LS9072A

Heat transfermachine

Specification

Zhejiang LENSH Intelligent Technology Co., Ltd.

COMPANY PROOFLIE

LENSH IS OPEN

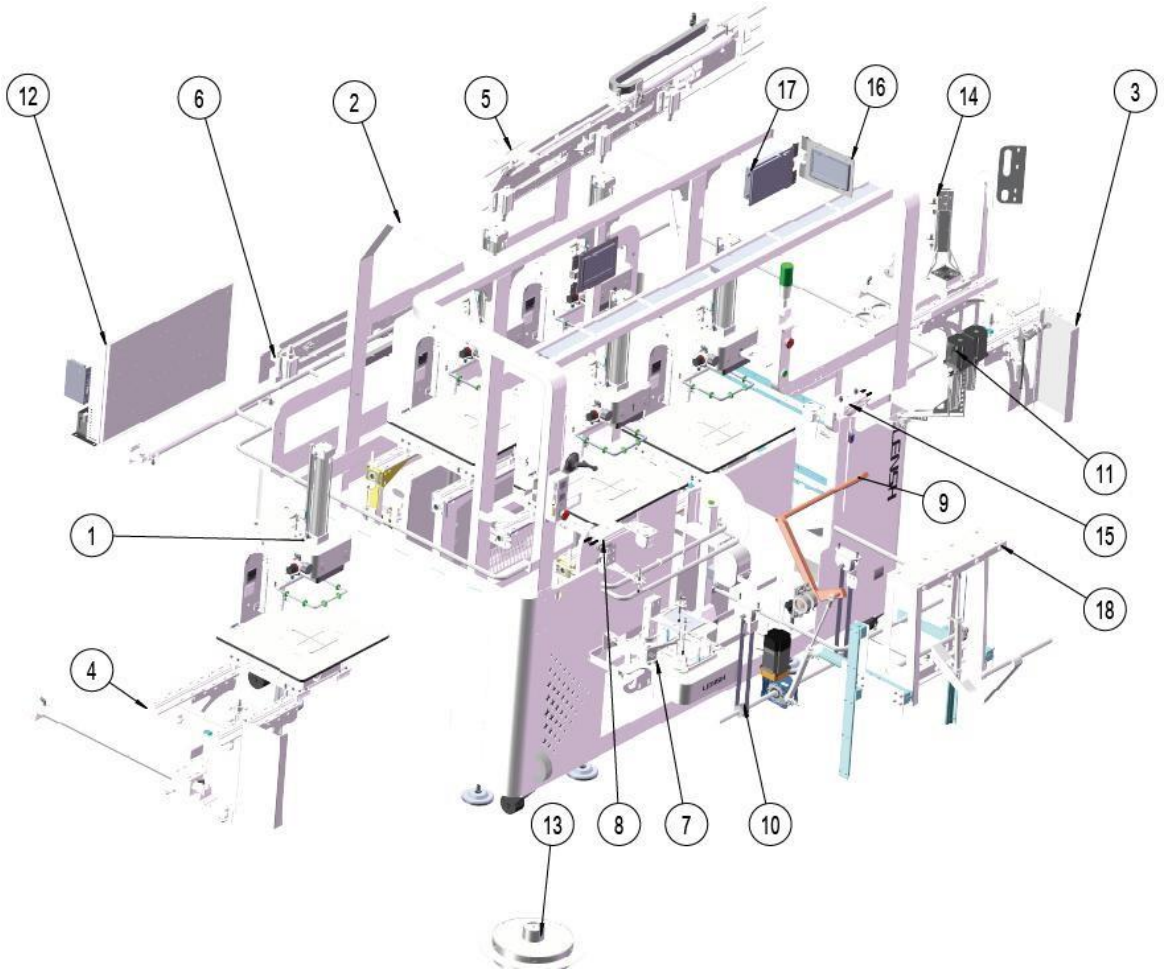
Zhejiang LENSH Intelligent Technology Co., Ltd. is located in Ningbo, Zhejiang province, mainly engaged in the research and development of automatic sewing equipment, production, based on the forefront of intelligent sewing technology, is committed to becoming a benchmark enterprise of intelligent sewing equipment research and application. The company is currently in the production of equipment LS5011 intelligent rope head knot machine, LS6021 rope threading machine, LS7031 intelligent access control machine, LS7041 sewing pressure two in one, LS7051 intelligent thread machine, LS8121 washing machine, LS2181 intelligent dispensing machine, etc., the company's product design covers the "integration of two" concept. The company has a strong management and technical research and development team, adhering to the "innovation, high efficiency, saving people, intelligent" business philosophy to step forward.

Table of Contents

1. Specifications

Model	LS-9072A	LS-9072A-01	LS-9072A-02	LS-9072A-03
	Standard version	Small pieces are collected	Underheat	Underheat Small pieces are collected
Voltage	220V 50~60Hz Single			
Power	4KW		6.5KW	
Air Pressure	0.5-0.6MPa			
Air consumption	400L/min			
Dimensions	2515-2230-1910mm			
packing size	2300-1700-1960mm			
Net weight	970kg			
Gross weight	1150kg			

2. Component assembly diagram



3. Operation declaration

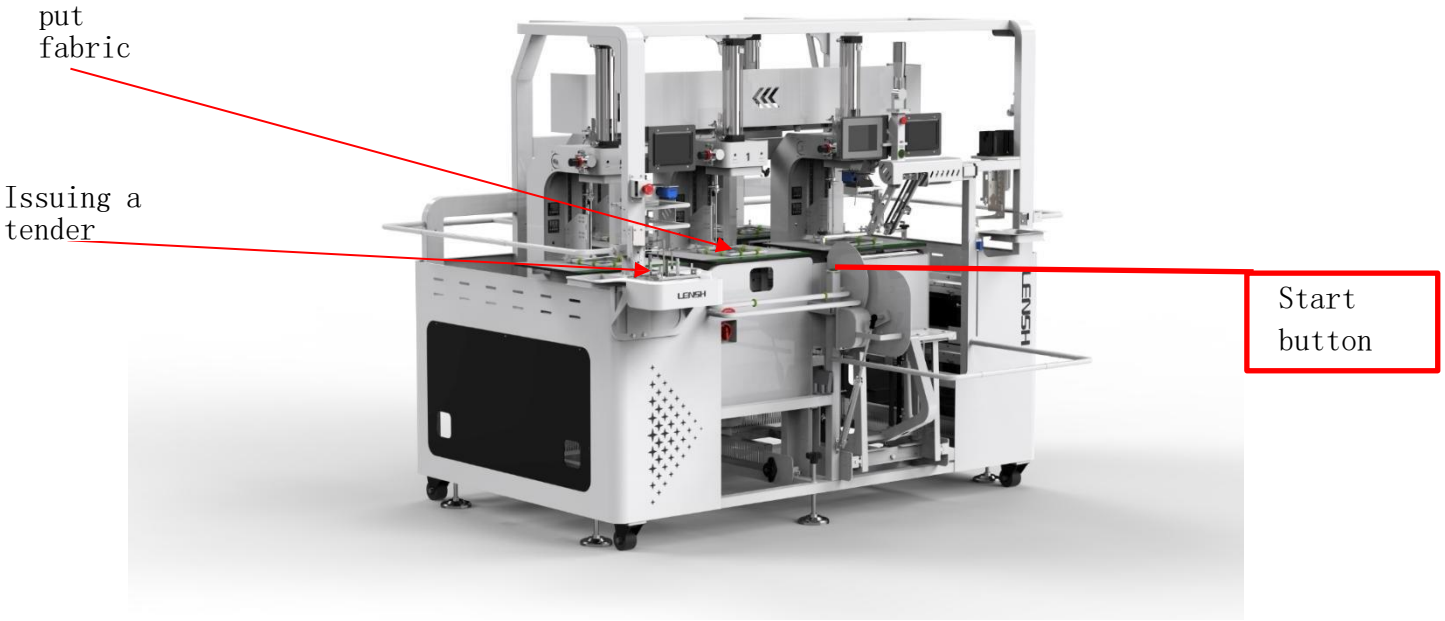
（1） Power on

First of all, insert the main power plug of the machine into the socket, and then press the ON switch to turn on the power. OFF indicates the switch is off, and ON indicates the switch is on

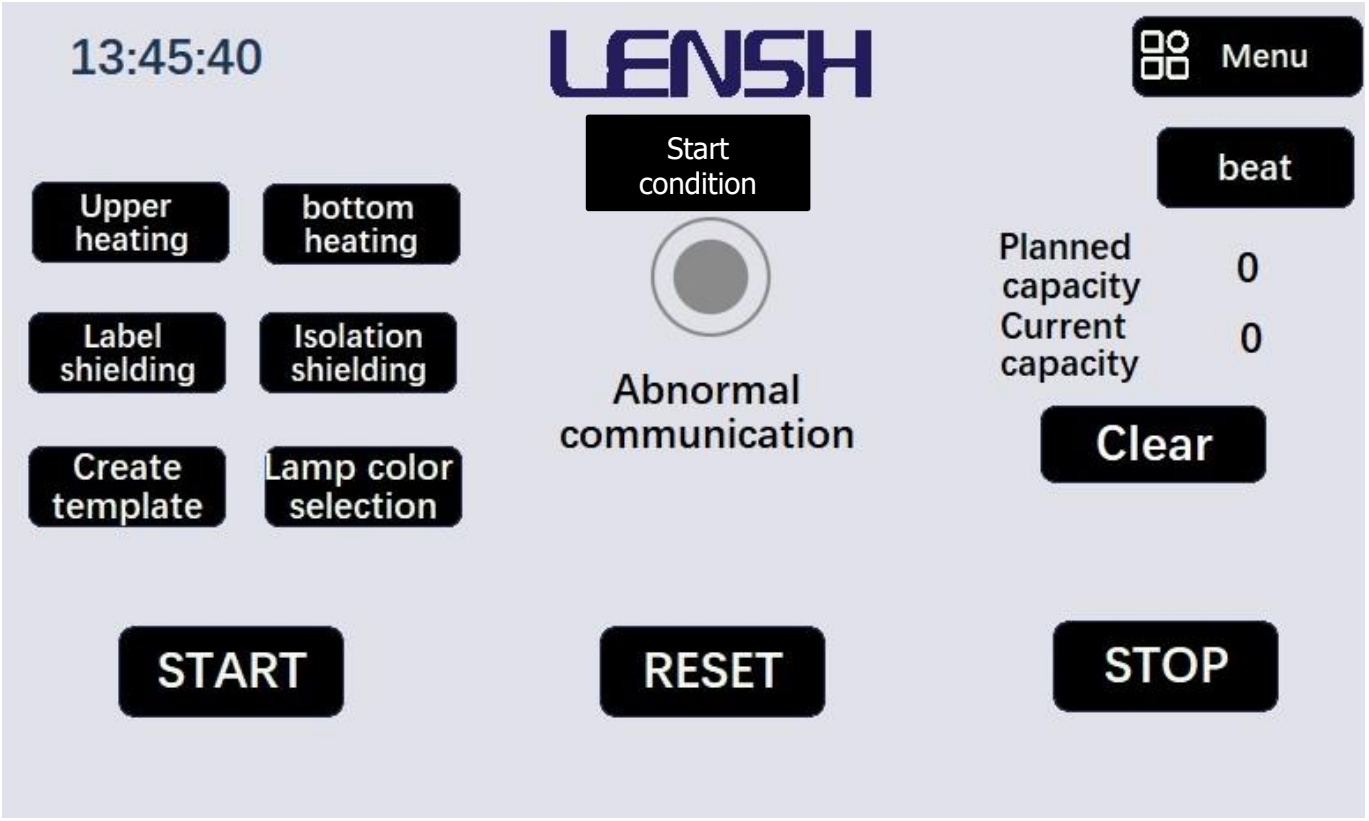
（2） Start steps

1：Place the fabric and labels

2：Press the start button

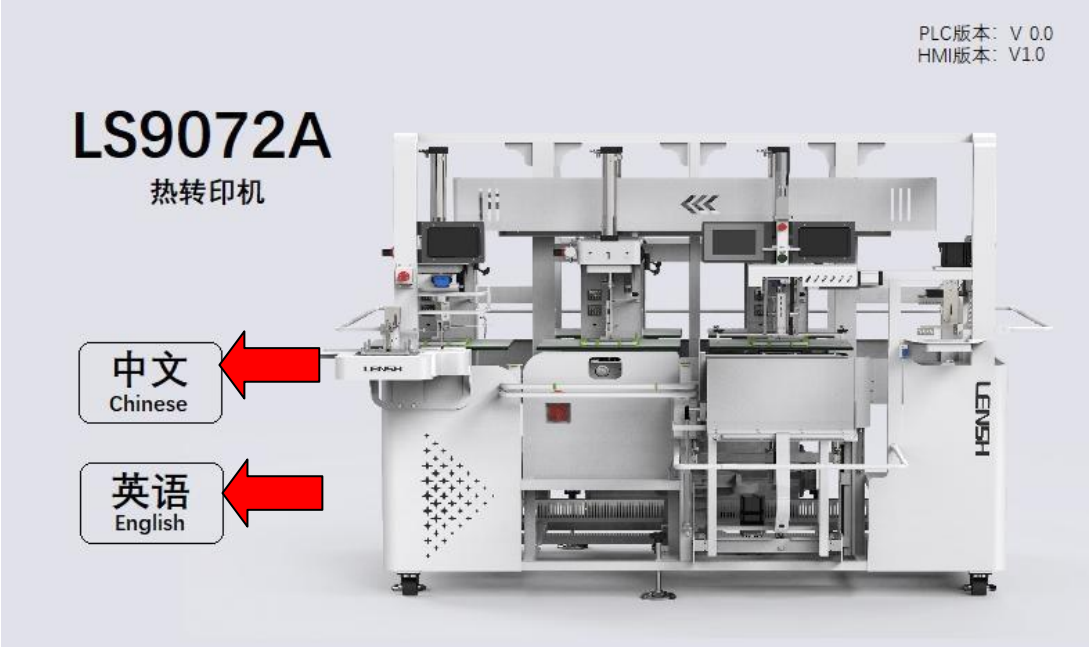


3：Reset → Start in the touch screen



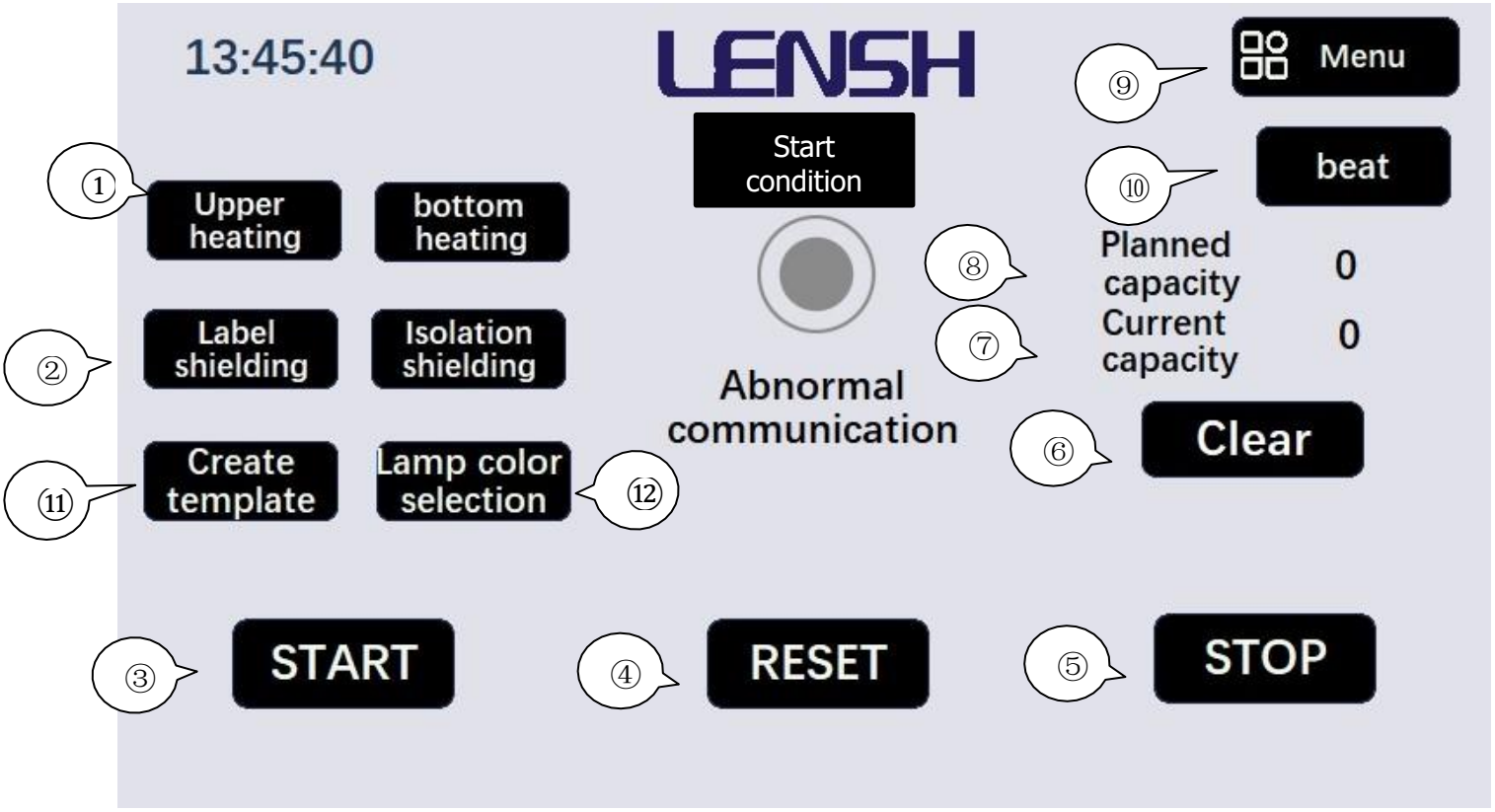
4. Touch screen operation

（1） Boot screen



After turning on the machine's power switch, the touch screen will enter the boot screen within 3 seconds. You can select either Chinese or English mode. After choosing the language mode, click on the device image to switch to the main screen.

（2） Main Interface



① Upper heating ： Turn on the upper heating function.

bottom heating： Turn on the lower heating function (this is optional).

② Label shielding： Press this key to disable the suction of the label pickup suction cup on the feeding assembly (for debugging purposes; normally open during regular operation)

③ . Isolation shielding： Press this key to disable the suction of the release paper suction cup.

④ START： Press this key to start the machine for normal operation.

⑤ RESET： Restore the machine to its initial power-on state.

⑥ STOP： Press this key, and the machine will stop running after completing the current action.

⑦ Clear： Clears today's production capacity and resets it to zero.

⑧ Current capacity： Displays the current output.

⑨ Planned capacity： You can enter and set the planned production capacity.

⑩ Menu： Press this key to enter the function interface.

⑪ beat： Tap to display the machine operating cycle time

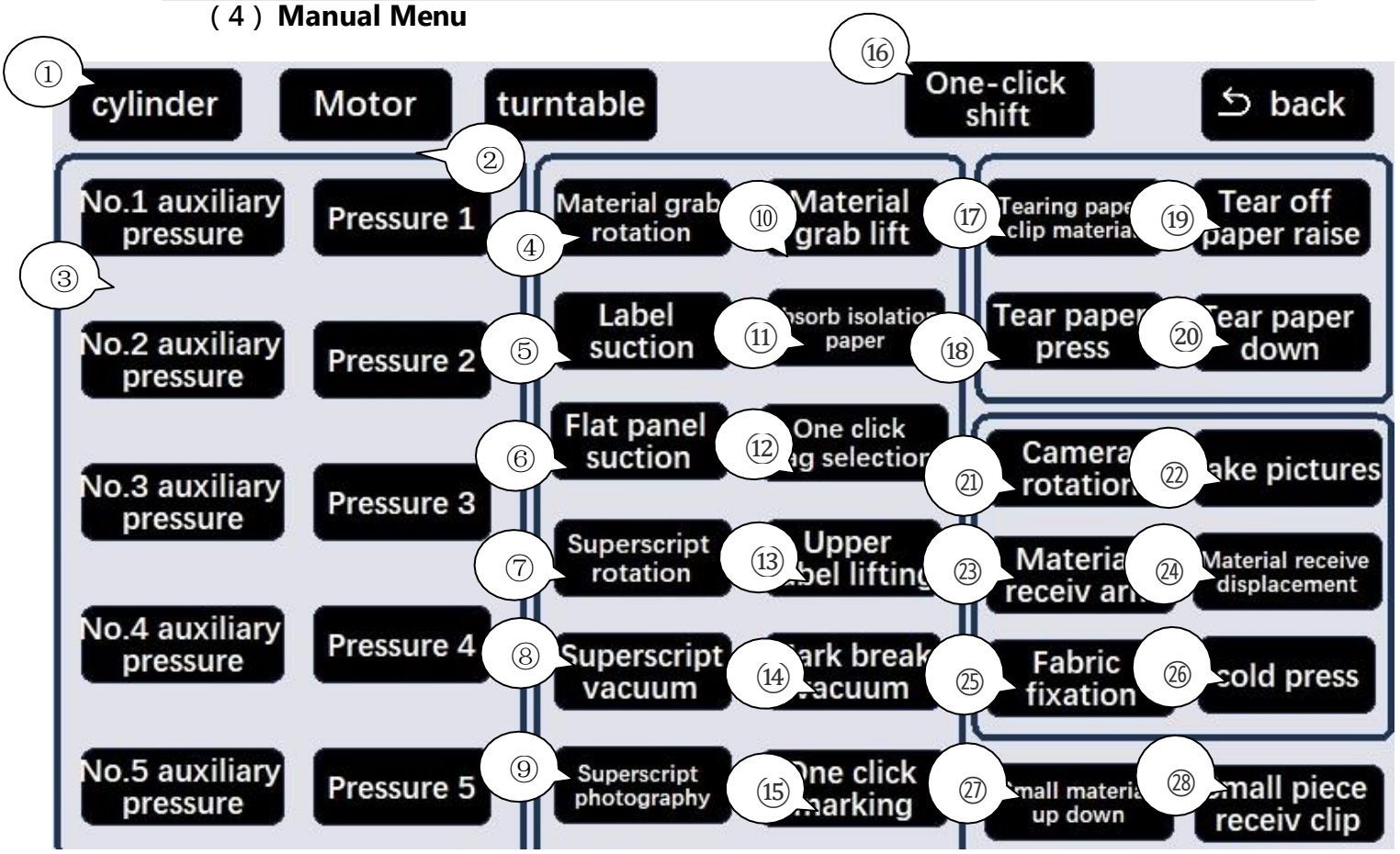
⑪ Create template： Press this key to enter the template making interface.

⑫ Lamp color selection： Press this key to enter the light color selection interface

（3） **Menu**

NO.	Name	Function	NO.	Name	Function
1	Manual Menu	Click this button to enter the manual control interface	5	Step	Click this button to enter the step-by-step action debugging screen
2	I/Ointerface	Click this button to enter the I/O input and output interface	6	setting	Click this button to enter the parameter setting interface
3	Alarm	Click this button to enter the alarm status interface	7	system	Click this button to enter the system parameter setting interface
4	Capacity	Click this button to enter the public production capacity data interface	8	Device	Click this button to view the technical service interface

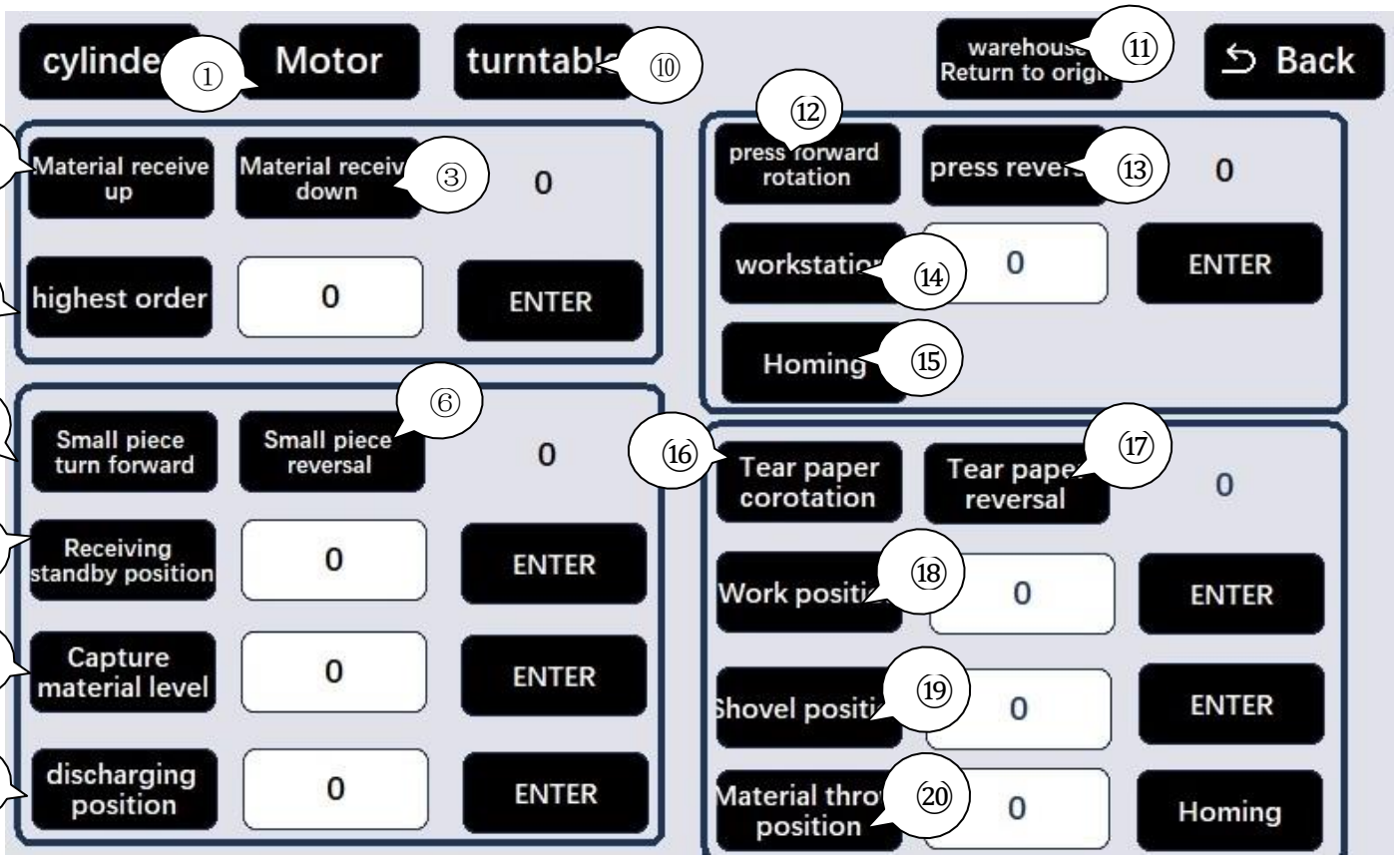
(4) Manual Menu

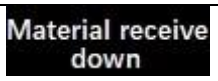
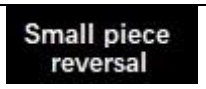
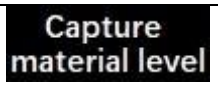
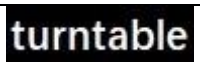
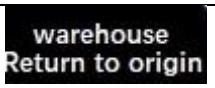
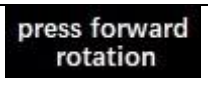


NO	Name	Function
①	cylinder	Press this key to enter the cylinder command interface (the figure above shows the cylinder interface).
②	Motor	Press this key to enter the motor command interface.
③	No.1-No5 Pressure1-5	Press this key to control the auxiliary pressing cylinder and the pressing cylinder of the corresponding station.
④	Material grab rotation	Press this key to control the rotation of the label pickup suction cup.
⑤	Label suction	Press this key to control the suction of the label pickup suction cup.
⑥	Flat panel suction	Press this key to control the suction at the center of the LED panel light.
⑦	Superscript rotation	Press this key to control the label suction

		rotation.
⑧	Superscript vacuum	Press this key to control the air blowing of the label pickup suction cup
⑨	Superscript photography	Press this key to control the camera to take pictures.
⑩	Material grab lift	Press this key to lift and lower the label picking cylinder.
⑪	Absorb isolation paper	Press this key to control the air blowing of the isolation paper suction cup.
⑫	One click tag selection	Press this key to control the label pickup cylinder to place the material onto the lamp panel.
⑬	Upper label lifting	Press this key to control the lifting of the labeling cylinder.
⑭	Mark break vacuum	Press this key to control the labeling suction cup.
⑮	One click marking	Press this key for the suction cup to feed the label.
⑯	One-click shift	Press this key to move to the previous station.
⑰	Tearing paper clip material	Press this key to control the clamping cylinder to release/clamp.
⑱	Tear paper press	Press this key to control the pressing cylinder for material pressing.
⑲	Tear off paper raise	Press this key to control the paper peeling cylinder to lift up.
⑳	Tear paper down	Press this key to control the paper peeling cylinder to descend.
㉑	Camera rotation	Press this button to control the rotation of the camera cylinder.

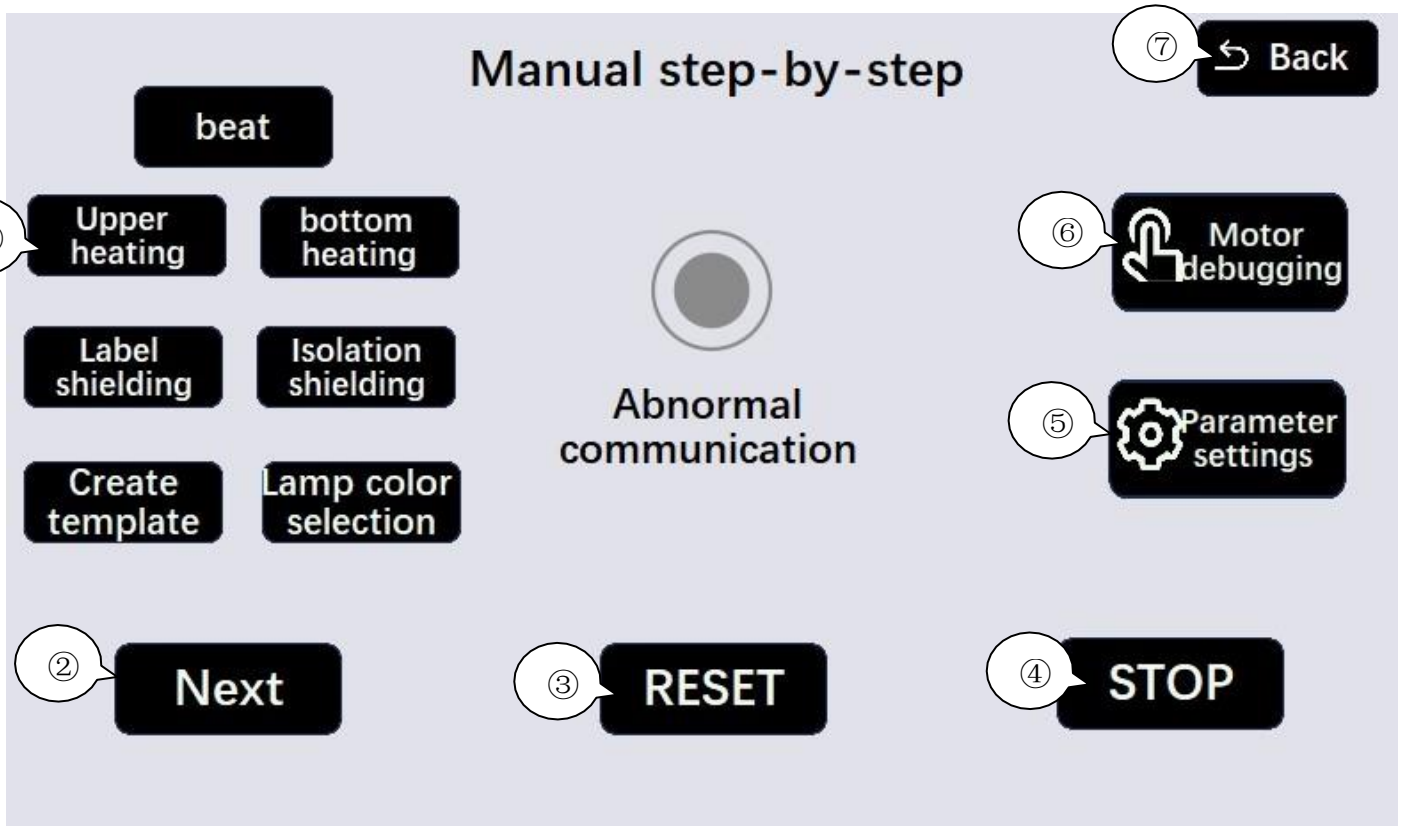
㉒	take pictures	Press this button to control the camera to take photos.
㉓	Material receiv arm	Press this button to control the retraction and extension of the material sweeping rod.
㉔	Material receive displacement	Press this button to control the forward and backward movement of the receiving platform.
㉕	Fabric fixation	Press this button to control the fabric fixation at the material receiving end.
㉖	cold press	Press this button to control the lifting and lowering of the cold press.
㉗	Small material up down	Press this button to control the lifting and lowering of the small part receiving unit.
㉘	Small piece receiv clip	Press this button to control the clamping and releasing of the small part receiving clip.


cylinde
①
Motor
turntabl
⑩
warehous
Return to origi
⑪
Back
⑫
press forward rotation
press rever
⑬
0
②
Material receive up
Material receiv down
③
0
workstatio
⑭
0
ENTER
④
highest order
0
ENTER
Homing
⑮
⑤
Small piece turn forward
Small piece reversal
⑥
0
⑯
Tear paper corotation
Tear pape reversal
⑰
0
⑦
Receiving standby position
0
ENTER
Work positi
⑱
0
ENTER
⑧
Capture material level
0
ENTER
Shovel positi
⑲
0
ENTER
⑨
discharging position
0
ENTER
Material thro position
⑳
0
Homing

NO	Name	Function
①		Press this button to enter the motor interface (the above image shows the motor interface).
②		Press this button to control the lifting of the receiving platform.
③		Press this button to control the lowering of the receiving platform.
④		Press this button to move the receiving platform to its highest position.
⑤		Press this button to control the forward rotation of the small part receiving motor.
⑥		Press this button to control the reverse rotation of the small part receiving motor.
⑦		Press this button to move the small part receiving unit to its standby position.
⑧		Press this button to move the small part receiving unit to the material gripping position.
⑨		Press this button to move the small part receiving unit to the material releasing position.
⑩		Press this button to enter the turntable interface.
⑪		Press this button to move the label bin module back to the origin position.
⑫		Press this button to control the forward rotation of the material pressing motor.

⑬	press reverse	Press this button to control the reverse rotation of the material pressing motor.
⑭	workstation	Press this button to move the material pressing motor to the working position.

（5）Manual step-by-step



NO	Name	Function
①	Upper heating bottom heating	Tap to select top/bottom heating
②	Next	Tap to proceed to the next step
③	RESET	Tap the reset button
④	STOP	Tap to stop the machine
⑤	Parameter settings	Tap to enter the parameter settings screen
⑥	Motor debugging	Tap to enter the motor debugging screen
⑦	Back	Tap to return to the previous page

（6）I/0


IO输入
>下一页
返回
X0
X1
X2 大盘电机原点
X3 收料电机原点
X4 撕纸电机原点
X5 标仓电机原点
X6 撕纸压料电机原点
X7 撕料升降原点
X10 急停
X11 冷压原点
X12 冷压旋转原点
X13 冷压旋转动作点
X14 启动信号1
X15 启动信号2
X16 收料光电
X17 相机旋转原点
X20 相机旋转动作点
X21 顶大盘原点
X22 取料原点
X23 取标真空
X24 取隔离纸真空
X25 取料旋转原点
X26 取料旋转动作点
X27 脚踏


IO输入
>上一页
>下一页
返回
X30 相机OK信号
X31 相机NG信号
X32 收料臂原点
X33 收料平台原点
X34 收料平台动作点
X35 收料布料固定动作点
X40 标仓反转


IO输入
>上一页
返回
X100 1号压料原点
X101 2号压料原点
X102 3号压料原点
X103 4号压料原点
X104 5号压料原点
X105 6号压料原点
X106 1号压料动作点
X107 2号压料动作点
X110 3号压料动作点
X111 4号压料动作点
X112 5号压料原点
X113 6号压料原点
X114 1号辅助压料原点
X115 2号辅助压料原点
X116 3号辅助压料原点
X117 4号辅助压料原点
X120 5号辅助压料原点
X121 6号辅助压料原点


IO输出
>下一页
返回
Y0 大盘电机PUL
Y1 收料电机PUL
Y2 撕纸旋转PUL
Y3 料仓电机PUL
Y4 撕纸压料PUL
Y5
Y6 冷压
Y7 冷压旋转
Y10 顶大盘
Y11 撕纸夹料
Y12 撕纸升降
Y13 取料旋转
Y14 相机旋转
Y15 相机拍照
Y16 取料升降
Y17 取标真空
Y20 取隔离纸真空
Y21 取标破真空
Y22 取隔离纸破真空
Y23 收料手臂
Y24 收料平台位移
Y25 收料布料固定
Y26 上方通气控制
Y27 撕纸压料

Note: Click this interface to view the I/O signals in the circuit, which is convenient for troubleshooting.

(This interface is the PLC signal monitoring screen. A lit indicator means the point has detected a signal; an unlit indicator means the point has not detected a signal.)

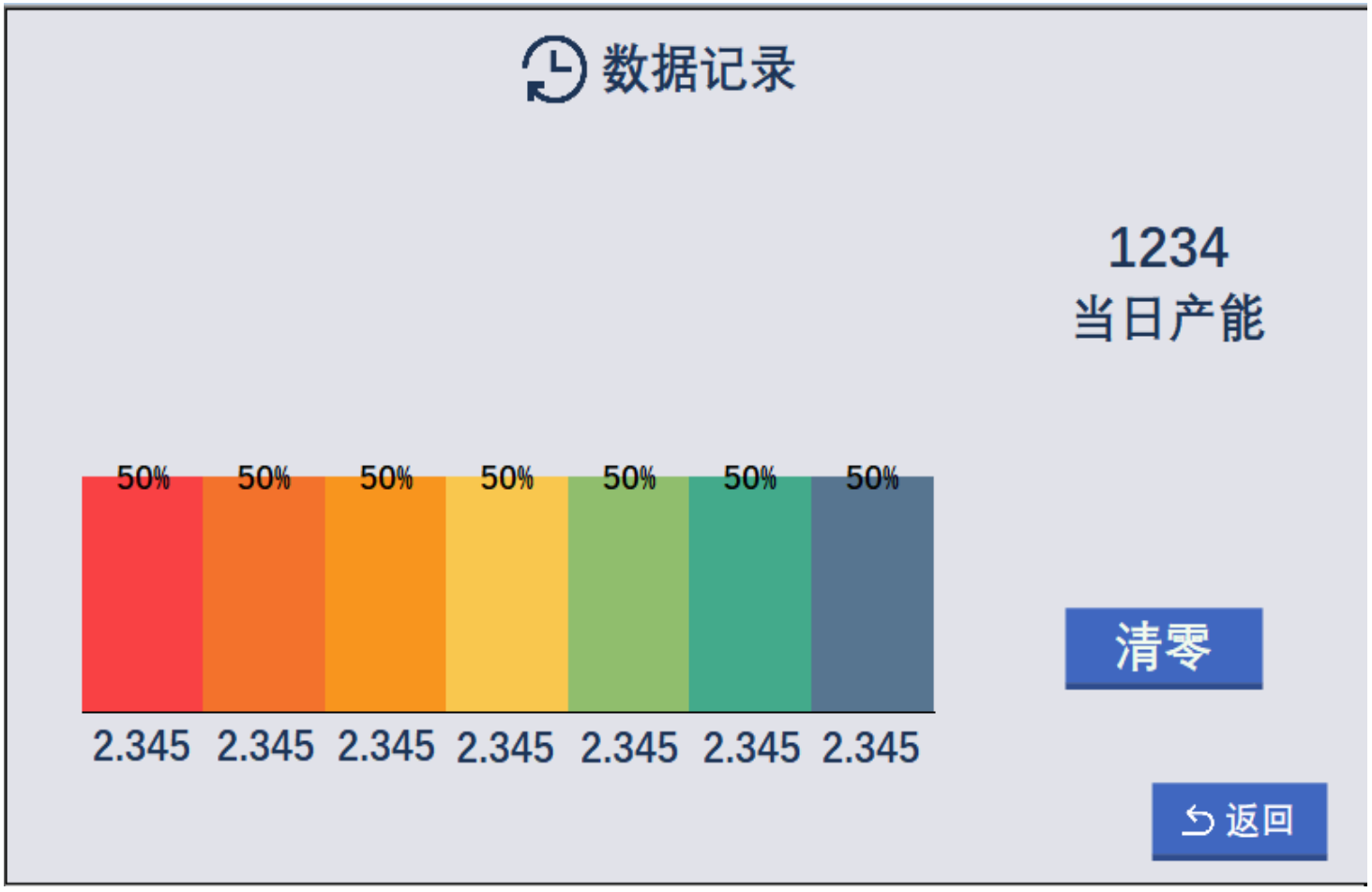
（7）**Alarm record**

Note: Troubleshoot according to the actual displayed alarm.

（8）**Technical service**

1. Scan the QR code to obtain the corresponding information
2. If the setting parameter changes cause the machine to not work normally, you can try to restore the factory Settings
3. Test mode: test before delivery

（9）**Capacity**



This interface allows you to view the daily or weekly production capacity

5. matters need attention

(1)  Do not open the maintenance cover plate during normal operation, so as not to cause personal accidents;

(2) Non-trained personnel shall not operate the equipment

(3) In order to prevent damage to the electrical parts of the machine, when lightning, please stop working and pull off the power head to ensure safety;

(4) Do not press the hand control button during the operation, so as not to scratch the palm of the steel wire expansion speed too fast;

(5) Put down the maintenance cover plate, please pay attention to the hand support, so as not to hurt the fingers or destroy the paint;

(6) Please read this manual carefully before the specific operation;

(7)  In order to prevent leakage accident, please be sure to ground ground;

(8)  In order to prevent electric shock accident, do not open the electric control box for any operation;

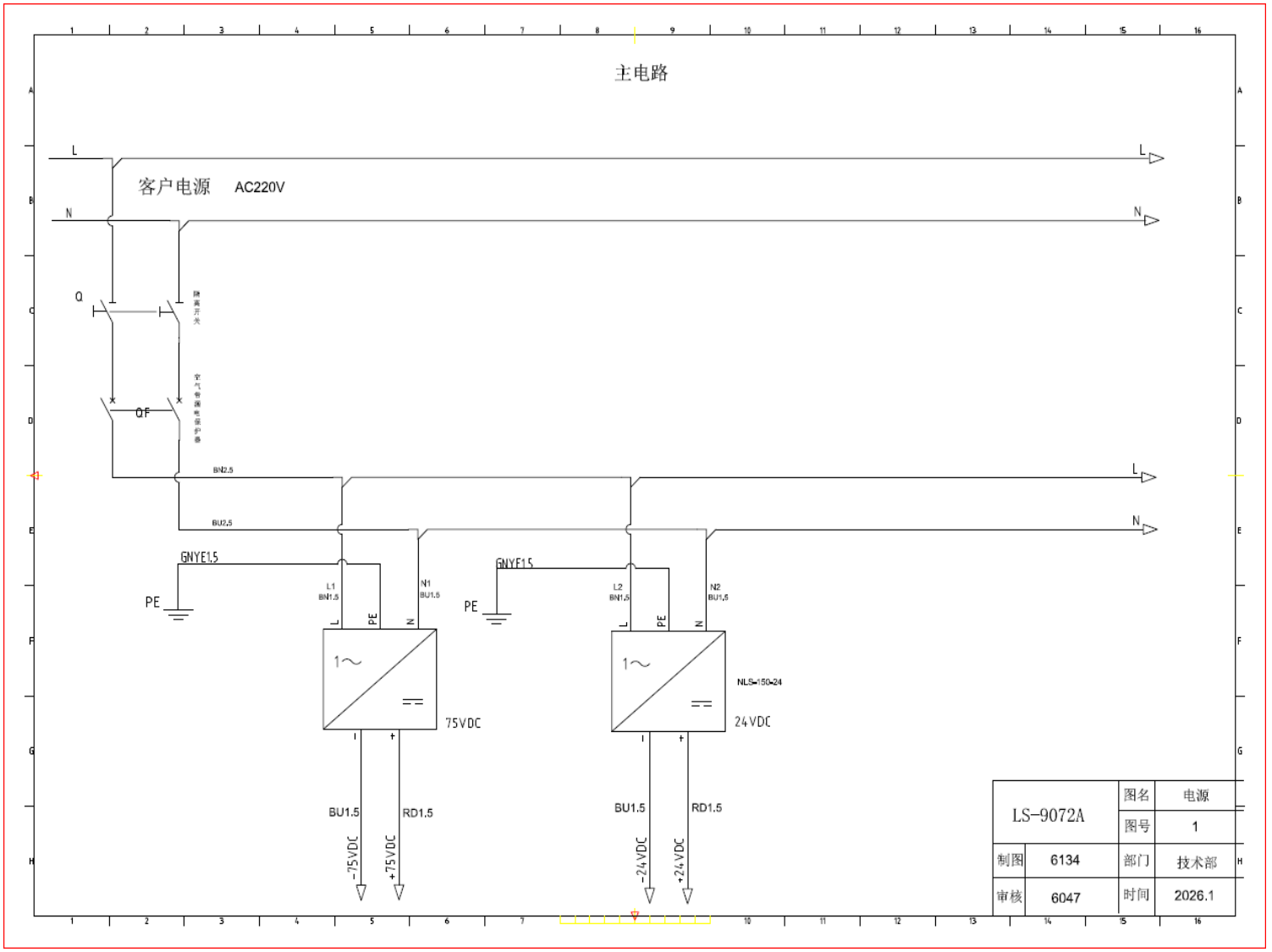
(9) In order to prevent personal accidents caused by mechanical operation, the equipment will automatically stop when the maintenance cover plate is opened.

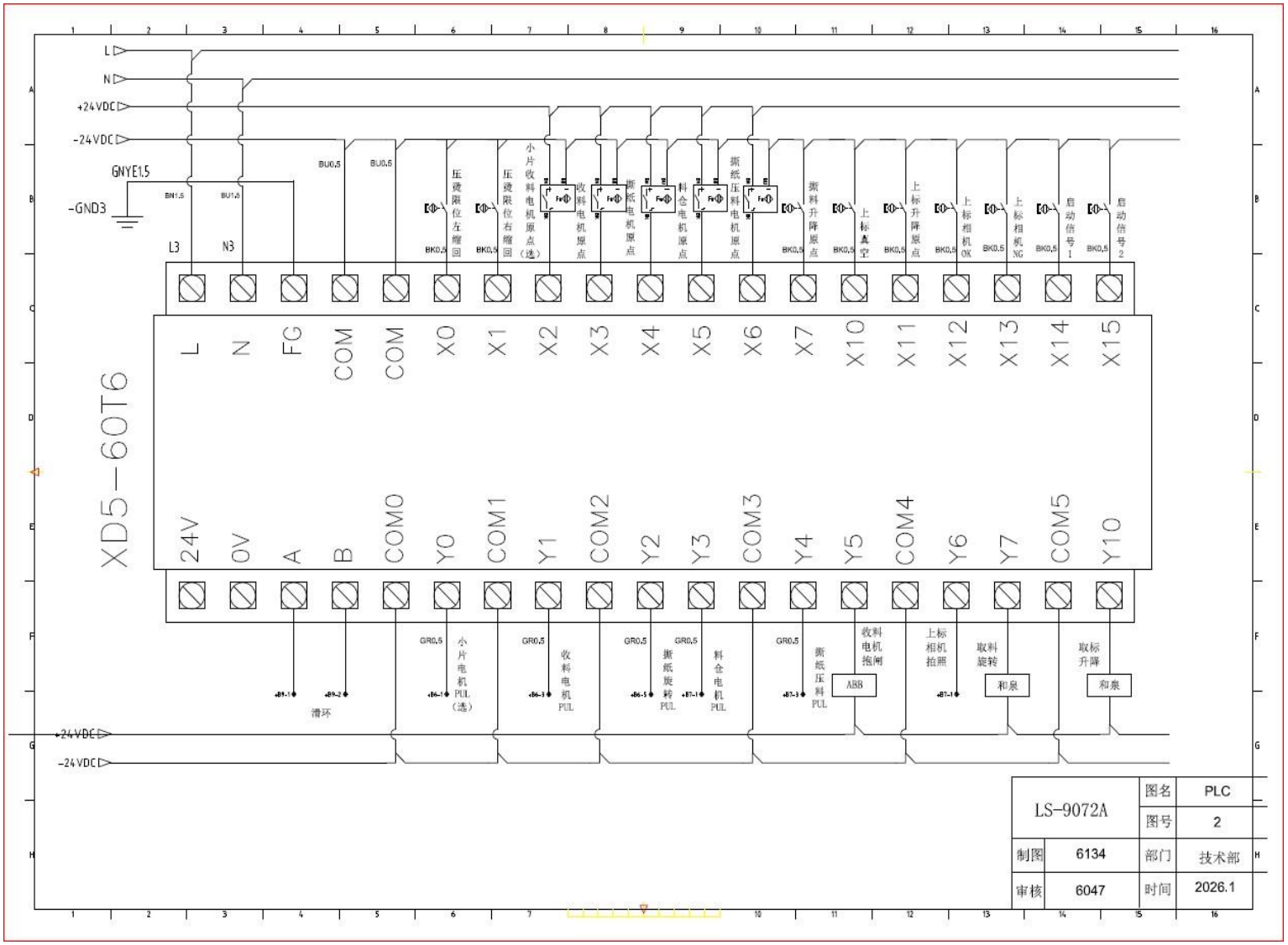
(10) Regularly refueling the air separator [1] with a refueling period of 3 months. The operation of opening the

air-liquid separator is to rotate the oil tank clockwise down while holding down the air-liquid separator button [2].

Note: the oil must use cylinder special oil, can not use sewing machine oil.

6. Circuit diagram





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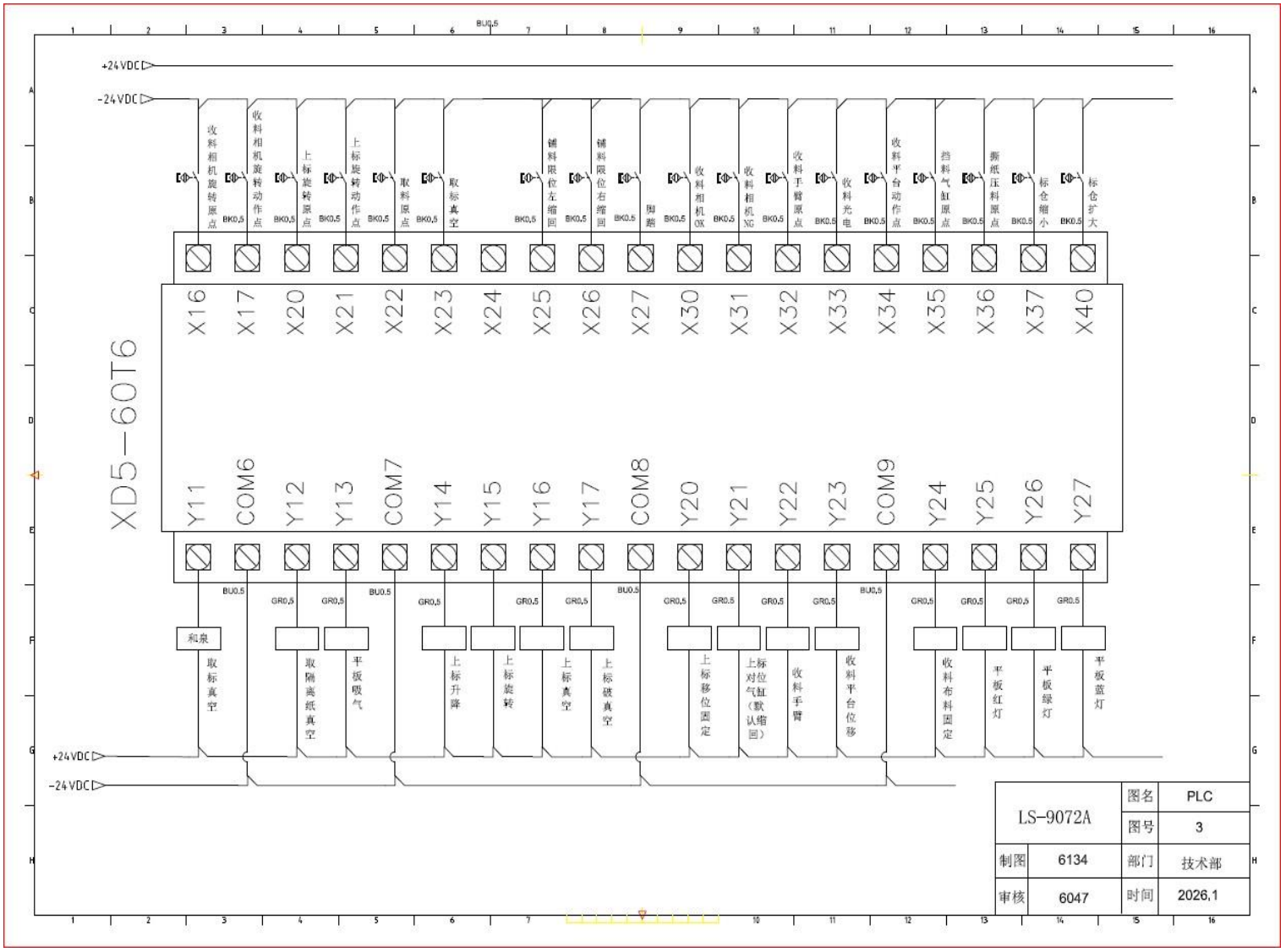
审核	6047	时间	2026.1



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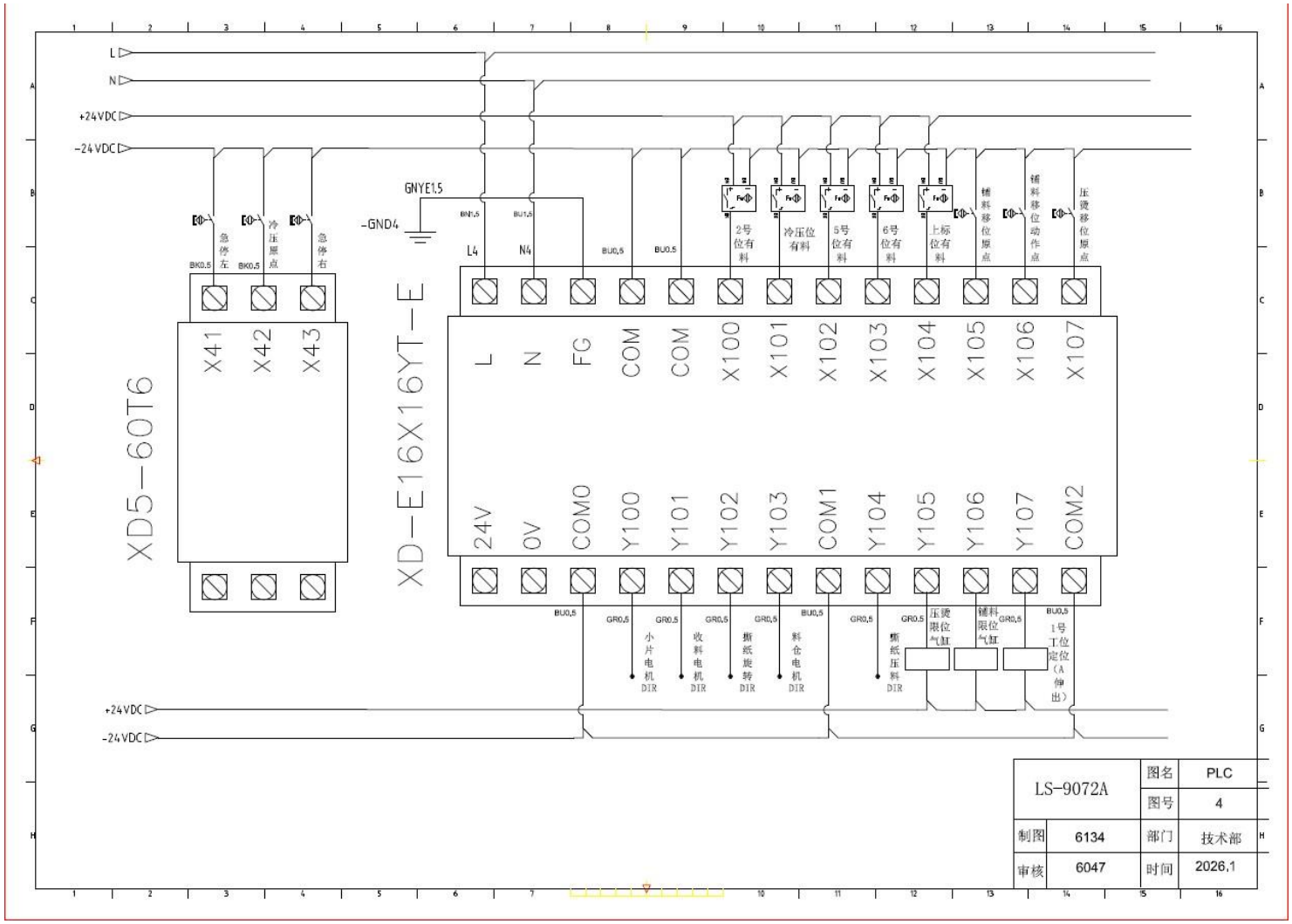
L
N
+24VDC
-24VDC
GNYE1.5
-GND4
XD5-60T6
X41
X42
X43
急停左
冷压原点
急停右
XD-E16X16YT-E
L4
N4
L
N
FG
COM
COM
X100
X101
X102
X103
X104
X105
X106
X107
24V
0V
COM0
Y100
Y101
Y102
Y103
COM1
Y104
Y105
Y106
Y107
COM2
2号位有料
冷压位有料
5号位有料
6号位有料
上标位有料
铺料移位原点
铺料移位动作点
压烫移位原点
小片电机DIR
收料电机DIR
撕纸旋转DIR
料仓电机DIR
撕纸压料DIR
压烫限位气缸
铺料限位气缸
1号工位定位（A伸出）
LS-9072A
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图号
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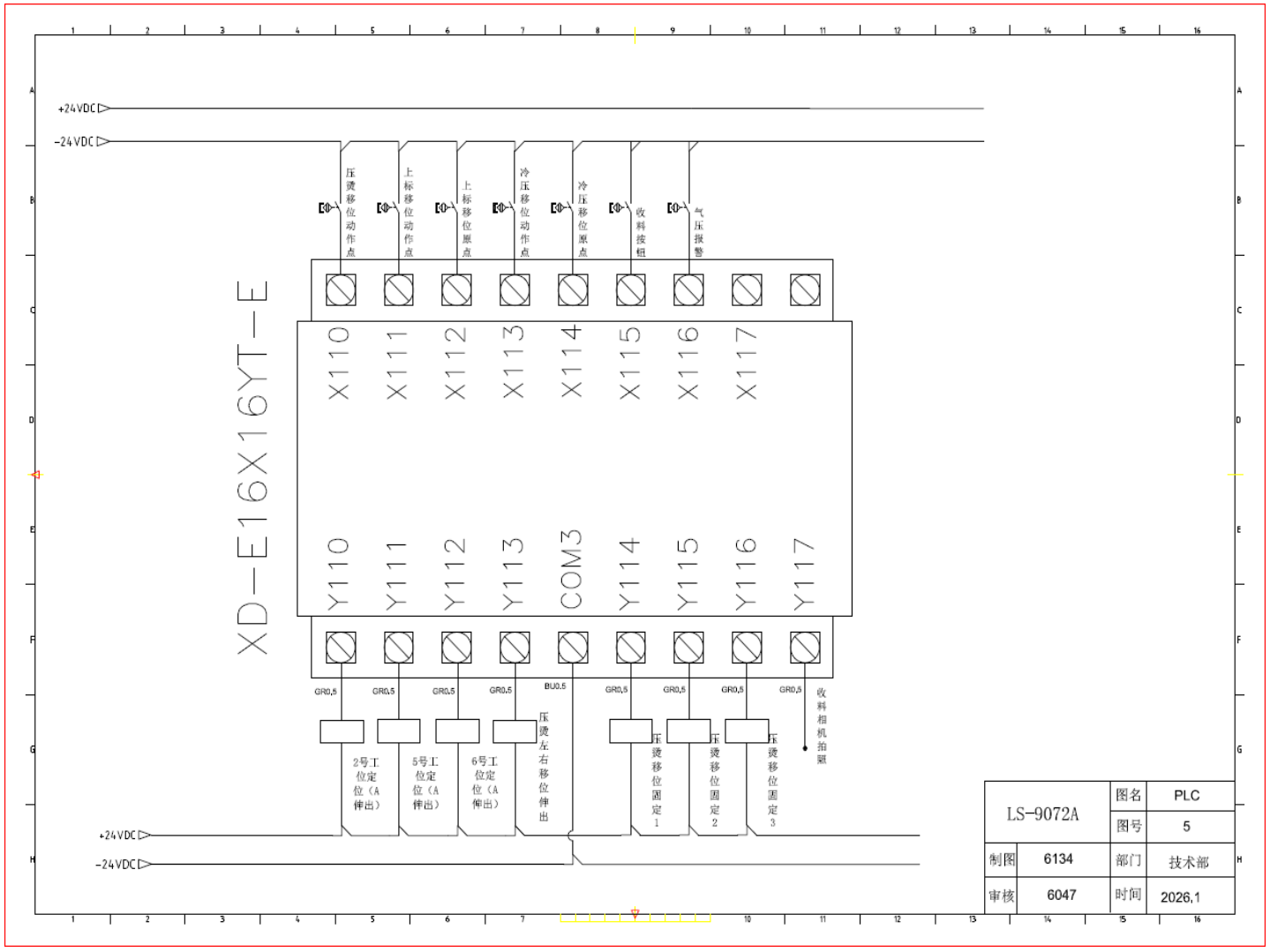
制图
6134
部门
技术部
审核
6047
时间
2026,1



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		图号	5
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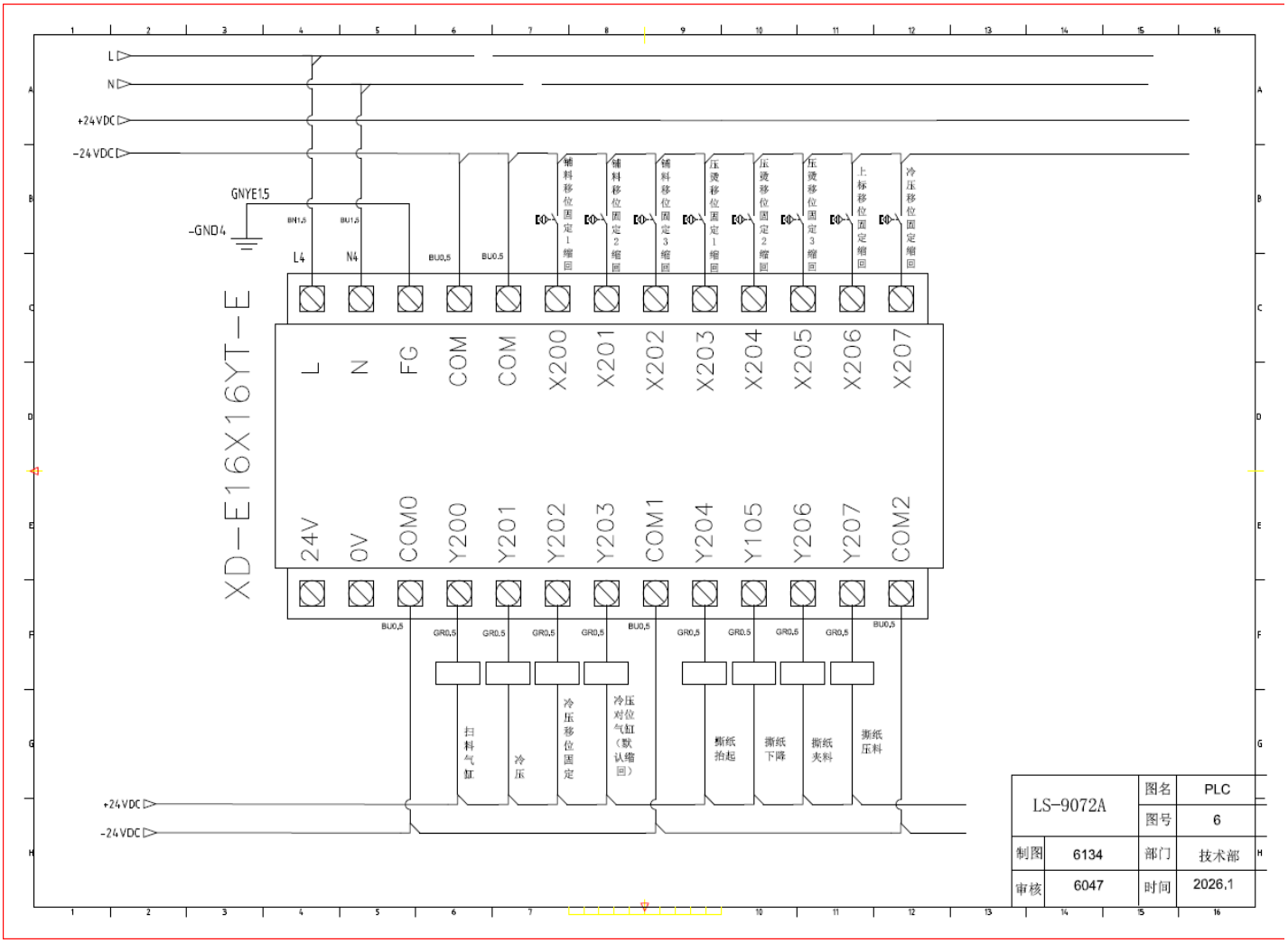
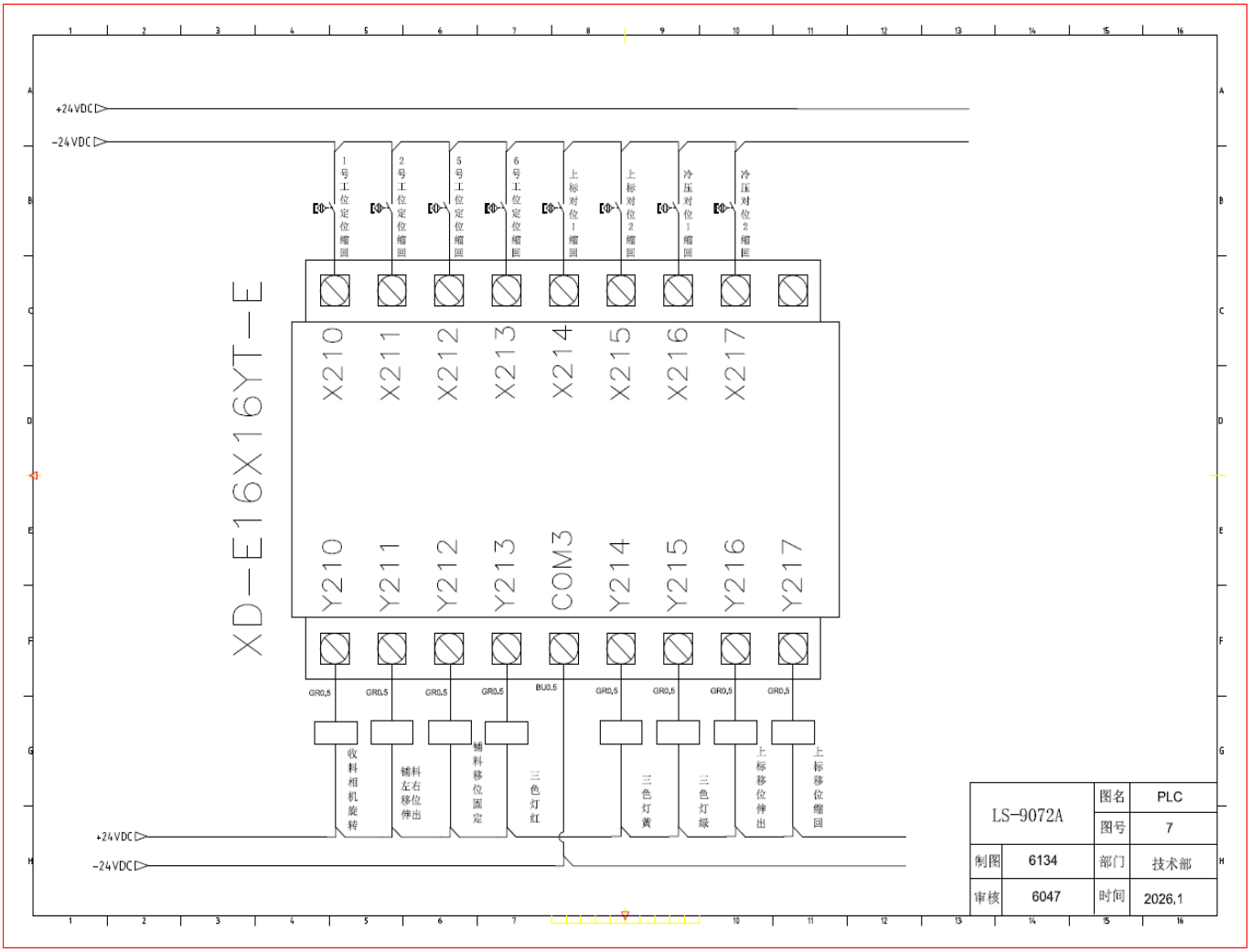
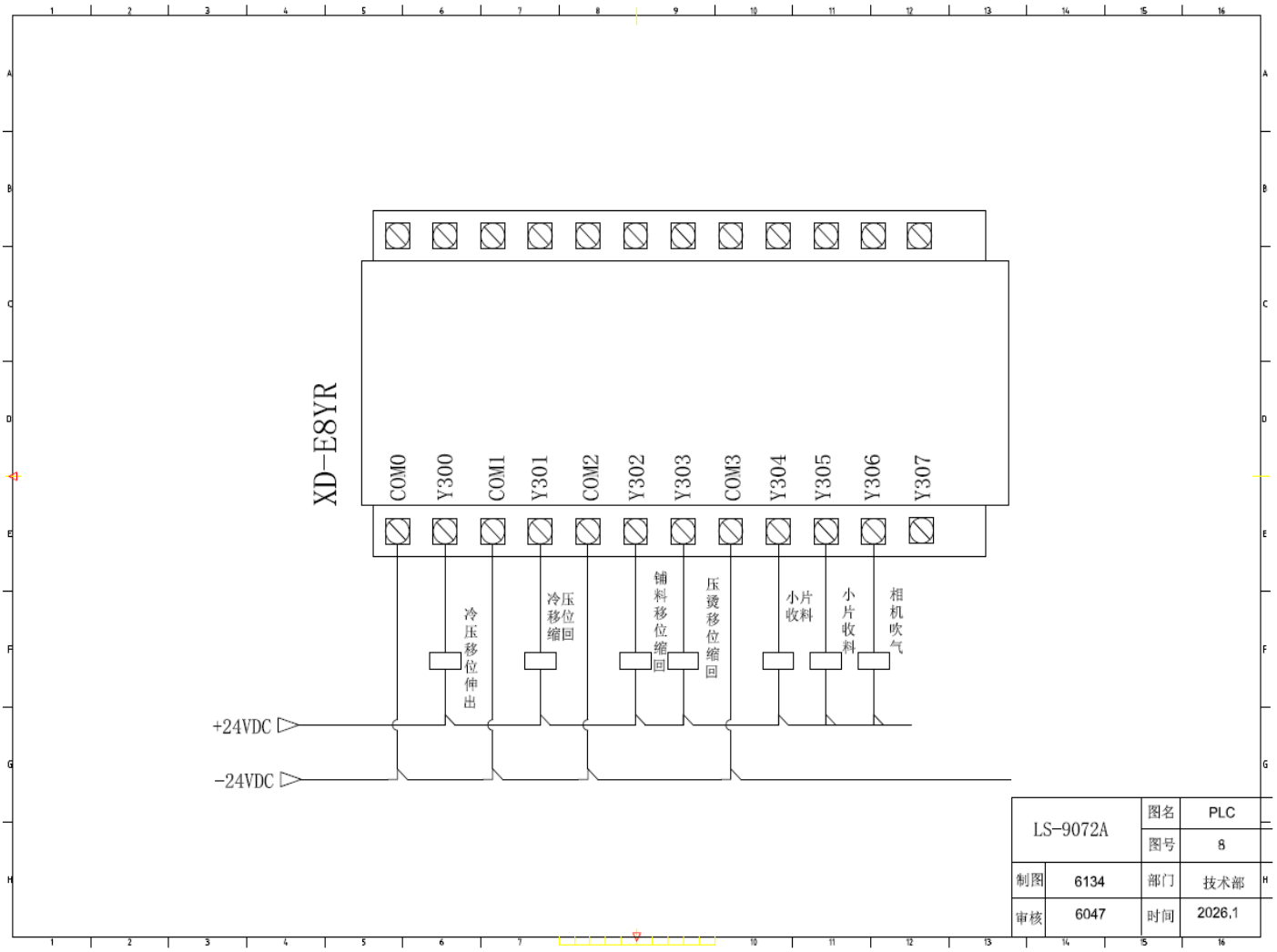
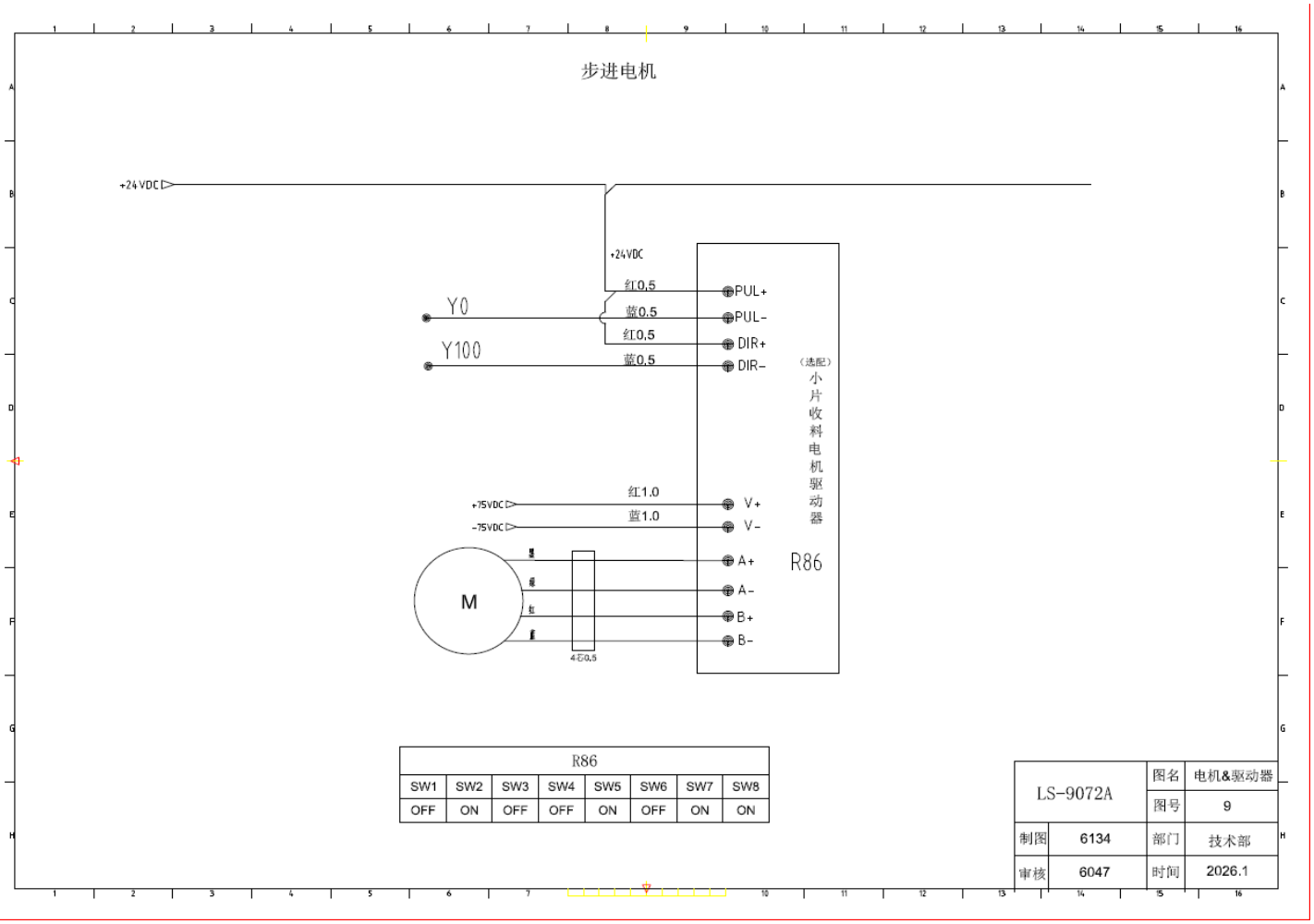

L
N
+24VDC
-24VDC
GNYE1.5
-GND4
BN1.5
BU1.5
L4
N4
BU0.5
BU0.5
辅料移位固定1缩回
辅料移位固定2缩回
辅料移位固定3缩回
压烫移位固定1缩回
压烫移位固定2缩回
压烫移位固定3缩回
上标移位固定缩回
冷压移位固定缩回
XD-E16X16YT-E
L
N
FG
COM
COM
X200
X201
X202
X203
X204
X205
X206
X207
24V
0V
COM0
Y200
Y201
Y202
Y203
COM1
Y204
Y105
Y206
Y207
COM2
BU0.5
GR0.5
GR0.5
GR0.5
GR0.5
BU0.5
GR0.5
GR0.5
GR0.5
GR0.5
BU0.5
扫料气缸
冷压
冷压移位固定
冷压对位气缸（默认缩回）
撕纸抬起
撕纸下降
撕纸夹料
撕纸压料
+24VDC
-24VDC
LS-9072A
图名
PLC
图号
6
制图
6134
部门
技术部
审核
6047
时间
2026.1


+24VDC
-24VDC
1号工位定位缩回
2号工位定位缩回
5号工位定位缩回
6号工位定位缩回
上标对位1缩回
上标对位2缩回
冷压对位1缩回
冷压对位2缩回
XD-E16X16YT-E
X210
X211
X212
X213
X214
X215
X216
X217
Y210
Y211
Y212
Y213
COM3
Y214
Y215
Y216
Y217
GR0.5
BU0.5
收料相机旋转
铺料左右位出
铺料移位固定
三色灯红
三色灯黄
三色灯绿
上标移位伸出
上标移位缩回
+24VDC
-24VDC
LS-9072A
图名
PLC
图号
7
制图
6134
部门
技术部
审核
6047
时间
2026.1

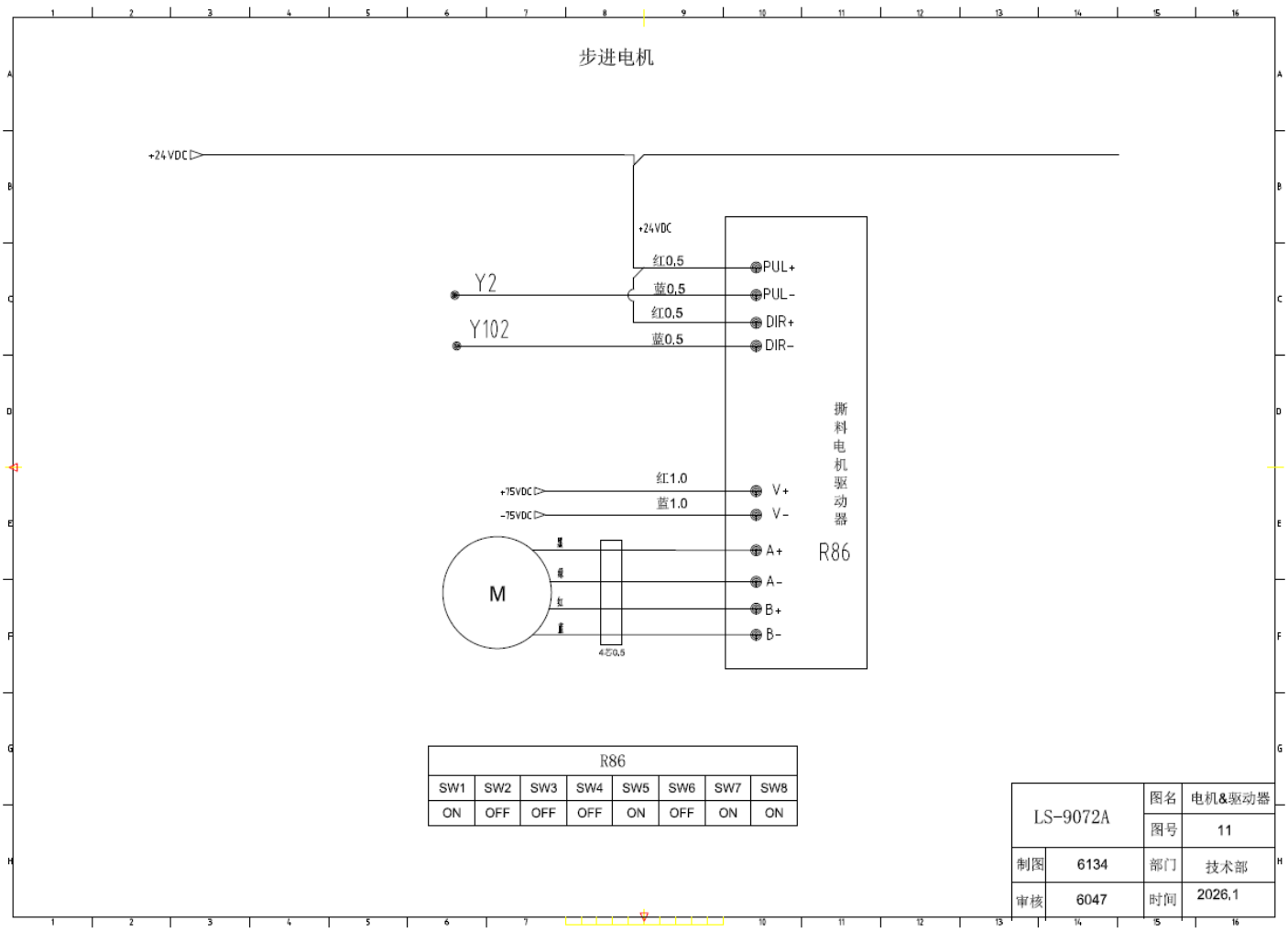


LS-9072A		图名	PLC
		图号	8
制图	6134	部门	技术部
审核	6047	时间	2026.1



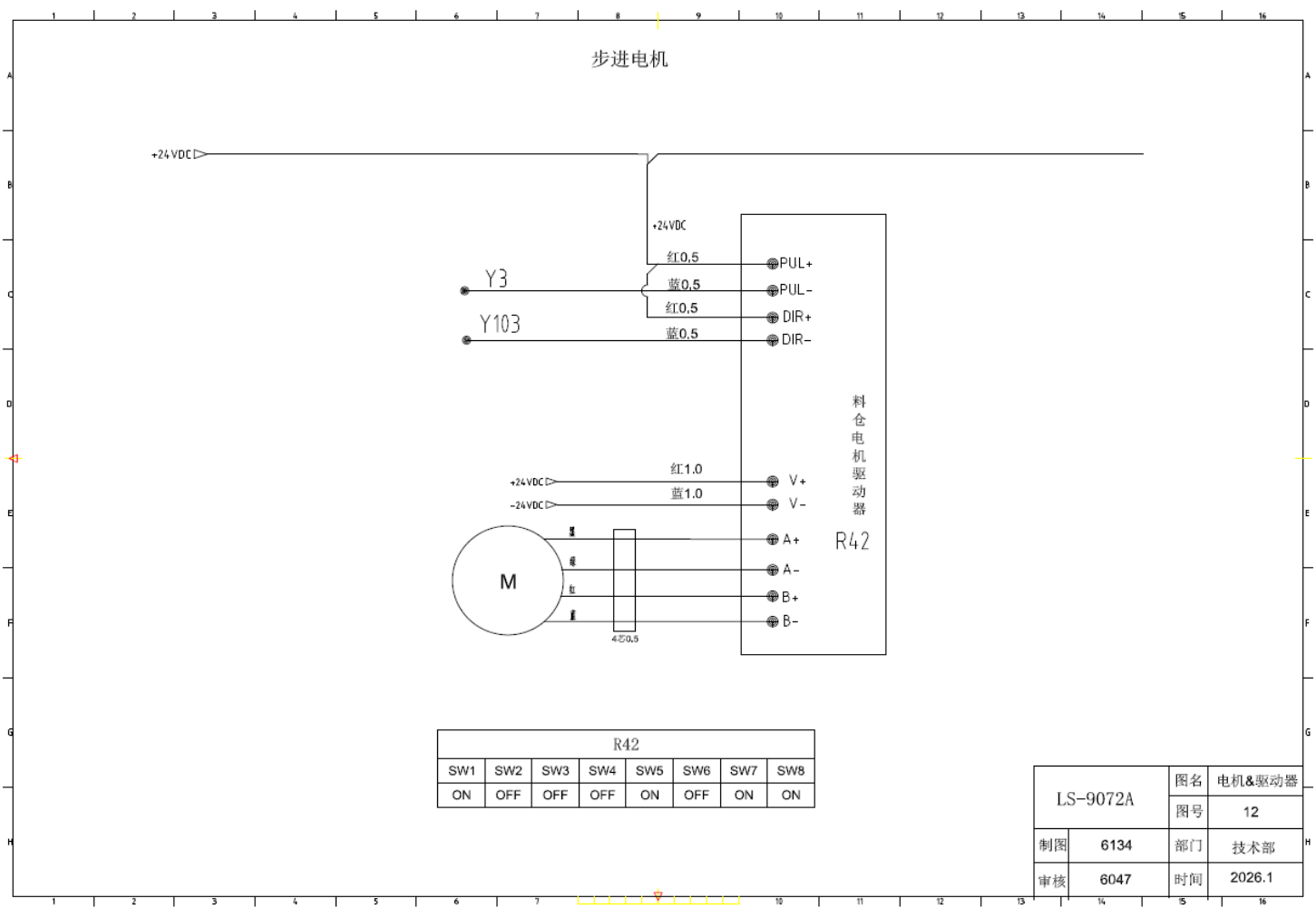
R86							
SW1	SW2	SW3	SW4	SW5	SW6	SW7	SW8
OFF	ON	OFF	OFF	ON	OFF	ON	ON

LS-9072A		图名	电机&驱动器
		图号	9
制图	6134	部门	技术部
审核	6047	时间	2026.1



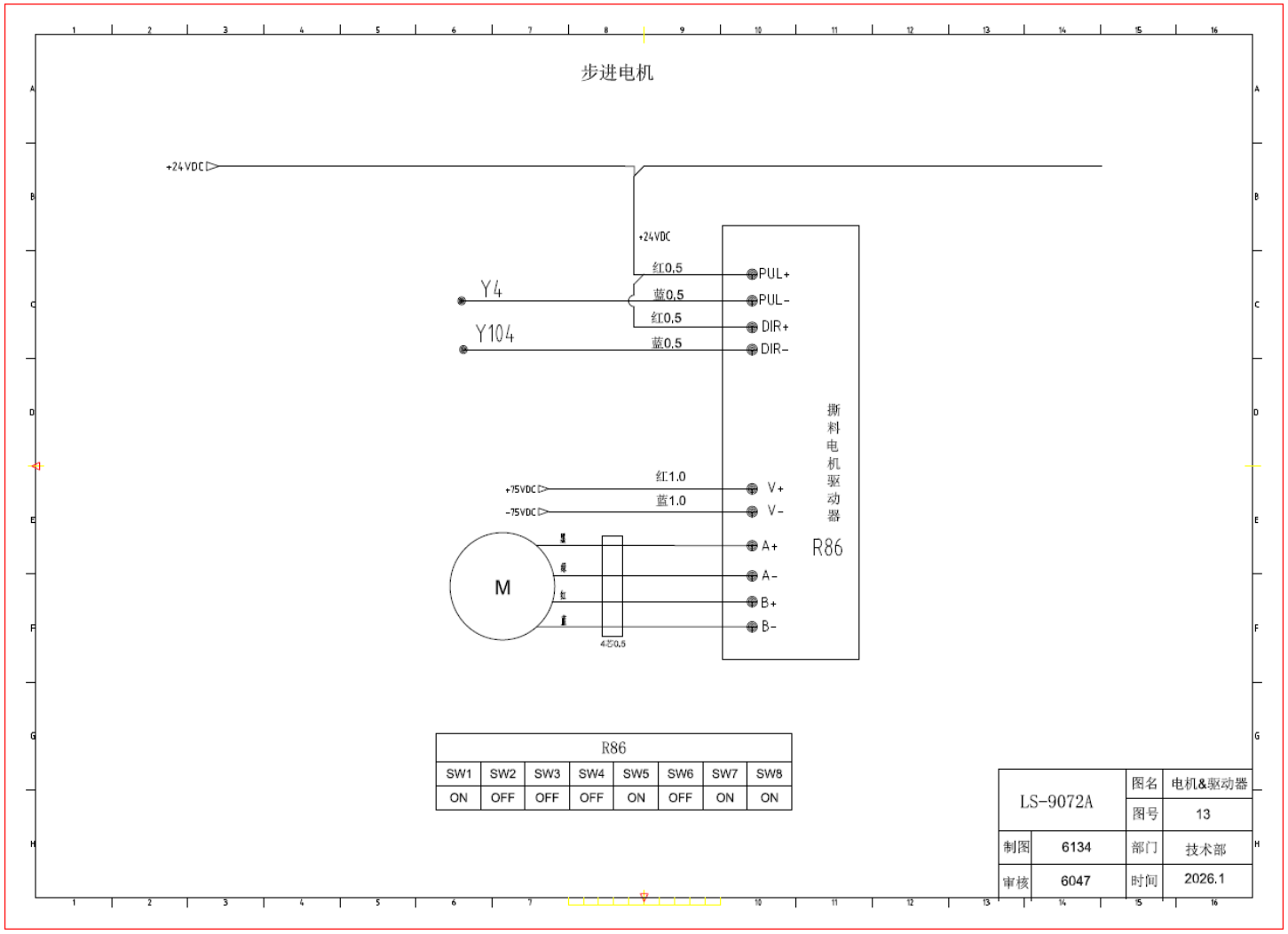
R86							
SW1	SW2	SW3	SW4	SW5	SW6	SW7	SW8
ON	OFF	OFF	OFF	ON	OFF	ON	ON

LS-9072A		图名	电机&驱动器
		图号	11
制图	6134	部门	技术部
审核	6047	时间	2026.1



R42							
SW1	SW2	SW3	SW4	SW5	SW6	SW7	SW8
ON	OFF	OFF	OFF	ON	OFF	ON	ON

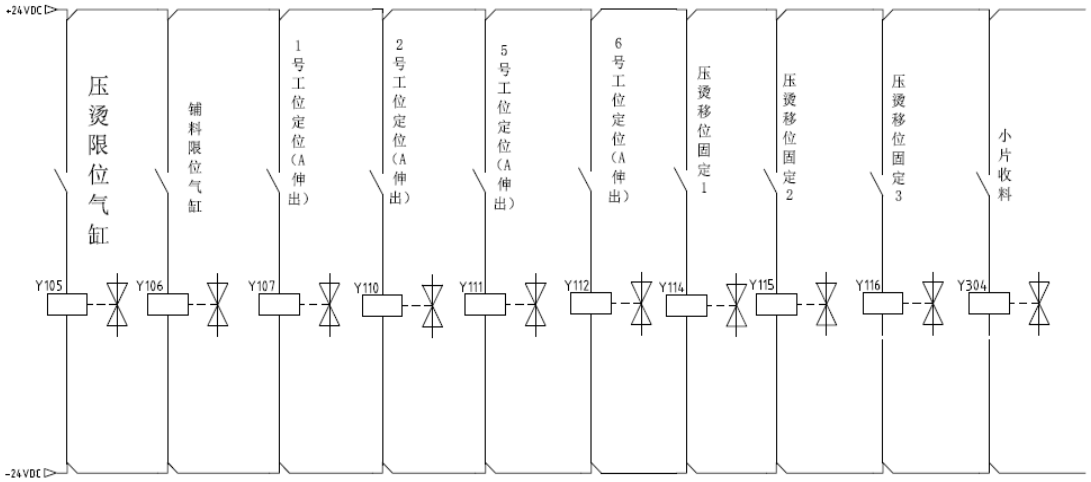
LS-9072A		图名	电机&驱动器
		图号	12
制图	6134	部门	技术部
审核	6047	时间	2026.1



R86							
SW1	SW2	SW3	SW4	SW5	SW6	SW7	SW8
ON	OFF	OFF	OFF	ON	OFF	ON	ON

LS-9072A		图名	电机&驱动器
		图号	13
制图	6134	部门	技术部
审核	6047	时间	2026.1

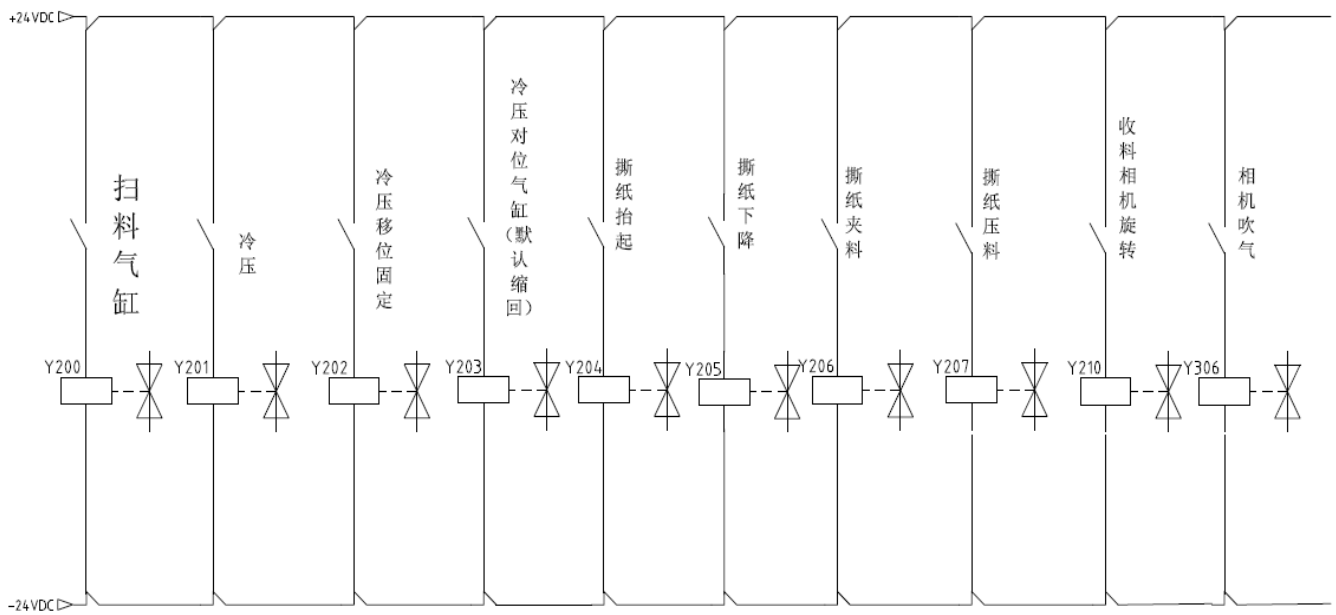
1号阀板



	Y105	Y106	Y107	Y110	Y111	Y112	Y114	Y115	Y116	Y304
A	堵头	堵头	6	6	6	6	6	6	6	4
B	4	4	6	6	6	6	6	6	6	4

LS-9072A		图名	继电器
		图号	14
制图	6134	部门	技术部
审核	6047	时间	2026.1

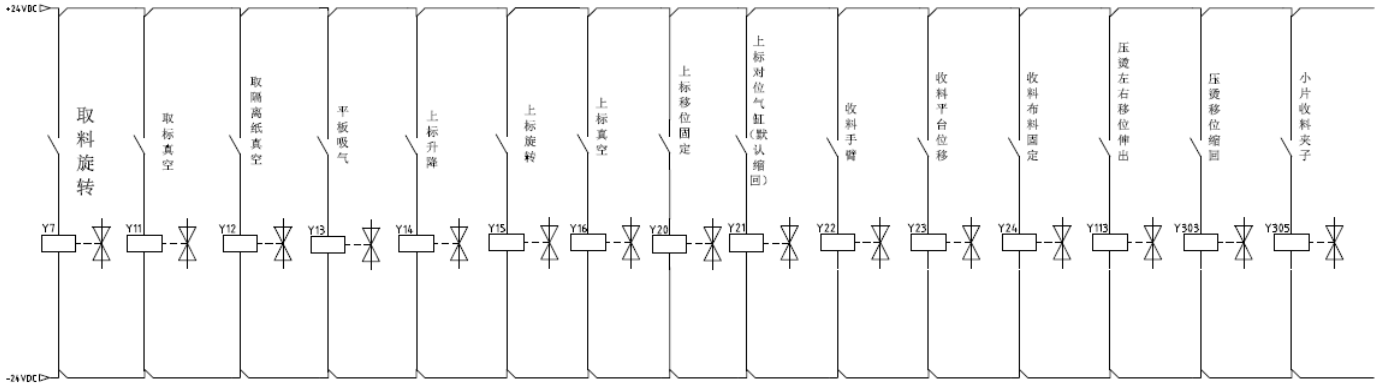
2号阀板



	Y200	Y201	Y202	Y203	Y204	Y205	Y206	Y207	Y210	Y306
A	4	6	6	6	4	堵头	4	4	6	堵头
B	4	6	6	6	堵头	4（过调压阀）	4	4	6	4

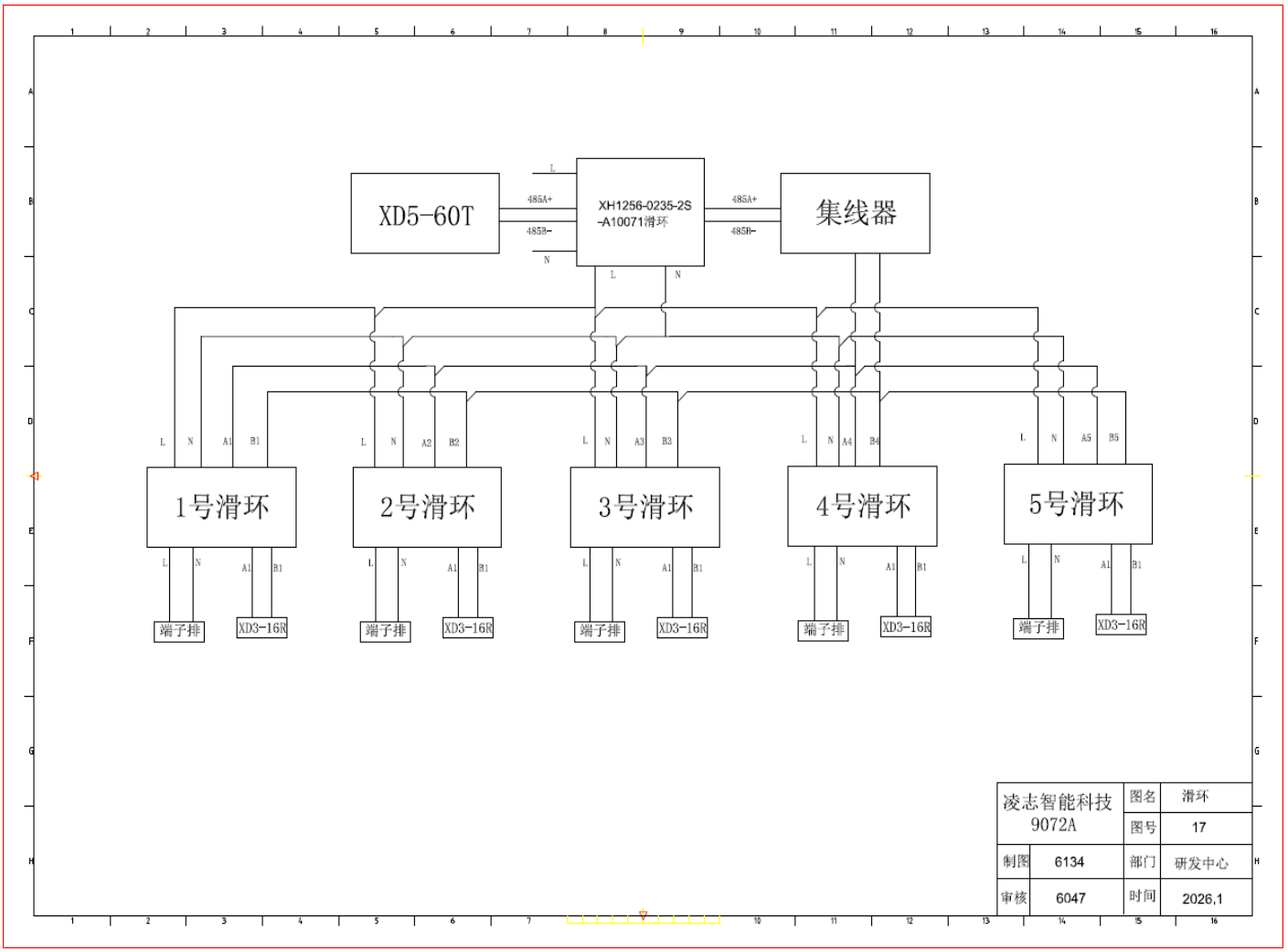
LS-9072A		图名	继电器
		图号	15
制图	6134	部门	技术部
审核	6047	时间	2026.1

3号阀板



	Y7	Y11	Y12	Y13	Y14	Y15	Y16	Y20	Y21	Y22	Y23	Y24	Y113	Y305
A	4	堵头	堵头	堵头	4	4	堵头	6	6	4	4	4	6	4
B	4	6	6	6	4	4	6	6	6	4	4	4	6	4
													Y303	

LS-9072A		图名	继电器
		图号	16
制图	6134	部门	技术部
审核	6047	时间	2026.1


XD5-60T
L
485A+
485B-
N
XH1256-0235-2S
-A10071滑环
485A+
485B-
集线器
L
N
L N A1 B1
1号滑环
L N A2 B2
2号滑环
L N A3 B3
3号滑环
L N A4 B4
4号滑环
L N A5 B5
5号滑环
L N A1 B1
端子排
XD3-16R
凌志智能科技
9072A
图名
滑环
图号
17
制图
6134
部门
研发中心
审核
6047
时间
2026.1

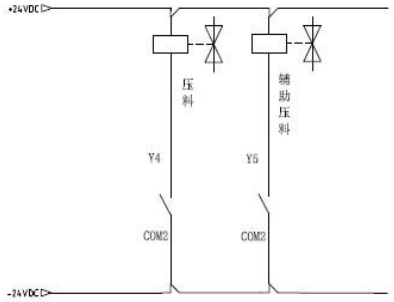
1号机XD3-16R		
PLC点位	使用号码管	注释
X0	M1000	1号压料原点
X1	M1001	1号压料动作点
X2	M1002	1号辅助压料原点
X3	M1003	1号在铺料位
X4	M1004	1号上加热温度报警
X5	M1005	1号下加热温度报警（选配）
Y0	M2000	1号上加热开关
Y2	M2002	1号下加热开关(选配)
Y4	M2004	1号压料
Y5	M2005	1号辅助压料
Y6	M2006	1号红灯
Y7	M2007	1号绿灯

2号机XD3-16R		
PLC点位	使用号码管	注释
X0	M1010	2号压料原点
X1	M1011	2号压料动作点
X2	M1012	2号辅助压料原点
X3	M1013	2号在铺料位
X4	M1014	2号上加热温度报警
X5	M1015	2号下加热温度报警（选配）
Y0	M2010	2号上加热开关
Y2	M2012	2号下加热开关(选配)
Y4	M2014	2号压料
Y5	M2015	2号辅助压料
Y6	M2016	2号红灯
Y7	M2017	2号绿灯

3号机XD3-16R		
PLC点位	使用号码管	注释
X0	M1020	3号压料原点
X1	M1021	3号压料动作点
X2	M1022	3号辅助压料原点
X3	M1023	3号在铺料位
X4	M1024	3号上加热温度报警
X5	M1025	3号下加热温度报警（选配）
Y0	M2020	3号上加热开关
Y2	M2022	3号下加热开关(选配)
Y4	M2024	3号压料
Y5	M2025	3号辅助压料
Y6	M2026	3号红灯
Y7	M2027	3号绿灯

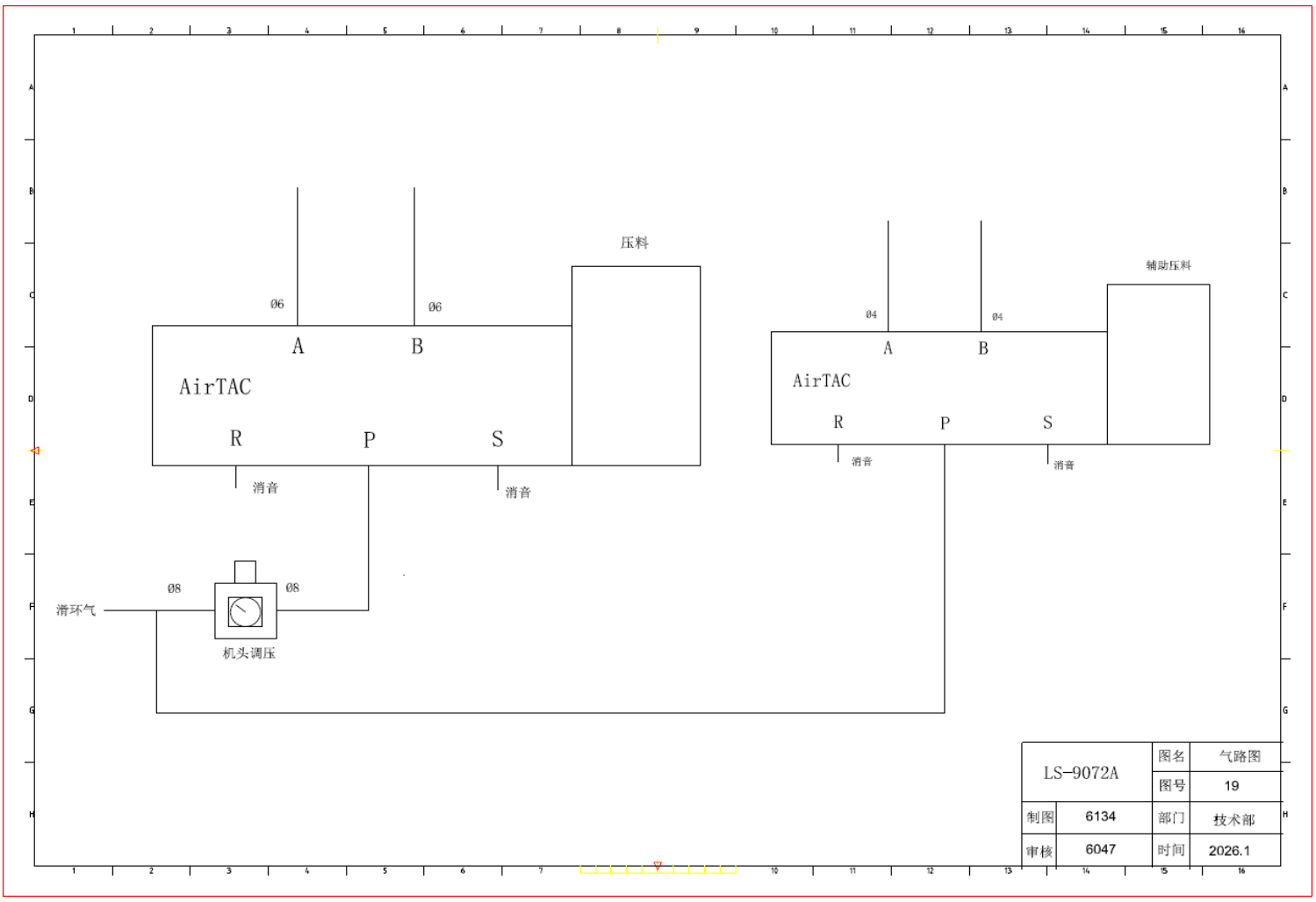
4号机XD3-16R		
PLC点位	使用号码管	注释
X0	M1030	4号压料原点
X1	M1031	4号压料动作点
X2	M1032	4号辅助压料原点
X3	M1033	4号在铺料位
X4	M1034	4号上加热温度报警
X5	M1035	4号下加热温度报警（选配）
Y0	M2030	4号上加热开关
Y2	M2032	4号下加热开关(选配)
Y4	M2034	4号压料
Y5	M2035	4号辅助压料
Y6	M2036	4号红灯
Y7	M2037	4号绿灯

5号机XD3-16R		
PLC点位	使用号码管	注释
X0	M1040	5号压料原点
X1	M1041	5号压料动作点
X2	M1042	5号辅助压料原点
X3	M1043	5号在铺料位
X4	M1044	5号上加热温度报警
X5	M1045	5号下加热温度报警（选配）
Y0	M2040	5号上加热开关
Y2	M2042	5号下加热开关(选配)
Y4	M2044	5号压料
Y5	M2045	5号辅助压料
Y6	M2046	5号红灯
Y7	M2047	5号绿灯

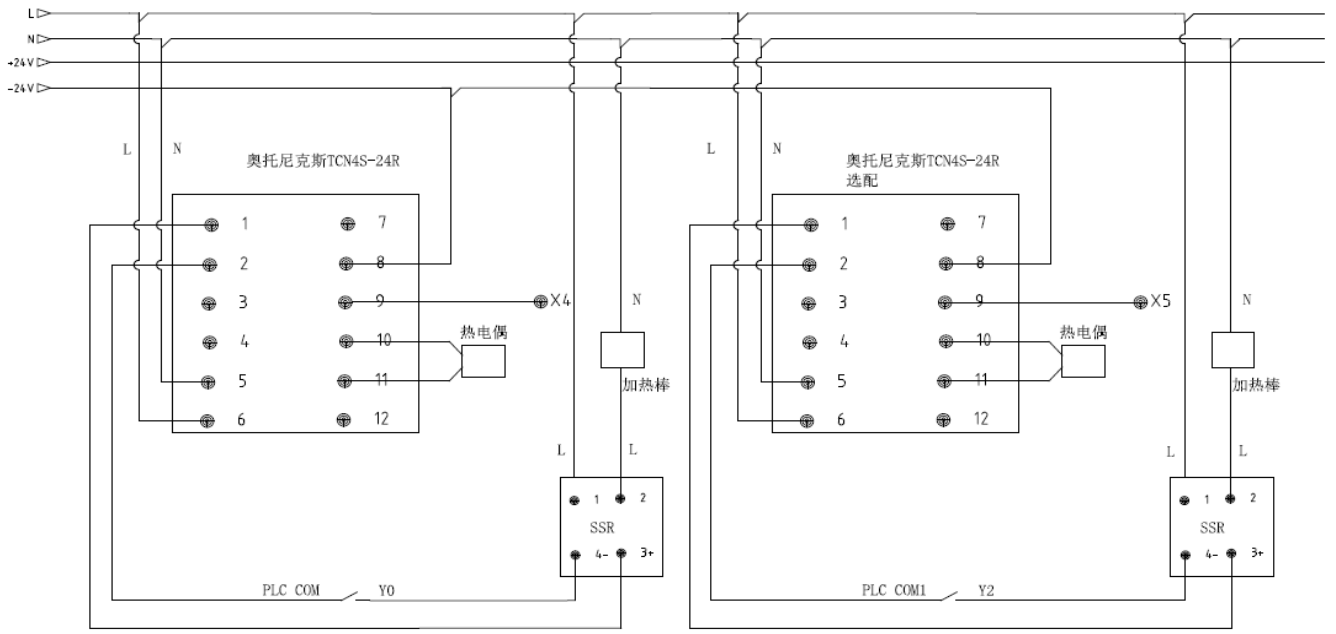


B	B	4
A	6	4

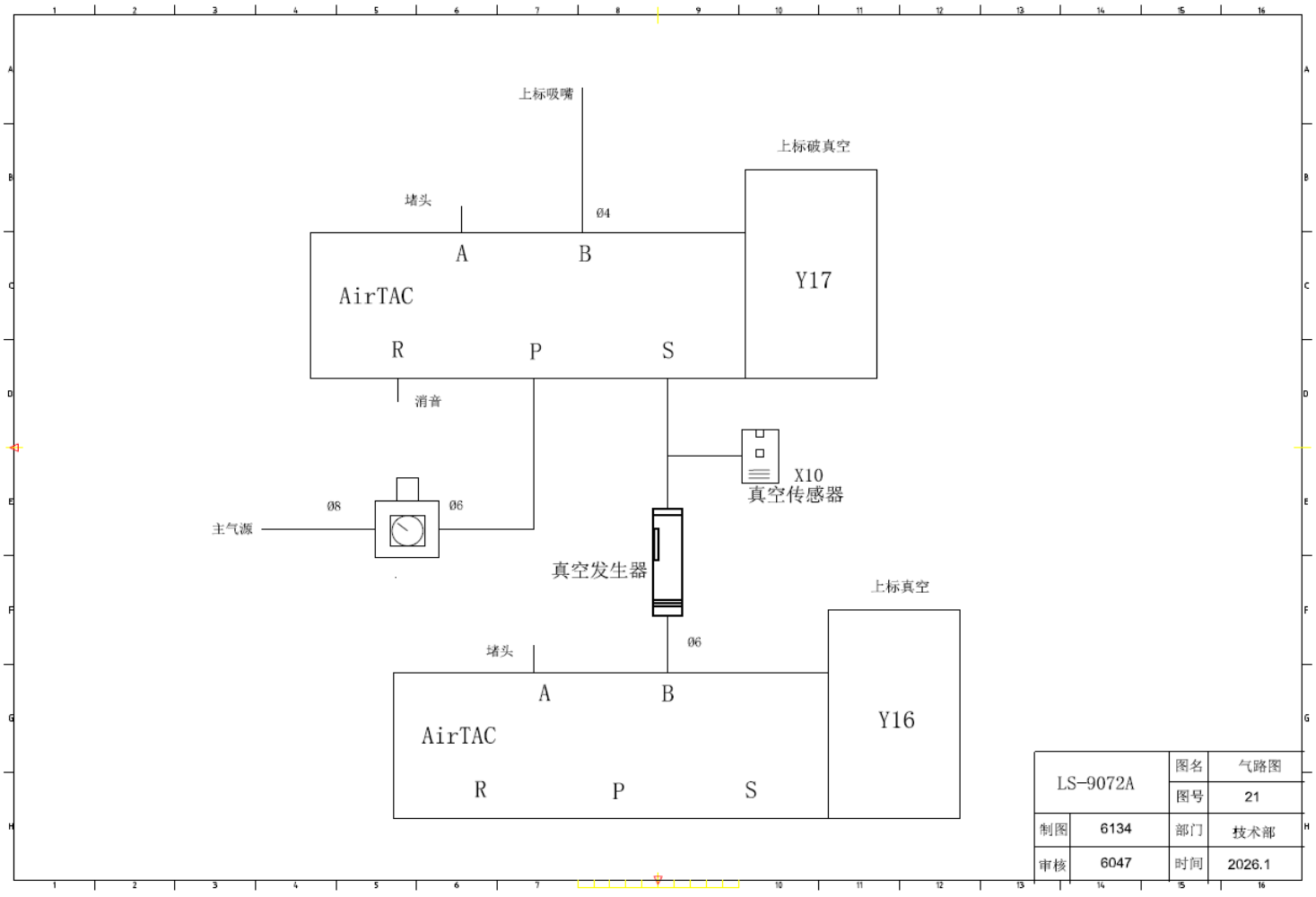
凌志智能科技 9072A		图名	机台PLC
		图号	18
制图	6134	部门	研发中心
审核	6047	时间	2026.2


压料
Ø6
Ø6
A
B
AirTAC
R
P
S
消音
消音
辅助压料
Ø4
Ø4
A
B
AirTAC
R
P
S
消音
消音
Ø8
Ø8
滑环气
机头调压
LS-9072A
图名
气路图
图号
19
制图
6134
部门
技术部
审核
6047
时间
2026.1

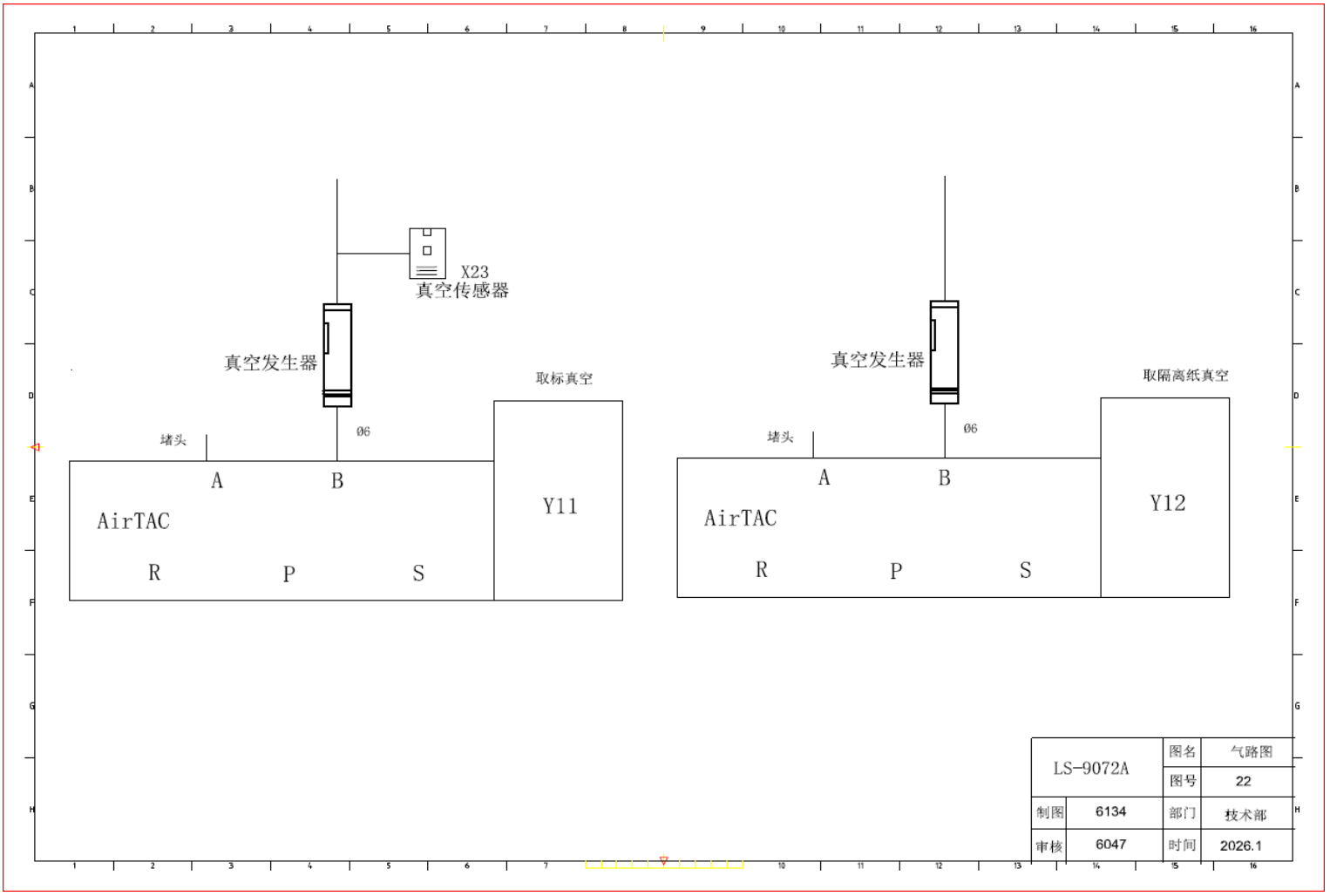
温控器



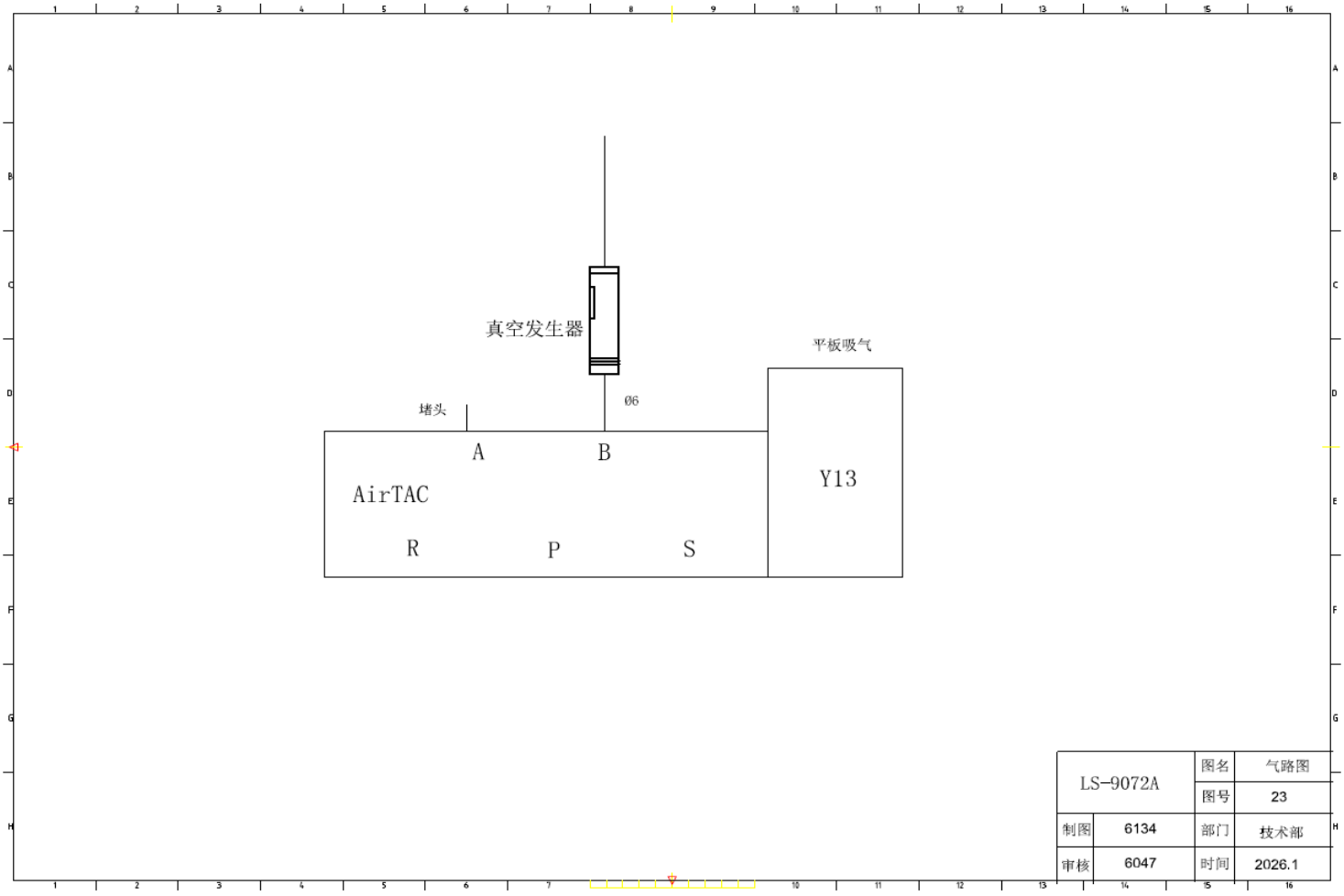
LS-9072A		图名	温控器
		图号	20
制图	6134	部门	技术部
审核	6047	时间	2026.1



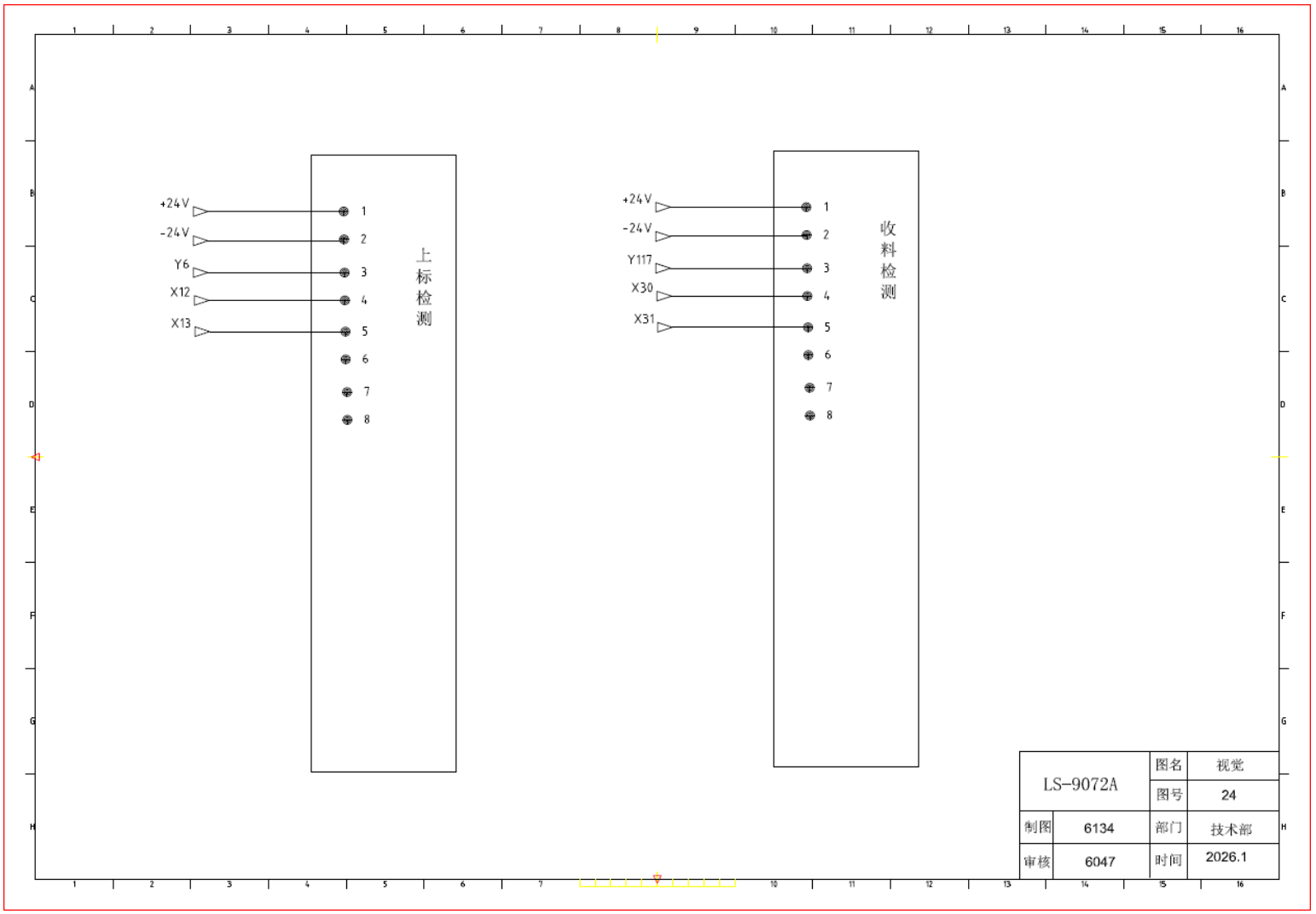
LS-9072A		图名	气路图
		图号	21
制图	6134	部门	技术部
审核	6047	时间	2026.1



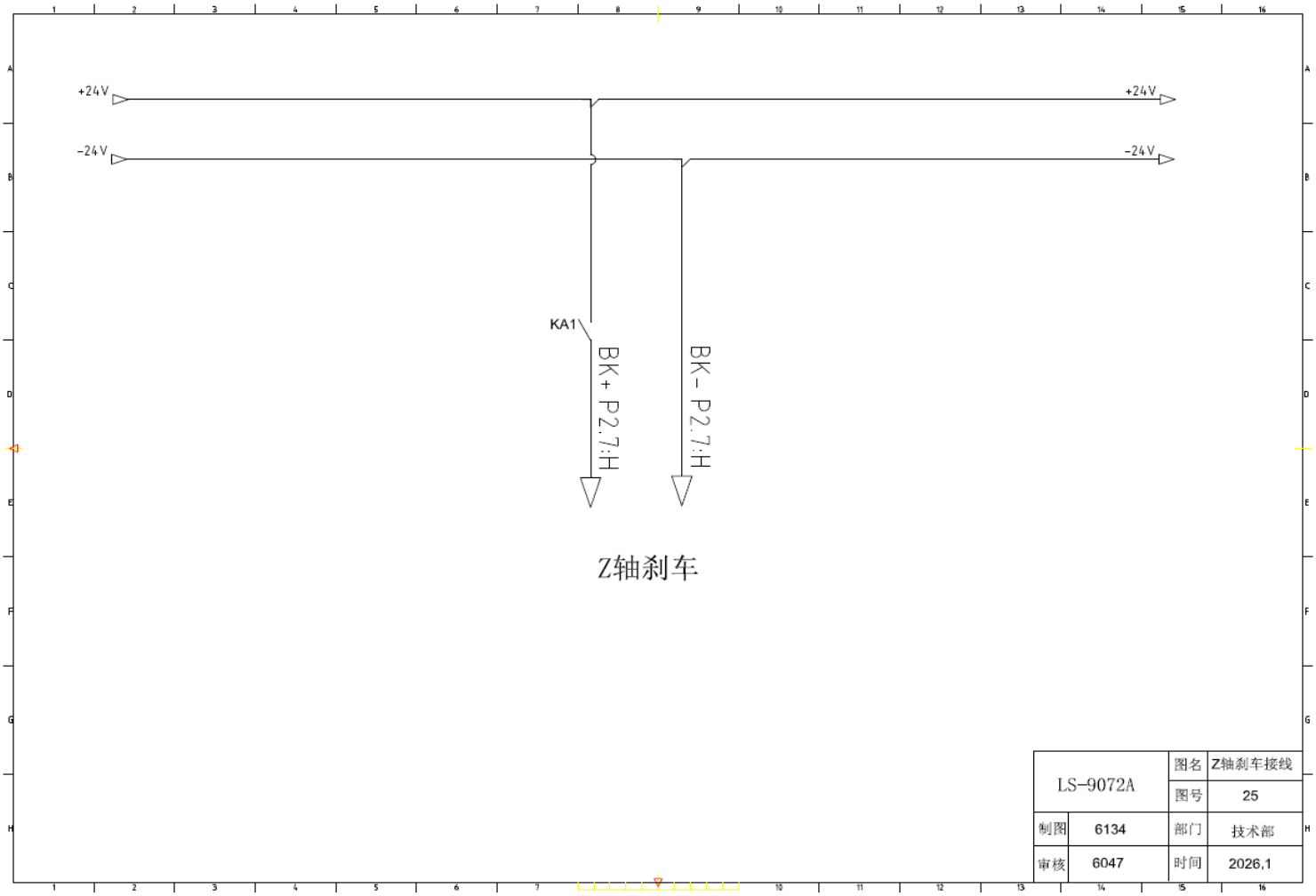
LS-9072A		图名	气路图
		图号	22
制图	6134	部门	技术部
审核	6047	时间	2026.1



LS-9072A		图名	气路图
		图号	23
制图	6134	部门	技术部
审核	6047	时间	2026.1

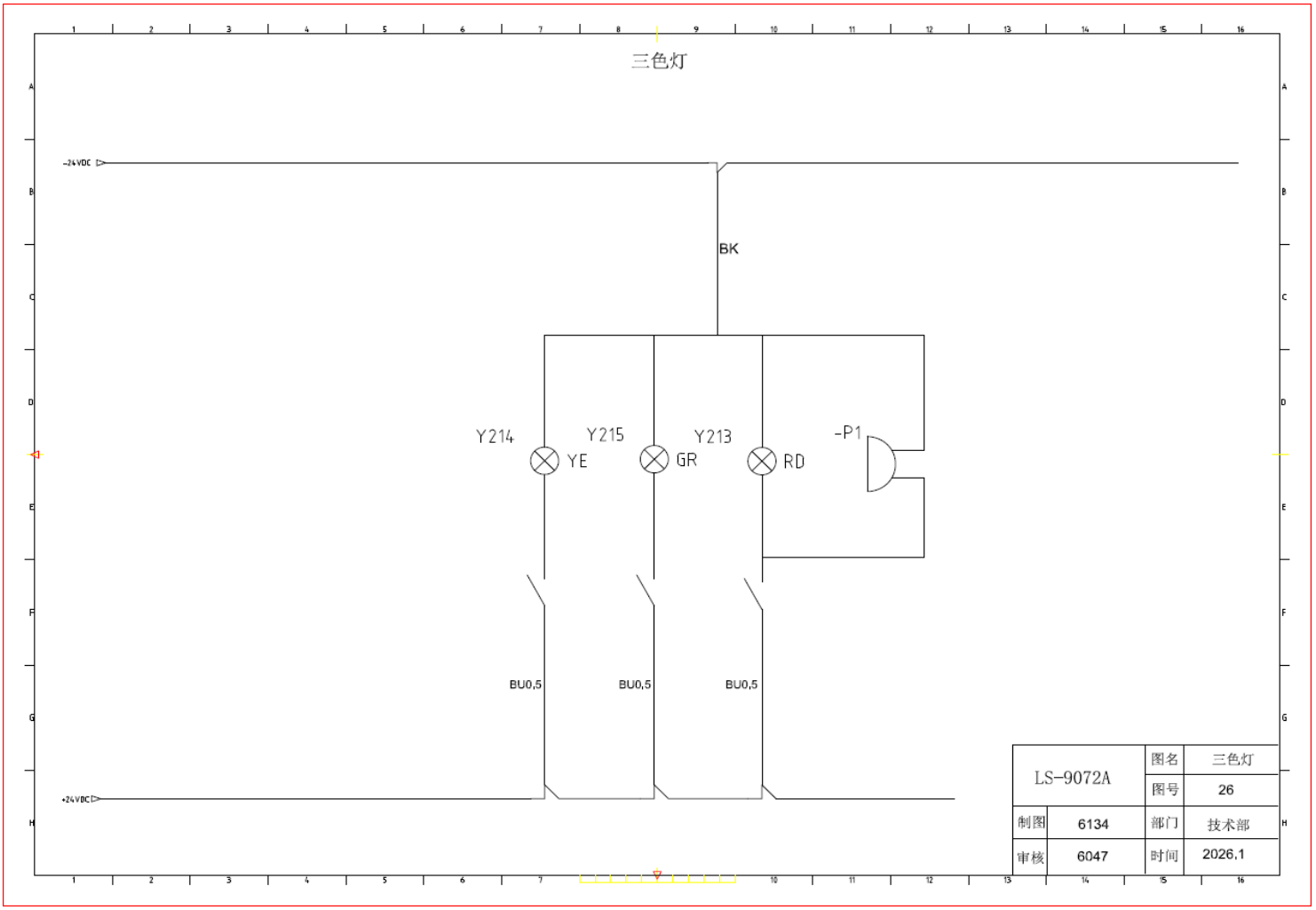


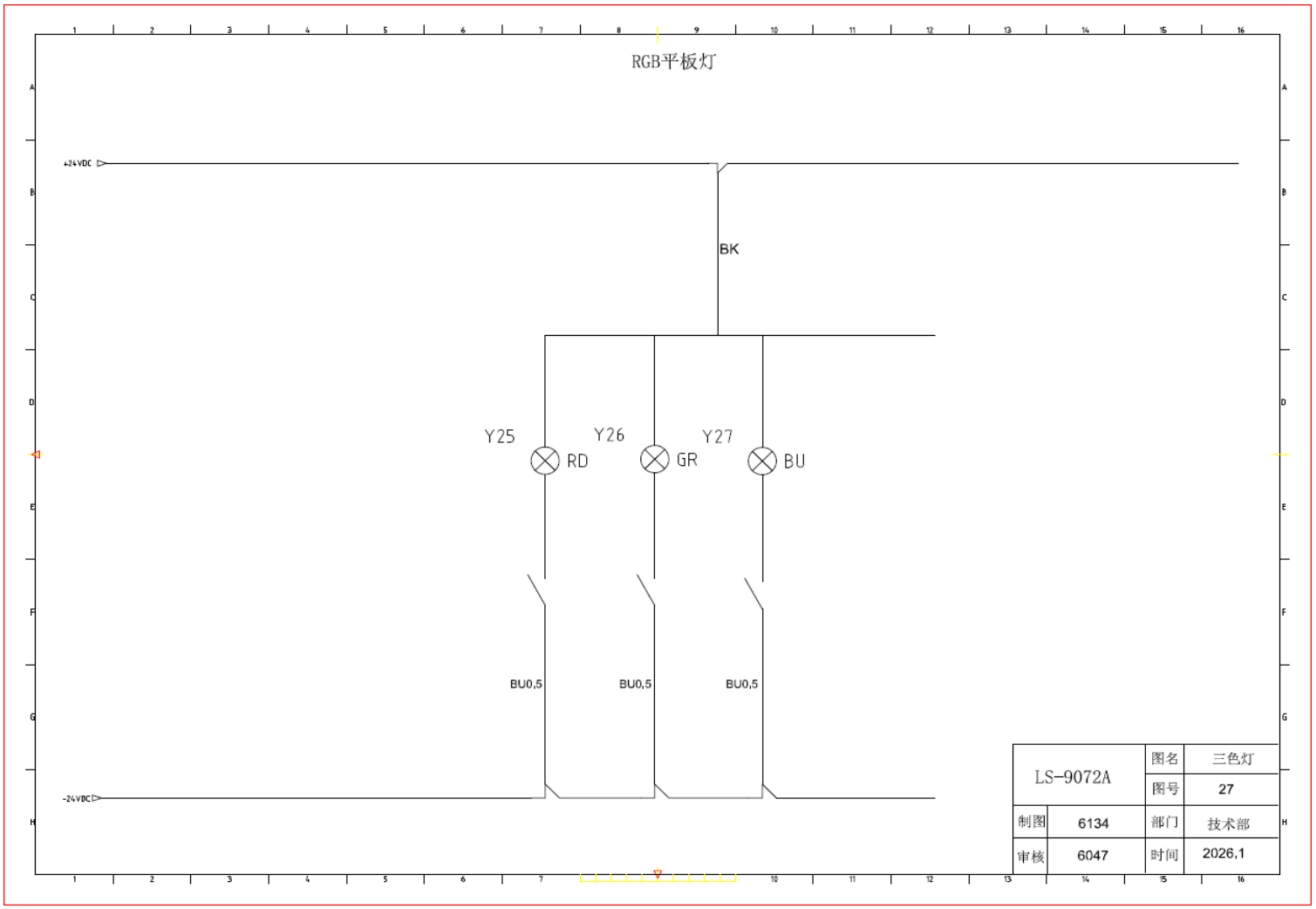
LS-9072A		图名	视觉
		图号	24
制图	6134	部门	技术部
审核	6047	时间	2026.1



Z轴刹车

LS-9072A		图名	Z轴刹车接线
		图号	25
制图	6134	部门	技术部
审核	6047	时间	2026.1


三色灯
-24VDC
BK
Y214
YE
Y215
GR
Y213
RD
-P1
BU0,5
BU0,5
BU0,5
+24VDC
LS-9072A
图名
三色灯
图号
26
制图
6134
部门
技术部
审核
6047
时间
2026.1


RGB平板灯
+24VDC
BK
Y25
RD
Y26
GR
Y27
BU
BU0,5
BU0,5
BU0,5
-24VDC
LS-9072A
图名
三色灯
图号
27
制图
6134
部门
技术部
审核
6047
时间
2026.1