

# Standard Operation

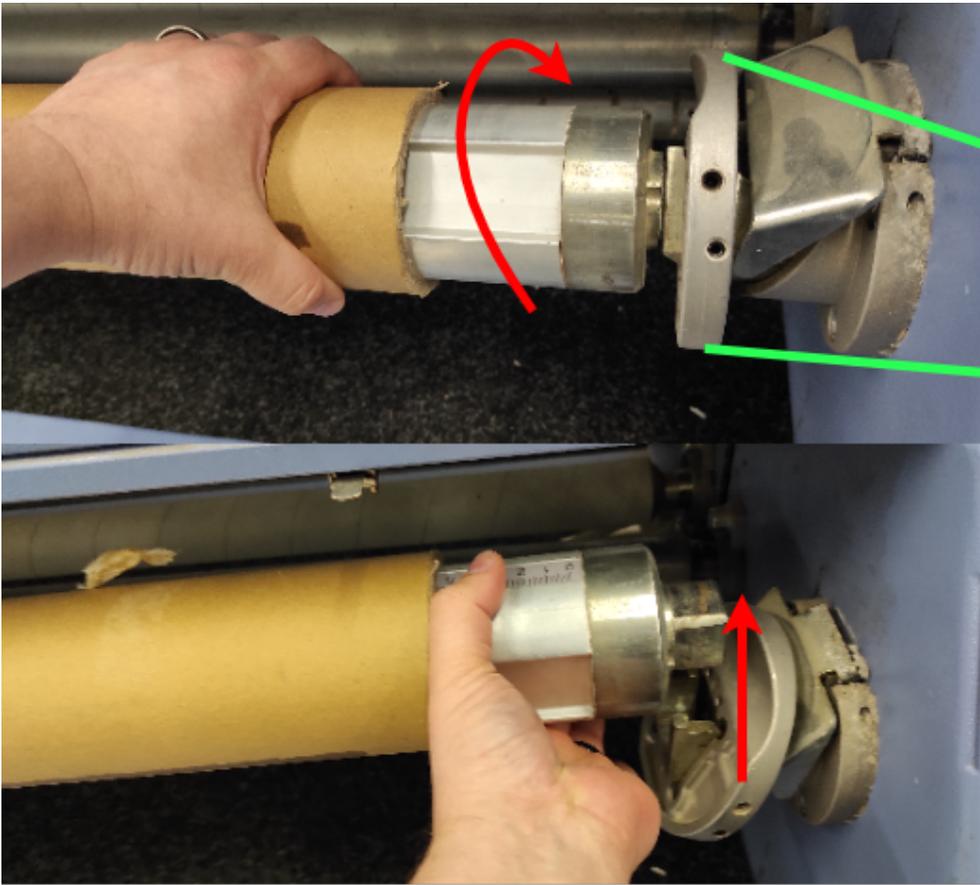
## Standard Operation Procedure for Fixating Fabric

Fixating dye-sublimated fabric is a balance between heat and time in the oven. To fixate fabric using the Transmatic Unit you must follow the following 5 Steps...

1. [Load Cores on to Front and Back Spool Bars](#)
2. [Load the Material into the Fixation Unit](#)
3. [Set the Temperature](#)
4. [Turn on the Extractor Unit](#)
5. [Feed Material Through Fixation Unit](#)

### Loading a Core on to a spool bar

1. Removing the spool bar

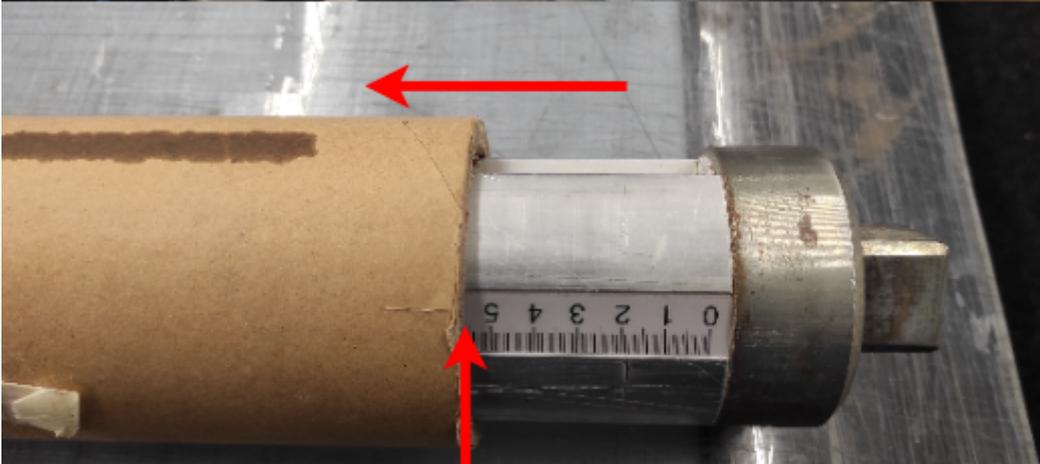
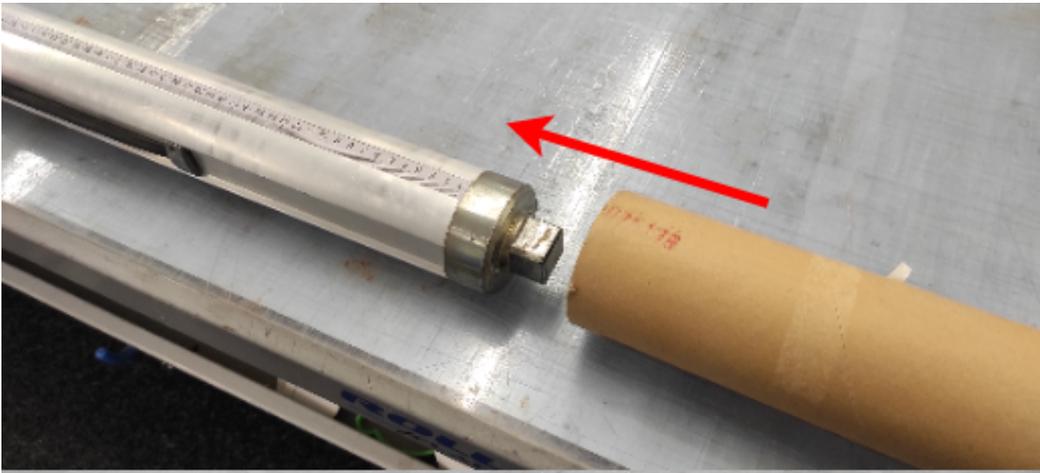


Rotate spool bar nibbed section like below is facing up



Lift spool bar up and out

## 2. Loading a Core on the Spool Bar



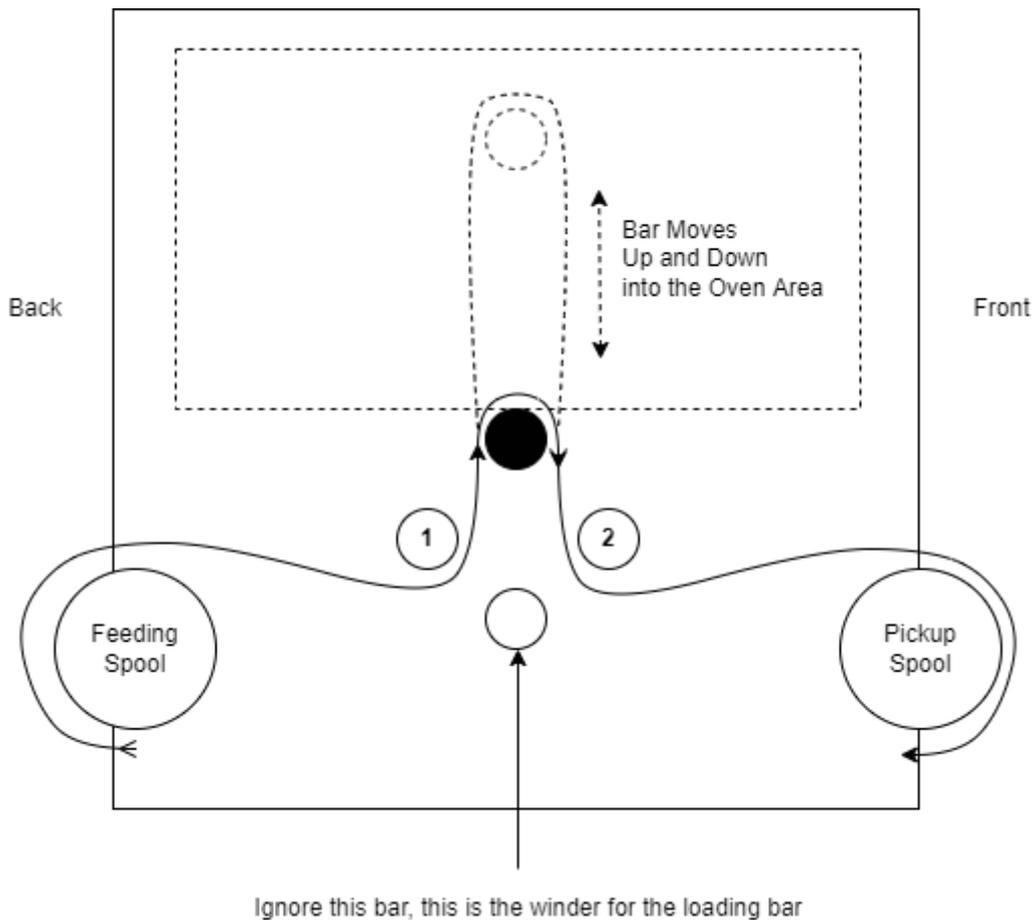
Line up the edge of the core with the ruler so it shows the same distance on the left and right.

e.g. 5cm & 5cm

## Loading the Material

1. Load the material from the back of the machine from the **feeding spool**
2. Feed the material under the **first tension bar** (shown as 1 in the diagram)
3. Feed the material over the **loading bar** (shown as black on the diagram)
4. Feed the material under the **second tension bar** (shown as 2 in the diagram)

5. Connect the material to the **pick up spool** at the front of the machine.



## Turning the Fixation Unit On/Off

1. Make sure the 3 Phase plug is plugged into the wall unit and turned on.



2. Turn the black switch on the right hand side on the Fixation Unit on



3. Press the Green Button



4. To turn off do the reverse procedure from above.

## Setting the Temperature

The fixation unit has a max operating temperature of 230 degrees Celsius.

### 1. Checking the Current Temperature Setting

The current temperature inside the oven will be shown here



Hold the "S" button to see what temperature the oven is set to.

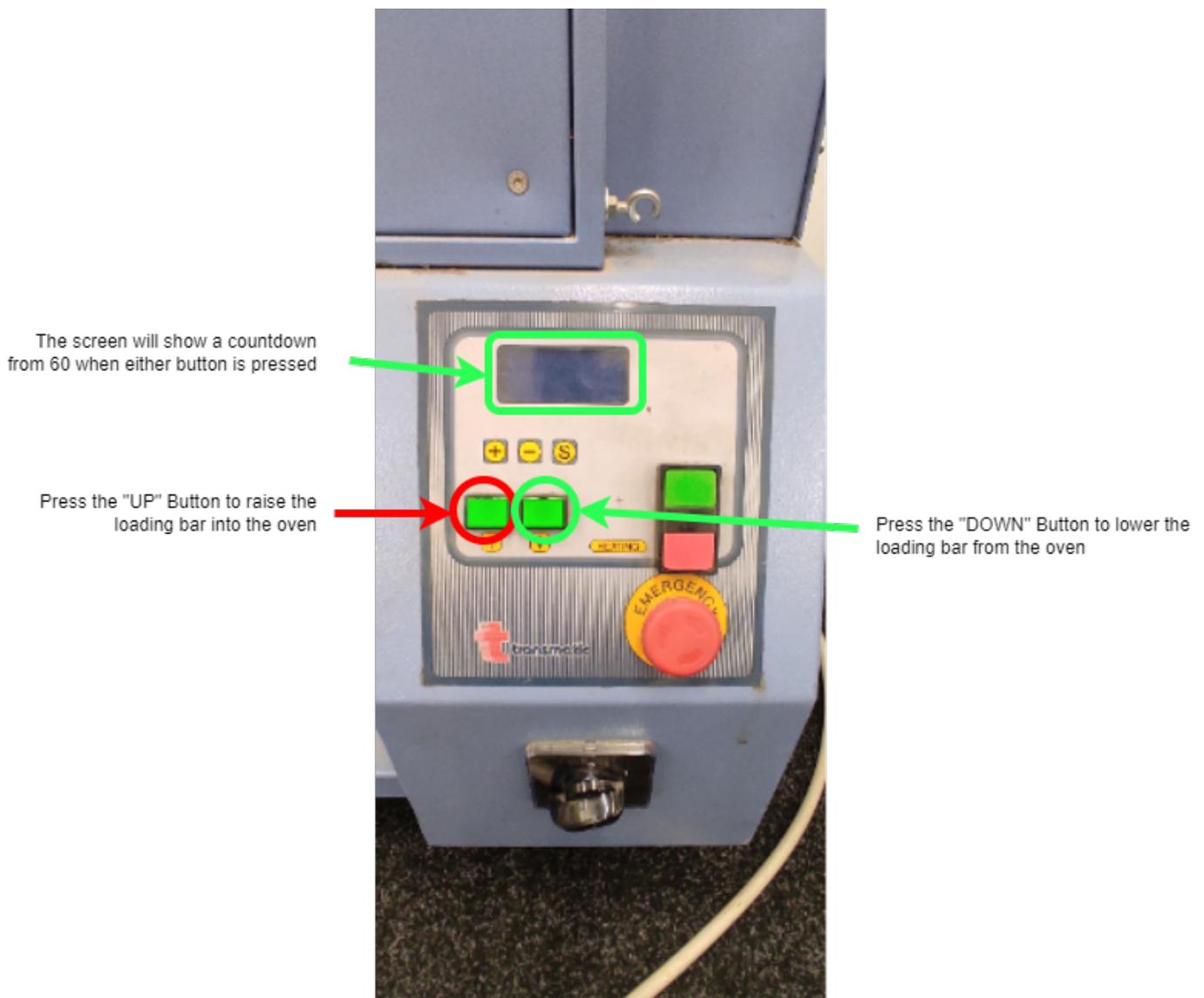
## 2. Changing the Temperature

Hold the "S" button and press up and down to change the currently set temperature



Turn On the Extractor Unit

Lowering/Raising the Loading Bar Into the Oven



# Feeding the Material Through the Fixation Unit

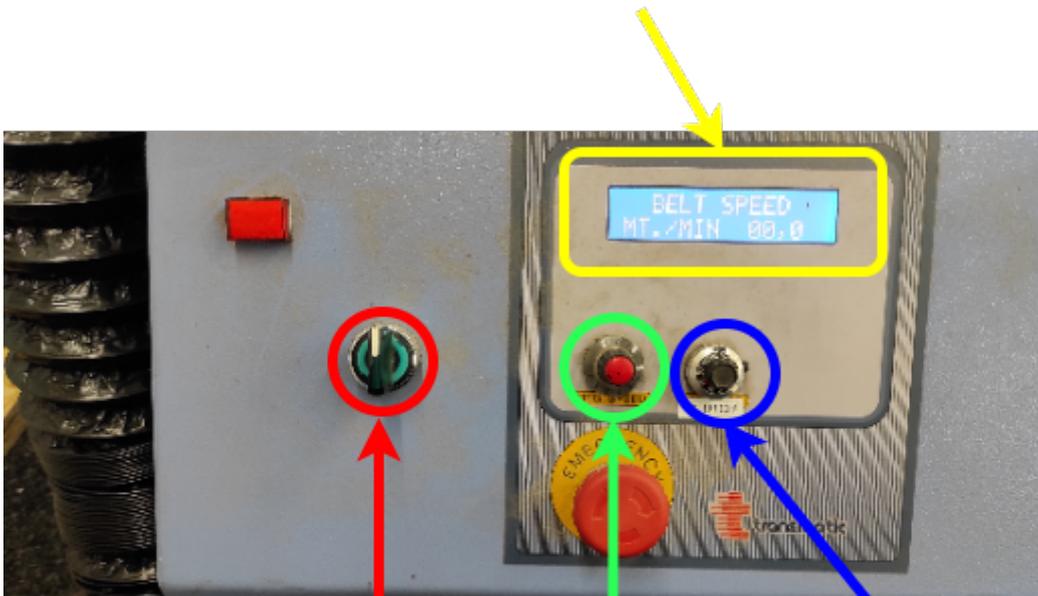
The diagram below shows the control panel for moving material through the Fixation Unit. This is located on the left hand side of the Fixation Unit.

## Process to start Fixating Fabric

1. Turn on the belt movement using the Green Switch (Highlighted in Red)
2. Use the red knob to set the speed you want the fabric to move through the Fixation Unit at (Highlighted in Green)
3. If the fabric is stopping half way through or is an inconsistent speed the acceleration needs increased (Highlighted in Blue)
4. If the fabric is pulling too quickly and is running uneven the acceleration is too fast.

**Normally the acceleration only needs to be changed if you are running a different fabric or trying to run at a very low speed. Otherwise keep it at 4.9.**

This is the speed at which material is going through the Fixation Unit



This is the on switch, turning this on will start the process of pulling the material through the Fixation unit

This is the acceleration at which material is sped up from starting

This is the speed at which the Material is pulled through the fixation unit

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