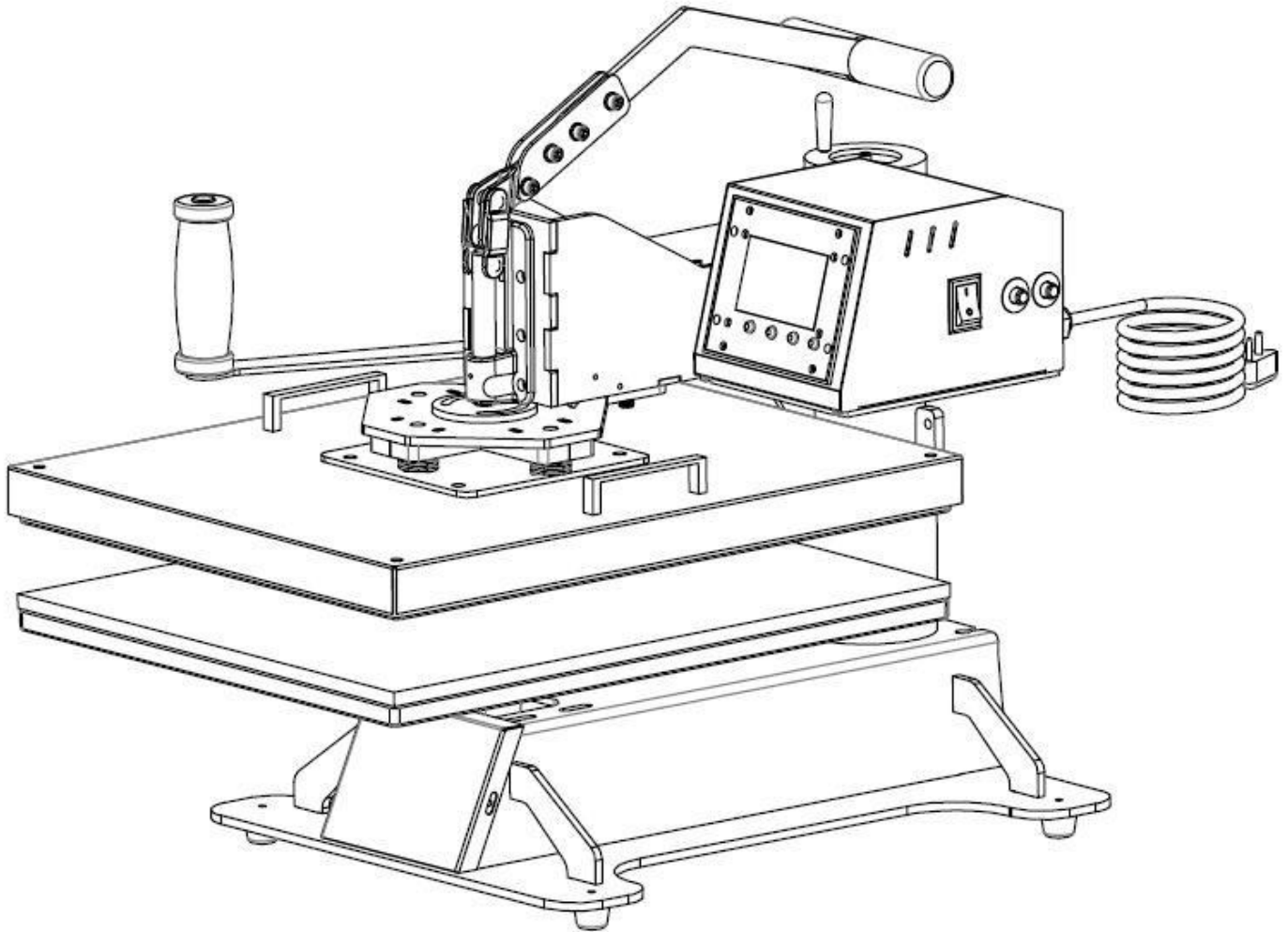




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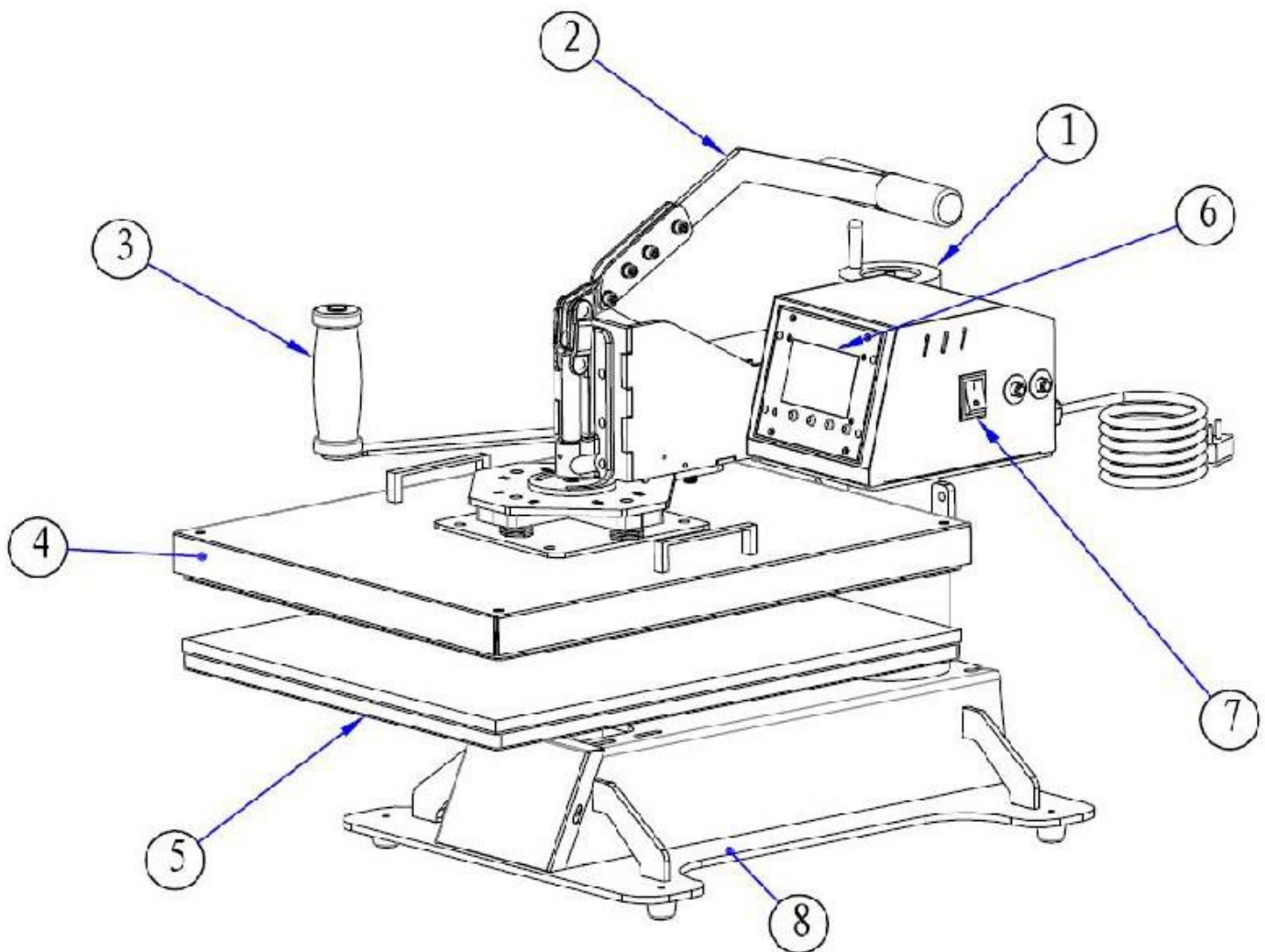
**Swing Away Heat Press
(with Pressure Sensor)
Model No.: HPD.SAPS50**



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I. ASSEMBLY DRAWING



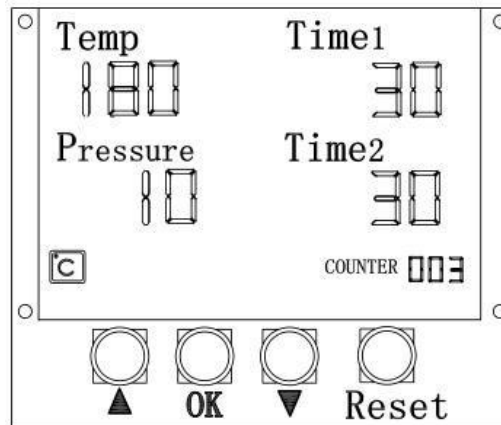
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|---------------|---------------|----------------|----------------|
| ① Hand Wheel | ② Handle Grip | ③ Swing Handle | ④ Heat Platen |
| ⑤ Base Platen | ⑥ Controller | ⑦ Power Switch | ⑧ Machine Base |

II. Technical Parameters

1. Model No: HPD.SAPS50
2. Machine Size: 662 x 413 x 480 mm
3. Heat platen Size: 40 x 50 cm
4. Printable Articles Max Size: 40 x 50 cm
5. Voltage: 220V - Single Phase
6. Power: 1.8kW
7. Time Range: 0~999s, Maximum Temp: 225°C
8. Packing Size: 805 x 555 x 590 mm
9. Gross Weight: 66.6 Kg

III. Controller Operating Instructions

- 1) On the control panel the upper row shows the 'actual Temperature' and 'Time 1', the lower row shows the 'Pressure value' and 'Time 2' [see below]:



- 2) Press the 'OK' button to set the temperature, press either '▲' or '▼' to adjust the value; Press the 'OK' button again to set 'Time 1', press either '▲' or '▼' to adjust the value. Press the 'OK' button again to set 'Time 2', press either '▲' or '▼' to adjust the value; Press the 'OK' button again to set the pressure, press either '▲' or '▼' to adjust the value.

After finalizing the settings, press the 'OK' button, which will then return you to the main interface window, the machine will then enter 'heating up' mode.

N.B. The Celsius degree adjustment range is 0~225°C, and the Fahrenheit degree adjustment range is 0~437°F; The 'time 1' and 'Time 2' adjustment range is 0 ~999 sec; The pressure value adjustment range is 0~10.

- 3) Pull the handle down, which will start the print cycle by lowering the heat platen to the pressure selected. The control panel will now countdown until 3 seconds is left at which time the buzzer will sound. Lift handle into the up position to complete the transfer cycle.
- 4) To reset the print cycle counter, press and hold the 'Reset' button for 3~5 seconds, until it starts to flicker, at which time it will set itself to zero.
- 5) Repeat 'step 2' to adjust the parameters when machine is under heating-up situation.
- 6) To calibrate/ set the controller press and hold the 'OK' button for 4~5 seconds [see below for settings]:

- P-1 Temperature Mode: Press either '▲' or '▼' to switch between Celsius or Fahrenheit.
- P-2 Temperature Difference Calibration Mode: The setting range is '-50'~'+50', e.g. Set 180°C as the target, when the display shows 180°C, while the actual average temperature of the heating platen is 174°C. That is to say, the temp difference is 6°C. To decrease the display temperature by 6°C. Suppose the current P-2 mode shows '10' after you enter, then you need to press either '▲' or '▼' and change "10" to '04'. (Decreasing the value by 6°C to compensate for the incorrect value).
- P3 Constant Temperature Mode, interval range is 1~10, e.g. you could set a temperature value that you want to enter, to constant temperature before it reaches the setting temperature. E.g., the setting temperature is 180°C and P-7 is 10°C, then when the temperature reaches 170°C, it will enter the constant temperature mode,

heating and pause in cycle to avoid the platen going beyond the required temperature.

- P4 Heating time and pause time: Setting range is 1~10 sec
- P5 Constant Temperature Heating Mode: Setting range is 0~10 sec
- P6 Sleep Mode: Sleep time 0~240 min
- P7 Pressure Value Compensation: Setting value 1~10 sec
- P8 Counter (Up to a million operations, sequential system), the value cannot be reset
- IP9 There are two modes: 'Mode 1' is standard setting mode, 'Mode 2' is safe setting mode [see below]
Mode one: The heat platen will lower once you press the start buttons
Mode two: The heat platen will lower only after the operator presses and holds the start buttons, for at least '2 seconds', if the start buttons are not pressed for at least 2 seconds, the heat platen will lift back up.
This is to prevent burns to the hands, by requiring the user's hands to be in contact with the start buttons until the heat platen is lowered.

Important Notice: This operation is recommended under the guidance of professional staff only.

Please don't change any setting without consulting an engineer at A. Adkins & Sons Limited beforehand.

IV. Maintenance

- 1) In order to prolong the machine service life, please add the lubrication oil on the joints regularly.
- 2) Turn off the power before changing spare parts. In order to ensure the accuracy of the parameter of GY-10 controller, please re-set the time and temperature.
- 3) To avoid damage, please keep the heaters well when change the spare parts.
- 4) The following checks should be carried out at regular intervals by a qualified and competent person:-
 - Electrical connections
 - Mechanical moving parts
- 5) If you are not able to solve your problem, please contact heatpressesdirect.com for technical support.

V. Heat Plate Temperature Measurement

Testing of the Heat Plate for temperature consistency or fault condition should only be undertaken after consulting a qualified engineer, and then only using a wired Digital Thermometer (***please see note below**).



***Please Note:**

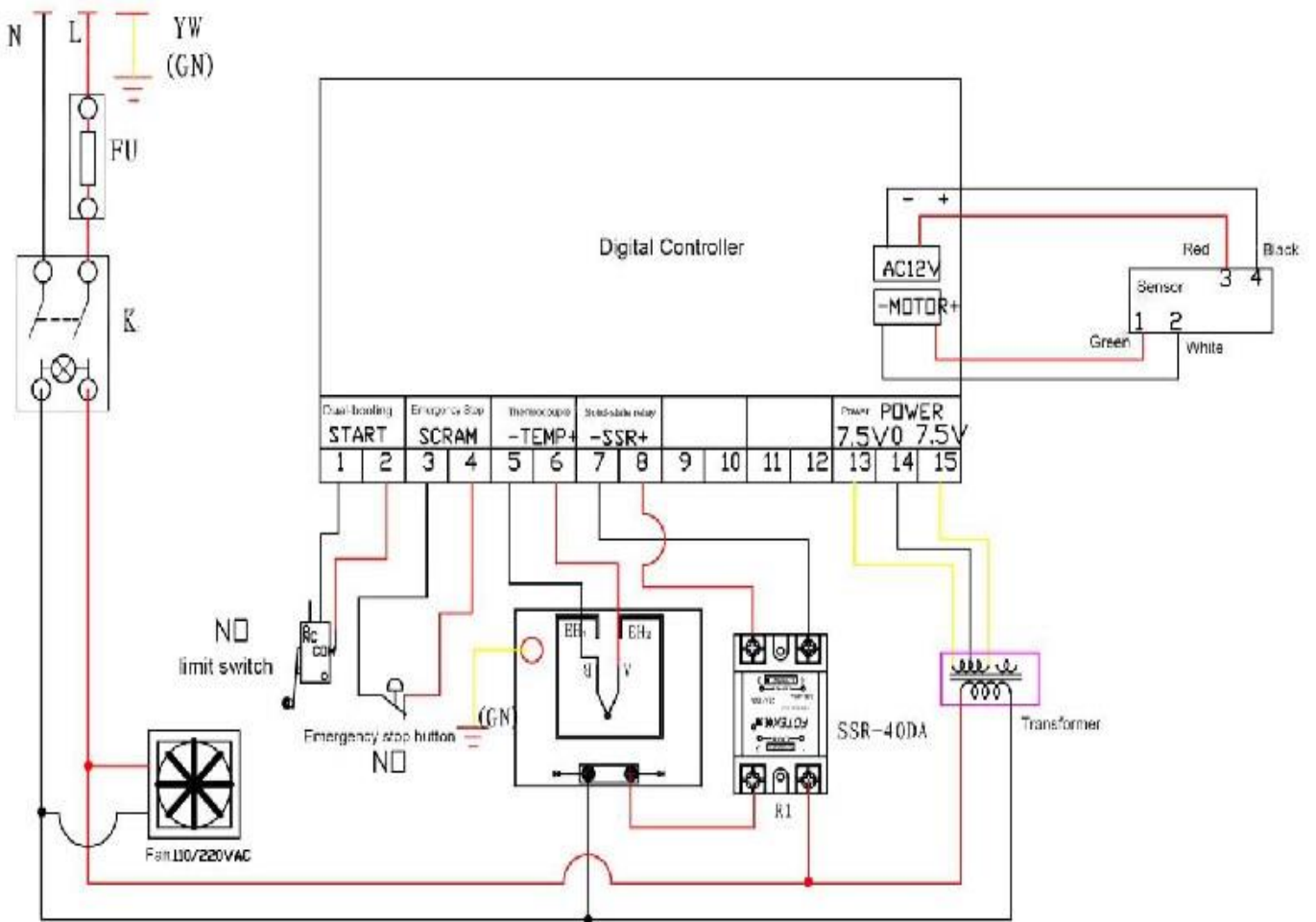
The Digital Thermometer with external probe is suitable for surface, air and immersion/penetration measurement, which is required for all Heat Presses Diect heat presses.

Laser Thermometers only measure air surfaces which can be misleading due to currents of hot air floating on the surface of the heat plate.

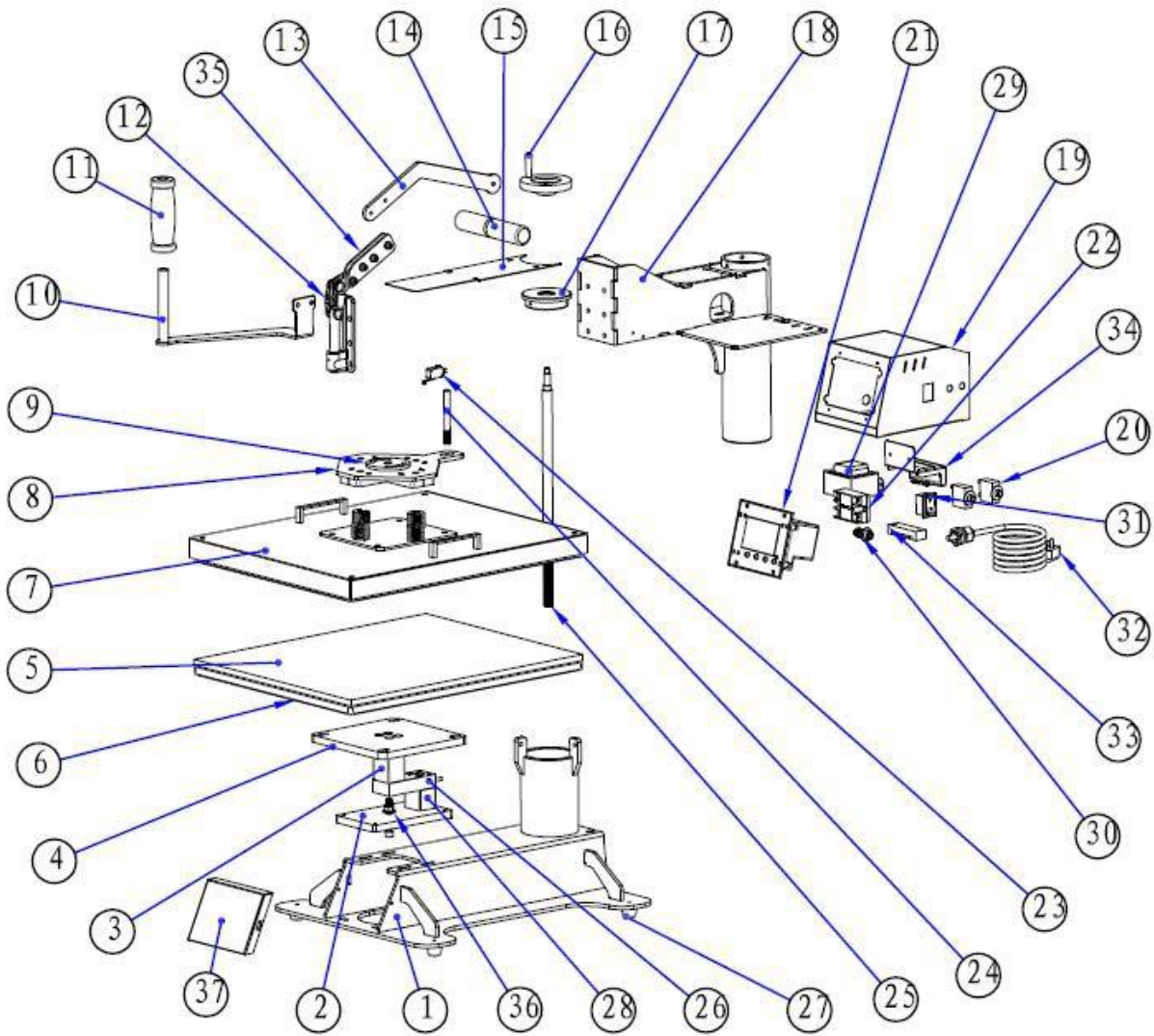
VI. Trouble shooting for transfer print quality

- 1) If the print colours are pale: the temperature is too low / the pressure is not correct / or the transfer has not been pressed for long enough.
- 2) If the print colour is too brown or the transfer paper is almost burnt: reduce the setting temperature.
- 3) If the print is blurring: too much transfer time causes proliferation of the ink.
- 4) If print colour is different/ partial transfer effect is not good enough: the pressure is not enough / or the transfer has not been pressed for long enough / or poor quality transfer paper.
- 5) If transfer paper sticks to the object after transfer: the temperature is set too high/ or poor quality printing ink.

VII. Electrical Diagram



VIII. Exploded Diagram



No.	Part Name	Qty.
1	Pedestal	1
2	Dynamometer-Base plate	1
3	Table support column	1
4	Table support plate	1
5	Silicon pad	1
6	Table	1
7	Heating element assembly	1
8	Cross frame	1
9	Adjustment plate	1
10	Swing arm handle	1
11	Handle grip	1

12	Toggle assembly	1
13	Machine arm	1
14	Handle	2
15	Cover plate for pressure display window	1
16	Pressure adjustment wheel	1
17	Rocker end cover	1
18	Rocker	1
19	Electric box	1
20	Circuit breaker(s)	2
21	Digital controller	1
22	Solid state relay	1
23	Limit switch	1
24	Locating rod	1
25	Rocker adjusting rod	1
26	Pressure sensor	1
27	Machine feet	4
28	Dynamometer-Under column	1
29	Transformer	1
30	Aviation plug	1
31	Power switch	1
32	Power line	1
33	Terminal blocks	1
34	Line connector mounting plate	1
35	Toggle assembly joining plate	1
36	Stop screw	1
37	Pedestal end cover	1