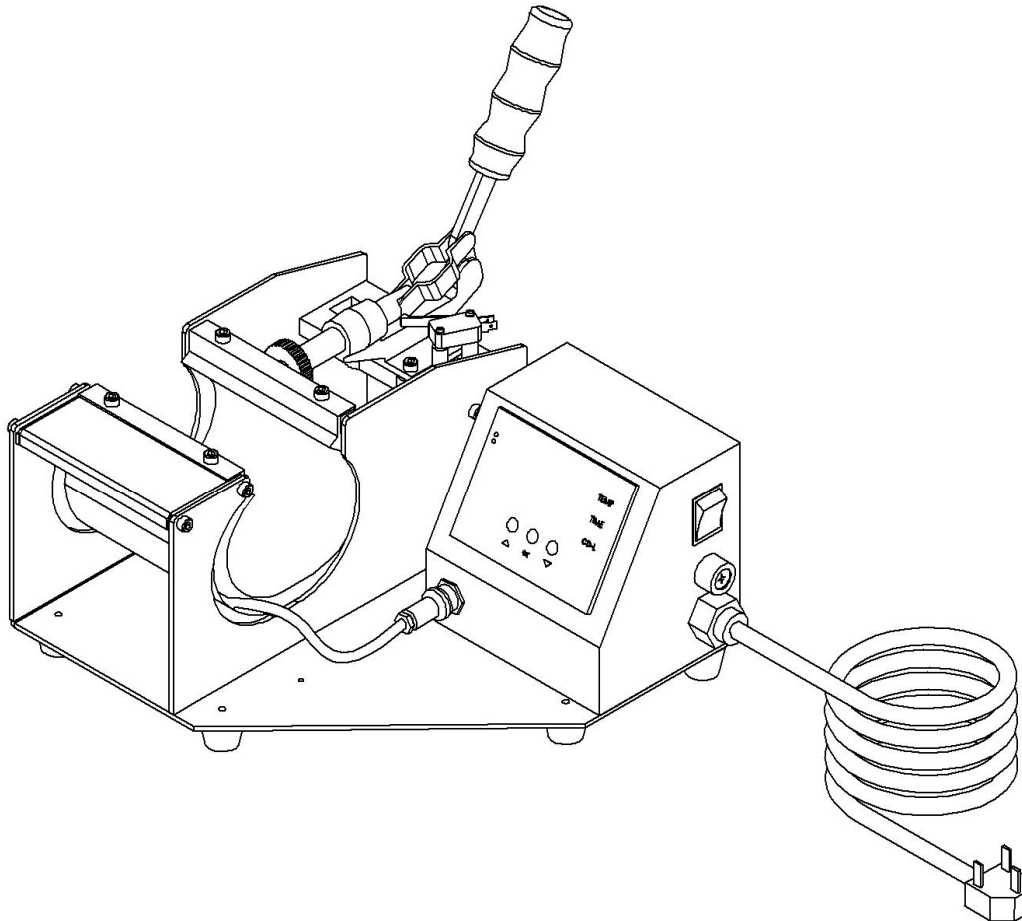


Digital Mug Heat Press Manual

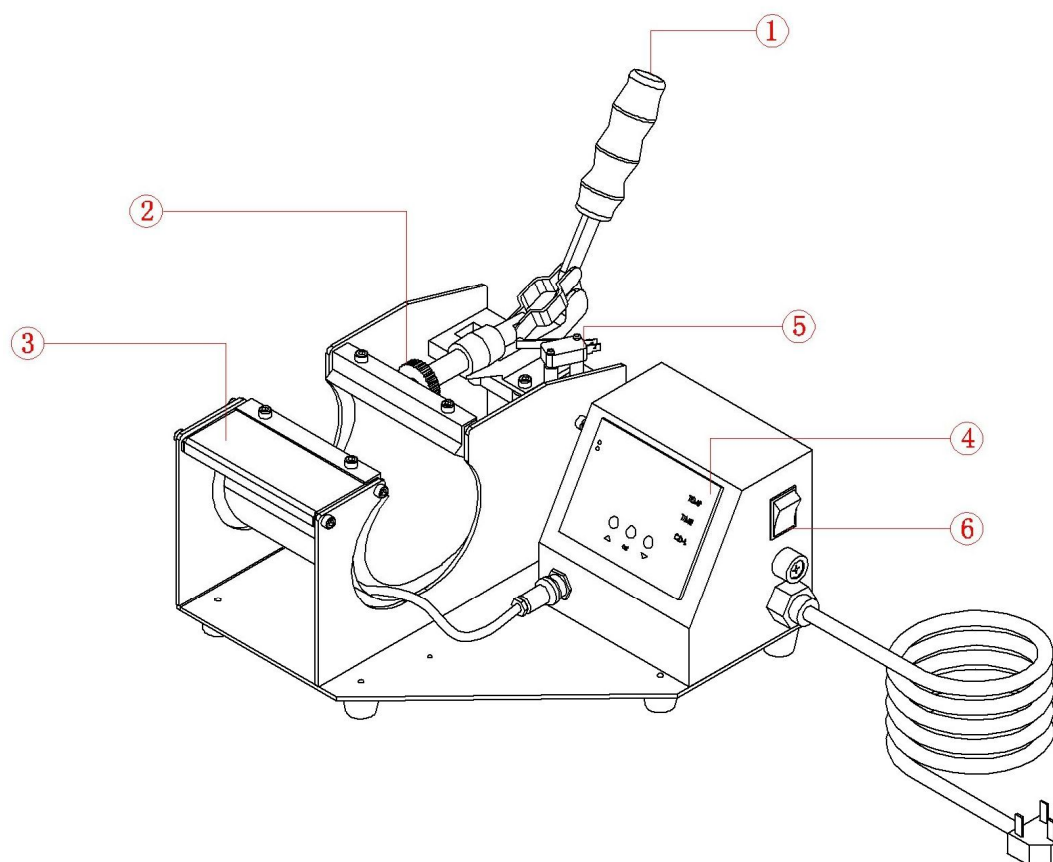
Model No.: MP-70AA/BA/CA



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I. Assembly Drawing



- | | | | |
|-------------------|---------------------|--------------|----------------------|
| ① Handle Bar Grip | ② Pressure Adjuster | ③ Mug Heater | ④ Digital Controller |
| ⑤ Limit Switch | ⑥ Power Switch | | |

II. Technical Parameters

1. Model No.: MP-70C70AA/BA/CA
2. Machine Dimension: 310*290*150mm
3. Mug Heater Size: Dia.6-7.5cm for 6oz,9oz,10oz etc Mug
Dia.7.5-9.0cm for 11oz,15oz etc Mug
4. Printable Articles Max Size: ϕ 100*120mm
5. Voltage: 220V/1Phase; 110V/1Phase
6. Power: 0.3KW
7. Recommend Setting: 30~280s; 180~200°C
Time Range: 0~999s
Maximum Temp: 225 C°
8. Packing Size: 41*39*33cm
9. Gross Weight: 4.75kg/4.85kg/5kg

III. Operating Process

1. Set temperature required

		
Turn on power switch, temperature light is ON. The digital display shows as above.	Press  button, the  light is on (C denotes Celsius). Press arrows “△” or “▽” to select “°C” or “°F” (F denotes Fahrenheit) according to your habits.	Press  button, the temp  light is on. Select with arrows the temperature according to different transfer material (Normally 180°C~200°C) SV: Set temperature PV: Current temperature

2. Set time required

	
Press  button after temperature setting and the time light is on. Select with arrows the time according to different transfer material. SV: Set temperature PV: Current temperature	Press  button to operating mode. Counter is “transfer cycle”, from 0~999. Press “Reset” for 5 seconds to make the counter to be “0”.

Kindly take NOTE:

1) The P-1 mode is Temperature Difference Calibration Model.

2) The P-2 mode is Heating Mode Setting.

 The image shows the GY-06 Digital Controller in P-1 mode. The top line of the LCD display shows 'P-1' in blue and '170' in blue. The bottom line shows '001' in green. Below the display are four buttons: an up arrow, 'OK', a down arrow, and 'Reset'.	 The image shows the GY-06 Digital Controller in P-2 mode. The top line of the LCD display shows 'P-2' in blue. The bottom line shows '003' in green. Below the display are four buttons: an up arrow, 'OK', a down arrow, and 'Reset'.
When there is temperature difference between SV (current heating temperature shows on the display screen) and actual Temp of heat platen, please long press  button for 5 seconds to enter the P-1 mode to calibrate. For example: When set 200°C, during the heating process, if you find the current heating temperature display shows is 180°C, but the measured actual temperature of heat platen is 170 °C, then please enter P-1 mode and press arrows “▽” to decrease 10°C(adjust the display' Temp value to be same with the actual Temp value.) Then after adjust, the display will be 170°C. and then the machines will keep heating to 200°C:	We already preset it to 003 before shipment. That is to say, if your setting temperature is 200°C, it will slow down the heating speed when it heats up to 197°C for a safe purpose. The suggest value of P-2 mode is 3°C~5°C. If you want to reset the value, long please press  button for 5 seconds to P-1 mode, and then press  button again to enter into the P-2 mode, and then press arrows “△” or “▽” to set the value you need.

3. Printing methods

Step 1: Make sure the cord is connected well to the wall socket. Place the mug in the mug heater, and transfer paper with images facing down the mug, adjust moderate pressure, and power on.

P.S: use heat resistant tape to fix the transfer paper, make sure transfer paper is exactly attached to mug heater;

Step 2: Set the temperature and time required, then temperature starts to rise.

Step 3: When the temperature rises to the setting temperature, the buzzer sends out sounds; then press the handle, (meantime the sounds stop) and starts to transfer.

Step 4: Then the time counter is on, once time is up, take out the mugs. Transfer work finished.

5. Recommendations:

Ceramic Mug transfer: Set temperature: 180°C. Set time: 150 seconds

V. Maintenance

1. No action after turn on the machine

- 1). Check the plug whether it connects well or whether it is broken.
- 2). Check the power switch or digital controller whether it is broken.
- 3). Check the fuse whether it has been burnt out.
- 4). Indicating light is on, but no display on screen, check the 5 cable of Railway transformer. If it's loosening, showing the problem is poor connection. If they connects well, showing that the Transformer is faulty.

2. The display screen are working well, but no temperature increasing on the mug heater.

- 1). Check whether the thermocouple of the mug heater touches well. If the thermocouple is loose, the display will show 255°C. and machine keeps beeping.
- 2). Check if the indicating light of solid-state relay is on, if not, check if the relay or digital controller is broken.
- 3). If you already changed the new solid-state relay but the mug heater still can't heating up, check if the mug heater is faulty or the mug heater's power cable is loose, need to change by new mug heater.

3. The display screen show 255°C once you power on.

- 1). Check whether the thermocouple is loose or not.
- 2). If the thermocouple touches is not in loose state, but still show 255°C, then it is faulty.

4. The machine is heating during 0~180°C, but display number jumps to above 200°C or 300°C suddenly, or the numbers on display jumps irregularly.

- 1). Check whether the thermocouple of the mug heater touches well.
- 2). If the thermocouple is good, It shows that the program of digital controller is broken, which namely IC or is broken, need to change by new controller.

5. The temperature is out of control: Set 180°C, but the actual temperature is above 200°C.

- 1). It means the solid-state relay is broken, out of control, need to change the relay.
- 2). Or the digital controller is faulty and it keeps conveying electric to relay, need to change controller.

6. The setting temp and time becomes abnormal after exchange the mug heater.

- 1). Please reset the temp and time according the operation process manual.

7. Other notice

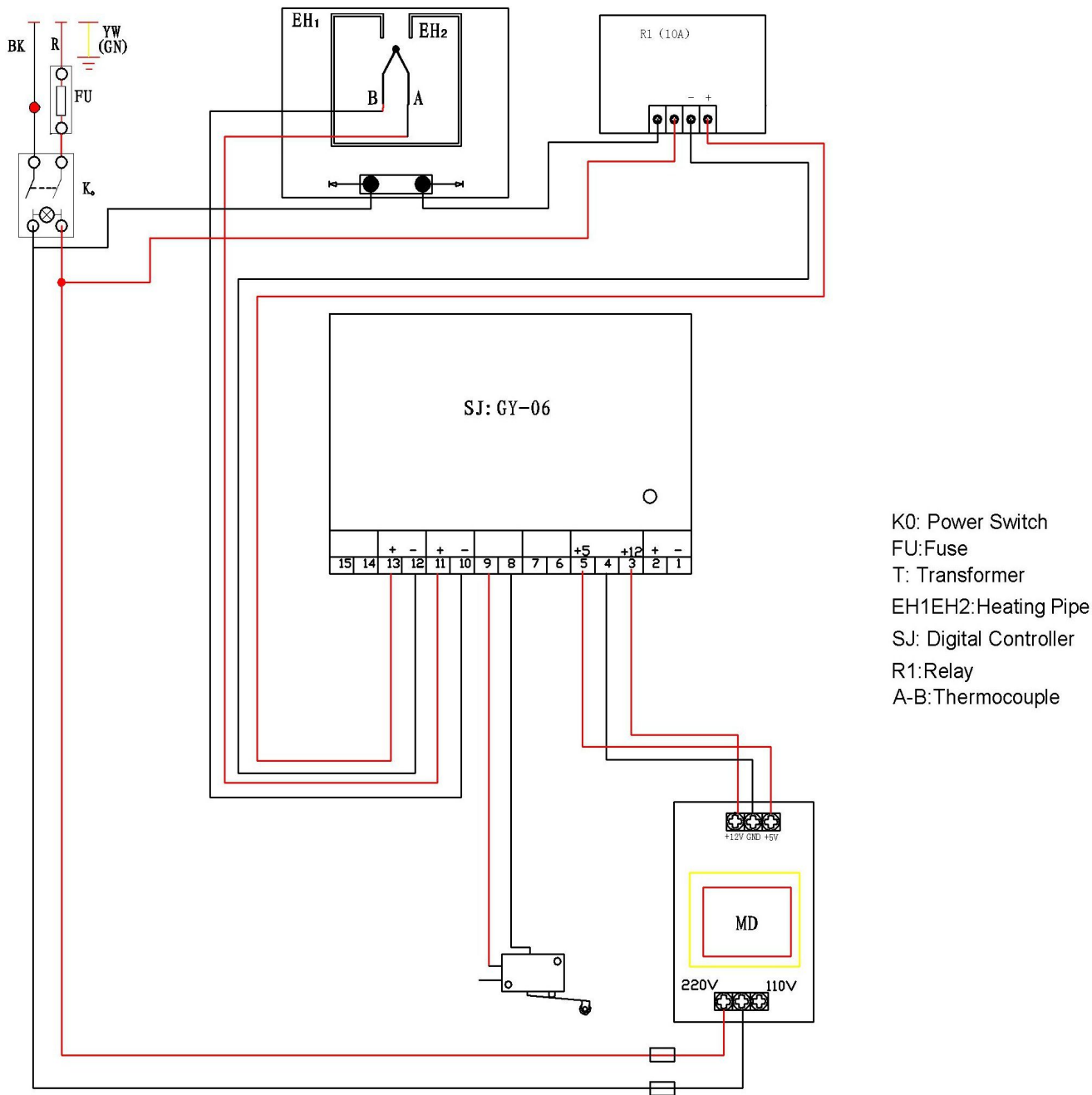
- 1). In order to prolong the machine service life, please add the lubrication oil regularly on the joints.
- 2). In order to keep the mug heater's good transfer effect, pls protect it carefully whenever you are using or not.
- 3). Please keep the machine in dry place.
- 4). The mug heater is belong to consumables. You need to change a new one after doing transfer print for about 700 times. If use our Grade A mug heater, then can change mug heater after 2000 times transfer.
- 5). If you are not able to solve the electrical parts problem, please kindly contact the supplier and get technical support.

IV. Trouble shooting for transfer print quality

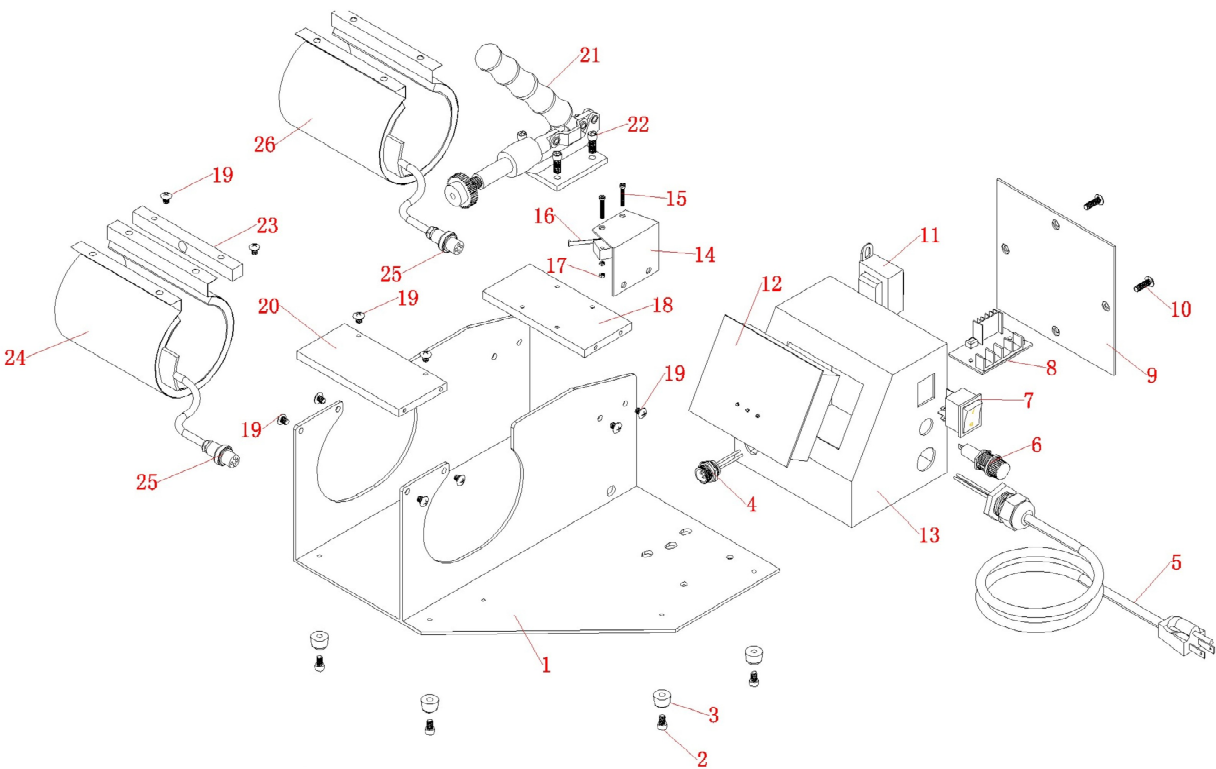
1. If the print color is pale: the temperature is too low / the pressure is not correct / or not pressed long enough.
2. If the print color is too brown or the transfer paper is almost burnt: reduce the setting temperature.
2. If the print is blurring: too much transfer time causes proliferation.
3. If print color is different/ partial transfer effect is not good enough: the pressure is not enough / or not pressed long enough / or poor quality transfer paper.
4. If transfer paper stick to the object after transfer: the temperature is too high/ or poor quality printing ink.

VI. Circuit Diagram

MP-70BA Wire diagram
(GY-06 Digital Controller 220V)



VII. Explosion View



Serial No.	Part Name	Qty
1	Machine Base	1
2	Screw	5
3	Rubber Foot	5
4	Female Socket	1
5	Power Cord	1
6	Fuse	1
7	Power Switch	1
8	Solid State Relay	1
9	Electrical Case Cover	1
10	Screw	4
11	Transformer	1
12	GY-04 Digital Controller	1
13	Electrical Case	1

14	Limit Switch Cover	1
15	Screw	2
16	Limit Switch	1
17	Nut	4
18	Connect Board	1
19	Screw	12
20	Adapter Plate	1
21	Handle Bar Grip	1
22	Hex Head Screw	4
23	Heater Fixing Connector	1
24	Small Mug Heater	1
25	Male Socket	1
26	Big Mug Heater	1