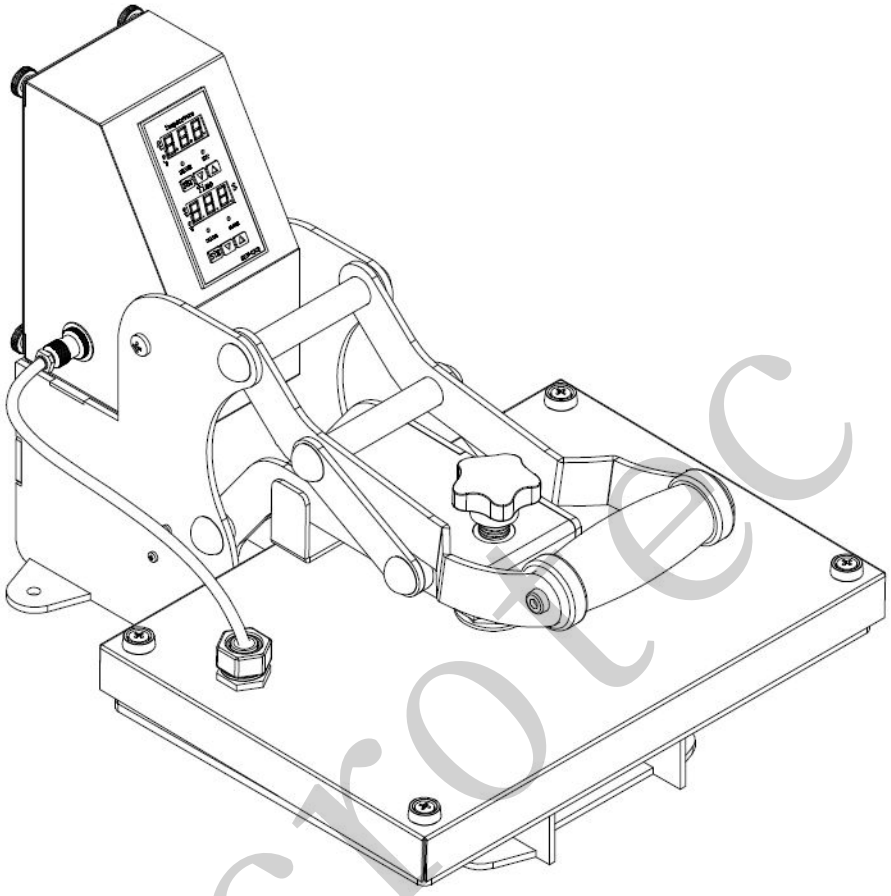
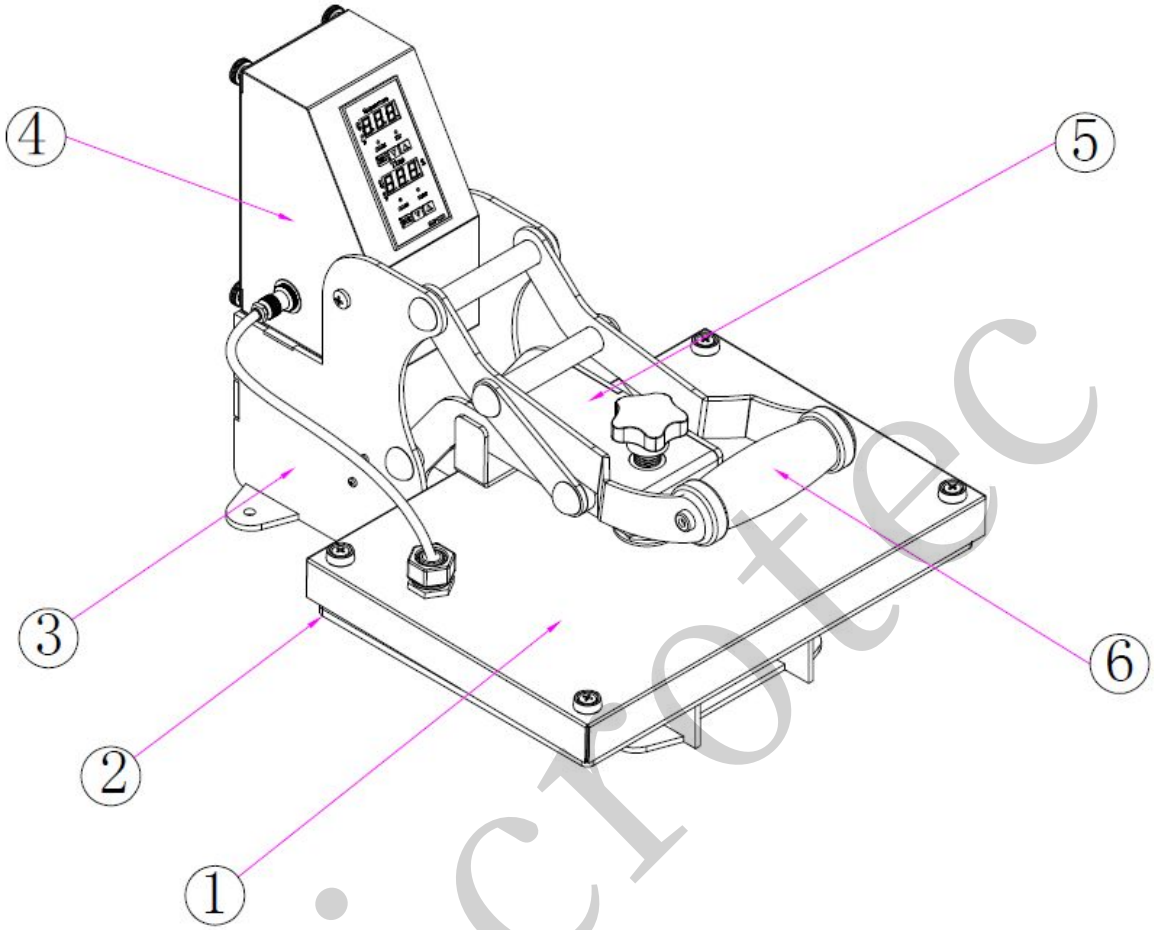
A4 Size Small Format Heat Press Manual



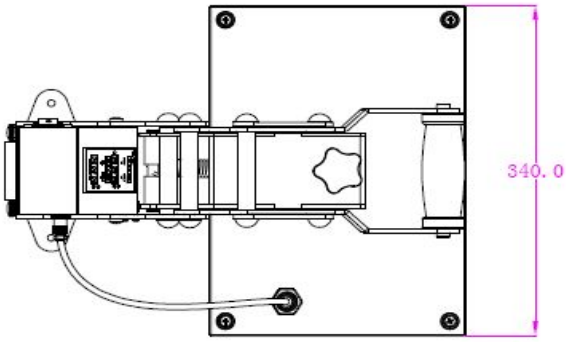
CONTENTS

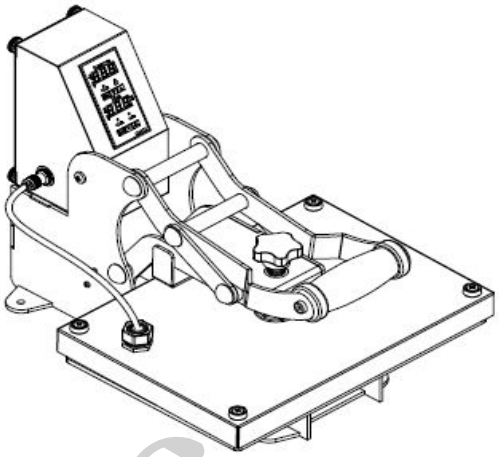
I. Assembly Drawing

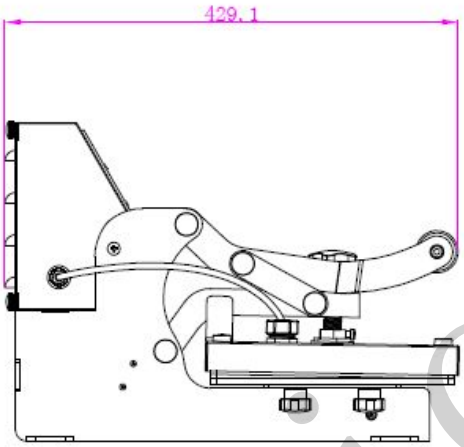


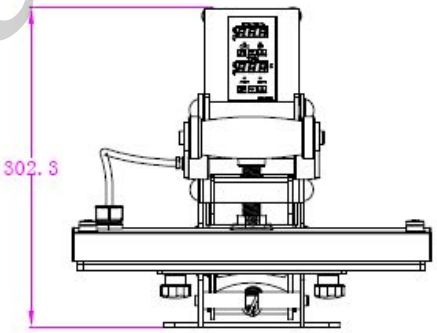
①Heat Platen ②Under Plate ③Machine Frame
④Electrical Case ⑤Machine Arm ⑥Handle Grip

II. Overall Dimensions



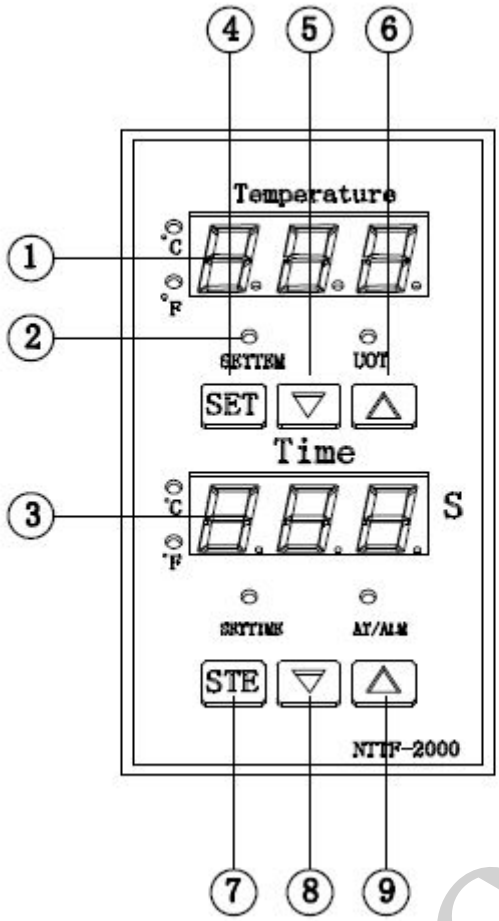






III.Operation Process

1. Brief Instruction about Digital Controller



①Display device for the set temperature(Green color) : to display the measuring temperature.

②Display device for the set time(Red color): to display the set time.

③Four indicators: (SETTEM: indicator of the set temperature (Green), lighting while set up the temperature (OUT: indicator of the heating output (Green), lighting while in working (SETTIM: indicator of the set time (Green), lighting while set up the set time (AT/ALM: indicator of Timing (Red), lighting while in working.

④Temperature function key：using to modify the set value of temperature, call out, update and confirm the parameters.

⑤Decrease key of the set temperature: using to modify the value of the set temperature and the control parameters.

⑥Increase key of the set temperature: using to modify the value of the set temperature and the control parameters.

⑦Time function key：using to modify and confirm the value of the set time.

⑧Decrease key of the set time: using to modify the value of the set time.

⑨Add key of the set time: using to modify the value of set time.

2. Machine Operation:

Step 1:Make sure the cord is connected well to the wall socket.

Place the printable blanks in the heat platen, and transfer paper with images facing down the blanks, adjust moderate pressure, use heat resistant tape to fix the transfer paper, make sure transfer paper is exactly attached to blanks; and then power on.

Step 2: After power on, there will be full display on upper and under meter about within 10 seconds.

1) Set temperature required：press “SET” button on the upper controller, then the indicator “SETTEM” is lightening; the upper panel displays the temperature value, Press ▲ or ▼ button to set the temperature value you need.

2) Set time required: press “SET” button on the bottom controller, the indicator “SETTEM” is lightening; the under panel displays the value of time, Press ▲ or ▼ button to set the time value you need.

Step 3: After set the temperature and time required, then machine starts to heat up.

Step 4: When the temperature rises to the setting temperature, the buzzer sends out sounds; then press down the heat platen, (meantime the buzzer sounds stop) and transfer begins. At the same time, the time counting down starts.

Step 5: Once time is up, lift the handle and take out the finished substrates. Transfer work’s done.

Note: Using the similar way when you need to transfer other substrates by using the plain heat platen. But the printing parameters are different from different items.

Recommendations:

1)Key Chains & Photo Slate transfer:

Set temperature:180℃.

Set time: 100~120 seconds

2)Jigsaw Puzzle transfer:

Set temperature:180℃.

Set time: 60~80 seconds

3)Wallet transfer:

Set temperature:180℃.

Set time: 120~140 seconds

3.Digital Controller Operation:

1) Set the Control parameters:

Press SET button on the upper controller for 4 seconds above, it displays prompt code of the parameter (please refer to the below schedule table of the control parameters for detail information), Press ▲ or ▼ button to make the under panel displays the needed value of this parameter. Continue to press the SET button of upper cotroller, the upper panel displays the prompt code of each parameter in turn, Press ▲ or ▼ button to display its needed value. Again press the SET button on the upper controller for above 4 seconds, the system return to its standard mode (no press the button after 1 minute , the system come back to its standard mode automatically).

2) If under the Time controller displays an "ooo":

The thermocouple is in reverse connection, else above the Time controller displays an "ooo", the thermocouple is in open current or the measuring temperature exceeds the measurement range of the instrument.

3)The Auto-tuning function of the instrument's parameters:

After 20 seconds of pressing the left ▲ button on the upper controller, the AT indicator is twinkle and the controller begins to start up the Auto-tuning. After the temperature goes through once or twice of oscillation, then the AT indicator extinguishes. The instrument will control the process with the updated parameters, which will be permanently persevered.

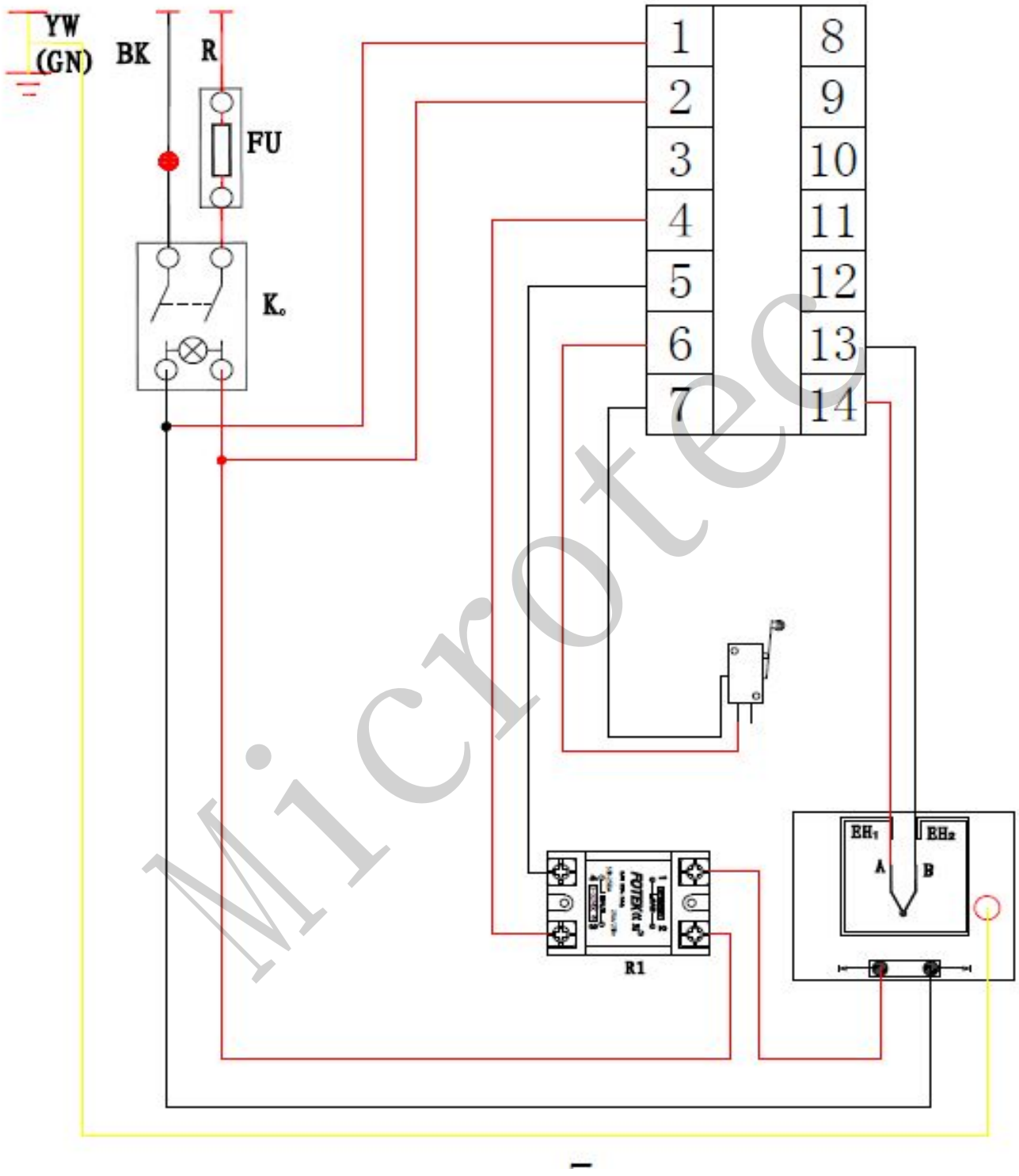
4. Table of Digital Controller's Parameters:

Press ▲ and ▼ button at the same time, the upper panel displays LK, set it to 88, then Press SET button, it'll display the below prompt code.

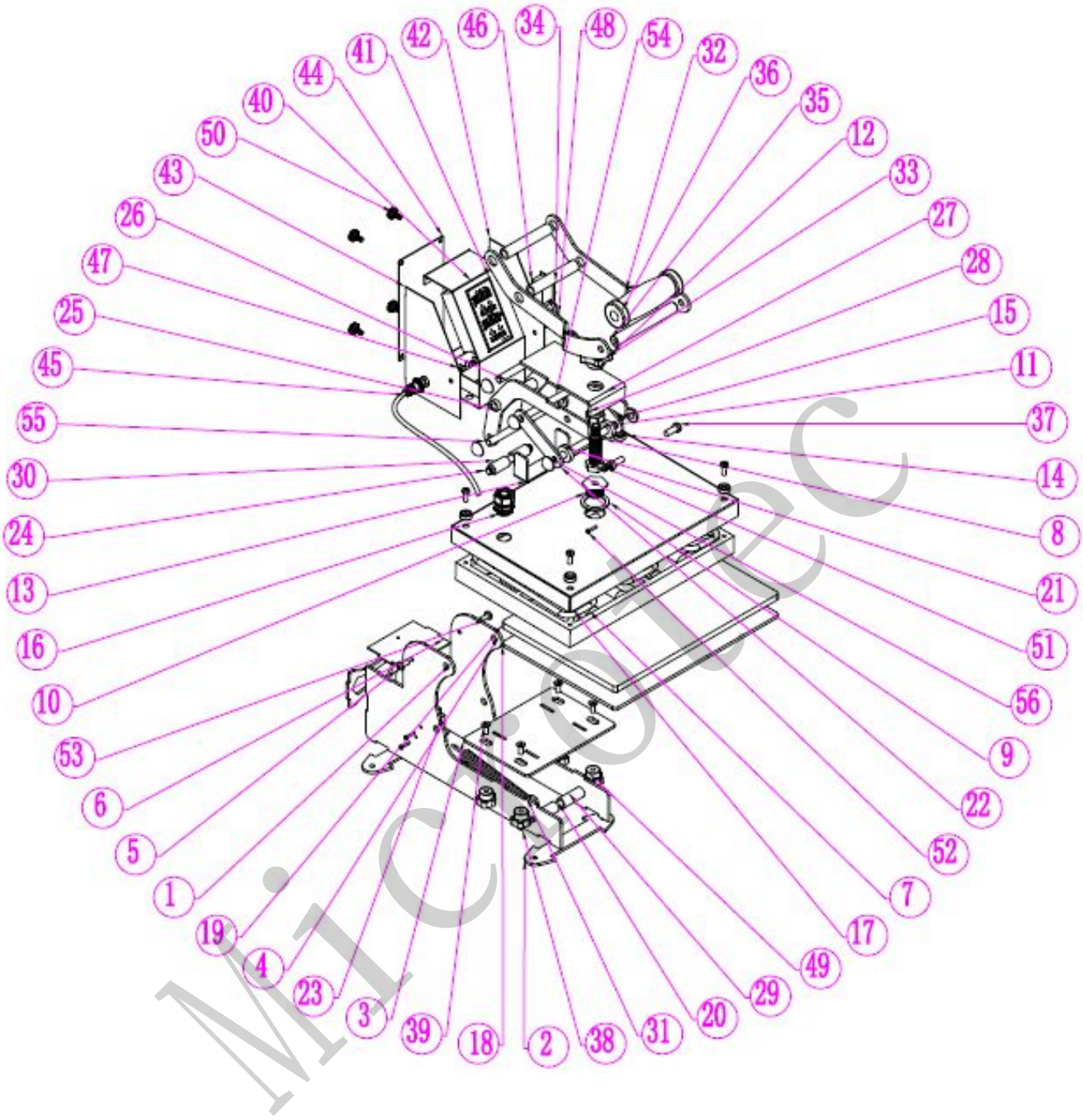
Prompt Code	Name	Setting Range	Explanation	Factory Value
rt	Measuring Revise	-100～100℃	Used to revise the measuring deviation caused by the thermocouple and compensating line.	0
Ar	Overshoot Suppression	0～100℃	Decreasing Ar can reduce the temperature overshoot. When SP changes, Ar have to re-set. After auto-tuning, Ar will be adjusted automatically according to SP. when P = 0, Ar becomes the Dead Band of the control，while Ar=0 the Band is equal to 0.4℃ and when Cr=0, Ar is the reset of time proportional control.	100
P	Proportional Range	0～800	Proportional control: The more P, the less the proportional control and the lower the system gain. When P is too big, the time of the temperature to achieve its setting value is too long; otherwise if P is too small, the measuring temperature will appear oscillation .	30
T	Control Period	1～100 Seconds	Relay output is not less than 20 seconds; for SSR external device, T takes 3 seconds.	20 3
Cr	System Constant	0～999	Concerned with heating power, heating-up time, the location of the thermocouple, the Proportion Range of the instrument and other factors. The general inertia of the major targets of Cr should be larger. Generally for the control process with large inertia, Cr should be larger. When P≠0,Cr=0, the system is a time proportional control one	240
LC	Coded Lock	0～2	LC = 0: All parameters can be modified; LC = 1: can only modify the setting point value (SP); LC = 2: All parameters can not be modified.	0
Sn	Calibration Mark		K: 0~700℃ E:0~400℃ J:0~550℃	0
run	Operating Mode	0;1;2;	Run=0 express Timing Setup by switch and time counting reversely; Run=1 express Timing Setup by the set temperature, when temperature arrives to its set value, begin the time counting reversely automatically; Run=2 express system with both of high and low temperature control, when temperature is less than the low set value, system have an output, when arrives the low set value, the system have no output, and arrives the high set value the system have no output and close the switch and begin the time counting reversely.	0

Prompt Code	Name	Setting Range	Explanation	Factory Value
Ft	Filter Coefficient	0～255	The less the Filter Coefficient, the more sensitive the response, but too less of the Filter Coefficient may cause oscillation; otherwise the display will be relatively stable	200
CF	Temperature Transformation	0;1;	Centigrade temperature while CF=0; Fahrenheit temperature while CF=1	0
dF	Dead Band	0~100℃	This parameter can adjust the Dead Band of the ON-Off instrument	0
rL	Lower Limit of the Range		According to the user's requirement	0
rH	Upper Limit of the Range	0~400℃	Adjusting rH can make the range of the instrument 0~rH(℃)	User Require-ment

IV. Wiring diagram



V. Exploded view



Item	Part name	Specification	Quantity
1	Left Panel		1
2	Fixing Plate		2
3	Under Platen's Fixing Plate		1
4	Right Panel		1
5	Rear Fixing Plate		1
6	Electrical Case's Base Plate		1
7	Heat Platen		1
8	Heat Platen Cover		1
9	Spacer	⌀ 30 x 2	1
10	Coupling Nut	M 20	1
11	Adjusting Screw	M 16 x 73	1
12	Adjustment Hand well	M 8	1
13	Anti-shaking "U" Shape Plate		1
14	Plastic Washer		4
15	Half Round Head Screws	M 6 x 10	4
16	Amphenol Connector		1
17	Heating Tube		1
18	Lower Platen	230 x 330 x 5	1
19	Silicon Pad	230 x 330 x 10	1
20	Spring Fixing Axis	⌀ 10 x 92	1
21	Heat Isolation Unit		2
22	Connecting Piece		2
23	Limit switch		1
24	Spring's Snap Ring Fixing Axis		1
25	Arm's Welding Axis		1
26	Arms' Side Panel		2
27	Arms' Upper Panel		1
28	Adjusting nut	M16	1
29	Spring's Heat Isolation Unit		2
30	Spring's Heat Isolation Unit 1		2
31	Spring		1
32	Right Handle		1
33	Left Handle		1
34	Handle's Welding Axis		2
35	Fixing Axis for Handles		1
36	Handles Grip		1
37	Handle locking screws	M 8 X 15	2
38	Locking screws of Handle	M 6 X 12	2

Item	Part name	Specification	Quantity
39	Under Plate's Fixing Screws	M 6 X 10	4
40	Electrical Controller Panel		1
41	Digital Controller/Computer Gauge	NTTH/F-2000	1
42	Electrical Case's Right Panel		1
43	Electrical Case's Left Panel		1
44	Electrical Case's Rear Panel		1
45	Air Plug	Four pins	1
46	Power on Switch		1
47	Relay	SSR-40DA 40A	1
48	Plug Socket Place		1
49	M6 Hand screws		4
50	Hand-twisting Screws	M 5 X 10	4
51	Locking Screws	M 5 X 10	1
52	Fixing screws	M 3 X 15	2
53	Round heat screws	M 5 X 15	2
54	Rivets shaft	⌀ 10 x 112	2
55	Rivets shaft	⌀ 10 x 113	2
56	rivet		8
36	Handles Grip		1
37	Handle locking screws	M 8 X 15	2
38	Locking screws of Handle	M 6 X 12	2
39	Under Plate's Fixing Screws	M 6 X 10	4
40	Electrical Housing's Panel		1
41	Digital Controller/Computer Gauge	NTTH/F-2000	1
42	Electrical Case's Right Panel		1
43	Electrical Case's Left Panel		1
44	Electrical Case's Rear Panel		1
45	Air Plug	Four pins	1
46	Power on Switch		1
47	Relay	SSR-40DA 40A	1
48	Plug Socket Place		1
49	M6 Hand screws		4
50	Hand-twisting Screws	M 5 X 10	4
51	Locking Screws	M 5 X 10	1
52	Fixing screws	M 3 X 15	2
53	Round heat screws	M 5 X 15	2
54	Rivets shaft	⌀ 10 x 112	2
55	Rivets shaft	⌀ 10 x 113	2
56	Rivet		8

VI. Maintenance

1. After changing heat platen, time and temperature showing become abnormal:

   Solution：refer to manual and make time/temperature reset.

2. If the color is not as bright as photo after printing, please try below ways:

   a. adding transfer time

   b. increasing transfer temperature.

3. If the print color is too brown or the transfer paper is almost burnt: need to reduce the setting temperature.

4. If the print is blurring: too much transfer time. Please decrease the transfer time.

5. If print color is different/ partial transfer effect is not good enough: the pressure is not enough / or not pressed long enough / or poor quality transfer paper.

6. If transfer paper sticks to the object after transfer: the temperature is too high/ or poor quality printing ink.

7. In order to prolong machine's using lifespan, please add the lubrication oil regularly.

8. In order to keep the heater's good transfer quality, please do take good care of the heater carefully whatever you are using or not.

9. Please keep this machine in dry place.

10. The machine should be well placed after changing parts and do not damage heat platen which will cause bad transfer performance.

11. If machine gets not working, please contact supplier as soon as possible to get technical support. and then deal with machine according to supplier's guidance.