



OPERATING INSTRUCTIONS

for the heat press

Secabo TPD12

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.

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Brief overview

Secabo TPD12 pneumatic heat press

The Secabo TPD12 is an outstanding production machine for large-scale productions in the field of sublimation, textile finishing and other transfer technologies up to a size of 100cm x 120cm. The pneumatic double plate heat press features a heating capacity of 9.0 kW and designed to provide a maximum pressure of 4 bars, which corresponds to the 140g/cm² or 1,700kg when using the XXL heat plate. This means, that the TPD12 is perfectly equipped for large runs of high quality large format transfers. The two base plates are superimposed on an electric linear system specially designed to retract one base plate into the heat press, while simultaneously exposing the other base plate. This feature serves to increase efficiency by enabling operators to remove a finished transfer object and/or prepare the next transfer object at the same time, that the other base plate is inside the transfer area within the TPD12's case. The user can choose different modes of operation, namely automatic or manual. In each case, operators are offered protection from injury by a wide range of safety equipment, including emergency shutoff and two-handed operation. The TPD12 facilitates a means for profitable and efficient production of large-scale transfers in large quantities.

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 TPD12 in tank volume and maximum pressure. Only use pressure tanks that possess the necessary TÜV-certificates.

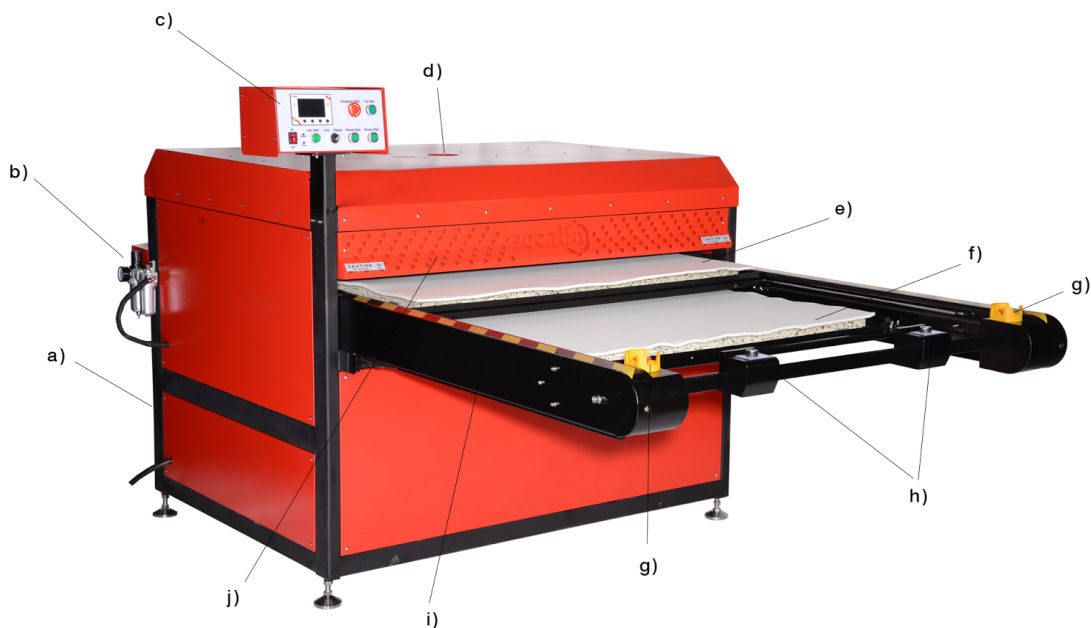
If you cannot observe one or more of the safety precautions above, or if you are not sure whether all points are satisfied, please contact our Technical Support Department.

Scope of Delivery

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

Article	Quantity
TPD12 heat press	1
Pneumatic adapter for air compressor connection	1
Instruction manual (download-link: http://www.secabo.com/en/support/)	1

Machine description



- a. master switch, fuse (not shown)
- b. manometer, oil- and drain valve, pneufit connector for compressed air
- c. rocker switch, controller for time and temperature, control panels
- d. flange for connecting a suction
- e. upper working surface
- f. lower working surface
- g. emergency stop
- h. buttons for two-hand operation
- i. linear system
- j. heating plate (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.

Besides the controller for temperature and time the TPD12 has following further control elements:

Toggle switch On/Off (panel)	Switches on the press
Toggle switch Speed Control (back side)	Power up of the motors for the sledges
Rotary control speed control (back side)	Speed regulation of the sledges
Rotary switch auto/ Manual (panel)	Change between manual and both automatic modes
Manual Start (panel)	Start of the heating process in manual mode
Upper Plate (panel)	Retracting of the upper plate in manual mode
Bottom Plate (panel)	Retracting of the lower plate in manual mode
Auto Start (panel)	Activation of two-hand operation
2x Start (front end)	Buttons for two-hand operation in semi-automatic mode
2x Emergency Stop (front side)	Emergency stop
Heat Start (Panel)	Start heating process

Operation

Pneumatic connection

- Connect the TPD12 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 TPD12 heat press. The other end of the adapter will be connected with the compressor. Charge the compressor with 3-4 bar.
- Set the desired pneumatic pressure on the manometer of the TPD12 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 4 bar.

Power supply

- Connect the heat press to a 400 V power socket (3P+N+PE) 32a via a 32 amp plug using the connection cable supplied. It is recommended to have the TP10 connected by an electrician. It is mandatory to assign the right lead of cables.
 - brown, black and grey = phases L1, L2 and L3.
 - blau = neutral conductor
 - green/yellow = earth

Operation and setting

- Switch on the press with the “On/Off” button at the main controller.
- The motor for the transport of the base plates has to be switched on by the toggle at the back of the TPD12 in the “Speed Control Unit”. The controller to adjust the speed of the sledge is above the switch.
- The recent set parameters for time and temperature are preset.
- The press starts heating up after the “Heat Start” button has been pressed. The heating process can only be stopped though turning off the press!
- To adjust time and temperature follow these instructions.
 - Press the OK button.
 - Use the arrow keys to switch between °C and °F. Confirm by pressing OK.
 - Use the arrow keys to adjust the temperature and press OK.
 - Use the arrow keys to adjust the pressing time in seconds and press again OK.
 - The press heats up to the set temperature.
- Three different operating modes are available.
 - Manual mode
 - a. The manual mode can only be operated through the main controller.
 - b. Turn the rotary switch on “Manual”.
 - c. The upper plate moves to the inside of the press after pressing the “Up-Plate”- button.
 - d. The lower plate moves to the inside of the press after pressing the “Bottom Plate”- button.

- e. As soon as the respective end position is reached, the pressing process can be started.
- f. The pressing process is triggered by pushing the “Manual Start”- button using the preset parameters.
- Semi-automatic mode
 - a. Turn the switch on “AUTO” and press the “Auto Start” button and the semi-automatic mode is activated. The “Auto Start”- button switches on “Start”- button of the two-hand operation.
 - b. The actual control of the semi-automatic mode is operated by the two-hand control at the front.
 - c. By pressing both “Start”- buttons at the same time the base plates moves to the inside of the press. After reaching the end position is reached the pressing process starts automatically.
- Fully automatic mode
 - a. De-activate two-hand operation by pressing the “Auto Start”-button.
 - b. Turn the rotary switch on “Auto”.
 - c. The base plates moves to the inside of the press. After the end position is reached the pressing process starts automatically.
 - d. After the end of the pressing process with set parameters for time and temperature the base plates change places!
 - e. After the end position is reached the pressing process starts again.
 - f. To end the fully automatic mode turn the rotary switch on “Manual”.

Operating transfers

- Place the transfer objects on the base plate and push both press buttons of the two-hand-operation.
- The timer starts running as soon as the press is closed.
- After the set time has expired, the TP10 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
- The settings cannot be changed during pressing.
- Each time the pressing process is completed, the counter display increments by one after the set time has expired.

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 and dispose it.

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.

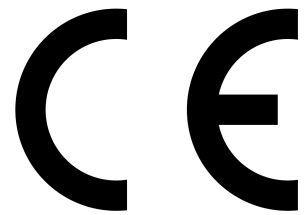
Note for textile work: After pressing, allow textiles to cool down before removing any type of backing from the transfer material. The hot glue in the transfer material develops its adhesive force only in the cold state. If the adhesive does not stick in the cold state, it may have been pressed too cold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

Technical data

Heat press	TPD12
Working Area	100cm x 120cm
Max. temperature	225°C
Max. time setting	999s
Max. pressure	140g/cm ² , max. 4bar, 1700kg
Pressure setting	Setting of pneumatic pressure on the manometer
Power supply	3P+N+PE, 9,0kW. It is recommended to have the TPD12 connected by an electrician.
Environment	+5°C - +35°C / 30% - 70% humidity
Weight	782kg
Dimensions (B x H x T)	275cm x 170cm x 150cm

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'.

Dipl. Ing. Fabian Franke

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

Dipl. Ing.(FH) Bernhard Schmidt