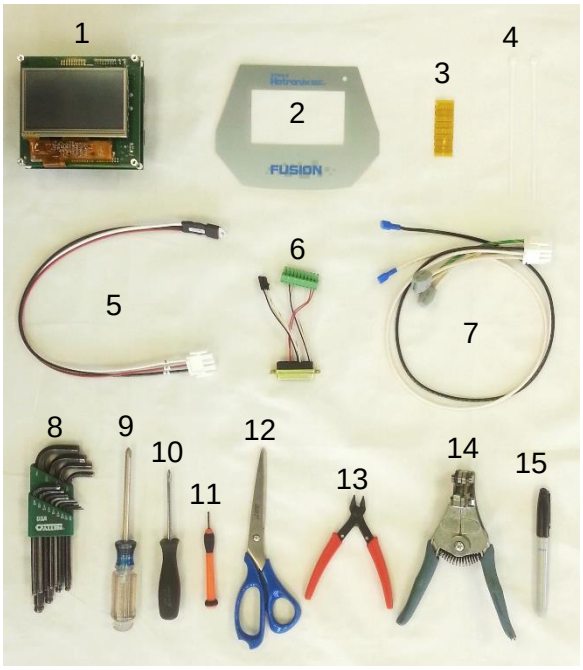
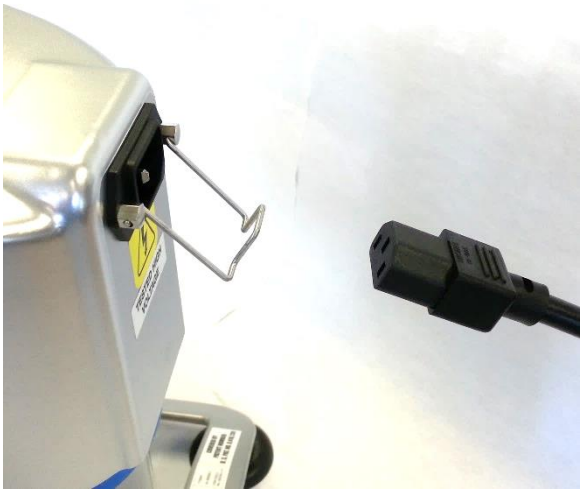


Included Parts:

1. Controller
2. Controller Overlay
3. Temperature strips
4. Zip ties
5. TRIAC
6. Adapter Harness (older models only)
7. 9-Pin Connector (where applicable)

Required Tools:

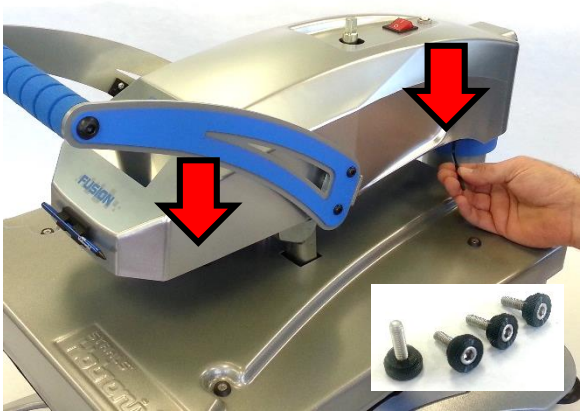
8. Allen Wrenches (3/32” & 9/64”)
9. #2 Phillips Screwdriver
10. #1 Phillips Screwdriver
11. 2mm Precision Flathead Screwdriver
12. Scissors
13. Wire Cutters (9-pin repair only)
14. Wire Strippers (9-pin repair only)
15. Permanent Marker (9-pin repair only)



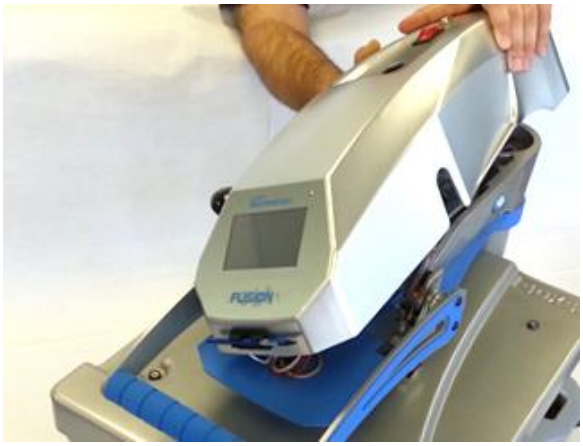
CAUTION: Detach power cord before proceeding

Lower heater but do not lock into place, such that it rests gently on lower platen

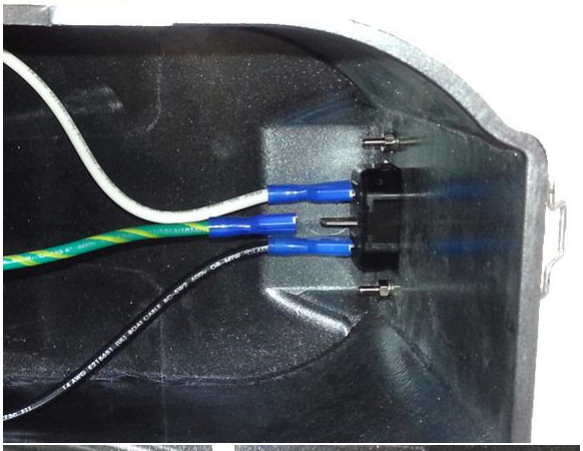
Loosen set screw in shaft of pressure adjustment knob and remove knob using 3/32” Allen Wrench



Remove 4 #8-32 x ½” Thumb Screws (right 2 shown) from underside of control housing using 9/32” Allen Wrench

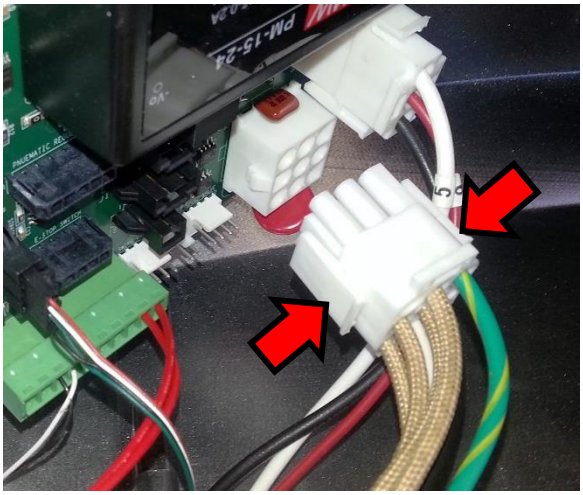


Lift off control housing and lay it gently on left side of press

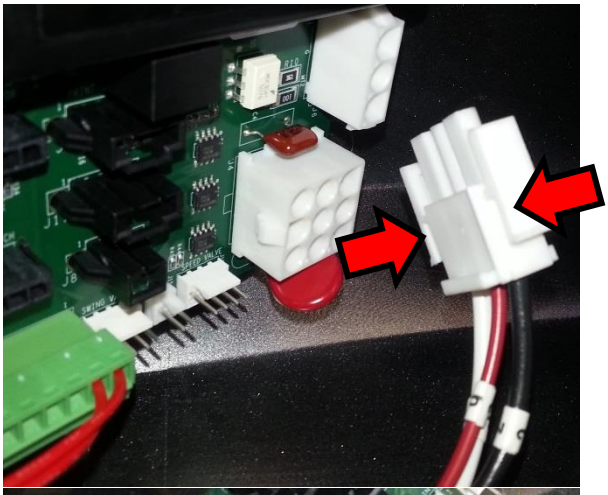


Unplug ground wire (green with yellow stripe) from IEC inlet at rear of housing

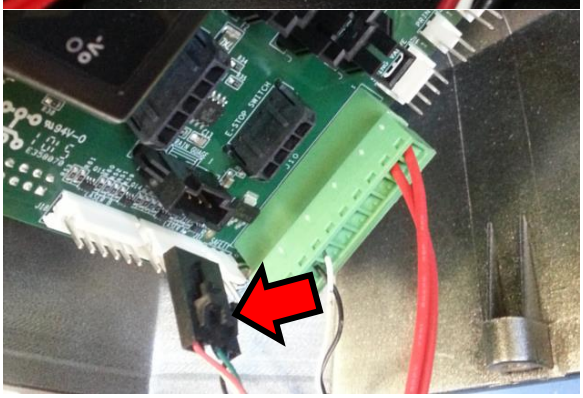
Unplug Black & White wires from Power Switch as shown to disconnect from Controller



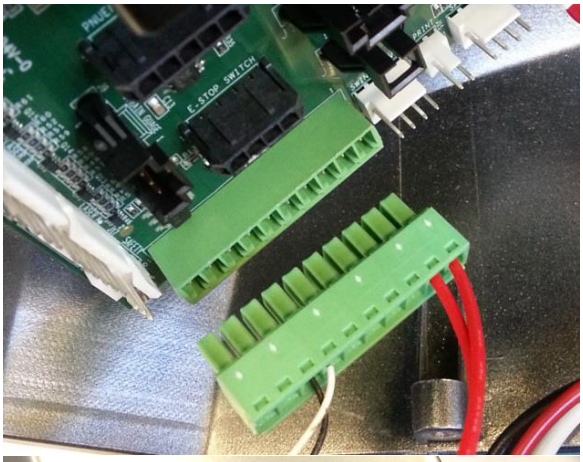
Unplug 9-pin connector from Controller by squeezing sides to release locking clips



Unplug 3-pin TRIAC connector from Controller by squeezing sides to release locking clips



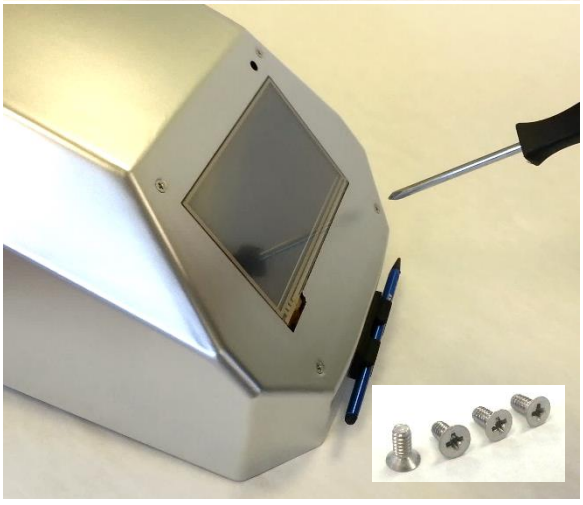
Unplug 4-pin Strain Gauge connector from Controller by depressing locking clip



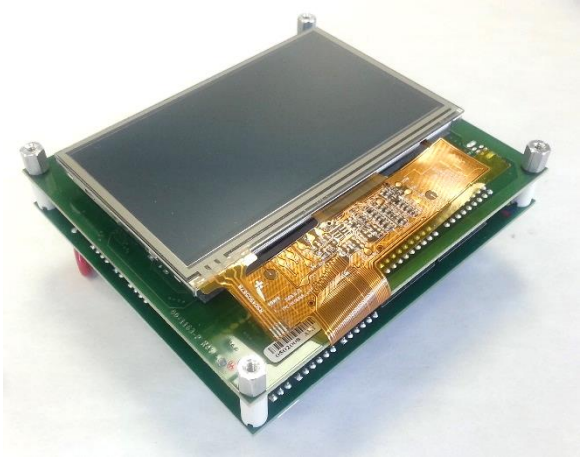
Unplug 10-pin I/O connector from Controller

NOTE: Version 2 and prior Controllers use 25-pin D-sub connector

Peel off Overlay and discard



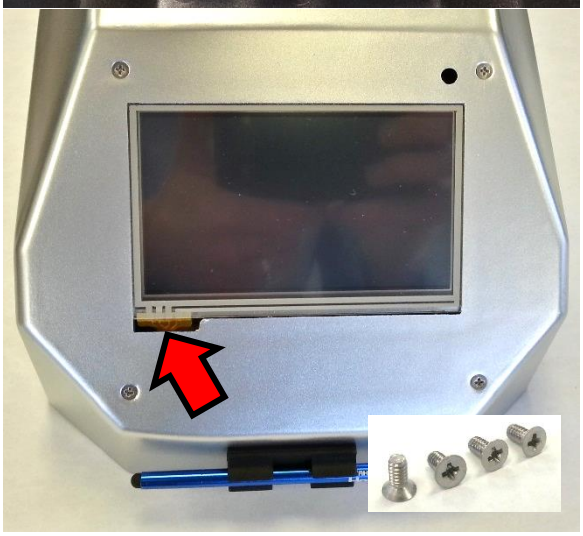
Remove 4 #4-40 x ¼" flathead screws using #1 Phillips Screwdriver



Remove old Controller and ship to Hotronix using provided return label

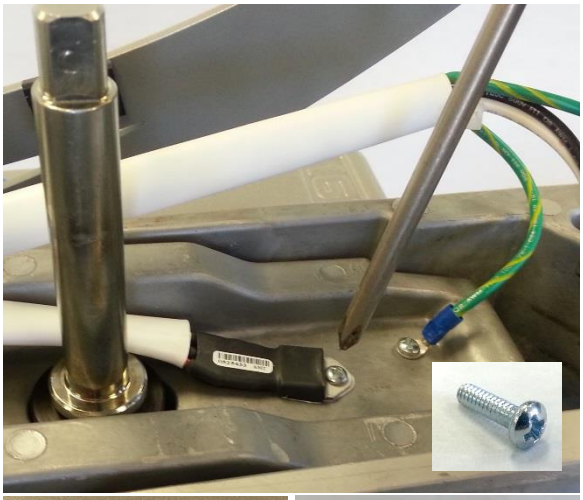
NOTE: Any unreturned Controllers will be billed for at owner's expense

Install new Controller, noting orientation

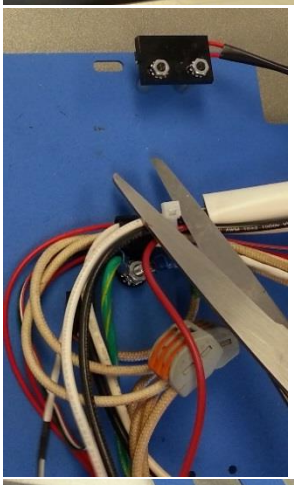


Ensure digitizer ribbon aligns with housing cut-out and replace 4 #4-40 x ¼" flathead screws, tightening with #1 Phillips Screwdriver only after all screws are in place

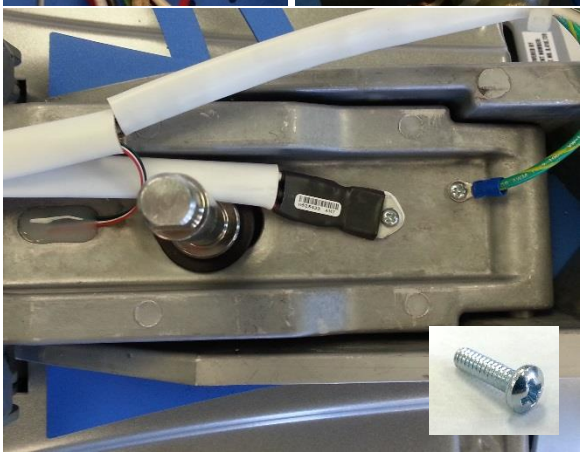
NOTE: do not apply new Overlay until press is reassembled and proper operation is verified



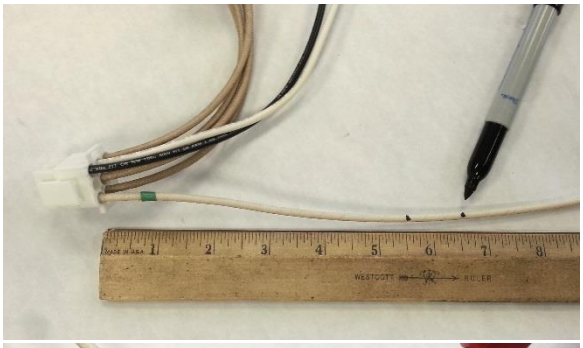
Remove TRIAC using #2 Phillips Screwdriver, saving #6-32 x ½" screw



Cut zip ties holding TRIAC wires using scissors or wire cutters, careful not to damage press wiring

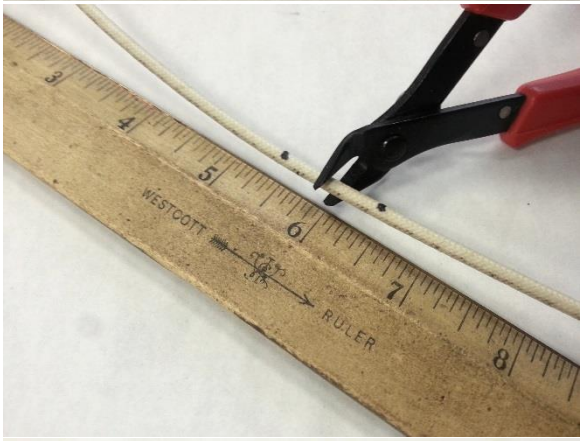


Install TRIAC flat side down using existing #6-32 x ½" screw, orienting it to direct wires around adjustment spindle and towards front of press as shown



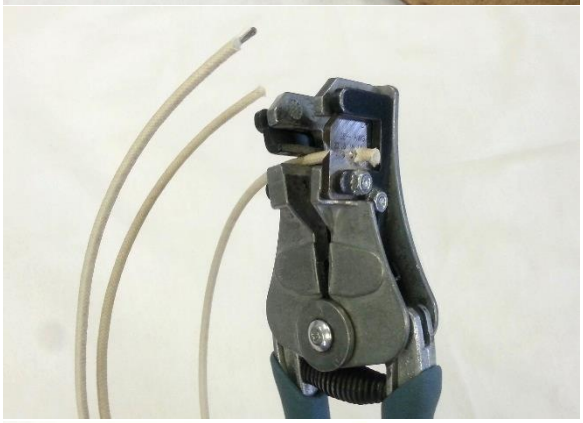
NOTE: Perform this step only if 9-pin connector is being replaced

Locate ground wire by identifying green band on braided cloth Heater Wire or green wire with yellow stripe, and mark with Permanent Marker 5-1/2” and 6-1/2” from 9-pin Connector



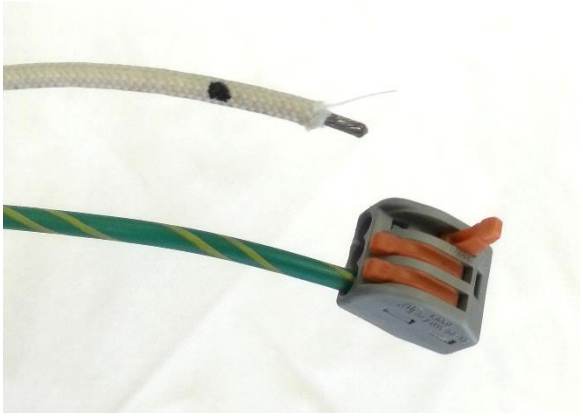
NOTE: Perform this step only if 9-pin connector is being replaced

Cut 3 braided cloth Heater Wires, including ground wire, 6” from 9-pin Connector using Wire Cutters, such that your marked ground wire can be identified on both loose wire ends.



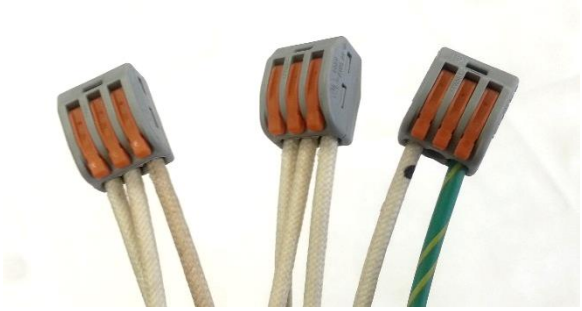
NOTE: Perform this step only if 9-pin connector is being replaced

Strip 10mm of insulation off of 3 braided cloth Heater Wires using Wire Strippers



NOTE: Perform this step only if 9-pin connector is being replaced

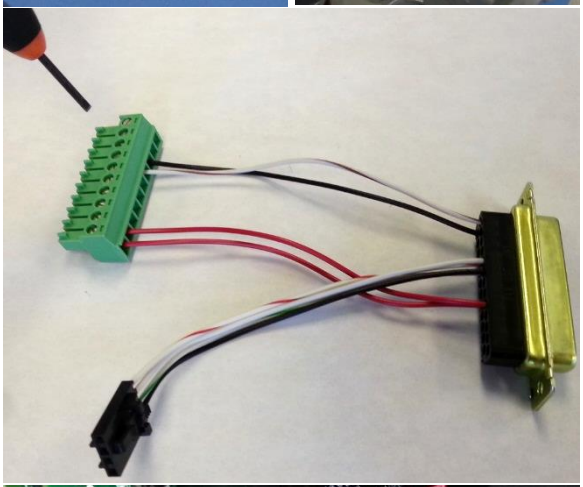
Match up ground wires from Heater and 9-Pin Connector and connect by inserting into Lever Nut and locking down orange lever



NOTE: Perform this step only if 9-pin connector is being replaced

Connect 2 braided cloth Heater Wires from Heater to 9-Pin Connector Lever Nuts

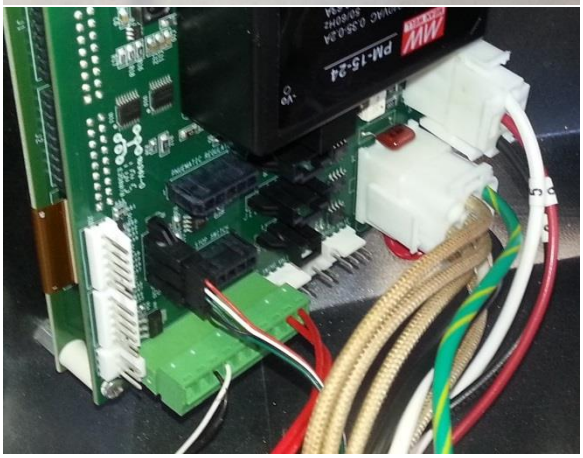
Install 2 Zip-Ties to secure cables, being sure to exclude Strain Gauge cable as shown



NOTE: For Version 2 and prior models only

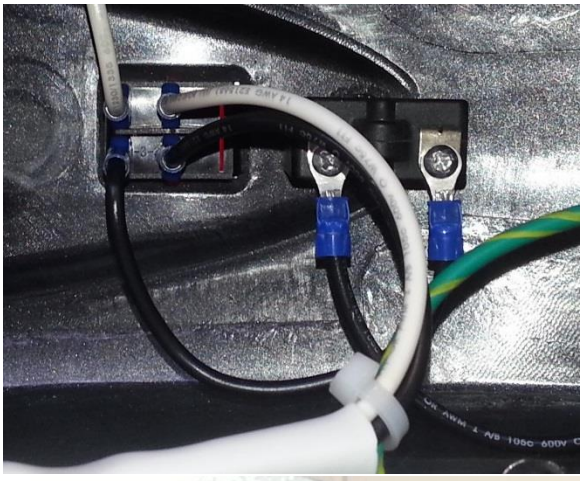
Assemble 25-pin D-sub adapter with 10-pin IO connector using Miniature Flat-Head Screwdriver, noting pin positions (bottom to top as shown):

1: Red, Proximity Switch (either)
2: Red, Proximity Switch (either)
3-6: None
7: Black/White, Temperature Probe (either)
8: Black/White, Temperature Probe (either)
9-10: None

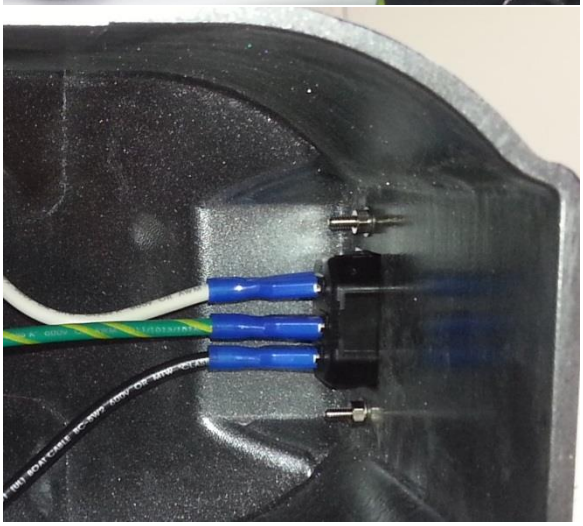


Plug connectors into new Controller:
1. 9-pin connector
2. 3-pin TRIAC connector
3. 4-pin Strain Gauge connector
4. 10-pin I/O connector

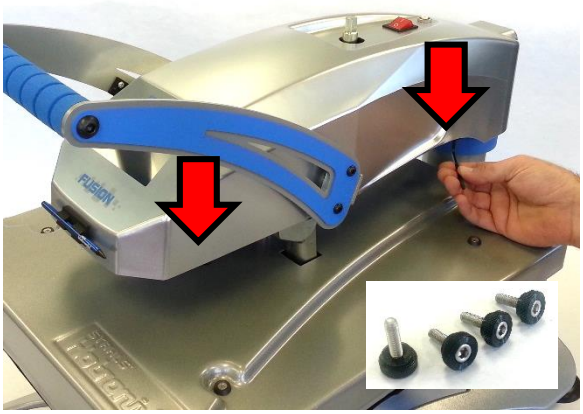
NOTE: For Version 2 and prior models, connect 25-pin D-sub adapter.



Plug in White & Black wires into Power Switch on opposite sides of the divider as shown to connect to Controller



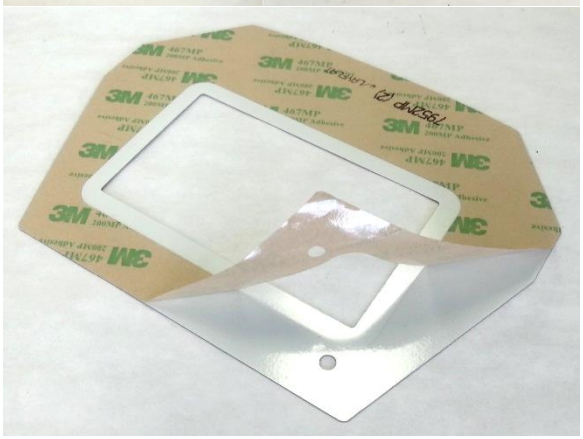
Plug Green wire with Yellow band into IEC outlet to connect to grounding circuit



Replace housing onto press and insert 4 #8-32 x ½" Thumb Screws (right 2 shown), tightening with 9/32" Allen Wrench

Replace Pressure Adjustment Knob, aligning set screw with flat of shaft and tightening with 3/32” Allen Wrench

Raise handle into open position, plug in press and turn ON



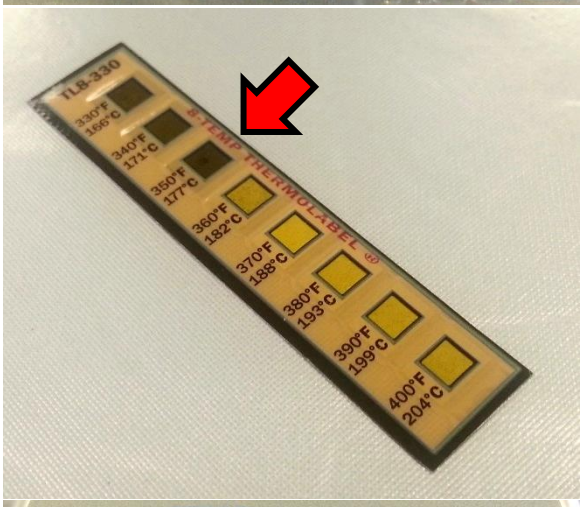
Peel adhesive backing off of supplied Overlay

With the press still ON, align border of supplied Overlay with Controller screen edges and apply using light pressure

Set the following printing parameters:
1. Temperature at 350°F/177°C
2. Print time at 10 seconds
3. Pressure at medium pressure

Place temperature strip on the 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

Press “GEAR” icon

Press “SET UP”

Type in password: JAGUAR2 (JAGUAR on older models) and press “ENTER”

NOTE: do not use this password for anything besides this temperature calibration or warranty is void

Press “CALIBRATION”

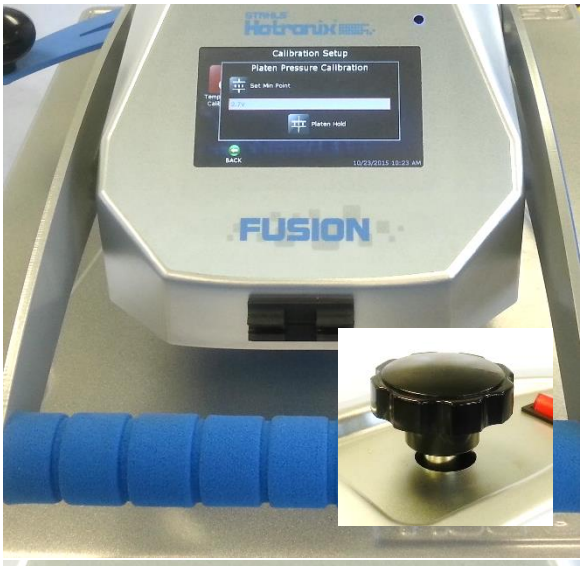
Press “TEMPERATURE CALIBRATION”

Use +/– buttons to change temperature next to “TEMPERATURE CALIBRATION” to match reading on temperature strip

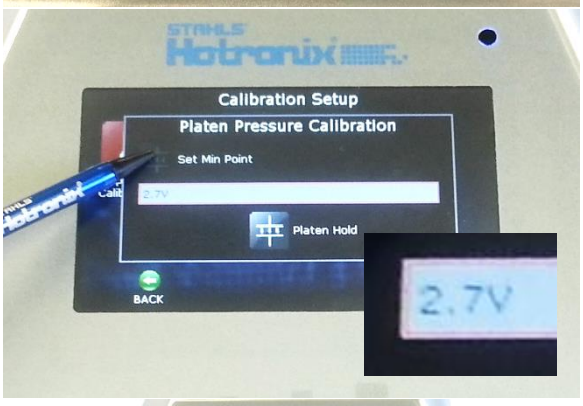
Press “SAVE” to save calibration, then “BACK” to return to the “CALIBRATION SETUP” screen

Press “PLATEN PRESSURE CALIBRATION”

Press “CALIBRATE” and wait for the Controller to dial into 2.5V and display the “SET MIN POINT” button at left



Open press and adjust the Pressure Adjustment Knob until the voltage reads 2.7V when locked down



While press is locked down at 2.7V, press “SET MIN POINT”

Open press and adjust the Pressure Adjustment Knob until the voltage reads either 3.1V or 3.2V when locked down

While press is locked down at 3.1V or 3.2V, press “SET MAX POINT”

Press “SAVE” to save calibration, then “BACK” repeatedly to return to main operation screen