

**3D sublimation**  
HEAT PRESS

# M40 user manual

Please read this information and notice, there is a piece of operating video demo CD to understand the machine feature and operating steps.  
The information in this manual is subject to change without notice and should not be construed as a commitment. Final interpretation rests with the company all



# READ THIS MANUAL

(IMPORTANT INFORMATION)

*Thank you for your using our machine.*

Please read and understand this manual and your employer' safety practices. *This manual includes operating instrction and precautions, normal error and solutions. Injury may occur if using the error method.*

*For your safety, please read this manual while you first use the machine no matter how familiar you are with the similar one.*

*The information in this manual is subject to change without notice and should not be construed as a commitment by us, We assumes no responsibility for any errors that may appear. The picture and description is just for your reference and subject to the material object.*

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# SECTION 1: SAFETY

Operation and maintenance of automated equipment involves potential hazards. Personnel should take precautions to avoid injury.

## 1. AVOID ELECTRIC SHOCK

Should not be opened the machine while power is on.

Should not be operated the machine while open it. Otherwise electric shock can kill if hands and limbs come in contact with high voltage terminal and charging part.

Should not be opened the driver and regulator even though power is off but check up the machine.

Wiring or checking please be sure residual voltage was disappeared after disconnect the electric 10 minutes with a multimeter was detected.

Should be sure make a ground connection to the machine and only be checked or repaired by trained service personnel.

Should not be operated the machine switch with wet hand in case electric shock.

Should be checked electric cable and be sure it is complete.

Should not be made it carrying heavy or excessive pressure, otherwise it will cause an electric shock.

## 2. AVOID FIRE

Should be kept away from flammable and explosive goods when the machine works, because of the internal temperature higher than 150 °C while power is on, otherwise it maybe cause fire.

Should be disconnected the electric while the machine has a breakdown. Otherwise sustained blarge current maybe cause fire.

Should be sure to keep people on duty while power is on, otherwise it maybe cause fire.

Should be made sure the temperature below 100 °C before disconnect the electric to stop working in case the high temperature maybe cause fire.

Should be opened the machine and disconnect the electric while has a breakdown or power off in case it maybe cause fire.

## 3. AVOID HARM

Should be operated with protection gloves in case hands maybe burn by the feed table frame or workpiece.

Should be made sure the machine is safety installed in accordance with enclosed procedures and specifications in case the machine maybe exploded or hurt.

Should be kept the wire dry and made sure the cable and the terminals firmly connected correctly

Should not touch the machine with bare hands while power is on or just stop working in case high temperature burns you.

Should be made sure the workpiece height below the maximum height machine could stand, otherwise it maybe cause material and machinery damage.

Should not put your hand into the loading in case hand maybe hurt.

## 4. OTHER NOTES

Please pay attention to the following items in order to prevent the accident injury, electric shock or damage.

(1) . Carry and install setallation.

Should use lifting tool correctly while carrying machine in case of damage.

Should not be stack, inclined or inverted the packing in case of rain or wet and not make the machine drop or have a strong impact.

Should be disconnected the power if the machine is damaged or missing component

Should not carrying heavy or covering the Cooling fan outlet

Please use the following environment

Environment temperature: 15-60°C

ambient humidity: below 90%RH (no condensation)

Indoor environment : non-corrosive gases, non-flammable gas or non-oil mist.

(2) 、 Wiring installation

Should install noise filter or power stabilizer in the voltage unstable situations and use the matching cable

(3) 、 Test run

Check all parametings and confirm the sudden start will not cause mechanical damage.

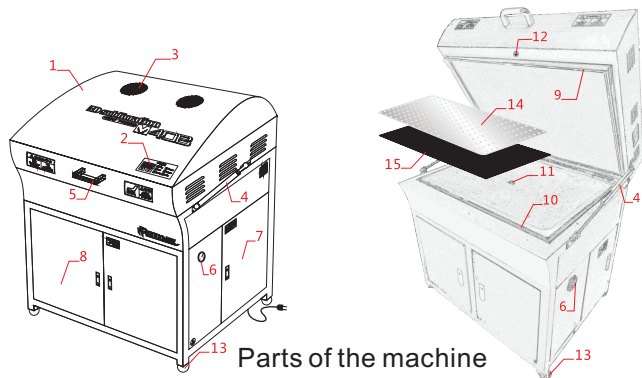
Should not transform the machine. After a long time out, Should be checked and trial operation after a long time stop work.

(4)、Do with the waste

Please do with the waste as industrial waste gas.

## SECTION 2:OVERVIEW

At the forefront of our design is a commitment to ease-of-use. M40 type 3D vacuum sublimation transfer machine adopts Sealed far-infrared radiation heating system with excellent insulation properties、vacuum transfer system、digital integrated intelligent temperature control system is stable and efficient: not only has fast heating perfect insulation, uniform temperature inside , energy saving, but also has two system: up heating and down heating, photo transfer easily with the side surface of the plane and stereoscopic special-shaped workpieces.



Parts of the machine

- |  |                    |                                   |
|--|--------------------|-----------------------------------|
| 1 . top cover (sealed heating chamber) | 2. control board   | 3. Cooling fan                    |
| 4. Power support levers                | 5. lid handle      | 6. Negative pressure gauge        |
| 7. main junction box                   | 8. main engine     | 9. loading table frame            |
| 10. feed table.                        | 11. Suction hole   | 12. The upper frame fixing device |
| 13. truckle                            | 14. Aluminum plate | 15. Mesh pad                      |

## SECTION 3:FEATURE

1. Application:M40 type 3D sublimation transfer machine can be shaped in the flat surface, curved surfaced. Can be full-color transfer without platemaking at one time. It is widely used in art gifts, DIY, digital image, wedding photo studio, advertising, logo signs and other industries.

2. The range of materials: pearl, drawing and other pre-coated metal plates and a variety of pre-coated metal sheet profiles, pretreatment of stone, ceramic glass, wood and so on.

3. Feature:

Small volume, light weight: To optimize the design of the internal space so that the machine has a bigger content and increase the number you could transfer at one time, which could improve work efficiency.

Digital integrated intelligent temperature control: Split type digital integrated circuit design so that operation and maintenance more convenient, up and down heating could control alone, you could choose the heating type based on different transfer products for energy conservation. For energy-efficient design, the working temperature is more suitable for large format full color transfer.

Powerful function complete assort: : Applications to surface graphic processing with flat surface, curve surfaces smooth or multiple surface, can complete solve the problem of DIY transferring with ceramic, mugs, wine bottle, stone photo, crystal glass, t-shirt, phone case and so on.

## SECTION 4:TECHNICAL PARAMETERS

MODEL: M40 EXTERNAL DIMENSIONS: 760\*860\*1000mm

WORKING AREA: 450\*650\*120mm GW: 98KG NW: 85KG

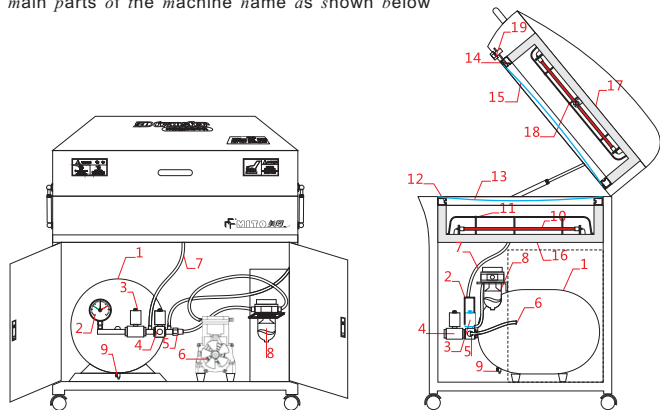
POWER: 21KW VOLTAGE: 110V/240V MAX TEMPERATURE: 250+-5℃

UP HEATING: 3KW DOWN HEATING: 2.6KW VACUUM PUMP: 150W

MAX VACUUM: -0.09kpa VACUUM FLOW: 1.5L/S

## SECTION 5: CONFIGURATION NOTES

1. The machine configuration is different for different countries and regions, please check according to your packing list.
2. Vacuum pump has oil pump and oil-less pump, if use oil pump please check the oil window regularly and fill the vacuum pump oil when the oil level is below the window center
3. The control panel is setting the temperature conversion of °C and °F (if the allocation), please setting according to different countries and regions.
4. According to different countries working voltage 110V and 240V according to the machine, please choose to use voltage power configuration.
5. The main parts of the machine name as shown below

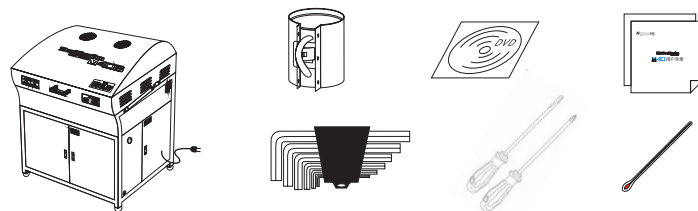


1. vacuum tank
2. electric contact pressure gauge
3. bleeder valve
4. release valve
5. check valve
6. vacuum pump
7. Silica gel tube
8. Filter tank
9. drain valve
10. pipe heater
11. Chrome frame
12. down worktable frame
- 13/15. Silicon rubber
14. up worktable frame
16. down reflecting shade
17. up reflecting shade
18. protective screening
19. upper frame fixing device

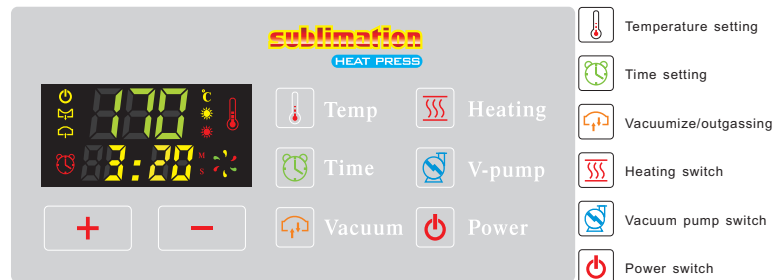
## SECTION 6: OPERATAcation

### 1. DISMOUNTING

Remove all packaging you will see the following items. Please use the power source can meet the power rating, Maintain ventilation and far away from flammable and explosive articles.



### 2. OPERAION PANEL





## Power

### Power switch

The machine after electrify the display icon lit, the top cover work cooling fan cooling machine in the state, the standby power



## V-pump

### Vacuum pump switch

Begin to work according to a vacuum pump, the display icon flashing or rotating, reach the set pressure vacuum pump automatically stops, the key has to give up parts of the machine pumping function



## Heating

### Heating switch

Heating according to the first machine, the display icon lit, press the second machine heating, the display icon lit, press the key to stop heating



## Vacuum

### Pumping gas/gassing

According to the first, the feed table pumping and start the countdown, icon lit, by second, the feed table deflated the countdown to the end, the icon lights



## Temp

### Temperature set

Click on the icon, digital temperature and began to flicker, this time with +/- button adjustment can set temperature, press second or wait for 5 seconds, digital stop flashing, storage settings and effect



## Time

### Time set

Click the display time, digital seconds and icon flashes, this time with keys to adjust can set the seconds value, under the second set time fractile (ibid), by third, or wait five seconds stop flashing storage settings and effect



+/- is the temperature and time regulating key, press +/- and hold 5 second delay can set the temperature correction coefficient. adjust the difference between display temperature and the actual temperature.

## 3. Pre-heating

- (1). Confirm the machine has a suitable power source when the indicator light, the top cover powder blower rotation.
- (2). Press the power switch, the machine control board with electric start automatic preheating process, machine in the up heating state lights, vacuum pump work automatically lights flashing or rotating, feeding platform at the pumping light on, the preset temperature is 120 °C preset preheating time is 30 minutes. the countdown begins, display temperature is the room temperature and rising change.
- (3). When reaching the set temperature (usually 10-20 minutes), the heating is stopped. Preheating process is over, the countdown may still be worked.
- (4). Temperature will be set numerical 5 floating up and down, heating will automatically work or stop; vacuum pump will stop work when the negative pressure

## 4. Transfer operation

(specific workpiece can watch video operation)

- (1). Before starting operation should wear gloves in case of high temperature, press the release switch, lights, countdown to zero.
- (2). Press the set time, according to different workpiece material and thickness of the transfer time required, based pearlescent board for example setting time is 1:20, repeat the point to memory set.
- (3). Open the top cover and put the metal plate fixed the picture in the aluminum plate the paper upward, close the cover, press the vacuum switch, lights, countdown begins.
- (4). When countdown is over, the machines will make tick - tick sound the alarm, press the release switch, open the engine cover remove the metal plate, tear up the surface of the thermal transfer paper check printing quality, cooling and packing.
- (5). If need to continue to work please repeat steps 2-4 action, if the same material is transferred without having to set, but this setting will not in the memory when the machine is off, the next operation should be set the time according to actual.
- (6). The workpiece transfer plane and concave-convex type requires the use of up loading and down loading platform frame and two layers of silicon rubber vacuum transfer, temperature is 170 °C, the transfer mug and wine bottles and three-dimensional objects can be matched with related models, upper and lower feed table frame removed out (see P10), press the switch to a heating lamp lights, temperature is 190 °C control program automatically shielded vacuum pump, pumping only countdown without vacuum.

## 5. Shut down

(1). Press the heating lamp switch  to turn off to make the machine stops heating.

(2). Press the gas switch  lights, open the top cover for cooling

(3). When the temperature is below 100 °C then turn off the total power source and put the top

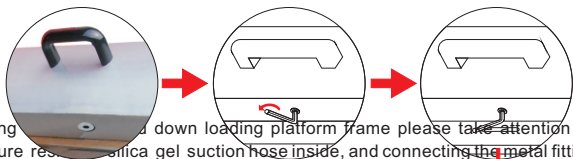
## SECTION 7: Daily maintenance and matters needing attention

1. Please keep the machine in good grounding, please check if cooling fan could work useful before use the machine.

2. For ensuring the vacuum machine work useful, if the configuration is oil vacuum pump please fill the vacuum pump oil .

3. The vacuum tank machine bottom and air filtration tank used for a long time will have water, please remove stagnant water and clean or replace the filter element regularly. The aluminum plate and the mesh pad is used for auxiliary exhaust, transfer such as sheet metal, ceramic tile, glass and other flat objects when placed in accordance with the P4 page graphic sequence; transfer porcelain should remove aluminum plate only use mesh pad.

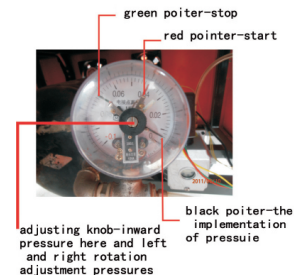
4. When the upper and lower silicon rubber need to replace please use the six square wrench to remove up loading and down loading platform frame, and then the frame block silicone rod groove in the pull off silicon rubber old, will the new silicon rubber paving still the original silica rod block formation pressure, as shown in the following show:



5. Handling the down loading platform frame please take attention to the high-temperature resin silica gel suction hose inside, and connecting the metal fittings should ensure strict, not to hose off to prevent leakage. Vacuum negative pressure gauge of the upper limit of -0.07Mpa, bound to -0.04Mpa, when it can't catch up to the preset pressure or vacuum pump working non-stop please check material platform frame and pumping gas pipeline leakage.

6. If you want more vacuum pressure can regulating electric contact pressure gauge in the down part of the machine, to make the pressure increases or decreases, the specific methods following:

7. After the cup when the feed table border will transfer out, the chrome bracket fixed screen placed in the cup down inside the machine, put down the machine cover. The cup number can be a place, space is not contacted with each other, the maximum height of not more than the height of the cup attention inside the machine.

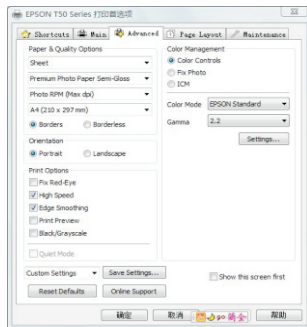


## SECTION 8: Common problems and troubleshooting

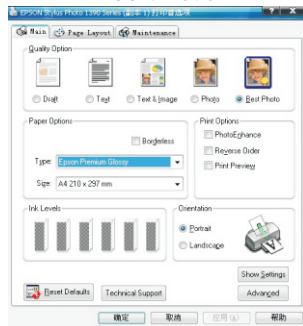
NO	PHENOMENON	REASON	SOLUTION
1	The color pattern on the paper is not bright, residue, low transfer rate	Transfer time is short	Prolong the transfer time
		The low temperature	Increasing the temperature appropriate
2	The color pattern on the paper is not bright, residue, high transfer rate	Transfer time is too long	Shorten the time
		hyperpyrexia	Decrease the temperature
3	The pattern edge edges, the haze phenomenon, local pattern hair virtual fuzzy	The thermal transfer paper and substrate not tightly, or no air discharge	Adjust the vacuum pressure or the substrate surface covered with cloth let the paper than the substrate
4	Vacuum pump working non-stop, numerical pressure gauge with low or jitter, Buck quickly	Pipeline leakage or feed table	Check the pipeline connection or feeding machine sealing, eliminate the leakage
5	Vacuum pump pumping speed and frequent start	Vacuum pump oil level is low or the filtering tank water	Filling the vacuum pump oil, drain the water cleaning filter
6	Large area transfer color hair is not uniform or preheating time more than 30 minutes	The heating element is damaged or a circuit component loosening	Check the heating element and the supply line
7	The display is not normal or failure of a key	The control board is damaged or cooling fan casing damage resulting in high temperature	Shutdown cooling to see whether the restoration, check the fan or the control board and replace

## SECTION 9:Printer common settings

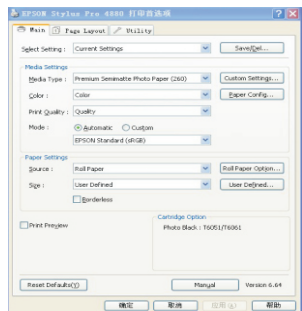
EPSON T50



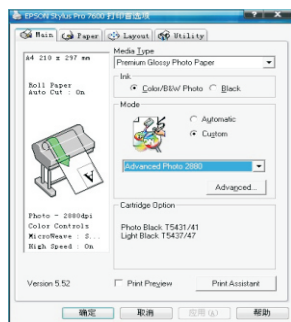
EPSON 1390



EPSON 4880



EPSON 7600



## SECTION 10: All kinds of material transfer parameters



METAL SHEET 170°C  
1min



SUBLIMATION ROCK 170°C  
6min



WINE BOTTLE 170°C  
8min



MUGS 190°C  
7min



GLASS FRAME 170°C  
4min



PLATE 170°C  
4min



CRYSTAL 170°C  
7min



TEXTILE 170°C  
40S



CERAMIC 170°C  
3min



ASHTRAY 170°C  
7min



WINE GLASS 170°C  
5min



IPHONE CASE 170°C  
4min

Note: due to the transfer colour is influenced by many factors, the data only for your reference, the specific time and the data only be your



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## Product certification

Product Model 3D sublimation heat press      Product Name \_\_\_\_\_

Inspector \_\_\_\_\_      Factory number \_\_\_\_\_

Inspecting Date \_\_\_\_\_      Manufacture date \_\_\_\_\_

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## Warranty card

The customer name \_\_\_\_\_      Address \_\_\_\_\_

The contact \_\_\_\_\_      Contact way \_\_\_\_\_

Purchase date \_\_\_\_\_      Dealers \_\_\_\_\_

Note: due to the transfer to the colour is influenced by many factors, the data for reference only, the specific time and the data for reference only.

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