



# CONTINUOUS BAG BAND SEALING MACHINE

MANUAL NO. 9685



## 1. PRODUCT PURPOSE

The machine is suitable for sealing and bag-making with various plastic and compound films. The equipment offers superior sealing abilities across a wide range of sectors, including the food, pharmaceutical, and chemical industries, as well as cosmetics, local produce, vegetable seeds, electronic components, and many more.

## 2. PERFORMANCE AND CHARACTERISTICS

With the electronic thermostatic control and the auto-transportation device, the machine can make various shapes of plastic film bags. It can be used for various packing lines with no limits to the length of the seal. Its key characteristics include a high efficiency of continuous sealing, high-quality and sturdy construction, and user-friendly operation. There are 2 groups of machines; the horizontal type and the vertical type. The horizontal type is used for packing and sealing dry goods and the vertical type is used for liquid goods.

## 3. CONSTRUCTION AND WORKING PRINCIPLE

The machine consists of a frame, speed regulator, sealing length regulator, temperature control, drive, and a transportation device. When turning the device on, the electro-thermal component produces sufficient heat to make the

and lower heaters promptly raise. From here, the temperature and speed can be adjusted as appropriate to the sealing material using the temperature control meter and the speed regulator. The plastic packing bag is transmitted by the conveyer belt with its sealing part positioned into the two running sealing braids. The seal is then subjected to the two heaters to make the plastic film melt and form a seal. Next, the bag is cooled in the cooling area, its sealing part is rolled by the pattern roller or the inker wheel to finish the job and form a tight seal.

The drive parts consist of sealing braids, a lead belt, and a conveyer belt which are all driven by a synchronized motor.

#### 4. MAIN SPECIFICATIONS

Power supply: 110V, 60 HZ

Sealing speed: 0 ~ 12m/min (adjustable)

Sealing width: 6 ~ 12mm (adjustable)

Temp. range: 0 ~ 300°C(adjustable)

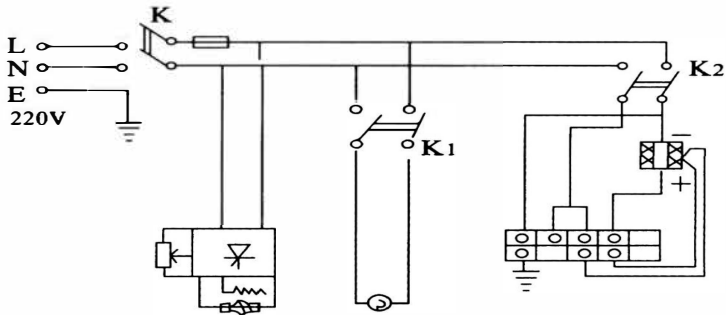
Single Layer Maximum Film Thickness:  $\leq 0.08$

Conveyor Table Maximum Load:  $\leq 6.6$  lbs

Machine Weight: 26 lbs

No. of printing words: 13

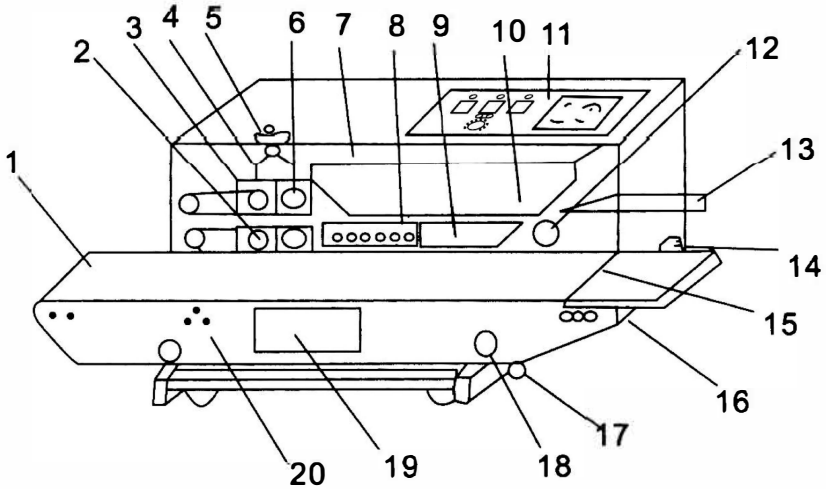
## 5. ELECTRICAL SCHEMATIC DRAWING



| Symbol | Name                      |
|--------|---------------------------|
| K      | Power supply switch       |
| BX     | Insurance tube            |
| W      | Potentiometer             |
| SW     | Speed regulating plate    |
| D1     | Motor                     |
| D2     | Blower                    |
| K1     | Blower switch             |
| K2     | Electro-thermal switch    |
| R      | Electro-thermal tube      |
| TDA    | Temperature control meter |
| E      | Electro-thermal couple    |

## 6. WAY TO USE

### (1) . Legend and description of the machine:



|    |  |    |  |
|----|--|----|--|
| 1  | Conveyer belt                                | 2  | Rubber wheel                                   |
| 3  | Pattern roller (inker wheel)                 | 4  | Inker wheel seat                               |
| 5  | Pressure regulating wheel                    | 6  | Driving wheel                                  |
| 7  | Safety guard                                 | 8  | Cooling block                                  |
| 9  | Heating block                                | 10 | Sealing braid                                  |
| 11 | Control box                                  | 12 | Driven wheel                                   |
| 13 | Guide place of sealing width regulation      | 14 | Power socket and safeguard                     |
| 15 | Fixed working table                          | 16 | Regulation screw of conveyer belt's elasticity |
| 17 | Regulation knob of conveyer station's in-out | 18 | Regulation knob of conveyer station's height   |
| 19 | Nameplate                                    | 20 | Conveyer station                               |

**(2) Name of control box:**



|   |                         |
|---|-------------------------|
| 1 | Power supply switch     |
| 2 | Heating switch          |
| 3 | Blower switch           |
| 4 | Motor speed-regulation  |
| 5 | Sealing temp indication |



Setting the temperature with the intelligent temperature control table:

A: The value displayed on the upper row PV is the actual temperature. The value displayed on the lower row SV is the set temperature.

B. Press the SET button in the lower left corner, and the value SV in the lower row will begin flashing.

C. Then press the ▲ button to increase or the button ▼ to

decrease to set the desired temperature. The value of this temperature should be set according to factors such as the thickness of the bag. It is generally set at about 150C.

D. When the temperature is set, you must press the SET button a gain, and when the screen returns to normal, you can commence your work.

(3). Preparation before starting the machine:

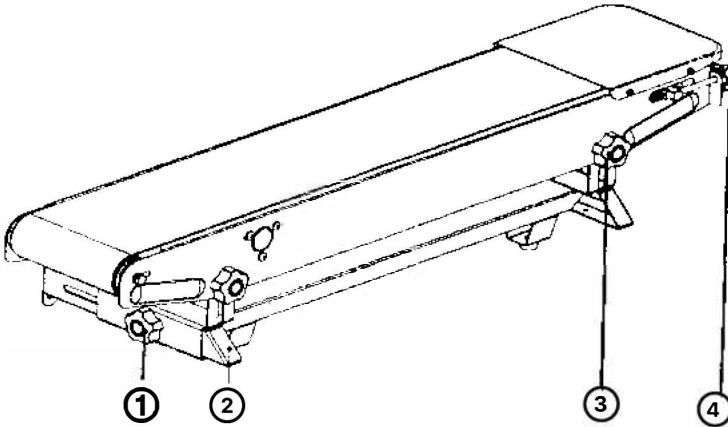
1. The machine is equipped with a shell-grounded triplex socket, which should be well-grounded to ensure safe use.
2. The electro-thermal component should be preheated at a low temperature for a few minutes before normal operation because it may be wet before initial use or after a long interval of being unused.
3. Adjust the height and the front-and-back position of the conveyor station to fit the size of the sealing bag.
4. Adjust the position of the guide plate of sealing width regulation according to your requirements.
5. Adjust the spaces between the upper and lower heaters and the upper and lower coolers (i.e., the spaces between the resealing brackets) according to the thickness of the sealing material.



**(4) 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



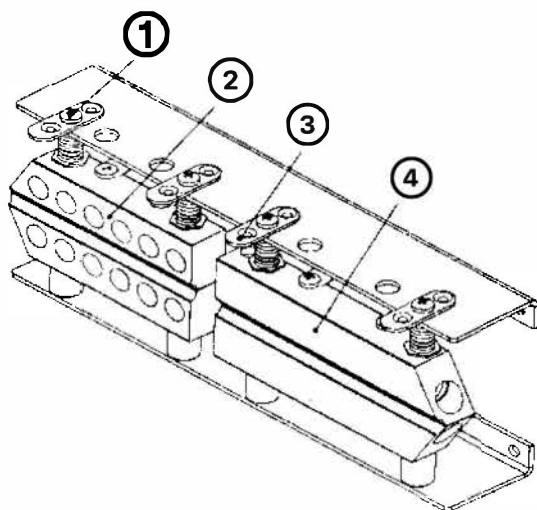
Conveyor belt tension adjustment: When the conveyor belt is too loose or too tight, turn the two "conveyor belt tension adjustment knobs" at the same time (right-handed for tension, left-handed for loosening) until the conveyor belt is tight enough.

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 " 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 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 " 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 .

## II: Adjusting the sealing section

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

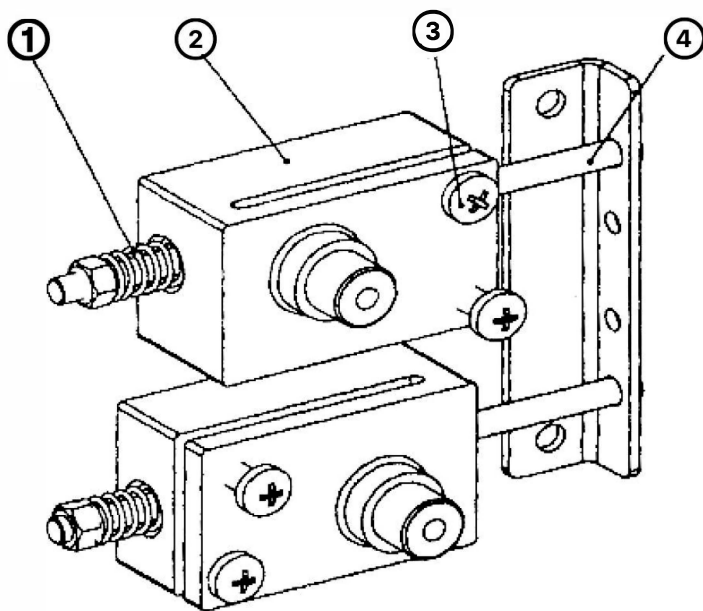


Adjustment of the distance between the upper and lower heating blocks and cooling blocks: Due to different sealing materials and their thickness, the distance between the upper and lower heating blocks and cooling blocks needs to be adjusted for each product that is sealed. This can be done by turning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

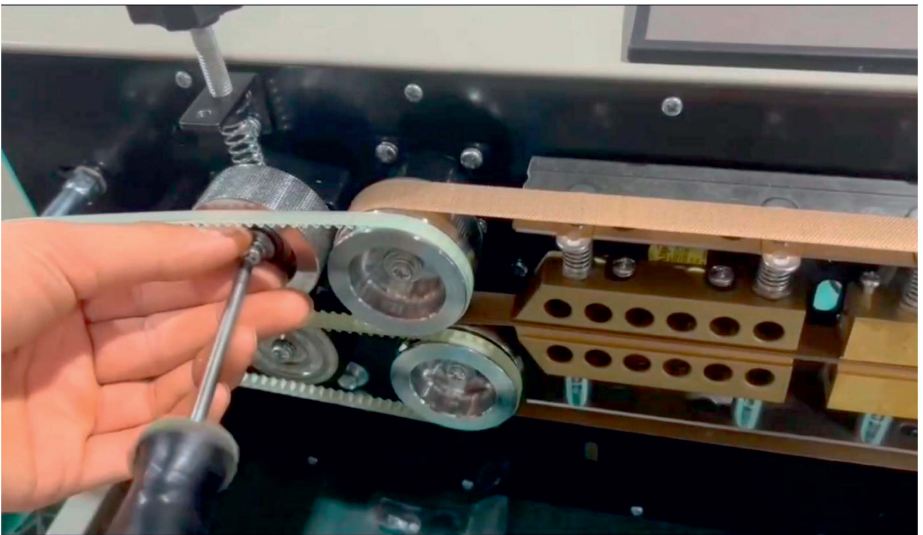
### III Passive pulley adjustment method:

- ① Spring
- ② Passive wheel seat
- ③ Adjustment screw
- ④ Sealing belt tension adjustment screw



If the sealing belt runs sideways, it can be adjusted through the adjusting screw on the passive wheelbase ②.

**(5) How to install the alphabet wheel.**



We have prepared a letter wheel for you which can be found in the accessory bag. This wheel can print numbers or letters onto the bag. You can use the small steel plate to unscrew the letter wheel and put the required letters into the letter wheel. Next, open the casing of the machine, remove the blank letter wheel with a screwdriver, and install the letter wheel you set.

**PLEASE NOTE:** For specific operations, please refer to the video on our product details page or email our customer service team to obtain videos of the machine operation and letter wheel installation.

### **( 6 ) Operation:**

1. Turn on the power, the indicator lights then all wheels begin their synchronistical running.
2. Adjust the knob of pattern roller to have it (or inker wheel) rotated and regulated to suitable pressure.
3. Turn on the heating switch, the green lamp of the electronic temperature control meter lights, adjust the meter to necessary temperature according to the nature and the thickness of the packing bag's material.

- a). Polyethylene: 150-- 160
- b). Polypropylene: 170-- 180
- c). Polyolefine compound: 180--190

The temperature can be adjusted along with the speed.

The red light will illuminate after heating for a while indicating the required temperature has been reached. At this point, a sealing trial can be done with a preset packing bag to determine if the temperature, speed, and the pressure of the pattern roller (inker wheel) needs to be adjusted to achieve an ideal sealing result. Once this has been achieved, continuous sealing can begin.

4. You can determine if the blower needs turning on for cooling based on the thickness of the sealing material. In general, it should be turned on for common polyethylene (i. e., single-layer plastic films).

5. The sealing part of the bag should be aligned when laid flat. Push the regulation place for the sealing sides in. The part will be gripped by the sealing braids and moved forward without intervention. At this point, stopping or removing the bag cannot occur. If you attempt this, uneven sealing or faults may result.



## OPERATION SUGGESTIONS:

1.The faster the speed, the higher the temperature may need to be adjusted. The slower the speed, the temperature may need to be adjusted lower. Try to adjust one setting at a time, either speed or temperature .

It is best not to adjust speed and temperature simultaneously.

2.If the bag is found to be broken or melted by welding, it means that the temperature needs to be lowered or the speed needs to be increased. If the bag is found not to be sealed or can be torn open after sealing, it means that the temperature needs to be increased or the speed needs to be slowed down.

3.If the items to be sealed are slightly heavy, in order to prevent the bag from shifting, it is best to hold it slightly with your hands when sealing.

## (7) MAINTAINING AND REPAIRING

### (1). Maintenance Method

- a). Push the driven wheel toward B and take out the sealing braid.
- b). Change for a new braid and install the upper and lower lead belt.
- c). Place the driven wheel, the heater, and the cooler in their original positions.
- d). Turn on the power to make the pulley rotate and the braid will start to move. You can now start a trial. The edge deviation on the sealing braid can be adjusted through the screw on the driven wheel.
- e). Install the safety guard. After doing so, continuous operation can commence after heating.
- g). To prolong the duration of the sealing braid, before stopping the machine, return the temperature adjustment dial to zero and turn on the blower. The temperature pointer will begin to slowly come down but the sealing braid will still be running. The blower and the master power switch cannot be turned off until the temperature falls below 100C, which can take a few minutes.

(2). Turbo case:

As an overall sealed turbo and worm unit, the turbo case has the features of low noise while delivering a large amount of power. It should be oiled with 50g 20#oil once a month. It should be cleaned and maintained only once a year based on a general usage of 8 hours per shift.

Care should be taken to keep the inside of the case clean to avoid it making noise.

## **Contact**

**Feel free to visit our website:**

**[www.ussolid.com](http://www.ussolid.com)**

**You can email us at [service@ussolid.com](mailto:service@ussolid.com)**