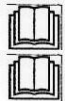

NittaBeltPoly Heat Press PP1535 Operation Manual



Follow this manual when using NittaBeltPoly Heat Press.
Please provide this manual to NittaBeltPoly Heat Press users for safe and trouble-free operation.

NITTA CORPORATION

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1. Confirmation of Product

Thank you for choosing our Heat Press PP1535.



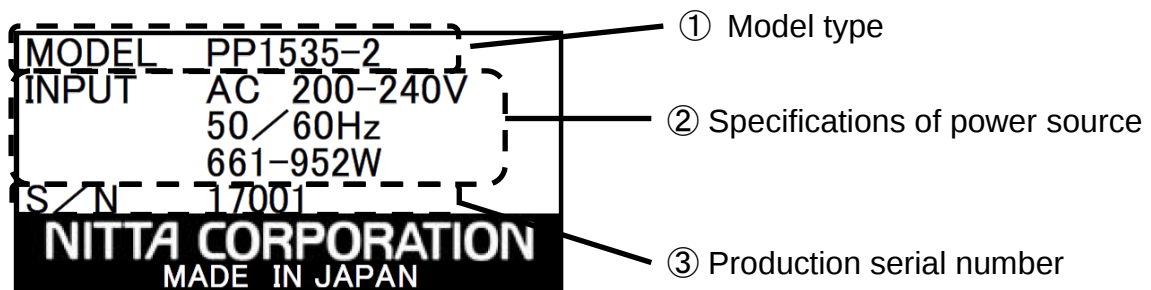
Check that the product is exactly what you have ordered.
Use of the wrong product may cause fire, electric shock or injury.

1-1) Confirmation of Product

Confirm the following items upon accepting delivery of your order. Contact your local sales office or distributor in your area if you find any deficiency or defect in your item.

- ① Are descriptions on the face plate the same as those of the item you ordered? Please confirm the model type and power source specifications.
- ② Has the product been damaged during transportation?
- ③ Has a nut or screw come loose?
- ④ Are the additional contents that are included with the product all there?

1-2) How to Read Face Plate



1-3) Press model

There are two kinds of models with a different input power supply.
The specification of the power supply is described by the input.

1-4) Additional contents

Operation manual (this manual), Cushion rubber × 1, Release sheet × 1

1-5) Notes for inquiry

When making inquiries, please contact us with both the press model and serial number.

2. Specifications

2-1) Outline of Heat Press

- ① Heat Press is exclusively designed for making endless **NittaBeltPoly** belts
- ② Heat Press is compatible with the following endless specifications:
Joint specifications: skiver endless (Right angle)
Maximum belt width: up to 300mm
Maximum belt thickness: up to 6mm
- ③ Other tools required for making skiver endless belts: NITTA Poly Skiver

2-2) Major Specifications of Heat Press

Type	PP1535-1	PP1535-2
Specification of power source	100V	200V
Input power supply	100V~120V	200V~240V
	50/60Hz	50/60Hz
	660 - 952W	660 - 952W
Temperature	※ 90~110℃	
Outer dimensions	Press body : 230mm wide ×600mm long ×215mm high	
Weight	※ 28kg	

**WARNING**

Do not set to a temperature in excess of 110 °C under any circumstances.

- ※ **During the endless splicing process, keep the temperature set in the range of 90 ~ 110 °C.**
- ※ **It is not possible to control temperature in an environment below normal room temperature.**
- ※ **This Heat Press weighs 28kg.**
Handle with care when transporting, so that you do not drop the press and risk damaging it.

3. Use Environment

Ambient Temperature	5-30 °C (no condensation)
Ambient Humidity	15~85%RH
Place of Use	Indoors (free from dust, water)
Environment	No flammable, combustible or corrosive gas; no steam

**WARNING**

In order to prevent fire or electric shock, do not use the Heat Press under the following conditions:

- In a flammable gas or combustible gas environment
- In a corrosive gas environment
- In ambient temperature of 5°C or below
- In ambient temperature of 30°C or above
- In a high humidity environment (humidity surpassing 85%)
- In places exposing the Heat Press to steam or water droplets

4. Storage Environment

Ambient Temperature	0-40 °C (no condensation)
Ambient Humidity	15~85%RH
Place of Use	Indoors (free from dust, water)
Environment	No flammable, combustible or corrosive gas; no steam

**WARNING**

The Heat Press should be stored subject to the above conditions when not in use.

Wrong or poor storage may cause mechanical disorder to the press and may cause fire or electric shock.

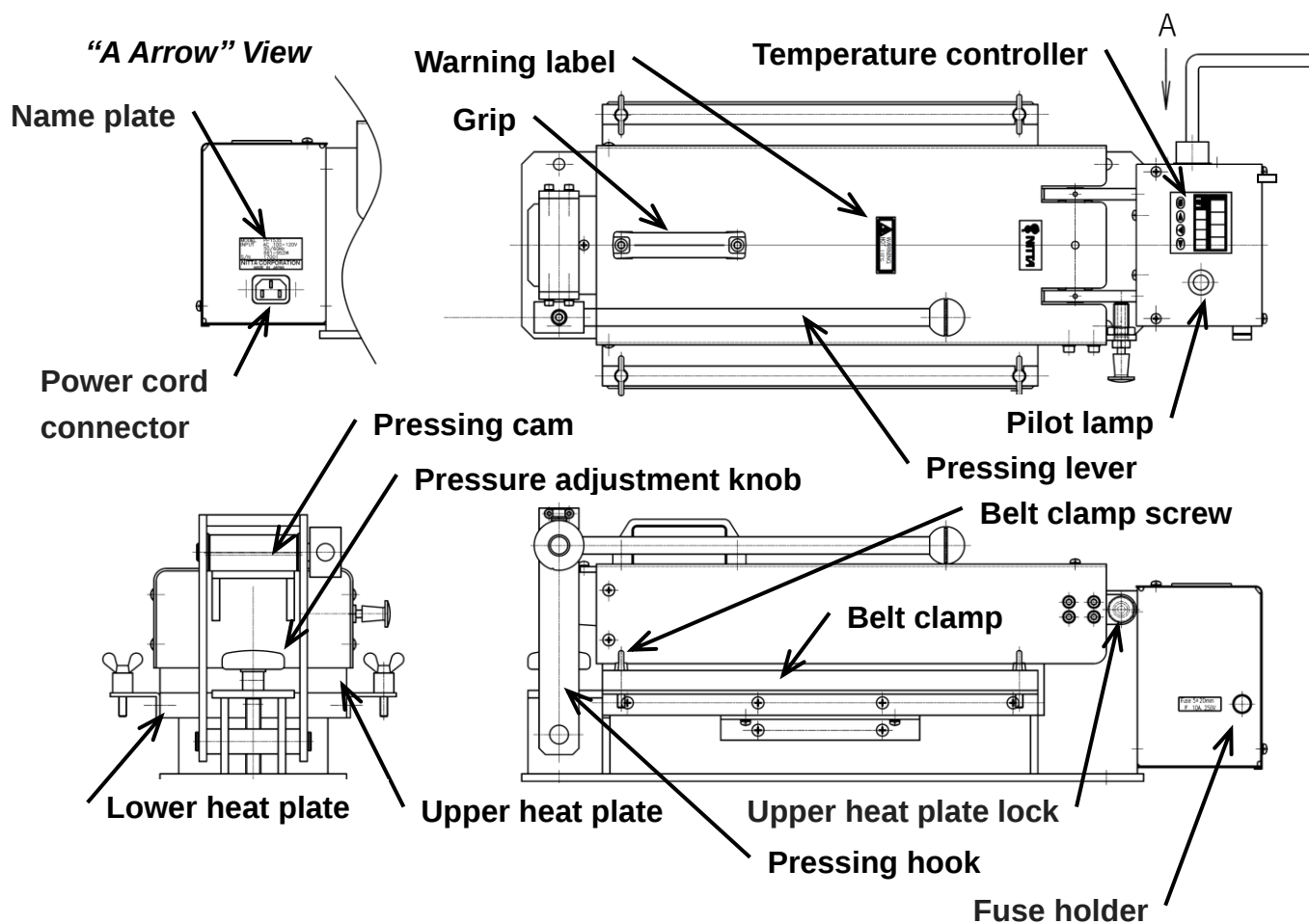
**WARNING**

Before using the Heat Press, perform a prior-to-use inspection and confirm that the press is working properly.

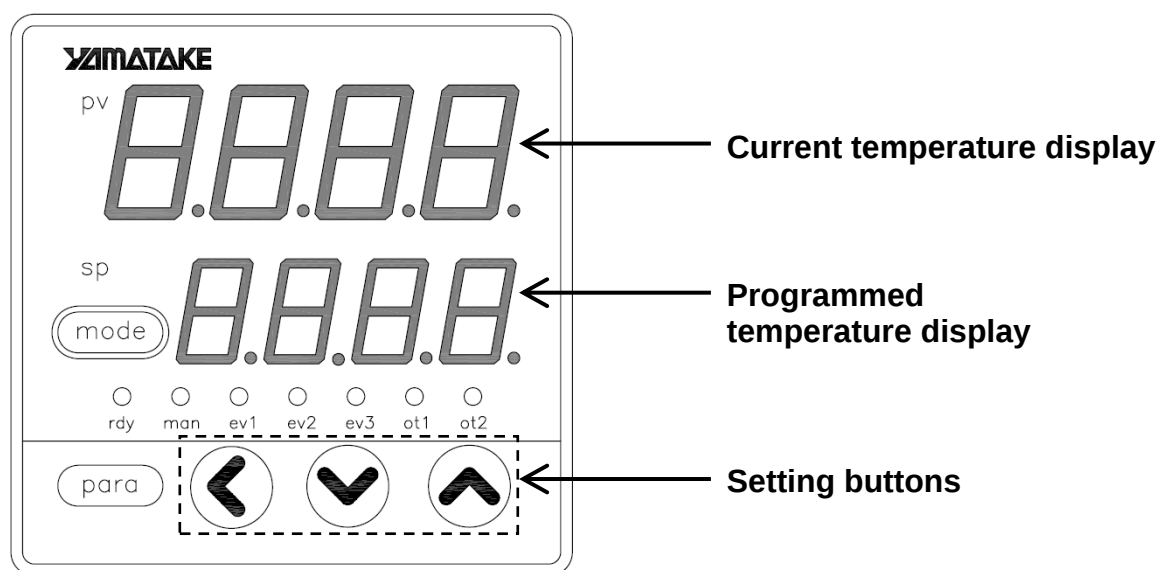
Any problem found in the prior-to-use inspection should immediately be notified to your local sales office or distributor in your area.

5. Name of Each Part

5-1) Main Press Body



5-2) Temperature controller



6. Safety Precautions

Please go over these safety precautions carefully to ensure correct and safe operation of the NittaBeltPoly Heat Press PP1535.

 **WARNING** Disregarding instructions marked with this symbol may lead to death or serious injury.

 **CAUTION** Disregarding instructions marked with this symbol may lead to injury or property damage.

 WARNING

 **WARNING** Do not use the Heat Press for any application other than the intended purpose of making belts endless.
Using the Heat Press for any unintended purpose may cause an unexpected accident. Incorrect operation may impair safety protection functions of the Heat Press.

 **WARNING** This machine is not intended for use by persons with physical, sensory or mental handicaps.
If such individuals use this Heat Press, they must be supervised by a trained operator responsible for their safety. Failure to do this may cause fire, electric shock or injury.

 **WARNING** Do not allow a child to handle this Heat Press.
Keep this machine out of children's reach.
Failure to do this may cause fire, electric shock or injury.

 **WARNING** A trained, experienced user should always be responsible for operating, maintaining and inspecting the Heat Press.
Handling by an inexperienced person may cause fire, electric shock or injury.

 **WARNING** Do not dismantle or modify the Heat Press for any reason.
Dismantling or modifying the Heat Press may cause fire, electric shock or injury.
For repair or inspection, please contact your local distributor or agent in your area.

 **WARNING** In case of an emergency (such as smoke, fire, foul smell), disconnect the main plug from the socket outlet and contact Nitta or your local distributor or agent in your area for inspection.
Failure to disconnect the main plug from the socket outlet may cause fire or electric shock.

6 Safety Precautions- Continued-



WARNING

Confirm that the power source used is within the designated specifications for the Heat Press.

Use beyond the designated specifications may cause fire or electric shock.

Specification	Power Source
For 100V	100V—120V 50/60Hz
For 200V	200V—240V 50/60Hz



WARNING

Use a conversion plug when the plug shape does not match the socket.

Failure to do this may cause electric shock.

The plug shape of the attached power cable is shown below.

The conversion plug is not attached.

When a conversion plug is necessary, users must provide their own.

Specification	Plug type	Plug illustration
For 100V	A Type	
For 200V	CEE7 (S Type)	



WARNING

Connect the main plug correctly to the socket outlet.

The power cable of the press uses a ground connection plug.

Connect the main plug correctly into a ground connection outlet to prevent electric shock.



WARNING

Always use heat-resistant gloves when handling the Heat Press to prevent burns.

A “Hot!” label appears on the top and bottom plates of the press to warn against high temperature.



WARNING

Do not touch any part of the press, other than its handle, even with heat-resistant gloves on while the press is being heated or while it is still hot after using.

Metal edge portions beyond the handle can exceed 110°C, which may cause burns even with heat-resistant gloves on.



WARNING

Disconnect the main plug from the socket outlet immediately after use.

The user operating the press should take precautions so that others do not burn themselves by touching the press accidentally before it has cooled down.

Once it has been unplugged, a heated press (110°C) takes about two hours to cool down to 40°C under room temperature conditions (25°C).



WARNING

Do not use the Heat Press on any flammable material.

Fire may result if the press is used on any product other than NittaBeltPoly and the release sheet and cushion rubber provided.

6 Safety Precautions- Continued-



WARNING

Impressed voltage is distributed in the power cable.

To prevent fire, electric shock or damage, please consider the following.

- Disconnect the main plug from the socket outlet with your hand.
- Do not modify or replace the main plug.
- Do not place any object on the power cable.
- Do not fold the power cable.
- Do not pull or stretch the power cable.



WARNING

Use a three-pin ground line as an extension cord.

When an extension cord is required, use a ground-connection type extension cord to prevent electric shock.



WARNING

To prevent fire or electric shock, do not use the Heat Press under the following conditions:

- In a flammable gas or combustible gas environment
- In a corrosive gas environment
- In ambient temperature of 5°C or below
- In ambient temperature of 30°C or above
- In a high humidity environment. (Humidity surpassing 85%)
- In places exposing the Heat Press to steam or water droplets



WARNING

To prevent electric shock, do not operate the Heat Press with wet or damp hands.



WARNING

Do not pour water on the Heat Press and do not get it wet.

Use of a wet press may cause fire or electric shock.



WARNING

Use a dry cloth for cleaning the Heat Press.

To prevent fire, do not use alcohol, benzine, thinner or any other inflammable solvent.



WARNING

Use the heat press by fixing it to a horizontal and sturdy table or stand with bolts.

A press that has not been properly secured may cause burns, injuries, and fractures.

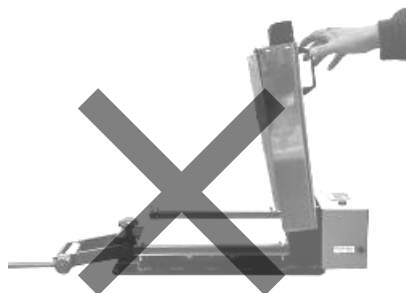


WARNING

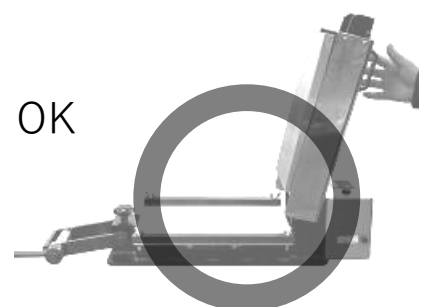
To open the upper heat plate, hold the grip firmly and pull it up slowly. Release your hand after confirming that the upper heat plate has opened to the maximum opening position and the upper heat plate locking mechanism has engaged.

If not opened all the way and locked, the upper heat plate may fall down and cause burns, injuries, and bone fractures.

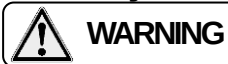
NG



OK



6 Safety Precautions- Continued-



WARNING

Do not use this press if the upper heat plate lock is not working. Do not remove the locking unit from the upper heat plate.
If it cannot lock, the press may cause burns, injuries, and fractures.



WARNING

When closing the upper heat plate, grasp the grip firmly, release the upper heat plate lock, and close it slowly.

Failure to follow these steps may cause burns, injuries, and fractures.

To release the upper heat plate lock, pull the plunger knob forward.



WARNING

Do not wrap the belt around the bottom of the Heat Press during the endless splicing process.

This causes the installation of the Heat Press to become unstable.
Destabilizing the press installation may cause injuries and fractures.



NG



OK



WARNING

When installing this Heat Press directly on a table, the sizes that can be made endless are as shown in the chart below. If you utilize a stand and attach the press to it as shown in the pictures below, even shorter endless lengths will be possible. Before use, be sure the press is firmly bolted onto the stand and the stand is firmly bolted to a table.

Belt width[mm]	Belt length[mm]
~100	2000~
100~200	2500~
200~300	3000~

Stand



6 Safety Precautions- Continued-

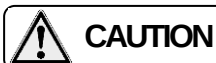


During the endless splicing process, the Heat Press is easier and safer to operate from the right side.

When using the press, the operator should face it so that, from their perspective, the temperature controller is to the right and the pressing lever is to the left.

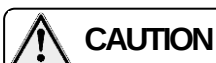


Caution



Do not use the Heat Press outdoors.

This product cannot be used outdoors.



Do not do anything to deliver a strong shock to the Heat Press.

This may cause fire, electric shock or injury.



When a lightning surge occurs, please discontinue use immediately.

A surge may cause fire, electric shock or press failure.



When using the Heat Press on any equipment, use a safety catcher for the press so it doesn't fall or collapse. This will help prevent fire, electric shock or injury.

Failure to do so may cause fire, electric shock or injury.



Before using the Heat Press, be sure to inspect the press in accordance with the procedure described on page 17 to help prevent fire or electric shock.



Do not use this machine to perform endless splicing on belting made by manufacturers other than Nitta.

Using this machine for endless splicing of other manufacturers' belting may result in a deficient splice.

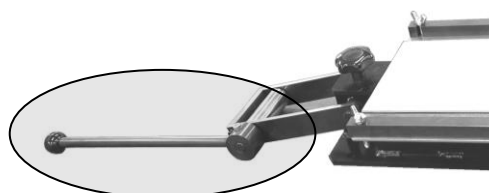
This may cause the belt not to achieve full function and performance.



The pressing hook may fall down unintentionally.

Do not place your hand within the arc of the pressing hook.

The pressing hook may cause injuries if caution is not exercised.



7.Operation Procedure

7-1) Pre-heat

Connect the main plug correctly to the socket outlet.

Power is supplied to the temperature controller, and the current temperature of the press is indicated on the temperature controller.

The press takes about 30 minutes to preheat.

Now it is possible to confirm and change the set temperature.



WARNING

Be sure to connect a ground line to prevent electric shock.

7-2) Temperature setting (Temperature controller)

- 1) Make sure that power is applied to the temperature controller.
- 2) Push the  display change button three times to indicate "SP-1" on the preset temperature display.
At this time, the preset temperature display indicates the preset temperature.
※The preset temperature before shipping is 110°C.
- 3) Push the  (up) button to raise the preset temperature or push the  (down) button to lower. Push the button once and the flashing digit will increase or decrease 1°C each time.
Pushing the  (side) button shifts to the next temperature digit.
- 4) The numbers in the preset temperature display will flash while the temperature is being adjusted.
The preset temperature will become set after 2 seconds with no button presses.
- 5) Push the  display change button twice to return the preset temperature display to the original state.

7-3) Discontinuing operation of the Heat Press while in use.

Disconnect the plug if it becomes necessary to discontinue operation of the Heat Press while it is in use.

Even if the plug is disconnected during operation, previously entered preset temperature and hold time data are maintained.



WARNING

When operation is discontinued during use, the Heat Press is kept at high temperature.

Be sure to wear heat-resistant gloves when handling the Heat Press.

Failure to do this may cause burns.



WARNING

The operator should take measures to prevent other people from touching the machine accidentally, until the Heat Press temperature lowers to near room temperature (about two hours).

Failure to do this may cause burns to others.



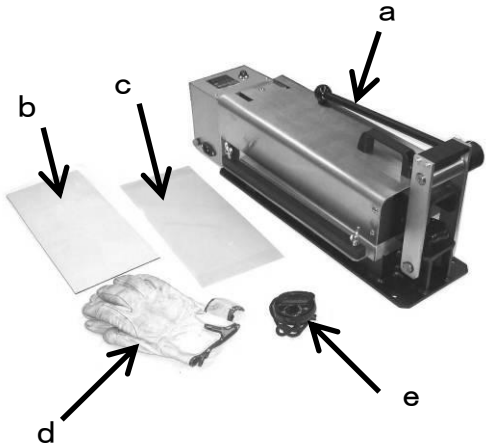
CAUTION

If Heat Press operation is discontinued during the process of splicing a belt, do not use the belt.

The splice may become defective, reducing the function and performance of the belt or rendering it unusable.

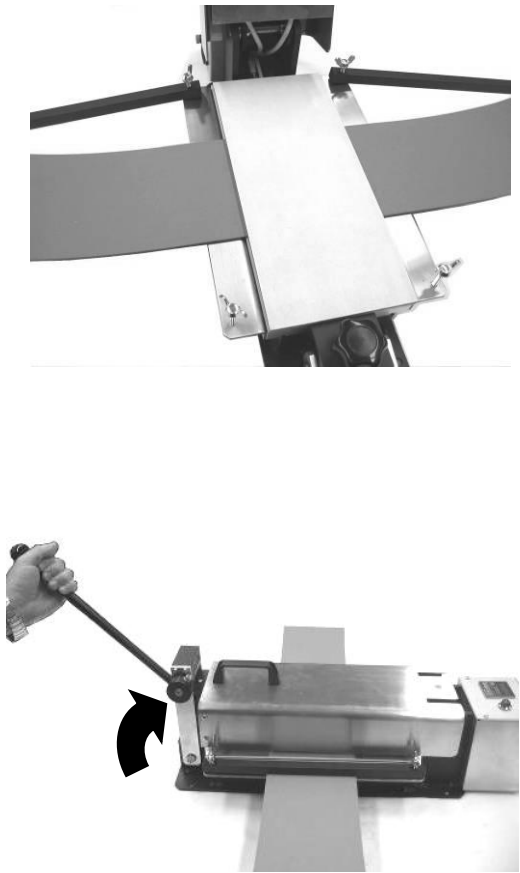
8. How to Make Belts Endless

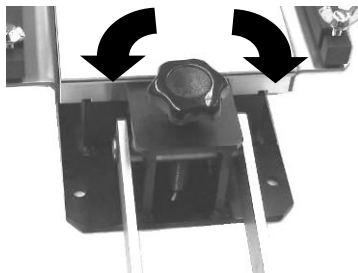
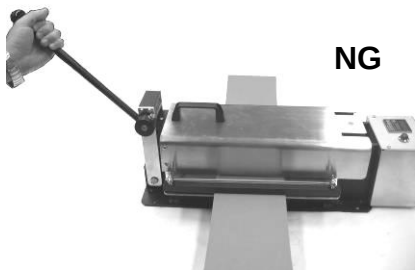
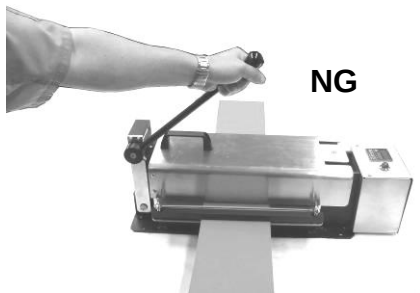
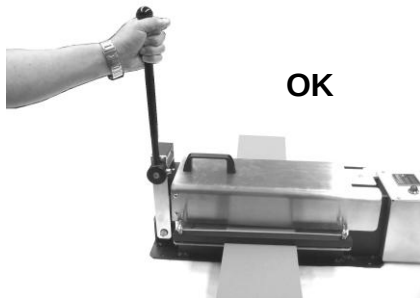
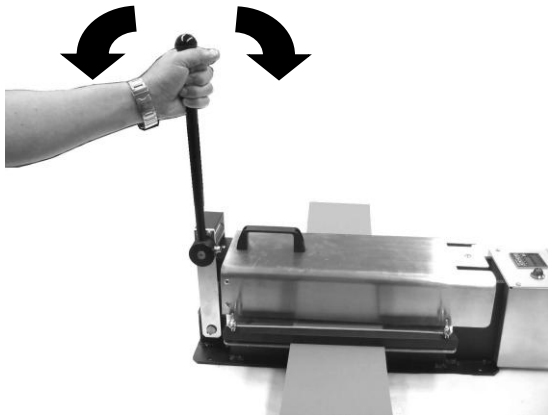
8-1) Required Tools

	a. Heat Press (PP1535) b. Cushion rubber (included with PP1535) c. Release sheet (included with PP1535) d. Heat-resistant Gloves (burn-preventive protection kits) e. Stopwatch or timer  WARNING The press body reaches a high temperature. Always use heat-resistant gloves to prevent burns.
---	--

8-2) Adjustment of Pressure

Before turning on power to the press, you can adjust the pressure depending on the belt to be made endless.

	• First, place the belt on the lower heat plate. Next, place the release sheet over it. Then, place the cushion rubber over the release sheet. ※Belt should be centered within the heat plate.  WARNING Be careful not to catch your hands on the upper heat plate. If your hand becomes caught by the plate, it may cause burns, injuries, or bone fractures. • Close the upper heat plate. • Hook the pressing hook over the pressing cam.
---	--



- Move the pressing lever back and forth to check the angle at which the pressing lever encounters resistance.
- It is appropriate to feel resistance when the pressing lever is at a right angle (90° angle) above the press.
- Pressure is too low if the pressing lever does not meet resistance even beyond a 90° angle.
- Pressure is too high if the pressing lever does not reach a 90° angle before meeting resistance.
- Turn the pressure adjustment knob to adjust the pressure.
To increase pressure, turn the pressure adjustment knob counter-clockwise.
To lower pressure, turn the pressure adjustment knob clockwise.

8-3) Make Belts Endless



※Set press temperature and pressure in advance before following these steps.

- Connect the main plug correctly to an electrical outlet, then wait for the press to finish preheating.



WARNING

The Heat Press body reaches a high temperature. Always use heat-resistant gloves to prevent burns.

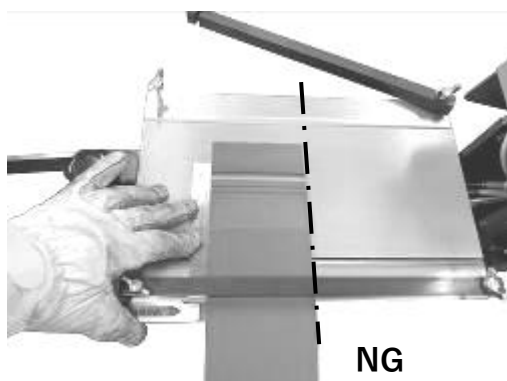
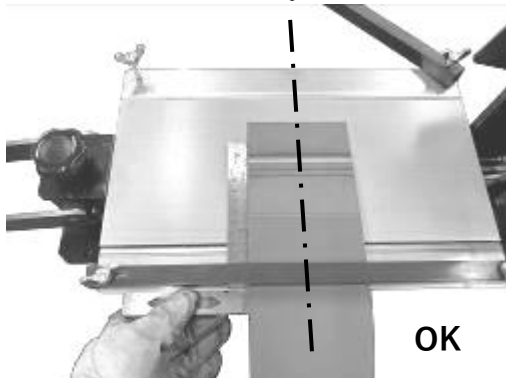
- Apply the adhesive to the belt.

※Check the splicing manual for the correct method of applying adhesive.

- Place one end of the belt in the center of the heat plate with the skived surface facing upward.

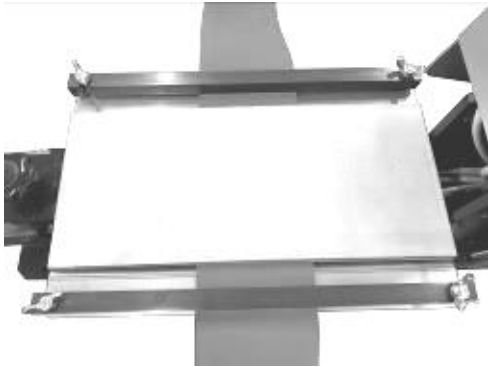
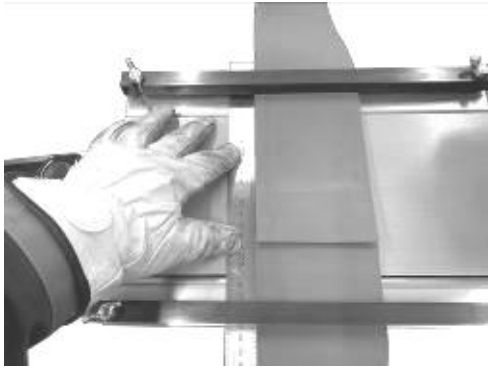
Lay other end of belt over top of first end so that the skived nylon core portions of both are matched and placed against each other.

Center of heat plate



※Belt should be centered within the heat plate.

Pressure will not be applied uniformly if the belt has not been set in the center of the heat plate.



- Use a ruler/scale or other straight edge to make sure the joined ends are straight and not bent, then clamp the belt to fix it in place.

- Place the release sheet over the belt, then place the cushion rubber over the release sheet.

- Close the upper heat plate.
Push the pressing lever all the way over until it is horizontal to pressurize the press.
- During the time the splice is being heated, as detailed in the splicing manual, the press should remain heated and pressurized.

- When splicing is complete, use the pressing lever to release the pressure and then remove the belt from the Heat Press.



WARNING

The Heat Press and belt are hot. They may cause burns. Please use caution.



WARNING

Close the upper hot plate after using the Heat Press.



WARNING

After finishing use of the Heat Press, unplug the power immediately and be careful not to touch the press or let others touch it until it has cooled to a safe temperature.

9. Troubleshooting

Problem	Cause		Solution
No display on the temperature controller	The power plug has been disconnected.		Connect the power plug.
	The fuse has blown out.		Replace the fuse.
	Is power supplied to the outlet?	Yes	Failure of the temperature controller or disconnection of power cable or internal wiring is suspected. * Please contact your local distributor, agent in your area or our company.
		No	Supply power to the outlet.
The temperature controller shows a display starting with AL. (AL01 - AL99)	Defective data on temperature controller		Disconnect the power plug once and connect it again. * If the alarm display does not disappear, failure on the temperature controller is suspected. * Please contact your local distributor, agent in your area or our company.
Temperature cannot be set.	Setting change is not possible for 6 sec. right after power ON.		Wait 6 sec. or more after power ON before changing settings.
	The  and other buttons were pushed right after the preset value was changed.		For the preset value to take effect, avoid pushing buttons for 2 sec. or more.
	Other than the above: Failure of the temperature controller		If temperature cannot be set even by the above methods, failure on the temperature controller is suspected. * Please contact your local distributor, agent in your area or our company.
Press cannot be heated to the set temperature.	Does power supply not match the specification?	Yes	Use the correct power supply.
		No	Failure of the temperature controller or disconnection of internal wiring is suspected. * Please contact your local distributor, agent in your area or our company.

10. Inspection

Inspection items	date/staff	date/staff	date/staff	date/staff	date/staff
The power cable is free of damage or destruction.					
The Control cable is free of damage or destruction.					
The temperature controller is free of damage or destruction.					
All screws on the temperature controller are tightened.					
Main plug is free of damage or destruction.					
The press body is free of damage or destruction.					
All screws on the press body are tightened.					

※Make a copy of this page and use it for a prior-to-use inspection

11. Warranty and After-Sales Service

1. Warranty period

The warranty period is for one full year after the delivery of the order at your appointed place.

2. Warranty coverage

1) Should the product malfunction due to causes for which our company is responsible during the abovementioned warranty period, our company will provide a replacement product or repair the product free of charge. However, even within the warranty period the following cases shall not be covered by the warranty. Please note that even if our company provides a replacement product or repairs the product, the warranty period will be calculated from the initial date on which the product was delivered.

- ① Malfunction arising from any inappropriate conditions, environment, handling and usage which are not described in the Operation Manual and the Endless Splicing Procedure.
- ② Malfunction due to a cause arising from something other than the product, such as your own device.
- ③ Malfunction arising from any modification or repair by other than our own company.
- ④ Malfunction arising from any development that would not have been possible to predict, within the limits of our chemical and technological capabilities, prior to shipment.
- ⑤ Malfunction arising from fire, earthquake, flood, other disasters, voltage error, or other external factors for which our company bears no responsibility.

2) The warranty coverage is limited to what is stated in 1) above, and the warranty does not cover secondary damages (equipment damage, opportunity loss, profit loss) and any other damage incurred by the user as a result of a malfunction of the product.

3) After the warranty period, if after examination the product is repairable, our company will repair it upon request.

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The specification is subject to change for improvement without notice.