

S-450P & S-650P

Auto Opening with Pressure Readout
15"x15" & 16"x20" Heat Transfer Machines

OWNER'S MANUAL



S-650P shown



HIX CORPORATION

For Customer Service, Call **1-800-835-0606**

or Visit www.hixcorp.com

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BEFORE warranty repair you MUST get Prior Authorization:

RECEIVING

SHIPPING OR RETURNS

NOTE: Save all of your shipping/packing materials.

DO NOT RISK COSTLY SHIPPING DAMAGE!

SHIP ONLY IN ORIGINAL BOX.

1. Fasten machine to plywood shipping base with bolts provided.
2. Tie or tape handle securely to base.
3. Place in original box, and put side liner and top liner in place. Fold in flaps and seal the box. (Additional bottom boards, box and liners may be obtained from your supplier for a nominal cost.)

UNPACKING

Remember to save all packing materials - including box, liner and board. You may need these for shipping your machine or if a repair is necessary in the future.

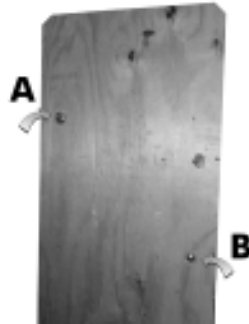
INSPECTION

Inspect your machine for hidden shipping damage. Contact the delivery company immediately, should you find damage.

INSTALLATION

INSTALLATION

1. Remove plywood shipping base bolts (see **A** and **B**) and screw on feet provided.



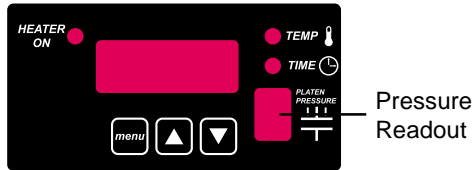
CAUTION: Handle **must be tied** to base before moving or shipping.

2. Plug the machine into the correct grounded electrical outlet. (The HT-600 requires a 20 amp receptacle.)

WARNING: When using an extension cord, use 12 or 14 ga.-3 conductor. Maximum length, 25' (7.62 m).

OPERATION

DIGITAL TEMPERATURE & TIME INSTRUCTIONS



1. Turn on the machine by pushing the on/off switch.
2. To change or set the temperature, press the menu button on the digital control. The light next to “TEMP” will light. Press the up s, or down t, button to your desired setting.
3. To change or set the time, press the menu button on the digital control. The light next to “TIME” will light. Press the up s, or down t, button to your desired setting.
4. When you have your desired settings **press the menu button a third time to lock in your settings** otherwise the previous settings will still be used.
5. Wait for the machine to reach your preset temperature by monitoring the display temperature until it matches the set temperature.

Daily cycle is displayed by holding the up key while powering up. It will continue to display counts (up to 9999) while the up key is pressed. When the key is released it goes to regular mode. To reset the daily count press the down key while still holding the up key.

PROGRAM THE MACHINE FOR SHUTDOWN

1. With the main power off, push in and hold the “Menu” button.
2. With the “Menu” button held in, apply power and continue to hold the “Menu” button in for about 3 seconds, and then release the “Menu” button.
3. Press the “Menu” button four more times until you see “SEC” in the display. While still holding the “Menu” button down while displaying “SEC” press the “Down” button.
4. Next release both the “Menu” and “Down” buttons.
5. Next press the “Menu” button one more time so you see “SDN” in the display.
6. Press “UP” or “Down” button to change this value as shown below. Once the value is change to what is desired, simply turn the power to the machine off and back on to store the new setting.

Value of 0 (default) to 12 hours (displayed as 120) adjustable in 1/2 hour increments. 5=1/2 hour, 10=1 hour, 15=1-1/2 hours etc.

If after this amount of time elapses the start switch is not closed the heater will shut off and the display will show “OFF” on the display. One minute before the controller shuts the heat down the beeper will beep 5 times to alert the user that the heat is about to shut down. To prevent this from happening, close the heat head to activate the start switch and cancel the shutdown timer. Once the machine is in “OFF” mode, close the heat head or press any of the menu or UP/DOWN buttons on the timer to take the machine out of the “OFF” mode.

OPERATION

PRESSURE

1. The pressure control knob, located on the top of the machine, should be set so that the heat head will lock down firmly.
2. Pressure is reduced by turning knob (with machine open) **counter-clockwise** and increased by turning it **clockwise**.



3. The amount of platen pressure can be monitored on the controller with the display labeled "Platen Pressure." A value between 0-9 will be displayed when the machine is closed indicating the amount of platen pressure on the machine. Values of 0-3 indicate "light" pressure, 4-6 "medium" pressure and 7-9 "heavy" pressure. If the value exceeds 9 then a "-" will appear in the display indicating that the maximum value that can be displayed has been exceeded.

NOTE: Adjustments may be required from one garment to another and will vary to achieve the desired result.

CAUTION: Excessive pressure can cause structural damage, voiding the machine warranty!

Your semi automatic press features Automatic Opening at the end of each count down timer setting. The press will simply release and open. **DO NOT** pry or try to open press, there is an emergency release lever atop the handle if you ever need to interrupt the countdown and get the press open. **CAUTION:** Do not lean over press when cycle is complete. Injury could occur.

Manual/Emergency release



TRANSFER APPLICATION

1. Set the temperature, time, & pressure to the desired settings as instructed on page 3. **Again, always** consult your specific transfer recommendations. Typical settings are; **Cold Peel:** 350°F (177°C), 15 seconds and **Hot Split:** 375°F (190°C), 10-12 seconds.
2. Align garment on the lower platen and smooth out the wrinkles.

NOTE: Wrinkles may be removed by bringing heated platen in contact with the garment before the transfer is positioned. Push the **platen release** button provided on the front of the lower right frame tube of the machine to interrupt the normal cycle and release the upper heat platen.

3. Position the transfer, then pull the operating handle down until the lower platen engages (approx. 1 second) then release. At the end of the time selected, the machine will open automatically.
4. Continuously peel the paper off the transfer away from your garment.

NOTE: Do not fold the transfer back on itself. Successful transfer work depends on the correct balance of time, temperature and pressure. The type and thickness of the material and the kind of transfer being used will determine what settings are necessary.

If a hot peel/split transfer is being applied, immediately peel the paper after the machine has opened. **DO NOT** allow the transfer to cool. If a cold peel transfer is being applied, rub the transfer with an eraser or cloth and allow to cool for 5-10 seconds before removing the release paper.

NOTE: Specific application instructions are enclosed with transfers.

MAINTENANCE/REPAIRS

RELAY BYPASS

WARNING: Before making repairs, be sure on/off switch is off and machine is unplugged!

1. Remove the back cover of the machine.
2. Remove wire #26 from terminal #2 on relay.
3. Loosen terminal #1 on relay and replace wire #26 along with wire #12 under terminal #1.
4. Tighten the connection.
5. Plug machine in and turn the power switch on.

NOTE: Replace the relay if the machine starts heating. This is a test only. Do not operate machine with relay bypassed.

LUBRICATION

Your press requires lubrication every 6 months. Using 3-in-1 oil (available from your hardware store), add one to two drops of oil at the joints of all moving parts.

CLEANING HEAT PLATEN

You may clean the heat platen with steel wool, scrubbing aluminum sponge, or fine wire brush.

FUSE REPLACEMENT

WARNING: Before making repairs, be sure on/off switch is off and machine is unplugged!

1. Remove back cover of the machine and locate internal fuse holder on inside of the machine.
2. Remove blown fuse. Replace with the proper fuse.
S-450P & S-650P: 120V=MDA-15; 220V=MDA-10
3. Replace back cover of machine.

TROUBLESHOOTING

Problem: Machine won't release at the end of time.

Q. Do you hear the solenoid click when the timer reaches zero?

If yes – Reduce the pressure on the machine and see if it will release then.

If no – with a volt meter check for voltage across the solenoid coil wires when the timer reaches zero. If you have line voltage (120V or 220V) then the solenoid is bad and needs replaced. If there is no line voltage the controller is bad and needs replaced.

Does reducing the pressure fix the problem?

If no- try manually releasing the machine with the **manual release lever**.

If yes – continue to use the lower pressure setting.

Does it manually release?

If Yes – remove the solenoid cover and inspect the connecting pin on the solenoid to see if it is intact or broken. If broken, replace the pin.

If no – inspect the latch mechanism to see if it is jammed.

Problem: Platen pressure indicator not working properly.

Q. Does the platen pressure display show "0" when the press is locked down?

If yes – Try increasing the pressure

Does increasing the pressure fix the problem?

If no- Call technical support.
800-835-0606

If no – does the display show "-"?

If yes – try reducing the pressure

Does reducing the pressure fix the problem?

WARRANTY

(Effective May 1, 2008)

HIX will automatically register the equipment on the date it was shipped to you or your distributor. If the equipment was not purchased directly from HIX, but through a distributor (either domestic or foreign), please keep a copy of their sales invoice showing the serial number and date it was sold/shipped to you with this warranty. In this case, we will use the distributor's invoice date as the beginning warranty date. **STAPLE A COPY OF YOUR RECEIPT TO THIS WARRANTY** and keep in a safe place to provide verification of your warranty should a problem occur. Thank you.

Please fill in the following information and attach a copy of your receipt for your records.

Date Purchased: _____ From: _____

Model #: _____ Serial #: _____

This warranty applies to equipment manufactured by the HIX Corporation (HIX), Pittsburg, Kansas, U.S.A. HIX warrants to the original purchaser, its Ovens and Dryers, Heat Transfer Presses, Mug Presses, Mug Glazer, Retensionable Screen Frames, Textile Printers, Spot Heaters, and Exposure Units against defects in workmanship and material, except for wear and tear for a period of "One Year" from the date of purchase. HIX warrants its Accessories, Reten Splines/Hardware/Tool Kit, and Shuttle for a period of 90 days from the date of purchase. DoughXpress and Thermatrol products are covered under separate warranty.

In the event of a defect, HIX, at its option, will repair, replace or substitute the defective item at no cost during this period subject to the limitations of insurance and shipping costs stated below.

In the case of heat transfer presses (except the Mug Press, Hobby Lite), HIX warrants the heat casting for the "Life" of the machine for the original purchaser. If a part becomes obsolete at the time for repair, and/or cannot be reasonably substituted for, HIX will credit, at half the then current list price or last recorded price, only that part toward a new machine or any product HIX offers. This credit offer shall be the sole responsibility of the HIX Corporation in the event of an obsolete part.

This warranty does not cover belts, pads, mug wraps, mug press liners, canvas, rubber blankets, bulbs, glass, rod ends, turn buckles on printers, or mug press or damages due to accident, misuse/abuse, alterations or damage due to neglect, shipping or lack of proper lubrication or maintenance. HIX shall not be responsible for repairs or alterations made by any person without the prior written authorization by HIX. This warranty is the sole and exclusive warranty of HIX and no person, agent, distributor, or dealer of HIX is authorized to change, amend or modify the terms set forth herein, in whole or in part.

In the case of a problem with the equipment identified herein, HIX Corporation should be contacted during regular business hours to discuss the problem and verify an existing warranty. HIX personnel will assist the customer to correct any problems which can be corrected through operation or maintenance instructions, simple mechanical adjustments, or replacement of parts. In the event the problem cannot be corrected by phone, and upon the issuance of a return authorization by HIX, the equipment shall be returned to HIX or an authorized service representative. All insurance and shipment/freight costs are solely the responsibility of the customer, and not that of HIX, and HIX shall not be responsible for improper handling or damage in transit. Contact HIX customer service for complete return authorization information.

This expressed warranty is given in lieu of any and all other warranties, whether expressed or implied, including but not limited to those of merchantability and fitness for a particular purpose, and constitutes the only warranty made by HIX Corporation.

In no event shall HIX's liability for breach of warranty extend beyond the obligation to repair or replace the nonconforming goods. HIX shall not be liable for any other damages, either incidental or consequential, or the action as brought in contract, negligence or otherwise.

This warranty gives you specific legal rights and you may also have other rights which vary from state to state.



Manufacturers of the Finest Quality Textile and Graphics Screen Printing and Heat Transfer Equipment

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