

DTF INLINE

Max 1600



User Manual

Revision 1.0
Original Instructions



ADKINS

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Introduction

Thank you for purchasing the Adkins Inline Max 1600 Shaker Cure Unit (hereafter called, "The Machine")

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Caution

Adkins is in no way liable for any damages whatsoever (including but not limited to lost profit, indirect damage, special damage, or other monetary damage) arising from using or inability to use the machine, except as provided in Adkins warranty provisions.

This applies even if Adkins has been informed of the possibility of such damages. For example, we cannot be held liable for any loss of media or other materials from using the machine, nor are we liable for any indirect loss caused by printed materials.

Please note that we are not liable for any financial damage or lost profits resulting from the use of the machine, or for any claims from third parties.

Requests

- This manual describes the operations and maintenance of the machine.
- Illustrations in the manual may be different from the appearance of some models.
- Read this manual carefully and make sure you understand it before use.
- Although every effort has been made to ensure the accuracy of the information in this manual, if you find any issues, contact your dealer.
- This manual is subject to change without notice for improvement.

CE Statement

This equipment has been tested and found compliant with the requirements set forth in the declaration of conformity.

Product Appearance

Please note that the descriptions of the product appearance in the operating manual are primarily based on the product you actually receive. While ensuring the main functionality of the product remains unaffected, we continuously make subtle adjustments to the product appearance to achieve optimal design. These adjustments aim to enhance the overall look and feel of the product, providing you with an improved user experience.

In the case of significant changes, we will promptly notify you through the appropriate channels, ensuring that you stay informed about the latest product information.

Machines Intended Use

Automatic powdering and fixation machine for direct-to-film transfer medias. Applying and melting the fixing powder to the ink on the transfer film to produce a garment decoration transfer. The machine has built-in filtration and extraction for the removal of any by-products produced through the heating process. All components of the direct-to-film process are suitable for commercial use. The machine is only for the intended use stated above. Any misuse of the machine outside of being used for the powdering and fixation of direct to film powder or to direct to film medias is strictly ill-advised and not covered with in the manufacturer's warranty. Inserting anything other than direct to film powder or direct to film media into the machine could lead to damage to the machine and injury to users of the machine.

Airbourne Sound Emission

During use the A-Weighted Sound Emission is 70db(A) or lower

Do not leave this machine unattended whilst in operation

Do not let unauthorized, unqualified or untrained people use machinery – never allow children to operate or help at the machine.

Safety Precautions

Symbols

In this manual, symbols indicate and explain precautions. The indicated symbol varies depending on the nature of the precaution. Make sure you understand the meaning of each symbol and use the machine safely and correctly.

Example of symbols

Meaning	
	Failure to observe the instructions given with this symbol may result in death or serious injuries to personnel. Be sure to read the precaution carefully and use the machine
	Failure to observe the instructions given with this symbol may result in injury to personnel or damage to property.
	Important notes regarding use of the machine are given with this symbol. Use as reference information.
	Indicates the corresponding page for related information.
	Indicates a precaution requiring attention (including cases of danger or warnings). Specific precautions are shown in the figure.
	Indicates a prohibited action. Specifically prohibited actions are shown in the figure.
	Indicates an action that must be taken or instructions that must be followed. Specific instructions are shown in the figure.

Warnings and precautions in use

Warning



The set of power cables provided with the machine is for use only with the machine and cannot be used with other electrical devices. Do not use any power cables other than the ones provided with the machine. Failure to observe these instructions may result in fire or electric shock.

Do not attempt to modify the cable and avoid damaging or breaking it. Placing heavy objects on, heating, or pulling the cable may damage it, which may result in fire or electric shock.

Avoid use in humid places. Additionally, do not pour water on the machine.

Failure to observe these instructions may result in fire, electric shock, or failure.

Use of the machine under an abnormal condition, as when it is emitting smoke or fumes, may result in fire or electric shock. Turn off the power switch immediately and then be sure to unplug the machine from the outlet. Once you have confirmed that smoke is no longer being emitted, request repair from your dealer. Never attempt to repair the machine yourself. Doing so is hazardous.

Never disassemble or modify the machine. Failure to observe these instructions may result in electric shock or failure.

Do not use extension cords. Failure to observe these instructions may result in fire or electric shock.

Keep foreign objects such as pieces of metal away from the power plug prongs. Failure to observe these instructions may result in fire or electric shock.

Do not overload electrical outlets by using too many pieces of equipment. Failure to observe these instructions may result in fire or electric shock.

If the power cable is damaged or the core wire is exposed or broken, ask your service representative to replace it. Using it as is may result in fire or

Warnings and precautions in use

Warning

electric shock.

Do not handle the power plug with wet hands. Failure to observe these instructions may result in electric shock.

Always hold the power cable by the plug when unplugging the machine. Do not unplug by holding the power cable. Failure to observe these instructions may damage the cable or result in fire or electric shock.

Do not use a voltage other than the indicated voltage. Failure to observe these instructions may result in fire or electric shock.

Do not use a power frequency other than the indicated frequency. Failure to observe these instructions may result in fire or electric shock.

If metal, water, liquid, or other foreign objects enter the machine, turn it off immediately. After that, be sure to unplug the machine and contact your service representative. Using it as is may result in fire or electric shock.

Keep the heater on the media transport surface free of dust and debris. Failure to observe these instructions may result in sparks or fires.

Keep children away from this machine.



Do not use a flammable spray or solvent inside or around the machine. Failure to observe these instructions may result in fire or electric shock from ignition.

Do not place vases, potted plants, cups, cosmetics, containers of chemicals or water, or small metal objects on top of the machine. Liquid or foreign objects may get inside the machine, leading to fire or electric shock.

Precautions in use

Warning

Handling of the power cable



Plug into a polarized electrical outlet. Always plug the power cable into an outlet near the machine, and make sure the power cable can be easily unplugged.

Regularly (at least once a year) unplug the cable and remove any dust on or near the power plug. Failure to remove dust may result in fire.

Do not use a voltage other than the indicated voltage.

Before plugging in the machine, check the outlet supply voltage and circuit breaker capacity. Plug each cable into a power source with an independent breaker. If you plug more than one power cable into an outlet that share the same circuit breaker, it may trip the breaker.



Notes on maintenance



Pay close attention to ventilation and be sure to wear safety glasses, gloves, and a mask when dealing with unused hotmelt powder, airborne particles may enter the eyes or mouth. Please take precautions.

Moving part precaution



Keep fingers and other body parts away from hazardous moving parts. Do not touch the dusting roller when it is rolling. Failure to observe these instructions may result in finger injury such as torn skin or fingernails.

Keep your head and hands away from moving parts during operation. Failure to observe these instructions may result in injury such as your hair becoming caught in the machine.

Wear suitable clothes. (Do not wear loose-fitting clothes or accessories.) Keep long hair bound.



Precautions in use

Caution

Heater



Do not pour liquid on the media transport surface. Failure to observe these instructions may result in heater failure or sparks.

Do not touch the media transport surface with bare hands while the heater is hot. Failure to observe these instructions may result in burns.

Precautions and notes

Warning

Consumable items



Machine consumables, including hot melt powder and transfer film.

The machine's safety level is based on the use of Adkins recommended transfer film. To ensure operational safety, please use the transfer film recommended by Adkins.

If hot melt powder is brought from a cold place to a warm place, please let it sit at room temperature for at least three hours before use (refer to product info for full details).

Do not leave consumables exposed to the air for an extended period; if left open for along time, they may not transfer properly. If not in use, seal and store them.

Store consumables in a cool, dark place.

Keep consumables out of reach of children.

Once consumable packaging is opened, please use it within half a month. After a certain period of time, the transfer quality may decline. Refer to specific product details.

Please hand over unused consumables to your dealer or service representative. If handling them yourself, comply with the requirements of industrial waste disposal facilities and local regulations.

Warning

Notes on maintenance



Some parts of the machine require regular replacement.

Machine disposal



Contact your dealer or service representative for assistance when disposing of the machine. If you do dispose of it by yourself, request assistance from an industrial waste disposer.

Warning

Notes on maintenance

- Use in a room with as little dust as possible.
- Use in a room with as much ventilation as possible.
- **Important:** Regularly wipe the oil tank to keep it clean and prevent oil accumulation.
- Store transfer film in a bag. Wiping off dust accumulated on the media will adversely affect the media due to static electricity.
- When leaving the workshop after working hours, do not leave any media on the roll hanger. Dust will adhere to the media.

Warning

Handling of media

- Use recommended media. Please use the media recommended by Adkins to ensure reliable, high-quality transfers.
- Be aware of media expansion and contraction. Do not use media that has just been opened. The media may expand or contract depending on the room temperature and humidity. Open the package and allow it to adjust to the place of use for at least 30 minutes before loading it on the machine.
- Do not use curled media. Not only does this cause media jamming, but it also affects transfer quality. Straighten any media that is significantly curled before use. When rolling up regular-sized coated media for storage, make sure the coated side is facing outward.
- Set the heater temperature to suit media characteristics.
- Do not leave media loaded over extended periods with the heater on.
- With some types of media, under high temperature and humidity, it may affect the transfer. Be careful about where media is stored.

- With some types of media, if the media is left exposed to air, the ink-receiving layer may change, causing image defects such as blurred colours and bleeding.

Warning signs and mandatory signs

Warning signs



“Warning; electricity” and it is used to warn people about the risk of coming into contact with electricity (e.g. electricshock, electrocution hazard, hazardousvoltage).



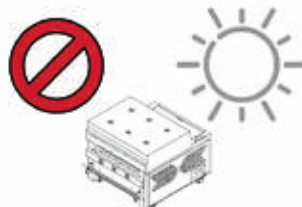
“Hot Surface” and it is used to warn people to take care to avoid coming into contact with a hot surface



“Crushing Hazard” and it is used to warn people to take care to avoid coming into contact with moving parts during operation.

Installation precautions

Places exposed to direct sunlight



Places with uneven surfaces



Places where vibration is generated



Places directly exposed to air conditioning



Places subject to significant changes in temperature or humidity



Places where open flames are present



Power Supply



Before connecting the machine to the power supply:

- Ensure the power supply matches the voltage and frequency specifications listed on the machines label.
- Only use properly earthed (grounded) outlets to avoid electric shock
- Verify that the circuit is protected by an appropriately rated fuse or circuit breaker to prevent overloading.
- Do not connect if the power cord or plug is damaged
- Turn off the power switch before plugging in.

If you are unsure about suitability of the power supply or circuit protection, contact a qualified local electrician for assistance. Failure to follow these instructions may result in electric shock, fire or damage to the machine



It is advised to connect the machine power to a circuit that has the correct power rating and RCD protection as to not overload the circuit. If you are unsure please contact your local electrician for electrical advice.

Before opening any panels on the machine please make sure all power has been isolated, to avoid the risk of coming into contact with electricity (e.g. electric shock, electrocution hazard, hazardous voltage).

Machine Technical/Sales Specification

Power Requirements

Power Consumption (w)	2640	Heat Up/Max	1980	At Temp
Power Supply (volts)	220			
Current (amps)	12	Heat Up/Max	9	At Temp
Machine Fuse Rating (amps)	20			
Plug Socket Requirement	16 Amp Comando Plug Socket			

Weight & Dimensions

	Width	Depth	Height
Machine Size (cm)	199	178	94
Net Weight (kg)	421		
Shipping / Packaging Size (cm)	210	171	120
Gross Weight (kg)	520		
Suggested Minimum Workable Area (cm)	410	230	148

Production Information

Operating Mode(s)	Manual / Auto Control
Max Media Size	160cm Wide
Heating / Curing	4 x Top / 10 x Bottom Heating Elements
	Heating time 10 mins (100 degrees)
	Max Temperature 140 degrees

Air-Purification	Built-In Filtration and Extraction Filters (Paper & Carbon)
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Display	Digital Touch Screen
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In the Box

Adkins Inline Max 1600 Powder Shaker Unit	1
16amp Comando Plug	1
Wooden Ramps for Pallet Removal	1

Unboxing and installation

Unboxing

Before installing the machine, ensure that the required amount of space is available in the place under consideration. The place of installation must have enough space for the machine as well as transferring tasks. See overleaf.

When moving the boxed item, only insert and lift where the markings are instructing.



Place the box in a position that is flat and level, and that you have sufficient space to unbox and remove the machine from the pallet.

Remove the securing transport screws. It is recommended that 4 people lift the sides and lid upwards and over the machine, taking care not to damage / scratch the outer surfaces.

The protective wrapper can be removed from the machine.



It is recommended that a forklift truck is used to remove the machine from the pallet. Lifting may be carried out from either the front or rear of the machine, with the forks positioned centrally to ensure safe and balanced handling.

although within the packaging are two ramps which can be used to allow the machine to be manoeuvred off the pallet. It is recommended that 4 people manoeuvre the machine off the pallet and into position.

(1)

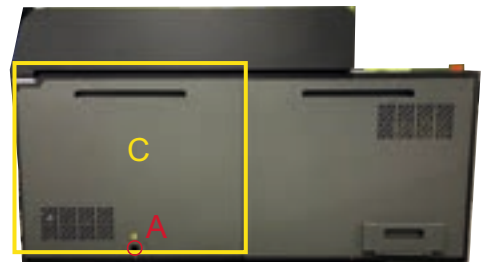


Installation

The heater hood is fixed by screws for transportation and need to be removed, and the filter door connection checked.

1

Remove the screw marked (A) that is securing the side panel. Once the screw is removed, Use the key supplied (1) and gently lift the side panel (c) upwards to remove the panel.



2

Proceed to remove the side panel from the opposite side, by removing the screw (B).



3

Once both sides are removed, remove the two screws that are holding the hood cover in place. There is one screw either side located as below.



Installation

4

Attach the take up brackets onto the machine (with supplied 3mm allen key) 4 screws on each bracket. Lining up the arrows on the body and brackets

5

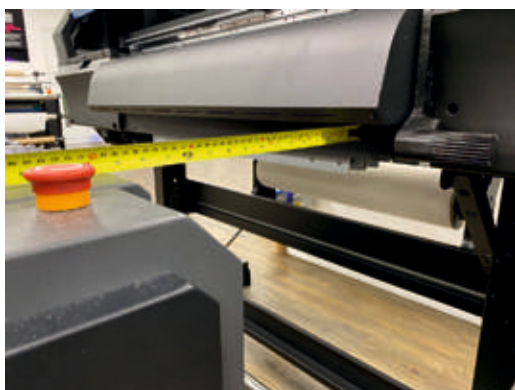


6

Position the machine in front of the printer to be used. The printer and machine have to be perfectly aligned for the film to run true.

If there is any mis-alignment the media can move or track off while in operation causing issues.

Use a tape measure to check that the front of the machine is aligned to your printer.



7

Using a spirit level, if possible (with adjustable feet), ensure the printer is level first. Then level the machine by lowering the rubber feet, via the red adjuster cog.

8

Connect the plug to a suitable plug socket (do not use an extension lead) and switch on via the green on/off button. If the system does not turn on, make sure that the emergency stop is not engaged.

Ensure the power lead is not going to come in to contact with any moving parts or any heat source and does not constitute a trip hazard.

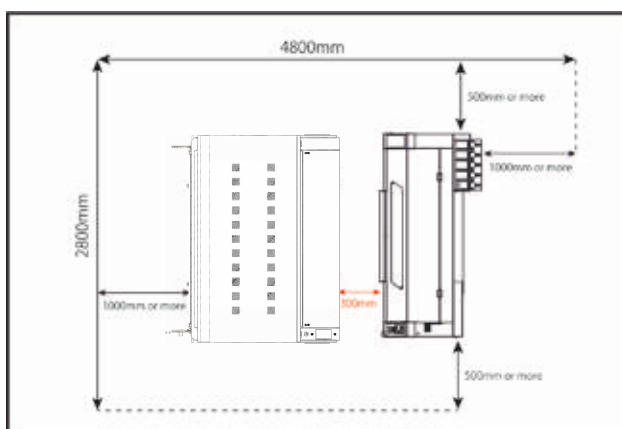
Places of installation

Before installing the machine, ensure that the required amount of space is available in the place under consideration. The place of installation must have enough space for the machine as well as transferring tasks.

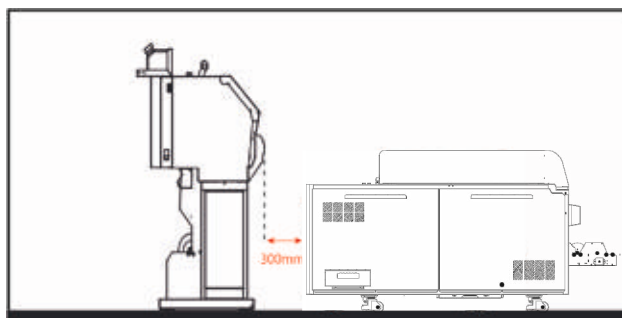
Width	Depth	Height	Total weight
199cm	178cm	94cm	421Kg

Minimum Working Area

Top view



Side view



Temperature of working environment

To ensure reliable transfer, use the machine in an environment of 20–28°C.

Airbourne sound emission

During use the A-Weighted Sound Emission is 70db(A) or lower

Before use

About this chapter

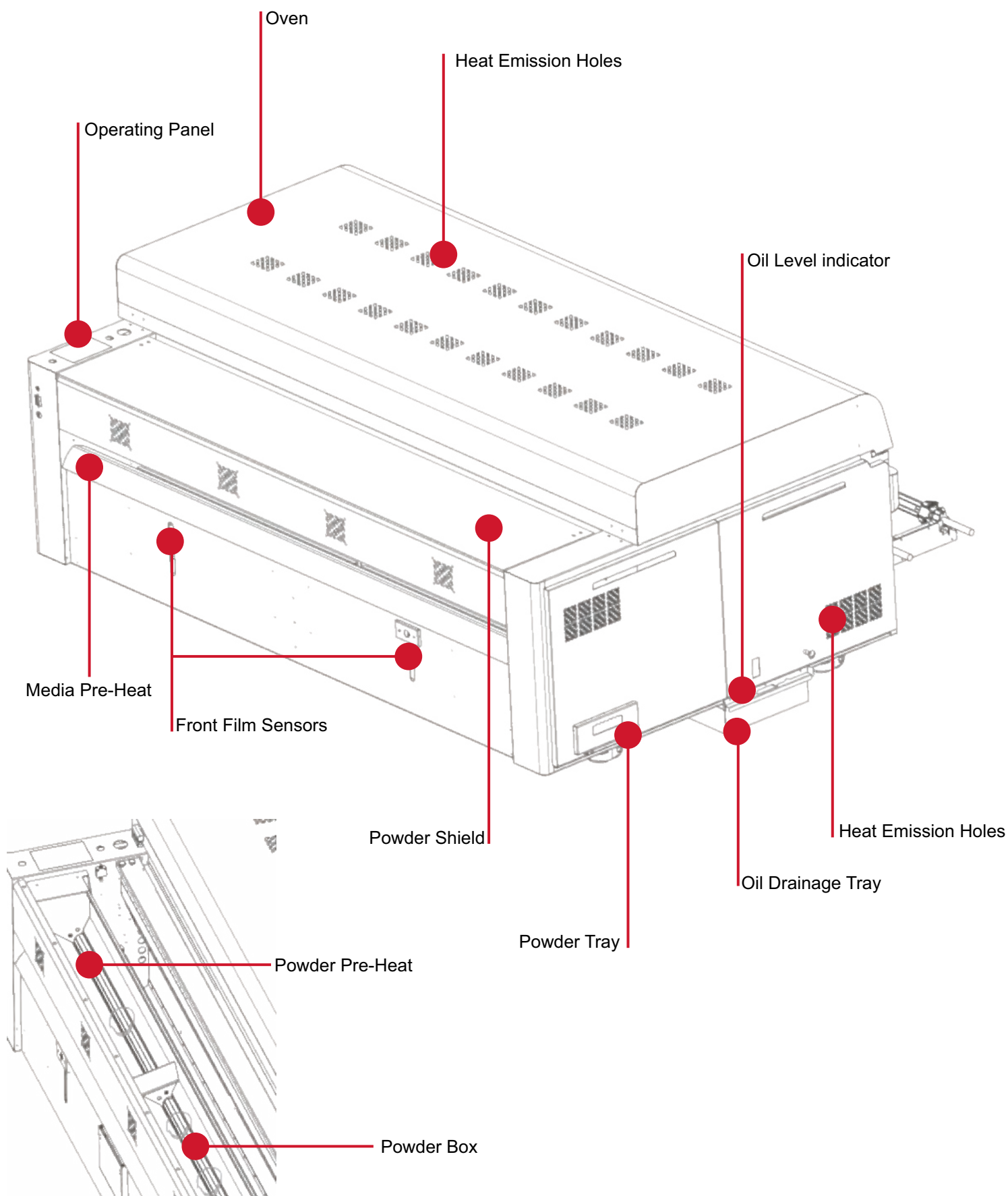
This chapter describes information to know before use, such as part names and installation instructions.

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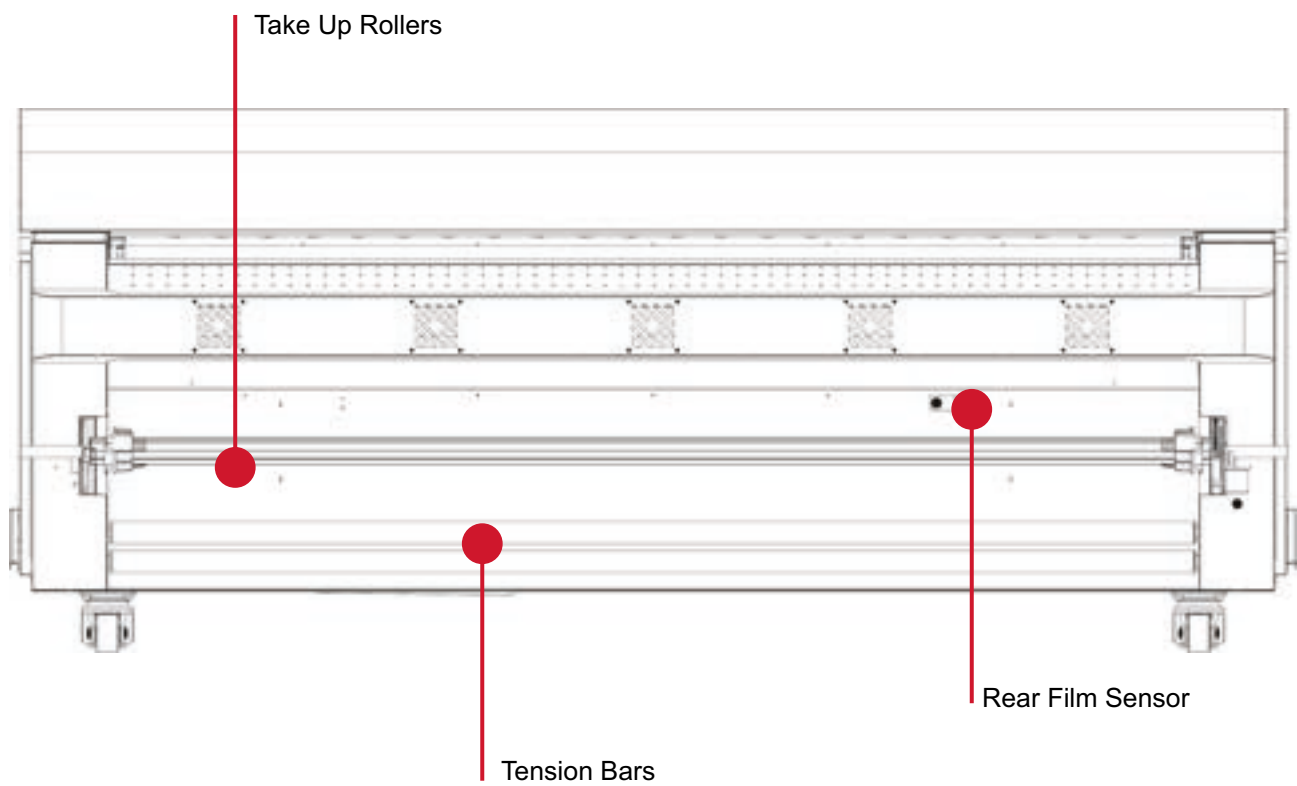
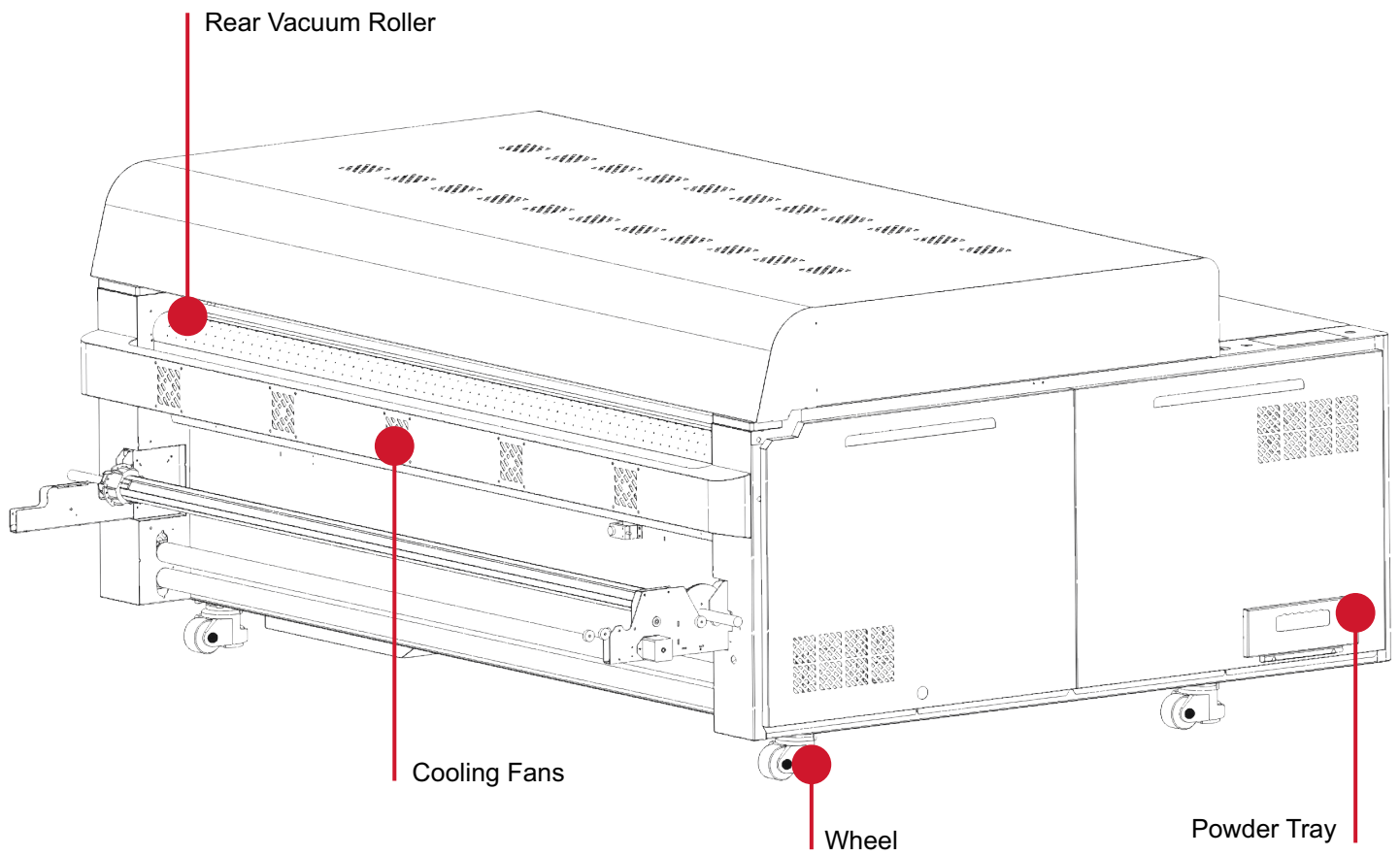
Part Names and Functions

Front



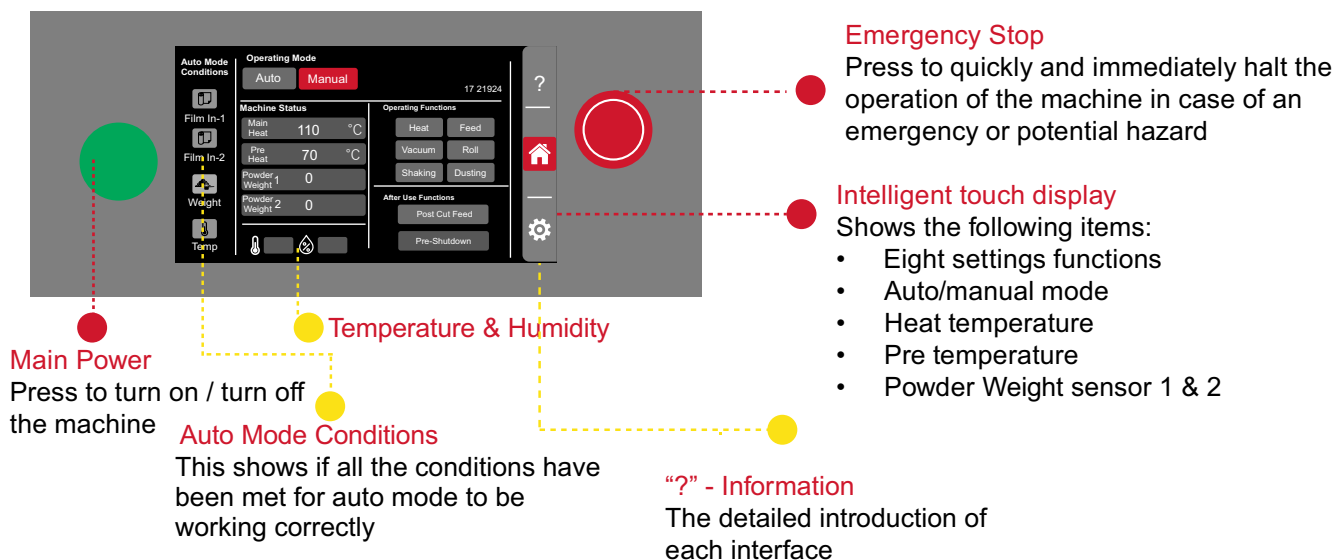
Rear Vacuum Roller

Rear



Operating Panel

Use the operating panel to specify print settings or operate the machine.



Function introduction

Icon	Details
Post Cut Feed 	"Post Cut Feed" can only be activated in the machines automatic mode. Post cut feed turns the film sensor off and instructs the machine to pull the film through the dryer, whether or not there is film in front of the sensor. This is used at the end of a job.
Heat	To activate the machine's heating function.
Dusting	To initiate the powder box roller to dust powder on to the film.
Vacuum	To start the operation/suction of the Vacuum roller.
Roll	To initiate the take up motor and tension system.
Shaking	To activate the powder shaking function (to remove excess powder from the film).
Feed	To start the vacuum movement, initiating the paper feeding movement of the machine when in manual and partial auto mode.
Pre Shutdown	To start the pre shutdown mode of the machine after post cut feed has finished.
Grey Red	
Off	On

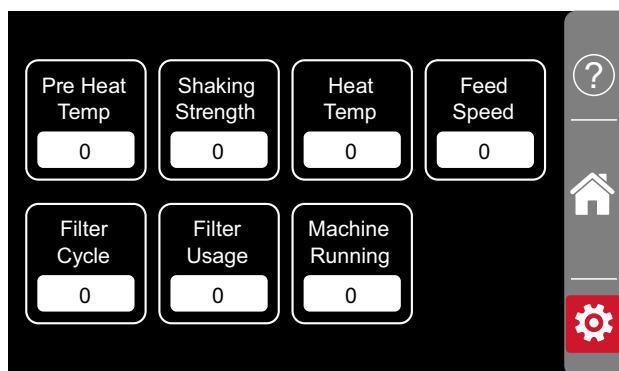
Temperature

Icon	Details
	Shows the current temperature of the oven (flashes with target temp whilst heating).
	Shows the current temperature of the pre-heater (flashes with target temp whilst heating).
	Show the current capacity of powder in the weight sensors . Display showing a minimum value of 0 and a maximum value of 100(0-100).
	

Settings



The parameters may require adjusting depending on the film, powder and print settings you use.



Pre temperature: Operating temperature of the pre-heater
Shaking Strength: Frequency of the powder blade intensity
Heat Temperature: Operating temperature of the oven
Feed Speed: The speed of media feeding
Filter Cycle: The interval duration set for filter operation reminders(non-editable, display only)
Filter Usage: The total operating time of the filter since it was last replaced.(Resettable)
Machine Runtime: The total operating time of the machine since the machine is powered on with heat and feed active. (non-editable,displayonly)

Auto/Manual mode



Switch to choose Auto mode or Manual mode of the machine.

Auto mode:

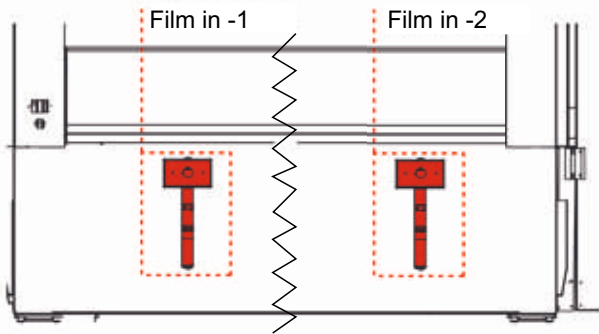
When the powder capacity value reaches approx. 50 and the oven temperature conditions have reached the specified temperature, and the Front sensor has sensed the film the machine can initiate the automatic transfer mode, allowing one person to operate multiple machines simultaneously. All auto conditions have been met by showing red on the screen. The machine will automatically feed the media at the speed of the printer, cure and take up the film on to the take up core.

Manual mode:

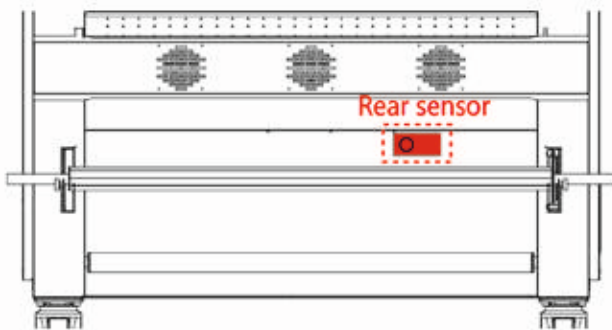
In manual mode, the machine allows adjustment of various parameters, enabling real-time monitoring and adjustment of machine operations giving full manual control.

Front & Rear Sensors

The front sensors is used to detect whether the machine has fed in media. The machine is equipped with two front sensors, located beneath the media pre-heat.



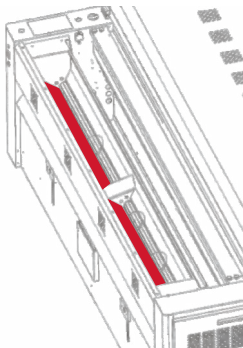
The front sensor has adjustable height levels, allowing users to adjust it to the appropriate position based on their needs.



After the transfer film is finished baking, it will exit the oven. The rear sensor is used to detect whether the transfer film has completed baking and emerged from the back, turning on the suction and cooling fans.

Powder Box

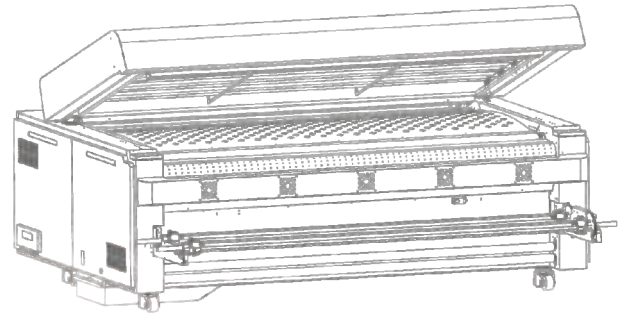
The powder box's main functions include Powder Storage powder supply and convenient powder replacement, ensuring a continuous supply of powder and high-quality printing results.



Powder preheat

Its purpose is to maintain a high level of dryness for the hot -melt powder inside the box, preventing it from absorbing moisture.

Heat Lamps



The upper and lower double rows of high-efficiency heating lamps (lower row is under the feeding belt) Combined with our unique intelligent heating solution, which offers efficient power consumption.

* Note you will only see 3 elements glow (2 bottom and 1 top)
This is because carbon element bulbs are installed and will not glow in the same way.

Tension Sensors

The tension sensor is used to maintain and adjust the tension of the printing material, besides it helps maintain print quality, facilitate powder transfer, and ensure accurate printing positioning by adjusting the tension of the printing material.

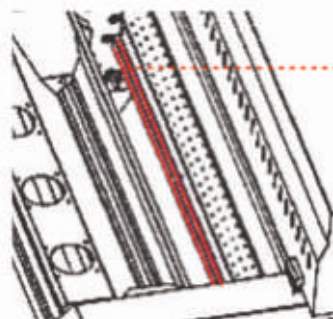


Tension sensors 1 and 2

Located beneath the take-up roller.

Tension bar 1 (Blue) is used for single roll operation
Tension bar 2 (Yellow) is used for dual roll operation for the left hand side (Film in 2)

Powder Shaking Blades

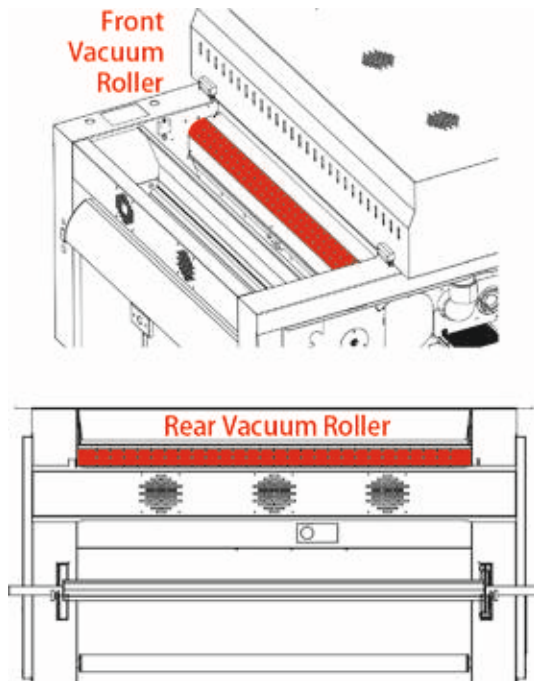


Powder shaking blade

Contributing to the uniform distribution of transfer powder through vibrational motion, thereby ensuring high - quality and consistent printing results, located beneath the vacuum roller.

Dual Vacuum Rollers

Through dual suction from the front and back, the paper feeding accuracy is ensured during the film transportation process, allowing it to better adhere to the conveyor belt. This ensures even baking of the transfer film.



Once the film is detected by the rear sensor, the front vacuum roller will stop suction but continue to transport the film, while the rear vacuum roller will maintain both suction and transport functions, cooling fans will also be engaged.

Power supply



Before connecting the machine to the power supply:

- Ensure the power supply matches the voltage and frequency specifications listed on the machine's label.
- Only use properly earthed (grounded) outlets to avoid electric shock
- Verify that the circuit is protected by an appropriately rated fuse or circuit breaker to prevent overloading.
- Do not connect if the power cord or plug is damaged

- Turn off the power switch before plugging in. If you are unsure about suitability of the power supply or circuit protection, contact a qualified local electrician for assistance.

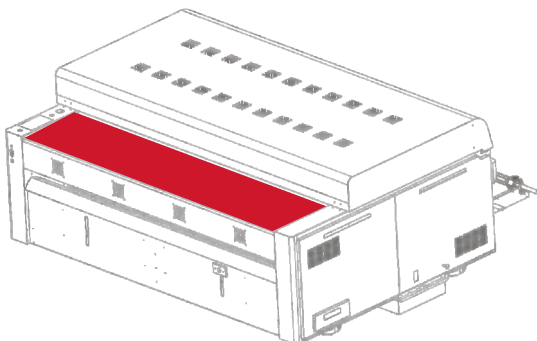
Failure to follow these instructions may result in electric shock, fire or damage to the machine

It is advised to connect the machine power to a circuit that has the correct power rating and RCD protection as to not overload the circuit. If you are unsure please contact your local electrician for electrical advice.

Before opening any panels on the machine please make sure all power has been isolated, to avoid the risk of coming into contact with electricity (e.g. electric shock, electrocution hazard, hazardous voltage).

Powder Shield

The powder shield's function is to prevent powder from splashing. If it is opened while the machine is running, the powder shaking function will stop. Once it is closed, the powder shaking function will resume.



Basic operation

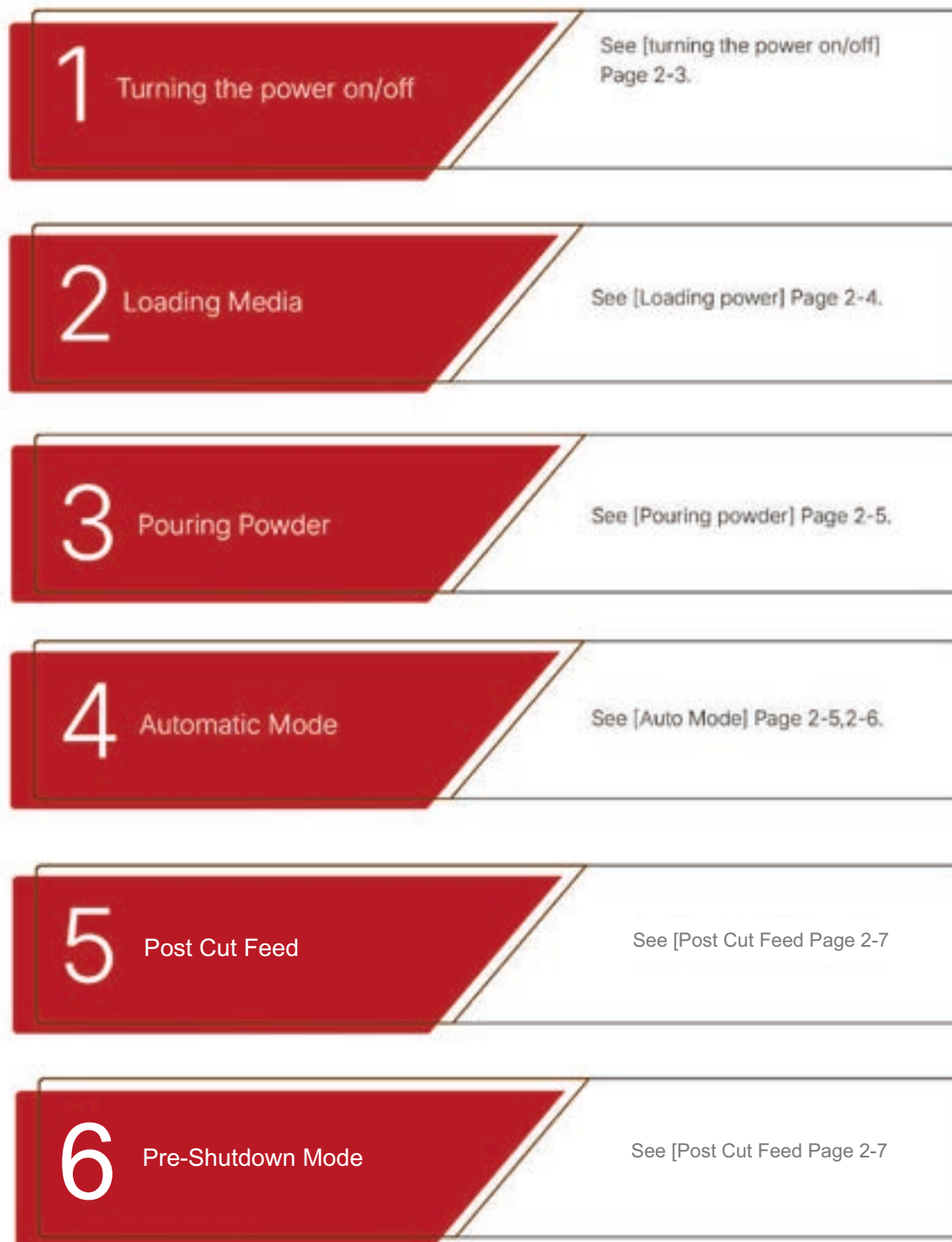
About this chapter

This chapter describes information about basic operation, such as how to load printing media, how to use auto mode and link mode correctly.

Chapter 2 - Basic Operations

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Workflow



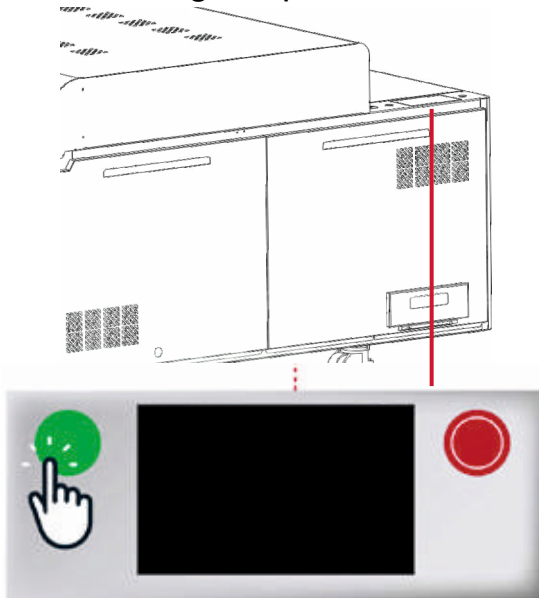
Please notice

The machine used to demonstrate the workflow in this section differs from the actual model, but the overall workflow sequence remains the same.

Emergency stop

Turning the power on/off

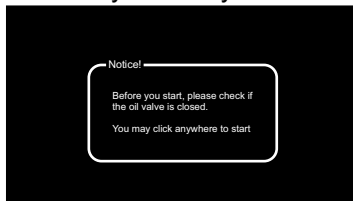
Turning the power on



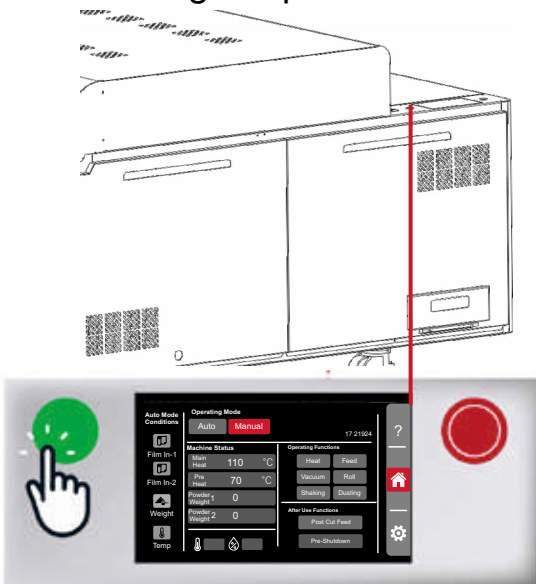
Press to turn on the machine

Before you start, please check if the oil valve is closed.

You may click anywhere to start



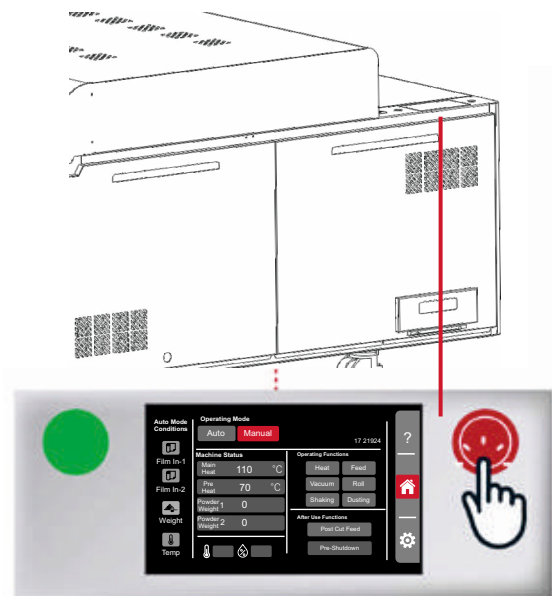
Turning the power off



Press to turn off the machine



Please ensure that the machine completes the transfer operation before turning off the power



Press to activate. Rotate the button to the right to exit the emergency stop state

Warning



Emergency stop can be activated only in the following situations:

Emergency Scenarios: In case of emergencies or potential hazards, the emergency stop button or switch is used to quickly initiate the emergency stop. This rapidly halts all movements of the machine to prevent injuries or equipment damage.

Loss of Control: If the operator loses control of the machine and is unable to handle unforeseen circumstances, the emergency stop is employed to swiftly halt the machine operations.

Equipment Malfunction: When there is a malfunction or abnormal operation of the equipment, the emergency stop helps prevent further damage and protects both operators and the equipment.

Safety Checks: During maintenance or safety checks, it may be necessary to activate the emergency stop to ensure the safety of personnel.

It's important to note that the emergency stop is intended for responding to urgent situations or ensuring safety, **so it should be used sparingly under normal circumstances.** After activating the emergency stop, a proper inspection and maintenance of the machine are usually required to ensure its safety and normal operation.



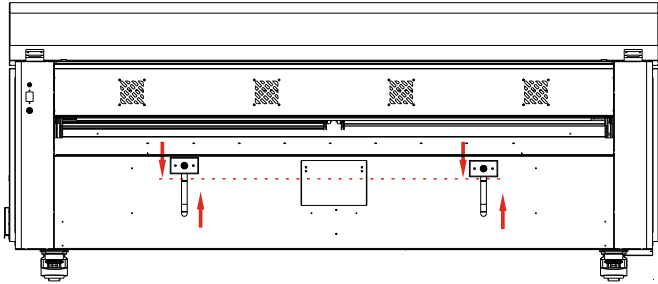
The Adkins Inline Max 1600 supports either a single DTF film roll from 1200mm to 1600mm wide, or two rolls up to 600 mm wide each in Dual Roll Mode.

In Dual Roll Mode, both rolls must be printed by the same printer using a single print engine. Use with two separate printers is not supported and falls outside the intended use of the system.

Loading Media

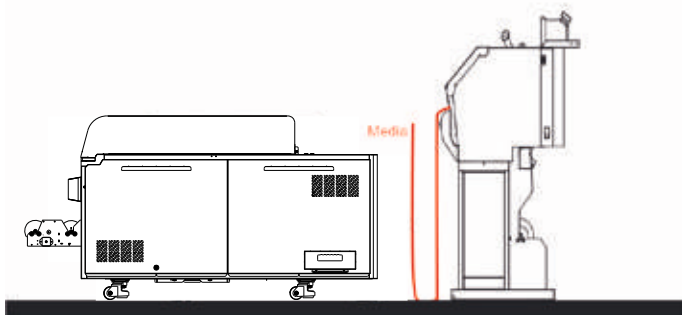
Adjusting the sensor height

Make sure both sensors are set at the same height

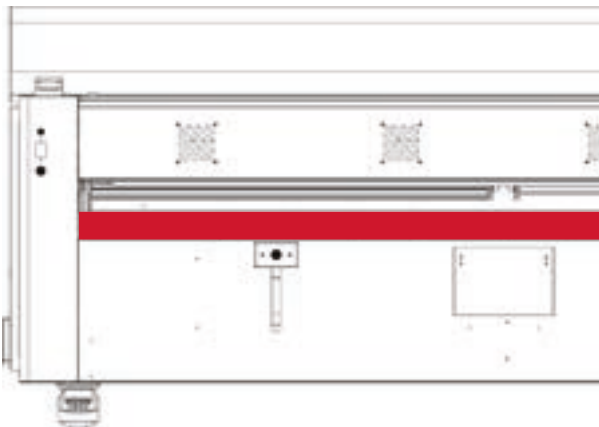


Loading the film/media

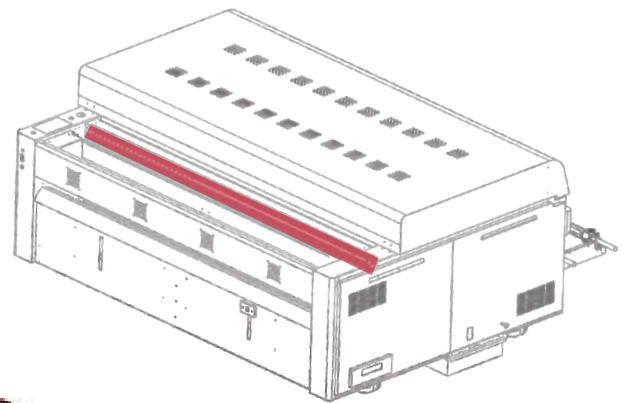
- 1** Wait until the media is long enough. The media length should generally reach close to the ground, see below.



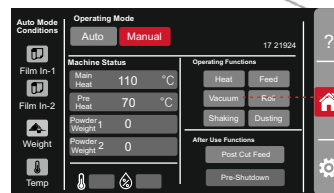
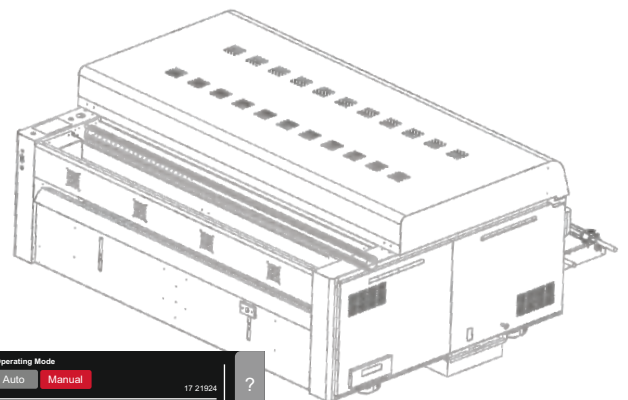
- 2** Feed the media into the shaker. The entrance is as shown in the diagram, above the pre heating plate.



- 3** Feed the media through to the vacuum roller. Ensure that the media is placed over the vacuum roller, keeping it fed straight, and hold in place.

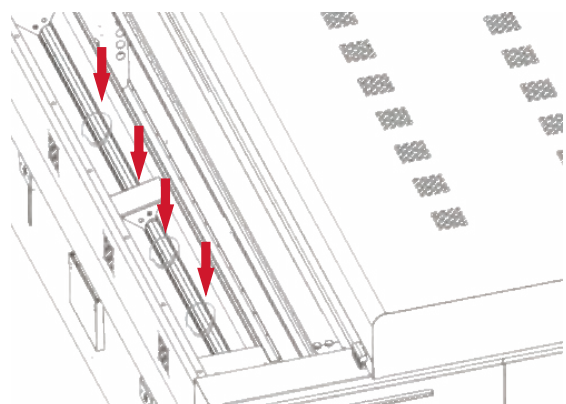


- 4** Turn on the 'Vacuum' function. Activate the vacuum roller to hold the film in place.



Vacuum → Vacuum

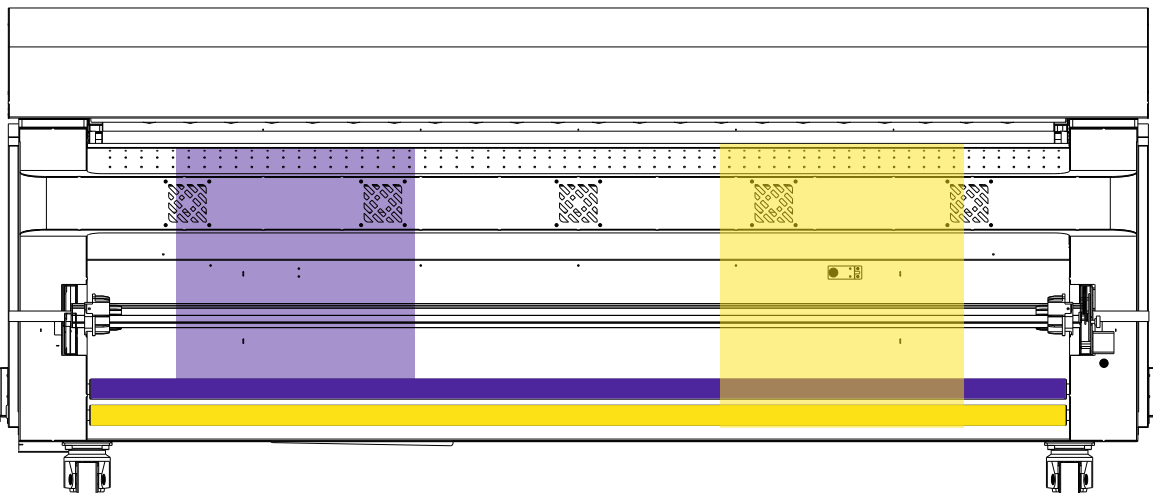
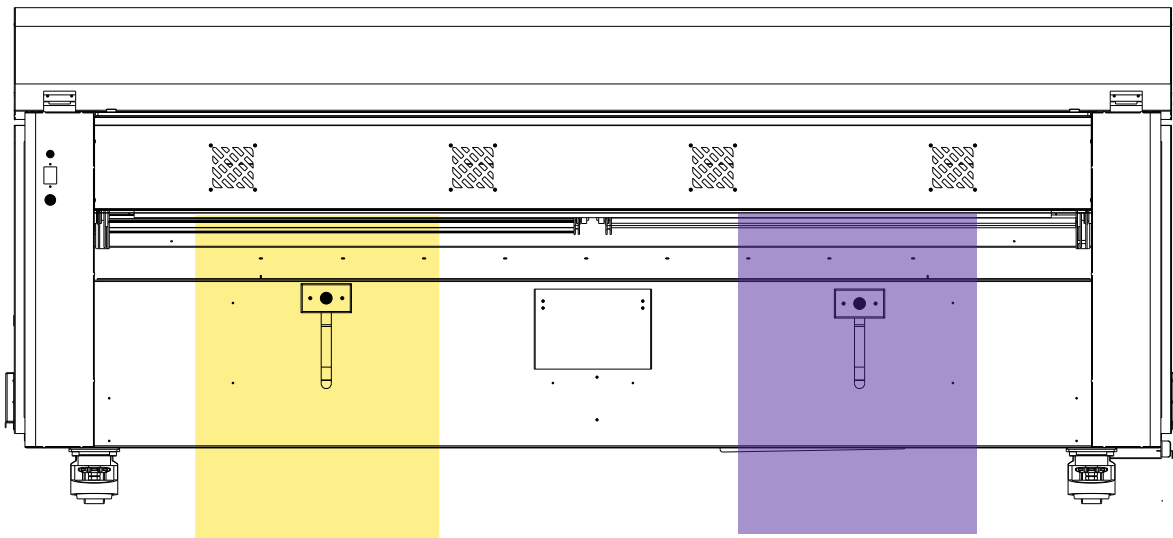
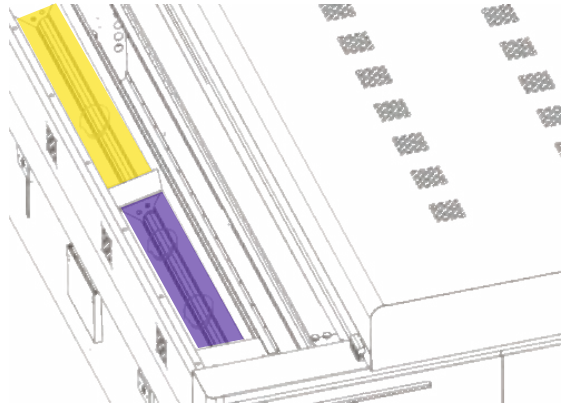
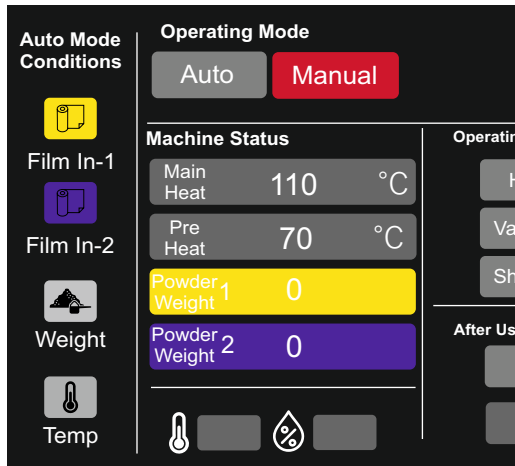
- 5** Adjust the position of the powder holders. Media holders pushed close to the media ensures minimal powder will fall outside or off the film, reducing the interval for replenishing powder.



Loading Dual Roll Media

Supports running two separate parallel rolls simultaneously, making it ideal for processing different jobs side-by-side. When loading for dual roll printing please observe make sure the film path is loaded correctly and the media guides are set in the correct places before loading.

* Colours are for illustration purposes only



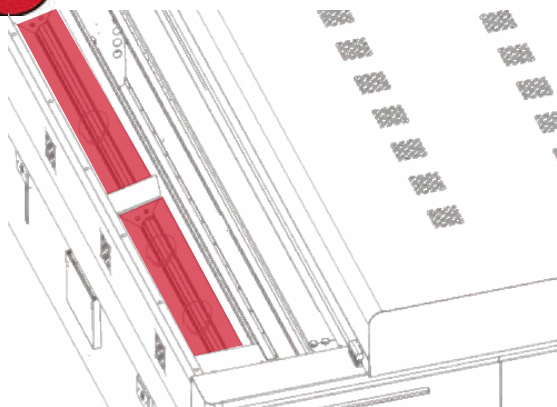
Film 1 (Touch Screen Side) Yellow = Bottom tension bar and furthest away Take up roller

Film 2 (Filter Side) Yellow = Top tension bar and closest Take up roller

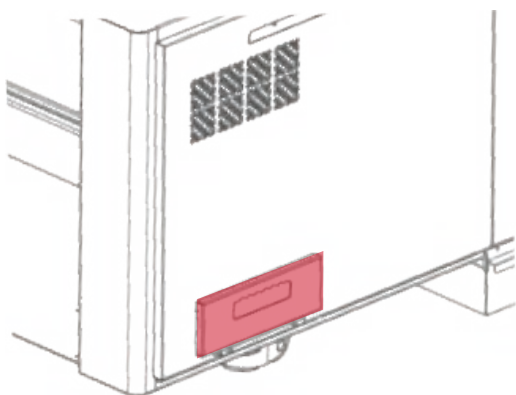
Pouring powder

Pouring powder

- 1 Adding powder into the powder box.

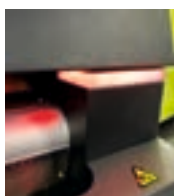


- 2 Opened adhesive powder can be stored in the two powder trays on each side to facilitate easy extraction for the next powder addition.



When the powder is low on one of the powder boxes the following lights will flash to indicate which box needs powder. This can be taken out of the powder tray and emptied into the low powder box, then the light will return to normal operation.

Powder box 1 empty



Flashing Colour

Normal operation



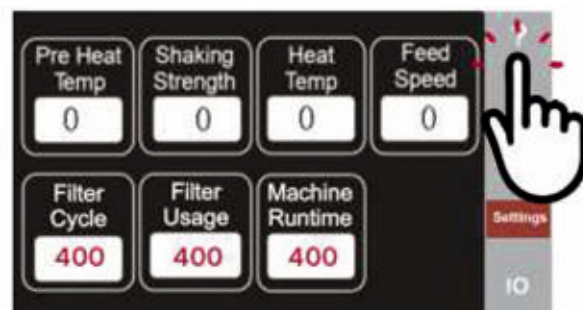
Solid Colour

Powder box 2 empty



Flashing Colour

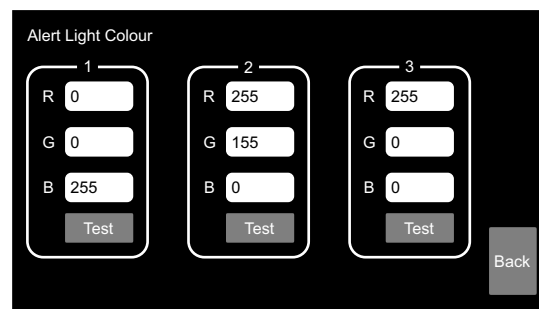
Changing Alert Light Colour



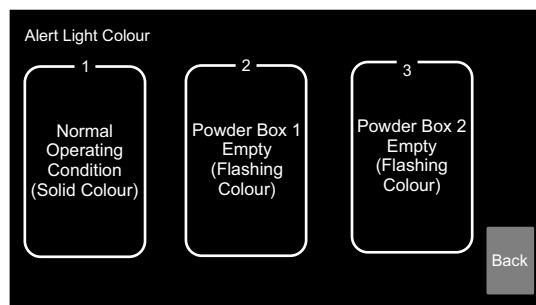
Press "?".



Enter Password 38765, Then Enter button



These are the colours which are suggested to use but they can be changed to suit your needs.

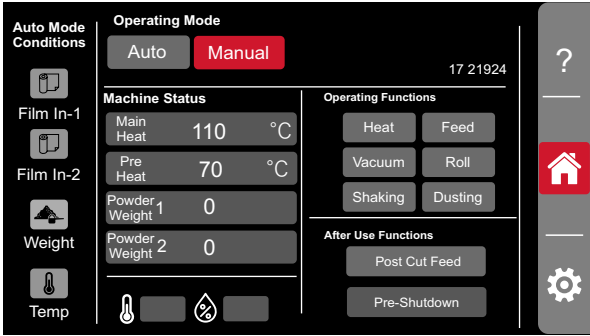


Auto mode

Switch to Auto Mode

- 1

Turn the “Heat” function on. (15minutes of preheating is recommended before moving to step 2).



- 2

Switch the auto function on.



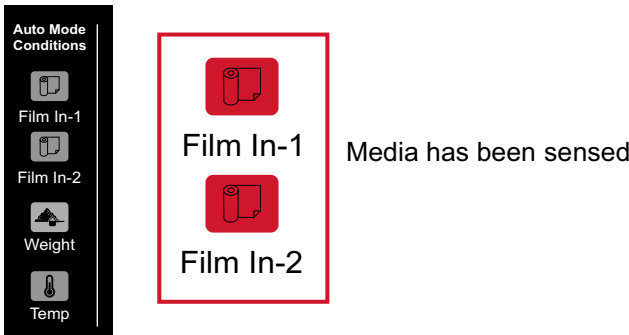
Conditions of Auto Mode

- !

For Auto Mode to function the following conditions are required.

- 1

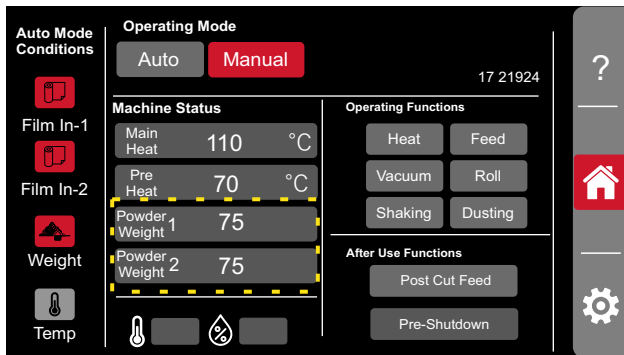
The machine needs to sense film is present (at the front film sensor).



If the icon is red, it indicates that the media has been sensed; if the icon is grey, it hasn't.

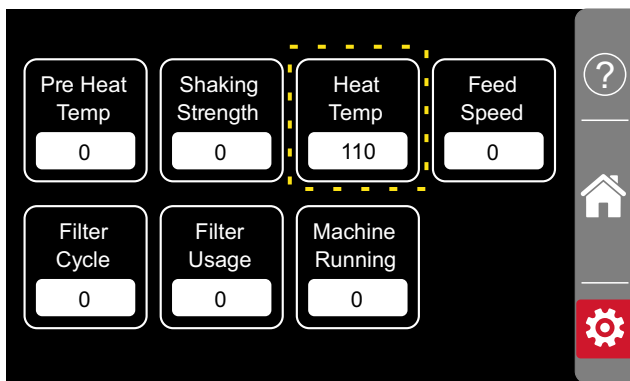
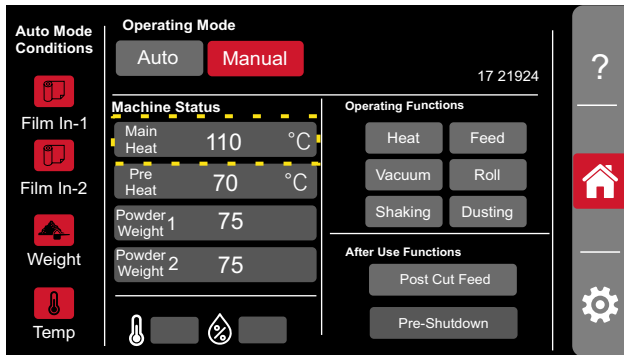
2

The Powder weight sensor has reached 50 or more, it indicates that the powder capacity meets the Auto mode condition.



3

The temperature has reached the target / set temperature.



4

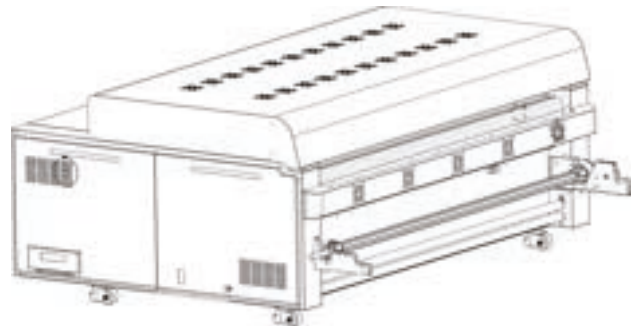
The machine is now in partial auto mode.

After the machine meets the above three conditions, it enters the semi-automatic mode status, allowing for the next step in the operation.

Loading film/media to take up

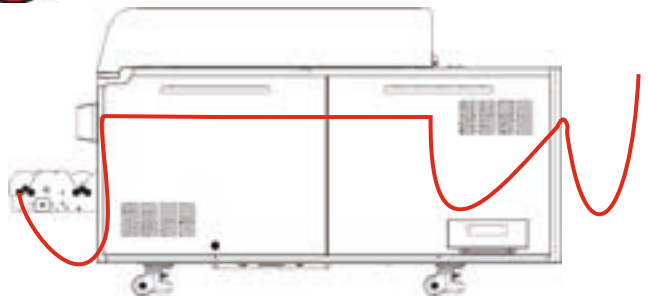
1

Wait for the film to pass through the oven.



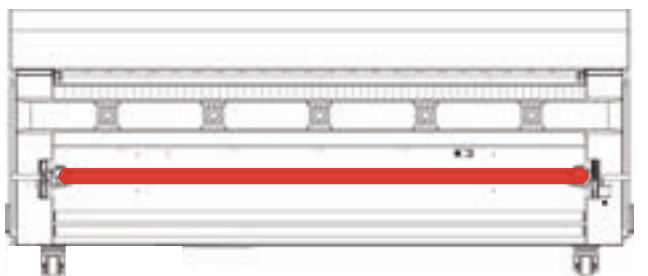
2

Allow enough slack on the film.



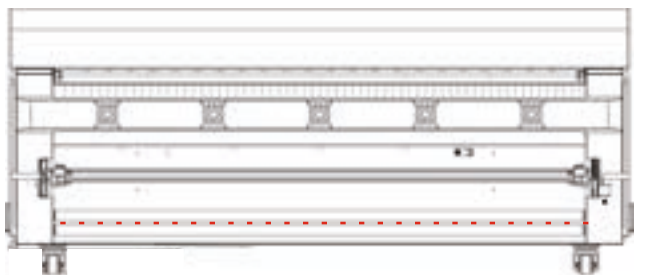
3

Attach the media to a cardboard take up core.



4

The machine is now in full Auto Mode.



The machine will be in the fully automatic mode when the tension sensor reaches its highest point.

When the machine is in full Automatic Mode Post Cut Feed

After the full automatic mode is activated, the front vacuum roller will stop suction but continue to transport the film while the rear vacuum roller and the tension take -up system will maintain both suction and transport functions to pull and tighten the media through the oven.

The front and rear vacuum roller operates intermittently allowing for the film to self align and ensure straight feeding.

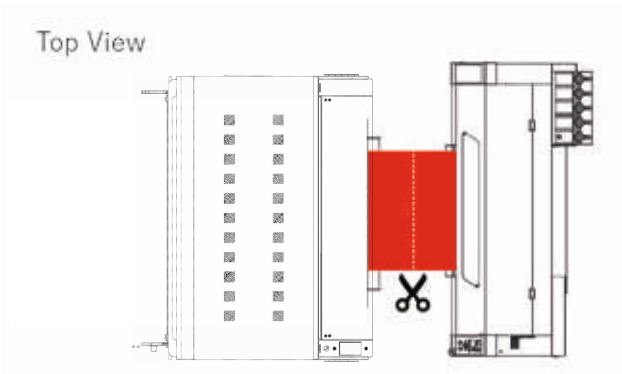
Post Cut Feed



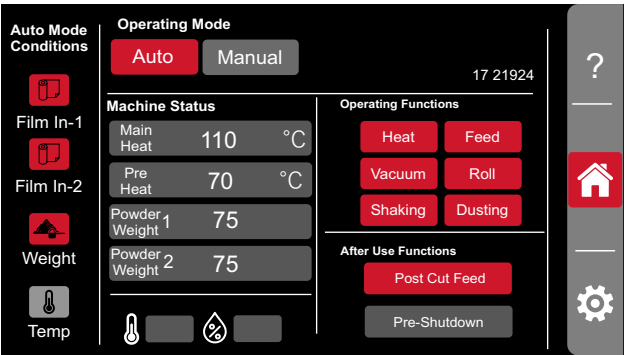
Post Cut Feed can only be activated upon completion of the transfer operation in auto mode.



After the print has finished roll off 500mm then cut the film.



Turn on Post Cut Feed.



Allow the film to feed through and cure

After Initiating the link mode,the machine will automatically complete the final heating work, ensuring the last media in the oven is fully baked until there is no media left inside.

The vacuum roller operates intermittently allowing for the film to self align and ensure straight feeding.

The system continues to pull the media through as the front sensor is deactivated in link mode.

Maintenance Guidelines

About this chapter

This chapter is about daily maintenance guidelines of the machine, properly maintaining the machine can extend its lifespan.

Chapter 3 - Maintenance Guidelines

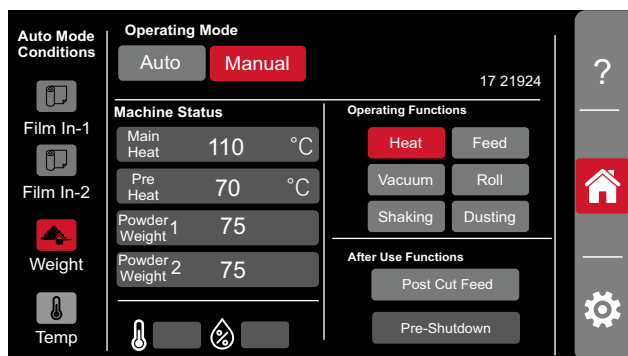
Routine Maintenance	3-1
Before use	3-2
After use	3-2
Oven cleaning	3-2
Filter box	3-2
Regularly replace the filter	3-3
How to replace filter box	3-3
Replacement cycle	3-3
Tips	3-3
Filter usage reset procedure	3-4

In order to avoid machine downtime, it is important to perform regular maintenance.



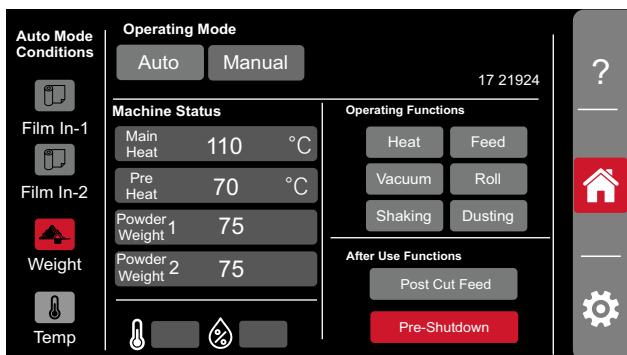
Due to the large amount of glycerin in the composition of DTFwhite ink, it is normal for oil and water condensation to appear on the metal surface after the machine is used. In order to prevent condensation from accumulating on the machine during long-term use, please follow the maintenance instructions below.

Before use

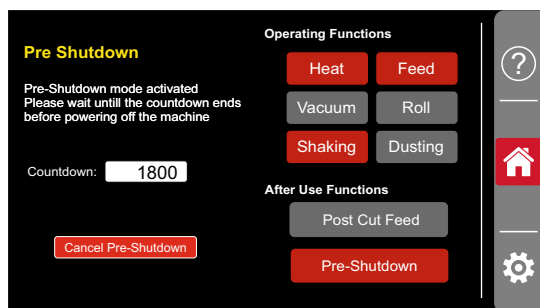


It is recommended to turn on the Heat function for 15 min before starting each work session to enhance the curing effectiveness.

After use



After every 8 hours of production please ensure a Pre-Shutdown cycle is performed.



Once Pre-Shutdown mode is activated this turns on 'Heat' 'Feed' and shaking is activated for 30 minutes and the machine will heat up as well as extraction fans will remain on to ensure all excess vapours are extracted.

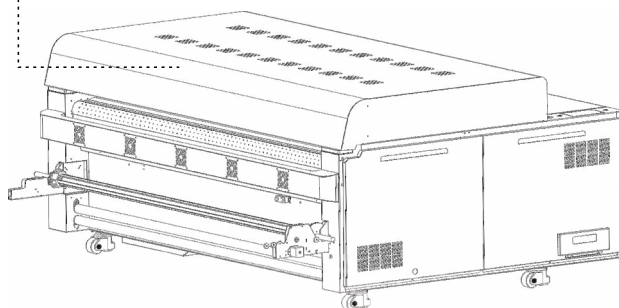
Notice!

If pre shutdown function is completed. Please turn off the machine power and drain the oil as required. If you want to continue the production please return to the main surface. You may click anywhere to return.

After 30 minutes of Pre-shutdown please open the oil drain tap and allow waste oil to drain out. Use the optional oil drainage tray which is included.



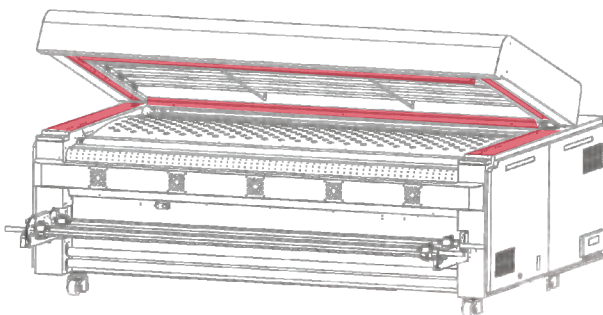
Lift up



* Before opening make sure the powder shield is down



Open the machine oven and wipe off the oil inside the oil guide groove, and all internal surfaces.



Due to the build up of glycerin/oil which comes from DTF ink it is **extremely important** that time is taken **each day** to thoroughly clean excess oil from all surfaces (including inside the lid/hood). The oil residue cannot be fully eradicated due to the oil particles being coming airborne, which forms condensation on various parts of the machine. Failure to clean the surfaces daily can **result in oil build up and leakages** from various parts of the system and can contribute **possibly faults**.



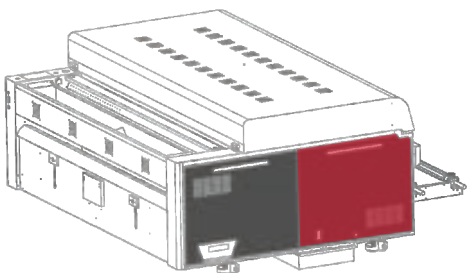
Replace the filter regularly

Replace the filter cartridge regularly according to the working condition, refer to the filter cartridge replacement guideline (as below):

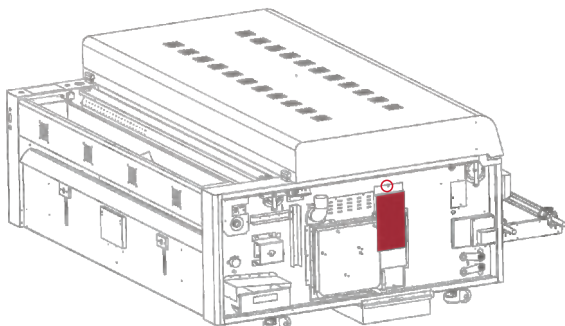
1. How to replace the filter box



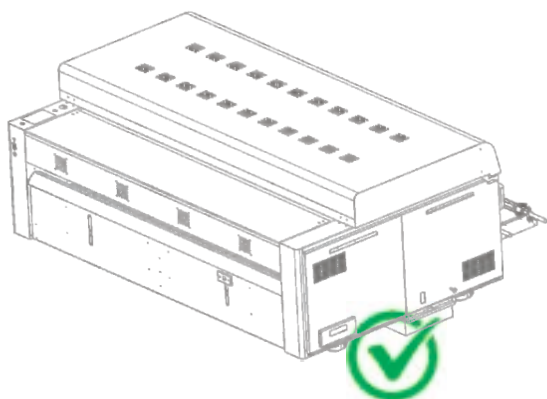
Open the smoke purifier.



Loosen the screws securing the filter box panel to reveal the filters.



Pull the old filters out and install the new filters (carbon at the bottom).



2. Replacement cycle

Medical Grade Carbon & Glass Fibre Filters

Use Status	Suggested Replacement Cycle
High Frequency use	1.5 Months
Low Frequency use	3 Months



If there is excess smoke / glycol buildup replace the filters immediately

Odour Removing Filter Cartridge

Use Status	Suggested Replacement Cycle
High Frequency use	3 Months
Low Frequency use	6 Months



If there is excess smoke / glycol buildup replace the filters immediately

This model benefits from a filter replacement reminder which is set to remind users following 400 hours of heat and feed are operating together.

The filters may need changing before 400 hours if use is high frequency.*

*The life span of the filters depends on actual usage conditions and may be affected by factors including, but not limited to the type of ink, Transfer film, hotmelt powder, as well as environmental temperature and humidity.

3. Tips



The filter element is a consumable item and needs to be replaced regularly.



The filter element replacement cycle is not the quality shelf life of the product.



Due to different use scenarios and frequency of use, the filter element replacement cycle varies. The specific use is based on the actual use.



Replace the filter element in a timely manner to ensure that the smoke filter reaches the best working state.

The importance of DTF Machine Maintenance and Filter Replacement

An Adkins DTF machine is not just designed to apply powder and cure the powder and ink on the film. It also must extract the by-product of the process (vapour) from the hood through the exhaust system and the medical grade filters.

The process of DTF innately creates a by-product of vapour, which can eventually condense into an oily liquid. This is from the glycerin in the white DTF ink which is required to ensure the ink is more viscous to avoid printheads from clogging. As this by-product is part of the DTF process, controlling this is the responsibility of both the shaker curing machine and the machine users.

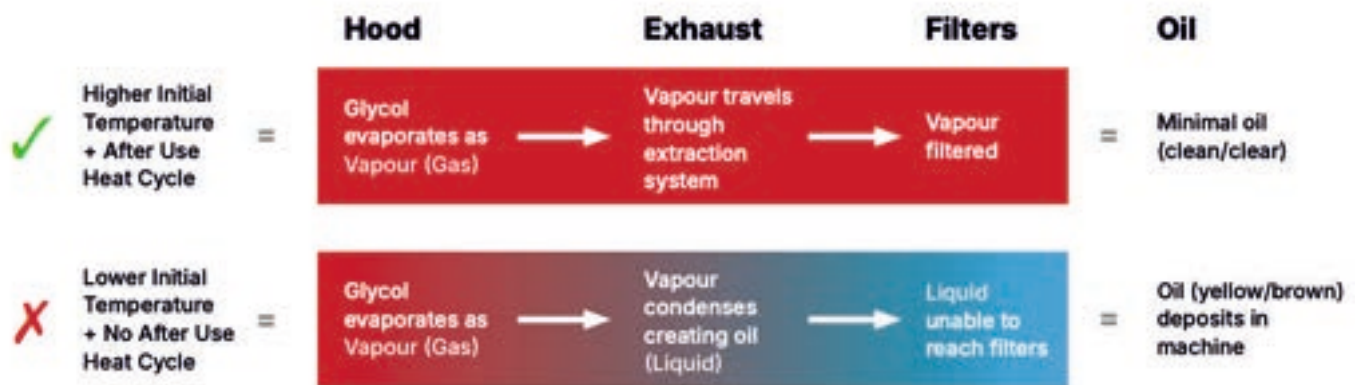
To effectively and efficiently do this, it's essential the machine is used and maintained correctly by following the DTF Curing Maintenance Guidelines.

Explanation:

It's important the vapour remains as a vapour (gas) as it flows through the extraction system, from the hood and through the exhaust and filters.

To do this, the temperature of the machine needs to be warm enough that at no point during the process the vapour cools enough to condense in an area that it shouldn't. If the vapour remains a gas it will pass through the system to the filters as intended.

If the machine and vapour cool it will condense into a liquid and not reach the filters, meaning oil deposits will sit in the machine. For example, the condensation point of steam is generally around 100 degrees therefore having the heat setting below at least 100 degrees will significantly increase the chance the vapour condenses into oil before reaching the filters.



Following production / use of an inline, it's essential a heat cycle is performed after a job is completed to aid the vapour through the system to the filters, rather allowing the machine to cool while the vapour is still inside as this will then create oil wherever the vapour finds cooler surfaces.

The filters of the machine are a consumable that need to be replaced because once they are full, the vapour cannot be filtered and therefore will remain in the machine. The vapour in the machine will condense into a liquid (oil) when the hot air in the machine cools down.

The machine is equipped with an oil collection chamber found beneath the filters to collect expected oil residue. This requires draining from the oil drainage tap which should be checked as part of the general machine maintenance and emptied regularly.

Filters should be replaced when one or more of the below happens first:

- Excess vapour or oil
- Drained oil becomes darker (not clear)
- 1.5–3 months depending on usage
- 400 hours of machine use

Summary:

The machine needs to be ran warm enough for the vapour to remain a gas through the extraction process, with a heat cycle (15-30mins) after use (8 hour period) to aid the removal of remaining oil/vapour.

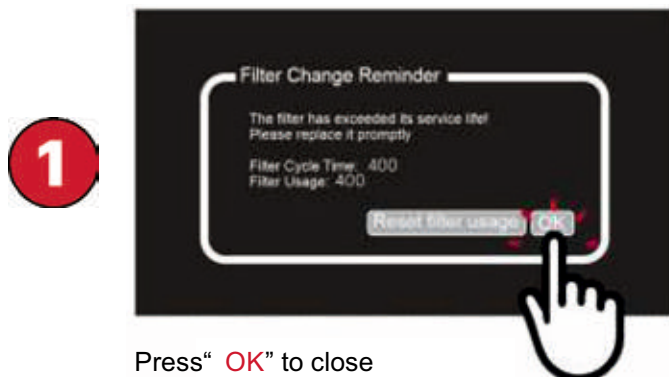
Changing filters, wiping excess oil and draining collected oil is an essential part of the maintenance for the DTF curing machines.

The machine maintenance will reduce machine downtime and increase the lifespan of your DTF curing unit.

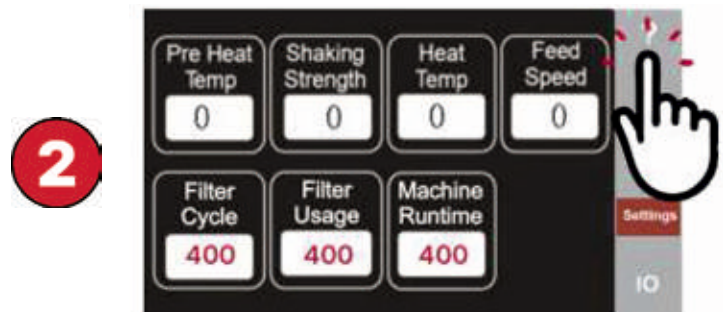
If experiencing excess vapour or oil then it's important to change the filters, or after 400 hours of use / 1.5-3 months depending on usage.

Filter Usage Reset Procedure

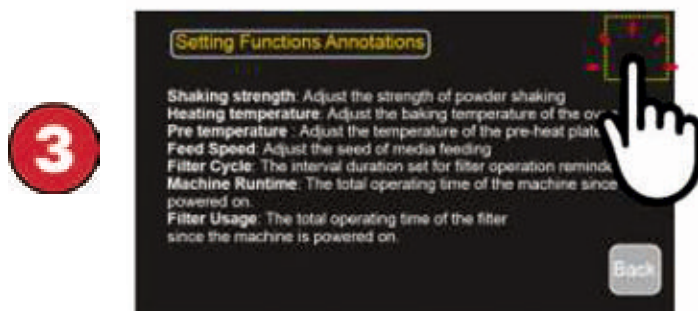
Once the Filter usage has reached the target filter cycle of 400 hours of operating use you will see a Filter change reminder pop up on the screen when the machine is turned on and a beeping will sound. To reset see below



Press "OK" to close the reminder



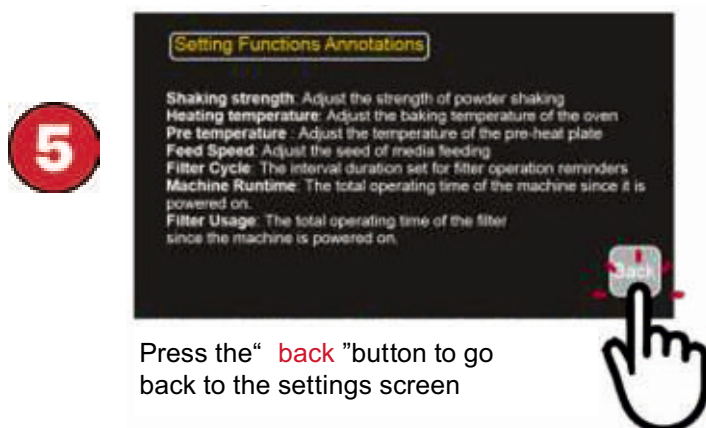
Once OK has been pressed you will be taken to this screen Press "?".



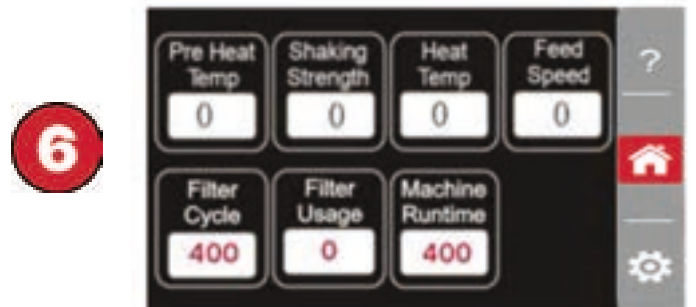
Next press into the top right hand corner to bring up the password screen



Enter Password 2234 ,Then Enter button



Press the "back" button to go back to the settings screen



The filter Usage has now been reset to "0" The beeping sound will still be continuing.



Turn the machine off by the powerswitch, wait 5 seconds and power the machine back on. The reset has now been completed.

Warranty and Declaration

About this chapter

This chapter is about the warranty and declaration of the machine

Chapter 4 - Warranty and Declaration

Warranty and Declaration	4-1
Design Change	4-2
Warranty	4-3
Declaration of Conformity	4-4,5
Installation Risk Assessment	4-6
Machine Risk Assessment	4-8
Parts Diagram	4-10

Design Change

With the policy of constant improvement and / or modification to meet changing conditions, the right is reserved to change the design and / or specifications at any time without prior notification, and therefore specifications may vary and not be in accordance with this manual.

Guarantee (Limited Warranty)

Adkins warrants that the machine is free from defects in material and workmanship for a period of 12 months from the date of supply. The machine comes with a one-year warranty on parts.

This warranty covers all parts to repair the defects, except when damage results from misuse or abuse, accident, alteration or negligence or when a machine has been improperly installed.

If a machine covered by warranty should need to be returned to the factory for examination or repair, where an on-site component replacement is not possible, Adkins will make every effort to repair the customer's machine. The warranty will only be effective when Adkins authorises the original purchaser to return the machine to the factory and only when the product examination has proven the machine to be defective.

Should any part of the machine be found defective in materials or workmanship, it will be replaced by the supplying dealer, distributor or the manufacturer depending on geographical agreements, provided that the machine has been installed, maintained as per the guidance, operated in the correct manner and not subjected to misuse. Whilst in warranty, any non-consumable replacement parts will be provided free of charge by Adkins to the supplying dealer/distributor. Additional costs associated with, but not limited to, labour and travel will be at the discretion of the supplying dealer and/or distributor. In exceptional circumstances, if Adkins authorise a replacement machine, the warranty of the replacement machine shall expire on the anniversary date of the original machine's invoice to the end user or the installation date logged via the 'warranty activation form' by the Adkins dealer.

For the warranty to be effective, no return of machine or parts may be made without prior authorisation. This will exclude any travelling and/or carriage costs which will be charged at our discretion.

Replacements parts purchased, when outside of the original 12 months machine warranty, receive a 6-month parts warranty, provided that the part and machine have been installed, maintained as per the guidance, operated in the correct manner and not subjected to misuse.

This is the sole warranty given by the company; there are no warranties, which extend beyond the description on the face hereof. The seller disclaims any implied warranty of merchantability and/or any implied warranty of fitness for a particular purpose; the buyer agrees that the goods are sold "as is".

The sole purpose of the machine is to be used for direct-to-film (DTF). Outside of this use Adkins does not warrant the machine. The entire risk of use, operation and/or maintenance of the machine lies with the end user. No claim of any kind shall be greater than the sale price of the product or part to which the claim is made.

In no event will Adkins be liable for any injury, loss or damage, including loss of profits, destruction of goods or any special, incidental, consequential or indirect damages arising from the use of the machine or accompanying materials. This limitation will apply even if Adkins or its authorised dealer/distributor had been advised of the possibility of such damage.

CHARTERHOUSE HOLDINGS PLC
EU DECLARATION OF CONFORMITY

Application of Council Directives:	European Low Voltage Directive (LVD) European Machinery Directive (MD), Electro Magnetic Conformity (EMC)
Standards to which Conformity is Declared:	(LVD): EN 60204-1:2018 (MD): EN ISO 12100:2010 2006/42/EC Annex1 (EMC): EN 61000-6-2:2019
Manufacturer's Name:	Charterhouse Holdings Plc
Manufacturer's Address:	Oakridge Park, Trent Lane, Castle Donington, Derby, DE74 2PY United Kingdom.
Type of Equipment:	DTF Shaker Cure Unit
Standards Compliance:	
Model Number:	DTF Inline Max 1600

I, the undersigned, hereby declare that the equipment specified above conforms to the above directives and standards.

Place: Castle Donington, United Kingdom

Signature:



Full Name: Miles Carter

Position: Chief Executive

European Union Authorized Representative

Authorised Rep Compliance Ltd
Ground Floor
71 Lower Baggot Street
Dublin
D02 P593
Ireland
www.arccompliance.com

INSTALLATION RISK ASSESSMENT

Area / Task for assessment: Installation of Adkins Inline	DTF powder shaker with built in extraction
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The guidance contained within this prepared assessment form will provide recommendations and indicate what action should be taken where hazards are identified.

Hazards Identified	Persons at risk and how	Manufacturer r recommended control measures	Current risk			Recommended action necessary
			L	C	S	
Trip and slip	Persons installing machine Could slip, trip, fall when moving/lifting goods	Engineer visually checks environment and has adequate PPE.	1	3	3	Persons receive sufficient training Keep environment around the machine tidy
Manual handling	Persons installing machine Improper lifting techniques.	Training in manual handling techniques. Weights and dimensions listed within product manual. Recommended personnel required to lift details within user manual. Installation ramps included for ease of removing from pallet.	1	3	3	Person s be trained in manual handling techniques.
Electric shock	Persons installing machine Shock from electrical circuit boards.	Isolate power supply if needed. Caution signage on display. Screw locked cover for electrics.	1	5	5	Persons be trained sufficiently in electrical safety and locations of highest risk of electric shock.
Exposure to harmful isocyanates	Persons installing machine use of DTF powder risks exposure to isocyanates.	Training in the risk of exposure to isocyanates and sufficient product knowledge. PPE worn when necessary. Relevant H&S signage in place and/or explained in operator's manual.	2	4	8	Ensure that there is appropriate PPE at all times and that staff adhere to any applicable procedures.
Burns	Persons installing machine burns from heat element and exposure.	Caution signage on display and explained in operator's manual. Protection from heat elements in place.	2	4	8	Ensure provision of a burns kit.
Moving parts	Persons installing machine risk of injury or loss of limbs from moving parts.	Majority of moving parts are covered, meaning exposure is minimised.	1	4	4	Persons be trained sufficiently and adhere to any applicable procedures.

Risk Level	LCS Risk Score	Average Risk Score	5.17
LOW	< 8.00		
MEDIUM	8.00-14.99		
HIGH	> 14.99		
		Overall Risk Rating	LOW

‘CURRENT RISK’ LCS SCORE SCHEME

Overall Risk	Likelihood					
Consequence	Score	1 (Improbable)	2 (Unlikely)	3 (Possible)	4 (Likely)	5 (Almost Certain)
	1 (Negligible)	LOW	LOW	LOW	LOW	LOW
	2 (Minor)	LOW	LOW	LOW	MEDIUM	MEDIUM
	3 (Moderate)	LOW	LOW	MEDIUM	MEDIUM	HIGH
	4 (Major)	LOW	MEDIUM	MEDIUM	HIGH	HIGH
	5 (Catastrophic)	LOW	MEDIUM	HIGH	HIGH	HIGH

The overall score (Score (S)) is determined by multiplying the Likelihood (L) and the Consequence (C) for each Hazard Identified and taking the average score. A Score (S) below 8.00 is considered a low overall risk; a Score (S) between 8.00-14.99 is considered a medium overall risk; and a Score (S) above 14.99 is considered a high overall risk.

‘Current risk’ scores and the ‘Current risk’ LSC Score Scheme are only suggested by Adkins* and encourage all users to perform their own risk assessment based on their specific environment and circumstances.

Adkins* does not take responsibility for any action (or non action) taken as a result of adhering or not adhering to recommendations listed in the ‘Recommended further action’ section.

Adkins* does not take responsibility for any consequence arising from actions in the ‘Recommended further action’ section, including death or injury through negligence.

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MACHINE USAGE RISK ASSESSMENT

Machine assessed: Adkins Inline	DTF powder shaker-with builtin extraction
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The guidance contained within this prepared assessment form will provide recommendations and indicate what action should be taken where hazards are identified.

Hazards Identified	Persons at risk and how	Manufacturer-implemented control measures	Current risk			Recommended further action
			L	C	S	
Electric shock	Persons working with machine – Shock from electrical circuit boards.	Emergency Stop Button. Screw locked cover for electrics. Caution signage on display.	1	5	5	Users be trained sufficiently in electrical safety and locations of highest risk of electric shock.
Manual handling	Persons working with machine – Improper lifting techniques.	Lockable wheels fitted to aid with movement of machine. Installation ramps included for ease of removing from pallet.	1	3	3	Users be trained in manual handling techniques.
Exposure to harmful isocyanates	Persons working with machine – use of DTF powder risks exposure to isocyanates.	Built-in extraction system for filtration of isocyanates. Cover placed over the powder trough. Outlined the risk of exposure to isocyanates. Relevant H&S signage in place and explained in operator's manual.	2	4	8	Ensure that there is appropriate PPE at all times. Users be trained sufficiently and adhere to any applicable procedures.
Burns	Persons working with machine – burns from heat element and exposure.	Caution signage on display and explained in operator's manual. Protection from heat elements in place.	2	4	8	Ensure provision of a burns kit.
Moving parts	Persons working with machine – risk of injury or loss of limbs from moving parts.	Majority of moving parts are covered, meaning exposure is minimised. Caution signage on display and explained in operator's manual.	1	4	4	Users be trained sufficiently and adhere to any applicable procedures.

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Risk Level	LCS Risk Score	Average Risk Score
LOW	< 8.00	5.60
MEDIUM	8.00-14.99	Overall Risk Rating LOW
HIGH	> 14.99	

‘CURRENT RISK’ LCS SCORE SCHEME

Overall Risk		Likelihood (L)				
Consequence (C)	Score (S)	1 (Improbable)	2 (Unlikely)	3 (Possible)	4 (Likely)	5 (Almost Certain)
	1 (Negligible)	LOW	LOW	LOW	LOW	LOW
	2 (Minor)	LOW	LOW	LOW	MEDIUM	MEDIUM
	3 (Moderate)	LOW	LOW	MEDIUM	MEDIUM	HIGH
	4 (Major)	LOW	MEDIUM	MEDIUM	HIGH	HIGH
	5 (Catastrophic)	LOW	MEDIUM	HIGH	HIGH	HIGH

The overall score (Score (S)) is determined by multiplying the Likelihood (L) and the Consequence (C) for each Hazard Identified and taking the average score. An Score (S) below 8.00 is considered a low overall risk; a Score (S) between 8.00-14.99 is considered a medium overall risk; and a Score (S) above 14.99 is considered a high overall risk.

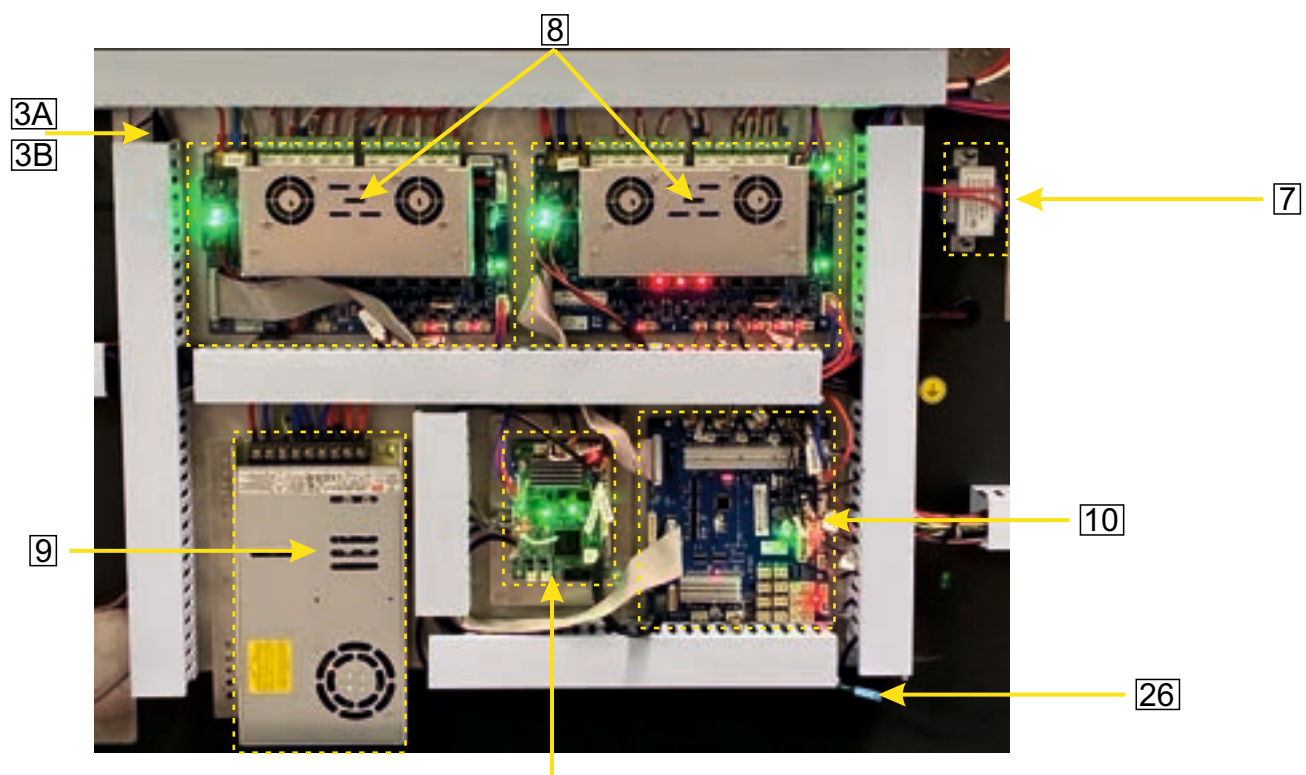
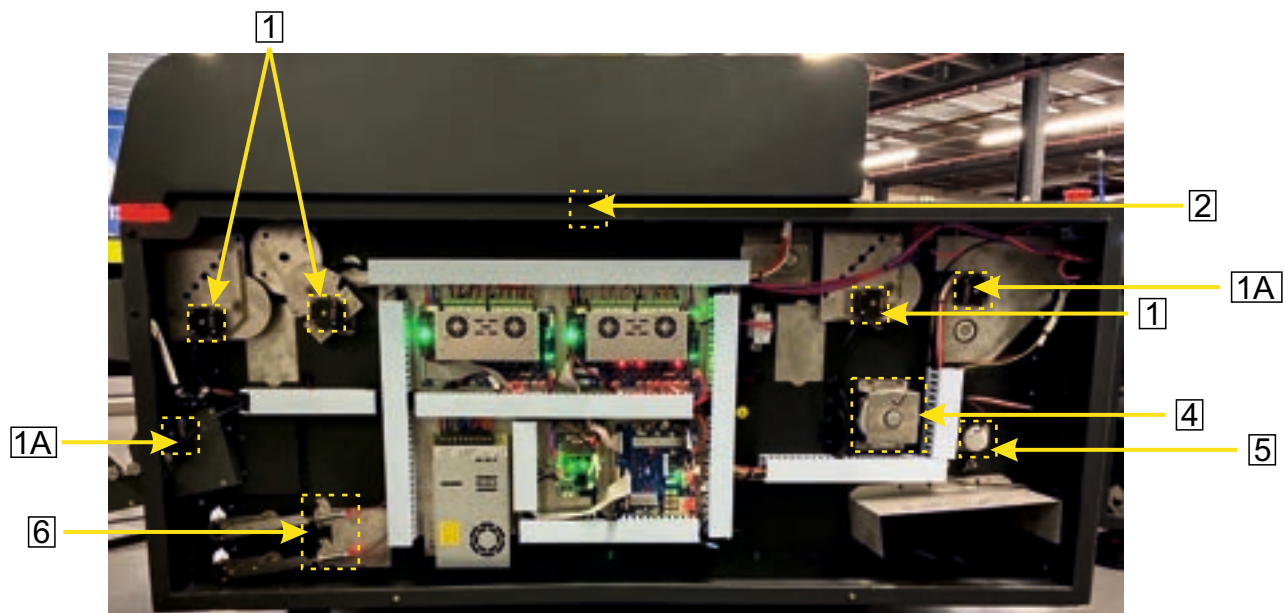
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Inline Max 1600 Parts Diagram



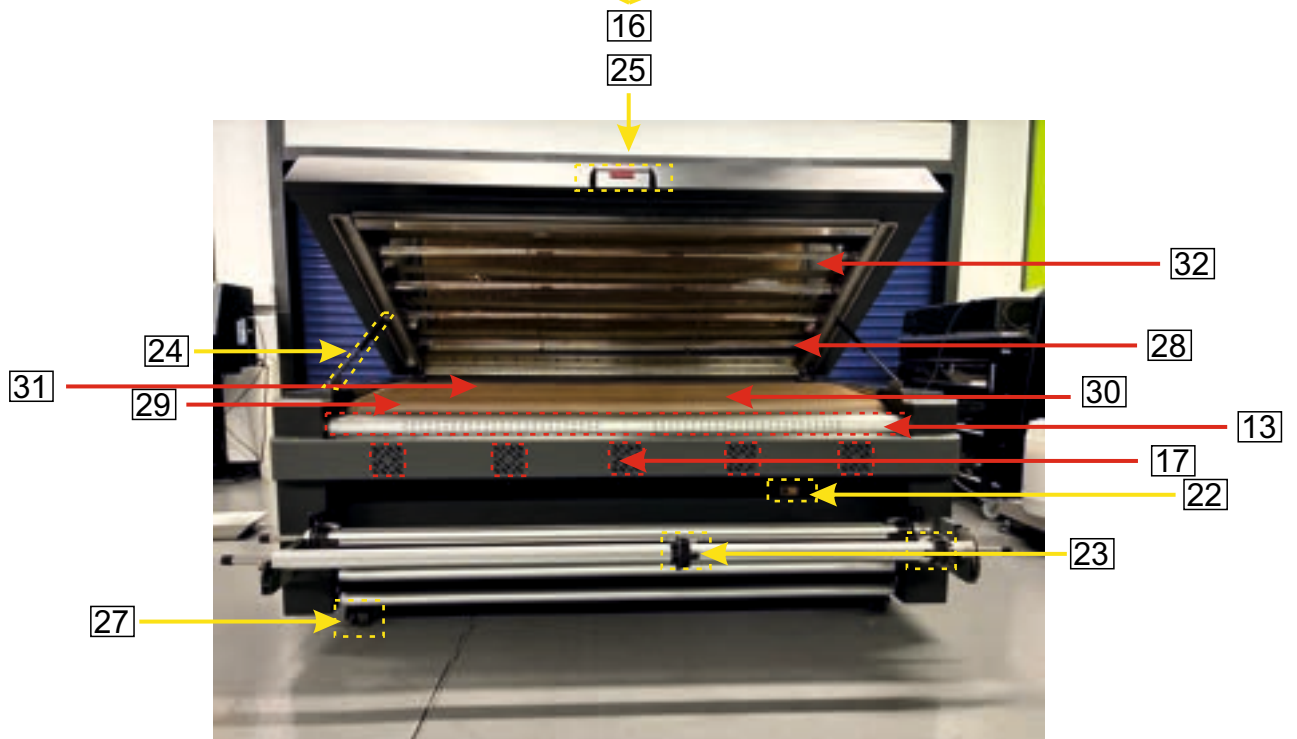
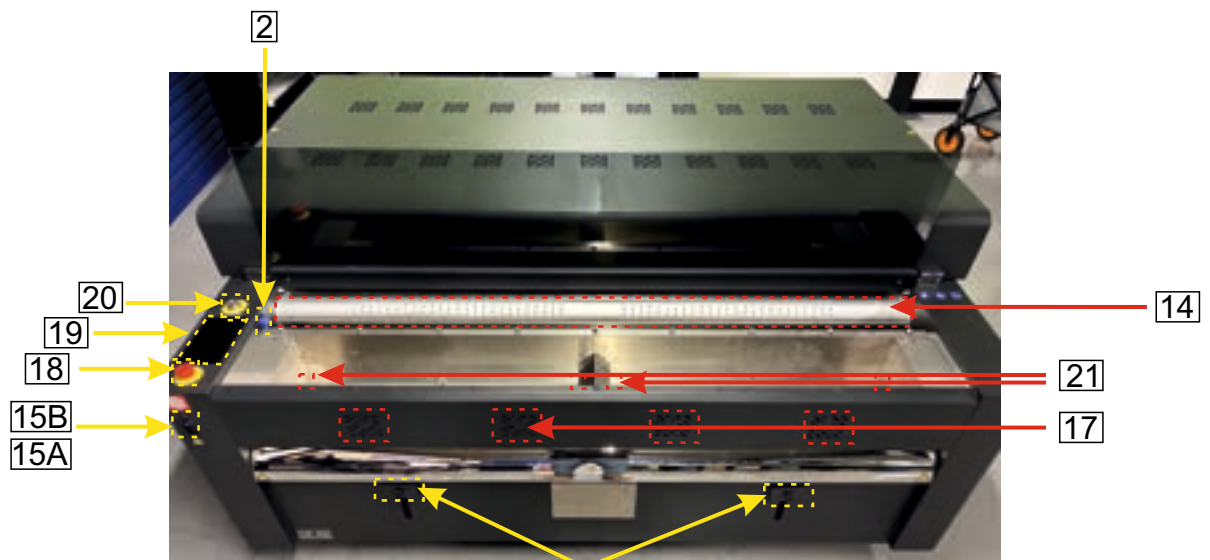
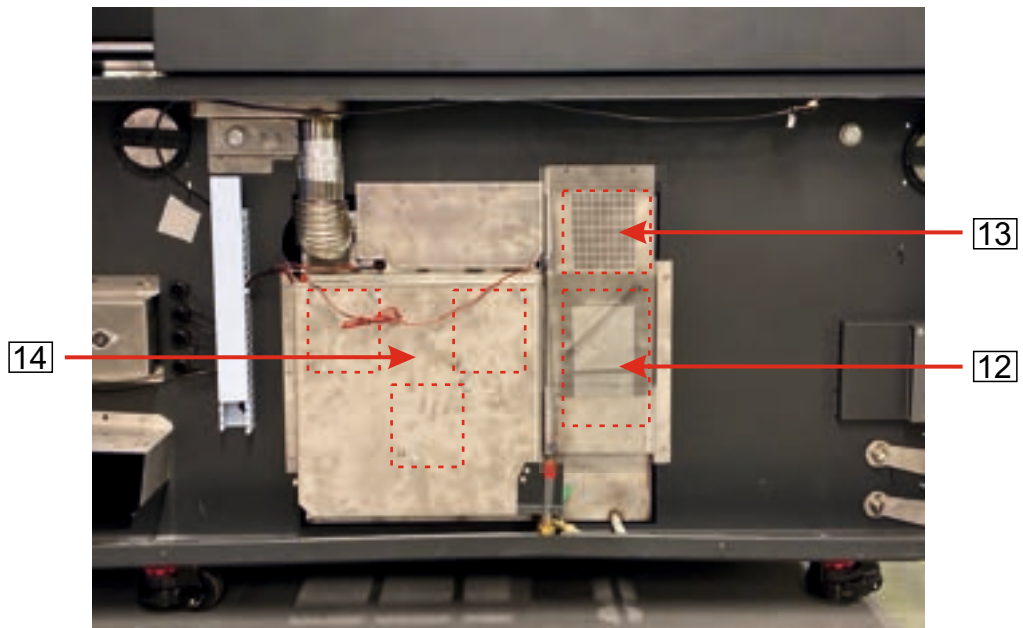


Diagram Number	Adkins Part Name	Adkins Code
1	Adkins DTF Motor - Take Up & Stiring/Recirculation - 800-600-TU	XP1350WM
1A	Adkins DTF Vacuum Roller Motor - (COM600-SUCT)	XP1356VW
2	Adkins DTF Safety Switch - EE-40-001-A	XP1354SS
3A	Adkins DTF Max 1600 Temperature Detection Line 200cm	ADK251TD200
3B	Adkins DTF Max 1600 Temperature Detection Line 270cm	ADK251TD270
4	Adkins DTF Powder Shaking Motor - WZDK13-38G-3	XP1350PSM
5	Adkins DTF Shaking Sensor - EE 24 007-B-1	XP1350SS
6	Adkins DTF Max 1600 Tension Bar Sensor	ADK251TBS
7	Adkins DTF Isolation Transformer - AF 21-09 009B	XP1350IT
8	Adkins DTF Sixteen Thyristor Board - EE-15-049-C-N	XP1350STB
9	Adkins DTF 24V (18.8a) Power Supply	ADK251PS18A
10	Adkins DTF 900 Main Board inc C600(ADKX..)-EE-15-072-A	XP1358CB
11	Adkins DTF Light Board	ADK251LB
12	Adkins DTF Medical Grade Carbon & Glass Fibre Filters(2 Pcs)	XP1350SEF
13	Adkins DTF Odour Fillter	ADK251OF
14	Adkins DTF Paper Suction Fan (1.2a) - EE-25-009-A	XP1351PSF12
15A	Adkins DTF Fuse Holder - EE-51-016-B	XP1354FH
15B	Adkins DTF 20 Amp Fuse	ADK251F
16	Adkins DTF Film Sensor - 7103-01-021B	XP1350S
17	Adkins DTF Axial Fan (0.2a) - 7101-11-09-003	XP1350AF
18	Adkins DTF Emergency Stop Button - AF-17-09-339A	XP1350ESB
19	Adkins DTF Max 1600 Touch Screen	ADK251TS
20	Adkins DTF Main Power Switch	ADK251MPS
21	Adkins DTF Powder Shortage Sensor - EE-23-010-A	XP1350PSS
22	Adkins DTF Rear Film Sensor - XR-01-094	XP1356RFS
23	Adkins DTF Single Media Flange - 0618B-E-01-02-29-3	XP1354MF
24	Adkins DTF Max 1600 Gas Spring	ADK251GS
25	Adkins DTF Hood Handle - AF-16-09-761A	XP1350H
26	Adkins DTF Temp & Humidity Sensor	ADK251THS
27	Adkins DTF Wheels (Black)	ADK251WB
28	Adkins DTF Carbon Element (164cm)	ADK251CE164
29	Adkins DTF Heat Element (19.8cm)	ADK251HE198
30	Adkins DTF Heat Element (110cm)	ADK251HE110
31	Adkins DTF Carbon Element (80cm)	ADK251CE80