We will provide you with the service to the best of my ability

USER MANUAL

Skill: How to make the pattern correct?

Put the drawings at exactly 12 o'clock with the mold stopper as a reference, and put the bottom cover at about 11 o'clock in mold R , make several comparison positions of finished products and make marks on the mold.

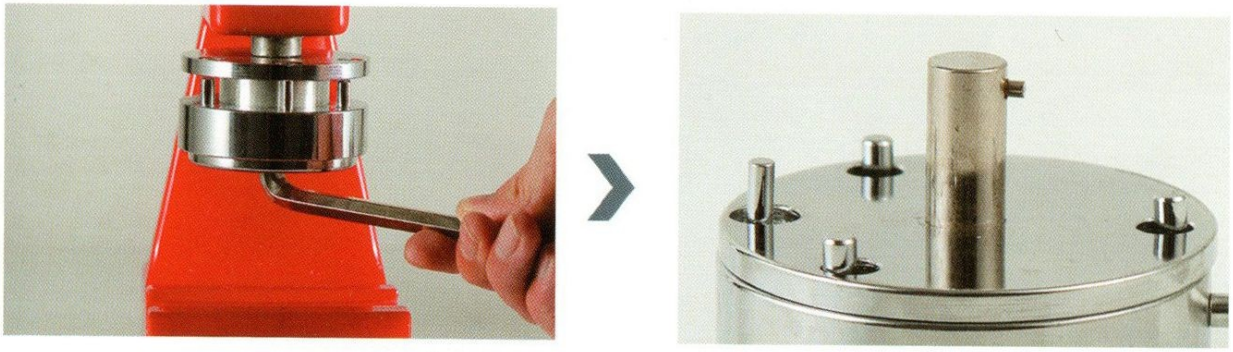


Figure 1: when the upper die is loose, the inner hexagon wrench can be used to tighten the mold. The standard is: 1.2.3 three points in a line

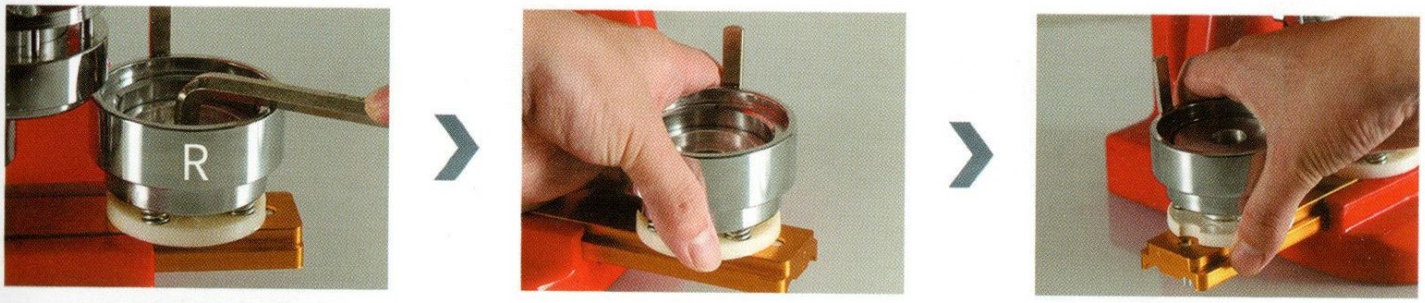
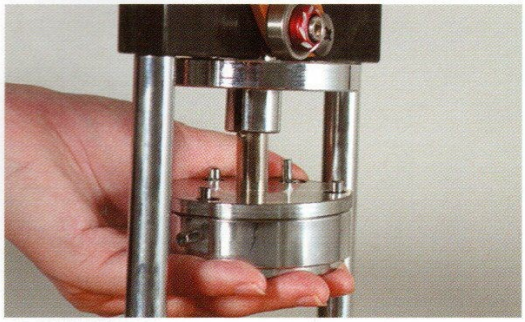
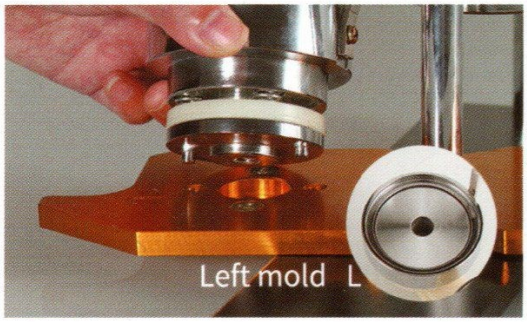


Figure 2: loosen the screw of the mould slightly with a hexagon wrench, rotate the whole die to an angle, and then conduct pressure test until the upper and lower dies are aligned, and then tighten the screws

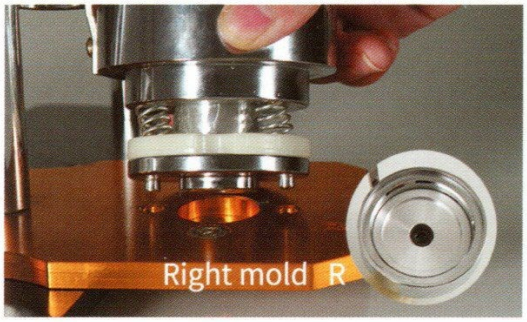
INSTALLATION PROCESS OF ROTATING BADGE MACHINE



1.Press the handle down, Align the bumps of the upper mold with the grooves, Push it up



2.the raised part of the left mold L with the Align mounting hole of the base, Put it in flat

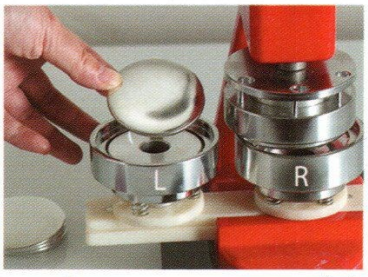


3.the convex part of the right mold R with the Align mounting hole of the base,Put it in flat

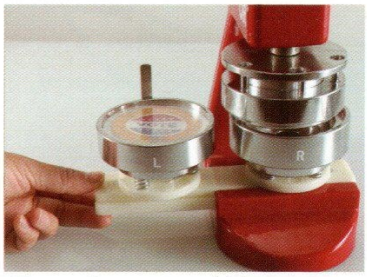
4.Put the pattern and badge material on the mold to start making

BADGE MAKING PROCESS

1.with a circle cutter Cut out the printed picture



2. Put the upper cover of the tinplate badge into the left mold



3.Drawings and Transparent protective film Put them on the tinplate in turn

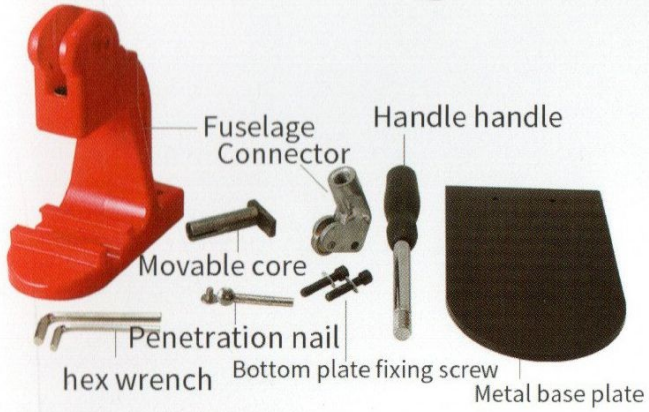
4.Push the slide mold to the right and align the upper and lower diess,Press the handle to push the mold to the bottom

5.Put the bottom cover into the mold on the right,Push the slide rail to the left until Align the upper and lower dies,Press down the handle Press the mold to the bottom

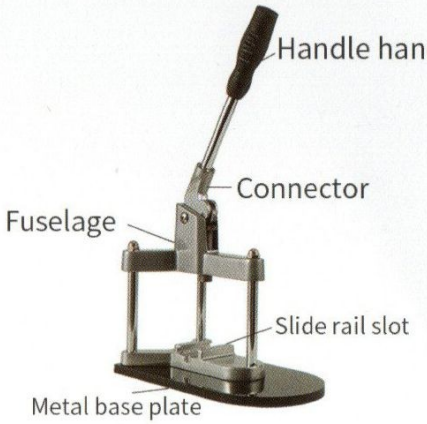
6.After pressing,Push the slide rail to the right, is complete

DISASSEMBLY DRAWING OF BADGE MOLD

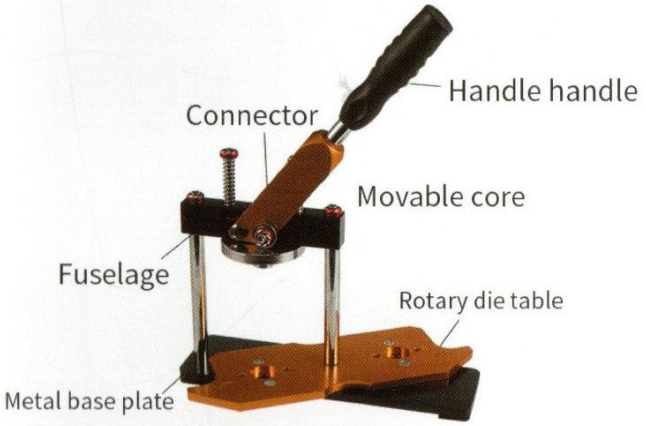
1.Red badge machine



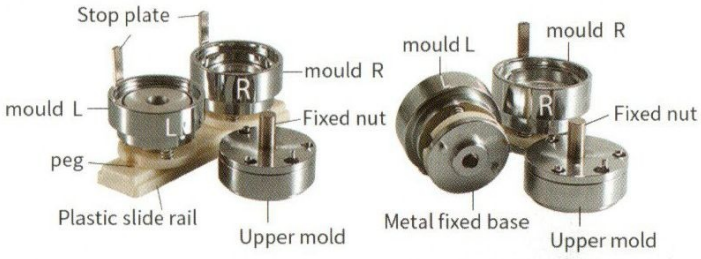
2.Tripod badge machine



3.Rotary badge machine



4.Slide rail mold · New mold

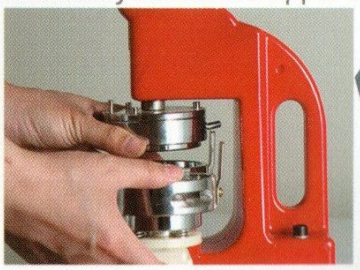


BADGE MACHINE INSTALLATION PROCESS

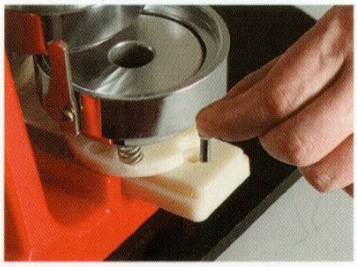
1. with a hexagonal wrench Fix the machine to the base

2.Install the handle on the machine

3.The convex points of the upper die are aligned with the grooves of the head and pushed up, and the head will automatically absorb the upper die



4.Align the slide rail mold with the groov and push it forward



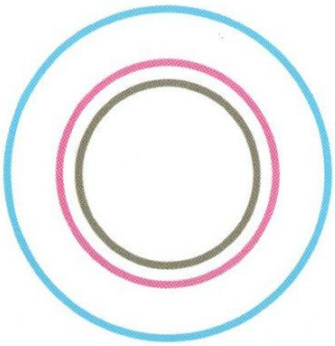
5.Effectively prevent the slide rail from falling off and the mold from being misaligned

6.Installation complete Place the pattern and badge on the mold to form the finished product

◆ DESIGN STANDARD OF BACKGROUND PAPER

finished product Size of	Image specifications	Cutting size
25mm	20mm	35mm
35mm	27mm	44mm
37mm	32mm	48.5mm
44mm	39mm	54mm
50mm	45mm	60.5mm
56mm	51mm	66mm
58mm	53mm	69.5mm
75mm	70mm	86mm
100mm	95mm	115mm
158mm	153mm	179mm

finished product Size of	Image specifications	Cutting size
25×18mm	20×13mm	35×28mm
39×31mm	34×26mm	49×42mm
47×32mm	42×27mm	57×42mm
57×45mm	52×42mm	67×55mm
69×45mm	64×40mm	80×57mm
32×32mm	27×27mm	42×42mm
50×50mm	45×45mm	61×61mm
68×24mm	63×19mm	79×34mm



- finished product Size of
- Image specifications
- Cutting size

Batch printing:

157g coated paper,
Double-sided coated with oily light film;

Home printing:

115-135g photo paper,
Membranes matched with consumables

Digital developing photo paper:

The thickness is less than 0.2mm
All kinds of brand photo paper

Use paper requirements

Tinplate Upper cover

Plastic base

Transparent protective film

◆ SOLUTIONS TO COMMON PROBLEMS

Fault phenomenon	Possible reasons	Exclusion method
The iron cover won't suck up	1. Improper operation method 2. the upper mold There is too much lubricating oil on	1.When pressing the first step, The upper mold must be separated 2.lubricating oil on the upper mold, There is too much Dry with a towel or paper 3.When the upper mold and the lower mold are closed, Must be on the same vertical line
Part of the membrane is not covered	1. Improper operation method 2.The friction of mold is large 3.Paper thickness is not suitable 4.Loose upper mold	1.When the upper mold and the lower mold are closed, Must be on the same vertical line 2.Apply lubricating oil to upper and lower die the inner circle of the 3.Use paper of a specified 4.Put the mold on the machine body and tighten the loose screws of the upper mold (As shown in figure 1)
Compaction is not tight	1.Not pressed to the end 2.Paper is thin 3.No gasket is placed 4.Loose upper mold	1.Need to press in place 2.Use thicker paper instead 3.Refrigerator magnet, Iron bottom badge,When making, put 2mm thick gasket in the right mold core 4.Tighten the loose screws of the upper mold
There is noise when pressing	The friction between dies is large	Apply lubricating oil to upper mold and the lower mold the inner circles of the
It is necessary to manually adjust of the upper and lower dies the separation and closing 2.The upper mold can rotate 360 degrees	Loose upper mold	1.The convex point of the die head is broken and can be replaced 2.Tighten the upper die screws
The upper mold is stuck together	1. Deviation of upper and lower dies 2.Foreign matter such as paper is stuck in the mold	With sharp objects, such as screwdrivers, Align the gap between the upper and lower dies Knock on objects with the help of hammer, etc. Make it drill open
The upper mold and the lower mold are not in the same vertical line	1.Wrong mold position 2.Reverse installation of mold slide rail	1.The pushed die position has passed or is not in place 2.The slide rail of the mold is reversely loaded into the machine Change the position of L and R dies 3. with a hexagonal wrench Loosen the die screws turn the die at an angle as a whole, and conduct pressure test until the upper and lower dies are aligned, and then tighten the screws