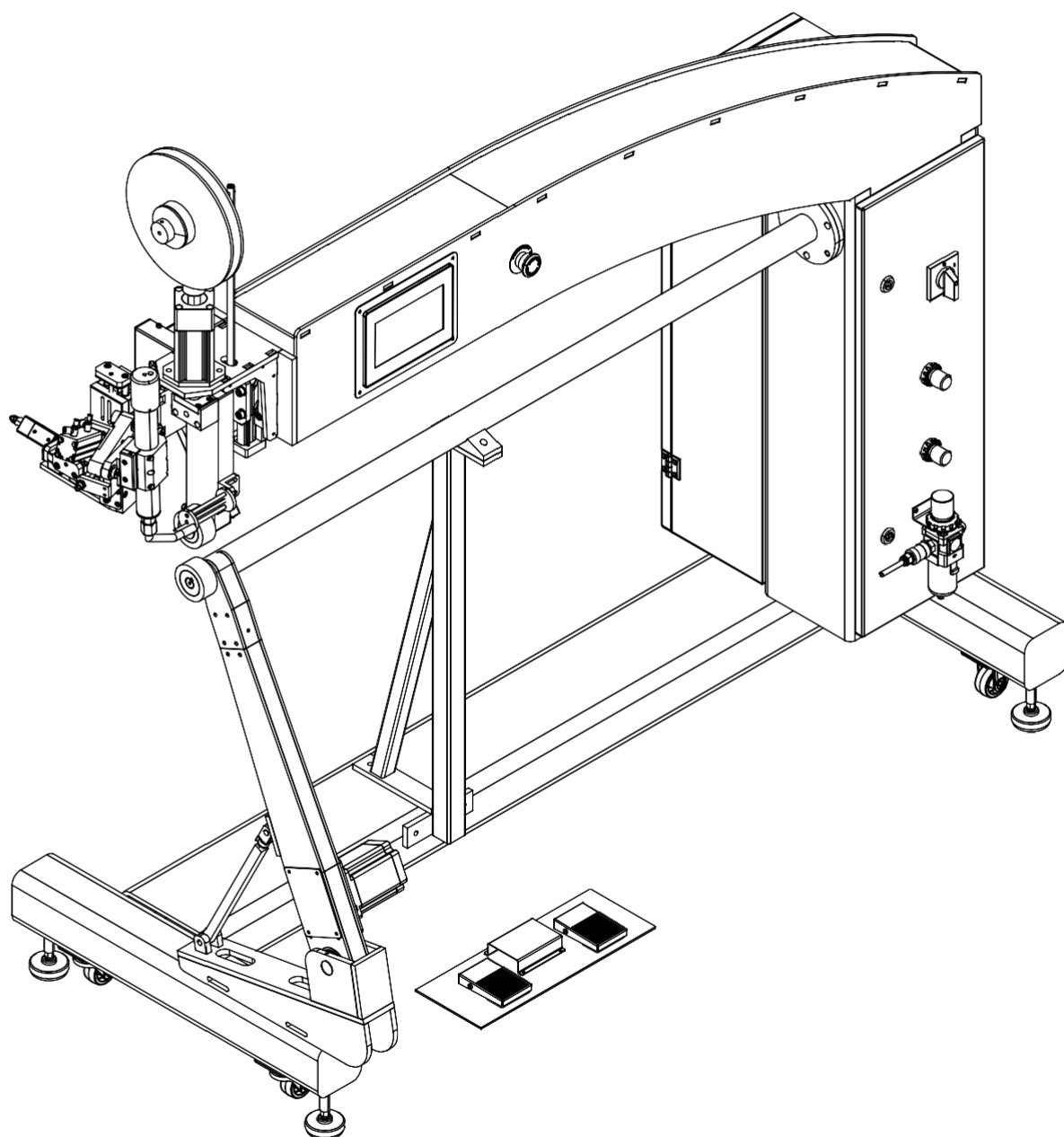


TORIA 8022 HOT AIR WELDING MACHINE



MOD:TORIA 8022



ATTESTATION

of product conformity

Certificate NO : 2024-PTC-5431

PTC Technical Inspection and Certification

ATTESTATION OF COMPLIANCE

(UYGUNLUK ONAYI)



By examining the technical files and test reports, it has been determined that the specified product complies with the 2006/42/EC Machinery Safety Regulation published by the European Union Technical Commission.

Teknik dosya ve test raporları incelenerek belirtilen ürünün Avrupa Birliği Teknik Komisyonu tarafından yayımlanan 2006/42/AT Makina Emniyeti Yönetmeliğine uygunluğu saptanmıştır.

Manufacturer (Üretici) : EPA TEKNOLOJİ VE OTOMASYON MAKİNALARI SAN.TİC.LTD.ŞTİ.

TEVFİKBEY MAH.ŞEHİT EROL OLÇOK CAD. NO.16 34295 SEFAKÖY KÜÇÜKÇEKMECE-İSTANBUL- TURKEY

Applicant (Başvuru Sahibi) : EPA TEKNOLOJİ VE OTOMASYON MAKİNALARI SAN.TİC.LTD.ŞTİ.

TEVFİKBEY MAH.ŞEHİT EROL OLÇOK CAD. NO.16 34295 SEFAKÖY KÜÇÜKÇEKMECE-İSTANBUL- TURKEY

Product (Ürün) : YAPIŞTIRMA VE ÜTÜLEME MAKİNESİ / GLUING AND IRONING MACHINE

Trademark (Marka) : EPA AKIN

Type / Model (Tip / Model) : EPA 200, EPA 201, EPA 202, EPA 203, EPA 203L, EPA 203XL, EPA 203 XXL, EPA 203 AP, EPA 204, EPA 205, EPA 206, EPA 207, EPA 209, EPA 210, EPA 252, EPA 305, EPA 306, EPA 307, EPA 308, EPA 401, EPA 402, EPA 403, EPA 404, EPA 405, EPA 406, EPA 152-00, EPA 152-01, EPA 152-02, EPA 152-03, EPA 152-03D, EPA 152-04, EPA ACE902, EPA 700, EPA 710, EPA 720, EPA 721, EPA 722, EPA 724, EPA 725, EPA 726, EPA 727, EPA 740, EPA 740/20, EPA 720/24, EPA 740/25, EPA 740/26, EPA 744, EPA 744/20, EPA 744/24, EPA 744/25, EPA 744/26, EPA 150, EPA 151, EPA 153, EPA 630, EPA 630T, EPA 631, EPA 1010, EPA 8000 SERIES

Base of Attestation (Onay Dayanağı) : TS EN 60204-1:2018; TS EN ISO 12100



www.ptc.com.tr

ID NO : 2612019

The certificate is issued after testing of the named product(s) and/or audit of the technical documentation and confirms that the tested product complies with the essential protection requirements of the mentioned directives on a voluntary basis.

Sertifika, belirtilen ürünün/ürünlerin test edilmesinden ve/veya teknik dokümantasyonun denetlenmesinden sonra verilir ve test edilen ürünün, belirtilen direktiflerin zorunlu koruma şartlarına gönüllü olarak uygun olduğunu onaylar.

The referred technical file(s) shows that the product complies with standard(s) recognized as giving presumption of compliance with the essential requirements listed EU Directive(s) above, other relevant Directives and standards have to be observed. This attestation does not abrogate the compulsory obligation of the manufacturer to issue the declaration of conformity.

Diğer ilgili standartlara ve direktiflere uyulmalıdır. Bu onay üreticinin uygunluk beyanı düzenleme zorunluluğunu ortadan kaldırmaz. Referans teknik dosya ile ürünün yukarıda belirtilen AT Direktiflerinin temel gereklerine uygunluğu kabul edilir.

Date / Tarih : 27/09/2024

Date of Issue / Basım Tarihi : 27/09/2024

Expiry to / -e Kadar Geçerli : 27/09/2025

PTC Ürün Test ve Belgelendirme San.Tic.Ltd.Şti



PTC

**Ürün Test ve Belgelendirme
San.Tic.Ltd.Şti**

Örnek Mah. Udi Hasanbey Sok. No: 31
Reis Plaza Ataşehir / İSTANBUL
Tel: +0(216) 393 32 32
info@ptctesting.com – www.ptctesting.com



TURKISH ACCREDITATION AGENCY

ACCREDITATION CERTIFICATE

As a Testing Laboratory

PTC ÜRÜN TEST VE BELGELENDİRME SANAYİ TİCARET LİMİTED ŞİRKETİ

Central Address: ÖRNEK MAH. UDİ HASANBEY SK. REİS PLAZA NO:31 A ATAŞEHİR İstanbul / Türkiye

is accredited in accordance with TS EN ISO/IEC 17025:2017 standard within the scope given in Annex following the assessment conducted by TURKAK.

Accreditation Number : AB-1374-T

Accreditation Date : 21.09.2018

Revision Date / Number : 07.04.2023 / 06

This certificate shall remain in force until **19.09.2026**, subject to continuing compliance with the standard **TS EN ISO/IEC 17025:2017**, related regulations and requirements.

Gülden Banu Müderrisoğlu
Secretary General



Turkish Accreditation Agency (TURKAK) is a signatory to the European co-operation for Accreditation (EA) Multilateral Agreement (MLA) and International Laboratory Accreditation Cooperation (ILAC) Mutual Recognition Agreement (MRA) in the scope of ISO/IEC 17025.

This document has been signed by Gülden Banu Müderrisoğlu on {t} with a secure electronic signature in accordance with the electronic signature law numbered 5070. Use the QR code to verify the e-signed document.



CERTIFICATE OF REGISTRATION

EPA TEKNOLOJİ VE OTOMASYON MAKİNALARI SAN. TİC. LTD. ŞTİ.

TEVFİKBEY MAH. ŞEHİT EROL OLCOK CD. EPA APT. NO:16/1 KÜÇÜKÇEMECE/İSTANBUL

Sertifika Numarası / Certificate No: QA/TR/9001/1677

Yukarıda adı geçen kuruluş, aşağıda belirtilen kapsamda bir yönetim sistemi yürürlüğe koymuş ve uygulamakla olup ilgili standarda uygunluğu ALBERK QA TEKNİK tarafından onaylanmıştır.
The above-mentioned organization has put into effect a management system within the scope specified below and its compliance with the relevant standard has been approved by ALBERK QA TECHNIC.

ISO 9001:2015

(KALİTE YÖNETİM SİSTEMLERİ)
(QUALITY MANAGEMENT SYSTEMS)

KONFEKSİYON VE TEKSTİL MAKİNALARI İMALATI, SATIŞI VE SERVİSİ
CLOTHING AND TEXTILE MACHINERY MANUFACTURING, SALES AND SERVICE

IAF KODU / IAF CODE: 18

Bu belge, firma ISO 9001:2015 standardının gerekliliklerini yerine getirdiği ve ALBERK QA TEKNİK'e karşı sorumluluğunu taşıdığı sürece geçerlidir.
This certificate is valid as long as the company fulfills the requirements of the ISO 9001:2015 standard and bears its responsibility towards ALBERK QA TECHNIC.

Sertifika Düzenleme Tarihi : 03.10.2024
Certificate Issue Date : 03.10.2024
Sertifika İlk Yayın Tarihi : 03.10.2024
Certification First Issue Date : 03.10.2024

Sertifika Geçerlilik Tarihi : 02.10.2025
Certificate Validity Date : 02.10.2025
Sertifikasyon Periyodu / Bitiş Tarihi : 3 Yıl / 02.10.2027
Certification cycle / End Date : 3 Years 02.10.2027

Sertifika Revizyon Numarası ve Tarihi : 00/03.10.2024
Certificate Revision Number and Date : 00/03.10.2024

Genel Müdür
Latif Murat YILMAZ

ALBERK QA ULUSLARARASI TEKNİK
KONTROL VE BELGELENDİRME A.Ş.
Küçükbakkalköy Mahallesi Kayışdağı
Caddesi No: 13 İç Kapı No: 1
Ataşehir / İstanbul / TÜRKİYE
Tel : 0216 572 49 10-11-12
Fax : 0216 572 49 14
www.qatechnc.com

FR-200-2, Rev.01, 01.05.2024



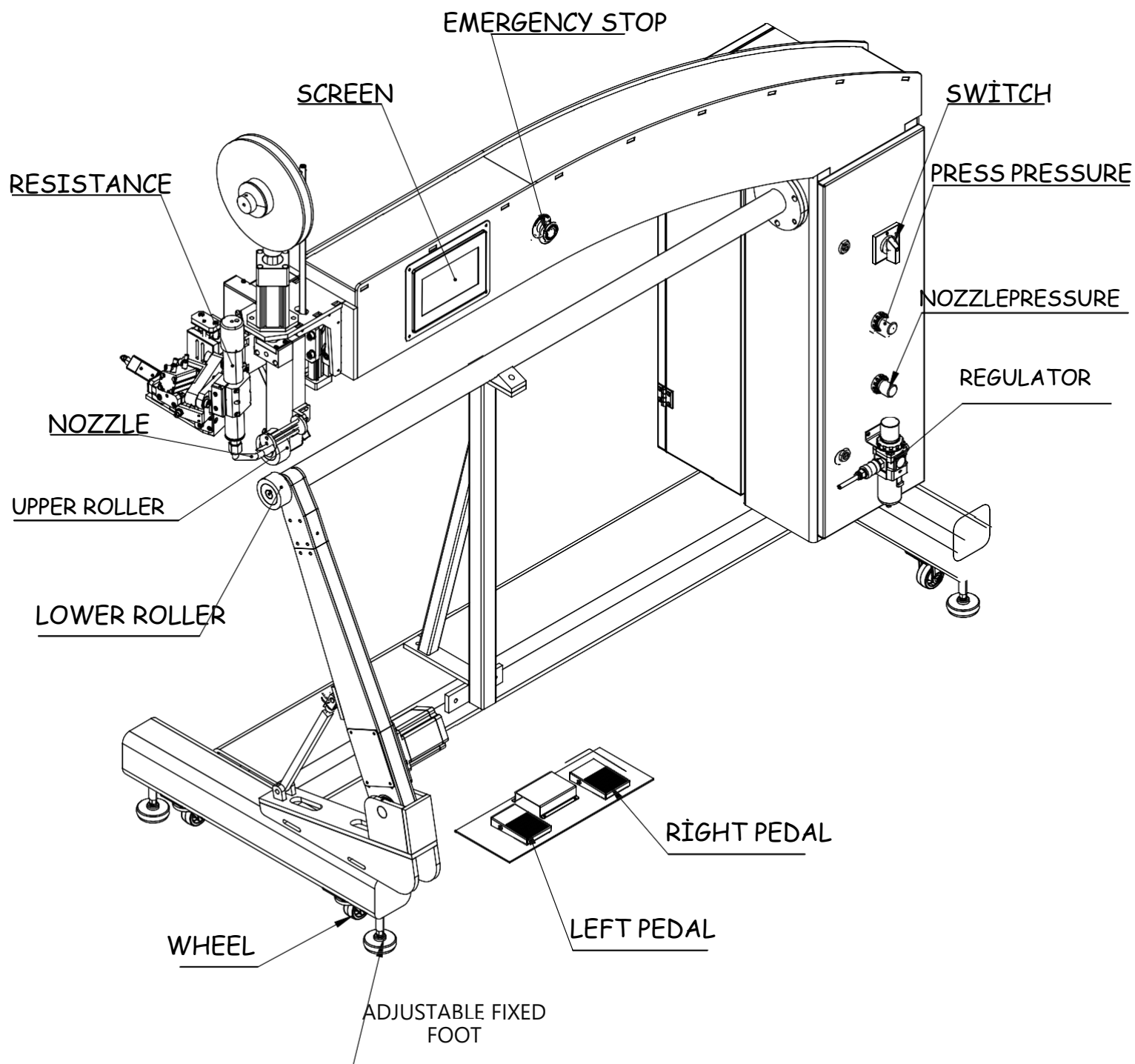
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MAKİNA ETİKETİNDEKİ BİLGİLER

Machine name	HOT AIR WELDING MACHINE
Type	TORIA 8022
Serial number	
Production date	
Voltage	220 V-50Hz
Power	4,1 KW
Weight	320 KG
Operating Pressure	2-6 Bar

1.MACHINE CONTROLS



MACHINE CONTROLS

LEFT PEDAL: Enables the rotation of rollers during operation. It ensures the rotation of rollers (located where the bottom, top, and step motor are) during operation.

RIGHT PEDAL: Provides manual movement of the top roller.

REGULATOR: Adjusts the air pressure. Used to decrease or increase the air pressure according to the operating pressure of the machine.

02- GENERAL FEATURES

A- CHARACTERISTICS AND APPLICATION AREAS

- The Toria hot air welding machine provides excellent results in waterproof bonding applications, especially in PVC and similar fabrics.
- For demanding applications in air and waterproof bonding. Three different attachments, independently adjustable: Circular closure, Side closure, Strip attachment.
- Adjustable multi-program structure through the touchscreen interface, allowing the creation of 10 different recipes where speed, heat, and time parameters can be adjusted differently.
- Automatic adjustment of bottom/top differentials independently. Adjustable belt slots.
- High-tech resistance capable of rapid reaction and adjustable up to 550°C. Lossless and precise temperature measurement obtained by measuring the heat from the air outlet.
- Equipped with a high-tech alarm and notification system.
- Pressure level visible digitally on the screen, adaptable to products through precise pressure adjustment.
- Three-axis adjustable hot air nozzle. Interchangeable pressure roller and nozzle tip, adjustable from 25-80mm.
- Machine is PLC controlled.

03- SAFETY PRECAUTIONS



Wherever this symbol is observed, it should be understood that the danger is

emphasized for the user's health. Therefore, maximum sensitivity is required when approaching these points. If you need to open the control panel containing electrical parts, always ensure to cut the power first.

Before using the machine, always read the user manual and other explanatory documents provided with the machine's accessories. Keep the user manual and explanatory documents stored as a readily accessible reference.

To prevent damage or injuries, never use the machine for any purpose other than its intended use.

EPA does not accept any responsibility for damage, injury, or death resulting from the use of the machine for a purpose other than its intended use.

To prevent accidents that could cause injury or death, do not make any modifications to the machine. EPA does not accept any responsibility for damage, injury, or death resulting from modifications made to the machine.

A- Training

Operators who will use the machine safely must receive adequate training. The company representative should prepare a training plan for operators.

B- Situations Requiring Power Shutdown of the Machine

Always shut down the power in case of abnormal conditions, malfunctions, or power outages to prevent accidents that could lead to death or injury.

Shut down the power when replacing or adjusting all parts of the machine.

Always shut down the power during inspection, repair, maintenance, or when leaving the machine unattended.

When unplugging, always hold the plug part, not the cable, to prevent electric shock, grounding faults, or fire.

C- Safety Precautions to be Taken During Various Stages of Work

When lifting and relocating the machine, ensure safety by considering the weight of the machine. Refer to the information on the MACHINE LABEL section for the weight of the machine.

Before lifting and relocating the machine, take necessary safety precautions against falls or Overturns to prevent injuries or fatalities.

Before powering on, check that connectors and cables are undamaged, and ensure there are no Loose or disconnected cables to prevent accidents that could cause injury or death.

Do not touch any moving parts of the machine.

Always use genuine EPA parts when replacing any part of the machine.

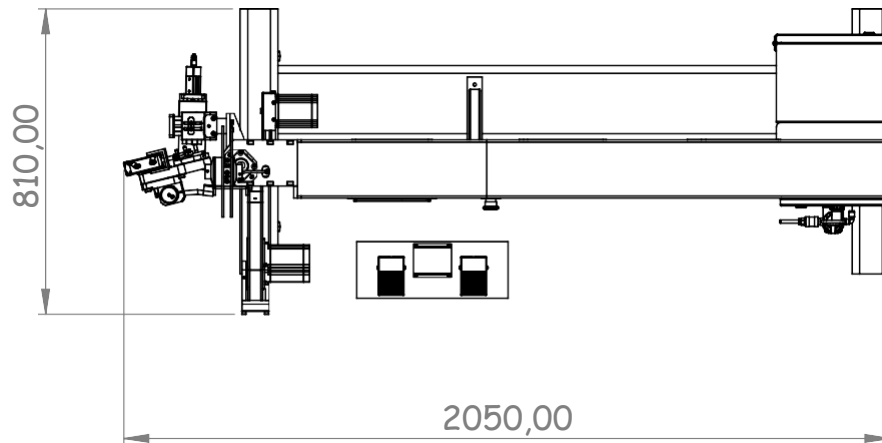
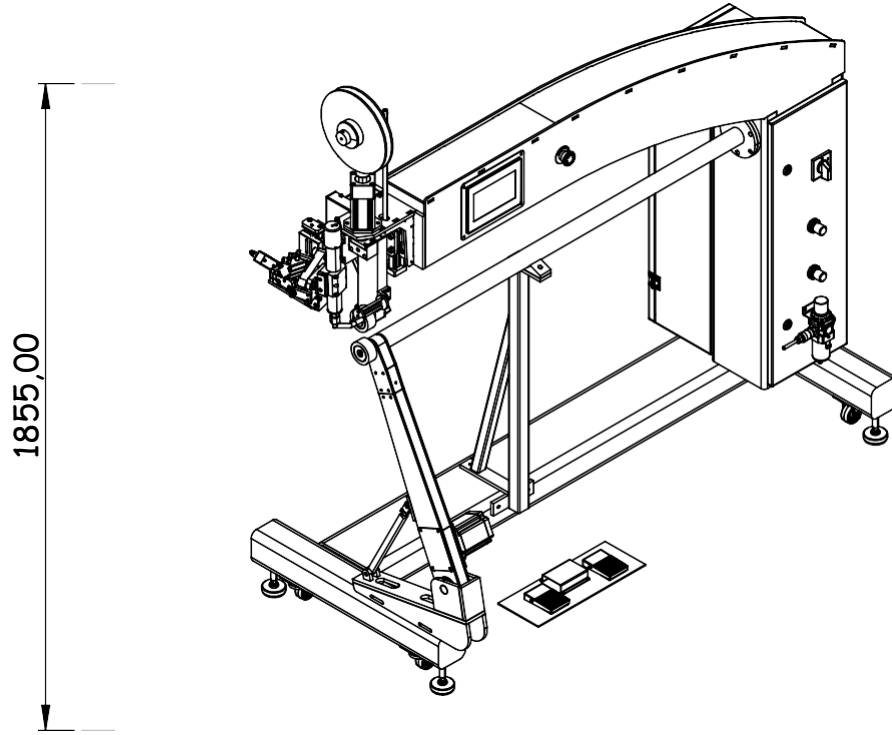
EPA is not responsible for accidents resulting from the use of non-original parts.

Before starting maintenance, part replacement, or adjustment tasks, disconnect the machine from the main power source and compressed air sources, and allow ironing parts to cool down.

After repair, adjustment, or replacement procedures, always check for loose bolts or nuts. Regularly clean the machine.

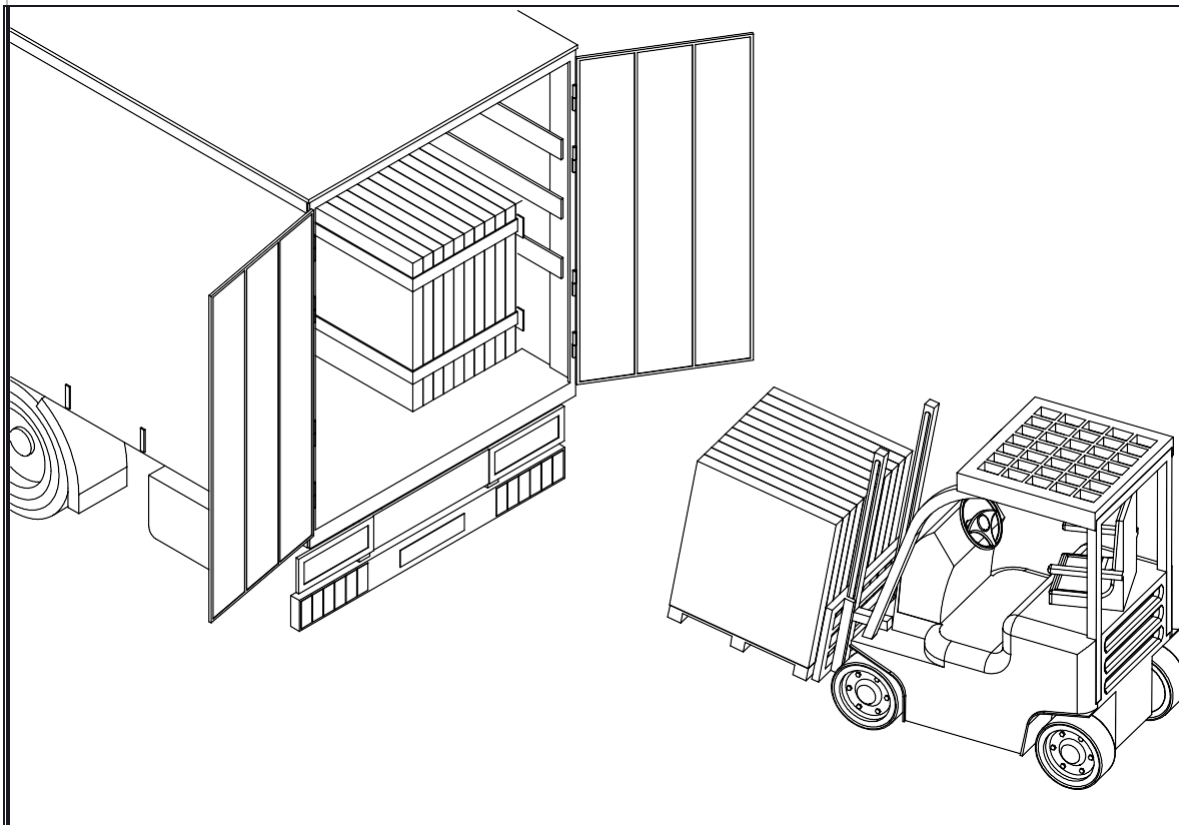
If the machine does not operate normally after repair or maintenance, immediately stop the machine to prevent injuries or fatal accidents and contact EPA technical service.

4-TORIA 8022 TEKNİK BİLGİLER



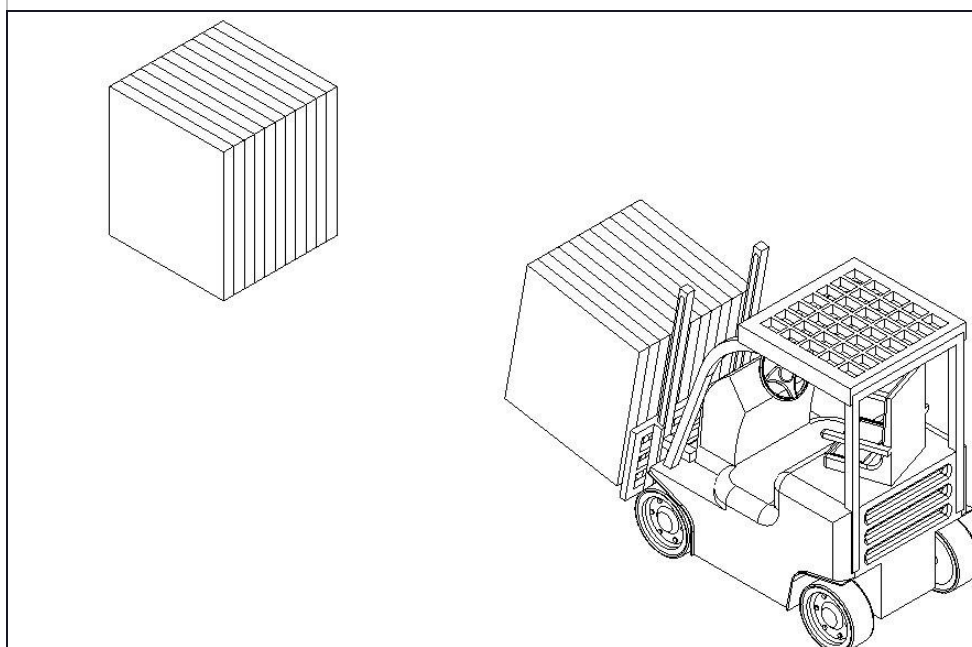
05-LIFTING AND TRANSPORT

The Toria 8022 can be transported packaged or unpackaged. In both cases, the lifting forks should be adjusted according to the full weight of the machine. When moving the machine, the front face should be facing the lifting forks. The machine should be placed onto the truck with the lifting forks and securely fastened.



06- LOADING AND UNLOADING

Ensure that the forklift forks are adjusted to the full weight of the machine while the forklift is in motion. Remove the packaging of the machine and position the front face towards the forklift. Lift the machine by passing the lifting forks underneath. After placing it onto a solid and flat surface that has not been exposed to any weather conditions, proceed with movement.



07-PLACEMENT AND INSTALLATION

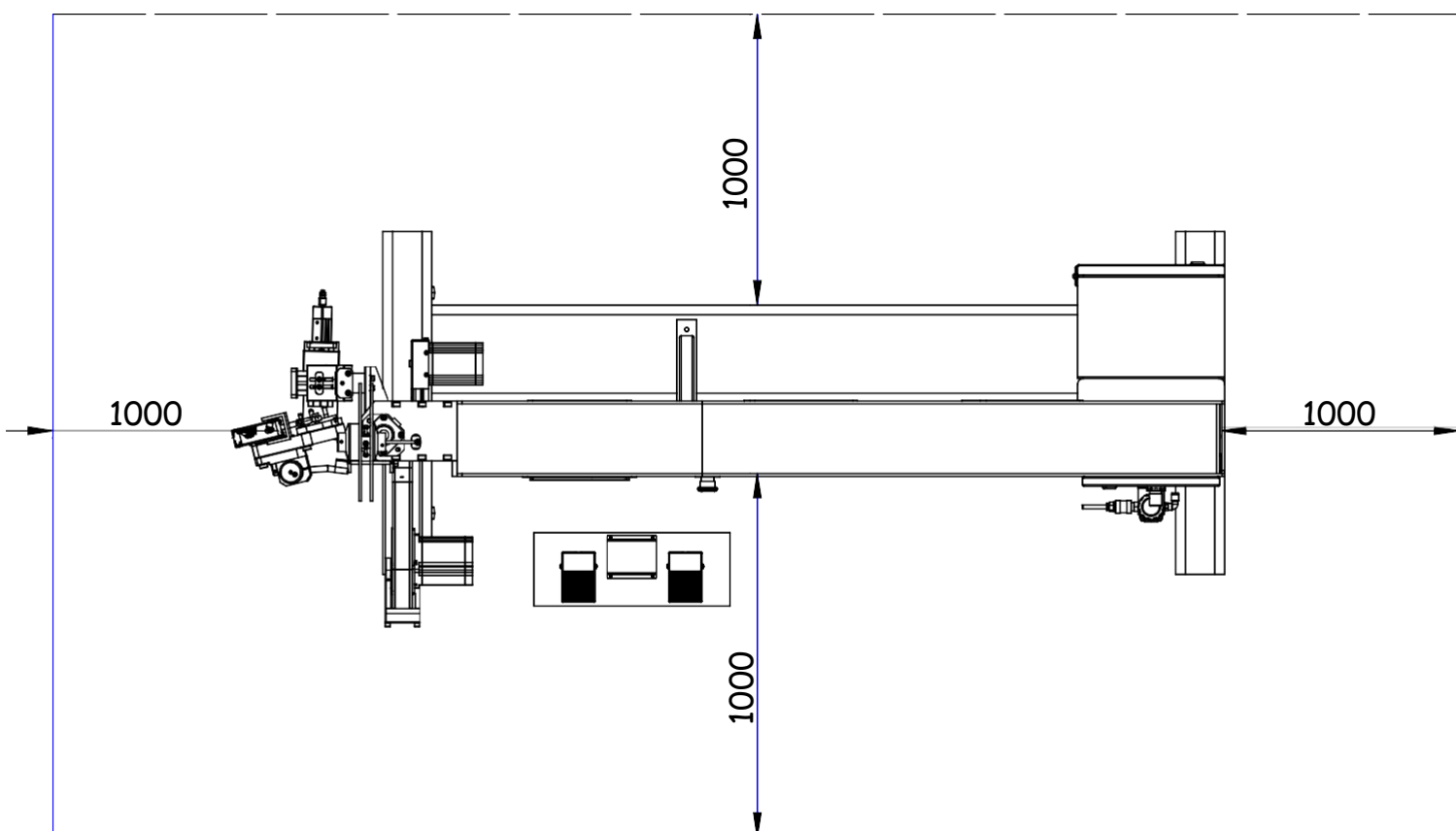
CAUTION: This machine should be installed by qualified personnel.

The manufacturer cannot be held responsible for problems and malfunctions arising from incorrect installation and insufficient connections to the main power sources.

The machine should be installed on a stable surface, please ensure that the surface can support the weight of the machine.

The machine should never be installed in areas where flammable/explosive/inflammable substances are present.

Check that the necessary clearance for the operation and maintenance of the machine is provided during installation.



Place your machine on a flat and sturdy surface. Adjust the feet as shown in Figure 1

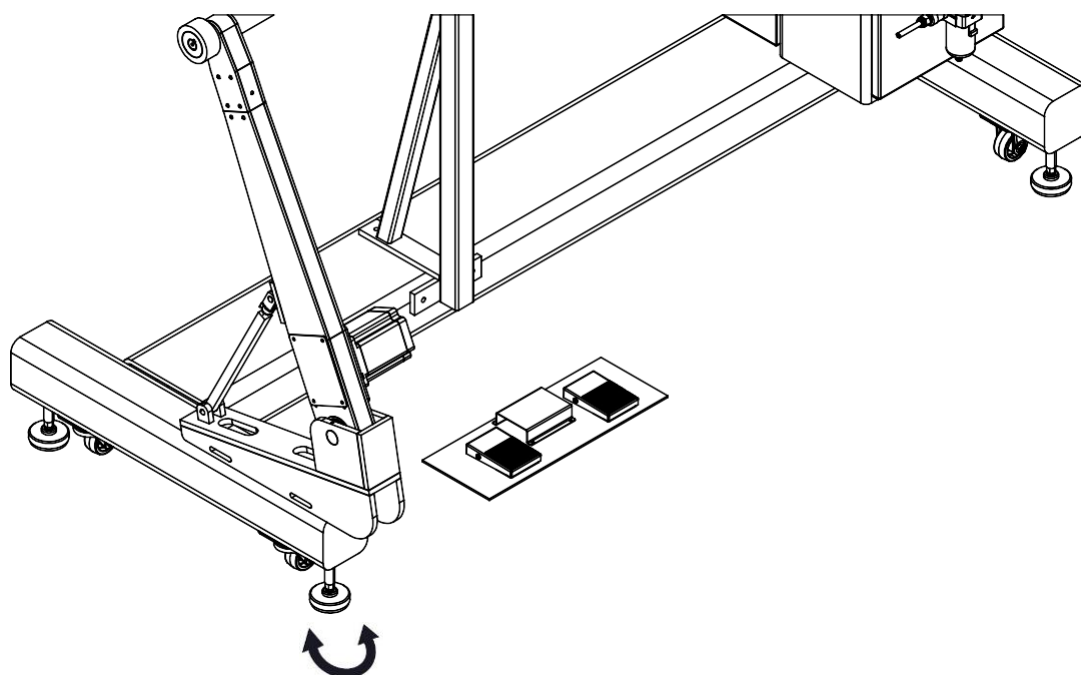
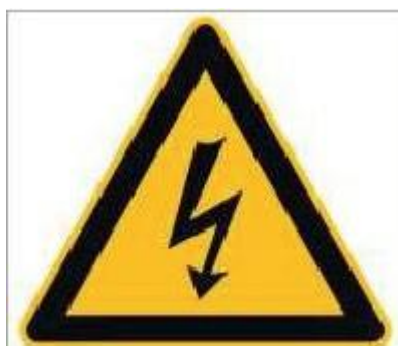


FIGURE 1

08- ELECTRICAL CONNECTION

The product is started by connecting it to a power source. Supply 220V power to the machine.



CAUTION!:

Electrical shock hazard.

This point requires special attention.

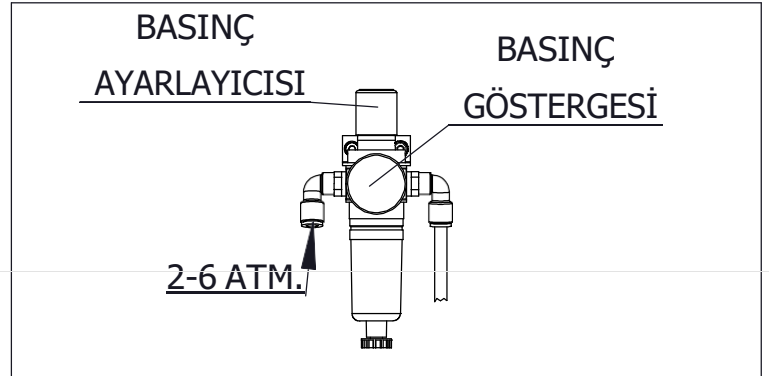
09- PNEUMATIC CONNECTION

Connect the machine to the compressed air outlet and ensure that

the air flow is at a suitable level for the machine to operate, with a pressure of

2- Atm. Adjust the pressure regulator

to a range of 2- Atm



10- OPERATING THE MACHINE

Ensure that the regulator shows 2-6 Atm. on the gauge (M). Check if air is coming out from the nozzle outlet. If necessary, adjust the air pressure using the regulator.

Supply 220V power to the machine.

Turn the main power switch (C) to the I position.

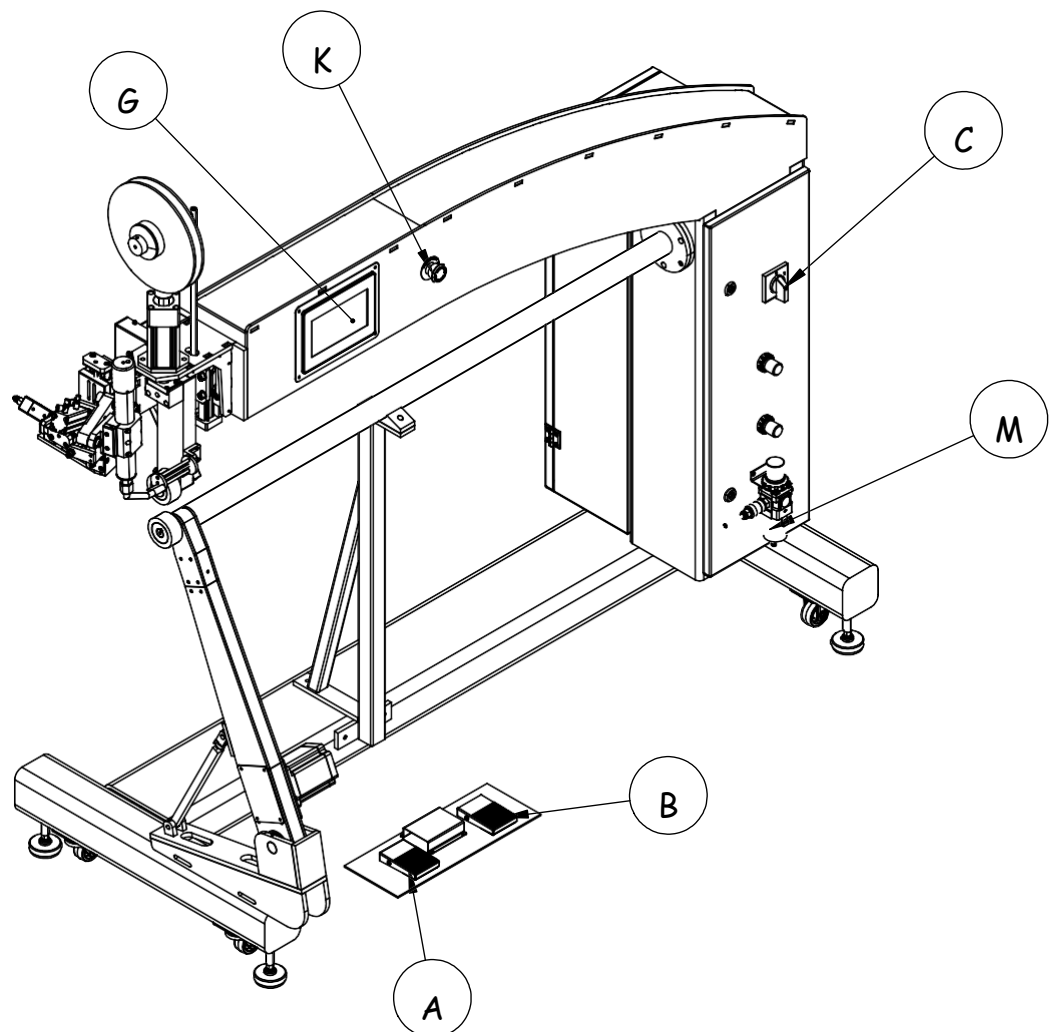
Set the machine parameters as shown in Section 11.

Enter the required heat from the screen (G).

Ensure that the emergency stop button (K) is open.

The left pedal (A) allows the rollers to rotate during operation.

The right pedal (B) enables manual movement of the upper platen.



11- MACHINE PARAMETERS

A- SCREEN PARAMETERS

1. Pressure

- **Press:** Indicates the press pressure.
- **Nozzle:** Indicates the nozzle pressure.
- **Nozzle Button:** Activates the nozzle.
- **Press Button:** Manually operates the press.
- **Press Standby Position Button:** Sets the position of The upper platen after completion of work.



2. Heat Settings

- **Desired Heat:** Input the required temperature for bonding.
- **Heat On/Off Button:** Turns the heat on and off.
- **Actual Heat:** Monitors the current temperature.

3. Backstroke

Adjusts the distance of backstroke when the foot is lifted from the pedal.

4. Motor Delay

- Sets when the wheels will start turning after the nozzle has been lowered

9. Speed Settings

Adjusts the speeds of the wheels separately.

10. P Symbol

Parks the machine in the park position." 17

12- MAINTENANCE

BEFORE STARTING MAINTENANCE PROCEDURES SUCH AS PART REPLACEMENT OR ADJUSTMENT, DISCONNECT THE MACHINE FROM THE MAIN POWER AND COMPRESSED AIR SOURCES, AND WAIT FOR THE IRONING PARTS TO COOL DOWN.

THE PROCEDURES DESCRIBED BELOW SHOULD ONLY BE PERFORMED BY TRAINED PERSONNEL. DUE TO ITS DESIGN, TORIA 8001 DOES NOT REQUIRE SPECIAL MAINTENANCE DURING NORMAL USE.

13- FAULTS, CAUSES, AND SOLUTIONS

1. If the nozzle pressure is low:

- The air supply to the machine may be insufficient.
- The nozzle regulator may not be sufficiently open.

To prevent such issues, the machine should be started after the air pressures are adjusted.

2. If the roller pressure is low:

- The air supply to the machine may be insufficient.
- The nozzle regulator may not be sufficiently open.

To prevent such issues, the machine should be started after the air pressures are adjusted.

3. If the heater is not heating up:

- There may be an issue with the resistor.

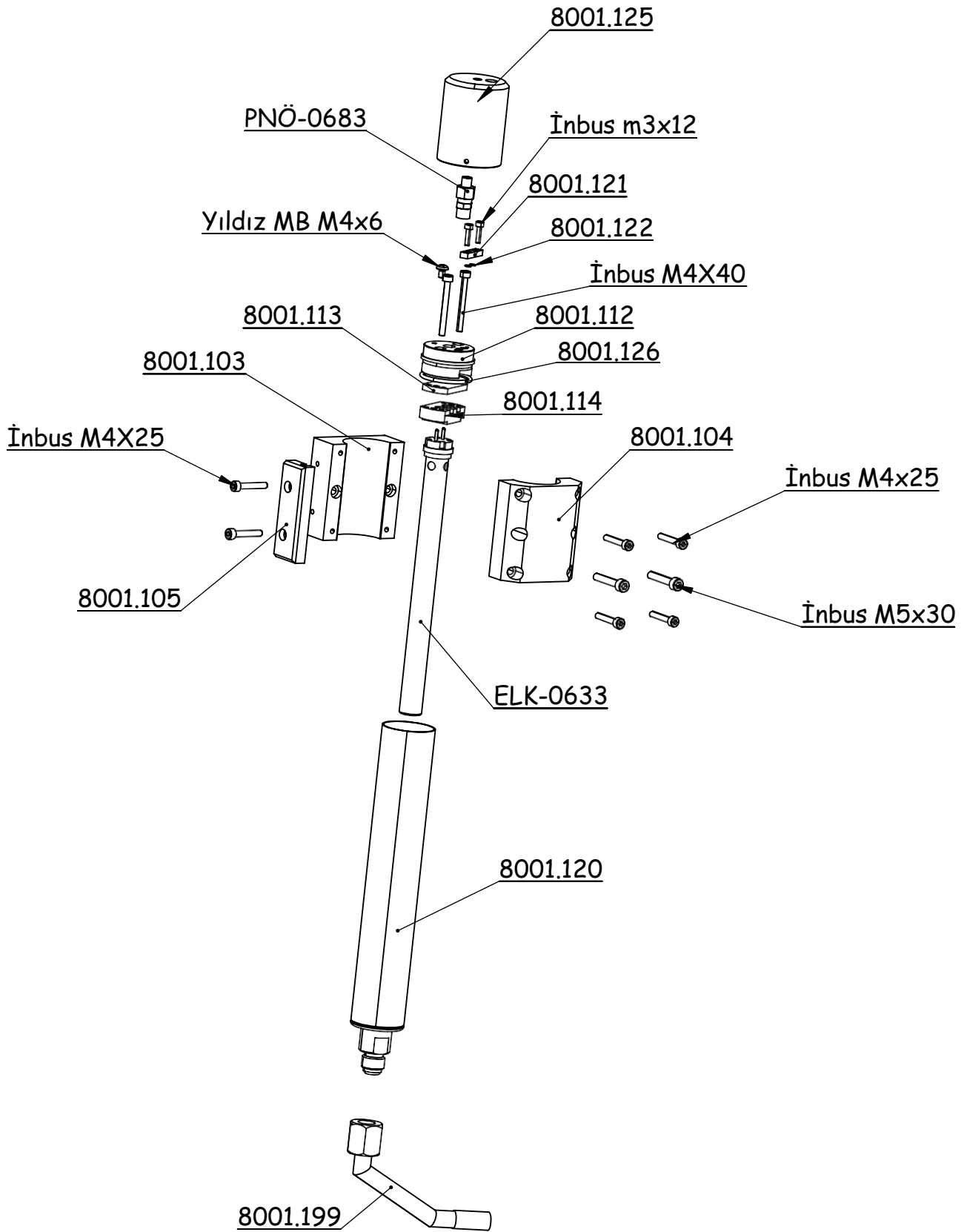
In case of such a problem, it is necessary to contact an authorized EPA service.

14- SPARE PARTS TABLE

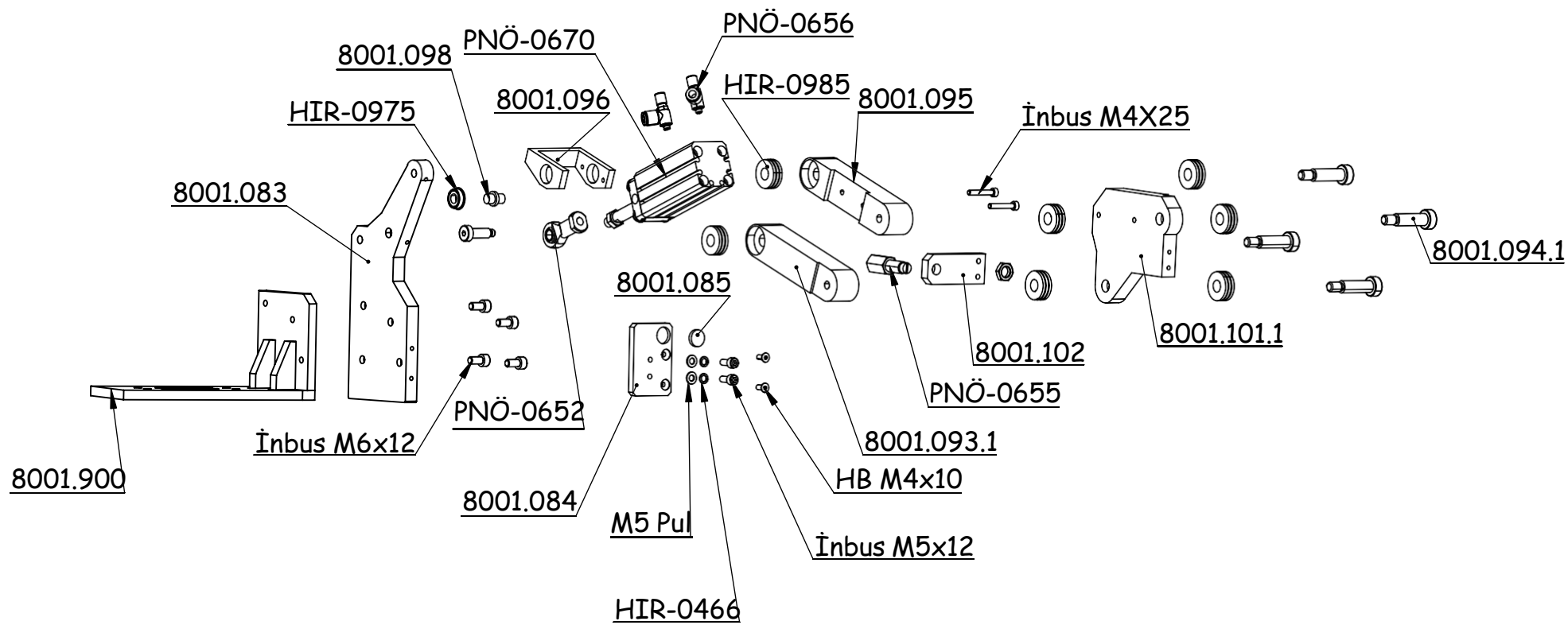
To quickly locate the required spare part, please provide us with the following information:

Machine model and serial number Spare part code Corresponding spare parts table

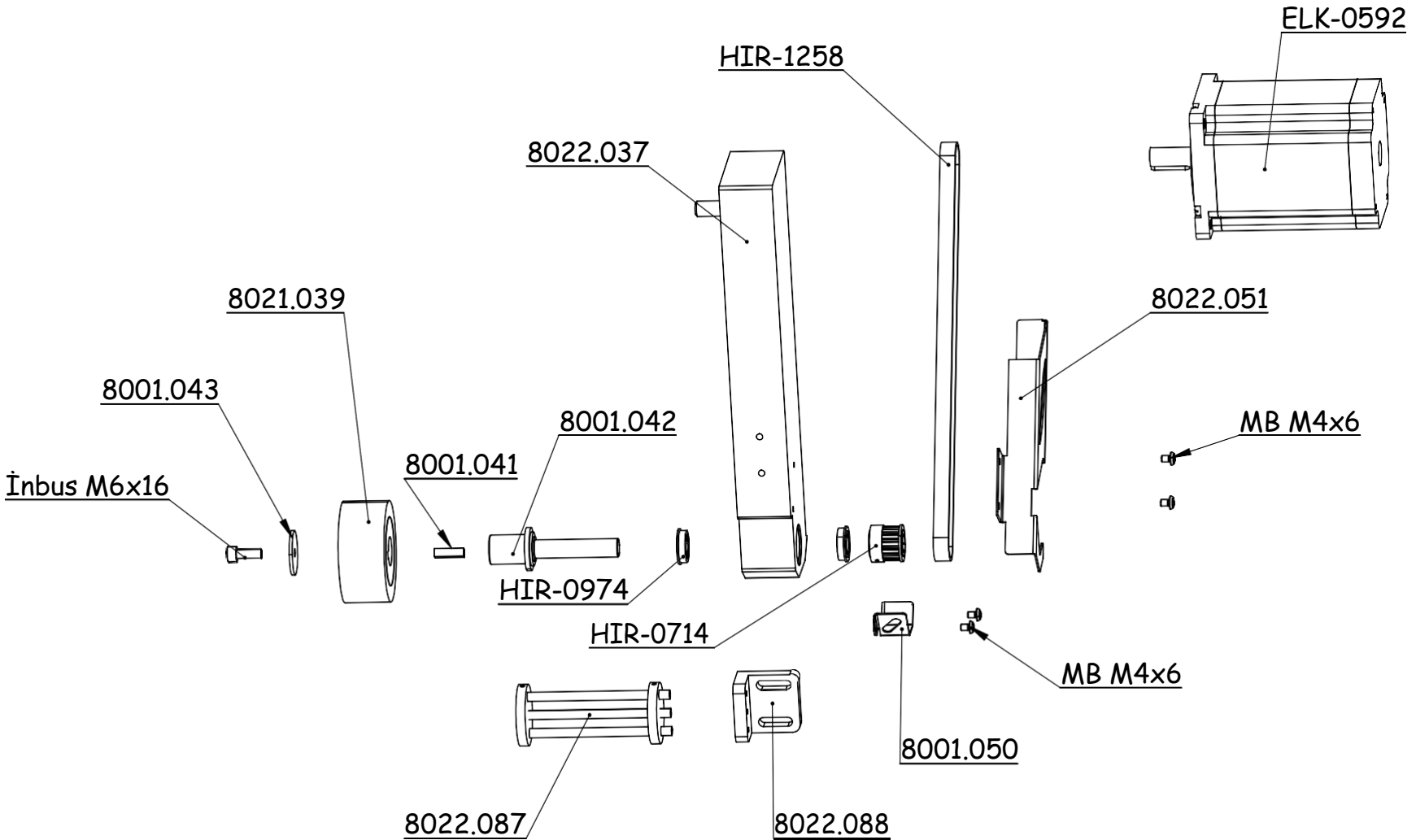
Example: Hot air tape sealing machine Model Toria 8022 Serial no Code 'part"



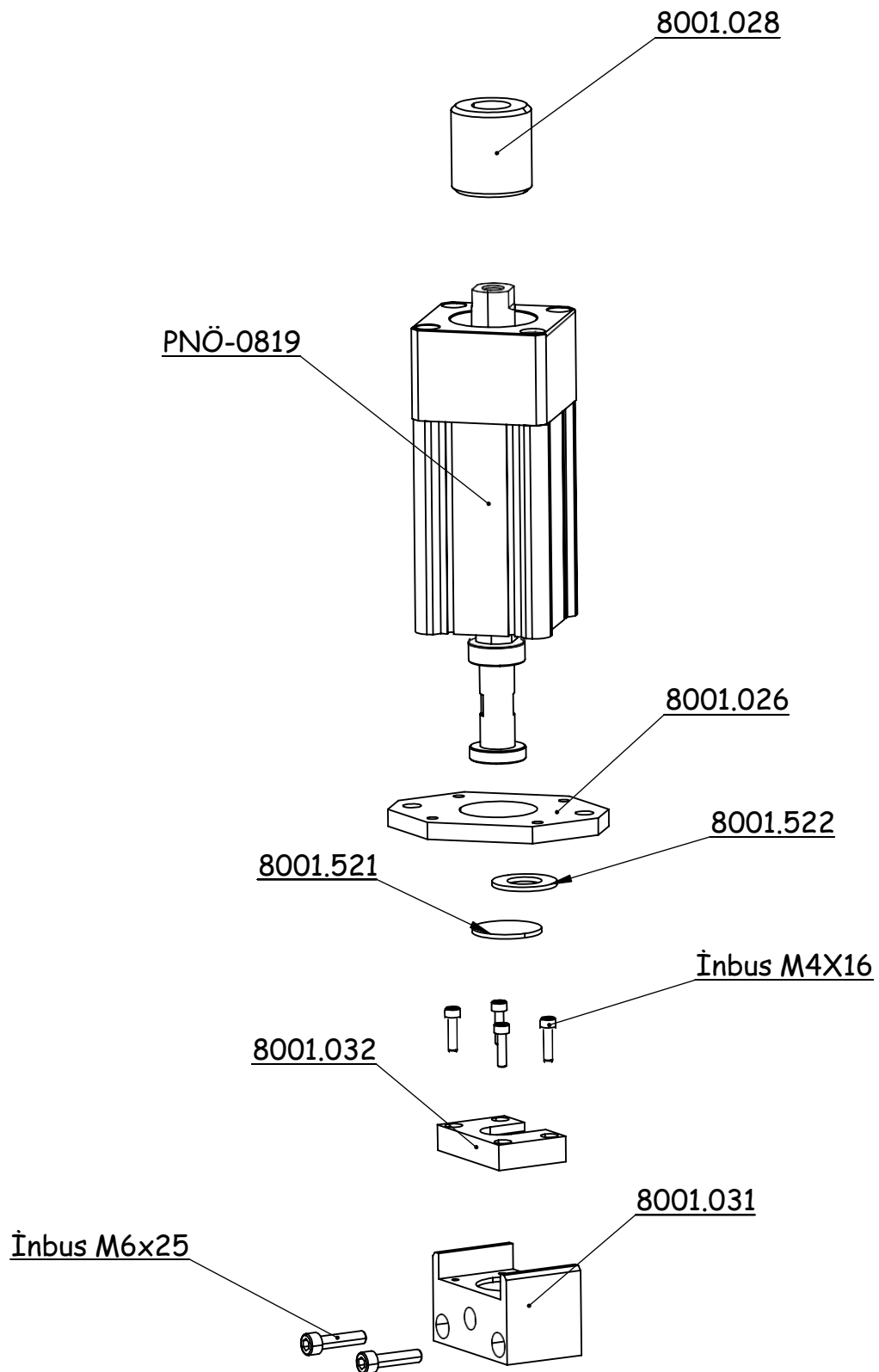
TORIA 8022
CHART:1



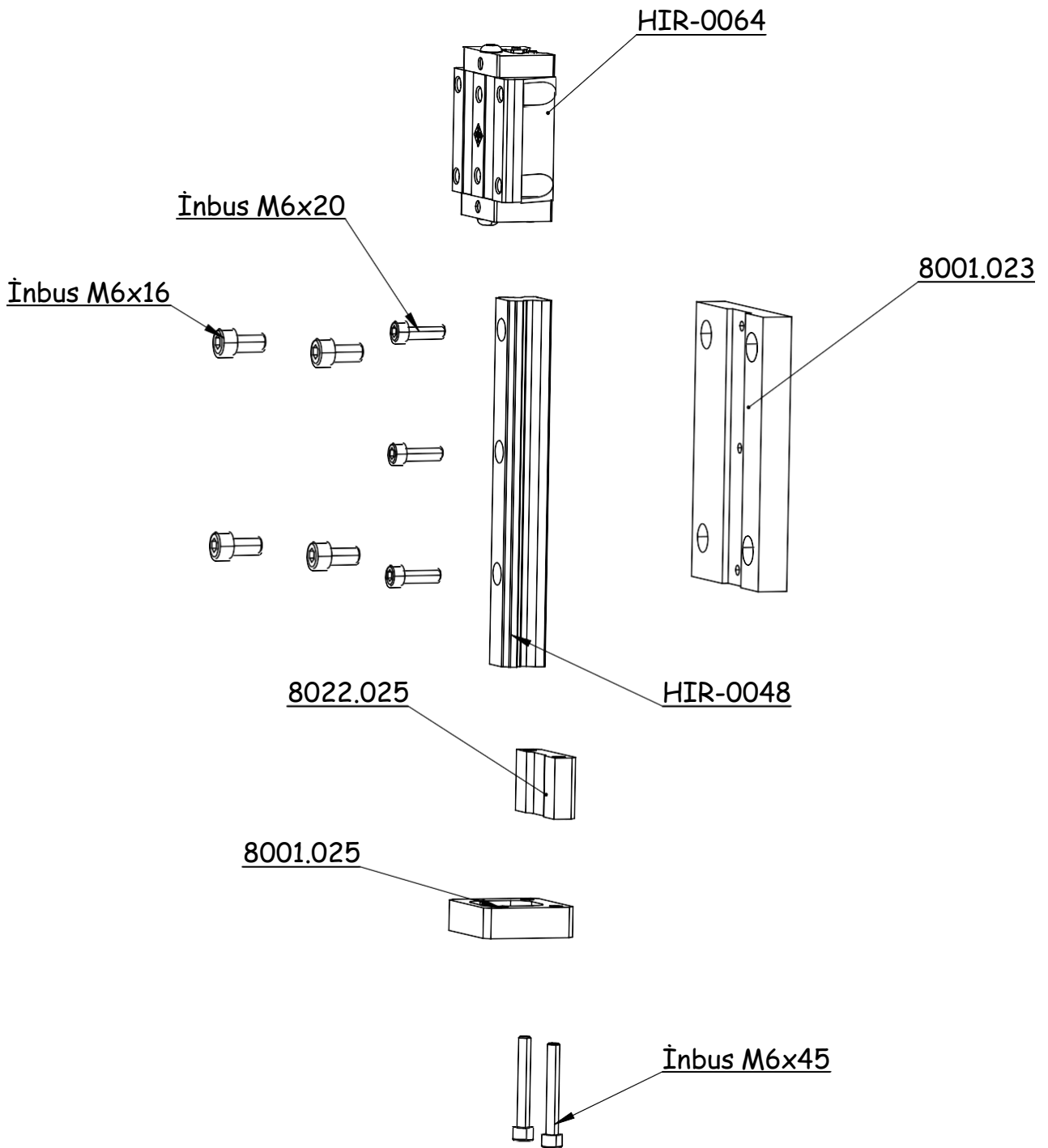
TORIA 8022
CHART:2



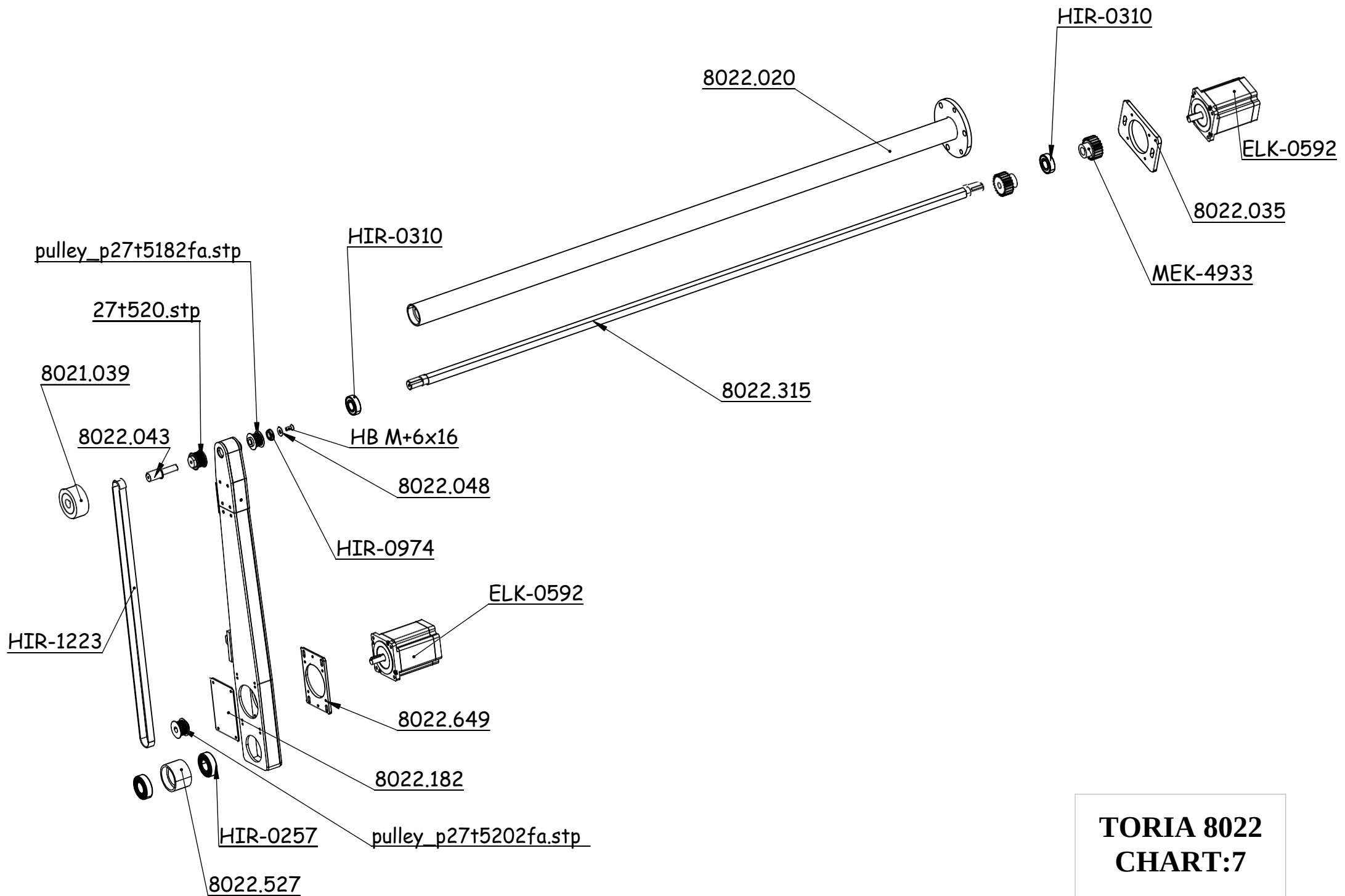
**TORIA 8022
CHART:4**



TORIA 8022
CHART:5

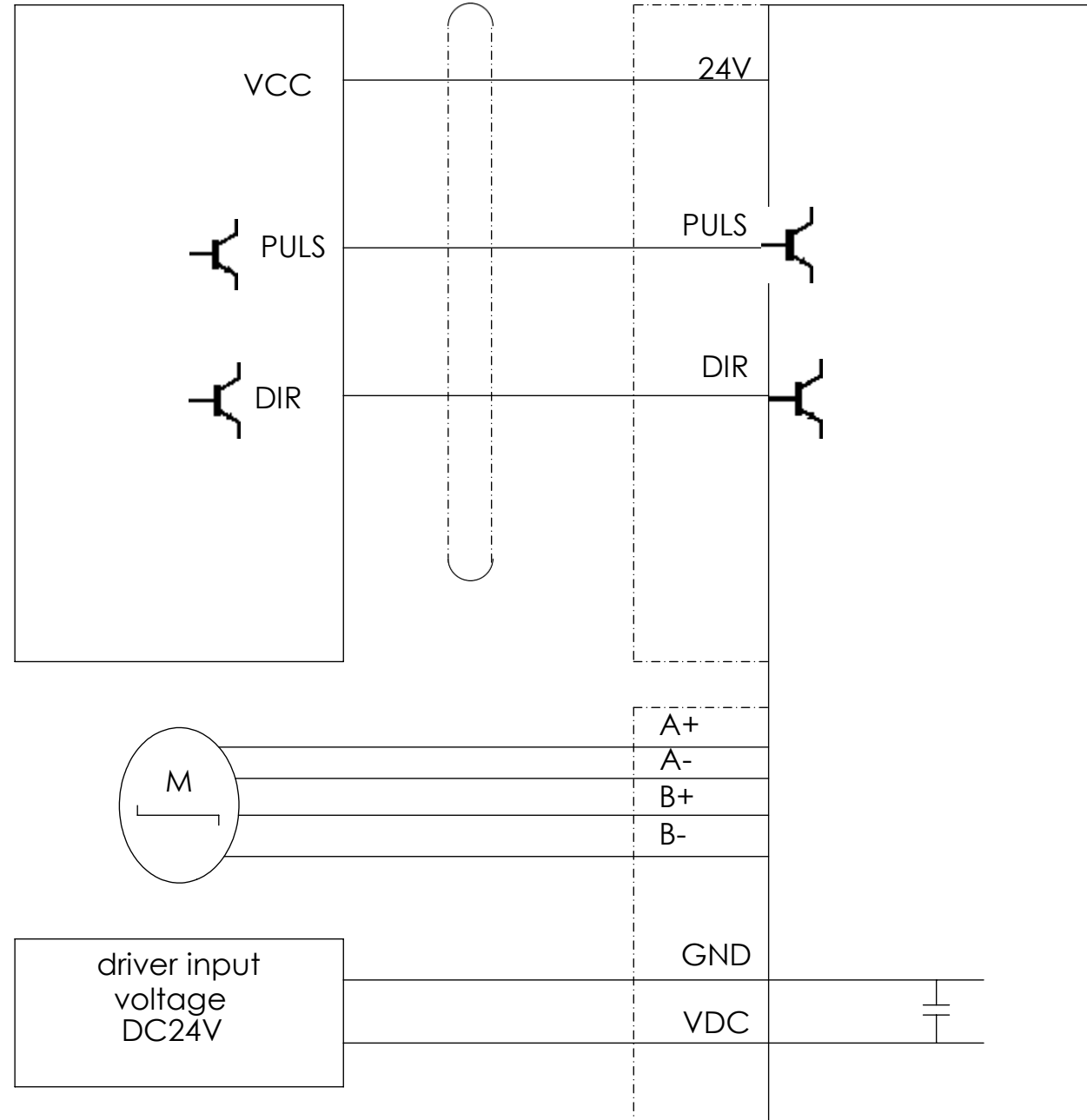


TORIA 8022
CHART:6



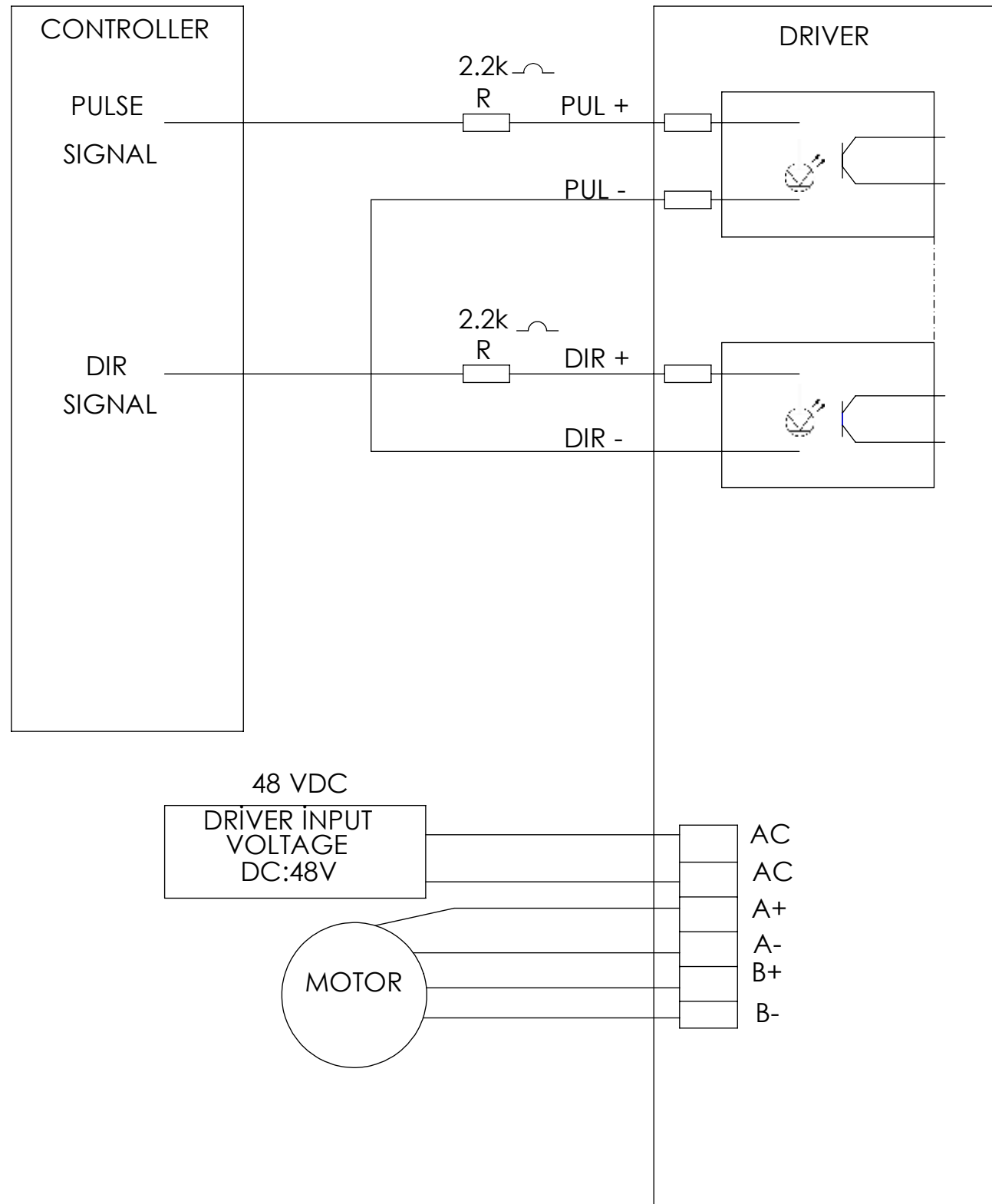
**TORIA 8022
CHART:7**

JK0220 MICROSTEP DRIVER



GND:VDC+	it input DC power
A+.A-	stepping motor one winding
B+.B-	stepping motor other winding
PUL	stepping pulse input
DIR	stepping motor direction input
VCC	power supply port for inside optical coupling
EN	motor free

ÇİZEN	EDA ÖZTÜRK HASANOĞLU	TARİH	22.10.2020	
KONTROL		PARÇA NO		
ONAY		ÖLÇEK		



SKD2060H

CONTROL SIGNAL CONNECTOR

NAME	Description
DIR-	direction signal negative
DIR+	direction signal positive
PUL-	pulse signal negative
PUL+	pulse signal positive
ENA-	Enable signal negative,usually left unconnected(enable)
ENA+	Enable signal positive,usually left unconnected(enable)

ÇİZEN	EDA ÖZTÜRK HASANOĞLU	TARİH	22.10.2020	
KONTROL		PARÇA NO		
ONAY		ÖLÇEK		