U.S. SOLID

CONTINUOUS SEALING MACHINE

MANUAL NO. 11383

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.

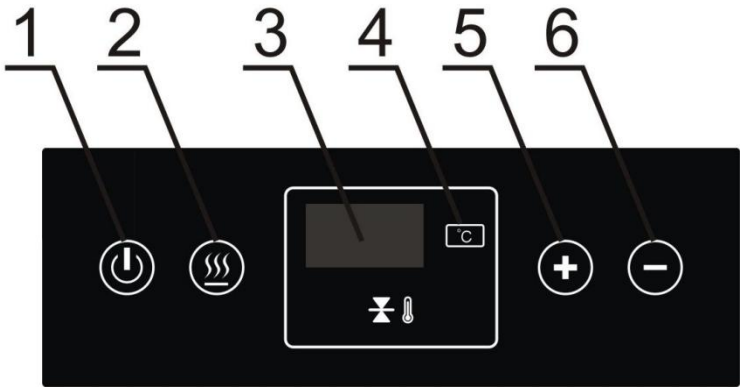
Adjust temperature/speed via control meter and regulator.

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

4. MAIN SPECIFICATIONS

PARAMETER	VALUE
Power supply	110V, 60 Hz
Sealing speed	7 m/min
Sealing width	10 mm
Temp. range	0–250°C (adjustable)
Temperatures suitable for different materials	LDPE material (0.03 - 0.16 mm), recommended 105 - 150°C。 MDPE material (0.04 - 0.12 mm), recommended 115 - 120°C。 HDPE material (0.04 - 0.09 mm), recommended 125 - 150°C。 PP material (0.04 - 0.06 mm), recommended 135 - 160°C。
Machine weight	11 lbs

5. NAME OF CONTROL BOX:



Number	Drawing	Name	Description
1		Power Switch	Used to turn the machine's power on or off
2		Heat-sealing Switch	Allows selection of turning the heat-sealing function on or off. Display
3		Display	In standby mode, it shows "□□□", which represents the current temperature value of the heating block; When it flashes "□□□", it indicates the set temperature value of the heating block; When it flashes "STD", it means the machine enters the

			preparation for shutdown state. When the temperature is below 50℃, the machine will automatically shut down.
4		Parameter Indicator Light	"℃" indicates the temperature value
5		Temperature Increase Button	Increases the temperature of the heating block
6		Temperature Decrease Button	Decreases the temperature of the heating block

6. START THE POWER SUPPLY

Danger! Electric shock hazard!

Please follow the safety operation procedures.

Start the machine's power supply by pressing the "Power Switch".

After the power is connected, the power - on indicator light on the control panel will light up, indicating that the machine is in standby mode and can be used.

7. Connect the power supply

Danger! Electric shock hazard!

Ensure that the socket used has a protective grounding wire.

Caution! Power mismatch may damage the machine!

Please check the machine's power parameters with reference to the machine nameplate.

Please follow the safety operation rules and national accident - prevention measures.

√ **Power supply/grounding**

* Check whether the voltage of the power supply used is consistent with the voltage specified on the machine nameplate.

* Ensure that the machine is correctly connected to a grounded socket to avoid fire or electric shock (the grounding wire is yellow - green double - colored).

* The cable must be able to move freely to avoid being squeezed.

* Once the cable is damaged, replace it immediately.

* When the machine malfunctions or requires maintenance, first cut off the power supply.

* If the machine is to be idle for a period of time, retract the cable.

√ Machine startup procedure

* Connect the power supply and press the power switch. The indicator light will turn on, and each transmission part will run synchronously.

* Adjust the embossing wheel knob slightly, rotate the embossing wheel, and adjust to an appropriate pressure.

* Press the heat - sealing switch and adjust the control panel to the required temperature according to the material and thickness of the packaging bag.

* The sealing edge of the packaging bag should be aligned and flattened. Feed the bag mouth flat to the adjustment position (feed port). When the sealing edge is bitten by the sealing belt, the packaging bag will move forward automatically. Do not arbitrarily push or block it at this time, otherwise it will cause wrinkles or malfunctions at the sealing edge.

* When it is found that the sealing belt and the heating block are adhered with foreign matter, stop the machine for cleaning. Do not remove it directly by hand when the temperature is too high.

√ **Machine shutdown operation**

Press the power switch. After the temperature drops below 50°C, the machine will automatically turn off.

8. STANDARD OPERATION & PARAMETER SETTINGS

 Caution! Risk of Injury!

Please operate the machine in accordance with this instruction manual. Do not remove necessary protective covers or casings.

 Caution! Pinch Hazard!

When the machine is running, do not put your hands into the transmission wheels to avoid being pinched!

 Caution! Scald Hazard!

When the machine is running, do not put your hands into the transmission wheels to avoid being pinched!

9. PREPARATION, ADJUSTMENT, AND INSPECTION BEFORE OPERATION

① Electrical Safety

This machine is equipped with a three-prong grounded plug. Ensure the power supply is properly grounded to prevent electric shock hazards.

② Preheating Procedure

For initial use or after long periods of inactivity, preheat the machine at low temperature for several minutes to remove moisture from the heating elements before normal operation.

③ Position Adjustment

Adjust the infeed guide (feeding port) according to the distance from the sealing line to the bag edge to ensure proper alignment.

④ Gap Adjustment for Sealing Blocks

Adjust the gap between the upper/lower heating blocks and cooling blocks based on the material type and thickness:

※ Use the knurled nuts to adjust pressure between the sealing belts:

* Clockwise rotation: Increase gap (loosen pressure).
* Counterclockwise rotation: Decrease gap (tighten pressure).

※ Recommended gap: Approximately the thickness of one packaging layer. Ensure firm seals and clear embossing without

excessive stretching at the seal edges.

10. 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.

11. MAINTAINING

Danger! Electric shock hazard!

Before maintaining the machine, the power supply must be completely disconnected.

To extend the product's service life, prevent malfunctions, and achieve the best packaging results, daily maintenance of the machine is necessary. If the machine is used frequently (more than 4 hours a day), it is recommended to conduct professional maintenance every three months. If the daily usage is no more than 4 hours, a complete maintenance should be carried out every six months (depending on the site, environment, and products).

However, some users can perform simple maintenance work on the product according to their own needs. The maintenance work is as follows:

① Maintenance Precautions

* Before performing maintenance, completely disconnect the machine from the power supply and unplug the power cord from the wall socket.

* If the machine operates abnormally or makes unusual noises, turn off the power immediately and contact the manufacturer or

supplier.

* Do not use high-pressure water to clean the machine, as this will severely damage its electronic components and other parts.

* Prevent water from entering the machine's control panel, as it may cause circuit damage.

* The manufacturer shall not be liable for machine malfunctions or damage caused by failure to follow the maintenance instructions in this manual.

② **Maintenance Schedule**

Maintenance Stage	Maintenance Content
Daily Maintenance Items	1. Use a brush to remove the attachments generated on the sealing belt during operation. 2. Check for any noise or abnormal sounds during the motor - running process.
Monthly Maintenance Items	1. Check whether the sealing belt is damaged.
Semi - annual Maintenance Items	1. Apply lubricating grease to the meshing parts of the exposed gears for lubrication.

Annual Maintenance Items	1. Conduct a general inspection according to the above items. 2. Check whether the rubber wheels are aged. Replace the rubber wheels if the aging is severe. 3. Check the heating - up time of the temperature controller. Consider replacing it if it takes more than ten minutes to reach the set value. 4. Check whether the electrical components such as switches and fans operate normally. 5. Inspect the gears and shafts in the transmission part and apply lubricating grease. Replace the severely worn parts if necessary. 6. Clean the worm gear box and replace the lubricating oil (Great Wall Brand 000# Extreme - pressure Lithium Grease Lubricating Oil).

12. ANALYSIS AND TROUBLESHOOTING OF FAULTS

Fault Phenomenon	**Cause Analysis**	**Troubleshooting Method**
Not working	1. Power supply not connected.	1. Check the power socket.
	2. Fuse blown.	2. Replace the fuse.
	3. Upper shield in open state.	3. Keep the upper shield closed when the machine is working.
Sealing belt easy to break	1. Sealing belt is too tight.	1. Adjust the longitudinal adjusting screw of the driven wheel seat to make the sealing belt tight but not too tight.
	2. Sealing belt runs off track.	2. (See the above.)
	3. Sealing belt has creases.	3. Ensure the sealing belt has no creases.
	4. Sealing belt has adhered films or other contaminants on the surface.	4. Timely remove the attachments on the surface of the sealing belt.

Unclear embossing	1. Embossing wheel is worn.	1. Replace the embossing wheel.
	2. The pressure spring of the embossing wheel seat is not tight enough.	2. Adjust the pressure spring of the embossing wheel.
Resistance during sealing belt transportation	1. The gap between the heating block or cooling block is too small, resulting in excessive friction.	1. The gap between the heating block or cooling block should be appropriate, so that the gap between the two sealing belts is approximately the thickness of one layer of packaging bag. It should ensure the sealing firmness and the clarity of embossing, and at the same time, prevent the two ends of the sealing part from extending too long.
The packaging bag is blocked or folded when running to the embossing wheel	1. The embossing wheel is pressed too tightly.	1. The pressure of the embossing wheel should be adjusted properly, so that the gap between the two sealing belts is approximately the thickness of one layer of packaging bag. It should ensure the sealing firmness and the clarity of embossing, and at the same time, prevent the two ends of the sealing part from extending too long.

A. If the machine has the phenomenon that the sealing temperature keeps rising when the heating switch is not turned on after startup, or the sealing temperature rises above 270°C. B. The equipment enters "std" - forced heating shutdown state when the heating switch is not turned off.	1. The thyristor on the circuit board is short-circuited internally.	1. Replace the circuit board.

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