



MERCHMAKERTM

Start Making Merch Like a Pro.

OPERATOR'S MANUAL



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-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.
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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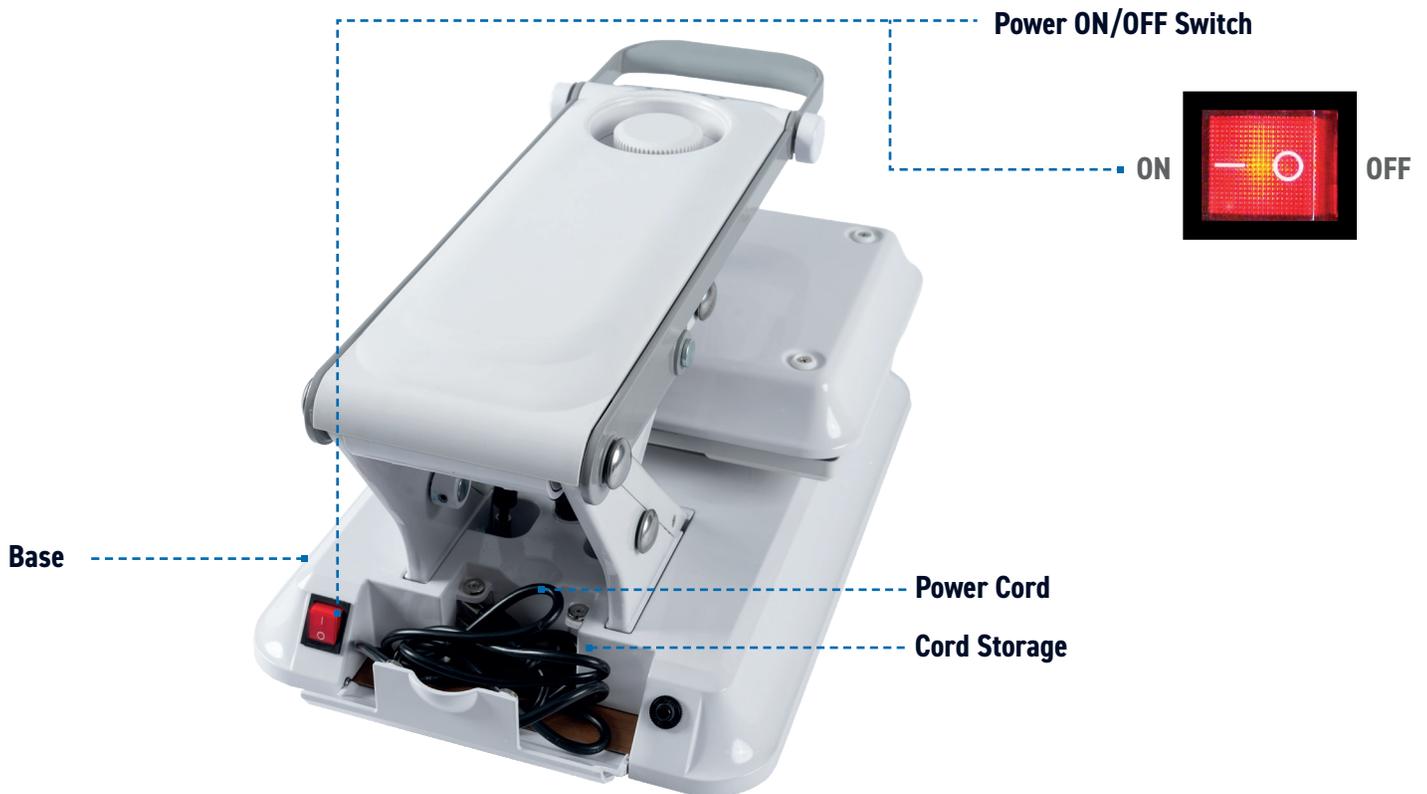
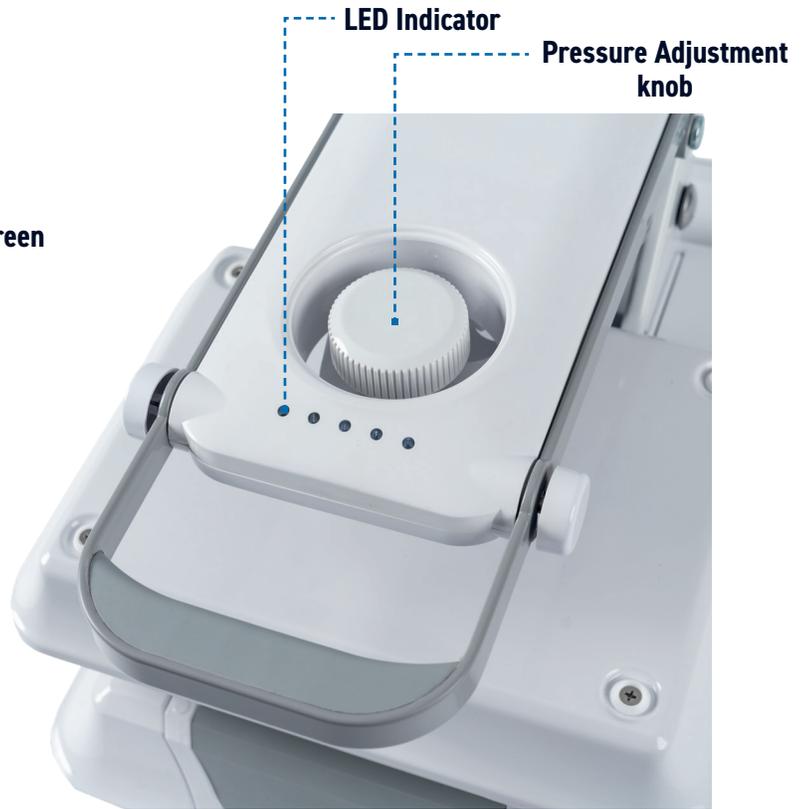
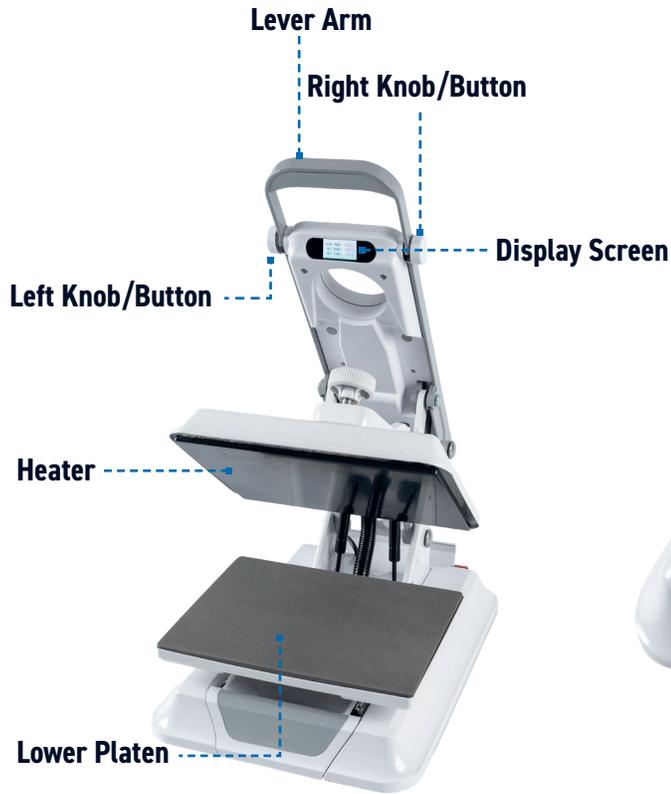
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MERCHMAKER®



Operating Instructions

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/temperature 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.



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.



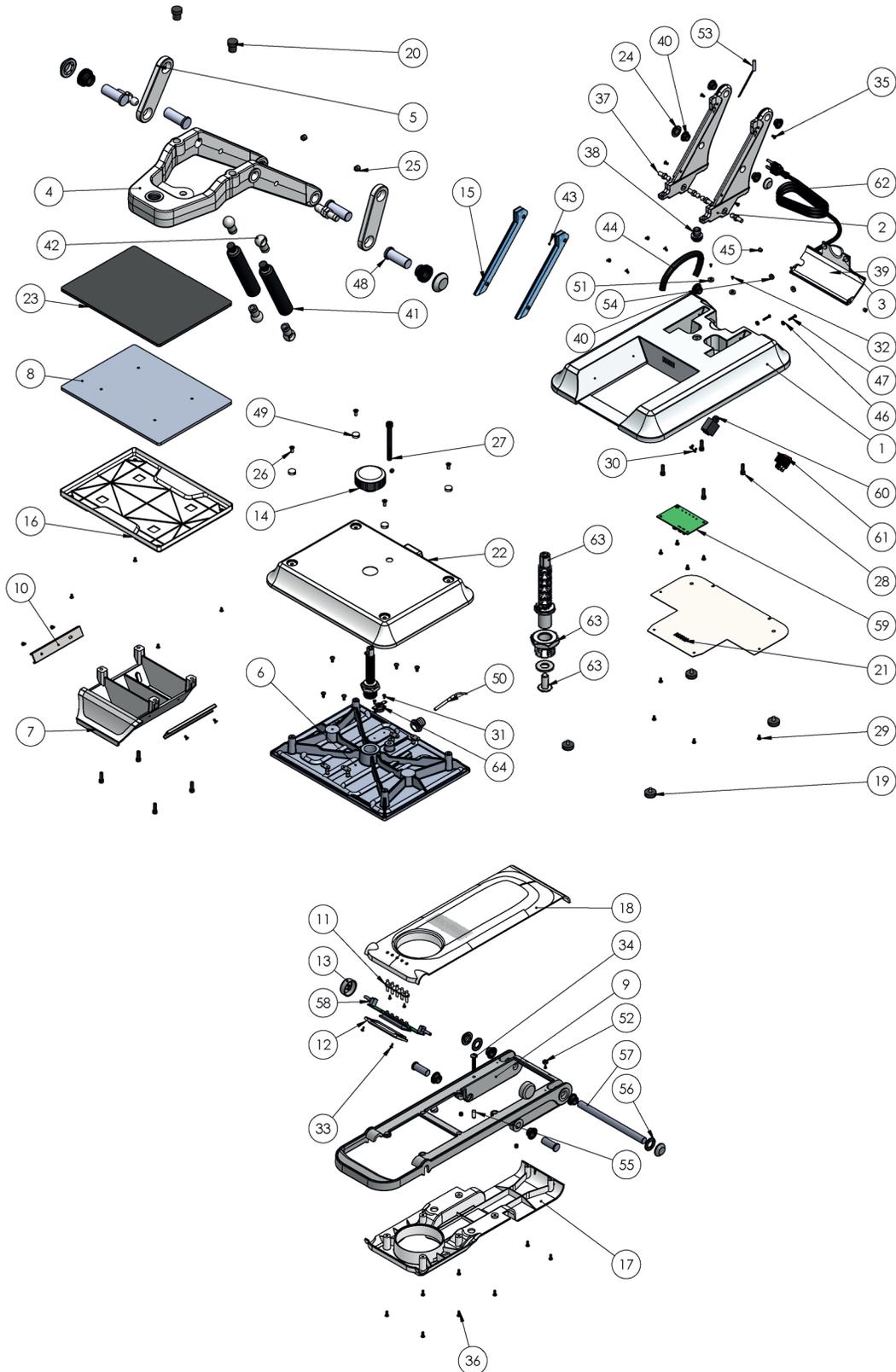
Slide in the two side foam pieces to hold the heater cover.
Place the top foam to cover the heat press and close the box.

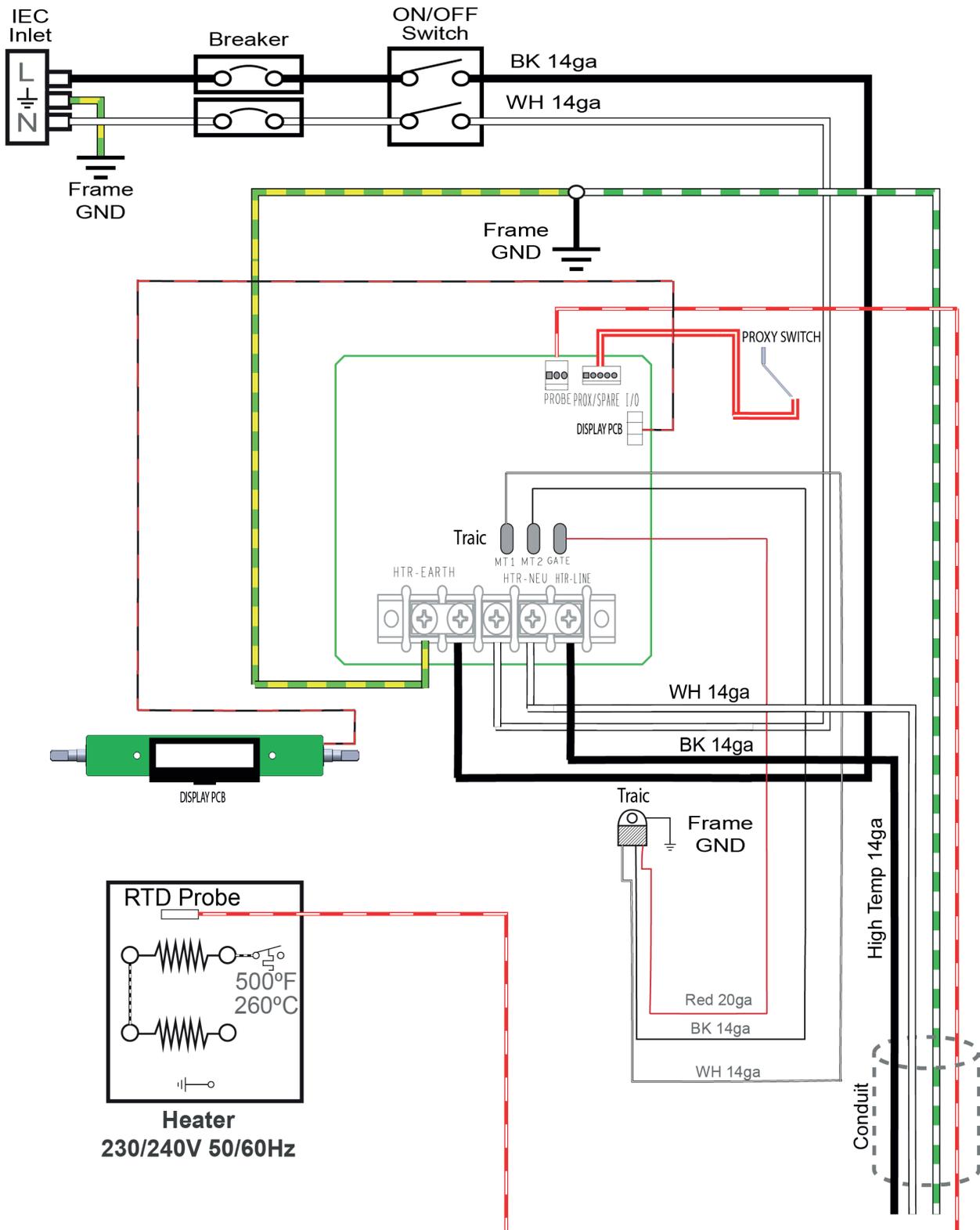
NOTE: When the heat press is stored or not in use, adjust the pressure to bare minimum (maintain slight contact between lower platen and heater) to keep the pressure buildup less between parts.

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





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: MerchMaker

Related Directives and Anne x:

- 2006/42/EC Machinery Directive / Anne x VIII
- 2014/30/EU Electromagnetic Compatibility Directive / Anne x II

Related Standards:

- EN ISO 12100:2010; EN ISO 13839-1:2015; 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

Related with Supply of Machinery (Safety) Regulations 2008 and Electromagnetic Compatibility Regulations 2016/1091:

- BS EN ISO 12100:2010; BS EN ISO 13849-1:2025; BS EN ISO 13849-2:2012; BS EN 60204-1:2018;
BS EN IEC 62368-1:2020+A11:2020
- BS EN IEC 61000-6-2:2029; BS EN IEC 61000-6-4:2019

Information on the Declaration of Conformity:

- Legislation: REACH [(EC) 1907/2006] Standard: EN 14362-1:2012; EN 14362-3:2012; EN ISO 17353:2005; EN 14852:2007;
EN 62321-6:2015; EPA 3540C:1996; EPA 8061A:1996; EPA 3060A:1996; EPA 5021:1996; EPA 8061A:1196; EPA 3550C:2007;
EPA 8270D:2014; EPA 3052:1996; EPA 9056A:2007; EPA 6010D:2014; EPA 8270D:2014; EPA 3050B:1996

Information on the Declaration of Conformity:

- Legislation: RoHS [2011/65/EU] Standard: 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 62321-7-2:2017]; EN 62321-8:2017 [idt IEC 62321-8:2017]

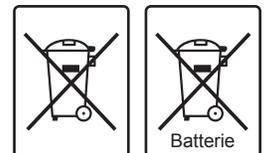
It is possible that not all the listed norms apply to the above mentioned product.

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

STAHLs' Europe

Dieselstraße 62
D-66763 Dillingen

**Warranty Support &
Customer Service**

info@stahls.de

Web
stahlseurope.com

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