

Below information is for Electronic Heating Roller Heat Press, for Oil Heating Roller Heat Press, the method before is not applicable, please watch video: <https://youtu.be/zIJN78MA2Ik>

### **Electronicc Roller Heat Press Blanket Preparation and Care**

First: reset the Temperature control <https://youtu.be/Gdf-jLiW6RY>

Second: lose the Blanket, pull it to centre of roller heat press, do not add tension, get the blanket rolling without Slippery. if slippery, add a little tension with roller, to make sure the bars able to roll the blanket

Follow steps below:

1. 90°C half hour (on the machine setup temperature at 90°C run 30 minutes) Clockwise
2. 130°C half hour (on the machine setup temperature at 130°C run 30 minutes) Counterclockwise
3. 150°C half hour (on the machine setup temperature at 150°C run 30 minutes) Clockwise
4. 190°C half hour (on the machine setup temperature at 150°C run 30 minutes) Counterclockwise
5. 200°C half hour (on the machine setup temperature at 150°C run 30 minutes) Clockwise
6. 210°C half hour (on the machine setup temperature at 150°C run 30 minutes) Counterclockwise

If the machine is not in use, the process of preparing the blanket can be stopped until the next time the machine is being used.

It is important to keep recording the step of the number of hours.

The blanket must be allowed to continue to roll loosely while the machine is cooling down during the blanket preparation and production stages.

If the preparation process - or later in production - is interrupted by load shedding, you must separate the blanket and keep it as far away from the heat drum as possible. If one spot becomes overheated , it will cause the blanket to burn and a new blanket will be required.

It is very important to keep checking the blanket tension every 10 minutes during the shrinking process, otherwise the parts of the blanket which have been shrunk will continue to shrink even further due to increased contact tension and trapped heat.

It's also important to keep the blanket in the centre position related to the heating drum during the blanket preparation stage and product stage.

This is achieved by providing equal tension from both sides of the tension wheel, you can keep increasing/decreasing either side when required to shift the blanket back to centre by the continuous rolling motion.

If the blanket shifts significantly to one side, you can loosen the blanket completely and drag it to the centre by hand. Allowing the blanket to rub against either side of the machine is going to damage the blanket and may also jam the machine.

## **How to prepare a new blanket for a roller heat press machine.**

*(previous doc)*

This is a new blanket. It is important to note that all roller heat press blankets will shrink when they are first used. Getting a blanket to shrink evenly is a process which has to be followed carefully to prevent shewing, bubbling and twisting which can result in a number of transfer issues.

To start, loosen the blanket by adjusting the tension wheels until the blanket stops rolling with the roller. Next tighten the tension wheels together slowly until the point where the blanket starts to roll. At this point start the process of heating the blanket up to 200 degrees C. This temperature must be maintained for at least 100 hours and up to 200 hours, checking every 10 minutes to loosen and retighten the tension wheels, ensuring that the blanket is merely rolling with the roller. Please also change the rolling direction every half hour to avoid the blanket shrinking in one direction only.

If the machine is not in use, the process of preparing the blanket can be stopped until the next time the machine is being used. It is important to keep a log of the number of hours. The blanket must be allowed to continue to roll loosely while the machine is cooling down during the blanket preparation and production stages. If the preparation process - or later in production - is interrupted by load shedding, you must separate the blanket and keep it as far away from the heat drum as possible. If one spot becomes overheated, it will cause the blanket to burn and a new blanket will be required.

It is very important to keep checking the blanket tension every 10 minutes during the shrinking process, otherwise the parts of the blanket which have been shrunk will continue to shrink even further due to increase contact tension and trapped heat.

It's also important to keep the blanket in the centre position related to the heating drum during the blanket preparation stage and product stage. This is achieved by providing equal tension from both sides of the tension wheel, you can keep increasing/decreasing either side when required to shift the blanket back to centre by the continuous rolling motion. If the blanket shifts significantly to one side, you can loosen the blanket completely and drag it to the centre by hand. Allowing the blanket to rub against either side of the machine is going to damage the blanket and may also jam the machine.