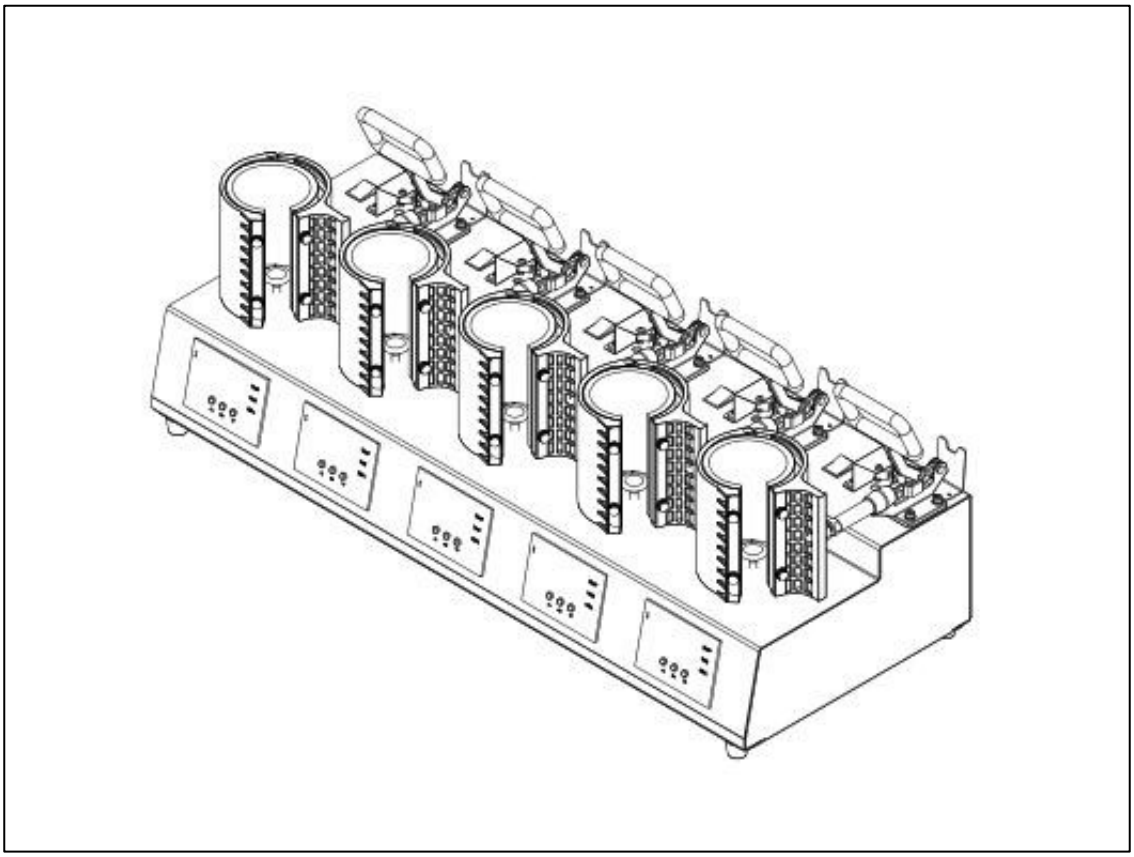
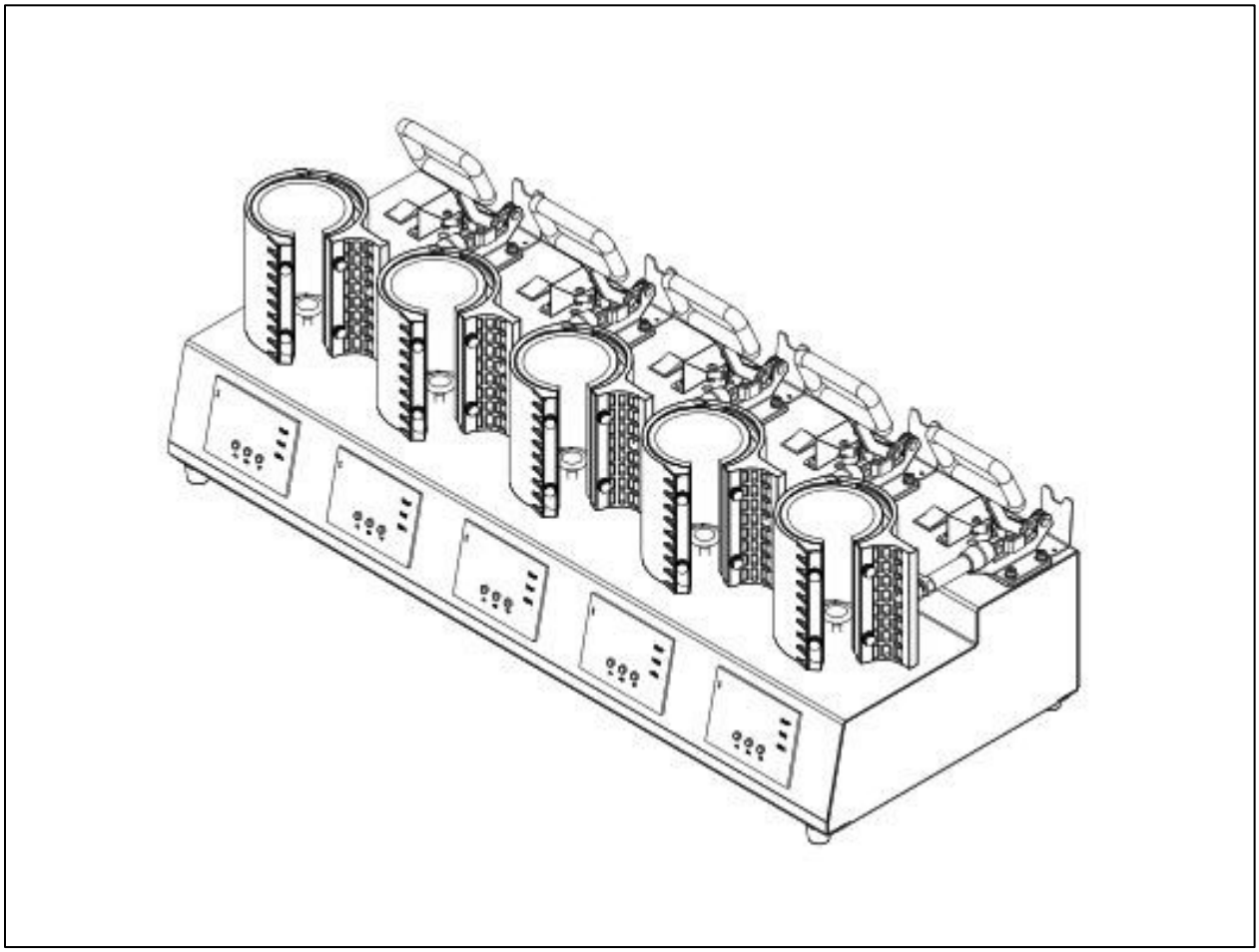
5 Station Mug Press

Model No.: XP7622



CONTENTS.

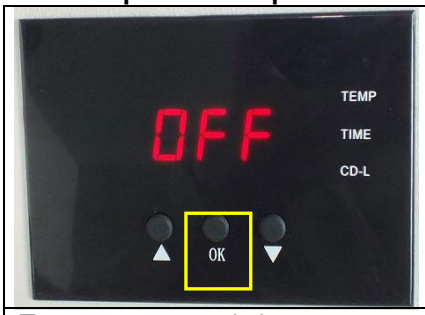
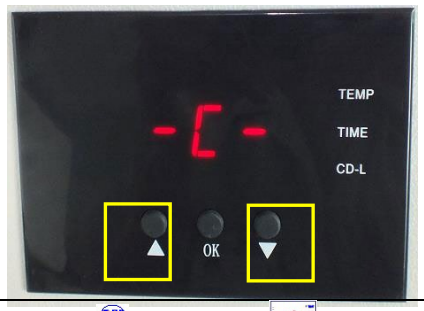
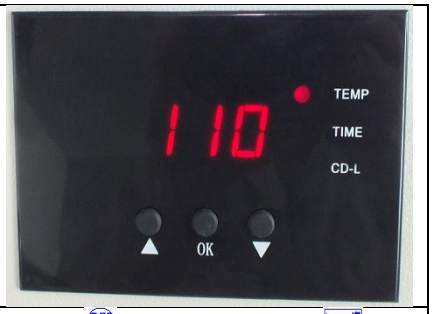


I. Technical Parameters

1. Model No.: XP7622 5 Individual Digital Temperature Controllers & 5 individual Time Controllers
2. Machine Dimension: 920 x 350 x 357mm
3. Machine Weight: 28 Kg
4. Heating Element Size: Dia.6-7.5cm for 6oz, 9oz, 10oz etc Mug, Dia.7.5-9.0cm for 11oz, 15oz etc Mug
5. Printable Articles Max Size: Ø72/Ø82 x 120mm
6. Voltage: 220V/1Phase
7. Power: (x5) 300 W = 1500 W
8. Digital controller display value: 0~999s
   Recommend Setting: 120~220s 180~200°C
9. Packing Size: 930 x 480 x 390 mm
10. Packed Weight: 31Kg

II. Operating Process

1. Set temperature required.

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

2. Set time required

	
Press OK button after temperature setting and the time light is on. Using the arrows select the time according to different transfer material.	Press OK button after time setting; the display shows the temperature starts to rise. "CD-L" shows the time counting down during your transfer.

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. Calibrating the Controller

1. If there is a difference between the actual temperature and temperature shown on the controller, you can use P5 mode to calibrate the difference.
   For example, when the actual heating element temperature is 180°C but the display shows 200°C, press the "OK" button for 5 seconds to enter P5 mode. Whilst in P5 mode, press the UP arrow "△" to set to 20, and then press the "OK" button again, for 5 seconds, to return to operational mode. Conversely, when the actual heating element temperature is 200°C but the display shows 180°C, press the DOWN arrow "▽" to set to -20 and then press the "OK" button again for 5 seconds to return to operational mode.

2. To change the heating and pause time, after the machine enters the constant temperature mode, press the "OK" button, after P5 mode to enter P6 mode. The setting parameters are different according to different size of heating element.

3. To set when the machine will enter constant temperature mode, press the "OK" button, after P6 mode, to enter P7 mode. Whilst in P7 mode you can set a constant temperature value that you want to achieve before reaching the set temperature.
   For example, when the set temperature is 180°C and P-7 is set to 10°C, then when the temperature reaches 170°C, it will enter the constant temperature mode whilst heating and pause in cycle to avoid overheating.

4. To set the heating and pause time, after the machine has reached the set temperature, press the “OK” button after P7 mode to enter P8 mode (The setting range is 0-9 sec).

5. Press the “OK” button after P8 mode to enter P9 mode.

   In P9 mode there are two choices:
   YES mode: When the temperature reaches the set temperature, the countdown begins (if the temperature doesn’t reach the setting temperature, the countdown won’t begin even if the heating element is closed)

   NO mode: Once heating element is closed, the countdown begins.

   Factory default settings is YES mode.

   N.B.: It is not advisable to change any settings for P-6 to P-9 without first consulting our engineers as this could cause damage to your press.

3. Printing methods.

Step 1: Make sure the cord is connected firmly to the wall socket. Place the Mugs in the heating elements and then put transfer paper, with image facing down, onto the Mugs. Adjust the pressure to your requirement, and turn on the power. P.S: Use heat resistant tape to fix the transfer paper, making sure the transfer paper is securely attached to the Mug and is in the correct position.

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 close the heating element, (in the meantime the buzzer will stop). This starts the transfer cycle.

Step 4: When the timer has counted down to zero, remove the Mug from the heating element and peel transfer.Note: if you want to transfer 5 mugs at one time, pls set the time and temperature separately for each heating element.

4. Recommendations:

Ceramic Mug transfer: (These settings are dependent on transfer paper, ink and mug type used and should be used for guidance only)

- Set temperature: 200°C.
- Set time: 240 seconds.

NOTE:

1) Please switch off the machine and unplug the power cord when the machine is not in use.
2) The heating element will cool down to room temperature if the machine is unused for more than 30 minutes.
3) To prevent damage to the 5 Station Mug Heat Press, the maximum setting temperature should be no more than 210°C (410°F).

III. 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 heating element 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 heating element will still not heat up, then check to see if the heat platen is faulty or the heating elements power cable is loose, you may need a new heating element.

3. The heating element 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 heating element 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 heating element.
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 heating element whenever the machine is not in use. This will prolong the life of the element and help to keep the image quality of your work high.

3). The machine should be stored in a dry place.

4). The heating element is a consumable part and as such will need to be replace after approx. 700 transfer cycles. Replacement heating elements are available to purchase from heatpressesdirect.com that will allow approx. 2000 transfer cycles.

5). If you are not able to solve your problem, please contact heatpressesdirect.com for technical support.

IV. 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.

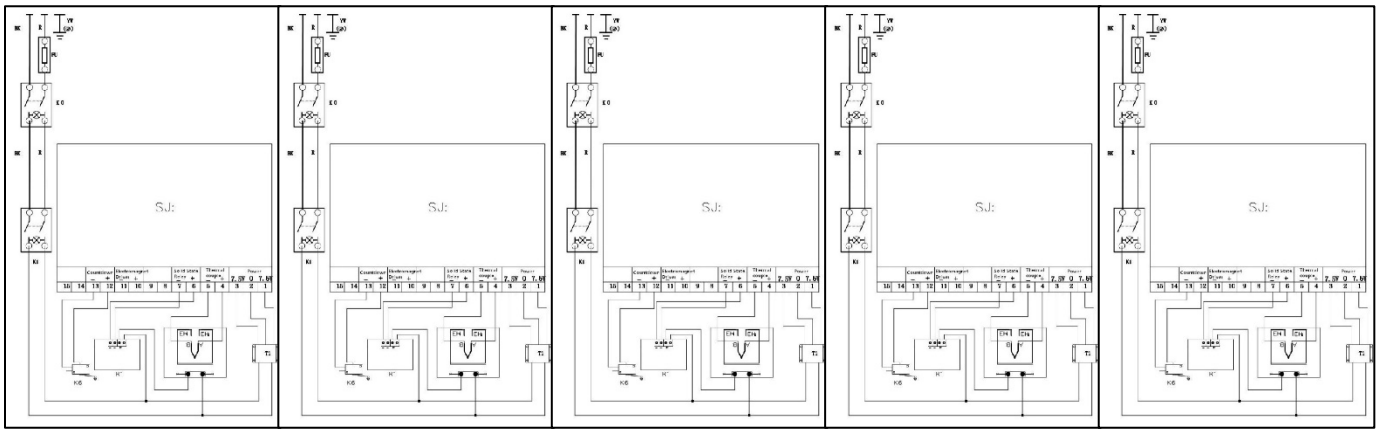
2. If the print colour is too brown or the transfer paper is almost burnt reduce the setting temperature.

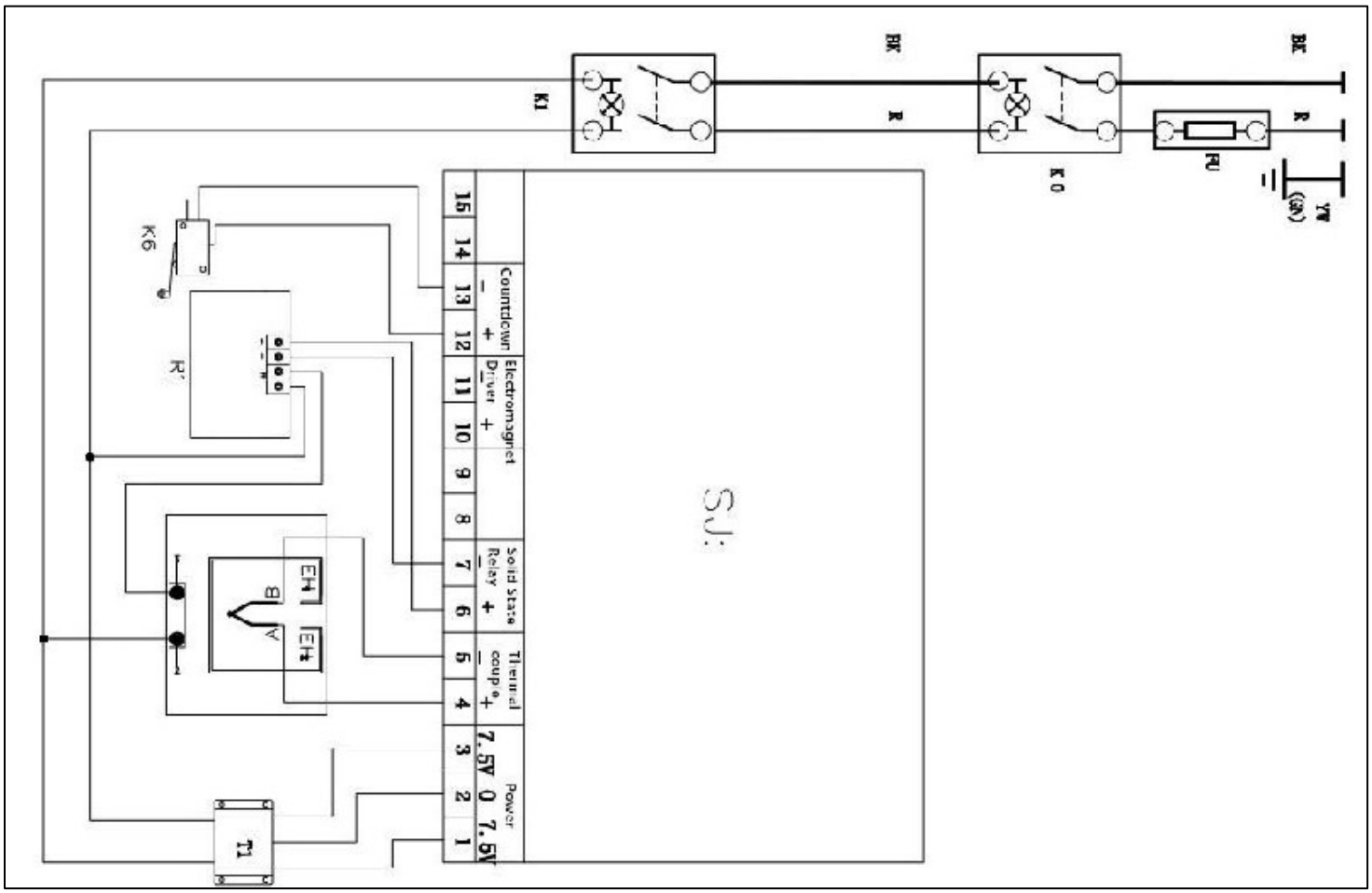
3. If the print is blurring too much transfer time causes proliferation of the ink.

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 Mug after transfer: the temperature is set too high/ or poor-quality printing ink.

V. Circuit Diagram

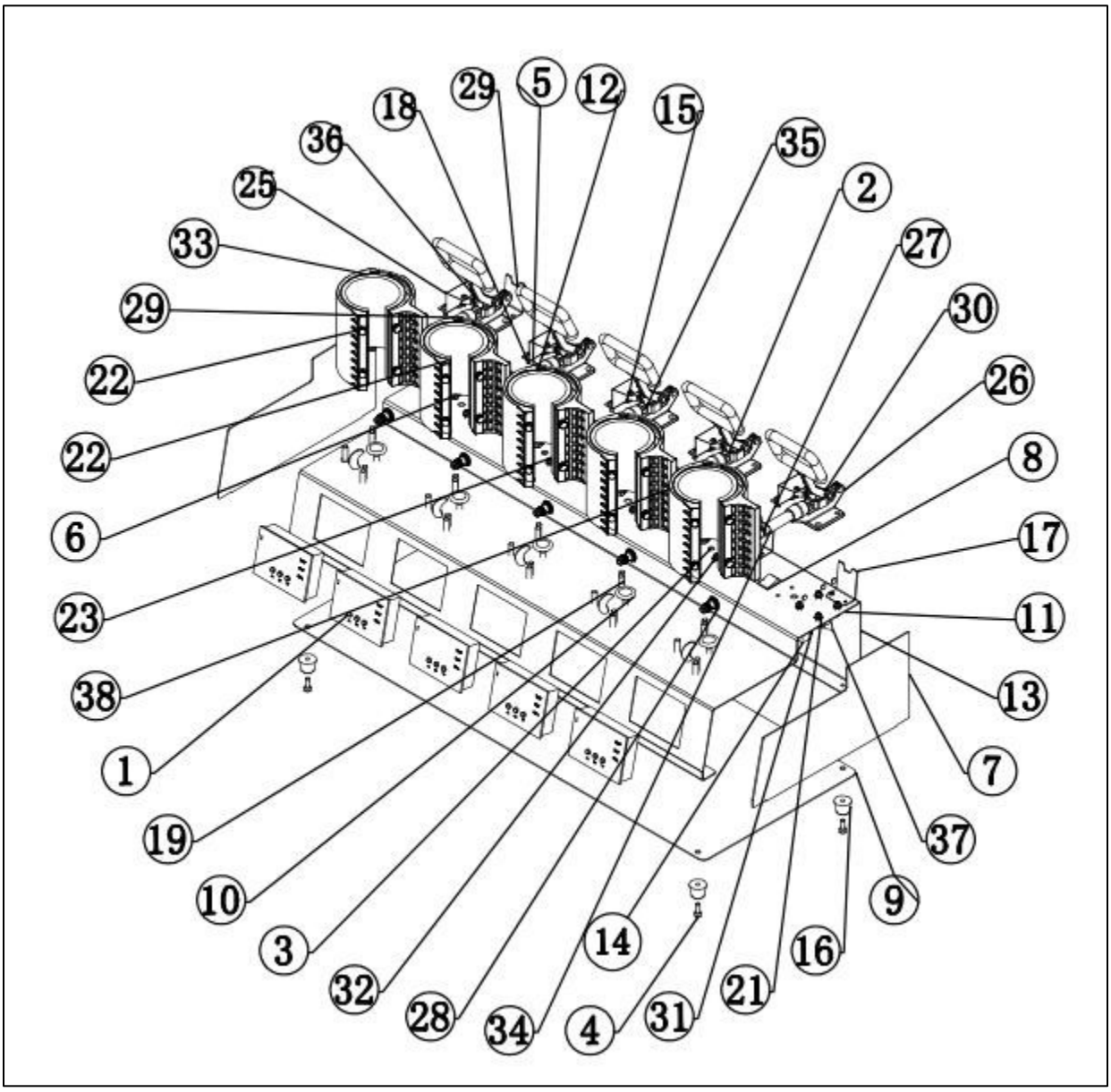




0-K5: Power Switch
R1-R5: Relay Board (4A)
A-B: Thermocouple (Inside of the mug heating element)
T1-T5: Transformer

FU: Fuse 15A/20
EH1-EH2: Mug Heating Element
SJ: GY-04 Digital Controller
K6-K10: Limit Switch

VI. Exploded View



Serial No.	Part Name	Qty
1	Digital Controller	5
2	Guide Pin 1	5
3	Transformer	5
4	Cup head hexagon screw M6X20	4
5	Power Switch	4
6	Mug Heating element	5
7	Side plate	2
8	Power switch	1
9	Bottom cover plate	1
10	Engine mount	5
11	Cup head hexagon screw M5x10	10
12	Cup head hexagon screw M5X20	5
13	Base	2
14	3 Pins outlet	5
15	Hexagon Nut M3	10
16	Conical engine mount 25 x 20	4
17	Quick-clamping backing plate	5
18	Truss head screw M5x10	10
19	Cup head hexagon screw M5x10	15
20	Round head screw M3x10	10
21	Cup head hexagon screw M6x20	10
22	Screw with high temperature resistant plastic cover - M5x12	20
23	Cup head hexagon screw M6x20	10
24	Hexagon Nut - M3	10
25	Limit switch chip	5
26	Quick-clamping base	5
27	Hexagon Nut	10
28	Small round air plug	5
29	Right half of aluminum mug clamp	5
30	Quick-clamping connector	5
31	3 Pins outlet	1
32	Flat gasket	20
33	Stainless sheet	5
34	Adjusting screw rod	10
35	Rivet head1	30
36	Limit switch	5
37	Low power electrical board	5
38	Left half of aluminum mug clamp	5

Charterhouse Holdings PLC
DECLARATION OF CONFORMITY

Application of Council Directives:	European Low Voltage Directive **(LVD)**, European Machinery Directive **(MD)**, Electro Magnetic Conformity **(EMC)**
Standards to which Conformity is Declared:	**(LVD):** **EN 60204-1:2018** **(MD):** **EN ISO 12100:2010 2006/42/EC Annex1** **(EMC):** **EN 61000-6-2:2019**
Manufacturer's Name:	Charterhouse Holdings PLC
Manufacturer's Address:	Oakridge Park, Trent Lane, Castle Donington, Derby DE74 2PY United Kingdom
Type of Equipment:	5 Station Mug Press
Standards Compliance:	RoHS COMPLIANT CE
Model Number:	XP7622
Serial Number:	.....
Year of Manufacture:	.....

I, the undersigned, hereby declare that the equipment specified above conforms to the above directives and standards.

Place: Castle Donington, United Kingdom

Signature: .. M. S. Carter ...

Date: 15th June 2023

Full Name: Miles Carter

Position: Chief Executive