

Hydraulic-pressure hot stamping machine

HH-TC3040LP

HH-TC4040LP

Operation Instruction



东莞市高宝印刷机械科技有限公司

KC Printing Machine (group) limited 29-1

Website: [Http://www.dg-padprinter.com](http://www.dg-padprinter.com)

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Company Profile



KC Printing Machine specializes in manufacturing of hot stamping machines. For many years by advanced technology from abroad and practical experiences of our country, our company has successfully developed the products with unique performance and new structure -- KC series gilding and impressing machine, manual/electric/pneumatic rolling ironing machine, gilding brander, heat transfer printing rolling ironing machine, auto-forgery prevention branding machine, full automatic PVC synchronization gilding machine, couplet gilding machine, foil cutter and manual nameplate numbering machine, etc. The series is currently the most ideal and advanced gilding & impressing equipment both at home and abroad. Also, our company can manufacture different kinds of non-conventional type equipment according to the user's demand. Our company would like to work together with clients to realize the magnificent prospect in the principle of credit uppermost, quality first and service first.

高宝印刷机械科技有限公司是专业的烫金机，移印机，网印机的生产厂家，多年来致力为用户提供高品质的特种印刷设备，高宝品牌的特种印刷设备糅合了国外最先进的技术，结合国内的实践经验，产品深受全球用户的推崇。

东莞市高宝印刷机械科技有限公司**KC Printing Machine (group) limited 29-2**Website: [Http://www.dg-padprinter.com](http://www.dg-padprinter.com)Online contact Skype: [yingsuhuakelven](#) QQ: 726986799 Whatapp: 0086-13592766499Email: cjscbsf@126.com 13592766499@VIP.163.com



HH-TC 大平面液压烫金机

一、概述 Summarize

- 1、该系列烫金机属液压式大压力烫金机，可作大面积烫金，也可用于压痕和模切。
- 2、该烫金机应用范围较大，广泛应用于烫金各种名片、橡胶、照像、木材、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. Lever type large-dimension flat Hydraulic stamping machine for gilding ,impress and die-cutting;
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.

二、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，我公司常备的有四种型号：其技术参数如下

There are four dimensions stamping plate in stock . other dimension stamping plate need order.

机器型号 Model	TC3040LP	TC4040LP	TC4050LPT	TC4060LPT
烫板尺寸				
Dimension of stamping plate	300 × 400 mm	400 × 400mm	400 × 500 mm	400 × 600 mm
工作台尺寸				
Dimension of working table	650 ×500mm	650 ×500mm	800 ×520mm	800 ×520mm
最大印刷压力				
Max Pressure	15000 Kg	15000 Kg	25000 Kg	25000 Kg
上下行程				
Stroke of up and down	60mm	60mm	60mm	60mm
加热功率				
Heater wattage	2500 W	2500 W	2500 W	2500 W
输纸方式:				
Feeding way	电机驱动	电机驱动	电机驱动	电机驱动
温度范围	Motor drive	Motor drive	Motor drive	Motor drive
temperature	0-299oC	0-299oC	0-299oC	0-299oC
净重				
Net weight	700kg	704kg	706kg	710kg

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三、安全注意事项

1. 应避免在下述场合使用液压烫金机。

堆积易燃易爆物品的场所；

潮湿，容易漏电的场所；

灰尘漂浮的区域；

底基不稳定的区域。

2. 电源

电源范围： AC220V (+-) 10%的波动范围；

频率变动范围： 50HZ (+-) 1HZ 波动范围；

电源线务必可靠接地。

3. 液压系统：



建议选用壳牌 ISO-VG32 抗磨液压油；

正确的油泵压力为 6-8MPA (60-80kgf/cm²)

4. 工作环境；

气温： 18-20 度之间；

湿度保持在 65%-85%之间；

海拔保持在 1500M 以下。

警告：

启动油泵前，务必使操作面板上的所有开关都处于关闭状态；

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最好将机器的四角固定后使用机器，防止机器滑动；

烫板温度高，应避免烫伤。

It is adverse for safety if the machine is installed in any place below. In addition, the machine may be in failure so that you'd better avoid the installation in any place below.

1. Combustible and explosive place
2. The place where the water may be drop or splashed or there is electricity leakage.
3. Humid place
4. Place with much dust.
5. Place in intense vibration.
6. Unstable or not flat place.

2.Power supply

Use stable power supply in right way and keep earth wire connected.

1. Voltage regulation: Within AC220V $\pm 10\%$
2. Frequency regulation: Within 50Hz ± 1 Hz.
3. Please make sure that the power cord of machine is connected to the power supply with earth wire.

3. Air supply: (selection: vacuum workbench or vacuum chuck mould)

Correctly use the stable air supply of which the pressure can not vary much.

The pressure of air supply used for the machine is: 6~8Mpa (60~80kgf/cm²)

4. Hydraulic system:

Select stable ISO VG32 antiwear hydraulic oil of "Shell" and the oil pressure of oil pump can not be too high

The pressure of oil pump correctly used for the machine is: 6~8Mpa (60~80kgf/cm²)

5. Working environment:

In order to keep the machine in good condition and facilitate use, the machine shall be in the following environment and conditions.

1. Keep air temperature within 18°C ~ 20°C.
2. Keep humidity within 65%~85%.
3. Keep altitude ≤ 1500 mm.

6. Correct operation of the machine

In order to keep the machine in good condition and facilitate the use, the operator shall pay attention to the following points.

1. The oil pump and oil tank for the machine shall adopt ISO VG32 antiwear hydraulic oil of "Shell" and it is not allowed to add other hydraulic oil to avoid the influence on normal working performance of hydraulic system.
2. Before the oil pump is started up, please make all switches on operation panel to "OFF" status. The machine shall be at original position.
3. 4 feet of the machine shall be locked, fixed and located well in operation to prevent the machine from sliding.
4. Please wear the gloves when the mould is replaced or hot printed to prevent scald.
5. The limbs of people can not enter the machine when it is in operation to prevent personal injured.
6. Please never litter articles on the machine or knock or crash machine parts.

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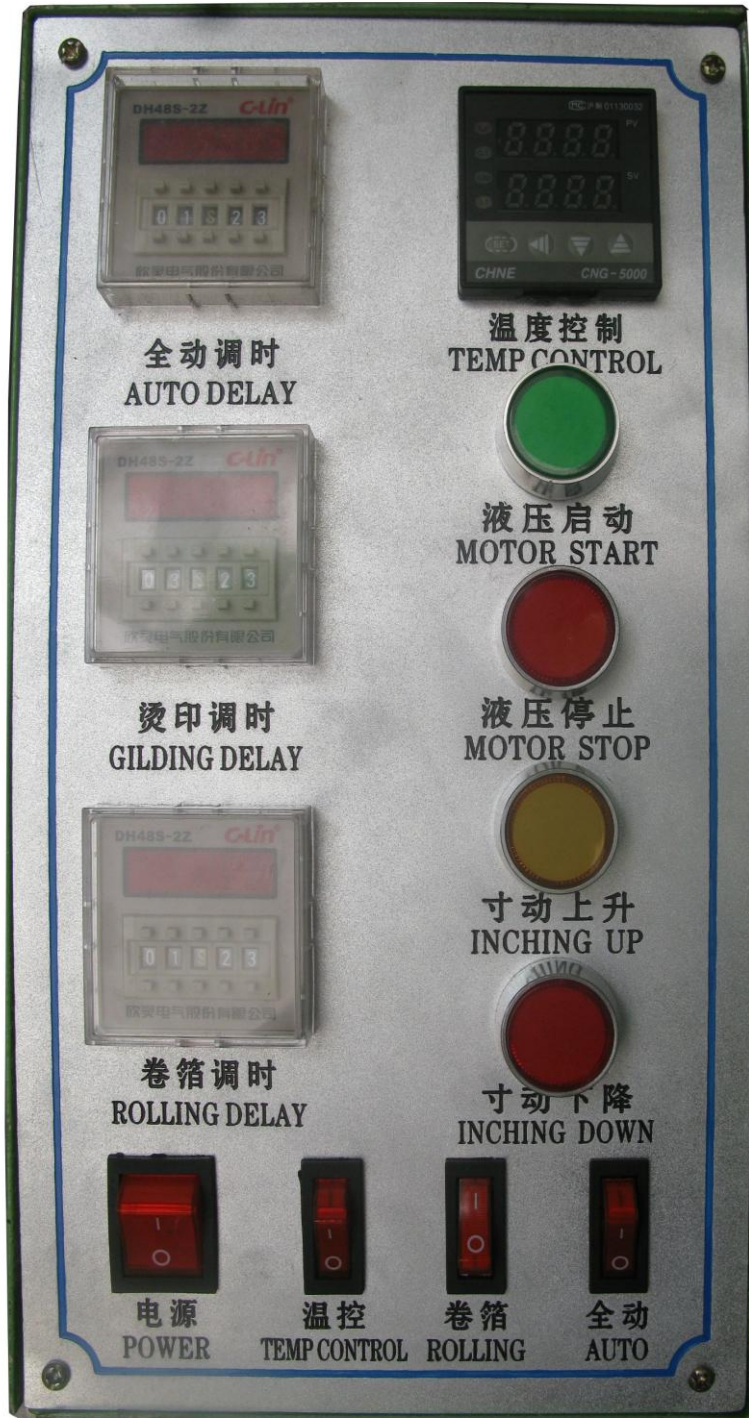
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7. Please never cut off the power when the machine is in operation so as to prevent the object from damage for pressing.
8. Please keep the magnet away from the control box.
9. Please keep combustible or explosive gas or liquid away from the machine.
10. Please never use machine in combustible or explosive place.
11. The waste oil used by machine shall be stored in the place designated by the government, not discharged into sewer,

soil or water.

12. Please connect power cord well and make sure earth wire in good contact to prevent that the leakage leads to the fire or electric shock.
13. Please never make the machine or other object cover main power switch.
14. Please cut off the power if the machine is not used for a long time.
15. The machine shall never conduct the hot printing of products not approved by copyright owner at home and abroad.



电气面板图 Operation panel instruction

1. 烫印调时: 加热模板下行, 与烫印件、工作平台、吻合之停留时间即烫印时间, 数值越大, 滞留时间越长。

Stamping timer: when stamping plate press down and contact with objects, it is used to adjust the time, the number is more big and the time of stamping is more longer.

2、卷箔调时: 控制卷箔马达拉电化铝距离, 数值越大, 电化铝距

离越长。

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Collecting testing: adjust the distance of foil-pulling , the number is more big and the distance of foil rolling is more longer.

3、**温控仪**: 调节加热模板的温度值, 反映烫金温度本机为智能温控, 自动调节。

Temperature controller: adjust the temperature range of heater according to different materials and quality

4. **液压启动**: 按动按钮, 液压站开始启动。

Hydraulic start: press this button make the Hydraulic station start..

5、**液压停止**: 按下这个按钮, 液压站停止工作。

Hydraulic stop: Press the key one time, The hydraulic station stop working

6. **寸动上升; Inching up.**

Press this key, The stamping heat will be up inching movement.

7. **寸动下降: Inching Down.**

Press this key, The stamping heat will be down inching movement.

8、**电源开关**: 上为开, 下为关。

Power supply: Turn the switch to the up position and electron connecting with machine. When you left from the machine, Please shut off the switch.

9、**温控开关: Temperature**

打开或者关闭温度控制器。

Open or close temperature controller.

10. **卷箔: Rolling :**

Foil feeding switch, open and shut off foil motor.

11. **全动: AUTO**

Run this machine with full automatically mode.

四、烫印温度参考: Stamping temperature

纸张(Paper): 85-120℃ 软 PVC(Soft PVC): 65-80℃

软塑料(Soft plastics): 75-85℃ 硬塑料(Rigid plastics): 100-135℃

人造革、皮革(Leather) : 120-150℃ 合成革仿皮(Synthetic leather): 160-180℃

以上温度为操作者操作机器时初始设定的温度, 在测试过程当中, 需要根据烫印产品的质量进行微调, 如出现烫印不牢或者烫印箔剥落现象, 可适当调高温度。 同时选择最适合的烫金纸时保证最佳牢度的关键环节。

五、参数的设置与调整 Setting and adjusting Parameter of Stamping process

1、**温度的设置: Temperature setting**

(参见智能温度仪的有关事项) 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。

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(See also temperature controller), different stamping materials , setting different stamping foil and temperature.

2、时间的设置: Time setting

烫印调时与卷箔调时设置方法相同，设置时应在通电时设置，例如：“44s38”，表示 44.38 秒，“M”为分钟，“H”为小时，“22H12”为 22.12 小时，本机出厂设置为“S”秒。

It is same between adjusting stamping testing and foil collecting testing. Please set them when power supply connect . For an ample: “44s38” meaning 44.38 seconds, “M” instead of minutes, “H” instead of Hour, “22H12”meaning:22.12 hours. The machine set as “seconds ”out of factory.

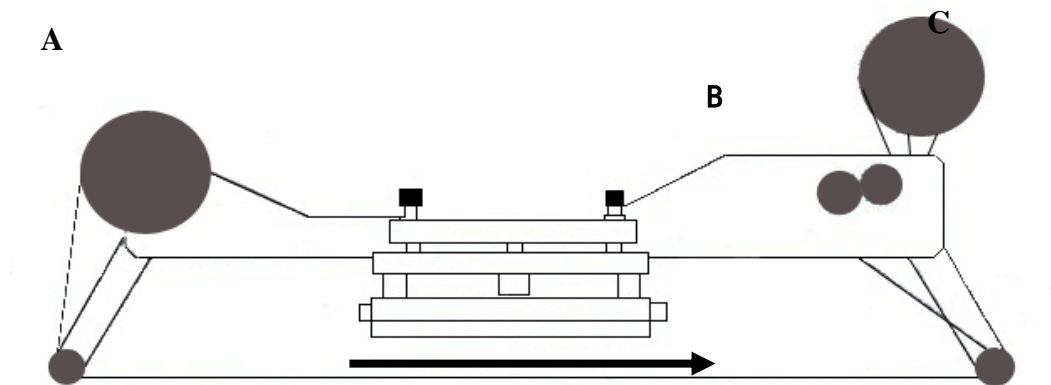
3、工作压力的调整: Pressure adjustment

本机为杠杆传动，调整压力时将加热模板与工作台紧密接触，用手旋转工作台下方法柄，使丝杆上升，上升到 3-4mm 左右时，产生的压力即为设备的最大压力，用户应根据烫印件选择合适的参数。

烫印时若压力过小，应旋转手柄使丝杆上升（缩短工作行程），若压力过大，应旋转手柄，使丝杆下降（增加工作行程）。

The pressure generated from Level cylinder installed on stamping head. Please rotate the handle below the working table and rise it up for 3-4mm with hands when stamping plate contact with working table. The pressure too small, rotate the handle and make screw mandrel rise up; the pressure too big, rotate the handle and make screw mandrel down.

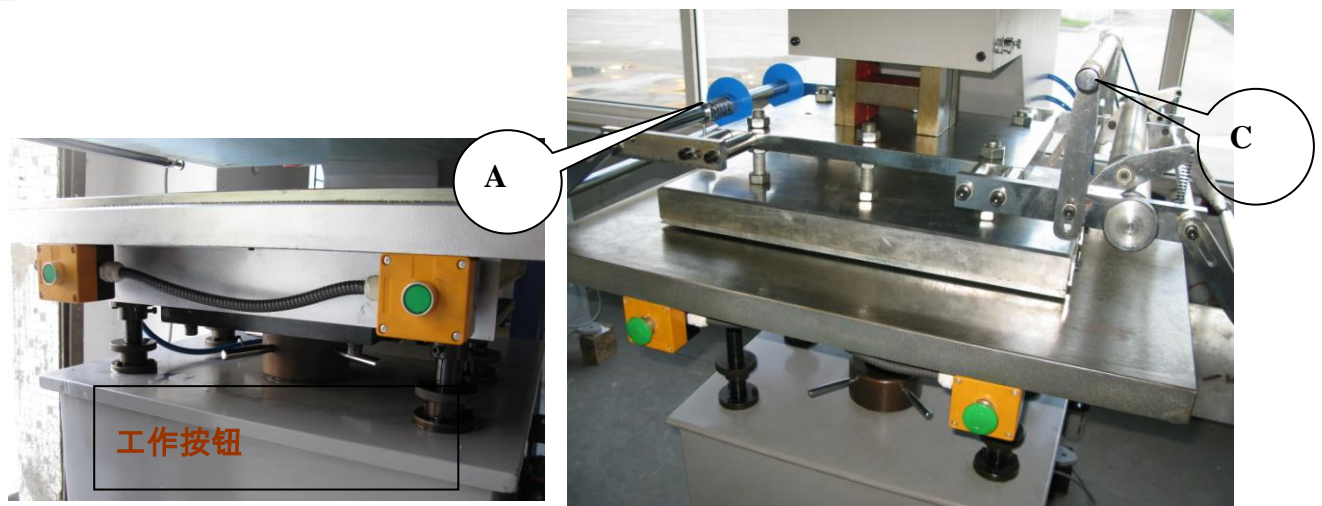
4、电化铝的安装与调整（见下图） Install foil



A. 根据工件的性质选择合适的烫金纸。

Choosing suitable stamping foil according to the substrates to be stamped

B. 烫金纸安装于下图，把金箔安装到放纸轮 A 上固定好后，拉出箔沿箭头方向绕，用手转动卷纸手轮 B，让金箔从胶辊和光螺中穿过，然后固定在收纸轮 C 上。



Install foil on the wheel A and fix it, Pull it and across along the direction of arrow. Then pass through rubber roller and steel roller, roll it on the collecting wheel C.

C. 调整烫金纸的位置，使其处于烫印面的正上方，然后用定位环定位。

Adjust the position and make it locate above the stamped objects, Then fix it with Location loop.

D. 调节拉杆的长度和摆角，使烫金纸距离烫印模板 10mm 左右。

Adjust the length and angle of steel rod, make the distance for 10mm between stamping foil and stamping plate.

5、烫印效果决定的主要因素：

注：压力、时间、温度以及合适的电化铝。

用户首先根据质材，选配合适的电化铝，其次烫印压力、时间、温度，根据实际情况略作调整。

It is very important to master how to adjust the pressure, time, temperature and choosing stamping foil. Please flexible revision these parameters based on practical situation.

六、操作程序：Operation process

1、将液压站管接入设备油管上。

Connecting the Hydraulic station with this machine.

2、将设备电源插入有保护接地的电源上（必须接地可靠）。

Connecting Power supply which protective earthling .

该款烫金机的加热功率较大，对于电源线的负荷要求较高，请尽量不要使用民用建筑内的电源，否则有可能造成电源线超负荷运行，引起不必要的损失。

This machine use More strong Power supply line, Please avoid use this machine in civil building room. Or the electron line will not bear the payload and hurt your supply.

3、合上断路器开关，拨开电源开关，设备在某设定参数下开始升温加热。

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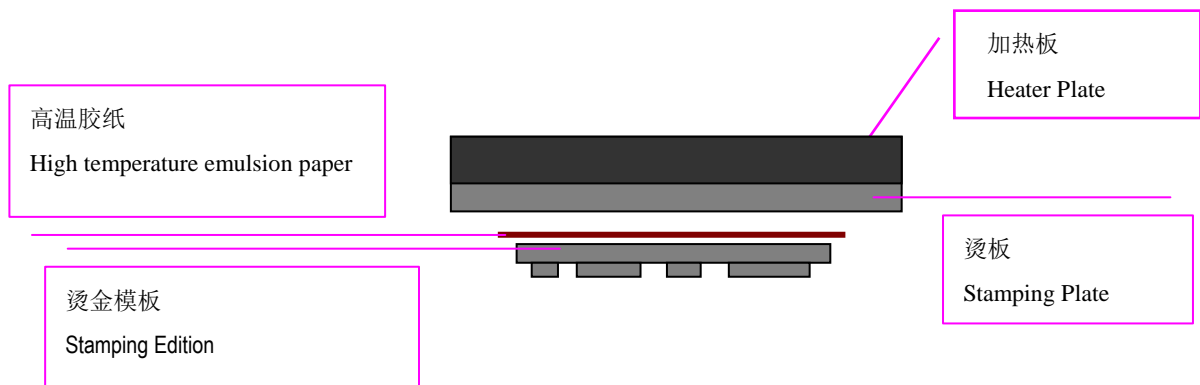
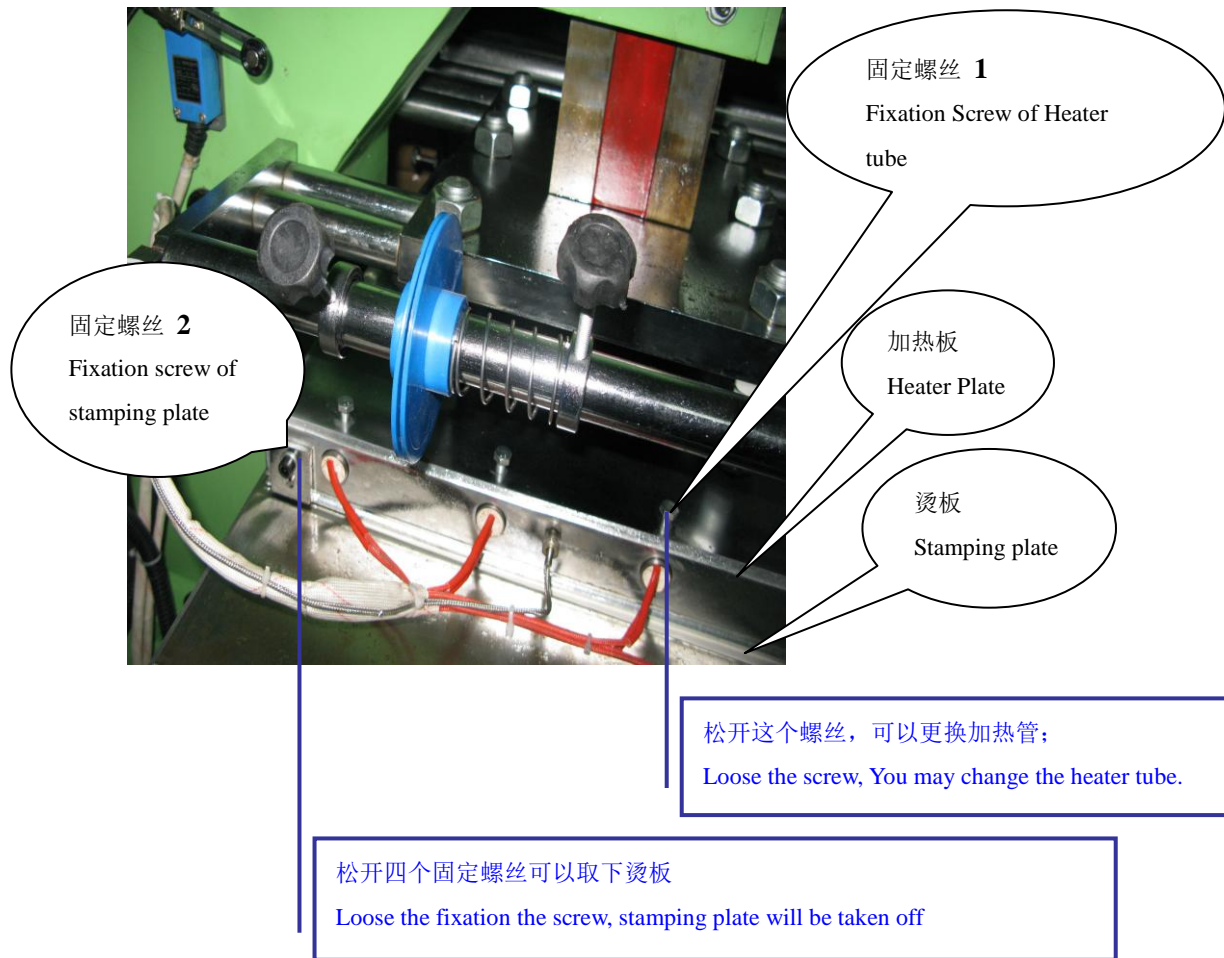
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Shut on circuit breaker, Switch on the Power button on the operation panel, The machine will be heat at the temperature.



4、安装烫金版

Put stamping Plate(silicon rubber plate, Copper plate, ZN Plate) on the working table, coating high temperature glue or adhering high temperature paper onto the surface of plate, Press "press-testing "make stamping head down and contact

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with plate for a moment till the plate can be lift up.■

安装烫金版有三种方式： 高温胶纸粘贴， 高温胶水粘贴， 螺钉固定。

较小规格的烫金版可以使用高温胶纸和高温胶水粘贴的方法， 较大尺寸的规格特别是金属烫金版可以采用螺钉固定的方法进行固定。

A) 一用高温胶纸粘贴： 首先裁切一块高温胶纸， 尺寸比烫金版稍微大一些， 将高温胶纸的黄色面朝下平铺于烫金版的金属面， 将胶纸的纸基去掉；将烫金版放置于工作台上面， 将烫金机加温， 然后操纵烫金机下压到烫金版一分种左右， 高温胶纸将受热融化并将烫金版粘贴到烫板上面；

B) 一用高温胶水粘贴： 将高温胶水涂布在烫金版的金属基板上面， 放置在工作台上面， 其他程序和 A 相同；

C) 一用螺丝固定： 首先松掉烫板固定螺丝， 取下烫板， 大致确定烫金版的位置， 在烫板上面制作固定螺丝孔四个， 然后将烫金版固紧， 再将烫板安装到原来的位置。 如下图所示。

There are three methods to install stamping edition: adhere with high temperature emulsion paper, High temperature glue, Fixation with screw:

A)—High temperature Emulsion paper: first cutting one high temperature paper according to the stamping edition, Then cover it onto the stamping edition, Put them on the working table of stamping machine, setting the temperature and start the machine to let stamping plate down to contact with them for a few minutes, the stamping edition will be lift up;

B)—High temperature glue: First coating the glue onto the Metal base of stamping edition, The rest process is same as A:

C)—With screw, First loose the fixation screw of stamping plate, take off the stamping plate, Make four screw holes on it, then install the stamping edition on it.

5、将电化铝按顺序安装好，注意夹电化铝，弹簧不亦过紧或过松，更不能将电化铝装反。调节拉杆的长度和摆角，使烫金纸距离烫印模块 10mm 左右。

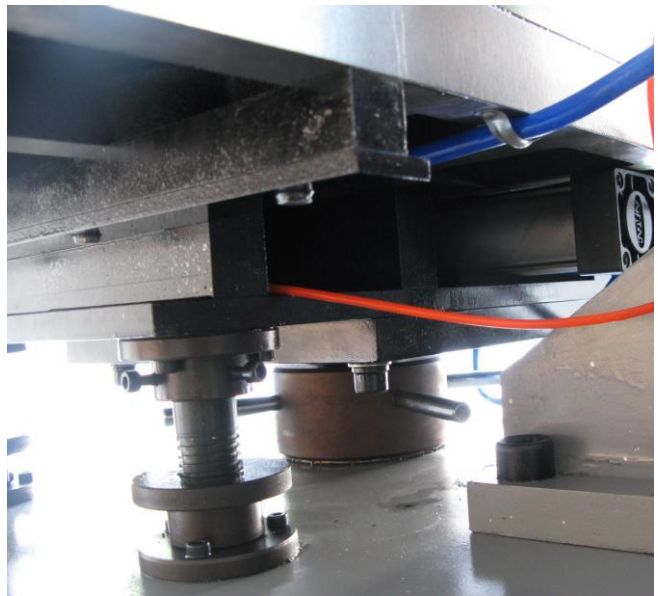
Install stamping foil and adjust the position , tension. The best distance between stamping foil and stamping plate is about 10mm.

6、上述一切工作就绪后，就可操作烫印了，将工件平铺工作台，按工作按钮，即可完成烫印一次。

Put object on the fixture and press “press-testing” to have a stamping process.

7、先进行试印，若设置参数不理想可重新设置。

First have a testing and setting parameter according to stamping result.



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8、为了工作安全，实际工作时，建议一人操作。

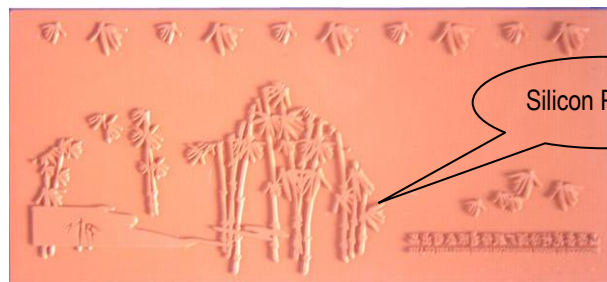
Only one worker to operate this machine suggested for safety cause.

9、若需停机，将电源开关拨至 0 位，如果长时间停机，还应把电源和气源关掉。

Move the power switch to "0" when machine stopping. Shut off power supply and compress air when stopping for long time.

七、使用烫金机的有关事项：Considerations

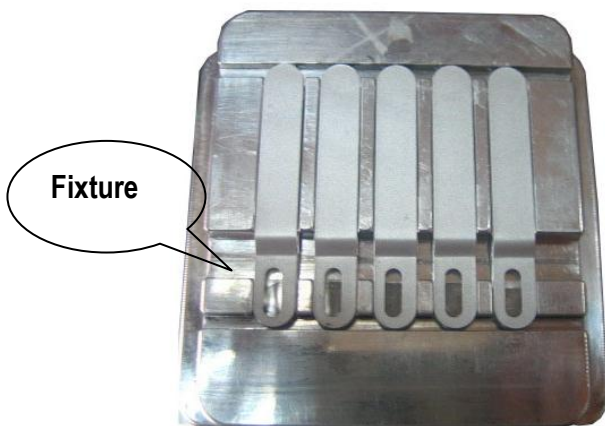
1、要根据烫印件的烫印面积以及形状选择合适的模具，预制好夹具等。



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.



对于一些塑料注塑产品，可以用机床车削加工一些夹具，夹具用工作台上面的治具进行固定；对于纸张，要在工作台的边缘粘贴一些定位片，确保纸张在每一次烫印过程中不走位。对于比较轻薄的纸张，我们也可以为您定做带有吸风工作台的平面烫金机，这样纸张烫印过程中会被紧紧吸附在工作台表面。

For some Injection objects, Wooden, We suggest you making Metal fixture to fix them, Please use the

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Website: [Http://www.dg-padprinter.com](http://www.dg-padprinter.com)

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fixing part on the working table to install it; For paper , Please adhering two pcs Thin paper sheets on the working table. If you use this machine to stamp very thin and soft objects such as paper and film, We will make flat stamping machine with vacuum table, Please enquire to our sales representative.

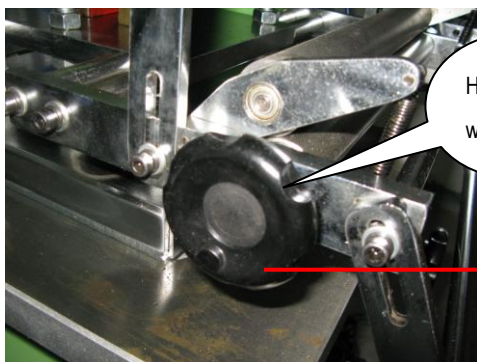
2、烫印时，要保证烫印板与烫印面的紧密接触。

机器出厂以前我们已经将烫板和工作台的平行度作出调整，在您进行正式烫印后可以先行对于烫金的平衡度作出测试，请在工作台上放置一块纸板，将 烫板压下，观察纸张表面的烫印情况，如果出现印痕轻重不同的情况，可以微量调节烫板上面的固定螺丝；

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

Before stamping , Please take a test when put one paper on the working table. Please observe the impression on the paper. Please adjust the Balance screw when you find the impression is not even.

3、操作前应检查各气路、电路以及接地装置是否良好。



Handle
wheel



转动这个手柄可以手动牵引烫金纸的输送
Turning the wheel, the stamping foil will be forwarding so
that you adjust the position between stamping foil and objects.

Please inspect gas path, circuit and earthing device.

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.

烫金机的标准规格是 640mm*120m, 但是通常的产品的烫印面积是不定的，您需要使用烫金纸切割机来把烫金纸切割成适合的宽度。

The standard size of stamping foil is 640mm*120mm, stamping size of different objects need different size, So, You need cu the stamping foil to fit width with foil cutter.

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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.

烫板的温度很高，所以在操作机器过程当中，请避免身体部位触及烫板，以免被烫伤

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.



八、所用电器元件明细（见附图二）

Electron component particulars

- ◆ 除非专业的电工，请不要自行打开电控箱
- ◆ 请不要使用磁铁接近机器的电控箱；
- ◆ 机器长期不用时应切断电源。

Unless a qualified electrician, do not open their own electronic control box

Do not use the magnet close to the machine's electrical control box;

Long-term machine when not cut off the power.

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序号 No.	电器符号 Symbols	名称 Name	型号 Model	数量 Qty
1	QF	漏电断路器 Earth Leakage Circuit Breaker	DZ47LZ-32A	1
2	KM	交流接触器 AC contactor	CJX2-2810/220V	1
3	R	加热管 Heater	Φ18×500	6
4	SK	旋钮开关 Knob switch	LAY7-11X/21	1
5	FU	熔断器 Fuse	RT14-20	1
6	Qt	温控元件 Temperature element	CNG-5131P	1
7	SB	按钮 Push button	LAY7-11BN(G)	3
8	KT₁KT₂	时间继电器 Time relay	DH48S-2Z/220V	2
9	KA₁KA₂	继电器 Relay	JQX-13F/220V	2
10	SA	行程开关 Travel switch	AZ8108	1
11	YV	电磁阀 Solenoid Valve	4V310-	1
12	M	卷箔电机 Foil Motor	60W/220V	1
13	○	热电偶 Thermoelectric	K/2M	1

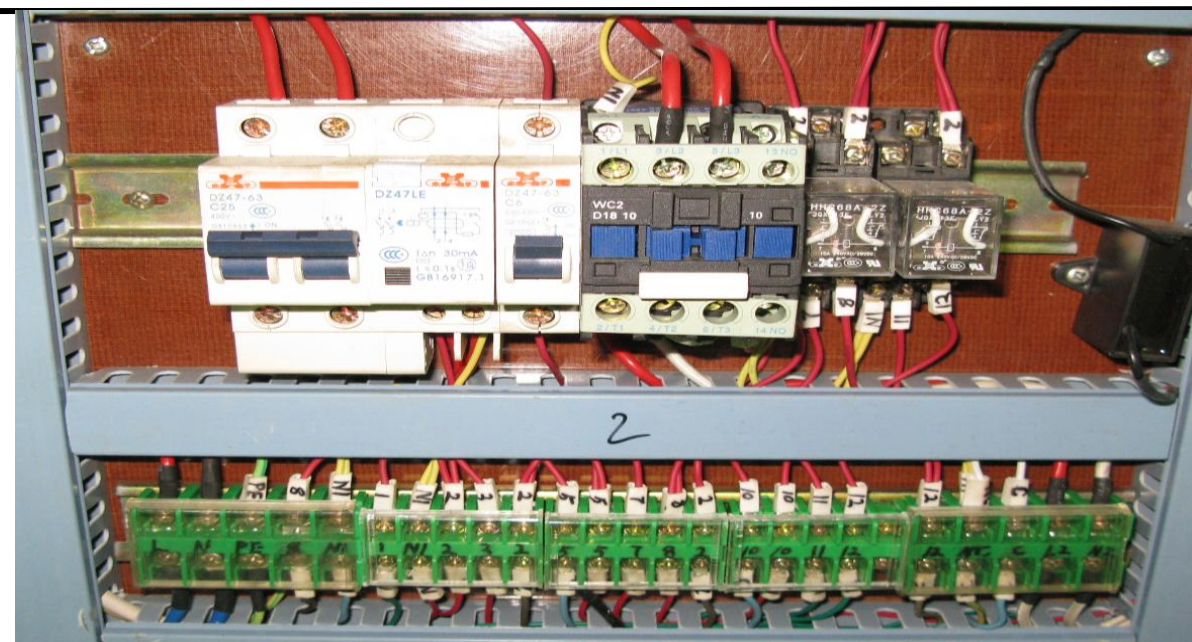
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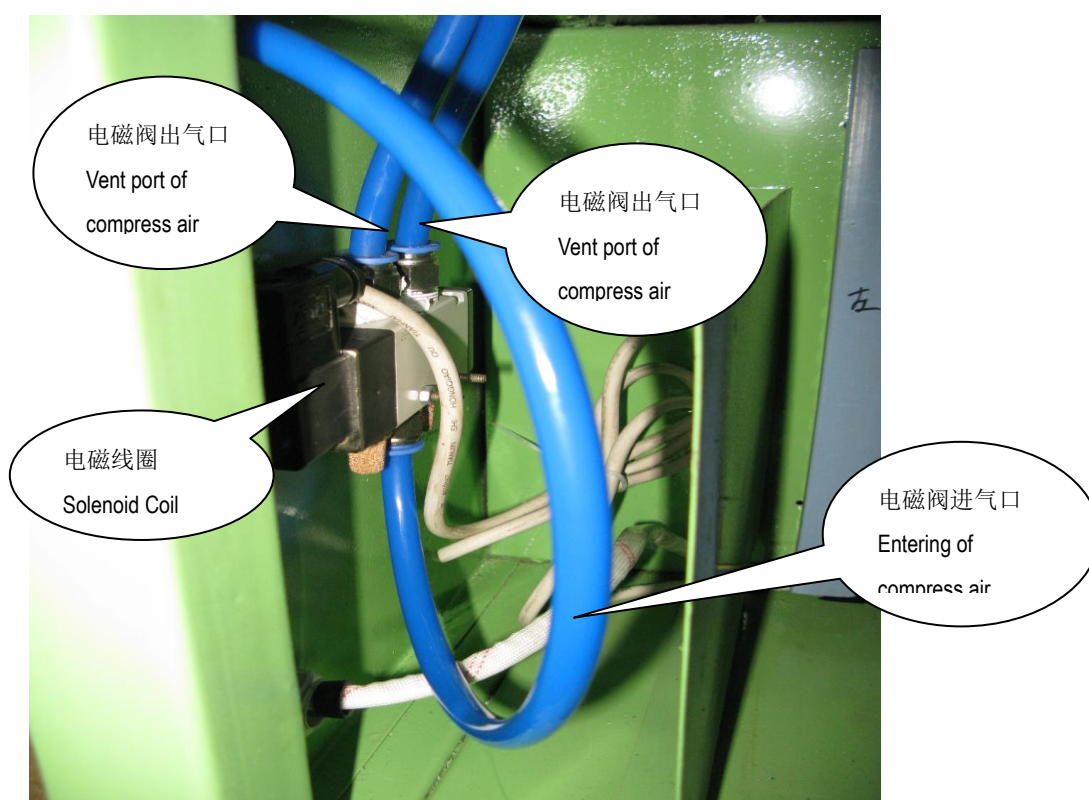
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机器的电控箱位于机器后面的安全门内，请专门的电气人员进行维修和拆卸；

Please open the door behind the machine body, Only expert can open the door and take a maintain and repair.



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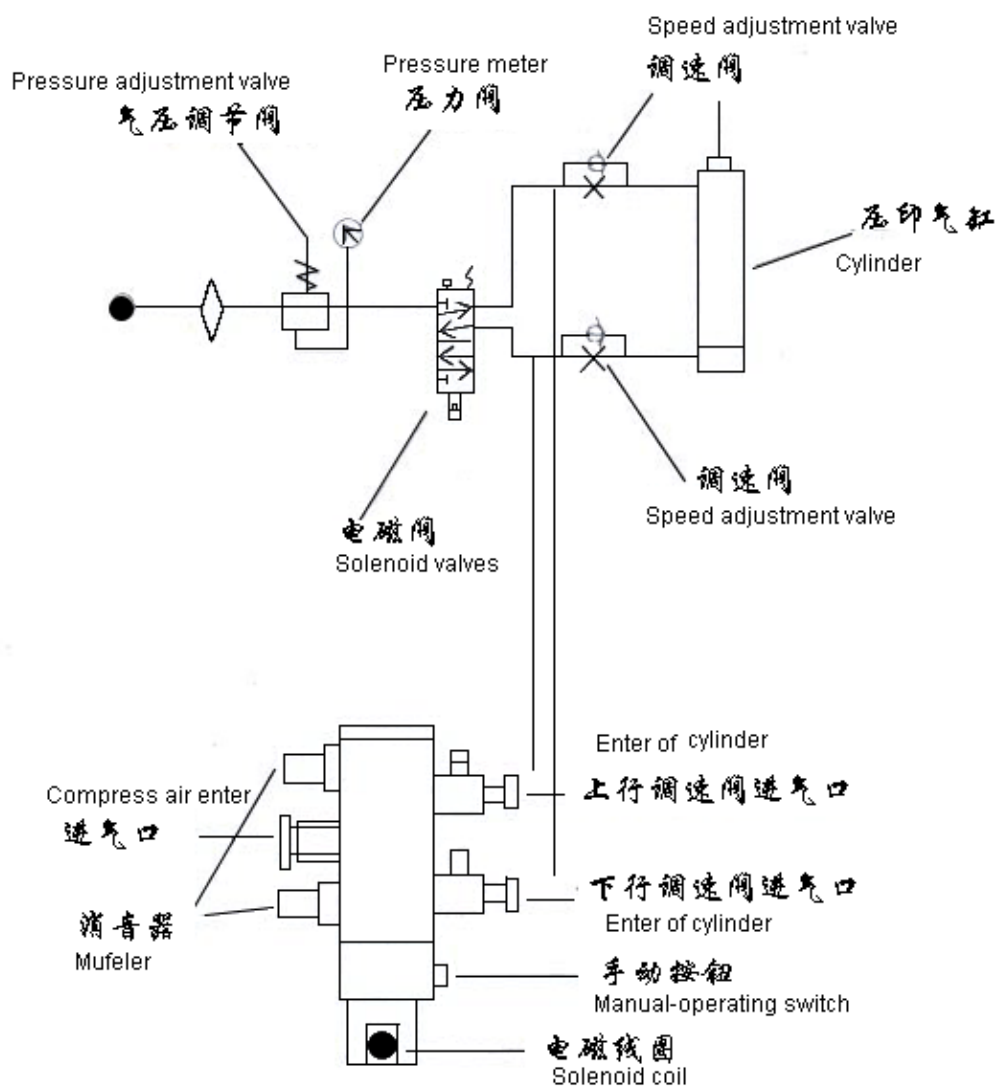
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十、气压传动系统图 (见附图三)

附图三 气压传动系统图

Figure 3 Pneumatic System chart



电磁阀气路图

Solenoid valve connecting figure

烫金机的电磁阀位于机身后面的机箱内。

电磁阀的进气口连接机器外部的组合气阀，出气口连接烫金机烫压汽缸的两端，电磁线圈连接到操作面板的烫压按钮上面，当按下启动开关，电磁线圈会通电，压缩空气会根据不同的气路进入烫压汽缸内，从而操纵汽缸执行上行抬起和下行压印的动作。

十一、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、经常及时排除空气过滤器中的积水。

Removing the sepper full of atmosphere filter timeliness.

- 3、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

- 4)、气压表压力是否正常。

Check the pressure meter if normal

5)、打开旋钮开关，卷箔电机不动作，卷箔无指示：a 检查行程开关碰块是否到位，若无复位应复位；b 时间继电器旋钮是否在零位电机运转处是否有卡住现象；c 检查电器箱内小型继电器是否很好（JQX-13F/220V）。

Open the foil switch, Foil motor no running, Foil no feeding:

A: Please check the travel switch if locate in place.

B: Please check time relay if lock at the Motor running.

C: Please check the small relay if keep well (JQX-13F/220V)

- 6)、卷箔电机运转无力，应该检查或更换启动电容。



Switching of foil motor

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Foil Motor run powerless, Please check or replace start-up Capacitance

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。Directivity lack pattern

A、烫印模与烫印面吻合不好。Stamping plate is not inosculates 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

● 智能温控仪的有关事项：Regarding Intelligent temperature controller

本机为智能温控，使用前请仔细阅读使用说明。

Please read the instruction carefully.

1、操作说明 Operation instruction

仪表面板上有四只键分别为：

There are four keys on panel



键：流程控制键

Flow controlling key



键：设定位移位键

Function shift Key



键：设立数字递增键

Number increase



键：设立-数字递减键

Number descend

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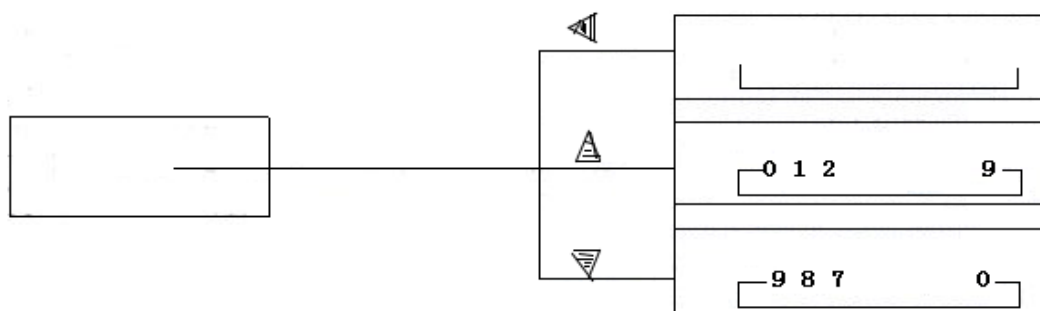
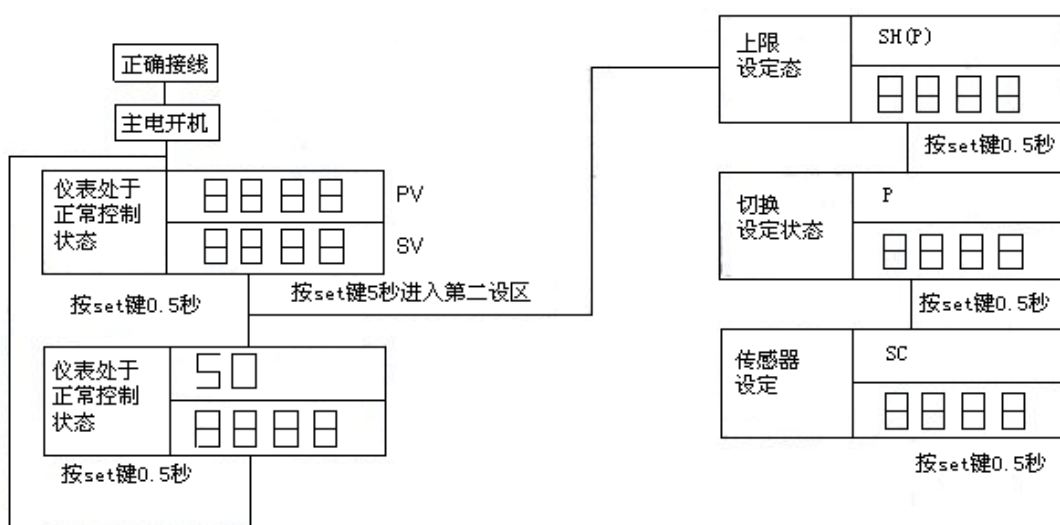
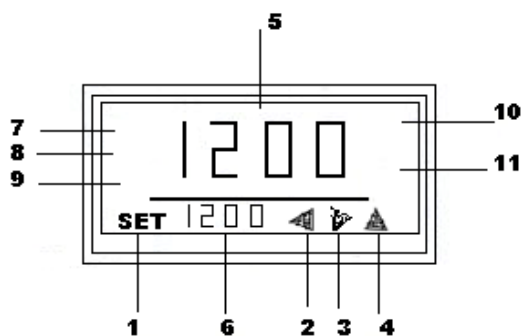
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仪表参数修改，设定时的人机对话均通过四只按键来实现的，当在第一次使用本产品时，请详细阅读上面的操作流程：

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Amending the Parameter through the four keys. Please read carefully the process:

注：①切换差可调整范围为 $1^{\circ}\text{C} \sim 20^{\circ}\text{C}$ 或 $0.1^{\circ}\text{C} \sim 20^{\circ}\text{C}$ 却仅对主控起作用。

Please adjust switching over as $1^{\circ}\text{C} \sim 20^{\circ}\text{C}$. $0.1^{\circ}\text{C} \sim 20^{\circ}\text{C}$ is only active on mainly function.

②传感器修正范围为 $-20.0^{\circ}\text{C} \sim 20.0^{\circ}\text{C}$ ，出厂时设置为 0.0°C 。

Please amending sensor parameter as $-20.0^{\circ}\text{C} \sim 20.0^{\circ}\text{C}$, The range is 0.0°C when machine is out of factory.

③在第二设区时按 SET 键 5 秒钟后，退出设定状态，进入正常状态。

At the second district, Press "set" for 5 seconds, exit setting state, enter working state.

2、其它操作

①（除 CNG 系列仪表） Besides CNG meter

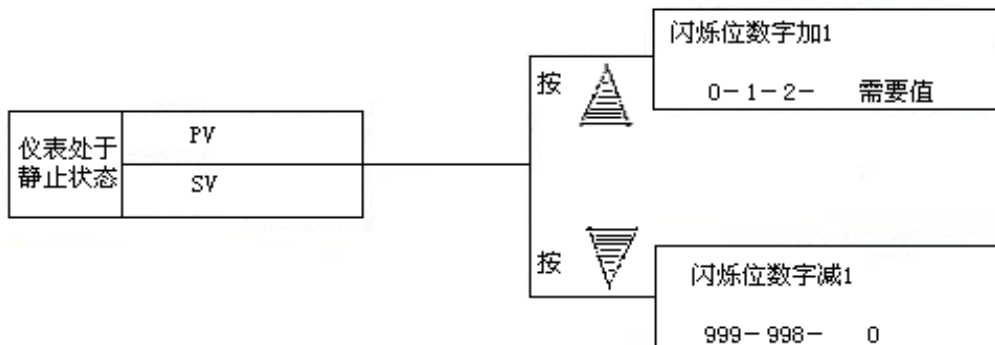
在进入你所修改的参数状态，你就可以操作其它键以达到你所修改的目的

When entering setting state, you can amend the parameter.

注：AT、TLOK 状态仅显示个位及十位值。

Note: AT, took State only display units digit and deckle .

②CNC 系列仪表： CNC Meter



当需要有大数字变化时，按住递增或递减键不放，则设定值将时行快速加、减以缩短设定时间。

Keeping press number increase and number descend key, the number will be continue change to save time.

3、设定字符解释： The character explain

以下字符每按一次 SET 键后依次出现，根据不同功能有些字符可能在你所选用的仪表中不存在。（见下表）

Press one time : "set", below character will be display in turn. Some character maybe do not exist

4、使用注意事项： Note

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①把仪表插入仪表盘开孔中，开孔公差应适中，装上安装板螺杆，适度旋紧，外壳带自锁的仪表插入开孔中即可。

Insert meter into the hole, install the screw and fix it.

②检查仪表分度号规格及电源电压是否与所订仪表相同。

Please check the voltage of power.

③按接线路铭牌或说明书接线图正确接线。

Please connect the wire according to the instruction.

④对热电偶输入信号请用与热电偶丝相同材料的补偿导线。

⑤对热电偶输入信号请用相同规格低阻值导线，且三线长度尽量相等。

⑥特别注意电源输入线与信号输入线不可错接，及输出端子被强电流短路等。

⑦仪表电源线与信号线尽量与大电流线分开布线，以减少电磁辐射对仪表的影响，在无法避免时，仪表连线请尽量先用屏蔽线。

⑧为防止仪器损坏或失效，用额定电供电。

⑨断电后方可清洁仪器，清除显示器上的污渍请用软布或棉纸；显示器易被划伤；禁止用硬物擦拭或触及。

⑩禁止用螺丝刀或圆珠笔尖硬物体操作面板按键，否则会损坏或划伤按键。

④ thermocouple input signal with a same material as the thermocouple wire compensation wire.

⑤ thermocouple input signal with a low resistance wire of the same size and length as much as possible equal to the third line.

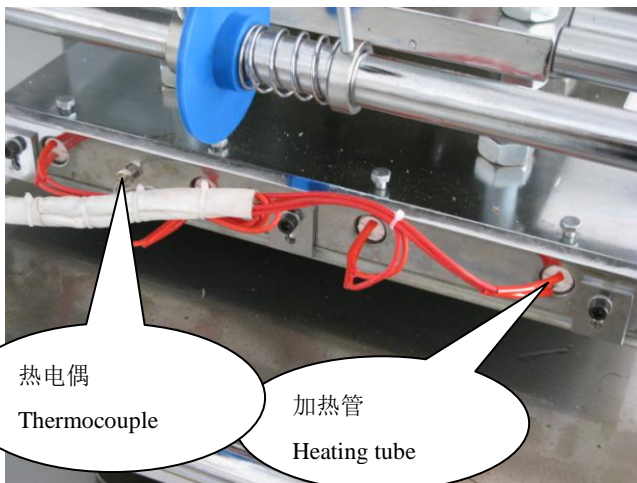
⑥ special attention to the power line and input signal line should not wrongly input, and an output terminal is short-circuited strong current.

⑦ instrument power lines and signal lines as far as possible with the large current wiring and cable separately, in order to reduce the effects of electromagnetic radiation on the instrument, when you can not avoid, try to connect the instrument to use shielded cable.

⑧ To prevent equipment damage or failure, power supply with rated power.

After ⑨ power before cleaning the instrument, remove stains on the monitor with a soft cloth or tissue; the display is easily scratched; do not scrub or hit with a hard object.

⑩ ban with a screwdriver or a ballpoint pen tip of a hard object operation panel buttons, otherwise it will damage or scratch the keys.





5、简易问题维修按仪表规格接上相应的电源线，传感器线及输出控制线以后，上电开机。仪表 PV 窗即显示测量值，SV 窗即显示设定值，同时时入自动温度控制状态。

①若认为仪表指示失常，请检查传感器及接线。

字符 Character	名称 Name	设定范围 Setting range	说明 Description	出厂设定 Setting factory
SO	主控设定 Mainly setting	0-9999	设定主控点数值大小	150
SL	下限绝对值设定 Lower limited setting	0-9999	设定下限(下限报警)点数值大小. 下限报警控制点 SL 设为 100℃, 实际控制点高于 101℃. 继电器释放, 低于 99℃继电器吸合.	100
SH	上限绝对值设定 Upper limited setting	0-9999	设定上限(上限报警)点数值大小, 上限报警控制点 SH 设定 200℃, 实际控制点高于 201℃继电器吸合, 低于 199℃继电器释放.	200
SHP	上限偏差值设定 Upper limited Deviation setting	0-9999	设定上限偏差值于设定绝对值之偏差, 上限报警偏差控制点应为 SO+SHP. SO 上控温度设定为 150℃. SHP 设定为 10℃. 实际报警控制点高于 161℃继电器吸合, 低于 159℃继电器释放.	10
SC	传感器修正设定 Sensor setting	-20-20	修正传感器误差	0
P	比例范围 Range	1-999	设定比例值大小, 不允许设定为零, P 越大比例越小, 系统偏差越低.	20
O	积分时间 Integral time	0-3600 秒	设定积分时间, 设定为 0 时关闭积分功能. O 越大积分作用越弱.	130
D	微分时间 Differential time	0-3600 秒	设定微分时间, 设定为 0 时关闭微分功能, D 越大微分作用越强, 并可克服超调.	30
F	比例周期	1-99 秒	设定输出开关周期不允许设定为零	20(2)继电器输出时 20, 其它输出时 2
AC	比例周期	00: 自整定停止 01: 自整定开始	确定自整定执行/关闭	00
LOR	比例周期	00: 不锁 01: 只能修改主控设定值 02: 所有参数设定	确定参数修正允许/不允许	00

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Please check the sensor and connecting wire when finding the meter display wrong.

②仪表面板各种功能显示，输出指示正常，而仪表失控时，请检查输出控制线是否正确，外部负载有否短路、断路、错线等导致表内部元件损坏，必要时可以停电打开仪表检查，输出端之铜箔，输出保护电阻有否烧焦，一般较容易修复。

The panel of meter display correct but the meter is out of control, Please check the output line, check the short circuit, turnoff etc .

补充图片说明

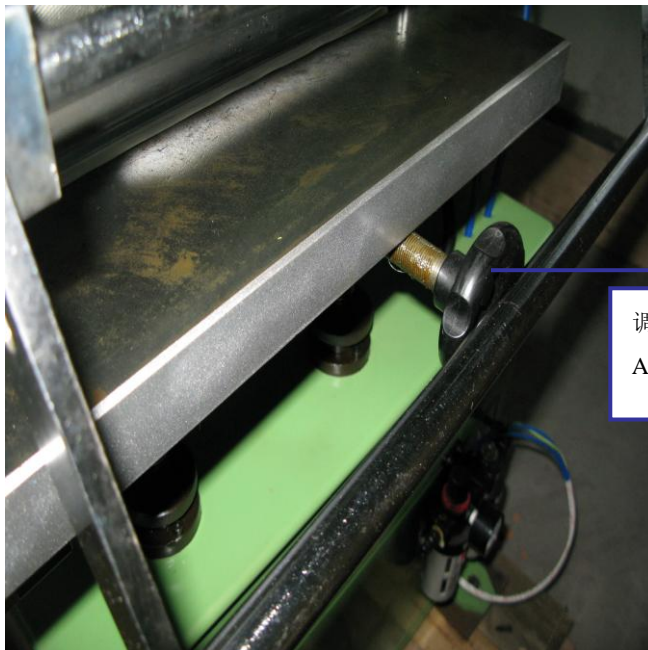


调节工作台的前后位置

Adjust the position of working table

正式操作机器需要同时按下这两个开关；

Press two buttons together will operate this machine



调整工作台的左右位置

Adjust the left-right position of working table

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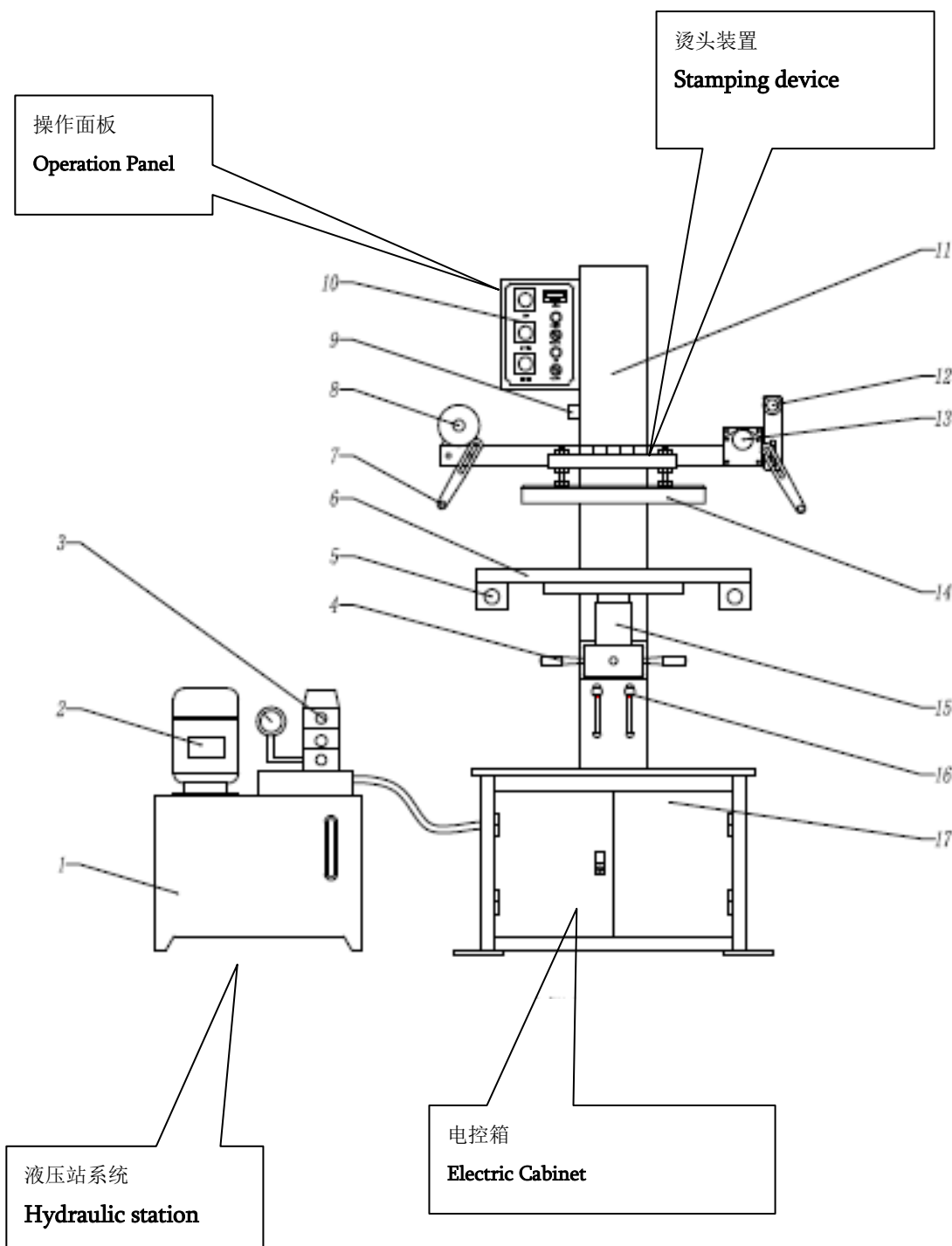
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十三.Name and Description of Major Machine Structure



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NO	Name	No.	Name
1	Oil tank of hydraulic station 液压站	11	Nose 机头
2	Hydraulic motor 液压电机	12	Foil receiving roller 收纸轴
3	Pressure control valve 压力调节阀	13	Foil rolling mechanism 收纸电机
4	Upgrade nut 工作台调整螺母	14	Hot plate 烫板
5	Starting switch 烫压开关	15	Upgrade screw 上升螺杆
6	Workbench 工作台板	16	Screw locking hand shank 螺杆手柄
7	Foil Guide rod 导纸轴	17	Chassis 底座。
8	Foil feeding roller 送纸轴	18	
9	Position switch 行程开关	19	
10	Control panel 控制面板	20	

- First of all, thanks for your great support for KC Printing Machine . **Please keep it earthed reliably before operation so as to guarantee the operator's safety!!! The power cord of this machine shall be power cable of 3*4 mm²..**

烫金机的功率较大，请使用 3*4 平方毫米的电缆线。

:

- Different hot printing materials require different temperatures. The hot printing of paper is generally within 85-120 °The wood branding requires about 240-280 °C. As for temperature displayed by the temperature controlled, the red digit indicates current temperature value while the green digit indicates the value to be set.
纸张的烫印通常在 85-120 度之间，木器烙糊的温度在 240-280 度之间。
- Coat the back of formwork with glue, put it on the located workbench, press motor starting switch to start hydraulic system, then press inching descending switch until the

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hot plate contacts with the formwork on workbench, stop for 1 minute and then press inching ascending button to make hot plate ascend to original position.

Or fix the formwork on hang plate of hot plate directly with the screw.

将烫金版背面涂上胶水后放置于定好位的工作台上，按下启动马达，液压系统启动，再按寸动下降开关使烫头和烫金版接触一分钟左右，再按寸动上升开关，使烫头上升到原始位置。

- If the bottom of the workbench fails to contact the hot plate, it is feasible to use the upgrade screw-nut under the workbench to conduct adjustment. Spin in the clockwise is hoisting and spin anti-clockwise is falling.

Reduce the hot plate to the lowest position, adjust the workbench and make it in contact with the hot plate, hoist the hot plate to the original position, then rotate the nut of the workbench hoisting for about 3~4mm. The pressure generated is the maximum mechanical pressure of the machine. If the pressure is small, it is feasible to adjust the pressure control valve of the hydraulic station. Clockwise rotation is to make it larger and anti-clockwise rotation is to make it smaller. Generally, the adjustment is about 6~8 Mpa (60~80kgf/cm²).

如果工作台不能接触到烫板，可调节工作台下方的升降丝杆使台面和烫板接触，使烫板回复到原始位置，再将台面上升 3-4mm 既是机器产生的最大机械压力。调节液压泵的压力控制阀也可适当增大压力，也来以 6-8MPA 为佳。

- There are 5 number regulating positions for hot printing time of the machine or time control regulator of foil rolling, the middle represents time unit. That is “S” is second, “M” is minute, “H” is hour. For example: The regulation is “12S18” represents that the hot printing time or foil rolling time is 12 second and 18.

本机的时间控制器调节为 5 位拨码盘，中间字母代表时间单位。S-秒，M-分钟，H-小时。

十四. Instructions for Maintenance。 维护和保养。

Attention: The maintenance can be conducted only after the power supply and air supply are cut off.

1. Daily maintenance:

1. Clear away the articles and dust on the machine.

Attention: Do cut off the power supply and air supply when the clearing of the machine is conducted, never use corrosive liquids such as water, ethanol and the like as detergent to rub the machine or heat the smudge in the middle-rubber roller.

日常维护：

清理机器表面的物品和粉尘。

- 清理机器请务必关闭电源，不能用天那水和酒精等腐蚀性液体擦拭收纸辊等橡胶部件。

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2. Each time the machine is operated for 8 hours, it is necessary to add lubricating oil to the rotating or sliding part of the machine and make the viscosity of the lubricating oil be 32~46#.

Attention: Never add too much lubricating oil, so as to prevent it from flowing to the hot head and causing combustion.

- 机器运行八小时后，应向机器的滑动部分加注润滑油。 润滑油不能加太多，以免流入到烫板上引起燃烧。

When the machine is operated for 2 working days or the hot printing mould (hot printing product) is replaced, it is necessary to clear the machine with clean cloth.

Attention: When the hot printing head is cleaned, it is necessary to cool the hot printing head at the temperature lower than 40 °. Then it is feasible to clean it with clean cloth.

机器运行 24 小时，或者更换烫印版时，需用干净的布碎清洗干净。

清洗烫头，必须确保烫头冷却到 40 度以下再清洁。

2. Monthly maintenance:

1. Inspect the operating parts of the machine and timely screw on if it is discovered that any screw becomes loose.
2. The extrovert sliding surface of the machine shall be rubbed with butter.
3. The solenoid directional control valve of the hydraulic station and the cooler shall be cleaned (As is shown in the figure below).



要定期对液压站电磁换向阀和冷却器的清理

3. Annual maintenance

1. Since the machine is used for long time by sliding, some sliding parts will be worn. For example: hot head hoisting guide pillar.
2. Inspect whether the bearing of the machine is used for long and abrasion occurs. Replace it if it is necessary.

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