

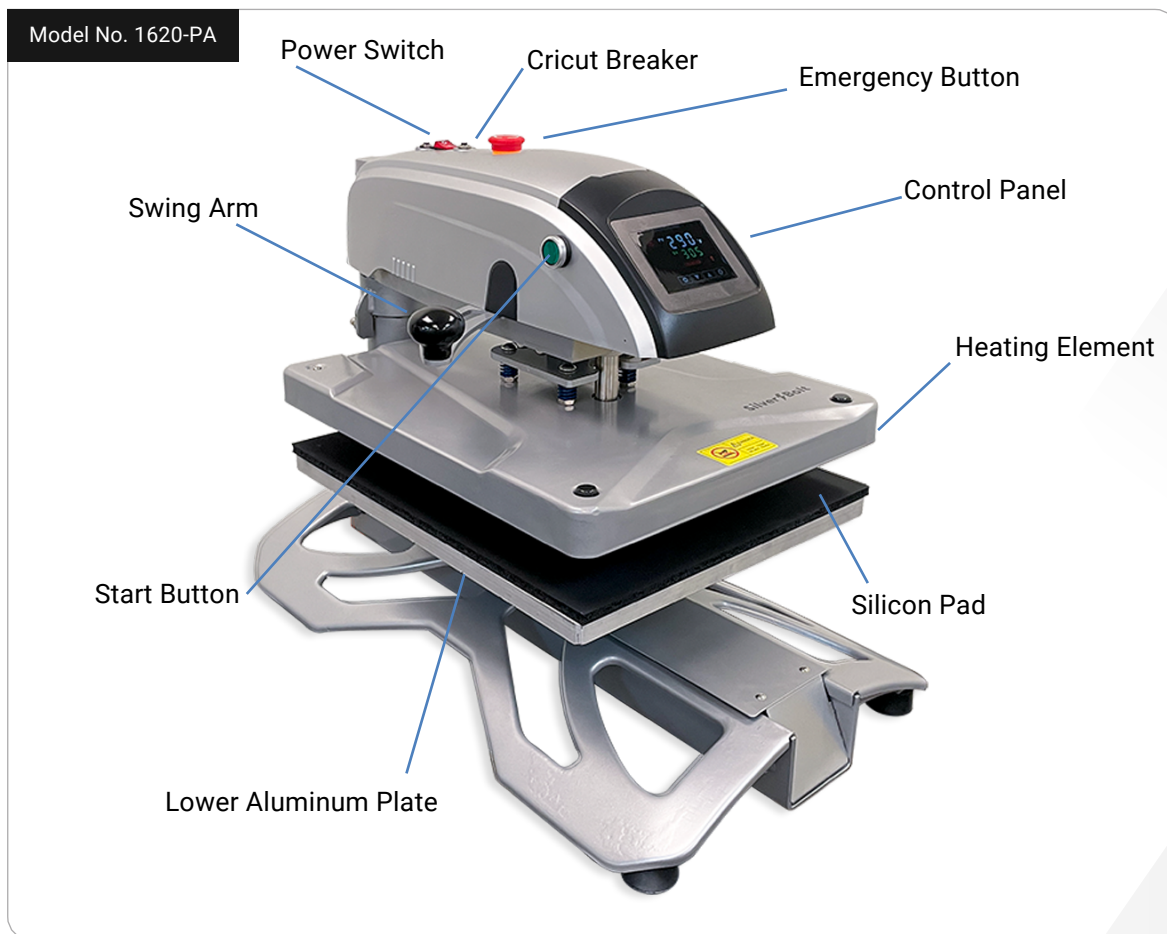
Silver ***Bolt***

USER MANUAL

SilverBolt 1620-PA

TABLE OF CONTENTS

| | |
|--|---|
| Specifications _____ | 1 |
| Operation Instructions _____ | 2 |
| Control Panel _____ | 3 |
| Temperature Calibration _____ | 4 |
| Emergency Stop Button _____ | 4 |
| Troubleshooting _____ | 5 |
| Heat Transfer Application Guidelines _____ | 7 |
| Caddie Assembly _____ | 8 |



SPECIFICATIONS:

Model NO: SilverBolt 1620-PA

Voltage: 110V*

Power: 1800W

Control Panel: LCD Control Panel

Time Range: 0~999sec.

Temp. Range: 0~480°F

Heating Element: 16" by 20"

Packaging: Double-walled Corrugated Paper Carton

Gross Weight: 149 lbs (67.5 kg)

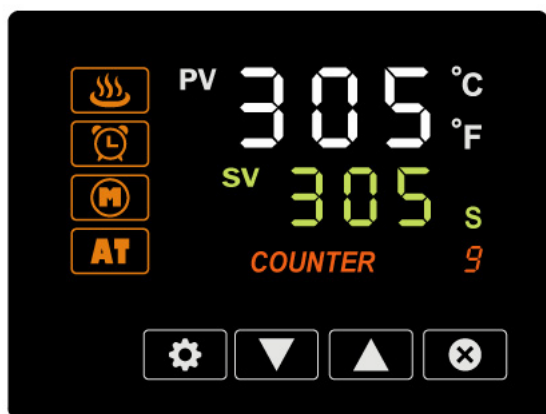
* For best results, 16" by 20" heat presses should be run on a dedicated 20-amp circuit. This provides sufficient power to quickly heat the platen, maintains consistent temperature and ensures steady power supply to the press. Failure to do so may result in longer heating times, inconsistent platen temperature 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. You must press both green buttons to close the machine. This is a safety feature.
4. Keep children away from the machine.
5. Do not touch the heating platen and platen cover after pressing whilst 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 480F as it may cause over heat and stop working.
8. The heat press carries a ground line by default, please make sure the socket gets a ground line protector.
9. The stand is optional for this heat press. When mounted on the stand, the heat press is not bolted to the stand. The 150lb-weight of the heat press and its rubber pads are sufficient to keep it securely mounted during normal use. Normal and reasonable caution should be taken to avoid handling the press roughly during operation.

CONTROL PANEL



Control Panel Display

- Heating Indicator
- Timing
- Motor Operation
- Self Adjusting Temp
- Settings
- Up Arrow
- Down Arrow
- Counter Clear (Hold for 5 seconds)

- PV** Present Value
- SV** Set Value
- °C** Temperature in Celsius
- °F** Temperature in Fahrenheit
- S** Time in Seconds
- COUNTER** Job Counter



P-1: Temperature Setting Mode

Hit SETTINGS & use the up and down arrows to set temperature



P-2: Time Setting Mode

Hit SETTINGS twice & use the up and down arrows to set amount of time for pressing



P-3: °C or °F Read Out

Hit SETTINGS three times & use the up and down arrows to select Celsius or Fahrenheit



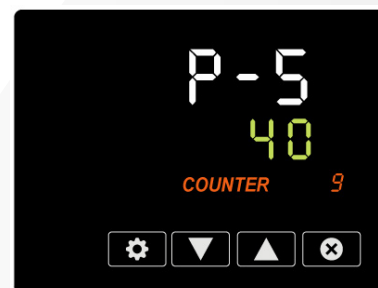
P-3: °C or °F Read Out

Hit SETTINGS three times & use the up and down arrows to select Celsius or Fahrenheit



P-4: Motor Pressure Setting

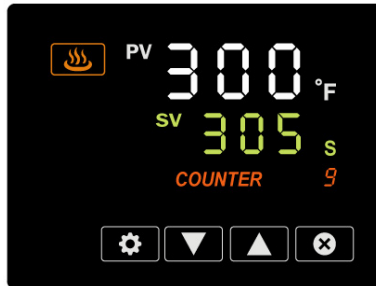
Hit SETTINGS four times & use the arrows to set the pressure of for pressing. Pressure Range 1-30. Higher the number, the more pressure.



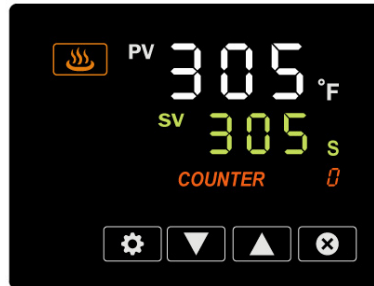
P-5: Auto Shut Off Mode

Hit SETTINGS five times & use the up and down arrows to set auto shut off when inactive 0-120 minutes range. If 0 is selected, the press will not shut off.

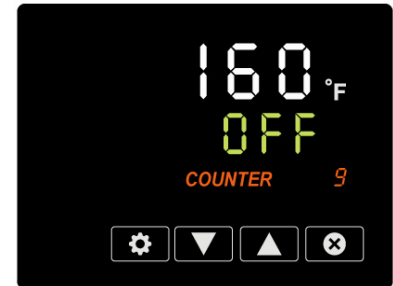
CONTROL PANEL



If the heating light is on, the heat press is still heating up to the Set Value.

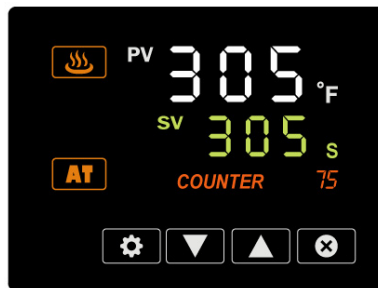


If you would like to clear the Counter, you will need to hold the Clear button for 4-5 seconds. The Counter will reset to 0.



If the heat press reads OFF on the screen, it means it's in stand by mode. If you would like to use the press, hit any button on the screen.

TEMPERATURE CALIBRATION



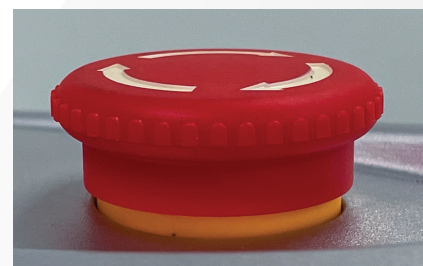
The heat press needs to have the correct reading of the temperate. If you have an IR thermometer, you can check to see if the press is off or not. If the press is reading incorrectly, it's easy to calibrate the press. Hold the down arrow for 4 seconds, and the AT light will start flashing. This means the meter starts self-tuning. The temperature may fluctuates. Once it's done the AT light will stop and the press is now calibrated.

EMERGENCY STOP BUTTON

The 1620-PA is an electrically activated auto-close and auto-open, swing-arm heat press. To close, you simply press the two green buttons on either side of the control panel simultaneously. This closes the press and starts the timer. The requirement to press both buttons is a safety feature. There is also an emergency stop button on top. Use the emergency stop to interrupt a cycle and raise the press immediately.



If the emergency button is up, the press will work properly. The press will move up and down freely.



If the emergency button is down, the press will NOT work. The press will not close if the button is down.

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 display (PV), adjust it using step four in the control panel (see 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 assistance.

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

TROUBLE-SHOOTING TIPS: CONT'D

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.

Q. Why does the press not engaged when I press both green buttons?

A. If the press is not engaging when you press the green buttons, please check the emergency stop button. If the button is down, it will keep the press from moving freely.

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

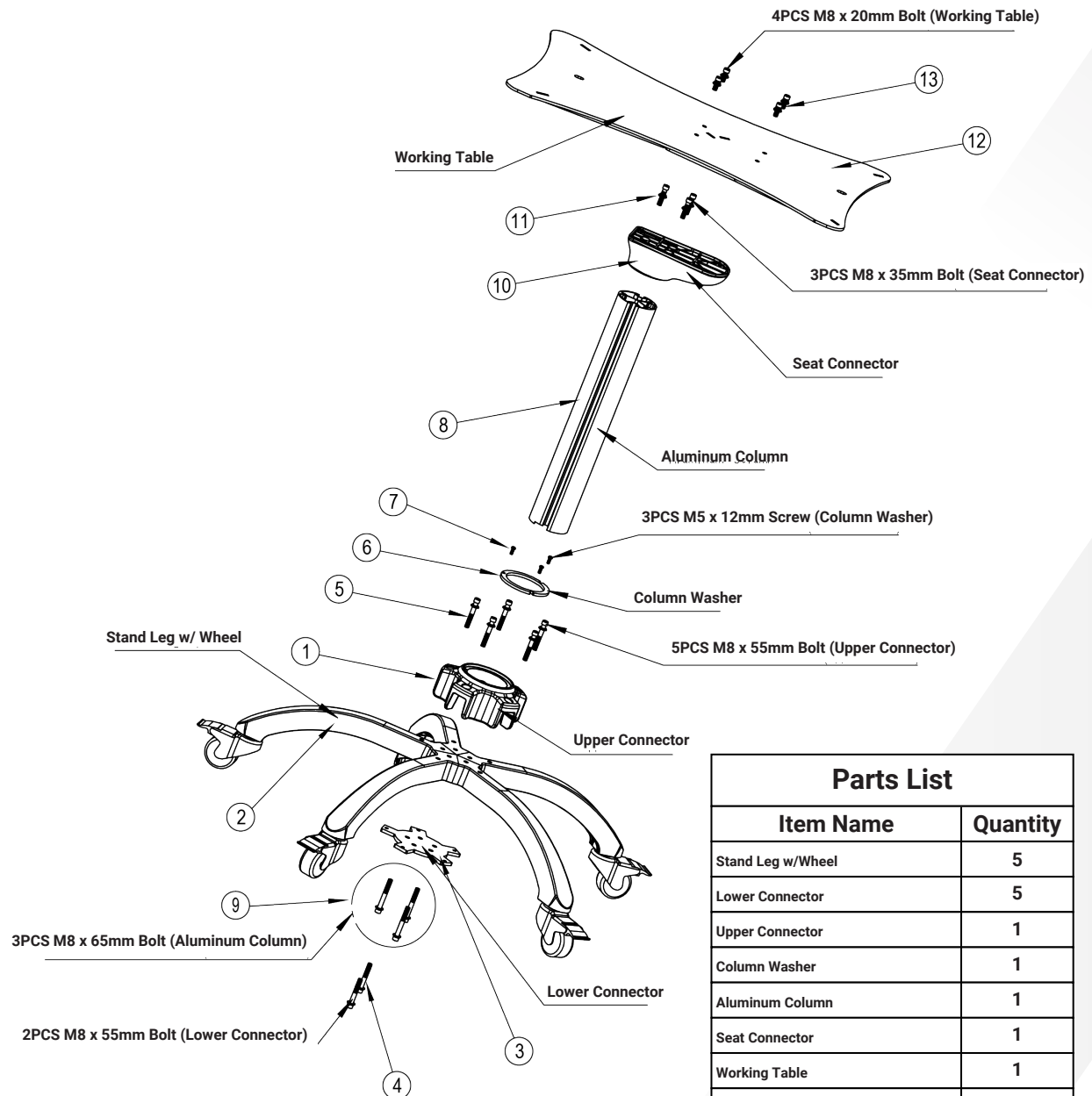
These are general guidelines. For specific time and temperature settings for specific films and/or transfer papers, please refer to the instructions for that particular product.

| TRANSFERS | Device | Fabric | TEMP. | TIME | PRESSURE |
|------------------------|-----------------|-------------|-------------|---------------|----------|
| Sublimation Paper | Ricoh, Epson | Polyester | 400°F | 25 - 30 sec. | 30Psi |
| Ink Tran. Paper | Inkjet Printer | Light Color | 365°F | 15 sec. | 30Psi |
| | | Dark Color | 330°F | 25 sec. | 30Psi |
| Laser Transfer Paper** | Laser Printer | Light Color | 345°F | 30 sec. | 30Psi |
| | Laser Printer | Dark Color | 260 - 320°F | 35 - 120 sec. | 25Psi |
| Transfer Vinyls | Cutting Plotter | / | 300 - 320°F | 8 -10 sec. | 30Psi |
| Plastisol Transfer | / | / | 335°F | 12 sec. | 50Psi |

** The SilverBolt 1620CSD and 1620-CSM are not recommended for use with two-step laser transfer papers. For these demanding applications, we recommend the SilverBolt 1620 Premium Auto or 1620A Premium.

CADDIE ASSEMBLY

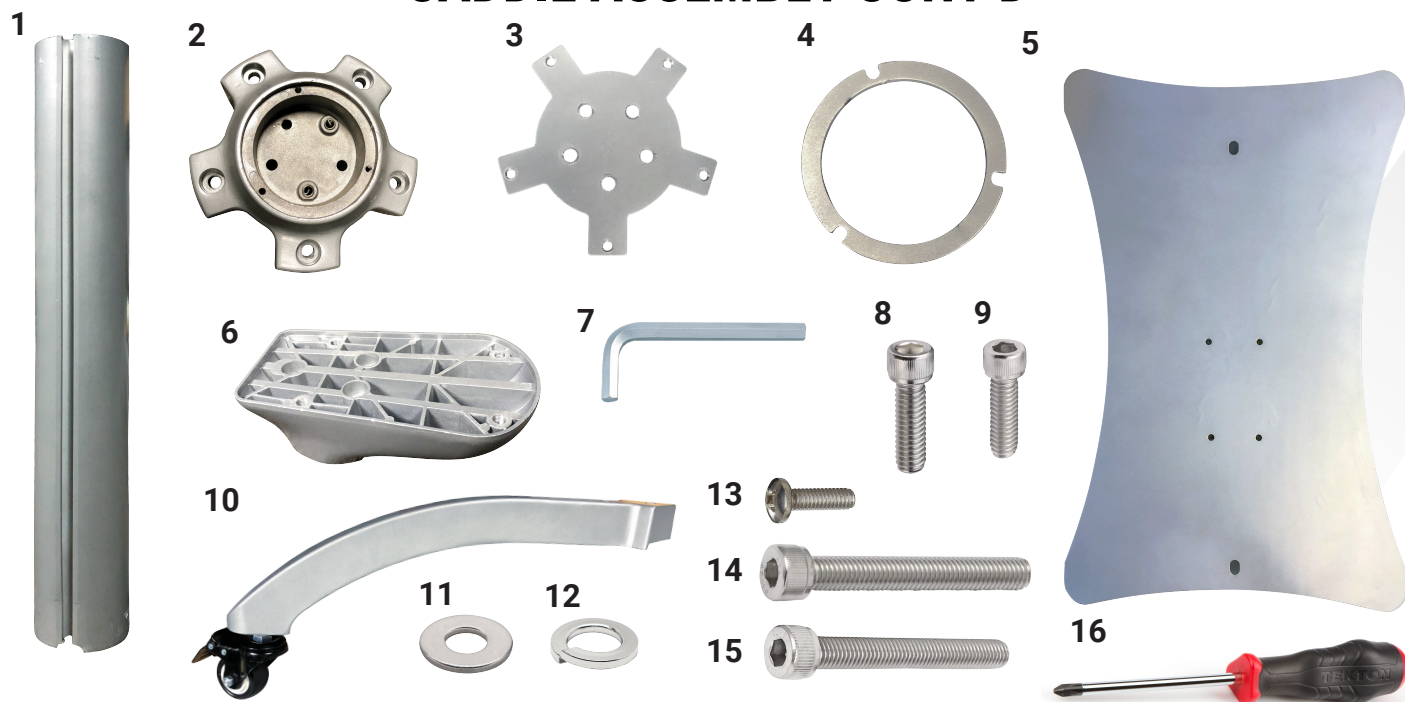
SilverBolt 1620-PA Optional Caddie Assembly



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 | 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) | 7 |
| M8 x 55mm Bolt (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 | 9 | M8 x 20mm Bolt | 4 |
| 2 | Upper Connector | 1 | 10 | Stand Leg w/ Wheel | 6 |
| 3 | Lower Connector | 1 | 11 | M8 Flat Washer | 17 |
| 4 | Column Washer | 1 | 12 | M8 Lock Washer | 17 |
| 5 | Working Table | 1 | 13 | M5 x 12mm Screw | 3 |
| 6 | Seat Connector | 1 | 14 | M8 x 65mm Bolt | 3 |
| 7 | Hex Tool | 1 | 15 | M8 x 55mm Bolt | 7 |
| 8 | M8 x 35mm Bolt | 3 | 16 | Phillips Screwdriver* | 0 |

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)

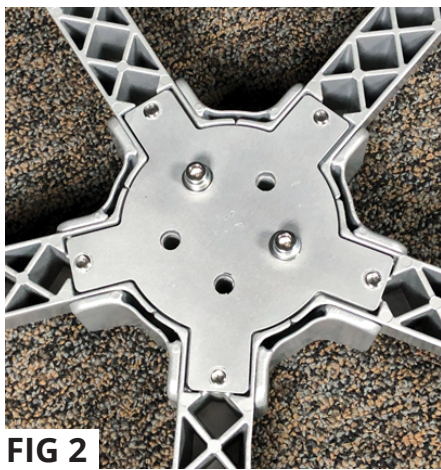
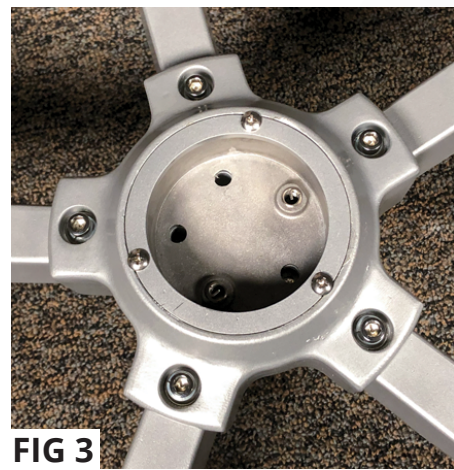
2) Once the Lower connector is attached, turn it over. Now take (5) M8 x 55mm bolt and tighten the legs to the connectors. (FIG 3)



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.
- 7) Take the seat connector and the 20mm bolts to screw into the column. The working table will attach to the seat connector. Using the holes on the working table, tighten the bolts down.
- 8) Place 1620-PA press on top of the stand.

**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.