Goldseal Plus

Operators Manual

Rev: GSW-Plus 2010 (K32)

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Features

The new Plus machine use a powerful microprocessor PID *(Proportional plus Integral plus Derivative)* controller utilizing flash memory processors which allow custom features and high standard of temperature accuracy.
PID controllers prevent oscillation around the temperature set point and adjust the power output to avoid overshoot and offset, for a more reliable and stable temperature. Dual display of temperature and time dwell. SSR controlled heating element.

Unpacking & Set-up

Safety First ~ NEVER stand over the machine when in the clamped / closed position.

- Remove the heat press from the packing case and retain all the packing.
- Mount the press on a solid surface ensuring it is located near a mains outlet.
- Plug the mains cable into the rear of the machine and connect to: - 240 Volt AC, single-phase mains supply (standard wall socket)
- Depress the **on / off** switch and the control will illuminate as below and perform a self diagnostic for a few seconds.

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The machine will now start to heat up. Please note for the later part of the heating cycle approximately 10°C before the set point the heating cycle will slow down this is the PID control bringing the temperature up by pulsing the element supply to avoid temperature overshoot
The first line of the controller display (in red) is the current temperature.
When the machine is first switched on it will display the temperature of the platen and gradually heat up to the set point.

The controller on the left is indicating 210°C this means the machine is ready to use.
The second display (green) line is the timer set point in seconds currently set to 8 seconds.

The machine is delivered set to standard factory settings as above but you may wish to change these for different materials or marking products.

You may check your settings at any time simply by pressing the P key and the temperature set-point will be displayed, press P again and the timer set-point will be displayed, press P a third time and the control will loop back to the temp set point simply leave the control for a few seconds and display will revert to monitoring the temperature of the machine.

To Change the Temperature & Timer Set Points

Press the P button once to enter the temperature set point

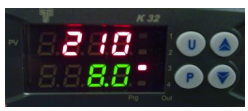
SP 1 – Set point for platen temperature
210 – Current temperature set point

If you want to alter the **temperature set point** use the arrow keys up & down followed by the P key to store the new temperature.

Or to leave the temperature set point as it is simply press the P key again to enter the timer set point

The controller will now display the preset dwell time
Again if you want to alter the **timer set point tr.t1** use the arrow keys up & down followed by the P key to store

Or to leave the timer set point as it is simply press the P key again.



The display on the controller will loop back to the temperature set point.

If you are happy with the setting then simply leave the controller for a few seconds and the display will return to monitoring the platen temp and dwell time.

To Operate the Hand Press

- Ensure that the temperature & Timer setting are correct.
- *You may check your settings at any time simply by pressing the* P *key and the temperature set-point will be displayed, press* P *again and the timer set-point will be displayed, press* P *a third time and the control goes back to the standard screen display*
- Place the part of the garment/article to be marked onto the silicone pressure pad.
- Pull the handle forward into the locked position, ensuring the garment is firmly clamped between the heat plate and pressure pad. (Make sure that your hands are away from the heated platen when using the heat press).
- The timer display will now start a countdown.

After completion of the above the buzzer will sound when the pre-set time has elapsed and **t.End** (timer end) will be displayed, the handle should then be lifted back to it full extent.

Before operating the machine at the start of each day carry out a sealing procedure without any garment or transfers this will remove any moisture from the pad.

Pressure Pad Assembly

The silicone pressure pad and assembly should be maintained and kept in good condition at all times.
A worn silicone pressure pad will effect the quality of transfer marking / fusing and should be replaced when showing signs of wear. (*See parts list*).
After a long duration of time it may be found that there is a loss of pressure through the pressure pad assembly, this can be rectified by replacing the pressure springs located under the pressure plate.
Never allow the heat plate to rest on the silicone pressure pad when the press is not in use.

PTFE Heat Plate Cover

A PTFE cover is fitted to the heat plate, which allows the surface to be wiped clean should it become marked.
New PTFE covers may be fitted to the heat plate when **WARM** *(not hot)* and has been cleaned to remove residue of the old PTFE.

Design Change

With a policy of constant improvement and/or modifications to meet changing conditions, the right is reserved to change the design and/or specifications at any time without prior notification, therefore no guarantee can be given as to the accuracy of the information contained in this instruction book.

Guarantee

This press is guaranteed to be free from defects in materials and workmanship ** for a period of 12 months from the proven date of delivery or installation.
Should, in our opinion, any part of this press be defective in materials or workmanship it will be replaced or repaired free of charge *(excluding any travelling costs / carriage costs which will be charged at our discretion)* provided that the press has been installed and operated in the correct manner and not subjected to misuse.
A charge will be made for any costs incurred if a reported fault on the press is found to be due to incorrect installation, operation and/or incorrect materials being used, as it is the responsibility of the press user to ensure the suitability of the materials operating through the press.
** *Exclusions - Pressure Pad GSW-16, PTFE GSW-18*

Application details for Wader Products

Your press should have the following settings: -
Temperature: - **200 / 210 °C** *(application dependent)*
Pressure: - **20 PSI**
Time Dwell: - **8-10 seconds**
The above is only a basic guideline you may need to change settings for special materials. To alter the settings see page 3.

We recommend that THERMAL materials / clothing are not used on this heat press.
Contact Sales For Special Material Settings.

Specifications

Supply Voltage 230 / 240 Volt AC. 500watt (8x6 - 700 Watt)., Microprocessor PID Temperature/Timer Control Unit.
Allowances should be made when P.A.T. testing.
240v Mica plate heating element including 40" leads and integral earth.
Cast Aluminium construction. Dry weight of 14 kg (8x6 15 kg).

Maintenance

Lubricate toggle linkage at **regular intervals** with light machine oil, this will ensure a long life of the toggle assembly and also a smooth operation.
Keep top PTFE cover in good condition.
Ensure that the silicone pad is in good condition.
Never clean the machine with abrasive cleaners or solvents that may damage the product.
Check all fasteners are tightened to the correct torque. This is particularly important with the heat plate fixing as these are under extreme heat and strain.

This machine is designed for application of heat-seal transfers, tape, badges and patches only.

- **Please ensure the manufacturers operating instructions are adhered to.**
- **A colour copy of this manual plus all the Wader machinery can be downloaded from the website www.wader.co.uk**
  We recommend a qualified engineer inspect the machine at six Monthly intervals

Fault Finding

No Mains light Or Control Display
Check the supply to press and condition of fuses (front panel & plug)
Is the press switched on?
Control Unit Transformer output of 12vac ?

Heat plate fails to get warm (refer to fig.2)
Does the element have continuity? *
Does the probe have resistance?
Is the relay switching over? (check SSR, and coil supply)

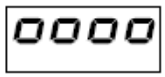
RTD Probe.
To test the probe condition remove completely from press and measure the resistance at room temperature using a multimeter.
Then warm the probe if the resistance changes the probe is working correctly.
This will only give you an approximation of the condition of the part.

Sealing Pressure Low.
Severely worn pad
Over compressed springs
Toggle links worn

Timer Buzzer
Toggle arm not making contact with micro-switch
Faulty micro-switch, check switching with meter.
Buzzer faulty check AC power supply to buzzer 230VAC.

Controller Error Codes

Out of range signals
The upper display shows the OVER-RANGE and UNDER-RANGE conditions with the following indications:
Over-range

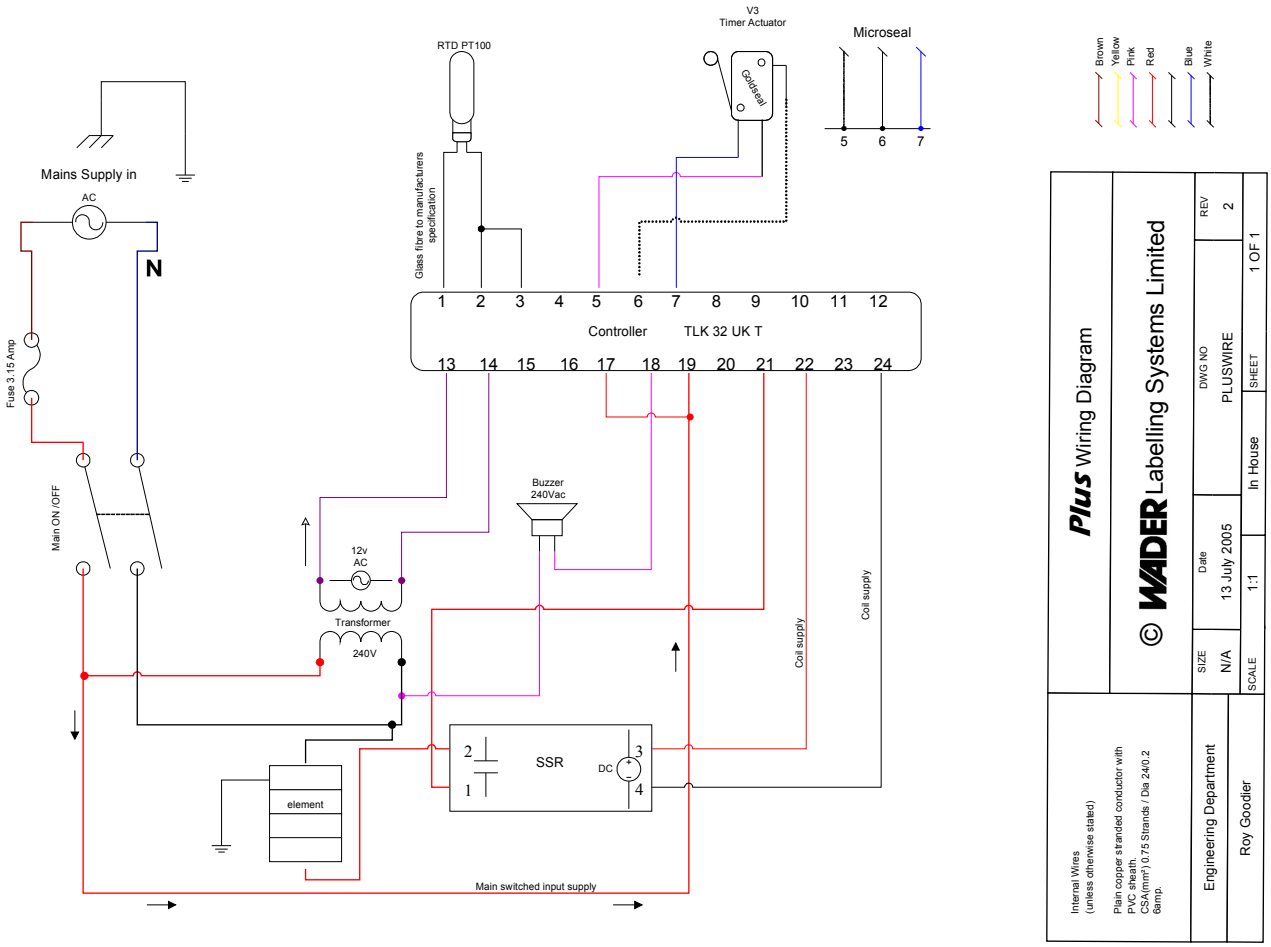


Under-range

The sensor break will be signalled as an out of range

NOTE: When an over-range or an under-range is detected, the alarms operate as in presence of the maximum or the minimum measurable value respectively.
To check the out of span Error condition, proceed as follows:
1) Check the input signal source and the connecting line.
2) Make sure that the input signal is in accordance with the instrument configuration.
Otherwise, modify the input configuration
3) If no error is detected, send the instrument to your supplier to be checked.
ErAT - Fast Auto-tune can't start. The measure value is too close to the set point.
Push the P button in order to delete the error message.
NoAt - Auto-tune not finished within 12 hours.
ErEP- Possible problem of the instrument memory.
The messages desappears automatically.
When the error continues, send the instrument to your supplier

Safety First When working on the heat press remember to always **DISCONNECT** the mains supply before removing covers or guards. Never allow your hands to be in a position that they may be trapped by the heat plate when you bring the handle down.



OEM *Parts List Goldseal 4x3*

PL-01	CONTROL UNIT (ascertain software / hardware version before ordering)	
PL-02	TRANSFORMER	(controller)
PL-03	BUZZER 240VAC	
PL-07	CONTROL RELAY	(ssr)
PL-05	MAINS SWITCH (Green Illuminated)	
PL-06	FUSE HOLDER	
GSW-01	BODY	(Main Casting)
GSW-02	LEVER HANDLE	(Operating Arm)
GSW-03	TOGGLE ARM	
GSW-04	PLATEN COVER	
GSW-05	BUSHES	(Oilite Bush)
GSW-06	PIN 125mm	
GSW-07	PIN 112mm	
GSW-08	PIN 38mm	
GSW-09	TOGGLE LINKS (Links are chemical blacked)	
GSW-10	CIRCLIPS	
GSW-11	GASKET L-21 (Heat plate to arm)	
GSW-12	HEAT PLATE TOP	
GSW-13	HEAT PLATE LOWER	
GSW-14	ELEMENT METAL CLAD	(500 Watt @ 240Vac)
GSW-15	PRESSURE SPRINGS	
GSW-16	SILICONE PRESSURE PAD	
GSW-17	PRESSURE PAD PLATE	(grade 525)
GSW-18	PTFE (pack of 5)	
GSW-19	MAIN TOGGLE SPRING	(Arm return spring)
GSW-22	RTD PROBE	
GSW-23	PROBE RETAINER	
GSW-24	MICRO-SWITCH	(Timer actuation)
GSW-26	BASE BOARD	
GSW-27	RUBBER FEET	
GSW-28	MAINS LEAD	
PL-08	MAINS INLET FIANGE FIXING 10amp	
GSW-32	PACKAGING	
GSW-33-plus	INSTRUCTION BOOK	
GSW-34	SET OF SCREWS	(Complete)
GSW-36	MICRO-SWITCH GASKET	
GSW-37	HEAT PLATE INSULATION GASKET	
GSW-38	HEAT PLATE SHIM	

(Optional Sizes 5x5, 6x4 & 8x6)

GSW-55-04	5x5 PLATEN COVER
GSW-55-16/17	5x5 SILICONE PAD AND PLATE
GSW-55-18	5x5 PTFE
GSW-64-04	6x4 PLATEN COVER
GSW64-16/17	6x4 SILICONE PAD AND PLATE
GSW-64-18	6X4 PTFE
GSW-86-04	8x6 PLATEN COVER
GSW-86-16/17	8x6 SILICONE PAD AND PLATE
GSW-86-18	8x6 PTFE
GSW-86-14	8x6 ELEMENT 700 WATT
GSW-86-19	8x6 MAIN TOGGLE SPRING
GSW-86-40	HEAT PLATE INSULATION

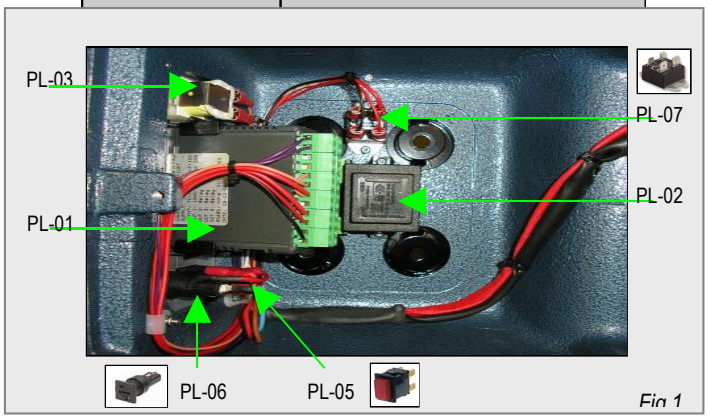
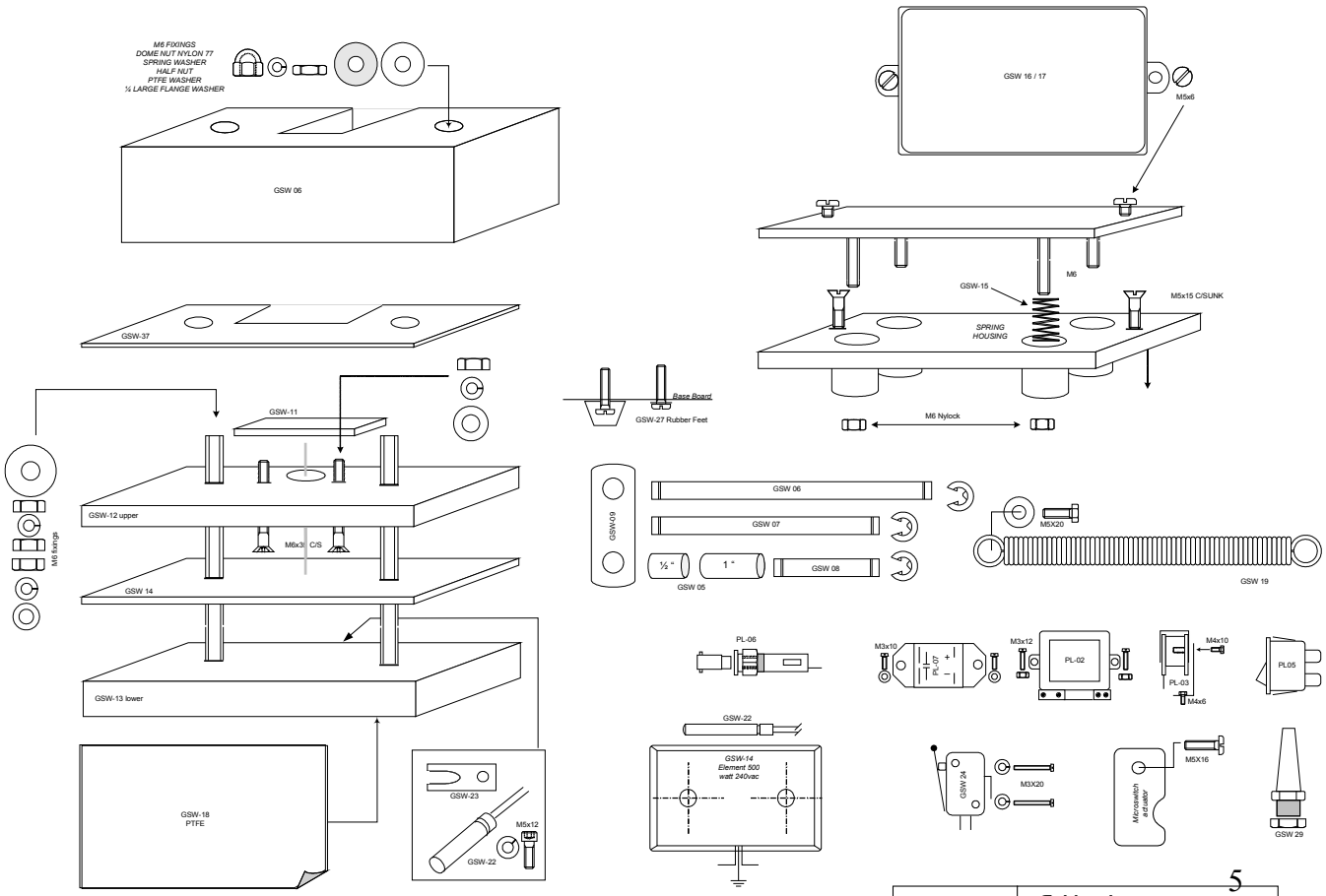


Fig 1



Studding all bright zinc plated. Metric fasteners all bright zinc plated.	Goldseal *Plus* Parts Assembly			
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Engineering Department	SIZE M/Imp	Date 03/08/2009	DWG NO Goldseal Plus Assembly	REV 2
Roy Goodier	SCALE NTS	In House	SHEET 1 OF 1	