



H Series Hot Stamping Machine



H-TC250K

LC Industrial company Limited

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H-TC200 Operation Instruction

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General Description

The hot stamping machine is using temperature (room temperature-280°C) and pressure to transfer the color film on foil (electrode aluminum) to product. With bright color and high gloss, it can be used at stamping paper, wood and plastic surface as well used as brander.

H-TC series flat hot stamping machine working way is heating frame model press printing work piece.

The operation instruction is compiled for customer to use the machine correctly. Any question please contact with our company.

1. Model identification and technical data

Identification

H-TC200 Flat stamping machine

H-TC250K flat/cylinder stamping machine with shuttle worktable

Model	H-TC200	H-TC250K
Heating frame area	150x200mm	155x200mm
Worktable size	165x220mm	165x140mm
Stamping head stroke	25-75mm	25-75mm
Max. workpiece height	185mm	95mm
Stamp temperature range	Room temperature-280°C	Room temperature-280°C
Stamp pressure range	≤130kgf	≤130kgf
Max. stamping speed	1200pcs/hr	1000pcs/hr
Pneumatic pressure	4 ~ 7bar	4-7bar
Air consumption	≤40L/min	≤58L/min
Power supply	110/220v 60z/50Hz	110/220v 60z/50Hz
Heat power	900w	900w
Outline Dimension(mm)	720x560x1700	720x830x1700
weight	100kg	120kg

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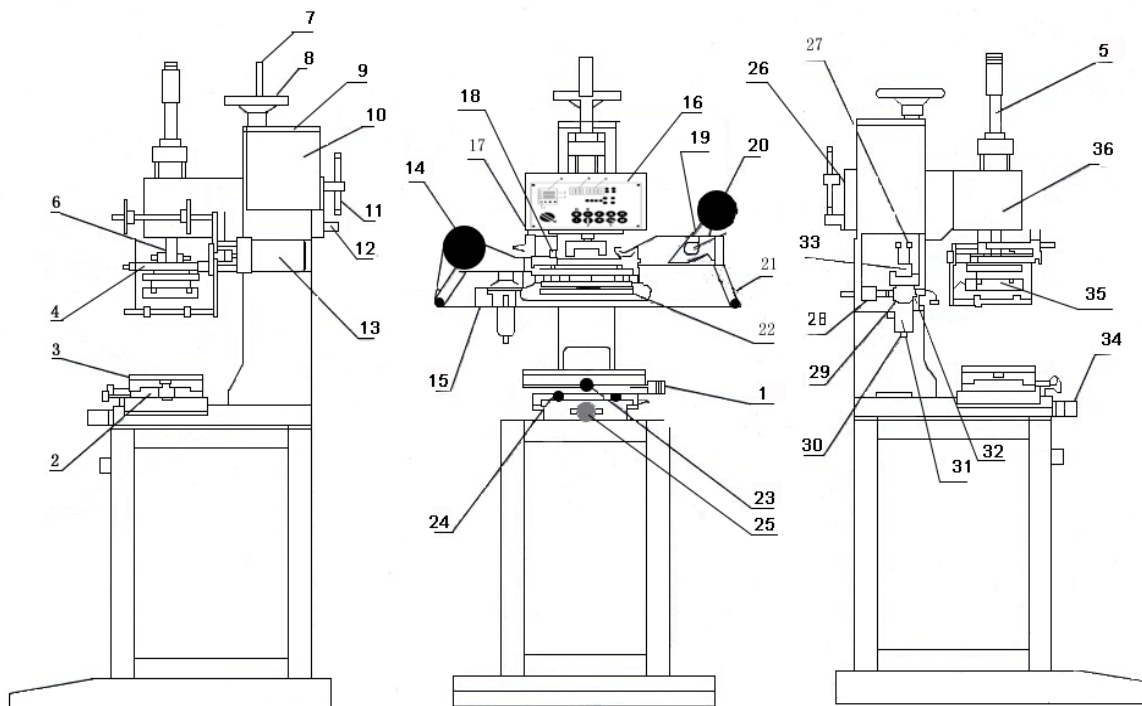


2. Main Structure and Functions

Main Structure (see figure 1)

1. Working table micro-adjustment knob
3. Worktable Board
5. Stamping cylinder.
7. Hand Wheel

- 2...Lower Guide Board
4. Main roller of receiving foil
6. Axis
8. Up-and down screw rod



- 9...Up and down aboard
- 11...Locking Screw
- 13...foil motor
- 15...Left Pull Bar
- 17...rod of up and down
- 19...Paper Collecting belt
- 21...Right Pull Bar
- 23...Lock Knob of working table
- 25...worktable front/back knob
- 27...Manual sliding valve
- 29...air pressure meter
- 31...water glass
- 33...pressure adjustment knob
- 35...stamping aboard

- 10...up and down seat
- 12...Worktable Rotating Knob
- 14...Stamping Release Wheel
- 16...control box
- 18...adjustment screw
- 20...paper collecting wheel
- 22...safe rod
- 24...Worktable left/right Move Knob
- 26...Stamp head lift speed knob
- 28...Press button
- 30...switching of removing water
- 32...water/ oil separating cup
- 34...Side gap adjust screw
- 36...stamping head

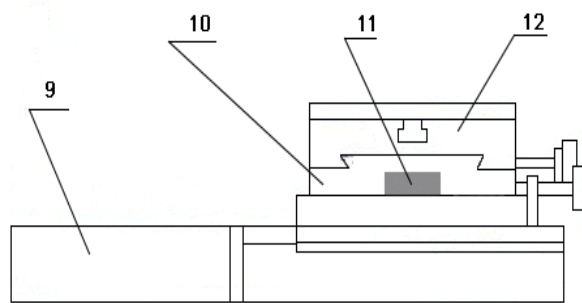
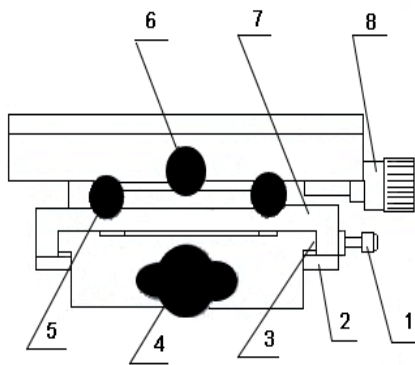
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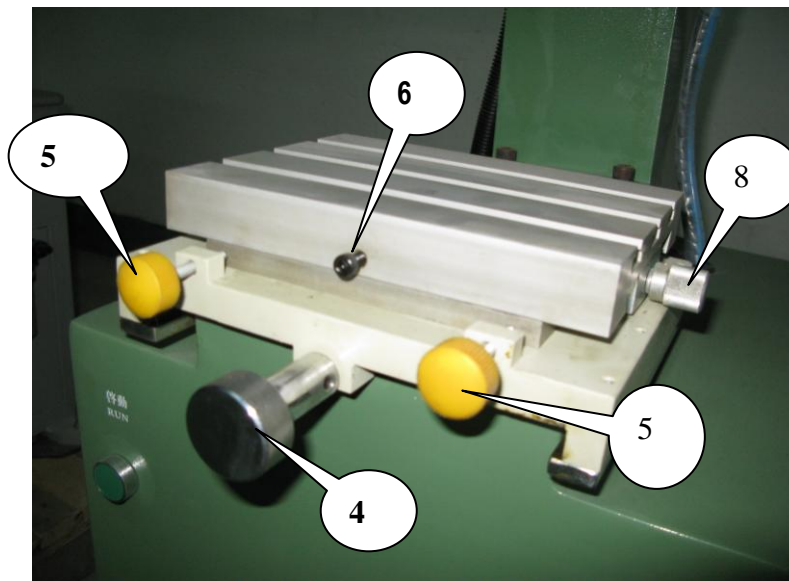
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3. worktable

H-TC200 hot stamping machine is basic model: H-TC250K is plus cylindrical worktable which is showed

◆ Basic worktable



1...Gap adjust screw

3...Gap adjust layer

5...Knob of worktable turning adjustment

7...base

9...worktable seat

11. Axis

2...Cover board

4...Knob of front back micro-adjustment

6...Worktable lock screw

8...worktable micro-adjustment screw

10. .guide aboard

12. Worktable

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Worktable adjustment

Front/back movement: loosen knob (6), turn knob (4)

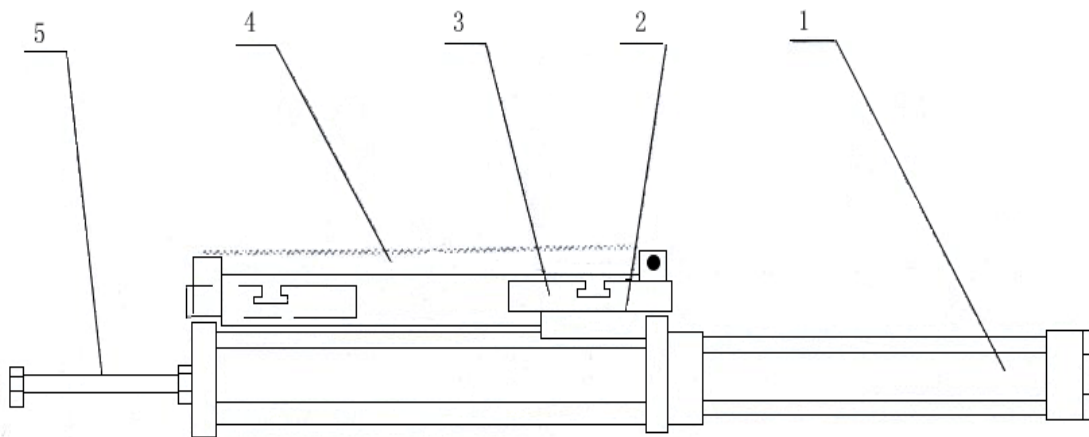
Left/right movement: loosen knob (6), turn knob (8)

Turning adjustment: turn two angle knobs (5) to move worktable, and then lock knobs.

◆ Cylindrical worktable

1. Cylinder 2. Slipping aboard 3. Worktable 4. Gear line 5. Stroke adjust screw

Work piece fixed on worktable when stamping worktable (3) moves to right, gear takes work pieces rolling to stamp cylindrical or arc surface stamping length can be adjusted by adjusting rod (5)



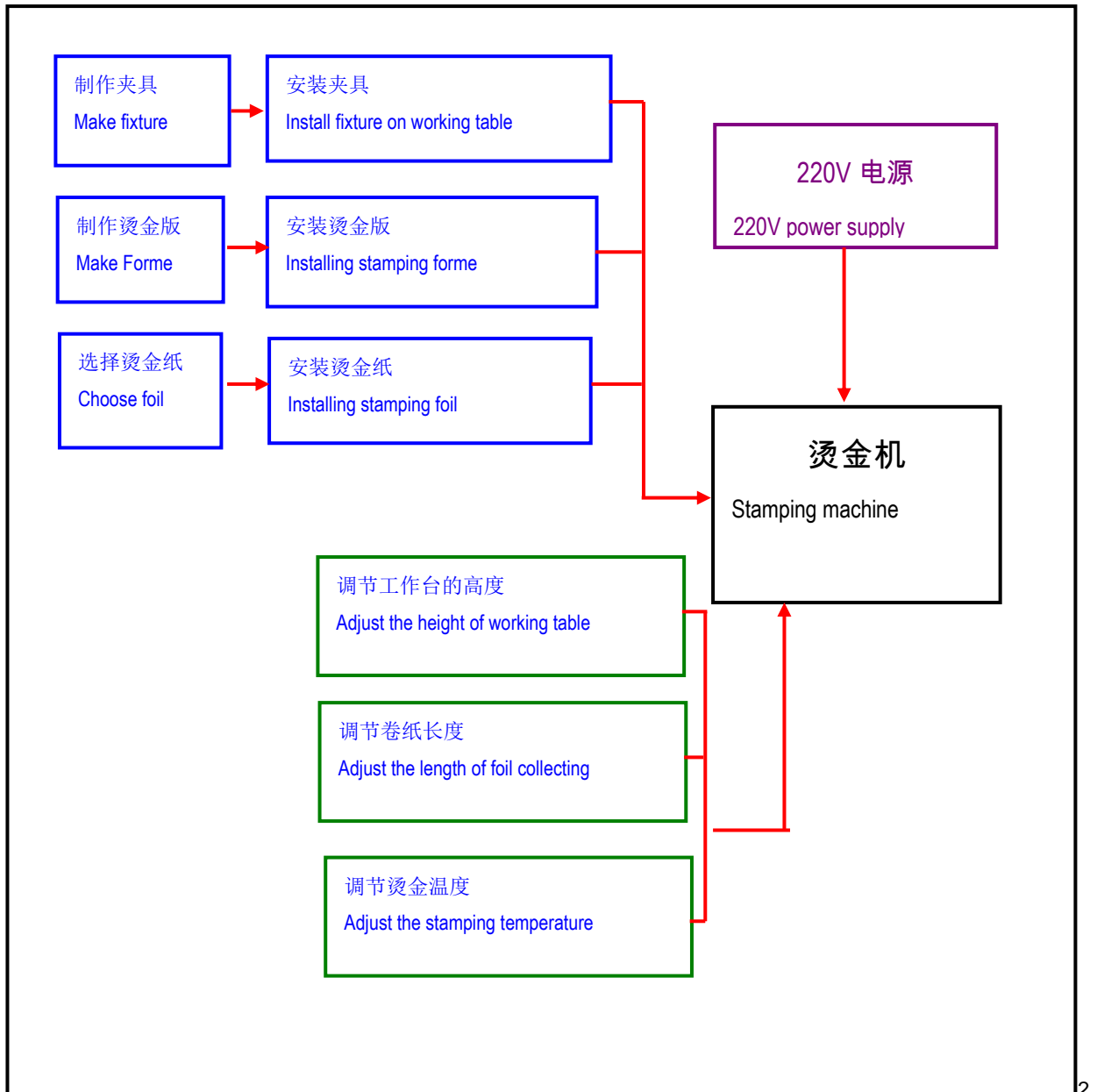
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"b" display collecting foil time, when this LED lights, monitor displays time collecting time.

4. Operation of control panel

Control panel instruction:

A. Temperature controller:

1. **TEMPERATURE SET:** User cans select temperature according to different stamping substrate
2. **TEMPERATURE DISPLAY:** Displays actuality temperature, under part is press reset key to change temperature ,
3. **SETTING TEMPERATURE DISPLAY:** Display setting temperature

B. Display setting

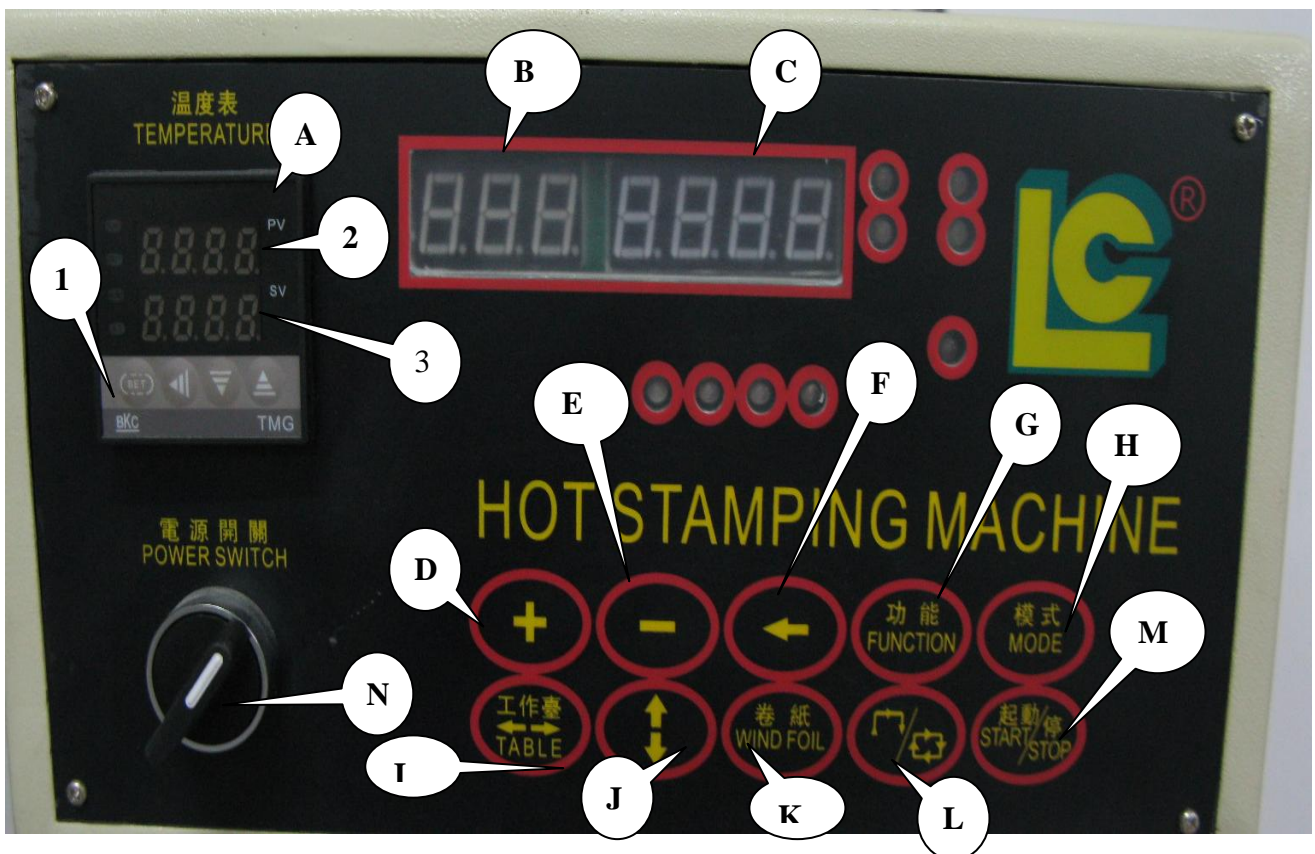
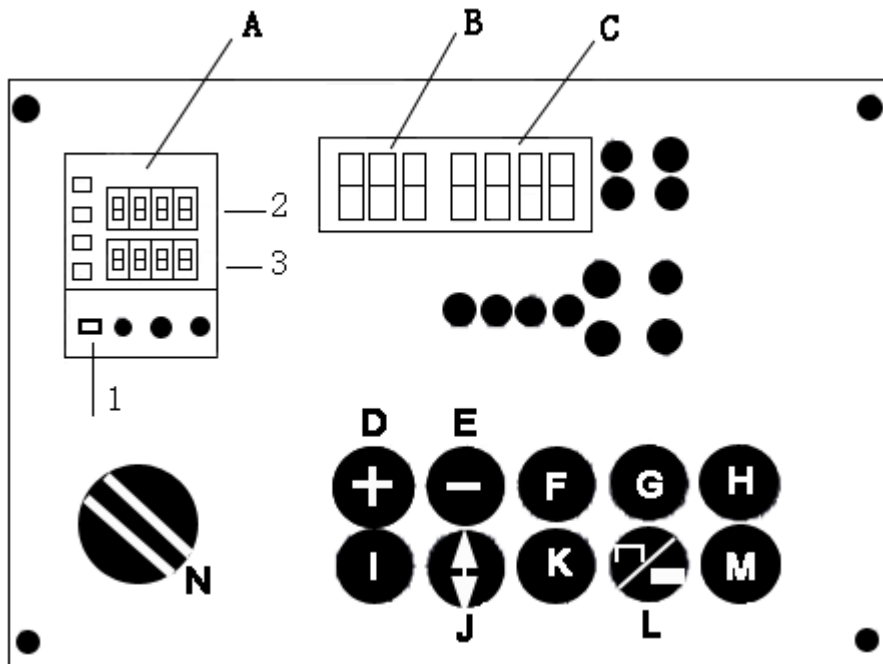
- 1."A" display stamping time: when this LED lights, Monitor displays stamping time.

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3. "[display pause time: when this LED lights ,Monitor displays time gap of two work cycle the auto mode is for test

4. "d" key of mode change: when this LED lights, "1" display flat stamping, "2" display cylinder stamping

5. "E" when stamping head raise up, collecting foil time delay.

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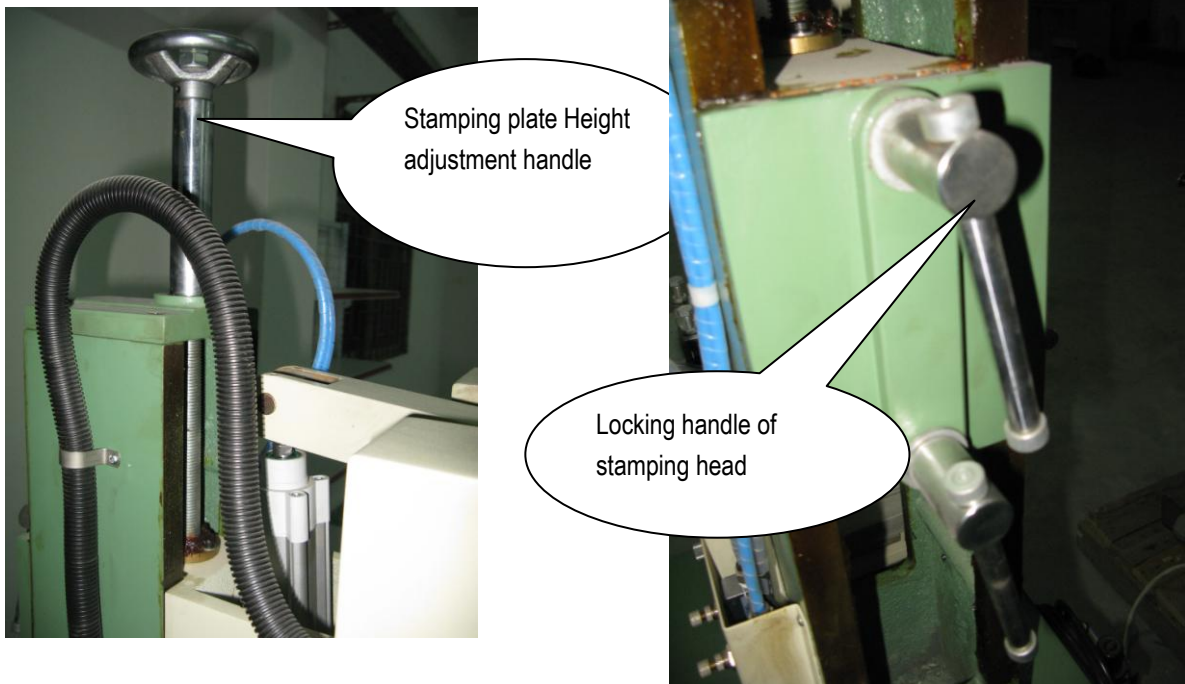
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C. Counter LED: when LED lights ,monitor displays finished product amount



1. Press this key one time , no calculate
2. press this key for 2 seconds reset zero.

D. Time reset key (+)

E. Time reset key (-)

F. Display moving

G. Flat/cylindrical key: LED not lights in default mode. It displays flat stamping press for LED lights to enter into cylindrical stamping shuttle table test key is not used in flat stamping mode .

H. switch key

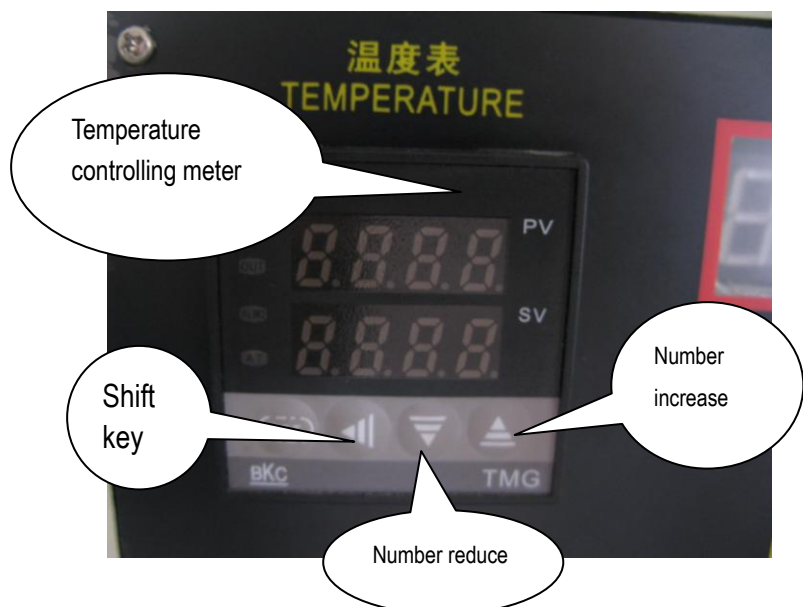
I. Shuttle table test: press one time, the shuttle move to left; press again the shuttle stop.

J. stamping test: press one time, stamping head down, press again stamping head up.

K. Motor test :press for motor winding release to stop motor running

L. Auto/I-cycle key : in auto cycle mode ,LED not lights. Press key for lights, machine is in I-cycle mode this model is in I-cycle mode auto mode is for testing

M. STOP/START” machine switch when machine is running, the J, K, L, M, keys is not available



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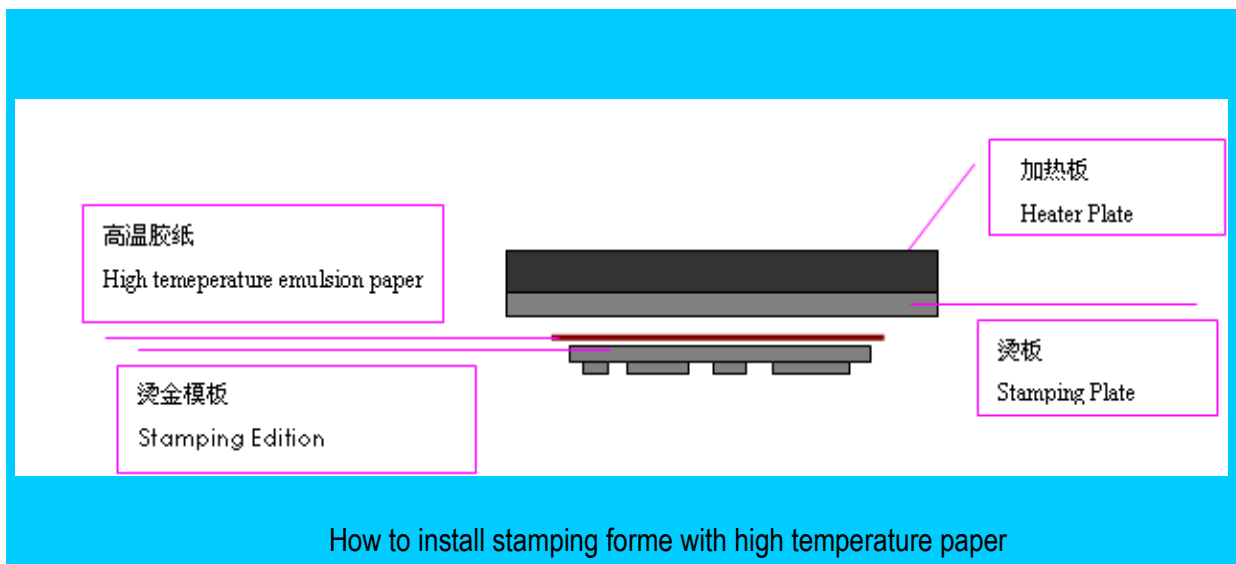
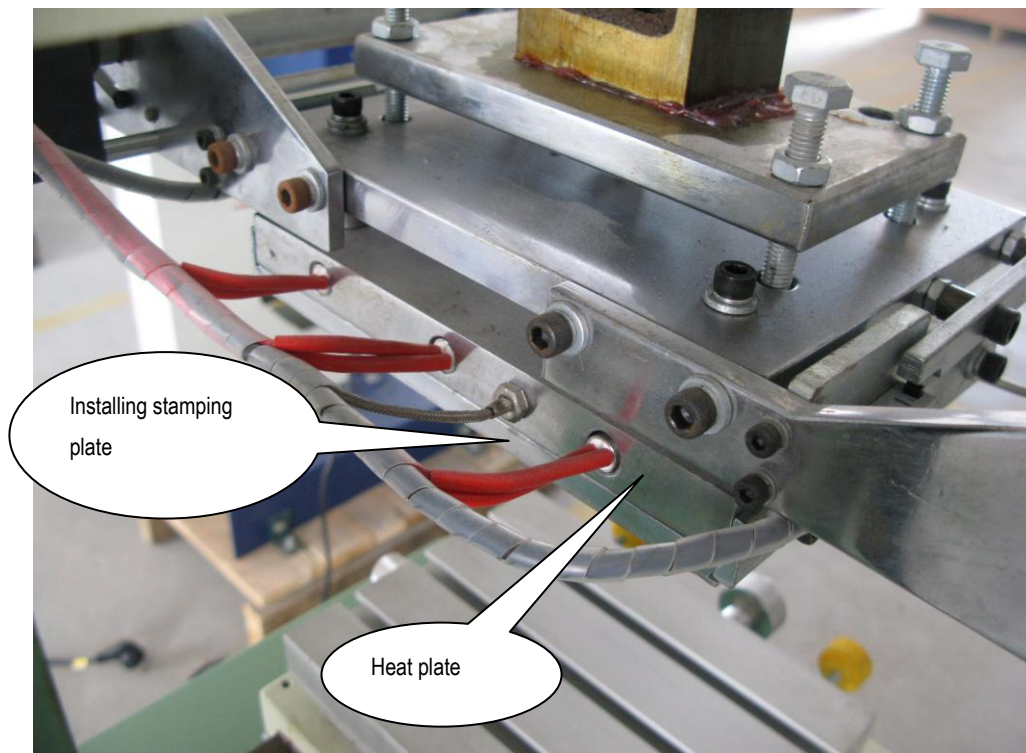
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N. Power switch



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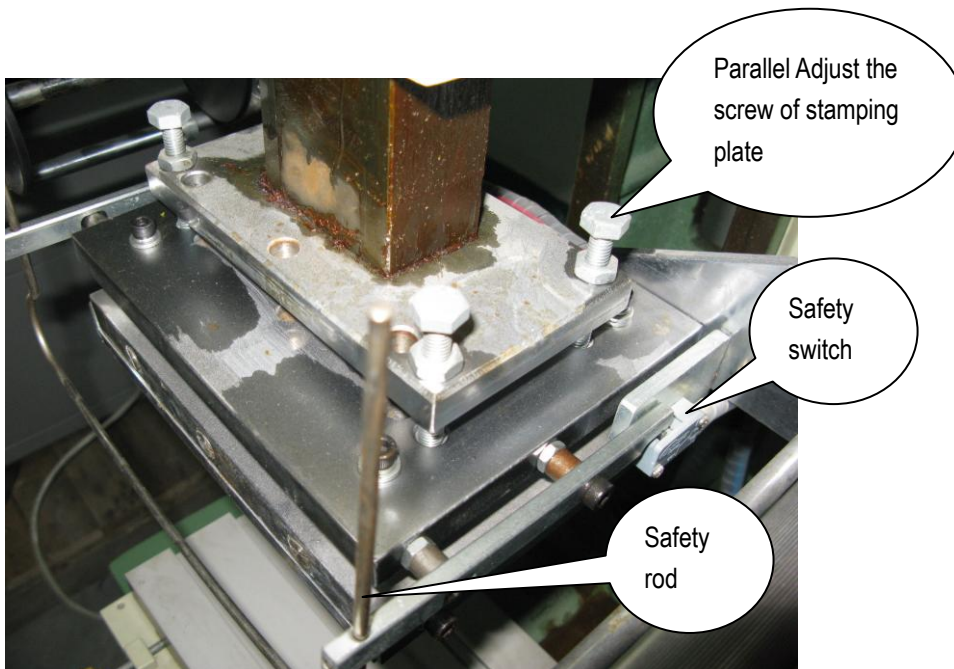
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6. Operation procedure

1. Connect pneumatic source to inlet of assemble valve (figure 1) and push valve (27) to assemble valve , the compressed air pass into machine ,lift and turn pressure knob (33) to adjust air pressure ,pressure gage (29)should display at 5 bar : press discharge key (30)after a period at working time to discharge water in glass .



2. Locate fixture on suitable position of worktable, put work-piece on and release handle (11) and turn hand wheel (8)to adjust gap between heating frame and substrate.█
3. Connect power supply, press switching "on" , and set stamping temperature.
4. Put template over the work-piece, coating stamping board with glue and press "stamping test" key to low stamping board for 10 seconds the template can also be pasted onto stamping board with two side glue belt
5. Stamping foil selection and installation

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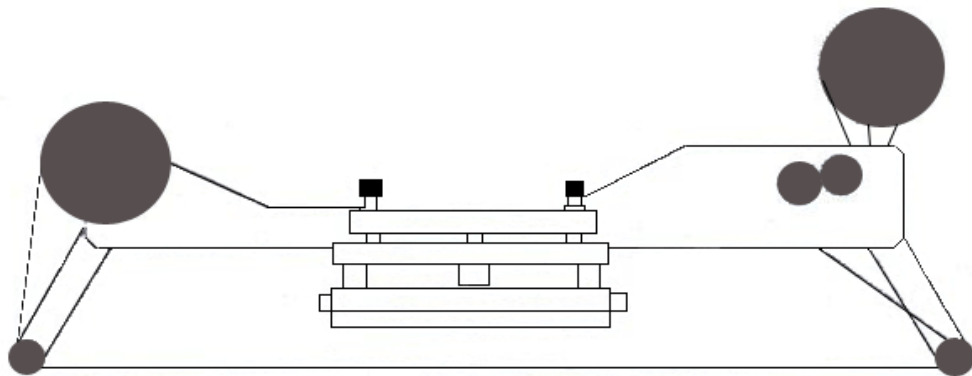
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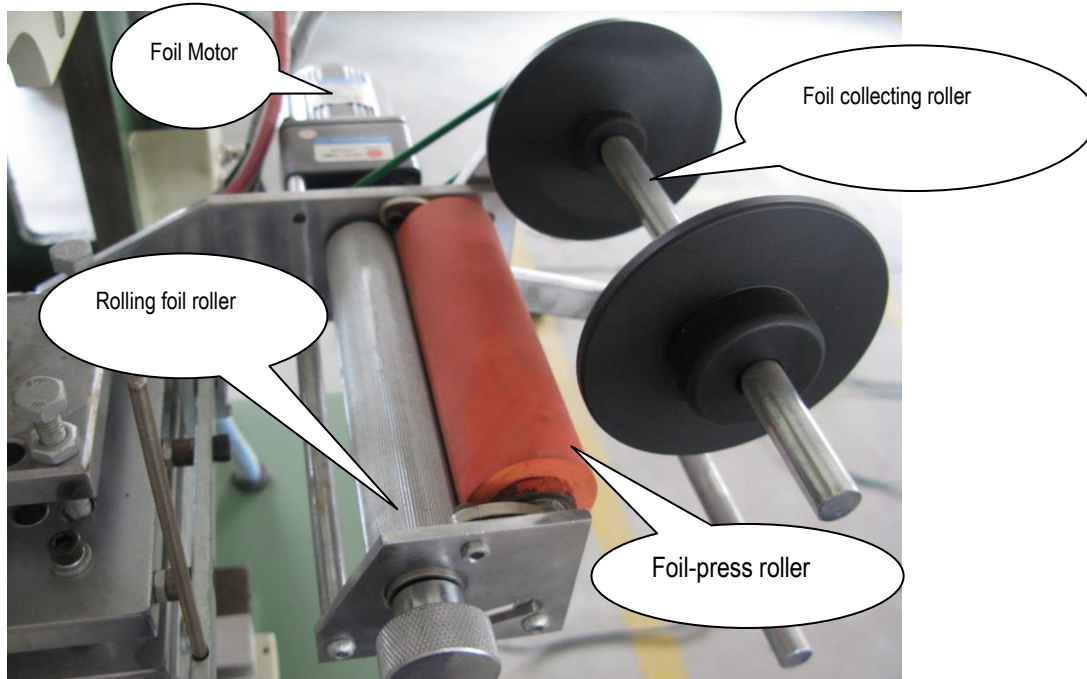
- Select available foil based on work-piece property

- Installation :

As figure below ,put foil on releasing wheel (14)and fixed draw the foil and wind to right direction manually wind paper roll to pass through the foil and fixed to collect roller (20)



- Adjust foil position to be over the stamping surface and locate



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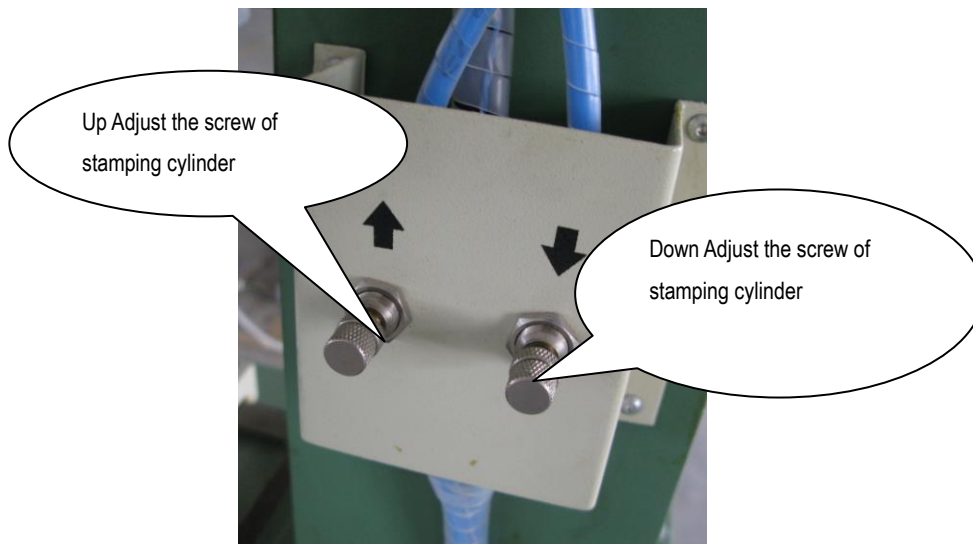


- Adjust draw rod length and angle to suit for 10 mm gap between foil and template
- 6. Adjust “stay time” to make machine run at suitable speed of work-piece operation
- 7. Adjust “stamping time”
- 8. Adjust “winding time “ to make winding length longer than substrate
- 9. Test once, if result is not ideal ,the temperature, pressure and worktable position should be adjusted to suit stamping board and surface
- 10. Select the best stamping temperature

Temperature selection reference list

Temperature	100 ~ 150℃	150 ~ 180℃
Suitable substrate	Paper, leather, PVC plastic	Plastic, rubber and wood

11. the above said is first time operation procedure ,on second time, open power and pneumatic source, and heat temperature to reset ones, install work-piece and press two knobs on base to complete stamping process.



7. Cautions

1. Pre-made clamps of substrate according to stamping area and shape
2. Ensure stamping board contact closely to surface
3. Check protect equipment (safe rod)
4. Different substrate need relative foil please request to local supplier
5. If cylinder moves faster , turn flux valve clockwise to reduce speed
6. Master manual sliding block draw away from assemble valve to cut pass way of pneumatic air and discharge air in cylinder ,machine stop running
7. If operator leave away ,the power plug must be taken out pneumatic source be shut off
8. Avoid 2 people operating same machine ,and adjustment can't be started until machine stop running

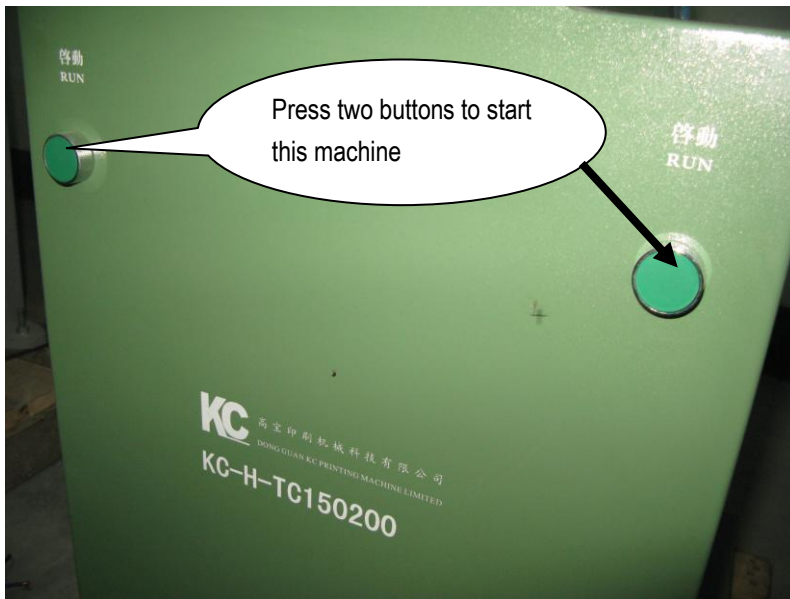
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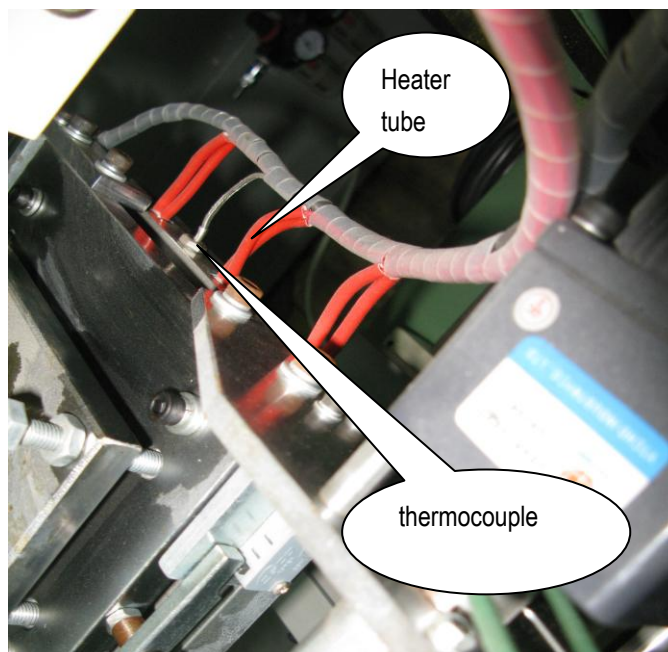
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8. Maintenance and service

Maintenance and service can prolong machine usage and keep it in good performance the following items can be adopted

1. Environment : clean, no dust producing environment is needed ,if long time no using it should be covered with plastic bag
power :stable power supplier is needed in unstable area
2. Pneumatic source : air source should be clean and no impurity discharge dirty water in filter regularly
3. Keep machine clean and no impurity disturbance
4. After printing ,clean and take away the residue glue on stamping head
5. Lubricating active part (assemble ,shaft ,rack ,gear ,and adjust rod)calcium grease is recommended to use general shaft ,each two months (5000 hours)change once
shaft chain lubricated once a day with motor oil as in figure 9.fill in oil on a, b, c, d, part rack ,gear and adjust rod be lubricated with butter each week note : lubricating frequency is based on normal working (8 hour per day)during work process, add oil should be more frequently



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NOTIFY

In order to keep solenoid work normally and prolong its life, the following item should be noticed

1. *Clean environment and pneumatic source without impurity*
2. *Discharge dirty water in separate water tank regularly*
3. *Keep discharge hole at back of unit smoothly and clean & dry if long time no use ,protect solenoid not to be blocked*

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

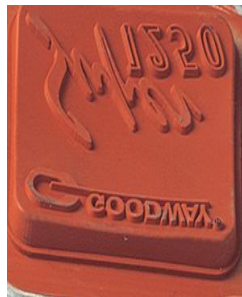
- Making appropriate fixture and install it one the working table of hot stamping machine
- Base on customer stamping document , Making copper-ZN metal plate or silicon rubber plate or silicon plain stamping plate and install it onto the upper heat plate of stamping machine;
- Choose correct stamping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

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