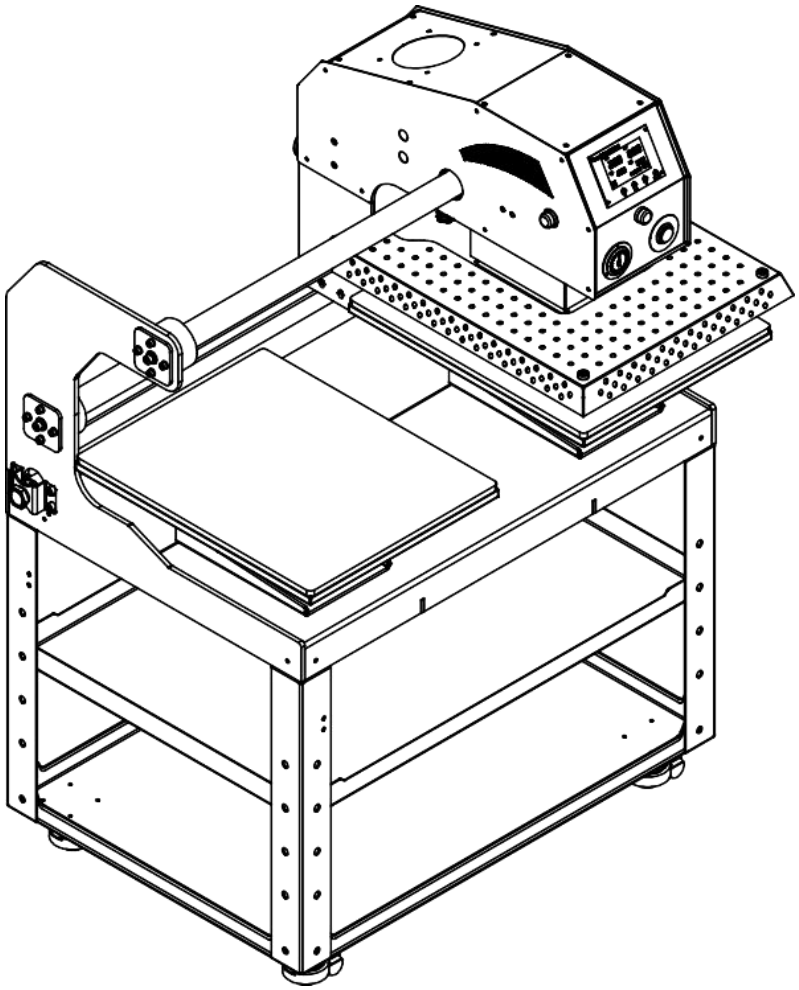
Fully Auto Pneumatic Dual-Station Shuttle Heat Press

XPDS-20



CONTENTS

I. Technical Parameters

1. Platen Size: 15"x15"/16"x20"

   (38x38cm/40x50cm)

2. Controller:GY-08 Digital Time & Temp. Control

3. Printable Articles: Up to 32mm Thickness

4. Air Compressor Required: Yes

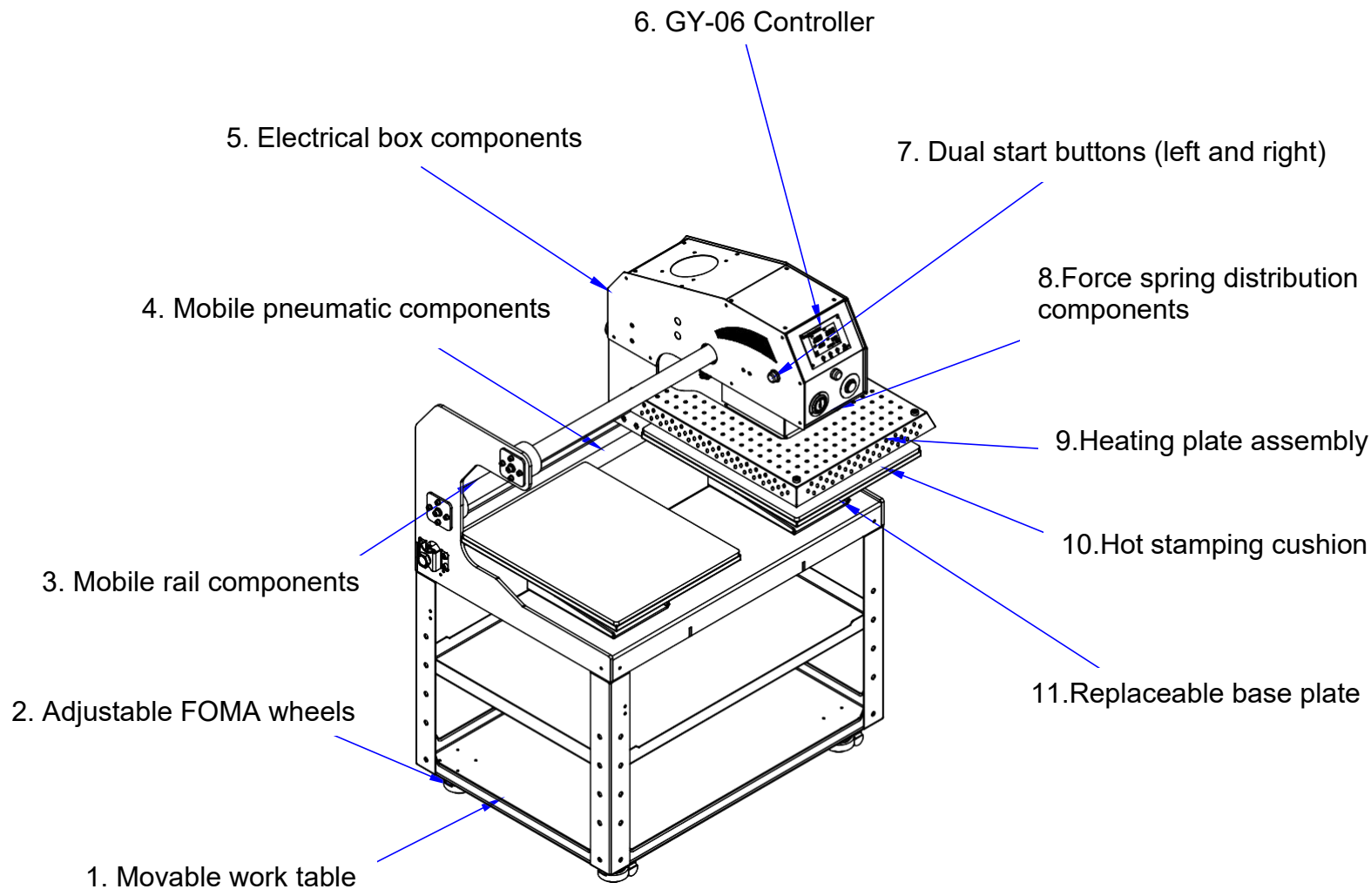
5. Voltage: 120V/ 220V

6. Power: 1.6KW/ 1.8KW

7. Time Range: 0-999 sec.

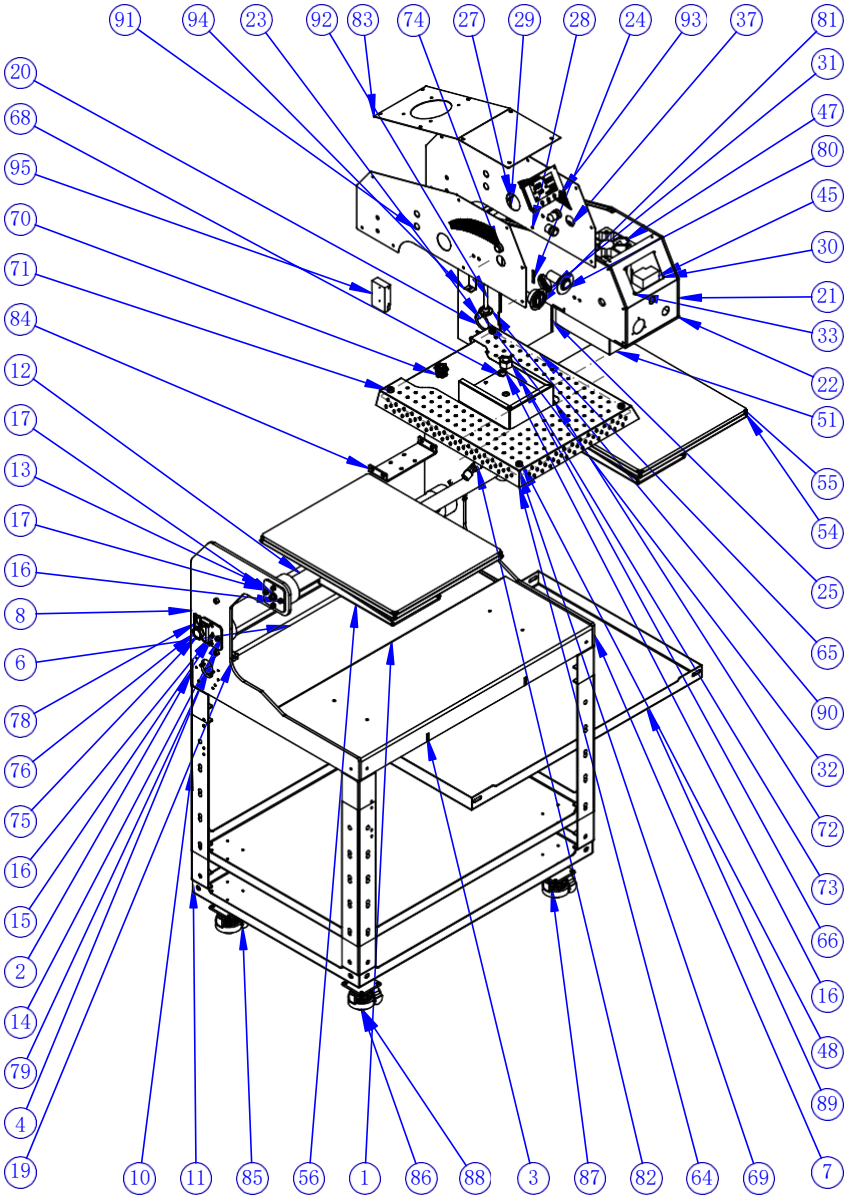
8. Maximum Temp: 225 C

II. Assembly Drawing



1. Movable work table	2. Adjustable FOMA wheels	3. Mobile rail components	4. Mobile pneumatic components
5.Electrical box components	6. GY-06 Controller	7. Dual start buttons (left and right)	8. Force spring distribution components
9.Heating plate assembly	10.Hot stamping cushion	11.Replaceable base plate	

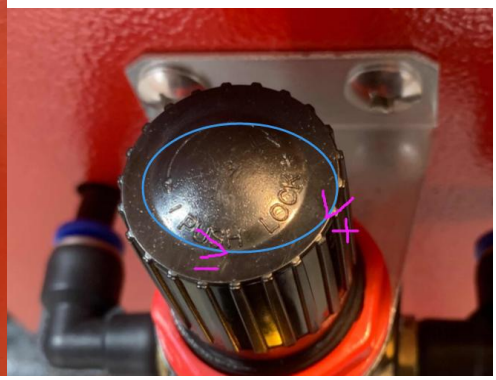
III. Explosion View



Item	Part	Quantity	Item	Part	Quantity
1	Base plate	1	49	Tank chain fixing plate head	1
2	Frame 6 board	1	51	Upper and lower cover 2	1
3	Short board 6	2	53	Circuit board	1
4	Machine foot 6 board	1	54	Bottom plate 45465	2
5	Machine foot triangle board 6	2	55	Swedish machine silicone pad	2
6	Tank chain support plate	1	56	XPDS bottom plate U-shaped bracket	2
7	Side plate-002 on both sides	1	57	XPDS U-shaped reinforcement rib	2
8	Side plate-001 on both sides	1	58	TS quick-release disk-4.-20	2
9	Wire buckle	4	59	XPDS large sliding guide plate 1	2
10	Worktable support foot T new	8	60	XPDS sliding guide plate 2	2
11	Worktable panel 2 new 2	2	61	TS sliding guide plate 3	2
12	40 chrome-plated rod 880	2	62	400x500 heating plate 2	1
13	Plug 5 board	4	63	500x8 heating tube	1
14	80 premium glue 42	4	64	XPDS cover plate	1
18	Power cord seat	1	65	XPDS heat insulation plate	1
19	Cylinder 10 joint 4	1	66	XPDS turn ⑩ plate	1
20	XPDS head left side plate	1	67	XPDS turn ⑩ plate 1	1
21	XPDS head right side plate	1	68	Mold spring 24	4
22	XPDS cylinder fixed plate	1	69	Heat insulation plate hollow aluminum rod 8	4
23	Short bearing fixed plate	1	70	New snake pipe ⑩ head	1
24	Long bearing fixed plate	1	71	Heat insulation plastic ring	4
25	XPDS electrical installation plate	1	72	Upper and lower cover 1	1
26	Wire hook	2	74	Starter switch	3
27	Rear cover fixed plate	1	78	Fixing seat	2
28	Upper cover fixed edge	2	81	Pressure gauge	1
29	Rear cover fixed edge	2	82	Infrared	2
30	Front electrical installation plate	1	83	Top cover plate	1
31	40 slider	1	84	Rodless cylinder mounting plate 2	1
32	Short bearing	1	89	Workbench panel T new	1
33	Stroke cylinder	1	90	Cylinder guide bushing	1
34	Rear engine hood cover	1	91	Left and right decorative panels	2
35	Transformer	1	92	XPDS chrome-plated anti-sway bar	1
36	Relay	1	93	GY06 controller	1
42	Filter fixing plate	1	94	Limit fixing bracket	1
44	Intermediate relay	1	95	Infrared power	1

IV. Operation

1. How to adjust the pressure

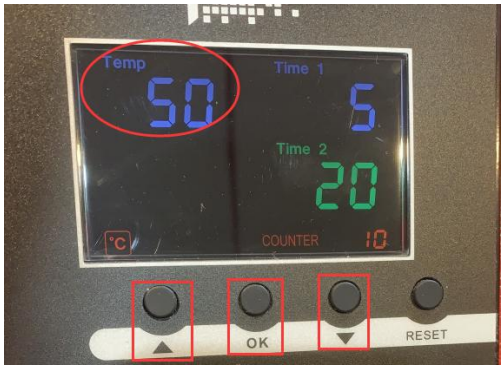


1) Connect the heat press with air compressor or air sources
2) Lift up the cap of air valve as the picture shown
3) Revolve the cap anticlockwise, the air pressure goes down; contrariwise, the air pressure goes up; when you finish the pressure adjustment, push down the ca
4) Suggested air pressure is 0.4~0.5Mpa/ 70-80Psi. It depends on the transfer mate

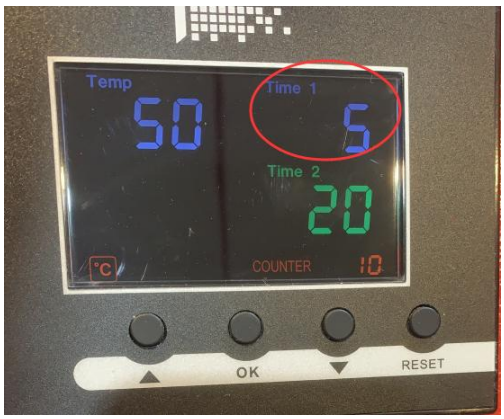
2. Plug the power cord into a standard 120V or 220V outlet and turn on the heat press by pressing the power switch located on the side of machine. Be sure that your heat press is positioned evenly on a steady and level surface. If using an extension cord, be sure it is industrial grade.

3. Heat transfer parameters settings. （GY-08）

A. Press “OK” button to enter TEMPERATURE setting .When the TEMP indicator blinks, use “Up/Down buttons” to set the required temperature and then press “OK ” button again to complete the temperature setting.

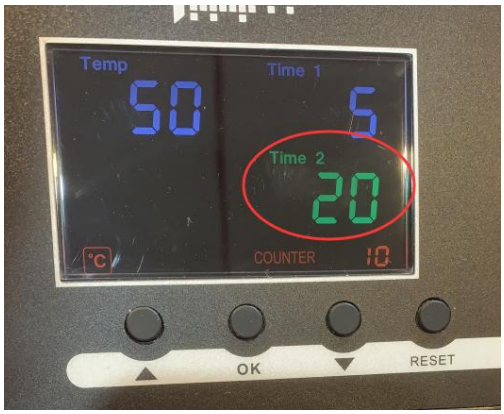


B. Press “OK” button to enter PREHEAT TIME setting When the TIME1 indicator blinks, use Up/Down buttons “” “” to set the required time for preheating and then press “OK” button again to complete the setting.



C. Press “OK” button to enter TRANSFER TIME setting

When the TIME2 indicator blinks, use Up/Down buttons “” “ ” to set the required time for transferring and then press “OK” button again to complete the setting. If you don’t need to preheat the transfer material, TIME1 and TI ME2 can be set in same values, and then the machine will be operating in same transfer parameters in cycle.



D. After finishing above-mentioned settings, your machine is ready for pressing.

E. Long press ‘OK’ button of the controller for 4~5 seconds enters to engineering pattern

P-1 :Temperature Mode: Press “▲▼” to switch Celsius degree/Fahrenheit deg

P-2 Temperature Difference Calibration Mode, setting range is -50~+50;

P-3 Constant Temperature Mode, interval range is 0~10
P-4 Heating time and pause time, setting range is
P-5 Constant Temperature Heating Mode, Setting range is 0-10S
P-6 Sleep Mode, sleeping time 0~2
P-7 Counter (Million progressive system), it cannot be cl

4.When the temperature reached to the set value, you can start the transfer printing by following below steps:

A. Place the transfer material flat onto the heat press pad
B. Press the station switching button to move the heat plate to the transfer station.

Warm reminder: Adjust the air pressure knob on the back of the machine to adjust the moving speed of the station switching. If it is adjusted too fast, the machine will easily shake. Please adjust it to a suitable speed.

C. Press the start buttons with BOTH hands at the same time, heat platen press down automatically, TIME1 indicator blinks and preheat timer starting to countdown.

D.When the timer counts to 3, the buzzer sounded; the heat platen opens automatically when the time counts to end.

E.During transfer, transfer materials can be prepared at another station at the same time.

F.When D E is finished, please cycle through the two steps B C.

Note: If you don’t need to preheat the transfer material, set the TIME1 and TIME2 in same value, then the machine will be operated in transfer parameters in cycle.

G.During the operation, if there is an unexpected situation for an emergency stop, press the "Reset" button to stop this operation.

H.During operation, the operator should pay attention to safety protection, avoid body touching on hot spots from crush injuries and burn risks.

I. This machine helps minimize the physical labor of the operator; it has a self-interrupting function and can work for a long time. Click a button to automatically switch stations and cycle transfer.

V. Maintenance

1. Air pressure

Checking the lubricating oil If it's enough in the Cylinder. Use the pressure knob on the Air Regulator to adjust the pressure, turn toward "+"direction to add the pressure, "-"direction to reduce the pressure.

2. Heat Platen Not Goes Down: If digital display show normally, but when you press green start button, the heat platen not goes down

1). The limit value under the bottom platen doesn't touch the counting down switch because of its too high position. Please loosen the value's screw a little to make it longer.

2). Checking the circuit connecting with green start-up switch if it's with problem.

3. No action after turn on the machine

1). Check the plug whether it connects well or whether it is broken.

2). Check the power switch or digital controller whether it is broken.

3). Check the fuse whether it has been burnt out.

4). Indicating light is on, but no display on screen, check the 5 cable of Railway transformer. If it's loosening, showing the problem is poor connection. If they connects well, showing that the Transformer is faulty.

4. The display screen are working well, but no temperature increasing on the heat platen.

1). Check whether the thermocouple of the heat platen touches well. If the thermocouple is loose, the display will show 255 and machine keeps beeping.

2). Check if the indicating light of solid-state relay is on, if not, check if the relay or digital controller is broken.

3). If you already changed the new solid-state relay but the heat platen still can't heating up, check if the heat platen is faulty or the heat platen's power cable is loose, need to change by new heat platen.

5. The heat platen works well, but suddenly the display screen show 255℃.

1). Check whether the thermocouple of the heat platen touches well.

2). If the thermocouple touches well but stills show 255℃, then it is faulty.

6. The machine is heating during 0~180℃, but display number jumps to above 200℃ or 300℃ suddenly, or the numbers on display jumps irregularly.

1). Check whether the thermocouple of the heat platen touches well.

2). If the thermocouple is good, It shows that the program of digital controller is broken, which namely IC or is broken, need to change by new controller.

7. The temperature is out of control: Set 180℃ · but the actual temperature

is above 200℃。

1). It means the solid-state relay is broken, out of control, need to change the relay.

2). Or the digital controller is faulty and it keeps conveying electric to relay, need to change controller.

8. The setting temp and time becomes abnormal after exchange the heat platen

Please reset the temp and time according the operation process manual.

9. Other notice

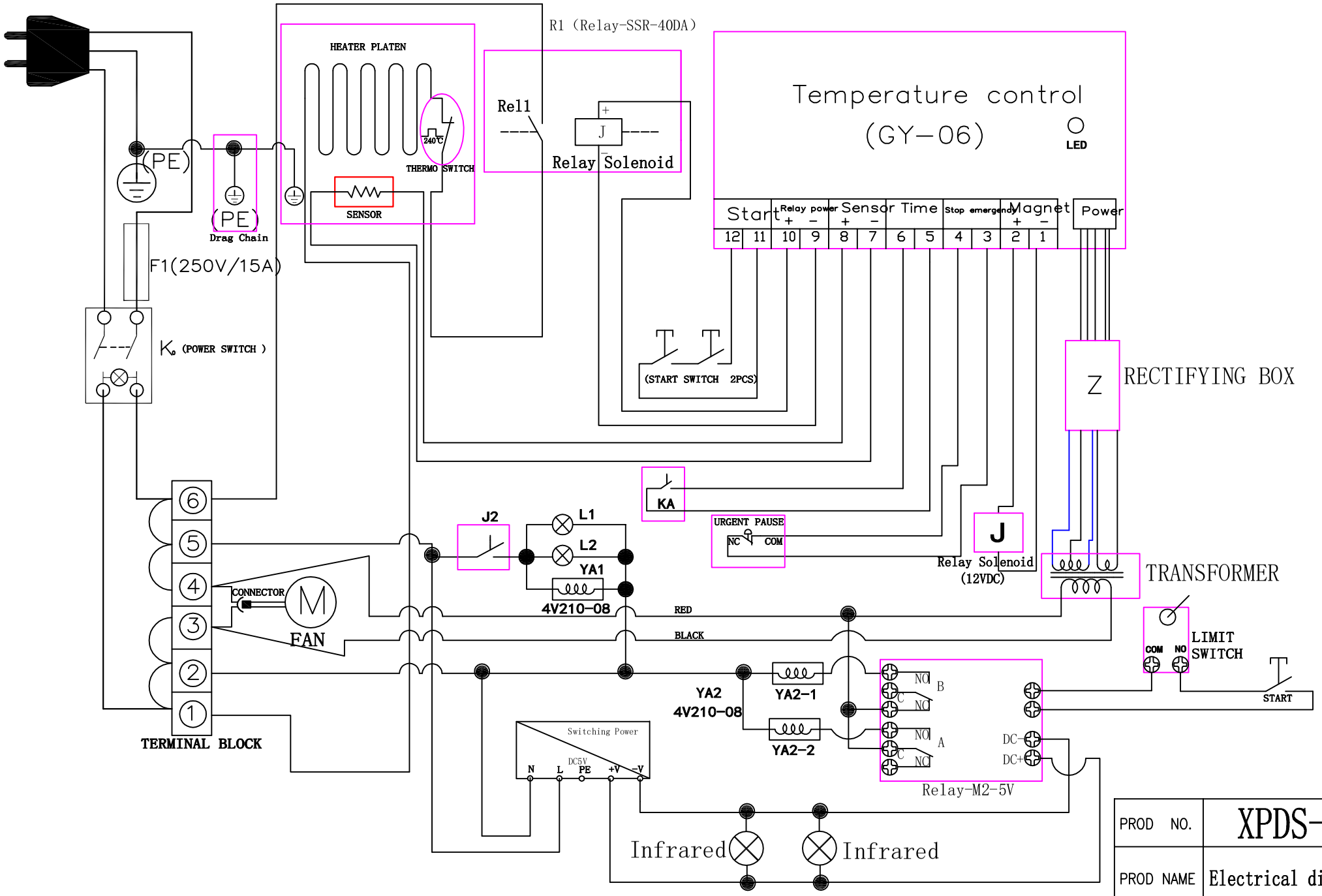
1). In order to prolong the machine service life, please add the lubrication oil regularly on the joints.

2). In order to keep the heat platen's good transfer effect, you need to protect the heat platen carefully whenever you are using it or not.

3). Please keep the machine in dry place.

4). If you are not able to solve the electrical parts problem, please kindly contact the supplier and get technical support.

REVISION	MODIFIED ITEM	ORIGINAL	CHANGE TO	REMARK	REPLEASED BY	DATE
A						2024-3-2



PROD NO.	XPDS-20
PROD NAME	Electrical diagram

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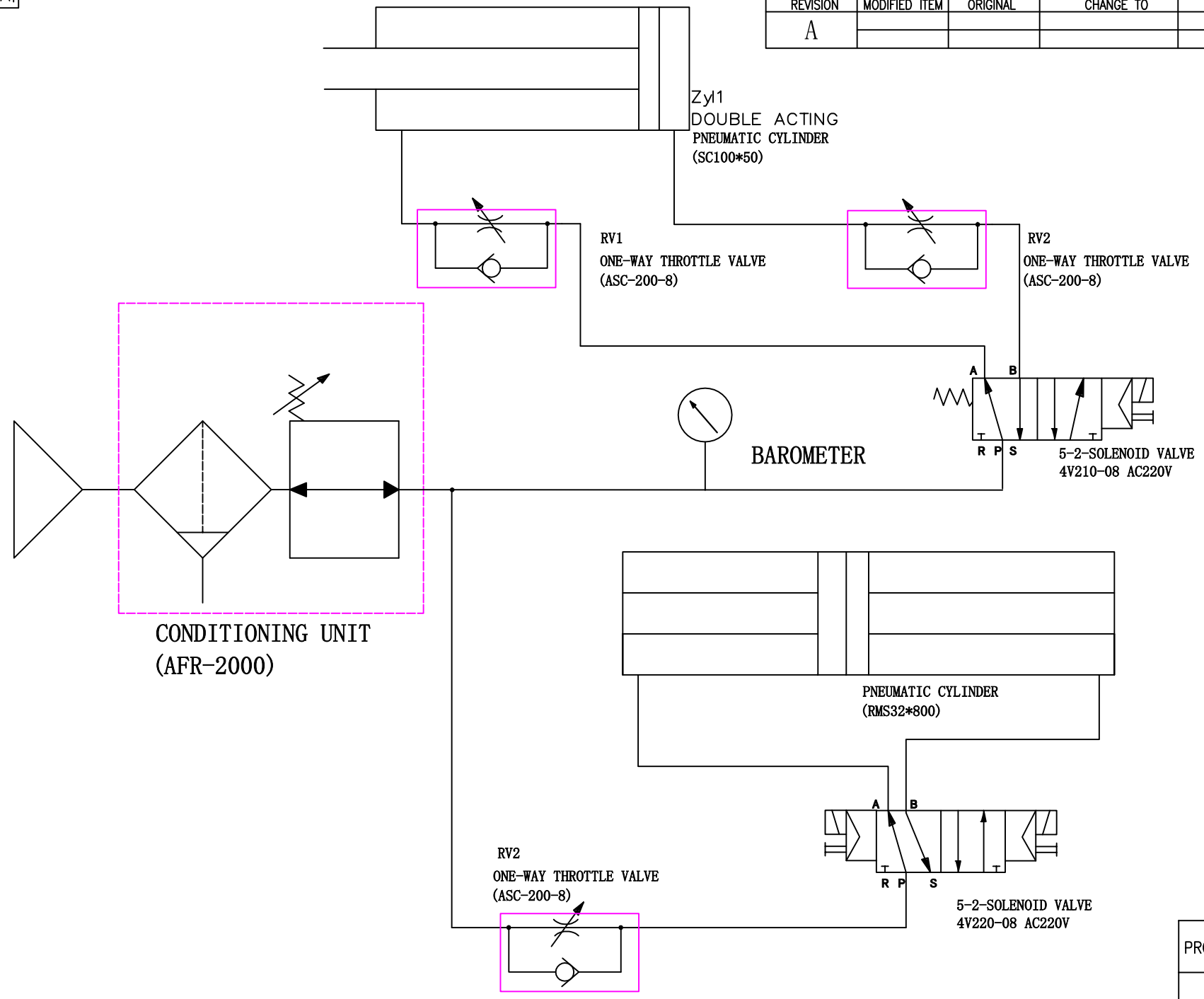
A						2024-3-2



PROD NO.	XPDS-20
PROD NAME	Pneumatic layout plans