



## **OPERATING MANUAL**

**for the TB7 Thermobase**

**40cm x 50cm**

Congratulations on purchasing your Secabo product!

Please read these operating instructions carefully so that you can start production smoothly with your device.

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Secabo GmbH accepts no liability for any direct or indirect damage resulting from the use of this product.

*Version 1.0 (11.12.2019)*

# Short overview

## Secabo Thermobase TB7 40cm x 50cm

- Heated bottom plate as extension for your 40cm x 50cm Secabo models like TC7 SMART, TS7 SMART, TPD7 and TPD7 PREMIUM.
- Better print results, especially with sublimation and white toner transfers.
- Particularly suitable for sensitive textiles
- The temperature of the TB7 is controlled by its own Secabo controller.
- Simple mounting, also on quick exchange system and slide extension
- Heats quickly up to a temperature of 160 °C

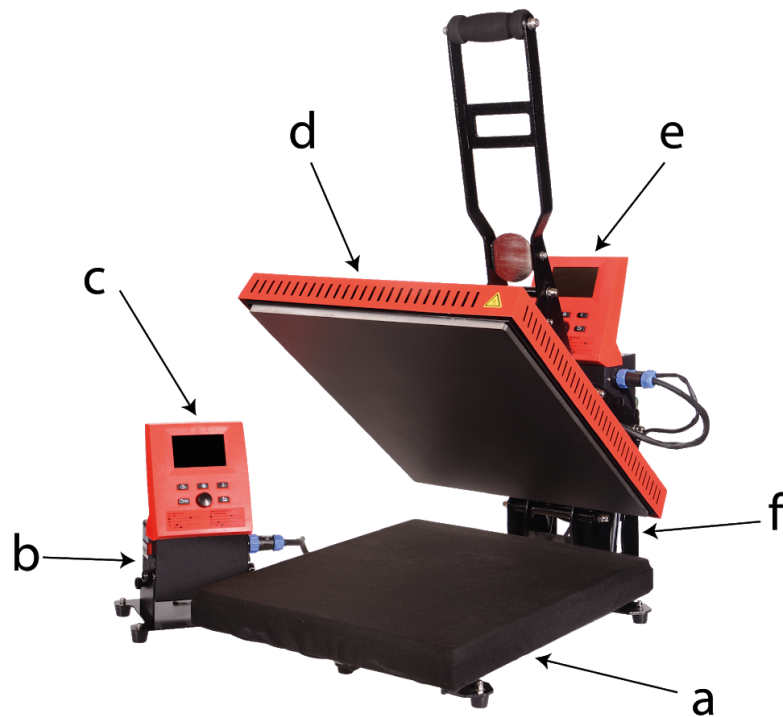
## Safety Precautions

Please read the information and safety precautions carefully prior to first commissioning of the device!

- Never touch the heating plate with your hands when it is connected to the power supply, especially when it is switched on and heated - danger of burns!
- When replacing the standard base plate, make sure that the TB7 is no longer connected to the power supply and that the TB7 has cooled down completely - risk of burns!
- Never open the TB7 and the corresponding controller and do not make any changes to both components yourself.
- Should it be necessary to open the heat plate cover upon explicit request by Secabo's customer service team, it is recommended you wear respiratory protection and only touch the insulation wool located therein using gloves. Possible disposal of the insulation wool should only be done inside a closed bag
- Ensure that no liquids or metal objects get inside the TB7 and the controller.
- Ensure that the outlet used is earthed. Please note that the TB7 may only be operated at a socket which is protected by a residual current circuit breaker.
- Disconnect the TB7 from the mains when not in use.
- Always operate the TB7 out of the reach of children and never leave the switched-on device unattended.
- Make sure that the TB7 is only used in dry rooms.

**If you cannot comply with one or more of the aforementioned safety rules, or if you are unsure as to whether you're in compliance with all of the points, please contact our technical support.**

# Machine description



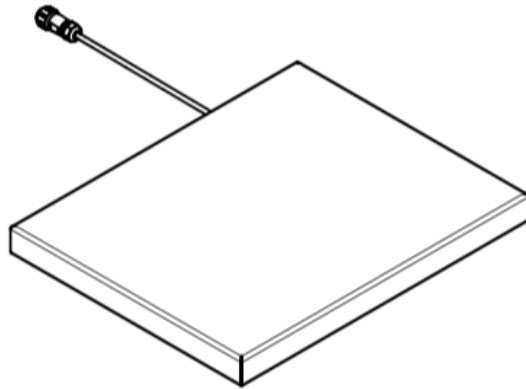
- a. Secabo TB7 Thermobase
- b. table holder
- c. HPC01 Controller Box
- d. HP7 (*not part of the delivery contents, just as an example*)
- e. HPC01 (*not part of the delivery contents, just as an example*)
- f. Secabo TC Smart Base (*not part of the delivery contents, just as an example*)

## Technical data

Brand:	Secabo
Work surface size:	40 x 50 cm
max. temperature:	220°C
Power supply:	Wechselspannung 230V / 50Hz - 60Hz, 2,0kW
Environment:	+5°C - +35°C / 30% - 70% Luftfeuchtigkeit
Dimensions:	41 x 51 x 7 cm
Weight:	13 kg
Weight with packaging:	17 kg

## Items included:

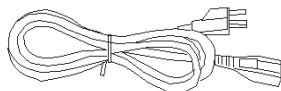
Heating plate with  
silicone mat  
and coating



Controller Box  
with table holder



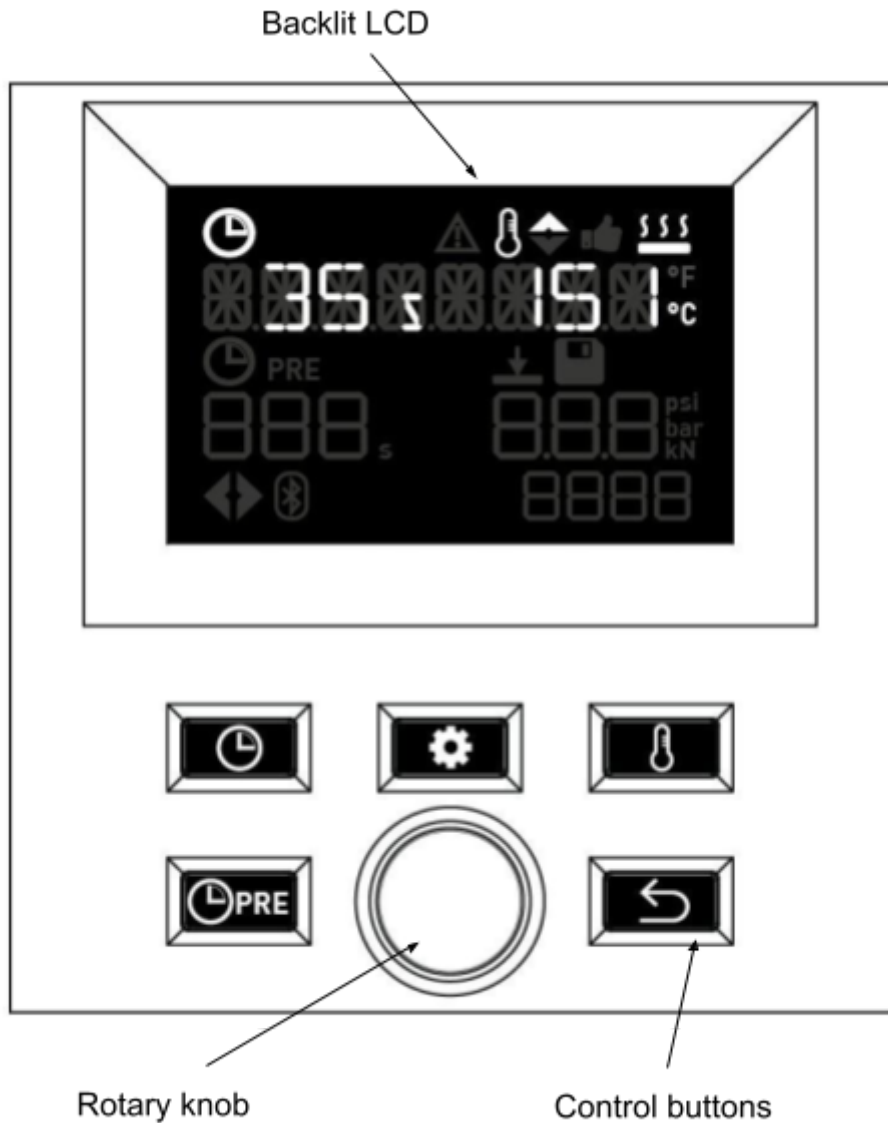
C13 Cold device cable



# Installation and Commissioning of the Secabo TB7 on a Secabo heat press

- Make sure that the Base Frame of the Secabo heat press is on a stable table.
- Remove the base plate of your Secabo heat press in the first step.
- Place the TB7 on the base of the Secabo heat press.
- Fix the TB7 to the base of the Secabo heat press from below using the two screws provided.
- Alternatively, you can also mount the TB7 on the Secabo quick-change system or the Secabo Slide extension.
- Place the table holder for the controller box on a flat surface near the TB7 and mount the controller box in it.
- Attach the large 5-pin plug from the bottom of the TB7 to the matching socket on the outside right of the controller box. (the other small 6-pin socket remains free)
- Plug in the supplied C13 power cord at the rear of the controller box and connect it to a shock-proof socket, which must have a grounded connection, a fuse and an earth leakage circuit breaker.
- **The Secabo Thermobase TB7 is now ready for operation.**

## Controller components and operation



## Display components and their meaning



Area for time setting and countdown when press is closed  
*(irrelevant for the TB7, time is controlled by the heat press)*



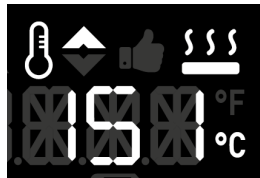
Area for time setting and activity indicator of the pre-press feature  
*(irrelevant for the TB7, time is controlled by the heat press)*



Icon for the Bluetooth connection  
*(irrelevant for the TB7, time is controlled by the heat press)*



General indicator for fault or error



Area for temperature indicator for target temperature and actual temperature



Indicator: Heat plate's heating active



Indicator: Press is done heating up



Indicator: Press is currently heating up or cooling down. If below the set temperature, up arrow will flash.



Indicator for management of memory slots



Counter for counting the performed press operations  
*(irrelevant for the TB7, time is controlled by the heat press)*



## Operation of the controller

### Initial setup on first power-up




When the HPC01 controller is switched on for the first time, the language selection appears first. Select the language suitable for you by turning the rotary control to the desired language and confirm by pressing .

Now select the desired unit for temperature - °C or °F - by turning the rotary control to the desired unit and confirm with pressing .

This initial setup will no longer be displayed when the TB7 is switched on in the future.

To reset the HPC01 controller to factory settings, press the  and  buttons simultaneously for 3 seconds.

### Setting the temperature:

Briefly press , the symbol in the display starts flashing. The value in the display changes from the current ACTUAL value to the TARGET value, which can now be set. Turn clockwise to increase the TARGET temperature, counterclockwise to decrease. Press the rotary knob or press  to **store the** set value. If no input occurs for 5 seconds, input mode ends automatically. Pressing  exits input mode, the set value is not applied and the display returns to the current ACTUAL value.

### Temperature-related indicators:



is activated whenever the heater is running.

During the warm-up phase, every 10s an estimated remaining warm-up time scrolls across the display for 3s instead of the current temperature.



is activated when the CURRENT temperature corresponds with the TARGET temperature, allowing for a certain deviation of X°.



Arrow up is activated when the temperature is rising (if below TARGET temperature, arrow is blinking), arrow down is activated when the temperature is dropping, e.g. during a transfer or if the heat plate is still hotter than the set target temperature.




is generally activated in the event of faults or errors, and when there is a significant deviation between TARGET and CURRENT temperature (value outside of a range that allows for pressing).

### Setting the time (irrelevant for the TB7, time is controlled by the heat press):



push briefly, symbol in the display flashes. Turning the rotary knob clockwise

increases time, counter-clockwise decreases. Press the rotary knob or press  to







store value. If no input occurs for 5 seconds, input mode ends automatically. Pressing



will exit the input mode, the display will return to its original value.


**Configuring pre-pressing:** *(irrelevant for the TB7, time is controlled by the heat press)*


Briefly pressing  activates pre-pressing for the following press operation using the preset time, and is deactivated again upon completing the press operation. When activated, the Time+Pre symbol will light up in the lower part of the display with the corresponding time indicator. This will count down to 0 while pressing, whereupon the symbol and time switched off again.


Holding  activates the setting mode for the PRE time analog with time setting: Symbol in the display flashes. Turning the rotary knob clockwise increases time, counter-clockwise decreases. Press the rotary knob or press  to store value. If no input occurs for 10s, input mode ends automatically. Pressing  will exit the input mode, the display will return to its original value.

Pre-pressing can be activated permanently from the settings menu. More information below.

**Saving to and loading from memory slots:** *(irrelevant for the TB7, time is controlled by the heat press)*

Press and hold rotary knob in the default state.  flashes. The number corresponding with the memory slot is shown below the disk. This indicator rises by one when turning the rotary knob clockwise. Each stored temperature value and time / PRE time value is also displayed at the top. If memory slot is blank, dashes are displayed for temperature and time / PRE time.

To retrieve a stored value, confirm the selected value in the display by briefly pressing the rotary knob. The stored values are now displayed,  is deactivated and no longer flashes.

To save the current values (to blank or currently used memory slots), first push and hold the rotary knob ( flashes), then select the desired memory slot, then hold the knob

until the values and symbols flash briefly. The values are now both, saved and loaded,




no longer flashes, the memory mode has been exited.

### Setting tier:

Press  .

You generally navigate through the setting tiers according to the following scheme:

- Rotate knob - scroll through the settings.
- Press knob - dive into current setting.
- Rotate knob - choose values within the setting.
- Press knob - store value and exit from the setting.
- You may press  to return to the parent tier if no action is to be taken in the subordinate tier.

The following eight menu items are available in the setting tier.

1. Auto Prepress (*irrelevant for the TB7, time is controlled by the heat press*)
  - Enable / Disable a permanent pre-pressing.
2. Bluetooth (*for TB7 please deactivate/ do not use, connection via heat press*)
  - Enable / Disable Bluetooth.
3. Bluetooth PIN (*for TB7 please deactivate/ do not use*)
  - You can use the rotary knob to save your individual PIN, which the app will then prompt you to enter. The default PIN from factory is 255, which is automatically recognized and used by the app.
4. Warning signal (*irrelevant for the TB7, time is controlled by the heat press*)
  - Enable / Disable the warning signal before opening the press.
5. Sleep Mode
  - Setting the time interval in minutes, after which the press enters the Sleep Mode.
  - In addition, the temperature the press should be cooled down to when in Sleep Mode can also be set.
  - To completely disable Sleep Mode, set the time value to "0".
  - The active Sleep Mode can be exited at any time by pressing any button or by actuating the press lever. The press will then restore the previously set parameters.
6. Auto Off
  - Setting the time interval in minutes, after which the press completely turns off the heating.

- To completely disable Auto Off Mode, set the time value to "0".
  - The active Auto Off Mode can be exited at any time by pressing any button or by actuating the press lever. The press will then restore the previously set parameters.
7. Language
- Setting the menu language.
8. Unit
- Configuring the temperature unit. Celsius or Fahrenheit are possible.


**Resetting the counter:** *(irrelevant with TB7, time is controlled by the heat press)*



Press the  button for 2s, display flashes briefly, values are set to 0.

### Second setting tier for operational key figures and service



Press and hold the Settings button  to enter the second tier of the settings. Here you can retrieve helpful data and counter readings by turning the rotary knob.

<b>1</b>	Service Tag
<b>2</b>	Firmware version
<b>3</b>	Serial number of the controller
<b>4</b>	Long-term counter press operations <i>(irrelevant for the TB7, time is controlled by the heat press)</i>
<b>5</b>	Operating hours counter in hours

## Operating the Thermobase

- Switch on the TB7 via the switch on the controller.
- Select the appropriate temperature on the controller.
- Select the correct settings on the heat press.
- Start the pressing process.

**Note: The higher the set contact pressure, the faster and more powerful the press usually opens. Keep the heads.**

## Maintenance and Cleaning

All maintenance work should be carried out with the press switched off and cooled down. The plug must first be removed from the socket. Carry out maintenance work only after consultation with our technical support.

The supplied coating is heat resistant up to 220°C and protects the base plate from discoloration and damage. The cover can be removed from the TB7 and cleaned in the washing machine. After drying it can be put on again and is ready for use. If it is closed, it must be replaced.

## Recommended times and temperatures

These values should only be considered as guideline values, may vary depending on the material and must be checked before pressing.

Material	Temperature	Pressure	Press duration
Flock film	170°C - 185°C 338°F - 365°F	low-medium	25s
Flex film	160°C - 170°C 320°F - 338°F	medium-high	25s
Sublimation flex	180°C - 195°C 356°F - 383°F	medium-high	10s - 35s
Sublimation on tiles	200°C 392°F	high	120s - 480s (depends on the thickness of the material)
Sublimation on puzzles	200°C 392°F	low-medium	25s
Sublimation on mouse pads	200°C 392°F	medium	20s - 40s
Sublimation on garments	200°C 392°F	medium-high	30s - 50s

**Important note: You should perform your own tests with the respective transfer materials and carrier media prior to each production. The aforementioned values, as well as any manufacturer specification merely serve as indications. Washing resistance and behavior during the transfer must be determined by performing your own tests.**

**No guarantee can be derived from the recommended values. It is always the user's responsibility to determine and apply the correct settings for his specific conditions.**

**Note on garment finishing processes: After the press operation, garments must cool off before any carrier media can be pulled off the transfer material. The hot glue in the transfer material doesn't develop its adhesive strength until cooled off. If the glue does not stick in its cold state, this may indicate that the pressing procedure was too cold or too short.**

## Konformitätserklärung - Statement of Conformity

Hiermit erklären wir in alleiniger Verantwortung, dass das unter „Technische Daten“ genannte Produkt mit den Bestimmungen der folgenden EG-Richtlinien und Normen übereinstimmt:



We herewith declare under sole responsibility that the under „technical data“ mentioned product meet the provisions of the following EC Directives and Harmonized Standards:

- EG-Richtlinien / EC Directives:
- 2014/35/FG Niederlassungsrichtlinien
- 2014/35/EC Low Voltage Directive
- 98/37/EG Maschinenrichtlinie (2006/42/EG ab 29.12.2009)
- 98/37/EC Directive on machinery (from 2009-12-29: 2006/42/EC)
  
- Norm / Standard: EN 60204-1:2006

Technische Dokumente bei / Technical documents at:

Secabo GmbH, Hochstatt 6-8, 85283 Wolnzach, Germany

A handwritten signature in black ink, appearing to read 'Fabian Franke'.

Dipl. Ing. Fabian Franke

A handwritten signature in black ink, appearing to read 'Bernhard Schmidt'.

Dipl. Ing.(FH) Bernhard Schmidt