Digital Cap Heat Press Machine

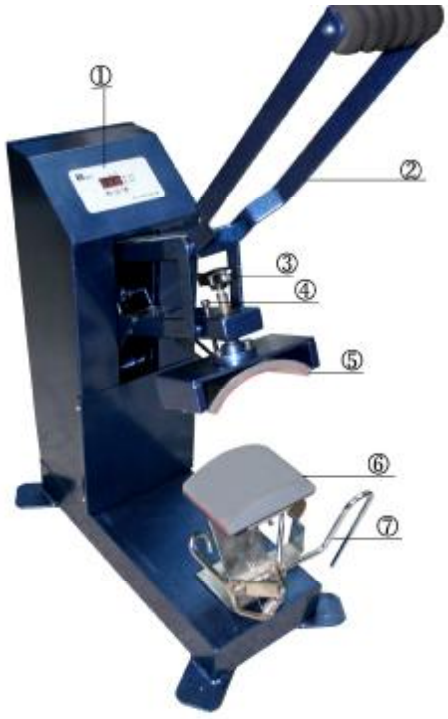
Instruction

Summarize：

The machine can transfer the colorful images and words with the sublimation and impregnant ink into Caps.

Applied Material:

The cap is made of cotton, hemp or fiber.



①：Control Panel

②：Handle Bar Grip

③: Handwheel for lift and fall

④：Pressure Knob

⑤：Heat Plate

⑥：Silicon heater

⑦：Clips

Start up

First of all, we should distinguish the material of the Clothing; for different clothing, we have different printing methods. There are two kind of methods: (1) For 75%-100% cotton T-shirt, you can use **sublimation ink** printing onto **T-shirt transfer paper**; Temperature: 180℃ Time：15-30S.
(2) Another way is to use **Pigment ink** (or **Sublimation ink**) printing onto **Inkjet transfer paper,** In this way, you can transfer images onto silk, fiber, terylene etc material ， temperature: 180℃ Time：80-120S.

Operation Process:

Step 1: Preparation:

A. Sublimation ink and sublimation transfer paper, which is suitable for cap material.

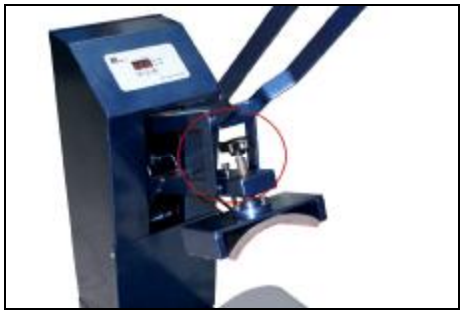
B. Determine the side of the paper your printer images to.

C. Mirror the image in your computer software.

Print the images out

Cut out the picture for transferring, Trim the side of picture

Prepare the cap for transferring



Circumvolve the handwheel or the nut to adjust the pressure

Clip the cap into the silicon heater and flat the cap

Place the transfer ink side down onto the cap

Step 2: Set the Control Panel

Turn on the power switch

Temperature light-ON

Select with arrows temperature required, (Normally 180℃)

Left arrow select Up.

Right arrow select Down

Press **OK** button after temperature set
now timer light-ON

Select with arrows time required,
(**normally: 120 seconds)**

Press **OK** button again,
The program will stay in memory of
the control board and
the temperature starts to rise

Step 3: Transferring

Once the temperature rise to the required180℃
the buzzer will send out a short sound

Close the handle of the press
and press **OK** button

Now time is counting down

Step 4: Finish the transfer

When the time reaches to the set point,
the buzzer sing again. Open the press.

Tear paper backing slightly
(Note: if it is heat transfer paper, pls do that as soon as possible, and if it is cool transfer paper, pls brushing the transfer paper by scrubbing brush, after 5-10 seconds, then take out the paper.)

Beautiful pictures have been
transferring to the cap

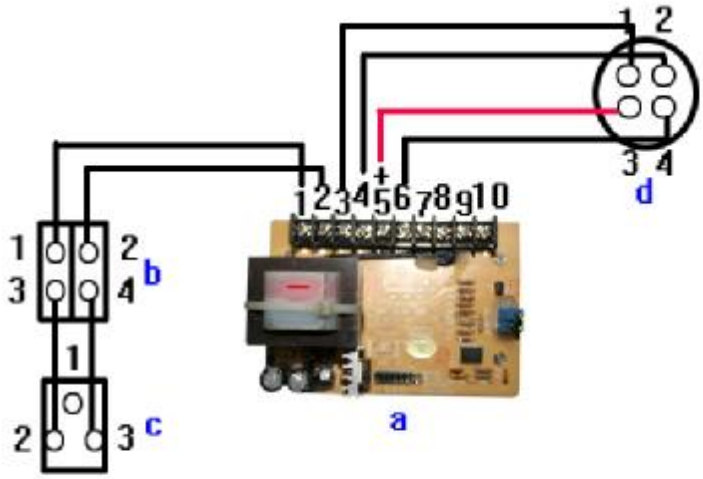
Technical Specification

Voltage：110/220V
Power ： 130W
Temperature Range ： 0-250℃
Time Range ： 0-3 minutes
Packing box: 71CM*65CM*32CM
Gross weight: 19.10kg

Trouble shooting for transfer quality:

A. If the color is pale: the temperature is too low / the pressure is not correct / or not pressed long enough.
B. If the picture is blurring: Too much tranfer time causes proliferation.
C. If a part of picture is blurring: Heat was not distributed correctly through heat plate. Allow more time between press operations. Pressure distribution can also be the cause, which can be set on the four plate surface adjusters. Please note that it has been factory set and there should be no need to adjust them
D. If the pattern is scarred: Transfer time is too long.
E. The pattern of color is different: the pressure is not correct or the transfer paper is poor quality
F. Adhesive paper: the temperature is too high or poor printing ink

Circuit Diagram:



a：PCB

b：Switch

c：Power supply socket

d: Aerial Plug

PCB Definition：

1，2 Electrical source tie-in；

3，4 Radiation pipe tie-in;

5，6 Sensor tie-in;

7，8 Relay output tie-in;

9，10 Relay input tie-in

Maintenance:

Ⅰ. No action after switch on the power

1. Check the plug whether it touchs well
2. Check the fuse whether it have been burn out.
3. Check the lead wire of the switch whether it have been fallen

Ⅱ. The display screen are working well, but the no temperature increasing on the Silica Gel Board

1. Check whether the tie-in of the Silica Gel touches well.
2. Check the 3,4 on PCB in the back box whether it touches well.

Ⅲ. The display screen is un-normal, but the Silica Gel heats.

Maybe for the fault of the PCB

Ⅳ. The display screen and Silica Gel works well, but un-normal show of the temperature.

1. Check whether the tie-in of the Silica Gel touches well.
2. Check the 5, 6 on PCB in the back box whether it touches well.

Advise: 1. Because the material and the thickness of the clothing are different, the temperature and the time are different too.

2. The temperature and the time are only for reference. And pls first try a sample to adjust the best temperature and time.
3. The best setting temperature are 180℃, pls do not over 220℃, and the transferring time should be within 3 minutes.
4. To make sure that the circuit can bear high-power machine, or it will bring about faulty of the fuse etc.