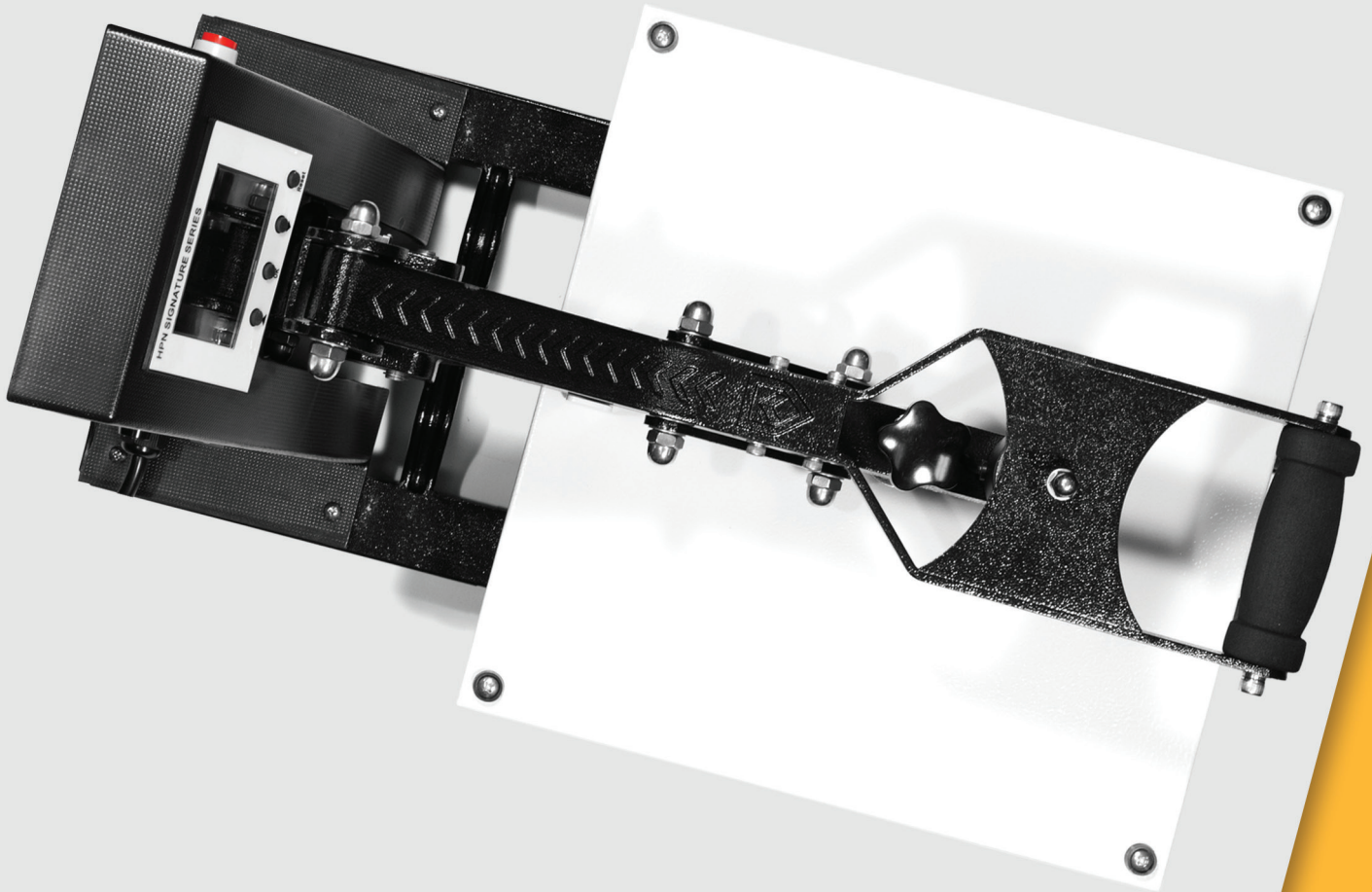




Signature Series



USER GUIDE

THE BEST TRANSFER MATERIALS BRANDS FOR YOUR HPN SIGNATURE SERIES



Siser Easyweed Heat Transfer Vinyl is an easy to use material that is ready to cut and allows you to weed out your designs with ease.



Paropy Heat Transfer Paper is widely known as the premier brand in quality heat transfer paper.



Neenah Paper has been an industry leader in the creation, development, and improvement of heat transfer products since their first patent was granted in 1980.



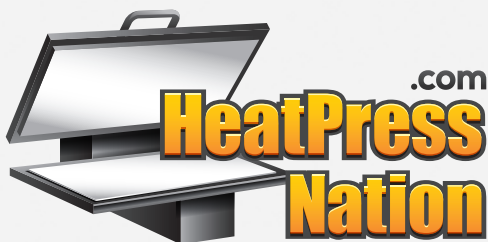
ThermoFlex by Specialty Materials is a durable polyurethane based heat transfer vinyl that is ready for all of your creative needs.



With Forever, you can produce self weeding designs without the need for a special toner. This makes your job easier by eliminating a tedious task.



Sawgrass is the go to brand for your sublimation printer and ink needs. They have been leading the industry for many years with their innovative products.



CALL US: (800) 215-0894
www.heatpressnation.com

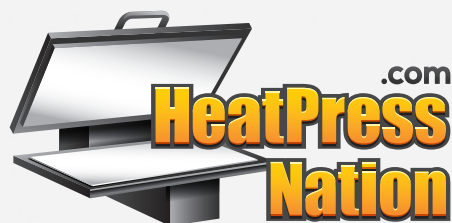
WELCOME	1
GETTING STARTED	2
PAPER PRESSURE TEST	6
GAUGE OPERATING GUIDE	7
AUTO OPEN USERS	11
MULTIFUNCTION USERS	12
CLAMSHELL	13
SIGNATURE PRO CLAMSHELL	15
SWING AWAY	16
FULLY AUTOMATIC MUG PRESS	17
STANDARD MUG PRESS	18
CAP & LABEL PRESS	19
AUTO OPEN CAP PRESS	20
HEAT PRESSING BASICS	21
MUG PRESSING	22
HEAT TRANSFER MATERIAL GUIDE	23
HEAT PRESSING SUPPLIES	25
FAQ	27
WARRANTY	28

WELCOME

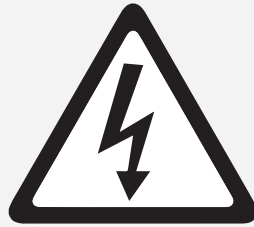
Thank you for choosing us! Heat Press Nation was founded in 2009 with one goal in mind: to help aspiring entrepreneurs create custom apparel businesses with a low cost of entry and high-profit products. At Heat Press Nation, we work hard to serve these entrepreneurs so they can fulfill their dreams of building and running their own successful ventures.

We understand the importance of education in making the best informed decisions to grow your business. Our team is highly trained and experienced in all aspects of heat press application, vinyl cutting, sublimation printing, and the varying techniques behind these applications. We'd love the opportunity to talk to you over the phone to help answer any questions you may have about your product.

We hope the contents of this manual will not only provide details about your product, but also help you to become an informed and empowered heat press user. We also offer free lifetime technical support on every product we sell, so please do not hesitate to contact our experts at **support.heatpressnation.com**. Thanks for being a valued part of Heat Press Nation!



SAFETY FIRST



Safely remove the machine out of the box

The contents may be extremely heavy and unsafe to remove alone. Most of the internal packaging will consist of protective foam that can be individually removed prior to the removal of the heat press. Please ask for assistance, use caution, and perform proper lifting techniques to remove the product out of the box. Do not throw away your box and internal packaging materials. This is required for returns and services.

Inspect your new product

As there are varying circumstances, we recommend inspecting your machine for obvious damages, defects, or missing items. Heat presses may have small blemishes and cosmetic imperfections which are perfectly normal and should not affect the overall operations longevity of your product.

Use a heavy duty stand

We offer a HPN Signature Series Universal Stand that is designed to support the weight of any of our heat presses. If you choose to use your own, we strongly recommend using an all metal stand that can support the weight of your machine. Plastic foldable stands are strongly advised against as they are not strong enough to withstand the weight and pressure that is being exerted during use.

SAFETY FIRST

Remove all liquids from the area

Do not operate the machine with any liquids or chemicals nearby that could potentially spill onto the machines components. This would be a high risk of electrical shock or fire.

A dedicated circuit is required for the machine

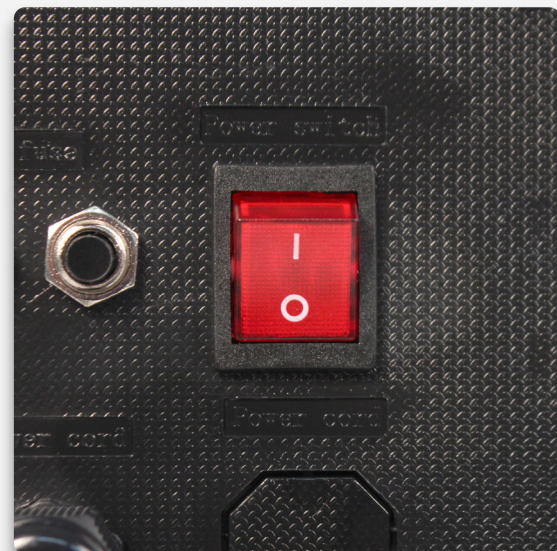
A heat press will draw anywhere between 3 to 18 amps from a single circuit. Due to this, we strongly advise against plugging any additional devices into the same circuit. Refrain from using a power strip as they are not necessary. If you choose to use a power extension cord, we recommend at least a 14 gauge or thicker. Your power extension cord will have an "AWG" reading that will help you choose the correct size. The lower the number, the thicker the wire is to support higher amperages.



SETUP INSTRUCTIONS



Let's start by opening your machine completely so that the heating platen is completely separated away from the lower platen.



Plug in the grounded AC power cord to the wall outlet and flip the power switch on.

GETTING STARTED

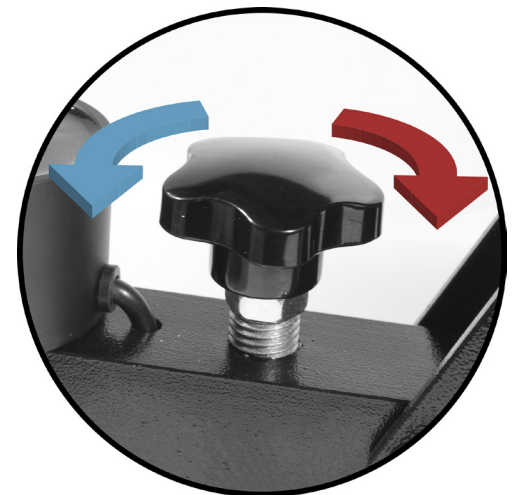
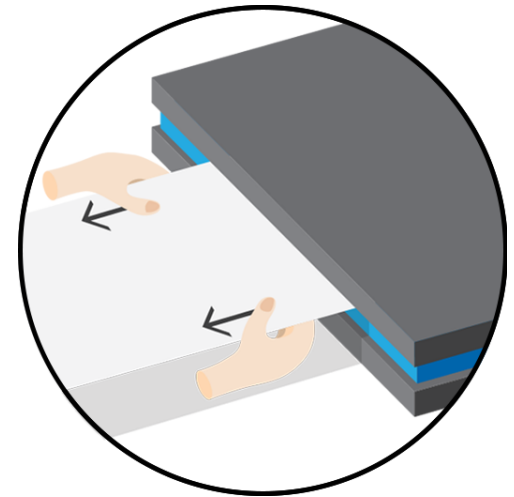
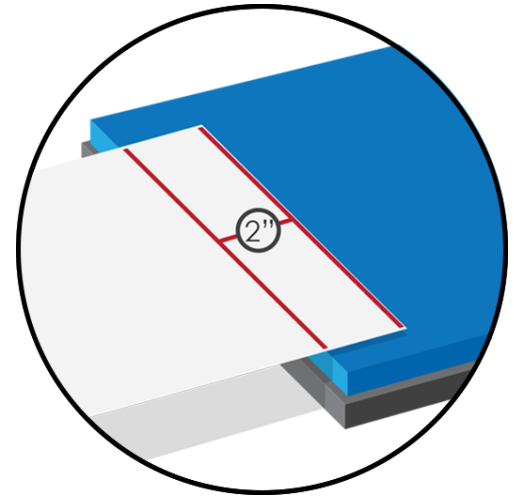
SETUP INSTRUCTIONS



The display will turn on and the machine will slowly start heating up. Learn more about this display and how to set up your temperature and time on page 7.

PERFORMING THE PAPER PRESSURE TEST

1. Take a plain piece of 8.5" x 11" copy paper and insert only 2" of the paper in the front of the machine.
2. Lock your machine down completely and try tugging on the paper on both ends.
3. If the paper slips out, open your machine and start turning the pressure knob clockwise to add more pressure. The rule should always follow as, "righty tighty, lefty loosey."
4. If the paper does not slip out then the pressure is proper.
5. Repeat steps 1 through 4 on the front, left, and right side of the heat press.
6. This is what is considered 50-60 psi or medium to heavy pressure.
7. From here, you may gauge pressure and adjust accordingly to reach light to heavy pressure.



GAUGE OPERATING GUIDE

GAUGE 1 INSTRUCTIONS

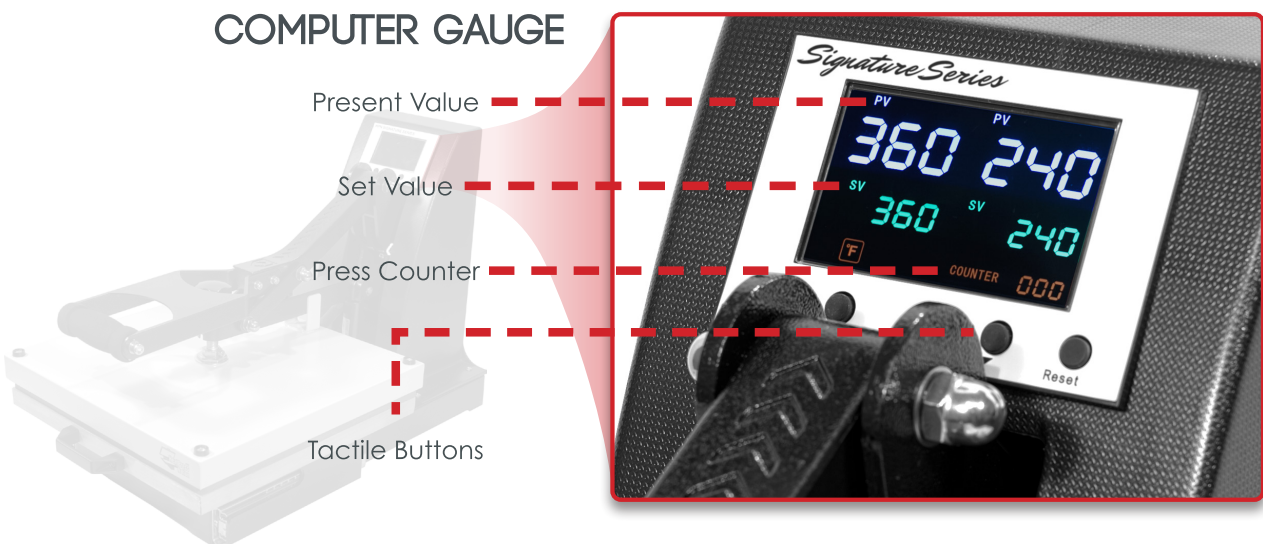
Present Value - The PV located on the left is the current temperature of the heating element. The number to the right is the current countdown timer. The counter will only activate as soon as the machine is closed.

Set Value - The SV located below are the preset settings for both the temperature on the left and countdown time on the right.

F - This is the current temperature scale that is being displayed. F is for Fahrenheit and C is for Celsius.

Counter - This is your machine's cycle count. To reset this, simply hold down the reset button for 3 seconds and the numbers will reset to 0.

COMPUTER GAUGE



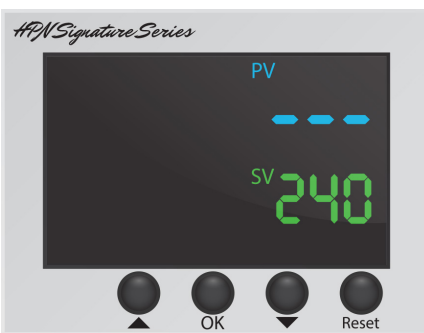
GAUGE OPERATING GUIDE



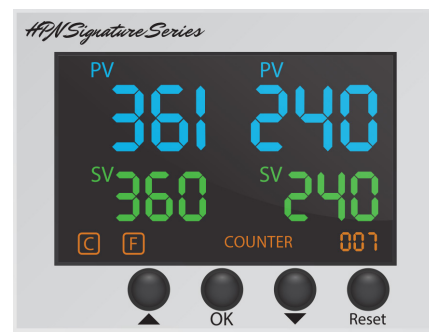
Start by pressing the OK button. The screen will display the letter F which references the current temperature scale. We recommend leaving it at Fahrenheit unless you prefer Celsius. Press OK to go to the next screen.



This function sets the temperature. Use the “▲” and “▼” buttons to set your desired temperature. Always follow your heat transfers recommendations. Press OK to go to the next screen.



This function sets the timer. Use the “▲” and “▼” buttons to set your desired timer and like before, always follow your heat transfer recommendations. Press OK to go to the next screen.

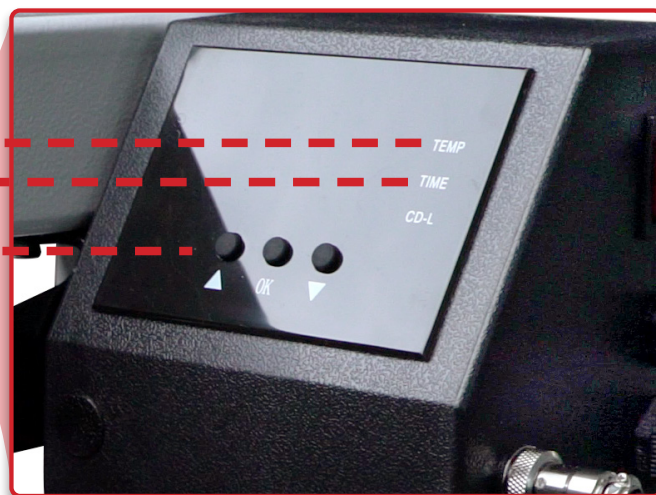
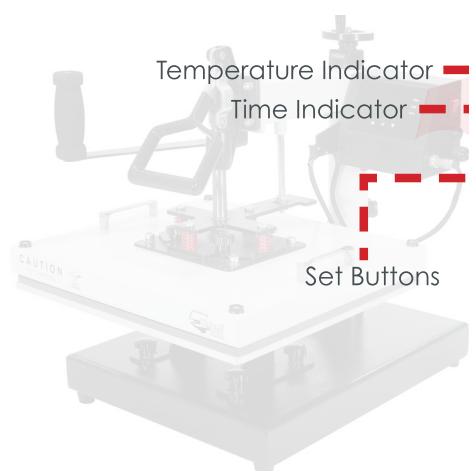


The new temperature and time settings will be displayed under sv. The pv will climb up to the sv. Heat up time can range anywhere between 15 to 45 minutes depending on the size of your heating platen. Once it reaches the desired temperature setting, it will beep indicating that the heat press is ready.

GAUGE 2 INSTRUCTIONS

When the machine is on, it will immediately show OFF indicating so we will need to cycle through the settings to get to the heat up mode. Press OK to go to the next screen.

COMPUTER GAUGE



GAUGE OPERATING GUIDE



The screen will display the letter F which references the current temperature scale. We recommend leaving it at Fahrenheit unless you prefer Celsius. Press OK to go to the next screen.



This is where we will set the machine's temperature. Use the "▲" and "▼" buttons to set your desired temperature. Always follow your heat transfers recommendations. Press OK to go to the next screen.



We are now going to set the countdown timer. Use the "▲" and "▼" buttons to set your desired timer and like before, always follow your heat transfer recommendations. When finished, click the OK button to complete setting up your machine.



The machine will display LO indicating that the machine is in the heat up mode. Leave the machine in this mode while it is slowly reaching temperature. Once the machine reaches 214F, the LO will disappear and start displaying the actual current temperature. This process can take up to 10-15 minutes.

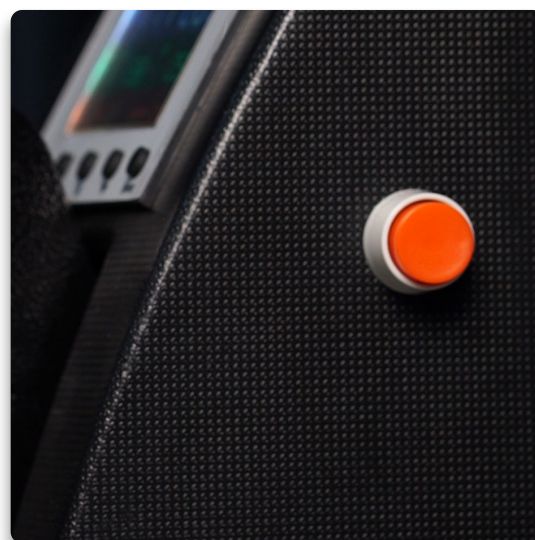
AUTO OPEN USERS

The auto open clamshell heat presses have an electromagnet that offers the comfort of automatically opening your machine when the countdown timer has completed. To engage the magnet, be sure to fully press down the machine until the electromagnet makes full contact with the metal above. This will only work while the machine is turned on.



The auto open feature is entirely opened by a hydraulic shock located underneath the upper platen. This will ensure extreme safety while it is being opened.

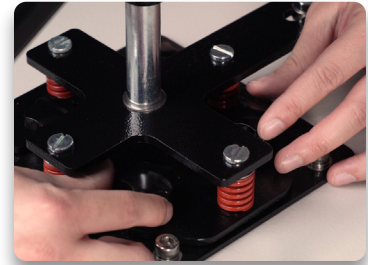
Sometimes, you need to open the machine a bit earlier. The auto release button will allow the machine to open at any given time.



The Multifunction heat press allows you to interchange between the included attachments such as the cap attachment, plate attachment, and mug attachments. Please refer to the Multifunction attachment steps required section below which will reference which steps need to be taken.

1. Removing the upper platen

To interchange between the multiple attachments, this can be achieved by unscrewing and disconnecting the 4 plastic knobs located on the top of the 15" x 15" upper platen.



2. Disconnecting the heating element cord

Disconnect the heating element cord that is directly connected to the left side of the computer box.



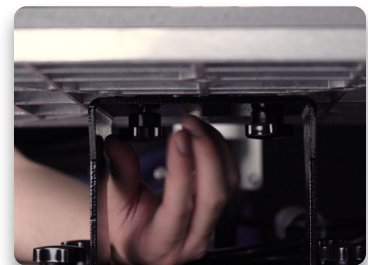
3. Disconnecting the timer cord

Disconnect the timer actuator cord that is directly connected to the right side of the computer box.



4. Removing the lower platen

Unscrew and disconnect the 2 plastic knobs located underneath the platen. This will allow you to completely lift up and remove away the platen.



Multifunction attachment steps required

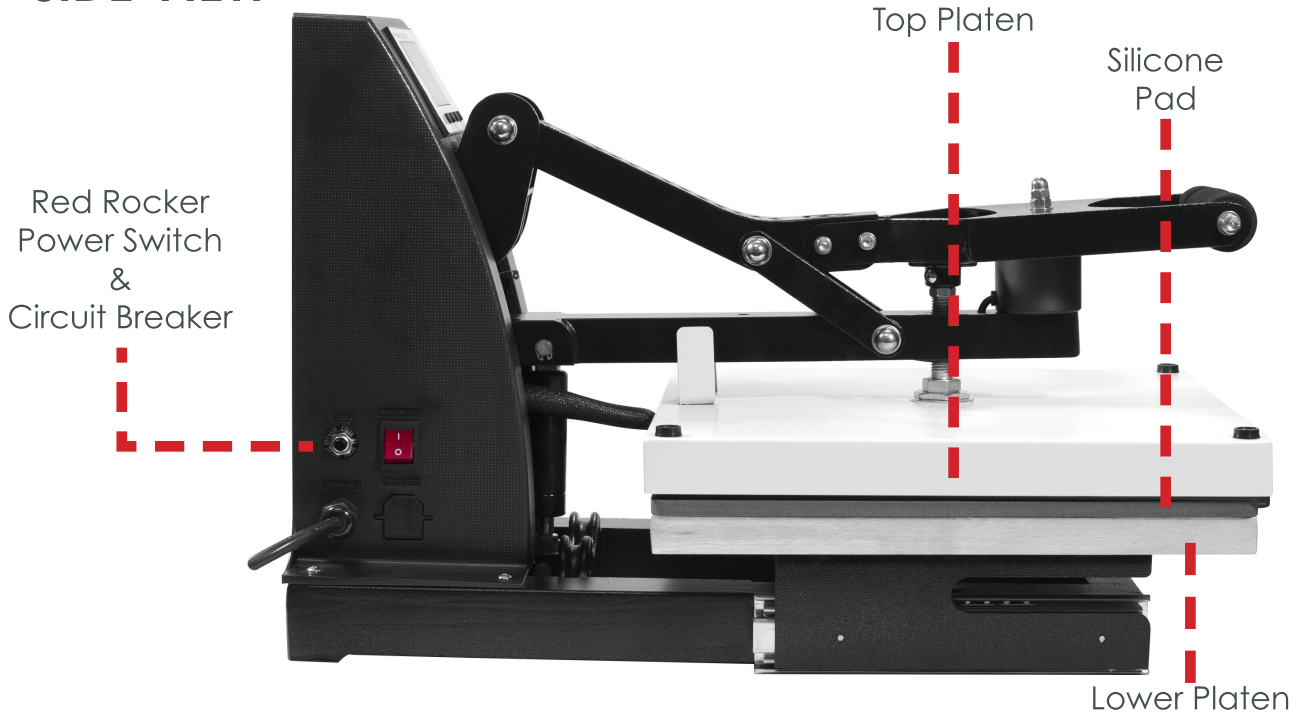
Cap attachment - 1, 2, and 4

Plate attachments - 1 and 2

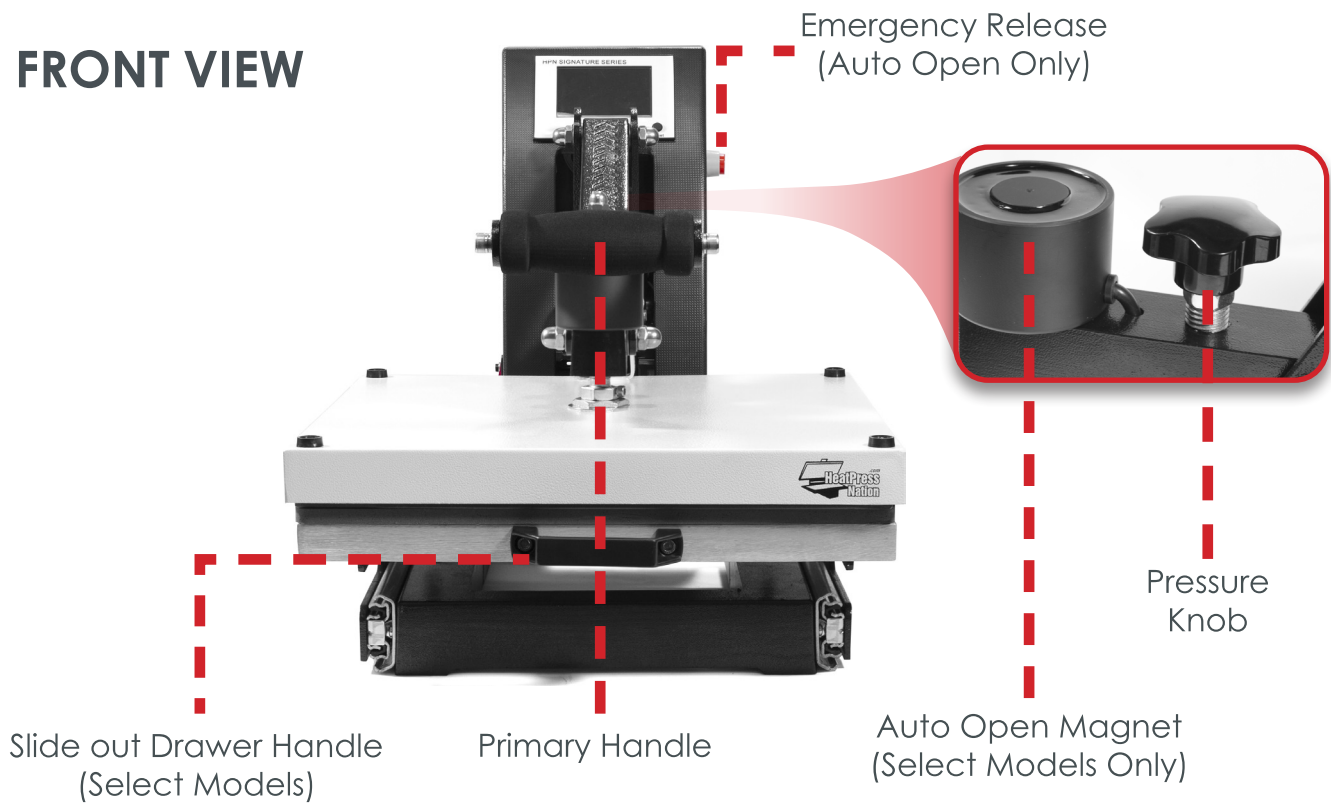
Mug cradle with attachments - 2 and 3

CLAMSHELL

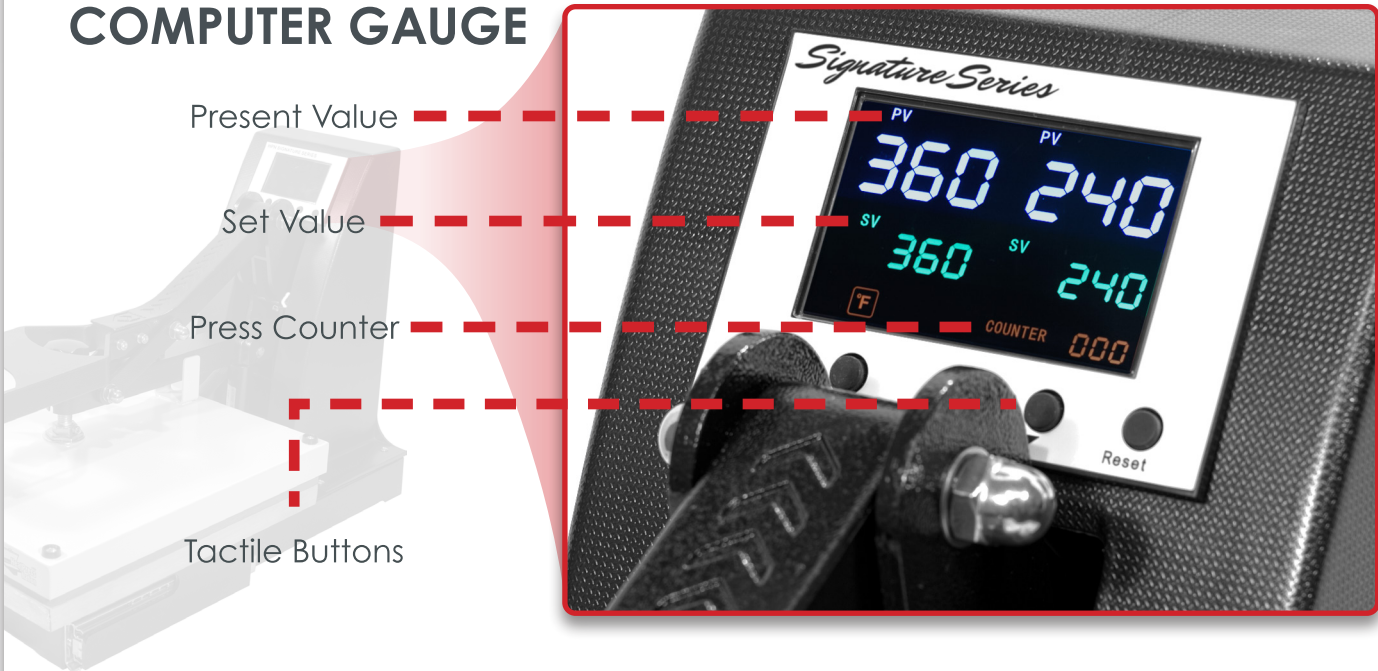
SIDE VIEW



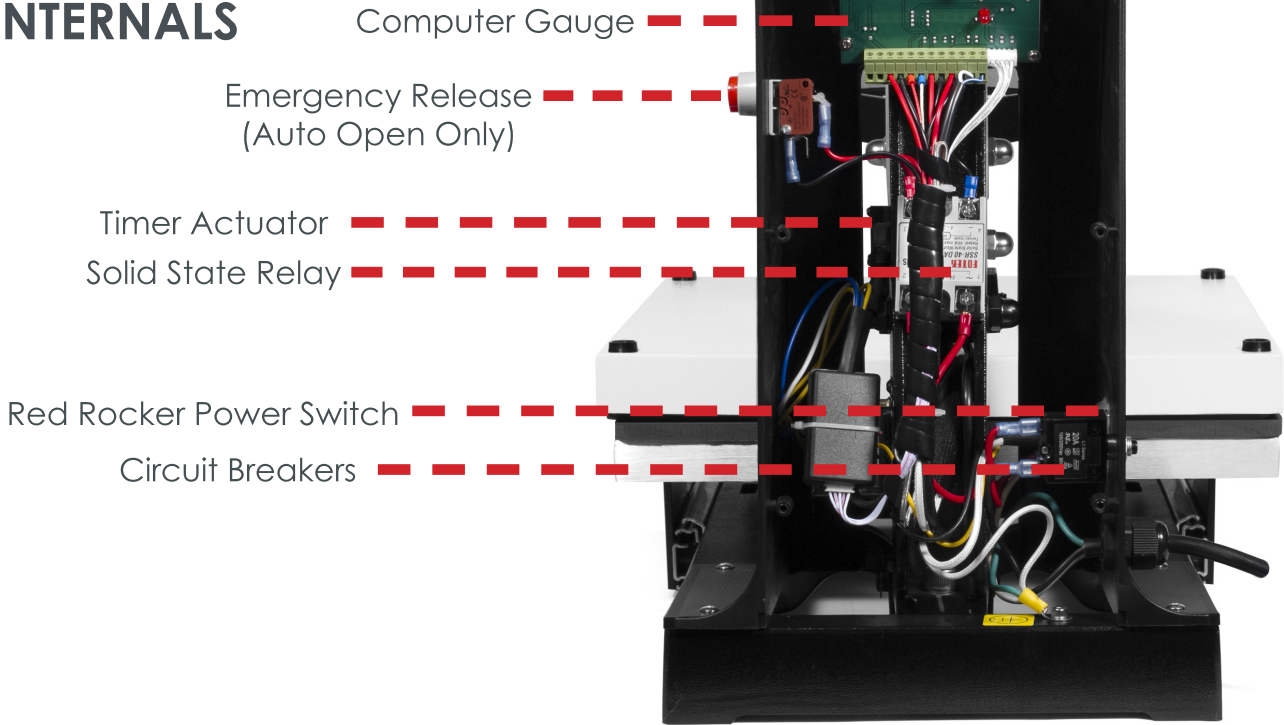
FRONT VIEW



COMPUTER GAUGE



INTERNALS



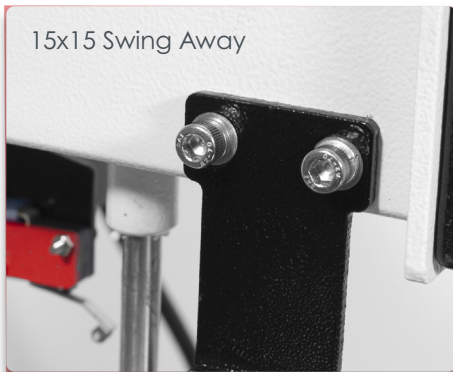
SUREPRESSURE

The SurePressure counter is designed to let you set a reference point of pressure between material to material. Although these numbers do not exclusively define which pressure your transfer recommends, you can set your adjustments prior to your application so that it stays consistent at all times. For our SurePressure pressure recommendations please refer to our cheat sheet towards the end of this manual.

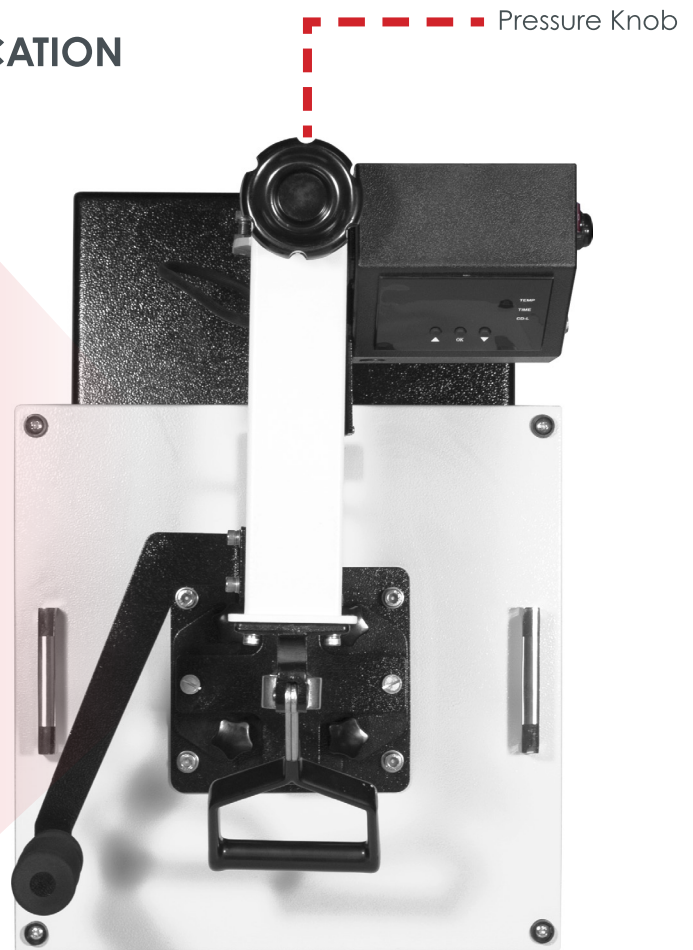


Our burn free support handle will allow you to close and open your machine with ease. Use the secondary handle as another support point so that it is not too difficult to operate your machine.

SWING HANDLE ATTACHMENT LOCATION



OR



MULTIFUNCTION ATTACHMENTS



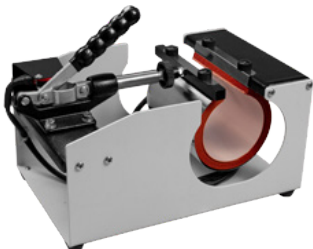
Cap Attachment



Mug Heating Elements



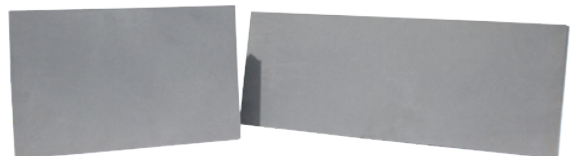
Plate Heating Elements



Mug Press Cradle



Flask Attachment

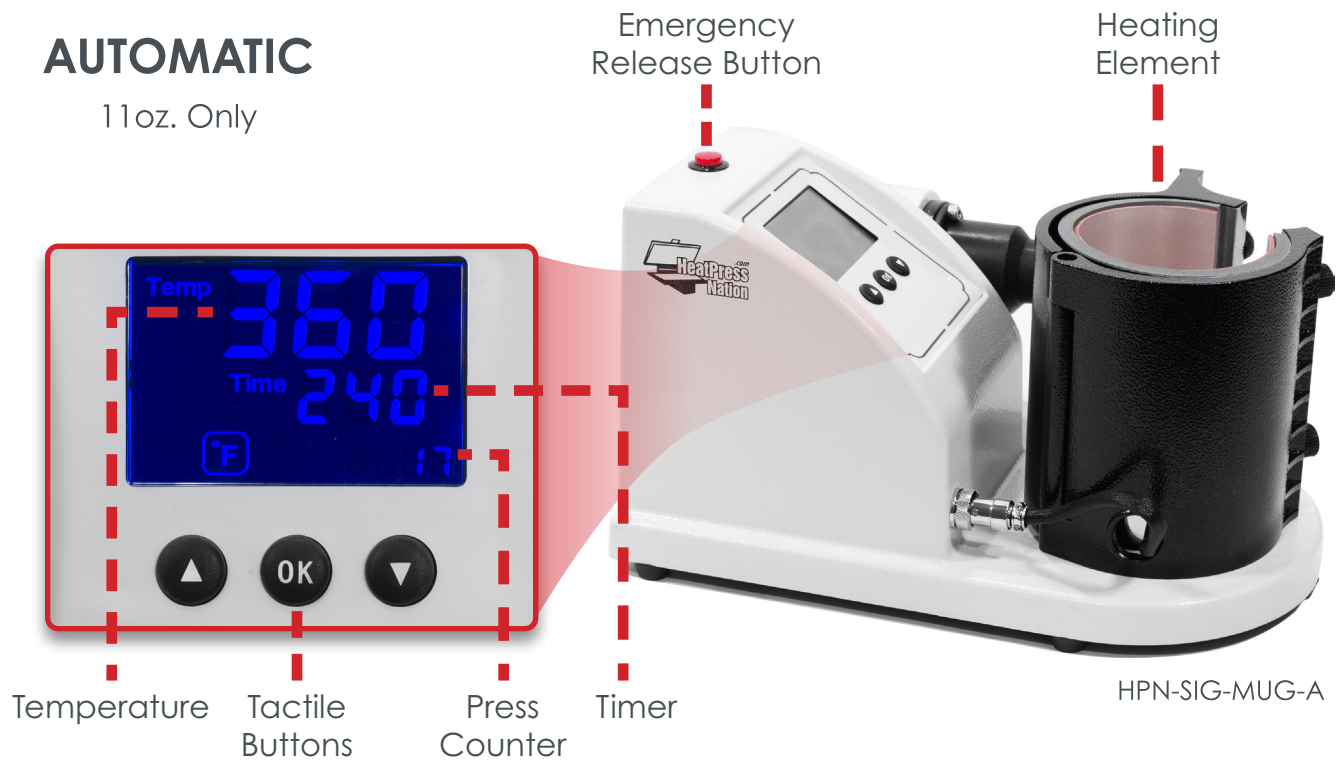


Drop On Tables

FULLY AUTOMATIC MUG PRESS

AUTOMATIC

11oz. Only



AUTOMATIC MUG PRESS OPERATING GUIDE

Press "OK" to switch between Fahrenheit and Celsius

To set temperature, press "OK" once and the upper numbers will blink which indicates you can now change the values to your choice

To set the time, press "OK" until the numbers to the right of time start blinking.

Once you're all done, press "OK" one last time and your machine will start heating in this general mode. When it reaches your desired temperature, you will be ready to insert a mug into the heating element. The heating element will automatically wrap around the mug.

When the timer reaches 0, the mug press will automatically release.

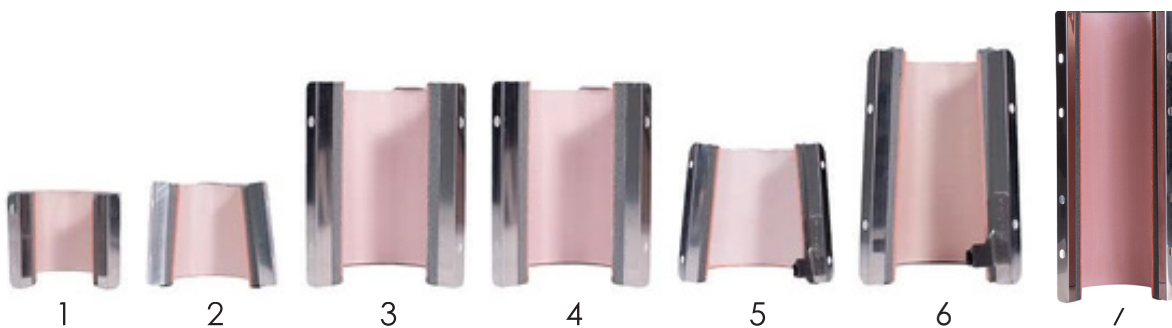
TO RELEASE THE GRIP OF THE MACHINE, PRESS THE RED "EMERGENCY RELEASE BUTTON"

STANDARD MUG PRESS

MANUAL



STANDARD MUG PRESS HEATING ELEMENTS



1 Mini Mug

2 Shot Glass

3 Water Bottle & 6oz. Mug

4 11 & 15 oz. Mug

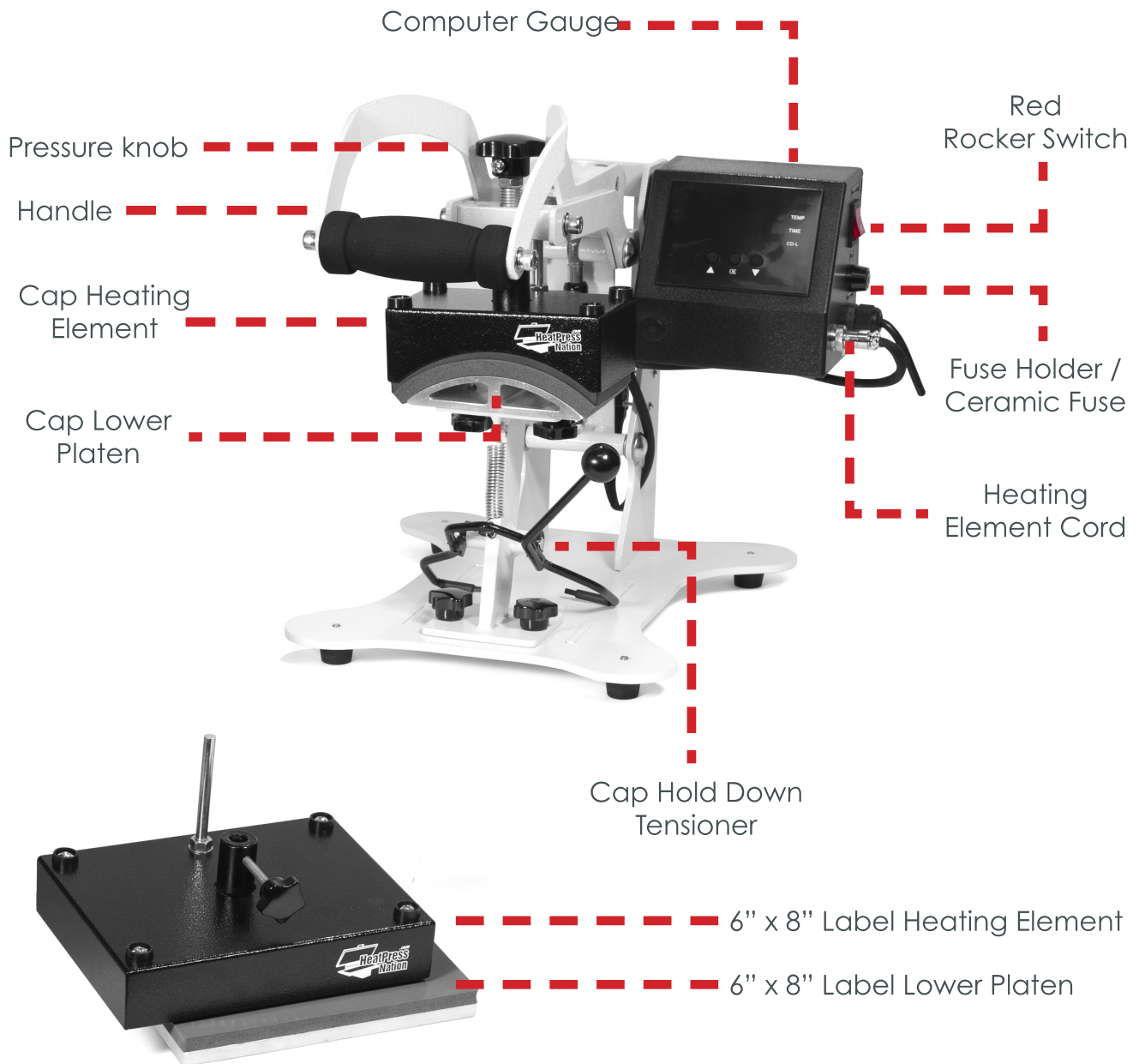
5 12 oz. Latte Mug

6 17 oz. Latte Mug

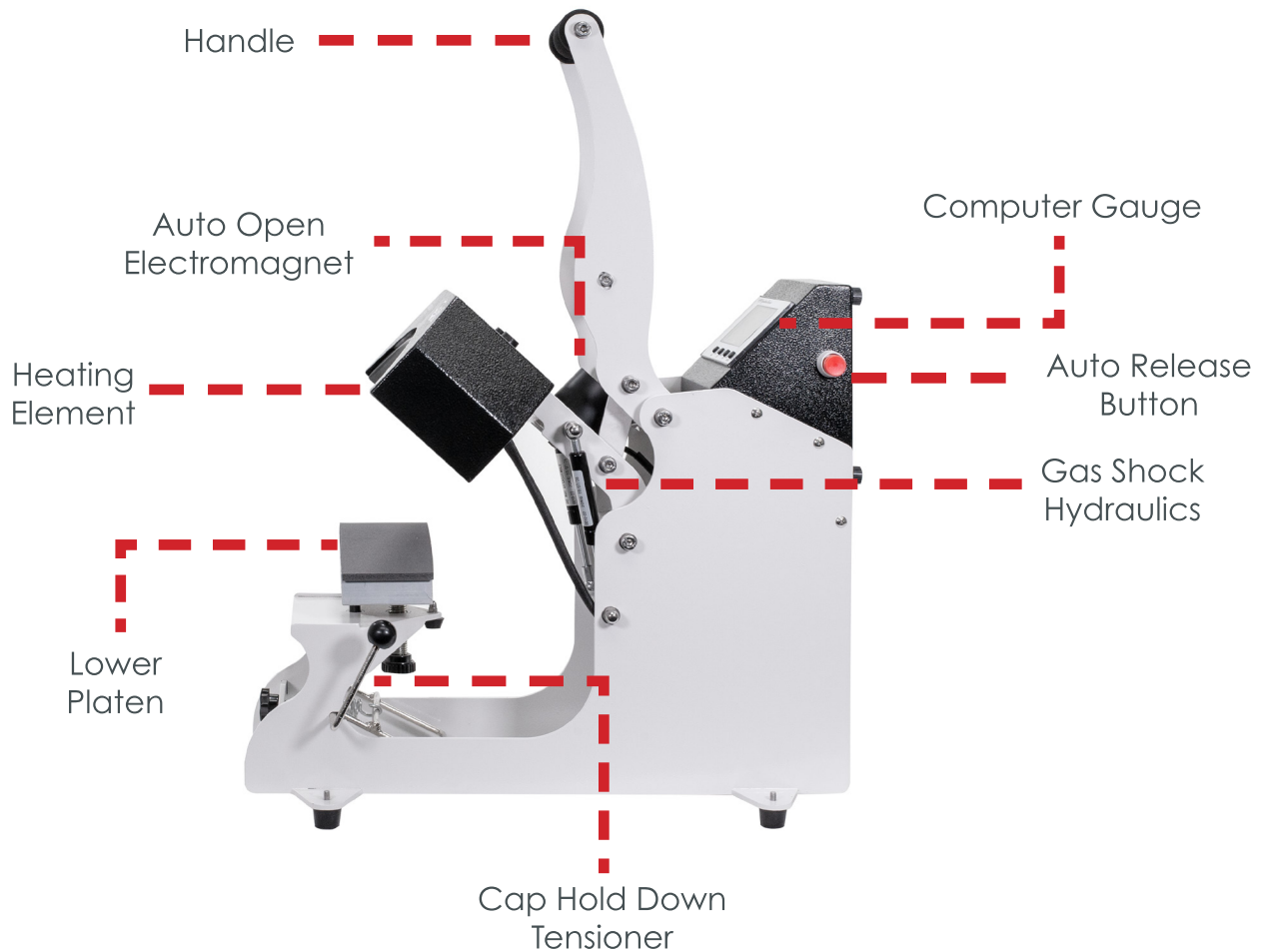
7 20 oz. Skinny Tumbler

For use with Standard Mug Press Only (HPN-SIG-MUG)

CAP & LABEL PRESS



AUTO OPEN CAP PRESS



STANDARD CAP PRESS LOWER PLATENS



2.875" x 7"



3" x 6.5"



3.875" x 7"



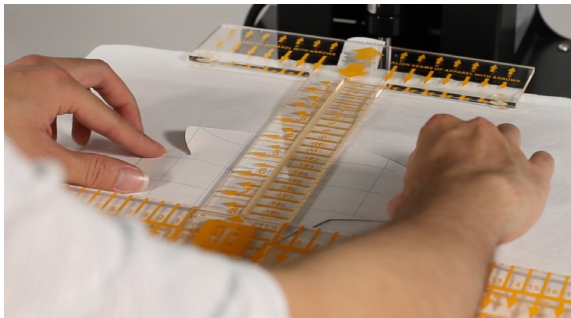
4" x 9"

HEAT PRESSING BASICS



Pre-Press

When the machine has reached the set temperature, start by prepressing the garment to remove all moisture and wrinkles. Lower the handle and allow the heating element to make contact with the garment. Apply some weight by pressing down on the handle but not locking it down completely. Do this for 5 seconds to remove moisture and wrinkles.



Align

Our next step is to align the transfer as perfectly as possible. We recommend using a Tee Square It that will help you center the transfer onto the shirt. While setting the transfer down, the top of the transfer should sit at least 3" below the bottom seam of your T-shirt collar.



Press

The next step is to cover the shirt and transfer with a Pro Grade Non-Stick Sheet or Pro Grade Parchment and press the garment by firmly locking down the handle until the machine has locked in. During this process, the countdown timer will begin.

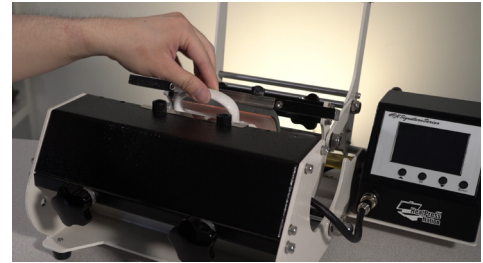


Peel

The final step is to open the machine after the timer has completed and peel away your transfer. It's important to note that certain transfers can either be a hot or cold peel. Please reference your transfer instructions or our cheat sheet for that information.

Pressure Prep

First, let's test to make sure you are able to insert the mug and comfortably close it. If adjustments need to be made, use the 2 knobs located on top of the machine to the appropriate level. We recommend a medium to firm pressure level that is not too hard on the substrate.



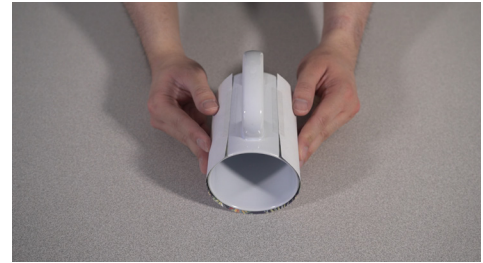
Tape Prep

While the machine is heating, tape your transfer using the Sublimation Heat Tape on both sides of the sublimation transfer.



Tape Your Mug

Tape your sublimation transfer onto your mug as straight as possible. We do this carefully aligning the transfer with both hands and then pressing the tape down after it is aligned. If done correctly, the surface should feel smooth and sit completely flat, free from any open spaces.



Press

When inserting your mug, make sure the handle is sitting straight as shown in this photo. This will ensure that you will get heating throughout the entire surface. This is especially important when doing full bleed transfers.



Peel

The final step is to remove the mug out of the machine and peel away. We recommend waiting until the mug cools down so that injuries do not occur. However, if you own our HPN Pro Grade Protective Gloves, you may peel it about 15 seconds after the mug has been taken out.



White color garments

White color fabrics are just about the easiest type of garments to work with since the heat transfer uses the color of the foreground which is white to depict the color and details of your design. The transfers are usually able to imprint directly to the fibers of the shirt which in the end gives you a much softer, stretchier, and long lasting transfer. It is important to note that everything recommended below is advised to use with white color garments or heather gray at the darkest.



Our top recommendation is the Inkjet or Laser Light Heat Transfer Paper. We believe this is the best option for anyone starting or established in their T-shirt business. Light transfer paper is a simple and extremely cost effective transfer that allows you to imprint any design of your choice.

Recommended brand: Neenah Jet-Pro Soft Stretch and Paropy Light Pro Inkjet Light Transfer Paper.

Required printer: Any color inkjet printer.

Estimated startup cost: \$200+

Our second top option is sublimation onto 100% polyester. Unlike transfer papers, sublimation ink does not rely on a waxy film to reproduce the graphic onto the shirt. Instead a unique chemical reaction occurs when the ink is heat pressed. The ink slowly transitions from a solid form to a gas form and is passed through to the fibers of the shirt. Unfortunately, sublimation ink does not have the ability to embed itself to natural fibers like cotton so 100% polyester or 70% polyester at the lowest is recommended. What you end up getting is a T-shirt transfer that is extremely vibrant and impossible to feel. Since it is able to migrate the dye into the fibers, it cannot stretch or crack, and offers superior washability over any transfer product on the market.

Recommended brand: TexPrint R and TexPrint XPHR sublimation paper.

Required printer: Sawgrass Virtuoso, any sublimation printer.

Estimated startup cost: \$600+

Our final option is the sublimation onto cotton. What, you say? Yes, we know we just mentioned that sublimation ink is only for polyester. As innovation throughout the market continues to grow, companies like Forever have created a unique transfer paper that allows you to transfer your sublimation ink onto 100% cotton shirts. It's of course not without the help of a special transfer film that allows the sublimation ink to embed into the cotton fibers. In the end, you are getting a product that is a bit similar to inkjet light transfer paper but you are using sublimation ink which should be a bit more durable. The only downside is that it has a hard time with light color designs so we recommend textile designs with solid darker colors.

Recommended brand: Forever SubliLight

Required printer: Sawgrass Virtuoso

Estimated startup cost: \$600+

Dark color garments

Dark color garments are just about the most common types of shirts but a bit more difficult to work with compared to light. This is because unlike light transfer paper, the media is unable to embed itself into the fibers to represent the t-shirt graphic. Since you have a darker colored background, most of the transfer media need to be applied facing away before it is pressed on. This transfer media usually needs to be trimmed completely around the design and usually has a thicker waxy polymer compared to the light.



Our top option is any self-weeding laser dark transfer paper. As mentioned above, dark transfer media needs to be trimmed completely around and inside the design or else you will have a white background behind your image. For example, if you print a small logo on an 8.5" x 11" sheet and you transfer the paper in full, you will have a 8.5" x 11" rectangle with a logo in the center. With self-weeding laser transfer paper's 2 step process, it is able to automatically weed away and unprinted areas of your design so that only your design is transferred. Paired with the Forever TransferRip software, you are able to rasterize your graphics to provide ultimate durability and hand quality unlike anything else.

Recommended brand: Forever Laser Dark, Forever Flex Soft

Required printer: OKI white toner laser printer (for Forever Laser Dark) and any monochrome laser printer for Forever Flex Soft.

Estimated startup cost: \$4,200+ for Forever Laser Dark and \$100+ for Flex Soft

Our second option is heat transfer vinyl. Heat transfer vinyl consists of Polyurethane that is usually dyed in a single color and offered in many different texture and color combinations. Some of the options include: standard, glitter, electric, fluorescent, flock, reflective, patterned, and many more. This allows you to transfer single color designs with the option of layering other colors as well. This is a great way to add numbers onto a jersey, glitter for cheer bows, reflection badges used by police, firefighters, EMS, and bicyclists to name a few. It is however important to note that you are unable to do full colored images since nothing is printed.

Recommended brand: Siser and Specialty Materials

Required equipment: Vinyl cutter

Estimated startup cost: \$300+

Our final option is inkjet or laser opaque transfer paper. Much like the light transfer version, you can use any inexpensive inkjet or laser printer to offer full color designs onto any color garment of your choice. This paper needs to be trimmed exactly to the image or else remnants of the white background will be noticeable. Of course we do not recommend doing this by hand! A vinyl cutter with contour cutting has the ability to trim away any unprinted areas to create an awesome finished product.

Recommended brand: Paropy Dark Pro and Neenah 3G Jet Opaque

Required equipment: Any inkjet printer, contour cutting vinyl cutter recommended

Estimated startup cost: \$200+

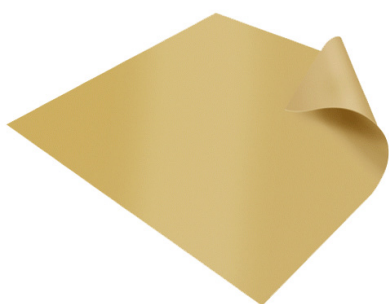
HEAT PRESSING SUPPLIES

A sturdy surface for your heat press

Made with heavy-duty steel and aluminum, the HPN Signature Series Heat Press stand provides an even, sturdy surface to safely operate your heat press. Though it is designed specifically for the HPN Signature Series Heat Presses it can be used with all other heat press machines.



HPN-SIG-STAND



PGNSS-01



PGNSP



PGNSTPP-1

A cover to protect your investment

The **Pro Grade Non-Stick Sheet**, **Pro Grade Parchment Paper**, or **Pro Grade Upper Platen Protector** can go long way in protecting your investment from residual build up. We recommend these choices as they all offer the same protection qualities.



HPN-SIG-BWP-15

An easy slide surface

The HPN Signature Series Non-Stick Lower Platen Protector cover offers a non-stick surface that allows you to easily slide your shirt onto your heat press so that loading and positioning of your shirt is much easier. It also protects the silicone pad from any residual build up.

Keep your hands safe

Certain applications, such as sublimation, require you to peel hot transfers off of metal and ceramic that can easily injure you. The HPN Pro Grade Protective Gloves will allow you to comfortably operate to always get the perfect transfer.

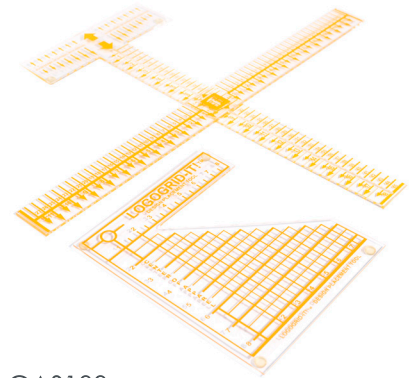


PGPG-S

HEAT PRESSING SUPPLIES

Alignment tools for easy positioning

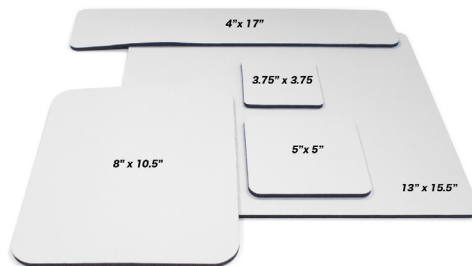
Aligning your transfers can be challenging when you are pressing several shirts at a time. We recommend the Tee Square It for large designs and the Logo Grid It for smaller designs such as tags and chest logos.



GAS100

Pads and Pillows to help eliminate seams

Pressing with buttons, collars, zippers, or seams, can be an issue with pressure. **The Tee Pad It** set comes in 5 different sizes to help you isolate the area you are looking to press. It is a silicone pad that slips inside or behind the T-shirt so that you are providing maximum pressure to that area. **The Sof-Fusion Pressing Pillows** feature a firm backing to accommodate easy insertion into your garments. It also features cushioned bounce-back foam which comes back to form after each press.



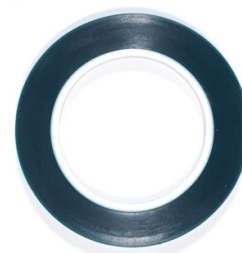
TPI003



SFPP

To keep your transfers in place

The Sublimation Heat Tape is designed to assist you in keeping your sublimation transfer in place on your substrate negating any shifting of your images such as ghosting or an otherwise "do-over" product. **AlbaChem Eco Mist** is perfect for use with sublimation, heat transfer paper, and any other application where you need a temporary adhesive with a spray application.



97223



1782C

Why does my heat press keep beeping?

Your machine will beep when in the closed position and the timer completes & also when it has reached its set temperature unless closed prior. Ensure your machine is in the open position while awaiting heat production.

What is this fabric cover on my lower platen?

The clamshell models will include a free lower cover protector. this is optional for usage but will help keep the silicone pad protected from residue.

Why doesn't my heat press stay closed when it's off?

Auto-open models will require power for it to stay closed due to the electro-magnetic system. If you do not have an auto-open, this would indicate your pressure level is set far too high.

What is the fuse for?

The internal circuit breaker fuse will protect the machine in any inconsistencies of power or electrical surges. If your fuse ever trips, it can be reset by pushing the black button back in.

Why is my heat press so hard to open and close?

The level of resistance to operate is based off the pressure level. For easier usage, it would be advised to decrease the pressure level.



NEED MORE HELP?

Scan this code for troubleshooting.



MyExpert Protection

Heat Press Nation provides a full and complete 1 year parts and service warranty from the original date of purchase. We carry all parts necessary to complete warranty service with the speed and efficiency that your business deserves. Warranty service does not include the cost of freight of the item to or from our facilities. If parts and/or accessories are needed at any time during the warranty period, Heat Press Nation will send them to you at no charge upon receipt of the defective part. Once the warranty period has ended, parts will be available at market price. For full warranty details please visit heat.press/warranty.

**DO NOT DISCARD BOX.
REQUIRED FOR WARRANTY AND
RETURNS**

You may be charged for a new box



SAWGRASS™



Specialty
Materials™

PAROPY™
image trans



GCC

Siser®
Thermo Transfers for Textiles

N
NEENAH



ChromaLuxe®

GEO Knight & CO., INC
EST. 1988

FOREVER®
DIGITAL TRANSFER APPLICATIONS TECHNOLOGY



INSTA
INSTA GRAPHIC SYSTEMS

unisub®



GRAPHTEC
GRAPHTEC AMERICA, INC.

EPSON®
EXCEED YOUR VISION



STAHL'S
Hotronix®

beaver paper
& Graphic Media, Inc.



SIGNMASTER
SOFTWARE VINYL SIGNS & CONTOUR CUTTING

WinPCSIGN
design | prepare | cut

OKI
PRINTING SOLUTIONS

Copyright © 2022 HeatPressNation

All rights reserved. No part of this publication may be reproduced, distributed, or transmitted in any form or by any means, including photocopying, recording, or other electronic or mechanical methods, without the prior written permission of the publisher, except in the case of brief quotations embodied in critical reviews and certain other noncommercial uses permitted by copyright law. For permission requests, write to HeatPressNation, 2300 E Walnut Ave, Fullerton, CA 92831

