

Assembly Instructions

Riley Hopkins

Congratulations!

You have just received one heck of a press! The following information is a guide to easily uncrating and setting up your press. Please remember: This press is a finely tuned machine, that has been lovingly assembled at the factory. Don't try any rocket science on it, or jump to your own conclusions on how it works. Please follow the operating instruction sheet.

Step One- Inspect the crate for damage before signing for it. Note any damage on the shipping bill of lading, and have the driver sign off on it too.

Step Two- Use a portable drill, with a Philips head screw driver in it to back out the screws on the lid. Remove the lid, and see if everything is ok. Next, remove the two shear sides, and then the two crate ends.

Step Three- Use a ½ inch socket to remove the print stations from the crate. Note that each print station has a number on it, two dowels, and scribe marks. When it comes time to assemble these parts onto the press, they must match the corresponding numbers on the press. Be careful not to let these printstations fall over, or damage to the shirtboards will occur.

Step Four- Remove the lag bolts holding the central assembly in place, and remove the lag bolts holding the base. While the base is upside down, install the center leg leveler into the threaded hole in the cross of the base (Win Series only).

Step Five- One at a time, fold each leg down, installing the hardware the way it is loosely installed in each leg. Tighten up the bolts **AFTER** all the bolts are in place. Place the base where you intend to locate the machine.

Step Six- Place the central assembly onto the base, noting where the holes line up. Install the four center ½ inch head bolts (with lock washers) into the four holes closest to the center shaft. Wiggle these to get them to start if necessary. Once all 4 are started, tighten them up. Install the remaining base hardware to fully secure the central assembly to the base.

Step Seven- Lower each one of the printheads (making sure the springs are attached to the wheel and spring plates) Install the blue bump rubber, with the

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9/16 head bolt going in the same direction as the one below it. Run the jam nut up to snug (finger tight) raise the printhead back up to its UP position. Repeat all.

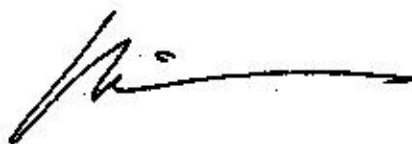
Step Eight-Rotate the green central assembly until the #1 station faces you. Pick up the #1 print station, and tap one of the roll pins through the back of the printstation about 1/8 of an inch. Use two vice grips (with ductape in the jaws so as not to harm the powdercoating). Place the dowel into the corresponding hole in the central backing plate. Rotate the print station until the scribe line on the opposite side as the engaged dowel lines up, and tap the dowel through into the backing plate. With two vice grips (one on either side) clamp the printstation in place, and install the four 9/16 inch head bolts, washers and locknuts. Repeat until all the printstations are on the correct corresponding number on the central assembly.

Step Eight-Adjust the leg levelers on the base to get any "rock" out of the base. There is a little clearance between the bolts and the holes in the base, so you may need to adjust the leg levelers a couple times. The center leg leveler takes up a lot of the center weight, and the four legs handle the "tip" side of things.

Step Nine-Spray the press down with WD-40, to act as a barrier against spray adhesive. This makes cleanup each Friday a lot easier. Respray after each cleanup. If you run a clean, well organized shop, you'll have better business, and better pride in the company.

Step Ten-Set the press up for your tallest printer (so they are in their best printing position when standing on a padded piece of carpet) Make up individual platforms for each other printer, adjusted to their best height, so that everyone is at their optimum position to print. Printing is an athletic job, so proper warmup, and job rotation is important for longterm worker health. Our Flying Wing Ergonomic Squeegees aren't a bad idea to use either!

Have FUN!



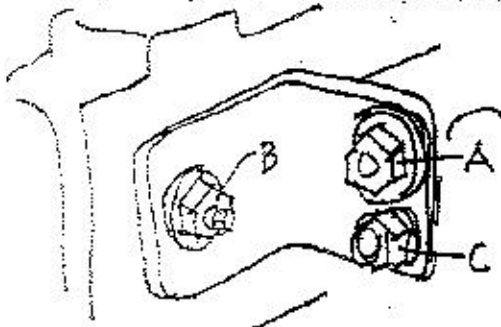
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Congratulations! You have just purchased one of the hottest presses on the planet! If you take care of it, and keep it clean, it will serve you well, and give you many years of faithful service! (I have machines in the field that are over 20 years old that are still banging out shirts, and making their owners money!)

INSTRUCTIONS

This is a high quality, light weight machine. Its casings are 356 heat treated aircraft grade aluminum. If you enter into a contest of strength with this machine, you may win. Therefore, don't use gorilla tactics, and don't over-torque knobs!



Clamp Adjustments

There are adjustments for Tilt (A)

Off Contact (B) Don't adjust the axle (C)

Notes: The clamp is like a "C" clamp. The more you tighten it, the more it spreads, and shifts the screen forward. To eliminate all

this, my rule is: **Finger tighten the knobs until tight, then 1/4 turn more, each!** This will apply the same amount of "torque" on each knob, and keep the screen in the same relative place. The same thing applies to the reggie knobs, and the shirtboard bracket clamp knobs. (Too much torque here will dent the tube!)

Using the joystick

This is one of the coolest things I've ever built. Its so easy to use, and does such nice work. It allows you to look at the image on the screen while you adjust it. You don't have the problems of micros...where you have to look at the micro to adjust it, and then go back to the screen image to see what went wrong!

When you've inserted a screen, and clamped it in place (finger tight until "snug", then 1/4 turn more by hand on each knob), loosen the two reggie knobs. Place the heel of your right hand on the top of the knobs for support. Grasp the joystick knob with your thumb and forefinger. Move the screen around to where you want it. You will find that your two hands follow each other naturally, so its very easy to adjust an image into register. Major moves are immediate, and the minor ones are easy to control, since you have so much leverage. Its a blast!

Shirtboards, and shirtboard brackets

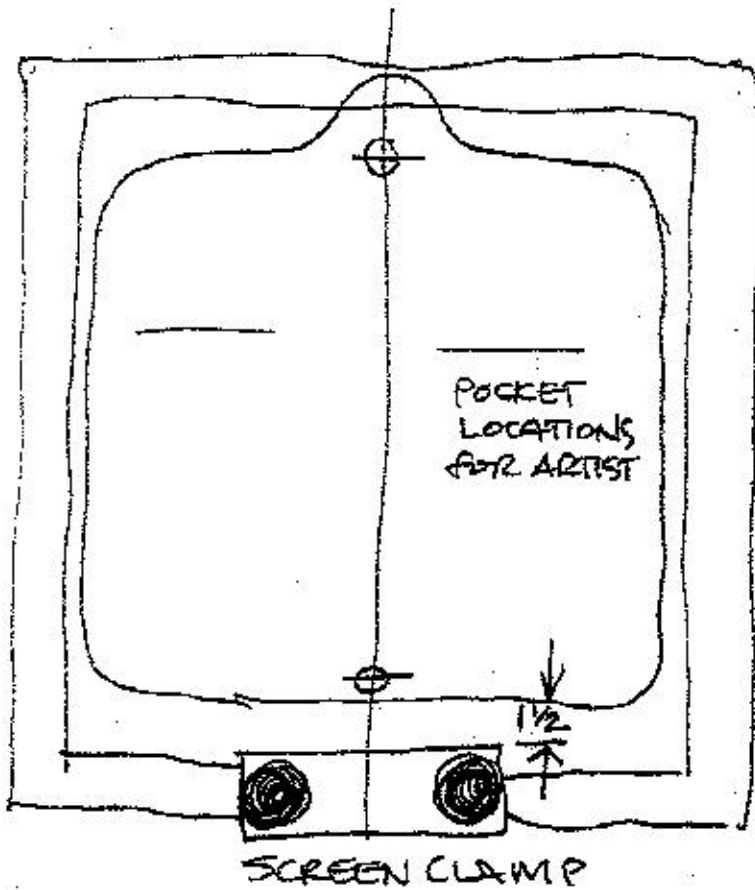
Make sure that any boards you make yourself are the same thickness as "stock". Don't over torque the bracket, or you'll bend the tubing! **Have fun!**

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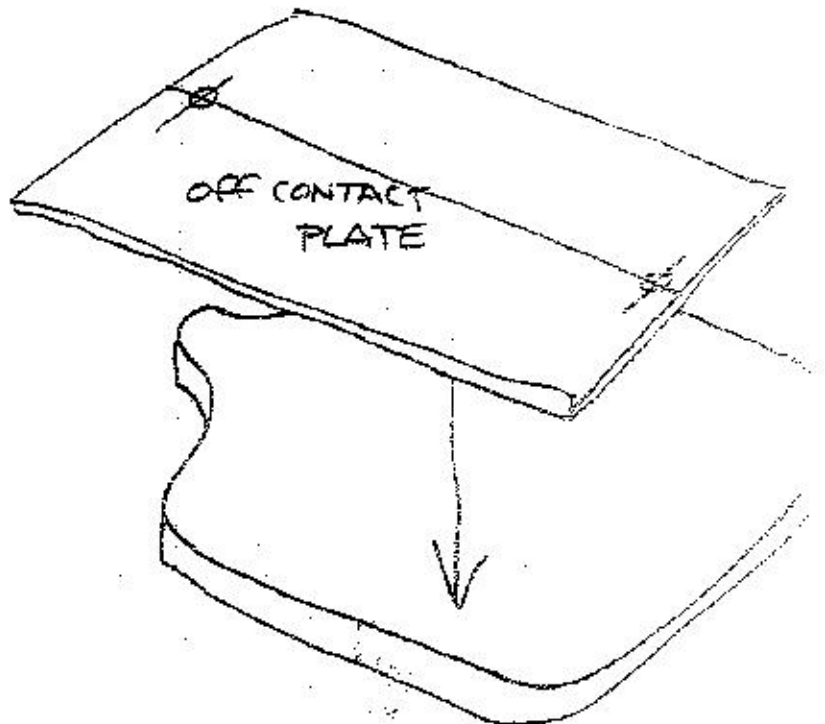
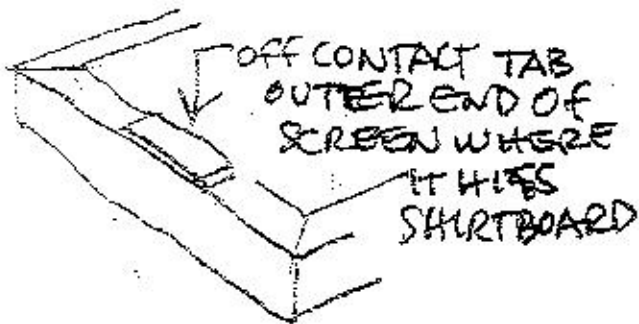
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GENERAL SET-UP TIPS
FOR RILEY HOPKINS PRESSES

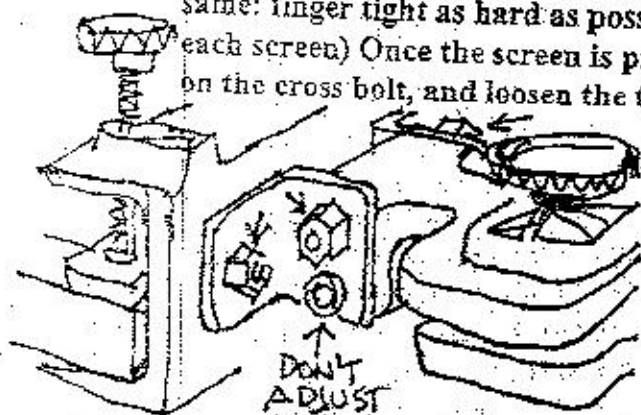
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BASIC ONE-TWO-THREE
ONE-SET OFF-CONTACT
TWO-REGISTER JOB
THREE-PRINT

ONE-SET OFF-CONTACT

The simplest, and fastest method for setting off contact I've found, is the use of an OFF-CONTACT PLATE...which is anything from illustration board, to thin cardboard, to thicker cardboard (where more off-contact is required)

The purpose of this plate, is to place it securely with tape onto your #1 print station, for the express purpose of fooling the screen into thinking its laying flat on the shirtboard. To get the screen to lay flat on the plate, place the screen in the clamp, and tighten it. (The best way to keep things the same, is to torque the knobs the same: finger tight as hard as possible, then 1/4 turn with your hand...each knob, each screen) Once the screen is properly tightened in the clamp, loosen the top nut on the cross bolt, and loosen the two nuts on the clamp (with a 9/16 box wrench).



Let the screen rest flat on the Off-Contact Plate. Make sure the arm is all the way down in gate. Snug up the two clamp bolts, so there is no play. Making sure that the screen is still flat on the Off-contact plate, tighten one of the clamp nuts, then tighten the top cross bolt nut, then the last clamp nut. Repeat this process on each screen.

TWO-REGISTER THE JOB

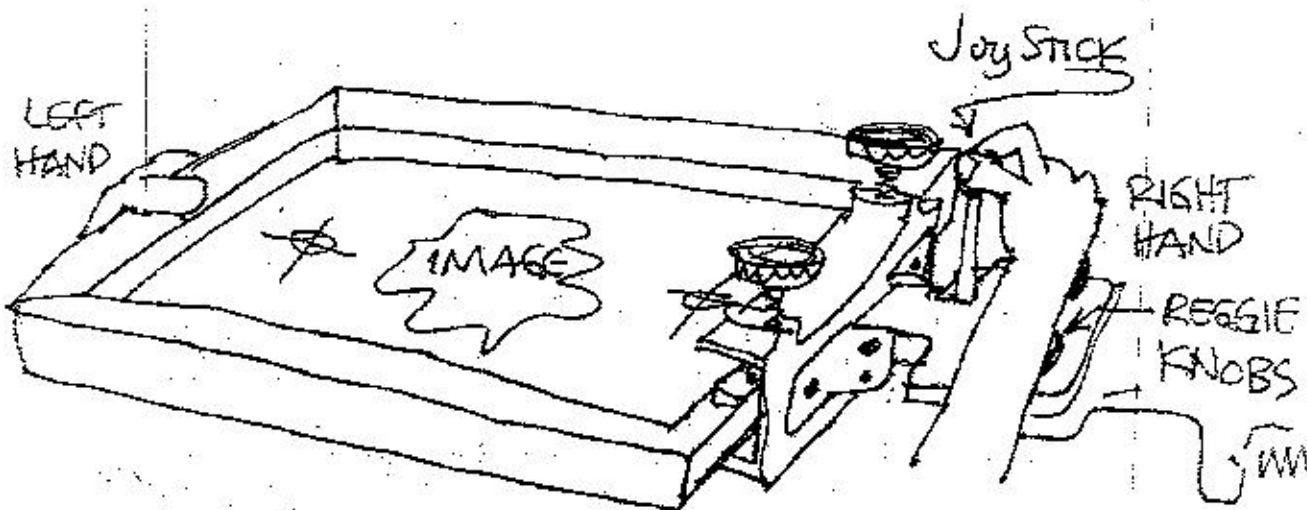
The Joy Stick Registration System was developed to speed registration, and to aid in the ability of the printer to keep their eyes on the mesh, while registering the screen. To Register, tape the positive on the Off-Contact Plate in the correct position. Then, loosen the two knobs on the Reggie plate that hold the clamp and screen assembly. Grasp the middle of the outer end of the screen with your left hand, to move the screen from that end. Place the heel of your right hand on the two Reggie knobs for support. Grab the Joy Stick Knob with your thumb and one or two fingers, so that you have maximum control. Moving your two hands together, move the screen into the basic desired position. For final adjustment, carefully move the screen and Joy Stick to get the image into its final position. It gives you fast major moves, and very good control on minor moves. All the time, you watch the image. When you are done, tighten up the two Reggie Knobs, making sure that nothing has moved. Repeat on all screens. (See drawing on following page)

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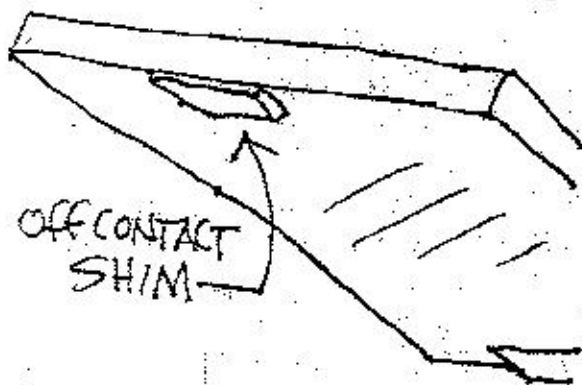
Registering the Job-Continued



Loosen Reggie Knobs, move screen into final position, tighten Reggie Knobs.

Three-Print the Job

Before printing the job, pull the Off-Contact Plate off the shirtboard. Next, add an Off-Contact Shim to the outer end of the screen, where it contacts the end of the shirtboard. Use something of similar thickness to the original Off-Contact Plate. Tape will do just fine. The objective, is to support the outer end of the screen during the print stroke, thus maintaining uniform off-contact throughout the print stroke. Now that this is done, load up the ink, and make a test print. If you still have to make an adjustment, the off-contact shim supports the outer end of the screen when you loosen the Reggie Knobs. Adjust as needed, tighten the Reggie Knobs, and print another sample. When everything is hunkie-dorie..have at it.



Print Notes-

Printing is an athletic endeavor. Make sure that you are at the right height to print (not bent over Not on tippy toe) Adjust with padded carpet as Needed. Warm up your body with some warm-up stretches, to get loose before printing. Rotate Jobs between printing, and load/unload, so that You aren't doing the same thing all day. (This Also lets you train others on the team to help out on all facets of the print shop.)

PUSH STROKE vs. PULL STROKE

Ergonomically, the Push Stroke is better for you than the Pull Stroke. The Push Stroke doesn't load up your carpal tunnels, or your finger tips like a Pull Stroke. Push Stroke technique is unfamiliar, and takes getting used to...but its worth it. If nothing else, use it to lay down that ultra thick white base plate that usually takes three Pull Strokes...to see how cool it is.

Enjoy Printing. Do Good Work. Have Fun!

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