

# user's manual

Please read the following carefully before using the machine

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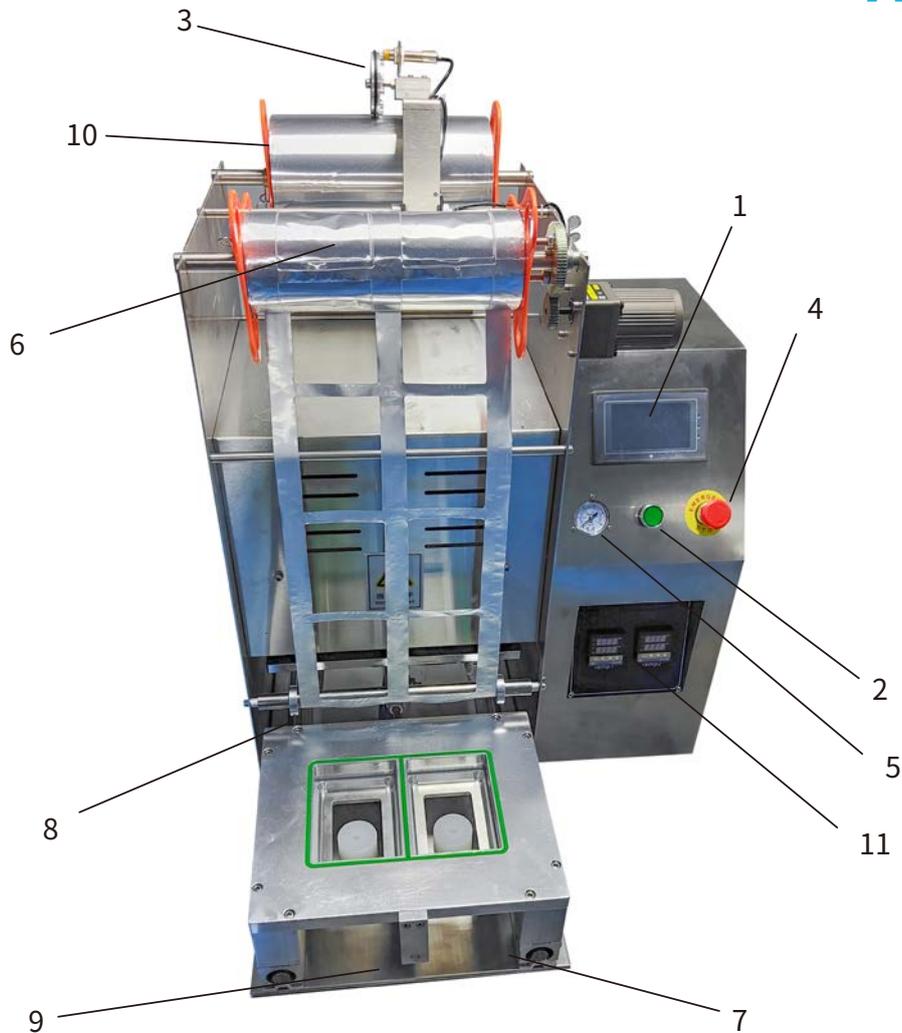
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## New high with automatic sealing machine illustration

- |                     |                  |                    |
|---------------------|------------------|--------------------|
| 1.HM                | 5.barometer      | 9.Top box cylinder |
| 2.start up button   | 6.Film end       | 10.Film end        |
| 3.Photoelectric eye | 7.Traction screw |                    |
| 4.emergency button  | 8.Guide wheel    |                    |

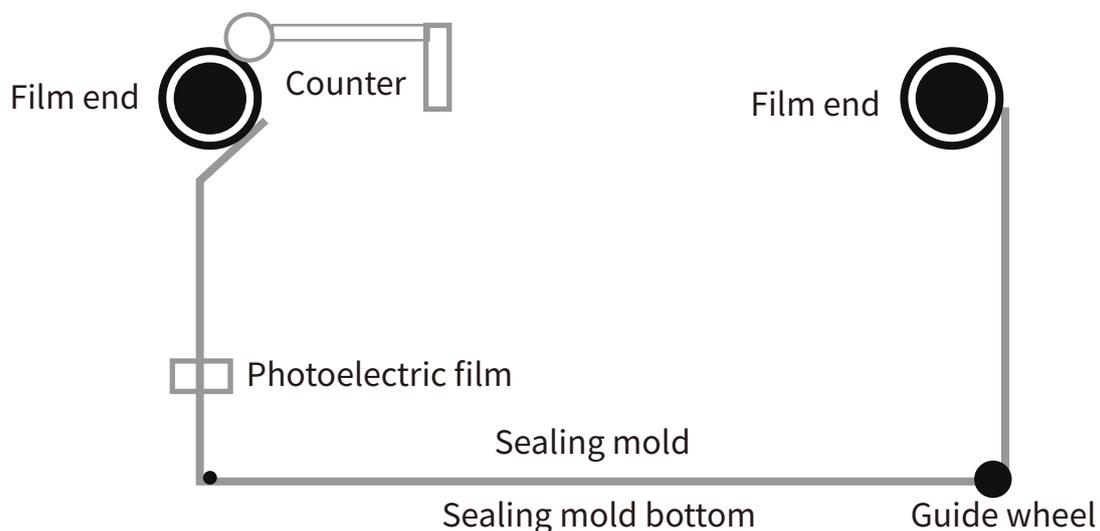
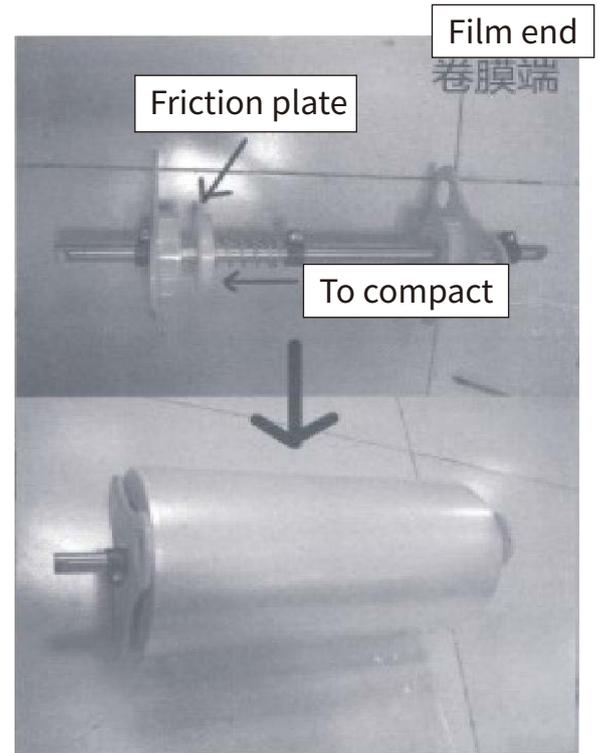
### PREPARATION BEFORE USE

- 1.If the self- contained air compressor is in place, prepare the trachea diameter 8 mm.
- 2.Power outlet with bottom line,voltage 220V, plus or minus 10V.
- 3.Check that the machine is in good condition.
- 4.Whether the random accessories are complete.
- 5.Does the body have a factory warranty card and a safety warning label?

6. Find a table or platform to place the machine, make sure the machine is balanced, and the table top and table top need to be strong.
7. Sealing film installation.
8. Sealing temperature adjustment.

## SEALING MEMBRANE INSTALLATION

- Before installing the parafilm. “Emergency stop switch” must be in Stop state, make sure the air source is connected to the machine, At this time, the sealing mold is kept rising, At this time, the sealing mold is kept rising, and the sealing film can pass through the space below the mold.
- The sealing film has a direction, and must not be reversed. The printing surface is on the object to be sealed, and the contact surface with the object to be sealed is a non-printing surface.
- Schematic diagram of film installation.



## SELECTION OF SEALING FILM AND ADJUSTMENT OF SEALING TEMPERATURE

### ● Selection

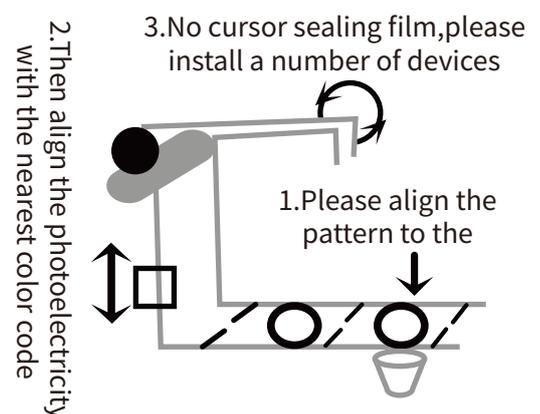
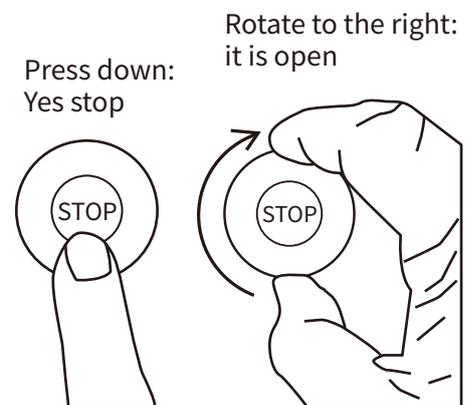
- 1.The sealing film must have a double-layer or three-layer composite structure, that is, it is composed of two to three layers. The composite film of the layer, the single layer film can not be used for the sealing of the machine.
- 2.This machine requires a thickness of the sealing film between 0.04mm and 0.11 mm, otherwise the sealing film will not be cut. Broken or sealed is not strict.
- 3.The width and printing size of the sealing film must be customized in strict accordance with the design of the factory.
- 4.The sealing film material is divided into: plastic composite film and aluminum foil composite film

### ● Temperature adjustment

- |                                |                                  |
|--------------------------------|----------------------------------|
| 1.PE (polypropylene) 170°C     | 3.PP easy to tear film 160-180°C |
| 2.PP (polypropylene) 170-200°C | 4.PET (polypropylene) 190-210°C  |

## Sealing film pattern proofing method

- 1.Press the “Emergency stop button”.
- 2.The person pulls the film and aligns the pattern between the cursors on the surface of the box.
- 3.On the side of the sealing film, it is manually retracted to ensure the flatness of the sealing film.
- 4.Use the tool to relax the photo-eye bracket and align the optoelectronics with the nearest cursor.
- 5.Open the “Emergency Stop Button” and press the “Start Button” to seal it once. Observe whether the pattern is centered. If it is not centered, use the tool to fine tune the position of the photocell until it is centered.



6. For the cursor-free transparent film, please use the “pointer” frame on the “film end” of the sealing film.

## PARAMETER SETTING

### ● Temperature adjustment

The temperature control table is displayed in the state of power-on, the red number is the real-time temperature, and the green is the preset temperature. “△” For the preset temperature up, “▽” Reduced for preset temperature.



### ● LED digital display man-machine interface adjustment and setting



Figure 1

Figure 1 is the boot interface, click Login to enter Figure 2

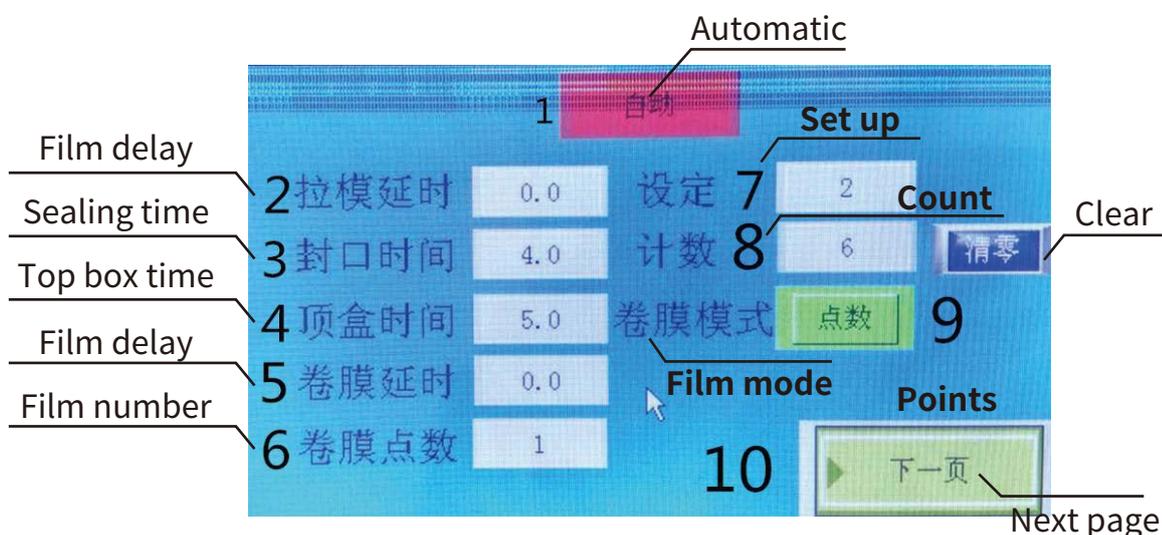


Figure 2

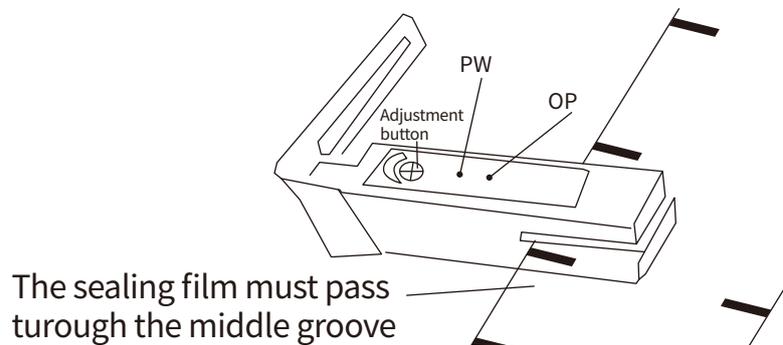


Figure 3

1. Click to adjust the “automatic” and “semi-automatic” click icons to switch.
2. Click to adjust the “automatic” and “semi-automatic” click icons to switch.
3. “Packing time”: set the heating time of the heating block and the sealed object, click the back value to enter the time value setting in Figure 3. After the time is filled, press “Enter” to confirm.
4. “Top box time”: set the time for the finished product to rise and exit, click the value of the back to enter the time value setting in Figure 3. After the time is filled, press “Enter” to confirm.
5. “Roll film delay”: Set the delay of the film roll time. (If there is no special case, please set it to 0..0) to hit the rear value and enter the time value setting in Figure 3. After the time is filled, press “Enter” to confirm.
6. “Volume Points” sets the “points” point in the film mode. Click the back value to enter the time value setting in Figure 3. After the time is filled, press “Enter” to confirm.
7. “Setting”: Set the number of finished products once sealed, click the value in the back to enter the time value setting in Figure 3. After the time is filled, press “Enter” to confirm.
8. “Count”: Accumulate the finished product output! Click clear” at the back to count from new.
9. “Roll film mode”: Click “points” to switch to “pairing” (no cursor, please set “points” mode to use the number of points to count.
10. “Next Page”: Click to go to the next page to view the start and stop and operation of each station.

## HOW TO USE PHOTOELECTRIC EYE

### Trough electric eye

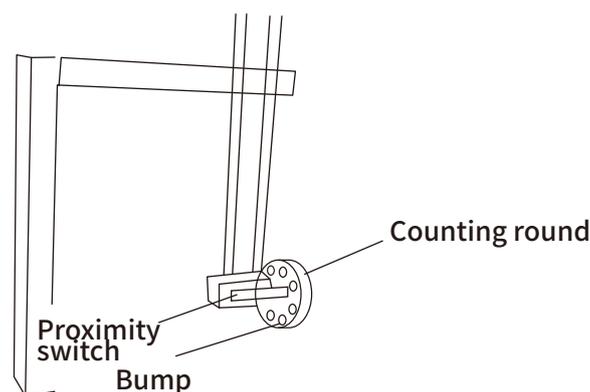


Slotted optoelectronics for transparent film, color-coded sealing film, and common milk tea sealing film the same.

The sealing film must pass through the electric eye slot in the middle of the photoelectric eye, and the PW green light is the power display light. When the colored block is illuminated by the OP red light, the roll film clicks to stop working.

If the color is not recognized by the electric eye, please aim at the fast, use a small screwdriver to twist the “adjust button” clockwise until the red light of the OP lights up.

## HOW TO USE THE NUMBER DEVICE



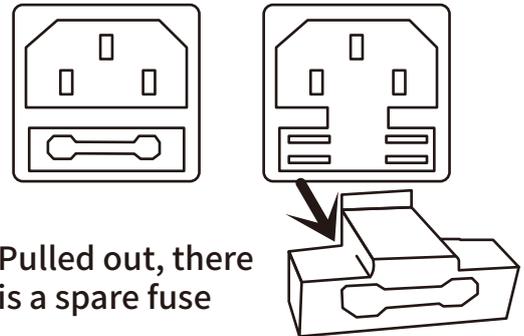
- 1.The counting wheel is a device for measuring the length of the sealing film. It consists of a wheel with eight raised points and a proximity switch.
- 2.The distance between the proximity switch and the raised point is 1-3mm. When the length of the film is not accurate, the distance between the adjustable wrench and the wrench can be checked.

3.The rubber ring on the wheel is used for anti-slip effect. Before use, the wheel should be placed on the sealing film to keep the wheel in continuous contact with the sealing film.

## COMMON TROUBLESHOOTING

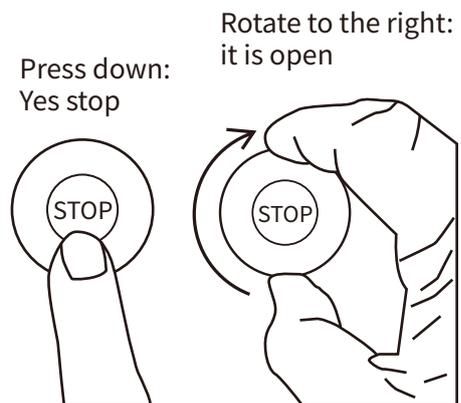
### ● No power

- 1.The power cord is damaged and can be replaced.
- 2.The fuse is damaged and can be replaced.



### ● No film

- 1.“Emergency stop button” is in the “stop” state, please rotate to the open state.
- 2.“Motor switch” is damaged or incorrectly positioned, adjust switch position or replace damaged switch.
- 3.The motor is damaged. If the motor is damaged, please replace it.



### ● Start button no action

- 1.Check if the air source is switched on.
- 2.Check if the emergency stop switch is on.
- 3.Start button is broken.
- 4.Check if the film motor is stopped. If it is not stopped, please check it.

### ● No sealing action

- 1.The seal switch is not in place, using a screwdriver or a hex adjustment.
- 2.Sealing output solenoid valve is damaged.

### ● Heating tube is not heated

- 1.The actual temperature value is higher than the preset temperature value.
- 2.Heat pipe damage.

- 3.Heat pipe line off.
- 4.Sensor abnormality.
- 5.Control panel damage.

### ● **Sealing film is not cut**

- 1.Barometer value below 0.4.
- 2.The width of the sealing film is narrow and the width should be 25mm or more larger than the single edge of the box.
- 3.Check if the position of the sealing film is offset and should be centered on the center line of the box.
- 4.Check if the upper and lower molds are.
- 5.Is the tool in the mold damaged?

### ● **Seal is not tight**

- 1.The air pressure is too low and the air pressure should be between 0.4 and 0.8.
- 2.Is the lower mold silicone strip damaged?
- 3.Is the heating block temperature too low?
- 4.Whether the sealing film material matches the box material.

### ● **The length of the film is not allowed**

- 1.Check if the number of wheels is installed in place.
- 2.Check if the point setting is accurate.

### ● **Sealing film surface fold**

- 1.Sealing temperature is too high.
- 2.Sealing time is too long.
- 3.Is the guide wheel installed?

### ● **Sealing film**

- 1.The edge of the waste film is too narrow, and the single side should be kept above 25mm.
- 2.The sealing film is not cut, causing the film to be pulled up.