



H-300M/150M

油压式平面圆型转印机

使用说明书

H-300M/150M oil pressure heat transfer machine

Operation Instruction



东莞市高宝印刷机械科技有限公司

KC Printing Machine (Group) Limited 19-1

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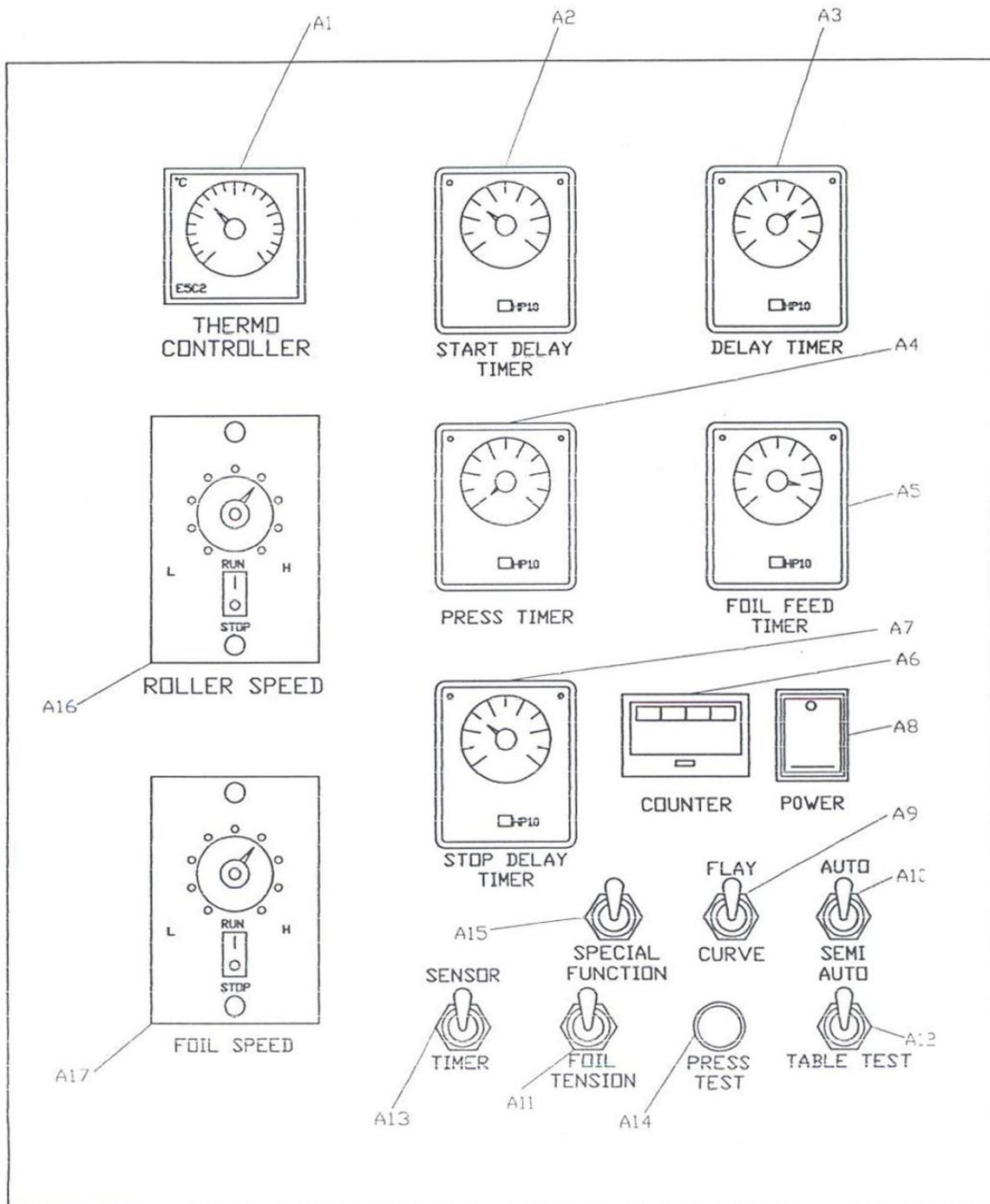
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● H-300M/150M 热转印机操作面板说明图

H-300M/150M Operation panel instruction picture



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操作面板功能解说

Function of operation panel key.

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编号	名称 Key	功能 Function
A1	温度控制 THERMO CONTROLLER	调校并设定转印时所需温度,当温度控制器上工作指示灯(NO)第一次灯灭时,表示转印机已达所调校的温度并自动保持该温度.由于耐热胶辊需要较长预热时间,第一次工作指示灯熄灭后,请再耐心等待一段时间(约为十五至二十分钟),让耐热胶辊充分预热约三十分钟,以免烘坏胶辊.本机装有自动空转装置,关上 A8(开关)后胶辊仍自动空转二十钟. Adjust and set stamping temperature. When the indicator on the temperature controller lights first, display reaching set temperature and keep this temperature automatic. Please wait a moment for 15-20 minutes because heat roller need long pre-heat time after the indicator turns off. When you shut off A8 switching, the roller will turn for 20 minutes to avoid roller be hurt.
A2	延迟启动时间 START DELAY TIMER	调校耐热胶辊压下后,工作台开始向右移动的时间. Adjust the time of roller from left to right when it press down.
A3	循环时间 DELAY TIMER	作全自动运作时,调校该旋钮,可设定两个工作周期之间的间歇时间. Adjust the intermission time of two working weeks in automatic operation mode.
A4	下压时间 PRESS TIMER	作圆型转印时,调校该旋钮可设定胶辊压烫工件的时间. Adjust press stamping time when stamping cylinder workpiece.
A5	拉纸时间 FOIL FEED TIMER	与 A17 卷纸调速(FOIL SPEED)配合作转印后拉纸的运作,调校该旋钮可设定拉纸的长度. Adjust the length of foil feed. Used to control how to pull foil with A17 (foil speed)
A6	计数器 COUNTER	自动计算转印次数,按复位钮,计数器复位为零. Calculate the transfer frequency automatic. Press reset key. The counter reset zero.
A7	同步拉纸延迟 时间 STOP DELAY TIMER	作圆型转印时,转印纸会粘连工件圆周转动影响运作,因而需要转印期间同步拉纸.调校该旋钮,可设定同步拉纸的起时时间.向左拧尽,转印开始时即时作同步拉纸;向右拧尽,不作同步拉纸.作平面转印时,一般不作同步拉纸. When stamping cylinder workpiece, it is used to adjust the start time of pull foil. Turn to left, begin to pull foil when stamping; turn to right, pull foil stop. When stamping flat workpiece, no need pull foil in transferring.
A8	电源 POWER SWITCH	电源总开关. Power switching
A9	平面/圆型 FLAT/CURVE	平面或圆型转印选择制.作平面转印时,向上拨至平面位置;作圆型转印时,向下拨至圆型位置. Press it up to flat for flat transfer ; press it down to cylinder for cylinder stamping

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续表 1continue.

A10	自动/半自动 AUTO/ SEMI AUTO	拨下至半自动位置, 启动本机可完成一次转印工作程序; 拨下至自动位置, 启动本机将不断逐次重复转印工作程序. At auto the machine run by automatic working procedure; at semi-auto, the machine will be only one working procedure.
A11	张箔开关 POIL TSNSION	拨下该按钮, 即启动装纸架上反卷马达, 对转印纸加一定反卷力以拉紧转印纸, 令转印纸平整以便转印. Press it down to start the foil motor and tighten the foil
A12	工作台调试制 TABLE TEST	向左压动该按钮, 工作台向左移动, 放开按钮, 工作台就地停止移动; 向右压动该按钮, 工作台向右移动, 放开按钮, 工作台就地停止移动. 用以试机及调校作圆型转印时胶轱与印件相对位置. Press the switching to left and the worktable move to left; let loose the switching and worktable stop. Press the switching to right and the worktable move to right; let loose the switching and worktable stop. Adjust it to find the best position between roller and work piece.
A13	电眼控制/ 时间控制 SENSOR/ TIMER	需作电眼控制拉纸时, 向上拨向电眼控制位置. 本机作电眼拉纸时, 会在压烫后, 机头回升最高位即开始拉纸. 当纸被拉至电眼黑点对正光点上, 经感应即停止拉纸. 请调校 A5 拉纸时间以使开始拉纸时先作少许自动拉纸, 从而把转印纸上电眼黑点位拉离对正辐射光点的位置. 不需作电眼控制时, 请向下拨向时间控制位置, 调校 A5 拉纸时间以设定拉纸长度. Need sensor to control pulling foil, press this switching up to sensor. After stamping, the roller raise up to top and foil begin dragging. While the black point on stamping foil is aligned with light eye of sensor, foil stop dragging. Adjust A5 (pull time) to set foil feed length so that you precision transfer picture on foil onto substrates. No need sensor, press A13 down to TIMER.
A14	试压控制 PRESS TEST	按下此制, 胶轱下压; 放开此制, 胶轱回升. 试机时用. Press the switching down, the roller drop. Let loose it, the roller is back.. it is for testing.
A15	特殊功能 SPECIAL FUNCIION	转印较大直径圆型图案时, 拨下该按钮, 便中止了 A4 下压时间功能. 胶轱会随脚制踩下而下压, 保持下压状态, 直至放开脚制胶轱才回升. 注意: 作普通圆型转印时, 请把该 按钮向上拨至空档位置. When stamping bigger diameter picture. Press this switching down to stop A4 function. The roller will be down with pressing foot switching and keep contact with workpiece till let loose foot switching. Notify: when stamping commonly cylinder workpiece, please press this switching up.
A16	胶轱调速 ROLLER SPEED	调节及设定胶轱转动速度, 配合 A4 下压时间作圆型转印. Set and adjust writhe speed of roller. Use to transfer cylinder workpiece with A4 (press time)
A17	卷纸调速 FOIL SPEED	调节及控制拉纸速度, 配合 A5 拉纸时间作转印后拉纸. 当用电眼控制拉纸时, 须将卷纸速度适当调慢, 以便电眼准确对位. Adjust foil pulling speed. With A5 pull time to control foil feed length. When using sensor to pull foil, please adjust the foil speed slowly so that accuracy overprint.

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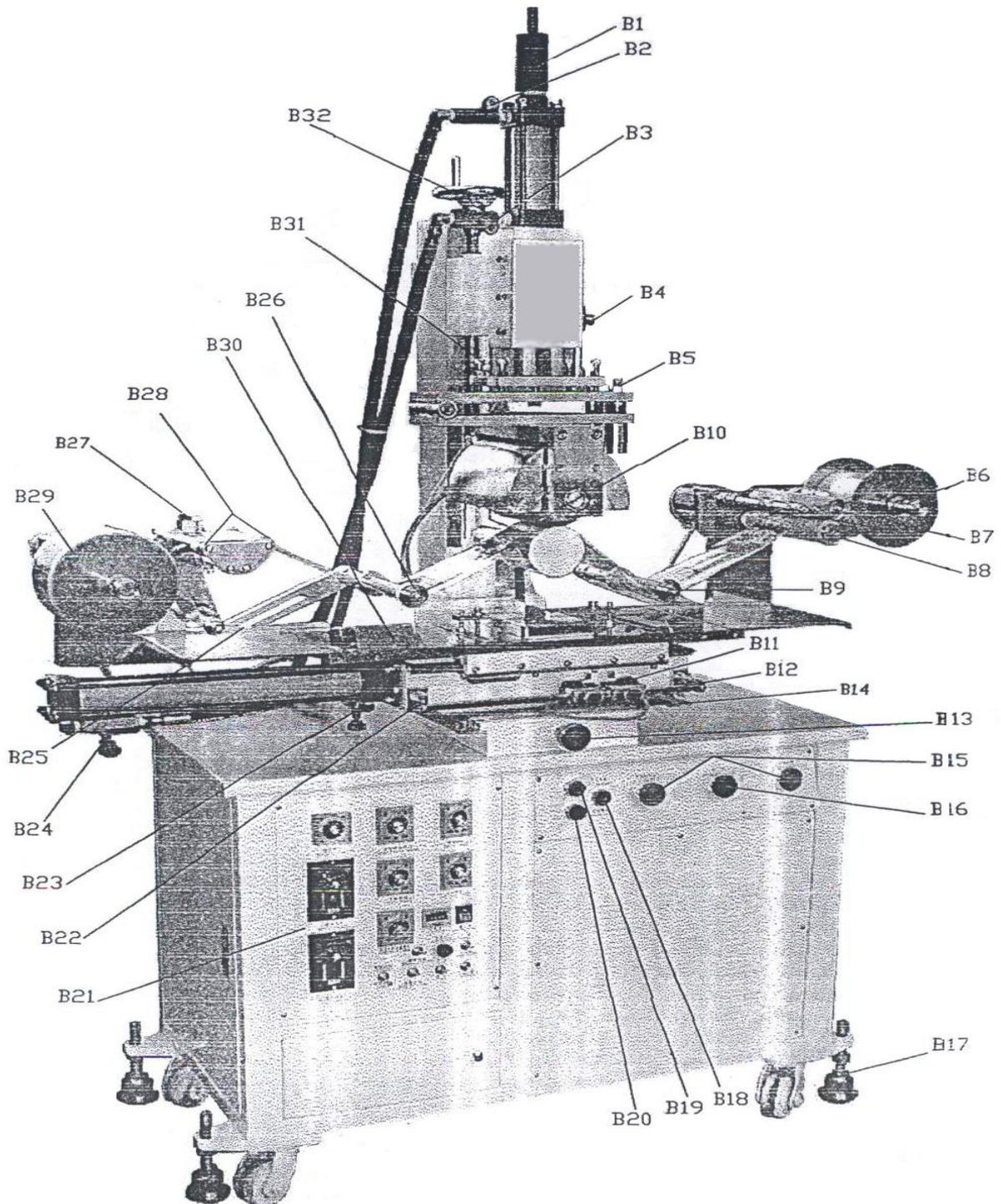
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H-300M/150M 热转印机结构图

H-300M/150M Heat transfer machine structure drawing.



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H-300M/150M 热转印机结构说明

H-300M/150M Heat transfer machine structure drawing instruction

No	名称 Description	功能 Function
B1	高度调节螺母 Head height adjustment screw.	与 32 机身调节手轮配合调节机身高度. 以使胶辊能适当烫印件. 顺时针调校调高机身; 逆时针调校调低机身. B1 作小幅度调校: B32 作大幅度调校. 调校前须松开调校上紧上端锁紧螺母. Adjust the height of head to fit for workpiece. B1 used for small breadth adjustment, B12 used for large breadth adjustment
B2	机身上升调速 Head upswing speed adjustment	调校及设定机身上升速度. 出厂时已作适当调校, 一般情况下毋须经常调校. Micro-adjustment the speed of head up. We already adjust it in factory. Please do not adjust.
B3	机身下降调速 Head descend speed adjustment	调校及设定机身下降速度, 出厂时已作适当调校, 一般情况下毋须经常调校. Micro-adjustment the speed of head down. We already adjust it in factory. Please do not adjust.
B4	凸轮微动开关 Touch switching	当本机完成一个工作程序, 机身回升至凸轮压动微动开关位置, 即作拉纸动作, 计数及作自动运作时的间歇时间计时. When finishing one working procedure, machine head raise up and the rod beside of head touch B4, foil begin to drag.
B5	调节螺丝 Adjustment screw	共四枚, 中间两枚为调整板调节螺丝. 当转印平面工件时, 上紧该两枚调节螺丝; 当转印圆型及不平工件时, 松开该两枚调节螺丝, 以令胶辊能均匀紧贴印伯进行转印. 外侧两枚为调整板弹簧调整螺丝. Total four pieces, two pieces in center connect modulate aboard. When stamping flat work piece, lock up it; when stamping cylinder work piece and coarse surface, untie two screws so that the roller can attach work piece. The other two pieces outside is connect elasticity body.
B6	集纸轴 Foil collecting axis	收集转印后废纸. Collecting wasted foil
B7	压纸辊 Press foil roller	与 B8 卷纸轴配合拉纸. Pull foil with B8 reeling foil axis
B8	卷纸轴 Foil reeling roller	与 B7 压纸辊配合拉纸. Pull foil with B7 press foil roller
B9	定位杆 Locating rod	固定走纸位置以作拉纸. Fixture foil dragging position.
B10	耐热胶辊 Roller	传输温度和压力经作转印. Transfer temperature and pressure to stamping
B11	行程开关 Distance switching	作平面转印时, 工作台向右移动至工作杆触及该开关, 即停止印程, 机身回升, 调节该开关位置可设定印程的长度. When stamping flat workpiece, worktable move to right and touch this switching, the head raise up. Adjust its position to adjust length of worktable move from left to right

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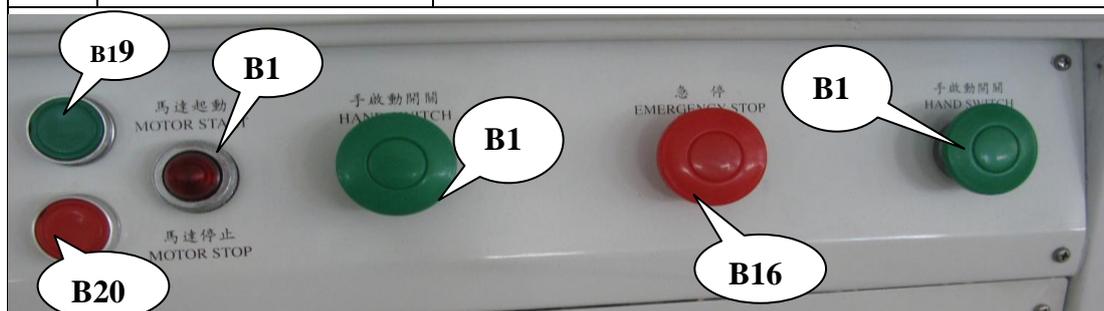
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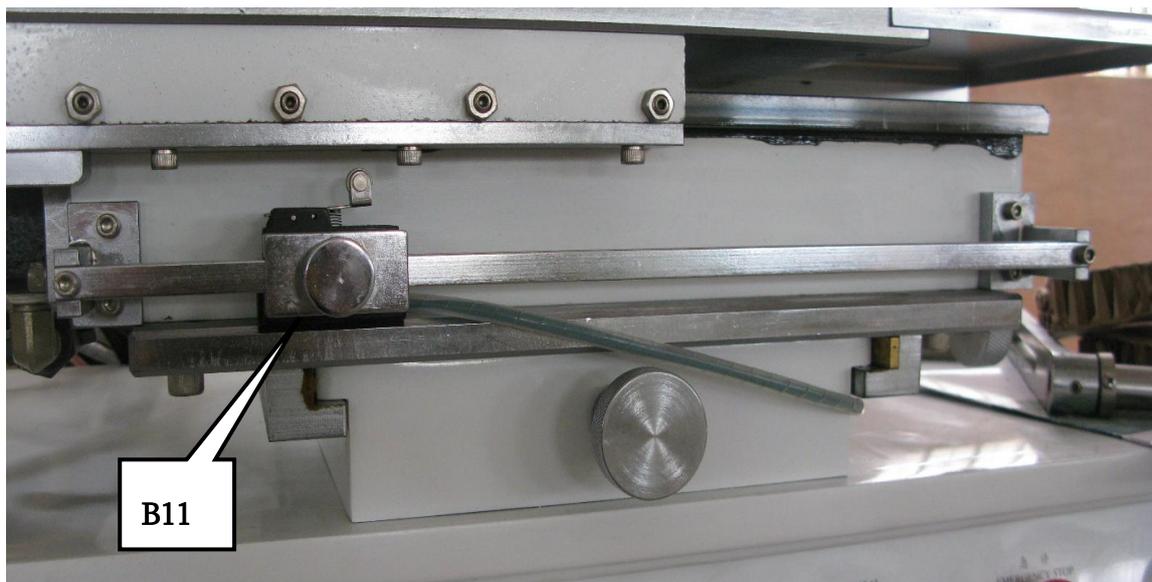
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续表 1.continue

B12	回程开关 Move back switching	工作台右移至工作杆触压该开关, 工作台开始左移回至转印前原来位置. Worktable move to right and touch this switching, worktable will move back to beginning position.
B13	前后调节手轮 Worktable wheel	用以调节工作台前后位置. 调节前须松紧开关后须上紧 B14 工作台锁紧手轮. Adjust the position of front and back
B14	锁紧手轮 Locked wheel	与 B13 前后调节手轮配合固定工作台前后位置. Fixture the position of worktable
B15	启动双制 Startup double switching	双手同时按动该两个绿色按钮即启动本机 Press two button together to start machine
B16	停机机制 Stop button	如要停机可按此制. Press this button, the machine stop running
B17	机脚 Machine foot	固定本机. Control the level of machine
B18	油压指示灯 Oil pressure indicator	灯亮即表示油压马达已启动. When it lights, oil motor start
B19	油压马达启动制 Oil motor start	按此按钮启动油压马达. Press this button to start oil motor



B20	油压马达停止制 Oil motor stop	按此按钮停止油压马达. Press this button to stop oil motor
B21	主控电箱 Operation panel	各按键功能在电箱说明中详述. Please see operation panel instruction
B22	锁定板 Locked aboard	工作台底座两边各一块, 松开四枚锁紧螺丝可作工作台微量角度调整, 调整后切记上紧四枚锁紧螺丝. There is one each one side of worktable. Untie them , you can adjust some angle . ok, locked them.
B23	右移调速 Move right speed	调校及设定工作台右移(工作)速度. 顺时针调慢, 逆时针调快. Adjust the speed of worktable move to right



续表 2.Continue

B24	左移调速 Move left speed	调校及设定工作台左移(回程)速度. 顺时针调慢, 逆时针调快. 一般情况下, 出厂时已作适当调校, 毋须经常调校. Adjust the speed of worktable move to left. Please do not adjust commonly.
B25	导纸杆固定螺丝 Locked screw	调校 B26 导纸杆后, 上紧该螺丝经定位. After adjust the position, please lock it.
B26	导纸杆 Foil adjustment rod	要据印件形状, 调整该杆高度, 经便送纸转印. 调校后须上紧 B25 棍杆固定螺丝, 棍杆上档圈作印纸限位用. Adjust the height so that the foil can feed in level and correct direction
B27	电眼架 Sensor easel	装上电眼后调校电眼架安放位置, 让电眼上射光点对准转印纸上电眼黑点. Install sensor and adjust the sensor position.

B28	送纸杆 Foil feed rod	配合 B26 导纸棍杆安装好转印纸作送纸转印。 Send foil to heat transfer with B26
B29	装纸盘 Fixture plate	把转印纸放在两个档盘之间, 对准工件位置后固定. 装纸盘有反转马达, 按下 A11 张箔开关, 可作反卷拉紧转印纸。 Fix the foil position on axis. Motor installed connect to plate. Press A11 switching, foil will be tightened.
B30	工作台 worktable	印件及夹具安放面制有间距 60×70MM 的 M3/8” 螺孔多个安装夹具。 Install jig and work piece. There are many M3/8screw apertures to install jig.
B31	调平螺丝 Adjustment screw	分列调整板四角. 调整该四周螺丝可令胶辊四角均匀压烫工件. 调整前须放松调整后须上紧下方锁紧螺母。 Untie them and adjust the level of rubber roller so that it can contact with work piece surface. After adjustment, please lock up them.
B32	机身调节手轮 Adjustment wheel	与 B1 机身调节螺母配合 调校机身高度, 以使胶辊能适当压烫印件. 顺时针调校调高机身, 逆时针调校调低机身. B1 作小幅度调校; B32 作大幅度调校. 调校前须松开调校后须上紧机身背后二枚上在压紧板上的六角螺丝。 Adjust the height of rubber roller to press down on work piece propriety with B1.

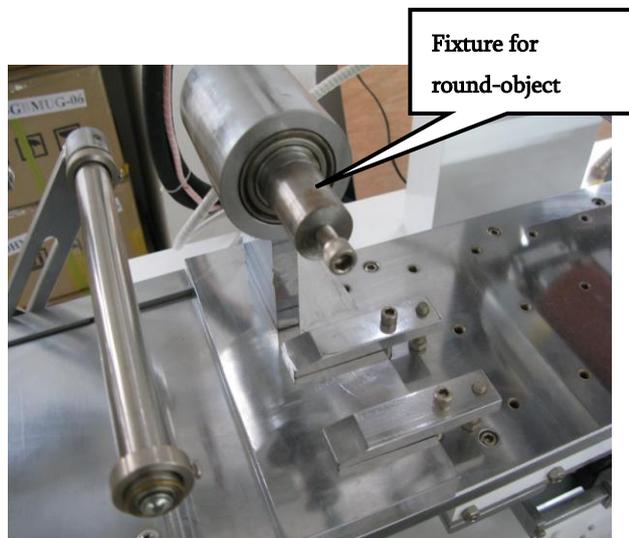
H-300M/150M 油压式平面/圆型转印机使用说明

H-300M/150M Heat transfer machine operation Procedure

一. 接上电源调校

Adjustment on power

1. 装上 380V 三相电源。
Connect 380V 3-phase power supply. Some country use 1 phase 110V, or 3 Phase 220V, Please enquire to our sales representative.
2. 打开机械左面电箱柜, 把三相电源总开关拨上至 (NO) 位置。
Open electron box and turn on total switching to "ON".



警告：必须受过专门培训的技术人员可以进行操作。

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3. 按住 A8 电源开关.

Press A8 power switching.

4. 打开机械柜右柜, 按下 B19 油压马达启动油压马达, 观察马达是否按马达上箭头指示方向转动 (一般是顺时针转动), 如果转动方向相反, 请随意调换三相引入线中两条相位线安装位置, 关上机械柜.

Open machine case, press down B19 oil motor, observe if oil motor write by a direction of arrow drawing. If no, please change any two phrase to connect power. Close the machine case.

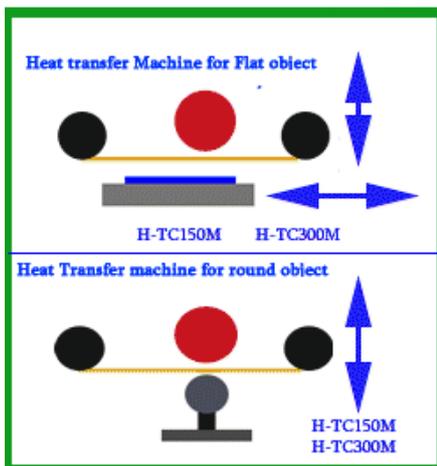
二. 机身调校

Adjustment on head

1. 装上夹具及印件.

Install jig and work piece.

Both Round and flat cab be proceed with the machine. Please make fixture according to your products shape.



按上 A14 试压按制, 观察 B10 耐热胶轱是否均匀压住印件. 否则调校 B32 机身调节手轮及 B1 机身调节螺母以修正机身与印件相对高度.

Press A14 test switching, observe if the roller equilibrium contact work piece, or please turn B32 and B1 to adjust the roller height.

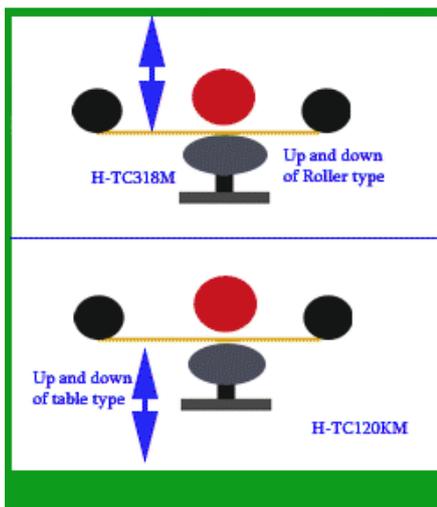
2. 调校 B31 调平螺丝修正胶轱压及印件的均匀度把压得太紧方向的螺丝调松, 把未能压紧方向的螺丝上紧.

Adjust B31 to contact work piece with equilibrium.

三. 印程调校

Stamping distance adjustment

Imitating-Shape Heat transfer machine

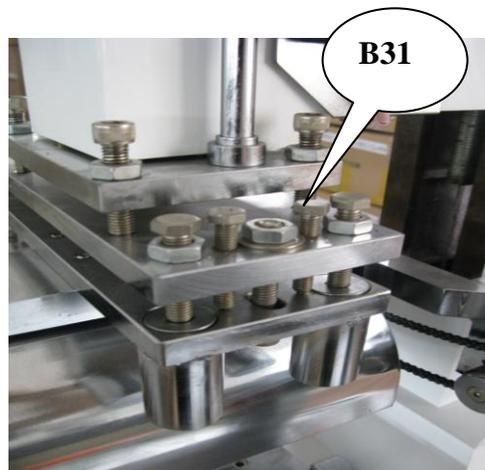


A. 平面转印 flat heat transfer.

1. 把 A9 平面/圆型转印选择制拨上至平面位置, 把 A10 自动/半自动选择制拨下至半自动位置.

Press A9 switching up to flat; press A10 switching down to semi-auto position.

2. 双手一齐按动 B15 启动双制或踩下脚



制, 观察胶辊压及印件后工作台开始右移进行转印的时间是否合适, 否则调整 A2 延迟启动时间以校正。

Press B15 with two hands or tread down foot switch, observe if fitness that the time of work table move to right when roller press on work piece.

3. 工作台右移至工作杆压及 B11 停印开关以时, 即停止印程, 机身回升. 观察印程是否不足或过长, 调整 B11 停印开关以校正. 机身回升后, 工作台会停动一个短时间以消除工作台右移的冲击力, 然后左移回至转印前位置, 旧设计 B12 回程开关已予取消。

Work table move to right and the rod touch B11 switching, the work table will stop. Observe the distance if correct. Or please adjust the position of B11. When roller rises up, worktable will stay to remove the impact, then come back to beginning position.

B. 圆型转印

Cylinder heat transfer

1. 把 A9 平面/圆型转印选择制拨下至圆型位置, 把 A10 自动/半自动选择制拨下至半自动位置。

Press A9 down to cylinder position, press A10 down to semi-auto position.

2. 启动本机后, 胶辊本身转动带动夹具转动进行圆型转印. 根据印程长短及印出效果配合调校 A4 下压时间旋钮及 A16 胶轮调速, 以达最佳转印效果。

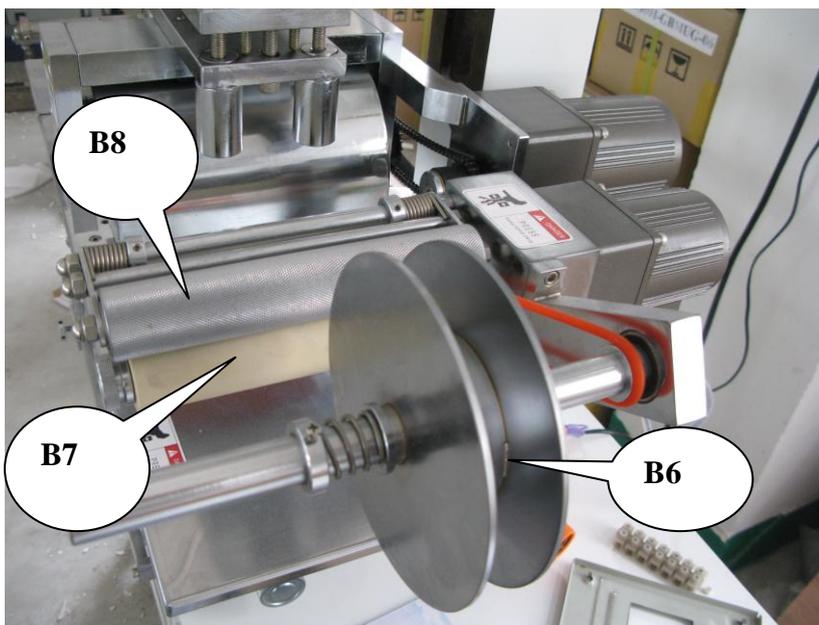
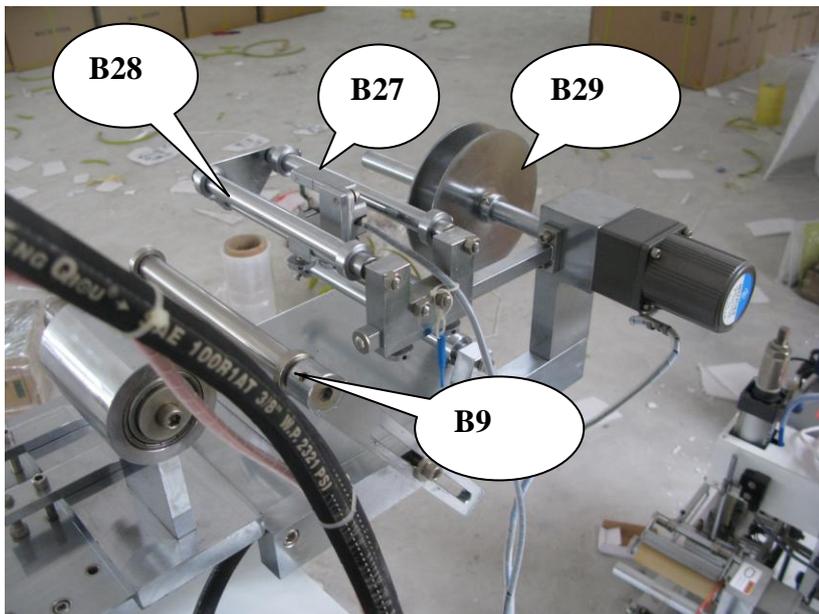
When starting this machine, roller will bring jig turning to transfer on cylinder products. Adjust A4 press time and A16 roller speed according to stamping distance and cylinder work piece diameter.

3. 转印较大直径圆型图案时, 拨下 A15 特殊功能按钮, 便中止 A4 下压时间功能, 胶辊会随脚制踩下而下压, 如脚制持续踩下胶辊保持下压状态, 直至放开脚制胶辊才回升。

Bigger diameter work piece need pressing A15 down. Please use foot switching to operate the machine. The roller rises up till you move your foot away.

4. 如作普通圆型转印, 必须把 A15 特殊功能按钮拨上至空档位置方可作正常运作。

Commonly cylinder transfer must press A15 up to empty position.



提示:

- 确保安装产品的夹具的中心线和胶辊的中心线在一个平面内!
- 确保产品能在夹具上面自由转动

四. 安装转印纸

Install foil or transfer film.

1. 把整卷转印纸装入 B29 装纸盘上, 请参阅结构图上转印纸安装方法安装绕过送纸杆铺过 B27 电眼架, 下绕 B28 送纸杆, 跨过印件, 再绕 B9 定位杆, 在 B7 压纸棍与 B8 卷纸轴之间穿过, 把纸头贴在集纸轴上纸筒即可。

Install foil roller on B29, please see page 5, across foil feed rod B27, B28, COVER WORKPIECE, then B9, through B7 and B8.

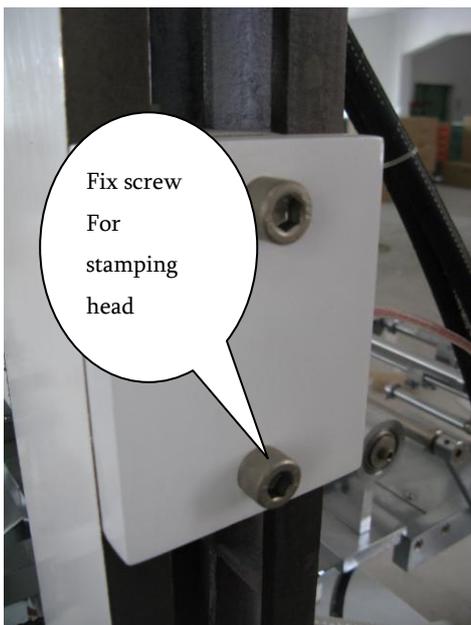
热转印机可以使用烫金纸和热转印纸, 烫金纸需要使用烫金纸切割机切割成合适的宽度。

2. 调校 B13 前后调节手轮, 可调节工作台前后位置。调校前须松开调校后须上紧 B14 锁紧手轮。松开工作台底座两边 B22 锁定板上四枚锁紧螺丝, 可做工作台微量角度调整。调整后切记上紧四枚螺丝。

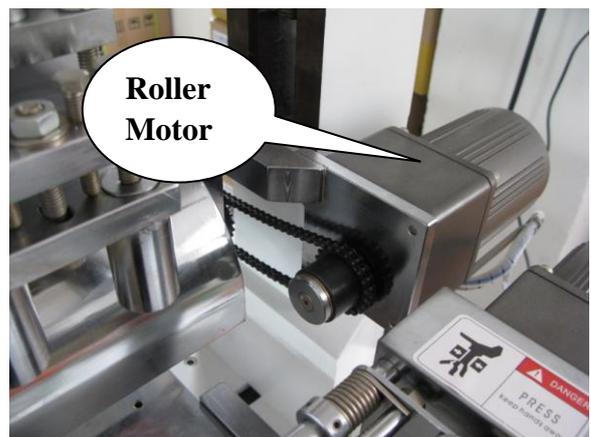
Adjust B13 wheel to set the work table front and back position. Before adjusting you must untie B14 and lock after adjustment.

五. 温度调校

Temperature adjustment



1. 调校 A1 温度控制可设定转印所需温度。为延长胶辊寿命, 每天第一次调温时, 最好采用分段升温。即先将温度调至 180℃, 待工作指示灯(ON)熄灭后, 再设至所需温度。一般设在 230℃ 左右, 温度太高, 印出图案边界模糊甚至烫溶烫金纸; 温度太低, 圆案残缺或容易掉色。需根据印件质地及印出效果而设定温度。



Set the temperature by A1 temperature controller. In order to elongate the

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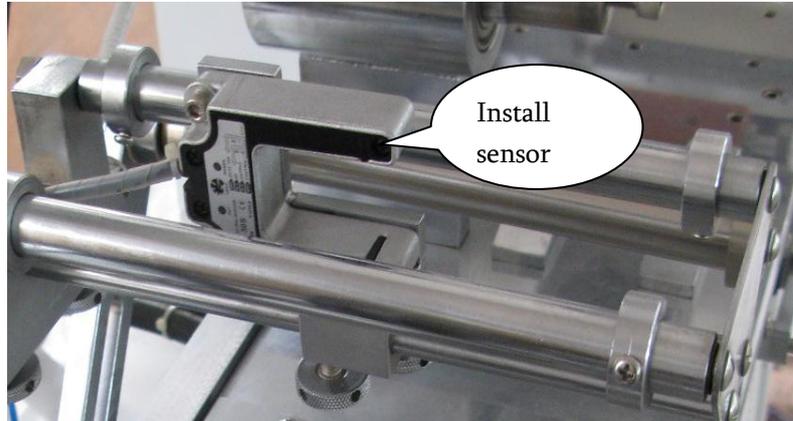
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life of roller, suggest you set temperature two-time. First set the temperature at 180°C, after the indicator turns off, set the needed temperature.

2. 设定温度后, 当 A1 温度控制上工作指示灯 (ON) 第一次熄灭, 表示本机已达到所需温度并自动保持该温度。由于耐热胶辊需要较长预热时间, 请再耐心等待十五至二十分钟。让胶辊充分预热再作转印。转印过程中, 灯会多次亮灭, 表示自动控温正在运作。



After setting temperature, A1 indicator turns off, the machine come to needed temperature and automatic maintenance. Wait for 15-20 minutes then begin to transfer. Because the roller have a longer pre-heat time. The indicator will turn on and off in stamping process.

3. 关机前请先把 A1 温度控制向左拧尽 (停止加热) 让胶辊空转散热约三十分钟, 以免因受热不匀而烘坏胶辊。(本机现增设自动胶辊空转装置, 按动 A8 电源开关灯熄灭后胶辊仍自动空转二十至三十分钟以确保胶辊得以冷却。

Before shutting off the machine, please turn A1 to zero to stop heating. There is roller automatic delay stop unit to protect roller.

六. 拉纸调校

Foil pulling adjustment

1. 时间控制拉纸 **time control pulling foil**

适用于整个表面烫金和没有定位要求的转印。不需作电眼控制拉纸时, 把 A13 电眼控制/时装控制向下拨至时间控制位置, 调校 A5 拉纸时间制以设定拉纸长度。

Press A13 down to time position, adjust A5 pulling time to set pulling foil length.

在此模式下, 拉纸动作在完成转印后进行。

2. 同步拉纸 **synchronization pulling foil**

作圆型转印时, 转印纸会偶连印件圆周转动影响运作, 因而需要转印期间同步拉纸。调校 A7 同步拉纸延迟时间制, 可设定同步拉纸的起动时间, 向左拧尽转印开始时, 即时同步拉纸; 向右拧尽, 不作同步拉纸。作平面转印时, 一般不作同步拉纸。

For cylinder work piece, need pulling foil synchronization while stamping. Please adjust A7 delay time switching to set the start time of synchronization pulling foil, turn to left end, begin synchronization pulling foil; turn to right end, no synchronization pulling foil. When stamping flat work piece, no need synchronization pulling foil.

3. 电眼拉纸 **Pulling foil by sensor:**

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电眼拉纸适用于定位要求的热转印。热转印纸的边缘会印有黑色识别点。电眼会识别这些黑点从而控制拉纸长度。

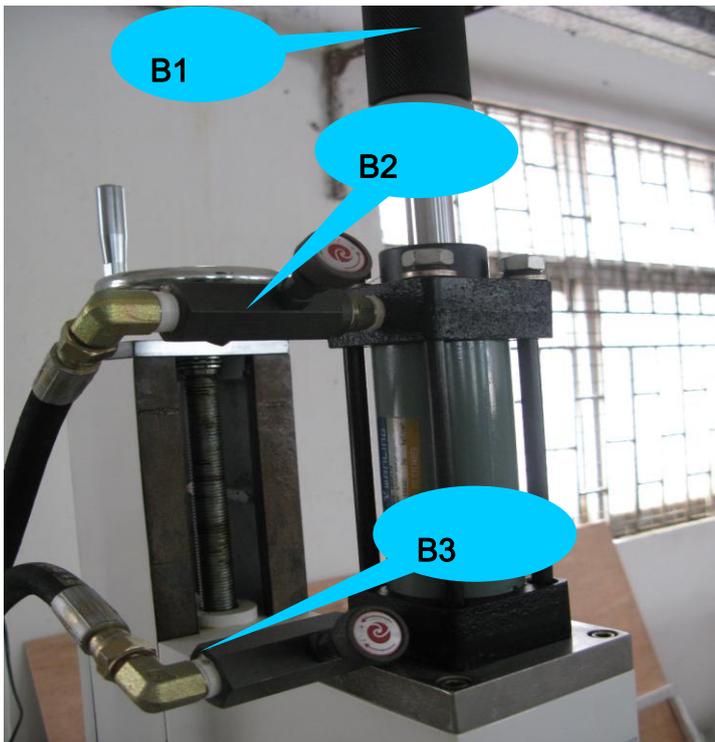
a 把 A13 电眼控制/时间控制向上拨至电眼控制位置。

Press A13 up to sensor position.

b. 把电眼安装在 B27 电眼架上，调校电眼架安放位置让电眼光位对准转印纸上电眼黑点。

Install sensor on B27; adjust its position and let foil and film across.

c. 本机作电眼拉纸时，会在压烫后机头回升最高位即开始拉纸，当纸上电眼黑点被拉到对正镭射光点上，经感应即停止拉纸。请调校 A5 拉纸时间以使开始拉纸时先作少许自动拉纸，从而把转印纸上电眼黑点位置拉离对正镭射光点的位置。



When pulling foil by sensor, foil will be pull when head raise up to highest top till the black point cover the light eye of sensor.

d. 适当调慢 A17 卷纸调速的速度，以便电眼能准确对位。

Adjust A17 at a more slowly speed so that sensor can precision be aligned

请注意： 在电眼拉纸模式下，应确保循环时间大于拉纸时间， 否则，拉纸长度可能不够；请配合拉纸时间和循环时间来使用。

七. 自动调校

Automatic operation adjustment

1. 如需作自动运作，可把 A10 拨上至自动位置。

Press A10 up to auto position

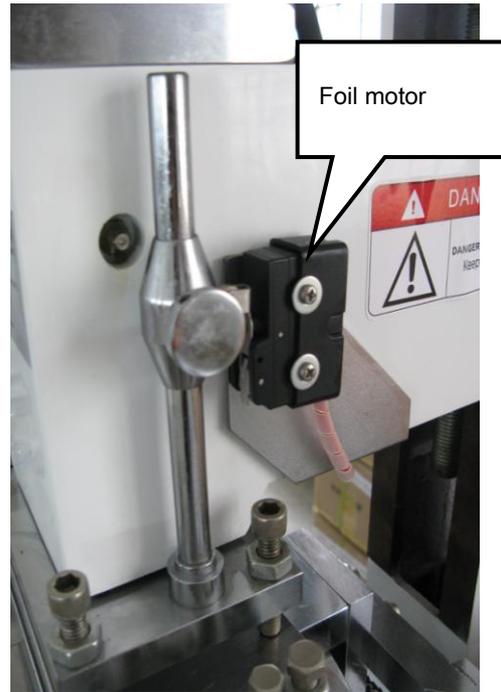
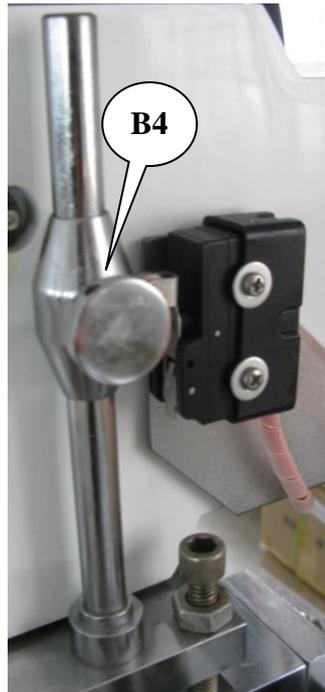
2. 调校 A3 循环时间，设定两个工作周期之间的间歇时间。

Adjust circulation A3 to set intermission time between two working weeks.

3. 机身上升至 B4 凸轮压及微动开关时，即开始拉纸时间及循环时间，注意机身回升最高位置定后 B4 凸轮须压及微动开关。

- 建议初次使用热转印机的用户采用半自动操作模式，熟练操作后再采用自动操作模式。
- 操作时请勿将身体的任何部位靠近夹具和胶辊；
- 避免高温烫伤。

When head rise up to touch B4 touch switching, foil begin to be pull time and circulation time. Please notice: when head rise up to top, B4 should be touched.



八. 开关

How to start and shut off the machine

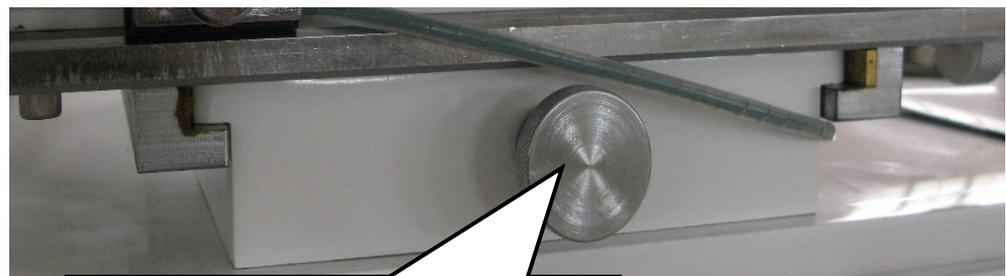
1. 工作过程如需停机, 可按 B16 停机制.

Press B16 to stop the machine in running

2. 关机前三十分钟, 先关 A1 温度控制.

First shut off A1 temperature controller 30 minutes ago.

3. 用木方楔上机身下降的空位, 以免关上油压马达后机身一降, 胶辊直接紧压夹具而损坏.



Adjust the back-forth position of working

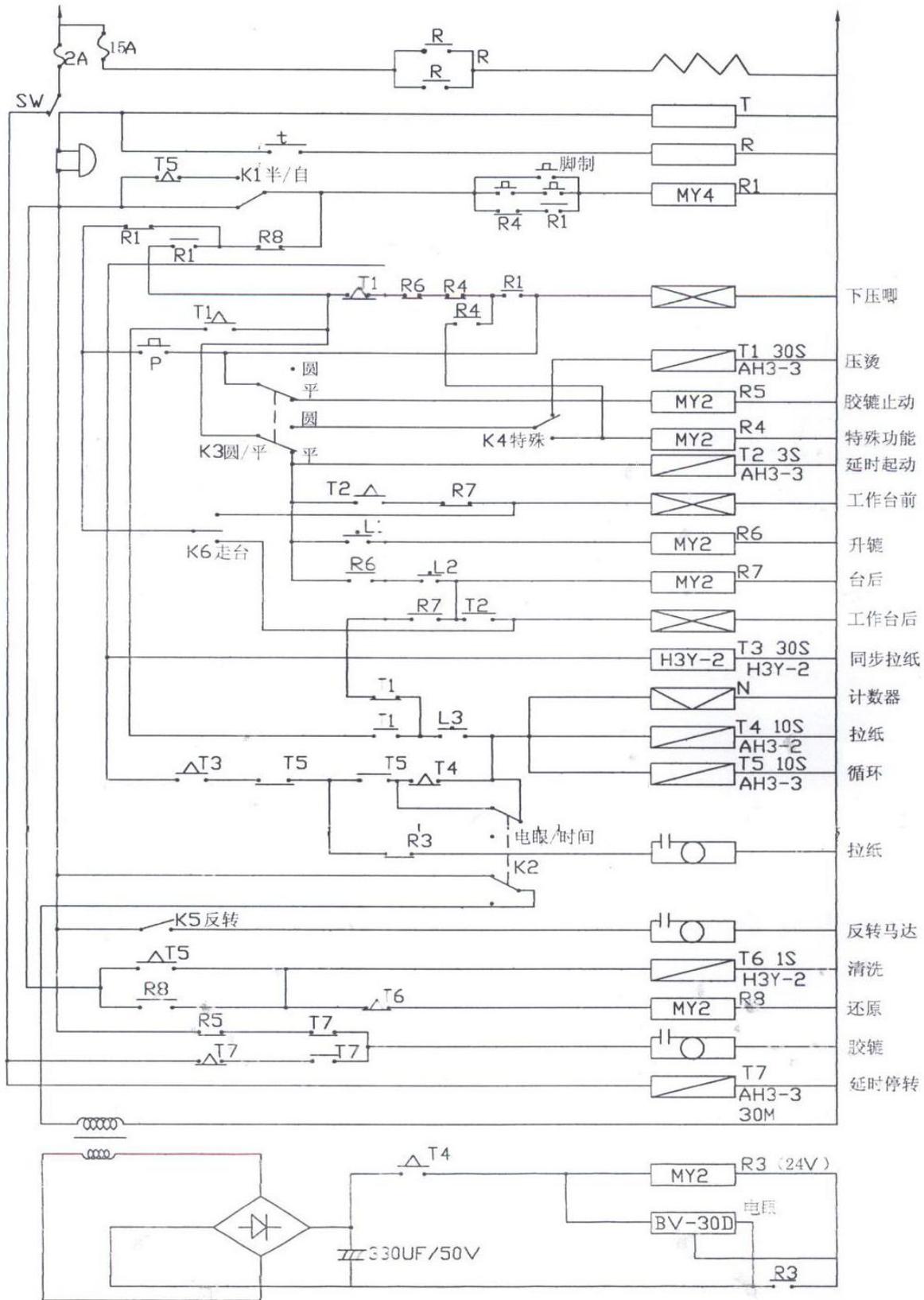
Please support the roller by wooden to avoid hurt the roller after oil motor shut off.

4. 关上 A8 电源开关.

Shut off A8 power switching

5. 如需长时间关机, 打开电箱柜关上三相电源总开关.

No use long time, please turn off total switch after opening machine box.



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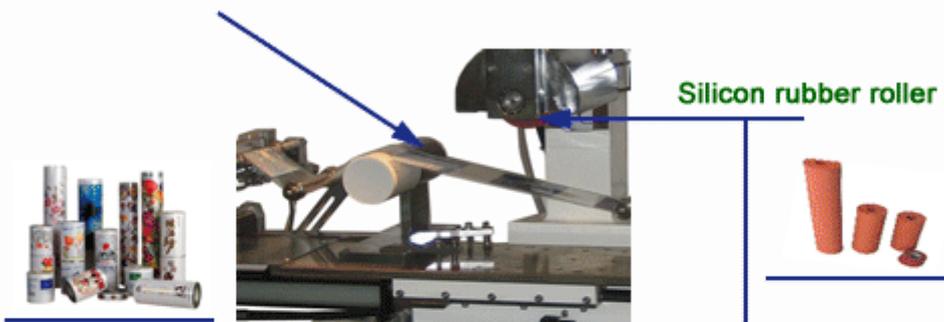
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平曲面热转印机

Flat/cylinder Heat transfer machine

When transferring onto Round-object, Please make the working table stillness
 When transferring onto flat-object, please make the working table movement

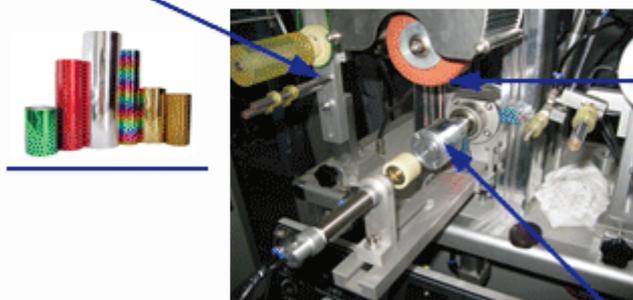
Fixture for cup



Silicon rubber roller

H-150M Heat transfer machine For cup trasfering testing

Heat transfer film
Hot stamping foil



Fixture for cap

H-TC120KM imitating-shape heat transfer machine for Cap stamping test.

您必须准备烫金纸和热转印膜-有专门的供应商为您提供;

Please prepare hot stamping foil or heat transfer film;

您必须准备适合产品的夹具-通常会建议用户要求机器的供应商来帮助制造;

Please make fixture base on your objects to be transferred

转印所用的胶辊要根据不同的要求进行选择: 可能需要磨削, 或者选择合适的宽度。

Please choose suitable rubber roller.

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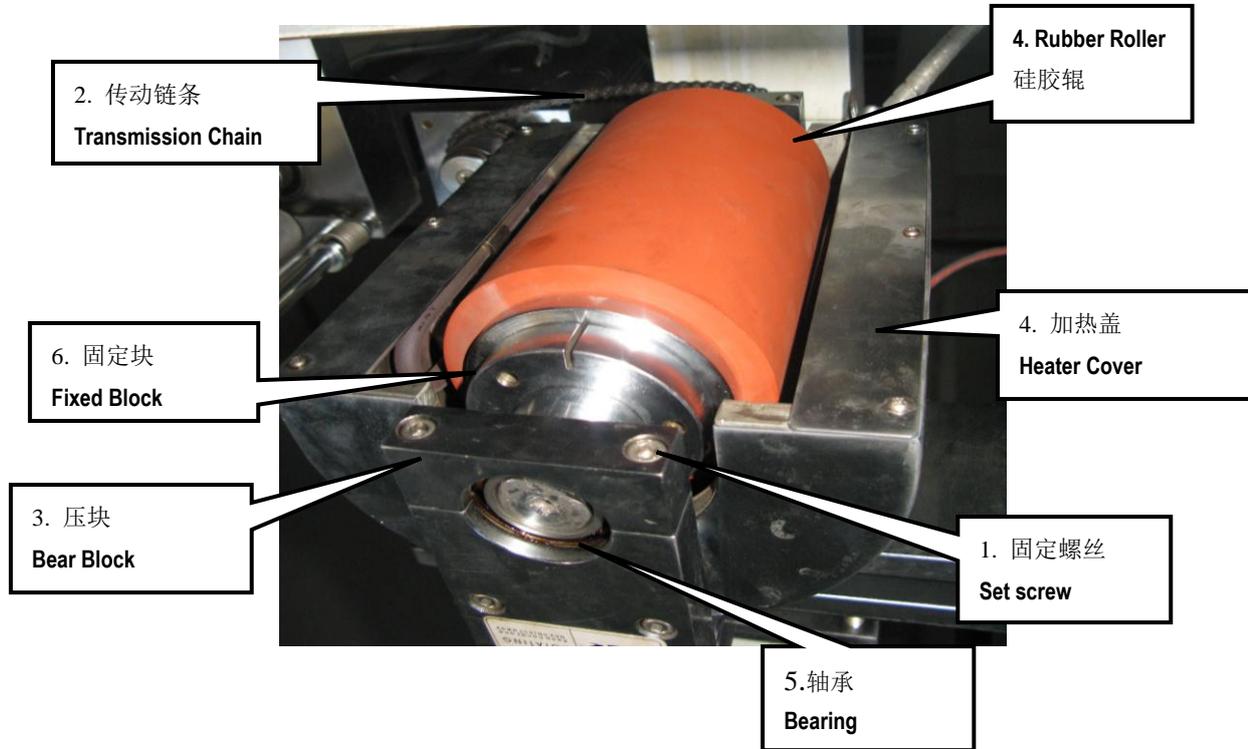
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如何更换胶辊

How to replace Rubber roller?



- 1) 确保电源关闭，胶辊冷却下来之后更换胶辊；
- 2) 先松开 4 个固定螺丝 1，
- 3) 去掉压块 3。去掉传动链轮，带有胶辊轴的胶辊可以从加热盖 4 中去掉；
- 4) 去掉轴承 5。固定块 6。胶辊就可以从轴上面去掉。
- 5) 更换胶辊后，再按照相反的步骤，将胶辊安装到加热盖中间。

- 1) Make sure power is off, cooled down before the roller replacement;
- 2) First Loosen the four screws (1)
- 3) Remove the briquetting (3). Remove the drive sprocket with roller shaft can be removed from the heated cover (4);
- 4) Remove the bearing(5). Fixed block (6). Rubber roller to remove the top from the shaft.
- 5) Replace the rubber roller, then the opposite of the steps to install the heating roller cover the middle.