

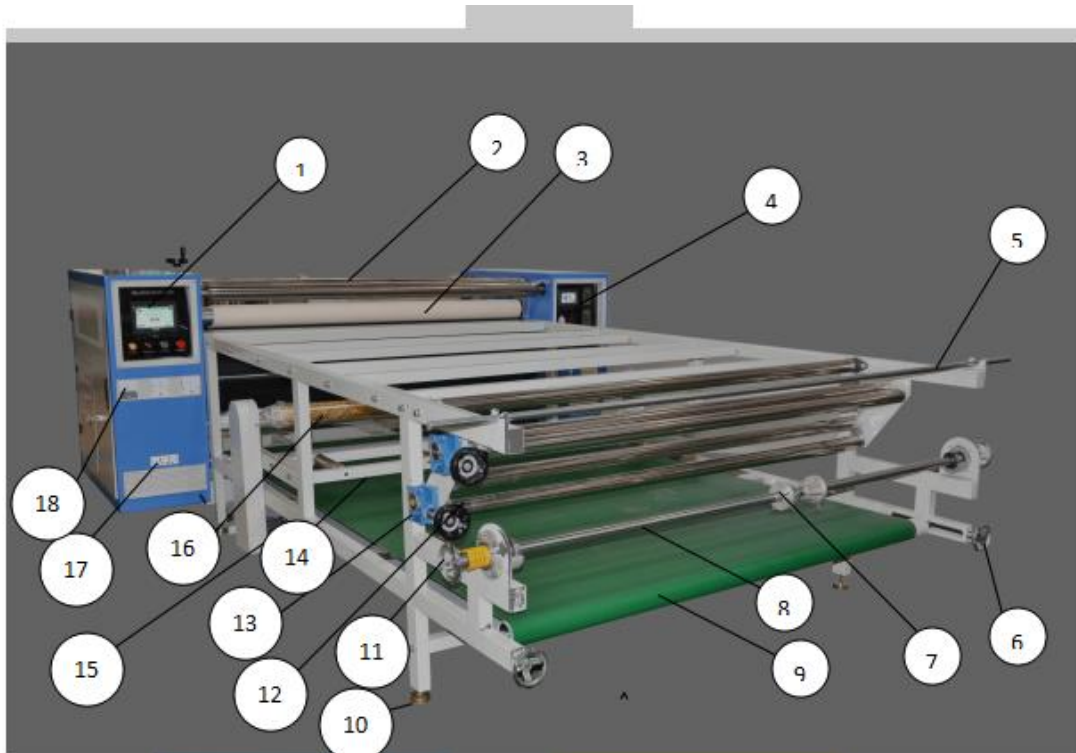
# **Roller Sublimation Machine Operating Manual**

PLC+Auto. Alignment blanket

## Catalogue

- A. Part overview No.1**
- B. Part overview No.2**
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- D. Electric wire power connecting instructions**
- E. PLC control panel with touch screen**
- F. Deviation alignment system control panel**
- G. Operation step**

## Part overview 1-1



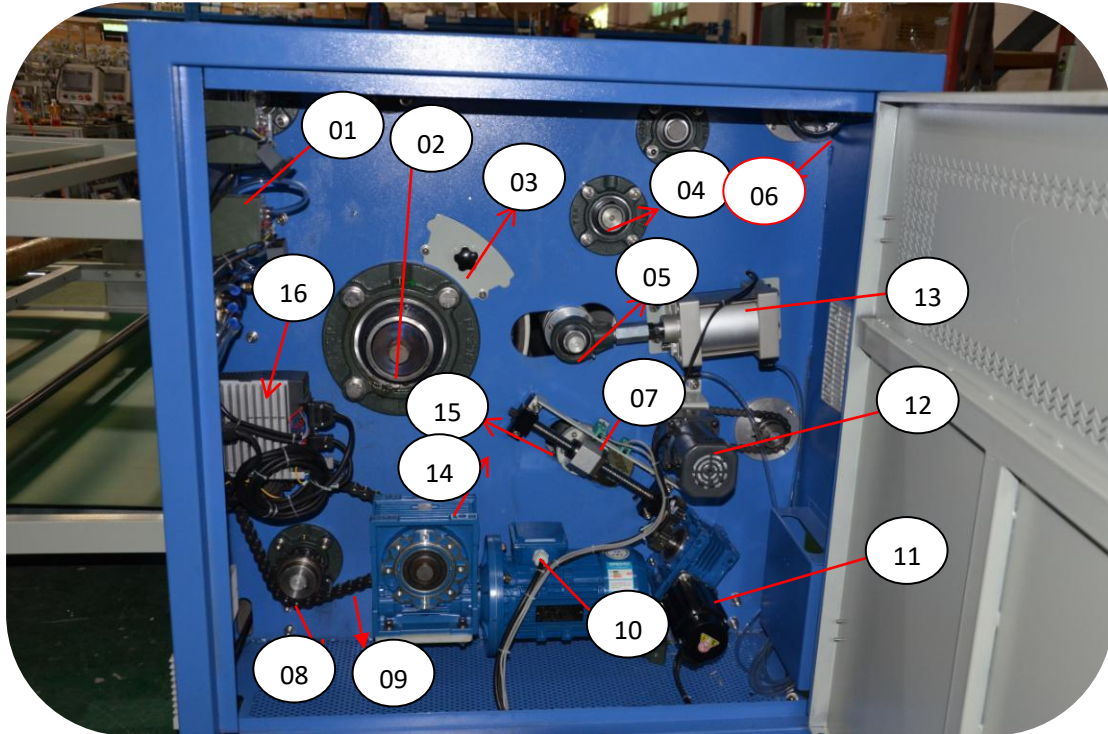
Item NO.	Part name
1	PLC control panel
2	tension rod
3	Blanket
4	Blanket alignment control panel
5	20# fabric unwind bar
6	Belt regulating hand-wheel
7	Taper sleeve
8	Transfer paper unwind bar
9	PVC belt
10	Fixable stand cup
11	Torsional adjustable hand-wheel
12	Adjustable hand-crank of tension rod
13	Tension turbine
14	Printed paper holder
15	Electric motor of transfer paper rewind
16	Air compressed shaft
17	AC220V
18	Ampere meter
19	

## A. Part overview 1-2



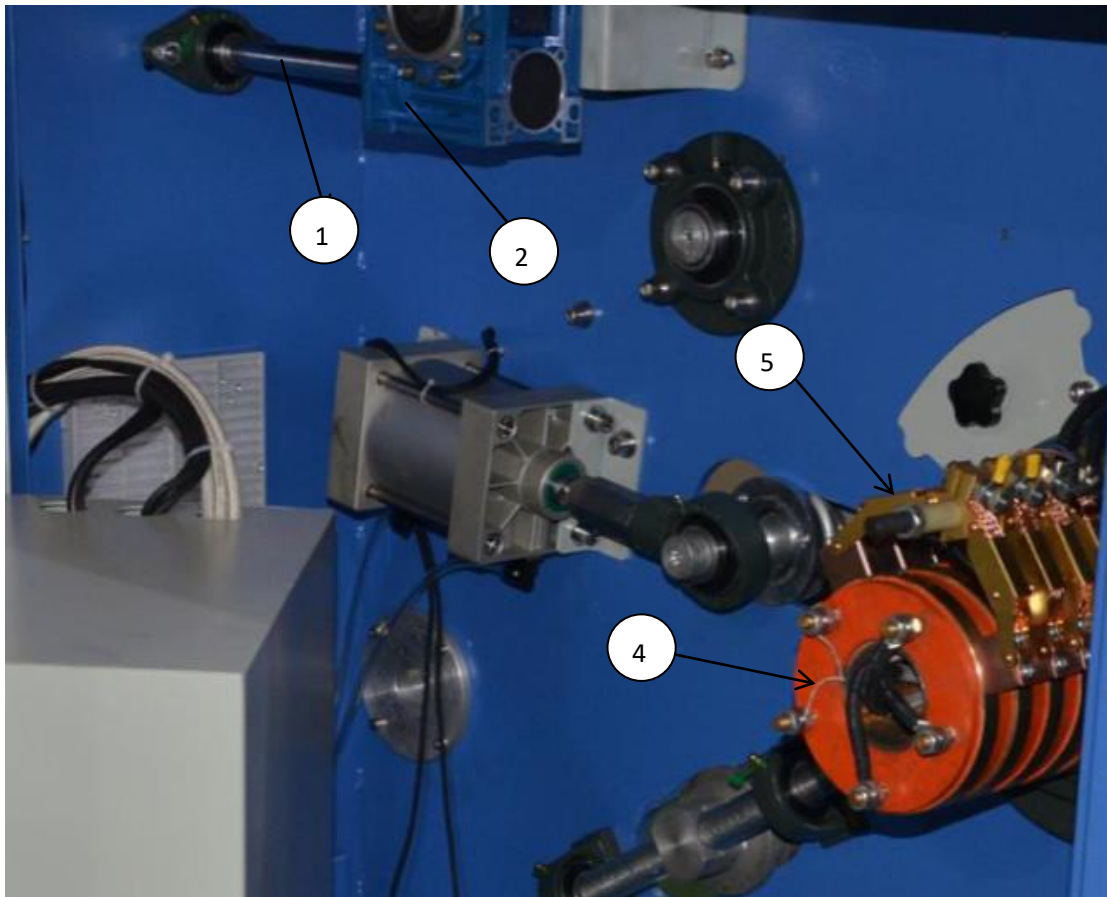
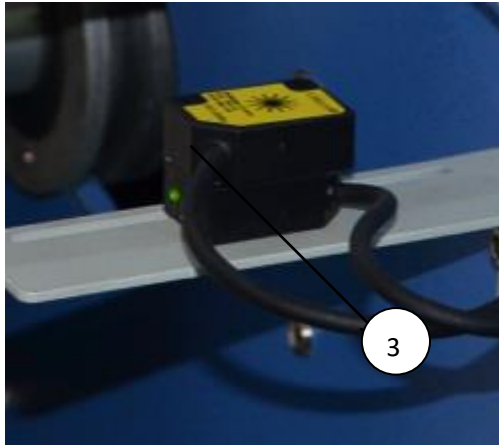
Item No.	Part name
1	Air shaft of lining paper
2	Condenser
3	Infrared light sensor
4	Lining paper unwind bar

## B. Part overview 2



Number	Part name
01	Torque governor
02	Oil filling hole
03	Heating roller inspection opening
04	Blanket cross shaft
05	Air pressure shaft
06	Torsional adjustable hand-wheel
07	Electric apparatus
08	Conveyor driver shaft
09	Driver chain
10	Main roller driver motor
11	Blanket deviation alignment serving motor
12	Lining paper rewind motor
13	Air cylinder
14	Driver reducer
15	Correcting screw rod
16	Serving driver

## C. Part overview 3



Number	Part name
1	Blanket handle adjust shaft
2	Blanket adjust reducer
3	Infrared light sensor
4	Integrate conducting rings
5	Carbon brush



## D. Electric wire power connecting instructions



### Electric wire connection:

1. Choose the related power cord according to the corresponding function
2. N is neutral wire line.  
ABC is fire wire.  
E is earth wire.

## E. PLC control panel with touch screen 1-1





## E. PLC control panel with touch screen 1-2



Number	Function and explain
1	Alarm, fault display
2	Speed regulator
3	Language switch
4	Positive and negative represents the addition and subtraction of the current temperature and the actual temperature, the maximum correction is between plus and minus 20
5	It can only be used when the current temperature is below 65 degrees and the delay shutdown is set to 0°C
6	Actual temperature
7	When the actual temperature exceeds the alarm setting temperature, the heating power is automatically cut off, and the information bar and buzzer have prompts.
8	Temp. pre-set of product needed
9	Transfer output counter
10	All power is automatically turned off at the set time(Red means power off, green means on)
11	Frequency converter(red means off, green means on)
12	Converter off
13	Heating off
14	Heating on (red means off, green means on)
15	Delay shut down, time pre-set
16	Delay off cancel( blue means off, green means on)
17	The rewinding motor switch can only be used after the frequency conversion is started (red means off, green means on)
18	Auto. Blanket corrector switch ( Abnormal situation happen will be show on main display)
19	Rotary speed per min.

## F. Deviation alignment system panel



Number	Function
1	Deviation correct system display,detail below next page
2	Pressure meter
3	Pressure regulating valve(Turn right to rise pressure,left to lower )
4	Pressure regulating manual valve
5	Rewinder speed regulating switch( rotary speed regulator)



## G. Operation step instruction

### ● Installment:

1. After receiving the transfer machine, check if the package is intact and undamaged
2. Confirm whether the physical object and the purchase style are the same.
3. Install the transfer machine in a safe, stable, dry and ventilated room, and ensure that there is enough space for movement.
4. Install the tempered glass on the transfer machine and the workbench in turn, and place the glass on the workbench, keeping the horizontal position. (The glass is purchased according to the length of the workbench, and tempered glass above 10MM is required)
5. Open the left rear cover and connect to the power supply.
6. Power supply connection (purchase the corresponding power cord according to the power of the equipment, 380V requires 3 phase 5 wires, 220V requires 3 wires N/L/E. Professional electrician operation is required)

### ● Sublimation/transfer process:

1. Confirm that there is no foreign matter on the surface of the transfer machine and the blanket, turn on the power, start the frequency conversion, heating switch, and heat to the temperature required for transfer (due to different materials and transfer paper characteristics, there is no uniform temperature and transfer speed).
2. Place the material in the corresponding position (see overview for details), adjust the transfer speed, winding speed, and pressure.

### ● Daily maintenance

1. Keep the machine body, table and sensor clean
2. All transmission bearings should be filled with liquid lubricating oil before starting up every day to increase the service life of transmission parts
3. All operators should be trained to obtain the qualifications before starting to operate.
4. If the equipment has not been used for a long time, please ask professionals to check all circuits and gas circuits before starting the machine to avoid serious personal injury.

### Warning:

1. The equipment must be connected to a reliable protective ground before use
2. Do not touch any rotating parts when the equipment is running
3. Do not touch any live parts when the equipment is energized
4. The above three points must be strictly observed. Violation may cause serious personal injury