006601 SPE-BQM240型单色棒球帽等软质帽丝印机

006601 SPE-BQM240 one color baseball cap soft caps screen printing machine

# 本机主要用于各种棉织布，化纤布，海绵类等软质材料制作的各种弧面与不规则帽子口罩等的印刷；如棒球帽，太阳帽，鸭舌帽，渔夫帽，雷锋帽，中山帽，八角帽各种软材料帽子，以及各种材料的口罩等等，使用本机能够有效提高印刷质量，提高印刷效率。

帽子口罩种类繁多，形状各异，尺寸不同，定位困难造成印刷位置不准确；印刷面为各种弯度的弧形面，弯曲不规则，帽型多样等特殊的特点，印刷中对帽子的固定和弧面网版适合不同帽体弧面的难点造成这类帽子的印刷效率非常低，印刷质量很难保证。

This machine is mainly used for the printing of various soft materials cambered surface and irregular cap mask ,such as cotton fabric, chemical fiber fabric, sponge, etc. For example, baseball cap, sun cap, duck cap, fisherman cap, leifeng cap, zhongshan cap, octagonal cap all kinds of soft material caps, as well as masks of various materials and so on, the use of this machine can effectively improve the printing quality, improve the printing efficiency.

There are many kinds of caps and masks, with different shapes and sizes. The printing position is not accurate because of the difficulty in positioning. The printing surface is cambered surface with various bending degrees, irregular bending, diverse cap shapes and other special characteristics. The difficulty in fixing the cap and fitting the camber screen plate for different cap bodies in printing results in the very low printing efficiency of such caps and the difficulty in guaranteeing the printing quality.

我公司设计的这款软质帽丝印机基本能够解决以上两个难点：

The screen printing machine designed by our company can basically solve the above two difficulties:

1. 帽子与口罩工装弧度调整定位：采用可调整弧面工装，可根据需要调整弧面弯曲度，以适合各种帽子与口罩的弧度；

Positioning by adjusting the radian of the cap and mask: using the adjustable arc material ; adjust the radian of the arc according to the need;

1. 帽子与口罩定位：将帽子或口罩套在工装上，帽子与口罩三面或四面通过4-6个吸铁石定位在工装上立板上；帽子或口罩会牢牢固定不移动；取下帽子只需拿下吸铁石即可，方便快捷；套入帽子轻松简单，帽子不发生偏离；

Positioning of cap and mask: place the cap or mask on the tooling, and position the cap and mask on the tooling vertical board by 4-6 magnets on three or four sides; The hat or mask will not move; Take off the hat just take off the magnet, convenient and quick; Easy to set the hat, the hat does not deviate;

1. 不锈钢弧面网版可按照帽子的弧面进行左右手动旋钮微调弯曲；达到适合帽子印刷面的弧度要求，从而保证网版弧面与印刷面的尽可能平行，保证印刷定位准确，保证印刷质量。

Stainless steel cambered plate can be bend a little from left to right in accordance with the arc of the hat ; To meet the radian requirements of the cap printing surface, so as to ensure that the screen plate and printing surface arc as parallel as possible, to ensure accurate printing positioning and the quality of printing.

一：本机基本功能：Basic functions of the machine:

1. 本机底部平台可前后移动，并设置拖动定位装置；将平台拖出，套入帽子或口罩，吸铁石吸附固

定；推入机器内印刷；拉出平台，取下吸铁石，取出帽子或口罩；拉出与推入均可通过平台两边定位滚珠螺丝准确定位；

The bottom of the machine and the positioning platform can be moved back and forth, and a drag positioning device is set;Drag the platform out, cover with a hat or mask, and the magnet

adsorb to fix, push the machine to print; Pull out the platform, remove the magnet, remove the hat or mask; Pull out and push in can be accurately positioned by positioning ball screws on both sides of the platform;

1. 主机为可左右，上下手动旋钮微调式；上下可移动170毫米；并带有把手锁定；左右可微调20

毫米，并拧紧锁定。

The main machine can be micro adjusted by manual knobs from left to right , up and down,up and down can move 170 mm; There is with a handle lock; Left and right can adjust 20mm,tighten and lock.

1. 采用1毫米不锈钢网板，网框直接固定在框架横梁两边；网版可前后130毫米；网版安装横梁

可通过手拧螺丝对网版弧度进行左右调整；调整至与印刷面弧度基本一致后锁定两只横梁两头螺丝。

The machine adopts 1 mm stainless steel plate, the screen frame directly fixed on both sides of the frame beam; Screen plate can move 130mm front and rear; Screen plate installation beam

can finished by adjusting the screen radian by hand screw; After adjusting to the same radian as the printing surface, lock the screws at both ends of the two beams.

1. 吸铁石整体包有橡胶层，吸附力大，同时还不会对帽子或口罩有损伤；吸铁石带有拉手，取用方便，快捷，省力。

The whole magnet is covered with rubber layer, adsorption force is large, at the same time it will not damage the hat or mask; Magnet with handle, easy to access, fast, labor - saving.

5， 随机配置两个可弯曲不锈钢网框；内径尺寸分别为100\*190毫米（外径130\*200毫米）；100\*240

毫米（外径130\*250毫米）；基本适合大多数各种软质帽子印刷图案的需要。

The machine is equipped with two flexible stainless steel frames; Inner size is 100\*190 mm (outer size is 130\*200 mm); 100\*240 mm (outer size 130\*250 mm); Suitable for most kinds of soft hat printing patterns

6，本机所有部件为高级静电喷涂表面处理，耐腐蚀，耐酸碱，耐清洗，长久使用不生锈。

All parts of the machine are advanced electrostatic spraying surface treatment, corrosion resistance, acid and alkali resistance, cleaning resistance, long - term use without rust.

二：本机配套设备（可根据需要选购，配套设备详细资料见相关网页）：

Supporting equipment of the machine (optional according to the need, details of supporting equipment see the relevant webpage):

1. SPE-3040型弧面网板专用绷网机：因弧面网版比较柔软，普通绷网机不可使用；本绷网机专门

用于弧面网版绷网；可同时绷制外径130\*250毫米的弧面网版2个；

SPE-3040 special stretcher for arc-surface screen plate: due to the softness of arc-surface screen plate , normal stretcher cannot be used; This stretcher is specialized in stretching mesh of

arc screen plate; It can stretch 2 arc screen plates with the outer size of 130\*250 mm at the same time.

1. SPE-弧面网板专用上浆台：因弧面网版不锈钢只有1毫米厚，边缘只有15毫米，比较柔软，按

传统的上感光胶方式无法保证涂胶均匀平整，该上浆台专门为弧面网版设计专用，只与本机的网版配套使用。

SPE- cambered screen plate special coating emulsion machine: because the arc screen plate of stainless steel only 1 mm thick, edge only 15 mm, relatively soft, traditional coating photosensitive emulsion can not ensure the smooth coating, the machine is specially designed for the arc screen plate, only used with the screen plate matching.

1. SPE-弧面网板专用烘版箱：本机两个用途：一是专门为弧面网版脱脂清洗和上感光胶后的网版

进行干燥和烘干；二是用于定型树脂的加热柔软。

SPE-arc screen plate special drying cabinet: this machine is used for two purposes: one is specially drying the arc screen plate after degreasing and cleaning ; The second is used to heating the soft resin.

1. SPE-4632SBJ型小型晒版机：弧面网版可适合各种晒版机；本晒版机为非专用配套设备。该机

可同时放置外径130\*250毫米的弧面网版3个进行紫外线曝光。

SPE-4632SBJ exposure unit: cambered screen plate can be suitable for a variety of exposure unit ; This exposure unit is not a special supporting equipment. This machine can place 3 cambered screen plate at the same time with the out side of 130\*250 mm .

使用方法与步骤（仅供参考）Usage methods and procedures (for reference only)

1. 拖出平台，将承印物套在工装上，并用吸铁石固定；

Drag out the platform, cover the substrate on the tooling and fix it with a magnet;

1. 根据承印物的弧度调整弧形工装两边的螺丝，以达到工装与承印物弧面基本吻合的状态；

将平台推入机器内准备定位；

Adjust the screws on both sides of the cambered settings according to the radian of the substrate to achieve the condition that the setting and the cambered surface of the substrate basically coincide;Push the platform into the machine for positioning;

1. 将绷好网的空网版安装在网框架上；

Install the screen frame with blank mesh on the frame rack;

1. 调整网框弧度与帽子印刷弧面基本吻合，并基本确定印刷图案在网版上的位置；

Adjust the screen frame radian and cap printing cambered surface basically matched, and basically determine the printing pattern on the screen plate position;

1. 取下网版并根据图案的位置制版；

Take down the screen plate and make plate according to the position of the pattern;

1. 为防止油墨外溢，网版四周可贴上封边胶条；

In order to prevent ink overflow, screen plate around can be affixed with sealing strip;

1. 安装上成品网版并做进行前后左右调整至合适对应位置后，将网版两边安装条国定螺丝锁定即可

进行印刷。

Install the finished screen plate and adjust it to the appropriate position ,Install the fixed screws on both sides of the screen plate to lock and print.

随机配置相关工具与材料：

1，8厘米上浆器1个

2，两款不锈钢弧形网板各1个

3，8厘米金属刮板1只（含胶条）

4，网版封边胶条1盘

Configured with relevant tools and materials:

1.1 piece 8 cm scoop coater

2. One for each of the two stainless steel cambered screen plates

3. 1 piece 8cm metal scraper (including rubber strip)

4, 1 roll screen plate edge sealing tape