

# WARRANTY

(Effective September 1, 2010)

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. Thermatrol and doughXpress 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 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, canvas, rubber blankets, bulbs, glass, rod ends, turn buckles on printers 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, packaging and shipment/freight costs are solely the responsibility of the customer, and not that of HIX, and HIX shall not be responsible for improper packaging, handling or damage in transit. Contact HIX customer service for complete return authorization information. Correct shipping boxes are available from HIX.

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

1201 E. 27th Terrace • Pittsburg, KS 66762 • U.S.A.

Web site: [www.hixcorp.com](http://www.hixcorp.com) • Phone: (800) 835-0606 • Fax: 620-231-1598

E-Mail: [customerservice@hixcorp.com](mailto:customerservice@hixcorp.com) • E-Mail: [sales@hixcorp.com](mailto:sales@hixcorp.com)

# N-680D / N-880D

15"x15" / 16"x20" Air Automatic Heat Transfer Machines

## OWNER'S MANUAL



N-880D shown

**HIX CORPORATION**  
For Customer Service, Call 1-800-835-0606  
or Visit [www.hixcorp.com](http://www.hixcorp.com)

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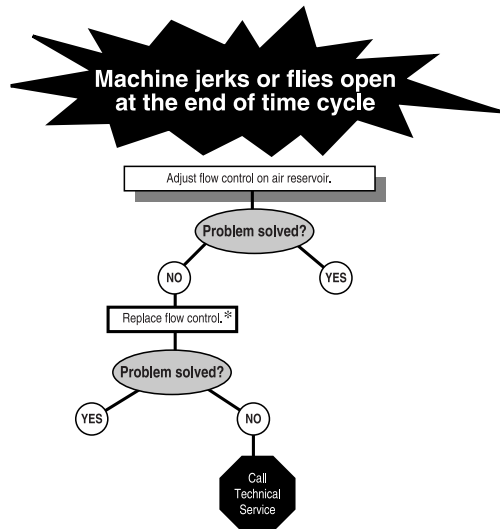
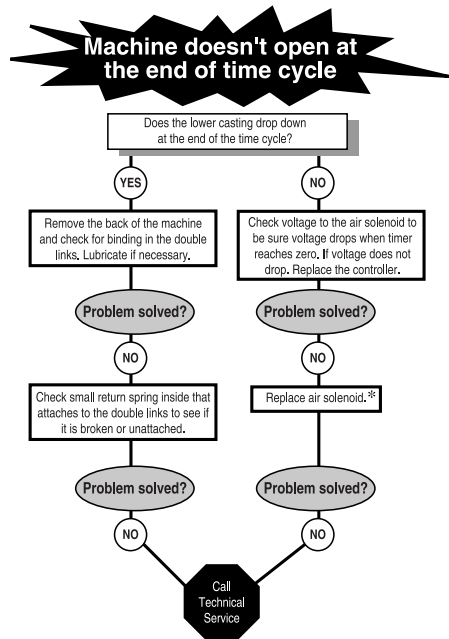
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**BEFORE warranty repair you MUST get Prior Authorization:**



# 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](http://www.hixcorp.com) to print or call 620-231-8568 and we will send you one. Parts ordering is available on-line.

# RECEIVING & INSTALLATION

- Supply a clean (void of oils) and dry (void of water) air source of 100-125 P.S.I. (6.8-8.5 bar) to the 1/4" NPT air inlet located on the left side panel (as viewed from the front) of the machine. Requires 1-1/2 to 2 CFM. It is strongly recommended that an external air filter and water trap be installed at the machine's air inlet connection. Compressed air is dirty. It has 'stuff', primarily moisture, residues from oil and smoke and whatever else is in the air. Compressors or 'shop air' may have filtered air and/or an "AIR DRYER" after the compressor. IF your air is not filtered and dried, YOU MUST FILTER THE AIR and REMOVE THE WATER AND 'STUFF' FROM THE AIR, before putting it in most air operated machines, including our press. There are small valves and ports that can become blocked from moisture and residue in compressed air, causing your press to malfunction. An external air filter and water trap must be installed at the machine's air inlet connection, if your air is not filtered. Damage to the machine's internal air operated components can occur that will not be covered under warranty. Combination air filter/water traps are available at any major hardware store or may be purchased directly from HIX (part #71145).

# OPERATION

Digital Display For Class D Models



## DIGITAL TEMPERATURE & TIME INSTRUCTIONS

- Turn on the machine by pushing the on/off switch.
- 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.
- To change or set the time, press the menu button on the digital control. The light next to "TIME" will light. Press the up ▲, or down ▼, button to your desired setting.
- When you have your desired settings **press the menu button a third time to lock in your settings** otherwise the previous settings will still be used.
- Wait for the machine to reach your preset temperature by monitoring the display temperature until it matches the set temperature.

Daily cycle is displayed by holding the up key while powering up. It will continue to display counts (up to 9999) while the up key is pressed. When the key is released it goes to regular mode. To reset the daily count press the down key while still holding the up key.

## AUTO SHUT OFF FEATURE

**NOTE:** This machine is programmed from the factory to turn the heat off after 3 hours of non use.

One Minute before the machine is going into “Auto Shut Down” mode, the controller will “BEEP” five times to alert the operator that the machine is about to shut the heat off. If nothing is done, then in one minute, the display on the controller will show “OFF” and the machine will start to cool down.

To circumvent from shutting the heat off, or to reactivate the heat from the “Auto Shut Off” mode, simply lower the handle of the machine to activate the timer and it will start heating again for another 3 hours.

### CHANGE AUTO SHUT OFF TIME SETTING

1. Power “OFF”, press and hold the “Down” button, then power “ON”. Release the “Down” button. The current Auto Shut Off Time will be displayed.
2. Press the “UP” or “DOWN” button to change Auto Shut Off Time to desired Auto Shut Off Time, up to 12 hours in 1/2 hour increments. A setting of 5=1/2 hour, 10=1 hour, 15=1-1/2 hours, 40=4 hours, etc. A setting of Zero will disable the feature.
3. Press the “Menu” button once to lock in the new setting.
4. Wait 15 seconds for the controller to automatically exit the “Programming Mode”.

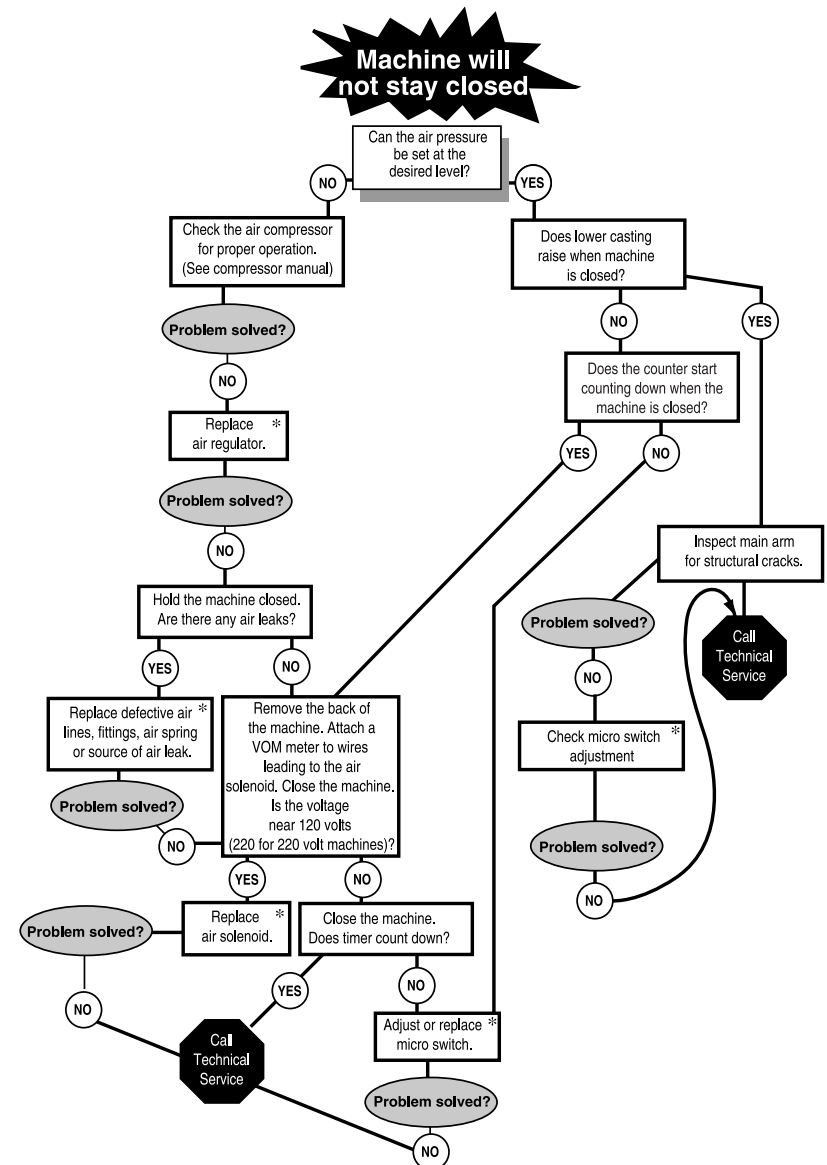
## PRESSURE

1. The air pressure control knob must be pulled out to allow for pressure adjustments then pushed in once final adjustments have been made. Set the air pressure by turning the regulator control knob and monitoring the air pressure gauge.
2. Set the air pressure to 40 P.S.I. (pounds per square inch). Turn the control knob clockwise to increase the pressure and counterclockwise to reduce it. Refer to your transfers manufactures guide for pressure recommendations. Your machine is protected by a pressure release valve which is preset at the factory.

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

## TROUBLESHOOTING

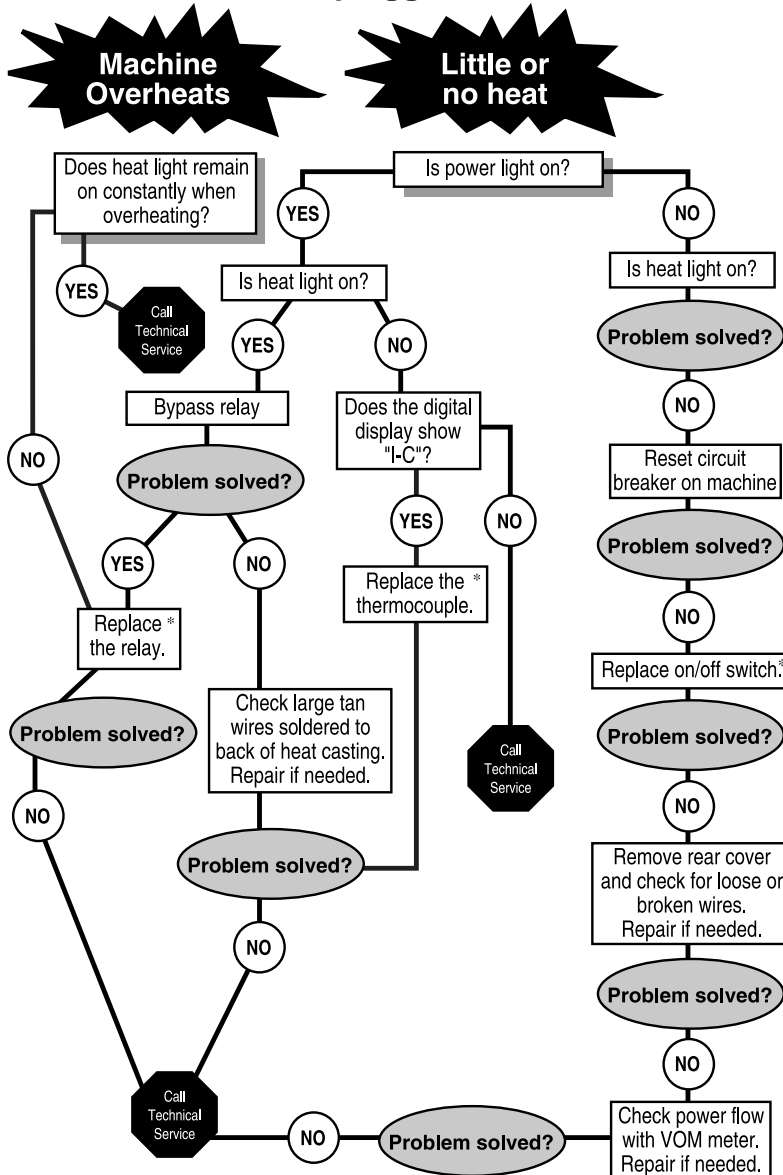
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# TRANSFER APPLICATION

The 120 volt models have a slower heat recovery (i.e. 18-20 seconds @ 375°F). The 220 volt models are recommended for quicker cycle times (i.e. 10 seconds @ 375°F).

1. Set the temperature, time, & pressure to the desired settings as instructed. **Always** consult your specific transfer recommendations. Typical settings are; **Cold Peel:** 350°F (177°C), 15 seconds and **Hot Split:** 375°F (190°C), 10-12 seconds.

2. Align substrate on lower platen. Smooth wrinkle from garments.

**NOTE:** Wrinkles may be removed by bringing the heated platen in contact with the garment for a few seconds before the transfer is positioned. Push the **platen release** button provided on the front of the lower right frame tube of the machine to interrupt the normal cycle and release the upper heat platen.

3. Position the transfer in the desired location on the substrate.

**NOTE:** The transfer image should be "mirrored" before transferring except when transferring to substrates where the image shows through, i.e. glass tiles and cutting boards.

**TIP:** When transferring double sided or sublimation transfers to garments, always place a sheet of transfer paper or a PTFE sheet between the layers of the garments to avoid bleed through or reheating of the applied transfer.

**TIP:** When sublimating to tiles and/or cutting boards, first place a tile blanket or felt pad on lower platen, second the transfer, third the substrate and finally a PTFE blanket or transfer paper to protect the upper platen.

4. Swing the upper heat platen over the lower platen. A stop is installed for perfect alignment between the upper and lower platen.
5. Pull the handle down until the handle locks.
6. Continuously peel the paper off the transfer and garment.

**NOTE:** Do not fold the transfer back on itself. 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. Specific application instructions are enclosed with transfers.

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



## TRANSFER APPLICATION

When you fail to make a successful transfer you can wonder, “Is it the machine’s fault, or the transfer, wrong settings or what”?

### FIRST, THE BASICS:

1. Be sure to set the heat transfer machine to the transfer manufacturer’s recommended Temperature, Time and Pressure settings. If you don’t have these specifications, contact your transfer supplier for this information and any other special application instructions as many of the new “High Tech” transfers require significantly different settings and/or application techniques than those from years past.
2. When you start up your press for the first time each day, preheat the pad for a minute. If the press has sat for 3-5 minutes without use, be sure to “preheat” the pad for 10-15 seconds before loading the shirt or making the first transfer.
3. After the shirt is positioned and centered on the preheated pad, “pre-press” the shirt for 3 seconds to take the wrinkles out and more importantly, release any excess moisture out of the T-shirt fabric which can reduce the chance of a successful transfer.
4. With all of the above recommendations, try making a transfer.
5. If successful, great! You are on your way to making some serious money with your transfer machine!
6. If you have an area that isn’t transferring completely or as you would like it to, follow these steps to determine the problem.
  - Try increasing the pressure on the machine by 10-20%
  - Recheck your temperature required and the press readout. You may want to increase the temperature 10 degrees.
  - Try increasing the application time by 2-4 seconds
  - If after trying these things there is still a “specific” area (say over in one corner of the transfer) that isn’t coming out as you would like it to, then try the same type transfer on a scrap shirt but rotate the transfer 180 degrees (changing the failure location) If after doing this the problem area is in the same physical location on the machine, then you probably have a problem with the pad or possibly a warped platen if the machine has ever overheated severely. On the other hand if the transfer failed in the same area on the transfer (after changing the location of where the problem had previously been occurring), then you most likely have a problem with the transfer or it’s application settings (Temperature, Time or Pressure) and you should contact your transfer supplier to discuss the problem.

Following these basic guidelines can help you be more successful with each and every transfer!

## REPAIRS

### RELAY BYPASS

**WARNING:** Before making repairs, be sure ON/OFF switch is OFF and machine is unplugged!

**ATTENTION:** Eteindre la machine avant de faire des réparations.

1. Remove the back cover of the machine.

**WARNING:** To prevent possible electrical shock, unplug the machine before removing cover to service.

**ATTENTION:** Afin d’éviter des choques électriques, éteindre la machine avant d’ouvrir.

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.

## MAINTENANCE

### LUBRICATION

Every 6 months add one to two drops of 3-in-1 oil (available at hardware stores), to the joints of all moving parts.

### CLEANING HEAT PLATEN

Clean the heat platen with steel wool, scrubbing aluminum sponge, or fine wire brush.