



**IRONING PRESSING MACHINERIES - FUSING PRESSES**

**Instruction Manual**  
***FLEX DOB***



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## **1. ATTENTION!!!**

*Please read this instruction manual very carefully before you start using your Ironing Table.*

*The customer by purchasing this product declares that he is fully aware, and accepts everything mentioned in this operating manual.*

*Primula SA assumes neither responsibility for any errors herein, nor for incidental nor for resulting damage in connection with the performance or use of this operating manual.*

*You may not copy, reproduce, or translate this operating manual, or parts of it, to another language without prior written consent of Primula SA.*

*Any information in this manual may be subject to change without any prior notice.*

**CAUTION! PLEASE READ CAREFULLY THE INSTRUCTION MANUAL BEFORE INSTALLING THE STEAM GENERATOR!!!**

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## 2. Technical Details

### 2.1 Identification Data

The Ironing Table "FLEX DOB" is a machine of high advanced technology with many advantages, unique in its kind. It is manufactured according to International and European safety standards by a company with experience, since 1969, in this sector. Congratulations for your choice!

Regarding its characteristics, the Ironing table includes a serial number plate (see below) where all its specifications are displayed. Every warning and symbol that is placed on the Ironing Table is in accordance with the specifications of the European standards.

The serial number plate has been placed in a visible place on the Ironing table and has made from fadeless material.

Amongst others, the Serial Number plate displays the following:

- Company Logo
- Manufacturer Information
- Model
- Serial Number
- Rated Voltage of Use
- Rated Frequency of Use
- Year of manufacturing
- Accumulated Installed Wattage

			
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		Made in EUROPE	
Model	FLEX DOB	Year	
Serial No		Power	KW
Frequency	Hz	Voltage	V

**Picture 1:** Serial Number Sign

### 2.2 Use of the instruction Manual

The correct assembly and adjustment of the machine is vital to the safety of the user and the machine's life span. For this reason, the installation, alteration, replacement or extension of the machine should only be performed by qualified personnel.

Under no circumstances is interventions allowed in the machine, unless it's for the planned maintenance by an unauthorized engineer.

If you remain uncertain regarding the correct assembly of the machine after reading the instructions, contact the manufacturer or an authorized representative before starting the operation of the machine.

## 2.3 Technical Description

*Ironing Table with Heating, adjustable suction and blowing through a lever.*

*For ironing readymade garments. Suitable for garment industries, workshops and ateliers.*

*Available in 3 models:*

*FLEX DOB1242 with suction.*

*FLEX DOB1242 S+B with automatic suction/blowing adjustment through two pedals.*

*FLEX DOB1242 M S+B blowing with manual suction/blowing adjustment through a lever.*

## 2.4 Technical Characteristics

<b>Model</b>	<b>FLEX DOB</b>	<b>FLEX DOB S+B</b>	<b>FLEX DOB M S+B</b>
<b>Working surface</b>	120X42cm(standard)	120X42cm(standard)	120X42cm(standard)
<b>Height adjustment</b>	75-91cm with screws	75-91cm with screws	75-91cm with screws
<b>Heating</b>	1KW	1KW	1KW
<b>Suction</b>	Adjustable	Automatic	Manual
<b>Blowing</b>	<b>NO</b>	<b>YES</b>	<b>YES</b>
<b>Motor Power</b>	0.75HP	0.75HP	0.75HP
<b>Power supply</b>	230V-1ph-50Hz or 400V-3ph-50Hz	230V-1ph-50Hz or 400V-3ph-50Hz	230V-1ph-50Hz or 400V-3ph-50Hz

## 3 General rules and Warnings

### 3.4 General rules of using the Ironing Table

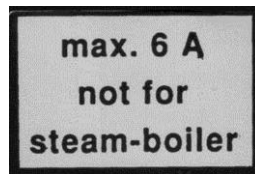
*For the safe usage of your Ironing Table, please read the following operating instructions carefully, as listed below:*

- *Install, use and maintain the Ironing Table according to the instructions in this manual. Otherwise, the manufacturer has no responsibility for the possible failed operation or safety.*
- *Before connecting the power supply, check that the voltage corresponds to the voltage indicated on the technical specifications.*
- *Connect the machine only to a power supply that meets the minimum required frequency and is properly grounded. Do not leave the Ironing Table while it is operating and is on power without supervision.*
- *Use the Ironing Table ONLY for the intended purpose in accordance with the current instruction manual and only with the accessories that are provided or that are intended for this specific Ironing Table. The manufacturer is not liable for any damages resulting from misuse or wrong use of the Ironing Table.*
- *DO NOT touch the power supply with wet hands.*
- *Do not clean the Ironing Table with corrosive or other damaging materials/chemicals.*
- *Never use the Ironing Table to support any other machine or structure.*
- ***It is strictly prohibited to do any kind of welding or alterations on the Ironing Table or its parts.***
- ***It is strictly prohibited to remove any protective device/guards.***
- ***It is strictly prohibited to intervene in the control units/circuit boards of the Ironing Table.***

- **It is strictly forbidden to do any modification to the technical specifications of the machine (electrical or mechanical) by third persons.**
- Please contact your dealer or the manufacturer for any malfunction or further information requests.

### 3.2 Warning marks placed on the Ironing Table

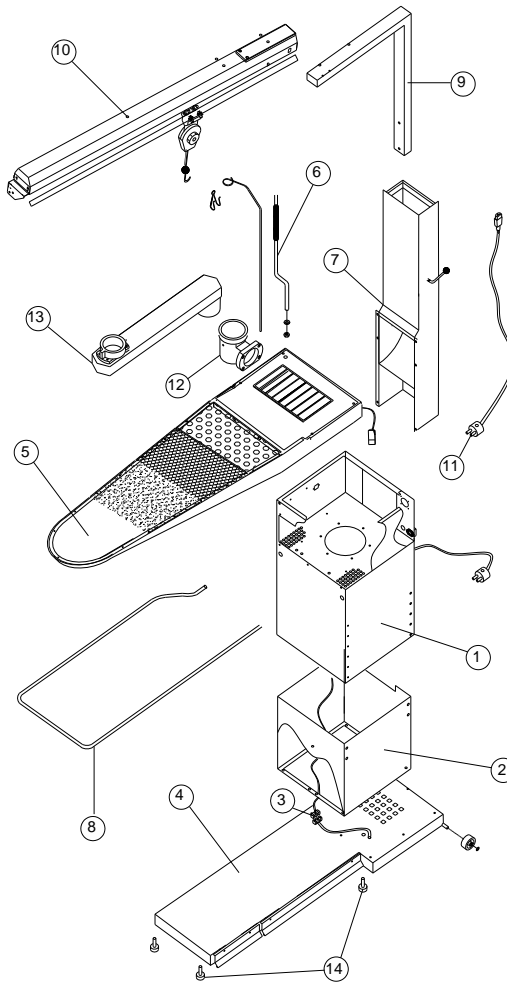
Each Ironing Table has the following attention marking:



The operator of the system has the obligation to be informed regarding the dangers which may occur during usage, so that he/she can avoid them or minimize their occurrence as best as he/she is able to.

### 4. Assembly instructions

For the instructions mentioned in the current section please see the below **drawing (picture2)**.



**Picture 2: Assembly**

1. Put base **No 01** in the inverted position. Screw the base **No 02** to the base of the table **No 04** to the base **No 02** after you have connected first the wires to the terminal block **No 03**.
2. Turn the assembled pieces in their regular position as soon as you screw the base.
3. Screw the working surface **No 05** to the base **No 01**.
4. Connect the wire of the working surface with the 4-poles socket which is situated on the back of the base **No 01**.
5. Screw the chimney **No 07** to the back side of the machine.
6. Screw the ATB Swivel bow for suspension of the iron cables **No 06**.
7. Place the base of the tray **No 08** in the slots into the front side of the base **No 01** and screw the screws.
8. In case you have purchased the model with the "vario iron system" screw the corner of the vario **No 09** to the chimney **No 07** and then the iron hanger **No 10** to the corner **No 09**.
9. Connect the cable of lighting **No 11** with the 3-poles socket of the lighting and the socket which is on the back of the base **No 01**.
10. Screw the corner of the swivelarm **No 12** to the working surface and put the swivelarm **No 13** above the corner.
11. Align the machine with the little feet **No 14** in order to be stable.
12. The machine is ready for use.

## 5. Instructions for Installation

For the instructions mentioned in the current section please see the **above drawing (Picture 2)**.

### 5.1 Installation

Put the Ironing Table in the designated area of your choice and align the machine by increasing/decreasing the height of its feet **No 14**. Make sure that the ironing Table is stable and the ironing surface flat.

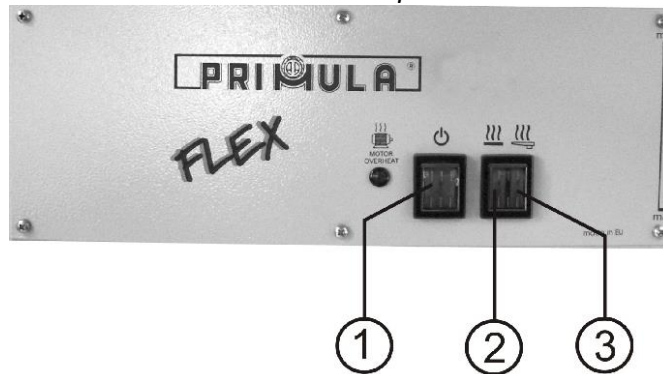
### 5.2 Electrical Connection

For the electrical connection and above all for the power supply, please follow carefully the instructions of the wiring diagram (enclosed) as well the warning signs symbols attached on the machine. In case you have purchased a single phase machine 230V, connect the machine to the power into the socket 230V/16A. The connection should be done with 3-phase 3X1,5 mm (1 phase, 1 neutral, 1 grounded). The power should be provided with a fuse 10A. If the machine is 400V/3 phase, the connection should be made to a 5-poles cable 5X1,5 mm (3 phase, 1 neutral, 1 grounding). The power should be secured with a 3-poles safety switch (3X10A).

**CAUTION!** For your own safety, pay attention to all the warning labels (yellow colored) that are placed on the machine. The manufacturer bears no liability for any damages or accidents due to faulty supplying network or to not specified personnel.

## 6. Activation Instructions

For the instructions mentioned in the current section please see the **below image (picture 3)**.



**Picture 3:** Switches

- Turn on the main switch **No 01**.
- Switch the thermostat that is placed below the buck to temperature 110°C during the winter and to 90°C during the summer.
- Whenever you want to use the suction just press the left pedal.
- Adjust the steam quantity of the steam generator in proportion to the suction performance of the table, in order to avoid steam liquidation on the working surface. The refined fabrics require small quantity of steam, while the gross fabrics require big quantity of steam.
- The ironing buck's heating is activated when you press switch **No 03** to position I.

**\*In case the table disposes Vario iron's system (optional)** hook the steam iron from the balancer and adjust the distance of the steam iron from the working surface



(approximately 5cm). After finishing ironing unhook the steam iron from the balancer and put it on the iron rest mat.

**\*\* In case your table disposes a blowing system of air:**

- Adjust the volume of the blowing air with the lever according to the requirements of the fabric (weight, quality , etc.) from the knob which is placed in the main body of the machine
- Push with your foot pedal for using the blowing.

## **7. Maintenance**

- Make sure that the covers of the table and the ironing buck remain clean, in order to have high performance of suction and blowing air. Wash the blue polyester fabric and the foam blue once per week in the washing machine (30-40 °C). In case you use felt molleton instead of blue foam, do not wash it in the washing machine, but wash it on hand. Replace them regularly, in order to keep high suction and blowing performance.
- Clean the dust of the fan wheel /impeller at least 2-3 times per year.
- Clean periodically and grease the arm's as well as the buck's bearings.
- Clean periodically the internal parts of the table as well as the electronic circuit by using compressed air.
- Keep the machine clean.

### **CAUTION!**

Before doing maintenance work, please disconnect the machine from the electrically power supply.

## **8. Troubleshooting**

For the instructions mentioned in the current section please see the **drawing of the spare parts of the machine on page 11.**

### **8.1 The vacuum does not function properly**

- Check if there is power supply.
- Check if the power feeding cable is for some reason cut off.
- Check the fuse 12A which is inside the fusecase **No 05**.
- Check if the suction's bouton pedal **No 09** is faulty.
- Check if motor **No 01** is for some reason damaged.
- Check the relay **No 13**.
- Check the electronic circuit **No 18**.

### **8.2 The heating of the working surface is not activated**

- Check if the fuse 12A inside the fusecase **No 05** is burnt out. Replace it.
- Check if the safety thermostat **No 31** is faulty. Replace it.
- Check if the thermostat **No 32** is faulty. Replace it.
- Check if the heating element **No 36** is burnt out. Replace it.
- Check the power supply cable and power plug on the board surface (**No 23**).
- Check if the switch **No 76** is faulty. Replace it.

### **8.3 The heating of the ironing buck is not activated**

- Check the cable and the plug of ironing's buck power supply.
- Check the switch **No 08** for the heating of the ironing buck.
- Check the heating element of the ironing buck .

#### **8.4 The machine operates loudly**

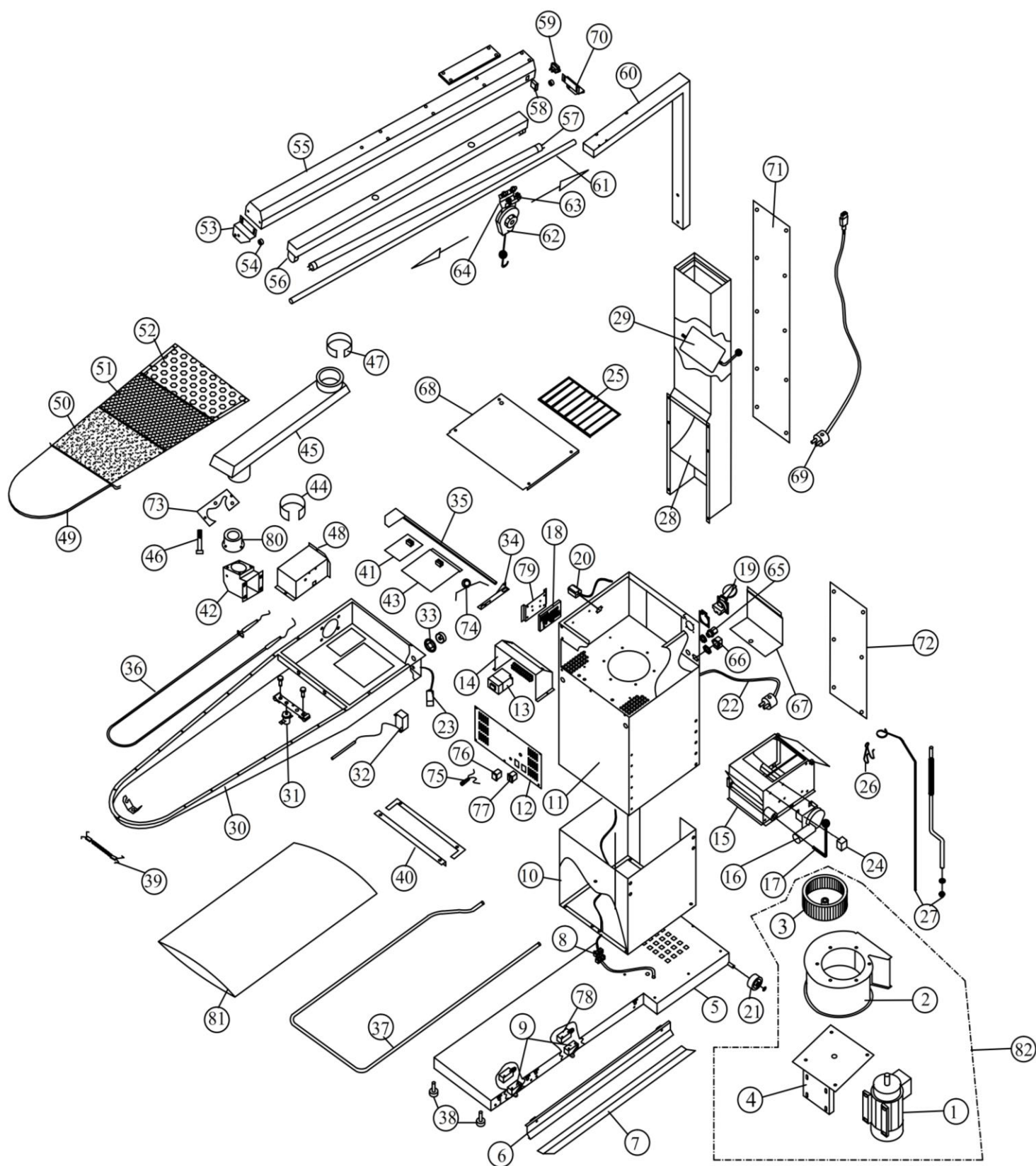
- Check if the ball bearings of the motor are faulty. Replace them.
- Check the impeller to be sure, that there is no dust which could cause the vibration.

#### **8.5 The blowing of air does not function**

**(If you have purchased the FLEX DOB S+B)**

- Check if the blowing's bouton pedal **No 09** is damaged.
- Check the electronic circuit **No 18**.
- Check the relay **No 13**.
- Check the motor **No 01**.
- Check the motor Flap Motor 12V/DC **No 16**.
- Check the relay 12V/DC **No 24**.

**Drawing of spare parts**



### List of Spare parts

<b>No</b>	<b>CODE</b>	<b>DESCRIPTION</b>
1	302-00-001-3	Electric Motor 0,75HP/400V/50HZ - 3 N
	302-00-001-1	Electric Motor 0,75HP/230V/50HZ - 1 N
	302-22-001-2	Electric Motor 0,75HP/220V/60HZ - 1 N
2	192-22-002	Metallic shell vacuum
3	302-00-003	Fan wheel Ø180
4	192-22-004	Metallic flange of metallic shell vacuum
5	192-21-005	Base of table 1242
6	192-26-022	Suction pedal 1242 ( for FLEX DOB)
	192-21-006	Blowing pedal 1242 (only for FLEX DOD 1242 S+B)
7	192-21-007	Suction pedal 1242
8	302-22-008	Terminal block for the connection of the button pedal
9	302-26-026	Suction and blowing button pedal
10	192-22-010	Male base
11	192-22-011	Female base
12	192-22-012	Dashboard
13	302-00-010	Relay
14	192-22-014	Circuit's case
15	192-22-015	Vacuum and Blowing interchange system (only for FLEX DOD 1242 S+B)
16	302-03-006	Flap Motor 24V/DC (only for FLEX DOD 1242 S+B)
17	192-22-017	Regulation lever of blowing (only for FLEX DOD 1242 S+B)
18	302-22-018	Electronic circuit (only for FLEX DOD 1242 S+B)
19	302-02-009	Socket 6A
20	302-27-004	Socket for buck with cable
21	302-01-016	Plastic wheel
22	302-26-005	Cable of power supply 3X1.5mm with plug
	302-00-014	Cable of power supply 5X1.5mm
23	302-21-023	Power supply cable of heating element
24	302-21-024	Relay 12V/DC (only for FLEX DOD 1242 S+B)
25	107-03-000	Silicon iron rest mat
26	192-01-027	Hanger of the iron's cables
27	107-01-000	Antenna
28	192-22-028	Chimney
29	192-22-029	Tamper of chimney
30	192-21-030	Plate of ironing table 1242
31	302-01-010	Safety thermostat 145°C
32	302-00-012	Thermostat of table 110°C
33	302-26-004	Thermostat knob
34	192-21-034	Bracket axle of corner
35	192-21-035	Axle of corner
36	302-01-014	Heating element 1 KW 230V
37	192-21-037	Base of tray
38	302-02-014	Leg for the regulation of table
39	302-01-035	Cover's spring with clip
40	192-21-040	Metallic corner
41	192-21-041	Tamper of swivelarm
42	192-22-042	Corner of swivelarm
43	192-21-043	Tamper of working surface

<b><u>No</u></b>	<b><u>CODE</u></b>	<b><u>DESCRIPTION</u></b>
44	192-22-043	Brass muff of corner 60mm
45	102-22-010-1	Arm of buck
46	302-21-046	Screw of arm
47	192-22-045	Muff of arm's brass bearing
48	192-21-048	Cover of tamper
49	302-21-072	Cover of table
50	302-21-050	Foam layer 1242
	302-21-050-1	Vacufix layer 1242
	302-21-050-2	Felt molletone 1242
51	302-21-051	Plastic lattice
52	192-21-052	Perforated
53	192-22-055	Blade of bar support S
54	302-01-057	Elastic stop
55	192-21-055	Plate of lighting
56	302-22-055	Lighting
57	302-00-044	Fluorescent lighting
58	302-22-054	Lighting's switch
59	302-22-056	Lighting's socket
60	192-22-059	Corner of vario
61	192-22-051	Suspension's bar
62	302-00-051	Iron's suspension
63	302-22-050	Ball bearing of stretcher's suspension
64	302-00-049	Stretcher suspension
65	300-00-008	Gland Ø 13.5mm
66	302-22-020	4-poles corner socket
67	192-22-031	Metallic cover (only for FLEX DOD 1242)
68	192-21-068	Base of iron
69	302-21-069	Cable of lighting power
70	192-22-055-1	Blade of bar support L
71	192-22-071	Metallic Cover of Chimney
72	192-22-072	Metallic Cover of male base
73	192-21-073	Metallic holder of screw
74	192-21-074	Spring of Tamper
75	302-22-074	Indicator light overheating motor
76	308-00-006	Switch ON-OFF 16A
77	302-00-017	Double switch ON-OFF
78	302-22-078	Cover of micro switch
79	192-22-065	Metallic base of electronic circuit
80	192-22-047	Bearing of arm
81	302-21-081	Cover for FLEX DOB tray
82	302-22-004	Vacuum 0.75Hp 400V complete
	302-22-004-1	Vacuum 0.75Hp 230V complete

**MONO FASE**

230V 1ph

**TRIFASE MOTORE MONOFASE**

220V 3ph

**MOTOR 3FASE**

400V 3ph

**PRIMULA**  
WARNING DIAGRAM  
FLEX FL 1365  
FLEX DOB 1242

**PRIMULA**

**WARNING DIAGRAM**

FLEX FL1365

FLEX DOB 1242

**List of Spare Parts of Wiring Diagram of the machine**

<b><u>Symbol</u></b>	<b><u>Articel</u></b>	<b><u>Description</u></b>
RLE	302-22-018	Electronic circuit
FSM	302-03-006	Flap motor
TPE	302-01-071	Brass terminal block of grounding
PS1	302-22-020	4-poles socket of working surface
PS2	302-02-009	Socket
PS3	302-27-004	Socket for buck with cable
TM1	302-22-072	Power supply terminal block
TM2	302-22-073	Flap moter terminal block
TM3	302-22-008	Bouton pedal terminal block
CV	302-26-005	Cable of power supply 3X1.5mm with plug
	302-00-014	Cable of power supply 5X1.5mm
LS	302-22-074	Indicator light overheating motor
K1	302-00-010	Relay motor fuse
FS	302-22-075	Cicuit safety fuse 2,5 A
F52	302-22-075	PC Board safety fuse 2,5 A
MB	302-26-006	Blowing Bouton
MV2	302-26-006	Suction Bouton
SI	308-00-006	Operation ON-OFF switch
SII	302-00-017	Working surface table ON-OFF switch
SII	302-00-017	Buck's heating operation switch ON-OFF



**TECHNICAL ASSISTANCE**

*For any advice about the operation of the machine or the spare parts, please contact the dealer you have purchased the machine from or us directly at:*



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*E-mail : [info@primula.gr](mailto:info@primula.gr)*

**All specifications have been made to the best of our knowledge.**

**Primula S.A preserves the right to make changes to the system and its parts without prior notice.**