900 SERIES

CONTINUOUS BAG SEALER

USER'S MANUAL

1. Usage

This machine can seal the single or composed layer plastic film. It is widely used for packing food, medicine, cosmetics, local specialities, aquatic-product, seeds, chemical material, electronic component, clothing, hardware, etc.

2. Feature

This machine is advance designed with complete function. It can seal, print marks at one time. The sealing length is free. It can be used in the assembling line with high efficiency.

This machine is nicely made new structure. It can be used as horizontal one, vertical one or floor one. The horizontal one is used for dry products. And the vertical one is for liquid products. The optional, steel printing device is reliable and can print marks clearly. The printing marks can be easily changed. The sealing speed and the sealing temperature can both be adjusted according to the packing materials and the thickness of the film to ensure the sealing quality.

3. Structure and principle

This machine is composed of frame, speed reduction organism, heating and cooling organism, drive and conveyor device, sealing and printing device, speed-adjusting organism, electronic controlled heating system and counter system. The sealing temperature, tension of the sealing bands, sealing speed and sealing gap are all adjustable.

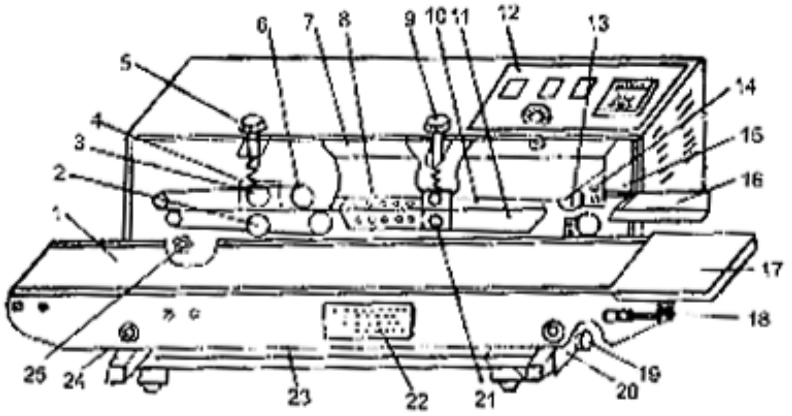
The sealing bands, the guide belt and the conveyor belt are all driven by one motor.

When switch on, the electro-heating components begin heating, which result in the two heating blocks being heated. According to the material used and the thickness of the film, adjust the temperature and the speed knobs to the right position. The bags to be sealed are conveyed by the conveyor belt. Put the opening of the bag into the heating area. Where heat transmits through the heating bands into the opening bag. And therefore the film of the opening bag is melted. Then, it is sent into the cooling area, where the temperature of the film falls. Finally, it is sealed, when pass through the hobbed wheel or printing wheel

to give our clear net figure and the desired marks. The bag is sent out by the guide belts. This is the process for one seal.

Horizontal sealer

1. Conveyor belt
2. Rubber wheel
3. Hobbed wheel(printing wheel)
4. Printing wheel base
5. Tension knob for the printing wheel
6. Moving wheel
7. Protection mask
8. Cooling block
9. Tension knob for sealing
10. Heating block
11. Sealing band
12. Panel

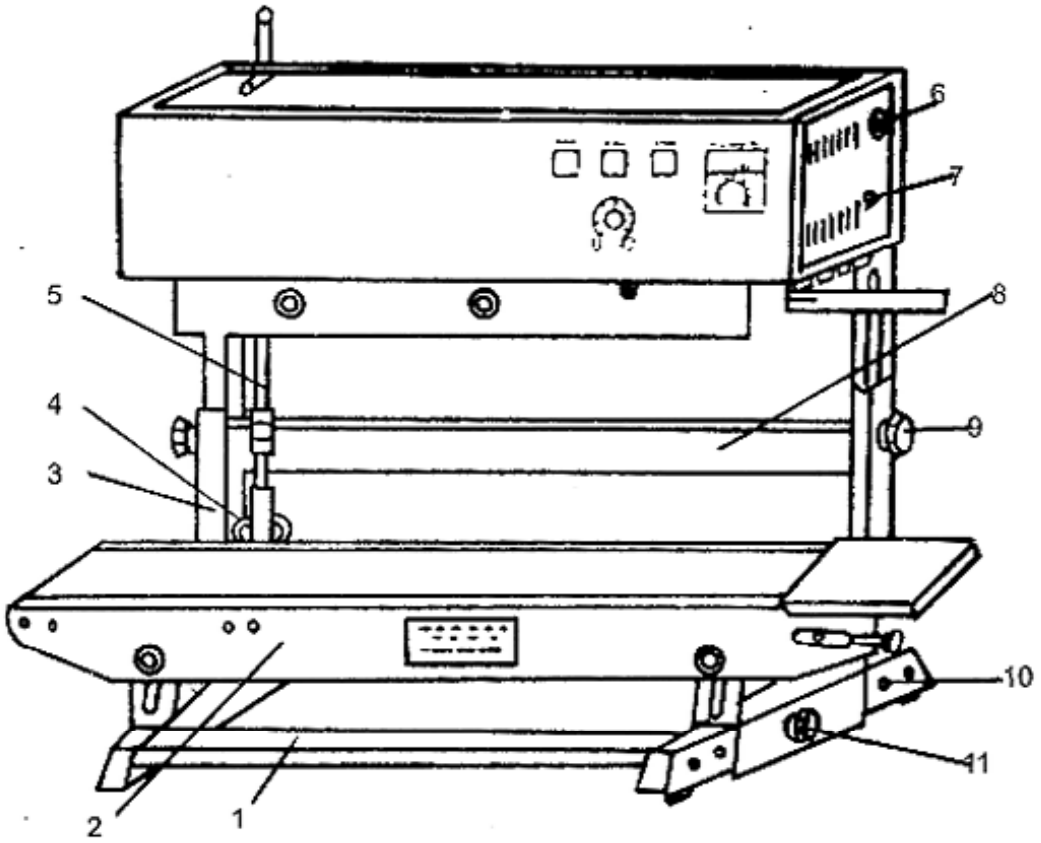


13. Idle wheel
14. Screw for moving sealing band in or out
15. Screw for tightness of sealing band
16. Plate for positioning the sealing width
17. Plate to fix the worktable
18. Screw for tightening the conveyor
19. Screw for moving the conveyor in or out
20. Moving frame of worktable
21. Sealing wheel
22. Plate
23. Conveyor
24. Knob for adjusting the height of the worktable
25. Nut for adjusting the height of the ring wheel

Vertical sealer

1. Tranvers bar

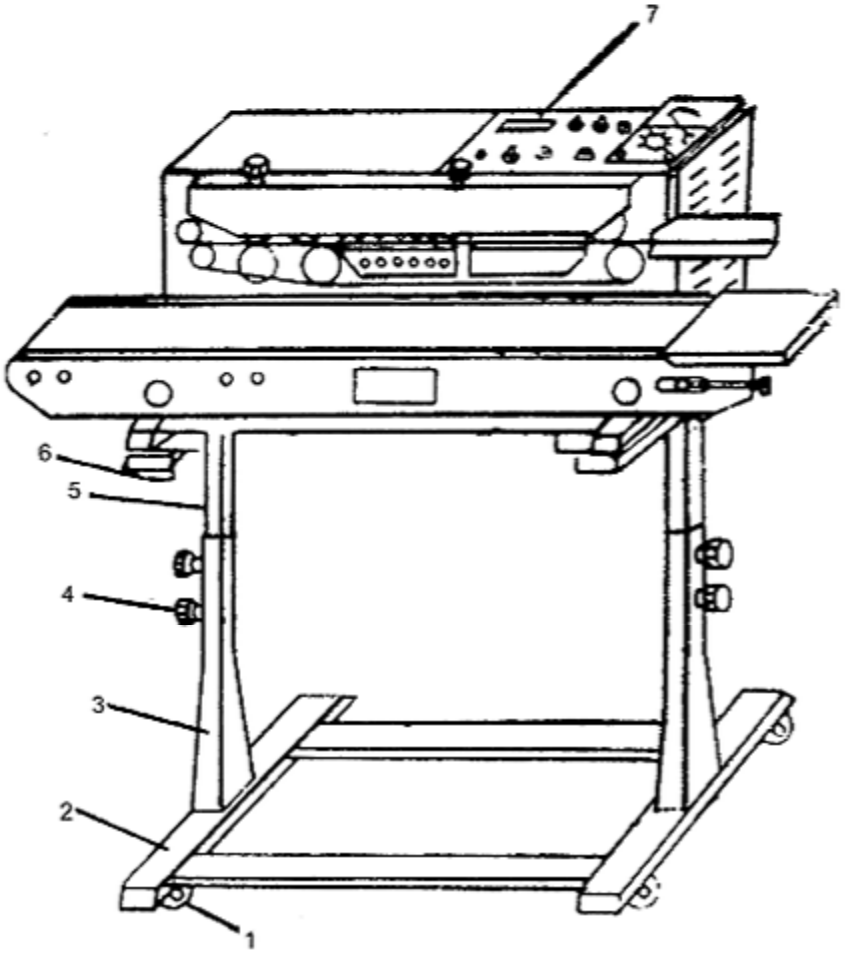
2. Conveyor
3. Triangular frame
4. Umbrella gear base
5. Long shaft
6. Power socket
7. Fuse
8. Foot stand
9. Knob for adjusting the height
10. Moving frame of working
11. Knob to fasten the conveyor



Foot wheel

1. Foot wheel
2. Machine base
3. Foot stand
4. Knob for adjusting height

5. Upper frame
6. Locking screw



Specification

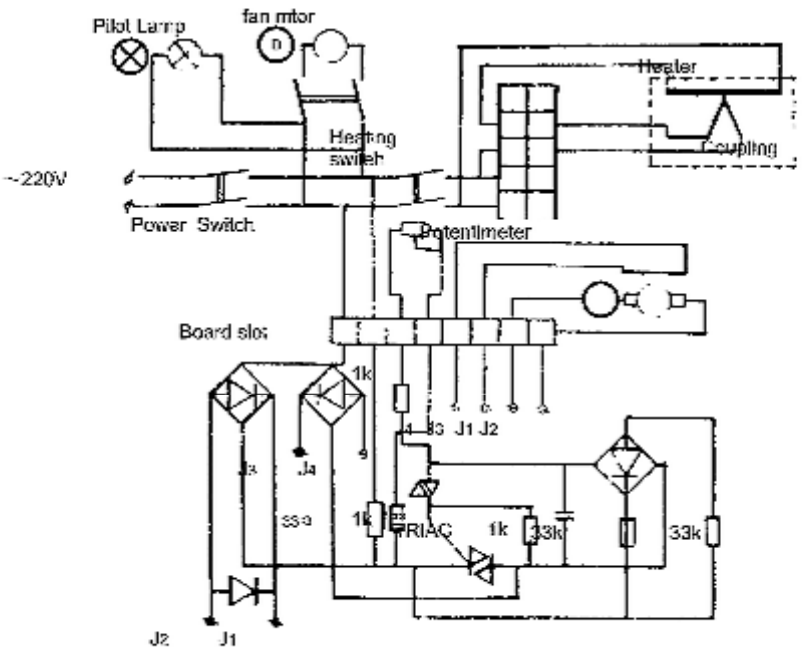
Power source: 220V/50HZ 60HZ 110V
Power: 0.5KW
Sealing speed: 0~12m/min
Sealing width: 5~15mm
Thickness of film: 0.02~0.80mm
Sealing length: free
Temperature: 0~300℃
Print word: ≤39words
Max conveyor: ≤10KG

Electric principle diagram

The temperature control system is composed of temperature controller,

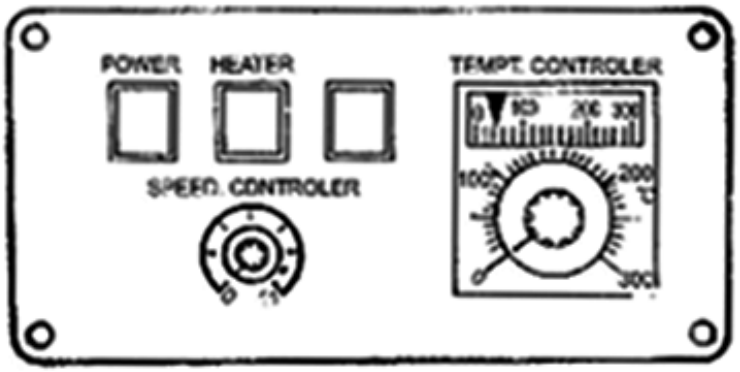
coupling and heaters. The sealing temperature is controlled by the temperature controller. When the sealing temperature is lower than the preset value, the green light in the temperature controller is on, indicates that it is heating. And when the temperature is higher than the preset value, the red light is on, indicating that it stops heating. Thus the sealing temperature knob is to preset the sealing temperature.

The sealing speed control system consists of TRIAC speed control device and the DC motor. The speed knob on the panel is to set the sealing speed.



Adjustment & Usage

(1) Panel



(2) Adjustment

a. To adjust the height of conveyor (see figure 1), loosen the nut (25) for adjusting the height of the ring wheel with cresent spanner. Then loosen the knob for adjusting the height of conveyor (24) and pull the conveyor up to the requirement position with both hands. Finally, tighten the knob (24) and the nut (25).

b. To move the conveyor in or out (see figure 1), if the conveyor needs moving in or out. Loosen the screws (19) at the both sides of the conveyor. Move in or out the conveyor to the required position, then tighten the screw (19).

c. To adjust the height of vertical sealer (see figure 2), face down the vertical

sealer, first loosen the nut for adjusting the height of the ring wheel, then the knob (9) for adjusting the height of the machine. Move the foot stand to the required position and tighten the knob (9). Now stand the sealer, adjust the vertical position of the long shaft (5), then tighten the nut.

d. To adjust the sealing length (see figure 1), adjust the position of the positioning plate (16) to the right place.

e. To adjust the sealing tension (see figure 1). The tension of the hobbed wheel (printing wheel) decided the sealing quality. Adjust the tension knob (5) properly to give out the clear figure. Low tension will result in vague in figure or even affecting the sealing tensity.

f. To adjust the tension of the sealing wheel (see figure 1), adjust the tension of the sealing wheel properly. Over tension will lower the machine' load.

g. To adjust the sealing bands while running (see figure 1 & figure 6). If the upper sealing band runs out, adjust screw D for moving the sealing band in or out at the upper idle wheel base. If the lower sealing band out, adjust screw D at the lower idle wheel base. If the sealing bands run in, adjust screw C at the idle wheel base correspondingly. If there are gap between the upper heating

block and lower block and between the upper block and the lower cooling block, but the sealing band doesn' t run adjust the screws for the tightening the sealing bands (figure 6). Tighten the screws properly. Otherwise the lift the sealing bands will be shortened.

h. To adjust the sealing speed and the sealing temperature, adjust the sealing speed and the sealing temperature knobs to the right position, according to the material used to get the best sealing tensity. There is relationship among the sealing temperature. Scaling speed and the material used. The higher the temperature, the higher is speed.

The following are just for reference:

Polyethylene: 150~190℃

Polyproplene: 170~180℃

Polyalkene compound: 180~190℃

Usage

a. Switch on and the pilot lamp lights. The wheels are running.

b. Turn the speed knob clockwise to the right poison to speed up.

c. Turn on the heat switch on the panel. Adjust the temperature knob to the right position.

d. When the red light in the temperature controller is on, the preset temperature is reached. Put the bag for trials. Adjust the temperature, the speed and the tension of the hobbed (printing) wheel to get the idea of sealing quantity. Now the machine is ready for continuous sealing.

e. When single layer film such as polyethylene is to be sealed, the fan motor should be turned on for cooling. When compound film is to be sealed, the temperature is much higher than for the single layer.

f. Put the opening of the bag into the heating area horizontally along the positioning plate. The sealing band carries the bag forward. No pushing, preventing or even pulling out at the same time, or it will cause uneven in the seal.

H. Stop operation

To prolong the life of the sealing bands, with the machine, still running, turn back the temperature knob to zero, turn on the fan till the temperature falls

below 100℃. Then cut down the fan and the power switch.

4. Maintenance

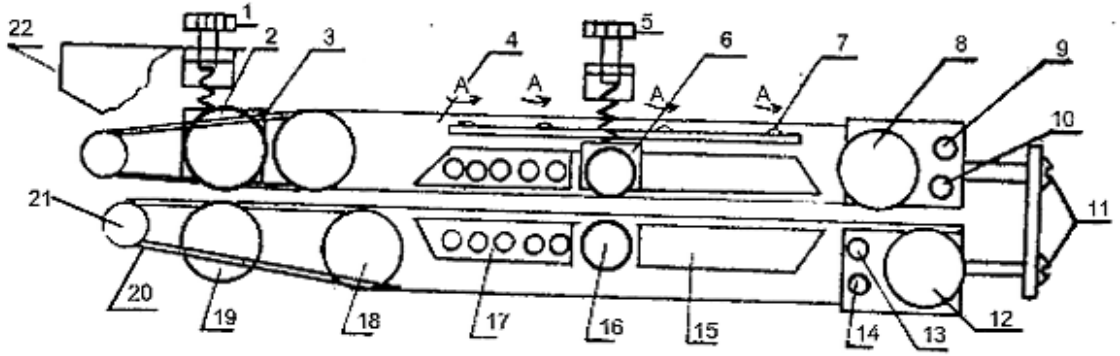
1) Be familiar with the usage of the machine before operation.

2) To ensure safely, the machine shall be connected with ground.

3) When firstuse the machine or haven′ t used it for along time, preheat the machine at the low temperature for a few minutes before actual operation, because the heater may get damp.

4) To select the sealing temperature and the speed properly, pay strict attention to the rules for stop operation. Sealing bands are never allowed to be in high temperature motionless for long in case of being damaged.

5) For the first trial, the temperature must be raised gradually to prevent overheating. If there is film melted in the sealing bands or in the heating blocks, stop the machine and clean it.



1. Tension knob for the printing wheel
2. Hobbed wheel (printing wheel)
3. Printing wheel base
4. Sealing belt
5. Tension knob for sealing
6. Sealing wheel base
7. Fixing position strap
8. Idle wheel
9. Screw C for moving sealing band in or out
10. Screw D for moving sealing band in or out
11. Screw for tightness of sealing band
12. Lower idle wheel base
13. Screw C
14. Screw D
15. Lower heating block
16. Sealing wheel
17. Cooling block
18. Moving wheel

19. Rubber wheel
20. Guide belt
21. Gude wheel
22. Protection mask

To replace the sealing bands (see figure 6)

1) Take away the protection mask. Rotate the (4) positioning shims A for 90° at the direction shown in figure 6. Lift up the cooling block and the heating block and remove the guide belt.

2) Push the idle wheel to the direction of B and remove the sealing band.

3) Replace with the new sealing band and put back the guide belt. Rotate back the shims A.

4) Adjust the screws to tighten the sealing band properly.

5) Fix back the protection mask. It's ready to operate.

To change the horizontal on to the vertical one

1) Fix two triangular frames and two transverse bars by M4 screws, with the concavities of the triangular frames in side and the concavities of the bars

downside.

2) Loosen the screws for moving the conveyor in or out to pull out the conveyor. Then remove the knob the locking screws to take down the conveyor.

3) Fix the conveyor onto the triangular frame and tighten the knob.

4) Replace the horizontal short shaft with the vertical umbrella gear.

5) Put the vertical umbrella gear into the hole of the machine. Put the foot stands of the machine into the shelves. Adjust to the required position and tighten the knob.

6) Stand the machine. Now the bag can be sealed vertically.

To install the floor one

1) Put foot stand 4 into the machine bare. Put the upper frame 5 into the slot, and adjust the height and tighten the knob 4.

2) Remove the two rubber feet at the back of the machine. Install the machine on the upper frame with 4 pieces special screws.

To change printing wheel (date code)

1) Take away the protection mask. Loosen the tension knob for the printing wheel.

2) Remove the upper guide belt. Screw away the locking screw in the axis of the printing wheel.

3) Pry up the printing wheel base with screwdriver to make a gap between the printing wheel and the rubber wheel.

Pull out the hobbed wheel with bands and install the printing wheel or put back the printing wheel with changed words.

4) Tighten the locking screw in the axis of the printing wheel. Put back the guide belt. Adjust to the proper tension and have a trail.

5. Trouble and troubleshooting

Trouble	Causes	Shooting
The pilot lamp doesn' t light	1. No AC voltage in 2. Open fuse 3. the lamp is damaged	Connect the power Replace the fuse Replace the lamp
The machine doesn' t run	1. The board for speed regulation is abnormal. 2. Doesn' t connect well 3. The brusher in DC motor is too short because of the friction.	Replace the board Tighten the connecting screws Replace the brushes
The motor runs at high speed and can' t be regular	The board for speed regulation is damaged	Replace the board
The motor runs at high speed and can' t be regular	The board for speed regulation is damaged	Replace the board

Trouble	Causes	Shooting
The sealing bands run out of the way	The sealing bands are too loose The screws for moving the sealing band in and out are not properly adjusted	Tighten the screw for sealing bands properly. Correctly adjust the in and out screws.
The conveyor runs out of the way	The screws for moving the conveyor in and out are not correctly adjusted	If runs left, tighten the left knob and loosen the right one and vice versa.
Low tension in the seal	The temperature is too low and the speed is too fast	Raise the temperature and reduce the speed properly

Trouble	Causes	Shooting
The printing marks are not clear enough	The tension screw for the printing wheel it too loose	Tighten the tension knob (figure 1)
The seal is crumple and the film sticks the sealing bands	The temperature is too high. The guide belt in not correctly adjusted	Turn on the fan motor. Reduce the speed or falls the temperature. Open the left plate to adjust the position of the guide roller
The temperature doesn't raise or in out of control	The heat switch is damaged. The heater is damaged. The temperature controller is out of control Open coupling	Replace switch Replace heater Replace the temperature

Trouble	Causes	Shooting
The temperature is far higher than the preset value	The replay in the temperature controller doesn' t connect well. The wrong position of the knob for presetting temperature	Replace the temperature controller or the replay. Connect the position of the knob and tighten the screw to lock the knob
The conveyor doesn' t work	Vertical driving shaft doesn' t stick together. The screw for the gear is loose. Screw for connecting shaft is loos	Take down the driving shaft (1 11) and stick it together with glue. Take away the left plate and fasten the M5 screw or fasten the screw for connecting shaft.

Trouble	Causes	Shooting
Open fuse	Short circuit in a switch Short circuit in the heater Short circuit in the board	Replace the short circuit component
There is inductive electricity or electricity leakage	The ground is not connected There are too many connection lines	Connect the ground well Shorten the connection lines Replace the heater

6. Accessories

Name	Quantity	Name	Quantity
Sealing band	40 pcs	Screw driver (cross)	1 pc
Guide belt	4 pcs	Screw drive (straight)	1 pc
Crescent spanner	1 pc	Fuse 3 A	2 pcs
Unadjustable spanner	2pcs	User' s manual	1pc