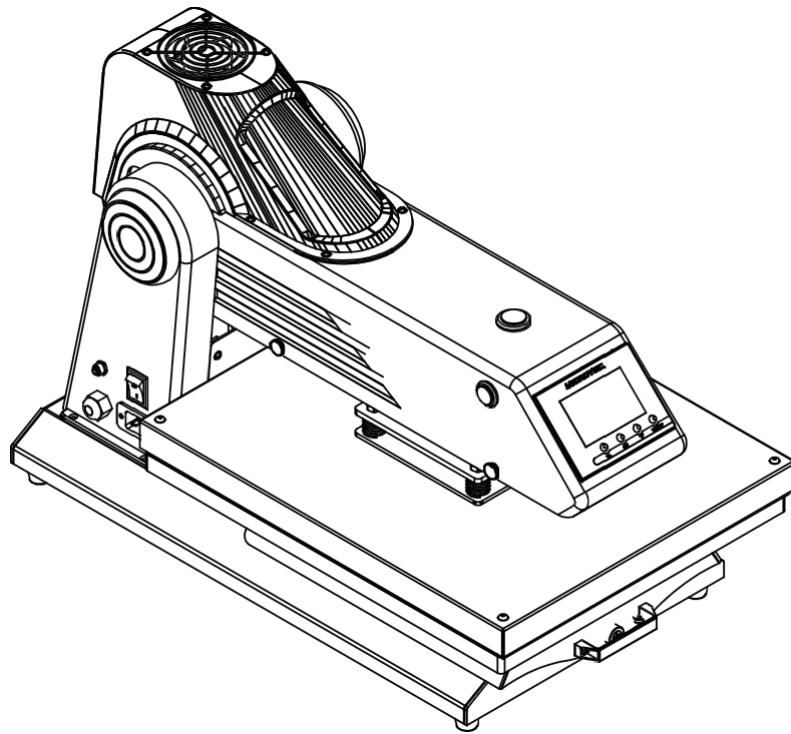


E-15S/E-20S

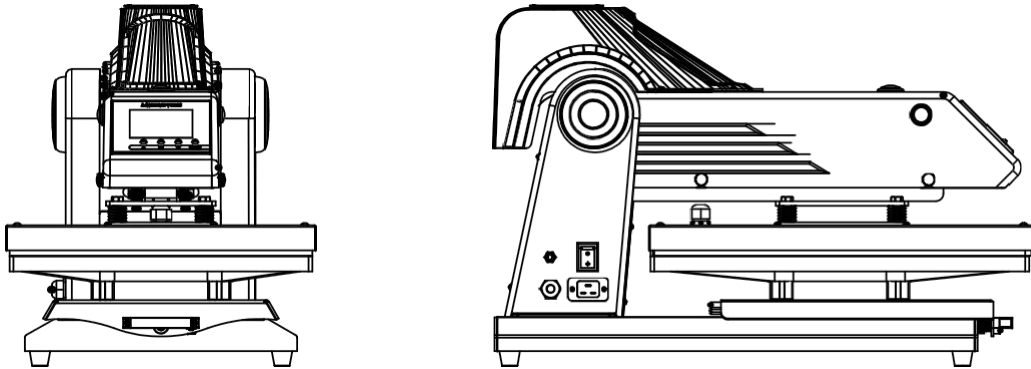
OPERATORS MANUAL



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I. Technical Parameters



Model No. : E-15S/E-20S

Description: Electric powered fully auto heat press

Heat platen sizes: 380x380mm (15"x15") / 400x500mm (16"x20")

Voltage: 110V/220V single-phase

Power: 1.6KW/1.8KW

Temperature range: 0-255 °C (0-490°F)

Time range: 0-999S

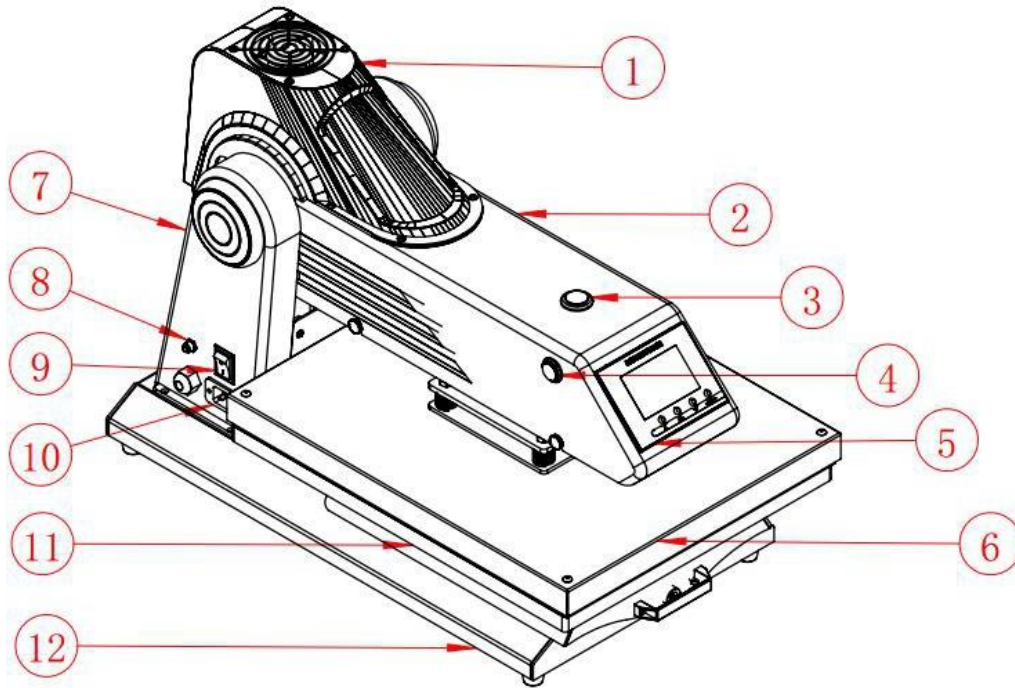
Pressure range: 0-10

Printable articles thickness: 0--20mm

Main Features:

- ✂ Fully electric control: no need noisy air compressor.
- ✂ Auto press down & auto open with safe start button.
- ✂ Easy pressure adjustment according to the thickness of items.
Program up to 10 different pressure.
- ✂ GY-08 controller with different pressure and dual time setting. It also stores frequently used settings, production cycle counter.
- ✂ Perfect for high volume commercial use, specialty decorators, direct-to-garment printing, and embossing etc.

II. Assembly Drawing



- | | | | |
|-----|-----------------------|-----|-----------------|
| 1. | Machine Cover | 2. | Davit Arm Cover |
| 3. | Emergency Stop Button | 4. | Start Buttons |
| 5. | GY-08 Controller | 6. | Heat Platen |
| 7. | Electric Box | 8. | Circuit Breaker |
| 9. | Power Switch | 10. | C19 Cable |
| 11. | Under Plate | 12. | Machine Base |

III. Operating Instructions

1. Plug the power cord into a standard 110V 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.
2. Heat transfer parameters settings.
 - A. Press “OK” button to enter **TEMPERATURE** setting
When the **TEMP** indicator blinks, use Up/Down buttons “**Δ**” **∇**” 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 **Δ**” **∇**” 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 “**Δ**” **∇**” 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 TIME2 can be set in same values, and then the machine will be operating in same transfer parameters in cycle.
 - D. Press OK button to enter into **PRESSURE** setting
The machine comes with segmented pressure mode, which can be adjusted according to different thickness of transfer materials in bulk transfer. Pressure value range: 0-10. (Pressure will be higher if you increase the setting value; the suggested pressure value for textile transfer is 7.)
 - E. After finishing above-mentioned settings, your machine is ready for pressing.
3. When the temperature reached to the set value, you can start the transfer printing by following below steps:
 - A. Pull out the under plate, and place the transfer material flat onto the silicon pad.
 - B. Push the under plate back to its original position.

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.

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

F. Pull out the under plate, lay the transfer paper over the transfer material, then push the under plate back to its original position.

G. Press the starting buttons with BOTH hands at the same time, heat platen press down automatically, TIME2 indicator blinks and the transfer timer starts to countdown.

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

J. Pull out the under plate, and take out the transferred material.
The pressing is finished.

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.

4. During the operation, if there is an unexpected situation for an emergency stop, press the emergency stop switch to stop this operation.

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

6. This machine helps to minimize the physical labor of operator; it has self-intermittent function to make it possible to work long hours. One operator can do multi-machine pressing at same time to increase the efficiency of work.

IV. Maintenance

1. It's necessary to maintain the machine regularly for stabilizing its performance, prolong service life, and to ensure the transfer process goes smoothly.
2. Fill or smear the lubricants on main active friction parts regularly.
3. Check the main parts frequently to make sure the screws are well fastened all the time.
4. Please set suitable transfer parameters (pressure/temperature/time) according to the transfer materials. It could cause the machine overloaded and damage heat platen by setting excess values.
5. Please follow above mentioned operating instructions correctly to prevent accidents from happening during the operation.

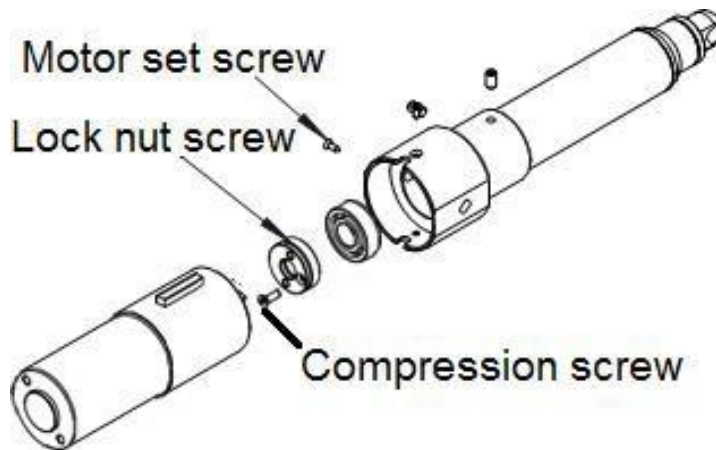
V. Trouble Shooting

1. Pusher lift with active gap.

Analyze: locking nut loose on Push rod bearing (refer to below picture)

Solutions:

- a. Loosen the hand wheel screws on both sides of the davit arm cover, and open the cover.
- b. Remove the motor set screws, pull the motor out.
- c. Insert the Needle-nose pliers into the Lock nut screwed hole to tighten the lock nut according to the **ft** you required, then tighten the compression screw.
- d. Install the motor back, and tighten the Motor set screw, then close the davit arm cover.



2. Large area of transferred paper with residual colors remains after heat transfer.

Analyze: The setting temperature or the pressure is too low.

Solution: Increase the temperature or the increase the pressure properly.

3. Transferred paper appear brown color after heat transfer

Analyze: The temperature setting is too high

Solution: Decrease the temperature properly.

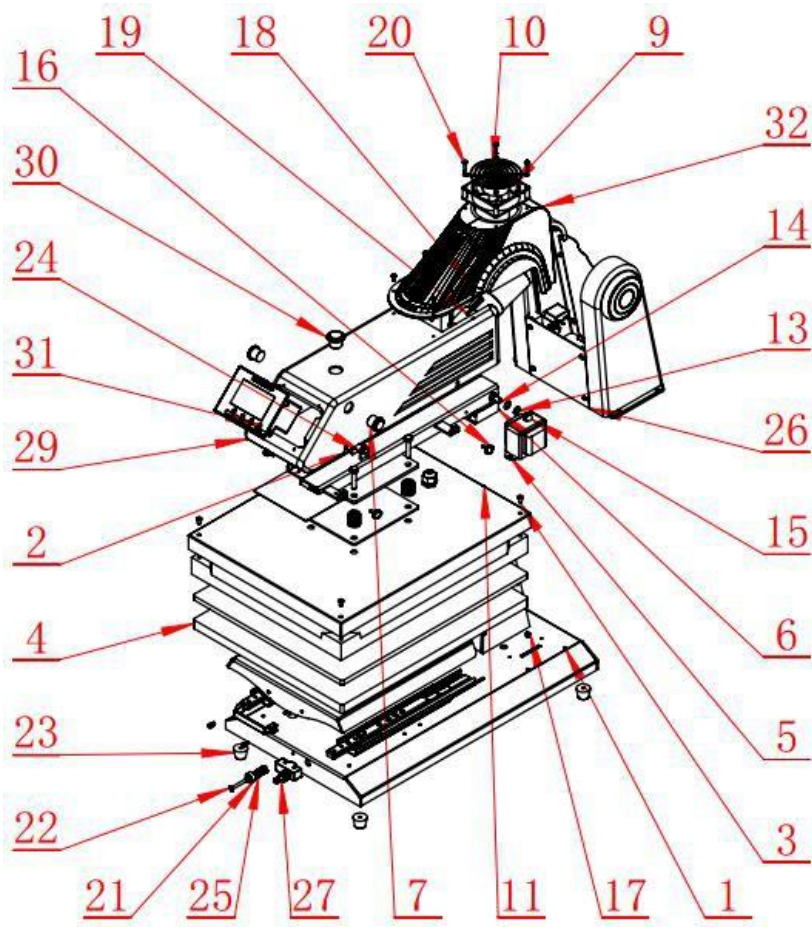
4. Part of the transferred image with bad transfer result.

Analyze: The pressure on the heat platen is not even.

Solution: Adjust the mold spring pressure on heat platen cover.

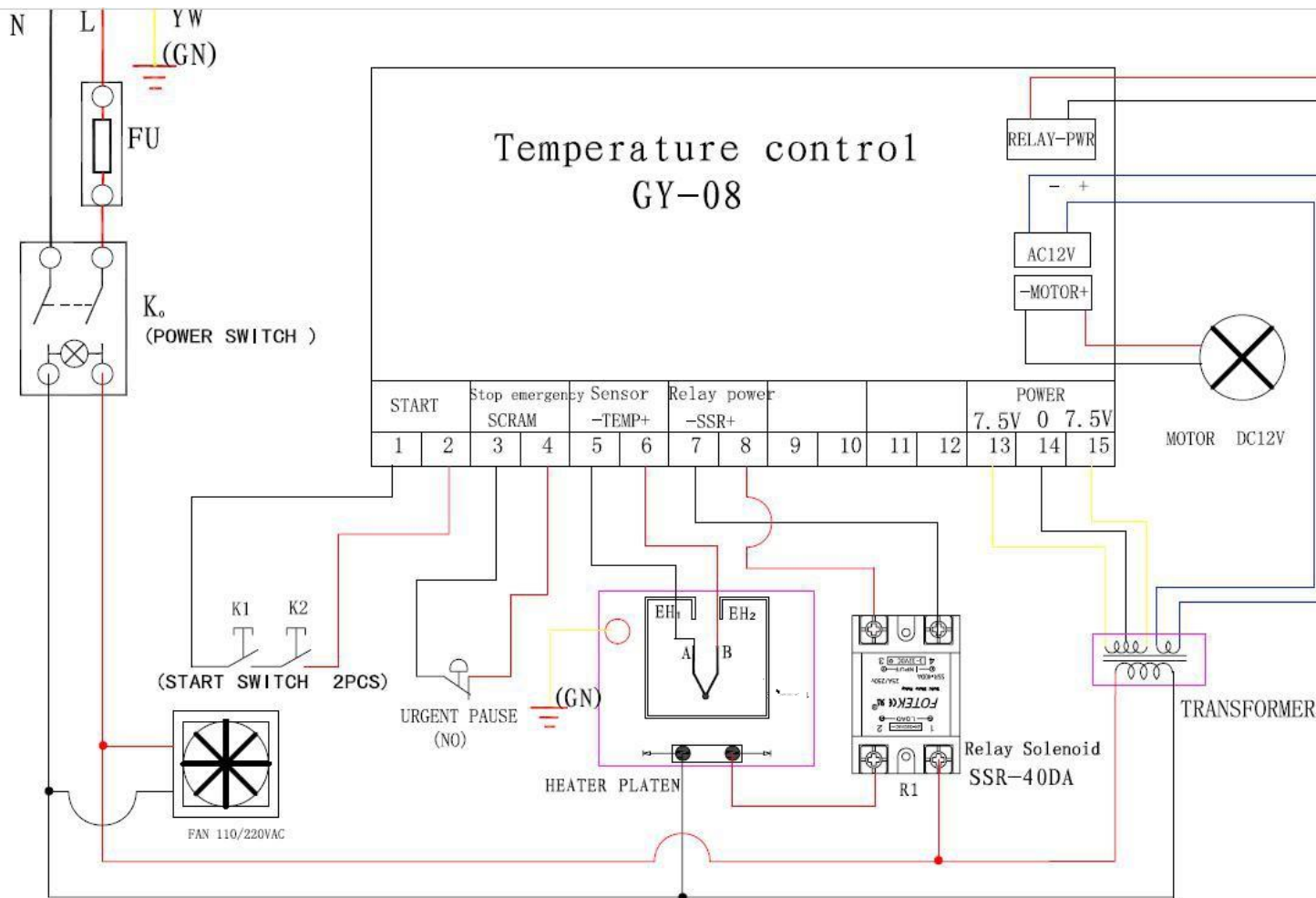
Try to loosen the spring that near bad transferred area, or tighten the springs on other areas.

VI. Explosive View



Item No.	Part name	Qty	Item No.	Part name	Qty
1	Iron base	1	17	M5x12 screw	1
2	Davit arm	1	18	M4x10 cushioned screw	5
3	Heat platen	1	19	Push rod set	1
4	Under plate	1	20	M4x20 cushioned screw	4
5	Transformer	1	21	Strong electromagnet	1
6	Relay	1	22	M5 screw	1
7	Start buttons	2	23	Machine feet	4
8	Electric box	1	24	Connecting shaft	1
9	Fan	1	25	12x20 mold spring	1
10	Fan cover	1	26	Back electric box set	1
11	Damping rubber jacket	2	27	Limit switch	1
12	M10x20 screw	2	28	Terminal block	1
13	10.0 washer	7	29	Davit arm cover	1
14	Davit arm shaft	1	30	Emergency stop button	1
15	M10 ball screw nut	2	31	GY-08 digital controller	1
16	M5x12 hand wheel screw	4	32	Back electric box cover	1

VII. Circuit Diagram



K.: Power Switch

T: Bridge Transformer

EH1 EH2: Heating Pipe

NC: Limit Switch

FU: Circuit Breaker

K1 K2: Start Buttons

NO: Emergency Stop

R1: Solid-state Relay