

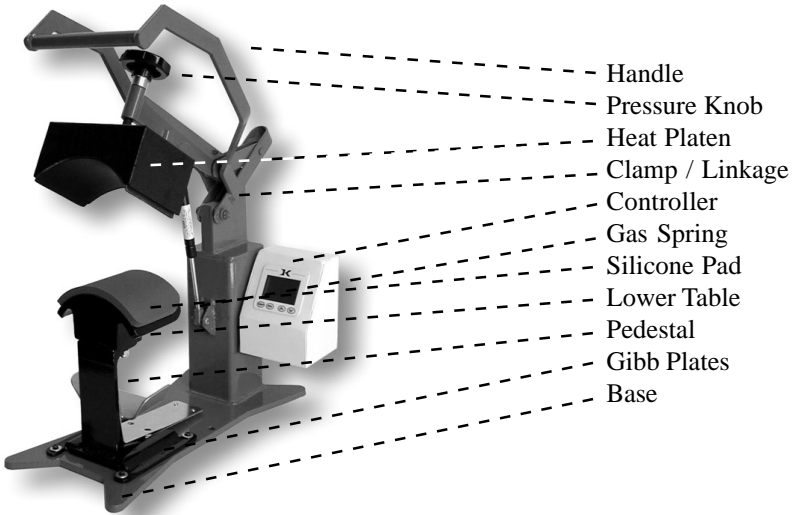
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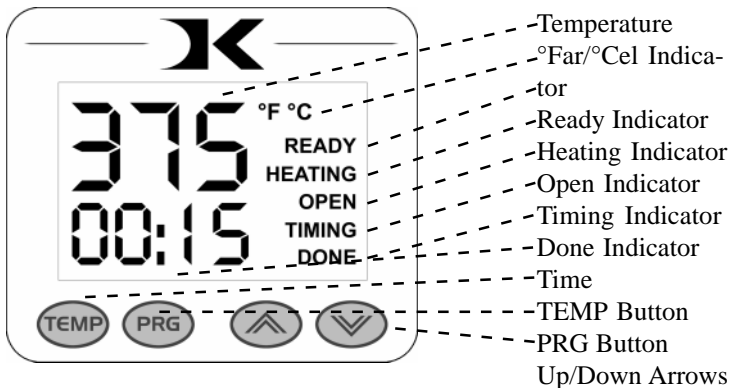
Introduction

This heat press machine has many exciting features, all of which are meant to help make your heat transfer pressing endeavors as successful and easy as possible. Please take the time now to thoroughly read through this manual to become acquainted with them. It will explain some key features, concepts and methods that will save much time and effort in using this press and in your heat pressing applications.

Throughout this manual, many areas and components of this machine will be referred to by specific names. Please refer to the illustrations below in order to become familiar with some of the terminology used in this manual.



Default Operating Mode of Controller



Setup & Suggestions

- Locate the press on a firm, sturdy work surface. It is highly recommended that the base be bolted to the workbench or a wooden pallet for additional stability.
- The height of the bench/work space the press is located on would be ideally 27” to 32” high.
- Attach the power cord from the rear to the backside of the controller. There is a power inlet on the back panel of the control box.
- The press should remain in the unclamped/open position when not in use. Do not leave the heater block closed on the table pressing surface when hot for long periods of time if not using. Heavy and prolonged exposure of the silicone padding to the heat platen will shorten the life of the silicone pad.

Basic Use

Setting Time

The time setting is always editable in the default operating mode of the controller. The left two digits of the time display are minutes. The right two digits are seconds. This can be changed to Hours/Minutes in the User Options Menu.

- Use the Up & Down arrow keys to change the time.
- Hold the Up or Down arrow key down to increment the values quickly. After a brief pause, the values will accelerate.
- Press the Up & Down arrow keys together to clear the setting to 00:00
- When the press is closed, the timing cycle starts. The “TIMING” indicator will appear.
- When the timing cycle is finished, the “DONE” indicator will appear.
- Depending on the timer alarm chosen, the alarm may continue to sound at the end of the timing cycle until the press is opened.
- When the press is opened up, the “OPEN” indicator will appear.



Setting Temperature

In the default operating mode of the controller, the displayed temperature is the **Current** temperature. This is the actual temperature of the heat platen surface. Please note that the operating range of the controller is from 150°F to 550°F (65°C to 288°C). During the first heat up cycle of the press, the controller will display 150°F (65°C) until the heat platen temperature rises above that temperature.

The **Set Point** temperature is the temperature the operator sets the press for. This is the value the press will regulate the **Current** temperature based on. The set point temperature may be changed whenever necessary:

- When in the default operating mode, press the TEMP button.
- The Current temperature will be replaced by the *blinking* Set Point temperature.
- Use the Up & Down arrow keys to change the Set Point temperature.
- Hold the Up or Down arrow key down to increment the values quickly. After a brief pause, the values will accelerate.
- Press the Up & Down arrow keys together to set the temperature to 350.
- When finished setting the temperature, press the TEMP button to return to the default operating mode.



- The control will regulate the heat platen temperature based on the set point temperature. When the temperature falls below the Set Point, the “HEATING” indicator will appear.
- When the temperature reaches the Set Point, the “HEATING” indicator will disappear and the “READY” indicator will appear.
- If the Set Point temperature is set to a temperature below the Current temperature, the press will wait to cool down to that Set Point. At that time, neither the “READY” or “HEATING” indicators will appear.

Setting Height / Pressure

- To decrease the pressure, turn the pressure knob to the right, clockwise.
- The top head will rise away from the lower table.
- To increase the pressure, turn the pressure knob to the left, counterclockwise.
- The top head will lower toward the pressing table.



CAUTION: The heat platen will become detached from the frame and drop onto the table if it is adjusted beyond the point of connection.

Aligning the pedestal

The table can be easily adjusted in a straight position if the heat platen does not correctly line up with the pressing surface. The pedestal the table rests on can slide front to back on the base of the machine. Loosen the screw in the gibb plates that holds the pedestal in place in order to adjust its position.

The pedestal can also be slightly rotated in order to align with the upper platen. Loosen all (4) screws holding the gibb plates in place, position/rotate the pedestal to the desired place, and retighten the gibb plates.

Guidelines & Standard Settings

The following information covers some basic guidelines for pressing, as well as some generic parameters for basic heat transfer applications.

- When pressing caps or shirts, it is often recommended that the items be quickly pressed for 2 seconds before transferring to remove wrinkles and water content.
- When pressing two sides of a garment, pull the garment over the table so that the printed side drapes underneath the table. This will avoid reheating previously transferred designs on opposite sides of garments. It will also avoid any bleed-through of inks on lighter fabrics.
- Avoid laying collars, cuffs, zippers, and other bulky parts of garments on the lower table, as these can adversely affect pressing conditions, and reduce the life of the silicone pad.
- When pressing rigid substrates (plastics, metals, woods, etc.), be sure that any protective films or laminates are removed before heating.
- Always check that the transfer image is face down against the material, to avoid sealing the image against the heat platen instead of the substrate.

Programmable Presets

This feature is ideal for recalling previously saved settings from various different applications. The presets are extremely easy to use, and bring a powerful level of accuracy to heat transfer pressing.

For example, the user may have Setting 00 for Hot-Split T-Shirts. When the user needs to perform that particular application, they simply select Setting 00, and the Current temperature & time parameters are updated. A pressure reference is also displayed, telling the user what pressure to set the press to. The user can then rotate the pressure knob until the gauge displays the same value that was stored and displayed by the preset.

This allows the user to quickly change from one application to another with extreme accuracy. Over time, the user will save many different settings in the presets based on the best results for every application. When those presets are selected, the user is immediately returned to the proper settings, without time consuming experimentation and risk of unsuccessful applications.

- From the default operating mode, to select a preset, press PRG.
- Use the Up & Down arrow keys to select a preset (00 - 70).
- Press PRG to update the current settings and return to the default operating mode.
- To edit or add a new preset, select the preset to be added/updated.
- Press TEMP to cycle through Temperature, Time & Pressure values.
- The editable value will flash indicating it may be changed.
- Use the Up & Down arrow keys to change values. Pressing Up & Down together when editing the temperature value resets it to 350, and 00 for time.
- After setting the pressure value, pressing PRG again will bring the user back to the preset selection screen.
- The user may press PRG to update the current settings and return to the default operating mode, or select another preset for editing/adding.



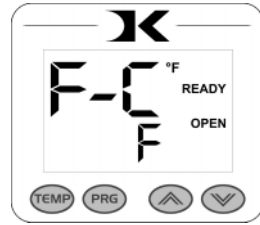
User Options Menu

The user options menu is a set of features and calibration options that are programmable and adjustable by the user. It consists of a set of menu items that can be scrolled through. Each menu item is a feature whose values can be viewed and /or changed. To enter the user options menu:

- From the default operating mode, press the TEMP & PRG keys simultaneously.
- If the keys are not pressed exactly at the same time, you may enter the temperature edit mode, or the presets mode. Exit either of those modes and try again.
- To cycle from one menu item to the next, press PRG.

Fahrenheit / Celsius

The Current, Set Point, and Preset temperature values can be displayed in Fahrenheit or Celsius. To change the value to F or C, use the arrow keys. Press PRG to move to the next menu item.



Timer Counter

The timer displays as factory default Minutes:Seconds. This can be changed to Hours:Minutes. To change to value to HR (hours:mins) or MIN (mins:secs), use the arrow keys. Press PRG to move to the next menu item.



Recorded Pressings

The digital control records the number of pressing cycles completed. This can be very helpful when counting the number of full pressings that have been performed. The value will scroll from left to right. A “-” sign will separate the beginning and end of the number. To reset the count to Zero, press an arrow key. Press PRG to move to the next menu item.



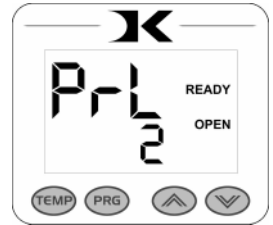
Height Gauge - High Point

This feature is not applicable on this press. Press PRG to skip this menu item.



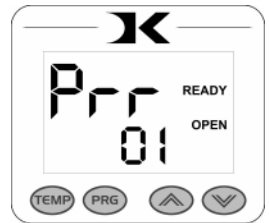
Height Gauge - Low Point

This feature is not applicable on this press. Press PRG to skip this menu item.



Pressure / Height Gauge Sensitivity

This feature is not applicable on this press. Press PRG to skip this menu item.



Drop Sense

A temperature alarm is available for warning the user of out-of-range temperature conditions. The user can set this menu item to sound an alarm if the heat platen drops below the Set Point temperature by the amount indicated. This can be helpful when pressing substrates that absorb an unusually large amount of heat, causing the platen to fall in temperature quickly. If the results of the transfer begin to deteriorate, the Drop Sense feature can help the user avoid this.

Use the arrow keys to set the degrees or to turn this feature off. If the Current temperature drops below the Set Point by this amount or more, an alarm will sound. The default value is OFF.



Beep

Normally, all buttons on the keypad beep when pressed. This can be turned off, so all button keypresses are silent. Use the arrow keys to turn this feature On or Off.



Alarms

There are 10 different alarms available to choose from. These alarms are sounded at the end of the timing cycle, as well as if the Drop Sense feature is enabled.

Use the arrow keys to change the values or to turn the alarm off. Please note the different alarms below.



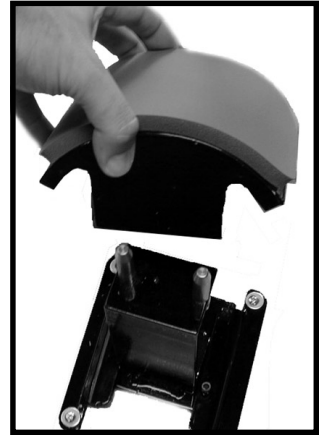
- denotes a short beep.
- _ denotes a longer beep.
- ~ denotes infinite loop.

<u>Alarm #</u>	<u>Alarm Pattern</u>
Off	No alarm
01	••• _
02	••• _ ~
03	•• _
04	•• _ ~
05	•••
06	••• ~
07	_ ~
08	_
09	•
10	• (shorter)

Interchangeable Tables

The lower table on the machine is interchangeable. Different sized optional tables can be obtained for various materials & handling requirements.

The tables simply fit right onto the pedestal. The 2 holes in the drop on tables & curved forms fit onto the 2 steel pins on the pedestal. Often times it is beneficial to leave one of the steel pins slightly loose to make changing out tables easier. This will not effect evenness of pressing or table stability.



Maintenance

The majority of the press has been designed to be as maintenance free as possible. There are only a few aspects of the machine that should be monitored to insure proper operation.

- The pressure adjustment screw is the area of greatest wear and stress on the machine and should be checked occasionally for loss of threading. Detach the heat platen from the frame by turning the knob to the left, counterclockwise, and check the threads of the pressure screw and the pressure block it screws into.
- Check the cord regularly to make sure there are no visible signs of damage. Make sure the modular cord does not come in contact with the heater.
- The silicone pad on the lower table can degrade after much use and over an extended period of time. This pad is replaceable. If the pad becomes dried out, cracked, or there are chunks removed from the silicone pad, this can result in inconsistent and poor quality transfers.

Troubleshooting

The following information attempts to address the most probable mechanical and user issues with the press. Most issues with heat transfer presses are application related. That is, they have to do with the results of a particular transfer application.

For technical support on problems having to do with the final results of a particular transfer paper or media, please contact the supplier of that transfer media. Generally, the machinery manufacturer is unable to support the myriad of different transfer papers, inks and imprintable items on the market from other resellers.

- Q.** The timer does not start when I close the heat platen, or the timer does not reset when I open the press up.
- A.** There are several probable causes for this. The timer is activated by a micro-tilt-switch inside the pressure sensor box. First: Check the wire connections to the control panel. The timer & pressure signals go to a small black 5-wire connector on the back of the electronics in the control box. Check to make sure this is firmly seated and plugged into the circuitry. Second: When the head of the machine is opened, the timer needs to be tilted at a certain angle to signal the controller to stop/reset. When the head for the machine is lowered, the timer needs to be tilted at a certain angle to signal the controller to stop/reset. Open the pressure box and manually rotate the tilt-switch to see if it is sending the proper signal.
- Q.** The control displays **Err** when it first comes on, and I can not set the temperature or use the press.
- A.** The **Err** message will display if the heating signal from the platen has been cut off, interrupted, or the heating sensor has failed. First check the green heat connector that plugs into the digital control. This is inside the top head. Unplug the power cord. Remove the two screws in between the clamp/linkage that hold down the top panel, and carefully lift the panel up and look inside at the digital controller. At the top of the controller, there is a green connector that plugs in. This is the temperature sensor wire. Check to make sure it is properly seated. Be sure not to unplug any other connectors. The temperature wire connects to the center of the rear half of the heat platen. Check this connection as well to see if the connection is correct.

Troubleshooting (cont.)

- Q.** I press the keys on the keypad, and there is no sound or response from the controller.
- A.** Check the connection of the keypad to the controller. This is inside the top panel. Unplug the power cord. Remove the two screws in between the clamp/linkage that hold down the top panel, and carefully lift the panel up and look inside at the digital controller. The keypad connector passes in through the top panel. It should wind around the first circuit board and be seated fully into the connector. Check the black keypad connector that plugs into the circuit board to see if it has pulled apart. Also check the area where the keypad connects to the front membrane to see if the leads have been damaged. The membrane keypad may need to be replaced.
- Q.** The gas springs are not lifting the head as easily as when the press was new, or the gas springs have lost their pressure.
- A.** After a large volume of use, and over an extended period of time of many, many pressing cycles, the gas springs will slowly lose their original force. These hydraulic lifter springs are extremely easy to replace, and are a surprisingly similar or even lower cost than conventional mechanical springs. Contact the factory for replacement gas springs if the lifting force is not able to maintain the platen in an open position.
- Q.** The press has shut off, and will not come back on after checking the power cord, on/off switch, etc.
- A.** Check the fuse. In the back panel of the control box, the power cord socket has a built-in fuse-holder. Unplug the power cord, and gently pry out the fuse-holder. If the fuse is burnt out or there is no continuity, replace it. If the fuse is fine, check the black and white wire connections from the power socket to the on/off switch, and from the on/off switch to the controller.
- Q.** I pressed a transfer upside down. The inks and transfer material have burned onto the heat platen.
- A.** Cool the press down. Using a nonabrasive detergent or cleaner, thoroughly scrub the heat platen surface. Do not use an abrasive scrubber, or a pad that will scratch the Teflon coating of the platen. Test whatever you use to make sure you will not remove the Teflon coating from the heat platen. If you are still unable to remove the transfer material, obtain teflon heater block cleaner from the contact information located at the end of this manual.

