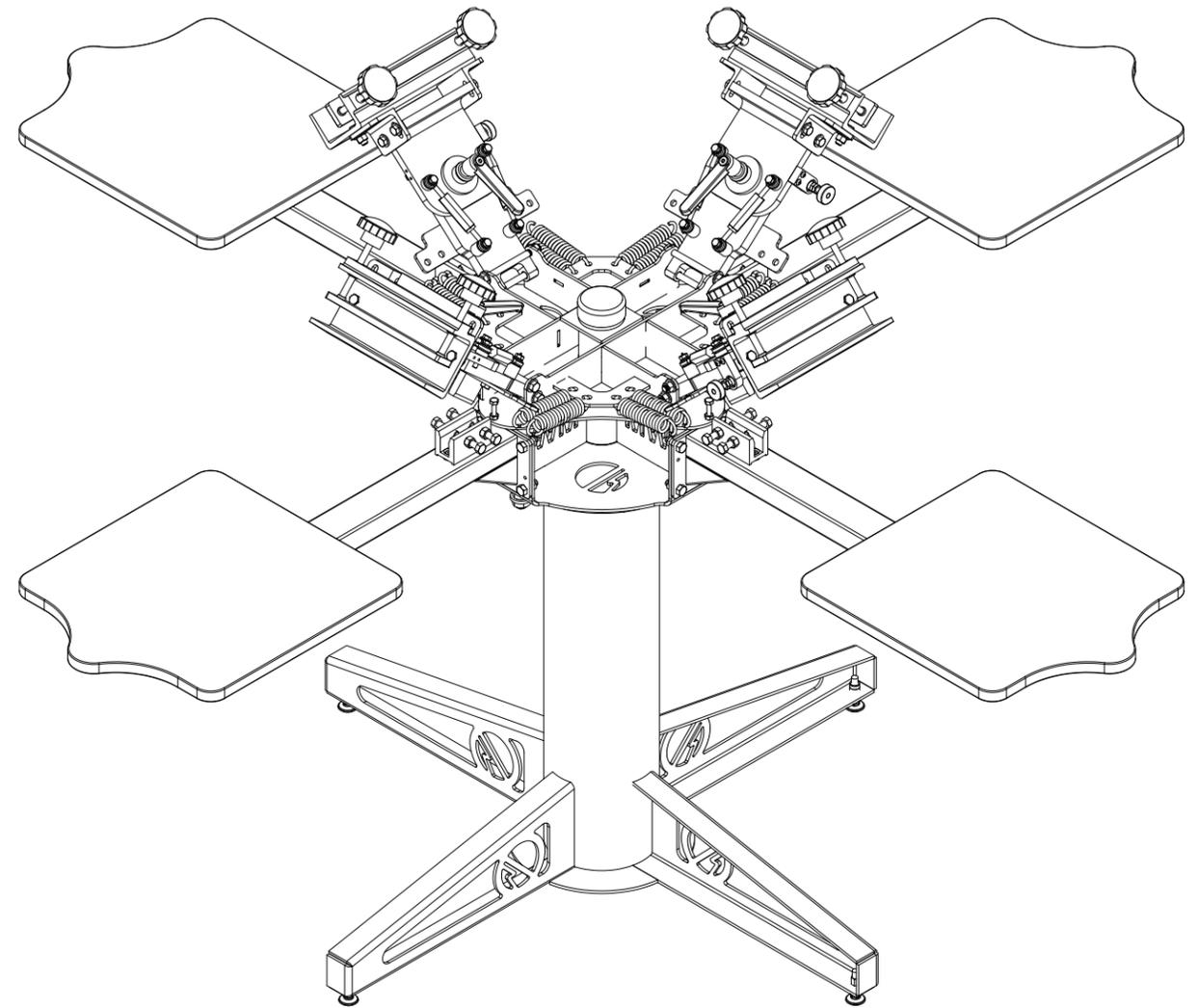


NOTES

Series of horizontal dotted lines for taking notes.



STARTING LINE™ PRESS

Setup And Operating Instructions

HOPKINS INTERNATIONAL™
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RECEIVING YOUR MACHINE

Your press has been crated to keep it from being damaged while in transit. Please inspect exterior of crate while the shipping company driver is present and make a notation on the freight bill if there appears to be any kind of damage. This is your responsibility!!! Be sure the driver signs too, it may help you if there is damage and a damage claim needs to be filed with the freight company.

Once you sign and accept the shipping receipt begin the uncrating process by removing the lid. Next, remove the body of the crate. Using a drill motor and a screwdriver bit remove the screws holding the body of the crate to the pallet on all four sides. After the screws are removed, lift the body of the crate up and over

the press. Next, remove the screws securing the print station to the floor of the crate with a phillips head driver and carefully move the print stations out of the way. Place the print stations on their side so they won't fall over. Please note, the white nylon registration bolts stick out on both sides of the gate. Take care not to drop the print station, as these bolts may be sheared off.

The press is bolted to the pallet floor. It must be unbolted from the underside of the pallet. You will need a 9/16 box wrench or 9/16 socket and ratchet. Unbolt the press from the pallet, slide it off the pallet and place the machine in the location where it is going to be used.

SETUP AND ASSEMBLY

Open the parts bag(s), spread and organize the nuts, bolts, steel roll pins and leg levelers in the area the press is now located.

LEG LEVELERS

Carefully tip each leg of your press up and thread a leg leveler on. Thread the leg levelers all the way up and into the threaded insert of each leg.

PRINT STATIONS

Note: Each print station is numbered on the backside of the mounting plate and each print station location on the rotary indexer has a corresponding number.

Mount the number one print station to the number one station on the rotary indexer. Use the 3/8-16x1" bolts with nuts and washers. Loosely install the 4 mounting bolts and locknuts so the print station can be moved slightly for alignment. (Use a 9/16" wrench and a 9/16" socket and ratchet). After the print station is in place, you will now insert the roll pins by aligning the scribe marks on the side of the mounting plates on the arm and indexer.

Install a roll pin into each pre-drilled hole (2) on each print station by tapping the pin through the hole using a hammer. Each pin should protrude through the holes far enough to be visible on the backside of the mounting plates.

Make sure the scribe marks on each side of the print stations line up with the mark on the companion plate and then secure all four mounting bolts.

Proceed to mount each additional print station to the corresponding numbered location on the rotary indexer. Because this press was factory leveled, it is not necessary to make any adjustments to the print stations.

PRINT HEADS AND SPRINGS

Locate the longer of the bolts in your parts bag (3/8-16 x 4 1/2"). These bolts and the corresponding nuts, along with the clear bumper tubes, are to be used in the bracket the print heads are to be mounted to. The bolts act as a stop, limiting the print heads upper movement. These bolts are removed for shipping purposes and now need to be installed. If any of the springs have come loose from their print head locations, now is the time to re-attach

them. Raise the print head up as far as necessary to attach any loose springs to the print head base and spring retainer bracket. After all springs are attached, pull the print head down and into the registration gate on the print station arm. If the springs are properly affixed there will be resistance felt as the head is lowered into the gate. Take caution that the print head does not come up inadvertently, it could hurt someone!

Begin inserting a bolt into the top hole of one of the print head brackets. As the threads of the bolt appear on the inside of the bracket, put one of the flat washers and then one of the bumper tubes next to the threads and complete the insertion of the bolt into the tube and through the hole and the washer on the other side of the bracket. Attach a 3/8-16 hex nut to the bolt to hold the bolt in place. Do not over tighten the bolt and nut, it could possibly restrict the up and down movement of the head. Complete this task for all the print heads.

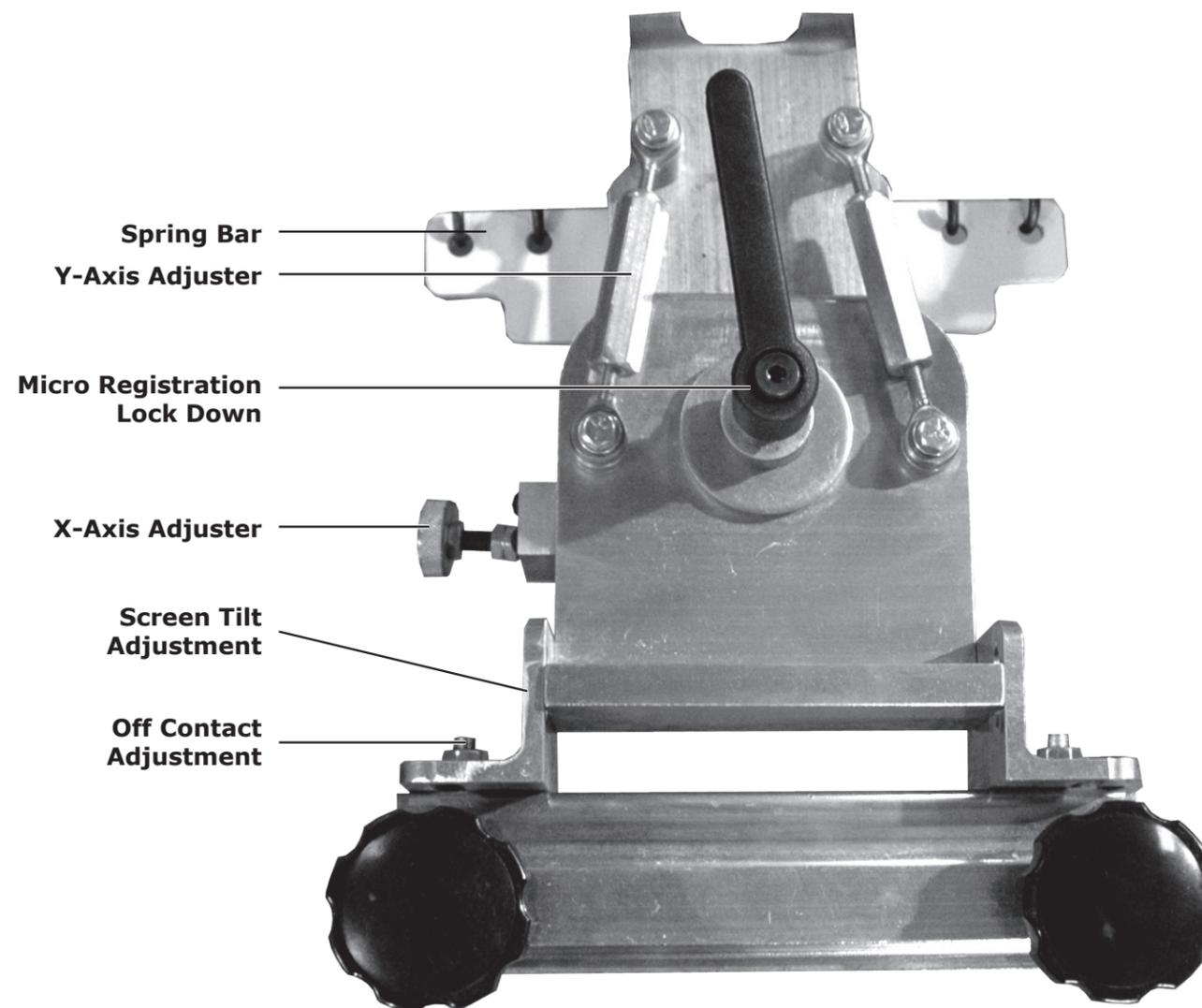
SHIRTBOARD

With the print heads in the up position and resting against the bumper and bolt, slide a shirt board with bracket onto a print station. Rotate the print head wheel into a position that allows a print head to be lowered into the registration gate on the print station arm. Position the shirt board so the rear or back edge of the board is approximately 1/2" from the print head screen clamp. To secure the board in this position hold your left hand on the top of the board's surface pressing down to ensure flatness. With your right hand, tighten the small side knob so it comes in contact with the side of the print station. Now tighten the large knob on the bottom of the bracket. This torque knob will hold the shirt board in place during the printing process. **DO NOT OVER TIGHTEN THESE KNOBS!!!** If you over tighten any of these knobs you may bend the metal of the print station. It is only necessary to snug these knobs.

Raise all the print heads to the up position and give one of them a solid push rotating the entire wheel. The wheel should rotate freely and effortlessly.

Rotate the print station indexer in the same manner. It should rotate easily with a slight noise and hesitation as each print station slips into and out of a print station location.

REGISTRATION ADJUSTMENTS



THESE INSTRUCTIONS ASSUME A MULTI-COLOR JOB IS TO BE PRINTED

Place screen frame into the print head frame clamp and center frame to center of the clamp. Turn down the large black knobs on the top of the clamp to lower the clamp bar down onto the top of the screen frame. Tighten the knob. It's not necessary to over tighten the knob as damage to the screen frame or clamp could occur! Pull the screen frame down and into the registration gate on the print station.

The off contact adjustment is preformed manually. Loosen the 2 nuts on the back of the screen frame clamp as well as the bolts that allow the adjustment of the screen angle.

With the print head and screen frame sitting in the registration gate and the

nuts and bolts loosened, raise the off contact distance between the bottom side of the screen frame and the top of the shirt board. The amount of off contact is dependant on mesh tension and not an issue for this narration. Suffice to say the higher the mesh tension the lower the off contact distance. Manually lift the print head and screen up to the desired height making sure the distance is the same across the entire rear of the screen frame. Tighten the off contact nuts.

Once the off contact is set at the rear of the screen it will be necessary to match that distance at the front of the screen. This adjustment is made manually by raising the front of the screen frame to the desired

height and then tighten the bolts on each side at the back of the clamp that will lock down the screen tilt adjustment. Verify all distances are correct. Re-adjust if needed.

At this point, if fine tuning is necessary to register the screens, Loosen the ratchet handle on top of the print head. Then use the two y-axis micro adjusters to move the screen front to back and/or rotational movements. Left and right adjustments are done with the x-axis micro located on the side of the print head (viewing from the front of the screen) and next to the y-axis adjuster. Once the screens are registered, re-tighten the handle.

Good Printing To You!!!