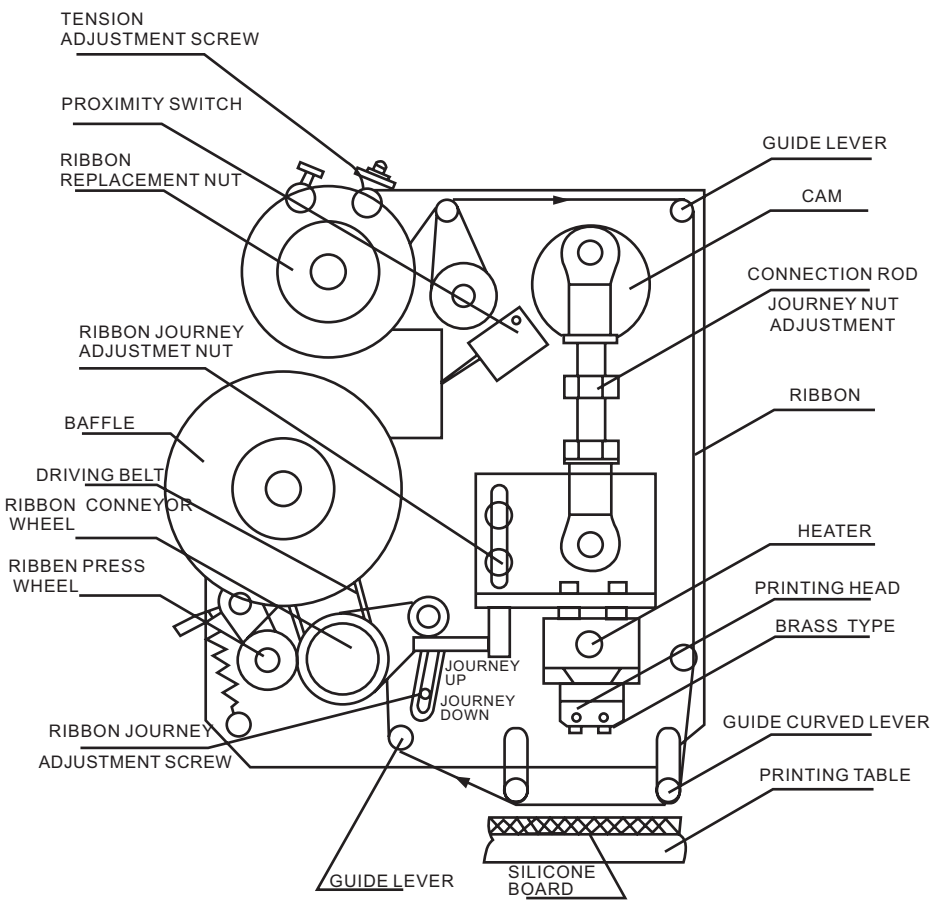
DK-700
Hot Stamp Coder

Manual

Contents



Description

DK-700 works with such vertical intermittent automatic filling and sealing machines as milk soft-pack packing machines, box packing machines to print production date, lot/ batch number and other related information. It is characterised with compact size, convenient installation, simple operation and easy maintenance.

Features

- Adopt hot stamp foil to print legible characters.
- Adopt the special type-replacement configuration to facilitate the installation of the types.
- Suitable for such materials as plastic, leather, paper and clothes.

Specifications

Printing Speed	Max 120times/ min
Printing Area	Single line Max. 4mm×35mm, about filling 15 characters; Two lines Max. 8mm×35mm, about filling 30 characters.
Hot Stamping Foil	Max. Width 35mm
Power	220V/ 200W
Weight	5kg

Installation

1 Installation of Hot Stamp Ribbon

a) Loosen the Clamp Nut on Ribbon Decoiler and take down Ribbon Baffle. Load ribbon coil onto Ribbon Decoiler shaft and then fix Ribbon Baffle, making sure both ends of ribbon coil abut against Ribbon Baffle.

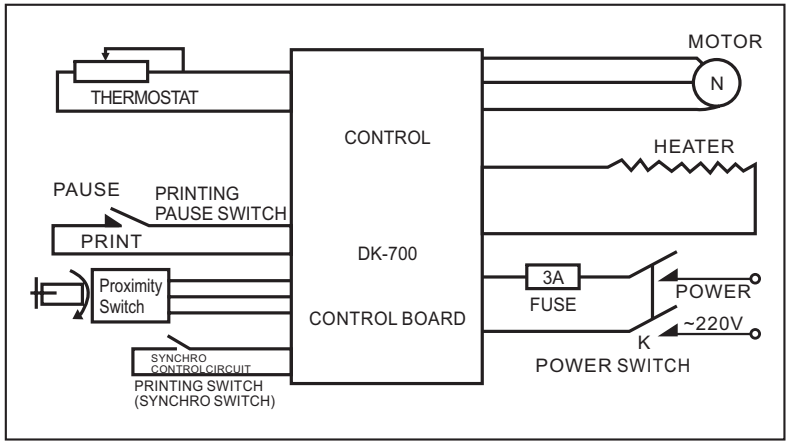
b) Loosen the Clamp Nut on Ribbon Recoiler and take down Ribbon Baffle. Load a hollow paper roller (leftover hollow Paper rollers of used ribbon coils may be reused) onto the Ribbon Recoiler shaft. Pull out start of ribbon coil and stick it to the hollow paper roller with glue. Pay attention to the winding direction of ribbon. At last fix the Ribbon Baffle on Ribbon Recoiler. The axial distances between the two Ribbon Baffles on Ribbon Decopiler/ Ribbon Recoiler to be 1mm more than the width of Ribbon coil.

2. Installation of Types

a) Push Type Replacement Handle by 1.5-2.0mm and turn it by 90-180° to unfasten the clasp. Take down Type Holder, unfasten the screws on it.

b) Put required types in the Type Holder. Make sure height of types is even, not tilted. Do not knock Types with metal bar in case of damaging Types.

c) Plug Type Holder into printing head and turn Type Replacement Handle to fasten Type Holder.



Troubleshooting to illegible print

Diagnosis	Solution
Heating temperature too low	Normal preheating time to be more than 15 min
	Carry out quick preheating
	Replace heating system when it is broken
Printing impress without color	Turn down printing temperature to optimum
Printing pressure too low	Fasten pressure preseting screw
	Adjust connection rob to descend types
Ribbon blocked	Loosen tension adjustment nut
Ribbon is damp or smeary	Replace it
Aging of silicone board	Replace it; turn it by 90° in the plane; or overturn it by 180°
Ribbon doesn't travel properly	Check single-way ribbon conveying parts
	Fasten ribbon press wheel
	Calibrate ribbon press wheel and ribbon conveyor wheel to make them parallel and match each other well
	Loosen tension adjustment nut
Types improperly fixed	Refit types; keep them at the same height, not tilted
Ribbon inversely installed	Reinstalled it correctly
Ribbon deviates from proper route	Replace tortuose guide rods
	Put baffles in place
	Calibrate ribbon press wheel and ribbon conveyor wheel to make them parallel and match each other well
Connection rod can not stop at vertex	Repalce broken proximity switch
	Repalce broken circuit board
	Replace broken emergency switch

Instruction

1 Steps of start

After Types and Ribbon installed, undermentioned steps shall be taken to start:

a) Turn on Power Switch.

b) Set temperature between 4 and 5 on the dial of Heat Controller. It will take 15 to 20 minutes to preheat, which depends on ambient temperature.

2 Attentions for printing

After adequate preheating printing is available. In the case of thin film printing, a pile of films(total thickness no more than 0.5mm) can be put into the printer, each piece of which can be taken out after printing one by one; in the case of thick item printing such as carton, single piece printing each time is proposed.

3 Maintenance

Periodically wash exteriors of Ribbon Conveyor Wheel, Ribbon Press Wheel and Ribbon Guide Rod with petroleum, aether or absolute alcohol to avoid adherence and slide resulting in illegible print. (wash frequency may be 3 days or one week once, which is determined by the pollution status of these parts.)

Adjustment

1 Adjustment of printing pressure

Printing pressure is one of the most important factors to realise clear and sharp print. It varies with materials

printed and shall be adjusted when Silicone Pad has been replaced.

2 Move of Silicone Pad

After used for a long time surface of Silicone Pad wil l be worn, which shall lead to bad print or ribbon damage. In this case, the position of Silicone Pad touching ribbon should be moved right or left.

3 Adjustment of resistance to ribbon conveying

Ribbon should be moderately tightened when print. The resistance to ribbon conveying should be reduced to the greatest extent and kept at a moderate level so that ribbon shall be moderately tightened after printing rather than adhering to printed items or deviating from proper route.

4 Adjustment of Connection Rod Journey and printing pressure

Connetion Rod and printing pressure preseting nut shall be adjusted to ensure the lowest position of Types is 1.5 to 2.5mm lower than the highest position of printed items and to realize legible print. Too high pressure will break off ribbon and damage printed item and lead to illegible print; while deficient pressure will lead to illegible print.

5 Adjustment of ribbon journey

Vertical position of ribbon journey adjustment screw shall be adjusted to adjust ribbon journey so as to adjust the space between adjacent lines(rows) on ribbon. 1mm space is proposed to save ribbon.

6 Adjustment of printing temperature

Optimum printing temperature varies with the material of printed items, which can be realized by adjusting heating temperature knob. Respective optimum printing temperature range of each kind of material as per the following table is for reference, which is affected by thickness, origin and quality of materials, ambient temperature, etc..

Optimum printing temperature (Position on heating temperature dial)	Material of printed item
Step 2- step 3	PE, PP, heat shrinkable lable
Step 3- step 4	OPP, PVC, paper, compound plastic bag

Step 3.5—step4 is adopted when the voltage is lower than200V, ambient temperature lower than 10℃ or quick heating is required.

Normal preheating lasts for 15 to 20 minutes. For quickpreheating, set heating temperature at the Max. and return to optimum printing temperature after actual printingtemperature reaches optimum printing Temperature.

7 Adjustment of printing speed

Switching between invariable speed printing and alterable speed printing is reachable with printing speed switch. Priting speed can be adjusted with printing speed adjustment knob. Printing pause can be realized with pause switch by hand or by foot.