

BASIC OPERATION AND SET-UP OF 394-TS/MTS MACHINE

(Use with Digital Knight Controller Manual)



REV 8/2014

ELECTRICAL:

The 394 machine is an air operated press that operates on 220v single phase power unless customize for your application. The machine is standardly made in one of two styles:

- 394-TS TWIN STATION (16" X 20")
208-240V SINGLE PHASE 3600 WATTS (17 AMPS)
- 394-MTS TWIN STATION (20" X 25")
208-240V SINGLE PHASE 4500 WATTS (20 AMPS)



PICTURE OF PLUG SUPPLIED ON STANDARD 394 PRESS

The machine is normally shipped with a 220v-30 amp power cord and plug. It is recommended that in either size machine be plugged into a 30 amp single phase outlet. This is to insure proper voltage and reduce any issues with heat recovery. Check with your local electrical code for specific requirements depending on actual loads. The 394-TS (16" x 20") can be plugged into a smaller 20 amp service, check with you local codes and a professional electrician to confer.

AIR:

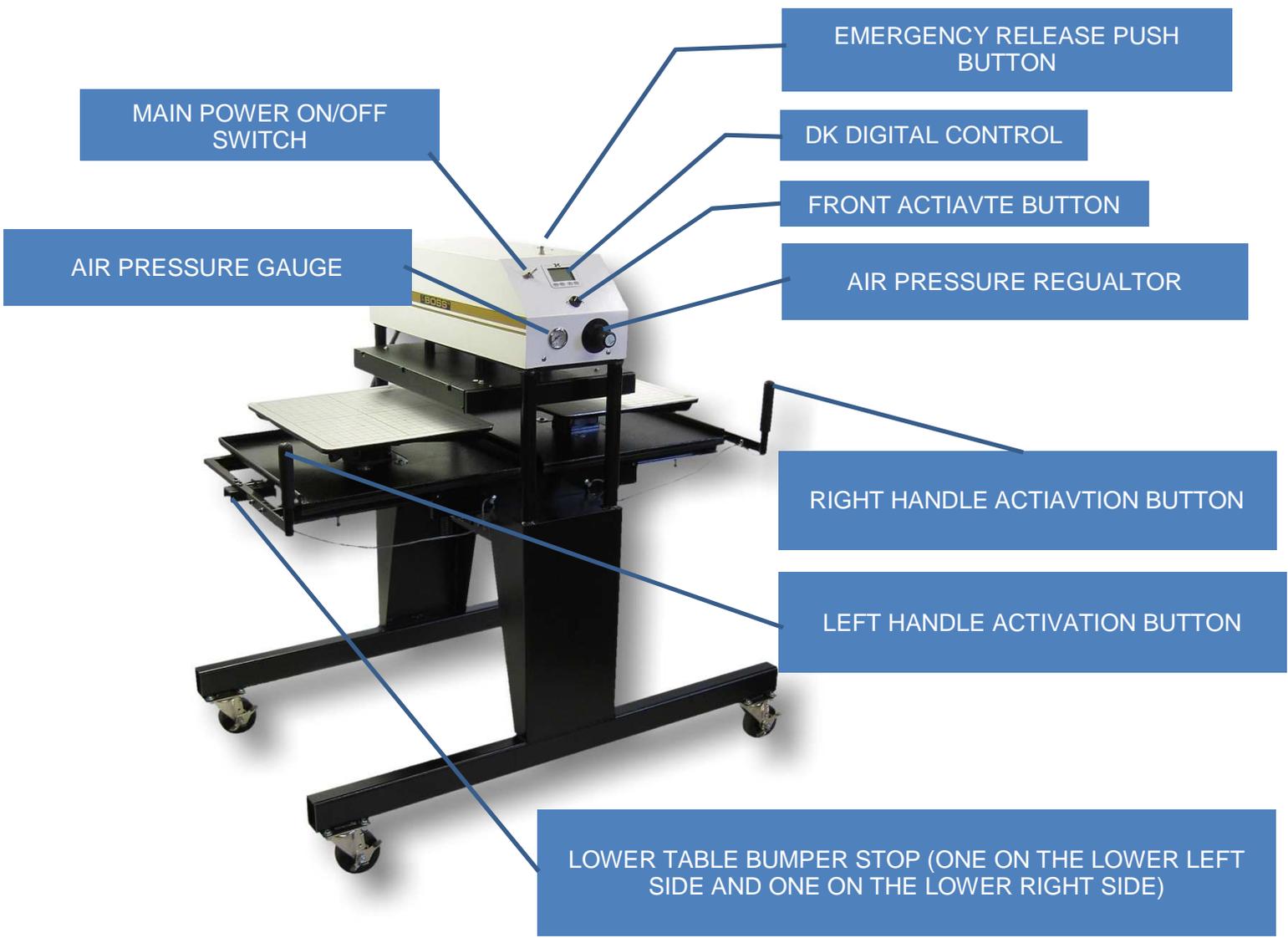
Either size press requires at least a 3/8" air line and the machines under normal use will use approx. ½ - 1 cfm. The normal air pressure supplied can be between 0-100 psi. **IT IS RECOMMENDED TO NOT EXCEED 100PSI ON THE OPERATIONAL PRESSURE OR PRESSURE SET ON THE MACHINE.** Normal pressings range from

20-80 psi max. The machine is equipped with a 3/8 NPT threaded female fitting on the back of the press. It is recommended you use a quick disconnect to attach to the machine. It is also recommended that you have a filter located before the machine to help remove water vapor and other contaminants from the air line before entering the machine. Most issues that occur in the future with the operation of the press can be traced back to DIRTY air and water not being drained from the air compressor being used or separated from the air line that the machine was attached to.

LOCATION:

Locate the machine on a clean level surface. You should be able to access the machine from any direction for future servicing. Once in place, lock the caster wheels to prevent the machine from moving around while operating.

MAIN CONTROL ASPECTS



BASIC CONTROLS AND OPERATION

TO ACTIVATE THE PRESS:

- Shuttle the lower table under the heater block area and make sure you keep the lower bumper stop pressed against the lower indexing switch.
- Use your thumb of the hand that is shuttling the table to depress the little black push button in the black foam handle. While the handle button is pressed, press the upper center position black push button on the front of the top cabinet.
- This will complete the circuit and the timer will activate, in turn the machine will press. Once the timer is completed, the machine will release.

TO RELEASE THE PRESS WHILE IT IS PRESSING (EMERGENCY RELEASE)

- Use the metal silver release push button located on the top of the control cabinet once to release the press. (NOTE: This is a push on/push off switch. Meaning you need to press this switch again to RESET the switch in order to operate again. DO NOT RESET THE RELEASE SWITCH UNTIL THE TIME HAS COMPLETELY ELAPSED.

TO SET THE TIME OR TEMPERATURE

- Refer to the separate Digital Knight Control Manual for basic time and temperature settings. Note: NOT ALL FEATURES IN THE DK CONTROL ARE USED IN THIS PRESS.

BASIC TROUBLE SHOOTING

MACHINE WILL NOT PRESS

- Make sure you have at least 20 psi reading on the air gauge
- Make sure the timer is indicating an actual pressing time (not 0:00)
- Press the RELEASE BUTTON once and try again.
- Make sure you have the machine pressed fully against the lower bumper switches.
- Are you pressing the handle and the center activation buttons?
- Contact the factory at 1-800-525-6766

THE TIMER IS COUNTING DOWN, BUT THE PRESS IS NOT PRESSING

- Press the RELEASE BUTTON once and see if that works.

THE MACHINE RELEASES FAST OR TOO SLOW

- Located under the machine in the center area is a BLUE colored air MAC VALVE. Attached to that valve is a QUICK EXHAUST valve that has a bronze adjustable exhaust muffler. This muffler has a threaded stud that you can turn in or out to adjust how fast the machine releases. TURN IT IN TO SLOW - TURN IT OUT TO SPEED UP the exhaust.

BASIC DO'S AND DON'TS

- Never press the machine without silicon padding. You do not want to over stroke the press or have METAL TO METAL contact with the heater block. Any questions, please call the factory.
- Never set the AIR PRESSURE for over 100psi on the front panel air gauge. In most cases, you can achieve the results you need with much lower pressure. High pressure may damage the press and impact it's life as well as can be a hazard to the operator if you exceed 100 psi.
- Never have the machine stroke more that 1-½" of travel unless you have a custom press or have checked with the factory. Doing so will damage your press.
- Apply a light grease to the lower shuttle table shoulder bolts as well as the lower lift plate blue spring shoulder bolts on a regular basis to insure long life.
- Spray WD40 or the like to the roller bearings and shuttle track on a regular basis or as needed if slight binding starts to occur.
- Protect the surface of the heater block with protection paper or Teflon like release sheets from materials sticking to the heated heater block.
- Make sure you drain the water from the air compressor on a daily basis to prevent water getting into the press. An air filter that traps airline water is recommended in the air line before the air enters the machine.
- Check on a regular basis that the lower table shoulder bolts have not loosened up as well as the lower blue spring shoulder bolts especially during heavy machine use.
- Do not place any items on top of the control cabinet that will impact the release button
- Lock the lower casters to prevent the machine from moving during operation
- Keep clean the area under the press for proper operation and blow out the lower part of the machine to prevent dust from building up on all moving parts.
- Keep the power cord clear of any items in the area to prevent damage to the power cord.
- Make sure you have the proper sized power supply and voltage to insure proper operation and long life
- If the machine is not working properly- Check for basic trouble shooting and contact the factory at 1-800-525-6766

The 394 is a solid heat press that has proven to give decades of none stop service. Simple basic maintenance and care is all that is required. In the event you should have trouble, we are able to solve the problem-ship parts if needed and get you back in service fast. When calling in, please have the model and serial number of the press as well as a clear understanding of what the machine is doing or not doing. If for any reason, the machine is not operating safely or properly- STOP AND CALL THE FACTORY.