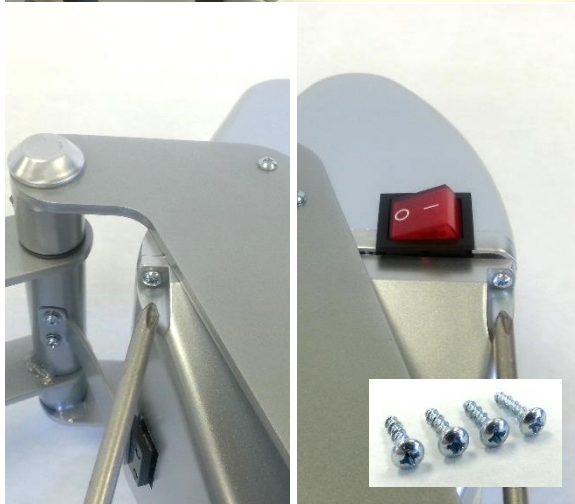**STAHLS'**
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Included Parts:
1. Controller Assembly
   o P/N 1-2129 for STX models
   o P/N 1-2017 for MAXX models
2. Overlay (STX only)
   o P/N 1-2018-1
3. Temperature Strips

Required Tools:
4. #2 Phillips Screwdriver
5. #1 Phillips Screwdriver
6. 2mm Precision Flathead Screwdriver

CAUTION: Detach power cord before proceeding

Remove 4x #6 x ½" Screws from control housing using #2 Phillips Screwdriver

STX & MAXX (Models STX20, STX20*, STX16, STX11, STXC, STX6, STX6*, MAXX20, MAXX15, MAXX11, MAXXC)
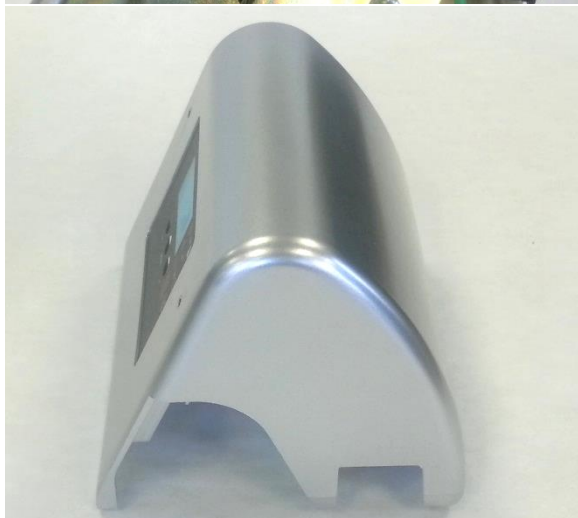**Controller Replacement / 2015-12-09**

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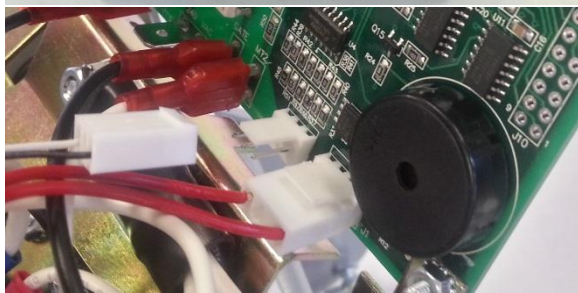Remove 2x #4-40 x 1" Screws from Controller Housing using #1 Phillips Screwdriver

NOTE: #4-40 Nuts on back side can be removed without a wrench due to integral toothed lock-washer

Lift off top half of Controller Housing and remove 2x #6 x ½" Screws from Controller Bracket using #2 Phillips Screwdriver
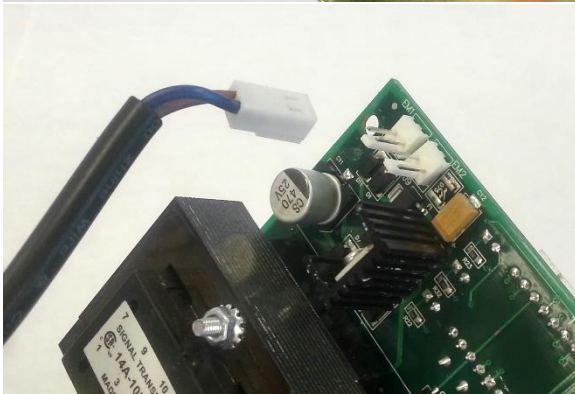
Fully remove top half of Controller Housing and set aside

Unplug Temperature Probe from Controller
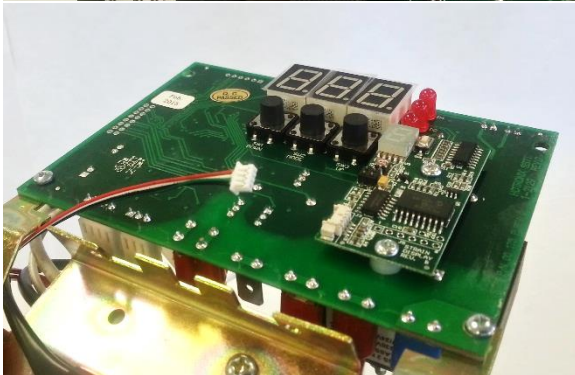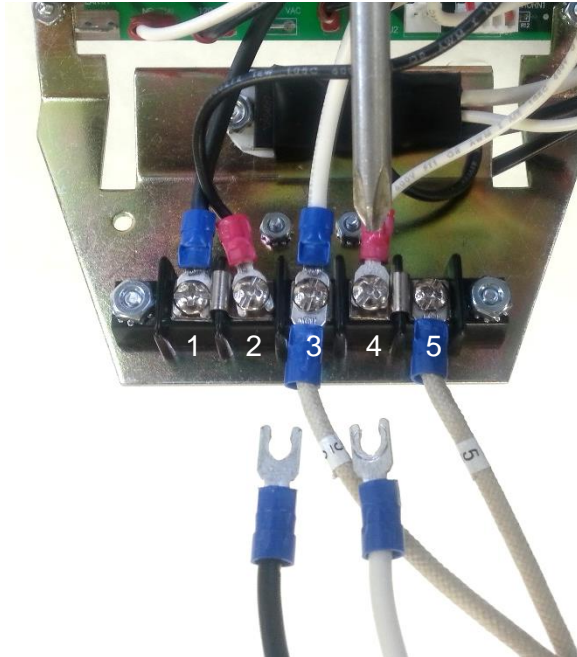
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Unplug earth ground wire from Controller

Unplug Electromagnet from Controller

NOTE: STX models only

Unplug Strain Gauge from Controller

NOTE: STX models only

STX & MAXX (Models STX20, STX20*, STX16, STX11, STXC, STX6, STX6*, MAXX20, MAXX15, MAXX11, MAXXC)
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Unscrew and disconnect black & white wires from terminal strip positions 2 & 4 as shown using #2 Phillips Screwdriver to disconnect Power Switch
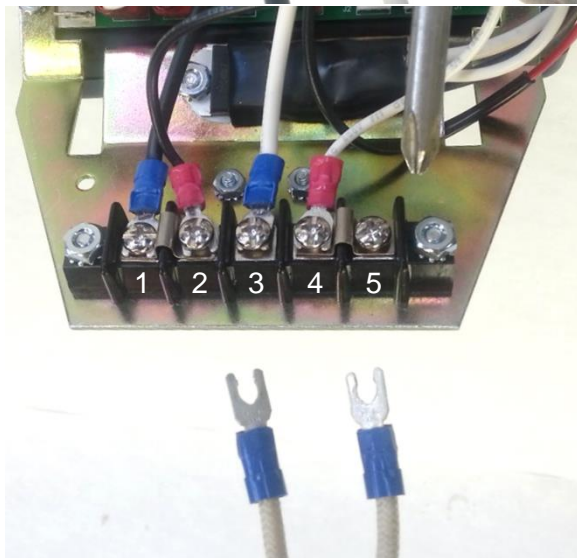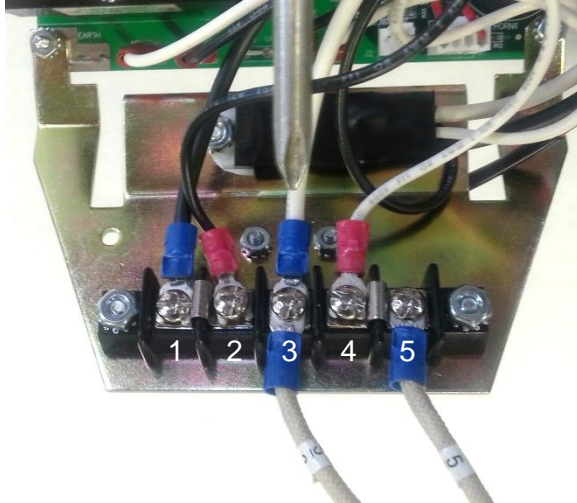

Unscrew and disconnect braided cloth (high temperature) wires from terminal strip positions 3 & 5 as shown
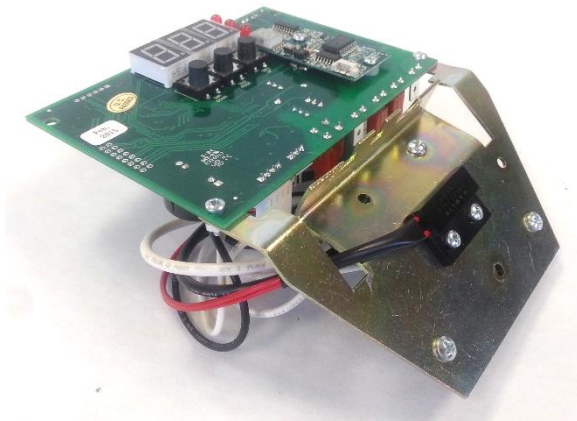
Remove old Controller and discard

NOTE: Please comply with your local electronics disposal laws

STX & MAXX (Models STX20, STX20*, STX16, STX11, STXC, STX6, STX6*, MAXX20, MAXX15, MAXX11, MAXXC)
Controller Replacement / 2015-12-09
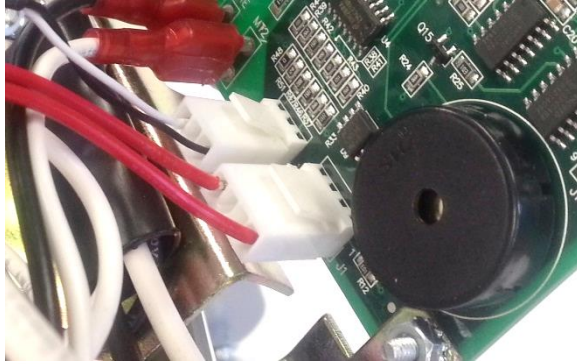
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Connect braided cloth (high temperature) wires to new Controller at terminal strip positions 3 & 5 as shown and tighten screws with #2 Phillips Screwdriver
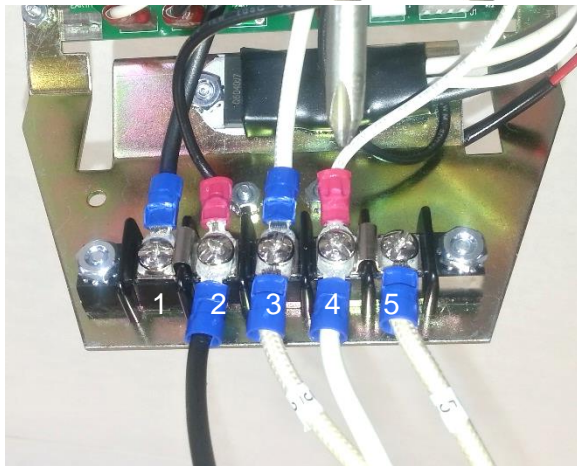
Connect black & white Power Switch wires to terminal strip positions 2 & 4 as shown and tighten using #2 Phillips Screwdriver

Plug in earth ground wire to Controller

STX & MAXX (Models STX20, STX20*, STX16, STX11, STXC, STX6, STX6*, MAXX20, MAXX15, MAXX11, MAXXC) Controller Replacement / 2015-12-09

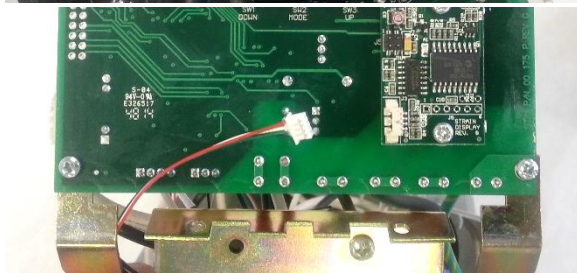**STAHLS'**
Hotronix

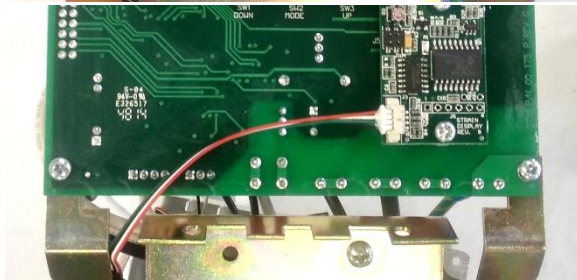Plug in Temperature Probe to Controller

Plug in Electromagnet wire to port EM1 of Controller
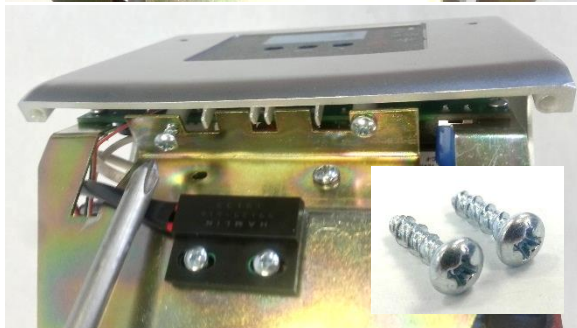
NOTE: STX models only

Thread Strain Gauge wire through gap between Controller and bracket
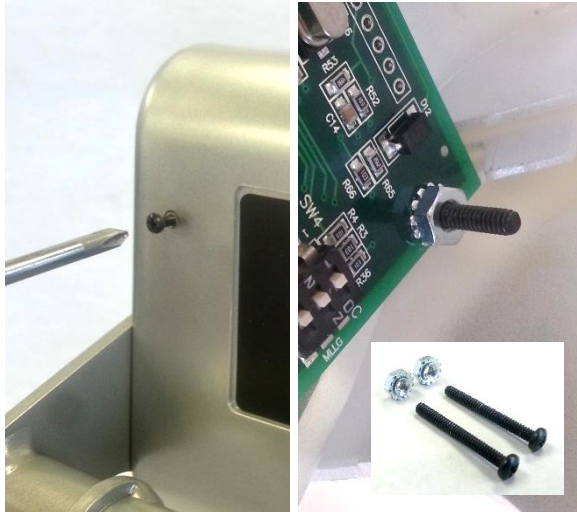
NOTE: STX models only

Plug in Strain Gauge to Controller

NOTE: STX models only

Attach new Controller to top half of Controller Housing by screwing in 2x #6 x ½" Screws using #2 Phillips Screwdriver

Install 2x #4-40 x 1" Screws and Nuts with Lock Washer using #1 Phillips Screwdriver to secure new Controller to top half of Controller Housing

Install top half of Controller Housing and secure by screwing in 4x #6 x ½" Screws using #2 Phillips Screwdriver
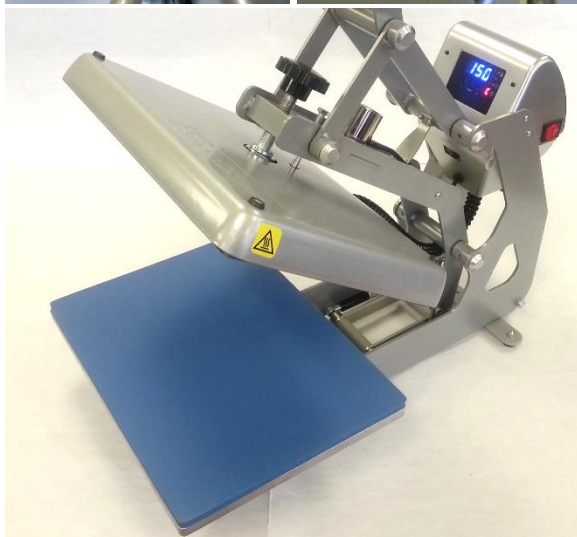
Plug in press and turn ON to verify proper operation

Set temperature to 350°F/177°C and allow press to heat up
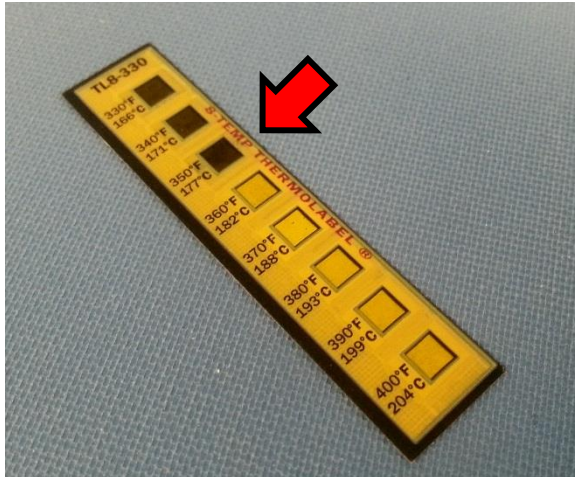
NOTE: this may take up to 20 minutes

Place temperature strip on center of silicone pad with numbers facing up

Once press reaches 350°F/177°C, lower handle to print directly onto temperature strip

Note reading on last temperature strip square which is completely black – this is the temperature of the heater platen.

If temperature strip reading matches display, skip next 3 steps

If temperature strip reading does not match display:

- Turn press OFF
- Press and hold (+) and (–) buttons
- Turn press ON
- When press powers up, release (+) and (–) buttons

NOTE: Display should read 350, 177 or similar (temperature)

STX & MAXX (Models STX20, STX20*, STX16, STX11, STXC, STX6, STX6*, MAXX20, MAXX15, MAXX11, MAXXC)
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Adjust display reading using (+) and (–) buttons to match temperature strip reading

Press center (MODE) button repeatedly (4 times) until LED indicator lights at right are all off
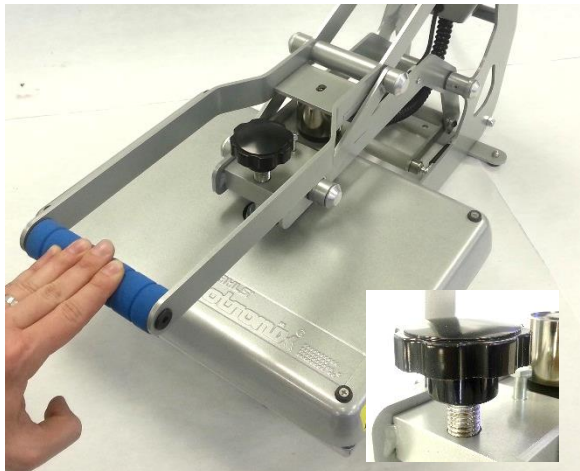

Turn press OFF

NOTE:

- MAXX model presses are now fully calibrated and require no additional steps
- STX model presses require additional pressure calibration described in following steps

Remove Overlay

NOTE: STX models only

With press OFF, adjust pressure knob to "light pressure" (platen lifts up when locked down in print position)

NOTE: approximately 3lb force on handle to lock


To calibrate pressure:
- Press and hold (+) and (–) buttons
- Turn press ON
- When press powers up, release (+) and (–) buttons
- Press center (MODE) button to skip temperature calibration
- Press (+) button once to display live pressure reading

NOTE: Main display should read "555" while secondary display shows a single number between 0-9
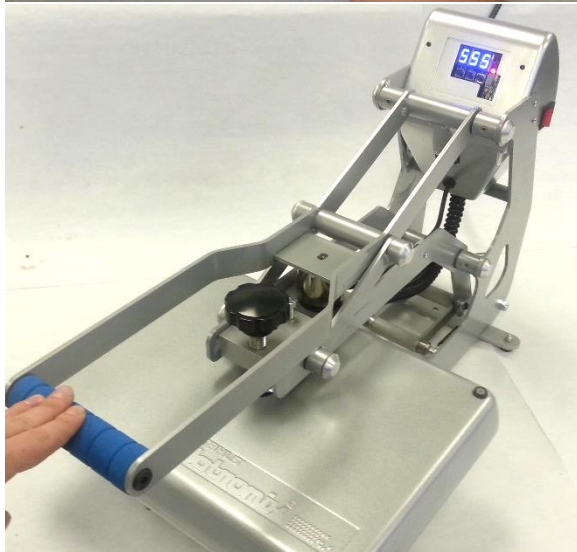

Adjust trim potentiometer as shown using 2mm Precision Flathead Screwdriver until display reads "0"

NOTE: Press should not be locked down for this step
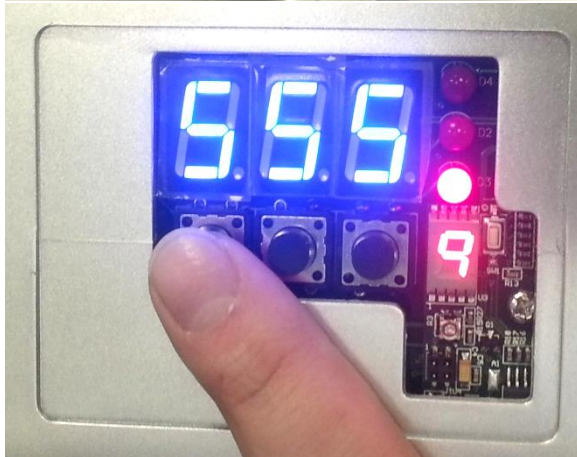
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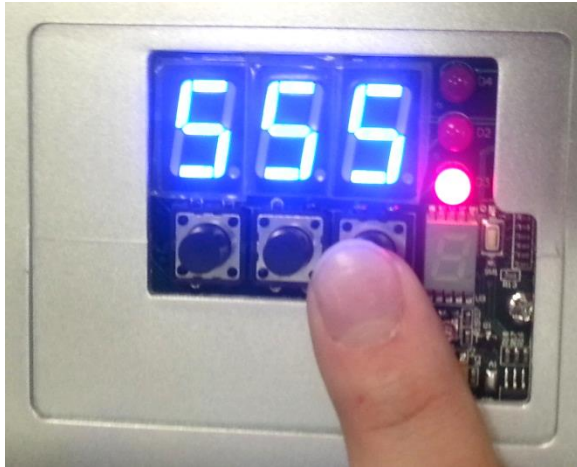
Press (+) button until display flashes "1" indicating pressure reading is below normal range
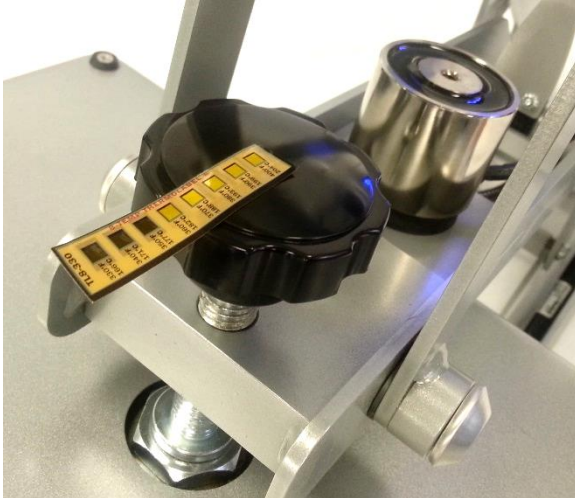

Lock press into print position and press (+) button

NOTE: Display should flash "9" indicating pressure reading is above normal range

Using caution as the press will open on its own, press and hold (–) button to release electromagnet lock

STX & MAXX (Models STX20, STX20*, STX16, STX11, STXC, STX6, STX6*, MAXX20, MAXX15, MAXX11, MAXXC)
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Adjust pressure knob to "heavy pressure" by turning 1½ turns clockwise (attaching a piece of tape to knob as shown may help keep count of turns)

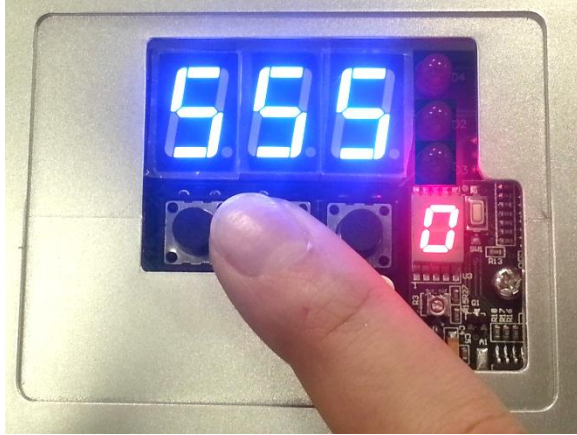NOTE: approximately 45lb force on handle to lock

Lock press into print position and press (+) button
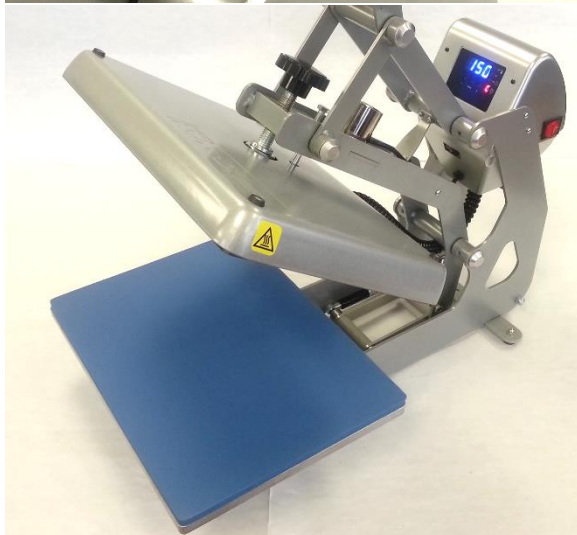
NOTE: Display should show steady "9" or slowly flashing "9"
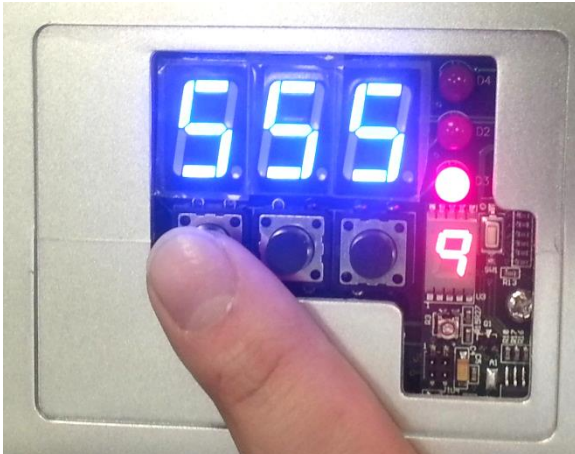
Using caution as the press will open on its own, press and hold (–) button to release electromagnet lock

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Press and center (MODE) button repeatedly (3 times) until LED indicator lights at right are all off

Apply new Overlay to Controller Housing

NOTE: STX model presses are now fully calibrated