MERCHMAKER®

Start Making Merch Like a Pro.

OPERATOR'S MANUAL

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MERCHMAKER®
Start Making Merch Like a Pro.

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.
6. Allow heat press to cool completely before storing.
7. 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.
8. 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.
9. Close supervision is necessary for any heat press being used by or near children. Do not leave equipment unattended while connected.
10. Burns can occur when touching hot metal parts.
11. To reduce the likelihood of circuit overload, do not operate other high voltage equipment on the same circuit.
12. 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.
13. Clean exposed surfaces with a damp cloth to prevent dust build-up, which could lead to overheating.
14. All other maintenance and service should be performed by an authorized service representative.

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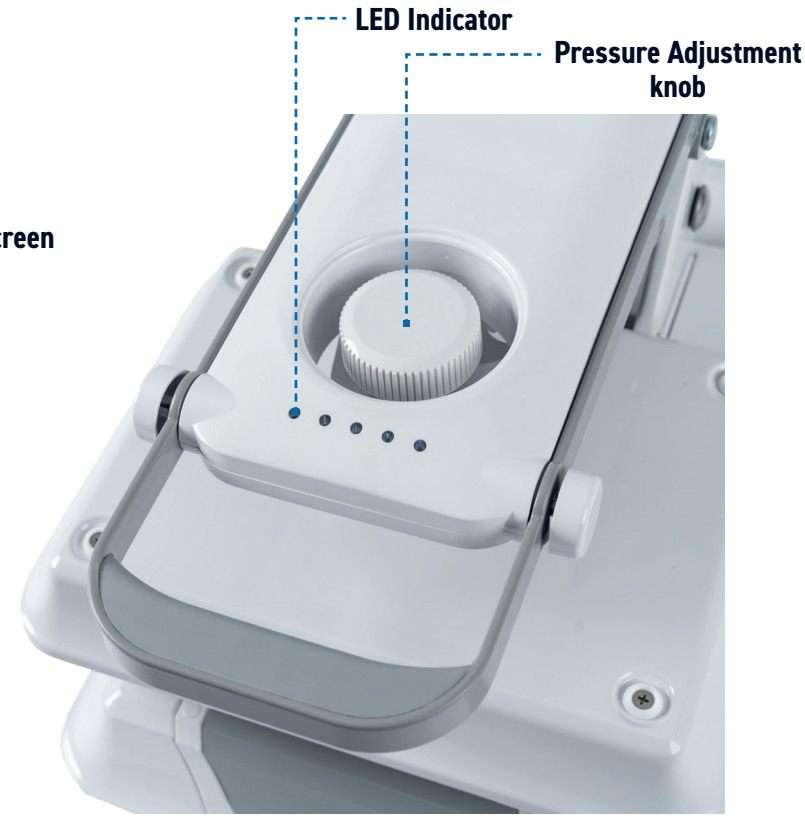
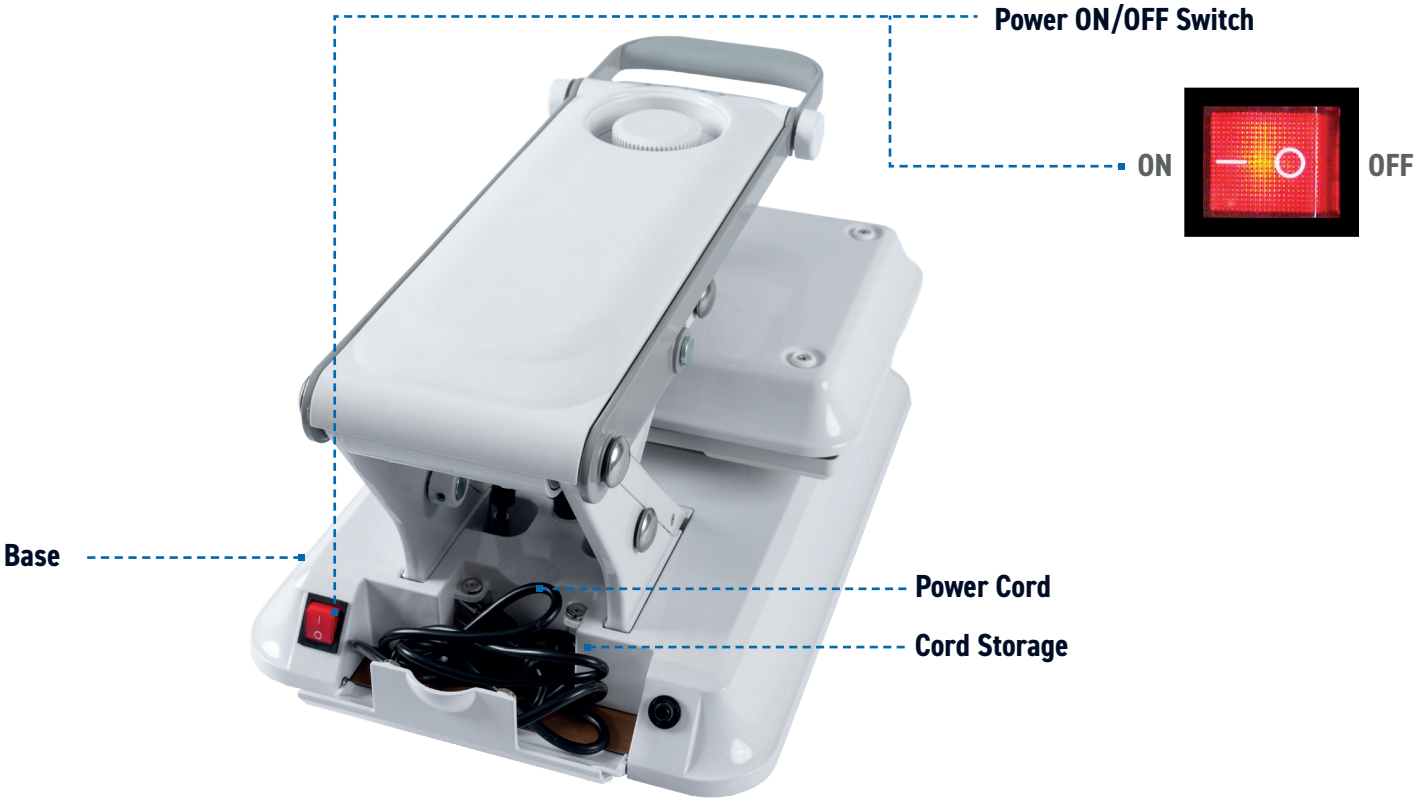
MERCHMAKER®

Machine View





Initial Setup

- To avoid burns, do not touch the heated platen during use.
- Keep hands clear from the heater of the press during heater lock down as the pressure may cause injury.
- Keep the work area clean, tidy, and free of obstructions. This guide is created with the user in mind. Carefully follow the step-by-step instructions for best results:

1. Connect the power cord into a properly grounded 120-volt/240-volt (for 240-V version) electrical outlet with a minimum 10-amp rating.

- If used, a minimum 16-gauge 10-amp extension cord is required.
- Power supply cord must be disconnected before cleaning or servicing press.

2. Turn the Power Switch "ON" located on the back of the heat press. Ensure that the lever arm is not locked, and the heater is completely unclamped (open position).

3. Calibrating the heat press (ONLY if needed):

- Ensure the time/temperature controls are unlocked (refer to section Additional Controller Settings below).
- Press and hold the left and right buttons together for 3 seconds to open the calibration window displayed on the screen.
- Use the left knob to adjust the temperature to calibrate and press the left button to save calibration.
- Press and hold the right button for 3 seconds to lock the settings once calibrated.

Adjusting Settings

Recommended settings vary based on the garment material and type of transfer product used. Please consult the instructions or specifications that came with your transfer product for appropriate temperature and time settings.

- **Temperature** is adjusted by rotating the left knob to the desired temperature setting. Temperature can be adjusted in 1°F/1°C increments. Counterclockwise rotation of the left knob increases the temperature.

- **Time** controls the amount of heat transferred to the ink or adhesive. Time is adjusted by rotating the right knob to the desired time setting. Time can be adjusted in 1 sec. increments. Clockwise rotation of the right knob increases the time.

- **Pressure** is adjusted using the pressure adjustment knob (center spindle), no matter how thick the garment is. Clockwise rotation of the pressure knob increases the pressure. The pressure adjustment controls pressure from low to high.

Additional Controller Settings

- Press and hold the right button for 3 seconds to lock/unlock time/tem perature settings. This will help the user avoid unintended changes to the time and temperature during operations.

- Press and hold the left button for 3 seconds to toggle between °F and °C. Lasting, durable prints can be easily achieved when observing the above essential recipe parameters.

Printing with your Heat Press

Unlock the time/temperature settings by pressing and holding the right knob for 3 seconds.
Set the desired temperature and time using the left and right knob respectively.
Press and hold the right knob for 3 seconds to lock the settings.
Once the Heat Press has reached the designated temperature, pull the lower platen out to position the garment on the lower platen, centering the transfer area on the platen for best results.

Operating Instructions

Pull out the lower platen and align the transfer material on the garment to be printed and push in the lower platen all the way.
Pull out the lower platen using the slider to gain access to the garment.

NOTE: Depending on the transfer product, you may need to peel off the transfer carrier while it is still hot, or it may be necessary to wait until it has cooled before peeling it off.

Some transfer products recommend a “pre-press” to heat and flatten the garment before printing. Push the lower platen in all the way and adjust the pressure to desired pressure using the pressure adjustment knob and lower the lever arm until the heater locks into the press position. Lift open the lever arm once “pre-press” is complete.

Lower the lever arm fully until the heater locks into the press position. This will start the countdown and the LED indicator on the top cover will be lit up per the adjusted time. At the end of the heat cycle (when time has elapsed), there will be a sound indicator indicating user to lift open the lever arm.

Storage and Transportation

WARNING: Allow heat press to cool before moving or placing in storage

Wrap the power cord and place it in the cord storage provided on the back side of the heat press.

Ensure that the lever arm is in the locked position, the pressure is adjusted to bare minimum (maintain slight contact between lower platen and heater) and the lower platen is pushed all the way in, before placing the heat press in the box.

To fit the heat press back in its original packaging, lift the heat press (while in locked position) carefully holding the end of the lever arm on the back and lower platen on the front.
NOTE: Be careful to not slide out/open the lower platen or lift open the lever arm while lifting the heat press.

Storage and Transportation

Place the press in the box carefully, ensuring that the press sits on the bottom foam completely.

Slide in the two side foam pieces to hold the heater cover.
Place the top foam to cover the heat press and close the box.

NOTE: When the heat press is stored or not in use, adjust the pressure to bare minimum (maintain slight contact between lower platen and heater) to keep the pressure buildup less between parts.

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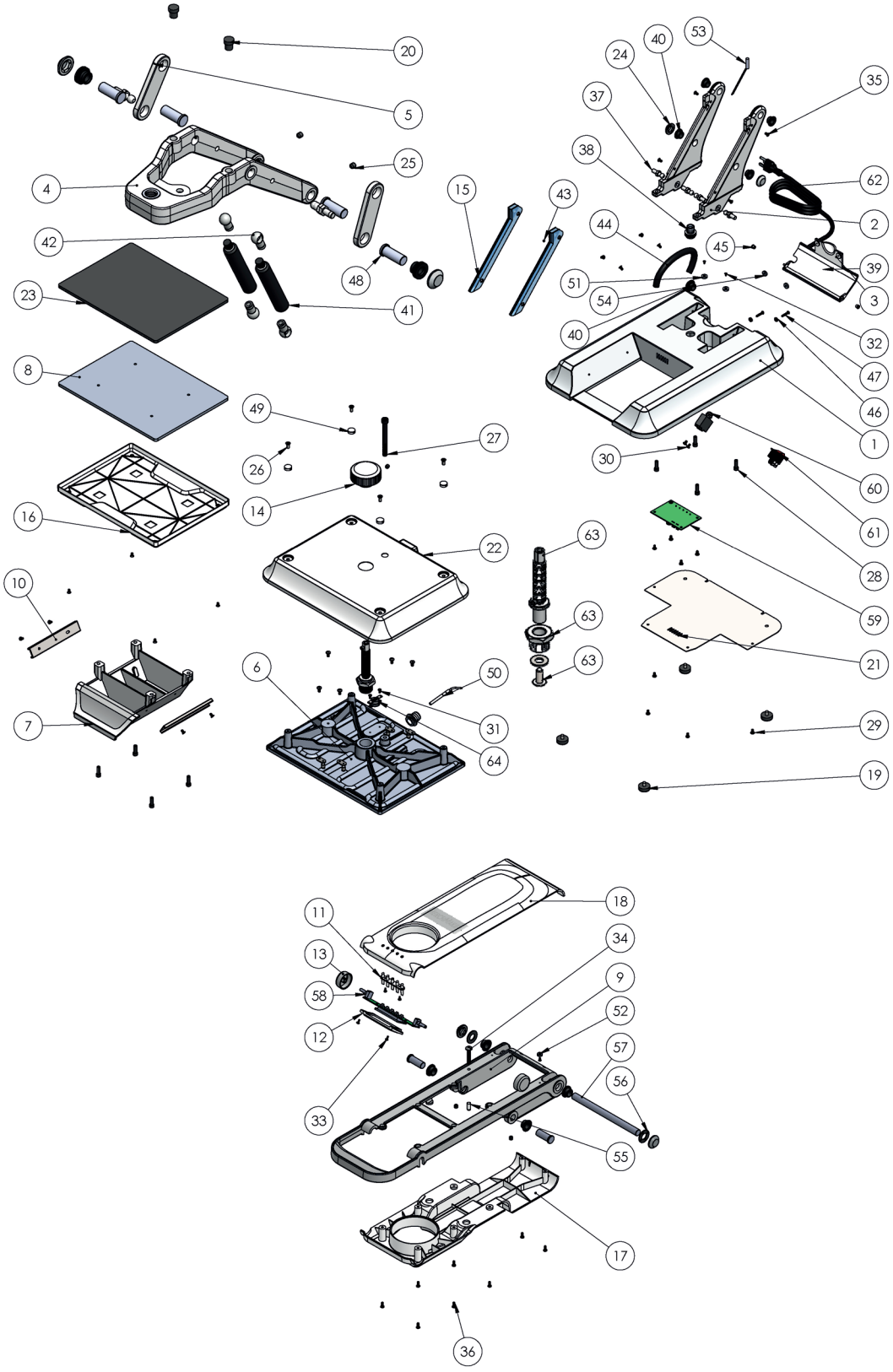
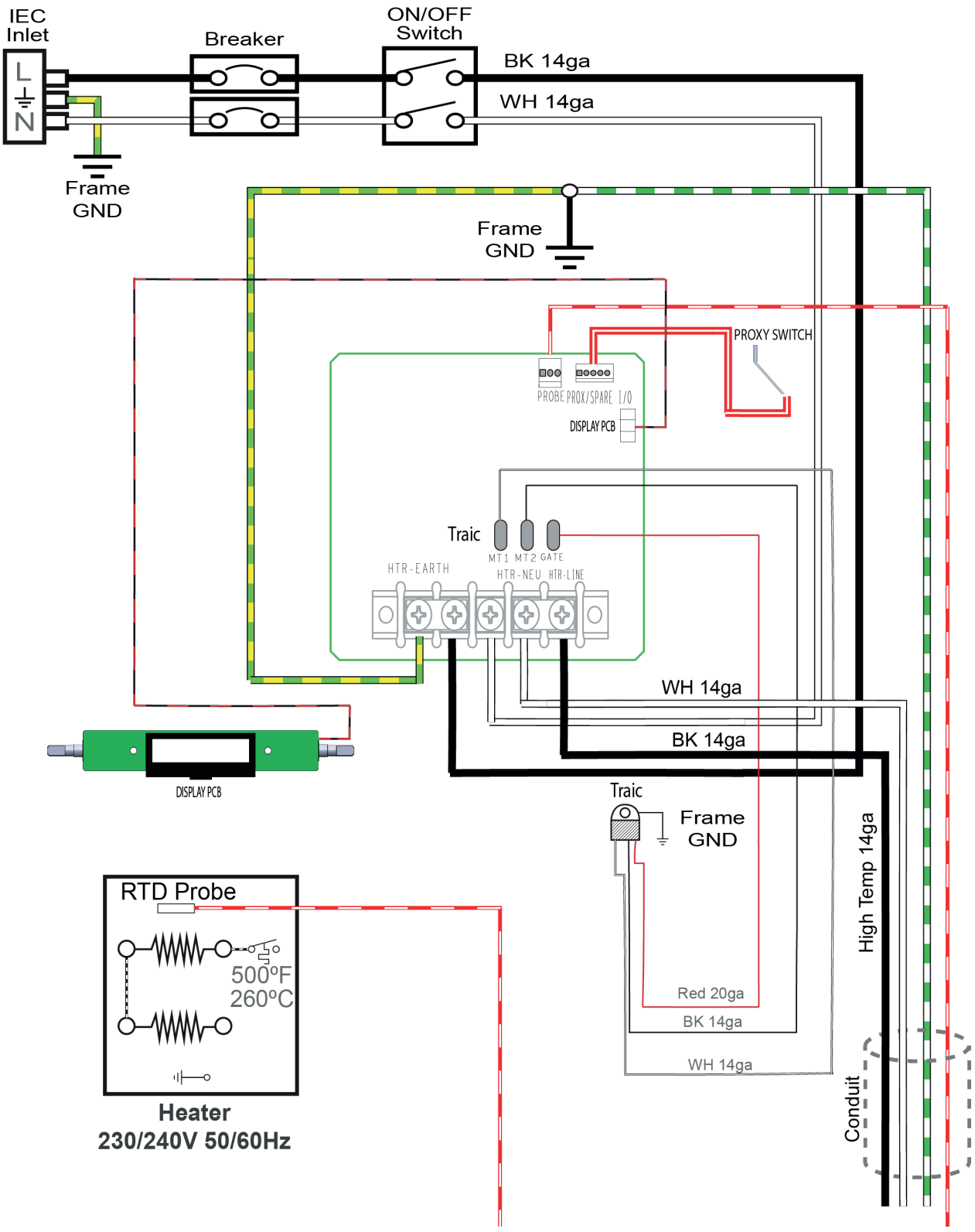
Replacement Part List

ITEM #	PART NAME	PART #	QTY
1	PROJECT 912 BASE	2-1709	1
2	PROJECT 912 FIN	2-1710	2
3	PROJECT 912 CORD COVER	2-1711	1
4	Project 912 Heater Arm	2-1712	1
5	PROJECT 912 LINKAGE	2-1713	2
6	CP2_9x12 Upper Heater	2-1690	1
7	PROJECT 912 Lower Molding	2-1714	1
8	platen 9x12	2-1715	1
9	912 LEVER ARM	2-1716	1
10	Drawer Slide Set 5 inch	2-1717	1
11	LIGHT_GUIDE	1-2706	1
12	LENS	1-2707	1
13	HANDLE_KNOB	1-2708	2
14	PRESSURE KNOB	1-2709	1
15	PROJECT 912 FIN COVER	2-1718	2
16	project 912 platen cover	2-1719	1
17	912 BOTTOM_COVER	2-1720	1
18	912 TOP_COVER	2-1721	1
19	Rubber Foot	1-2710	4
20	Rubber Foot Small	1-2711	2
21	PROJECT 912 BASE PLATE	2-1722	1
22	Project 912 Heater Cover	1-2712	1
23	Silicone Pad grey 9x12x0.25	1-2713	1
24	Hub Cap 1/2"	1-2714	6
25	Set Screw, 1/4"-20 x 1/4"	-	7
26	Self tapping Screw, Flat Head Phillips #10-24 x 1/2"	3-1011-217	4
27	Screw, Socket Head Cap 5/16"-18 x 3"	-	1
28	SHCS 0.250-20 x 0.750	-	8
29	316 Stainless Steel Pan Head Phillips Screw, Super-Corrosion-Resistant, 8-32 Thread Size, 5/16" Long	-	13
30	316 Stainless Steel Pan Head Phillips Screw, Super-Corrosion-Resistant, 8-32 Thread Size, 1/4" Long	-	2
31	316 Stainless Steel Pan Head Phillips Screw, Super-Corrosion-Resistant, 4-40 Thread Size, 1/4" Long	-	2
32	Phillips Flat Head Thread-Cutting Screw for Metal, Zinc-Plated Steel, 4-40 Thread, 1/4" Long	-	3
33	Phillips Rounded Head Thread-Forming Screws for Plastic, Zinc-Plated Steel, Number 4 Size, 1/4" Long	-	4
34	316 Stainless Steel Pan Head Phillips Screw, Super-Corrosion-Resistant, 1/4"-20 Thread Size, 1-3/8" Long	-	1
35	Passivated 18-8 Stainless Steel Phillips Flat Head Screw, 82 Degree Countersink, 8-32 Thread, 5/16" Long, Undercut	-	16
36	Zinc-Plated Steel Pan Head Phillips Screw, 6-32 Thread, 3/8" Long	-	8
37	Ball Stud for Gas Spring, 1.19" Overall Length	1-2715	4
38	Metal Conduit Fitting 0.500	1-2716	2
39	heyco_1839	-	1

ITEM #	PART NAME	PART #	QTY
40	Flange Bushing 0.5 inch	-	10
41	Gas Spring, 5.9" Extended Length, 30 lbs	1-2717	2
42	End Fitting for Gas Spring, Ball Socket	1-2718	4
43	18-8 Stainless Steel Cup-Point Set Screw, 8-32 Thread,1/8" Long	-	1
44	flexible conduit 1/2" diameter, 7" long Black Color	1-2719	1
45	Sleeve Bearing Flanged, for 1/8" Shaft Diameter and 1/4" Housing ID, 1/4" Long	-	2
46	Mil. Spec. Low-Strength Steel Hex Nut, 6-32 Thread Size, MS35649-262	-	2
47	Zinc-Plated Steel Pan Head Phillips Screw, 6-32 Thread, 3/4" Long	-	2
48	clevis pin 912	-	6
49	White Washer Plastic Finishing Heater Cover	1-2720	4
50	Temperature Probe	1-2721	1
51	Neodymium Ring Magnet 1/2inch ODx1/8 inch Thick	1-2722	2
52	Neodymium Ring Magnet 3/8" OD x1/8inch Thick	1-2723	1
53	Firecracker Proximeter Switch	1-2724	1
54	ZInc Plated Steel Washer M4-D12x3mm	1-2725	2
55	rubber cap	-	1
56	Teflon Washer (1)	-	2
57	Shaft Pin, 0.5" diameter with (-0.007",-0.005") tolerance and 6.720" length (-0.005",0) tolerance. Zinc Plated.	-	1
58	DISPLAY_PCB	1-2726	1
59	Power Board 912 A	1-2727	1
60	Breaker 10A	1-2728	1
61	Power Switch	1-2729	1
62	Power Cord Flying Leads (1600 mm long, 3 prongs, 0.25" dia., 10A/5A 125V/250V USA	1-2730	1
	Power Cord Flying Leads (1600 mm long, 3 prongs, 0.25" dia., 10A/5A 125V/250V UK	1-2731	1
	Power Cord Flying Leads (1600 mm long, 3 prongs, 0.25" dia., 10A/5A 125V/250V EURO	1-2732	1
63	Spindle /BushingSet	1-1285/ 2-1081	1
64	Thermal discs	1-2733	1
65	Wire kits 912	1-2734	1
66	Triac 912	1-2735	1
67	Wool insulation 912	-	1
68	Foam 912	1-2736	1
69	Packaging 912	1-2737	1

Parts Location Guide




IEC Inlet
L
N
Breaker
ON/OFF Switch
BK 14ga
WH 14ga
Frame GND
Frame GND
PROXY SWITCH
PROBE
PROX/SPARE I/O
DISPLAY PCB
Traic
MT1 MT2 GATE
HTR-EARTH
HTR-NEU HTR-LINE
WH 14ga
BK 14ga
DISPLAY PCB
Traic
Frame GND
High Temp 14ga
RTD Probe
500°F
260°C
Red 20ga
BK 14ga
WH 14ga
Conduit
Heater
230/240V 50/60Hz

MACHINERY DIRECTIVE,
ELECTROMAGNETIC COMPATIBILITY DIRECTIVE
ATTESTATION OF CONFORMITY

Technical file of the company mentioned below has been inspected and audit has been completed successfully.
2006/42/EC Machinery Directive has been and 2014/30/EU Electromagnetic Compatibility has been taken as referances for these processes.

Company Name	: **Rongxing (Xi'an) Mechanical Technology Co., Ltd**
Company Address	: 2nd Floor (Factory), No.9 Building, China Electronics Industrial Park in Xi'an No.1288, 10th Caotan Road, Xi'an Economic and Technological Development District, Xi'an City, Shaanxi Province, China, Zip 710018
Related Directives and Annex	: **2006/42/EC Machinery Directive / Annex VIII** **2014/30/EU Electromagnetic Compatibility Directive / Annex II**
Related Standards	: **EN ISO 12100:2010; EN ISO 13849-1:2015; EN ISO 13849-2:2012** **EN 60204-1:2018; EN IEC 62368-1:2020+A11:2020** **EN IEC 61000-6-2:2019; EN IEC 61000-6-4:2019**
Product Name	: **Heat Press Machine**
Report No and Date	: J71-XRX-21992 / May 28, 2024
Product Brand/Model/Type	: MM912, MM15, MM20

Certificate Number	: **M.2024.206.C101775**
Initial Assessment Date	: 06.06.2024
Registration Date	: 07.06.2024
Reissue Date/No	: -
Expiry Date	: **06.06.2029**

UDEM International Certification
Auditing Training Centre Industry and Trade Inc. Co.
Mustafa MEMiSOGLU
General Manager

The validity of the certificate can be checked trough www.udem.com.tr. Upon completion of EC declaration of conformity, it is used solely at the manufacturer's responsibility. This certificate remains the property of UDEM International Certification Auditing Training Centre Industry and Trade Inc. Co. to whom it must be returned upon request. The above named firm must keep a copy of this certificate for 15 years from the registration of certificate. This certificate only covers the product(s) stated above and UDEM must be noticed in case of any changes on the product(s).

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E-mail: info@udem.com.tr www.udem.com.tr

S/N: 009072

Verification of Conformity

No.: **ICR/VC/HYT240601**

Name and address of Applicant	Rongxing (Xi'an) Mechanical Technology Co., Ltd 2nd Floor (Factory), No.9 Building, China Electronics Industrial Park in Xi'an No.1288, 10th Caotan Road, Xi'an Economic and Technological Development District, Xi'an City, Shaanxi Province, China, Zip 710018
Name and address of manufacturer:	Rongxing (Xi'an) Mechanical Technology Co., Ltd 2nd Floor (Factory), No.9 Building, China Electronics Industrial Park in Xi'an No.1288, 10th Caotan Road, Xi'an Economic and Technological Development District, Xi'an City, Shaanxi Province, China, Zip 710018
Product name:	Heat Press Machine
Product types:	MM912, MM15, MM20
Product trademark:	n/a

This document confirms that the product sample meets the requirements of the following standards:

- Related with Supply of Machinery (Safety) Regulations 2008 and Electromagnetic Compatibility Regulations 2016/1091:
  BS EN ISO 12100:2010
  BS EN ISO 13849-1:2015
  BS EN ISO 13849-2:2012
  BS EN 60204-1:2018
  BS EN IEC 62368-1:2020+A11:2020

  BS EN IEC 61000-6-2:2019
  BS EN IEC 61000-6-4:2019

The assessment process has been carried out in accordance with individual rules and conditions agreed with the applicant. Evaluation has been carried out in accordance with:

Test report:	J71-XRX-21995
Tests conducted by:	Rongxing (Xi'an) Mechanical Technology Co., Ltd
Issue date:	05.06.2024
Expiration date:	04.06.2029

Remarks

This Verification of conformity refers to the above mentioned product and its conformity in regards of above mentioned standard(s) was proven on test sample.

This Verification of conformity was issued on voluntary basis and does not imply meeting all essential requirements, assessment of the series-production or any other restricted UK Conformity Assessment Bodies conformity assessment procedure appropriate for the product.

UKCA marking remarks:
- mark is not sanctioned by the following verification of conformity
- mark given here as reference, can be only use by the manufacturer after applying all essential requirements from relevant directives and/or regulations

document status can be checked: https://cert.icrpolska.com/

CEO, ICR Co., Ltd.
Warsaw, 05.06.2024

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VERIFICATION OF CONFORMITY

S/N: 009073

No.: **ICR/VC/HYT240602**

Name and address of Applicant	Rongxing (Xi'an) Mechanical Technology Co., Ltd 2nd Floor (Factory), No.9 Building, China Electronics Industrial Park in Xi'an No.1288, 10th Caotan Road, Xi'an Economic and Technological Development District, Xi'an City, Shaanxi Province, China, Zip 710018
Name and address of manufacturer:	Rongxing (Xi'an) Mechanical Technology Co., Ltd 2nd Floor (Factory), No.9 Building, China Electronics Industrial Park in Xi'an No.1288, 10th Caotan Road, Xi'an Economic and Technological Development District, Xi'an City, Shaanxi Province, China, Zip 710018
Product name:	Heat Press Machine
Product types:	MM912, MM15, MM20
Product trademark:	n/a

Verification was carried within following scope:

Information on the Declaration of Conformity:

Result:	**Legislation:**	**Standard:**	
✓	REACH [(EC) 1907/2006]	EN 14362-1:2012	
		EN 14362-3:2012	
		EN ISO 17353:2005	
		EN 14582:2007	
		EN 62321-6 :2015	
✓	—	EPA 3540C:1996	EPA 8270D:2014
		EPA 8061A:1996	EPA 3052:1996
		EPA 3060A:1996	EPA 9056A:2007
		EPA 5021:1996	EPA 6010D:2014
		EPA 8061A:1196	EPA 8270D:2014
		EPA 3550C:2007	EPA 3050B:1996

The assessment process has been carried out in accordance with individual rules and conditions agreed with the applicant.
Evaluation has been carried out in accordance with:

Test report:	J71-XRX-21993
Tests conducted by:	Rongxing (Xi'an) Mechanical Technology Co., Ltd
Issue date:	05.06.2024
Expiration date:	04.06.2029

Remarks:

- VoC was issued on voluntary basis and does not imply meeting all essential requirements listed in Declaration of Conformity.
- For introducing this product on European market may be needed EC/EU-type examination conducted by appropriate Notified Body.

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VERIFICATION OF CONFORMITY

S/N: 009074

No.: **ICR/VC/HYT240603**

Name and address of Applicant	Rongxing (Xi'an) Mechanical Technology Co., Ltd 2nd Floor (Factory), No.9 Building, China Electronics Industrial Park in Xi'an No.1288, 10th Caotan Road, Xi'an Economic and Technological Development District, Xi'an City, Shaanxi Province, China, Zip 710018
Name and address of manufacturer:	Rongxing (Xi'an) Mechanical Technology Co., Ltd 2nd Floor (Factory), No.9 Building, China Electronics Industrial Park in Xi'an No.1288, 10th Caotan Road, Xi'an Economic and Technological Development District, Xi'an City, Shaanxi Province, China, Zip 710018
Product name:	Heat Press Machine
Product types:	MM912, MM15, MM20
Product trademark:	n/a

Verification was carried within following scope:

Information on the Declaration of Conformity:

Result:	**Legislation:**	**Standard:**	
✓	RoHS [2011/65/EU]	EN IEC 63000:2018	
		EN 62321-1:2013	[idt IEC 62321-1:2013]
		EN 62321-2:2014	[idt IEC 62321-2:2013]
		EN 62321-3-1:2014	[idt IEC 62321-3-1:2013]
		EN 62321-3-2:2014	[idt IEC 62321-3-2:2020]
		EN 62321-4:2014+A1:2017	[idt IEC 62321-4:2013+A1:2017]
		EN 62321-5:2014	[idt IEC 62321-5:2013]
		EN 62321-6:2015	[idt IEC 62321-6:2015]
		EN 62321-7-1:2015	[idt IEC 62321-7-1:2015]
		EN 62321-7-2:2017	[idt IEC 62321-7-2:2017]
		EN 62321-8:2017	[idt IEC 62321-8:2017]

The assessment process has been carried out in accordance with individual rules and conditions agreed with the applicant.
Evaluation has been carried out in accordance with:

Test report: J71-XRX-21994

Tests conducted by: Rongxing (Xi'an) Mechanical Technology Co., Ltd

Issue date: 05.06.2024

Expiration date: 04.06.2029

Remarks:

- VoC was issued on voluntary basis and does not imply meeting all essential requirements listed in Declaration of Conformity.
- For introducing this product on European market may be needed EC/EU-type examination conducted by appropriate Notified Body.

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MerchMaker
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REV. 0624