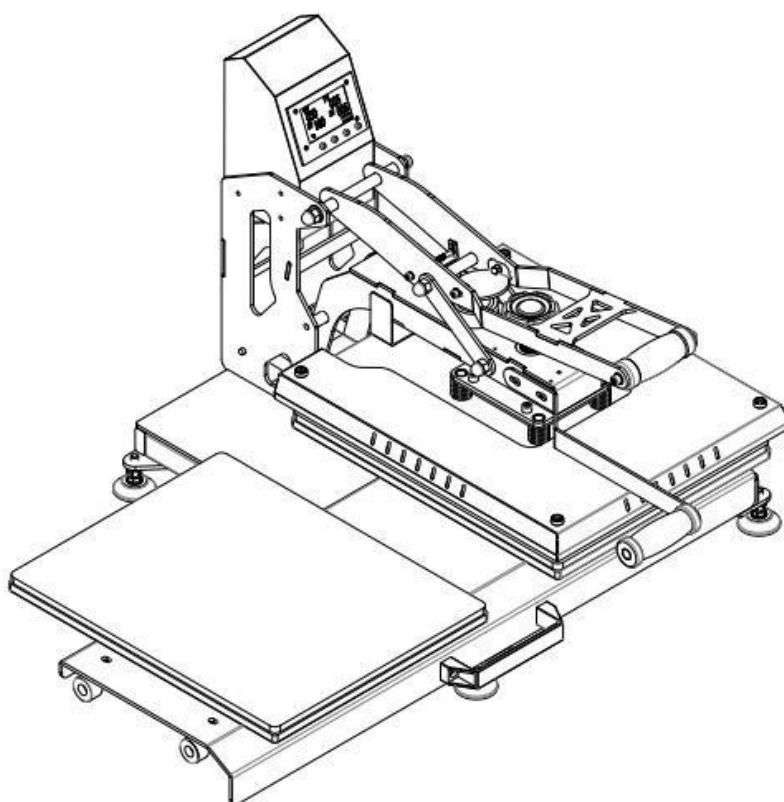


TC Auto Open Heat Press with Double Stations Manual

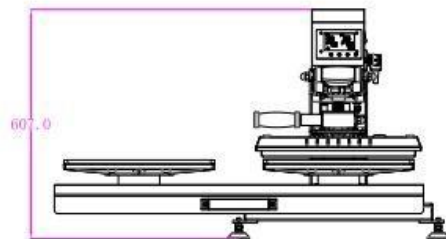
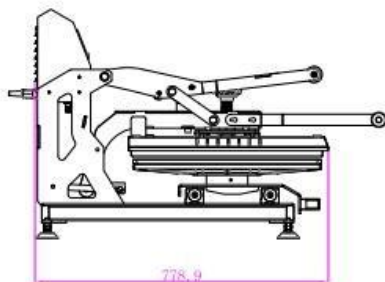
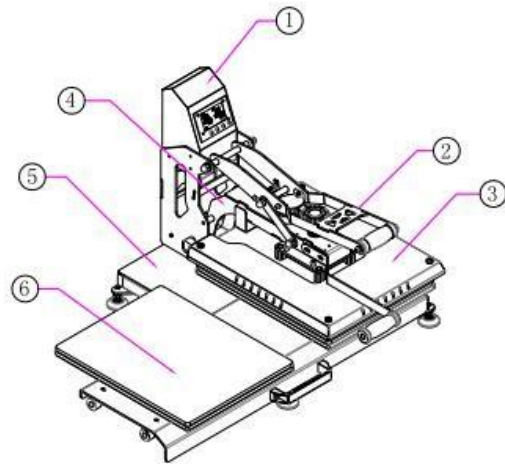
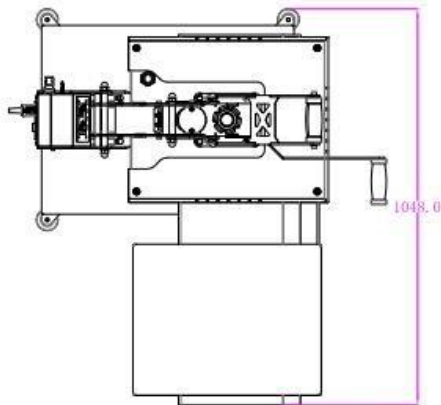
Model No: TC-15/20A



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1. Assembly Drawing



1. Electrical Case
2. Handle
3. Heat platen
4. Crane
5. Base
6. Exchangeable heat platen




2. Technical parameters

1. **Model No.** TC-20A
2. **Machine Size:** 1084*778.9*607mm
3. **Print Articles Max Size:** 400*500*10mm
4. **Voltage:** 220v/1st Phase or 120v/1st Phase
5. **Power:** 1.8kw
6. **Recommended Settings:**
 - Time Range: 0~999s
 - Time: 30~280s; Temperature 180~210°C





3. Operation Process

1. Setting Required Temperature







<p>Turn on machine via power switch, when the temperature light is ON. The digital display shows as above.</p>	<p>Press  button, the focused measurement is on (C denotes Celsius). Press arrows “△” or “▽” to select “°C” or “F” (F denotes Fahrenheit) according to your desired unit. Press  again after choosing the correct reading.</p>	<p>After setting your reading, press the  button, when the temp light is on. Select using the arrows, the temperature according to different transfer material used (Normally 180°C~200°C) SV: Set temperature PV: Current temperature</p>
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2. Setting Required Time

	
<p>Press  button after temperature setting and the time light is on. Use the arrows to select the required time according to different transfer material. SV: Set temperature PV: Current temperature</p>	<p>Press the  button to return to operating mode. Counter is the number of transfer cycles performed, you can reset this value by pressing and holding the “Reset” button for 5 seconds.</p>

3. Temperature offset calibration and Heat safety Settings

- P – 1 Denotes the Temperature offset.
- P – 2 Denotes the Heat Safety Setting.

 <p>The image shows a digital controller with a black display. The top line of the display shows 'P-1' in blue and '170' in blue. The bottom line shows '001' in green. Below the display are four buttons: an up arrow, 'OK', a down arrow, and 'Reset'.</p>	 <p>The image shows a digital controller with a black display. The top line of the display shows 'P-2' in blue. The bottom line shows '003' in green. Below the display are four buttons: an up arrow, 'OK', a down arrow, and 'Reset'.</p>
<p>When there is temperature difference between SV (current heating temperature shows on the display screen) and actual temperature of heat platen (measured via temperature gun), please press and hold the  for 5 seconds to access the P-1 attribute. This is the offset to calibrate the display temperature correctly.</p> <p>For example: When set 200°C, during the heating process, if you find the current heating temperature display shows is 180°C, but the measured actual temperature of heat platen is 170 °C, then please enter into the P-1 attribute and press arrows “▽” to decrease by 10°C(this adjusts the display to match the actual temperature).</p> <p>Then after adjusting the value, the display will be showing the correct value 170°C which is successfully calibrated. The machine can still heat up to a maximum of 200°C.</p>	<p>The machine is already pre-set to 003 before shipment.</p> <p>This setting is there as a safety measure, if your setting temperature is 200°C, it will slow down the heating speed when it heats up to 197°C.</p> <p>The suggested value of the P-2 setting is 3~5° C. If you want to change this setting, press and hold the  button for 5 seconds to move to P-1 attribute, and then press button again to enter into the P-2 attribute, you can then press arrows “△” or “▽” to set the value you require.</p>

4. Printing Guidance

Please note that these instructions are a rough guide to getting you started with the press. These values may need to be changed for you to receive the required production quality results.

Step 1: Make sure the cord is connected well to the wall socket. Place the object (i.e. T-shirt) on press bed, and transfer paper with images facing down the object, adjust pressure using the handle at the top of the heat plate to your requirement, and start the machine.

Step 2: Set the temperature and time required.

Step 3: When the temperature rises to the setting temperature, the buzzer will sound; you can then close down heat platen (the buzzer sound will stop) and begin the transfer.

Step 4: The timer will be active during the transfer, once the transfer time is up, the upper heat platen will auto open and swing away to another side automatically.

Step 5: Consult the Transfer Paper instructions on whether to peel cold or hot, here are suggested Pressing time guidelines for different transfer paper (*Rough values*).

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

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 unused for more than 30 minutes.

The heat-releasing fan will automatically start when the temperature of heat platen reaches 80 degrees centigrade (176 degrees Fahrenheit). 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 210 degrees centigrade (410 degrees Fahrenheit).
- 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.

5. 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 connect well, this is showing that the transformer is faulty.

2. The display screen is working well, but there is no temperature increase on the heat platen.

- 1). Check whether the thermocouple of the heat platen is connected well. If the thermocouple is loose, the display will show 255 and as a result the 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 heat 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°C.

- 1). Check whether the thermocouple of the heat platen is connected well.
- 2). If the thermocouple is connected well but still the display still shows 255°C, then it is faulty.

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

- 1). Check whether the thermocouple of the heat platen is connected well.
- 2). If the thermocouple is good, it shows that the program of digital controller is broken, which namely IC or is broken, this needs to be corrected by changing to a new controller.

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

- 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 lubricating oil regularly to the joints.
- 2). Please turn of the power when changing the spare parts. And reset the time and temperature on the digital controller GY-06 after the replacement.
- 3). In order to keep the heat platen's good transfer effect, please keep the spare parts well after the replacement and avoid any damage for the heat platen.
- 4). Please store the machine in a dry place.
- 5). If you are not able to solve the electrical parts problem, please kindly contact **support@ukcutter.co.uk**.

6. Troubleshooting Print Transfer Quality

1. If the time/temperature setting is not correct after exchanging the heat platen: reset the time and temperature according to the manual.
2. If the print colour is faded: increase the time for transfer/ raise the setting temperature.
3. If the print colour is too brown or the transfer paper is almost burnt: reduce the setting temperature.
4. If print colour is different/partial transfer effect is not good enough: adjust the temperature for heat platen accordingly.

If any electrical parts problems are found during the operation, please kindly contact support@ukcutter.co.uk.