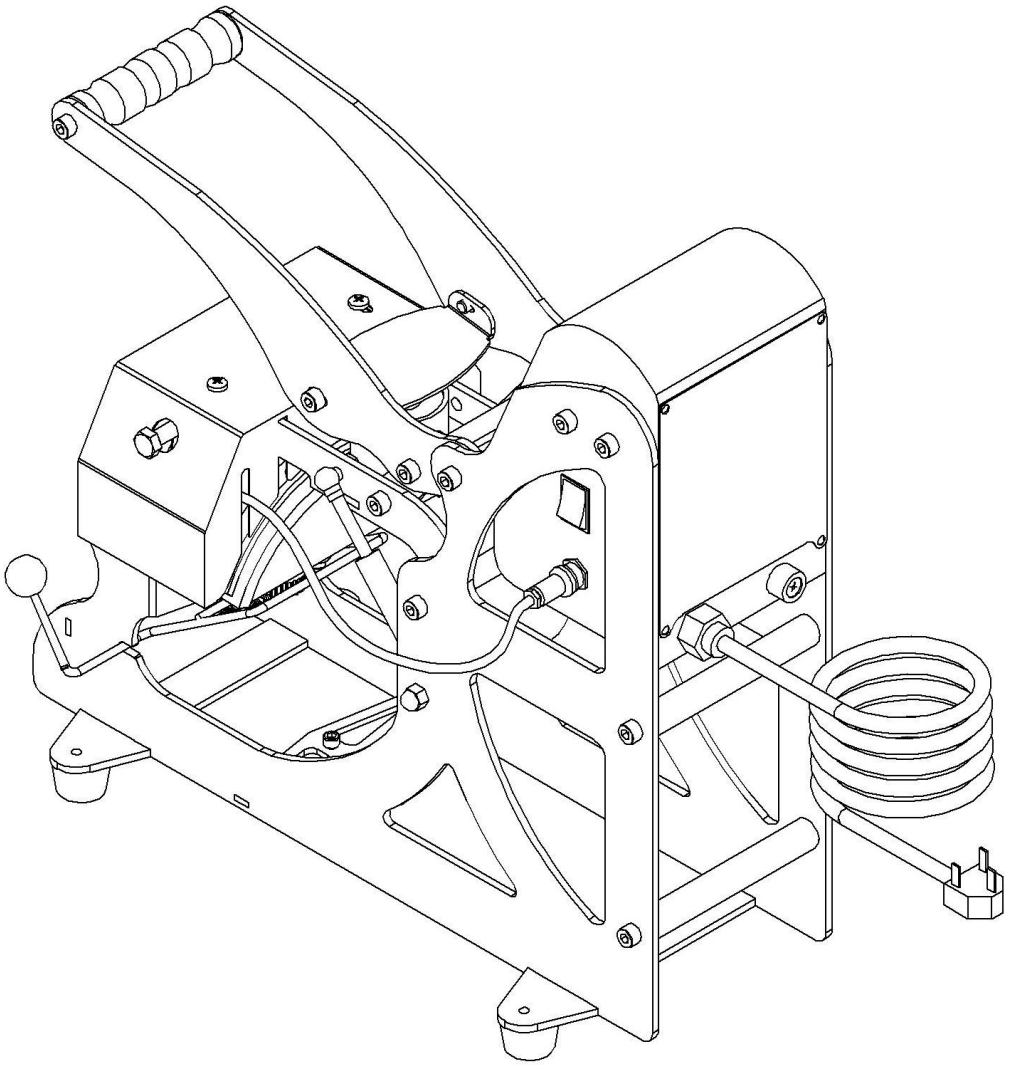
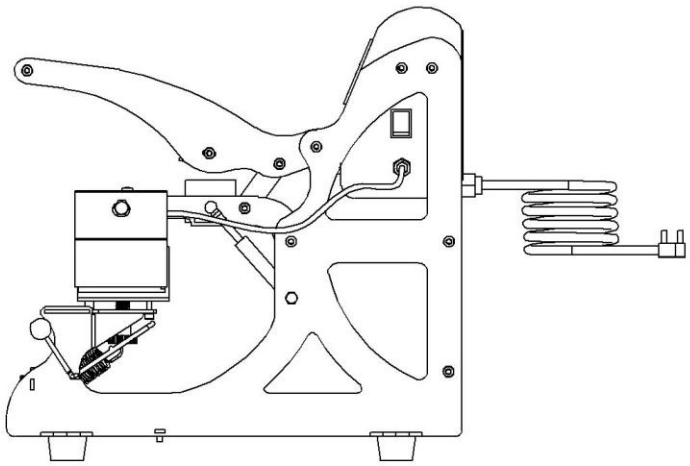
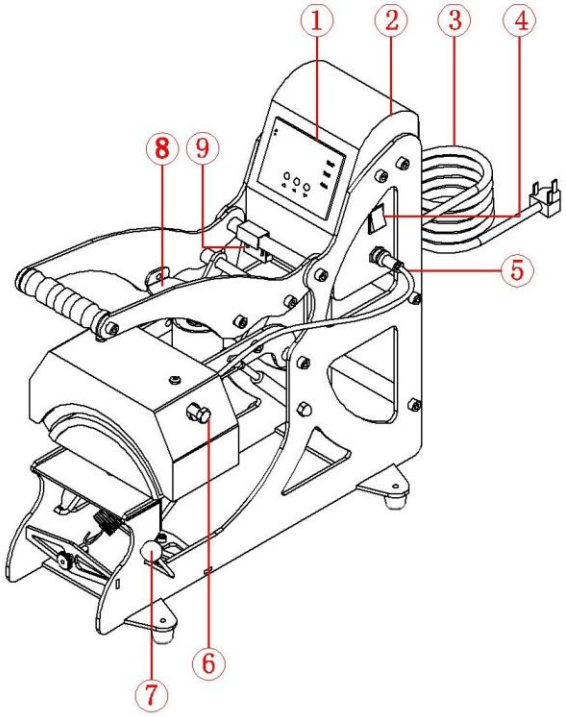
Auto Cap-Pocket Combo Heat Press
Model No.: HPD.ACPC200



CONTENTS

I. ASSEMBLY DRAWING





①Digital Controller ②Controller Box ③Power Cord
④Power Switch ⑤Heater Socket ⑥Connecting Screws
⑦Cap Attachment ⑧Electromagnet Plate ⑨Limit Switch

II. Technical Parameters

1. **Model No.**: Auto Cap-Pocket Combo
2. **Machine Size**: 526 x 500 x 250 mm
3. **Printable Articles Max Size:** 80 x 130 x 10 mm
4. **Voltage:** 220V Single Phase
5. **Power:** 0.6kw
6. **Recommend Setting:** 30~280s; 180~200ºC
   Time Range: 0~999 Sec
   Maximum Temp: 225ºC
7. **Packing Size**: 620 x 600 x 350 mm
8. **Gross weight**:25Kg

III. Operating Procedure

1. Set temperature required

		
Turn on power switch, temperature light is ON. The digital display shows as above.	Press OK button, the °C light is on (C denotes Celsius). Press arrows "△" or "▽" to select "℃" or "℉" (F denotes Fahrenheit) according to your habits.	Press OK button, the temp light is on. Select with arrows the temperature according to different transfer material (Normally 180ºC~200ºC) SV: Set temperature PV: Current temperature

2. Set time required

	
Press OK button after temperature setting and the time light is on. Select with arrows the time according to different transfer material. SV: Set temperature PV: Current temperature	Press OK button to operating mode. Counter is "transfer cycle", from 0~999 Sec. Press "Reset" for 5 seconds to return the counter to "0".

NOTE: Please do as follow:

1） When SV and PV has a big difference

2） When the temperature shows on the display is not the same as actual temperature on heat platen

	
When SV and PV has a big difference, press OK button for 5 seconds, and press OK button again to adjust the temperature. If SV&PV has difference of 20 degrees, Press arrows "△" or "▽" to set to 20.	When the temperature shows on the display is not the same as actual temperature on heat platen, press OK button for 5 seconds to reset mode: ①When display shows 200°C, the actual heat platen temperature is 170°C, Press arrows "△" or "▽" to set to 30. ② When display shows 200°C,the actual heat platen temperature is 230°C, Press arrows "△" or "▽" to set to -30

3. Printing methods

Step 1: Make sure the cord is connected well to the wall socket. Place the object (i.e. Cap) on press bed, and transfer paper with images facing down the object, adjust pressure to your requirement, and start the machine.

Step 2: Set the temperature and time required, then temperature starts to rise.

Step 3: When the temperature has risen to the set temperature, the buzzer will sound; then close down heat platen (in the meantime the sound will stop) and the transfer cycle will start.

Step 4: Once the time is up, the upper heat platen will automatically.

Step5: Consult the Transfer Paper instructions on whether to peel cold or hot. Below are suggested pressing time guidelines for different transfer paper:

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

5. Recommendations:

1) Ceramic tile transfer: (Mugs & Plates transfer is similar)
Set temperature: 180℃. Set time: 15 seconds
2) T-shirt transfer:
Set temperature: 180℃.
Set time: (chemical fiber use for sublimation transfer paper: 30-50seconds; pure cotton use for T-shirt transfer paper: 10-20 seconds)

step 6: When the temperature has risen to the set temperature, the buzzer will sound; then close down heat platen (meantime the sound will stop) and the transfer cycle will start.

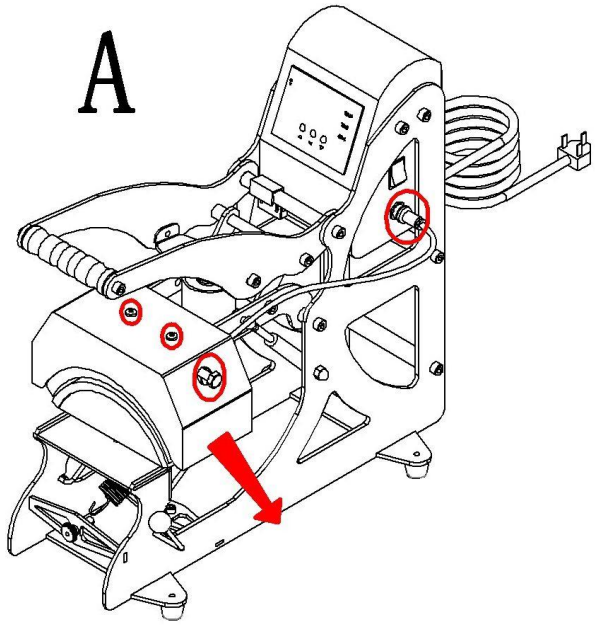
step 7: Time is counting down; once time is up, the buzzer will send out a sound again, the heat platen will open automatically (in the meantime the sound will stop).

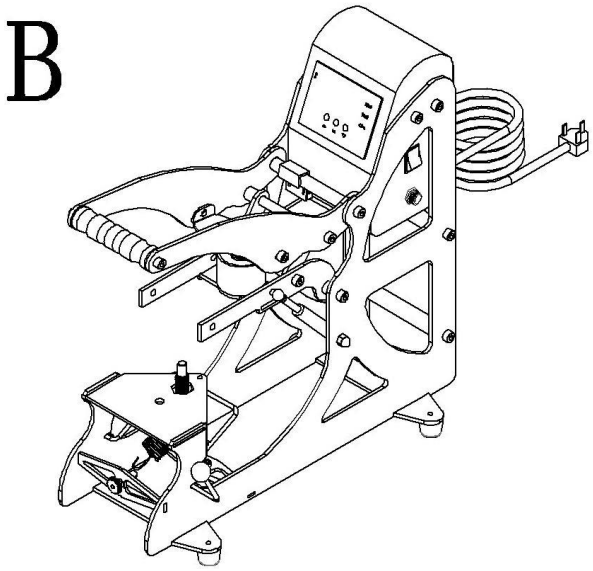
Step 8: Work finish and take out the cap. If you want to print on another cap, press OK button and confirm the time and temperature set as last time, then repeat above process.

NOTE:

1) Please 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 heat press stays un-use for more than 30 minutes.
3) The heat-releasing fan will automatically start when the temperature of heat platen reaches 80ºC (176ºF). It helps to reduce the temperature of electrical parts and prolong the service life of them.
4) For better maintenance of heat press, the maximum setting temperature is 210ºC (410ºF).
5) To avoid re-heating the first transfer when printing double sided T-Shirts, insert a sheet of cardboard in between the shirt; adjust the height to less pressure, then press.
6) Heat platen may pivot slightly back and forth rotationally. This is due to movement allowance within the clamp assembly, and is normal.

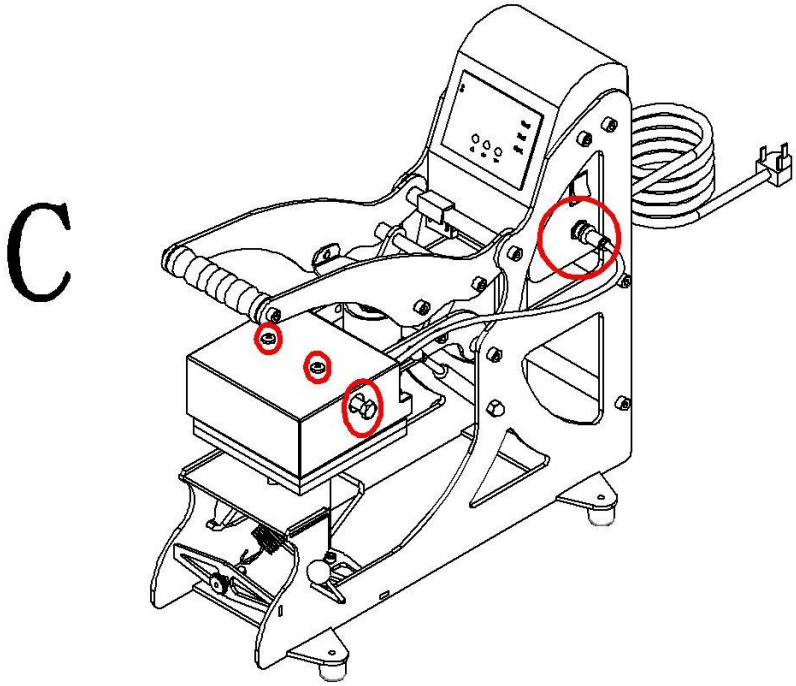
IV. Changing Heating Elements





Remove the male socket which is connected to Female socket set in side of electrical case;
Unscrew two screws on the cap heat platen.

Install 15x15cm heat platen as the above picture



Fitted with locking screws, and insert the socket.

V. Maintenance

1. No action after turn on the machine

1). Check the plug whether it connects well or whether it is broken.

2). Check the power switch or digital controller whether it is broken.

3). Check the fuse whether it has been burnt out.

4). Indicating light is on, but no display on screen, check the 5 cable of Railway transformer. If it's loosening, showing the problem is poor connection. If they connects well, showing that the Transformer is faulty.

2. The display screen are working well, but no temperature increasing on the heat platen.

1). Check whether the thermocouple of the heat platen touches well. If the thermocouple is loose, the display will show 255 and machine keeps beeping.

2). Check if the indicating light of solid-state relay is on, if not, check if the relay or digital controller is broken.

3). If you already changed the new solid-state relay but the heat platen still can't heating up, check if the heat platen is faulty or the heat platen's power cable is loose, need to change by new heat platen.

3. The heat platen works well, but suddenly the display screen show 255℃.

1). Check whether the thermocouple of the heat platen touches well.

2). If the thermocouple touches well but still show 255℃, then it is faulty.

4. The machine is heating during 0~180℃, but display number jumps to above 200℃ or 300℃ suddenly, or the numbers on display jumps irregularly.

1). Check whether the thermocouple of the heat platen touches well.

2). If the thermocouple is good, It shows that the program of digital controller is broken, which namely IC or is broken, need to change by new controller.

5. The temperature is out of control: Set 180℃，but the actual temperature is above 200℃。

1). It means the solid-state relay is broken, out of control, need to change the relay.

2). Or the digital controller is faulty and it keeps conveying electric to relay, need to change controller.

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

1). Please reset the temp and time according the operation process manual.

7. Other notice

1). In order to prolong the machine service life, please add the lubrication oil regularly on the joints.

2). In order to keep the heat platen's good transfer effect, you need to protect the heat platen carefully whenever you are using it or not.

3). Please keep the machine in dry place.

4). If you are not able to solve the electrical parts problem, please kindly contact the supplier and get technical support.

8. The following checks should be carried out at regular intervals by a qualified and competent person:-

- Electrical connections
- Mechanical moving parts

VI. Trouble shooting for transfer print quality

1. If the colour is not as bright as photo after printing.

Solution(s):

a. Adding transfer time

b. Increasing transfer temperature

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

Solution: Reduce the setting temperature

3. If the print is blurring.

Solution: Reduce the transfer time

4. If print colour is different/partial transfer effect is not good enough.

a. The pressure is not correct (use more pressure).

b. The job has not been pressed for long enough.

c. The transfer paper is of a poor quality.

5. Transfer paper sticks to the object after transfer cycle.

a. The temperature is too high.

b. The ink quality is poor.

6. Prolonging your machines useable life.

Add lubrication oil regularly.

7. Ensuring heat transfer quality.

Take care of your press by storing carefully when not in use.

8. Site the machine in a dry place and on a firm and stable surface.

9. Always use quality replacement parts fitted by a competent person.

10. If your press will not work please contact https://www.heatpressesdirect.co.uk/

VII. Heat Plate Temperature Measurement

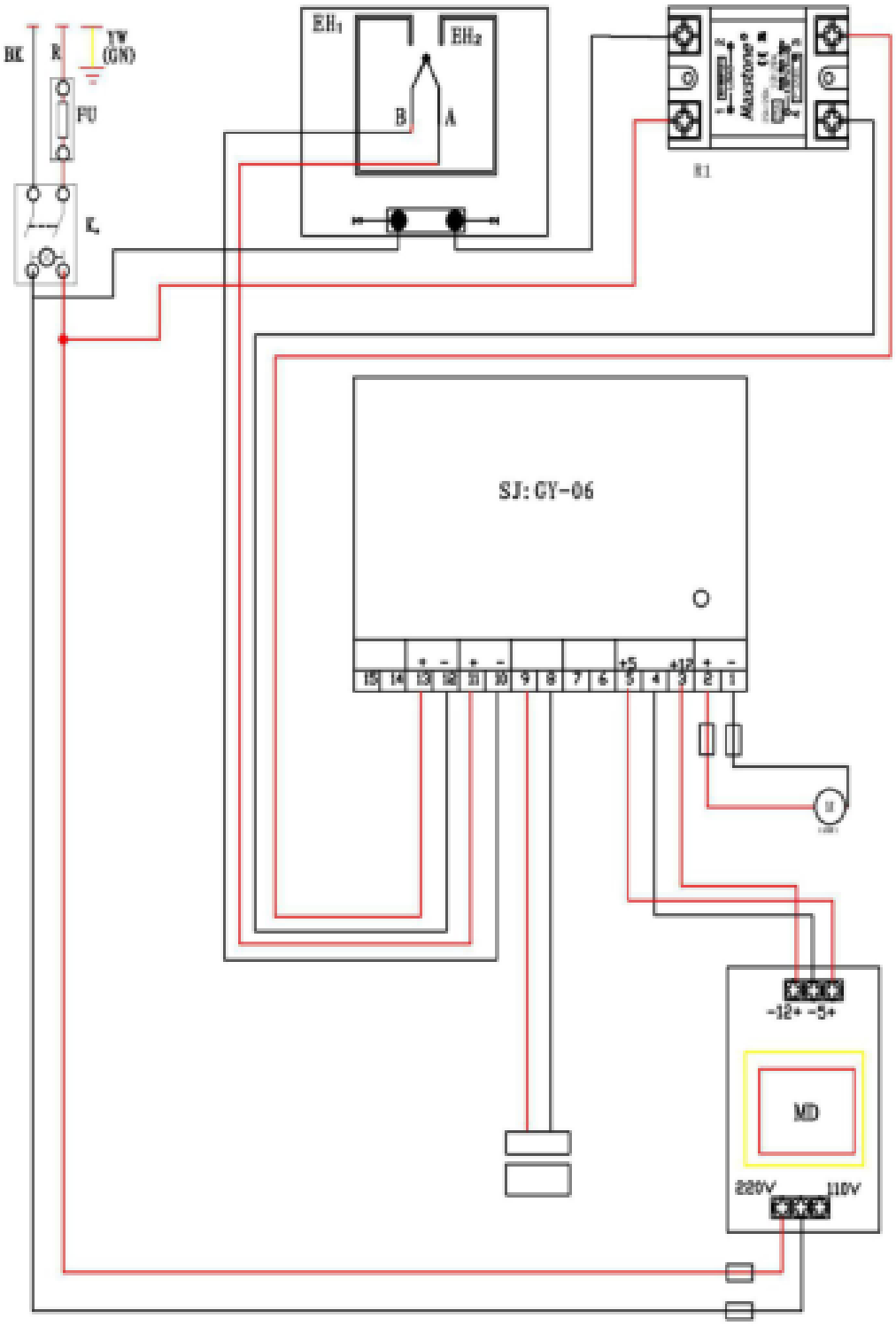
Testing of the Heat Plate for temperature consistency or fault condition should only be undertaken after consulting a qualified engineer, and then only using a wired Digital Thermometer **(*please see note below)**.

***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.

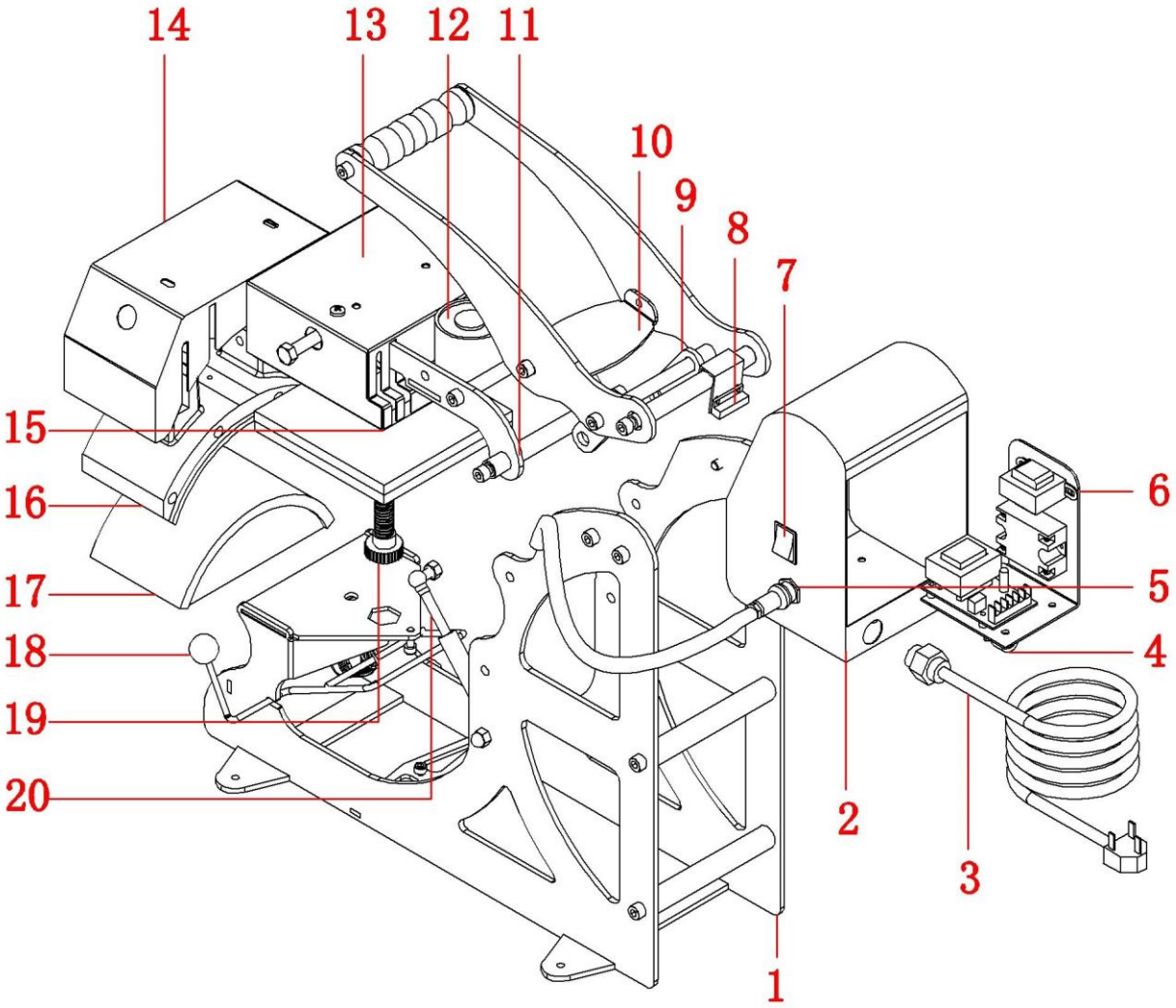
Laser Thermometers only measure air surfaces which can be misleading due to currents of hot air floating on the surface of the heat plate.

VIII. Electrical Diagram



K_0:Power Swith	C:Magnet	K_2:Limit Switch
T:Transformer	FU:Fuse	R1:Relay
EH1 EH2:Heating Pipe	MD:Magnet Driver	SJ:Digital Controller

IX. Exploded Diagram



No.	Part Name	Qty
1	Machine Frame	1
2	Electric Case	1
3	Power Cord	1
4	Fuse Holder	1
5	Heating Plate Socket	1
6	Electrical Parts Bracket	1
7	Power Switch	1
8	Limit Switch	1
9	Connecting Piece	2
10	Electromagnet Suck Plate	1

11	Davit Arm	1
12	Electromagnet	1
13	Flat Heat Platen Cover	1
14	Cap Heater Cover	1
15	Flat Heat Platen	1
16	Cap Heater	1
17	Electromagnet	1
18	Hat Rack	1
19	Pressure Adjust Gear	1
20	Gas Spring	1