



# USER MANUAL

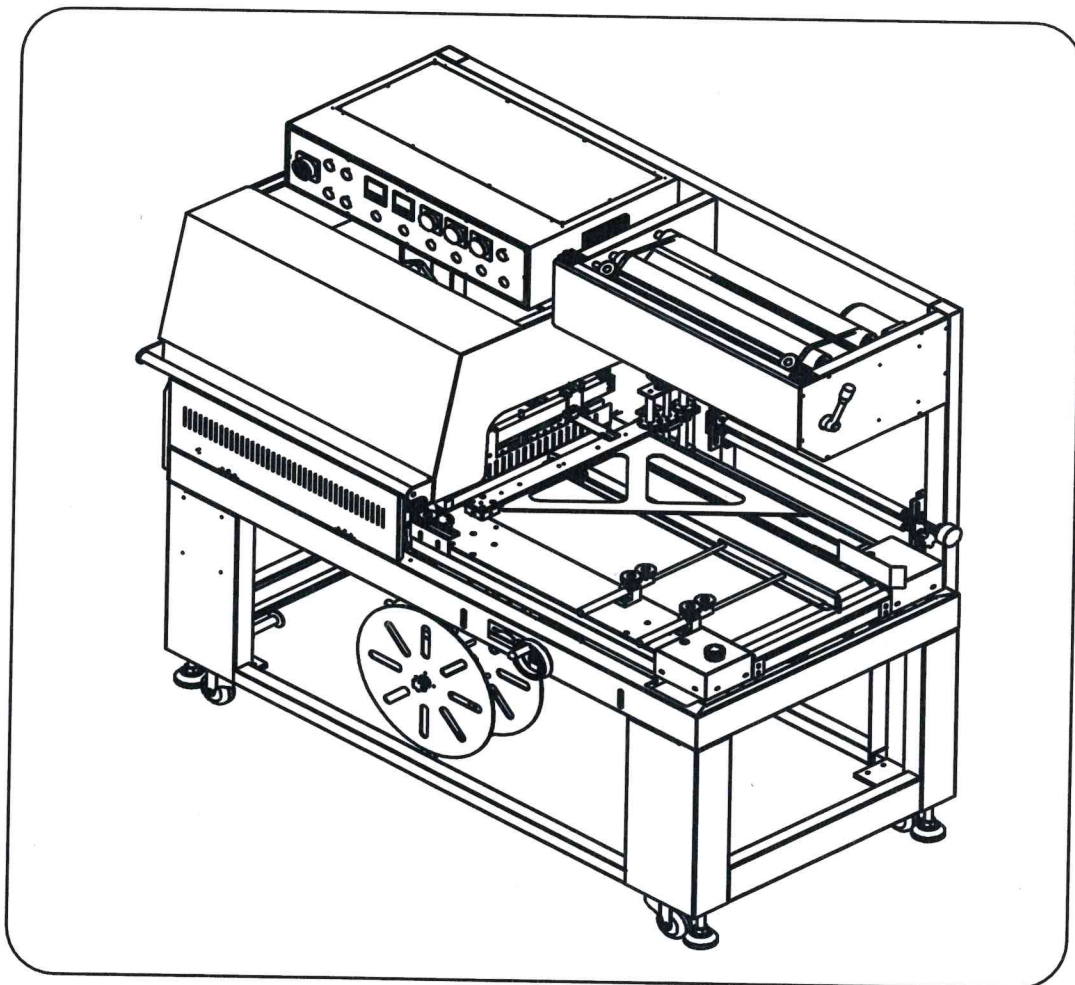
AUTOMATIC L SEALER – 5545TBA



# USER MANUAL

# **PHOENIX<sup>®</sup>**

## *Fill Weigh Pack*



FULL AUTOMATIC L'SEALER



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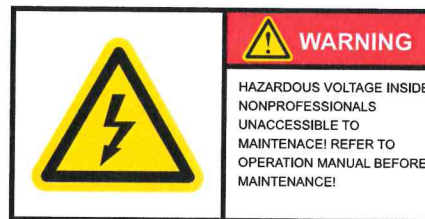
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## Safety Signs

Beware of the signs below to prevent mechanical damages or casualties due to improper operation



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# 1. Preface

## Summary

Thank you for using our products. It's your right choice to make you have a safe, practical, efficient and innovative automatic sealing packaging equipment.

This machine is of great versatility, economic benefits and operational convenience. It is suitable to fully wrap the products in small size and weight. With the supporting use of SM series constant temperature shrinking machines, the packing effect will be improved. And the superiority of this equipment will be more obvious in concert with the production line.

The whole machine, consisting of mainframe, electrical system, and pneumatic system is characterized as compact structure, power-saving, high sensitivity and operational simplicity. With the system controlled by PLC and the blade temperature by digital display temperature controller, the machine has high control precision. Sealing and cutting speed, knife temperature sealing, sealing and cutting time are adjustable. The products packed by this machine is neat, compact, which greatly enhances the products image. It's an advanced new type packing machine in full-closure versions.

## Readers' Guidance

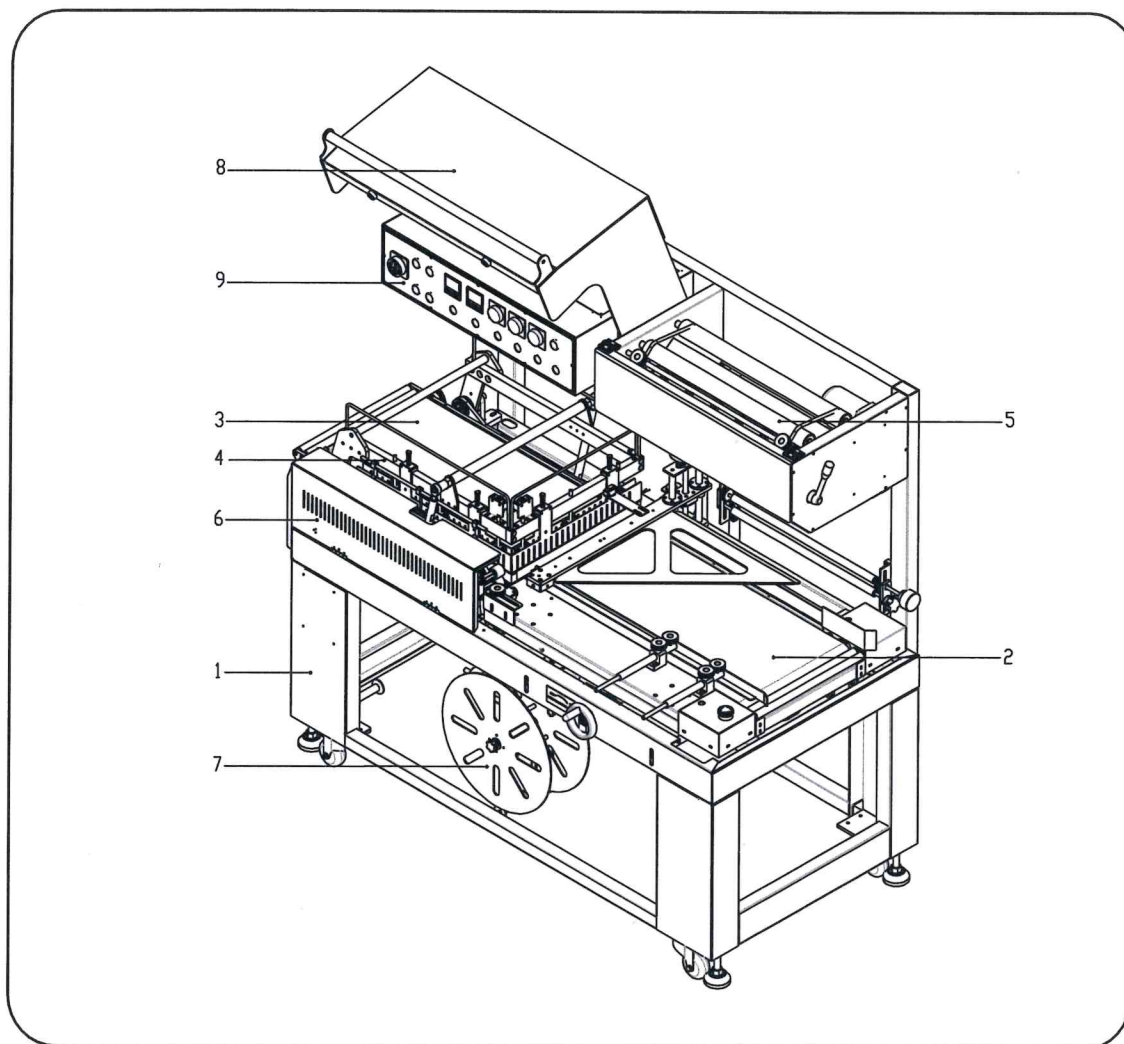
- A) Please read the manuals carefully before operate the machine.
- B) The manuals is the full description of the product, please keep it with the machine.
- C) Please do not delete or revise this manuals
- D) We reserve our right to revise this manual owing to continuous machine improvement.
- E) Please strictly adhere to the procedures in this manuals, incorrect operation will cause the damage of the machine or personnel casualties!

## Precautions for safety and use:

- ⚠ No other breakers or electricity wires without the equivalent capacity to this machine are allowed. Any usage of the breakers with smaller capacity or electricity wires with smaller diameters will cause damage of the circuit and major components.
- ⚠ Liquid materials, when packaged, shall not leak. Any usage of this machine to seal the poorly-sealed liquid materials may cause damage of the machine or electric shock.
- ⚠ Do not use machine in a highly humid environment; Do not expose the machine to enormous steam; Do not use or place this machine in a dusty places.
- ⚠ Hand off the sealing part in operation.
- ⚠ Do not place any metal objects in sealing parts ,or it will cause damage to the sealing blade.
- ⦿ Set the sealing time according to the film texture and its thickness normally 0.5-1.5 seconds. Any period shorter or longer will lead to poor sealing or cause damage to the Teflon tape .
- ⦿ Normal operation requires compressed air with the pressure at 6-7Kg/cm<sup>2</sup>, excess-low pressure will make the machine run abnormally.
- ⦿ Make proper reservation for such consumable parts as sealing blade, Teflon tape and silicone rubber. Cut off the power before replacing spare parts and replace according to the right steps.

## 2. Parts

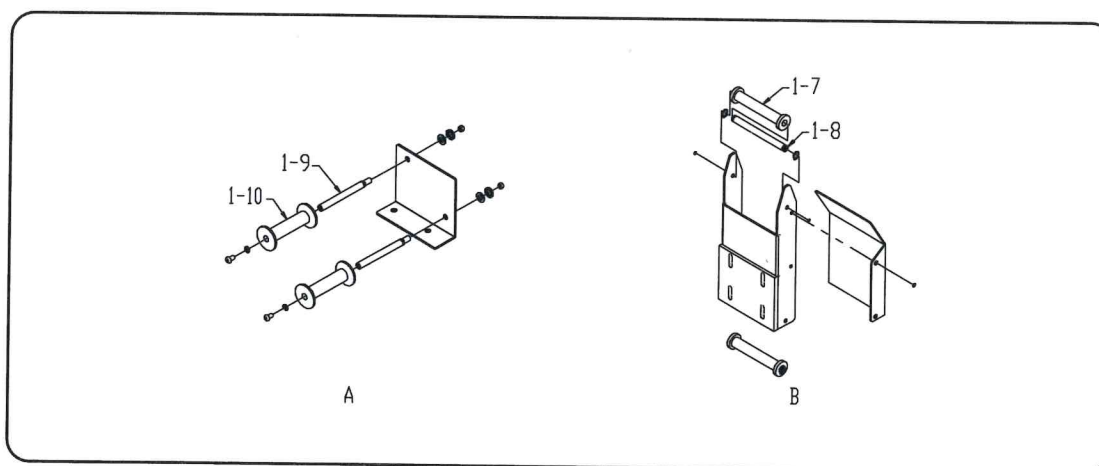
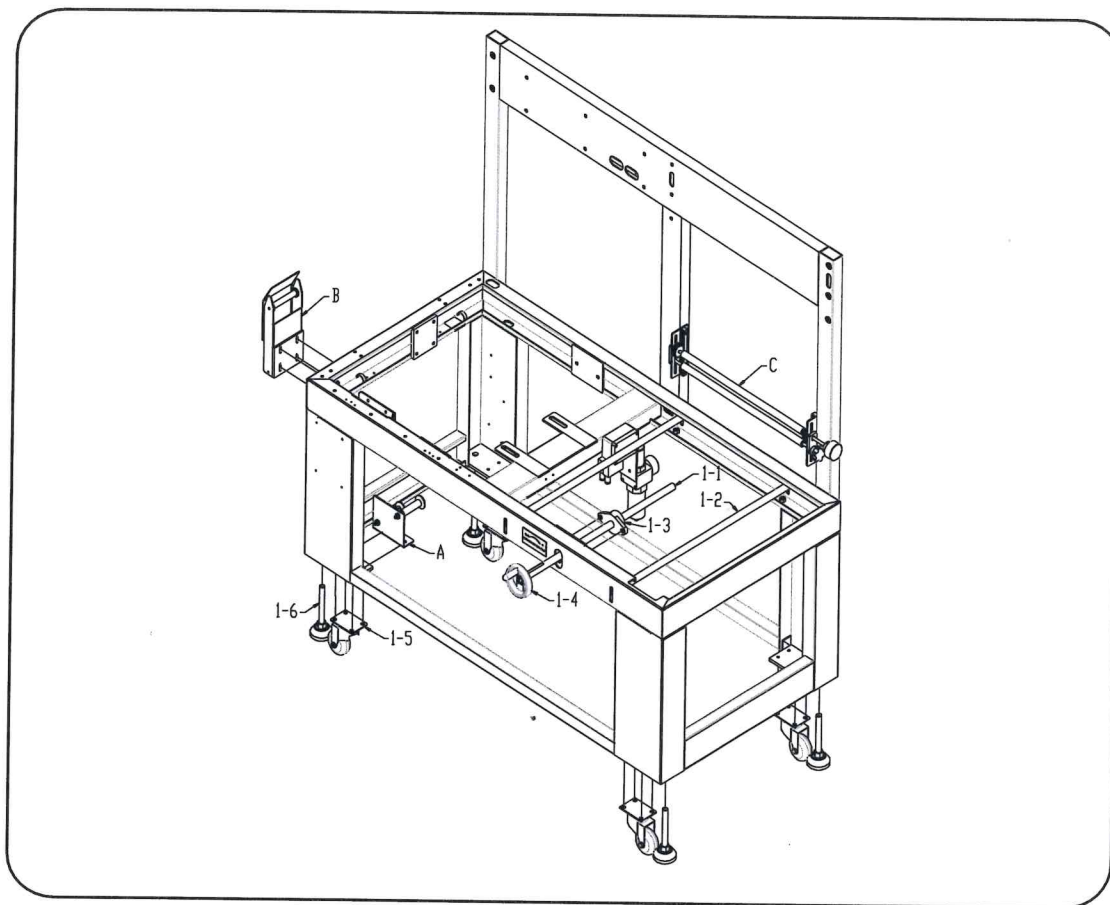
### ◆ General Assembly Drawing

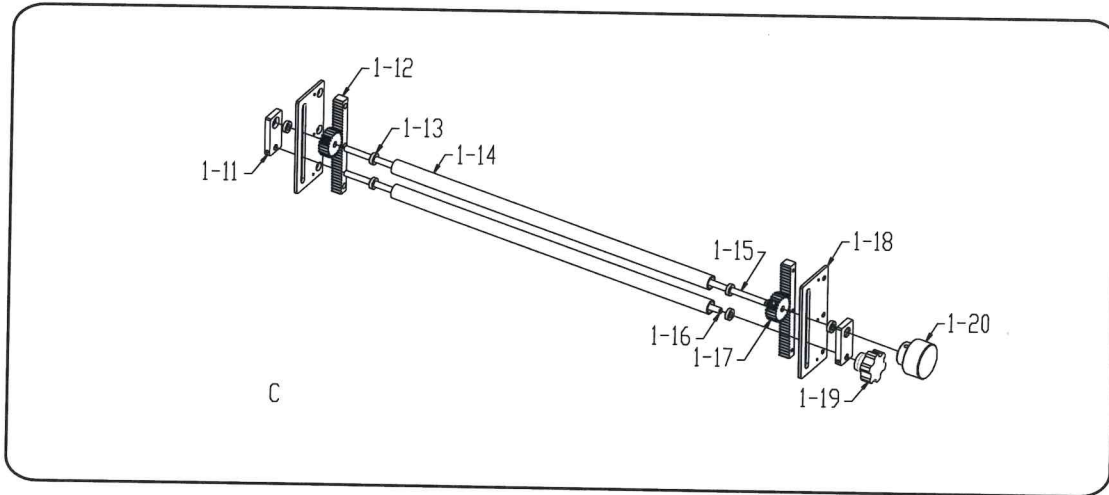


Code	Name
1	Frame
2	Front Conveying System
3	Rear Conveying System
4	Sealing System
5	Film Pulling System
6	Film Feeding System
7	Film Collecting System
8	Guard
9	Electrical Control Box



## ◆ Frame

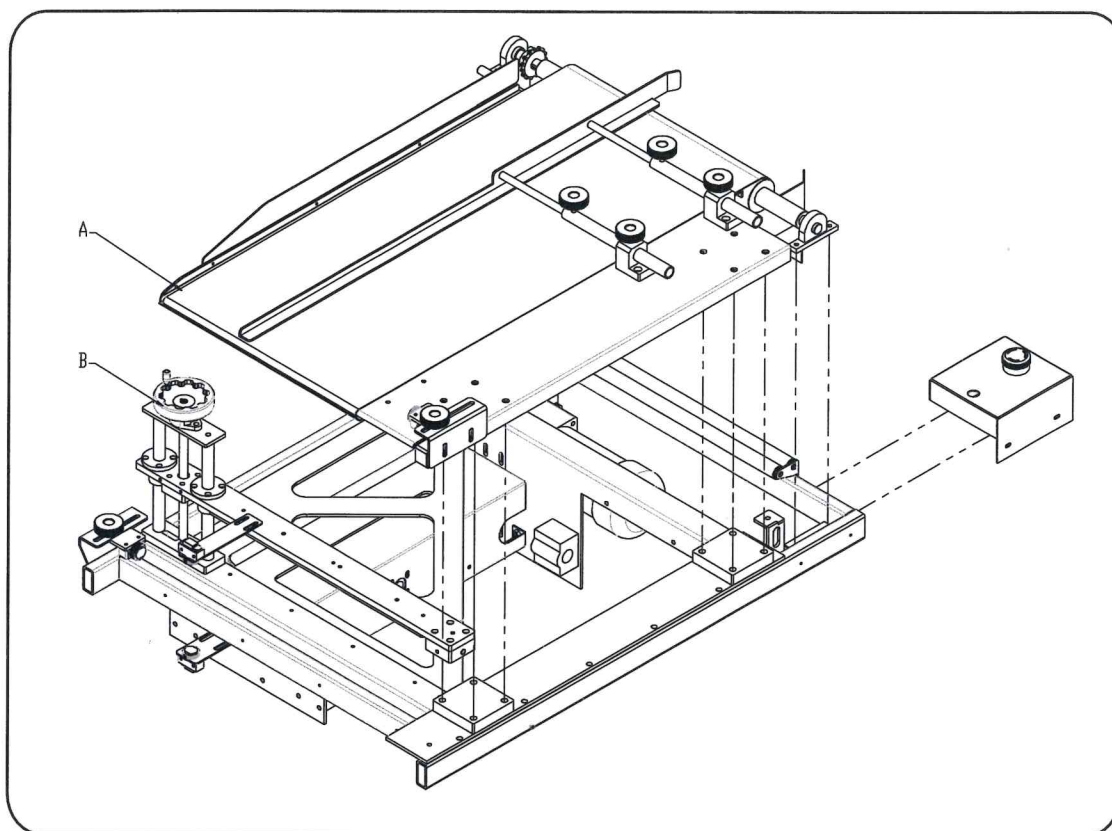


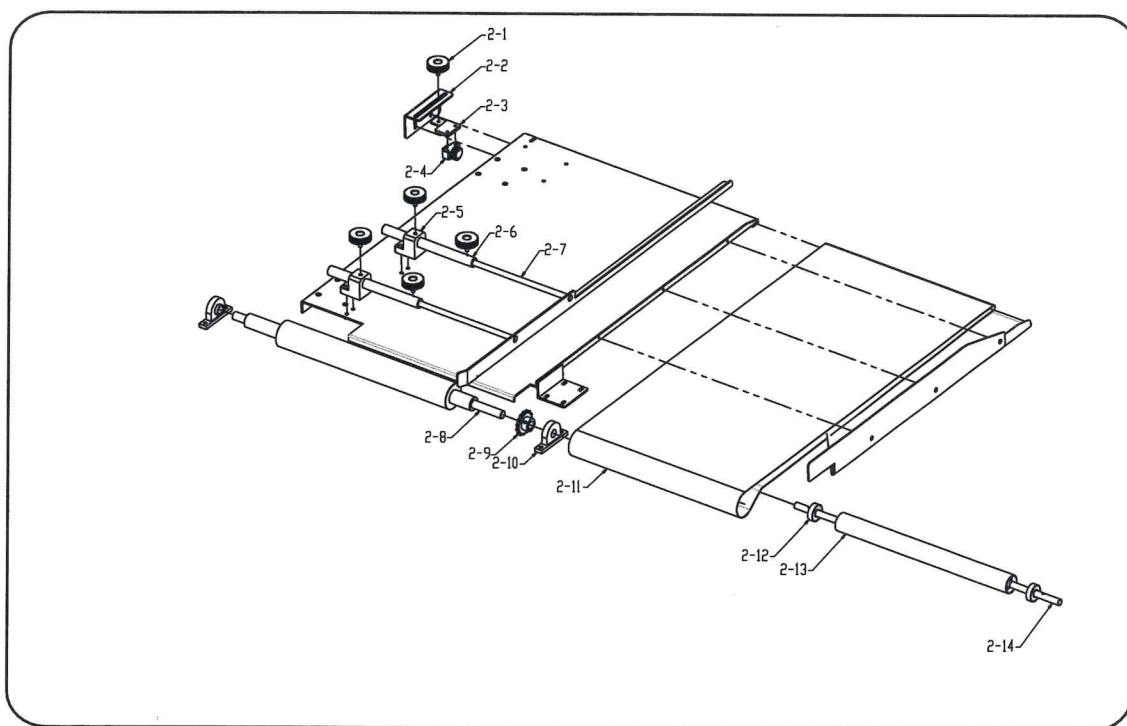


No.	Drawing No.	Name	Quantity
1-1	TBA. 3-21	Screw Rod	1
1-2	TBA. 1-6	Slide Rail Supporting Bar	2
1-3	UCFL204	Plummer Block	1
1-4	$\phi$ 12x100	Double Amplitude Hand Wheel	1
1-5	2-3689-52-99	3 Inch Castor	4
1-6	M16x150	Anchor Bolt	4
1-7	TBA. 2-13	Pulley	2
1-8	TBA. 2-4	Pulley Shaft	2
1-9	TBA. 2-39-2	Roller Shaft III-2	2
1-10	TBA. 2-41	Roller	2
1-11	TBA. 5-26-2-B	Adjusting Plate	2
1-12	TBA. 5-07	Slide Rack	2
1-13	688	Deep Groove Ball Bearing	6
1-14	TBA. 5-26-1	Drum	2
1-15	TBA. 5-26-2-B	Drum Shaft	1
1-16	TBA. 5-30-1	Drum Shaft	1
1-17	TBA. 5-33	Slide Gear	2
1-18	TBA. 5-26	Slide Rod Fixing Frame	2
1-19	AM8X32	M8 Internal-Crests Quincunx Handle	1
1-20	TBA. 5-31	Manual Adjusting Head	1



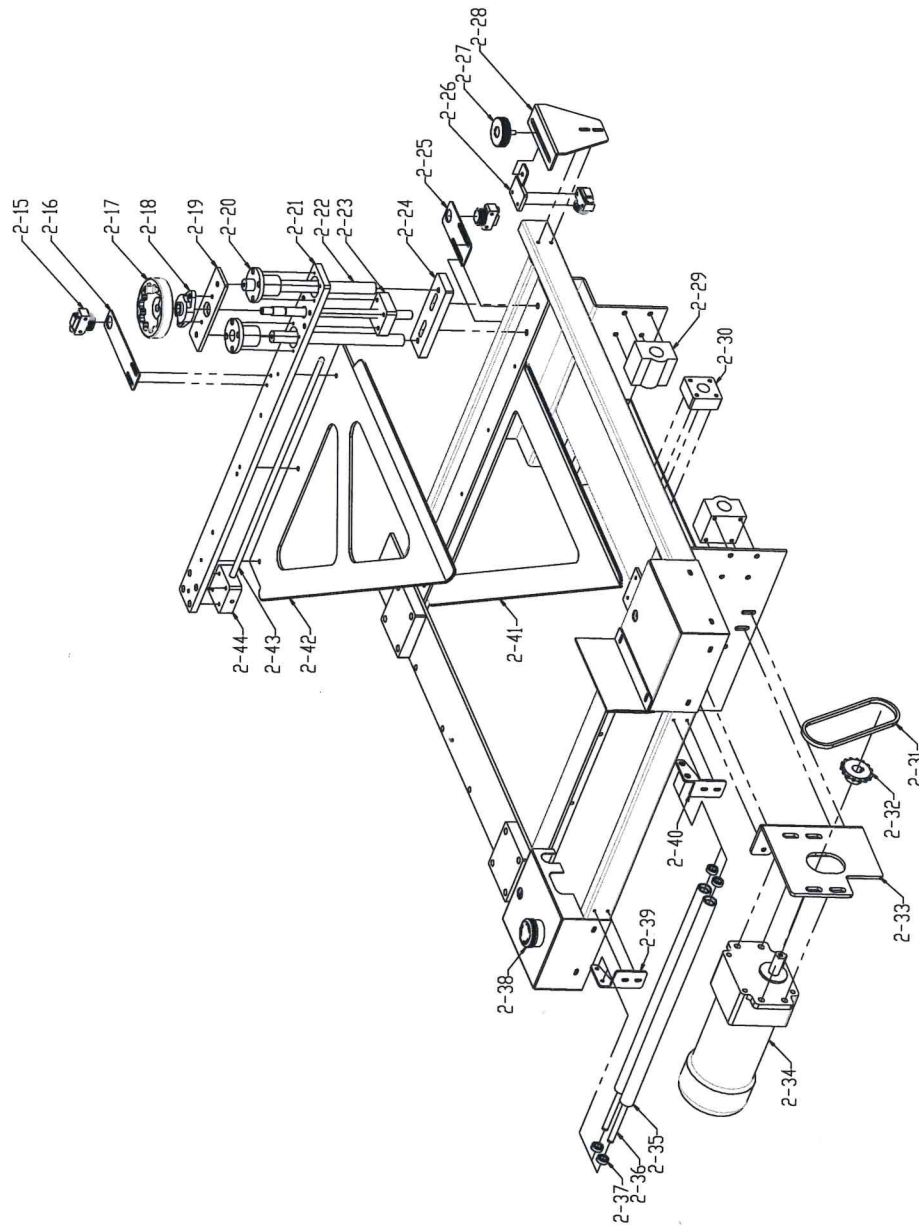
## ◆ Front Conveying System





No.	Drawing No.	Name	Quantity
2-1	BM6X32X10	Plastic Quincunx Handle	5
2-2	TBA. 3-2-B	Front Horizontal Photocell Support	1
2-3	TBA. 3-3-1	Photocell Switch Mounting Plate	1
2-4	QS186E/QS18VN6R	Correlation Photocell	1
2-5	TBA. 3-10-B	Adjusting Shaft Supporting Seat	2
2-6	TBA. 03-26	Adjusting Shaft Sleeve	2
2-7	TBA. 03-25	Adjusting Shaft	2
2-8	TBA. 3-30	Driving Drum	1
2-9	TBA. 00	Sprocket	2
2-10	UP002	Plummer Block	2
2-11	1648X375X1.2	Front Conveying Belt	1
2-12	6201	Deep Groove Ball Bearing	2
2-13	TBA. 3-29-2	Auxiliary Drum Shaft Sleeve	1
2-14	TBA. 3-29-1	Auxiliary Drum Axis	1

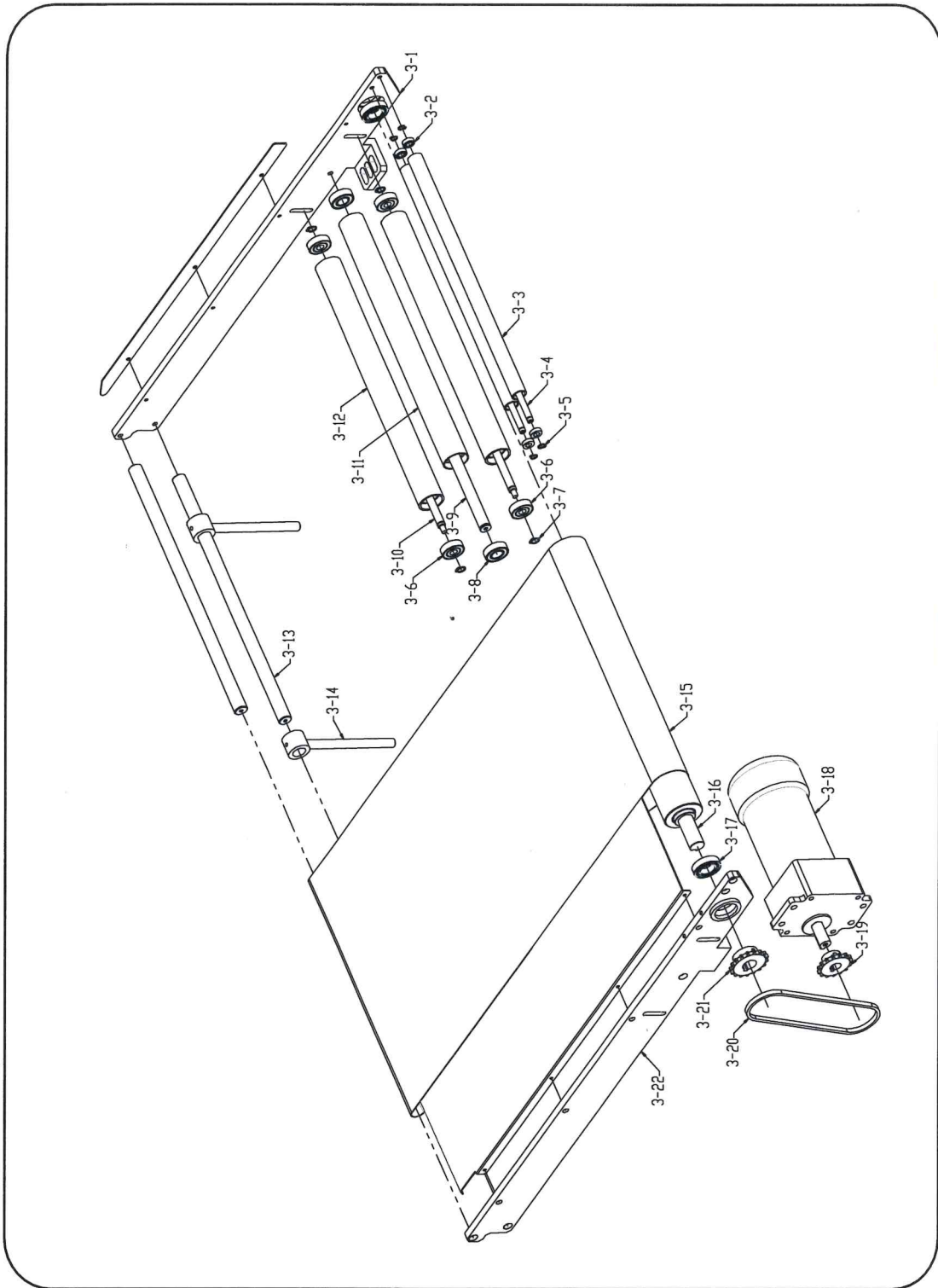




No.	Drawing No.	Name	Quantity
2-15	QS186E/QS18VN6R	Correlation Photocell	1
2-16	TBA. 3-13-1	Sensor Switch Support III	1
2-17	10x80 2-M5	Hand Wheel	1
2-18	UFL001	Plummer Block	1
2-19	TBA. 3-8	Hand Wheel Mounting Plate	1
2-20	LMF16AUU	Linear Slide Block	2
2-21	TBA. 3-6A	Lifting Slide Plate	1
2-22	TBA. 3-5	Lifting Frame Fixing Rod	2
2-23	TBA. 3-01	Lifting Small Nut	1
2-24	TBA. 3-4	Lifting Frame Fixing Plate	1
2-25	TBA. 3-13-2	Sensor Switch Support III	1
2-26	TBA. 3-3-1	Photocell Switch Mounting Plate	1
2-27	BM6X32X10	Plastic Quincunx Handle	1
2-28	TBA. 3-2A	Horizontal Photocell Support 2	1
2-29	SC20UU	Linear Slide Block	4
2-30	TBA. 3-22	Nut	1
2-31	06B	Chain	1
2-32	TBA. 00	Sprocket	2
2-33	TBA. 3-37	Front Conveying Motor Mounting Plate	1
2-34	GP15-0090-15A	Motor	1
2-35	TBA. 3-35-2	Supporting Shaft Sleeve	2
2-36	TBA. 3-35-1	Supporting Shaft Axis	2
2-37	688	Deep Groove Ball Bearing	4
2-38	A22-RPV-EK01	Emergency Stop Button	1
2-39	TBA. 3-49-B	Auxiliary Drum Mounting Support	1
2-40	TBA. 3-49-B-RL	Auxiliary Drum Mounting Support	1
2-41	TBA. 3-14	Lower Triangular Plate	1
2-42	TBA. 3-11	Upper Triangular Plate	1
2-43	TBA. 3-47	Film Blowing Rod	1
2-44	TBA. 3-07	Film Blowing Rod Fixing	1

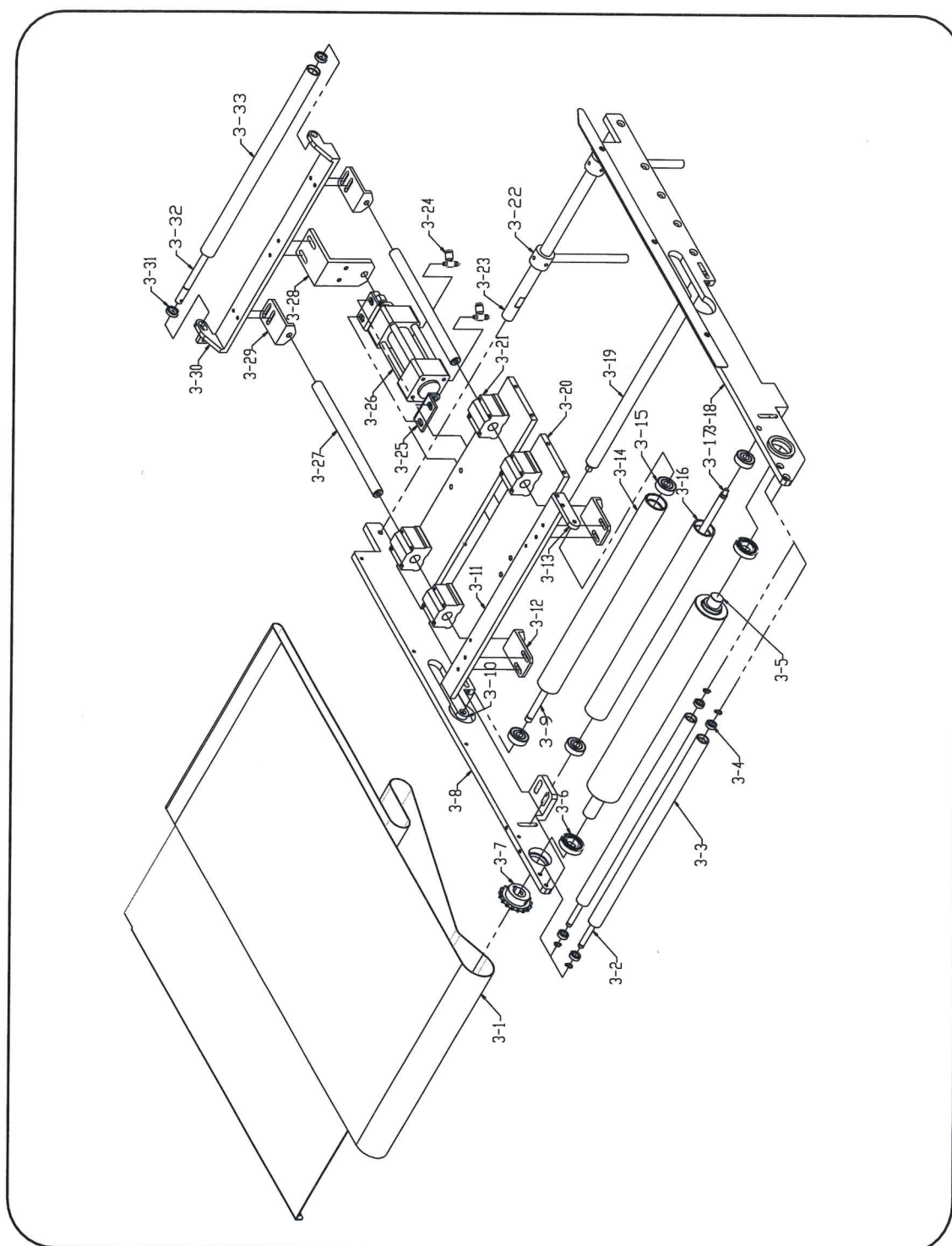


◆ Rear Conveying System



No.	Drawing No.	Name	Quantity
3-1	TBA. 4-01-B	Conveying Left Support	1
3-2	688	Deep Groove Ball Bearing	2
3-3	TBA. 4-08	Rear Conveying Auxiliary Drum Shaft Sleeve	2
3-4	TBA. 4-07	Rear Conveying Auxiliary Drum Axis	2
3-5	φ 8	Sanp Spring for Shaft	4
3-6	6200	Deep Groove Ball Bearing	4
3-7	φ 10	Sanp Spring for Shaft	4
3-8	6002	Deep Groove Ball Bearing	2
3-9	TBA. 4-13-1	Drum II-Shaft	1
3-10	TBA. 4-9-1-B	Drum I-Shaft	2
3-11	TBA. 4-13-2	Drum II-Sleeve	1
3-12	TBA. 4-9-2-B	Drum I-Sleeve	2
3-13	TBA. 4-21	Fixing Rod	2
3-14	TBA. 4-22	Screw Rod	2
3-15	1555X385X1. 2	Rear Conveying Belt	1
3-16	TBA. 04-03-1	Driving Drum	1
3-17	6904	Deep Groove Ball Bearing	2
3-18	GP15-0090-15A	Motor	1
3-19	TBA. 00	Sprocket	1
3-20	06B	Chain	1
3-21	TBA. 00	Driven Sprocket	1
3-22	TBA. 4-02-B	Conveying Right Support	1

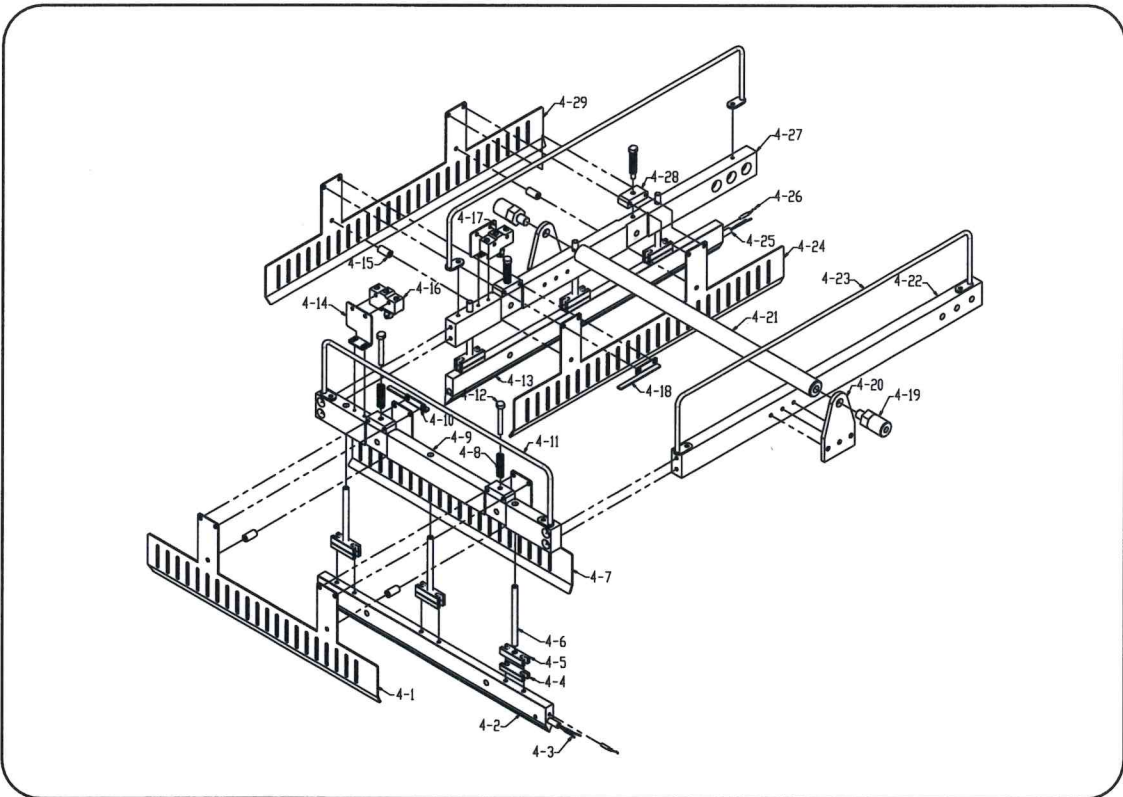
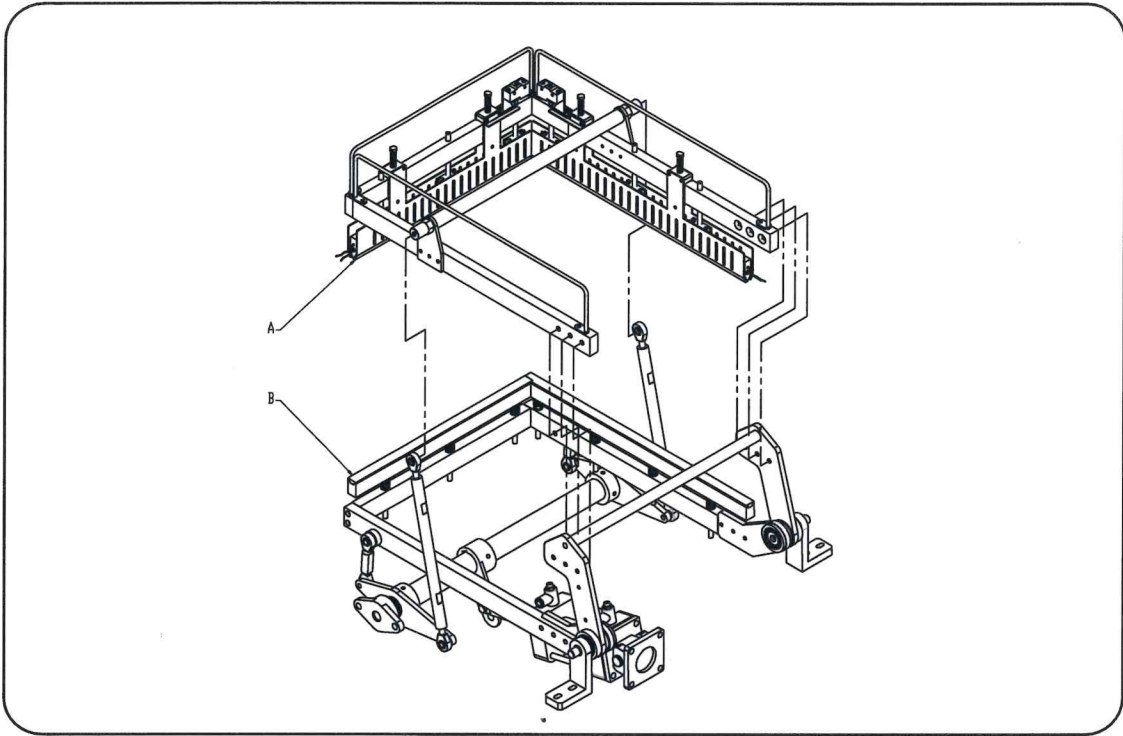
◆ Rear Conveying System With Kissing Device  
(IPM-5545TBB/6550TBB Model)





No.	Drawing No.	Name	Quantity
3-1	1780X385X1.2	Rear Conveying Improving Belt	1
3-2	TBA. 4-07	Rear Conveying Auxiliary Drum Axis	2
3-3	TBA. 4-08	Rear Conveying Auxiliary Drum Shaft Sleeve	2
3-4	688	Deep Groove Ball Bearing	4
3-5	TBA. 04-03-1	Driving Drum	1
3-6	6904	Deep Groove Ball Bearing	2
3-7	TBA. 00	Sprocket	1
3-8	TBB. 4-02M-B	Conveying Right Support	1
3-9	A. 4-13M-2	Drum II-Shaft	1
3-10	TBA. 4-14M-2	Slide Rail Front Fixing Plate-2	1
3-11	TBA. 4-14M-1	Slide Rail Front Fixing Plate-1	1
3-12	TBA. 4-04M	Guide Bar Fixing Plate	2
3-13	TBA. 4-14M-2-L	Slide Rail Front Fixing Plate-2	1
3-14	TBA. 4-13M-1	Drum II-Sleeve	1
3-15	6200	Deep Groove Ball Bearing	4
3-16	TBA. 4-9-2	Drum I	1
3-17	TBA. 4-9-1	Drum I	1
3-18	TBB. 4-01M-B	Conveying Left Support	1
3-19	TBA. 4-34-M	Kissing Device Tension Shaft	1
3-20	TBA. 4-12M	Cylinder Fixing Plate	2
3-21	SCS16AUU	Linear Bearing	4
3-22	TBA. 4-22	Screw Rod	2
3-23	TBA. 4-21M	Fixing Rod	1
3-24	JSC8-02AT	Cylinder Speed-Adjusting Connector	
3-25	TBB. 4-24M	Cylinder Mounting Seat	2
3-26	IC40B40	Air Cylinder	1
3-27	TBA. 4-25M	Guide Bar	2
3-28	TBA. 4-20M	Guide Bar Connecting Plate	2
3-29	TBA. 4-19M	Cylinder Connector	1
3-30	TBA. 4-15M	Slide Rail Rear Fixing Plate	1
3-31	61800	Deep Groove Ball Bearing	2
3-32	TBA. 4-16-01-M	Kissing Device Drum Shaft Axis	1
3-33	TBA. 4-16-02-M	Kissing Device Drum Shaft Sleeve	1

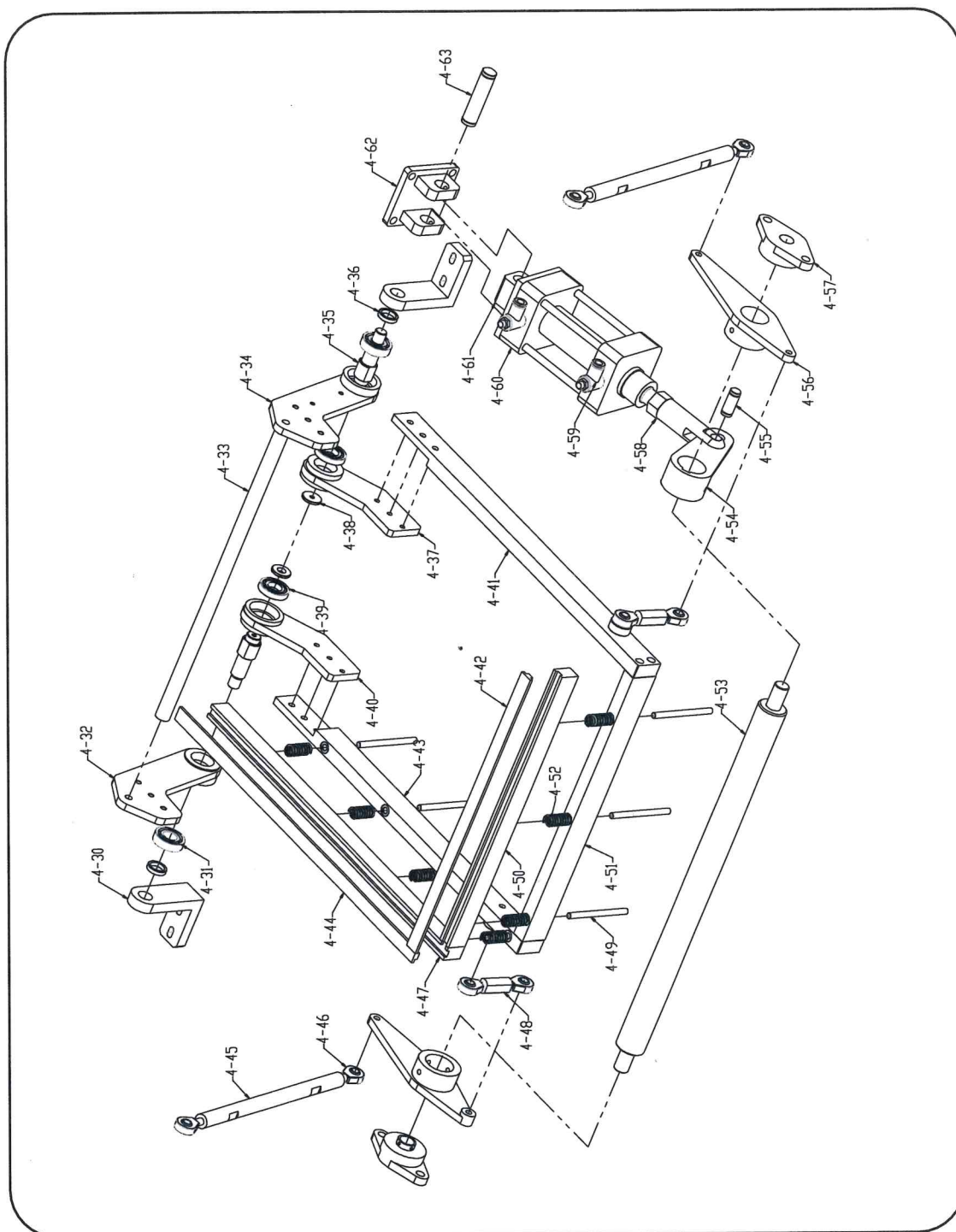
# ◆ Sealing System



No.	Drawing No.	Name	Quantity
4-1	TBA. 6-22-B	Horizontal Sealing Slot Guard I	1
4-2	TBA. 6-19	Horizontal Sealing Blade	1
4-3	Φ 8x539/1200W220V	Horizontal Sealing Heater	2
4-4	TBA. 6-48-B	Heat Insulater	6
4-5	TBA. 6-47-B	Fixing Adjustable Block	6
4-6	TBA. 6-31	Screw Rod	6
4-7	TBA. 6-23-B	Horizontal Sealing Slot Guard II	1
4-8	0. 7X9X38	Sealing Blade Guard Pressure Spring	4
4-9	TBA. 6-19-3-B	Horizontal Sealing Blade Frame	1
4-10	TBA. 6-30-1	Micromovement Switch Contactor	1
4-11	TBA. 6-25	Cable Tray A	1
4-12	TBA. 6-7A	Sealing Plate Screw Rod	4
4-13	TBA. 6-18	Vertical Sealing Blade	1
4-14	TBA. 6-24-1	Micromovement Switch Mounting Plate	1
4-15	TBA. 6-44	Supporting Rod	4
4-16	Z-15GW22-B	Micromovement Switch 2	2
4-17	TBA. 6-24-2	Micromovement Switch Mounting Plate	1
4-18	TBA. 6-30-2	Micromovement Switch Contactor	1
4-19	TBA. 6-11	Supporting Rod II Connecting Rod	2
4-20	TBA. 6-18-5	Vertical Sealing Lower Pressure Plate	2
4-21	TBA. 6-10-B	Supporting Rod II	1
4-22	TBA. 6-18-4-B	Vertical Frame Plate 2	1
4-23	TBA. 6-26	Cable TrayB	2
4-24	TBA. 6-21-B	Vertical Sealing Slot Guard II	1
4-25	Φ 8X455/900W/220V	Vertical Sealing Heater	1
4-26	3. 8m/K&4. 8m/K	Thermocouple	2
4-27	TBA. 6-18-3-B	Vertical Frame Plate	1
4-28	TBA. 6-7	Sealing Slot Guard Mounting Block	4
4-29	TBA. 6-20-B	Vertical Sealing Slot Guard I	1

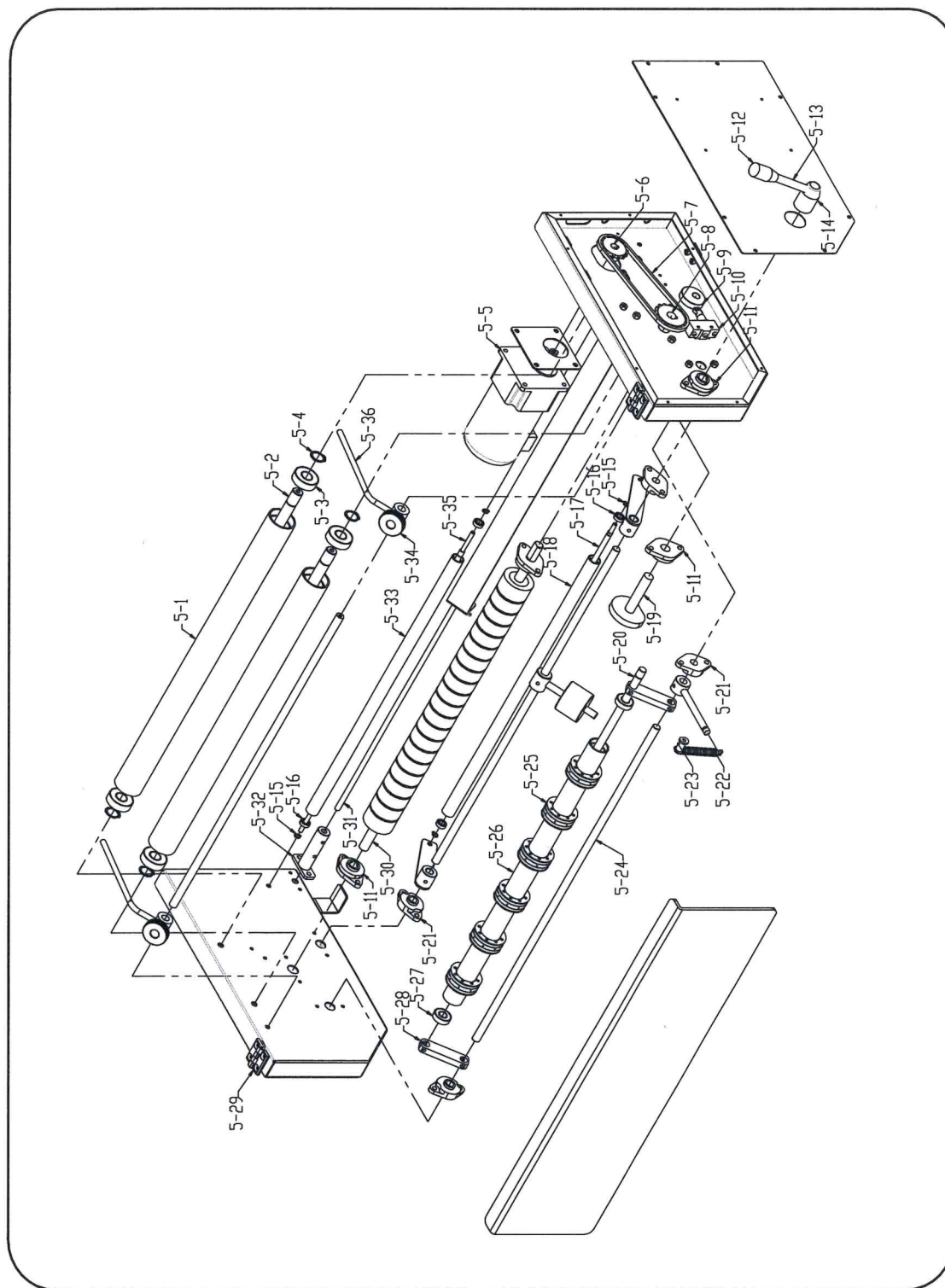


## ◎ Lower Sealing Blade Part



No.	Drawing No.	Name	Quantity
4-30	TBA. 4-26-B	Sealing Fixing Seat Right	2
4-31	6004	Deep Groove Ball Bearing	2
4-32	TBA. 6-36-B	Upper Sealing Connecting Plate(Right)	1
4-33	TBA. 6-9-B	Supporting Rod I	1
4-34	TBA. 6-37-B	Upper Sealing Connecting Plate(Left)	1
4-35	TBA. 4-27-B	Sealing Connecting Plate Fixing Axis	2
4-36	TBA. 4-28-B	Spacing Sleeve	2
4-37	TBA. 6-38-B	Lower Sealing Connecting Plate(Right)	1
4-38	TBA. 4-29-B	Bearing Retaining Ring	2
4-39	16004	Deep Groove Ball Bearing	2
4-40	TBA. 6-39-B	Lower Sealing Connecting Plate(Left)	1
4-41	TBA01-06-047-A	Lower Blade Frame A	1
4-42	TBA. 6-47-C	Horizontal Sealing Blade Rubber	1
4-43	TBA01-06-048-A	Lower Blade Frame B	1
4-44	TBA. 6-48-C	Vertical Sealing Blade Rubber	1
4-45	TBA. 6-42	Upper Sealing Connecting Rod	2
4-46	POSA10/POSA10L	Joint bearing	8
4-47	TBA. 6-29	Rubber Groove II	1
4-48	TBA. 6-43	Upper Sealing Connecting Rod II	2
4-49	TBA. 6-31	Screw Rod	13
4-50	TBA. 6-28	Rubber Groove I	1
4-51	TBA01-06-049-A	Lower Blade FrameC	1
4-52	2. 5X14X36	Sealing Blade Lower Seat Pressure Spring	7
4-53	TBA. 6-5	Cylinder Connecting Shaft	1
4-54	TBA. 6-4	Cylinder Connecting Rod	1
4-55	TBA. 6-45-1-B	Cylinder Connecting Rod Cross-Pin	1
4-56	TBA. 6-2	Cylinder Connecting Rod Seat II	1
4-57	UCFL204 (20-90)	Plummer Block	2
4-58	IC80B55-1	Air Cylinder	1
4-59	JSC10-03AT	Adjusting Valve	2
4-60	IC80B55-2	Air Cylinder	1
4-61	TBA. 6-46-B	Cylinder Seat	1
4-62	TBA. 6-33-B	Cylinder Connecting Seat	1
4-63	TBA. 6-32-B	Cylinder Pin	1

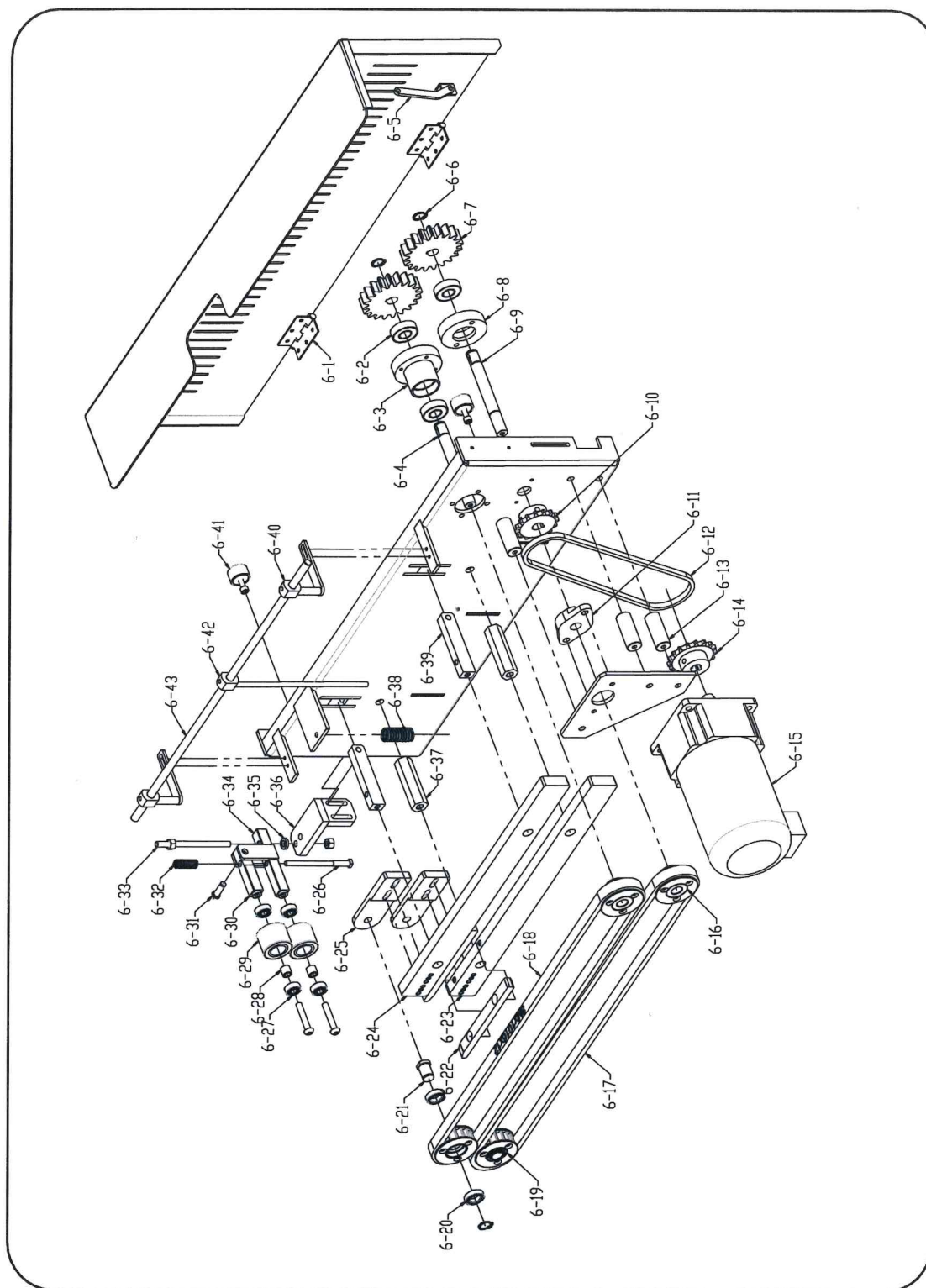
# ◆ Film Feeding System





No.	Drawing No.	Name	Quantity
5-1	TBA. 5-18-2	Drum I-Sleeve	2
5-2	TBA. 5-18-1	Drum I -Shaft	2
5-3	6203	Deep Groove Ball Bearing	4
5-4	φ 20	Sanp Spring For Shaft	4
5-5	GV12-0045-15A	Motor	1
5-6	TBA. 00	Sprocket	1
5-7	06B	Chain	1
5-8	TBA. 00	Sprocket	1
5-9	TBC01-06-032-A	Eccentric	1
5-10	Z-15GQ22-B	Micromovement Switch 1	1
5-11	UFL002	Plummer Block	4
5-12	M10x55	Handle Sleeve	1
5-13	TBA. 5-35	Handle Wheel	1
5-14	TBA. 5-34	Handle Wheel Connecting	1
5-15	φ 8	Sanp Spring For Shaft	4
5-16	628-8z	Deep Groove Ball Bearing	4
5-17	TBA. 5-6-2	Guide Bar IIA-Sleeve	1
5-18	TBA. 5-6-1	Guide Bar IIA-Sleeve	1
5-19	TBH01-06-014-A	Handle Wheel	1
5-20	TBA. 5-21-1	Perforator Shaft I-Shaft	1
5-21	UFL001	Plummer Block	4
5-22	2X10X78	Film Feeding Perforator	1
5-23	TBA. 5-14	Tension Spring Rod	1
5-24	TBA. 5-19	Guide Bar V	2
5-25	TBH01-06-020-3-A	Perforator	6
5-26	TBA. 5-21-2	Perforator Shaft I-Sleeve	1
5-27	6001	Deep Groove Ball Bearing	2
5-28	TBA. 5-20	Connecting Plate	2
5-29	40X40	Hinge	2
5-30	TBA. 5-25	Perforator Shaft II	1
5-31	TBA. 5-8-1	Guide Bar III-1	1
5-32	TBA. 5-8-2	Film Spacing Rod Seat	1
5-33	TBA. 5-5-1	Guide Bar I-Sleeve	1
5-34	BM6X32X10	Plastic Quincunx Handle	2
5-35	TBA. 5-5-2-B	Guide Bar I-Shaft	1
5-36	TBA. 5-13	Jantho Rod	2

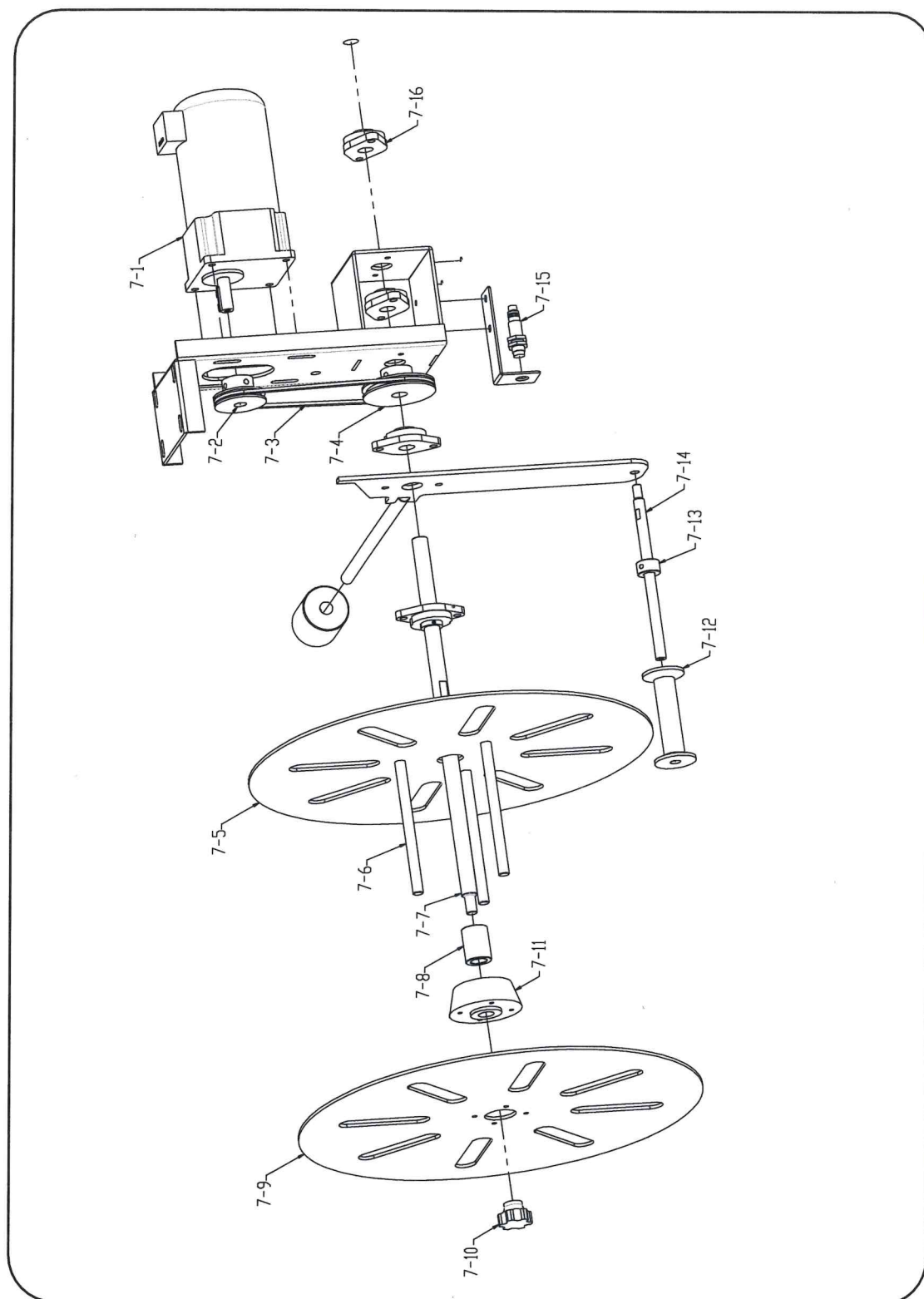
# ◆ Film Pulling System



No.	Drawing No.	Name	Quantity
6-1	2寸	Stainless Hinge	4
6-2	6001	Deep Groove Ball Bearing	3
6-3	TBA. 2-34	Sprocket Seat II	1
6-4	TBA. 2-14	Sprocket Shaft 2	1
6-5	TBA. 2-45	Connecting Plate	1
6-6	φ 12	Sanp Spring For Shaft	4
6-7	TBA. 2-16	Gear	2
6-8	TBA. 2-33	Sprocket Seat I	1
6-9	TBA. 2-14A	Sprocket Shaft 1	1
6-10	TBA. 00	Sprocket	1
6-11	UFL001	Plummer Block	1
6-12	06B	Chain -Film Pulling Drive	1
6-13	TBA. 2-8-B	Sprocket Mounting Plate Mounting Post	3
6-14	TBA. 00	Sprocket	1
6-15	GV12-0045-15A	Motor	1
6-16	TBA. 2-56-01-B	Driving Timing Wheel	2
6-17	HTD1080x8Mx12	Film Pinching Timing Belt	1
6-18	HTD1016x8Mx12	Film Pinching Timing Belt	1
6-19	TBA. 2-55-01-B	Driven Timing Wheel	2
6-20	6801	Deep Groove Ball Bearing	4
6-21	TBA. 2-18B	Film Pulling Driven Timing Wheel Axis	2
6-22	TBA. 2-17-B	link plate I	2
6-23	TBA. 2-18-L	link plate	1
6-24	TBA. 2-18	link plate	1
6-25	TBA. 2-18A	Adjusting Plate	2
6-26	TBA. 2-49-B	Pressure Spring Guide Post	1
6-27	606	Deep Groove Ball Bearing	4
6-28	TBA. 2-57-B	Film Pinching Wheel Spacer Ring	2
6-29	TBA. 2-46-B	Film Pinching Wheel	2
6-30	TBA. 2-47-B	Upper Film Pinching Wheel Support	1
6-31	TBA. 2-51-B	Film Pinching Wheel Axis Rotary Pin	1
6-32	1x9x25	Film Pinching Pressure Spring	1
6-33	TBA. 2-53-B	Lower Support Mounting Screw Rod	1
6-34	TBA. 2-48-00-BB	Lower Film Pinching Wheel Support	1
6-35	TBA. 2-50-B	Film Pinching Wheel Spacer Cushion	1
6-36	TBA. 2-54-B	Film Holding Assembly Mounting Seat	1
6-37	TBA. 2-9	link plate Support Rod II	2
6-38	1. 6X13X32	Film Pulling Pressure Spring	1
6-39	TBA. 2-6B	Timing Belt Clamping Support Rod	2
6-40	TBA. 2-22A	Film Spacing Rod Connecting Rod Fixing Seat	2
6-41	MGCE1	Magnet Assembly	2
6-42	TBA. 2-22	Film Spacing Rod Connecting Rod	1
6-43	TBA. 2-21	Film Spacing Rod	1

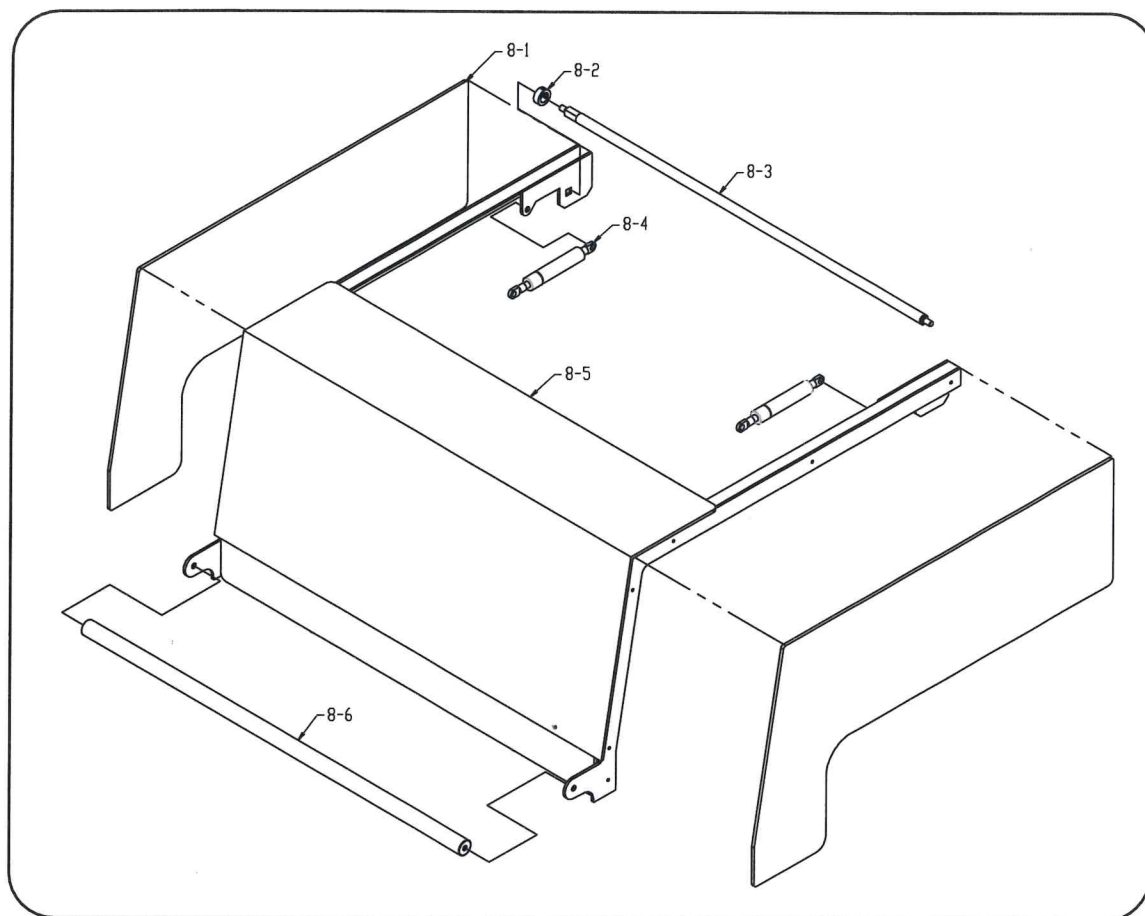


## ◆ Film Collecting System



No.	Drawing No.	Name	Quantity
7-1	GV12-0045-15A	Motor	1
7-2	TBA. 2-28	Pulley II	1
7-3	MB10x480	Film Pulling Jugged V Belt	1
7-4	TBA. 2-27	Pulley I	1
7-5	TBA. 2-5-1-B	Rear Material Reel-1	1
7-6	TBA. 2-5-2-B	Rear Material Reel-2	3
7-7	TBA. 2-25-B	Film Collecting Central Shaft	1
7-8	TBA. 2-5-3-B	Rear Material Reel-3	1
7-9	TBA. 2-26B	Material Reel B	1
7-10	AM10X50	Plastic Quincunx Handle	
7-11	TBA. 2-6C	Material Reel Connecting Block	1
7-12	TBA. 2-41	Wheel	1
7-13	TBA. 2-44	Film Collecting Diverting Rod Sleeve	1
7-14	TBA. 2-39-1	Wheel Shaft III-1	1
7-15	IME12-04NNSZW2S	Proximity Switch	1
7-16	UFL002	Plummer Block	4

## ◆ Guard



No.	Drawing No.	Name	Quantity
8-1	TBA. 4F-009	Side Guard Plate	2
8-2	TBC01-08-004-A	Retaining Sleeve	1
8-3	TBA. 4F-3	Connecting Rod	1
8-4	QD19-240x82x450N-GG	Pneumatic Spring	2
8-5	TBA. 4F-008	Upper Guard Plate	1
8-6	TBA. 4F-5	Handle	1

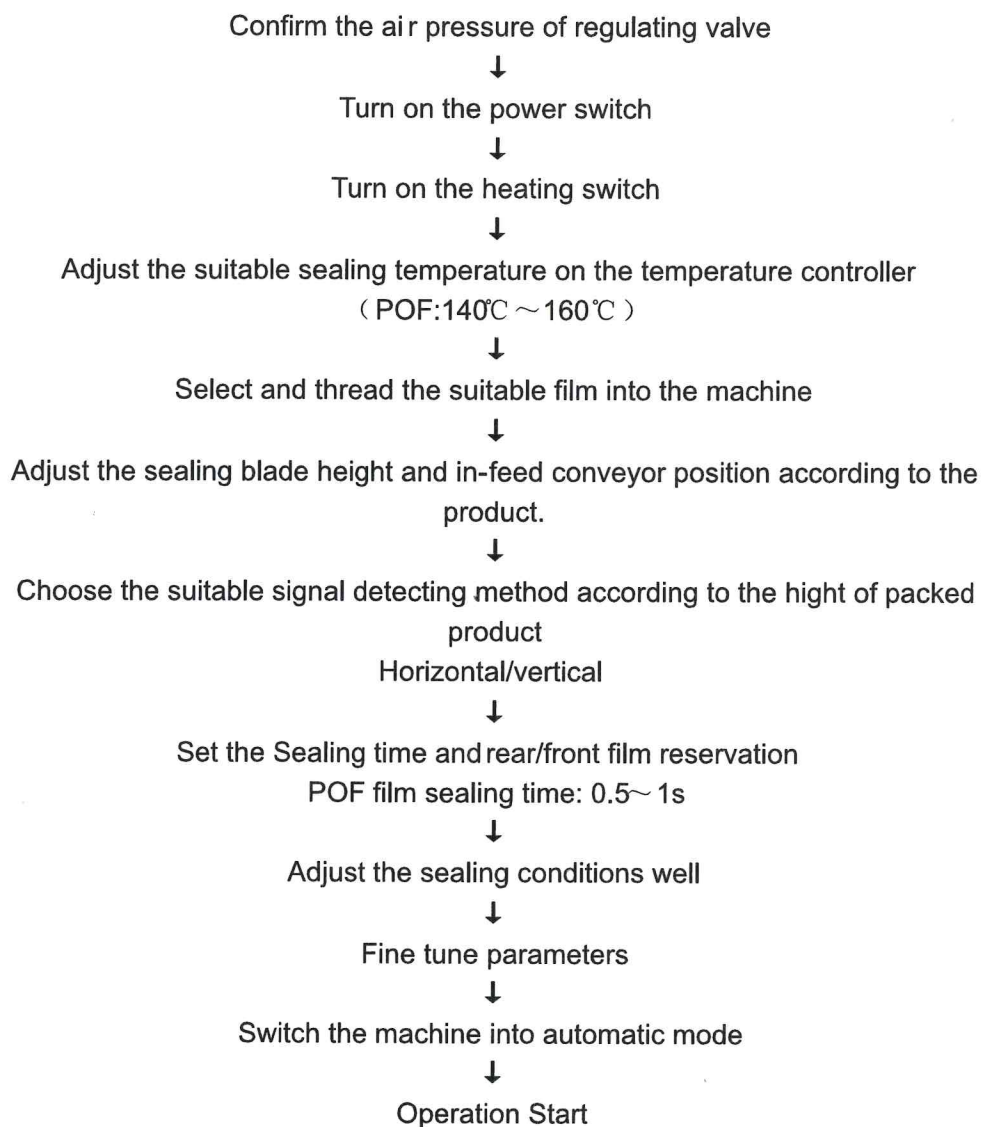


### 3. Technical Parameter

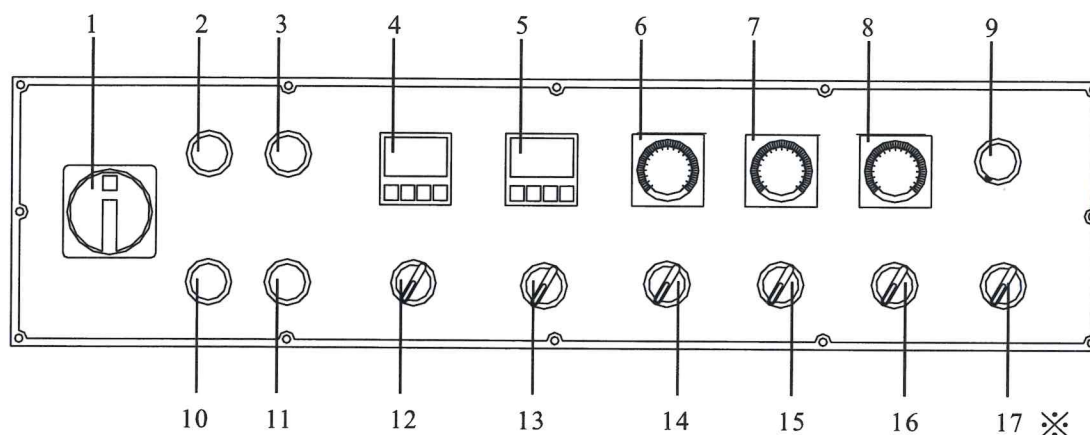
Spec. \ Model	IPM - 5545TBA/B	IPM - 6560TBA/B
Power Supply	1PH AC220V 50/60Hz	
Power	2.5KW	3.0KW
Air Source Pressure	6~7Kg/cm <sup>2</sup>	
External Dimension	L=1685mm	L=1940mm
	W=828mm	W=1000mm
	H=1480mm	H=1480mm
Conveying Speed	15m/min	
Suitable Film	POF	
Sealing Balde Temp.	0~300°C Adjustable	
Weight	225Kg	300Kg

## 4. Operation

### I Operation Panel



## II Operation Panel



No.	Name	Function
1	Main power switch	Turn on/off machine
2	Indicator Light 1	Indicate the machine power on or off
3	Indicator Light 2	Indicate the machine running automatically
4	Button 1	Horizontal sealing bar up
5	Temperature Controller 1	Set horizontal sealing blade temperature
6	Temperature Controller 2	Set vertical sealing blade temperature
7	Timer 1	Set sealing time
8	Timer 2	Set the front film reservation
9	Timer 3	Set the rear film reservation
10	Button 2	Reset machine operation and alarm
11	Button 3	Manual Film Pulling
12	Temperature Controller 1	Set horizontal sealing blade temperature
13	Temperature Controller 2	Set vertical sealing blade temperature
14	Mode Optional Switch	Choose auto/manual working mode
15	Speed Selection Switch	Set the pause function of infeed belt in sealing
16	Singnal Optional Switch	Choose horizontal/vertival signal detecting method
17	Kissing device Option Switch	Choose to start / stop the kissing device

※ TBA without kissing device



### III Operation Steps

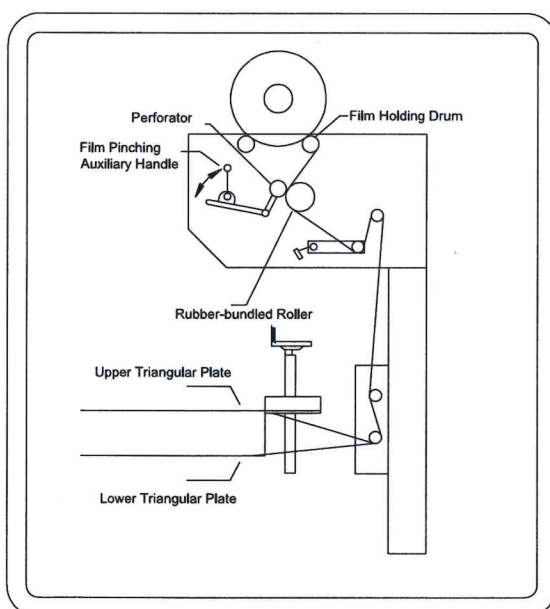
#### 1. Start Up Prepration

- 1.1 Power Source Specification Shall be 3PH 380V AC 50-60Hz with the grounding terminal grounded unfaillingly.
- 1.2 Air source shall be steady and dry with the regulating valve reading at 6-7kg/cm<sup>2</sup>.
- 1.3 Turn "ON" the main power switch , power indicator lit; Press "ON" the sealing blade heating switch, indicator lit and temperature controller displaying reading; Set target degree on temperature controller to heat up the sealing blade.

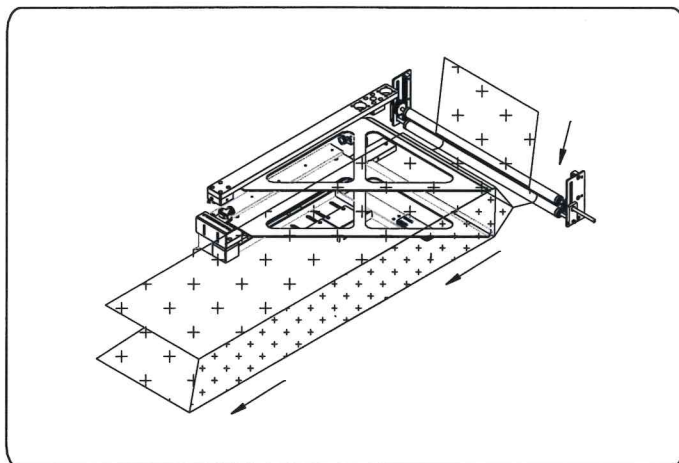
#### 2. Film Threading

- ◎ The film used in this machine is central folded film( film for short as below)
  - ◎ Select the packing film with size and texture suitable to the product dimensions, then thread the film according to the schematics.
2. 1 Place the reel onto the two rollers above, check the film opening and the rotation direction.
  2. 2 Pull open the handle of the film perforator pin wheel to separate the pin wheel from the rubber-bundled roller.
  2. 3 Thread the film as per the schematics below on the basis of the reel opening and rotation direction.
  2. 4 Pull the pin wheel handle to reset the pin wheel after the film threads between the pin wheel and the rubber-bundled roller.
  2. 5 Pull out the film around 30 cm beyond the machine frame

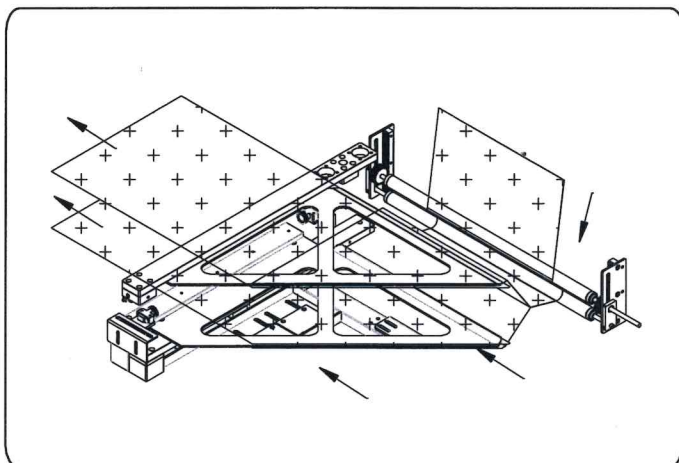
Schematics for  
film threading in  
film feeding system



2.6 Thread the film past the triangular unfolders (see chart below) after the film threading through the film racks.



◎ Wrap over the unfolders with the film



◎ Parallel the film to the conveying ? belt by diverting the film to the left by 90°

2.7 After the film threading through the triangular unfolders, converge the film near the horizontal sealing blade after the film passing over the in-feed conveyor belt and direct the film through the vertical sealing film clamping system.

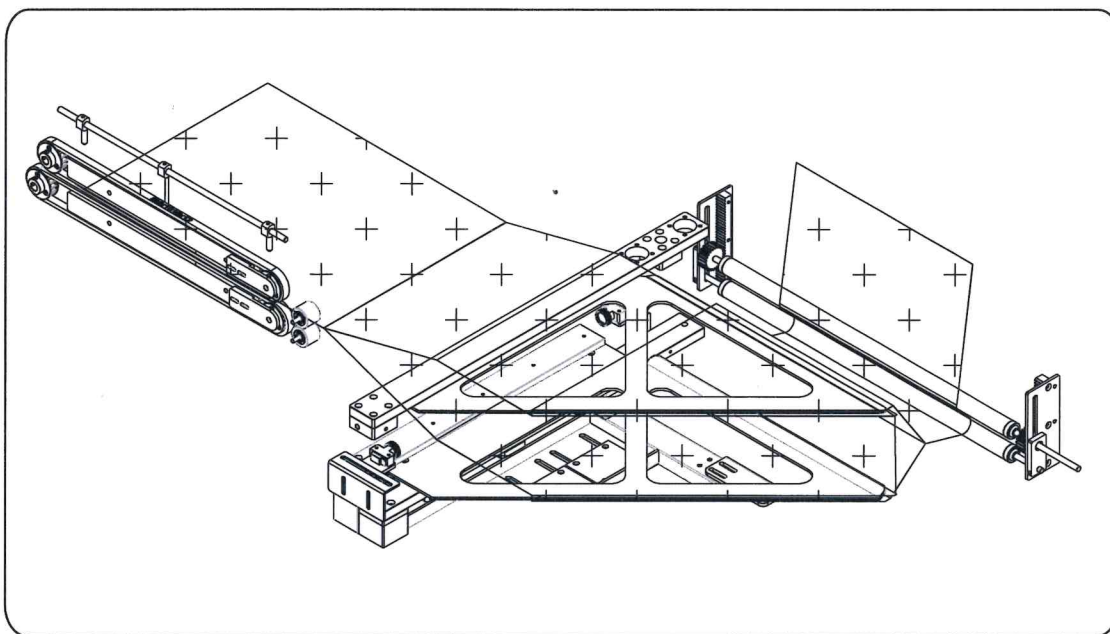
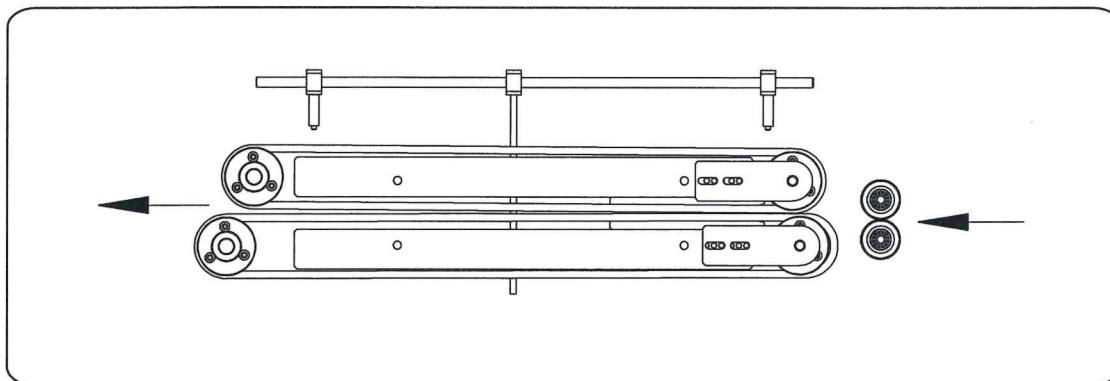
2.7.1 Pull the film unfolded by the two triangular plates along the vertical sealing in forward direction;

2.7.2 Pinch the film via the upper film pinching wheel( Optional Parts);

2.7.3 Pinch the film via the lower film pinching wheel( Optional Parts);

2.7.4 Film below and above meet while threading through the horizontal sealing blade;

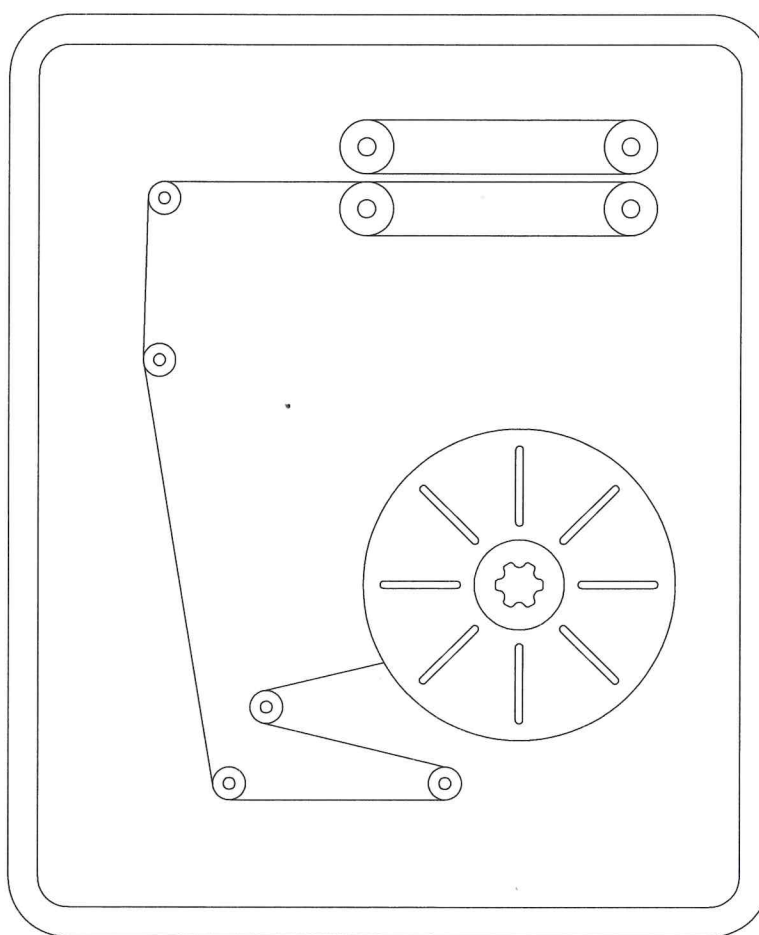
- 2.8 When the film reaches the film pulling system through the horizontal sealing bracket, lift up the auxiliary film pinching wheels and the film compressing synchronous wheel, thread the film according to the schematics.





- 2.9 After threading the film through the sealing system, shift the machine into manual mode to pull the film along with the waste film; direct the film as shown in the picture below into the waste film collecting box below the control cabinet and tie the waste film to the waste film collecting wheel.

### Waste Film Collecting Threading Schematics

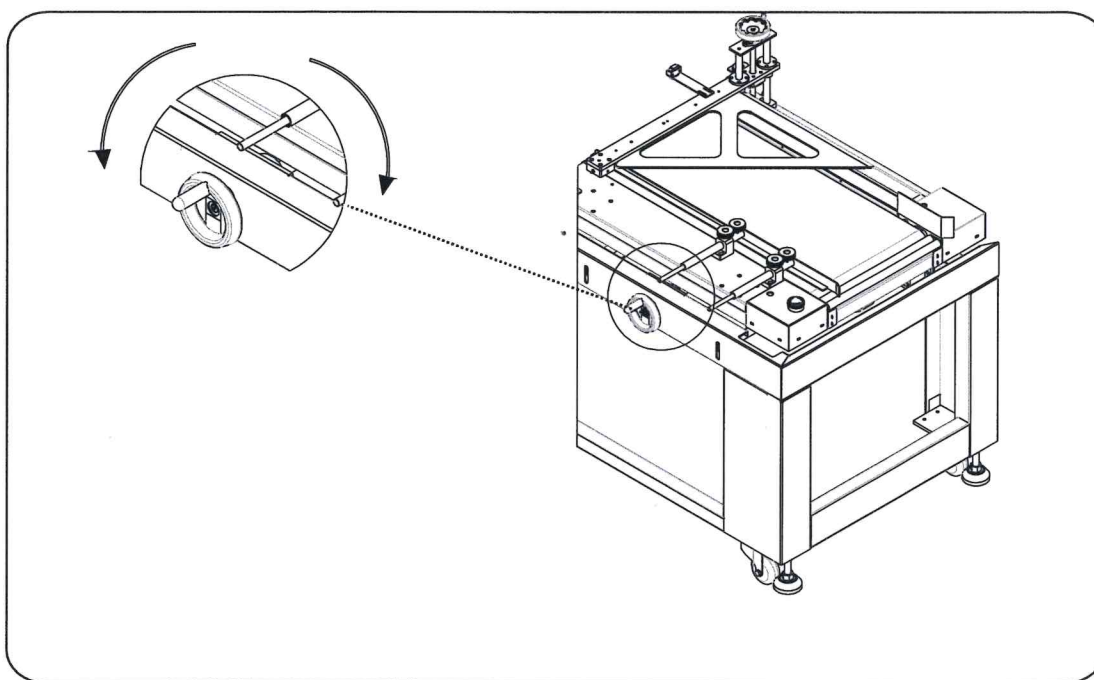


### 3 In-feed Adjustment

After threading the film, adjust the infeed fending palte, in-feed conveying rack longitudinal position, film unfolding triangular plates vertical position and the horizontal and vertical sealing blade carriers vertical position, the quantity of perforator according to the products external size.

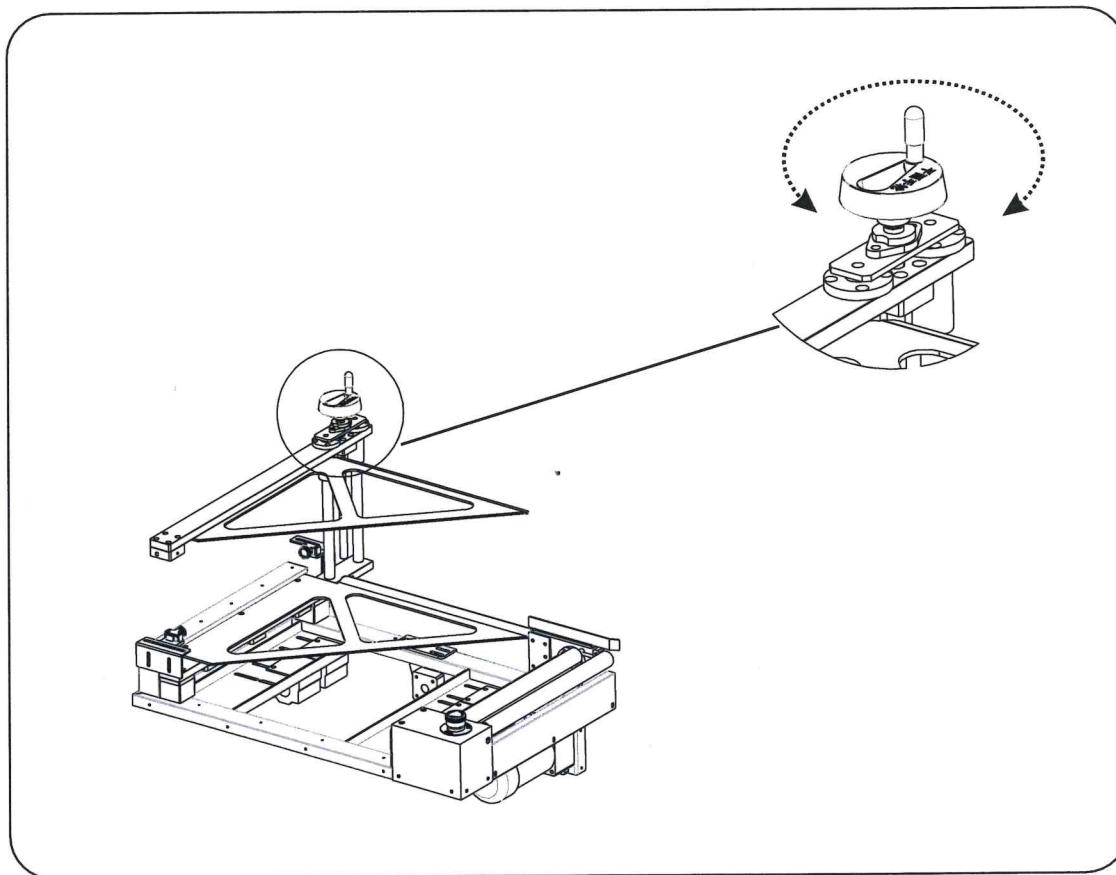
© Back/Front adjustment of infeed conveying:

- 1) Rotate the hand wheel on the right front of frame clockwise to move the infeed conveying belt forward;
- 2) Rotate the hand wheel anti-clockwise to move infeed conveying belt backward;
- 3) Adjust the position of the infeed conveying rack in relation to the outfeed conveying belt according to the product width to specify the packing bag width..



### ◆ Film Unfolding Triangular Plate Vertical Position Adjustment

- 1) Rotate the film unfolding triangular plate hand wheel clockwise to move the triangular plates downward.
- 2) Rotate the hand wheel anti-clockwise to move the triangular plates upward.
- 3) Adjust the height of the triangular plates according to the product height to make the products pass smoothly.



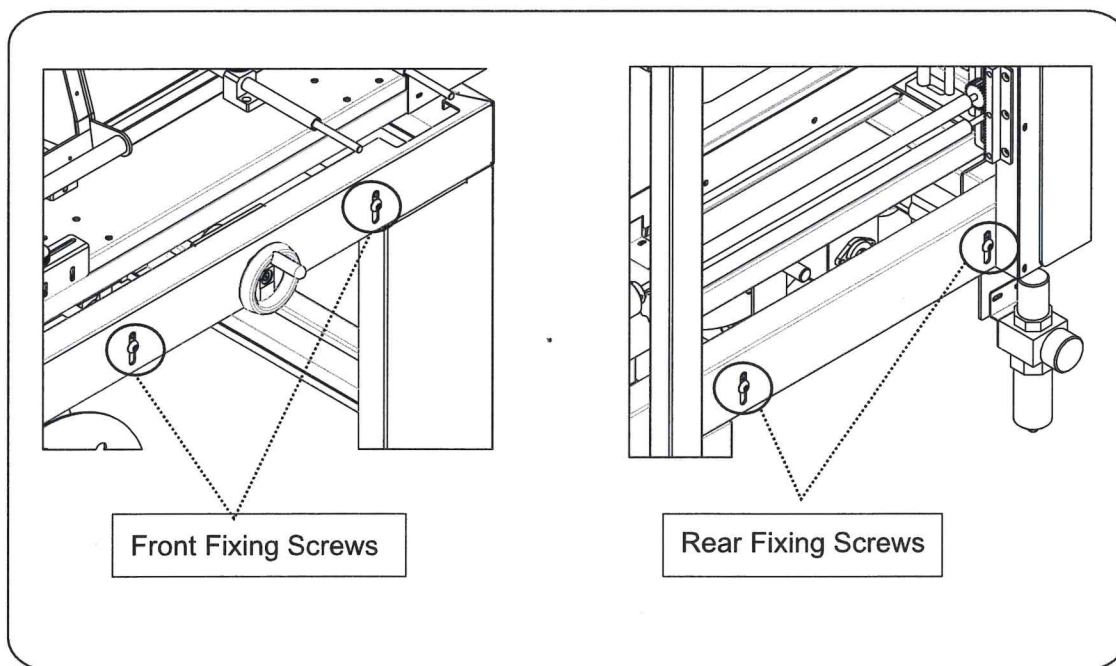


**◆ Welding Line Position Adjustment:**

- ◎ Change the welding line position by the vertical position of the front/rear conveying belts;
- ◎ Keep the front/rear conveying belts parallel horizontally after being adjusted;

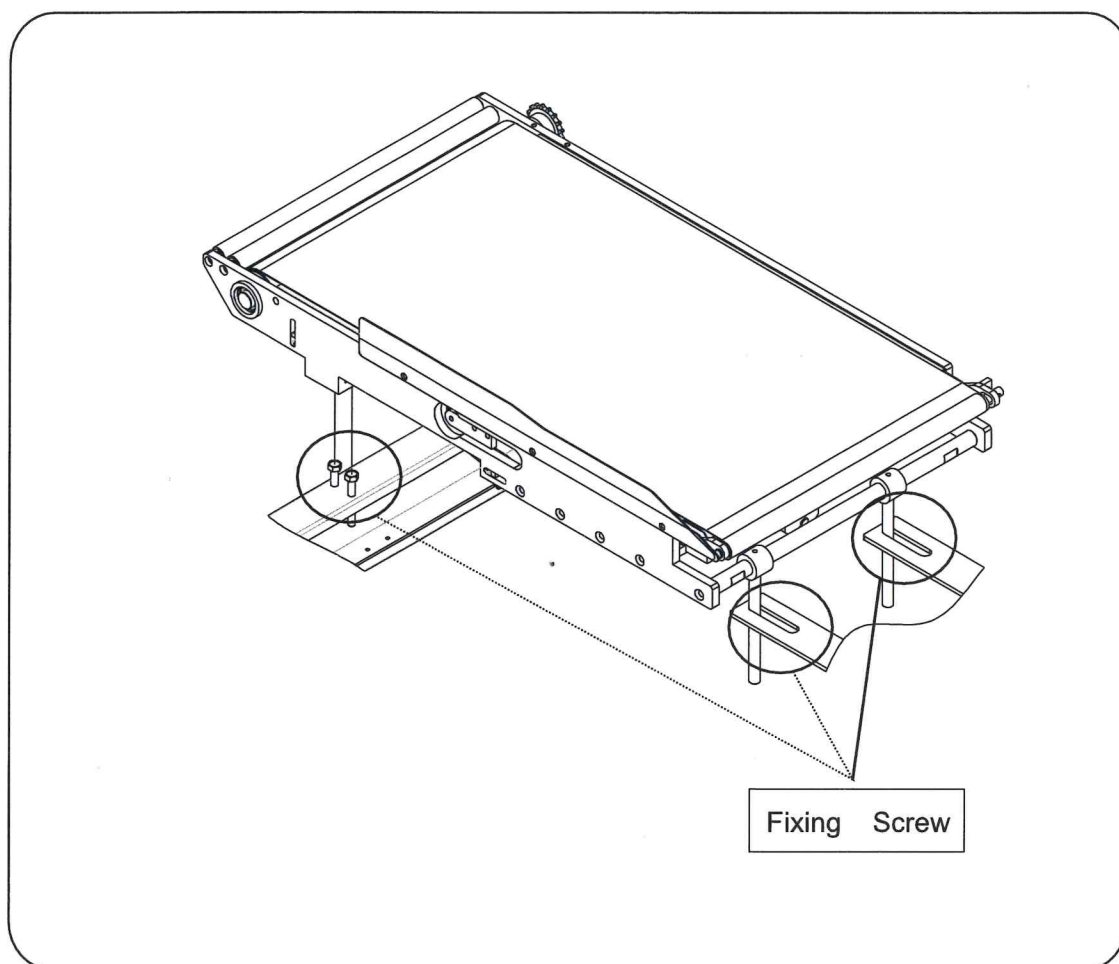
**◎ Front Conveying belt Position Adjustment:**

1. Adjust the front/rear conveying belts position by lossening the four fixing screws before and after the machine frame ;



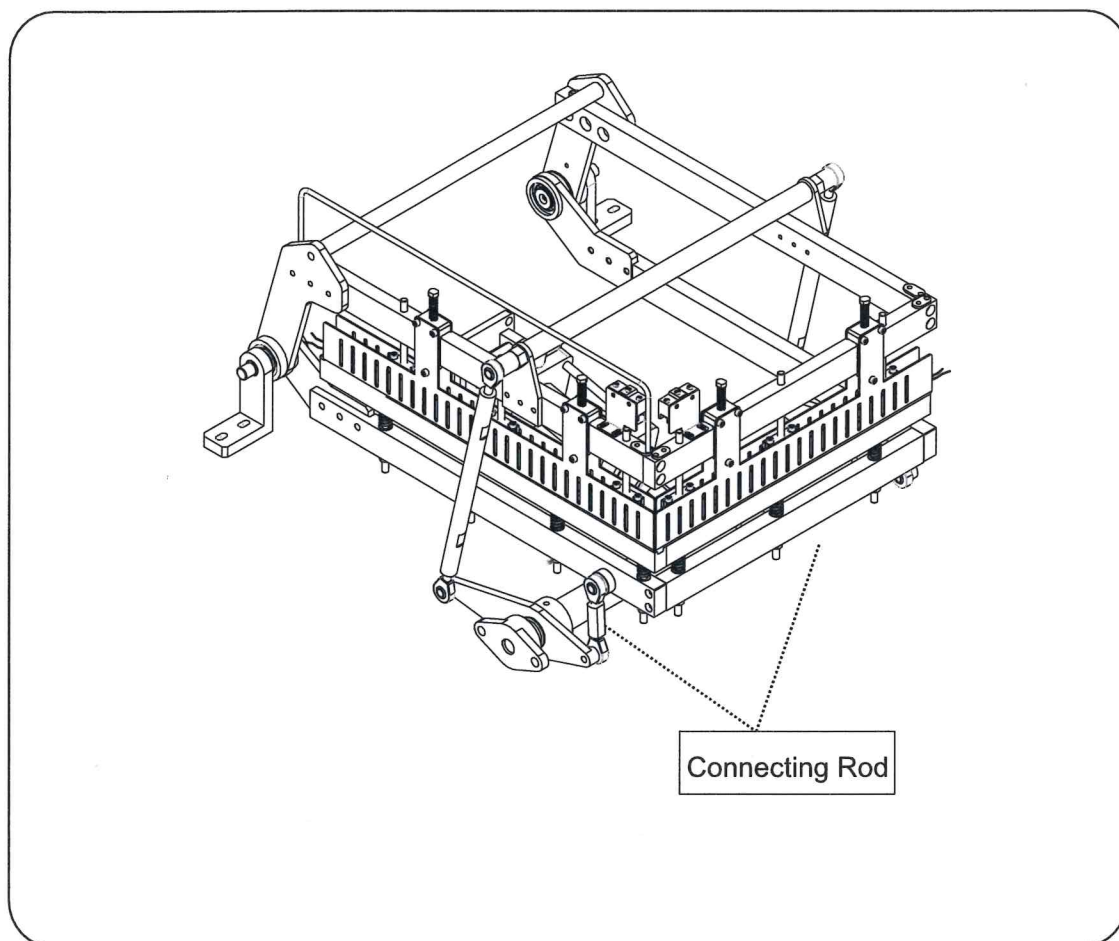
## ◎ Rear Conveying Belt Position Adjustment:

1. Loosen the four screws on the nuts to adjust the rear conveying belt position.



### ◆ Sealing Blade Opening Height Adjustment:

- 1) Adjust the conveying rod to change the sealing blade opening height to pass the products smoothly ;





#### **4. Parameter Setting**

- 4.1 Finetune the sealing blade temperature according to sealing effect in manual operation mode to optimize the effect .
- 4.2 Set such paremeters as front/rear film reservation and sealing time etc. on the operation panel in order.

#### **5. Automatic Operation**

- 5.1 Choose kissing function(models with "M") in accordance with actual needs.
- 5.2 Choose horizontal/vertical detection mode
- 5.3 Turn the mode switch to automatic mode to start the automatic operation program
- 5.4 Place products on the in feed conveyor to start operation

#### **6. Manual Operation**

- 6.1 Turnthe mode switch to manual mode
- 6.2 Press button 3 to pull film manually
- 6.3 Press button 4 to seal manually

#### **7. Trouble Shooting**

- 7.1 Press the emergency switch to immediately stop the machine in abnormal operation
- 7.2 Machine will stop and alarm in abnormal operation, Press button 3 to reset after trouble eliminated.
  - 7.2.1 Sealing Anomaly: the blade has cut the product, or the vertical photocell sensors detect objects
  - 7.2.2 Film Collecting Anomaly: film collecting motor operates continuously for 6 seconds or longer. Check if wasted film is broken, or the sensor and motor are abnormal

## 5. Care & Maintenance

Please follow the instructions as below to maintain the machine in normal condition.

1. Use clean soft cloth to clear the sealing blade after the operation. Wear heat-resistance gloves to clear the sealing blade before its temperature falling. It may cause damage to the Teflon coated on the blade if the temperature is below 70 degrees.
2. Smear the paste detergent on the blade uniformly with a soft cloth by pressing the sealing slightly.
3. Replace the sealing blade if the sealing blade cannot seal closely due to wastage.
4. Pneumatic Circuit Maintenance

### 1) Waste Water Drainage

- ◎ Discharge the waste water when it reaches the fending plate
- ◎ Screw out the stopper at the bottle bottom to discharge the water ;If pressed from below, the stopper may not move back , if so, dismount the bottom , press down the stopper from above.

### 2) Pressure Adjustment

- ◎ Rotate the adjustment knob to the right, the pressure will goes up .
- ◎ Press the knob to lock the pressure after setting.

### 3) Dismounting

- ◎ Cut off the air source.
- ◎ Loosen the four screws, guard, spring, template etc.
- ◎ Rotate the bolt to left to take it out, then loosen the spring and stopper washer to take them out.

## 5. Lubrication

- ◎ Keep all movable spare parts lubricated well.
- ◎ Add lubricating oil to sealing blade guide rail every 3 days.
- ◎ Add lubricating oil to conveying belt support guide rail every 30 days.
- ◎ Add lubricating oil to transmission chain every 30 days.

### ◆ Horizontal Sealing Blade Cleaning and Replacement.

Much film debris will accumulate on the cutting edges of the horizontal and vertical sealing blades after the machine running for a long period. The cutting edges must be cleaned periodically to ensure the smooth operation and extend the life-span of sealing blade.

#### Horizontal Sealing Blade Cleaning:

1. Lift up the sealing blade guard to protrude the sealing blade, use tools to keep the protrusion.
2. Use special detergent to clean the sealing blade by slightly wiping the cutting edges of the blade.



The machine must be powered off with the sealing blade temperature below 50 degrees during cleaning.

#### Horizontal Sealing Blade Replacement :

If the Sealing blade coat wears out during long term operation, it will need to be replaced.

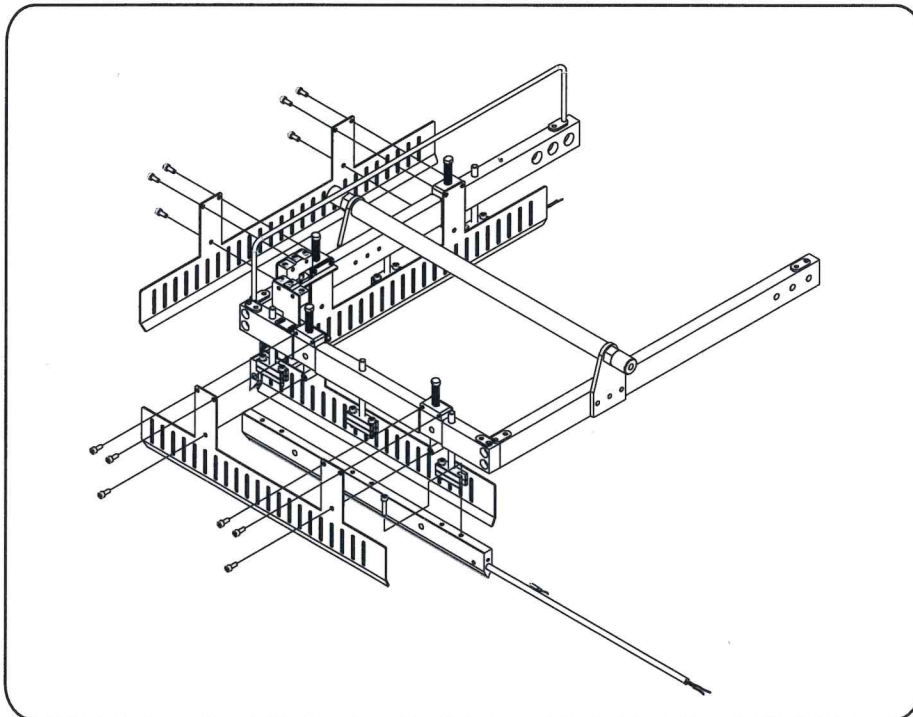


Power off the machine before replacing the sealing blade.

### Replace steps:

1. Dismount the locking screws from the blade guards.
2. Remove the blade guards in and out.
3. Dismount the tap in the front of the sealing blade.
4. Loosen the sealing blade fixing screws.
5. Loosen the puller screws for the heating tubes and the thermocouples, then pull out the heating tubes along with the thermocouples from the sealing blade bracket.
6. Dismount the sealing blade to be replaced.
7. Replace with the new sealing blade , and install the blade in the reverse order of dismounting.
8. Steps to vertical sealing blade is same as horizontalsealing blade.

### Dismounting Schmatics:

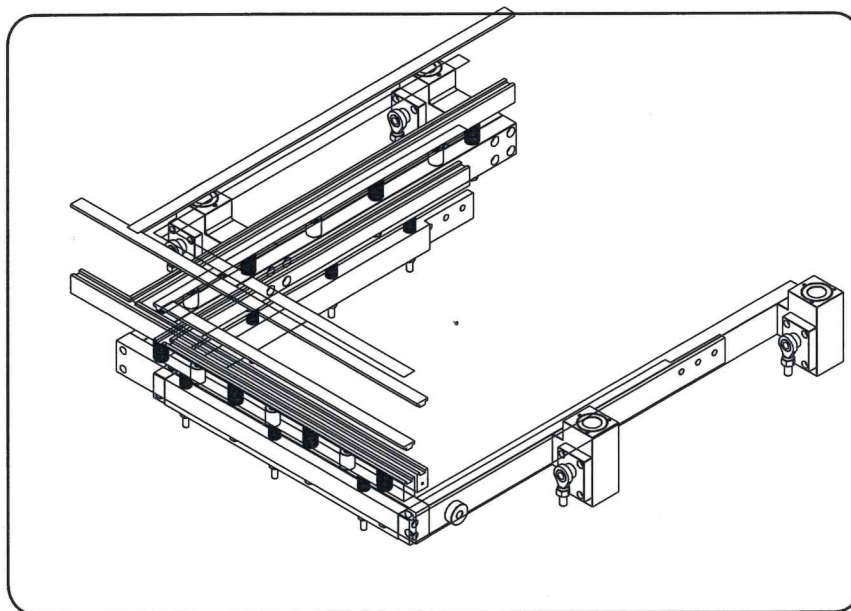




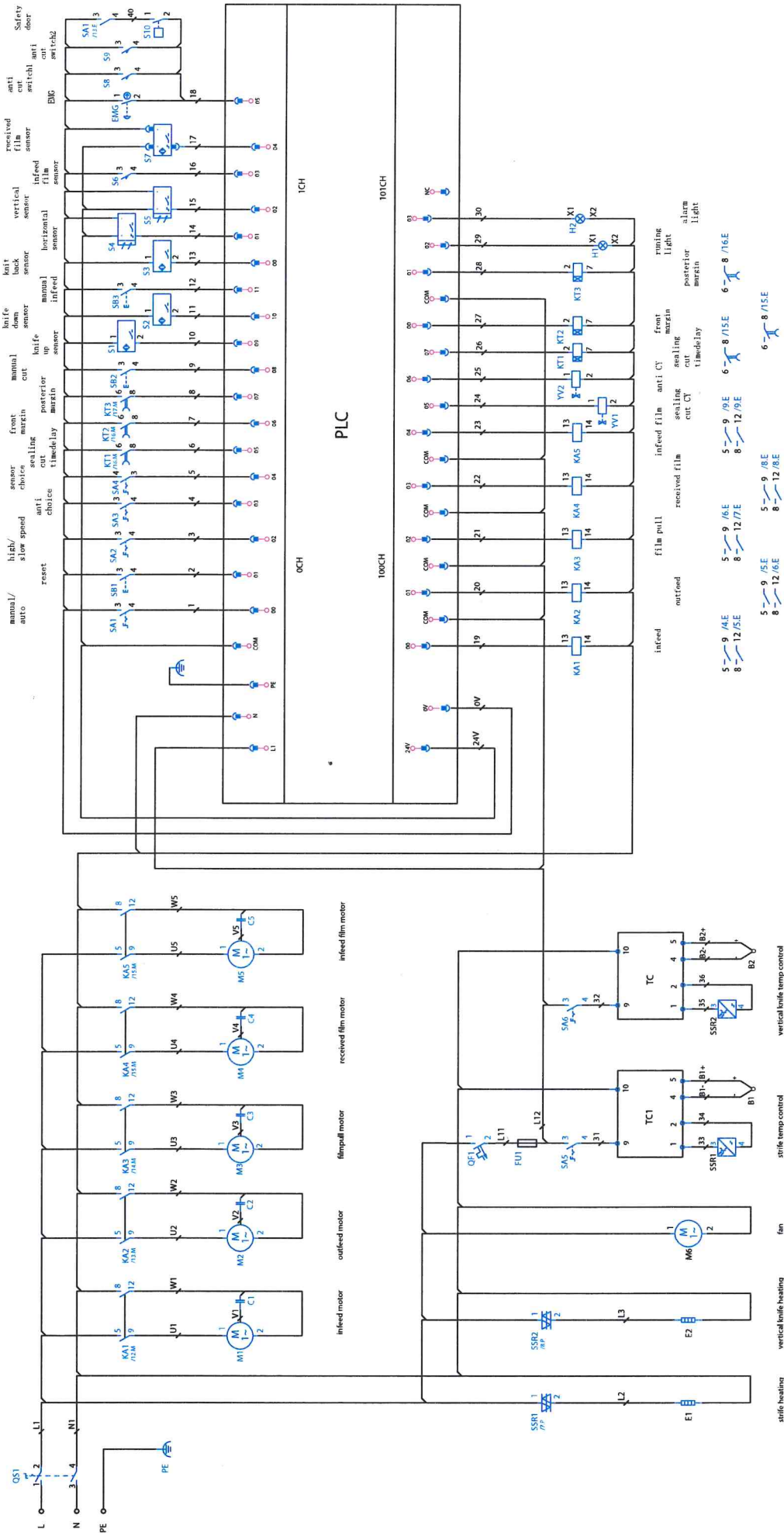
◆ **Sealing Blade Bracket Silicone Rubber Replacement:**

1. Take out the silicone rubber from the sealing blade bracket
2. Embed the silicone rubber into the sealing blade bracket evenly with, its length same as that of the bracket.
3. Stick the Teflon onto the silicone rubber evenly with 2-3CM exceeded from both ends and the adhesive side facing downward. .

**Dismounting Schematics:**



## 6. Circuit Diagram and Pneumatic Diagram



© **Electircal box layerout**

© **Pneumatic Diagram**



## 7. Trouble Shooting

Fault Symptoms	Causes	Eliminating Methods
Film feeding or collecting motor out-of-operation	Press emergence stop	Unscrew the emergency etop switch
	AC contactor failure	Replace the contactor
	Motor failure	Replace the motor
	Proximity switch broken or its position adjusted improperly	Replace the proximity switch or readjust its position
Conveying belt out-of-operation	Motor broken	Replace the motor
	Mechanical failure	Check the conveying transmission Mechanism
	Wiring anomaly	Check the wiring connection
Sealing blade failure	Electromagnetic valve broken	Replace the electromagnetic valve
	Wiring anomaly	Check the connecting wires and the connectors
	Cylinder broken	Replace the cylinder
Film cutting failure	Sealing blade uneven	Adjust sealing blade fixing screws
	Inadequate temperature	Rise the temperature
Poor sealing effect	Sealing blade surface scratched	Replace the sealing blade
	Foreign matter on sealing bladesurface	Clean with a dry cotton cloth
Vertical sealing cylinder failure	Low or no air pressure	Check the air source
	Electromagnetic valve broken	Replace the electromagnetic valve
Temperature anomaly	Heating tube broken	Replace the heating tube
	Thermocouple broken or abnormal	Replace the thermocouple
	Solid relay broken	Replace the solid relay
	Wiring anomaly	Check the wiring or connectors
	Heating breaker tripping out	Check or replace the breaker

## 8. Packing list

Serial No.	Items	Unit	Remark
1	Master machine	1 piece	
2	Operation and Maintenance Manual	1 piece	
3	Tool box	1 piece	
4	Inner Hexagon Spanner	1 set	
5	Adjustable Spanner	1 piece	
6	Philips Screwdriver	1 piece	