

H-TC100K 曲面烫金机使用说明书

H-TC100K Cylinder Hot Stamping Machine

Operation Instruction



一、概述 Overview

该系列烫金机是在平面烫金机、滚动烫金机的基础上进一步革新, 研制共发出的新一代多功能型全自动平/滚机。设备既可用于平面烫印 (纸张, 木器, 塑料, 皮革, PVC 等), 又可作圆周曲面滚动。同时具有手动, 半自动, 全自动之功能, 真正体现了一机多用。烫金产品的特点是色彩鲜艳, 具有高度光泽。

Gilding machine in these series is upgraded further based on plane gilding machine and roll gilding machine and research and develop out new generation multi-functional full automation plane/roll gilding machine. The equipments are not only applicable to plane gilding (paper, wooden



appliances, plastic, leather and PVC etc), but also to the circle curve surface rolling. At the same time, it has manual, semi-automatic and full automation functions, which really embodies multiple functions in one machine. The characteristics of gilding products are brightly colorful and highly shining.

为了使用户能够准确地使用本烫金机, 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。

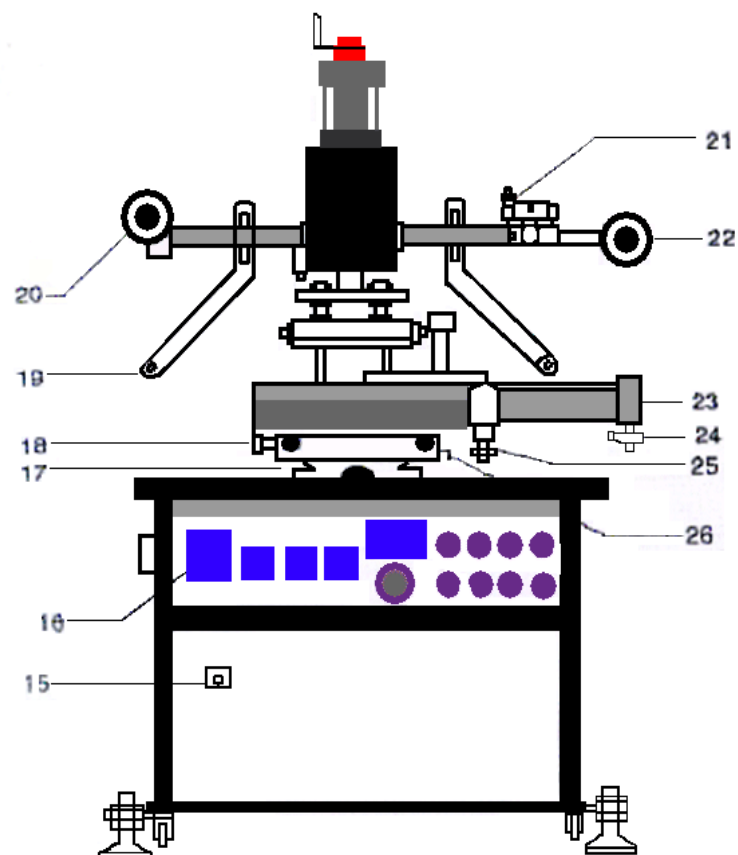
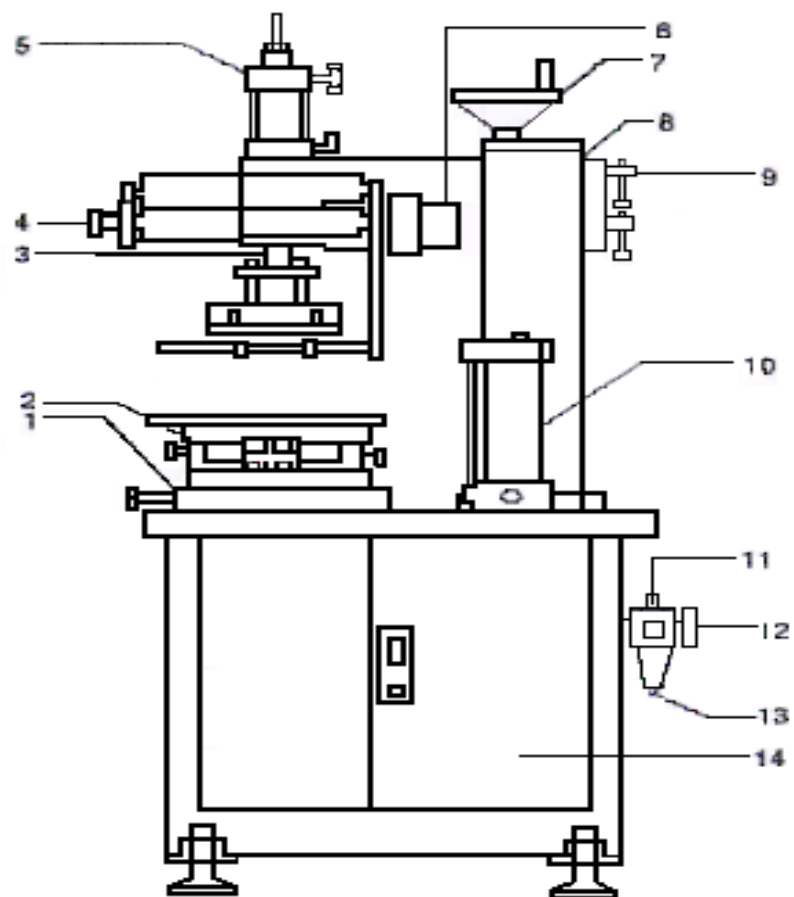
In order to use the gilding machine , please read the instruction carefully before use. In case of any ambiguities or questions, please do not hesitate to contact our company.

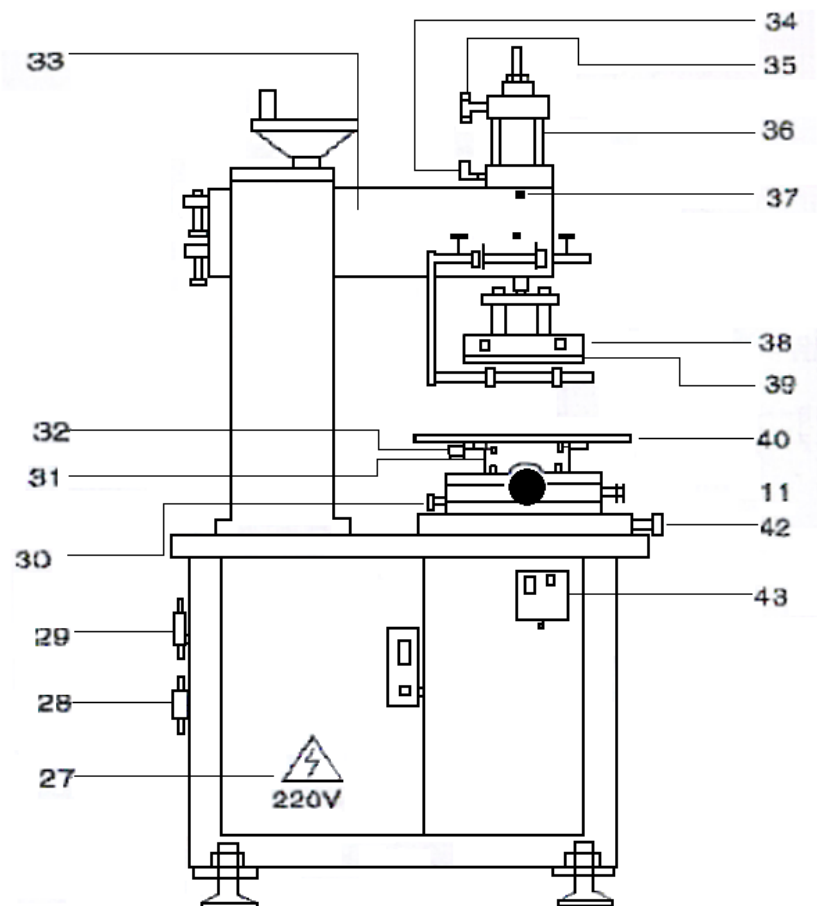
二、主要技术参数 Main technical details

烫金面积: 160*360mm	Stamping area: 160*360mm
工作台尺寸: 400×320mm	Worktable size: 400×320mm
烫印头行程 80mm	Displacement of the Gilding Head: 80mm
最大工件高度 260mm	Maximal height of working component 260mm
烫印压力选择范围≤1MPa	Scope of the Gilding Pressure: ≤1MPa
最大烫印速度: 1200PCS/H	Maximal hot stamping velocity:1200PCS/H
电源: 200V 50HZ	Power supply:200V 50HZ
发热功率 900W	Heating Power:900W
外形尺寸 1400*520*800mm	The size of appearance 1400*520*800mm
重量 0.10T	Weight:0.10T

三、主要结构及性能 (见附图 1 左/右主视图)

Primary structure and performance (see attached 1 left/right main view figure)







No.	名称 Name	No.	名称 Name
1	底盘 Under-pan	23	横向气缸 Horizontal cylinder
2	前后左右导板 Guide board in the front, back, left and right	24	横向气缸左行速度调节阀 Left running speed adjustment valve in horizontal cylinder
3	滑块 Slide block	25	横向气缸右行速度调节阀 Right running speed adjustment valve in horizontal cylinder
4	手动卷箔旋钮 Manual coil winding knob	26	前后导板锁紧螺丝 Lock tight screw in the front and back guide board
5	纵向气缸 Vertical cylinder	27	电器箱 Electrical appliance foil
6	卷箔马达 Coil winding motor	28	横向电磁阀 Horizontal electromagnetic valve
7	升降手轮 Hoisting hand-wheel	29	纵向电磁阀 Vertical electromagnetic valve
8	立柱 Column	30	左右导板锁螺丝 Lock screw in the left and right guide boards
9	锁紧螺丝 Lock tight screw	31	横向滑枕 Horizontal slip pillow
10	油缸 Oil tank	32	横向滑枕调节螺钉 Adjustment screw of horizontal slip pillow
11	压力调节旋钮 Pressure adjustment knob	33	机头 Machine head
12	压力表 Pressure meter	34	纵向气缸下行速度调节阀 Downward speed adjustment valve in the vertical cylinder
13	排水顶针 Drain thimble	35	纵向气缸上行速度调节阀 Vertical speed adjustment valve in the vertical cylinder
14	工具箱 Toolbox	36	纵向气缸 Vertical cylinder
15	脚踏插头 Feet step socket	37	纵向滑块间隙调节螺钉 Vertical slip block gap adjustment screw
16	操作面板 Operation panel	38	电热板 Galvanothermy board
17	工作台转锁紧螺丝 Workbench transfer lock tight screw	39	贴模板 Stick mould board
18	工作台左右移动调节旋钮 Left and right movement adjustment knob in workbench	40	工作台面板 Workbench panel
19	左拉杆 Left pull lever	41	工作台转动调节旋钮 Workbench rotation adjustment knob
20	放箔轮 Foil placement wheel	42	总坐台前后移动调节旋钮 Front and back movement adjustment knob in the general desk
21	胶辊调节旋钮 Rubber roller adjustment knob	43	电源断路器 Power breaker
22	收箔轮 Foil reception wheel	44	



四、面板操作

Panel operation

操作面板如图所示，各部分操作说明如下：

The panel operation is shown as the figures and the instructions of every part operation as following:

A: 温度显示器：分两部分，上部分为通电显红色数字.....烫板实际温度，下部分为预置温度装置。用户可根据不同的烫印无聊，选择合适的温度。

Temperature controller: divided into two parts, and the upper part is red figures after connecting current.....the actual temperature of the stamping template, and the lower part is pre-set temperature appliance. Users can select suitable temperature according to different gilding requirements.

B: 烫印调时：0~9s, 0 最短, 9 最长。

Gilding time adjustment: 0~9s , 0 minimum, 9 maximum.

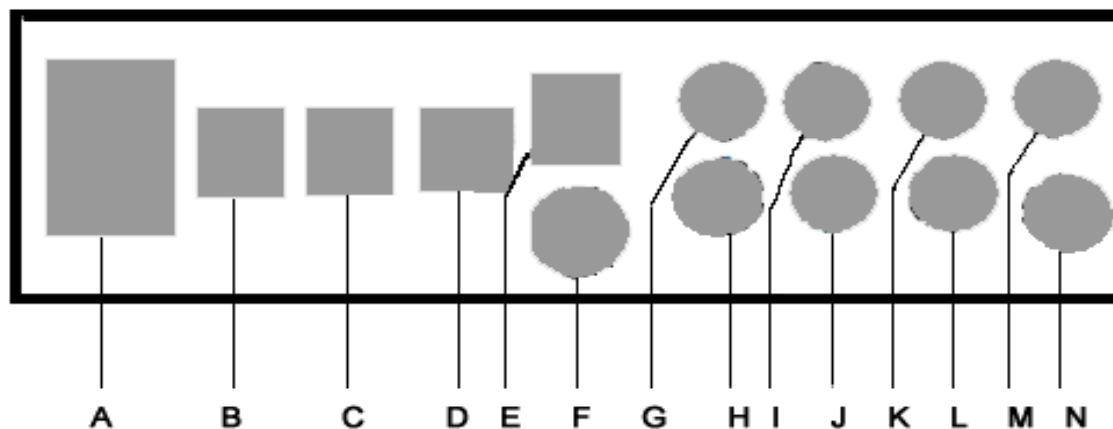
C:自动调时：设备处于全自动工作状态时，此表显示，稍停时间根据用户需要设置。0~9s, 0 最短, 9 最长。

Automatic time adjustment: when the equipments are under the full automatic state, this meter has shown figures and the suspending period is set according to the requirements of the users. 0~9s , 0 minimum, 9 maximum.

D: 卷箔调时：0~9s, 0 最短, 9 最长。通过调节此时间达到卷箔长短的目的。（或按寸动）

Foil winding time adjustment:0~9s , 0 minimum, 9 maximum. The length of the Foil winding can be adjusted through adjusting this period.(moved according to inch)

E: 计数器 220V 50HZ Counter 220V 50HZ



Function switching



Parameter setting

**Operation Panel of
H-TC100K**



F：急停按钮（红色）：按下此按钮设备自动停机，并锁住；若再开机，须按箭头方向旋开停扭。

Emergent stop button (red): press this button and the equipments are stopped automatically and locked; if restart, it needs to rotate the suspending button according to the direction of the arrow.

G：半动/全动开关，往左拨为半自动，可实现脚踏或手按各一次一步骤；往右拨为全自动，通过自动调时的稍停时间来实现。

Semi/full automatic switch, move to the left with hand is semi-automation, which can realize the procedure once feet stepping or pressing with hand; move to the right is full automation, which will be realized through suspending period in automatic time adjustment.

H：横向试模开关：拨动此开关，气缸推工作台左移到死点；拨回此开关，自动复位。

Horizontal mould trial switch: move this switch, and the cylinder will push the workbench left to the dead point; move back this switch and go back to the position automatically.

I：平烫/滚烫开关：往左拨为平烫；往右拨为滚烫。

Plane gilding/ rolling gilding switch: move left is plane gilding; move right is rolling gilding.

J：纵向试模开关：拨动此开关，气缸带末班下行；拨回此开关，自动复位。

Vertical mould trial switch: move this switch, and the cylinder will go downwards with the last time; move back this switch and go back to position automatically.

K：电源钮子开关：开机停机之功能。

Power button switch: the function of starting and stopping machine.

L：卷箔控制开关：将此开关拨到停位置，马达不运转。

The Foil winding control switch: move this switch into stop position and the motor will stop operation.

M：工作启动钮：开机工作时，按此按钮。

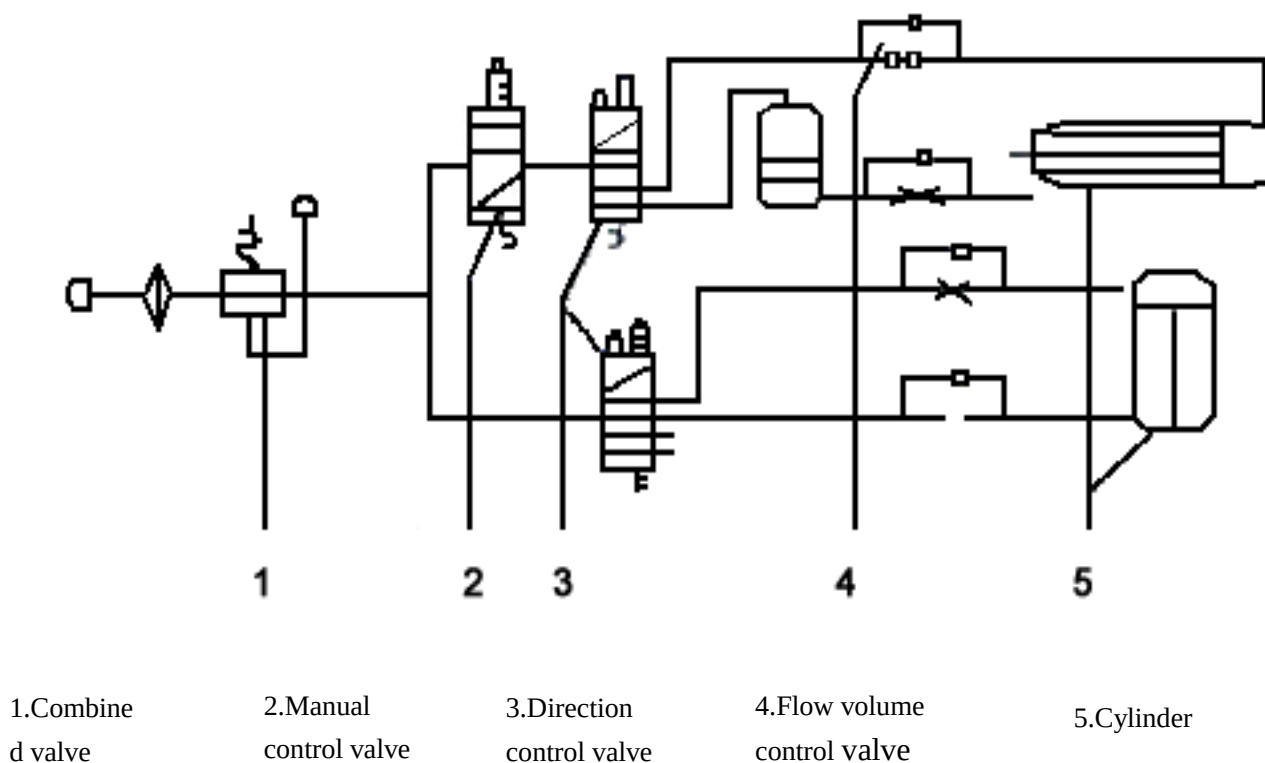
Work start button: press the button when starting the machine.

N: 卷箔寸动按钮：用手按一次，卷箔电机动一次；松开手卷箔不动。

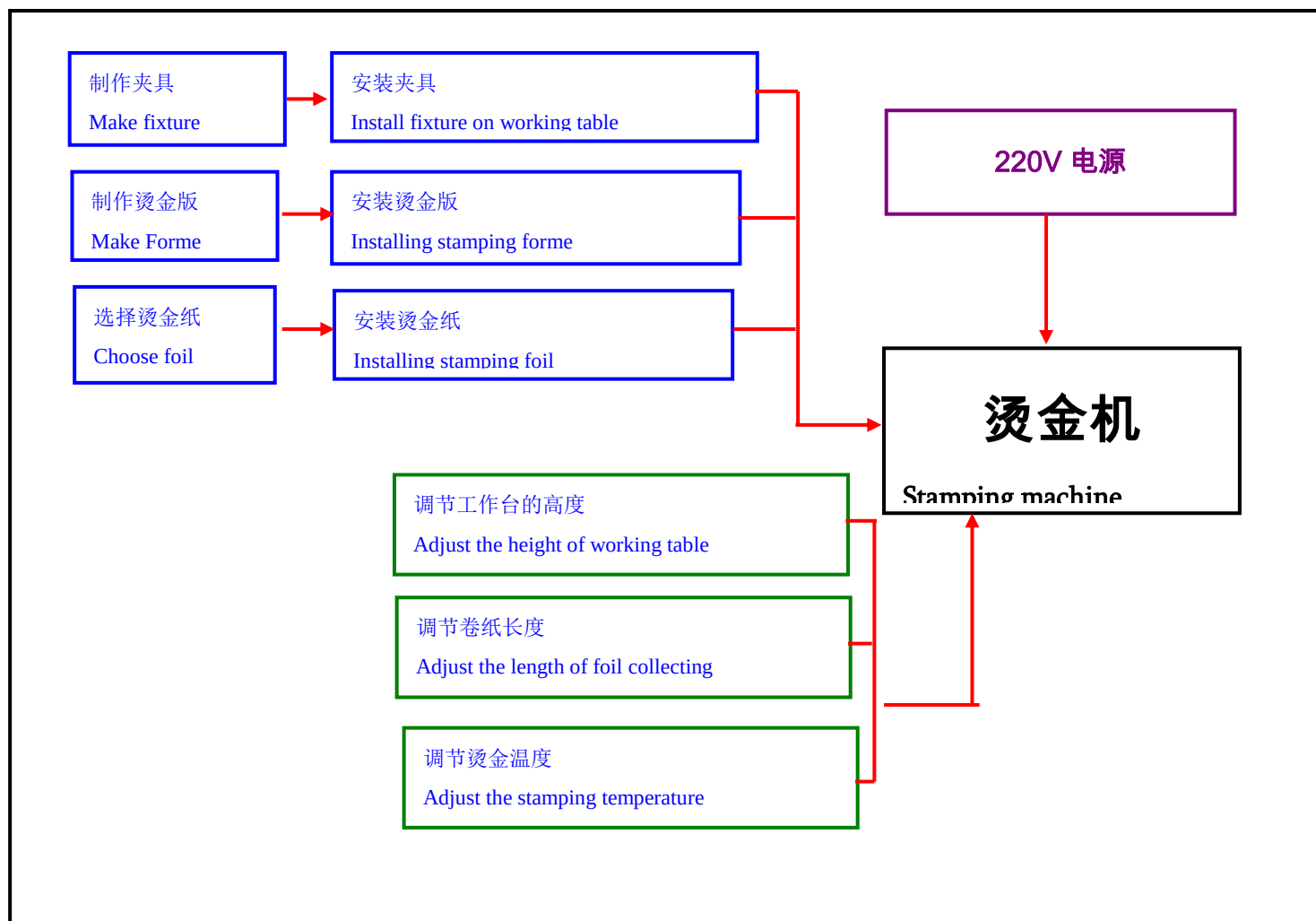
Foil winding inch move button: press once with hand and the Foil winding motor will move once; loose the hand and the Foil winding are motionless.

五、气压传动系统图

Pneumatic action system diagram



六、操作程序：Operational procedure：



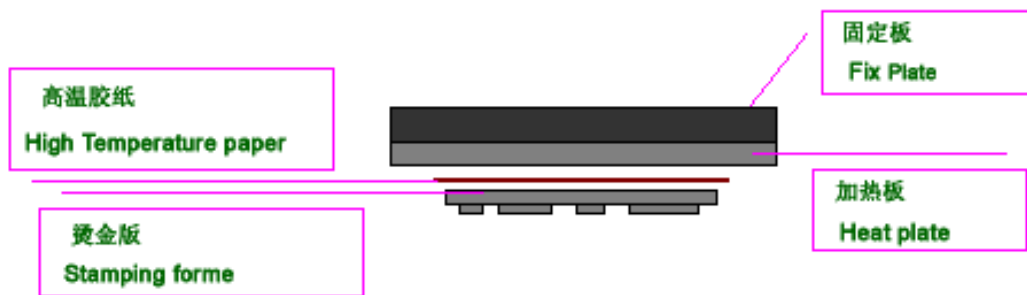
1、将空压机气管接入设备油水分离器上，然后将调压旋钮，往上提起后旋转，“+”为增压、“—”为减压，调节空气压力使压力表显示压力在 0.3MPa 左右，工作一段时间后按下排水顶针，让玻璃杯里的积水排出。

Connect the air pipe of air compressor to the equipment of oil-water separator , then raise the pressure adjustment knob and rotate it, " + " for pressure charging , " _ " for pressure reduction. Adjust the air pressure so that the pressure gauge can show the pressure between 0.3MPa or so. After a period of time, push down the drain thimble to vent the water accumulated in glass.



2.上好模具，放上工件，松开立柱后面的两根手柄，转动立柱上手轮调节烫板到工件的距离。

Put on the mould and the working components and loose the two handles behind the vertical poles and turn the hand wheel in the vertical pole to adjust the distance between stamping template and working components.



3、合上断路器开关，拨开电源开关，设定烫板在某一温度（例如 120℃）使烫板升温。

Switch on the circuit breaker, switch off the power switch , set the stamping template into certain temperature(e.g. 120℃) and make the

stamping template increase its temperature.

4、把烫印模板放在工件上方，用上板胶水平涂在烫印板上，按住试印键使烫板压下。烫印版平贴烫板约 10 分钟即可；亦可用双面胶把烫印模板粘在烫板上。。

Place the hot stamping template above the work piece, paint the glue into stamping template and press the printing trial key and make the stamping template go downwards. The gilding template is sticking the stamping template for about 10 minutes; you can also use double-face adhesive to stick the gilding template into stamping plate.

5、烫金纸的选择与安装

The selection and installment of gilding paper

A. 根据工件的性质选择合适的烫金纸。

Select the appropriate gilding foil according to the property of workpiece

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，用手转动卷纸旋钮 B，让烫金纸从胶辊和光螺中穿过，然后固定在收纸轮 C 上。

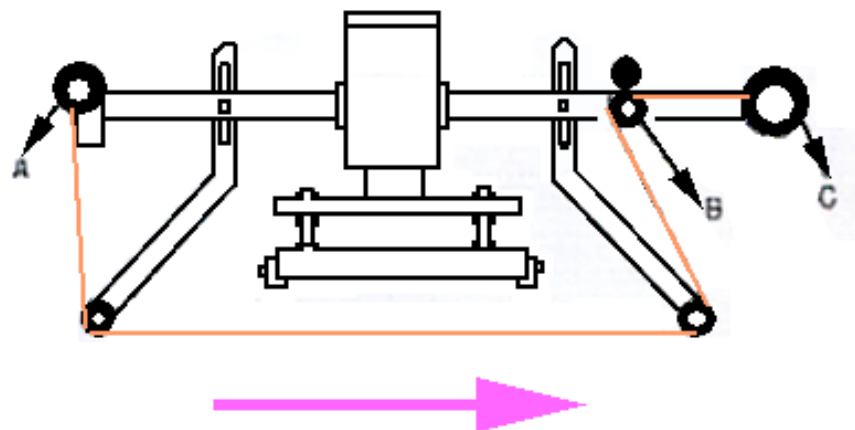
Gilding foil is fixed based on the following figure. The gold foil is positioned to Foil Releasing Wheel A and fixed, then drawn out and enwound following the direction of arrow. Rotate Foil --Enwinding Hand wheel B by hand to let the gold foil pass through the rubber roller and carrier, then fix it to Foil Collection Wheel C.

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。

Adjust the position of hot stamping foil so that it can be just above the hot stamping surface, then position it with the holding ring.

D. 调节拉杆的长度和摆角，使烫金纸距离烫印模板 10mm 左右。

Adjust the length and drift angle of drawbar so that there can be 10mm or so between the hot stamping foil and the stamping template.



6、调整“自动”时间，让机器的运行速度适合于手取放工件。



Adjust “automatic” period and make the operation speed of the machine match the condition using hand to put on and take out of the working components.

7、根据烫印件的性质，调整“烫印”时间。

Adjust “gilding” time according to the feature of the gilding components.

8、调整“卷箔”时间，即调节卷纸长度，使卷纸长度略长于印件。

Adjust “Foil winding” time, i.e. adjust the length of roll paper and make the length of the roll paper little bit longer than stamping components.

9、试印一次，如果效果不理想，可通过调节温度，压力及工作台位置（保证烫印板和烫印面吻合）来加以改善。

Try to stamp once, if the result is not ideal, it can be improved by adjusting temperature, pressure and position of workbench (guarantee the gilding template matches the gilding face).

10、选择最佳烫印温度（如图所示）

Select the best gilding temperature(shown as the figure)

温度 Temperature	100~150℃	150~180℃
适用的烫印件 Applicable gilding components	纸类，皮革，PVC 软板 Paper, leather and PVC soft plate	塑料，硬胶，木器等 Plastic, hard rubber and wooden appliance etc

11、设备具有两种循环状态，即单循环状态和连续循环状态。

The equipment has two kinds of cycle states, i.e. single cycle state and consecutive cycle state.

A: 单循环状态（半动）

A: Single cycle state (semi-automation)

平烫：将旋转开关 CK 旋至半动，LK 开关拨至平烫，电源开关开启位置，按工作起动按钮，动作一次完成一次平印。



Plane gilding: rotate the rotation switch CK into semi-automation and move the switch LK into plane gilding and make the power switch into on position and press the work start button and complete one plane stamping in one-time action.

滚烫: 将 CK 旋至半动, LK 开关拨至滚烫, 电源开关开启, 按一次或叫他, 次纵向气缸带模板下行至一定延时后, 横纵向气缸推工作台左移碰压行程开关 XXK2 和 XXK1, 气缸复位, 完成一次滚烫。

Roll gilding: turn CK into semi-automation and move LK switch into roll gilding and switch on the power switch and press once, when the secondary vertical cylinder template goes downwards for certain delay, the horizontal cylinder pushes the workbench left and touch and press the distance switches XXK2 and XXK1 and the cylinder goes back position and complete one-time roll gilding.

B: 连续循环状态

B: Consecutive cycle state

将自动调时时间, 卷箔时间, 烫印时间设定好后, 设备方可自动连续循环工作。

After well setting automatic time adjustment period, Foil winding period and gilding period and the equipments can make automatically consecutive working.



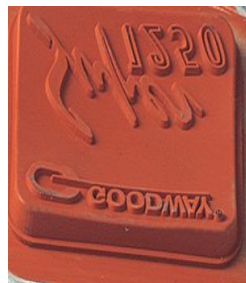
高温胶纸

High temperature tape



烫金纸

Stamping foil



硅胶版

Silicon rubber plate



烫金夹具

Stamping fixture model

12、若需停机, 将电源按钮开关拨至停位置即可; 如果长时间停机, 还应把电源和气源关掉。

In case of shutdown, set the power switch to stop Position . In case of a long period of shutdown, it is required to switch off the power supply and air supply.

七、使用烫金机的有关事项:

Concernment for gilding machine use



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。

Select the appropriate mould and prefabricate jigs according to the hot stamping area and shape of hot stamping piece.

2、烫印时，要保证烫印板与烫印面的紧密接触。

During the hot stamping, close contact between the hot stamping board and the hot stamping surface should be guaranteed.

3、操作前应检查急停按钮，行程微动开关等保护装置动作是否灵敏，以保障安全。

It should check whether the emergency stop button, distance slight movement switch and other protective appliances have sensitive actions before operation and so that guarantee the security.

4、不同质地的印件要求不同的烫金纸，要根据印件的选择与其相符的烫金纸。

The stamping piece of different materials requires different hot stamping foils. The corresponding stamping foil should be selected according to the stamping piece.

5、如果气缸动作太快，把该运动方向的流量控制阀顺时针方向旋转即可减慢其速度。

If the cylinder is moving too fast, rotate the flow control valve in this movement direction clockwise to slow down the speed.

6、工作过程中，当身体某部位处于极其运动空间时，应立即拍下红色急停按钮，这样就可以避免或减轻压伤事故。

In the working process, when certain part of the body is under the extremely moving space, it should press down the red emergency stop valve immediately, so that avoid or lighten the press injure accidents.

6、若操作者离开现场，必须拔掉电源插头和关掉气源。

The air supply and power supply must be disconnected if the operator leaves the site.

八、日常维护及故障处理：Routine attention and troubleshooting

1、保持机器的干净。Keep the equipment clean.

2、经常及时排除空气过滤器中的积水。

Eliminate the water accumulated in the air filter frequently.

3、定期对设备的“活动”部位进行清洁、润滑，把纵向、横向等活动部添加机械润滑油。



Clean and lubricate the "moving" position of equipment regularly. Apply the machinery oils to the moving position of both longitudinal and transverse directions.

4、若烫金机不动作，请按照以下顺序进行检查。

In case that the gilding machine has a failure to actuate, the inspection should be carried out according to the following sequence .

A、电源输出端的电压是否正常。

If the voltage at the power output terminal is normal.

B、熔断器是否熔断。

If the fuse is burnt out.

C、急停按钮是否复位，电源开关是否打开。

If the power switch is on. Whether the emergency stop button goes back position or not.

D、气压表压力是否正常。

If the pressure of air pressure gauge is normal.

5、查找线路故障时，必须由专业电工进行维修，严禁擅自拆装。

It must be maintained by the professional electricians and prohibited to dismantle and install them personally when checking up the errors in the lines.

九、常见烫印图案缺陷原因分析：

Analysis of causes on common hot stamping pattern defects:

1、图案呈方向性缺少。Patterns decrease in direction.

A、烫印模与烫印面吻合不好。



The hot stamping mould fits the hot stamping surface out of condition.

B、烫印板不平。

Uneven hot stamping board.

2、烫印不上或不齐。

Hot stamping failure or unevenness

A、湿度过低。 Too low humidity

B、压力过低。 The pressure is too low.

C、烫印纸选择不当。 Improper selection of hot stamping foil.

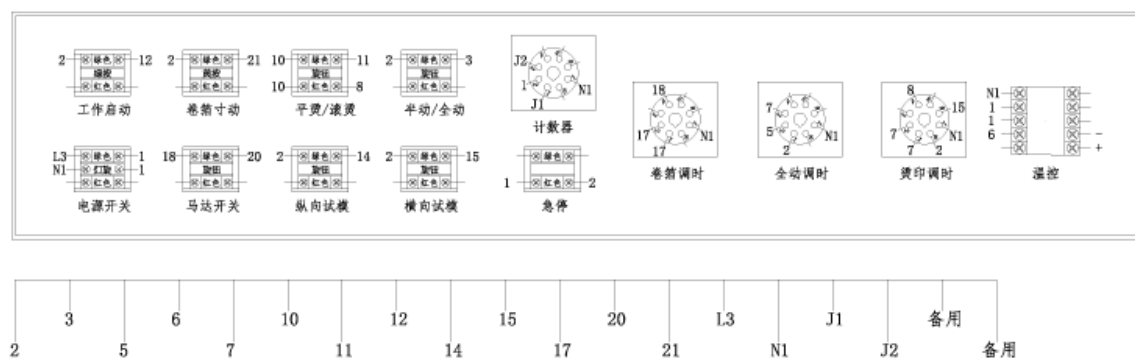
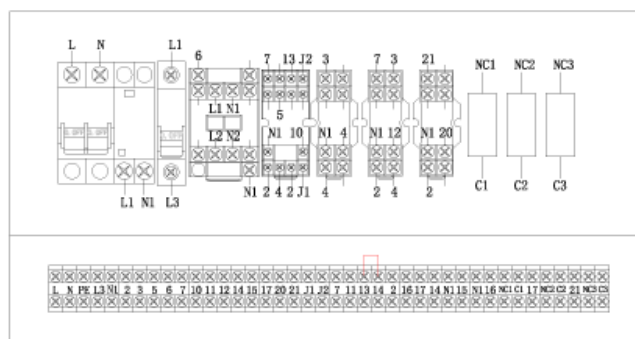
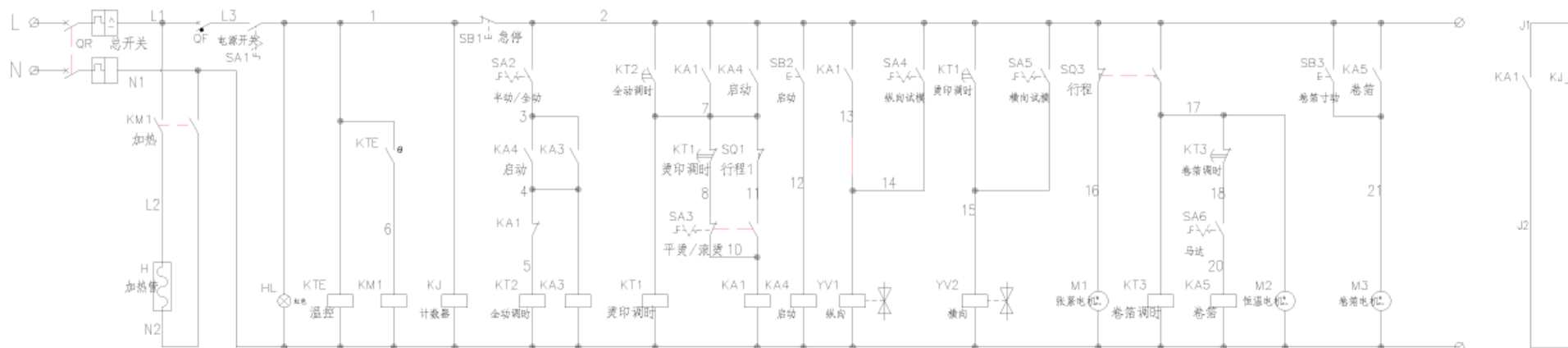
3、图案模糊烧焦

Pattern indistinctness and/or scorch.

A、压力太大。 Excessive pressure

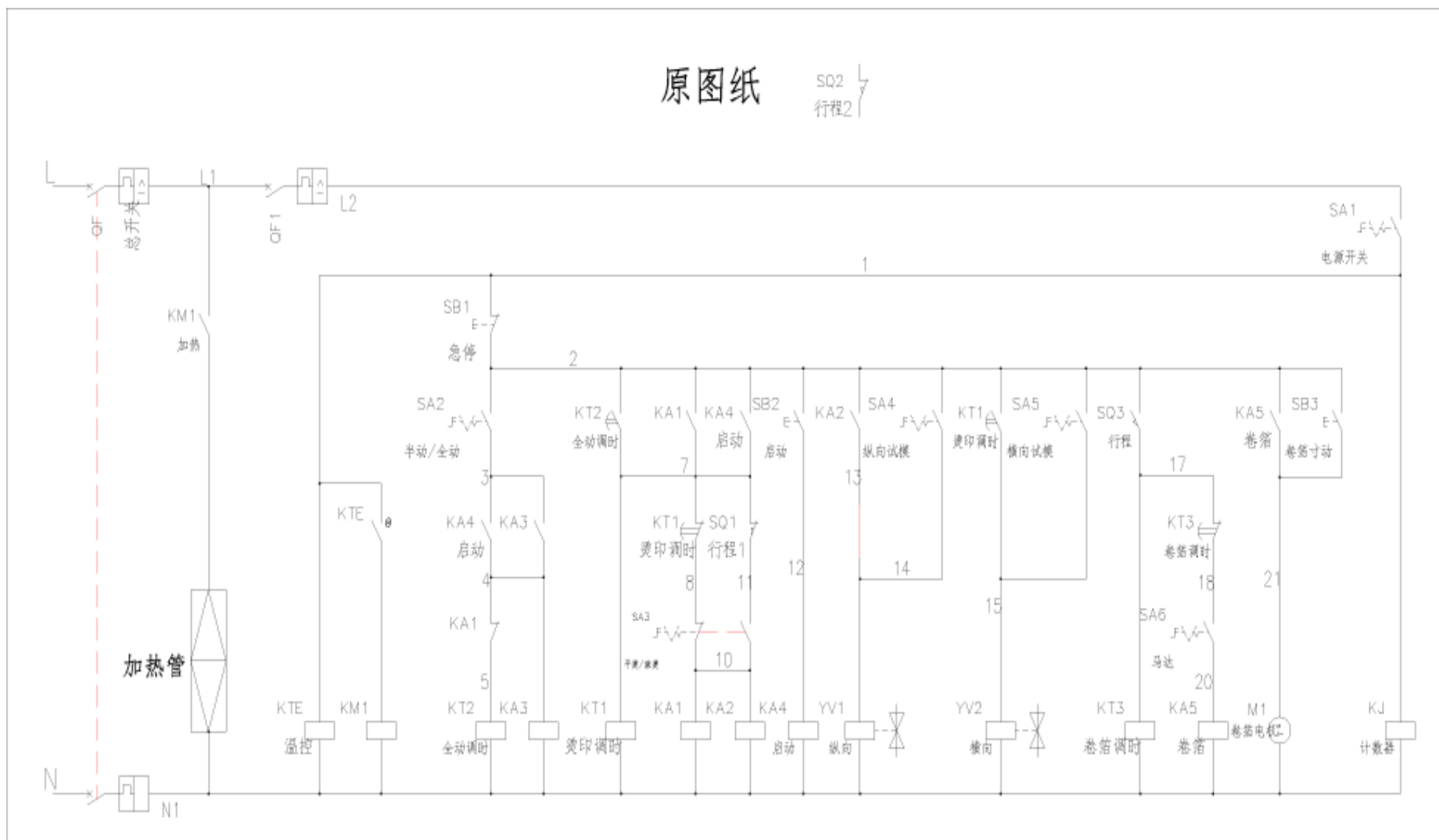
B、湿度过高。 Too high humidity.

电源	加热	控制电源	温控	计数器	全自动	烫印	工作台	卷箔	计数
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原图纸

SQ2
行程2





电气元件明细表 Detail for all electric units				
序号 No.	符号 Symbol	名称 Name	数量 Qty.	备注 Remarks
1	B16/220V	交流接触器 AC contactor		
2	RT14--20	熔断器 Fuse		
3	JQX-13F/220	小型继电器 Small-size relay		
4	XMTD-2301	温控仪 Temperature control element		
5	DH48S	时间继电器 Time relay		
6	DH48J	计数器 Counter		
7	LAYT-11ZS	急停按钮 Emergency stop button		
8	LAYT-11X/Z	钮子开关 Button switch		
9	LAYT-11BN(G)	按钮 Button		
10	NL18-20	漏电断路器 Creepage breaker		
11	1.2UF	电容 Capacitance		
12	15W/220V	卷箔电机 Foil winding motor		
13	18*100/220V	加热管 Heating pipe		
14	SY5120/220V	电磁阀 Electromagnetic valve		

十一、智能温控仪的有关事项：

11. The items about intelligent temperature controller

本机为智能温控，使用前请仔细阅读使用说明

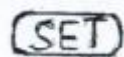
This machine is with intelligent temperature controller, please carefully read the application instruction before using.

1、操作说明

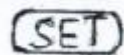
(1) Operation instruction

仪表面板上有四只键分别为：

There are four keys in the instrument panel, which are:



键：流程控制键



Key: the procedure control key



键：设定位移键



Key: set the displacement key



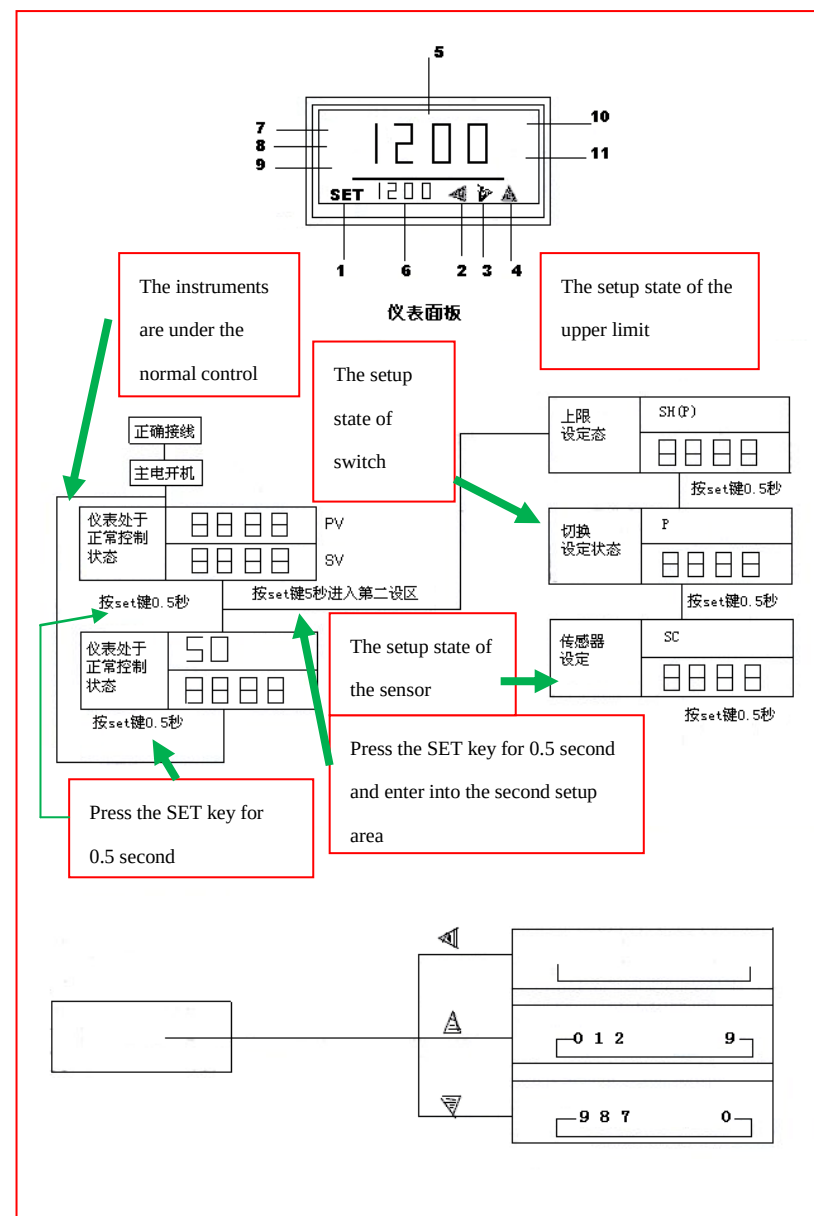
键：设立数字递增键



Key: set digital increase key



键：设立数字递减键





Key: set digital decrease key.

仪表参数修改，设定时的人机对话均通过四只按键来实现的，

The four keys can be used for the realization of modifying the parameters as well as human-machine conversation in setup.

当在第一次使用本产品时，请详细阅读上面的操作流程：

Please read the above operation procedures carefully when firstly using this product.

注：①切换差可调整范围为 $1^{\circ}\text{C}\sim 20^{\circ}\text{C}$ 或 $0.1^{\circ}\text{C}\sim 20^{\circ}\text{C}$ 却仅对主控起作用

Remarks: (1) the adjustable range of the switch difference is 1 degree to 20 degrees or 0.1 degree to 20 degrees, which can only function to main control.

②传感器修正范围为： $-20.0^{\circ}\text{C}\sim 20.0^{\circ}\text{C}$ ，出厂时设置为 0.0°C 。

(2) The correction range of the sensor is -20 degrees to 20 degrees and the setup when out of the factory is 0 degree.

③在第二设区时按 SET 键 5 秒钟后，推出设定状态，进入正常状态。

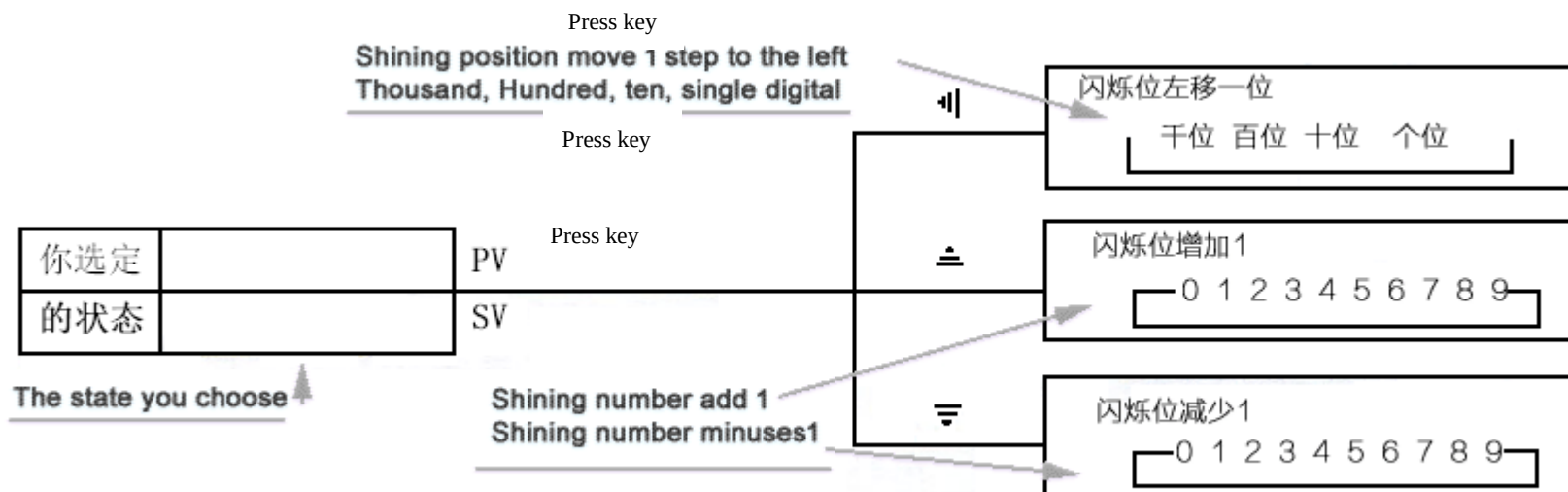
(3) Press SET key for 5 seconds in the second setup area and withdraws from the setup state and enters into the normal state.

2、其他操作

2. Other operation

① (除 CNG 系列仪表)

(1) (Excluding the CNG series instruments)



在进入你所修改的参数状态，你就可以操作其他键以达到你所修改的目的。

You can operate other keys to achieve the purpose that you can modify after you entering into the state of the parameters modified by you.

注：AT、T LOK 状态仅显示各位及十位值。

Remarks: AT, T LOK states only show single digital positions and ten position value.

②CNC 系列仪表：

(2) CNC series instruments:

Shining number adds

你选定

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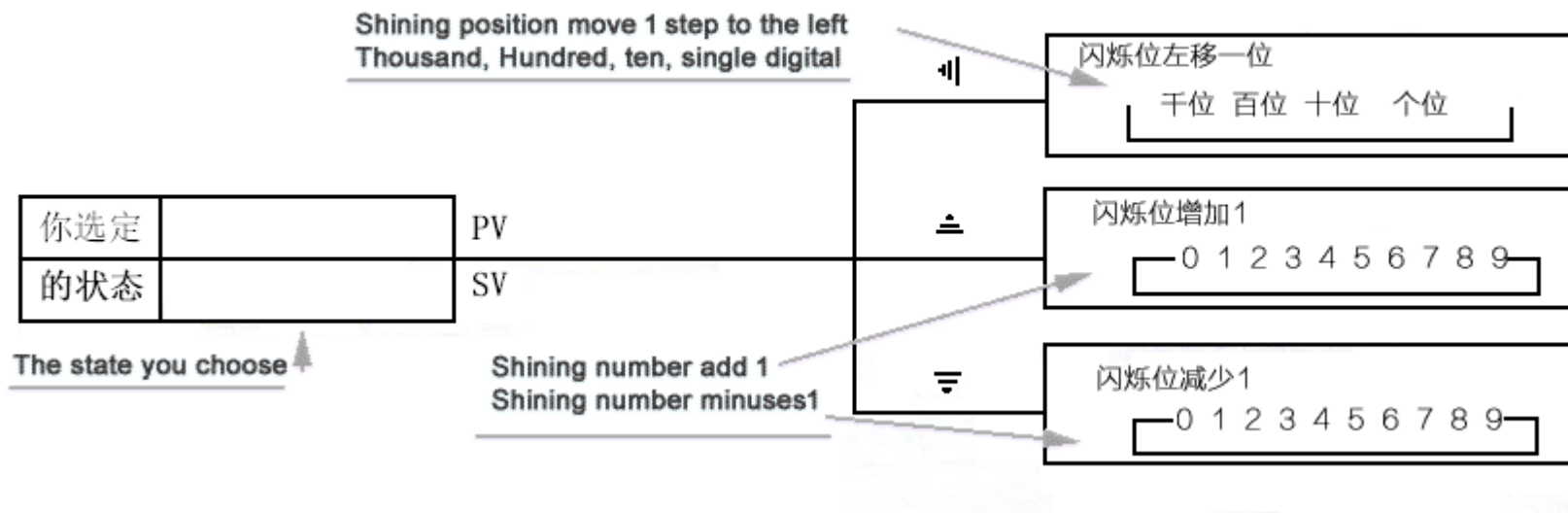
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Press



的状态: The state you choose 按 键: Press key 需要值: Value needed 闪烁数字加 1: Shining number adds 1 闪烁数字减 1 Shining number minuses 1

当需要有大数字变化时, 按住递增或递减键不放, 则设定值将进行快速加、减以缩短设定时间。

When it needs to change the big numbers, to press the decrease or increase key continuously and quickly add or minus the setup value to shorten the setup period

3、设定字符解释:

3. Setup the sign explanation

以下字符每按一次 SET 键后一次出现, 根据不同功能有些字符可能在你所选用的仪表中不存在。(见下表)

The following signs will be shown one by one when pressing SET key every time and some of which may not exist in the instruments you choose according to different functions (see the following figure)



4、使用注意事项：

4. The remarks about application

①把仪表插入仪表盘开孔中，开孔公差应适中，装上安装板螺杆，适度旋紧，外壳带自锁的仪表插入开孔中即可。

(1) Insert the instrument into the open hole of the instrument panel and the tolerance for the opening hole should be moderate and install and assembly the board screw and rotate tightly and the instruments with self lock in its outside shell shall be inserted into the open hole.

②检查仪表分度号规格及电源电压是否与所定仪表相同。

(2) Check whether the dividing level number specifications of the instruments and the power voltages are identical with the ordered instruments.

字符 Signs	名称 Name	设定范围 Setup range	说明 Description	出厂设定 Setup factory
	主控设置 Main control setup	0-9999	设定主控点输值大小 Setup the size of value output in the main control point	150
	下限绝对值设定 The absolute value in the lower limit setup	0-9999	设定下限（下限报警）点数值大小，下限报警控制点 SL 设为 100℃，实际控制点高于 101℃，继电器释放，低于 99℃继电器吸合。 Setup the size of point value in lower limit(the lower limit alarm) and the alarm control point in the lower limit is set as 100 degrees and the actual control point is higher than 101 degrees and the relay is released and absorb the relay lower than 99 degrees.	100
	上限绝对值设定 The absolute value in the upper limit setup	0-9999	设定上限（上限报警）点数值大小，上限报警控制点 SH 设为 200℃，实际控制点高于 201℃，继电器吸合，低于 199℃继电器释放。 Setup the size of point value in upper limit(the upper limit alarm) and the alarm control point in the lower limit is set as 200 degrees and the actual control point is higher than 201 degrees and the relay is released and absorb the relay lower than 199 degrees.	200
	上限偏差值设定 The upper limit error value setup	0-9999	设定上限报警点高于主控设定点的相差值，上限报警偏差控制点应为 SO+SHP，SO 主控温度设定为 150℃，SHP 设定为 10℃，实际报警控制点高于 161℃继电器吸合，低于 159℃继电器释放。 The alarm point in the upper limit setup is higher than the difference value in main control setup point and the upper limit error value setup control point should be SO+SHP, SO main control temperature is set as 150 degrees and SHP is set as 10 degrees and the actual alarm control point is higher than 161 degrees relay absorption and	10



			the relay is released when it is lower than 159 degrees.	
	传感器修正设定 Sensor correction setup	-20-20	修正传感器误差 Correct the errors of the sensors.	0
	比例范围 Proportion range	1-999	设定比例带大小，不允许设定为零。P 越大比例作用越小，系统增益越低。 Setup the size of proportion, it is not allowed to set as zero, the bigger P is, the smaller the proportion is and the lower that system increase becomes.	20
	积分时间 Integral time	0-3600 秒	设定积分时间：设定为 0 时关闭微分功能，I 越大积分作用越弱。 Setup integral time and close the differential coefficient function when set is 0 , the bigger the I becomes, the weaker the integral function becomes.	130
	微分时间 Differential time	0-3600 秒	设定微分时间：设定为 0 时关闭微分功能，D 越大微分作用越强，并可克服超调。 Setup the differential time and close the differential coefficient function when set is 0 , the bigger the D becomes, the stronger the differential function becomes and can overcome the super adjustment.	30
	比例周期 The proportion cycle	1-99 秒	设定输出开关周期不允许设定为零 Setup the cycle of output switch, which is not allowed to set as zero	20 (2)
			继电器输出时 20，其它输出时 2。 It is 20 when the output of relay is 20 and it is 2 when it is other output	
	比例周期 The proportion cycle	00: 自整定停止 Stop self -tuning 01: 自整定开始 Start self -tuning	确定自整定执行/关闭 Determine the execution and closing of the self-tuning.	00
	比例周期 The proportion cycle	00: 不锁 Not locked 01: 只能修改主控给定值 Only can modify the value provide d by the main control 02: 所有参数全所定 Lock all the parameters	确定参数修正允许/不允许 Determine whether it is allowed to correct or not.	00

③按接线铭牌或说明书接线图正确接线。

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(3) Connect the lines correctly according to the connection nameplate or use instructions.

④对热电偶输入信号请用与热电偶丝相同材料的补偿导线。

(4) Please use the makeup lead identical with the materials of thermocouple lines for the signals output from thermocouple.

⑤对热电偶输入信号请用相同规格低阻值导线，且三线长度尽量相等。

(5) Please use low resistance value lead with the same specification for the signals output from thermocouple and the length of the three lines are equal as possible as they can.

⑥特别注意电源输入线与信号输入线不可错接，及输出端子被强电流短路等。

(6) Especially pay attention that it is not allowed to make wrong connection between input line of power and the input line of signals and the output terminals are made with short-circuited by strong current.

⑦仪表电源线与信号线尽量与大电流线分开布线，以减少电磁辐射对仪表的影响，在无法避免时，仪表连线请尽量先用屏蔽线。

(7) The power lines of the instruments and the signal lines are laying separately with big current lines as possible as they can, so that reduce the impact to the instruments from the electric magnetic radiation, and please use the shielding lines for the connection lines of the instruments as possible as they can when it is not avoidable.

⑧为防止仪器损坏或失效，用额定电供电。

(8) It should use rated power for supply in order to prevent the instruments from damage or failure.

⑨断电后方可清洁仪器，清除显示器上的污渍请用软布或棉纸；显示器易被划伤；禁止用硬物擦拭或触及。

(9) It should clean the instruments after the power is off and please use soft cloth or cotton paper to clean the dirt in the display; the display is vulnerable to be damaged; it is not allowed to use hard stuff to clean or touch it.

10. 禁止用螺丝刀或圆珠笔尖硬物体操作面板按键，否则会损坏或划伤按键。

(10) It is not allowed to use screw blade or tip of ball pen and other hard stuff to operate the keys of the panel, otherwise they will damage or cut the keys.

5、简易问题维修

5. The maintenance for the simple problems



按仪表规格接上相应的电源线，传感器线及输出控制线以后，上电开机。仪表 PV 窗即显示测量值，SV 窗即显示设定值，同时进入自动温度控制状态。

Turn on the machine with current when connecting the corresponding power lines, sensor lines and output the control lines according to the specification of the instruments. The PV window of the instrument will show the measure value and the SV window will show the setup value and enter into the automatic temperature control state at the same time.

①若认为仪表指示失常，请检查传感器及接线。

(1) If it is thought that the instrument has abnormal display, please check the sensors and the connection lines.

②仪表面板各种功能显示，输出指示正常，而仪表失控时，请检查输出控制线连接是否正确，外部负载有否短路、断路、错线等导致仪表内部元件损坏，必要时可以停电打开仪表检查，输出端之铜箔，输出保护电阻有否烧焦，一般较容易修复。

The displays of variety of functions and output instructions in instrument panel are normal, when the instruments are out of control, please check whether the output control lines are connecting correctly or not, whether there are short-circuit, broken circuit and wrong circuit in outside load, which cause the damages of internal components in instruments and you can open the instruments and check them if necessary, whether the bronze coil in the output end and the output protection resistance are burned or not, which is easy to repair usually.