



# CONTINUOUS SEALING MACHINE

MANUAL NO.11091



## 1. PRODUCT PURPOSE

The machine is suitable for sealing and bag-making with various plastic and compound films. It is widely used in food, pharmaceutical, chemical, cosmetics, local produce, vegetable seeds, electronic components, and other industries.

## 2. PERFORMANCE AND CHARACTERISTICS

Electronic thermostatic control and autotransportation device enable various plastic film bag shapes.

Key features: High efficiency continuous sealing, durable construction, user-friendly operation.

## 3. CONSTRUCTION AND WORKING PRINCIPLE

Components: Frame, speed regulator, sealing length regulator, temperature control, drive, transportation device.

Working principle:

Electrothermal component heats upper/lower heaters.

Adjust temperature/speed via control meter and regulator.

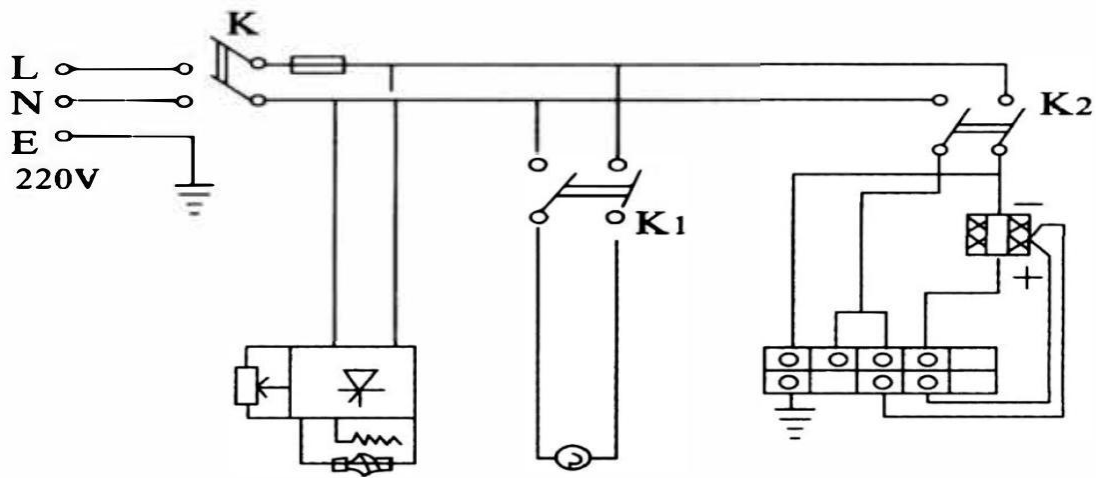
Plastic bag is conveyed, sealed by heated braids, cooled, and rolled by pattern roller/inker wheel.

Drive: Synchronized motor drives sealing braids, lead belt, and conveyor belt.

#### 4. MAIN SPECIFICATIONS

PARAMETER	VALUE
Power supply	110V, 60 Hz
Sealing speed	0–16 m/min
Sealing width	10mm
The maximum thickness of bags this machine can seal	0.6mm
Temp. range	0–400°C (adjustable)
Conveyor load	6.6 lbs

## 5. ELECTRICAL SCHEMATIC DRAWING

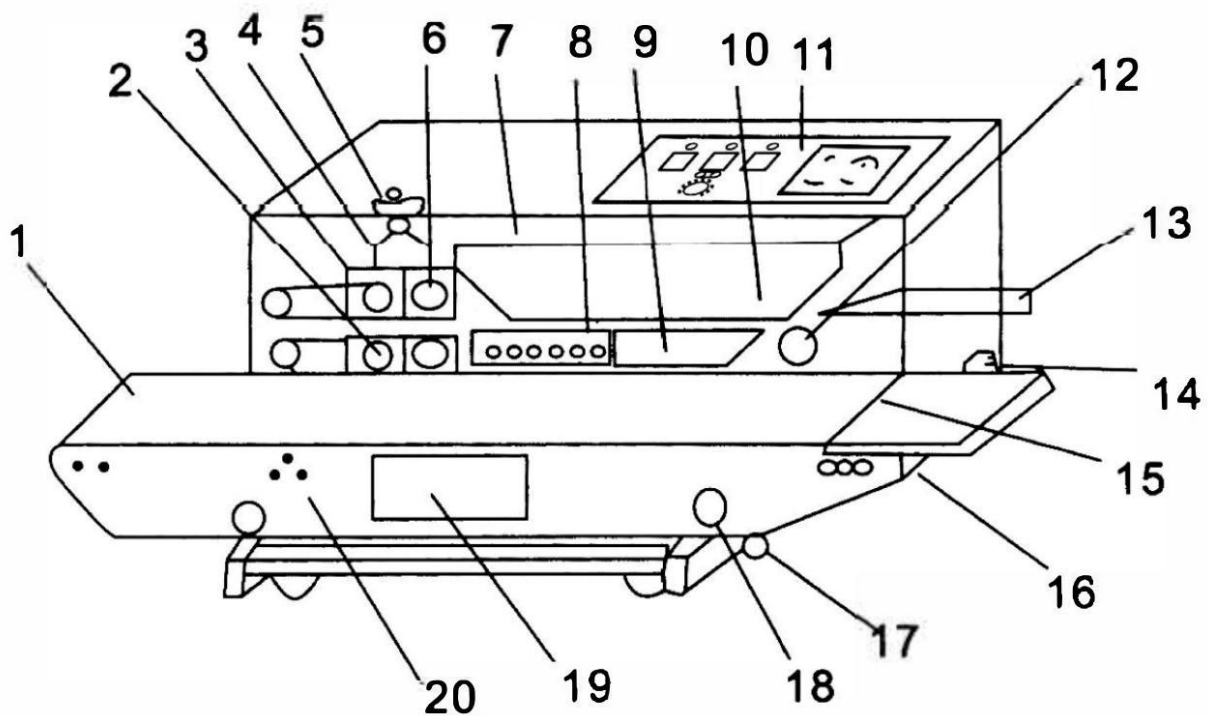


SYMBOL	NAME
K	Power supply switch
BX	Insurance tube
W	Potentiometer
SW	Speed regulating plate
D1	Motor
D2	Blower

SYMBOL	NAME
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 150°C.

D. When the temperature is set, you must press the SET button again, 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.

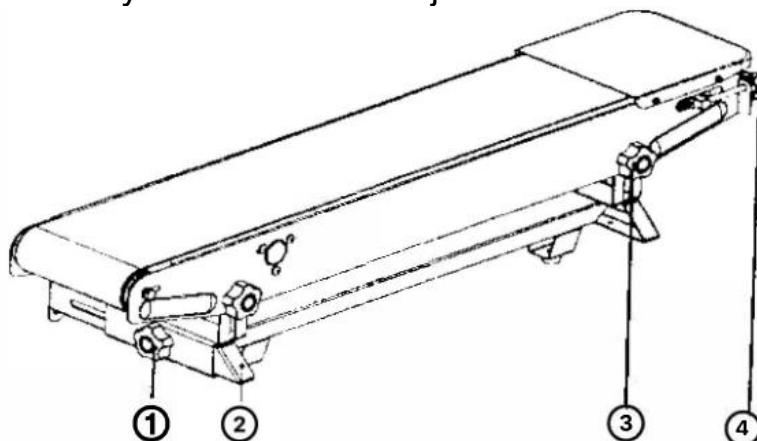
- ③ Adjust the height and the front-and-back position of the conveyor station to fit the size of the sealing bag.
- ④ Adjust the position of the guide place of sealing width regulation according to your requirements.
- ⑤ Adjust the spaces between the upper and lower heaters and the upper and lower coolers (i.e., the spaces between the sealing braids) according to the thickness of the sealing material.

#### (4) Adjustment methods for each component:

(Product design may be subject to optimization and adjustment without prior notice. If the manual is not updated in time, please refer to the actual product or contact official channels for the latest information)

I: The adjustment method for the conveyor belt:

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

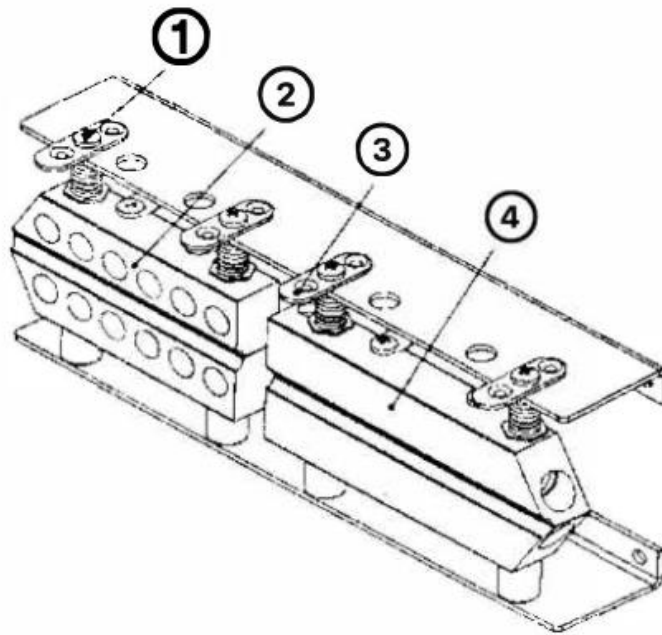


Conveyor belt tension adjustment: When the conveyor belt is too loose or too tight, turn the two "conveyor belt tension adjustment knobs" at the same time (right-handed for tension, left-handed for loosening) until the conveyor belt is tight enough.

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



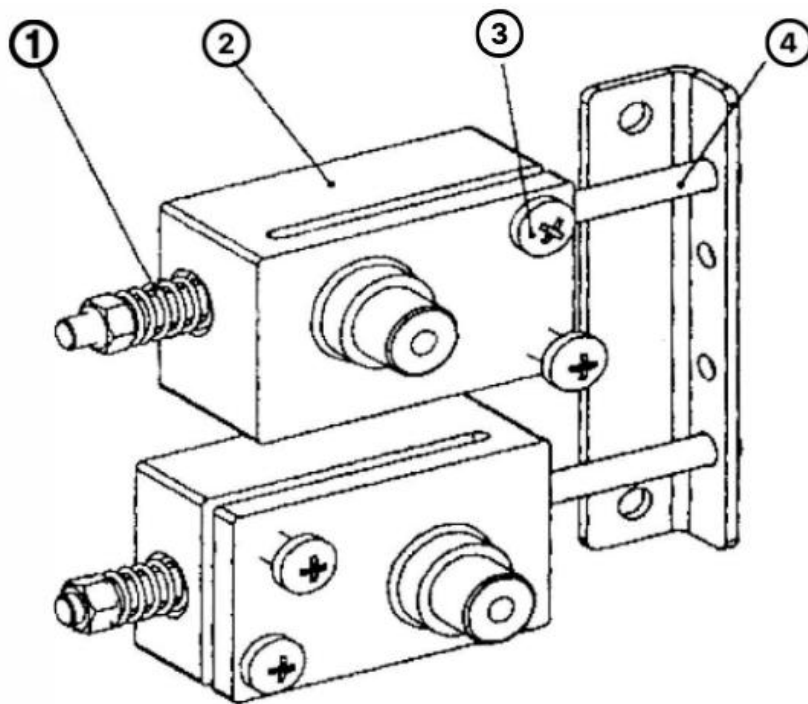
Adjustment of the distance between the upper and lower heating blocks and cooling blocks: Due to different sealing materials and their thickness, the distance between the upper and lower heating blocks and cooling blocks needs to be adjusted for each product that is sealed. This can be done by turning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

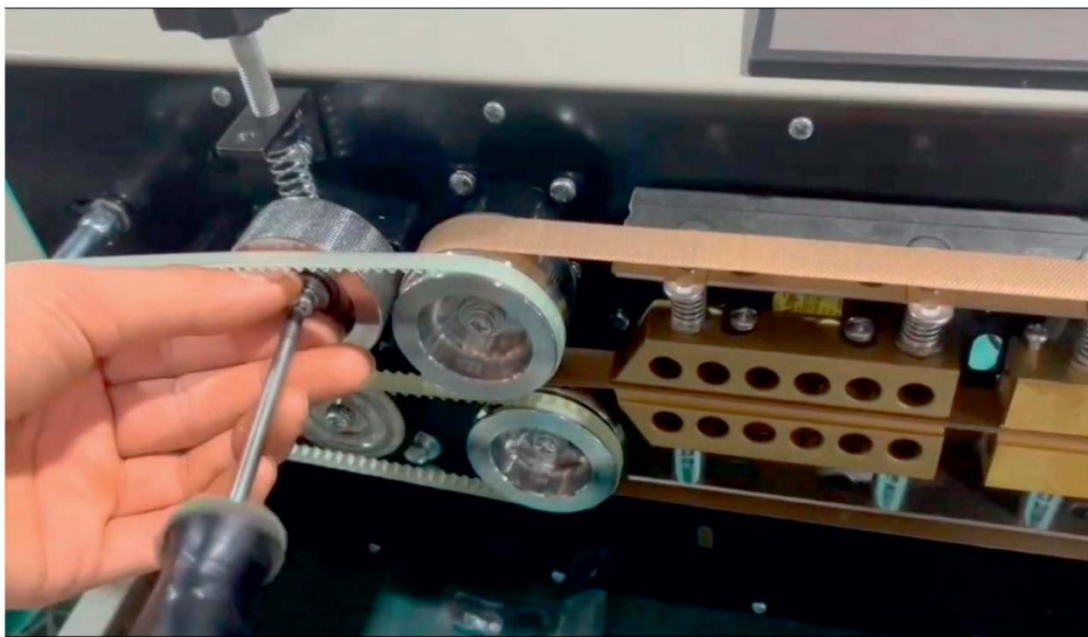
### III Passive pulley adjustment method:

- 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:

***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 prepared 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 the machine straight***

***away 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 (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 100 ° C, 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:

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