

Operation Manual of one-piece packaging machinery

Foreword

Thank you for your choice of one-piece packaging machinery manufacturing automatic sub-packaging machine series, the product has a simple to use, strong and durable advantages, it will be for you and the enterprise's work to provide the greatest convenience.

Before installing and using the packing machine, please be familiar with the contents of this operation manual. It can help you understand the basic performance, structure and operation of the machine quickly, so that you can use the packing machine correctly, make the machine play the best performance, reduce the failure, extend the service life.

Integrated packaging machinery professional brand, focusing on improving the production efficiency for enterprises and individuals

To enhance product value. Every year for tens of thousands of enterprises to effectively recover the invisible loss of profits. Thank you for giving us the opportunity to serve you.

Safety precautions for using this machine

1, before starting the machine to check whether there is material at the bottom of the packing machine pile up in the bottom plate, packaging machine seal if there is before the residual bag residue can be cleaned first. 2. Install the shield before starting up. During the operation of the machine, it is strictly forbidden for any part of the body to approach or touch the working parts. 4, the machine in normal work is strictly prohibited frequently switching Operation Button, strictly prohibited at will frequently change parameters (what parameters to adjust please contact our technical personnel) . 5. Do not insert hand or tool into the sealing cutter while the machine is in operation. 6. Ultra high speed long running is strictly prohibited. 7, check and repair the control circuit, strictly prohibit live work, be sure to cut off the power. 8. Do not alter the machine without the company's permission and do not use the machine outside the specified environment.

Warning: For your safety and the safety of other people and machines and equipment, please operate according to the above requirements. We are not responsible for any accidents or accidents arising from not operating according to the above requirements.

2. Installation steps

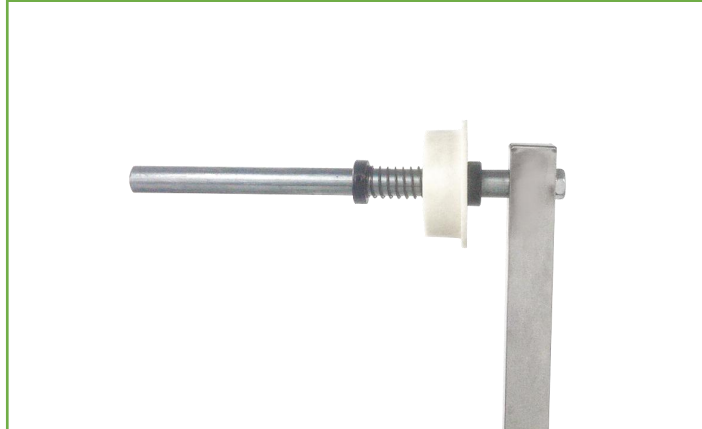
① mounting bracket: :

Fix the bracket on the sealing machine (3 screws as shown) as far as possible to keep the bracket perpendicular to the ground. If the machine is equipped with a two-bar encoder rack, use a medium-sized rack



②Mounting roll

Place the film on the top rail of the shelf. Note that the center of the film must be perpendicular to the molding. The black fixing ring on the far right should not be moved. The technician has found the position when testing the machine. The other pieces should be removed and re-entered in sequence, from the left in order: Black fixed ring (if not removed do not use), white roll film card wheel, gasket, spring, black fixed ring (the spring will be slightly tight and then lock the hexagon screw locking), roll film, White Roll Film Card Wheel, black fixed ring (hexagon screw locking). The effect is shown in the red line.



③Roll the film into the molding machine

Note that the individual film has two sides, as shown in the picture above, pull the film down in half, cut diagonally to form a triangle, as shown in figure.



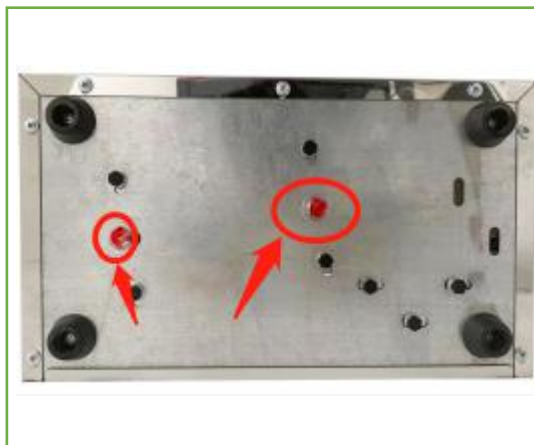
④Secure the clutch

Open the clutch switch to the upper left, when the entrainer gear will be separated, the two sides of the film will be aligned back to the middle of the entrainer gear, close the entrainer switch, the entrainer gear closed, fixed the film.



⑤Remove the mounting screws from the sub-assembly

The sub-assembly machine down, the bottom plate marked red reinforcement screw (transport protection role) removed, and the machine on the top of the sealing machine, sub-assembly machine outlet alignment machine molding machine feed mouth. Connect the signal line of the packer and the sealer at the same time.

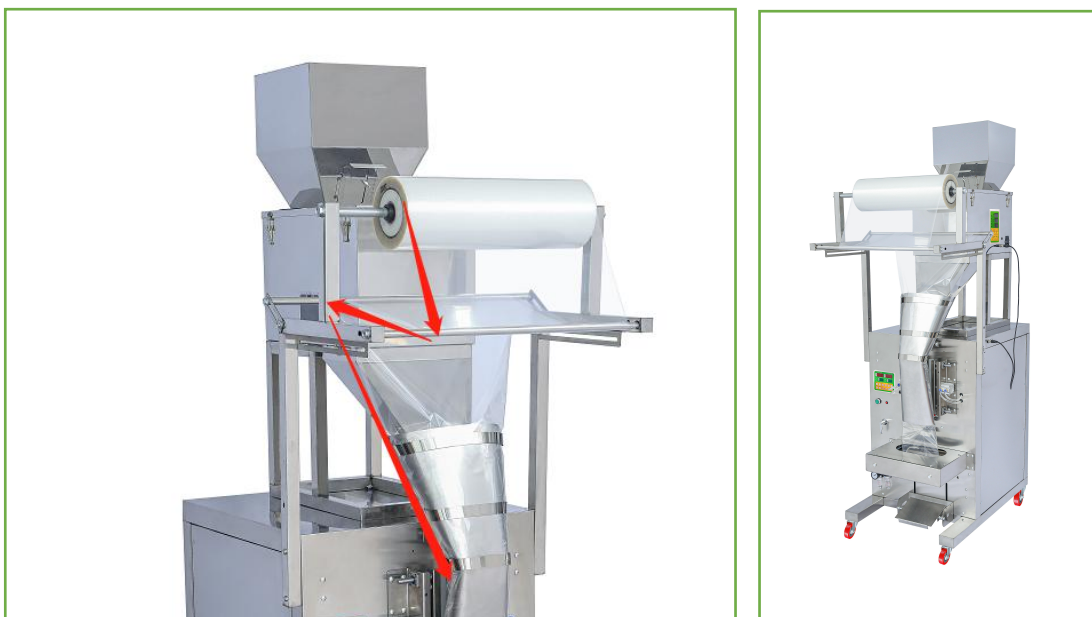


⑥Set parameter

After the signal line is connected to the machine, set the parameters of the sub-loader and the sealing machine, how many grams can be fixed directly through the sub-loader Computer Board weight + and weight-preset weight. Packaging machine computer board set up and down temperature (usually about 140 degrees, depending on the bag material and thin thickness adjustment) . After the temperature is set up, press the function key about 5 times to see if the bag is sealed. After the bag is sealed, adjust the length by adding or subtracting the length key (the printing film should be installed with a cursor, cut by the cursor, no need to set the length, need to set the parameters back to 001 length to 000) . After the bag is adjusted, the upper packing machine press start/start, the lower packing machine press run, the machine start normal work (pneumatic machine needs to be connected with the Trachea, air pressure will be enough to start) .



二、 Installation and display of medium and large machine or bracket with encoder

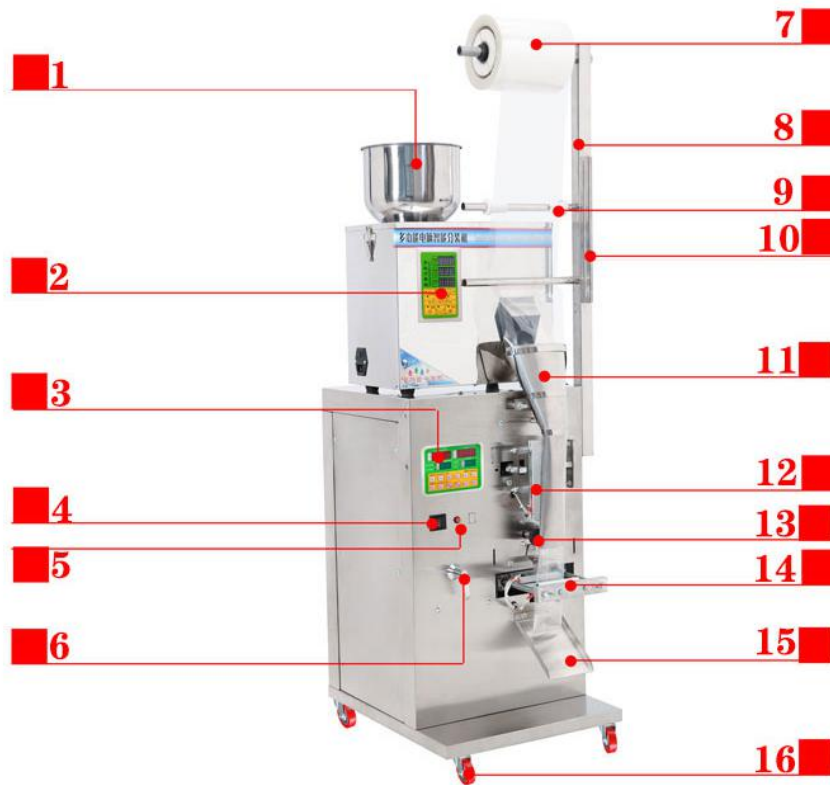


三、Installation and effect drawing of large machine and multi-head machine

1. The installation of medium and large machines is the same as that of small machines, except that the frame is different. There are two additional small iron plates and Cross bar. Lock the cross bar behind the 7-character bar at an angle of 45 degrees (avoid turning the bag when the film is taken) . 2, the multi-headed machine will first support the pole according to the number one-to-one corresponding to mount, then the sub-assembly machine on the shelf, remove the sub-assembly machine bottom mark red or mark the Arrow protection screw (specific several depending on the model) . 3. Install the hopper and the outlet, and then fasten the sub-loading machine bottom shelf and the previously installed shelf together through buttons. Note that the outlet direction is the same as the direction where the shelf has an opening. 4, the packaging machine into the shelf inside, and sub-loading machine outlet alignment can be.



四、Analysis of machine structure



1 Hopper (storage hopper) : CONTAINER FOR PLACING MATERIALS

2 sub-packer computer board: Regulation, setting, control sub-packer parameter

3 Packer Computer Board: Regulation, setting, control packer parameter

4 packer power key: 1 Bar Open, 0 close, 2 Bar Pause

5 vibration switch: Control Shaper Vibration (powder material is recommended to open)

6 pocket switch: control clamping gear

7 roll film (consumable) : Bag Roll Film Installation Location

8 shelves: Install Roll Film, cursor, Marker Bracket

9 clip: fixed stable roll film,

10 cursor bracket: position of 10 CURSOR BRACKET:

11 Shaper: Mould for roll forming

12 longitudinal seal (top seal) : Heating zone for roll back seal

13 pull bag gear: Open when film is loaded, when working, close

14 horizontal seal (lower seal) : Roll Film Upper and lower seal heating area

15 discharge baffle: According to the size of material, bend baffle stone finished product packaging discharge smooth out

16 direction wheel: easy to move and move

五、Key analysis of computer board of Packer



Three figures



Four digits

1. Screen (3-digit screen, 4-digit 2 screen) preset weight: show the weight of grams you have set: show the actual weight as measured

Quantity: The quantity that has been quantified (added up one by one, unset)

2. KEYPAD

Add, subtract key: set weight (long press can quickly add or subtract) clear: weight, packet number return to zero fast, medium speed, slow speed: according to the actual material and their own error requirements can be switched loading speed start, Stop: control sub-loading machine operation and stop (four-digit Computer Board start, stop key for a key)

Discharging and emptying: When testing or without foot pedal and photoelectric induction, press the release key to release the quantitative good material (to be in the Stop State) . When the work is finished and you don't want to continue working and there is material in the hopper, press to stop, then press to empty for three seconds, the machine enters the clearing state, the vibrator works continuously, and the placing material baffle is in the open state, the material is cleared out. The four-digit Computer Board has two separate buttons for discharging and emptying

Function: The vibration strength and internal parameters of the sub-packer are set up. There are many function settings in this key. It is more complicated. Please contact our after-sales technical staff to change and set the parameters in this key, we will show you the settings in the video and forbid you to change the parameters.

六、 Key analysis of computer board for packaging machine



Upper temperature regulation: Control Regulation Longitudinal Seal (upper seal) temperature (set according to the bag thickness) lower temperature regulation: Control Regulation Horizontal Seal (lower seal) temperature (set according to the bag thickness) Stop: Press Stop when the machine is running

OPERATION: Press the machine to start work (the above sub-machine also according to "Start") length adjustment: without the use of the cursor adjustment through the length of the "+" "-" button to set the length (note that the addition and subtraction of the number displayed only as a reference, not the actual value, there is a cursor when the length should be reduced to 000)

FUNCTION/SETTING: Click to get an empty bag to test the length of the bag and the seal. Long by entering the functional settings, divided into a number of gear, need to adjust the parameters can contact our after-sales technical staff to provide teaching video.

CLEAR/QUANTITY: Quantity Column Return to zero

pull bag: press the bag down, loosen the stop

cutting bag: press the down seal on, the blade cut into the cut bag, loosen and stop (pneumatic type need air pressure to cut bag)

七、Failure Analysis (sub-loading machine)

Failure condition	Failure condition	Handling method
No, turn it on	1、Check to see if the power cord is broken	Replace the power cord
	2、Check the fuse to see if it's blown	Replace the fuse
	3、Check whether the internal wiring of the chassis is broken or not in bad contact	To Reinsert or reconnect by unplugging the power cord
No weight, no pulsation	1、Check the hopper for material, or the sensor does not return to zero	Press the shutter button
	2、Check if there is any material stuck in the hopper, stuck in the weighing hopper	Clean the weighing hopper and the material around the sensor (sharp edge of the machine, careful cutting)
	3、Check the sensor circuit, row plug site is not in good contact	It can be reconnected and plugged into a computer board
Weight Window Number Jumble	1、Check if the sensor hopper is jammed with material	Clean the weighing hopper and the material around the sensor
	Whether the machine is affected by moisture (such as rainy day, spring environment humidity is more obvious)	Please remove the cover and blow hot air into the Computer Board for 5 minutes, then turn it back on after 5 minutes
Hopper not open or close	1、Press the release key to see if the hopper door panel swings	If there is no wobble reference
	2、The Motor has the working door plate fixed, the door plate screw loose	Please lock the door plate to fix the screw
	3、The door is tight and the hand is not easy to move, and the motor is stuck or damaged	Replacement Motor
	4、the door is very loose, please check whether the connection wire is broken, green row plug motor wire is not bad contact	Reconnect and re-tighten the green main power strip
	5、Computer Board has no current output, computer board is damaged	Replace the Computer Board
Computer Board flashing	1、Is the power cord fully plugged in or not in good contact	Reinsert or replace the power cord
	2、check the chassis internal main power connection wire, green wire row is not in good contact	Reconnect and re-tighten the green main power strip
	1. Check that the material is stuck and pressed together	Clean up the stuck material and repackage it
	2、long press the feed key 53 seconds to see if the vibration dress has become large, if become large	Check whether the set weight is normal or according to the weight window number do not jump/jump check
	3、If there is no change and the force is reduced,	Machine failure
No response on the sensor or the foot switch	1. Observe whether the weight of the machine has reached our preset weight	If the preset weight is not reached, the machine can not refer to the fault by sensing the blanking (loading speed is slow and powerless)
	2、the machine reached the weight of the first package automatically blanking, the second package is not under, press stop next package	1. The sensor is in the sensing state . 2. The foot switch is short circuited or broken. 3. Check the wiring for faulty connections. 4. Sensor failure

八、Trouble shooting (packaging machine)

Fault Code	Fault Code	Processing method
E-1 overheat failure	The heat line's broken	Change the temperature sensor
E-2 pull bag part failure	1, the cursor state, the cursor is not good, did not feel	Adjust the CURSOR
	2, the length of the state, pull the bag motor did not turn	1, pull the bag Houle adjustment or replacement. 2, Replacement Motor
E-3 bag-cutting failure	The slitting motor isn't working or in place. HOULE's not picking it up	Adjust in place, Houle or check the motor
E-4 temperature failure	The heat line's broken	Change the temperature sensor

九、Function setting of packaging machine (suggested to contact after-sale teaching)

Press and hold the function key for 2.2 seconds, wait for the display 000 after the release, according to the temperature to reduce the digital shift, with the temperature keys for digital adjustment, enter the corresponding function password in the temperature 1 box (see the table below), enter the function key to enter the function settings after the completion of the input, in the length setting display * If the function password input error, then exit the setting state. Function Password input is correct, press length increase key and length decrease key, make corresponding function adjustment in length setting window, press function key to exit setting and save after adjusting, the machine enters working state.

The code	Corresponding function	Set Range	Notes
202	Cut The bag and stop the clock	0.0-2.0 seconds	Default is 0.0, do not stop during bag cutting
303	Cut-off delay	0.0-2.0 seconds	Cut-off time during bagging, 202 setting is valid
404	Color Selection	0-2	0 = normal, 1 = color plus, 2 = color minus
606	Pull-bag Front delay	0.0-3.0 seconds	Default is 0.0, no delay before bagging
707	Vibration selection	0-2	0 = No earthquake, 1 = total earthquake, 2 = No earthquake in the pull bag
808	Pre-cut delay	0.0-3.0 seconds	Default is 0.0, no delay before bag cutting
909	Range Correction	1-4	Two-bit standard. The bigger the number, the longer the distance

Note: In the setting state, no key operation within 12 seconds will automatically exit the setting state, with vibration output function, vibration during the delay to maintain the output.