



ELECTRIC STRAPPING MACHINE

MANUAL NO. 8336



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SAFETY INSTRUCTION

Please read the matters carefully, if not follow this prompt, it is possible to cause operator injury during operation.

1.1 Battery operation

Environmental protection:

- 1) Please do not put used batteries into household trash can, waste water tank, or burn them.
- 2) Dealers provide battery environmental treatment services.

Short circuit

- 1) Do not leave batteries and other metal objects together.
- 2) Do not open the battery, and store the battery in a dry and anti-frost room. Maximum temperature is 50 C. Please keep dry all the time.
- 3) Do not charge waste battery. Change a new one immediately.

1.2 Eye injury hazard

If you do not wear safety glasses with side shields, it may cause eye damage and even blindness. It requires wearing safety glasses with side shields.

1.3 Operation

Personnel who are not properly trained are not allowed to operate the strapping tool. Before straining straps read and correctly understand the operating instructions. If you do not follow the operating instructions or improperly load the straps, it will cause straps damaged. Please keep your fingers far away from squeezing or cutting areas. Before being familiar with the strapping tool.

1.4 Adhesion position

You should check the pressured adhesion position. Be familiar with adhesion control and regulation. Irregular adhesion may be insecure, which cause serious injury. Please do not ship the packing containers which are not correctly packaged.

1.5 Straps distribution

Please use the specially designed distributing device to distribute the straps. When not in use, please fold the strap end into the distributing device.

1.6 Straps warning

Do not use straps to drag or lift load, which easily lead to personal injury.

1.7 Straps broken hazard

Improper operation, excessive tensioning, using straps not as requires, load sharp corner will cause tightening force lose, or straps broken could eventually:

The operator loses his balance and falls down.

Strapping tool and straps together quickly fly to the operator's face.

Attention:

- 1) If the load angle is very sharp, please add edge protection.
- 2) Please wind the straps around the suitable load surface.
- 3) When tensioning and adhesion, operating personnel and straps are on the same straight line, there may be hurt by flying straps or strapping tool, so when operating please stand Beside straps and keep spectators far away. Please use recommended straps with good quality in the instruction, with a suitable width, size, and strength. Straps that do not match may cause damage when tensioning.

1.8 Tensioning straps shearing

When shearing straps, please use a suitable shearing tool, and ensure a safe distance with people, and do not stand on the same straight line with straps, and keep away from the straps loose direction. Please use the special tool for shearing the straps. It is not allowed to use a hammer, pliers, hacksaw, axes and so on.

1.9 Fall hazard

Keep your work area clean and tidy. Untidy work area is likely to cause damage hazard. Before tensioning, bad stay or unbalance will be easy to fall, especially in the stair area. So keep body balance. Both feet shall tread on a flat and solid surface. When you feel uncomfortable, do not operate the tool. Please pay attention to the precautions specifically mentioned in work area.

1.10 Strapping tool hazard

- 1) Well-maintained strapping tool is necessary.
- 2) Periodically inspect broken or worn parts, if there are cracking or worn parts, do not use the machine.
- 3) Do not modify the machine, or else it may cause personal injury.

TECHNICAL PARAMETERS

2.1 Description

Manufactured strapping tool is using plastic straps. Manually use strap feeding device to wind the plastic straps around the box (bag). Straps end is inserted into strapping tool and automatically tensioned, separate after friction adhesion.

2.2 Size of strapping tool with battery

Length: 370mm

width: 140mm

Height: 135mm

Weight: 3.4kg

Battery weight: 0.6kg

2.3 Straps material

Quality: flat or embossed PET (polyester) and PP (polypropylene) straps.

Applicable size : 1/2inch -5/8 inch (width)

0.4mm-1.20mm (thickness)

Please choose the appropriate size according to strapping tool you purchased.

2.4 Straps strength

Tensile strength: 400-3500N adjustable.

(Maximum value depends on the quality of straps.)

Tensioning speed: 100-200mm/s

Adhesive strength: about 75%of plastic straps.


(Depending on the quality of straps)

2.5 Working temperature

Ambient air temperature is 41°F— 113°F.

Optimum working temperature is 59°F — 68°F.

ACCESSORY

 Please use the parts and accessories that mentioned in the operating instructions.

To use other accessories may hurt you and others.

3.1 Battery powered strapping tool

As some strapping tools may use NiCd (nickel cadmium) or NiMH (nickel metal hydride) batteries, please purchase the battery for this tool according to the following parameters.

Type: Lithium battery

Voltage: 18V

Capacity: 5.0Ah

3.2 Battery charger

Standard charger:

INPUT: 50/60Hz, 100-240V

OUTPUT: 10.8-18V Max DC == 3.5A

Charging time:

Lithium battery 5.0A/h, charging time is approximately 90 minutes.

OPERATING ELEMENTS



Diode status indication	
Green	Normal working
Red flashing	Low battery, please charge
Red on	Machine failure, power off inspection
Purple on	Work finish

OPERATION

5.1 Installation


- 1) Please do not put the strapping tools in the rain!
- 2) For security, the battery is not charged when delivery.
- 3) Before using, please charge.

Insert the battery:

- 1) Push the battery box cover assembly upward by arrow direction, and insert the battery into slot from up to down.
- 2) When inserting the battery, electric quantity state will show for a short time.
- 3) Battery charge status is displayed by the LED indicator.

If LED flashes in red when tensioning or welding, which indicates that the battery power runs out, all electrical functions will be stopped.

Adhesion insufficient

 Warning: If the adhesion is not sufficient, please remove the straps! The battery must be charged.



5.2 Operation function description

5.2.1 Switching between normal mode and flexible mode: in normal mode (H--): press the tightening gear button for 3s to enter the flexible mode (L--). There are 9 gears in the flexible mode, with the tension range of 400-1600N; in the flexible mode, press the tension gear button for 3s to switch into the normal mode (H--).

5.2.2 Mode adjustment: press the MODE key for short time, and the three modes (AUT/ SEM / MAN) can be selected circularly.

5.2.2.1 in AUT mode, press the tension button for a short time, and the belt will be automatically tightened. When the set tension value is reached, the belt will be welded and cut automatically;

5.2.2.2 in the semi-automatic mode (SEM), it is necessary to press and hold the tension button all the time. When the set tension value is reached, the machine will start automatic welding and cutting. (if the take-up button is released during tightening, the tension wheel will stop rotating. Press the welding button at this time, and the baler will start to weld and cut the belt.)

5.2.2.3 when manual mode (MAN) is used, the tension button shall be pressed and pressed all the time. When the set pull value is reached, the fusion button must be pressed, and the beft shall be fused and cut manually.

5.2.3 Tension adjustment: press SET key briefly to adjust the tension gear (9 gears are used in a total, the tension in the first gear is the minimum and the tension in the ninth gear is the maximum).

5.2.4 Welding time adjustment: Press INC key in a short time, and weld time will be longer: press DEC key in a short time to reduce the welding time (the adjustment range is 0. 1s each time, and the value display interval is 0.5-3.5s).

5.2.5 Display of cumulative welding times (six digits): after unlocking, press mode selection button (MODE) for more than 3s, and the interface displays XXX (decimal point is displayed on the right end of digital tube), indicating the value of hundreds, tens and digits of welding cumulative times, and then press MODE to display XXX (no decimal point is displayed on the right end of digital tube), indicating 100,000 and 10,000 1,000 values digits of

accumulated welding times, press MODE to cycle the display of values, and press any other key to return to the main interface.



Note: The machine settings:

1. In the no-packing operation state after 120 seconds , the machine will get into sleep. If you want to wake it up, please press the tensioning button gently (the silver button on the right side of the handle). The machine will enter the working state .
2. In flexible mode, the tension force and tension speed decrease. which is suitable for PP belt packaging.
3. Unlock operation: It will be automatically locked after 30 seconds without any operation on the machine, first long press the "DEC" button for two seconds, the machine prompts the sound to start, and then press the welding button (the silver button on the left side of the handle).

Wake up the machine



In the no-packing operation state after 120 seconds , the machine will get into sleep. If you want to wake it up, **please press the tensioning button** (the silver button on the right side of the handle). The machine will enter the working state .

Unlock operation




It will be automatically locked after 30 seconds without any operation .

If you want to unlock the machine, **first long press the "DEC" button for two seconds**, the machine prompts the sound to start, and **then press the welding button** (the silver button on the left side of the handle).

a. Straps winding

Wind the straps as shown in the figure.

 Warning! Keep away from oil, grease and other dirt when welding plastic straps. Dirty straps can't be welded.



b. Straps inserting


Lift the handle with your right hand, insert straps with left hand stack the two pieces horizontally, release the handle.



c. Straps tensioning

Press the tensioning button, after reaching straps tensioning strength, then release the switch knob.

Remark: Press tensioning button all the time until the LED displays in purple, tightening protection doesn't affect next step.

 Keep strapping tools equilibrium shifting when tensioning. So please do not obstruct moving direction of the strapping tool.



d. Contact adhesion

Press welding button, the hands leave immediately, plastic strap is welded and the redundant straps are cut off.

During welding, LED displays in green or purple. Welding is completed.



e. Remove strapping tool

Lift the handle and loose straps, pull the machine to right side and away from the straps.

Remark: Automatic mode, only need to operate a, b, c, e.

When the strapping machine is stuck and not moving, you must first pull out the battery, then cut the strapping strap, remove the panel screws, and then remove the strapping strap.



5.3 Adhesion control

Correct adhesion:

Weld the entire width of strap, the welding length is about 19 mm.

A small amount of molten plastic is allowed to overflow the edge.



Welding time is too short:

The entire width is not welded and the adhesion is insufficient.

⚠ WARNING! Straps with insufficient welding must be removed. Adjust the welding time.



Welding time is too long:

Such as if welding time is too long, straps are overheated, molten plastic overflow two sides. Adhesion effect is affected.

⚠ WARNING! Straps with not enough adhesive strength must be removed. Adjust the welding time.



WORN PARTS REPLACEMENT

 **Every time maintenance, please remove the battery.**

Cutter: first remove the left shield screw and remove it. Then remove the screw on the cutter and remove it. Take out the cutter, Keep the cutter spring; install in reverse order.

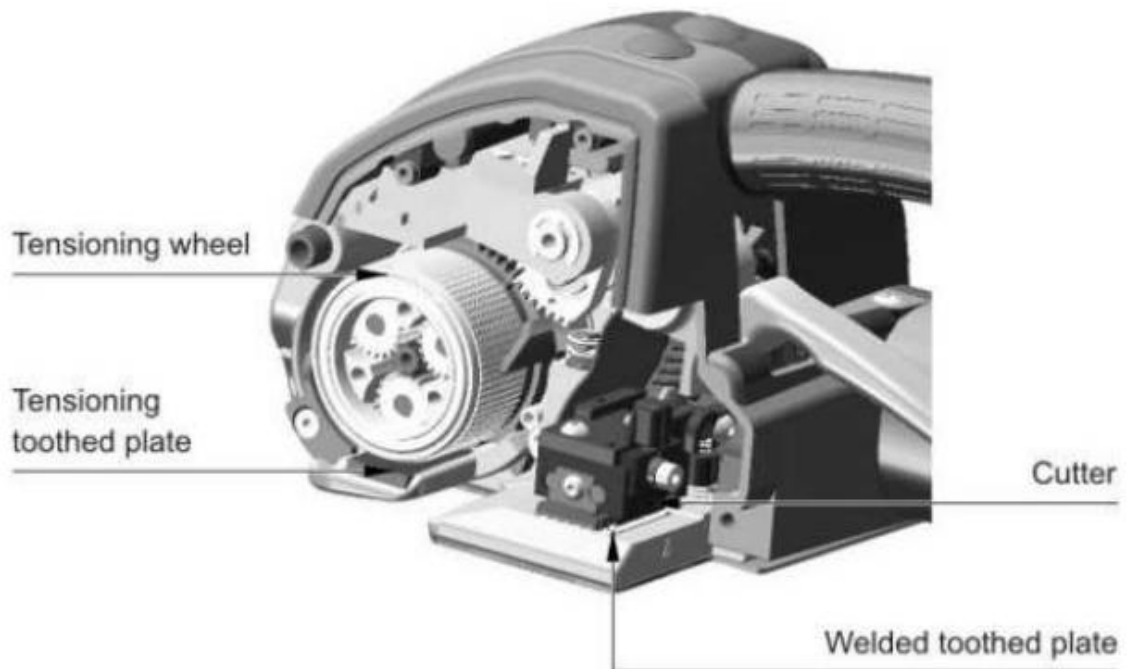
Welding tooth plate: remove the fixing screw of the fusion lower tooth plate to remove the fusion lower tooth plate; install in the opposite order.

Tensioning toothed plate: remove the screw fixing the toothed plate on the base, lift the handle to take out the toothed plate for replacement, and install it in the reverse order.

Tensioning wheel: first remove the left cover screw and remove it, then take out the tension wheel, and then take out the two bearings on the tension wheel; install in reverse order.

Cutting belt adjustment

Cutter adjustment: if the cutting belt is not smooth, replace the cutter or cutter spring. Refer to the above vulnerable parts for replacement.



COMMON FAULTS

1. Special reason: If the machine stuck in strapping process, which results straps stuck in the machine and can't be removed.

Immediately cut off power, cut the straps, remove the screws on the left and right panel covers and move, remove the straps, and check the machine. Check the lines on travel switch fall off and replace micro switch.

2. Press the welding and tensioning button, if motor doesn't rotate, check the motor and micro switch, and replace the motor and micro switch.

Machine fault code description:

E0.2	Tape take-up and tensioning motor timeout fault (not completed for more than 10 seconds)
E0.3	Belt take-up and tensioning motor short circuit fault
E0.4	Abnormal hall fault of take-up and tensioning motor / abnormal current induction fault of take-up and tensioning motor
E0.5	Bonding and welding motor short circuit fault
E0.6	Hall fault of adhesive welding motor / abnormal current induction fault of adhesive welding motor.
E1.0	Fault that the motor still outputs torque when the speed is 0 RPM /motor locked rotor fault
E1.1	Overcurrent protection
In case of the above fault display, you can press any key to eliminate it and enter the standby mode. If it cannot return to normal, please contact the supplier for solution.	

Contact

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