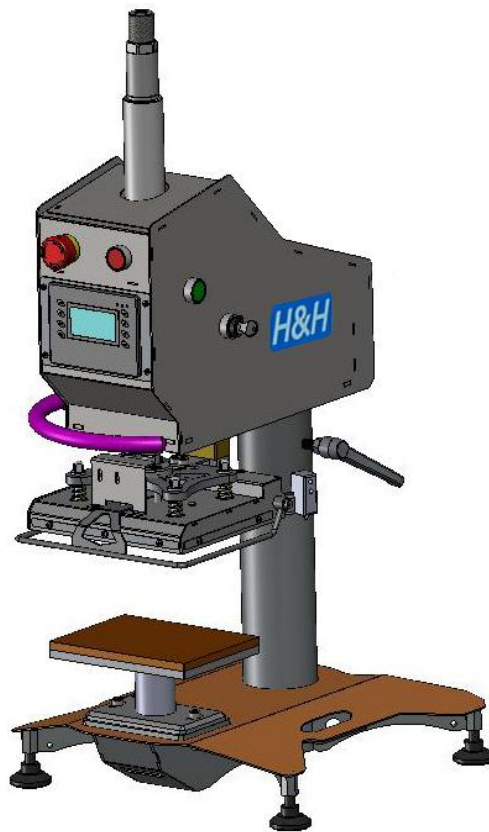


CS-653 Pneumatic Flat Press Machine**Operation Manual**

is powered by
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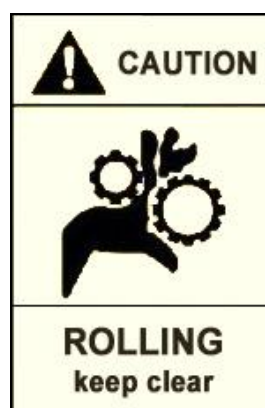
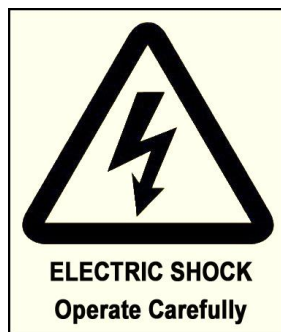
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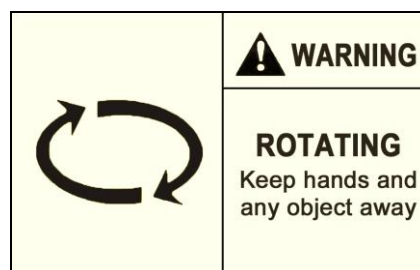
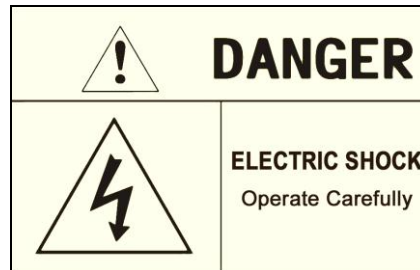
Appendix A Pneumatic Scheme

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> Precautions with regard to Safety

Please observe these safety tips for safe, efficient, an injury-free operation of your equipment. By strictly following all instruction contained in this manual you will certainly obtain an excellent performance from the use of this equipment for years.



> Precautions with regard to Safety (cont.)

> Name Plate

Model : CS-653				
Pneumatic Flat Press Machine				
spec A-D1A1-020015				
Voltage	Frequency	Power	Compressed Air	Weight
220 V	50/60 Hz	1000 W	>0.4 Mpa	50 Kg
Date :			S/N :	

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CE

> Introduction

Thank you for your choosing of CS-653 which is manufactured by H&H.

The pneumatic flat press machine described in this manual is one of the sophisticated machines for processing the flat press products in the market today. Built on pure digital control platform and designed for the professional users. Operators are recommended to have basic knowledge and skill in heat press operation before using this machine.

This manual is aimed for the operators to understand the machine and avoid damage to the machine or personnel. Please read this manual carefully and keep it well for daily reference usage.

> Specifications

Model	:	CS-653
Voltage	:	220 V, single phase
Frequency	:	50/60 Hz
Power Consumption	:	1000 W
Compressed Air	:	>0.4 Mpa
Heat Temperature Range	:	30~260°C
Press Duration	:	1~999 second
Heat Press Size	:	8" X 6"
Lower Platform Size	:	8" X 6", 6" X 2", ϕ 2.5"
Overall Dimensions	:	560mm (L) x 450mm (W) x 910mm (H)
Overall Weight	:	50 kg

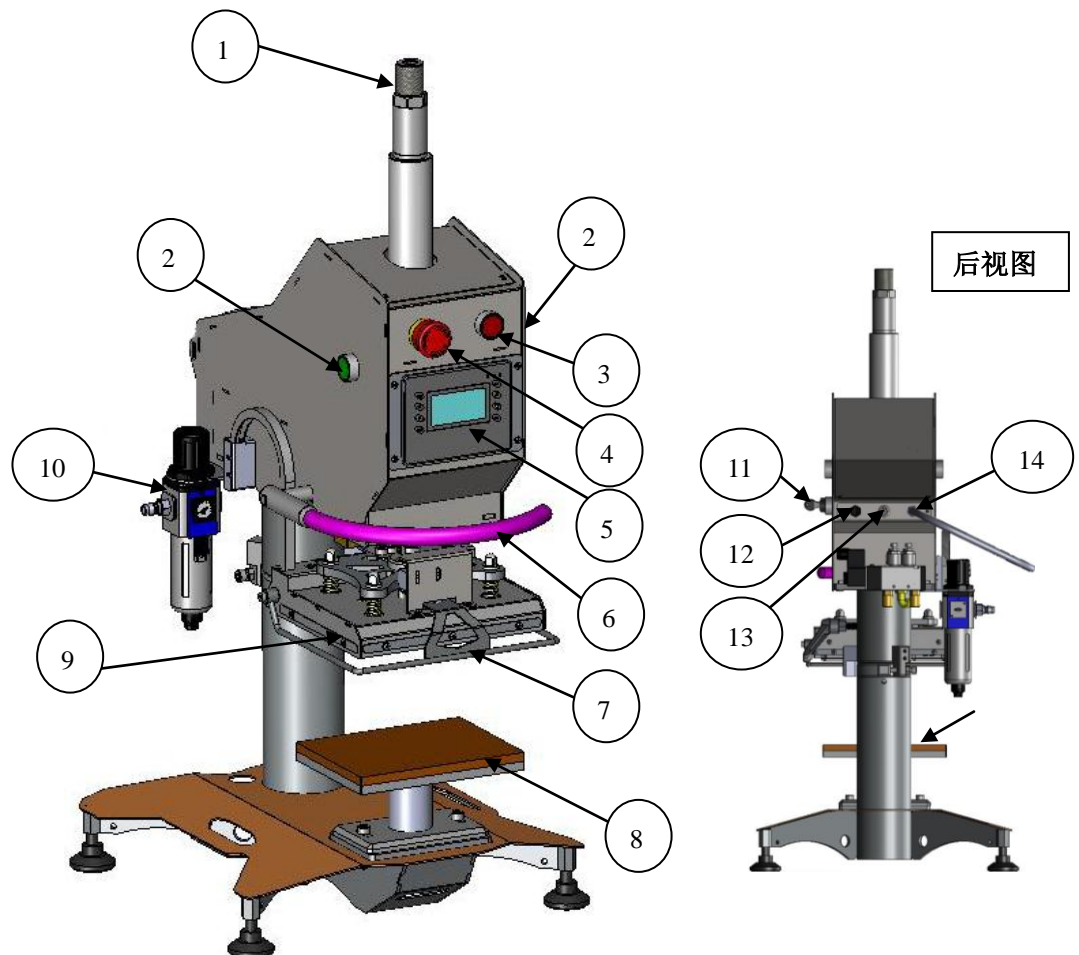
Note : due to continuous improvement, specifications are subjected to change without prior notification

> Features

- Control system - user friendly touch screen interface.
- Safety protection - safety lever around the main working area. The machine will stop when this lever frame is lifted. Both of the start buttons must press simultaneously and keep pressing until the heat plate trigger the lower limit switch, otherwise the heat plate downward motion will cancel and retract.
- Individual heat temperature control.
- Individual heat & cool cycle timing setting control

> Component Names

>> Front View



1. press cylinder work length adjusting knob (also can alter the pressure exerts on the work piece)
2. start buttons (in pair)
3. stop/cancel button
4. power on/off & emergency stop switch
5. touch screen control panel
6. manual control bar (push downward will trigger the downward motion of the press)
7. safety bars (will cancel the downward motion when hit once)
8. lower working table (platform)
9. upper heating plate
10. compress air filter & regulator
11. master key for locking the settings of the machine (e.g. timer, heat set point)
12. fuse
13. foot pedal (optional) connecting socket
14. power cord extension

> Preparation for Installation

Installation must be carried out by authorized personnel. Please act according to the following steps :

1. Remove the package of the machine and placed it on the ground level, cleaning the machine before operation.
2. Unleashing all packing cables which tie to the machine and allow it from free movement.
3. Connect air hose to the inlet of the air regulating filter at the back of the machine, make sure the air pressure not lower than 0.4Mpa. Once connected, the heat plate will go up with face down while the cool plate will face to front side. You can connect the foot pedal (optional) power plug with the corresponding socket at the back #15.
4. Connect the power cord with a 220V, 10A power supply.
5. Turn on the main power switch of the machine and switch on the power switch.
6. The touch screen panel will on and showing the welcome note and program loading. After a while, it will change to show the main control page.

> Operation and Controls

>> Language

The #1st page is “language”. It is used for selecting the language using in this panel.



>> Main page

The #2nd page is “main” page, it is used for setting & showing the temperature and time span.



1. select the temperature or timer set point
2. value “minus” button
3. value “add” button
4. heating temperature & time span preset value
5. lit up when heating is activated
6. real time heating temperature & time duration count down value
7. heating on/off button
8. next page button
9. previous page button

> Operation and Controls (cont.)

>> Counter

The #3rd page of the panel is named “counter”. It is the showing the accumulated press cycles.



Complete cycle: the total complete cycles are accumulated.

incomplete cycle: the total incomplete cycles are accumulated (caused by a mid-way cancel or the press work is terminated before the timer is reached to its set value).

>> Lock

The #4 page of the panel is named “lock”. It is used for lock or unlock the heating control set value. Switch the control lock key on (the lock will lit up on the screen) then select the temperature or time lock/unlock (lit will lit up on the right hand side circle when locked). Switch off the control lock key when the selection is finished. The operator cannot alter the set value when the selection is locked.

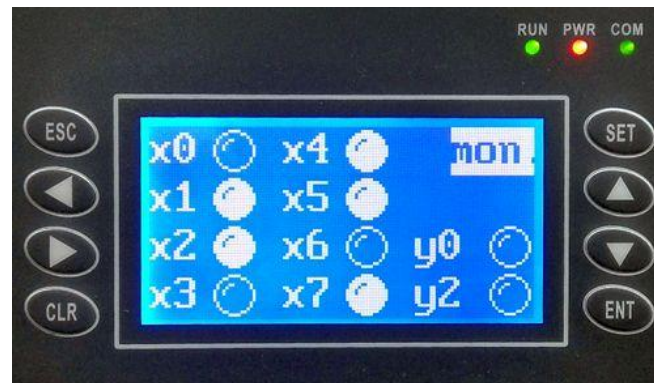


1. setting the temperature set point lock/unlock button
2. setting the timer set point lock/unlock button
3. previous page button
4. next page button

> Operation and Controls (cont.)

>> Monitor

The #5 page of the panel is named “counter”. It is the showing the accumulated press cycles.



The signal feedback code lit up table explanation:

x0	Manual control bar on	x4	Safety bar on/off		
x1	Manual control bar off	x5	Lock key on/off		
x2	Red cancel button	x6	Start button pair on/off	y0	Solenoid on/off
x3	Foot pedal on/off	x7	Cylinder lower limit switch activated/off	y2	Heating on/off

> Operation and Controls (cont.)

>> **Offset**

The #6 page of the panel is named “offset”. It is used for temperature calibration. Switch the control lock key on (the lock will lit up on the screen) then select the temperature minus or add value from the corresponding button. Switch off the control lock key when the selection is finished.



1. value “minus” button
2. value “add” button
3. previous page button
4. next page button

> Operation and Controls (cont.)

>> Preferences

The #7 page of the panel is named “preferences”. It is used for selecting the control of the press with either handle bar/foot pedal or both. Switch the control lock key on (the lock will lit up on the screen) then select the corresponding press control method (the bulb at the right hand side will lit up when selected). Switch off the control lock key when the selection is finished.



1. manual handle bar control on/off button (the bulb at the right hand side will lit up when selected)
2. foot pedal control on/off button (the bulb at the right hand side will lit up when selected)
3. previous page button
4. next page button

>> Press Pressure Adjustment

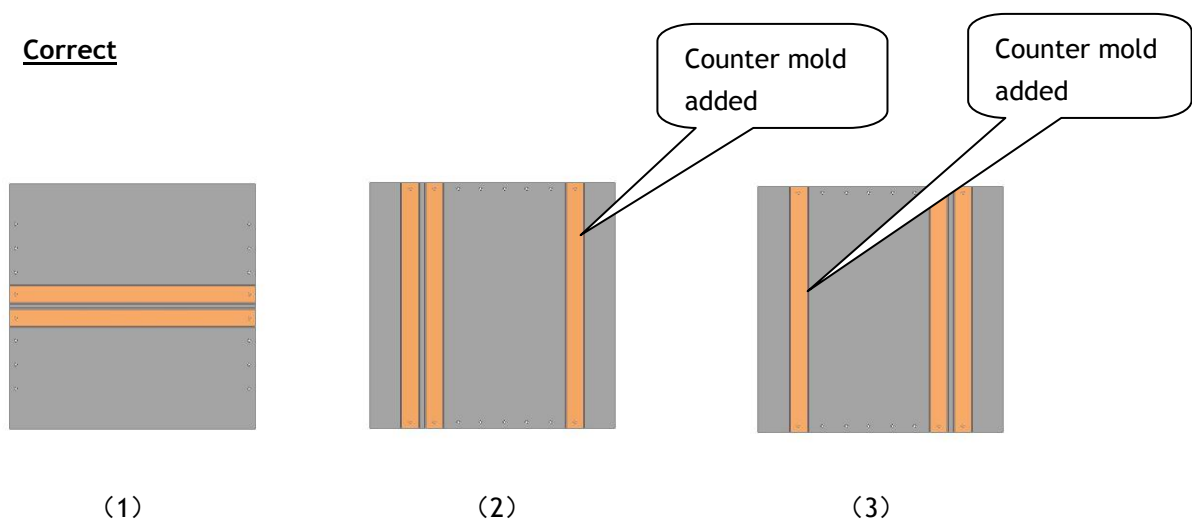
- A. Turning the knob on the compress air filter regulator to adjust the press pressure.
- B. Turning the press pressure adjusting knot for the cylinder work length to adjust the press pressure.

> Precaution when Using Mold

Some application require a special mold as fixture to position the object correctly, examples are zipper mold or pocket mold. It is essential that the center of mold is position directly under the center of the press, or otherwise the downward pressing force from the main cylinder may induce a rotating force to the rotating head. This may cause damages to the press head and the cylinder and may also affect the overlook of the product due to uneven pressure. In case the mold is required to position off center, a counter balance mold of the same height is necessary to correct the force of the press.

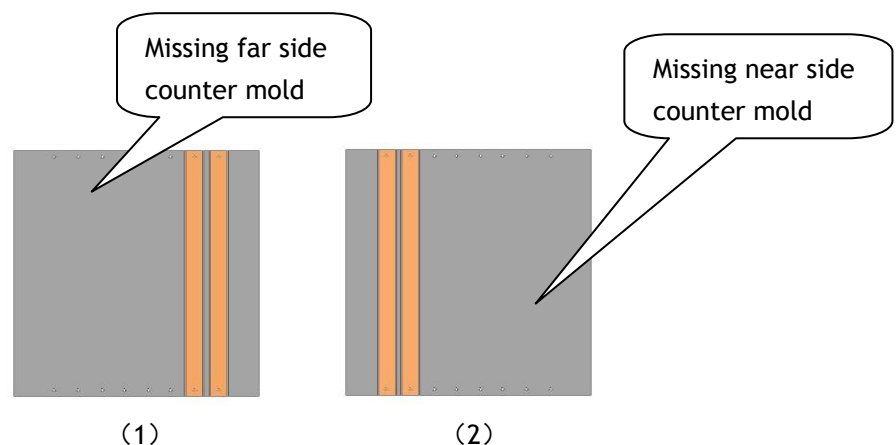
The following illustrations (top view) demonstrate the correct and incorrect method of using mold.

Correct



1. Zipper mold is positioned at the center of the working table.
2. Zipper mold is positioned off centered, a counter mold is added at the right hand side of the working table.
3. Zipper mold is positioned off centered, a count mold is added at the left hand side to balance the force

Incorrect



1. Missing left hand side counter mold
2. Missing right hand side counter mold

> Cleaning and Maintenance**>> Cleaning the Thermo Plates**

During operation, excess glue or residue may deposit on the surface of the lower silicone rubber and/or the top heat or work piece. This may deteriorate the outlook of the final product in the coming cycle and cleaning is necessary. To carry out this operation, we suggest you to use a dry piece of towel to wipe off the surface of the heat plate. There is no particular schedule for this type of cleaning, do it whenever required.

>> Daily Maintenance

- Operate the machine a few cycles before use, pay attention to any unusual noise. This may indicate a problem.

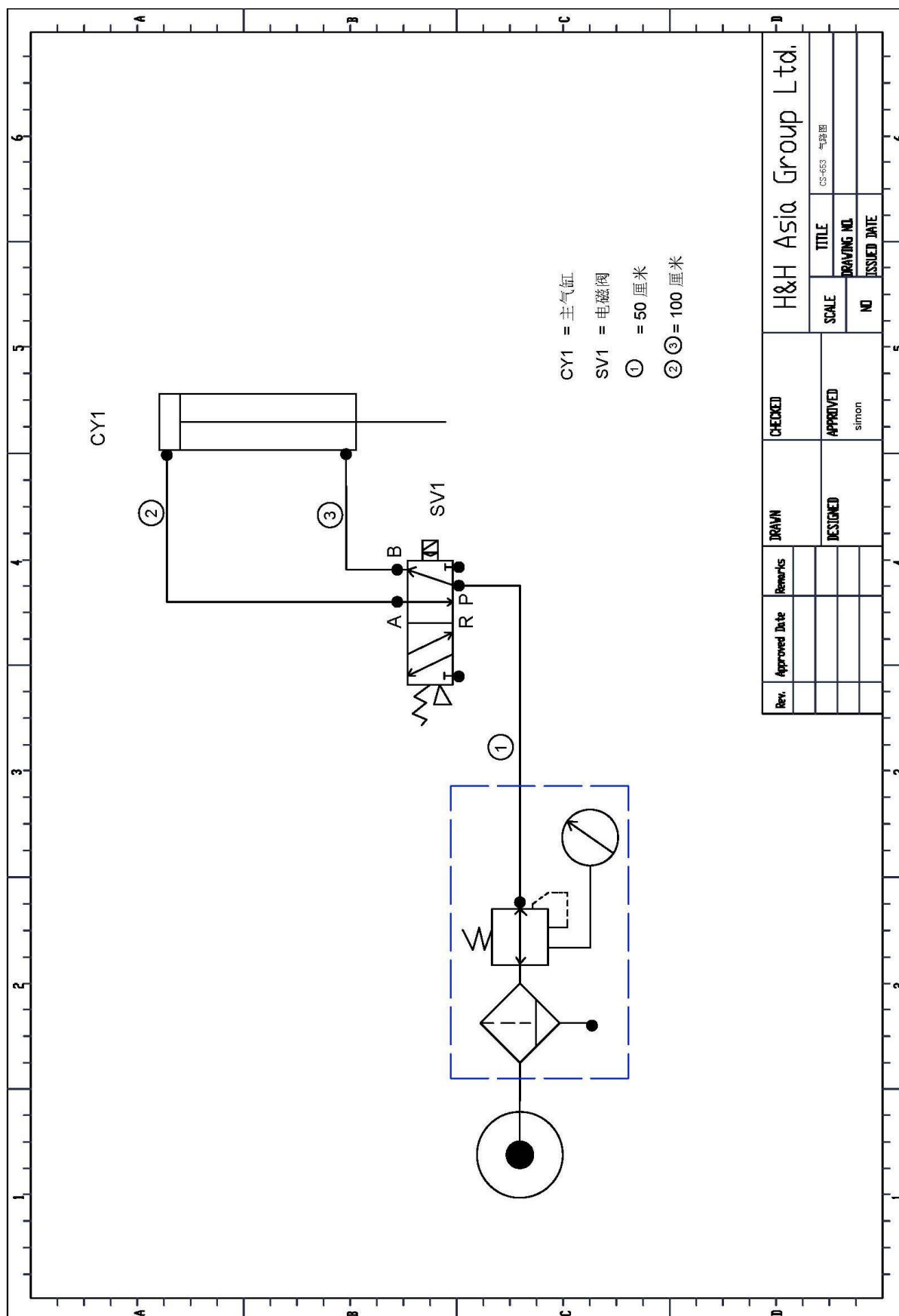
>> Monthly Maintenance

- Check the main press side guide rods for smoothness, apply lubrication if needed.
- Inspect the Teflon paper from wear and tear on both the heat press and the cool press, as this may affect the outlook of the finished product. Replace with a new one if necessary.

> **Trouble Shooting**

Problem	Cause	Solution
Display not light up Whole machine not working	Power supply not connected	Plug in a suitable power supply
	Power plug not secure	Try to plug in socket again
	Overloaded circuit breaker and/or RCB tripped	Check the problem and reset breakers
Heat plate not heating up	Heater not enabled	Press the ENT button once
	Preset temperature lower than room temperature	Change preset temperature above room temperature
Excess noise and vibration during operation	Floor is not level or wheels are not locked	Reposition machine to a level and solid floor

Appendix A . Pneumatic Scheme



Appendix B . Wiring Scheme

