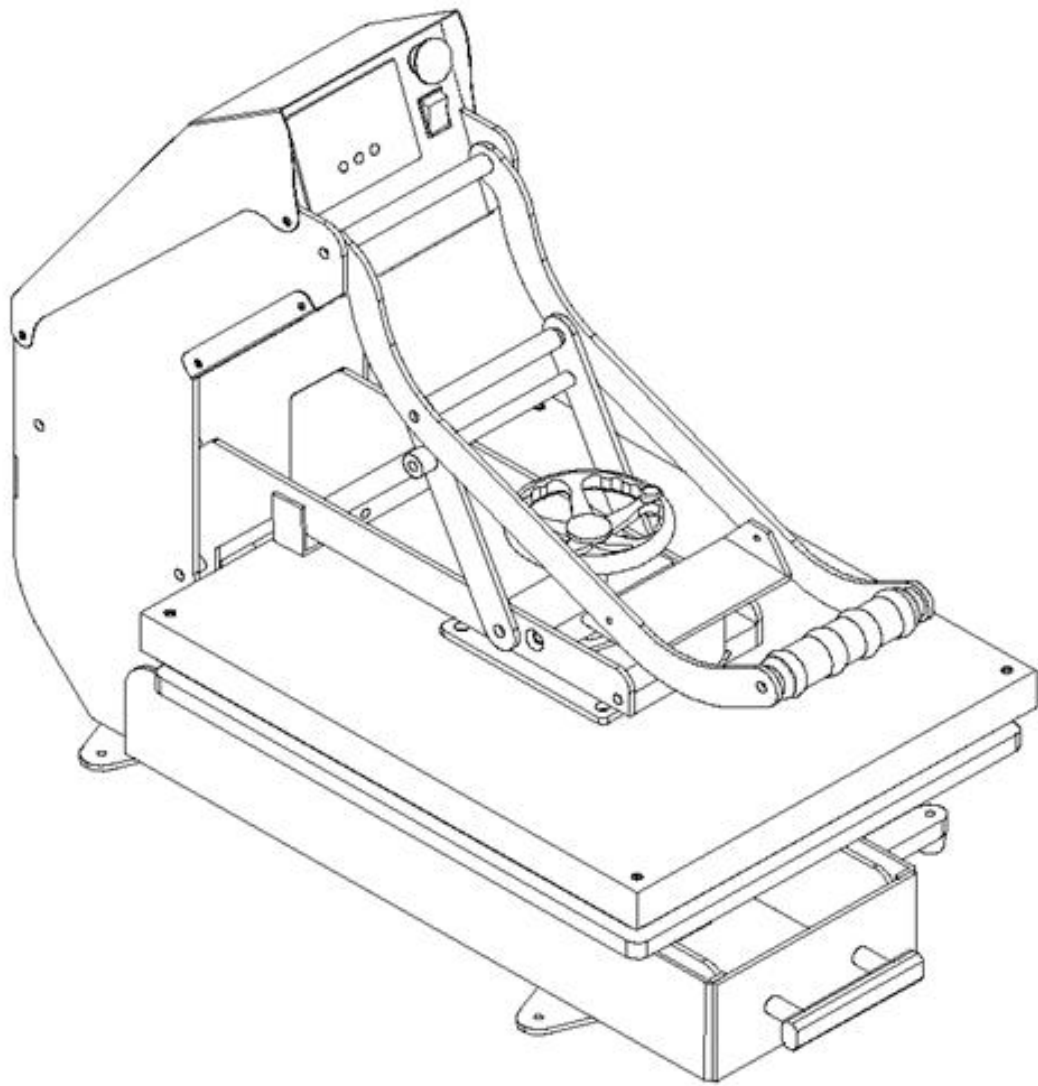


# SENKO Auto Open Heat Press Manual

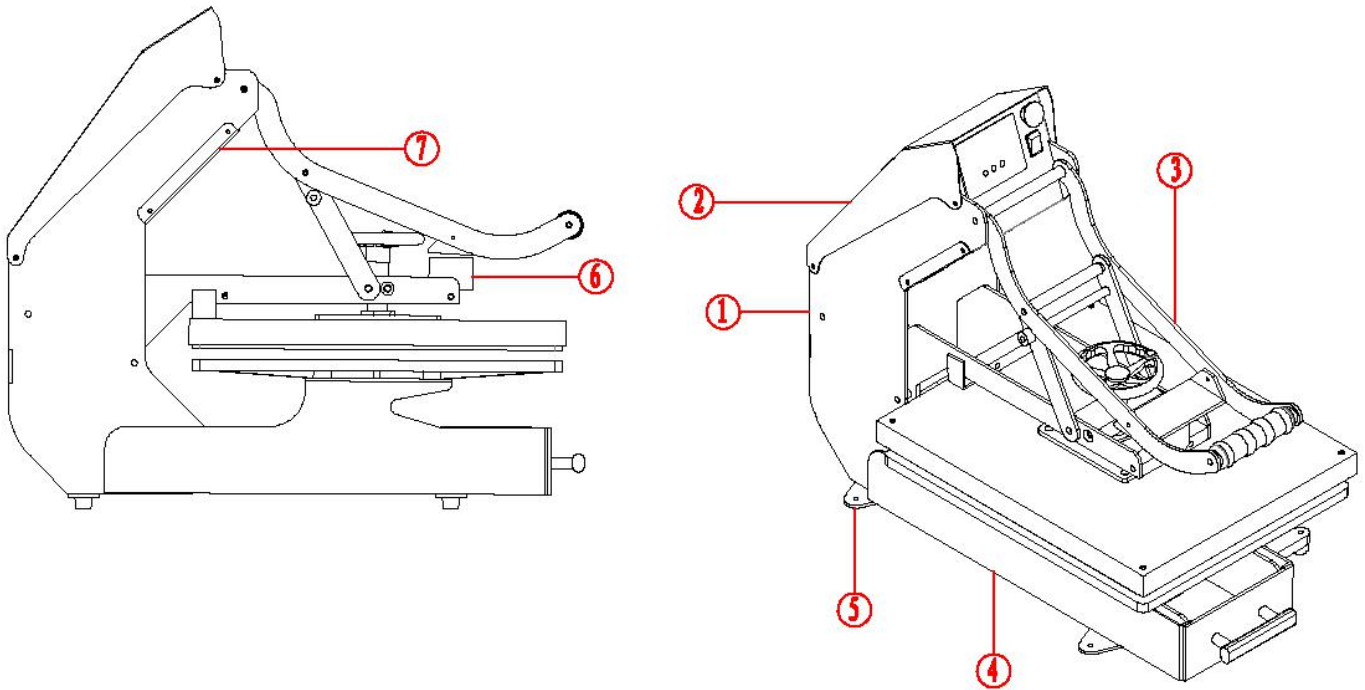
## Model No.:SENKO-15A/20A



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# I. Assembly Drawing



- |                            |                |                 |
|----------------------------|----------------|-----------------|
| ① Electronic Case          | ② Back Cover   | ③ Handle Frame  |
| ④ Slide Rail               | ⑤ Machine Foot | ⑥ Electromagnet |
| ⑦ Electrical Parts Bracket |                |                 |

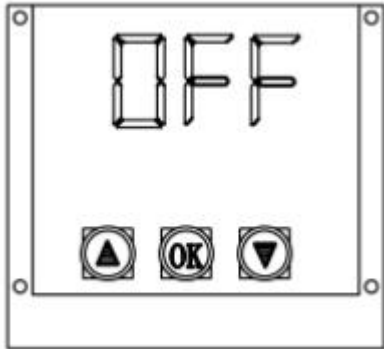
# II. Technical Parameters

1. Model No.: SENKO-15A/20A
2. Machine Dimensions: 780\*680\*400mm
3. Heat Platen Size : 15"X15", 16"x20" (38\*38cm,40\*50cm)
4. Printable Articles Max Size: 400\*500\*10mm
5. Voltage: 220V/1Phase; 120V/1Phase
6. Power: 220V/1.8KW; 120V/1.2KW
7. Recommend Setting: 30~280s; 180~200°C  
Time Range: 0~999s  
Maximum Temp: 225 C°
8. Packing size:102\*64\*82cm
9. Gross weight: 81.06kg

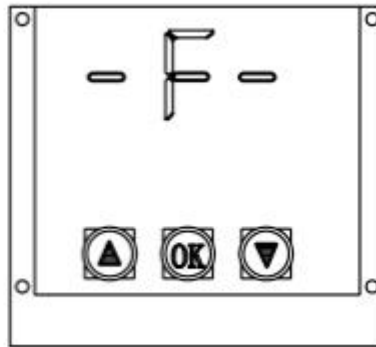
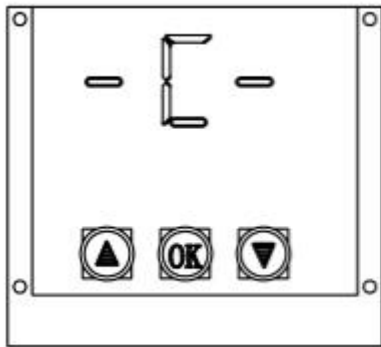
# III. Operation Process

## GY-04 Operation Instruction

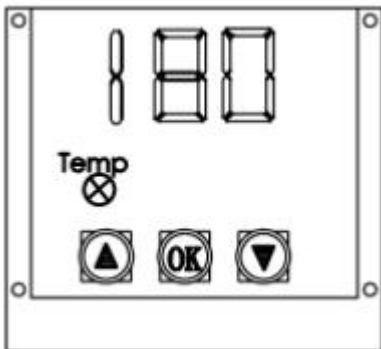
1. When you turn on the heat press machine, the display shows “OFF”.



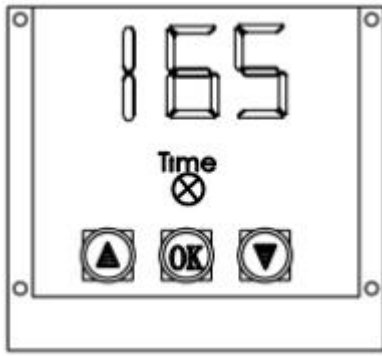
2. Press the “OK” button will show the degrees Celsius “C”. You could use the Up or Down button to switch between degrees Celsius and degrees Fahrenheit.



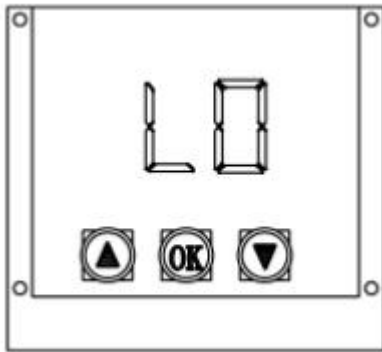
3. Press “OK” button to enter TEMPERATURE setting. When the TEMP indicator blinks, use Up/Down button to set the required temperature. (Temperature adjustable range: 100-225 C/212-437 F)



4. Press “OK” button to enter TIME setting. When the TIME indicator blinks, use Up/Down button to set the required time. (Time adjustable range: 0-999S)



5. After finishing above-mentioned settings, press “ OK ” button to enter the heating mode. If the temperature is below 100C/212F, then the display reads “LO”(low temperature).



6. If you need to adjust the settings during the heating mode, you could repeat step 2 to step 5 to do the adjustment.

7. When the heat platen has settled into its desired temperature, press down the heat platen, then the timer will automatically start counting down and CD-L indicator blinks. The timer will begin to sound once it reaches 3 seconds. The warning is meant to prepare the user to release the handle once the time reaches 0 seconds. When the handle is lifted, the timer will automatically sound off.

8. Long press the digital controller for 4-5 seconds, then can enter the engineering model:

P-5: Temperature Difference Calibration Mode, calibration range is -99 to +99

P-6: Intermittent heating in advance before setting, setting range is from 1 to 20 Sec.

This function is to set the heating time and pause time after the machine enter the constant temperature mode. The setting parameters is different according to different size of heat platen.

P-7: Constant temperature in advance before setting, setting range is from 1 to 9 degree.

This function is to set when the machine will enter the constant temperature mode. You could set a temperature value that you want to enter to constant temperature before it reach the setting temperature.

For example, the setting temperature is 180°C and P-7 is 10°C, then when the temperature reaches 170°C, it will enter the constant temperature mode, heating and pause in cycle to avoid overheat.

P-8: Constant temperature mode, when reach the setting temperature, the machine will stop heating for 1 seconds then will keep heating for few seconds, setting range is from 0 to 9 Sec.

P-9: Countdown mode: “No”means when the machine work, it will count down, “Yes”means when reach the setting temperature, the machine will enter the countdown mode.

### **3. Printing methods**

Setp 1: Make sure the cord is connected well to the wall socket. Place the object (i.e. T-shirt) on press bed, and tranfer paper with images facing down the object, adjust pressure to your requirement, and turn on the power.

Setp 2: Set the temperature and time required, then temperature starts to rise.

Setp 3: When the temperature rises to the setting temperature, the buzzer sends out sounds; then close down heat platen (meantime the sounds stop) and starts to transfer.

Setp 4: Then the time counter is on, once time is up, the upper heat platen will auto open automatically.

Setp 5: Consult the Transfer Paper instructions on whether to peel cold or hot, Here are suggested Pressing time guidelines for different transfer paper.

Ink-Jet Transfer Paper (fabric) 14-18 seconds

Laser Copier/Printer Transfer Paper (fabric) 18-25 seconds

Sublimation Transfers (onto Fabrics) 25-30 seconds

Sublimation Transfers (onto FR-Plastic/Woods) 60-70 seconds

#### **NOTE:**

- 1) Please switch off the machine and unplug the power cord when the machine is not in use.
- 2) The heat platen will cool down to the room temperature, if heat press stays unuse for more than 30 minutes.
- 3) The heat-releasing fan will automatically starts when the temeprature of heat platen reaches 80 degree C (176 degree F). It helps to reduce the temperature of electrical parts and prolong the service life of them.
- 4) For better maintenance of heat press, the maximum setting temperature is 210 degrees C (410 degrees F).
- 5) To avoid re-heating the first transfer when printing double sided T-Shirts, insert a sheet of cardboard in between the shirt, adjust the height to less pressure, then press.
- 6) Heat platen may pivot slightly back and forth rotationally. This is due to movement allowance within the clamp assembly, and is normal.

## IV. Maintenance

### 1. No action after turn on the machine

- 1). Check the plug whether it connects well or whether it is broken.
- 2). Check the power switch or digital controller whether it is broken.
- 3). Check the fuse whether it has been burnt out.
- 4). Indicating light is on, but no display on screen, check the 5 cable of Railway transformer. If it's loosening, showing the problem is poor connection. If they connects well, showing that the Transformer is faulty.

### 2. The display screen are working well, but no temperature increasing on the heat platen.

- 1). Check whether the thermocouple of the heat platen touches well. If the thermocouple is loose, the display will show 255 and machine keeps beeping.
- 2). Check if the indicating light of solid-state relay is on, if not, check if the relay or digital controller is broken.
- 3). If you already changed the new solid-state relay but the heat platen still can't heating up, check if the heat platen is faulty or the heat platen's power cable is loose, need to change by new heat platen.

### 3. The heat platen works well, but suddenly the display screen show 255°C.

- 1). Check whether the thermocouple of the heat platen touches well.
- 2). If the thermocouple touches well but still show 255°C, then it is faulty.

### 4. The machine is heating during 0~180°C, but display number jumps to above 200°C or 300°C suddenly, or the numbers on display jumps irregularly.

- 1). Check whether the thermocouple of the heat platen touches well.
- 2). If the thermocouple is good, It shows that the program of digital controller is broken, which namely IC or is broken, need to change by new controller.

### 5. The temperature is out of control: Set 180°C, but the actual temperature is above 200°C.

- 1). It means the solid-state relay is broken, out of control, need to change the relay.
- 2). Or the digital controller is faulty and it keeps conveying electric to relay, need to change controller.

### 6. The setting temp and time becomes abnormal after exchange the heat platen

- 1). Please reset the temp and time according the operation process manual.

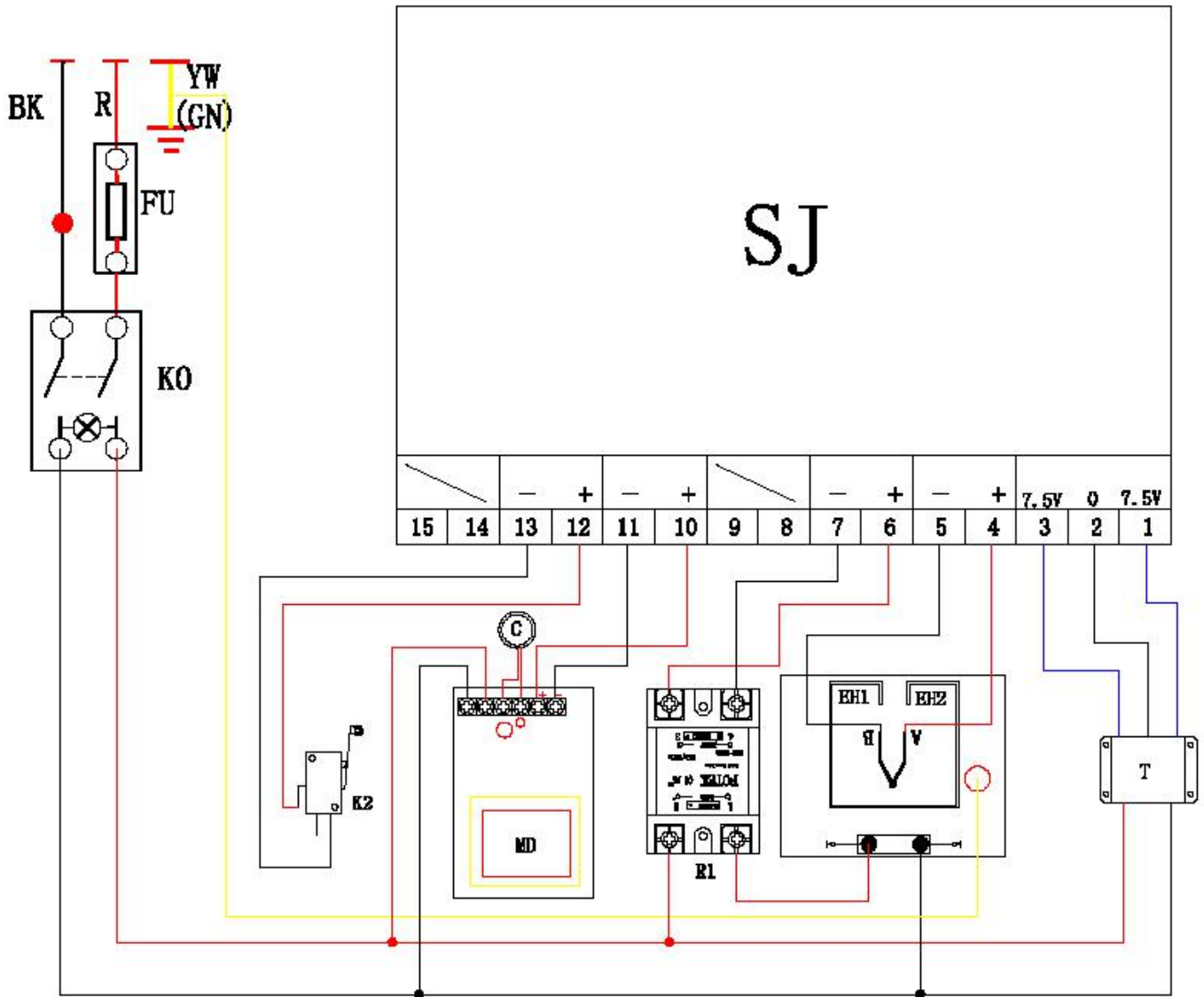
### 7. Other notice

- 1). In order to prolong the machine service life, please add the lubrication oil regularly on the joints.
- 2). In order to keep the heat platen's good transfer effect, you need to protect the heat platen carefully whenever you are using it or not.
- 3). Please keep the machine in dry place.
- 4). If you are not able to solve the electrical parts problem, please kindly contact the supplier and get technical support.

## V. Trouble shooting for transfer print quality

1. If the print color is pale: the temperature is too low / the pressure is not correct / or not pressed long enough.
2. If the print color is too brown or the transfer paper is almost burnt: reduce the setting temperature
2. If the print is blurring: too much transfer time causes proliferation.
3. If print color is different/ partial transfer effect is not good enough: the pressure is not enough / or not pressed long enough / or poor quality transfer paper.
4. If transfer paper stick to the object after transfer: the temperature is too high/ or poor quality printing ink.

## VI. Circuit Diagram



Ko.: Power switch

T:Transformer

EH1 EH2: Heat Pipe

C:Magnet

FU: Fuse

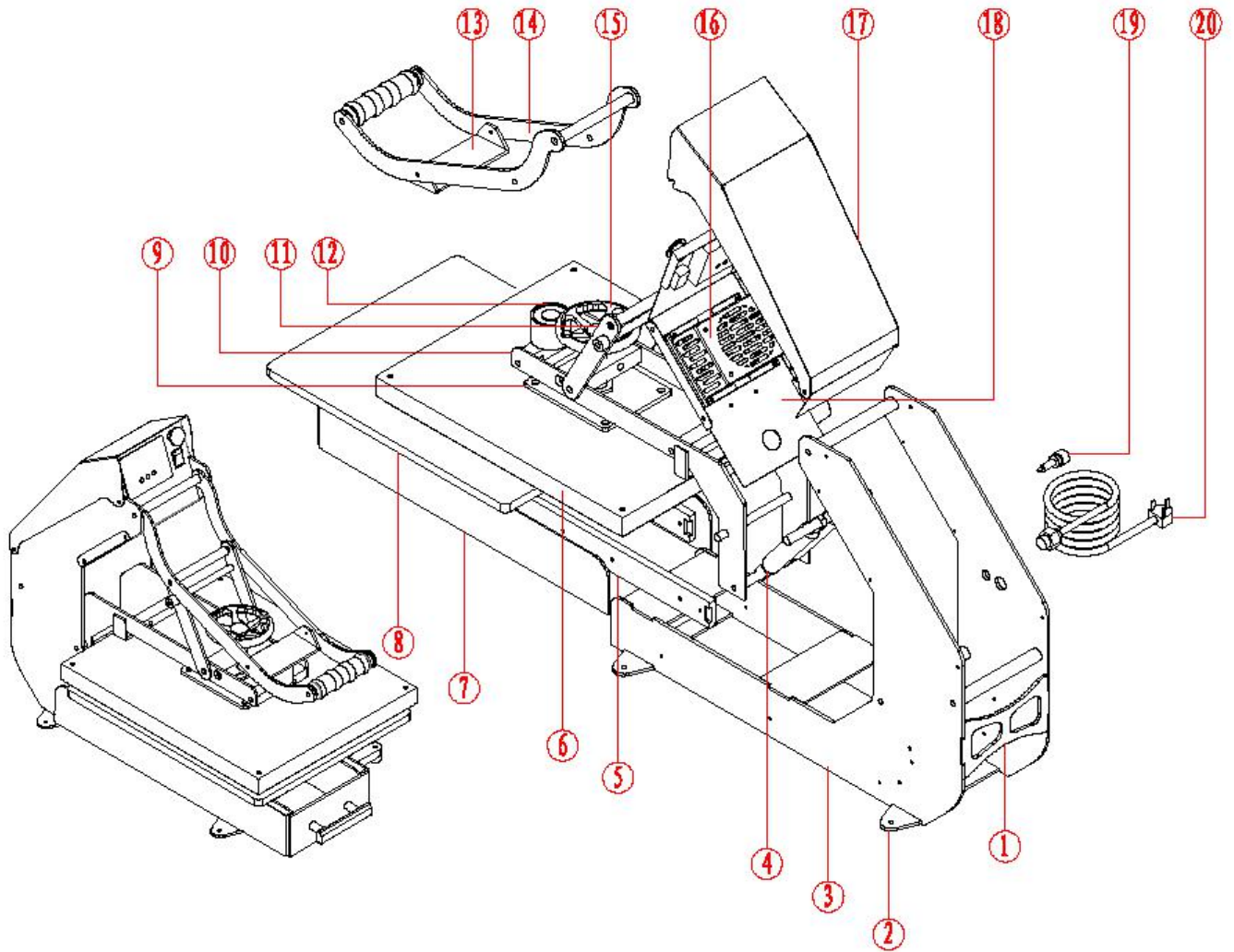
MD:Magnet Driver

K2: Limit Switch

R1: Relay

SJ: Digital Controller

## VII. Explosion View



Serial No.	Part Name	Qty
1	Welded Plate	2
2	Machine Foot	2
3	Machine Frame	2
4	Compression Spring	2
5	Slide Rail	2
6	Heat Platen Cover	1
7	Side Slide Board	2
8	Under Plate	1
9	Adapter plate	1
10	Davit Arm	1

11	Connecting Piece	2
12	Electromagnet	1
13	Magnetic Suck Plate	1
14	Handle Bar Grip	2
15	Press Adjustment Gear	1
16	Electrical Parts Bracket	1
17	Back Cover	1
18	Electrical Parts Bracket	1
19	Fuse Holder	1
20	Power cord	1