



PS-6080PV 平面丝印机

操作说明书

**Operation
instruction**



KC Printing Machine (group) Limited 19-1

Website: <http://www.dg-padprinter.com>

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■ 机器简介

■ Machine Introduction

- 1、 这是一款高精密高效率的平面丝印机，左右上下全电动控制，印刷平衡震动小，精度高，运行平稳，多色套印准确；采用双柱式结构，双变频系统，运行高速平稳。印刷头左右动作采用进口直线滑轨驱动。双导柱左右网夹臂，同时安装版距调节装置，印刷精度： $<0.05\text{MM}$ ，每小时运行速度可达到 1200 次，适用于大幅面商标印刷，如高精度线路板，PT 板，纸张，亚克力板及高精度四色网点等产品 LOGO 印刷。
 - 2、 机器控制采用名牌可编程控制器
 - 3、 立式结构，网板电动式垂直式升降，印刷头左右动作采用进口直线滑轨驱动。
 - 4、 印刷和网板升降采用独立驱动源。
 - 5、 变频系统控制印刷刀架升降，光电眼控制行程，独立调校。
 - 6、 印刷动作设计多种印刷循环，用户可视印刷工艺自由选择。
 - 7、 设用手动/半自动/全自动三种模式，印刷间接时间数字控制。
 - 8、 精磨高强硬度工作台，均布吸气孔，强力真空吸附，保证多色套色准确。
 - 9、 独立设计的机头升降装置，刮墨刀/回油刀、网版装卸和网版清洗方便。
 - 10、 双导柱左右网夹臂，同时安装版距调节装置，调整方便。
 - 11、 网版防压红外线检查自动报警停机装置，更人性化，安全系数更高。
- Which is a high-precision high-efficiency flat screen printing machine, up -down of screen plate , Right-left of Rubber squeegee driven by all-electric control, printing balance vibration, high precision, stable, multi-color overlay accuracy; dual-column structure, dual invert system, high-speed smooth running . Around the print head movement adopts imported linear slide driven. Dual guide column clamp arm around network, install version at the same time regulating device, printing precision: $<0.05\text{MM}$, hourly running speed can reach 1200 times for large-format label printing, such as high-precision circuit boards, PET board, paper, acrylic four-color plates and precision products such as LOGO printing outlets.
 - The machine is controlled by Omron programmable controller ;
 - Vertical structure, vertical stencil electric lift, printing head around action adopts imported linear slide driver;
 - Printing and stencil movements using independent driving source ;
 - The invert system control the printing carriage lift, photoelectric eye control stroke, independent adjustment ;
 - The printing action design a variety of printing cycle, the printing process visible to the user freedom of choice;
 - Set with manual / semi-automatic / automatic three modes, printing and indirect time digital control.
 - High strength and hardness of the grinding table, uniform suction hole, powerful vacuum suction, ensuring accurate color multicolor;
 - Individually designed nose lifting device, doctor blade / knife back to the oil, screen handling and screen for easy



cleaning;

- Double guide column clamp arm around network, install version at the same time regulating device, easy to adjust;
- Screen anti-pressure hand infrared inspection automatic alarm shutdown device, more humane, higher safety factor

■ 技术参数

■ Technology Parameters

Model /型号	PS-6080PV	Table area/台板面积	700×900MM
Power supply(V)/电压	220V 1 Phase 50HZ	Inspiration area/吸气面积	600×800MM
Max printing area/印刷面积	600×800MM	Printing speed/印刷速度	1000PCS/HOUR
Up-down stroke/上下行程	300MM	Right-left stroke/左右行程	800mm
Max printing height/产品高度	70MM	Total weight/净重	382KG
Total wattage/功率	2.5KW	Compress air/气压	0.5-0.7MPA
Max frame size/网框尺寸	750*1350mm	Precision/定位精度	0.05mm.

1、 动作模式选择：全自动|半自动|手动.

Action mode: Full-auto/Semi-auto/Manual

2、 启动方式：面板|脚踏开关

Starting mode: Panel/foot-switch

3、 刮刀压力控制：调压阀恒压

Rubber squeegee pressure controlling: adjustment valve

4、 上下驱动方式：电动，电机配蜗轮减速箱

Up-down driven mode: Motor-driven, Motor drive Worm Reduction gearbox

5、 左右驱动方式：电动，齿轮减速马达配同步带

Left-right driven mode: Motor-driven, Reduction motor and Synchronous belt

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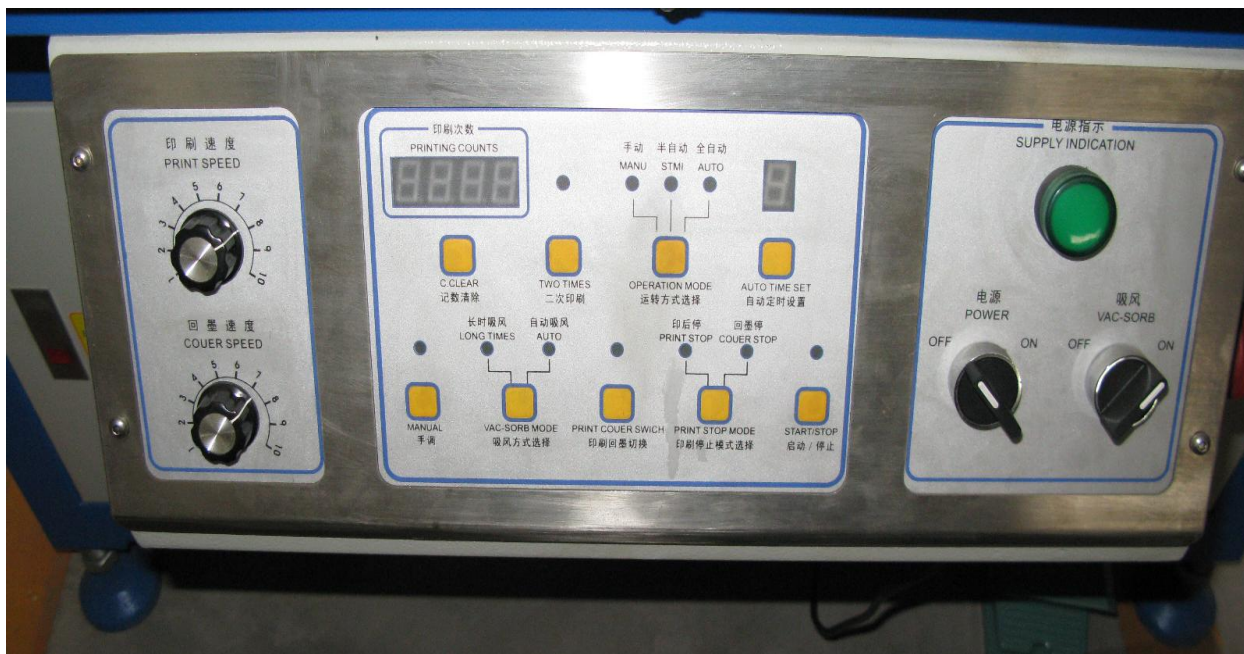
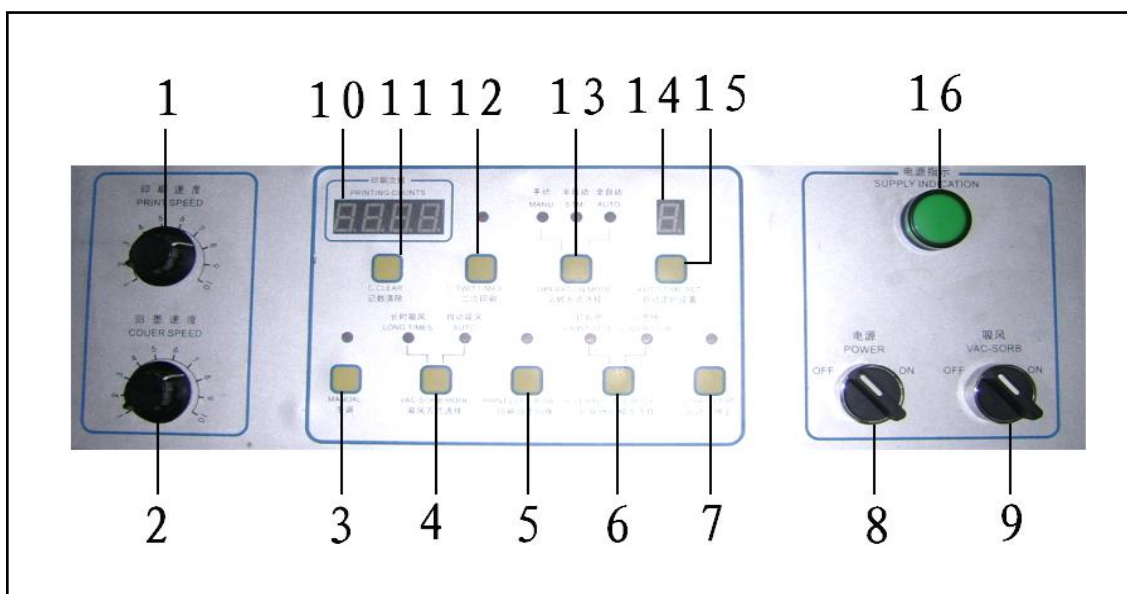
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■ 机器操作

■ Machine Operation

- Control panel and operating instructions
- 控制面板



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Panel introduction

- 1、 **Printing speed**: One to ten means it from small to largest one of printing speed
- 2、 **Cover speed**: One to ten that's means the speed from small to the largest one of ink covering speed.。
- 3、 **Manual control**: The switch you don't control to use, the machine won't

Continue work (using on vertical screen printing machine)

4. **VAC-Sorb Mode**: you hit the left light means long time absorbing, or hit the right one means automatic absorbing.

5. **Print Counter Switch**:

When you hit the witch, the counter will be up , and when you hit the switch again, the counter will be down.

6. **Print stop model**: you can chose the counter stop in the front or behind.

7. **Start/Stop switch**:

You can chose the print counter stop in the front or behind.

8. **Power switch**: OFF /ON

9. **VAC-Sorb**: off/on

10. **Print accounts**: you will see the printing times when the machine began to work

11. **Counter Clear**:

When you hit the switch, the number on it will become zero.

12. **Two Time Print**:

When you hit the second print witch it means the second print/

13. **Operating mode**: when the manual light turn on, each one is only means single step, when the semiautomatic light turn on, and means the work ways is semiautomatic and so on.

14. **Stop Time**: the machine print times

15. **Time Set**:

When you hit the switch, it means the stop time has changed

16. **Power introduction**:

The light turn on it means the work has turn on the power.

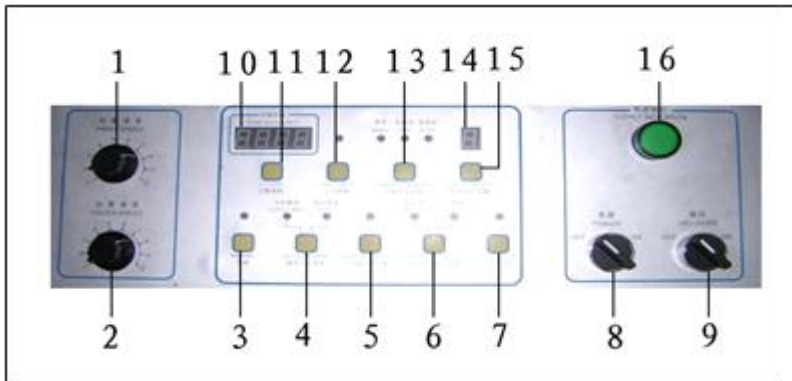
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● 控制面板及操作说明



- 1、印刷速度旋钮：1 至 10 速度为从小到大。
- 2、回墨速度旋钮：1 至 10 速度为从小到大。
- 3、手调按钮：该按钮在此机上不应用（立式机型上应用）。
- 4、吸风方式选择按钮：按下按钮左灯亮为长吸风，按下按钮右灯亮为自动吸风。



- 5、印刷回墨切换按钮：按一下按钮为印刷刮刀下，回墨刀上；再按一下按钮印刷刮刀上，回墨刀下。
- 6、印刷停止模式选择按钮：可选择印刷回墨刀停前或停后。
- 7、启动停止按钮：该按钮可选择启动或停止。
- 8、电源开关：OFF 为关、ON 为开。
- 9、风机开关：OFF 为关、ON 为开。



- 10、印刷次数显示：半自动或全自动印刷时显示当前印刷的次数。
- 11、记数清除按钮：按下记数清除按钮，印刷次数归 0。
- 12、二次印刷按钮：按下二次印刷按钮灯亮为二次印刷
- 13、运转方式选择按钮：当手动灯亮时，各运转方式为单步；当半自动或全自动灯亮时，动转方式显示为半自动或全自动印刷。
- 14、印刷停顿时间显示：自动印刷间隔时间。
- 15、自动定时设置按钮：按下设置按钮停顿时间改变。
- 16、电源指示：灯亮为已开启电源。

■ 丝印机的安装、测试、使用

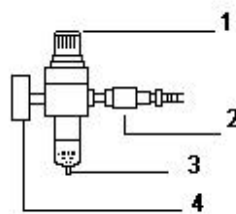
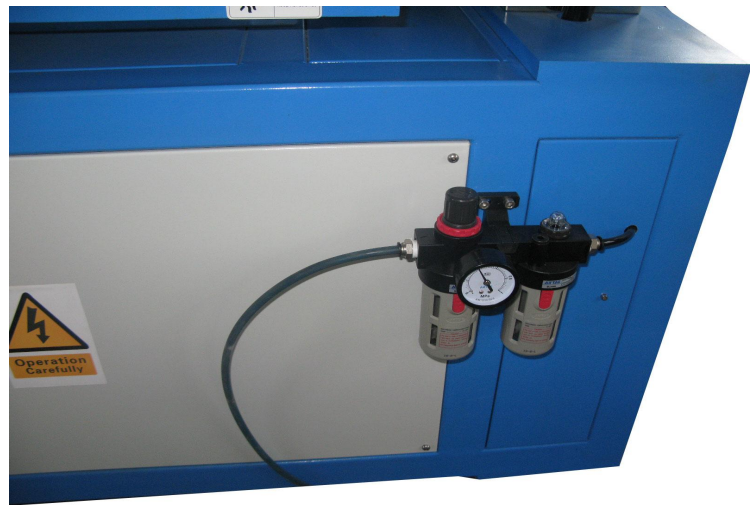
■ Install test usage

✧ 安装环境

✧ Installing environment

本机适宜于安装在环境清洁，空气流动量不大，无粉尘及温度保持在 25 度左右的厂房，为了保证本机的精密度，在运输过程中不可受大力撞击。

The machine suitable for installation in a clean environment, the air flow is not, dust, and temperature maintained at 25 degrees around the plant, in order to ensure the precision of the machine, during transport by the strong



1 Pressure regulating valve 压力调节阀

2 Manual valve 手动滑阀

3 Drainage needle 水隔开关

4 Pressure meter 压力表

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impact not.

✧ 调节机身平衡：

✧ **Adjust the level of Machine**

在机座的四个脚掌板上分布有平衡调节螺丝，调节时先将配有的脚掌圆饼对准螺丝放在地上，再将螺丝上的螺母旋松，然后将螺丝顺时针旋转，使螺丝压紧脚掌圆饼，再逐一调节四颗螺丝的高度，使机身平衡后，锁紧上面的螺母，防止松动。

Four feet at the base of the plate for a balanced distribution of the adjustment screw, adjust the feet when the first round cake aligned with some screws on the ground, and then unscrew the nut on the screw, and then screw clockwise, so that the screw clamping foot round cake, and then adjust the four screws each height, so that the body equilibrium, locking top nut to prevent loosening.

✧ 接电

✧ **Connect the electric source;**

✧ 我们制造的机器使用三相 380V 电源，有些国家使用三相 220V 的电源，我们会按照客户的要求进行免费改装。所以，你必须了解您的电压环境，或者了解您的客户的电压环境之后再决定。电源连接后，应检查电源指示灯是否处于接通状态。

Our machine use 3 phase 380 V power supply. Some countries such as, USA, Canada, Mexico use 3 phase 220V, we will change the voltage when you make a demand on it. First confirm your locating and electron condition. Check whether the power supply light is in the status of connecting.

✧ 接气源 -

✧ **Connect the compressed air.**

精密丝印机的刮墨刀和回墨刀仍然需要气源，机器需要连接空气压缩机，您的工作场地一定要配备一台空气压缩机，或者具备压缩空气的能力，KC 品牌的丝印机绝大多数都需要使用空气压缩机，我们的销售代表会向您提供一些必要的建议。

请保证机器的正常使用气源的压力是 5-7bar。机器侧边的组合气阀可以调整，旋转上面的螺旋可以增大和减小气压，请从压力表的读数判断适合的压力。

Your printing plant must be have one set compressor to provide compress air to machine, Please inquire to our sales Members, we will give you some advice on how to choose it. Please Check the display of the pressure gauge, adjust the pressure to 5~7 Bar (the standard pressure).

注意：机器接入电源和气源之前，所有机器部件应该安装正确。

Reminding: Please Confirm all machine part before connecting with power and air

✧ 调试气压表：

✧ **Adjust the pressure meter**

本机工作时，进气压力表通常调整至 5-7BAR 为宜，如发现指数偏高时，可先将调压阀推上，然后逆时针方向旋转至标准压力，反之，反向调整，待调整至所需压力后，再把调压制按下，

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锁定气压在标准范围内。为了使机器正常运作，防止外来水汽渗入本机安装的各种精密气动组件之中，须经常把过滤器胶杯内的水或污物排出，将过滤器的排水顶针向上按多次即可排出污水。同时须不定期向油雾杯加入润滑油，以保持各气动零件运作的顺畅性（松开油雾杯时须先除开气源）。

The Machine is operating, the intake pressure gauge is usually adjusted to 5-7BAR appropriate, such as found in index is high, the regulator can be first pushed, then counterclockwise to the standard pressure, on the contrary, the reverse adjustment, to be after adjusting to the desired pressure, and then transfer to suppress press, locking pressure within the standard range. In order to make the machine work properly to prevent external moisture seeps into the local installation into a variety of precision pneumatic components shall always be within the filter plastic cup of water or sewage disposal, drainage of the filter can be discharged repeatedly pressed upward thimble sewage. Also be required from time to time to add oil mist cup to maintain the smooth operation of the pneumatic components of (cup must first release the mist apart from gas source).

✧ 各机械部件的运作测试：

✧ Action test

各机械部分的运作是否正常，对产品的印刷品质和机器的寿命都有影响，因此，在印刷工作之前，测试各部件的运作是一件重要事项。

<1>插上电源，并开启电源开关后，机器操作面板亮灯

<2>检查网臂左右移动是否顺畅，有无异常响声发出。

<3>检查工作台升降是否正常，高低位置是否需要调整。

<4>开启自动印刷状态，看网臂滑动和工作台升降的速度节奏是否配合，运行过程中是否有异常响声发出。

The proper operation of the mechanical part, the printing quality and the product has an impact on the life of the machine, therefore, before the print job; the test operation of the components is an important matter.

<1> plugged in and turned on the power switch, the machine Panel interface is lights

<2> Check the screen frame moves from left to right smoothly, with or without abnormal noise issue.



<3> Check screen frame lift is normal, the need to adjust the level of the position.

<4> Turn automatic printing status, see screen frame sliding and lifting table should match the speed of the rhythm, running for unusual noise issue.

■ 丝印注意事项

■ NOTICE

- 1、工作车间应尽量保持无尘状态，因为粉尘会严重影响丝印质量，
- 2、做好被印件在平面台的固定装置，使被印件既可以随意放入和取出，又达到精确定位的目的，故此要有一套安放被印件的合适夹具，由于被印件的外形各不相同，故夹具要随需要而确定及制造。如果机器用于印刷纸张和薄膜，请在工作台的靠近立柱的两边粘贴定位片确保定位。
- 3、当发生塞网时，应用稀释剂或洗网水来清洗网板，请勿用天拿水去清洗。
- 4、注意所采用的胶刮，外型是否符合被印件的特性。胶刮有平刮(方角)和尖刮二种，当被印件为平面或印刷较平较硬状态时，以采用平刮(方角)胶刮为宜，印出的效果较佳；当被印件为有弧度或凸凹面状态时，以采用尖刮胶刮为宜，印出的效果较佳。
- 5、根据印刷图案的要求，选择密度合适的网纱。
- 6、将所需用的油墨调和至适合印刷之用，如油墨过粘，一来缺乏流动性，二来容易塞网，引致印刷困难，如果油墨过稀，会导致印出的图案或线条颜色不够深，线条容易起毛等缺陷，所以丝印油墨的调较切不可轻视。而油墨种类繁多，一定要用与被印件的特性相符合的油墨，才可产生美好的印刷效果。
- 7、印刷时存放在网框内的油墨量不可过多或过少，否则容易发生渗网、塞网，印刷图案浓淡不均等缺陷。

1. Workshops should be kept clean state, because the dust will seriously affect the printing quality.
- 2, the good items to be printed on the flat platform of the fixing means, the items to be printed both loading and unloading above, but also to achieve the purpose of precise positioning, therefore have a place to be printed to a suitable clamp member, the member to be printed shape each are not the same, so with the need to determine the fixture and manufacturing. If the machine is used for printing paper and film, on both sides of the table near the uprights paste positioning pieces to ensure positioning.

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3, when screen plate I blocked , the application of thinner or wash solvent to clean the stencil, do not use Tina solvent to clean.

4, note the use of the squeegee, the appearance are in accordance with the characteristics of printed pieces. There are flat squeegee scraping (square corners) and sharp scraping two kinds, when printed

pieces for the plane or printed harder than the flat state, to the use of flat scraper (square corners) squeegee appropriate, printed was better; when the printed pieces of the arc or concave surface state, to adopt appropriate tip scraping squeegee, printed better results.

5, according to the printed pattern requirements, select the appropriate mesh density.

6, will be required to reconcile with ink suitable for printing purposes, such as ink too sticky, one to the lack of liquidity, the second to easily plug network, causing difficulty printing, if the ink too thin, it will lead to the printed pattern or line color not deep enough, the line is easy to fluff and other defects, so adjust screen inks must not be taken lightly. The ink variety, be sure to use the characteristics of printed pieces and being consistent ink can produce better print results.

7, printing ink stored in the screen plate volume is not too much or too little, or prone to infiltration screen plate, printing pattern block and other defects.



Screen Plate

■ 保养与维护

■ Maintain

- 1、每周必须给网臂滑行导轨及升降座加注润滑脂一次，使机器导向部件保持润滑。
- 2、压缩空气的水分要过滤干净，以免水分进入气缸而降低气缸和电磁阀的使用寿命。
- 3、注意每班后，排掉水隔中的积水，
- 4、保持机身的洁净，经常清洗粘附在表面的油墨。
- 5、每次下班时，必须关闭机器电源及清洗掉网板、胶刮上的油墨，防止油墨凝固后造成塞网、坏网等。

1. One week must give screen frame lift seat slide rails and greasing once, the machine-oriented parts remain

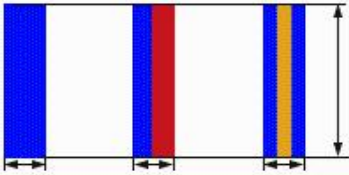
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丝印机 胶刮的截面形状



Plain screen printing;
Four process printing;
UV Screen Printing
UV Spot coating
Paper screen printing



Container screen printing;
CD Screen printing;
Glass screen printing;
Fabric screen printing;
Round-object screen printing
Full-automatically screen printing



Metal screen printing;
Ceramic screen Printing;
Wooden screen Printing;
Thick film coating;
Billboard screen printing

lubricated.

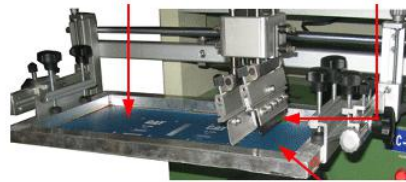
2, The air cleaner to filter the water, so water into the cylinder and reduce the service life of the cylinder and the solenoid valve.

3, note that after working, drain the water compartment in the gas valve
4, to keep the body clean, regular cleaning of the ink adhered to the surface.
5, Each work, you must turn off the machine power and cleansed stencil, rubber squeegee the ink to prevent ink solidified on the screen plate caused by block

How to choose Screen printing ink

Screen printing ink curing type can be divided into four categories:

Solvent-based inks,
UV curable inks,
Plastisol ink,
Two-component ink.



Solvent-based inks to rely on the solvent in the ink component in the volatile completion of the drying, can be through a variety of ways to accelerate the drying speed; UV ink by ultraviolet light irradiation completion of the drying, the drying rate depends on the type of ink, the power of the UV curing device; thermosetting the ink is completed by heating the ink curing; bicomponent inks rely on the crosslinking of the resin and curing machine completion of the reaction

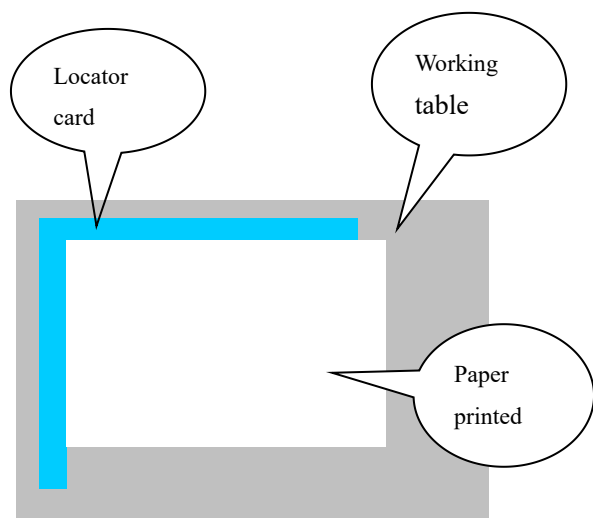
操作程序

Operation process

➤ Inst
all
scr
een
fra
me.

You

must make one set screen frame by yourself, at the first order, we





can suggest you sending printing document by email and make one pc screen plate for you, It is expert technology to make screen plate, some equipment and materials , one operating worker with excellent experiences. Please keep the screen frame surface parallel with working table, or please adjust the screw 29 of picture 2.

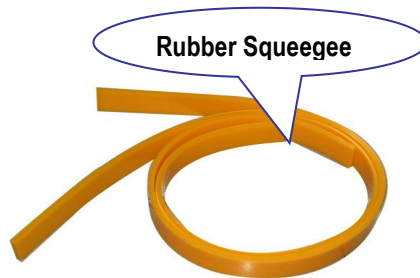
在操作丝印机之前，您要根据印刷文件来制作一块网版，网版的尺寸要和您使用的丝印机匹配。 通常情况，在您第一次采购 KC 品牌丝印机时 我们会建议您发送印刷文件到我公司，我们将免费为您制作一块网版。

- **Install fixture.** T model working table need to make one fixture to fix it one the working table. When printing paper, only adhere two pcs locator thickness about 75um card on the working table.

吸气工作台的丝印机主要用来印刷纸张，薄膜等软性产品，只要在工作台的边缘粘贴薄片进行横向和纵向两个方向上的定位即可，如果印刷其他一些产品，必须制作专门的夹具安装在工作台上面。图示的夹具可以帮你了解夹具的结构和制作方法。

- **Install rubber squeegee,** there are different size rubber squeegee, we suggest you use the

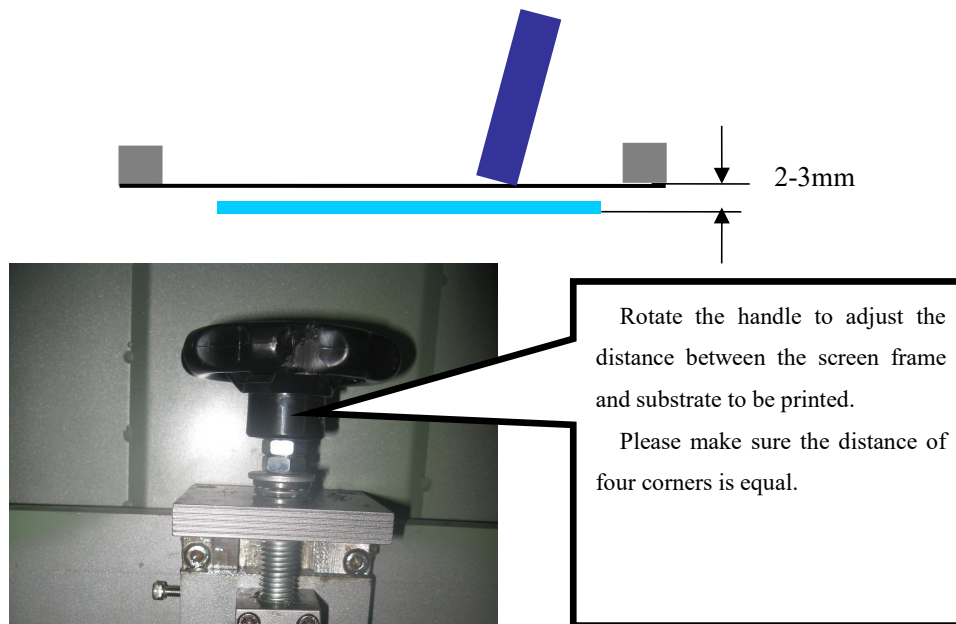
size 45*7mm or the length only with knife Adjust Loose the screw combine nip, first at the beginning of setscrew at the rubber squeegee to



cover all printing design, then fasten the screw of left stroke screw.

50*9mm . Please cut it to longer than printing design the stroke of squeegee. and put down of squeegee push the rubber squeegee printing design, fasten the right side, then push the the other end till it can

丝印机最常使用的是 45*7mm, 和 50*9mm 两种规格的方型胶刮，按照印刷图文的宽度将胶刮裁切称适合的宽度，就可以将胶刮安装在胶刮夹内。安装胶刮要保证胶刮的下边和丝网面平行， 并保持一定的角度。胶刮的宽度要略长于图案的宽度。



➤ **Adjust the distance between screen frame and products.**

Turning the handle wheel of machine at the back of machine to drop the screen frame. It is best distance is 2-3mm when the screen frame press down. Adjust the height of rubber squeegee make it contact with the surface of screen silk exactly.

网版下压后，丝网和承印物之间应该保持 2-3mm 的距离，可以调节网框组件的升降手轮进行调节，应保证丝网的四边和丝网保持相同的网距，可以通过螺丝来进行精细调整。胶刮和网版的接触状态也是非常重要的，首先将刮板放下，是胶刮的下边和丝网接触，然后缓慢调节刮板上面的微调螺丝，使刮板能够接触丝网，推动刮板，使胶刮在丝网表面出现刮印动作，观察胶刮和丝网的接触状态，发现有接触不好或者接触太多的现象，应对网框和刮板的微调装置进行调整。

➤ **Adjust the stroke of Rubber squeegee**

After installing screen plate, Push the rubber squeegee to left end, make it can cover the printing image on screen plate, then fix the Limited switch on left end; Then push the rubber squeegee to right end, make it completely cover the printing image, then fix the limited switch on right end.

首先推动刮板至网版图案的右端，使刮板能够覆盖图文的起始部分，然后固定右边的限位螺丝，再推动刮板向左方向移动，使刮板能够覆盖图文的结束部分，然后固定右边的行程限位螺丝



The Limited switch:

There are two limited switch:
adjust the distance between two
limited switch, the stroke of
rubber squeegee is adjustable.

➤ Adding ink and thinner.

Choose ink according to your products. Pour them into screen frame along the direction of rubber squeegee , start the machine and make a one circle run, check the printing quality, Please adjust the pressure till clearly words .



■ 电路图

■ Circuit Diagram

KC Printing Machine (group) Limited 19-15

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