



4400 Cantrell/Practix Road  
Acworth, GA. 30101

Phone: (770) 974-1480  
Fax: (770) 974-1584

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# **Practix OK-385**

## **2 Station Shuttle Press**

### **Operations Manual**

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## WARRANTY

Practix Mfg. LLC will replace free of charge, F. O. B. Purchaser's plant, within 365 days (1 year) from time of shipment to the original purchaser, any mechanical part, within six (6) months any electronic component, and within six months (6) on a prorated basis any belt found in our judgment to be defective.

This Warranty does not cover damage to the Machine or any part thereof found in our judgment to be the result of accident, negligence, or misuse. This warranty shall become ineffective if the product or component is altered by anyone other than Practix employees. Damage incurred in shipment should be reported to the designated carrier. It is his responsibility to ensure arrival in perfect condition.

This Warranty covers only labor and material. Expenses will be charged at cost. This warranty does not include installation of the product or component.

This Warranty is registered in the name of the original Purchaser and is non-transferable.

**Practix Mfg. LLC will, in no case and under no circumstances, be liable for special or consequential damages, loss of profit or commission or for loss or delay in production.**

Warranty will be non-redeemable if the balance on the Purchaser's account for the product is delinquent.

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Mechanical Warranty Begins \_\_\_\_\_ through \_\_\_\_\_  
Electrical Warranty Begins \_\_\_\_\_ through \_\_\_\_\_

## **WARNING!**

At no time during the operation of the machine should any beverages or liquids be placed anywhere on the top of the Machinery to prevent injury from electric shock.

It is the responsibility of the Purchaser of this Machinery to train his personnel in the proper manner of operation.

It is further understood that Practix Mfg. assumes no responsibility for injuries, disabilities, or death resulting from the improper operation of, removal from the Machinery, or bypassing of any electrical or mechanical safety devices incorporated in the design and manufacture of this Machinery.

NOTE: During the first few hours of operation the Machinery will release fumes due to the normal curing of coating materials.

**PRACTIX MFG.  
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We at Practix Mfg. appreciate your purchase of our product. Your new machine is built to perform flawlessly for years to come.

This Operations Manual should be referred to for the installation, operation, and maintenance of this machine. Regular maintenance will ensure a long and trouble-free service life.

Design and development of Practix Machines are subject to constant improvement. There is no obligation on our part to carry out improvements, free of charge, on machines already delivered.

For further questions concerning machine maintenance, call:

**PRACTIX MFG.**  
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## ***INSTALLATION***

Position the machine on a solid, level section of the floor before removing it from the skid.

**NOTE:** Leave sufficient clearance around the machine for material movement and maintenance personnel.

1. A certified electrician in accordance with local standards and electrical codes should make the electrical connections for 220/240 Volt-1 or 3 Phase industrial equipment.
2. Bring the power supply to the wall adjacent to the machine. Install a breaker.
3. Run conduit and wire to the ceiling and then down to the top of the quick disconnect box on the machine. Connect to the main power distribution block on the quick disconnect box.
4. Bring air supply to the machine using hose or pipe. Airline must be a minimum 1/4" I.D. to achieve proper pressure and fast filling of cylinder.

***In case of problems or questions, please contact Practix Mfg.***

## **Leveling and Squaring**

1. Use a spirit level.
2. Place the level first on the top of the lower platen across the longer side of the platen. Adjust the legs as necessary.
3. Place the level on the top of the lower platen across the shorter side of the platen. Adjust the legs as necessary.
4. Repeat steps 2 and 3 on the lower platen.

## ***OPERATION***

To energize the machine, move the switch on the quick disconnect box to the ON position. Next, move the toggle switch marked MAIN SWITCH to the “ON” position. Make sure to turn on the compressed air to the machine.

Adjust the pressure regulator/filter on the side of the machine marked PRESSURE. Next, adjust the pressure regulator marked SPEED. This pressure regulator should be set to approximately 50 PSI.

To heat the top platen, set the temperature on the controller to the desired temperature. Wait for the machine to reach the correct temperature.

***NOTE: FOR MORE DETAILED INSTRUCTION ON THE TEMPERATURE CONTROLLER, SEE THE TEMPERATURE CONTROLLER SECTION IN THE BACK OF THIS MANUAL.***

When the machine reaches full temperature, the temperature controller indicator light will cycle on and off to maintain the desired temperature. If the heaters or temperature controllers do not energize properly consult the TROUBLESHOOTING section. After the machine has reached full temperature, it is ready to be used for printing.

To move the heating platen from side to side, use the toggle switch on the top of the machine. Move the heating platen to the end of the stroke and press both of the green start buttons to energize the pressing cycle. Set the desired time on the timer.

## ***HEATER STRIP REPLACEMENT***

1. Remove the outside side covers from both sides of the heater platen.
2. Remove the cover from the top of the machine.
3. Disconnect the power wires going to the heater platen from the contractor inside the top of the machine. Also, disconnect the thermocouple wire from the temperature controller on the machine.
4. On the support plate of the heating platen assembly, there are approximately 6 to 10 nuts and washers that hold the heating platen up. Remove these nuts and washers. Remember to place something under the heater platen so that the platen does not drop once the nuts are removed.
5. Remove the spacer material from under the heater platen so that it is resting on the lower platen. Slowly move the head of the machine over to the other side.
6. To remove a heater, loosen the hold down brackets on and around the heater.
7. Disconnect the wires, slide out the old heater, and replace it with a new heater of the same type.
8. Replace everything using the reverse of the above procedure.

## ***MAINTENANCE***

**NOTE:** We recommend a regular maintenance plan as outlined below. These maintenance points are considered a very minimum. Additional maintenance is left to the Owner's discretion.

### **1. Daily Maintenance**

Cleaning: Vacuum or blow off any visible dust and lint.

### **2. Weekly Maintenance**

A. Cleaning

- Clean any buildup off the heater platen and bottom rubber pad.
- Remove any visible accumulation of dust, lint, or resin.

### **3. Monthly Maintenance**

A. Cleaning

- Remove thread and lint deposits.
- Remove dust and lint accumulation from pivot points

## ***TROUBLESHOOTING***

This section is provided for the identification and repairs of items considered as field serviceable and are part of the maintenance of any machine. Problems falling outside the areas covered in the Manual should be first isolated as far as possible, then repaired only after consultation with your Deal or our service department.

<u>Problem</u>	<u>Checklist</u>
Main controls fail to energize	A. Electrical power supply B. Control Fuses C. Incomplete circuit
Heaters fail to energize with Main controls energized	A. Main fuses B. Contactor C. Thermocouple probe D. Temperature controller E. Incomplete circuit
Heaters energize but fail to Come up to temperature	A. Incorrect line voltage B. Thermocouple probe C. Temperature controller faulty D. Temperature controller calibration off E. Heater element F. Incomplete circuit

## ***PRACTIX MFG. GUIDE TO QUALITY EMBOSSING***

These notes are intended for those who are new to the embossing business.

A few things need to be understood about your new embossing machine from Practix Mfg.

### **1. Backings**

These backings are the key to your embossing success.

- ◆ 1 ½ mil. This is the best backing for T-shirt and other lightweight items. The glue is not too heavy, so maintain a soft feed to the garment. Approximately 375 degrees F for 12 seconds. Experiment for your best results.
- ◆ 2 mil. Most suitable for heavy weight T's and regular-midweight sweats-up to 9 oz. usually. T's hit for 12-13 seconds at 375 degrees F, sweats hit at 320-330 degrees F for 25-30 seconds. Experiment for your best results.
- ◆ 5 mil. Used usually on leather, denim, and super weight 9 oz. sweats. Hit at 330 degrees F for approximately 35 seconds. For leather or denim, experiment depending on thickness.

### **2. Important**

Remember always to test wash your item before sending it out to your customer. The embossing concept is new and some experimentation is required. Do not be afraid to call Practix Mfg. or their representatives if any unexpected problem arises.

### **3. Platen Support**

Platen support for embossing plates which are not centered on the heating platen: The enclosed drawing Fig. 1 demonstrates how an embossing plate, when incorrectly centered on the heating element, will cause an uneven pressure between the embossing plate and the garment. This will cause, when washed, some of the "imprint" to come off in the wash. To prevent this from happening, simply place at the opposite end of the platen a piece of plywood or extra rubber backing equal to the thickness of BOTH the plate and the absorbent pad on the embossing table. This will provide an even pressure surface, to ensure an even emboss.

### **4. Rubber Absorbers**

There are two types of rubber absorbers available in thicknesses of ¼", 3/8", and ½".

- ◆ A. 20 Duro—best, as it is softer, for high detail emboss.
- ◆ B. 30 Duro—best, as it is stiffer, for large surface, open area embosses.

### **5. Tips**

Make sure your rubber absorber is cut to be the same shape as the plate, best just an 1/8" or 3/16" larger, and that your backings likewise are pre-cut to that same shape. In this way, the entire cut backing adheres completely to the garment, and the absorber does not leave any additional "platen marks" on the garment, for a clean looking emboss. It is advisable to chamfer sharp edges on the absorber.



## ***OMRON E5GN***

### **To Set Temperature Desired on the Controller**

Depress up or down arrow keys. Setpoint temperature is in the lower right corner.

### **To Recalibrate Controller (i.e. controller display temperature is different than actual temperature.**

Press  (gray button) once. AT OFF is displayed

Press  until in5 is displayed. Input value of the difference with up and down arrow keys.

Press  once to return to display temperature.

### **To Tune Controllers**

Press  once. AT OFF is displayed.

Press up arrow once. AT ON is displayed. Allow machine to run. Will take 10 minutes to 1 hour.

AT OFF is displayed when the controller is finished.

Press  once to return to display temperature.

## Practix OK-385 Parts List

<u>PART NO.</u>	<u>QUANTITY</u>	<u>DESCRIPTION</u>
385/101	4	Pneumatic Air Bag
385/102	1	Pneumatic Air Cycle
385/103	2	Air Solenoid Valve ¼" N.P.T.
385/104	2	Air Solenoid Valve 1/8" N.P.T.
385/105	2	Flow Control Valve
385/106	1	Square Relay
385/107	1	Square Base
385/108	1	Clevis for Push Cylinder
385/109	2	Fan 3 ¼
385/110	1	Transformer 50VA
385/111	1	Panel Fuse Holder
385/112	1	Contactora 50A
385/113	2	Start Push-button
385/114	1	Stop Push-button
385/115	1	Toggle Switch On-Off
385/116	1	Temperature Controller CAL 3200
385/117	1	Regulator w/ gauge for Platen Pressure
385/118	1	Regulator w/ gauge for Head Speed
385/119	1	J type Thermocouple
385/120	1	Timer
385/121	1	Timer Socket
385/122	1	Terminal Strip
385/123	1	Toggle Switch Left-Right
385/124	2	Limit Switch
385/125	1	2 Amp Glass Fuse
385/126	3	40 Amp Fuse
385/127	1	Main Disconnect Box