



# *PonyXprs™* *Manual*

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PX-646

The PonyXprs is a mobile multicolor printing/drying unit perfect for small spaces. This clever space saving design features a durable multi-color printer and a compact professional conveyor dryer.

\$20.00

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## Machine Assembly

- Step 1: Remove the machine from the crate or skid. After placing it in the desired location, lock the casters
- Step 2: Install the Print heads.
- Step 3: Install the clamps.
- Step 4: Install the platen support rails. Attach both the left and right rail with the 5/16" bolts, washers and flange nuts provided.
- Step 5: Install the platens by placing them on the leveling rails. Secure using the knobs provided.
- Step 6: Install the conveyor belt.
- ◆ Turn both the tension adjustment knobs counter clockwise to move the tail pulley inward. This allows enough slack for the belt to loop around and complete the splice.
  - ◆ Ensuring that the edges are even, connect the two ends together by interlocking the splice teeth and insert the splice wire completely through the splice.
  - ◆ Turn both tension adjustment knobs clockwise to move the tail pulley out. Adjust the pulley so that the belt is snug -- do not over tighten.
- Step 3: Connect to power. See the power requirements below.
- Step 4: Exhausting. The garments that are cured in this oven will smoke and this will remove most of the smoke from the printing area. Place a fan in a nearby window to exhaust. The exhaust fan on the machine is located on the side of the dryer opposite the control panel.

## Leveling the Printer

- Step 1: Place a machine level on one platen of the machine. Adjust the level of the platen using the bolts are in the top of the hub and secure the platen support rails when the platen is flat.
- Step 2: Place a flat screen into one of the print heads and pull it down into the registration gate of the leveled platen. Head leveling adjustments are located on the side of each clamp. Using a 7/16" wrench, loosen the bolts and flatten the screen to the platen. Tighten the bolts.
- Step 3: Level the other print heads to the original platen.

Step 4: Using the first adjusted print head, adjust the other platens so that they are parallel with the screen frame (follow Step 1).

**Note:** Remember that we are trying to make the machine parallel to itself, not level to the world. A machine level is only helpful for the first platen and should not be used on the rest of the process.

## Printer Operation

### Micro Registration

Your new PonyPrinter is equipped with a micro registration system. Easy adjustment to your screen positioning can be made as follows:

#### Front-Back-Diagonal

Loosen the two knobs located on the top of the screen head to allow the clamp to glide on the print head. The two knobs on the back of the head determine this movement. Simply loosen the top knob and turn the back knob. The guide on the print head will show the direction and increments of movement. When done, tighten the top knob, finger tight.

#### Side-to-Side

The knobs located at the back of the print head allow for side to side adjustments. Loosen one knob and tighten the other and the screen will mover toward the loosened knob. Gently tighten the knobs to each other before printing. These knobs should only need to be finger tight. The guide on the print head will show the direction and increments of movement.

**Note:** It is always a good idea to return each micro to its center position before beginning your next job.

### Off Contact Adjustment

This machine is equipped with an off contact adjustment for each print head. The knob in the top center of the print head will lift the screen off the platen. Loosen the wing nut, turn the knob so that the screen is at the desired height, then tighten the wing nut. Your screen may need leveling after adjusting the off contact. Refer to the section on screen leveling for more information.

### Tilt Adjustment

This machine is equipped with a screen tilt adjustment. The bolt on the side of the clamp hanger bracket can be loosened and the clamp will tilt to adjust flat for all off-contact settings.

### Registration System

Your PonyPrinter is equipped with a registration gate system that is warranted for one year. The machine has been adjusted

at the factory to insure perfect registration. However, in the event that it needs any future adjustment, follow these steps.

Step 1: Place the first print head in the down position and loosen the 5/16" nut for the left hand registration pin.

Step 2: Adjust the 1/4-20 adjustment bolt on the left side of the gate to move the left pin. Adjust as needed then tighten the pin nut.

## **Printer Maintenance**

The durable construction of your PonyPrinter makes this machine low maintenance. There are a few items that should be checked occasionally.

First, the cleaner the machine, the longer its life. As with any machinery, if the parts are kept clean of lint and spray adhesive they will work freer and have less of a chance of binding.

Second, the platens that come standard on the machine are made of a melamine coated press board. These will warp if too much heat is applied. Replacement wooden tops are available through BMG.

Normal wear and tear on the machine will include knob replacement and lifter replacement.

## **Dryer Adjustments**

### **Belt Tension**

Apply enough tension to keep the belt from slipping on the pulley. Excessive tension is unnecessary and may shorten the useful life of the belt and the belt motor.

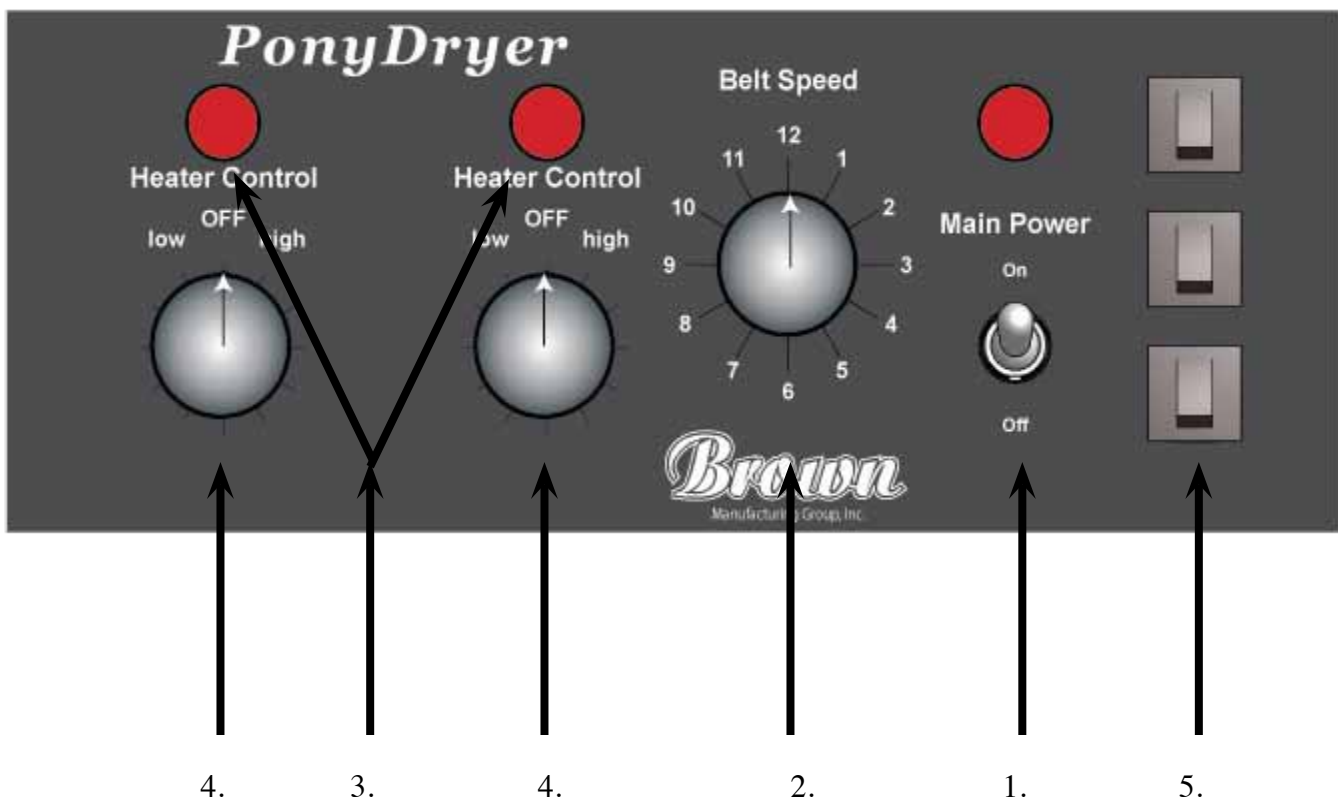
### **Belt Tracking**




Run the belt on high speed with the heat off to determine whether the belt is tracking correctly. The knobs in the end of the pulley take-up plates are used to adjust the belt tension.

Belt tracking is adjusted with the knobs on the end of the conveyor frame. Increasing the belt tension on one side will cause the belt to track toward the opposite side of the dryer frame. Decreasing the belt tension on one side will cause the belt to track toward that side. Additional adjustment may be required when the oven reaches full temperature or as the belt stretches with wear.

## Control Panel Layout

- 1: Main Power.
- 2: Belt Speed Control. Adjusts the speed of the belt throughout the chamber.
- 3: Pilot Light. When a heater is on, the light will be on.
- 4: Heater Control(s). Singular control on the PD-2004 and two on the PD-2006 and PD-2407. On the PD-2006 and PD-2407, the right hand switch controls the front heater.
- 5: Breaker switches.



Model	PD-2004	PD-2006/120	PD-2006/240
Power Requirements	120VAC, 15A	120VAC, 15A/30A	240VAC, 30A
Wattage	1620	3240	7200
Number of Elements	1	2	2
Plug Type	1 Required	2 Required	Pigtail
		 	

## Dryer Operation

### Start Up

- Step 1: Turn the “Main Power” switch to “on”.
- Step 2: Adjust the belt speed dial so that the garment will be in the chamber for 60 seconds.
- Step 3: Turn on the heater(s). We recommend that you run the heaters on high for most jobs.
- Step 4: Adjust the height of the heater rack using the handles on the ends of the tunnel so that the heaters are about 3 inches away from the garment.
- Step 5: Turn the “Forced Air” switch to “on” if required.
- Step 6: Always check your cure with a stretch or crack test and check the temperature of the garment using heat tapes.

### Shut Down

- Step 1: Turn the heater(s) off and allow the dryer to cool for about 10 minutes.
- Step 2: Turn the “main power” to “off”.

## Dryer Maintenance

The Pony dryer requires very little maintenance. By following these few steps your dryer will provide you with years of satisfactory service.

### Preventative Maintenance

- All conveyor belts stretch so periodically check the tension of the conveyor belt and adjust as needed.
- Check the lint accumulation on the belt drive chain periodically. If it is heavy, remove the lint with a stiff brush **after turning off power to the dryer.**

## Disclaimer

You can count on this dryer’s reliability for stable, consistent results. But, adverse conditions may cause problems even though the control panel shows no change from the ordinary. Determination of successful dryer performance is the responsibility of the user. Please implement regular checks on product quality and completion of ink cure during production. Brown Manufacturing (BMG) is not responsible for lost production or improperly cured goods due to equipment malfunctions.

## Customer Liability

Brown Manufacturing Group, Inc. will not assume liability or responsibility for injury to persons installing or performing repairs on products manufactured by Brown Manufacturing Group, Inc.

Special precautions must be taken when servicing the electrical apparatus of this equipment. If suspected electrical problems occur, a qualified electrician/electronics technician should take the following steps.

- Step 1: Disconnect and lock-out all electrical power to the unit before opening the electrical enclosures.
- Step 2: Use a multi-meter with an Rx1 scale of resistance, at least 240VAC and 150VDC capacity.
- Step 3: Reapply electrical power to the equipment for test purposed only after inspecting the opened enclosure for obvious malfunctions.
- Step 4: If needed, contact BMG for telephone assistance. BMG does not accept responsibility for incorrect service procedures.

## Machine Warranty

Brown Manufacturing Group, Inc. warrants its products to the original purchaser to be free from defective materials and workmanship for the following periods of time:

- General Parts are covered for 1 year.
- Heaters are covered for 3 years.

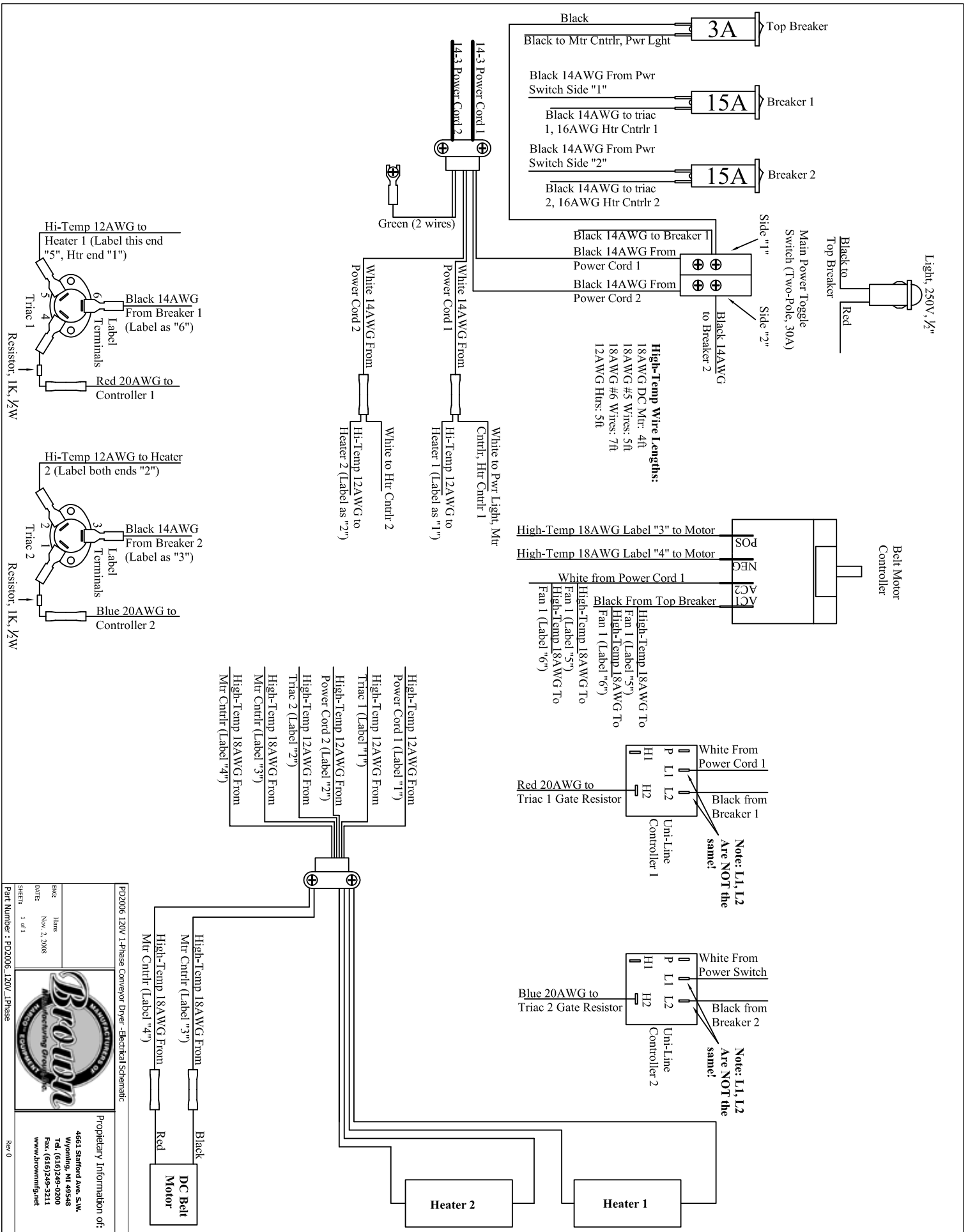
This warranty does not apply to any appearance items nor to any product whose exterior has been damaged or defaced; nor to any product subject to misuse, abnormal service or handling; nor to any product altered or repaired without written approval from authorized Brown personnel.

This warranty entitles the original purchaser to have the warranted parts rendered at no cost during the period of time stated above, except for any freight costs.

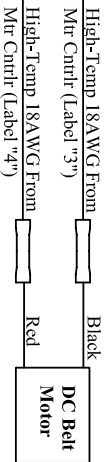
In no event shall Brown Manufacturing Group, Inc. be liable for consequential economic damage or consequential damage to property.

## Trouble Shooting Guide

Trouble	Cause	Remedies
Conveyor Belt Stalled	<ol style="list-style-type: none"> <li>1. Improper power connection.</li> <li>2. Loose drive chain/sprocket.</li> <li>3. Motor controller defective.</li> <li>4. Drive Motor defective.</li> </ol>	<p>Check power connections and fuses.</p> <p>Adjust or reconnect.</p> <p>Replace.</p> <p>Replace.</p>
Exhaust or Forced air Not working fan.	<ol style="list-style-type: none"> <li>1. Improper power connection.</li> <li>2. Defective</li> </ol>	<p>Check power connections.</p> <p>Replace.</p>
Low heat or no heat	<ol style="list-style-type: none"> <li>1. Improper power connection.</li> <li>2. Voltage drop to the dryer.</li> <li>3. Temperature selector switch defective.</li> <li>4. One (or both) heater panels not functioning.</li> </ol>	<p>Check power connections.</p> <p>If this is caused by a high load in your area, a boost transformer may be required. If the problem is localized to your plant wiring, it may be relieved by increasing the supply wire size.</p> <p>Replace.</p> <p>Replace.</p>



PPD2006 120V 1-Phase Conveyor Dryer - Electrical Schematic



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