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# USER MANUAL

210704 -V1



## GO Xpress C-1200 / C-1700

It is of paramount importance that a certified electrician be responsible for performing any electrical work including connecting the Xpress units within the location where the calendar will be utilized.

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## 1. Introduction

Thank you for choosing our C-1220/C-1720 3-in-1 Heat Transfer Sublimation Rotary Calendars. To ensure the best quality and extended machine life please carefully read this manual.

Prior to using this calendar, please fill out the warranty card inside the operating manual and return to us.

## 2. Safety Notice

Before operating, please read the instructions carefully. Operator training is recommended, prior to use and is available from Graphics One. Please see Contact details at the end of these instructions. Please pay attention to the warning signs affixed to the equipment.

### 2.1 Safety Parts

#### 2.1.1 Emergency Switch

There are 2 emergency switches, pressing either of these will disconnect the power. The switch will release automatically by rotating clockwise. The device will only re-start by pressing the power switch on the main panel.

**NOTE:** Please regularly check the functionality of the Emergency switch.

#### 2.1.2 Heating Cylinder (Drum)

During heating, the surface temperature of the heating cylinder could be over 446°F/230°C. and it will alarm when the temperature exceeds 482°F/250°C. While it is heating, please do not touch the cylinder surface with any part of the body to avoid crushing or burning. When the machine is in use, an operator **MUST** be present at all times.

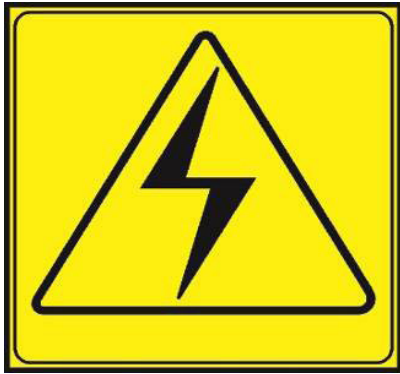
### 2.2 Warning Signs

Please follow all warning signs.



**Pinch point symbol**

(This sign is placed on the side frame of drum and blanket connection).



### High-voltage symbol

The symbol is inside the cabinet. Do not touch in case risk of electric shock.

The cabinet should not be opened while the unit is running electrically connected.



### Entanglement symbol

This symbol is inside the right body.

Please keep your hands, clothing and hair away from the sprocket when in use.



### High Temperature symbol

This is placed at the heating cylinder of cabinet.

Cylinder becomes very hot. Do not touch. After powering off, please allow to cool before touching the cylinder.

## 2.3 Safety Precautions

1. The main supply must match the required supply indicated on the machine identification label. And reliable ground connection shall be provided.
2. The max temperature is 482°F/250°C. The default temperature is 410°F/210°C. The alarm will sound when the maximum is reached.
3. The temperature of roller surface is very high during operation. Do not touch.
4. Before opening the machine doors to examine and maintain the equipment, the machine must be powered off to avoid electric shock or mechanical injury. Switch off the power when the transfer is finished.
5. Do not place the power cable on the walkway or stack goods on it.
6. Electrical components should be kept clean in order to avoid circuit damage. Never open the protective covering before disconnecting the power, do to risk of electric shock.
7. The workplace should be dry and ventilated. Please keep the equipment away from water or dampness. Do not store inflammables or explosives near the equipment.
8. Do not put tools, or other items, on the table or the surface of both stands to prevent damage to the cylinder.
9. Do not use water to wash the machine to avoid short circuit, electric shock, or corrosion.
10. The ambient temperature should be between 14°F/-10°C to 122°F/+50°C.

## 3. Unpacking



**Step 1:**  
Remove the top cover



**Step 2:**  
Pull down the wooden side covers

**Step 3:**

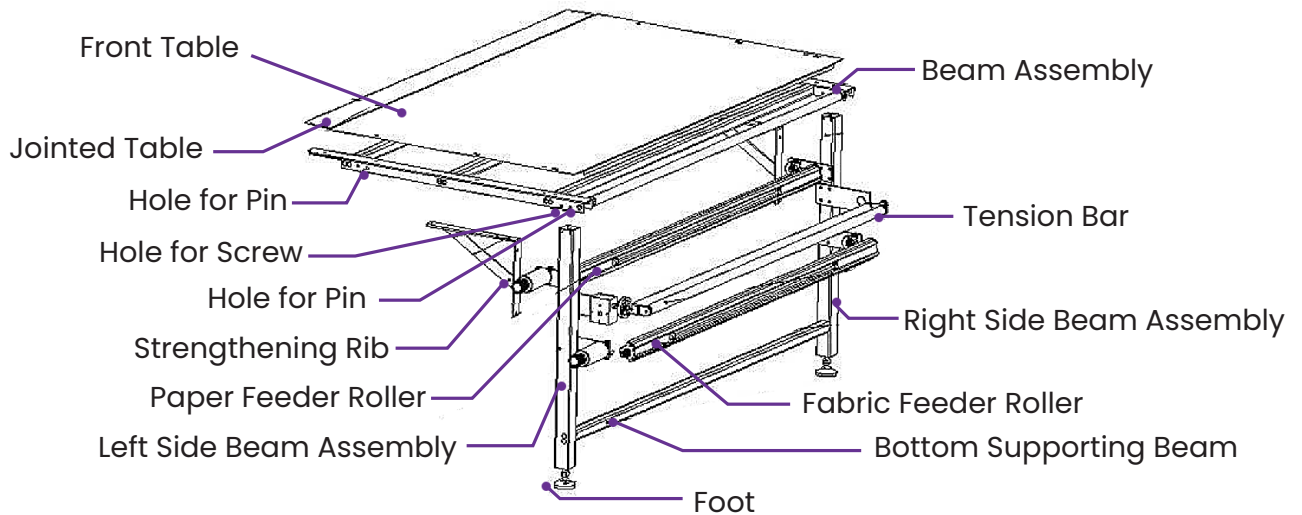
Loosen the screw between pallet and machine. Move the machine using a forklift.



**Caution:** When moving the machine by forklift, you must put the bottom frame of the machine on the forks and protect the machine on both sides. Be careful during moving to prevent falling.

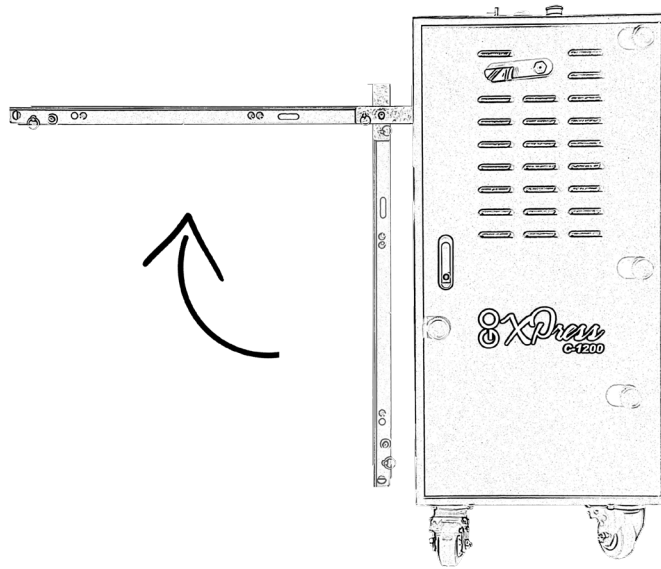
**Step 4:**

Table assembly





1. Rotate the beam assembly to horizontal, then install the left-side beam assembly and right-side beam assembly with screws and pins.



2. Join the right-side beam assembly and left-side beam assembly with the bottom supporting beam, adjust the feet to level the beam and install the strengthening rib.

3. Install the paper feed roller, fabric feed roller, and tension bar.

4. Install the jointed table and front table.



#### 4. Technical Specification

##### GO Xpress C-1200

##### ANSI

<b>Width</b>	1,2 Meter	47 Inches
<b>Speed</b>	0-1.3 m / min	0-90.6 in/min
<b>Belt Size</b>	Ø 1794mm x1300 mm x 8mm thk	Ø 72 in x 51 in x 0.2 in thk
<b>Thermal Media</b>	Electricity	
<b>Temperature</b>	0-230°C	0-446°F
<b>Power</b>	7 K	
<b>Power Supply</b>	Single Phase, 220V	
<b>Current</b>	32A	
<b>Motor Power</b>	200W	
<b>Machine Size</b>	1821 (L) x 1856 (D) x 1234 (H)mm	71.7(L) x 73.1 (D)x 48.6 (H) in
<b>E-Stop</b>	2	
<b>Weight</b>	500 Kg	1102.31 Lbs

##### GO Xpress C-1700

##### ANSI

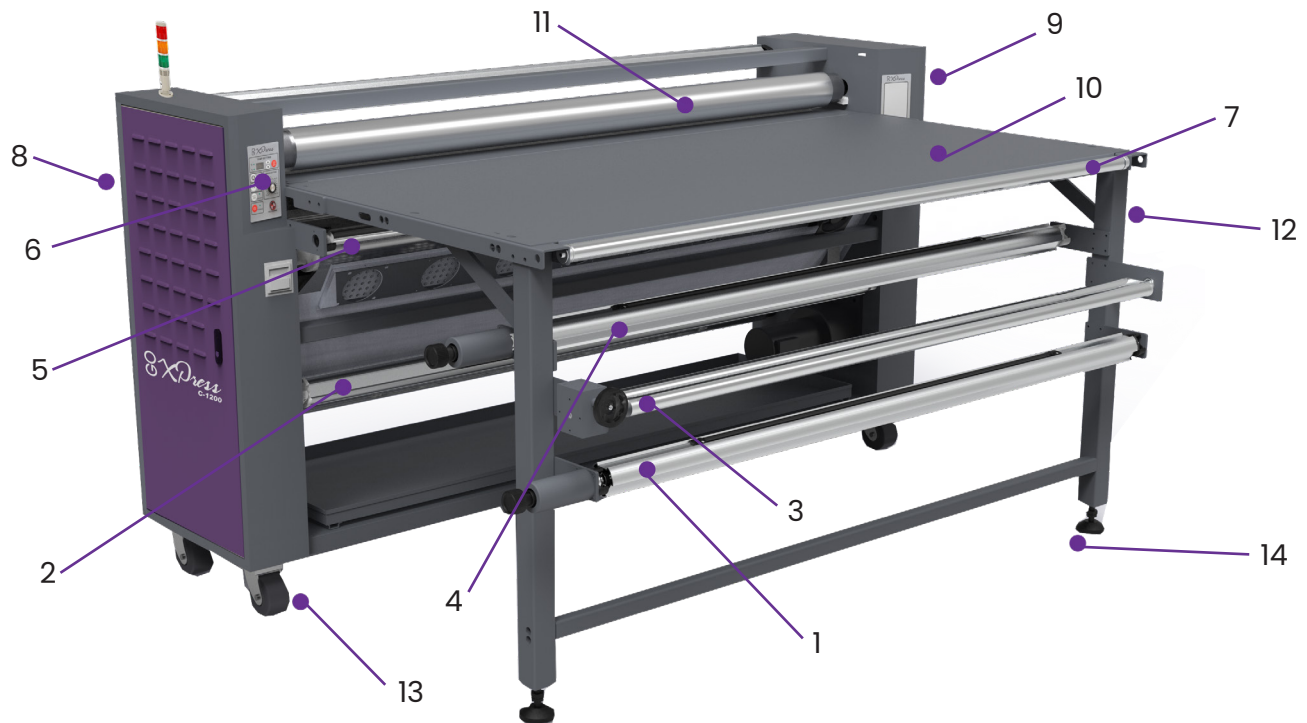
<b>Width</b>	1,7 Meter	67 Inches
<b>Speed</b>	0-1.3 m / min	0-90.6 in/min
<b>Belt Size</b>	Ø 1794mm x1800 mm x 8mm thk	Ø 70.6 in x 70.8in x 0.3 in thk
<b>Thermal Media</b>	Electricity	
<b>Temperature</b>	0-230°C	0-446°C
<b>Power</b>	7 K	
<b>Power Supply</b>	Single Phase, 220 V	
<b>Current</b>	32A	
<b>Motor Power</b>	400W	
<b>Machine Size</b>	1821 (L) x 2356 (D) x 1234 (H)mm	71.7(L) x 92.8 (D)x 48.6 (H) in
<b>E-Stop</b>	2	
<b>Weight</b>	700 Kg	1543.24 Lbs

**NOTE:** The power supply for the C-1200 is Single phase, 220V, 32A. The power cable is 0.23622 in/6mm 2×3.

The power supply for the C-1700P T2B is Single phase, 220V, 32A. Power cable is 0.23622 in/6mm 2×3.

## 5. Definition of whole machine

### 5.1 Front View



- |    |                    |     |                  |
|----|--------------------|-----|------------------|
| 1. | Fabric Feed        | 7.  | Table Idler Bar  |
| 2. | Paper Take-up      | 8.  | Left Side Cover  |
| 3. | Tension for Fabric | 9.  | Right Side Cover |
| 4. | Print Feed         | 10. | Feeding Table    |
| 5. | Paper Idler bar    | 11. | Conveyor Roller  |
| 6. | Control Panel      | 12. | Stand            |
|    |                    | 13. | Castor           |

14. Adjustable foot

#### 5.1.2 Notes

##### Functional Rollers

The machine is equipped with 6 rollers, 3 feed rollers which are: – Tissue paper, Print feed a Fabric feed; another 3 Take-up rollers which are: – Tissue paper, Waste paper and Fabric. There are 4 tension knobs on the right frame and another 2 on the feeding table. Increase the tension by rotating clockwise and decrease tension anti-clockwise. Please adjust the tension based to improve transfer quality.

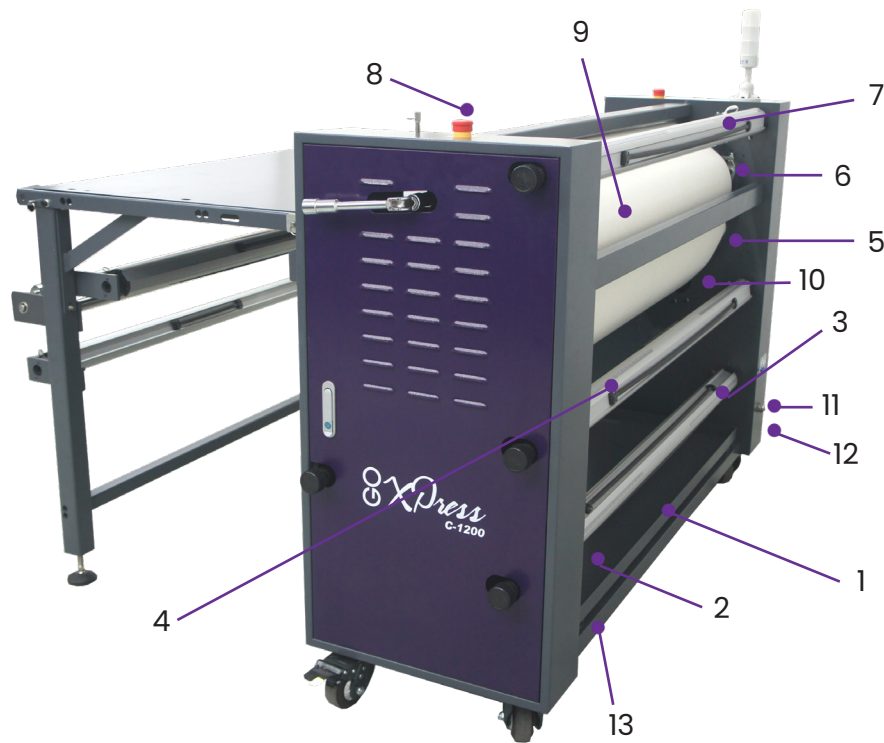
##### Castors

The wheels are  $\varnothing$  3.93701 in / 100 mm with brake; these are only used for moving short distances or adjustment.

##### Adjustable Feet

There are two M16×100 feet, to level the table adjust the foot height.

## 5.2 Rear view



- |    |                      |     |                      |
|----|----------------------|-----|----------------------|
| 1. | Drawer Collection    | 8.  | Emergency Stop       |
| 2. | Main Motor           | 9.  | Felt                 |
| 3. | Fabric Rewind        | 10. | Felt Adjustment Roll |
| 4. | Tissue Paper Rewind  | 11. | Circuit breaker      |
| 5. | Heating Drum         | 12. | Power connection     |
| 6. | Blanket Support Roll | 13. | Pallet               |
| 7. | Tissue Paper Unwind  |     |                      |

### 5.2.1 Notes

#### Power connection

Connect the main power cable, switch on the circuit breaker, reset the E-stop, then power on the machine from the control panel. Select direction of F (Forward) or R (Reverse), and turn the motor on, adjust the speed to the recommended value, and wait for the machine to reach the desired temperature.

#### Emergency Switch

In emergency, press stop button to power off the machine. The roller will stop rolling. In order to restart the machine turn the emergency button clockwise and it will return to normal position. To restart the roller, press the switch button on the control panel.

## Felt

The felt is a very important component on the machine. Please follow instructions carefully to ensure extended life.

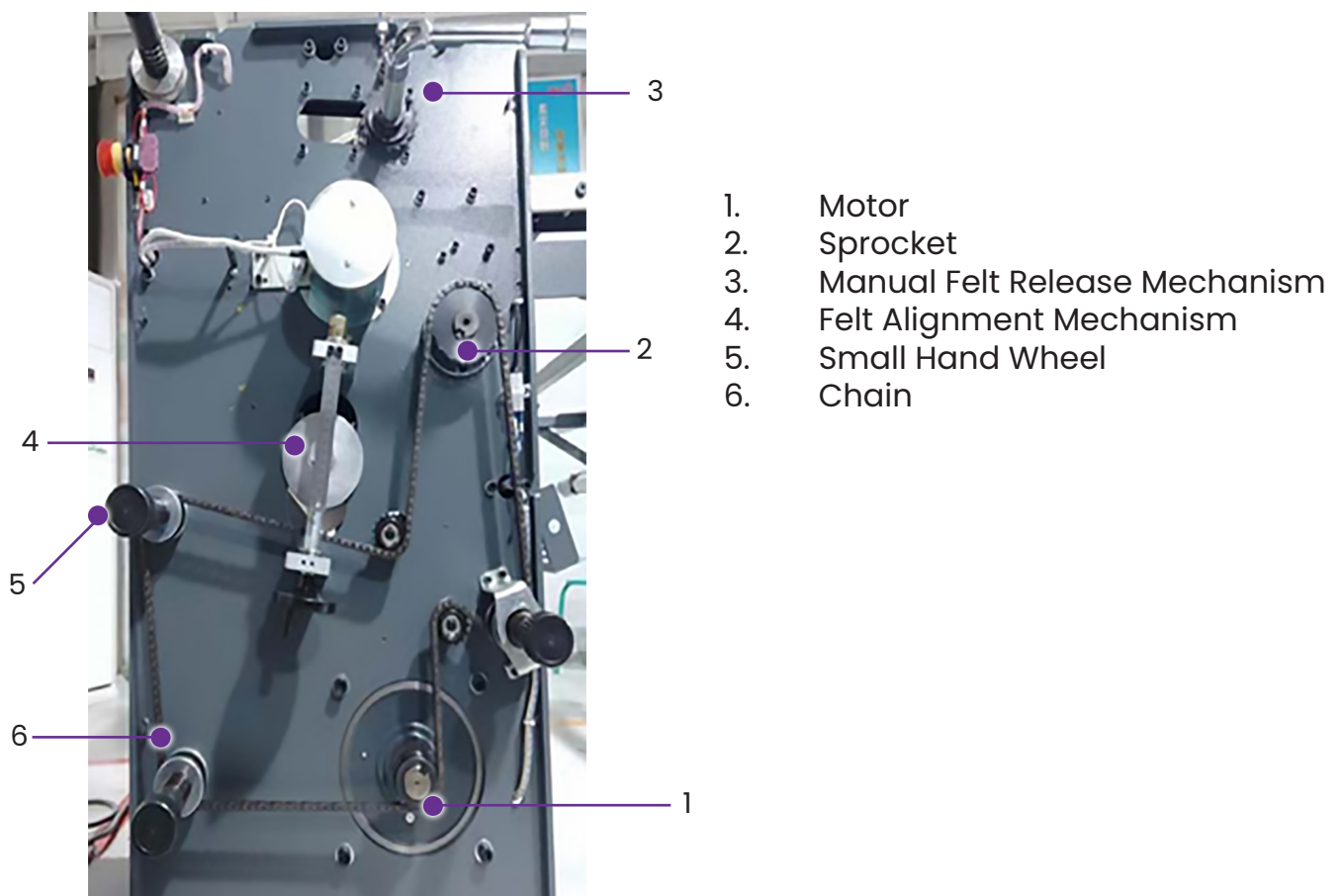
**The felt (belt) MUST be always running while the machine is hot.**

The machine can be shut down only when the temperature drops below 80°C or the felt will be damaged.

## Thermal Drum

Before every use, make sure the drum is clean. Do not use chemical or abrasive cleaners and do not allow object to touch the drum mechanism to ensure the drum is not damaged.

### 5.3 Layout of Right Enclosure



#### 5.3.1 Notes

##### Alignment Mechanism

This is used to adjust the felt to the right or left and adjust tension. Use the bar to rotate down if the felt is loose and move it up if you want to decrease the tension. Do not adjust during use and do not make any unnecessary adjustments.

## Manual Felt Alignment Adjustment

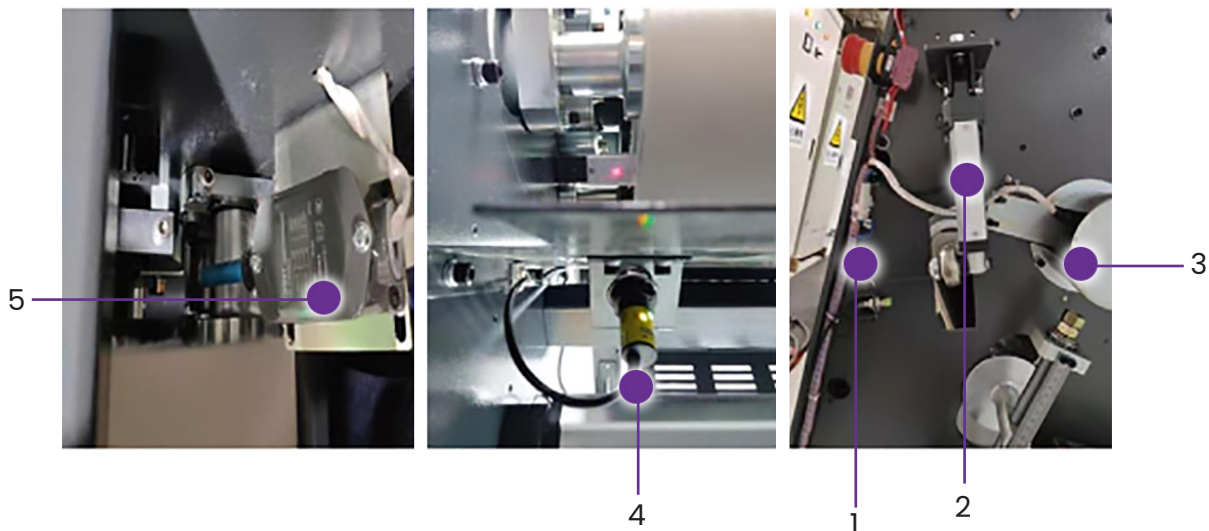
After the equipment ages, it may cause the blanket to deform (stretch), resulting in decreased quality of transfer. At this time you can adjust the alignment manually. Make sure both sides are adjusted at the same time (tight or relaxed). It may be necessary to adjust one side more than the other.

Adjustment Guide: If the blanket moves to the left, it indicates that the left end is loose, rotate the left-hand wheel after the blanket is released, until the left side of the blanket belt is tight. On the other hand, do the same if the right is loose. (Refer to steel gauge values while adjusting, please move 5mm each time you adjust).

## Auto Felt Alignment

The machine is equipped with an automatic felt alignment system, where the machine will block the photocell when the blanket deviates to the left / right. This will trigger the electric push rod to drive the correction roller in the appropriate direction, forming an offset angle between the correction roll and the blanket. A linear sensor detects the distance from which the electric push rod moves to stop automatically (this value has been set when it leaves the factory and can not be changed). When the alignment time is reached (the value D-2, refer to instructions), the push rod automatically returns to its initial position.

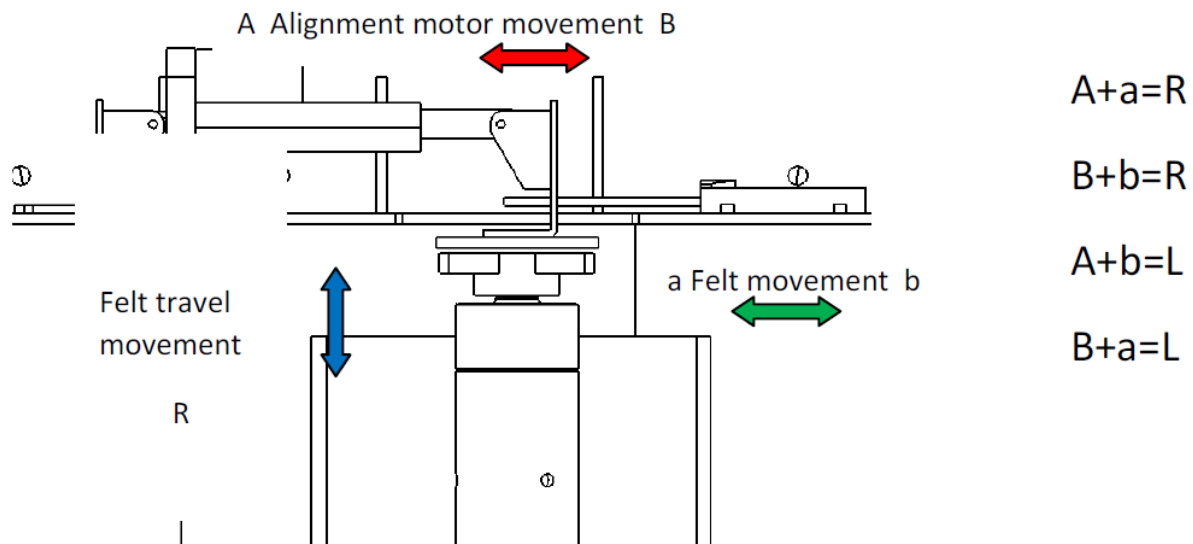
If the photocell is damaged or other reasons cause deviation correction failure, the blanket will touch the limit switch, the alarm at the top of the machine will display a red light and the buzzer will make an alarm sound to the operator; At that time, the blanket must be released and the belt should be manually adjusted.



1. Linear Sensor
2. Alignment Rod
3. Alignment Motor

4. Felt Edge Reading Sensor
5. Limit Switch

## Alignment Motor Movement and Felt Alignment Layout



### Working Steps

1. After powering on, the blanket moves left for 15 seconds and then returns to the middle position (reading switch).
2. Once the left photocell is blocked, the push rod (retracts) moves the blanket to the right. After the left photocell is cleared, the push rod is powered off and remains at setting time D-2, and the push rod returns to the middle position.
3. Once the right photocell is blocked, the push rod (retracts) moves the blanket to the left. After the right photocell is cleared, the push rod is powered off and remain setting time D-2, and the push rod returns to the middle position.
4. M button to switch the internal parameter display value.

D-1: Test alignment manually.

“+” alignment motor moves arm back and the felt will move right.

“-” alignment motor moves out and the felt will move to the left.

D-2: Alignment motor delay time. 1 unit = 10 seconds.

D-3: N/A Empty

D-4: Alignment motor movement instruction.

0 = Stop

1 = Felt Move to Left

2 = Felt Move to Right

D-5: Photocell state:

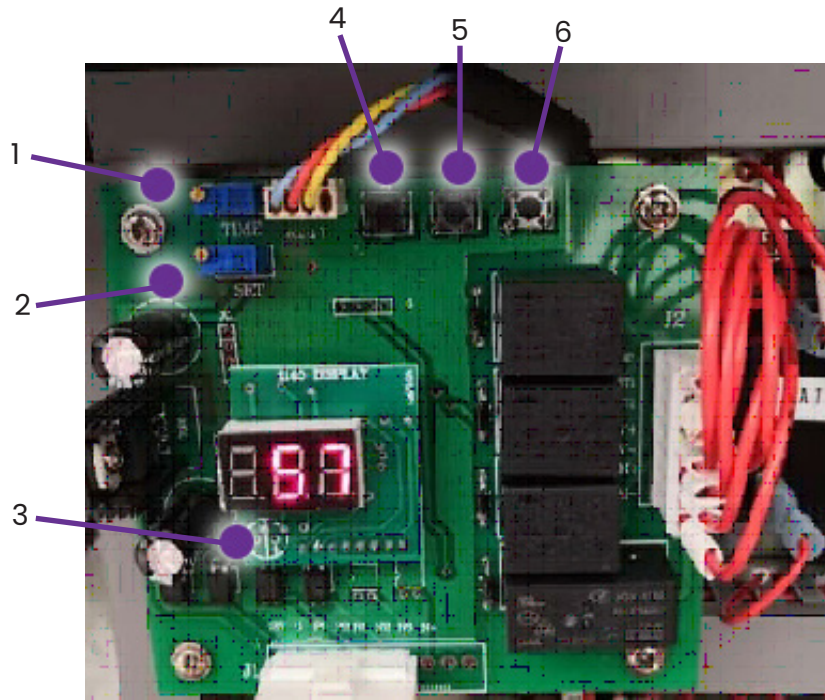
0 = No block

1 = Left photocell blocked

2 = Right photocell blocked

3 = Left and Right photocells blocked.





- |                          |               |
|--------------------------|---------------|
| 1. " TIME" Potentiometer | 4. "M" Button |
| 2. "SET" Potentiometer   | 5. "+"        |
| 3. Display               | 6. "-"        |

### Small Hand Wheel

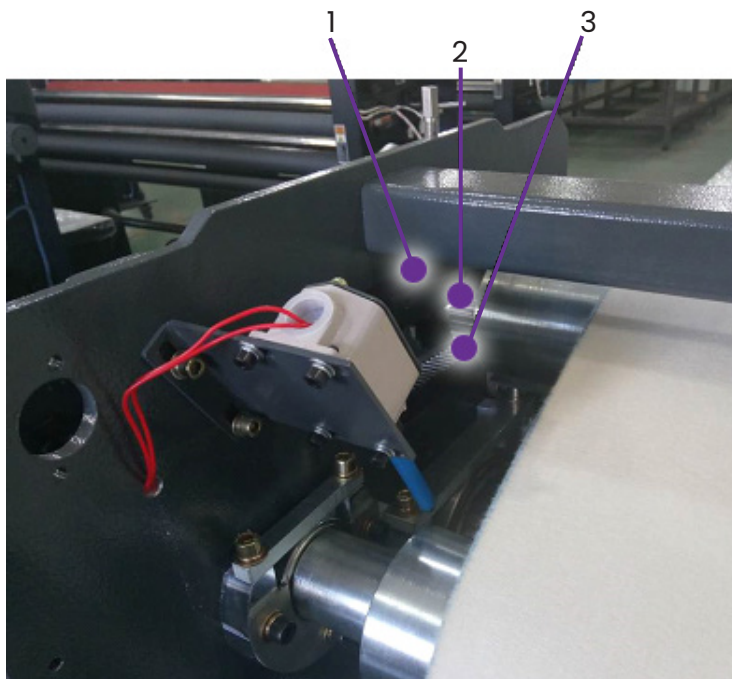
This is used for felt alignment, rotating will adjust the felt tracking on the drum. Use when the felt is loose.

### Manual Felt- On/Off

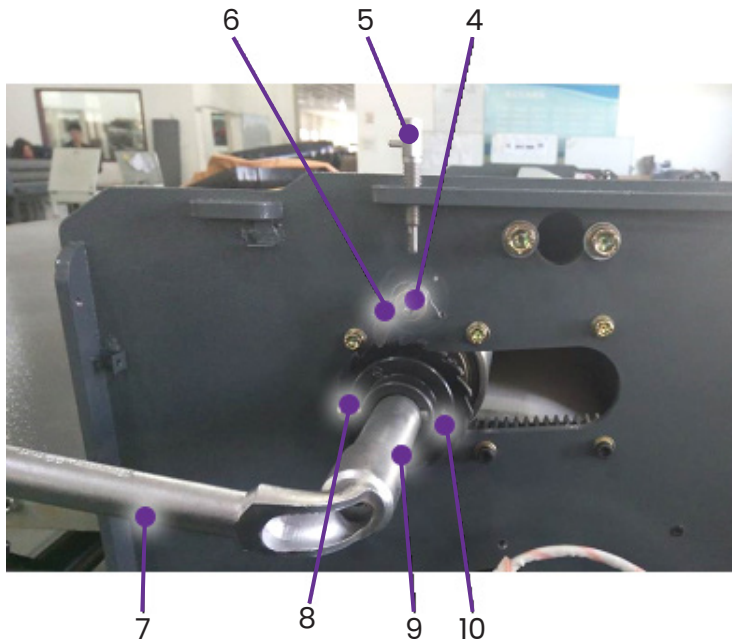
Before transferring, you can set the felt tension to a suitable level. During transfer do not adjust the tension, just set the appropriate pressure for use. If the felt travels to either left or right while working, just release it and put the felt into center and lock to continue.

**Note:** When the equipment is shipped out of the factory, the blanket tension position has been set correctly, the blanket is run for more than 20 hours at high temperature setting. You should not adjust the blanket tension after installation. If the blanket moves to the side, be sure to manually adjust the blanket to the middle position so that the blanket can be protected and extend its working life.

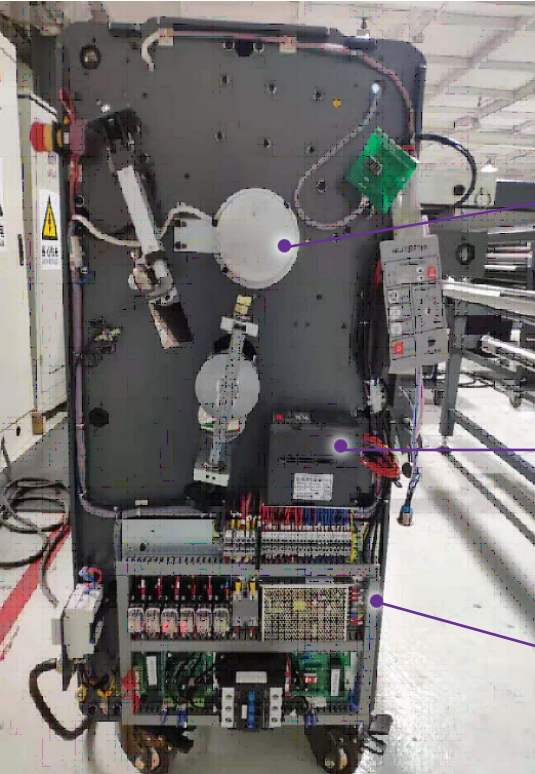




1. Gear Way
2. Gear
3. Fixed Gear Way
4. Bolt and washer
5. Quick Disconnect
6. Pawl
7. Wrench
8. Ratchet Wheel
9. Expanded Shaft
10. Fixed Plate for Ratchet Wheel



5.4 Contents of Left Case



- 1. IR Heater
- 2. Inverter
- 3. Electric Panel

## 5.5 Control Panel



### 1. Power On/Off Switch:

Main power control button, the green light on means the machine power is connected; switching it off disconnects the main power and the machine will stop. **Ensure that the machine temp is less than 176°F/80°C and blanket is off before you switch the machine off.**

### 2. Cooling Fan Switch:

The fan will cool down the transfer artwork to avoid 'ghosting' if the fabric surface is too hot. It must be on during transfer for the best quality transfer.

### 3. F/R Button:

F means forward, R means reverse.

### 4. Motor On/Off:

Controls the main motor on and off

### 5. Speed Potentiometer:

The range is 0-8.2 feet / 0-2.5m per minute, but we suggest setting 3.2-4.92 feet / 1-1.5m per minute for better finishing quality.

### 6. Temp Indicator:

Display the real heating temp, you can select Celsius or Fahrenheit

### 7. Temp Up/Down:

Increase or decrease setting temp

### 8. Heater On/Off:

Switch heater on or off.

### 9. Timer on/off Switch:

Power on the timer function

## 5.6 Timer Control



### Manual mode (Timer Button Released, Timer Indicator Light Off)

1. When powering on the machine, turn on the POWER button, press the HEATER button, the machine will work normally.
2. When powering off the machine, turn off the HEATER button and POWER button, the machine will stop heating and the blanket will keep moving and cooling. After 120 minutes, the blanket will be released, power off CIRCUIT BREAKER and the motor will stop.
3. If the blanket touches the limit switch, release the blanket immediately, power off main power, and the motor will stop working. Do not perform timing boot.

### Timer Mode (Press Timer button, Timer indicator light on)

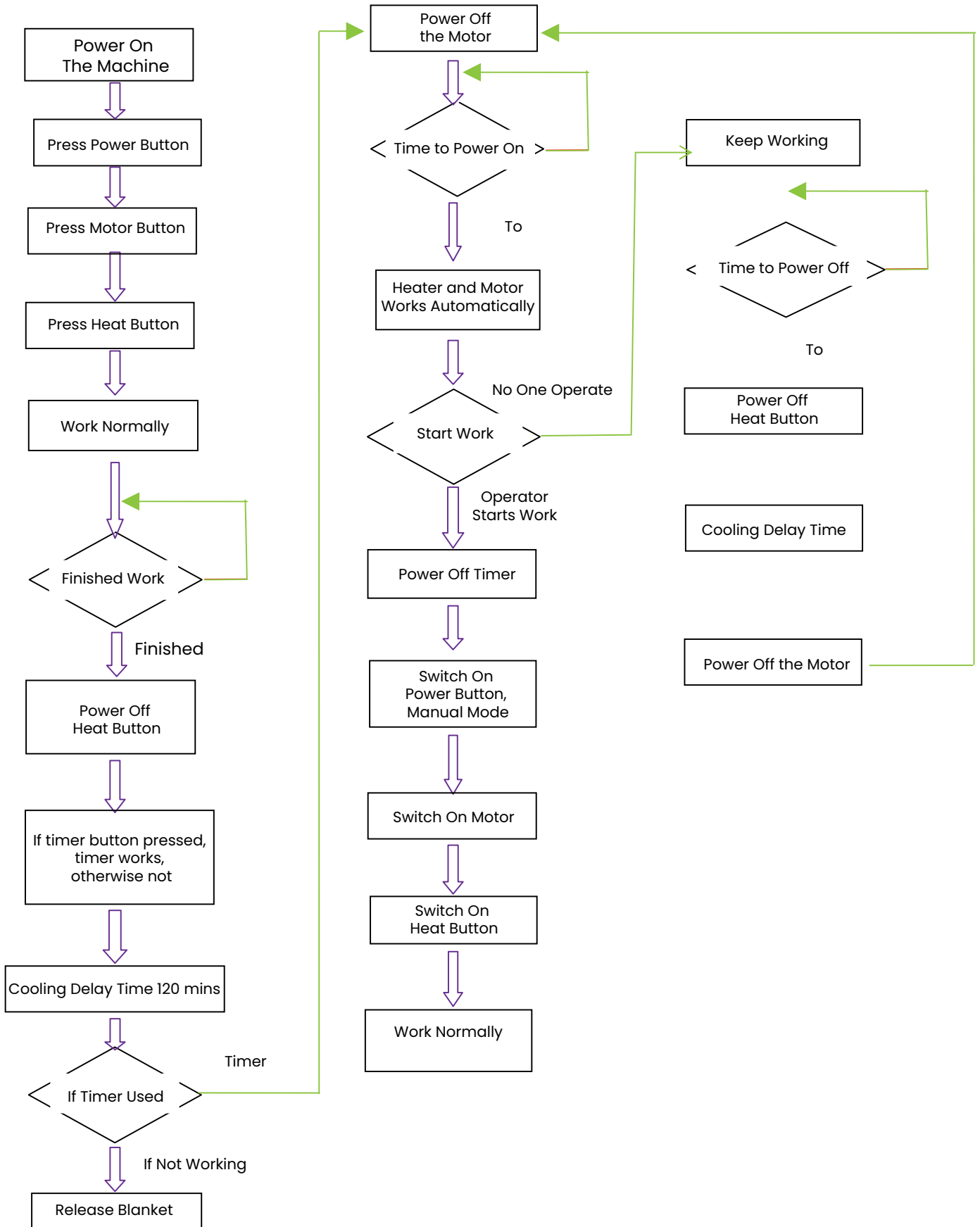
If the power button is pushed, the machine works in timer mode. The machine will power on and off according to the set time. T1 ON = set time power on machine; T1 OFF = setting time power off machine. Releasing the timing button will cancel the timer function.

For example,

If the operator starts work at 9:00 tomorrow and the machine needs 2 hours to heat up to 392°F/200°C. The timer can be set as follows: TIME-ON 1=7:00, TIME OFF 1=10:00. Then after work today, power off the HEAT button and POWER button, push the TIMER button on. (Power off machine normally, start timer)

The machine will work as follows with the above settings:

1. The machine will stop heating and the blanket keeps moving and cooling. After 120 minutes, do not release the blanket, main power off and motor stops.
2. The next day the machine starts to heat up at 7:00 AM and the motor works automatically. The Operator starts work at 9:00 AM, pushes the POWER button, release the timer button and changes to the manual model.
3. If the operator does not start work the next day, the machine will be power on automatically at 7:00 AM and power off at 10:00 AM automatically (the machine stops heating, the blanket keep moving and cooling. after 120 minutes, the blanket does not release. The main power turns off and the motor stops)



## 5.7 Timer Delay Motor-Off function : ( Main Control Board D-5 Setting Time)

The HEATING button is turned off and the MOTOR button is NOT turned off, the machine will automatically cool down, and the motor will automatically stop after cooling.

1. The counter will start once the machine heater is powered off, once the delay time is reached, the motor will stop running. (D5 range 60-180 minutes, default 120 min)

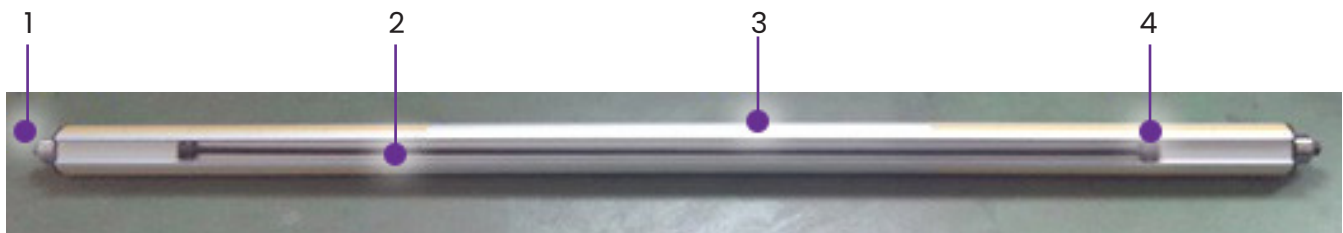
2. Reading temperature is less than 50 degrees for 2 minutes The motor will stop running if these two conditions meet either one Light Indicator description:

Green Light - Motor Running

Yellow Light - Warming Up

Red Light - Blanket Running Touch Limit Switch, Buzzer Alarm.

## 5.8 Functional Shaft



1. Bearing  
2. Rubber Strip

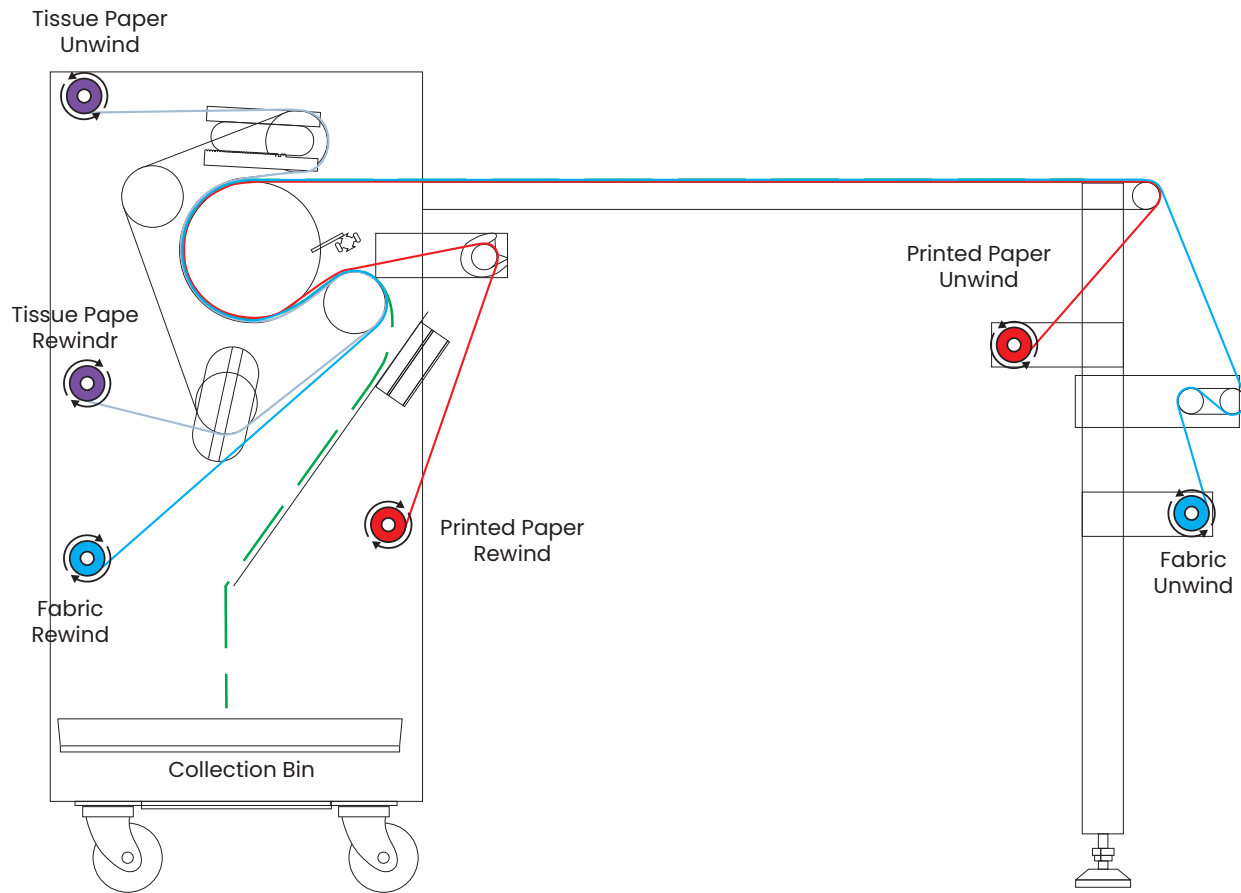
3. Aluminum Shaft  
4. Scale Mark

The tissue paper feed, print feed, fabric feed, tissue paper take-up, wastepaper take-up, finished fabric take-up, all have the same design as shown in the above picture.

All feed shafts have no chain driven, and all take-ups are driven by a motor, and they all have a tension knob for adjustment.

When putting loading, insert one side into the holder first and then locate the other side into the holder, finally put the pin into the front hole to lock.





## 6. Feed Diagram.

## 7. Operating Procedure

1. Before switching on the machine, make sure that all electrical wires are connected correctly. The body of the machine must be connected to ground.
2. Keep the blanket and roller clean. The belt cannot be too tight. Feel the tension by touching the belt with your palm. The belt should be firm.
3. Press the MAIN POWER switch and HEATER switch. Set up the speed.
4. Test with a small piece of printed transfer paper and substrate. Adjust the temperature according to the test result of the transfer to ensure the quality of final job.
5. Place the printed transfer paper and fabric on the correct rollers (to prevent the contamination of the blanket). Feed on the belt evenly. The printed image is up and adjacent to the fabric.
6. Use the take-up (Rewind) roller when the transfer paper is long enough. Adjust the tension by turning the tension knob.
7. Keep objects from falling into and damaging the drum. Keep clean and tidy. During operation, the operator must be present to avoid blanket deviation and other accidents.
8. Print color can be adjusted by adjusting the temperature up or down or can be controlled by adjusting the speed of the drum.
9. When the transfer is ended, press HEATING button off and the machine will stop when it cools down to 80°C.
10. The equipment should be maintained and checked regularly.



## 8. Installation and Use

1. Check the packaging for damage before unpacking.
2. Check the accessories according to the packing list.
3. There should be enough room for installing the equipment. The working environment should be clean, and the machine installed on level ground.
4. Before using, clean the surface of heat roller, the other drive roller and blankets. The heating roller surface is coated by a special process, avoid cleaning with corrosive liquid and abrasives.
5. When operating, if the blanket is adjusted incorrectly, it will deviate on the rollers. Turn the knob to reset the position of blanket.
6. The rollers and bearing may expand and create noise when they are hot. Do not worry as it is normal.
7. Keep clean and tidy so that there is no dirt falling into electric circuit box and transducer. Do not open the protective cover of the transformer to avoid electric shock.
8. Do not replace parts yourself without consulting the service engineers of our company who sold the unit. The parts must be provided or approved by this company.
9. DO NOT put heavy items on the feed table.
10. When using a forklift to move the machine, protect it from damage and tipping.

## 9. Device Maintenance

### 9.1 Daily Maintenance

No.	Item		Solution
1	Switches and Lights		Repair/replace if broken
2	Heating Problem	1. Incorrect Voltage	Check power
		2. Loose Connections	Check the circuit
3	Temperature Uncontrolled	1. Solid Relay Broken	Replace relay
		2. Temperature Controller Damage	Replace temp. controller
4	Drum not rotating	1. Blanket too Loose	Tension the blanket
		2. Sprocket slipping	Tighten the screws
		3. Bearing Stuck	Replace bearing
		4. Inverter Damage	Replacement
		5. Motor or Gear Box Damage	Replacement

## 9.2 Regular Maintenance

No.	Item		Solution
1	Heating Problem	1. One or more heating element defective	Replacement
		2. Thermal oil aging	Replacement
2	Drive roller maintenance		Keep clean. Clean the surface with water or alcohol.
3	Due to the high usage, blanket damage. Blanket is too loose to tension		Replacement
4	Check electrical connections		Adjustment
5	Check for any loose fasteners (screws/ nuts) through vibration.		Adjustment

## 9.3 Trouble Shooting

Phenomenon	Cause	Solution
1. Power Off	1. Faulty Supply 2. Circuit Breaker Open 3. Transformer Damage 4. Switch Damage	* Replace Spare Parts * Replace Spare Parts * Replace Spare Parts * Replace Spare Parts
2. No Light When Turning On Machine	1. Supply voltage does not match the machine voltage 2. Emergency-Stop switch is locked 3. Power fuse is not installed or has been damaged	* Check the voltage of supply and machine * Unlock E-Stop switch * Check if fuse damage
3. Power On, But No Heat	Heating rod damaged causing a short circuit	* Check and replace heating rod
4. Motor Rotates But Cannot Adjust Speed	Potentiometer damage	* Replacement
5., Drive Roller Runs Abnormal	Chain is loose	* Adjust chain

Contact Us