



JR1241 FLEXOGRAPHIC LABEL PRINTING MACHINE

Operation Manual

(Welcome to purchase Jingda Printing Machine)

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Flexographic Label Printing Machine

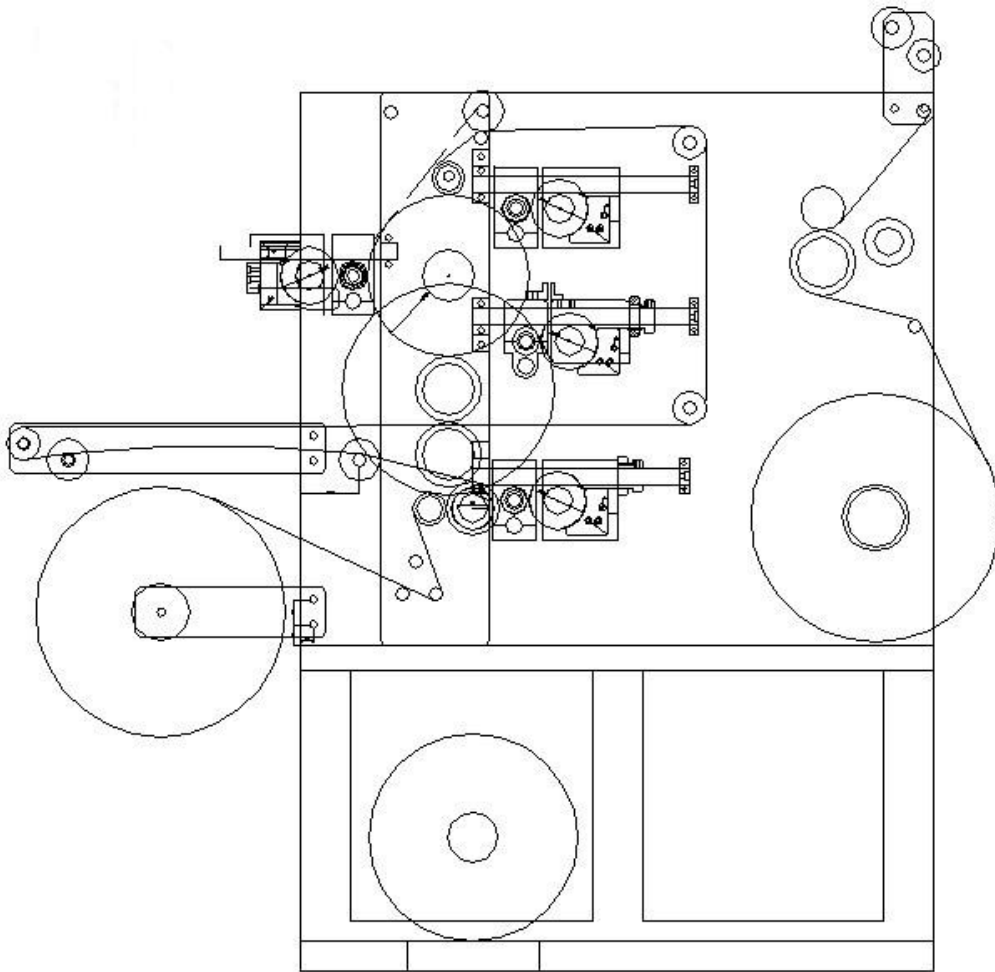
Basic parameters

Color stations:	4color + 1 color of back printing
Max. printing width	120 mm
Max. printing length or range	254 mm 127mm-254mm
Anilox roller	200 lines/in
Length counter	(pre-set), refer to Reference Table 2-1
Max. speed	60 meters/min
voltage	220V/50Hz

Optional accessories	Basic accessories
Ceramic anilox roller	200 line/in anilox roller
Gears	1 set of printing roller
Double rolling device	1 set of gears
Double unrolling device	Electric heated board dryer
Printing cylinder and gears	

1. Please read the “User’s Manual” carefully and get a complete understanding of its content before transporting, installing, adjusting, operating and maintaining the JR flexographic plate series of trademark printers.
2. In transporting, installing, and operating of the machine as well as electricity and high temperature, the user should not only observe the safety specification and meet the requirement of the “User’s Manual”, but also the related national rules and regulations in the fields of machinery and electricity.
3. The “User’s Manual” and the intellectual property right of the flexographic plate printer series belong to Rui’an Jingda Printing Machinery Company, Ltd., which should not be disclosed to the third party. Should there be any violation of the right; the company is entitled to take a legal action.

Feeding chart



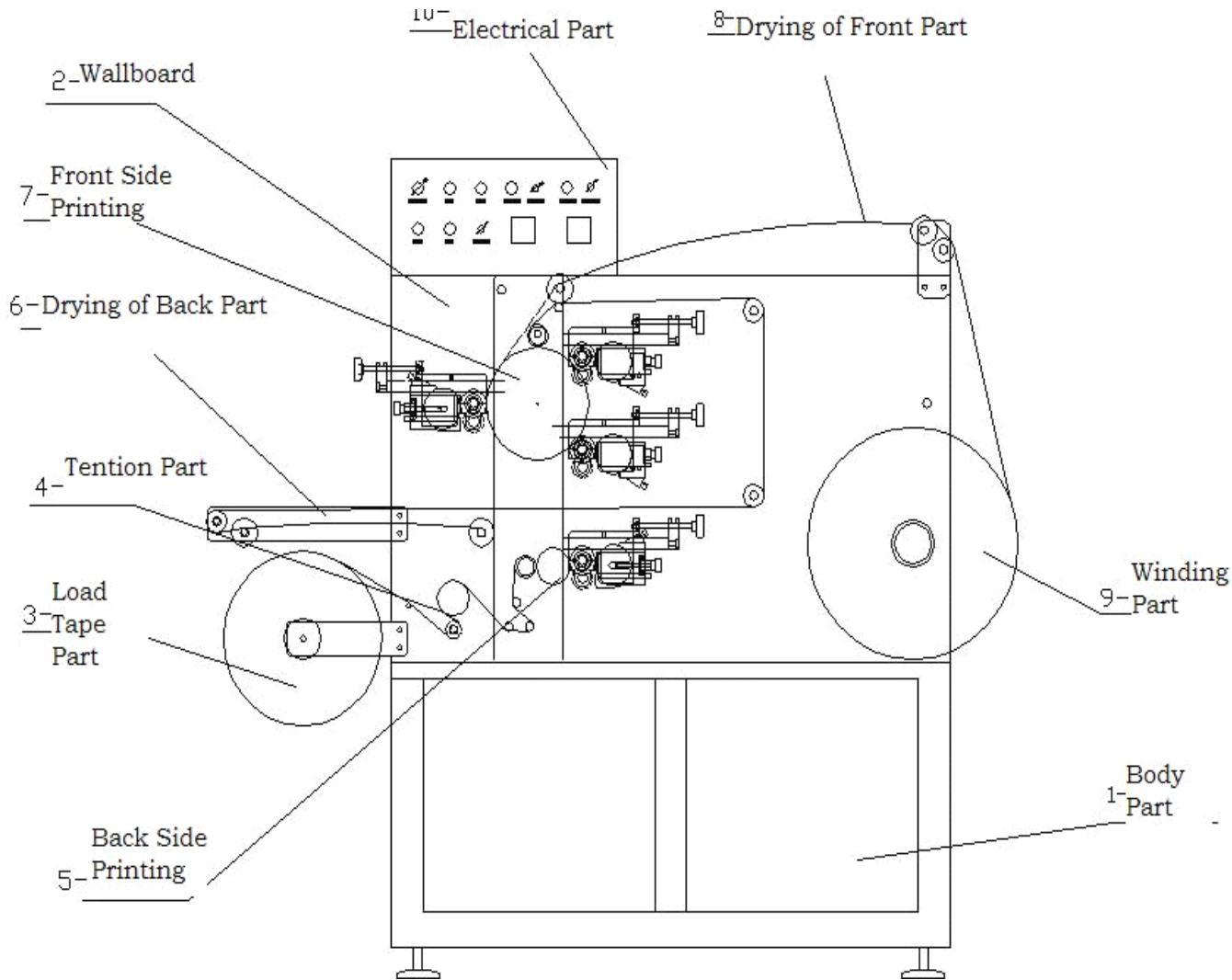
Note: the Line in the chart stands for the route of double printing

Since 2000 JINGDA Company has become a professional enterprise specializing in the design, development and manufacture of the printing machines. We have put into the national and international markets all kinds of printers and thus won the trust of users both at home and abroad. At the same time to improve quality and increase variety, we have also standardized and serialized our products.

The JR flexographic series of trademark printers are of high quality and variety. They have multiple functions and simple operation as well as reliable after sale services. They are the ideal choice for flexographic plate printer users. Since their introduction to the markets in Europe, America, Southeast Asia, the Middle East and South Africa in 2002,

they have been highly evaluated and liked by the commercial agents and users in various countries and regions.

To correctly use the flexographic plate series of trademark printers, please read the “User’s Manual” carefully and get a complete understanding of its content before transporting, hoisting, installing, adjusting, and operating the machine.



I. Operating principle

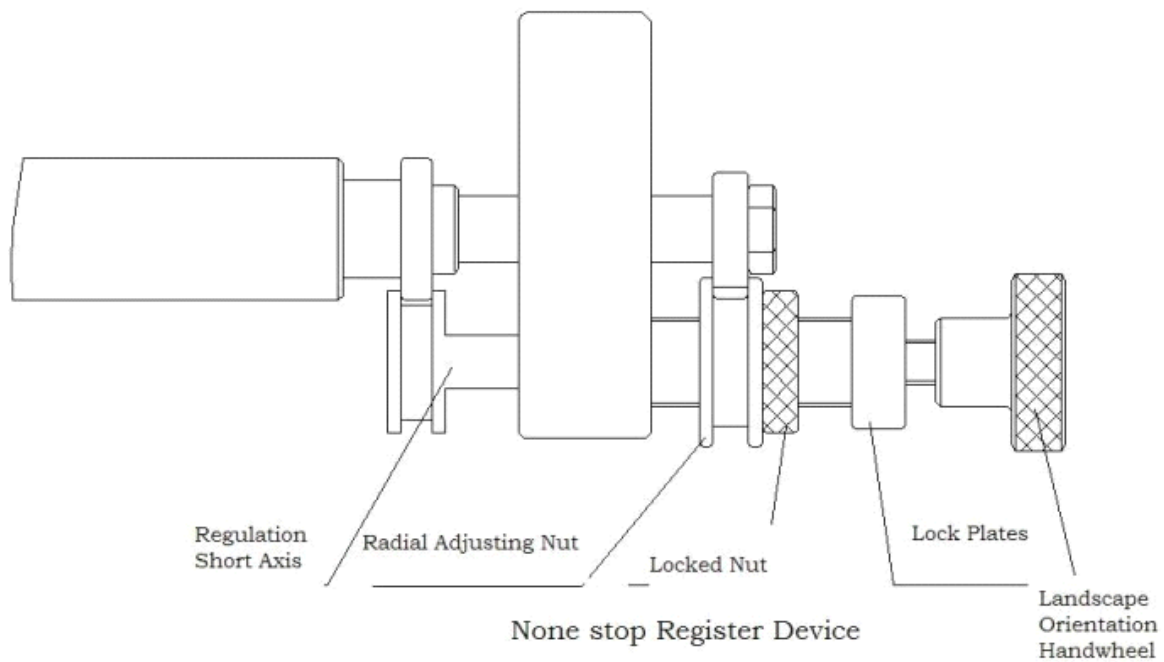
When the machine is switched on, the anilox roller will rotate in the ink duct. By controlling the clearance between the ink scraper and the anilox roller, you can deliver a proper amount of ink evenly to the flexographic plate of the circumferential surface of the printing plate wheel. The flexographic plate roller carries the ink to the surface of the material to be printed, which is dried and rolled by the electrically heated drying board to finish the process. The printed material is then put into the electric thermostat ventilating and drying cabinet for about 5 and 6 hours, with the effect of fast color and tolerant laundry. Environment friendly, the machine is characterized by its speed and efficiency.

Structure

i. Operating principle of photoelectric controlled band-feeder

There are two modes in the setting: ON and OFF. When the machine is in the ON mode, the photoelectric switch must be screened by the material for the machine to start up. When the material has been printed, the machine stops working.

ii None Stop Register



First make rough positioning. Press in the printing cylinder. When the error of the printing trace is around 3.5mm, accurate positioning can be made. However, when the error is greater than 3.5mm, the gear must be withdrawn and turned to the necessary position. Press in the printing cylinder again to make the error around 3.5mm. Switch on

the machine to make fine adjustment as shown above picture (None stop register device)

To save material, the plate cylinder for each color should be installed on approximately the same position of the corresponding group. If this is done correctly, the position of the picture to be printed for each color will be very near the register position, which can minimize the times of register adjustment necessary for the setting and reduce the waste of the material to be printed. It is recommended that marks be made on the same position of each plate cylinder or gear, so that the picture on the printing plate adjusted according to the marks will be very near to the register. When each cylinder is installed on to the printer, the marks can be used for accurate installation (the accuracy is within a gear). The mark on the paper belt should be calibrated with the mark on the cylinder and gear of the first group, and then inch start to move the paper belt to the next color and calibrate with the mark on the next cylinder. This method can be used for rough peripheral calibration so as to reduce the waste of trademark belt and the time for setting.

Aluminum plate wheel, accessory gears and comparison table of film length

Aluminum plate wheel printing circle spec (printing length)	Gear teeth number	Film length mm (plate thickness 1.7mm. silicone thickness 0.38mm)
5inch=127mm	40z	117.1
5.125 inch=130.175mm	41z	120.275
5.25 inch=133.25mm	42z	123.35
5.375 inch=136.5mm	43z	126.6
5.5 inch=139.7mm	44z	129.8
5.625 inch=142.875mm	45z	132.975
5.75 inch=146mm	46z	136.1
5.875 inch=149.225mm	47z	139.325
6 inch=152.4mm	48z	142.5
6.125 inch=155.575mm	49z	145.675
6.25 inch=158.75mm	50z	148.85
6.375 inch=161.92mm	51z	152.02
6.5 inch=165.1mm	52z	155.2
6.625 inch=168.27mm	53z	158.37
6.75 inch=171.451mm	54z	161.155
6.875 inch=174.6mm	55z	164.7
7 inch=177.8mm	56z	167.9
7.125 inch=180.97mm	57z	171.07
7.25 inch=184mm	58z	174.1
7.375 inch=187.3mm	59z	177.4
7.5 inch=190.5mm	60z	180.6
7.625 inch=193.675mm	61z	183.775

7.75 inch=196.85mm	62z	186.95
7.875 inch=200mm	63z	190.1
8 inch=203mm	64z	193.1
8.125 inch=206mm	65z	196.1
8.25 inch=209.5mm	66z	199.6
8.375 inch=212.7mm	67z	202.8
8.5 inch=215.9mm	68z	206
8.625 inch=219mm	69z	209.1
8.75 inch=222.2mm	70z	212.3
8.875 inch=225.4mm	71z	215.5
9 inch=228.6mm	72z	218.7
9.125 inch=231.77mm	73z	221.87
9.25 inch=234.95mm	74z	225.05
9.375 inch=238mm	75z	228.1
9.5 inch=241.3mm	76z	231.4
9.625 inch=244.47mm	77z	234.57
9.75 inch=247.65mm	78z	237.75
9.875 inch=250.8mm	79z	240.9
10 inch=254mm	80z	244.1

iii. Correct use and maintenance of anilox roller

a. Rules for selecting anilox roller

The line selection of the anilox roller is determined by the originals duplicated on the printer. When the printing plate is designed, the line of the anilox roller is generally between 85 and 200. When words or lines are to be printed, it is usually between 180 and 400. To print dense line area, the minimum ratio is 4 to 1 in selecting anilox roller, i.e., to print 100-line color picture, the minimum line of the anilox roller is 400.

The company standard for the user is 200 lines per inch.

b. Ceramic anilox roller

Each time when the ceramic anilox roller is cleaned, it must be cleaned thoroughly and checked with a high-powered amplifier. The cleaning is better to be done when the ink on the anilox roller is wet. This way, the ink can be effectively stopped from drying in the roller holes. In general, a special chemical detergent is used to soften and dissolve the ink in the roller hole. Method: Place the anilox roller in the detergent for a while and then brush the surface of the roller spirally with a special brush. This is especially effective for the severely blocked anilox roller with dried ink in the roller holes. After cleaning, pure alcohol must be used to treat the surface of the roller, including gears and axle. When the moisture is evaporated, cover the anilox roller with clean paper to prevent dust.

NB. If there is grease on the surface of the roller, clear it away with alcohol immediately.

iv Ink duct structure and its adjustment

JR series the ink duct contain up doctor blade scraper and down doctor blade scraper, the installation of two kinds of duct ink is the same way, first loosen all of the adjustable ink screws, and then encase into anilox roller seat, pressed screw and use hand to rotating anilox roller and carefully observe both sides of the copper for ink duct and anilox roller meeting circles, if not, adjust positioning screws on both sides of copper and let it meeting better with the anilox roller which is a key factor to ensuring without leak ink. Please let the masters familiar with this series machine. And then pressed into the gear and rotating anilox roller, put oil into side hole of copper, and then add ink to regulate the amount of ink. Ink duct has been mark color group, please installed it with correct mark ink duct.

v. Eccentric labeling roller and central impress roller

Through the rotation of its handle, the eccentric labeling roller makes the left and the right eccentric covers to rotate synchronously, which uses the eccentric distance to press the material to be printed onto the circumferential surface of the central impress roller. When this is done, the locking handle of the roller should be tightened clockwise to ensure that the material to be printed to rotate synchronously at a certain tension with the central impress roller without slipping or deviating. Thus, the color registering is accurate and the printing quality is guaranteed.

The central impress roller is the central element of the machine, the material, processing, and static balance testing of which are very strict. The accuracy of coaxiality of the outer circumferential surface relative to the bearing position at both ends of the main axle and the vibrating error of the outer circle relative to the rotating center are strictly kept within the permissible scope of designing and printing. It has also had enough accuracy reservation to ensure the performance, life and reliability of the whole machine. Besides, an anti-slippery film is added to the circumferential surface of the central impress roller to increase the friction factor with the material to be printed during printing process.

vi. Name and function of operating panel control, display and knobs

1. Power.

2. Speed display: The digit number shows the printing speed. And the number 10 means 16m.

3. Counter: To preset the quantity of the material to be printed. When the actual

quantity of the printed material has reached the preset number or the multiplication of the preset number, the machine will stop automatically. At this time when the machine needs to be restarted, just press the “clear” key on the counter to make the number accumulated on the counter reset to zero.

4. Stop button: The knob is marked red. When this knob is pressed, the printing motor will stop.

5. Inching button: The knob is marked yellow. When this knob is pressed, the printing motor will rotate slowly; when this knob is released, the printing motor will stop rotating. This function is used for page correction or testing the stepping of the machine. When the machine is in operation, press this knob and the printing motor will stop immediately.

6. Operation button: This knob is marked green. When this knob is pressed, and the machine will begin to operate

7. Speed button: By turning this knob, stepped speed regulation of the printing motor can be realized. When it is turned clockwise, the printing speed will increase; when it is turned counterclockwise, the printing speed will be decrease.

8. Broken-band protection switch: when the material to be printed is used up, the machine will stop automatically. This is done through a probe. When there is material to block the probe, the machine will operate; when there is no material to block the probe, the machine will stop.

9. Counter switch: When there is need to count the printed material, just press this knob to “ON” position; when there is no need, press this knob to “OFF” position. And how to counter printing label amount, means counter display figure multiply by fixed 609.6mm for JR1231 4color, multiply by fixed 1219.2mm for JR1262 8colors.

10. Temperature control and display of the upper drying board: Temperature control I is used for the temperature control of six-color group arranged in satellite form, and the 3 positive 1 negative types is used for the temperature control of 3 positive printing.

11. Electric switch of the upper drying board: When the 6 positive 2 negative type is used only for the drying of two-color group, or the 3 positive 1 negative type is used only for the drying of single-color group, the upper drying board can be switched off.

12. Temperature control and display of the lower drying board: The 6 positive 2 negative types is used for the temperature control of two-color group, and the 3 positive 1 negative type is used for the temperature control of single-color group.

13. Electric switch of the lower drying board: When the 6 positive 2 negative type is used only for the temperature control of six-color group arranged in satellite form, or the 3 positive 1 negative type is used for the temperature control of two-color group, the lower drying board can be switched off.

Make sure that the machine is in OFF position. Thread the material to be printed along the threading line according to the sketch diagram of the purchased type of the machine.

Loosen screw, take out screw cover, and place the roller wheel threaded with the flexographic plate and the accessory gear with the confirmed correct number of gears into the bearing holes at both ends of the corresponding printing color position.

Mesh the accessory gear of the plate roller wheel with the central impression roller gear, and then lock tightly the locknut.

Run the machine slowly and adjust every adjustable handles of the adjustable plate assembly. Adjust the ink between the printing plate wheel and the anilox roller and the contact pressure and accuracy on the impression roller till satisfactory. In printing practice, the contact pressure between the plate roller and the material to be printed is generally very small, sometimes approaching “zero”, i.e., the “zero pressure” contact in flexographic plate printing terms. In short, adjust the machine till the printed pictures, words and lines are clear and satisfactory. Needless to say, practice makes perfect. Everyone can learn and improve his skills with time going by.

In normal printing, adjust the speed knob until the rotation or the ink amount corresponds with the electric drying speed of the machine.

The maximum printing speed can reach 60 meters per minute.

14. The switch-off procedure is as follows: Turn off all the electric drying knobs → turn off the stop knob → switch off the power switch of the main control box → switch off the external power source.

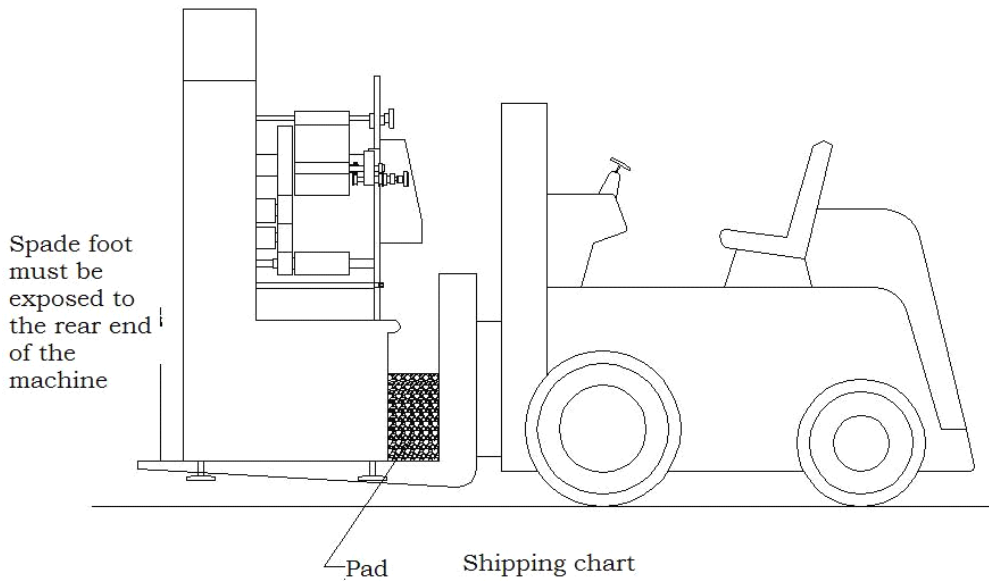
And then clean the anilox roller, the ink duct, the plate wheel and finally the whole machine.

III. Trial running and switch on and off machine

Switch on the power source.

1. When there is no material to block the photoelectric probe, use material to block the photoelectric switch; otherwise, the machine is unable to start.
2. Check the counter to see if it is in the position of “zero”. When the number reaches the preset number and the “zero” is not pressed, the machine will stop automatically.
3. When the machine is trial running without load, all the inkless ducts should be taken down and put aside. Check every part and see if they are running normally, especially the rotating direction of the anilox roller. Whatever types of the machine, the correct rotating direction of the anilox roller should rotate towards its matched ink duct. If the rotating direction is not correct, ask the electrician to change the rotating direction of the motor. When everything is confirmed normal, enter the next step.
4. Press the yellow “spot move” knob on the main control box, and the machine will be in the position of spot movement.
5. Press the green “operation” knob on the main control box and adjust the “printing speed” knob to let the machine run at low speed. If everything is normal, continue the following adjustment.
6. Press the red “OFF” knob on the main control box, and the machine stops running. When the machine is in operation, press the yellow “spot move” knob or the yellow “spot move” knob on the main wall board of the 6/2 type and the 3/1 type, the machine can also stop running.
7. put on the ink ducts (according to the actual use, if there is an empty color position or positions, there is no need to put on the ink ducts), drop a moderate amount of lubricating oil into the anti-overflow hole in the combination of the ear plate of the ink duct and the anilox roller. Add a proper amount of ink in the ink duct; adjust evenly the adjusting bolt of ink until the amount of ink on the anilox roller meets the requirement.
(slow speed while adjusting)

IV. Attention, transportation and hoisting



- i. Before switching on the machine, the machine must have a good ground connection lest there should be damage to humans or the frequency converter of the machine. In maintenance, first switch off the power supply until all the displays disappear and the high-voltage indicator inside the frequency converter dies off before doing maintenance and check.
- ii. The machine will stop in the following 4 cases:
 - ① When there is no material to be printed to block the photoelectric probe. Block the photoelectric probe is OK.
 - ② When the printing speed adjusting (potentiometer) knob is at the lowest speed. Turn this knob clockwise is OK.
 - ③ When the counter has reached the preset number. Reset the counter to “zero” is OK.
 - ④ When the power voltage is greater than 250 V or lower than 190 V. It is necessary to use a stable power source, the power of which should be greater than the overall power indicated on the machine.
- iii. For other specifications concerning machine operation and electricity safety not listed in this “User’s Manual”, the user should strictly observe the rules and regulations formulated by the state and the departments concerned.
- iv. The wall board and other components are precision elements, therefore, in

hoisting the steel cable should not be tied at the position other than the hoisting rings. The user will be responsible for the damage caused by violation.

- v. It is recommended to use a forklift truck to carry the machine. When the wooden packaging box is removed, the forklift truck will shovel the machine from the front (see the sketch diagram). Pay attention to the center of gravity when the machine is lifted 50-100 mm from the ground. Only when it is adjusted in balance, can the machine be carried to the place for installation, which should be a solid and even floor (The machine is permitted to be placed on the wooden base of the packaging box). Adjust the anchor bolts, and make the surface of the wall board vertical or 0.5 degrees tilted backward to the ground level.

V. Table of accompanying accessories

Name	Quantity	Remarks
User's Manual	1	Compiled by the company
Screw spanner for dismantling bearing cover	1	Special tools made by the company
Wedge for reel core	2	
Labeling plate seat	1 (assembly)	
Additional plate wheels and their matched gears of other specifications	Packaged according to contract	Manufactured according to requirement
Socket head cap spanner	1 set	Purchased
screwdriver	1	Purchased
Speed adjusting potentiometer	1	Purchased
Doctor Blade	1	
Surgical Blades	1	
Surgical Knife Handle	1	

JR1241 柔版印带机

使用说明书

(欢迎使用“景大”牌印机)



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合格证明书

JR1241 柔版印带机

机器精度检验前，首先调整好安装水平，在压印滚筒上测量横向允差

0.04mm

一几何精度

序号	名称	检验允差	检验结果
J01	压印滚筒	锥度允差 0.01 圆柱度允差 0.015 安装后跳动度 0.035	
J02	印刷滚筒	锥度允差 0.01 圆柱度允差 0.015 安装后跳动度 0.025	
J03	背面滚筒		
J04	螺杆移动	移动精度	
J05	网纹辊		
J06	墨斗	墨在机器上运行二小时有 无有 漏墨，停机后在开动，有 无飞墨，刮刀有无均匀	
J07	烘干	最高速度印刷时，烘干是 否能达到 正常效果，测试正反	
J08	电气		
J09	噪声		
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八. 操作作业指导书

印长范围：127mm-254mm

网纹滚筒:200 线/in

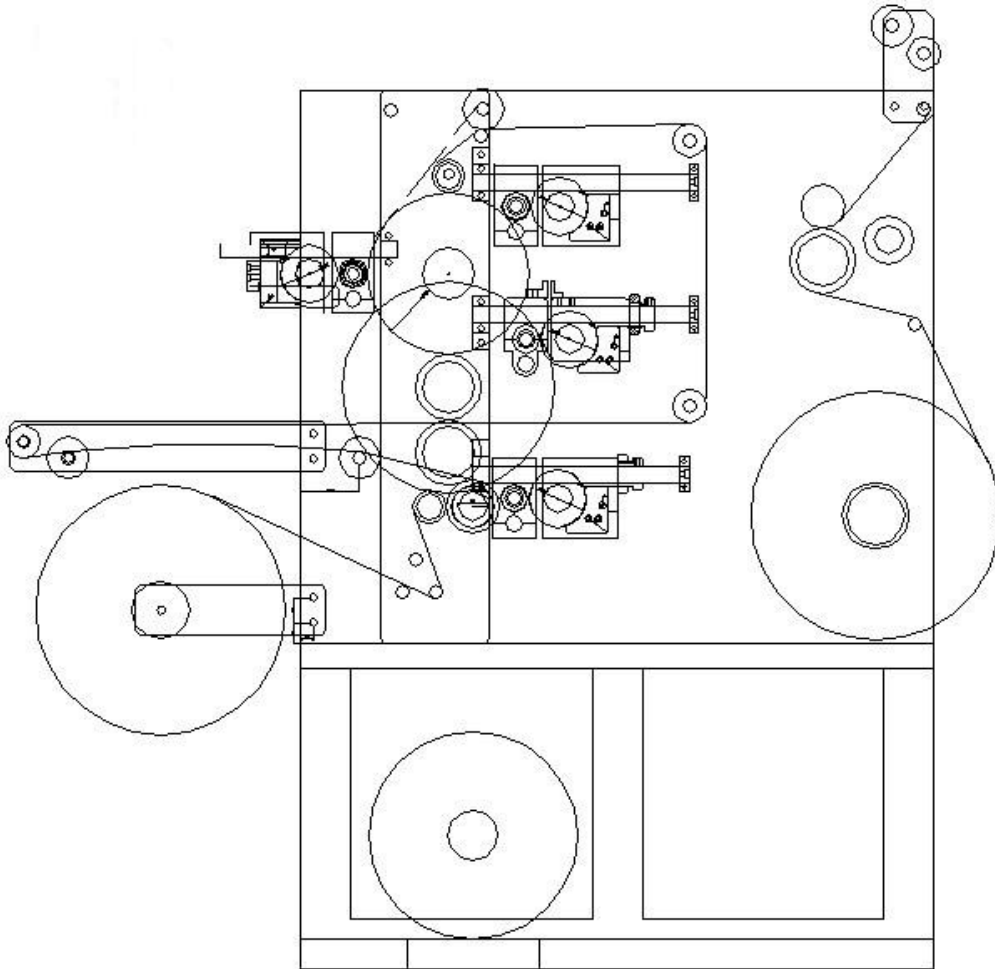
长度计量器：《程式设定》注参考 2-1

最高速度：60 米/分

电压：220V/50HZ

选择配件	基本配件
陶瓷网纹滚筒	200 线/in 网纹滚筒
齿轮	1 套 印筒
双收卷器	1 套 齿轮
双放卷齐集	电热板
印筒和齿轮	烘箱 背印一色

1. 请务必在详细熟读《使用说明书》，真正领会。安全理解本说明书内容之后，方能搬运，安装，调试和操作维护 JR 柔版系列商标印刷机
2. 本机械设备的搬运，安装，操作安全及用电，高温等安全规范，除按本《使用说明书》的要求外，还应严格遵照国家及机械，电器行业的有关规定执行。
3. 本《使用说明书》及本公司柔性版系列各机型知识产权属于瑞安景大印刷机械有限公司。请妥善保管使用，请不要泄露给第三方人员。若有侵权行为发生，本公司保留依法追究权利。

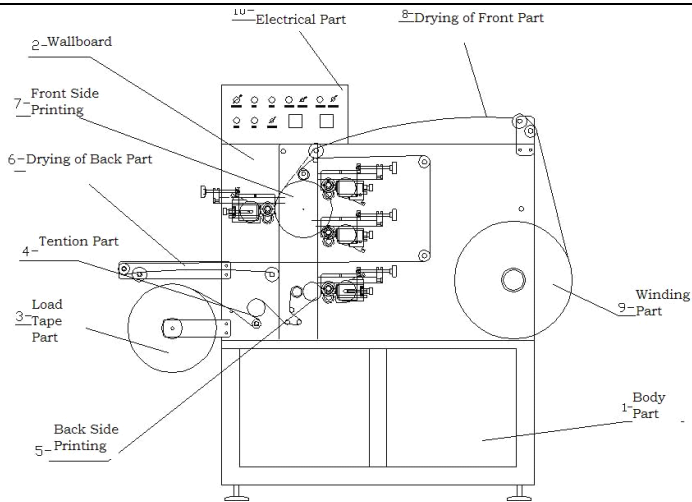


本公司自 2000 年以来，景大一直从事印刷机械设计研发和制造的专业生产企业。随着各型印刷机械产品大量投放国内外市场以后，我们在广泛赢得国际，国内用户信赖的基础上，不断上质量，增品种，使产品标准化，系列化。

尤其是我们的 JR 柔版系列商标机，质量上乘，机型多样，功能齐全，操作简便，售后服务，诚信可靠，是柔印用户经营致富的理想选择，远销欧美，东南亚，中东和 南 美洲等国际市场以来，深受各国家，地区的代理商和用户的青睐及过度评价。

一. 本机工作原理

通过刻有高精度致密网穴的网纹辊直接在墨斗内作旋转运动，控制墨斗内的出墨片刮刀与网纹辊的间隙大小，将适量的油墨均匀的传递到印刷版轮圆周表面的柔性版上，在由柔性版轮直接滚印到承印物表面，经过电热式烘干板同步烘干，收卷完成印刷过程。其效果快速，高效，环保。印品墨层特别厚实，立体感强。再将印后的收卷整盘放到电热恒温鼓风干燥箱中约 5-6 小时，便可达到色牢好耐水洗而不脱色的效果。（详见我公司印刷机系列干燥箱有关内容）。印刷原理图见第二页。

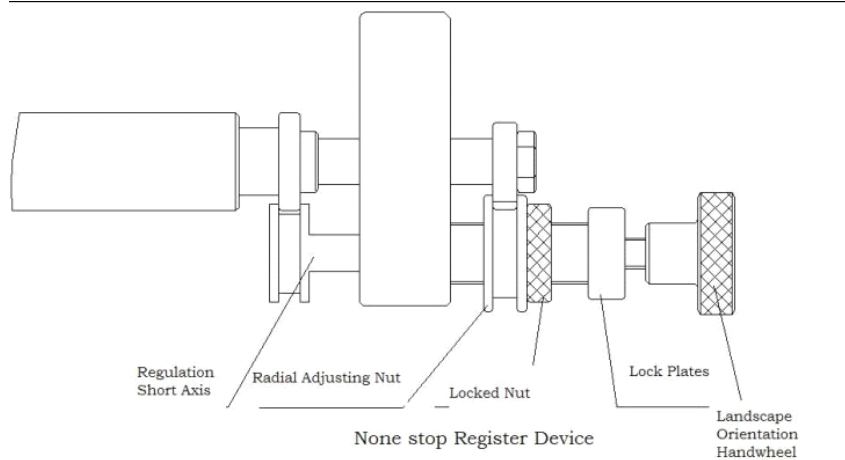


二. 本机结构简介

(一) 关电控制供带装置工作原理

关电开关在无供带遮挡关电开关时，应将带料遮住关电开关，不然无法启动，关电开关，可选择不工作和工作。

(二) 不停机对版



(三) 印刷版轮，对版总成工作方法

本机铝版轮，配套齿轮及菲林长度尺寸对照表

印刷长度	齿数	菲林长度 (版材厚度 1.7mm. 胶带厚度 0.2mm)
5inch=127mm	40z	116.3
5.125 inch=130.175mm	41z	119.49
5.25 inch=133.25mm	42t	122.66
5.375 inch=136.5mm	43z	125.8
5.5 inch=139.7mm	44z	129
5.625 inch=142.875mm	45z	132.19

5.75 inch=146mm	46z	135.368
5.875 inch=149.225mm	47z	138.54
6 inch=152.4mm	48z	141.7
6.125 inch=155.575mm	49z	144.88
6.25 inch=158.75mm	50z	148
6.375 inch=161.92mm	51z	151.2
6.5 inch=165.1mm	52z	154.4
6.625 inch=168.27mm	53z	157.58
6.75 inch=171.451mm	54z	160.76
6.875 inch=174.6mm	55z	163.9
7 inch=177.8mm	56z	167.1
7.125 inch=180.97mm	57z	170.28
7.25 inch=184mm	58z	173.3
7.375 inch=187.3mm	59z	176.6
7.5 inch=190.5mm	60z	179.8
7.625 inch=193.675mm	61z	182.99
7.75 inch=196.85mm	62z	186.16
7.875 inch=200mm	63z	189.3
8 inch=203mm	64z	195.5
8.125 inch=206mm	65z	195.6
8.25 inch=209.5mm	66z	198.86
8.375 inch=212.7mm	67z	202
8.5 inch=215.9mm	68z	205.2
8.625 inch=219mm	69z	208.3
8.75 inch=222.2mm	70z	211.5
8.875 inch=225.4mm	71z	214.7
9 inch=228.6mm	72z	217.9
9.125 inch=231.77mm	73z	221.09
9.25 inch=234.95mm	74z	224.26
9.375 inch=238mm	75z	227.4
9.5 inch=241.3mm	76z	230.6
9.625 inch=244.47mm	77z	233.79
9.75 inch=247.65mm	78z	236.96
9.875inch=250.8mm	79z	240.1
10 inch=254mm	80z	243.3

（四）网纹滚的正确使用及维护

清洗每次要彻底，用高倍放大镜检查。在网纹辊表面的油墨是湿态时，及时对网纹辊进行清洗，可有效防止油墨干燥在网孔里。一般是采用专用的化学清洗剂，通过软化和溶解网孔中的油墨达到清洗的目的。具体的清洗方法是网纹辊置于清洗溶液里一段时间，用专用刷子在网纹辊表面均匀螺旋刷洗定期清洗，针对网孔堵塞严重的网纹辊，特别是对干固在网孔中的油墨。清洁干净后，必须用纯酒精涂布辊

面（齿轮、轴头）挥发水分，再用清洁纸张缠线保护防尘。警示：若油脂玷污在辊面上，请即刻用酒精擦洗

（五）墨斗结构与调节

JR 系列墨斗有分上刮刀和下刮刀墨斗两种，两种墨斗安装方法相同，先松开所有的调墨螺丝，再装入网纹辊座，压入螺丝用手转动网纹辊，仔细观察墨斗两边的铜排方与网纹辊接触情况，如有不对，可调节两边定位螺丝铜排方与网纹辊接触良好，这是保证不漏墨的关键因素。请刚使用本系列的师傅多熟悉。然后压入齿轮转动网纹辊，把机油加入铜排方的加油孔内，再加入油墨，调节墨量。墨斗已做好色组记号请对号装上。

（六）操作面板控制。显示器和按钮名称及作用

1. 运行指示灯：当按下运行按钮时，机器运转，指示灯亮。
2. 印刷速度显示：数字大小显示印刷速度的快慢。
3. 计数器：可预置印品的印刷数量。当印品的实际印刷数达到预置数的某倍数时，机器即自动停车。如需再开机，需按一下计数器上的“清零”按键，使累计数值全部复位归零。（注：印刷品的实际数与预置数值或累计数值的对应关系与印版上单个印刷品的连版数相关）。
4. 停止按钮：此按钮为红色标记按钮，按一下此按钮，印刷电机停止运转。
5. 点动按钮：此按钮为黄色标记按钮，按住此按钮，印刷电机慢速运转，松开此按钮，印刷电机停止转动。此功能用于校版或试机布进运行。若机器在运转状态下，按下此按钮电机即停止运转。
6. 运行按钮：此按钮为绿色标记按钮，当按下此按钮时，机器运转，运行指示灯亮。
7. 印刷速度按钮：旋转此按钮能使印刷电机实现无级调速顺时针方向旋转，印刷速度加快。逆时针方向旋转，印刷速度减慢。
8. 断电保护开关：当承印带料用完时，机器自动停机。探头被承印带料挡住从而机器运转。无承印带料遮挡时即停机。
9. 计数器开关：当需要计数时则按至“工作”(ON)位置，若无需计数时则按取消(OFF)位置。计数显示计算：JR1231 型，显示数字乘以固定值 609.6mm，JR1262 型，显示数字乘以固定值 1219.2mm。
10. 上烘干板温度控制及显示：上烘干板温度控制 I 用于卫星式排布的六色机组印刷后烘干温度控制 3 正反 1，机型为正 3 色印刷烘干温度控制。
11. 上烘干板电源开关：当 6 正 2 反机型只用二色机组印刷烘干时，或 3 正 1 反机型只用单色机组印刷烘干时，可关闭上烘干板。
12. 下烘干板温度控制及显示：6 正 2 反机型用于二色机组印刷烘干温度控制。正 3 反 1 机型用于单色机组印刷烘干温度控制。
13. 下烘干板电源开关：当 6 正 2 反机型只用于卫星排布的六色机组印刷烘干时或 3 正 1 反机型只用于 3 色机组印刷烘干时，可关闭下烘干板

三. 试机及开机，关机

1. 开启总电源
2. 无供带遮挡关电探头时应先将带料遮住关电开关，不然无法启动。
3. 检查计数器是否“归零”。若数码到达预置数而未按至“归零”机器则自动关闭，不能开启。
 - a) 空车试车前应卸下所有无墨斗，轻放一旁。检查各部分运转情况有无异常，尤其应观察网纹辊的旋向，无论何种机型，正确旋向应是网纹辊向各自配对的墨

斗内旋转，若旋向不对，应由电工即时改变电机旋向。当确认无异常后，可进行下一步操作。

- b) 按动主控制箱黄色“点动”按钮，机器处于点动状态。
- c) 按动主控制箱绿色“运行”按钮，调整“印刷速度”旋钮时机器处于低速运转。若仍无异常现象，再进行下列项目调整。
- d) 按下主控制箱红色“停止”“OFF”按钮机器停止运转。机器在运转状态时，按一下黄色“点动”按钮，及6、2型，2/1型主墙板上分置黄色“点动”按钮也兼有停止功能的作用。
- e) 装上墨斗，（若不用的莫个或几个印刷色位墨斗不要装上），再往墨斗内加入适量油墨，均匀调节墨量调节螺钉，时网纹辊出墨量符合要求。（开慢机调整）。

在停机状态下，按所购机型的穿带示意图所示的穿带路线，穿好承印带料。松开螺丝，拿下压盖将贴好柔性印版的版辊轮包括和确认配对齿数正确的配套齿轮，一起装在相对应的印刷色位两端轴孔内。

将版辊轮上的配套齿轮于中心（中间）压印辊齿轮相齿和，然后锁紧可调版，锁紧螺丝、

开慢车调整可调版总成上的各可调手轮，将印刷版轮调节到与网纹辊着墨适量；与压印辊上承印带料滚印的最佳接触压力和最佳接触精度。在印刷实践中，版辊轮与承印带料的滚压接触压力都很小，甚至接近或趋向与“零”

即柔印术语所指的“零压力”印刷接触。总之，调节到兼顾印刷图案，字，线清晰的满意效果即可。此外人人都必须经历从不会到会，边学，边干，边提高的过程。循序渐进，熟能生巧。

正式印刷时。再将调速旋钮的印刷速度调至所需转速或出墨量与电热烘干速度相匹配的印刷速度。

最高印刷速度可达到 60m/min

下班关机程序：关所有电热烘干按钮，关停机按钮-关主控制箱总电源开关-关机外电源。

清洗网纹辊，墨斗，版轮及机器擦拭清洁等。

三. 注意事项及搬运，吊装

- a) 通电开机前机器必须良好接通深埋的接地线。以免引起人员安全事故或烧坏机内变频器调速器等。维护检查时，务必先切断电源，待所有显示消失，确认变频器内部高压指示灯熄灭后，方可是实施维护，检查。
- b) 下列四种机器停机情况，不属于机器故障原因。

断电保护关电探头无承印带料遮挡。遮住关电探头即可。

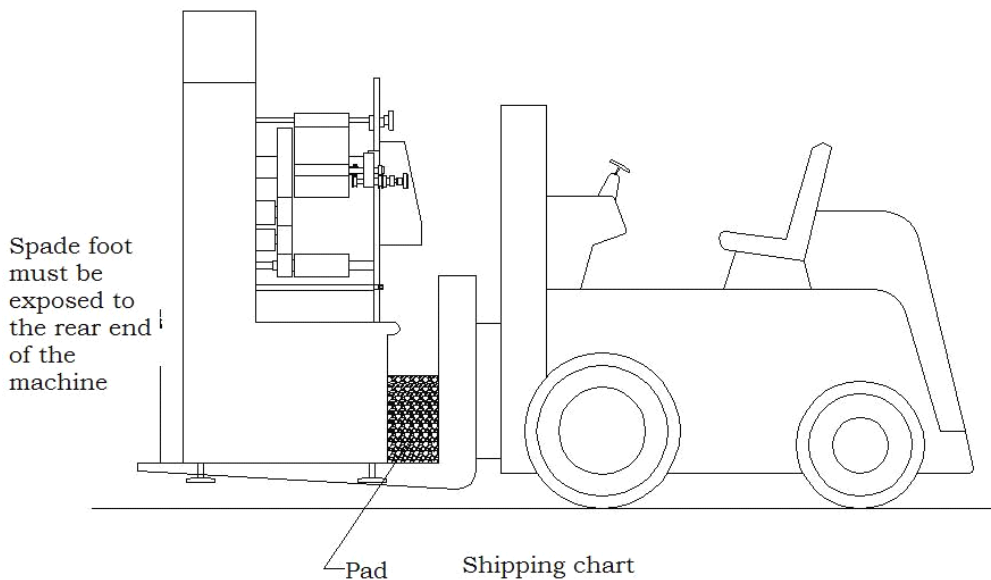
印刷速度调节（电位器）旋钮停在最慢位置。将此按钮顺时针旋动一下即可。

计时器已到达预置数。将计数器复位“归零”即可。

电源电压大于~50V 伏，小于~190 伏，机器不能启动，须用大于机器标示总功率的稳压电源。

- c) 机械设备操作及用电安全规范等，本《使用说明书》未能一一引述，应严格按照国家机械，电器行业规定执行。
- d) 本机墙板及其他构件均系精密部件，吊装时不得将钢丝绳吊在吊环以外的其他任何位置，（只准起吊力加在吊环上）。因不按搬运，起吊要求而损坏机器，后果自负。
- e) 本机器搬运宜用叉车，去包装木箱后，叉车从机器正面下边叉入（见搬运示意

图) 叉起离地面 50-100 毫米时应注意机器的重心位置, 调整平衡后, 方能叉运至机器的安装位置。机器应放于地基牢固, 平衡地面使用, (机器允许放在装箱木底座上使用) 校平地脚调整, 应使机器墙板平面与水平面垂直或墙板平面后倾 0.5 度为宜。




五. 随机附件表

附件名称	数量	备注
《使用说明书》	1 份	本公司编印
拆卸轴承盖螺纹扳手	1 件	本公司制造有 专用工具
卷蕊楔子	2 件	
贴版座	1 件 (组合件)	
增加其它规格版轮及配对齿轮等	按合同装箱	按需定产
内六角扳手	1 套	外购
十字螺丝刀	1 把	外购
速度调节定位器	1 只	外购
墨刀	1 把	
手术刀	1 包	
手术刀柄	1 把	

- 六. 柔版系列印刷机电气原理图
 七. 本机变频器的报警显示和跳闸保护功能

八. 操作作业指导书

 JINGDA <small>PRINTING MACHINERY</small> 瑞安市景大印刷机械有限公司 Ruian Jingda Printing Machinery Co.,Ltd			文件编号	
			制订部门	
			生效日期	
柔性树脂版操作作业指导书			版次	
			页次	第 26 页, 共 28 页
工序	背面曝光、正面曝光、洗版、干燥、除粘、定形	工具设备	剪刀、美工刀、直尺、聚光灯、防毒口罩	检测器具
填写记录	晒版记录表	自检要求		互检要求
材料	菲林、柔性树脂版、苯胺水	参考准则		安全措施
项目	步骤		要求	
工作准备和条件	1、上班穿厂服 2、备好美工刀、直尺 3、备好原稿、菲林、柔性树脂版		1、柔性树脂版放置时不能见光, 以免曝光。	
作业工序	1、背面曝光: 决定版的厚度, 15 秒 2、正面曝光: 时间为 10-15 分钟, 根据字体的粗细决定。 3、洗版: 一般为 200 秒, 用苯胺水 4、干燥: 10 分钟左右, 温度 60℃。 5、除粘: 根据洗版水的新旧程度, 决定除粘时间, 一般为 10 分钟。 6、检查: 是否与原稿符合, 图案清晰度、线条完整性, 是否变形。 7、记录: 作晒版记录, 时间、数量等 8、晒版结束: 把苯胺水放置于桶内贮藏, 擦试机台卫生, 打扫制版室。			
注意事项	1、洗版时, 刷子四个角一定要平行。 2、洗版时不能加温度			
常见问题	原因		处理方法	
版变形	烘干筒的温度过高, 时间过长		合理控制温度	

残缺	洗版时间过长，曝光时间不够			
图形变粗	菲林药膜面放反			
洗不出来	版要存放时已被曝光			
编制		审核		批准

景大印刷

客户 印刷版筒和配对齿轮选择表

齿数 (配对)	印刷滚筒	印刷长度	数量	备注

售后服务经理:

客户签字: