

# 全自动椭圆丝网印花机

## Full automatic oval screen printing machine

作业指导书 Operation Manual v2.0



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## 导读 Preface

感谢您购买我公司全自动椭圆丝网印花机，在使用机器前应认真阅读本指导书。机器相关操作人员应具备本机或同类型印花机使用经验，且具备良好的安全意识。未具有相关经验的操人作员，应在专业人员的陪同下进行作业，不能擅自操作机器，如果擅自操作机器造成人生安全事件或机器损坏事件，本公司不承担任何责任。为了保证安全，机器运作中严禁无关人员靠近机器、操作机器、打开机箱、进入机器危险空间等动作。如机器运行中出现故障，请及时联系公司电工或机修。维修时特别注意人身安全，切具备一定的自动化设备维修经验，如仍然无法解决，请即时通知我公司，以便于我公司安排维护人员。在保修期内，除人为损坏或不可抗拒的自然灾害以外，我们为您免费提供维护，如已超出保修期，我们会收取合理费用。在机器的使用过程中有任何疑问和建议，请联系我们，我们会本指导书会随着时间的推移，在文字内容上，进行增加或删减，我们不在另行知会！如想了解公司最新的机器行情，请及时联系我们以索取最新资料。

真诚聆听，我们希望能给客户一台实实在在的、稳定的、效率的、精准的机器！

Dear Customer,

Thank you for choosing our oval screen printing machine. Please read this instruction carefully before using the machine. The operator of the machine should have the experience of using this machine or the same type of printing machine, and have a good sense of safety. The operator who doesn't have the related experience should be accompanied by professional personnel to operate, and can not operate the machine without authorization, if life safety incident or machine damage incident caused by unauthorized operation of the machine, our company will not assume any responsibility. If the machine is running fault, please contact the company electricalian. In the maintenance, please pay special attention to personal safety, and have a certain degree of automation equipment maintenance experience, if still can not be resolved, please notify my company, so that our company will arrange maintenance personnel. During the warranty period, we will provide you with free maintenance, except for man-made damage or irresistible natural disasters. If your machine has exceeded the warranty period, we will charge a reasonable fee. If there is any question or suggestion in the use of the machine, please contact us.

Due to our policy of continuous improvement we reserve the right to add or omit specifications without further notice. Therefore certain parameters may differ slightly from the model detailed in this instruction. For any further question or suggestion, please contact us.

We all ears, we hope to give you a reliable, stable, efficient and high-registration machine!

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## 运行前注意事项 Safety Instruction

通电开机前，请务必检查以下事项：

Before powering on, be sure to check the following:

**1: 检查电源：**三相五线 AC 380V，切可靠接地。

**1: Check the power supply:** Three-phase five-wire AC 380V, earth wire need to be connected.

**2: 检查气源：**气压不小于 0.6 Mpa / 6 kg 。

**2: Check the gas source:** Air pressure should not be less than 0.6 Mpa / 6 kg.

**3: 检查台面：**所有台面上不能有异物，如镙丝、工具、浆料桶、夹具、手机、工作服等。

**3: Check the pallet:** All the pallets can not have any other things, such as screws, tools, bucket bucket, fixtures, mobile phones, uniforms and so on.

**4: 安全检查：**注意是否有人在维修机器，是否有人处于机器下方和半圆内等危险空间作业。

**4: Safety checking:** Check whether someone in the maintenance of the machine, whether someone is working in dangerous spaces such as under the machine or in the semicircle.

**5: 检查报警：**查看操作中心是否有报警未解决，急停是否解除。

**5: Check the alarm:** Check whether there is an unresolved alarm in the operation center, and whether the emergency stop is released.

\* **6: 检查烤箱：**烤箱高度不应低于或贴近台板，烤箱发热面应高于台板 2cm 以上。

\* **6: Check the oven:** The height of the oven should not be lower than or close to the pallet, and the heating surface of the oven should be higher than the pallet 2cm or more.

\* **7: 检查压烫机：**检查压烫机气源，压烫板是否升起，压烫机信号线是否插入，操作中心压烫机开关是否开启。

\* **7: Check the heat pressing machine:** Check the air supply of the heat pressing machine, whether the press plate is raised, whether the press machine signal line is inserted, and whether the pressing machine switch of the operation center is turned on.

\* **8: 检查植绒机：**检查植绒机气源，植绒头是否升起，植绒头开关是否打开。（选购）

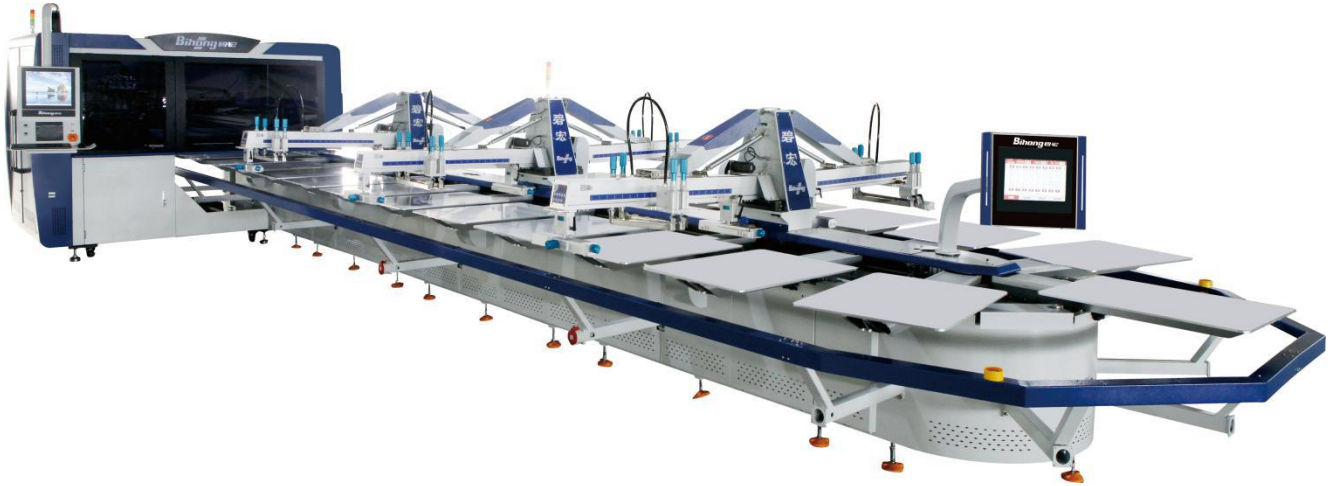
\* **8: Check the flocking machine:** Check the gas source of the flocking machine, whether the flocking head is raised, and whether the flocking head switch is turned on. (Optional)

\* **9: 检查数码机：**检查数码印花机气源，数码印花机印头是否处于原点位上，数码印花机信号线是否插入，数码印花机是否报警。（选购）

\* **9: Check the digital printing machine:** Check the gas source of the digital printing machine, whether the print head of the digital printing machine is on the origin, whether the signal line of the digital printing machine is

inserted, and whether the digital printing machine is alarming. (Optional)

## 1. 机器结构 Machine Construction



椭圆印花机由控制系统、传动机构、印刷机构、台车组四大部分组成。

The oval screen printing machine consists of four parts: control system, transmission mechanism, printing mechanism, and trolley sets.

### 1.1. 控制系统 control system

主控系统采用进口高端可编程控制器和大规模集成电路组成，各印头之间采用工业高速网路连接，自主研发控制主板，高度集成化的电控系统，95%以上的进口电气部件，使得稳定性大幅度提高的同时，故障的维修变的异常快捷。

The main control system adopts imported high-end programmable controller and large-scale integrated circuit, the printing head between the use of industrial high-speed network connection, independent research and development control board, highly integrated electronic control system, more than 95% of imported electrical components, making a substantial increase in stability at the same time, the failure of the maintenance becomes unusually fast.

先进的控制中心，人性化的互动体验，无需过多学习，就能完全掌握，控制中心负责对整机的行为管理，如驱动台车和对印头动作的监视、调节作用，及各种外接设备的接驳。如：压烫机、植绒机、数码机等等。

Advanced control center, user-friendly interactive experience, operator is able to fully grasp the skills without too much learning. The control center is responsible for the behavior management of the whole machine, such as the monitoring and regulating effect of the driving trolley on the printing head movement, and the connection of various external devices. Such as: pressing machine, flocking machine, digital machine and so on.

## 1.2. 传动机构 transmission mechanism

吸收了先进的国外同行经验，采用无链条传动结构，每个台车间，采用高强度合金钢链杆连接，链杆结构具有抗拉长、抗变形、间隙小、精度高等优点，平均寿命数倍于链条寿命。好马配好鞍！驱动部分采用一台进口具有 17 位光学编码器的伺服电机，搭配一台高性能进口滚柱减速机组成（非行星减速机），加上一体化 CNC 成形圆弧导轨，驱动部分的平均无故障时间可达数万小时。

Adopting the experience of advanced foreign counterparts, we use the chainless transmission structure, each workshop is made of high strength alloy steel chain connecting rod chain structure with anti-elongation, anti-deformation, small gap, high precision, its average life is the chain life several times. The drive part uses a servo motor with 17-bit optical encoder, with a high-performance imported roller reducer (non-planetary reducer), plus integrated CNC forming arc guide, the trouble-free average time of drive part is up to tens of thousands of hours.

## 1.3. 印刷机构 printing mechanism

每个印头由一台伺服电机驱动，具有速度快，噪音小，行走平稳，印刷行程可根据客户花型需要，任意调节长度。刮刀由精密调压阀控制，刮印压力可随意调节。网框采用气锁方式，可快速上下网框，网框的前、后、左、右、上、下均可调节。如在使用中将网框取下清洗，重新上回时，无需重新对版，即可印货，正常操作时，将印头抬高，即可擦洗。斜壁式的印头结构，不只是利于操作，也特别适用于成衣的印刷，可以将成衣直接套于台板上印刷。

Each print head is driven by a servo motor, with fast speed, low noise, smooth walking, printing stroke can be adjusted according to customer needs. Scraper is controlled by the precision pressure regulator valve, scratching and printing pressure can be adjusted optionally. Screen frame adopts the air lock way, you can take screen frame up/down quickly. If you remove the screen frame(when printing) to clean, re-back, no need to re-version and can print directly; maintain the normal operation, just raise the print head and scrub. Sloping wall design of the print head structure, not only conducive to the operation, but also particularly suitable for the printing of clothing that can be directly placed on the station to be printed.

## 1.4. 台车组 Trolley Sets

一台 16 色机型，具有 54 块台板，比一般 16 色机多出两块台板，分别在线体两端，增加的两个工位，方便铺布和收布时人手的不足和清洗台面时人员的操作。台车支撑体，具有三梁结构，比一般口字型结构中间多出一个支撑，可防止长期使用中台车的扭曲变形，使印花套位更加精准。

A 16-color model with 54 platens, more than the average 16-color machine two stations, respectively, at both ends of the machine, the two additional stations to facilitate the spreading and collection of cloth when the shortage of staff and easy cleaning table operation. The trolley support has a three-beam structure, which is one more support than the middle of the mouth structure to prevent the long-term use of the trolley from being twisted, to get a higher-registration printing effect.

## 2. 控制中心 Control center

控制中心采用进口高性能人机界面和公司自主研发高效且人性化的控制系统，负责整机动作的协调、监视、参数录入、报警处理等操作，也包括对外部扩展设备的通信、控制、接驳。每个印头，还具有一个精简版的控制中心，以方便远程时的快速操作。

The control center adopts the imported high-performance human-computer interface and the independent research and development system, which is responsible for the coordination, monitoring, parameter entry and alarm processing of the whole machine. It also includes the communication, controlling and connection of the external extension equipment. Each print head has a compact control center to facilitate fast operation at a remote location.



2.1. 主控画面 Master screen

2020/08/14  
13:53:56    铺布延时 56.0    计数器 23456 X    前一小时 3456

9 6 Round ▲ 6 ▼ 6	10 6 Round ▲ 6 ▼ 6	11 6 Round ▲ 6 ▼ 6	12 6 Round ▲ 6 ▼ 6	13 6 Round ▲ 6 ▼ 6	14 6 Round ▲ 6 ▼ 6	15 6 Round ▲ 6 ▼ 6	16 6 Round ▲ 6 ▼ 6
▲ 6 ▼ 6 6 Round	▲ 6 ▼ 6 6 Round	▲ 6 ▼ 6 6 Round	▲ 6 ▼ 6 6 Round	▲ 6 ▼ 6 6 Round	▲ 6 ▼ 6 6 Round	▲ 6 ▼ 6 6 Round	▲ 6 ▼ 6 6 Round
8	7	6	5	4	3	2	1

总产量: 1234567890

<b>主画面</b>	印刷参数	速度设定	报警检查
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2020/08/20  
15:59:32    DELAY 56.0    COUNTER 23456 X    HOURAGO 3456

9 6 Round ▲ 6 ▼ 6	10 6 Round ▲ 6 ▼ 6	11 6 Round ▲ 6 ▼ 6	12 6 Round ▲ 6 ▼ 6	13 6 Round ▲ 6 ▼ 6	14 6 Round ▲ 6 ▼ 6	15 6 Round ▲ 6 ▼ 6	16 6 Round ▲ 6 ▼ 6
▲ 6 ▼ 6 6 Round	▲ 6 ▼ 6 6 Round	▲ 6 ▼ 6 6 Round	▲ 6 ▼ 6 6 Round	▲ 6 ▼ 6 6 Round	▲ 6 ▼ 6 6 Round	▲ 6 ▼ 6 6 Round	▲ 6 ▼ 6 6 Round
8	7	6	5	4	3	2	1

TOTALOUTPUT : 1234567890

<b>MAIN</b>	PARAMETER	SPEED	ALARM
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▲单击主画面按钮，出现下方操作条，在次点击关闭操作条。

Click the main screen button, then shows the operation bar, click again to close the action bar.

▲单击主画面印头按钮，出现上方操作条，绿色表示印头开启。

Click the print head button on the main screen, the upper operation bar appears, green means the print head is on.

**功能介绍 Function:**

**铺布延时 0.0 DELAY** 自动运行时，所有电源打开的印头印刷完成后，台车会等待此时间到达后，方可行走下一次台车，用于在人员铺布时不熟练或布型复杂需要较长时间铺布时使用。如设置为 0，则所有开启的印头完成后，马上开始下一回合，无需等待。（单位：0.1 秒）

Automatic operation, after all the working print head complete the printing, the trolley will not go for another station until time is up, which facilitates the staff's spreading cloth in case he's unskillful or cloth type is complex. If set to 0 second, then after all the print heads finish printing, the next round will start immediately without waiting. (Unit: 0.1 second)

**计数器 0 COUNTER** 用于工作时计数，如白班、夜班，下班时可用于统计数量，仅作为参考数据！如需清除，长按数值后面的红色小叉即可。

Be used for counting working hour when off duty, such as day shift, night shift, but is only for reference! To clear, click the red dot behind the value.

**件/小时 0 HOURAGO** 从开机时间累计，显示前一小时生产数量，仅作为参考数据！数值为单向显示，不可手动变更。

From the boot time to accumulate, showing the previous hour's production capacity, which is only as a reference data! The value is one-way display and can not be changed manually.

内侧感应器信号 Inner Sensor Signal ◆



- ◆ 定位信号 framing signal
- ◆ 印刷次数 Printing Times
- ◆ 印刷速度等级 Printing Speed Level
- ◆ 覆墨速度等级 Ink-covering Speed
- ◆ 外侧感应器信号 Outer Sensor Signal
- ◆ 印头号 Printing Head Number

**主画面 MAIN**

用于打开和关闭主画面操作条，或在其它页面时返回主画面。

Used to open and close the main screen operation bar, or return to the main screen in other pages.

印刷参数

PARAMETER

进入与印刷参数相关的画面，参见 2.3 印刷参数

Enter the screen related to printing parameters, see 2.3 Printing Parameters

速度设定

SPEED

进入与速度相关的画面，参见 2.4 印刷速度

Enter the screen related to the speed, see 2.4 Printing Speed

报警检查

ALARM

进入与报警相关的画面，参见 2.5 报警检查

Enter the screen related to alarm, see 2.5 Alarm and Check

运行

RUN

等于 equal to



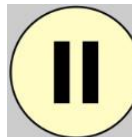
**运行按钮：**启动后机器自动运行，如机器未作回原点操作时，会先作回原点操作后运行机器，且操作中心没有任何暂停和报警信号，电源打开的印头，会按照所设定的模式和参数印刷。

**Operation Button:** After the machine starts, it will run automatically, if the machine does not return to the original operation, it will run back to the original operation first, and there is not any pause and alarm signal in the operation center, the powered print head print according to the set mode and parameters.

停止

STOP

等于 equal to



**停止按钮：**功能生效时，机器运行完当前回合后停机。如按钮未解除时，无法自动运行和走板。

**Stop button:** When the function is in effect, the machine will stop after running the current turn. If the button is not released, it can not run automatically and run the board.

前进

←FOR  
WARD

等于 equal to



**前进按钮：**台板向前走一个工位，如机器未作回原点操作时，会先作回原点操作，且操作中心没有任何暂停和报警信号。

**Forward button:** The platen goes forward a station, the machine will return to the original operation first if haven't returned, and there is not any pause and alarm signal in the operation center.

后退

BACK→  
WARD

等于 equal to



**后退按钮:** 台板向后走一个工位, 如机器未作回原点操作时, 会先作回原点操作, 且操作中心没有任何暂停和报警信号。

**Backwards button:** The platen goes backward a station, the machine will return to the original operation first if haven't returned, and there is not any pause and alarm signal in the operation center.



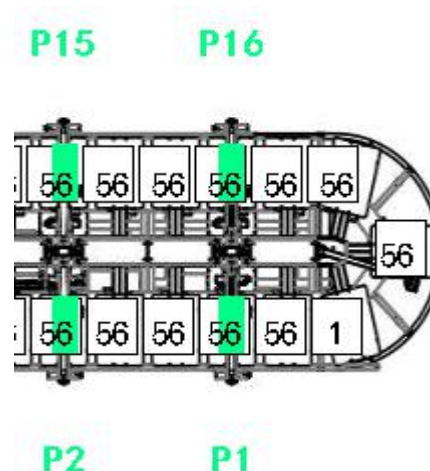
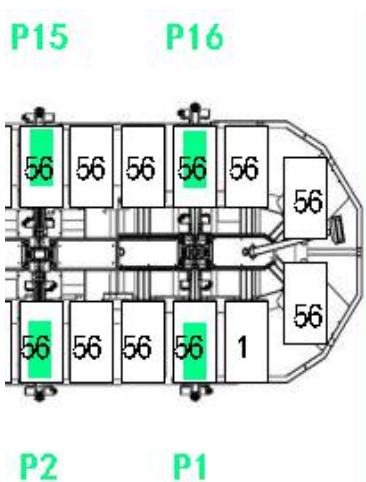
在显示屏选定好要开启的印头, 点击开始印按钮, 机器会选定台板为起始印刷。这块台板走到开启的印刷头后, 印刷头才会工作。如下两图: 请根据圆弧台板数量, 圆弧 1 号台板开始印。

Select the print head to be turned on on the display screen, click the start printing button, and the machine will select the platen as the start printing. The printing head will not work until this platen reaches the opened printing head. The following two pictures: Please start printing on the arc 1 platen according to the number of arc platens.

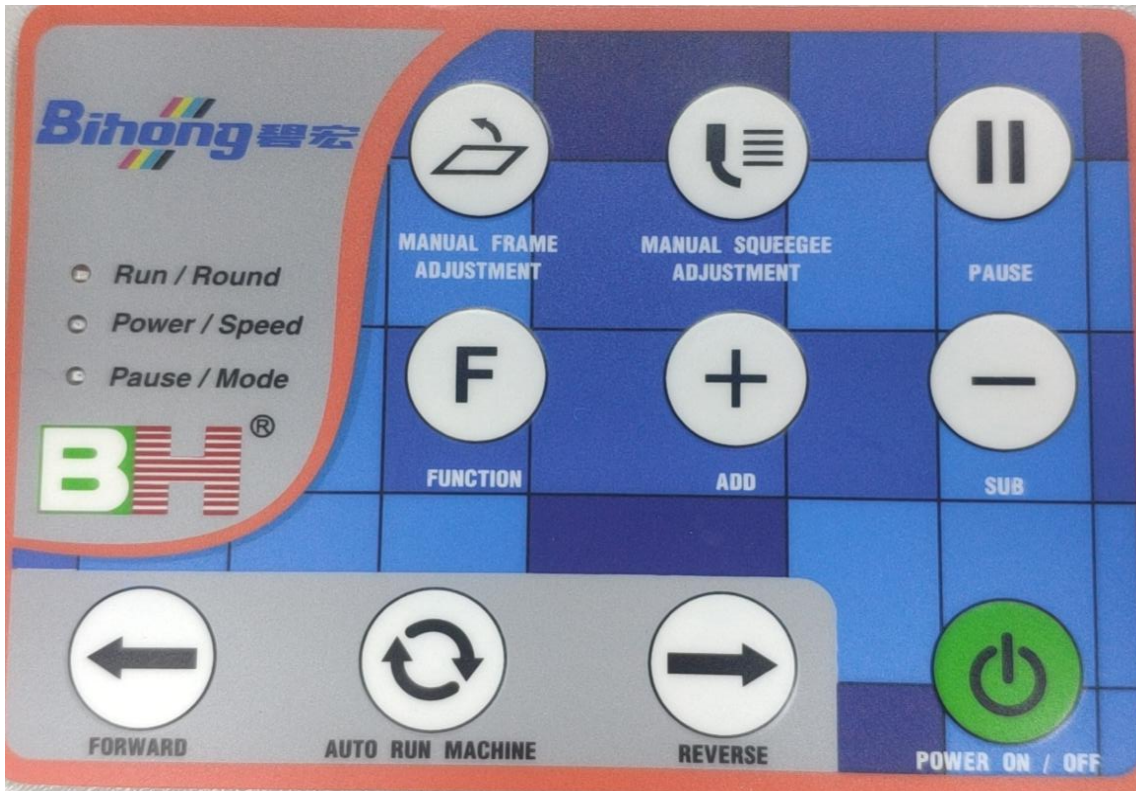


在印刷完成时, 在显示屏点击收板按钮, 机器会自动默认一块台板为停止起点, 当这块台板行走到任何印刷头时, 印头会自动关闭, 刮刀停在内侧。机器运行一圈后自动停止。自停起点如下两图: 1 号台板

When the printing is finished, click the button of receiving plate on the display screen, the machine will automatically default a platen as the stop starting point. When this platen reaches any printing head, the printing head will automatically close and the scraper will stop on the inside. The machine stops automatically after one revolution. The starting point of automatic stop is as follows:



2.2. 印头面板 Print head panel



功能介绍 Function:

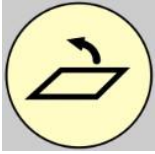
- Run / Round
- Power / Speed
- Pause / Mode

- ◆ 运行指示灯：自动运行时亮起，绿灯；  
Running indicator light: the green light will light up when running automatically;
- ◆ 电源指示灯：当前印头打开时亮起，红灯  
Power indicator light: The red light will light up when open the current print head;
- ◆ 暂停指示灯：当前印头暂停时亮起，黄灯  
Pause indicator light: The yellow light will light up when current print head pause.



**电源按钮：**用于开启或关闭当前印头，关闭后自动运行时不动作，如印头报警发生时，关闭后不触发报警。电源按钮具备本印头急停功能，如电源关闭时，本印头无论处于哪个状态，将立即停止当前动作。

**Power button:** used to turn on or off the current print head, when turn off then automatic operation stops, if the print head alarm occurs, it does not trigger the alarm after turning off. Power button has the print head scram function, if the power is off, the print head will immediately stop the current action no matter in which state.



**网框按钮:** 用于将网框抬升或下降, 手动操作时用于调试和对版, 自动运行时不可用。

**Screen frame button:** used to uplift or drop the frame, to register and debug when operating manually(unavailable for automatic operation).



**刮印按钮:** 控制刮刀的印刷和覆墨, 手动操作时用于调试和对版, 自动运行时不可用。

**Squeegee button:** Control the printing and flooding of scraper, to register and debug when operating manually(unavailable for automatic operation).



**设置按钮:** 此按钮按一下 Run/Round 灯闪烁时设置刮刀次数, 再按一下 Power/Speed 灯闪烁时设置刮刀度, 再按一下 Pause/Mode 灯闪烁时设置回墨速度

**Setting Button:** Click the button and set the squeegee times when Run/Round lights up, click again and set the squeegee angle when Power/Speed lights up; click once more and set the covering ink speed when Pause/Mode lights up.



**参数按钮:** 加

**Parameters button:** add

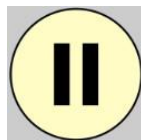


**参数按钮:** 减

**Parameter button:** minus



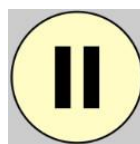
松网框 等于



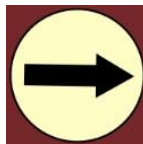
+



紧网框 等于



+



**网框松紧按钮:** 取网时应先松开气锁, 而上网后应把气锁夹紧, 如遗忘锁紧, 自动运行时, 机器也会帮你锁紧。

**Screen Frame elastic button:** the air lock should be loosened first when take down the screen frame, and clamp the air lock after putting up the frame, if forgot to lock, the machine also will help to lock in automatic operation.

其它按钮的功能, 请参见 第9页

For the functions of other buttons, please see page 9

### 2.3. 印刷参数 Printing parameters

印刷次数	印刷模式	延时设定	植绒设定	压烫设定	台板设定	高级设定	
9 6 Round + - + - 6 Round 8	10 6 Round + - + - 6 Round 7	11 6 Round + - + - 6 Round 6	12 6 Round + - + - 6 Round 5	13 6 Round + - + - 6 Round 4	14 6 Round + - + - 6 Round 3	15 6 Round + - + - 6 Round 2	16 6 Round + - + - 6 Round 1
主画面	<b>印刷参数</b>	速度设定	报警检查				

PRINTING ROUND	PRINTING MODE	DELAY SET	FLOCKING EQUIPMENT	HOTPRESS EQUIPMENT	PLATEN SET	ADVANCED SETTINGS	
9 6 Round + - + - 6 Round 8	10 6 Round + - + - 6 Round 7	11 6 Round + - + - 6 Round 6	12 6 Round + - + - 6 Round 5	13 6 Round + - + - 6 Round 4	14 6 Round + - + - 6 Round 3	15 6 Round + - + - 6 Round 2	16 6 Round + - + - 6 Round 1
MAIN	<b>PARAMETER</b>	SPEED	ALARM				

功能介绍 Function introduction:

印刷次数	PRINTING ROUND	设定印头印刷次数。To set the printing times of print head.
印刷模式	PRINTING MODE	设定印头印刷模式。To set the printing mode of print head.
延时设定	DELAY SET	设定印头动作时间相关参数。To set the action time and other related parameters of the print head.
植绒设定	FLOCKING EQUIPMENT	设定可选配套设备植绒机相关参数。To set the related parameters of flocking machine.
压烫设定	HOTPRESS EQUIPMENT	设定可选配套设备压烫机相关参数。To set the related parameter of press machine.
高级设定	ADVANCED SETTINGS	进入高级设定画面。Enter advanced setup screen.

### 2.3.1. 印刷次数 Printing times



印刷次数	印刷模式	延时设定	植绒设定	压烫设定	台板设定	高级设定	
<b>9</b> 6 Round + -	<b>10</b> 6 Round + -	<b>11</b> 6 Round + -	<b>12</b> 6 Round + -	<b>13</b> 6 Round + -	<b>14</b> 6 Round + -	<b>15</b> 6 Round + -	<b>16</b> 6 Round + -
<b>8</b> + - 6 Round	<b>7</b> + - 6 Round	<b>6</b> + - 6 Round	<b>5</b> + - 6 Round	<b>4</b> + - 6 Round	<b>3</b> + - 6 Round	<b>2</b> + - 6 Round	<b>1</b> + - 6 Round
主画面	<b>印刷参数</b>	速度设定	报警检查				

PRINTING ROUND	PRINTING MODE	DELAY SET	FLOCKING EQUIPMENT	HOTPRESS EQUIPMENT	PLATEN SET	ADVANCED SETTINGS	
<b>9</b> 6 Round + -	<b>10</b> 6 Round + -	<b>11</b> 6 Round + -	<b>12</b> 6 Round + -	<b>13</b> 6 Round + -	<b>14</b> 6 Round + -	<b>15</b> 6 Round + -	<b>16</b> 6 Round + -
<b>8</b> + - 6 Round	<b>7</b> + - 6 Round	<b>6</b> + - 6 Round	<b>5</b> + - 6 Round	<b>4</b> + - 6 Round	<b>3</b> + - 6 Round	<b>2</b> + - 6 Round	<b>1</b> + - 6 Round
MAIN	<b>PARAMETER</b>	SPEED	ALARM				

功能介绍 Function:



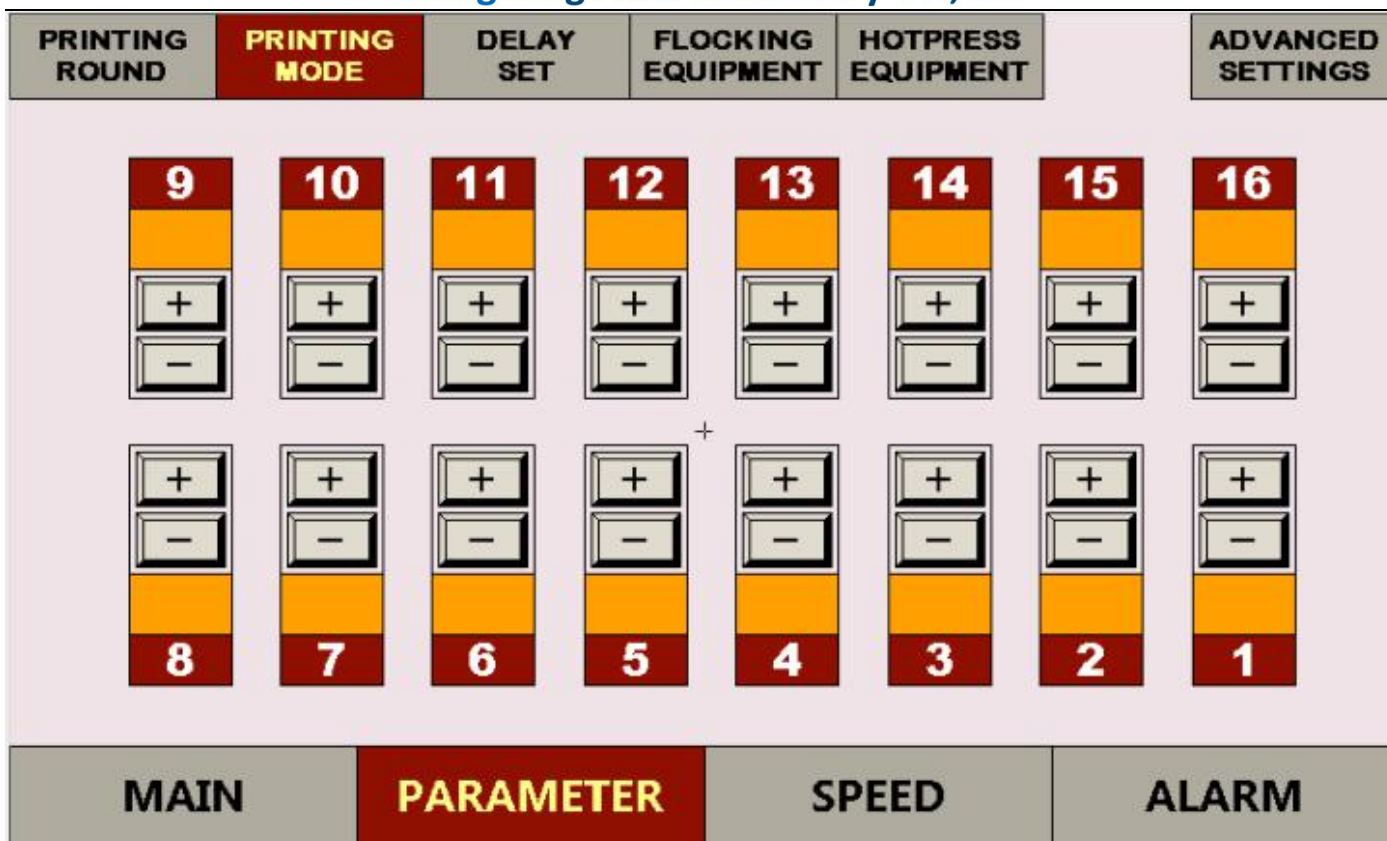
- ◆ 刮刀次数加 Add the number of scraping
- ◆ 刮刀次数减 Reduce the number of scraping
- ◆ 印刷次数 Print Head Times
- ◆ 印头号 Print Head Number

设定印头印刷次数，每个印头可单独设定。（设定范围 1—7 次）

To set the printing times of print head, each print head can be set individually. (Setting range 1-7 times)

2.3.2. 印刷模式 Printing Mode

印刷次数	印刷模式	延时设定	植绒设定	压烫设定	高级设定																																																		
<table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 12.5%; background-color: #800000; color: white; text-align: center;"><b>9</b></td> <td style="width: 12.5%; background-color: #800000; color: white; text-align: center;"><b>10</b></td> <td style="width: 12.5%; background-color: #800000; color: white; text-align: center;"><b>11</b></td> <td style="width: 12.5%; background-color: #800000; color: white; text-align: center;"><b>12</b></td> <td style="width: 12.5%; background-color: #800000; color: white; text-align: center;"><b>13</b></td> <td style="width: 12.5%; background-color: #800000; color: white; text-align: center;"><b>14</b></td> <td style="width: 12.5%; background-color: #800000; color: white; text-align: center;"><b>15</b></td> <td style="width: 12.5%; background-color: #800000; color: white; text-align: center;"><b>16</b></td> </tr> <tr> <td style="background-color: #ffcc00;">覆墨模式</td> <td style="background-color: #ffcc00;">覆墨模式</td> <td style="background-color: #ffcc00;">覆墨模式</td> <td style="background-color: #ffcc00;">覆墨模式</td> <td style="background-color: #ffcc00;">覆墨模式</td> <td style="background-color: #ffcc00;">覆墨模式</td> <td style="background-color: #ffcc00;">覆墨模式</td> <td style="background-color: #ffcc00;">覆墨模式</td> </tr> <tr> <td style="border: 1px solid black; text-align: center;">+</td> <td style="border: 1px solid black; text-align: center;">+</td> <td style="border: 1px solid black; text-align: center;">+</td> <td style="border: 1px solid black; text-align: center;">+</td> <td style="border: 1px solid black; text-align: center;">+</td> <td style="border: 1px solid black; text-align: center;">+</td> <td style="border: 1px solid black; text-align: center;">+</td> <td style="border: 1px solid black; text-align: center;">+</td> </tr> <tr> <td style="border: 1px solid black; text-align: center;">-</td> <td style="border: 1px solid black; text-align: center;">-</td> <td style="border: 1px solid black; text-align: center;">-</td> <td style="border: 1px solid black; text-align: center;">-</td> <td style="border: 1px solid black; text-align: center;">-</td> <td style="border: 1px solid black; text-align: center;">-</td> <td style="border: 1px solid black; text-align: center;">-</td> <td style="border: 1px solid black; text-align: center;">-</td> </tr> <tr> <td style="background-color: #ffcc00;">覆墨模式</td> <td style="background-color: #ffcc00;">覆墨模式</td> <td style="background-color: #ffcc00;">覆墨模式</td> <td style="background-color: #ffcc00;">覆墨模式</td> <td style="background-color: #ffcc00;">覆墨模式</td> <td style="background-color: #ffcc00;">覆墨模式</td> <td style="background-color: #ffcc00;">覆墨模式</td> <td style="background-color: #ffcc00;">覆墨模式</td> </tr> <tr> <td style="background-color: #800000; color: white; text-align: center;"><b>8</b></td> <td style="background-color: #800000; color: white; text-align: center;"><b>7</b></td> <td style="background-color: #800000; color: white; text-align: center;"><b>6</b></td> <td style="background-color: #800000; color: white; text-align: center;"><b>5</b></td> <td style="background-color: #800000; color: white; text-align: center;"><b>4</b></td> <td style="background-color: #800000; color: white; text-align: center;"><b>3</b></td> <td style="background-color: #800000; color: white; text-align: center;"><b>2</b></td> <td style="background-color: #800000; color: white; text-align: center;"><b>1</b></td> </tr> </table>								<b>9</b>	<b>10</b>	<b>11</b>	<b>12</b>	<b>13</b>	<b>14</b>	<b>15</b>	<b>16</b>	覆墨模式	覆墨模式	覆墨模式	覆墨模式	覆墨模式	覆墨模式	覆墨模式	覆墨模式	+	+	+	+	+	+	+	+	-	-	-	-	-	-	-	-	覆墨模式	覆墨模式	覆墨模式	覆墨模式	覆墨模式	覆墨模式	覆墨模式	覆墨模式	<b>8</b>	<b>7</b>	<b>6</b>	<b>5</b>	<b>4</b>	<b>3</b>	<b>2</b>	<b>1</b>
<b>9</b>	<b>10</b>	<b>11</b>	<b>12</b>	<b>13</b>	<b>14</b>	<b>15</b>	<b>16</b>																																																
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主画面	印刷参数	速度设定	报警检查																																																				



功能介绍 Function:

- |  |   |
|--|---|
|  | <ul style="list-style-type: none"> <li>◆ 印头号 Print Head Number</li> <li>◆ 印刷模式 Printing Mode</li> <li>◆ 模式切换加 Mode Switch</li> <li>◆ 模式切换减 Mode Switch</li> </ul> |
|--|---|

设定印头印刷模式，每个印头可单独设定，共三种印刷模式：覆墨模式、印刷模式、水浆模式。（需机器停止状态下可调）

To st the printing mode of print head, each print head can be set individually, total three modes: flooding mode, printing mode, water slurry mode. (Adjustable when the machine is stopped)

### 2.3.3. 延时设定 Delay setup

印刷次数	印刷模式	延时设定	植绒设定	压烫设定	台板设定	高级设定
------	------	------	------	------	------	------

功能	值
刮刀延时下降	56
刮刀下降时间	56
刮刀延时上升	56
刮刀上升时间	56
水浆网框延时下降	56

+

单位: 0.1 秒

回退刮印功能

已关闭

次数设定: 56

主画面	印刷参数	速度设定	报警检查
-----	------	------	------

PRINTING ROUND	PRINTING MODE	DELAY SET	FLOCKING EQUIPMENT	HOTPRESS EQUIPMENT	ADVANCED SETTINGS
----------------	---------------	-----------	--------------------	--------------------	-------------------

FUNKTION	VALUE
Scraper delay decline.	56
Scraper decline times.	56
Scraper delay rise.	56
Scraper rise times.	56
The Aqueous slurry nets board delay decline.	56

+

Unit: 0.1 s

MAIN	PARAMETER	SPEED	ALARM
------	-----------	-------	-------

功能介绍 Function:

刮刀延时下降

Scrapper delay decline.

刮刀机构伺服电机行走到位后，延时下降刮刀，用于消除刮刀机构行走时重力所带来的共振，如设为 0，到位后立即下降，如水性浆料，时间过短浆料容易溅出，而时间过长，则会影响到生产效率，可根据生产工艺进行设定。（范围 0—50，出厂 2）

Scrapper delay decline: After the servo motor of scrapper mechanism is in place, the scrapper delay drop is used to eliminate the resonance brought by the weight of scrapper mechanism when moving. If set to 0, after being in place, the scrapper will drop immediately, such as water-based slurry, it will be easy to spill if the time is too short, and it will affect the production efficiency if the time is too long, so the delay time should be set according to the production process. (Time Range: 0-50, Ex-factory: 2)

刮刀下降时间

Scrapper decline times.

刮刀下降所需时间，刮刀角度、网框高度均会影响刮刀下降时间，可根据生产工艺进行设定。（范围 0—50，出厂 2）

Scrapper decline times: Both of the squeegee angle and screen frame height will influence the scrapper drop time, and the scrapper drop time can be set according to the production process. (Range 0-50, factory 2)

刮刀延时上升

Scrapper delay rise.

刮刀机构伺服电机行走到位后，延时上升刮刀，用于消除刮刀机构行走时重力所带来的共振，如设为 0，到位后立即上升，如水性浆料，时间过短浆料容易溅出，而时间过长，则会影响到生产效率，可根据生产工艺进行设定。（范围 0—50，出厂 2）

Scrapper delay rise: After the servo motor of scrapper mechanism is in place, the scrapper delay rise is used to eliminate the resonance brought by the weight of scrapper mechanism when moving. If set to 0, after being in place, the scrapper will drop immediately, such as water-based slurry, it will be easy to spill if the time is too short, and it will affect the production efficiency if the time is too long, so the delay time should be set according to the production process. (Time Range: 0-50, Ex-factory: 2)

刮刀上升时间

Scrapper rise times.

刮刀上升所需时间，刮刀角度、网框高度均会影响刮刀上升时间，可根据生产工艺进行设定。（范围 0—50，出厂 2）

Both of the squeegee angle and screen frame height will influence the scrapper rise time, and the scrapper rise time can be set according to the production process. (Range 0-50, factory 2)

水浆网框延时下降

The Aqueous slurry nets board delay decline.

水浆模式时，网框会先下降，然后刮刀才会动作，此时间是指网框下降到到位后，刮刀开始动作，设定时间和网框气缸下降速度有关。（范围 0—50，出厂 2）

When switch into water-based slurry mode, the screen frame will drop first, then the scrapper works, the frame delay drop time refers to that scrapper start to work after the frame drops in place, the setting time is related to the drop speed of frame air cylinder. (Range 0-50, factory 2)

2.3.4. 植绒设定 Flocking setup

印刷次数	印刷模式	延时设定	植绒设定	压烫设定	台板设定	高级设定
------	------	------	------	------	------	------

1

植绒时间

456

2

植绒时间 +

456

3

植绒时间

456

单位: 0.1 秒

主画面	印刷参数	速度设定	报警检查
-----	------	------	------

PRINTING ROUND	PRINTING MODE	DELAY SET	FLOCKING EQUIPMENT	HOTPRESS EQUIPMENT	ADVANCED SETTINGS
----------------	---------------	-----------	--------------------	--------------------	-------------------

1

FLOCKING TIMES

456

2

FLOCKING TIMES +

456

3

FLOCKING TIMES

456

Unit: 0.1 s

MAIN	PARAMETER	SPEED	ALARM
------	-----------	-------	-------

功能介绍 Function:

植绒机号 ◆  
Flocking Machine  
Number

1

FLOCKING TIMES

植绒时间

0

◆ 植绒时间  
Flocking times  
(范围 Range 0—150)

机器标配 2 台本公司植绒机接口，如客户有特殊需求，请与公司联系。  
Configure 2pcs of flocking machine, welcome to contact us if you have any special demand.

2.3.5. 压烫设定 Press setup

印刷次数	印刷模式	延时设定	植绒设定	压烫设定	台板设定	高级设定
------	------	------	------	------	------	------

单位: 0.1 秒

1

压烫关闭

456

+

2

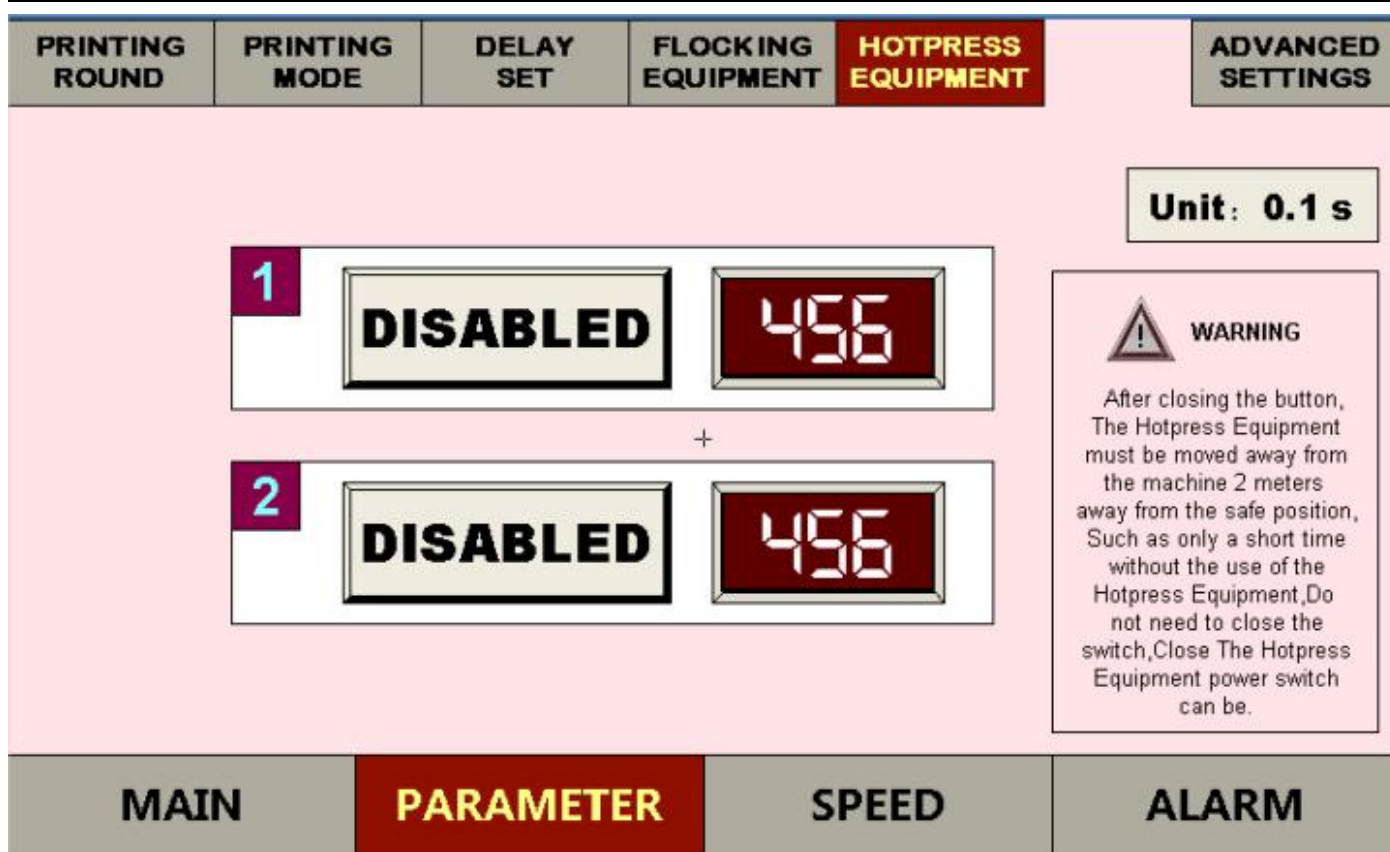
压烫关闭

456

警告

关闭此按钮后，必须立刻将压烫机移至离机器 2 米以外的安全位置，如只是短时间不使用压烫机时，无须关闭此开关，关闭压烫机上红色电源开关即可。

主画面	印刷参数	速度设定	报警检查
-----	------	------	------



**功能介绍 Function:**

压烫机号 ◆  
Press Machine  
Number

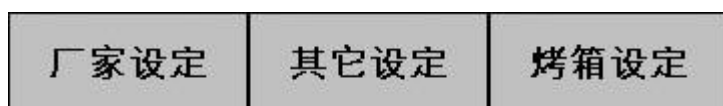


◆ 压烫时间  
Press Time  
(范围 Range 0—150)

压烫机不使用时，需把按钮关闭.机器标配 2 台本公司植绒机接口，如客户有特殊需求，请与公司联系。

Turn off the button when the pressing machine is not in use, configure 2pcs of flocking machine, welcome to contact us if you have any special demand.

**其它高级设定: Other advanced setup**



由于过于复杂和涉及很多关键参数，我们不建议您私下进行修改，否则会影响到机器的正常运行。包含台车设定在内，在正常情况下不要随意进入修改，如的确需要修改时，应先与我公司联系。随意修改容易造成错误动作、撞机等事件。

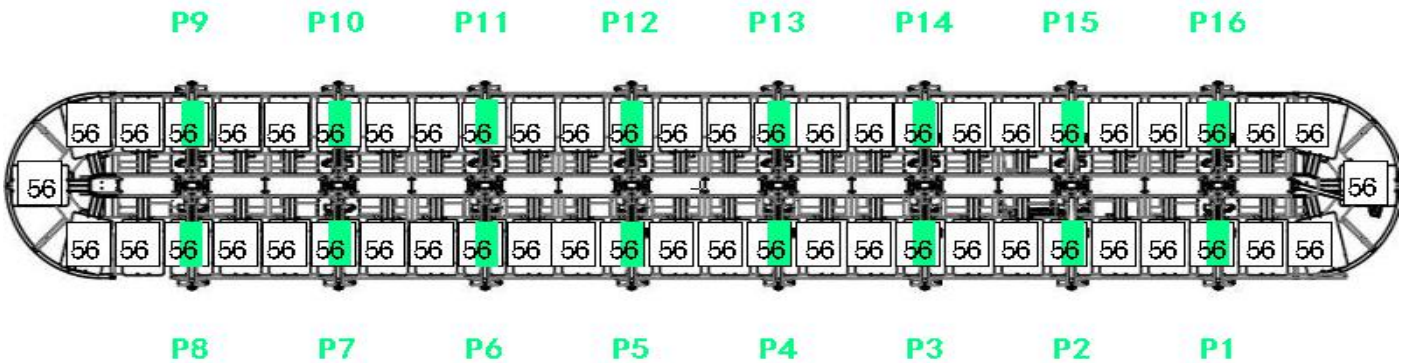
Due to the complexity and many key parameters involved, we do not recommend that you modify it privately, otherwise it will affect the normal operation of the machine. Including the trolley setup, do not arbitrarily enter the



amendment under normal circumstances, if need to modify, you should contact with my company first. Change arbitrarily will lead to wrong action, collision and other events.

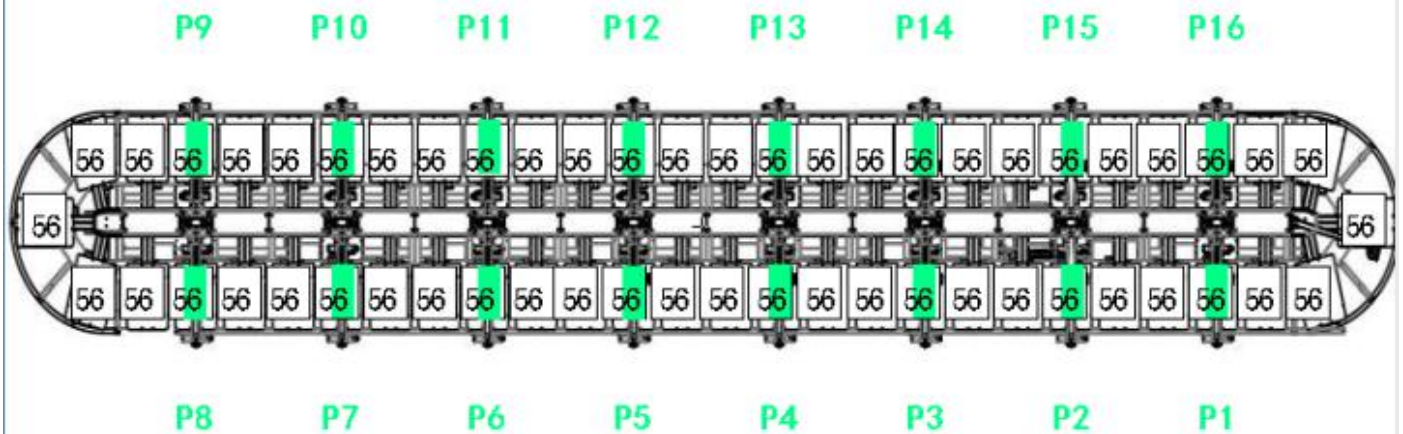
2.3.6. 台板设定 Pallet setup

印刷次数	印刷模式	延时设定	植绒设定	压烫设定	台板设定	高级设定
------	------	------	------	------	------	------



主画面	印刷参数	速度设定	报警检查
-----	------	------	------

PRINTING ROUND	PRINTING MODE	DELAY SET	FLOCKING EQUIPMENT	HOTPRESS EQUIPMENT	PLATEN SET	ADVANCED SETTINGS
----------------	---------------	-----------	--------------------	--------------------	------------	-------------------



MAIN	PARAMETER	SPEED	ALARM
------	-----------	-------	-------

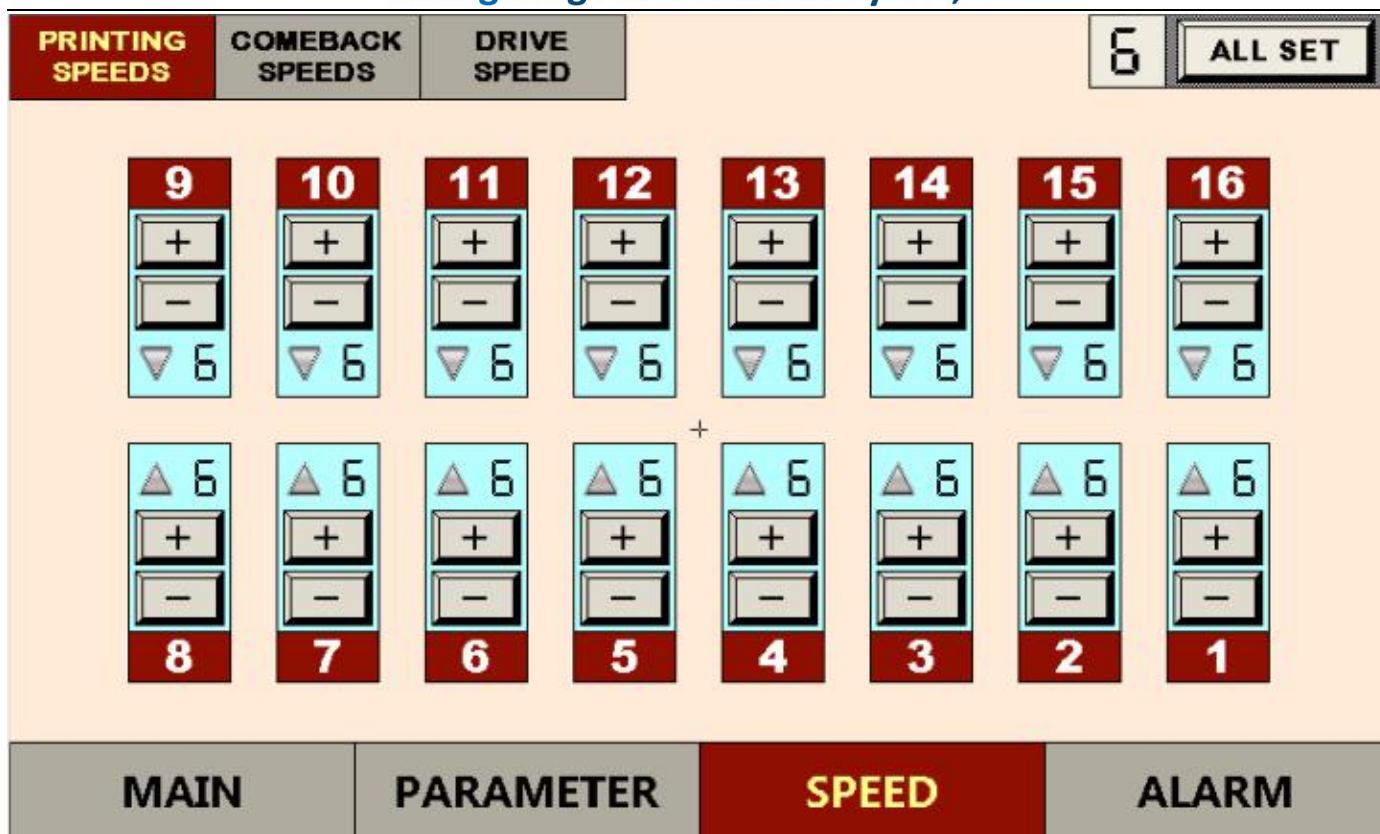
功能介绍 Function:

当某块台板有问题，可以在显示屏点击对应的台板号（显示红色），它这块台板行走任何印刷头都不工作。

When there is a problem with the pallet, you can click on the corresponding plate number (displayed in red) on the display screen, and any printing head will not work when it walks on this platen.

2.4. 速度设定 Speed Setup



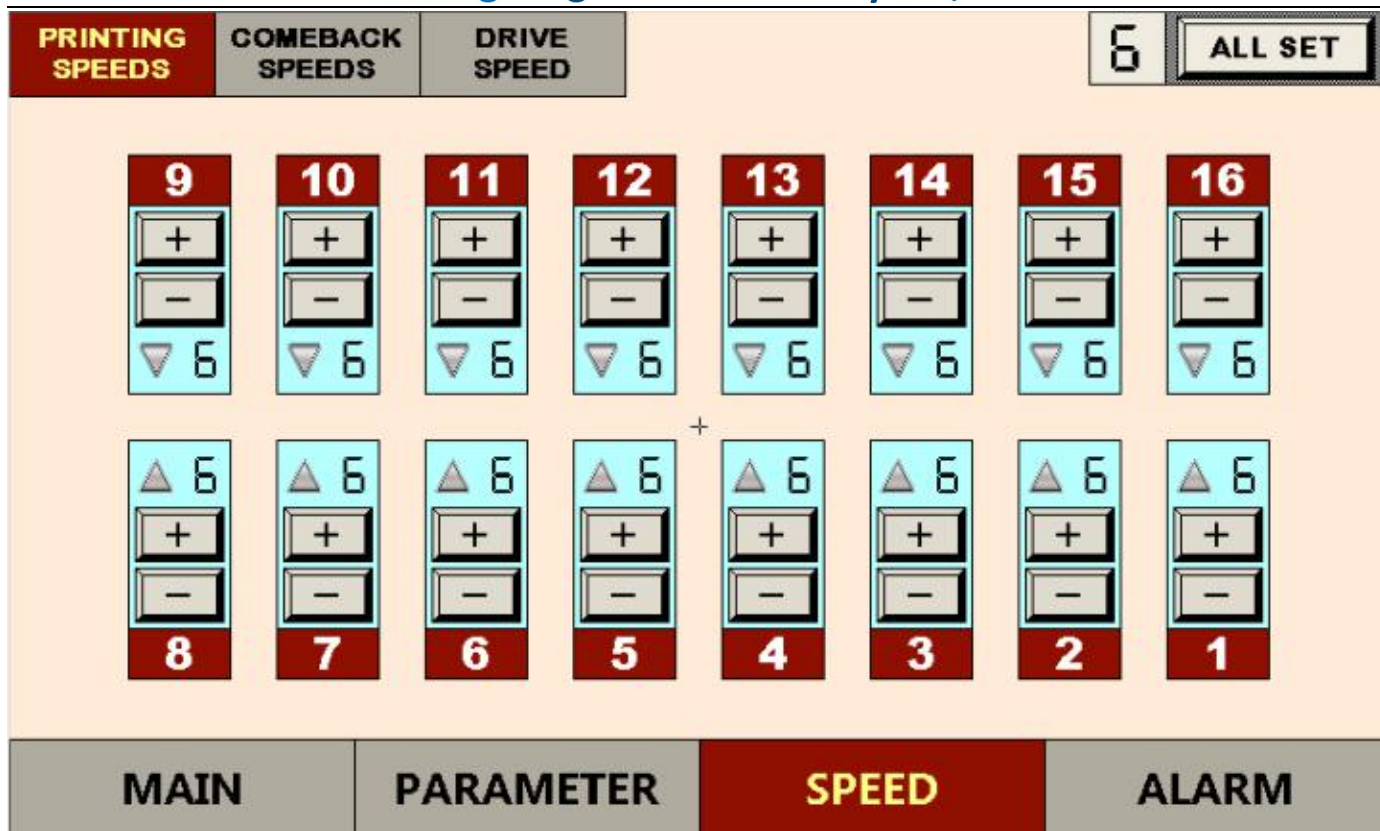


功能介绍: Function:

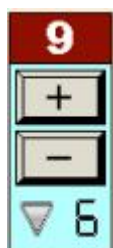
印刷速度	<b>PRINTING SPEEDS</b>	设定印刷速度。To set the printing speed.
覆墨速度	<b>COMEBACK SPEEDS</b>	设定覆墨速度。To set the flooding speed.
台车速度	<b>DRIVE SPEED</b>	设定台车运行速度。To set the trolley running speed.

### 2.4.1. 印刷速度 Printing Speed

印刷速度			覆墨速度			台车速度			6	全体设定																																																																	
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主画面		印刷参数			速度设定			报警检查																																																																			



功能介绍: **Function:**



- ◆ 印头号 Print Head Number
- ◆ 速度加 Speed Increasing
- ◆ 速度减 Speed Reduction
- ◆ 印刷速度 Printing Speed

设定印头印刷速度，每个印头可单独设定。（设定范围 1-7）

To set the printing speed of print head, each print head can be set individually. (Range: 1-7)



用于快速的对全部印头设定，输入数值后，按全体设定键生效。

Used to set all the print head quickly, press "ALL SET" to come into effect after inputting the value.

### 2.4.2. 覆墨速度 Flooding Speed

印刷速度	<b>覆墨速度</b>	台车速度	6	全体设定																																																																									
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PRINTING SPEEDS	<b>COMEBACK SPEEDS</b>	DRIVE SPEED	6	ALL SET																																																																									
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MAIN	PARAMETER	<b>SPEED</b>	ALARM																																																																										

功能介绍 Function:



设定印头覆墨速度，每个印头可单独设定。（设定范围 1-7）

Set the flooding speed of printing head, each printing head can be set individually. (Setting range 1-7)

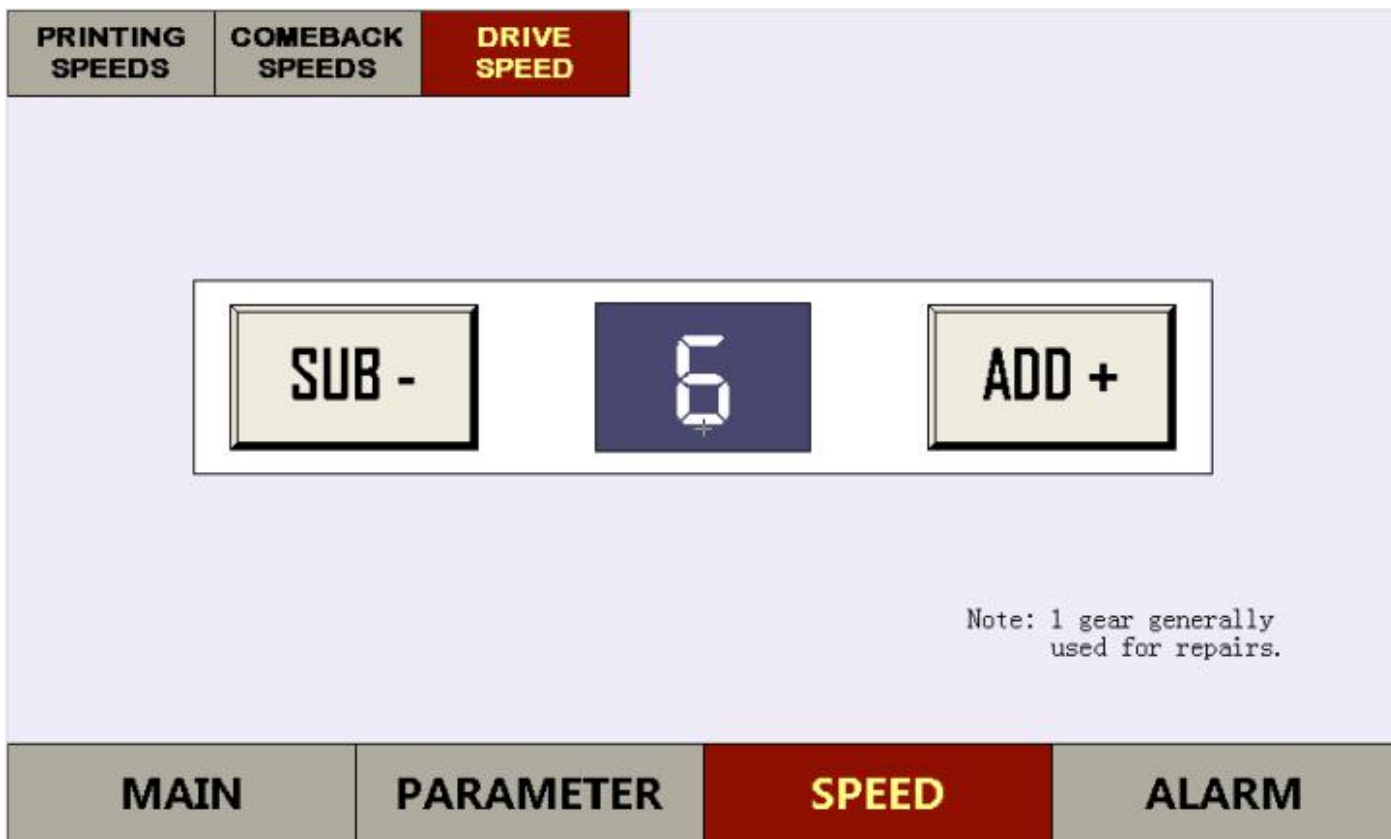


用于快速的对全部印头设定，输入数值后，按全体设定生效。

Used to set all the print head quickly, press "ALL SET" to come into effect after inputting the value.

2.4.3. 台车速度 Trolley Speed

印刷速度	覆墨速度	台车速度	
<div style="display: flex; justify-content: space-around; align-items: center;"> <div style="border: 1px solid black; padding: 10px; background-color: #f0f0f0;">SUB -</div> <div style="background-color: #4b4b8b; color: white; padding: 10px; font-size: 2em;">6</div> <div style="border: 1px solid black; padding: 10px; background-color: #f0f0f0;">ADD +</div> </div>			
注：一档一般用于维修。			
主画面	印刷参数	速度设定	报警检查



功能介绍 Function:



台车速度共有两个档位，1 档主要用于检修使用，其速度大约是正常运行速度的一半，正常运行时应使用 2 档。  
There are 2 stages of trolley speed, 1th stage is mainly used for maintenance use, the speed is about half the normal running speed, the normal operation should use 2th stage.

## 2.5. 报警检查 Alarm and Check



当前报警
历史报警
检修

TIME/时间	ALARM/报警		
20/08/14 11:55	ERROR.700:	急停异常处理方法	通讯异常处理方法
20/08/14 11:55	ERROR.701:Sub-station 1 communication error!	/ 子站1通讯异常!	
20/08/14 11:55	ERROR.702:Sub-station 2 communication error!	/ 子站2通讯异常!	
20/08/14 11:55	ERROR.703:Sub-station 3 communication error!	/ 子站3通讯异常!	
20/08/14 11:55	ERROR.704:Sub-station 4 communication error!	/ 子站4通讯异常!	
20/08/14 11:55	ERROR.705:Sub-station 5 communication error!	/ 子站5通讯异常!	
20/08/14 11:55	ERROR.706:Sub-station 6 communication error!	/ 子站6通讯异常!	
20/08/14 11:55	ERROR.707:Sub-station 7 communication error!	/ 子站7通讯异常!	
20/08/14 11:55	ERROR.708:Sub-station 8 communication error!	/ 子站8通讯异常!	
20/08/14 11:55	ERROR.709:Sub-station 9 communication error!	/ 子站9通讯异常!	
20/08/14 11:55	ERROR.70A:Sub-station 10 communication error!	/ 子站10通讯异常!	
20/08/14 11:55	ERROR.70B:Sub-station 11 communication error!	/ 子站11通讯异常!	
20/08/14 11:55	ERROR.70C:Sub-station 12 communication error!	/ 子站12通讯异常!	
20/08/14 11:55	ERROR.70D:	定位异常处理方法	数码异常处理方法
20/08/14 11:55	ERROR.70E:	网框上下超时处理方法	台车伺服异常处理方法
20/08/14 11:55	ERROR.70F:	台车原点异常处理方法	

主画面
印刷参数
速度设定
报警检查

CURRENT ALARM
ALARM HISTORY
CHECK REPAIR

TIME/时间	ALARM/报警		
20/08/20 16:03	ERROR.700:		
20/08/20 16:03	ERROR.701:Sub-station 1 communication error!	/ 子站1通讯异常!	
20/08/20 16:03	ERROR.702:Sub-station 2 communication error!	/ 子站2通讯异常!	
20/08/20 16:03	ERROR.703:Sub-station 3 communication error!	/ 子站3通讯异常!	
20/08/20 16:03	ERROR.704:Sub-station 4 communication error!	/ 子站4通讯异常!	
20/08/20 16:03	ERROR.705:Sub-station 5 communication error!	/ 子站5通讯异常!	
20/08/20 16:03	ERROR.706:Sub-station 6 communication error!	/ 子站6通讯异常!	
20/08/20 16:03	ERROR.707:Sub-station 7 communication error!	/ 子站7通讯异常!	
20/08/20 16:03	ERROR.708:Sub-station 8 communication error!	/ 子站8通讯异常!	
20/08/20 16:03	ERROR.709:Sub-station 9 communication error!	/ 子站9通讯异常!	
20/08/20 16:03	ERROR.70A:Sub-station 10 communication error!	/ 子站10通讯异常!	
20/08/20 16:03	ERROR.70B:Sub-station 11 communication error!	/ 子站11通讯异常!	
20/08/20 16:03	ERROR.70C:Sub-station 12 communication error!	/ 子站12通讯异常!	
20/08/20 16:03	ERROR.70D:		

MAIN
PARAMETER
SPEED
ALARM

显示机器当前发生和最近一段时间发生过的报警信息，信息明确表达了报警发生的时间、故障现象、故障

位置等信息，维修时应根据报警信息进行故障排除。如有疑问，请与我公司联系！切勿随意进行拆卸。

Display the alarm information that occurs currently and recently, the information clearly showed the time, fault phenomena, fault location and other information when alarm occurs, maintenance should be based on alarm information for troubleshooting. If you have any doubt, please contact us! Pay attention to not knock down the machine arbitrarily.

#### 功能介绍 Function:

当前报警

CURRENT  
ALARM

显示当前未解除的报警，报警解除后不在显示。可点击异常处理方案，根据方法进行排查。

Display the current unresolved alarm, the alarm is not displayed after the release. Clickable exception handling scheme, according to troubleshoot program.

历史报警

ALARM  
HISTORY

显示曾经发生过的报警，记录了发生报警的日期、时间、类型和解除的时间，具有断电保持功能，最多可记忆最近 100 条记录。

Display the alarm that occurred before, record the occur date&time, type and release time;even if power-off, it still retain the data and keep 100pcs of records at most.

检修

CHECK  
REPAIR

进入检修画面，用于发生故障时的相关操作。

Enter the "CHECK REPAIR" for related operations in the event of a failure.

#### 2.5.1. 检修 CHECK REPAIR

当前报警	历史报警		I/O 输入	I/O 输出	工具																																																																																																																																																																																
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功能介绍 Function:



显示控制器接收到的输入信号，包含按钮信号和感应器信号，维修时可根据所对应的信号格来判断线路是否为通路。

Display the input signal that controller receives, including the button signal and sensor signal, maintenance can be based on the corresponding signal to determine whether the line is a path.



显示控制器输出的信号，以此判断控制程序是否正常，但不能显示输出线路是否通路。仅作为维修时的参考。

Display the signal output of the controller to determine whether the control program is normal, but can not show whether the output line is a path. Only as a reference for maintenance.



工具画面，包含了维修时会使用到的部分功能。

Tools, contains some of the functions that will be used when maintaining.

2.5.2. 工具 TOOLS



功能介绍 Function:

**定位锁定**

手动操作定位气缸锁定，自动运行时不可用。

Lock the positioning cylinder manually and is unavailable for automatic operation.

**定位弹出**

手动操作定位气缸弹出，自动运行时不可用。

Pop up the positioning cylinder manually and is unavailable for automatic operation.

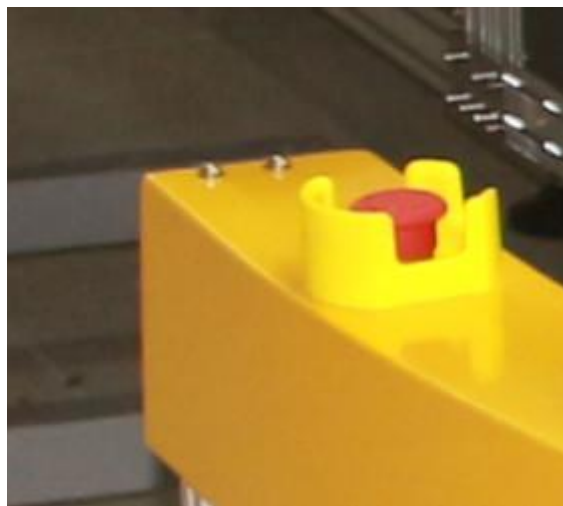
**清除伺服报警**

清除印头伺服电机因行程调节不当后冲撞而产生的报警。

Clear the alarm occurred by the collision due to the improper stroke adjustment of print head servo motor.

### 3. 操作相关 Related operation

#### 3.1. 急停 E-Stop



本机共设有 4 个急停开关，分别位于机器半圆的前部两侧和后部两侧，用于紧急情况下的制动，因考虑到印刷的可靠性，紧急制动不包含印头印刷的制动，印头的紧急制动由印头所对应的电源按钮控制。急停开关采用安全常闭信号方式，如信号线断裂和损坏，也会触发报警，检修时注意！非紧急情况勿按!!!

The machine has a total of four emergency stop switches, located on both sides of the front and rear of the machine respectively, used for braking under the stage in emergency condition, because taking the reliability of printing into account, emergency braking does not contain the brake of print head, the emergency brake of print head is controlled by the corresponding power button of the print head. E-stop switch adopts the safe normally closed signal way, it will trigger the alarm if the signal line is broken and damaged, pay attention when overhauling!

Do not press in non-emergency situations!!!

### 3.2. 脚踏开关 Foot Switch



脚踏开关用于生产时的柔性节拍控制，当铺布或收布忙不过来时，但又不是次次忙不过来，只是偶然，如果加长铺布时间的设定，会造成效率上的浪费，这时只需踩住脚踏开关，机器会暂停走板，直到脚踏开关松开为止。功能生效时，塔式报警灯绿灯闪烁。按机型配备，一般在机器前部和机器尾部分别配备一个，如客户需要在中间其它部位增加时，请与公司联系。

Foot switch is used for the flexible beat control of production, when busy in spreading or collecting cloth, but not busy frequently, just by chance, then it will cause the waste of efficiency if extending the cloth-spreading time set. Therefore, you only need to step on the foot switch at this time, the machine will not stop running board until the foot switch release. When the function is active, the tower alarm light flashes. To equip the foot switch according to the models, usually equipped in the front of the machine and the tail of the machine, if you need to increase the switch in other parts, please contact us.

### 3.3. 手动操作 Manual Operation



手动操作分为电气动作和机械调节两个部分。电气动作是指在非自动运行状态下以手动操作实现各种印刷动作，如：网框上下、刮刀动作、台车动作等等。机械调节是指调节各个气缸部件的力度和机械部件的位置，如：印刷长度、刮刀角度、刮刀力度和网框位置等等。手动操作时，应遵循 运行前注意事项。



Manual operation is divided into two parts: electrical action and mechanical adjustment. Electrical action refers to achieve a variety of manual operation under the non-automatic operating condition , such as: the screen frame up and down, scraper action, trolley movements and so on. Mechanical adjustment refers to adjust the strength of each cylinder component and the location of mechanical parts, such as: printing length, blade angle, blade strength and the location of the frame and so on. For manual operation, please follow Safety Instruction.



### 3.3.1. 操作印头 Printing Head Operation





各按钮单独功能说明前面已经明说，此处不在叙述，请参见 **2.2 印头面板** ，下面介绍各按钮手动时的组合操作。


Individual function of each button has been described before, please refer to **2.2 Print Head Panel**, the following describes the combination operation of the button under manual action.


**开启手动操作模式:** 走近需要手动操作的印头，按下暂停按钮  ，按下电源按钮  ，此时暂停指示灯（黄色）和电源指示灯（红色）亮起，进入手动模式成功。

**To turn on the manual operation mode:** Come up to the print head which requires manual operation, press the pause button  , and press the power button  . When the pause indicator light (yellow) and the power indicator light (red) are on, then the manual mode is successful.


**网框操作:** 手动模式开启后，按下  按钮可进行网框向上或向下的操作。如此时关闭电源按钮或关闭暂停按钮，网框将恢复高位。


**Screen Frame operation:** Press the button  after opening the manual mode, so as to move the frame up or down. If you turn off the power button or turn off the pause button, the frame will revert to the high position.


**刮刀操作:** 手动模式开启后，按下  按钮可使刮刀进行印刷和覆墨的操作，无论网框是处于高位还是低位，均会执行此操作，如此时关闭电源按钮或关闭暂停按钮，刮刀将立即停止。


**Scraper Operation:** Press the button  after opening the manual mode, so that the scraper can have printing and flooding operation. No matter the screen is in the high or low position, this will be done as usual. If turn off the power button or the pause button, the scraper will stop working immediately.





**印刷一个回合:** 手动模式开启后, 按下  按钮, 印头会根据设定好的次数和模式运行一个回合的操作, 印刷过程中关闭电源按钮或关闭暂停按钮, 动作将立即停止。

**Print for a turn:** Press the button  after opening the manual mode, the print head will run a round of operation according to the set times and mode, if turn off the power button or pause button during the printing process, the action will stop immediately.

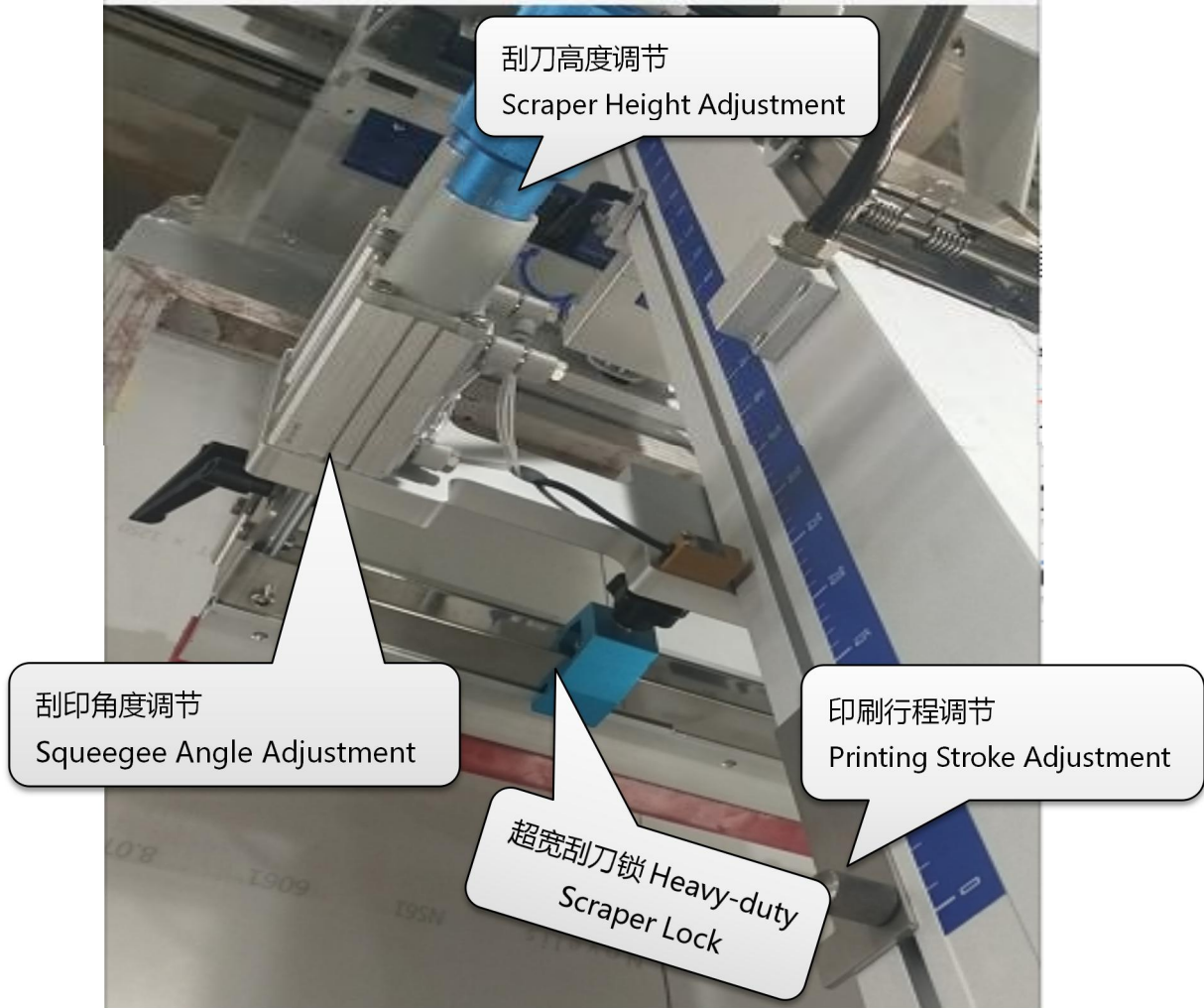
**台板前进一次:** 在确保所有印头及控制中心都没有暂停状态时, 按下  按钮, 台车进行一次前进走板动作, 走板过程中, 按下暂停也不会停止台车, 直到走板完成。

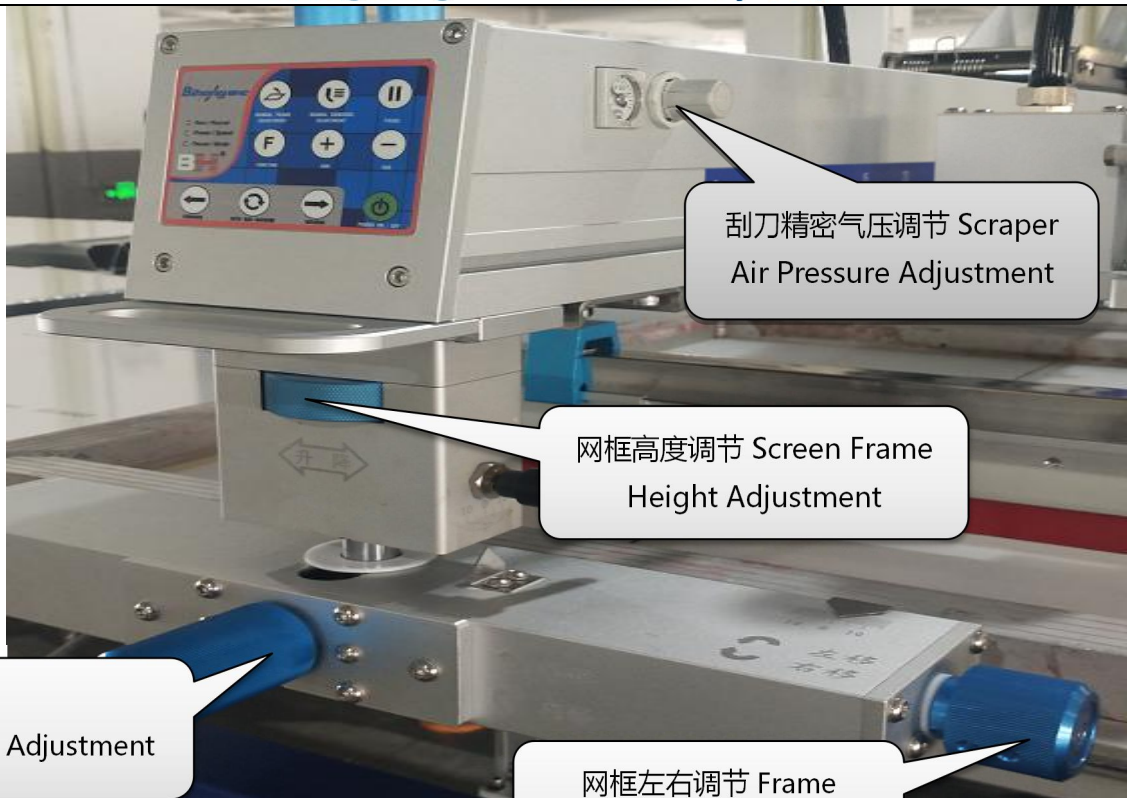
**The platen goes forward once:** Press the button  when ensure that all the print head and the control center are not suspended, the trolley will run forward for a round and will not stop until the round is over.

**台板后退一次:** 在确保所有印头及控制中心都没有暂停状态时, 按下  按钮, 台车进行一次后退走板动作, 走板过程中, 按下暂停也不会停止台车, 直到走板完成。

**The platen goes backward once:** Press the button  when ensure that all the print head and the control center are not suspended, the trolley will run backward for a round and will not stop until the round is over.

### 3.3.2. 机械调节 Mechanical Adjustment





刮刀精密气压调节 Scaper  
Air Pressure Adjustment

网框高度调节 Screen Frame  
Height Adjustment

网框前后调节  
Frame Vertical Adjustment

网框左右调节 Frame  
Horizontal Adjustment



大小网框调节  
Frame Size Adjustment

网框保持气锁  
Frame Airlock

通用网框夹具  
Universal Frame Clamp

网框左右调节 Frame  
Horizontal Adjustment

## 功能介绍 Function:

**刮刀高度调节:** 调节刮刀和覆墨刀下降时的高度, 配合精密气压调节使用, 可根据花型需要而随意变化, 可在 30mm 范围内自由调节。

**Scraper Height Adjustment:** The drop height adjustment of scraper and ink-covering blade combines with precision air pressure adjustment together, so that scraper height(within 30mm ) can be changed arbitrarily according to the logo shape.

**印刷行程调节:** 可随时根据印花需要调节刮刀行走长度, 无需复杂设定, 直接拧松手柄后前后移动即可。具体行程参见机型标称范围。

**Printing Stroke Adjustment:** To adjust the printing stroke according to the needs of printing process without complex setup, unscrew the handle and move forward or backward directly.

**刮刀角度调节:** 调节刮刀和覆墨刀角度, 根据花型需要, 可在 50 度范围内自由调节。

**Scraper Angle Adjustment:** To adjust the scraper and ink-covering blade angle according to the logo type, and can be adjusted within 50 degrees.

**重型超宽刮刀锁:** 支持超宽刮刀、覆墨刀, 调节方便, 性能稳定, 通常一把刀具安装两把锁具, 但如果是超长型刀具, 可按实际需要, 多加装几只锁具, 以便夹持力度更稳、更均匀。

**Heavy-duty Airlock:** support ultra-wide scraper, ink-covering blade, easy adjustment, stable performance, usually one scraper is installed with two locks, but if it is a long scraper, it can be installed with more locks according to actual needs, so that the clamping force will be more stable and more uniform.

**刮刀精密气压调节:** 调节刮刀下降时的力度, 配合刮刀高度调节, 可根据花型需要而随意变化, 一般情况调节到 0.3 MPa 左右即可。

**Scraper Air Pressure Adjustment:** To adjust the scraper drop intensity with scraper height adjustment, which can be changed freely according to the logo type, normally it's adjusted about 0.3MPa.

**网框高度调节:** 调节网框上下高度, 主要是指调节网框与台板间的高度, 根据印花的工艺需求可在 25mm 范围内调节。

**Frame Height Adjustment:** Frame height adjustment, mainly refers to the height between frame and station, which can be adjusted within 25mm according to the needs of printing process.

**网框前后调节:** 调节网框前后距离, 主要是在调节网版前后套位时使用, 可在 30mm 内范围内自由调节。

**Frame Vertical Adjustment:** To adjust the longitudinal separation of frame, mainly used in registering version back and forth, which can be freely adjusted within 30mm.

**网框左右调节:** 调节网框左右距离, 主要是在调节网版左右套位时使用, 可在 30mm 内范围内自由调节。

**Frame Horizontal Adjustment:** To adjust the left-right length of frame, mainly used in registering version leftward and rightward, which can be freely adjusted within 30mm.

**大小网框调节:** 本机器不限于一种尺寸的网框, 只要符合本机器网框规范内网框均可用于本机, 只需松开把手, 移动至合适位置即可, 调节十分方便。调节完成后, 注意气管位置, 气管伸出过长, 台车行走时容易挂到台车。

**Frame Size Adjustment:** The machine is available for various sizes of screen frame which meet the specifications. The operation is very simple: just release the handle and move the frame to the appropriate location.. After adjusting, pay attention to the air pipe position, for the air pipe will hang to the running trolley easily if the air pipe stretches too long.

**网框保持气锁:** 用于夹紧网框, 运行时全压力夹紧网框, 使网框不会脱落。需要取下网框时, 操作印头面板, 解除网框锁定, 此时网框压力变小, 可轻易取下网框。请参见 第9页 网框松紧按钮。

**Frame Air Lock:** Used to clamp the frame at run time so that the frame will not fall off. Operate the print head panel for releasing the frame lock when you need to take down the frame, after the frame pressure becomes smaller, you can take down it easily. See page 9 Screen Frame elastic button.

**通用网框夹具:** 采用四点自平行方式固定网框, 在网框四个角点, 分别有一个定位安装点, 有效解决因网框变形等原因所引起的网框松动。

**Universal Frame Clamp:** Adopt four-point self-parallel way to fix the screen frame, there is a positioning installation point at four corners of screen frame respectively, which solves the frame loosened problems caused by the deformation of the frame or other reasons effectively.

### 3.4. 自动运行开机流程 Operation Process of Automatic Running

(1)打开显示屏电源 Turn on the Power

(2)打开气源 Open the Gas Source



(3)检查 **运行前注意事项** Check **Safety Instruction**

(4)运行机器 Run the Machine



回原点完成后自动启动机器。The machine will start automatically after back to the original place.



回原点完成后停止，回原完成后，在次按下将走动行走一次台板。

After back to the original place, the machine will run forward if press the button.



回原点完成后停止，回原完成后，在次按下将走动行走一次台板。

After back to the original place, the machine will run backward if press the button.

(5)按需要打开印头 Open the print head as per your need.



每个印头分别对应一个开关 One print head, one corresponding switch.

机器正常作业啦!! 完!!

Normal Working!!