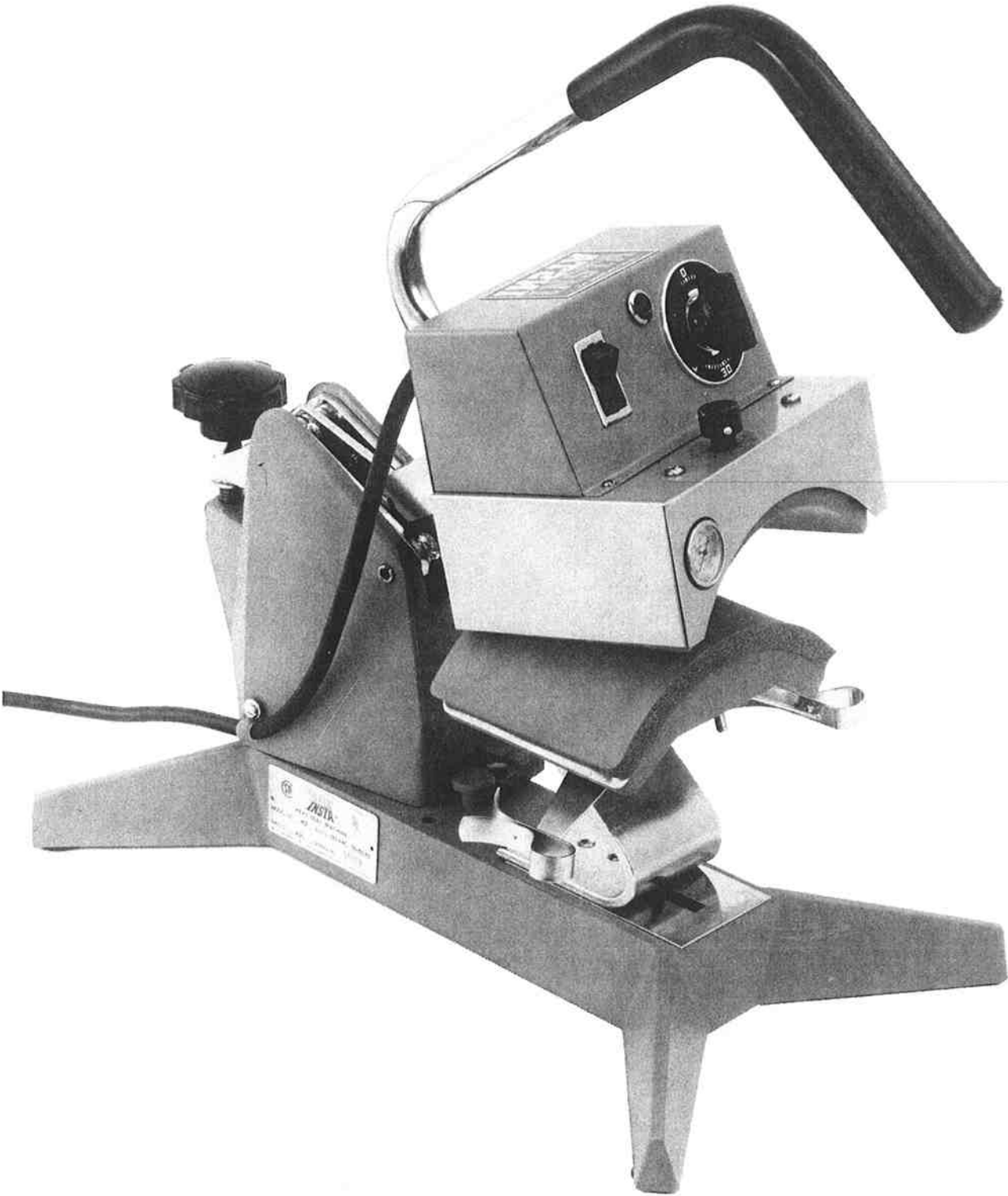


**Operation and maintenance manual
for model 412 Cap Machine**

INSTA



Congratulations!!

Your selection of the Insta Graphic heat seal machine is a sound business decision. Insta Graphic equipment is the result of the highest quality engineering and time-tested design. Your new machine, combined with INSTA's reputation for innovation in the heat sealing field, insures you the continuing capability of delivering the best decorated garments possible. This manual describes the installation and operation procedures for your new Model 412 machine, as well as an easy-to-use chart for on-the-spot maintenance. Proper heat sealing instructions and helpful hints are included in a separate brochure.

With simple maintenance, your Model 412 machine will have a long, trouble-free life. Read this manual. Keep it with your machine. It's your key to proper operation and lasting service.

Installation

Use a 120 volt, 5 AMP, AC circuit. (240 volt machines are also available.)

Operation

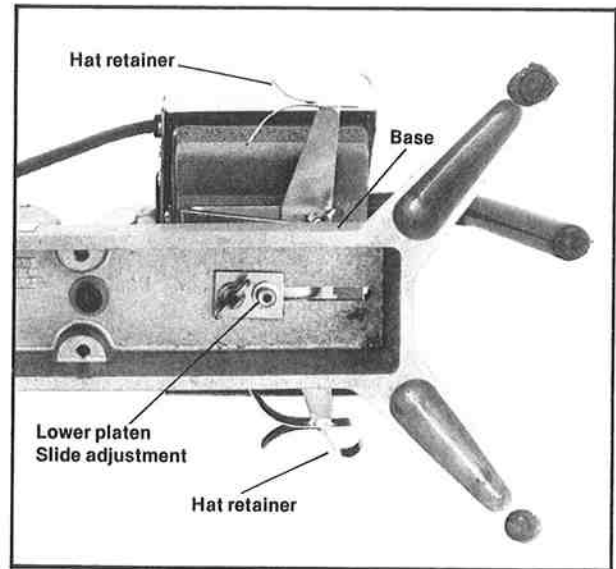
1. Push ON/OFF switch to "ON" position. Set temperature dial to 375°-400°F. (190°-250°C).
2. Lift the handle to the open position. Swing upper platen assembly to the side.
3. Allow the machine to warm up for approximately 30 minutes. When the selected temperature is reached, the neon lamp on the instrument housing will cycle on and off.

NOTE: The thermometer indicates the internal temperature of the heat platen and will indicate a temperature approximately 15F.° (8.3C°) higher than the actual heat platen surface. The temperature control indicates the TRUE surface temperature of the heat platen.

4. Set the desired pressure by adjusting the pressure adjust knob at the rear of the machine. To increase pressure, turn knob counterclockwise. To reduce pressure, turn knob clockwise.
5. Place article to be printed in position on lower platen. For a cap, pull sweatband out, place crown on lower platen, and slip both sides into retainer springs. Pull sides down tight to smooth out print surface.
6. Position transfer or lettering on cap or article.
7. Close machine by pulling handle down into locked position.
8. Set timer for proper time cycle. For best heat sealing results, refer to the "How to Apply Insta Heat Seal Transfers And Die Cut Letters" manual.
9. Bell will ring at end of time cycle. Lift handle up **slowly** and move to its full open position. (This technique will help avoid premature liftoff of transfer paper.)
10. Swing upper assembly to side to clear working area of upper heat platen.

11. Remove the cap or article.

12. The lower platen on the 412 has a sliding assembly to accommodate the variety of printing areas on caps, sleeves, etc. Simply sliding the lower platen backward or forward will allow a choice of variable printing areas 3" to 4.5" x 6.75" (7.6cm to 11.4cm x 17.2cm). A wing nut at the bottom of the machine locks the assembly in the desired position.



Bottom View
(Figure 1)

Preventive Maintenance Suggestions

The Insta Graphic heat seal machine is relatively maintenance free. For long, trouble-free life, the following preventive maintenance should be followed:

1. Do not insert items into the machine which would tend to cut the silicone rubber pad, or scratch the teflon, i.e., buttons, pins, snaps or zippers.
2. Periodically clean the teflon-coated heat platen with a non-abrasive piece of cloth. Stubborn stains may be cleaned, when platen is cool, with mineral spirits (paint thinner or kerosene).
3. When the heat platen is hot and not in use, keep in open position (away from the silicone rubber pad).
4. To prevent soiling of garment, periodic wiping of the entire exterior of the machine, including platens, with a clean rag is recommended. If necessary, use mineral spirits for cleaning a cold machine. Since mineral spirits are flammable, use precautions and keep away from sparks, flame or hot heat platen.

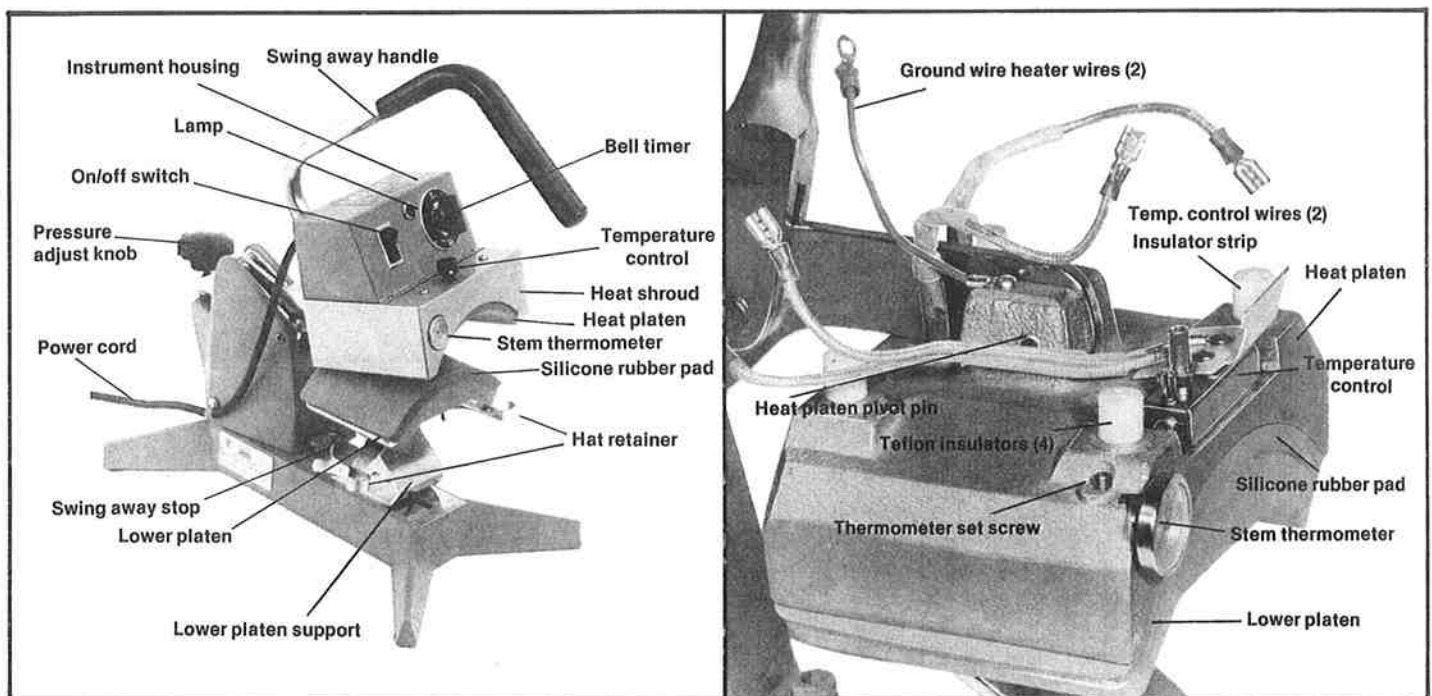
Occasionally apply a few drops of heavy machine oil to the moving parts of the cam assemblies and pressure adjustment screw.

General Maintenance

The following maintenance chart has been prepared to assist you in locating and correcting problems if the Model 412 should not operate properly .

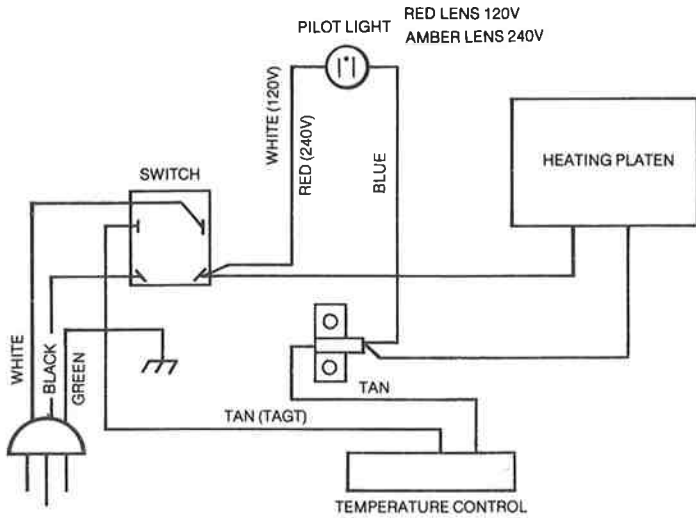
To locate the problem area it may be necessary to refer to more than one symptom listed in the chart. The table directs your attention to the fault. It does not rule out other possibilities.

SYMPTOMS	PROBABLE CAUSE AND FIX
Temperature of the platen gets too hot or cannot be controlled.	Defective temperature control. Replace with a new unit.
Platen DOES NOT heat when temperature control is turned on. Temperature indicator lamp DOES NOT light.	<ol style="list-style-type: none"> 1. Is machine on? 2. Power cord or wire disconnected or broken? 3. Defective temperature control. Replace with a new unit. 4. Defective ON/OFF switch. Replace with a new unit.
Platen DOES NOT heat when temperature control is turned on. Temperature indicator lamp DOES light.	<ol style="list-style-type: none"> 1. One of the connections from the heat platen is disconnected or broken. 2. Defective heater. Replace with heat platen assembly.

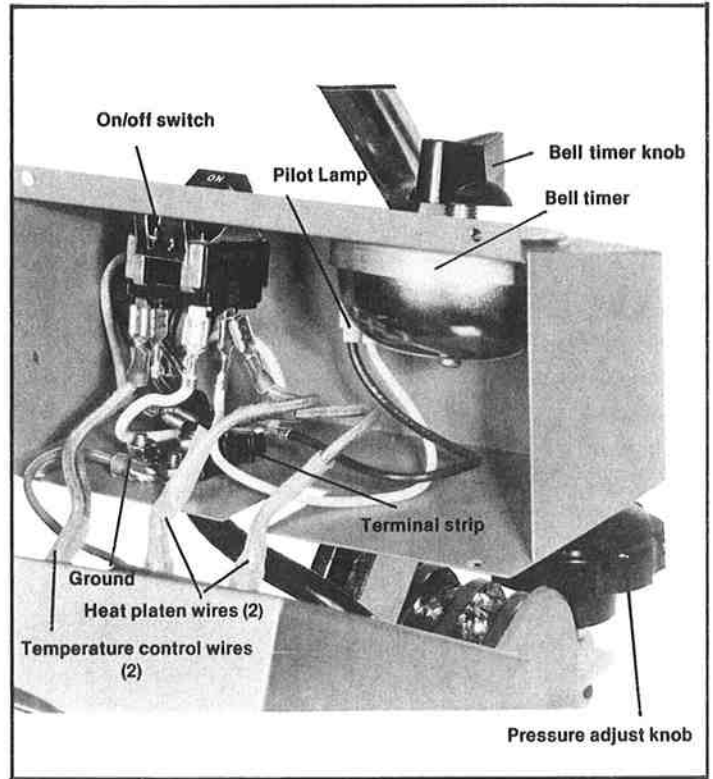


412 Cap Machine
(Figure 2)

Heat Platen Assembly
(Figure 3)



**Electrical Wiring Diagram
Model 412 Cap Machine**



**Instrument Housing
(Figure 4)**

Insta's Model 412 Parts List for Manual

Part	Stock No.
Handle and Linkage Assy.	MP-SH-405
Hat Retainer Kit	MP-SR-022
Insulators (heat shroud) set	MP-SI-089
Knob - temperature control	MP-SK-440
Knob - pressure adjustment	MP-PK-018
Lamp Assembly (120V)	MP-PL-019
Lamp Assembly (240V)	MP-PL-018
Pad, silicone rubber	MP-PP-021
Pivot Pin - Heat Platen	MP-SP-086
Plate, Retaining	MP-SP-451
Plate, Wear	MP-SP-045
Platen, Heat (120V)	MP-SP-461
Platen, Heat (240V)	MP-SP-462
Pressure Adjustment Screw Assy.	MP-SP-481
Screw, Shoulder	MP-SS-410
Screw, Wing	MP-SS-411
Shroud, Heat Platen	MP-SS-405
Spring, Return	MP-SS-453
Switch - on/off (120V)	MP-PS-050
Switch - on/off (240V)	MP-PS-051
Temperature Control	MP-PT-030
Thermometer C°/F°	MP-PT-056
Timer Assy. - (Bell)	MP-PT-058
Wire, Power Cord (120V)	MP-PW-174
Wire, Power Cord (240V)	MP-PW-176

Limited Warranty

INSTA GRAPHIC SYSTEMS warrants that for one (1) year from date of purchase, it will repair or replace any part of a machine operated under normal use and maintenance which is found to have been defective in material or workmanship. In order for this warranty to be effective, no return of machine or parts may be made without prior written factory authorization.

Manufacturer shall not be liable for any injury, loss or damage, direct or consequential, arising out of the use or the inability to use the product.