# Automatic Continuous Sealing Machine

MANUAL NO.10525

## 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 temperature of both upper

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, 50~60 HZ

Power: 770 W

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

Sealing width: 6 ~ 12mm (adjustable)

Temp. range: 0 ~ 300°C(adjustable)

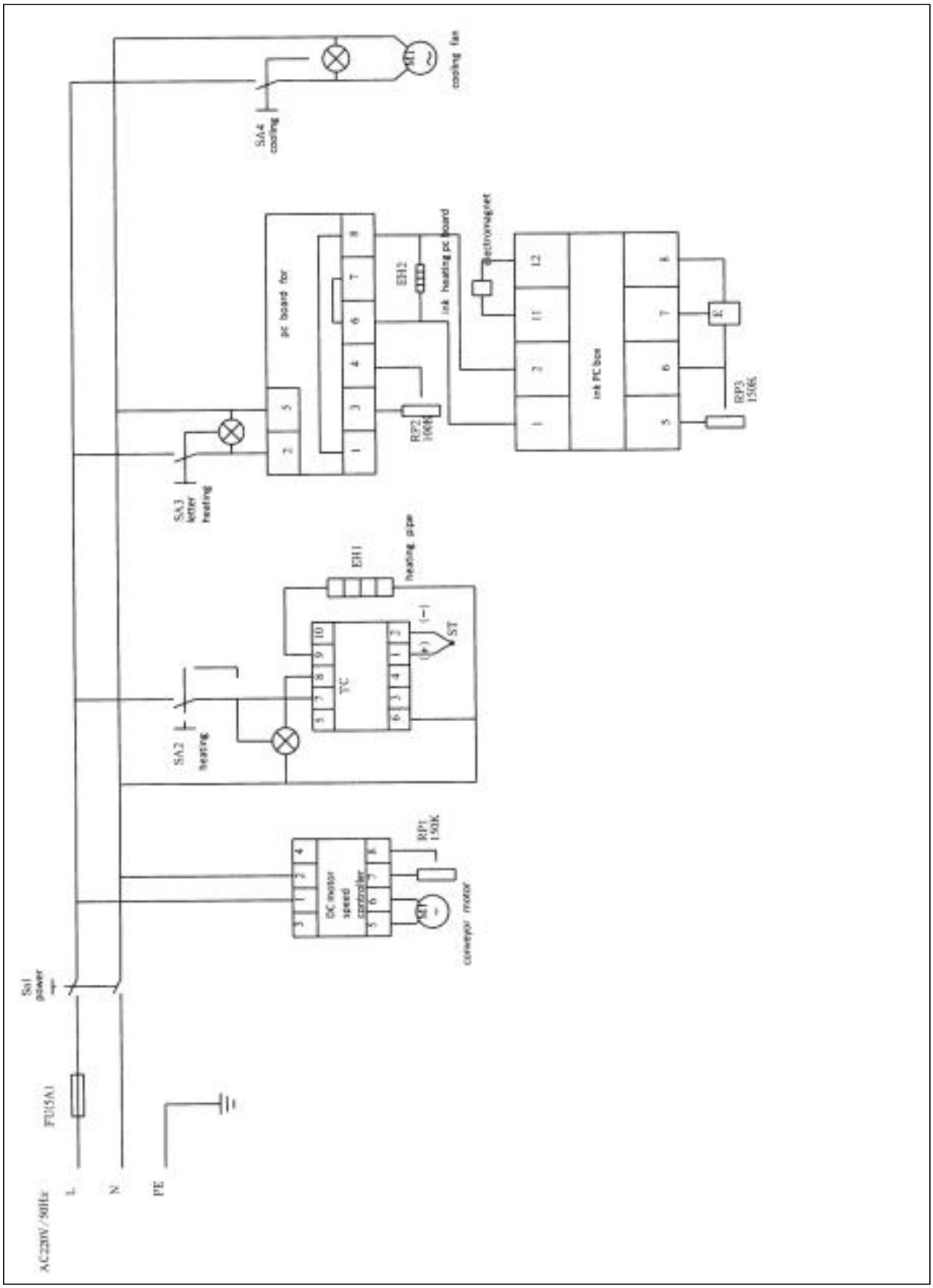
Single Layer Maximum Film Thickness: ⩽0.08

Conveyor Table Maximum Load: ⩽3kgs

Machine Weight: 25kgs

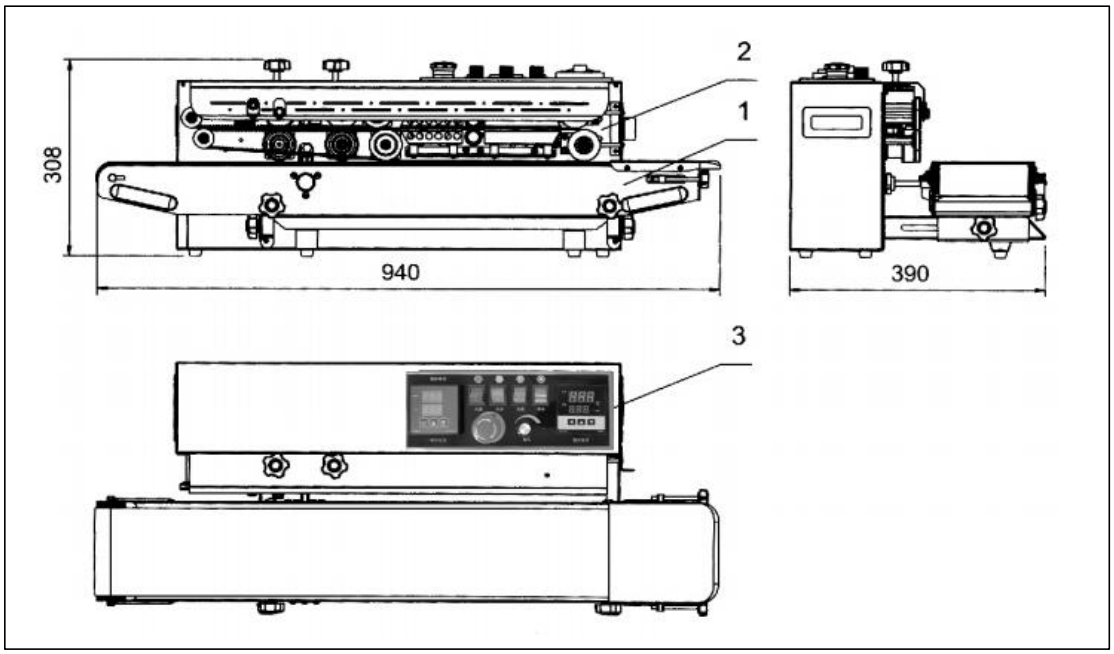
No. of printing words: 13

# 5. ELECTRICAL SCHEMATIC DRAWING



## 6. MAIN STRUCTURE AND WORKING PRINCIPLE & ADJUSTMENT METHOD

● Key Components:




1. Conveyor system
2. Sealing mechanism (heating/cooling blocks, embossing wheel)
3. Control panel

● Working Principle

After being connected to the power supply, each device begins to work, the electro - thermal parts generate heat to heat up bottom and up heating block rapidly. When the temperature reaches at the setting temperature of temperature controller, putting the sealing part of plastic bag into the position between two sealing belts,

then it conveys into the heating area which among bottom and up heating block, the plastic sealing part will be sealed by melt through heating and extruding by roller. Then it will convey into cooling area to get into form, to make plastic bag sealing parts with stripe or reticulate (or dates ) by embossing wheel rolling.

## ● Adjustment methods for each component:

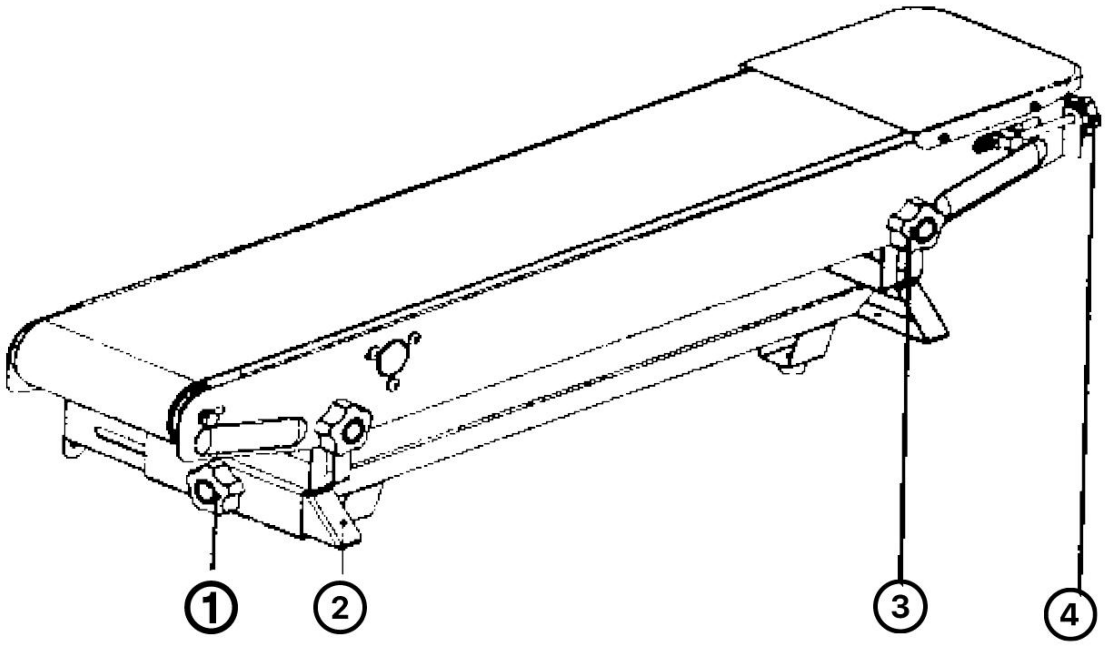
**I: The adjustment method for the conveyor belt:**

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.

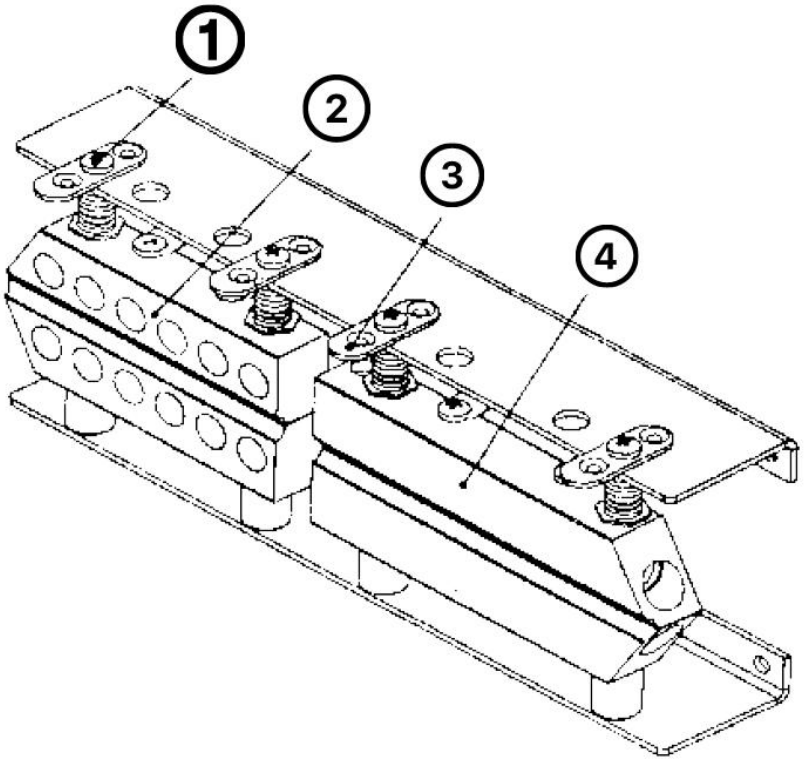
## Ⅱ: Adjusting the sealing section

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.

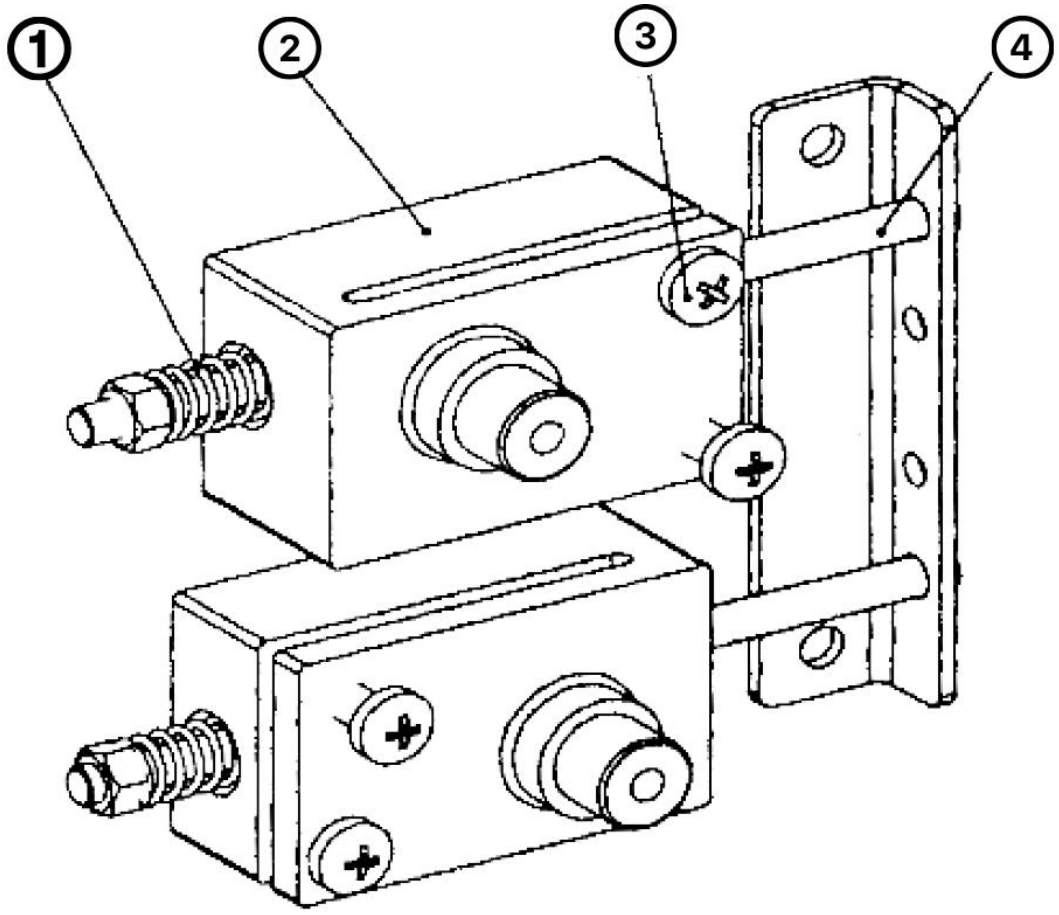
**III Passive pulley adjustment method:**

① Spring

② Passive wheel seat

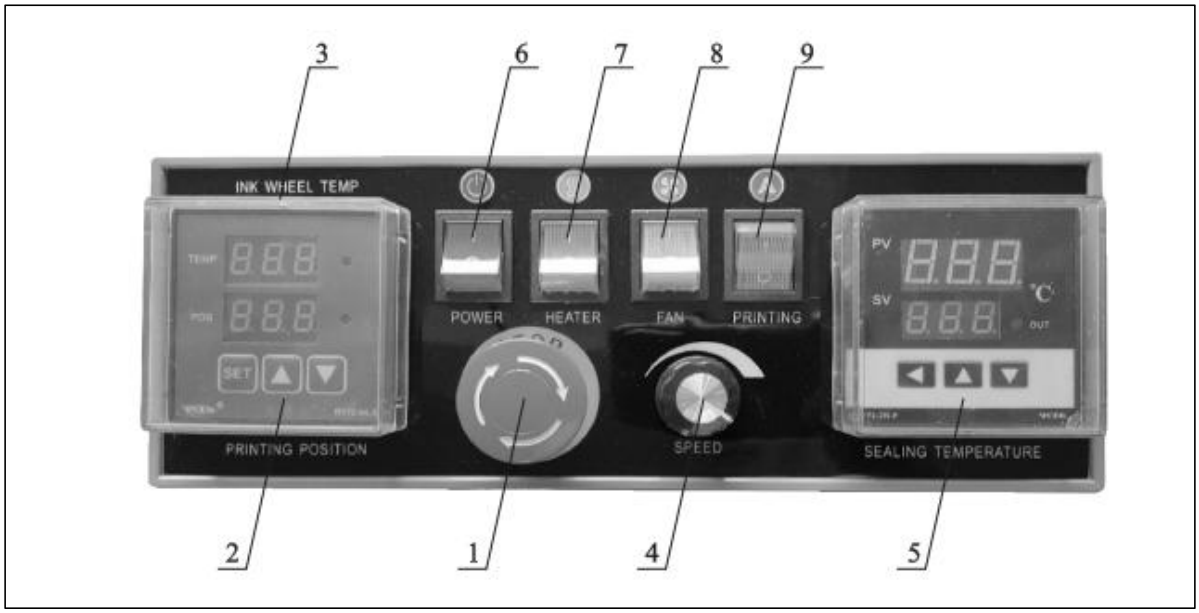
③ Adjustment screw

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.

## 7. PANEL FUNCTION DECLARATION:




① Urgent stop switch: under emergency status, disconnect the power supply. (In the case of first use, if the machine does not run after turning on the power, turn the emergency switch upward to start the machine)

② Sealing speed: adjust the running speed of sealing belts.

③ Printing temperature adjustment: Adjusting temperature of solid-ink roller heating block.

④ Printing position adjustment: Adjusting the position of solid ink coding.

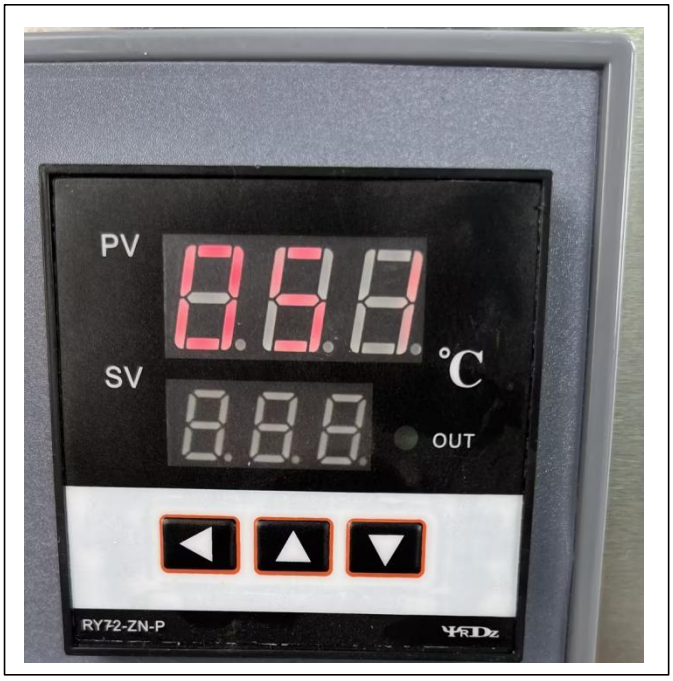
⑤ Sealing temperature adjustment: adjust and control the temperature of heating block.

⑥ Power switch: Control the whole machine on or off.

⑦ Sealing heating: Control the power of heating block on or off.

⑧ Cooling: Control the cooling fan on or off.

⑨ Printing heating: Control the solid ink heating block on or off.




A. The number displayed by PV indicates the current actual temperature. The number next to SV indicates the temperature we set.

B. Press the ◀ key on the left, and the number below will flash.

C. Then press the ▲ key to increase or the ▼ key to decrease, and set the required temperature for the corresponding digit. This temperature needs to be set according to the thickness of the plastic film, and the set temperature is usually about 150°C.


TEMP shows the set temperature of the ink wheel, and it is recommended to set it between 80-100. POS shows the position of the text. The larger the number is, the closer the text position is to the right side of the bag. (Adjust the appropriate position according to the width of the bag).

Operation: Press SET first, and the number next to TEMP will flash, and you can increase or decrease the temperature by using the up and down arrows. If you want to set the position of the text, press SET again, and the number next to POS will flash, and you can increase or decrease the spacing by using the up and down arrows.

## 8. HOW TO INSTALL THE TWO WHEELS AND THE VERTICAL RACK （For the detailed installation process, you can refer to the video on the product details page or contact our customer service to obtain the video）：

① **Replace the ink wheel:**

Remove the cover plate of the machine, and pull out the ink wheel. Use a tool or your hand to remove the cover on the top of the ink wheel. Remove the black and milky white parts. Replace them with the new parts in the accessory bag, install them, and insert them back into the original position.

②**Replace the letter wheel:**

Use a tool to remove the letter wheel, remove the soft rubber at the fixed position of the letter wheel, install the characters in the letter wheel box according to the required position. Then fix it back to the original position with screws.

**③Install the vertical rack:**

- Remove the two yellow-black knobs on the side of the machine, and take off the conveyor belt part.
- Remove the rotating shaft on the conveyor belt.
- Take out a rotating shaft with a black shell from the accessories, remove the black cover on the rotating shaft, and then install this rotating shaft onto the rotating shaft of the original machine. (Embed the rotating shaft into the groove of the gear.) Then fix it with the screws in the accessories.
- Remove the four foot pads at the bottom of the machine.
- Take out 2 L-shaped brackets from the accessories, and install the 4 removed foot pads on them.
- Take out the crossbar bracket from the accessories, and fix and connect the two L-shaped brackets with screws.
- After the stand is assembled, take out 2 new yellow-black knobs from the accessories and install the machine base on the stand. (There are 4 new yellow-black knobs in the accessory bag. Take out 2 knobs that are different in appearance from the previously removed yellow-black knobs.)
- Turn the machine over, use the special tool in the accessories to loosen the connection holes on the machine counterclockwise, and adjust the hole positions downward.

- Remove the 2 foot pads on the main unit.
- Invert the machine, and install the conveyor belt part onto the machine. Insert the rotating shaft into the connection hole that has just been adjusted. And rotate the rotating shaft to align it with the groove inside the connection hole.
- Take out the yellow-black knob of the machine base that was removed at the beginning and 2 yellow-black knobs of the same appearance as it from the accessory bag (4 in total). Fix them on both sides of the stand with screws to adjust the distance between the main unit and the conveyor belt.
- Loosen the two knobs at the bottom of the machine base to adjust the position of the conveyor belt, so that the connecting rod is perpendicular to the machine.
- Tighten the connection hole and install the inlet adjustment plate.

## 9.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.

- When using the machine for the first time, turn the emergency stop button according to the arrow direction. Then turn on the 4 buttons. Use the SPEED knob to adjust the speed of the conveyor belt.

- Use the SEALING TEMPERATURE control panel to adjust the sealing temperature (the number beside SV). Press the ◀ key to set the value of the position to be adjusted. Each press moves one digit to the left. The up and down keys are used to adjust the size of the value. After 2 seconds without any operation, the machine will run according to the temperature

you adjusted. (It is recommended to control it within 180 degrees Celsius.)

- Set the INK WHEEL TEMP. First press the SET key to select to set the temperature (TEMP) or the position of the character (POS). Use the up and down keys to adjust the value.
  TEMP corresponds to the heating temperature of the ink wheel (it is recommended to be between 80 and 100). After the machine is turned on, give the ink wheel a preheating time. Test the machine more, and the characters printed on the bag will become clearer and clearer.
  POS corresponds to the number at the position of the value. The larger the value, the closer the characters are to the right side of the bag. Press the SET key again after setting to confirm the value.

## 10. 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.

## 11. 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.<br>2. Too close to the running edge.<br>3. The closure has a crease.<br>4. There is film or other dirt on the surface of the sealing tape.<br>5. The sealing tape burns easily. | 1. Adjust the longitudinal adjustment screw of the driven wheel seat so that the sealing belt is neither too tight nor too loose.<br>2. Refer to the above item.<br>3. Adjust or replace without creases.<br>4. Remove the adhesive or dirt from the surface of the sealing tape.<br>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.<br>2. The compression spring of the roller seat is not pressed tightly | 1. Replace the embossing wheel.<br>2. Adjust the compression spring of the embossing wheel seat. |

| | | |
|---|---|---|
| There is resistance when the sealing belt is conveyed. | The heating block or cooling block gap is too small which is generating too much friction. | Adjust the heating block or cooling block to make a moderate gap. 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. |
| 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. This ensures the sealing fastness and embossing clarity without extending the two ends of the sealing part.<br>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. At the same time, ensure that the conveyor belt is not 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.<br>2. Properly tighten the conveyor belt. |

Contact：

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