

SWINGER & DRAW PRESS 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 reassembly or repair could cause a risk of fire, electric shock, or injury to persons when the equipment is used.
7. Close supervision is necessary for any heat press being used by or near children. Do not leave equipment unattended while connected.
8. Burns can occur when touching hot metal parts.
9. To reduce the likelihood of circuit overload, do not operate other high voltage equipment on the same circuit.
10. If an extension cord is necessary, then a 20 ampere 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

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Machine View

SWINGER PRESS



DRAW PRESS



SWINGER PRESS / DRAW PRESS

Operating Instructions

Hotronix® SWINGER & DRAW PRESS

The Hotronix® Swinger & Draw Press 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® Swinger & Draw Press requires a full 20 amp grounded circuit for 120 volt operation.
240 Volt - The Hotronix® Swinger & Draw Press requires a full 10 amp grounded circuit for 240 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 HSJ type, rated 250 V - 10 AMP 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.

Turning the System On

2. SWITCH THE SYSTEM ON

- See the diagram below for switch placement.

IMPORTANT: Before turning your machine on, be sure that the heat platen is in the UP position. This is necessary so that the pressure sensor may function correctly.
[The Power ON/OFF Switch is located on the right side of the plastic cover].

HELLO!

- 2.1 Flip the Switch to the ON position. The machine will display "HELLO!" for 3 seconds.



Power ON/OFF Switch



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

04/01 WED 16:00

Time
Day
Date (Month/Day)

- The Temperature message will automatically appear.

T = 180/375F t = 008

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



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

3. ADJUST THE PRESSURE

3.1 First, locate the LCD Display on the Press.

3.2 Then Press the Pressure Key on the Control Panel (Press for 2 seconds).



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

Actual Platen Pressure
Target Pressure

ADJ PRESSURE = 0 0

- The Actual Platen Pressure displays the manual pressure you are applying (Numbers 1 - 9).
- The Target Pressure will always display zero ("0") when manually applying the pressure.
- When a Pre-Set Program is used, the Target Pressure will display the pressure that the program suggests.

ADJ PRESSURE = 0 5

Manually Set Pressure

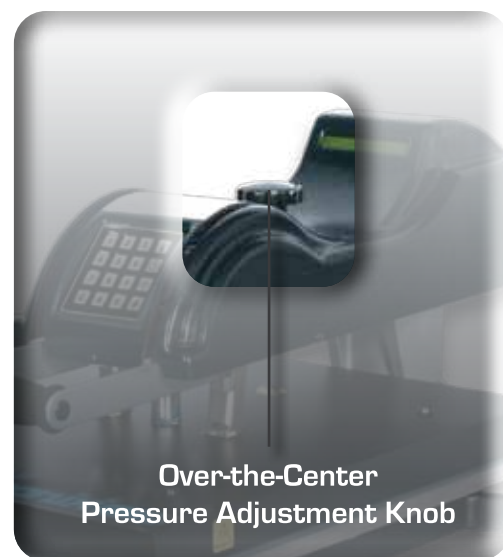
ADJ PRESSURE = 5 5

Pre Set Programmed Pressure

3.3 Adjust the Actual Platen Pressure by raising the platen to the UP position and manually turning the Pressure Adjustment Knob clockwise to increase the pressure or counter clockwise to decrease the pressure.

1 - 3 = Light Pressure
4 - 7 = Medium Pressure
8 - 9 = Heavy Pressure

NOTE: The Hotronix® Swinger/Draw Press features a patented, Over-the-Center Pressure Adjustment located in the center of the heat platen. (See figure to the right)



Over-the-Center
Pressure Adjustment Knob

- 3.4 Lower the heat platen into the print position.
- 3.5 Repeat this process until the Actual Platen Pressure displays the pressure desired for printing.
- 3.6 If a Pre-Set Program is used, then repeat the pressure adjusting process until the number displayed on the right, (Actual Platen Pressure) matches the number on the left (Target Pressure).
- 3.7 Press the "E" Key to exit the Pressure Mode and to return to the Print Mode.

REMEMBER: The garment must be in the press when setting the pressure. Allow for the thickness of your garment when adjusting the pressure.

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

Adjusting the Time

4. ADJUST THE TIME

- 4.1 First, locate and press the Time Key on the Control Panel.
(Press for 2 seconds)



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

- 4.2 Key in desired time. To enter time, key in 3 digits within a range of 001 to 999 seconds. (i.e. 008 seconds).

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.



- 4.3 Press "E" Enter Key to enter the time. (Press for 2 seconds)



- Your time has now been programmed and will appear in the display.
- The Hotronix® press will automatically return to the "READY TO PRINT" cycle.



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

Adjusting the Temperature

5. ADJUST THE TEMPERATURE

5.1 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.



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

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

5.4 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.

5.5 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.

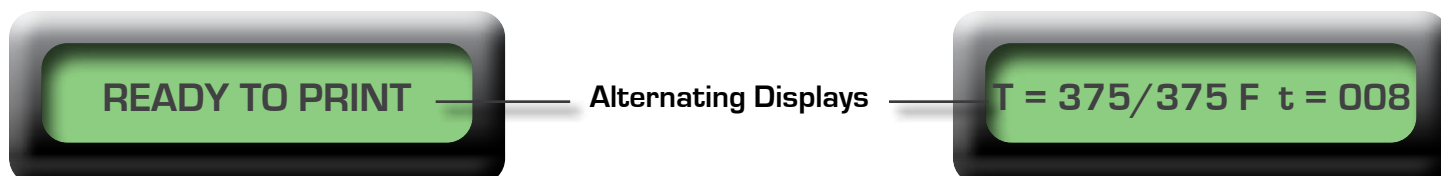
REMEMBER: If a beep is heard at any time during programming, you have made an error. Please re-read the instructions and try again.



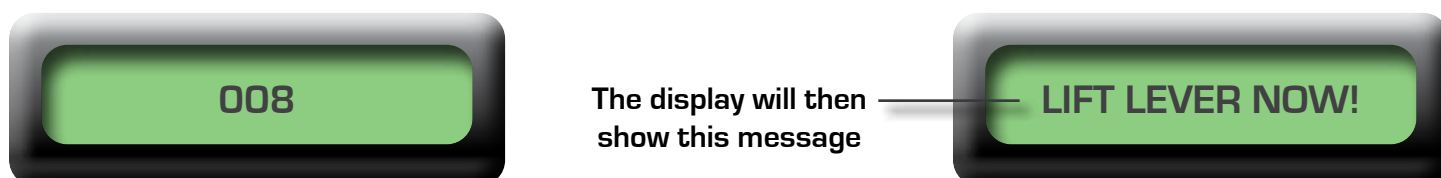
Printing / Pressing

6. 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.



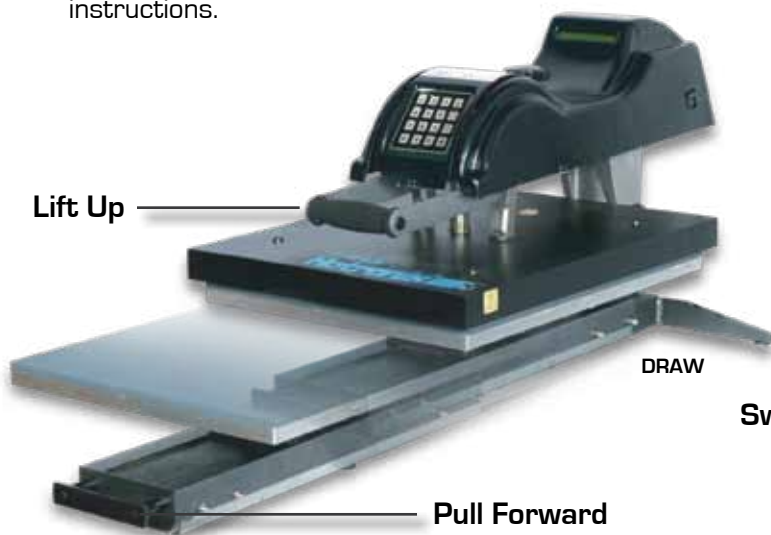
- 6.1 Position garment and application. Swing heat platen into position. Lower and lock the heat platen into the press position. The display will automatically initiate a count down and visually and audibly signal you when to lift the platen off the garment.



Example: 005, 004, 003, 002, 001

- 6.2 Immediately lift the platen to the UP position.

- On the Hotronix® Draw Press, lift up handle and pull draw handle forward, then proceed according to your application's instructions.



- On the Hotronix® Swinger Press, lift up handle and swing heat platen away and proceed according to your application's instructions.



Your equipment has automatically reset and will again alternate between the "READY TO PRINT" and "TIME AND TEMPERATURE" messages. You may continue to print.

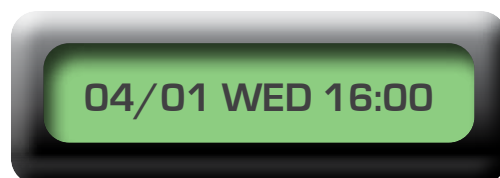
Setting the Date & Time

7. SWITCH THE SYSTEM ON

- 7.1 The Power ON/OFF Switch is located on the right side of the plastic cover. Flip the switch to the ON position. The machine will display "HELLO!" for 3 seconds.



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



- 7.2 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 7.1.



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

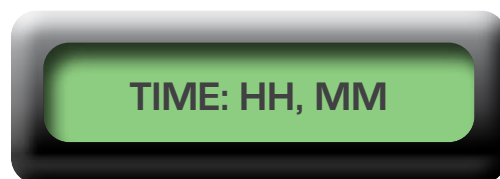


This message will automatically appear

- 7.4 Key in the two digits for the month (MOMO)
(01= January, 12=December)
- 7.5 Next, key in one digit for the day (DAY) (1= Monday, 7= Sunday)
- 7.6 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 7.1.



- 7.7 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.



- 7.8 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

8. SET THE AUTO ON/OFF

- 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



Number Key



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



- 8.2 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.



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



Setting the Auto ON/OFF - cont.

8.4 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.

8.5 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 8.6)



- 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.



8.6 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.



8.7 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.



8.8 Pressing the "#" Key will allow you to change the time for the desired day. (Refer to step 8.2).

- 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.

8.9 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

9. 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.



9.1 Set the Temperature
(Refer to page 10)



9.2 Set the Time
(Refer to page 9)



9.3 Set the Pressure
(Refer to page 8)



9.4 Lower the heat platen into the Print position. Adjust the Actual Platen Pressure by raising the platen to the UP position and manually turning the Pressure Adjustment Knob clockwise to increase the pressure or counter-clockwise to decrease the pressure. Then lower the Heat Platen into the print position. Repeat this process until the actual Platen Pressure displays the pressure desired for printing.

This message will automatically appear

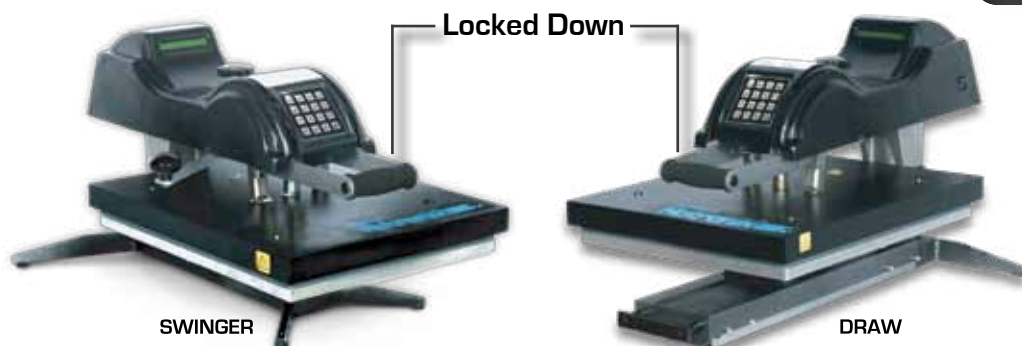


Target Pressure
Actual Platen Pressure



Storing Settings - cont.

- 9.5 Press The "E" Key with the platen in the locked down position to save the pressure setting and to return to the "READY TO PRINT" mode.



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



- 9.6 Press the temperature key. (Press for 2 seconds)
The "Ready to Print" message will stop blinking.



- 9.7 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.



- 9.8 Press the "C" Key. (Press for two seconds)

- 9.9 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

10. TO RETRIEVE A PRESET PROGRAM



10.1 Press the "C" Key.
(Press for 2 seconds). This turns the retrieve function on and the "READY TO PRINT" display will stop blinking.

READY TO PRINT

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.



10.2 Press the "#" Key (Press for 2 seconds). This signals the controller that you are about to retrieve a pre-set program.

10.3 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.

READY TO PRINT



■ The LCD Screen will display your Actual Temperature, new Target Temperature, and new Time as shown to the right:

T = 350/375 t = 015

1 - 3 = Light Pressure
4 - 7 = Medium Pressure
8 - 9 = Heavy Pressure

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

**Over-the-Center
Pressure Adjustment Knob**

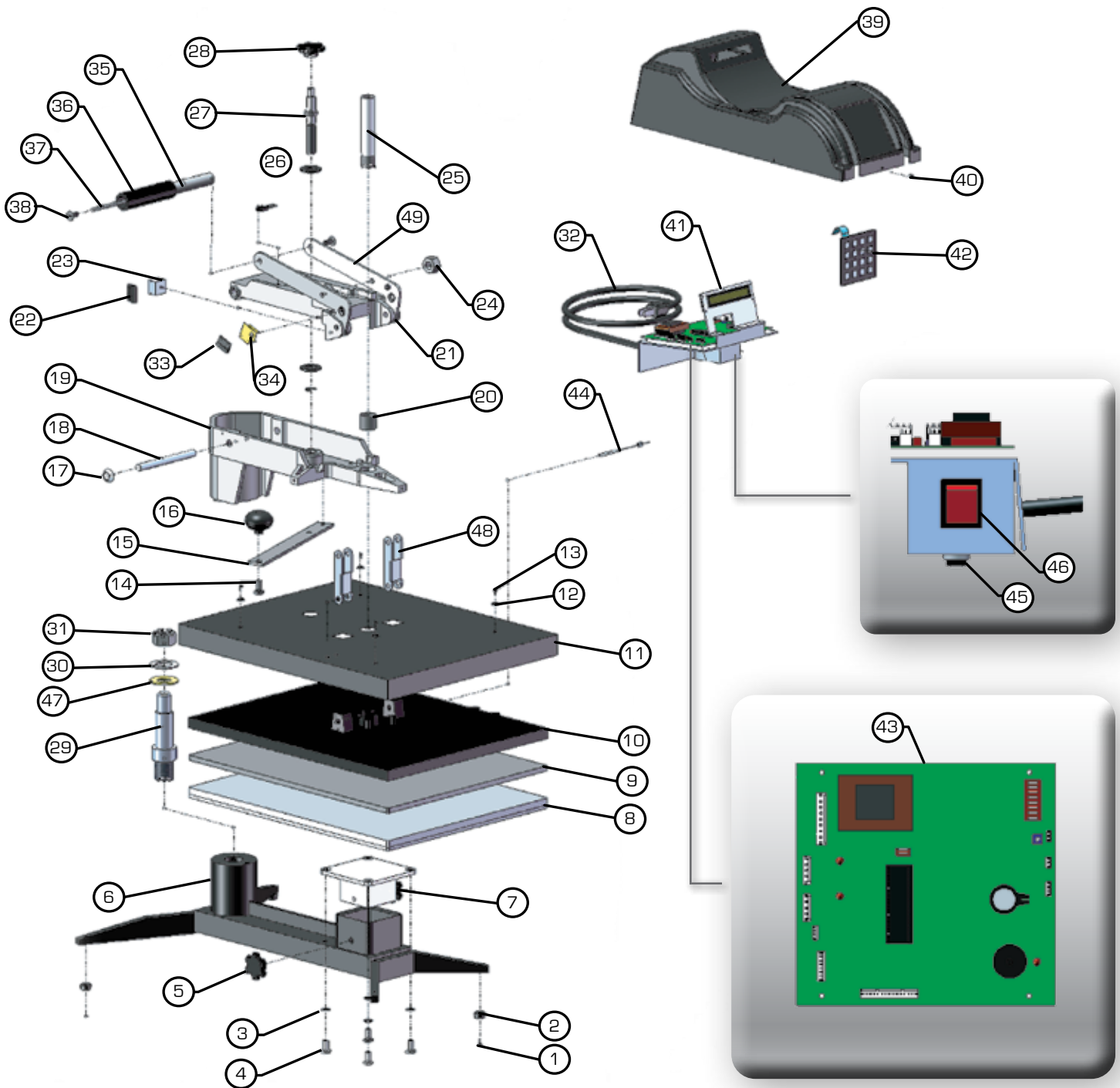
SWINGER PRESS / DRAW PRESS

Swinger Replacement Parts List

Item #	Part Name	Part #	Qty.	
1	Hex Soc Button HD #10-32 x 1/2"	3-1011-164	4	each
2	Rubber Foot	1-1256	4	each
3	Lock Spring Washer	2-1006-44	4	each
4	Hex Soc Screw 1/4-20 x 3/4	3-1011-106	4	each
5	Platen Thumb Screw	1-1016	2	each
6	Swinger Base	4-1003	1	
7	Post Casting	2-1033	1	
8	Lower Platen 16 x 20	2-1029	1	
9	Silicone Pad Gray 16 x 20	1-1011	1	
10	Heat Platen	2-1002	1	
11	Heat Platen Cover	2-1003	1	
12	Finish Washer	1-1063	4	each
13	Cover Screw 10-24x1/2"	3-1011-217	4	each
14	Hex Soc Screw HD 3/8-16 x 3/4"	3-1011-41	1	
15	Swing Arm	Kit 3-6915	1	
16	Swing Knob	1-1054	1	
17	Hub Cap	1-1107-1	2	each
18	Steel Pin 1/2" x 5 7/8"	1-1004	1	
19	Top Casting	Kit 3-1255	1	
20	Guide Tube Bushing	1-1013	1	
21	Adjustment Casting Kit	Kit 3-1216	1	
22	Proximity Switch	1-1211	1	
23	Proximity Bracket	1-1277	1	
24	Ball Plunger	1-1039	1	
25	Guide Tube	1-1005	1	
26	Triac	1-1059	1	
27	Adjustment Spindle Kit	Kit 3-1220	1	
28	Pressure Knob	1-1012	1	
29	Main Spindle	2-1005	1	
30	Washer, Type A 1"	2-1006-21	1	
31	Nut, Hex Slotted Castle	2-1006-1	1	
32	Power Cord	2-1013-1	1	
33	Magnet, Slotted	1-1219	1	
34	Magnet Bracket	1-1278	1	
35	PVC Spacer 1/2" x 4.90	1-1049-6	1	
36	Black Foam Grip	1-1540	1	
37	All Thread Pin 1/4-20 x 4 3/4"	1-1042-1	1	
38	JCN Nut	2-1006-2	2	each
39	Plastic Cover	3-1013	1	
40	Cover Screw 8-32 x 3/8"	3-1011-127	4	each
41	LCD Display	1-1031	1	
42	Keypad	2-1014	1	
43	Control Board	1-2021	1	
44	Probe	1-1272-1	1	
45	Circuit Breaker	1-1331	1	
46	On/Off Switch	1-2087	1	
47	Washer, Bronze	1-1015	1	
48	Lift Links	1-1024	2	each
49	Lift Handle Assembly	Kit 3-1262	1	set
50	Controller Update Kit	Kit 3-1226	1	

SWINGER PRESS / DRAW PRESS

Swinger Parts Location Guide



- (21) —
- Adjustment Casting Kit
 - Ball Plunger
 - Lift Levers
 - Adjustment Spindle
 - Hub Caps
 - Adjustment Casting
 - Bearings

- (50) —
- Controller Update Kit
 - Triac
 - Plastic Cover
 - Probe
 - Complete Controller
 - Keypad

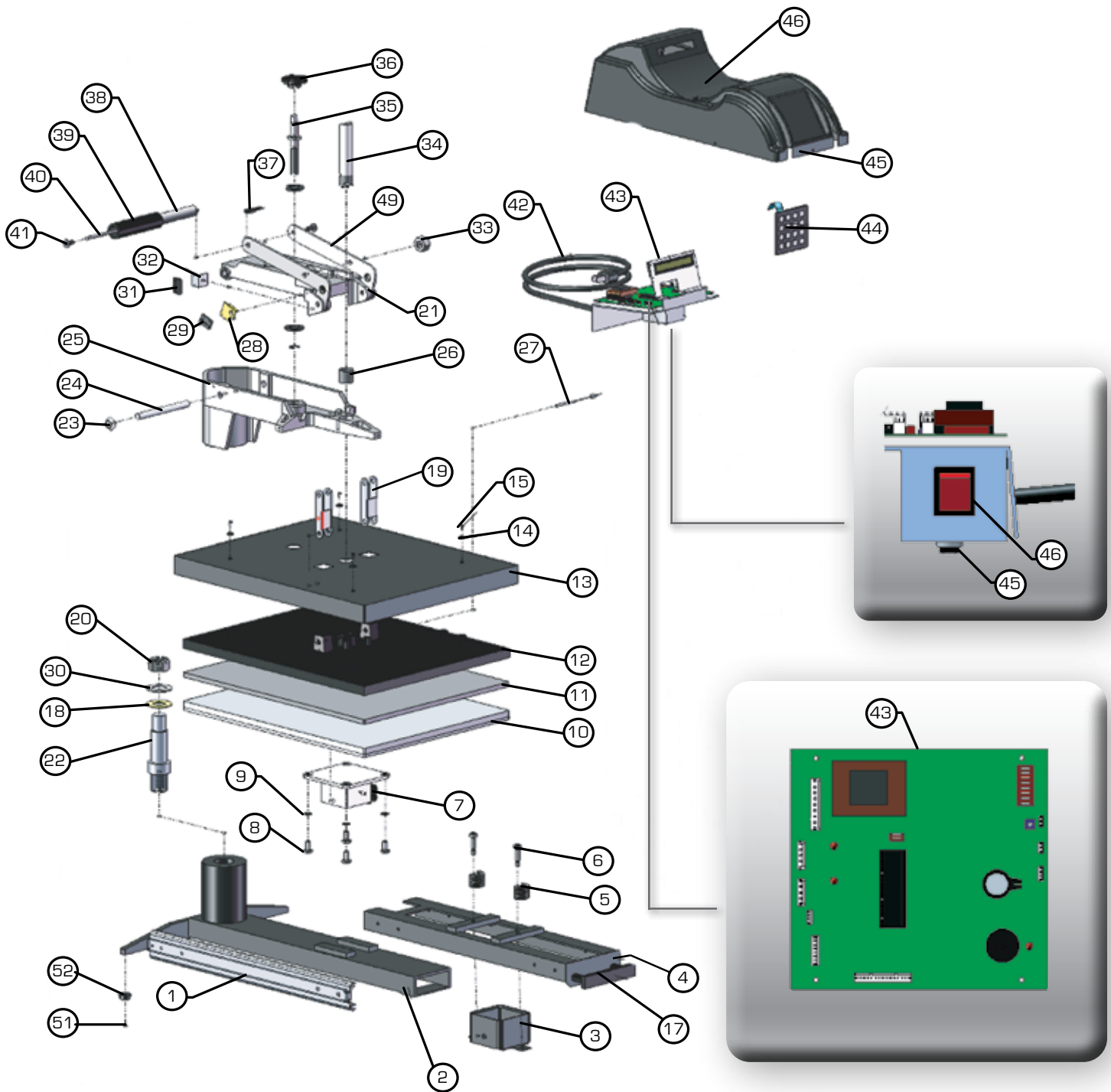
SWINGER PRESS / DRAW PRESS

Draw Replacement Parts List

Item #	Part Name	Part #	Qty.
1	Drawer Slide	1-1749	1 set
2	Hotronix Draw Base	4-1094	1
3	Head Piece	Kit 3-6913	1
4	Slide Piece	Kit 3-6914	1
5	Spring, Die 1/2" I.D. x 1"	1-1837	2
6	Shoulder Bolt, Soc HD 3/8" x 1"	3-1011-121	2 each
7	Post Casting	2-1033	1 each
8	Hex Soc Cap Screw 1/4-20 x 1 1/4"	3-1011-62	4
9	Lock Spring Washer	2-1006-44	4 each
10	Lower Platen	2-1029	1 each
11	Silicone Pad Gray 16 x 20	1-1011	1
12	Heat Platen	2-1002	1
13	Heat Platen Cover	2-1003	1
14	Finish Washer	1-1063	4
15	Cover Screw 10-24 x 1/2"	3-1011-217	4 each
16	Control Board	1-2021	1 each
17	Pull Handle	1-1783	1
18	Washer, Bronze	1-1015	1
19	Lift Links	1-1024	2
20	Nut, Hex Slotted Castle	2-1006-1	1 each
21	Adjustment Casting Assembly	Kit 3-1216	1
22	Main Spindle	2-1005	1
23	Hub Cap	1-1107-1	2
24	Steel Pin 1/2" x 5 7/8"	1-1004	1 each
25	Top Casting	Kit 3-1255	1
26	Guide Tube Bushing	1-1013	1
27	Probe	1-1272-1	1
28	Magnet Bracket	1-1278	1
29	Magnet, Slotted	1-1219	1
30	Washer, Type A 1" I.D.	2-1006-21	1
31	Proximity Switch	1-1211	1
32	Proximity Bracket	1-1277	1
33	Ball Plunger	1-1039	1
34	Guide Tube	1-1005	1
35	Adjustment Spindle Kit	Kit 3-1220	1
36	Pressure Knob	1-1012	1
37	Triac	1-1059	1
38	PVC Spacer 1/2" x 4.90	1-1049-6	1
39	Black Foam Grip	1-1540	1
40	All Thread Pin 1/4-20 X 4 3/4"	1-1042-1	1
41	JCN Nut	2-1006-2	2
42	Power Cord	2-1013-1	1 each
43	LCD Display	1-1031	1
44	Keypad	2-1014	1
45	Cover Screw 8-32 X 3/8"	3-1011-127	3
46	Plastic Cover	3-1013	1 each
47	Circuit Breaker	1-1331	1
48	On/Off Switch	1-2087	1
49	Lift Handle Assembly	Kit 3-1262	1 set
50	Controller Update Kit	Kit 3-1226	1
51	Hex Soc Button HD#10-32 x 1/2"	3-1011-164	4
52	Rubber Foot	1-1256	4

SWINGER PRESS / DRAW PRESS

Draw Parts Location Guide

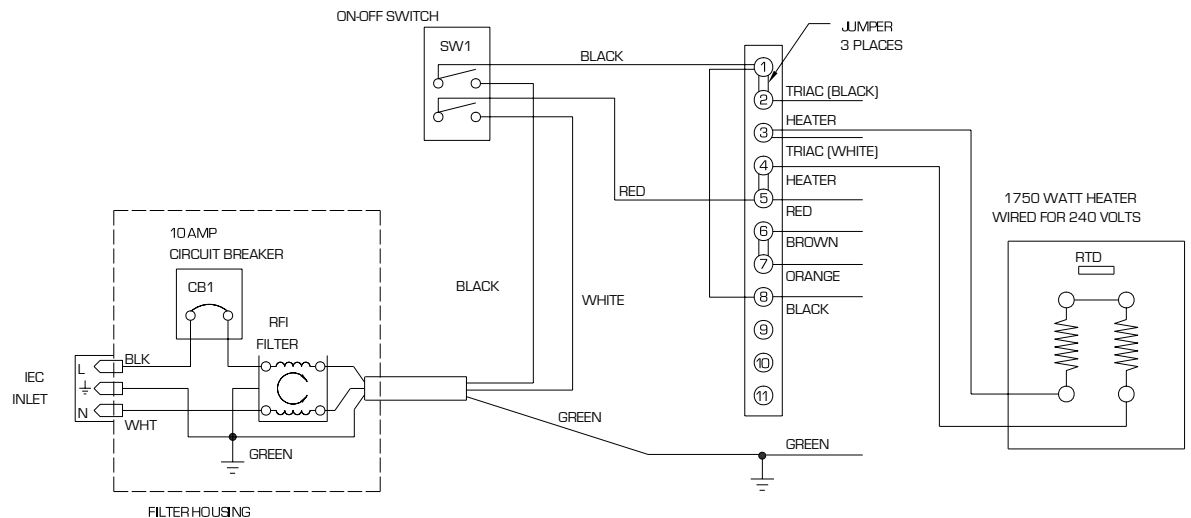
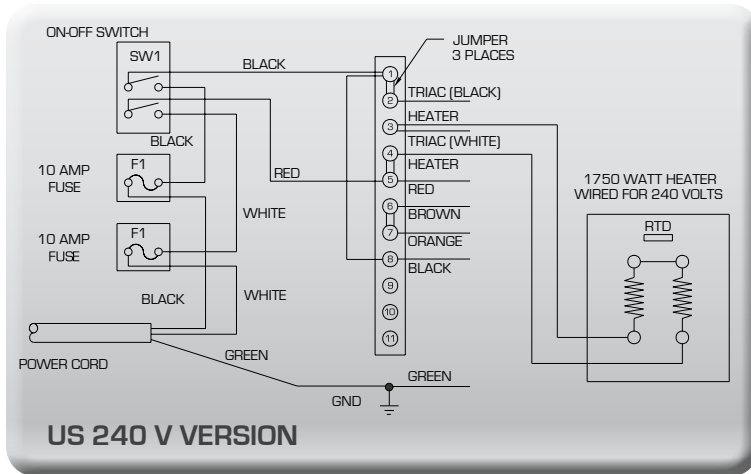
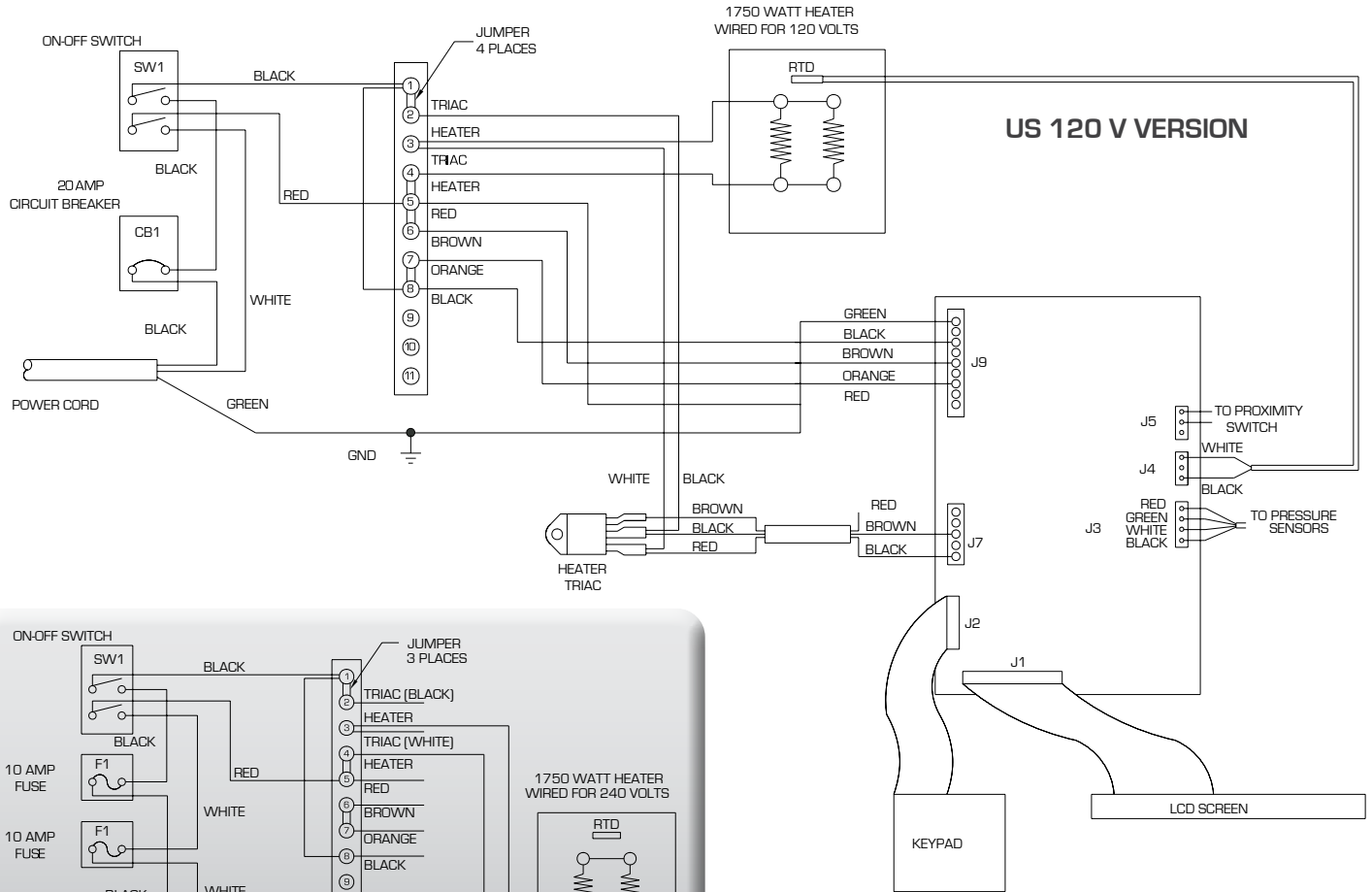


- (21) • Adjustment Casting Kit
- Ball Plunger
- Lift Levers
- Adjustment Spindle
- Hub Caps
- Adjustment Casting
- Bearings

- (50) • Controller Update Kit
- Triac
- Plastic Cover
- Probe
- Complete Controller
- Keypad

SWINGER PRESS / DRAW PRESS

Electrical Schematic



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