Thermopatch
an Avery Dennison Company

USER MANUAL

NL-15 R / SQR MAMMOTH

ATTENTION!
All persons involved in installation, commissioning, operation, maintenance and repair of this product should be made available to these instructions.

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Introduction

Dear User,

Welcome to the growing group of Thermopatch users.
Your purchase has been manufactured with the utmost care to ensure that you benefit as long as possible from your Thermopatch product.
The products by Thermopatch are designed with special attention to your convenience. Should you discover any fault or damage upon receipt of this product, please contact your local Thermopatch vendor.
The manual has been prepared in accordance with NEN 5509 and in conformity with the Machinery Directive 2006/42/EC.
This user manual is intended not only for all users of the machine, but also for those who install and maintain the NL-15 R / SQR. The goal is to familiarize you with the operation, to provide for safe working instructions and guidelines for periodical maintenance.

This manual applies to machines NL-15 R / SQR from serialnumbers for type R: M14-03-0420 and for type SQR: SQR13-0456.

☛ ATTENTION!

In order to make safe and optimal use of the NL-15 R/ SQR, it is important to take note of -and understand the contents of this manual.

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1. General description

The pneumatic Mammoth is a practical and universal heat seal press with two press pads for optimal use.
Therefore, you do not have to wait during the press cycle, but can prepare the next article. Textile labels, company emblems, repair patches, transfers, in short all Thermopatch materials for marking and repair are easily and permanently pressed on all types of fabric.The machine is hand operated but can also be set to automatic operation. In that case, the press cycle is performed automatically when the swivelling arm comes in the end position.

1.1 Delivery

The NL-15 R / SQR is mounted onto a pallet and fixed with straps, covered with a cardboard box. The following articles can be found:

- NL-15 R / SQR heat seal machine
- Power cord
- 6 mm air tubing
- Quick installation guide
- quality checklist
- CE Declaration of Conformity

If one of these articles should be missing or faulty, please contact your Thermopatch supplier.

1.2 Conditions of warranty

Thermopatch points to its warranty and product liability conditions as laid down in our general conditions. These can be obtained at your Thermopatch supplier.

2. Intended use

The pneumatic NL-15 R / SQR is a heat seal machine that is intended for the application of textile labelling, repair patches and emblems and transfers.

⚠ WARNING!

Any use other than described above can be dangerous and cause damage and thus qualifies as 'misuse' which excludes Thermopatch bv from any liability.

3. Specifications

3.1 Specifications of the NL-15 R / SQR

NL-15 R

Power	800 Watts
Power supply	230 Volt AC
Operating temperature	204 °C
Temperature range	25-225 °C
Press Time range	1-240 sec.
Discharge pressure range	3-6 bar
Machine height (open)	540 mm
Machine width	620 mm
Machine depth	540 mm
Gross weight, including packaging	85 kg
Net weight	60 kg
Size sealing pads, round	160 mm
Fuses, slow	4.0 Ampere
A-weighted noise level	<70 dB (A)

NL-15 SQR

Power	800 Watts
Power supply	230 Volt AC
Operating temperature	204 °C
Temperature range	25-225 °C
Press Time range	1-240 sec.
Discharge pressure range	3-6 bar
Machine height (open)	540 mm
Machine width	600 mm
Machine depth	540 mm
Gross weight, including packaging	85 kg
Net weight	60 kg
Size sealing pads, round	160 mm
Fuses, slow	4.0 Ampere
A-weighted noise level	<70 dB (A)

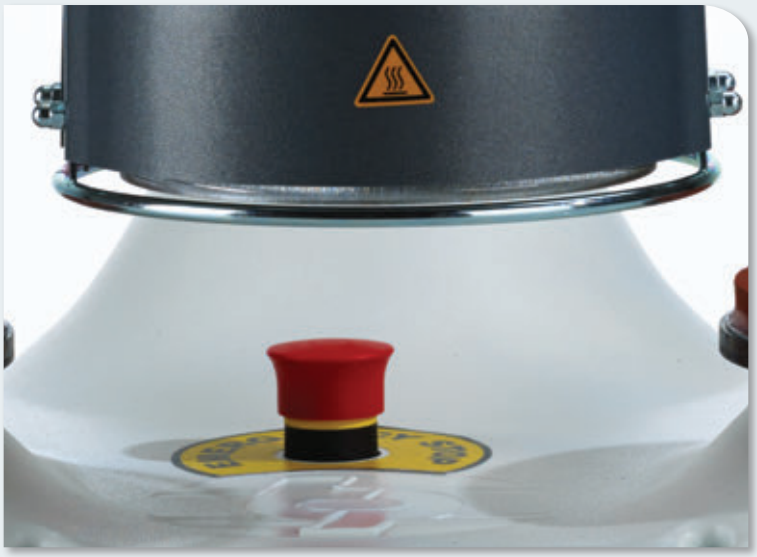
4. Safety measures and warnings

4.1 Safety

The NL-15 R / SQR has several features to ensure your safety.

The safety frame

The press plate of the NL-15 R / SQR is provided with a
safety frame. When this is touched or firmly moved, the heat sealing cycle is automatically interrupted.
To resume work, turn the machine off and on again.



The emergency stop button

In addition to the mandatory safety measures in conformity with the Machinery Directive, from serial numbers:
Model R: M14-03-0420 and model SQR: SQR13-0456, an emergency stop button has been provided to be able to intervene even faster in case of unforeseen events.

The safety thermostat

The safety thermostat on the heating element will interrupt the power supply when the temperature rises above 270°C.

Warning symbols

The following warning symbols have been mounted onto the machine for added safety:

▲Warning!

HOT SURFACE

▲Warning!

ELECTRIC TENSION

▲Warning!

ATTENTION!

Make sure you are informed about the contents of this manual before starting to work with the NL-15 R / SQR. This ensures an optimal and safe use of the machine.

ATTENTION!

Always turn the power off (unplug it) when you need to carry out maintenance work or when cleaning the machine.

ATTENTION!

In case of emergency, press the emergency stop button!

ATTENTION!

Take care that there is enough space around the machine. Cables and connections must not get pinched. Although the heat radiation of the press is low, there should be enough space for cooling down.

ATTENTION!

Avoid contact with the heating element.

ATTENTION!

Pull the fabrics tight around the press pad and ensure that your hands are away from the sealing pad before operating the machine.

5.0 Transport and storage

5.1 Transport

When the machine needs to be moved, Thermopatch advises to use the original packaging. The machine has to be lifted by the screw that is fixing the swiveling arm and the handle on the front of the machine.

5.2 Storage

When the machine needs to be stored, Thermopatch advises to use the original packaging. The machine should be stored on a pallet, off the floor, in dry conditions.

6.0 Operating instructions

6.1 Operating the NL-15 R / SQR

You can work with the Mammoth when the machine is connected to the mains.

- Set the airpressure to 3 - 5 bar on the manometer.
- See paragraph 6.5.2 for information regarding the pressure settings required for the NL-15 R / SQR.
- Place the plug in the socket and turn ON the NL-15 R / SQR with the ON - OFF switch which is placed on the back of the machine.
- Wait until the factory set temperature is reached.

Heating up will take approx 1 minute. The standard operating temperature has been set to 204 °C after which the press is ready for use.

6.2 Automatic mode

You can use the NL-15 R / SQR in Auto mode by pressing the AUTO -button.
The press cycle will automatically start when the swivel arm is positioned above the press plate.
The robot symbol is shown in the display.

☛ ATTENTION!

The automatic mode (🤖) should be switched off, when you wish to change the set values for temperature, pressure and press time. When the automatic mode is activated, the key board will not respond.

6.3 Safety Frame

The upper platen of the press head of the NL-15 R / SQR is enclosed by a safety frame. This frame will react if it is moved or touched and will interrupt the sealing cycle immediately. Switch the machine off and on again to resume work.

6.4 The control panel

NL-15 R / SQR control panel. The pressure, temperature and time are shown on the display.
The minimum, maximum and default values for temperature and pressure have been set by the manufacturer.
The following icons are present on the display:

KEYS		Temperature setting
		Pressure setting
		Time setting
	+	Plus (higher)
	-	Minus (lower)
	AUTO	Automatic mode on / off
SYMBOLS ON SCREEN		Automatic mode on
		Power saving mode on
		time indicator
		Second sealing cycle active
		Interruption of the safety circuit

6.5 Change settings

6.5.1 Temperature settings

The default operating temperature of 204 °C has been set by the manufacturer. In case you want to adjust the operating temperature above or below the default temperature range, please contact the service department of your supplier. The default temperature range is: minimum 25 °C, maximum 210 °C.

Temperature change

You can change the temperature in steps of 1 degree by pushing the temperature button 1 x pushing the + and the -.
You change from Celsius to Fahrenheit and vice versa by pushing the temperature button for 3 seconds.

Temperature check

The temperature is displayed digitally by pressing one key.
An additional check of the temperature between the press plates can be performed by means of temperature indication labels.

To check the temperature, do the following:

- Let the machine heat up for about 1 minute.
- Set the time to 12 seconds and close the machine.
- After opening the machine again, put the indicator on the press pad and close the machine again.
- Take the label away immediately after opening the machine.
- For details: https://www.thermopatch.com/en/products/temperature-indicator-labels-thermolabels/

6.5.2 Pressure settings

The standard factory setting for pressure is set at 5 bar. The pressure is easily set to your requirements by turning the air pressure adjustment knob of the air pressure regulator placed on the back of the machine. The adjusted pressure setting will be on display. The NL-15 R / SQR has a pressure guard which is set to a minimum of 2,5 and a maximum of 6,0 bar. At too low or too high pressure the machine cannot be operated and a failure code will be on display(4 or 5).
The setting of the lower limit for the pressure setting is done as follows:
by pushing the pressure icon once, the set lower limit appears on display. This can be adjusted by pushing + or -. When the lower pressure limit is set to 0, the the pressure guarding system is de-activated. The setting of the upper limit for the pressure setting is done as follows:
by pushing the pressure icon twice, the set upper limit appears on display. This can be adjusted by pushing + or -.

6.5.3 Time settings

The default sealing time setting of the NL-15 R / SQR is 12 seconds. Adjusting the settings can be done with the control panel.

Change time

Push the time button once. Change the time setting in steps of 1 second by pushing the - or + button. The range is 1 - 60 seconds.

6.5.4 Power save

When you want the machine to switch to a lower energy level when you are not working, you can use the power save mode.
Push the time button twice.
Set the power save mode in steps of 1 minute by pushing the + or – button.
Power save ranges from 1-60 minutes.
If it is set to 0 the power save mode is not active and the machine will be heated continuously.

6.5.5 Second sealing cycle

In some cases it is desirable to seal a second time.
Push the AUTO button during three seconds. A second seal cycle of 2 seconds takes place.
You can switch this option off by pushing the button for three seconds once more.

6.5.6 Interrupting the sealing cycle

There are various means to interrupt the sealing cycle of the machine. You can interrupt the operation by:

- Pushing a button of the display randomly.
- Turning the on/off switch on the front.
- Stir the safety bar.
- Push the emergency stop button, pull it out and switch on the machine again.

ATTENTION!

When the first heat sealing cycle is interrupted, the second cycle will not start.

6.5.7 Exchangeable base platens with rubber sealing cushions

The standard base plate with press cushion SPAMA-01-04-VA-QR with dimensions 140x140 mm can be replaced by other base platens. When desired, smaller rubber cushions can be easily installed by replacing the standard base platen with quick release with a smaller base platen with quick release, with smaller silicone rubber cushions on top.
In addition to the base platen, we have re-introduced the classic NL-9 base plates with rubber cushions.
There are 4 base plates available with the following dimensions:

- SPA9016 BASE: dimensions 130x50mm.The corresponding rubber press cushion is the SPA9016.
- SPA9017 BASE: dimensions 130x25mm.The corresponding press cushion is the SPA9017.
- SPAPEN-21026 BASE: dimensions 115x1155 mm and all existing variants of rubber press cushions in this size.
- SPA43941 BASE: size 120x95mm and all existing variants of rubber press cushions in this size.

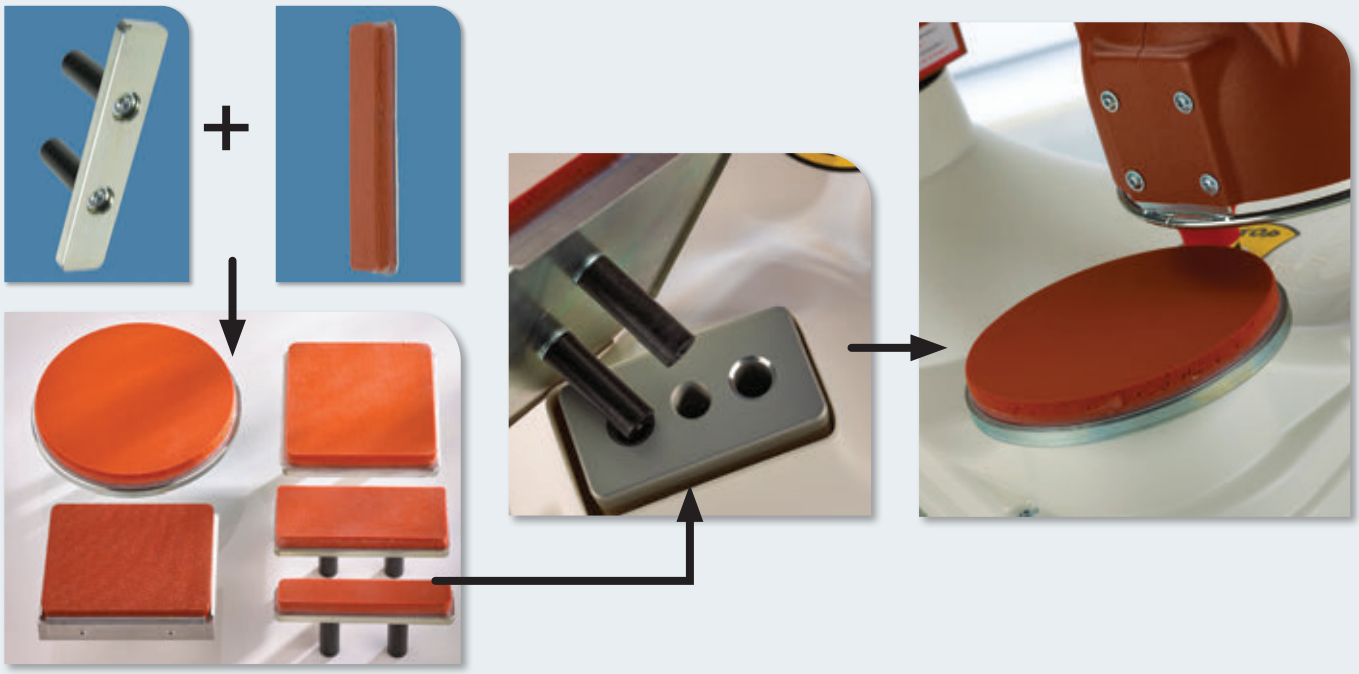
SPA9016 BASE

SPA9017 BASE

SPAPEN-21026 BASE

ATTENTION!

The base platens will be supplied without rubber sealing cushion!



6.5.8 Messages in the display

A description is given below of the messages in the display which appear immediately after turning on the machine.
Further, we will discuss some failure codes that can be displayed on the control panel display.

- During heating up of the machine the temperature, pressure and time are displayed.
- During the press cycle the press time is displayed from 0 to the programmed sealing time
- Automatic mode ON/OFF is displayed with the Robot-icon. ( ).
- is displayed during POWER SAVE MODE.

ATTENTION!

When the first heat sealing cycle is interrupted, the second cycle will not start.

6.5.9 Error codes

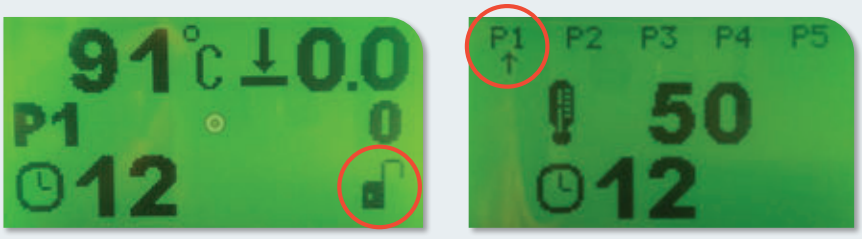
There are 6 different failure codes that can be displayed; contact your Thermopatch supplier.

01	Sensor defective or broken sensor cable
02	Sensor short cut
03	Element defective or broken element cable
04	Pressure set too low
05	Pressure set too high
06	Safety switch interrupted or defective

6.5.10 Preprogrammed settings

The setting of the heat sealing time and temperature is dependant on the labour that has to be executed and the materials to be marked. These can be adjusted by the operator.
By pressing the “AUTO” button the NL-15 R/SQR can be entered into and taken out of operational mode.
Only when the NL-15 R/SQR is taken out of oprational mode parameters can be altered and presets can be chosen (nr. 1 - 5) by pressing the + button.
Presented in the display:

- the chosen preset: See P1, P2, P3, P4, P5
- The temperature
- The set time: see preset in seconds
- Day counter: 001
- Machine in operational mode: Locked



Select the required preset by pushing the + button.

The NL-15 R / SQR has been supplied with the following 5 preset programs:

Preset 1, for Thermopatch label products for high temperature applications (up to 95 °C washing):	Sealing time: Temperature:	14 seconds 204 °C
Preset 2, for labels, emblems and transfers for high temperature applications (up to 95 °C washing)	Sealing time: Temperature:	14 seconds 195 °C
Preset 3, for emblems and transfers for high temperature applications (up to 95 °C washing)	Sealing time: Temperature:	12 seconds 185 °C
Preset 4, for emblems and transfers for medium to low temperature applications (up to 60 °C washing)	Sealing time: Temperature:	15 seconds 150 °C
Preset 5, for emblems and transfers for medium to low temperature applications (up to 40 °C washing)	Sealing time: Temperature:	12 seconds 185 °C

7. Assembly and installation

7.1 Assembly
To work seamlessly with the NL-15 R / SQR, it is very important that the machine can dispose of supply of clean, dry air. The water condenser is an additional safety measure. Provide pressure of 4-6 bar from the compressor or its own air supply.
Attach a tube with a diameter of 6 mm at the compressor or own air supply and the air regulator of the NL-15 R / SQR (Image A).

7.2 Installation
Upon delivery, the NL-15 R / SQR is fastened with straps to a pallet. The arm of the machine is locked with a bolt (M12).
- Lift the machine out of the box holding it by this bolt and the handle.
- Put the machine on a work table near an earthed socket.
- Remove the M12 bolt.
- Make sure that there is enough free space around the machine.
- Make sure that there are no items near the machine that are sensitive to heat radiation.

If you have to move the machine at a later time, it is recommended to pack it in a similar way. Let the press cool down before you pack it.

7.3 Electrical requirements
The NL-15 R / SQR should be connected to the electricity grid (230 V alternating current). Use the machine's power cable to provide current. The NL-5 R / SQR is an earthed machine and has been provided with two fuses of 4.0 amps, see image B.

A

B

8. Maintenance instructions

8.1 Daily maintenance

Clean the outside of the machine regularly with a clean, moist cloth. First switch off the machine, let it cool down and pull the plug out of the socket.
Every now and then the inner parts of the press should also be cleaned from dust and lint.

- First switch off the current before performing this operation and remove the bottom plate.

For good press results it is important to keep the press surfaces clean. Therefore, clean the teflon coating of the upper platen with a clean, dry cloth.

- Do not touch the heating element!

Also clean the silicone rubber of the press platen daily with a dry cloth. Do not use solvents or other chemical substances to remove impurities. Do not let buttons, zips, etc. come between the plates. In this way, the silicone rubber will remain intact for a long time.

8.2 Periodic maintenance

The mechanism of the NL-15 R / SQR needs no maintenance.
Remove collected moisture from the separator of the air filter regulator at least once a week.
The rubber pads and the upper plate must be cleaned once or several times daily. Clean them with a clean and dry cloth when they have cooled down. They must be absolutely smooth and clean.
Both the and the lower press pad should be replaced regularly.
Remove the old sealing cushion and carefully remove all glue residues from the metal surface. The surface must be absolutely clean and smooth, so that the new rubber cushion has an optimal adhesion to the metal platen

Teflon replacement

In order to be able to replace the teflon of the upper platen, the press needs to be warmed up until 80 °C. Remove the worn teflon sheet and remove glue residue carefully from the metal surface by using a scraper or a putty knife.
After this, brush the surface with with a copper wire brush. Finally clean the upper platen with a soft cloth. The newly applied teflon will stick best when the surface is completely clean.
Make sure no air is trapped in underneatch the teflon cover.

8.3 Parts for regular replacement for maintenance:

• Sealing pads	Art.nr.
for type R: 160 mm round	SPAMA-01-04
for type SQR: 140 x 140 mm	SPAMA-01-04 VA
• Self adhesive teflon sheet	
for type R: 160 mm, round	SPAMA-03-21
for type SQR: 150 x 150 mm	SPAMA-03-21 V
• Fuse	
4 A TR	SPAMA-04-10

9. Technical annexes (English)

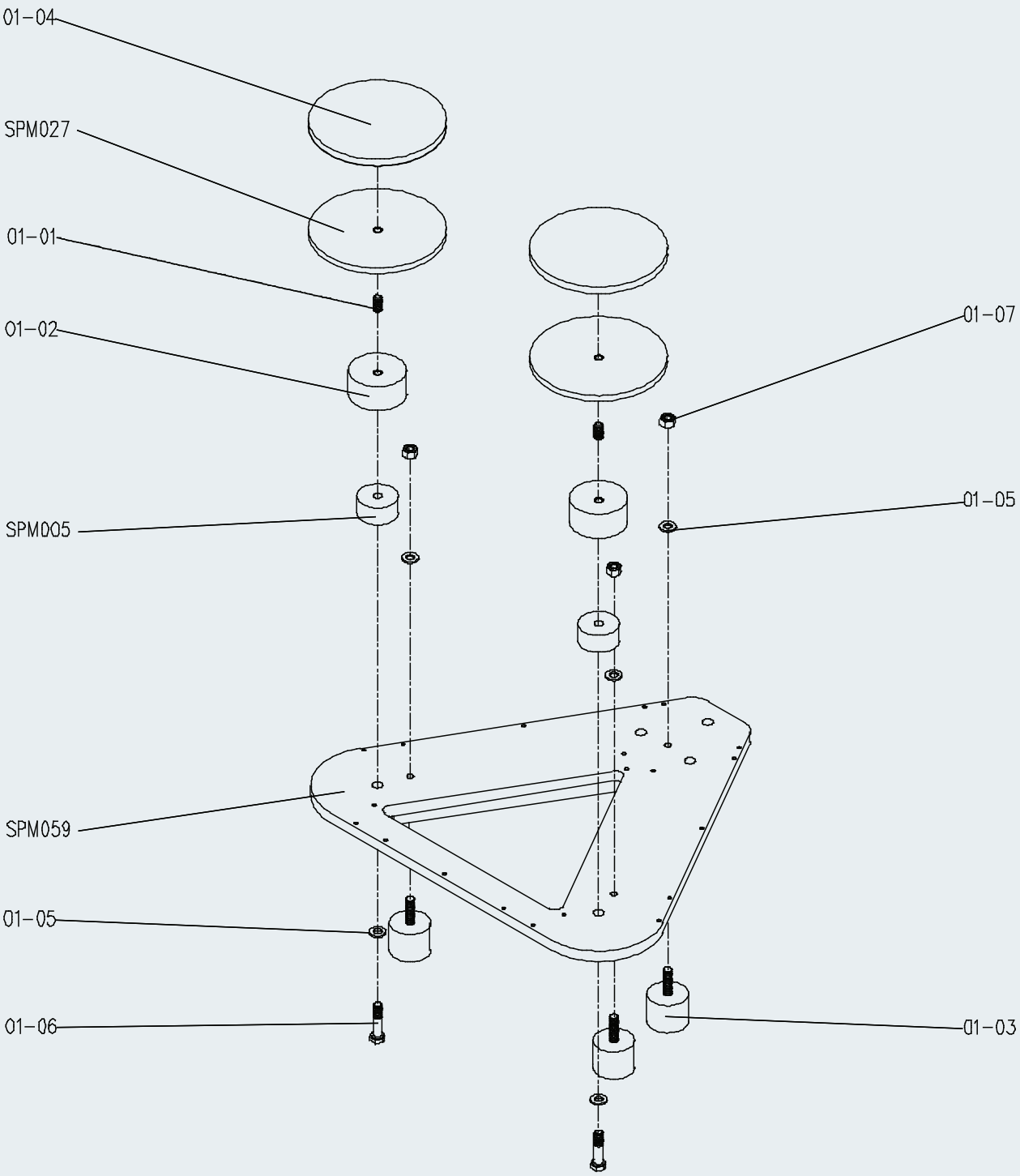
In this chapter you will find the parts lists, the applicable exploded views and the pneumatic and electrical wiring diagrams.

Parts list 01

Code dwg	Description 1	Description 2	Quantity	Thermopatch Code
01-01	Socket set screw	M10 x 16	2	*
01-02	Rubber buffer	D=65, h=35	2	SPAMA 01-02
01-03	Rubber buffer	D=50, h=40	3	SPAMA 01-03
01-04	Resilient pad		2	SPAMA 01-04
01-05	Plain washer	10,5 x 20 x 2	5	SPAMA 01-05
01-06	Hex. Head bolt	M10 x 50	2	SPAMA 01-06
01-07	Nut	M10	3	SPAMA 01-07
SPM005	Distance bush		2	SPAMA 005-B
SPM027	Support, resilient pad		2	SPAMA 027-B
SPM059	Mounting frame		1	SPAMA 059-C

*Thermopatch does not hold stock for this item

Drawing 01

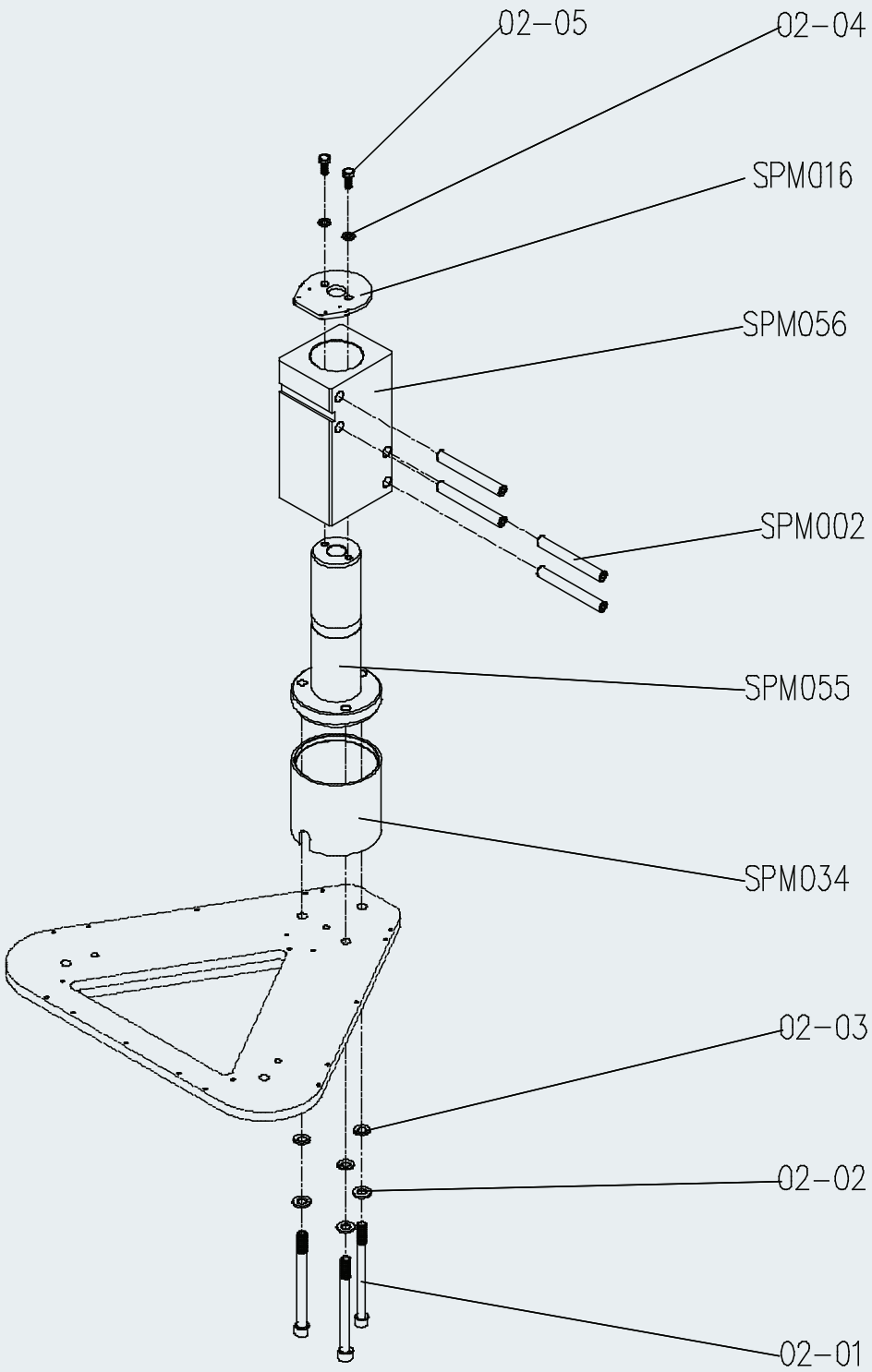

01-04
SPM027
01-01
01-02
SPM005
SPM059
01-05
01-06
01-07
01-05
01-03

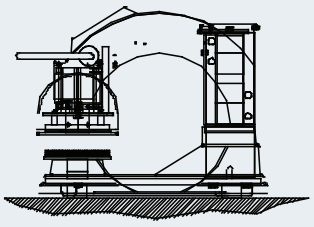
Parts List 02

Code dwg	Description 1	Description 2	Quantity	Thermopatch Code
02-01	Socket Head screw loctite	M12 x 150	3	*
02-02	Plain washer	13 x 24 x 2,5	3	*
02-03	Spring lock washer	12,2 x 21,2 x 2,5	3	
02-04	Plain washer	8,4 x 16 x 1,6	2	*
02-05	Socket Head screw	M8 x 20	2	*
SPM002	Shaft, hinge point		4	SPAMA-002-B
SPM016	Top cam, column		1	SPAMA-016-C
SPM034	Distance bush, column		1	SPAMA-034-B
SPM055	Main column, arm		1	SPAMA-055-B
SPM056	Hinge block		1	SPAMA-056-C (incl.4x GSM-6570-50)

*Thermopatch does not hold stock for this item

Drawing 02





MAIN COLUMN & HINGE BLOCK 02

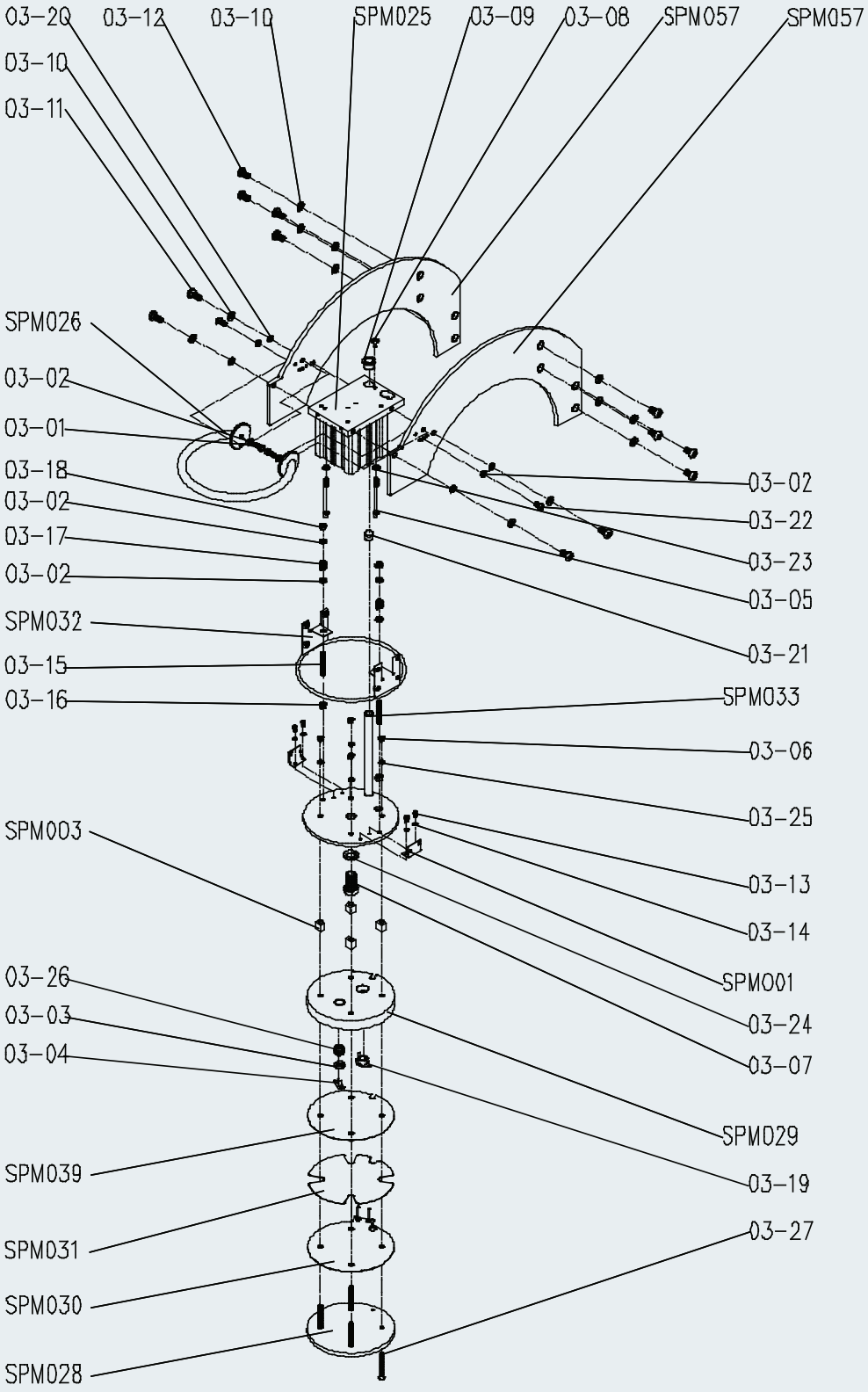
MAMMOTH – SERIE-II |August 2104|

Parts List 03 for NL-15 R

Code dwg	Description 1	Description 2	Quantity	Thermopatch Code
03-01	Hex. Head bolt	M6 x 16	4	*
03-02	Plain washer	6,4 x 12 x 1,6	10	*
03-03	Bush		1	SPAMA 03-03
03-04	PT-1600	TP	1	SPAMA-03-04
03-05	Socket head screw	M6 x 90	2	*
03-06	Nut	M6	3	*
03-07	Hex. Head bolt	M16 x 20	1	*
03-08	Socket button screw	M6 x 10	1	*
03-09	Slide bearing		1	SPAMA 03-09
03-10	Plain washer	8,4 x 16 x 1,6	4	*
03-11	Socket button screw	M8 x 20	4	*
03-12	Socket button screw	M10 x 16	8	*
03-13	Socket head screw	M3 x 8	4	*
03-14	Plain washer	3,2 x 7 x 0,5	4	*
03-15	Socket set screw	M6 x 50	2	*
03-16	Nut	M6	2	*
03-17	Spring		2	SPAMA 03-17
03-18	Lock nut	M6	2	*
03-19	Thermostat	TP	1	SPAPEN-03-02
03-20	Lock washer		4	SPAMA 03-20
03-21	Teflon self-adhesive (not on drawing)		1	SPAMA-03-21
03-26	Spring			SPAMA-03-26
03-27	Bolt		4	SPAMA-03-27
SPM001	Bracket safety switch		2	SPAMA 001-C
SPM025	Bracket air cylinder		1	SPAMA 025-D
SPM026	Handle, press arm		1	SPAMA 026-B
SPM028	Heater shield		1	SPAMA 028-B
SPM029	Isolating plate		1	SPAMA 029-C
SPM030	Silicon element		1	SPAMA 030-B
SPM032	Safety rack		1	SPAMA 032-C
SPM033	Safety bracket		1	SPAMA 033-C
SPM039	Aluminium disc		1	SPAMA 039-C
SPM057	Press arm		2	SPAMA 057-C

* Thermopatch does not hold stock for this item
** Only replace when the heating element or the PT1600 sensor is replaced.

Drawing 03 for NL-15 R

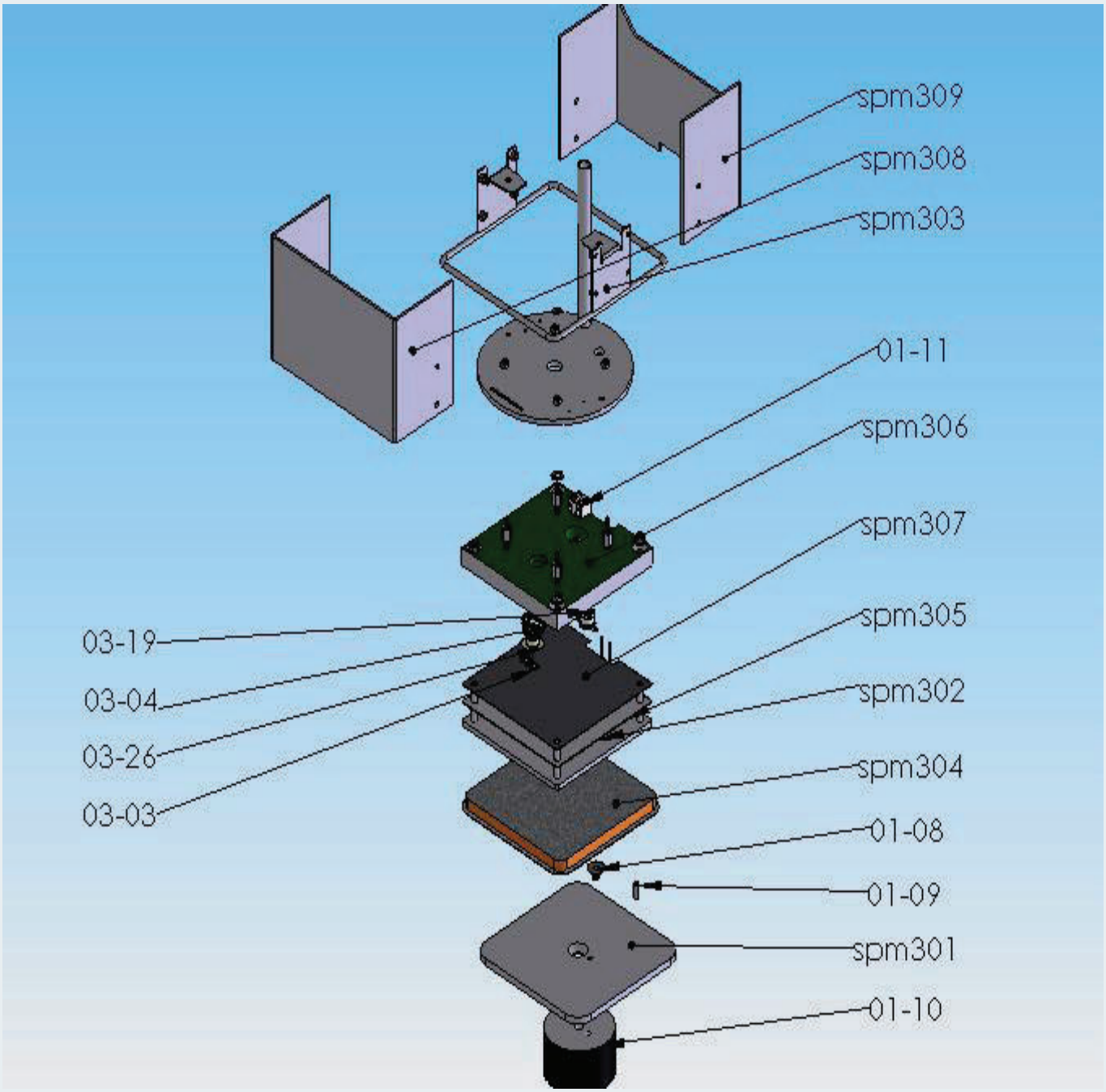


Parts List 03 for NL-15 SQR

Code dwg	Description 1	Description 2	Quantity	Thermopatch Code
01-08	Countersunk bolt	M10x12	2	SPAMA 01-08
01-09	Spring pen	D=6 l=20	2	SPAMA 03-26
01-10	Rubber buffer *	D=65 H=35	2	SPAMA 01-02
01-11	Ceramic terminator		1	SPAPEN03-04
03-03	Bush		1	SPAMA03-03
03-04	PT-1600		1	SPAMA03-04
03-19	Thermostat		1	SPAPEN-03-02
03-26	Spring		1	SPAMA03-26
SPM301	Support resilient pad*	160x160	2	SPAMA027-V
SPM302	Heatershield	150X150	1	SPAMA028-V
SPM303	Safety rack	160X160	1	SPAMA32-Z
SPM304	Resilient pad	150X150	2	SPAMA01-04-V
SPM305	Heater	150X150	1	SPAMA-030-C
SPM306	Insulation	150X150	1	SPAMA-039-V
SPM307	Cover aluminum	150X150	1	SPAMA307
SPM308	Safety front		1	SPAMA308
SPM309	Safety back		1	SPAMA309

*Thermopatch does not hold stock for this item

Drawing 03 for NL-15 SQR



Drawing 03A for NL-15 R / SQR, SAFETY FRAME UPGRADE February 2017
From **2-2017** a modification of the part has been executed to solve the fault indicator, on the display (see page 18. 6.5.9)

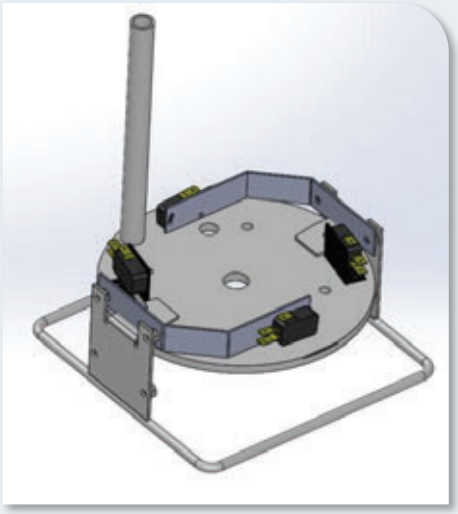
06	Safety switch interrupted or defective

2 x SPAMA-SU2-C1 have been replaced by 1 x SPAMA-SU2-C4 (the safety switch mounting plate)

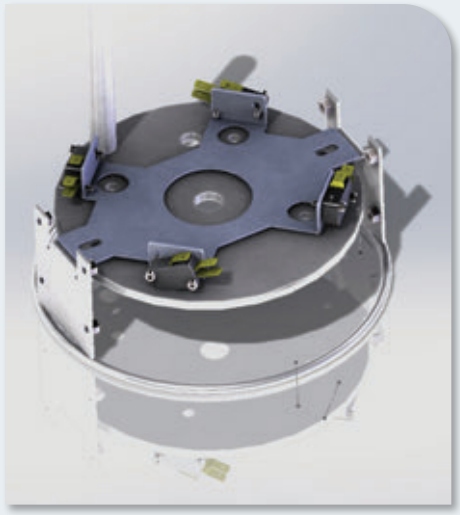
In total 4 x SPAMA-SU2-B1 (Safety switch Omron V16-1-C5) are now used for the switches. In the previous set, before February 2017, up this used to be 2 x SPAPEN-03-09 en 2 x SPAMA-SU2-B1.

Modifications on machines from productions before 2-2017 must be executed by qualified technicians; take note that this is an important safety feature of the NL-15 machine.

Modifications are estimated to take up to 30 minutes.



Version before Februari 2017



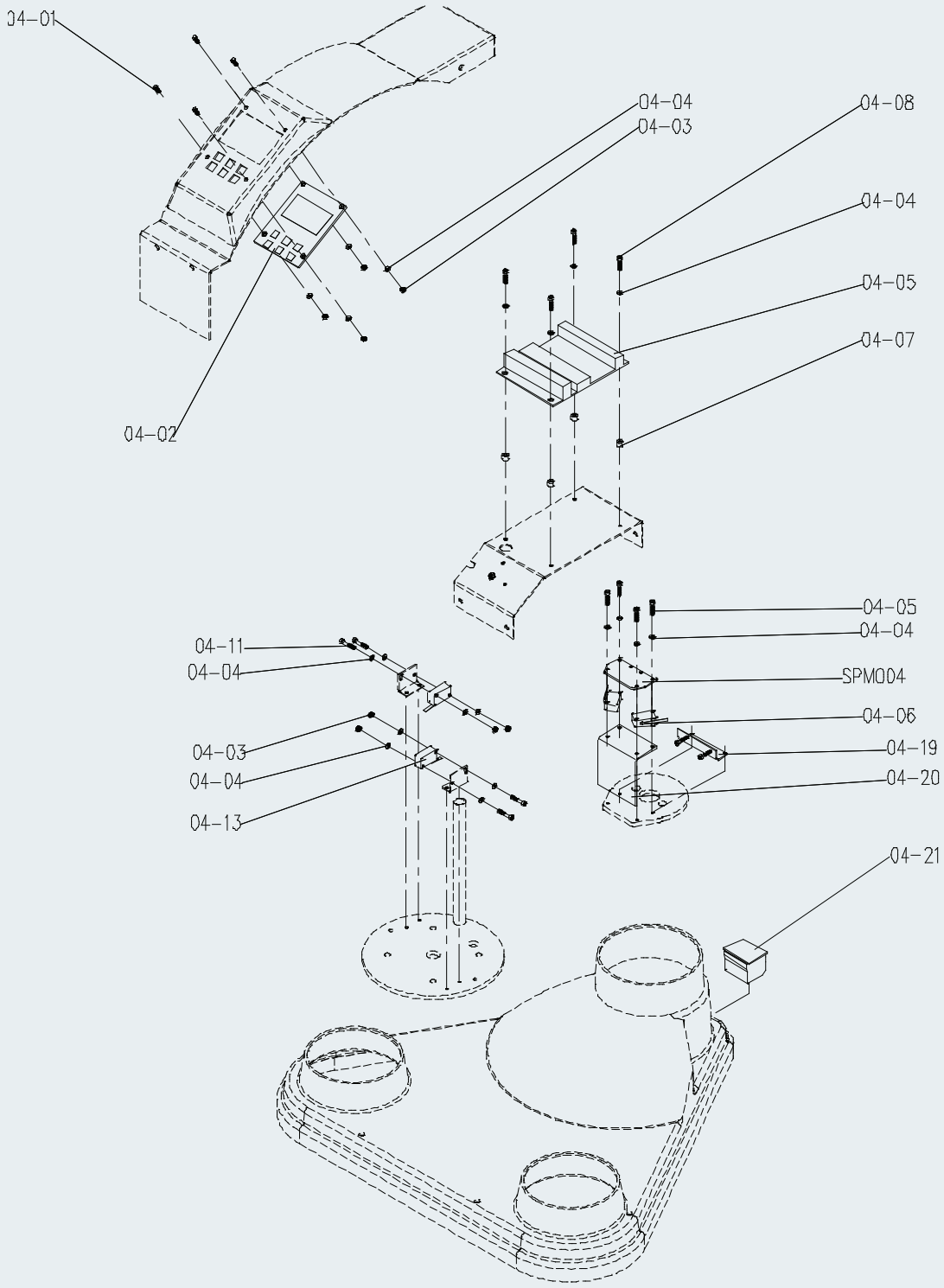
Version since February 2017

Parts List 04

Code dwg	Description 1	Description 2	Quantity	Thermopatch Code
04-01	Flat head bolt	M3 x 12	4	*
04-02	Display	TP	1	SPAMA 04-02
04-03	Lock nut	M3	8	*
04-04	Plain washer	3,2 x 7 x 0,5	20	*
04-05	Socket head screw	M3 x 16	4	*
04-06	Micro switch		2	SPAMA 04-06
04-07	Distance bush		4	SPAMA 04-07
04-08	Main board	TP	1	SPAMA 04-08
04-09	Fuse holder	***	1	SPAMA 04-09
04-10	Fuse 4A slow	BN238547	1	SPAMA 04-10
04-11	Socket head screw	M3 x 20	4	*
04-13	Safety switch		2	SPAMA 04-13
04-14	Foot switch connector	Not on drawing	1	SPAMA 04-14
04-15	Pull relief	Not on drawing	1	SPAMA 04-15
04-17	Sunk head bolt	M3 x 25	4	*
04-18	Nut	M3	4	*
04-19	Bracket switches		1	SPAMA 071-A
04-20	Adjustment bracket		1	SPAMA 070-A
04-21	Net entry incl. filter		1	SPA105003
			1	SPAMA 004-B

*Thermopatch does not hold stock for this item

Drawing 04

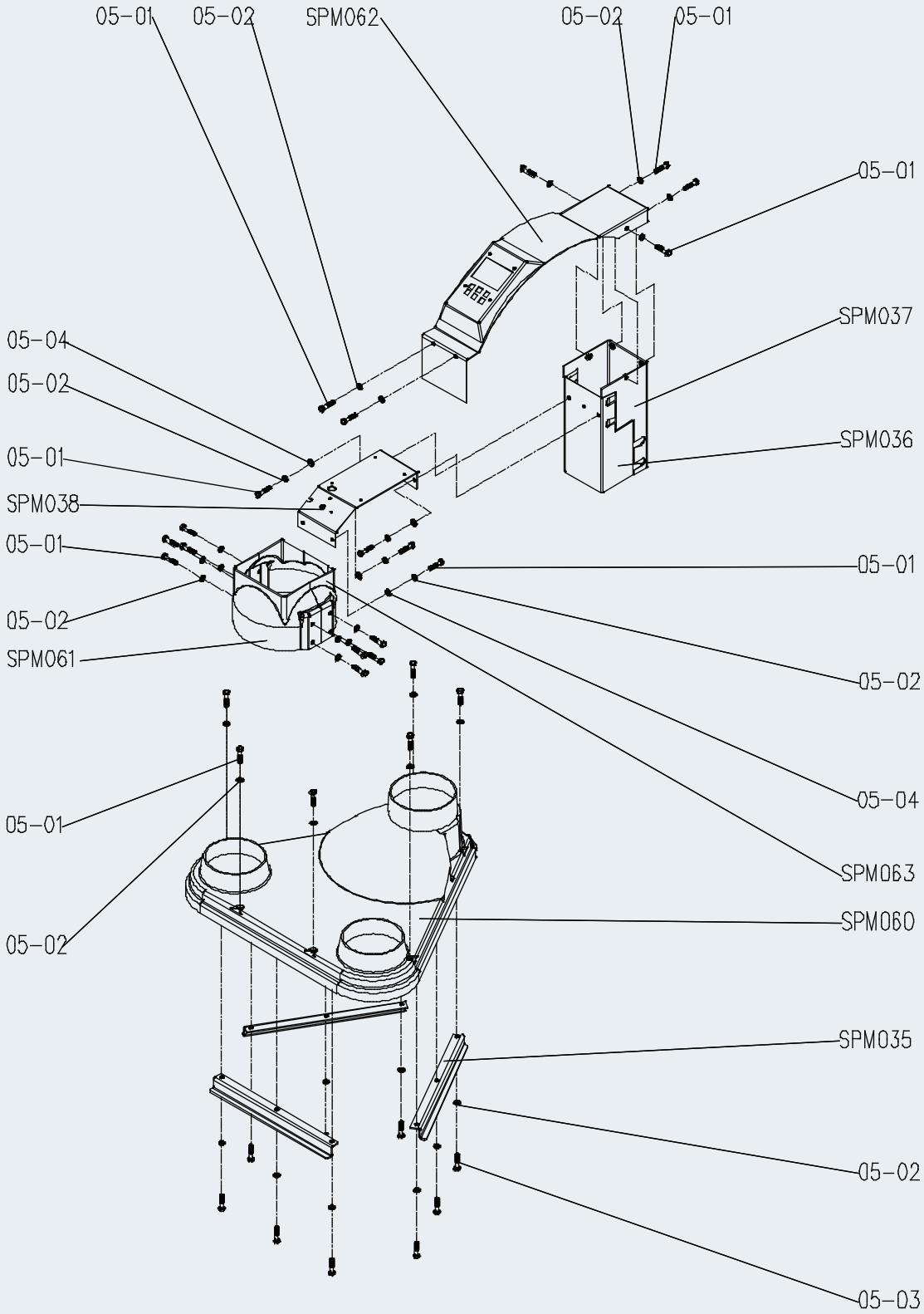

04-01
04-04
04-03
04-08
04-04
04-05
04-07
04-02
04-05
04-04
SPM004
04-06
04-19
04-20
04-11
04-04
04-03
04-04
04-13
04-21

Parts List 05

Code dwg	Description 1	Description 2	Quantity	Thermopatch Code
05-01	Socket button screw	M5 x 10	26	*
05-02	Plain washer	5,3 x 10 x 1	35	*
05-03	Hex. Head bolt	M5 x 16	9	*
05-05	Nut	M5	1	*
SPM035	Protective strip		3	SPAMA-035-B
SPM036	Cover, hinge block,front		1	SPAMA-036-B
SPM037	Cover, hinge block,rear		1	SPAMA-037-B
SPM038	Bracket main board		1	SPAMA-038-C
SPM060	Main cover, frame		1	SPAMA-060-E
SPM061	Element cover, front		1	SPAMA-061-D
SPM062	Top cover, press arm		1	SPAMA-062-C
SPM063	Element cover, back		1	SPAMA-063-D
04-14	Foot switch connector	Not on drawing	1	SPAMA 04-14
04-15	Pull relief	Not on drawing	1	SPAMA 04-15
04-17	Sunk head bolt	M3 x 25	4	*
04-18	Nut	M3	4	*
04-19	Bracket switches		1	SPAMA 071-A
04-20	Adjustment bracket		1	SPAMA 070-A
04-21	Net entry incl. filter		1	SPA105003
SPM004	Cover, top cam		1	SPAMA 004-B

*Thermopatch does not hold stock for this item

Drawing 05

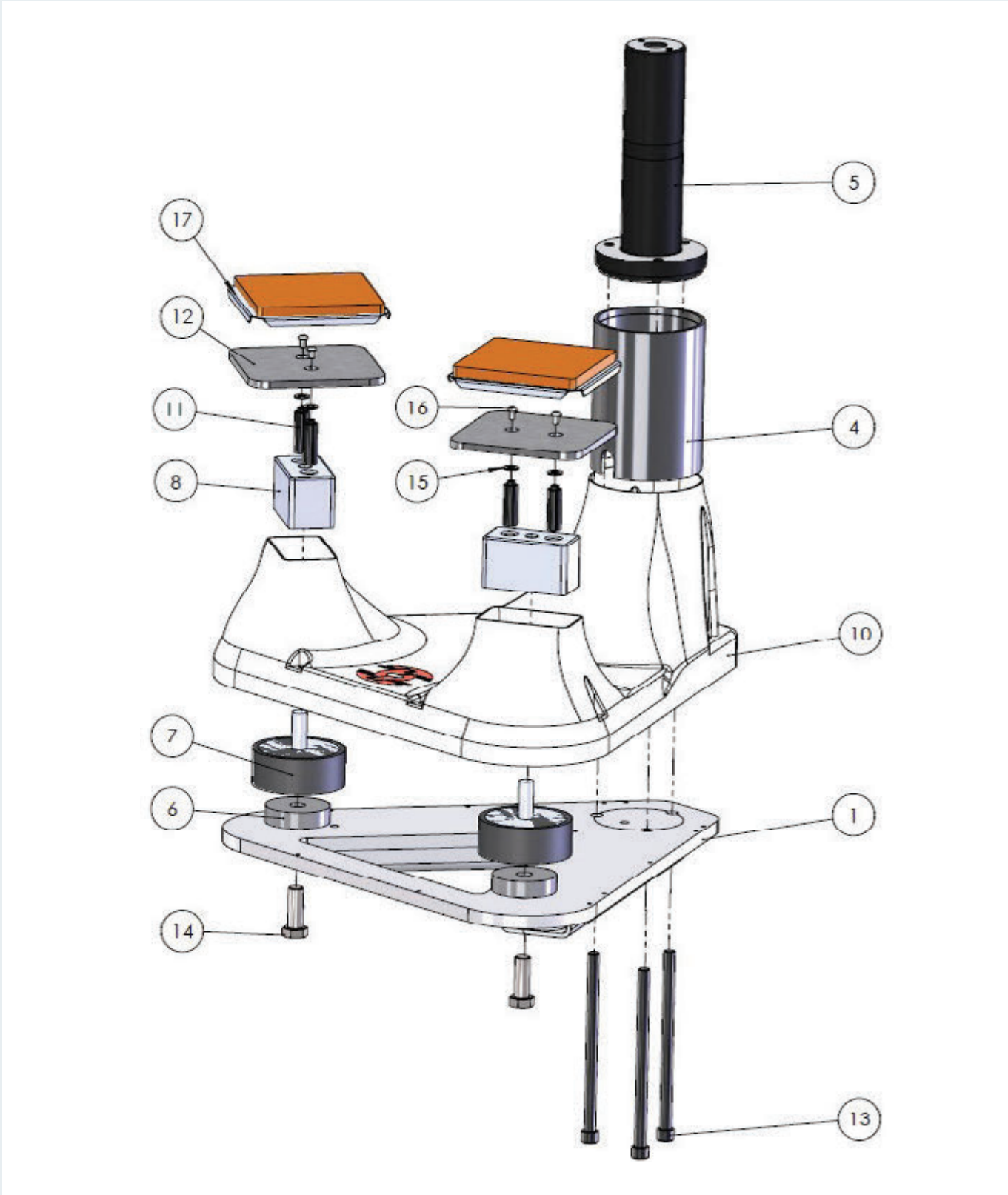

05-01
05-02
SPM062
05-02
05-01
05-01
SPM037
05-04
05-02
05-01
SPM036
SPM038
05-01
05-01
05-02
SPM061
05-02
05-01
05-04
SPM063
SPM060
05-02
SPM035
05-02
05-03

Parts List 05A High Model from Jan 2019

Item nr.	Thermopatch Code	Description	Quantity
1	SPAMA-059-E	Mounting Frame	1
4	SPAMA-034-D	Distance bush column	1
5	SPAMA-055	Main column	1
6	SPAMA-005g	Distance bush	2
7	SPAMA-01-02-A	Cylindrical mounting	2
8	SPAMA-201	Guide bottom plate	2
10	SPAMA-060-F	Main cover	1
11	SPAES-033	Support plate pin	4
12	SPAES-032	Support plate sealing pad	2
13	*	M12x200 Hexagon Socket Head Cap Screw	3
14	*	M16X45 Hexagon head screw	2
15	*	M8 plain washer	4
16	*	M16x10 Hexagon head screw with flange	4
17	SPAMA-01-04-VA-QR	Sealing pad 140x140 mm quick release NL15SQR/NL24	2

*Thermopatch does not hold stock for this item

Drawing 05A HIGH MODEL 2019 onwards

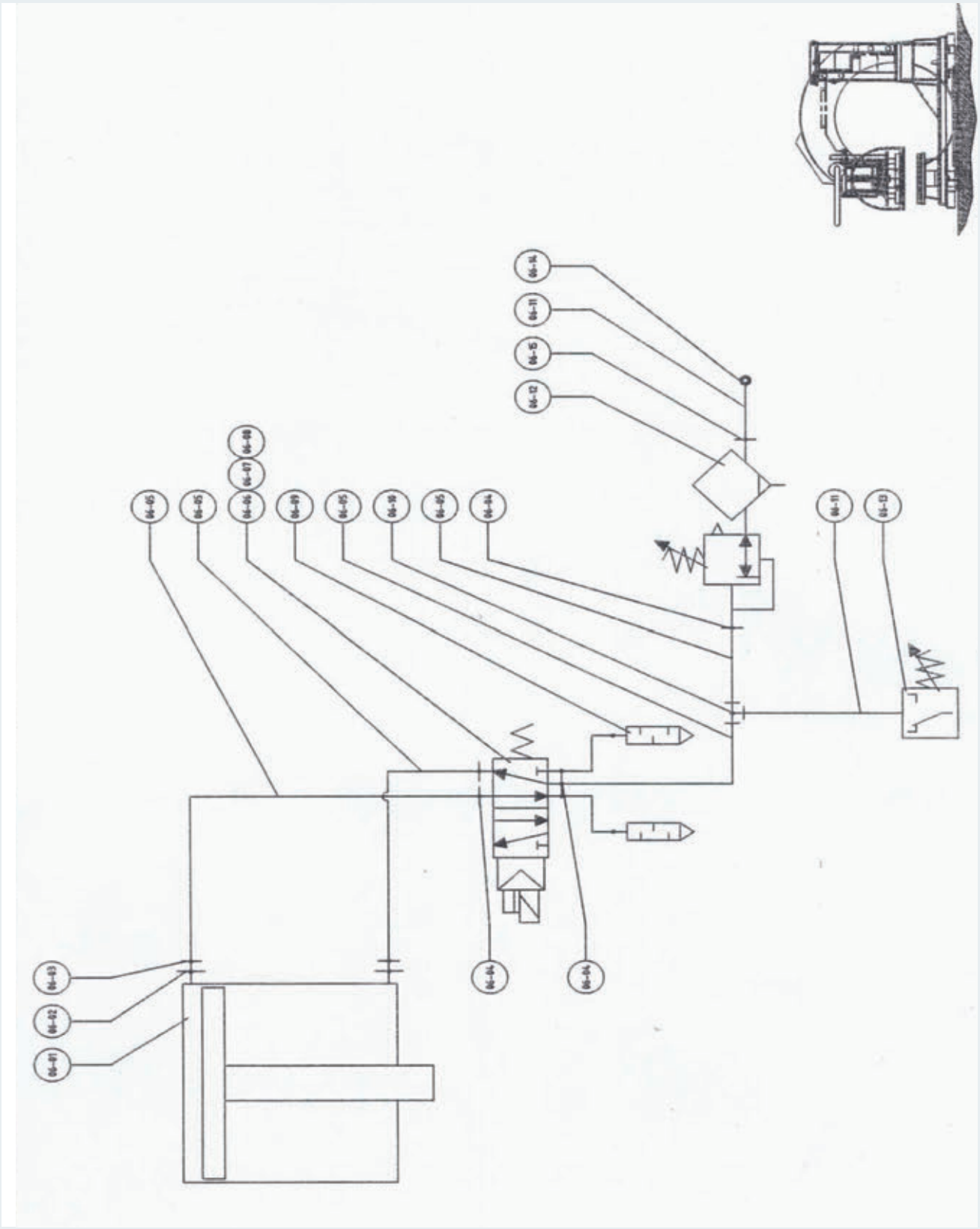


Parts List 06 for pneumatic parts

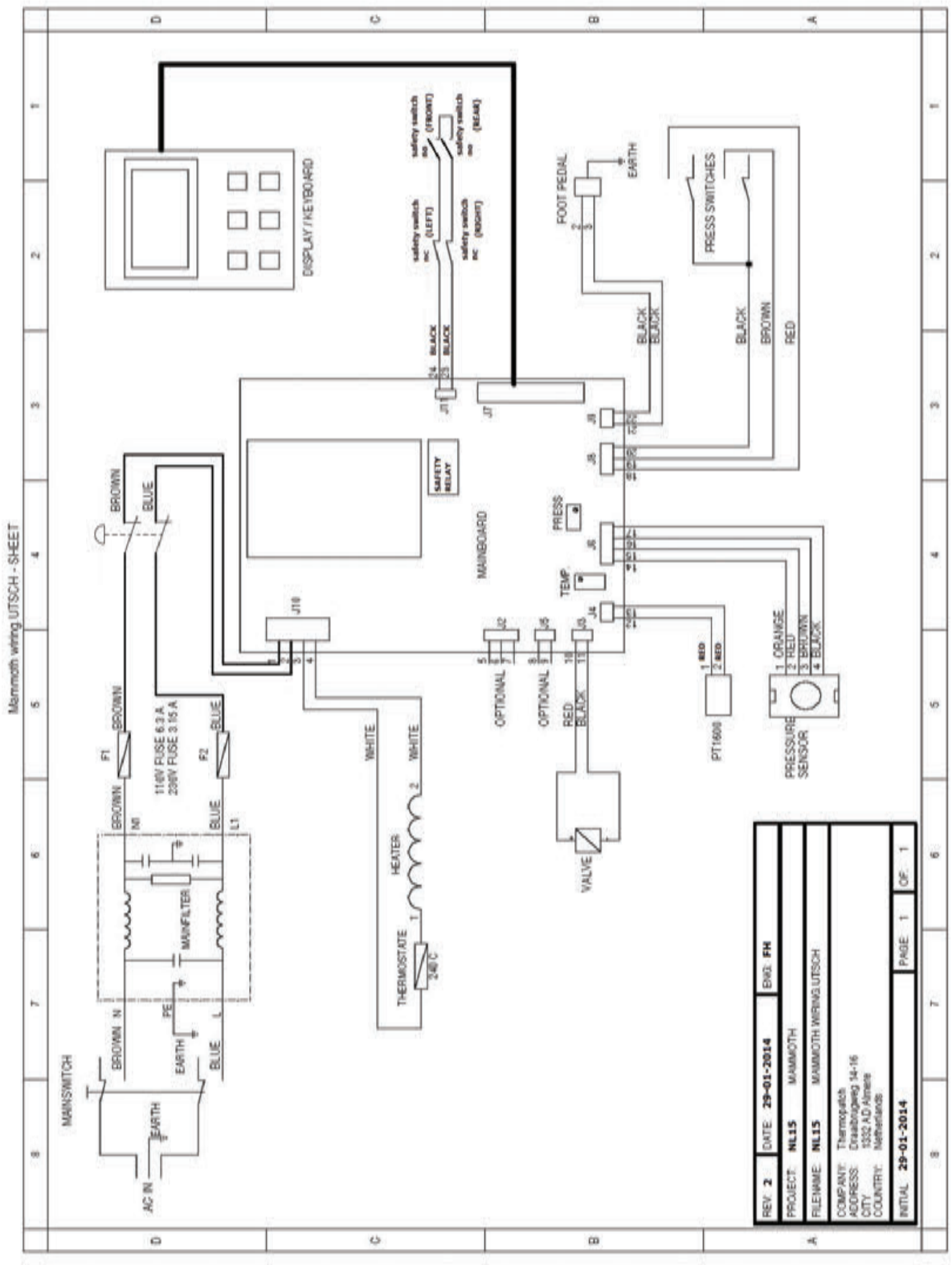
Code dwg	Description 1	Description 2	Quantity	Thermopatch Code
06-01	Cylinder Extra: XB6*Z-2668		1	SPAMA-06-01
06-02	Adapter nipple 3/8-1/4		2	SPAMA-06-02
06-03	¼"-90degr-hose4mm		2	SPAMA-06-03
06-04	5mm-90degr-hose4mm		3 + 1	SPAMA-06-04
06-05	Hose		L =	SPAMA-06-05
06-06	5/2 valve		1	SPAMA-06-06
06-07	Connector, incl. wire		1	SPAMA-06-07
06-08	Mounting plate		1	SPAMA-06-08
06-09	Silencer		2	SPAMA-06-09
06-10	T-fitting 4-4-6		1	SPAMA-06-10
06-11	Hose		L =	SPAMA-06-11
06-12	Air preparation unit		1	SPAMA-06-12
06-13	Pressure sensor		1	SPAMA-06-13
06-15	5mm-90degr-hose6mm		1	SPAMA-06-15
04-17	Sunk head bolt	M3 x 25	4	*
04-18	Nut	M3	4	*
04-19	Bracket switches		1	SPAMA 071-A
04-20	Adjustment bracket		1	SPAMA 070-A
04-21	Net entry incl. filter		1	SPA105003
SPM004	Cover, top cam		1	SPAMA 004-B

*Thermopatch does not hold stock for this item

Drawing 06 pneutics schematics



Drawing 07 Electrical schematics



10. Faults

If a problem should occur, please consult the list below; if the problem you are facing cannot be solved by yourselves contact your supplier.

Fault	Possible cause	Solutions
Heating plate does not heat up.	1. ON/OFF switch is not set to ON 2. Machine is not connected to the electricity grid 3. Electronics not connected to the machine 4. Temperature sensor defective 5. Electronics wrongly set 6. Electronics defective 7. Heating element defective	Check Check Check Check Check Check Check and replace when necessary
Heating plate is too hot or too cold.	1. Check the temperature settings	Correct
Machine opens too soon	1. Check the sealing time settings	Correct
Machine does not close	1. Pressure or temperature is not correct 2. Swivel arm is not in final position 3. Contact switch is not correctly positioned	Check Bring swivelling arm back to end position Correct
Insufficient adhesion of patches, label tapes, labels or fixing of the transfers	1. Press time too short 2. Incorrect pressure 3. Heating plate too cold 4. Press pad of lower plate worn out 5. Teflon below heating plate dirty or worn	Increase time settings by 2 seconds and check results Set pressure correctly with knob and check results Check temperature Replace Clean with soft cloth or replace
The colour of the textile penetrates the transfer	1. Temperature set too high 2. Pressure set too high 3. Sealing time set too long	Follow heat sealing instructions carefully

11. End of lifecycle

Choose to dispose of the machine responsibly when it has reached its end of life.
Electrical machinery, accessories and packaging should be recycled as much as possible in an environmentally responsible manner.

- Dismantle the machine groups: steel parts / pneumatic components / electrical components
- These can be separated and returned for recycling.

ATTENTION!

Always dispose according to current and locally applied guidelines for health and safety and disposal requirements.

12. Declarations of conformity

We,
Thermopatch B.V.
Draaibrugweg 14
1332 AD Almere
Netherlands

CE

Declare under our own responsability that the heat sealing machine:
Thermopatch NL-15 R/ SQR Mammoth, which this declaration refers to, is in accordance with the conditions of the following. Directive(s):
2014/30/EU (emc directive)
2006/42/EG (machinery directive)

Netherlands, Almere, 01-01-2021

Stephen Huyton
Business & Financial Director Thermopatch EMEA

We,
Thermopatch BV
Draaibrugweg 14
1332 Almere
Netherlands

declare that the DoC is issued under our sole responsibility and belongs to the following product: Thermopatch NL-15, which this declaration refers to, is in accordance with the conditions of the following guidelines:

- Electromagnetic Compatibility Regulations (EMC) 2016
- Electrical Equipment (Safety) Regulations (LVD) 2016
- Supply of Machinery (Safety) Regulations 2008

The Netherlands, Almere, 01-05-2022

Stephen Huyton
Business & Financial Director Thermopatch EMEA

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For any warranty Thermopatch B.V. refers to its general terms and conditions.
We can confirm that the machines we supply conform to CE when in standard configuration.
Using sealing pads of any format other than the standard supplied with the machine may render the CE declaration invalid.
Thermopatch accepts no responsibility for any damage or injury that may result from possible non-conformity.
Choosing an alternative configuration other than the standard is at the customer's own responsibility.

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