

Digital Knight Twin Shuttle Assembly Instructions

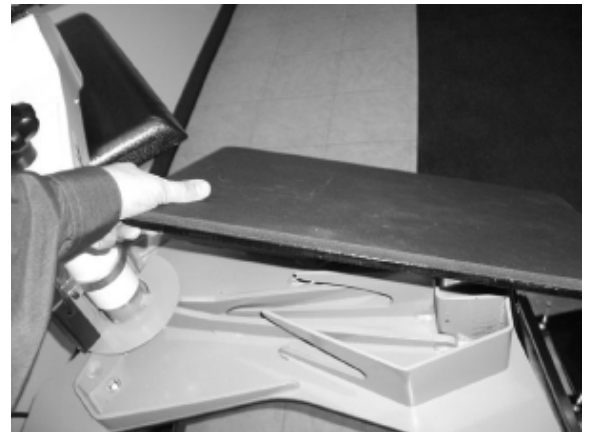
The Digital Knight Twin Shuttle can be added to the DK20S swing away press, and also the DK20 clamshell press (modifications to the DK20 clamshell frame are necessary, see “DK20 Clamshell Notes” at end of instructions before purchasing or attempting to install).

There are 3 steps to adding the shuttle to the DK20S press. Follow these steps carefully, and read through the entire instructions before attempting installation. Please note the warnings mentioned during certain steps, as injury or damage can occur during installation.

STEP 1 - Prepare press

Remove the original table from the machine.

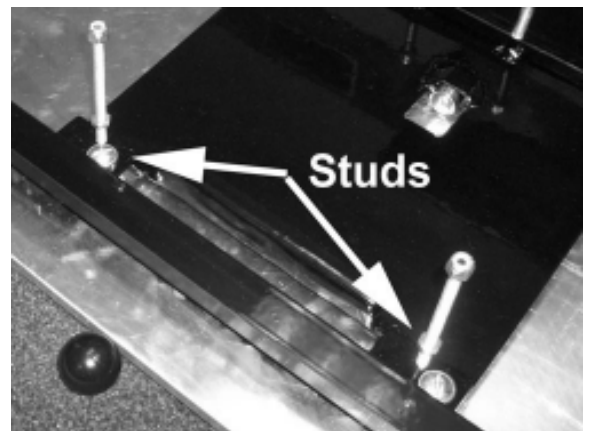
The 16x20 tables are “drop-on” tables, which means they are readily pulled off the press base. For the DK20S, swing the head completely out of the way and lift up the table, pulling up on it from the back of the table as shown. (DK20 Clamshell - pull from front)



STEP 2 - Prepare Slide Assembly

**Attach the support studs to the slide assembly.
Remove hold-down bar from the slide assembly.**

Attach the 4 support studs to the slide assembly. Screw them into the roller bearing blocks as shown, as far as they can be screwed in. They will be adjusted later once the assembly is in place.



Remove the 8” long hold-down bar and 2 lock nuts from the slide assembly as shown. These will be used later to attach & lock the shuttle to the base.



STEP 3 Lowering the Shuttle onto the Press

**Carefully lower the slide/bearing plate into the base of the machine.
Two People are recommended for this step !**

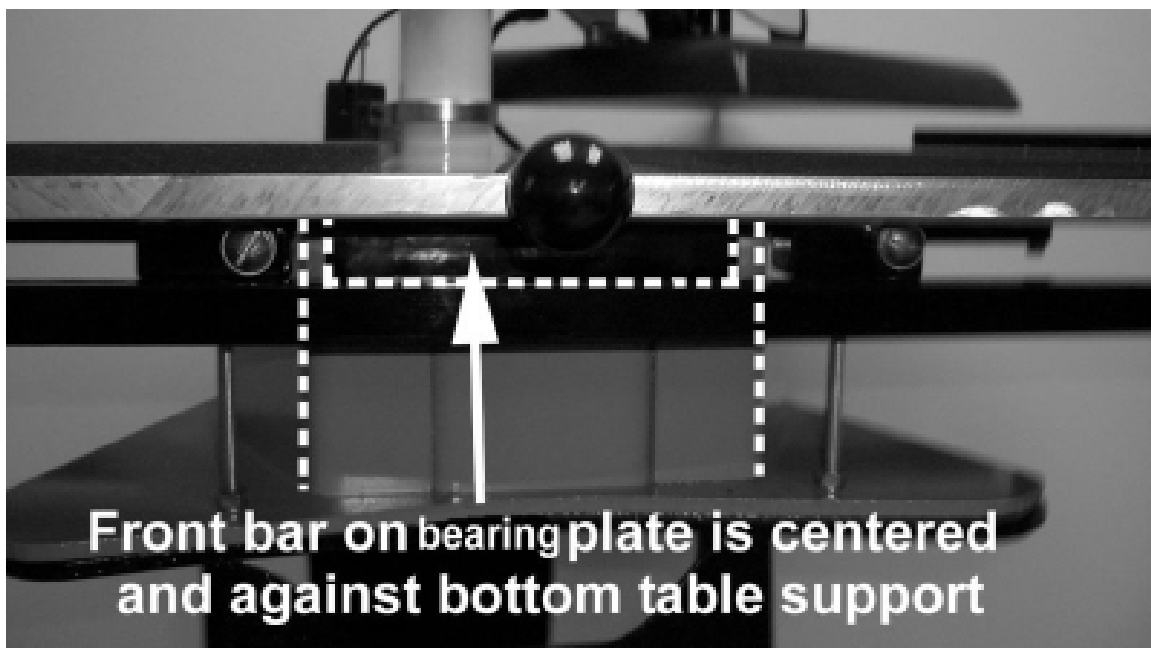
CAUTION: When lifting the shuttle assembly, pinching and injury can occur. Please note the picture shown.



CAUTION: Keep the aluminum shuttle plate centered. Until locked in place, the main aluminum shuttle plate will fall off the press and can cause damage and/or injury if not kept centered. Please note the picture shown.



The bearing plate is the black square plate with the roller bearings and rolls freely side to side. Lower the shuttle onto the base of the press with the bearing plate landing on the center of the heat press table support. The front stop of the bearing plate should be centered with the table support of the press, as shown. The front stop should also be flush up against the table support of the press. (DK20 clamshell - just the reverse, the front bar is up against the rear side of the table support. See DK20 diagram at end of manual.)



**Front bar on bearing plate is centered
and against bottom table support**

STEP 4 Securing the Shuttle to the Press

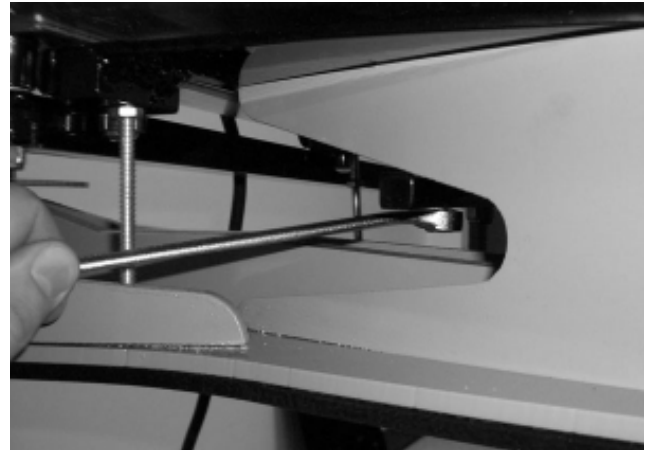
**Attach the hold-down bar to the shuttle
Two People are recommended for this step !**

CAUTION: One person should hold the aluminum shuttle plate so it does not slide and fall off the base.

Attach the hold-down bar to the two threaded rods as shown above. Screw on the nuts by hand but leave them slightly loose for later alignment.



Once the hold-down bar is in place, test the squareness of the shuttle. Swing the heat platen over the shuttle as far as it goes. Slide the shuttle from left to right and make sure the sides of the heat platen are parallel with the silicone pads.



Do not worry about overlap of the heat platen with the rubber padding at this time. Minor adjustments to the stop position are made later. Make sure the aluminum plate and silicone pads are parallel within 1/4" with the heat platen.

Once this is done, tighten the two nuts against the hold-down bar Very Tightly, to fully secure and lock the shuttle to the base of the press. This is important. Please note the picture shown.

STEP 5 Minor Alignments

Wrap double sided velcro to stopping posts if desired. (Not required)



The shuttle should slide within 1/4" to 3/8" of the heat platen, left to right. It is normal for there to be a slight variance and this is acceptable. Although the press will properly perform right to the edge, it is recommended to keep the image area within a minimum 1/2" away from the edges of the rubber.

Use the double sided velcro supplied to wrap around the posts on the shuttle assembly. The Roller Bearings hit 2 of these posts on the shuttle. Depending on the amount of velcro used, the position where the shuttle stops can be adjusted and fine-tuned. Add more velcro around the stop post to make the silicone pad stop earlier if desired. This also dampens the contact sound of the roller bearings.

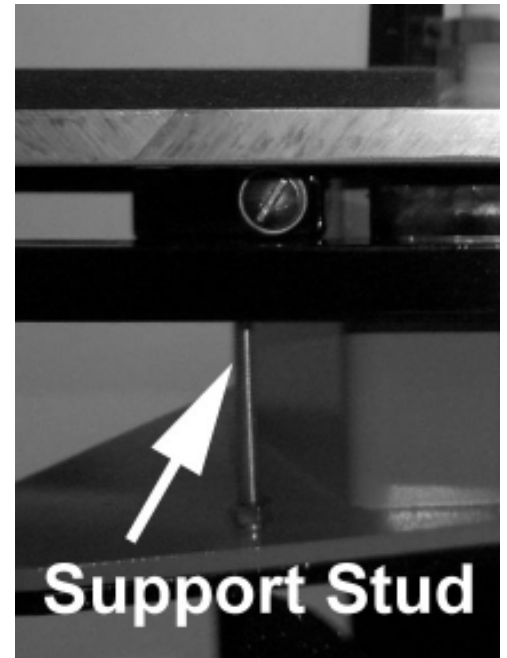
STEP 5 Support Studs

Lower and tighten support studs in place

Turn down the support studs until they hit the base of the press or benchtop. Make sure they are tightly pressing down against the base frame, but not lifting up the slide plate, as shown.

Tighten the small loose hex nut on the support stud up against the black bearing plate so it is locked in place. The nylon base nut on the stud will remain against the bottom surface.

Sometimes only 3 studs can be used, with the 4th not having a contact point available below it. This is acceptable. It is important for the long term life of the slide plate to have at least 3 support studs supporting the bearing plate at the corners.



DK20 Clamshell Notes

Modification required to use the Twin Shuttle on the DK20 Clamshell

The base frame of the DK20 must be cut in order to allow the shuttle rails to pass back and forth at the rear of the shuttle assembly. The cuts are minor and will not affect the structural integrity of the frame. Please note the following diagram of the cuts required. (A "sawzall" or manual hacksaw or similar metal cutting tool is recommended for best results.)

