

S-450D/P & S-650D/P

Auto Opening with Pressure Readout
15"x15" & 16"x20" Heat Transfer Machines

OWNER'S MANUAL

The S-450D/650D will be replaced by the S-450P/650P Models. These Models are auto open. That is they close manually and open after your preset time. The P model has the added feature of a digital pressure readout. Simply set the pressure number established for your transfer application for reproducible pressure settings every time.



S-650P shown



CORPORATION

For Customer Service, Call **1-800-835-0606**
ext. 209, ext. 211, ext. 220, ext.221 or
Visit www.hixcorp.com

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BEFORE warranty repair you MUST get Prior Authorization:

RECEIVING AND INSTALLATION

UNPACKING & INSPECTION

Remove packing material and tape. Remove bolts holding machine to bottom board. Inspect your machine for hidden shipping damage. Contact the delivery company immediately, should you find damage.

CAUTION: Handle must be tied to base before moving or shipping.

SHIPPING OR RETURNS

NOTE: Save all of your shipping/packing materials.
DO NOT RISK COSTLY SHIPPING DAMAGE!
SHIP ONLY IN ORIGINAL BOX.

1. Fasten machine to plywood shipping base with bolts provided.
2. Tie or tape handle securely to base.
3. Place in original box, and put side liner and top liner in place. Fold in flaps and seal the box.

(Additional bottom boards, box and liners may be obtained from your supplier for a nominal cost.)

INSTALLATION

Plug the machine into the correct grounded electrical outlet.

WARNING: When using an extension cord, use 12 or 14 ga.-3 conductor. Maximum length, 25' (7.62 m).

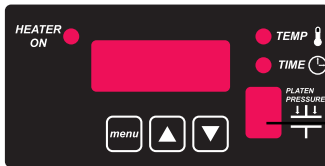
OPERATION

Your semi automatic press features Automatic Opening at the end of each count down timer setting. The press will simply release and open. **DO NOT** pry or try to open press, there is an emergency release lever atop the handle if you ever need to interrupt the countdown and get the press open. **CAUTION:** Do not lean over press when cycle is complete. Injury could occur.



Digital Display
For Class D Models

Manual/Emergency release



Digital Display
For Class P Models
Pressure
Readout

TEMPERATURE & TIME INSTRUCTIONS

1. Turn on the machine by pushing the on/off switch.
2. To change or set the temperature, press the menu button on the digital control. The light next to “TEMP” will light. Press the up ▲, or down ▼, button to your desired setting.
3. To change or set the time, press the menu button a second time on the digital control. The light next to “TIME” will light. Press the up ▲, or down ▼, button to your desired setting.
4. When you have your desired settings **press the menu button a third time to lock in your settings** otherwise the machines previous settings will revert back.
5. When the machine reaches the preset temperature, the controller will beep once. Machine is now ready to use.
Note: The controller has a high temperature alarm. If the machine temperature ever exceeds 460° F (238C) then the controller will beep continuously to alert the operator.

PRESSURE

1. The pressure control knob, located on the top of the machine, should be set so that the heat head will lock down firmly.
2. Pressure is reduced by turning knob (with machine open) **counterclockwise** and increased by turning it **clockwise**.

Pressure knob



OPERATION

3. The amount of platen pressure can be monitored on the controller with the display labeled "Platen Pressure." A value between 0-9 will be displayed when the machine is closed indicating the amount of platen pressure on the machine. Values of 0-3 indicate "light" pressure, 4-6 "medium" pressure and 7-9 "heavy" pressure. If the value exceeds 9 then a "-" will appear in the display indicating that the maximum value that can be displayed has been exceeded.

NOTE: Adjustments may be required from one garment to another and will vary to achieve the desired result.

CAUTION: Excessive pressure can cause structural damage, voiding the machine warranty!

TRANSFER APPLICATION

1. Set the temperature, time, and pressure to the desired settings as instructed on page 3. **Always** consult your specific transfer manufactures recommendations.

Successful transfer work depends on the correct balance of time, temperature and pressure. The type and thickness of the material and the kind of transfer being used will determine what settings are necessary. Always "pretest" a new transfer (or if unknown settings) on "pellon" or scrap garment before applying to a new garment to avoid unnecessary spoilage.

2. Align garment on the lower platen and smooth out the wrinkles.
3. Position the transfer and close the machine.
4. Pull operating handle down, locking the machine closed. After the designated time has elapsed, the machine opens automatically. If you want to open the machine before the timer has counted down to "0", pull the release lever on the top of the machine's arm. (**See Page 3**)
5. Continuously peel the paper off the transfer (away from your garment). **NOTE:** Do not fold the transfer back on itself.

If a hot peel/split transfer is being applied, **immediately peel** the paper after the machine has opened. **DO NOT** allow the transfer to cool. If a cold peel transfer is being applied, rub the transfer with an eraser or cloth and allow to cool for 5-10 seconds before removing the release paper.

Specific application instructions are enclosed with each transfer.

MAINTENANCE

Lubrication

NOTE: Unplug the machine before lubricating.

Your press requires lubrication every 6 months. Using 3-in-1 oil (available from your hardware store), add one to two drops of oil on all moving parts.

Cleaning The Heat Platen

Unplug the machine.

After cooling you may clean the heat platen with steel wool, scrubby, scouring pad/warm water or fine wire brush.

PLATEN REMOVAL

Your press comes standard with a removable 15"x15" (450) lower platen or a removable 16"x20" (650) lower platen. They are both interchangeable with a specifically designed lower platens. Interchangeability is quick, simple and toolless.

1. Remove pin (Fig. A). Grasp the lower platen with both hands and lift both sides upward in a slow, smooth and even motion. Again, lift both sides evenly to insure easy removal of the platen. (Fig. B)
2. By using the same process in reverse you can place the desired platen back onto the press.



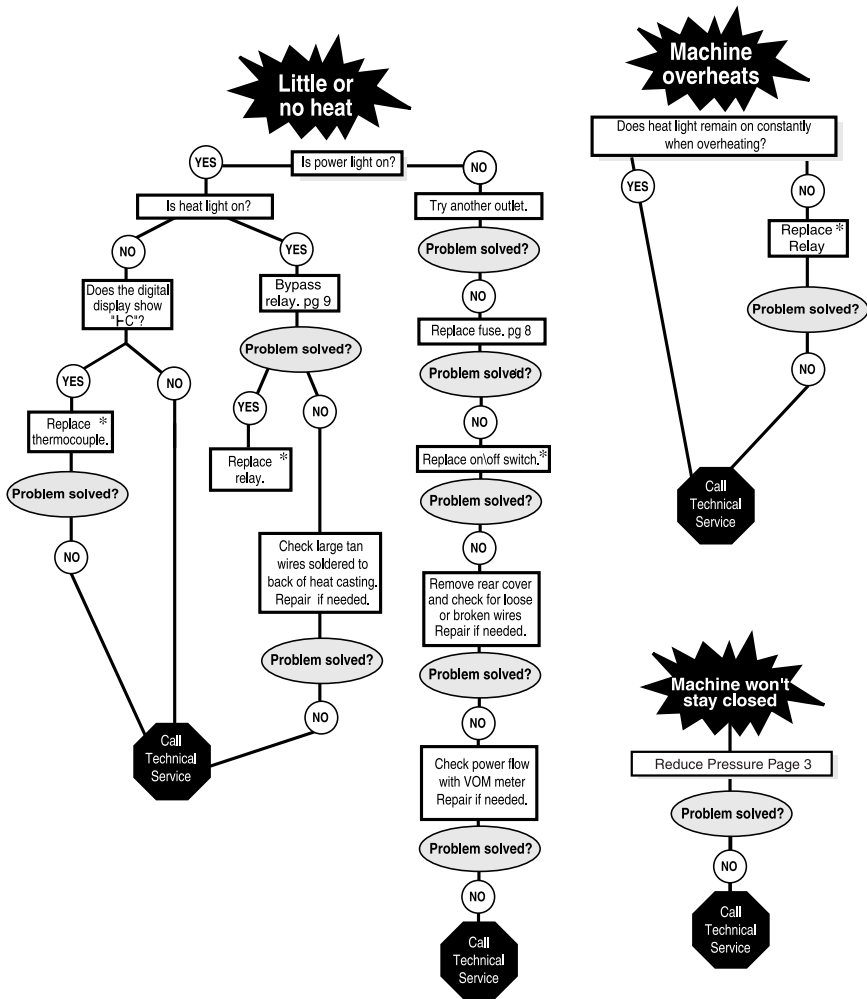
(Fig. A)



(Fig. B)

TROUBLESHOOTING

WARNING: Before making repairs, be sure on/off switch is off and machine is unplugged!



*Customer Service Tech Sheets are available for this step. Visit www.hixcorp.com to print or call 620-231-8568 and we will send you one. Parts ordering is available on-line.

TROUBLESHOOTING

Problem: Machine won't release at the end of time.

Q. Do you hear the solenoid click when the timer reaches zero?

If yes – Reduce the pressure on the machine and see if it will release then.

If no – with a volt meter check for voltage across the solenoid coil wires when the timer reaches zero. If you have line voltage (120V or 220V) then the solenoid is bad and needs replaced. If there is no line voltage the controller is bad and needs replaced.

Does reducing the pressure fix the problem?

If no- try manually releasing the machine with the **manual release lever**.

If yes – continue to use the lower pressure setting.

Does it manually release?

If Yes – remove the solenoid cover and inspect the connecting pin on the solenoid to see if it is intact or broken. If broken, replace the pin.

If no – inspect the latch mechanism to see if it is jammed.

Problem: Platen pressure indicator not working properly.

Q. Does the platen pressure display show "0" when the press is locked down?

If yes – Try increasing the pressure

Does increasing the pressure fix the problem?

If no- Call technical support. 800-835-0606

If no – does the display show "-"?

If yes – try reducing the pressure

Does reducing the pressure fix the problem?

REPAIRS

FUSE REPLACEMENT

WARNING: Before making repairs, be sure on/off switch is off and machine is unplugged!

1. Remove back cover of the machine and locate internal fuse holder on inside of the machine. (See page 9 for diagram)
2. Remove blown fuse. Replace with the proper fuse.
S-450D/P & S-650D/P: 120V=MDA-15; 220V=MDA-10
3. Replace back cover of machine.

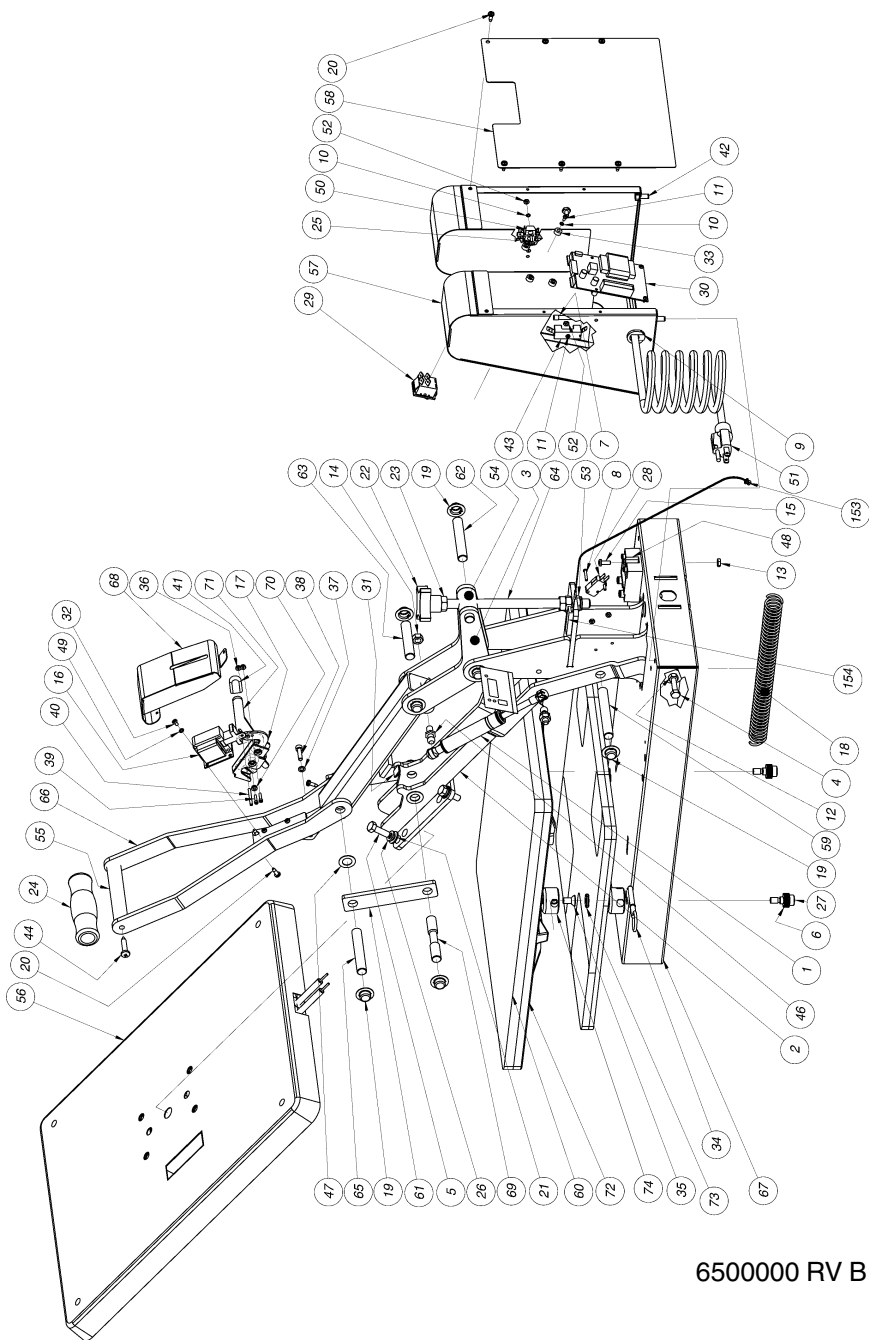
RELAY BYPASS

WARNING: Before making repairs, be sure on/off switch is off and machine is unplugged!

1. Remove the back cover of the machine.
2. Remove wire #26 from terminal #2 on relay.
3. Loosen terminal #1 on relay and replace wire #26 along with wire #12 under terminal #1.
4. Tighten the connection.
5. Plug machine in and turn the power switch on.

NOTE: Replace the relay if the machine starts heating. This is a test only. Do not operate machine with relay bypassed.

PARTS IDENTIFICATION



650000 RV B

PARTS IDENTIFICATION

KEY: 220V Only* Custom Part** Not Shown[•] SN= Serial Number

#	DESCRIPTION	Part #	Qty.
1	GAS SPRING	15753	1
2	MAIN ARM WELDMENT	A0100001**	1
3	ROCKER LINK	10502	2
4	BOLT 1/4-20x1-3/4 ZP	10710	2
5	BOLT 5/16-18x1	10769	4
6	WASHER SPG STL .38x.75x.034	12386	12
7	FUSE 15A	13045	1
7	FUSE 10A	76752*	2
8	SCREW MCH 4-40x3/4 ZP	13103	1
9	CORD GRIP	13250	8
10	LOCK WASHER #4	13919	7
11	SCREW MCH 4-40x1/4 ZP	14524	4
12	NUT HEX 1/4-20 ZP	14548	4
13	NUT HEX 10-24 ZP	14563	2
14	NUT HEX 5/16-18 ZP	14605	4
15	SCREW MCH 10-24x1/2 ZP	15339	1
16	SOLENOID, 120v PULL	15751	1
16	SOLENOID, 220v PULL	15752*	1
17	ROTARY LATCH	15754	1
18	EXTENSION SPRING	15834	1
19	NUT PUSH .500	20214	10
20	SCREW TAP-B PHPH 8x1/2 ZP	21482	11
21	WASHER-0.344x0.6875x0.0625	24732	4
22	PLASTIC KNOB	25143	1
23	NUT JAM 1/2-20 ZP	25151	3
24	HANDLE GRIP FOAM	26840	1
25	SCREW MCH 4-40x1/2 ZP	29807	2
26	WASHER LOCK 5/16	30910	4
27	SCREW SHOULDER .375x.500	30929	2
28	LIMIT SWITCH	31823	1
29	ROCKER SWITCH	32581	1
29	ROCKER SWITCH 220v	33754*	1
30	CONTROL TEMP CVC PDB BOARD FOR THE S-450D & S-650D MODELS	34681	1
		34711	1
30	CONTROL TEMP CVC PDB BOARD FOR THE S-450P & S-650P MODELS	38385	1
		38393	1
30	CONTROL DYN HTM (both required)	65315	1
	RELAY SS 50A 90-280VAC INPUT	84368 [•] (before SN 650-1081)	1
31	BUMPER 1/8x1/2 SQ BLK RUBBER	35408	2
32	SCREW MCH PH PHIL 6-32 x 1/4 ZP	36587	4
33	SPACER .171X.375X.188 NYLON	36595 (after SN 650-1081)	4
34	PIN DETENT 0.250x1.300 STL ZP	36811	1
35	SCREW FHSKT CAP 5/16-18x5/8	36846	2
36	NUT, 4-40 NYLON LOCK	36951	2
37	WASHER LOCK #6 SPLIT ZPS	36978	2
38	SCREW SHCS M5x0.8x20MM BLK	36986	2
39	SCREW SHCS 4-40x0.500	36994	2
40	PIN DOWEL 1/8x1-1/4 HARD GRND	37001	1
41	CAP 0.125x0.50x1.00 BLK VINYL	37028	1

PARTS IDENTIFICATION

KEY: 220V Only* Custom Part** Not Shown● SN= Serial Number

#	DESCRIPTION	Part #	Qty.
42	SCREW HX WH THR CUT .25-20x.50	50181	2
43	FUSE HOLDER	57118	1
44	SCREW 14x0.125 TAP ZP	59816	2
45	DECAL TEMP-TIMER	62944	1
46	BALL STUD	63428	2
47	WASHER AN .515x.625x.032 SS	64203	6
48	RELAY SS 50A 3-32VDC INPUT	65897	1
48	RELAY SS 25A 3-32VDC INPUT	62731*	1
49	WASHER LOCK #6 SPLIT ZPS	68330	4
50	TERMINAL BOARD 2KT	72223	1
51	CORDSET	74609	1
51	CORDSET 220v	20028*	1
52	NUT HEX 4-40 ZP	81224	5
53	NUT 1/2-20 NYLON INST	89078	1
54	BLOCK, ADJUSTMENT 400-600	0100001**	1
55	HANDLE	2507074**	1
56	PLATEN ASSY 120v 16X20	6000100**	1
56	PLATEN ASSY 220v 16X20	6000110**	1
57	ENCLOSURE ASSEMBLY	6001000**	1
58	ENCLOSURE BACK COVER	6001006**	1
59	MAIN ARM PIN	6102008**	1
60	PAD SILICONE 16x20x1/2 ORG MED	6103005**	1
61	LINK	6105001**	2
62	TOWER PIN	6105002**	1
63	HANDLE PIN	6105004**	1
64	PRESSURE ADJUSTMENT ROD	6105005**	1
65	LINK PIN	6105006**	1
66	HANDLE ASSEMBLY	6500100**	1
67	FRAME WELDMENT	6500250**	1
68	SOLENOID COVER ASSEMBLY	6500500**	1
69	LINK PIN	6501141**	1
70	LATCH BUSHING	6501143**	1
71	LATCH RELEASE HANDLE	6502112**	1
72	LOWER PLATEN	6505003**	1
73	QC LOWER PIN	6505012**	2
74	QC LOWER RECEIVER	6505013**	2
153	STRAIN GUAGE ASSEMBLY	47482	1
154	STRAIN GUAGE COVER	6505020	1
N/A	RESISTOR 5K, 5 WATT	84798 ●	1
N/A	HEATSHIELD	8404010** ●	2
N/A	HEATSHIELD INSULATING SPACER	8004013** ●	2

WARRANTY

(Effective May 1, 2008)

HIX will automatically register the equipment on the date it was shipped to you or your distributor. If the equipment was not purchased directly from HIX, but through a distributor (either domestic or foreign), please keep a copy of their sales invoice showing the serial number and date it was sold/shipped to you with this warranty. In this case, we will use the distributor's invoice date as the beginning warranty date. **STAPLE A COPY OF YOUR RECEIPT TO THIS WARRANTY** and keep in a safe place to provide verification of your warranty should a problem occur. Thank you.

Please fill in the following information and attach a copy of your receipt for your records.

Date Purchased: _____ From: _____

Model #: _____ Serial #: _____

This warranty applies to equipment manufactured by the HIX Corporation (HIX), Pittsburg, Kansas, U.S.A. HIX warrants to the original purchaser, its Ovens and Dryers, Heat Transfer Presses, Mug Presses, Mug Glazer, Retensionable Screen Frames, Textile Printers, Spot Heaters, and Exposure Units against defects in workmanship and material, except for wear and tear for a period of "One Year" from the date of purchase. HIX warrants its Accessories, Reten Splines/Hardware/Tool Kit, and Shuttle for a period of 90 days from the date of purchase. DoughXpress and Thermatrol products are covered under separate warranty.

In the event of a defect, HIX, at its option, will repair, replace or substitute the defective item at no cost during this period subject to the limitations of insurance and shipping costs stated below.

In the case of heat transfer presses (except the Mug Press, Hobby Lite), HIX warrants the heat casting for the "Life" of the machine for the original purchaser. If a part becomes obsolete at the time for repair, and/or cannot be reasonably substituted for, HIX will credit, at half the then current list price or last recorded price, only that part toward a new machine or any product HIX offers. This credit offer shall be the sole responsibility of the HIX Corporation in the event of an obsolete part.

This warranty does not cover belts, pads, mug wraps, mug press liners, canvas, rubber blankets, bulbs, glass, rod ends, turn buckles on printers, or mug press or damages due to accident, misuse/abuse, alterations or damage due to neglect, shipping or lack of proper lubrication or maintenance. HIX shall not be responsible for repairs or alterations made by any person without the prior written authorization by HIX. This warranty is the sole and exclusive warranty of HIX and no person, agent, distributor, or dealer of HIX is authorized to change, amend or modify the terms set forth herein, in whole or in part.

In the case of a problem with the equipment identified herein, HIX Corporation should be contacted during regular business hours to discuss the problem and verify an existing warranty. HIX personnel will assist the customer to correct any problems which can be corrected through operation or maintenance instructions, simple mechanical adjustments, or replacement of parts. In the event the problem cannot be corrected by phone, and upon the issuance of a return authorization by HIX, the equipment shall be returned to HIX or an authorized service representative. All insurance and shipment/freight costs are solely the responsibility of the customer, and not that of HIX, and HIX shall not be responsible for improper handling or damage in transit. Contact HIX customer service for complete return authorization information.

This expressed warranty is given in lieu of any and all other warranties, whether expressed or implied, including but not limited to those of merchantability and fitness for a particular purpose, and constitutes the only warranty made by HIX Corporation.

In no event shall HIX's liability for breach of warranty extend beyond the obligation to repair or replace the nonconforming goods. HIX shall not be liable for any other damages, either incidental or consequential, or the action as brought in contract, negligence or otherwise.

This warranty gives you specific legal rights and you may also have other rights which vary from state to state.



Manufacturers of the Finest Quality Textile and Graphics Screen Printing and Heat Transfer Equipment

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