

DMS Hot stamp unit: Set up procedure for Hot Stamp Unit.

- Using the adjustment ratchet handles back off the impression 8 turns. It is necessary to ensure that the impression is completely off prior to start up.
- Make sure that the die assist hold down bolts are also backed off as a typical die will expand 5 – 10 thousandths of an inch when heated.
- Set the temperature controller to the desired temperature and wait for the die to come up to temperature.

* Please note: as the die warms up to the desired temperature the alarm may sound once or twice, this is normal during the start up procedure. Simply press the “Enter” button to reset the alarm.

Amongst other things the temperature controller monitors the temperature change of the die relative to the heat delivered to the die. During the initial warming of the die when the die is cold there is a slight lag in temperature rise relative to heat delivered that falls outside of the systems parameter's causing this alarm to be tripped.

- Set impression switch to “Auto”.
- Once the unit is up to temperature run a few feet at minimal speed through the unit with no impression checking that the base roll does not make an impression on the web. If the base roll does make an impression back the base roll off further using the ratchet handles.
- Tighten down the die assist hold down bolts to a desired reading of 200 Lb's if TorKit unit is fitted.
- Gradually raise the impression until the desired results are achieved.
- The print job is now ready to run. Fine adjustments to temperature and impression may or may not be required dependent on run speed and materials used.