

**CBS-980P**

**AUTOMATIC INK-PRINTING  
SEALING MACHINES**

# **INSTRUCTION**

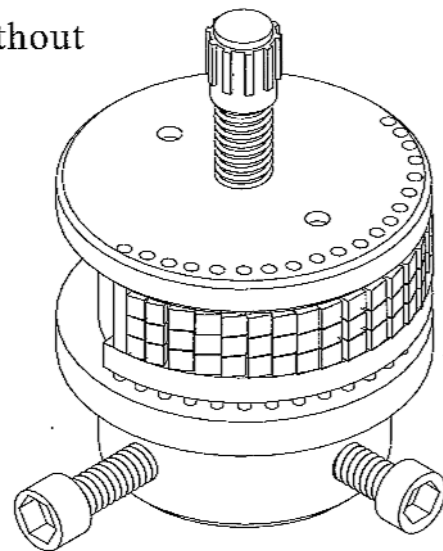
**Before operation, please read this  
operational manual carefully**

## **1.PURPOSE OF THE PRODUCT:**

The machine is suit for sealing bag of various plastic films and is the best sealing equipment to be widely used in such sectors as food,pharmacy ,chemical industry,electronic components seeds etc.

## **2.PERFOMANCE AND CHARACTERISTICS**

with the electronic thermostatical control and the no step speed variation device,the machine can make various shapes of plastic film bags and be used for setting of various packing lines without limiting the sealing length,having the characteristics of high effectiveness of continuous sealing,reliable quality, reasonable contruction,convenient operation etc.At the sealing time,the solid ink can print color label ,produce time and expire date on the film drags, the characters are very clear,the color can choose and easy dry,each row can carry 20 words.



(Diagram1)

**TYPE OF ARRAY WORDS:** (see diagram1)

## **3.CONTRUCTION AND WORKING PRINCIPLE**

The machine consists of frame,speed regulator,sealing length regulator temperature controller ,drive and transportation devices.When it turns on,the electronic theronic thermal component produces quantity of heat to make the temperature on both upper and lower heaters promptly rise. Adjust temperature and speed according to sealing material through the temperature controller and the speed

regulator. The plastic packing bag is transmitted by the conveyor belt with its sealing part sent into between the two running sealing braids, and subjected to the extrusion of the two heaters in heating area to have the plastic film bound after being heated, the bag is cooled in cooling area, its sealing part, ruled by pattern roller or inker wheel, is made out with stripes or netted veins and necessary color label. The drive part consists of sealing belt, lead belt and conveyor belt all in synchronism running driven by a motor.

#### **4.MAIN PARAMETERS:**

**CBS-980P(VERTICAL)CBS-980P(HORIZONTAL)**

**POWER SUPPLY:220V/50HZ,110V/60HZ**

**POWER:620W**

**SEALING SPEED:0-12M/MIN**

**SEALING WIDTH:6-13MM**

**TEMPERATURE RANGE:0-300<sup>0</sup>C**

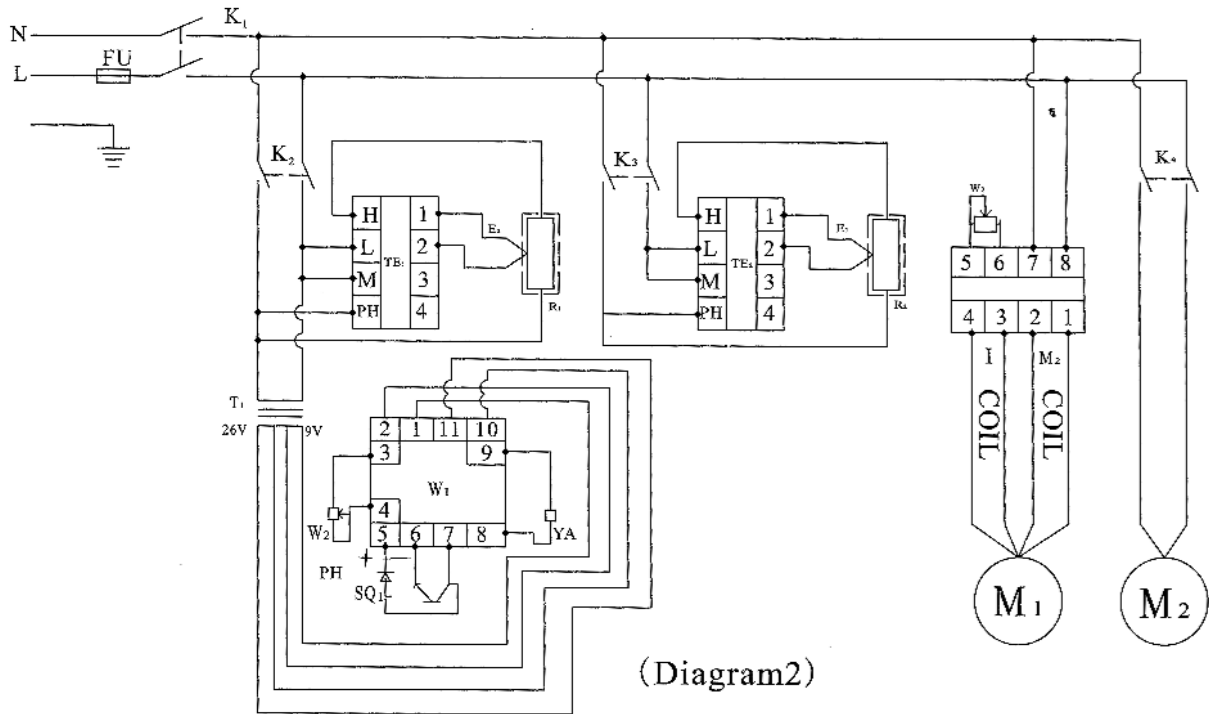
**QUANTITY OF PRINT WORDS:20×3ROW**

**LOADING OF CONVEYOR: ≤10KG,**

**EXTERNAL SIZE:920×390×290mm 920×390×590mm**

**WEIGHT:29.5KG 33KG**

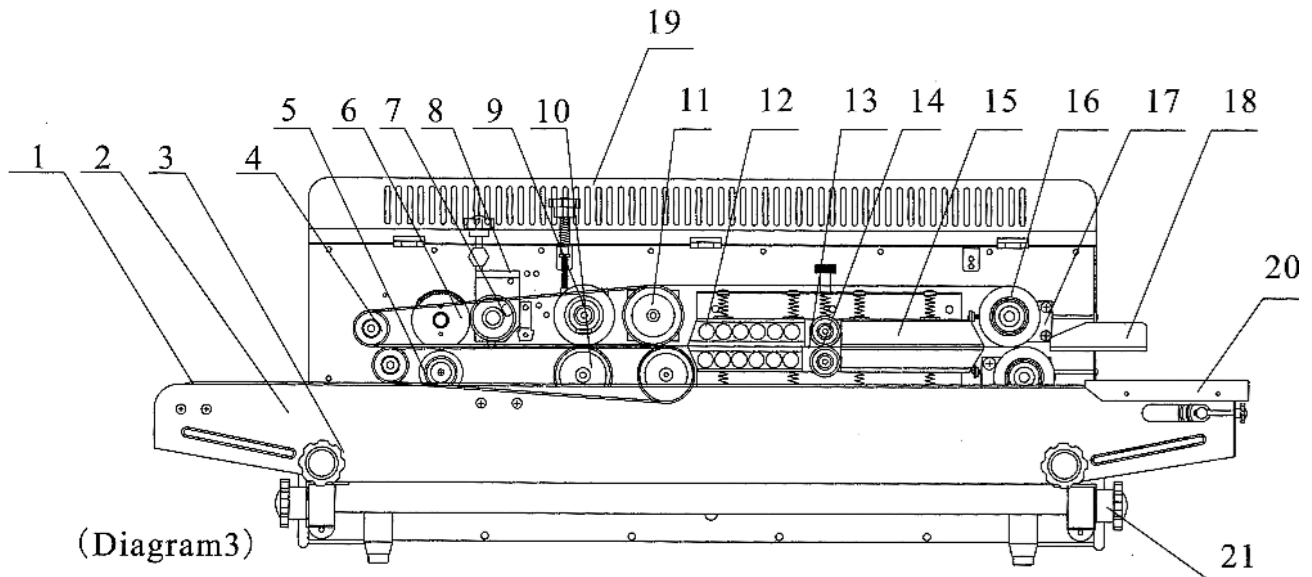
## 5.ELECTRICAL SCHEMATIC



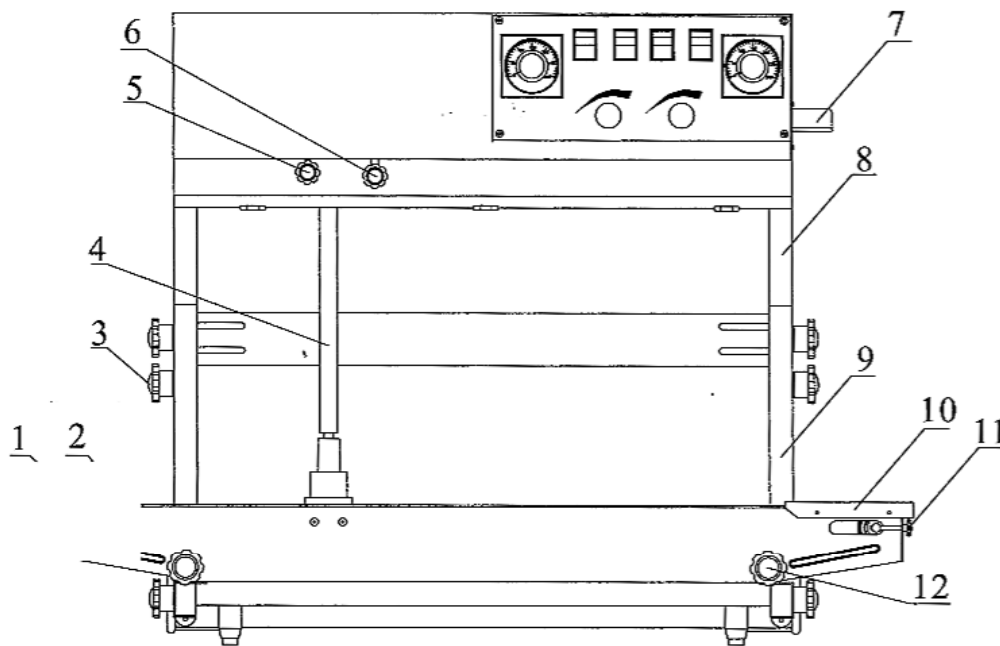
1. FU      2.K1 power switch      3.K2 print switch      4.K3 heating switch  
 5.T1 transformer      6.SQ1 print photocell      7.W2print position potometer  
 8.YA electromagnet      9.TE1-2 temperature controller      10.W2 transport adjusting  
 11.M1 transport motor      12.M2 fans      13.R1 heaters of the print      14.heaters of the R2 seal

## 6.USAGE:

### (1)The name of main components



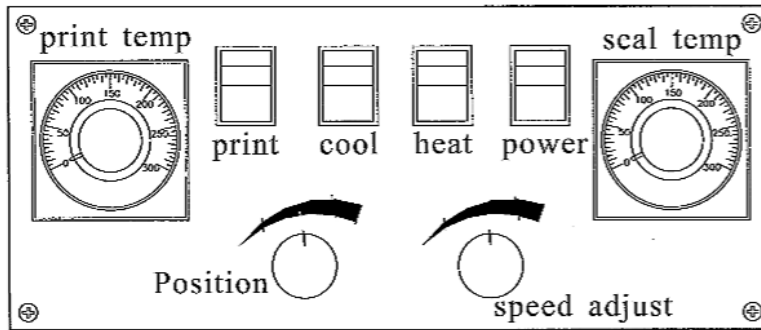
1. conveyor 2. conveyor table 3. the adjusting knob
4. small guiding wheel 5. silicon wheel 6. print wheel
7. solid ink wheel 8. ink wheel base 9. pressing wheel
10. rubber wheel 11. driving wheel 12. cooling block 13. sealing band
14. pressing wheel 15. heating block 16. driven wheel
17. driven wheel base 18 material inlet 19. protective cover
20. working table protective board 21. adjusting knob for the conveyor table.



(Diagram4)

1. conveyor belt 2. conveyor table
3. the adjusting knob for the machines body fluctuation
4. long axes 5. the adjusting knob for the print darkness
6. the adjusting knob for the pressing wheel 7. material inlet
8. supportor 9. vertical shelf 10. the protective board
11. the adjusting screw for the conveyor
12. the adjusting knob for the conveyor table

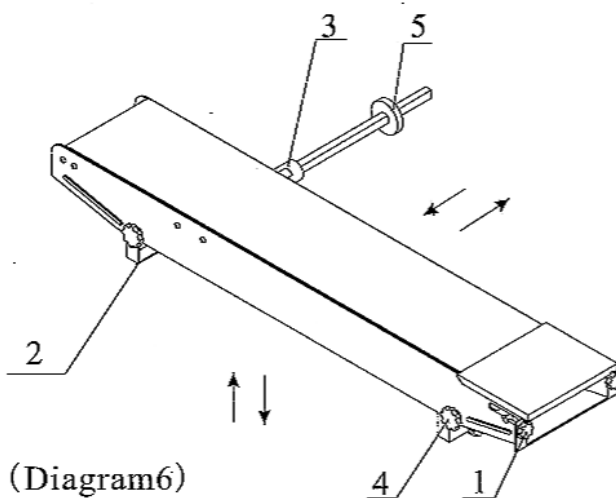
## (2)control plate:



(Diagram5)

## (3)preparation before machine running:

- 1)The machine is equipped with a shell-grounded triplet socket which should be well grounded when used to make sure of safe production,
- 2)The electrothermal component should be preheated with low temperature for a few of minutes before normal operation.
- 3)Adjust the height and the front and back position of the conveyer section to fit the necessary level of the sealing bags's external size.
- 4)Adjust the position of the lead plate of sealing width regulation according to its requirement.
- 5)Loosen swing knob,pull or push the coveyer station,and then turn it tight.
- 6)Loosen swing knob and scrwe and then turn it tight.

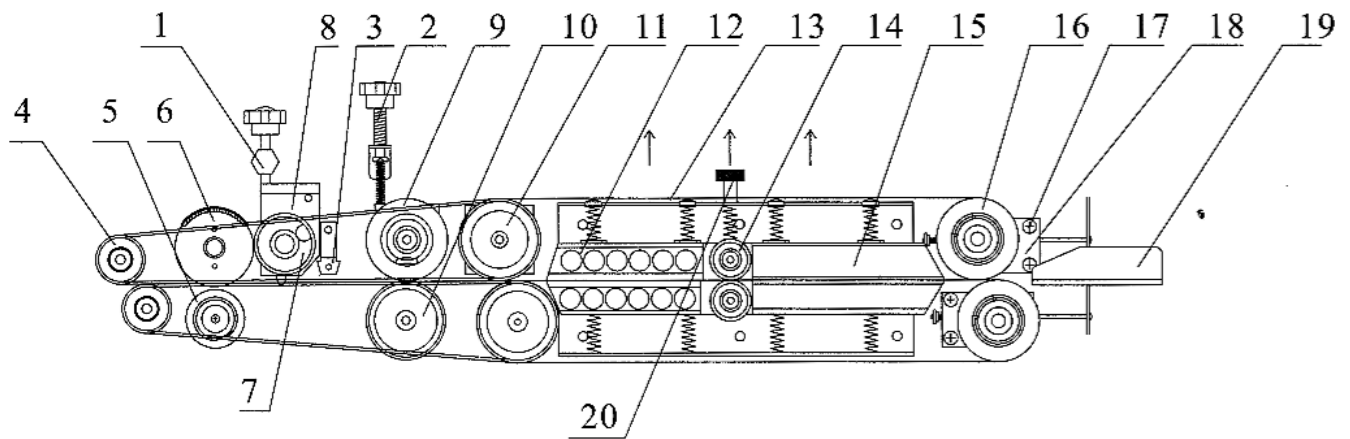


(Diagram6)

1. adjusting knob of conveyor
2. foot
3. cardan shaft of conveyor
4. adjusting knob of conveyor of the fluctuation
5. round nut

## **7. OPERATIONS:**

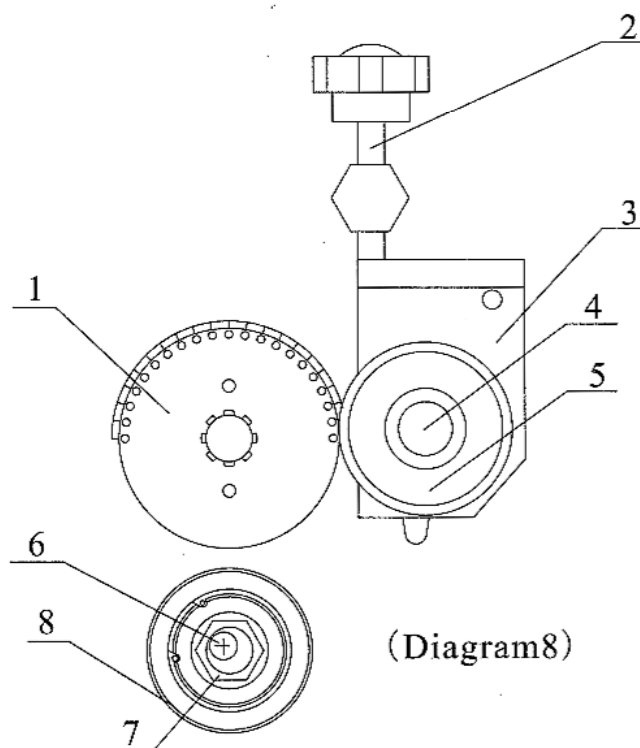
- 1) Turn on the power, all wheels begin their synchronistical running.
- 2) Adjust the knob of pattern roller to have it rotated and regulate to suitable pressure.
- 3) Turn on the heating switch, the green lamp on electronic temperature controller lights, adjust the controller to necessary temperature according to the nature and the thickness of the packing bags' material.
- 4) Determine if the blower needs tuning on cooling according to the thickness of sealing material.
- 5) Make the package sealing flat and send it to the material entrance.
- 6) If you find the dirty thing in sealing band and heating tablet, please stop the operation and clean it.
- 7) Method of adjust sealingband:
  - A. Hence the button of heating table, cool tablet, and press wheel spring, take sealing band and guide band away.
  - B. Push the mobil wheel to the direction of material entrance, take the sealing band away,
  - C. Replace the new sealing band, lead band.
  - D. Reset the driver wheel heating tablet, cooling tablet, press wheel.
  - E. If the sealing band go away the right direction, you can adjust the screw of driver wheel.
  - F. Conver the safty convering.
  - G. Adjust the solid inker wheel, print wheel, silica gel wheel.



(Diagram7)

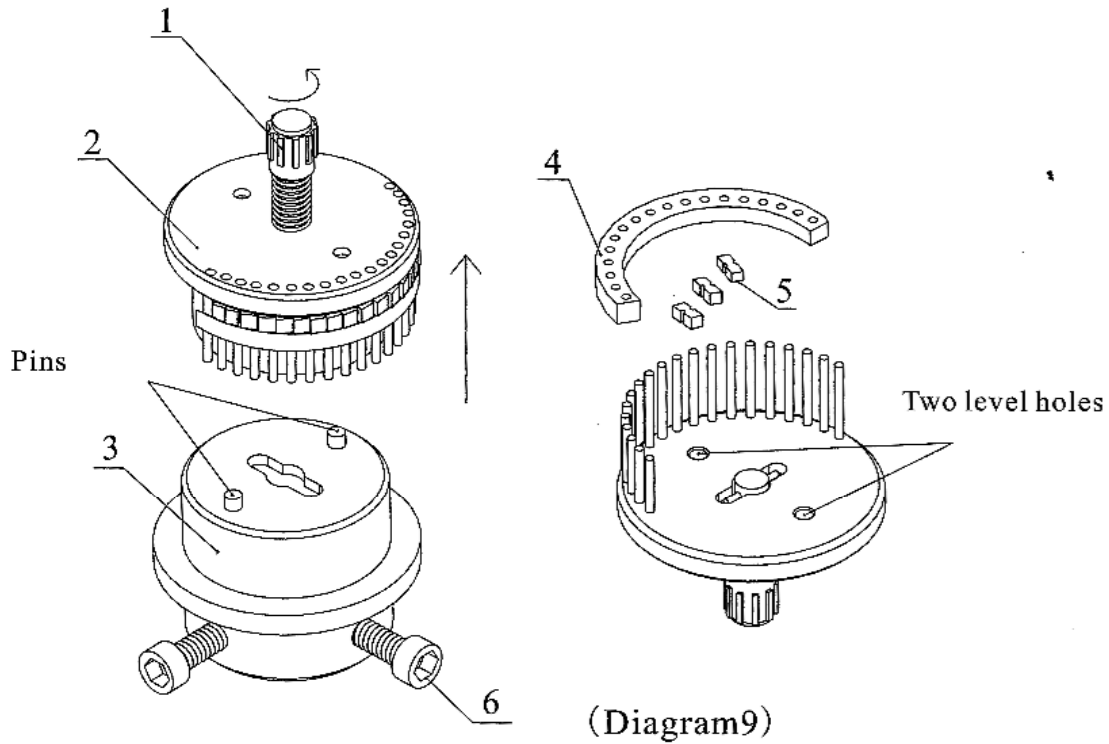
1. adjusting knob for the print
2. the pressure adjusting knob
3. photocell
4. small guiding wheel
5. silicon wheel
6. print wheel
7. solid ink wheel
8. ink wheel base
9. pressing wheel
10. rubber wheel
11. drive wheel
12. cooling block
13. sealing band
14. press wheel
15. heating copper block
16. driven wheel
17. adjusting screws
18. driven wheel base
19. material inlet
20. liftout plate

1. print wheel
2. adjusting knob
3. ink wheel base
4. ink wheel core
5. ink wheel
6. adjusting screw
7. axes
8. silicon wheel



(Diagram8)





1. knob for the print wheel    2. print wheel  
 3. print wheel core    4. silicon stripe  
 5. letter    6. fasten screw of print wheel

### 8.PRINTER PLACE CONTROL:

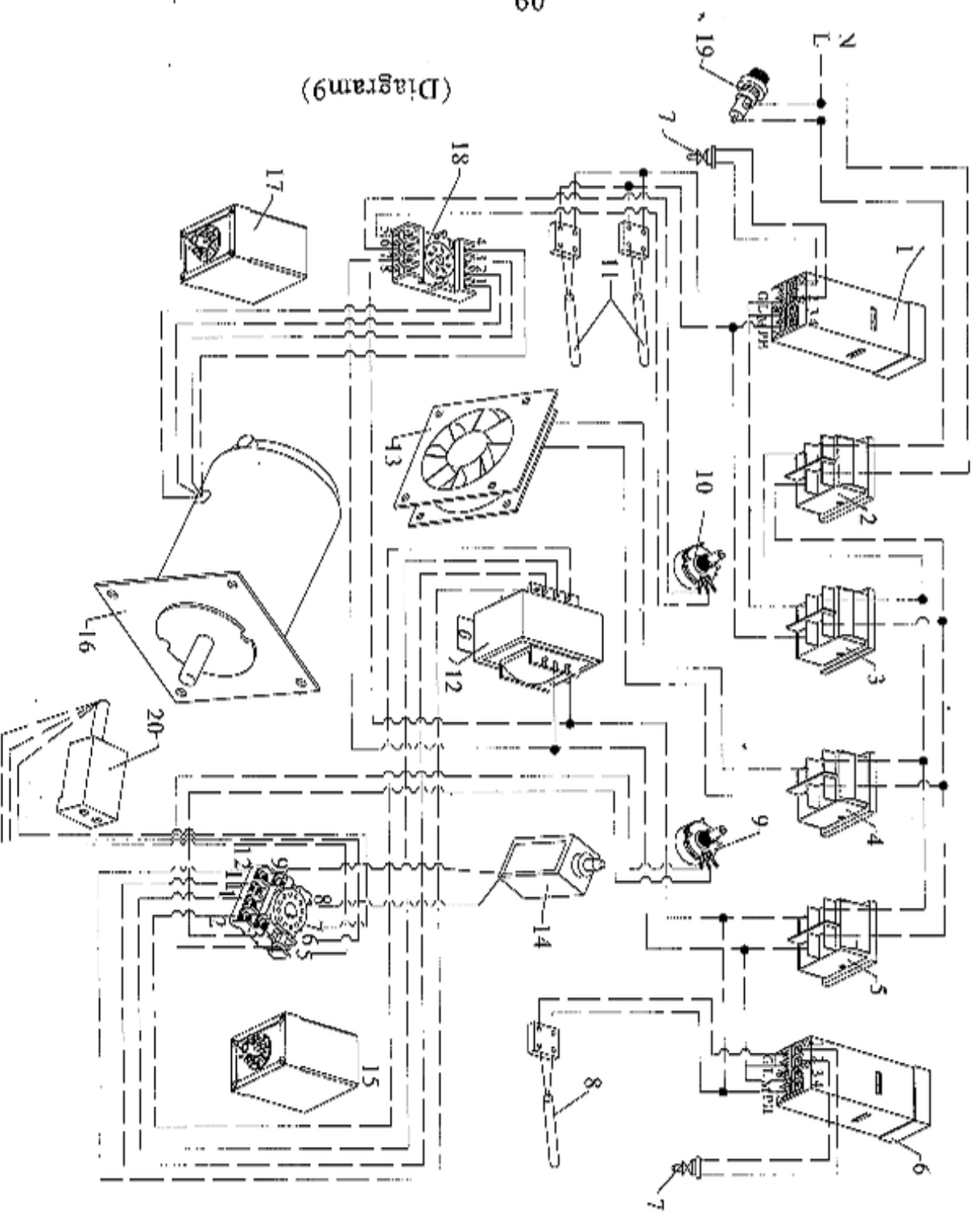
You can order to the length of film bags,adjust the switch for print distance.  
 Adjust printing rows and put the words and fix on the bearing.

### 9.STOP OPERATION:

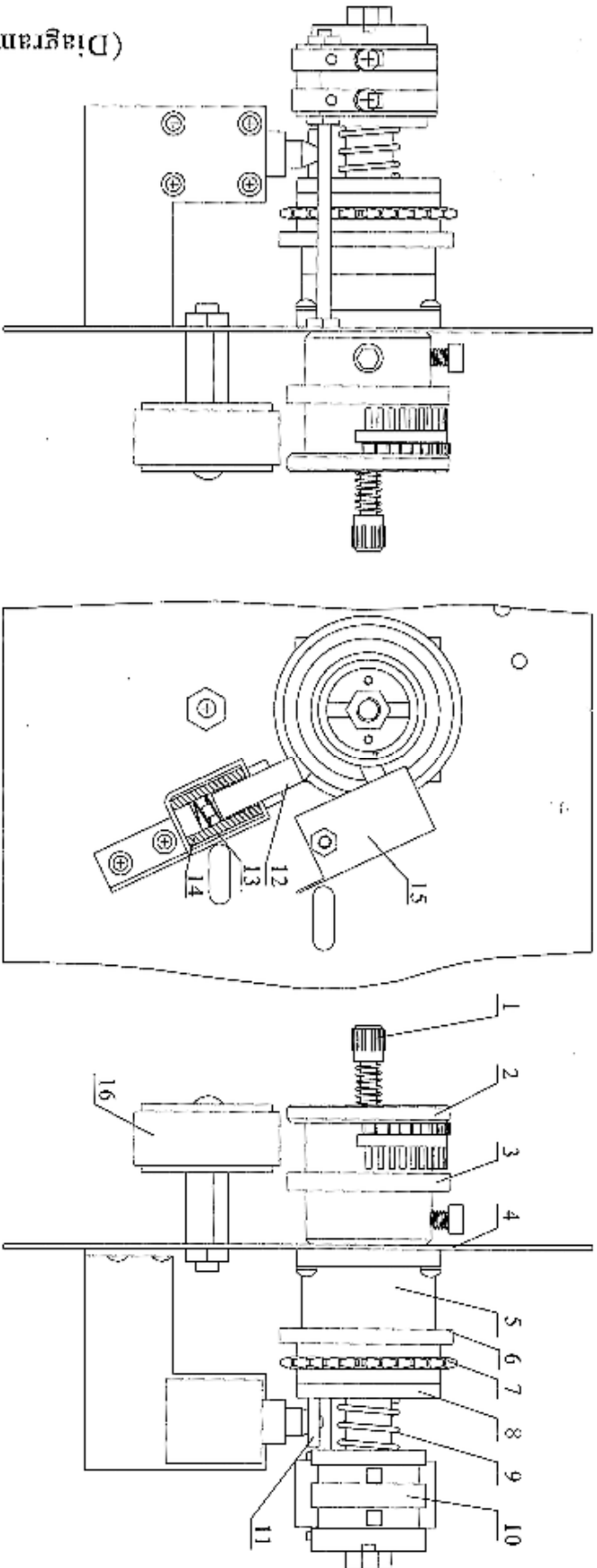
Turn off the temperature switch and open cooling fan to make the temperature below 100<sup>0</sup>C,then turn off fan and power switch.

### 10.ELECTRIC CONNECTION WIRE:

# CBS-980P DIAGRAM



NO	NAME	SPEC	AMOUNT
20	Photocell		1
19	Fuse base	5A	1
18	Speed adjusting base		1
17	Speed adjustor	220V/ 50-250W	1
16	Motor	50W	1
15	Photocell controller		1
14	Electromagnet	24V	1
13	Cooling fan	220V	1
12	Transformer	220V/ 26V/9V	1
11	Heater	220W	2
10	Transport potentiometer	150K	1
9	Potentiometer for the print position	470K	1
8	Print heater	60W	1
7	Heat coupling	0.35m/ EA	2
6	Print temperature controller	48X48	1
5	Print switch	321B	1
4	Cooling switch	321B	1
3	Heat switch	321B	1
2	Power switch	321B	1
1	Temperature controller	48X48	1



(Diagram 10)

1. knob for the wheel.
2. print wheel.
3. print core.
4. install board.
5. bearing base.
6. cushion.
7. chain wheel.
8. friction disk.
9. adjusting spring.
10. conducting ring.
11. stop pin.
12. electromagnetic core axes.
13. pull-off spring.
14. electromagnet.
15. electronic brush box.
16. silicon wheel.

The working principle of the print wheel when the photocell get the signal. The electromagnet begin work. The core axes would be su ck back meanwhile. The friction power between the chain wheel and the friction disk would dive the print wheel

## 11.MAINTENANCE&TROUBLESHOOTING OF INK WHEEL PRINTING MECHANISM

The ink wheel printing mechanism is tested and adjusted before the delivery,users don't need to adjust by themselves,but users should read the instruction carefully before operation.

Malfunction	Causes	Solution
Does not work	<ol style="list-style-type: none"> <li>1.no powe</li> <li>2.the main controlled circuit board is loose or did not conect closely.</li> <li>3.the main-controlled circuit board is broken.</li> <li>4.the motor is broken</li> </ol>	<ol style="list-style-type: none"> <li>1.check up the power,leads whether plus-in firmly or not,the indicator light works or not.</li> <li>2.checkout if the circuit board pin is loose or the thrum is break off.</li> <li>3.check out the circuit board and cange the elements if necessary.</li> <li>4.change the motor.</li> </ol>
The printing wheel doesn't work or rotating weakly.	<ol style="list-style-type: none"> <li>1.The contactor of sensoris blocked.</li> <li>2.The sensor is unclear,the Hole of sensor-couple is blocked up by the dirt.</li> <li>3.The printing distance controlled board is broken.</li> <li>4.The Electromagnet mandrel is blocked or inflexible.</li> <li>5.Open circuit of electromagnet.</li> <li>6.The wrench spring of clutch is abrasive</li> </ol>	<ol style="list-style-type: none"> <li>1.clean the obstructions away.</li> <li>2.clean up the dirty on the surface of the sensor couple.</li> <li>3.check out or changingthe elements.</li> <li>4.check out the mandrel.</li> <li>5.repair the electrical equipments.</li> <li>6.change the wrench spring.</li> </ol>
The printing wheel cant be heated	<ol style="list-style-type: none"> <li>1.The printing distance-controlled board is broken.</li> <li>2.The electromagnet mandrel is blocked or inflexible.</li> <li>3.the spring in the mandrel is broken.</li> <li>4.the stopping wheel is abrasive.</li> </ol>	<ol style="list-style-type: none"> <li>1.check out the circuit board, replace the elements.</li> <li>2.check out the mandrel.</li> <li>3.check out the spring.</li> <li>4.check out the stopping wheel or changing it if necessary.</li> </ol>

<p>the ink wheel or the printing wheel cant be heated</p>	<ol style="list-style-type: none"> <li>1.the electrothermal tube or the wire is broken.</li> <li>2.the temperature controller or heat-sensor is broken.</li> <li>3.the carbon brush holder shifts the position.</li> <li>4.the carbon brush is broken.</li> </ol>	<ol style="list-style-type: none"> <li>1.change the electrothermal tube or wire.</li> <li>2.change the elements.</li> <li>3.adjusted it in good place,tighten screws</li> <li>4.change it</li> </ol>
<p>The copper blocks are Out of the control of rising temperature</p>	<ol style="list-style-type: none"> <li>1.the thermal-couple or wire is broken.</li> <li>2.the heating tube is open circuit</li> <li>3.the temperature controller is broken</li> </ol>	<ol style="list-style-type: none"> <li>1.check out heating sensor or wire,change it if necessary</li> <li>2.change the heating tube</li> <li>3.check it out,change the elements</li> </ol>
<p>The printing is out of the position</p>	<ol style="list-style-type: none"> <li>1.the screws in the printing wheel are loose</li> <li>2.the sensor is broken</li> <li>3.the circuit board which adjusts the print distance broken</li> </ol>	<ol style="list-style-type: none"> <li>1.tighten the screws</li> <li>2.change the sensor</li> <li>3.check out or changing the elements.</li> </ol>

## 12.SPARE PARTS LIST

NAME	Specification	Quantity
Sealing belt	750×15×0.2mm	8pcs
Lead belt	610×6×4.2mm	2pcs
Power wire	3×0.5	1pc
Heating tube for printing	φ 10×28,110V 60W	1pc
Hexagon wrench	M5	1pc
Fuse tube	φ 5×20(5A)	2pcs
Cross screwdrier	4"	1pc
“-” screwdrier	4"	1pc
Solid ink	φ 36×15	1pc
“O” type belt	φ 35×φ 5	2pcs
Nords		2boxes
Silica gel circle	φ 39×φ 28×12	1pc
Power switch	220V	1pc
Crescent moon urench		1pc
instruction		1pc
Twist spring		1pc
Amount		26