



HS11 Operator's Manual



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Preface

Welcome to the growing group of Thermopatch customers. The product you have purchased has been carefully designed and manufactured to ensure that you will gain the maximum benefit.

All Thermopatch products are specifically designed to ensure ease of use with particular attention to safety requirements.

Should you discover any fault or damage upon receipt of this product, contact your local Thermopatch representative immediately.

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1. Introduction

The HS11 is designed as a heavy-duty heat-seal machine for applying patches, emblems, hot paper transfers and identification tapes. The sealing cycle is initiated by hand, which causes the sealing head to lower. Temperature, time and sealing pressure can all be individually adjusted as required for the particular materials being sealed. Upper and lower platen temperatures can be set independently in Fahrenheit or Celsius. A new LCD screen with a 3-button interface simplifies machine operation.

The machine develops 24 PSI inter-platen pressure with the standard 5" x 6" platens. Two optional smaller platens are available for even higher inter-platen pressure.

1.1 What Did You Receive?

HS11 Machine	Air Filter Pressure Regulator	Air Line Hose
Line Power Cord	Quick Start Guide	Instruction Manual CD

1.2 Machine Specifications

Electrical requirements	: 12 amp @ 120 VAC, 50/60Hz or
	6.0 Amp @ 240 VAC, 50/60Hz

Maximum operating air pressure: 70 PSI (4.8 Bar)

Time settings	: 1.0-30 seconds		
Heat range	: 150°-450°F (66°-232°C)		
Shipping weight	: 65 lbs (29.5 kg)		
Length (open) (closed)	: 20″ (51 cm) : 23″ (58 cm)		
Height	: 21″ (53 cm)		
Width	: 8″ (20 cm)		
Sealing iron size	: 5" x 6" (13 x 15 cm)		
Sealing pad size (standard) (optional) (optional)	: 5" x 6" (13 x 15 cm) 2" x 4" (5 x 10 cm) 1-3/16" x 4" (3 x 10 cm)		
Pedestal (optional)	: 32" (81 cm) high		
Garment tray (optional)	: 17" x 25" (43 x 64 cm)		

1.3 Safety Information

Each HS11 is equipped with a safety-lock feature for the protection of the operator. The pneumatic sealing cycle will not start until the upper sealing plate is within 5/32" (4 mm) of the lower sealing platen. If an obstruction is met before this point, the sealing cycle will not occur. **THE SAFETY LOCK FEATURE IS PRESET AND SHOULD NOT BE TAMPERED WITH**. In addition, there is a touch guard around the upper heater platen. Should any obstruction contact the touch guard, the machine will become inoperative. An error message will appear on the LCD screen.

Before operating, make sure all covers are in place and keep loose jewelry and clothing clear of machine during operation.

Two back-up high-limit thermostats prevent the temperature of either sealing iron from rising above 500°F (260°C) in case either heat control malfunctions.

1.4 Conditions of Warranty

Thermopatch Corporation, Syracuse, New York ("Seller") warrants this product to be free from defects in material and workmanship under normal use and service. Any part which proves to be defective in material or workmanship within one year of the date of original purpose for use will be repaired or replaced, at Seller's option, free of service or labor charges, with a new or functionally operative part. Seller's liability under the Warranty shall be limited to repairing or replacing at its own factory or through an authorized service distributor or dealer, material which is determined by Seller to have been defective in manufacture and upon which a claim has been made by the original purchaser or user to Seller (or an authorized distributor or dealer) within the warranty period. An authorized officer of Seller will honor claims under this Warranty only upon written approval. Approved return of parts or products will be on a prepaid transportation charges basis only. Claims under this Warranty will be honored only upon Seller's determination that the claim is covered by this Warranty, and Seller shall incur no obligation under this Warranty prior to such determination. This Warranty does not apply: (1) To any machinery or equipment which has been altered or repaired, except by Seller or its authorized representatives, or (2) to any machinery or equipment which has been subject to misuse, negligence or accident, including, without limitation, use and operation of such machinery or equipment while parts are loose, broken, out of order, or damaged by the elements. Parts replaced under this Warranty are warranted only through the remainder of the original Warranty. Any and all claims for warranty service must include such information as Seller designates, and shall include specifically the serial number of each unit (if appropriate).

The foregoing shall constitute the sole and exclusive remedy of any using purchaser and the sole and exclusive liability of Seller in connection with this product. THIS WARRANTY IS IN LIEU OF ALL OTHER WARRANTIES, EXPRESS, IMPLIED OR STATUTORY, INCLUDING BUT NOT LIMITED TO, ANY WARRANT OF MERCHANTABILITY OR FITNESS AND ALL OTHER OBLIGATIONS OR LIABILITIES OF SELLER, INCLUDING ANY TORT LIABILITY, FOR NEGLIGENT DESIGN OR MANUFACTURE OF THIS PRODUCT, OR OTHERWISE. It is expressly agreed that Buyer shall not be entitled to recover any incidental or consequential damages, as those terms are defined in the Uniform Commercial Code, and that Buyer shall have no right of rejection or of revocation of acceptance of any part or of the goods covered hereby.

1.5 Customer Service

Thermopatch Corporation's U.S. and International network of Sales Representatives, as well as its internal Customer Service Department, offer their assistance in the development of effective heat-seal mending, marking and identification programs.

Thermopatch markets a complete line of heat-seal and marking machines, as well as a complete line of materials and supplies.

Label Print Machines – Manual, automatic and computer controlled.

Marking Machines – High speed permanent imprinting of decorative or informative marks on most woven fabrics.

Heat-Seal Machines – Manual, semi-automatic and completely automatic, with high inter-platen pressure to assure excellent adhesion of label tapes and mending materials.

Label Tapes – Specially woven 100% cotton and blends with adhesives to match specific processing requirements.

The **Deco-Print** line of products has been specifically designed to offer alternative solutions to sewn-in labeling and other methods of decorative trimming. An assortment of heat-sealable applications are available including **hot paper transfers, screen printed transfers, direct printing, application equipment and supplies and digital printed transfers.**

When ordering machine parts, please include the model and serial numbers of your equipment.

United States	: Thermopatch Corporation P.O. Box 8007 Syracuse, New York 13217-8007 Telephone: 315-446-8110 Fax: 315-445-8046 Toll Free: 800-252-6555 (in the US only)	Netherlands	: Thermopatch BV P.O. Box 50052 1305 AB Almere Netherlands Telephone: 011-31-36-549-1111 Fax: 011-31-36-532-0398
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		Internet Address E-mail Address	: http://www.thermopatch.com : sales@thermopatch.com

1.6 Operating Specifications

Temperature: The HS11 heat-sealing machine will require approximately 10-15 minutes for the temperature to stabilize. Check the digital readout for upper and lower platen temperatures.

Time: Heat-sealing cycle time is factory set to 10.0 seconds. The sealing time can be changed as required to apply or remove a label.

To adjust time or temperature settings, press the MODE key and see "Menu Screens." To adjust sealing pressure, see section 2.1.

Sealing Pressure: Factory set at 60 PSI (4.1 Bar).

CAUTION: NEVER EXCEED 70 PSI (4.8 Bar) THE MAXIMUM OPERATING PRESSURE!

1.7 Setting Up The Machine

Worktable Mounting (Optional)

1. Set the machine on the worktable in the desired location.

2. Draw a pencil line on the table at the front edge of the machine, near the center.

3. Move the machine out of the way and measure back 2'' (5 cm) from the pencil line.

4. Drill a 9/32-inch (7 mm) diameter hole for a sheet metal table, or 3/16-inch (5 mm) diameter hole for a wood table.

5. Mount the wood screw or shoulder bolt.

6. Reposition the machine so the keyhole slot in the bottom cover (at the front) drops over the head of the screw.

7. Push the machine back slightly (Note: The purpose of this screw is to prevent the machine from bouncing or moving across the table).

Pedestal Mounting (Optional)

Mount using instructions provided with the pedestal.

Garment Tray (Optional)

The garment tray can be mounted so it is either level with the rubber platen, or reversed so it is about 5'' (13 cm) below.

1. Remove two screws from each side of the machine.

2. Place the garment tray in the desired position and attach with four screws.

Completing the Installation

1. Attach filter assembly to air inlet at rear of machine. Use pipe thread sealant or tape.

2. Hand tighten or tighten lightly with a pipe wrench on the short piece of pipe between the machine and air filter.

3. Plug the electrical power cord into a properly grounded outlet of the correct voltage/amperage rating.

2. Machine Operation

2. 1 Operating Instructions

1. Turn the "Power" switch to ON. The LED on the switch will light indicating power is being supplied.

2. Adjust upper and lower sealing temperatures as needed.

WARNING: THE HEATED PLATENS MAY REACH TEMPERATURES AS HIGH AS 450°F (232°C) DURING NORMAL OPERATION. APPROPRIATE CARE SHOULD BE TAKEN TO PREVENT SKIN BURNS. ALWAYS KEEP HANDS CLEAR OF HEATER PLATENS AND TOUCH GUARD WHEN OPERATING MACHINE!

3. Adjust pressure as needed. Turn the large black knob clockwise to increase air pressure, counterclockwise to decrease. Check air gauge and repeat as needed. **DO NOT EXCEED 70 PSI!**

2.2 Applying a Patch or Emblem (non-embroidered)

1. Set your desired sealing time by pressing the up or down keypads to the proper setting.

2. Center the work piece over the lower sealing pad.

3. Place the patch, emblem, etc. over the work piece with the adhesive side toward the fabric.

4. When hands are clear of the touch guard, grasp the upper sealing head handle and lower the sealing head.

5. As soon as the upper iron comes all the way down to the lower platen, the upper iron will automatically stay down to complete sealing. The digital display will show elapsed time for the sealing cycle. When it reaches the set seal time, the upper iron will automatically return to the upright position.

CAUTION: FOR BEST RESULTS, SEALED MATERIAL SHOULD BE HANDLED CAREFULLY UNTIL IT HAS COOLED TO ROOM TEMPERATURE.

2.3 Applying Embroidered Emblems

Embroidered emblems and emblems with embroidered borders (also called Merrowed borders) are special and usually should be sealed as follows:

See Section 5 "Maintenance" to remove the Teflon shield from the upper platen and to remove the sponge rubber pad from the lower platen.

1. Mount the Teflon shield to the lower platen and the sponge rubber pad to the upper platen.

2. Readjust the temperatures so the lower platen is at $410^{\circ}F$ (210°C) and the upper platen is at $375^{\circ}F$ (191°C).

3. Set pressure at 60 PSI (4.1 Bar) for the 5" x 6" (13 cm x 15 cm) platen.

4. Set at 12 seconds. This can be varied between 10 seconds (for light fabrics) and 14 seconds (for heavy fabrics).

5. Follow procedure for non-embroidered emblems, see section 2.2.

Due to the difficulty of getting heat through very thick garments, it may be necessary to increase the time setting.

2.4 Removing a Patch or Emblem

1. Set the sealing time to 5 seconds by pressing up or down on the keypads.

2. Place the work piece on the pad so the patch is centered.

3. Lower the upper platen until the sealing cycle begins.

4. When the upper iron releases, quickly peel the patch or emblem off the surface of the work piece.

5. If the patch cools before it is removed, repeat the procedure.

CAUTION: USE EXTREME CARE IN HANDLING THE FABRIC. IT WILL BE VERY HOT!

Part No.	Size	Material	Used for
42477	5" x 6"	Silicone sponge rubber	Apply mending patches, emblems, hot paper transfers and label tapes to garments and linens
42515	4" x 2"	Silicone sponge rubber (firm)	Apply smaller heat-seal products, or for higher sealing pressure than standard platen
42516	4" x 1- 3/16"	Silicone hard rubber (solid)	Smallest size applications, spot sealing, applying labels to confined areas such as trouser belt loops, where extremely high inter-platen pressure is required

2.5 Recommended Platens and Application

GAUGE AIR INTER-PLATEN PRESSURE							
PRE	SSURE	4247	77	425:	15	4251	.6
PSI	(Bar)	PSI (<u>Kg./cm²)</u>	PSI (Kg./cm ²)	PSI (<u>Kg./cm[*])</u>
<u>15</u>	(1.0)	5	(0.4)	19	(1.3)	32	(2.3)
20	(1.4)	7	(0.5)	26	(1.8)	43	(3.0)
<u>25</u>	(1.7)	8	(0.6)	32	(2.2)	54	(3.8)
30	(2.1)	10	(0.7)	38	(2.7)	64	(4.5)
35	(2.4)	12	(0.8)	45	(3.1)	75	(5.3)
40	(2.8)	14	(1.0)	51	(3.6)	86	(6.0)
45	(3.1)	15	(1.1)	57	(4.0)	97	(6.8)
50	(3.4)	17	(1.2)	64	(4.5)	107	(7.5)
55	(3.8)	19	(1.3)	70	(4.9)	118	(8.3)
60	(4.1)	20	(1.4)	76	(5.4)	129	(9.1)
65	(4.5)	22	(1.6)	83	(5.8)	140	(9.8)
70	(4.8)	24	(1,7)	89	(6.3)	150	(10.6)

2.6 Start-Up Screen

The HS11 heat-sealing machine is equipped with a LCD display. When machine power is switched on, the following start-up screens will show:

This screen appears after the heat platens reach the default or user-set

temperatures. The machine is now ready to seal. The upper and lower temperatures are shown at left, the time and daily count (DC)

UPPER=410F TIME 10.0 LOWER=375F DC=123456

at right. To change any of these, see the section "Menu Screens."

3. Menu Screens

The default settings can be changed as required. To advance a menu screen, press the MODE key. To change the value or select an option, press the up or down key. If no button is pressed for 8 seconds, the machine will exit the menu. The following menu screens will appear in sequence:

Screen 1 (Select Temperature Scale)

F/C SELECT SET=F UP=C DN=F MODE=NEXT

Appears when the MODE key is pressed 1 time. The current temperature scale is indicated in the upper right as an "F" for Fahrenheit or "C" for Celsius. Press the UP key for Celsius and DOWN key for Fahrenheit.

Screen 2 (Set Upper Platen Temperature)

SET UPPER TEMP=410F UP=+ DN=- MODE=NEXT

Appears when the MODE key is pressed 2 times. The upper platen temperature is displayed in the upper right. Press the UP and DOWN keys to adjust. The temperature can be changed in 2°F or 1°C increments.

Screen 3 (Set Lower Platen Temperature) SET LOWER TEMP=375F UP=+ DN=- MODE=NEXT

Appears when the MODE key is pressed 3 times. It operates like Screen 2, setting the temperature for the lower platen. The lower platen temperature is displayed in the upper right. The temperature can be changed in 2°F or 1°C increments.

Screen 4 (Set Seal Time) SET SEAL TIME-10.0 UP=+ DN=- MODE=NEXT

Appears when the MODE key is pressed 4 times. The seal time is shown in the upper right hand corner. The seal time can be changed in 0.1 second increments from 1.0 to 30.0 seconds. Press the UP and DOWN keys to adjust.

Screen 5 (Reset Daily Count) DAILY COUNT=123456 DN=RESET MODE=NEXT

Appears when the MODE key is pressed 5 times. The daily counter, displayed at upper right, is the number of seals since the counter was last reset. To reset, press the DOWN key, then the MODE key to advance to screen 6. To continue without resetting the counter, simply press the MODE key to advance.

Screen 6 (Information and Exit) TOTAL COUNT=12345678 PRESS MODE TO EXIT

Appears when the MODE key is pressed 6 times. This screen displays the total seal count and is for information only. The total seal count cannot be changed. Press the MODE key to exit and resume machine operation.

4.Troubleshooting

4.1 Touch Guard Errors TOUCH GUARD ACTIVE PRESS ANY BUTTON

The touch guard has been activated by contact. Keep hands clear of touch guard and press any key to resume operation.

TOUCH GUARD WIRE BROKEN-NOT FUNCTIONAL

There is a fault in the touch guard wire. This prevents the machine from operating without the touch guard safety feature. This message will appear until the wire is fixed. Turn off the machine and repair the wire before operating.

ENSURE TOUCH GUARD IS CLEAR

The touch guard was activated during startup. The startup sequence continues normally once the touch guard is cleared.

4.2 Hook Seal Errors NO HOOK SEAL RELEASE HOOKSEAL OR SOLENOID

The hook seal switch did not release within 4 seconds after elapsed seal time. The seal made is counted, and the switch should release the upper sealing arm automatically. This message indicates a possible failure of the solenoid that controls the hook seal switch.

LOST HOOK SEAL SWITCH PLEASE TRY AGAIN

The hook seal switch lost contact before the seal cycle was completed. The cycle is not counted. The sealing arm resets automatically. Wait for the arm to reset and try the seal again.

4.3 Heater and Temperature Errors

UPPER HEATER FAILURE PRESS ANY KEY

LOWER HEATER FAILURE PRESS ANY KEY

The heater did not reach the set temperature in 20 minutes. Press any key. Try to set a lower temperature. If this error message re-occurs, there may be a more serious failure (see Problem Analysis and Solutions).

LOWER HEATER > 250C FAIL- PRESS ANY KEY UPPER HEATER > 250C FAIL- PRESS ANY KEY

LOWER HEATER > 482F FAIL- PRESS ANY KEY UPPER HEATER > 482F FAIL-PRESS ANY KEY

The heater has exceeded its maximum safe temperature, or a thermocouple or circuit board has failed. Machine operation will stop and an alarm will sound. Press any key to silence the alarm and return to normal mode. Shut down machine and check thermocouple and circuit boards. Repair or replace as needed before resuming operation of the machine.

HIGH TEMPERATURES CAN DAMAGE MACHINE AND CAUSE PERSONAL HARM. DO NOT OPERATE IF A HEATER FAILURE MESSAGE APPEARS!

4.4 Problem Analysis and Solutions

Before referring to the information below, check for proper set-up and operation as outlined in Sections 2 and 3. Solutions are listed with the most probable ones listed first. Some procedures may require completion by a person with mechanical skill. See Section 1.5 for Customer Service or to order replacement parts.

PROBLEM	POSSIBLE CAUSE	SOLUTION
Power "ON" light	-Machine is unplugged or outlet has no power	-Check
not lighted	-Electrical power switch or light is not "ON" or is defective	-Check/Replace
	-Bad fuse at power entry module	-Check/Replace
	-Loose or broken wires or connections	-Check/Repair
No heat	-Machine is unplugged or outlet has no power	-Check
	-Electrical power switch is not "ON" or is defective	-Check/Replace
	-Blown fuse on circuit board	-Replace
	-Defective sealing iron	-Replace
	-Defective heat sensor	-Replace
	-Defective temperature control	-Replace
	-Defective high-limit thermostat	-Replace
	-Loose or broken wires or connectors	-Check/Repair
High or low heat	-Defective heat sensor	-Replace
	-Defective temperature control	-Replace
	-Short between sensor wires (high heat only)	-Repair/Replace
Sealing pressure	-Leak in air supply hose	-Repair/Replace
drops, fluctuates	-Dust, oil or water in air lines, regulator or solenoid air	-Replace
or hisses	valves	
Timed sealing	-Garment or cloth is too thick	-See Section 3-3
cycle does not	-Leak in hose or connections	-Repair/Replace
activate	-Defective micro switch	-Replace
	-Solenoid air valve not shifting	-Replace
	-Mechanical binding	-Check/Correct
	-Cracked sealing hook	-Replace
	-Cracked sealing arm	-Replace
	-Missing or broken pins or cam rollers	-Replace and add grease
	-Loose or disconnected wiring	-Check/Correct
Sealing head does	-Air solenoid valve not shifting	-Check/Replace
not fully rise	-Leak or restriction in air line or connections	-Check/Repair
-	-Weak or broken return springs	-Replace
Heat transfers or	-Insufficient sealing time	-Increase time
patches, etc. not	-Insufficient sealing pressure	-Increase sealing pressure
bonded properly to	-Insufficient temperature	-Increase temperature on
garment		Teflon platen
	-Sponge rubber pad is worn	-Replace
	-Teflon cloth covers for upper/lower platens are worn	-Clean/Replace
Adhesive bleed	-Sealing time too long	-Decrease by 2 second
through		increments
	-Sealing pressure too high	-Decrease sealing air
		gauge pressure by 5 P.S.I.
	15	or .5 Bar increments

5. Maintenance

Teflon/Fiberglass Shield

Clean often by wiping with a soft, clean rag. A non-flammable cleaner such as "Ez-Off," part #DH-6873, may be used according to the manufacturer's instructions. **NEVER USE A FLAMMABLE SOLVENT OR ABRASIVE CLEANER!** To ensure the best heat-sealing results, regularly replace shield whenever it becomes torn or too soiled to clean.

From the side, gently wedge a screwdriver between the sealing iron and the aluminum backing plate. The shield may now be removed by applying gentle pressure. Being careful of the heat, install the new shield by holding it against the sealing iron and pressing to snap it into position.

Rubber Sealing Pads (without Teflon Cover)

Clean often by wiping with a soft, clean rag. Replace the pad when it becomes worn. Note: To replace rubber sealing pad, use the shield replacement procedure.

Compressed Air Supply

Maintain a filtered air supply. Check air filter daily. Drain by pushing up on bottom of filter bowl.

General

Keep inside of machine free of foreign material, including lint.

Lubrication

Place one drop of standard lubricating oil (SAE 10 or equivalent) at the following locations once a month:

Pivot shafts for sealing arm: at both ends of shaft where it enters the case (See Upper Iron and Chassis Assembly)

Sealing hook, pins and camrollers: Both rollers and pins in the sealing hook and sealing arm (See Sealing Hook and Bracket Assembly, Fulcrum Arm and Chassis Assembly). Be sure to wipe off any excess oil.

6. Drawings and Parts Listing

On the following pages, the reader will find technical drawings and corresponding parts listings of the HS11 **Thermo-Seal** machine. The technical drawing illustrating a particular sub-assembly or area of the machine will precede the parts listings.

The reader will find that the technical drawings and corresponding parts listings are arranged by category. Those categories in order are:

- 1. Electrical
- 2. Pneumatic
- 3. Mechanical

Electrical





Lower Heater Unit Assembly



Sealing Arm and Heater Unit Assembly Note, some wires have been eliminated to improve clarity.

Pneumatic

Pneumatic Sealing Cylinder

Pneumatic Diagram

Sealing Cylinder Assembly Part Number 46573

Machine Assembly Features

Machine Assembly Features

HS11 Parts Listing				
Electrical				
Thermostat Preset	20018-11			
Thermocouple 36"	20018-14			
Line Cord, 15A, 125V, IEC - CSA	20080-99			
LCD/Electronics Module	46566			
Wiring Harness, Machine	46570			
Wire Harness, Power Entry	47281			
Microswitch w/Cover	D-3230-1			
Pneumatic				
Air Regulator/Filter With Gauge	22045-91			
Solenoid Valve	22046-18			
Main Air Line Hose Assembly	DH-6795			
Mechanical				
Spacer, Nylon Touch Guard	21028-50			
Washer, Shoulder, Touch Guard	21028-51			
Feet, Rubber	21050-185			
Extension Spring	24080-23			
Teflon Plate, 5" x 6"	40747			
Air Cylinder	42319			
Insulating Spacer, Top	42455			
Insulating Spacer, Bottom	42456			
Sealing Iron	42458			
Platen Assembly, 5" x 6"	42477			
Sealing Arm Assembly	42613			
Teflon Cloth Insulator	42649			
Support Pedestal	43029			
Garment Tray, 17" deep by 25" wide	43036			
Sealing Pin Replacement Kit	44766			
Additional Platens				
2" x 4" raised area, offset, in a 5"x6" assembly	47168			
1.5 "x 3.25" raised area	47174-A			
1.5" x 3.5" raised area	47174-B			
1.62" x 3.62" raised area	47174-C			
2" x 4" raised area	47174-D			

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