

A woman in a light blue uniform is operating a Miele commercial flatwork ironing machine. The machine is dark grey with a control panel on top. In the background, there is a metal cart with stacks of white and blue linens, and a white ironing board on a stand. The room has concrete walls and a large window.

**Miele**

## Guide to flatwork ironing

Information on all aspects of commercial ironing





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# What happens during ironing?

Ironing gives laundry a smooth finish, a glossy surface and retains its shape. This occurs due to the interaction of mechanical energy, heat and moisture. During ironing, damp laundry is fed into the ironer and the heated trough is pressed against the ironer roller. The roller guides the laundry through the trough. This causes moisture to evaporate and items to glide smoothly on a film of steam.

The moisture is absorbed by the fabric fibres, which makes them easier to smooth. The high temperature of the trough in combination with the contact pressure produces particularly smooth, glossy and dry results.



# Machinery Directive and Safety

## Convincingly versatile

A wide variety of textiles and garments require ironing. Miele's ironers offer a convenient solution for smoothing items quickly and effortlessly. See for yourself how versatile and easy they are to operate.

## Compliance with Machinery Directive

Flatwork ironers are ideal for commercial use and can also be operated by untrained staff. They meet all health and safety requirements and are compliant with the Machinery Directive. And, what's more, they have passed a conformity assessment including a risk analysis – for greater security in your everyday working life. In addition to this, flatwork ironers observe North American safety standards.

**Exclusive  
to Miele**

## Safety for your benefit

Miele flatwork ironers feature an automatic finger guard. If fingers get too close to the roller, the finger guard and safety switch react immediately and the motor is switched off – this stops the roller and retracts the heater plate or trough. This reliably protects your fingers.



# The ironing process

## Before ironing

### **Washing laundry**

Always comply with instructions issued by detergent manufacturers on precise dispensing. If too much detergent is dispensed, residues will remain in the fabric after washing. This can result in yellowish discolouration during ironing or cause a build-up of residues in the trough. If not enough detergent is dispensed, the water will not be sufficiently softened and incrustations may build up in the fabric. Limescale can then occur in textiles and in the trough, which can cause damage to the surface of the trough.

Water hardness, too, has an impact on ironing results:

- If water is too soft (<8.7 gpg | 8.4°dH), it is important to add an extra rinse cycle.
- If water is too hard (>14.5 gpg | 14°dH), the use of a water softener is recommended.



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# The ironing process

## Before ironing

### Drying laundry

Pre-drying down to the ideal residual moisture level is essential for a good laundry finish. The ideal residual moisture level for the ironing process is between 15% and 50%, depending on the ironer size and the fabric.

The ideal residual moisture is based on:

- Size and model of the ironer
- Surface weight of the laundry
- Roller speed
- Quality of finish required

Starched items need a residual moisture level of at least 38% to 40%. If the residual moisture content is any lower than 38%, the starch will be released from the laundry in the tumble dryer.

**Tip:** Up to a maximum residual moisture of 50%, as a rule of thumb, the higher the residual moisture, the better the quality of the finish. However, higher residual moisture goes hand in hand with a more complex and longer ironing process.



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# The ironing process

## Before ironing

### Sorting laundry

To ensure an efficient workflow, the washed and dried laundry should be sorted before it is ironed. This prevents unnecessary heating and cooling down of the ironer, resulting in time and energy savings. Sort laundry so that work can commence with the more temperature-sensitive items:



1. Nylon (synthetic fibres)



2. Woollens, Silk



3. Cotton, Linen

**Tip:** Items should also be sorted by size in the interests of a smooth workflow.



# The ironing process

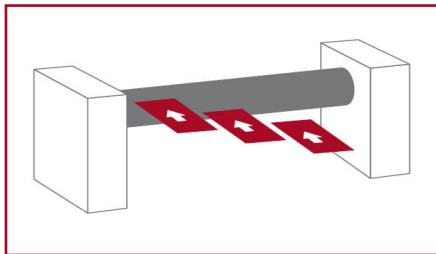
## During ironing

### Use the entire roller length

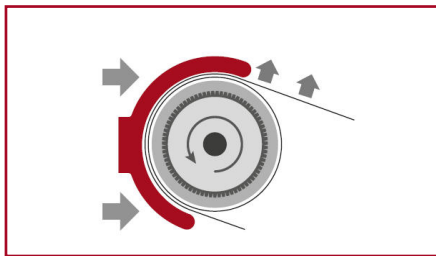
Always use the entire length of the roller by feeding in smaller items alternately left, right and centre. This keeps the ironing cloth in good condition for longer and reduces dark discoloration. This also saves even more time as you can iron larger items as well as several small items in one process.

### Feeding in laundry

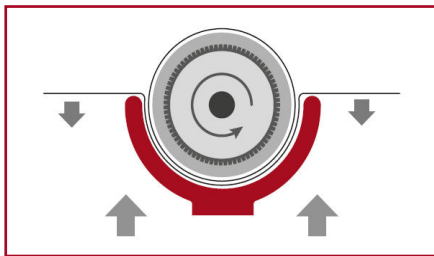
In all cases, laundry should be crease-free and straight on entering the ironer. Buttons and zippers should face the roller as the laundry is fed into the ironer.



- On smaller Miele ironers (PRI 210/214/217), the heater plate is pressed against the roller from the rear. Items should be introduced with the side requiring a smooth finish facing upwards.



- On bigger Miele flatwork ironers (PRI 318/418/421), the heater plate is located below the roller in the form of a trough. Items should be introduced with the side requiring a smooth finish facing downwards.



**Tip:** The surface of items requiring a smooth, glossy finish should face the heater plate or trough. This is because it is the heated surface which smooths the fabric and gives it its gloss.

# The ironing process

## During ironing (PRI models)

### Removing laundry

Feeding in laundry is followed by the removal of ironed laundry and folding. Depending on the type of ironer, there are different approaches to removing laundry:

- A through-feed ironer requires a well-rehearsed team. Laundry is fed in on the infeed side and removed on the outfeed side opposite. Timing and communication is important.
- On a return-feed ironer, laundry is removed from the infeed side. In this configuration, an ironer can be operated by a single person.

Several Miele ironers are convertible and can be switched from through-feed to return-feed. The finish is completed when the laundry is removed. The outfeed table on Miele ironers features a special honeycomb structure with perforations. Rising air passing through the holes cools down the fabric before it is folded.

**Tip:** Very hot laundry may self-ignite and cause a fire. Allow the ironed laundry to cool down before packing or stacking it.



# The ironing process

## Cleaning and care

Regular cleaning and waxing is essential to ensure consistent ironing results. Regular care is also very important for protecting the roller drive and padding.

**Tip re. PRI models:** There are different cleaning products for aluminium and steel troughs. You must make sure you only use cleaning products that are suitable for your ironer.

### Cleaning and care of aluminium troughs

The following Miele ironers are fitted with aluminium troughs or heater plates as standard:

- PRI210/214/217
- PRI318/418/421

Use only cleaning agents that are suitable for aluminium troughs. Any build-up of limescale, detergent or starch makes the trough dull with the result that laundry no longer glides easily between the trough and the roller. In addition, increased friction leads to greater wear on the drive elements and the roller padding. To prevent this, the trough must be cleaned and waxed at regular intervals.



# The ironing process

## Cleaning and care

### Cleaning the trough

The trough should be cleaned at regular intervals. The specific intervals will depend on the type of ironer, how often it is used and the fabrics being ironed. That said though, it is always the required level of finish which determines when a trough needs cleaning. For new ironers, the trough should be cleaned at shorter intervals. Shorter cleaning intervals may also be required if there are high levels of dust and particles in the room air.

**Tip re. PRI models:** The trough should only be cleaned with the ironer set to the • temperature symbol! Always clean the entire width of the trough.

**Tip re. PRI models:** Loosen incrustations (e.g. starch residues) by ironing a damp cloth soaked in lukewarm water first.


**Tip re. HM 16-80 models:** Any buildup of limescale or starch in the trough can be removed using domestic dishwashing detergent and cleaning agents. Cleaning is performed when the trough is cold. Operating the emergency release simplifies the job. Do not use coarse scouring agents!



# The ironing process

## Cleaning and care (PRI models)

### Cleaning with the Miele cleaning cloth

1. Select the cleaning  program using the left-hand button.

Then press the • temperature button. 176°F | 80°C is shown in the display.

2. Once the required temperature is reached, the bar below the 'Start' button flashes and the program can be started.

3. Lay the cleaning cloth on the left side of the infeed table with the abrasive cleaning strip facing the trough.

4. Feed in the cleaning cloth evenly and straight from the left side of the feed table through the ironer until it comes out on the other side. The abrasive strip loosens the soiling. The softer cotton strip removes the soiling and polishes the trough.

5. Now lay the cleaning cloth back on the feed table, but this time move it slightly to the right. The abrasive strip must again face the trough.

6. Feed the cleaning cloth through the ironer again.

7. Repeat the process until you reach the right side of the feed table and the entire width of the heater plate has been cleaned.

**Tip:** Since the cleaning cloth is narrower than the trough is wide, you cannot clean the entire length of the trough by feeding the cloth through only once. You need to feed the cleaning cloth through the ironer several times, and move it from side to side.



# The ironing process

## Cleaning and care (PRI models)




### Waxing the trough

You should always wax the trough after cleaning. Waxing should always be carried out over the entire width of the trough.



### Starting the waxing program

1. To start the waxing  program, press and hold the ●●● button for at least 3 seconds and then press the temperature button. The ironer will then switch to the waxing program. 356°F | 180°C is shown in the display. The waxing program is then ready to begin.
2. Press the flashing 'Start' button to start the waxing program. The heater plate can then be waxed using the waxing cloth.



### **Waxing the trough with the Miele waxing cloth**

1. Let the ironer heat up to the ●●● temperature level.
2. Sprinkle some wax into the pocket of the waxing cloth. Use the wax sparingly to prevent the ironing cloth around the roller from becoming too smooth.
3. Lay the waxing cloth on the left side of the feed table. Make sure that the rubberized interior of the pocket is facing the roller.

**Tip:** Always carry out cleaning in the cleaning program and waxing in the waxing program as otherwise the ironer's maintenance interval will not be reset. The maintenance interval is only reset once cleaning and waxing has been carried out for at least 40 seconds in the corresponding mode respectively.

# The ironing process

## Cleaning and care (PRI models)

4. Feed the ironer waxing cloth through the ironer from the left side of the feed table until it comes all the way out on the other side.
5. Lay the ironer waxing cloth back on the feed table, but this time move it slightly to the right.
6. Feed the ironer waxing cloth through the ironer again. Then move the ironer waxing cloth slightly to the right again. Repeat the process until you reach the right side of the feed table and the entire length of the trough has been waxed.

**Tip:** On machines with belt feed, avoid any soiling of the belts with hot wax. Use the gap between the finger guard and the roller.



**Brände verhindern**  
Lesen Sie bitte die Bedienungsanleitung  
Vorarbeiten in Brandfall  
- Feuerlöscher  
- Alarm  
- Evakuierung  
- Notruf  
- Erste Hilfe

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# Tips on ironing with a Miele ironer

## **Introducing laundry items correctly**

Pull the item flat and ensure the correct positioning of seams.

Rotate the roller with the item manually until the item makes contact with the trough.

## **Avoid distorting items**

If items are pulled too tight when feeding them into the ironer, textiles can become distorted. Smooth the entire item by hand instead of just keeping hold of the edges.

## **Ironing temperature-sensitive textiles**

Heat-sensitive fabrics and embroidery can be ironed if a damp linen or cotton cloth is placed between the laundry and the trough.

### **And shiny patches?**

Shiny patches are the result of a combination of temperature, pressure and contact with a smooth surface (in this case the trough) and is the result of light reflecting from the ironed surface of textiles. This can be a problem in particular with man-made fibres as they already have a smoother surface than natural fibres.

Undesirable shiny patches can be avoided by ironing items upside down or inside out or by placing a thin cotton cloth between the textile and the trough.

A shiny finish is not necessarily a bad thing. On tablecloths, for example, it is even desirable!



# Tips on ironing with a Miele ironer

## Prints, embroidery, buttons

**Tip:** Appliques can be used to add an individual touch to textiles. They can transform a plain T-shirt into something special. A wide range of designs – made from fabric, with glitter or beading and other finishes – is available to suit all tastes. To apply iron-on patches to fabrics, see the instructions supplied with the appliqué. Use the pressing function on a Miele ironer.

### Prints and appliques

To ensure long-lasting pleasure from clothes with prints and appliques, they should always face the roller. Alternatively, iron these items inside out.

### Undesirable creases

Occasionally, an unwanted crease might be ironed into an item in error. A little water is a quick and reliable way of saving the day. Thoroughly wet the crease with water and simply iron the item flat again. We recommend the use of the pressing function on Miele ironers so that wet areas are dried quickly.





### **Embroidery**

Textiles with embroidery (for example tablecloths) should be ironed on both sides. First iron items with the embroidery facing up to smooth the textile. Then turn the item over and iron the back so that the embroidery stands out better.



### **Ironing buttons, zippers, etc.**

Textiles with buttons are ironed with the buttons facing the roller where they press into the soft roller padding during ironing. This prevents damage to the trough or heater plate.

**Alternative:** Place a cloth over zippers, metal buttons and metal hooks to protect the trough or heater plate.

# Tips on ironing with a Miele ironer

## Long-sleeve shirts, sweatshirts, polo shirts

### Ironing long-sleeve shirts and sweatshirts

**Preparatory work:** Straighten out shirt and sleeves and ensure the correct positioning of seams.

**Sleeves:** Place the right sleeve with the cuff first on the infeed board and straighten it out. Rotate the roller manually until the item makes contact with the edge of the heater plate. Operate the foot switch. Iron the sleeve all the way up to the shoulder seam, then let go of the foot switch. Do the same with the left sleeve.

**Front and rear:** Place the shirt with the collar first in the centre of the infeed board and smoothen it out. It does not matter if the front or back is facing upwards. Buttons and zippers as well as prints and appliqués should however always face the roller. Rotate the roller manually until the collar and sleeves make contact with the edge of the heater plate. Operate the foot switch and iron the item. Then release the foot switch again.

**Repeat:** If necessary, turn the item around and repeat the process.

**Tip:** Just before reaching the shoulder seam, stop the ironing process and position the sleeve so that the shoulder seam is parallel to the heater plate. Now finish ironing the sleeve.

## Ironing polo shirts

**Preparatory work:** Straighten out shirt and sleeves and ensure the correct positioning of seams. All buttons should be unbuttoned.

**Collar:** Place the collar, including collar stand, on the left side of the roller. Allow all other parts of the polo shirt to hang over the end of the roller on the left. Collar buttons should face the roller. Operate the foot switch, iron the collar, then let go of the foot switch.

**Sleeves:** Place the right sleeve with the cuff first on the infeed board and straighten it out. Rotate the roller manually until the item makes contact with the edge of the heater plate. Operate the foot switch and iron the sleeve up to the shoulder seam. Release the foot switch again and iron the left-hand sleeve.

**Front and rear:** Position the shirt with the hem first onto the infeed board at the left side of the roller so that one half is on the roller and the other is hanging next to the roller. Operate the foot switch and start the ironing process. The button border should be off the roller and not ironed at this stage. Iron along the button border up to the collar. Then let go of the foot switch again.

**Repeat:** Now iron the other half of the shirt, repeating the process.

**Tip:** Just before reaching the sleeves, briefly let go of the foot switch and rotate the roller by hand until the sleeves contact the heater plate. Operate the foot switch and continue ironing up to the collar.

# Tips on ironing with a Miele ironer

## T-Shirts, shirts

### Ironing T-shirts

**Preparatory work:** Straighten out shirt and sleeves and ensure the correct positioning of seams.

**Front and rear:** Position the T-shirt with the neck first in the centre of the infeed board (it does not matter which side is facing upwards) and smoothen it out. Rotate the roller manually until the collar and sleeves make contact with the edge of the heater plate. Operate the foot switch and iron the item. Now release the foot switch.

**Repeat:** If necessary, turn the item around and repeat the process.



**Prints and appliqués:** Please ensure that prints and appliqués on your laundry always face the roller.

## Ironing shirts HM 16-80

As you will already have experienced, shirts are by far the most time consuming items to iron. This also applies to ironing with an ironer as it requires a lot of practice to achieve good ironing results on shirts.

**Preparatory work:** Smooth out the item and ensure the correct positioning of seams. All buttons should be unbuttoned.



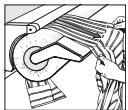
**Collar:** Place the collar, including collar stand, on the left-hand end of the roller and iron it. Collar buttons should face the roller.



**Shoulder yoke:** Fold the shoulder yoke along the back seam forwards and place it on the left side of the roller. Iron from the right shoulder seam, past the collar, up to the left shoulder seam. Level with the collar, stop the ironing process briefly and move the shoulder yoke to the left a little.

# Tips on ironing with a Miele ironer

## Shirts, denim



**Sleeves and cuffs:** Place the cuff on the left-hand end of the roller and commence ironing (see 'Ironing collars'). Now place

the sleeve with the cuff first onto the infeed board and turn the roller until the cuff is in contact with the heater plate. Iron the sleeve up to the shoulder seam.



**Front:** Position the left front half (button hole border) with the hem first on the left-hand side on the roller. Rotate the roller

manually until the item makes contact with the edge of the heater plate. Iron the front part of the shirt along the side seam and past the sleeve up to the collar. Level with the collar, stop ironing briefly and move the front section to the left a little.

Ensure that the buttons face the roller when ironing the right hand side of the shirt (button border).



**Back:** Remove the infeed board and pull the shirt with the collar first over your left arm. The back of the shirt is on top. Starting

with the hem, pull the textile along the roller to the left. The yoke and collar should be hanging off the roller on the left. Now iron the back of the shirt from side seam to side seam.

## Ironing jeans

**Preparatory work:** Smooth out the denims and ensure the correct positioning of seams.

**Right trouser leg:** Position the right trouser leg with the hem first on the left hand side of the infeed board. The left trouser leg should be hanging over the left-hand side of the roller. Rotate the roller manually until the item makes contact with the edge of the heater plate. Operate the foot switch and iron the trouser leg, including the seat, up to the waistband. Release the foot switch: Please ensure that zippers and buttons are not ironed.

**Left trouser leg:** Iron the left trouser leg in the same way as the right trouser leg.

**Tip:** Ironing trouser waistbands. Remove the infeed board, open buttons or zips and pull the trouser waistband over the left-hand end of the roller. Both trouser legs are hanging to the left of the roller. Operate the foot switch and iron around the waistband. Now release the foot switch. Take care not to iron zippers and buttons.

# Tips on ironing with a Miele ironer

## Skirts, tablecloths, bed linen



### Ironing skirts

Remove the infeed board. Pull the skirt from hem to waistband over the left-hand end of the roller and smoothen it out. Operate the foot switch and start ironing. Now release the foot switch.

### Ironing tablecloths and bed linen

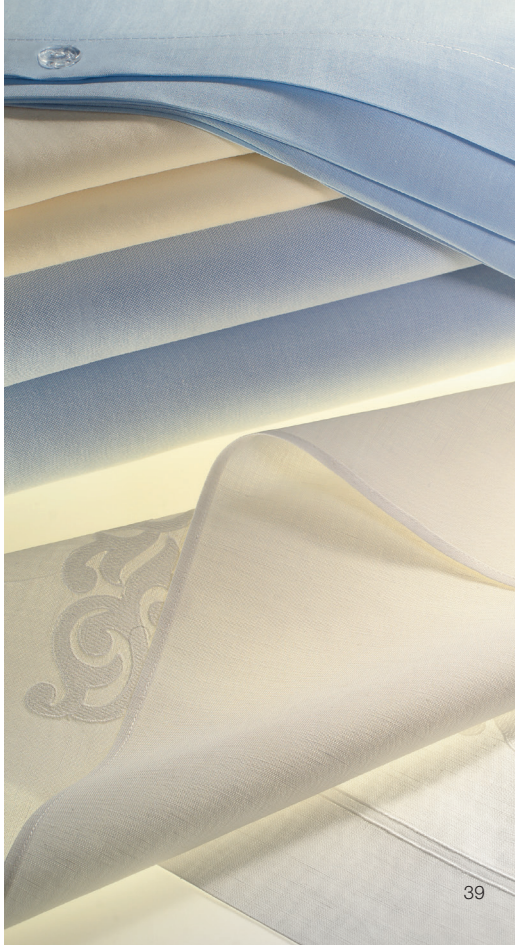
**Preparatory work:** Dampen the textile well by spraying it with water and allow to rest. Fibers can now swell, giving much smoother results. Now the textile can be pulled into shape. Ensure correct positioning of seams.

**Feeding into machine:** Place the textile on the infeed board and smoothen it out. The part of the textile that does not fit on the roller is left hanging over the left-hand end of the roller. Rotate the roller manually until the item makes contact with the edge of the heater plate.

**Ironing:** Operate the foot switch and commence ironing, then let go of the foot switch. Follow on with the parts of the garment still to be ironed. Repeat the process until all areas are dry and crease-free.

**Folding items:** Fold the item once lengthwise. Place item on the infeed board and smooth out. Rotate the roller manually until the item makes contact with the edge of the heater plate. Operate the foot switch and start the ironing process. Then release the foot switch again. If necessary, fold the item once more and repeat the process.

**Tip:** To avoid a crease in the middle, use this trick: Position the folded textile so that the crease is just off the left-hand end of the roller and is not held tight during ironing.



# Useful tips and tricks

## **Hanging up items to dry**

If a tumble dryer is not used to dry laundry, the following should be observed: Smooth out the laundry and ensure that it hangs straight. This takes little time and greatly simplifies the subsequent ironing process.

## **Sorting laundry before ironing**

### **... saves time!**

Start with items that only tolerate low heat (e.g. silk) and increase the temperature slowly. With mixed fabrics, the temperature for the most sensitive fibre always applies. Cotton and linen items are ironed at the highest setting.

Get through mountains of laundry quickly and easily by ironing similar items one after the other.

## **Starch and additives**

Starch, smooth and care for all textiles made from cotton, linen or blends of the two. This even simplifies the ironing of dry and badly creased items. Textiles keep their shape for longer. Starched items should be ironed last so that any starch residues on the heater plate or soleplate do not affect other items.

### **Small before large**

Iron small sections such as arms, cuffs, straps and collars before ironing larger areas. Ironing small parts first is important to prevent creases on areas already ironed.

### **Shirts**

When washing shirts, try not to use fabric conditioner. Fabric conditioner reduces the amount of starch in the detergent, resulting in more wrinkles. Collars, cuffs and button borders are often reinforced with stiffeners and should not be ironed too hot. Heat combined with steam may damage the inlays.



# Useful tips and tricks

## **How crease-free is 'non-iron'?**

'Non-iron' does not mean that a shirt looks as if it has been ironed after washing. It always depends on the demands placed on laundry by the wearer. Normally, consumers expect 'non-iron' to mean that an item does not need to be ironed. Practical experience has shown, however, that ironing is still needed for a perfect finish. Textiles made from cotton, linen and viscose crease easily. These fibers can be treated to reduce their tendency to crease; this can be useful on shirts for example. Such treatment involves the introduction of synthetic resins or chemicals to the fibers. This increases the elasticity of textiles. Untreated cotton fibers swell during washing and alter their position within the fabric. After drying, the individual fibers do not return to their original, orderly position. This is why the fabric appears creased.

During washing and drying, fibers with a non-crease finish retain their original looks to a great extent. Subsequently such fabrics require only light ironing, if they need any ironing at all. The fabric finish, however, washes out over time so that the non-iron effect gradually disappears. Finishing fabrics also reduces their resistance to wear. Areas subject to excessive wear such as collars and cuffs become worn more easily.



# Problem-solving guide

## Creases in ironed laundry



### **Deposits have made the trough dull.**

- Clean and wax the trough.
- Check how much detergent and starch is being dispensed.
- Check the water hardness level before commencing the wash process.

### **When repadding the roller, the maximum roller padding diameter was exceeded.**

- Call Customer Service to adjust the roller padding.

### **There was too much residual moisture in the laundry before ironing.**

- Check the spin cycle settings before commencing the wash process.
- Iron at a low roller speed.
- Before ironing, dry the laundry to the residual moisture level recommended for your ironer.



**The laundry was too dry before ironing.**

- Dampen the laundry in the washing machine using the “Separate rinse/spin” program.
- Reduce the drying time.
- Cover the laundry if it is stored temporarily after washing.

**The ironing cloth wound around the roller is too smooth.**

- Wash or replace the ironing cloth.
- When waxing the heater plate, apply less wax to reduce the amount of wax which finds its way into the ironing cloth.

- After waxing, always run a cotton cloth through the trough to remove any wax residue.

**Not enough steam extracted.**

- Wash the ironing cloth to remove deposits.
- Call Customer Service to check the ducting, the condensate drain and the baffle.

**The laundry was not ironed at the correct temperature.**

- Set the ironing temperature according to the care symbols on the laundry labels. Start ironing only when the set temperature has been reached.
- Call Customer Service to check the temperature control, heater elements, thermostat and temperature limiter.

# Problem-solving guide

## Brownish/yellowish stains on laundry

### **Laundry ironed at incorrect temperature.**

- Observe the recommended ironing temperature on the laundry care label.
- Change the ironing temperature and/or increase the roller speed.

### **Heavy metals (iron and manganese) in the water supply.**

- Check the quality of the water supply

### **There is too much starch in the laundry.**

- Wash the laundry again.
- Reduce the amount of starch used.



# Problem-solving guide

## Water marks or damp streaks on the laundry after ironing (PRI models)

### **Uneven contact pressure during ironing.**

- Call Customer Service to check the roller padding.



# Problem-solving guide

Item comes out of the ironer (PRI models) at an angle, although it was fed in parallel

## **The roller padding is worn on one side.**

- Call Customer Service to replace the roller padding.
- In future, always iron across the entire length of the ironer by feeding small items into the ironer alternately on the left, right and in the middle.

## **The ironer has not been aligned correctly.**

- Level the ironer in both directions using a straightedge, a spirit level and the adjustable feet.
- After aligning the ironer, tighten the counternuts by turning them in an anti-clockwise direction with a spanner. This locks the feet tight and prevents any alterations.

## **Uneven friction due to deposits on the surface of the trough**

- Clean and wax the trough.

## **The trough is exerting uneven contact pressure on the roller.**

- Call Customer Service to check the contact pressure.

## **The steel-wool roller padding is rusty and disintegrating.**

- Call Customer Service to check the roller padding, steam extraction system, ducting and condensate drain.
- In future, leave the ironer running after ironing for around 10 minutes with the trough raised and at the lowest temperature setting to allow the roller padding to dry.

# Problem-solving guide

## Visible discolouration of ironing cloth



### **Brownish discoloration of the ironing cloth**

To a degree, brownish discoloration of the ironing cloth is to be expected (especially at the ends of the roller). This is due to the effects of temperature.

### **Blackish discoloration of the ironing cloth**

Blackish stripes or patchy discoloration can be caused by singed or burnt foreign bodies in the trough, e.g. synthetic fibres or plastic buttons. Ironing cloths made from ARAMID needle felt are subject to graphite-black discoloration at the ends of the roller due to electrostatic charge.

- Clean the trough.
- Wash or replace the ironing cloth.
- Always observe the recommended ironing temperature on the laundry care label.
- Only use temperature-resistant cloths and feed/picker belts.
- Avoid running the ironer without laundry.
- Always use the entire length of the roller.

# Problem-solving guide

## Water marks or rust stains visible on the ironing cloth (PRI models)



### **The roller was not dried after ironing.**

- After ironing, let the ironer run for about another 10 minutes at the minimum temperature and with the trough raised until the padding is dry.

### **Moisture has penetrated the padding.**

- Install a non-return valve in the ducting if the ducting used is short or if the vent system is shared with other machines.
- Call Customer Service to check the ducting.

### **The ducting is blocked or its diameter is too small**

- Clean the ducting.
- Check that condensate can drain unimpeded from the ducting.
- Call Customer Service to check the ducting.

# Problem-solving guide

## Fabrics develop static charge during ironing (PRI models)

### **Laundry has too little residual moisture prior to ironing.**

- Increase the residual moisture by adjusting the setting in the tumble dryer.

### **The ironer is not sufficiently earthed.**

- Provide equipotential bonding.

### **The humidity in the room where the ironer is installed is too low.**

- Increase the humidity in the room where the ironer is installed.

### **The trough is insufficiently waxed.**

- Clean and wax the ironer regularly.

### **You are not using any additives to reduce static charge.**

- Fill a commercially available spray bottle (0.5 l) with a mixture of 50% water and 50% fabric conditioner. Spray the solution sparingly onto the ironing cloth on the roller about every 3–4 hours.



# Garment care symbols

## Care symbols

An easy, standardized and international system of care symbols provides advice on laundry care. An iron on the care label: Textiles can be ironed with a hand iron as well as with a rotary ironer at a low temperature. Dots indicate the ironing temperature.



Three dots correspond to a temperature of about 390°F | 200°C.



Two dots correspond to a temperature of about 300°F | 150°C.



One dot indicates that a temperature of about 230°F | 110°C is sufficient for ironing.



Items with this label should not be ironed.



# Fabric facts



## **Fabric knowledge in brief**

All textiles consist of fibers. These subdivide into natural fibers and synthetic fibers. Natural fibers again divide into vegetable (cotton, linen) and animal (wool, angora) fibers. Synthetic fibers are divided into natural (e.g. viscose) and synthetic (e.g. polyester) materials, depending on the raw materials used. All fibers have their own specific characteristics and properties which must be taken into consideration in laundry care. Miele caters for the needs of individual textiles.

# Fabric facts

## Cotton, linen

### Cotton

Cotton is one of the most popular natural fibers because it is very easily spun and is very resilient and durable. There are more than 300 different types of cotton shrubs. The largest cotton-growing regions are China (23%) and the USA (20%). Cotton fabrics are very easy to dye and bleach. But cotton does not have great natural elasticity, has a greater tendency to crease and does not have good insulating properties. Still, no other material is as robust as cotton.



**Ironing:** Use high heat (3 dots) and apply steam.



## Linen

This is a textile made from the fibres of the flax, or linseed, plant. Linen is a very durable and strong fabric. It is also very resistant to soiling and odours. As it lacks elasticity, it is very prone to creasing. Linen is mainly used for home textiles such as table linen but also in the fashion industry for light summer clothes.



**Ironing:** It is recommended to iron linen hot (3 dots) and preferably with steam. The non-stick soleplate provides additional protection against shiny patches.

Tip: Linen is easier to iron when starch is added to the final rinse.





## Fabric facts

### Nylon, polyester

#### Nylon

This fiber is also known as polyacrylic. It is made almost exclusively into spinning thread and is light- and chemical resistant, has a low density and a wool-like feel. Polyacrylic yarn is often used to make pullovers, imitation fur and blankets, often blended with wool.

**Ironing:** Nylon tends to shrink when subjected to intense heat. Because of its crease-free structure, nylon should only be ironed at a very low temperature (1 dot). The non-stick soleplate provides additional protection against shiny patches.

## Polyester

The fully synthetic fibers of this textile are extremely elastic, tear-proof and resistant to abrasion. They do not shrink and dry fast as they absorb only little moisture. Synthetics also keep their shape well and do not crease much.

**A Ironing:** Polyester is less prone to creasing and recovers easily. In the event that creases occur during washing or drying, they are easily smoothed by hand. Particularly persistent creases disappear when ironed at a low temperature (1 dot). The non-stick soleplate provides additional protection against shiny patches.



# Fabric facts

## Silk, viscose

### Silks

Silk is a natural fiber which is obtained from the cocoons of silkworms. The busy silk moths spin a very fine thread up to 4 kilometres long. Silk is characterized by its shimmering appearance and its very fine and light weight properties. Due to its distinctive smoothness and glamorous look, silk conveys a sense of luxury. Silk therefore requires special treatment.



**Ironing:** As silk is sensitive to high temperatures, it should be ironed at a moderate temperature (max. 2 dots) whilst still slightly damp. The non-stick soleplate provides additional protection against shiny patches.



**Tip:** A hand-rolled hem is a sign of high quality silk and should not be flattened during ironing.

## Viscose

Viscose is the most important cellular chemical fiber with a long tradition. As far back as 100 years ago, the search was on for a fiber which was as fine as expensive silk. It was discovered that thread from solubilized cellulose could be spun into yarn. Viscose is used to produce garment linings and summer clothes such as dresses, skirts, blouses, shirts, jackets and trousers. The knitwear industry has also discovered viscose.



**Ironing:** As with silk, its fibres are sensitive to high temperatures.

Viscose should therefore be ironed at a low temperature (1 dot) whilst still damp, or ironed with steam. The non-stick soleplate provides additional protection against shiny patches.



# Fabric facts

## Wool, woolen blends

### Woolens

Wool fibers consist of several layers. Wool has particularly good heat retention properties and is often used to knit warm pullovers or thick, soft winter wear such as scarves. The term wool includes, amongst others cashmere, angora, merino, lambswool and mohair. Pure new wool is the most common type of wool. It comes from sheep which are sheared twice a year.



**Ironing:** Woolen garments can be ironed at a medium temperature (max. 2 dots) and with steam.



### **Mixed fibers**

A good fabric is like a good perfume: It all comes down to the right blend and composition. Robust cotton becomes fine and elegant when blended with viscose, and cashmere blended with cotton becomes affordable. A classic blend consists of a combination of cotton and synthetic fibers, often referred to as polycottons. Microfibers are also made from a combination of various polymers.

**Ironing:** Microfibers are always ironed at a temperature which is suited to the most sensitive fibre in the textile. A linen and viscose blend would, for example, be ironed at a low temperature best suited to viscose.



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