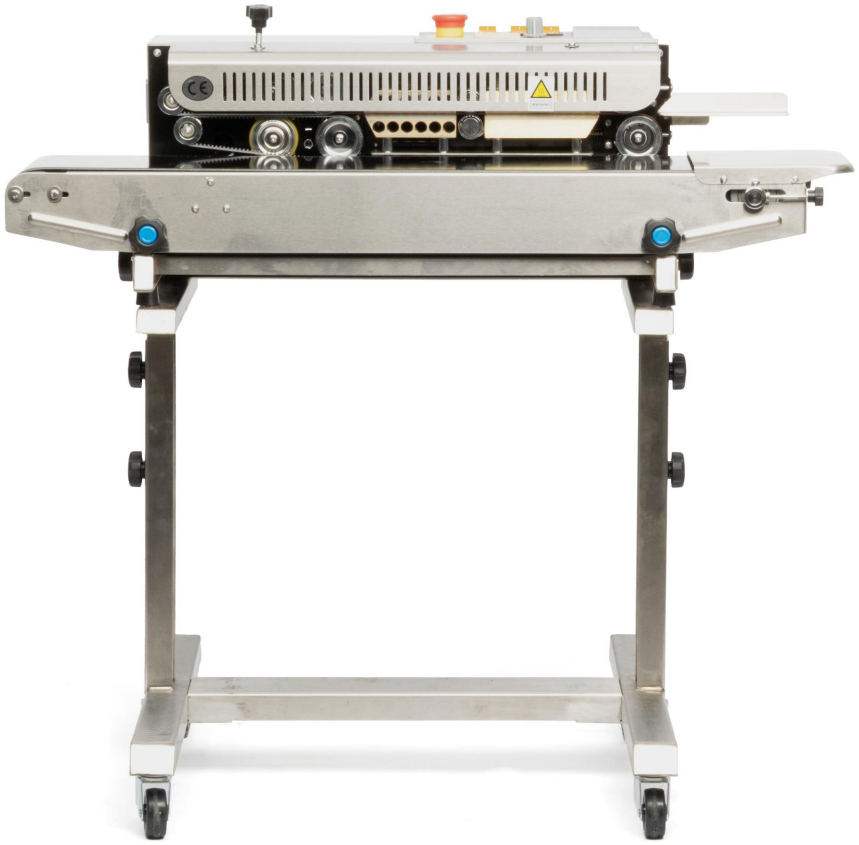
CONTINUOUS BAG BAND SEALING MACHINE

MANUAL NO. 10729



1. PURPOSE OF THE PRODUCT

The machine is suitable for sealing and bag-making of various plastic and compound films it is a best sealing equipment to be widely used in such sectors such as food, pharmaceutical, chemical industry, daily cosmetics, native and special local products, vegetable seeds, electronic components etc.,

2. PERFORMANCE AND CHARACTERISTICS

With the clectronic thermostatical control and the auto-trans-portation device, the machine can make various shapes of plastic film bags and be used for setting of various packing lines without Limiting the sealing length; having the characteristics of high efficiency of continuous sealing, reliable quality, reasonable construction,convenient operation etc.

In the series machines, there are horizontal type and vertical type, the horizontal type is for packing and sealing of drying goods; the vertical one is used for liquid goods.

3. CONSTRUCTION AND WORKING PRINCIPLE

The machine consists of frame, speed regulator,sealing length regulator, temperature control, drive and transportation devices.

When it turns on the electro-thermal component produces quantity of heat to make the temperature of both upper and lower heaters promptly raise And be adjusted the temperature and necessary

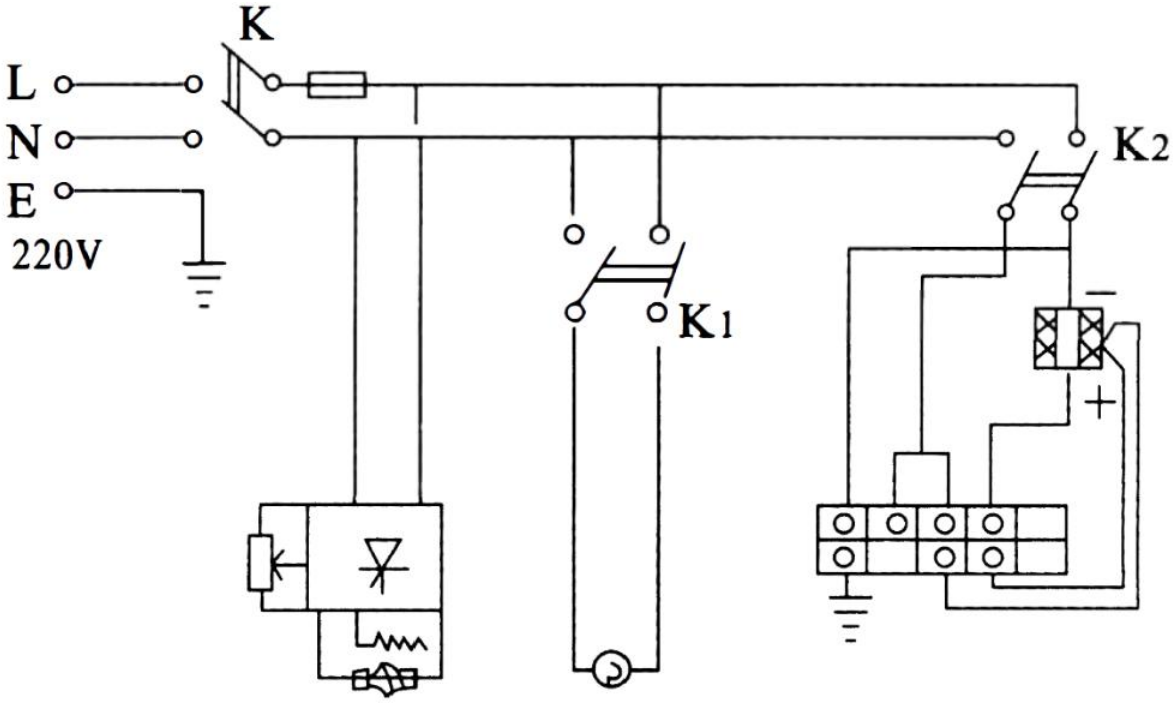
speed for the sealing material by the temperature control meter and the speed regulator, The plastic packing bag is transmitted by the conveyer belt with its sealing part senting into the two running sealing braids, and then is subjected to the extusion of the two heaters in heating area to make the plastic film conglutinate after being heated, then the bag is cooled in cooling area, its sealing part, rolled by the pattern roller or the inker wheel, is made out with stripes or netted veins or the necessary words.

The drive parts consisting of sealing braids, lead belt and conveyer belt all are driven by a motor in synchronistical running

4. MAIN SPECIFICATIONS

5. Power supply: 110V, 60 Hz
6. Power: 720 W
7. Sealing speed: 0 ~ 24m/min (adjustable)
8. Sealing width: 10mm
9. Temp. range: 0 ~ 300°C (adjustable)
10. Single Layer Maximum Film Thickness: ≤0.08mm
11. Conveyor Table Maximum Load: ≤22 lbs
12. Machine Weight: 63.9 lbs
13. Sealing length: Unlimited
14. No. of printing words: 15
15. Dimensions: 33.2 × 14.8 × 12.2 inch

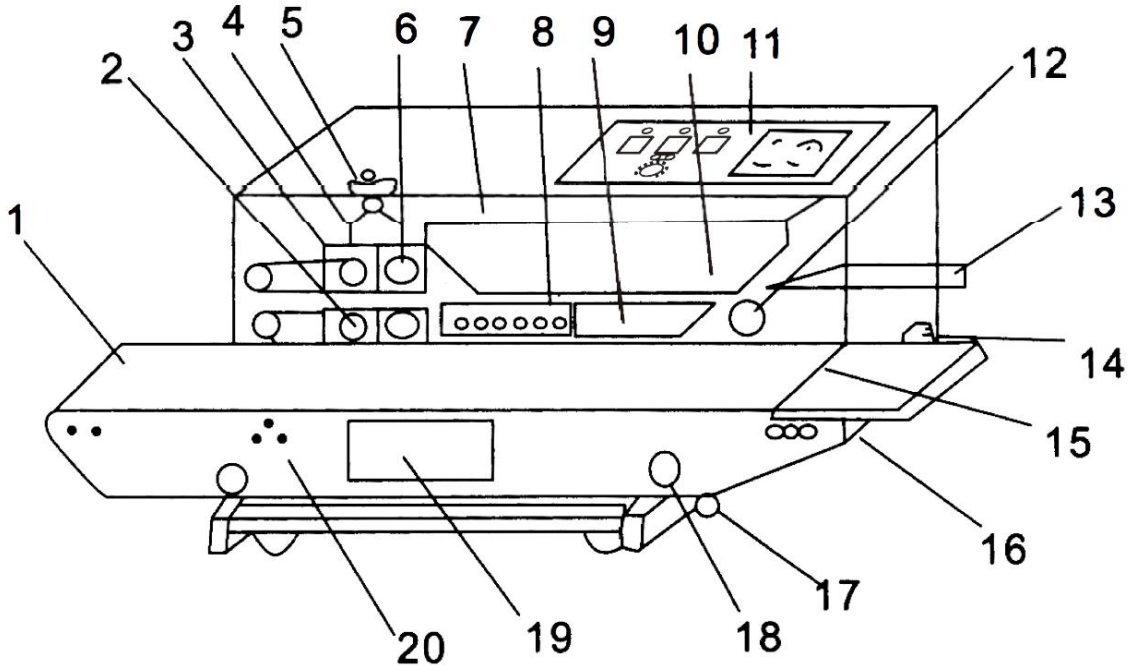
5. ELECTRICAL SCHEMATIC DRAWING



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 （Except the bracket part）:



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（If any）	20	Conveyer station

(2) How to install the bracket:

For detailed operation videos, please refer to the video section on the product details page or contact our customer service to ask for the video.

① Secure the bottom of the two T-shaped brackets and the I-shaped bracket using screws and a wrench.

② Install the wheels into the holes at the ends of the T-shaped brackets.

③ Insert the two smaller T-shaped brackets into the already assembled base unit.

④ Secure the two smaller T-shaped brackets to the base unit at the desired working height using screws and blue star-shaped knobs.

⑤Loosen the two blue star-shaped knobs at the bottom of the sealer. Pull out the conveyor belt section of the machine. Align the socket of the rotating column on the main body section with the black protrusion on the conveyor belt section, insert it fully, and push it firmly into place. Tighten the screws to secure it. Use a wrench to tighten the black clamp on the rotating column section.

⑥ Remove the six foot pads from the bottom of the machine.

⑦ Place the machine onto the stand. Place two foot pads at the bottom of the machine to keep it balanced. Secure the foot pads

by inserting screws upwards from the bottom of the stand. Similarly, secure the machine and the stand together by inserting screws upwards from the bottom of the stand at the other end.

(3) Name of control box:

1	Emergency Stop
2	Power Supply Switch
3	Heating Switch
4	Blower Switch
5	Sealing Temp Indication
6	Speed Regulation
7	Counter

The setting method:

1. For first-time use, unlock the emergency switch by turning it upward, then power on other controls sequentially.

2. Temperature Settings for Sealing: The PV value displays the real-time temperature, while SV sets the target temperature. Press the + or - buttons to adjust the SV temperature, then press SET to confirm.

3. The black knob controls the conveyor belt speed. Rotate it clockwise to increase speed or counterclockwise to decrease.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.

(4). Preparation prior to start the machine:

1. The machine is equipped with a shell-grounded triplex socket, which should be well grounded to make sure of safe production.

2. The Electro-thermal component should be preheated with low temperature for a few of minutes before normal operation because it may be wet in initial use or after long interval unused.

3. Adjust the height and the front-and-back position of the conveyer station to fit the necessary level of the sealing bag's exterior size.

4. Adjust the position of the guide place of sealing width regulation according to its requirement.

5. Adjust the spaces between the upper and lower heaters and the upper and lower coolers (i. e. the spaces between the resealing braids)according to the necessary thickness of sealing material.

(5) The adjustment method of each component:

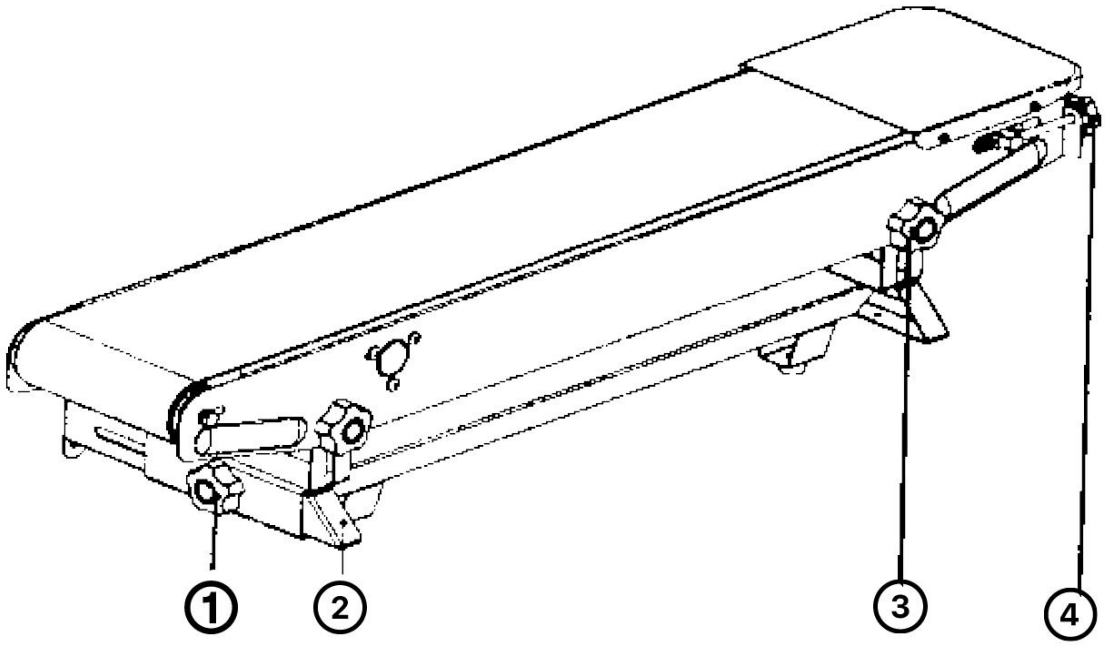
I: The adjustment method of conveyor belt:

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 When appropriate.

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, and 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 until the position is right, and then lock the "locking knobs" on both sides respectively ③".

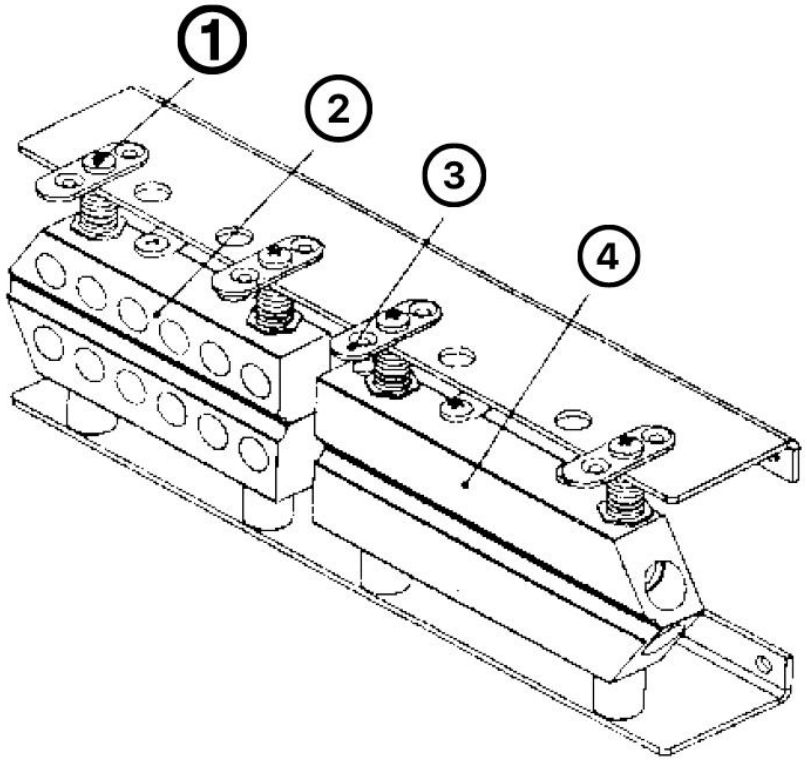
II : How to adjust the sealing part

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 the different sealing materials and thicknesses, the distance between the upper and lower heating blocks and cooling blocks needs to be adjusted for each product seal. For the distance between the upper and lower heating blocks and the cooling block, turn the upper adjustment screw ① to the left to reduce 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, rotate the lifting piece ③ on the heating block and the cooling block 90°, and raise the two parts; and loosen the embossing wheel and the middle pressing wheel. Spring, remove the guide belt, then push the passive wheel seat toward the heating block, remove the sealing tape, replace with a new sealing tape, and then return the passive wheel, heating block, cooling block, embossing wheel, etc. to their original positions.

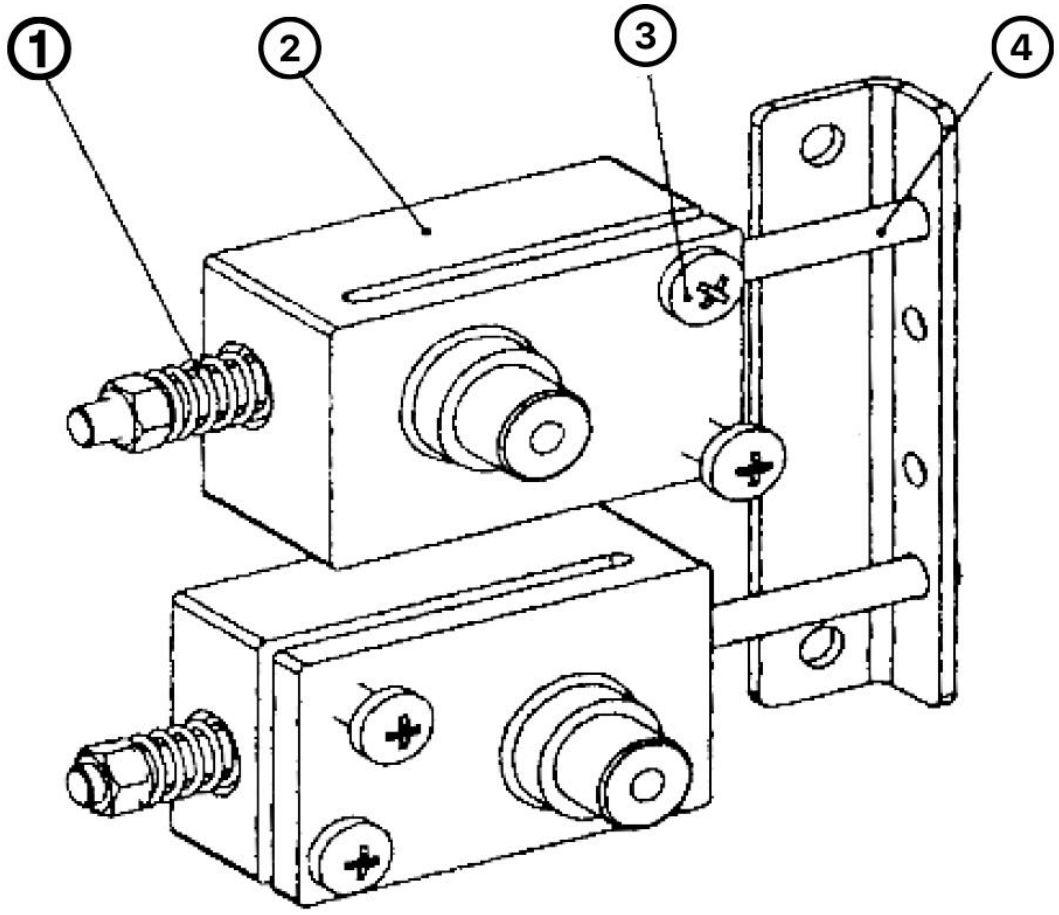
III Passive pulley adjustment method:

① Spring

② Passive wheel seat

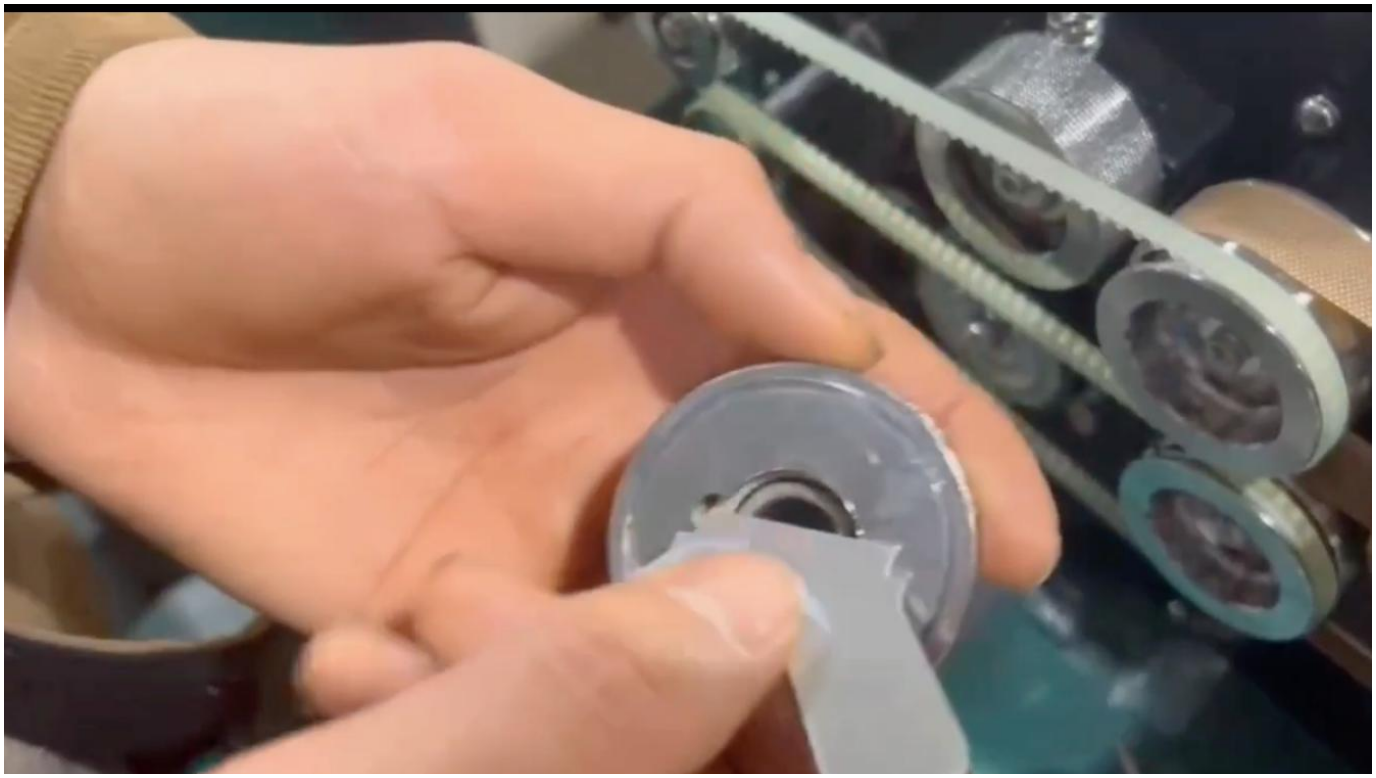
③ Adjustment screw

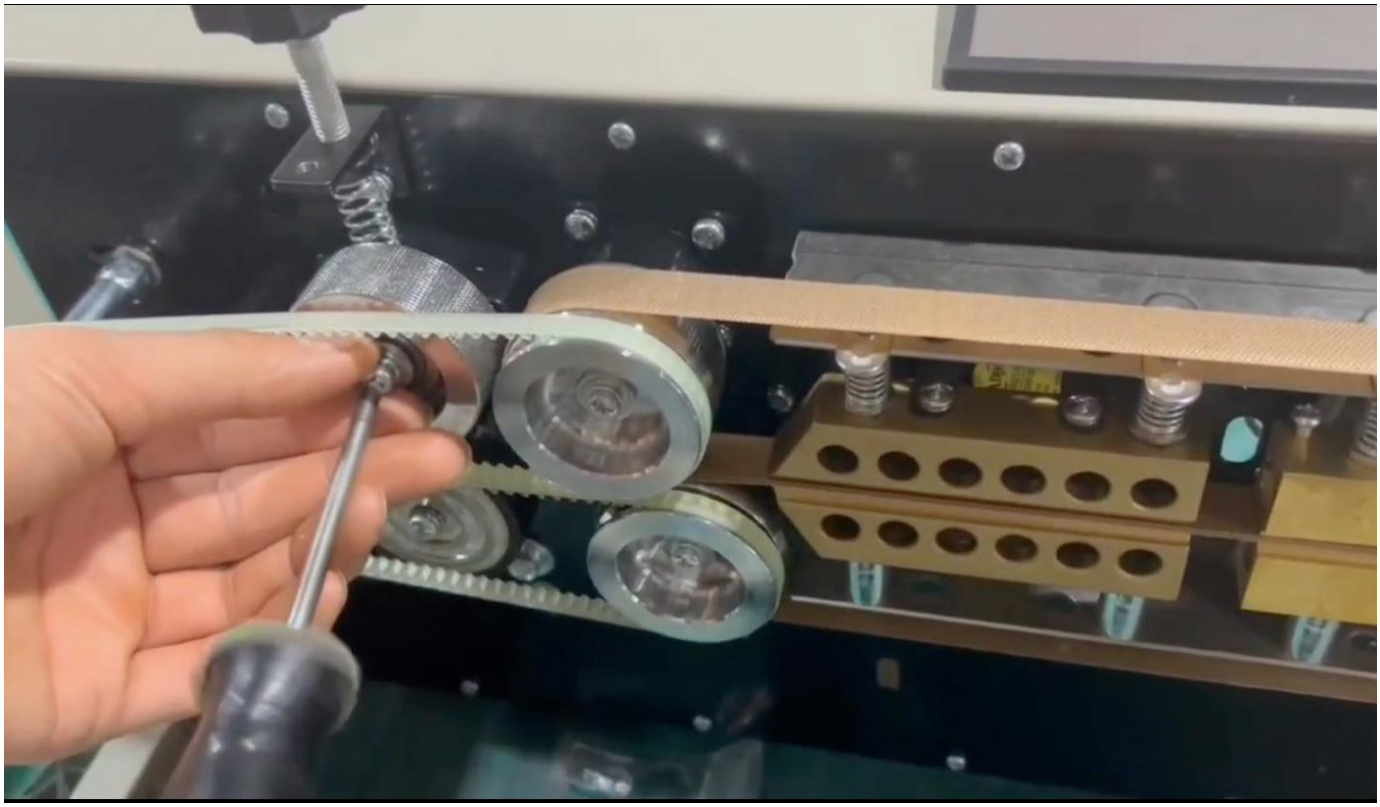
④ Sealing belt tension adjustment screw



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

(6) How to Install the Alphabet Wheel:





We have prepared a letter wheel for you in the accessory bag that can print numbers or letters on the bag. You can use the small steel plate we prepared for you to unscrew the letter wheel and put the letters you need into the letter wheel. Then open the casing of the machine, remove the blank letter wheel with a screwdriver, and install the letter wheel you set. (For specific operations, please refer to the video on our product details page or contact our customer service by email to obtain the operation video of machine and letter wheel installation)

(7) Operation:

Please note:

Our machine is equipped with a photoelectric counter suitable for colored bags. If you need to count transparent bags, please replace the mechanical counters we prepare for you in the accessory bag. (For the specific installation method, please refer to the video displayed on the product details page or contact us to obtain the installation video). If you don't need to count the bags you pack (whether your bags are clear or colored bags), you can use it directly after receiving the machine without changing the counter.

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 rotated and regulated to suitable pressure.

3. Turn on the heating switch, the blower switch and the blower switch, adjust the meter to necessary temperature according to the nature and the thickness of the packing bag's material. In general, the numerals below can be used for above adjustment at a room temperature of 20℃:

a). Polyethylene: 150-- 160℃

b). Polypropylene: 170-- 180 ℃

c). Polyolefine compound: 180--190℃

The flexibility of temperature adjustment can be increased along with the adjustable speed.

The red lamp lights after heating for a while indicating the required temperature is enough, then a trial of sealing can be done with a preset packing bag to determine the temperature, The speed and the pressure of the pattern roller need to be adjusted upon the sealing result to get an ideal sealing quality, and after that ,continuous sealing can be processed.

4. Determine if the blower needs turning on for cooling according to the thickness of the sealing material.(It should be turned on for common polyethylene etc.single layer plastic films).

5. The sealing part of the bag should be aligned flatly laid . Push the regulation place for the sealing sides in and at the moment, when the part is gripped by the sealing braids and self-moving forwards, neither pushing or stopping nor putting-in or pulling-out wit force can be done; otherwise uneven sealing or faults may result.

(7) WAY To MAINTAIN AND REPAIR

(1). Way to maintain

a). Push the driven wheel toward B and take out the sealing braid.

b).Change with a new braid and install the upper and lower lead belt.

c). Place the driven wheel and the heater and the cooler in their original positions.

d). Turn on the power to make the pulley rotated and the braid driven to move,then start a trial. The edge-deviation,ifany, on the sealing braid can be adjusted through the screw on the driven wheel.

e). Install the safety guard, then continuous operation can be done after heating.

g). In order to prolong the duration of the sealing braid, prior to stop the machine,return the rotating disk of temperature adjustment to zero place and turn on the blower, at the moment,the temperature pointer begins slow falling down but sealing braid is still running. It cannot be done to turn off the blower, the master power switch etc. until the temperature becomes under I OOC in minutes.

(2). Turbo case:

As an overall sealed turbo and worm unit, the turbo case has the features of low noise, lerge power etc. , oiled with 50g 20#oil only once month and cleaned and maintained only once a year calculated per 8 hours a shift in general when in use.

Cares should be taken to keep cleaned inside of the case when maintaining to avoid appearing noise.

(8) Troubleshooting:

Symptom	Cause	Solution
Deviation of seal	The driving wheel is not parallel to the driven wheel	Adjust the two screws on the driven wheel until it no longer deviates
Sealing tape breaks easily	1. The sealing tape is too tight. 2. Closure with running edge. 3. The closure has a crease. 4. There is adhered film or other dirt on the surface of the sealing tape. 5. The sealing tape is easy to burn	1.Adjust the longitudinal adjustment screw of the driven wheel seat so that the sealing belt is neither too tight nor too loose. 2. Refer to the above item. 3. Adjust or replace without creases. 4. Remove the adhesives and dirt on the surface of the sealing tape in time. 5. Adjust the gap between the heating blocks, or adjust to a suitable temperature if the temperature is too high
Knurling is not clear	1. The roller is worn out. 2. The compression spring of the roller seat is not pressed tightly	1. Replace the embossing wheel. 2. Adjust the compression spring of the embossing wheel seat.

There is resistance when the sealing belt is conveyed	Heating block or cooling block gap too small, too much friction	Adjust the heating block or cooling block to make the gap moderate. Generally, the gap between two sealed bags is about the thickness of one layer of packaging, which can ensure the sealing fastness and embossing clarity without extending the two ends of the sealing part. too long.
The packaging bag is stuck or turned when running to the middle pressing wheel or embossing wheel	Intermediate or embossing rollers are too tight.	1. The pressure of the wheel or embossing wheel should be adjusted properly, and the gap between the two sealing belts is about the thickness of one layer of packaging bags, which can ensure the sealing fastness and embossing clarity without extending the two ends of the sealing part too long. 2. After the clearance is completed, adjust the limit screw.

Conveyor belt deviation	Active rod axis is not parallel to passive spoke axis	Adjust the two conveyor belt tension adjustment knobs on the passive roller shaft (rear shaft) of the conveyor table to ensure that the two shafts are parallel, and at the same time ensure that the conveyor belt is too loose or too tight.
The conveyor belt is out of sync with the sealing belt	Conveyor belt is not tensioned	1. Properly tension the driving roller and the intermediate shaft conveyor belt so that they are fully in contact with the rollers. 2. Properly tighten the conveyor belt

Contact

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