SilverBolt

USER MANUAL

SilverBolt 1620-SA

REV 12/08/2022

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Model No. 1620-SA

SPECIFICATIONS:

Model NO: SilverBolt 1620-CS

Voltage: 110 V*

Power: 1800 W

Control Panel: LCD Control Panel

Time Range: 0~999 sec.

Temp. Range: 0~480˚F

Heating Element: 16” by 20”

Maximum pressure: 771lbs (350kg)

Packaging: Wooden crate

Gross Weight: 149 lbs (67.5 kg)

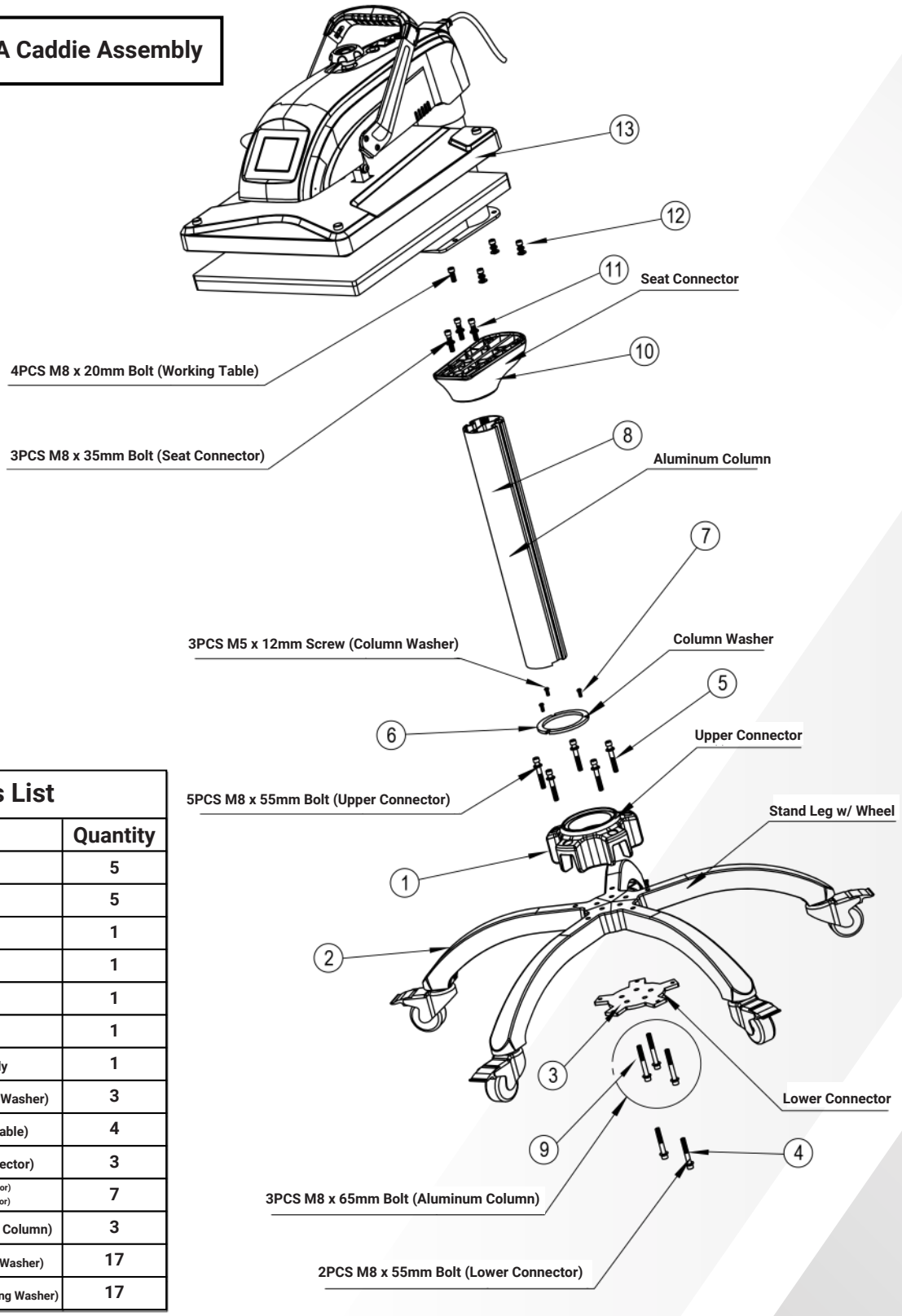
* For best results, 16” by 20” heat presses should be run on a dedicated 20-amp circuit. This provides sufficent power to quickly heat the platen, maintains consistent temperature and ensures stedy power supply to the press. Failure to do so may result in longer heating times, inconsistent platen temperatue and interrupted operation because of tripped circuit breakers.

OPERATION INSTRUCTIONS
READ BEFORE USE

1. Check the voltage before using it. The correct voltage is 110.
2. Turn off the machine when not in use, and remove the power plug from socket.
3. Grasp the handle firmly when opening.
4. Keep children away from the machine.
5. Do not touch the heating platen and platen cover after pressing while in operation.
6. Do not attempt to press products that are not intended for normal heat transfer.
7. Do not set the temperature any higher than 480°F as it may cause the press to overheat and stop working.
8. The heat press carries a ground line by default, please make sure the socket gets a ground line protector.

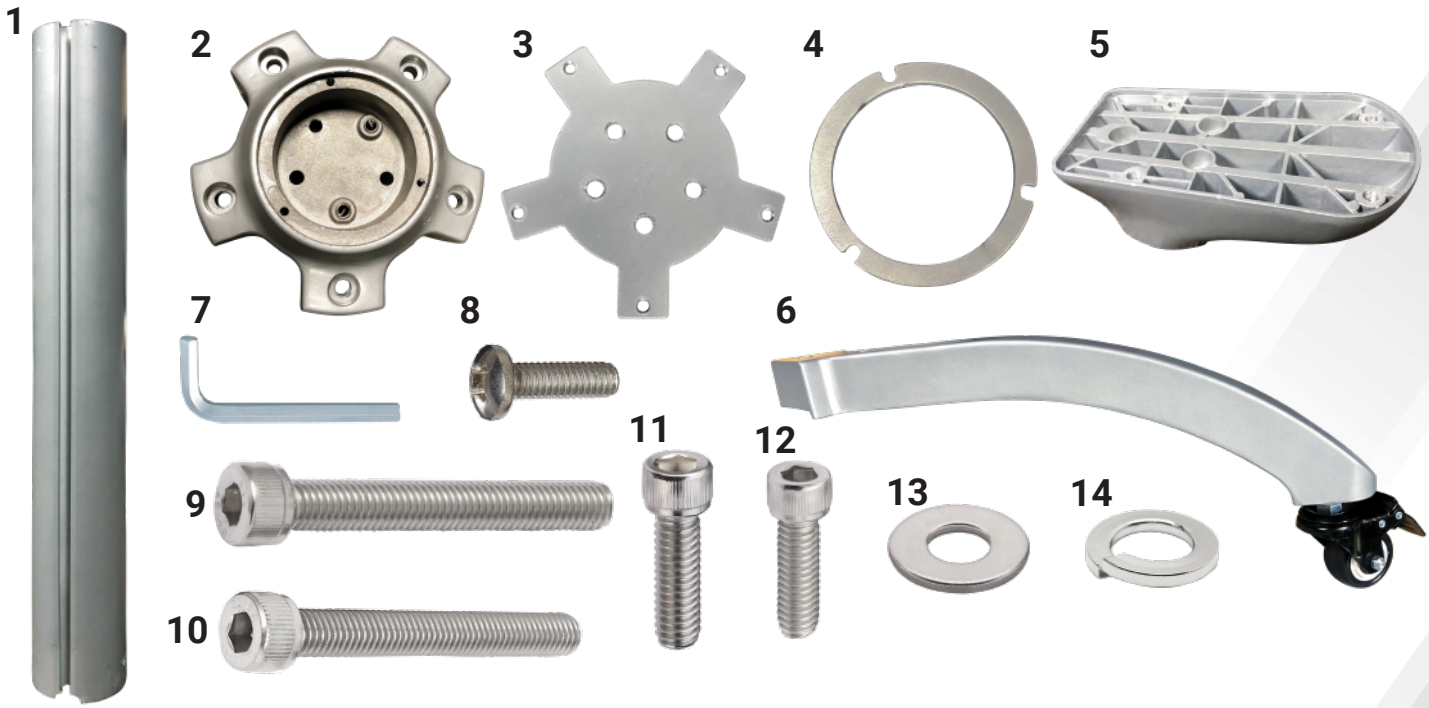
CADDIE ASSEMBLY

SilverBolt 1620-SA Caddie Assembly



Parts List	
Item Name	**Quantity**
Stand Leg w/Wheel	5
Lower Connector	5
Upper Connector	1
Column Washer	1
Aluminum Column	1
Seat Connector	1
Working Table/Machine Body	1
M5 x 12mm Screw (Column Washer)	3
M8 x 20mm Bolt (Working Table)	4
M8 x 35mm Bolt (Seat Connector)	3
M8 x 55mm Bolt (Lower Connector) (Upper Connector)	7
M8 x 65mm Bolt (Aluminum Column)	3
M8 Flat Washer (Under Spring Washer)	17
M8 Spring Washer (Above Spring Washer)	17

CADDIE ASSEMBLY CONT'D



NO.	NAME	QTY	NO.	NAME	QTY
1	Aluminum Column	1	8	M5 x 12mm Screw	3
2	Upper Connector	1	9	M8 x 65mm Bolt	3
3	Lower Connector	1	10	M8 x 55mm Bolt	7
4	Column Washer	1	11	M8 x 35mm Bolt	3
5	Seat Connector	1	12	M8 x 20mm Bolt	4
6	Stand Leg w/ Wheel	5	13	M8 Flat Washer	17
7	Hex Tool	1	14	M8 Lock Washer	17

*** You will need a Phillips screwdriver and a Level. These are not included with your stand**

NOTE: The Base must be installed in stages, and the column must be installed correctly. Two people maybe needed for construction of the base.

1) Start with the Upper and Lower Connector and the 5 legs. You will want to note where the two raised holes are and then turn the Upper connector over and place the legs inside (See FIG 1). Take the Lower connector and place on top of the legs. You may need an extra hand or two to hold the legs to thread the bolts through the Lower connector. All the legs must be under the Lower connector before putting the bolts in. You will need to make sure the bolts, M8 x 55mm, are not too tight. (FIG 2)

2) Once the Lower connector is attached, turn it over. Now take (5) M8 x 55mm bolt and tighten the legs to the connectors. (FIG 3)

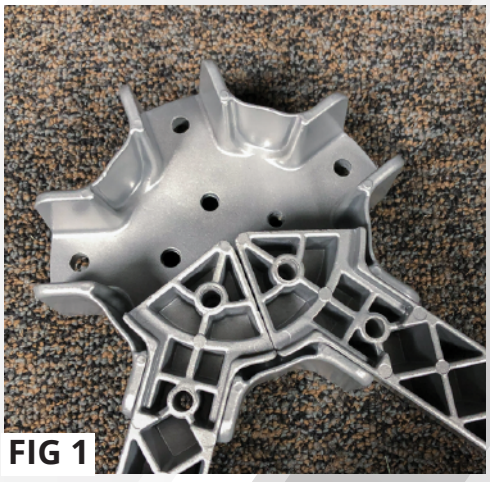


FIG 1

CADDIE ASSEMBLY CONT'D

3) Take the Column Washer and screw on the top of the Upper Connector (See Fig 3).
4) Make sure the column (1) is installed with the two notches on the bottom. The flat surface is the top.
5) Align ONE of the notches over one of the bolts in the base plate (2). See Fig 4 below.
6) When inserting the three bolts (9) through the bottom of the base plate and into the bottom of the column, do not over-tighten these bolts. If over-tightened, the column may tilt slightly. When properly installed, the column will be level. Check with a level on top of the column, or on top of the top mounting support (5), as seen in Fig 5 below. If the column or top mounting support are not level, adjust the screws securing the column to the base.

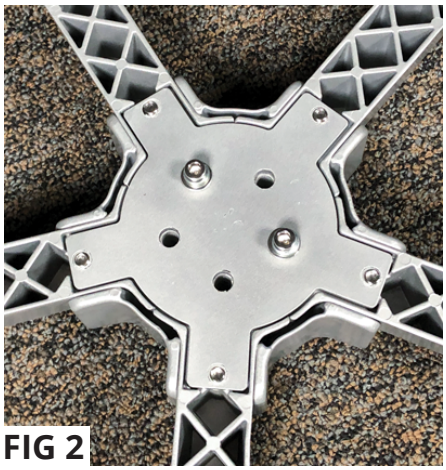


FIG 2

FIG 3

FIG 4

Align one of the notches in the bottom of the column over one of the bolts in the base plate. Then thread the three bolts through the bottom of the base plate into the bottom of the column. Do not over-tighten.

FIG 5

It's a good idea to use a carpenter's level to check the vertical alignment of the column. Place it on the top of the column after installation to ensure a level platform for the top mounting plate and the heat press.

CONTROL PANEL

Initializing

This is the initialization screen.

Home Screen

The Home Screen shows the current selected preset, the set temperature, current temperature, time setting, number of presses, and, if heating, the amount of time remaining before set temperature is reached.
Please refer to the legend below for information on using the home screen icons

HOME
This icon takes you to the home screen.

SETTINGS
This icon takes you to the settings menu.

PROGRAM
This icon takes you to the Presets menu.

LOCK
This icon locks or unlocks saved settings. Locking prevents over-writing saved presets.

LEFT ARROW

RIGHT ARROW

Use the left and right arrows to increase or decrease numerical values in the menus, such as time, temperature, and pressure.

POWER
This icon powers the press on / off or ends standby mode to resume production.

CONTROL PANEL: SETTINGS MENU

Settings Menu

Unit Switching: Switch temperature display from Celsius to Fahrenheit°
Calibration: Use to adjust displayed temperature to match the measured temperature of the heat platen.
Sound: Turns audio alarms on or off
Standby: Allows user to set time duration for standby mode.
Reset: Reset all Settings to factory defaults

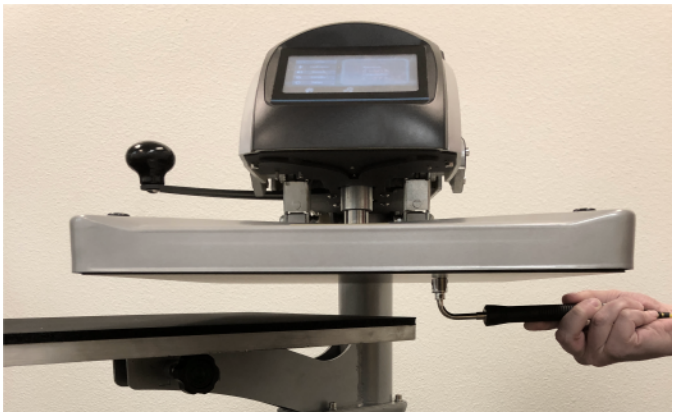
Settings: Unit Switching

Unit Switching: To change the temperature setting from Celsius to Fahrenheit (or vice versa) touch the Units button to access the Unit Switching menu. Then press the °C or °F on the main screen to change the parameter.
Gear icon: There is an additional settings icon at the bottom of each page in the Settings menu. This is for use by technicians only and has no end-user function.

CONTROL PANEL SETTINGS CONT'D

Settings: Calibration

Calibration: All SilverBolt heat presses are calibrated at the factory. However, should you find that your results are not as expected, it may be necessary to calibrate the temperature display. Calibration adjusts the displayed temperature to match the actual measured temperature of the heat platen.
This requires the use of a contact thermometer such as the Geo Knight IR thermometer. Once the heat press has achieved its set temperature, place the probe of the contact thermometer near the center of the bottom of the heat platen. If the measured difference is more than 5°, you may want to calibrate the display.
To calibrate the display, enter the settings menu, press the calibration button and use the arrow keys to adjust the displayed temperature in the Compensation window upwards or downwards enough to match the actual measured temperature.
The value in the Reference window should always be set to -50. This is the factory default.
If the home screen display says 300°, but the IR thermometer measures 320°, the displayed temperature needs to be increased by 20. Press the right arrow to change the compensation value to 20. Then press the Home button.
The displayed temperature should now match the actual measured temperature of the heat platen. If not, repeat the adjustment until the readings match.



Calibration: Always use a contact thermometer to measure the actual heat platen temperature. Laser IR thermometers don't give accurate readings on the alloys used in heat press platens.

Settings: Sound

Sound: The SilverBolt 1620SA is programmed to sound alarms at several intervals, including at the end of press cycles. To turn the alarms off, open the Settings menu and press the Sound button. In the central window, press the slider near 'OFF' to move the white cursor from On to OFF. This disarms all alarms.
NOTE: Since end-of-cycle alarms indicate the need to raise the press, deactivating this alarm can pose a risk of overheating materials. Depending on the material in the press, this may pose a fire hazard and is strongly discouraged.

Settings: Standby

Standby: The SilverBolt 1620SA can be programmed to power down by going into standby mode. This helps to reduce power consumption. To program this feature, enter the Settings menu and press the Standby button.
From the menu in the central window, press the white button to toggle the feature on or off. When turned on, use the right and left arrows in the lower windows to determine the length of the desired standby time interval in hours and minutes.
The standby time set here will determine how long the press can be left idle at a set temperature before it enters standby mode. To recover the press from standby mode, press the power button on the Home screen.

CONTROL PANEL SETTINGS CONT'D

Setting: Reset

Reset: To erase all custom settings and return the heat press to its factory default settings, open the Settings menu, touch the Reset button and, in the central window, press the Confirm button. This will reset the values in the Settings Menu.
NOTE: Resetting the heat press reverts the machine to its default values. Since the heat press temperature display is calibrated at the factory, the reset will erase this calibration and require you to recalibrate the temperature display. See page 4

CONTROL PANEL: PROGRAM MENU

Programming Presets: To save custom presets for your favorite heat transfer materials, touch the Program icon at the bottom of the Home screen to enter the Program menu.

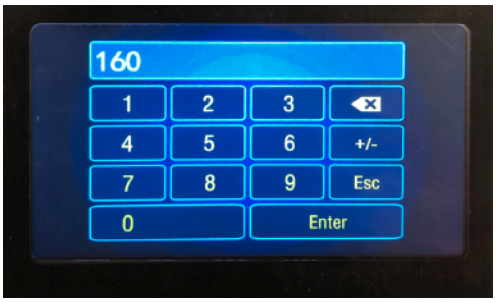
Programming Presets: The Custom/Default screen will appear with the current values entered. There are slots for three more settings on page 1. Page 2 holds five more slots for presets.
To add a custom preset, touch the + icon at the right of one of the empty rows. This will open the New preset table.
To delete a preset, press and hold the X icon for three seconds.

Programming Presets: The New preset window will open with these placeholder values. Here you can enter your desired name for the preset, then enter the specifications for its temperature, time, and pressure. Start by touching the Name window.

Programming Presets: When you touch the Name window, The naming screen will open. Use the keypad to enter the desired name for your custom preset. The keypad supports upper and lower-case alpha-numeric names, with spaces.
Press the x key to backspace and erase characters.
Press the Esc key to quit the screen without saving inputs.
Press the Enter key when finished.
There is a 15- character limit, including spaces, so you may have to abbreviate certain terms.

CONTROL PANEL: PROGRAM MENU CONT'D

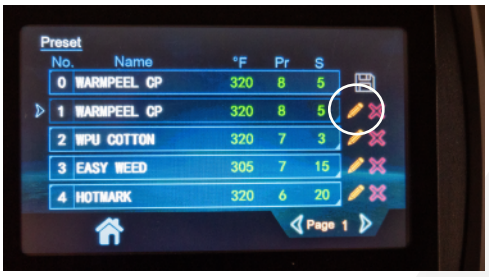
Programming Presets: Temperature:
Touch the window next to Temperature to enter the temperature settings window. A numeric keypad will appear. Use the keypad to enter the desired temperature for the intended preset.
Press Esc to quit the screen without saving. Press Enter to save.



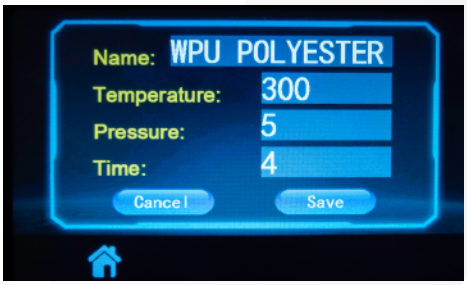
Programming Presets: Pressure:
On the Program screen, touch the window next to Pressure and repeat the process to set the desired pressure.
The pressure is not an absolute value. Rather it measures the range of available pressures on a scale of one to 10, with ten being the maximum (approximately 770 lbs). Most applications work best with pressure settings between 3 and 6.
If an application requires light pressure set it at 2 - 4, test the application, and adjust as needed.
For medium pressure, set the press at 4 - 6 and adjust as needed.
For firm pressure set the press at 6 - 9 and adjust as needed.

NOTE: An object on the table of a swing-arm heat press acts like a fulcrum. The pressure settings are designed for standard-weight textiles such as cotton shirts. Placing thicker items in the press, such as mouse pads, ceramic tiles, or hooded sweatshirts reduces the space needed to close the press and amplifies the applied pressure. Always reduce the pressure setting when changing from thin to thicker items. Using the press with a too-high pressure setting, or changing from thin to thick materials without adjusting the pressure can damage the heat press, and may void the warranty.

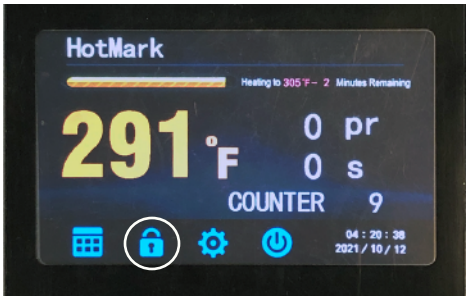
Programming Presets: Confirm
When you have entered the desired name, temperature, and pressure settings, the Custom Presets screen will present a summary of the saved settings for review. If everything is correct, press the Enter key to save the settings.
The newly named preset will be added to the Program menu.



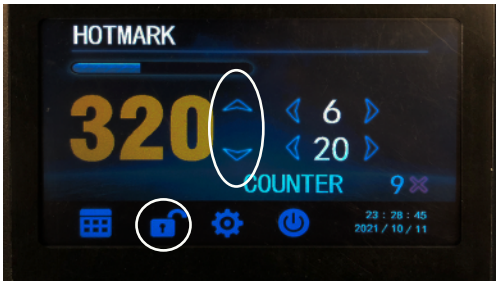
Editing Presets:
To edit a saved preset, press the Program button from the home screen to enter the Program menu. Touch the line of the preset you want to save. This will highlight the intended preset. Touch the pencil icon to edit the preset. This will take you to an edit screen where you change the name, temperature, or pressure values (see below).



CONTROL PANEL: HOME SCREEN FUNCTIONS



Home Screen: Locked Once you have selected a preset from the program menu, that preset will be loaded onto the home screen. The name of the preset will appear at the top with the set temperature and an estimated time until that temperature is reached. The present temperature is displayed in bold type and the lock icon at the bottom of the screen is closed. This means that the settings cannot be changed from the home screen.



Home Screen: Unlocked To quickly adjust the time, temperature, or pressure settings, or to clear the counter, press the lock icon on the home screen. This will change the display and add arrow keys around each of these parameters. Touch the arrow keys to raise or lower any of these settings.
To clear the counter, press and hold the X icon for three seconds.
To save the new settings, press the home key again.

Home Screen: Standby If the Standby feature has been activated and the press is left idle long enough, it will transition into Standby Mode. In this mode, the screen is mostly dark, with only a temperature setting displayed. No other buttons except the Home screen button are visible. To restore full operation, touch the Home button. The press will immediately revert to the home screen and the platen will resume heating if it has fallen to below the set temperature.

Home Screen: Standby To manually place the heat press into standby mode, just press the power icon on the home screen.

TROUBLE-SHOOTING TIPS

Q. Why isn't my heat transfer vinyl sticking to the fabric?

A. This can be caused by three things. Insufficient pressure, or temperature, or time.

Time: Some heat transfer films need a few seconds to cool before you remove the liner. Try a warm or cold peel first.

Temperature: If that doesn't work, check to make sure you are using the recommended time and temperature settings. If you are, your press may not be putting out the correct amount of heat. Use a Geo Knight IR thermometer to check the actual temperature of the platen. If it is more than 5° different from the LCD set value display, adjust it using the calibration feature in the Settings Menu, as seen on page 4.

Pressure: If the temperature is correct, adjust the pressure. Some films require more pressure to bond the adhesive to the fabric. There should be some resistance when you close the press. If you have verified all of these and the film doesn't stick, contact SIGNWarehouse customer service or Technical Support for further

Hoe toassistance.

Q. Why does my sublimated transfer look washed out?

A. This is usually caused by insufficient temperature. Sublimation works best at or near 400°F. If your transfer is faded, check the output of the heat platen with a

TROUBLE-SHOOTING TIPS: CONT'D

contact thermometer and make sure the output matches the displayed temperature. If not, adjust as directed above. Then repress at 390 - 400°F

The other reason may be dwell time. Most polyster sublimation transfers reach full saturation around 45 seconds. If your transfers are too light, try increasing the time on the heat press.

Q. Why are my transfers are sticking to the heating element of the upper platen?

A. If T-shirt vinyl is sticking to the heating element, you have it upside down. Remove any adhesive residue, flip it over and try again. If an inkjet or laser transfer is sticking to the heating element, it's because the heat is affecting the ink. Cover it with a Teflon sheet or sheet of silicone Kraft paper to prevent this. Using a Teflon sheet or Kraft paper is recommended for almost all heat transfer applications.

Q. Why is it so hard to peel the liner when I'm done pressing the paper?

A. A hot or warm peel film may become hard to peel if allowed to cool. Always peel the film or transfer paper in accordance with the product's recommendations.

How to Get Help

If you have followed all of these tips and are still having trouble, please contact SIGNWarehouse Product Support. Use the Contact Us link at the top of any page on our website at www.signwarehouse.com. Include all pertinent information and submit a support ticket. We will contact you promptly with solutions.

HEAT TRANSFER APPLICATION GUIDELINES

These are general guidelines. For specific time and temperature settings for specific films and/or transfer papers, please refer to the instructions for that particular product.

TRANSFERS	Device	Fabric	TEMP.	TIME	PRESSURE
Sublimation Paper	Epson, Sawgrass	Polyester	360 - 400°F *	30 - 45 Sec.	3 - 5
Ink Transfer Paper	Inkjet Printer	Light Color	365°F	15 Sec.	3 - 5
		Dark Color	330°F	25 Sec.	3 - 5
Laser Transfer Paper	IColor, Oki, Crio	Light Color	345°F	30 Sec.	3 - 5
	IColor, Oki, Crio	Dark Color	260 - 320°F	35 - 120 Sec.	2 - 4
Transfer Vinyls	Cutting Plotter	/	300 - 320°F	8 -10 Sec.	3 - 5
Plastisol Transfer	/	/	335°F	12 Sec.	5 - 7

* Dwell times for sublimation vary greatly depending on the substrate. Polyester apparel generally works best with a 30 to 45-second press cycle. Ceramic mugs generally require 4 minutes, and stainless steel tumblers generally require 3 minutes or more. Various subsrates will have different recommended dwell times depending on the softness of the polymer coating and the nature of the surface to be sublimated. Please refer to the application instructions for the particular item for the best time, temperature, and pressure guidelines for successful sublimation.

SilverBolt 1620-SA

Transfer Material, Cuttable	TEMP.	TIME	PEEL	PRESSURE
Logical Color WarmPEEL CP	320°F	15 sec.	Warm	4-6
Logical Color GlitterSOFT	320°F	15 sec.	Warm	4-6
Logical Color Flock	320°F	15 sec.	Warm	4-6
Logical Color Universal				
• 100% Cotton	320°F	3 sec.	Warm	6-8
• Cotton/Polyester Blends	300°F	4 sec.	Warm	4-6
• Polyester and Acrylic	300°F	5 sec.	Warm	2-4
Siser EasyWeed	305°F	10-15 sec.	Hot or Cold	4-6
Siser EasyWeed Fluorscent	305°F	10-15 sec.	Hot or Cold	4-6
Siser EasyWeed Extra	305°F	10-15 sec.	Hot or Cold	4-6
Siser EasyWeed Electric	305°F	10-15 sec.	Hot or Cold	4-6
Siser EasyWeed Glow	305°F	10-15 sec.	Hot or Cold	4-6
Siser EasyWeed Stretch	320°F	20 sec.	Hot or Cold	6-8
Siser EasyWeed Adhesive	275°F	5-10 sec.	Hot	4-6
Siser EasyPatterns	305°F	10-15 sec.	Hot or Cold	4-6
Siser EasyReflective	305°F	15 sec.	Warm	4-6
Siser Blackboard	275°F	15 sec.	Warm	4-6
Siser Glitter	320°F	15-20 sec.	Warm	4-6
Siser Twinkle	320°F	15-20 sec.	Warm	4-6
Siser Holographic	320°F	15-20 sec.	Cold	4-6
Siser EasySubli	311°F	15 sec.	Hot	4-6
Chemica Hotmark	320°F	20 sec.	Cold	4-6
Chemica Hotmark Revolution				
• Quick Mode	285°F	5 sec.	Warm	5-7
• Low Temp Mode	250°F	20 sec.	Warm	5-7
• Nylon, 1st Press	285°F	5 sec.	Hot or Cold	5-7
• Nylon, 2nd Press	285°F	15 sec.	Hot or Cold	5-7
Chemica FirstMark	300°F	10-15 sec.	Warm or Cold	4-6
Chemica Metallic	293°F	15 sec.	Cold	4-6
Chemica Fashion	320°F	20 sec.	Cold	4-6
Chemica Galaxy	320°F	20 sec.	Cold	4-6
Chemica UpperFlock	320°F	20 sec.	Cold	4-6

* These settings are from our testing and recommended starting point.
Always perform a test press before going into production.*

SilverBolt 1620-SA

Transfer Material, Printable	TEMP.	TIME	PEEL	PRESSURE
Logical Color WarmPEEL CP PRINT	320°F	15 sec.	Warm	4-6
Logical Color CozyPRINT	320°F	15 sec.	Warm	4-6
Logical Color DarkJET	350°F	20 sec.	Cold	4-6
Logical Color RGP	375°F	20 sec.	Warm	4-6
Logical Color Universal PRINT				
• 100% Cotton	320°F	3 sec.	Warm	6-8
• Sublimated Polyester	267°F	5 sec.	Warm	4-6
• Nylon	302°F	5 sec.	Warm	4-6
Siser ColorPrint PU	295°F	15-20 sec.	Hot	4-6
Siser ColorPrint Easy	300°F	15 sec.	Warm	4-6
Siser ColorPrint Extra	320°F	10-15 sec.	Hot	4-6
Siser ColorPrint Soft Opaque	311°F	15 sec.	Hot	5-7
Chemica BestPrint	320°F	20 sec.	Hot	4-6
Chemica HotMark	320°F	20 sec.	Hot	4-6
Chemica HotMark Revolution				
• Quick Mode	285°F	5 sec.	Warm	5-7
• Low Temp Mode	250°F	20 sec.	Warm	5-7
• Nylon, 1st Press	285°F	5 sec.	Hot or Cold	5-7
• Nylon, 2nd Press	285°F	15 sec.	Hot or Cold	5-7
LXF Light				
• Cotton/Polyester	340°F	45 sec	Hot	8
LXF Dark				
• A-step	320°F	100 sec	Hot	6
• B-step	320°F	30 sec	Cold	7
• A-step with Holes	330°F	100 sec	Hot	5
• B-step with Holes	330°F	30 sec	Cold	5

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Always perform a test press before going into production.*