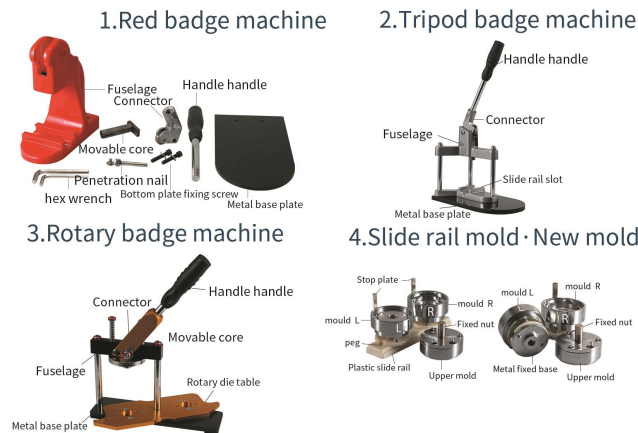


To the best of my ability provide service

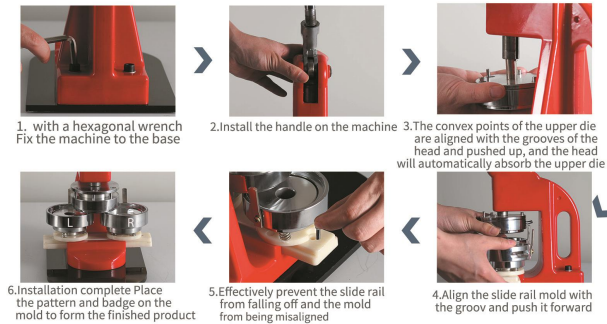
USER MANUAL



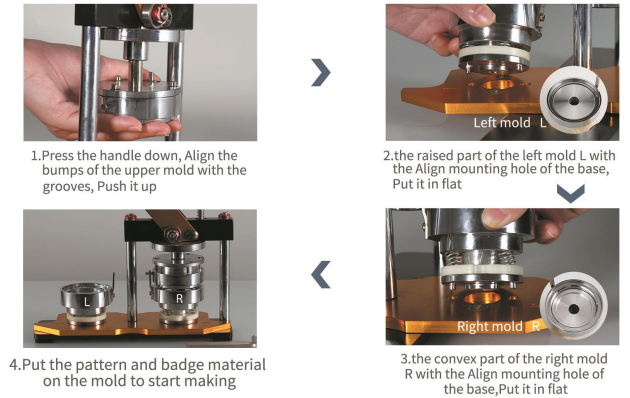
◆ DISASSEMBLY DRAWING OF BADGE MOLD



◆ BADGE MACHINE INSTALLATION PROCESS



◆ INSTALLATION PROCESS OF ROTATING BADGE MACHINE

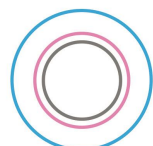


◆ BADGE MAKING PROCESS



◆ DESIGN STANDARD OF BACKGROUND PAPER

finished product Size of	Image specifications	Cutting size	finished product Size of	Image specifications	Cutting size
25mm	20mm	35mm	25×18mm	20×13mm	35×28mm
35mm	27mm	44mm	39×31mm	34×26mm	49×42mm
37mm	32mm	48.5mm	47×32mm	42×27mm	57×42mm
44mm	39mm	54mm	57×45mm	52×42mm	67×55mm
50mm	45mm	60.5mm	69×45mm	64×40mm	80×57mm
56mm	51mm	66mm	32×32mm	27×27mm	42×42mm
58mm	53mm	69.5mm	50×50mm	45×45mm	61×61mm
75mm	70mm	86mm	68×24mm	63×19mm	79×34mm
100mm	95mm	115mm			
158mm	153mm	179mm			



- finished product
Size of
- Image
specifications
- Cutting size

↓
Tinplate
Upper cover

↓
Plastic base

↓
Transparent protective film

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



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

◆ 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