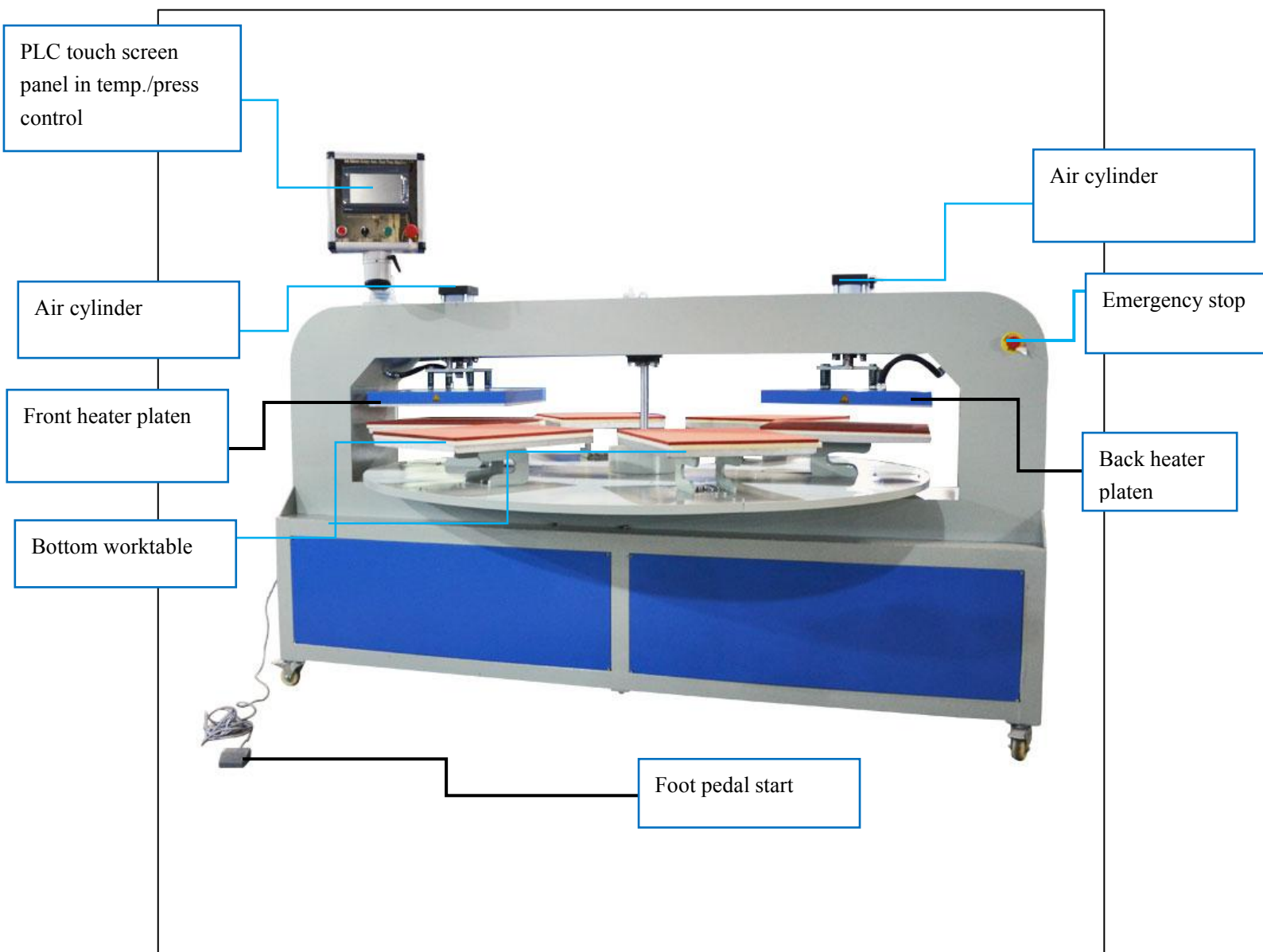


Automatic Pneumatic Six Worktable Rotary Dual Heater Heat Press Machine (GS-QD6)



I. Technical parameters

Specification: 40*60cm

Voltage: 220V -1 phase

Power: 4KW

Electricity: 18amp

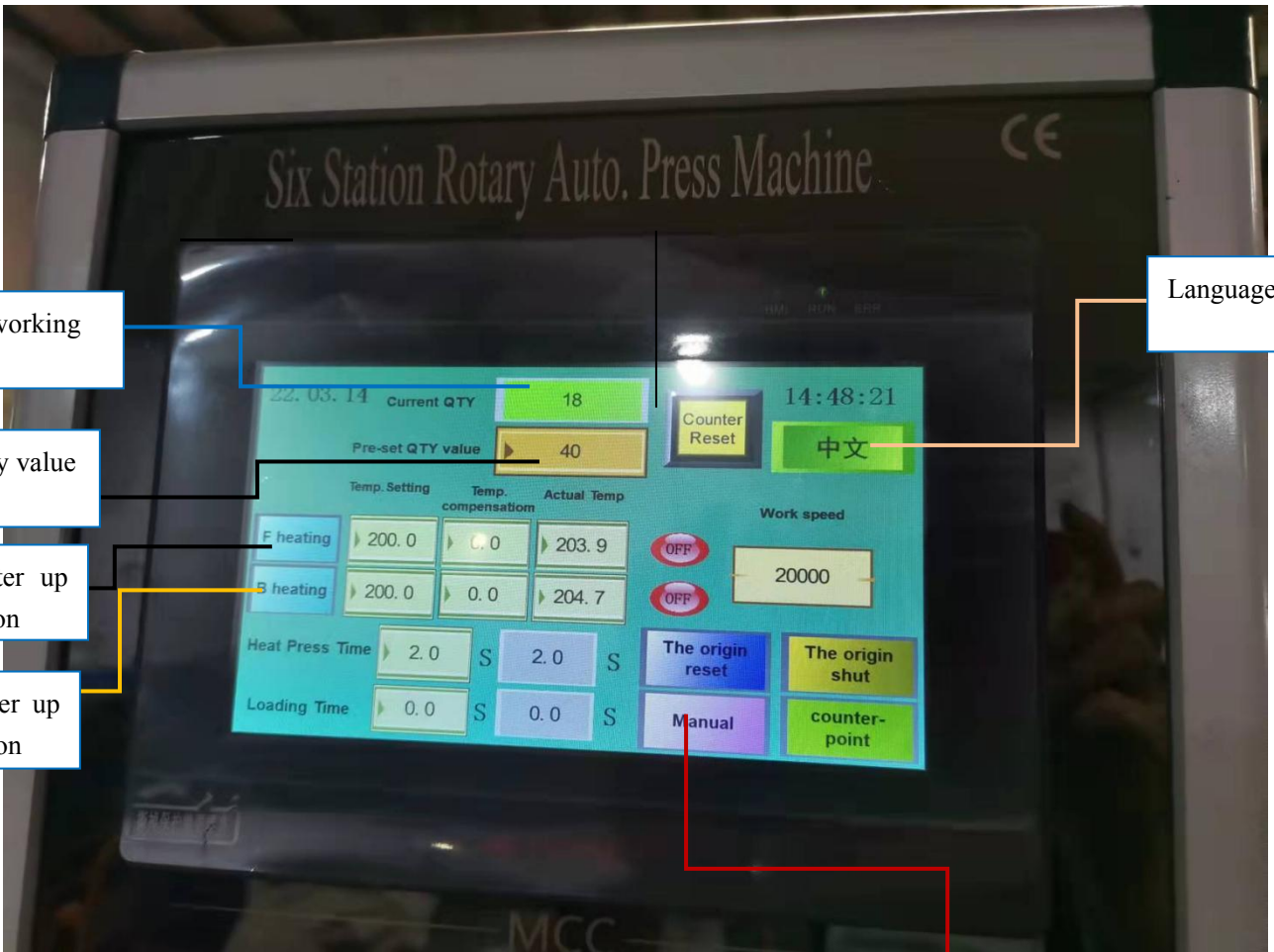
Time range: 0-999s

Temperature range: 0-399°C

Working pressure: 0-8kg/cm

li. Main use:

Pneumatic rotary heat press with four workstation can be sublimated, solvent ink color logo and the heat transfer in such as cotton, hemp, chemical fiber, nylon fabric and ceramic products, also can be flocking heat press process and foaming printing process such as heat treatment, and the low temperature low pressure line of the clothing and fabric glue, glue, such as clothing, shoes and hats a lot is suitable for the production of large quantities of cutting piece, t-shirt printing.



Present working piece

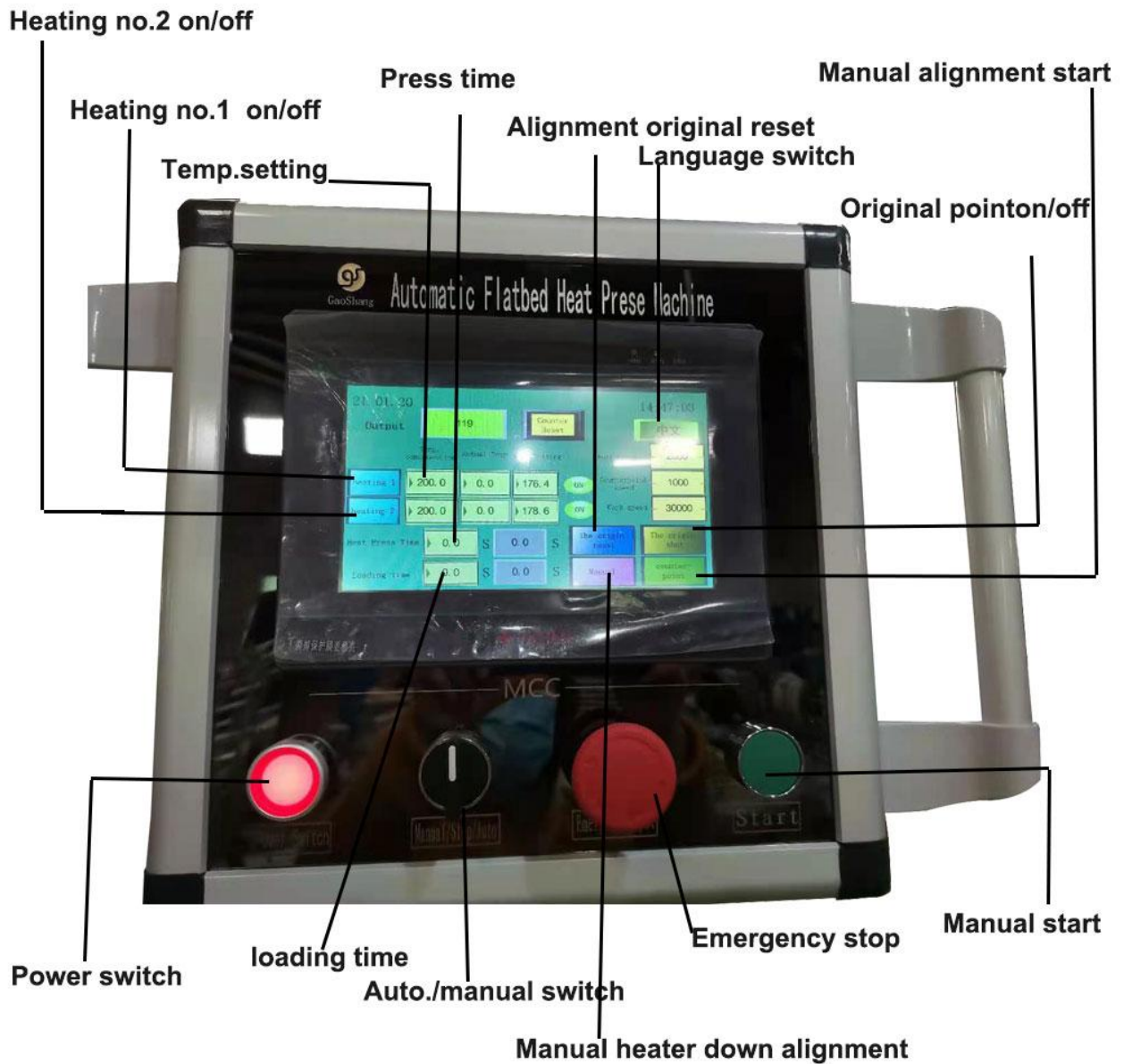
Needed Qty value

Front heater up or off button

Back heater up or off button

Language switch

Press down by manual press for table correct way



iii. Product feature:

Time control, temperature control, piecework function, manual/automatic mode in one PLC programming touch screen, high accuracy, ($\pm 2^{\circ}\text{C}$).

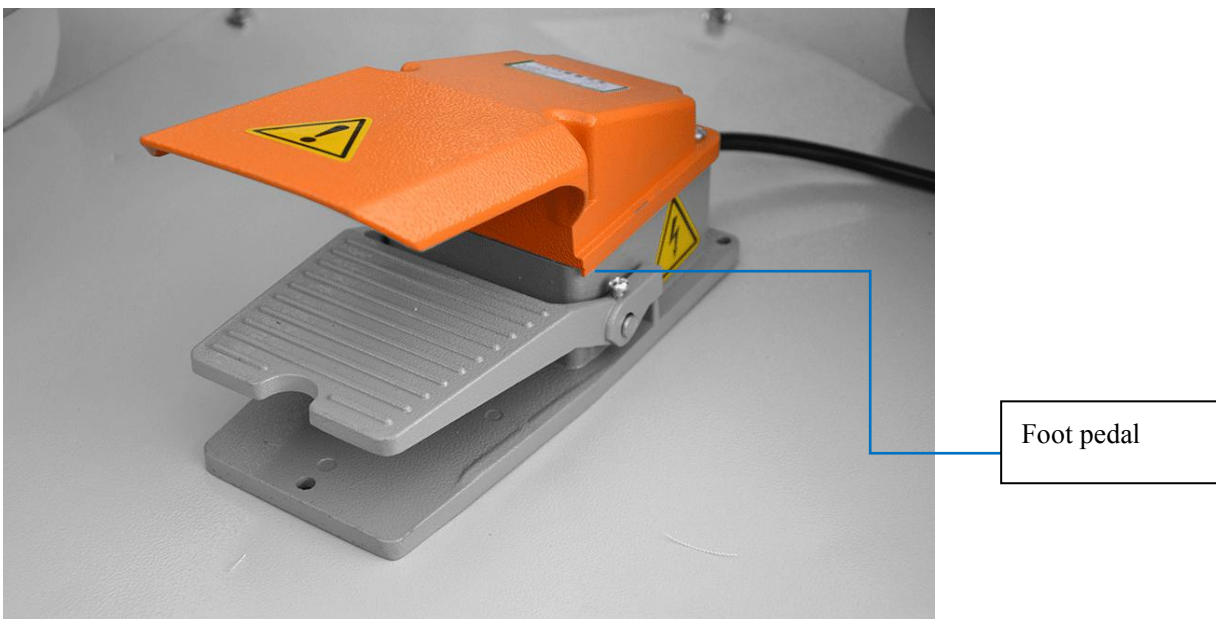
Imported aluminum alloy casting heat conduction principle, energy saving, uniform temperature, small coefficient of temperature difference.

Electronic digital time control, high accuracy, beautiful.

Random pressure regulation.

iv. Operating procedures

1. Connect the compressor connector, open the air pressure, adjust the pressure gauge (4pb-6pb), and make the heating plate rise;
2. Plug in the power, turn on the main power switch, and the indicator light turns on.
3. Touch the screen to enter the system, adjust the required time and temperature, and turn on the heating switch.
4. After adjusting the temperature and time, wait for the machine to heat up.
5. After the heating up is completed done, the actual temperature is what you pre-set value temp.
6. Clothes/fabric should flat on the silicone mat, switch to manual mode working, every time driving electric, **stepping on foot switch for 3 seconds long to start working operation**, then choose switch manual or automatic mode.



Make the sample test first.

7. When the press time is up, the heating platen will rise automatically and the table will rotate to next right worktable automatically(When the working table is press process,you need to prepare next table substrate material ready in advance)

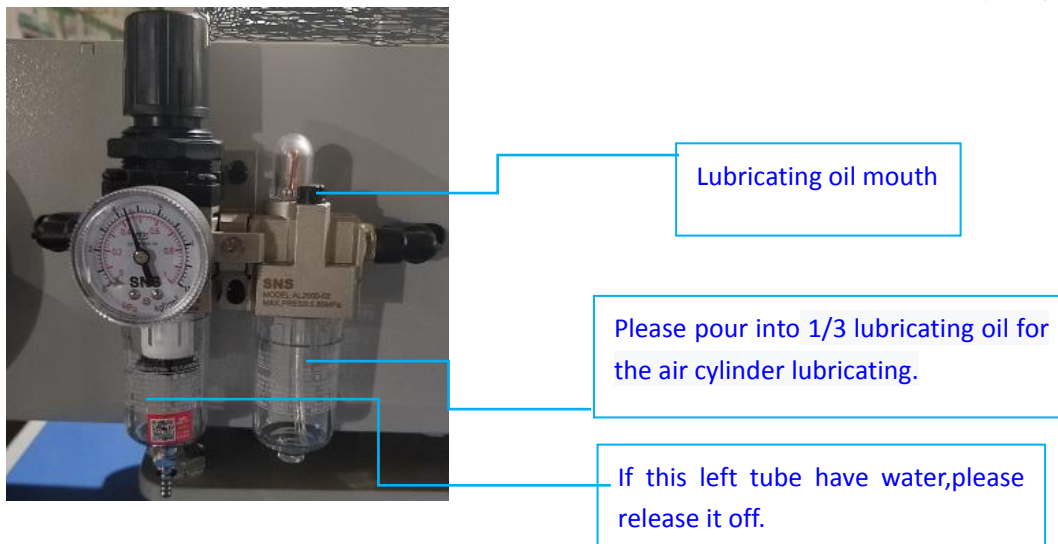
8. Hot items. If the vinyl need to be cold, please wait 5-10 seconds before tearing off the hot paper. If it is hot, please immediately tear off the hot paper.

Continue work next table repeat

9. After successful trial printing, the transfer switch can be right-handed to the automatic transmission. After placing the hot stamping items, as long as the switch to full automatic, hot stamping will start automatically. In case of emergency, you can press the emergency stop button, at this point, the upper pressure plate (heating plate) after the automatic rise, emergency stop button reset can continue hot stamping.

V. Maintenance matters:

1. pressure: not uniform, first use a ruler to measure whether the distance between the four sides of the heating plate and the four sides of the bottom plate is consistent. If not, adjust the "down" nut of the four screw rod in the center of the heating plate, and raise it to the down-down tightening heating plate, and lower it to the "up" tightening heating plate. If the pressure is too high or too low (usually 4kg-6kg), adjust the regulating valve on the filter to lift it in the "+" direction to increase the pressure, "-" to reduce the pressure, or check whether the air compressor pressure is normal (usually 6kg-8kg).



2. Time: when the bottom plate is in place, do not show the time, then check the proximity switch, whether the distance is moderate, should be adjusted to less than 5mm, time, heating plate will not come down, check the circuit (intermediate relay).

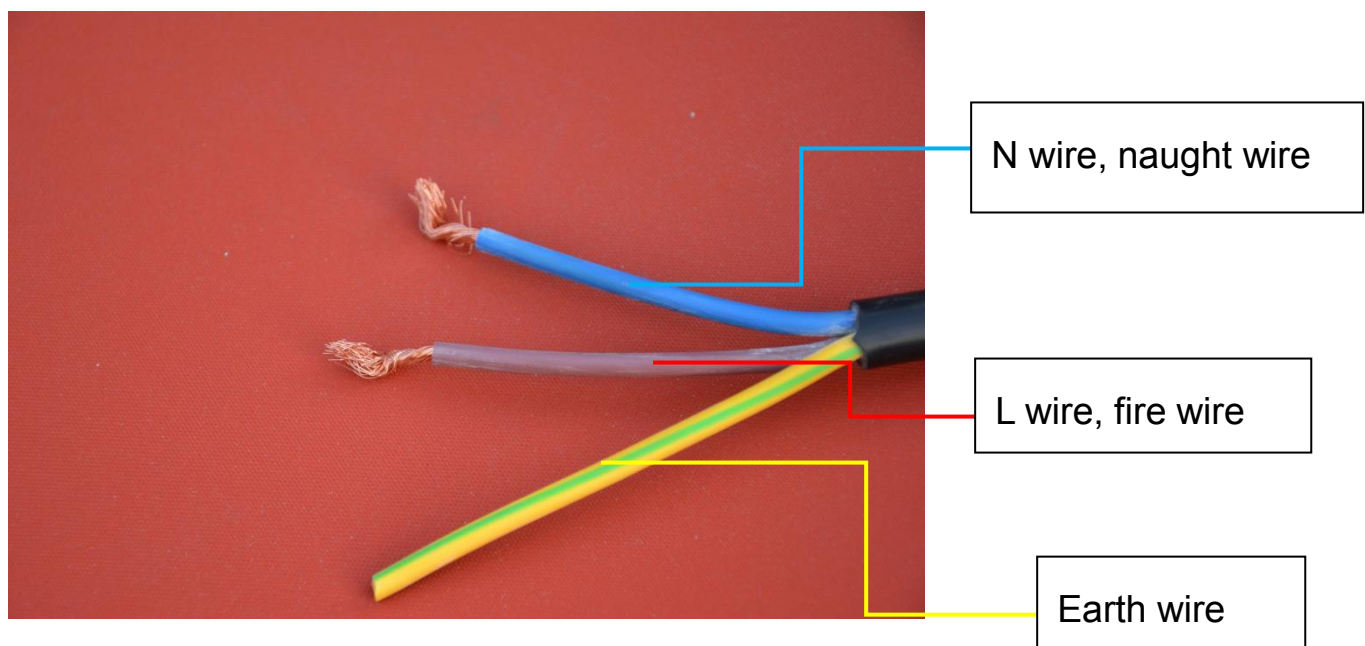
3. Temperature: adjust to the set temperature, no temperature rise, no temperature control, check whether the temperature control meter, solid state relay, heating plate line is in good contact and electrical original fault.

4. Worktable correction: turn on original shut→press counter point(the worktable will be move slightly to left table till table under heater platen beneath)→press manual button for several seconds to check top platen and bottom table correct or not→original rest(if not correction,please try again)

Note:

The whole machine must have proper and reliable protective ground wire

Successful hot stamping needs to have the right time, temperature and pressure to cooperate, the thickness of clothes and materials and all kinds of hot stamping paper affect the effect of hot stamping, all kinds of hot stamping paper need to try hot samples before mass production.



Set the temperature and time(Suggested parameter)

Speed adjustable: 30000-50000 velocities

Heating: For example, the temperature has been set, if you need to cool down in advance, turn off the heating;

Temp Setting: Successful hot stamping needs to have the right time, temperature and pressure to cooperate, the thickness of clothes and materials and all kinds of hot stamping paper affect the effect of hot stamping, all kinds of hot stamping paper need to try hot samples before mass production.

Actual temp: When the temperature is set, the actual temperature bar shows the current temperature rise;

The required temperature and time for hot stamping are as follows

(for reference only) :

Cotton: 180 degrees, 15 seconds

Polyester: 180-220 degrees, 25 seconds

Pearl plate: 180 degrees, 120- 180 seconds

Metal pendant: 180 degrees, 60 seconds

Mouse pad: 180 degrees, 15 seconds

Porcelain: 200 degrees, 180 seconds

Heat press Time: According to the material heat transfer time adjustment, such as heat transfer is generally 25S, do hot stamping is generally 8S;

Loading Time: Refers to the hot pressing after the completion of the upper plate after the movement of the time, according to the laying time Settings;

The origin shut, Counterpoint,The origin reset: Will play to the center select manual mode switch will return to the origin switch, speed adjustable slow to about 1000 on light dots move to general position after testing whether the lower position on the para press buttons, origin will reset after 0 k and close the switch back to the origin, and the speed to normal speed, back to the origin to long press foot switch for 3 seconds to recover after the parameters of the normal use;

counter: A record of how many times the device has worked;

speed: Usually not adjusted.

buffer time: Usually not adjusted.

Vi. After-sales service

Thank you for buying our products. Our company adhere to the quality of survival, reputation and development of the purpose, over the years in the machine production, technical research and after-sales service has made great efforts. We promise you with high quality products:

1. The machine is guaranteed for one year. Within one year of use, if the machine has non-human fault, our company is responsible for free repair and delivery of accessories.
2. If the machine is damaged or malfunctions due to customers' failure to install it as required or improper operation, maintenance or transportation, our company shall be responsible for repair and technical guidance, and only charge the cost of accessories.
3. If the machine breaks down after the one-year warranty period, our company will be responsible for the maintenance and only charge the cost of accessories.

* Note: the sample pictures and instructions are standard sizes of our company.