

STEINEL[®]
PROFESSIONAL



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Information
HG 2520 E

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1. Round nozzle, 5 mm 2. Round nozzle, 10 mm 3. Round nozzle, 5 mm, extended
 4. Flat angled nozzle, 20x2 mm, (straight) 5. Flat angled nozzle, 40x2 mm 6. Flat angled nozzle, 30x2 mm



7. Flat angled nozzle, 40x2 mm, perforated 8. Flat nozzle, 60x2 mm, for bitumen
 9. Pressure roller, 50 mm 10. Pressure roller, 35 mm 11. Tarpaulin shears 12. Kehlfix



13. Weld slide 14. Welding nozzle 15. Fast welding nozzle, 3 mm 16. Fast welding nozzle, 4 mm 17. Fast welding nozzle, 5 mm



18. Fast welding nozzle, 3 mm, with narrow air slot 19. Fast welding nozzle, 4 mm, with narrow air slot 20. Fast welding nozzle, 5 mm, with narrow air slot
 21. Jointing plane 22. Quarter-moon knife



HG 2520 E

23. Soldering reflector nozzle 24. Reflector nozzle, 20 mm 25. Reflector nozzle, 35 mm 26. Sieve reflector nozzle, 30x20 mm 27. Sieve reflector nozzle, 50x35 mm

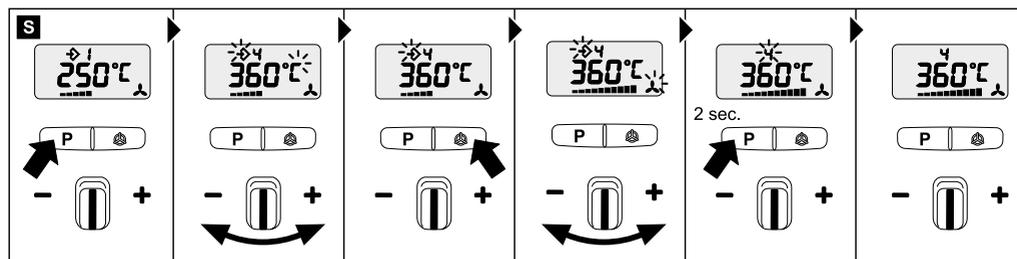
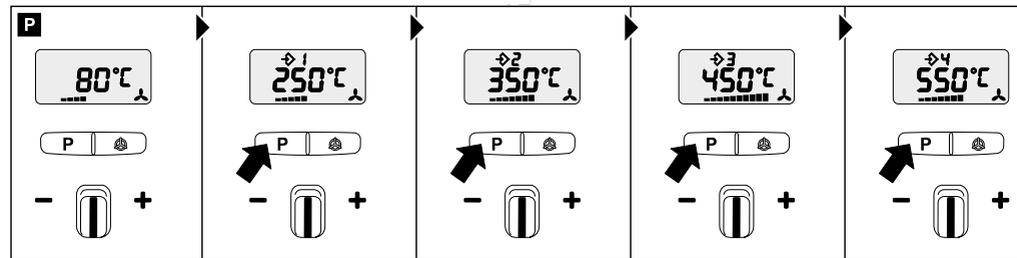


28. Shell reflector nozzle



29. HG Scan PRO





Thank you for deciding to choose a STEINEL heat gun. This tool can be used for completing a wide range of jobs safely and reliably, such as soldering, welding PVC, shaping, drying, shrink-fitting, stripping paint etc. All STEINEL tools are manufactured to the highest standards and undergo a strict process of quality control. Used in the proper manner, this heat gun will give you lasting satisfaction.

Please read carefully and keep in a safe place.
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 - Subject to change in the interest of technical progress.

Safety warnings

Read and observe this information before using the tool. Failure to observe the operating instructions may result in the tool becoming a source of danger.

When using electric power tools, observe the following basic safety precautions to avoid electric shock as well as the risk of injury and fire. Used carelessly, the tool can start an unintentional fire or injure persons. Check the tool for any damage (mains connection lead, housing etc.) before putting it into operation and do not use the tool if it is damaged. Do not leave the tool switched on unattended.

Children should be supervised to make sure they do not play with the tool.

First time of use

A small quantity of smoke may occur when the tool is used for the first time. This smoke is caused by binding agents released from the heater's insulating film during the first time of use.

To let the smoke escape quickly, the tool should be set down on its standing surface. The area you are

working in should be well ventilated when using the tool for the first time. Any smoke coming out of the tool is not harmful!

Take the ambient conditions into account

Do not expose electric power tools to rain. Do not use electric power tools when they are damp or in a damp or wet environment. Exercise care when using the tool in the proximity of flammable materials. Do not direct the tool at one and the same place for a prolonged period. Do not use in the presence of an explosive atmosphere. Escaping heat may be conducted to flammable materials that are hidden from direct sight.

Protect yourself from electric shock

Avoid coming in contact with grounded objects, such as pipes, radiators, cookers or refrigerators. Do not leave the tool unattended while in operation.

Safety warnings

Store your tools in a safe place.

After use, set the tool down on its standing surface and let it cool before putting it away.

When not in use, tools must be stored in a dry, locked room out of children's reach.

This tool may be used by children aged 8 or above and by persons with reduced physical, sensory or mental capabilities or lack of experience and knowledge if they are supervised or have been given instructions on how to use the tool safely and understand the hazards involved.

Do not allow children to play with the tool.

Children are not allowed to clean or carry out maintenance work on the tool without supervision.

Do not overload your tools.

Your work results and safety will be enhanced if you operate the tool within the specified output range. Do not carry the tool by the power cord. Do not unplug the tool by pulling on the power cord. Protect the power cord from heat, oil and sharp edges.



Beware of toxic gases and fire hazards.



Toxic gases may occur when working on plastics, paints, varnishes or similar materials.

Beware of fire and ignition hazards. For your own safety, only use accessories and attachments that are specified in the operating instructions or recommended or specified by the tool manufacturer.

Using attachments or accessories other than those recommended in the operating instructions or catalogue may result in personal injury.

Repairs must only be carried out by a qualified electrician.



This electric power tool complies with the relevant safety regulations. Repairs should only be performed by a qualified electrician. Otherwise the user may run the risk of accidents.

Safety warnings

Residual heat indicator



The residual heat indicator serves as a visual warning to prevent injury from direct contact with the hot nozzle outlet. The residual heat indicator also works when the tool is unplugged. The indicator starts working after the tool has been in use for 90 seconds and keeps flashing until the temperature at the nozzle outlet has fallen below 60 °C at room temperature. The residual heat indicator does not show if the tool has been in operation for less than 90 seconds. Responsibility always rests with the user as care must be taken at all times when handling hot air tools.

Keep these safety precautions with the tool.

For your safety

The tool is protected from overheating:

The thermal cut-out completely shuts down the tool if it is overloaded.

Tool description - Operation

Please note: The distance from the object you are working on depends on material and intended method of working. Always try out the airflow and temperature on a test piece first. Using the attachable accessory nozzles (see accessories page on the cover) the flow of hot air can be controlled with maximum precision.

Take care when changing hot nozzles! When using the hot air tool in the self-resting position, make sure it is standing on a stable, non-slip and clean surface. Switch-on procedures generate short-term voltage drops. In unfavourable grid conditions, adverse effects can occur on other devices. With grid impedances of less than 0.35 ohms, no disturbances are expected.

1. Operation

The tool is switched on and off at the ON/OFF switch  on the back of the grip handle. The joystick  is used for controlling temperature and airflow or fan speed.

2. Setting the temperature

Temperature can be infinitely varied over a range of 50-700 °C at the joystick on the control panel with LCD display. The actual temperature is measured at the hot air outlet nozzle and indicated on the display. The joystick  is used as an input button with plus/minus function.

Briefly pressing the "+/-" joystick increases or reduces the temperature setting in 10 °C steps. Keeping the joystick pressed speeds up the temperature setting process. Once the temperature has been set, the tool takes a few seconds to reach temperature (depending on speed/airflow). The temperature setting selected is shown on the display for 3 seconds. The display then shows the current actual temperature. The "°C/°F" symbol continues to flash until the selected temperature is reached.

If you want to alter the setting, simply press the joystick again to increase or reduce the temperature. After switching off, the hot air tool stays in the last setting.

3. Setting airflow rate

To change the airflow rate, first press the button for airflow mode ; the fan symbol flashes. Now use the joystick to set the airflow rate. The airflow rate setting mode automatically closes if the airflow rate setting is not changed within 5 s. Pressing the the airflow button again after setting the airflow rate immediately closes the airflow rate setting mode. The airflow rate can be varied from a minimum of 150 l/min to a maximum of 500 l/min.

4. Programming mode [P]

Four programmes are factory-set for the most common types of work. Press button "P" for programming mode. Number 1 is displayed for programme 1. Continuing to press the programme selection button will take you to programmes 2 – 4. Pressing the button again will return the tool to normal operation.

Preset programmes

Programme	Temperature °C	Air l/min
1	250	approx. 350
2	350	approx. 400
3	450	approx. 500
4	550	approx. 400

5. Memory function [S]

The values selected for the four programmes can be changed and memorised at any time. To do this, first press the programme selection button "P" ⑨ until the display shows the programme you wish to change. Set the temperature and airflow rate you require. The memory symbol  on the LCD flashes to indicate that the user programme selected has been changed. To record this setting in the user programme selected, press and hold down the programme selector button. The memory symbol continues to flash for approx. 2 s. The settings entered have been saved once the memory symbol stays on all the time. To return to normal operation, press the programme selection button until the programme symbol disappears from the display.

Temperature measurement on the workpiece

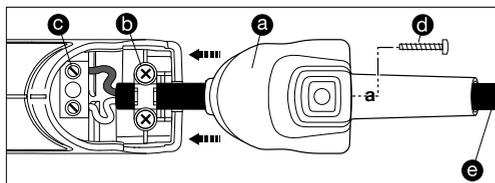
Use the STEINEL HG Scan PRO temperature scanner (Prod. No.: 007690) for measuring the temperature at the workpiece.

Heating element

The HG 2520 E hot air tool can be switched off directly after use. There is no need to let the tool cool down after the work process. This does not affect the heating element's life.

Repair

Changing the power cord ⑬

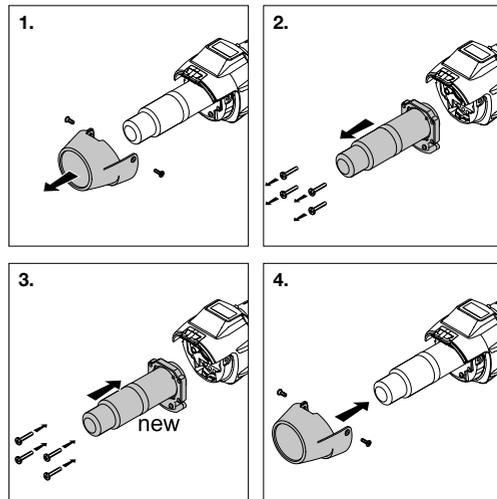


If the power cord is damaged, it can easily be changed without opening the casing.

1. **Important!** Disconnect tool from power supply.
2. Undo screw **a** and pull off cover cap **a**.
3. Release cable grip **b**.
4. Undo mains terminals **c**.
5. Pull out cable **e**.
6. Insert new cable and secure in reverse order (1. Firmly screw down mains terminals etc.).

Changing the heating element

The plug-in heating element in the HG 2520 E can be changed in a matter of seconds.



1. **Important!** Disconnect tool from power supply.
2. Undo guard sleeve screws (**Fig. 1**).
3. Remove guard sleeve (**Fig. 1**).
4. Undo 4 screws at the end of the hot air outlet nozzle (**Fig. 2**).
5. Detach heating element and replace it with a new one (**Fig. 2/3**).
6. Firmly screw heating element into place (**Fig. 3**).
7. Firmly screw guard sleeve back on (**Fig. 4**).

LOC function

To avoid altering the chosen settings unintentionally, the HG 2520 E comes with a Lockable Override Control Function (LOC). To find out how to set the LOC function, please contact our Service Department on +44/1733/366-700.

Tool features

- 1 Stainless steel outlet nozzle
- 2 Removable guard sleeve
- 3 Removable cap for mounting HG Scan PRO temperature scanner
- 4 Hanger
- 5 Residual heat indicator
- 6 LCD display
- 7 Soft coating for non-slip standing
- 8 Button for airflow rate mode
- 9 Programme selector button and memory button
- 10 Joystick (for setting temperature and airflow rate)
- 11 Air inlet
- 12 ON/OFF switch
- 13 Replaceable mains power cord
- 14 Heavy-duty rubber-insulated power cord
- 15 Soft grip handle for comfortable operation

Technical Specifications

Voltage	220-230 V, 50/60 Hz
Output	2300 W max.
Temperature	50-700 °C, continuously variable
Airflow rate	150-500 l/min, continuously variable
Air pressure	4000 Pa
Delivery nozzle Ø	30mm, using Professional nozzles
Brushless motor life	10,000 hrs.
Residual heat indicator	Yes
Power cord	H07 RN-F 2X1 3.0M
Protection class (without earth terminal)	II
Thermal cut-out	Yes
Emission sound pressure level	≤ 70dB (A)
Total vibration value	≤ 2.5 m/s ² / K = 0.08 m/s ²
Weight without power cord	0.84 kg

Subject to technical modifications

Applications

Here are some of the applications you can use STEINEL hot air tools for. This selection is by no means exhaustive – no doubt you can immediately think of other examples.

- Applying films in advertising and vehicle wrapping.
- Welding tarpaulins and films.
- Welding PVC floor coverings and linoleum.
- Working rigid thermoplastic materials in plastics and tank construction.
- Shaping thermoplastics.
- Drying wet surfaces.
- Activating and removing glues and hot-melt adhesives.
- Drying and heating processes of all kinds.
- Smoothing leather.

Guide for selecting the right type of welding rod for welding plastics

Material	Applications	Characteristic signs
Rigid PVC	Pipes, fittings, tiles, structural sections, technical mouldings 300 °C welding temperature	Chars when held in flame, pungent odour; crashing sound
Rigid PE (HDPE) Polyethylene	Tubs, baskets, canisters, insulating material, piping 300 °C welding temperature	Light yellow flame, drips continue to burn, smells of a candle being extinguished; crashing sound
PP Polypropylene	High-temperature drainpipes, seat buckets, packagings, automotive parts 250 °C welding temperature	Bright flame with a blue core, drips continue to burn, pungent odour; crashing sound
ABS	Automotive parts, equipment enclosures, cases 350 °C welding temperature	Black, fluffy smoke, sweet odour; crashing sound

Accessories (see Fig. on page 2.)

1	Round nozzle, 5 mm	Prod. No. 092214
2	Round nozzle, 10 mm	Prod. No. 092313
3	Round nozzle, 5 mm, extended	Prod. No. 009076
4	Flat angled nozzle, 20x2 mm	Prod. No. 092115
	Flat angled nozzle, 20x2 mm, straight	Prod. No. 013240
5	Flat angled nozzle, 40x2 mm	Prod. No. 092016
6	Flat angled nozzle, 30x2 mm	Prod. No. 011925
7	Flat angled nozzle, 40x2 mm, perforated	Prod. No. 009083
8	Flat nozzle, 60x2 mm, for bitumen	Prod. No. 009090
9	Pressure roller, 50 mm	Prod. No. 093211
10	Pressure roller, 35 mm	Prod. No. 006785
11	Tarpaulin shears	Prod. No. 010423
12	Kehlfix	Prod. No. 011833
13	Weld slide	Prod. No. 093013
14	Welding nozzle	Prod. No. 075316
15	Fast welding nozzle, 3 mm	Prod. No. 010263
16	Fast welding nozzle, 4 mm	Prod. No. 010270
17	Fast welding nozzle, 5 mm	Prod. No. 010287
18	Fast welding nozzle, 3 mm, with narrow air slot	Prod. No. 009106
19	Fast welding nozzle, 4 mm, with narrow air slot	Prod. No. 011765
20	Fast welding nozzle, 5 mm, with narrow air slot	Prod. No. 011840
21	Jointing plane	Prod. No. 093112
22	Quarter-moon knife	Prod. No. 092917
23	Soldering reflector nozzle	Prod. No. 011871
24	Reflector nozzle, 20 mm	Prod. No. 011857
25	Reflector nozzle, 35 mm	Prod. No. 011864
26	Sieve reflector nozzle, 30x20 mm	Prod. No. 010416
27	Sieve reflector nozzle, 50x35 mm	Prod. No. 010409
28	Shell reflector nozzle	Prod. No. 011888
29	HG Scan PRO	Prod. No. 007690

CE Declaration of Conformity

(refer to page 160)

Functional Warranty

This STEINEL product has been manufactured with utmost care, tested for proper operation and safety and then subjected to random sample inspection. STEINEL guarantees that it is in perfect condition and proper working order.

The product is guaranteed for 12 months or 10,000 hours of operation commencing on the date of sale to the consumer. We will remedy defects caused by material flaws or manufacturing faults. The warranty will be met by repair or replacement of defective parts at our own discretion. This guarantee does not cover damage to wearing parts, damage or defects caused by improper treatment or maintenance nor does it cover breakage as a result of the product being dropped. Further consequential damage to other objects shall be excluded.

Claims under warranty shall only be accepted if the product is sent fully assembled and well packed complete with sales receipt or invoice (date of purchase and dealer's stamp) to the appropriate Service Centre or handed in to the dealer within the first 6 months.

