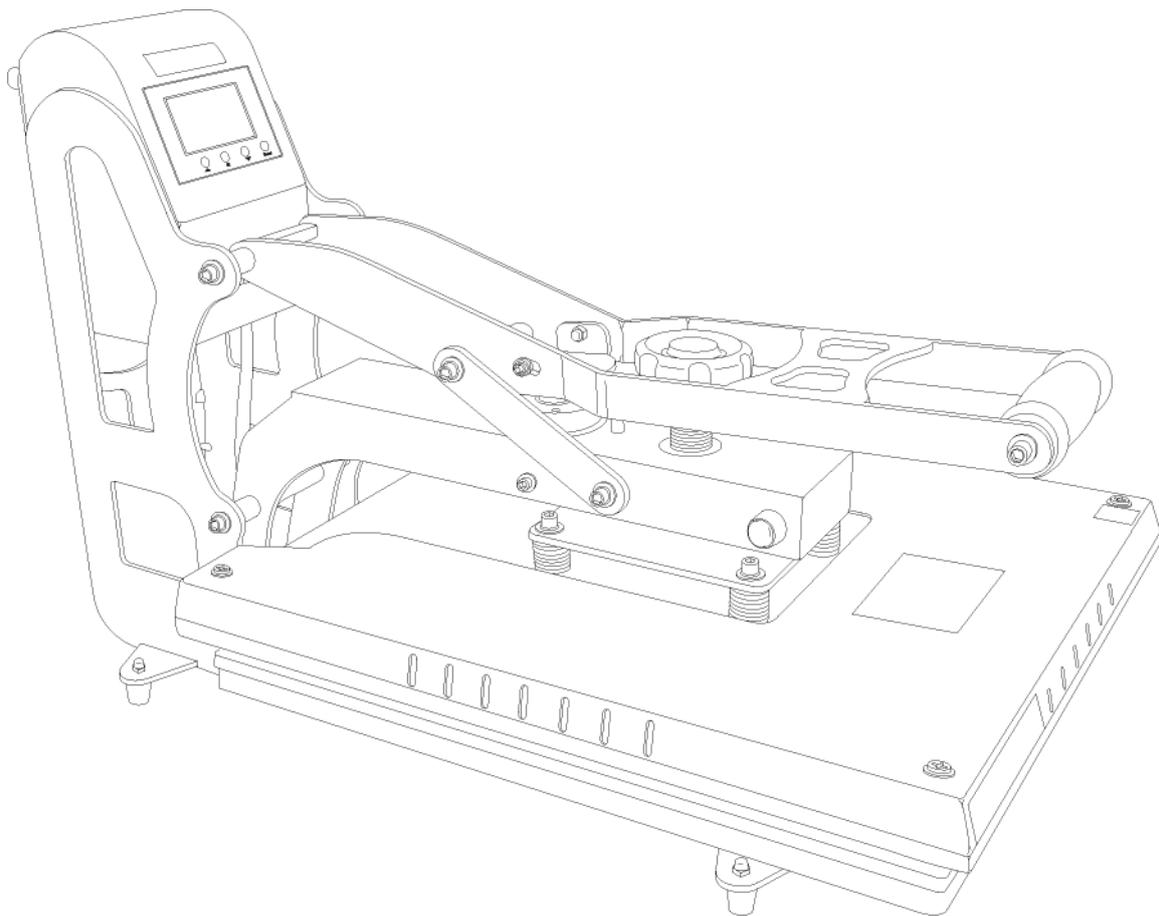




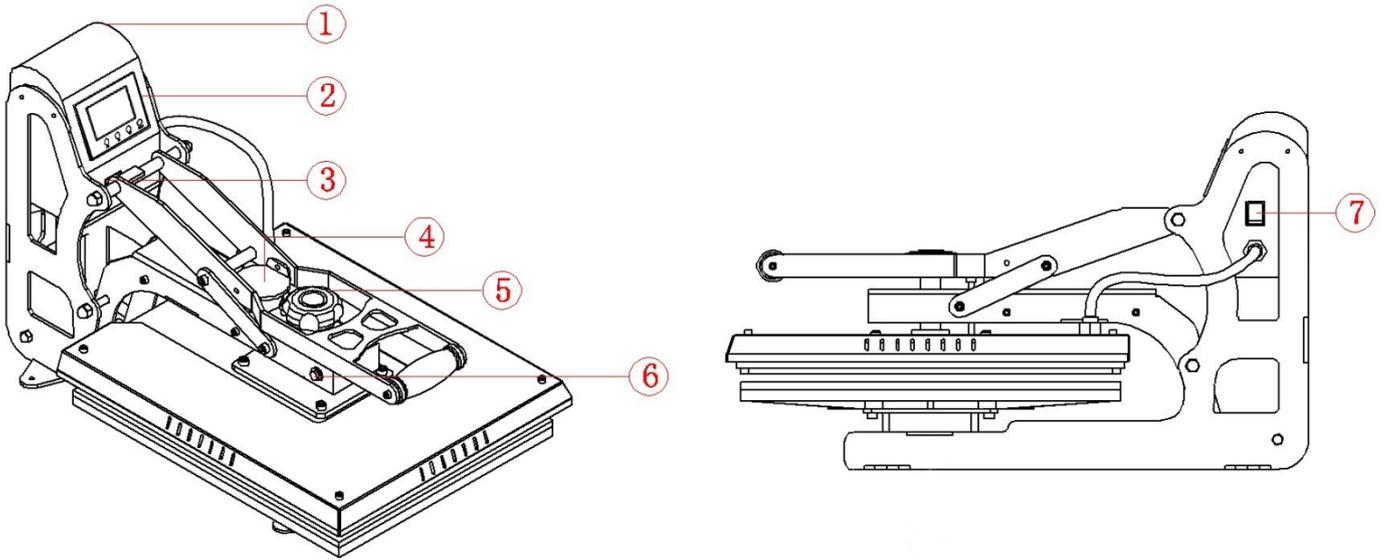
# Master Auto Clam Heat Press Model Nos.: HPD.PACL38 & HPD.PACL50



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# I. ASSEMBLY DRAWING



- ① Electronic Case      ② GY-06 Digital Controller      ③ Magnetic Switch      ④ Electromagnetic Contact Plate
- ⑤ Pressure Adjust Knob      ⑥ Emergency Stop Button      ⑦ Rocker Switch

# II. Technical Parameters

- 1. Model Nos.: HPD.PACL38 & HPD.PACL50
- 2. Machine Size: 748x480x410mm
- 3. Heat platen Size: 205x255x100mm/Size: 155x255x100mm/Size:  $\Phi$  18x10mm
- 4. Printable Articles Max Size: 400x500x10mm
- 5. Voltage: 220v/1Phase
- 6. Power: 1.8kw - Heating element power: 1.8kw (x1)
- 7. Recommend Setting: 30~280s; 180~200°C  
Time Range: 0~999s  
Maximum Temp: 225°C.
- 8. Packing Size: 850x550x500mm
- 9. Gross Weight: 51.5Kg (HPD.PACL50) & 44Kg (HPD.PACL38)

### III. Operating Process

#### 1. Set temperature required

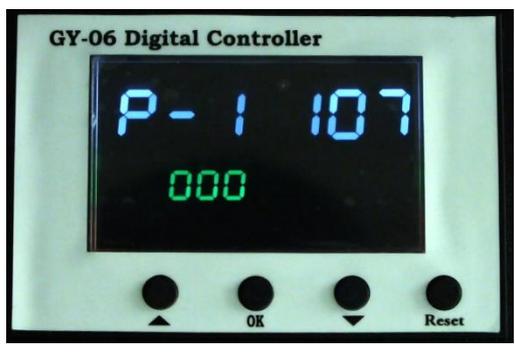
		
<p>Turn on power switch, temperature light is ON. The digital display shows as above.</p>	<p>Press  button, the  light is on (C denotes Celsius). Press arrows “△” or “▽” to select “°C” or “°F” (F denotes Fahrenheit) according to your habits.</p>	<p>Press  button, the temp  light is on. With the arrows select the temperature according to your particular transfer material (Normally 180°C~200°C) SV: Set temperature PV: Current temperature</p>

#### 2. Set time required

	
<p>Press  button after temperature setting and the time light is on. Using the arrows select the time according to different transfer material. SV: Set temperature PV: Current temperature</p>	<p>Press  button to enter operating mode. The counter denotes the number of “transfer cycles”, with a range of 0~999. To reset the counter to “0” press “Reset” for 5 seconds“.</p>

**NOTE: Please do as follow:**

- 1) When the SV and PV values show a big difference [see below]
- 2) When the temperature shown on the display is not the same as the actual temperature on the heat platen [see below]

 The image shows a GY-06 Digital Controller with a blue LCD display. The top line of the display shows 'P-2' and the bottom line shows '027'. Below the display are four buttons: an up arrow, 'OK', a down arrow, and 'Reset'.	 The image shows a GY-06 Digital Controller with a blue LCD display. The top line of the display shows 'P-1 107' and the bottom line shows '000'. Below the display are four buttons: an up arrow, 'OK', a down arrow, and 'Reset'.
<p>When SV and PV values show a big difference, press  button for 5 seconds, and press  button again to adjust the temperature.</p> <p>If SV &amp; PV values have difference of <math>\pm 20</math> degrees, Press arrows "<math>\Delta</math>" or "<math>\nabla</math>" to set to 20.</p>	<p>When the temperature shown on the display is not the same as the actual temperature on the heat platen, press  button for 5 seconds to reset mode:</p> <p>① E.g. if the display shows 200°C, and the actual heat platen temperature is 170°C, Press arrows "<math>\Delta</math>" or "<math>\nabla</math>" to set to 30.</p> <p>② Or similarly if the display shows 200°C, and the actual heat platen temperature is 230°C, Press arrows "<math>\Delta</math>" or "<math>\nabla</math>" to set to -30.</p>

### 3. Printing methods

- Step 1:** Make sure the cord is connected well to the wall socket. Place the object (i.e. T-shirt) on the press bed, then put transfer paper with image facing down onto the object. Adjust the pressure to your requirement, and turn on the power.
- 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 lower the heat platen (in the meantime the buzzer will stop). This starts the transfer cycle.
- Step 4:** Then the time counter is on, once time is up, open up the upper heat platen.
- Step 5:** Consult the Transfer Paper instructions on whether to peel cold or hot. Here are suggested Pressing time guidelines for different transfer papers:
- Ink-Jet Transfer Paper (fabric) 14-18 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°C.
- Set time: 15 seconds.

2) T-shirt transfer:

- Set temperature: 180°C.
- Set time: (chemical fibre use for sublimation transfer paper: 30-50 seconds; pure cotton use for T-shirt transfer paper: 10-20 seconds).

3) Aluminium sheet transfer:

- Set temperature: 180°C.
- Set Time: 45 seconds.

**Step 6:** When the temperature rises to the set temperature, the buzzer sends out a sound; then close down heat platen (meantime the sounds stop) and starts to transfer.

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

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

### PLEASE NOTE:

1) 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 the heat press stays unused for more than 30 minutes.

3) The heat-releasing fan will automatically start when the temperature of heat platen reaches 80°C (176°F). It helps to reduce the temperature of electrical parts and prolong their service life.

4) For better maintenance of your heat press the maximum setting temperature is 210°C (410°F).

5) To avoid re-heating the first transfer when printing double sided T-Shirts, insert a sheet of cardboard inside the T-shirt; Remember to adjust the height to less pressure before you press.

6) Heat platen may pivot slightly back and forth rotationally. This is normal and is due to the movement allowance within the assembled clamp.

## IV. 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 heat platen 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 heat platen will still not heat up, then check to see if the heat platen is faulty or the heat platen's power cable is loose, you may need a new heat platen.

### **3. The heat platen 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 heat platen 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 heat platen.**

- 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 heat platen whenever the machine is not in use. This will prolong the life of the platen and help to keep the image quality of your work high.
- 3). The machine should be stored in a dry place.
- 4). If you are not able to solve your problem, please contact [heatpressesdirect.com](http://heatpressesdirect.com) for technical support.

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

- Electrical connections
- Mechanical moving parts

## **V. 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 object after transfer: the temperature is set too high/ or poor quality printing ink.

## VI. 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**).

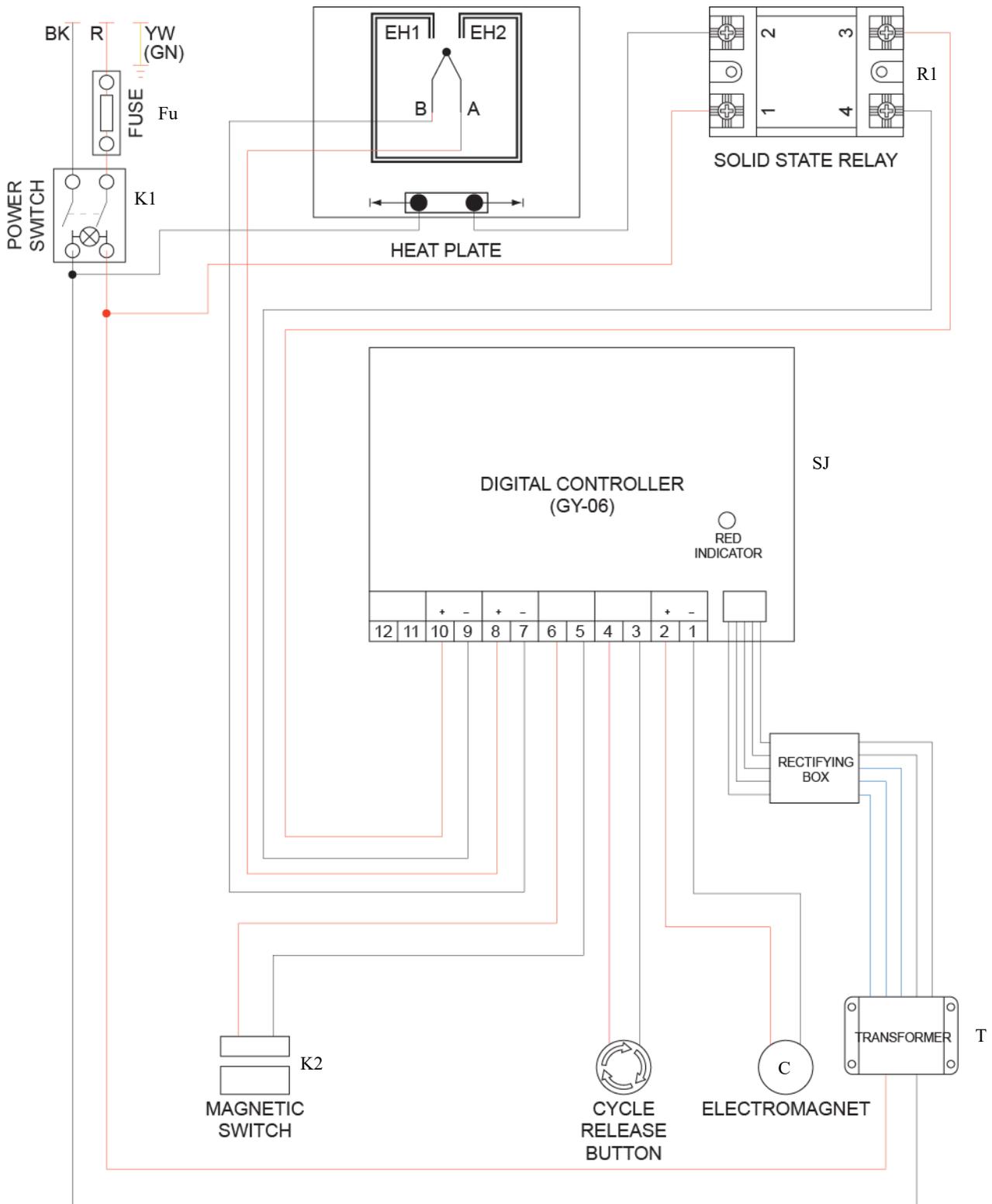


**\*Please Note:**

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.

# VII. Electrical Diagram



K1.: Power switch

C: Electromagnet

K2: Magnetic Switch

T: Transformer

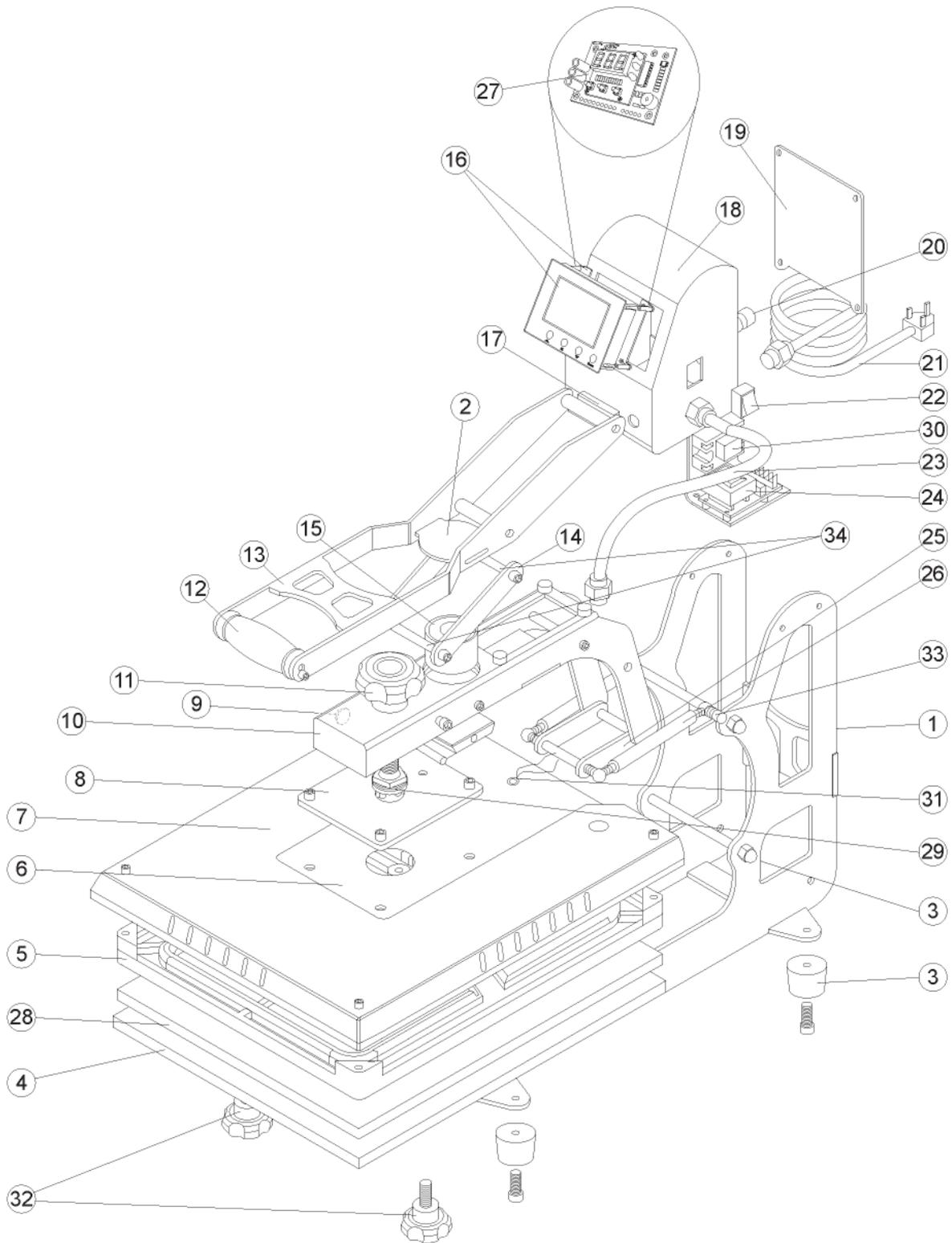
FU: Fuse

R1: Solid State Relay

EH1 EH2: Heating Pipe

SJ: Digital Controller

# VIII. Exploded Diagram



<b>No.</b>	<b>Part Description</b>	<b>Qty.</b>	<b>Part No.</b>
1	Machine Frame	1	STEZA/1
2	Electromagnetic Contact Plate	1	STEZA/2
3	Feet	4	STEZA/3
4	Table	1	STEZA/4
5	Heat Platen	1	STEZA/5
6	Insulation Cover	1	STEZA/6
7	Anti-scald Protect Cover	1	STEZA/7
8	Adapter Plate	1	STEZA/8
9	Emergency Stop Button	1	STEZA/9
10	Arm	1	STEZA/10
11	Pressure Adjust Knob	1	STEZA/11
12	Handle Grip	1	STEZA/12
13	Handle	1	STEZA/13
14	Handle Connecting Piece	2	STEZA/14
15	Electromagnet	1	STEZA/15
16	Controller Housing (2 Part)	1	OMC750/8
17	Magnetic Switch	1	STEZA/17
18	Electronic Case	1	STEZA/18
19	Back Plate of Electronic Case	1	STEZA/19
20	Circuit Breaker	1	STEZA/20
21	Power Cord	1	STEZA/21
22	Rocker Switch	1	STEZA/22
23	Metal Conduit Cable	2	STEZA/23
24	Transformer	1	OMC750/29
25	Gas Spring Fitting Bracket	1	STEZA/25
26	Gas Springs	2	STEZA/26
27	Digital Controller - GY-06 (2 Part)	1	OMC750/35
28	Silicone Pad	1	STEZA/29
29	Pressure Adjust Assembly	1	STEZA/30
30	Solid State Relay	1	ACL50/SSR
31	Ring Probe	1	FP3057/5
32	M10 Star Knob	2	STEZA/32
33	Top Axel Pin	1	STEZA/33
34	Toggle Pin	2	STEZA/34