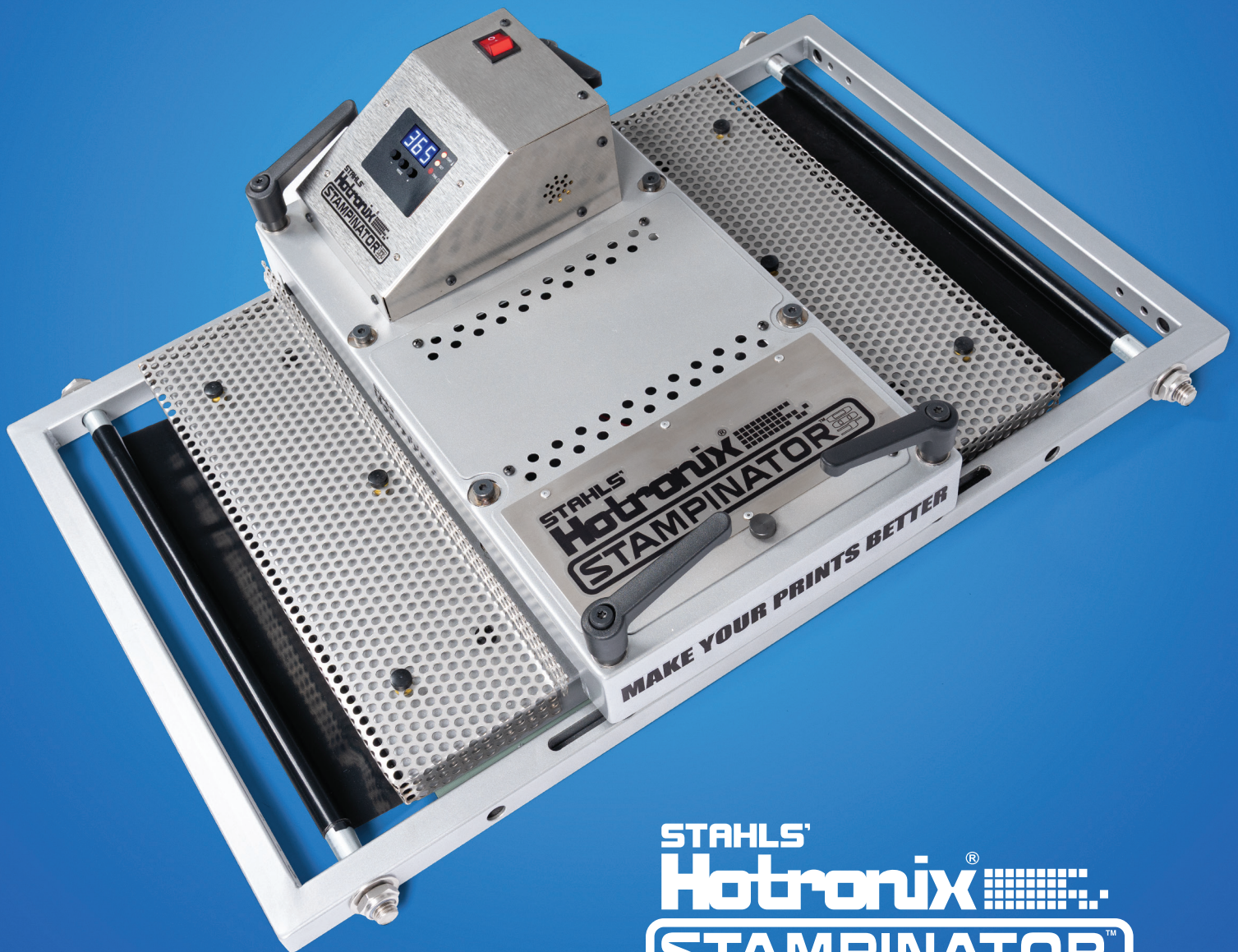


STAMPINATOR® 480

OPERATOR'S MANUAL



STAHL'S
Hotronix®
STAMPINATOR™

GENERAL SAFETY GUIDELINES

► Read and Follow Instructions

- All users must read this manual thoroughly and adhere to the outlined safety procedures when operating the Stampinator® 480.

► Intended Use

- Operate the Stampinator® 480 exclusively for its designated functions as specified in Section 6: **Intended Use**.

► Securing the Unit

Ensure the unit is secured in place by:

- Locking down the air cylinders.
- Hand-tightening all clamp downs prior to operation.

ELECTRICAL SAFETY

► To prevent electrical hazards:

- **Avoid contact with liquids:** Do not immerse the unit in water or other fluids.
- **Proper grounding:** The unit must be grounded in accordance with NEC (National Electrical Code) requirements by a qualified electrician.
- **Safe disconnection:** Always grasp the plug—not the cord—when disconnecting from the power outlet.
- **Cord safety:** Keep power cords away from hot surfaces and allow the unit to cool before storage.
- **Wiring integrity:** Never alter the unit's internal wiring.
- **Damage inspection:** Do not use the unit if the power cord is damaged or if the unit has been dropped or otherwise compromised.
- **Qualified servicing:** Only qualified personnel should perform inspections or repairs.
- **Power disconnection for service:** Always unplug the unit before cleaning or performing any maintenance.

USAGE RESTRICTIONS

► Supervision Requirements

- This equipment is not intended for use by individuals with reduced physical, sensory, or mental capabilities, or lack of experience and knowledge, unless they are supervised or properly instructed by a responsible person.

► Personnel Safety

- Ensure close supervision when the unit is used near children. Never leave the unit unattended while it is connected to a power source.

► Burn Prevention

- Avoid contact with hot metal parts or the heated platen during and immediately after operation.

Safety Procedures

OPERATIONAL SAFETY

► Circuit Management

- Do not connect other high-voltage devices to the same power circuit.
- If using an extension cord, ensure it is rated for at least 20 amps. Lower-rated cords may pose overheating risks.

► Cable Arrangement

- Position power cords to prevent tripping or accidental disconnection.

► Personal Safety

- Keep loose clothing, hair, jewelry, and other items away from moving or heated parts.
- Never place hands near the operating unit.

► Work Area Conditions

- Maintain a clean and organized workspace, free of unnecessary materials and obstructions.

MAINTENANCE & STORAGE

► Maintenance Safety

- Ensure power is turned off at both the unit and the main circuit breaker before performing maintenance.
- Disconnect the power cable from the unit entirely prior to servicing.

► Flammable Material Storage

- Do not store flammable liquids or vapors within a three-foot radius of the unit.

INTENDED USE

► The Stampinator® 480 is specifically designed for:

- In-line stamp curing of underbase layers
- In-line stamp matting of textile fibers
- In-line stamp application of heat transfers
- In-line stamp curing on textiles and cut goods

HOTRONIX® **STAMPINATOR® 480**

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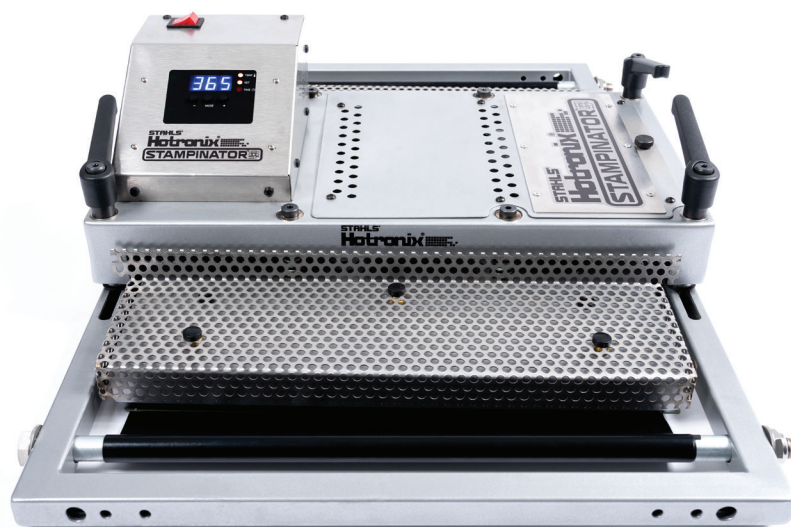
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Congratulations and Thank You for Purchasing the Stampinator® 480!

We're excited for you to start using your new equipment and want to make sure everything arrives just right.

Before you open the box, take a quick look at the packaging. If you notice any damage, don't accept the delivery. Instead, take a few photos, let the driver know, and contact Hotronix® right away. Our packaging is built to handle typical shipping, but if something doesn't look right, it's important to report it as soon as possible so we can help make it right.

Please contact Hotronix® at 800-727-8520.

For your safety and proper installation of the unit, it's important to thoroughly review this manual before use.



Specifications



Weight: 70 lbs. (32 kg.)

Electrical: 120 volt • 15 amps / 1800 watts
240 volt • 7.5 amps / 1800 watts

Dimensions: 21" X 31.13" X 8" (53 x 79 x 20 cm)

Heater: 16" x 20" (40 x 50 cm)

Warranty: Lifetime on heating element, 2-year on controller

Temperature: Fully digital temperature control 176 - 430°F (80 - 221°C)

HOTRONIX® STAMPINATOR® 480

The Stampinator® 480 powered by Hotronix® ships in one box. Carefully unbox and examine the unit for damage.

INSTALLATION

Install the Stampinator® 480 in print head #2, removing the flash unit if currently installed. Please refer to the appropriate installation instructions specific to your press model before proceeding.

ANATOL

The Stampinator® 480 is designed to fit directly into the print head frame holder assembly. Simply insert the unit as you would insert a screen frame using the side rails. (1.1)

Secure the unit in place:

- Move the print carriage to the rear of the unit.
- Move the print head proximity sensor (PROX).
- Lock down and tighten the manual clamps to ensure a firm hold. (1.2)

The Stampinator® 480 is already pre-calibrated for your machine type.

Adjust machine settings:

- Navigate to: Settings → Advanced Settings
- Set Lift Speed to 700
- Set Acceleration Speed to 200
- Set Dwell Time between 2-7 seconds

The unit comes with Teflon already mounted to the heating element.

- Check the Teflon for tightness.
- The Teflon should be snug against the heating element—no slack should be present between the heater and the Teflon.



1.1



1.2

Installation & Operation

INSTALLATION

Install the Stampinator® 480 in print head #2, removing the flash unit if currently installed. Please refer to the appropriate installation instructions specific to your press model before proceeding.

M&R

The Stampinator® 480 is designed to fit directly into the print head frame holder assembly. Flip the print head up and insert the unit as you would a standard screen frame. (2.1)

Bring the print head assembly down and lock the unit in place:

- Move the print carriage to the rear of the unit.
- Adjust the print head proximity sensor (PROX) to the correct position.
- Lock down the air cylinders (if applicable) and tighten the manual clamps to ensure added holding pressure. (2.2)

The Stampinator® 480 comes pre-calibrated for your machine type. If your press is equipped with air cylinders on the print heads (e.g., Gauntlet III, Cobra, Stryker), you may adjust air pressure as needed for optimal performance.

To adjust flash time, simply program your flash settings on the press to the desired duration. The Stampinator® 480 operates based on your press's existing flash settings.

For presses such as the Gauntlet III, Cobra, or Stryker, install the extension bar to the rear of the unit (Parts Location Guide > Bottom Frame > Part #50 Dashed)

To engage the Stampinator® 480:

- Move the PROX switch (slide it to the rear of the unit).
- Align the rear PROX sensor with the end of the print head.
- Set the print head to Print Mode.
- Reduce the squeegee and print speed settings to their lowest levels.

The unit includes Teflon pre-mounted to the heating element:

- Inspect the Teflon for tightness.
- Ensure it is snug against the heating element—there should be no slack between the Teflon and the heater surface.



2.1



2.2

HOTRONIX® STAMPINATOR® 480

INSTALLATION

Install the Stampinator® 480 in print head #2, removing the flash unit if currently installed. Please refer to the appropriate installation instructions specific to your press model before proceeding.

ROQ

The Stampinator® 480 is designed to fit directly into the print head frame holder assembly. Insert the unit as you would a screen frame, using the side rails. (3.1)

Bring the print head assembly down and lock the unit in place:

- Move the print carriage to the rear of the unit.
- Adjust the print head PROX sensor to the correct position.
- Lock down the air cylinders (if applicable) and tighten the manual clamps for added pressure. (3.2)

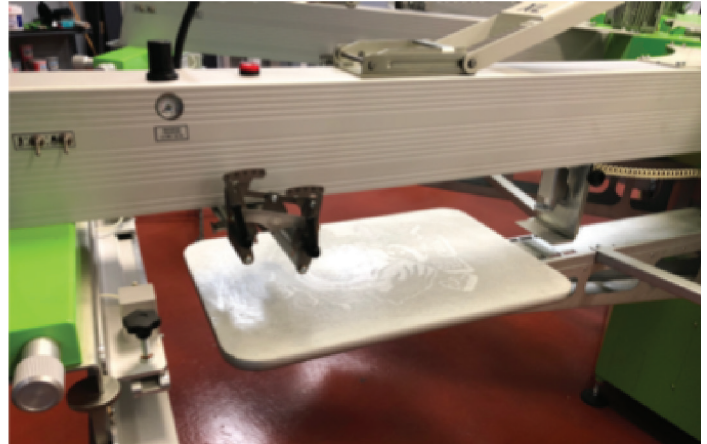
The Stampinator® 480 is pre-calibrated for your specific machine type. Set the off-contact to 5 mm, and lower as needed depending on your application.

Adjusting dwell/stamp time:

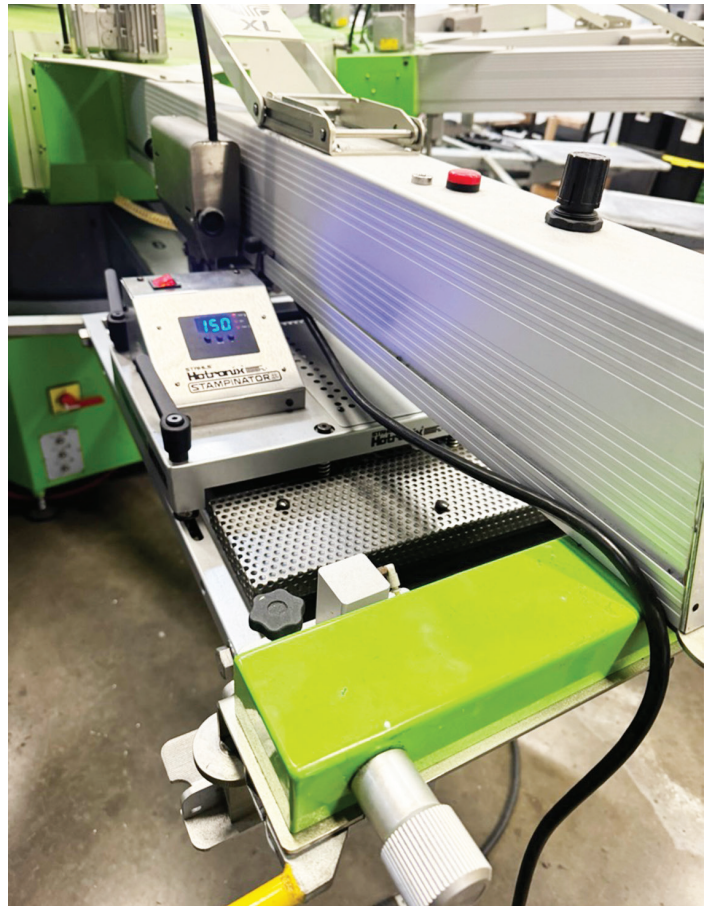
- On ECO and NEXT models, simply program the desired stamp time using your press's flash settings. The Stampinator® 480 responds to the press's timing settings.
- For the ROQ YOU, adjust the squeegee speed to control the length of time the Stampinator® 480 applies heat.

The unit comes with Teflon pre-mounted to the heating element:

- Check that the Teflon is tight against the heating element.
- There should be no slack between the Teflon and the heater surface.



3.1



3.2

Installation & Operation

INSTALLATION

Install the Stampinator® 480 in print head #2, removing the flash unit if currently installed. Please refer to the appropriate installation instructions specific to your press model before proceeding.

WORKHORSE

The Stampinator® 480 is designed to fit directly into the print head frame holder assembly. Flip the print head up and insert the unit as you would a screen frame. (4.1)

Bring the print head assembly down and lock the unit in place:

- Move the print carriage to the rear of the unit.
- Adjust the print head PROX sensor to the appropriate position.
- Lock down the air cylinders and tighten the manual clamps to ensure secure pressure. (4.2)

The Stampinator® 480 comes pre-calibrated for your machine type. If your machine includes air cylinders on the print heads, you may adjust the air pressure as needed for your application.

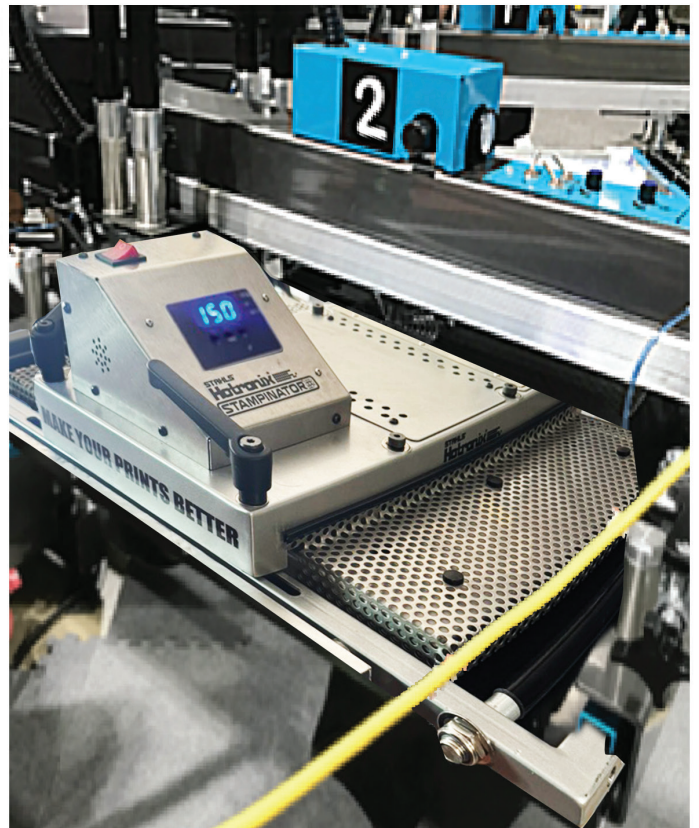
To adjust flash time, simply program your press's flash settings for the desired duration. The Stampinator® 480 operates according to the press's timing controls.

The unit comes with Teflon pre-mounted to the heating element:

- Inspect the Teflon to ensure it is tight and secure against the heating surface.
- There should be no slack between the Teflon and the heating element.



4.1



4.2

INSTALLATION

Install the Stampinator® 480 in print head #2, removing the flash unit if currently installed. Please refer to the appropriate installation instructions specific to your press model before proceeding.

MHM

The Stampinator® 480 is designed to fit directly into the print head frame holder assembly. Insert the unit as you would a screen frame, and place the mounting pins into the frame. (5.1)

Leave the print assembly in the UP position during installation. Secure the unit using zip ties on each corner, wrapping around both the Stampinator® 480 frame and the screen holder frame. Refer to red circle indicators for placement. (5.2)

The Stampinator® 480 is pre-calibrated for your machine type:

- Set the off-contact height for best results.
- If the unit is too high, spacers can be removed to adjust the height (Parts Location Guide > Top Frame > Part #53).

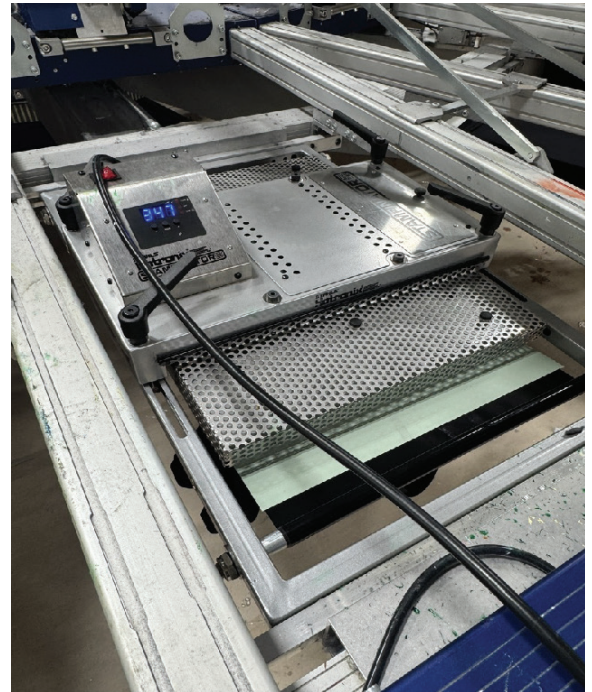
To adjust flash time, program the flash or dwell settings on your press to the desired time. The Stampinator® 480 functions based on the press's timing configuration.

The unit comes with Teflon pre-mounted to the heating element:

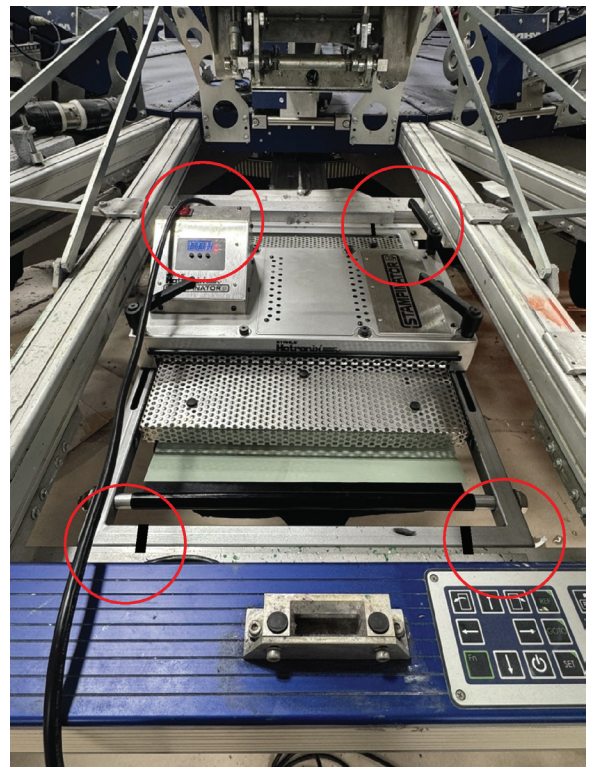
- Verify the Teflon is tight and flush against the heating element.
- There should be no slack between the Teflon and the heater surface.

OTHER BRAND PRESSES

Please refer to the other presses listed in the manual, as most have a similar setup. For further assistance, feel free to contact customer support.



5.1



5.2

Controls

ADJUST TEMPERATURE

- 1 Press the Mode Select button located in the center of the Control Panel. The (SET) and (TEMP) indicator lights next to the display will illuminate. (6.1)
- 2 Use the (+) or (-) buttons to adjust the temperature setting. You can set the temperature anywhere from 176°F (80°C) to 430°F (221°C).
- 3 The LED display will update in real time to reflect your changes.

ADJUST TIME

Your heat press offers two separate time settings for two-hit applications. For single-hit applications, simply set both time settings to the same value.

After adjusting the temperature, press the Mode Select button once to enter Time #1 Mode. The (SET) and (TIME) lights will illuminate, indicating you're setting Time #1 (6.2). Use the (+) or (-) buttons to select your desired Time #1 setting.

Press the Mode Select button again to advance to Time #2 Mode. All three red LED lights will illuminate, showing you're now setting Time #2 (6.3). Use the (+) or (-) buttons to set your desired Time #2.

Press the Mode Select button once more to exit the time settings. All indicator lights will turn off, and the press will return to PRINT mode. (6.4)

NOTE:

- Press the Mode Select button once to enter 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.



6.1



6.2



6.3



6.4

PROX ADJUSTMENT

The PROX sensor is pre-calibrated at the factory. If the PROX is not activating, adjust the thumb screw clockwise until the sensor engages properly.

To allow the PROX to deactivate when the print head lifts, turn the thumb screw counter-clockwise.

- The PROX adjustment thumb screw is shown in red for reference. (7.1)

The Stampinator® 480 features an auto sleep mode:

- If the unit remains inactive (PROX not engaged) for two hours, it will enter energy-saving sleep mode.
- To wake the unit, press any button on the display panel and allow it to return to the set temperature.

The PROX sensor will only activate if the unit is properly compressing:

- The Stampinator® 480 is equipped with four shoulder bolts and compression springs.
- During operation, each shoulder bolt must rise approximately $\frac{1}{4}$ " to confirm full compression.
- Shoulder bolts and compression springs are shown in red. (7.2)



7.1



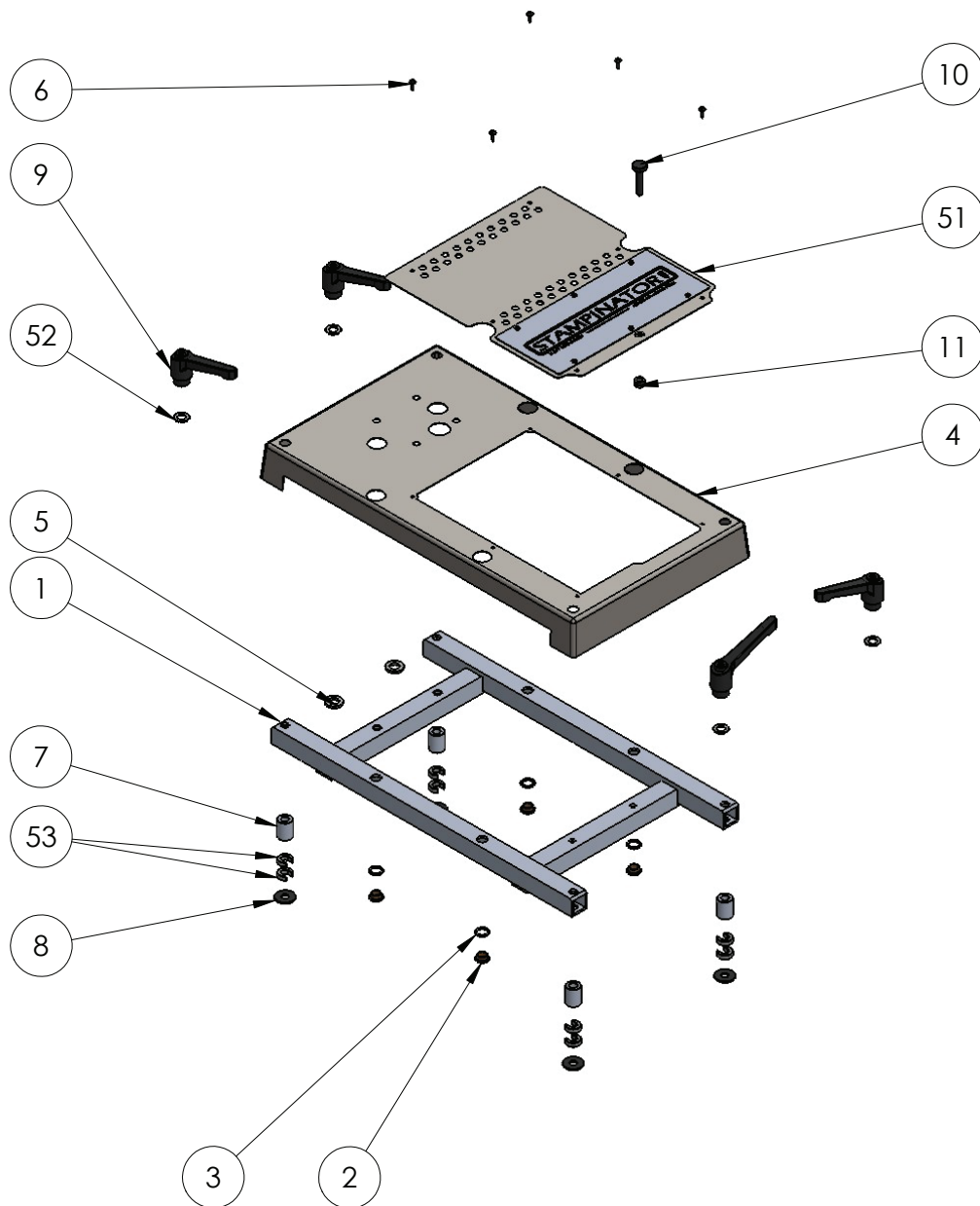
7.2

ITEM #	PART NAME	PART#	QTY.
1	Top Frame	3-1369	1
2	Bearing, High-Temp Flanged 3/8" Shaft Bronze	1-2769	4
3	Washer 0.063 X 0.51 ID X .688 OD	1-2770	4
4	Top Frame Cover	3-1370	1
5	Washer, .869 OD X .512 ID X .125 THK	2-1006-128	2
6	Screw, #8 x 1/2" Sheet Metal	3-1011-108	22
7	Spacer, 3/8 X 1" Aluminum	1-2773	8
8	Washer, 3/8" X 1.0" OD X .084" Thk PEEK	2-1006-129	4
9	Handle, Adjustable	1-2775	4
10	Thumb Screw 1/4"-20 X 1 1/2" Knurled	3-1011-303	1
11	Shaft Collar 1/4" W/ Set Screw	1-2776	1
12	Bottom Frame	3-1371	1
13	Spring Plate	2-1726	1
14	Heat Platen 16 x 20 1800W Milled (No Ears)	2-1002-3	1
15	Screw, 3/8"-16 x 3/4" Hex HD	3-1011-41	1
16	Heater Cover 16x20	3-1377	1
17	Spring, 2" Compression	1-2779	4
18	Insulation 16 x 20	1-2256	2
19	Thermostat Disc	1-2076	1
20	Screw, SS Sheet Metal #4 X 1/4"	3-1011-98	2
21	Screw, Machine #8-32 x 1/4"	3-1011-87	1
22	Heater Cover Maintenance Cover	3-1372	1
23	Perforated Heater Cover	3-1373	2
24	Grommet Rubber 1"	1-2780	2
25	Temperature Probe	1-1272-1	1
26	Snap Acting Switch	1-2790	1
27	Foam, 0.5" X 0.5"	1-2781	1
28	Screw, #4-40 X 5/8" SS Pan Head Phillips	3-1011-306	2
29	Nut, #4-40 with Tooth Washer	2-1006-51	2
30	Washer, #10 Black Finishing	2-1006-133	10
31	Screw, Machine #10-24 x 1/2"	3-1011-217	4
32	Screw, Machine #8-32 x 3/4"	3-1011-155	6

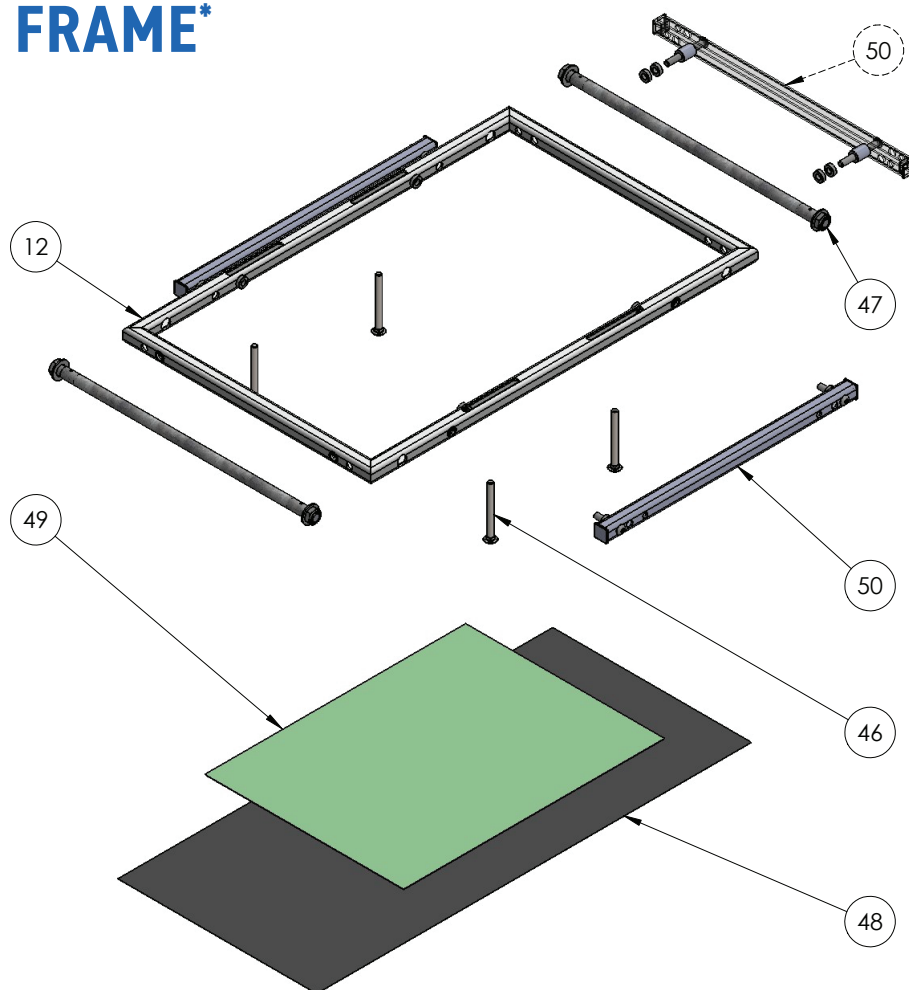
ITEM #	PART NAME	PART#	QTY.
33	Bolt 1"-12 x 1" Lg GR8.8 ZP	3-1011-311	1
34A	Control Housing Lower, 120V	4-1190	1
34B	Control Housing Lower, 240V	4-1191	1
35	Control Housing Face	4-1192	1
36	Controller Kit, STX	1-2129	1
37A	Circuit Breaker 20A, 120V	1-1331-3	2
37B	Circuit Breaker 10A, 240V	1-1331-2	2
38	Terminal Block, 5 Contact High Voltage	1-1290	1
39	TRIAC	1-2464-1	1
40	Controller Overlay, MAXX	1-2018-2g	1
41	Nut, #6-32 Hex with Lockwasher	2-1006-50	6
42	Screw, Machine #6-32 x 1/2"	3-1011-19	6
43	Power Switch	1-2087	1
44	Screw, Pan Phillips #4-40 x 1/4"	3-1011-278	4
45	Screw, #10-24 X 5/8" SS Pan HD Phillips	3-1011-307	2
46	Bolt .375" X 4" Carriage SS	3-1011-308	4
47	Teflon Tensioner	3-1374	2
48	Teflon Sheet 16" X 35"	1-2791	1
49	16X24 Silicone Pad 1/32"	1-2742	1
50	Mounting Bar Kit	3-1375	2
51	Top Frame Maintenance Cover	3-1376	1
52	Washer, 3/8" 316 SS	2-1006-131	4
53	C spacer, 3/8" X .25 Aluminum	1-2774-1	8
54	Flanged Shoulder Bolt 2.25"	3-1011-312	4
55	Washer #8 Plastic	2-1006-132	16
56	Standoff, #4-40 X 5/16" Male-Female Hex Standoff	1-2782	4
57	Wire Kit, STMP Assembly	2-1723	1
58A	Power Inlet and Filter, 120V	1-2783	1
58B	Power Inlet and Filter, 240V	1-2490	1
59A	120V Locking Power Cord, 12'	2-1724	1
59B	240V Locking Power Cord, 12'	2-1725	1
60	Plug PCE CEE 63A 5p Power Twist	1-2792	1

Parts Location Guide

TOP FRAME



BOTTOM FRAME*



* BOTTOM FRAME

50

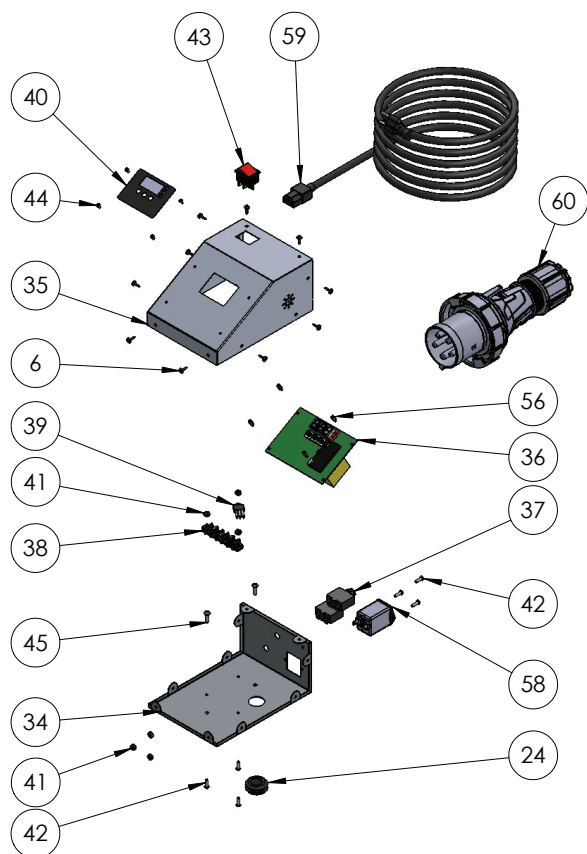
Mounting Bars / Side Rails
For side clamp presses:
Anatol
M&R Diamondback
Lawson Express

50

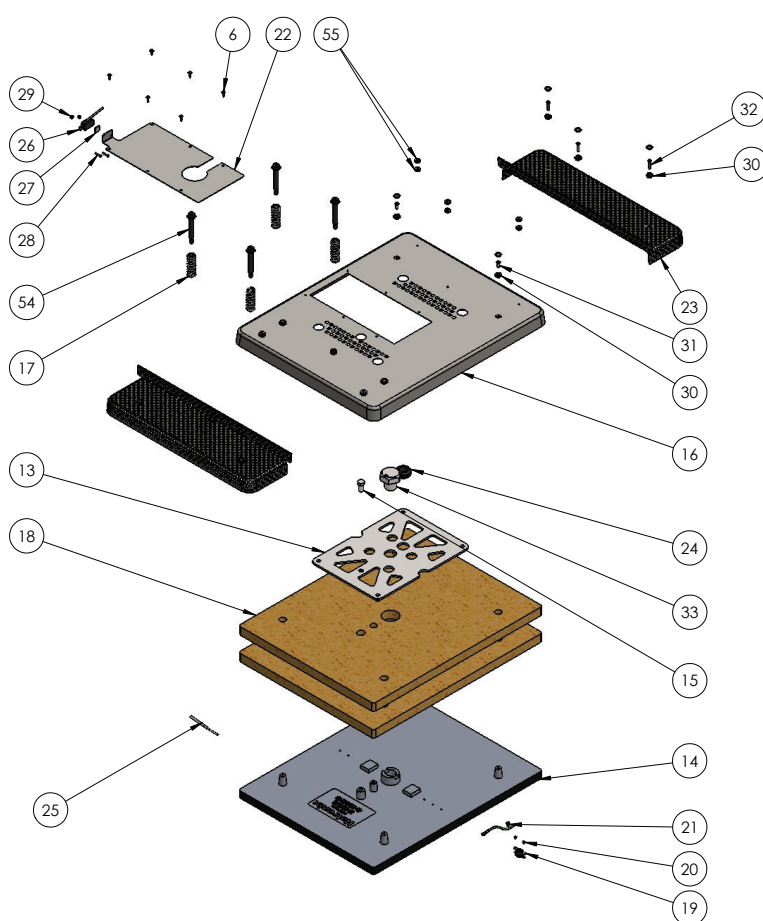
Mounting Bars (Front/Rear) or Extension Bar
For M&R presses with pneumatic print heads:
Stryker
Gauntlet 3 & 4
Cobra

Parts Location Guide

CONTROL HOUSING



HEATER ASSEMBLY



CONTACT US

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Replacement Parts

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