



OPERATING INSTRUCTIONS

for the heat press

Secabo TPD7 PREMIUM

Congratulations on the purchase of your Secabo heat press!

Please carefully read the operating manual to easily integrate your unit into your production environment.

Any type of reproduction of this operating manual requires the written permission of Secabo GmbH. Changes and errors in the technical data and the product characteristics are reserved.

The Secabo GmbH is not liable for any direct or indirect damages occurring as a result of the use of this product.

Version 1.0 (31.08.2016)

Brief overview Secabo TPD7 PREMIUM automatic double plate press

- Extremely high contact pressure of 12kN at 10 bar (600g/cm² or 1.2t)
- Automatic operation of the pressing head
- Pre-pressing function with adjustable pre-pressing duration
- Separately adjustable durations for both base plates
- Savable sets of durations and temperature
- Extremely high heat output and heat capacity of the heating plate, as well as professional heat distribution
- Easily adjustable and reproducible pneumatic pressure
- Modular construction, easily exchangeable components, such as base plate, heating plate, controller etc.
- Includes a stable base stand for an ergonomic working height

Safety measures

Please read the information and safety measures carefully prior to initial operation of the unit!

- Never touch the heat press with your hands when it is connected to the power supply, especially if it is switched on and heated up – danger of burns!
- Never manipulate the buttons for two-hand operation, the emergency stop or any other component of the heat press.
- Never open the casing and do not make any modifications to the unit yourself.
- Should it be necessary to open the cover of the heat plates upon explicit request by Secabo's customer service team, it is recommended to wear respiratory protection and to only touch the damping wool contained therein with gloves. If the insulation wool needs to be disposed of, it should be placed in a closed bag.
- Ensure that neither liquids nor metal objects are put inside the heat press.
- Ensure that the wall socket you use is grounded. Keep in mind that a card cutter may only be operated on a wall socket equipped with a ground fault switch.
- Disconnect the heat press from the power supply when it's not in use.
- Always ensure that the heat press is out of reach of children during operation and never leave the unit switched on without supervision.
- Ensure the unit is only used in dry rooms.
- Ensure that the tank volume and maximum pressure of the employed compressor is in tune with the air consumption and pressure requirements of the TPD7. Only use pressure tanks, which have the necessary TÜV certificates.

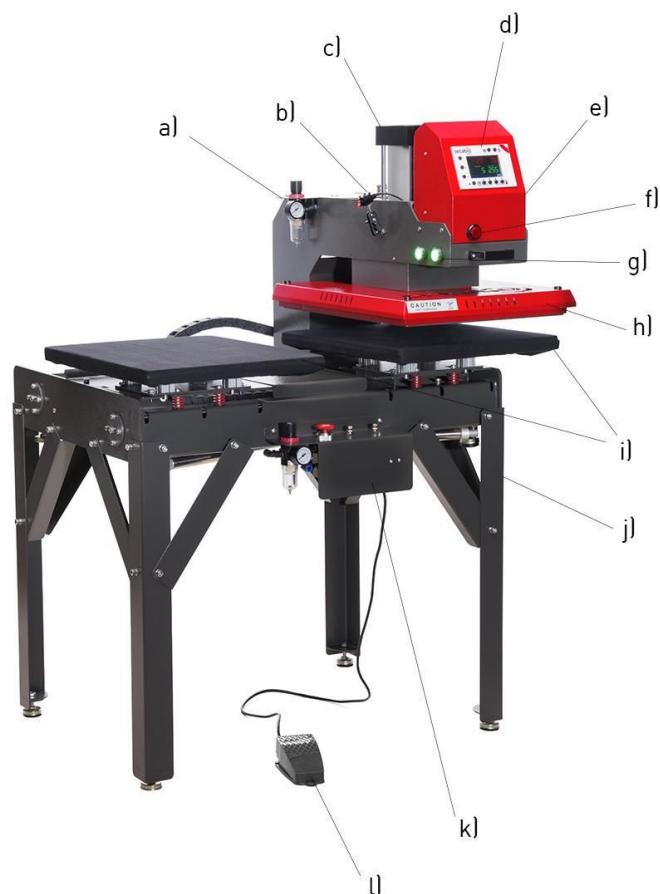
If you cannot meet one or more of the aforementioned safety rules, or if you are not sure if you're meeting all of the points, please contact our technical support.

Items included

Before starting work, please check whether all of the following items were delivered:

Item	Quantity
TPD7 PREMIUM heat press	1
Sheet metal parts for stand	4 x leg, 8 x stabilizer, screw set
Pneumatic adapter for connection with compressor	1
Foot switch	1
Power cable	1
Operating Instructions	1

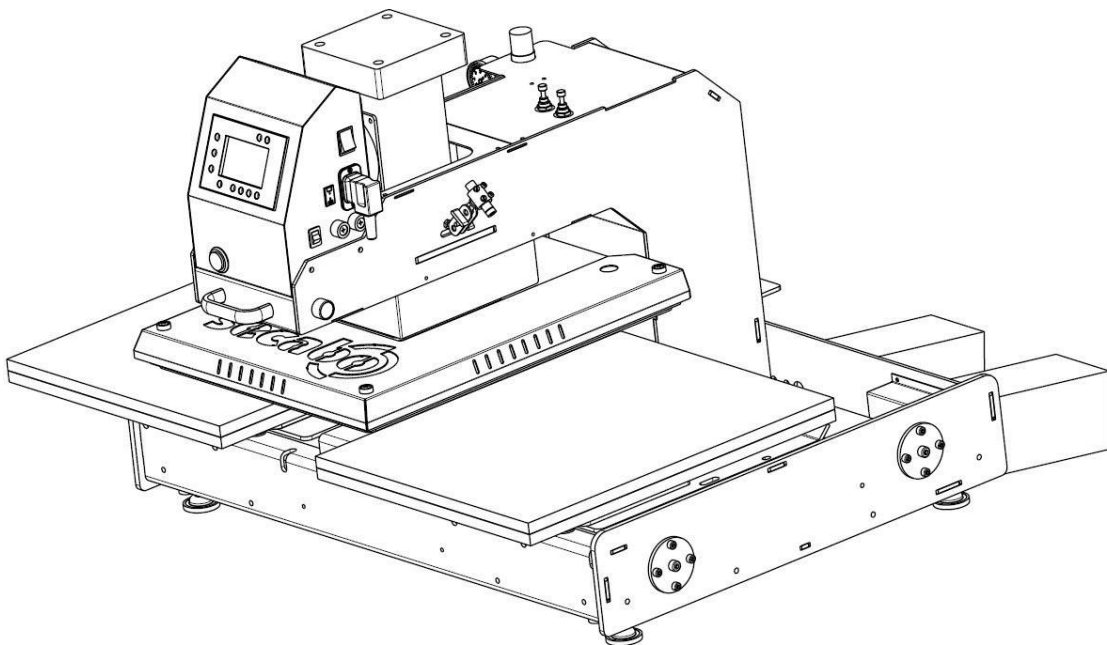
Machine Description



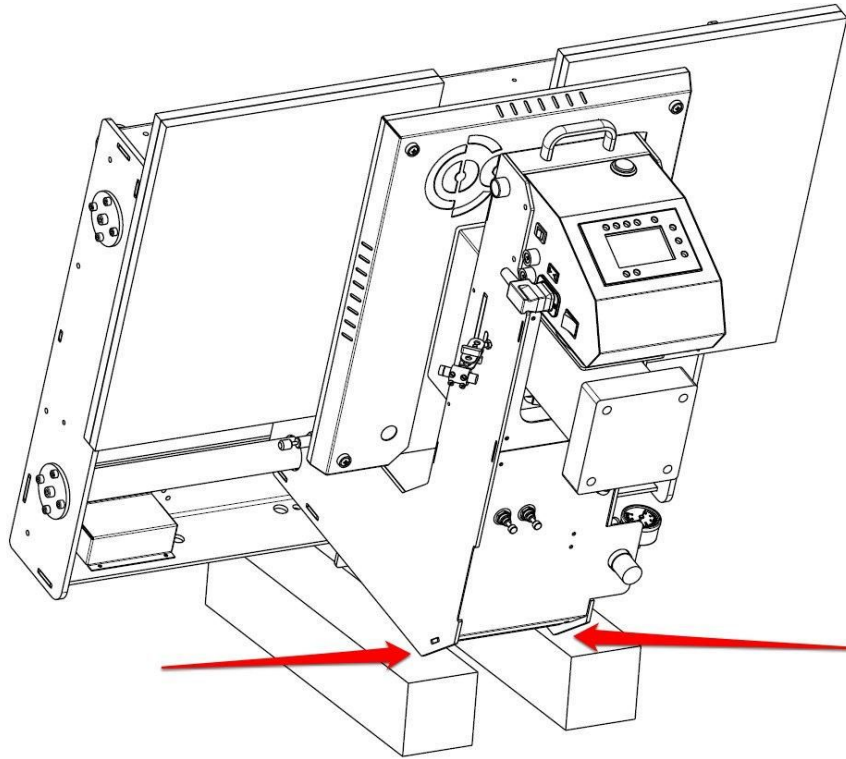
- a. Manometer, oil and water separator
- b. Cross laser with ball joint and focus ring at the front, another cross laser is located on the other side of the compression head (not shown)
- c. Pneumatic cylinder
- d. Time and temperature controller
- e. Toggle switch, fuse, Pneufit connection for compressed air (rear side, not shown)
- f. Button for manually opening the press
- g. Buttons for two-hand operation for pressing and pre-pressing
- h. Heat plate with cover
- i. Base plates with cotton covers
- j. Stand with adjustable rubber feet
- k. Control unit for automatic moving of the press head
- l. Foot switch for moving the press head

Mounting stand and pneumatic unit

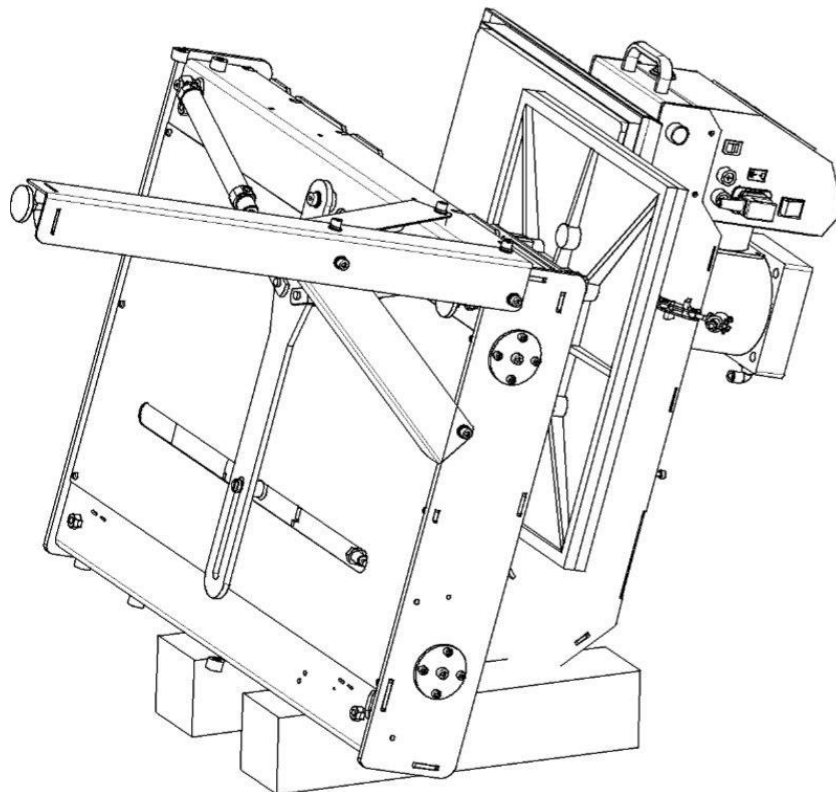
- Place two squared timbers approx. 8x8x60cm under the back side of the transfer press.



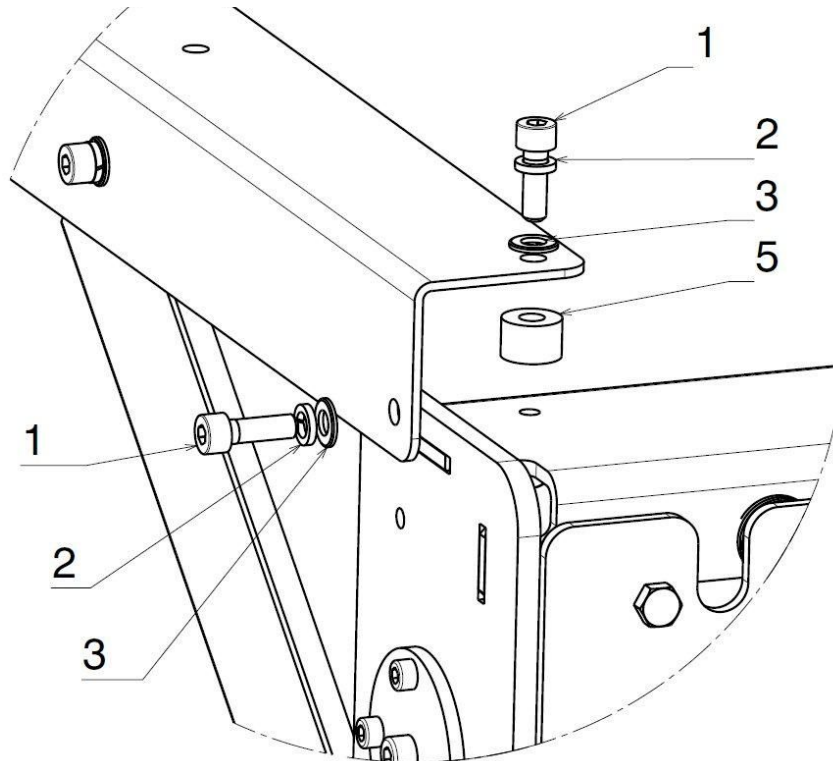
- Carefully tilt the press backwards with at least two persons. When doing this, the press head must be resting on the squared timbers. Place something soft underneath to avoid scratching the unit!



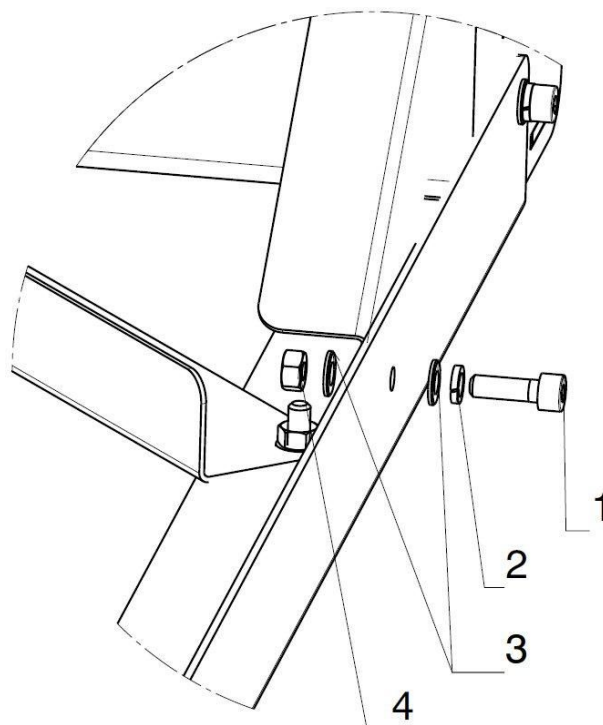
- Place the four legs in the mounting holes one by one and screw them tight.



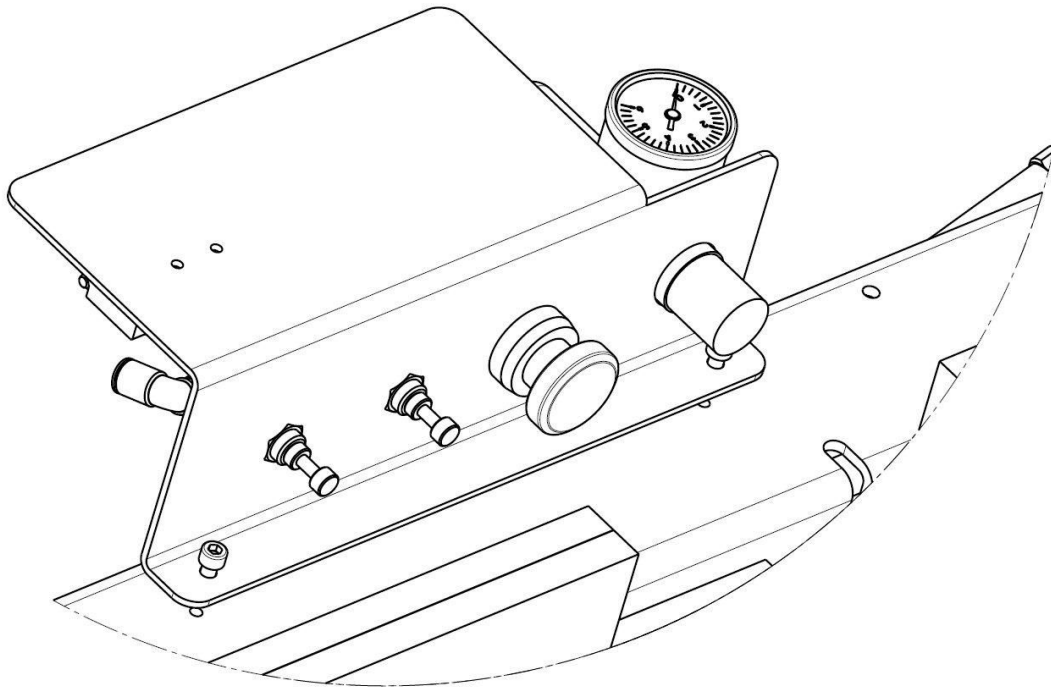
- To do so, use screws (1), washers (2) and spring washers (3). Insert the spacers (5) on the front and the back side of the press.



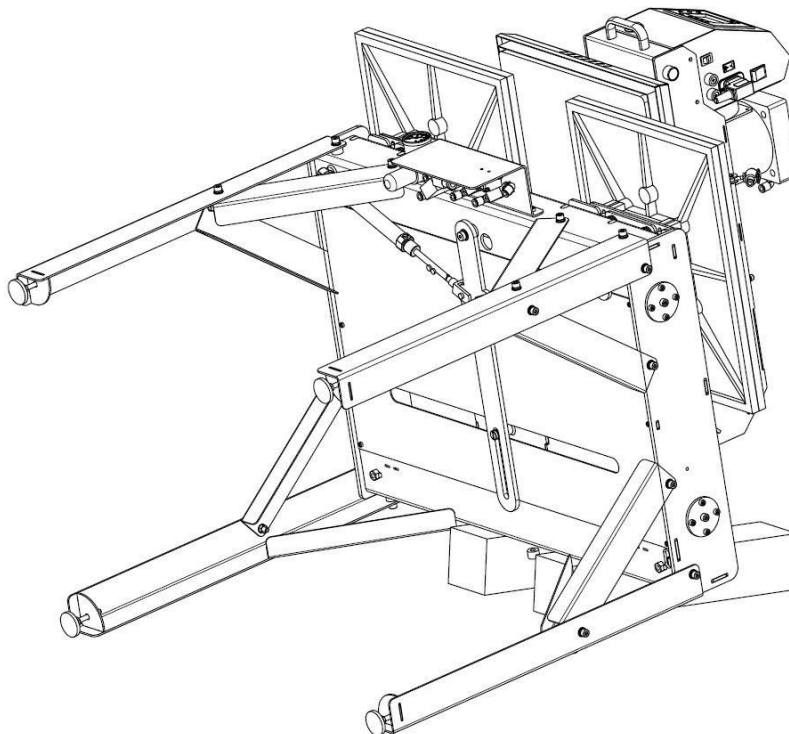
- Screw the stabilizers to the legs using screw (1), washers (3), lock washer (2) and nut (4) from the **inside** .



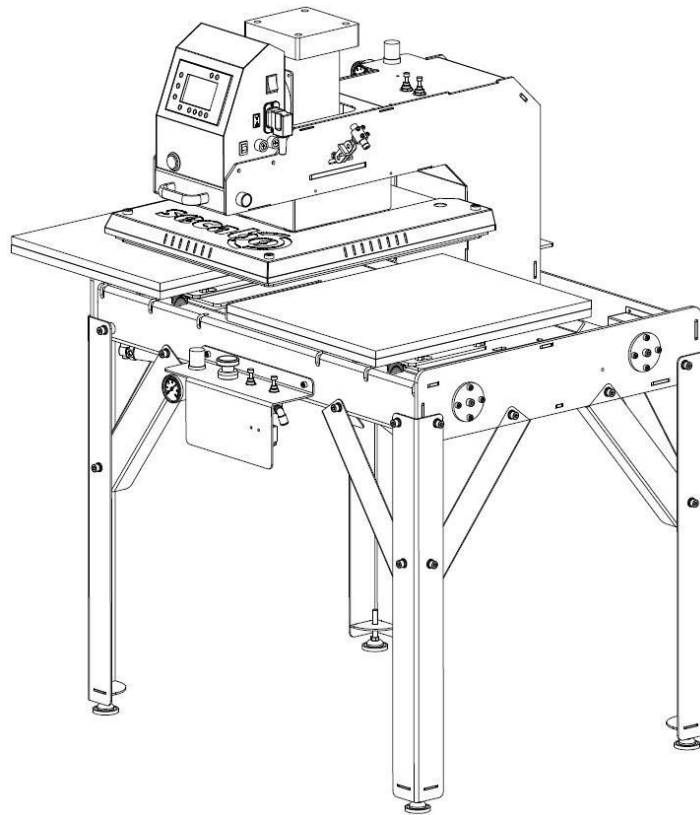
- Screw the pneumatic control unit to the press using two screws.



- After assembly of all legs, tighten all screws one more time. Now carefully tilt the press forward with at least two persons.



- Carefully position the press with at least 2 persons. In doing so, avoid resting the weight on the rear legs by slightly lifting it off the ground.



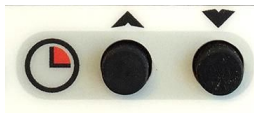
Controller



The central controller allows for setting the desired temperature ($^{\circ}\text{C}$ and $^{\circ}\text{F}$), as well as the press duration in seconds. The green digits because represent the target values, while the white numbers reflect the current values. The counter is displayed at the lower right and indicates the number of pressing operations carried out since the last reset.

Three sets of settings can be saved and loaded. Furthermore, separate time values can be set for the left and right base plate.

The features in detail



These arrow keys serve to set the time values in seconds.



These arrow keys serve to set the temperature values in degrees Celsius or Fahrenheit - depending on the selected unit.



The save keys 1, 2 and 3 serve to save complete sets of temperature and time values - also for the left and right base plate separately. To store the current values, simply hold the key until the display flashes briefly.



The time mode can be selected with this button. "<>" on the top left of the display means - same time on both plates, "<" represents the time of the left plate, ">" represents the time of the right plate. If you wish to set the time of the plate not currently in use by the TPD7 PREMIUM, you can select this side via the button and change the time as described above; a few seconds after the last input, the display returns to displaying the press head's current side.



This button serves to reset the counter at the bottom right of the display back to 0.



Press shortly to set the pre-press times for the left, right or both sides.

The setting itself is done using .

Press this key for approx. 3 seconds to enter the settings mode. Press it again to exit.

Various settings can be configured in the settings mode. Navigate the individual sets using the arrow keys , allows you to change the respective value.

Set 1	Unit temperature	°C or °F
Set 2	Automatic shut-off of the heater in minutes when the press is not in use	0 - 240
Set 3	Hysteresis value, switch off the heater X° before attaining the target value	0°C - 10°C
Set 4	Temperature correction of the display	-5°C - +5°C in

		steps of 1/10°
Set 5	Maximum temperature of the press	0°C - 225°C
Set 6	Sound	on / off
Set 7	Absolute counter for press operations	mere reading the current value

Operation

Connection pneumatic

- Connect the TPD7 PREMIUM to your air compressor using the supplied pneumatic adapter. Insert the hose of the supplied adapter into the Pneufit connection on the back of the TPD7 PREMIUM heat press. The other end of the adapter is to be connected to the compressor. Charge the compressor, usually with 6-8 bar; up to 10 bar is possible.
- Set the desired pneumatic pressure for pressing on the manometer at the top of the TPD7 PREMIUM by simply pulling up the cap at the top and then turning it. After setting the pressure, push the cap back down. The pressure should be lower than on the compressor's manometer. Commonly a pressure between 3 and 6 bar is used.
- A value of 4 bar is preset on the pneumatic control unit's manometer below the base plate, which does not need to be changed.

Connection power

- Use the the supplied power cord to connect the heat press to a 230V socket equipped with a ground fault switch.
- Furthermore, connect the pneumatic control unit below the heat press to the back of the heat press via the integrated power cable.
- The red toggle switch turns the press ON.

Operation and Configuration

- You can switch on both cross lasers using the small black toggle switch on the right side of the controller box and align them on the base plates as desired, as well as via the focus at the front.
- The TPD7 PREMIUM is immediately ready for use and can be configured as described above.
- The press will now heat up to the set temperature.

Moving pressing head

- You can move the head press automatically by using the foot switch.
- The foot switch should be positioned under the heat press in such a way, that it is easily accessible and can only be used when a moving of the press head is intended.

- In case of danger ahead, press the emergency stop button for the moving feature located between the two base plates.
- Upon pulling the emergency off switch, the press head automatically moves to the closest end, after which the function is normally available again.

Performing transfers

- Bring the press head to the right or left end position by pressing the foot switch.
- Proceed by using both hands to push both two silver buttons on the left and right side of the pressing head to lower the heater plate.
 - If pre-pressing, the back button on the left side is to be chosen.
 - For normal transfers, the front left button is to be chosen.
- Once the press is closed, the clock begins to run.
- The TPD7 automatically opens after the set time has elapsed.
- You can stop the pressing process at any time by pressing the red button at the bottom side of the controller.
- Now the press head can be moved to the other side and closed again there, if necessary.
- No settings can be changed during the pressing process.
- With each completed pressing process, the counter displays increases by one, as soon as the specified time has elapsed.

Operation of the throttle valves

- Two silver screws, which can be used to set the throttle valve to open or close the heating plate, are found on the top part the press head.
- Unscrewing the screws slows down the lifting and lowering processes.
- Screwing the screws in causes the TPD7 to accelerate the lowering and raising of the heat plate.
- Fix the setting by hand-tightening the appropriate lock nuts.
- The same applies to the two throttles for the automatic moving of the press head. These are located on the pneumatic control unit between the base plates.

Note: Please note that it takes some time for the press to cool off after it is switched off.

Maintenance and cleaning

All maintenance work must be carried out with the press switched off and cooled off, no exceptions! First, remove the plug from the wall socket socket. Only perform maintenance work after consultation with our technical support team.

The press should be cleaned regularly using a soft cloth and a mild household cleaner to remove adhesive residues, etc. Do not use scouring sponges, solvents or gasoline!

Any residue in the oil and water separator must be drained via the lower valve screw and disposed of.

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	Time
Flock film	170°C - 185°C	low - medium	25s
Flex film	160°C - 185°C	medium - high	25s
Sublimation flex	180°C - 195°C	medium - high	10s - 35s
Sublimation on ceramic cups	200°C	medium - high	150s - 180s
Sublimation on tiles	200°C	high	120s - 480s (depending on the thickness of the material)
Sublimation puzzle	200°C	low - medium	50s
Sublimation mouse pad	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 the thickness of the material)

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

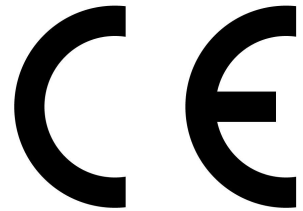
Note for textile finishing processes: After the pressing process, textiles must cool off before any media can be removed from the transfer material. The hot glue in the transfer material doesn't develop its adhesive strength until cooled off. If the glue does not stick in its cold state, this may indicate that the pressing procedure was too cold or too short.

Technical data

Heat press	TPD7 PREMIUM
Working area size	2 x 40cm x 50cm in portrait mode
Max. temperature	225°C.
Max. preset time	999s
Max. contact pressure	600g/cm ² , max. 10bar
Pressure setting	Configuring pneumatic pressure on the manometer
Power supply	AC voltage 230V / 50Hz - 60Hz, 2.5kW
Environment	+5°C - +35°C / 30% - 70% relative humidity
Weight	125kg
Dimensions (W x H x D)	90cm x 134cm x 84cm

Declaration of conformity - Statement of Conformity

We hereby declare under our sole responsibility that the product referred to in "technical data" complies with the provisions of the following directives and standards:



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

- EC directives / 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)
- Standard / Standard: EN 60204-1:2006

Technical documents at / 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