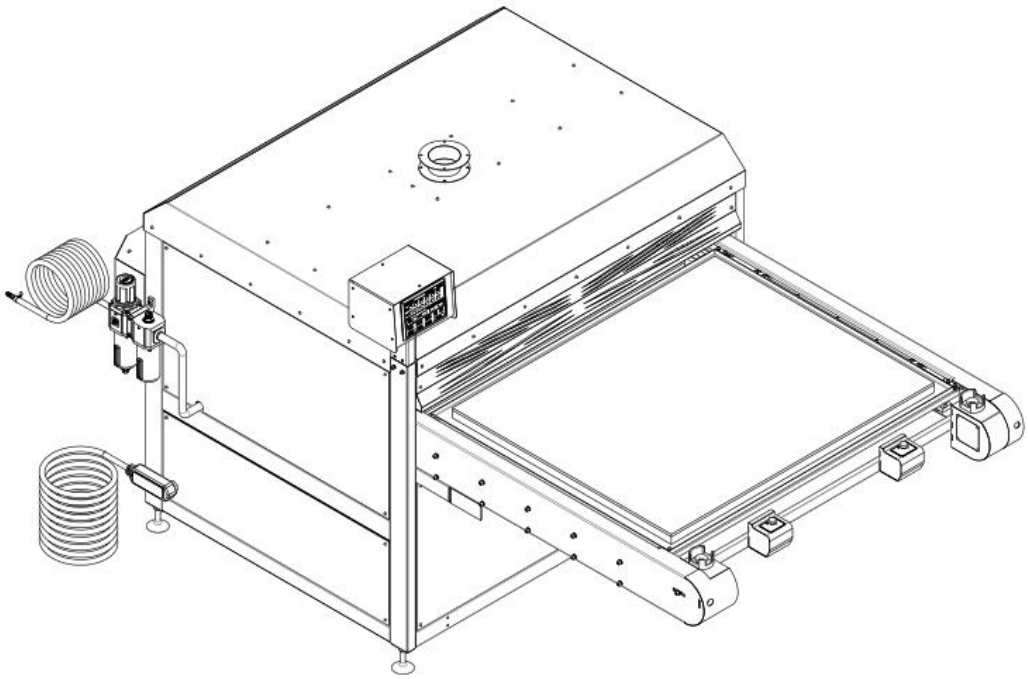
XSTM-98P Large Format One Side Two Stations Automatic Heat Transfer Machine



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:

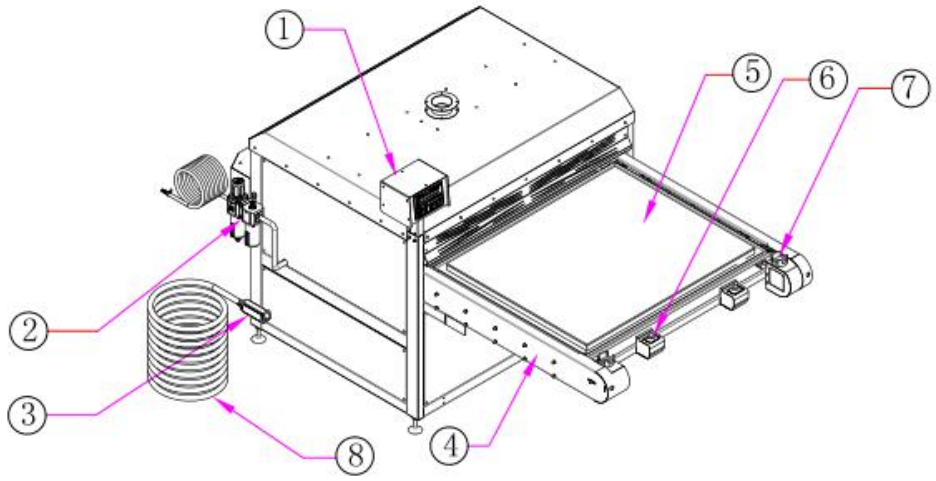
2.1, This machine adopts the advanced electric control technology, Double Station take turns to work automatic-ally. More accurate and safety limit switch, high reliability, long service life.

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.

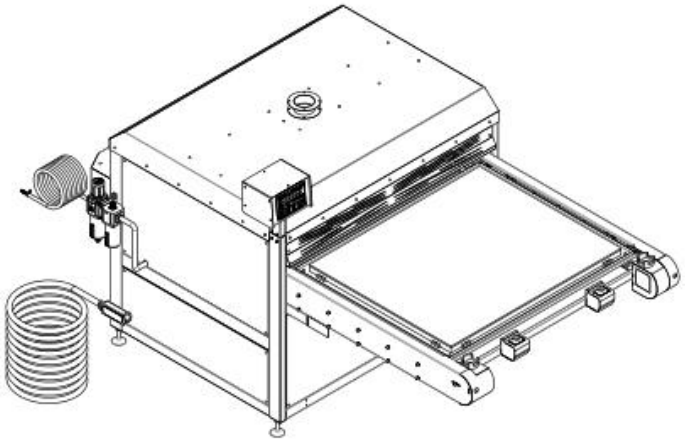
2.5, Installation and calibration is convenient and quick, easy to maintain and clean.



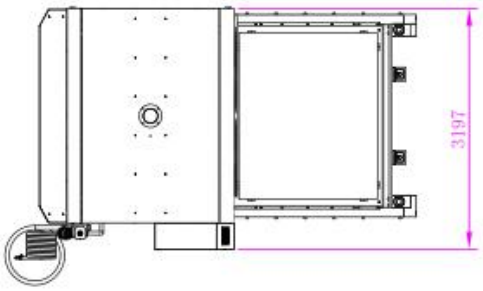
3. Assembly drawing

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-98P
Heat Platen Size(mm	1500X2500
Voltage(V)	380
Power(W)	25000
Current(A)	50
Heating Time(M)	100-110
lemperature Setting(C)	225
Time Setting(S)	0-999
Iransfer Range(mm)	1500X2500
Pressure Value(Mpa	0.4-0.5
Machine Size(m)	4258x3197x1752
Net Weight(KG)	2850
Gross Weight(KG)	4030
Packing Size(mm)	3530x2190x2195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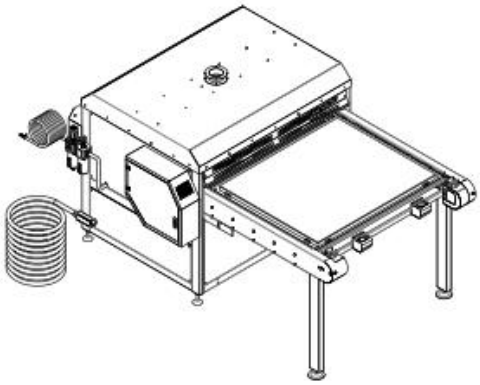

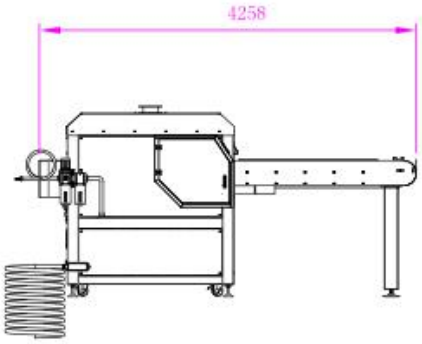
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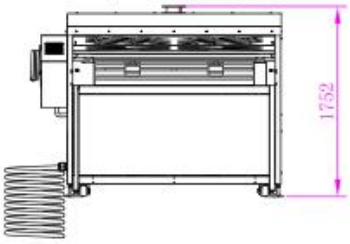
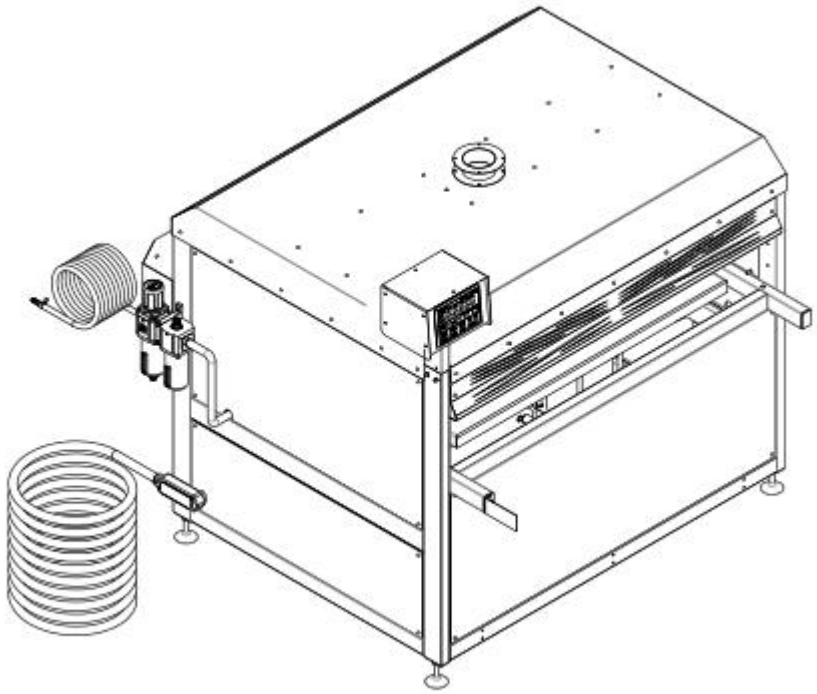
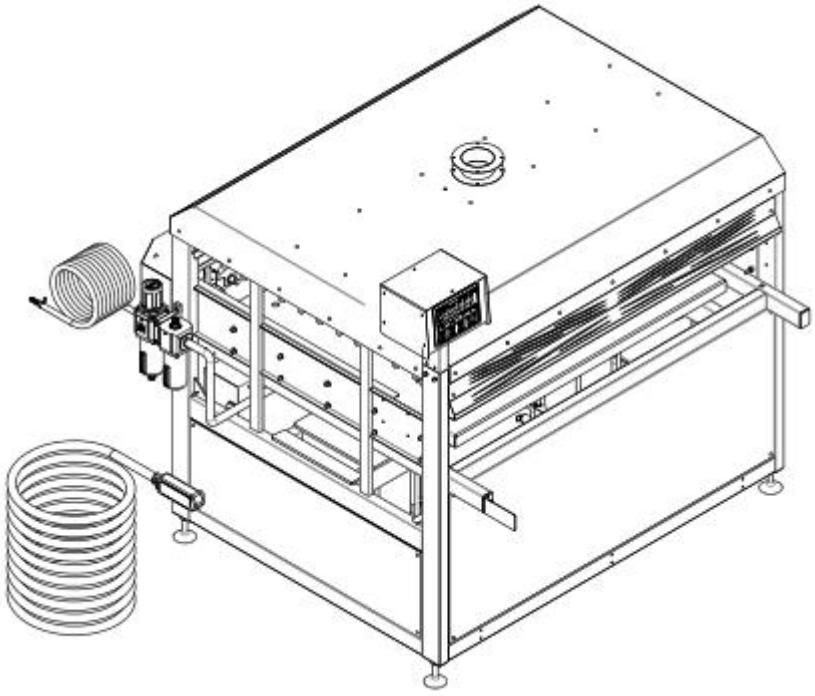

1752

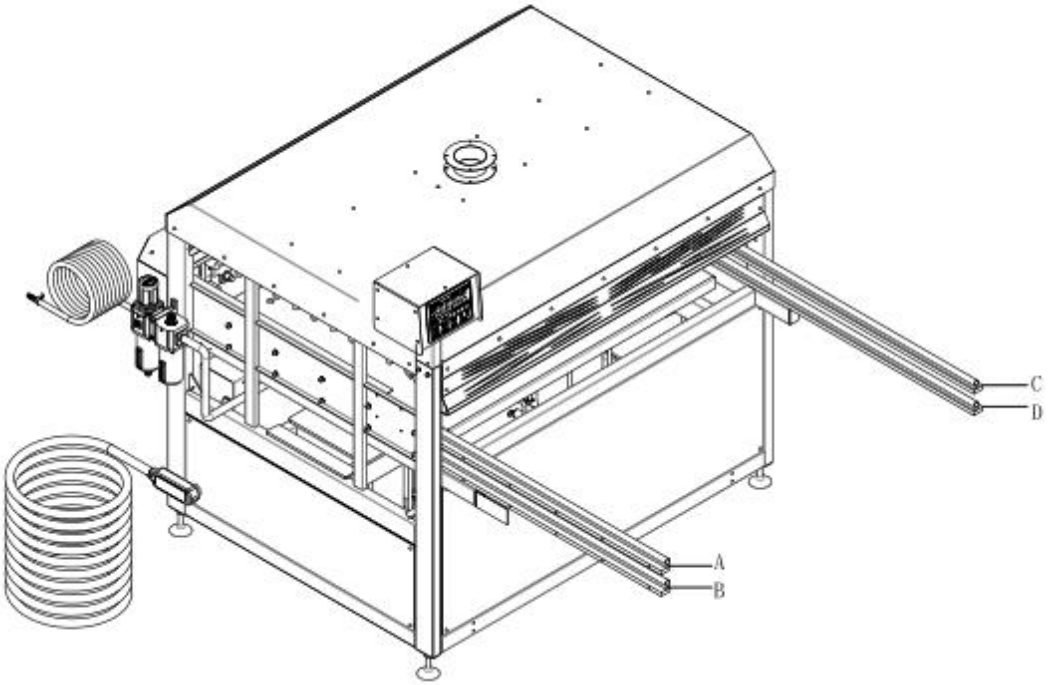
Ⅲ.Installation



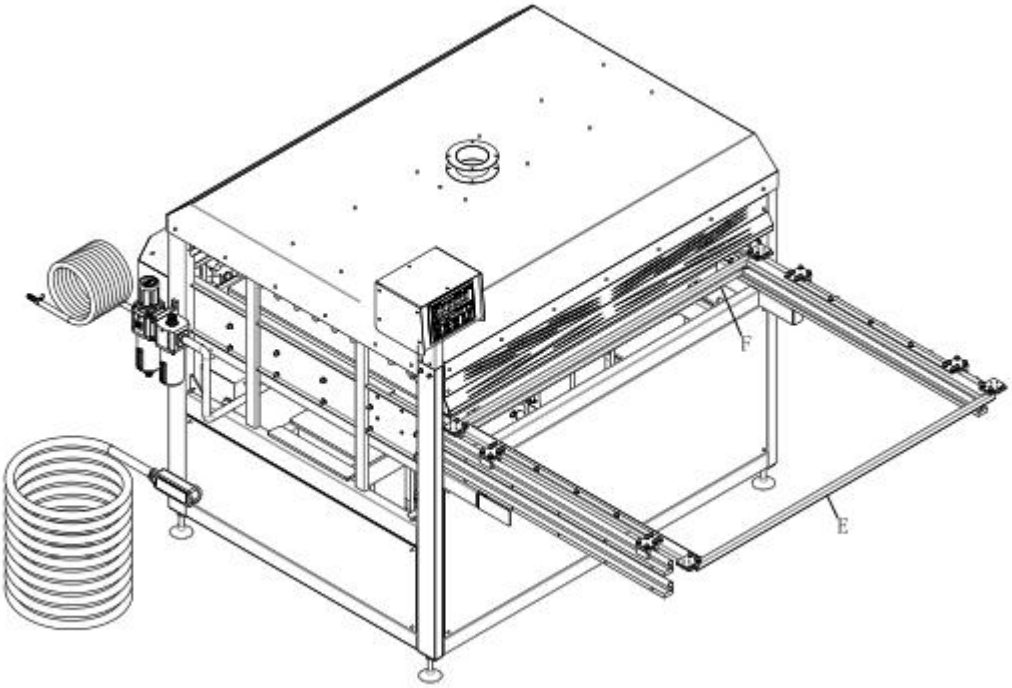
1. Open the carton box, the machine as shown above.



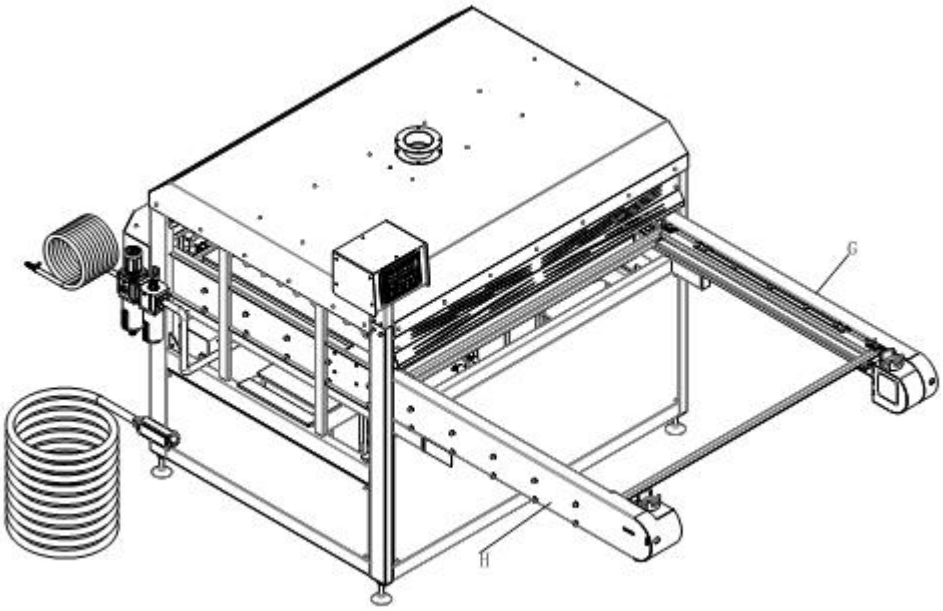
2. Check and make sure there is no any parts of the machine is missing or damaged during the shipping process. Demount the left and right panel, as shown above.



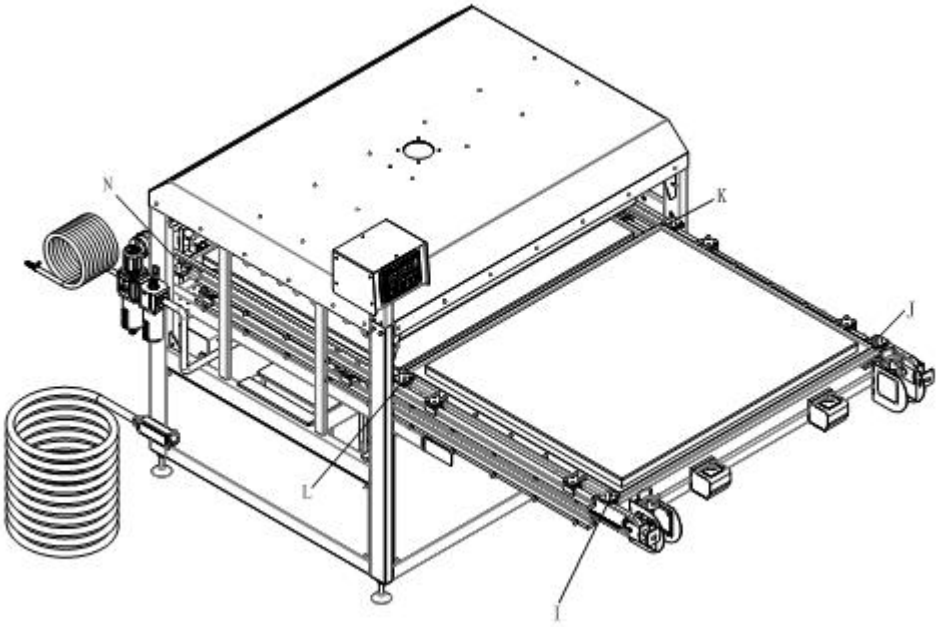
3. Demount Upper, Left and Right panel, then install the slide tracks. Fix the A,B,C,D slide tracks to the hole of the machine frame, as shown above(Fix the screw not to lock well)



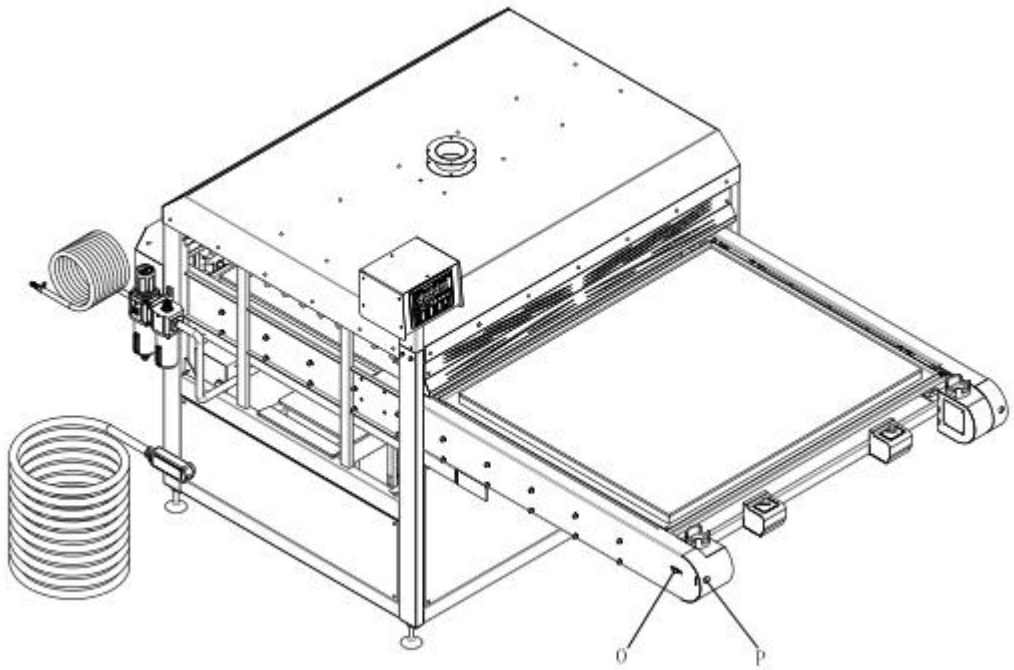
4. Fixed the slide tracks on the machine, Install the sliding frame E,F to the slide tracks. As shown above.



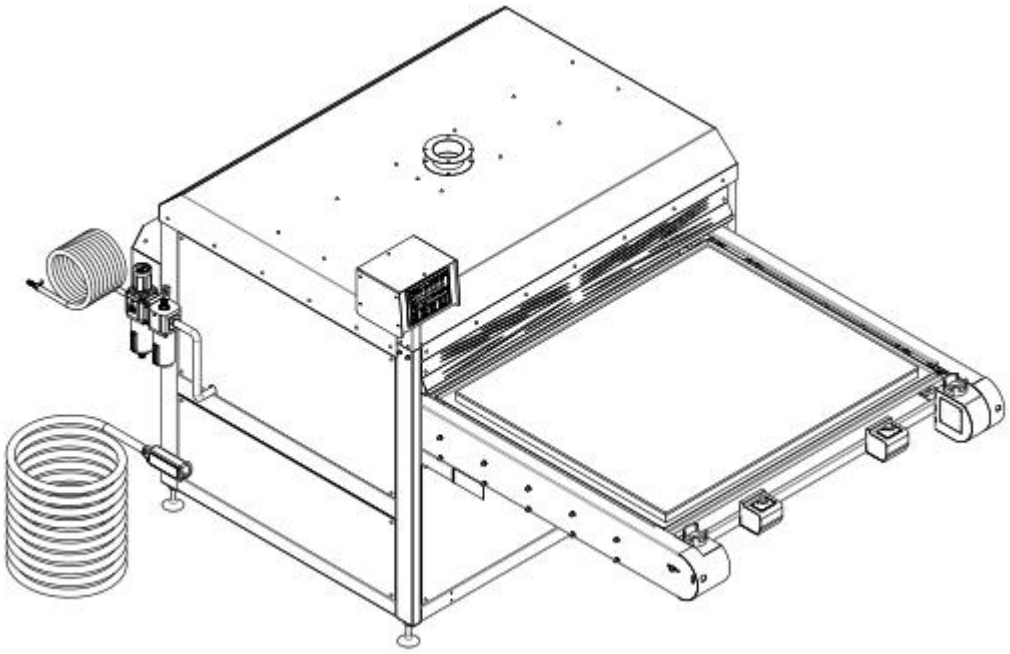
5. Install the left front plate of slide track H and right front plate of slid track G, lock the screw well.



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.

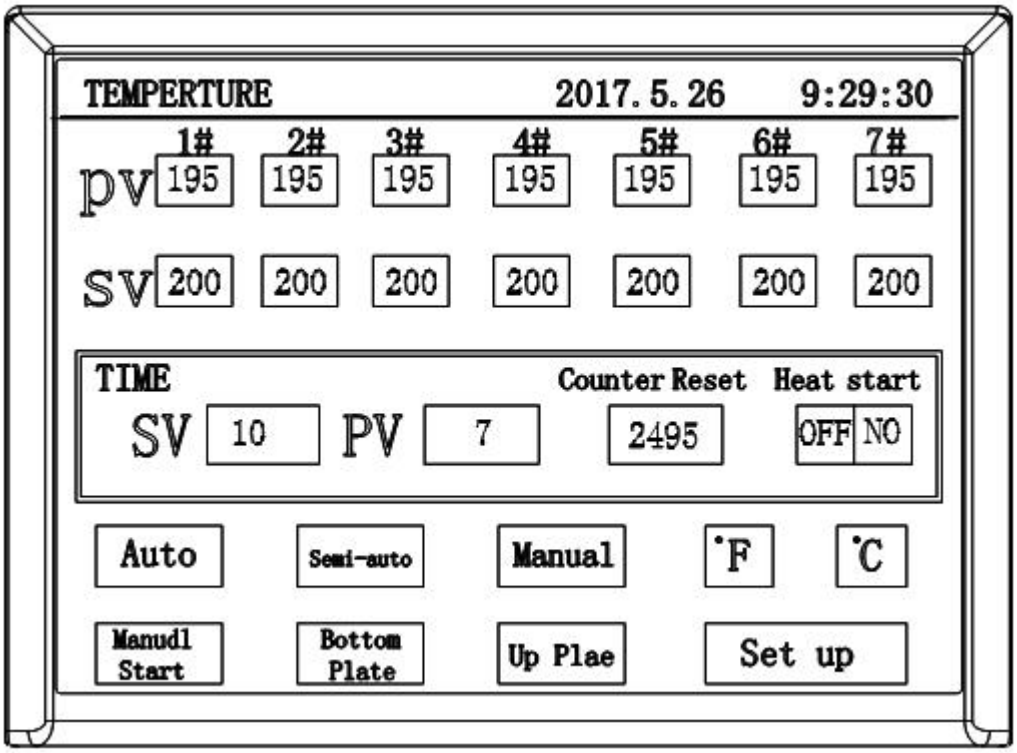


8. The machine finished assemble. Make sure the good ventilation and then to do the testing.

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)

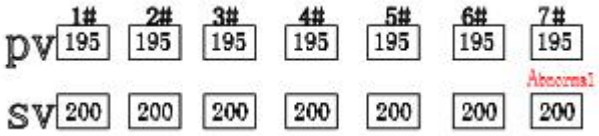
3)When the actual temp. reach the setting temp., press the manual button to enter into the operation mode, press the bottom plate until it reach the lower limit and then stop, press the manual start to begin the heat press transfer and countdown. When the countdown reach to 3seconds, the buzzer warning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

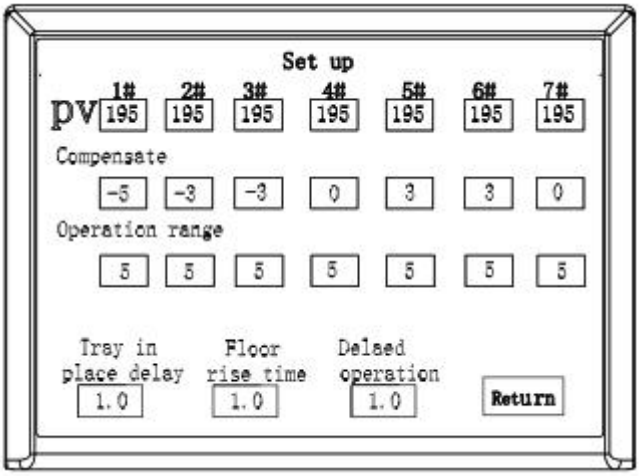
7)When one or more thermocouples are abnormal, Abnormal appears in the middle of the current temperature and the set temperature, and the heating is turned off and the machine does not warm up.



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

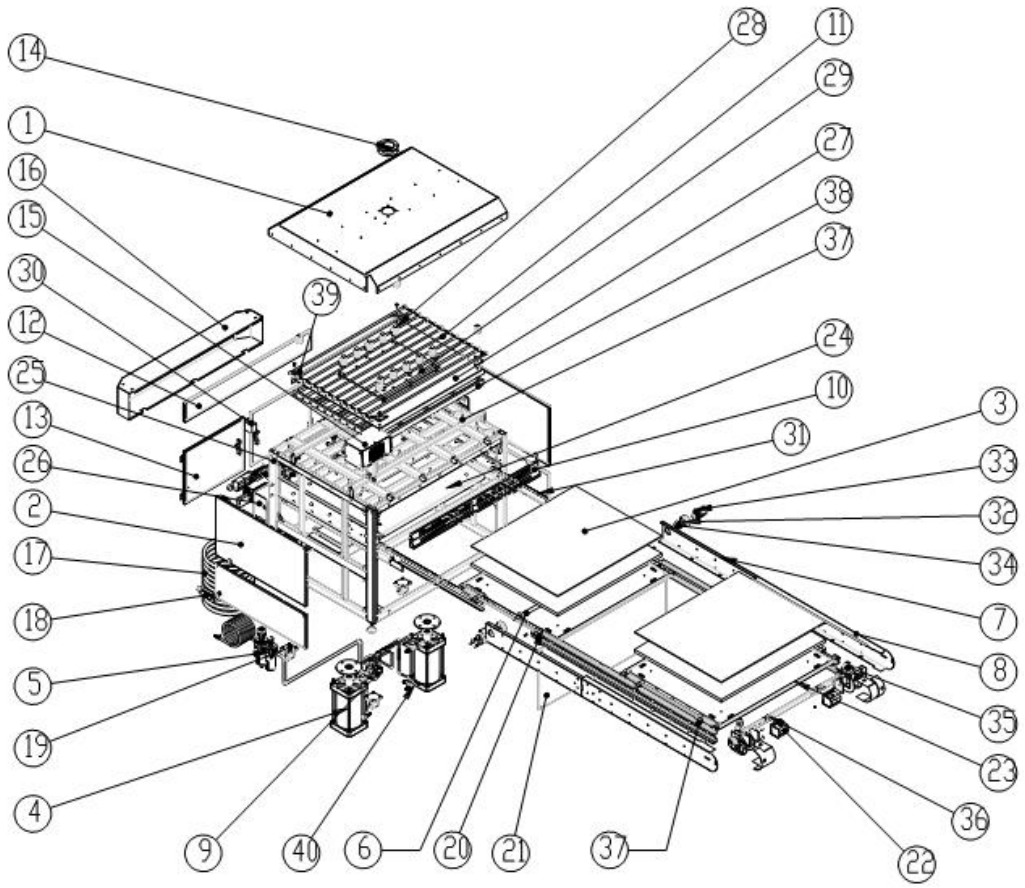
The first row show from 1# to 6# or 7# heating zone current temperature;

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.

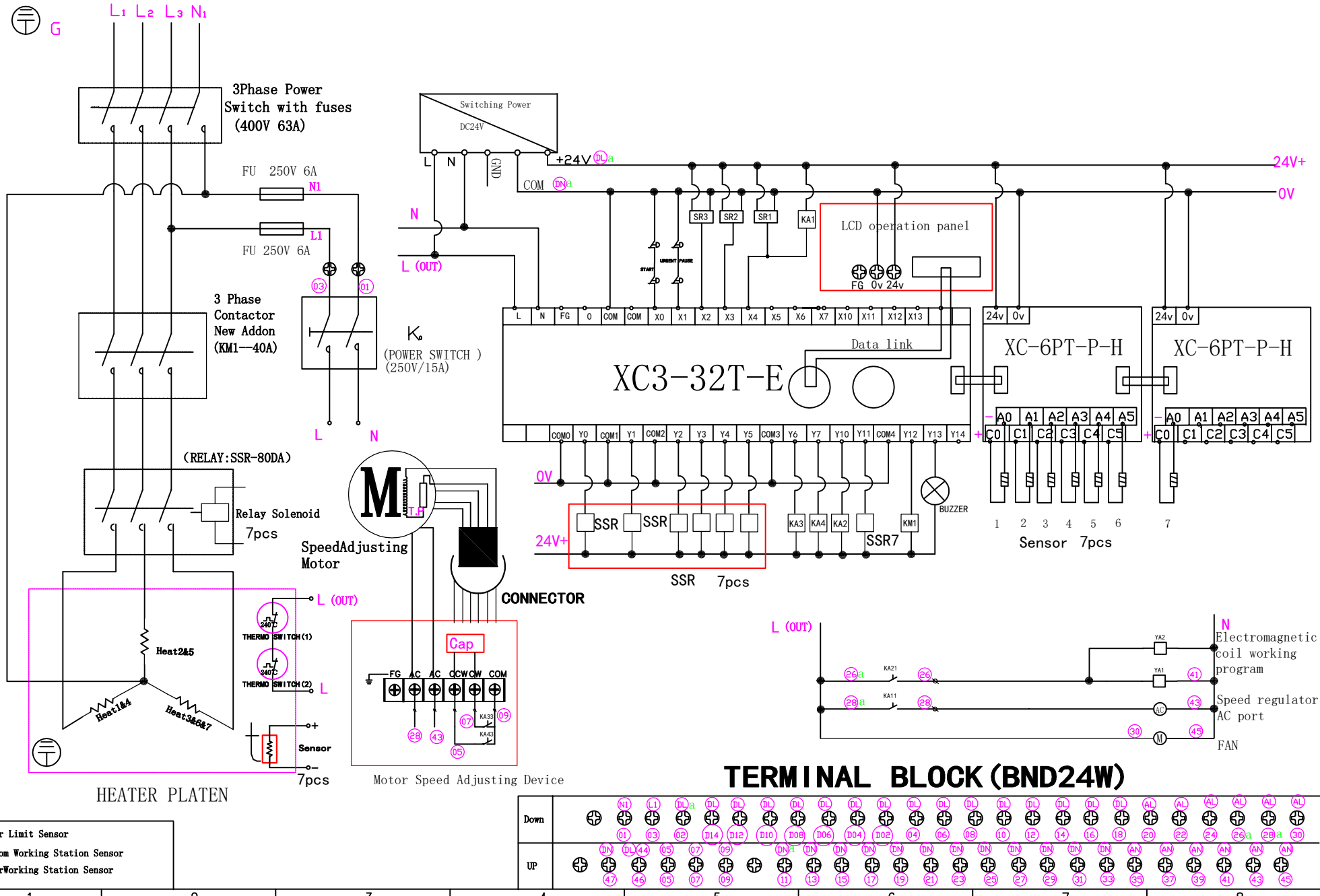
Ⅴ.Explosion View



No.	Parts Description	Quatity
1	Top cover plate	1
2	Side plate	2
3	Silicon pad	2
4	Air cylinder	4
5	Filter	1
6	Drive rod	1
7	Rear rail fixing plate	2
8	Front rail fixing plate	2
9	Solenoid valve	2
10	Front plate	1
11	Iron pipe	12
12	Backplate	1
13	Eletric box	2
14	Fixture for cooling fan	1
15	Electric box	1
16	Shield for drive shaft	1
17	Power cord	1

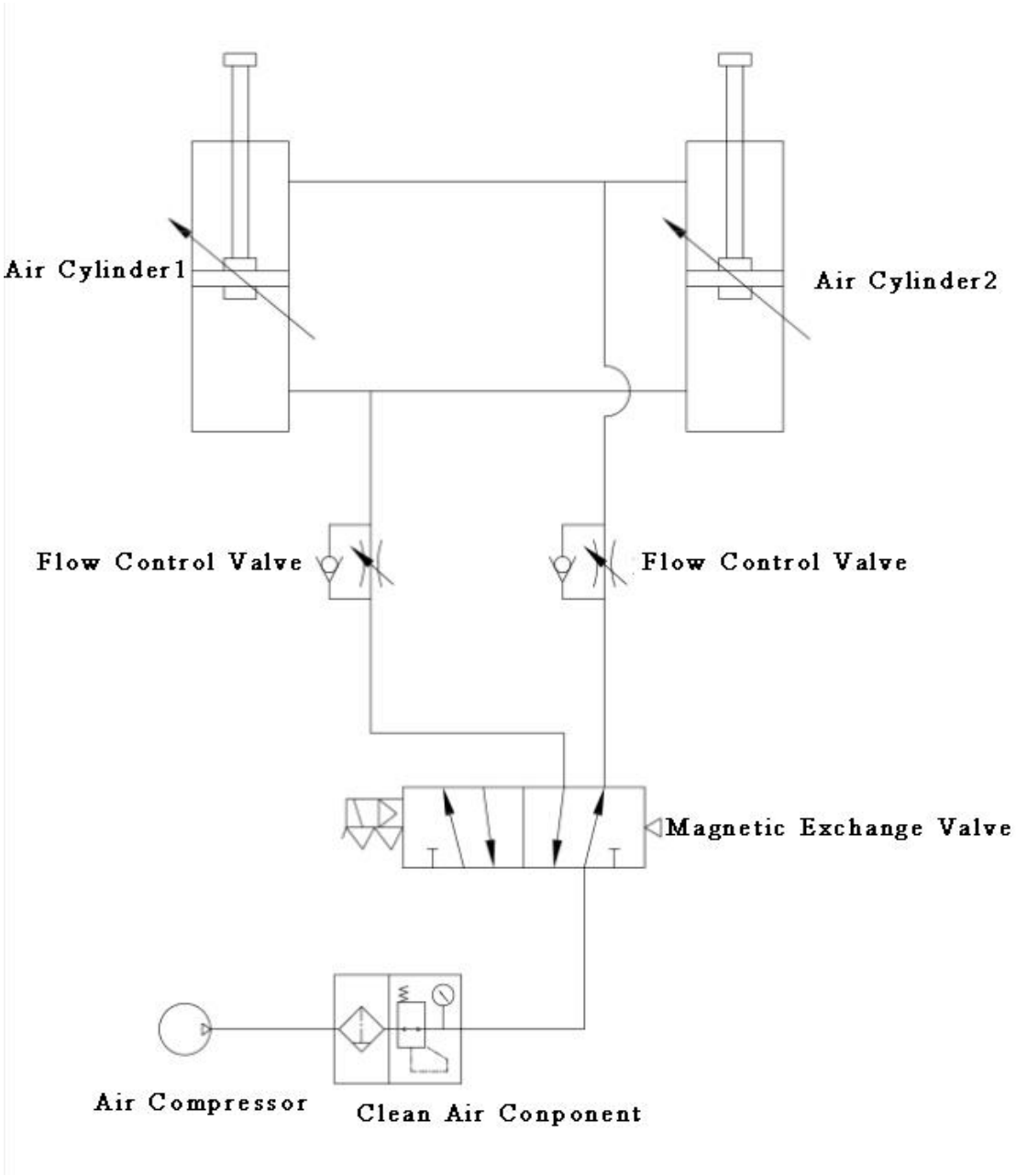
18	Unite box	1
19	Caster	4
20	Slide rail	4
21	Fallboard for the frame	1
22	Start control box	2
23	Moving frame	2
24	Lifting board	1
25	Machine frame	1
26	Lower electric control box	1
27	Cover plate for heat platen	1
28	Fixing bolt	6
29	Upper adapter plate	1
30	Governor	1
31	Synchronous belt	4
32	Synchronizing wheel	4
33	Fixed flange	2
34	Gear	1
35	Emergency stop button	2
36	Start button	2
37	Slide block	8
38	Heat platen	1
39	Shim plate for heat platen	4
40	Tee	3

XSTM-98P Electrical diagram 380V 3-Phase (2023-05-23)



TERMINAL BLOCK (BND24W)

Ⅶ XSTM-98P 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