

# OPERATOR'S MANUAL **HT-400 & HT-600**

Manual Clamshell with Pressure Readout  
15"x15" & 16"x20" Heat Transfer Machines

**EVO TOUCH**



HT400



HT600

# S-450 & S-650

Auto Opening Clamshell with Pressure Readout  
15"x15" & 16"x20" Heat Transfer Machines

**EVO PRO**



S450



S650

For Customer Service:  
Call 1-800-835-0606 or Visit [hixcorp.com](http://hixcorp.com)

**HIX** CORPORATION



# CONTENTS

<i>Receiving &amp; Setup</i> .....	3
<i>Power</i> .....	4
<i>User Adjustable Settings</i> .....	5
<i>Machine Presets</i> .....	6
<i>Platen Pressure</i> .....	7
<i>Transfer Application</i> .....	8
<i>Troubleshooting</i> .....	9-12
<i>Repairs &amp; Maintenance</i> .....	13
<i>Parts List</i> .....	14-15
<i>Warranty</i> .....	16

BEFORE warranty repair you MUST get Prior Authorization



Intertek



Certified Green

# RECEIVING & SETUP

## SHIPPING OR RETURNS

**\*NOTE\*** *Save all of your shipping/packing material. Do not risk costly shipping damage, ship only in original box.*

1. Fasten machine to plywood shipping base with bolts provided.
2. Tie or tape handle securely to base.
3. Place in original box, and put side liner and top liner in place. Fold flaps and seal the box. (Additional bottom boards, box and liners may be obtained from your supplier for a normal cost.)

## UNPACKING

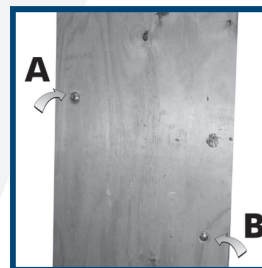
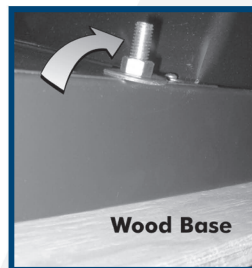
Remember to save all packing material - including box, liner and board. You may need these for shipping your machine or if a repair is necessary in the future.

## INSPECTION

Inspect your machine for hidden shipping damage. Contact the delivery company immediately, should you find damage.

## INSTALLATION

1. Remove plywood shipping base bolts (see A and B) and screw on feet or affix self-adhesive rubber feet provided.



**CAUTION:** Handle must be tied to base before moving or shipping.

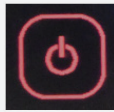
2. Carefully cut tape/wrap holding the machine closed.
3. Plug the machine into the correct grounded electrical outlet.

**WARNING:** When using an extension cord, use 12 or 14 ga.-3 conductor.  
Maximum length, 25' (7.762 m).

# POWER

## TURNING THE POWER “ON”

1. Once the machine is plugged into power, the display will show a “Red Icon” as shown below. To turn the power on to the machine, simply press the Red Icon.



2. The display will then come on and look similar to what is shown below.

To turn the Power “OFF” to the machine, simply press the Green “Power” Icon in the upper right corner of the display and the machine will turn “OFF.”



To adjust the temperature or time settings, simply press the “UP” or “DOWN” arrows to change the values.

As the temperature is warming up from a cold start, the temperature digits will be RED when the heat platen temperature is more than 10 degrees away from desired setpoint temperature.

When the platen temperature is less than 10 degrees, but more than 5 degrees from the desired setpoint the temperature displayed will be YELLOW.


When the platen temperature displayed is within 5 degrees of the desired setpoint, the temperature digits will be GREEN.

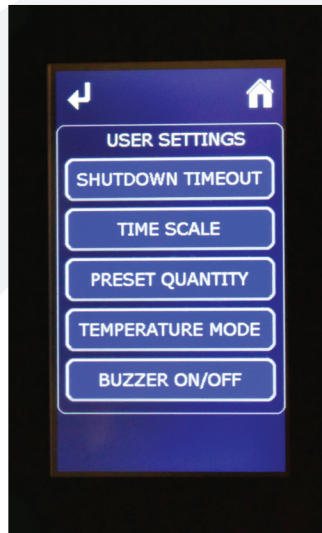
When the actual platen temperature reaches the setpoint, the controller will BEEP.

3. A little “Red Dot” shown above in the lower left corner of the temperature display window represents the “Heat Light.” This indicator will be on when the controller is applying power to the heating element. It is normal for this indicator to flash on and off as heat is required.

# USER ADJUSTABLE SETTINGS

## USER ADJUSTABLE SETTINGS

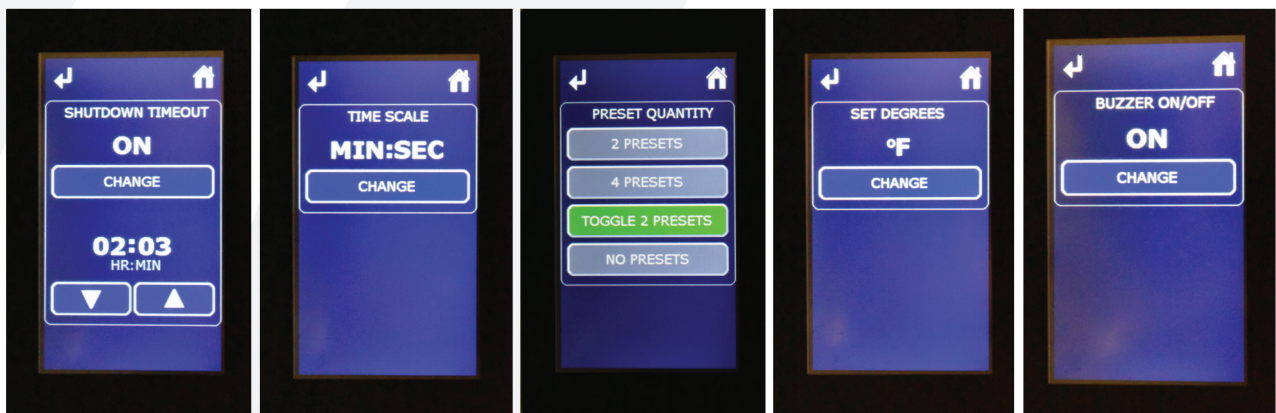
Pressing the “GEAR” Icon  in the upper left corner of the Home Screen will switch the screen to the user settings menu, shown below.



Pressing the “Back Arrow” Icon in the upper left corner of the display will take you to the previous screen.

Pressing the “Home” Icon in the upper right corner of the display will take you to the “HOME” Screen.

Pressing any of the USER SETTINGS buttons will take you to one of the screens shown below where you can adjust the machine settings to your preferences.



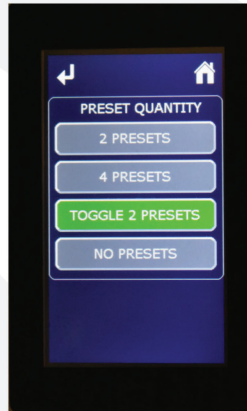
Once you have made the desired adjustments, press the “Back Arrow” or “Home” Icon.

Any changes in any of the settings or values you have made will be automatically stored as you leave that screen.

# MACHINE PRESETS

## PRESETS FOR TIME & TEMPERATURE SETTINGS

The controller has several Time and Temperature Preset options (No Presets, Two Presets, Four Presets, Toggle Two Presets) which are selectable in the “User Adjustable Settings” as outlined on the previous page.



## ON THE HOME SCREEN

If one of the buttons is “GREEN” then that button is the ACTIVE time and temperature preset on the controller. See below:

2 presets option



4 presets option



If you wish to make an adjustment to the time or temperature, simply press the UP/DOWN arrows next to the Time or Temperature values to change the number to the new setting desired.

**NOTE:** You will notice when you change either the Time or the Temperature away from the preset values, all the preset buttons will turn “Gray.”

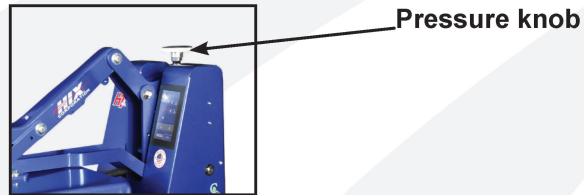
To store the new Time or Temperature value(s) in a preset button location, simply press and HOLD on the desired preset button for 2 seconds. Once the new values are stored, the button will turn GREEN and the controller will BEEP to acknowledge the new values are stored.

To “recall” a preset, simply touch on the desired preset button and the Time and Temperature setting stored in that location will be recalled and displayed in the Time and Temperature values.

# PLATEN PRESSURE

## PRESSURE CONTROL KNOB

The pressure control knob, located on the top of the machine, should be set so that the heat will lock down firmly.



Pressure is reduced by turning knob (with machine open) counter-clockwise and increased by turning is clockwise.

## PLATEN PRESSURE READOUT

The amount of platen pressure being exerted on the transfer and substrate can be monitored on the controller. When the machine is closed, the platen pressure is expressed in a numerical value between 0-9 on the controller home screen. Values of 0-3 indicate “light” pressure, 4-6 “medium” pressure and 7-9 “heavy” pressure. If the value exceeds 9, then “Pressure High” will appear on the display indicating that the maximum value can be displayed has been exceeded.

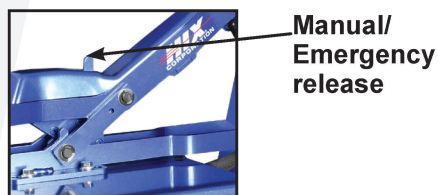
**WARNING:** Excessive pressure can cause structural damage, voiding the machine warranty!

## AUTO-OPEN OVERRIDE (S-450 & S-650 MODELS)

Your semi automatic press features Automatic Opening at the end of each count down timer setting. The press will simply release and open.

**DO NOT** pry or try to open press, there is an emergency release lever atop the handle if you ever need to interrupt the countdown and get the press open.

**CAUTION:** Do not lean over press when cycle is complete. Injury could occur.



# TRANSFER APPLICATION

The **120 volt models** have a slower heat recovery (i.e. 18-20 seconds @ 375°F).

The **220 volt models** are recommended for quicker cycle times (i.e. 10 seconds @ 375°F).

1. Set the temperature, time, & pressure to the desired settings as instructed. **Always** consult your specific transfer recommendations. Typical settings are; **Cold Peel**: 350°F (177°C), 15 seconds and **Hot Split**: 375°F (190°C), 10-12 seconds.

2. Align substrate on lower platen. Smooth wrinkle from garments.

**NOTE:** Wrinkles may be removed by bringing the heated platen in contact with the garment for a few seconds before the transfer is positioned.

3. Position the transfer in the desired location on the substrate.

**NOTE:** The transfer image should be “mirrored” before transferring except when transferring to substrates where the image shows through, i.e. glass tiles and cutting boards.

**TIP:** *When transferring double sided or sublimation transfers to garments, always place a sheet of transfer paper or a PTFE sheet between the layers of the garments to avoid bleed through or reheating of the applied transfer.*

4. Pull the handle down until the handle locks.

**NOTE:** Do not fold the transfer back on itself. Successful transfer work depends on the correct balance of time, temperature and pressure. The type and thickness of the material and the kind of transfer being used will determine what settings are necessary.

For hot peel/split transfers, immediately peel the paper after the machine has opened.

**DO NOT** allow the transfer to cool. For cold peel transfers, rub the transfer with an eraser or cloth and allow to cool for 5-10 seconds before removing the release paper.

# TROUBLESHOOTING

**NOTE:** Specific application instructions are enclosed with transfers.

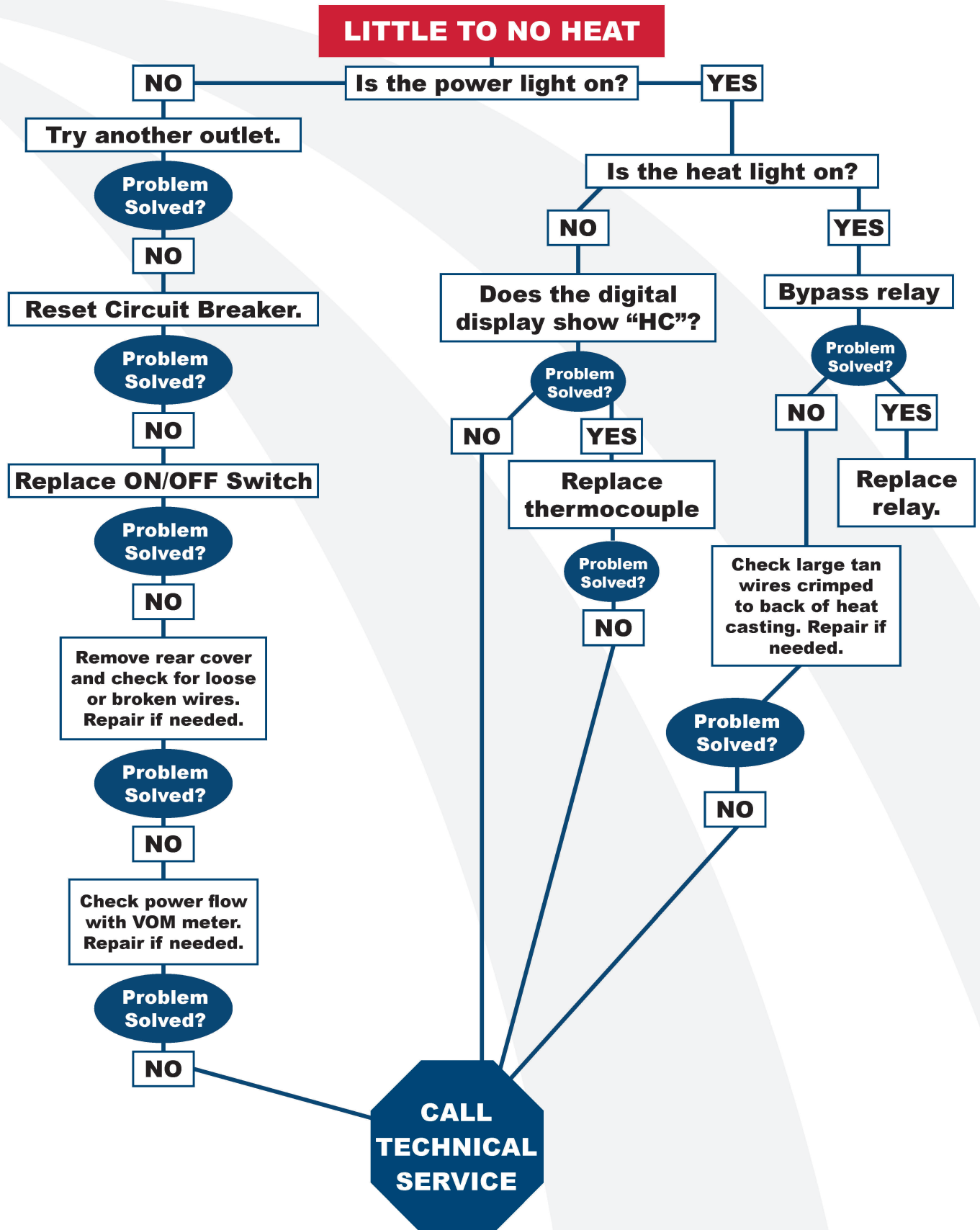
**When you fail to make a successful transfer you can wonder, “Is it the machine’s fault, or the transfer, wrong settings or what?”**

## **FIRST, THE BASICS**

1. Be sure to set the heat transfer machine to the transfer manufacturer’s recommended Temperature, Time and Pressure settings. If you don’t have these specifications, contact your transfer supplier for this information and any other special application instructions as many of the new “High Tech” transfers require significantly different settings and/or application techniques than those from years past.
2. When you start up your press for the first time each day, preheat the pad for a minute. If the press has sat for 3-5 minutes without use, be sure to “preheat” the pad for 10-15 seconds before loading the shirt or making the first transfer.
3. After the shirt is positioned and centered on the preheated pad, “pre-press” the shirt for 3 seconds to take the wrinkles out and more importantly, release any excess moisture out of the T-shirt fabric which can reduce the chance of a successful transfer.
4. With all of the above recommendations, try making a transfer.
5. If successful, great! You are on your way to making some serious money with your transfer machine!
6. If you have an area that isn’t transferring completely or as you would like it to, follow these steps to determine the problem.
  - Try increasing the pressure on the machine by 10-20%
  - Recheck your temperature required and the press readout. You may want to increase the temperature 10 degrees.
  - Try increasing the application time by 2-4 seconds
  - If after trying these things there is still a “specific” area (say over in one corner of the transfer) that isn’t coming out as you would like it to, then try the same type transfer on a scrap shirt but rotate the transfer 180 degrees (changing the failure location) If after doing this the problem area is in the same physical location on the machine, then you probably have a problem with the pad or possibly a warped platen if the machine has ever overheated severely. On the other hand if the transfer failed in the same area on the transfer (after changing the location of where the problem had previously been occurring), then you most likely have a problem with the transfer or it’s application settings (Temperature, Time or Pressure) and you should contact your transfer supplier to discuss the problem.

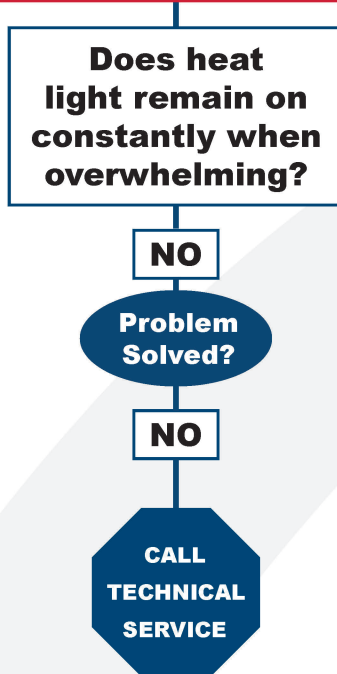
Following these basic guidelines can help you be more successful with each and every transfer!

# TROUBLESHOOTING

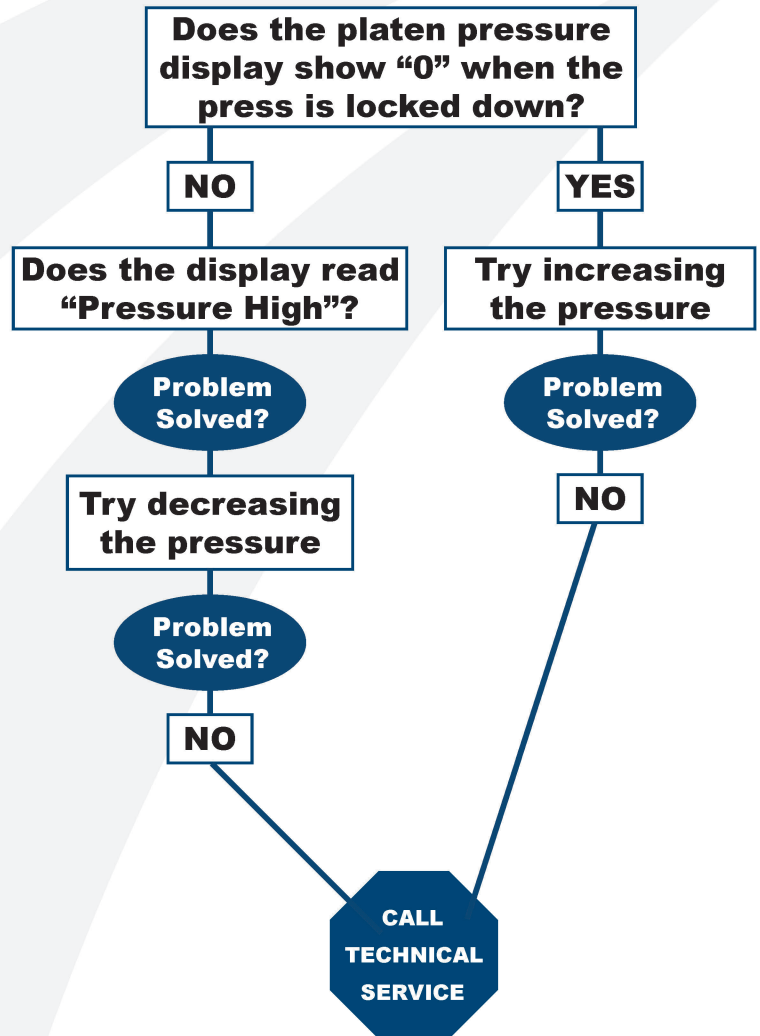


# TROUBLESHOOTING

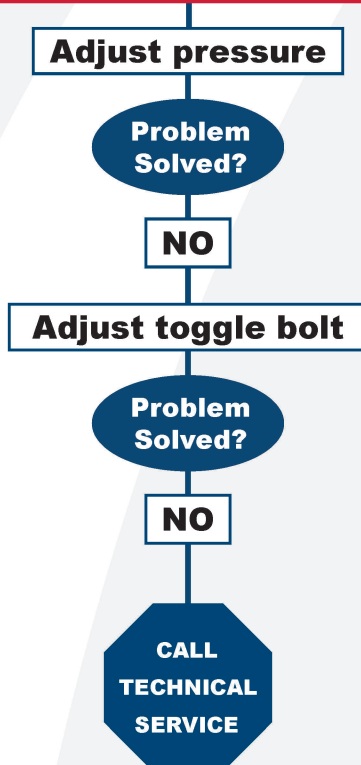
## MACHINE OVERHEATS



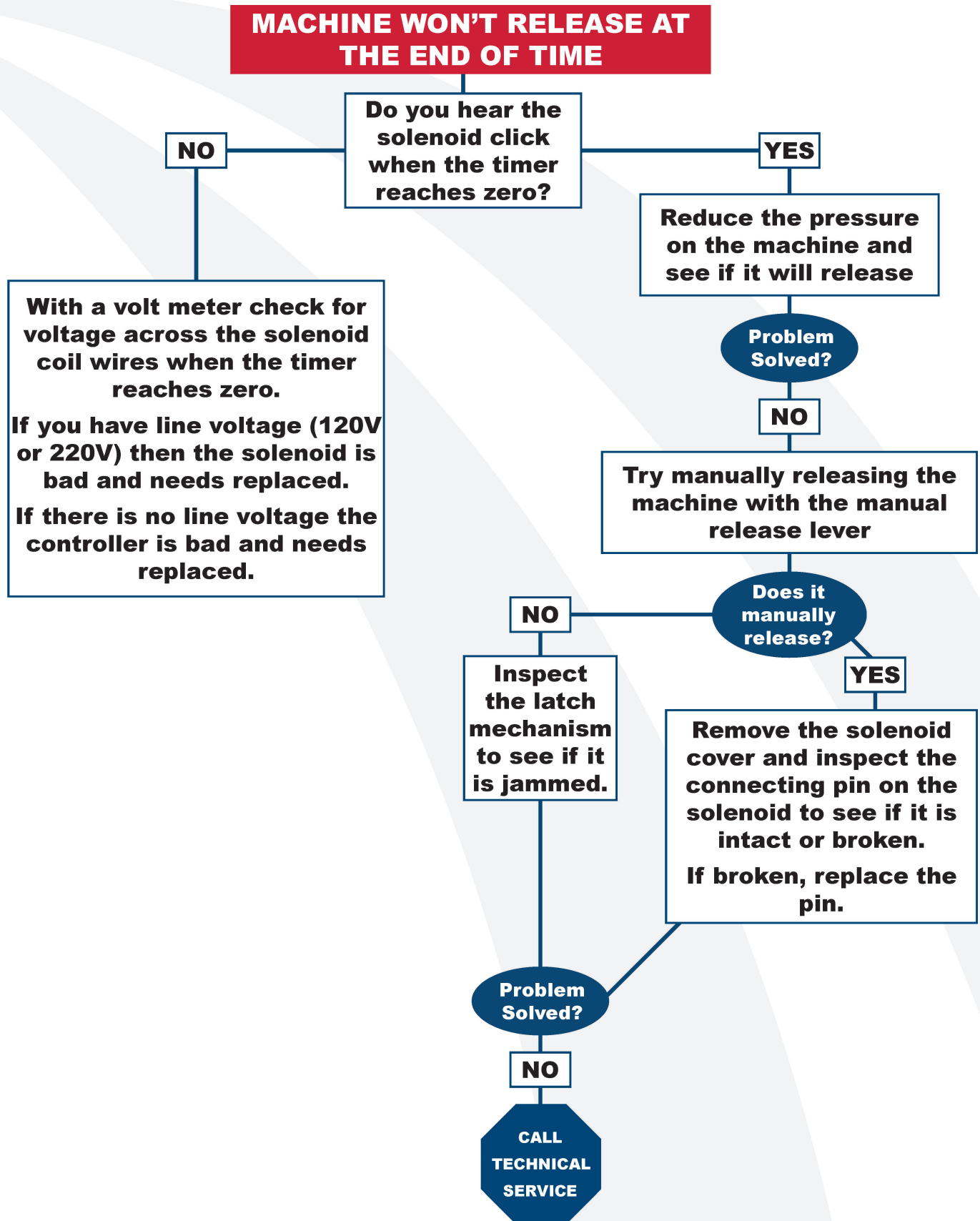
## Platen pressure indicator not working properly.



## MACHINE WON'T STAY CLOSED



# TROUBLESHOOTING



# REPAIRS

## RELAY BYPASS:

**WARNING:** Before making repairs, be sure ON/OFF switch is OFF and machine is unplugged!

1. Remove the back cover of the machine.

**WARNING:** To prevent possible electrical shock, unplug the machine before removing cover to service.

2. Remove wire #26 from terminal #2 on relay.
3. Loosen terminal #1 on relay and replace wire #26 along with wire #12 under terminal #1.
4. Tighten the connection.
5. Plug machine in and turn the power switch on.

**NOTE:** Replace the relay if the machine starts heating. This is a test only. Do not operate machine with relay bypassed.

# MAINTENANCE

## LUBRICATION:

Your press requires lubrication every 15,000 cycles or every 6 months.

Lubricate weekly in a heavy use production environment.

Use NSF/NLG12 rated food grade grease (such as Bel-Ray No-Tox #2 or equivalent).

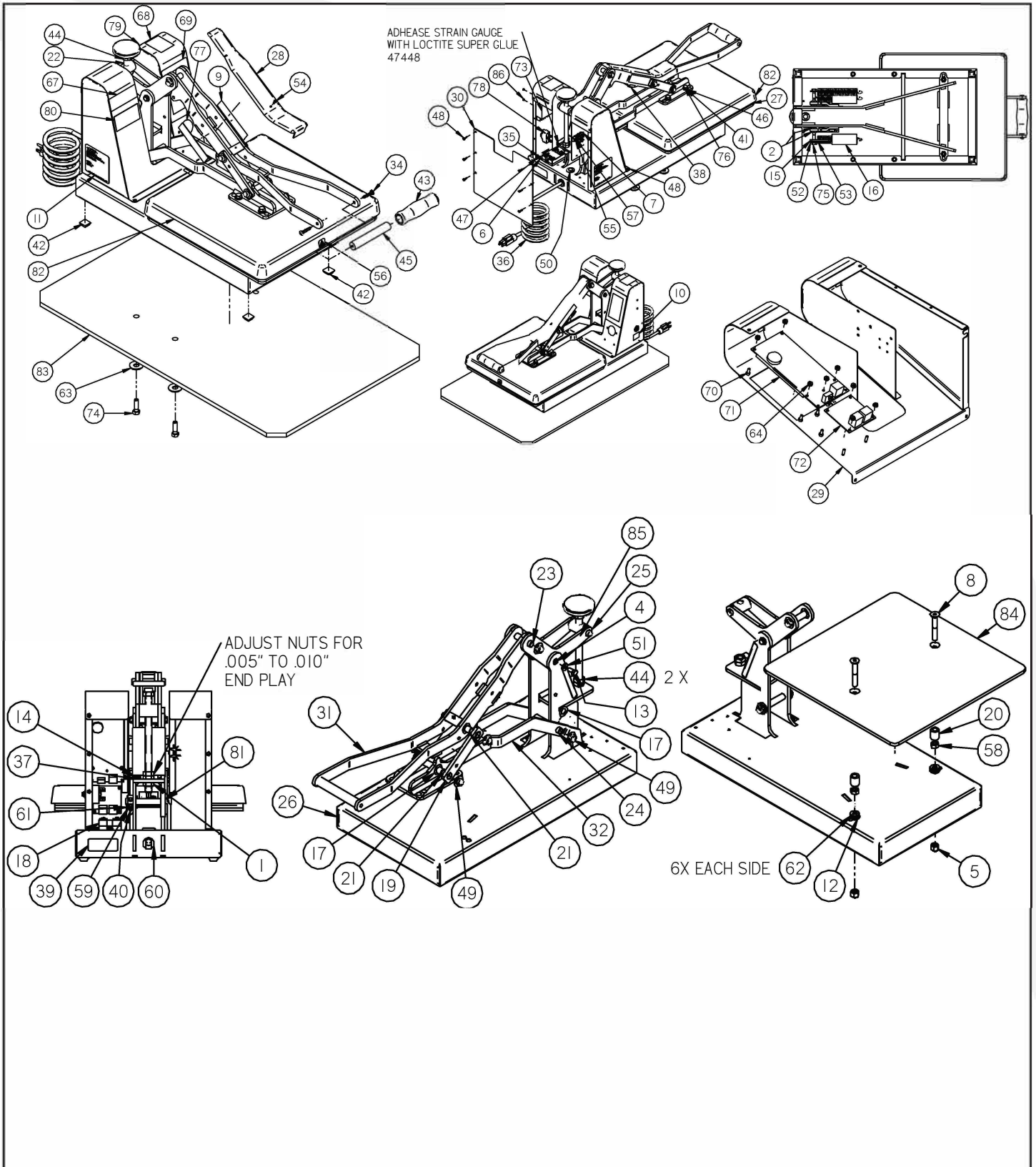
A general purpose food grade machine oil spray is also acceptable such as CRC03055 lubricant (available from retailers such as Amazon).

Lubricate all moving or hinged points.

## CLEANING HEAT PLATEN:

Clean the heat platen with steel wool, scrubbing aluminum sponge, or fine wire brush.

# REPLACEMENT PARTS LIST (HT-400 MODEL)

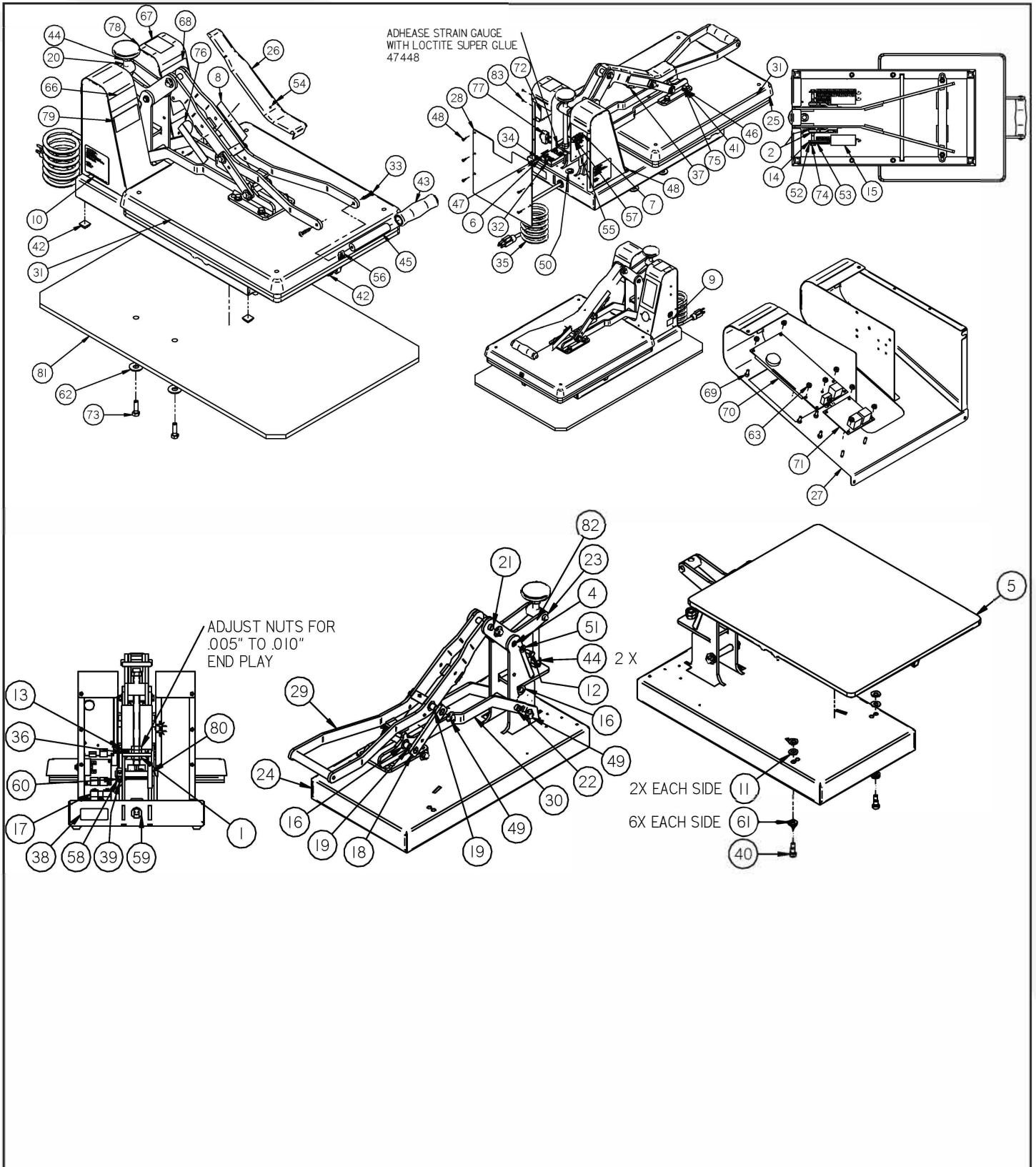


# REPLACEMENT PARTS LIST

## (HT-400 MODEL)

ITEM#	PART#	TITLE	ITEM#	PART#	TITLE
1	89078	NUT 1/2-20 JAM NYLON INSERTZPS	55	15297	SCREW MCH 6-32x0.500 PHPH
2	87619	NUT 5/16-18 JAM	56	14910	DECAL HOT SURFACE SYMBOL
3*	8640502	P-TXM20/DM18/400/600 PACKAGING	57	14621	NUT 6-32 ZPS
4	8611803	O-400/600 PIN THREADED .5x2.5	58	14571	NUT 3/8-16 ZPS
5	81380	NUT 3/8-16 NYLON INSERT ZPS	59	13919	WASHER LOCK HEL SPR #4 ZP
6	73841	TERM 18-14 RING 1/4 NON M	60	13250	CORD GRIP HEYCO 1857 RDD201
7	72223	TERM BD 601-2-KT37,38,39	61	13103	SCREW MCH 4-40x0.750 RHSL
8	71103	SCREW FHSKT 3/8-16X2.500	62	12378	WASHER SPG STL .375x.750x.028
9	70732	DECAL HIX LOGO 4"x1"	63	12229	WASHER FLT .500x1.250x.078 ZPS
10	70362	DECAL CERTIFIED GREEN	64	11349	NUT 6-32 EXT TOOTH LOCK ZPS
11	70268	DECAL HIX I.D. 3"x3" SILVER	65*	11121	WIRE KIT 400/600 120V ANT
12	70009	WASHER FLT .406x0.813x.080 ZPS	66*	11120	MANUAL OWNERS HTM ANT
13	65986	BOLT 1/4-20x0.625	67	11024	DECAL SILVER/RED EVO TOUCH
14	6505020	M-STRAIN GAUGE COVER	68	10963	DECAL QR CODE DXP ANT
15	6505015	M-400/600/450/650 SPG EXT LINK	69	10916	DECAL LCD DISPLAY ANT
16	6501144	P-400/600/450/650 TUBE DAMPEN2	70	10914	SPACER .140x.250X.125 NYLON
17	64203	WASHER FLT .515x0.875x.032 SS	71	10911	CONTROL DISPLAY BD 4.3" COLOR
18	62731	RELAY SS 25A 3-32VDC INPUT	72	10910	CONTROL TEMP I/O BOARD ANT
19	6105036	M-LINK ASSY 400/600 ANT	73	10903	POWER SUPPLY 5VDC 15W
20	6105030	O-400/450 PLATEN SPACER	74	10868	BOLT 3/8-16x1.250
21	6105006	M-HT400 PIN LOWER LINK	75	10793	BOLT 5/16-18x1.750
22	6105005	M-DM18/400/600 PRSURE ADJ ROD	76	10769	BOLT 5/16-18x1.000
23	6105004	M-HT400 PIN ROCKER LINK	77	10664	DECAL MADE IN THE USA ROUND
24	6102008	M-HT400 PIN MAIN ARM	78	10347	CIRCUIT BKR 1-POLE PTR 15A ST
25	6021041	M-ROCKER LINK 400/600 ANT	79	10151	KNOB 1/2-20 KNURLED
26	6020065	M-400/600/450/650 BASE WM ANT	80	10131	DECAL HT-400 SILVER/RED
27	6010062	M-PAD 15x15x3/8 MED BLK MOLDED	81	10012	TRIM-LOK 150 B2 X 3/16 ALUM
28	6003001	O-CVR HANDLE SHORT 400/600	82	0101031	M-ASSY PLATEN 15X15 120V ANT
29	6001031	M-400/600/450/650 ENC WDMT ANT	83	0101010	M-400/600/DM MOUNTING BOARD
30	6001006	M-ENC BACK SHEET UNIVERSAL	84	0100004	M-PLATEN 1515 STL
31	6000133	M-HANDLE WELDMENT 400/600 ANT	85	0100001	M-UNIVERSAL ADJUSTMENT BLOCK
32	6000131	M-MAIN ARM WLDMNT 400/600 ANT	86	10909	SCREW MCH M3-0.5X3 PHP ZPS
33*	59886	SCREW TAP 10-32x0.500 WHHX			
34	59816	SCREW TAP 14x1.250 PHPH			
35	50181	SCREW TAP 1/4-20x0.500 WHHX			
36	39768	CORDSET 120V 14/3 STOW 5-15P			
37	39179	GAUGE STRAIN			
38	35408	BUMPER 1/8X1/2 SQ BLK RUBBER			
39	33605	DECAL UNPLUG MACHINE			
40	31823	SWITCH MICRO SMALL SEMI-HOOK			
41	30910	WASHER LOCK HEL SPR 5/16 ZP			
42	28010	BUMPON BLACK .81"x.30"			
43	26840	HANDLE GRIP 3/4" FOAM BLK			
44	25151	NUT 1/2-20 JAM			
45	2507074	M-GENERIC HTM HANDLE			
46	24732	WASHER FLT .344x0.688x.063 ZPS			
47	21989	WASHER LOCK INT TH #14			
48	21482	SCREW TAP 8x0.500 PHPH			
49	20214	NUT PUSH 1/2 PW500015 EZ			
50	17301	GROMMET .563IDx.750 GRVx.063			
51	16774	WASHER FLT .281x0.625x.063 ZPS			
52	16683	WASHER FLT .375x0.875x.078 ZPS			
53	15834	SPRING HIX #105			
54	15446	SCREW TAP 6x0.375 PHPH			

# REPLACEMENT PARTS LIST (HT-600 MODEL)

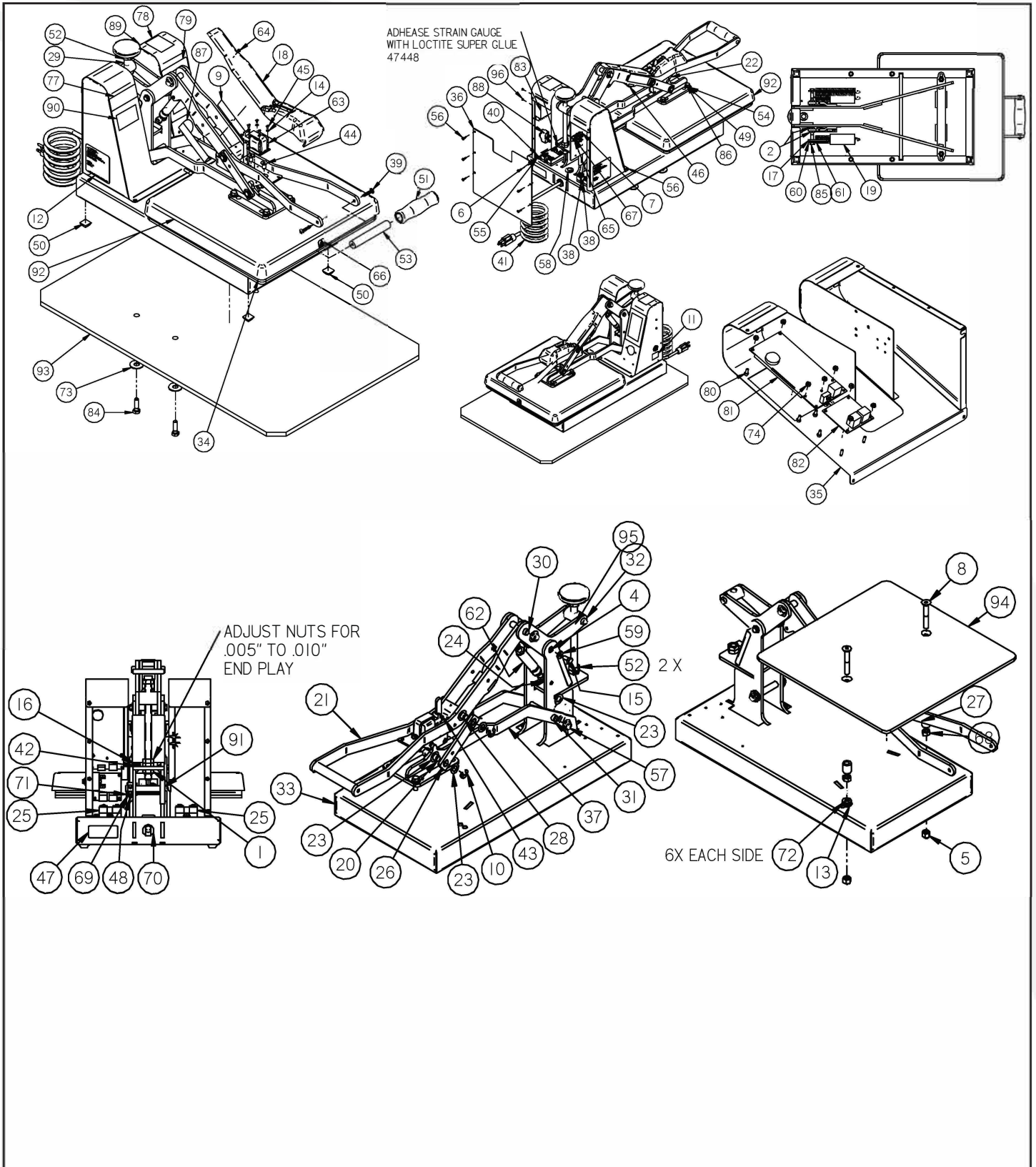


# REPLACEMENT PARTS LIST

## (HT-600 MODEL)

ITEM#	PART#	TITLE	ITEM#	PART#	TITLE
1	89078	NUT 1/2-20 JAM NYLON INSERTZPS	55	15297	SCREW MCH 6-32x0.500 PHPH
2	87619	NUT 5/16-18 JAM	56	14910	DECAL HOT SURFACE SYMBOL
3*	8640502	P-TXM20/DM18/400/600 PACKAGING	57	14621	NUT 6-32 ZPS
4	8611803	O-400/600 PIN THREADED .5x2.5	58	13919	WASHER LOCK HEL SPR #4 ZP
5	82768	M-CASTING 16x20 LOWER F	59	13250	CORD GRIP HEYCO 1857 RDD201
6	73841	TERM 18-14 RING 1/4 NON M	60	13103	SCREW MCH 4-40x0.750 RHSL
7	72223	TERM BD 601-2-KT37,38,39	61	12378	WASHER SPG STL .375x.750x.028
8	70732	DECAL HIX LOGO 4"x1"	62	12229	WASHER FLT .500x1.250x.078 ZPS
9	70362	DECAL CERTIFIED GREEN	63	11349	NUT 6-32 EXT TOOTH LOCK ZPS
10	70268	DECAL HIX I.D. 3"x3" SILVER	64*	11121	WIRE KIT 400/600 120V ANT
11	70009	WASHER FLT .406x0.813x.080 ZPS	65*	11120	MANUAL OWNERS HTM ANT
12	65986	BOLT 1/4-20x0.625	66	11024	DECAL SILVER/RED EVO TOUCH
13	6505020	M-STRAIN GAUGE COVER	67	10963	DECAL QR CODE DXP ANT
14	6505015	M-400/600/450/650 SPG EXT LINK	68	10916	DECAL LCD DISPLAY ANT
15	6501144	P-400/600/450/650 TUBE DAMPEN2	69	10914	SPACER .140x.250X.125 NYLON
16	64203	WASHER FLT .515x0.875x.032 SS	70	10911	CONTROL DISPLAY BD 4.3" COLOR
17	62731	RELAY SS 25A 3-32VDC INPUT	71	10910	CONTROL TEMP I/O BOARD ANT
18	6105036	M-LINK ASSY 400/600 ANT	72	10903	POWER SUPPLY 5VDC 15W
19	6105006	M-HT400 PIN LOWER LINK	73	10868	BOLT 3/8-16x1.250
20	6105005	M-DM18/400/600 PRSURE ADJ ROD	74	10793	BOLT 5/16-18x1.750
21	6105004	M-HT400 PIN ROCKER LINK	75	10769	BOLT 5/16-18x1.000
22	6102008	M-HT400 PIN MAIN ARM	76	10664	DECAL MADE IN THE USA ROUND
23	6021041	M-ROCKER LINK 400/600 ANT	77	10347	CIRCUIT BKR 1-POLE PTR 15A ST
24	6020065	M-400/600/450/650 BASE WM ANT	78	10151	KNOB 1/2-20 KNURLED
25	6010063	M-PAD 16x20x1/2 MED BLK MOLDED	79	10132	DECAL HT-600 SILVER/RED
26	6003001	O-CVR HANDLE SHORT 400/600	80	10012	TRIM-LOK 150 B2 X 3/16 ALUM
27	6001031	M-400/600/450/650 ENC WDMT ANT	81	0101010	M-400/600/DM MOUNTING BOARD
28	6001006	M-ENC BACK SHEET UNIVERSAL	82	0100001	M-UNIVERSAL ADJUSTMENT BLOCK
29	6000133	M-HANDLE WELDMENT 400/600 ANT	83	10909	SCREW MCH M3-0.5X3 PHP ZPS
30	6000131	M-MAIN ARM WLDMNT 400/600 ANT			
31	6000104	M-PLATEN ASSY 16X20 120V ANT			
32	59886	SCREW TAP 10-32x0.500 WHHX			
33	59816	SCREW TAP 14x1.250 PHPH			
34	50181	SCREW TAP 1/4-20x0.500 WHHX			
35	39768	CORDSET 120V 14/3 STOW 5-15P			
36	39179	GAUGE STRAIN			
37	35408	BUMPER 1/8X1/2 SQ BLK RUBBER			
38	33605	DECAL UNPLUG MACHINE			
39	31823	SWITCH MICRO SMALL SEMI-HOOK			
40	30929	BOLT SHOULDER 3/8x1/2x5/16-18			
41	30910	WASHER LOCK HEL SPR 5/16 ZP			
42	28010	BUMPON BLACK .81"x.30"			
43	26840	HANDLE GRIP 3/4" FOAM BLK			
44	25151	NUT 1/2-20 JAM			
45	2507074	M-GENERIC HTM HANDLE			
46	24732	WASHER FLT .344x0.688x.063 ZPS			
47	21989	WASHER LOCK INT TH #14			
48	21482	SCREW TAP 8x0.500 PHPH			
49	20214	NUT PUSH 1/2 PW500015 EZ			
50	17301	GROMMET .563IDx.750 GRVx.063			
51	16774	WASHER FLT .281x0.625x.063 ZPS			
52	16683	WASHER FLT .375x0.875x.078 ZPS			
53	15834	SPRING HIX #105			
54	15446	SCREW TAP 6x0.375 PHPH			

# REPLACEMENT PARTS LIST (S-450 MODEL)

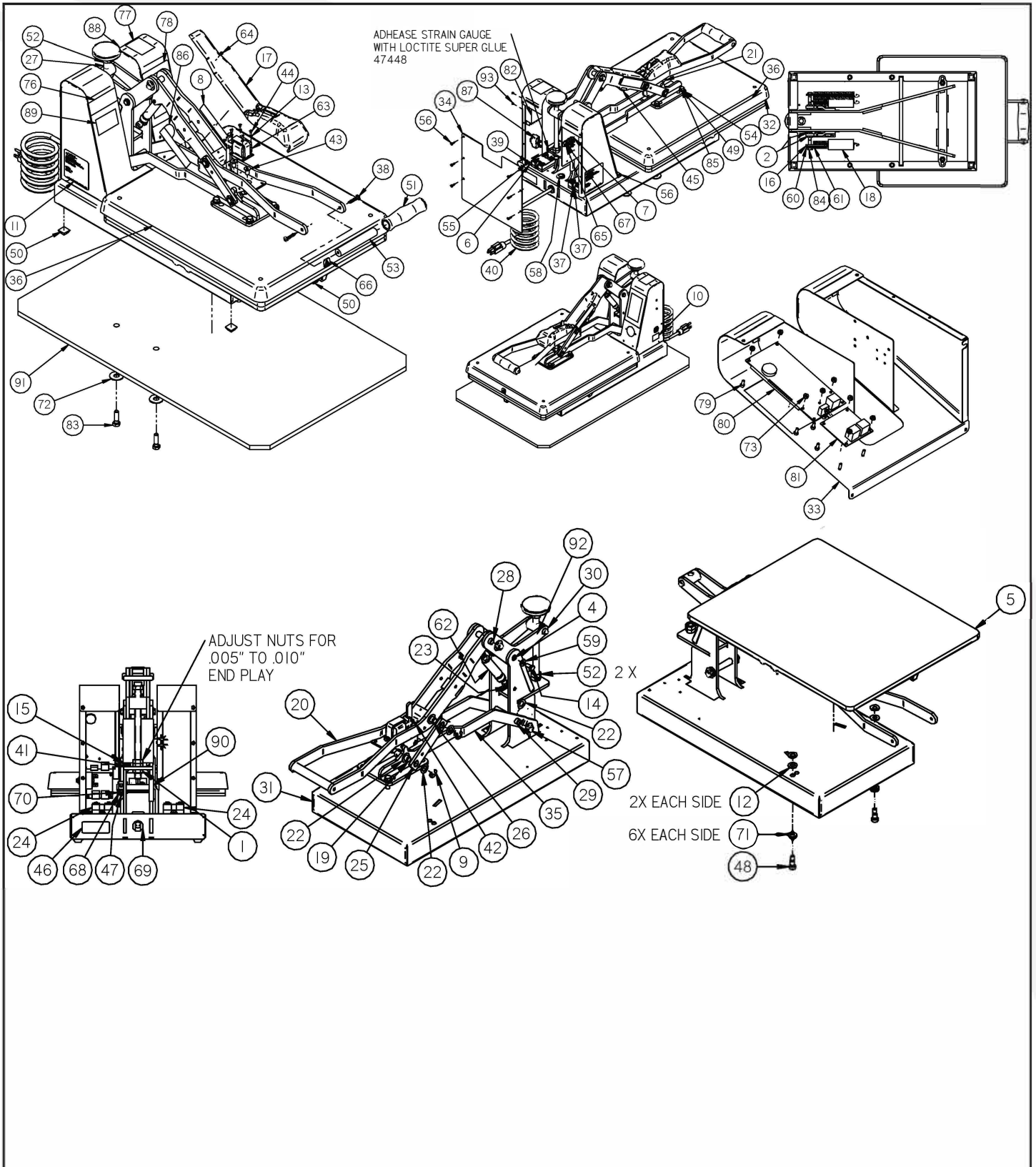


# REPLACEMENT PARTS LIST

## (S-450 MODEL)

ITEM#	PART#	TITLE	ITEM#	PART#	TITLE
1	89078	NUT 1/2-20 JAM NYLON INSERTZPS	55	21989	WASHER LOCK INT TH #14
2	87619	NUT 5/16-18 JAM	56	21482	SCREW TAP 8x0.500 PHPH
3*	8640502	P-TXM20/DM18/400/600 PACKAGING	57	20214	NUT PUSH 1/2 PW500015 EZ
4	8611803	O-400/600 PIN THREADED .5x2.5	58	17301	GROMMET .563IDx.750 GRVx.063
5	81380	NUT 3/8-16 NYLON INSERT ZPS	59	16774	WASHER FLT .281x0.625x.063 ZPS
6	73841	TERM 18-14 RING 1/4 NON M	60	16683	WASHER FLT .375x0.875x.078 ZPS
7	72223	TERM BD 601-2-KT37, 38,39	61	15834	SPRING HIX #105
8	71103	SCREW FHSKT 3/8-16X2.500	62	15753	SPRING GAS 125# P6909
9	70732	DECAL HIX LOGO 4"x1"	63	15751	SOLENOID 120V PULL
10	70693	RETAINING RING EXT 0.500 E	64	15446	SCREW TAP 6x0.375 PHPH
11	70362	DECAL CERTIFIED GREEN	65	15297	SCREW MCH 6-32x0.500 PHPH
12	70268	DECAL HIX I.D. 3"x3" SILVER	66	14910	DECAL HOT SURFACE SYMBOL
13	70009	WASHER FLT .406x0.813x.080 ZPS	67	14621	NUT 6-32 ZPS
14	68330	WASHER LOCK HEL SPR #6 ZP	68	14571	NUT 3/8-16 ZPS
15	65986	BOLT 1/4-20x0.625	69	13919	WASHER LOCK HEL SPR #4 ZP
16	6505020	M-STRAIN GAUGE COVER	70	13250	CORD GRIP HEYCO 1857 RDD201
17	6505015	M-400/600/450/650 SPG EXT LINK	71	13103	SCREW MCH 4-40x0.750 RHSL
18	6503021	O-CVR HANDLE LONG 450/650	72	12378	WASHER SPG STL .375x.750x.028
19	6501144	P-400/600/450/650 TUBE DAMPEN2	73	12229	WASHER FLT .500x1.250x.078 ZPS
20	6501141	M-450/650 LINK PIN MACHINED	74	11349	NUT 6-32 EXT TOOTH LOCK ZPS
21	6500380	M-450/650 HANDLE WELDMNT NEW	75*	11123	WIRE KIT 450/650 120V ANT
22	6500370	M-450/650 LATCH ASSEMBLY	76*	11120	MANUAL OWNERS HTM ANT
23	64203	WASHER FLT .515x0.875x.032 SS	77	11025	DECAL SILVER/RED EVO PRO
24	63428	STUD BALL FOR GAS SPRINGS	78	10963	DECAL QR CODE DXP ANT
25	62731	RELAY SS 25 A 3-32VDC INPUT	79	10916	DECAL LCD DISPLAY ANT
26	6105036	M-LINK ASSY 400/600 ANT	80	10914	SPACER .140x.250x.125 NYLON
27	6105030	O-400/450 PLATEN SPACER	81	10911	CONTROL DISPLAY BD 4.3" COLOR
28	6105022	M-450/650 PIN LOWER LIN	82	10910	CONTROL TEMP I/O BOARD ANT
29	6105005	M-DM18/400/600 PRSURE ADJ ROD	83	10903	POWER SUPPLY 5VDC 15W
30	6105004	M-HT400 PIN ROCKER LINK	84	10868	BOLT 3/8-16x1.250
31	6102008	M-HT400 PIN MAIN ARM	85	10793	BOLT 5/16-18x1.750
32	6021041	M-ROCKER LINK 400/600 ANT	86	10769	BOLT 5/16-18x1.000
33	6020065	M-400/600/450/650 BASE WM ANT	87	10664	DECAL MADE IN THE USA ROUND
34	6010062	M-PAD 15x15x3/8 MED BLK MOLDED	88	10347	CIRCUIT BKR 1-POLE PTR 15A ST
35	6001031	M-400/600/450/650 ENC WDMT ANT	89	10151	KNOB 1/2-20 KNURLED
36	6001006	M-ENC BACK SHEET UNIVERSAL	90	10133	DECAL S-450
37	6000131	M-MAIN ARM WLDMNT 400/600 ANT	91	10012	TRIM-LOK 150 B2 X 3/16 ALUM
38	59886	SCREW TAP 10-32x0.500 WHHX	92	0101031	M-ASSY PLATEN 15X15 120V ANT
39	59816	SCREW TAP 14x1.250 PHPH	93	0101010	M-400/600/DM MOUNTING BOARD
40	50181	SCREW TAP 1/4-20x0.500 WHHX	94	0100004	M-PLATEN 1515 STL
41	39768	CORDSET 120V 14/3 STOW 5-15P	95	0100001	M-UNIVERSAL ADJUSTMENT BLOCK
42	39179	GAUGE STRAIN	96	10909	SCREW MCH M3-0.5X3 PHP ZPS
43	37001	PIN DOWEL 0.125x1.250			
44	36846	SCREW FHSKT 5/16-18x0.625			
45	36587	SCREW MCH 6-32x0.250 PHPH			
46	35408	BUMPER 1/8X1/2 SQ BLK RUBBER			
47	33605	DECAL UNPLUG MACHINE			
48	31823	SWITCH MICRO SMALL SEMI-HOOK			
49	30910	WASHER LOCK HEL SPR 5/16 ZP			
50	28010	BUMPON BLACK .81"x.30"			
51	26840	HANDLE GRIP 3/4" FOAM BLK			
52	25151	NUT 1/2-20 JAM			
53	2507074	M-GENERIC HTM HANDLE			
54	24732	WASHER FLT .344x0.688x.063 ZPS			

# REPLACEMENT PARTS LIST (S-650 MODEL)



# REPLACEMENT PARTS LIST

## (S-650 MODEL)

ITEM#	PART#	TITLE	ITEM#	PART#	TITLE
1	89078	NUT 1/2-20 JAM NYLON INSERTZPS	55	21989	WASHER LOCK INT TH #14
2	87619	NUT 5/16-18 JAM	56	21482	SCREW TAP 8x0.500 PHPH
3*	8640502	P-TXM20/DM18/400/600 PACKAGING	57	20214	NUT PUSH 1/2 PW500015 EZ
4	8611803	O-400/600 PIN THREADED .5x2.5	58	17301	GROMMET .563IDx.750 GRVx.063
5	82768	M-CASTING 16x20 LOWER F	59	16774	WASHER FLT .281x0.625x.063 ZPS
6	73841	TERM 18-14 RING 1/4 NON M	60	16683	WASHER FLT .375x0.875x.078 ZPS
7	72223	TERM BD 601-2-KT37,38,39	61	15834	SPRING HIX #105
8	70732	DECAL HIX LOGO 4"x1"	62	15753	SPRING GAS 125# P6909
9	70693	RETAINING RING EXT 0.500 E	63	15751	SOLENOID 120V PULL
10	70362	DECAL CERTIFIED GREEN	64	15446	SCREW TAP 6x0.375 PHPH
11	70268	DECAL HIX I.D. 3"x3" SILVER	65	15297	SCREW MCH 6-32x0.500 PHPH
12	70009	WASHER FLT .406x0.813x.080 ZPS	66	14910	DECAL HOT SURFACE SYMBOL
13	68330	WASHER LOCK HEL SPR #6 ZP	67	14621	NUT 6-32 ZPS
14	65986	BOLT 1/4-20x0.625	68	13919	WASHER LOCK HEL SPR #4 ZP
15	6505020	M-STRAIN GAUGE COVER	69	13250	CORD GRIP HEYCO 1857 RDD201
16	6505015	M-400/600/450/650 SPG EXT LINK	70	13103	SCREW MCH 4-40x0.750 RHSL
17	6503021	O-CVR HANDLE LONG 450/650	71	12378	WASHER SPG STL .375x.750x.028
18	6501144	P-400/600/450/650 TUBE DAMPEN2	72	12229	WASHER FLT .500x1.250x.078 ZPS
19	6501141	M-450/650 LINK PIN MACHINED	73	11349	NUT 6-32 EXT TOOTH LOCK ZPS
20	6500380	M-450/650 HANDLE WELDMNT NEW	74*	11123	WIRE KIT 450/650 120V ANT
21	6500370	M-450/650 LATCH ASSEMBLY	75*	11120	MANUAL OWNERS HTM ANT
22	64203	WASHER FLT .515x0.875x.032 SS	76	11025	DECAL SILVER/RED EVO PRO
23	63428	STUD BALL FOR GAS SPRINGS	77	10963	DECAL QR CODE DXP ANT
24	62731	RELAY SS 25A 3-32VDC INPUT	78	10916	DECAL LCD DISPLAY ANT
25	6105036	M-LINK ASSY 400/600 ANT	79	10914	SPACER .140x.250x.125 NYLON
26	6105022	M-450/650 PIN LOWER LIN	80	10911	CONTROL DISPLAY BD 4.3" COLOR
27	6105005	M-DM18/400/600 PRSURE ADJ ROD	81	10910	CONTROL TEMP I/O BOARD ANT
28	6105004	M-HT400 PIN ROCKER LINK	82	10903	POWER SUPPLY 5VDC 15W
29	6102008	M-HT400 PIN MAIN ARM	83	10868	BOLT 3/8-16x1.250
30	6021041	M-ROCKER LINK 400/600 ANT	84	10793	BOLT 5/16-18x1.750
31	6020065	M-400/600/450/650 BASE WM ANT	85	10769	BOLT 5/16-18x1.000
32	6010063	M-PAD 16x20x1/2 MED BLK MOLDED	86	10664	DECAL MADE IN THE USA ROUND
33	6001031	M-400/600/450/650 ENC WDMT ANT	87	10347	CIRCUIT BKR 1-POLE PTR 15A ST
34	6001006	M-ENC BACK SHEET UNIVERSAL	88	10151	KNOB 1/2-20 KNURLED
35	6000131	M-MAIN ARM WLDMNT 400/600 ANT	89	10134	DECAL S-650
36	6000104	M-PLATEN ASSY 16X20 120V ANT	90	10012	TRIM-LOK 150 B2 X 3/16 ALUM
37	59886	SCREW TAP 10-32x0.500 WHHX	91	0101010	M-400/600/DM MOUNTING BOARD
38	59816	SCREW TAP 14x1.250 PHPH	92	0100001	M-UNIVERSAL ADJUSTMENT BLOCK
39	50181	SCREW TAP 1/4-20x0.500 WHHX	93	10909	SCREW MCH M3-0.5X3 PHP ZPS
40	39768	CORDSET 120V 14/3 STOW 5-15P			
41	39179	GAUGE STRAIN			
42	37001	PIN DOWEL 0.125x1.250			
43	36846	SCREW FHSKT 5/16-18x0.625			
44	36587	SCREW MCH 6-32x0.250 PHPH			
45	35408	BUMPER 1/8X1/2 SQ BLK RUBBER			
46	33605	DECAL UNPLUG MACHINE			
47	31823	SWITCH MICRO SMALL SEMI-HOOK			
48	30929	BOLT SHOULDER 3/8x1/2x5/16-18			
49	30910	WASHER LOCK HEL SPR 5/16 ZP			
50	28010	BUMPON BLACK .81"x.30"			
51	26840	HANDLE GRIP 3/4" FOAM BLK			
52	25151	NUT 1/2-20 JAM			
53	2507074	M-GENERIC HTM HANDLE			
54	24732	WASHER FLT .344x0.688x.063 ZPS			

# WARRANTY

**BEFORE warranty repair you MUST get Prior Authorization: Call 1-800-835-0606 Warranty will be voided otherwise.**

**(Effective 9/1/2021)**

HIX® Corporation (HIX) will automatically register the equipment on the date it was shipped to you or your distributor. If the equipment was not purchased directly from HIX, but through a distributor, please keep a copy of their sales invoice showing the serial number and date it was sold/shipped to you with this warranty. In this case, we will use the distributor's invoice date as the beginning warranty date. **STAPLE A COPY OF YOUR PROOF OF PURCHASE TO THIS WARRANTY** and keep in a safe place to provide verification of your warranty should a problem occur. Thank you.

Please fill in the following information and attach a copy of your receipt for your records.

**Date Purchased:** \_\_\_\_\_ **From:** \_\_\_\_\_  
**Model #:** \_\_\_\_\_ **Serial #:** \_\_\_\_\_

This warranty applies to Graphics equipment manufactured by the HIX® Corporation (HIX), Pittsburg, Kansas, U.S.A. HIX warrants to the original purchaser, its Heat Transfer Machines, Ovens and Dryers, Printers, Spotholders and Exposure Units, against defects in workmanship and material, except for wear and tear for a period of "One Year" from the date of purchase. HIX warrants Accessories for a period of 90 days from the date of purchase. doughXpress® products are covered under separate warranty.

In the event of a defect, HIX, at its option, will repair, replace or substitute the defective item at no cost during this warranty period subject to the limitations of insurance and shipping costs stated below (excludes labor).

In the case of heat transfer presses (except the Hobby Lite® and Large Format presses), HIX warrants the heat casting for the "Life" of the machine for the original purchaser. If a part becomes obsolete at the time for repair, and/or cannot be reasonably substituted for, HIX will credit, at half the then current list price or last recorded price, only that part toward a new machine or any product HIX offers. This credit offer shall be the sole responsibility of the HIX in the event of an obsolete part.

This warranty does not cover belts, rail tape, pads, mug wraps, canvas, rubber blankets, bulbs, glass. Warranty does not cover damages due to accident, misuse/abuse, alterations or damage due to neglect, shipping or lack of proper lubrication or maintenance. HIX shall not be responsible for repairs or alterations made by any person without the prior written authorization by HIX. This warranty is the sole and exclusive warranty of HIX and no person, agent, distributor, or dealer of HIX is authorized to change, amend or modify the terms set forth herein, in whole or in part.

In the case of a problem with the equipment identified herein, HIX should be contacted during regular business hours to discuss the problem and verify an existing warranty. HIX personnel will assist the customer to correct any problems which can be corrected through operation or maintenance instructions, simple mechanical adjustments, or replacement of parts. In the event the problem cannot be corrected by phone, and upon the issuance of a return authorization by HIX, the equipment shall be returned to HIX or an authorized service representative. All insurance, packaging and shipment/freight costs are solely the responsibility of the customer, and not that of HIX, and HIX shall not be responsible for improper packaging, handling or damage in transit. Contact HIX customer service for complete return authorization information. Correct shipping boxes are available from HIX.

This expressed warranty is given in lieu of any and all other warranties, whether expressed or implied, including but not limited to those of merchantability and fitness for a particular purpose, and constitutes the only warranty made by HIX.

In no event shall HIX's liability for breach of warranty extend beyond the obligation to repair or replace the nonconforming goods. HIX shall not be liable for any other damages, either incidental or consequential, or the action as brought in contract, negligence or otherwise.

This warranty gives you specific legal rights and you may also have other rights which vary from state to state.



1201 E. 27th Terrace • Pittsburg, KS 66762 • U.S.A.

Phone: (800) 835-0606 • Fax: (620) 231-1598

Web site: [hixcorp.com](http://hixcorp.com) • E-Mail: [support@hixcorp.com](mailto:support@hixcorp.com)