D-100 and D-1000 Series Dryer
Assembly and Operating Instructions

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Serial Number: VTX

Date: / / 

(Please log your machine's serial number and date of purchase for future reference.)

Electrical Drawing #: __________________________ Rev: ______

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Introduction

Congratulations, you have chosen a VASTEX conveyor curing system. VASTEX has been designing and building dryers since 1960 and has the knowledge and expertise to supply a quality dryer and help you keep it running for years to come. VASTEX has innovated many of the features found in conveyor ovens today from control methods, modular features, air movements and belt tracking.

Vastex Infrared Dryer have been Factory tested and burned in for a period of 2-8 hours. All components are tested to be sure they work correctly when the Dryer leaves our factory.

Safety

The Instruction Manual and Safety Instructions must be read and understood by anyone operating the Vastex Conveyor Drying System.

- The operator should read and understand the instruction manual before operating this equipment. Store instruction manual and safety instructions near equipment for easy access to operators.
- VASTEX Conveyor Drying System is intended for the curing of non-flammable inks on screen printed materials. Do not use for any other purpose unless authorized by Vastex International, Inc. Use of this equipment for any other purpose can be dangerous and may cause damage to this equipment, voiding the warranty.
- It is recommended that the area around this equipment be designated as a work area and only authorized employees be allowed in the area.
- Children and pets must be kept clear of the work area.
- Do not place any objects on top of the drying chamber. Surfaces are hot!
- Never leave equipment unattended.
- Do not operate conveyor or dryer with any cover or guard removed.
- Operator must be familiar with controls of the dryer and conveyor.
- Never put excessive load on the conveyor belt.
- Before starting production, the operator must check that all covers and guards are in place, no material has been left on the conveyor, and the work area is clear of obstructions.
- Switch on and verify conveyor belt is moving before turning on the heat.
- Allow dryer to cool to 300°F (149°C) or turn off heat for 10 to 15 minutes before switching off conveyor.
- Always turn off power at the main disconnect at the end of production.
- In case an abnormal symptom occurs, for example excessive vibration, noise, and strong smell or smoke development, turn off the VASTEX Conveyor Curing System and contact a qualified technician.
- Immediately turn off the VASTEX Conveyor Curing System if products become jammed in the drying chamber or conveyor belt.
- Do not remove any cover or guard until power at the main disconnect is switched off and locked out. No unauthorized persons are to be allowed inside the control boxes.
- Turn off and lock out power at the main disconnect before any cleaning or maintenance.
- Only qualified technicians should be allowed to make repairs on the VASTEX Conveyor Drying System.
Stability during use, transportation, assembly, testing, and foreseeable breakdowns:

The D-100 and D-1000 dryers are designed and expected to be inherently stable under all foreseeable conditions of use, assembly, testing, etc., so long as the procedures listed in this manual are followed. Be certain that your workbench, table, or stand can safely support the weight of your ma-

Safe handling, transport, and storage:

Unplug your dryer and allow it to cool before storing. When handling or transporting your machinery, be aware of the following weights and dimensions:

D-100: Assembled — 89 lbs (40.4 kg); 46” x 24” x 24” (119 x 61 x 61 cm)
Boxes: #1 – 57 lbs (25.9 kg); #2 – 14 lbs (6.4 kg); #3 – 18 lbs (8.2 kg); Boxes on skid: 115 lbs (52.2 kg)

D-1000: Assembled — 116 lbs (52.6 kg), 46” x 32” x 24” (119 x 81 x 61 cm)
Boxes: #1 – 38 lbs (17.2 kg); #2 – 43 lbs (19.5 kg); #3 – 35 lbs (15.9 kg); Boxes on skid: 137 lbs (62.1 kg)

Safety during adjustment and maintenance

Before beginning any maintenance or adjustment procedures on your dryer:

- If the machine’s heater has been ON, shut the heat control OFF, but allow the belt to continue running for 10 -15 minutes, or until the heater has cooled to 300°F (149°C) or lower . If the belt is stopped while the heater is hot, belt damage will occur.
- Switch machine OFF and disconnect from power before beginning any adjustment or maintenance.
- Do not attempt any maintenance while machine is powered.
- Do not run machine with panels or guards removed.

Adjustment and Maintenance:

- Periodically check ink temperature on garments exiting machine. See page 11, “Operation Tips.” Readjust temperature control as necessary to maintain correct temperature for your application.
- Occasionally, check belt tracking and adjust if necessary. See page 9, step 12.
- Chains in chain drives can loosen over time; occasionally check the tension on the chain in your machine.

In the event of a malfunction or breakdown:

- Allow heater to cool, then shut off machine and disconnect from power as described above in “Safety during adjustment and maintenance.”
- Follow the troubleshooting chart below
- If the chart does not resolve the trouble, contact Vastex for additional assistance.

<table>
<thead>
<tr>
<th>Symptom</th>
<th>Possible Cause</th>
<th>Solution</th>
</tr>
</thead>
<tbody>
<tr>
<td>No functions operate</td>
<td>Machine unplugged Building wiring fault</td>
<td>Make sure machine is plugged in. Have wiring checked.</td>
</tr>
<tr>
<td>Belt does not move</td>
<td>Belt circuit fuse(s) blown Speed control faulty Belt motor faulty</td>
<td>Check or replace fuse(s). Replace. Contact Vastex. Replace. Contact Vastex.</td>
</tr>
<tr>
<td>No heat</td>
<td>Faulty heater control Faulty heater assembly</td>
<td>Replace. Contact Vastex. Replace. Contact Vastex.</td>
</tr>
</tbody>
</table>
Package Contents D-100 only

3 Separate Cartons

Carton #1  Conveyor Components

Conveyor Assembly

Conveyor Belt

Carton #2  16 x 16 Infrared Heater

1) Chain Guard
1) Hardware package with:
6 screws and 2 belt guards.

Carton #3  Chamber Components

Hardware Package Contains
(1) Wire Cover
(2) Knobs
(2) Heater Hold Down Tab
(2) Heater Hanger Bracket
(40) Black #8 Sheet Mtl Screws
(1) 1/4” & 7/16” Hex Wrench
Package Contents D-1000 only

3 Separate Cartons

Carton #1 Front Conveyor Components

Carton #2 Rear Conveyor Components

Carton #3 Chamber and heater Components

Additional items above:
1) Belt, 1) Chain guard, and 1) Hardware package with: 6 screws and 2 belt guards.

Hardware Package Contains
(1) Wire Cover
(2) Knobs
(2) Heater Hold Down Tab
(2) Heater Hanger Bracket
(40) Black #8 Sheet Mtl Screws
(1) 1/4” & 7/16” Hex Wrench

Install hanger with provided #8 sht metal screws as shown above
**Chamber Components**

**IR Heater**
The infrared heaters in VASTEX dryers emit medium wave infrared heat, perfect for curing many types of fabric inks. The heater height and tilt is adjusted by knobs located on the sides of the chamber. A heater height scale allows for accurate height adjustment.

<table>
<thead>
<tr>
<th>Model</th>
<th>Description</th>
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<tbody>
<tr>
<td>HI-16-D100-120</td>
<td></td>
</tr>
<tr>
<td>HI-16-D100-240</td>
<td></td>
</tr>
<tr>
<td>HI-1620-D1000-120</td>
<td></td>
</tr>
<tr>
<td>HI-1620-D1000-240</td>
<td></td>
</tr>
</tbody>
</table>

**Conveyor Components**

**Belt**
The conveyor belt is made of Teflon coated fiberglass. It is joined together with an alligator lace using a steel pin to connect each side. The belt will not burn under normal conditions but the dryer should always have the belt moving while the heater is hot. The belt should remain tracked in the center of each pulley. (See Belt Installation and Tracking for adjustment instructions.)

- D100: p/n 04-06-065
- D1000: p/n 04-06-131
- D100 extension belt: p/n 04-06-132

**Aligner**
The aligner is a device for tracking the belt and keeping it on the pulley. As the belt moves from side to side the aligner is used for adjustments to keep it centered. The belt does not have to be perfectly centered on the pulley but should not be hanging over either edge.

**Pulley**
The pulleys at either end of the conveyor are made by VASTEX of 4 ½ inch tubing with ¾ inch center shaft. They are mounted on self aligning flange bearing blocks for precision rolling.

**Gear Motor**
A 90 Volt DC gear motor is located to the rear of the conveyor. It drives the rear pulley and belt with a roller and a #25 chain.

<table>
<thead>
<tr>
<th>P/N</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>04-02-005</td>
<td>A 90 Volt DC gear motor</td>
</tr>
</tbody>
</table>

**Belt Speed Control**
Rotate knob clockwise to increase, counter clockwise to decrease belt speed. Turn knob counter clockwise until it clicks for off position.

<table>
<thead>
<tr>
<th>P/N</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>04-01-004</td>
<td>Rotate knob clockwise</td>
</tr>
<tr>
<td>04-01-005</td>
<td>Rotate knob counter clockwise</td>
</tr>
</tbody>
</table>

**Heat Control**
Turns power on/off and varies heater temperature.

<table>
<thead>
<tr>
<th>P/N</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>04-01-008</td>
<td>Turns power on/off</td>
</tr>
<tr>
<td>04-01-009</td>
<td>Turns power on/off</td>
</tr>
</tbody>
</table>

**Fuses**
Protects the belt drive control circuit.

- P/N 04-03-057: (Fuse AGC 1 amp)

One required for 120V Dryers, two required for 240V Dryers
Assembly D1000 conveyor only

The D1000 conveyor comes in two sections. Slide them together while interlocking the joiner plates and insert six (6) screws on each side as shown below.

Inner and outer joiner plates go together as shown above.

NOTE: D100 conveyor come shipped as one piece.

Optional 10” Conveyor Extension D1000

The optional D-1000 conveyor extension comes complete. Instruction for installation are as follows: Disconnect all power. Remove dryer chamber via 3 or 4 sheet metal screws on each side. Separate conveyor belt. Remove front and back halves of the conveyor via 6 screws.

Separate front and rear conveyor sections. Insert the 10” conveyor extension noting the position of the inner and outer joiner plates. Attach extension to front and rear conveyor section with screws provided. Splice the conveyor belt extension piece. Replace dryer chamber into conveyor via the sheet metal screws. Reconnect power.
Assembly

Tools Required:
Note: A 1/4" and 7/16" Flat Plate Wrench is supplied.
Or use
1/4" Nut Driver (recommended) or 1/4" Socket and Ratchet (6.5mm)
7/16" Wrench Open End (11mm), for belt aligner adjustment.

Chamber Assembly and Heater Installation

1A) Install knob and bolt through pointer and spacer outside of both side panels. Connect to weldnut and hexnut on other side as shown above.

1B) Install (3) Sheet Metal Screws (each corner)

2) Do not over tighten fasteners.

3) Attach Front Panel to Left Side Panel

4) Attach Front & Back Panel to Right Side Panel

5) Heater wires are towards back of chamber

6) See Pg. 5 for heater assembly

Install (4) heater mounting screws (2 each side) through the heater hold down tabs
Connecting Chamber To Conveyor

7

Heater and mounting pins installed, wires toward the back. Position chamber onto conveyor. Corner alignment tabs on chamber slide into cutouts in conveyor. Note heater wires are towards back of conveyor. Attach chamber to conveyor with (6) screws, 3 each side.

Install Sheet Metal Screws (3 or 4 each side)

Chamber alignment tabs at four corners.

Heater Mounting screws (2 each side)

Printed Side

Front

Back

Pass the three wires, one at a time, thru the hole in the conveyor bed. Tan wires first then the green wire. Pull wire thru to make the connections.

Note: Power cord must be unplugged and belt removed to make heater connections. Do not operate dryer without belt installed.

8

Check that the heater mounting pins are installed before proceeding. Carefully lay the conveyor on its side as shown.

9
Assembly

Heater Wire Connections

Heater Wires (tan wires) have push on connectors. Attach either wire onto either open terminal (indicated on the left) on the heat control. It does not matter which wire to which terminal. Align the connector with the tab on the heat control and push firmly until fully seated. It should be hard to push them on, we want a tight connection. Pull gently on each connector, it should be held firmly onto the tab.

Push any extra slack in the wires, back up thru the hole in the conveyor bed.

10A

See photo 10B for Ground Wire Connection

10B. Ground Wire Connection
Remove the wingnut and lock washer. Place the green ground wire with the ring terminal oriented as shown, onto the grounding stud. Secure with lock washer and wingnut. Tighten nut securely.

Belt Installation and Tracking

Belt Installation
1) While dryer is on its side, pass the belt over the aligner bar and both braces.
2) Carefully lay the dryer back onto its feet.
3) Align the edges of the belt and insert the belt connecting pin. See enlarged view below.
4) Center belt on both rollers. Raise both sides of the belt aligner equally approximately 1-1/2”.
Do Not over tension belt, tension only enough to eliminate any belt slip on drive pulley.

Align the edges of the belt. Insert the belt connecting pin. Pin ends can be trimmed if desired

Belt Installation and Tracking
Assembly

Belt Tracking
Perform after assembly is complete and dryer is on a flat surface. Maintain belt as close to centered as possible on both rollers. Do Not leave conveyor unattended during tracking process.

1) While conveyor is running at full speed, observe position on both rollers.
2) Raising the belt aligner on one side moves the belt in the opposite direction. Lowering the bar moves the belt toward that side.
3) Make small adjustments, 1/4 turn of adjuster bolts. Allow the belt to respond to the adjustment.

Never allow the belt to track off the rollers, belt damage can result. Make belt tracking adjustments as needed.

To move the belt to the Left ←

Turn bolt **Counterclockwise**, Lowering this side of Aligner Roller

To move the belt to the Right →

Turn bolt **Clockwise**, Raising this side of Aligner Roller

DO NOT TIGHTEN BOTTOM NUT!
Gently pull up on wires to remove any excess wire from below the conveyor bed. Place the high temperature plastic ty-wrap as shown to control wire movement. Cut extra material off ty-wrap.

**Installing Chain Guard and Belt Guards**

*Chain Guard must be installed before operating the dryer.* Hook tabs on the bottom of the guard into the slots below the drive chain. Pivot the guard up, secure to the conveyor with (2) sheet metal screws.

*Belt Guards* are to be installed at both sides on the rear of the conveyor. Secure to conveyor with (2) sheet metal screws.

Do Not operate dryer with chain guard removed.
Electrical Requirements

Models: Plugs and receptacles listed are for domestic (USA) models. International models are supplied with the appropriate power cords.

**D-100 / 120Volts, 12.5Amps, 1.63KW**
Requires dedicated 15 amp circuit with a NEW commercial duty 5-15R receptacle.

**D-1000 / 120Volts, 16.5Amps, 2.05KW**
Requires dedicated 20 amp circuit with a NEW commercial duty 5-20R receptacle.

**D-100-240 / 240Volts, 6.3 Amps, 1.63KW**

**D-1000-240 / 240Volts, 8.6 Amps, 2.05KW**
Requires good quality 6-15R receptacle. (Some international plugs available)

(North America Standard Receptacles)

- **Variable Heat Control**
The control has positions LO-2-3-4-5-6 and HI. The controller turns the power to the heater on and off to vary the temperature. The higher the number on the control the longer the on cycle and shorter the off cycle is. The “HI” position is full power.

- **Heat On Light**
This RED light is wired to the controller. It will illuminate when the control is turned on, even if the controller has failed.

- **Belt Speed Control**
Rotate clockwise to increase, counter clockwise to decrease belt speed.

- **Fuses**
Protects belt control circuit, (1) Amp AGC fast blow
One (1) fuse for 120 volt.
Two (2) fuses for 240 volt.
**Dryer Operation**

### Startup Procedure

1. **Plug in Dryer:**
   - Be sure the breaker and dryer controls are switched off. Plug the dryer into a properly rated outlet and turn the breaker on.

2. **Check belt path:**
   - Remove any objects from the conveyor and belt.

3. **Turn on Conveyor:**
   - Set belt speed with the Belt Speed Control on the conveyor, near the motor.

4. **Turn on the Heat:**
   - Turn the Variable Heat Control dial on HI for 10-15 minutes to allow the dryer to warm up.

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**Curing Plastisol with infrared:**

Plastisol ink can fully cure in approximately 20-30* seconds. Most inks must achieve 320°-330 F (160°-165°C) throughout to cure and fuse to the garment. The thicker the ink the hotter the top skin has to be in order to be cured completely to the garment.

**Discharge or water based:** (A powered exhaust is recommended)

Water based products require more time than plastisol to cure due to the fact that the water/moisture must be evaporated before the ink can cure. We have seen cure times from 50 to 90* seconds to achieve a full cure or discharge and not damage the garment. Please note as the time is increased the temperature must be decreased to protect the garment from scorching.

*Actual cure times can vary depending on conditions such as garment moisture and color, ink color, ink thickness, and environmental conditions. All three variables should be used to maximize production while insuring a proper cure.

5. **Set the Heat:**
   - With the dryer plugged in, rotate the Variable Control Timer to the desired setting. Often times, it is best to run the dryer on HI and adjust your belt speed and heater height to achieve a proper cure.

6. **Set the Heater Height:**
   - Set the desired heater height for your job. On each side of the heating chamber, there is a knob to raise and lower the heater. It is recommended to run the heater height at about 2” - 3” above the garment. The heater can be run at an angle for curing non-flat sub-straights such as hats.

7. **Set the Belt Speed:**
   - Rotate the Belt Speed Control Knob clockwise to increase speed and counter-clockwise to decrease it. For Plastisol inks, a good starting point is 20-25 seconds in the chamber. The dial numbers are for reference only. They do not represent seconds in the chamber.

### Operation Tips

- While machine is in operation, it is necessary to have the belt moving while the heater is above 300°F (149°C).
- Allow approximately 15 minutes for dryer to reach Full temperature.
- If no garments are being run through the dryer for more than 10 minutes, it is recommended to lower the dryer heat control to “4” or lower. It will take approximately 10 minutes to return to operating temperature.
- Periodically check ink temperature at the exit of the dryer. It is recommended that you check the temperature of the ink towards the outside of the printed image.
- When checking temperature with a laser gun, shoot the ink while it is still under the heating elements.

### Shut Down Procedure

1. **Turn off Heat:**
   - Turn the Heat Control off. Allow the heaters to cool for 10-15 minutes before shutting the conveyor off. Belt damage may result from stopping the conveyor with hot elements.

2. **Turn off Conveyor:**
   - Once the dryer cools down to 300°F (149°C) or lower, turn the Belt Speed down to the off position. Skip this step if leaving the conveyor belt speed set for the following shift.

3. **Turn off Breaker:**
   - Turn off the breaker controlling the dryers at the end of each shift and unplug them from their outlets.
The proper chain tension is critical to achieving acceptable service life as excessive tension can cause accelerated wear or chain overload and excessive slack can cause rough chain operation and possibly result in the chain skipping a sprocket tooth, resulting in a catastrophic failure. For Vastex drives, the total movement in the slack span of the chain (up and down total movement) should be .25 to .38 inch. Please see below for picture.

This is the slack in the down position.  

This is the slack in the up position.  

Total slack is .25 to .38 inch. This is total up and down movement.
Updates:

The Vastex Warranty applies to the original end user of the equipment who holds a copy of the original invoice. Warranty period begins from date of shipment to the buyer and will only apply to parts and labor paid for in full. Warranty periods are as follows: one (1) year for E-1000, three (3) years for all other complete machines (including F-Flash), fifteen (15) years for infrared heaters (excluding F-Flash) installed by Vastex in a new dryer, three (3) years for replacement infrared heaters, and one (1) year for replacement parts. Rubber blankets, light bulbs and glass on exposure units are particularly subject to wear while in use. Wear is not covered by this warranty but as stated above only manufacturers defects are covered. All sales made through Vastex dealers must be certified by an authorized Vastex dealer. All repairs which occur under warranty will be thoroughly tested and inspected before delivering.

Vastex, hereinafter referred to as “seller” warrants only to its original “purchaser”, who holds a copy of the original invoice and is the original end user of the equipment in question, its new equipment against manufacturing defects for the warranty periods stated in paragraph one. The defective parts of a unit will be replaced or repaired and the discretion of Vastex International, Inc. If the equipment in question is less than one (1) year old, it will be shipped to the customer at no charge, with an RGA issued by Vastex for the defective part. The defective part must be shipped back to Vastex freight prepaid within 30 days or the account will be billed. If the equipment is more than a year old, the part will be shipped after we receive the defective part. It is necessary to expedite the movement of parts and to minimize down time to the buyer, the replacement part shall be supplied on a C.O.D. basis. Testing and analysis of said part by the seller or its supplier discloses that said part is defective, the cost of said part will be refunded to the buyer on a prorated basis.

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(3) Except as otherwise provided herein, the equipment is being sold as “is”. Final determination of the suitability of the equipment for the use contemplated by the buyer, is the sole responsibility of buyer, and seller shall have no responsibility in connection with the suitability.

(4) All warranties implied by law, including the implied warranties of merchantability and fitness are hereby limited to manufacturer defects in materials or workmanship during the warranty period stated in paragraph one. The express warranty and remedies contained herein and such implied limited warranties are made solely to the sole warranties and remedies and are in lieu of all other warranties, guarantees, agreements, and other liabilities, whether express or implied, and all other remedies for breach of warranty or any other liability of seller, in no event shall seller be liable for consequential damages.

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This warranty gives you specific legal rights, and you may also have other rights which vary from state to state. Infrared heaters are the only replacement parts covered for a period of 3 years from date of shipment and contingent to receipt of payment in full.

No person, agent, distributor, or service representative is authorized to change, modify or extend the terms hereof in any manner whatsoever. These terms and conditions are an essential part of the transaction between the parties and constitute the entire agreement between them with respect to the same. Sales to states not doing business in writing, prices not including sales, excise, value-added or other taxes. Consequently, in addition to the prices specified herein, the amount of any present or future sales, use, excise, value-added or other tax applicable to the manufacture, sale, purchase or use of the products hereunder shall be paid by Buyer, or in lieu thereof, Buyer shall provide Seller with a valid tax exemption certificate acceptable to the tax authorities.

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Vastex, hereinafter referred to as “seller” warrants only to its original “purchaser”, who holds a copy of the original invoice and is the original end user of the equipment in question, its new equipment against manufacturing defects for the warranty periods stated in paragraph one. The defective parts of a unit will be replaced or repaired and the discretion of Vastex International, Inc. If the equipment in question is less than one (1) year old, it will be shipped to the customer at no charge, with an RGA issued by Vastex for the defective part. The defective part must be shipped back to Vastex freight prepaid within 30 days or the account will be billed. If the equipment is more than a year old, the part will be shipped after we receive the defective part. It is necessary to expedite the movement of parts and to minimize down time to the buyer, the replacement part shall be supplied on a C.O.D. basis. Testing and analysis of said part by the seller or its supplier discloses that said part is defective, the cost of said part will be refunded to the buyer on a prorated basis.

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