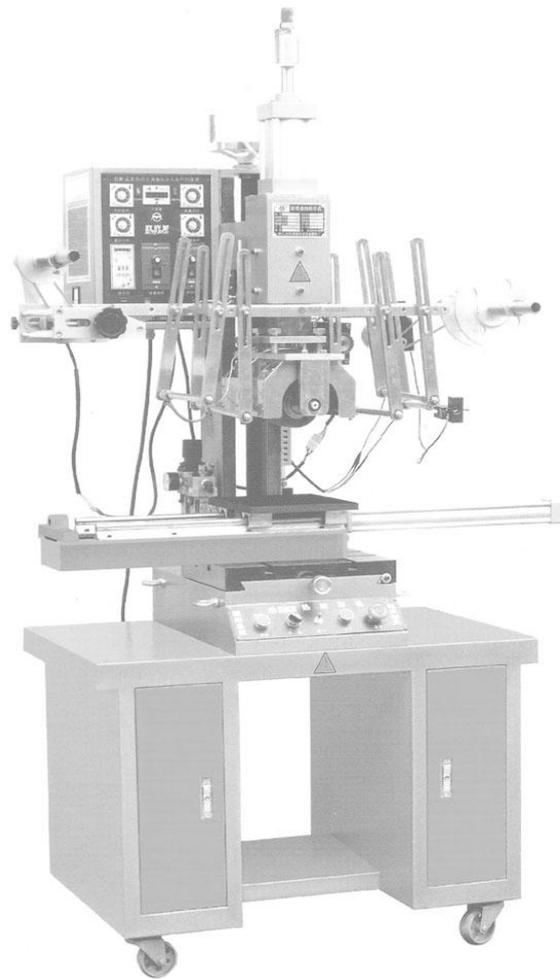




Operation Instructions

Heat transfer printing machine



Zhejiang Taizhou Huangyan Meitian printing supplier
factory

Dear customers:

Thanks for your choosing our heat transfer printing machine. We are professional producing all kinds of the automatic heat transfer printing machine, and bronzing machines. (Welcome you order by sending photos or samples) In order to build strong brand name "Meitian", we take the quality as our brand's life. "If others do not have, we have; if others have, we are the best." This is our brand's Philosophy. In order to satisfy the customers' requirement, we have been innovative, never relax our wills. This machine added five new functions: 1, "fine-tuning the black standard orientation" to change the original tradition problems, the advantage is to make the machine fast alignment; 2, "locking knob" is to prevent the nose down when less pressure which caused the silica gel damage or spend membrane volume into the silica gel. "Flat printed switch" could be energy saving and protect the relay. "count switch" should be off during debugging, it could improve the passing rate finished counting; 3, "stamping down smooth" to address some of the operator when the hand-bag anti- direction of the operation; 4, when we adjust the time stamping to 00s00, the machine can also be controlled directly by foot stamping time; 5, hot first trip cut position switch, the advantage is when we using the switch the stamping time is more accurate. 6, positioning standard, because of black ocelli of flowers membrane has tolerances, resulting in about stamping product positioning not allowed. With the standard positioning the operator can see the flowers membrane translocation, so the operator could adjust immediately.

These new functions could make the machine operators have become convenient, practical. Customers choose different features to operate the machine for different products, which could make the processing more efficient and the products with high quality.



Warning

If missing the following warnings and instructions may result in serious damage and loss

Warning:

1 careful of electric shock: the machine must be grounded! Electrical connections must follow the safety rules, when you inspect or clean the machine keeps the connection unplug! Please check the heating pipe work, solenoid valve connector and the other wire is exposed or off when you start!

2 burn care: during the work, if you touch the hot glue head, electric hood and other hot components may cause burns! Do not put your hands on silica gel to avoid crushing. If you want to replacement silicone, you must make the machine cool.

Unskilled workers do not use the foot switch, so as not to burn;

3 careful Fire: flammable materials away from the machine.

Notes:

1. Power supply voltage is 220V, 50HZ. Operating pressure is 0.4-0.6Mpa clean dry air source.

2. After the work or having a rest, the heat switch should be closed, do not cut off the power directly, so as to make hot glue head spin. This is to make the silica gel cool slowly to extend the life of silicone. If the work is half-way power failure, shall promptly remove the silicone to avoid burns.

3. Turn on the heating switch, to observe whether the silicone is turning, if not, should immediately check the stamping body; troubleshooting before they can work. Please heat the silicone into several shifts. We suggest 50 degrees by degrees.

4. Please choose the silicone with the diameter 38mm, outside diameter 100mm, hardness's 50-70 degrees. Avoid burning, burning crack, fracturing, all of these

problems could affect stamping effect. Silica gel should always use the fine sandpaper grinding.

5. Please test the emergency stop switch before the work, and check the machine locking screw whether loose.
6. During working process, please note the water in the air filter whether exceed the warning limit line. Please let stagnant water promptly go of. Avoid the solenoid valve damage because of the water leakage, which affect the using time of electromagnetic valve cylinder.
7. Check whether photoelectric eye liner is in the correct placement, so as to prevent breakage.
8. Please add special oil lubrication into oil filter to maintain pneumatic components
9. Switch off the count switch in the debugging
10. Please turn off the flat print switch when print the round products.
11. The machine is equipped with stamping reversible switch and collect foil reversible switch. (The switch is effective when using the slow speed of the motor).
12. minimum (start time) pressure of Pump must be over the set pressure of regulating valve of the machines, otherwise the stamping length is instable.
13. Nose "locking knob" should release, if the operator leave the machine, it must be locked. Locking function is to protect the nose to be down without enough air pressure which causes the damage.

I. Introduction

Heat transfer printing machine is a new type of printing machinery which makes the pre-printed flower pattern film transfer in various types of products through hot silicone. It is ideal equipment for surface processing industry because of high production efficiency and significant economic benefits. It is widely used in plastic products, stationery, cosmetics, toys, daily necessities, glass, ceramics, home appliances, wood crafts, and labels and so on.

The heat transfer products are colorful, color layer thick, rich three-dimensional

and strong adhesion. It could improve product quality, and increase product added value.

The machine can also be conducted on the above-mentioned items gilt decoration.

The Installation

First of all, you need familiar with all parts of the machine before the installation, commissioning has a direct impact on product quality and service life of machine parts (see diagram of the host structure).

(1) The base (table) must be fixed the horizontal place that must be against moisture. Rotate four supports of ground screws contact with the ground, and locking, so that keep the machine on horizontal plane.

(2) Put the host on the base (table), and using four 10MM screws get together and connected to the ground, so as to prevent electric shock.

(3) Loosen the three locking screws of the back nose; turn hand wheel on the top to make nose up to the need height, and then lock the screws.

(4) After ventilation adjust air pressure between the 0.4-0.6Mpa (based on product settings).

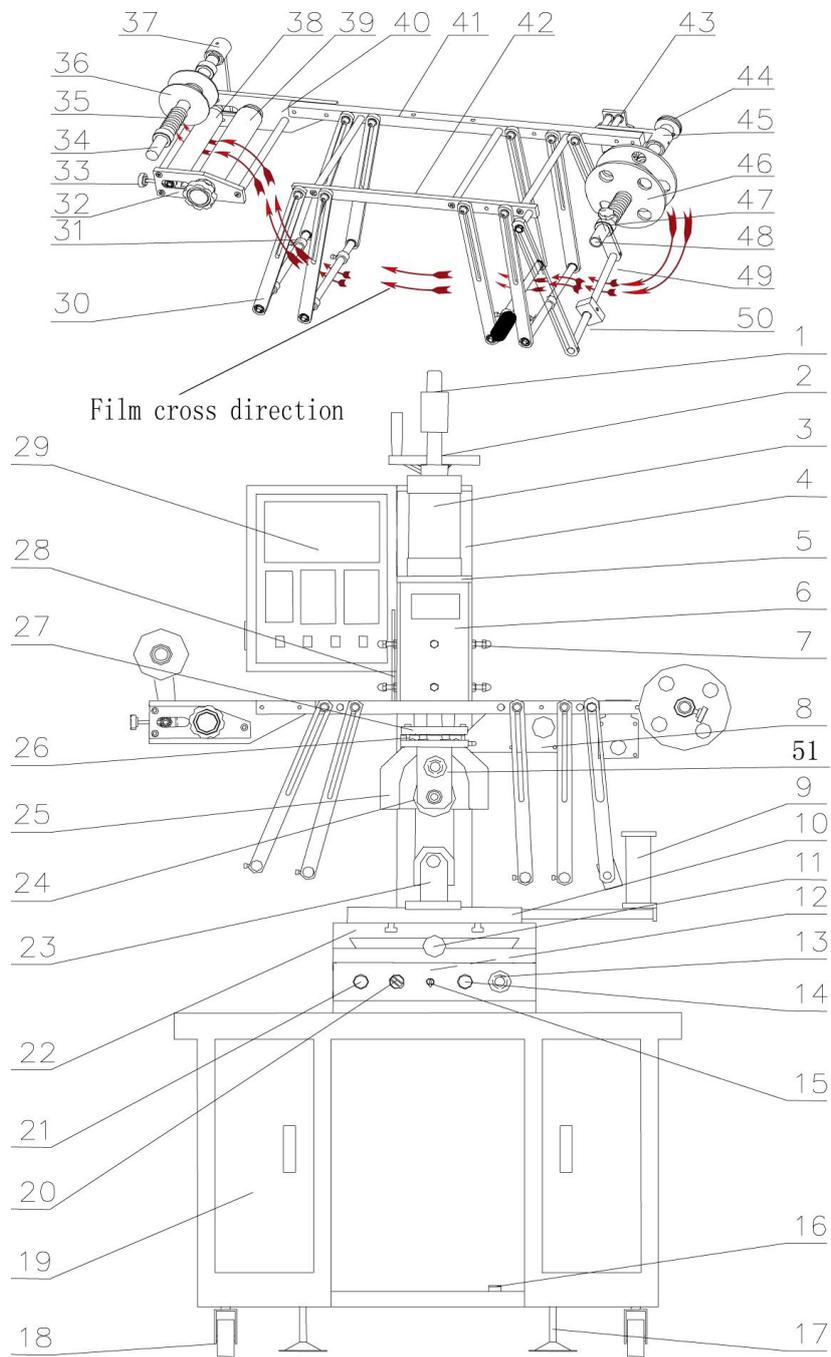
(5) Power on, and then debug the cylinder to be freedom of movement up and down. After that you have to set the table number of values to test the key functions.

(6) Test emergency stop switch whether closing membrane motor control, tension motors, cylinders which plays a protective role.

Precautions

1. It should be noted whether the body properly grounding before start, check whether bare wire or check off leakage;
2. Air pumps, air pressure, time to set the location of the switch components are normal;
3. Make sure that the Nose, silicone, mould, cylinder lock master, working placement and so on locked.
4. Check the butter of the nose, let the water in the pressure regulating value and go, add oil in lubricator, check whether the lubricator into the trachea to reach the oil valve, and check whether cylinder is lubricate.
5. Turn on the heat switch, check the main spindle of the silicone is rotating;
6. Check the collect foil system work.
7. Work in the safe environment

The host structure diagram



五、主机结构示意图

The introduction of host structure

serial number	The title	The function
1	fine-tuning nut	Fine-tuning the distance between the printed products with the iron part. It also means fine-tuning the work pressure.
2	Hand wheel lift	Turning the hand wheel can adjust lifting mechanism up and down motion according to the product level height adjust iron part position.
3	air cylinder	Driving the iron part movement. (up-down)
4	upright stanchion	Support the nose, electric boxes, lift share, etc.
5	Cylinder fixed plate	The connector of the cylinder and the nose.
6	The nose	It has the lifting arm, activity seats, locking block etc.
7	Adjustment screws	Adjust the nose moving space
8	The nose locking knob	Locking the nose, and protecting the nose down without air pressure.
9	Stamping motor	Through the chain drive silicone rotation, uniform heat
10	Gas-liquid damping cylinder	Transfer air pressure into hydraulic pressure.
11	Flat-printing cylinder	Drive the sliding table move the left-right direction
12	Carriage hand wheel	Adjust the platform
13	Grounding wire	play the security role when leakage
14	Emergency stop switch	Emergency stop working
15	Start button	Press once to auto-complete a work program
16	Tension switch	Flowers membrane tension

17	Foot switch	The same function as the start switch
18	Foundation screw	Fixed the equipment
19	Castor	Easy to move the equipment
20	Base	Installation the equipment body
21	Manual - Automatic switch	Manual control iron part movements; automate work processes
22	Start - try to membrane switch	Start, test membrane dual-use switch
23	Sliding table	Adjust the position of the film
24	Mould seat	The mould Installation
25	Silica gel	Transfer heat and pressure to spend the pattern printed film to the products
26	electric mantle	Installation of electric heating tubes, protecting thermal diffusion
27	Adjustment screw	adjust the horizontal level of the iron part and the product, during the regulation, they would first loosen the middle of the four M8 socket screw, adjust completed and then lock
28	adjustable plate	Connection the iron part with the sliding table.
29	PLC TIMING SYSTEM	The timing control system, you could adjust the stamping, film collecting, flat printing time in this system.
30	Conditioning block	Set the nose down to the lowest block point as the contact position for the movement
31	Travel rod	Block by loading stroke adjustment
32	Electric box	Control the operation of the machine. (see the controller instruction)
33	Collect foil adjustment screw	Adjust the film position
34	The membrane-axis	Burden the film
35	Collect film front board	Fixed knurled shaft and other parts

36	The screw of the collect film	Adjust the pressure of collecting film
37	Film-collecting axis	Recycle the used film
38	mechanical spring	Adjust the film-collect pressure
39	Film-collect board	Fixed the used film
40	Film-collect brace	Support the film-collect axis
41	Film-collect silicone	Tight the used film, so as to collect the film
42	Film-collect motor	Control the knurled shaft and motor rotation
43	Knurled shaft	Improve the film-collection
44	Film-collect back board	Fixed the film-collect motor and knurled shaft
45	Back beam	Connect with the nose in the up, from the left-right sides connect tension, film-collect parts.
46	Front beam	Support the film-collect screw
47	Tension-motor Mounting plate	Fixed the tension-motor
48	Tension-motor	Support the film with certain tension
49	Tension belt pulley	Transfer the tension
50	Tension axis brace	Burden the tension axis
51	Tension board	Adjust the silicone position(in or out)

Instructions for use

1. Connect with the air pump: adjust the air pressure between the 0.4-0.6Mpa. Check pump pressure should be above the minimum starting pressure regulator settings.
2. Switch on the power: the total power allocated on the 2P, opening the power

switch, click Start to complete a process of film-collect at the same time stamping motor starts to rotate.

3. Setting: Check the time setting (S is the second sign) whether meet the requirement of the stamping. According to the test, adjust the time value, set back along the direction of electrical stamping, motor down along the direction of film collecting. Count switch should be turned off before the qualified product.
4. Hand packaging: adjust the stamping time to Zero, and directly controlled by the foot switch, and also we can set the stamping time.
5. Tension: if you need to tight the film, switch the tension switch on. The tension is up to the spring elastic, and the film roll diameter.
6. Photoelectric switch: when film past the photoelectric switch, the machine will collect the film. When the black cursor of the film step into photoelectric switch, it will send a signal to film-collect motor, so as to immediately stop receiving income membrane. (If the photoelectric switch is too sensitive to easily send mistaken signal. Further more, if the switch with low sensitivity, it will not send signal. In this situation, we could adjust the fine tuning screw to achieve a reasonable need ➤ increase the sensitivity; ⬅ back direction of reduced sensitivity) please be carefully debugging, otherwise it may damage the photoelectric switch.
7. Machine debugging: determine the product stamping method (flat printing or roll printing). We take the rolling as an example, and give you brief debugging steps.
 - a. Custom the mould according to the different products. (Usually use the wooden mould or the aluminum mould). Install at the adjustable mould platform. The middle center of the printed product must be vertical with the middle of silicone. Must be strictly aligned around.
 - b. Set the distance of pressure of the cylinder. Generally the space of silicone and the products must be controlled about 60mm. if you need to adjust, loosen the three locking screws behind the nose. After that, turn hand-rotated to fit the scope, and then lock the nose. If you want to change the pressure, you can directly adjust cylinder tuning nuts. By the way, you have to adjust

the limited position so as not to make limit switch malfunction.

- c. Turn the manual-automatic switch to the manual. Press the start, and check whether the iron part is parallel with the printed products. If not, adjust the mould seat angle to achieve parallel. Different products and different temperature would use different stamping pressure.
- d. The space of the film and product is usually between 10-40mm. if the space too close to the silicone, the film is easy to be wrinkle. The left-right adjustment is center-right 10mm to 20mm of the picture left side and the silicone. Adjust the photoelectric switch, and then press the film-test (start) button once, the machine will finish one process of the setting.
- e. Turn the temperature switch, temperature controller is set 100 degrees for the first time, if the light of the temperature controller is green, it means heating element is working. If the light turns red, which means the temperature is achieving the set degree. At the same time, the silicone must be hot at outside and cool inside. If we continue heating, it will destroy the silicone. For this reason, you had better stop for a while, make the silicone have a heated process.
- f. Procedure: when we finish the above steps, put a product into the mould, and press work button (automatic), the nose will fall down to begin stamping. In the same time, the film-collect delay starts to time. When achieve the delayed time, film-collect timing begin to time and film-collect motor begin rotate. Meanwhile, the nose down to touch the overtravel-limit switch, stamping-timing begins to time. When finish timing, the nose goes up until the film-collect timing finished or the photoelectric switch sends the signal. Film-collect motor will accept the first instructions to stop collecting film. After this, we could remove the product, and complete a program.

Note: (1) the nose must finish the stamping before the end of the film-collect. (2) If the nose when fall down does not bump against the limit switch cause time stamping does not work. The nose will never rise, then immediately turn on the emergency stop switch, adjust the trip. (3) If the motor speed, time, and temperature is not harmonized, it will impact on the quality of the stamping. (4) Stamping motor too fast, the temperature over

the bottom, the pressure is too small, if there is a non-compliant with the flower pattern on the membrane adhesion appears low.

Optional accessories

1. Sliding table: if the products need the sliding table to do the flat stamping or rolling stamping, you need equip the sliding table on the platform. It consists of two five-solenoid valve, low oil pressure cylinder, liquid converter, one-way throttle valve and other components.
2. Moulds: it depends on your product.
3. Silicone: this is the transfer the heat, so as to make the picture on the film transfer into the products.

Machine maintenance

1. Clean: you have to clean the platform of the machine after work. Keep the machine clean.
2. Lubrication: you have to add lubricating oil on every trail when you start to work.

The reference of Troubleshooting

The accident, and the reasons	Troubleshooting
Collect the film is not in correct position	To extend the closing film ahead of time, or check the optical signal
Black ocelli pass the photoelectric	Reduce the stamping time or reduce the stamping or film collect motor speed/

The color of black ocelli is too light, which cause the photoelectric do not work	Fine-tuning the photoelectric sensitive
The cylinder pressure is instability, which impact on the stamping quality	Adjust the air pressure of the pump
Stamping time is too short, which makes the printing do not complete.	Extend the stamping time.
The silicone slip makes the printing incomplete	Lock the silicone
The photoelectric is too sensitive, which send wrong signal	Adjust the photoelectric sensitive
Poor quality films occurs low adhesion	Change the film
The product is not clean, with water, oil.	Change the product
The beginning of the picture is over the center of silicone or deviation to right, which make the printing incomplete	Move the picture about 10-20mm from the center of the silicone to right side,
travel switch of the nose is not mixed up	Adjust the travel switch
Excessive pressure, mold rotation is not flexible, the sliding table become slow down or unstable	Adjust the air pressure, fine-tuning nut and repair mold
The film become wrinkled	Reduce a reasonable temperature or adjust the space of silicone and the film
Higher temperature and tension make film damage	Reduce the temperature and tension



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