

# MERCHMAKER<sup>®</sup>

*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.

# Table Of Contents



**Safety Instructions** 2

**Machine View** 4

**Operating Instructions** 5-7

Initial Setup 5

Adjusting Settings 6

Printing with your Heat Press 6-7

**Storage and Transportation** 8-9

**Replacement Parts List** 10

**Parts Location Guide** 11

**Electrical Schematics** 12

**Contact** 13

**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 20-amp rating.
    - If used, a minimum 12-gauge 20-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.
    - Rotate the left knob to adjust and calibrate to the temperature. Press and hold the left and right button together for 3 seconds to exit out of calibration mode.



## 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 during operations.
- Press and hold the left button for 3 seconds to toggle between °F and °C.

**Caution:** When pressing the left and right buttons, press the buttons in the center of the knob to ensure you're engaging controls. 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.

# Operating Instructions

- 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.

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.

- 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.

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.

**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.



**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.



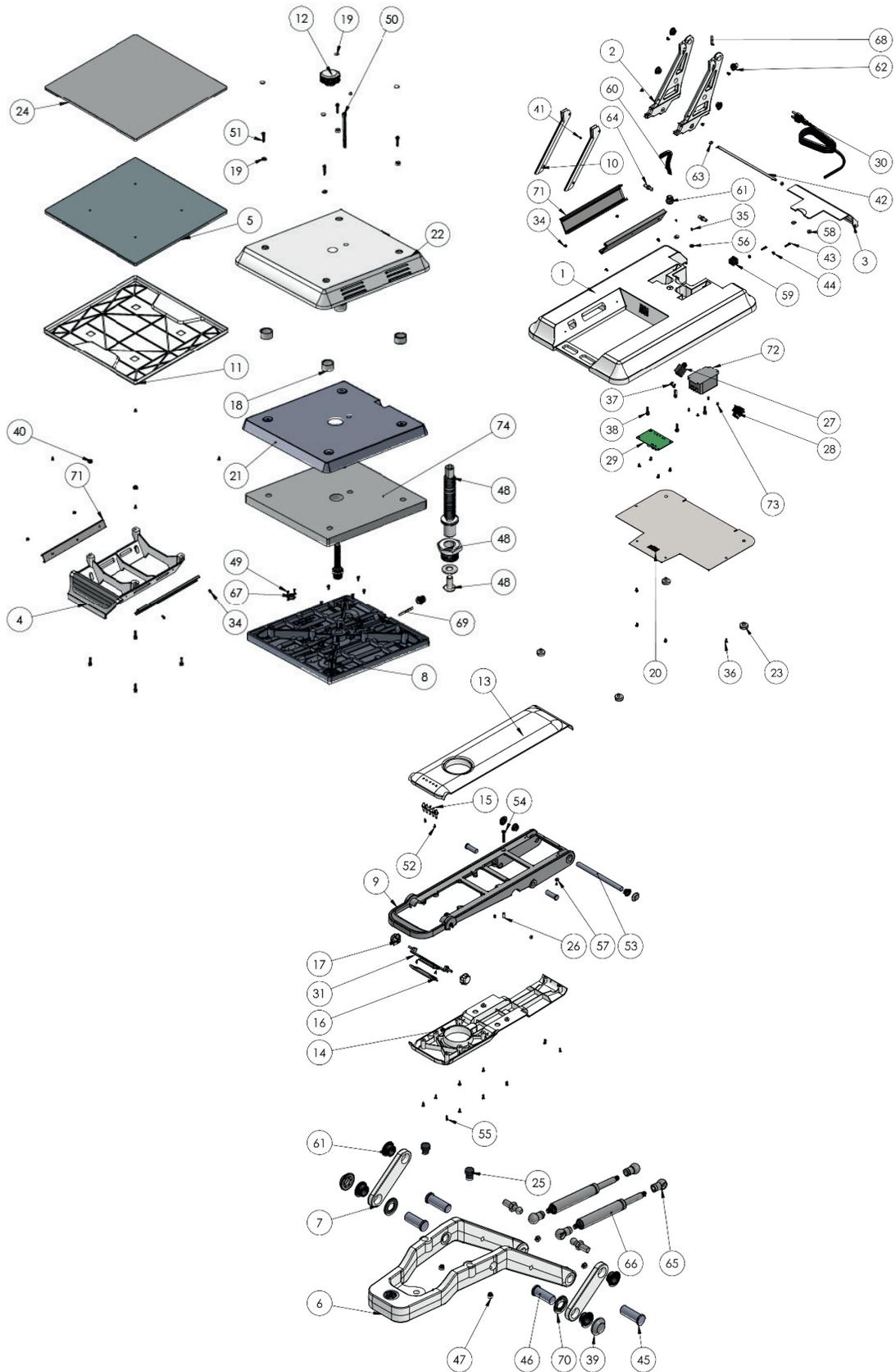
Slide in the two side foam pieces to hold the heater cover. Place the top foam to cover the heat press and close the box.

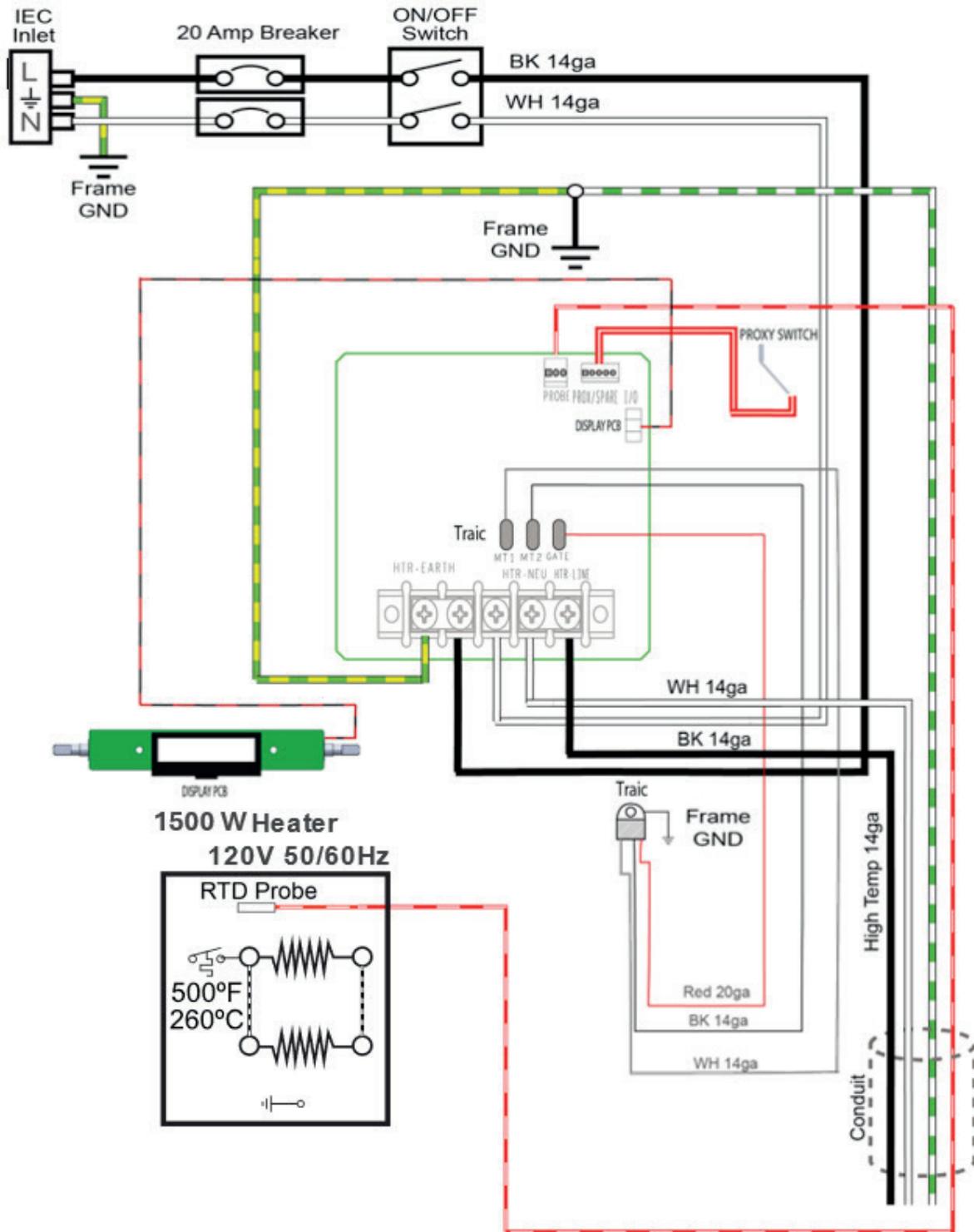
**NOTE:** When the heat press is stored or not in use, adjust the pressure to bare minimum (maintain slight contact between lower platen and heater) to keep the pressure buildup less between parts.

ITEM #	PART NAME	PART #	QTY
1	PROJECT 1515 BASE	3-1355	1
2	PROJECT 1515 FIN	3-1356	2
3	PROJECT 1515 CORD COVER	3-1357	1
4	PROJECT 1515 Lower Platen Molding	3-1358	1
5	PROJECT 1515 Lower Platen	3-1359	1
6	Project 1515 Heater Arm	3-1360	1
7	PROJECT 1515 LINK	3-1361	2
8	PROJECT 1515 HEATER	5-1000-1	1
9	Project 1515 Lever Arm	3-1362	1
10	PROJECT 1515 FIN COVER	3-1363	2
11	PROJECT 1515 PLATEN COVER	3-1364	1
12	PRESSURE KNOB	1-2709	1
13	Top Cover	3-1365	1
14	Bottom Cover	3-1366	1
15	LIGHT_GUIDE_15X15	1-2706-1	1
16	LENS	1-2707	1
17	Control Knob	1-2743	2
18	Washer Standoff	2-1006-127	4
19	White Washer Plastic Finishing Heater Cover	1-2720	4
20	PROJECT 1515 BASE PLATE	3-1367	1
21	Heater Insulation Sheet	1-2744	1
22	Project 1515 Heater Cover	3-1368	1
23	Rubber Foot	1-2710	4
24	Silicone Pad Black 15x15x0.25	1-2745	1
25	Rubber Foot Small	1-2711	2
26	RUBBER CAP	-	1
27	Breaker 20A	1-2746	1
28	Power Switch	1-2729	1
29	Power Board 1515 W/ FLEX CABLE 50"	1-2727	1
30	Power Cord Flying Leads (1600 mm long, 3 prongs, 0.35" dia., 10A/250V) USA	1-2747	1
	Power Cord Flying Leads (1600 mm long, 3 prongs, 0.35" dia., 10A/250V) UK	1-2748	1
	Power Cord Flying Leads (1600 mm long, 3 prongs, 0.35" dia., 10A/250V) EURO	1-2749	1
31	DISPLAY_PCB	1-2726	1
32	Wire kits 1515	1-2750	1
33	Triac 1515 16" long	1-2751	1
34	Passivated 18-8 Stainless Steel Phillips Flat Head Screw, 82 Degree Countersink, 8-32 Thread, 5/16" Long, Undercut	-	18
35	Phillips Flat Head Thread-Cutting Screw for Metal, Zinc-Plated Steel, 4-40 Thread, 1/4" Long	-	3
36	316 Stainless Steel Pan Head Phillips Screw, Super-Corrosion-Resistant, 8-32 Thread Size, 5/16" Long	-	13
37	316 Stainless Steel Pan Head Phillips Screw	-	2

ITEM #	PART NAME	PART #	QTY
38	SHCS 0.250-20 x 0.750	-	8
39	Hub Cap 1/2"	1-2714	4
40	RUBBER SPACER 0.5 OD X .23 ID X .1875	-	2
41	18-8 Stainless Steel Cup-Point Set Screw, 8-32 Thread, 1/8" Long	-	1
42	PROJECT 1515 CLEVIS PIN FOR CORD COVER	1-2752	1
43	Zinc-Plated Steel Pan Head Phillips Screw, 6-32 Thread, 3/4" Long	-	2
44	Mil. Spec. Low-Strength Steel Hex Nut 6-32 Thread Size, MS35649-262	-	2
45	PROJECT 1515 CLEVIS PIN	-	4
46	PROJECT 912 CLEVIS 1.25IN	-	2
47	Set Screw, 1/4"-20 x 1/4"	-	7
48	Spindle /BushingSet	1-2753	1
49	316 Stainless Steel Pan Head Phillips Screw, Super-Corrosion-Resistant, 4-40 Thread Size, 1/4" Long	-	2
50	Screw, Socket Head Cap 5/16"-18 x 4"	3-1011-315	1
51	Rounded Head Thread-Cutting Screws for Metal, Zinc-Plated Steel, 10-24 Thread, 1" Long	-	4
52	Phillips Rounded Head Thread-Forming Screws for Plastic, Zinc-Plated Steel, Number 4 Size, 1/4" Long	-	4
53	LEVER DOWEL PIN 15x15	1-2754	1
54	Passivated 18-8 Stainless Steel Phillips Flat Head Screw, 82 Degree Countersink, 1/4"-20 Thread, 1-3/8" Long	-	1
55	Zinc-Plated Steel Pan Head Phillips Screw, 6-32 Thread, 3/8" Long	-	10
56	Neodymium Ring Magnet 1/2inch ODX1/8 inch Thick	1-2722	2
57	Neodymium Ring Magnet 3/8" OD x1/8inch Thick	1-2723	1
58	Zinc Plated Steel Washer M4-D12x3mm	1-2725	2
59	heyco_1848	-	1
60	flexible conduit 1/2" diameter, 7" long Black Color	1-2719	1
61	Metal Conduit Fitting 0.500 HG	1-2716	2
62	Flange Bushing 0.5 inch	-	10
63	PROJECT 15X15 WASHER 0.25 IN	-	2
64	Ball Stud for Gas Spring, 1.19" Overall Length	1-2715	4
65	End Fitting for Gas Spring, Ball Socket	1-2718	4
66	Gas Spring, 90 lbs. Force, 5.9" Extended Length	1-2755	2
67	Thermal discs	1-2733	1
68	Firecracker Proximeter Switch 1515 LENGTH 15"	1-2756	1
69	Temperature Probe 1515	1-2721	1
70	Teflon Washer	-	2
71	Drawer Slide Set 8 inch	1-2757	1
72	Filter 20 Amp	1-2799	1
73	316 Stainless Steel Pan Head Phillips Screws, M3 x 0.50 mm Thread, 5mm Long	-	4
74	Wool insulation 1515	-	1

# Parts Location Guide







# MerchMaker

Start Making Merch Like a Pro.

Warranty Support &  
Customer Service

[www.hotronix.com/support](http://www.hotronix.com/support)



*This document includes multiple trademarks and describes equipment covered by many patents that are owned by GroupeSTAHL and/or its subsidiaries. GroupeSTAHL enforces its rights to protect these intellectual properties. ©2024*