NL-22

Combo Heat seal machine

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Preface

Dear User,

Welcome to the growing group of Thermopatch NL-22 press users. The product you have purchased has been carefully designed and manufactured to ensure that you, the user, will gain the maximum benefit.

All Thermopatch products are specifically designed to ensure ease of use with particular attention to safety requirements.

Should you discover any fault or damage upon receipt of this product, you should immediately contact your supplier.

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1. Introduction NL-22 press

The NL-22 press is a manually operated heat press for printing caps and similar small items. This simple robust machine is powered by a micro-processor for control of both heat and dwell accuracy and ease of operation and requires minimal operating space.

The work area of the NL-22 press is 100 x130 mm

The NL-22 press is produced in two versions, nominally 230 Volts AC and nominally 120 volts AC.

1.1 What did you receive

The NL-22 press has been shrink wrapped or shrink wrapped and placed in a cardboard box and held in place with foam. The following articles should have been delivered:

- NL-22 press complete with mains cable and plug and additional platens.
- NL-22 press Users' Handbook on CD
- Any extra items ordered

If there is any damage or any article is missing, please contact your supplier immediately.

1.2 Specifications of the NL-22 press

The NL-22 press is a manually operated heat press for transfer printing and material fusing. It is ideal for medium volume production.

Specifications	**230V**
Power consumption	500 Watts
Power supply	230 Volts AC
Working temperature	70-235°C
Machine height open	80 cms
Machine height closed	43 cms
Machine width	28 cms
Machine depth	52 cms
Net weight	14.5 kg
Press pad dimensions Pocket	13 x 10 cms
Press pad dimensions Caps	15 x 9 cms
Fuses	3.15A
A-weighted noise level	<70dB(A)

Specification	**120V**
Power consumption	500 Watts
Power supply	120 Volts AC
Working temperature	160-455°F
Machine height open	32 ins
Machine height closed	17 ins
Machine width	11 ins
Machine depth	21 ins
Net weight	32 lbs
Press pad dimensions Pocket	5 x 3.6 ins
Pres pad dimensions Caps	6 x 3,75 ins
Fuses	6.3A
A-weighted noise level	<70dB(A)

1.3 Safety

The NL-22 press has been equipped with various safety features to ensure operator safety.

a. **A thermal cut-out** on the heating element shuts off the power to the element if the temperature exceeds 235° ±± 15°C (455 ±± 27°F).

b. **The time/temperature** controller has a built in facility giving error messages in the event of faults with the element heating and control system.

1.4 Safety Tips

Our customer service has its own service engineers and, if required, maintenance and advice is available upon request

♦ **The NL-22 press** meets the European Legislation standard. Under normal conditions accidents are rare. However listed below are some practical points to ensure your safety.

- **Always switch off** and isolate the mains supply (i.e. remove plug) before undertaking any maintenance work.

  Keep other people away from the machine during use.

  Ensure that there is sufficient space around the machine. Cables and connections must not get jammed. Although the heat radiation of the press is low, there should be enough space for cooling down.

- **Avoid contact** with the press element.

♦ **DO NOT REMOVE THE BASE BOARD OR CONTROLLER UNLESS QUALIFIED TO DO SO** - touching internal parts is dangerous and may cause shock hazard. All electrical connections inside covers are live. Never operate Press with any covers and/or guards removed.

♦ **PROTECT THE MAINS CABLE** - damage to the mains cable may cause fire or shock hazard. When unplugging, hold by the plug only and remove carefully. Take care that the mains cable does not come into contact with the heat plate (or moving parts of the mechanism) during operation of the machine.

♦ **OPERATING AMBIENT TEMPERATURE RANGE** - the operating ambient temperature range is 32°F - 104°F, (0 - 35°C) and humidity of 20 - 80%. This heat press is fitted with a thermal cut out to ensure that it cannot operate above 235° ±± 15°C (455 ± ± 27°F).

- **MACHINE FUSES** - type: ultra rapid (FF) fuses 1¼" 230 Vac max. 3.15 amps. (120 Vac max. 6.3 amps).

- **WARNING - THIS APPARATUS MUST BE EARTHED (GROUNDED)**

- **CAUTION**

  This machine gets hot whilst operating. Take care not to touch any surfaces that are labelled "Caution this plate is HOT".

- **MACHINE OPERATION**

  Only suitably trained personnel should operate this machine.

  For Safety use both handles to move the handle up and down.

  Do not allow the handle to move upward, by the effect of the springs, without a hand on it

  Keep fingers away from **trapping points** in the arm - lever toggle mechanism. Using both hands on the handle keeps the hands safe.

  Contact your print media suppliers to ascertain whether **fumes** are given off during the transfer process, and if so what precautions are needed for operator safety. These may include **air extraction** and / or masks for personnel.

Please refer to Appendix I for an illustration of the NL-22 press machine.

2. Installation

2.1 Transport instructions

The machine comes to you in a box or shrink wrap. If you have to transport the machine at any time it is recommended that you use a similar box and packing methods. Please let the machine cool down and lower the handle to the locked position.

2.2 Installing the machine

2.2.1 **Remove all** packaging from the heat press.

2.2.1 **Check to ensure** that no damage has been caused to the machine during transit.

2.2.3 **Place the machine** on a sturdy horizontal surface that is within easy reach of the operator and allow space for the handle to move up to the loading position. Ensure that no items vulnerable to heat radiation are too close to the machine and that local lighting is adequate.

2.3 Electrical requirements

The NL-22 press should be connected to the mains supply, (nominally 230V AC for the European Market, or 120V AC for America) by the mains cable provided and a suitable plug. A qualified person should carry out this work.

The press is designed for 220-230 volts AC ± 50/60 hertz and requires exclusive use of a power outlet rated for at least 5 amps (Europe), or for 120 volts AC 8 amps (America).

Ensure that the supply rating on the machine specification plate corresponds with your local supply and that the correct plug is fitted.

MAINS LEAD

The wires in this mains lead are coloured in accordance with the following code:

230 VAC	**Green and Yellow**:	**EARTH**	**(GREEN)**	**120 VAC**
	Blue:	**NEUTRAL**	**(WHITE)**	
	Brown:	**LIVE**	**(BLACK)**	

As the colours of the wires in the mains lead of this apparatus may not correspond with the coloured markings identifying the terminals in your plug, proceed as follows: -

1. **The wire coloured green and yellow** must be connected to the terminal in the plug which is marked by the letter E, or by the safety earth symbol coloured green, or green and yellow.

2. **The wire coloured blue** must be connected to the terminal which is marked with the letter N, (Neutral connector)

3. **The wire coloured brown** must be connected to the terminal which is marked with the letter L, (Live connector)

4. **NOTE:**

   Replacement of the mains cable must be done by a competent service engineer.

HEATING ELEMENT
The heating element fitted to this press is rated at 500 Watts.
Never connect to any outlet or power supply having a different voltage/frequency from that on the machine data plate.

2.3B Wiring the plug for a 120 VAC machine.

1.The wire which has green insulation must be connected to the terminal in the plug coloured green or marked GR.
2.The wire which has white insulation must be connected to the terminal in the plug identified as neutral.
3.The wire which has black insulation must be connected to the terminal in the plug which is identified as live (line).
4. Note: Replacement of the power cord must be carried out by a qualified electrician in accordance with national and local electrical codes, and the instructions provided with the plug.

2.4 Adjusting the pressure

This press is fitted with a pressure adjusting unit, which enables the heat plate assembly to be raised or lowered by use of a pressure adjustment knob located on the top of the machine:

a) **To increase pressure** or to use thinner materials turn knob clockwise.

b) **To decrease pressure** or to raise the heat plate assembly to enable thicker materials to be used, turn the adjustment knob anticlockwise.

NOTE
DO NOT adjust the pressure when the machine is clamped shut

CAUTION
Never increase the pressure to the extent of requiring undue force to lower the toggle/heat plate assembly into the lock position, as this will place excessive stress on the press frame, resulting in permanent damage to the press.

2.5 Adjusting the time and temperature
Please refer to Appendix II showing the operation of the control unit.

3. How to Operate the NL-22 press

3.1 Starting with the NL-22 press

3.1.1 **Plug into your supply** outlet and switch supply on.

N.B. Please ensure the mains plug is easily accessible to the operator so that in the event of a fault the machine can be unplugged.

3.1.2 **Turn on the NL-22 press;** the on/off switch is to the right of the controller. Set the machine controls as necessary. See instructions for adjusting the pressure, **2.4**, and the operation of the time temperature unit, **5.2**. When the set temperature is steady in the display the machine is ready to use

3.2 Working with Heat Transfer Materials

This section is divided into Transfer Marking/Transfer Printing and Heat Bonding and Fusing.

First ascertain from the supplier of the material that it is suitable to be used, and obtain the correct heat and time dwell setting for the material and transfer. Approximate settings may be as follows:-

3.2.1 **Transfer Marking**

200° C (392°F) - Heat setting 3 to 5 seconds - Time dwell setting

NOTE: **Transfer marking** is usually for the marking of materials for identification purposes and should not be confused with the transfer printing, as mentioned in the next section.

3.2.2 **Transfer Printing**

190° - 200°C (374-392°F) - Heat setting 20 to 30 seconds - Time dwell setting

NOTE: **Always ascertain** from the supplier of material and transfer paper, that the material to be used is suitable for, and has been prepared for transfer printing.

3.2.3 Heat Bonding - Fusing

140° - 200°C (284-392°F) - Heat setting 5 to 15 seconds - Time dwell setting

3.2.4 **Ensure that the heat setting** and dwell time setting are correct for the material being used.

3.2.5 **Adjust the pressure** setting of the machine by rotating the adjusting knob situated at the rear of the machine. (See exploded diagram in this manual. Clockwise for more pressure, anticlockwise for less pressure.

3.2.6 **Adjust the position** of the silicone pad table to align with the cap with the heat plate by loosening the locking knob situated underneath the silicone pad table, positioning it as required (front to back) and retightening the locking knob.

3.2.7 **Hook the cap** under the cap tensioning arm and pull the cap onto the silicone pad table.

3.2.8 **Place the transfer** in the desired position on the work.

3.2.9 **Gently pull the handle** forward into the lock position, using both hands for safety and ensuring the work is firmly clamped between the heat plate and pressure pad.

3.2.10 **When the pre-set dwell time** has been reached, a buzzer will sound. The heat plate should then be lifted by pushing the handle back to its full extent. The handle should be held until the up position is reached to remove the possibility of injury to the operator's face from an uncontrolled upward movement of the handle.

3.3 Material Fusing

3.3.1 **When the press is to be used** for the fusing of fusible interlining/heat bonding etc., ascertain from the supplier of the material to be used, the correct settings for time and temperature for the process.

Approximate settings are usually within the following:-

120° - 170°C (250° - 340°F)	Heat Setting
5 - 30 seconds	Time Dwell Setting

The method of operation for fusing is the same as for transfer printing.

During the fusing operation it will be found to be advantageous to lay a piece of PTFE cover material (the same size as the table), over the article being fused. This will act as an anti-stick barrier to prevent strike through of any surplus adhesive from the fusible materials adhering to the heat plate of the press.

Note:

It is not advisable that this PTFE cover material be used when the press is being used for transfer printing.

3.4 Pressing Pad Assembly

The pressing pad normally supplied with this machine is silicone rubber. The pressing pad must be maintained in good condition at all times and replaced when showing signs of wear. A worn pressing pad will always affect the quality of printing/fusing. Do not insert items into the machine which would tend to cut the pressing pad, i.e. buttons, pins, press studs or zips.

Never allow the hot heat plate to rest on the pressing pad when the press is not being used as the pad may be damaged.

IMPORTANT NOTE:

The pressing pad supplied with the machine is of the correct thickness. Using a thicker pad may invalidate your warranty.

3.5 Shutting Down

To shut down the machine, turn off the green illuminated rocker switch to the right of the controller. The handle should be in the up position.

After shutting off the machine, it should not be switched on again for 30 seconds.

3.6 Fault Diagnosis

This machine has a built in fault diagnosis. The display may show the following:

1. Heat Fault

If the element of the heat press, or the thermal cut-out go open circuit, after approximately 20 minutes the display will show "Heat Fault". If this display is seen, contact your machine supplier immediately.

2. Probe Fault

If the probe goes open circuit, the display will show "Probe Fault" immediately. Contact your machine supplier immediately.

3. **"CAL" Fault**

If "CAL" appears in the controller display the controller will need to be recalibrated. Switch off the machine and contact your supplier for an instruction sheet.

CAUTION

In all fault conditions, switch off the power to the machine and unplug the machine from the electrical supply before contacting your machine supplier.

3.7 Hints and Tips

Transfer Printing

Extra care should always be taken to ensure that transfer paper is placed print down onto the article as mistakes will result in the heat plate becoming soiled with ink and spoiling following work.

When transfer printing, it may be found advantageous to cover the press pad with paper to prevent strike-through of surplus ink, particularly when printing thin material as surplus print on the pressing pad cover can also strike back on the following work.

Transfer Paper/Motifs Fail to Print Out Correctly

Check:-

1. **Heat and time** dwell settings are correct.

2. **Article** having transfer applied is locked in contact between pressing pad and heat plate.

3. **Pressing pad** is in good condition, and making complete contact over the whole area of the heat plate. See Pressing Pad details.

"Ghosting" (Double Image) of Transfer Prints

Check:-

1. **Material being used** has been correctly heat set for transfer printing.

2. **Material being used** does not shrink during printing process, i.e. measure material before and after printing.

3. **Transfer paper** does not move after printing process upon lift off of the heat plate.

4. **If possible**, use adhesive coated paper, particularly to overcome fabric shrinkage.

5. **By pre-shrinking** of material in press before transfer printing.

4. Maintenance of the Machine

4.1 Daily Maintenance

For good press results it is important to keep the press surfaces clean. Wipe the surface of the heat plate with a dry non abrasive cloth before use when the plate is cold.

4.2 Periodic Maintenance

Put a few drops of oil onto the various pivot pins and the pressure adjusting screw every three months.

4.3 Cleaning

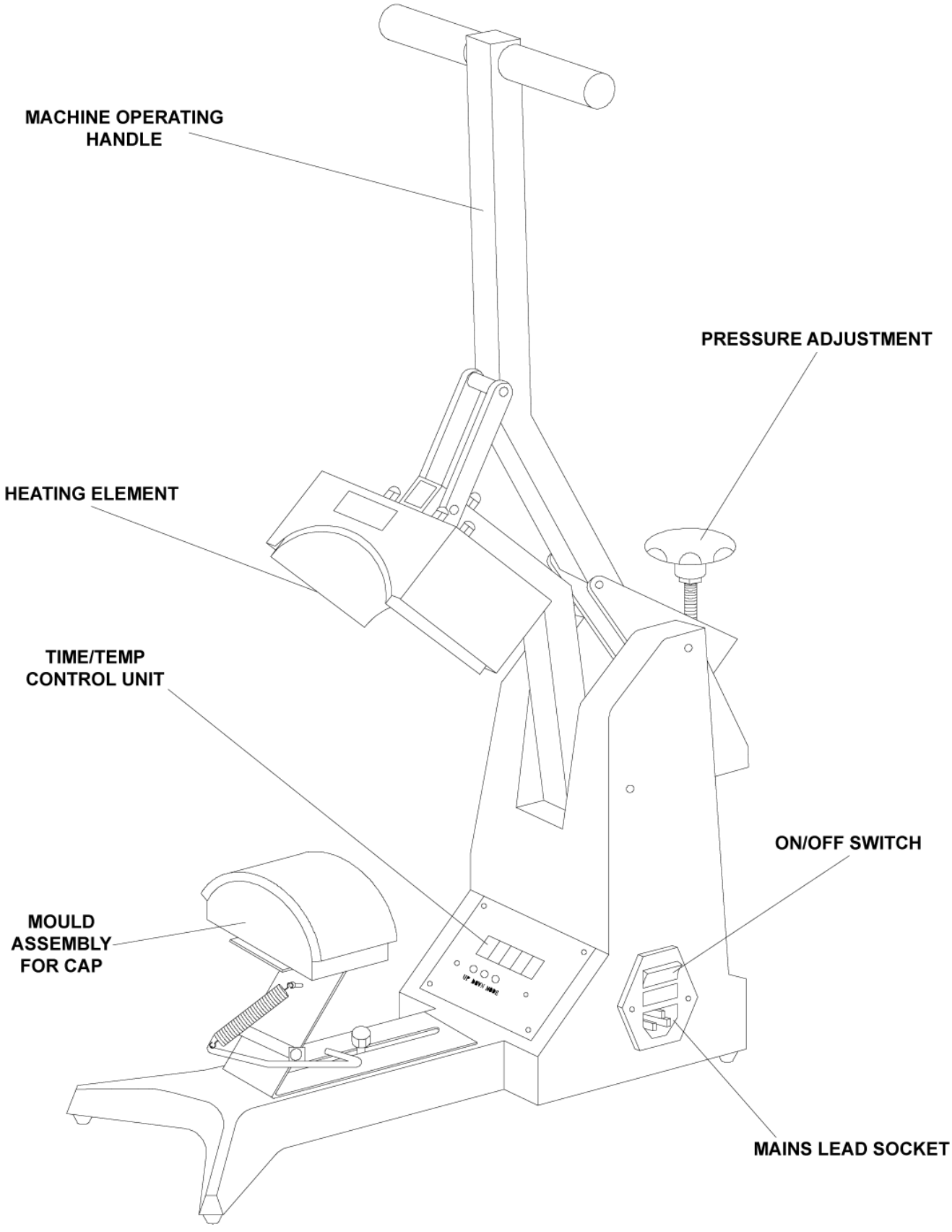
First unplug the machine. Clean the outside of the machine frequently with a clean, moist cloth. This may conveniently be carried out when the machine is cold.

5. Machine Drawings, Diagrams and Declarations

On the following pages are the schematic diagrams for the NL-22 press machine.

5.1	**General Layout**	**Appendix I**
5.2	**Control Unit - Operation**	**Appendix II**
5.3	**Exploded Diagram and Parts List**	**Appendix III / IV**
5.4	**Electrical Diagram**	**Appendix V**
5.5	**Controller - Electrical Diagram**	**Appendix VI**
5.6	**Declaration of Conformity**	**Appendix VII**

5.1 General Layout of the NL-22 Cap Pocket Combo Press.

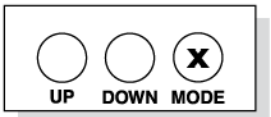


Appendix I

5.2 Operation Of Control Unit, Setting Time and Temperature.

(The head must always be in the up position before the controller is set)

1



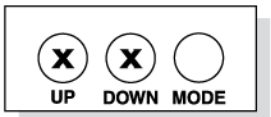
To set the Time:
Press the MODE button once.

2

TEMP.	TIME	
	0	20
	M.	SEC.

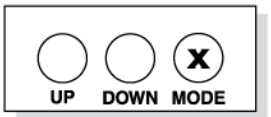
The display will now show.

3



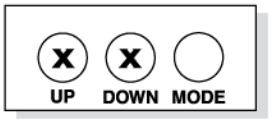
Use the "UP" & "DOWN" buttons
to set the desired time
within the range 0 to 9mins. 59 secs.

4



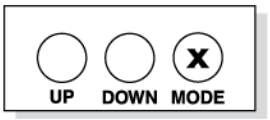
Now press the"MODE" button,this will save the set time and put the controller into the set temperature mode.

5



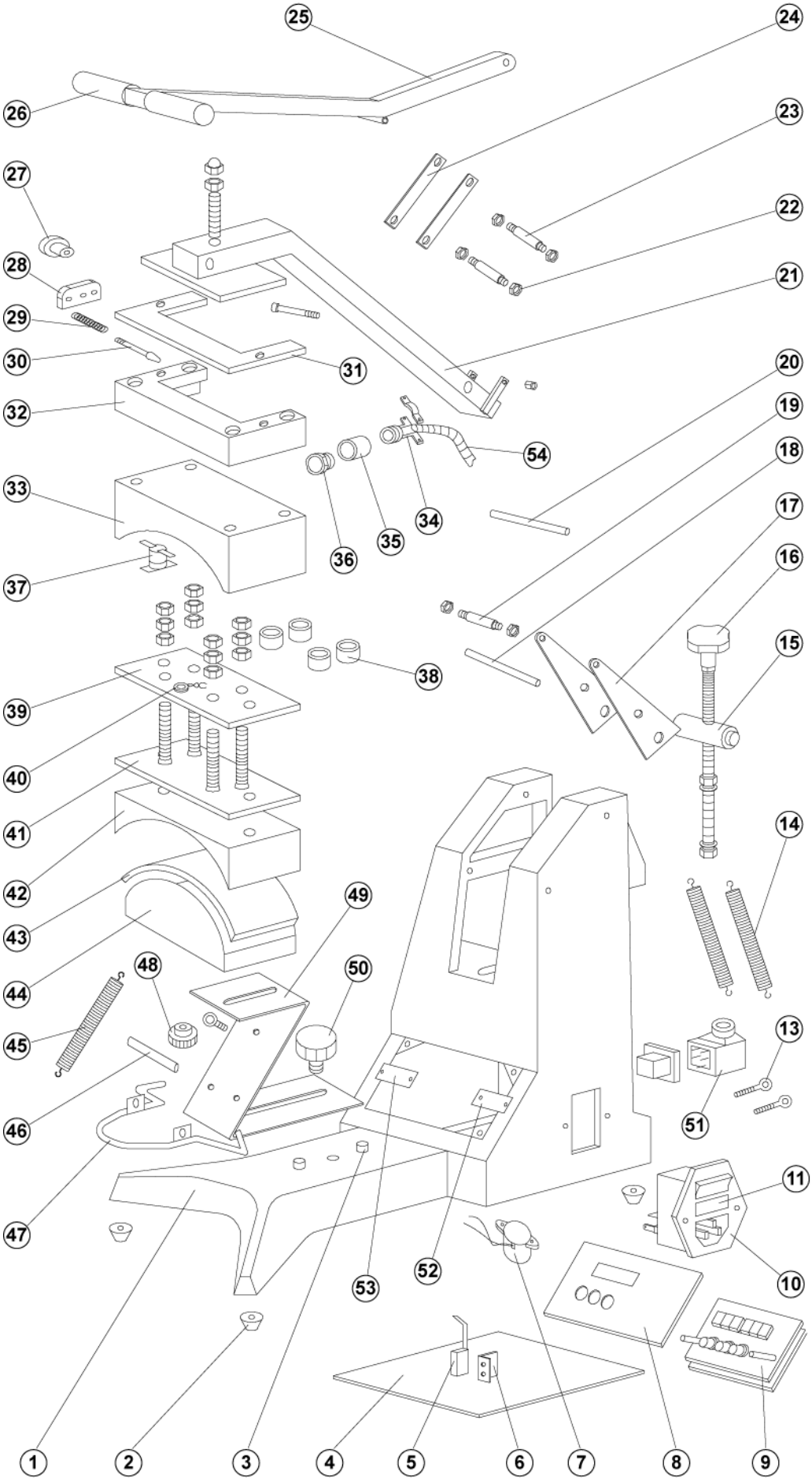
Use the"UP" & "DOWN" buttons
to set the desired temperature
within the range 70-235oC
(158°F-455°F)

6



Press the "MODE" button once, this will save the temperature and return the controller into its normal operating condition.

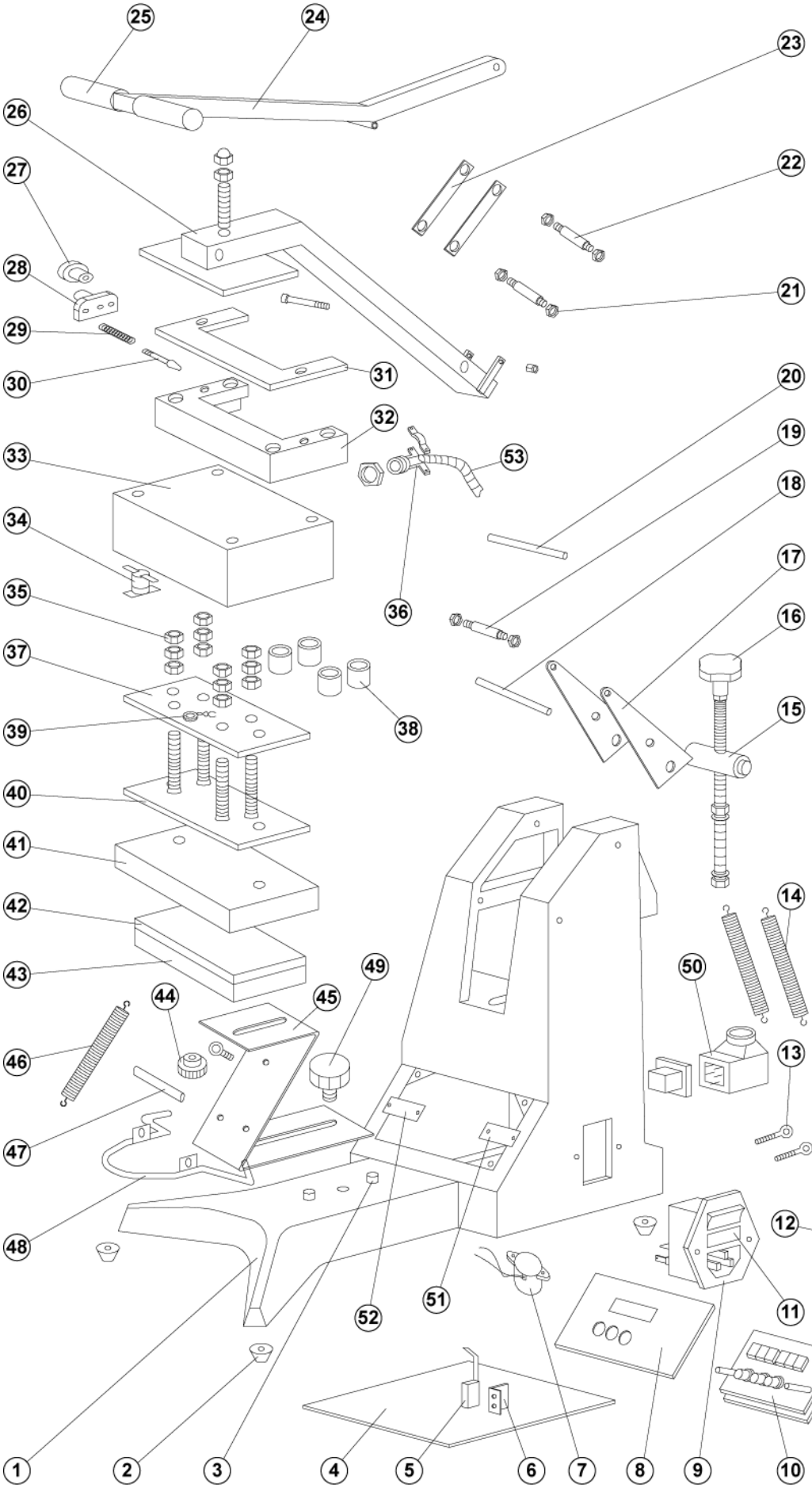
5.3 Exploded Diagram and Parts List (with Cap Attachment).



ITEM	DESCRIPTION	QU.	PIN No.
1	BASE	1	NCC 34
2	RUBBER FEET	4	SWC 33
3	DOWELS	4	NCC 74
4	BASE BOARD	1	NCC 37
5	MICRO SWITCH	1	BMC 462
6	MICRO SWITCH BRACKET	1	NCC 31
7	BUZZER	1	BUZ 1
8	FACIA	1	NCC 85/A
9	CONTROLLER	1	BMC 332
10	FILTER FUSE UNIT	1	BMPC 16
11	3.15A FUSE	1	SWC 51
	6.3A FUSE	1	CPC 29
12	MAINS LEAD & PLUG 230V	1	BMC 425/L/SP
	MAINS LEAD & PLUG 120V	1	NCC 617/A
13	SPRING HOOK	3	BMC 477
14	ARM SPRING	1	NCC 36
15	PIVOT BUSH	1	NCC 26
16	HANDLE WHEEL	1	MPC 6518
17	TOGGLE SIDE PLATES	2	NCC 24
18	ARM PIVOT PIN	1	NCC 15
19	LEVER TOGGLE PIN	1	NCC 28
20	TOGGLE PIVOT PIN	1	NCC 14
21	ARM	1	CPC 01
22	NYLON NUTS	6	
23	ARM TOGGLE PIN	2	NCC 27
24	LEVER SIDE PLATES	2	NCC 25
25	LEVER HANDLE	1	NCC 23
26	HANDLE	2	BMC 19/H
27	PLUNGER KNOB CAP & POCKET)	1	CPC 08
28	PLUNGER RETAINING PLATE	1	CPC 10
29	CAP PLUNGER SPRING	1	CPC 09
30	CAP PLUNGER	1	CPC 07
31	CAP SLIDE PLATE COVER	1	CPC 06
32	CAP SLIDE PLATE	1	CPC 05
33	CAP INSULATION COVER	1	CPC 03
34	SHORT THREAD GLAND	1	BC 40
35	COUPLING	1	CPC 12
36	COUPLING NUT	1	CPC 13
37	THERMAL CUT-OUT	1	BM 338
38	SPACER	4	NCC 21
39	CLAMP PLATE	1	CPC 04
40	TYPE 'K' THERMO COUPLE	1	FPC 3057
41	ELEMENT 230V x 500W	1	SWC 14
	ELEMENT 120V x 500W	1	SWC 14/A
42	FEMALE MOULD	1	NCC 52
43	SILICON PAD	1	NC 79
44	MALE MOULD	1	CPC 02
45	TENSION ARM SPRING	1	NCC 35
46	TENSION ARM AXLE	1	NCC 12
47	TENSION ARM	1	NCC 11
48	KNURLED KNOB	1	BMC 224
49	MALE MOULD SUPPORT	1	CPC 11
50	KNURLED KNOB M6 x 33	1	NCC 73
51	PLUG/SOCKET	1	CPC 24
52	LH. CONTROLLER BRACKET	1	NCC 43
53	RH. CONTROLLER BRACKET	1	NCC 42
54	CABLE SLEEVING	1	CPC 28

Appendix III

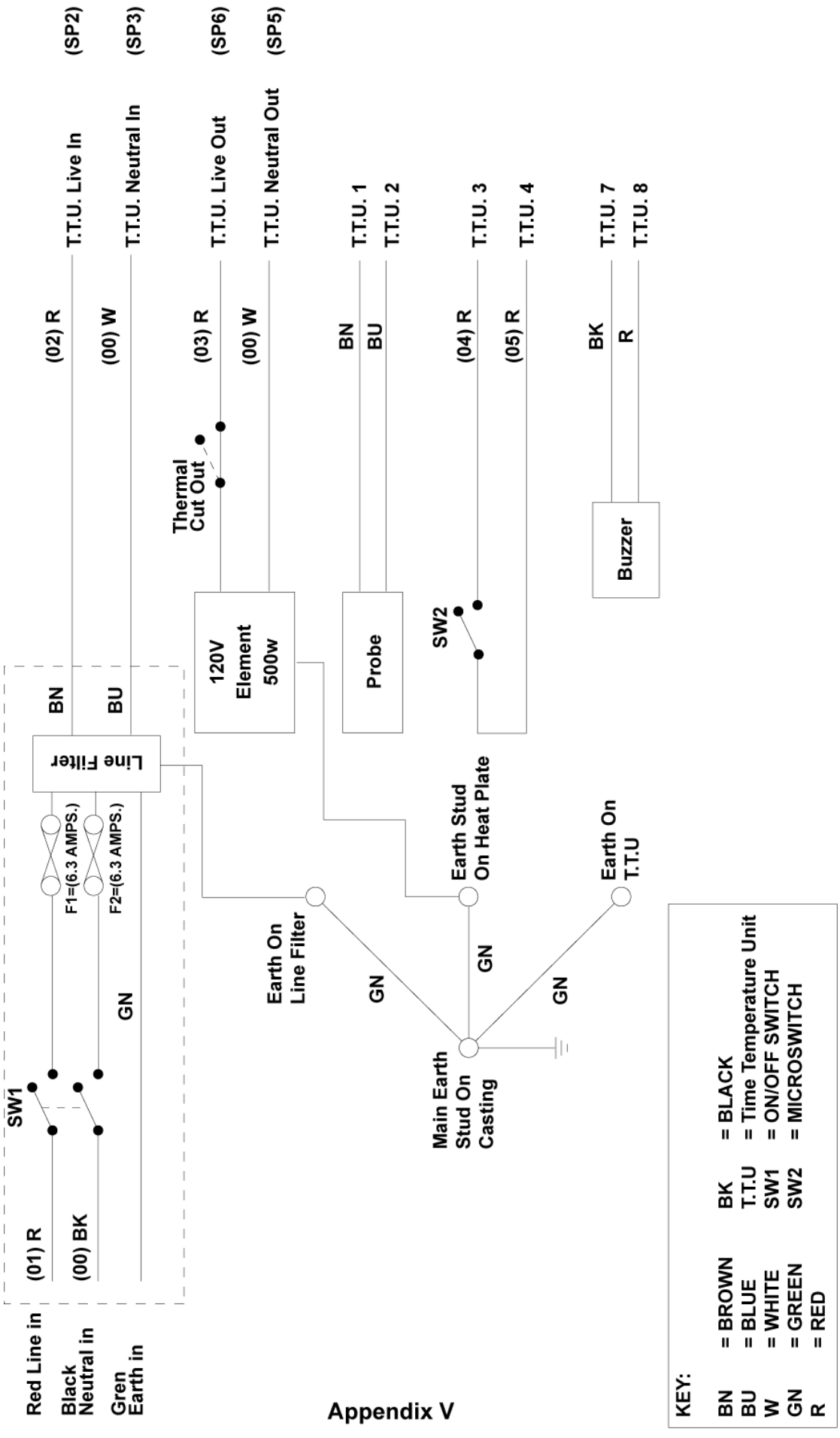
5.3 Exploded Diagram and Parts List (with Pocket Attachment).



ITEM	DESCRIPTION	QU.	PIN No.
1	BASE	1	NCC 34
2	RUBBER FEET	4	SWC 33
3	DOWELS	4	NCC 74
4	BASE BOARD	1	NCC 37
5	MICRO SWITCH	1	BMC 462
6	MICRO SWITCH BRACKET	1	NCC 31
7	BUZZER	1	BUZ 1
8	FACIA	1	NCC 85/A
9	FILTER FUSE UNIT	1	BMPC 16
10	CONTROLLER	1	BMC 332
11	3.15A FUSE	1	SWC 51
	6.3A FUSE	1	CPC 29
12	MAINS LEAD & PLUG 230V	1	BMC 425/L/SP
	MAINS LEAD & PLUG 120V	1	NCC 617/A
13	SPRING HOOK	3	BMC 477
14	ARM SPRING	2	NCC 36
15	PIVOT BUSH	1	NCC 26
16	HANDLE WHEEL	1	MPC 6518
17	TOGGLE SIDE PLATES	2	NCC 24
18	ARM PIVOT PIN	1	NCC 15
19	LEVER TOGGLE PIN	1	NCC 28/A
20	TOGGLE PIVOT PIN	1	NCC 14
21	NYLON NUTS	6	
22	ARM TOGGLE PIN	2	NCC 27/A
23	LEVER SIDE PLATES	2	NCC 25
24	LEVER HANDLE	1	NCC 23
25	HANDLE	2	BMC 19/H
26	ARM	1	CPC 01
27	PLUNGER KNOB (CAP & POCKET)	1	CPC 08
28	PLUNGER RETAINING PLATE	1	CPC 10
29	PLUNGER SPRING PACKET	1	CPC 22
30	PLUNGER PACKET	1	CPC 21
31	POCKET SLIDE PLATE COVER	1	CPC 20
32	POCKET SLIDE PLATE	1	CPC 19
33	PACKET INSULATION COVER	1	CPC 14
34	THERMAL CUT-OUT	1	BM 338
35	HEXAGON NUT	12	
36	SHORT THREAD GLAND	1	BC 40
37	POCKET CLAMP PLATE	1	CPC 15
38	SPACER PACKET	4	CPC 23
39	TYPE 'K' THERMO COUPLE	1	FPC 3057
40	ELEMENT 230V x 400W	1	CPC 25
	ELEMENT 120V x 400W	1	CPC 25/A
41	POCKET HEAT PLATE	1	CPC 16
42	100 x 130 SILICON PAD	1	CPC 27
	63 x 82 SILICON PAD	1	CPC 26
43	100 x 130 TABLE	1	CPC 17
	63 x 82 TABLE	1	CPC 18
44	KNURLED KNOB	1	BMC 224
45	PAD PLATE SUPPORT	1	CPC 11
46	TENSION ARM SPRING	1	NCC 35
47	TENSION ARM AXLE	1	NCC 12
48	TENSION ARM	1	NCC 11
49	KNURLED KNOB M6 x 33	1	NCC 73
50	PLUG/SOCKET	1	CPC 24
51	RH. CONTROLLER BRACKET	1	NCC 43
52	LH. CONTROLLER BRACKET	1	NCC 42
53	CABLE SLEEVING	1	CPC 28

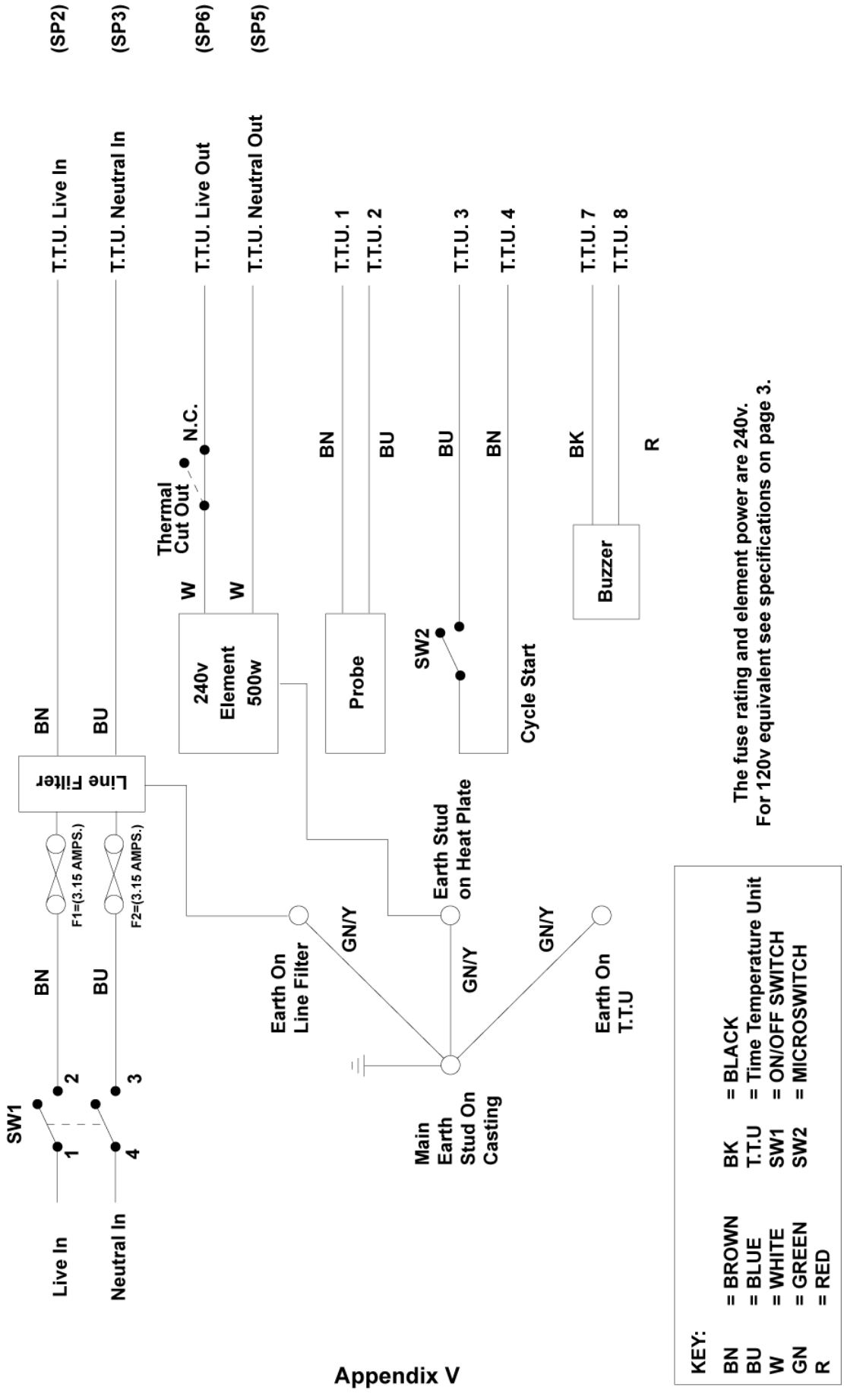
Appendix IV

5.4 Electrical Diagram (120 VAC)



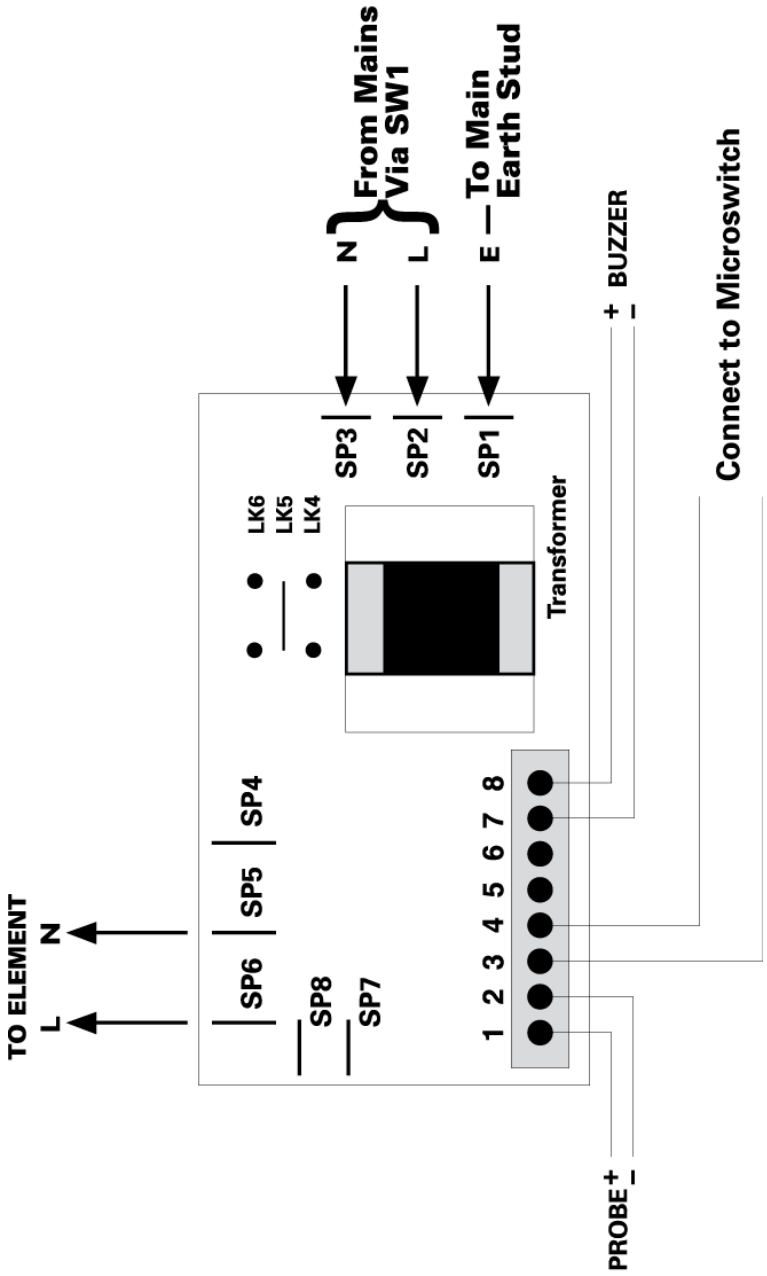
Appendix V

5.4 Electrical Diagram (240 VAC)



Appendix V

5.5 Controller Electrical Diagram.



Appendix VI

DECLARATION OF CONFORMITY

Application of Council Directives:	Machinery, Low Voltage. E.M.C
Standards to which Conformity is Declared:	**BS EN 292-1:1991** - Safety of machinery: Basic Technology. **BS EN 292-2:1991** - Safety of machinery: Principles of Design. **BS EN 60204-1:1991** - Safety of machinery: Electrical Equipment of Machines. **BS EN 60529:1992** - Degrees of protection provided by enclosures. **BS EN 418:1992** - Safety of machinery: Emergency Stops. **BS EN 1050:1997** - Safety of machinery: Principles for Risk Assessment. **E 55011:1998** - Class A Group 2 equipment - EMC Emissions. **EN 50081-1:1992** - EMC Conducted Emissions. **EN 50082-2:1995** - EMC Immunity. **BS 5304:1998** - Safety of machinery.
Manufacturer's Name: Manufacturer's Address:	**Thermopatch bv** Draaibrugweg 14 1332 AD Almere The Netherlands
Type of Equipment:	**Small Format Heat Presses**
Model Number:	NL-22
Serial Number:	See invoice
Year of Manufacture:	See serial number plate on machine

I, the undersigned, hereby declare that the equipment specified above conforms to the above Directives and Standards.

Place: Almere, The Netherlands

Signature: 

Date: Invoice date

Name: Jan Bausch
Position: General Manager

Appendix VII

6. Design Change

With the policy of constant improvement and/or modification to meet changing conditions, the right is reserved to change the design and/or specifications at any time without prior notification, and therefore specifications may vary and not be in accordance with this manual.

7. Guarantee

This press is guaranteed to be free from defects in material and workmanship (excluding pressing pad assembly) for a period of 12 months from the date of supply.

Should in our opinion any part of this press be defective in materials or workmanship, it will be replaced or repaired free of charge, provided that the press has been installed and operated in the correct manner and not subjected to misuse. (This is excluding any travelling and/or carriage costs which will be charged at our discretion.)

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. It is the responsibility of the press user to ensure the suitability of the materials operating through the press.

In order for this guarantee to be effective, no return of machine or parts may be made without prior factory authorisation.

The manufacturer shall not be liable for any injury, loss or damage, direct or consequential, arising out of the use or the inability to use the product.