



One、 Technical parameter

Model	Name	Max printing area	Printing speed	Vot/Power
EC-400X	Cylindrical screen printer	350*220mm	1500PCS/H OUR	220V 2.5KW

Two、 Control panel

1) Control panel



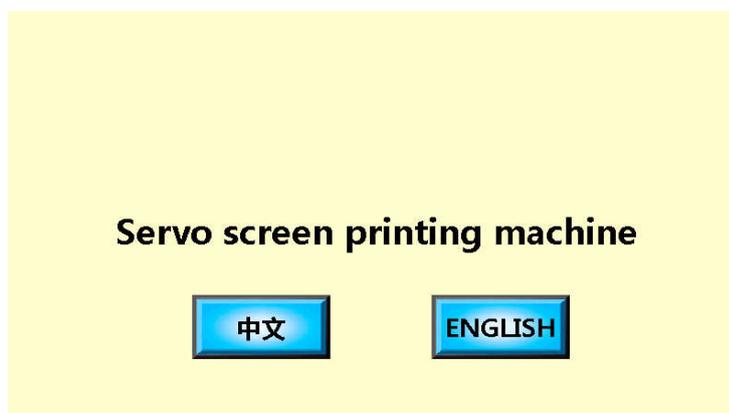
POWER(black button):Turn on / off the machine.

EMERGENCY (red button):Immediately stop the machine all the action.

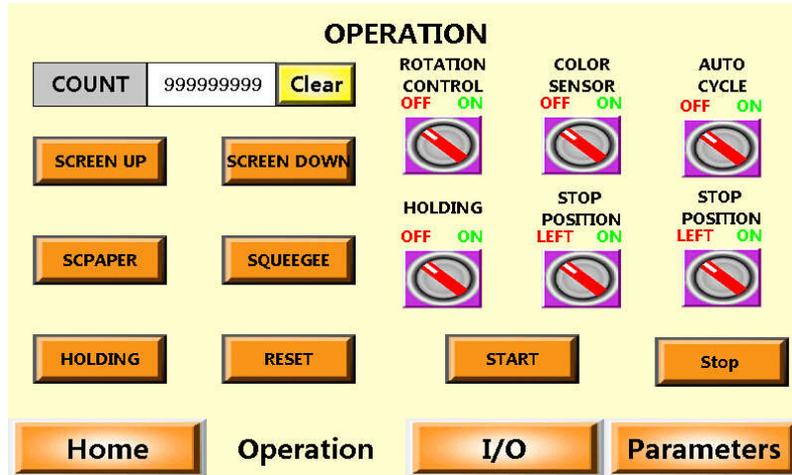
RUN (green button):Machine run / stop key. The effect is equivalent to the "start switch / stop switch" in the touch screen. Stop, press this button, the machine runs, and then click, the machine to complete a print to stop.

RESET (left black button): At shutdown, press this button and the machine will return to its original state.

2)Touch screen



中文/English: The system selects the text as Chinese/English.



Count: cumulative printing times.

Clear: Clears the current number of prints.

Screen Up / Screen Down: Status Display Key Displays the lift motor up / down.

SCPAPER/SQUEEGEE: status display key, showing the scraper cylinder / back to the cylinder cylinder running status.

HOLDING: The status display shows the operating status of the jacking cylinder.

Reset: The machine is running and reverts to the initial state.

Rotation control: Rotate function switch.

Control Search : servo registration function (search for electric eye) switch.

AUTO Cycle: cycle printing / single printing switch key.

HOLDING: the top of the nozzle when printing the key.

Stop position: printing is completed, the print head stop left / stop right.

Blow mode: select "continuous", the top of the mouth blowing function has been open, select the "timing", the top mouth blowing function in the printing open:

Start : press this button, the machine is running, the effect is equivalent to the "start (green)" on the workbench.

Stop : When the machine is running, press this key and the machine will stop after a printing cycle.

HOME: press this button, enter the "HOME".

Operation: Press this key to enter "Operation".

I / O : Press this key to enter "I / O".

Parameters:setting: Press this key to enter "parameters".

I/O表

X0	模块A相	X10	复位开关	X20	备用	Y100	*CA1	Y110	CONT1/MD
X1	色标CONT5	X11	急停开关	X21	备用	Y101	*CA2	Y111	CONT2/ST
X2	模块B相	X12	旋转完成	X22	备用	Y102	备用	Y112	CONT3/LOW
X3	旋转原点	X13	旋转OK	X23	备用	Y103	*CB1	Y113	CONT4/AW
X4	网版左限	X14	旋转报警	X24	备用	Y104	*CB2	Y114	网版升降
X5	网版参考点	X15	网版报警	X25	备用	Y105	备用	Y115	备用
X6	网版右限位	X16	变频报警	X26	备用	Y106	顶嘴气缸	Y116	色标电源
X7	网版上位	X17	脚踏开关	X27	备用	Y107	刮刀气缸	Y117	吹气阀
X8	网版下限	X18	备用	X28	备用	Y108	回墨气缸		
X9	启动开关	X19	备用	X29	备用	Y109	脉冲禁止		

返回

This interface is an input / output display.

PRINTING SERVO PARAMETER SETTING

SCREEN LEFT POSITION	-9999.99	MM	MANUAL LEFT	MANUAL RIGHT
SCREEN RIGHT POSITION	-9999.99	MM	ROTATE RIGHT	ROTATE LEFT
AUTO PRINT SPEED	9999.99	MM/S	SCREEN HOMING	ROTATE HOMING
PRINT RETURN SPEED	9999.99	MM/S	CURSOR SEARCH	HOLDING
PRINTING POSITION	-9999.99	MM		

Operating
Printing parameters
Rotation parameter
Other parameters
Parameter

This interface sets the parameters for the printing servo.

Screen Left Position: Sets the position of the left position of the taxi servo (the return point).

Screen Right Locator: Sets the position of the right position of the glide servo (the return point).

Auto Print speed: set the speed of the sliding servo in the machine printing.

Print return speed: Sets the speed at which the taxi servo returns after the machine is printed.

Printing position: to display the current position of the printed servo.

Manual Left: When stopped, press this button and slide the servo to the left.

Manual right: When stopped, press this button, the taxi servo to run right.

Rotate Right: When stopped, press this button to move the servo forward.

Rotate Left : When stopped, press this key to reverse the printing servo.

Screen Homing: stop, press this button, slide the servo to run until the return to the original position.

Rotate Homing: stop, press the button, the printing servo to run back to the original position.

Cursor search: stop, open the "Control Search", press this button, print servo run until the search point (need to work piece).

Holding: stop, press this button, top nozzle cylinder on / off.

Operation: Press this key to enter "Operation".

Printing parameters: press this button, enter the "printing parameters".

Rotation parameter: press this button, enter the "Rotation parameter".

Other parameters: Press this key to enter "other parameters".

parameter: This item is set before the factory is completed, no need to set again.

ROTARY SERVO PARAMETER

DIAMETER	-9999.99	MM	MANUAL LEFT	MANUAL RIGHT
Rotating shift	-9999.99	MM	ROTATE RIGHT	ROTATE LEFT
Search target speed	999.99	R/S	SCREEN HOMING	ROTATE HOMING
Rotate position	-99999.9	Deg	CURSOR SEATCH	HOLDING
				Sensor Description
Operating		Printing parameters		Rotation parameter
			Other parameters	Parameter

Diameter: Sets the diameter of the work piece.

Rotating Shift: Sets the offset value of the work piece after the cursor is aligned.

Search target speed, set the printing servo in the search when the rotation speed.

Rotate position: Displays the current position of the printing servo

Sensor Description: Press this key to enter "color label". This interface details the operation of the color eye.

OTHER PARAMETER

HOLDING TIME	99.99	S	AFTER PRINTING UP DELAY	99.99	S
SQUEEGEE DELAY TIME	99.99	S	CYCLE DELAY	99.99	S
SCREEN DELAY TIME	99.99	S	CYCLE DELAY	99.99	S

Operating
Printing parameters
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Holding Time: Set the running time of the nozzle.

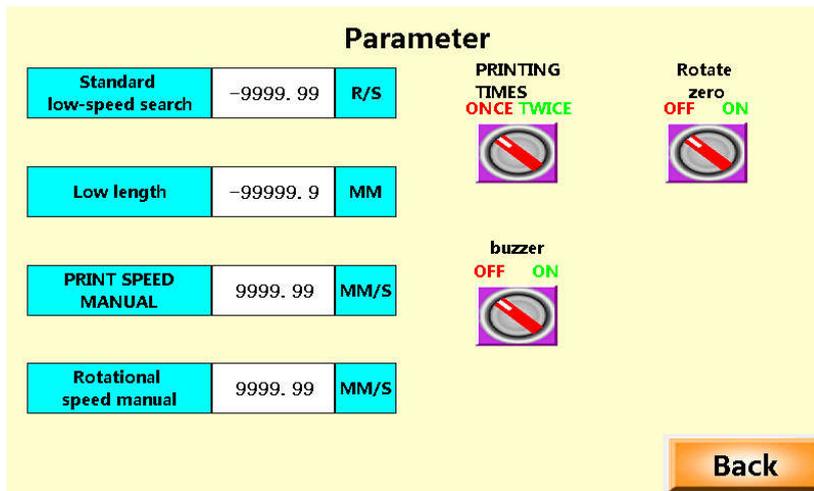
Squeegee Delay time: Set the time when the scraper is printed.

Screen delay time: set the screen when the delay time.

After Printing Up Delay:Start: Sets the delay time for the ink return.

Blowing time: set the time to blow your mouth.

Cycle delay: set the "cycle control" to open the next two printing cycles between the delay time.



parameter: This item is set before the factory is completed, no need to set again.

Three、 Installation,testing , usage

This machine is suitable for installation in a clean environment, not the amount of air flow, no dust and keeping the temperature around 25 degrees of the plant (the higher the temperature of the ink is more be vapping).

1, ready to put the machine room, and making enough position for inspection and maintenance. When removing the transport of wooden packaging, please check the machine weather is damaged by shipping. Any damage to the machine being in transit will not be included in the warranty, if found, Please inform the transport company or contact us.

2 preparation for starting

1) Power: 220V 50Hz; 2) Air supply: compressed air; 3) fixture: Making the special fixture is based on the shape of workpiece; 4) Screen plate; 5) ink.

3. Balancing the body of the machine.

Four foot board with distributed balance adjustment screw, at first,please put the original footpad one the ground to align screw, then loosen the nut on the screw, after that, screw clockwise so that the screw pressing foot pie, and then adjust the height of each of the four screws until after the body held in a horizontal position above the locking nut to prevent loosening.above the locking nut to prevent loosening.

4.Adjust the air pressure

Connected to the air mouth, adjust the air pressure, generally, regular work of the machine about 5BAR, if you found the barometer index is high, it can be pressed onto the first tune, and then counter-clockwise to the standard pressure, whereas, reverse adjustments .after that ,and then transfer press, locking pressure within the standard range. In order to make the normal operation of the machine, to prevent the infiltration of foreign water locally installed into a variety of precision pneumatic components, shall always be water or dirt filter plastic cups of draining the filter press drainage thimble up to several times discharge of sewage. While from time to time shall be added to the lubricating oil mist cup, in order to maintain the smooth functioning of the various pneumatic components (except air source must first release the mist cup)

5. Testing for all parts of the machine

The whole machine is controlled by a servo system operation, the machine has been debugged before shipping, generally you do not need to debug.

1) Plug in the power, and the power switch is turned on, please check touch screen whether it can display, if it can display, please operate the machine after 1 minute ,if no display Check the power cord.

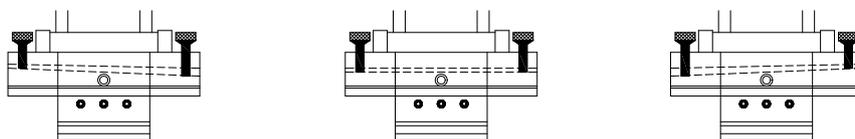
2) in the touch screen of the "parameters" interface, press "manual" test the servo system weather is normally .

3) Press the "start" button, turn on automatic printing status, please check servo system and the blade portion weather is normal, weather it can be printed normally.

6,scraper and printing head adjustment scratch

1) scraper adjustment

A. height position adjustment: use two trim knob, respectively adjusting the level of printing scraper (you can as the depth of scraper), with a limit on the catch off the wiper speed adjustment, in order to avoid heavy impact-generated vibrations.
 B. horizontal position adjustment: cup head screws are the center of rotation of the scraper seal, loosen cup head screws, use four high angle adjustment knob can scratch and halftone printing parallel, respectively, and then the cup head screws print scratch.



2) adjust the printing head

A. adjust the print head height By adjusting the lift knob

B. The slide adjusting screws loosen, the print head can be moved back and forth.

7. adjust screen arm

1) Install the screen

Arm around the back of the screen release locking screw, move the right arm

to the left and right screen position, put the screen plate, the locking knob is fixed, then the back of the lock between the locking screws (the distance from stencil to work piece about 1-2MM).

2) the height position of debugging screen: First loosen the locking screw lift lines, and then adjust the lift knob after completion of the locking screw.

3) the location of the front and rear screen debugging: loosen the nuts, and then adjust the trim knob, you can. Or release

The frame is fixed knob, you can move the screen around.

8, added to the ink to make a sample for testing (two-color patterns need to be process color)

After checking all the above steps correctly, you can start a normal print.

Four, the silk screen Notes

1, the workshop should be kept clean state, because the dust will seriously affect the quality of printing,

2. according to the products shape to make a proper jig.

3, when the printing occurs plug screen plate, please use dilution water or wash water to clean the screen plate, It is forbidden to use thinner to clean it, otherwise the screen and thinner will make chemical reaction to destroy silk screen pattern .

4, check the squeegee, whether the appearance is suitable for the products There are flat squeegee scraping (square corners) and two sharp scraping, When the products are flat ,or relatively flat printing ,please use flat scraper (square corners) squeegee is appropriate, it is better for printing ; when the products is convexo-concave please use a sharp scraping squeegee to print ,it is appropriate, printed better results.

5, according to the requirements of the printing pattern, select the appropriate density mesh to make screen.

6, please adjust the concentration of the ink before printing, if the ink is thick, lead to the ink lose activity, also it will be blocked, therefore, it is difficult to print, if the ink is too thin, will lead to the printed pattern or color line is not enough deep, easy fluff lines and other defects, so adjust the screen printing ink must not be taken lightly. The wide range of ink, must use consistent with the characteristics of products, then you can get a better printing results.

7, when the amount of ink stored in the printing screen frame can not be too much or too little, otherwise lose ink from screen , block screen ,printed pattern uneven shades and other defects

Five, maintenance

1. Daily Maintenance

1) Please check and hear the machine weather is normally when you start the machine such as :the action is unusually,or has abnormalvoice, and or installation is not good that lead to impact the parts. If not any malfunction,please add lubricant to the machine.

2) Check the water separator oil mist, often discharge water, and add the proper lubricant.

3) check the consumable , such as squeegee, screen, ink, cleaning agents.

4) To clean the ink accumulated dirt surface of the machine and screen plate. at the end of the work day.

2, monthly maintenance

1) after one month for using the machine, joints should be checked for each activity, and add lubricant, lubricant solidification if the situation should be erased and washed with petrol and re-inject new lubricant.

2) Check the electrical or pneumatic parts of the machine is normal, if has problem,it should be replaced.

3, annual maintenance

1) After one year of operation the machine, the machine should be a comprehensive inspection, including all mechanical parts of the situation, with or without rust, wear or lubricant solidification, etc., if it should be addressed promptly.

2) Thoroughly clean the dirt inside the machine and electricity and dust.

3) Check all the air mouth and the cylinder, if damaged or expired, should be replaced.

4) Check all circuits, if damaged, should be replaced.