

FOT-1200 平面热转印机操作说明

FOT-1200 Flat Heat Transfer Printing Machine

Operation Instruction

主要参数

Main Technical Data

型号:FOT-1200

Type: FOT-1200

额定电压:380V

Rated voltage: 380V

额定功率: 发热体 18KW 动力系统 2KW

Rated power: heating element: 18KW; power system: 2KW

频率:50HZ

Frequency: 50HZ

接线方式:三相一零四线制

Wiring: 3-phase 1 zero line 4-wire system

发热方式:电热

Heating type: electric heating

动力系统:液压式升降

Power system: hydraulic lifting

发热板尺寸:1200mm×1000mm

Size of heating plate: 1200mm×1000mm

主机尺寸:1600mm（长）×1200mm（宽）×1300mm（高）

Machine size: 1600mm（L）×1200mm（W）×1300mm（H）

净重: 600KG（约）

Net weight: 600KG (Approx.

[声明]以上参数以实物为准，如有局部变动，恕不另行通知，敬请谅解。

Note: All above data shall be based on the actual equipment; in case of any possible changes of the data, please forgive us not informing again.

安装 Installation

1. 开箱后,请检查主机上各个部位螺丝是否在运输途中松动,如有请拧紧.
1. After opening the package, please check whether the screws on each part of the machine are loosened during the transportation, if so, please tightening the screws in time.
2. FOT-1200 型平面印花设备,净重约 600KG,应放置在有足够承托力的水平地面上.
2. The net weight of the FOT-1200 planar printing equipment is about 600KG, the machine shall be placed on the flat floor with sufficient loading strength;
3. 取出轨道连接在主机上,确保证条轨道水平后再拧紧螺丝.
3. Take the rails out and install the rails on the machine; then tighten the screws after ensuring the levelness of the rails;
4. 把已拆掉钢索的滑车拉出,使之平行,且传动链与链轮咬紧,且两边同步,这样可把钢索与滑车连接好。
4. Pull out the pulley with its steel cable already removed to ensure parallelism, and the drive chain and sprocket shall be linked tightly with simultaneous movement of both sides, so the steel cable may be connected with the pulley well;
5. 打开机器上前门板,请在油箱内加好液压油,油量以油标线为准。
5. Open the front door of the machine and fill the hydraulic oil in the oil tank with the oil filling level according to the oil scale mark;
6. 按额定功率,连接相应线径的电源线,请用国标 10 平方的铜芯线或电缆线。连接时请分清相线和零线的位置,千万不可接反。
6. Based on the rated power, connecting the power cables with suitable diameter; it is preferable to use GB 10mm² copper-core cables or electric cables. While wiring, please be careful to connect the phase lines and zero lines with the right positions and avoid reverse wiring;
7. 警告——为了防止触电,使用前必须确保此设备接地良好!

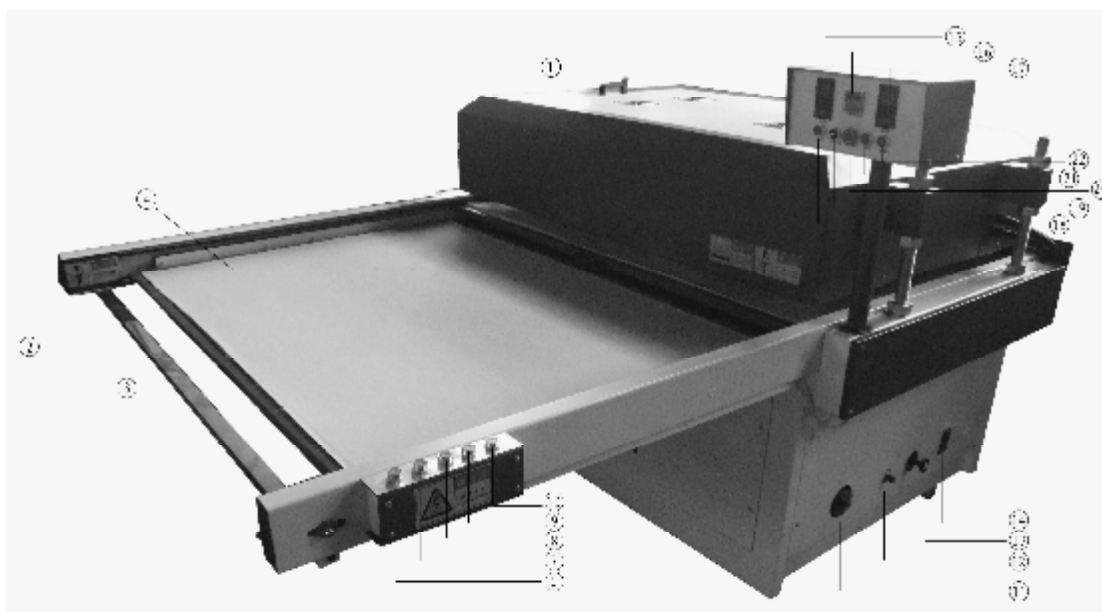
7. Warning - To prevent electric shock, the machine shall be ensured of proper earthing prior to operation!

8. 检查接线无误后，推上机箱内的断路器，打开控制面板上的总电源。把滑车开到轨道顶端。按下液压开关，然后按下轨道旁控制盒上的上工作按钮，如电机运转而下托板不能上下，则把电源线上的三根相线互相对调一下位置，这样就能正常工作。

9. After checking to ensure the proper wiring, turn on the circuit breaker in the cabinet, set the function switch at manual position, then move the pulley to the end of the rail; press the switch of hydraulic machine and then press the operation button in the control box next to the rail; if the electric motor runs, but the lower support plate fails to move up and down, then it is suggested to exchange the positions of three phase lines of the power cable, then the machine will work properly.

机器各部件说明

Instructions of parts of the machine



功能说明：Function description:

(1) 通风网罩

(1) Airy guard

(2) 连杆——连接两根滑轨槽

(2) Connecting rod —— Connecting two slide rail grooves;

(3) 工位——转印物的载体

(3) Service station——carrier of the printing material;

(4) 隔热垫——转印物与下托板之间的缓和物

(4) Heat insulating mattress —— the buffer between the printing material and
lower support plate;

(6) 上升开关——按下下托板上升

(6) Lifting switch —— press to lift the lower support plate;

(7) 下降开关——按此开关，可使下托板下降

(7) descending Switch——press to descend the lower support plate

(8) 紧急下降开关——紧急情况下，按下下托板立刻下降

(8) Switch for emergency descending —— press to descend the lower

support plate at once under emergency cases;

(9) 上工位进开关——按下它，上工位进

(9) Switch for upper service station in —control the upper service station in.

(10) 下工位进开关——按下它，下工位进

(10) Switch for lower service station in —control the lower service station in.

(11) 压力表——显示液压缸工作时的压力大小

(11) Pressure gauge—— display the pressure of the hydrocylinder while working;

(12) 快慢阀——控制下托板下降的速度

(12) Speed control valve —— control the descending speed of the lower support plate;

(13) 调压阀——调整液压缸工作时压力的大小

(13) Pressure control valve —— adjust the working pressure of the hydrocylinder;

(14) 控制器——控制工位电机的电源及速度

(14) Controller —— control the power and speed of the service station motor;

(15) — (17) 温控仪——控制发热板工作温度

(15) — (17) temperature controller —— control the working temperature of the heating plate;

(16) 时控仪——控制下托板上升加压的时间

(16) Time controller —— control the time for rise and pressurizing of the lower support plate;

(18) & (22) 加温按钮——控制发热板电源的通断

(18) & (22) buttons for temperature increase —— control the on/off of the power supply to the heating plate;

(19) 电源按钮

(19) button for power source

(20) 急停按钮——控制整机的电源通断

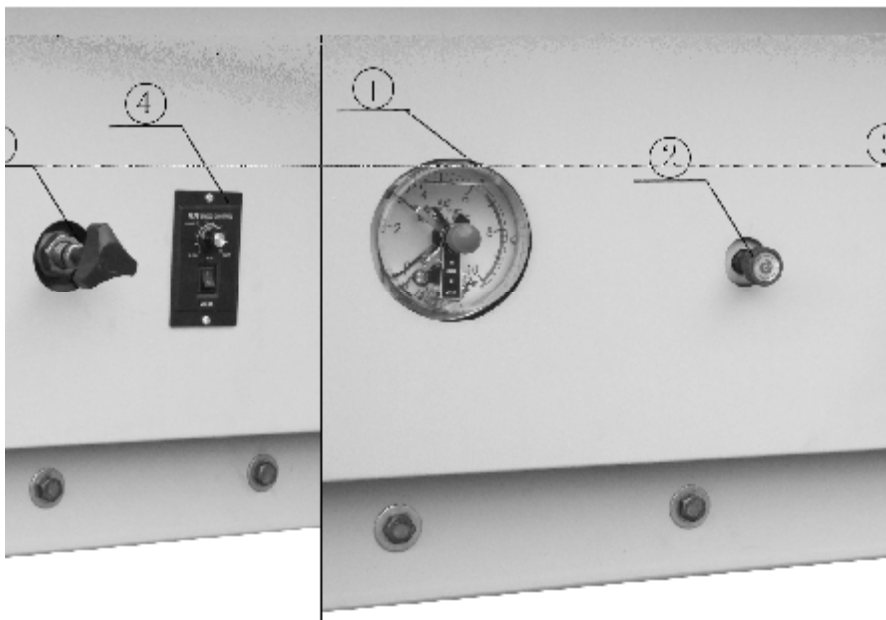
(20) button for emergency stop——control the power to the operating system

(21) 油泵开关——控制油泵电机的电源

(21) Switch for oil pump——control the power to motor of oil pump

(23) 紧急下降阀——在工作台无法下降的情况下使用。具体操作步骤：往顺时针拧到底就可使工作台下降。工作台下降后，该阀需按逆时针拧回原位。

(23) valve for emergency descending——It is used when working table can not descend . Operating steps: Go clockwise rotation out to descend the working table .When the table descend, go anticlockwise rotation to normal position.



功能说明 Function description:

(1) 压力表——显示液压缸工作时的作用力

(1) Pressure gauge - display the force when the hydrocylinder is in operation;

(2) 快慢阀——控制下顶板下降时的速度

(2) Speed control valve - control the descending speed of the lower support plate;

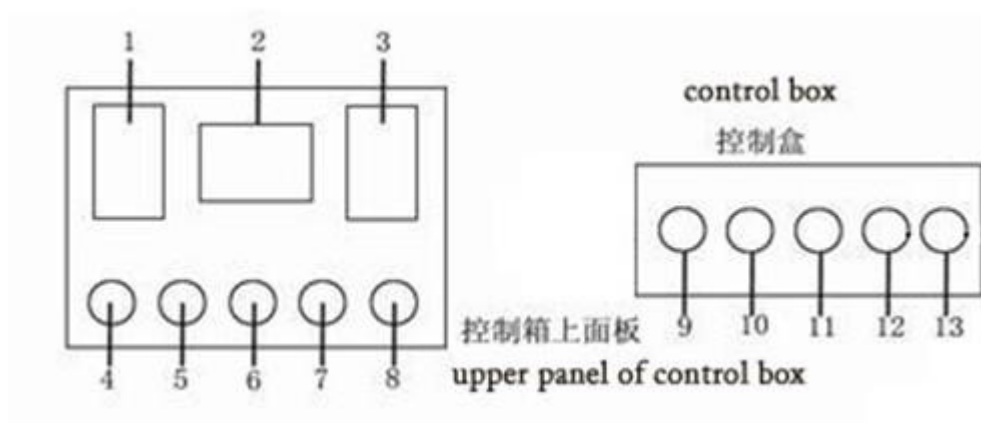
(3) 调压阀——控制液压缸工作时作用力的大小

(3) Pressure control valve —— adjust the working pressure of the hydrocylinder;

- (4) 控制器——控制滑车电机电源的通断及速度变化
- (4) Controller – control the power supply to the motor of the slide pulley and the speed

控制面板说明

Instruction of control panel



1. 加温 A 温控仪——检测和设定加热板两侧部分的温度。
Temperature controller for heating A – test and set the temperatures at both sides of the heating plate;
2. 时间控制仪——控制下托板上压烫时间的长短。
Time controller – control the press and heating time of the lower support plate;
3. 加温 B 温控仪——检测和设定加热板中间部分的温度。
Temperature controller for heating B – test and set the temperature of the middle part of the heating plate;
4. 加温 A 按钮——控制加热板两侧部分发热体电源通断。
Button for heating A – control the power supply to the heating elements at both sides of the heating plate;
5. 总电源按钮——控制线路上电源的通断。
Button for general power source – control the general power supply;

6. 急停按钮——控制整机电源的通断。
button for emergency stop——control the power to the operating system
7. 油泵——控制液压电机的运行。
Button for oil pump—— control the running of the hydraulic motor;
8. 加温 B 按钮——控制加热板中间部分发热体电源通断。
Button for heating B – control the power supply to the heating elements at both sides of the heating plate;
9. 上升按钮——按此按钮，下托板才能升起
Lifting button——when pressing this button, the lower support plate may rise;
10. 紧急下降按钮——在任何状态下，按此按钮，下托板会立即下降。
Button for emergency descending – under any operation state, when pressing this button, the lower support plate will descend instantly;
11. 暂停——在“手动”状态时，按此按钮，可以使下托板随时停止上升。
Pause button – under “manual” state, by pressing this button, the lower support plate may stop rise at time;
12. 上工位进按钮——按下它，上工位进
Button for upper service station in—when pressing the button, the upper service station will get in.
13. 下工位进开关——按下它，下工位进
Button for lower service station in —when pressing the button, the lower service station will get in.

操作方法

Operating Method

1. 确认机体良好接地和电源接线无误后，推上机箱内短路器，然后打开总电源按钮，再按下“加温 A”和“加温 B”，设定好所需温度，此数据靠客户根据不同的面料成分而定。

After ensuring the right earthing and proper power connecting, turn on the circuit breaker in the cabinet, and then press the button for general power source, then press buttons for “ heating A “ and “heating B” and set the required temperature. The data is set by the customers depending on different fabrics.

2. 当温度达到设定值时，按下控制面上的“液压”按钮，再把滑车运行到位,在滑车上放好面料和纸后运行至发热板下,按下滑轨旁控制盒上的上升按钮,下托板才会抬起.当压烫到所设定时间时,下托板自动下降.下托板下降到位后,才可以打开滑车开关.

When the temperature reaches the pre-set value, press the “hydraulic” button on the control panel and move the slide pulley to the specified location; then move the slide pulley with fabric and paper on it to below the heating plate, please press the rise button in the control box beside the side rail to lift the lower support plate, when time for the press and heating reaches the set level, the lower support plate will descend automatically; only when the lower support plate descends to the required position can the switch for slide pulley be turned on.

3. 我厂建议,客户在到达设定温度是先用小块面料和转印纸转印.如温度过高和过低,可作出相应调速同时也应调整压烫的时间,以保证大幅转印品的质量.

We suggest that the user may use small size fabric and transfer printing paper for printing purpose when the machine reaches the set temperature; if the temperature is over high or over low, the speed may be adjusted accordingly or the time for pressing and heating may also be adjusted to ensure the quality of the large-size transfer printing materials.

4. 转印工作结束后,应关掉”加温”和”液压”按钮,把上滑车开到轨道外顶端.

Upon completion of the transfer printing, turn off the buttons for “heating” and “hydraulic press” and move the upper slide pulley to the top end of the rail.

注意事项

Cautions

1. 因为是热工机械,所以在使用过程中,发热板可能产生一些弯曲,这是属于正常现象,不必惊慌.

As this machine is the thermal machinery, there may be possible bending of the heating plates during the operation, which is the normal phenomenon. Please do not get panic;

2. 发热板表面经过特殊处理不得用腐蚀性液体擦洗及有硬物进入划伤.

The surface of the heating plate is specially treated, do not use corrosive liquid to clean the plate or scratch by hard objects;

3. 本机所有液压系统已调好,特别是压力表,不可随便调整,如确需变动请来电话讯.

All the hydraulic systems of the machine have been already adjusted; please do not adjust the speed at will, especially for the pressure gauge; if you intend to adjust the data, please contact us by phone.

平面热转印印花机常见故障异常分析及对策

common fault 、 analysis of cause and solution

故障名称 fault	原因分析 analysis of cause	对 策 solution
工作台无法进出 working table can not get in or out	1、 接近开关故障 proximity switch damaged	更换或调整间距 change or adjust spacing
	2、 工位电机故障 motor to work station damaged	更换 change
	3、 工位电机调速器故障 speed controller damaged	更换 change
	4、 交流接触器故障 AC contactor damaged	更换 change
	5、 工位开关故障 switch to work station damaged	更换 change
工作台面不会升起 working table can not rise	1、 电磁阀故障 magnetic valve damaged	更换或清洗 change or clean
	2、 上升按钮故障 button for rising damaged	更换 change
	3、 压力不够 pressure lower	调整或更换 adjust or change
	4、 电路缺相 dedamaged phase	检查 check
	5、 上下工位没到位 upper station or lower station not in place	检查 check
	6、 中间继电器损坏 intermediate relay damaged	更换 change
	7、 行程开关损坏 travel switch damaged	检查 check and change
电源跳闸 tripping operation	1、 发热板短路 heating plate short circuit	检查 check
	2、 电压异常 voltage is abnormal	检查 check
	3、 发热板高温线漏电 Electric leakage in high temperature wire	更换 change
	4、 进线空气开关损坏 air switch for inlet wire damaged	检查 check
工作台面不会下降 working table can not descend	1、 电磁阀异常 megnetic valve is abnormal	检查 check
	2、 下降快慢阀异常 valve for descending is abnormal	调整 adjust
	3、 油路通断异常 oilway is abnormal	检查 check
	4、 油压表异常 oil pressure gauge is abnormal	检查 check

工作台面时间不显示 When working table have risen, time can not be displayed.	1、压力异常 pressure is abnormal	检查 check
	2、时间显示表故障 timing indicator damaged	更换 change
	3、压力阀压力过小 pressure from pressue valve is low	调整 adjust
	4、压力表压力过小或过大 pressure from pressure gauge is abnormal	调整 adjust
显示温度异常 display of temperature is abnomal	1、温控表故障 temperature control gauge damaged	更换 change
	2、发热板故障 heating plate damaged	更换 change
	3、固态接触器故障 solidcontiguity meter damaged	更换 change

平板机发热片更换

How to change heating plate

- 1、 打开机器上方罩壳及盖板
open the encloser and cover board above the machine.
- 2、 清理掉保温棉 take away the insulation cotton
- 3、 松开发热板固定螺丝及连接铜片
loosen the screws for fixing heating plate and copper sheet
- 4、 抽出旧发热板 draw off old heating plate
- 5、 插入新发热板，并放置在铝板中央
insert new heating plate in the middle of aluminium plate
- 6、 固定好发热板及连接铜片 fix heating plate and copper sheet
- 7 用以上步骤依次更换所需加热板。
change other heating plates according to above step
- 8 更换好所有发热板后，再次检查所有螺丝是否拧紧。
Check all screws to be tightened again after changing all heating plate