

AIR SWINGER OPERATOR'S MANUAL



STAHL'S
Hotronix®

a GroupeSTAHL company

Safety Instructions

When using your heat press,
basic precautions should always be followed,
including the following:

1. Read all instructions.
2. Use heat press only for its intended use.
3. To reduce the risk of electric shock, do not immerse the heat press in water or other liquids.
4. Never pull cord to disconnect from outlet, instead grasp plug and pull to disconnect.
5. Do not allow cord to touch hot surfaces, allow heat press to cool completely before storing.
6. Do not operate heat press with a damaged cord or if the equipment has been dropped or damaged. To reduce the risk of electric shock, do not disassemble or attempt to repair the heat press. Take it to a qualified service person for examination and repair. Incorrect assembly or repair could increase the risk of fire, electric shock, or injury to persons when the equipment is used.
7. This appliance is not intended for use by persons (including children) with reduced physical, sensory or mental capabilities, or lack of experience and knowledge, unless they have been given supervision or instruction concerning use of the appliance by a person responsible for their safety.
8. Close supervision is necessary for any heat press being used by or near children. Do not leave equipment unattended while connected.
9. Burns can occur when touching hot metal parts.
10. To reduce the likelihood of circuit overload, do not operate other high voltage equipment on the same circuit.
11. If an extension cord is necessary, then a 20 amperage rated cord should be used. Cords rated for less amperage may overheat. Care should be taken to arrange the cord so that it cannot be pulled or tripped over.

SAVE THESE INSTRUCTIONS

Product Warranty Registration

Log onto **www.Hotronix.com/registration**
You must provide the Hotronix® heat press
serial number and model information.

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HOTRONIX® AIR SWINGER

Important Safety Notice

The Hotronix® Air Swinger is equipped with a lighted Quick Release Button. When pressed, this button activates a quick release of the heat platen when in the print position and automatically returns the platen to the "UP" position.

Once activated, the button can be reset by pushing it in. The press will then return to the previous mode (Normal Operation Mode).

Light On = Normal Operation Mode
Light Off = Quick Release Mode





HOTRONIX® AIR SWINGER

Operating Instructions

HOTRONIX® AIR SWINGER

The Hotronix® Air Swinger Operating Instructions are designed with the user in mind. Carefully read and follow the step-by-step instructions for best results.



- To avoid burns, do not touch the heated platen during use.
- Keep hands clear of the upper platen of the press during platen lock down as the pressure may cause injury.
- Press should be placed on a sturdy, suitable stand at least 36"L x 24"W x 29"H.
- Work area must be kept clean, tidy and free of obstructions.
- Power supply cord must be disconnected before cleaning or servicing press.

Connecting the System

1. CONNECT THE POWER CORD

1.1 Connect the power cord into a properly grounded electrical outlet with a sufficient amperage rating.

■ VOLTAGE

120 Volt - The Hotronix® Air Swinger requires a full 20 amp grounded circuit for 120 volt operation.

220 Volt - The Hotronix® Air Swinger requires a full 10 amp grounded circuit for 220 volt operation.

- **EXTENSION CORDS** If used, should be as short as possible and not less than 12 gauge. Heavy duty cords are recommended.

- **CIRCUITS** that have less than 15 amps or that have other high demand equipment or appliances (especially more than one heat seal machine) plugged in, should not be used.

NOTE: If the supply cord is damaged, it must be replaced by the manufacturer, its service agent or a similarly qualified person in order to avoid hazard. Use SJT type rated 300 V cord for replacement.

CAUTION: Failure to follow these instructions will cause:

1. Erratic controller functions.
2. Inaccurate displays and slow heat-up.
3. The circuit breaker to disengage.

2. CONNECT AIRLINE

2.1 Connect the air line from your Hotronix® Air Swinger to the standard port on your air compressor.

- The Air Swinger requires 1CFM of air at 90 PSI to print continuously. A 1/2 hp compressor with a 1 gallon tank or larger is recommended. The motor should be rated for continuous operation.

Turning the System On

3. SWITCH THE SYSTEM ON

- See the diagram below for switch placement.
(The Power ON/OFF Switch is located on the top of the control housing).

3.1 Flip the Switch to the ON position. The machine will display “HELLO” for 3 seconds.

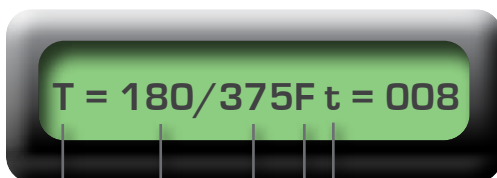


- The Date, Day, and Time message will automatically appear.



Time
Day
Date (Month/Day)

- The Temperature message will automatically appear.



t = Actual dwell time in seconds
F = Fahrenheit
C = Centigrade (Refer to page 10)
Target Temperature
Actual Platen Temperature
T = Temperature



Power ON/OFF Switch



NOTE: 180 F (82.2C) is the lowest number the temperature sensor will read. Once the actual platen temperature reaches a temperature of 180 F (82.2C) degrees, the display will then increase as the actual temperature rises. Now the Hotronix® press will automatically recall the previous settings at the time the machine was last turned off.

Adjusting the Pressure

4. ADJUST THE PRESSURE

- 4.1 While the platen is heating, Adjust the Pressure by turning the Pressure Adjustment Knob clockwise to increase the Pressure and counter clockwise to decrease the Pressure.

NOTE: The machine may not operate properly at pressure settings below 20 PSI.

- Refer to the Pressure Gauge for the actual pressure setting. (see diagram to the right).

IMPORTANT: The display on the Pressure Gauge will follow the actual pressure when increasing the pressure. When decreasing the pressure, adjust below the target pressure and turn back up. Failure to follow this procedure will result in poor print quality.



REF PRESSURE = 00

- 4.2 Optional: If you desire to store a Reference Pressure, press the Pressure Key. (Press for two seconds)

- 4.3 Press the Pressure Key again. (Press for two seconds)

REF PRESSURE = C 00

- 4.4 The "C" signals that a pressure may be entered. Enter your reference pressure from 01 to 99 PSI. Press the "E" Enter Key when completed. (Press for two seconds)



30 - 45 PSI = Light Pressure
45 - 60 PSI = Medium Pressure
60 - 90 PSI = Heavy Pressure

NOTE: Press the Pressure Key once to review Reference Pressure. (Pressure will be displayed and automatically return to the "Ready To Print Mode.") Or press the Pressure Key twice to enter a Reference Pressure.

- 4.5 Press the "E" Key to exit the Pressure Mode and to return to the Print Mode.



WARNING: Structural damage caused by excessive pressure is not covered under the limited warranty!

Adjusting Dual Time

5. ADJUST DUAL TIME

- Dual Time will allow you to enter two times which will alternate between print cycles.

SET TIME: 008

- 5.1 Press the Time Key.
(Hold for two seconds)



- 5.2 Key in desired time. To enter time, key in 3 digits within a range of 001 to 999 seconds (i.e. 008 seconds). To accept time without changing it, press the "E" Key and begin entering second time.

NOTE: The press will not accept times below 001 or above 999 seconds. If you mistakenly attempt to key in a time beyond the allowable range, the press will beep to alert you of your error.

- 5.3 Press "E" Enter Key to enter the time (press for 2 seconds).
Your time has now been programmed and will appear in the display.

SET TIME: 2 010

- The Air Swinger will automatically return to the "READY TO PRINT" cycle.

REMEMBER: If a beep is heard at anytime during programming, you have made an error. Please re-read the instructions and try again.

- 5.4 Key in second desired time (i.e. 010 seconds)
- 5.5 To accept time without changing it, Press the "E" Key. The Machine will turn to normal operating mode.
- 5.6 To enter time, key in 3 digits within a range of 001 to 999 seconds.

T = 360/360 t = 010

- 5.7 Press "E" Enter Key to enter the second time (press for 2 seconds).
The second time has now been programmed.



NOTE: Your Hotronix® Air Swinger will automatically return to normal operating mode.

Adjusting the Temperature

6. ADJUST THE TEMPERATURE

6.1 First, locate and press the Temperature Key on the Control Panel.
(Press for 2 seconds)

- The displayed message will illuminate in the LCD display indicating you are in the Adjust Temperature Mode.



6.2 Key in desired temperature (i.e. 330°).

6.3 To enter a temperature in fahrenheit, key in 3 numbers.

6.4 To enter a temperature in centigrade, key in 4 numbers.

NOTE: The press will not accept temperatures below 205° F (96° C) or above 430° F (221.6° C). If you mistakenly attempt to key in a temperature beyond the allowable range, the press will beep to alert you of your error.

6.5 Press "E" Enter Key to enter the temperature.
(Press for 2 seconds)

- Your temperature has now been programmed and the heat platen will begin to heat or cool to obtain the new temperature.

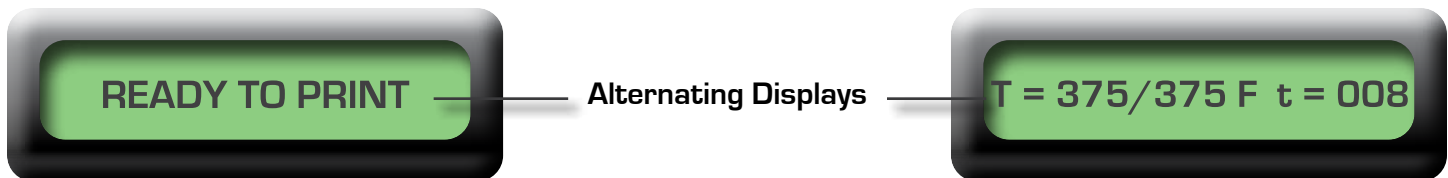


REMEMBER: If a beep is heard at any time during programming, you have made an error. Please re-read the instructions and try again.

Pressing

7. PREPARE TO PRINT

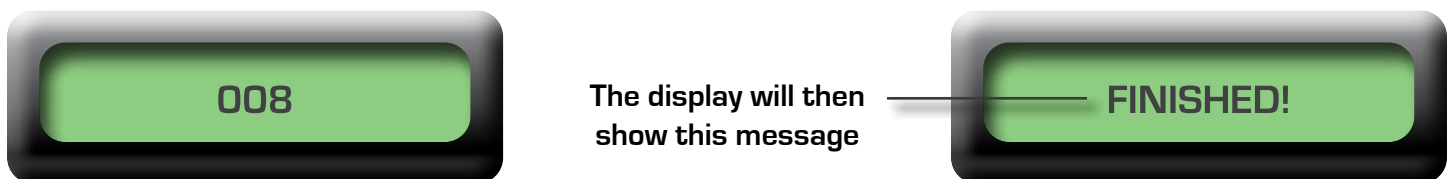
- When the targeted press temperature is reached, the display will prompt you with the message “READY TO PRINT”. This display will flash alternately with the “Temperature/Time” display.



7.1 Position garment and application. Gently swing the top platen in a smooth continuous motion, until it lines up with the lower platen. With both hands, press the Print Buttons located on the side of the press. The heat platen will lower to the print position and remain lowered for the number of seconds indicated by the timer.

CAUTION: When the print cycle is complete, the heat platen will return to the UP position and audibly signal.

7.2 Gently swing the top platen to the side and proceed according to the application's instructions.



Example: 005, 004, 003, 002, 001

8. OPTIONAL GARMENT PRE-PRESS TACK MODE



8.1 Position the garment and press the Tack Button located on top of the Control Housing.

8.2 Gently swing the top platen in a smooth continuous motion until it lines up with the lower platen. With both hands, press the Print Buttons located on each side of the press. The top platen will lower to the print position and remain there until you release the buttons.

CAUTION: Once the Print Buttons are released, the top platen will return to the UP position.

8.3 To exit the Tack Mode simply press the Tack Button.



Setting the Date and Time

9. SWITCH THE SYSTEM ON

- 9.1 The Power ON/OFF Switch is located on the top of the control housing. Flip the switch to the ON position. The machine will display "HELLO" for 3 seconds.



- The Date, Day and Time message will automatically appear.



- 9.2 Immediately press the "E" Key while the Date, Day and Time message is being displayed.
(Press for 2 seconds)



This message will automatically appear

NOTE: If the Time and Temperature screen appears before a decision is made, turn the press off and begin with Step 9.1.



- 9.3 Press the "#" Key.
(Press for 2 seconds)



This message will automatically appear

- 9.4 Key in the two digits for the month (MOMO)
[01= January, 12=December]
- 9.5 Next, key in one digit for the day (DAY) [1= Monday, 7= Sunday]
- 9.6 Then, key in two digits for the date (DD) [01 - 31]
- When the final number is keyed in, the LCD screen will display this message:



NOTE: If too much time is taken, the controller will return to the original display and you will need to start the sequence again. Turn machine off and begin with Step 9.1.

- 9.7 Key in four digit hours (HH) and minutes (MM) using the 24-hour clock. Example: 08:00 = 8 am 16:49 = 4:49 pm. When the final number is keyed in, the LCD screen will display this message:



NOTE: If a blank screen appears, simply press the "C" Key followed by the "E" Key.

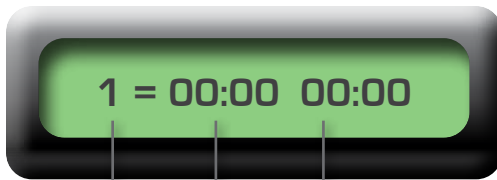
- 9.8 Press the "E" Key to store your new time and date and to return the press to the Print Mode or press the "C" Key to set the Automatic ON/OFF Function (Where time and date will automatically be stored).

NOTE: If the Automatic ON/OFF Function is not used, your Hotronix® press is equipped with an energy conserving feature which automatically shuts off the machine's heat at 12:00 AM in case the machine was left on. To override simply press the "#" Key.

Setting the Auto ON/OFF

10. PREPARE TO PRINT

- The Automatic ON/OFF feature allows you to make the most of every business day. By using the Automatic ON/OFF feature your equipment may be programmed to turn on, pre-heat the platen, and be ready to print when you arrive to work. Also, your equipment may be programmed to automatically turn itself off each evening at any time you desire.



1 = Monday

00:00 = OFF Time, Hour: Minute

00:00 = ON Time, Hour: Minute



- 10.1 Press the “#” Key.
 (Press for 2 seconds)
 The LCD screen will go blank as displayed.



- 10.2 Key in the desired settings. Using the 24-hour clock, key in Four digit hours (HH) and minutes (MM). This example shows the press automatically turning on at 8 AM and automatically turning off at 4PM.

NOTE: If you do not want to have your machine turn on and off for a particular day, then simply key in eight zeros for that day.



- 10.3 When the eighth number is keyed in, the next day will automatically be displayed.



Setting the Auto ON/OFF - Cont.

10.4 Repeat the previous step until all seven days are entered. This message will be displayed:



= Set Clock E = OK

NOTE: You must continue through all seven days in this manner for the Automatic ON/OFF Function to work.

10.5 If you make an error in entering the times, do not panic. Finish the settings for the remaining days, then return to the error by repeating the Time Set and Automatic ON/OFF programming steps. (Refer to Step 10.6)



- If you press the "E" Key during the programming of any of the seven days, the memory will be erased and the procedure for Time Set and Automatic ON/OFF will have to be repeated.



10.6 Press the "E" Key to exit the automatic ON/OFF programming mode and to save your settings into memory or press "#" to reset the time and then correct errors for the Automatic ON/OFF.



10.7 When resetting Automatic ON/OFF times, it is not necessary to reset each day. Pressing the "C" Key instead of the "#" Key will retain the displayed information and advance to the next day's settings.



10.8 Pressing the "#" Key will allow you to change the time for the desired day. (Refer to step 10.2).

- Now your Hotronix® press will automatically turn on each morning and turn off each evening at your designated time.

IMPORTANT: When using the Automatic ON/OFF function, you must leave the press plugged in and have the power switch in the "ON" position. The press will automatically heat itself to the previous day's final temperature setting.

10.9 If the press should turn itself off while you are working, simply press the "#" Key to override the Automatic ON/OFF function. Once your work is completed, press the "#" Key again to return your press to the Automatic ON/OFF Mode.

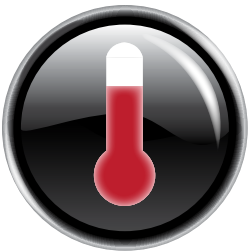
Storing Settings

11. STORE FREQUENTLY USED SETTINGS

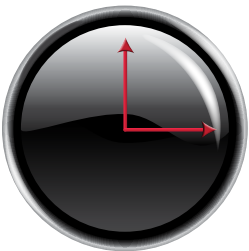
- Frequently used press settings (Time, Temperature, and Pressure), can be stored into the Hotronix® press memory and may be instantly recalled at any time. For your convenience, Hotronix® has already pre-set the ten most commonly used settings. The preset programs are as follows:

Seconds	A 330/165	B 350/180	C 375/190
4	0		
6		3	
8		4	
10	1	5	
15	2	6	9
20		7	
25		8	

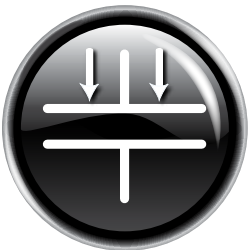
- The numbers 0 through 9 are pre-set programs. For example, Program Number 9 is the only pre-set program for 15 seconds at 375° F (190° C). A pre-set program sticker has been enclosed for your convenience. To store the setting you are currently using as a pre-set program, follow the instructions below.



11.1 Set the Temperature.
(Refer to page 10)



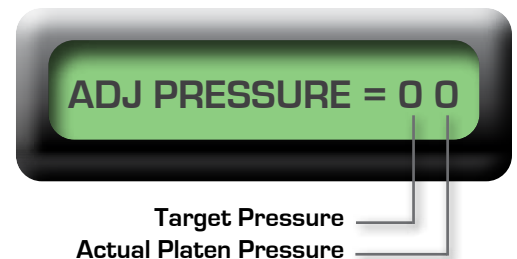
11.2 Set the Time.
(Refer to page 9)



11.3 Set the Pressure.
Press the "pressure" key.
(Refer to page 8)



This message will automatically appear



Storing Settings - cont.

IMPORTANT: The Actual Pressure must be re-checked each time a pressure change is desired.



- 11.4 Press the Temperature Key [Press for 2 seconds]. The "Ready to Print" message will stop blinking.

SET TEMP F 330

- 11.5 Press the Temperature Key a second time. [Press for 2 seconds]

- This signals the controller that you are about to store the settings that you are currently using. The controller is now ready to accept the next command.

SET TEMP F 33A



- 11.6 Press the "C" Key [Press for two seconds].



- 11.7 Press the Number Key [0-9] that you desire to assign your new stored program. Once the new program is stored into memory, your press will return to the "READY TO PRINT" mode.

REMEMBER: Keep a written record of your new preset programs as well as notes on the best temperature, time, and pressure for each garment type and applications.

Retrieving a Pre-Set Program

12. TO RETRIEVE A PRESET PROGRAM

12.1 Press the "C" Key. (Press for 2 seconds)

This turns the retrieve function on and the "READY TO PRINT" display will stop blinking.



NOTE: Make sure the display has stopped blinking before proceeding to the next step. Failure to do this will result in the controller advancing into an incorrect mode when you perform Step 2.



12.2 Press the "#" Key. (Press for 2 seconds)

This signals the controller that you are about to retrieve a pre-set program.



12.3 Press the particular Number Key (0-9) of the pre-set program which you desire to retrieve. Once you have pressed the recall number, your machine will return to the "READY TO PRINT" mode and will display the pre-set program you retrieved.



- The LCD Screen will display your Actual Temperature, new Target Temperature, and new Time as follows:



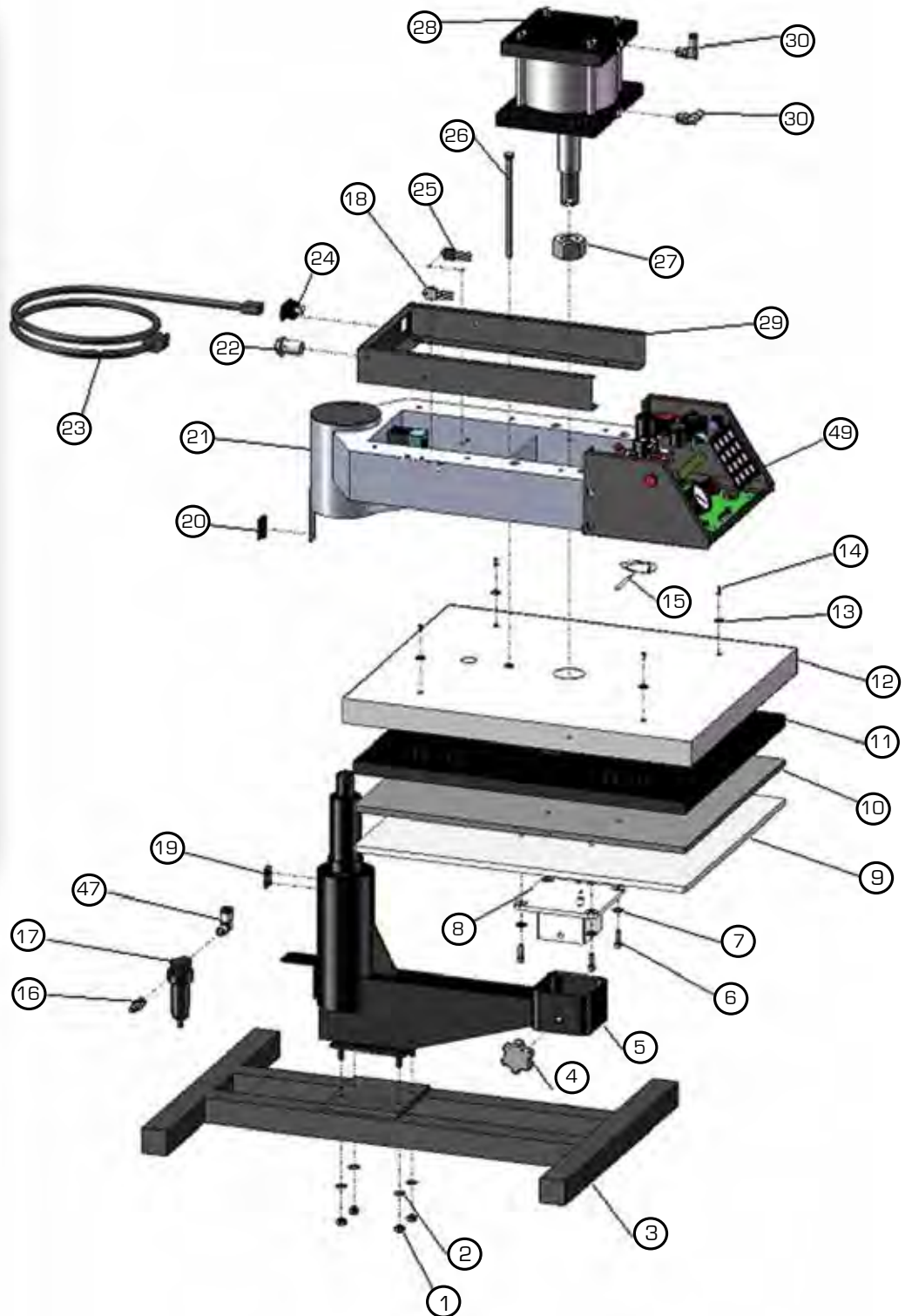
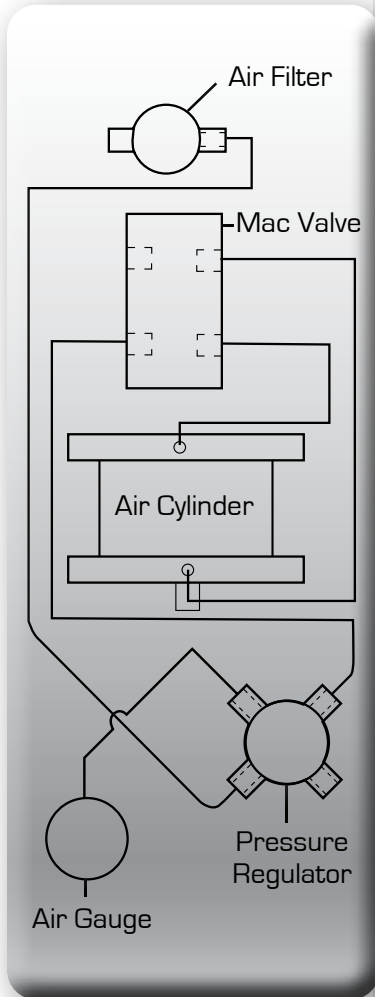
30 - 45 PSI = Light Pressure
45 - 60 PSI = Medium Pressure
60 - 90 PSI = Heavy Pressure

12.4 Check the pressure setting before you begin to print.
(Refer to page 8 for instructions on setting your pressure).

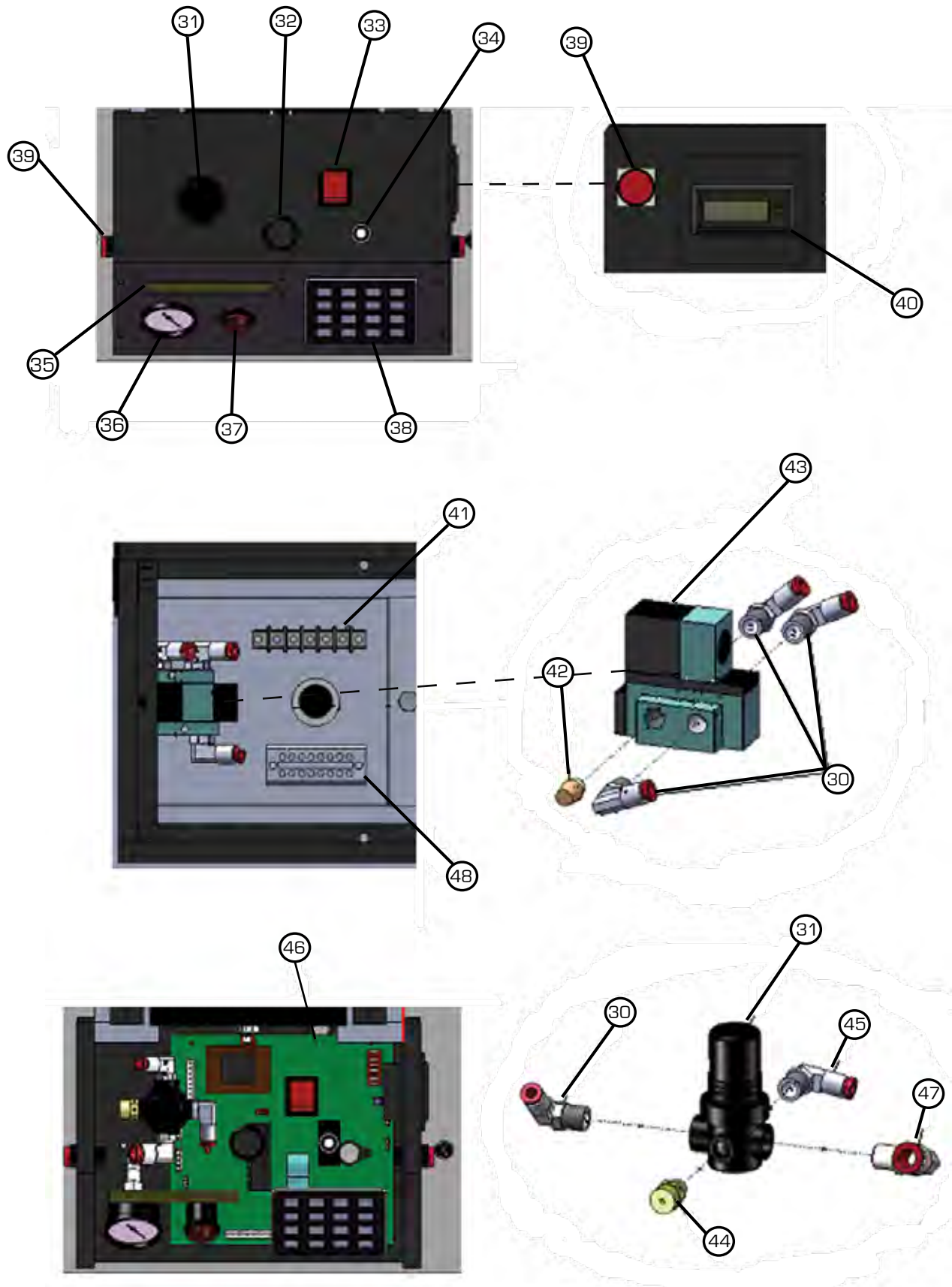
HOTRONIX® AIR SWINGER

Parts location Guide

Air Line Diagram



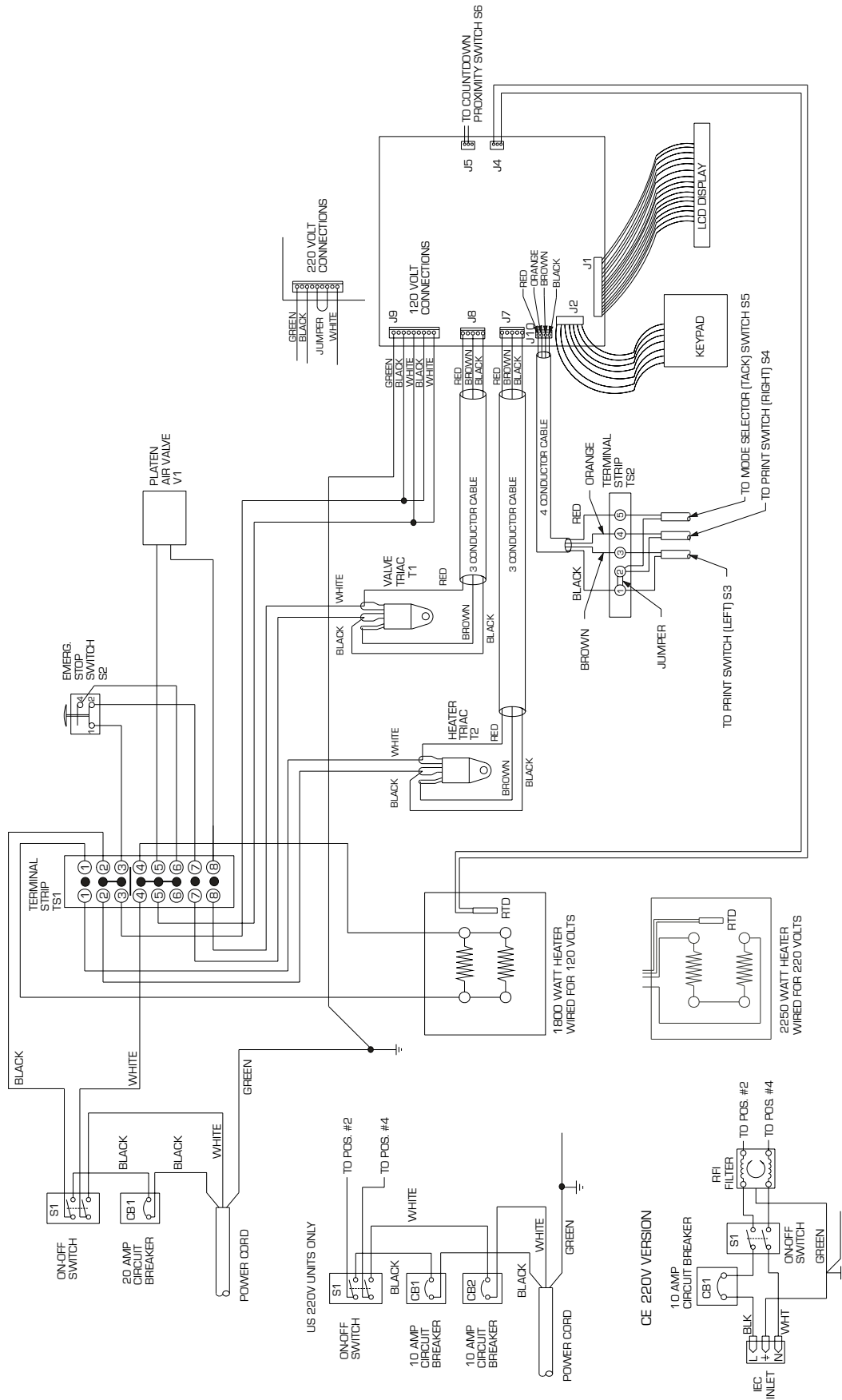
HOTRONIX® AIR SWINGER



HOTRONIX® AIRSWINGER

Replacement Parts List

Item #	Part Name	Part #	Qty.	
1	Nylon Lock Nuts 5/16-18	2-1006-20	4	Each
2	Lock Spring Washer 3/8"	2-1006-43	4	Each
3	Table Top Stand	Kit 3-6918	1	
4	Platen Thumb Screw	1-1016	2	Each
5	Base Weldment with Spindle	Kit 3-1225	1	
6	Hex Soc Screw 1/4-20x3/4"	3-1011-106	4	Each
7	Lock Spring Washer 1/4"	2-1006-44	4	Each
8	Post Casting	2-1033	1	
9	Lower Platen 16x20	2-1029	1	
10	Silicone Pad Grey 16x20	1-1011	1	
11	Heat Platen 16x20	2-1002-3	1	
12	Heat Platen Cover	4-1117	1	
13	Finish Washer	1-1063	4	Each
14	Cover Screw 10-24x1/2"	3-1011-217	4	Each
15	Probe	1-1272-1	1	
16	Quick Disconnect	1-1791	1	
17	Air Filter	1-1215	1	
18	Heater Triac	1-1059	1	
19	Proximity Switch	1-1211	1	
20	Magnet	1-1219	1	
21	Top Weldment	Kit 3-1257	1	
22	Bulkhead Fitting 3/8"	1-1892	1	
23	Power Cord	2-1013-1	1	
24	IEC Inlet	1-1759	1	
25	Air Triac	1-1059-1	2	Each
26	Safety Bolt 3/8-16x7"	3-1011-230	1	
27	Jam Nut 1"-12	No Number	1	
28	Air Cylinder	1-2074	1	
29/49	Control Housing/Back	4-1161	1	
30	Elbow Fitting 1/4"x1/4"	4-1015-12	7	Each
31	Pressure Regulator	1-1213	1	
32	Tack Button	1-1587	1	
33	ON/OFF Switch	1-2087	1	
34	Circuit Breaker	1-1331	1	
35	LCD Display	1-1031	1	
36	Pressure Gauge	1-1214	1	
37	E-Stop	1-1588-1	1	
38	Keypad	2-1014	1	
39	Print Switch	1-1670	2	Each
40	Counter	1-2067	1	
41	Terminal Block 5 Position	1-1290	1	
42	Stone Filter	4-1015-36	1	
43	Mac Valve	1-1231 IN	1	
44	Safety Valve 100 PSI	1-1581	1	
45	Elbow Fitting 1/8"x1/4"	4-1015-13	1	
46	Control Board	1-2021	1	
47	Elbow Fitting 1/4"x3/8"	4-1015-4	2	Each
48	Terminal Block	1-1762	1	
49/29	Control Housing	4-1161	1	



HOTRONIX® AIR SWINGER

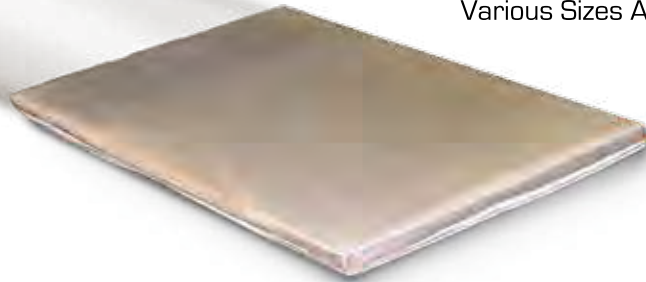
Models/Accessories



Air Swinger (Table Top)

Quick Slip Pad Protector

This fitted, non-stick cover slips snugly over the bottom platen making it easy to slide garments on to it. It also reduces wear and tear and aides proper adhesive flow. Various Sizes Available.



Interchangeable Heat Platens

Interchangeable platens allow you to maximize heat applying graphics to a wide variety of garments and accessories. Various Sizes Available.



Air Swinger (Pedestal Stand)

Contact us

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