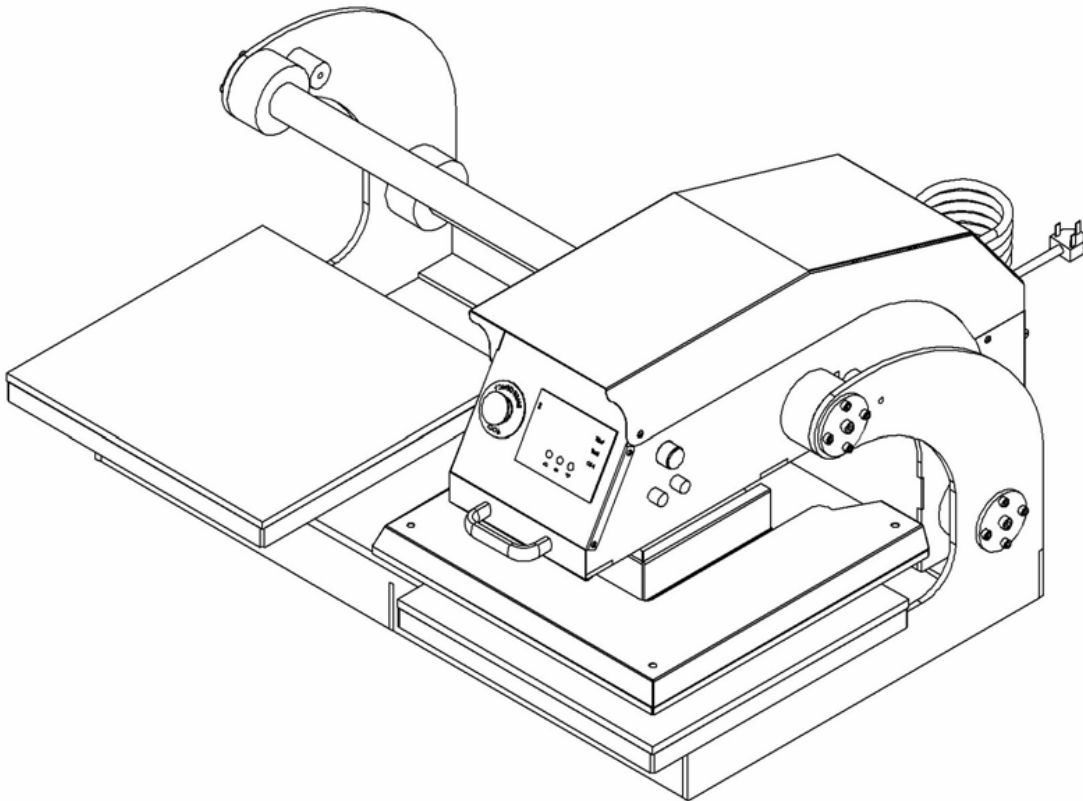




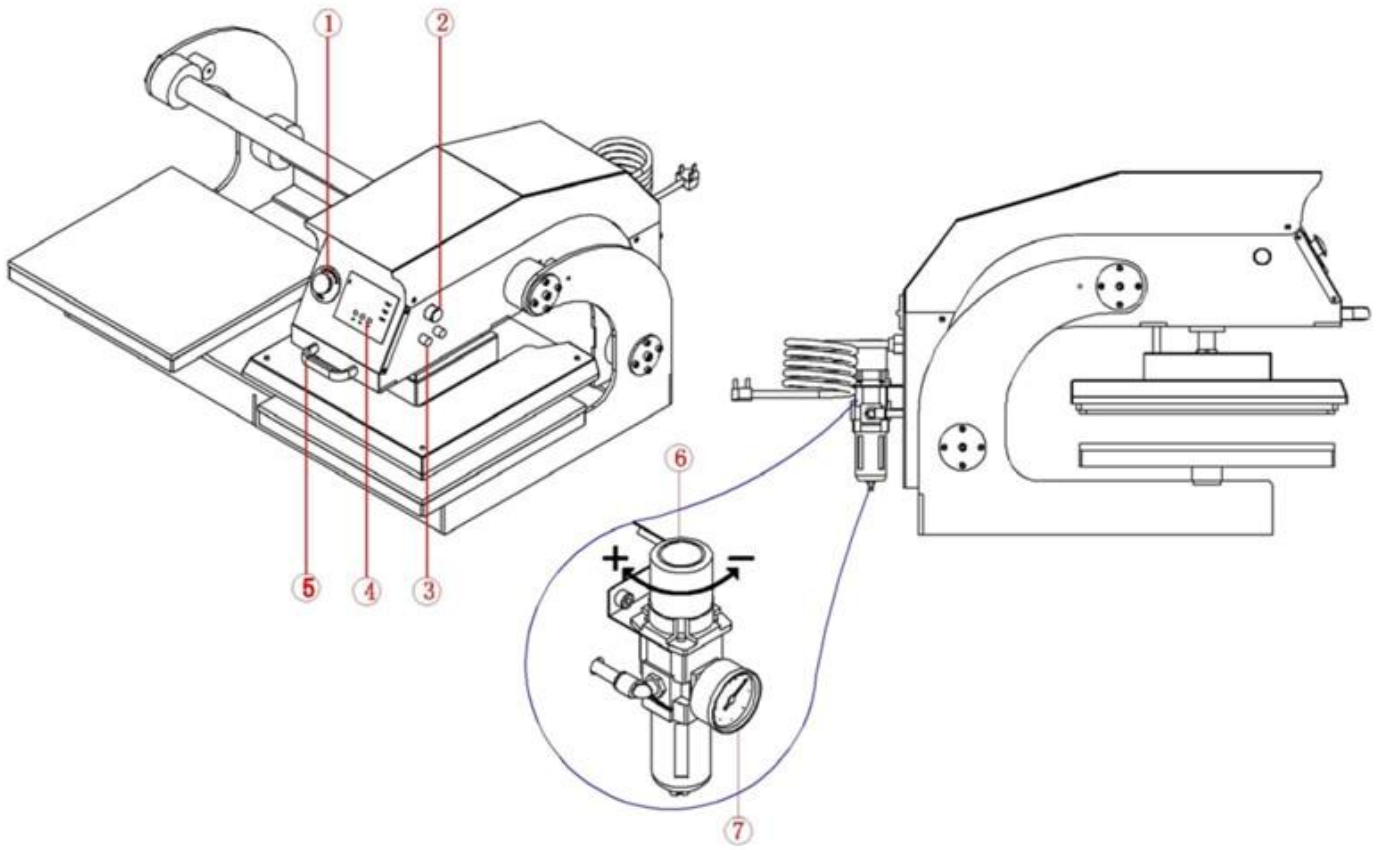
Twin Pneumatic Heat Press Model No.: HPD.TTP50



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I. Assembly Drawing



① Emergency Stop	② Start Switch	③ Air Pressure Adjust Knob	④ Digital Controller
⑤ Machine Handle	⑥ Pneumatic Valve	⑦ Air Filter	

II. Technical Parameters

1. Model No.: HPD.TTP50
2. Machine Dimensions: 970 mm x 860 mm x 600 mm
3. Heat Platen Size: 40 cm x 50 cm, 40 cm x 60 cm
4. Printable Articles Max Size: 400 mm x 600 mm x 30 mm
5. Voltage: 220V
6. Power: 220V/ 1.8 kW
7. Recommend Setting:
 - Time: 30~280s; 180~210°C.
 - Time Range: 0~999s
 - Maximum Temp: 225°C
 - Heating Element Power: 1.8 kW
8. Packaging size: 1050 mm x 950 mm x 700 mm
9. Gross Weight: 200 Kg

III. Operational Procedure

1. How to adjust the pressure:



1. Connect the heat press to the air compressor or other air source.
2. Lift up the cap of the air valve [as the picture shown above]
3. Rotate the cap anticlockwise, to increase the air pressure; Rotate the cap clockwise, to decrease the air pressure. When you have finish the pressure adjustment, push the cap down to lock the pressure.
4. Suggested air pressure is 0.4 - 0.5Mpa (70-80Psi). Although this will depend upon the transfer materials being used.

2. Setting the temperature

<p>Turn on the power switch and the temperature light will illuminate. The digital display shows as above.</p>	<p>Press the button, and the light will illuminate (C denotes Celsius F denotes Fahrenheit). Press the “△” or “▽” buttons to select “C” or “F” (according to your habits).</p>	<p>Press the button, the temperature light will illuminate. Select the temperature with the arrow buttons, according to the different transfer materials used (Normally 180°C~200°C) SV: Set temperature PV: Current temperature</p>

3. Setting the time

<p>Press the button after the temperature setting and the time light will illuminate. Select the time with the arrow buttons, according to different transfer materials used. SV: Set temperature PV: Current temperature</p>	<p>Press the button to enter the operating mode. The transfer cycle counter, has a range of 0 – 999. Press “Reset” for 5 seconds to return the counter to “0”.</p>

4. Printing methods

Step 1: Make sure the Power Cord is secured to the wall socket. Place the object (i.e. T-shirt) on the press table, and the transfer paper with images face down onto the object. Adjust the pressure to your requirements, and turn on the power.

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

Step 3: When the set temperature is reached, the buzzer will sound. Press the two green cycle start buttons using both hands and the Heat Platen will lower automatically. Once the set time has elapsed the heat platen will open automatically.

Step 4: You can then use the Shuttle Handle to move the Heat Platen to the other table, and repeat the steps 2 to 3.

Step 5: Consult your transfer paper instructions as to whether to peel hot or cold.

Please see below suggested Pressing time guidelines for different types of transfer paper:

Ink-Jet Transfer Paper (fabric):	14-18 seconds
Laser Copier/Printer Transfer Paper (fabric):	18-25 sec
Sublimation Transfers (onto fabrics):	25-30 sec
Sublimation Transfers (onto FR-Plastic/Woods):	60-70 sec

5. Recommendations:

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

Set temperature: 180°C.

Set time: 15 seconds

2) T-shirt transfer:

Set temperature: 180°C.

Set time: (chemical fiber use for sublimation transfer paper: 30-50 seconds; pure cotton use for T-shirt transfer paper: 10-20 seconds)

3) Aluminum Sheet transfer

Set temperature: 180°C

Set time: 45 seconds

Emergency:

In the event of an emergency situation, the user should press the red emergency stop button. After the emergency situation has been rectified, turning the emergency stop button clockwise will allow the operator to resume work.

NOTE:

1. Please switch off the machine power control valve if there is any problem.
2. Suitable air pressure should be 0.4 - 0.5 Mpa (75 – 80 Psi). Too much air pressure can destroy the machine, just as too little pressure will prevent the Heat Platen from working smoothly.
3. It is good-practice to power off for 1 - 2 hours, after continuous working of 6 - 8 hours.

IV. Maintenance

1. Air pressure

Check that there is enough lubricating oil in the Cylinder.

Adjust the pressure knob on the Air Regulator correctly. To adjust the pressure, the knob should be turned in the direction of the "+" sign (to increase pressure), or the "-" sign (to reduce the pressure).

2. If the Heat Platen does not lower correctly when the green Start Button is pressed but the Digital Display is working correctly.

- 1). If the limit switch, under the bottom Platen doesn't make contact, due to being set too high, the adjustment screw should be loosened a little.
- 2). Checking the circuit connecting with green start-up switch if it's with problem.

3. Nothing happens after you turn the machine on.

- 1). Check the power plug is inserted into the mains socket or is not faulty.
- 2). Check that neither the Power Switch nor Digital Controller is faulty.
- 3). Check that the fuse has not blown.
- 4). If the power light is on, but there is no display on screen, check the 5 cables of the Transformer. If they are loose, they should be tightened correctly. If they are already connected correctly, this indicates that the Transformer is likely to be faulty.

4. The display screen is working okay, but there is no temperature increase at the Heat Platen.

- 1). Check whether the Heat Platen's Thermocouple is attached securely. 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, after you have already changed the new Solid-State Relay, the Heat Platen still will not Heat up, you should check to ascertain if the Heat Platen is faulty, or the Heat Platen's power cable is loose. You may need to replace the Heat Platen.

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

- 1). Check whether the Heat Platen's Thermocouple is attached securely.
- 2). If the Thermocouple is attached securely but the display screen still shows 255°C, then the Thermocouple is faulty.

6. When the machine is heating up from 0°C to 180°C, but the display number suddenly jumps to above 200°C or even 300°C, or the numbers on the display jump erratically.

- 1). Check whether the Heat Platen's Thermocouple is attached securely.
- 2). If the Thermocouple is secured correctly, it suggests that the programming of the Digital Controller is corrupt, and that the Digital Controller may need replacing.

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

- 1). It means the Solid-State Relay is broken or out of control, you may need to change the Relay.
- 2). Or the digital controller is faulty and keeps supplying electric to the relay, you may need to change the Controller.

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

Please reset the temperature and time according the Operational Procedure contained in this manual.

9. Other notice

- 1). In order to prolong the machine service life, please add lubricating oil regularly to all joints.
- 2). To keep the heat platen transferring correctly, you should protect it carefully at all times.
- 3). The machine should be kept in a dry place, away from moisture.
- 4). The following checks should be carried out at regular intervals by a qualified and competent

person:-

- Electrical connections
- Pneumatic system for air leaks
- Pneumatic system for lubrication
- Mechanical moving parts

5). If you are unable to solve electrical/ parts problems, please contact the supplier:
<http://heatpressesdirect.com> for further 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:**

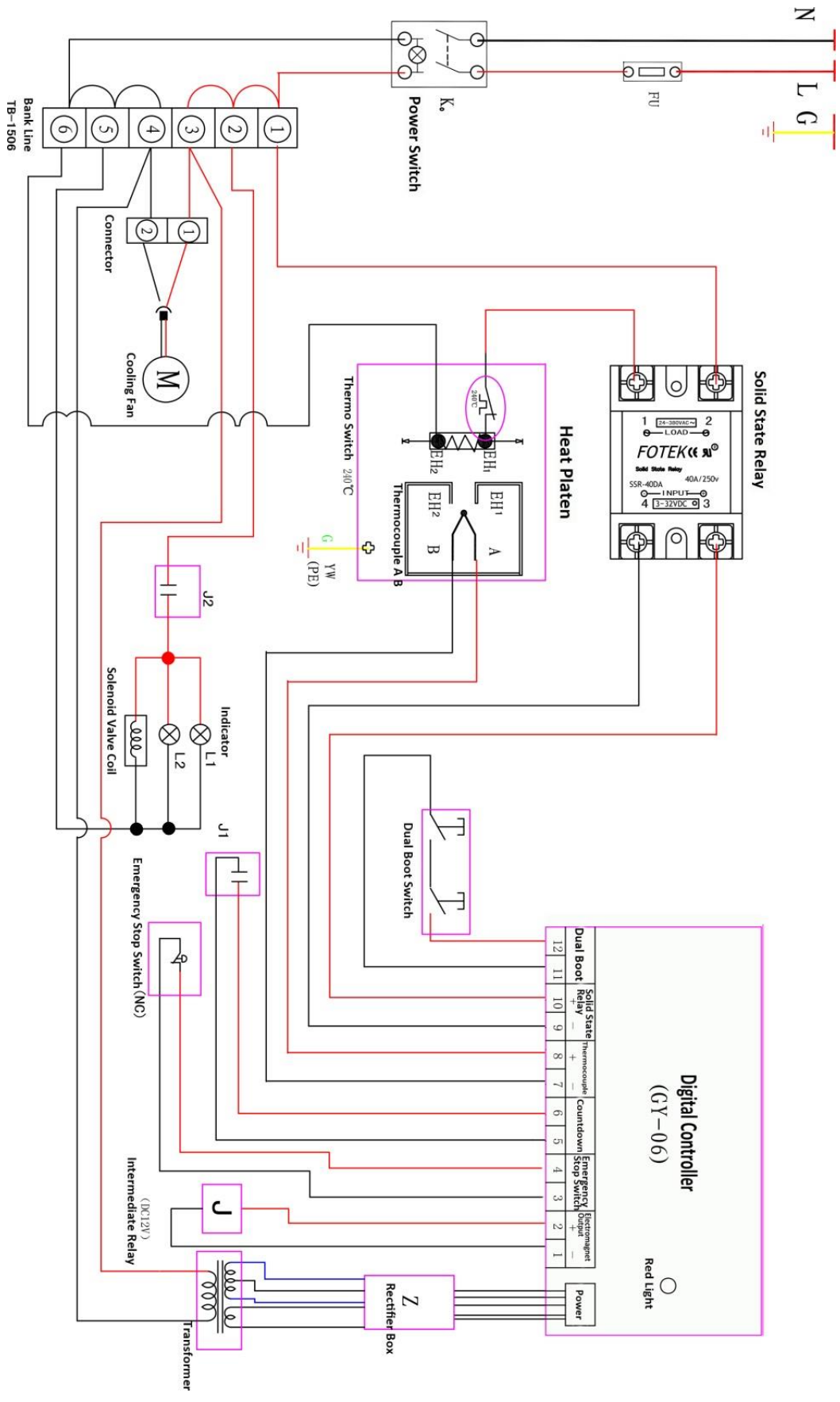
The **Digital Thermometer with external probe** is suitable for surface, air and immersion/penetration measurement, which is required for all Heat Presses Diect heat presses.

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

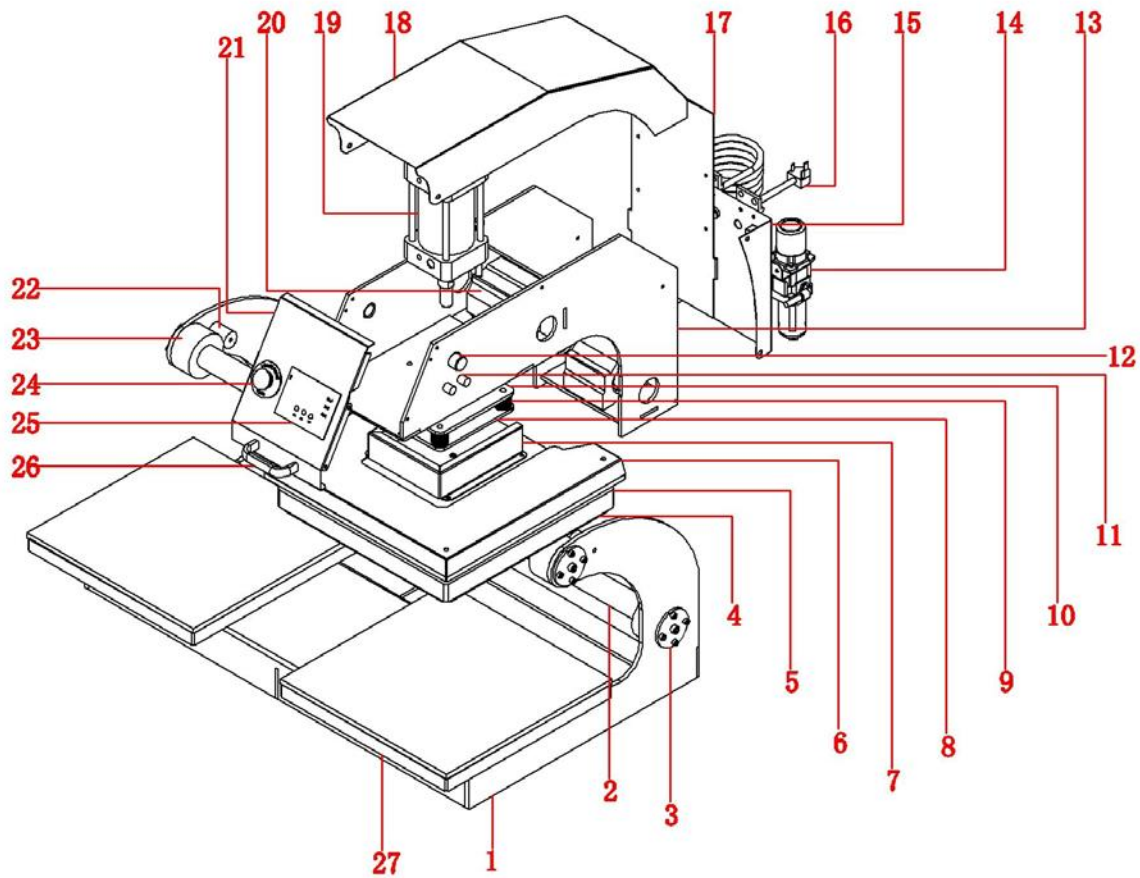
VI. Trouble Shooting For Transfer Print Quality

1. If the print color is pale: the temperature is too low/ the pressure is not correct/ or not pressed for long enough.
2. If the print color 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.
4. 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.
5. If transfer paper sticks to the object after transferring: the temperature is too high/ or poor quality printing ink.

VII. Electrical Diagram



VIII. Exploded Diagram



No.	Part Name	Qty
1	Machine Frame	2
2	Slide Rail	1
3	Slide Rail Fixed Plate	1
4	Heat Platen	1
5	Heat Platen Cover	1
6	Anti-scald protect metal cover	1
7	Spring Protective Cover	2
8	Spring Fixed Cover	2
9	Spring	1
10	Adaptor Plate	1
11	Air Regulating Valve	1
12	Start Switch	1
13	Side Plate	1

14	Air Filter	1
15	Back Plate	4
16	Power Cord	1
17	Electronic Parts Bracket	1
18	Upper Cover Plate	1
19	Air Cylinder	1
20	Spindle with Base	1
21	Controller Cover	1
22	Electromagnet	2
23	Casting Polyurethane	2
24	Emergency Stop Button	2
25	Digital Controller	1
26	Front Handle	1
27	Under Plate	1