CALCA®

DIGITAL PRINT FINISHING

We are looking for distributor, please ask us for better offer!

Sample and self-pickup service are available.

A3 Automatic Powder Shaker And Dryer Unit

User Manual

Please read this manual carefully before operation

Thank you very much for choosing our CALCA brand series DTF powder shaker and dryer unit, please read the manual carefully, including the operation and maintenance to ensure the best output and the lifetime of the machine.

DTF opens the door to a wide range of choices and is capable of printing onto non-treated cotton, silk, polyester, denim, nylon, leather, 50/50 blends, and more. It works equally well on white and dark textiles.

Direct Transfer Printing is a revolutionary new printing technique that's more affordable and accessible compared to DTG, screen printing, sublimation or laser white toner transfers.

What sets DTF apart from other transfers?

- ✓ A great option for small orders.
- ✓ No cutting and weeding required.
- ✓ Crisp, defined edges and images from start to finish.
- ✓ Low cost on waste.
- ✓ Low investment – high reward (Print Cost: $0.007/inch²).

Works on Most any Fabrics

DTG technology works best on cotton pre-treated fabrics while DTF opens the door to a wide range of choices and is capable of printing onto non-treated cotton, silk, polyester, denim, nylon, leather, 50/50 blends, and more. It works equally well on white and dark textiles.

CALCA DTF powder shaker and dryer unit can handle up to 13.8in wide DTF film. This all in one unit takes over by evenly spreading, then melting the needed amount of adhesive material directly onto your printed image, saving time, effort, and cost.

Applicable Medium: Nylon, Chemical Fiber, Cotton, Leather, Swimsuit, Diving Suit, PVC, EVA, etc.

I. Machine Information

Data Sheet:

CALCA Brand: USA registered

Maximum Shake Powder Width: 350mm (13.8inches)

Heating Element: Far-infrared carbon fiber heating tube

Rewinding Function: Automatic

Common Film Size: 300mm x 100m roll material

Powder spreading structure: The motor drives the brush to rotate to brush the hot melt powder out of the powder box.

Powder shaking device: the motor drives the powder shaking lever to beat the film to clean up excess hot melt powder.

Machine Size: 36in x 24.8in x 21.7in (920mm x 630mm x 550mm)

Power Shaker and Dryer Weight: 92.4lbs (42kg)

Packaging Size: 31in x 24.4in x 28.7in (790mm x 620mm x 730mm)

Gross Weight: 103.4lbs (47kg)

Requirements:

Working Power Supply: AC110V or 220V, 50hz / 60hz, 1 phase.

Current: 22A (110V), 11A (220V), 2400W

With CALCA DTF film, power and Inks, you can easily and quickly create custom t-shirts and apparel.

Features:

> With a warming inlet platform, automatic powder dispenser, paddle to remove excess powder, 4 bulb tunnel dryer and roll up at the end.

> This all in one unit takes over by evenly spreading, then melting the needed amount of adhesive material directly onto your printed image, saving time, effort, and cost.

> Infrared drying and heating improves and protects color reproduction.

> Customized automatic powder recycling drawer, increases effectiveness against manual recycling.

> Shake powder control, dusting control, PID setting of curing temperature.

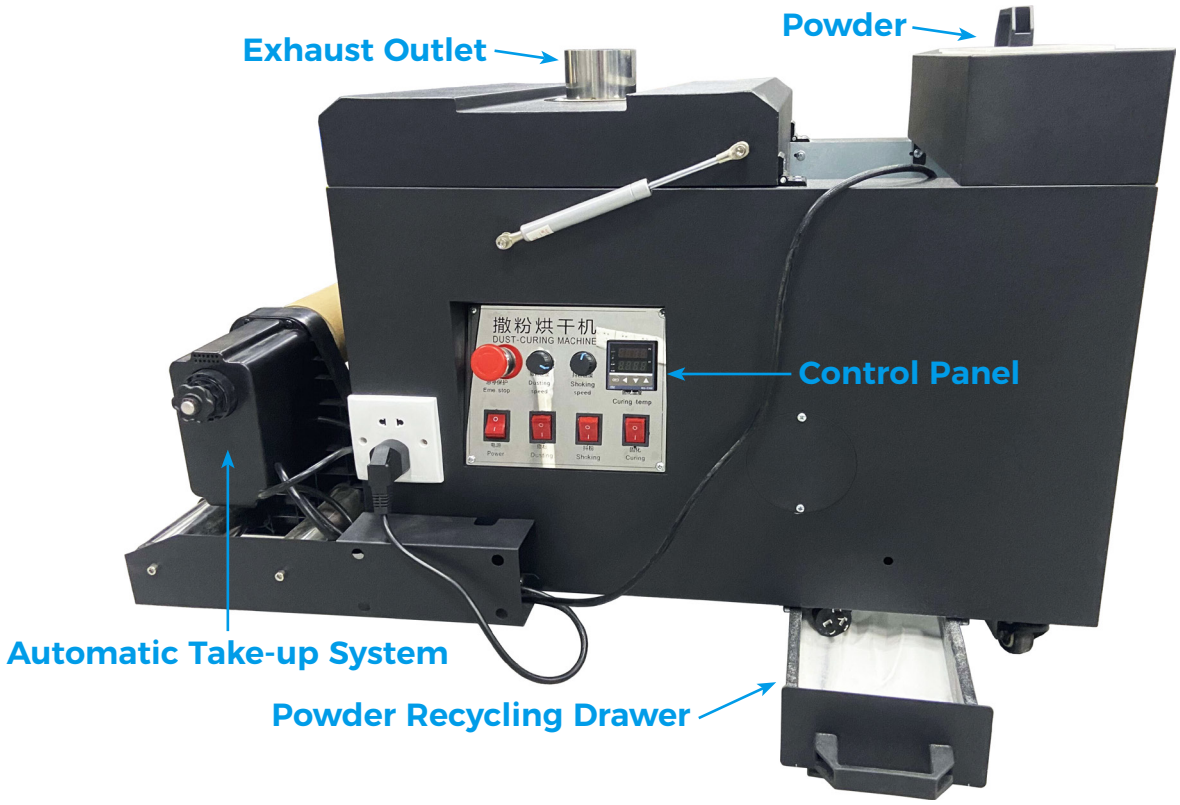
> Automatic powder feeding, evenly spreading powder.

II. Installation Precautions

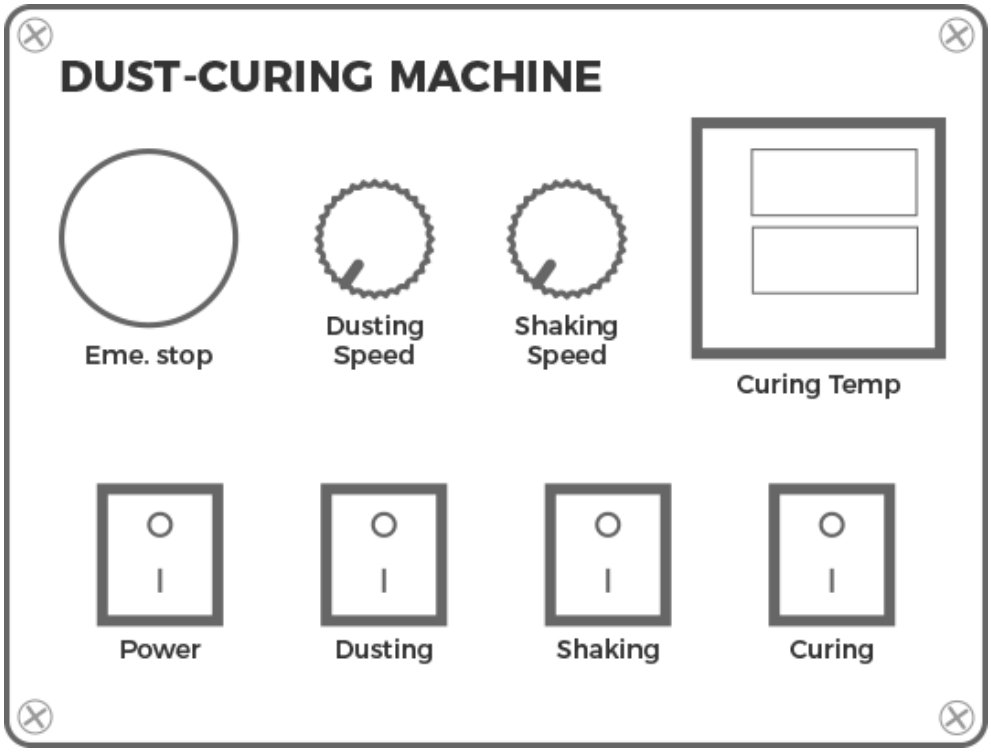
1. Before unpacking, carefully check if there is damage for the packing and machine during transportation.
2. After unpacking, check if the service parts are correct as the packing list.
3. The installing place should be provided enough space for operating and free of dust, no vapor, no corrosive gas, no combustible or explosive substance around. Keep the machine away from wind blowing place, otherwise will affect the roller temperature which might bring the laminating quality.
4. After installation, adjust each caster to reach level ground. The casters only be used on even ground for short distance movement.

Notice: Please move carefully since it is heavy equipment

III. Parts Identification



Control Panel:



1. **Emergency stop protection:** Used for emergency shutdown of the equipment when an abnormal situation occurs. Its working mechanism is to cut off the power supply of the equipment and make the machine stop in an emergency;
2. **The dusting speed:** Its working mechanism is to control the speed of the dusting motor by adjusting the working voltage of the motor, and the dusting motor drives the brush to output the powder, so as to achieve the different effects required by the product;
3. **Powder shaking speed:** This adjustable knob controls the speed of the powder shaking motor by adjusting the working voltage of the motor. The powder shaking motor drives the powder shaking film through the connecting rod. The appropriate powder shaking speed can be applied to the different effect requirements of different products;
4. **Curing temperature:** The powder shaker uses this function to adjust the working temperature of the drying area. Because different working environments and media have different curing temperature, it needs to be adjusted according to the characteristics of the product and material;
5. **Power:** This is the power control switch of the device;

6. **Dusting power:** This is the function control switch of the powder spreading motor;
7. **Shaking powder:** This is the function control switch of the shaking powder motor;
8. **Curing:** This is a functional control switch that controls the heating in the heating zone.

IV. Steps to Operate

1. Select the appropriate power supply according to the regulations, connect the equipment power supply according to the standard, and fix the equipment;
2. Debug the printer and pass the film through the printer and the powder shaker. The film should be dropped to the height of the sensor in the dusting box, and finally fixed on the reel of the take-up reel;
3. Add hot melt powder to the powder box. Be careful not to add too much powder. It is appropriate to just submerge the brush. The normal powder spreading speed is 4 hours per shift;
4. Turn on the dusting switch and adjust the dusting speed to the proper amount of powder;
5. Turn on the powder shaking switch and adjust the shaking speed to a proper speed;
6. Turn on the curing switch and adjust the curing temperature to 212˚F (100˚C). The recommended curing temperature adjustment range is 194-266˚F (90-130˚C);
7. After the curing temperature of the powder shaker is constant, the printer can enter the working state, and the powder shaker is in the working mode of automatic induction and receiving.

V. Attention

1. The power supply voltage should be within a reasonable range and the power supply should be connected to the ground as required to ensure that the equipment is good grounding to ensure the normal and stable operation of the equipment and the personal safety of the operators;
2. The fluctuation range of the power supply voltage of this equipment should be less than ±5%. If the voltage is too low, it will affect the working efficiency of the equipment. If the voltage is too high, it will shorten the service life of the key components of the equipment. It is recommended that qualified users install a

voltage stabilizer.

3. If it is not used for a long time (more than 3 days), the power plug should be unplugged;
4. This product must be installed horizontally to ensure that the equipment does not shake when working. After adjusting the position, fix the brake casters;
5. The installation location must be well ventilated. Because the powder shaker will produce smoke and a large amount of water vapor when it is working, it is recommended to install a smoke purifier at the exhaust port of the powder shaker, and an exhaust fan is recommended to be installed in the room; this is very important: heat The molten powder is sensitive to water vapor and temperature, and a good working environment can reduce the failure rate of the equipment and improve the stability of the product;
6. The quality of the products produced requires the cooperation of appropriate temperature and appropriate working speed. A good working environment can greatly increase the service life of the equipment and produce more stable products.

VI. Problems and Solutions

Phenomenon	Reason	Solution
The whole machine does not work?	1. The power is not connected. 2. Poor circuit connection.	1. Check and turn on the power 2. Check the circuit and return to normal state.
Doesn't shake the powder down?	1. The dusting brush is stuck. 2. The motor shaft is loose and not locked.	1. Clean the powder in the powder box and solve the problem of ventilation in the work place. 2. Tighten the loose screws.
The take-up reel works abnormally?	1. Too much powder causes it to pile up and block the line of sight of the sensor. 2. The sensor is loose or in abnormal position. 3. Circuit failure.	1. Clean up excess hot melt powder 2. Re-adjust the position of the sensor and fix it. 3. Repair circuit.

VII. Maintenance

1. Only experienced operator could open the cabinet, be noted following measures;
2. Don't use abrasive cleaner to clean the machine surface.

3. Check the rotation parts regularly and fill high-temperature grease to lubricate the two bearings of heating rollers.
4. Do not wash the machine with water. This can damage the electrical circuits, cause electrical shock or corrosion.
5. During maintenance, don't run the machine.
6. During maintenance, don't change, move and dismantle the safety parts. Make sure the safety parts before using.
7. Cut the power supply before dismantling and assembly.

WARRANTY CARD

MODEL		LOT #	
BUYER		DATE	
SELLER		TEL	

Notes

i. The warranty card should be filled by seller and kept by buyer. Alterations are prohibited.

ii. The guarantee period is two years. The repair is free of charge within 6 months and will be charged with material and labor cost after 6 months.

iii. No free repair is available for any damages caused by the improper use.