



HM-TC -C 系列

卡片烫金机操作说明书

HM-TC1016C

HM-TC1020C

Card flat stamping machine

Operation Instruction



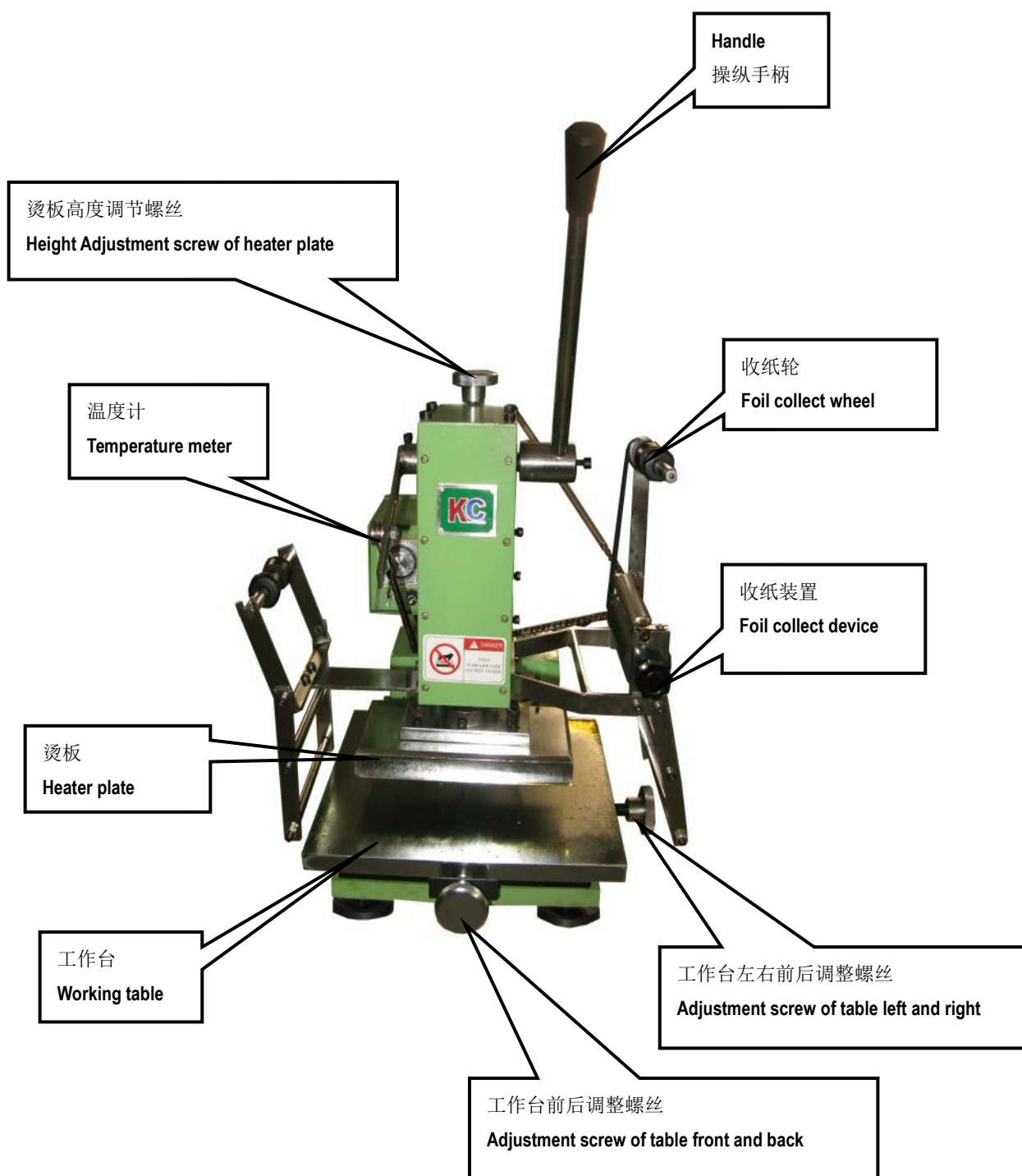
KC Printing Machine (Group) Limited 10-1

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• 主要结构 Mainly structure





自动温度控制系统

Auto-aromatically temperature controller

机械自动卷纸装置;

Mechanical auto-foil collect device

烫板装置;

Stamping head device;

工作台机构

Working table system.

● 概述 Summarize

用途 Usage

- 1、烫金机属手动烫金机，可作小面积烫金，也可用于小面积压痕。
- 2、广泛应用于烫金各种名片、橡胶、相片、纸张、皮革、塑料、各种食品及化妆品硬包装等印件上的电化铝图案。
- 3、为了使用户能够正确地使用本烫金机，请用户在使用前仔细阅读本说明书，若有不明之处或其它问题，可随时与本公司联系。

1. Operating with hand , suitable for stamping smaller size objects;;
2. Widely used for gilding on cards, Rubber, Film, wooden, Paper, Leather, Plastics, cosmetic industry field.
3. Please read carefully the instruction before use this Machine.

主要技术参数 Mainly technology parameter

该类型平面烫金机可以根据客户需求定制不同面积的烫金版，目前，我公司常备的有两种型号：其技术参数如下

There are two models stamping plate in stock . other dimension stamping plate need order.

机器型号 Model	TC1016C	TC1020C
烫板尺寸 Dimension of stamping plate	100 × 160 mm	100 ×200mm
工作台尺寸 Dimension of working table	250 ×280mm	250 ×280mm
最大印刷压力 Max Pressure	500 Kg	500 Kg
上下行程 Stroke of up and down	40mm	40mm
加热功率 Heater wattage	500 W	500 W
输纸方式: Feeding way	机械驱动 Chain drive	机械驱动 Chain drive
温度范围 temperature	0-299oC	0-299oC
净重 Net weight	35kg	35kg

温度设定参考

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Temperature setting reference

1	纸张/ Paper	85-120	
2	软 PVC/soft PVC	65-80	
3	软塑料/ Soft Plastics	75-85	
4	硬塑料/rigid Plastics	100-135	压痕温度/Press-ion Temperature
5	人造革、皮革/Leather	75-85	120-150
6	牛皮/Cow leather	100-135	
7	合成革仿皮/ Synthetic leather	160-180	

以上温度设定仅供参考，用户可以根据烫印过程中出现的问题进行比较的调整。

Please adjust the temperature according to stamping process.

● 操作程序：

Operation Process

1、接通电源，温控仪上红色电源指示灯亮起，调节设定盘，使红色指针指向设定温度，绿色指示灯亮起，设备进入预热状态。

This machine used 220V one phase power supply. Please insert the power line to power seat. The indicator of temperature controller lights up. Please set the temperature according to materials to be stamped.



Power Line

2、安装烫印模板

烫印模板可以是铜版， 锌版， 硅胶板， 树脂版。

Copper plate, ZN-plate, silicon rubber plate, Polymer plate used with this machine;

Please install stamping block with below method:

固定到热模上，依工件尺寸调节升降螺杆和工作台微调螺钉，定出规矩位。

固定方法：

A、 用双面胶或高温胶直接粘到上模上。

Adhere stamping block with Double-faced adhesive tape or high temperature paper;

B、 用白乳胶中间加薄纸介层固定到上模。



High Temperature emulsion-paper

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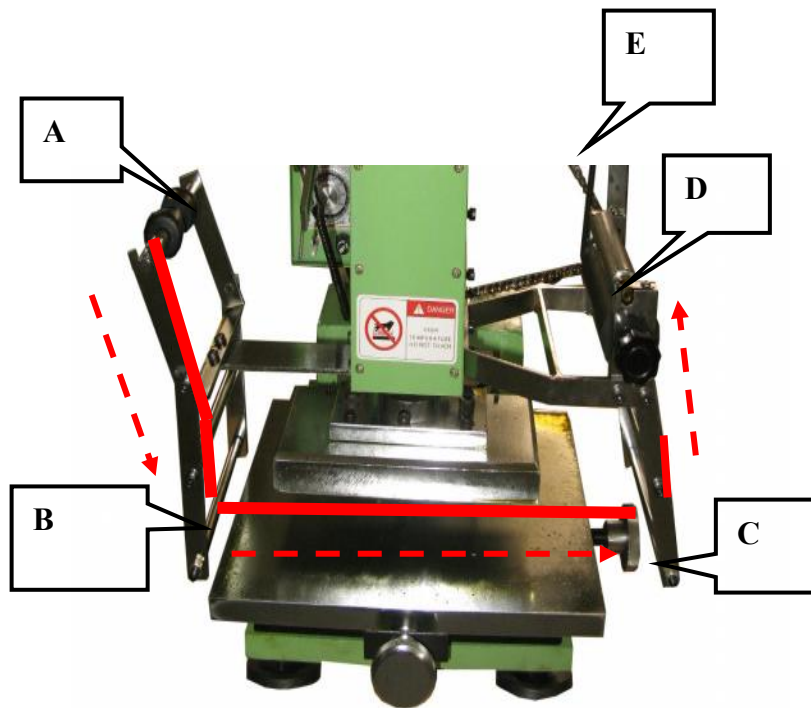
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Adhere stamping block with PVAC Coating on double face of paper;



C. 用高温胶水粘贴上模。

Adhere stamping block with high temperature glue

3、安装烫金纸.

Install stamping foil

将电化铝箔依图安装到设备上。

(根据烫印材料选择电化铝型号)。

安装方法如下：

A、把电化铝箔安装在放纸杆 A 上调正铝箔位于烫印面的正下方。用两橡胶定位轮固定好后，拉出铝箔沿箭头方向依次经撑纸杆 BC，后让铝箔从胶辊与滚花

辊中间 D 处穿过，然后固定在收纸杆 E 上。

B、把电化铝箔安装在放纸杆 A 上调正铝箔位于烫印面的正下方。用两橡胶定位轮固定好后，拉出铝箔沿箭头方向依次经撑纸杆 B 后，让铝箔从胶辊与滚花辊中间 C 处穿过。



烫金纸
stamping foil

Please ensure the glue layer of stamping foil contact with objects to be stamped;

Please cut the foil according to the width you want to stamp with foil cutter;

First put stamping foil on the rod of A;

Take one end of stamping foil , across B C and through Press-roller D.

Please ensure the stamping foil can cover all surface of object to be stamped.

4、根据烫印面积，调节工作手柄异侧的卷箔摆杆上的调节螺钉，选定螺钉位置，使卷箔长度适合（注：本机卷箔长度的控制是依摆动的幅角大小来实现的）。

According to stamping size, Please adjust the length of stamping foil feed.

5、待温度达到定温度后，绿色指示灯熄灭，设备自动恒温，此时可心放上工件，压下手柄，依不同工件的材料等选择压下时间即烫印时间，松开手柄完成一次烫印。

When the fact temperature come up to the setting temperature, The green indicator of temperature controller will be lights out, Then you use the machine to test and stamp

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● 参数的设置与调整

Setting and adjusting Parameter of Stamping process

1、温度的设置: Temperature setting

不同的烫印材料, 要有不同温度与烫印箔, 应根据材质温度所需设置好温度。

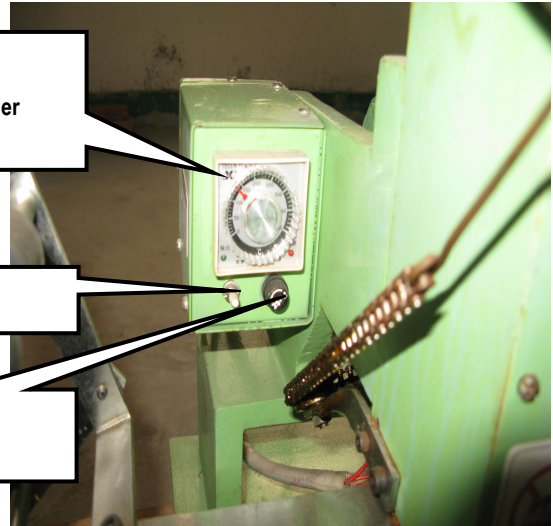
(See also temperature controller), different stamping materials , setting different stamping foil and temperature. It is very simple to set the temperature.

温度控制器

Temperature controller

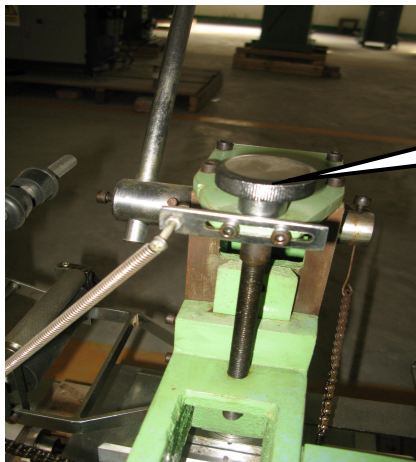
开关 Switching

保险丝 Fuse



2、工作压力的调整:

Pressure adjustment



烫板高度调节旋钮

Height adjustment screw of
stamping plate



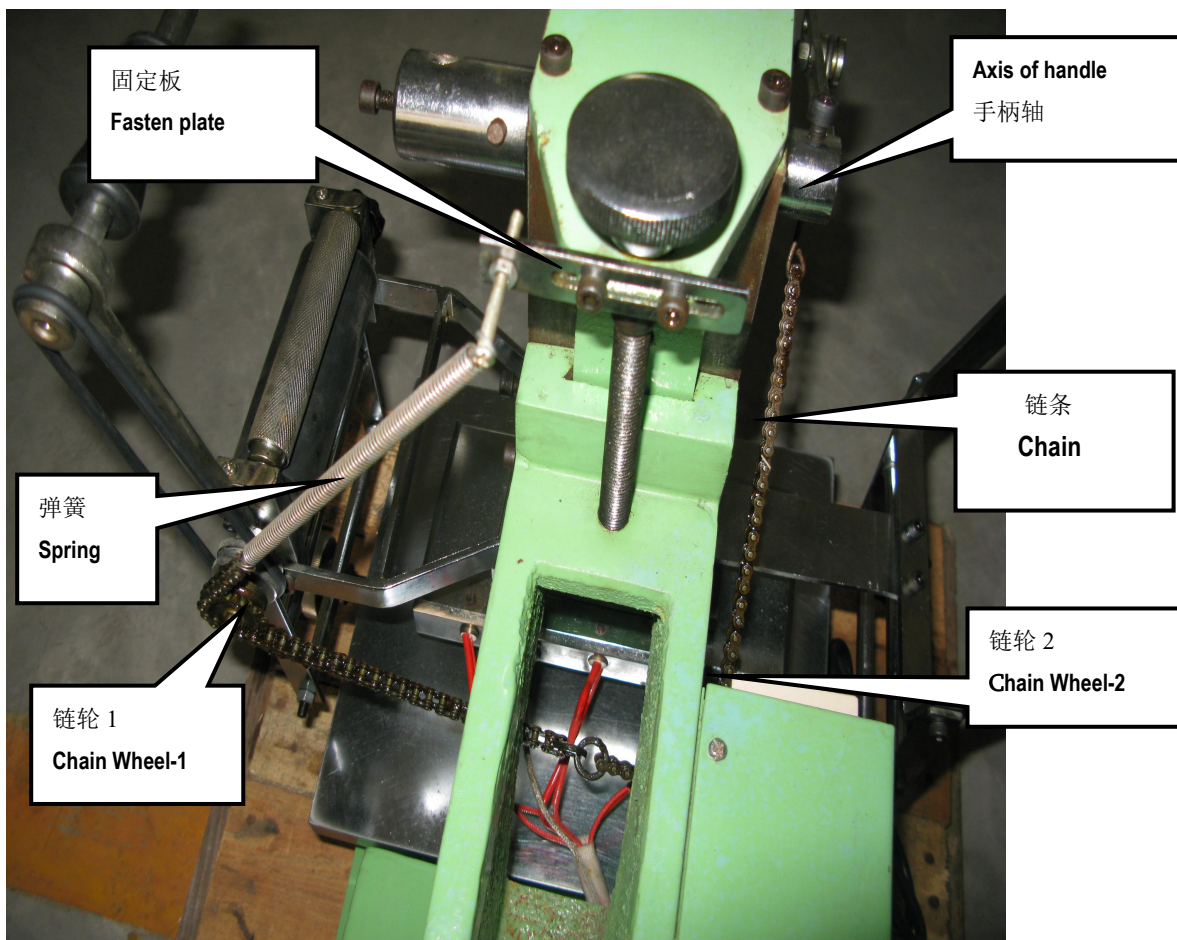
HM-TC1016C and HM-TC1020C card stamping machine installed one adjustment screw on the top of stamping head. Please adjust the height to adjust the stamping pressure.

为了压力均衡，你可能需要调整烫板上面的螺丝来达到目的。

In order to balanced pressure, You need to adjust four screws on the stamping plate.

3、卷纸长度的调整：Length of foil feed

HM-TC1016C and HM-TC1020C 卡片烫金机的卷纸长度的调整和其他使用电机驱动方式不同，它们是利用杠杆的原理来完成的。



The foil feed device of HM-TC1016C and HM-TC1020C card stamping machine is different from other type Pneumatic stamping machine.

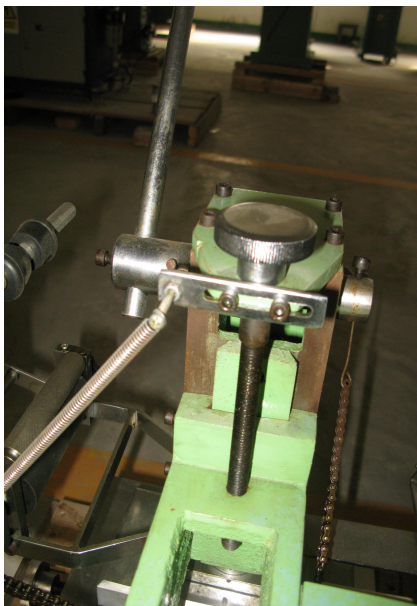
当使用手柄压下烫头时，手柄轴的槽型摆轴会随着上下动作执行摆动，安装在摆轴上面的链条通过链轮 2，链轮 1，带动收纸轴转动，手柄压下时链条转过的长度越大，烫金纸输送的长度也越大。

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调节滑块的位置可以调节卷纸长度，
滑块越靠近转轴，卷纸的长度越小；

Adjust the position of slide to adjust
the length of foil feed. The more closer
to handle axis, the more shorter the foil
feed.

4. 工作台位置的调整。

Position Adjustment of working table

调节工作台的位置可以更加方便的执行烫印精度，根据用户的需求，对于烫印位置的精细调整是通过调整工作台的左右和前后位置来达到。

● 使用烫金机的有关事项：

● Considerations

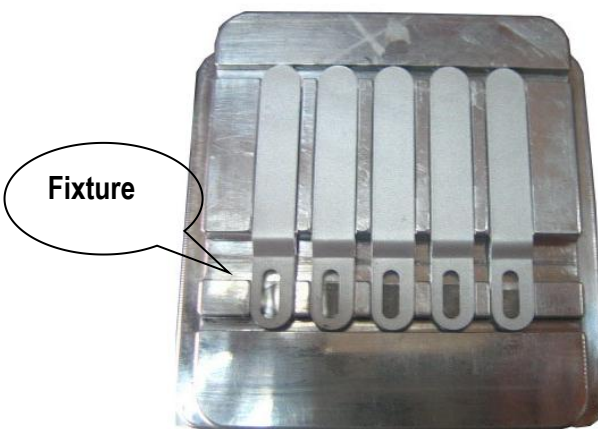
1、要根据烫印件的烫印面积以及形状选择合适的模具，预制好夹具等。

It is important to make appropriate fixture on the basis of stamped objects. Metal plate is suitable for soft substrates such as Paper, wooden, leather; Rubber plate is suitable for rigid substrates such as Plastics.

2、烫印时，要保证烫印板与烫印面的紧密接触。

Ensure stamping plate contact compactness with the surface of object stamped when working.

3、操作前应检查电路以及机械部分是否良好。



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Please inspect , circuit and machine structure .

4、不同质地的印件要求不同的烫金纸，要根据印件选择与其相符的烫金纸。

Please choosing stamping foil consonant with object to be stamped.

5、工作过程中，不要将身体某部位倾向烫印模块。

Please do not touch stamping head because of high temperature while working.

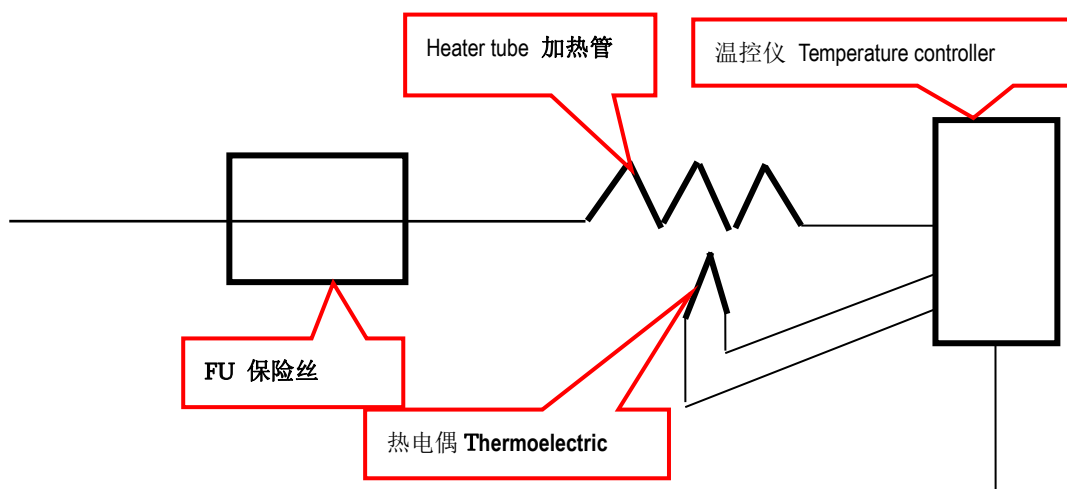
6、若操作者离开工作现场，必须关掉气源、电源。

Shut off Air source and Power source when the operator leaving.

• 电气原理图 Electron component particulars

序号 No.	电器符号 Symbols	名称 Name	型号 Model	数量 Qty
3	R	加热管 Heater	Φ10×150	3
5	FU	熔断器 Fuse	3A	1
7	TEG	温控仪 Temperature controller	TEG-01	1
13	QT	热电偶 Thermoelectric	K/2M	1

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● 日常维护及故障处理: Maintain and trouble shooting

- 1、保持设备的干净。

Keep the machine clean.

- 2、定期对设备的“活动”部位进行清洁、润滑，把纵向、横向等活动部添加机械润滑油。

Regularly clean and add lubricating oil

- 4、若烫金机不动作，为了安全，避免一切意外损失，查找线路故障时必须由专业电工，按照以下程序进行检查。

When machine not working, Please ask specialized electrician to look up circuit malfunction so that avoiding unexpected loss.

- 1)、电源输出端的电压是否正常。

Check the output voltage of power supply if normal

- 2)、熔断器是否熔断。

Check the fuse if break

- 3)、电源开关是否打开。

Check the switch if switch on

十二、常见烫印图案缺陷原因分析: Stamping trouble- shooting

- 1、图案呈方向性缺少。 **Directionless lack pattern**

A、烫印模与烫印面吻合不好。 Stamping plate is not in-oscultates with objects

B、烫印板不平。 Stamping Plate is uneven

- 2、烫印不上或不齐。 **Can not stamped**

A、温度过低。 Temperature too low

B、压力过大。 Pressure too big

C、烫印纸选择不当。 Stamping foil is not suitable for objects

- 3、图案模糊烧焦 **Patten vague or scorch**

A、压力过大。 Pressure too big

B、温度过高。 Temperature too high

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