



## **OPERATING INSTRUCTIONS**

for the heat press

**Secabo TC D5**

Congratulations on purchasing a Secabo heat press!

Please read these operating instructions carefully so you can start production with your press without problems.

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## 1 Brief overview

### **Secabo TC D5 pneumatic double sheet transfer press**

Using the Secabo TC D5 double sheet transfer press, all common hot transfer processes (flock, flex, sublimation, transfer, InkJet-flex, chromablast etc.) can be conducted professionally and with highest productivity. The desired settings can be set easily with the digital controllers for temperature and time. The pneumatic pressure can be regulated smoothly with the manometer. With the restriction valve the speed at which the press is opened and closed can be adjusted.

### **Short overview Secabo TC D5 transfer press**

- Pneumatic double sheet transfer press for medium and large batches.
- Fast and simple time and temperature specification, comparison of target and performance values with digital display.
- Flexibly adjustable contact pressure by manometer with oil and water separator.
- Two-hand operation emergency off switch.
- Restriction valves for the regulation of lifting and lowering speed.
- CE-certificate, RoHS-certificate, inspected according to German safety standards.



## 2 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 TC D5 in tank volume and maximum pressure. Only use pressure tanks that possess the necessary TÜV-certificates.

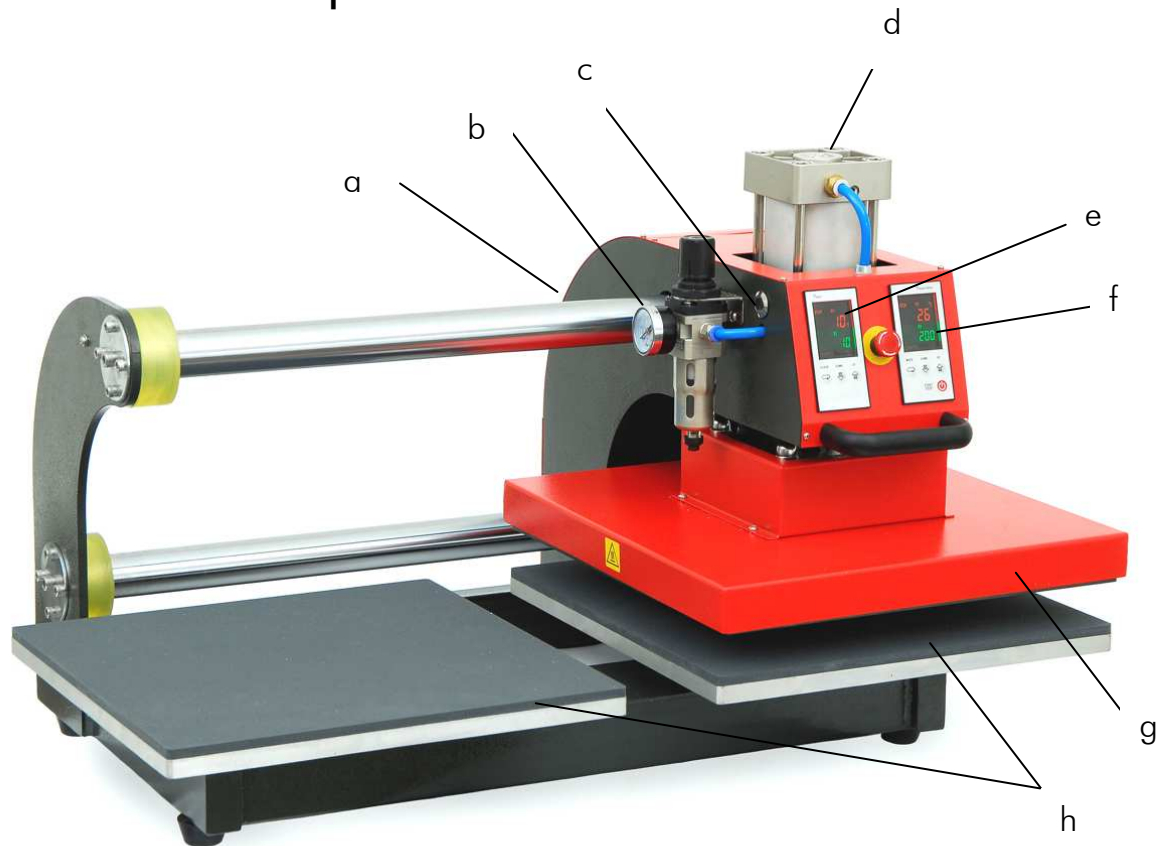
**If you cannot observe one or more of the safety precautions above, or if you are not sure whether all points are satisfied, please contact our Technical Support Department.**

### 3 Scope of Delivery

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

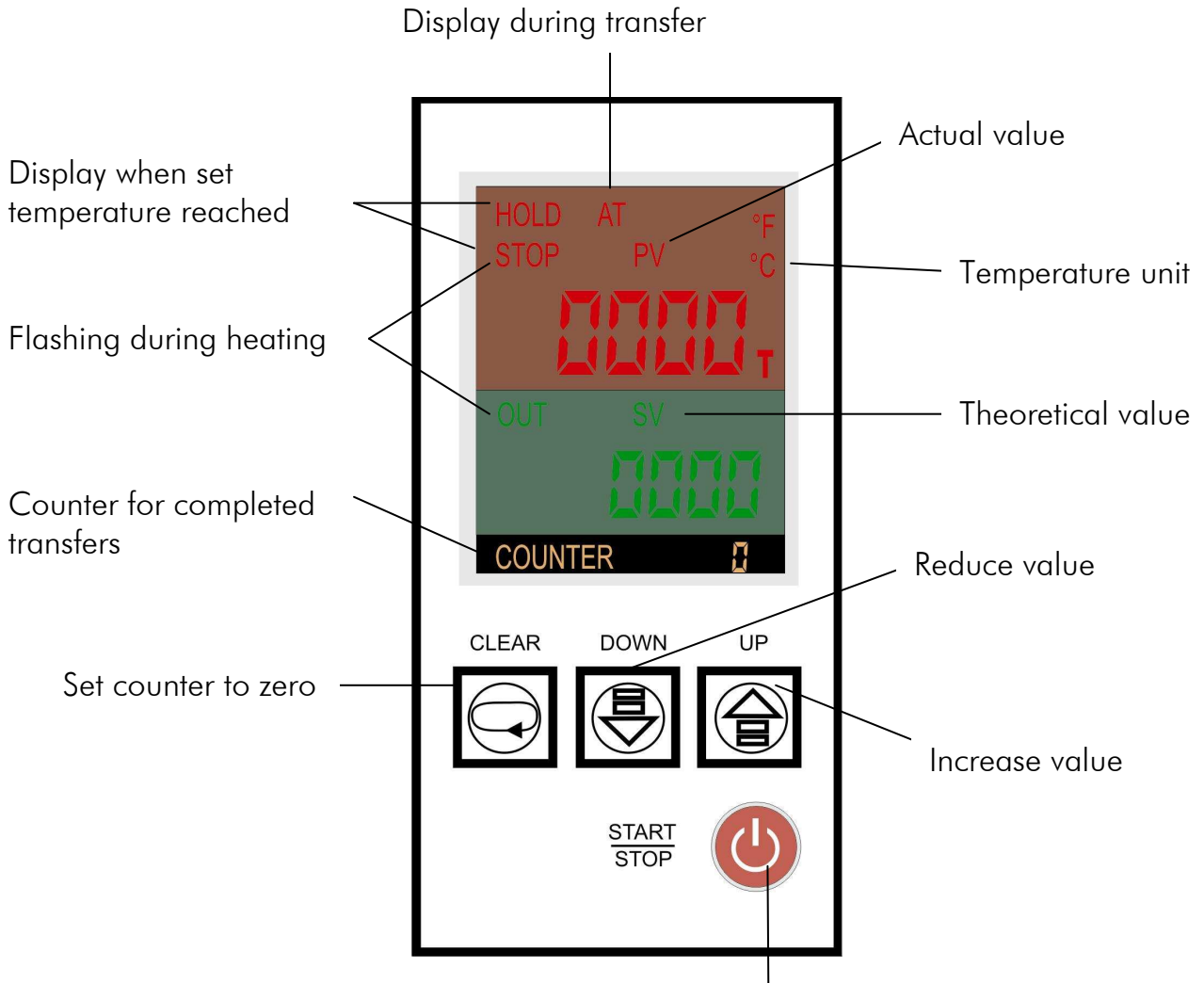
Article	Quantity	
Heat press	1	
Pneumatic Adapter	1	
Instruction manual	1	

## 4 Machine description



- a) Rocker switch, Fuse, Connecting cable
- b) Manometer, Drain valve
- c) Two Hand Control Buttons
- d) Pneumatic Cylinder
- e) Time Controller
- f) Temperature Controller
- g) Heating Plate
- h) Double Workplate

## 5 Controllers



“START”

Press button to start heating

“STOP”

Press button again to stop heating



## 6 Operation

- Connect the TC D5 to your pressurized air compressor with the included pneumatic adapter. Charge the compressor, usually with 6-8 bar, up to 10 bar is possible.
- Connect the heat press to a 230 V power socket using the connection cable supplied.
- Switch on the press with the red rocker switch.
- "STOP" is displayed on both controllers.
- Theoretical value "SV" and actual value "PV" are displayed. The theoretical value can now be set on the individual controllers.
- Use "UP" or "DOWN" to set the desired temperature on the temperature controller and to set the desired time on the time controller.
- Press the "START/STOP" button to start heating to the set temperature. "STOP" and "OUT" is displayed alternately on the temperature controller while the press is heating.
- Actual value PV rises to the set temperature.
- A signal is heard when the set temperature is reached. "STOP" and "HOLD" are displayed on the controller; the press is ready for operation.
- You can now make the first transfers. The timer starts running as soon as the press is closed with the press lever. "AT" is displayed on the time controller during the pressing process.
- Set the desired pneumatic pressure on the manometer of the TC D5 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 6 bar.
- Bring the press head into an end position right or left. Pay attention that the magnet keeps the head on the end position.
- Now use both hand to push each one of the two silver buttons on the left and right of the press head to lower the heating sheet.
- After the set time has expired, the TC D5 opens automatically.
- Now the press head can be pushed to the other side and closed there again, if necessary.
- After expiration of the set time a warning signal sounds.



- You can adjust the contact pressure by turning the large hand screw on the top of the press to increase or reduce the lever path. Turning it clockwise reduces the contact pressure, while turning it anticlockwise increases the pressure.
- 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.
- You can reset the counter by pressing "CLEAR". "COT" is displayed on the time controller. Press "CLEAR" for longer than 2 seconds. If you press it for less than 2 seconds, the action will be cancelled.
- The "MODE" function button is only used for maintenance purposes and does not affect press operation.
- Operating the restricting valves
- On the right side of the press head there are two silver screws with which the restricting valves to open and close the heating sheet can be adjusted.
- If the screws are screwed out, this slows down the lifting and lowering process.
- When the screws are screwed in, the TC D5 accelerates the lowering and lifting of the heating sheet.
- Fix the respective setting with the corresponding counter nuts by tightening them by hand.

**Note: Please note that a certain time is required before the press cools down after it is switched off.**



## 7 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.



## 8 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 - 170°C	medium-high	25s
Sublimation flex	180°C - 195°C	medium-high	10s - 35s
Sublimation on ceramic mugs	200°C	medium-high	150s - 180s
Sublimation on tiles	200°C	high	120s - 480s <small>(depending on thickness of material)</small>
Sublimation on jigsaw puzzles	200°C	light-medium	25s
Sublimation mousepads	200°C	medium	20s - 40s
Sublimation on textiles	200°C	medium-high	30s - 50s
Sublimation on metal plates	200°C	high	10s - 50s <small>(depending on thickness of material)</small>



**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.



## 9 Technical data

<b>Heat press</b>	Secabo TC D5
<b>Type</b>	Linear pneumatic double sheet transfer press
<b>Work surface size</b>	2x 38 cm x 38 cm
<b>Max. temperature</b>	260°C
<b>Max. time setting</b>	9999s
<b>Max. contact pressure</b>	350g/cm <sup>2</sup>
<b>Pressure adjustment</b>	Setting pneumatic-pressure on the manometer
<b>Power supply</b>	230 V / 50 Hz – 60 Hz AC, 2,2 kW
<b>Ambient conditions</b>	+ 5°C - +35°C / 30% - 70% humidity
<b>Weight</b>	82 kg
<b>Dimensions (W x H x D)</b>	84 cm x 52 cm x 55 cm
<b>Scope of Delivery</b>	Heat press, power cable, pneumatic adapter, operating instructions



## Konformitätserklärung Statement of Conformity



Hiermit erklären wir in alleiniger Verantwortung, dass das unter „9. Technische Daten“ genannte Produkt mit den Bestimmungen der folgenden EG-Richtlinien und Normen übereinstimmt:

We herewith declare under sole responsibility that the under „9. 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:

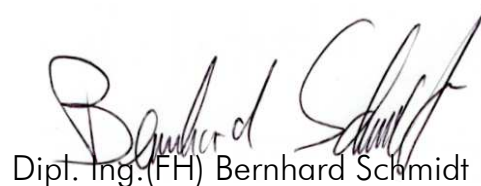
EN 60204-1:2006

Technische Dokumente bei / Technical documents at:

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