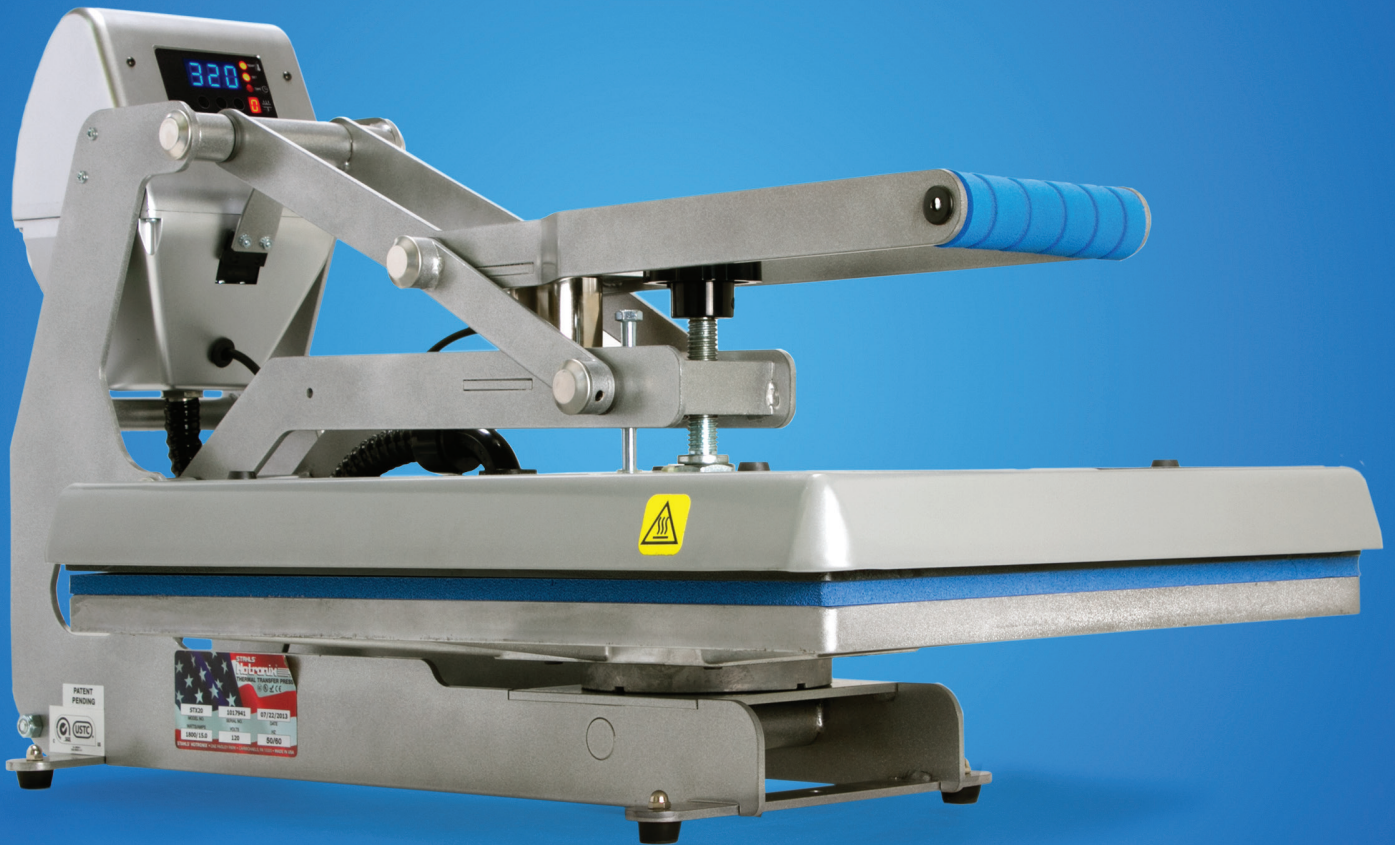


# AUTO OPEN CLAM

## OPERATOR'S MANUAL



Available models: Auto Open Clam:  
28 x 38 cm, 40 x 40 cm, 40 x 50 cm (shown) & Hover

STAHL'S  
**Hotronix**®

**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. Power supply cord must be disconnected before cleaning or servicing press.
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. To avoid burns, do not touch hot metal parts or the heated platen during use.
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-ampere rated cord should be used. Cords rated for less ampere may overheat. Care should be taken to arrange the cord so that it cannot be pulled or tripped over.
12. Keep hands clear of the upper heat press platen during lock down as the pressure may cause injury.
13. Heat press should be placed on a sturdy, suitable stand at least 91,5 cm L x 60 cm W x 75 cm H.
14. Work area must be kept clean, tidy and free of obstructions.

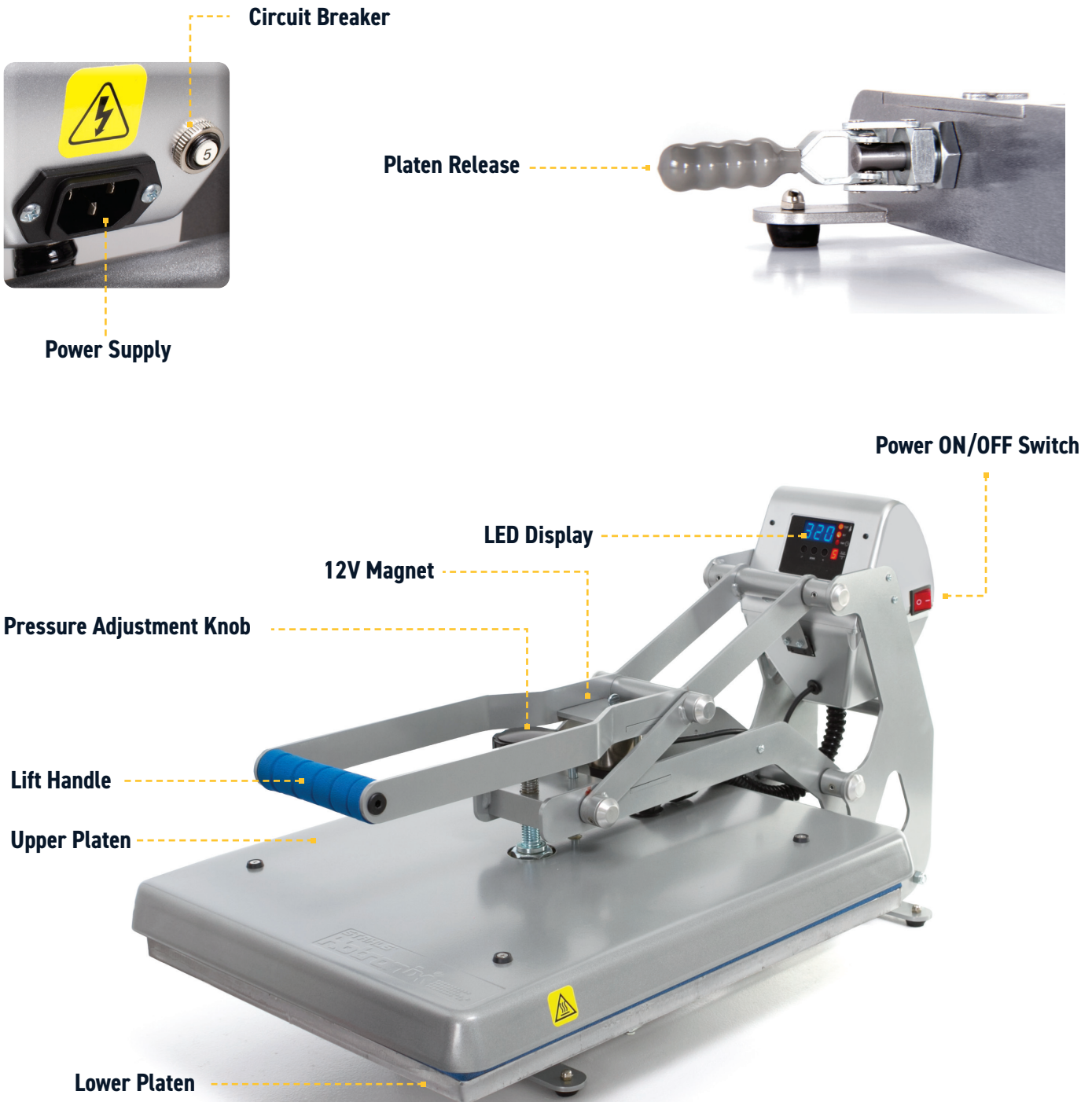
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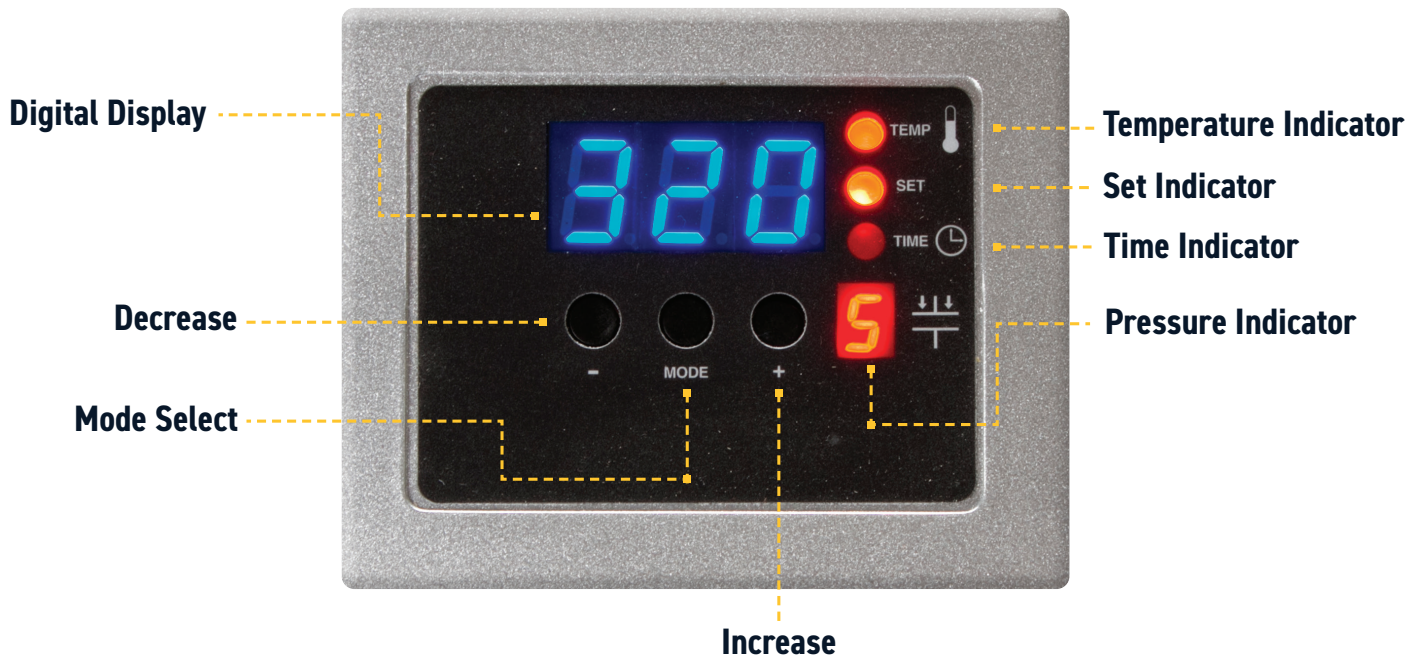
# HOTRONIX® AUTO OPEN CLAM

## Machine View



# Operating Instructions

## LED Display



### Connecting the System

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

#### Voltage

**230 volt** requires a full 10-amp grounded circuit.

**Extension cords** should be as short as possible and not less than 12 gauge. Heavy duty cords are recommended.

**Circuits** with less than 10 amps or 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 300V 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.

### Start Up/Shut Down

Locate the packaging bolt on top of press and remove prior to turning on or operating (2.1).

Locate the Power ON/OFF Switch on the side of the press, then turn the Power Switch ON (2.2).

*NOTE: The Auto Open Clam Heat Press is equipped with an Auto Sleep Mode. When the machine is inactive for a period of two hours, it will enter an energy saving sleep mode. To restore to normal operating mode, press any button on the display panel and allow the heat press to return to the target temperature.*



1.1



2.1



2.2

# Operating Instructions

## Adjusting Settings

### Adjust Temperature

Press the Mode Select button in the center of the Control Panel.  
The (SET) and (TEMP) lights located next to the display will illuminate.

Press the (+) or (-) button to raise or lower the temperature setting.  
The temperature can be set from 176°F (79°C) to 430°F (220°C).  
The LED Display will show changes as you make them.

### Adjust Time

Your heat press has two time settings that will allow you to set different times when a two-hit application is required. For single-hit applications, simply set both time settings the same.

Once the temperature is adjusted, press the Mode Select button again to advance to Time #1 Mode. The (SET) and (TIME) lights will illuminate, indicating you are in Time #1 Mode.

Once you have Time #1 set, push the Mode Select button again to advance to Time #2 Mode. All three red LED lights will illuminate indicating you are in Time #2 Mode. Select the desired time and push the Mode Select button again to exit the time settings. All lights will be off and the press will return to the PRINT mode.

#### NOTE:

- Press the Mode Select button ONCE to advance to Adjust Temperature Mode.
- Press the Mode Select button A SECOND TIME to advance to Time #1 Mode.
- Press the Mode Select button A THIRD TIME to advance to Time #2 Mode.
- Press the Mode Select button A FOURTH TIME to return to Heat Up/Operating Mode.

Turn the knob clockwise to increase pressure and counterclockwise to decrease pressure.

### PRESSURE READOUT

A visual Pressure Readout is located on the lower right side of the LED Display. When the handle is locked into the PRINT position, a pressure number between 0-9 will be displayed. 0 indicates no pressure and 9 indicates very heavy pressure.

Remember to allow for the thickness of your garment when adjusting the pressure.

1 - 3 = Light Pressure

4 - 7 = Medium Pressure

8 - 9 = Heavy Pressure

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

### Pressing

Once your equipment has reached the designated temperature:

- Position the garment and design
- Lower and lock the heat press platen into position
- The automatic timing process will begin

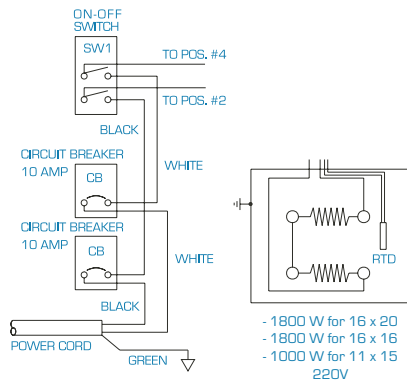
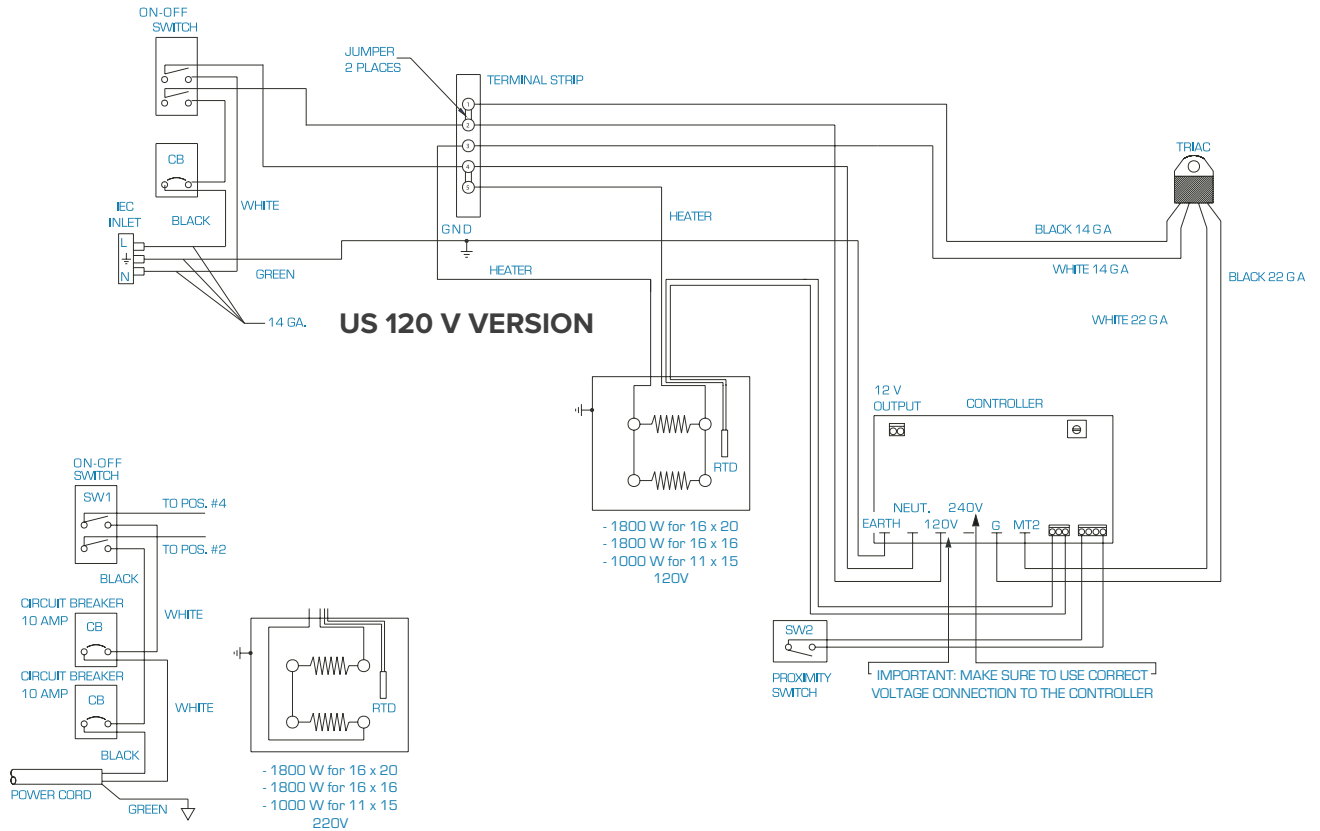
The timer will automatically count down and lift the heat platen into the UP position when the print cycle is complete.



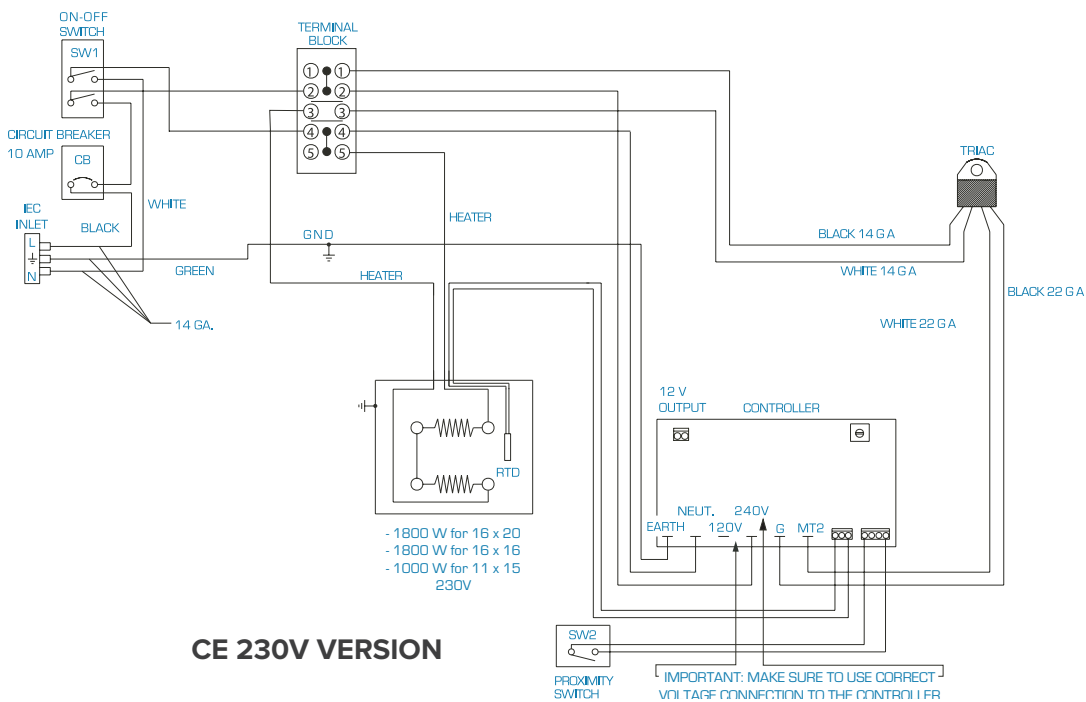
*Note: Please be aware after time is complete, gas shocks will automatically release the platen into the UP position.*



# Electrical Schematic



**US 220 V VERSION**




**CE 230V VERSION**

# HOTRONIX® AUTO OPEN CLAM

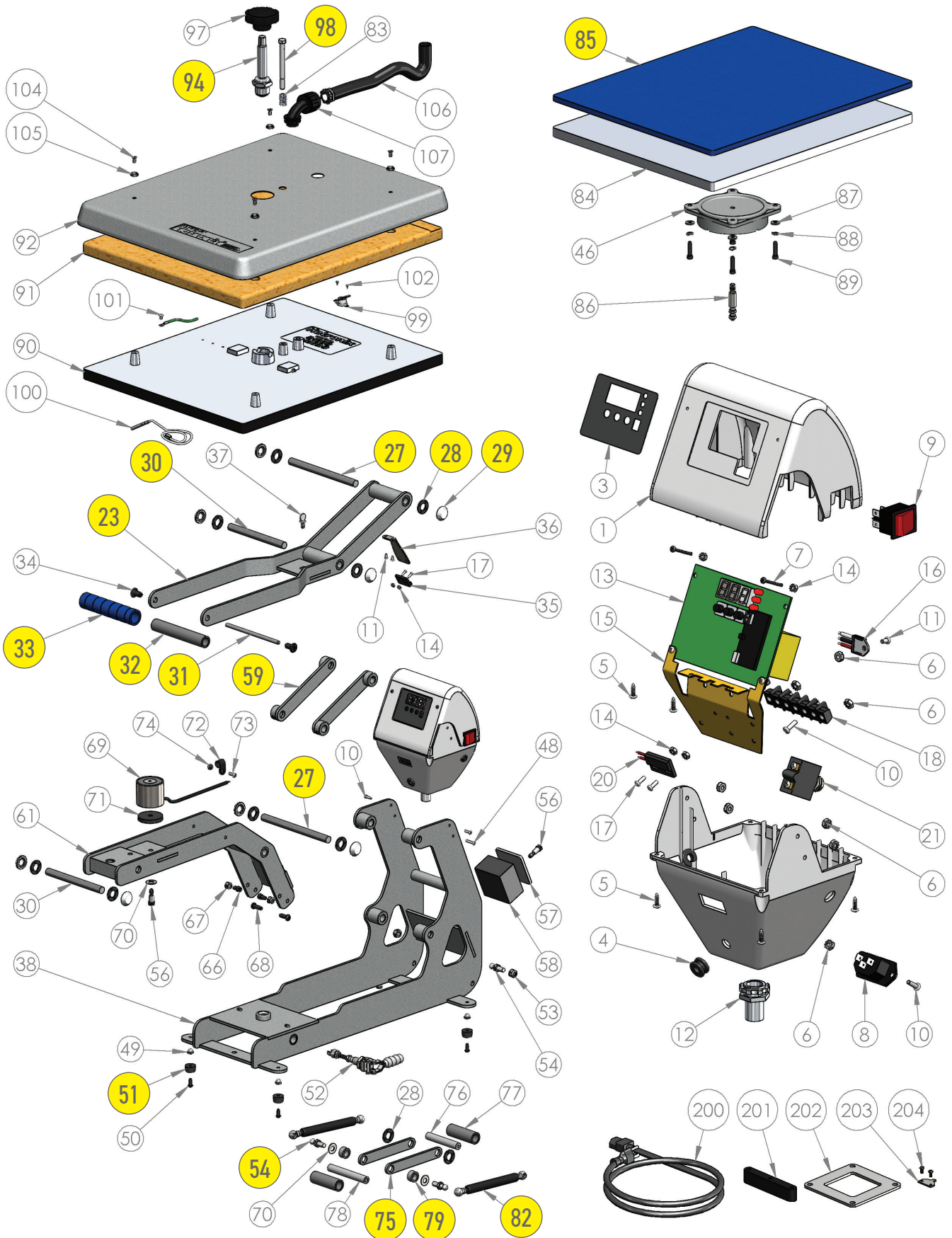
## Replacement Parts List


ITEM #	PART NAME	PART #	QTY
1	Control Housing, STX	4-1172-S	1
3	Controller Overlay, STX	1-2018-1	1
4	Grommet, 9/32" ID 3/8" OD	1-2105	2
5	Screw, Plastic #6 x 1/2"	3-1011-235	6
6	Nut, #6-32 Hex with Lockwasher	2-1006-50	9
7	Screw, Pan Phillips #4-40 x 1"	3-1011-130	2
8	Power Inlet	1-1759	1
9	Power Switch	1-2087	1
10	Screw, Machine #6-32 x 1/2"	3-1011-19	7
11	Screw, Machine #6-32 x 1/4"	3-1011-25	7
12	Conduit Fitting, 1/2" Topaz Straight Twist-On	1-1353	2
13	Controller Kit, STX	Kit 3-6945	1
14	Nut, #4-40 with Tooth Washer	2-1006-51	8
15	Controller Bracket, STX MAXX	2-1661	1
16	TRIAC	1-1059	1
17	Screw, Machine #4-40 x 3/8"	3-1011-22	6
18	Terminal Block, 5 Contact High Voltage	1-1290	1
18	Terminal Block, CE Machines	1-1762	5
18	Terminal Block Section, CE Machines	1-1763	2
18	Terminal Block Jumper, CE Machines	1-1764	2
18	Terminal Block Separator, CE Machines	1-1767	2
20	Proximity Switch	1-1211	1
21	Circuit Breaker 20A (STX XF XRF)	1-1331	2
21	Circuit Breaker 10A (220V & 11x15)	1-1331-2	2
23	Handle Assembly STX	KIT 3-6930	1
27	Steel Pin 1/2" x 6.45"	2-1055-26	2
28	Washer, 1/2" Nylon	1-1048-3	10
29	Hub Cap 1/2"	1-1107-1	8
30	Steel Pin, 1/2" x 5-3/8"	1-2093	2
31	All Thread Pin	1-1042-1	1
32	PVC Spacer 1/2" x 5"	1-1049-11	1
33	Blue Foam Grip	1-2115	1
34	JCN - NUT	2-1006-2	2
35	Proximity Magnet	1-1219	1
36	Magnet Bracket (STX)	1-2085	1
37	Shipping Bolt (Thumb Screw), 1/4"-20 x 1/2"	3-1011-232	1
38	Base, STX Hover	KIT 3-6917	1
38	Base, STX 16x20, 16x16, 11x15	KIT 3-6931	1
46	Adapter Plate	3-1336	2
48	Screw, Pan Phillips #6-32 x 3/4"	3-1011-252	1
49	Acorn Nut 10-32	3-1011-182	4
50	Screw, Button Socket Head #10-32 x 1/2"	3-1011-164	4
51	Rubber Foot	1-1256	4
52	Quick Release Clamp, Manual Presses	1-2332	1
53	Nut, Hex Nylok 5/16"-18	2-1006-20	2
54	Ball Stud 10mm	1-1939	4
56	Screw, Shoulder 5/16" x 1/2" w/ 1/4"-20 Thread	3-1011-233	2
57	Silicone Pad	1-1561	1
58	Hover Electromagnet	1-2157	1
59	Pressure Link STX	KIT 3-6905	2
61	Adjustment Arm Kit, STX Hover	KIT 3-6916	1
61	Adjustment Arm Kit, STX	KIT 3-6903	1
66	Soc HD Cap Screw 1/4-20 x 3/8 "	3-1011-215	2

ITEM #	PART NAME	PART #	QTY
67	Nut, Hex 1/4"-20 Nylok	2-1006-7	2
68	Screw, Button Socket Head 1/4"-20 x 3/4"	3-1011-106	2
69	Electromagnet	1-1945-1	1
70	Washer, 5/16" SS	2-1006-46	3
71	Silicone Pad, 5/16" ID x 1-3/4" OD x 1/4" T	1-2104	1
72	Clamp, Cable 7/16" Black	1-1105	1
73	Screw, Machine #8-32 x 1/2"	3-1011-159	1
74	Nut, Hex #8-32 w/ Tooth Washer	2-1006-52	1
75	Bridle Links STX	KIT 3-6906	2
76	Pin, 1/2" x 3" w/ 1/4-20 Threads	1-2091	1
77	PVC Spacer 1/2" I.D.x 2.48	1-1049-13	2
78	Pin, 1/2" x 3-5/8" w/ 5/16"-18 Threads	1-2092	1
79	Steel Spacer	1-2114	2
82	Gas Spring 11x15 & 6x6 & Cap	1-2246	2
82	Gas Spring 16x20 & 16x16	1-2243	2
83	Spring, 1/2" D x 3/4" L, 62lb/in	1-2163	1
84	Lower Platen 11 x 15	3-1199-1	1
84	Lower Platen 16 x 16	2-1059	1
84	Lower Platen 16 x 20	2-1029	1
85	Silicone Pad 11 x 15 Blue	1-2134	1
85	Silicone Pad 16 x 16 Blue	1-2135	1
85	Silicone Pad 16 x 20 Blue	1-2136	1
86	Quick Release Pin	1-2215	1
87	Washer, Flat 1/4" SAE	2-1006-25	4
88	Washer, Split Lock 1/4"	2-1006-44	4
89	Screw, Socket Head Cap 1/4"-20 x 1"	3-1011-191	4
90	Heat Platen 11 x 15	3-1199	1
90	Heat Platen 16 x 16	2-1015	1
90	Heat Platen 16 x 20 1800W Milled (No Ears)	2-1002-3	1
91	Insulation 11 x 15	1-2258	1
91	Insulation 16 x 16	1-1534	1
91	Insulation 16 x 20	1-1020	1
92	Heat Platen Cover 11 x 15 STX	3-1331-S	1
92	Heat Platen Cover 16 x 16 STX	3-1333-S	1
92	Heat Platen Cover 16 x 20 STX	3-1332-S	1
94	Adjustment Spindle	2-1081	1
97	Adjustment Knob	1-1012	1
98	Bolt, Hex Head 5/16-18 x 3-1/2"	3-1011-238	1
99	Thermostat Disc	1-2076	1
100	Temperature Probe	1-1272-1	1
101	Screw, SS Phillips #8-32 X 1/4"	3-1011-87	1
102	Screw, SS Sheet Metal #4 X 1/4"	3-1011-98	2
104	Screw, Flat Head Phillips #10-24 x 7/16"	3-1011-217	4
105	Washer, Plastic Finishing	1-1063	4
106	Conduit, STX & MAXX 12"	1-1048-2	1
107	Conduit Fitting, 1/2" Elbow	1-1940	1
200	120V Locking Power Cord	2-1671	1
200	220V Power Cord	2-2186	1
200	230V European Locking Power Cord	1-1672	1
201	Lower Platen Spacer	1-1279	1
202	Platen Lift Kit	KIT 3-6924	1
203	Quick Change Keyway (Old Style)	1-2367	1
204	Screw, Machine #8-32 x 3/8" Black Oxide	3-1011-127	2
205	Heater Wire (Not Shown)	1-1068	1

 = Wear Parts

# Parts Location Guide



 = Wear Parts

### CE Certification

For the purposes of the EC-Machine Guideline 2006/42/EC, Appendix II A and the EC Low Voltage directive to 73/23 European Economic Community as well as the EC EMV-guideline 89/336.

For the manufacturer STAHL'S Hotronix® Division, we state as European Commissioners, that our product A Transfer Press for ironing of thermo application, Model: Auto Open Clam supplied corresponds to the following appropriate regulations:  
EMC Directive (2014/30/EU) & Low Voltage Directive (2014/35/EU):

- EN/IEC 60335-1:2010 Safety of household and similar electrical appliances
- EN 60335-2-44:2002 + A1:2008 + A2:2011 Safety of household and similar electrical appliances-safety Par 2-44: Particular requirement for ironers
- EN 60335-2-44:2002 + AMD1:2008 + AMD2:2012 Safety of household and similar electrical appliances-safety Par 2-44: particular requirement for ironers
- EN 61000-6-3:2007, Inc. A1:2011 - Electromagnetic compatibility (EMC) generic standards. Emission standard for residential, commercial and light-industrial environments
- EN 61000-6-1:2007 - Electromagnetic compatibility - generic immunity standard, part-6-1: residential, commercial and light industrial
- EN 61000-3-2:2014 - Electromagnetic compatibility (EMC) - Part 3-2: limits-limits for harmonic current emissions (equipment input current < or = 16 Amp per phase)
- EN 61000-3-3:2013 - Electromagnetic compatibility (EMC) - Part 3-3: limits-limitation of voltage changes, voltage fluctuations and flicker in public low - voltage supply systems, for equipment with rated current < or = to 16 Amp per phase and not subject to conditional connection.

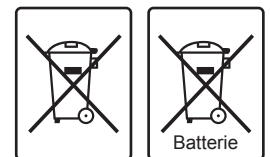
It is possible that not all the listed norms apply to the above mentioned product.

STAHL'S Europe GmbH



(Stephanie Schnur, Managing Director, STAHL'S Europe GmbH)

### WEE and RoHS Symbols



STAHL'S Europe GmbH will take back all heat press machines free of charge (inside the EU) that have been manufactured by them, even those sold prior to the date stated above, subject to the heat press machine being delivered to them at the owners costs. STAHL'S Europe GmbH will break down the heat press machine and ensure that all recyclable parts are correctly recycled, and non-recyclable parts will be disposed of in accordance with legal requirements. In an effort to make such transaction as smooth to customers as possible, and to ensure that all STAHL'S heat presses are identifiable, all heat press machines supplied by STAHL'S Europe GmbH will have the logo/brand of STAHL'S Hotronix clearly marked upon them.



# CONTACT US

## STAHL'S' Europe GmbH

Dieselstraße 62  
66763 Dillingen  
Germany

## Technical Support & Customer Service

+49 (0) 68 31/97 33 0

### Email

[info@stahls.de](mailto:info@stahls.de)

### Web

[stahls.de](http://stahls.de)

