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Model: T1620/24-APL2-D

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T1620/24-APL2-D Series User Manual

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Overview

1.1 Equipment Overview

Thank you very much for choosing our pneumatic dual-station T1620/24-APL2-D series heat press machine!

Please read this instruction manual carefully before use to ensure correct operation.

Please keep this manual in a safe place for future reference. Depending on the specific configuration, some machines may not feature all functions listed in this manual.

Please refer to your actual model for specific operational features.

1.2 Safety Precautions

NOTICE



The manufacturer is not responsible for damage, injury, production loss, or other losses caused by improper operation, unauthorized modification, incorrect installation, incompatible parts, or service by unqualified personnel.

1.3 Operating Environment

- Indoor, dry, clean, and well-ventilated location.
- Operating / Storage Temperature: 41°F–104°F.
- Relative Humidity: 30%–90%, non-condensing.
- Stable, level, heat-resistant work surface.
- Keep away from water, excessive dust, corrosive gases, flammable materials, and explosive vapors.

1.4 Grounding & Technical Parameters

1.4-1 Grounding Requirements:

To prevent electric shock or fire caused by leakage, overvoltage, or insulation failure, please ensure the equipment is reliably grounded.

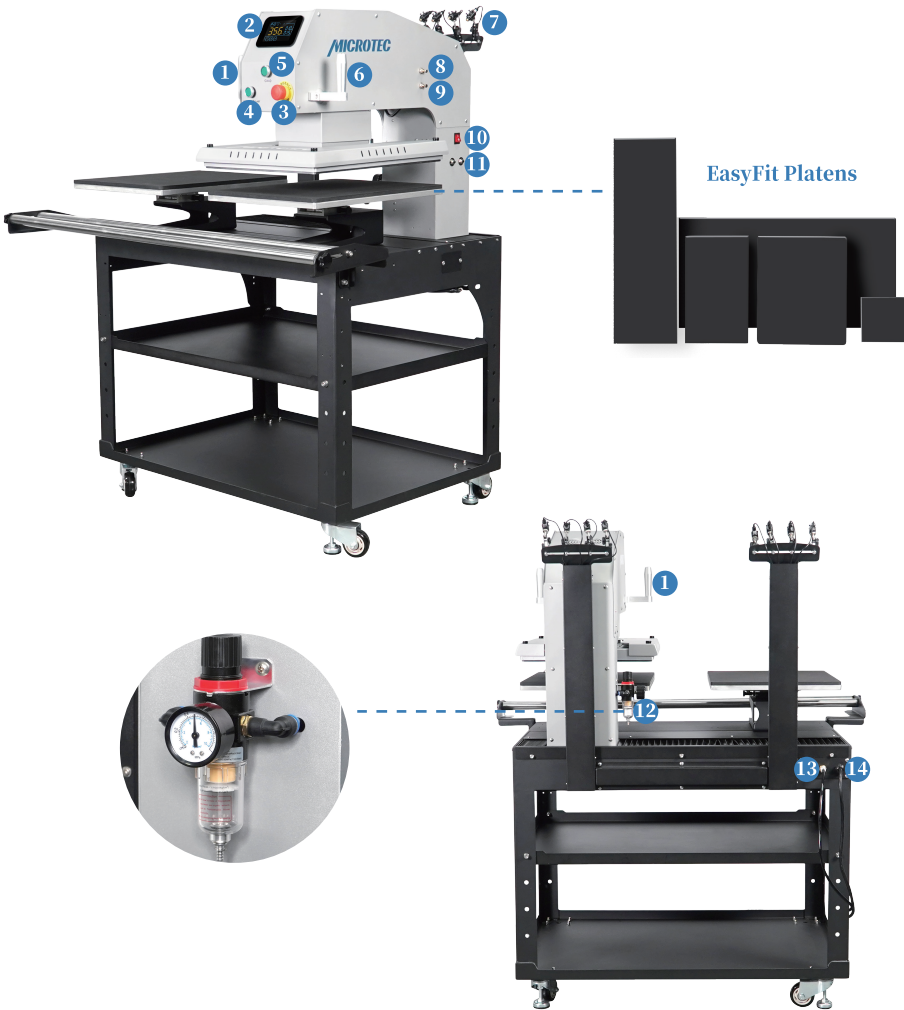
1.4-2 Technical Parameters:

MODEL NO.	T1620-APL2-D	T1624-APL2-D
Controller	GY-13	GY-13
Amp\Voltage\Power\phase	14.2A\120V\1700W, 60HZ	14.2A\120V\1700W, 60HZ
Time Range(S)	0~999	0~999
Temperature Range(°F)	32~446	32~446
Heating plate size (Inch)	15.7*19.6	15.7*23.6

Appearance and Functions

2.1 Exterior View

(Please refer to the images in your original document for labels 1 through 14.)



2.2 Component Names and Functions

1 & 6. Left & Right Start Buttons: When the heating platen is aligned over either station, simultaneously press both the left and right start buttons to activate the temperature controller. The heating platen will press down to begin heat transfer.

2. GY-13 Temperature Controller: Controls machine heating parameters, timing, and transfer cycles.

3. Emergency Stop Switch:

If pressed during the heat transfer press-down cycle, the heating platen will immediately raise and abort operation.

If pressed while the heating platen is moving horizontally between stations, the platen will immediately halt. Once the emergency stop switch is reset, the platen will resume moving in its original direction.

4. Alignment Laser Power Switch: Turns the alignment lasers ON and OFF.

5. Station Toggle Button: When the heating platen is at its fully raised position, tap this button once to automatically switch the platen to the opposite station.

7. Alignment Lasers: Provides fast, accurate alignment and positioning for the transfer graphics.

8. Throttle Valve (Upward Speed): Adjusts the upward/ascent speed of the heating platen.

9. Throttle Valve (Downward Speed): Adjusts the downward/descent speed of the heating platen.

10. Power Switch: Cycles the main power of the machine ON and OFF.

11. Self-Resetting Circuit Breakers (x2): Automatically pop out to cut off power in the event of an electrical overload. Once the fault is resolved, press them back in to restore standard operation.

12. Air Pressure Regulator & Gauge Assembly: Displays the current working pressure and allows adjustment of the operating pneumatic pressure.

13. Air Inlet Coupler: Connects the external air supply required for the horizontal movement and downward pressing of the heating platen.

14. Power Cord: Supplies the main electrical power for the entire machine.

2.3 Operation Steps

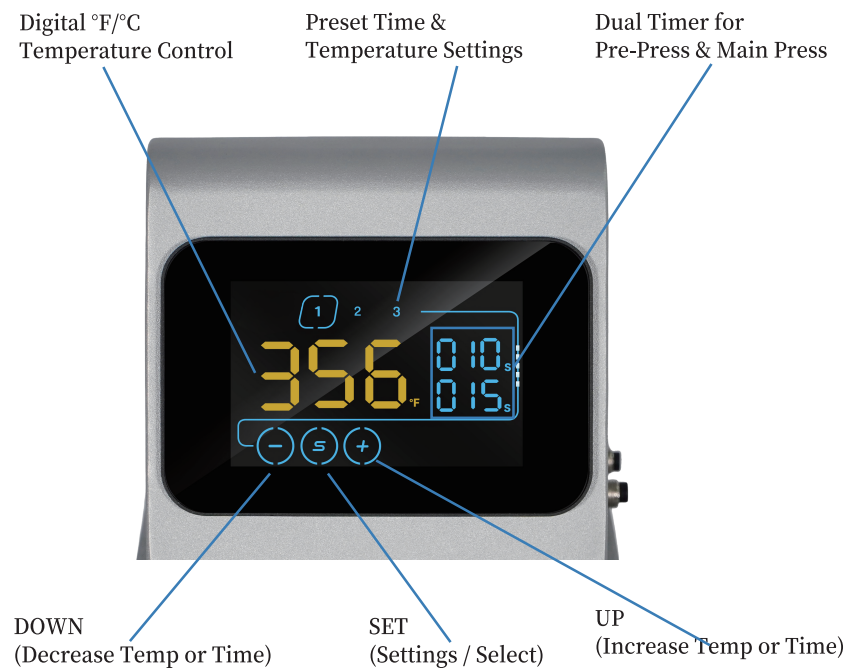
1. Connect the main power cord [14] to an AC 120V outlet matching the equipment electrical rating. Connect a suitable clean air supply to the air inlet coupler [13]. Turn ON the power switch [10]. Pull up the black adjustment knob on the air pressure regulator assembly [12] and rotate it to set the working pressure between $4\sim6 \text{ kg/cm}^2$ ($0.4\sim0.6 \text{ MPa}$), then push the knob down to lock.

2. Place the substrate and heat transfer material flat onto the lower station bed that is currently clear of the heating platen.

3. Once the platen reaches the pre-set operating temperature, tap the station toggle button [5]. The heating platen will automatically glide over to the station containing the prepared materials. Simultaneously press the left and right start buttons [1] and [6] with both hands to initiate the cycle timer. When the timer counts down to zero, the heating platen automatically raises, completing the heat transfer cycle.

4. Repeat steps 2 and 3 for continuous production cycles.

2.4 GY-13 Touch Screen Working Interface



2.5 GY-13 Temperature Controller Instructions

2.5.1: Press preset buttons 1/2/3 to quickly switch between saved application settings.



Preset [1] is selected in the image below.



Preset [2] is selected in the image below.



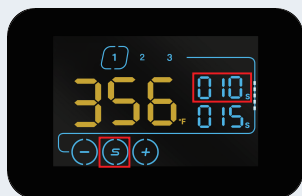
Preset [3] is selected in the image below.

2.5.2 Adjusting Settings

Once a preset is selected, follow these steps to customize the temperature and time:



1. Tap the "S" key; the temperature unit "°F" will flash. Tap "-/+" to adjust the temperature (range: 32–446 °F).



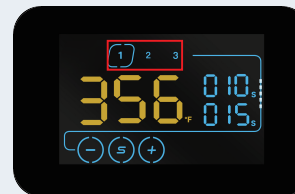
2. Tap "S" again; the first timer value will flash. Tap "-/+" to adjust (range: 0–999 seconds).



3. Tap "S" again; the second timer value will flash. Tap "-/+" to adjust (range: 0–999 seconds).



4. Tap "S" once more to save, exit, and return to the main interface.



5. **Preset Memory:** Settings are automatically saved to the selected preset memory: Preset 1, 2, or 3.

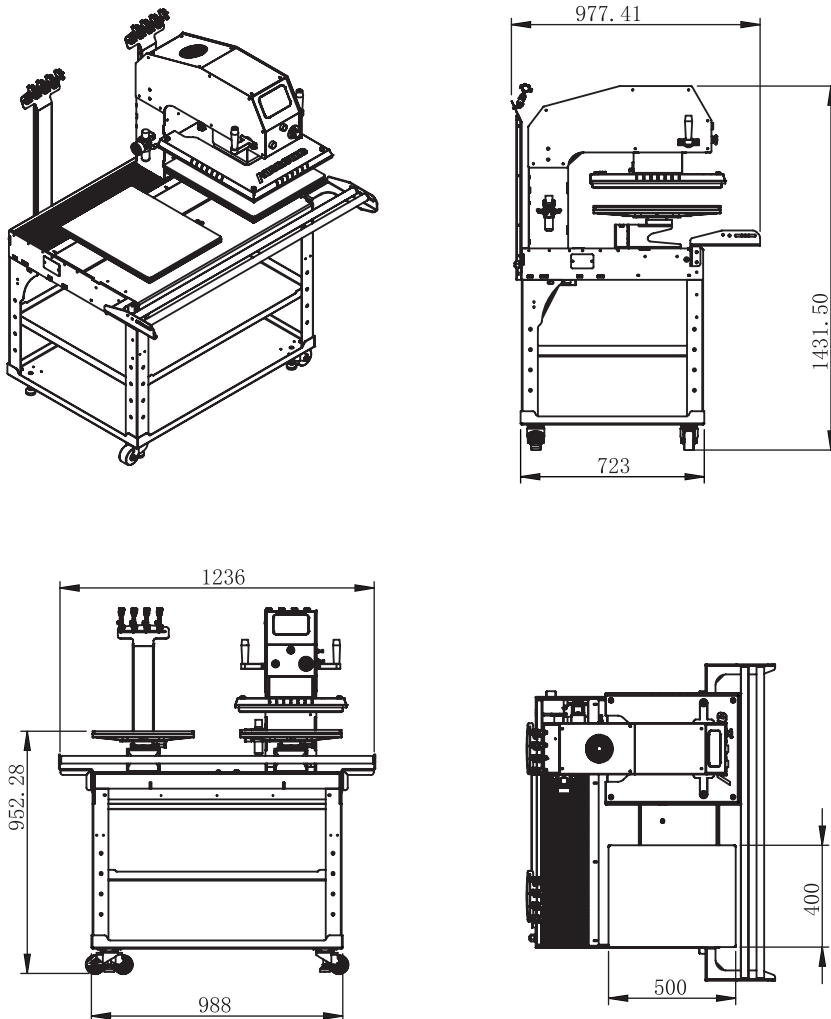


6. **Dual Timer Function:** The dual timers operate in sequence. After the first timer finishes, the second timer will start automatically. If only one timer is needed, set Timer 1 to 0 and use Timer 2 only.

For further instructions on the controller, please contact your supplier!

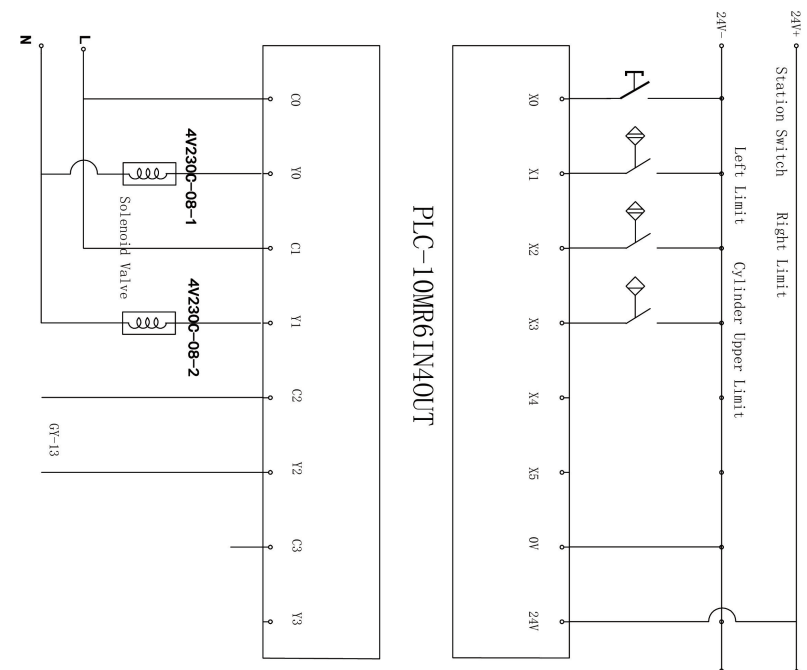
2.6 Equipment external dimensions

(Refer to the technical drawings in your original document for specific measurements.)



Circuit Diagram

(Refer to your original document for the diagram layout.)



Pneumatic Diagram

(Refer to your original document for the diagram layout.)

