



OPERATING INSTRUCTIONS

for the heat press

Secabo TPD7

Congratulations on purchasing a Secabo heat press!

Please read these operating instructions carefully so you can start production with your press without problems. Reproduction of these operating instructions in any form requires the written approval of Secabo GmbH. We reserve all rights to change technical data and product features. Secabo GmbH does not assume any liability for direct or indirect damage resulting from use of this product.

Version 1.0 (22.04.2013)

Brief overview

Secabo TPD7 pneumatic double sheet transfer press

Using the Secabo TPD7 double sheet transfer press, all common hot transfer processes (flock, flex, sublimation, transfer, InkJet-flex, chromablast etc.) can be conducted professionally and with highest productivity. The desired settings can be set easily with the digital controller for temperature and time. The pneumatic pressure can be regulated smoothly with the manometer. With the restriction valve the speed at which the press is opened and closed can be adjusted. By a bleed air valve the press could be opened in an emergency or a transfer object could be jacked through.

Short overview Secabo TPD7 transfer press

- Pneumatic double sheet transfer press for medium and large batches.
- Fast and simple time and temperature specification, comparison of target and performance values with digital display.
- Flexibly adjustable contact pressure by manometer with oil and water separator.
- Two-hand operation emergency off switch, emergency-stop for pneumatic cylinder with pre-press function.
- Restriction valves for the regulation of lifting and lowering speed.
- CE-certificate, RoHS-certificate, inspected according to German safety standards.

Safety Precautions

Please read these instructions and safety precautions carefully before using your press for the first time!

- Never reach into the heat press with your hands when it is connected to the power supply, particularly when it is switched on and heated up – danger of severe burns!
- Never manipulate the buttons for two-hand operation, the emergency off switch or another component on the transfer press.
- Never open the housing or attempt to modify the machine yourself.
- In case you are requested by the Secabo customer support to open the heating plate cover, please make sure you are wearing respiratory protection and only touch the contained insulation wool with gloves. Any disposal of the wool must be contained in a closed bag.
- Ensure that liquids and metal objects do not get into the inside of the heat press.
- Ensure that the power socket used is grounded. Note that it is only permissible to operate a heat press from a power socket protected by a ground fault protection switch.
- Disconnect machine from power outlet when not in use!
- Never operate the heat press within the reach of children and never leave the machine unsupervised when switched on.
- Ensure that the machine is used only in dry rooms.
- Pay attention that the used compressor is attuned to the air consumption and the pressure

need of the TPD7 in tank volume and maximum pressure. Only use pressure tanks that possess the necessary TÜV-certificates.

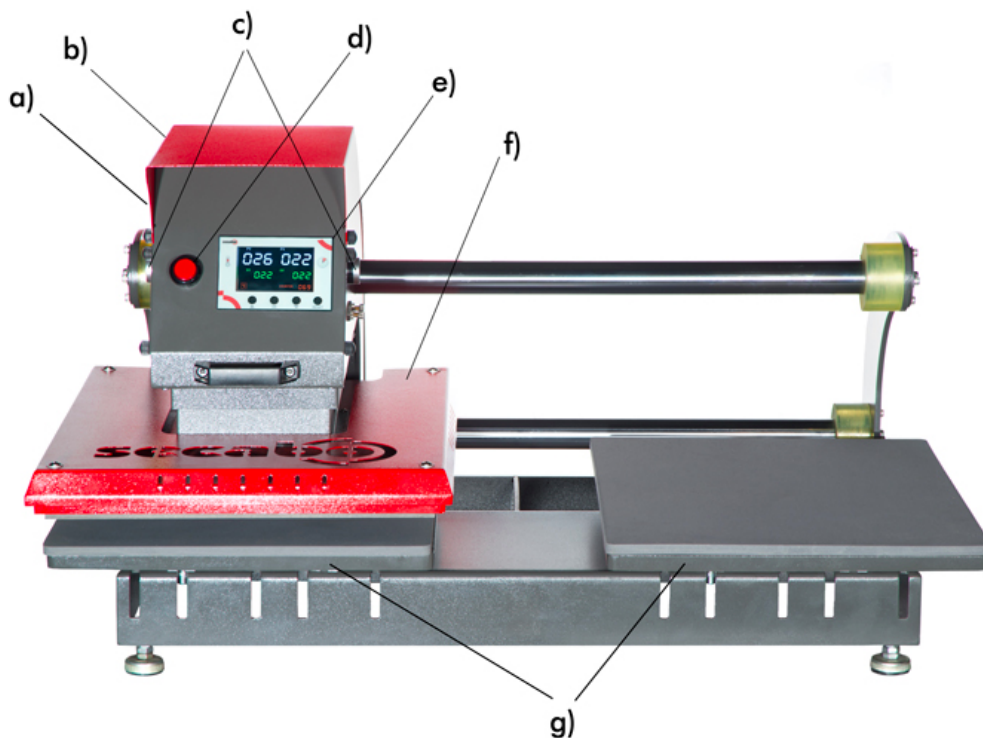
If you cannot observe one or more of the safety precautions above, or if you are not sure whether all points are satisfied, please contact our Technical Support Department.

Scope of Delivery

Before starting work, please check whether the following items are all present:

Article	Quantity
TPD7 heat press	1
Pneumatic adapter for air compressor connection	1
Instruction manual	1

Machine description



- a. manometer, oil- and drain valve (back side, not shown)
- b. rocker switch, fuse, connecting cable (back side, not shown)
- c. two hand control buttons
- d. emergency stop for pneumatic system, pre-pressing button
- e. time- and temperature controller
- f. heating plate
- g. double base plates - available with optional quick-change system (not shown)

Controller



With a large digital controller, temperature (°C und °F) and pressing time can be adjusted. The green digits are showing the theoretical value, the white digits are showing the actual value. A counter (at the right bottom) counts the number of transfers that have already been made during the current session. The counter can be reset at any time.

Operation

Pneumatic connection

- Connect the TPD7 to your air compressor with the included pneumatic adapter. Insert the tube of the supplied adapter in the pneufit-connection at the rear of the TPD7 heat press. The other end of the adapter will be connected with the compressor. Charge the compressor with 6-8 bar, up to 10 bar is possible.
- Set the desired pneumatic pressure on the manometer of the TPD7 by pulling up the cap at the top end and then turning it. After the pressure is set, push the cap back down. The set pressure should be lower than on the manometer of the compressor. Commonly used pressures are between 3 and 6 bar.

Power supply

- Connect the heat press to a 230 V power socket using the connection cable supplied.
- Switch on the press with the red rocker switch.

Operation and setting

- After a short self-test lines appear in the display.
- Press the OK button.
- Use “UP” or “DOWN” to set °C or °F and press OK.
- Use “UP” or “DOWN” to set the desired temperature and press OK.
- Use “UP” or “DOWN” to set the desired time and press OK.

- The press is heating up to the desired temperature

Operating transfers

- Set the desired pneumatic pressure on the manometer of the TPD7 by pulling up the cap at the top end and then turning it. After the pressure is set, push the cap back down. The set pressure should be lower than on the manometer of the compressor. Commonly used pressures are between 3 and 6 bar.
- Bring the press head into an end position right or left. Pay attention that the magnet keeps the head on the end position.
- Now use both hands to push each one of the two green buttons on the left and right of the press head to lower the heating sheet.
- After the set time has expired, the TPD7 opens automatically.
- By pressing the red button next to the controller the transfer process can easily be stopped at any time - e.g. for pre-pressing garments

Operation of throttle valves

- On the right side of the press head there are two silver screws with which the restricting valves to open and close the heating sheet can be adjusted.
- If the screws are screwed out, this slows down the lifting and lowering process.
- When the screws are screwed in, the TPD7 accelerates the lowering and lifting of the heating sheet.
- Fix the respective setting with the corresponding counter nuts by tightening them by hand.

Note: Please note that a certain time is required before the press cools down after it is switched off.

Maintenance and cleaning

Maintenance work should always be accomplished with the press switched off and cooled down. The plug must first be disconnected from the power socket. Consult Technical Support before carrying out any maintenance work.

Clean the press regularly with a soft cloth and mild household cleaner to remove adhesive residues etc. Never use scouring sponges, solvents or gasoline!

Clean the Drain Valve by draining Oil and Water through the Drain Valve.

Recommended times and temperatures

These values are only guidelines; they can vary from material to material and should always be checked before pressing.

Material	Temperature	Pressure	Time
Flock film	170°C - 185°C	light - medium	25s
Flex film	160°C - 185°C	medium-high	25s
Sublimation flex	180°C - 195°C	medium-high	10s - 35s

Sublimation ceramic mugs	200°C	medium-high	150s - 180s
Sublimation on tiles	200°C	high	120s - 480s (depending on thickness of material)
Sublimation on jigsaw puzzles	200°C	light - medium	50s
Sublimations mousepads	200°C	medium	20s - 40s
Sublimation on textiles	200°C	medium-high	30s - 50s
Sublimation on metal plates	200°C	high	10s - 50s (depending on thickness of material)

Important note: You should carry out your own tests with the transfer material and backing to be used before starting production. The values given above and the manufacturer's own figures are only intended as a guide. You should establish the washability and behaviour during transfer in your own tests.

The recommended values do not imply a guarantee. The user is responsible for determining and using the appropriate setting for his particular conditions.

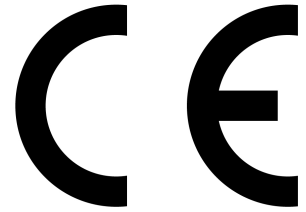
Note for textile work: After pressing, allow textiles to cool down before removing any type of backing from the transfer material. The hot glue in the transfer material develops its adhesive force only in the cold state. If the adhesive does not stick in the cold state, it may have been pressed too cold or for too short a time.

Technical data

Heat press	TPD7
Working Area	2 x 40cm x 50cm portrait
Max. temperature	225°C
Max. time setting	999s
Max. pressure	350g/cm ² , max. 10bar
Pressure setting	Setting of pneumatic pressure on the manometer
Power supply	230V / 50Hz - 60Hz, 1,8kW
Environment	+5°C - +35°C / 30% - 70% humidity
Weight	98kg
Dimensions (B x H x T)	100cm x 58cm x 75cm

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:
- 2006/95/EG Niederspannungsrichtlinie / 2006/95/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', written over a horizontal line.

Dipl. Ing. Fabian Franke

A handwritten signature in black ink, appearing to read 'Bernhard Schmidt', written over a vertical line.

Dipl. Ing.(FH) Bernhard Schmidt