AIR FUSION IQ®

STAHLS'
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-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.

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 36"L x 24"W x 29"H.

14. Work area must be kept clean, tidy and free of obstructions.

Table Of Contents

STAHLS'
Hotronix®

Print Button

Air Connect

Circuit Breaker
& IEC Inlet

Stand

Height
Adjustment

Foot Pedal

Caster

ON/OFF
Switch

Upper
Platen

Lower
Platen

Quick Release

Touch Screen

Platen Release

Base

Connecting the System

Insert power cord into IEC inlet located on the side of press (1.1). Connect the power cord into a properly grounded electrical outlet with a sufficient amperage rating.

To remove a locking power cord (if equipped), depress the two red buttons while pulling on the plug (1.2).

Voltage
120 volt presses require a full 15-amp grounded circuit.
240 volt presses require a full 10-amp grounded circuit.

Extension Cords
If used, extension cords should be as short as possible and not less than 12 gauge. Heavy duty cords are recommended.

Circuits
Circuits that have less than 15 amps, or have other high demand equipment or appliances (especially more than one heat press) plugged in, should not be used.

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

Pneumatics
The air compressor used with the press should be no less than 8 gallon capacity, no less than 2.3 CFM. The air compressor should be rated for continuous operation and with a pressure 110-120psi delivered from the compressor to the press. Checked water regulator (air filter) and shop air compressor, and drained regularly to avoid pumping water into the press and damaging the EP Regulator and/or Air Cylinder.

1.1

1.2

2.1

Start Up/Shut Down

To start up your heat press:

Flip the power switch ON (2.1). A splash screen displaying the Hotronix® logo and current software version is shown for several seconds.

To turn your heat press off, flip the power switch OFF.

To place your heat press into Standby Mode, touch and release the Power icon on the Home Screen (3.2 - following page). In Standby Mode, the heater turns off while the Touch Screen remains on, displaying an orange background as a warning if the platen is still hot (above 100° F / 38° C).

NOTE: Standby Mode must be used for the Auto On feature to function (10.1).
The Auto On feature will not work if the power switch (2.1) is in the OFF position.
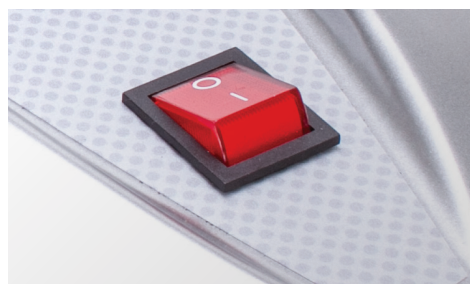
To start up your heat press while in Standby Mode, touch and release the Home icon on the Standby Screen.

Home Screen

Displays the selected preset. Touch and hold to see application settings.

NOTE: *Holding down material name will display targeted application settings. Screen displays current temperature, pressure, and time.*

Displays multiple heat application preset step. Touch the empty circled numbers to switch between preset steps.
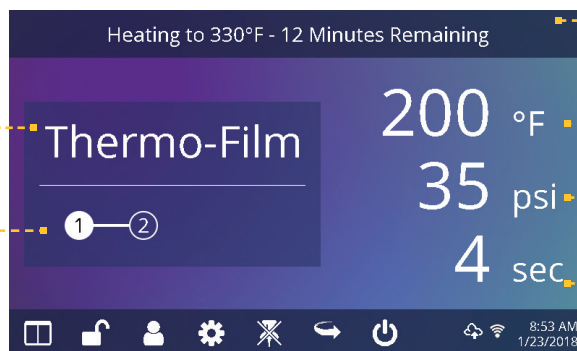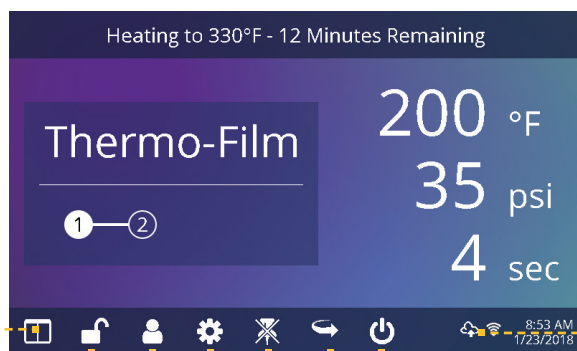
Status bar provides helpful information regarding heat press.

Displays the current application temperature, pressure and time.

Heating to 330°F - 12 Minutes Remaining

Thermo-Film
1 — 2
200 °F
35 psi
4 sec
8:53 AM
1/23/2018

3.1

Touch and edit your favorite presets.

Lock the screen (Manager-level only) to prevent User-level operators from changing settings.

IQ® Portal and WIFI connection status.

Heating to 330°F - 12 Minutes Remaining

Thermo-Film
1 — 2
200 °F
35 psi
4 sec
8:53 AM
1/23/2018

3.2

Touch and edit Users to control operator access level and track press usage by operator in the IQ® Portal.

Touch Setup Menu.

Touch to toggle tack mode.

Touch to cycle through Swing modes.

Place press in Standby Mode to take advantage of the scheduled Auto On feature.

Prepare to Print

To begin heat applying, start by verifying that you have the proper settings displayed on the Home Screen.
- Select preset material application.
- Manually enter temperature and time for selected material. Adjust pressure accordingly.

When desired settings are reached, you can begin heat application.

When using the Swing feature (4.1), swing the heat platen outward and position the garment and design.
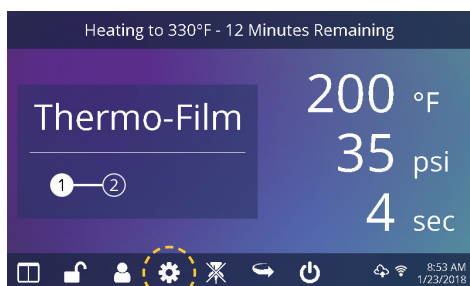
Swing the platen back into position and press both print buttons to lower platen and heat apply (4.2).

The Home Screen will initiate a count down and signal when to lift the platen off the garment.

Swing or pull the heat platen and proceed according to the application instructions.

4.1

4.2

Setup Menu

5.1

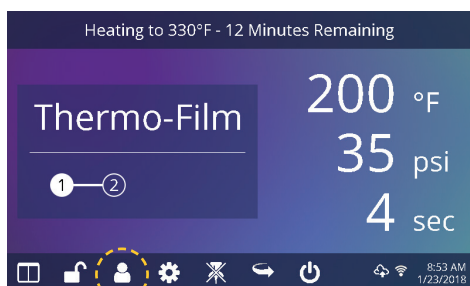Touch the Settings icon on the Home Screen (5.1) to configure your heat press.

Managers can access all setup options, while Users can access a limited set (5.2).
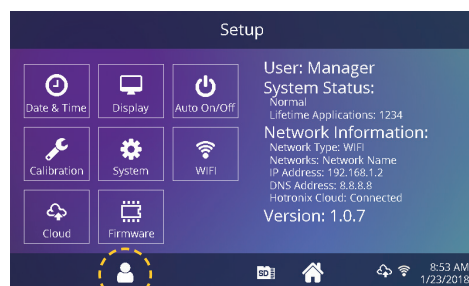• Managers default password: M

5.2

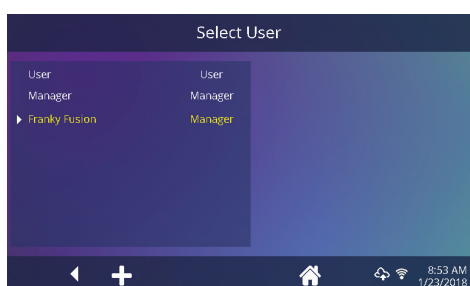## Password Setup (Manager Level Only)

6.1

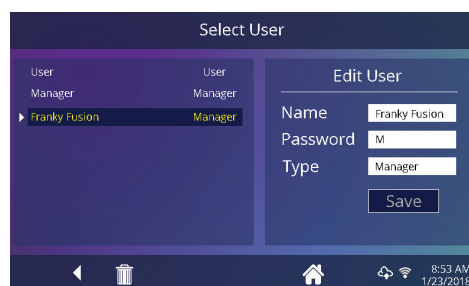Touch the User icon on the Home Screen (6.1) or Setup Menu (6.2) to select, add, and edit Users.
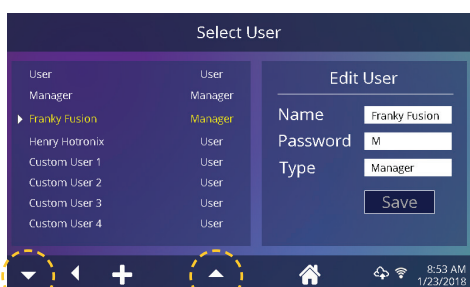
6.2

6.3

Touch and edit Managers and Users to configure access to settings (6.3, 6.4). Heat press reports on the IQ® Portal can be filtered by User to track individual operator performance.
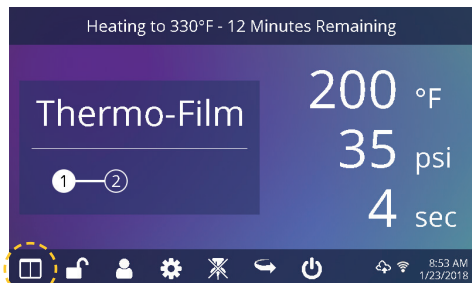
6.4

6.5

Touch the arrow keys on the taskbar to scroll through a long list of Users (6.5).

Preset Setup

7.1

Touch the Columns icon (7.1) to select from a list of saved presets (7.2).
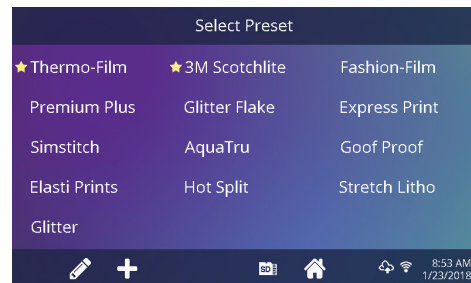
7.2
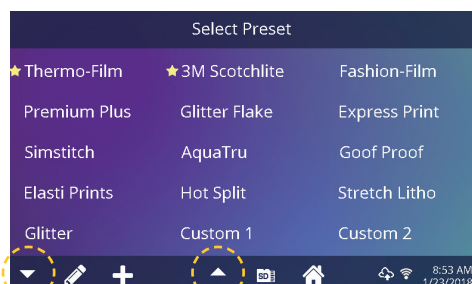
7.3

Touch the arrow keys on the taskbar to scroll through a long list of presets (7.3).

Touch a preset to select a material.

Touch the Pencil icon (7.4) to enter edit mode, then touch preset name to edit settings. Touch Save to save changes.
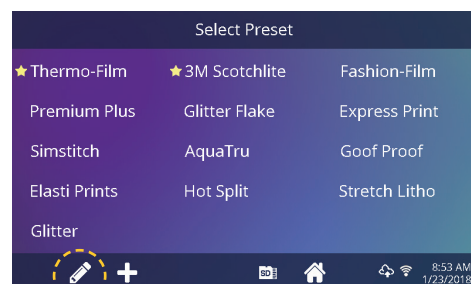
7.4
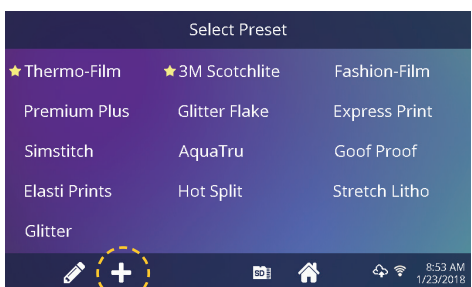
7.5

Touch the Plus icon to create a new preset (7.5).

Name your preset and enter desired temperature, time, and pressure. When creating a new preset, the current Home Screen application settings are selected automatically (7.6).

7.6

7.7

Touch the empty circled numbers to set multiple preset stages for pretreatment or multi-step applications (7.7).

Date & Time Setup

Touch the Settings icon on the Home Screen.

• Touch Date & Time, information displays on right of screen (8.1).

• Touch up/down arrows to select time zone.

• Touch Auto to automatically synchronize the heat press clock.
  The heat press must be connected to a WIFI network with
  access to the Internet. See page 12 for WIFI connection information.

• Touch Daylight Saving to enable daylight saving mode.
  This option should be enabled during summer.

8.1

Display Setup

Touch the Settings icon on the Home Screen.

• Touch Display, information displays on right of screen (9.1).

• Touch Temperature to switch between F° or C°, then touch
  Check Mark icon on taskbar to save.

9.1

Auto On & Off Setup

Touch the Settings icon on the Home Screen.
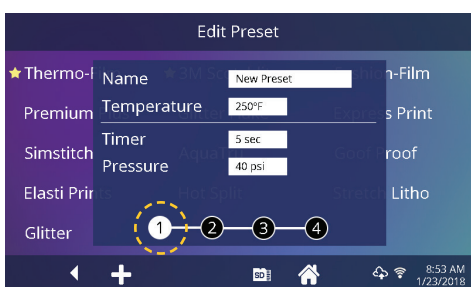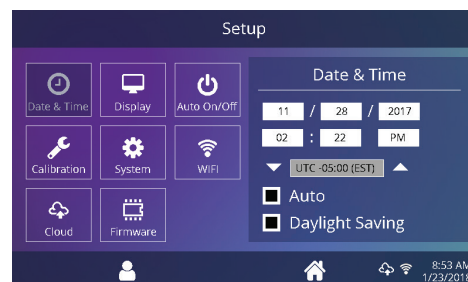
• Touch Auto On/Off, information displays on right of screen (10.1).

• Touch Enable, then On Hour/Minute and Off Hour/Minute,
  selecting Enter between each setting. Once entered,
  touch Check Mark icon on taskbar to save.

NOTE: Standby Mode must be used for the Auto On feature to function (3.2).
The Auto On feature will not work if the power switch (2.1) is in the OFF position.
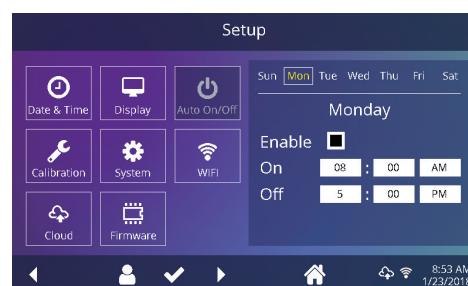
10.1

System Setup (Manager Level Only)

Touch the Settings icon on the Home Screen.

• Select System, information displays on right of screen (11.1).

• Touch Power Save and select time, then touch Check Mark icon
  on taskbar to save.

• When enabled, your heat press will enter Standby Mode if it is not used for the
  specified number of hours.

• Select Target Temp. Press both buttons to lower heat platen.
  Heat press won't count down until it reaches setting temperature.

• Change Shuffle Delay, time will result in a delay for swing after heat printing
  completes.

11.1

Calibration (Manager-Level Only)

Your heat press comes pre-calibrated from the factory. Calibration is only required after sensor or controller replacement. Pressure is periodically self-calibrated. Incorrect calibration can result in poor print results or damage to your heat press which is not covered by warranty.

All FUSION® heat presses have a temperature calibration function (12.1).

- Turn on heat press and heat to 350°F/177°C.
- Place temperature strip on center of platen and press for 5 seconds, or measure center of heater with contact thermocouple (not infrared) thermometer.
- Touch the Settings icon on the Home Screen.
- Touch Calibration, information displays on right of screen.
- Touch Temperature and adjust Temperature Calibration to match Target Temperature.
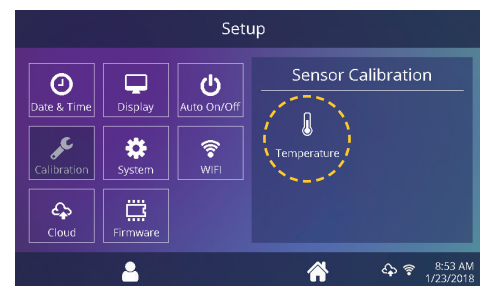
12.1

Updating Software

Touch the Settings icon on the Home Screen.

- When a software update is available, an exclamation point appears after the version number in the Setup Menu (5.2).
- Touch Firmware, information displays on right of screen. An available online update displays a cloud icon (12.2).
- Touch Update File on right of screen, then touch Check Mark icon on taskbar to start download. A downloaded update displays a memory card icon.
- Touch Downloaded Update File on right of screen, then touch Check Mark icon on taskbar to start installation.

NOTE: If a power failure occurs during installation, the heat press will attempt to install the previous software version.
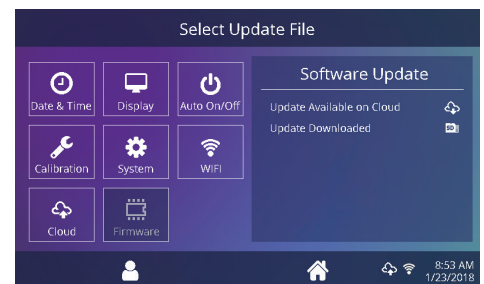
12.2

Create Your Account

- Using a phone or computer, visit **iq.hotronix.com** to create an account (13.1).
- Enter your name, email, and password.
- Click on the confirmation link in the email you receive.
- Your account has been created.

Register a Heat Press

- Click on Manage Heat Presses, then New Heat Press.
- Select heat press type, enter serial number, and enter a name for the heat press (optional).
- Click on Create Heat Press and enter the verification code given.
- On the heat press Setup Menu, touch WIFI and connect to your WIFI router or mobile hotspot (13.2).
- On the heat press Setup Menu, touch the Cloud icon and enter the verification code displayed in the IQ® Portal (13.3).
- Your heat press has been registered.

Create & Assign Users

- Click on Manage Operators, then New User.
- Enter a name and select a privilege level. Managers can access all heat press settings while Users have limited access.
- Click on New User, then Assign Machines in the sidebar.
- Select a machine and click Assign.
- On the heat press Setup Menu, touch the Cloud icon, then Manual Sync (13.4).
- Reporting will show impressions made by the Users.

13.1

13.2

13.3

13.4

120V Version

RTD Probe

1800W Heater - 120V - 50/60Hz

230/240V Version

RTD Probe

1800W Heater - 230/240V - 50/60Hz

Electro-Pneumatic Regulator

Quick Release Switch

Proximity Switch

Print Switch

High Temperature Wire 14ga

High Temperature Wire 14ga

IEC Inlet

Black 14ga

Ground to Frame

White 14ga

Print Switch

Circuit Breaker

Circuit Breaker

Ground to Frame

ON/OFF Switch

Black 14ga

White 14ga

E - STOP   PNEUMATIC REGULATOR   PROBE

PRINT

SWING

PRINT SW

AC EARTH

AC NEU

LINE

FOOT SW

PRINT SW

PROX/SPARE I/O

TRIAC

Ground to Frame

Traic 1

GATE

MT 2

MT 1

Heater1

HTR - LINE

HTR - NEU

HTR - EARTH

White 14ga

Black 14ga

Red 20ga

Print Valve

Swing Valve

Foot Pedal

ITEM #	PART #	PART NAME	QTY
1	1-2197	Air Fusion Control Housing	1
2	1-1971	Cap, Plastic Black 1/2"	2
3	1-2658-P	Fusion IQ Power Board	1
4	1-2473	Fusion IQ Power Bracket	1
5	3-1011-235	Screw, Sheet Metal #6 x 1/2"	6
6	1-2474	Fusion IQ Latch	2
7	—	Spring, 1/4" x 1", 1.7lbs/in	2
8	1-2658-F	Fusion IQ Controller	1
9	1-2198-1	Fusion Overlay NextGen	1
10	1-2386	Touchscreen Stylus Holder	1
11	1-2385	Touchscreen Stylus	1
12	1-2319	Button, White, Print Switch	2
13	1-2270	Button, Red, Quick Release	1
14	1-2087	Power Switch	1
15	1-2423	Chevron Cover Plate	1
16	3-1011-19	Screw, Machine #6-32 x 1/2"	4
17	2-1006-50	Nut, #6-32 Hex with Lockwasher	3
18	3-1011-155	Screw, Machine #8-32 x 3/4"	3
19	3-1341	Air Fusion Upper Casting	1
20	1-2268	Bearing, Tapered Cup	2
21	1-2464-1	TRIAC	1
22	1-2282	Bushing, Flange 1in	1
23	1-2264	Air Cylinder 6in	1
24	3-1011-104	Screw, Button Socket Head 5/16"-18 x 1"	8
25	2-1006-96	Nut, Hex 1"-12	1
26	2-1006-94	Washer, 1in Nord-Lock	1
27	4-1015-12	Air Fitting, Elbow 1/4" NPT x 1/4" Tube	5
28	1-2302	Air Fusion Shock Stop Plate	1
30	1-1048-3	Washer, 1/2" Nylon	2
31	1-2308	Air Fusion Rocker Arm	1
32	3-1011-276	Screw, Shoulder 1/2" x 1" w/ 3/8"-16 Thread	1
33	1-2280	Bearing, 6900 Double Shielded	1
34	1-1018-1	Pin, Spring 3/8" D x 3/4" LG	1
35	1-2300	Shock Absorber	1
36	1-2289	Bearing, 1/2" Needle	1
37	3-1011-217	Screw, Machine #10-24 x 1/2"	4
38	1-1063	Washer, Plastic Finishing	4
39	1-2263	Air Fusion Heater Cover	1
40	1-2256	Insulation 16 x 20	1
41	1-2286	C-Clip	1
42	1-2290	Guide Tube, XRF & XRF2	1
44	3-1011-100	Screw, Socket Head 5/16"-18 x 3/4"	1
45	3-1011-43	Screw, Socket Head 3/8"-16 x 1"	1
47	3-1011-87	Screw, SS Phillips #8-32 X 1/4"	1
48	1-1272-1	Temperature Probe	1
49	3-6968	Thermostat Disc	1
50	3-1011-98	Screw, SS Sheet Metal #4 X 1/4"	2
51	2-1002-3HW	Heat Platen 16 x 20 3500 W Milled (No Ears)	1
52	3-1011-245	Screw, Socket Head Cap Low Profile 1/4-20 X 3/4"	8
53	3-1011-22	Screw, Machine #4-40 x 3/8"	2
54	2-1006-51	Nut, #4-40 with Tooth Washer	2
55	1-1211	Proximity Switch	1
56	1-2307	Chain 04B	1
57	1-2306	Sprocket, 22 Tooth 04B	1
58	1-2269	Pneumatic Package, Air Fusion	1
61	1-2421	Screw, Sheet Metal Hex #8 x 1/2"	4
62	1-2417	Screw, M4x0.7 x 8 Pan Phillips	5
63	1-2299	Print Valve	1
64	1-2427	Air Fitting, Straight Hex 1/4" NPT 1/4" Tube	3

ITEM #	PART #	PART NAME	QTY
65	1-2418	Air Fitting, Muffler, 1/8" NPT	2
66	1-2339	Speed Control Muffler	1
67	1-2419	Air Fitting, Check Valve, 1/4" Push-to-Connect	1
68	—	Screw, Pan Phillips M3x05 x 6mm	2
69	1-2298	Swing Valve	1
70	1-2428	Air Fitting, Elbow Restrictor #10-32 UNC 5/32" Tube	2
71	1-2350	Air Fitting, Elbow #10-32 UNF 5/32" Tube	6
72	1-2293	Electro-Pneumatic Regulator	1
73	1-2420	Air Fitting, Tee, 1/4" Push-to-Connect	1
74	1-2297	Pneumatic Regulator, Mini	1
75	1-2430	Air Fitting, Elbow #10-32 UNF 1/4" Tube	1
76	3-1011-164	Screw, Button Socket Head #10-32 x 1/2"	6
77	1-2296	Rotary Actuator	1
78	1-2429	Grommet, 5/16" ID 1/2" OD	1
88	1-1274	Air Tubing, 1/4" Polyurethane	1
89	3-1340	Air Fusion Bottom Casting	1
90	1-2332-1	Quick Release Clamp, Air Fusion	1
91	1-2284	Air Fusion Stop Plate	1
92	2-1670	Air Fusion Spindle	1
94	—	Screw, Button Socket Head 5/16"-18 x 1-1/8"	8
95	1-2267	Bearing, Tapered Roller Cone	2
96	2-1006-95	Spanner Nut 2in-18	1
97	1-2281	Bearing, 6002	1
98	1-2306-1	Sprocket, 32 Tooth 04B	1
99	—	Air Fusion Proximity Magnet Bracket	1
100	1-2285	Grommet, 3/8" ID 3/4" OD	1
101	1-2311	Proximity Magnet, Miniature	1
102	3-1011-278	Screw, Machine #4-40 x 1/4"	2
103	1-2287	Bearing Shield	1
104	—	Air Fusion IO Panel, IEC Inlet	1
105	1-1331	Circuit Breaker 20A (STX XF XRF)	2
106	—	Power Inlet and Filter, 15A 120V	1*
106	1-2490	Power Inlet and Filter, 20A 240V	1*
107	3-1011-25	Screw, Machine #6-32 x 1/4"	4
108	—	Air Fusion IO Panel, Air Pedal and Breaker	1
109	Kit 1-2305	Foot Pedal Socket (Part of Foot Pedal Assembly)	1
110	-	Air Fitting, Elbow Bulkhead 1/4" Tube	1
111	—	Filter Regulator Bracket	1
112	3-1011-266	Screw, Hex Head 1/4"-20 x 2"	2
113	2-1006-7	Nut, Hex 1/4"-20 Nylok	2
114	1-1215	Air Filter & Regulator	1
115	1-1788	Air Fitting, 1/4" ARO Male Coupling 1/4" NPT	1
116	—	Sprocket Spacer	1
117	—	Magnet, Neodymium 0.50 x 0.25 w/ #4 Countersinks	1
118	—	Screw, Countersunk #6-32 x 3/8" Stainless	1
119	2-1029	Platen, 16x20	1
120	1-2136	Silicone Pad 16 x 20 Blue	1
121	3-1336	Adapter Plate	1
122	1-2215	Quick Release Pin	1
123	2-1006-25	Washer, Flat 1/4" SAE	4
124	2-1006-44	Washer, Split Lock 1/4"	4
125	3-1011-191	Screw, Socket Head Cap 1/4"-20 x 1"	4
127	1-2291	Pedestal Stand Assembly	1
143	1-2262	Self-Leveling Stem Caster	4
149	2-1006-10	Nut, Hex 3/8"-16 Nylok	4
150	1-2324	Air Fusion Tabletop Stand	1
151	1-2329	Foot, Rubber Suction Cup with Stud, 5/16"-18	4
152	1-2186	Power Cord	1
154	Kit 1-2305	Foot Pedal Assembly	1

Verschleißteile
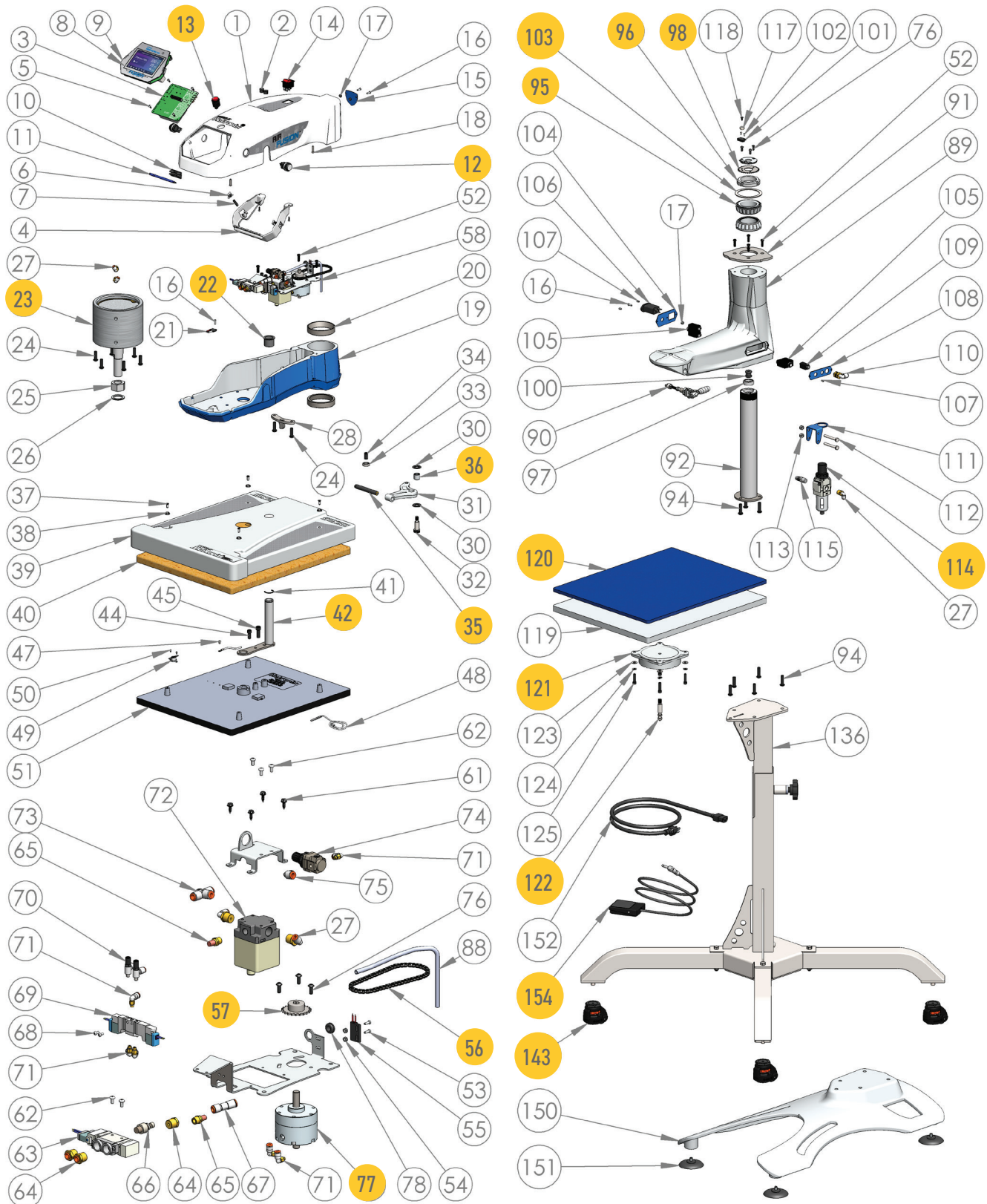
CE Certification:

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 STAHLS' Hotronix® Division, we state as European Commissioners, that our product

A Transfer Press for ironing of thermo application, Model: AirFusion IQ®

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 requirment for ironers
- EN 60335-2-44:2002 + AMD1:2008 + AMD2:2012 Safety of household and similar electrical appliances-safety Part 2-44: particular requirment 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.
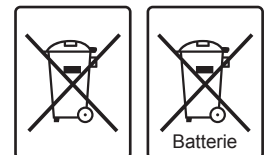
It is possible that not all the listed norms apply to the above mentioned product.

STAHLS' Europe GmbH

(Stephanie Schnur, Managing Director, STAHLS' Europe GmbH)

WEE and RoHS Symbols

STAHLS' 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. STAHLS' 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 STAHLS' heat presses are identifiable, all heat press machines supplied by STAHLS' Europe GmbH will have the logo/brand of STAHLS' Hotronix clearly marked upon them.

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