Declaration of conformity (Europe only)

We,

Trodat GmbH
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hereby declare that the Flash Stamp Machine model T1511M is CE certified respectively in conformity with the essential requirements of all relevant directives and regulations applied with the European Union.

The CE certification can be requested from your Trodat sales representative.

Trodat GmbH cannot be held responsible for any direct or indirect damages, which result from using or working with the machine described herein. Only trained and skilled personnel must use the machine. Before use the manual should be read and followed carefully. Furthermore, Trodat reserves the right to change or alter any product described herein without prior notice.
Trodat Flash Machine T1511M
User Manual

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Congratulations and thank you for your purchase of the Trodat Flash Machine T1511M. Before using the machine please read this manual to insure safe and proper operation and keep it for future reference. In case of problems or further questions please contact your Trodat sales representative.
I. General and safety information

Before putting the T1511M Flash Machine into operation read this user manual carefully and keep it for future reference.

- The machine may only be used in closed and dry areas. Do not operate it in explosive environments.
- Make sure that the machine is situated away from heat sources or equipment that may generate excessive vibration, dust or moisture.
- To prevent condensation inside the Flash Machine avoid exposing it to sudden temperature changes.
- The machine may only be operated on a stable, even and clean work surface. Serious injury to the operator and damage to the machine can result from poor machine placement.
- Do not use the machine with non-grounded power sources. Operate the machine only with a power source that meets the specifications indicated on the label at the back of the machine.
- Do not overload wall sockets, extension cords or surge protectors with other devices as this can result in a risk of fire or electrical shock. Power supply cords should be routed so that they are not likely to be walked on or pinched by items placed against them.
- Do not use any accessories or supplies (spacers, glass plates, vellum papers, transparency sheets etc.) that are not recommended or supplied by Trodat, as this may cause hazards.
- Always unplug the machine from the power supply prior to any installation, maintenance or cleaning procedures.
- Very high voltages may be inside the machine (due to capacitors). Never modify or bridge any of the safety features. Serious injuries due to an electric shock or unintentional exposure could be the consequence.
- Do not use the machine if it shows any damage. Immediately disconnect it from the power supply.
- The electric power supply cables must not show any damages or material fatigue.
- Never attempt to disassemble or repair the machine. Electrical repairs should only be done by a qualified and authorized technician (familiar with these types of electronics and capacitors).
- Do not dispose of the machine with domestic waste! Electronic devices have to be disposed according to the regional directives on electronic and electric waste disposal.
II. Scope of use

The Flash Machine T1511M is an exposure system, designed to quickly and easily expose (flash) all models and sizes of Trodat’s Premium Flash range including the new (die box) and regular (foam) systems:

- MaxLight (S-Style, Z-Style)
- MaxLight X (Pre-Assembled Z-Style)
- PSI (E-Style)
- Slim Stamp (E-Style)
- Super Slim (Slim Style)

The Flash Machine T1511M supports all production methods of the Premium Flash range, no matter if (a) an entire die box or (b) foam only (microporous photosensitive text plate) is exposed (explanation see below). After placing the printed vellum paper and a clear transparency film in the machine, the die box or foam can be positioned and the machine closed. The desired energy level will charge the system and properly expose the die box or foam. The exposed die box or foam is then ready for inking and assembling in the proper MaxLight, MaxLight X, PSI or Slim Stamp pre-inked stamp.

(a) **DIE BOX** (new system)
Combines foam and dry cartridge all in one. The die box is exposed on the grey foam side and is inked by filling ink into the ink cartridge cavities.

(b) **FOAM** (regular system)
The foam only textplate has foam on the one side and a thin cartridge layer on the other side for fast ink migration. The foam is exposed on the grey foam side and is assembled in a retainer ring or die box for inking.
III. Delivery content and installation

Please check the packaging for transport damages and completeness. In case of any damage contact your supplier immediately and do not use the Flash Machine.

**Delivery content**

- Flash Machine T1511M
- Exposure glass
- Spacer (pressure plate)
- Power cable
- User manual
- Premium Flash Catalogue (including inking and assembling instructions)

**Installation**

Place the Flash Machine on a stable, even and clean surface and make sure that it is placed in an unobstructed area to ensure that the cooling fan can operate properly. Put the exposure glass plate on top of the lamps.

Use the supplied power cable to connect the machine to a grounded power outlet.

**Attention:** Never place or remove the glass plate when the machine is plugged into a power supply. High voltages inside the machine may cause serious injuries!
IV. Controls and Functions

1. Power plug
The power plug is located on the back of the Flash Machine. It allows the use of grounded power cables only.

2. Fuse
The fuse holder is located above the power plug. This contains the fuse that provides overload protection for the Flash Machine.

3. Power switch
The power switch is located on the back of the Flash Machine. Press this switch to turn the power on/off to machine. The switch will be lighted when the machine is turned on. The light will go off when the machine is turned off.

4. Fan switch
The fan switch is located on the back of the Flash Machine. Press this switch to turn the cooling fan on/off. The cooling fan is for cooling the electronic device, lamps and glass. Due to the integrated cooling fan a continuous production process is possible, as no cooling phases are required. It is recommended to turn on the cooling fan when the temperature rises above 35°C, to cool down the exposure system and ensure optimal exposure results. The cooling fan has no impact on the exposure result and can be turned on/off during the exposure process.
5 **Energy dial**

The energy dial sets the energy level of the lamps when the exposure is activated. The energy levels are numbered "1-10", with "1" being the lowest and "10" being the highest setting. For exposing all Trodat Premium Flash models it is recommended to set the energy level at "6".

6 **Cover and clamping mechanism**

The clamping mechanism of the cover is for the compression of the die box or foam. The cover evenly applies pressure and compresses the die box or foam, which is required for proper exposure results. Due to safety reasons the exposure process will not start if the cover is in open position.

7 **Start button (Flash button)**

The start button is located on the front of the Flash Machine. Press the button to execute an exposure. This button is only active with the clamping mechanism in the fully closed and locked position.

8 **Temperature indicator**

The temperature indicator is located on the front of the Flash Machine and indicates the temperature of the exposure system in degrees Celsius. The temperature of the machine will increase with a continuous production process. Operating the machine over a temperature of 50°C can have a negative impact on the exposure result and can lead to an overexposure (overflashing) of the foam. It is recommended to turn on the cooling fan when the temperature rises above 35°C, to cool down the exposure system and ensure optimal exposure results.
9 Exposure area

The exposure area of the machine (150mm x 110mm) is designed to expose all MaxLight, MaxLight X, PSI, Slim Stamp and Super Slim sizes.

**Important:** Always make sure that the exposure area is clean before flashing.

10 Spacer (pressure plate)

The spacer is mounted on the cover with magnets for simple exchange. For exposing foam only the delivered spacer must be mounted on the cover. For exposing entire die boxes the spacer must not be mounted on the cover.

**Important:** Never expose a die box, while the spacer is mounted on the cover. This can cause serious damage to the machine.
V. Required Equipment

For proper stamp production with the Flash Machine T1511M the following additional equipment is needed:

1 Computer with graphic arts software

A computer with basic graphic arts software (e.g. Corel Draw) is recommended for typesetting. A regular word processing software can also be used for typesetting, but you will be unable to use the recommended Trodat typesetting templates.

Please note: Trodat offers typesetting templates for all MaxLight, MaxLight X, PSI, Slim Stamp and Super Slim models and sizes as Corel Draw files. Each typesetting template consists of 3 attributes: model number, black positioning frame (outer border) and red typesetting frame (inner border) – see picture "Typesetting template". The model number is located next to the positioning frame of each individual template. The black positioning frame represents the total overall size of the die box or foam and is used for centering the die box or foam over the printed artwork. The red typesetting frame represents the maximal area for typesetting. Before printing make sure to delete the red typesetting frame, otherwise it will be visible on the stamp text plate.
Please contact your Trodat sales representative to get the typesetting templates.

2 Monochrome laser printer

A monochrome (only black and white) laser printer with 600 DPI (dots per inch) or higher resolution is required for printing an artwork on vellum paper. Do not use a colour laser or ink jet printer for vellum printing. Using the improper printer will cause unsatisfactory stamp impression quality. The density of the toner is important to block the light of the print areas. You may need to adjust the print density setting of your printer for optimal performance. See your printer's owner manual. Please also make sure you are only using original toner cartridges for best printing results.
3 Trodat Premium Vellum Paper

The vellum paper is used for printing the desired artwork. It is available in two sizes: pre-cut (108mm x 140mm) or US letter (216mm x 279mm). The pre-cut size perfectly fits into the T1511M Flash Machine (no extra cutting needed before putting into the machine). It is highly recommended that you use only the Trodat Premium Vellum paper. Using improper vellum can cause bad exposure results and lead to unsatisfactory stamp impression quality.

4 Trodat Premium Transparency Film

The clear transparency film is placed on top of the printed vellum to separate the artwork from the Flash foam. It is available in two sizes: pre-cut (108mm x 140mm) or US letter (216mm x 279mm). The pre-cut size perfectly fits into the T1511M Flash Machine (no extra cutting needed before putting into the machine). Please use only the Trodat Premium Transparency Film for proper production results.
VI. Operation

All Trodat's Premium Flash models use a high quality flash foam as text plates. The foam will be sealed during the exposure process according to the artwork.

1 Print artwork

The artwork for the exposure process should be printed using a 600 dots per inch (DPI) or higher monochrome laser printer on Trodat Premium Vellum Paper. The vellum can be printed from both sides. The print should be right-reading (positive) and not reversed or mirrored for use in the T1511M Flash Machine. For proper exposure results, the printed artwork has to be deep black. Make sure to not use grey or colour tones in your artwork. Set the print density in the printer properties to its highest setting and use the printer setting "Print black only". Do not print in greyscale, this will have a negative impact on the exposure result.

The artwork for the stamp should be surrounded by a black printable positioning frame that is the same overall size as the die box or foam that will be exposed. Doing this will allow for easy placement of the die box or foam during the loading process. For fast and easy artwork designing you can use Trodat's typesetting templates (described in the previous chapter), which offer positioning frames for all MaxLight, MaxLight X, PSI, Slim Stamp and Super Slim models and sizes.

**Tip:** When printing several artworks on one vellum sheet, make sure to leave at least a 1cm gap between each artwork in your layout. This is to allow for quick and easy placement of die box or foam.

2 Switch on machine

Switch the machine on using the main power switch on the back side of the machine.
3 Open cover and adapt machine setup

Open the cover of the machine and make sure that you have the correct machine setup depending on whether a (a) die box or (b) foam only will be exposed:

(a) Exposing Die Boxes: For exposing entire die boxes remove the spacer from the cover. Following models have to be exposed without spacer:
- MaxLight S-Style
- MaxLight X Pre-Assembled Z-Style
- PSI E-Style
- Slim Stamp E-Style
- Super Slim

(b) Exposing Foam: For exposing foam only place the spacer onto the cover (magnets centre it automatically).
Following models have to be exposed with the spacer:
- MaxLight Z-Style
- MaxLight X Foam Only *
  (=disassembled Pre-Assembled Z-Style)

* X39 cannot be flashed as assembled die box. Always disassemble the X39 die box and flash foam only!

4 Place vellum

Make sure that the exposure area is clean and place the printed vellum paper onto the glass. The vellum is placed with the toner side facing up and the copy right reading (not reversed or mirrored). Ensure that the vellum paper is larger than the exposing die box or foam.
5 Place transparency film

Place one sheet of transparency film on top of the printed vellum. Ensure that the transparency sheet fully covers the vellum paper. The clear transparency film can be used from both sides. It is necessary to prevent the toner (from the printed vellum) from being deposited on the die box or foam due to the pressure and heat generated during the exposure process.

**Tip:** For easier handling you can staple the vellum and transparency together and then place it on the glass. This will prevent the vellum and transparency from sliding when you proceed to the next step.

6 Place die box or foam

Take the appropriately sized die box or foam for your printed artwork. Make sure that the transparency film as well as the die box or foam is clean and dust free. If necessary you can clean it with a dry cloth. Place the (a) die box or (b) foam (grey foam side facing down) on top of the transparency using the positing frame of the artwork. Make sure that the (a) die box or (b) foam is positioned exactly within the positing frame. You can also expose multiple die boxes or foams during one exposure process.
**Please note:** Super Slim stamps do not use an extra die box or foam. Super Slims have the foam and ink cartridge already included in the stamp and are exposed like die boxes. Just remove the dust cover (do not remove the index window) and place the complete stamp (grey foam side facing down) on the transparency film.

### 7 Close cover

Lower the cover down, grasp the handle and push it into an upright position until the handle meets with resistance and feels locked.

**Important:** Do not over push the handle!

![Close cover](image)

### 8 Set energy and press start

Switch on the machine using the main switch on the back side. Set the energy dial to an energy level of "6" and press the start button one time. After a few seconds the machine will flash once. The die box or foam is fully exposed after one flash cycle. There is no need to flash a second time.

**Please note:** Both die box and foam only use the identical flash foam material so there is no need to adjust the energy level between components. For artwork layouts with very fine details, the energy level can be adapted, if the impression quality is not as desired. To reach an even more fine impression, increase the energy level to "8" and expose two times. After first exposure press start button again. Do not open the cover between the first and second exposure cycle. With these exposure settings, very thin lines and fine details will print even more crisp.

![Set energy at "6" and press start](image)
9 Remove transparency

Open the clamp cover and take out the die box or foam. Remove the transparency from the exposed (a) die box or (b) foam.

Please note: Exposing without transparency film is not possible. The printed vellum and transparency film can only be used for one exposure (no reuse possible).

10 Ink and assemble the stamp

The exposed (a) die box or (b) foam is now ready to be used in the corresponding MaxLight, MaxLight X, PSI or Slim Stamp mount.
For proper stamp assembly follow the detailed inking and assembling instructions to be found in Trodat's Premium Flash Catalogue.
VII. Maintenance

The Trodat Flash Machine T1511M has been designed for low maintenance operation as well as ease of use. There are regularly scheduled maintenance requirements consisting of cleaning the glass and machine body as needed. Please observe the following cleaning tips.

Cleaning the exposure glass
Unplug the unit for 10 minutes before performing any operations below. It is very important to keep the glass in the exposure area clean and dust free. This will prevent any possibility of foreign objects interfering with producing a properly exposed die box or foam. Clean the glass with any household glass cleaner. Apply glass cleaner to a soft paper towel and then use the towel to clean the glass. Do not spray any cleaners directly on the glass or any other part of the machine.

Cleaning the machine body
Unplug the unit for 10 minutes before performing any operations below. Apply water or any mild household cleaner if needed to a soft towel and wipe the surface of the machine clean. The towel should be damp, not wet. Do not use any solvent based cleaners to clean the unit, this may cause damage to the paint or display.

VIII. Technical specification

Flash Stamp Machine Model: T1511M
Quantity of lamps: 3
Exposure area: 150mm x 110mm
Dimension: 340mm x 235mm x 187mm
Weight: 9.7kg
AC power supply: 220-240 V
Frequency: 50/60 Hz
Power consumption: 1200 W