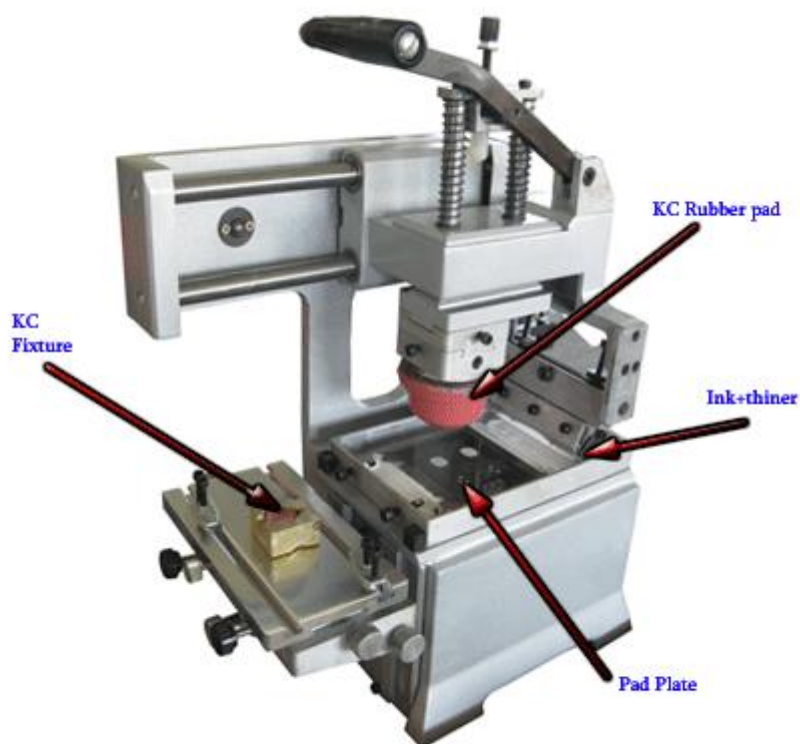




KC-404/406M 手动移印机

Manual single-color pad printer

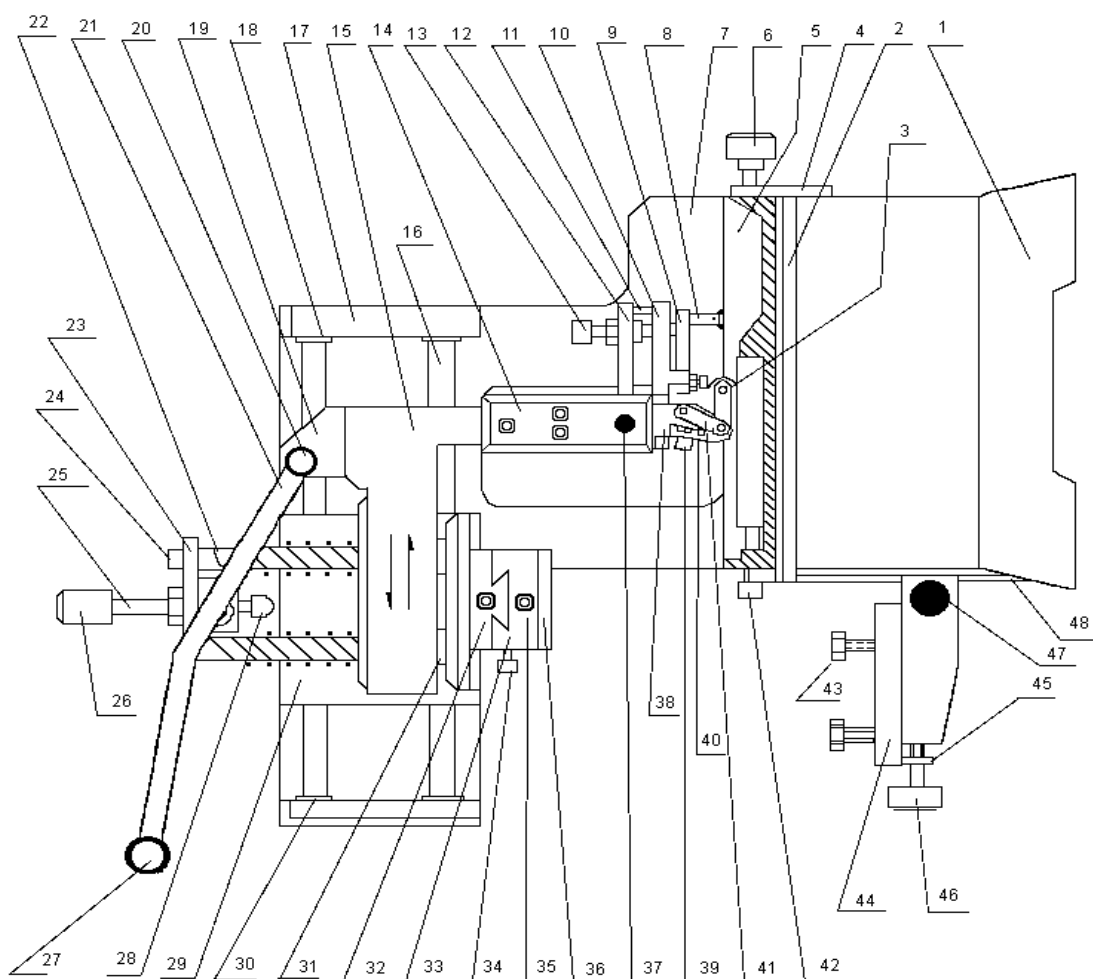
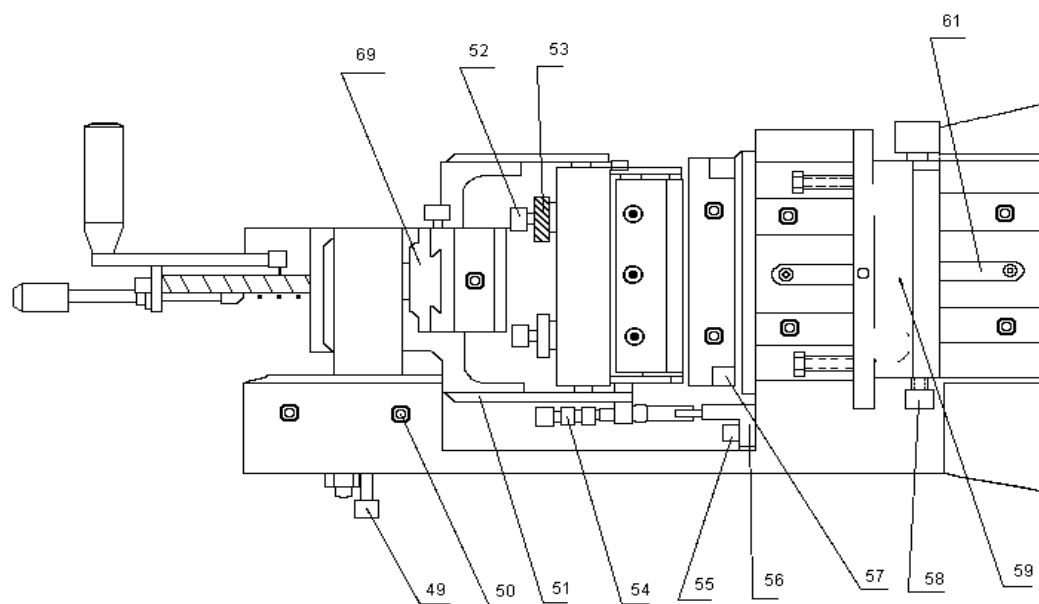


使用说明书

Operation Instruction

● 技术参数 TECHNOLOGY PARAMETER

最大印刷面积 Max printing area	钢板尺寸 Plate dimension	机器净重 Net weight	外形尺寸 Outer dimension
80×80mm/80×130mm	100×100mm/150mm	27kg	500×400×220mm
套印精度 Overprint precision	行程 Move distance	印刷色数 Colour number	产品最大高度 Products max high
0.02mm	150mm	1	150mm.





手动移印机具有结构简单，操作方便，成本低，无需能源能特点。非常适合于产品 LOGO 等小批量和产品打样的移印加工，为广大中小型企业所青睐。

Manual single-colour printer is one of the earliest products developed in our factory, which has several years' production history. In order to satisfy the customer's need, we have already made three times change on its design and model, including its general outward appearance ,technical specifications and printing quality, etc. So a great improvement has been brought into its global quality. It has the features of energy-free, convenient move, low cost, high printing quality and simple operation, etc, Which make it suitable for the decorative printing of the commodities, i.e. cosmetics, recreational and sports activities, electronic and electrical parts and their trademarks.

一. 型号: Symbol Expression

KC-404M 其中: 404 代表钢板的长宽尺寸 4 “代表 100mm。KC 为商标标志。M 代表手动操作。

KC-404M : plate dimension is 4×4, KC — company logo.。M is of manual operating.

二. 结构说明:

1. 机座	2. 墨盘座	3. 上墨辊	1.base	2.ink tray	3.roller	4.fixation
4. 固定板	5. 墨盘	6. 锁紧螺丝	5.ink tray	6.locking bolt	7.vertical stand	8.roller
7. 立板	8. 滚轮架	9. 下调杆	9.lower adjusting bolt		10.connecting	11.thimble
10. 连杆	11. 顶锁	12. 上调杆	12.upper	13.adjusting bolt	14.right stand plate	
13. 调节螺丝	14. 右支板	15. 支架	15.support	16.horizontal	17.rear support plate	
16. 水平导杆	17. 后支撑板	18. 橡胶垫	18.rubber flat	19.support	20.shaft pin	21.rocker
19. 支架	20. 轴钉	21. 摇臂	22.up-and-down	Guide column	23.roller support	
22. 上下导柱	23. 滚轮座	24. 连接螺丝	24.connecting	25.joint cap	26.Spacing bolt	27.handle
25. 固紧螺丝	26. 限位螺杆	27. 手柄	28.spacing	29.horizontal	30.front supporting plate	
28. 限位触头	29. 水平滑块	30. 前支撑板	31.O ring	32.middle swallow-tailed block		
31.O 型圈	32. 中燕尾块	33. 下燕尾块	33.lower swallow-railed block		34.locking bolt	
34. 锁紧螺丝	35. 螺栓	36. 胶头座	35.bolt	36.print head	37.swinging rod	
37. 摆杆	38. 刀架	39. 螺栓	38.blade	39.bolt	40.blade press	41.joint
40. 刀压板	41. 连接片	42. 禁锢螺丝	42.fixation bolt	43.hexagon bolt	44.working table	
43. 六角螺丝	44. 工作台	45. 调节板	45.adjustable	46.adjusting bolt		
46. 调节螺丝	47. 上下手轮	48. 上下导板	47.up-and down hand wheel		48.up-and down guide plate	
49. 锁紧螺丝	50. 拉紧螺钉	51. 左支板	49.locking bolt	50.tension	51.left support plate	
52. 调节螺栓	53. 滚花螺丝	54. 禁锢螺丝	52.adjusting	53.rolled joint	54.tightening screw.	
55. 螺栓	56. 角规	57. 左右限位	55.bolt	56.angle tool	57.located	
58. 锁紧螺丝	59. 调节丝杆	60. 上燕尾座	58.lock crew	59.adjust rod	60.seat	
61. 齿条			61.gear line			

三：安装 Installation

1. 打开包装箱，搽去防锈油脂

Remove the outer packing of the printing machine and clean away the anti-rust grease.

2. 安放适当位置，并调平工作台。

Put the machine on a correct position and adjust its stability

3. 安装手柄。

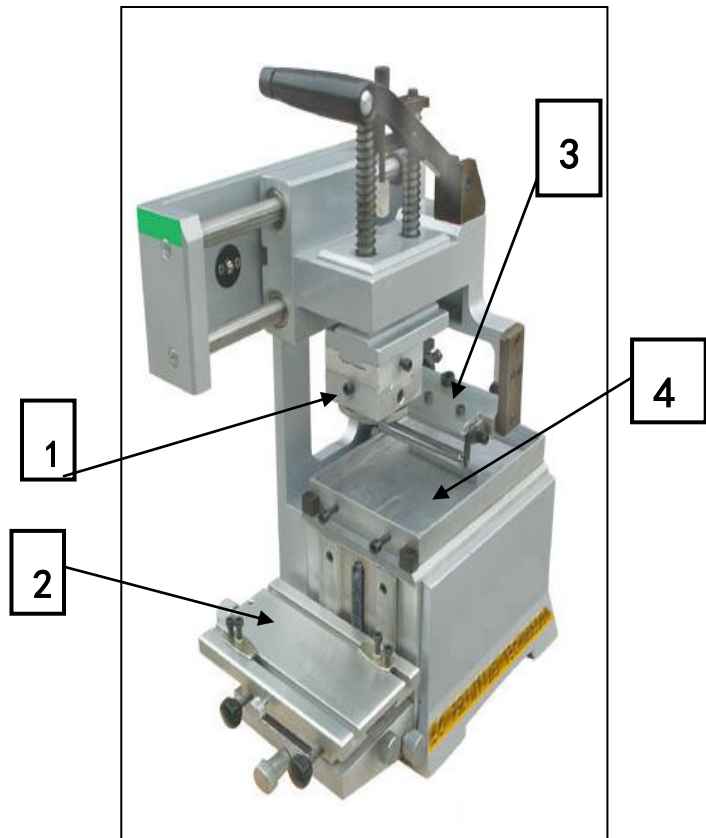
Install the handle on the machine.

手动移印机要完成移印任务：需要根据相应的产品进行移印要素的整合才能完成：包括：

- 制作合适的夹具：将产品和夹具安装在工作台 2 上；
- 制作并安装合适的胶头到胶头座 1 上；
- 根据客户提供的印刷文件制作移印钢板并安装在油盘前端 4；
- 选择适合产品材质的油墨和稀释剂装进油盘后端 4；
- 安装刮刀片在刮刀夹上 3。

Finishing pad printing task need all items below to be done:

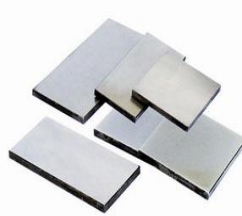
- Making appropriate fixture and install it one the working table of manual pad printer 2
- Making and installing appropriate pad to the pad seat 1;
- Base on customer printing document , etching pad plate and install in the front end of inkwell 4;
- Choose correct ink and thinner and pour into the back end of inkwell 4;
- Install doctor blade into blade nip.



移印胶头
Rubber pads



移印油墨
Pad inks



移印钢板
Pad plates



夹具
Fixture



刀片
Doctor blade

四：调试 Test Printing

1. 松开锁紧手柄 49，拉动手柄检查水平滑块运行是否灵活；

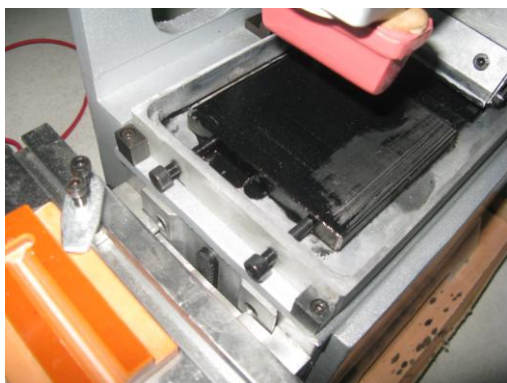
Unfasten the locking screw (49), grasp the handle (27) with your right hand to see if the horizontal slide (29) could move forward and backward, and if the print head seat (36) could move up and down.

2. 调试胶头座上下是否灵活

Please check pad seat if move freely up and down;

3. 将制好的钢板放入油墨盘并固紧，确保钢板底部全部贴紧油墨盘底部。

Put the prepared printing plate into the ink tray (5), and fasten the

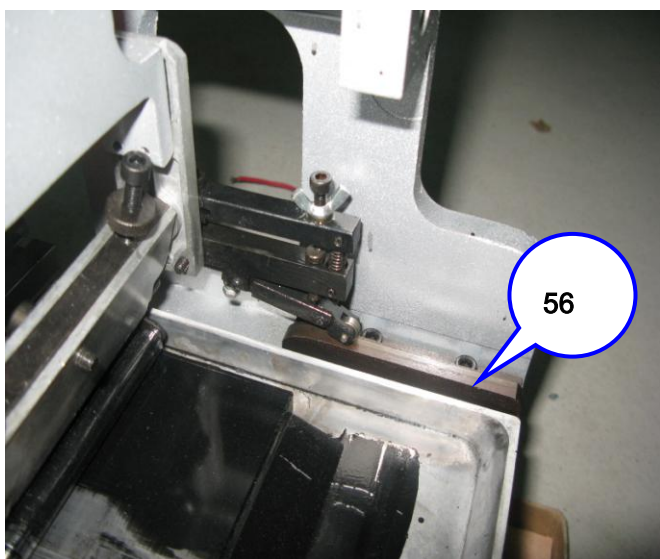
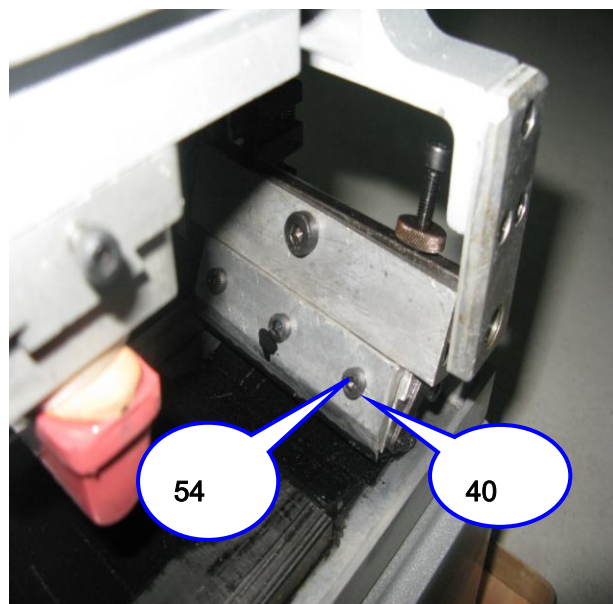


fixation bolt (42) to ensure the film touch between the plate bottom and the ink tray.



4. 松开压板 40，装上刮刀，使刮刀刃口与钢板平行，旋紧固定螺栓 54，将上调杆 12，禁锢在摆杆 37 轴端。

Unfasten the blade press (40), and install the blade to make the blade edge even with the printing plate, then, fasten the bolt (54). And fix the upper adjusting rod (12) on the shaft end of the swinging rod (37).



5. 调整角规 56，使刮刀在钢板前沿 3mm 处落刀，后 3mm 处起刀。起刀高度离钢板 3mm。

Adjust the angle gauge (56) to let the blade down at 3mm ahead of the plate and up at 3mm behind the plate, with the height of 3mm.

6. 将油墨加入油墨盘，试刮或试印，并调整刮刀位置，使油墨刮的干净。

Put the ink into ink tray (5), and make a scrape test to see if the effect is good, you can adjust the bolt (13) if needed. Besides, you can also adjust the left or right height of the adjusting screw (52) by fastening the left and loosening the right alternatively.

7. 根据印品形状，选择合适的胶头，并将胶头固定在胶头座上。调整胶头的前后左右位置，使胶头

的中心位于印迹的中心稍偏位置。



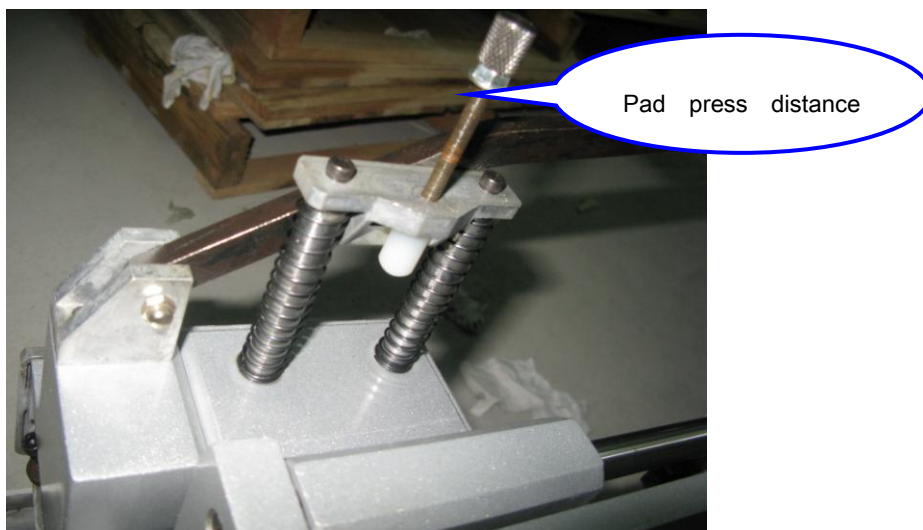
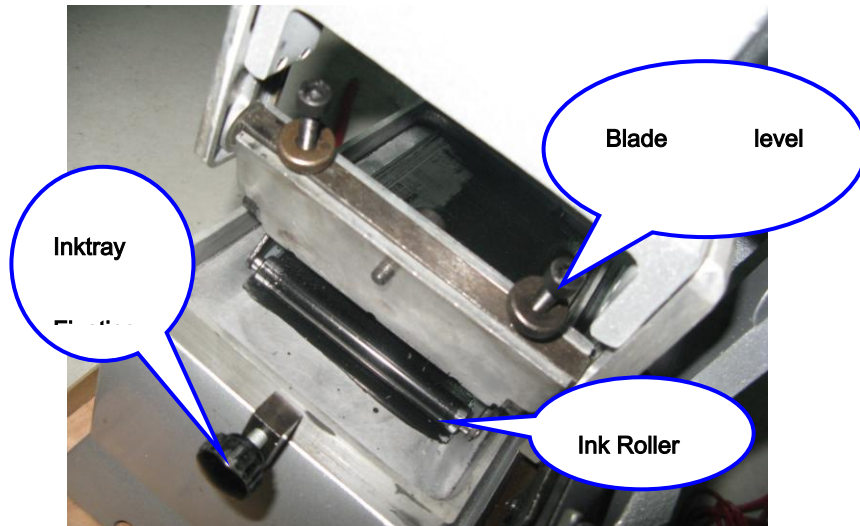
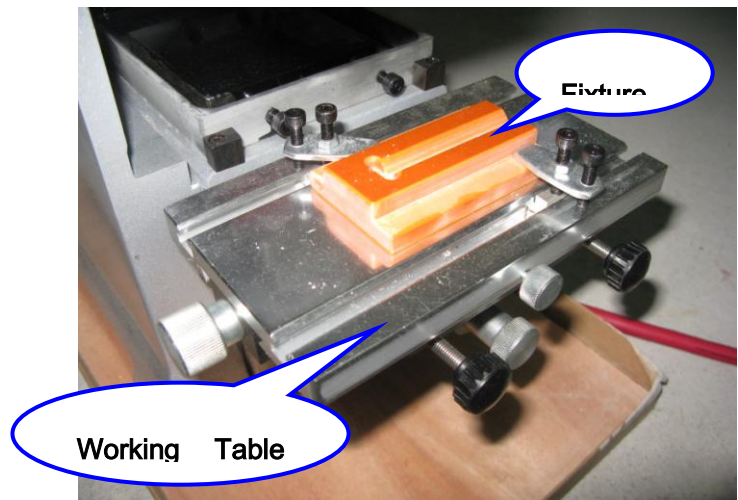
According to the printing requirement, choose the pad head and fix the pad on the seat (36) with screw. adjust the swallow-tailed blocks (32, 33) to make the center of the printing area and the center of the printing plate ate the position of the rubber head.

8. 固定夹具。先调整好最佳位置，印刷图文比较清晰后，固定夹具和产品。

According to the different printing products .make a special jig and install it on the worktable(44) then fix the products on the jig. Adjust the spacing bolts to control the press printing position

9. 试印,拉动手柄进行试印，对胶头，夹具位置等进行细微调整后可得到最完美的印刷效果。

Test printing: pull forward and backward the horizontal slide (29), press down on backward to bring the ink and press down an forward to make a clear and perfect printing.



手动移印机的刮刀调整比较困难，请按照下面所述的程序进行：

Please adjust the blade according to below process:

- 1) **Loose the fixation screw 54 and install the blade. Before installing it, you must cut the blade to shorter dimension.**

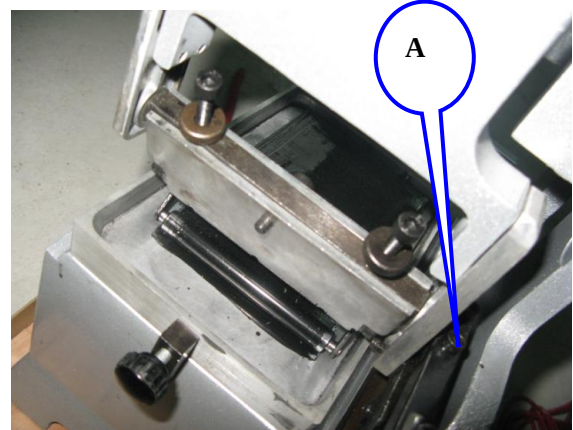
松开固紧螺丝 54， 安装刀片， 请按照图文尺寸的大小裁切刀片到合适的宽度。

- 2) **Loose the screw A, Make the blade whirl and parallel with pad plate and keep the distance for 3mm.**

首先松开刮刀轴端的固定螺丝 A， 使刮刀可以下降并接近钢板， 使刀片和钢板保持 3mm 的距离。

- 3) **Fix the screw A. Pull the handle and see the blade if remove the ink from plate.**

固定螺丝 A， 使刀片的转动能够带动轴的转动



- 4) **If blade can not remove the ink, Please adjust the screw B. adjust the screw B only adjust a few . If the distance between blade and plate is too far, Please loose the screw A again and make the blade more closer to pad plate till the blade removing the ink from plate when printing.**

如果刀片不能刮净钢板上的油墨， 请调整螺丝 B， 但是调整螺丝 B 仅仅能微小调整刮刀的余量， 如果仍然不能刮净油墨， 必须再次

松开螺丝 A， 使刀片更靠近钢板。然后再拉动手柄使刀片刮净油墨。

