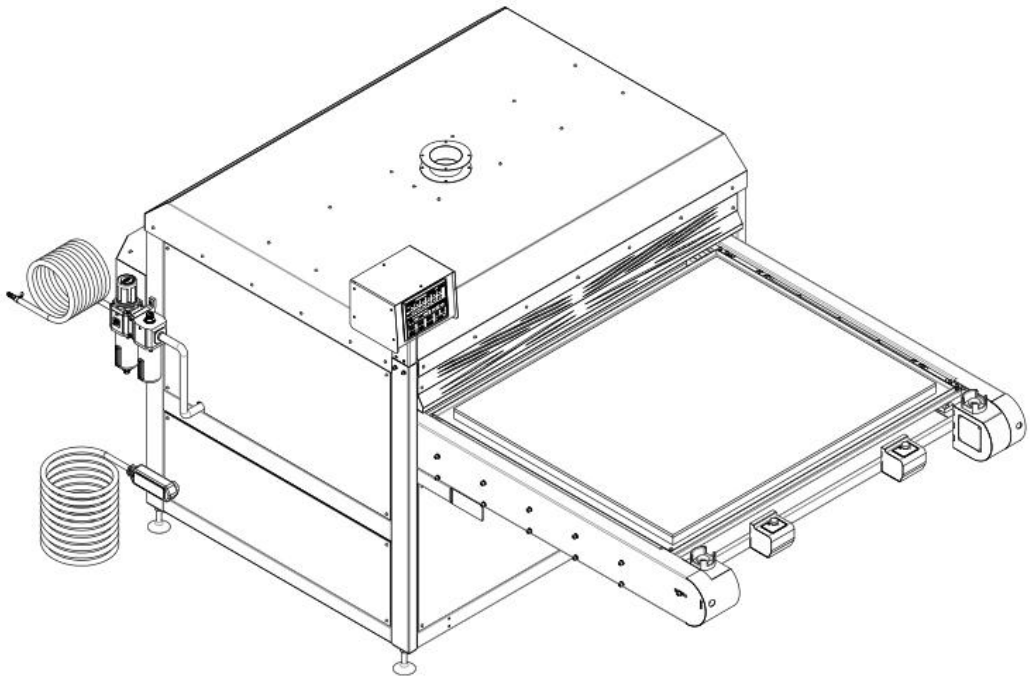
XSTM-48 Large Format One Side Two Stations Automatic Heat Transfer Machine



Content

Ⅰ. Introduction:

1. APplication:

1.1, This machine is suitable for Textile, Leather, Metal, Ceramic, Glass, Organic glass transfer, with colorful transfer images, and rich layers.

2. Feature:

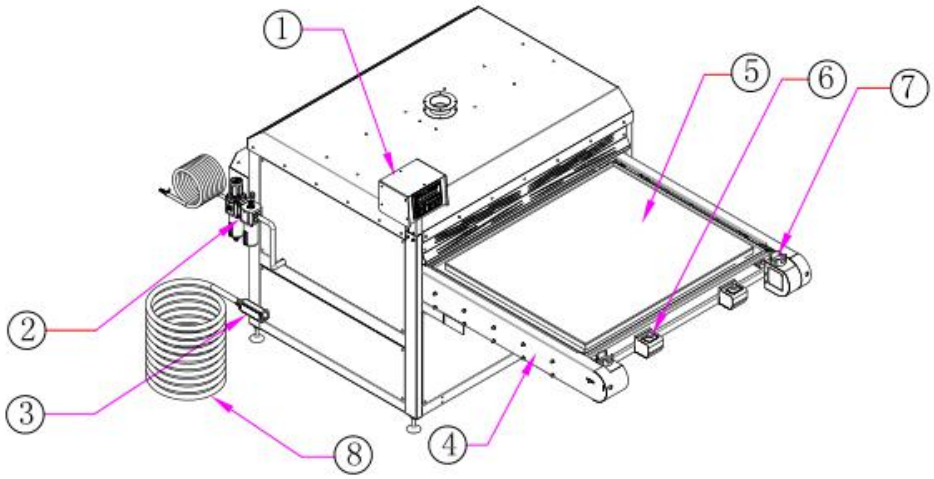
2.1, This machine adopts the advanced electric control technology, Double Station take turns to work automatic-ally. More accurate and safety limit switch, high reliability, long service life.

2.2, Use specific PLC controller (Programmable Logic Controller), High control precision, good stability. Large PLC screen display shows all datas clearly.

2.3, Heat platen using a new developed pluggable heat elements. The heating is more evenly, and temperature is more balance and stable. If one of the heating tubes is fulty during usage, customer can plug out and replace a new one, instead of replacing the entire heating element, which can save the cost a lot.

2.4, With dual air cylinder apparatus, higher pressure, more uniform, the transfer ranges is very wide.

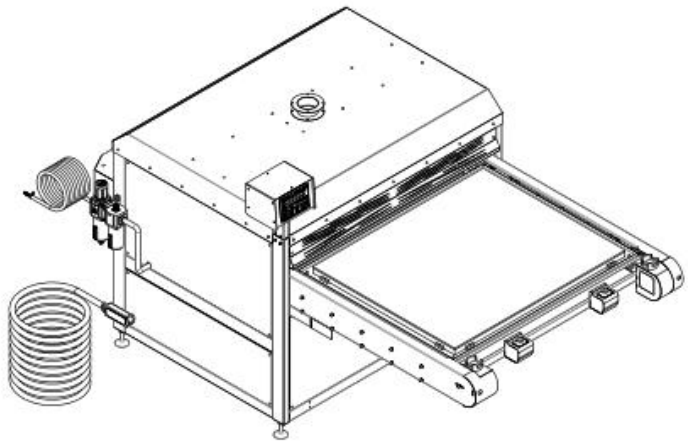
2.5, Installation and calibration is convenient and quick, easy to maintain and clean.



3. Assembly drawing

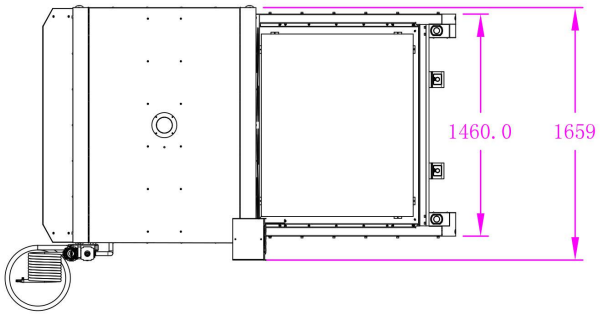
1. PLC control box	3. Over wire Explosion proof box	5. Up and bottom tray	7. Emergency stop button
2. Air filter	4. Left and right borders	6. Green Start button	8.Power cable

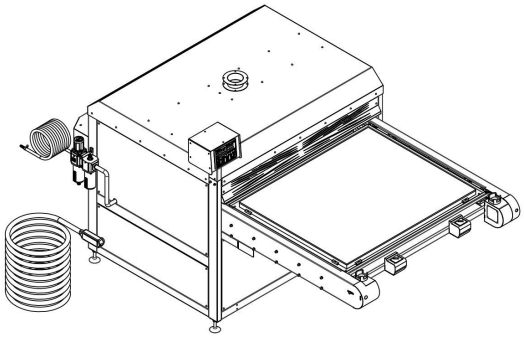
Ⅱ.Technical Parameters

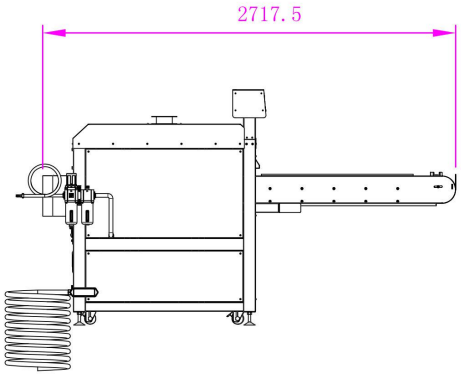


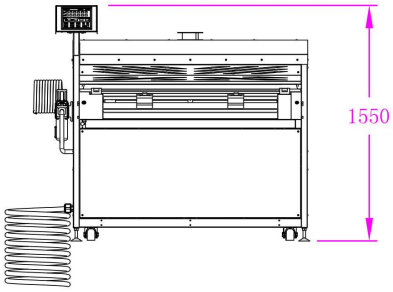
Machine Type	XSTM-40	XSTM-48	XSTM-68	XSTM-98
Heat Platen Size(mm)	800x1000	1000X1200	1200X1700	1500X2500
Voltage(V)	380	380	380	380
Power(W)	7500	9000	18000	25200
Current(A)	12	14	27	38
Heating Time(M)	45-50	50-55	55-60	55-60
Temperature Setting(℃)	225	225	225	225
Time Setting(S)	0-999	0-999	0-999	0-999
Transfer Range(mm)	800x1000	1000X1200	1200X1700	1500X2500
Pressure Value(Mpa)	0.4-0.5	0.4-0.5	0.4-0.5	0.4-0.5
Machine Size(m)	2316x1458x1550	2717x1659x1550	3130x2110x1550	4258x3197x1752
Net Weight(KG)	680	780	810	7000
Gross Weight(KG)	910	1100	1300	9000
Packing Size(mm)	1530x1580x1715	1870x1930x1730	2190x2080x1815	3530x2190x2195

Overall size of the machine









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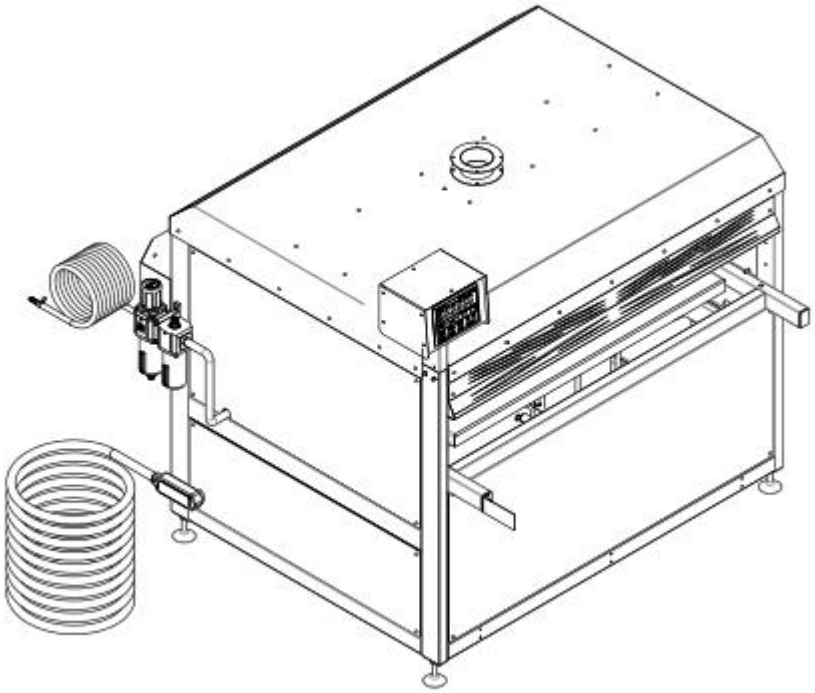
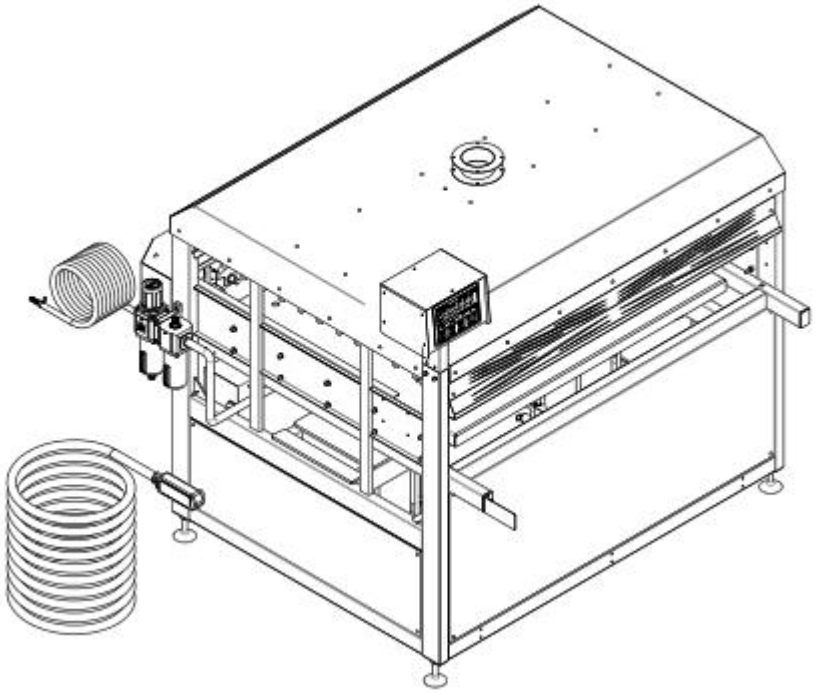
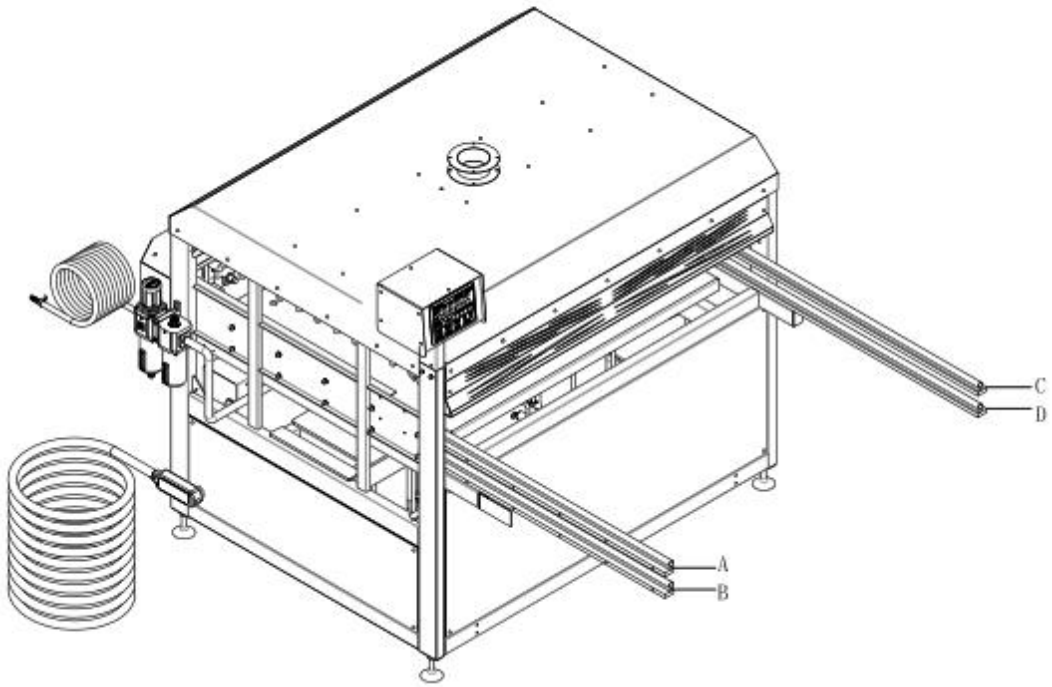
Ⅲ.Installation



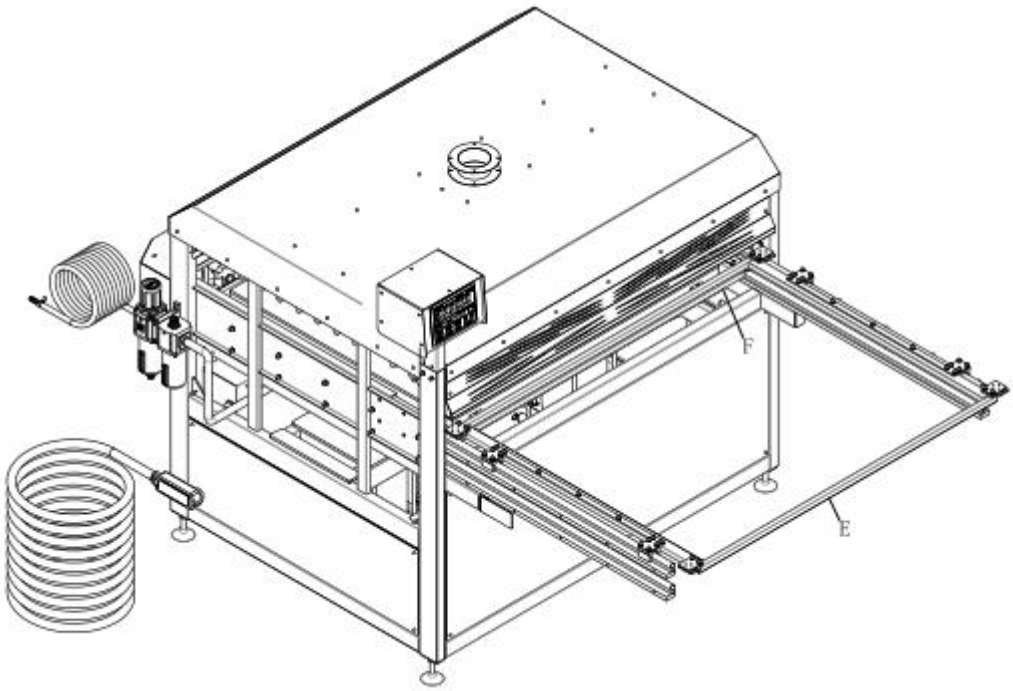
1. Open the carton box, the machine as shown above.



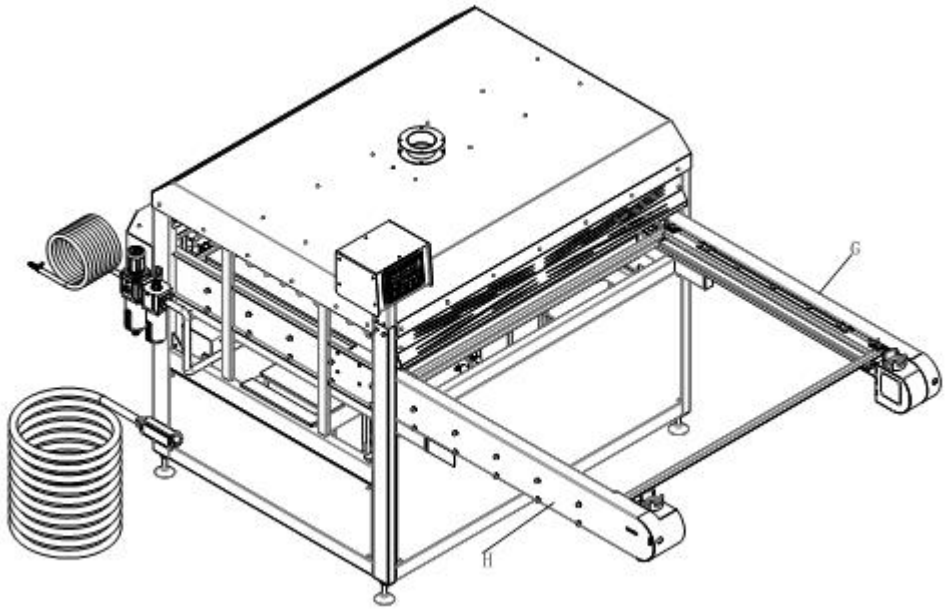
2. Check and make sure there is no any parts of the machine is missing or damaged during the shipping process. Demount the left and right panel, as shown above.



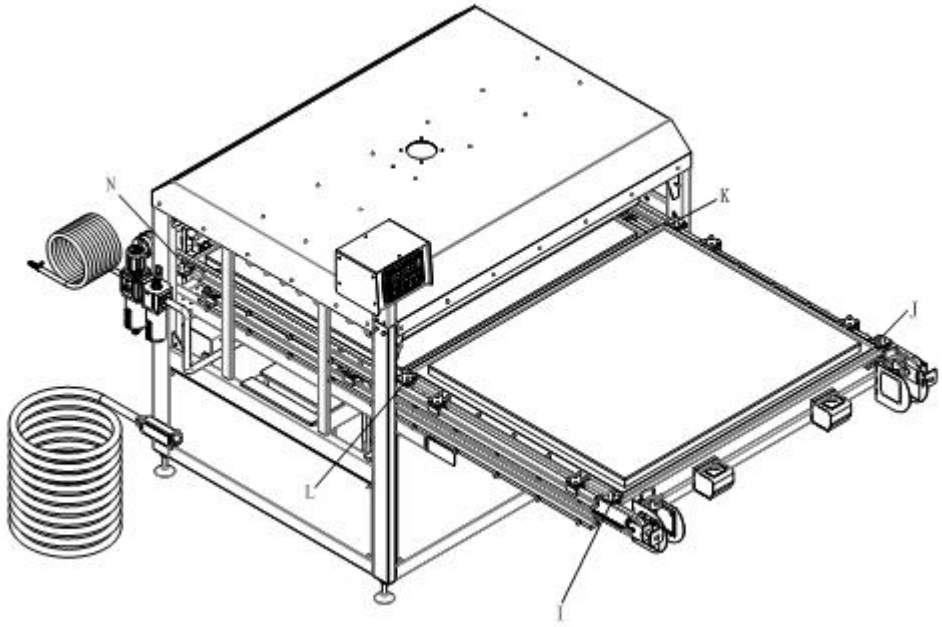
3. Demount Upper, Left and Right panel, then install the slide tracks. Fix the A,B,C,D slide tracks to the hole of the machine frame, as shown above(Fix the screw not to lock well)



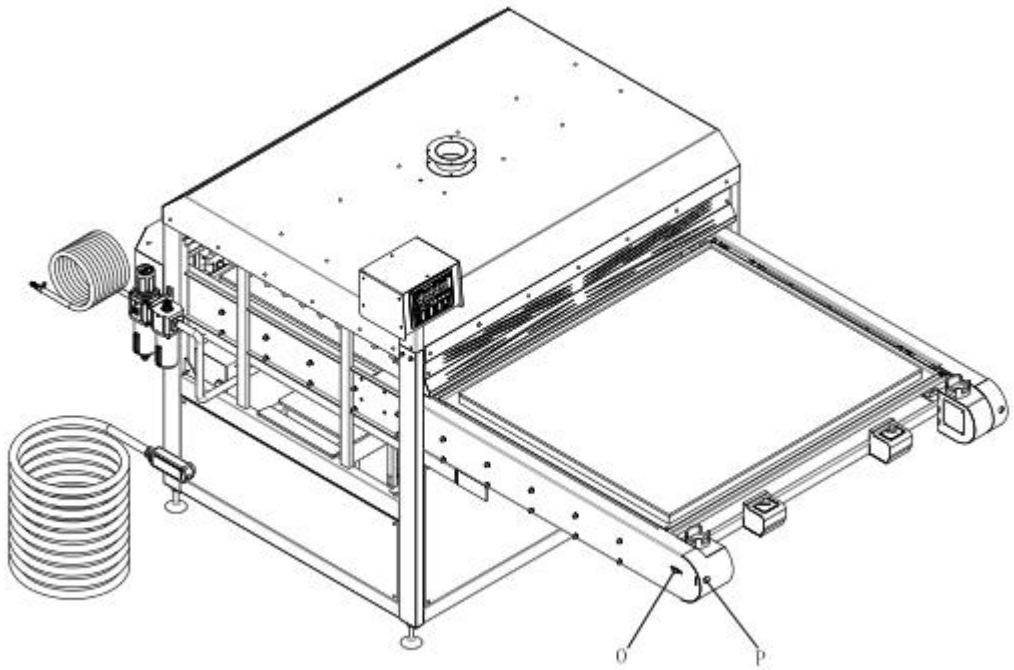
4. Fixed the slide tracks on the machine, Install the sliding frame E,F to the slide tracks. As shown above.



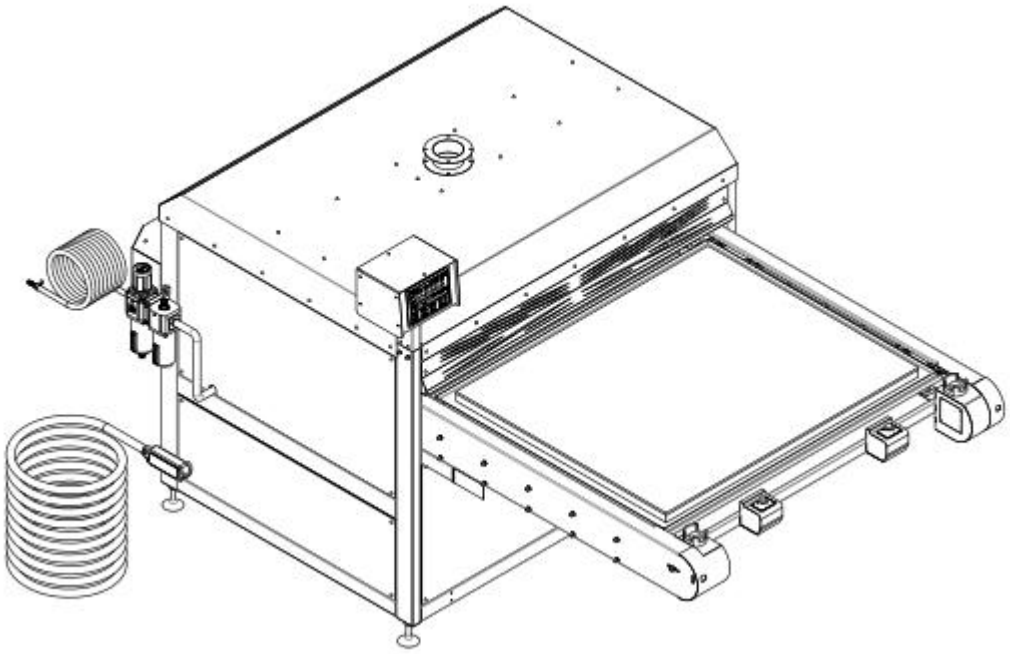
5. Install the left front plate of slide track H and right front plate of slid track G, lock the screw well.



6. Fix the I,J,L,K,N connector to the movable frame.



7. To adjust P points, This is the adjusting screw bolt of tension synchronous belts. Lock the screw bolt after tension the synchronous belts on O points.

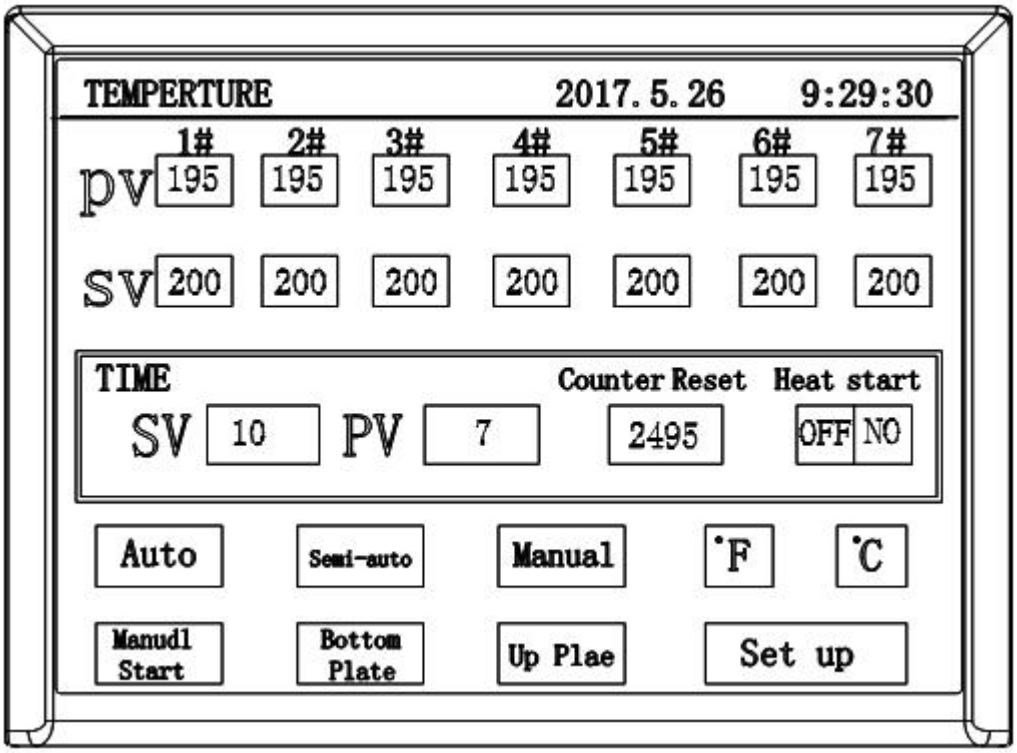


8. The machine finished assemble. Make sure the good ventilation and then to do the testing.

IV PLC controller operation instruction

1)Open the machine to display the PLC main interface, the upper row are heating zone, 1 to 6# shows the actual temperature, the second row for the temperature setting, from 1 to 6# or 7#, the third row is for time setting and countdown time, counter, heating start and close.

The fourth row shows auto, semi-auto, manual, ℉, ℃. The fifth row shows manual start, bottom plate movement, upper plate movement, setting up.



2)Press 1 # corresponding to set the SV position, enter the # 1 to the heating zone temperature setting, press ENT to save and then exit, CLR to clear the setting, ESC to reset; The same way for setting 2 to 6 #; Press switch in degrees Celsius or degrees ; After the setting, press the heat start to open the heating switch, the machine wil enter into the heating mode.

(Adjustable temperature range is 50-225℃, 50-437℉, adjustable time range is 0-999)

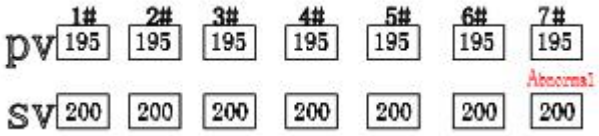
3)When the actual temp. reach the setting temp., press the manual button to enter into the operation mode, press the bottom plate until it reach the lower limit and then stop, press the manual start to begin the heat press transfer and countdown. When the countdown reach to 3seconds, the buzzer warning until the countdown reach to o. Upper platen reset to the upper limit, the heat transfer of the upper platen been finished.

4)When the bottom platen move to the lower limit or when the upper platen move to the upper limit, press the semi-auto button on, the machine will enter into semi-auto mode(A single transfer).

5)When the bottom platen move to the lower limit then stop or the upper platen move to the upper limit then stop, press the auto-open button on, the machine enter into the auto mode(Cyclic transfer), operation process pls refer to step 3.

6)Press the reset button, the counter value flashes and then returns 0.

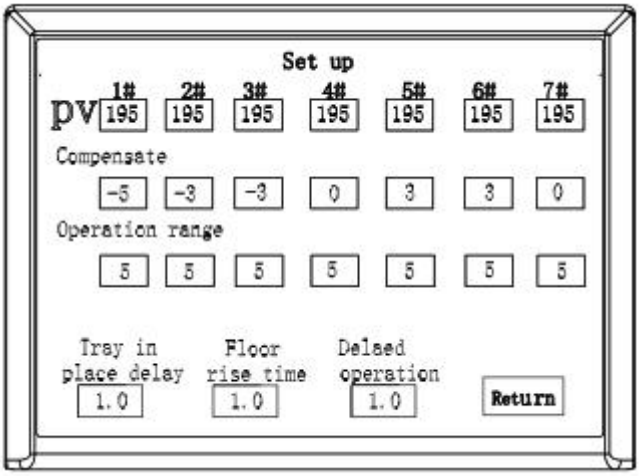
7)When one or more thermocouples are abnormal, Abnormal appears in the middle of the current temperature and the set temperature, and the heating is turned off and the machine does not warm up.



8)Press the set up can enter into the machine engineering model.

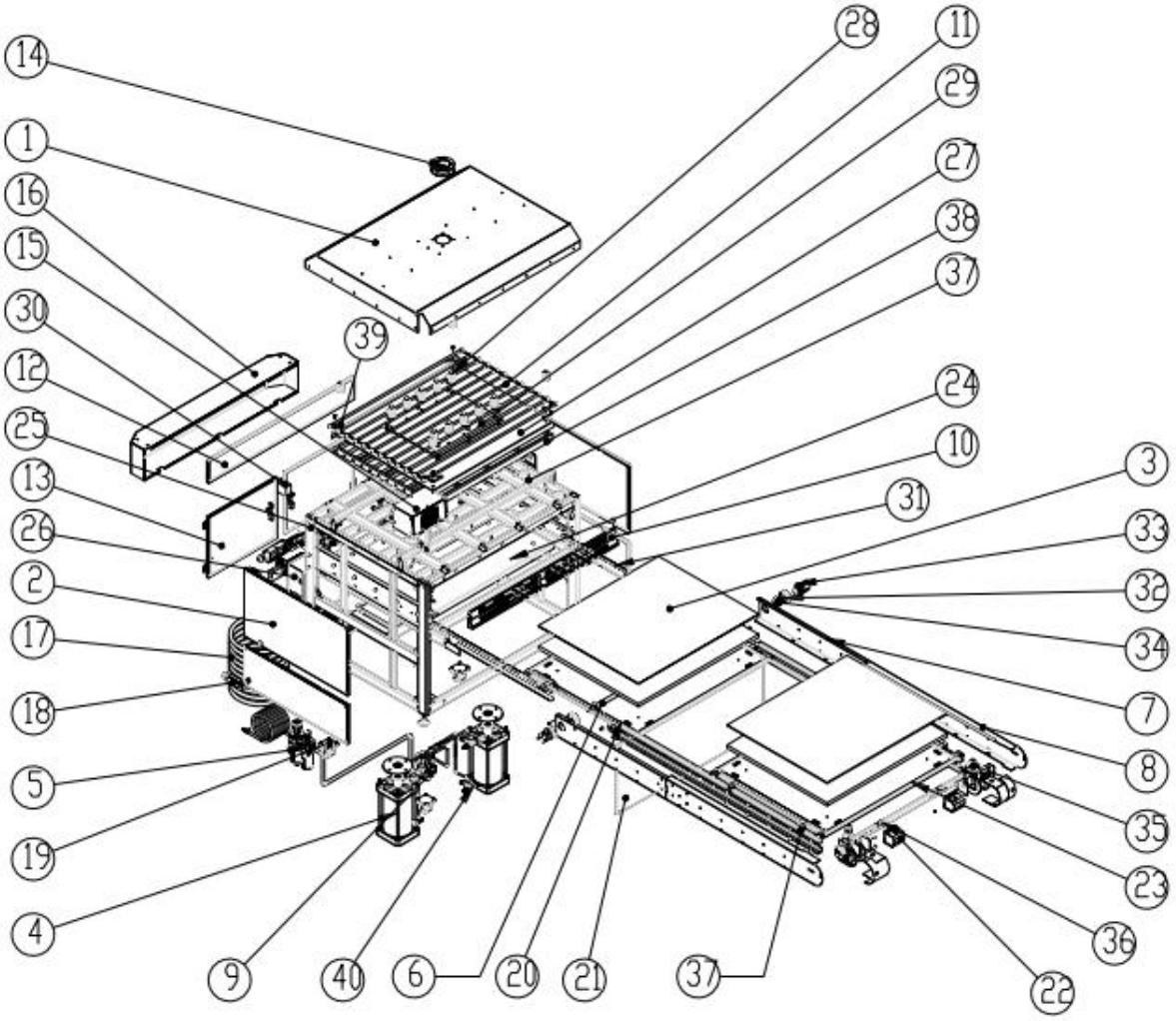
The first row show from 1# to 6# or 7# heating zone current temperature;

The second row show from 1# to 6# or 7# temperature calibration value, calibration range is -99-+99;



Please contact the supplier before you do the operation of above mode.

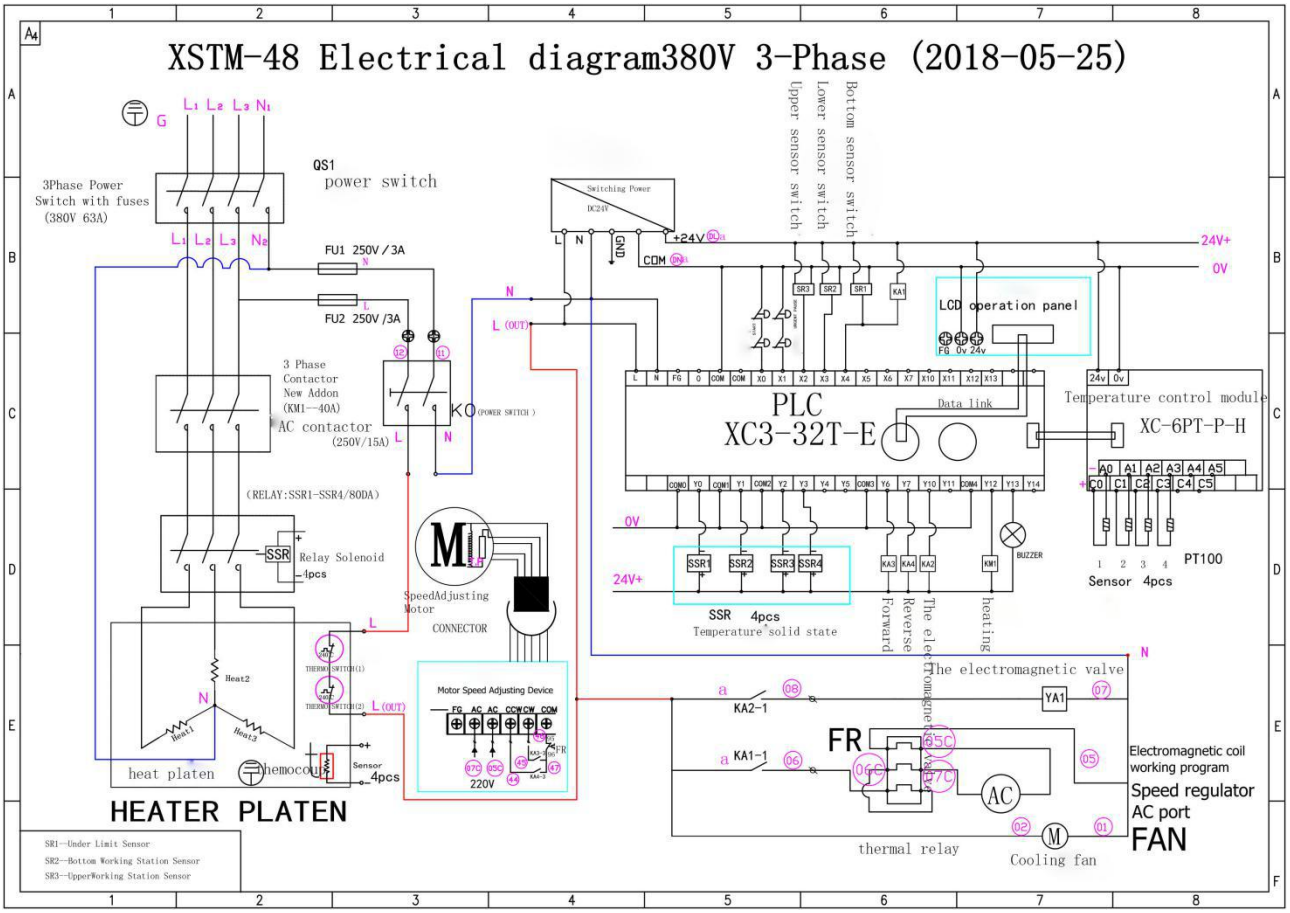
Ⅴ.ExplosionView



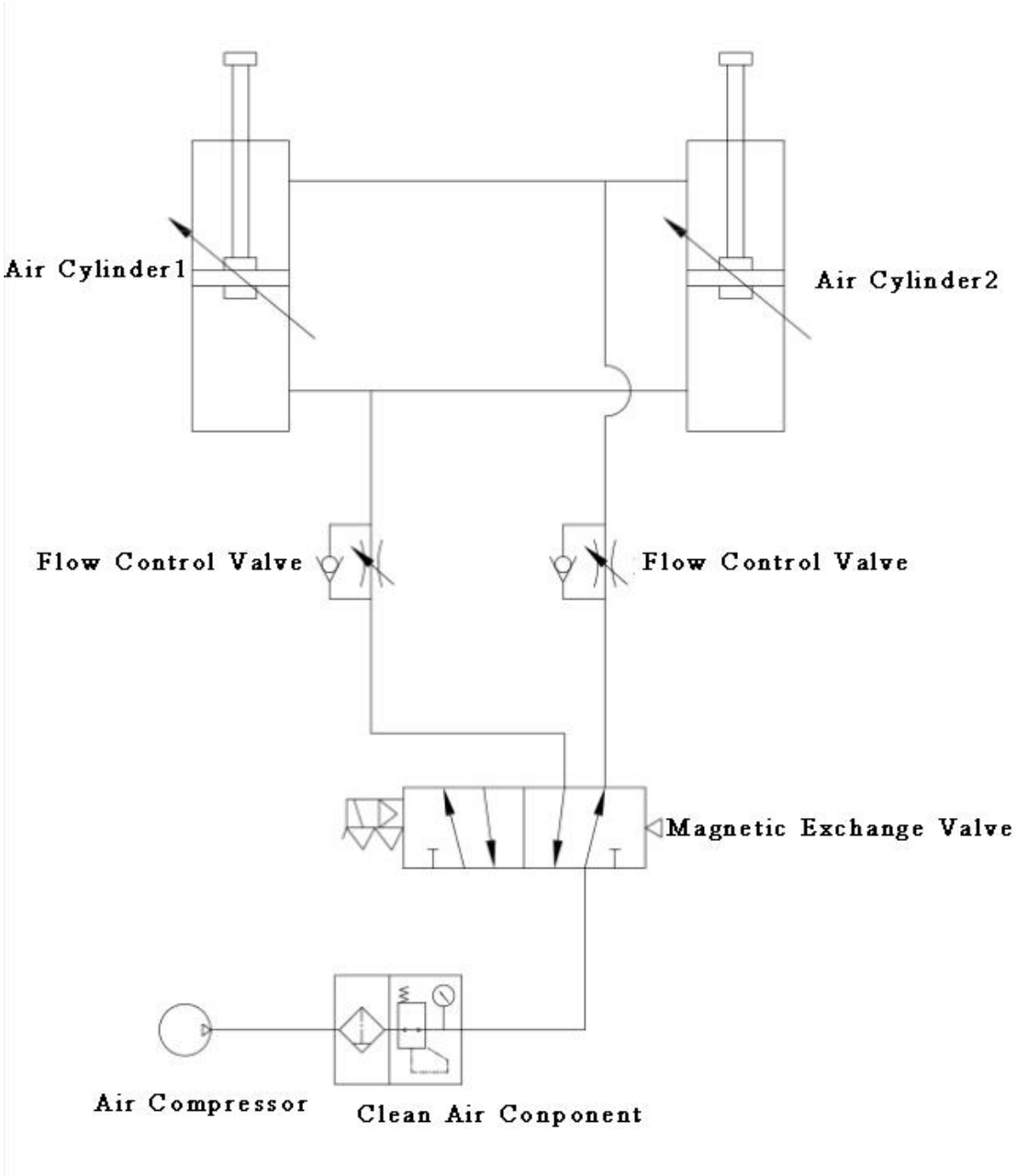
No.	Parts Description	Quatity
1	Upper cover	1
2	Left and right side panels	2
3	Silicon pad	2
4	Air cylinder	2
5	Filter	1
6	Transmission rod	1
7	Rear navigation fixed plate	2
8	Front navigation fixed plate	2
9	The electromagnetic valve	1
10	Front decorative panel	1
11	iron tube	12
12	Rack rear trim panel	1
13	Electric door panel	2

14	Fan fixture	1
15	Control box	1
16	Drive shaft guard	1
17	power cable	1
18	Explosion box	1
19	Casters	4
20	guide	4
21	Rack front side panel	1
22	Start control box	2
23	Activity framework	2
24	Lifting base plate	1
25	Overall rack	1
26	Lower control box	1
27	Heating plate cover	1
28	Fixing bolts	6
29	Upper adapter plate	1
30	Governor	1
31	Timing belt	4
32	Synchronous wheel	4
33	Fixed flange	2
34	gear	1
35	Emergency stop switch	2
36	start up button	2
37	Opening slider	8
38	Heating plate	1
39	Heating plate Pad	4
40	Steel tee	3

Ⅵ.Electrical Diagram



Ⅶ XSTM-48/68/98 Pneumatic schematic diagram



Analysis of common troubles

Failure phonomenon	Reason	Solution
1.No display on the controller panel when machine on work. The heat plates cant's be reciprocated under manual/Auto modes	1.Lack of electric power phase	Check the power source
	2.Fuse burned out	Check and replace the fuse
	3.Controller damaged	Replace the controller
	4.Station reciprocate motor failed	Replace the motor
2.No display on the controller panel when machine on work. The heat plates can be reciprocated under manual/Auto modes	1.Solid-state relay broken	Replace solid relay
	2.Controller damaged	Replace the controller
	3.Temperature value was set too high	Reset the temperature after cold reboot
	4.Temperature switch(inside heating palte)broken	Replace the temperature switch
3.Display works fine but the heat plates can be reciprocated under manual/Auto modes	1.Motor speed controller damaged	Replace the motro controller
	2.Synchronous belt broken	Replace the synchronous belt
	3.Synchronous wheels,sprockets slip	Locked the wheels sprockets
	4.Sensor broken	Replace the sensor
4.occasionally stopped on Auto modes when transferring	1.The switch loose	Locked the limite switch
	2.The distance between sensor and sensor shim is large	Adjust the distance
5.Do not heating	1.The solid relay went wrong	Replace the solid relay
	2.Heat platen goes wrong	Replace the heat platen
	3.Sensor broken	Replace the sensor
6.Switch trip when open the machine	1.The solid relay went wrong	Replace the solid relay
	2.Heat platen goes wrong	Replace the heat platen
	3.Circuites for leakage	Check the circutes