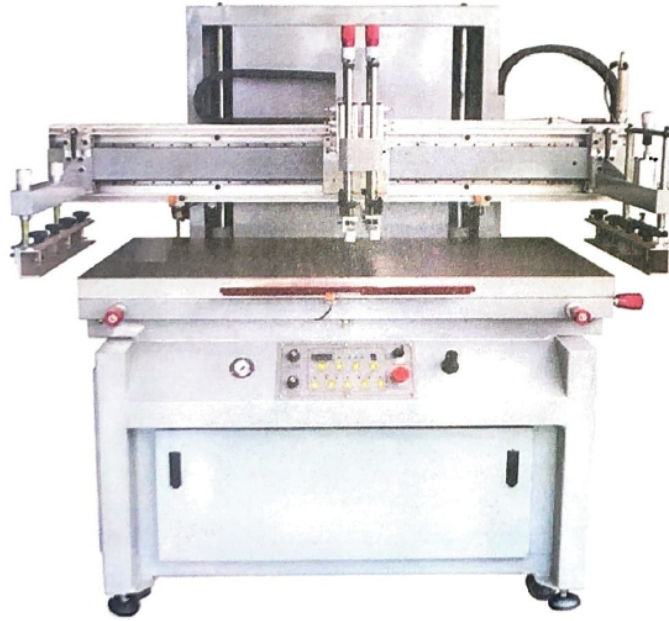


USER MANUAL



SEMI-AUTOMATIC SCREEN PRINTING MACHINE FLETBED SERIES

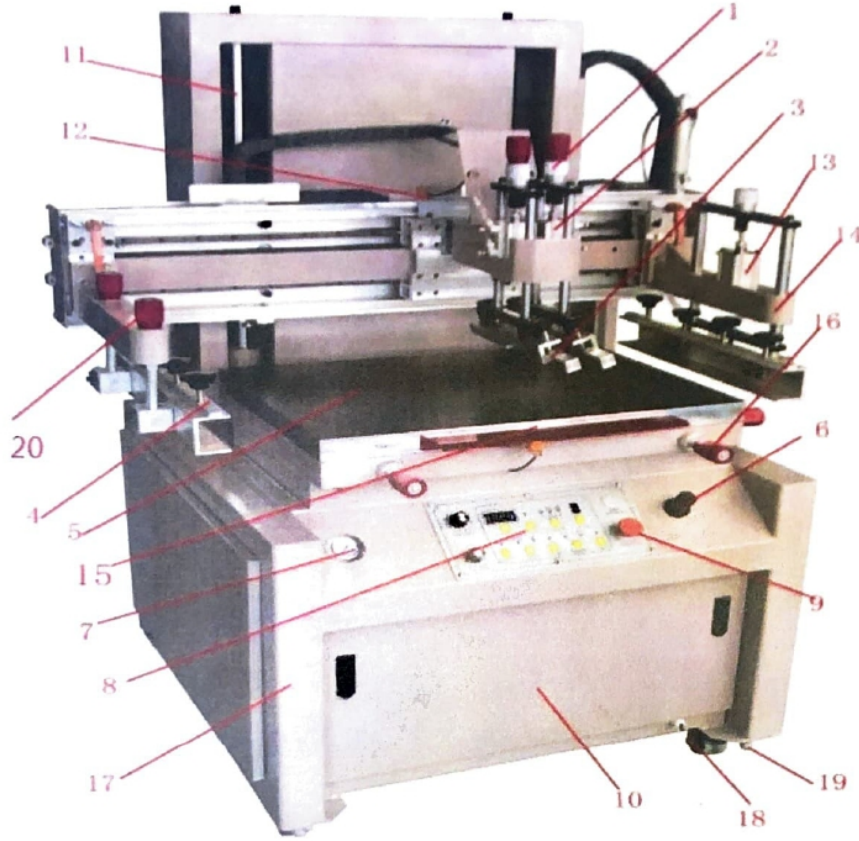
CONTENTS

1. Technical Parameters.....	3
2. Name Of Each Part	4
3. Installation	5
4. Operating Instructions	5
5. Screen Plate Installation.....	6
6. Knife Installation	7
7. Adjustment Of The Printing Stroke	8
8. Printing Fixed Position.....	8
9. Attention	8
10.Maintenance	8
11. Accessories	9

1. Technical Parameters

Model	HS-4060ST	HS-5080ST	HS-60100ST
Max. printing area	400x600(mm)	500x800(mm)	600x1000(mm)
Workable size	500x700(mm)	600x900(mm)	700x1100(mm)
Max. Screen frame size	600*1000(mm)	700*1200(mm)	900*1400(mm)
Max. Printing thickness	25(mm)	25(mm)	25(mm)
Power supply	2.1kW/(380V3PH)	2.3kW/(380V3PH)	2.8kW/(380V3PH)
Printing capacity	1200 PCS/hr	1000 PCS/hr	800 PCS/hr
Registration accuracy	± 0.1 mm		
Drive for up&down	Electric invert motor for		
Drive for left&right	Electric invert motor for printing head		
Air pressure	4-6 bar		
Main control	Micro-computer Control panel		
Unit dimensions	1230x950x1580mm	1400*950*1580mm	1660*1220*1630mm

2. Name of each part



Pic1. Machine Appearance

1	Squeegee adjusting stud	2	Lifting Cylinder
3	Ink covering Knife & squeegee	4	Clamp for screen frame
5	Printing Table	6	Working Air Pressure regulator
7	Air-pressure gauge	8	Control Panel
9	Emergency Stop Switch	10	Electronic control box
11	Upright Pillar	12	Motor for left& right movement
13	Cylinder for screen frame lifting	14	Arm for frame holder
15	Emergency shutdown switch	16	Micro-Adjust handle for Printing Table
18	Castor Wheel	19	Feet

3. Installation

3-1). Position

Place the unit on a firm, level surface ground, adjusting the four feet to ensure the wheels are away the ground, then still adjust the four feet to make sure the printing table is horizontal.

3-2). Air source connection

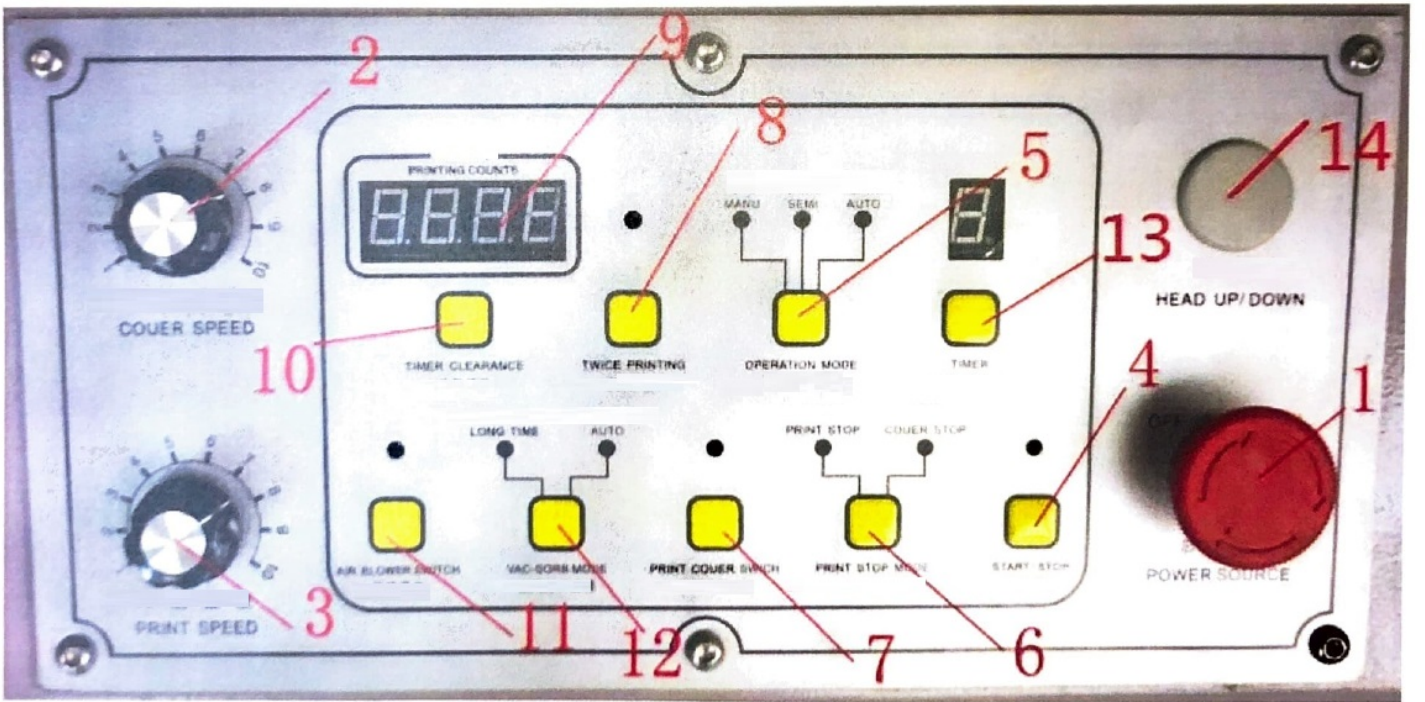
Use $\varnothing 8$ cm air tube connect the air compressor exit, another side connect the oil-water separator which is on the right side of machine, adjust the pressure lock to set the pressure at 6kgf/cm^2

3-3). Machine Installation

- ① The machine is using three-phase 380V.
- ② Foot switch connected to the mechanical the bottom right at the foot switch jack and nut.

4. Operating instructions

4.1 Control Panel



Pic2. Control Panel

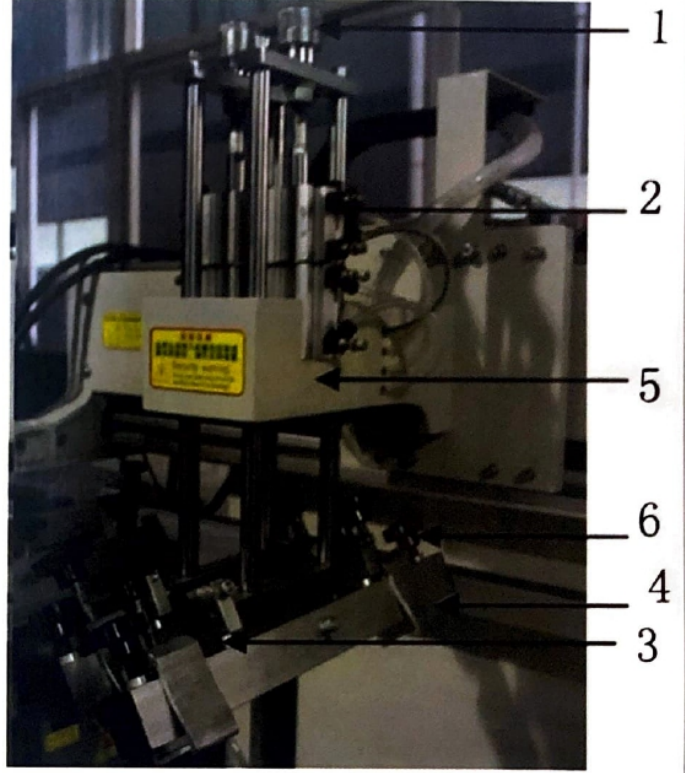
1	Power ON/OFF	Under emergency situations, press to shutdown the machine at once.
2	Couer Speed Knob	Adjust the speed of couer travelling speed from 1 to 10.
3	Print Speed Knob	Adjust the speed of printing travelling speed from 1 to 10.
4	Start/Stop Button	Press to start or stop printing process.
5	Operation Mode Button	Press to select a printing mode between Manual, Semi-auto, Auto.
6	Print Stop Mode Button	Printing Head stops at left or right after complete printing once.
7	Print & couer switch button	Switch Print ink knives up/down.
8	Twice printing button	The unit printing twice at each material.
9	Printing counts LED	Display the printing cumulative number.
10	Timer reset button	Reset the printing cumulative number.
11	Fan ON/OFF button	Press to start or stop Vacuum fan.
12	Vac-Sorb mode button	Select the vacuum table kit running mode for Continuous or Auto.
13	Timer setting button	Set a time for printing suspend time after printing once.
14	Head up/down	Press to operate the printing head up/down.

5. Screen Frame Installation

- 5-1). Press (1) Main Switch to turn on the power.
- 5-2). Press (14) to raise the printing head at upper position.
- 5-3). Put the screen frame into the Screen Holder.
- 5-4). Secure the fame on the correct position, then lock the clamp(4).

6. Knife Installation

- 1--- Pressure adjusting knob
- 2--- Air cylinder
- 3--- Squeegee angle adjusting Clamp
- 4--- Squeegee Clamp
- 5---Printing head
- 6---Balancing controller



Pic3. Printing Head

- 6-1) Knife install: Put the print Knife and cover knife on the holder, then locked it up by tighten (4).
- 6-2) Pressure adjusting knob(1): Use this knob to adjust the printing pressure of the knife.
- 6-3) Knife angle adjusting (3): To adjust this nut to make the knife at the correct angle which printing need.
- 6-4) Balancing controller(6): To adjust this knob to make sure that the knife and the printing table at the same level.

7. Adjustment of the printing stroke

- 7-1) The Printing Stroke is depend on your printing size(the printing size cannot big than the max printing size of the machine)
- 7-2) There are two electronic approach switch on the linear guide of the print head , you can move this 2 switch to make the stop of the left & right move of the print head.
- 7-3) Please make sure that the Print head cannot meet the Clamp for the frame.

8. Printing fixed position

- 8-1) Can use 3 points localization principle.
- 8-2) In order to make the Powerful vacuum inspiration, please use the Scotch tape to cover the air suction holes outside of the Printing area.

9. Attention

- 9-1) read this manual carefully before use
- 9-2) Notes when move this machine:

The weight of this machine is more than 300kg, so please use the Forklift truck

You can use the 4 Wheels to move the machine to the desired place, but please let the wheels away the ground after you finished.

10. Maintenance

■ Maintaining of this machine covered many aspects of management. Hereby we only point out the basic requirements that can keep the machine work normally, others requirements such as machine's interior and appearance, environment condition and sanitation of workplace, should be standardized by user's disciplines and guidance.

■ Either starting or operating the machine, you should check if there are any abnormal action or sounds. Please fix it immediately if there is, If it not caused by mechanical failures, or only caused by bad lubrication, you should check if need to apply lubrication to all movement parts.

Please clean the machine's appearance after complete work.

■ At the end of every month, should check all movement joint and check if need to add lubrication.

■ Normally, the machine should be thoroughly maintained every half year, Please handle it in time if there is any riot, abrasion, or lubrication concretion phenomenon.

■ After the machine used for one year, it should be checked completely, there, the mechanical part should be checked to see if there are any abrasion or lubrication concreting phenomenon. If there are, please handle it immediately. Meanwhile, please check all air tubes and switches and replace all damaged.

11. Accessories

No	Product	QTY	UNIT	
1	Tool Box	1	PCS	
2	Spanner	1	PCS	
3	Hexagon screw driver	1	PCS	
4	Cross-type of screw driver	1	PCS	
5	Word screwdriver	1	PCS	
6	Foot switch	1	PCS	
7	Printing squeegee	2	SET	
8	Ink-collecting squeegee	2	SET	
9	Manual	1	PCS	