



BOBO

H E A T P R E S S

O P E R A T O R S M A N U A L



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BOBO

H E A T P R E S S

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GETTING STARTED

SETTING UP

- 1 Carefully remove the 3030 from the delivery box.
KEEP THE BOX AND PACKAGING!
You will need it for return-to-base servicing and repairs.
- 2 Place the 3030 on a solid, level surface at a comfortable working height.
- 3 Plug the 13 amp fused plug in to a 240V power supply.
- 4 Switch on at rear of machine base.
- 5 The 3030's display shows the temperature (PIC A) of the heated plate and the target temperature. You will note that the head temperature will now start to rise toward the target. Once at the target temperature the machine will regulate itself and keep the head temperature at +/- 5°C of the target temperature. When the temperature is out of operating temperature range the light will display red and turns green once the machine is within range. Only commence a heatsealing process when the light is green. If the light is red when a heatsealing cycle is started the warning buzzer will sound and the display will read 'FAULT: WAIT NOT WITHIN BAND'
- 6 **CARE** - the heatsealing head will become hot. The base will also become hot with use.
- 7 The various parameters i.e. temperature, pressure and length of heatsealing time recommended for various J&A heatseal products are given on pages 6 & 7. To change the various parameters on the 3030, see page 3.

PIC A



HEATSEALING

- 1 Practice on some scrap garments or cloth before tackling something of value! Some handy practical advice is given on pages 4 & 5 and if you are new to heatsealing we recommend familiarising yourself with this first.
- 2 Swing the heatsealing head out of the way (PIC B) to give a clear view of the working area.
- 3 Check the display is showing the correct parameters for the type of decoration and change if necessary - see No5 above.
- 4 Place the garment/item to be decorated over the base pad (PIC C)
- 5 Carefully position the badge or transfer on the garment.
- 6 Grip handle and swing head back across as far as it will go so that it lines up with the base pad.
- 7 Pull the handle down as far as it will go. It will remain 'locked' in this position throughout the heatsealing dwell time and does not need to be held down. You can however stop the heatsealing at any time during the dwell period by simply lifting the handle up.
- 8 When the dwell period is complete a buzzer sounds. Lift the handle and swing the heatsealing head out of the way. During the heatsealing process it is possible to see how many seconds of the dwell time remain by selecting the 'count down' read-out. (see page 3)
- 9 **CARE**
AFTER HEATSEALING, THE BASE PAD AND GARMENT WILL BE HOT
- 10 If the applied decoration is a transfer, peel away the transfer release paper. Check with page 6 to see if this needs doing straight away or when the garment and decoration have cooled.

PIC B



PIC C



CHANGING THE SETTINGS

GENERAL

The three important factors for a heatsealing process are time, temperature and pressure. The correct settings for each J&A product are given on pages 6 & 7.

Each of the three settings may be changed on the 3030 as below.

Generally, the left (◀) and the right (▶) buttons move the display from one parameter to the next.

The Up (▲) and Down (▼) buttons increase and decrease respectively the displayed setting .

TIME

Press the (▶) button until the time screen is displayed (shown below).

Press (▲) or (▼) until the desired dwell period (in seconds) is shown.

When heatsealing, the count down display counts down from the dwell time to zero at which time the buzzer sounds and the display reads "FINISHED RAISE HEAD".

COUNT DOWN nnnS
DWELL TIME nnnS

*Representation
of display screen*

TEMPERATURE

Press (▶) until the temperature screen is displayed (appears as below).

Press (▲) or (▼) until the desired temperature (in Celsius) is displayed.

HEAD Temp = nnnC
TARGET = nnnC

*Representation
of display screen*

PRESSURE

CARE BOTH TOP AND BOTTOM HEAT PLATES
BECOME HOT DURING OPERATION

To increase the pressure between the heat plates rotate the bottom plate anti-clockwise. To decrease the pressure, rotate the bottom plate clockwise.

COUNTER

The count registers the number of cycles completed and may be reset to zero as follows: Press the (▶) button until the following screen appears:

COUNT nnnn
PASSWORD >0000

*Representation
of display screen*

NB The cursor is at the left of the digits.

Now press the (▼ ▲) buttons together.

WARNING MESSAGES

DISPLAY READS	THIS MEANS	ACTION TO TAKE
WAIT NOT WITHIN BAND	Machine temperature is more than +/- 5°C outside of set temperature	Raise head and wait until light turns green.
BROKEN PROBE	Probe is broken or become detached from earth connection	Return machine to J&A for repair
OVER TEMPERATURE	Temperature reading from head is in excess of 250°C	Switch off. Allow to cool <i>NB - if the displayed temp is more than 15°C above set temp - there is probably a fault - switch off & return 3030 to J&A</i>

CHANGING THE HEAT PLATES

BOTTOM PLATE

TO REMOVE EXISTING BOTTOM PLATE

Swing head of machine to the side to give clear working access to the bottom plate. Rotate the bottom plate anti-clockwise. This in effect simply unscrews it and after several turns can be lifted away.

TO INSTALL REPLACEMENT PLATE

Insert post of bottom platen into the receptacle on the machine base. Rotate bottom platen clockwise until the required pressure is achieved between the plates.

TOP PLATE

The top plate can only be changed by returning the 3030 machine to J&A (International) Ltd.

HEAT SEALING BEST PRACTICE

Basically the heat seal procedure comprises three essential elements of time, temperature and pressure. These elements need varying for different fabrics, products etc. The tips and hints below will help you to achieve perfect results every time.

DON'T FORGET THAT J&A WILL BE ONLY TOO HAPPY TO GIVE ADVICE AND TEST FABRICS/GARMENTS FOR YOU

DIFFERENT TYPES OF BADGES/TRANSFERS

The correct heat seal parameters for each type of decoration supplied by J&A (International) Ltd are given on the product packaging and on the 'Heat Seal Parameters' chart available on request from J&A. A version correct at time of printing is shown on pages 6 & 7.

The parameters quoted above are guidelines which are satisfactory for most fabrics but do please read the points below and bear in mind they may occasionally dictate that parameters are set outside usual ranges. J&A (International) Ltd accept no liability for goods damaged by the heat sealing process.

DIFFERENT FABRIC TYPES

Differing fabrics require differing heat seal parameters to ensure good adhesion of the decoration and prevent marking/damaging the fabric/garment. J&A (International) Ltd have built up an extensive data-base of optimum parameters for various fabrics and will be pleased to advise and recommend settings.

FABRIC THICKNESS

Principally, the thicker the fabric, the longer the dwell time required. There is no exact formula to determine the time required - simply experiment with the particular fabric you are using as to what dwell works best.

OPENING OUT GARMENTS

Wherever possible, only heat seal onto one thickness of fabric. This, for example, entails opening out garments and putting only either the front or back, as appropriate, over the base plate.

FABRIC FINISHES

Modern fabrics can be coated or finished with a variety of different chemicals to achieve different fabric properties and performances. Most do not affect the strength of adhesion of J&A heat seal products. On the rare occasions that the adhesion is not as strong as would be expected and fabric coatings are suspected as the cause, try heating the area of fabric to be decorated using the heat seal machine before applying the badge or transfer as this can evaporate away or “burn off” the finish in this area.

ADHESIVE SHOWING ROUND EDGE OF TRANSFERS

This can sometimes be seen when applying transfers to darker garments. In such cases the visible adhesive can be greatly reduced by removing the transfer release-paper in the normal manner after heatsealing and then sealing the transfer again for about 5 seconds.

‘DELICATE’ FABRICS

Some fabrics with a low melt point can show an imprint of the heat plates after heat sealing. This effect can be reduced / eliminated by, prior to sealing, covering the transfer and whole area of the garment that will be touched by the top plate with a sheet of silicone paper. Also reduce temperature to lowest possible for the type of product used.

GARMENT SEAMS, STUDS ETC

Wherever possible, make sure that any raised or thick parts of the garment, such as seams, buttons, studs etc fall outside of the heat area as shown below. Such factors entail reduced pressure and unsatisfactory adhesion which is not always immediately apparent.

CORRECT POSITION



INCORRECT POSITION



HEAT SEAL PARAMETERS - TRANSFERS

TRANSFERS	INTERPLATEN TEMP	DWELL TIME (SECS)	INTERPLATEN PRESSURE	PAPER RELEASE
CLEAN ROOM	200°C / 392°F	35	Medium	Hot
ENDURA	210°C / 410°F	15 - 20	High	Cold
FLOCK	165°C / 329°F	10	Medium	Cold
FR TRANS	210°C / 410°F	15 - 20	High	Cold
GLITTER TRANS	160 - 180°C 320 - 356°F	10	High	Cold
RADIANCE	140 - 180°C 284 - 356°F	12 - 18	Low	Cold
SILVER REFLECTIVE	160 - 180°C 320 - 356°F	10 - 12	Medium / Low	Hot
TRADEMARK	210°C / 410°F	7 - 10	High	Hot
TRIMAX <small>Tramax names are Cold Peel</small>	140 - 180°C 284 - 356°F	10	Medium / Low	Warm
TRIMAX PLUS	140 - 180°C 284 - 356°F	10	Medium / Low	Cold
TRIMAX GLOSS	140 - 180°C 284 - 356°F	10	Medium	Cold
TRIMAX KOLORMAX	140 - 180°C 284 - 356°F	10	Medium / Low	Cold
PRO FLEX	160°C / 320°F	10	Medium / Low	Warm
PRO FLEX PLUS	160°C / 320°F	10	Medium / Low	Cold
HOLOFOIL	140 - 180°C 284 - 356°F	10	Medium / Low	Cold

	PSI	BAR	KGF / CM ²	PASCALS
LOW PRESSURE	8 - 11	0.54 - 0.75	0.56 - 0.77	55000 - 76000
MEDIUM PRESSURE	12 - 16	0.82 - 1.09	0.84 - 1.12	83000 - 110000
HIGH PRESSURE	OVER 17	OVER 1.16	OVER 1.20	OVER 117000

Where Medium/Low Pressure is stated this is fabric dependant.

DISCLAIMER: Modern garments are coated and finished in many different ways. We recommend testing the best combination of heatseal parameters before applying the decoration. J&A (International) Ltd accept no liability for incorrectly applied decoration.

HEAT SEAL PARAMETERS - BADGES

BADGES	INTERPLATEN TEMP	DWELL TIME (SECS)	INTERPLATEN PRESSURE	PAPER RELEASE
CLASSIC	210°C / 410°F	15 - 18	High	N / A
OPTIMA	210°C / 410°F	12 - 15	High	N / A
RADIANCE	140 - 180°C 284 - 356°F	12 - 18	Low	N / A
SECURITY POCKET	210°C / 410°F	15 - 20	High	Cold
SILVER REFLECTIVE <small>For Industrial Wash badges (RL) remove carrier before application.</small>	160 - 180°C 320 - 356°F	10 - 12	Medium / Low	N / A
HOT STITCH <small>Apply heat to reverse of badge.</small>	210°C / 410°F	20	Firm	N / A

TAPE	INTERPLATEN TEMP	DWELL TIME (SECS)	INTERPLATEN PRESSURE	PAPER RELEASE
IDENTA	210°C / 410°F	12	Medium	N / A
PREMIER	210°C / 410°F	12	Medium	N / A
PRIMA	210°C / 410°F	12	Medium	N / A

3D	INTERPLATEN TEMP	DWELL TIME (SECS)	INTERPLATEN PRESSURE	PAPER RELEASE
3D (DOME) <small>Allow to cool before flexing</small>	160 - 190°C 320 - 374°F	15	Medium	N / A

	PSI	BAR	KGF / CM ²	PASCALS
LOW PRESSURE	8 - 11	0.54 - 0.75	0.56 - 0.77	55000 - 76000
MEDIUM PRESSURE	12 - 16	0.82 - 1.09	0.84 - 1.12	83000 - 110000
HIGH PRESSURE	OVER 17	OVER 1.16	OVER 1.20	OVER 117000

Where Medium/Low Pressure is stated this is fabric dependant.

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ROUTINE MAINTENANCE

3030 not working? - see the trouble shooting guide on page 9

Occasionally clean top and bottom heat plates with a solvent such as J&A Superspray and a clean, dry cloth.

Regularly check that the temperature between the heat plates is the same as is reading on the display. To measure the inter-plate temperature you will require a digital thermometer fitted with a thin thermocouple.

PROCEDURE

Set the dwell time to 60 seconds.

Place a thermocouple between the plates and pull down head.

The thermometer reading will rapidly rise and then level out.

If the reading is still rising at the end of the 60 second dwell period simply repeat until it does level out. The temperature indicated on the thermometer should be within $\pm 3^{\circ}\text{C}$ of the set temperature. If not, calibrate the machine as below.

CALIBRATION

Carry out the test above to determine if machine needs calibrating.

In order to access the 'temperature adjust' mode a four digit password must be entered to match the password set by the manufacturer at "0101". Change the display by pressing the **▶** button until the following screen appears:

COUNT nnnn
PASSWORD 0000<

Representation of display screen

The '<' symbol indicates that the right hand two of the four digits may be adjusted by using the **▲** and **▼** buttons.

Then press the **▶** button to change the display to:

COUNT nnnn
PASSWORD >0001

Representation of display screen

Indicating that the left hand two of the four digits may be adjusted using the **▲** and **▼** buttons.

Enter the password 0101 and wait for about 10 seconds.

The display will then change to:

COUNT nnnn
PASSWORD XXXX

Representation of display screen

The **▶** button may now be used to advance to a previously unavailable screen showing:

GAIN ADJUST
nnnC

Representation of display screen

This screen is displaying the temperature between the plates and can be adjusted to read the same as the thermocouple by using the **▲** and **▼** buttons.

Once the temperature has been calibrated the 'Gain adjust' screen may be disabled again by simply reverting to the password screen and altering the displayed digits to be anything other than the password (0101).

SERVICING

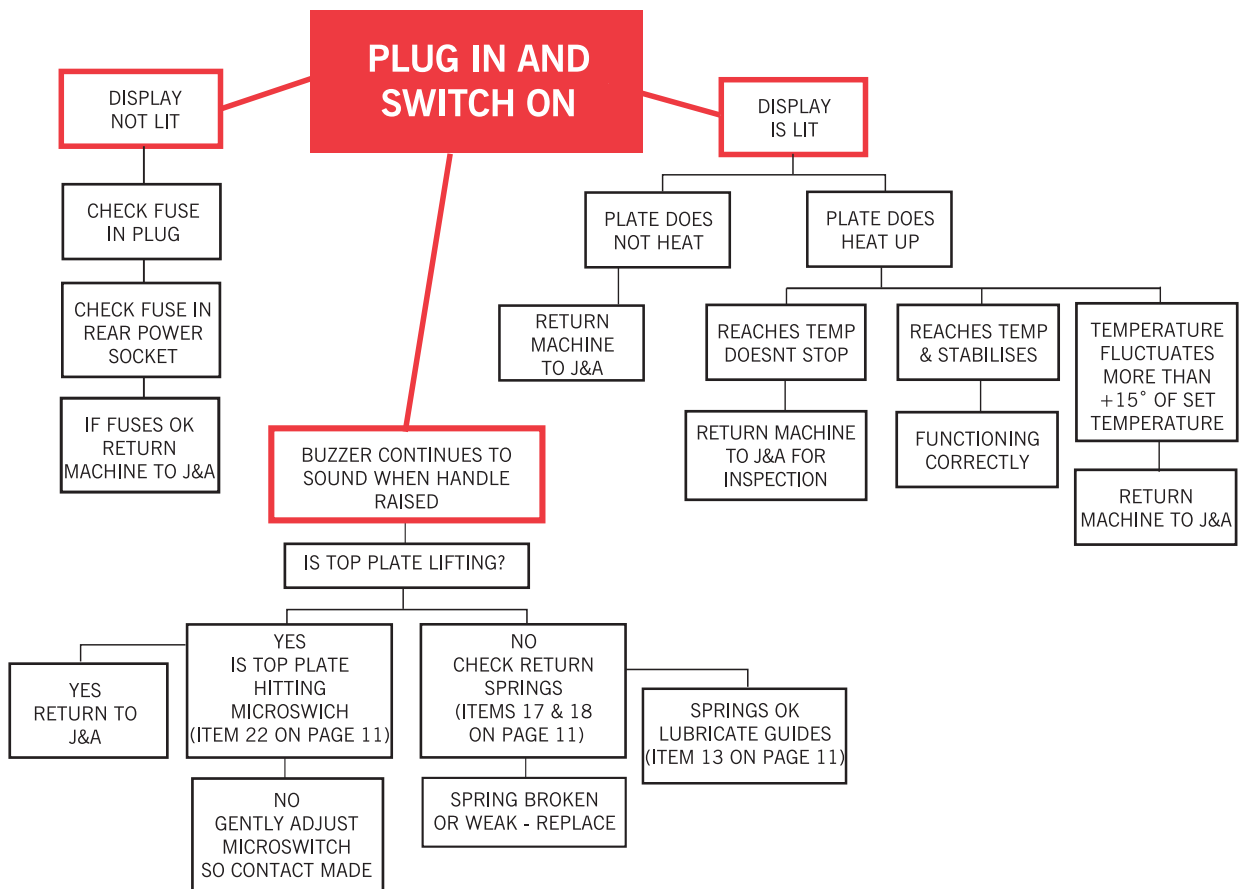
Where a machine is owned (rather than rented on the J&A Seal-Deal scheme) the J&A annual service is recommended. This full return-to-base, strip-down and return system gives your machine a complete overhaul with change of key components for a minimal fixed outlay each year.

Probably the most attractive part of the service is that if the machine needs repair during the following 12 months all parts and labour are free of charge regardless of whether or not the faulty components were changed at the annual service. (Excludes structural damage to machine chassis and other non wear and tear breakages). This means no unexpected repair bills during the year.

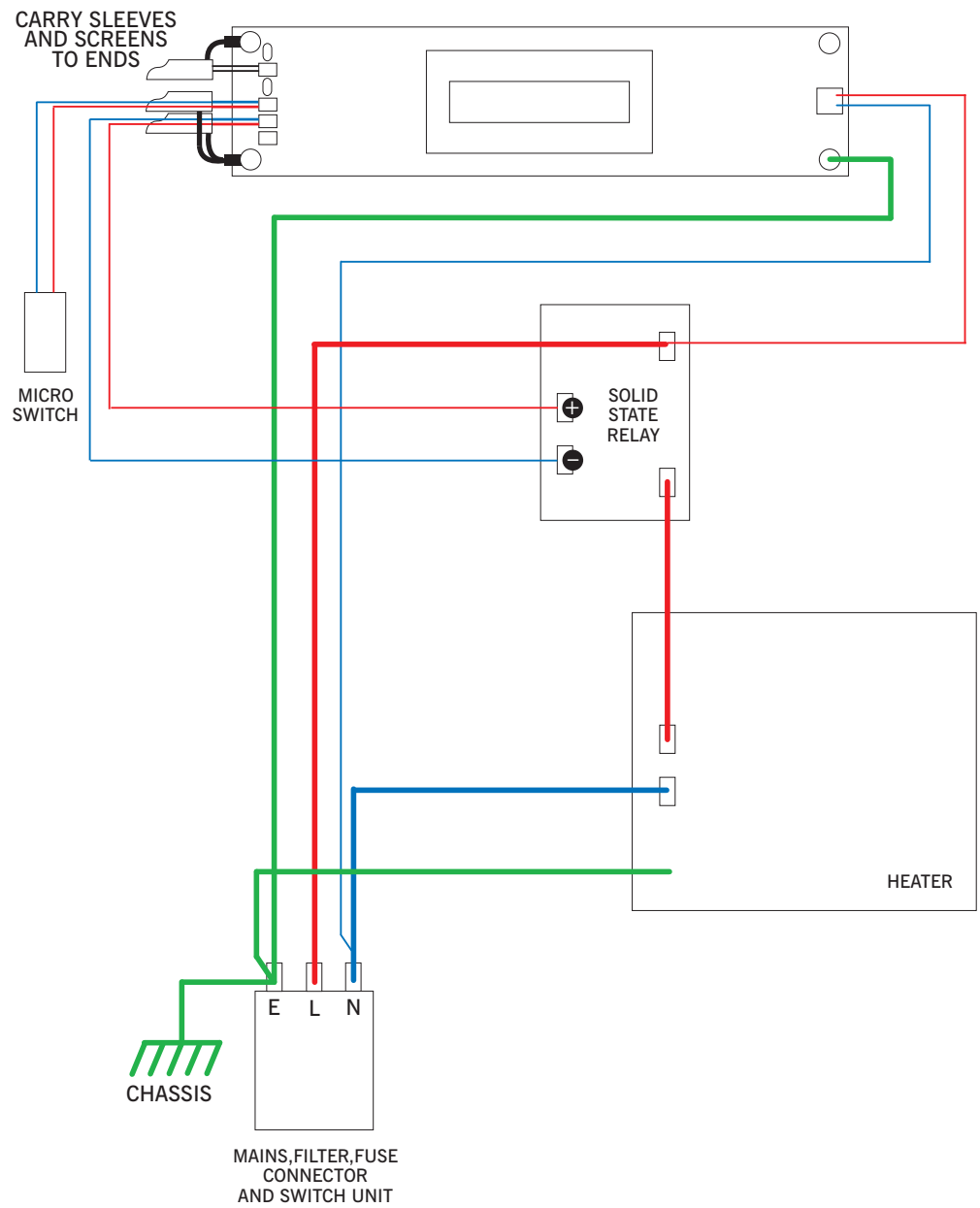
If needed, whilst your 3030 is being repaired or serviced, J&A will lend you a replacement machine free of charge (except carriage) to keep you working.

TROUBLESHOOTING FLOW CHART

NB - Seal Deal customers - please simply return the machine to J&A (Keep in mind repairs to non wear and tear damage is chargeable under the Seal Deal agreement).

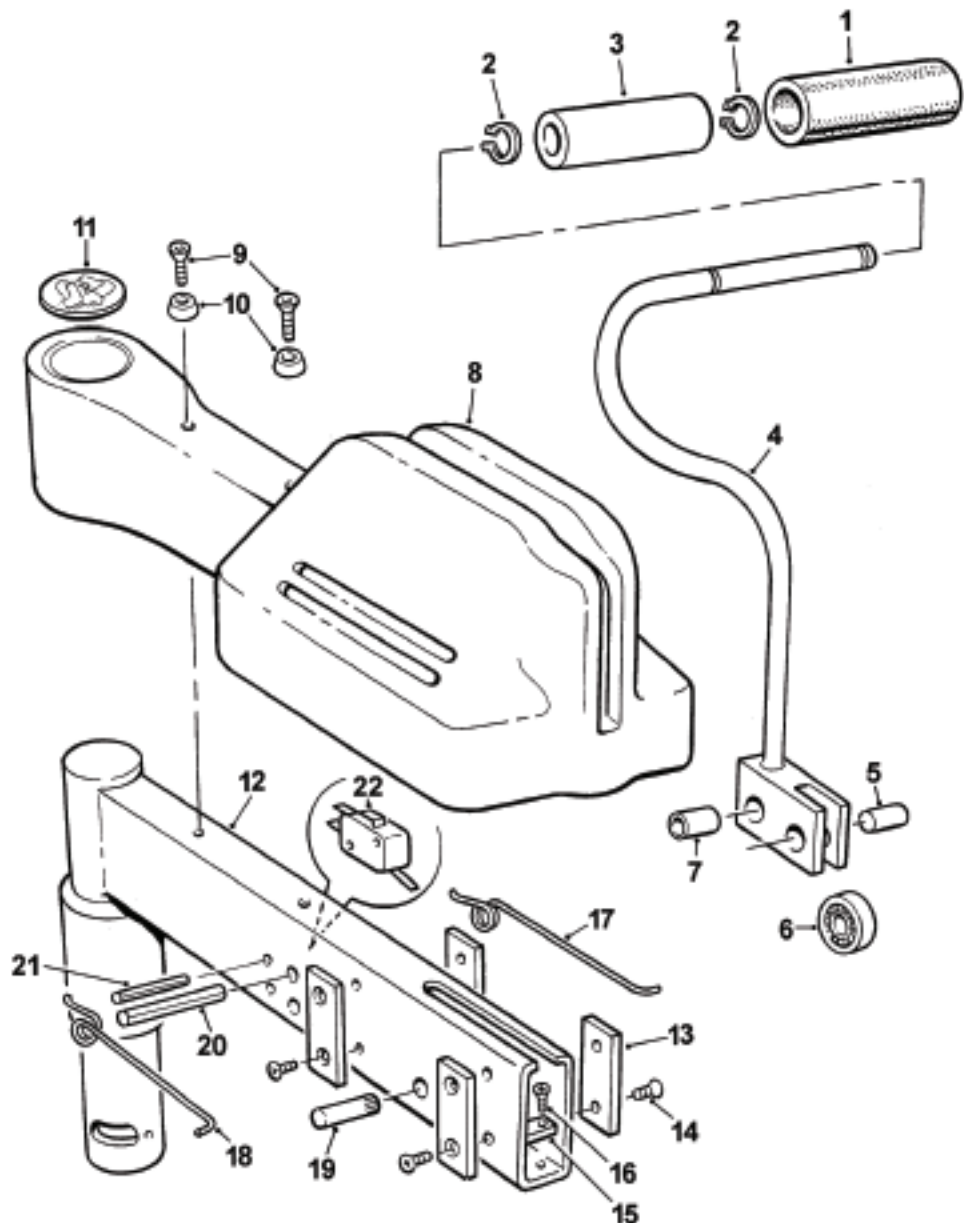


WIRING DIAGRAM



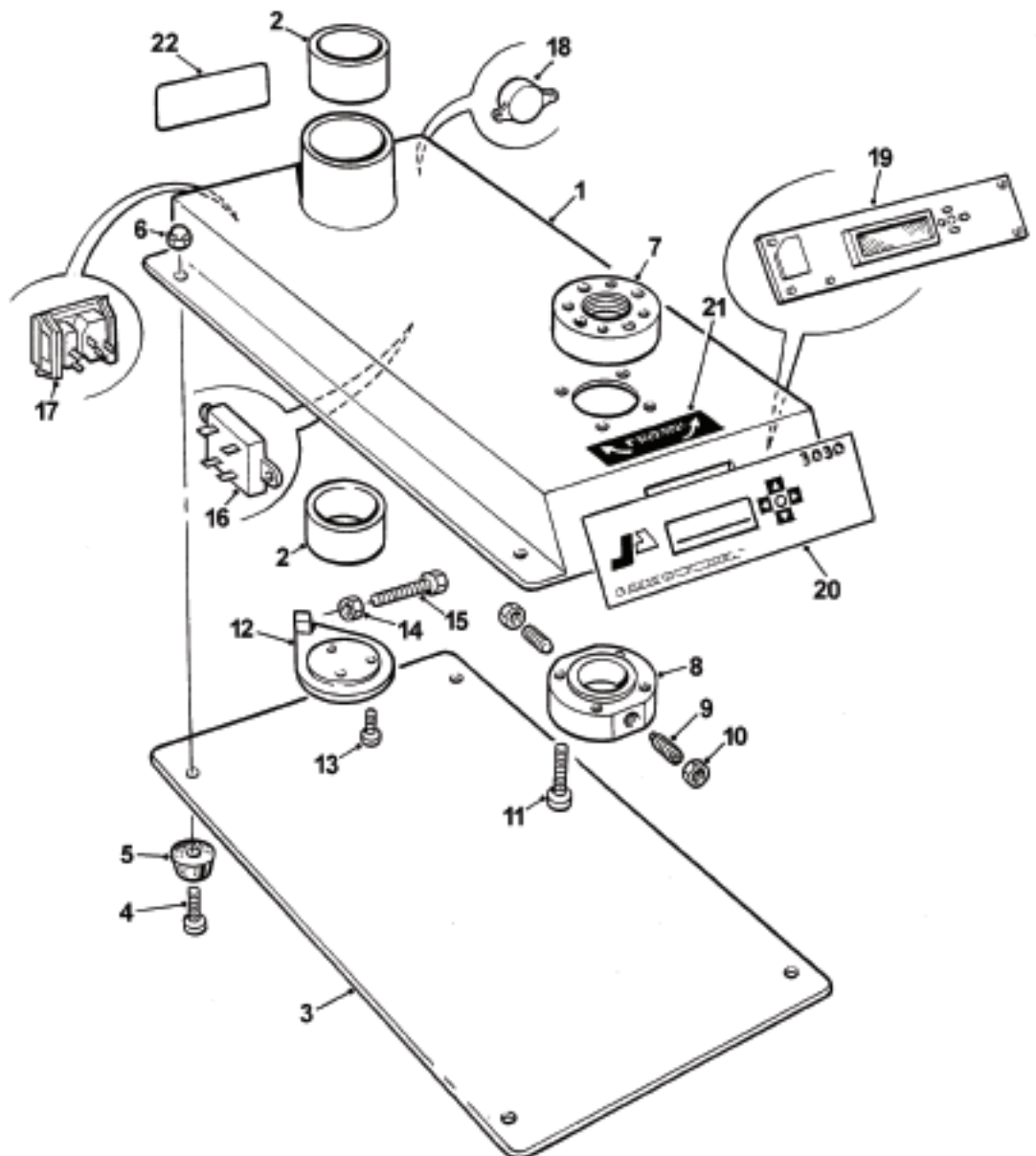
ARM ASSEMBLY

- | | | | |
|----|---------------------|----|--------------------------|
| 1 | Sleeve, rubber | 12 | Arm |
| 2 | Circlip | 13 | Guide |
| 3 | Handle | 14 | Screw, Counter sink/sunk |
| 4 | Lever | 15 | Arm Stop |
| 5 | Pin, roller bearing | 16 | Counter sink/sunk |
| 6 | Roller bearing | 17 | Spring RH } 127010 Pair |
| 7 | Bush | 18 | Spring LH |
| 8 | Cover Type A | 19 | Pin, lever pivot |
| 9 | Sleeve, rubber | 20 | Pin, roll |
| 10 | Nylon Washer | 21 | Pin, roll |
| 11 | Badge | 22 | Micro switch |



BASE ASSEMBLY

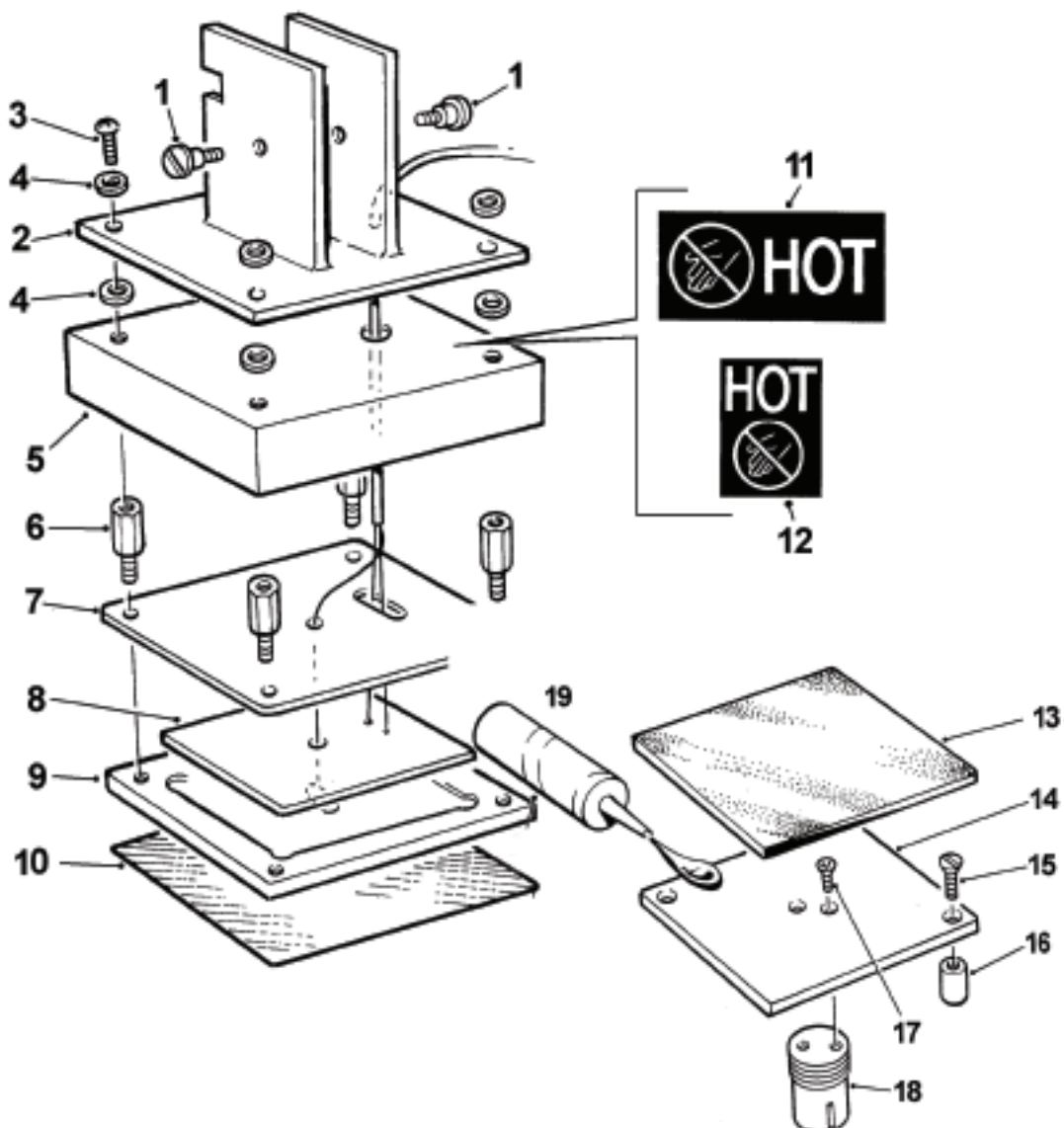
- | | | | |
|----|-------------|----|----------------------|
| 1 | Base | 12 | Retainer, arm |
| 2 | Bush | 13 | Screw |
| 3 | Cover, base | 14 | Nut Locking |
| 4 | Screw | 15 | Screw adjusting |
| 5 | Pad, rubber | 16 | Relay |
| 6 | Nut, domed | 17 | Switch/plug |
| 7 | Adjuster | 18 | Buzzer |
| 8 | Collar | 19 | Control Panel |
| 9 | Spring Bolt | 20 | Decal, control panel |
| 10 | Nut, half | 21 | Decal, pressure |
| 11 | Screw, cap | 22 | Decal, serial plate |



PLATENS (STANDARD)

- | | | | |
|-------|----------------------|----------------------|---------------------------|
| 1 | Bearings, Shoulder | 11 | Decal, 'hot' Large |
| 2 | Mount, Heated Platen | 12 | Decal, 'hot' Small |
| 3 | Screw, Round | 13 | Pad Rubber |
| 4 | Washer, Plain | ORDER NUMBERS | |
| 5 | Shield, Heat | 6x6 | 127007 |
| 6 | Spacer | 10x10 | 127008 |
| 7 | Cover, Element | 12x8 | 127009 |
| 8 | Element | 14 | Platen, Bottom |
| | ORDER NUMBERS | 15 | Screw, Counter Sink |
| 6x6 | 127011 | 16 | Knob |
| 10x10 | 127012 | 17 | Screw, counter sink |
| 12x8 | 127013 | 18 | Adjuster, Platen pressure |
| 9 | Retainer, Element | 19 | Adhesive (tube) |
| 10 | Teflon | | |
| | ORDER NUMBERS | | |
| 6x6 | 127004 | | |
| 10x10 | 127005 | | |
| 12x8 | 127006 | | |

BASE
ORDER NUMBERS - see page 12

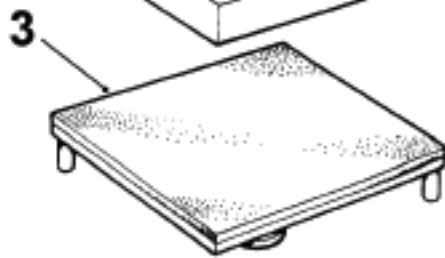
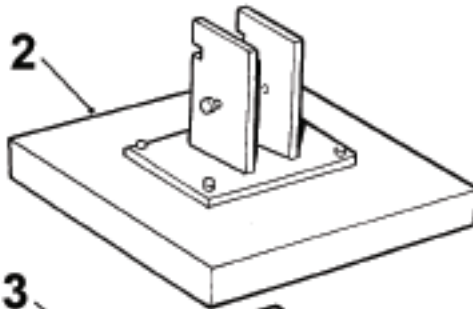
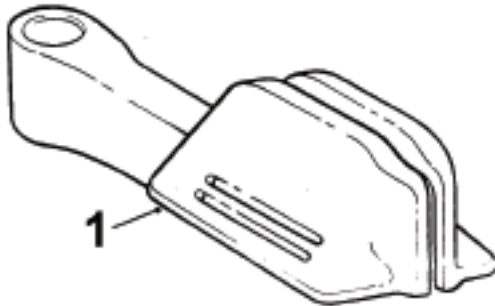


OPTIONAL PLATENS

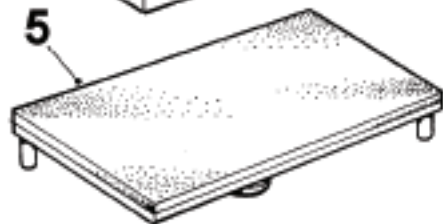
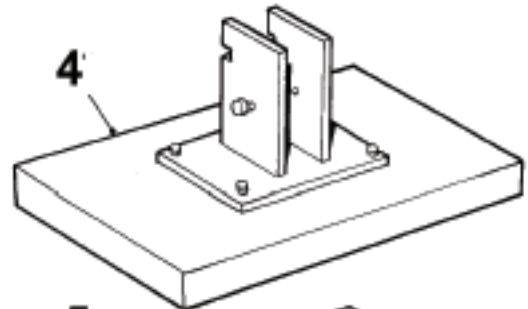
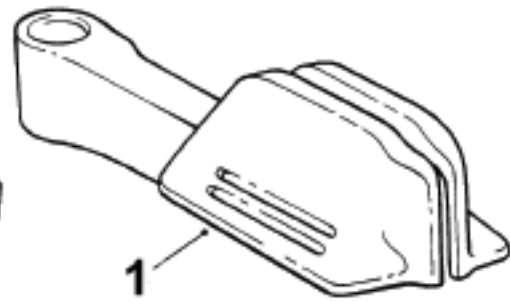
1. Cover, Type B
2. Top platen 250mm x 250mm
3. Base platen 250mm x 250mm
4. Top platen 300mm x 200mm
5. Base platen

ORDER NUMBERS - For base platens

6x6	127001
10x10	127002
12x8	127003



250mm x 250mm
10" x 10"



300mm x 200mm
12" x 8"