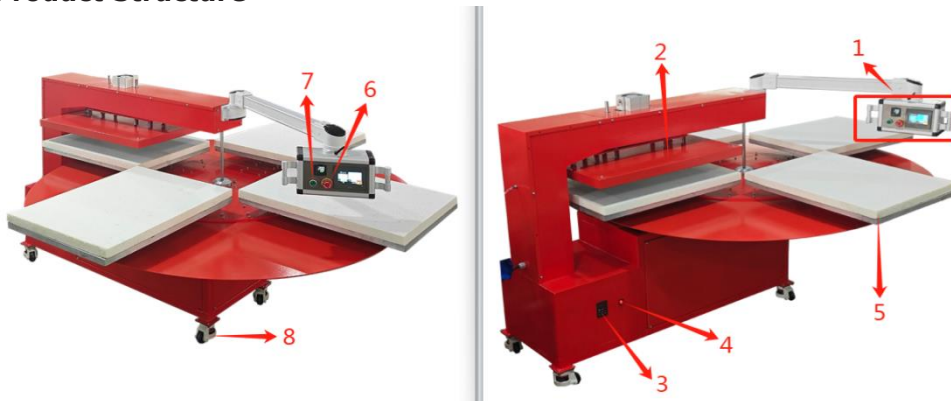# AIDARY

User manual
Heat Press Machine

AP2319

Introduction

A heat press machine is using temperature and pressure with a certain amount of time to transfer images on items, the transfer is permanently embedded into the product.

Package Contents

1 × Heat Press Machine
1 × User Manual

Product Structure

1. Control system	5. Bottom platen
2. Heat platen	6. Emergency button
3. Speed governor	7. Start button
4. Power switch	8. Movable wheel

1.Printing Methods

1. Make sure the power cord is well connected to the circuit breaker, then press the power switch to turn on.
2. Hook up to air compressor (The diameter of the air hose is 8mm)
3. Set the temperature and the time you need.(See the temp&time setting sheet)
4. The buzzer will sound when the temperature reaches the setting temperature, place the object (e.g T-shirt) on the bottom platens, and let the transfer paper upon the object.
5. Operate the controller and starts to transfer.
6. The heat platen will lift up automatically when the scheduled time is up, then the transfer work is finished.
7. If meet some emergent situation, press the emergency button, the plate will lift up immediately.
8. How to use speed governor

Default setting, Don't press

Speed knob

Use speed knob to adjust the moving speed of the bottom platens**(Do not make it higher than 25.00)**

Other keys are default setting, don't press them to change any settings please!

2.Recommended Setting for the Object

SURFACE	PRESS TIME	TEMPERATURE	PRESSURE	TIPS
Fiber/Fabric/Polyster material	35-40 seconds	180°C(400 F)	40 PSI (Medium)	With sublimation paper
Pure cotton material	20-25 seconds	165°C-170°C	40 PSI (Medium)	With transfer paper
Mouse pad	25-30 seconds	180°C(400 F)	40 PSI (Medium)	With sublimation paper
Metal card /Aluminium card	20-25 seconds	180°C(400 F)	40 PSI (Medium)	With sublimation paper
These are approximate datas FYI				

3.Maintain Note:

1. Different item will require different temperature and time setting because the materials or thickness is different.
2. This machine is not suitable for children to use or for food processing.
3. Please turn off the machine and unplug the power cord when the machine is not in use.
4. The heat plate will automatically cool down to the room temperature if the heat press stays non-use for more than 30 minutes.
5. The heat-releasing fan will automatically starts when the temperature of heat plate reaches 80 °C (176 °F). It helps to reduce the temperature of electrical parts and prolong the service life of them

4.Troubleshooting:

No action after turn on the machine.
1. Check the plug whether it connects well or whether it is broken.
2. Check the fuse whether it has been burnt out.
3. Check the power switch or digital controller whether it is broken.

Indicating light is on but the display screen is black.
Check the 5 cable of railway transformer. The connection is poor if it is loose, just fix it. The transformer may be faulty if the cable is well connected just fix it.

The display screen is working well but the temperature is not heating up.
1. Check if the indicating light of solid-state relay is on, if not, please check whether the relay or digital controller is broken.
2. The heat platen still can't heating up if you already changed the new solid-state relay, please check whether the heat plate is faulty or the heat plate's power cable is loose, if so,it will need to change a new heat plate.

The temperature is out of control: Set temperature 180°C (356°F)，but the actual temperature

is above 200°C (392°F)

1. It means the solid-state relay is broken, out of control, need to change a new relay.
2. Or the digital controller is faulty, need to change controller.

The print color is pale or faded image
The pressure is not high enough or The temperature is too low / pressing time is too short.
Please adjust the pressure/ temperature or increase the heating time.

The print color is too Darkened, deep or blurred image
The temperature is too high / or pressing time is too long.
Please adjust the temperature or reduce the heating time.

The print color is different/ partial transfer effect is not good enough
Pressing time is too short/ using poor quality transfer paper.
Please increase the heating time or use high quality transfer paper.

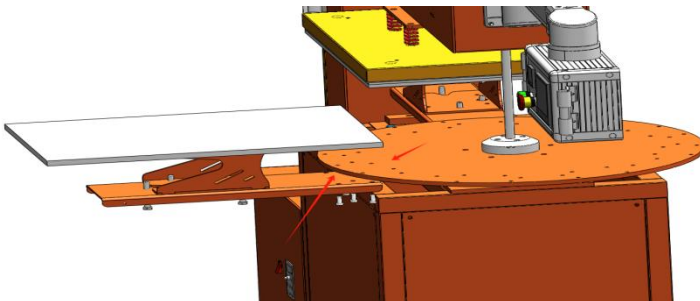**The transfer paper stick to the object after transfer**
The temperature is too high / use poor quality printing transfer
paper Please adjust the temperature or use high quality transfer
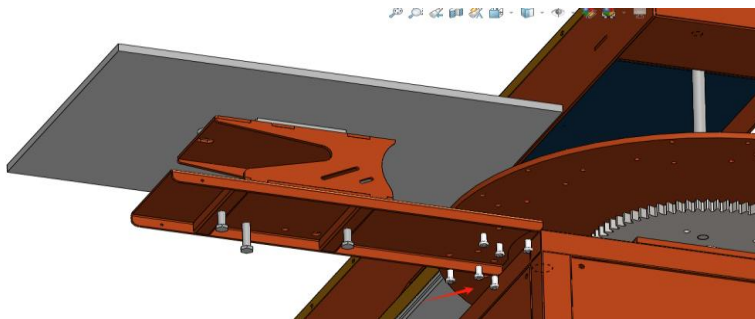paper.

Installation Instruction
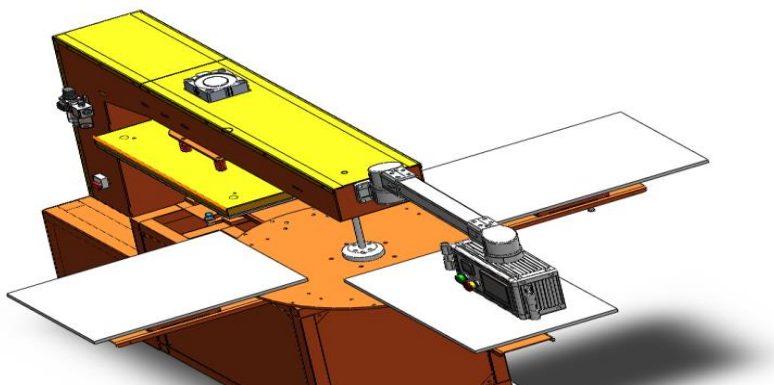
Step 1: Install the bottom platen
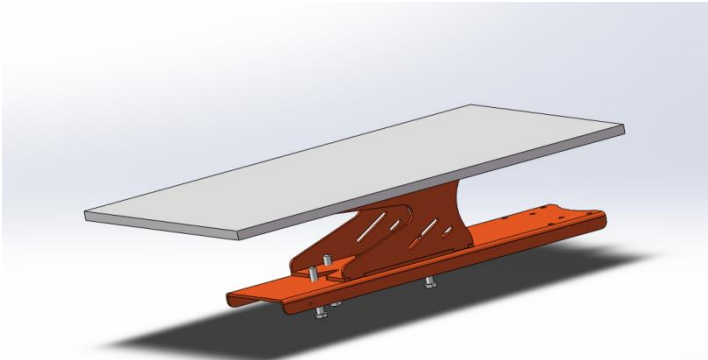
Align the holes position
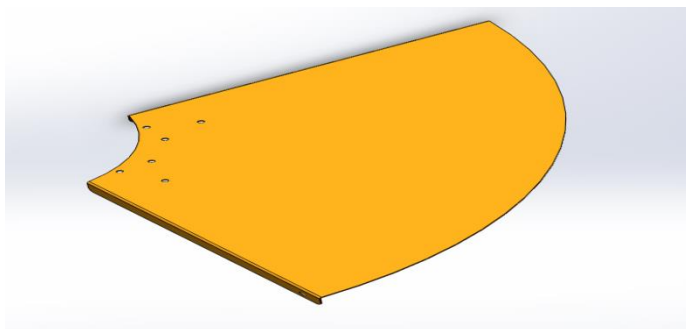
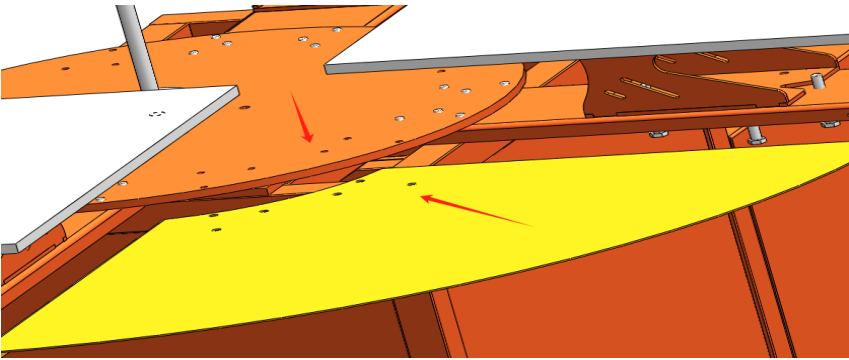Use M8*16 hexagon screws to lock from the bottom up.

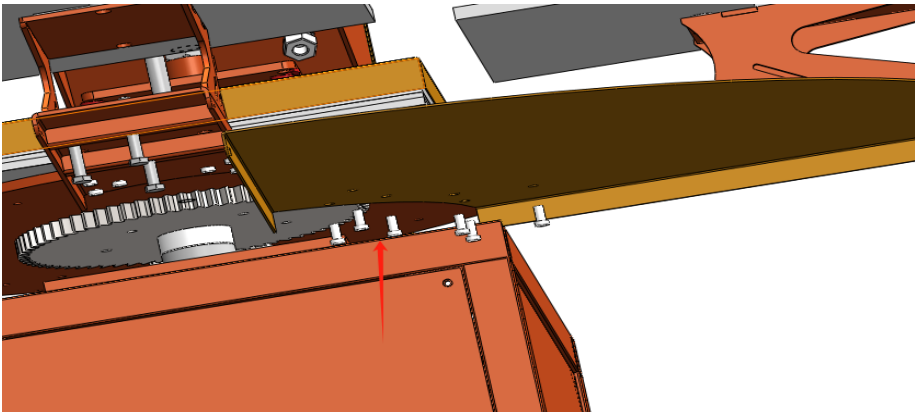Follow the steps above to install the remaining two bottom platens in turn.

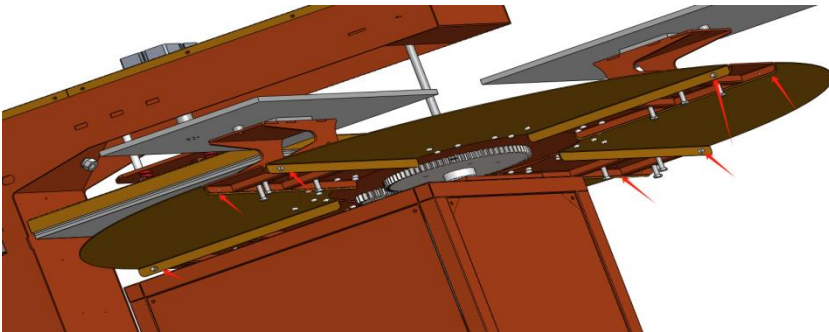Step 2: Install the fan-shaped iron plate

Align the holes position

Use M8*16 hexagon screws to lock from the bottom up.

Follow the steps above to install the remaining two bottom platens in turn.

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