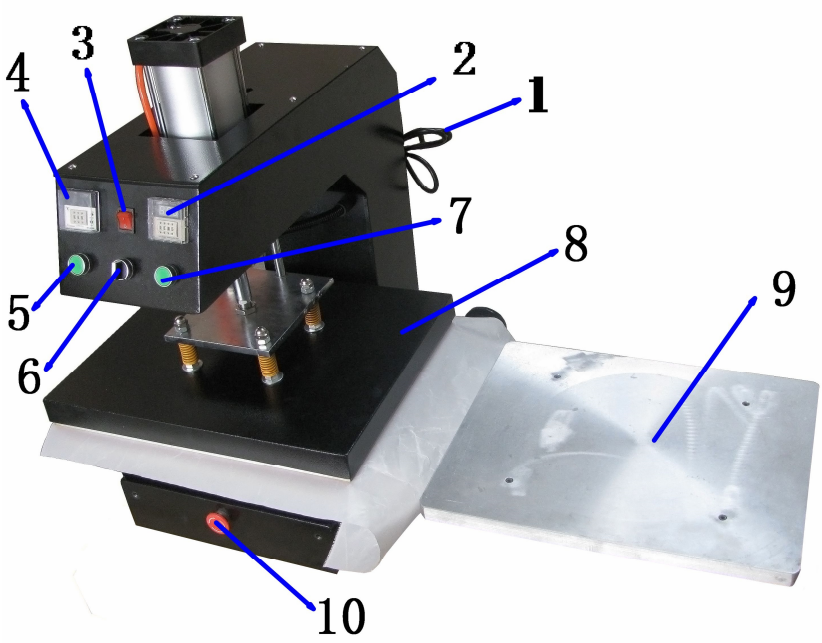
Double Station Pneumatic Heat Press Machine Operation Manual

1. Description of the Machine:

These are series of heat press machines which heating plate is driven up and down automatically by air pressure. After working plate is moved manually on position, the heating plate will move down automatically and hold pressure for preset time, and then move up. It can be used for transfer on fabric, sweatshirts, ceramic tiles, steel sheets, non-woven bags, etc. It also can be used for fabric ironing and heat treatment on screen printed textiles.

2. Structure of the Machine（The picture is for a reference only, the actual item is the standard）



1. Power cord　　2. Time controller　　3.Power switch

4. Temperature controller　　5.Manual start　　6. Selector(Manual/Auto)

7. Auto start　　8.Heating plate　　9.working plate　　10.Emergency-stop

PS: 1)Selector turns left is for manual(same direction as manual start),turns right is for Automatically(same direction as auto start)

2)Auto start: when turned on,the working plate will moving from right to left. When released the working plate will moving from left to right.

3. Product Features:

(1) Heating plate is driven by air pressure. Working efficient is 3 times more than manual heat press machine.

(2) Temperature, time and pressure can adjust and readout.
(3) The temperature of the heating board is even and stable.
(4) Holes in the printing platen eliminate vacuum between platen and foam pad. It can help to improve transfer quality.
(5) Foam pad can bare high temperature within 300 ℃ without deformed.

4. Setting Steps: (Require electrical power)

1) Plug in the machine. Make sure the electrical wire is at safety position and will not affect the operation.
2) Check and make sure proper quantity of the rubricate oil is in oil can of the air filter.
3) Connect windpipe to air compressor and make sure no air leakage from all the air supply system.
4) Pull up and turn the pressure control button on air filter, until pointer of pressure meter is on required pressure. (Heating plate will be raised up during pressure adjusting). Press the button down after adjusting.
5) Turn on the power switch.
6)Time and Temperature setting:

A：

Place 4 is temperature controller, you can set your ideal temperature through its "up" and "down" button.

B： Place 2 is timer, the third button from the left side counting stands for decimal and unit.

eg. "20S5" stands for 20.5seconds ,"03M5" stands for 3.5minutes, "04H6" stands for 4.6 hours

7)Adjust lubricating quantity by turning the oiling control knot on filter so that proper lubricating oil can be brought into pneumatic jack by air.(Suggestion turning it to minimum position to avoid excess oil leaking from wind releaser)

5. Operation Steps:

1）Put transfer items on the working plate(Let's suppose it on the right when original position of the heating head is upon left plate, and the selector is turn right-auto position), and cover the heat transfer paper(printed side down) onto the transfer item, at last cover the teflon sheet(if any) to protect transfer items.

2)press auto start button on, the working plate • will moving right under heating plate,until heating press down automatically and hold preset time.

3)During machine is working on operation2), repeat operation1) to put transfer item and transfer paper to the other working plate ，.

4)After heating plate moves up automatically from working plate • ,release auto start button to move working plate ， right under the heating plate, until heating press down automatically and hold preset time.

5)Put the imprinted item out of the working table and remove heating transfer paper from transfer item.

6)Repeat above operation to imprint items vicissitudinary.

7)Select manual or semi-automatic working mode by rotating selector"6" if necessary. When the machine is in manual mode, pressing manual start "5" to closing heating plate and hold preset time.

8)**Quick stop**: In case transfer item or transfer paper is found improperly positioned on the working plate, or any thing urgent happened and the machine needs to be stopped,please press emergency-stop button"10"; The upper heating plate will be automatically open. When you want to do the transfer again, please turn emergency-stop button rightward, and the button will be up; then the machine can be used again for transferring.

6. Trouble shooting

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.

Q1. The timer does not start when I close the heat platen, or the timer does not reset when I open the press up.

A1. There are several probable causes for this. The timer is activated by a micro-tilt-sensor stuck to the pressure arm. First: When the head of the machine is opened, the tilt sensor needs to be tilted slightly upward to signal the controller to stop/reset. When the head of the machine is closed, the timer sensor needs to be tilted downward (towards the floor) to signal the controller to start counting. Second: Check the wire connection from the tilt sensor into the control panel. The timer & pressure signals go to a small black 6-pin connector on the top of the circuit board in the control box. Check to make sure this is firmly seated and plugged into the board.

Q2. The control displays Err when it first comes on, and I can not set the temperature or use the press.

A2. 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 Lime Green temperature connector that plugs into the digital control. At the top of the controller, there is a green connector that plugs in with 2 small wires. This is the temperature sensor wire.

Check to make sure is it properly seated. If after unplugging and plugging the lime green connector the Err message still appears. unplug the green connector and remove the 2 tiny wires from the lime green plug. Cut them back 1/4" and strip them so they have new connections. Reconnect them to the lime green plug so they are screwed in tightly and can not pull out. Plug the green plug back in and turn the press on.

Q3. I press the keys on the keypad, and there is no sound or responsefrom the controller.

A3. 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.

Q4. The gas springs are not lifting the head as easily as when the press was new, or the gas springs have lost their pressure.

A4. After a large volume of use, and over an extended period of time of many, many pressing cycles, the gas springs will slowly loose 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 it is not able keep the platen open. The gas springs must have the silver rod Face Down, and the black tube Face Up.

Q5. The press has shut off, and will not come back on after checking the power cord.

A5. Test for power coming from the back side of the power cord inlet socket. Test for power coming from the back side of the on/off switch. Test for power coming to the end of the black & white wires that come from the on/off switch into the control board. This will narrow down which power handling component needs replacement. RPK-DKPWR is a common replacement kit that includes all these components.

Q6. I pressed a transfer upside down. The inks and transfer material have burned onto the heat platen.

A6. 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. If you are still unable to remove the transfer material, obtain teflon heater block cleaner from the factory.