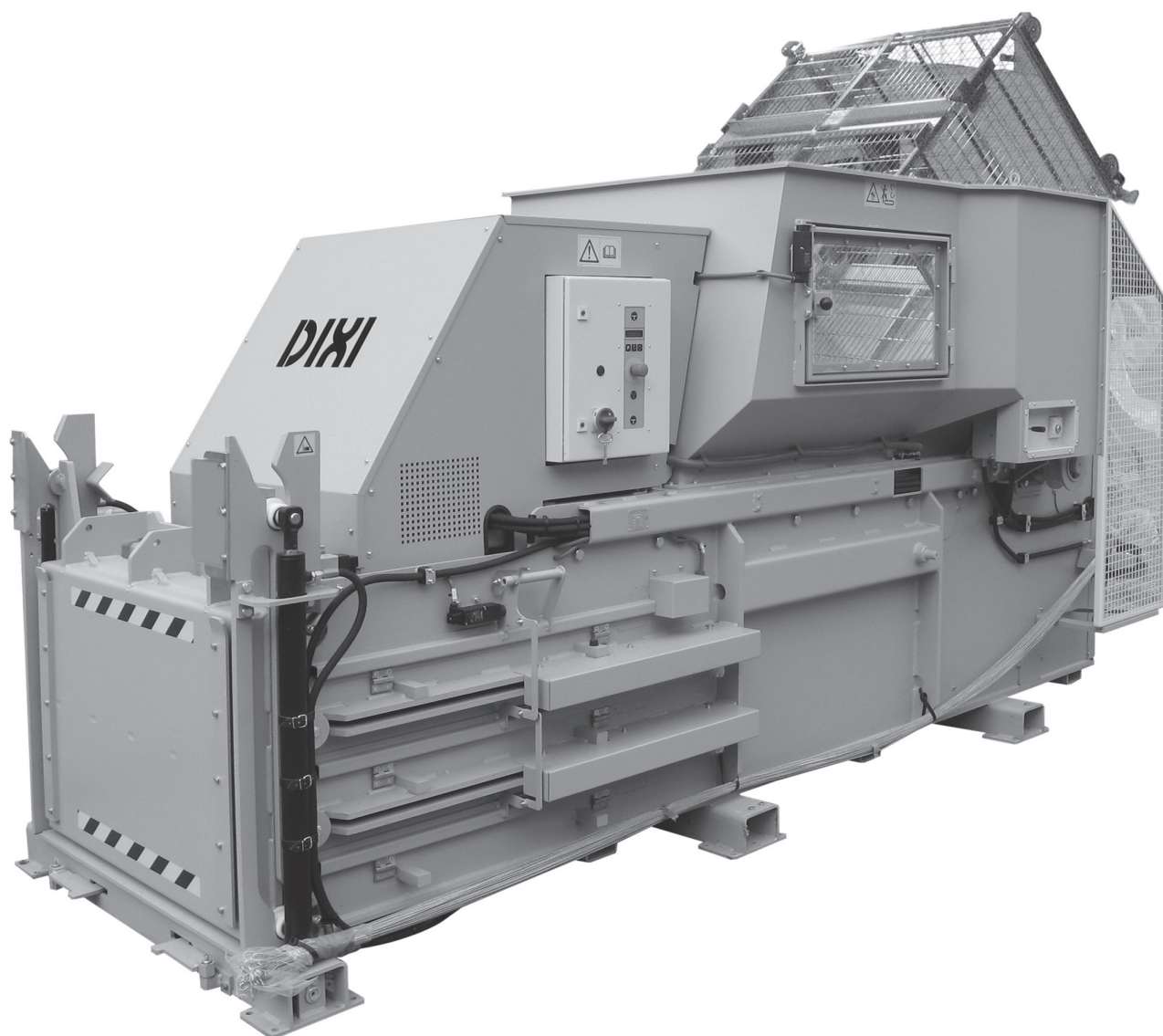


**Translation of the original
operating manual**

Horizontal Baler

DIXI 60 SLD

DIXI 60 SLS



Maschinenfabrik Bermatingen GmbH & Co. KG
Kesselbachstr. 2 D-88697 Bermatingen

Phone: +49 (0) 75 44 / 95 06-0
Email: service@mabe-info.de

Certificate of Conformity



for the following machine manufactured by us:

Horizontal Baler DIXI 60 SLD/60 SLS

Identification No. 629.00.000, 630.00.000

We confirm the compliance with the requirements of the:

Machinery Directive 2006/42/EC

including its modifications and supplements published up to the present.

Corresponding technical documentation can be made available. The following standards and directives were complied with in the design and manufacture:

Applied standards and specifications:

DIN EN ISO 16252	Horizontal Baler
Directive 2014/30/EU	Directive on the harmonisation of the laws of the Member States relating to electromagnetic compatibility
Directive 2014/35/EU	Directive on the harmonisation of the laws of the Member States relating to the making available on the market of electrical equipment designed for use within certain voltage limits

In particular:

DIN EN ISO 12100:2010	Safety of machinery (including risk assessment)
DIN EN 13857	Safety distances to prevent hazard zones being reached by upper and lower limbs
EN ISO 13849 – 1	Safety of machinery - Safety-related parts of control systems – General principles for design

Authorised person for documentation: Wolfgang Websky. For address, refer to manufacturer.

If the machine is modified without coordinating with us this declaration loses its validity.

Bermatingen, September 2021

**Maschinenfabrik Bermatingen
GmbH & Co. KG
D-88697 Bermatingen, Kesselbachstr. 2**

Company management

A handwritten signature in black ink, appearing to read 'Ulrich Gotterbarm', is written over a horizontal line.

Ulrich Gotterbarm

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General Information of the Horizontal Baler

Manufacturer's Address:

Maschinenfabrik Bermatingen GmbH & Co. KG
Kesselbachstr. 2
88697 Bermatingen

Telephone: +49 (0) 7544 - 95 06-0
Telefax: +49 (0) 7544 - 95 06-677
Email: service@mabe-info.de

Your DIXI Horizontal Baler **Serial Plate (1)**

Maschinenfabrik Bermatingen GmbH & Co D-88697 Bermatingen • Tel.07544/9506-0			
Typ	Horizontal Baler DIXI 60 SLD / 60 SLS		
Ser.Nr.			
Volt		Hz	
Amp.		Ph	
kW		HP	
MADE IN GERMANY			

The **Serial Number** (Ser. No.) appears on the serial plate of your DIXI Horizontal Baler. Please enter this number in the following field:

Ser. No. / Machine No.:

Warranty claims and inquiries cannot be processed without the serial number.

Symbols used in these Operating Instructions

The following symbols are used in these operating instructions:

- This symbol appears in front of work which must be undertaken.



Warning - Personal Danger

Non-compliance of this reference can endanger health and life of persons.

ATTENTION

Reference to Property Damage

Non-compliance of this reference can lead to functional errors or damage to the DIXI Horizontal Baler.

Note

Appears in front of text which contains additional information.

1 Safety Regulations

1.1 General Safety Regulations

The DIXI Horizontal Baler is manufactured in compliance with the most up-to-date technology and accepted safety standards.

Nevertheless, improper use can lead to:

- Danger to the life and health of the operator or others, or
- Damage to the DIXI Horizontal Baler or other property damage.

ATTENTION

In **case of danger** press the Emergency Off Button, remove the plug from the mains, or switch the main switch off.

1.2 Intended Use

The DIXI Horizontal Baler is a electro-hydraulic horizontal baler.

The DIXI Horizontal Baler may only be used for the compacting of contractually agreed upon, compactable materials, e.g. cardboard, textiles and plastics.

Materials which contain propellant gases or other chemical substances may not be compacted.

During the compaction cycle it isn't allowed to do other activities (e. g. cleaning etc.) at the machine.

The DIXI SLD may only be put into operation in compliance with the technical data in chapter 8.

Any other use, or uses which go beyond this, are not to be considered intended use. The manufacturer assumes no responsibility for damages resulting from non-intended use. This responsibility is covered by the user only.

Only use the DIXI Horizontal Baler:

- when it is in perfect operational condition
- for its intended use
- with safety and danger in mind in accordance with these operating instructions.

ATTENTION

Intended use includes the observance of these operating instructions and proper maintenance.

Regulations, norms and guidelines as related to specific countries must also be observed.

1.3 Organisational Measures

The operator of the DIXI Horizontal Baler is responsible for the observance of the prescribed, valid accident prevention and safety regulations.

- Ensure that only trained staff operates the Horizontal Baler.
- The presence of children in the operating area of a machine in the operational mode is not permitted. The technical conception of the machine with regard to safety (dimensions, safety clearances etc.) is intended for a hazard free operation by adults.
- Check on a regular basis to be certain that safety and danger regulations are observed during operation.
- Ensure that staff has read and understood these operating instructions, especially the chapter „Safety Regulations“. The owner of the DIXI Horizontal Baler can, if necessary, have the operator confirm this to him in writing.
- Keep the operating instructions on hand at the operating site of the DIXI Horizontal Baler. Ensure that they are always complete and fully legible.
- Observe all generally applicable, legal and other binding regulations concerning accident prevention and environmental protection, and their application, in addition to these operating instructions.

ATTENTION

- **We recommend an annual inspection of the machine according to country-specific regulations.**

**ATTENTION**

Do not modify any of the safety equipment.
Increased danger of accident!

ATTENTION

Do not climb on the machine!

ATTENTION**Emergency Off**

Activation of the Emergency Off Button causes that the Horizontal Baler will be switched off.

If an operating error or any unusual changes occur:

- immediately switch off the DIXI Horizontal Baler, and secure the main switch with the padlock against renewed activation or rather pull out the power plug.
- report the error to the responsible person.

In order to release the Emergency Off Button it has to be pulled out.

1.4 Safety Conscious Work Procedures

„Make a contribution to safety at your place of work“

This also includes the reading of these operating instructions, especially these safety instructions, and the observance of all directives, as well.

Make sure that only authorised staff is present at the site of operation, and within the danger zone of the Horizontal Baler.

Report all unusual changes (including changes to operating performance) immediately to the responsible person.

Keep safety in mind when doing any work with or on the baler, e.g.

- protect the turned off main switch (if existing) against turning on and remove the plug from the mains before doing any repair or maintenance work.
- for work done at positions above body height use a safe and suitable work platform.
- do not climb onto the Horizontal Baler

Observe all safety and danger warnings on the DIXI vertical baler. Keep these warnings in complete and legible condition.



ATTENTION: Automatic start – do not climb into the press!

1.5 Additional Equipment

Do not carry out any changes or program changes, or any structural additions (either on or around the baler) to the DIXI Horizontal Baler without previous consent of the manufacturer. The manufacturer assumes no responsibility for changes and/or interventions of any type, which he has not previously approved.

All documentation delivered with additional equipment from Maschinenfabrik Bermatingen must be observed.

1.6 Electrical

The DIXI Horizontal Baler operates with life endangering voltages. Flawless grounding of the DIXI Horizontal Baler must be assured through the use of a protective grounding conductor.

- If the Horizontal Baler is set up outside of enclosed rooms, the main connection must be protected at the machine side with a fault-current circuit breaker. Only fault-current circuit breakers with a nominal fault-current of a maximum of 30mA may be used.
- If a flexible power supply line is to be used, heavy rubber-jacket cord (H 07 RN-F in accordance with VDE 0100) must be used.
- The GS partial test on the electrical system was carried out in compliance with EN 60204 Part 1 (06/93) and EN 13 489 - 1.
- Work on the electrical system may only be carried out by authorised electrical technicians.

Do not use an extension cable to run the machine.



1.7 Mechanical

The DIXI Horizontal Baler should be checked at least once per month for external damage and defects. Damage and defects are to be corrected immediately.

1.8 Hydraulics

ATTENTION

- Hydraulic hoses are to be inspected visually every day.
- **Never work with damaged hoses and fittings.**
- Lines and fittings have to match and should be produced by the same manufacturer.
- Hydraulic lines are to be inspected regularly (at least every 3 year) for damage (worn areas, tears, cuts, dents etc.) by a trained specialist, and if necessary, replaced.

ATTENTION

- **All hydraulic lines are to be completely replaced at least every six years.** The date of manufacture is marked on all fittings.
- The adjustment of the pressure regulating valve may not be changed. Corrections are only permitted when carried out by a trained specialist, or in consultation with Maschinenfabrik Bermatingen.
- Spilled hydraulic fluid is to be collected or bound with a binding material and disposed properly.
- Observe all environmental regulations.

1.9 Repair and Maintenance

Repair and maintenance work may only be carried out by a service technician from Maschinenfabrik Bermatingen.

Trained staff may bind the bales with binding wire.

ATTENTION

For damages to the Horizontal Baler

Request a service fitter from Maschinenfabrik Bermatingen.

Service Centre
Maschinenfabrik Bermatingen GmbH & Co. KG
+49 (0) 75 44 / 95 06-0, Fax +49 (0) 75 44 / 95 06-677

1.10 Disposal

The owner must ensure a safe and environmentally-sound disposal of the operating materials & auxiliary materials, the replacement parts, and of the entire machines. The respective country-specific regulations must be complied with.

Obsolete units have to be disposed in compliance with local laws. The Maschinenfabrik Bermatingen would be pleased to submit a corresponding offer to you, just dial: **+49 (0) 75 44 / 95 06-0**

1.11 Additional Regulations and Standards

Regulations applying to specific countries are to be observed in the operation of the DIXI Horizontal Baler. In addition, the following norms and guidelines are to be observed in its latest revisions:

- EN 1010
Safety requirements for the design and construction of printing and paper converting machines.
- German Workplace Safety Ordinance (BetrSichV) (power-operated machinery)
German Workplace Safety Ordinance (BetrSichV) (printing and paper processing)
- EN 60204 Part 1 and DIN EN ISO 13849-1
Electrical equipment of machines

2 Transport and Set-Up

ATTENTION

2.1 Transporting the DIXI Horizontal Baler

Danger of damage to the DIXI Horizontal Baler

The DIXI Horizontal Baler is only to be transported and stored in the original packaging from the manufacturer.

Improper transport can lead to damage or functional errors of the DIXI Horizontal Baler. The DIXI Horizontal Baler may only be transported uprightly with a fork lift or a suitable machine. The fork lift/machine must have a minimum capacity of 6000 kg.

- Only have trained personnel execute the transport
- Bring the DIXI Horizontal Baler to its installation site with the fork lift/heavy duty castors.
- The transport height is at least 2,2 m (without additional equipment).

2.2 Setting Up the DIXI 60 SLD/60 SLS

Floor Requirements

The floor must be:

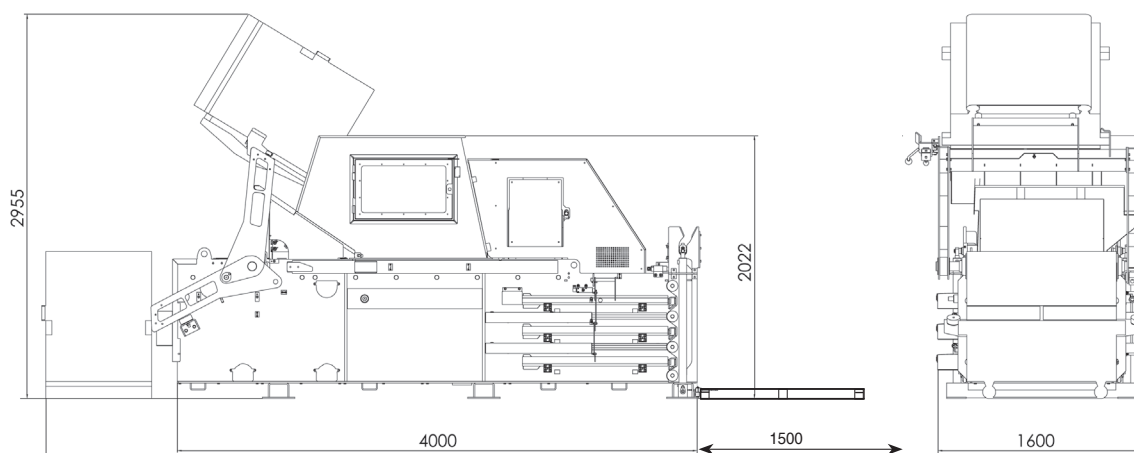
- plain
 - must withstand a point load of at least 1000 kg.
- Maximum weight of the DIXI SLK with bale is approx. 6000 kg.

Site Requirements

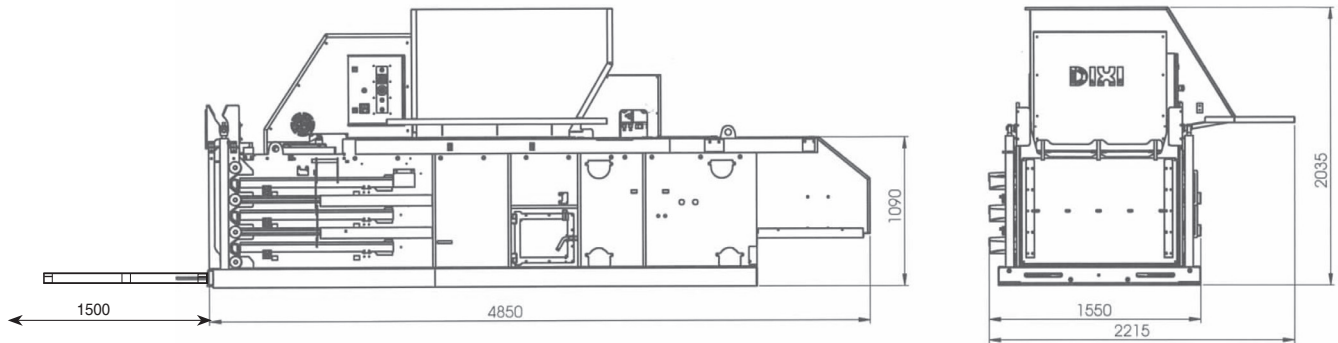
The site can be indoors or outdoors.

The site must:

- be covered and dry.
- be sufficiently protected against weather conditions when outdoors.
- **if the machine is installed on an unfixed ground (e.g. gravel bed), the operator must ensure, that any hydraulic oil which might escape can be caught in a collection trough.**
- be in compliance with the technical data shown in chapter 8



Space Requirements DIXI 60 SLD



Space Requirements DIXI 60 SLS

Voltage Supply Requirements

For the electrical connection on site you need (see serial plate):

- Three Phase Current
- Protection for all three phases (32 A inert at 400 V)
- According to EN 60204 the baler has to be connected directly to a plug with the provided cable - please do not use extension cables!

Unpacking, Set Up and Startup

- Remove the original packaging from the DIXI 60 SLD/60 SLS .
- Check completeness of all items delivered (see packing slip).
- Set up the Horizontal Baler DIXI 60 SLD/60 SLS on its site.

Note The Horizontal Baler DIXI 60 SLD/60 SLS has fixed metal feet. These metal feet assure a solid base. Anchoring is not necessary.

Note **At the time of delivery, the program buttons are always locked. The responsible employee receives the code for unlocking at the time of transfer.**

ATTENTION: Measures to be provided by the customer

Safety distances of the press to walls or other room dividers (DIN EN ISO 13857-2008, page 20)

When setting up the press the owner must always ensure that the relevant occupational health and safety standards and directives are complied with.

If the machine is set up in such a manner that it adjoins a wall or a room divider, then the customer must ensure that personnel cannot unintentionally get between press and room divider. Appropriate barriers must be installed.

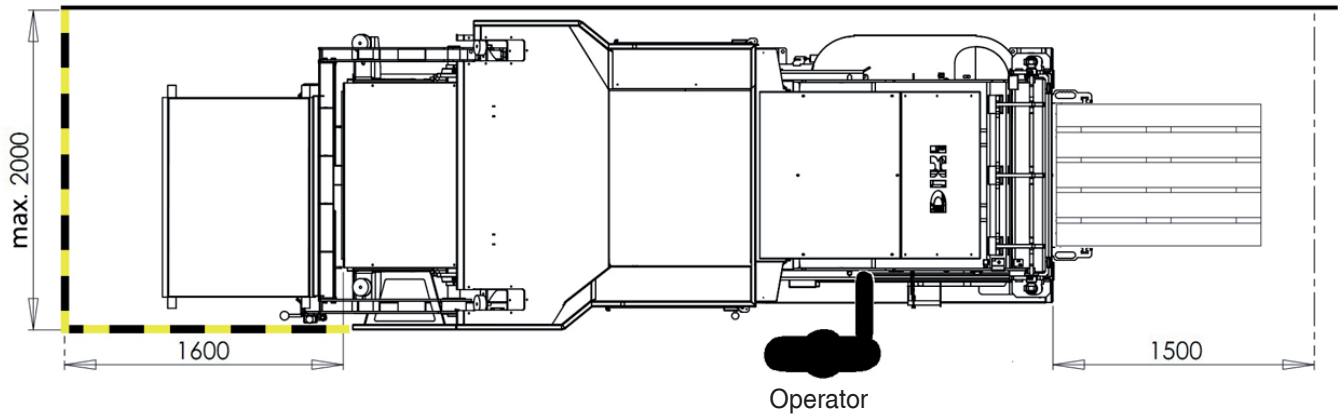
For any lubricating and cleaning tasks on the rear of the machine, performed by instructed personnel, the machine must be de-energised so that these tasks can be performed without danger.

Under some circumstances it is also recommended that the customer provide feed plates between wall / room divider and filling hopper, if there is danger that material drops between the press and the room divider and safe access is no longer possible.

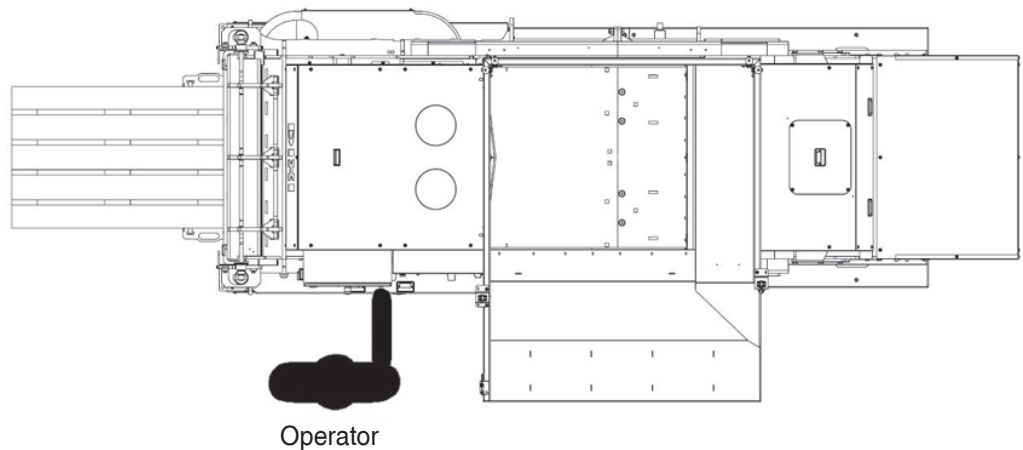
If necessary, additional mirrors must be attached so that the work area can be viewed even more effectively.

2.3 Marking of the safety areas

DIXI 60 SLD



DIXI 60 SLS



2.4 Electrical Connection



HIGH VOLTAGE

VDE as well as local regulations, especially with regard to protective measures, are to be observed.

The 4 meter connection cable is located at the control box or the baler (exits at the control box from the bottom).

- Connect the connection cable to the mains.
- Turn on main switch (if existing).
- Pull the Emergency Off Button.
- The ram is moving automatically backwards (door and cover have to be closed).
- Baler can be filled.

ATTENTION:

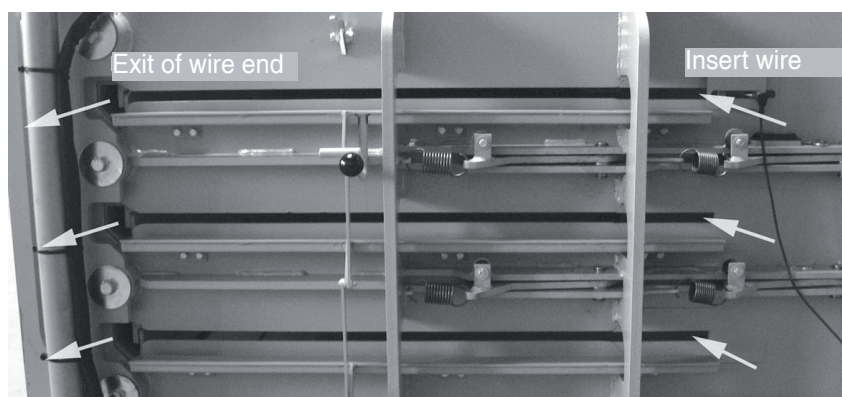
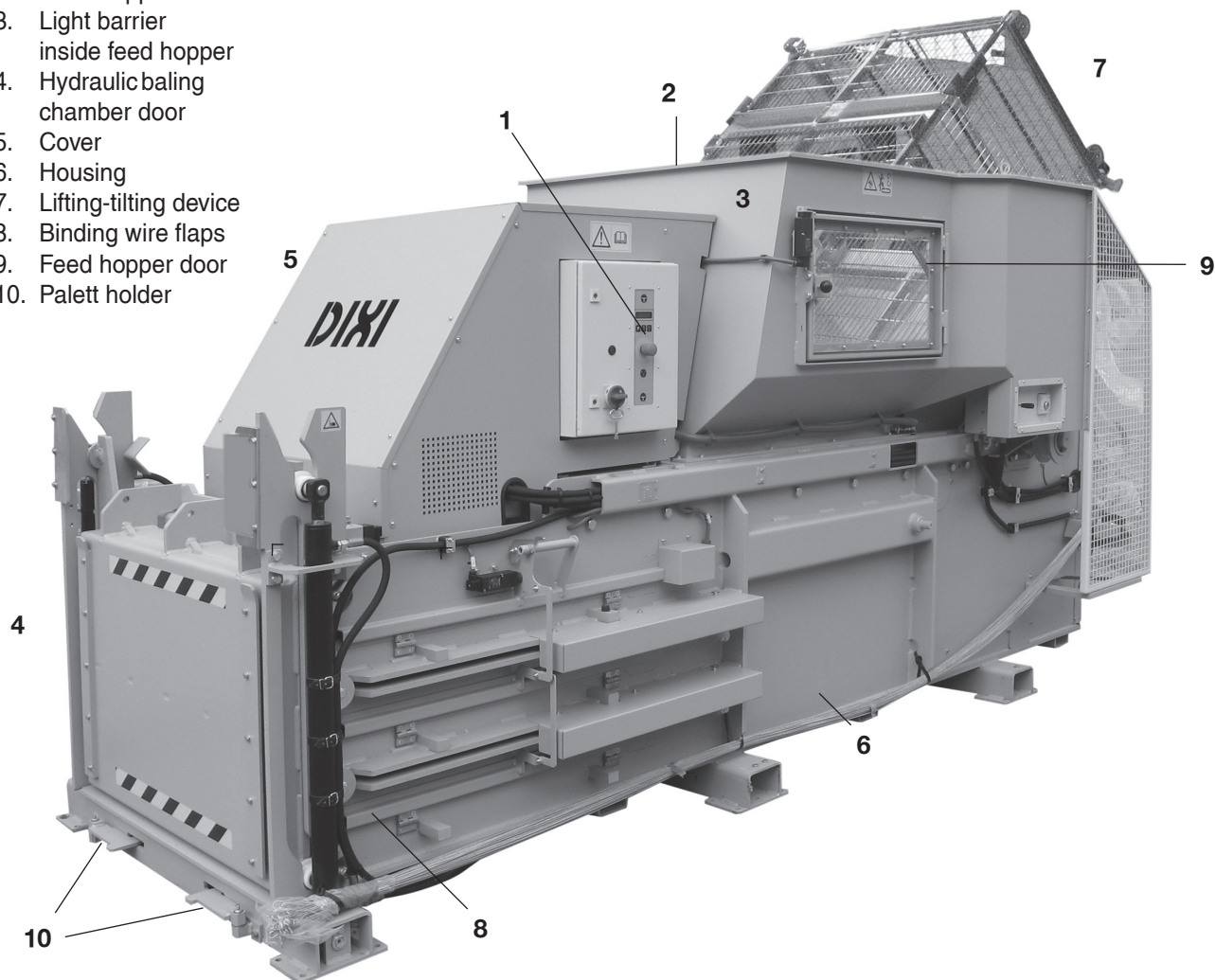
If the ram **does not** move, observe chapter 2.4.

If chapter 2.4 is correct, then the display indicates after 15 sec.:
ERROR 10 (see chapter 6).

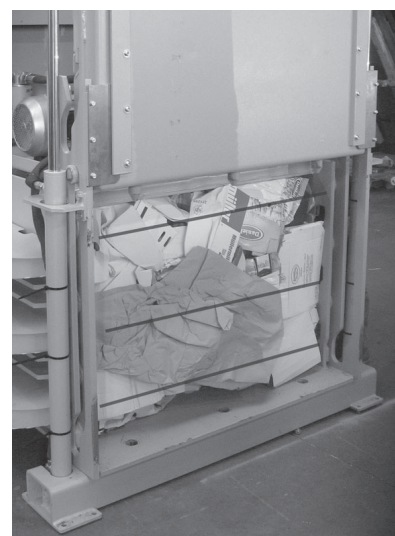
3 Lay-out and Function

3.1 Horizontal Baler DIXI 60 SLD/60 SLS

1. Control panel
2. Feed hopper
3. Light barrier inside feed hopper
4. Hydraulic baling chamber door
5. Cover
6. Housing
7. Lifting-tilting device
8. Binding wire flaps
9. Feed hopper door
10. Palett holder



Binding wire flaps open



Safety and security equipment
see page 12

Fig. 1: Lay-out of Horizontal Baler DIXI 60 SLD/60 SLS

3.2 Safety Equipment

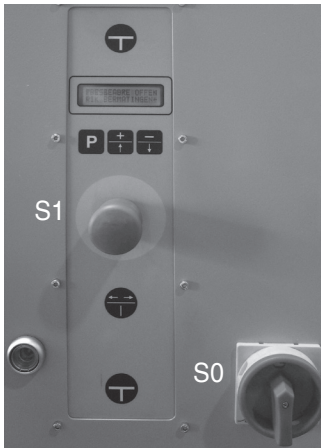
Danger of crushing

Only trained staff with knowledge of all safety guidelines (see chapter 1) is allowed to operate the DIXI Horizontal Baler.

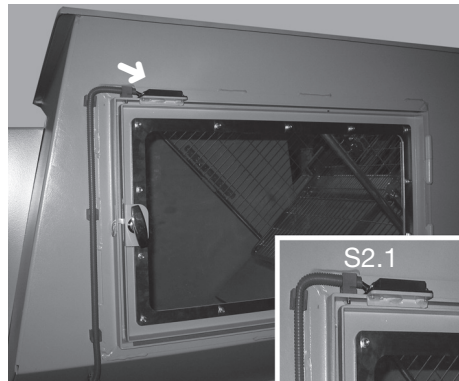
Safety equipment

The DIXI baler possesses the following safety equipment:

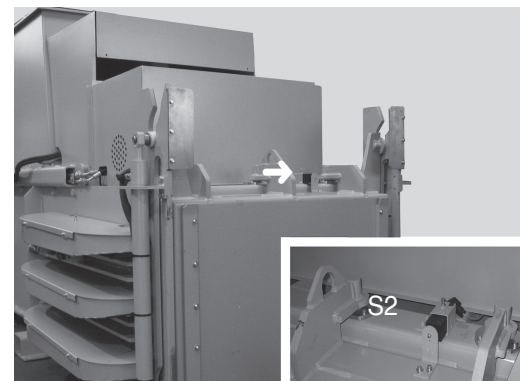
- Main switch
- Emergency Off Button
- Safety switch feed hopper door
- Safety switch cover of tying cylinder
- Safety switch auto binding unit/ twisting unit
- Safety switch cover central greasing unit
- Door of wire feeding unit (sensor monitored) see function binding
- Safety switch components like lifting/tilting device (customized)



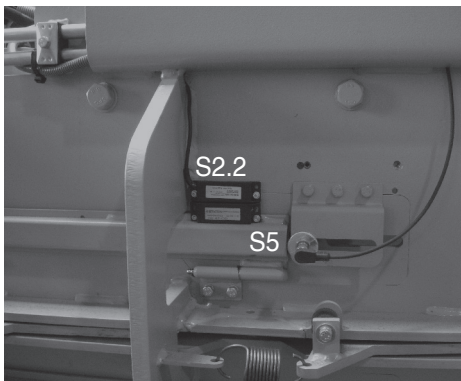
S0 Main switch
S1 Emergency Off Button



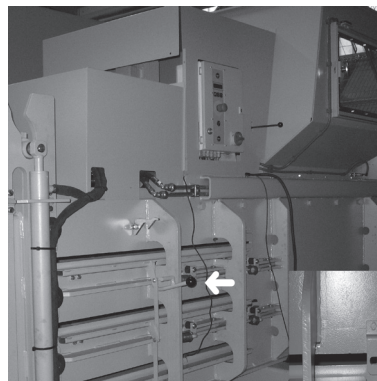
S2.1 Monitoring of feed hopper door



S2 Monitoring of baling chamber door



S2.2 Monitoring of binding unit
S5 Monitoring of ram position/bale size



Opening of binding wire flaps



S6 Monitoring of lifting/tilting device

NOTE:

The Horizontal Baler only starts if these safety equipments

- exist,
- are functional and
- are positioned correctly.

The sensor monitored equipments will switch off the machine as soon as the contact is interrupted.

3.3 Control Panel in General

Lay-out

The control panel (fig. 4) consists of a display, control buttons, the Emergency Off Button and the main switch.

The main switch (ON/OFF) can be locked.

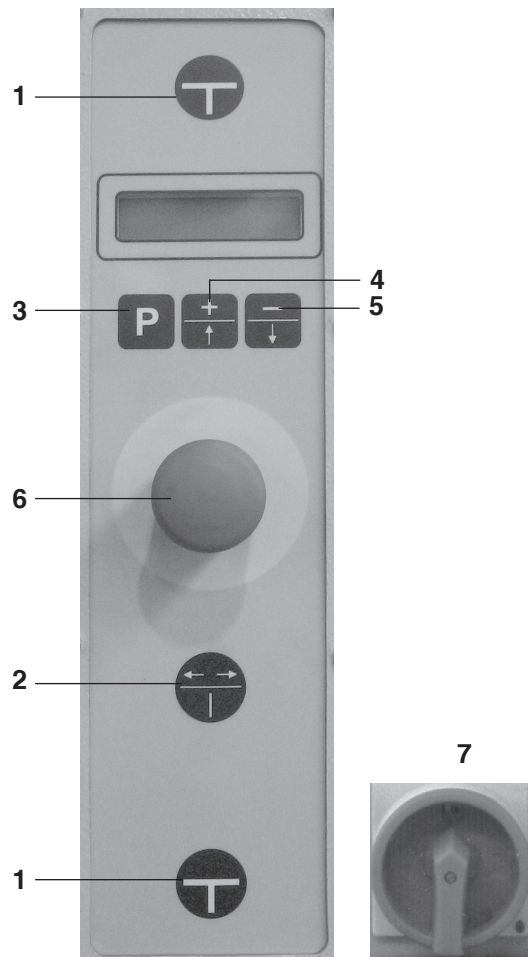
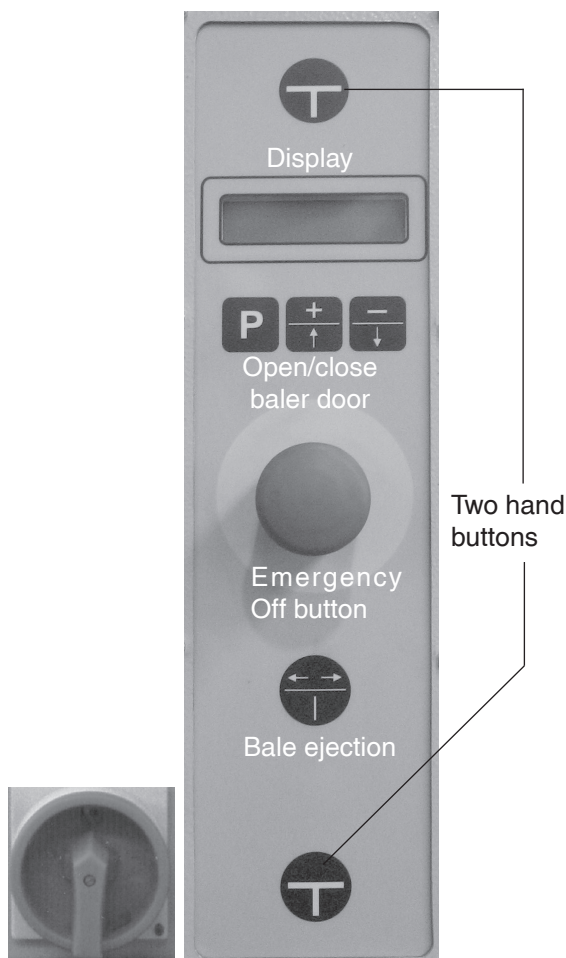


Fig. 4: Control panel

Functions

The control panel has the following control buttons:

Diagr.	Control buttons and switches	Function
1	 two hand function	Move baling chamber door, bale ejection.
2	 bale ejection	Choose function bale ejection
3	P switch to the programming mode (inactive).	
4	P  open door	baling chamber door
5	P  close door	baling chamber door
6	Emergency Off Button	baler stops.
7	main switch	ON / OFF (right beside the control panel)



The button is used to modify the direction of movement of the extrusion die. **IMPORTANT:** For ejection, the arrow must point towards the door of the extrusion chamber.

4 Operation

Only trained staff with knowledge of all safety notes (see chap. 1) may operate the DIXI Horizontal Baler.

In principle the DIXI Horizontal Baler DIXI 60 SLD/60 SLS operates automatically.

It only starts if:

- the light barrier feed hopper is active,
- the baling chamber door and
- feed hopper door at the hopper
- the binding wire flaps are closed.

Start baler

Message on display
Start

Baler ok.....K (cardboard packaging)
Automatically as soon as there is enough material inside the feed hopper so that the light barrier is interrupted.

Message on display

Ram forward/ram return

The ram moves forwards and backwards.

If no more material follows the ram stays in its rear limit position.

Message on display

Baler ready

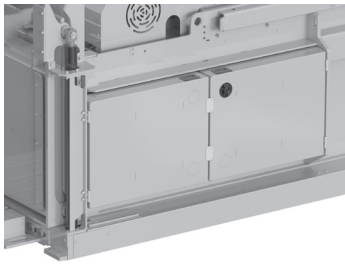
The baler can be filled with material via the feed hopper until the light barrier is interrupted. Then again... until...

Bale finished

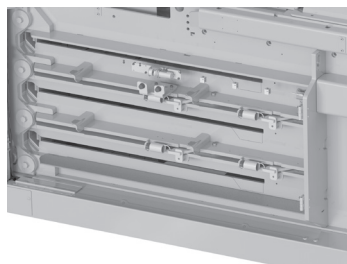
Message on display

Bale finished

The ram is in its forward limit position and keeps the compacted material under pressure.



Doors closed

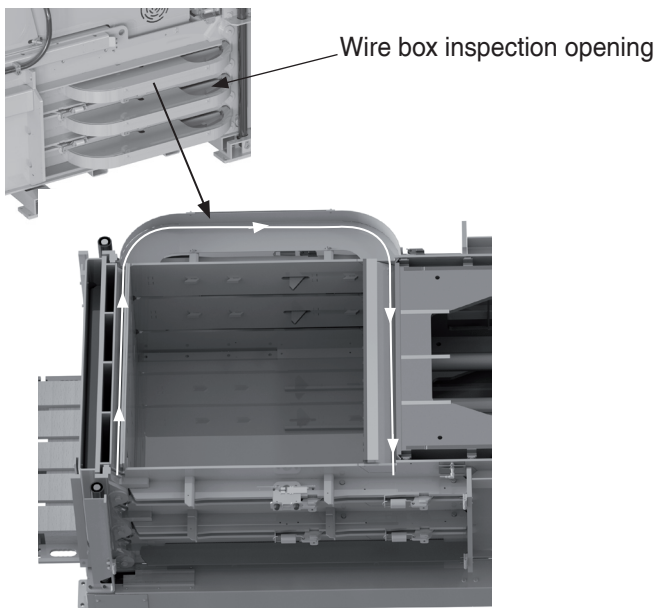


Doors open

Binding bales

1. Open binding doors

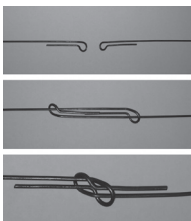
Open the doors by activating the twist lock.



Attention: Pay attention to the direction of the arrow

2. Inserting the binding wire

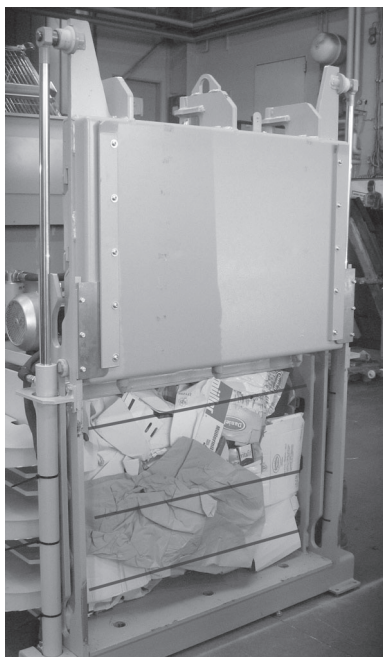
Slide in the wire on the left in the direction of the arrow until it exits on the right side. This procedure must be performed for all three binding levels.



3. Clip the ends of the binding wire together.

If necessary, repress by two-hand operation **T T** so that the wire ends can be easier joined together.

Close the doors after the binding procedure.



The  button is used to modify the direction of movement of the extrusion die. **IMPORTANT:** For ejection, the arrow must point towards the door of the extrusion chamber.

Open the baling chamber door

Press button 

Message on display

Door open

Press button **T** and **T**

simultaneously
(hold down the buttons until the motor stops)

Door is open

Eject/push out bales

Depending on model

right

left

Display shows

→ → or ← ←

Press button **T** and **T**

simultaneously

Hold down the buttons until the motor stops.

Approx. 1/3 of the bale will be pushed out.

Release button **T** and **T**

Press button **T** and **T**

simultaneously

Hold down the buttons until the motor stops.

Ejector cylinder moves out and pushes out the whole bale.

Close baler door

Press button 

Close door

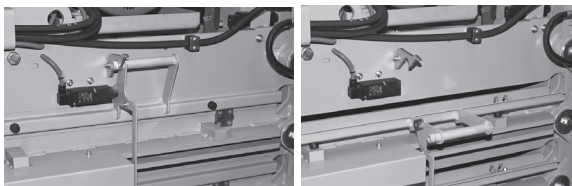
Message on display

Close door

Press button **T** and **T**

simultaneously

Hold down the buttons until the motor stops and the door is closed.



Baler ready for operation

Close binding wire flaps

Move lever up.

The flaps shut.

Press button 

Motor starts, baler is in start position.

Baler ready for operation

Message on display

Baler ready

The sequence begins again with

- start baler

Lifting/tilting device

ATTENTION:

The operator has to ensure that nobody is present within the area of the lifting/tilting device. **It shall not be possible to endanger persons during lifting and setting the container.** According to the position of the buttons the movement shall be made by inching or two hand operation. **The operator shall be able to watch the danger zone completely.** If this cannot be guaranteed there has to be a safety fence or alternative safety installations (e. g. light barriers). These measurements have to be mounted on site.

- Max. 100 kg lifting force.
- Only use suitable/intended containers/collapsible cardboard packaging cart.
- Only fill with the intended material (cardboard/foil/PET).

General view



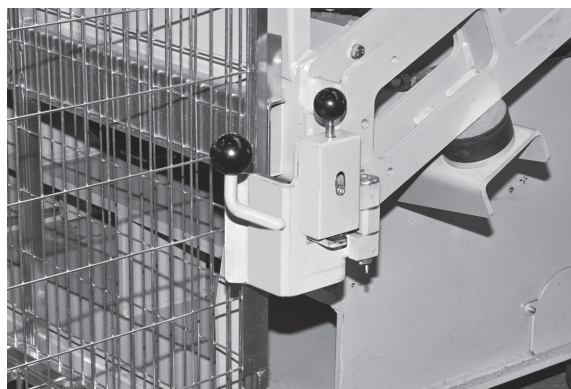
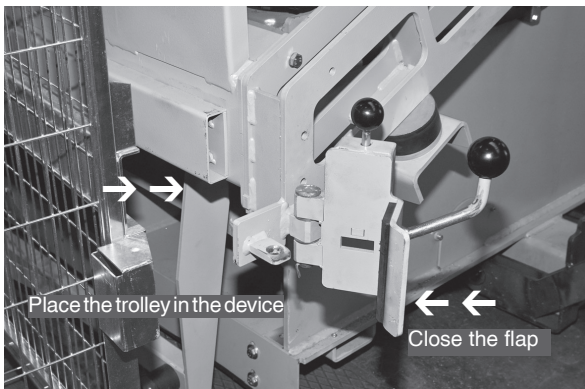
Attach the trolley

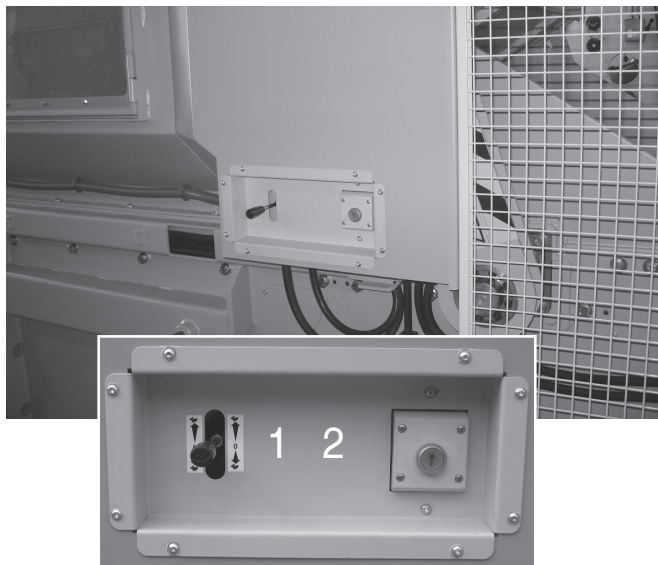
Attach the trolley back sidewise and push it backwards up to the stop.

Push the trolley against the device.



Close the lifting/tilting device





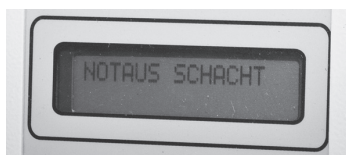
Activate the lifting/tilting device

Press the following buttons at the control panel:
"Lifting/tilting" (1) lever "up or down" and simultaneously
"start tilting device" (2) button and hold down the button

up = Lifting
down = Tilting

Press button 2 twice = start pressing process

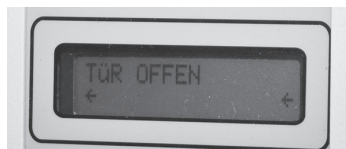
Operation instruction



Display: Emergency off chute
= Chute open
Command: Close the chute



Display: Flaps open
= Binding wire flaps open
Command: Close the binding wire flaps



Display: Door open
= Bale door open
Command: Close the bale door

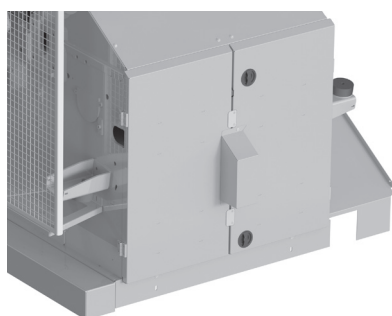
4.1 Switch the DIXI 60 SLD/60 SLS off

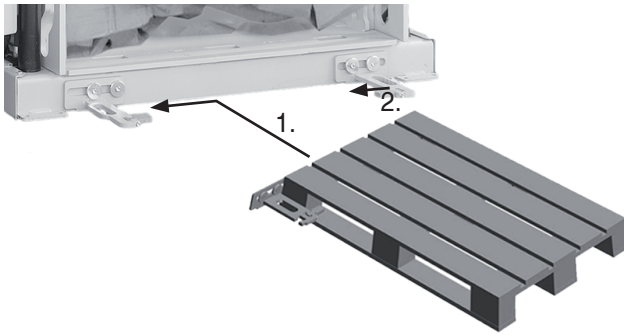
- Press Emergency Off Button
 - and turn the main switch to the OFF position.
- The DIXI 60 SLD/60 SLS is properly switched off. All settings remain unchanged.

4.2 Cleaning/Summary: -de-energised -

One every month, the following tasks must be carried out:

- 1) Remove all packaging residue from around the machine. During this, examine the machine for damaged parts.
- 2) Service doors are opened by activating the two twist locks. Now any cardboard that may be present can be removed. Opening the doors automatically de-energises the machine; this means that the machine must be restarted after you close and lock the doors.





4.3 Pallet holder

Attach pallet:

1. Insert the pallet into a pallet holder (right or left), then
2. slide the loose pallet holder against the pallet.

Remove palette:

If the pallet is lifted with the stacker, the pallet holders are released.
The pallet can be pulled away to the front.

5 Long term interruption of operation

- Switch the DIXI Horizontal Baler off.
- Secure the main switch.
- Remove the plug from the mains.
- Clean the DIXI Horizontal Baler.
- Oil and grease at appropriate points.

This is also valid when executing maintenance work.

6 What to do When ?



Personal Danger

Only trained staff may correct errors.

Error, message on the display	Cause	Remedy
Door OPEN	Feed hopper door or baling chamber door/cover is open	Close the door/cover.
MOTOR OVERHEATED		DIXI baler displays automatically after approx. 5 min.: BALER READY
	Phase error	Request electrician
Horizontal Baler cannot be switched on	No power	Connect plug to mains
	No power	Pull out Emergency Off Button and turn main switch to ON position.
	Defective fuse	An electrician must open the control box. There are 3 fuses in the control box. Replace defective fuses.
Horizontal Baler still cannot be switched on		Request a service technician
Display is not legible	Surrounding temperature below -3°C	Functions of baler are not affected.
Ram remains at the front STOP AT THE FRONT	button  pressed for	Press button  again more than 1.5 sec.
Error code 10-12	Motor does not run	*Check fuses, phases, power supply
	Wrong direction of rotation of motor	*Change direction of rotation, see chap. 2.3
	Control valve does not respond	Request service technician
	Defective pressure switch	Request service technician



*Only authorised specialists may execute this work.

Baler stops during compaction cycle in automatic mode	Feed hopper door/cover was opened during compaction cycle.	Close feed hopper door Close cover
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7 Program Settings

customized

8 Technical Data

Machine description	Horizontal Baler
Machine type	DIXI 60 SLD/60 SLS
Ser. No. / Machine No.	See serial plate
Dimensions of machine (height x width x depth) SLD	2160 x 1590 x 4000 mm without lifting/tilting device
Dimensions of machine (height x width x depth) SLS	2215 x 1550 x 4850 mm without lifting/tilting device
Transport height	from 2160 mm
Opening feed hopper w x h	approx. 900 x 1010 m (depending on application)
Bale size (w x h x l)	1100 x 800 x 1200 mm
Bale weight	approx. 380 - 450 kg (depending upon material)
No. of bindings	3
Weight of machine	approx. 5000 kg (without bale)
Max. compaction force	600 kN
Max. operating pressure	220 bar
Max. compacting cycle SLD	~ 52 sec.
Max. compacting cycle SLS	~ 27 sec.
Year of manufacture	See serial plate (encoded in Ser. No. / Machine No.)
Motor SLD	See serial plate 7,5 kW
Motor SLS	See serial plate 11 kW
Operating voltage / frequency	See serial plate, e. g. 3/N/PE/400V/50Hz C-32A
Fuse installed by manufacturer	32A
Noise level in accordance with EN ISO 3744/3746	approx. 75 dB(A) depending on installation site and pressed material

9. Hydraulic system & circuit diagrams

Hydraulic system diagram and circuit diagram are in the control cabinet or can be requested, with specification of the serial number, via the email address kundendienst@mabe-info.de.

Maschinenfabrik Bermatingen
GmbH & Co.KG



custom equipment for
environmentally sound
utilisation of materials



mulching equipment for fruit
and wine growing, and
community services



compacting systems for
the volume reduction of
recyclable materials