



H-TC200N 气动号码烫金机操作说明书
H-TC200N Numbering pneumatic Hot stamping
machine

Operation instruction



目录

● 概述

- 1、该系列烫金机是在平面烫金的基础上，根据杠杆的原理，将杠杆的力量作用于发热体与工作介面，从而达到工作所需的大压力，该机不但可用作烫金，而且可压痕和小型模切。
- 2、该烫金机应用范围较广，广泛应用于烫金各种名片、橡胶、照像、木材、纸张、皮革、塑料、各种食品及化妆品包装等印件上的电化铝图案。
- 3、为了使用户能够正确地使用本烫金机，请用户在使用前仔细阅读本说明书，若有不明之处或其它问题，可随时与本公司联系。
- 4、H-TC200N 是将烫板更换为烫印头，可以烫印连续变化的号码，成为号码烫金机。

Summarize

1. Flat stamping machine is made on the basic of flat gilding .According to the theory of lever, it can put the strength of lever on the heating unit and workspace., thus supply required high pressure. It can be used for gilding, impress and die-cutting.
2. Widely used for gilding on cards, Rubber, film, wooden, Paper, Leather, Plastic cosmetic industry field. Please carefully read the instruction before use this machine.
3. H-TC200N is replaced by the hot plate stamping head, you can change the number of consecutive stamping, a number of hot stamping machine.

● 烫印温度参考：

纸张：85-120℃

软 PVC：65-80℃

软塑料：75-85℃

硬塑料：100-135℃

人造革、皮革：120-150℃

合成革仿皮：160-180℃

Stamping temperature

Paper: 85-120℃

Soft PVC 65-80℃

Soft plastics 75-85℃

Rigid plastic 100-135℃

Leather 120-150℃

Synthetic leather 160-180℃

● 电气面板图：

Operation panel instruction



- 1、烫印调时：气缸带加热下行，与烫印件、工作平台、吻合之停留时间即烫金时间，调旋钮数值越大，滞留时间越长。
- 2、温控仪：调节加热模板的温度值，反映烫金温度。
- 3、卷箔调时：控制卷箔马达拉电化铝距离，旋钮数值越大，电化铝距离越长。
- 4、电源开关：0 为闭，1 为开。
- 5、卷箔开关：0 为卷箔马达停，1 为卷箔马达运转。

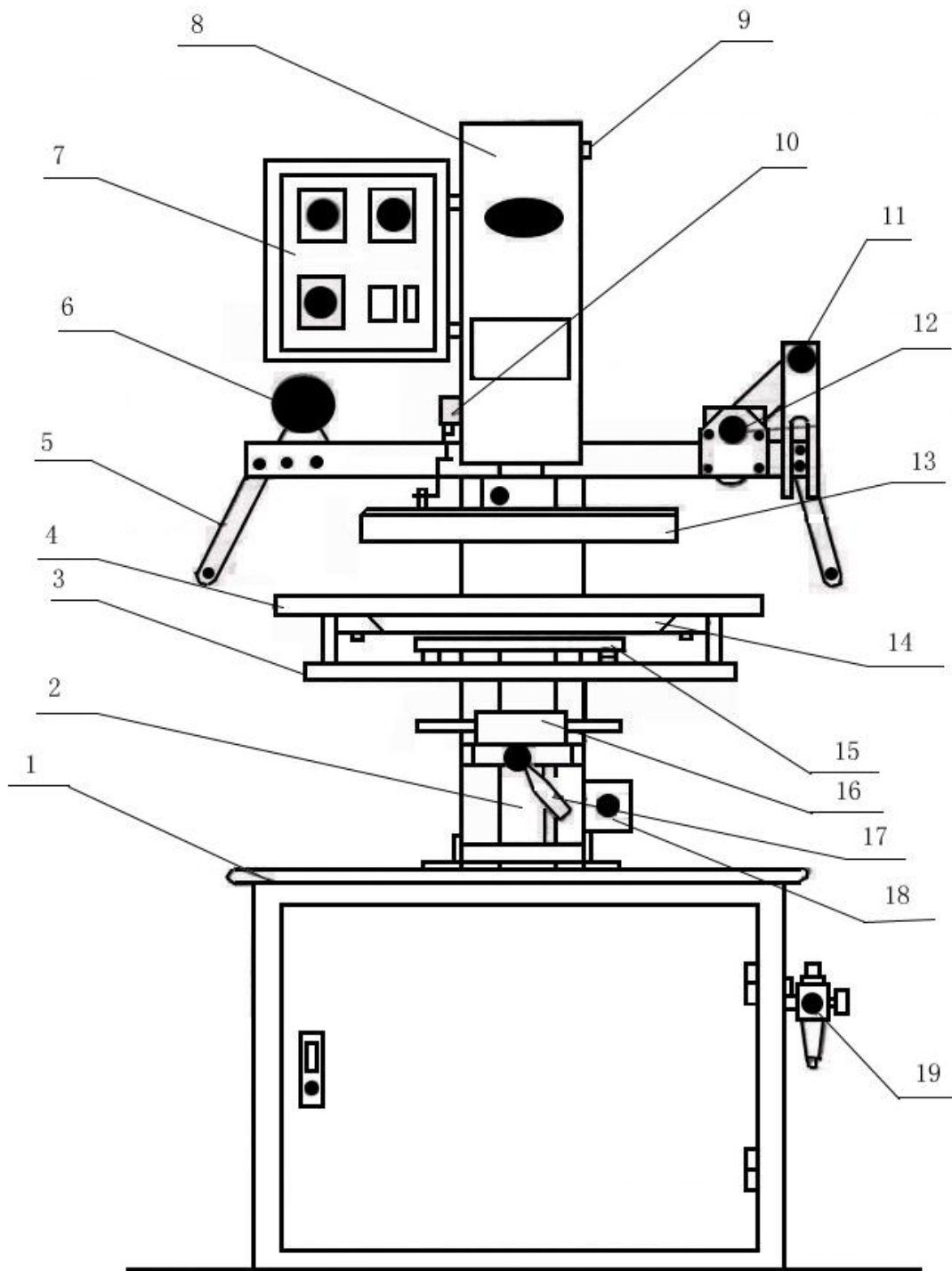
1.Stamping timer: when stamping plate press down and contact with objects, it is used to adjust the time ,the number is more big and the time of stamping is more longer.

2.Temperature controller: adjust the temperature range of heater , reflect gild temperature.

3.Collecting testing: adjust the distance of foil-pulling, the number is big and the distance of foil rolling is more longer.

4.Power indicator:0 means Off,1 means ON

5.Power supply:0 means foil motor shut off,1 means foil motor start.



● 主要结构及性能

Main structure and characteristics

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1	机箱 chassis
2	升降丝杆 Screw rod of lift and drop working table
3	工作台拉杆 Handle of working table
4	工作台 Working table
5	支承 foil support frame
6	放箔轮 wheel of foil installing
7	电气箱 Electric box
8	机体 organism
9	杠杆轴 Lever shaft
10	行程开关 Travel switch
11	收箔轮 wheel of foil collect
12	卷箔手轮 handle-wheel of foil collect
13	电热板 Platen heater
14	工作台滑道 guide of working table
15	工作台平衡块 Balance weight of working table
16	升降螺母 lift and drop screw
17	锁紧螺钉 locating screw
18	启动开关 Start switch
19	二连体 compress air switch
20	电机 Electric motor
21	断路器 Breaker



● 参数的设置与调整

Setting and adjusting parameter of stamping process

1、温度的设置

不同的烫印材料，要求有不同温度与烫印箔应根据材质温度所需设置好温度，将温控仪旋钮上的红色刻度针，对准所需的温度值正常升温时，温控仪上的红色电源灯和绿色输出灯都亮，恒温后，绿色输出灯灭。（设备停止加热自动恒温）。

2、时间的设置：

烫印调时即气缸下行与工作台停留时间，卷箔调时控制卷箔瞳动长度其设置范围为 05 秒、03 秒不等，用户可根据烫印要求，在通电前将旋钮刻度旋至所需时间值（出厂时设置为 5 秒）。

3、工作压力的调整：

本机为杠杆式传动，调整压力时将加热模板 13 与工作台 4 紧密接触，用手旋转工作台下方手柄 16，使丝杆 2 上升，上升到 3-4mm 左右时，产生的压力即为设备的最大压力，用户应根据烫印工件选择合适的参数。

烫印时若压力过小，应旋转手柄使丝杆上升（缩短工作行程），若压力过大，应旋转手柄，使 z 丝杆下降（增加工作行程）。

4、电化铝的安装与调整（见下图）

A．根据工件的性质选择合适的烫金纸。

B．烫金纸安装于下图，把金箔安装到放纸轮 A 上固定好后，拉出金箔沿箭头方向绕，用手转动卷纸手轮 B，让金箔从胶辊和光螺中穿过，然后固定在收纸轮 C 上。

C．调整烫金纸的位置，使其处于烫印面的正上方，然后用定位环定位。

D．调节拉杆的长度和摆角，使烫金纸距离烫印模板 10mm 左右。

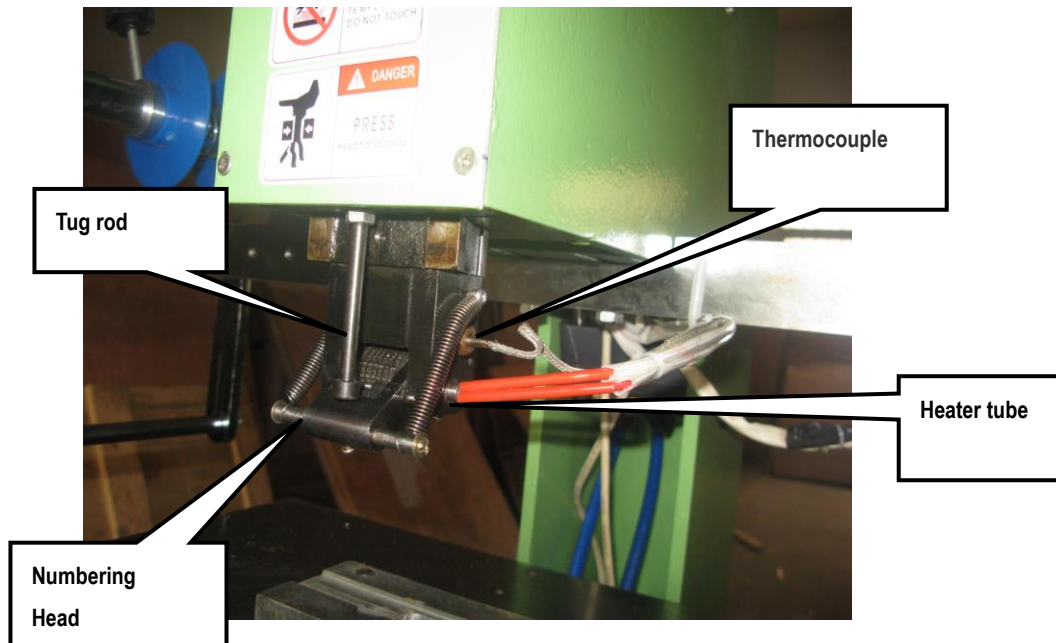


5、首先将设备放于平衡度好且无震动的场所，设备在出厂前都已调好，若需换牌或作其它调整，其步骤如下：

- A．将丝杠螺母手柄顺时针旋转工作台上升。
- B．让加热模块紧贴工作台。
- C．用一张薄纸放于两间隙中，以四点均拉不出最佳平衡状态。
- D．调节方式为：调整工作台下方四个螺栓。

6．烫印效果决定的主要因素：

注：压力、时间、温度以及合适的电化铝。



用户首先根据质材，选配合适的电化铝，其次烫印压力、时间、温度，根据实际情况略作调整。

1. Temperature setting

Different stamping materials, setting different stamping foil and temperature. When the red pointer point to the required temperature and heating up, the red power light and green light both on. After the temperature reach constant, the green light will off.(stop heating automatically)



2. Time setting

Foil collecting testing can be set 0~5seconds or 0~3 seconds. Different hot stamping need different setting. Please make them point to the needed time before power supply connect. (The machine set as 5seconds out of factory)

3. Pressure adjustment

The pressure generated from Level cylinder installed on stamping head. Please rotate the handle below the working table and rise it up for 3-4mm with hands when stamping plate contact with working table. The pressure too small, rotate the handle and make screw mandrel rise up; the pressure too big, rotate the handle and make screw mandrel down.

4. Install foil

- A. Choosing suitable stamping foil according to the substrates to be stamped
- B. Install foil on the wheel on the wheel A and fix it, Pull it and across along the direction of arrow then pass through rubber roller and steel roller, roll it on the collecting wheel C.
- C. Adjust the positing and make it locate above the stamped objects, then fix it with Location loop.
- D. Adjust the length and angle of steel rod, make the distance for 10mm between stamping foil and stamping plate.

5. The equipment have been adjusted out of factory. Be sure put it on flat and no shock place. If need adjust, the process of adjustment is as follows:

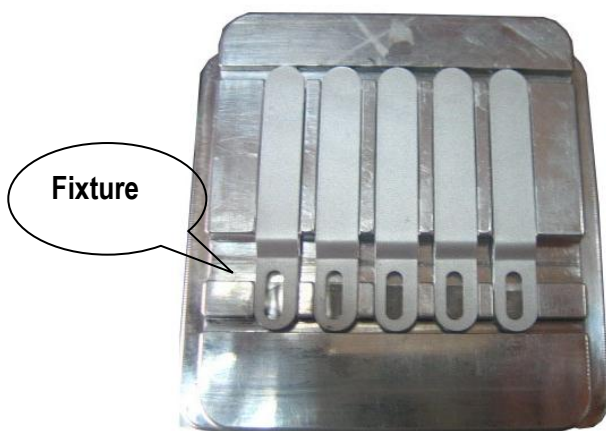
- A. Please rotate the handle and make the working table rise up.
- B. Make the stamping head contact closely with working table
- C. Put a piece of paper into the clearance.
- D. Way of adjustment: adjust the bolt under the working table

6. It is very important to master how to adjust the pressure, time, temperature and choosing stamping foil. Please flexible revision these parameters based on practical situation.

● 操作程序:

Operation process

- 1、将空压机气管接入设备或下侧油水分离器上,然后将调压旋钮,往上提起后旋转,“+”为增压、“-”为减压,调节空气压力使压力表显示压力在 4-6MP 左右,工作一段时间后按下排水顶针,让玻璃杯里的积水排出。
- 2、将设备电源插头插入有保护接地的电源上(必须接地可





靠)。

3、合上断路器开关，拨开电源开关，设备在某设定参数下开始升温加热。

4、将电化铝按顺序安装好，注意夹电化铝，弹簧不亦过紧或过松，更不能将电化铝装反。调节拉杆的长度和摆角，使烫金纸距离烫印模块 10mm 左右。



断路器
Circuit Breaker

5、上述一切工作就绪后，就可操作烫印了，将工件平铺工作台，按工作按钮，即可完成烫印一次。

6、先进行试印，若设置参数不理想可重新设置。

7、为了工作安全，实际工作时，建议一人操作。

8、若需停机，将电源开关拨至 0 位如果长时间停机，还应把电源和气源关掉。

1. Connecting the compress air with this machine, then lift up the pressure regulation and rotating. “+”is pressure increase. “-”is

pressure reduce. Please adjust the pressure of compress air and make pressure gauge displaying 4-6MP. Please removing the sweeper full of glass cup after the period of working.

2. Connecting Power supply which protective earthing.

3. Shut on circuit breaker, Switch on the Power button. The machine will be heat at the temperature

4. Install stamping foil and adjust the position, tension. The best distance between stamping plate is about 10 mm.

5 . Put object on the fixture and press 'press-testing' to have a stamping process.

6. First have a testing and setting parameter according to stamping result.

7. Only one worker to operate this machine suggested for safety cause.

8. Move the power switch to “0” when machine stopping. Shut off power supply and compress air when stopping for long time.



● 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。
- 2、烫印时，要保证烫印板与烫印面的紧密接触。
- 3、操作前应检查各气路、电路以及接地等装置是否良好。
- 4、不同质地的印件求不同的烫金纸，要根据印件选择与其相符的烫金纸。

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- 5、工作过程中，不要将身体某部位倾向烫印模块。
- 6、操作者离开工作现场，必须关掉气源、电源。

- 1.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.
- 2.Ensure stamping plate contact compactness with the surface of object stamped when working.
- 3.Please inspect gearing, circuit and earthing device.
- 4.Please choosing stamping foil consonant with object to be stamped.
- 5.Please do not touch stamping head because the temperature is high while working.
- 6.Shut off Power source when the operator leaving.

● 所用电器元件明细：

Electron component particulars

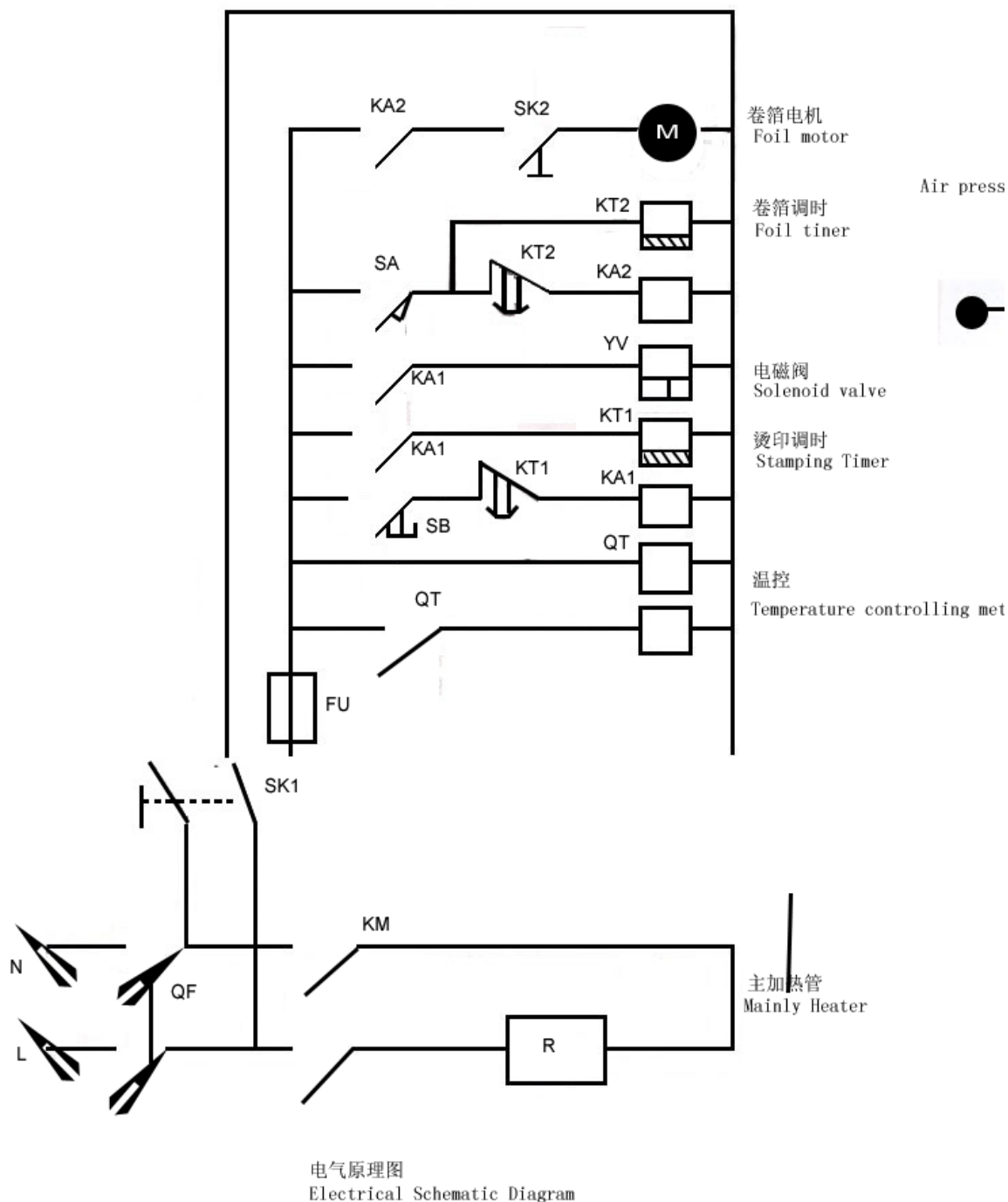
所用电器元件明细一表

序号 No.	电器符号 Symbols	名称 Name	型号 Model	数量 Qty
1	QF	漏电断路器 Earth Leakage Circuit Breaker	NL18-20	1
2	KM	交流接触器 AC contactor	CJX-0910/200V	1
3	R	加热管 Heater	Φ18X205	4
4	SK ₁ SK ₂	拨动开关 Knob switch	KCD ₂ KCD ₃	2
5	FU	熔断器 Fuse	RT14-20	1

6	Qt	温控元件 Temperature element	TEG-01	1
7	SB	按钮 Push button	LAY7-11BN(G)	1
8	KT1KT2	时间继电器 Time relay	ST3A-A/220V	2
9	KA1KA2	继电器 Relay	JQX-13F/220V	2
10	SA	行程开关 Travel switch	AE7311	1
11	YV	电磁阀 Solenoid Valve	4V310-10	1
12	M	卷箔电机 Foil Motor	25W/220V	1
13	θ	热电偶 Thermoelectric	E/m	1

● 电气原理图

Circuit schematic diagram



● 气压传动系统图 Pneumatic system chart

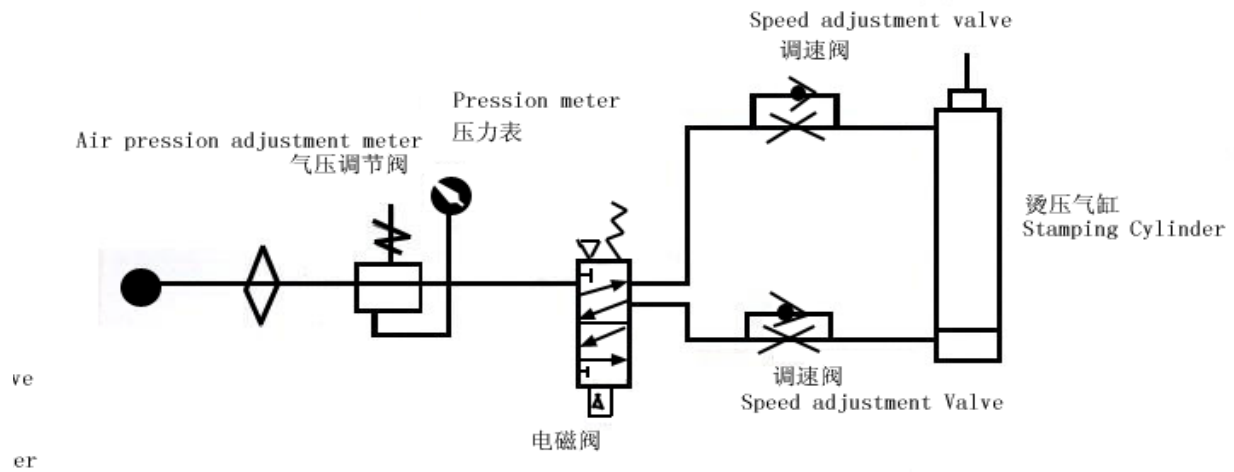
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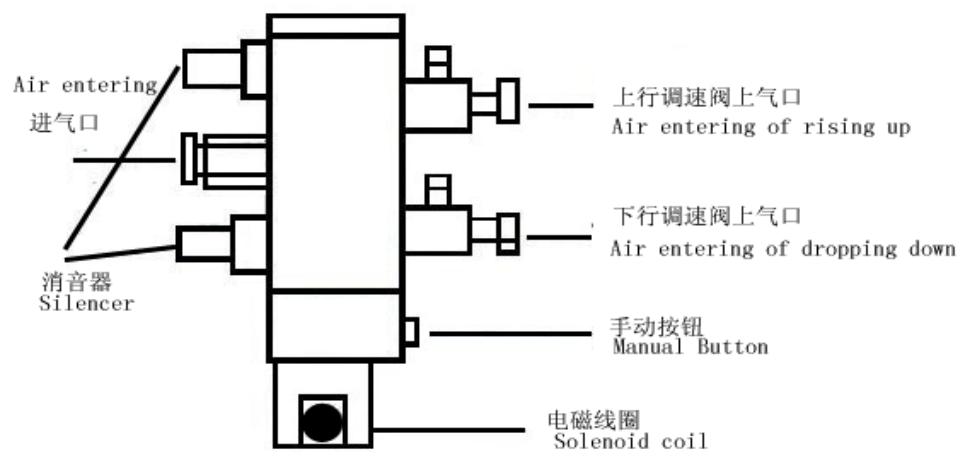
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controlling meter



4V310-10电磁阀气路图
4V310-10 Solenoid valve Drawing



● 日常维护及故障处理:

Maintain and trouble shooting

- 1、保持设备的干净。
- 2、经常及时排除空气过滤器中的积水。
- 3、定期对设备的“活动”部位进行清洁。
- 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，按照以下序进行检查。
 - 1)、电源输出端的电压是否正常。
 - 2)、熔断器是否熔断。
 - 3)、电源开关是否打开。
 - 4)、气压表压力是否正常。
 - 5)、打开旋钮开关，卷箔电机不动作，卷箔无指示：a 检查行程开关碰块是否到位，若无复位应复位，b 时间继电器旋钮是否在零位电机远处是否有卡住现象，c 检查电器箱内小型继电器是否很好 (JQX-13F/220V)。
 - 6)、卷箔电机运转无力，应该检查或更换启动电容。

- 1.Keep the machine clean.
 - 2 . Removing the sweeper full of atmosphere filter timeliness
 - 3.Regularly clean and add lubricating oil
 - 4.When the machine not working, please ask specialized electrician to look circuit malfunction so that avoiding unexpected loss.
- ①Check the output voltage of power supply if normal
②Check the fuse if break



- ③ Check the switch if switch on
- ④ Check the pressure meter if normal

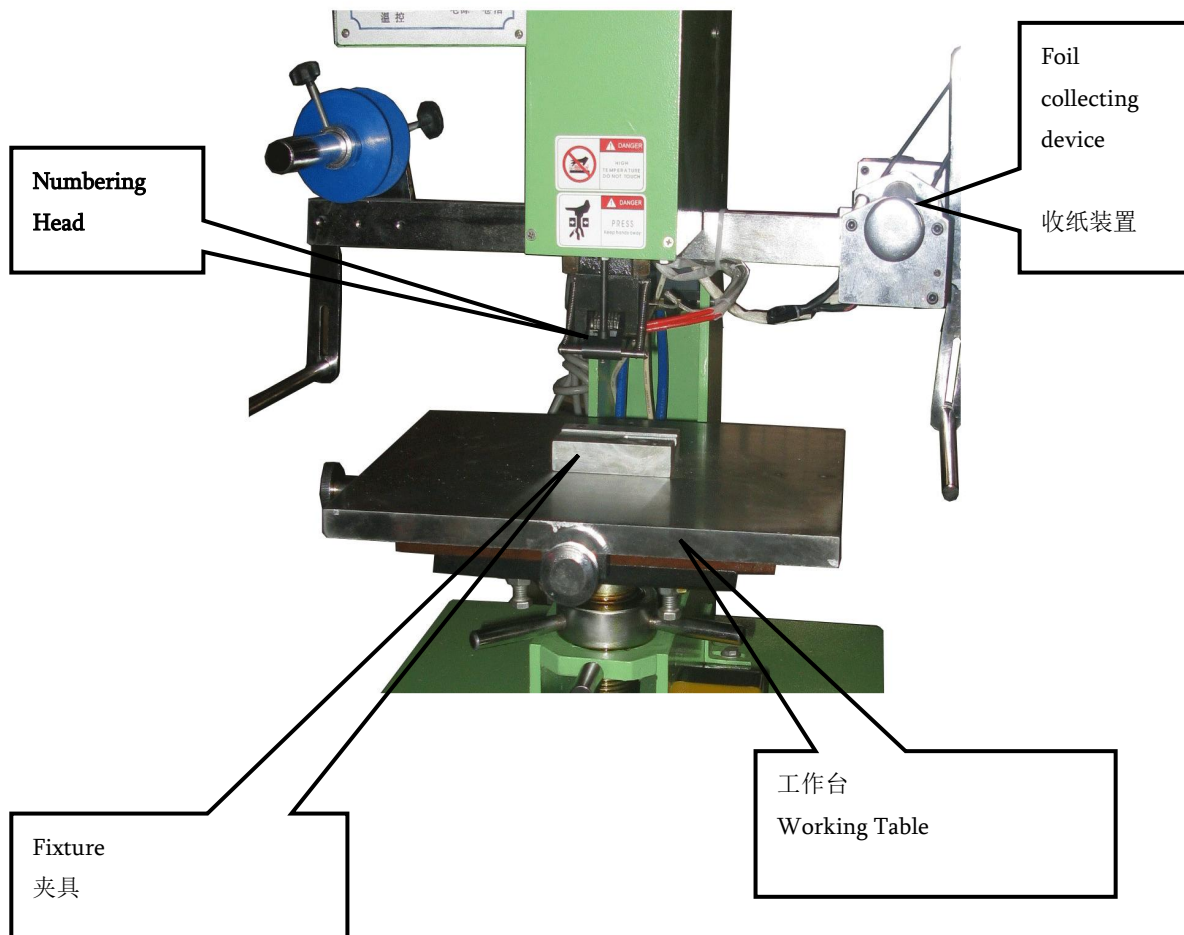
3. Open the foil switch, foil motor no running, foil no feeding:

A; Please check the travel switch if locate in place

B. Please check the time relay if lock at the Motor running.

C. Please check the small relay if keep well(JQX-13F/200V)

6.Foil Motor run powerless, please check or replace start-up Capacitance





1) 燙金的內容和編排方式：

比較常見的是數字，0.1.2.3.4.5.6.7.8.9. 英文字母：
A.B.C.D.E.F.G.H.I.G.K.L.M.N.O.P.Q.R.S.T.U.V.W.X.Y.Z. 有時候用戶也需要提供LOGO的設計文件。數字通常要燙一次變一次，也有的要一天變一次。反映在號碼機上面，有些需要自動變化，有些需要手動編號。

2) 字體的大小，一般以5號到3號居多。主要考慮要在產品表面燙印出清晰的字體。

3) 字體的類型，世界上有種類繁多的字母類型，但是用的最多的還是 Arial, times New roman, System.

1) hot stamping content and layout:

The more common is digital, 0.1.2.3.4.5.6.7.8.9. English letters: A.B.C.D.E.F.G.H.I.G.K.L.M.N.O.P.Q.R.S.T.U.V.W.X.Y.Z. sometimes users also need to provide LOGO design documents. Digital usually to iron a become a, also some will one day become a. Reflected in Numbering machine, some need to be automatic change, some need to manually Numbers.

2) the font size, general with 5th to no. 3 in the majority. The main consideration in product surface hot stamping out clear font.

3) the font types, in the world there is a wide variety of letters type, but use most or Arial, times New Roman, System.