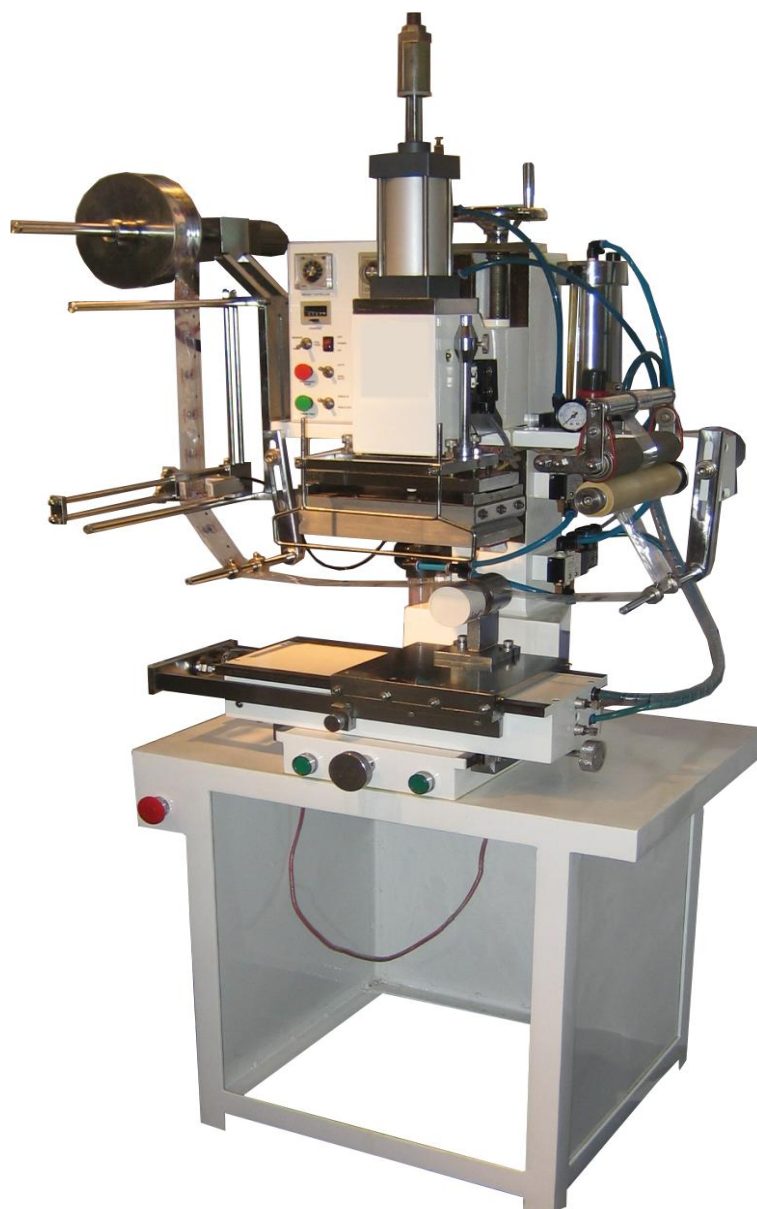




H-TC70K 曲面烫金机使用说明书



H-TC70K Cylinder Hot Stamping Machine

Operation Instruction

东莞市高宝印刷机械科技有限公司

1-16

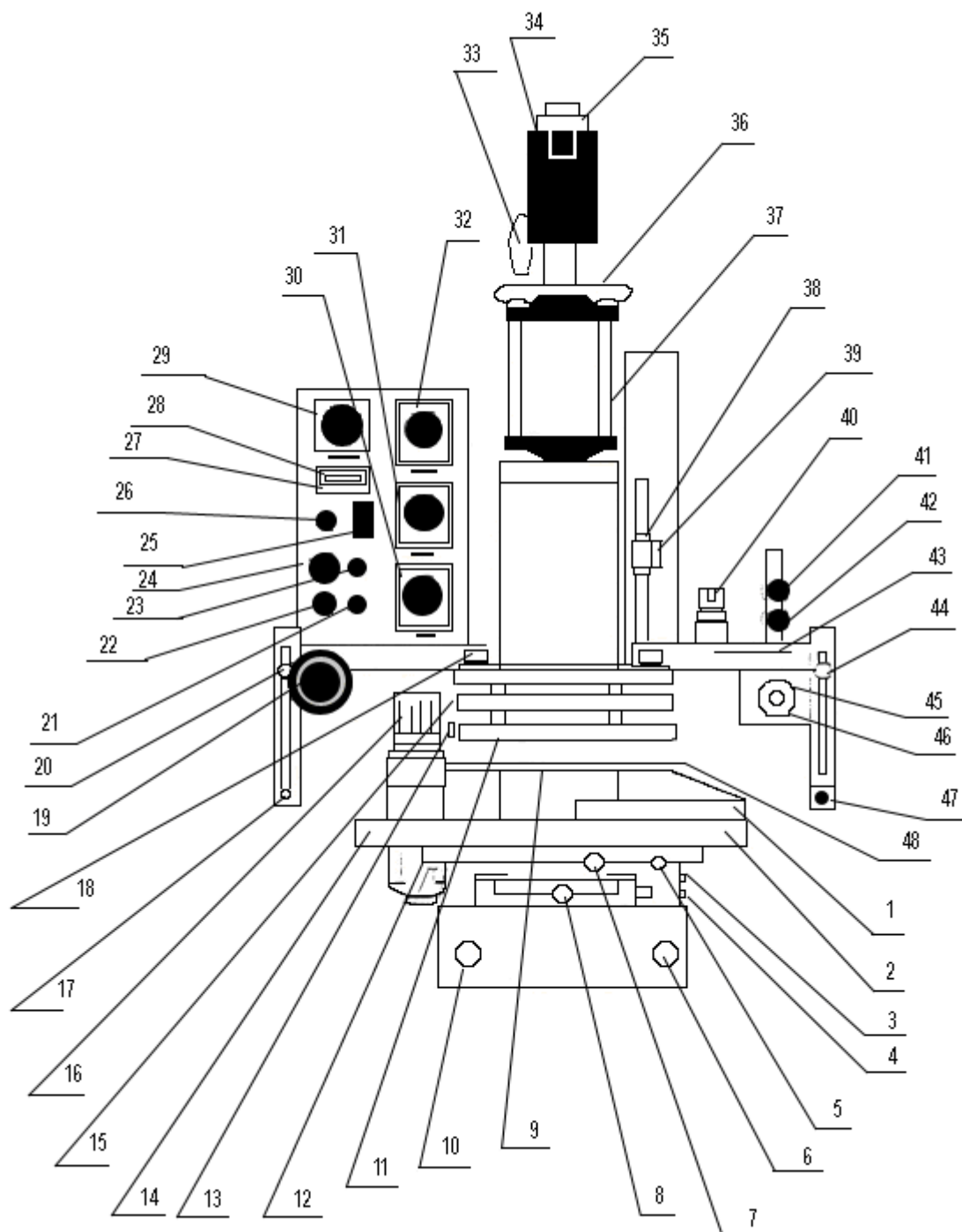
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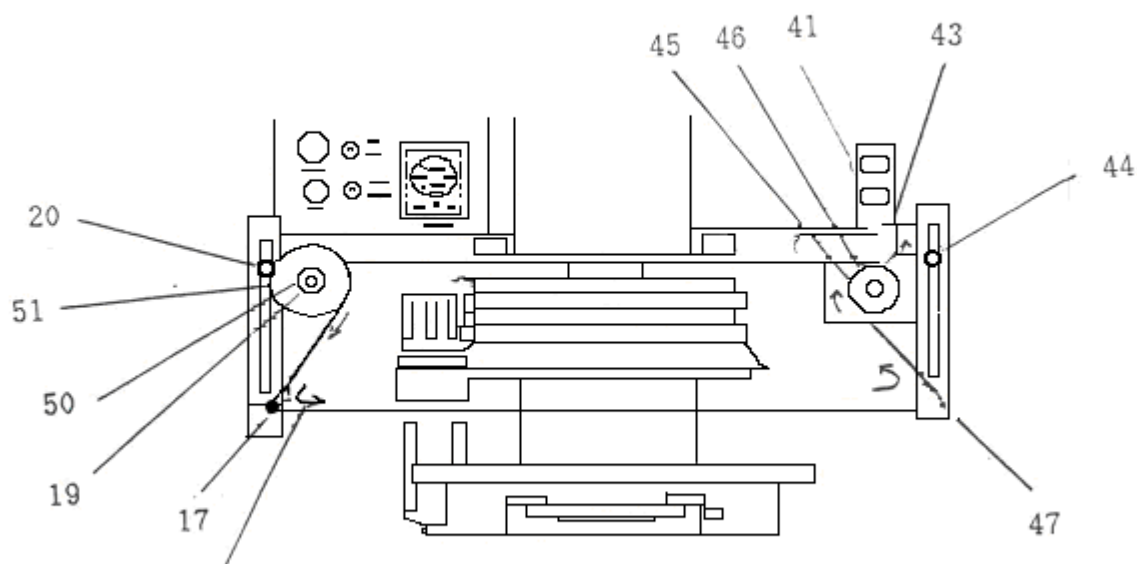
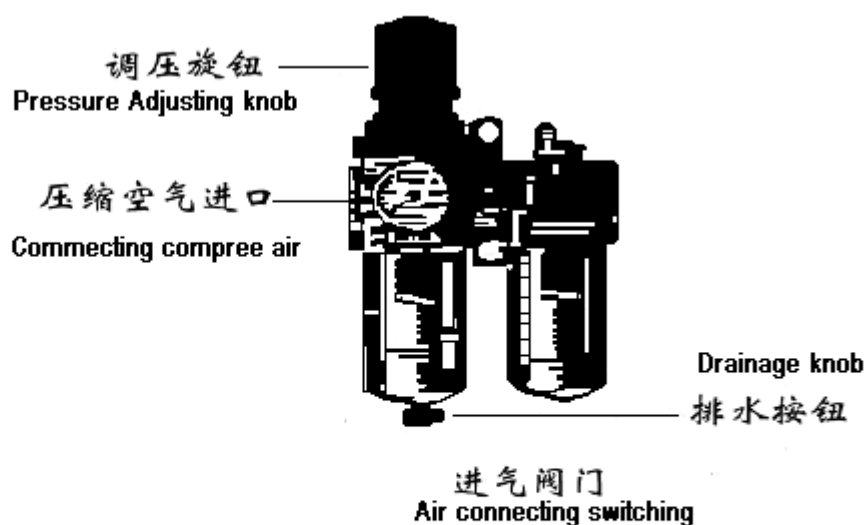
Website: [Http://www.dg-padprinter.com](http://www.dg-padprinter.com)

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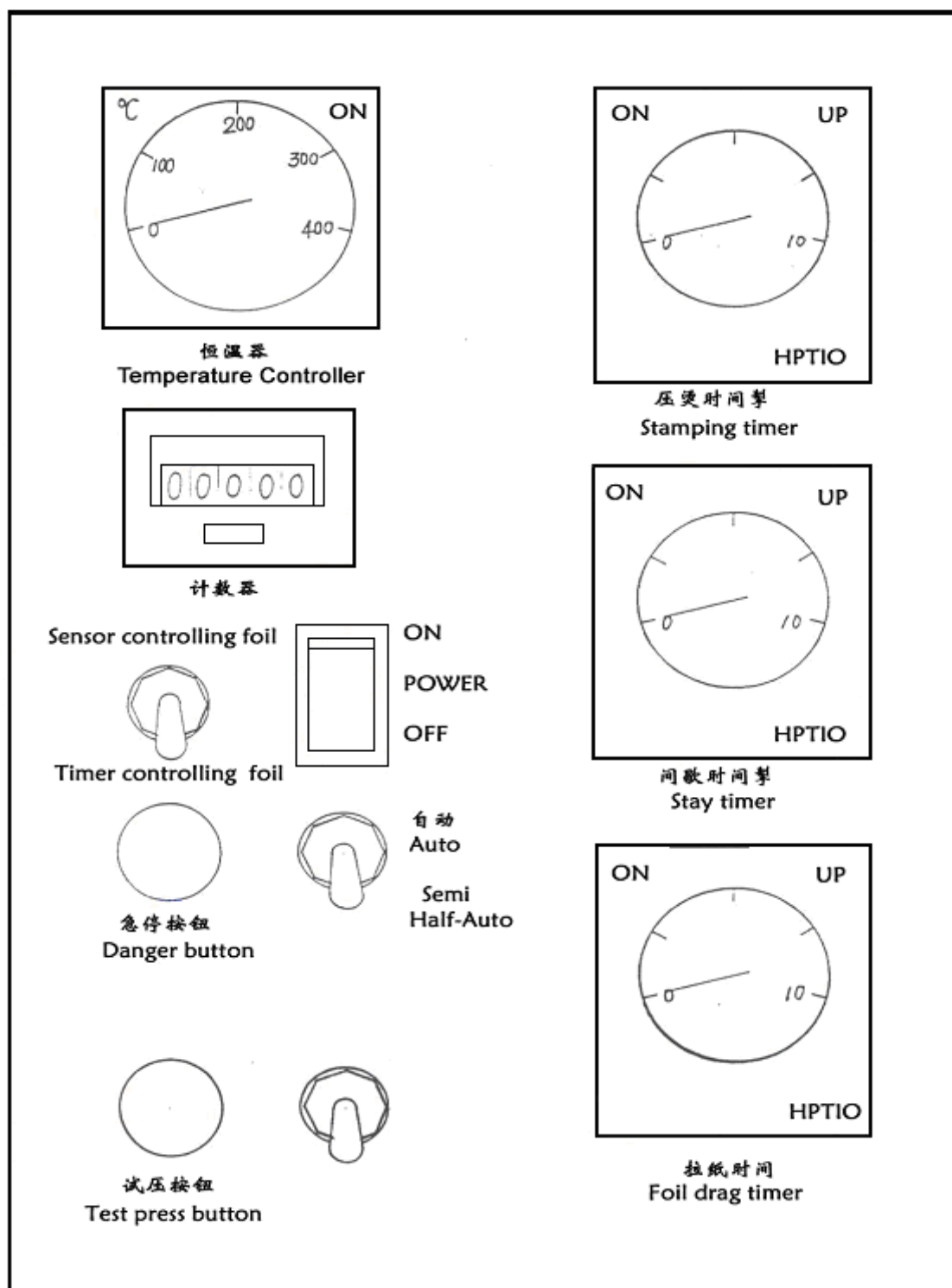
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按照图示方向安装烫金纸
Install stamping foil according to the direction displayed on drawing.

H-TC70K 控制面板说明图





- H-TC70K 曲面烫金机结构说明
- H-TC70K cylinder stamping machine part instruction

NO	名称 Description	功 能 Function
1	活动工作台 Shuttle working table	动作时活动工作台（1）会由右向左移动。配合夹具和电版砧（48）令圆型印件均匀转以作烫印。 Move from right to left and finish cylinder stamping with fixture and upper plate(48)
2	固定工作台 Working table	通过固定工作台（2）上各调校旋钮，调校活动工作台位置。 Install shuttle working table and adjust work piece position
3	印程限流阀 Stamping length valve	调校烫印时间长短。顺时针方向调校增长烫印时间；逆时针方向调校加快烫印时间。如果上紧，则活动工作台不会起动，调校前必须松开及调校后须上紧底部之六角锁紧螺母。 Adjust the stamping length. Turn to right for increasing stamping time, turn to left for expediting stamping time.
4	回程限流阀 Backhaul adjustment valve	调校烫印完成后回程时间快慢。如果上紧，活动工作台在完成烫印后将停留不动，不会自动返回起点。 Adjust the speed of working table backhaul.
5	角度调整螺丝 Angle adjustment screw	调校该螺母可令活动工作台（1）作微量角度的调校，以校焉烫印面的平行。调校前须松开及调校后须锁紧分列固定工作台（2）底部四色之四枚锁紧螺丝（12）。 Adjust the angle of working table
6	按钮 Button	同时按动本按钮及按钮（10），即启动烫金机。 Press this button and button (10) to start stamping machine
7	调整螺母 Adjustment screw	调校烫印时活动工作台（1）行程长短。上紧该螺母于较左位置，缩短印程；上紧该较右位置，增加印程。 Adjust the move distance of working table(1).
8	调整手轮 Adjustment hand wheel	调校活动工作台（1）作前后方向移动，使印件位置与电版位置吻合，调校前须松开及调校后须锁紧分列固定工作台（2）底部四色之四枚锁紧螺丝（12）。 Adjust the working table(1) to move back and front so that the stamping plate contact correctly with substrates.
9	护栏 Safe rod	安全装置，操作时，当操作者手部触动护栏（9），即停机，电版砧（49）立刻恢复最高位置。 Machine stop when the hand contacts it. Meantime the plate (49) goes back to top position immediately.
10	按钮 Button	同时按动本按钮及按钮（6），即启动烫金机。 Press the button and button(6) together to start the machine
11	发热板 Heat plate	内藏发热体，发出热力传至发热板砧（49）作烫金之用。 Install heat tube and transfer heat to upper plate(49)

续表 1

12	锁紧螺丝 Lock screw	共四枚, 分列固定工作台(2)底部. 调校活动工作台位置后, 上紧四枚螺丝以定位. Total 4 pcs. Finishing adjusting position of working table, please lock up the four screw
13	固定螺丝 Fasten screw	分列电版式砧两边共六枚, 固定电版砧在发热板之上. 松开则可取出电版砧. 当新装电版砧时, 切记要上紧该六枚螺丝, 否则发热板上热量不能很好地传到电版砧上, 影响烫印效果. Fasten the stamping plate on the heat plate. Untie it and take out stamping plate. After change one new stamping plate, you must tighten six screws.
14	调校螺母 Adjustment screw	位于固定工作台(2)左侧后部, 用于调校活动工作台烫印起点之左右位置. Adjust the beginning position of shuttle working table stamping point
15	调校板 Adjustment plate	通过调节分列上面四角之调节螺丝(18), 使电版砧均匀压烫, 以达最佳烫印效果. Adjust the screw(18) so that stamping plate press stamping with substrates uniformity
16	进气总承 AIR switching	供应烫金机用气压装置, 如果在透明孔中看到积水, 请按下方之白色排水按钮排水, 并请经常注意排水. Provide compress air to stamping machine.
17	烫金纸左定位杆 Left rod	与烫金纸右定位杆配合, 设定烫金纸安装位置. Enactment stamping foil position
18	调节螺丝 Adjustment screw	共四枚, 分列调整板上四方. 适当调节可使电版砧四面均匀地进行压烫, 以达最佳烫印效果. (必须松开下方之六色螺母方能调校). Adjust the press between stamping plate and substrates
19	烫金纸档圈 Circle	固定烫金纸 Fasten stamping foil
20	定位螺丝 Screw	固定烫金纸左定位杆(17)位置 Fasten left rod position
21	钮子开关 TABLE IN/TABLE OUT	钮子开关(21)于向下位置(TABLE OUT)时, 活动工作台(1)会移至左位置并停留不动, 以便检查及校机, 日常动作时必须把钮子开关发于向上(TABLE IN)位置. When the button press down to TABLE OUT, shuttle working table(1) move to left position and stillness so that maintain the machine; when operating the machine, please press the button to TABLE IN.
22	按钮开关 Press TEST	手按该按钮开关电版砧(48)即压下, 并保持压下状态. 放开该按钮开关, 电版砧即升起. 试机及上电版时用. When pressing it, the stamping head press down and keep down, or the stamping plate raise up When testing machine
23	钮子开关 AUTO SEMI-AUTO	选择敲定烫金机作自动或半自动操作. Choose auto or semi-auto operation



续表 2

24	急停按钮 EMERGENCY STOP	按下此按钮, 烫金机立刻停止动作, 电版式砧(48)回升最高位置. 在紧急或特殊情况下用. Press it to stop machine when dangerous
25	电源开关 Power supply	烫金机电源总开关 Provide power supply
26	转换制 SENSOR TIMER	时间控制及电眼控制拉纸转换制. 非电眼控制拉纸时, 则须把转换制发下至时间控制(TIMER)位置, 才能准确调校烫金后拉纸时间. Choose sensor controlling foil (SENSOR) or time controlling foil (TIMER)
27	计数器复位按钮 Reset	将计数器(28)所显示数字复位为 0. Reset Arithmometer (28) to zero
28	计数器 Arithmometer	显示烫印实际数目. Display stamping number
29	自动恒温器 TEMPER CONTROLLER	调节及控制发热板(11)的温度. 温度计数器调节好后, 等待预热, 当右上角红灯第一次熄灭时, 即表示烫金机已经达所需温度, 并自动维持该温度. Adjust the stamping temperature according to stamping substrates.
30	时间控制器 FOIL FEED TIMER	控制烫金纸输送长短. Controlling foil length feeding
31	时间控制器 PRESS TIMER	作自动操作时, 设定两个工作程序之间的间歇时间. When auto operation, set the time between two working process
32	时间控制器 PRESS TIMER	控制及设定电砧板(48)压烫工作时间. Controlling and set the stamping time
33	手轮 Hand wheel	调节电砧板(48)与工件之间高度. 调节前须松开及调节后须锁紧机身背后两枚螺丝. (大幅度调节). Adjust the distance between stamping plate and work piece. high range adjustment
34	调节螺母 Adjustment screw	调节电砧板(48)与工件之间高度. 调节前须松开及调节后须锁紧螺母(35).. (小幅度调节) Adjust the distance between stamping plate and work piece. (small range adjustment
35	锁紧螺母 Locknut screw	调校调节螺母(34)完毕, 上紧螺母以定位. When adjust (34) ok. Lock it up.
36	上排气阀 Cylinder valve	位于气缸后面上方, 调节顶部螺丝可控制电版砧上升速度. Adjust the speed of stamping plate raise up
37	下排气阀 Cylinder valve	位于气缸后面下方, 调节顶部螺丝可控制电版砧下压速度. Adjust the speed of stamping plate press down.
38	凸轮 Cam	电版砧(48)下压过程中, 凸轮(38)压及启动开关(39)活动工作台(1)便开始工作; 凸轮(38)安装位置要与电版砧位置配合, 以选择最佳启动活动工作台时间. In the process of hot stamping plate press down, when the cam(38) contact button(39), the shuttle working table begin to move;

续表 3

39	启动开关 Startup switch	当凸轮 (38) 压及启动开关 (39), 即启动活动工作台. Startup (39) contacted by the cam(38) and make shuttle working table moving.
40	调压阀 Press adjustment valve	调节压烫印压力 Adjust the pressure of stamping plate
41	压纸棍 Foil press roller	收集烫金后圈子纸 Collect waste stamping foil
42	压轮 Wheel	将卷纸轴 (45) 之动力传至集纸轴 (41). Collect stamping foil with roll foil axis
43	压纸棍 Foil roller	与卷纸棍 (45) 配合, 拉送烫烫纸. Pull and feed stamping foil with roll foil axis
44	定位螺丝 Screw	固定烫金纸右定位杆 (47) 位置 Fasten right orientation rod(47)
45	卷纸轴 Collect axis	与压纸棍 (43) 配合, 拉送烫金纸. Drag stamping foil with foil press roller
46	捏手 Wheel	手动拉送烫金纸. Pull stamping foil by hand
47	烫金纸右定位杆 Right orientation rod	与左定位杆 (17) 配合, 设定烫金纸安装位置. Fasten the position of stamping foil with left rod
48	电版砧 Upper plate	固定电版, 传送温度压力, 进行烫金. Fix stamping plate for stamping

图二: H-TC70K cylinder hot stamping machine part instruction

H-TC70K 型全自动圆型烫金机操作

H-TC70K cylinder hot stamping machine operating instruction

第一章 开机前工作

Pre-working

(一) 参阅附图二, 将空气压缩机气后接至进气总承 (16) 之入气口, 将调压旋钮向上拉, 然后顺时针或逆时针方向旋转即可



调整气压. 顺时针加压, 逆时针减压, 正常值应在 6 kg f/c m² 左右. 操作时要经常注意在透明杯中观察是否发现积水, 如果发现积水, 拉下下方排水钮便可排水.

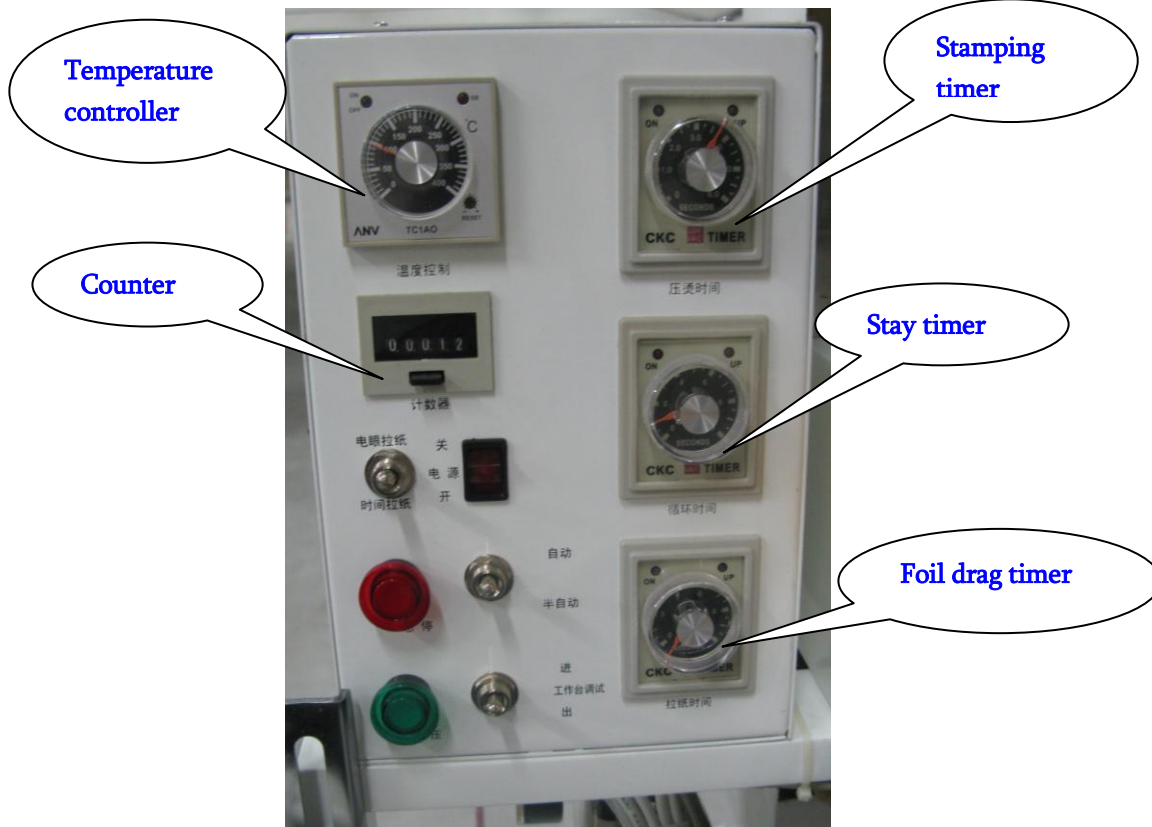
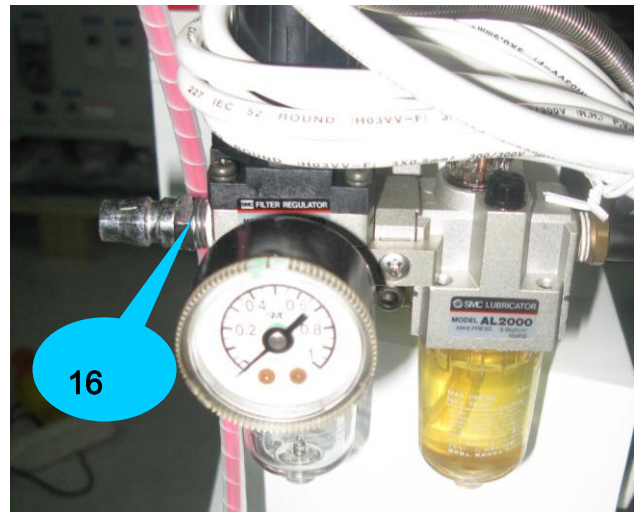
Connecting compress air to (16) , pull air switching and adjust air press at 6 kg f/c m². When you find water in optical cup of air switching, please drainage by opening switching.

(二) 把脚踏开关插到烫金机电箱背后的脚踏开关插座上.

Insert foot switching to the back of stamping body.

(三) 插上电源.

Insert power supply



(四) 如需校机, 请拨下开关 (23) AUTO SEMI 至 SEMI-AUTO 半自动位置.

Testing machine need set up machine to half-automatic position (23)

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第二章 上电版

Install electricity plate

(一) 烫印圆型印件时, 由于印件在操作过程中转动, 通常使用耐热矽胶板或矽胶模作电版式进行烫印.

Suggest using silicon rubber plate or model plate when you need stamping cylinder products.

(二) 上电版方法. **Usage of installing electricity plate**

1. 活动工作台应在中间位置, 工作台面须清洁及无杂物.

Keep shuttle working table at middle position and keep working table cleaning.

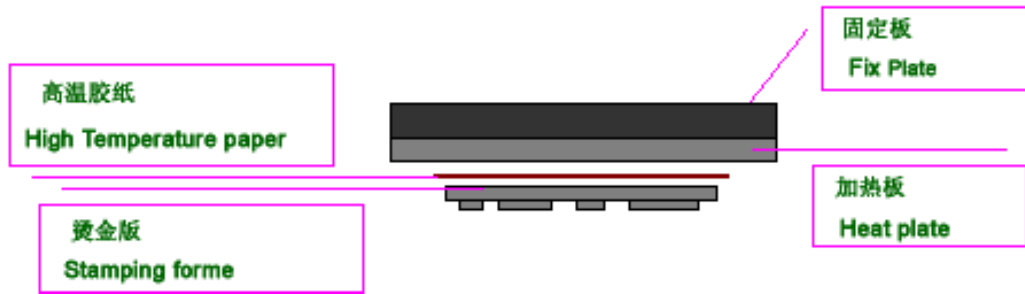
- a. 把钮子开关(21)拨至向下 (TABLE OUT) 位置, 活动工作台 (1) 会移动至最左位置停留不动.

Press switching (21) down to (TABLE OUT), shuttle working table(1) will move to left end and keep stillness

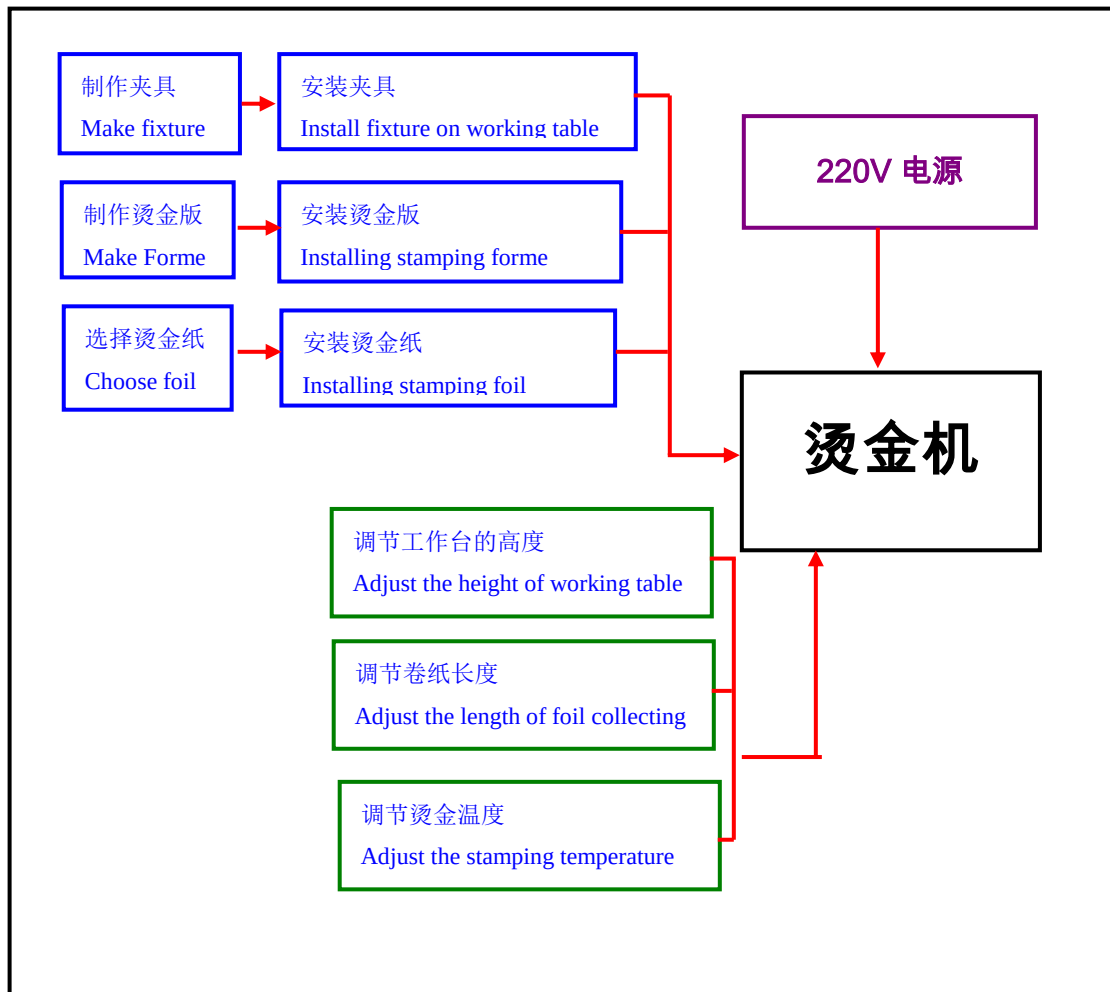
- b. 测量活动工作台左侧栏杆与固定工作台之间空隙的宽度, 预备一件约该宽度二分之一长的木方.

Measure the interstitial breadth between left rod and working table. Take one wood with one-second width of the breadth width.

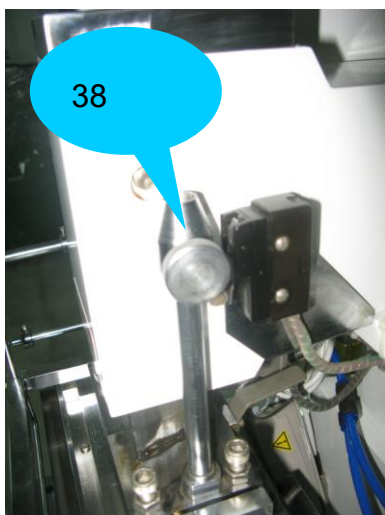
- c. 把钮子开关(21)拨至向上 (TABLE IN) 位置, 在活动工作台 (1) 回程时, 用该木方堵塞在活动工作台左侧栏杆与固定工作台 (2) 之间空隙, 使活动工作台 (1) 固定在固定工作台中间位置, 即对正电版砧 (48) 中部.



Press switching(21) up to TABLE IN position, when shuttle working table go back, use the wood jam at the interstitial position. Keep shuttle working table at the middle of working table and against the center of stamping plate(48).



2. 安装烫金版 Install stamping plate



- a. 拆去原有夹具，把凸轮（38）及护栏（9）推到顶端，以便烫金版能够下压至与活动工作台面紧贴之位置。

Remove fixture on the working table, push the cam(38) and safe rod(9) to top so that stamping plate press down to contact working table surface.

- b. 调节手轮（33）和螺母（34），使手按开关（22）—PRESS TEST，电版能与活动工作台面紧贴，手轮（33）用于大幅度的调整，（34）用于微量调节。

Adjust hand wheel (33) and screw(34) so that when you press switching(22)-PRESS TEST, the stamping plate is down to contact surface of shuttle working table. Wheel is for large range adjustment and screw(34) is for small range adjustment.

- c. 把自动恒温器温度调整到 100 度，约 15 分钟后，右上角红灯熄灭时可进行粘贴烫金版



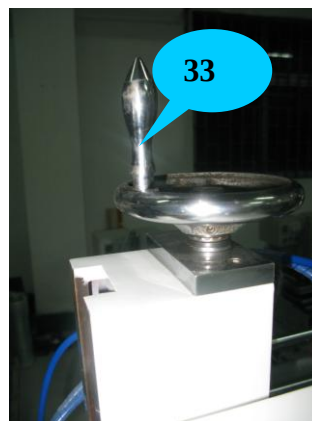
Set the temperature of TEM CONTROLLER at 100 degree , after 15 minutes, please adhere stamping plate when the lamp at the corner of TEM controller.

d. 在烫金版背面均匀涂上高温胶水或贴上高温胶纸,朝上放在承烫产品上,手按开关(22)使烫版下压紧紧接触烫金版约 20 秒, 放开按钮开关(22), 烫金版会粘贴到烫版上面。

Coating high temperature glue or high temperature tape on stamping plate put it on products you will stamp. Press switching (22) and keep stamping head contact it for 20 seconds, then unlash (22), stamping plate will be adhered on stamping head.

e. 检查烫版和工作台台面是否均匀接触, 否则调整螺丝(18)以达平衡。

Check stamping head if contact uniformity with working table surface, or please adjust screw (18).



第三章 印件位置及工作程序的调校

Adjustment of product position and stamping procedure

(一) 调校起印点位置 adjust beginning stamping point

由于烫印圆型印件时, 印件会被夹具带引转动, 所以印件放置位置须在电版砧压及印件时, 电版的最右处与起印点紧贴为全. **When stamping cylinder products, it will move round with the jig, please put the product one place where the right of electric plate attach closely the point begin printing.**

1. 高度调校 the height of stamping head adjustment

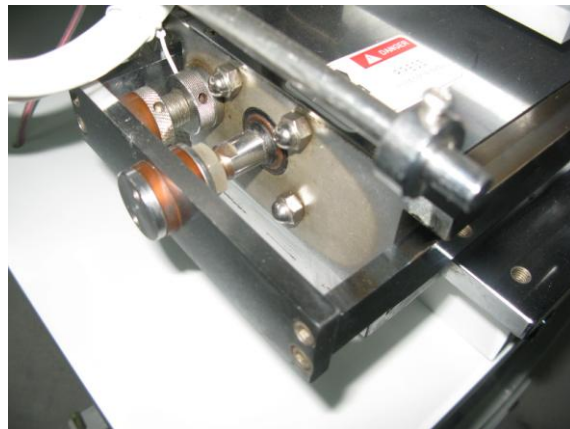
机头高度须调至手按试压按钮时, 电版砧以适当压力压及印件为合. 请友阅第一章中有关调校机头高度的说明作出调校.

Adjust the stamping head height so that it can contact products by a fitness press.

2. 工作台调校 working table adjustment

工作台座两边各有两枚锁紧螺母, 松开该四枚螺母, 拧动调位螺母, 可调校工作台前后位置, 同时亦可移动工作台作轻微角度调校. 调校完毕须上紧四枚锁紧螺丝.

There are four pcs locating screws at the end of machine (B11), untie them, turn adjustment screw

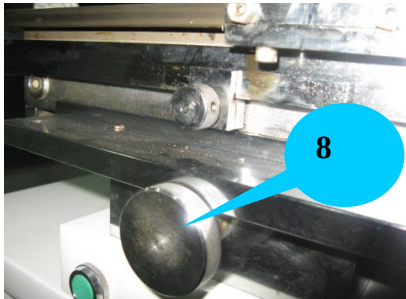


(B12) to adjust the position of working table. After adjustment, locked them.

3. 前后调校 **Back and front adjustment**

调校调整手轮(8)可使活动工作前或后移动, 令印件旋转位置与电版上图案位置吻合.

Adjust wheel(8) to move shuttle working table so that work piece move round and anatomize with the design on stamping plate.



(三) 工作程序的调校 **procedure adjustment**

1. 印程调校 **stamping distance adjustment**

烫印圆型印件一般都采用滚压操作, 因而需要作印程调校.

You must adjust stamping distance when stamping cylinder products.

- 把压烫时间制(32)向右拧开.

Turn

stamping time controller(32) to right end.

- 调校印程限流阀(3)以设定印程速度, 即压烫转动印件的时间. 顺时针方向调校, 延长压烫时间; 逆时针方向调校, 加快烫印时间表. 压烫时间以压件质地及印出效果而定. 印出图案及文字整体着色过深至边界模糊, 要加快烫压时间; 印纹残缺, 要延长压烫时间. 如果上紧印程限流阀(3), 活动工作台便不会起动.

Adjust the valve (3 to set stamping speed, clockwise for prolong stamping time; counter-counter for expedite stamping time. Close (3) will shut shuttle working table.

- 把调整螺母(7)上于适当位置以设定印程长短. 上紧该螺母于较左位置, 减少印程; 上紧于较右位置, 增加印程



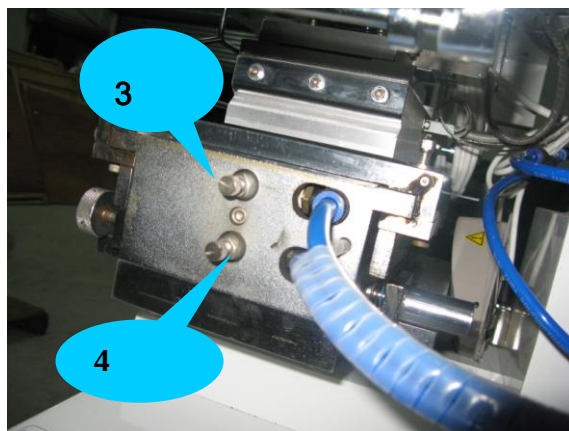
Set stamping distance by fasten the screw(7) at a position, more near to left and more short stamping distance; more near to right and more far stamping distance.

2. 回程调节 **Backhaul adjustment**

调校回程限流阀(4)可设定回程时间快慢. 顺时针调校延长回程时间, 逆时针调校加快回程时间. 如果上紧, 活动工作台在完成烫印后, 将停留不动, 不会自动返回起点. 出厂时会把回程限流阀(4)调至回程时间较快位置, 不必经常调校.

Adjust the valve(4) to set the speed of shuttle working table

backhaul. please do not adjust it commonly because our engineer adjust ok.



第四章 安装烫金纸或热转印纸(请参阅附图三)

Install stamping foil

(一)把烫金纸或热转印纸放入左面上纸架

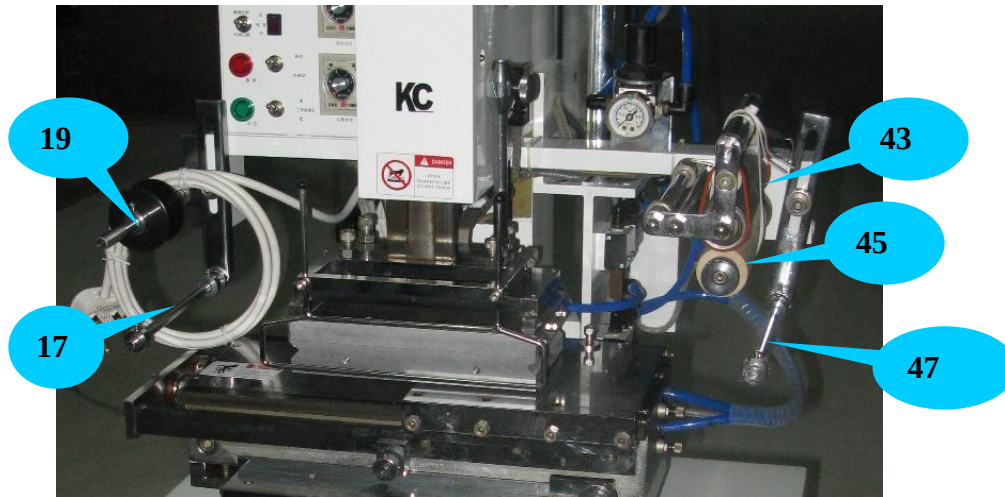


Install stamping foil to left frame.

取出烫金纸档圈(19), 套入烫金纸或热转印纸, 再装回档圈(19), 上紧档圈螺丝, 烫金纸便已装好. 注意烫金纸安装位置必须与电版位置配合.

Take out loop (19), install stamping foil and return loop(19). Please notify stamping for must cooperate electric plate.

(二) 拉纸上架 pull the stamping foil on the roller.



先绕过定位杆(17), 跨过右定位杆(47), 通过压纸棍(43)旁限位杆, 左压纸棍与橡胶卷纸轴(45)之间穿过, 将烫金纸卷在集纸轴(41)上, 再用弹片卡住.

First writhe through locating rod(17), cross pass right locating rod(47), pressing roller, rubber axis(45) and rolling .

注意:

3. 烫金纸着色面必须向下.

Surface colored of stamping foil must against down

4. 烫金纸安装位置以远离电版砧而又不影响动作作为最佳.

Stamping height keep further from electric plate.

5. 由于是滚烫, 烫金纸压及印件时间有先后之分, 在不影响活动工作台运作的情况下, 左定位杆要尽量装得比右定位杆低, 目的是使压烫时后压及印件的烫金纸远离电版砧, 以免电版砧热量烘至变质而影响烫印效果.

Keep left locating rod a lower position than right locating rod so that heat from electric plate can not impact stamping quality.

6. 在印刷过程中烫金纸有可能走位而偏身卷纸轴两端. 如出现此毛病, 请查看下列各点:

When stamping foil appears deflection, please observe below items:

- A. 卷纸轴、右写位杆、左定位杆及装烫金纸档支架是否全部互相平行?

Check if parallelism of all axis (45) (17)

- B. 左右定位杆之挂臂(47)是否紧固?

Check if lock the left and right rod (47) installed stamping foil.

- C. 左右定位杆(17) (47)是否紧固?



Check if fasten left and right rod ? (17) (47)

(三) 调节拉纸长度 **adjust foil step length**

- 转换制 (26) (SENSOT/TIMER (FOIL FEED)) 是用以设定用时间控制或电眼控制拉纸程式. 电眼控制接纸程式通常是用于压烫热转印纸之特制图案时用. 在一般情况下, 须把转换制拨下至时间控制 (TIMER) 位置, 才能准确调校烫金纸拉纸时间.

FOIL FEED (26) (SENSOR/TIMER) use to set the foil feed way: time controlling or sensor controlling.

Sensor controlling is for heat transfer film. Commonly, please press down to TIMER position

- 时间控制器 (30) (FOIL FEED TIMRR) 是用以控制烫金后烫金纸走纸长度. 顺时针方向旋转旋钮, 送纸长度由短至长, 请按烫印需要调校走纸长短. 把时间控制器调至 0, 则不会自动走纸.

Time controller(30) control stamping foil step length. Clockwise lengthen foil feed length foil, please adjust it according to the diameter of products . when timer controller is at zero, foil feed stop.

第五章 程序调整

Stamping Process adjustment

- 全自动的设定 **automatics operating set up**

A. 将设自动制 (23) 拨上到自动位置, 设定烫金机作全自动操作.

Set up (23) to automatic operating position AUTO.

- 压力调校 **pressure adjustment**

印出印纹过深, 表示压力过大; 印纹过浅至不完整, 表示压力过小. 调校调节螺母 (34) 以修正. 顺时针方向调校减少压力; 逆时针方向调校增加压力. 调校前要松开及调节后要上紧上方之锁紧螺母 (35).

Too deep of impression display too weight pressure; incompletely impression display too light pressure. Please adjust screw(34) to ameliorate.

- 温度调校 **temperature adjustment**

A. 由于通常用矽胶板或矽胶模压烫圆型印件, 所需温度较用金属电版高, 一般在 200℃ 以上, 用温度控制器 (A4) 设定烫印温度后, 等待试预热, 当左上角灯号 (NO) 第一次熄灭, 即可进行烫印.



The stamping temperature of silicon rubber plate higher than metal plate. Set it at 200℃, wait the lamp turn off, start stamping.

B. 印件质不同, 所需需不同, 请根据印出效果作调校. 温度过高印痕着色会越界至模糊; 温度不足着色不匀. 温度由低调高, 则待灯号熄灭便可进行烫印. 如果温度由高调低, 则需待灯号重亮后方可烫印. 降温比升温需要较长时间, 请耐心等待.

Different product substrates need different temperature. Please according to stamping result adjust the temperature .

C. 烫金纸不同, 所需温度不同请参阅供应商意见及实践中修正.

Different stamping foils need different temperature.



烫金机要完成烫印任务：需要根据相应的产品进行烫金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上；
- 根据客户提供的烫金文件制作烫金铜锌版或者硅胶版并用高温胶纸或者高温胶水粘贴到上烫板上；
- 选择适合产品材质的烫金纸并安装在烫金机上；

Finishing Hot foil stamping task need all items below to be done:

- Making appropriate fixture and install it on the working table of hot stamping machine
- Base on customer stamping document , Making copper-ZN metal plate or silicon rubber plate or silicon plain stamping plate and install it onto the upper heat plate of stamping machine;
- Choose correct stamping foil and install ;



高温胶纸

High temperature tape



烫金纸

Stamping foil



硅胶版

Silicon rubber plate



烫金夹具

Stamping fixture model

