

**UNINET ICOLOR**

# IColor™ enduraPRESS SD20 Heat Press User Manual



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November 2021 Edition – A newer version of this manual may be available at [www.icolorprint.com/support](http://www.icolorprint.com/support)

# Specifications



Model NO: ENDURAPRESS SD20  
Voltage: 120V/60Hz Power: 15.5A, 1700W  
Control Panel: LCD Control Panel Time  
Range: 0~999sec.  
Temp. Range: 0~480°F  
Max Open Height: 0.5"  
Packaging: Double-walled Corrugated Paper Carton  
Gross Weight: 126lbs (57kg)



Power Switch



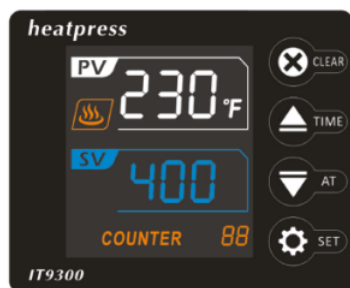
Breaker

# Operation Instructions

## Read Before Use

1. Check the voltage before using. The correct voltage is 110-120V/60Hz.
2. Turn off the machine when not in use, and remove the power plug from socket.
3. Grasp the handle firmly when opening.
4. Keep children away from the machine.
5. Do not touch the heating platen and platen cover while in operation or when hot.
6. Do not attempt to press products that are not intended for normal heat transfer.
7. Do not set the temperature any higher than 480 F as it may cause over heating and stop working.
8. The heat press carries a ground line by default, please make sure the socket gets a ground line protector.

# Control Panel Operations



**Control Panel Display**



**P-1: Temperature Setting Mode**

Hit SET & use the up and down arrows to set temperature



**P-2: Time Setting Mode**

Hit SET twice & use the up and down arrows to set amount of time for pressing



**P-3: °C or °F Read Out**

Hit SET three times & use the up and down arrows to select Celsius or Fahrenheit



**P-3: °C or °F Read Out**

Hit SET three times & use the up and down arrows to select Celsius or Fahrenheit



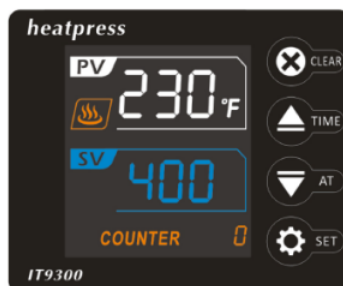
**P-4: Auto Shut Off Mode**

Hit SET four times & use the up and down arrows to set auto shut off when inactive 0-120 minutes range



**Auto Shut Off Mode**

The screen will read OFF and start to cool down if heat press is inactive  
To reheat the press, hit any button



**Clear Counter Number**

Long hold the CLEAR button to clear your counter on the panel.

## Other Functions



If you need to calibrate your press, hold the up and down arrow together for a few seconds.



If you need to clear your counter, hold your clear button for a few seconds.

# Temperature Display Calibration



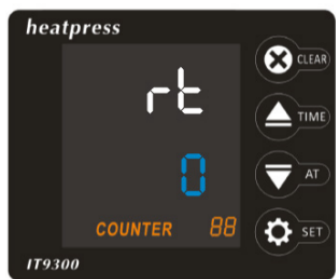
Touch the up and down arrow for a few seconds together.



Gauge enters into a window like above picture



Touch the up arrow till you hit 88.



Touch the SET key till you find a window like the picture above.



Touch the up and down arrow to determine the temperature will be modified. Say -30 (i.e. heating platen 30°F cooler than the gauge read-out)



Touch the SET key back to the temperature, and it will read out 200°F, and the press will continue to heat up to 230°F.



Touch the up and down arrow to determine the temperature will be modified. Say 30 (i.e. heating platen 30°F hotter than the gauge read-out)

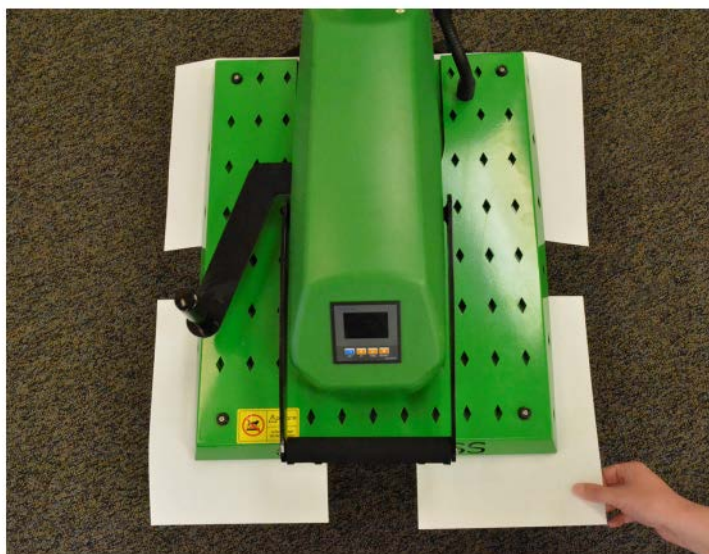


Touch the SET key back to the temperature, and it will read out 260°F, and the press will cool down to 230°F.

# Leveling the Bed

The SD20 comes with a mechanism designed to help ensure that the bed is perfectly level front-to-back and side-to-side. There are adjustable bolts under each corner that can be adjusted with an allen wrench to raise or lower the lower platen. In order to make the adjustment, you will need an 8mm allen wrench. Here are the steps:

1. Set the pressure to medium range.
2. Place four sheets of paper on the bed, one on each corner.
3. Close the press and try to pull the sheets free, one at a time.
4. If one or more of the sheets can be removed, or if there are varying levels of resistance, the bed is not perfectly level.
5. Use pliers to loosen the locking nuts. Then use the allen wrench to raise or lower the four corner bolts. Test again with the press closed on the four sheets of paper until resistance is even at all four corners.
6. Re-tighten the locking nuts to secure the bolts in their new position.
7. Turn the large central knob clockwise to lock in the new bed height.



# SD20 Support Brackets

There are two sets of brackets added to provide more support for the base.

This is intended to reduce the risk of the press becoming top-heavy and unstable.

If you experience any incidence of instability when the press is rotated at 180° away from the closed position, attach the bracket extensions to extend and secure the base of the heat press.



To extend brackets, first loosen the nuts indicated at left. Then slide the brackets out from the frame to the desired length. When you have extended the brackets, re-tighten the nuts to secure them.



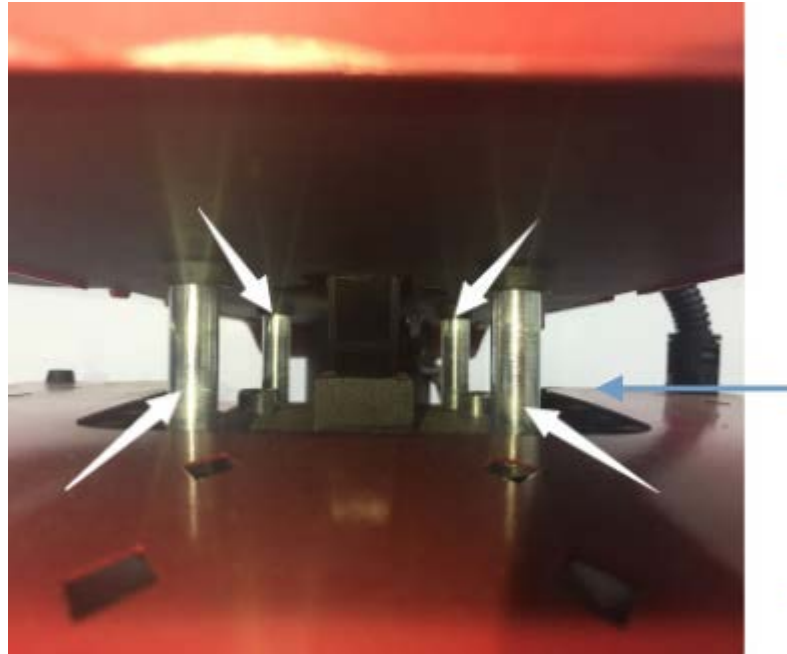
The brackets are height-adjustable. Simply turn the feet clockwise or counter-clockwise to extend or retract the feet and raise or lower the brackets. Adjust these to set the bracket height parallel to the table so that the entire base of the heat press is level and parallel with the work table.

Caution! Only use the heat press on a secure, stable work surface! Placing it on an unstable surface such as a folding or temporary table may degrade performance and cause risk of injury.



# Regular Maintenance

There are two points on the SD20 that should be lubricated regularly to maintain good performance. Use a standard lubricant such as WD40 or 3-in-1 oil. Use lubricating oil for regular maintenance for these 4 columns above the heating cover.



Use lubricating oil for regular maintenance for the swing-arm column.



# SD20 Optional Lower Platen

There are three optional lower platens compatible with the SD20. The normal platen that comes with the SD20 is a standard 16 inch by 20 inch platen. The optional lower platens provide smaller tables suitable for decorating small or oddly shaped objects. The optional platens are for shoes, sleeves and youth sized shirts.

- The Youth platen measures 12 by 14 inches. This smaller platen helps you thread small shirts without overstretching the fabric.
- The sleeve platen measures 5 by 18 inches. This platen can also be used for decorating sleeves and pant legs. This is a great option for those customizing like athletic wear such as yoga pants.
- The shoe platen measures 5 by 14 inches and is shaped to support the side of most shoes. Make sure you choose a heat transfer film compatible with the material from which the shoe surface is made.



Youth Platen



Shoe Platen



Sleeve/Leg Platen

## How to Change Lower Platens

**CAUTION:** Before attempting to change the platen, make sure the heat press is turned off and cooled to room temperature.

1. Under the standard platen, there are four bolts and a large central knob (See page 7).
2. Loosen the bed-leveling bolts, but do not remove them.
3. The large central knob is what fastens the platen to the press. Loosen the knob and remove the standard 16 x 20 base platen.
4. Once the platen is free, set it to the side.
5. Place the optional platen on the bed. Align the new platen with the central hole and the adjacent holes and use these to fasten the large central knob from the bottom.
6. When the platen is in position, tighten the large central knob to secure it to the bed.

# Troubleshooting Tips

Q. Why isn't my heat transfer vinyl sticking to the fabric?

A. This can be caused by three things. Insufficient pressure, or temperature, or time. Time: Some heat transfer films need a few seconds to cool before you remove the liner. Try a warm or cold peel first.

**Temperature:** If that doesn't work, check to make sure you are using the recommended time and temperature settings. If you are, your press may not be putting out the correct amount of heat. Use an IR thermometer to check the actual temperature of the platen.

If it is more than 5° different from the LCD display (PV), adjust it using step four in the control panel (see page 6).

**Pressure:** If the temperature is correct, adjust the pressure. Some films require more pressure to bond the adhesive to the fabric. There should be some resistance when you close the press. If you have verified all of these and the film doesn't stick, contact Technical Support for further assistance.

Q. Why does my sublimated transfer look washed out?

A. This is usually caused by insufficient temperature. Sublimation works best at or near 400°F. If your transfer is faded, check the output of the heat platen with a contact thermometer and make sure the output matches the displayed temperature. If not, adjust as directed above. Then repress at 390 - 400°F.

Q. Why are my transfers sticking to the heating element of the upper platen?

A. If T-shirt vinyl is sticking to the heating element, you have it upside down. Remove any adhesive residue, flip it over and try again. If an inkjet or laser transfer is sticking to the heating element, it's because the heat is affecting the ink. Cover it with a PTFE sheet or sheet of silicone Kraft paper to prevent this. Using a PTFE sheet or Kraft paper is recommended for almost all heat transfer applications.

Q. Why is it so hard to peel the liner when I'm done pressing the paper?

A. A hot or warm peel film may become hard to peel if allowed to cool. Always peel the film or transfer paper in accordance with the product's recommendations.

# Wiring Schematic

