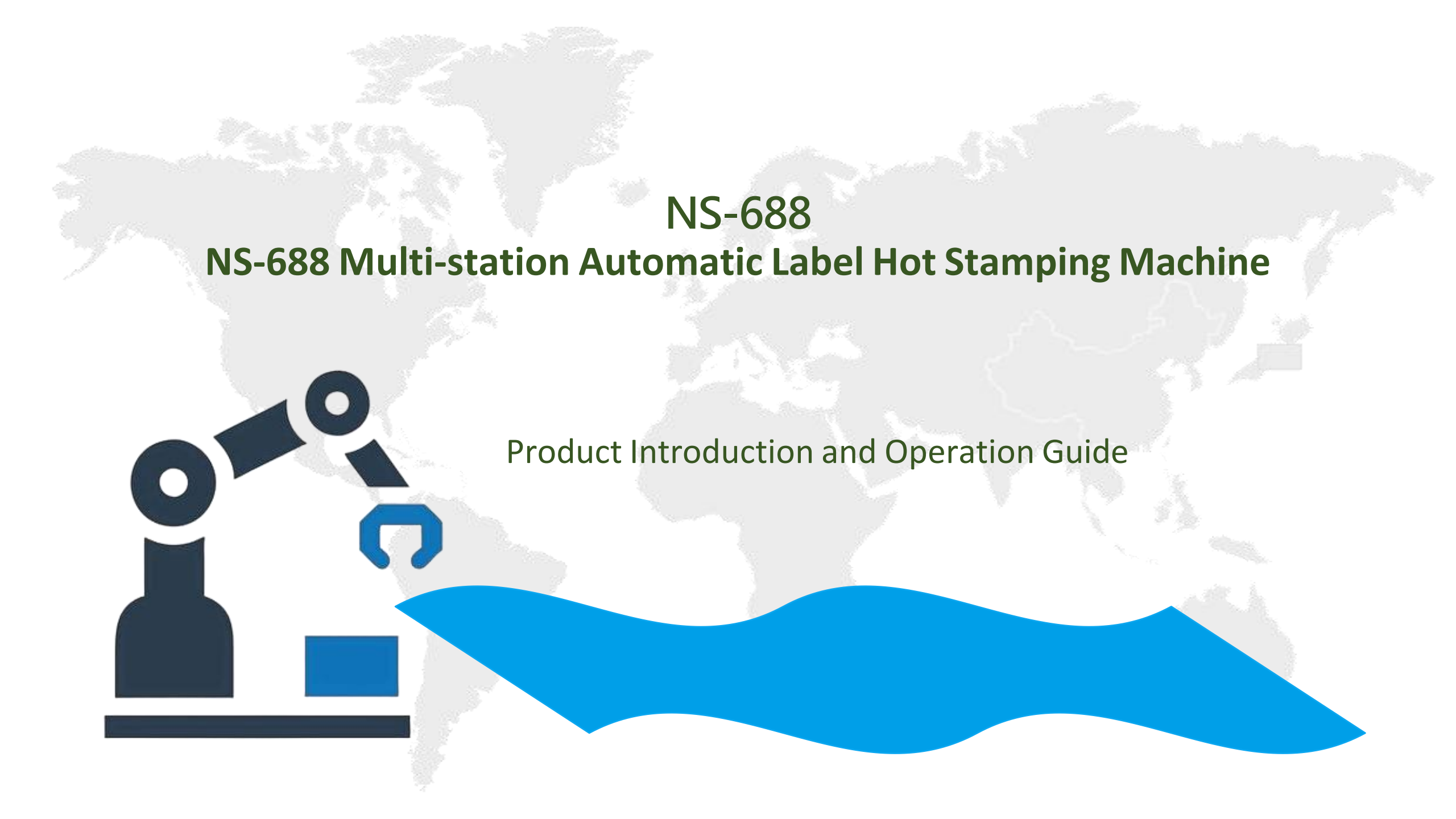
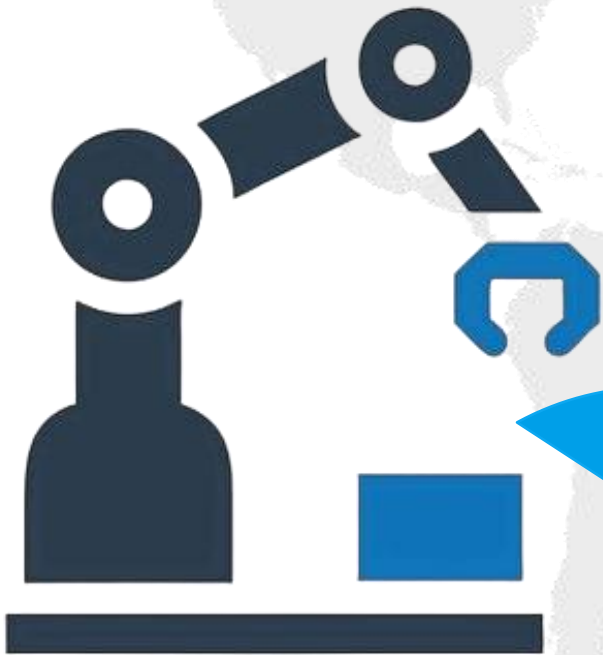


A light gray, stylized world map serves as the background for the entire page. It shows the outlines of continents and major countries.

NS-688

# NS-688 Multi-station Automatic Label Hot Stamping Machine

Product Introduction and Operation Guide



## Product Introduction

- The fully automatic five-station rotating label ironing machine is an automated equipment that integrates automatic label feeding, precise label placing, high-temperature pressing and ironing, cooling, film tearing, and material collecting.
- It adopts a five-station circular rotation structure to achieve continuous, high-speed and stable production.
- with an automatic label feeding device, mechanical arm positioning, a cooling and film tearing system, and an automatic sheet collecting device.
- Suitable for ironing and pressing trademarks on clothing, T-shirts, shirts, trousers, and underwear.
- Fully automated process, reducing manual labor and improving the consistency of quality.



## Operating Procedure

1. Turn on the machine and check the power supply and air source.

power switch

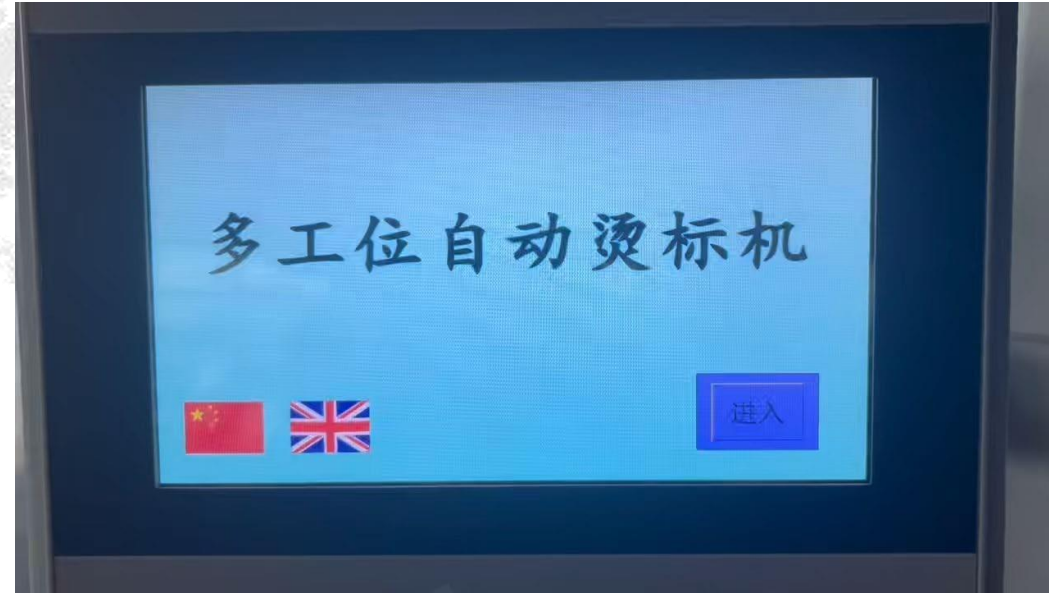


1. Set the temperature and pressure.

Main gas valve



The air pressure must not be lower than (0.6Mpa)



Enter the screen page and turn on the temperature control and the function switches that need to be used.

Pressure regulating valve for ironing cylinder



**Boost pressure adjustment:**  
Slowly rotate the pressure regulating knob clockwise, observe the pointer of the pressure gauge until the target pressure is reached (e.g., 0.25~0.70 MPa)

Operating Procedure

Page Introduction

Click Settings or Parameter Settings on the main page to access control parameters and primary parameter adjustments.

Main control page

Multi station automatic hot stamping machine

Production count

0

Clearing

on  
off

on  
off

on  
off

on  
off

on  
off

Connect

Temperature

Feeding SW

Throw

Film peeling

Collecting SW

Manual

Label Change

Setting

parameter setting

Preheat

turntable



control parameters

Setting

Home

Logo Position 1

Film Peeling 1

Peel Area

Clamp Area

Logo Position 2

Reset

Film Peeling 2

0.0

0.0

Logo Position 3

Film Peeling 3

0.0

0.0

Feeding Position

0.0

Pressing time

0.0

Cooling time

0.0

Cooling Position

0.0

Turntable

Label Feeding Single Step

Film Peeling Single Step

Level 1 control parameters entered

Multi station automatic hot stamping machine

Production count

0

Clearing

on  
off

on  
off

on  
off

on  
off

on  
off

Connect

Temperature

Feeding SW

Throw

Film peeling

Collecting SW

Manual

Label Change

Setting

parameter setting

Preheat

turntable



System Parameter

Label Feeding Rotation Motor

Current Position

0.0

Standby Position

0.0

1rd Label Suction Position

0.0

2nd Label Suction Position

0.0

3st Label Suction Position

0.0

Waiting Position

0.0

Label Placement Position

0.0

Film Placement Position

0.0

lift up motor

Current Position

0.0

Up Position

0.0

Label Placement Position

0.0

Up

Reset

Down

Label Peeling Cooling Pressing Cloth Motor

Current Position

0.0

Standby Position

0.0

Cooling Pressing Cloth Position

0.0

Left

Reset

Right

Left

Reset

Right

Label Peeling Motor

Current Position

0.0

Standby Position

0.0

Start Position

0.0

Label Peeling Position

0.0

Label Discaard Position

0.0

Left

Reset

Right

Turntable Motor

Rotate

Reset

Control Panel

IO page

manual page

next page



parameter page-two

|                                      |     |                                              |     |
|--------------------------------------|-----|----------------------------------------------|-----|
| Label Pick Vacuum On Delay           | 0.0 | Cloth Press Cylinder Delay                   | 0.0 |
| Label Pick Vacuum Off Delay          | 0.0 | Material Press Cylinder Delay                | 0.0 |
| Positioning Cylinder Delay           | 0.0 | Rewind Material Press Cylinder Extend Delay  | 0.0 |
| Label Peeling Up/Down Cylinder Delay | 0.0 | Rewind Material Press Cylinder Retract Delay | 0.0 |
| Label Peeling Cylinder Delay         | 0.0 | Rewind Material Push Cylinder Delay          | 0.0 |
| Cooling Time                         | 0.0 | Label Ironing Cylinder Delay                 | 0.0 |
| Air Blow Time                        | 0.0 | Label Ironing Time                           | 0.0 |
|                                      |     | Preheating Time                              | 0.0 |

Control Panel

IO page

manual page

up page

# Operating Procedure

System Parameter

Label Feeding Rotation Motor

Current Position0.0

Standby Position0.0

1rd Label Suction Position0.0

2nd Label Suction Position0.0

3st Label Suction Position0.0

Waiting Position0.0

Label Placement Position0.0

Film Placement Position0.0

LeftResetRight

lift up motor

Current Position0.0

Up Position0.0

Label Placement Position0.0

UpResetDown

Label Peeling Cooling Pressing Cloth Motor

Current Position0.0

Standby Position0.0

Cooling Pressing Cloth Position0.0

LeftResetRight

Label Peeling Motor

Current Position0.0

Standby Position0.0

Start Position0.0

Label Peeling Position0.0

Label Discaard Position0.0

LeftResetRight

Turntable Motor

RotateReset

Control PanelIO pagemanual pagenext page

manual page

Label Ironing Cylinder 1

Cloth Pressing Cylinder 1

Peel/Cool/Press Up /Down Cylinder

Positioning Cylinder

Label Ironing Cylinder 2

Cloth Pressing Cylinder 2

Label Peeling Up /Down Cylinder

Vacuum On / Vacuum Suction

Label Ironing Cylinder 3

Cloth Pressing Cylinder 3

Label Peeling Cylinder

Vacuum Off / Vacuum Break

Label Ironing Cylinder 4

Cloth Pressing Cylinder 4

Material Receiving Pressing Cylinder

vacuum breaking

Label Ironing Cylinder 5

Cloth Pressing Cylinder 5

Material Receiving Pushing Cylinder

Control Panelparameter settingTurntable RotationTurntable Reset

## Page Introduction

IO page-one

X0 Air Pressure Check

X1 E-Stop

X2 Spare

X3 Light Curtain

X4 Spare

X5 Turntable Motor Home

X6 Label Feed Rotation Home

X7 Label Feed Vertical Home

X10 Label Vacuum Check

X11 Spare

X12 Label Position Check

X13 Turntable Positioning Cylinder Signal

X14 Turntable Motor Error

X15 Label Feed Rot Motor Error

X16 Label Feed Vertical Error

X17 Cylinder In Position (Peel)

X20 Foot Switch

X21 Temperature Not Reached Signal

X22 Station Sensor #1 Signal

X23 Station Sensor #2 Signal

X24 Station Sensor #3 Signal

X25 Spare

X26 Turntable Rotation Button

X27 Registration Button

X30 workstation detection-one

X31 Peeling & Pressing Motor Error

X32 Label Peeling Motor Error

X33 Spare

X34 Spare

X35 Spare

X36 Spare

X37 Spare

Control Panelparameter settingnext page

IO page-two

Y0 Turntable Motor PU

Y1 Label Feed Rot Motor PU

Y2 lift up motor-PU

Y3Label Feeding Up/Down Motor PU

Y4Label Peeling Motor PU

Y5 Spare

Y6 Spare

Y7 Spare

Y10 Hot stamping cylinder-one

Y11 Hot stamping cylinder-two

Y12 Hot stamping cylinder-three

Y13 Hot stamping cylinder-four

Y14 Hot stamping cylinder-five

Y15 positioning cylinder

Y16Spare

Y17Spare

Y20 Turntable Motor DR

Y21 Label Feed Rot Motor DR

Y22 pressing cylinder-three

Y23 Label Feed Vert Motor DR

Y24 Label Peel Motor DR

Y25 suction cylinder

Y26 vacuum suction

Y27 Label Peel Vert Cyl

Y30 Cloth Press Cyl 1

Y31 Cloth Press Cyl 2

Y32 Cloth Press Cyl 3

Y33 Cloth Press Cyl 4

Y34Cloth Press Cyl 5

Y35 Label Peeling & Clamping Cylinder

Y36 Label Suction Vacuum On

Y37 Label Suction Vacuum Off

Y40 Spare

Y41 Material Receiving & Pressing Cylinder

Y42 Material Receiving & Pushing Cylinder

Y43 Buzzer

Y44 Tri-color Light - Red

Y45 Tri-color Light - Yellow

Y46 Tri-color Light - Green

Y47 Spare

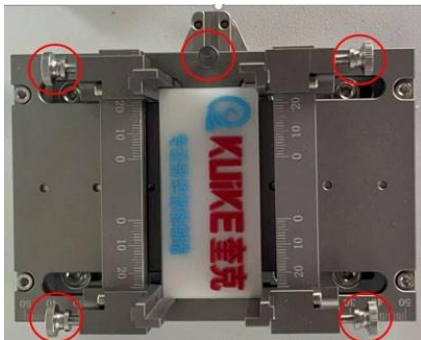
Control Panelparameter settingmanual pageup page

## Operating Procedure

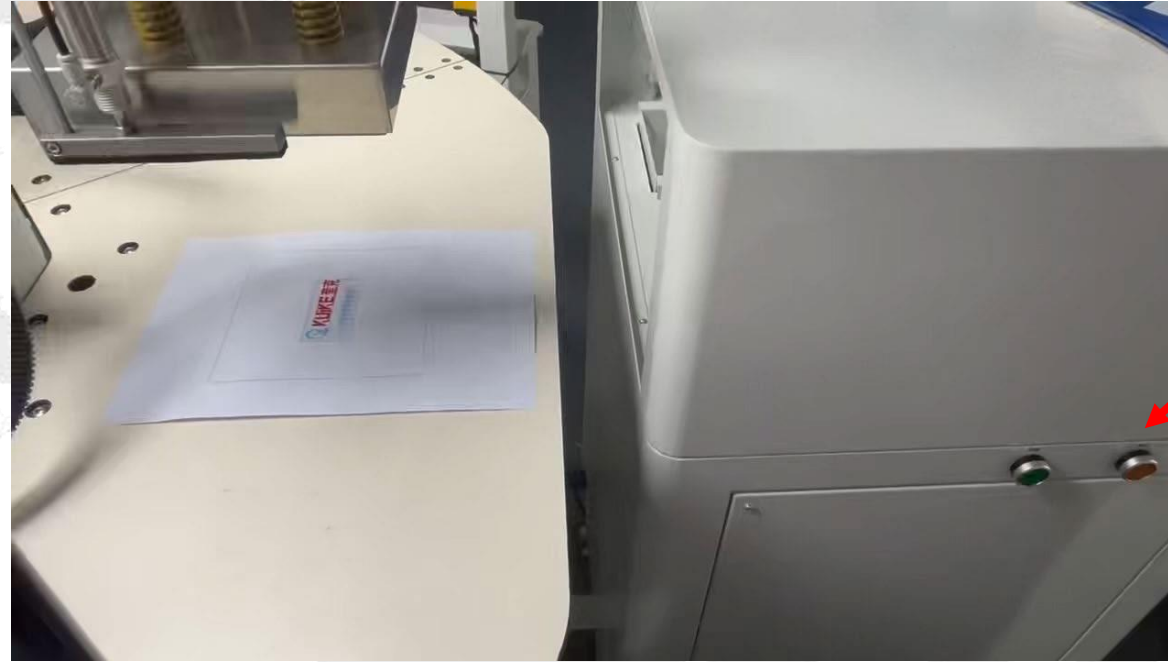
3. Set the temperature and align the position



① Press the SET key to enter the 5U temperature setting mode. After adjusting the temperature data with the white triangle key, press the SET key once to return to the main page, and then the temperature setting is completed. Adjust the temperatures of the remaining workbench pressing machines in sequence.



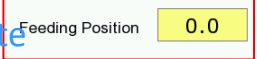
② Loosen the 5 bottom screws (inside the red circle) according to the size of the printed mark, adjust the position, and then tighten them.



Green Benchmarking Button

orange rotating button

③ Press the yellow button to rotate the workstation to the marking feeding position, and place the alignment template against the rubber plate.

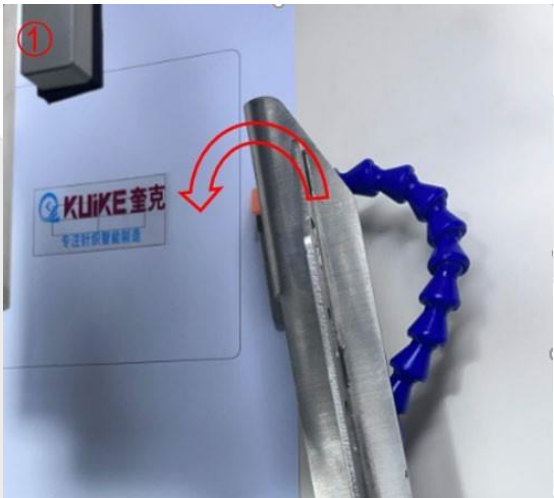
④ Press the green alignment button. The robotic arm will pick up the heat transfer label, hover above the sample, then press the alignment key, and the label-feeding manipulator will descend. The descending distance needs to be adjusted by clicking the lower label placement adjustment on the settings page , The smaller the number, the greater the distance from the rubber plate

⑤ Align the template with the mark and stick the template well. Then press the alignment key, repeat placing the mark twice to ensure the mark is consistent with the template, and stick the templates for all workstations in the same way.

# Operating Procedure

## 4.Set the tear label cooling time

Click on the homepage **Setting** to enter the settings page, click to enter the label tearing single-step mode **Film Peeling Single Step**, step on the start switch, the cooling cloth pressing motor reaches the cloth pressing position, and the cloth pressing position. The motor rotation angle can be adjusted through the cooling position parameter; the larger the value, the more it moves to the left (as shown in Figure ①)

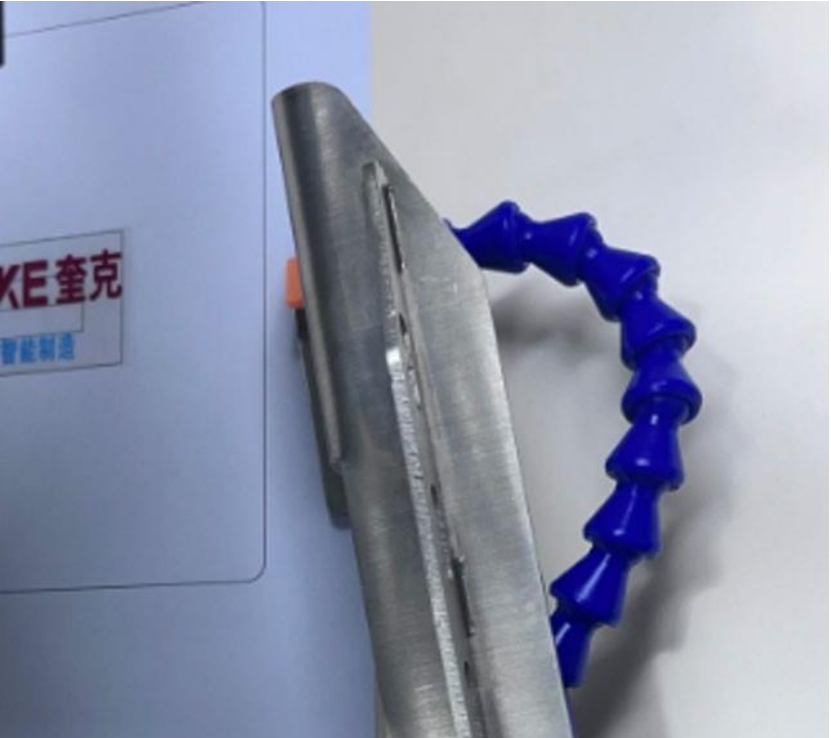
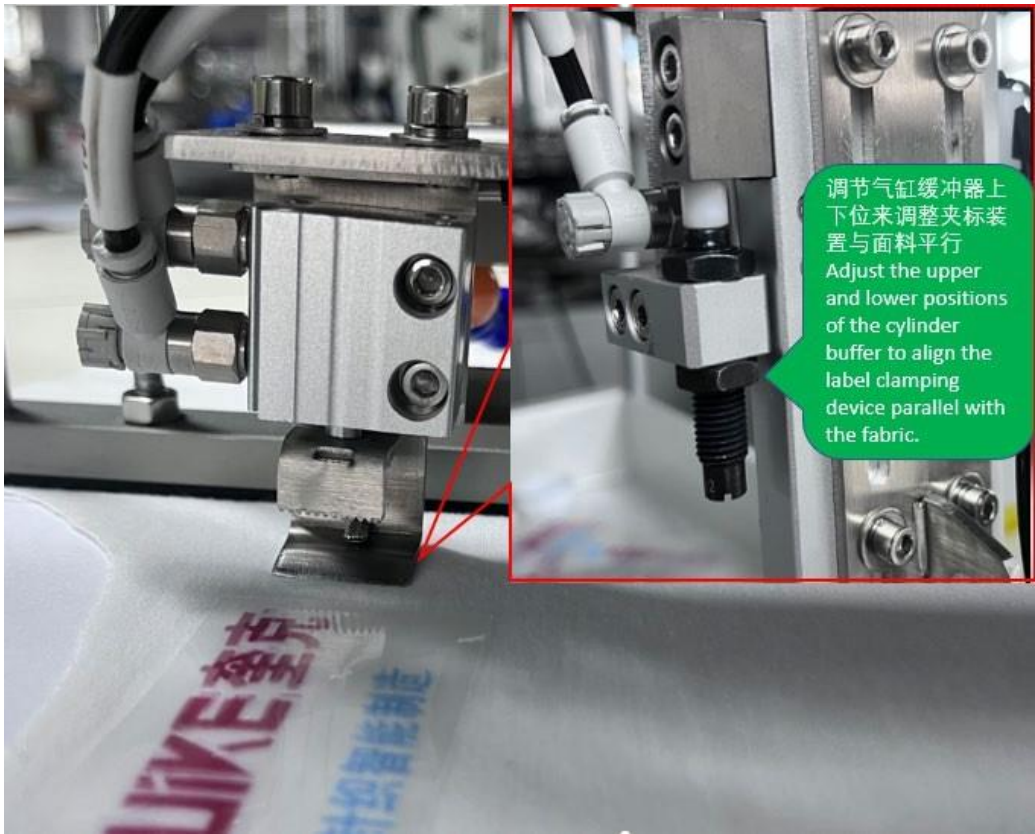


Continue to press the start switch, and the label tearing motor will reach the label tearing position. The label tearing position is set through the parameters of the label tearing position and the label clamping position.

|                | Peel Area | Clamp Area |
|----------------|-----------|------------|
| Film Peeling 1 | 0.0       | 0.0        |

# Operating Procedure

## 4.Set the tear label cooling time



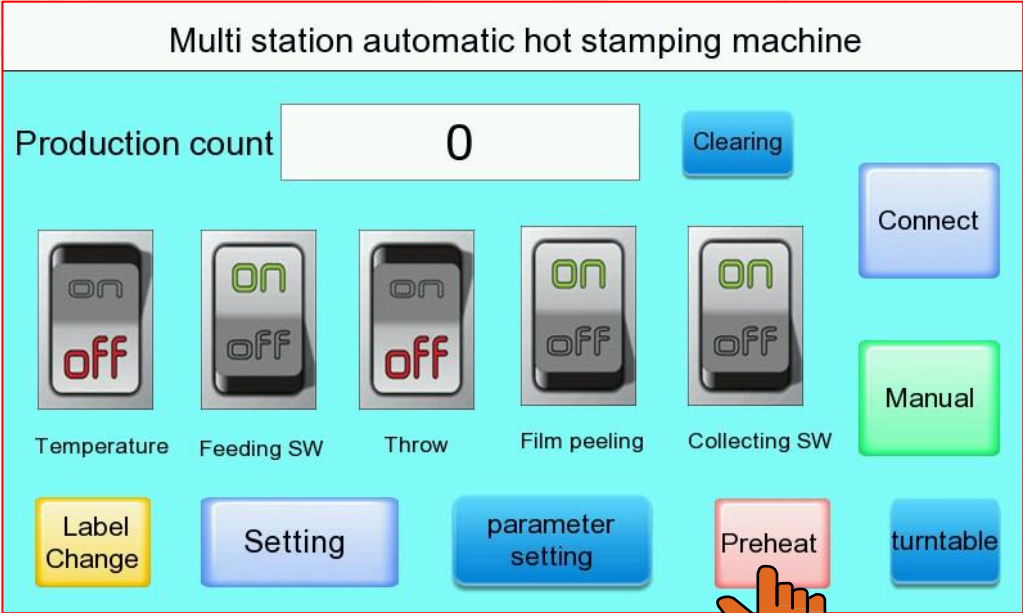
| parameter page-two                   |     |                                              |     |
|--------------------------------------|-----|----------------------------------------------|-----|
| Label Pick Vacuum On Delay           | 0.0 | Cloth Press Cylinder Delay                   | 0.0 |
| Label Pick Vacuum Off Delay          | 0.0 | Material Press Cylinder Delay                | 0.0 |
| Positioning Cylinder Delay           | 0.0 | Rewind Material Press Cylinder Extend Delay  | 0.0 |
| Label Peeling Up/Down Cylinder Delay | 0.0 | Rewind Material Press Cylinder Retract Delay | 0.0 |
| Label Peeling Cylinder Delay         | 0.0 | Rewind Material Push Cylinder Delay          | 0.0 |
| Cooling Time                         | 0.0 | Label Ironing Cylinder Delay                 | 0.0 |
| Air Blow Time                        | 0.0 | Label Ironing Time                           | 0.0 |
|                                      |     | Preheating Time                              | 0.0 |

Control PanelIO pagemanual pageup page

The cooling time can be adjusted via the cooling time and blowing time settings on the configuration page.

# Operating Procedure

## 1.Preheating for perm, online matching



| parameter page-two                   |     |                                              |     |
|--------------------------------------|-----|----------------------------------------------|-----|
| Label Pick Vacuum On Delay           | 0.0 | Cloth Press Cylinder Delay                   | 0.0 |
| Label Pick Vacuum Off Delay          | 0.0 | Material Press Cylinder Delay                | 0.0 |
| Positioning Cylinder Delay           | 0.0 | Rewind Material Press Cylinder Extend Delay  | 0.0 |
| Label Peeling Up/Down Cylinder Delay | 0.0 | Rewind Material Press Cylinder Retract Delay | 0.0 |
| Label Peeling Cylinder Delay         | 0.0 | Rewind Material Push Cylinder Delay          | 0.0 |
| Cooling Time                         | 0.0 | Label Ironing Cylinder Delay                 | 0.0 |
| Air Blow Time                        | 0.0 | Label Ironing Time                           | 0.0 |
| Preheating Time                      |     |                                              | 0.0 |

Control Panel IO page manual page up page

On the main page, click the preheating button, and the four hot pressing cylinders will press down simultaneously for preheating. (The workstations for placing garment pieces during operation are equipped with safety protection devices, so the cylinders will not press down.) After preheating is completed, click the indexing button to move the non-preheated workstations to the next position, then click the preheating button again to start preheating. The preheating duration can be adjusted via parameter settings.

Preheating time setting

**THANKS**