



# CODING SEALING MACHINE

MANUAL NO. 7474



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## **SAFETY INSTRUCTION**

1. Before using the machine, be sure to check whether the power cord is intact;
2. The machine must be grounded before use;
3. Do not disassemble the machine at will or use it in an uneven and humid place;
4. When inspecting and replacing consumables or parts, you must unplug the power supply before replacing;
5. Do not touch the heating part and transmission part directly with your hands;
6. Except for adding a proper amount of lubricating oil to the chain sprocket part, do not add oil or water to any other part;

## **FUNCTIONAL INTRODUCTION**

1. This machine is suitable for sealing and bag making of plastic films, and is widely used in food, medicine, chemical industry, daily necessities, hardware accessories and other industries;
2. Due to the unique and reasonable design and structure of this machine, the electrical part adopts an intelligent control system, and the mechanical parts adopt special materials and unique manufacturing processes. It can seal plastic film packaging bags of various materials, and completely solve the common problems of the industry such as loose sealing, non-adhesion, bag eating, and tape sticking of special plastic bags. And it is superior to other ordinary sealing machines that cannot work continuously for a long time, parts are easily damaged, and the adjustment is cumbersome and unstable, so that users can use this product with confidence;
3. Since the tension of the sealing belt of this machine is automatically adjusted, the sealing is very stable, the failure rate is extremely low, and the service life is longer. It can be used continuously for a long time and can meet the production needs of large quantities.

## **WORKING PRINCIPLE**

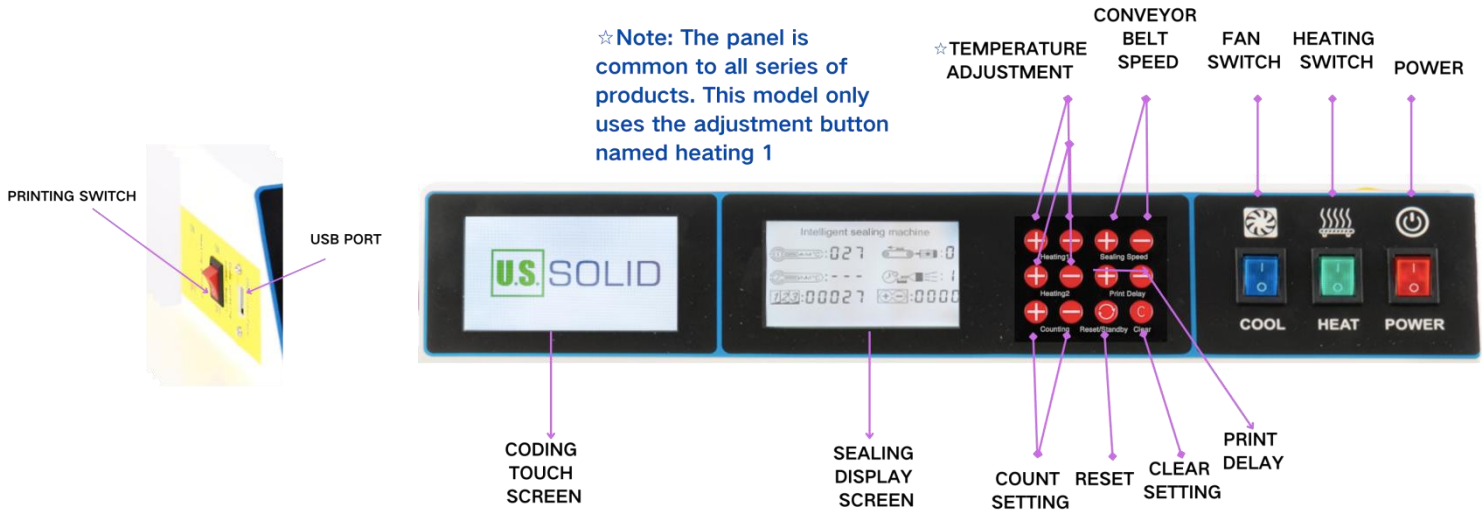
The machine consists of a frame, speed regulation, heating, cooling control system, transmission, conveying, printing and coding components. When the machine is started normally, the electric heating element begins to generate heat, so that the upper and lower heating blocks transfer heat quickly. When the temperature is controlled to the preset temperature by the circuit board control system through the thermocouple, the packaging object can be transferred to the sealing transmission part. The packaging bag is conveyed from the gap between the upper and lower sealing belts through the heating area (softening), cooling area (setting), and then rolled into a mesh shape through the embossing wheel part, and then counted by the counting sensor. At the same time, the code printing can also be completed, and finally the whole process is completed, which greatly improves the production efficiency and saves a lot of labor and machinery costs !

## BASIC PARAMETERS

POWER	700W	CONVEYOR BELT SPECIFICATIONS	70.86*7.08*0.07 INCH
MOTOR	24V/80W	POWER SUPPLY	110V/50-60HZ
SEALING SPEED	0~23 (M/MIN)	CONVEYOR LOAD	11 LBS
SEALING WIDTH	0.39INCH	MACHINE DIMENSIONS	37.8*16.5*16.1 INCH
TEMPERATURE CONTROL RANGE	0~536°F	MACHINE WEIGHT	66 LBS

# ELECTRICAL CONTROL SYSTEM

☆Note: The panel is common to all series of products. This model only uses the adjustment button named heating 1



1. Power Switch/Heating Switch/Fan Switch: These switches control the entire machine's power on and off functions. Press to turn on, and release to turn off. Note that the fan cannot be turned off if the ambient temperature is above 0°C. After setting the parameters, please turn on these three switches to start the machine.

2. Conveyor Belt Speed: The speed can be adjusted according to the temperature and sealing requirements. Press the button to directly adjust the sealing speed.

3. Temperature Adjustment: (The panel is common to all series of products. This model only uses the adjustment button named "Heating 1"): Adjust the

temperature according to the your requirements by pressing the “+” or “-” button. The temperature will increase or decrease by 1°C. Press and hold the “+” or “-” button to rapidly increase or decrease the temperature to the desired value.

4. Print Delay: This function adjusts the printing content position. Press the “+” button to extend the printing time, which moves the printing content to the right. Press the “-” button to shorten the printing time, which moves the printing content to the left. The exact movement distance depends on the sealing speed.

5. Count Setting: The maximum value is 9999. The number on the display screen will decrease from top to bottom. When the number is set to 0, the machine will automatically sound an alarm and the display screen will show the counting number. (If you don't need to count, you don't need to set this.)

*The machine is installed with a photoelectric counter by default, which may not be accurate in counting transparent bags.*

6.Reset/Standby: If there are alarm displays on the display screen, the machine will stop working. Press the reset button to check whether the machine will start working or not. If the machine still doesn't work after



pressing the reset button, check the machine. To put the machine on standby, press the reset button for 3 seconds. The display screen will show "STANDBY". In this condition, the machine will automatically turn off the heating system and the motor will turn off after the heater temperature decreases to 50. The machine will then go into standby condition. Pressing the reset button again will put the machine into working condition. Turning off the power will stop the machine from working.

7.Clear: The machine will automatically start counting after turning on the counter. The maximum count is 99999. The counter will clear the count after reaching the maximum of 99999. You can clear the count by pressing the clear button.

8.USB Port: If you need to print pictures or edited words, kindly connect a USB that contains the files you want. Click on the U-Disk and find what you want to print after connecting the U-Disk. Press the print button after selecting the items you want to print (Picture format should be BMP monochrome bitmap).

9.Printing Switch: Turn on the printing switch when you need to print. Turn it off when not in use.

## OPERATION

### ① Install the convey plate:

First remove the screws, place the convey plate on the belt, and tighten it with screws.



### ② Install the bag feeding plate:

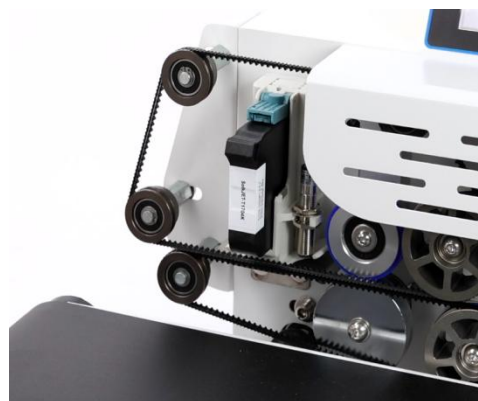
First remove the screws on the side of the machine, install the bag feeding plate, and tighten it with screws.



③ Install the ink cartridge:

Remove the transparent protective cover and install the ink cartridge on the machine according to the direction of the picture.

Note: When not using inkjet printing, be sure to remove the ink cartridge and cover the transparent protective cover to avoid ink solidification and failure to print. (Recommended ink model: W3T10B HP 2590 Black Solvent Ink Cartridge)



④ Sealing bags directly (no need to turn on the touch screen panel switch next to the USB port on the side) :

Press the sealing speed button and temperature adjustment button to seal the bags. Tips: The faster the speed is set, the higher the temperature needs to be adjusted. The slower the speed is, the lower the temperature needs to be adjusted.

⑤ Coding text: **(We have equipped you with a stylus, you can use the stylus or your finger to touch the screen.)** Turn on the touch screen panel next to the USB port on the side, click the menu button first (since we have put a protective film on the screen, you can use a little force to click the screen), click Text, and enter the edit page. Then edit the text you want to spray on the bag. Then click OK, the page returns to the original interface and displays the text you edited. Then click PRINT below, and the page jumps to PRINTING... and other texts. Click PRINTING... to start spraying. Other displayed functions such as STOP PRINT, PRINT SET, CANCEL can be set according to your needs.

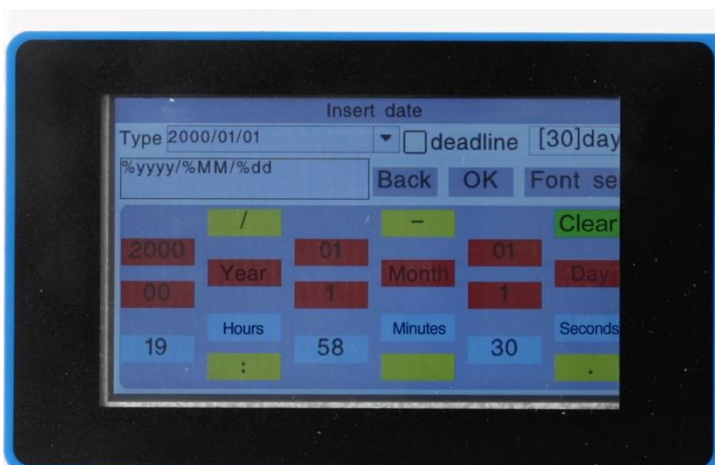




### ⑥ Date coding:

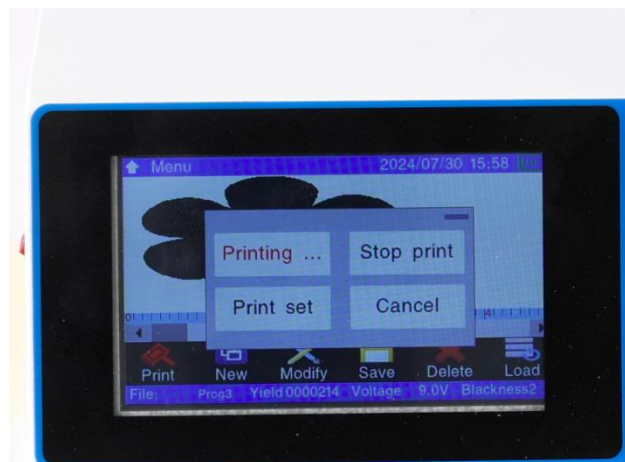
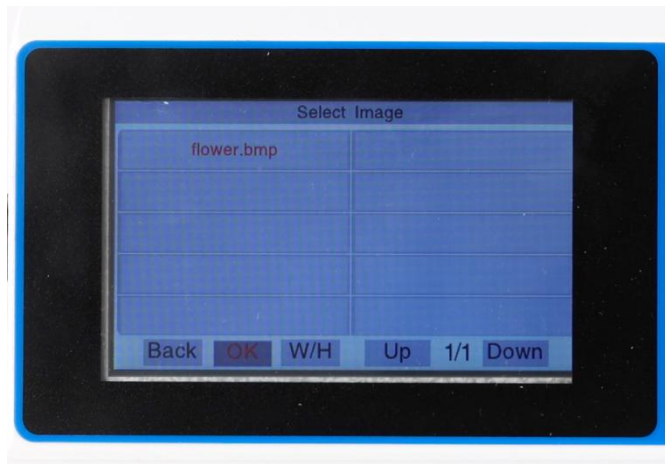
First click the menu button, click Date, and enter the edit page.

Then edit the date format you want to ink on the bag. Then click OK, the page returns to the original interface and displays the date format you edited (there will be + and - signs above the date, you can click to increase or decrease the font. Then click PRINT below, the page will jump to PRINTING... and other words. Click PRINTING... to start coding. Other displayed functions such as STOP PRINT, PRINT SET, CANCEL can be set according to your needs.



⑦ Image coding:

Insert the USB disk into the USB port on the side of the machine, click Menu, click image, select U disk, and click the file in the U disk to inkjet. Note: The image format must be bmp format.



If you need to print multiple patterns or texts in one line, click stop print on the print page, then click print set, click print counts, and set the number of codes you want to print. Then click OK to return to the previous page, click print interval, and set the interval between each code. The larger the number, the larger the interval. Then click OK, and then click back to return to the main page. Click start print to start the coding operation.



If you need to print a barcode, the operation process is also to first click the menu button, then click the relevant required coding option to enter the edit page. Then edit the coding content you want to inkjet on the bag. Then click OK, the page returns to the original interface and displays the text you edited. Click Stop print on the print page, then click Print set , click Speed. It is recommended to set the speed to 800 (you can adjust it according to actual conditions), then click OK and return to the previous page. Also, It is recommended to set other printing speed( words, image,txt, etc.) to 3000.

For other functions such as split, QRcode, the operation process is also to first click the menu button, then click the relevant required coding option to enter the edit page. Then edit the coding content you want to inkjet on the bag. Then click OK, the page returns to the original interface and displays the text you edited. Then click PRINT below, and the page jumps to PRINTING... and other texts. Click PRINTING... to start coding. The Txt file operation process is similar to the image operation process. You need to insert a USB drive and select relevant content from the USB drive for coding.

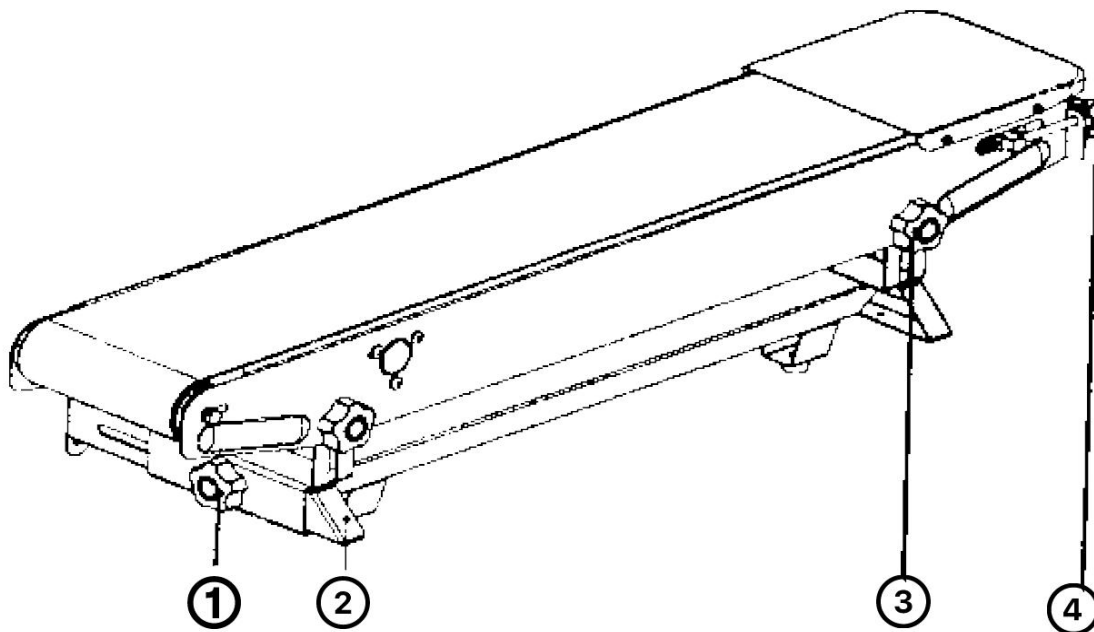




## ADJUSTMENT METHODS FOR EACH COMPONENT

### I: The adjustment method for the conveyor belt:

- ① Adjust the locking knob
- ② Tripod
- ③ Locking knob
- ④ Conveyor belt tension adjustment knob



Conveyor belt tension adjustment: When the conveyor belt is too loose or too tight, turn the two "conveyor belt tension adjustment knobs ④" at the same time (right-handed for tension, left-handed for loosening) until the conveyor belt is tight enough.

Front and rear fine-tuning adjustment of the conveying workbench:

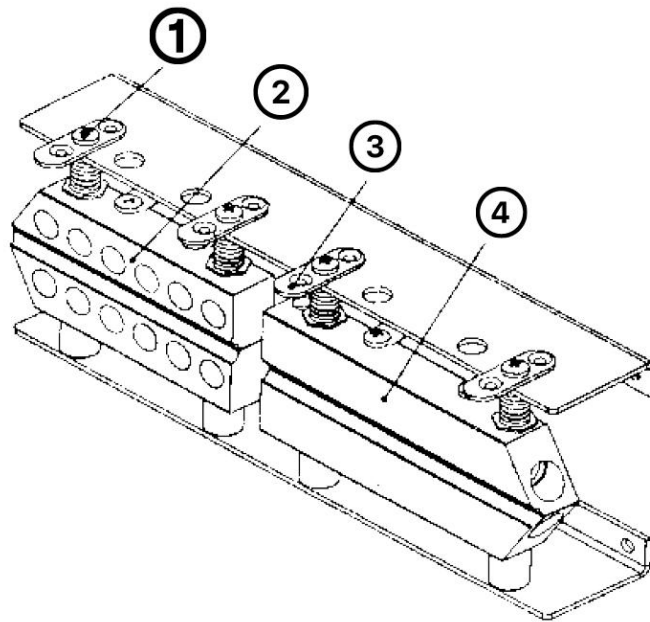
When the conveying workbench needs to be adjusted back and

forth, first loosen the "adjustment locking knob ①" on both sides, and then push or pull the workbench until the position is appropriate. Then, lock the "adjustment locks" on both sides respectively Tighten the knob ①

Up and down fine-tuning of the conveying workbench: When the conveying workbench needs to be adjusted up and down, first loosen the "locking knobs ③" on both sides, then move up or pull down the workbench to achieve the desired position. Secure it by locking the "locking knobs" on both sides respectively ③.

## II: Adjusting the sealing section

- ① Adjustment screw
- ② Cooling block
- ③ Lifting piece
- ④ Heating block



Adjustment of the distance between the upper and lower heating blocks and cooling blocks: Due to different sealing materials and their thickness, the distance between the upper and lower heating blocks and cooling blocks needs to be adjusted for each product that is sealed. This can be done by turning the upper adjustment screw ① to the left to reduce or increase the distance between the upper and lower heating blocks and the cooling block.

Sealing belt replacement method and adjustment: After the heating block cools down, remove the protective cover and rotate

the lifting piece ③ on the heating block and the cooling block by 90°. Raise the two parts and loosen the embossing wheel and the middle pressing wheel. Remove the guide belt then push the passive wheel seat toward the heating block. Remove the sealing tape and replace it with new sealing tape. Finally, return the passive wheel, heating block, cooling block, embossing wheel, etc. to their original positions.

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