

Pre-stretch Wrapping Machine with Auto Top Press Operating Manual

G1P Model



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- ◆ **Thanks for using our products**
- ◆ **This manual expounds on wrapping/packing machine and its usage.**
- ◆ **While the use is simple, but operating mistake can cause accidents, shorten the service life of the machine and reduce the properties, please be sure to read this manual carefully before using, so as to use it properly for a long time.**
- ◆ **Please preserve the manual.**
- ◆ **Please be sure to give this manual to the end user.**
- ◆ **The company focuses on updates, subject to improvements without notice.**

Security considerations:

Before your setup, operation, maintenance, inspection, be sure to read the entire contents of this manual, used correctly, read the related knowledge of the machine, safety information and cautions before use.

Please follow the machinery and equipment installation drawings and technical specifications, the technical requirements for equipment installation.

Please verify that the product corresponds to the rated supply voltage and the AC power source voltage to avoid injury or circuit fault. Concerning AC power should be carried out by a full-time electrician, to avoid electric shock and the risk of circuit fault.

Machines inside the electrical box high-voltage electricity, a part-time electrician or full-time maintenance personnel, do not open to prevent electric shock. Check power off 5 minutes later, otherwise there is risk of electric shock. When the machine is running, please stay away from the machine to avoid injury while resetting in running signal, the machine may restart, so please stay away from the machine to avoid injury.

1、Performance introduction

Automatic film wrapping machine is a newly developed intelligent packaging machinery of our company, it adopts PLC control core can supply a variety of pallet stretch wrapper to the subject according to the technological requirements. With stable performance and strong anti-interference ability can be work at normal status under high dust, noise, electromagnetic interference and temperature fluctuation, it also has the advantages of simple operation. Main electrical components adopt imported brand-name product, the operation is stable and reliable

Technical parameters:

Model	G1P-200220
Machine dimension	L 2900 mm * W 2000mm * H 2400mm
Machine weight	500kg
Max packing weight	2000kg
Max packing height	2100mm
Turntable diameter	1650 mm
Turntable speed	3-15rpm
Turntable Rotation Direction	Clockwise
Turntable Motor	0.75kw
Lifting Motor	0.40kw
Pre-stretch Motor	0.40kw
Maximum Film Reel Diameter	500mm
Inner Film Reel Diameter	75mm
Max film height	500mm
Power voltage	Single phase, 220V, 50Hz, 1.55kw

2、 Features

This machine adopts intelligent control technology for different target groups for a variety of packaging jobs.

(1) Various functions of your program settings: fully-automatic wrapper, manual procedures, up-down pause, return to origin position (stop procedures, equivalent to the function of STOP) and so on.

(2) Using digital modes on the wrapper objects to set upper and lower packing cycle, Digital display set value is the actual packing cycle values, simple and clear.

(3) Design of complete self protection function, equipped with the manual emergency stop, electronic controls stop motion, prevent parts from accidental damage.

(4) Stretch film packaging technique that allows users not only benefit from packaging cost reduced, but also makes appearance on a higher level.

(5) Turntable slow start and stop, can overcome package falling result from fast start speed. Enable the operator to load and unload work piece conveniently. Machines can be easily matched with packing lines.

(6) Automatic reset. when the machine is in normal use, the whole pack will reset automatically after completion of the procedure in a standby state, while due to improper use or mechanical cause, automatic reset of the machine is not in place, you can check the reset of the machine, and the machine to be reset to run the program.

3、 Device Installation& Transport

1. Shipped out the machine column and chassis parts from the container with forklift or other tools.

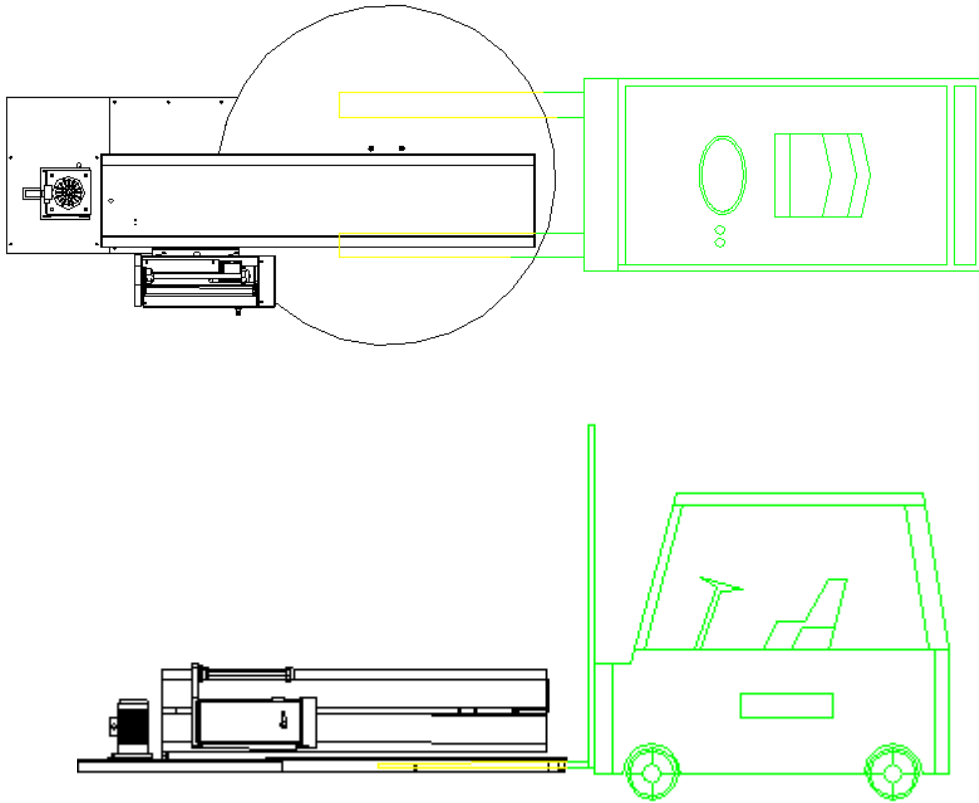


Fig.3-1

Put the chassis on a smooth & level ground, use plastic or other materials if unevenness. Mount column on mounting base on the chassis, mount the locating pin to fix the bolts.

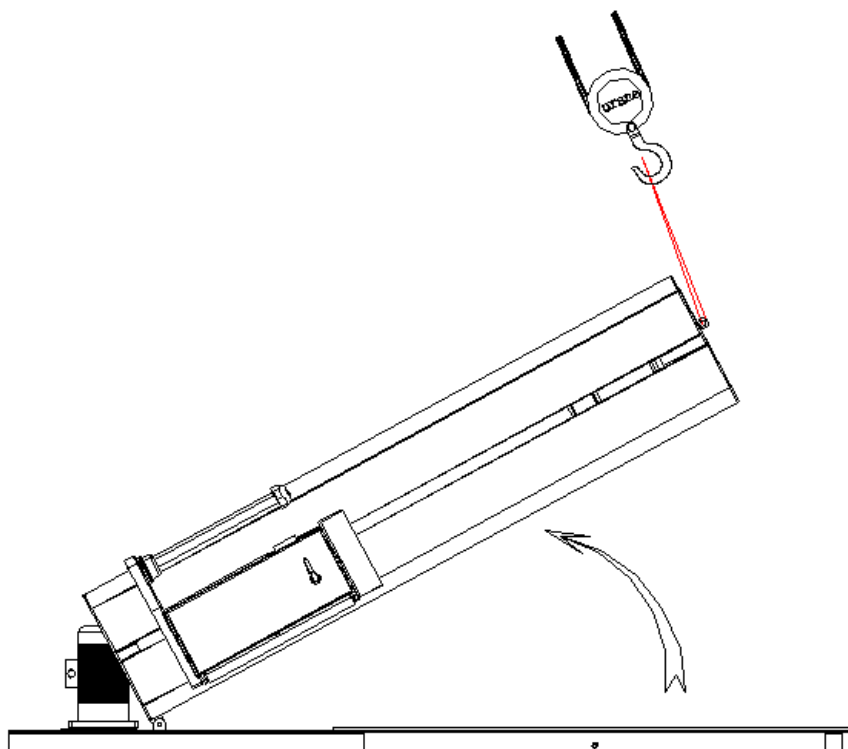


Fig.3-2

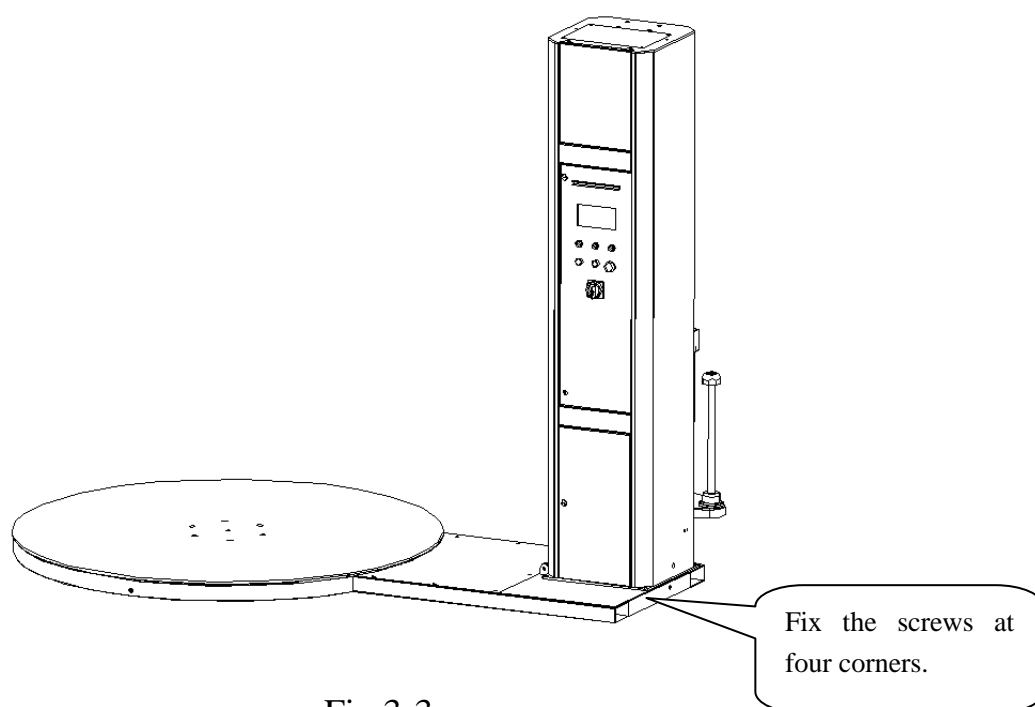
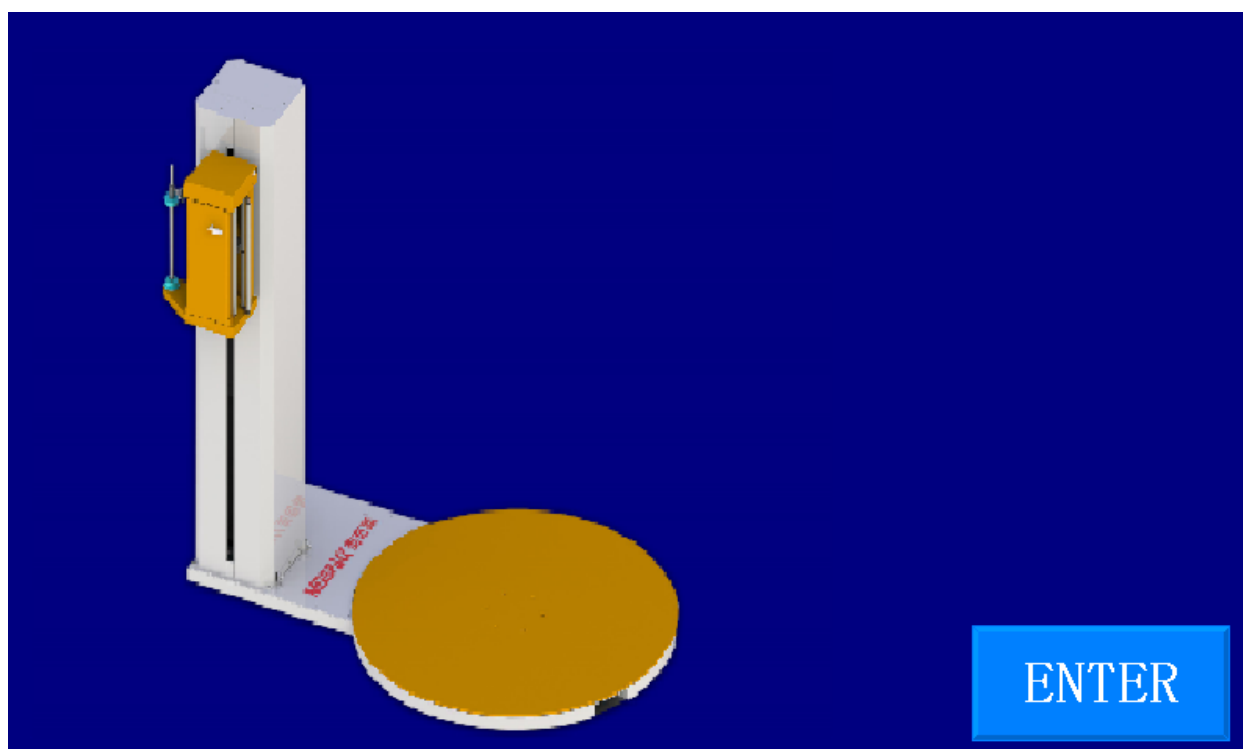


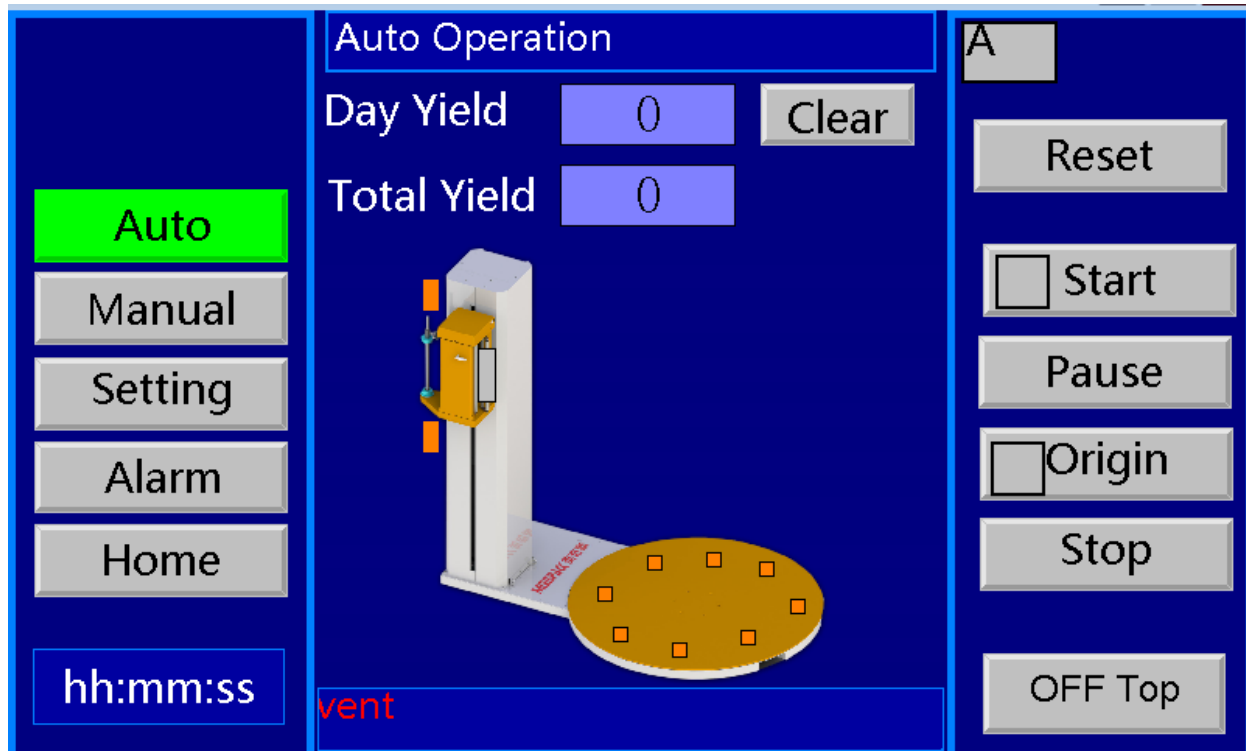
Fig.3-3

4、 Operating Instructions

Power on, the picture shows as following. Press “Enter” into main page.



Auto



Start: Start Wrapping in Auto Mode.

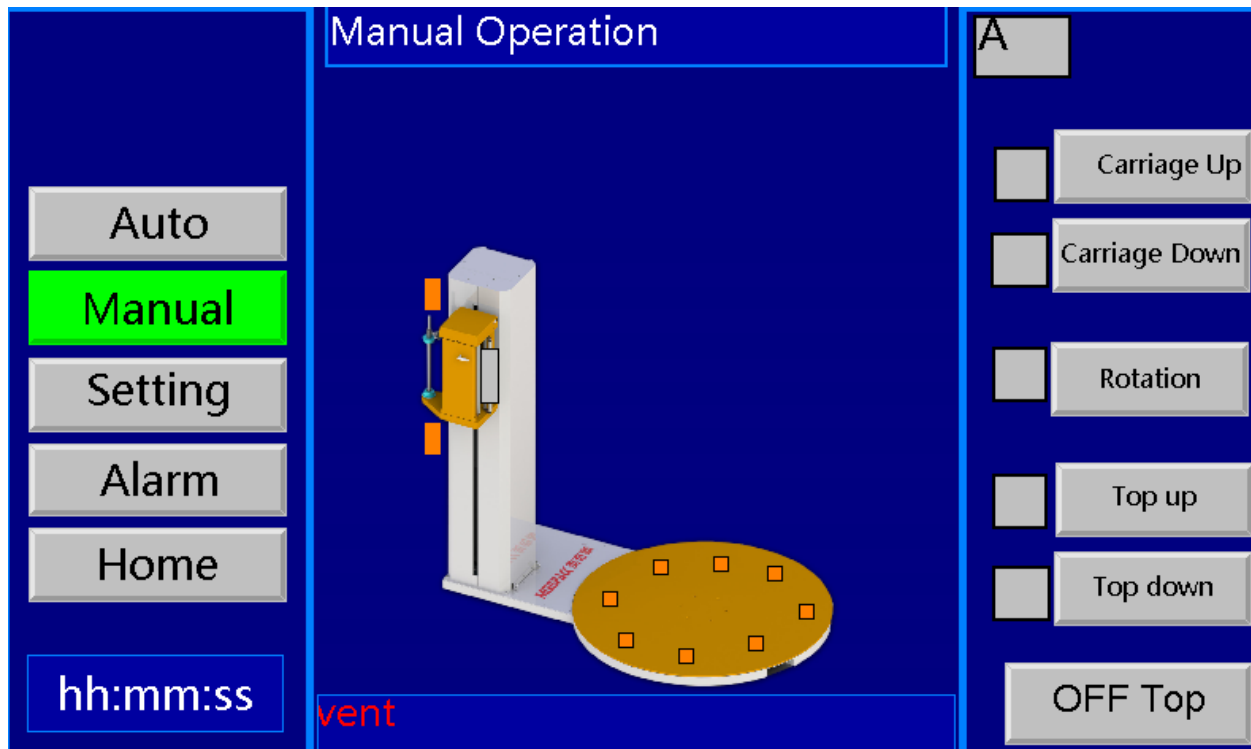
Pause: Pause running in Auto Mode.

Origin: Return to original position in Auto Mode.

Stop: Emergency Stop.

OFF Top: Switch of Top Press function.

Manual



Carriage Up: Manual control to rise up carriage.

Carriage Down: Manual control to get down carriage.

Rotation: Manual control to rotate.

Top up : Manual control top press plate to rise up with the switch on.

Top down: Manual control top press plate to get down with the switch on.

Setting

Setting Operation		
Auto	Wrapping Layer	##
Manual	Bottom Circle	##
Setting	Top Circle	##
Alarm	Over Top Time	#.# Sec.
Home		
hh:mm:ss		
		IO Status
		Information
		Monitor
		Adv Setting

Wrapping layer: Set layers of wrapping.

Bottom Circle: Set cycles of bottom wrapping.

Top Circle: Set cycles of top wrapping.

Over Top Time: Set rising time of carriage after over top of goods.

Adv Setting

IO Status

Information

Monitor

Adv Setting

Return

hh:mm:ss

Login for Adv. Setting

Modifying parameters

Password:

OK

Password Change:

Old password:

New password:

OK

IO Status

Information

Monitor

Adv Setting

Return

hh:mm:ss

Adv. Setting

Top speed	<input type="text" value="##"/>	Hz
Rotation Speed	<input type="text" value="##"/>	Hz
Pre Pull proportion	<input type="text" value="###"/>	%
Film Carriage speed	<input type="text" value="##"/>	Hz
Turntable ReduceTime	<input type="text" value="#. #"/>	S
Film Break	<input type="text" value="#. #"/>	S

Advanced parameter setting, original password is 0.

Password could be change, please keep noting new password after modification.

Top speed: Set up&down frequency of top press.

Rotation Speed: Set rotate frequency of turntable.

Pre Pull Priportion: Set tension of stretch film.

Film Carriage Speed: Set up&down frequency of Carriage.

Turntable Reduce Time: Set speed slow down time of turntable during last cycle.

Film Break: Set alarm time of film break. Warning if detect no film during this period.

IO Status

<div>IO Status</div> <div>Information</div> <div>Monitor</div> <div>Adv Setting</div> <div>Return</div> <div>hh:mm:ss</div>	IO State-Input	
	<input type="checkbox"/> X0 Off film Count	<input type="checkbox"/> X10 NC
	<input type="checkbox"/> X1 Pre pull SW	<input type="checkbox"/> X11 Auto Start
	<input type="checkbox"/> X2 Rotation base point	<input type="checkbox"/> X12 Pause
	<input type="checkbox"/> X3 Film Shelf Safety door	<input type="checkbox"/> X13 Estop
	<input type="checkbox"/> X4 Film Shelf Upper bound	<input type="checkbox"/> X14
	<input type="checkbox"/> X5 Height Photoelectric switch	<input type="checkbox"/> X15
	<input type="checkbox"/> X6 Film Shelf Lower bound	<input type="checkbox"/> X16
	<input type="checkbox"/> X7 Film Shelf Lower Limit	<input type="checkbox"/> X17
	Input	Output

<div>IO Status</div> <div>Information</div> <div>Monitor</div> <div>Adv Setting</div> <div>Return</div> <div>hh:mm:ss</div>	IO State-Input	
	<input type="checkbox"/> Y0 Braker	<input type="checkbox"/> Y10 Pre pull motor
	<input type="checkbox"/> Y1	<input type="checkbox"/> Y11 Rotation_estop
	<input type="checkbox"/> Y2	<input type="checkbox"/> Y12 Top pressure up
	<input type="checkbox"/> Y3 Pre pull spd2	<input type="checkbox"/> Y13 Top pressure down
	<input type="checkbox"/> Y4 Rotation run	<input type="checkbox"/> Y14 Off film electromagnet
	<input type="checkbox"/> Y5 Rotation run 5Hz	<input type="checkbox"/> Y15 NC
	<input type="checkbox"/> Y6 film carriage up	<input type="checkbox"/> Y16
	<input type="checkbox"/> Y7 film carriage down	<input type="checkbox"/> Y17
	Input	Output

PLC input output signal.

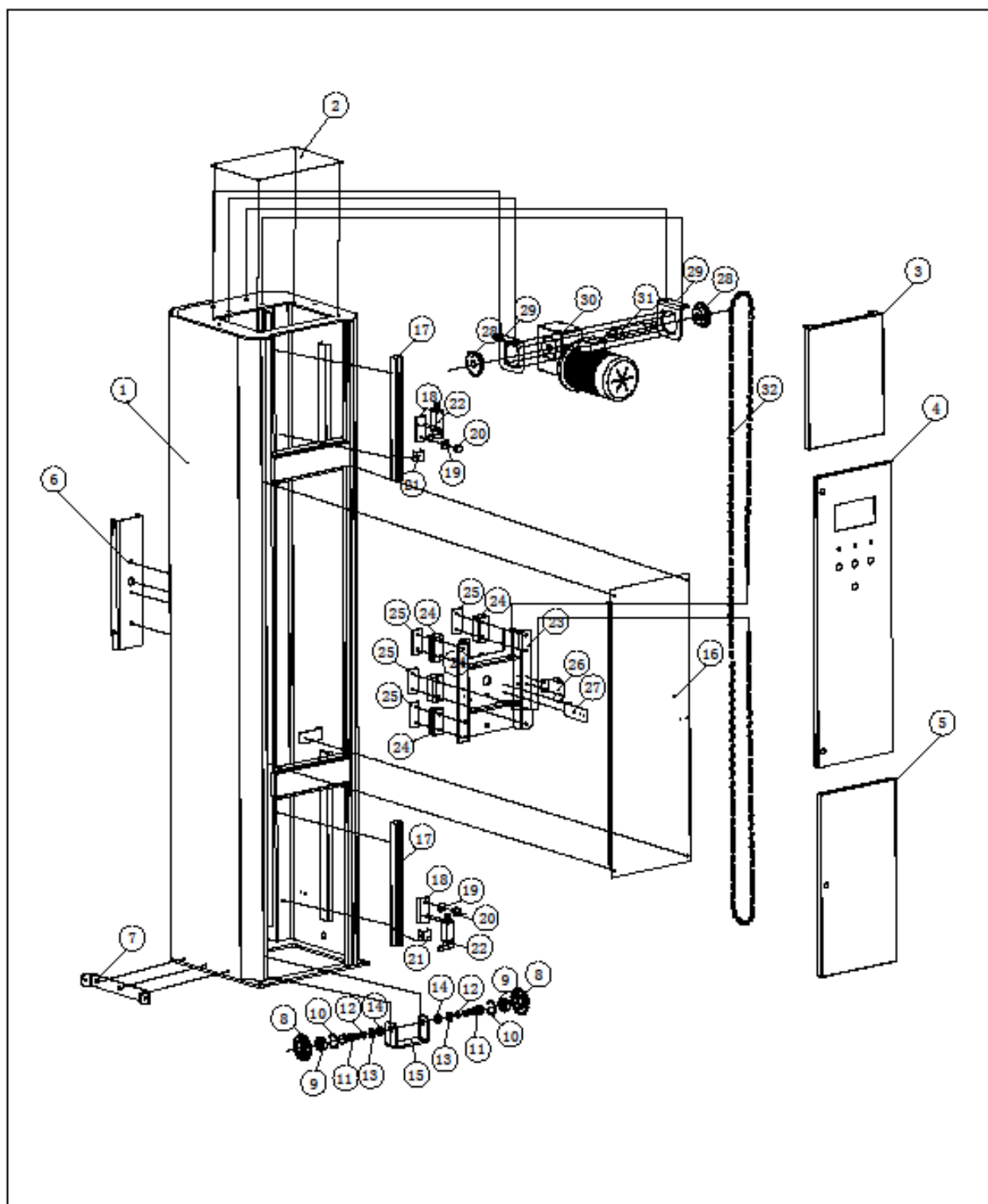
Monitor

Monitor					
<div>IO Status</div> <div>Information</div> <div>Monitor</div> <div>Adv Setting</div> <div>Return</div> <div>hh:mm:ss</div>	Wrapping Layer	0	0	OverTop Time	0.0
	Bottom Circle	0	0	Day Yield	0
	Top Circle	0	0		
	Addition Circle	0	0		
	Rotation Puse	0	0		
	Rotation	0.00			
	Film Carriage	0.00			
	Pre Pull	0.00	vent		
				Reset	
				<input type="checkbox"/> Start	
				Pause	
				<input type="checkbox"/> Reset	
				Stop	

Showing current working status of machine.

7 Structure of machine

①: Structure of column

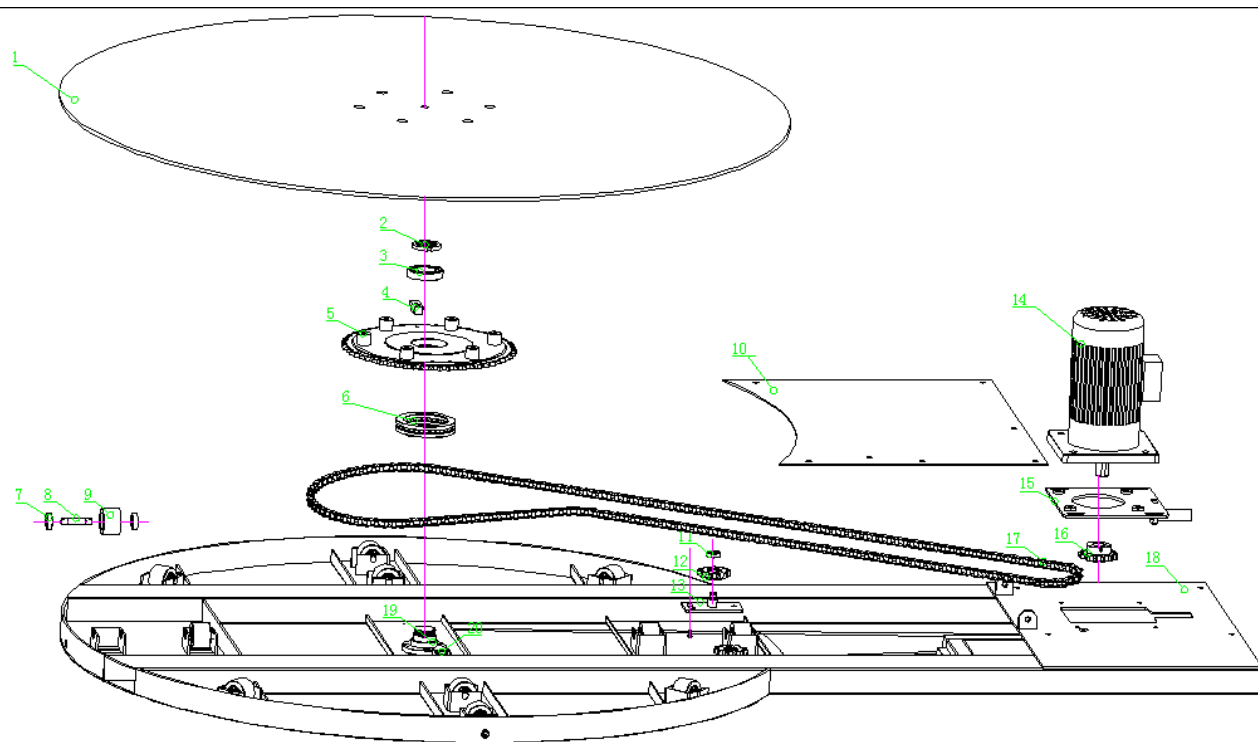


1-1

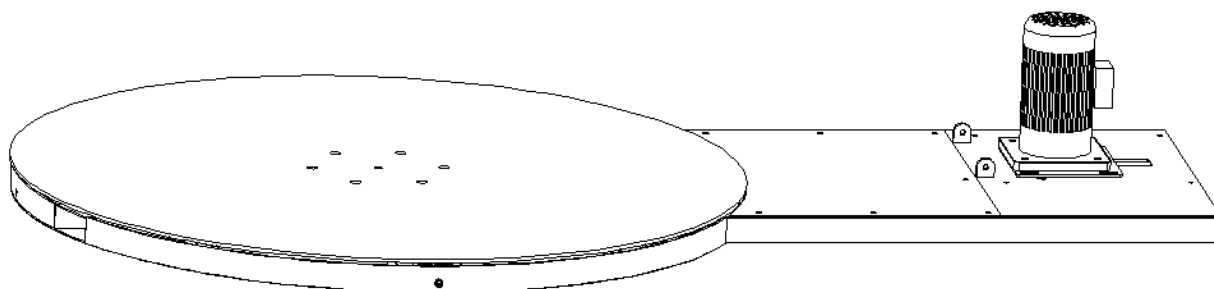
Column breakdown drawing

No.	Item	Spec.	Code	Qty (PCS)	Mark
1	Column Main Part		M120-0201	1	
2	Column Top Plate		M120-0201-02	1	
3	Column Upper Door		M120-0217	1	
4	Operate Plate		M120-0215	1	
5	Column Lower Door		M120-0216	1	
6	Carriage Connector		M120-0207	1	
7	Column Hinge		M120-0214	1	
8	Sprocket	08B19Z		2	
9	Bearing	6004		2	
10	Internal Circlip	B-C-42-15		2	
11	Lower Sprocket Axle		M120-0210	2	
12	External Circlip	B-C-S-20-10		2	
13	Gasket	B-P-M16		2	
14	Nut	B-M16		2	
15	Lower Sprocket Bracket		M120-0202	1	
16	Component Plate		M120-0206	2	
17	Fixed Limit Switch Connector		M120-0213	2	
18	Limit Switch Bracket		M120-0227	2	
19	Handle Connector		M120-0226	2	
20	Handle			2	
21	Fixed Connector Bracket		M120-0213	2	
22	Limit Switch	B-TLSM-B104		2	
23	Up&Down Frame		M120-0205	1	
24	Nylon Slider		M120-0229	4	
25	Nylon Slider Connector		M120-0230	4	
26	Limit Switch Matcher		M120-0209	1	
27	Fixed Corrugated Pipe Bracket		M120-0220	1	
28	Motor Sprocket	08B-19Z		1	
29	Motor Bracket		M120-0203	1	
30	Motor	B-T-050-MOPAR		1	
31	Motor Axle		M120-0210	1	
32	Chain	08B		2	

②: Turntable Structure



2-1



2-2

Turntable breakdown drawing

No.	Item	Spec.	Code	Qty (PCS)	Mark
1	Cycle Table		M120-0101	1	
2	Nut	D45		1	
3	Bearing	6010	M120-0217	1	
4	Proximity Switch Matcher			1	
5	Sprocket		M120-0107	1	
6	Bearing		51308	36	
7	Bearing		6202	1	
8	Bearing Axle		M101-0304	12	
9	Roller		M101-0303	12	
10	Chassis Coverplate		M120-0105	1	
11	Bearing	6002		2	
12	Tension Sprocket	12A11Z		2	
13	Tension Sprocket Adjuster		M120-0304	1	
14	Motor			1	
15	Motor Adjust Plate		M120-0103	1	
16	Main Sprocket	12A13Z		1	
17	Chain			1	
18	Chassis			1	
19	Bearing Base			1	
20	Proximity Switch			1	