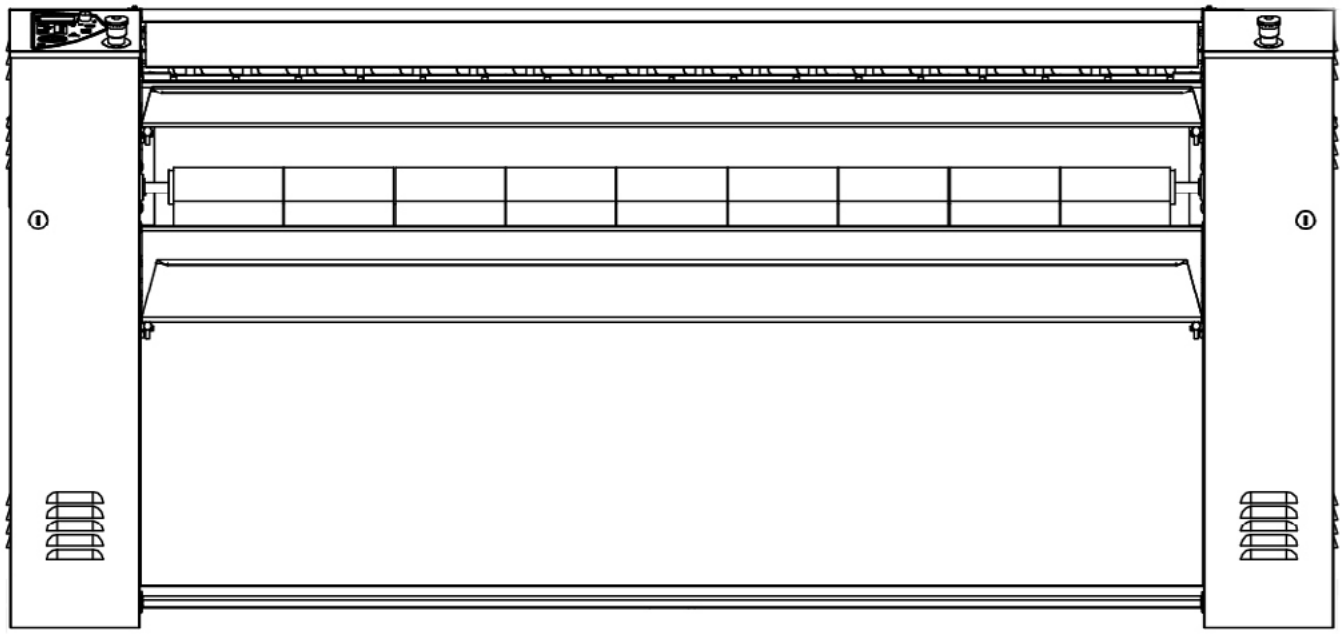
USE & MAINTENANCE MANUAL

G line



G 14.25

G 15.35
G 18.35
G 21.35
G 26.35
G 32.35

G 21.50
G 26.50
G 32.50

Before use,
Read carefully the manual

Installation must be performed by qualified engineers complying with instructions supplied in the installation manual

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DANGER!

Informs of a dangerous situation that, if not avoided, will cause death or severe body injury.

WARNING!

Informs of a dangerous situation that, if not avoided, will cause severe body injury or damage to property.

CAUTION!

Informs of a dangerous situation that, if not avoided, will cause minor body injury or damage to property.

IMPORTANT!

Informs of a procedure that, if not respected, will cause damage to appliance.

WARNING!

Failure to install, maintain, and/or operate the ironer according to the manufacturer's instructions may result in conditions which can produce body injury and/or property damage.

WARNING!

For your safety and to reduce the risk of fire or explosions, do not store or use flammable substances or substances that can generate flammable vapours and in proximity of this appliance.
Do not process with this appliance fabrics containing residuals of flammable substances.

NOTE: The DANGER, WARNING and IMPORTANT instructions appearing in this manual are not meant to cover all possible conditions and situations that may occur.

It must be understood that common sense, caution, and carefulness must be applied whenever installing, operating or servicing the ironer.

DANGER!

To prevent personal injury, fire or explosion, the ironer may only be positioned, connected, adjusted, installed, and started by fully qualified engineers.

Read the manual
prior to carrying out any operation.

TECHNICAL DATA

Model	G 14.25	G 15.35	G 18.35	G 21.35	G 26.35	G 32.35
Roller Ø	270 mm	325 mm	325 mm	325 mm	325 mm	325 mm
Roller length	1450 mm	1480 mm	1800 mm	2100 mm	2580 mm	3200 mm
Ironing speed	0,8÷3 m/min	1,6÷5 m/min	1,6÷5 m/min	1,6÷5 m/min	1,6÷5 m/min	1,6÷5 m/min
Hourly production	25 kg	43 kg	50 kg	56 kg	75 kg	80 kg
Maximum recommended moisture	50%	50%	50%	50%	50%	50%
Ironer net weight	310 kg	450 kg	490 kg	548 kg	635 kg	715 kg

Table A1

Model	G 21.50	G 26.50	G 32.50
Roller Ø	500 mm	500 mm	500 mm
Roller length	2100 mm	2580 mm	3200 mm
Ironing speed	1,6÷8 m/min	1,6÷8 m/min	1,6÷8 m/min
Hourly production electric gas steam	 75 kg 85 kg 95 kg	 95 kg 110 kg 115 kg	 120 kg 135 kg 145 kg
Maximum recommended moisture	50%	50%	50%
Ironer net weight	1200	1320	1700

Table A2

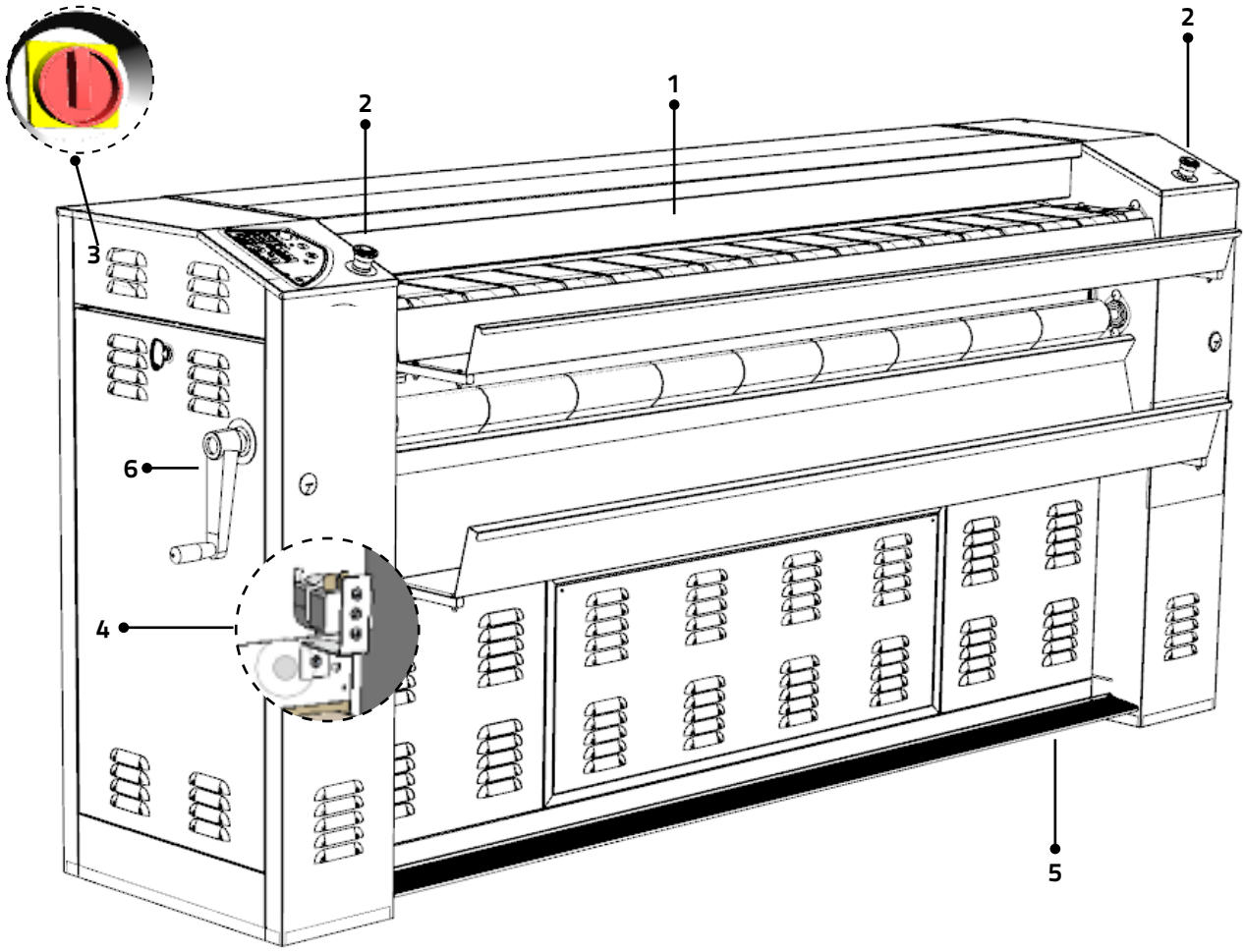
SAFETY DEVICES

WARNING!

Before starting working, control the functioning of main safety devices: finger protection bar, emergency stop buttons and foot pedal (the latter only for models equipped with this device).

In case one of these devices does not work properly, do not start ironing and immediately call a qualified engineer.

The fundamental part to operation of all the models is a heated element (cylinder). Avoid deliberate contact with points which in normal working position (hands on the feeding table/belts) cannot be reached.



1 **FINGER PROTECTION BAR**: prevents the operator's hands being exposed to the heated cylinder. By exerting minimum pressure on the bar, the cylinder stops and the ironer immediately switches off.
To begin ironing again, press start button (I) and then press the pedal.

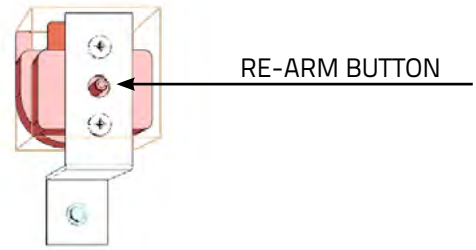
2 **EMERGENCY STOP BUTTONS**: protect the operator in an emergency condition. By pressing the red knob, the cylinder immediately stops rotating and the ironer switches off.
To begin ironing again, disengage the emergency button turning it in the direction of the arrows, press the start button (I) and press the pedal.

3 MAIN SWITCH: prevents contact with live electric circuits.

DANGER!

When the main switch mounted on the ironer is in position 0, there is still tension on the ironer supply terminals.

4 MAXIMUM TEMPERATURE SAFETY THERMOSTAT: this device provides a double check on temperature, limiting its excessive rise should the main thermostat fail.
To re-arm the thermostat, simply press the button located on the safety thermostat.



5 FOOT PEDAL: The foot pedal control also has a rapid stop function: when pressing it during working, the cylinder stops and the heating switches off (except on steam heated models).

IMPORTANT!

When cylinder temperature is above 90°C, never stop the cylinder rotation for longer than 1 minute, or the heat will damage the belts.

If you need to make a longer break, always remember to press the 0 button so that the automatic cool-down procedure will start. The ironer will then automatically switch off when 90°C are reached.

IN THE EVENT OF A POWER FAILURE

WARNING!

Turn off the main switch (3).

GAS HEATED MODELS: always close gas input valve if the event of a power failure.
STEAM HEATED MODELS: always close steam input valve if the event of a power failure.

EMERGENCY HANDWHEEL (6): to be used only in the event of a power failure, to extract linen that remained stuck between belts and cylinder during the ironing process.

IMPORTANT!

If power failure lasts for longer than 1 minute, after having taken out the linen, introduce a wet sheet (just wrung with the hands) to insulate the belts from the heated cylinder, otherwise heat will damage them.

Take the time to check the exact position of the handwheel and try the manual rotation procedure as soon as you receive your ironer, so that you will be prepared in the event of a power failure.

Manual rotation procedure is detailed in instructions labelled on the ironer door panel:

- **REVERSING MODELS: RIGHT DOOR PANEL**
- **NON REVERSING MODELS: LEFT DOOR PANEL**

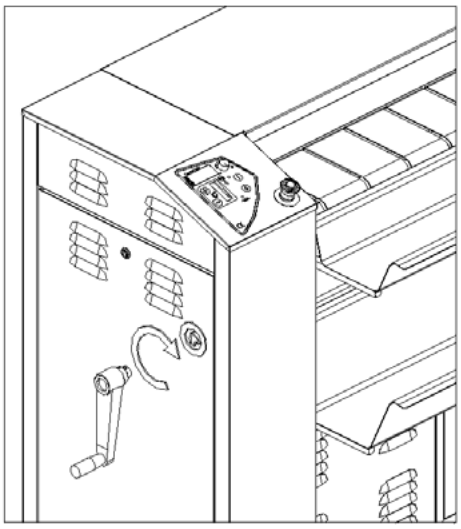
WARNING!

Remember to dismount the handwheel prior to turning on the power again.

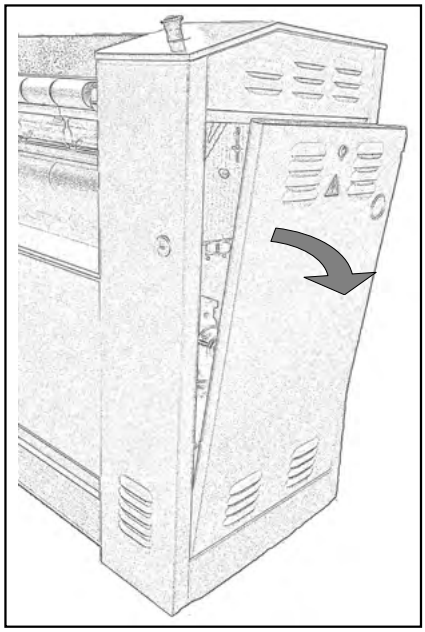
WARNING!

Only insert the handwheel after having turned off the main switch (3).

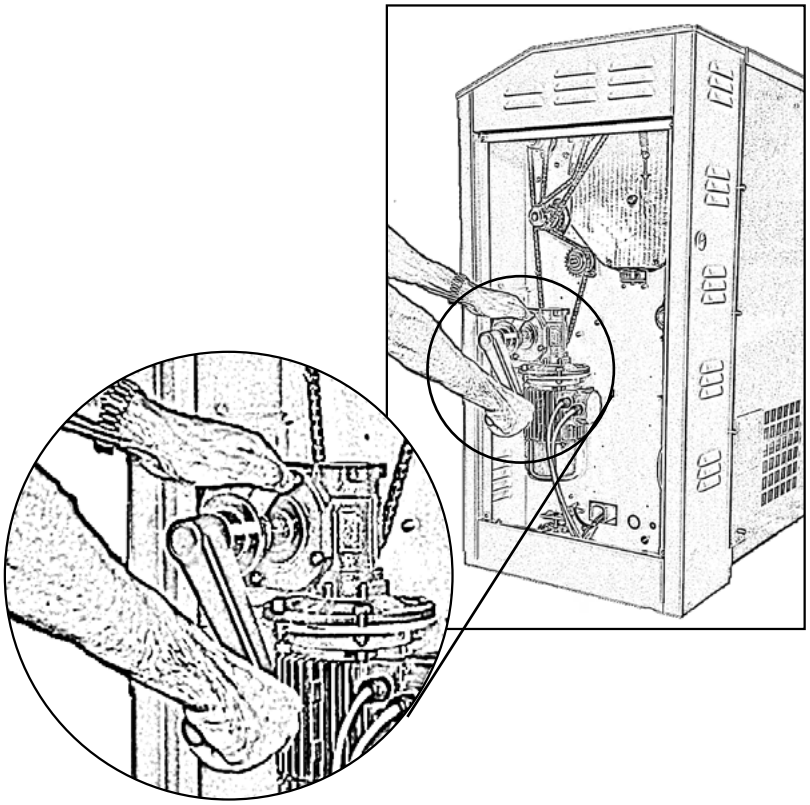
NON REVERSING MODELS



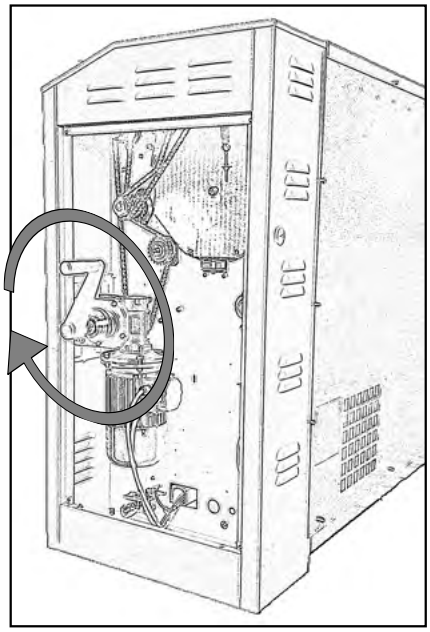
STEP 1



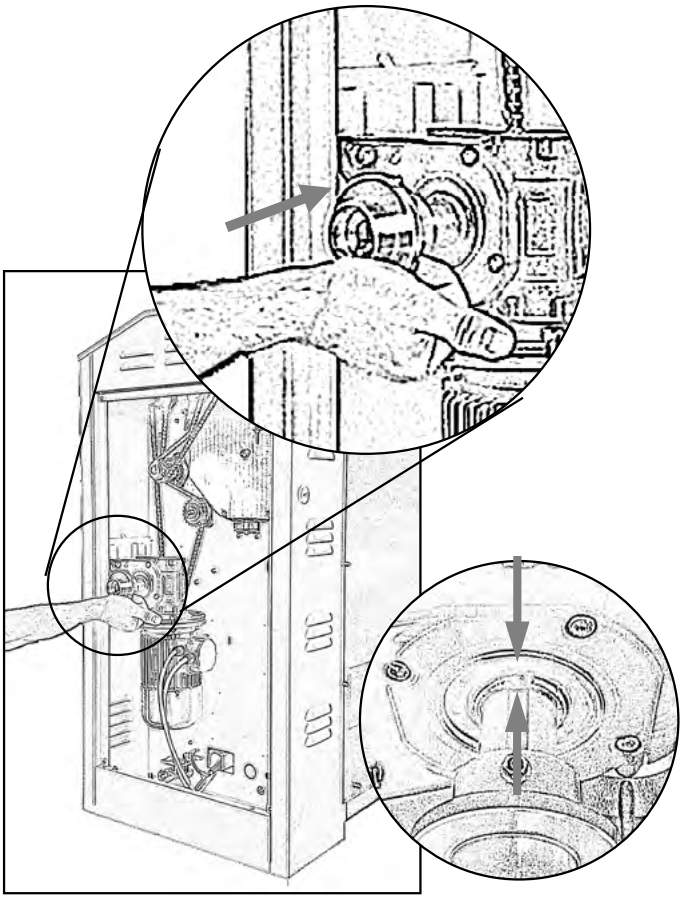
STEP 2



STEP 3



STEP 4



USE

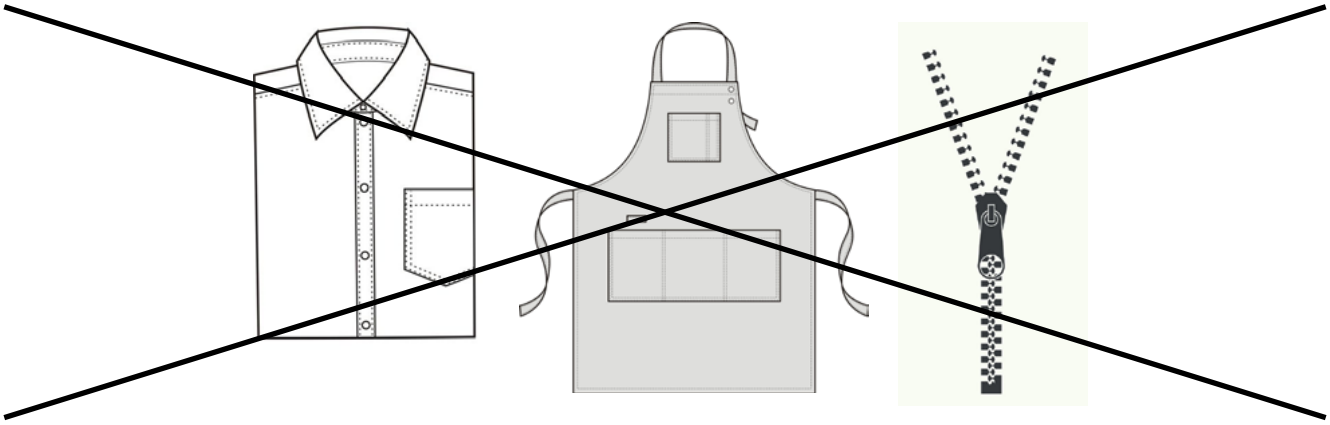
G-line industrial flatwork ironers have been designed to iron flat linen. Any other use is to be considered incorrect and therefore unreasonable.

The manufacturer cannot be held liable for any damage to things or injury to persons caused by improper, incorrect or unreasonable use.

WHAT CAN BE IRONED
Drying ironers have been designed to iron flat linen, therefore **they are not suitable to process clothes, carpets or blankets**.

IMPORTANT!

- Items fitted with ribbons, buttons or metallic zips might be damaged when processed on a drying ironer, and they might cause equipment damage, too.
- Always carefully read care label on the fabrics before starting ironing, and scrupulously follow care instructions in respect to suggested ironing temperature.
- Printed textiles should not be processed, since heat will melt the decorations, damaging the fabrics and the equipment.



PREPARING LINEN FOR IRONING
To optimize the ironer performance, and obtain best finish results, we recommend an appropriate preparation of the linen.

- Humidity content is a key factor to obtain a good ironing finish: fibres need to be humid in order to soften and predispose to be ironed.
- Do not leave washed or pre-dried linen for hours wrinkled and/or pressed waiting for the ironing phase.
  Humidity will evaporate, drying the fabric and impressing the wrinkles: it will be harder to remove them during the ironing, and this will force you using higher temperatures or working slowly.
- If because of laundry organisation reasons it is not possible to iron straight away, foresee 10 minutes dryer time to remove the spinning wrinkles and soften the fabrics.
  Then store the linen in a covered container, so that the humidity content does not evaporate and remains homogeneous for the entire load.
- When ready for ironing, prepare the linen in a trolley, unrolling and opening them.
  This last passage will allow you to feed them one after the other, saving time in the introduction phase.

HUMIDITY (MOISTURE) and FINISH
Deciding the appropriate humidity content represents a key factor to obtain the desired ironing finish.

G line can process linen with different residual humidity contents, varying from 50% down to 15-20%.
To be perfectly ironed, linen need to dry completely. Consequently, the higher the moisture content -> the slower the ironing speed.

- **High humidity content (>30%) + slow ironing speed: STIFF FINISH.**
  If the fabric structure is suitable, like in the case of linen or thick cotton, fabrics come out of the ironing process with a rigid finish.

  Very much used and appreciated for **napkins** and **table cloths.**

- **Low humidity content (<30%) + high ironing speed: SOFT FINISH.**
  In this case fibres have softened during the drying phase in the tumbler, and ironing will not add rigidity.

  This finish is typically used for **bed linen**.

CHOOSING THE IRONING TEMPERATURE
As a general rule, we should keep in mind that the lower the water content retained by the fabric after the spinning process, the faster the drying time, and the lower the temperature needed to dry.

Polyester: max. 120-125°C
This is a synthetic material, and as common experience teaches us with clothes, it absorbs very little water, drying up quickly.
Additionally, synthetic fabrics derive from plastic, so they are particularly sensitive to temperature effects.

When ironing pure polyester we should therefore precautionally use low temperatures, and never exceed 120-125 .

Poly-cotton: refer to care label
Polycotton is a very popular fibre used for tablecloths and bedding, because it absorbs less liquids than cotton, so spots don't go deep in the fibres and can be cleaned easier.

Ironing temperatures can vary quite much, depending on the cotton percentage contained in the fabric processed, and on its thickness.

Recommended temperatures can therefore space between 130 and 160°C: care label will tell you the appropriate information.

Cotton / Linen: max. 160-170°C
Pure cotton and linen can normally be processed using the highest temperatures, so 160-170°C would be appropriate.

If processing coloured fabrics, refer to care label for their resistance to temperature, avoiding fading or colour change.

IMPORTANT!
The above information represent just a generic guide and do not substitute the care label information, which should be scrupulously followed when treating your linen.

Always make sure the linen you are processing or buying are fitted with care labels.

Remember that temperatures above 150°C will increase production but could scorch linen, especially on sensitive fabrics or colours.

CHOOSING THE IRONING SPEED

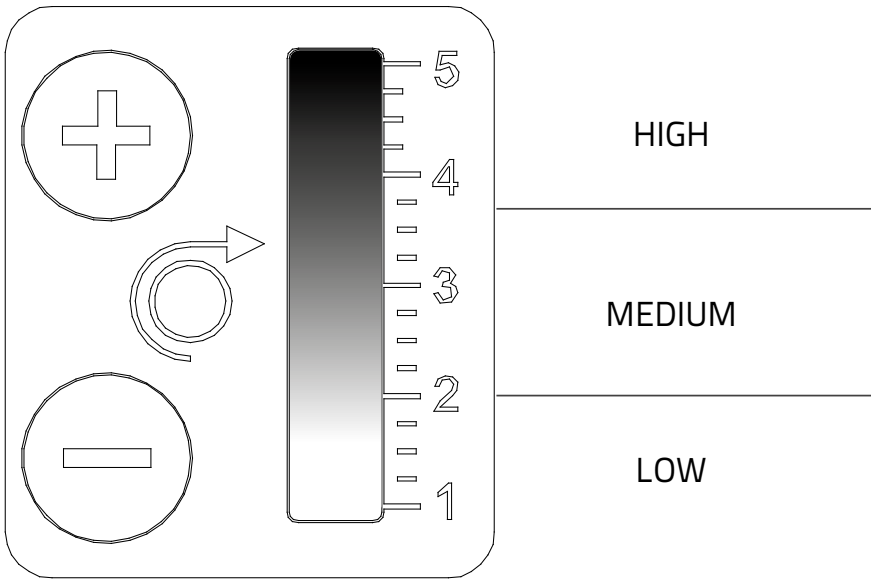
Once the ironing temperature and the humidity content have been chosen according to the fabric processed and to the finish required, the ironing speed will come as a consequence.

Ironing speed just represents the time the linen need to remain in contact with the heated surface to be perfectly dried.

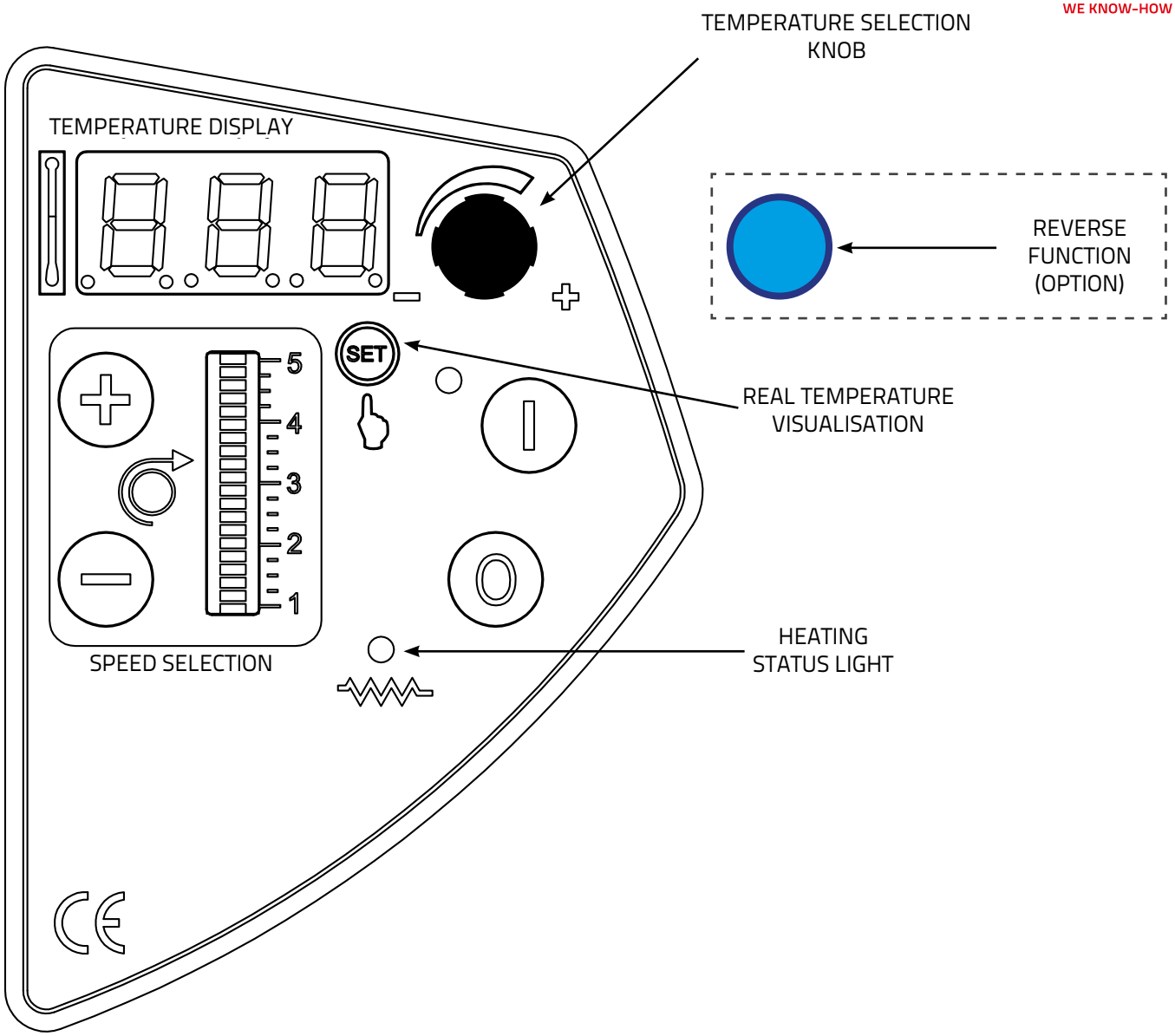
Generally ironing speed is related to fabric type: natural fibres will need to be processed slowlier than synthetic fibres, because they retain more water, which requires more time to evaporate.

We suggest starting with a medium ironing speed, and decreasing it if linen are not perfectly dry after the ironing process. In case linen coming out of the ironing process are very hot (difficult to touch with hands) or present electro-static problems, increase the ironing speed.

In fact, electro-staticity is just the result of overdrying. This means you can process your linen faster.



CONTROL PANEL



ON/OFF
To switch on the ironer, press I. The display will light up, showing last temperature/speed settings.
To switch off the ironer, press O.

SELECTING IRONING TEMPERATURE
To modify the desired ironing temperature, rotate the black knob. The display will show the selected ironing temperature.
The heating status light switches on as soon as heating is activated.

On steam heated models, the thermostat simply works as a thermometer.
In fact, the ironing temperature varies according to the pressure of the steam supplied. To change the ironing temperature, you have to change the setting of the steam supply pressure, using the steam regulator located on the steam input line.

SEEING ACTUAL TEMPERATURE
Pressing SET button, the display will briefly show the temperature detected by the thermostat sensors.
On models equipped with 2 sensors, the temperatures read by the 2 sensors will be displayed one after the other.

SELECTING IRONING SPEED
Press + and - buttons.

REVERSE FUNCTION (REVERSING MODELS ONLY)
If linen are going in skew, or if you wish to pull back the item, press the REVERSE button on the control panel till the complete extraction of the linen.
For security reasons, it is necessary to keep the REVERSE button pressed to invert the cylinder rotation. When releasing the REVERSE button, the ironer will automatically go back to the normal operating mode and the cylinder will turn forward.

OPERATION

After having set the ironing temperature, press the foot pedal. The cylinder will start rotating and the heating will be activated.

Wait until the desired temperature is reached (heating status light off) and start introducing linen.

It is always a good norm to start ironing items that require lower temperatures, and then increase the set to process items requiring higher temperature set.

At first start, or after breaks, remember that if you do not start ironing immediately, temperature will always tend to rise above the set value because of heat accumulated inside the cylinder.
If you would like to heat up the ironer to be ready for work, but are unsure about when you will be ready to start, pre-heat setting 100°C, and finally rise up the set temperature 5 minutes before being ready.
The ironer will heat up quickly, and you will save energy costs and extend belts lifespan.

IMPORTANT!

When cylinder temperature is above 90°C, never stop the cylinder rotation for longer than 1 minute, or the heat will damage the belts.

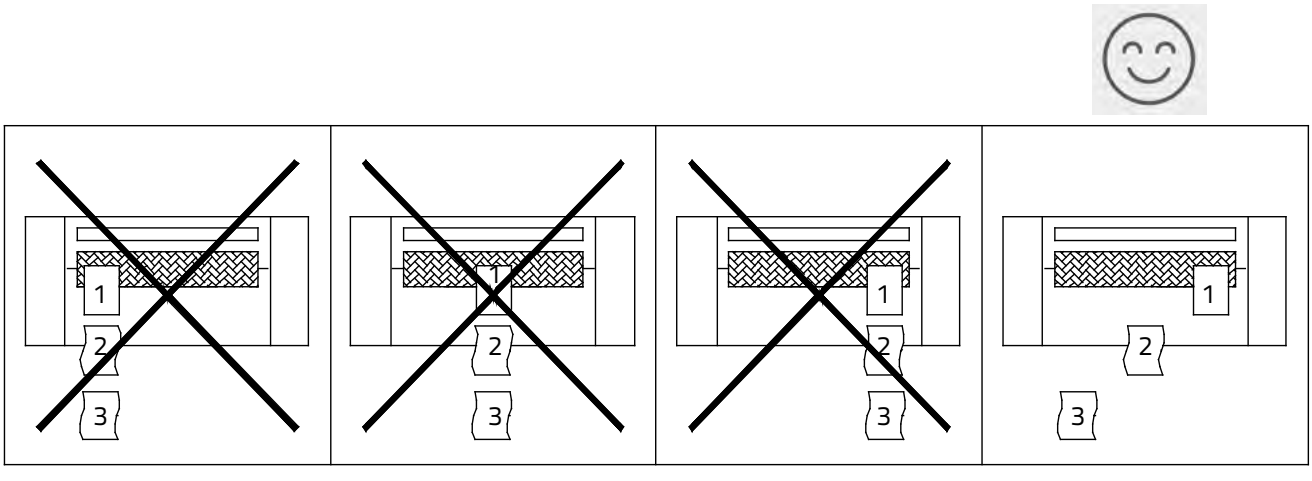
If you need to make a longer break, always remember to press the 0 button so that the automatic cool-down procedure will start. The ironer will then automatically switch off when 90°C are reached.

FEEDING THE LINEN

Understanding the importance of a correct feeding procedure represents the basics to maximize ironer performance, save energy waste, avoid overheating damage and therefore reduce maintenance costs.

The ironer cylinder is heated inside by a system that gives same energy to all its points. When ironing, it is therefore important to subtract homogeneously the temperature from the cylinder, continuously changing the introduction point and not forgetting side spots.

Following the simple below schematic will ensure a homogeneous temperature all over the ironing surface.



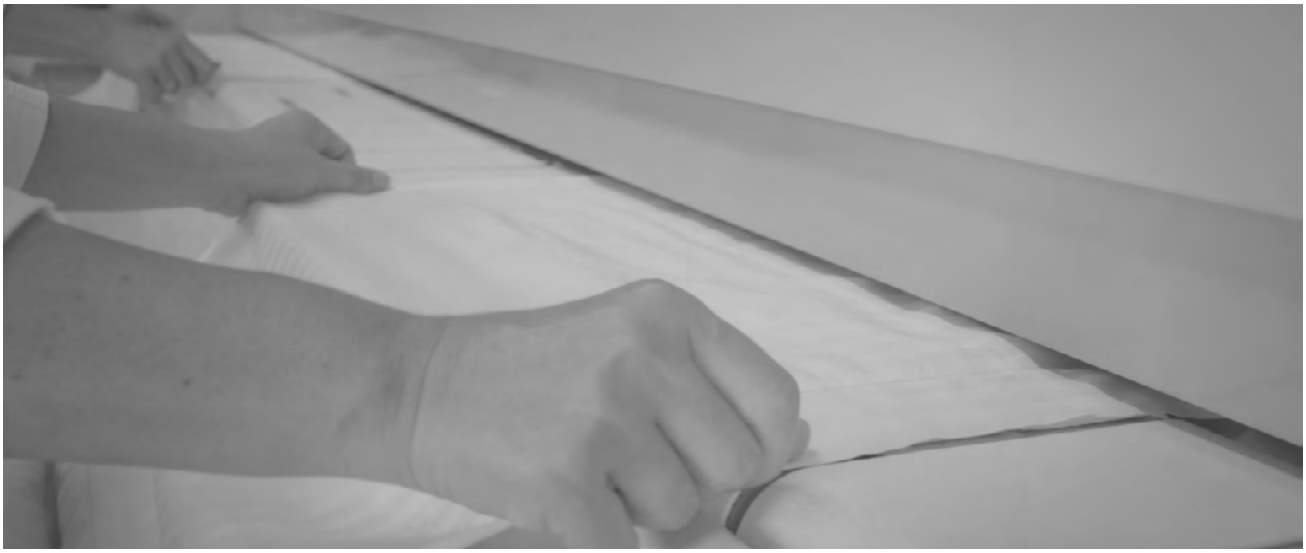
HINTS & ADVICES

The following advices will help you in obtaining the best ironing finish with the minimum effort.

FEEDING
Feeding phase is particularly important to obtain a smooth ironing: make sure linen upper edge is parallel to the finger bar, and avoid skew introduction.

When feeding linen, do not pull them toward yourself to keep them tightented. The pressure roller installed on the ironer already makes this function, and additionally pulling would deform linen and damage pressure roller covering in the time.

Just keep linen "open" by tightening them gently with your hands on the sides.



SMALL ITEMS (napkins, small table linen)
Position the item over the feeding belts. The belts will not take immediately the item, giving you the possibility to adjust if skew, just pulling it slightly from the sides.

LONG ITEMS (bed sheets, big table cloths)
If you need to fold the items for ironing, we recommend preparing them before starting ironing, making sure they are well folded. When feeding them, ensure the two parts remain in place and do not slip one over the other.

If you work with the help of another operator, position the item over the feeding belts, and if necessary stop the rotation by pressing the foot pedal, till you are sure the item is parallel to the finger bar. At this point start feeding.

CAUTION !

Linen ironed using the higher temperatures can be very hot out of the ironing process.
In such a case, use appropriate protection gloves for the hands.

PROCESS
Make sure linen are well rinsed after the washing cycle prior to the ironing.

Linen containing soap residuals will be more difficult to iron and will lead to deposits building up on the cylinder surface, which is going to require cleaning and maintenance in a shorter time span.
If linen out of the washing process are sticky, this means they still contain detergent residuals.
In this case, double-check detergent quantity taken by the washer during the wash cycle, and if this is correct, improve the rinse phase.

Starch should not be used when processing linen with a drying ironer.

If water used is particularly hard, foresee regular cylinder cleaning with your service team.

SWITCHING OFF THE IRONER

Press 0 button on the control panel to activate the automatic cool-down procedure (display shows "cooling").
Close the gas/steam valve.
Continue feeding the linen to lower the cylinder temperature, or let the ironer cool-down: the equipment automatically switches off when the safe temperature of 90°C is reached.

IMPORTANT!

Interrupting the cool-down procedure and stopping the cylinder when its temperature is above 90°C will damage the belts and the pressure roller.

For models with polished cylinder: always make sure that ironing belts are completely dried before switching off the ironer at the end of the working day: this will help in avoiding corrosion issues.

CAUTION!

Always turn off the circuit breaker before leaving.

CYLINDER CARE (models with polished cylinder only)

If you have chosen a polished cylinder version, the ironer cylinder is not coated and therefore it is sensitive to oxidation (corrosion).
Oxidation can be generated by humidity, salinity or detergent residuals. The best way of protecting the surface from oxidation is making sure linen is well rinsed and more important, that ironing belts are perfectly dry before switching off the ironer.

Completing the cool-down phase (which automatically starts when you press the 0 button to switch off) definitely helps, but as a precaution always make sure the belts are dry at the end of the cool-down.

A paraffin coating should be regularly applied to the cylinder with the purpose of protecting it from the oxidating effects of detergents residuals, humidity and air.
This is particularly important for production stops lasting more than a few working days. At season shutdown accurately clean the roller surface and apply a protective paraffine coating.

IMPORTANT!

Only use high-temperature resistant paraffin.

INFORMATIVE MESSAGES

SOFTWARE CODE
When you connect electric power to the ironer, the display shows for a while the software code used for the specific equipment and then switches off, waiting for the ironer to be switched on with the **I** button.

Software code starts with:
- G25
- G35
- G50

and does not represent an error message. This is just an informative message.

COOLING
When switching off the ironer, the thermostat will detect the cylinder temperature and if this is above the safe level (90°C), the ironer will automatically start the COOL-DOWN process.
The cylinder will continue turning till temperature drops to 90°C, then the ironer will automatically switch off.

During the cool-down phase, the display shows "Cooling".

ERROR MESSAGES

ER6
Foot pedal just needs a touch to start cylinder rotation, and a touch to stop it.
If you keep foot pedal pressed for too long, then display will show ER6.

Solution: remove object pressing over the foot pedal, or stop pressing it.
If not solved, call for service.

ER7
Activating the emergency stop button, the ironer switches off completely.

It has to be switched on again by the operator pressing the **I** button. If the emergency button has not been released before switching on the ironer, the display will show Er7.

Solution: disengage emergency stop button.

Err
Activating the finger bar, the ironer switches off completely.

It has to be switched on again by the operator pressing the **I** button. If the finger bar has not been released before switching on the ironer, the display will show Err.

Solution: disengage the finger bar.

IMPORTANT!

Use emergency devices only in real danger conditions.

At the end of the work cycle, only use 0 button to switch off the ironer. This will ensure automatic cool-down procedure starts and will avoid irreparable damages to ironing belts and other components due to high temperatures.

rSt (gas heated models only)
If the burner ignition does not succeed at first attempt, the alarm message "rSt" will be displayed.

Solution: make sure gas input valve is open. Press the **I** button to reset the electronic ignition and make another couple of trials.
If not solved call for service.

tE (models with 2 temperature sensors only)
The display shows this message when the thermostat sensors detect a temperature difference between each other higher than 60°C. This means linen are introduced always in the same place and a part of the cylinder is overheating.

In this situation, the ironer goes in protection mode and automatically switches off the heating to avoid belts damage.

Solution: feed the linen continuously switching from left to right, so that the ironing surface is homogeneously used. The heating will be activated again automatically once the temperature difference between the sensors go below 60°C.

ERROR MESSAGES NEEDING YOU CALL FOR SERVICE

ER1, ER2, ER3, ER4
These error messages are displayed when an error occurs in reading the temperature.

Solution: call for service.

ER8
When the serial communication between the I/O board and the display board is interrupted, the display shows Er8.

Solution: call for service.

Prb
Brass plate supporting thermostat sensors has worn out, or safety wiring has been accidentally misplaced during work.

Solution: call for service.

Display blinking and beeping (gas heated models only)
Burner ignition cannot be completed.

Solution: call for service.

MAINTENANCE

DANGER!

When the main switch mounted on the ironer is in position 0, there is still tension on the ironer supply terminals.

Before any maintenance intervention:
- Turn off the circuit breaker or unplug the ironer
- Make sure the ironing cylinder is cold (ideally carry out maintenance in the morning, before starting any work cycle).

WARNING!

Any work on mechanical parts and the electrical system must be carried out by fully qualified personnel. Contact your service team in case such interventions are required.

Under normal working conditions, G ironers require a minimum but regular maintenance.

Lint is the real enemy in the laundry, so ensuring to keep ironer clean from lint will extend lifespan of the equipment and reduce maintenance costs.

While some interventions can and should be carried out on a regular basis directly from the operator, we recommend agreeing a programmed maintenance agenda with your service team for the periodical inspections of internal components.

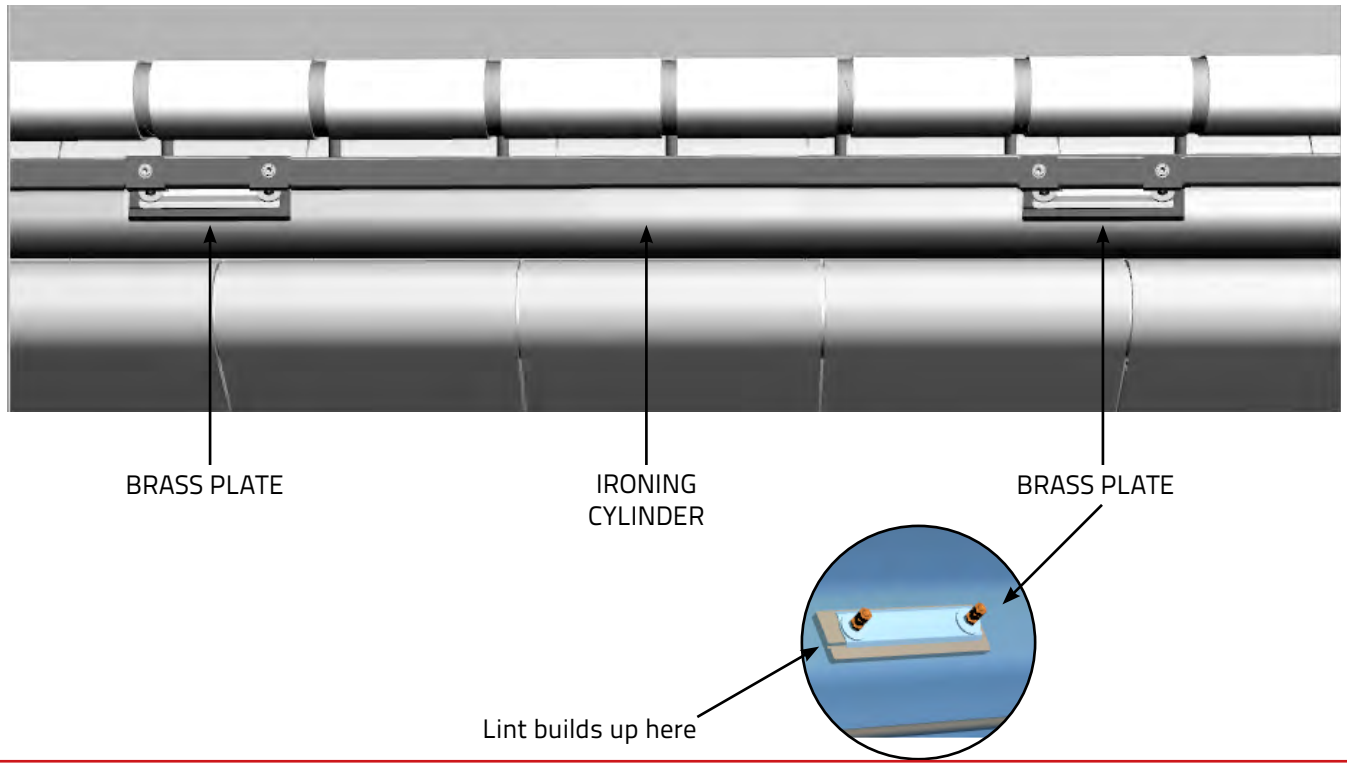
WEEKLY MAINTENANCE

BRASS PLATE CLEANING
Clean the brass plates supporting the thermostat sensor, making sure it is free from lint build-up. This operation is very important, because lint delays transmission of temperature from the cylinder to the thermostat sensor, generating overheating.

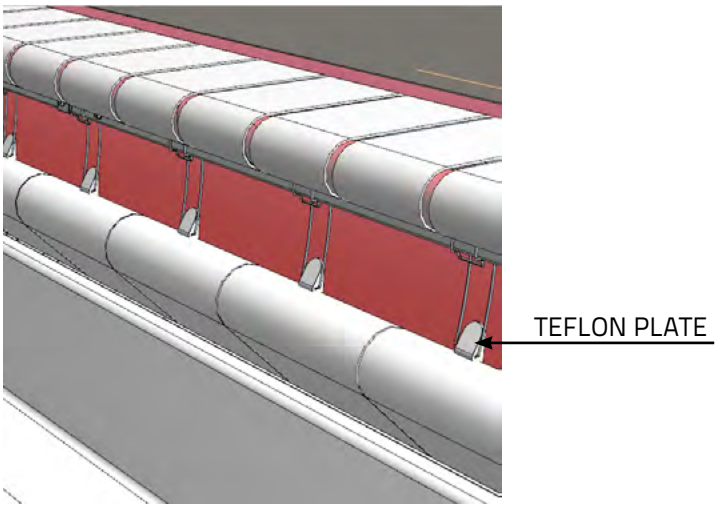
To clean the plate, lift it up gently and wipe the lint. Reposition the plate.

IMPORTANT!

When repositioning the plate, make sure that it is well adhering to the cylinder surface. A perfect contact is fundamental to ensure a correct temperature reading and to avoid overheating.



DETACHING LINEN PLATES CLEANING
Clean the teflon plates that avoid linen remain stuck on the cylinder and enter again into the ironer.
Make sure the teflon plates are free from lint build-up: lift the plates gently and wipe them.
Reposition in place.



EXHAUST HOOD CLEANING (G.50 models only)
Using a vacuum cleaner, clean the exhaust hood.

MONTHLY MAINTENANCE

EXHAUST MOTORS CLEANING
Using a vacuum cleaner, clean the area around exhaust motors and filters on models provided.

GENERAL CLEANING
Using a vacuum cleaner, remove accurately the lint from the internal part of the side panels. You need to take off the doors to carry out this operation.

DANGER!
When the main switch mounted on the ironer is in position 0, there is still tension on the ironer supply terminals.

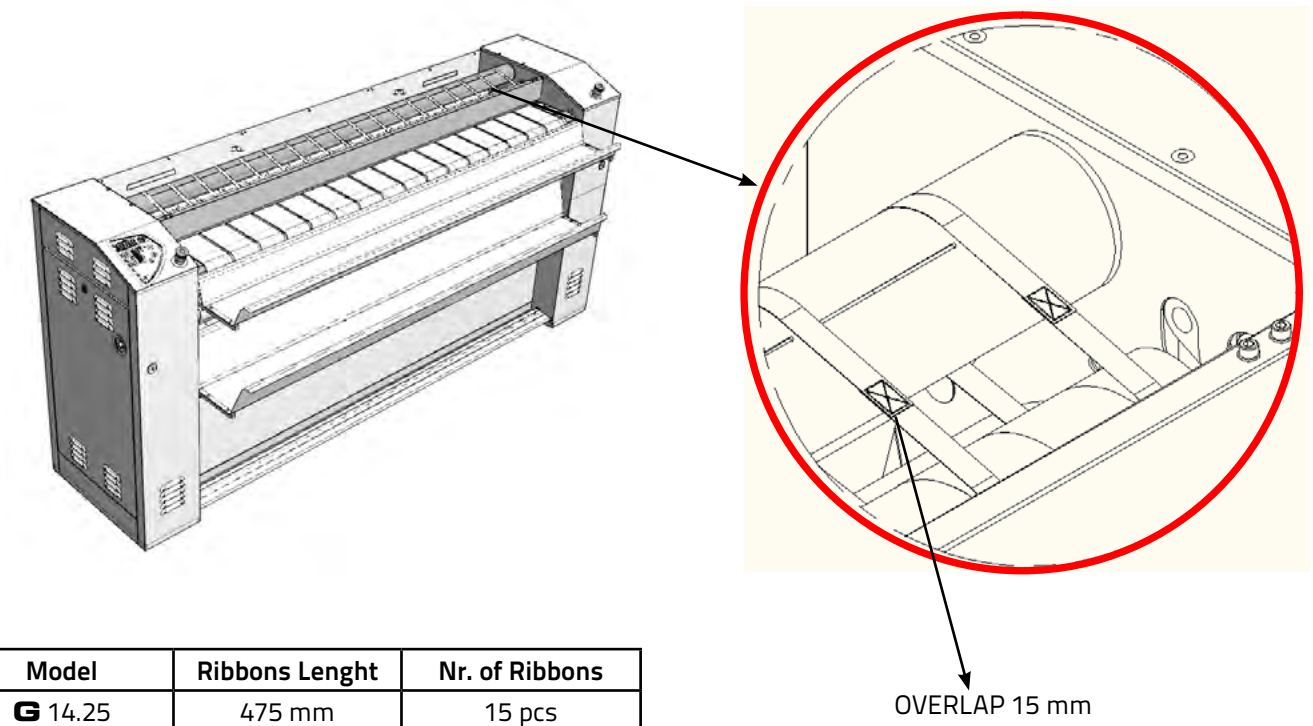
TURN OFF the circuit breaker before carrying out this operation.

More generally, it is a good practice to keep the area around the ironer clean from lint: this will allow longer breaks between general cleanings and will avoid lint building up in the internal components.

RIBBONS CONTROL

Double-check that ribbons are in good conditions and that none of them is missing. If some are missing, add them: cut the ribbon (p/n 035039R) at desired length and position it in place.

Overlap the two extremities for about 15 mm, and glue them using the specific high-temperature glue (p/n 5010328). Keep them pressed together using a clothes pin, and let glue dry 8 hours before activating heating again.



Model	Ribbons Lenght	Nr. of Ribbons
G 14.25	475 mm	15 pcs
G 15.35	475 mm	15 pcs
G 18.35	475 mm	18 pcs
G 21.35	475 mm	22 pcs
G 26.35	350 mm	26 pcs
G 32.35	548 mm	30 pcs
G 21.50	385 mm	22 pcs
G 26.50	385 mm	26 pcs
G 32.50	385 mm	32 pcs

TROUBLESHOOTING

You will find a quick answer to the most frequent questions in the below troubleshooting scheme.
You might find a quick help going through this chapter, before calling for service.

Problem	Possible Reasons	Solution
ERRORS OR DISPLAY BLACK		
When pressing the **I** button, display does not switch on.	Main switch is not ON.	Turn on the main switch.
When pressing the **I** button, display shows an error message, blinks or beeps.	Safety device activated, or failure.	Refer to paragraphs "Informative Messages" and "Error Messages".
HEATING PROBLEMS		
The ironer is not heating, and the heating light on control panel is not on.	The actual temperature is higher than the set temperature. The cylinder is not turning. The safety thermostat has been activated.	Increase set temperature. Press pedal to activate cylinder rotation. Re-arm safety thermostat.
The ironer is not heating, but heating light on control panel is on.	Heating system failure.	Call for service.
FUNCTIONING PROBLEMS		
Upon pressing pedal, cylinder does not rotate.	Mechanical/electrical failure.	Call for service.
Yellow/brown stripes on the linen.	Incorrect ironing temperature. Uneven use of the ironing surface.	Reduce ironing temperature. Alternate linen feeding, following instructions given in the paragraphs "Use" and "Operation".
Yellow spots on the linen.	Detergent residuals turning yellow with high temperature.	Check detergent quantity taken during wash cycle, and rinsing phase.
Ribbons keep breaking.	Items with ribbons are fed (e.g. aprons). Excessive traction when feeding.	Items with ribbons should not be ironed. If you want to iron them, make sure ribbons will be introduced last, facing the operator. Do not pull the linen while feeding.
Squeaking noise.	Possible wax/detergent residuals built-up below the brass plates sustaining temperature sensor, or below detaching-linen teflon plates .	Clean brass plates/detaching-linen teflon plates, following instructions given in the paragraph "Maintenance".