

15 x15”/ 16”x20” / 16”x24”

Flat Heat Press

Instruction Manual

Warning and Caution

- There are high voltage electrodes inside the heat press. Do not remove the panels from the heat press.
- The heat press will heat up very quickly. Do not place any object on top or near the heat press.
- Heat press operated at 180 C (380 degrees F) and above. It is very hot. Please remove object around heat press.
- Keep away from flammables.
- Very important: Keep away from children. Do not let small children play near the press when it is hot.
- Unplug heat press when not in use.
- Even the unit is unplugged; the heat press will remain hot for a long period of time. (over 40 minutes) Make sure do not touch heat surface.
- Provide ample working surface. Accident tends to happen when the area is tight.
- Do not try to move the heat press until it is cool to touch.
- Heat press is rated at 1200 to 1400 watts. Make sure it is on a 20-amp circuit with minimal other electrical equipment on the same electrical circuit.
- Make sure the electrical circuit is property grounded before plug the heat press in. (Never use a 3 prong adapter)
- Keep away from water or wet environments.
- We recommend turning off the press when not in use. It saves energy. Furthermore the fuse tends to burn out during prolong nonstop operation.
- Save the packing box. It is almost impossible to ship the press for warranty service unharmed without the Styrofoam packaging.
- When taking the heat press out of the box, check for any damage, loose parts, screw or nuts before plugging the press. The press is very heavy and it is very possible that it might be damaged or some parts got shaken loose during transportation.

SET TEMPERATURE TO 180-200 C or 355-390 F FOR MOST TRANSFER

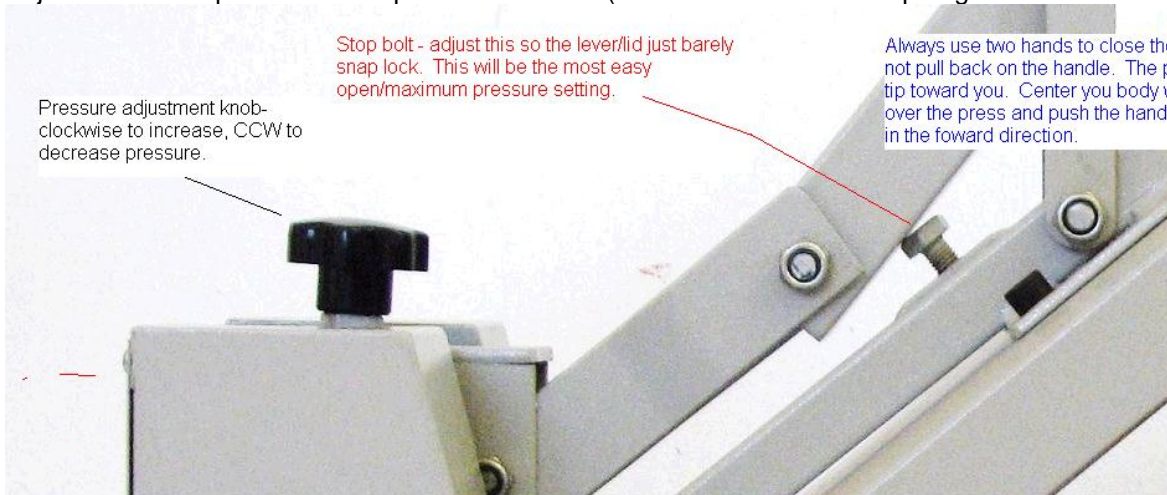
Temperature Conversion Chart

100 C = 212 F
149 C = 300 F
163 C = 325 F
180 C = 356 F
193 C = 380 F
199 C = 390 F
204 C = 400 F
300 C = 572 F

Operating Instruction:

1. Remove the machine out of the carton and place it on a wide and flat working surface. (Make sure clear all Styrofoam and packaging material)
2. There is an only gauge on the press and a pressure adjustment knob that you will need to adjust. **(We will use light color iron on transfer as an example)**
3. To adjust temperature, press the **SET** button once), press **UP** and **Down Arrows** to adjust the temperature setting.
4. To adjust time, press the **SET** button again, press **UP** and **Down Arrows** to adjust the time setting.
5. Press the SET button once again to get to the real time mode for the machine to start heating.
6. Note: If you press SET button for longer than 5 seconds, secondary menu will comes on. The gauge will indicate F3 than F or C will be shown. Press up and down arrow to change the scale to your preference.
7. Press Set button again, than the gauge will shown F4. This is number is used for calibration. Normally it is set between -20 to +20. Important, to get back to the real time mode, need to press the SET button for 5 seconds.

8. Prepare T-shirt and your transfer image. (Make sure the print on the transfer sheet is reversed/mirrored)
9. Open the press Handle.
10. Adjust the rubber pad so it sits square on the base (some model has rubber pad glued onto the base).



11. Adjust the pressure knob clockwise so you feel a heavy to heavy high force is needed to snap close the press. The more pressure on the transfer, the better the results. – Adjust the stop (the stop bolt that makes contact with the arm when closing the lid. Turn the hex bolt to a point such that when closing the lid, the arm will just barely snap close. (This is the maximum pressure locking setting). Moreover, this will also make it very easy to open the lid. (Tips: Place the press on a table that is lower so when closing the lid the grip is near your stomach. Center you body weight over the handle. Close the lid with two hands on the grip. This will generate very large pressure with minimal effort.)
12. Now, increase the pressure knob on the back by turning the knob CW accordingly. Important: If the stop bolt is too low, it is very difficult to open the press. Furthermore, the lower the hex stops, the lower the pressure. **Remember** to adjust the stop so it barely locks and also that it does not pop open too easily. We don't want the lid to pop open by itself and the handle could hit you on the jaw!!
13. Open the press Handle again plugs the heat press into 110 V source.
14. Flip the switch on top of the heat press ON. (The heat press now is on, the temperature will start to rise)

15. Set temperature around 180 to 195 C.
16. Set time to 15 to 20 seconds.
(For stock silk screen transfer, we recommend 200 C / 30 seconds / maximum pressure / hot peel)
17. Open the presses handle. (It takes about 15 to 20 minutes for the press to reach 185 C)
18. Place the first Teflon sheet over the rubber pad. (Teflon sheet is recommended but not necessary)
19. Place T shirt on the Teflon sheet. (Be careful, the press is hot)

******Warning: Never close the heat press platen directly on the rubber when the press is hot! Doing so may melt the rubber and cause fire.******

20. When the temperature is stabilized (in this case 180 to 195 C), close the press for about 5 seconds. (This will allow the contaminants and moisture to burn off from the T shirt to yield better adhesion)
21. Open the presses handle.
22. Position the transfer paper over the T-shirt. Face down. (for light color transfer paper)
23. Place 2nd sheet of Teflon over the transfer paper.

(A word about browning of T-shirt: The cotton fibers will get scorched around 350f due to direct contact to the hot metal surface. One way to alleviate this browning is using Teflon sheet. It will help and make it less obvious. To better describe the mechanism here imagine an oven heated up to 400 F. You will not get burned when your hand is in the oven for few seconds. But you will get a blister immediately when you touch on the metal hot surface of the oven)

24. Close press handle.

25. The timer will begin to count (15 to 20 seconds).

26. Open the handle when alarm buzz.

27. Remove the t shirt and peel off the backing immediately to get matted finish. (for hot peel)

28. If your paper has cold peel property then peel the transfer paper after 2 minutes to get glossy transfer. (Not all paper has hot and cold peel option. Most transfer paper only can do hot peel. How good of transfer depends mostly on the iron on paper.) Caution: If the paper is a hot peel only and the backing is not removed in time, it will be almost impossible to remove the backing! (For purchase info see notes in the back)

29. Turn off the press and unplug the unit when not using the press any more

30. Do not close the lid until the press is cooled. (The rubber pad may still be hot and get scorched.)

- There are no exact ways to for heat transfers. If using very high pressure, the time and temperature can be reduced. If set at lower temperature, then the time and pressure need to increase.
- Washing instruction: Wait for 24 hours before washing. Turn the t-shirt inside out, use cold water, no bleach and use light cycle.
- Maintenance: keep all moving parts well lubricated. Check all electrical contacts after few hundreds shirts. Heat press shakes every time it opens. It is possible that some contacts may come loose.

Common Problems:

- **Iron on image does not stick or washes off:** Increase temperature and increase pressure. A heat press is basically a very hot iron with pressure mechanism. If the paper does not stick mostly likely is due to the quality of iron on paper. A home use or hobby iron on paper is considerable less quality. It will peel after 1 or 2

washes. Furthermore, use good inkjet ink (Such as Epson Durabrite). If the ink is not good, the image colors will run during washes.

- Item thickness is over 1/2" or less than 1/2": The base of the heat press can be swiveled to match the top heat platen. When the item to be press is thick (such as wood or tile), loosen the bottom 2 bolts on the aluminum base plate just a little bit so it swivels. The pressure on the item will be more balanced.
- Not complete transfer due to not enough pressure:----Add 1 or 2 layers of towels on the rubber mat. Sometimes adding padding to the base will give more cushioning effect.

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