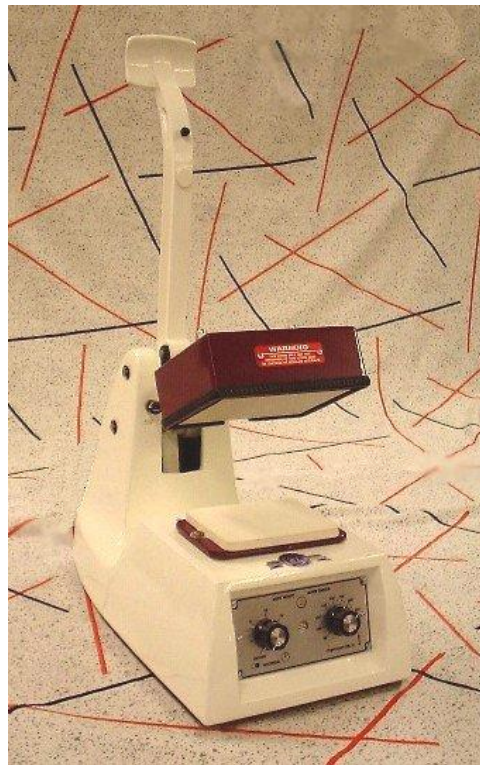


Miniseal

***Pneumatically Operated
Goldseal Heat Press***



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Operating Instructions

General description

This is a semi-automatic heat press for the use of applying heat seal tape, transfers and other heat seal items.

It consists of a heated upper platen that when brought down in to the sealing position will bond the transfer to the garment or sheet.

Operation / Set-up

The machine must be located on a firm work surface and near a single 240 Volt AC outlet.

The air supply must be filtered and supply a flow of air between 75 -100 psi in to the machine (*do not exceed the 100 psi limit*).

Ensure that the machine is in the open position and connect the air to the 1/8" BSP connector located at the rear of the machine.



Turn the pressure regulator to the desired sealing pressure (see gauge on opposite side of machine) to approx. 80 psi or 5 bar.



Plug the machine into a suitable power point and switch on at the front control panel; continue turning this knob to set the desired dwell time.

The small light in the centre of the control fascia will turn red, check that the other control knob (*temperature control*) is set to the correct position.



With The air supply set it should not be necessary to alter this unless the air is disconnected for any reason, just check the pressure gauge when you first come to operate the machine.

When the light on the front of the machine turns to green this indicates that the temperature set point had been reached and the machine is ready for use.

Sealing Transfers / Tape

Check The Temperature & Time Dwell Is Correct!

(Please ensure that the settings are right for the type of marking you are about to do, if in doubt contact your supplier)

If the above is OK then place the garment on the silicone base pad and put the transfer face down in the desired position.

Now bring the operating arm down until it locates against the toggle arm and the two are clamped together.

You will now here the pneumatic cylinder operate and the pad base will rise to the heat plate causing the transfer ink to bond to the material.

When the dwell time has expired the cylinder will release and the buzzer will sound, raise the operating arm to the open position and the buzzer will stop. Remove the transfer backing paper and the transfer will be bonded to the garment if it is not check the temperature, time & pressure settings.

Repeat the above procedure for applying other emblems **only altering the time, temp & pressure for different bonding applications / materials.**

Please note: -

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

Please ensure the manufacturers operating instructions are adhered to.

We recommend a qualified engineer inspect the machine at six Monthly intervals

Fault Diagnosis

No Front Panel Light

- Is the machine connected to a power supply?
- Test the fuse in the plug.
- Disconnect from mains supply and remove base cover and test fuse on control board and replace with equivalent type.
- Have a qualified service engineer check circuit board transformer and internal connectors.

Front Light Illuminates but Heat Plate Cold

- Element open circuit (test for continuity at element termination).
- Faulty probe (contact supplier for test procedure)
- Power relay contacts pitted.

Heat Plate Over Heating

- Check temperature control knob has the correct rotation.
- Replace probe if faulty.

Air Cylinder Fails To Operate

- Air supply connected to machine & regulator set?
- Test if the screw actuator on the operating arm is making contact it with the switch under the platen cover when the arm is in the locked position.
- Faulty Solenoid valve, contact your supplier on how to test this using the manual override.

Buzzer fails to sound & Cylinder does not release.

- Faulty V3 microswitch or poor contact remove base plate and test.
- Faulty Switching Relay

*Buzzer Fails To Sound **BUT** Cylinder Releases*

- Faulty Buzzer on PCB (contact supplier).

Low Sealing Pressure

- Check air pressure is set correctly.
- Replace silicone pad if worn.

Parts List Miniseal

GSP-2	LEVER HANDLE
GSP-3	TOGGLE ARM
GSP-4	PLATEN COVER
GSW-5	BUSHES TOGGLE & OPERATING ARM
GSW-6	PIN 125mm
GSW-7	PIN 112mm
GSW-8	PIN 38mm
GSW-9	TOGGLE LINKS
GSW-10	CIRCLIPS
GSW-11	GASKET L21 SINDANYO
GSW-14	ELEMENT (5.25 x 3.75") 500WATT
GSP-16/s	SILICONE PRESSURE PAD
GSW-17	PRESSURE PAD PLATE
GSW-18	TOP HEAT PLATE PTFE
GSW-19	MAIN TOGGLE RETURN SPRING
GSP-20	CONTROL UNIT TEMPERATURE & TIME
GSW-21	CONTROL RELAY 2off temp & valve control
GSW-22	RTD PROBE
GSW-23	PROBE RETAINER CLIP
GSW-24	MICROSWITCH (TIMER CONTROL)
GSW-25	INTERNAL CONNECTORS (CIRCUIT BOARD & RELAYS)
GSW-26	BASE BOARD
GSW-27	RUBBER FEET
GSW-28	MAINS CABLE
GSW-29	CABLE GLAND (M16)
GSW-30	CONTROL KNOBS 2off
GSP-31	CONTROL FACIA
GSP-33	INSTRUCTION BOOKLET
GSW-36	GASKET (TIMER CONTROL MICROSWITCH)
GSP-40	1/8 - 4mm BULKHEAD CONNECTOR
GSP-41	4mm "T" CONNECTOR
GSP-42	4mm - 6mm IN LINE CONNECTOR
GSP-43	MINI PRESSURE GAUGE
GSP-44	REGULATOR & M5 - 4mm ADAPTOR
GSP-45	SOLENOID VALVE
GSP-46	VALVE CABLE 240vac
GSP-47	SOLENOID VALVE AIR CONNECTOR (1 SET)
GSP-48	MAIN ACTUATOR (AIR CYLINDER)
GSP-49	1/4 - 4mm CONNECTORS 2 OFF
GSP-50	SPEED CONTROLLER (ACTUATOR)
GSP-51	4mm AIR LINE (2Mtr)
GSP-52	HIGH TEMPERATURE MICROSWITCH (HEAT PLATE)
GSP-53	BRACKET MICROSWITCH
GSP-54	SPRING LEAVER (PLATEN COVER SWITCH)
GSP-55	SOLENOID VALVE BRACKET

Pneumatic Parts



Main Actuator GSP-48



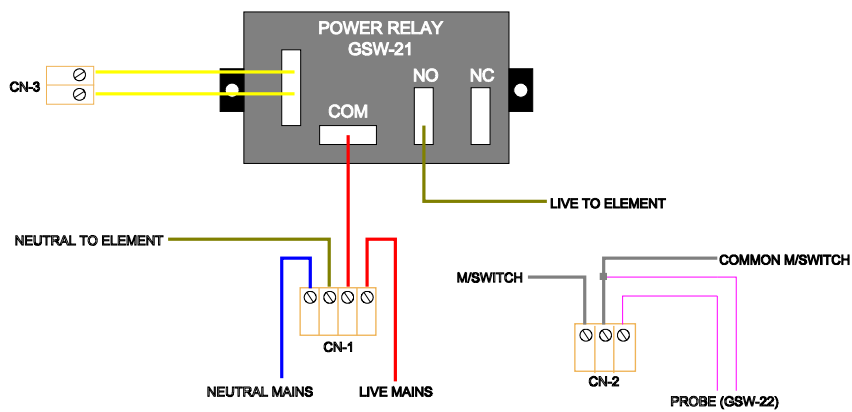
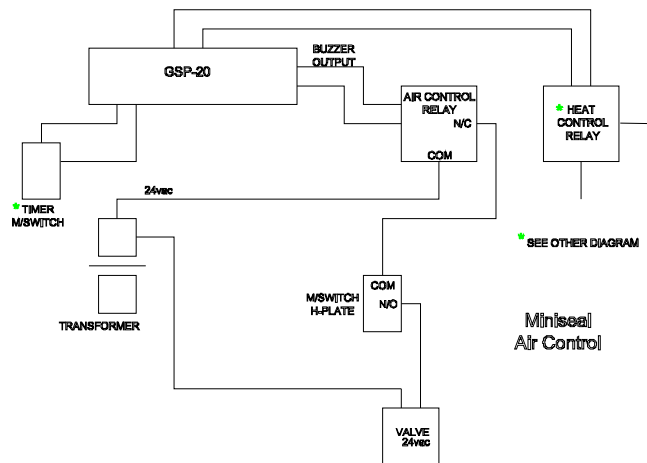
Regulator GSP-44



Valve SY3 series GSP-47



Pressure Gauge GSP-43



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GSW-21
 CONTROL
 RELAY