

UNINET® DTF™
VERTICAL
SHAKER
AUTO POWDERING SYSTEM

SLIMSHAKER User Manual



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1.1 Safety Information

Your DTF product has been carefully designed to give you years of safe, reliable performance. As with all electrical equipment, there are a few basic precautions you should take to avoid hurting yourself or damaging the product.

Warning - Here are some of the things to look for:

- Save all provided documentation for future reference. Ensure all warning and instruction labels on the product are read, understood and followed in order to prevent any risk of injury.
- This product may be heavy. Please check the weight of the product and take all necessary precautions to prevent the risk of personal injury. Place your product on a firm, solid surface. If placed on something unsteady, it may fall and be damaged.
- If the product is installed on a cabinet or high capacity feeder, ensure wheel locks are applied once placed in final position for use, to prevent risk of movement or injury.
- Protect your product from overheating. Make sure no obstructions block the openings of the product. Do not put the product on or near a heat source (such as a radiator or heat register). Keep the product out of direct sunlight. Allow enough room around the product for adequate ventilation and easy access to the media paths. If the product is placed in any kind of enclosure, make sure the enclosure is well ventilated to prevent a fire.
- When the product cover is open, do not touch the heat lamps or heat trays as you may receive burns. Allow it to cool before touching.
- If the product casing gets extremely hot or smoke, unusual smells or abnormal noises are emitted from the product, there is a risk of fire. Unplug the mains connector and contact DTG PRO service.
- Do not use the product near water. Do not spill liquid of any kind on it. Do not connect or disconnect the power plug with a wet hand as this may cause electric shock. Unplug the product before you clean it. Use only a damp cloth; do not use liquid or aerosol cleaners. Do not use an extremely flammable spray near the product as the product contains high temperature parts that may cause a fire.
- Be certain that your power source matches the rating listed on the back of the product. If you are not sure, check with your dealer or local power company before connecting the product.
- Do not connect this product to an uninterruptible power supply (UPS).
- Your product has a grounded, three-prong plug as a safety feature. This plug only fits into a grounded outlet. If the plug does not fit, the outlet may be an older, non-grounded type. Contact an electrician to have the outlet replaced. Do not use an adapter to defeat the grounding.
- Install the product near an easily accessible power outlet and avoid damaging the power cord. Do not put anything on it or place it where it will be walked on. If the cord becomes damaged or frayed, replace it immediately.
- If you are using an extension cord or power bar with the product, make sure the total amperes required by all the equipment on the extension is less than the extension's rating. The total ratings of all equipment plugged into the outlet should not exceed 30A amperes.
- Do not poke anything in the ventilation slots of the product. You could get an electrical shock or cause hazardous electrical arcing, which could cause a fire.
- Ensure loose clothing and hair is kept clear of moving parts when the product is in operation to prevent possible risk of injury.
- Ensure both the product and mains power switches are in the OFF position before connecting the AC power cable.
- Always hold the power plug to connect/disconnect the power cable to/from the mains socket. Unplugging by pulling on the cable can cause fraying and may lead to fire or electric shock.
- Do not make any adjustments other than those outlined in the documentation. You may cause damage that will require extensive repair work. If anything happens that indicating your product is not working properly or has been damaged, unplug it immediately and DTG Pro tech support.

1.2 System Specifications

DTF PRO SLIMSHAKER: System Specifications	
Output Speed	Depends on printer speed
Technology	Single Pass Oven
Media Width	Maximum: 26 inches (660 mm)
Rewinder System	Output roll maximum diameter: 11 inches (279 mm) Core inside diameter: 3.0 inches (76.2 mm) or 2.0 inches (50.8 mm)
Dimensions (H X W X D)	Shaker & Feeder: 62" x 40" x 48.5" (1,575 mm x 1,016 mm x 1,232 mm)
Weight	Shaker & Rewinder: 508 lbs (230 kg)
Operating Environment	Temperature: 15°C to 35°C (50 to 95°F) Humidity: 50 to 80% RH
Power	30A 240 AC 2 pole
Warranty	6 Months – Parts and Labor

Please ensure you follow every step in order.

If your system does not comply with this list, DO NOT continue the install!

Overview of the Installation

System Requirements

- Power
 - 30A 240v 2 pole Outlet (x1)
Outlet type is based on customer preference
 - 30A 240v 2 pole Plug (x1)
Plug type must match outlet type
 - 30A 240v 2 pole Circuit Breaker (x1)
 - 8 Gauge Circuit Wiring
- Ventilated area
 - Should be installed in well ventilated area

Attention: Highly recommended to have a professional electrician install the above mentioned requirements, if they are not pre-existing in your building.

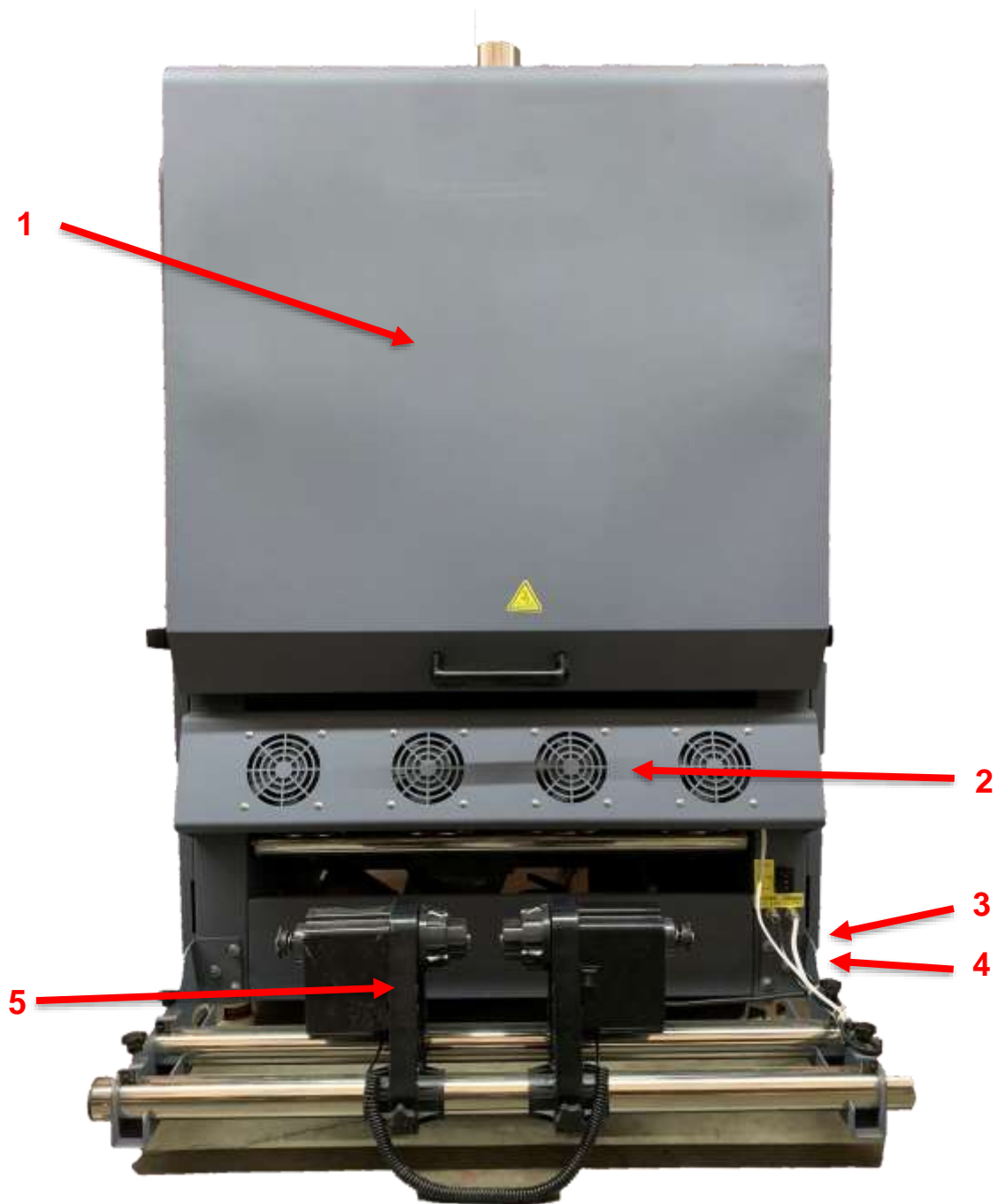
NOTE: Your product requires a grounded, three-prong plug as a safety feature. This plug only fits into a grounded outlet. If the plug does not fit, the outlet may be an older, non-grounded type. Contact an electrician to have the outlet replaced. Do not use an adapter to defeat the grounding.

1.3 SLIMSHAKER Front View



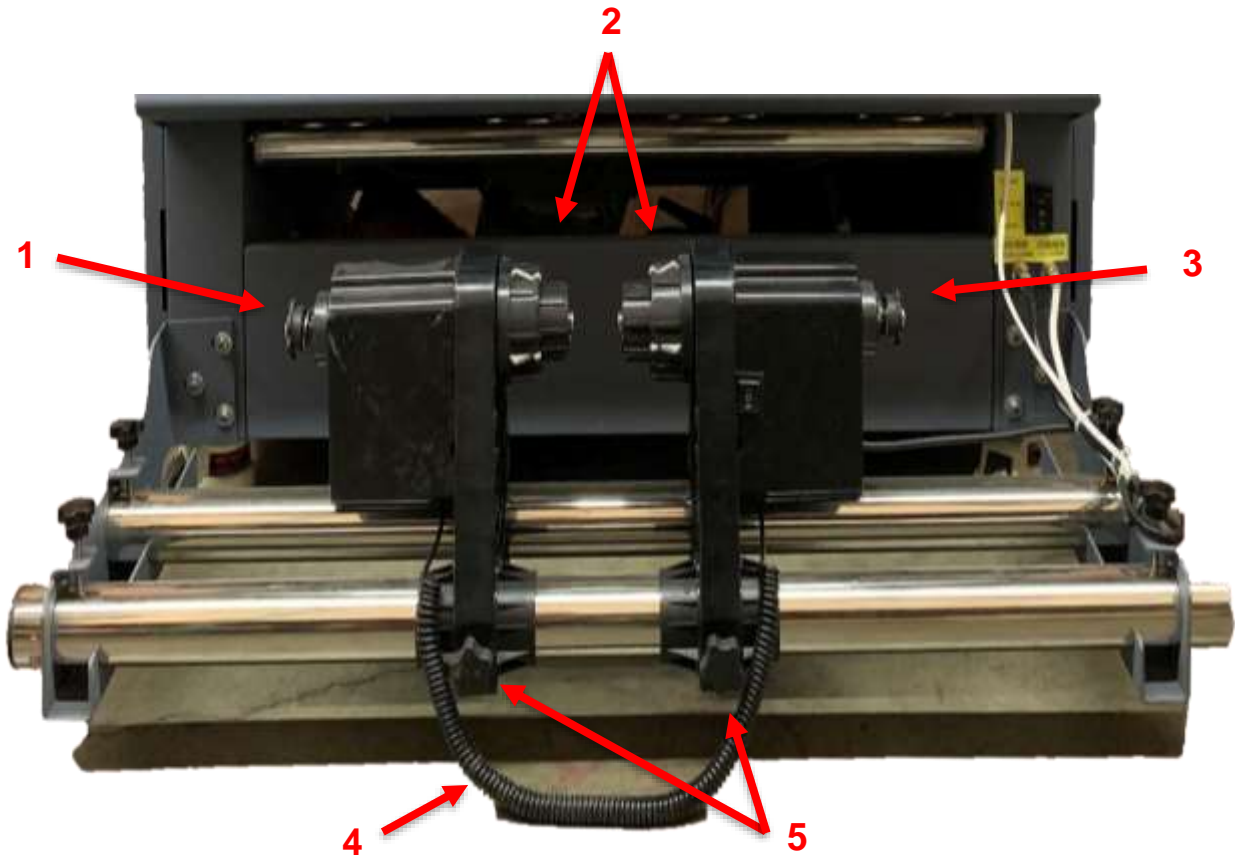
1. Air Vent
2. Belt Window
3. Emergency Shut Off
4. On/Off Switch
5. Powder Window
6. Heated Guide Plate
7. Circuit Breaker
8. Power Entry Connector

1.4 SLIMSHAKER Rear View



1. Heat Lamp Top Cover
2. Cooling Fans
3. Feeder Network Connection
4. Take Up Rewinder Connections
5. Take Up rewriter

1.5 SLIMSHAKER Rear Rewinder View



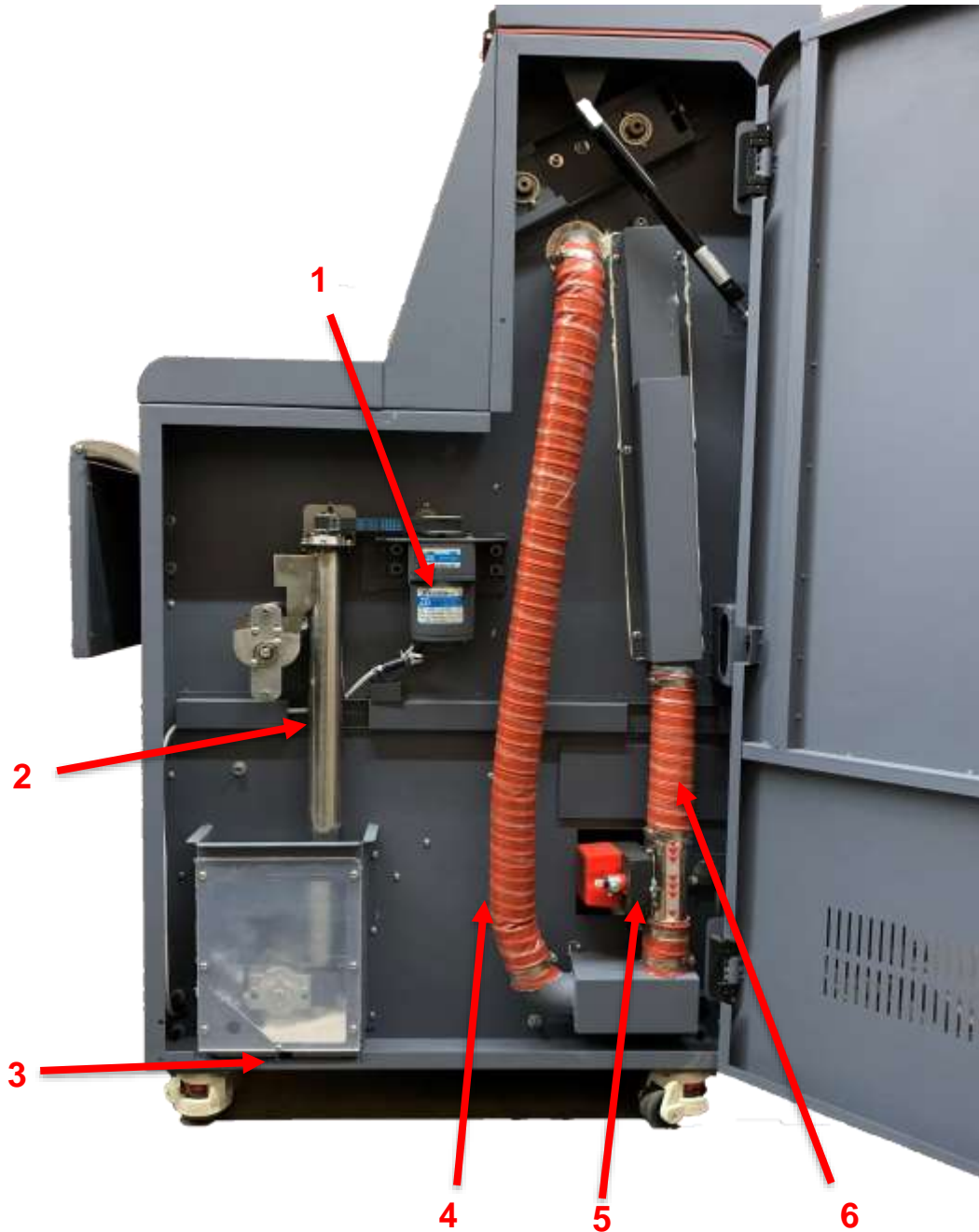
1. Left End Tension Knob
2. Core Holders
3. Right End Tension Knob
4. Left Power Cable
5. Width Adjustment knob

1.6 SLIMSHAKER Left View (door open)



1. Heating Lamps Relay Box
2. Main Control Panel
3. Power Supply
4. Main Control Access Panel
5. Conveyor & Take Up Relay Box

1.7 SLIMSHAKER Right View (door open)



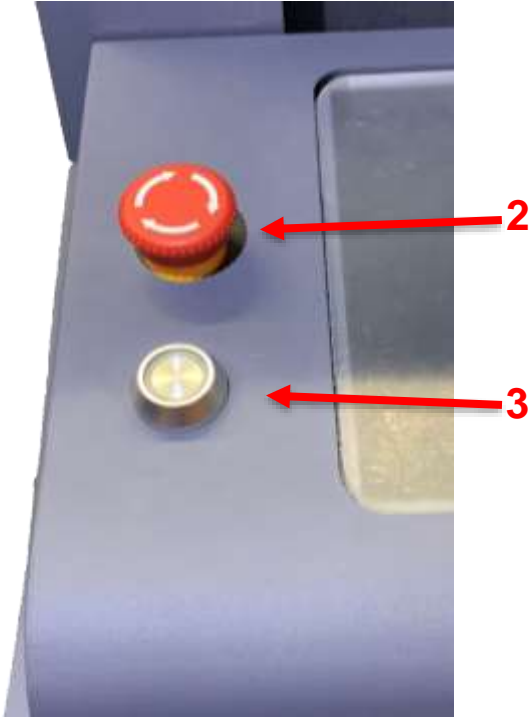
1. Powder Circulating Motor
2. Powder Circulating Auger
3. Powder Catch Can
4. Top Suction Tube
5. Electromagnetic Shut Off Valve
6. Rear Suction Tube

1.8 SLIMSHAKER Operator Panel



1	Top Dryer Control Panel	Controls the upper portion of the heating lamps.
2	Top Dryer On/Off Switch	Turns upper portion of the heating lamps ON or OFF.
3	Guide Belt Control Panel	Turns on the conveyor belt and regulates the speed.
4	Front Guide Plate Control	Regulates the temperature of the front guide.
5	Powder Feed Timing Control	Regulates the amount of TPU powder dispensed by controlling rotation time.
6	Bottom Dryer Control Panel	Controls the bottom portion of the heating lamps.
7	Bottom Dryer On/Off Switch	Turns bottom portion of the heating lamps ON or OFF.
8	Shake Powder Speed	Controls the paddle roller speed to shake off excessive powder from the print.
9	Cooling On/Off Switch	Turns cooling fans On/Off.
10	Front Guide ON/OFF Switch	Turns On/Off the heating plate in the front of the shaker.
11	Powder Feeding On/Off Switch	Turns On/Off the mixing auger to dispense powder.
12	Suction On/Off Switch	Turns On/Off the media suction motor.
13	Suction On/Off Control	Controls suction of conveyor for top and bottom ON or top only ON, for production or loading/unloading film.

2.1 Powering on Slim Shaker

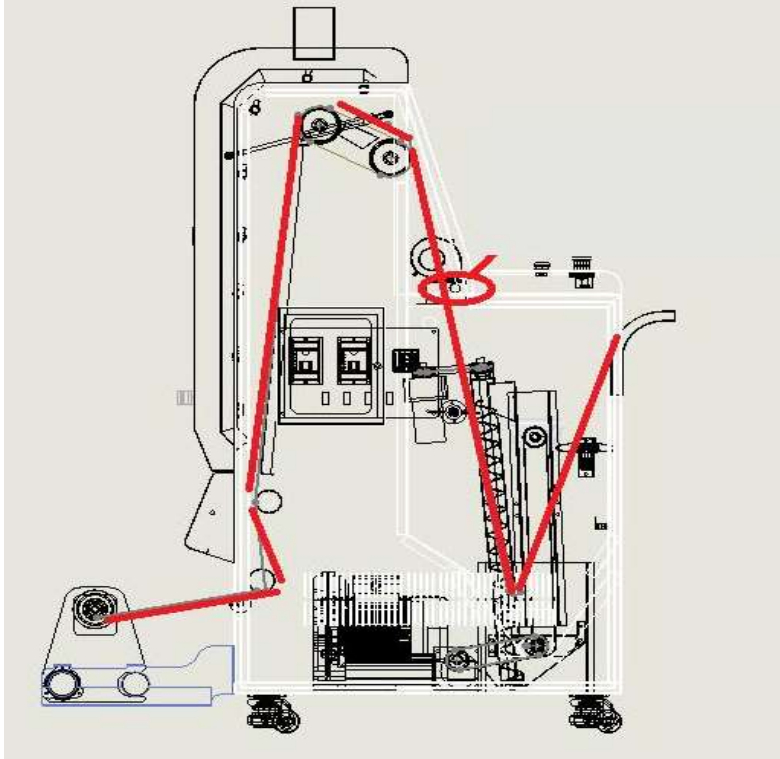


1	Main Circuit Breaker	63A 250v 2 Phase Circuit Breaker
2	Emergency Shut OFF Button	Controls the speed of the conveyor belt.
3	Main Power Switch	Turns conveyor belt ON or OFF. NOTE: Turning OFF conveyor belt does not turn OFF the take up rewinder

Once all the power requirements are met, the Slim Shaker can be turned ON

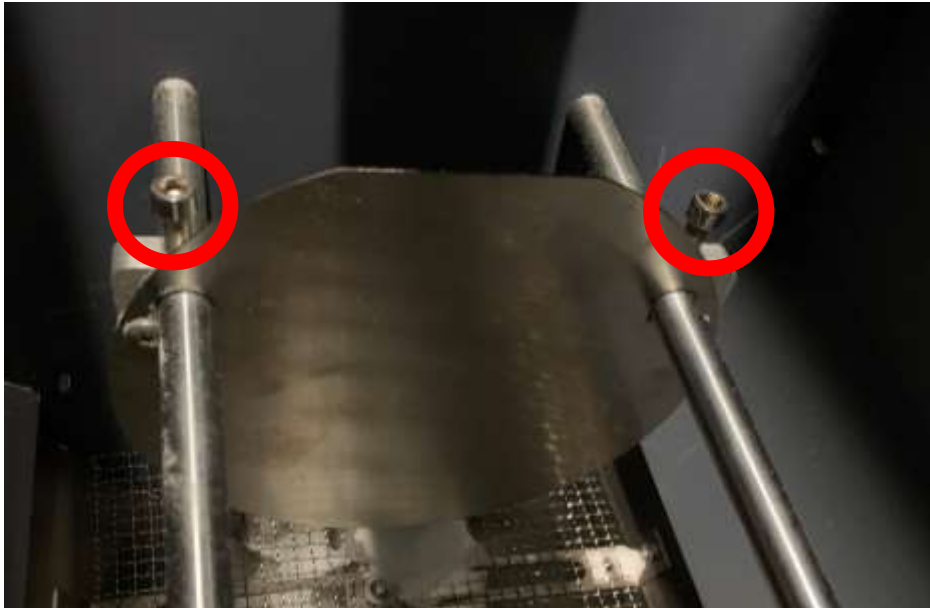
NOTE: Recommended to have all the switches on the control panel in the OFF position.

2.2 How to Set Up the Film



STEP 1 of 6

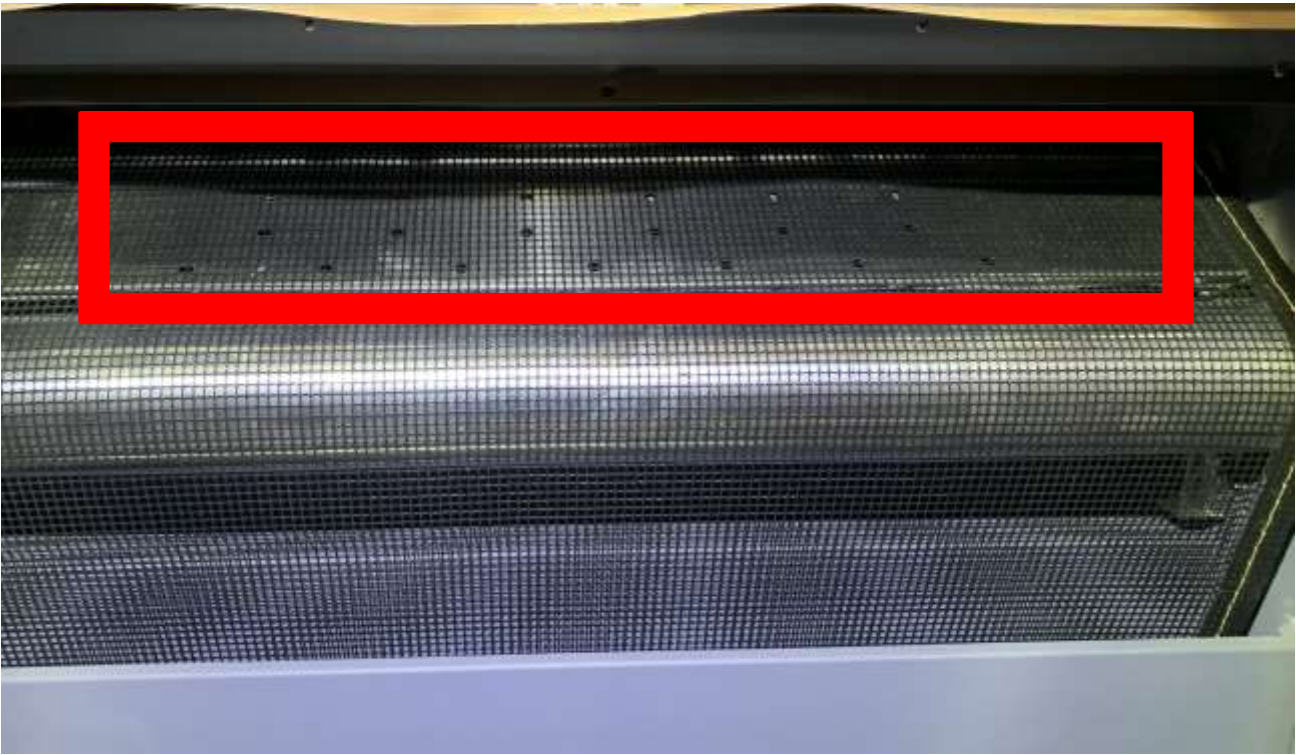
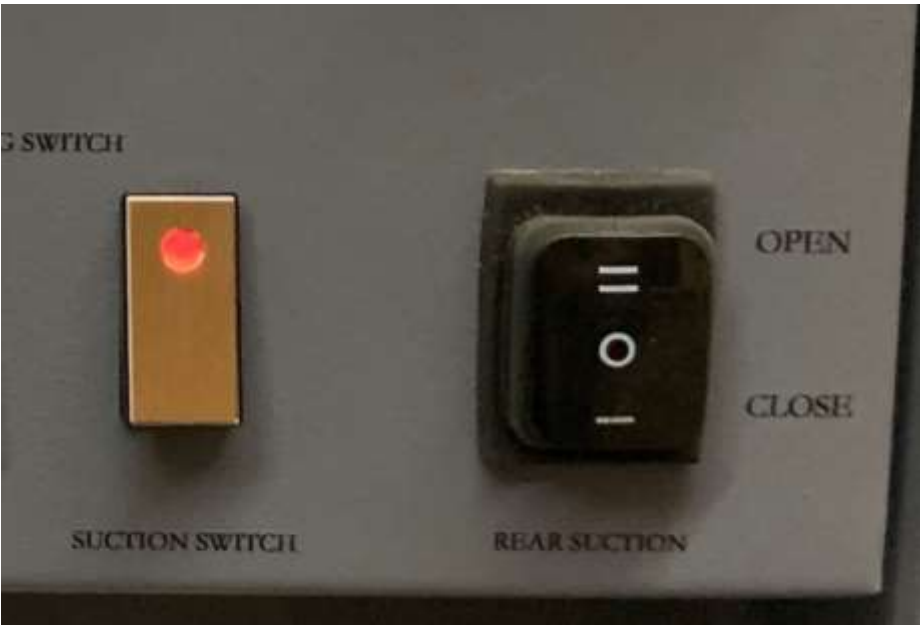
Open media valley guides to the far edge. Loosening the two hex bolts below. Move them out of the way for now, they will be adjusted once the media is fed in the Shaker.



How to Set Up the Film Continued

STEP 2 of 6

Turn on the top suction only on the conveyor belt. To do so turn ON the power switch (indicated by LED) Labeled "Suction Switch" and set the controller to "Close" on the switch labeled "Rear Suction".

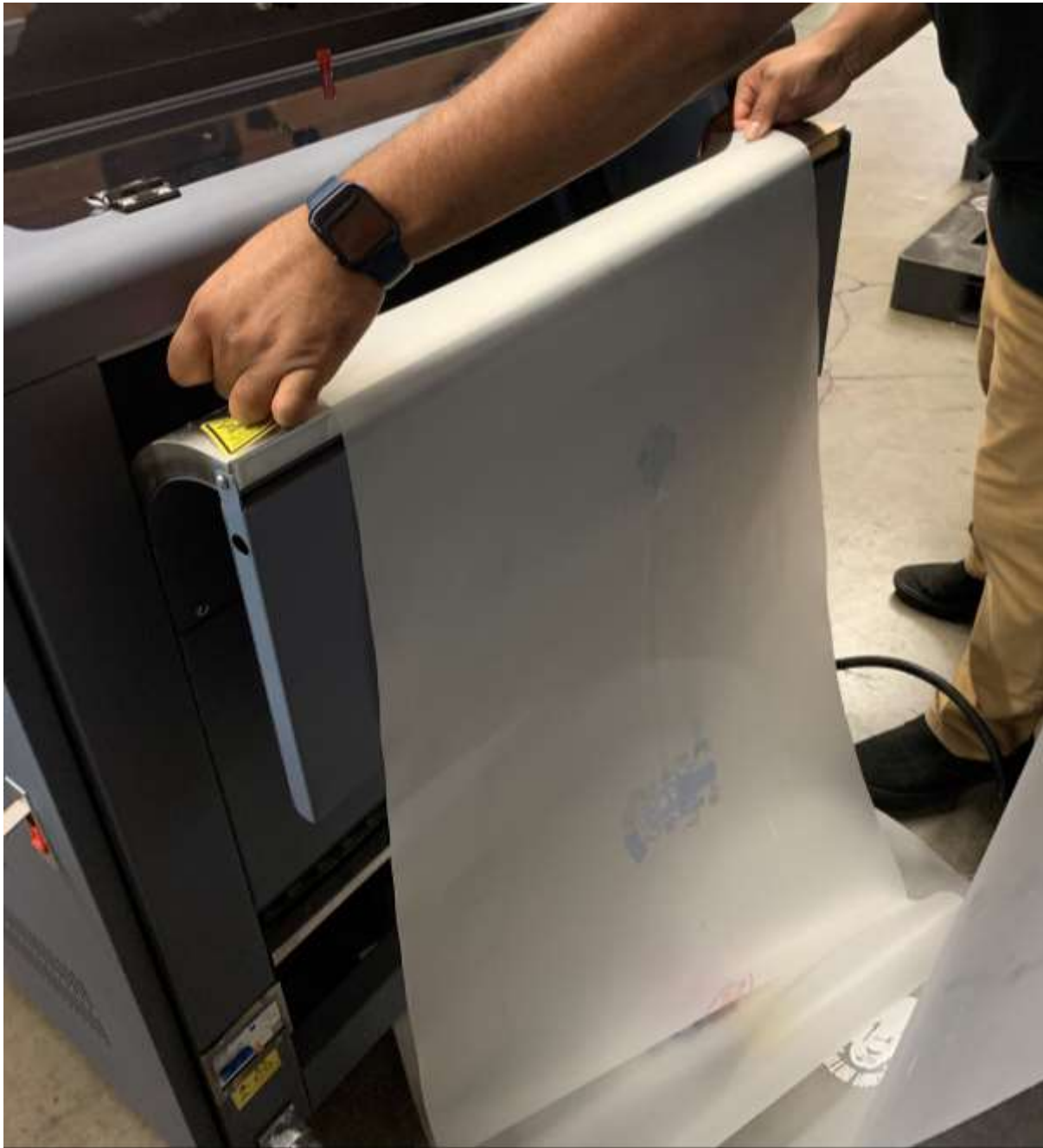


How to Set Up the Film Continued

STEP 3 of 6

Feed the slack film through the top of the front heated guide.

NOTE: It is recommended to have about 15 feet of header film (slack film) to set up the slim shaker. The additional slack will allow you to feed the media through the shaker without using or having to wait for the job film to get long enough to feed into the shaker.



How to Set Up the Film Continued

STEP 4 of 6

Feed the film between the powder feeding auger and the media valley.



STEP 5 of 6

Feed the media on top of the paddle roller.



How to Set Up the Film Continued

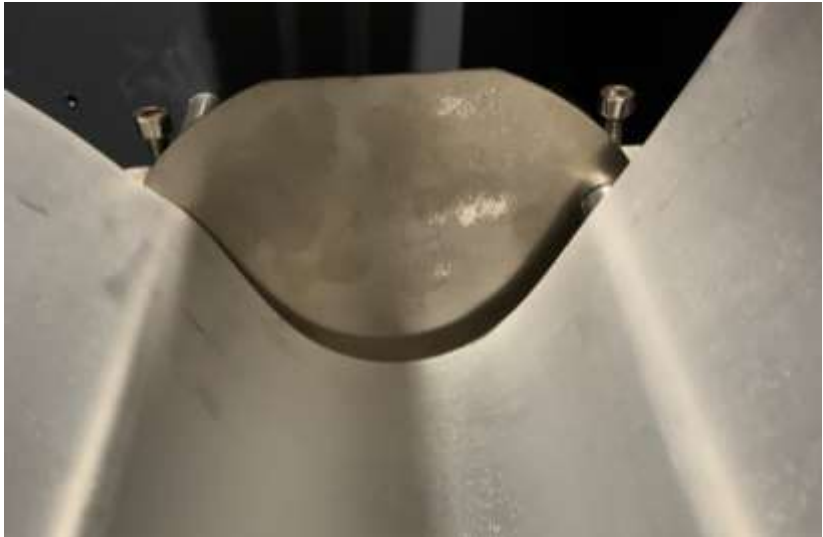
STEP 6 of 6

Lay film flat on top suction portion of conveyor belt. With the top suction turn ON, the film will lay flat on the conveyor belt.



STEP 7 of 6

Adjust the valley guides to the far edge of the film.



How to Set Up the Film Continued

STEP 7 of 6

Run the film down the rear conveyor belt.



How to Set Up the Film Continued

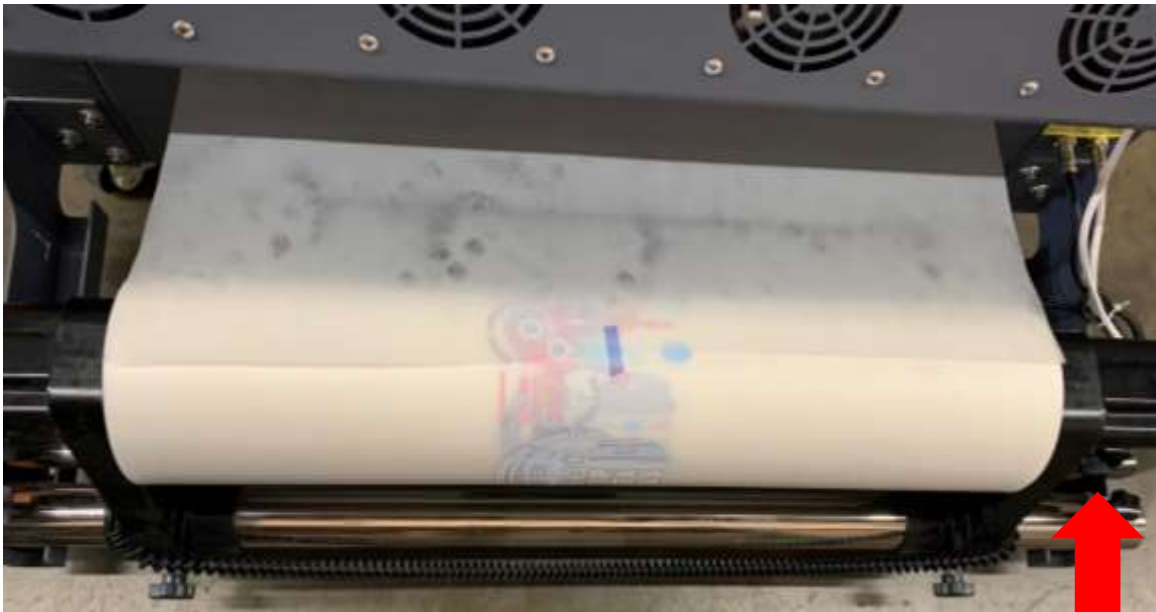
STEP 8 of 6

Feed the film behind idle roller.



STEP 9 of 6

Tape the film on to the take up rewriter.



NOTE: If film is taped to the top of the core, set rewriter to counter clockwise (=). This will rewind film with image facing out.
If preferred, tape film to bottom of core and rewriter to clockwise (-). It will rewind with image facing inward.

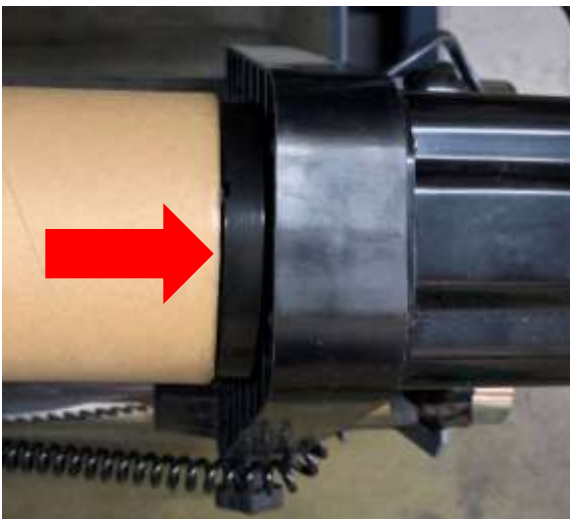


2.3 Rear Rewinder Set Up



Clean Chrome tubes of any dust or residue to allow the end guides to move freely. Loosen the two lockdown knobs on the bottom of each guide. Adjust according to the width of the film to be used. The rewinder will fit 3" cores and 2' cores. Make sure the cores are inserted completely, fitting flush with the guide. Once the core is fitted correctly center the rewinder and tighten the lockdown knobs.

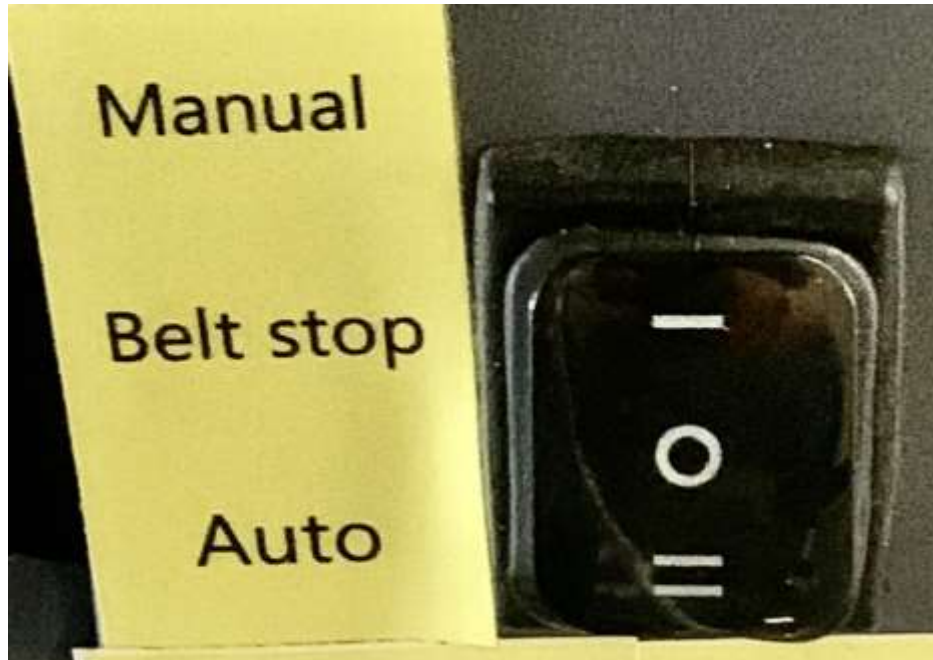
NOTE: Further adjustments may be needed, after the media is loaded.



Rear Rewinder Set Up Continued

The take up rewinder is controlled by the button switch on the bottom right of the shaker.

The switch has three settings



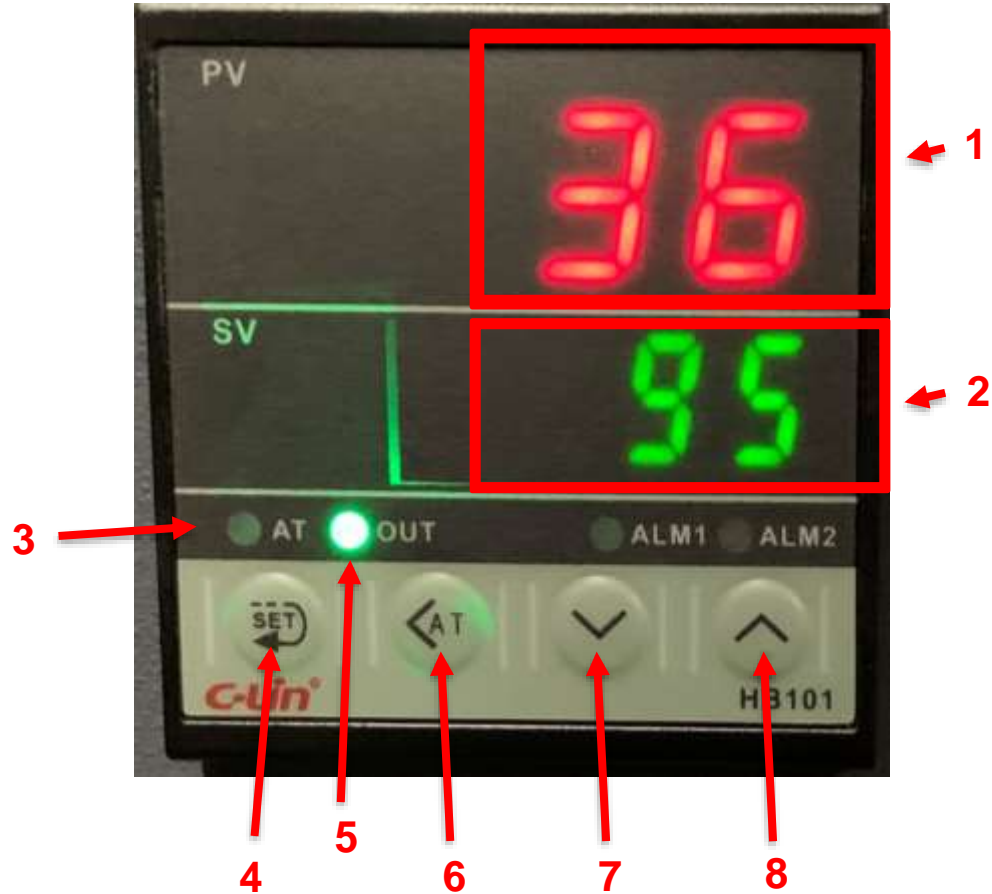
Manual (-) will set the rewinder to manual mode. It will continuously rewind without stopping.

Belt Stop (o) will turn OFF the rewinder.

Auto (=) will set the rewinder automatic mode. It will rewind parallel to the conveyor belt. When the conveyor belt stops the rewinder will also stop.

After the Media has been set, leave the switch to Auto (=) to rewind with the belt.

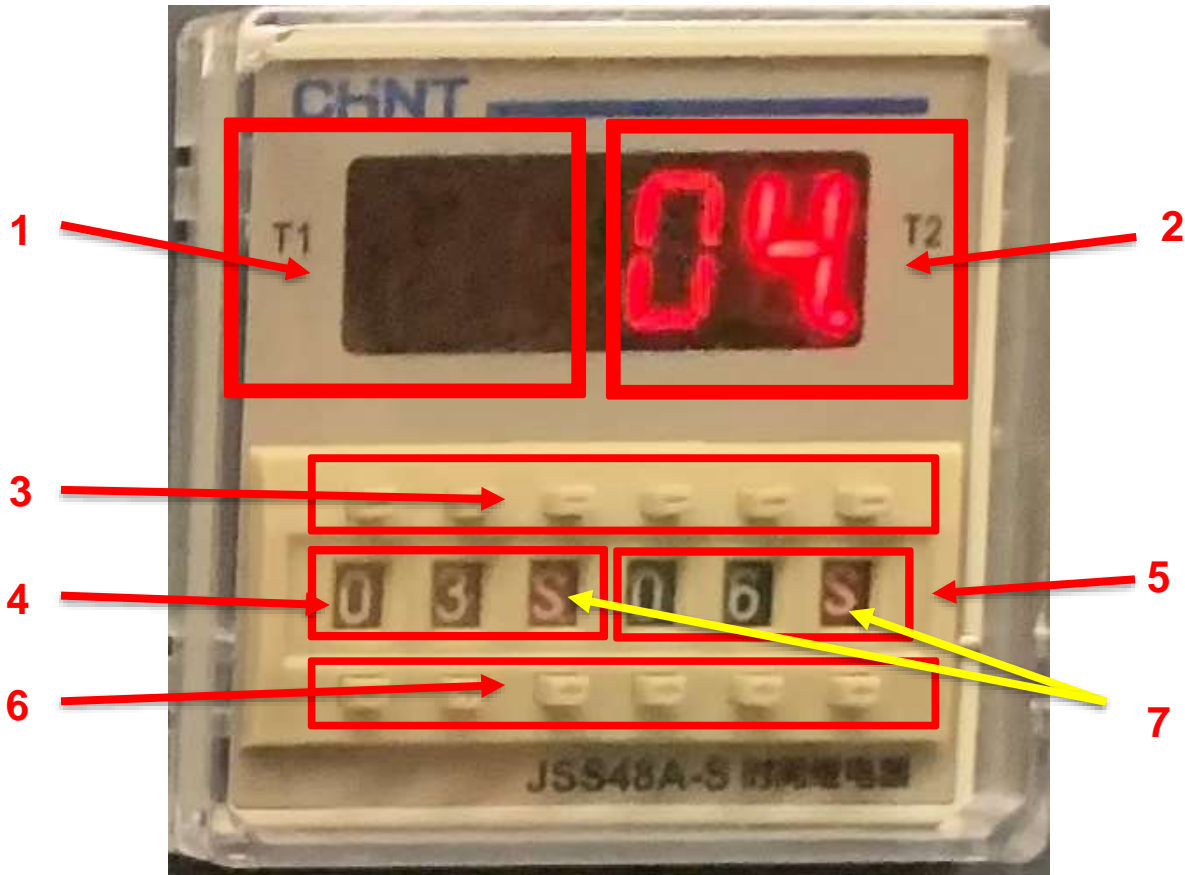
2.4 Heating Lamps Adjustment



1	Heat lamp Current Temperature	Displays the current temperature of the curing lamps.
2	Heat Lamp Set Temperature	Displays the temperature of the curing lamps set by the user.
3	AT Indicator	Self-adjusting Lamp, lights when self-adjusting is working
4	SET Button	Press the SET button to change and set the heating lamp temperature.
5	OUT indicator	Indicates when power is being fed to the heating lamps
6	AT Button	Used to select digit position to change to raise or lower the degrees
7	Down Arrow Button	Used when setting the degrees in SET option
8	Up Arrow button	Used when setting the degrees in SET option

To set desired temperature, press the SET button. Green display will begin to blink one digit at a time. The blinking digit can be adjusted using the UP and Down arrows. Using the AT button will allow you to switch from the ones, tens and hundreds place.

2.5 Powder Feeding Adjustment



1	T1 Display (Timer 1)	Displays the current temperature of the curing lamps.
2	T2 Display	Displays the temperature of the curing lamps set by the user.
3	Down Buttons	Used when setting the time on the counter
4	Feeding Powder Delay Display	Displays the delay of time set for pause feeding powder
5	Feeding Auger Rotation Display	Displays the time set for feeding powder
6	Up Buttons	Used when setting the time on the counter
7	Time Indicator	Displays the unit of time on the counter

To set the desired time, turn ON the powder feeding switch. The counter will light up and Auger will begin to run based on the current times set. If you wish to change them, use the up or down buttons above or below the digit you want to change. Once you reach the desired times, turn the powder feeding switch OFF and ON again, this will set the counter to the new times.

Recommended feeding time is 25-30 seconds delay (Timer 1) and 3-5 seconds active (Timer 2).

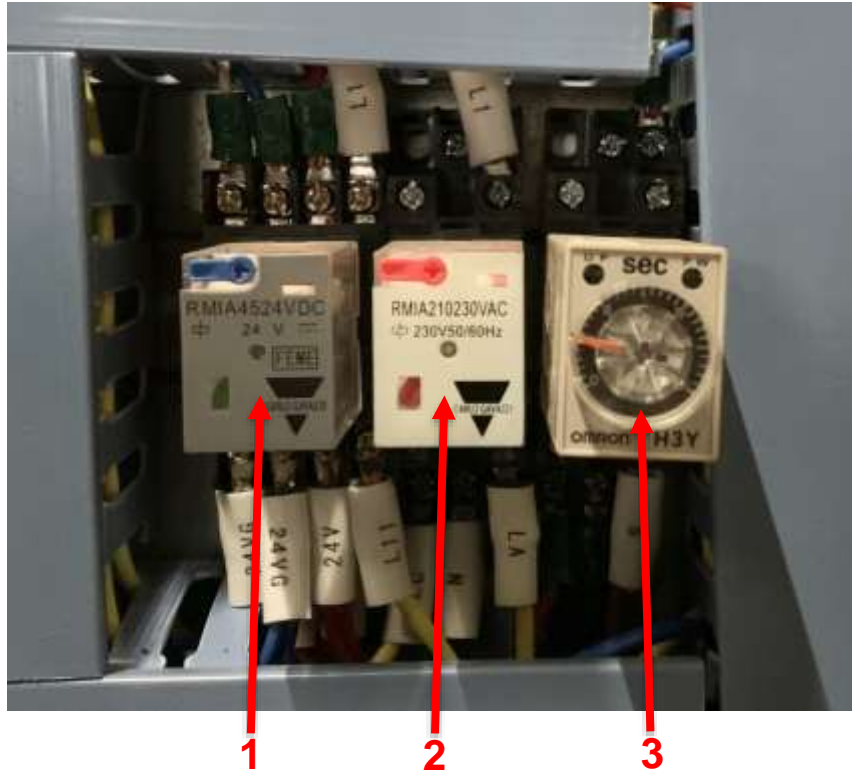
2.6 Guide Belt Adjustment



1	Conveyor Belt Speed Control	Controls the speed of the conveyor belt.
2	Conveyor Belt ON/OFF Switch	Turns conveyor belt ON or OFF. NOTE: Turning OFF conveyor belt does not turn OFF the take up rewinder

NOTE: Speed Control knob will also control the speed of the take up rewinder. Speed of conveyor belt should be a second faster than the printer output.

2.7 Timer Relay Adjustment



1	Conveyor Belt Relay	Turns conveyor belt ON when activated
2	Rear Rewinder Relay	Turns rear rewriter belt ON when activated
3	Timer Relay for Conveyor and Rewinder	Activated by the film sensor, active time can be adjusted per seconds

Timer relay is adjusted based on the speed of the printer. The timer relay will activate once the film sensor detects the film. It will continue to supply power to the belt and rewriter, when the sensor stops detecting film the timer will begin to count down. It will turn off the power once the set time is reached.

The goal is to have enough slack in the valley to hold the powder. The speed of the conveyor belt and the time should be enough to raise the slack away from the film sensor but not so much that the media makes contact with the auger system above it.

Set the conveyor speed to be roughly 1 second faster than the output of the printer (see section 2.6). Set the timer at 2 seconds. Once the SLIMSHAKER is working adjust the speed and time accordingly.