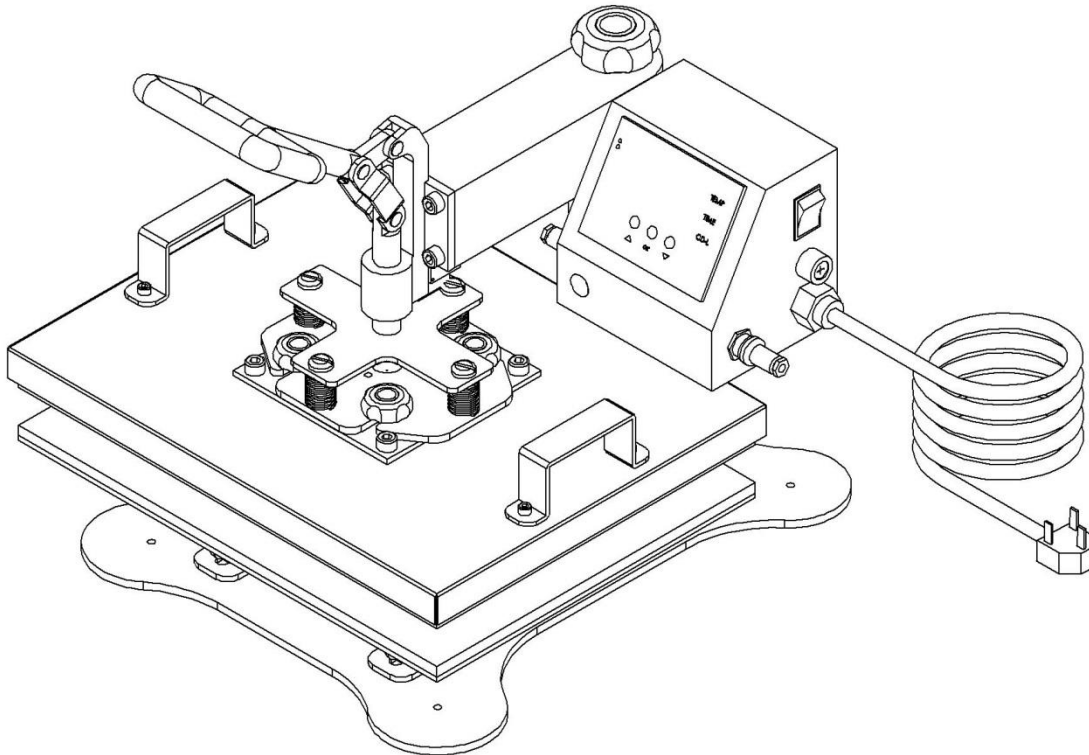




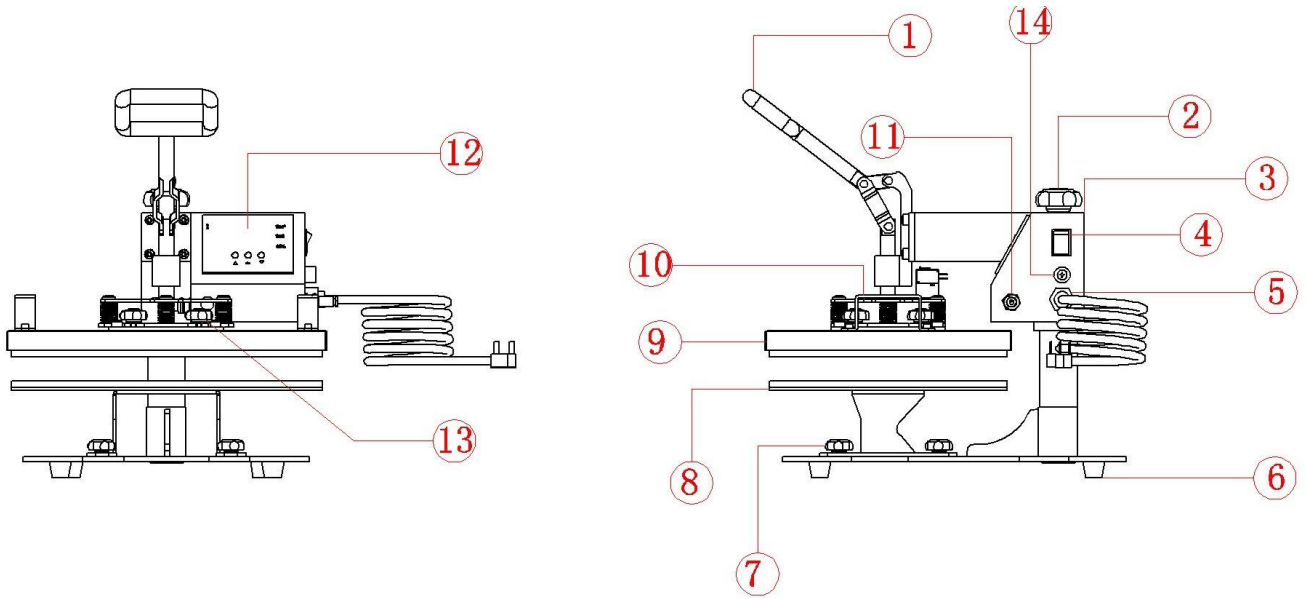
# Swing Away 4 in 1 Combo Heat Press Model No.: HPD.SA38-4/1



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# I. Assembly Drawing.



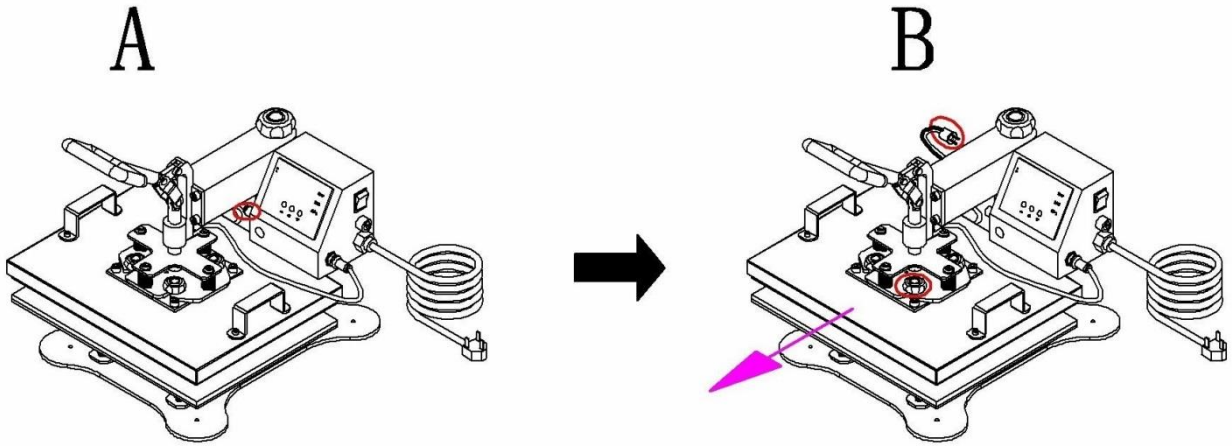
- |                            |                      |                           |                        |
|----------------------------|----------------------|---------------------------|------------------------|
| 1) Handle Bar Grip         | 2) Pressure Adjuster | 3) Electrical Case        | 4) Power Switch        |
| 5) Power Cord              | 6) Rubber Foot       | 7) Screw for Fast Release | 8) Under Plate         |
| 9) Heat Platen             | 10) Swing Handle     | 11) Aviation Socket       | 12) Digital Controller |
| 13) Screw for Fast Release | 14) Fuse             |                           |                        |

# II. Technical Parameters

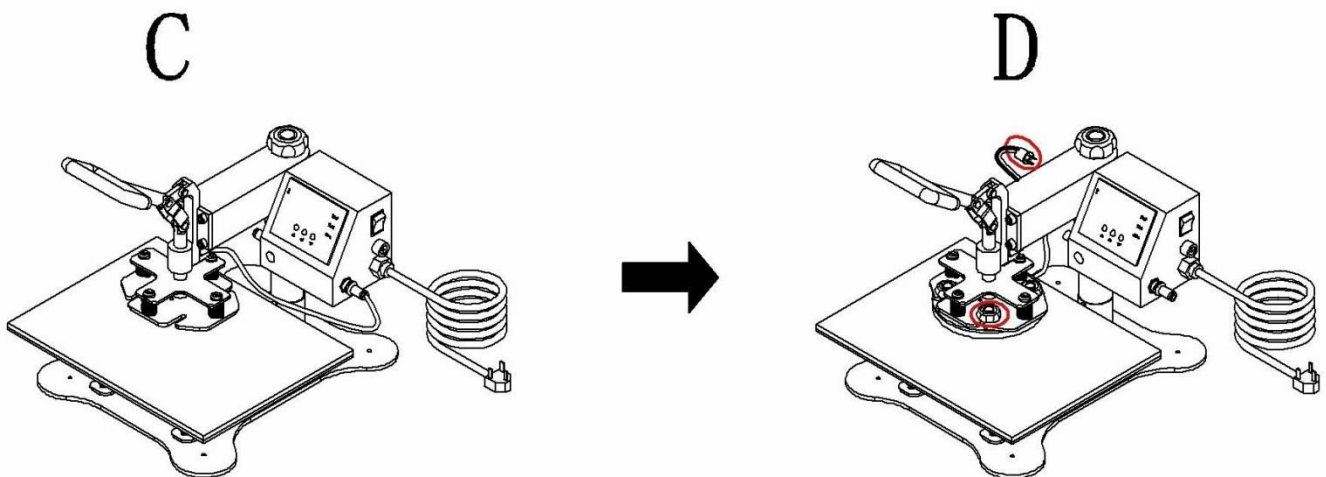
1. Model No.: HPD.SA38-4/1
2. Machine Dimension: 588\*380\*450mm
3. Heat Platen Size: 12"x15" (29x38cm)
4. Printable Articles Max Size: 290\*380\*10mm
5. Voltage: 220V/1Phase; 110V/1Phase
6. Power: 220V/1.8kW; 110V/1.2kW
7. Recommend Setting: 30~280s; 180~200°C  
Time Range: 0~999s  
Maximum Temp: 225°C
8. Packing Size: 53\*53\*53cm
9. Gross Weight: 36kg

### III. Heating Element Exchange Instructions

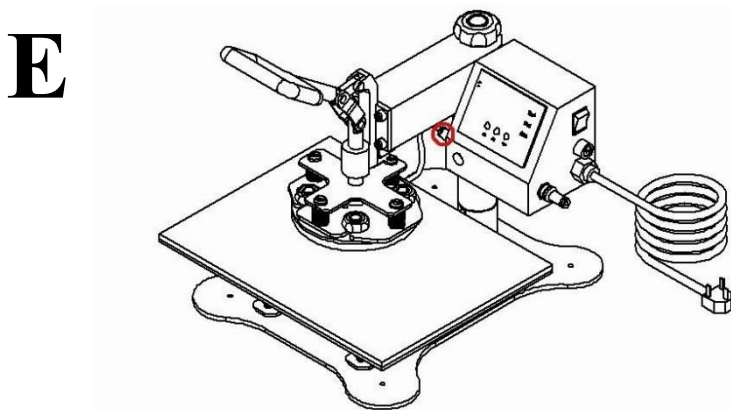
#### Plate Heating Element



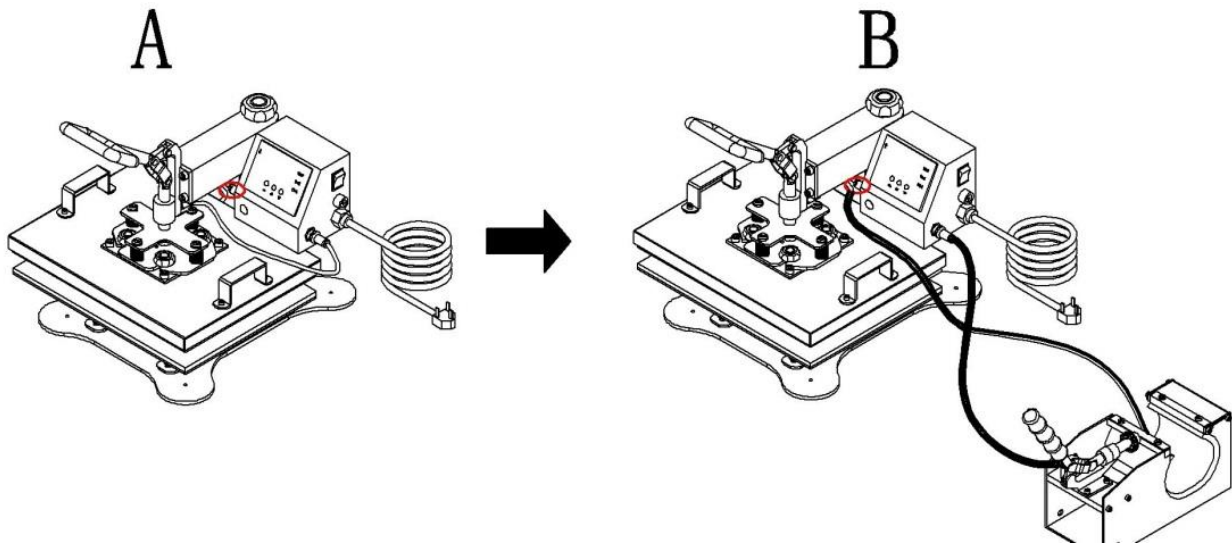
Please loosen the screws marked in red.  
Unplug the power connector as the above picture shown.



Remove the heat platen. Tighten the screws of the heat plate element and then connect the wire of the heat plate element to the power connector.

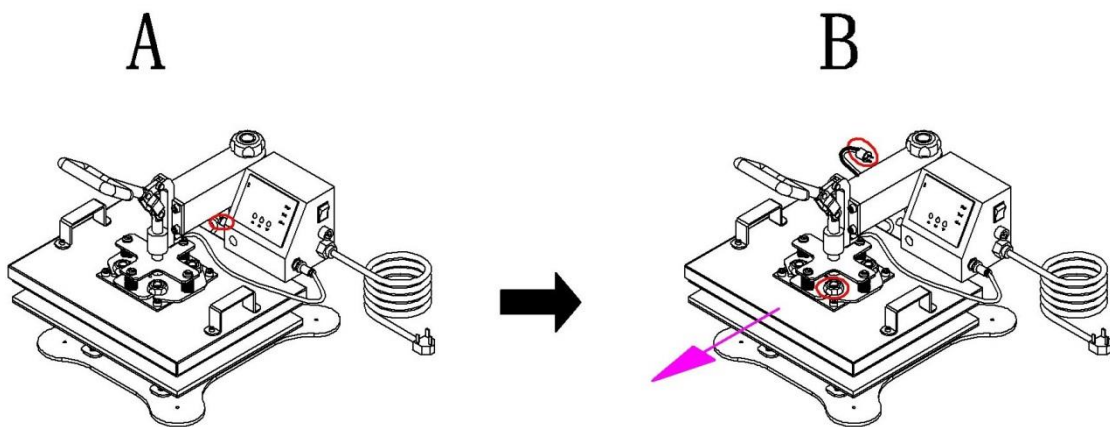


## Mug Heating Element



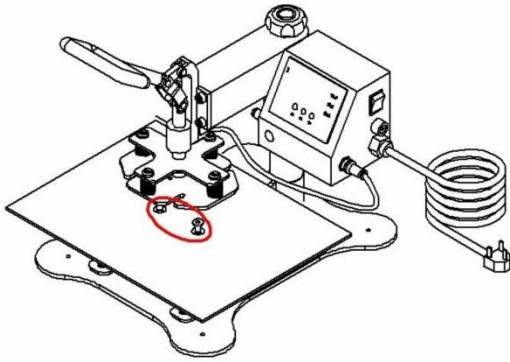
Disconnect the power connector of the heat platen as the above picture shown.  
Connect the mug heating element wire to the power connector and plug in the other wire to the aviation socket.

## Cap Heating Element

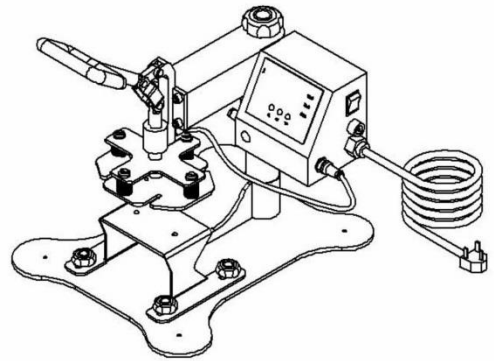


Please loosen the screws marked in red.  
Disconnect the power connector as above picture shown.

# C

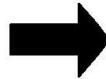
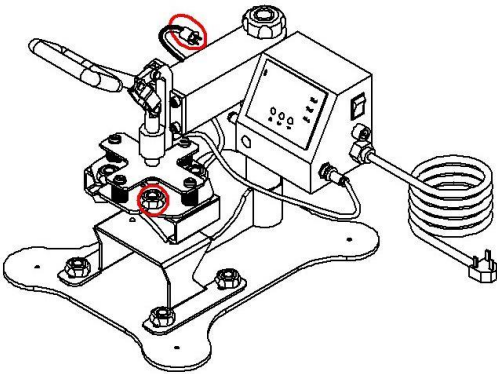


# D

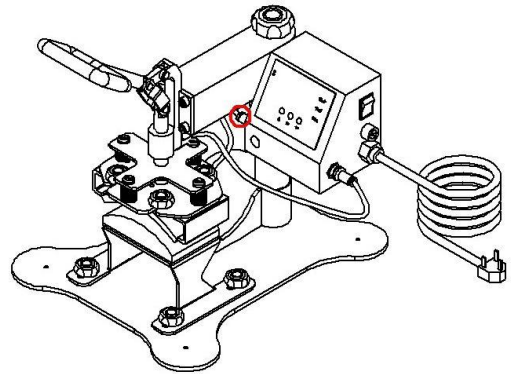


Remove the heat platen and under plate. Install the heat element as the above picture shown.

# E

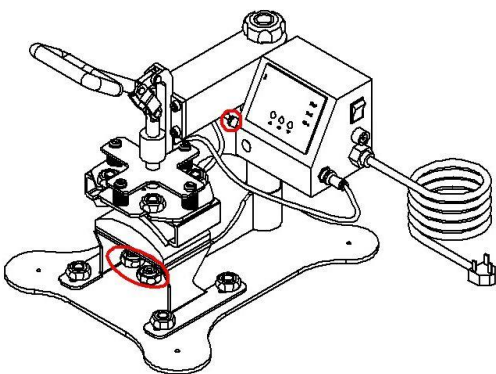


# F

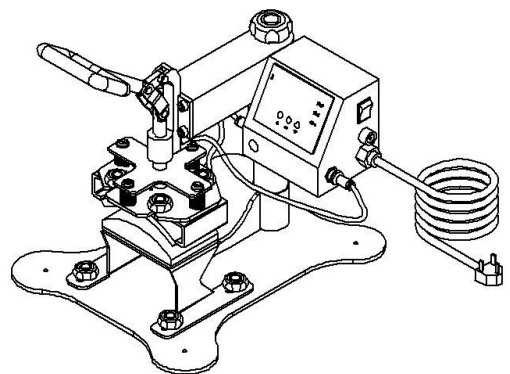


Tighten the screws of the cap heat element and then connect the wire to the power connector.

# G










# H



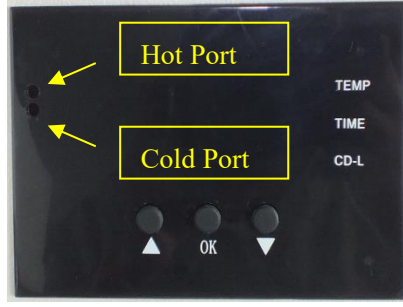





## IV. Operating Process.

### 1. Set temperature required.

		
<p>Turn on power switch, temperature light is ON. The digital display shows</p> 	<p>Press  button, the  light is on (C denotes Celsius). Press arrows '△' or '▽' to select '°C' or '°F' (F denotes Fahrenheit) according to your habits.</p>	<p>Press  button, the temp light is on. Using the arrows select the temperature, according to different transfer material (Normally 180°C ~200°C)</p>

### 2. Set time required

		
<p>Press  button after temperature setting and the  time light is on. Using the arrows select the time according to different transfer material.</p>	<p>Press  button after time setting; the display shows the temperature starts to rise. "CD-L" shows the time counting down during your transfer.</p>	<p>Note: There are two small ports in the front side of the digital display. If the real temperature is lower than digital controller shown, you can adjust the "hot port"; Clockwise to Raise the temperature; anticlockwise to reduce the temperature.</p>

**NOTE:** If 'LO' appears on the display, this is part of the program. Once the temperature rises to approx. 100°C the display will change from 'LO' to the actual temperature

### 3. Printing methods.

Step 1: Make sure the cord is connected firmly to the wall socket. Slide out heat platen and place the object (i.e. T-shirt) on press bed, then put transfer paper with image facing down onto the object. Adjust the pressure to your requirement, and turn on the power.

Step 2: Set the temperature and time required (see above) and the temperature will start to rise.

Step 3: When the temperature has risen to the setting required, the buzzer will sound; you can then lower the heat platen (in the meantime the buzzer will stop). This starts the transfer cycle.

Step 4: When the timer has counted down to zero, the buzzer will sound. Remove the cap from the heating element and peel the transfer.

Step 5: Consult the Transfer Paper instructions on whether to peel cold or hot.

Here are suggested Pressing time guidelines for different transfer papers:

- Ink-Jet Transfer Paper (fabric) 14-18 seconds.
- Sublimation Transfers (onto Fabrics) 25-30 seconds.
- Sublimation Transfers (onto FR-Plastic/Woods) 60-70 seconds

**NB:** Other items should be transferred in the same way. After you exchange the heating elements the printing parameters are will be different for different items. Please refer below.

#### **4. Recommendations:**

1) Ceramic tile transfer: (Mugs & Plates transfer is similar).

- Set temperature: 180°C.
- Set time: 15 seconds.

2) Cap transfer:

- Set temperature: 180°C.
- Set time: 60 seconds.

3) T-shirt transfer:

- Set temperature: 180°C.
- Set time: (chemical fibre use for sublimation transfer paper: 30-50 seconds; pure cotton use for T-shirt transfer paper: 10-20 seconds).

#### **PLEASE NOTE:**

1) Switch off the machine and unplug the power cord when the machine is not in use.

2) The heat platen will cool down to the room temperature if the heat press stays unused for more than 30 minutes.

3) For better maintenance of your heat press the maximum setting temperature is 210°C (410°F).

4) To avoid re-heating the first transfer when printing double sided T-Shirts, insert a sheet of cardboard inside the T-shirt; Remember to adjust the height to less pressure before you press.

5) Heat platen may pivot slightly back and forth rotationally. This is normal and is due to the movement allowance within the assembled clamp.

## **V. Maintenance.**

### **1. The machine will not work after you turn on the power.**

- 1). Check the plug is connected well or that it is not broken.
- 2). Check the power switch or digital controller is not broken.
- 3). Check the fuse is not blown.
- 4). Indicating light is on, but no display on screen, check the 5 cable of Railway transformer. If it is loose, this indicates that the problem is poor connection. If it is securely connected, it indicates that the Transformer is faulty.

### **2. The display screen is working well, but the heat platen temperature does not rise.**

- 1). Check whether the thermocouple of the heat platen is secure. If the thermocouple is loose, the display will show 255°C and the machine will keep beeping.
- 2). Check if the indicating light of the solid-state relay is on. If not, check if the relay or digital controller is broken.
- 3). If you have already replaced the solid-state relay for a new one but the heat platen will still not heat up, then check to see if the heat platen is faulty or the heat platen's power cable is loose, you may need a new heat platen.

### **3. The heat platen works well, but suddenly the display screen shows 255°C.**

- 1). Check whether the thermocouple is secure.
- 2). If the thermocouple is firmly attached but the controller still shows 255°C, then it is faulty.

### **4. The machine is heating between 0~180°C, but the display number jumps to above 200°C or 300°C suddenly, or the numbers on the display jump irregularly.**

- 1). Check whether the thermocouple of the heat platen is firmly attached.
- 2). If the thermocouple is OK, It shows that the program of the digital controller is broken. You will need to replace it for a new controller.

### **5. The temperature is out of control: Set to 180°C , but the actual temperature is above 200°C.**

- 1). This indicates that the solid-state relay is broken/ out-of-control; You will need to replace the relay.
- 2). Alternatively the digital controller could be faulty with an open circuit providing constant power; You will need to replace the controller.

### **6. The setting temp and time becomes abnormal after you have replaced the heat platen.**

- 1). Please reset the temp and time according to this operators' manual.



## **7. Maintenance.**

- 1). In order to prolong the machine's service life, you should regularly lubricate all mechanical joints with light machine oil.
- 2). Care should be taken to protect the heat platen whenever the machine is not in use. This will prolong the life of the platen and help to keep the image quality of your work high.
- 3). The machine should be stored in a dry place.
- 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](http://heatpressesdirect.com) for technical support.

## 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. 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**).

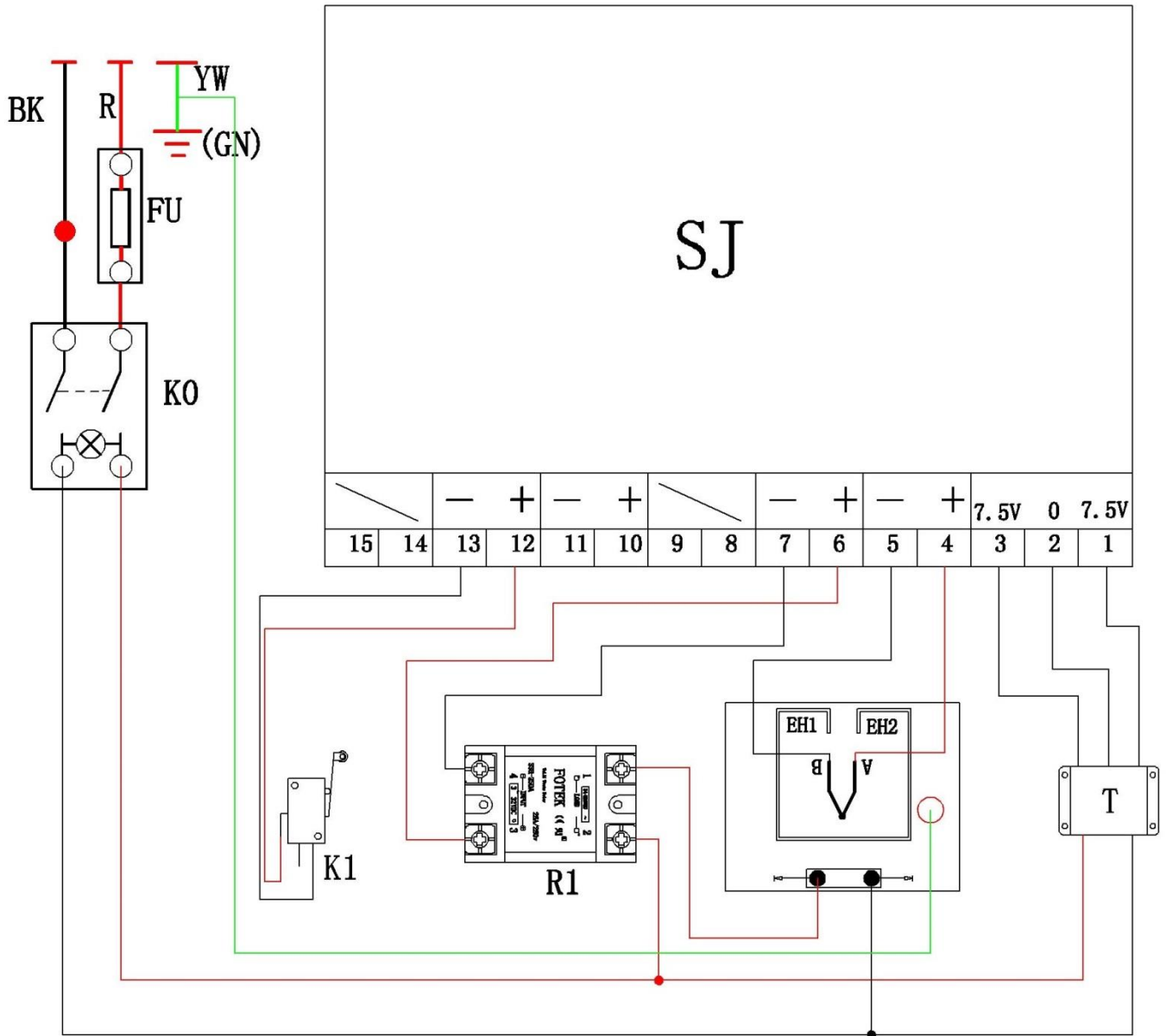


**\*Please Note:**

**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.

## VIII. Circuit Diagram



K0.: Power Switch

FU: Fuse

SJ: Digital Controller

EH<sub>1</sub>EH<sub>2</sub>: Heating Pipe

R1: Relay

T: Transformer



Item No.	Part Name	Qty	Part No.
1	Machine Base	1	
2	Rubber Foot	4	
3	Screw	16	
4	Under Plate Stander	1	
5	Screw or Fast Release	8	
6	Under Plate	1	
7	Screw	2	
8	Heat Platen	1	
9	Heat Platen Cover	1	
10	Adapter Plate	1	
11	Washer	8	
12	Eye Bolt	8	
13	Swing Handle	2	
14	Spring	4	
15	Screw	4	
16	Adapter Plate	1	
17	Iron Board	1	
18	Adjustment Spindle	1	
19	Limit Switch	1	
20	Limit Switch Fixed Piece	1	

21	Handle Bar Grip	1	
22	Iron Arm	1	
23	Pressure Adjuster	1	
24	Male Socket	1	
25	Female Socket	1	
26	Hand Wheel	1	
27	Female Socket	1	
28	GY-04 Digital Controller	1	
29	Electrical Case	1	
30	Solid State Relay	1	
31	Transformer	1	
32	Power Switch	1	
33	Fuse Holder	1	
34	Power Cord	1	
35	Electrical Case Cover	1	
36	Screw	4	
37	10" Plate Heater	1	
38	8" Plate Heater	1	
39	Mug Press Part	1	
40	Cap Heater & Metal Cover	1	
41	Male Socket	1	