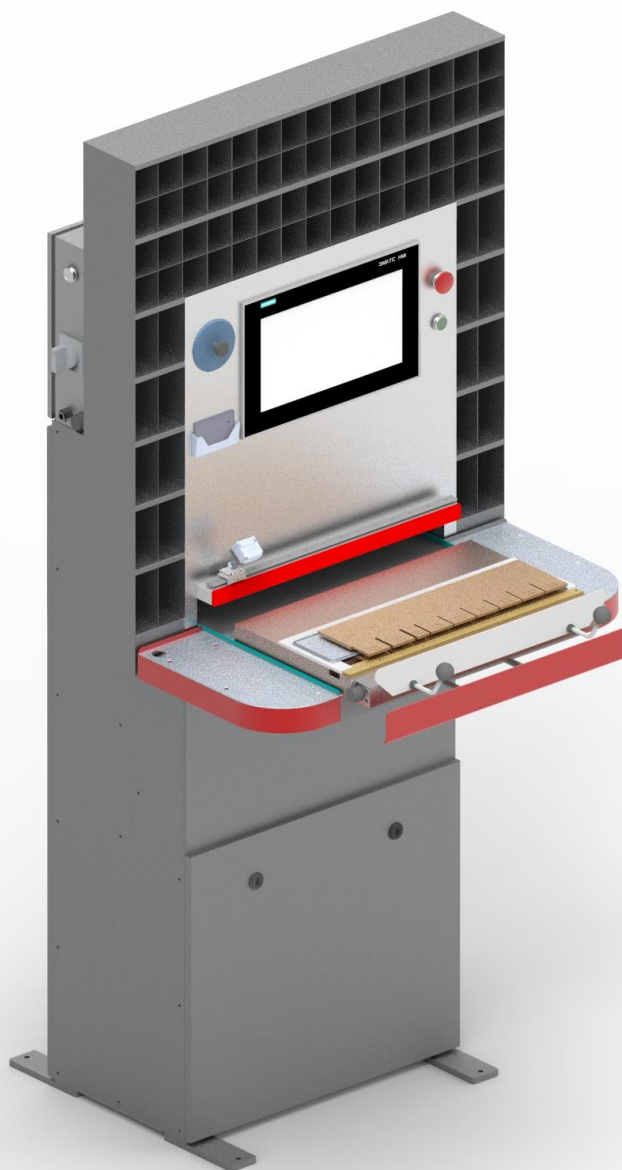


# NFC Secure Plus PRESS FOR EMBOSSING LICENSE PLATES



## INSTRUCTION MANUAL

Poznań – Gruszczyn

Date: 25.03.2023

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## 1. Introduction

This Instruction Manual contains important safety information and tips marked by the following symbols:

**WARNING!**

This symbol warns against the danger of destroying or damaging the machine.

**WARNING!**

This symbol warns against the risk to your or other people's health when operating the machine.

**WARNING!**

This symbol warns against the electrical voltage dangerous to human life. It also indicates the work that has to be performed by a specialist.

**WARNING!**

This symbol indicates information and tips for the economical and power-efficient use of the machine.

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## 2. Specifications

15" HD(720p) widescreen touch panel

Barcode / 2D-code scanner

User Identity Card reader

Multi-color status indicator lamp

Pressure adjustment knob

Embossing time: ~ 2s

Power supply: ~ 230 V, 50 Hz

Weight: ~ 490 kg

Dimensions (height × width × depth): 1900 × 850 × 840 [mm]

Connection to the LAN network Wired LAN only, use min. Cat5e RJ45 ethernet cable

Types of user login card supported Nxp Mifare Classic 1k (ISO 14443-3A),  
ISO 15693, Legic Prime, Legic Advant

### 3. General Rules



#### **WARNING!**

Failure to follow these safety instructions may result in physical injuries and press damage. In addition to following the guidelines in this Instruction Manual, keep in mind all other generally applicable health and safety regulations, including those regarding workplace accidents.



1. Maintenance and use of the press are only allowed after this Instruction Manual has been read.
2. The press should be used according to its intended use described in this Instruction Manual.
3. The press should be operated only by qualified and trained staff.
4. Operation, maintenance and repairs can only be carried out by appropriately qualified and trained staff.
5. Any modifications or changes to the mechanical assembly, hydraulics and electrical installation require the consent of UTAL, otherwise the manufacturer shall not be held liable for proper functioning and operational safety of the machine.
6. Apart from the special drawer designed to emboss the license plates, font stamping dies and the license plates themselves, it is forbidden to place any materials or parts on the surface of the work bench.
7. Storing any products in the vicinity of the machine should not restrict the access to it or its normal operation.
8. Setting pressure values on the pressure controller higher than these recommended in this Instruction Manual is strictly forbidden.

## Transport Damage

UTAL shall not be liable for damage or loss in transport. Right after the press has been delivered, check the product over and report any damage to the last shipping company, even if the packaging itself is intact. In order for the requirements of the shipping company to be met, we recommend to leave the machine in the condition when the damage has been identified. All other complaints should be submitted to the manufacturer within 6 days of the product delivery.

## Repairs

The main technical data on the product may be found on the data plate. UTAL provides a service hotline which is at your disposal. Call +48 61 817 37 02 to get your questions answered.

## Transporting the Product

The press may be transported using a fork-lift truck or a crane. If the press is screwed to the palette, it will have to be lifted by the palette. If it is screwed to the bench, it should be lifted by means of forks.

Transporting the machine with the use of a crane should be carried out only when it has been secured with cargo belts which are strong enough. Lifting the press with belts may be done only by fixing the belts to the upper beam of the press after the protective cover at the back has been unscrewed.

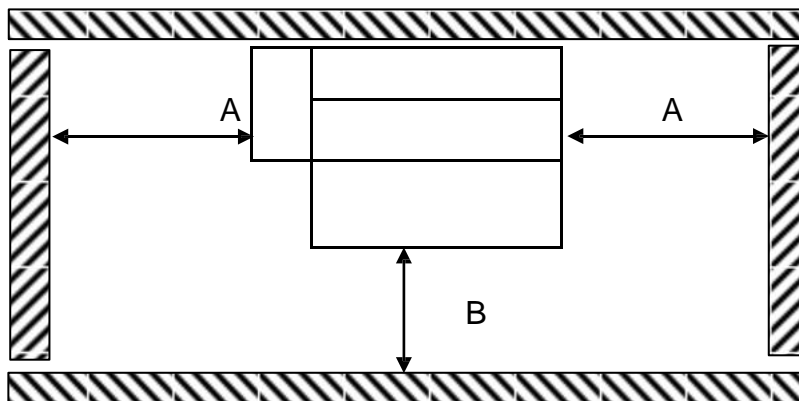


### **WARNING!**

The press should be transported in a vertical position due to the danger of hydraulic oil spill through the vent holes in the plug of the hydraulic oil container.

## Machine Room

The room where the product is intended to work should be clean, dry and dust-free. The surface under the press should be stable. Operating temperature range: from +5°C to +40°C.



It is recommended to keep the following minimum distances:  $A = 0.5\text{ m}$ ,  $B = 1.5\text{ m}$

## 4. Description of the Machine

### General description

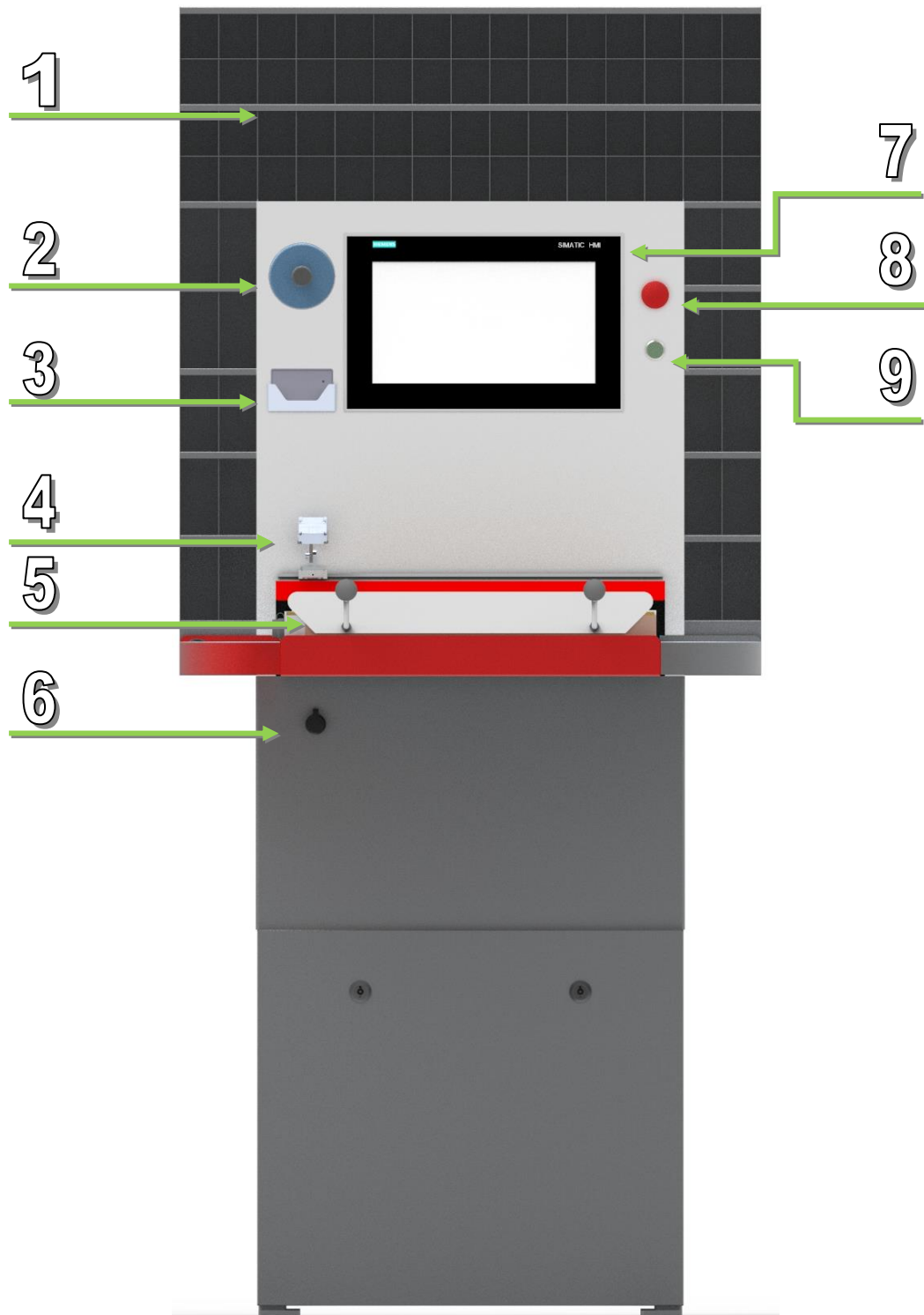


Figure 1. NFC Secure Plus press - front view



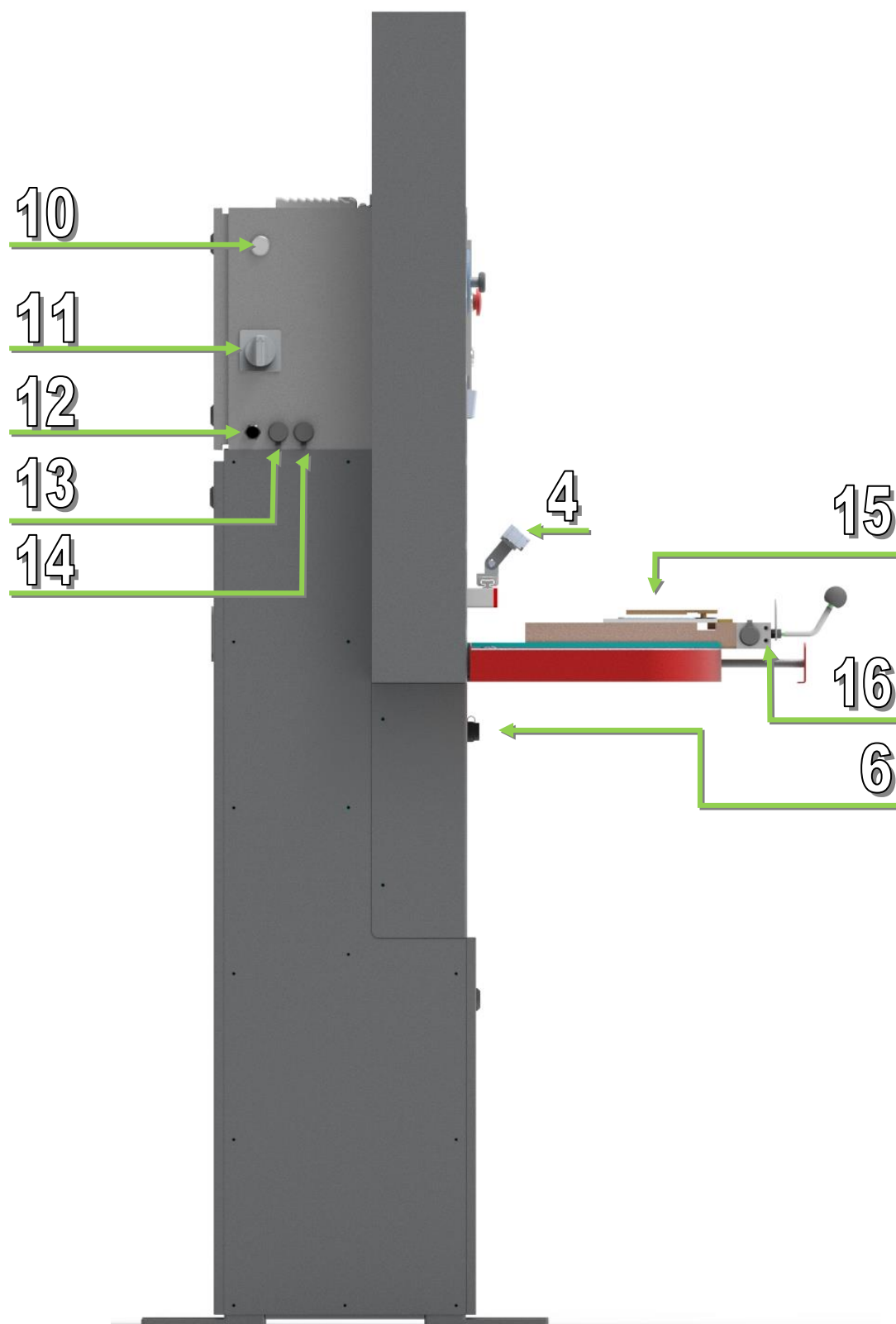


Figure 2. NFC Secure Plus press - left view

1	Font storage	6	Drawer connection socket	11	Power supply switch
2	Pressure control	7	Operating screen	12	Power cord
3	User card reader	8	Emergency stop button	13	RJ45 LAN socket
4	Barcode / QR reader	9	Start button / Status lamp	14	USB socket
5	Drawer	10	Power indicator	15	Fonts
				16	Drawer connection socket

### 1. Font storage

Storage for clapper dies helps keeping them organized and easy accessible.

### 2. Pressure Control

The pressure control is used to adjust the operating pressure of the machine. The pressure, depending on the type of the license plate, should be within the limits specified in the table below:

Plate/Dimensions [mm × mm]	Pressure [bar]
One-row / 114 x 520 Two-row / 214 x 305	160–165
Motorcycle / 150 x 190 Moped / 114 x 140	80–90



#### WARNING!

The maximum pressure set with the pressure control must not exceed the value of **165** bar. Setting higher pressure may lead to damage of the hydraulics and the pump or the electric motor



#### WARNING!

Too high pressure will lead to premature wear of the embossing dies.

### 3. User card reader (optional)

The card reader is used by the operator to log into the system. Each operator should have their own card, which they should use each time before starting work. Each time a license plate is embossed, the user ID logged in the moment of embossing is stored within the database which enables the monitoring.

**4. Barcode / QR code / DMC code reader (optional)**

The reader serves the function of decoding information contained in the various types of data codes, such as barcode, DMC (Data Matrix Code) or QR code from the license plates. Subsequently, this piece of information together with the number of the embossed license plate is saved in the IT system. In order to ensure the correct operation of the reader, it should be set in such a position so that the green rectangle is in the centre of the scanned code. The optimal scanning distance depends of the size of the scanned object (the maximum of its width and height).

**5. Drawer**

Drawer is used for placing clapper dies on defined spots to emboss a proper plate pattern. It is equipped with NFC reader which detects fonts placed on a drawer and compares them with order downloaded into production system.

**6. Drawer connection socket (press side)**

This RJ45 socket is used to connect the drawer with the press using standard Cat5e Ethernet cable (straight wiring) – the socket on the drawer side is marked as (16).

**WARNING!**

Never try to connect anything other than the drawer to the drawer connection socket. Failure to follow this instruction may lead to permanent equipment and press damage.

**7. Control Panel**

The control panel is used to control the operation of the machine. It can display the current status of the machine or be used to select orders to be processed, etc.

**8. Emergency Stop Switch**

The emergency stop switch disengages only the systems controlling the press. It does not cut off the power supply to the press. Use this switch whenever there's a need to break operation of the machine immediately.

**WARNING!**

Using the emergency switch does not turn off the press. In order to use the machine economically and power-efficiently, it is necessary to turn it off with the power supply switch after the work has been finished.

## 9. Start Button & Status lamp

The start button with integrated multi-colour machine status lamp is located next to the operating screen. The status of the machine can be recognized by checking the colour of status lamp.

<b>Lamp off</b>	Machine is most likely turned off or the Emergency Button is pressed. If the Emergency Button is not pressed, machine is turned on (Power indicator (8) is lit) and the Status lamp is off it can mean that the internal +24VDC supply is broken. If that's the case, please switch the machine off and contact UTAL for further instructions. In this state the font reader is not supplied with power, so the machine isn't able to recognize fonts.
<b>Lamp blue</b>	Internal 24VDC is waiting to be applied to the control section of the machine. The Emergency Button is pulled out and the operator is asked to reset the control circuit by pressing the button integrated with the lamp. The font reader power supply is still not active in this state.
<b>Lamp red</b>	The machine is engaged, but the press is not ready to embossing process. There are still some embossing conditions that are not met – look further in this instruction how to check which embossing condition is missing. The font reader should be operating normally in this state.
<b>Lamp green</b>	Machine is now ready to emboss the plate – all embossing conditions are met. Inserting drawer with plate and fonts to the press will trigger the start of the embossing process.

## 10. Power indicator

This lamp indicates the presence of supply voltage within the control cabinet. Typically, the lamp should turn on immediately after switching the power supply to the machine using Power supply switch (11). If there's no illumination on the power indicator after the Power supply switch has been turned on, it most likely means, that the power supply to the machine is broken – e.g. machine is not plugged in to the socket.

## 11. Power supply switch

On ("I")/Off ("O") switch to turn the machine on and off.



### WARNING!

Make sure that the power supply switch is in OFF position before plugging in or plugging out the power cord. Failure to follow these instruction may cause the machine to break down or risk of electric shock.



### WARNING!

The press should be turned off after the work has been completed in order to ensure economical and power-efficient operation.

**WARNING!**

Due to the risk of electrocution, the maintenance of the electrical installation should be performed only by qualified and appropriately trained staff.

**12. Power cord**

The machine has been designed to be supplied with power from ~230 V/50 Hz mains.

**WARNING!**

Make sure that the Power supply switch is set to position Off before plugging in the power cord to the socket.

**WARNING!**

The machine should be permanently connected to the power supply with the main power switch in the “ON” position. Frequent turning off of the machine at its mains supply or setting the main power switch in the “OFF” position may cause permanent damage of the circuitry!

**WARNING!**

Due to the risk of electrocution, the maintenance of the electrical installation should be performed only by qualified and appropriately trained staff.

**WARNING!**

Modifying the electrical system in any way is not permitted. Any repairs are to be carried out only by the service engineers. Failure to follow these instructions violates the warranty terms.

**13. Ethernet Socket**

The RJ45 socket is used to connect the machine to the network. For proper operation, it is necessary to correctly configure the connection to the database. Making sure that the connection is stable is a very important factor of further smooth operation of the machine. Use cable with min. category 5e in order to connect the machine to your network.

The press is aimed to work without direct and constant connection to the Internet. It is not advised to enable press to have access to the global network (except for the remote diagnostics & service needs done by UTAL).

**WARNING!**

Incorrect configuration of the machine will make it impossible to exchange data. Consequently, the machine will not display the orders, whereas the press will fail to start embossing. Please contact the service engineers if there are any doubts regarding the correct configuration of the system.

**14. USB Socket**

The USB socket can be used to connect keyboard or computer mouse to the press. Although these devices are not required to operate the press, they may sometimes become useful, especially in cases of damage of touch functionality.

**15. Fonts**

The set of fonts supplied with the Secure Plus press contains the RFID tags. Each font's tag has been programmed in order to be uniquely identified by the press. Thanks to this the machine recognizes the plate number that is currently set on a drawer.

**WARNING!**

Fonts supplied with the machine have been equipped with appropriately programmed RFID tags. Embossing plates by means of fonts not designed to work with a Secure Plus machine is impossible.

**16. Drawer connection socket (drawer side)**

This RJ45 socket is used to connect the drawer with the press using standard Cat5e Ethernet cable (straight wiring) – the socket on the press side is marked as (6).

## 5. Start-up

### Preparing the Press Start-up



#### WARNING!

Before starting the machine for the first time, it is necessary to ensure that it has been in the machine room for at least an hour (if the previous storage temperature was above 5 deg. C). If the press was storage under different conditions, this time should be increased up to the point the machine has the same temperature as the environment in machine room and no signs of steam condensation is present. Attempting to start up the press before that time may cause permanent damage of the electrical components.

### Connecting the Press to the Mains

The press has been designed to be supplied with 230 V/50 Hz alternating current. Connection to the mains is carried out by connecting the power cord ending with a plug to the socket.



### Turning the Press On and Off

The press is turned on with the power supply switch. After the machine has been turned on, the control systems start up, including the control panel. When the machine has been turned on correctly, within about a minute since turning it on, the control panel will display the main screen.

### Connecting the Drawer, Setting the RFID Readers and the DMC Reader

In order to connect the drawer to the press, it is necessary to connect the drawer with the press using delivered ethernet cable. Location of sockets is shown on Figure 3.



#### WARNING!

Never try to connect anything other than the drawer to the drawer connection socket. Failure to follow this instruction may lead to permanent equipment damage.

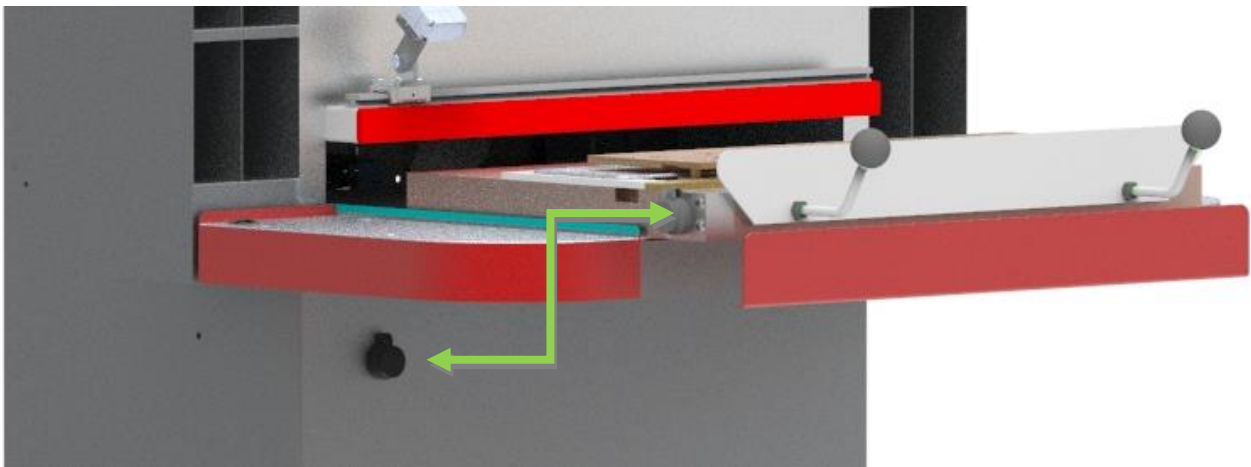


Figure 3. Drawer <-> Press connection



## 6. Press Operation

For most of the time the machine will be operated by means of the control panel. Each screen consists of four main areas.

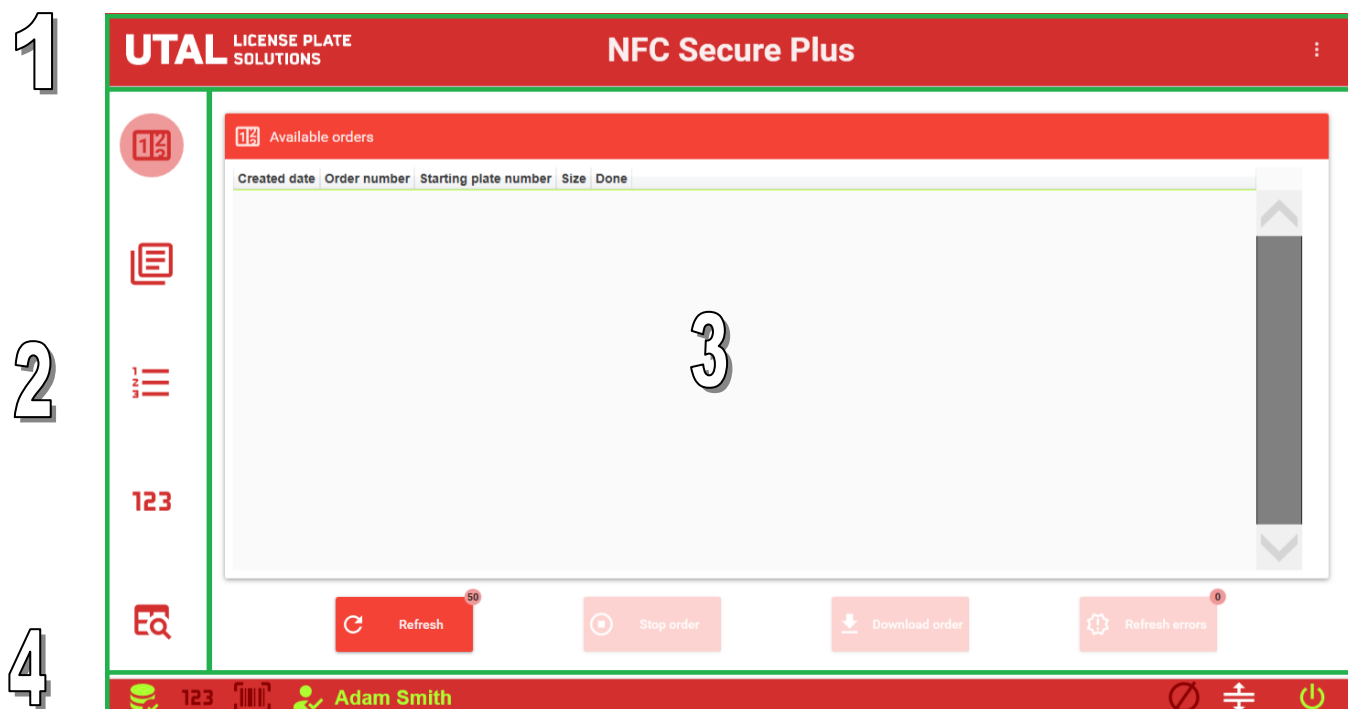


Figure 4. The screen divided into logical areas

1	Title bar
2	Screen operation buttons
3	Main content area
4	Status bar

### 1. Title bar






The title bar contains two fields.

Press name is displayed in the center of this area. This name is unique for each machine. The press name is downloaded from the database during each program startup, so if there's no press name displayed on the title bar it means that the connection with the database has not been set up at all.

Expandable dropdown menu is marked by three dots in the top right corner. Clicking on this item expands the menu entries.

## 2. Screen operation buttons

These buttons enable user to switch between screen pages. Switching between pages changes the content of the main area (3). The currently active page is marked by highlighting the icon of the active page with red circle.









	Activation of Orders List screen (see page 20).
	Activation of Actual Plate screen (see page 23).
	Activation of Order Details screen (see page 24).
	Activation of Actual Fonts screen (see page 25).
	Activation of Plate Search screen (see page 26).









## 3. Main content area

The content in this area is changed with the selection of operating button (2). The detailed description of pages is shown further in this Instruction Manual.

## 4. Status bar

Icons in the status bar area provide status of the press.

		Database server connection status. Green icon means that the database server is online. Number inside the circle represents the amount of embossed license plates waiting to be sent to the database. "0" means, all embossed plates have already been transferred back to the database.
		Font correctness status. Green icon means that all fonts are placed in correct order on drawer. Not only the font character is checked, but also font country and font type (e.g. bottom row fonts and top row fonts are distinguished). If the icon is red, the press will not allow to embosse a license plate.
		<i>Only for applications which require barcode scanning.</i> Barcode correctness status. Green icon means that barcode is scanned correctly. Which parts of barcode are checked depends entirely on specific customer needs. If this icon is invisible, the barcode scanning is not activated on this machine. If this icon is visible and red, the press will not allow to embosse a license plate.
		<i>Only for applications which require QR code scanning.</i> QR code / DMC code correctness status. Green icon means that this code is scanned correctly. Which parts of the code are checked depends entirely on specific customer needs. If this icon is invisible, the QR code /DMC code scanning is not activated on this machine. If this

		icon is visible and red, the press will not allow to emboss a license plate.
		User login status. Green icon means that appropriate user is logged onto machine. The user logging can be done using installed card reader (optional) or by standard login procedure which requires to enter password. If this icon is red, the press will not allow to emboss a license plate. The name of the user logged in is shown right next to this status icon if the user is logged in.
		Embossing readiness status. Green icon means that the press can now emboss plate (all embossing conditions are met). The embossing will start as soon as the drawer is pushed inside the press. Red icon means that there are still some embossing conditions which are not met – check the rest of the status icons.
		Press state status. White icon means the press is not embossing, green icon shows that the press is in embossing phase – the table should go up and emboss a license plate.
		Internal power activation status. Yellow exclamation mark shows that either the Emergency Stop button is pressed or the Start button has not been pressed after releasing the Emergency Stop button. Press the Start button (which should be blue in this case) and the status lamp will turn red while the icon will turn green.

## 7. Orders List screen

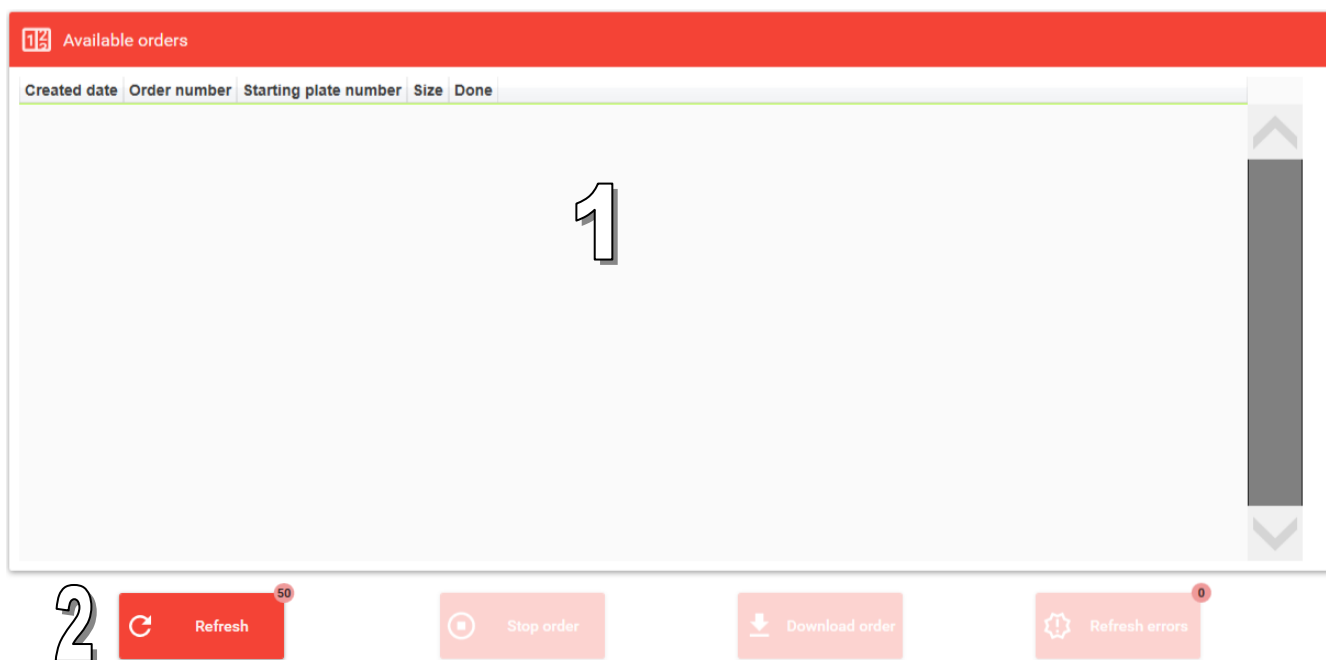


Figure 5. Orders List page with empty list

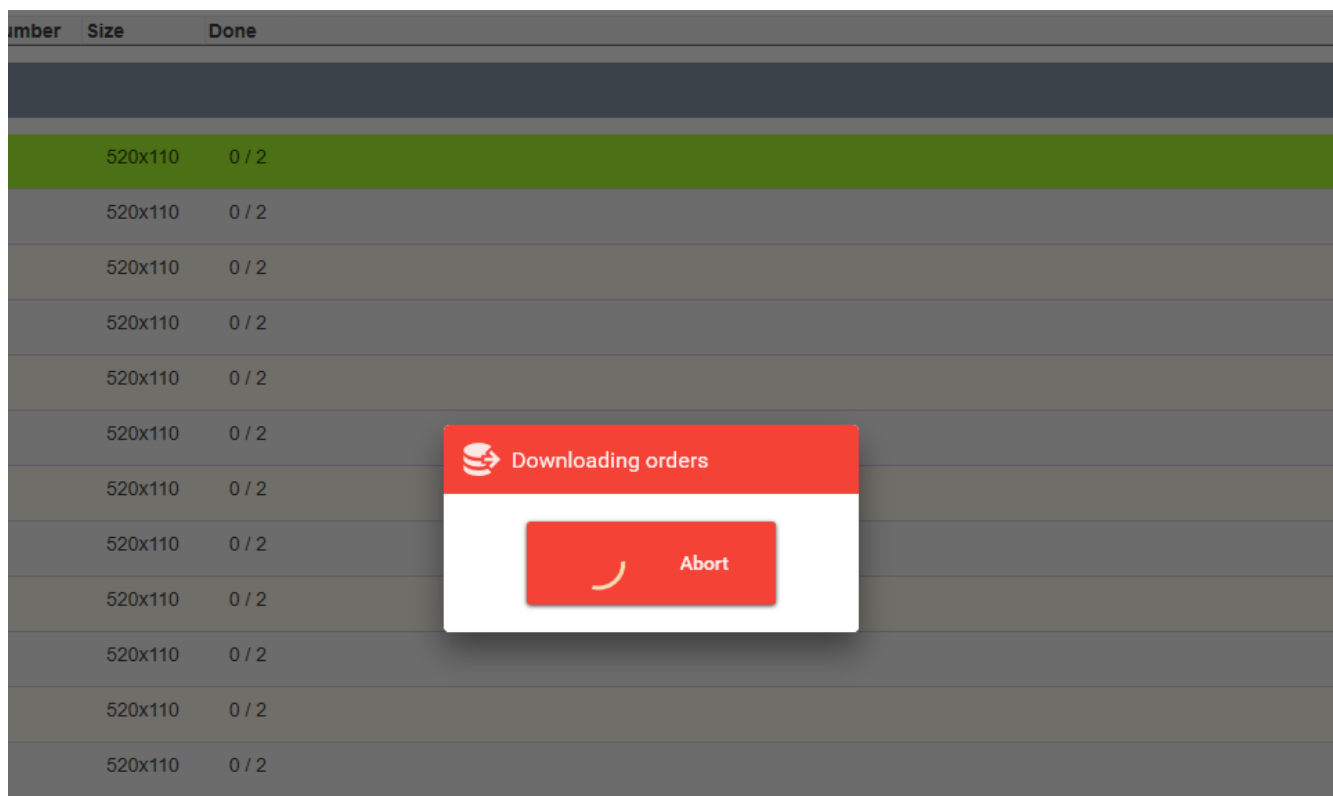


Figure 6. Order download progress window

Available orders				
Created date	Order number	Starting plate number	Size	Done
UTAL - 137				
24.04.2020	UT/000064/2020	XX01234	520x114	0 / 1
24.04.2020	UT/000064/2020	XX0123Y	520x114	0 / 1
24.04.2020	UT/000064/2020	XX012YY	520x114	0 / 1
24.04.2020	UT/000064/2020	XXXY012	520x114	0 / 1
24.04.2020	UT/000064/2020	XXX0Y12	520x114	0 / 1
24.04.2020	UT/000064/2020	XXX01Y2	520x114	0 / 1
24.04.2020	UT/000064/2020	XXX01YY	520x114	0 / 1
24.04.2020	UT/000064/2020	XXX5GA1	520x114	0 / 1
24.04.2020	UT/000064/2020	XX0Y123	520x114	0 / 1

Refresh
Stop order
Download order
Refresh errors 0

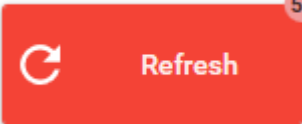
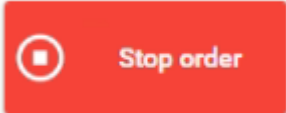

Figure 7. Orders List page with refreshed orders

## 1. Orders list

This list displays the orders that are available to be downloaded into production for this machine. List is empty by default, a press user refreshes the list himself when necessary.

## 2. Control buttons

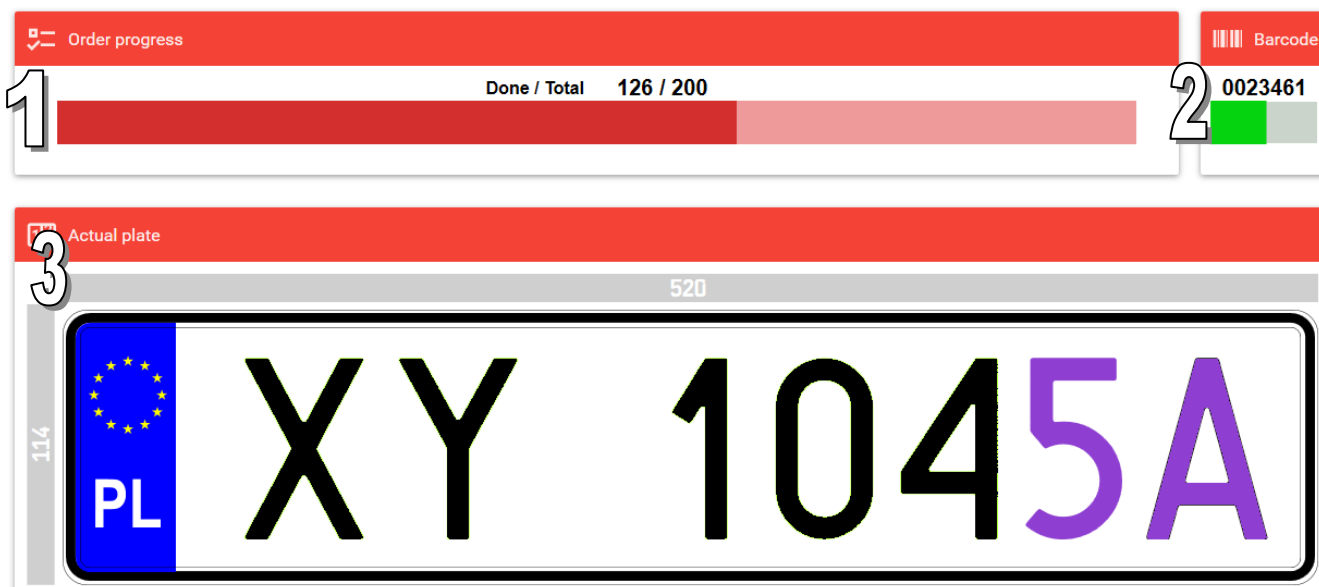
These buttons enable user to perform basing operations such as refreshing orders, downloading & stopping order. Active buttons are marked with full colour.

	<p>Clicking this button loads the unfinished orders from the database to the Orders list (1). A order download progress window is shown – see Figure 6. This button is enabled when the machine has a valid connection to the database and no order is downloaded into production. Once an order is downloaded into production with use of “Download order” button, it should be stopped first using “Stop order” button in order to be able to refresh orders once again.</p> <p>The number of orders available for download is checked automatically and shown in the top-right corner of the button in the form of circle.</p>
	<p>Clicking this button stops the downloaded order from production and enables downloading of another order or refreshing the list with other buttons. This button is active only when an order is currently downloaded to production. Once the downloaded order is finished, the page is switched back do Orders List page and the finished order is stopped automatically.</p>
	<p>Clicking this button downloads the order selected on the list to the production. Screen is automatically changed to Actual Plate page.</p>

**Refresh errors****1**

This button refreshes orders that contain plates marked previously as errors. A field in top right corner shows how many error plates are waiting to be downloaded. The counter in the top-right corner is updated automatically.

## 8. Actual Plate page



This page is the main production page. Once an order is downloaded into production using “Download order” button on Order List page, the screen is changed automatically to display Actual Plate page. If no order is downloaded into production, all fields remain empty.

### 1. Order progress area

This area shows the order progress – how many plates have already been made out of total number of plates in downloaded order.

### 2. Barcode status area

This area shows the status of a scanned barcode. Once barcode on the plate is scanned and assessed as correct, the barcode serial number is displayed and the green progress bar starts indicating the remaining barcode validity time. Once the barcode validity time is passed, the barcode must be scanned again. If the scanned barcode is valid, an operator is notified by notification message as well as by barcode status icon in the status bar area.

### 3. Actual plate area

This area displays a preview of license plate which should be embossed. Grey fields provide information about the size of the license plate that should be used. Letters on the screen are displaying the number that's next to be embossed and statuses of the fonts placed actually on a drawer. Correct letters are painted in the color of the required hot-stamping foil. Letters painted violet indicate that the font on the drawer mismatches the font that should actually be used in this place. Overall font status is displayed in the status bar area.

## 9. Order Details page

Items list in current order

No.	Plate number	Done	Done timestamp	Operator ID
0	AA0000	<input type="checkbox"/>	01.01.01 00:00:00	0
1	AA0000	<input type="checkbox"/>	01.01.01 00:00:00	0
2	AA0001	<input type="checkbox"/>	01.01.01 00:00:00	0
3	AA0001	<input type="checkbox"/>	01.01.01 00:00:00	0
4	AA0002	<input type="checkbox"/>	01.01.01 00:00:00	0
5	AA0002	<input type="checkbox"/>	01.01.01 00:00:00	0
6	AA0003	<input type="checkbox"/>	01.01.01 00:00:00	0
7	AA0003	<input type="checkbox"/>	01.01.01 00:00:00	0
8	AA0004	<input type="checkbox"/>	01.01.01 00:00:00	0
9	AA0004	<input type="checkbox"/>	01.01.01 00:00:00	0
10	AA0005	<input type="checkbox"/>	01.01.01 00:00:00	0
11	AA0005	<input type="checkbox"/>	01.01.01 00:00:00	0
12	AA0006	<input type="checkbox"/>	01.01.01 00:00:00	0
13	AA0006	<input type="checkbox"/>	01.01.01 00:00:00	0
14	AA0007	<input type="checkbox"/>	01.01.01 00:00:00	0
15	AA0007	<input type="checkbox"/>	01.01.01 00:00:00	0
16	AA0008	<input type="checkbox"/>	01.01.01 00:00:00	0
17	AA0008	<input type="checkbox"/>	01.01.01 00:00:00	0
18	AA0009	<input type="checkbox"/>	01.01.01 00:00:00	0
19	AA0009	<input type="checkbox"/>	01.01.01 00:00:00	0

Select plate to production

Order details

Order number

UT/000180/2021

Customer

UTAL

Created date

14.07.2021

Starting plate number

AA0000

Pieces count

20

Size

460x110

Color

White

This page serves mainly for information purposes. It consists of list of plates that are part of currently downloaded order and provides details about individual plates and details about whole order. If no order is downloaded into production, these fields are empty.

User can change the next plate to be embossed by selecting the required entry from the list and clicking "Select plate to production" button. Selected plate will be chosen as the next to be embossed and the further production will be continued starting from this entry.



## 10. Actual Fonts page

123 Fonts on table							
Letter	Letter	Letter	Letter	Letter	Letter	Letter	Letter
P	S	R	1	9	5	9	A
Country Type PL 2	Country Type PL 2	Country Type PL 2	Country Type PL 3	Country Type PL 3	Country Type PL 3	Country Type PL 3	Country Type PL 2

This page serves for information purposes only. It lists the fonts detected by the font reader which is embedded within the drawer. Each clapper die stores its character, country and type. The type of fonts is used e.g. to distinguish between bottom row fonts and top row fonts or between various font sizes.

In case there are no fonts detected on the screen despite being placed on the drawer, check the connection cable between drawer and the press and replace if necessary. Use straight wiring cables only.

In case the fonts are not detected on a particular drawer (they are detected on other drawers), please contact UTAL for support.

In case there are some fonts missing (not detected) while others are detected, please contact UTAL for support.

## 11. Plate Search page

Plates found

Plate number	Order status	Country	Size	Color	Done	Error	Done timestamp	Machine	User	Serial num.
FERD123	In production	DE	520x110	White	<input checked="" type="checkbox"/>	<input type="checkbox"/>	13.12.21 15:54:44	NFC Secure Light	Adam Smith	0
FERD123	In production	DE	520x110	White	<input type="checkbox"/>	<input type="checkbox"/>	01.01.01 00:00:00	NFC Secure Light		0
FERD123	In production	DE	520x110	White	<input type="checkbox"/>	<input type="checkbox"/>	01.01.01 00:00:00	NFC Secure Light		0
FERD123	In production	DE	520x110	White	<input type="checkbox"/>	<input type="checkbox"/>	01.01.01 00:00:00	NFC Secure Light		0

Find plate

Plate number

FERD123

7 / 20

Search

Mark as error

1

2

3

4

5

6

7

8

9

0

✕

Q

W

E

R

T

Y

U

I

O

P

🗑

A

S

D

F

G

H

J

K

L

Z

X

C

V

B

N

M

-

This page enables searching for any license plate number that exist in the database. “Find plate” area and the keypad enables entering of the license plate number to be searched. Search is executed by the “Search” button.

Once the plates with given number are found, they are displayed in the “Plates found” list. Plate production details are available.

There is a possibility to mark selected plate as error in case this plate was damaged during or after the embossing. Select the plate and click “Mark as error”. If order status of the selected plate is different than “In production” or “Produced” the press will not mark the plate as error and notify the user about this fact.

Once the plate is marked as an error, user may go back to the main screen and search for plates marked as errors using the appropriate button. Then it is possible to download these plates to production.

## 12. User login

Logging into machine is an essential step in embosing process. It enables the possibility of tracking back the production of license plates – who was responsible for embosing given plate, when did that happen.

There are two ways of logging operator into machine.

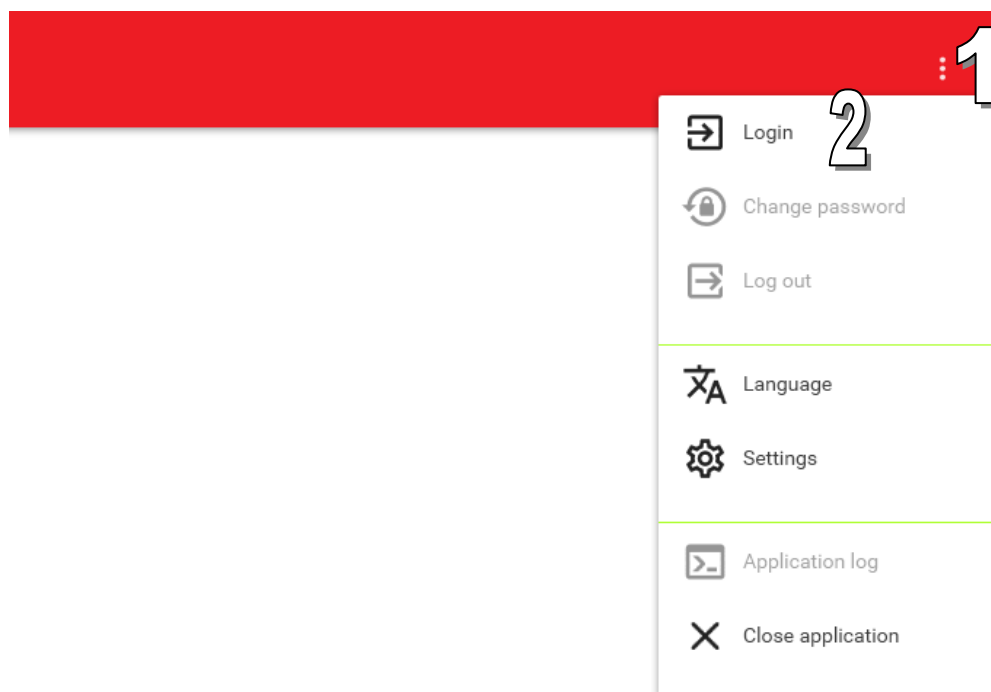
**Logging with user card** *(only for machines with user card reader installed).*

If the machine ordered by the customer is equipped with optional card reader, the logging procedure is quite simple: an user card needs to be inserted into the reader socket ( see Chapter 4 at page 8 of this Instruction Manual).

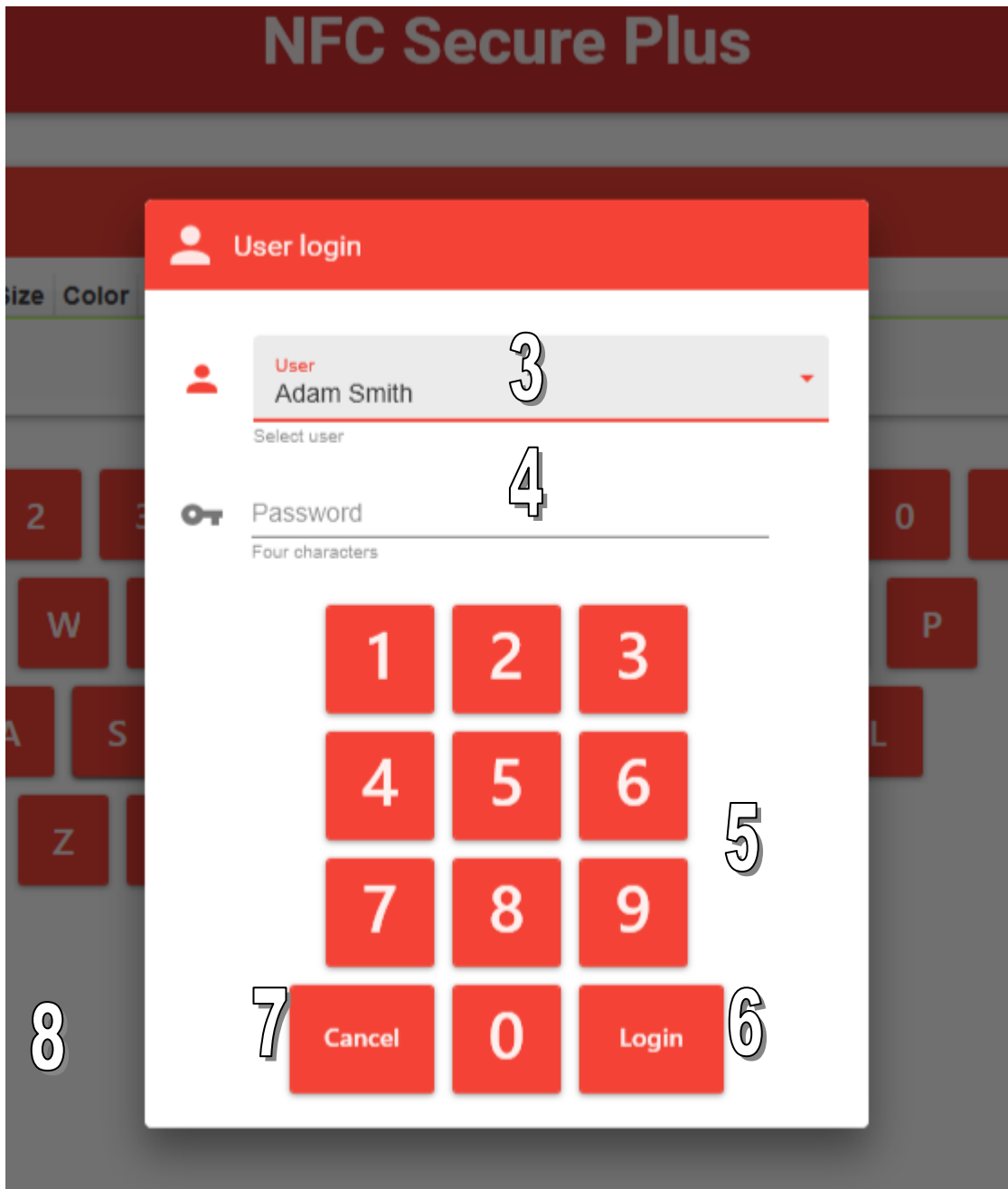
### Logging with password

Logging with password is available for all types of NFC Secure Presses. The procedure looks as follows.

Select three dots button in the top-right corner of the screen (1) and select “Login” (2).



User login window will open. Select appropriate user name (3) and enter password (4) using keypad (5). Finally, press “Login” (6). Logging window can be closed anytime using “Cancel” button (7) or by clicking outside the window area (8).



Once the logging procedure is finished (the entered password must be correct), an user is logged into machine which is indicated in the status bar:



It is also important for the users to remember to log out of the machine after their work is done since this secures the press form unauthorized access. To log out of the machine select three dots button in the top – right corner of the screen (1) and select “Log out”. The successful logout is indicated in the status bar:



## 13. Password change

Once logged in, any press user is able to change his password. The procedure looks as follows.

Select three dots button in the top-right corner of the screen (1) and select “Change password” (2).



The password change window will open. Retype your actual password and insert new password twice (4). Finally press “Save” button (5). If the actual password was wrong or there is a mismatch between new password and repeated new password, the user will be notified about failure of changing password procedure. Clicking away of the “Change password” window or clicking “Cancel” button will abort the procedure and close the window.

**Change password**

**Actual password** 3  
Four characters

**New password** 4  
Four characters

**Repeat new password** 4  
Four characters

1 2 3  
4 5 6  
7 8 9  
Cancel 0 Save 5

## 14. Embossing

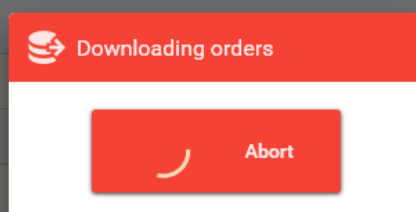
The following steps describe the embossing process.

First, refresh the orders from the server by clicking the “Refresh” button on the Order List page.



Now wait until the orders have been downloaded. You can abort downloading of further orders at any time.

Number	Size	Done
	520x110	0 / 2
	520x110	0 / 2
	520x110	0 / 2
	520x110	0 / 2
	520x110	0 / 2
	520x110	0 / 2
	520x110	0 / 2
	520x110	0 / 2
	520x110	0 / 2
	520x110	0 / 2
	520x110	0 / 2
	520x110	0 / 2
	520x110	0 / 2
	520x110	0 / 2



From the list of the available orders, select the order you would like to download into production and click the “Download order” button.



Available orders

Created date	Order number	Starting plate number	Size	Done
UTAL - 137				
24.04.2020	UT/000064/2020	XX01234	520x114	0 / 1
24.04.2020	UT/000064/2020	XX0123Y	520x114	0 / 1
24.04.2020	UT/000064/2020	XX012YY	520x114	0 / 1
24.04.2020	UT/000064/2020	XXXY012	520x114	0 / 1
24.04.2020	UT/000064/2020	XXX0Y12	520x114	0 / 1
24.04.2020	UT/000064/2020	XXX01Y2	520x114	0 / 1
24.04.2020	UT/000064/2020	XXX01YY	520x114	0 / 1
24.04.2020	UT/000064/2020	XXX5GA1	520x114	0 / 1
24.04.2020	UT/000064/2020	XX0Y123	520x114	0 / 1

Refresh

Stop order

Download order

The screen will be automatically changed to “Actual plate” screen.

Order progress

Done / Total

0 / 1

Barcode

Actual plate

520

114

XX 01234

Now, install the appropriate drawer on the press and plug in the drawer connection cable. You have to use a drawer that is designed to the required plate size.

Install the font holder on the drawer. Font holder is a positioning tool which helps inserting the clapper dies at the correct spots.

Now, take the appropriate clapper dies and place them on the drawer. All the letters displayed on the “Actual plate” screen needs to be marked as correct (their color matches the color of the hot-stamping foil and license plate rim).

Now take the appropriate blank plate. The size of the blank plate you need to take can be read from the grey fields located next to the plate image.

If the barcode scanning is required for the embossing, there will be a “Barcode” field visible in the top right corner of “Actual plate” screen. Also, the barcode status icon will be displayed in the status bar (bottom of the screen). In this case, scan the barcode printed on the blank plate. You will be notified when the code is scanned – the scanning verdict will be presented in form of notification. Having scanned the code/codes, slide the plate in between the fonts.

You also need to be logged in onto machine in order to fulfill all the embossing requirements.

Check the “Embossing readiness status icon” on the status bar.

Notice that all the embossing conditions (left side of the bar) are met. The embossing readiness status is the green circle with thick inside (third icon from the right side).



No the press is ready to emboss. The status lamp should turn green (see Chapter 4 of this Instruction Manual).

Slide the drawer in into the press to initiate the embossing. The embossing is finished once the pre-set value of pressure has been reached and when the work bench has lowered itself thanks to the system of antagonistic springs.

**WARNING!**

Sliding the drawer in (with the license plate in it) the working area of the press has to be done by pushing the drawer using only the handles designed for this purpose. Trying to close the drawer in any other manner or using inappropriate tools to do this may result in serious hand injuries.

**WARNING!**

The fonts should be placed symmetrically in the drawer. Placing them off-center may lead to the damage of the hydraulic cylinders.

Once the embossing is finished, the drawer can be withdrawn. Take the plate out of the clapper dies. If the previously downloaded order contains any unfinished plate, the next plate to be embossed will be loaded automatically.

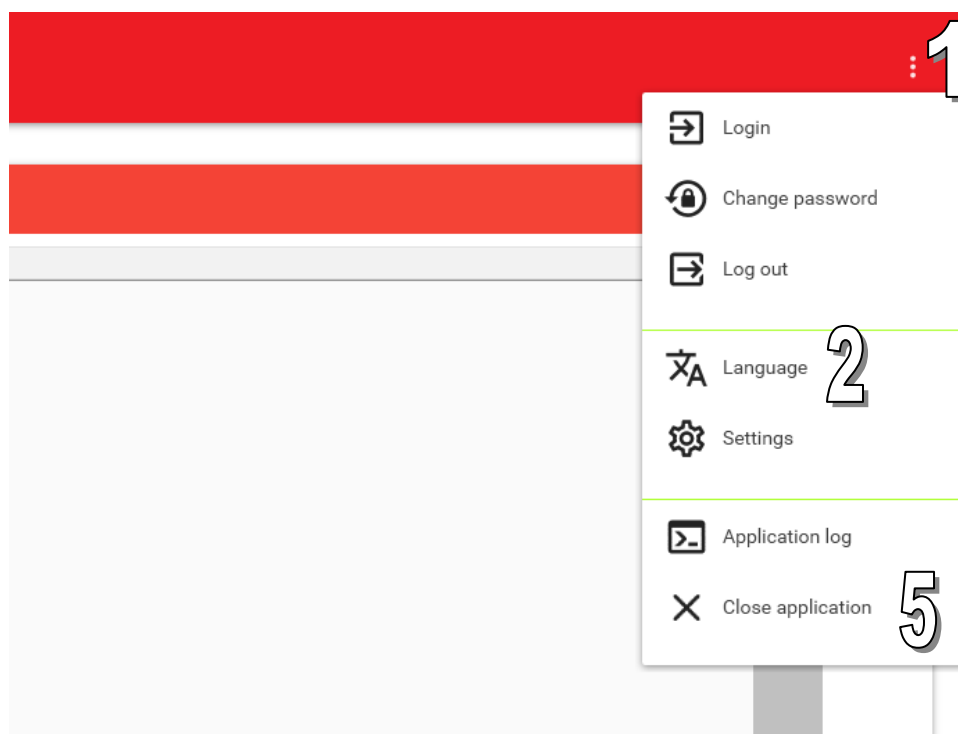
Once the order is finished, the order will be closed automatically. The next order of the same client as previously downloaded will be downloaded automatically into production.

The order can be stopped anytime using "Stop order" button at the Order List page.

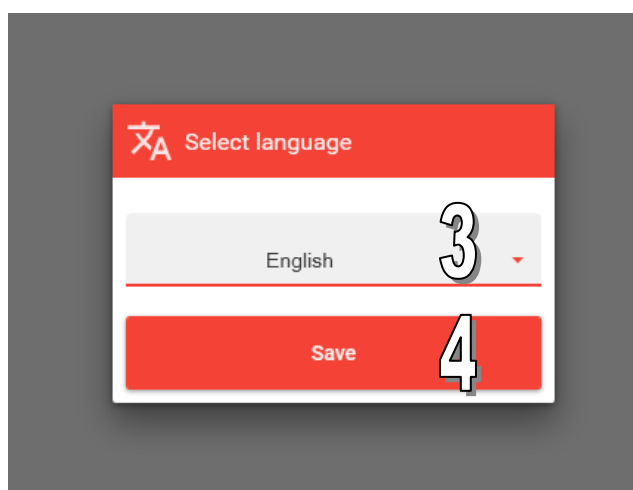
## 15. Changing user interface language

Following steps need to be done in order to change language of the user interface.

Select three dots button in the top-right corner of the screen (1) and select "Language" (2).



The language selection window appears. Select the language from the drop-down list (3) and press "Save" button (4).



The language of your choice will be loaded the next time the program is started. You can either switch the machine off and back on, or press "Close application" (5) from the drop down list and start the application again using the shortcut icon on the Windows desktop.

## 16. Maintenance

### Changing and Refilling the Hydraulic Oil

The oil level should be checked periodically with the oil dipstick located in the filler plug which may be found behind the front press cover. Excessive oil loss may be caused by leaks somewhere in the hydraulics. Such leaks should be identified and the service engineers should be notified.

It should be noted that leaks from the hydraulics, apart from the fact that they are dangerous to the environment and that the oil is wasted, may cause accidents and failures. At the same time, due to leaking hydraulics, the air, water and mechanical impurities may find their way into the system. This will result in the working fluid becoming frothy, in addition to rising noise levels, decreasing power and unstable work of the machine. Impurities also cause the individual components of the press hydraulics to wear at a faster rate.

How frequently the oil should be changed depends on the intensity of use of the machine. Under normal conditions, it is recommended to change the oil once every 5 years. The steps to follow while changing the oil have been given below:

1. The oil from the hydraulics and the container should be drained (or pumped out) to an appropriate container for used oil.



**Warning** The used oil should be safely disposed of to a company specializing in recycling. Do not dispose of any oil derivatives in the sewer system or in the municipal waste containers.

2. When changing the oil, also replace the filter box. The filter box should be unscrewed with a strap wrench. Before screwing in the new filter box, place a thin layer of oil on the box's seal.
3. Fill in the oil container with the new oil whose type has been specified in the spare parts list.
4. Start the press up and check the hydraulics over for leaks 4 hours after the oil change.