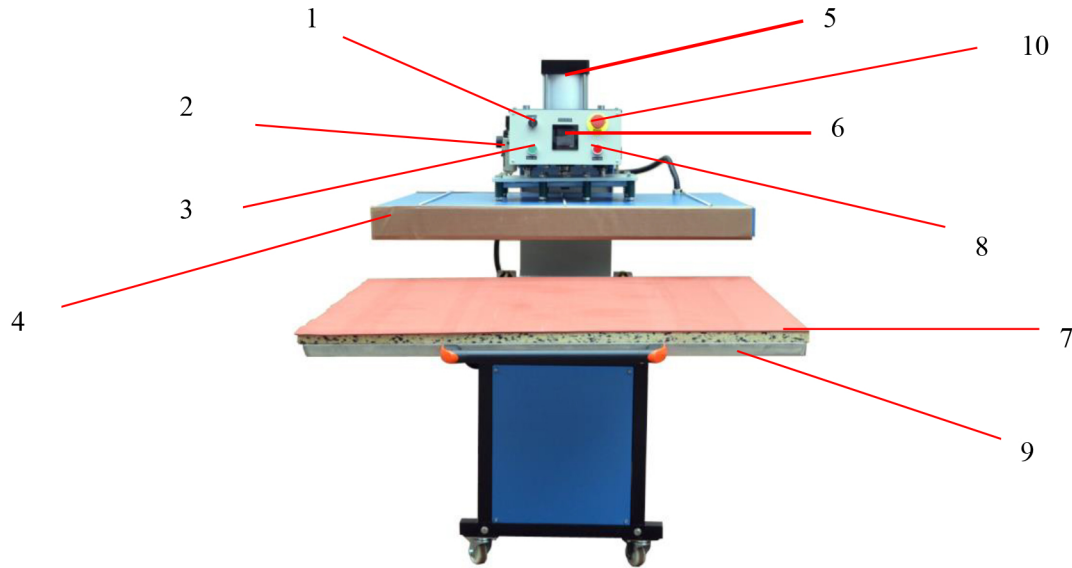


# Instructions of Standard Drawer-type Pneumatic Single Station

## Heat Press Machine



- ① Automatic/Manual button    ② Air processor    ③ Manual switch    ④ Heat plate  
⑤ Air cylinder    ⑥ Temperature Time controller displayer    ⑦ Silicone and foam pad  
⑧ Power switch    ⑨ Bottom plate(worktable)    ⑩ Emergency stop button

### A. Technical parameters

Size: 31.5 × 39 inch

Voltage: 220V, 1 phase, 60HZ

Power: 5.2KW

Current: 38Amps

Time range: 0-999 Seconds

Temperature range: 0-750.2°F

Pressure: 0-114 Psi

### B. Main uses:

This machine can transfer patterns and texts which are printed by sublimating ink or solvent ink onto fabrics like cotton, linen, chemical fabric, and nylon and ceramics through heat transfer technology. Flock printing and puff printing can also be achieved by this machine. It can be used to fuse cloth too, for example, clothes, caps, and shoes etc.

It is also suitable for small-scale of handkerchief production.

## **C. Product features:**

We use digital displaying thermostatic controller which provides high accuracy ( $\pm 2^{\circ}\text{C}$ ); Our heater is cast by imported aluminum alloy which is power-saving and temperature-uniformity, and only have little temperature difference; We use a digital timer which provides high accuracy and fine look; Our pressure adjuster enables you to adjust the pressure at will.

## **D. Operating Steps**

1. Connect to the matching compressor, open the pneumatic valve to adjust the pressure to 4pB-6pB to make the heater go up.
2. **Plug in the power, turn on the power switch (red bottom), the power indicating lamp lights. (Attention: the machine must have a reliable and protective ground wire)**
3. **Preset the needed time and temperature (See the details on the last page).**
4. After the presetting, wait till the heater heats up.
5. **The OUT1 light on the temperature displayer will go off then blink when the heating process is done (heat-retaining mode).**
6. **Put the substrate on the silicon pad and put the transfer paper on the substrate (please make sure it's the right side of the paper), then put the high-temperature resistant cloth on the transfer paper, push the platen to its working position then push the start-up button, the printing begins.**
7. **The heater will go up automatically when the process is done, then you can pull out the lower plate.**
8. **If the transfer paper requires to be removed in lower temperature, please remove it after 5 to 10 seconds, if not, please remove it as soon as the process is done.**
9. **After successful test-printing, you can switch the button to automatic mode. All you need to do is to move the handle to make the heater in a position above the substrate after you have settled the substrate, the printing process will begin automatically. When an emergency happens, push the**

**emergency stop button to stop the machine, the heater will go up automatically. The printing process continues when the emergency stop button is reset.**

## **E. Maintenance**

1. About pressure: If the pressure is unbalanced, use a ruler to measure the distance between the lower platen and the heater from 4 sides, if they are not the same, you can fix it by adjusting the nuts above the heater (tighten down makes the heater up, tighten up makes the heater down). If the pressure is too low or too high (normally the pressure is 4KG-6KG), please adjust the filter, press “ + ” to increase the pressure, press “-” to decrease the pressure, and you can check if the air compressor is in its normal condition (normally the pressure is 6KG-8KG).

2. About time: when the lower platen is in its working position, if there' s no display of time, please check the sensor and make sure the distance is shorter than 5mm; When the heater is not responsible in its due time, please check the electric circuit (intermediate relay).

## **Attentions**

1. This machine must connect to a reliable ground wire, then come into use, to ensure safe operation and production.

2. The pressure should be chosen appropriately, do not adjust the pressure arbitrary, so as not to damage the machine due to overpressure.

3. Do not put your hands under the heating plate during the pressing process, so as to avoid scald.

4. During the pressing process, in the case of special circumstances, press the emergency stop button, then the heating plate will automatically rise, so an accident can be avoided.

5. At the end of the work, the staff must cut off the main electricity supply and turn off the gas source before leaving.

## **F. Temperature and time requirements of different materials:**

**Pure cotton: 180-220 °C, 25sec**

**Polyester: 180°C, 15sec**

**Pearl board: 180°C, 120-180sec**

**Metal pendant: 180°C, 60sec**  
**Mouse pad: 180°C, 15sec**  
**Vitrolite: 220°C, 180sec**  
**Key ring pendant: 180°C, 100sec**  
**Ceramics: 180-220°C, 180sec**

## G. Time and Temperature settings

- 1. Temperature setting:** press the “SET” button, then the numbers on the lower line blink, temperature-setting mode starts. You can press ▲ and ▼ to adjust the temperature, press and hold the “SET” button for 2 seconds to confirm the setting.
- 2. Time setting:** press the increase and decrease button to set time. The letter “H” stands for “hour”, “M” for “minute”, and “S” for “second”.

## H. After-sale service:

If the machine damages or breaks down due to improper installation, improper maintenance or transporting damage. We'll provide maintaining and technical guidance, charge at accessory cost price.

