



H-TC129C

卡片烫金机说明书



Dongguan KC Printing Machine Limited 11-1

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一、产品概述

Product overview

H-TC129C 气动烫金机造型精致、美观、结构紧凑，操作简便，自动化程度和生产效率高，对环境无污染。主要适用于橡胶、塑料、皮革、木材、纸张等制品表面的烫金、压痕加工，提高产品档次。

H-TC129C Pneumatic drive hot stamping machine modeling exquisite, beautiful, compact structure, easy to operate, the degree of automation and high production efficiency, environmental pollution-free. Mainly used in rubber, plastics, leather, wood, paper and other products for surface machining of bronzing, indentation, upgrade products

二、技术参数

Technical parameter

额定电压 Power voltage 220V 50Hz 工作压力 Compress air: 0.3-0.6MPa

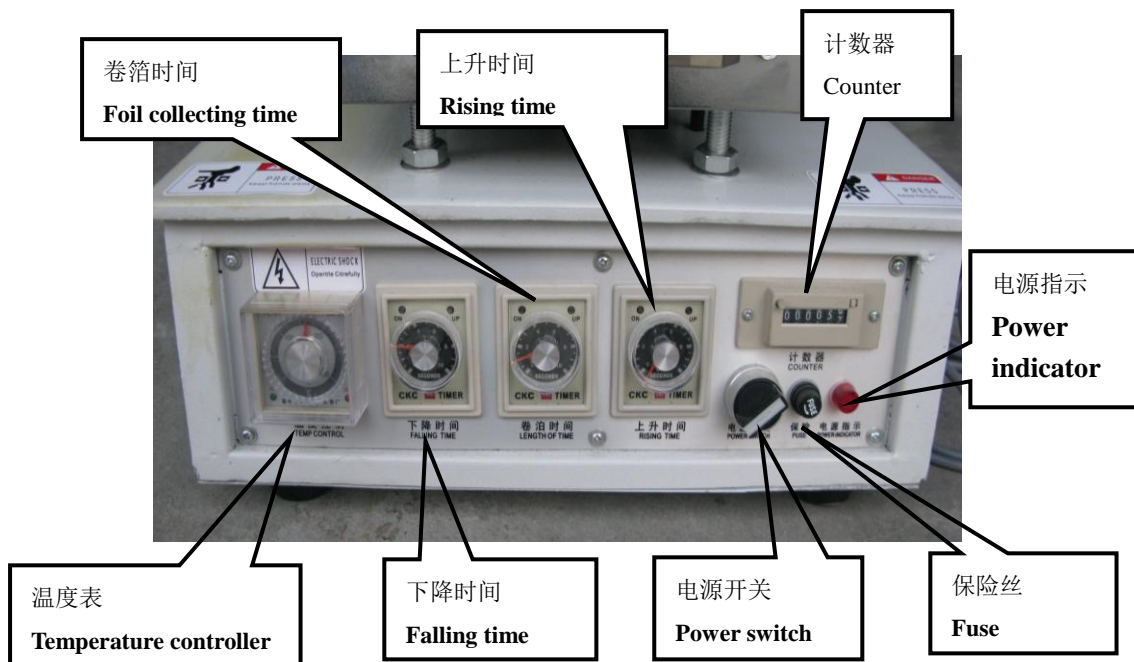
时间设定 Time setting range: 0-10S 温度设定 Temperature setting rang:0-300°C

最大压合高度 Max Height of objects: 100mm 电热功率 Heater wattage:500W

上工作板尺寸 Heat plate size: 90×120mm 机械尺寸 Machine size: 480×390×800mm 重量 Net weight: 40Kg

三、主要结构

Mainly structure



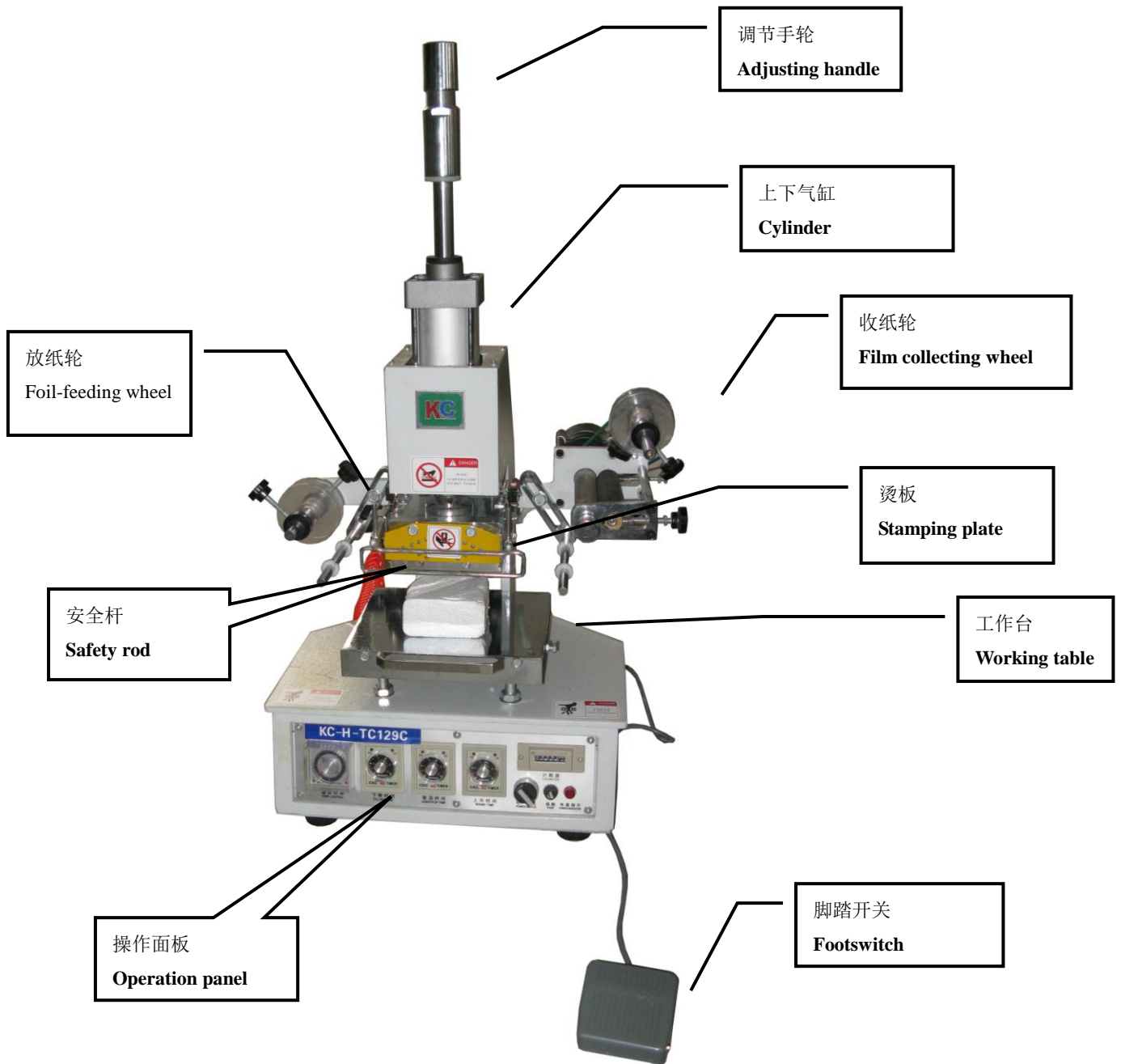
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- 操作面板 Operation panel
- 整体结构



四. 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。



Power Line

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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.

2、安装烫印模板



烫印模板可以是铜版， 锌版， 硅胶板， 树脂版。

Any type of 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。

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

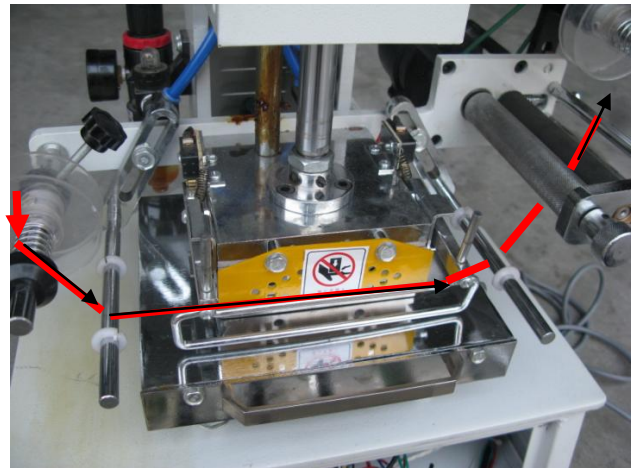
将电化铝箔依图安装到设备上。
(根据烫印材料选择电化铝型号)。

安装方法如下：

A、把电化铝箔安装在放纸杆上 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，



烫金纸
stamping foil



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。

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操作面板上面的卷纸时间来实现的）。

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，此时可放上工件，依不同工件的材料等选择压下时间即烫印时间，操作脚踏开关来完成一次烫印。

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

五. 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.

温度设定参考 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/Pressing 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	

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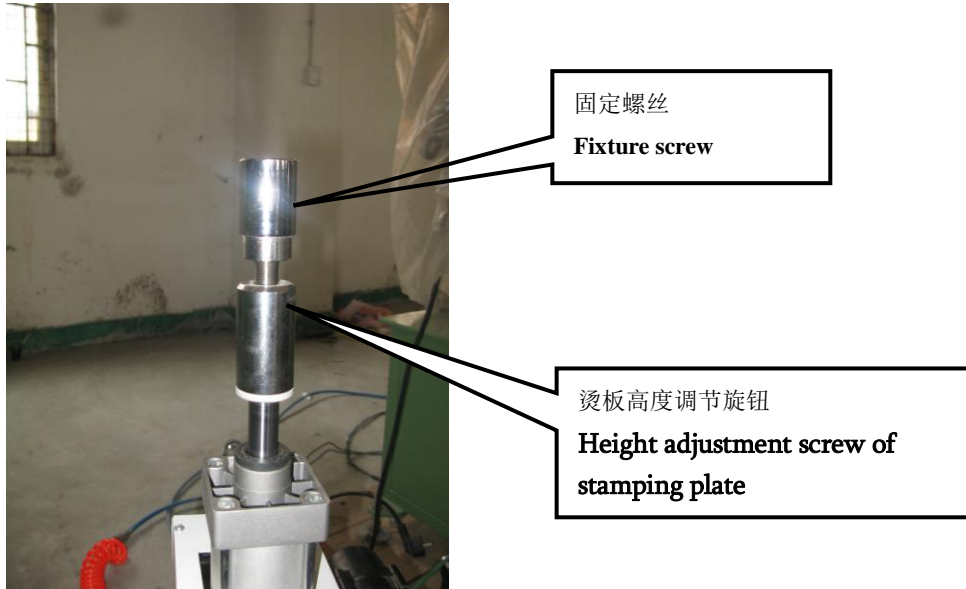
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以上温度设定仅供参考，用户可以根据烫印过程中出现的问题进行比较的调整。

Please adjust the temperature according to stamping process.

2、烫板高度的调整：height of stamping plate adjustment



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

当烫印不同尺寸的产品时，要对收卷电机转过的长度进行调整，这个可以通过调整操作面板上面的卷纸长度旋钮来完成。

When stamping different size objects, Please adjust the Knob- Foil collecting switch to adjust the foil feeding length.

六. 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.

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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。

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。

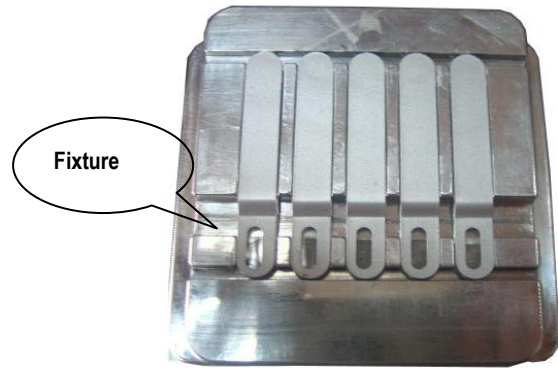
Please choosing stamping foil consonant with object to be stamped.

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.

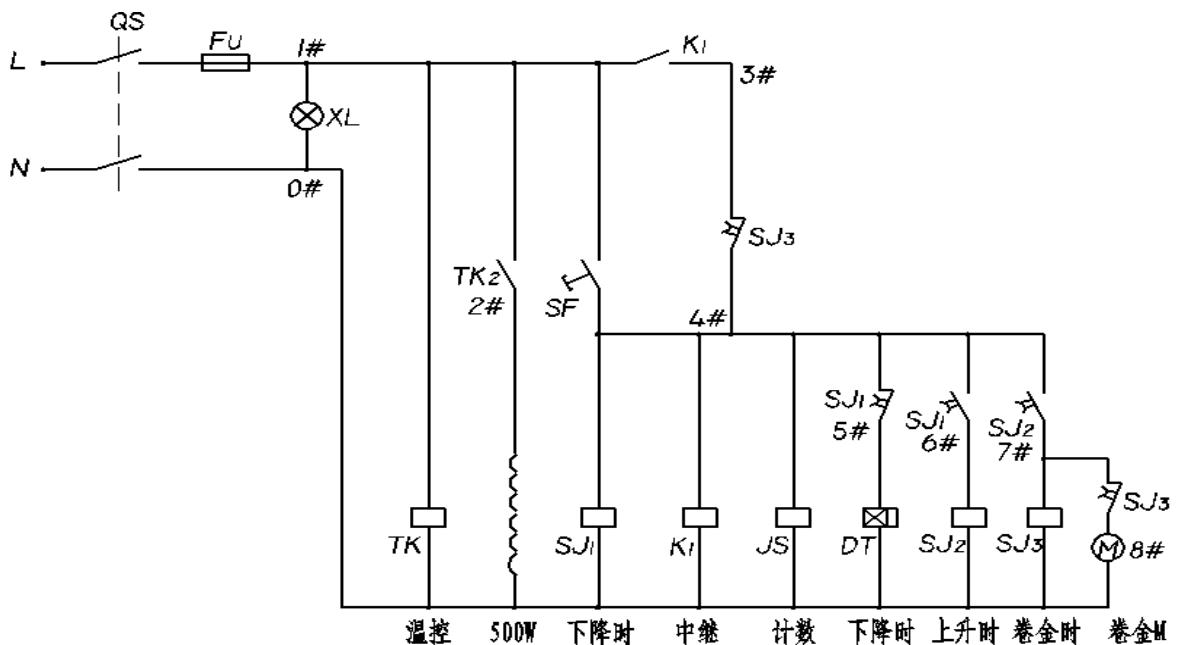
6、若操作者离开工作现场，必须关掉气源、电源。

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



七. 电气原理图

Electron component particulars





序号 No.	电器符号 Symbols	名称 Name	序号 No.	电器符号 Symbols	名称 Name
1	QS	电源开关 Power switch	7	SJ3	卷纸继电器 Foil Relay
2	FU	熔断器 Fuse	8	SF	脚踏开关 Foot switch
3	TK	温控仪 Temperature controller	9	K1	中间继电器 Auxiliary relay
4	XL	指示灯 Power indicator	10	JS	计数器 Counter
5	SJ1	气缸继电器 Cylinder replay	11	DT	电磁阀 Solenoid Valve
6	SJ2	气缸继电器 Cylinder replay	12	M	卷纸电机 Foil motor

八、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。

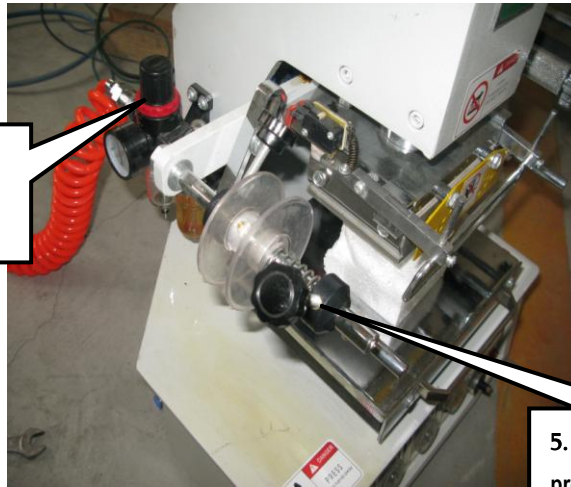
Check the output voltage of power supply if normal

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6-2) Please adjust the pressure of air switching



5. Please adjust the pressure of the spring.

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

5. 烫金纸收带时易拉断，这是左边夹盘上的压力太大，应及时减小弹簧的压力。

If the foil easy to snap, Please decrease the pressure of foil feeding wheel.

烫金纸收带时收不完，这是左边夹盘上的压力太小，应及时增大弹簧的压力。

If the foil do not transport , please increase the pressure of foil feeding wheel.

6. 烫金压痕效果差：

1) 应先检查模具的深度是否合格。

Please check if the stamping plate is ok.

2) 应调节气缸的压力（一般压力为 0.3-0.6MPa）。具体调节方法，先看（18）二联件上的压力表指针指向多少，若指针指向的气压低于 0.3-0.6MPa，用手把旋钮往上拉出 5-6mm，然后顺时针旋转压力增大，逆时针旋转压力减小，调好后把旋钮复位。

If the pressure under 0.3-0.6.mpa, Please adjust the air switching. First pull out the Knob and turn round with clockwise rotation till the rang reach requirement, then press down the knob.

3) 气缸上下动作太快或太慢，应适当调整节流阀，进出气缸气流即可增大或减少（注：本气缸节流阀为出气节流阀）。

If the speed of cylinder too slow, Please adjust the airflow valve on the cylinder.

当达到所需的压力时，烫印效果还不理想，这时应考虑是否选购的烫金纸太差的原故，应及时更换烫金纸。

When you find stamping quality is not good, Change other stamping foil perhaps can solve it.

7) . 电磁阀不工作时，请注意使用的电压（220V）是否正常，如果正常，检查压缩空气是否太脏，把电磁阀的孔堵塞，若堵塞，先断电，再拆下来用柴油清洗干净或更换新的。

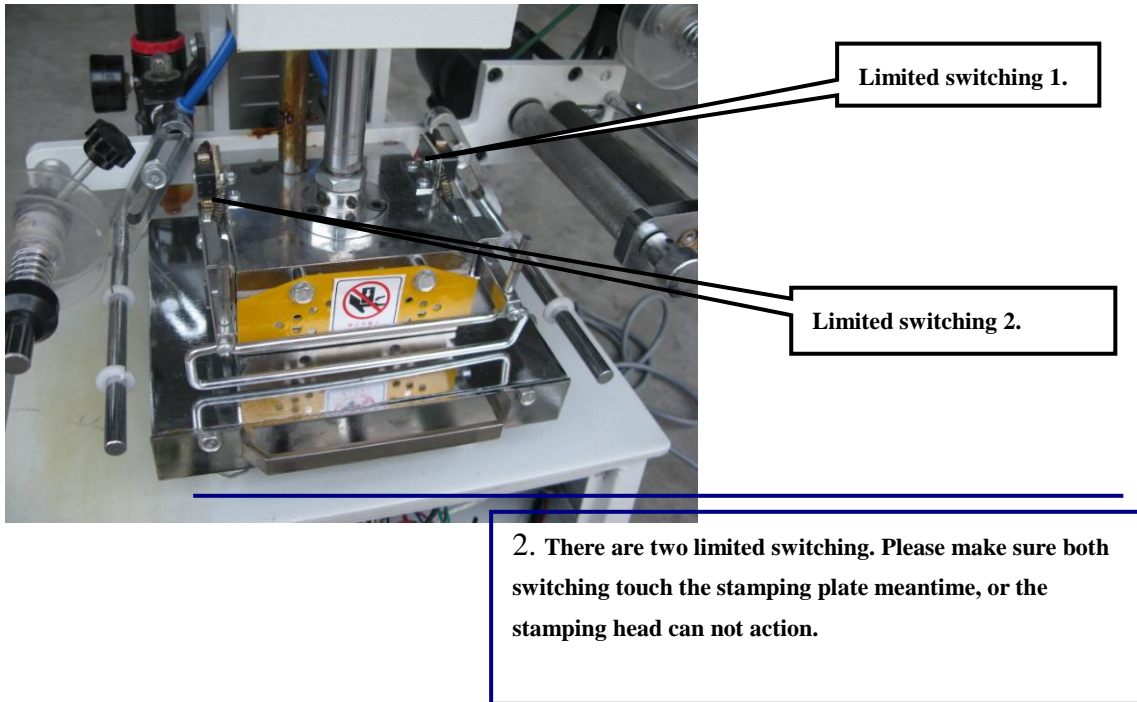
Many problems caused with solenoid valve. Please check the voltage if is 220V, Please make sure the voltage is 220V. Please make sure the compress air if cleaning and drying.

If you find the solenoid is bad, please replace it.

8) . 当电源开启后，升温正常，但气缸还是不工作，这时应检查保护装置上的二条直臂是否同时碰到微动开关，且发



出轻微的“嘀嗒”声后才会工作，如果只是一边的微动开关碰到发出响声，电磁阀是不工作的，气缸也不会工作，这时要调到两边同时碰到微动开关才能启动工作。



Please make two limited switch beside the stamping head touch the safety device meantime. Or the cylinder will not work.

9) 当压力调得过大工作时，上工作板与下工作板，相互接触并产生震动，受其影响，直臂与微动开关就会跟着震动，微动开关就会有时常开有时闭合，就会出现气缸不能下来的现象，这时应适当调节气缸上下节流阀，顺时针调为气流小，速度慢，逆时针为气流大，速度快。

Please make sure the stamping pressure not too big and cause shaking , Or the limited switching and safety rod will shake.

九、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 Patten**
 - 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

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- 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

提示： Warning

- 电热板加热温度不超过 250℃。

Do not use the machine over 250 degree.

- 电源插头要插入带有接地的插座内，并检查机器有无漏电现象。

Please make sure tha machine safety earth connecting

- 有互相摩擦的部件应定期加黄油或其它润滑油润滑。

Please adding Lubricating oil into the place where Frictional part

- 严禁将手伸入工作区域，若小件烫金，请选择手推下工作板工作，若大件烫金，定好位直接放在下工作板上就可工作。

Please do not put your hand on the working table on the operation process.

- 保持气动二联件油杯内有足够的油量，并保证进入气缸的压缩空气干燥，清洁。

Please keep compress air cleaning and drying.

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