

G1

Semi-automatic stretch wrapper

Manual

HENO PACKAGING INDUSTRIES LIMITED

We manufacture the packing machine , the end of packing line system

such as palletizer robot , pallet dispenser/stacker/magazine stretch wrapper,

pallet strapping machine,pallet conveyor ,corner applicator,tray erector and former ,case erector &
carton sealing machine

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Chapter 1 Preface

1. Manual

Thank you for your purchasing of our products!

Instructions manual for use, maintenance, safety, transport, storage, unpacking, installation, repairing, diagnostics, spare parts and disposal of the pallet stretch wrapper.

All right served. Manufacturer reserves the right to carry out modifications without obligation of prior notice

2. Importance of the manual

The manual is an integral part of the machine. The information it contains will help you to maintain your machine in good and safe working conditions. Please keep the manual during entire working life of the machine. Make sure that any supplement to the manual is correctly inserted into it. The manual must be read and understood by each user of the machine.

3.Important information

This machine has been submitted to a final test on the functionality of components, protections, controls and emergencies.

Do not modify the machine for any reason.

In case of modifications:

- 1) Compliance with relevant laws is no longer valid
 - 2) The machine can not guarantee the safety for which it was designed.
- The warranty is no longer valid.

4. Manual maintenance

Keep the manual in a dry and cool place. Do not remove, tear or rewrite parts of the manual for any reason. Do not damage the manual. If the manual has been lost or damaged, ask your assistance/spare parts service for a new copy, quoting the document code number.

5.Machine identification date

Machines identification date must always be supplied by the user when requesting spare parts of technical intervention.

Within the limits of what is set forth below, the supplier agrees to repair any manufacturing defects which may

occur within the three year warranty period starting from the date on which the machine has been put into use. Expressly excluded from this warranty are those parts subject to normal wear and tear (such as belts, rubber rollers, gaskets, brushes, etc) and electrical parts, in order to benefit from the warranty the customer must immediately inform the supplier of the defect, quoting the machine serial number.

The customer shall send the defective item to the supplier for repair or replacement. The supplier will perform the repair within a reasonable period of time. Upon providing such repair or replacement the supplier has fulfilled his warranty obligations. If the repairs or replacements must be performed at the place where the machine is installed, all technicians' or installers' labour, travel and lodging expenses will be fully paid for by the customer. The supplier is not responsible for damage and /or defects resulting from:

- Improper use of the machine, negligence or lack of maintenance
- Tampering with the machine or repairs performed by the customer.

The supplier will not be liable for any injury to people or things different from the machine, or for any production failure. With regards to materials not manufactured by the supplier, such as motors or electrical equipment, the supplier will grant the customer the same warranty the supplier receives from this suppliers of such materials.

The supplier dose not guarantee the compliance of its machines with laws in non-eeec countries in which the machines maybe installed, nor dose he guarantee compliance with laws or standards relating to the prevention of accidents or pollution.

Chapter 2 Machine general information:

1. Technical specifications:

- A. Power: 1PhaseAC200-240V50HZ 10A(Or 3PhaseAC380-415V 50HZ 10A)Total power:1.12KW(anti-stretch type) 1.32KW(Pre-stretch type)
- B. Turntable motor Power 0.75KW; 1-14round/minute;
- C. Lift motor: 0.37KW;
- D. Pre-stretch motor: 0.2KW;Stretch rate 100%-250%.
- E. Turntable Diameter: 1500MM (can be made as per your requirements)
- F. Max turntable loading weight: 2000KG (can be made as per your requirements)
- G. Max height of package: 2100MM(can be made as per your requirements)
- H. Pneumatic press unit device: (Optional)
- I. Turntable height: 82CM

2. General function

- A. Panasonic(or MITSUBISHI) PLC control system
- B. Digital screen, 4 wrapping programs: up, up with cap, up+down, up+down with cap
- C. Pre-stretch film carriage
- D. Easy-open film carriage

- E. Automatic photocell reading of pallet height
- F. Reinforce function
- G Slow start and stop
- H. Automatic stop on turntable position “homing”
- I. Use in automatic and manual mode
- J. Turntable rotation speed regulation
- K. Film carriage up/down speed regulation
- L. film extraction speed regulation (motorized per stretch)
- M. Presser management (optional)

3. Main parts

Part Description	Brand
PLC	Panasonic(OR MITSUBISHI)
Inventor	SAJ
Turntable motor	Taiwan Taichuang
Film carriage motor	ZIK
Pre-stretch motor	Taiwan Taichuang
Photocell	Taiwan FOTEK
Limit switch	Steimex
Digital screen	SLJD
Button	Beelee

* Remark

Optional parts: Ramp, press unit, Pre-stretch film carriage

Special size for: Column, turntable.

4. Film carriage characteristics (PS Type)

Film carriage with motorized pre stretch and panel tensioning

Film type: pre-stretch, 23um thick

Max theoretic pre-stretch % up to: 110,160,250,300%

Depending on setting and film tension (expressed as film extension increased compared with initial extension)

Film max-width:500MM

Film carriage loading weight: Max 15kg

Bore shaft diameter of the film: $\varnothing 75\text{mm}$.

5. Turntable characteristics

A. 15 Type

Turntable diameter: 1500MM
Max Loading capacity: 2000kg
Pallet dim: Min 600 x 600mm
 Max: 800 x 1200mm
Rotation speed: 12 r/min~50hz
 14r/min ~60hZ
With adjustable version: from 6 to 14r / min~
Running direction: Clockwise

B. 16 Type

Turntable diameter: 1650MM
Max Loading capacity: 2000kg
Pallet dim: Min 600 x 600mm
 Max: 1000 x 1200mm
Rotation speed: 12 r/min~50hz
 14r/min ~60hZ
With adjustable version: from 6 to 14r / min~
Running direction: Clockwise

C. 18 Type

Turntable diameter: 1800MM
Max Loading capacity: 2000kg
Pallet dim: Min 600 x 600mm
 Max: 1200 x 1400mm
Rotation speed: 12 r/min~50hz
 14r/min ~60hZ
With adjustable version: from 6 to 14r / min~
running direction: Clockwise

D. 20 type

Turntable diameter: 2000MM
Max Loading capacity: 2000kg
Pallet dim: Min 600 x 600mm
 Max: 1400 x 1600mm
Rotation speed: 12 r/min~50hz
 14r/min ~60hZ
With adjustable version: from 6 to 14r / min~
Running direction: Clockwise

6. Column characteristics

Column height: 2500mm

Max wrapping height: 2100mm

Carriage speed: m/min 2.0/2.8~ 50HZ
 2.5/3.4~60HZ

Chapter 3 Essential instructions

Keep this manual; The information contained will help you maintain your machine in good and safe working conditions.

Read all instructions carefully before using the machine: Please pay particular attention to sections marked by the symbol:

The machine is provided with a lockable emergency stop button placed on the control panel when pressed, it stops the machine at any point in the working cycle.

Disconnect the electrical plug from the mains before any maintenance operation.

1. Operators' qualifications

Only staff with the qualifications defined in the following pages may operate on the machine.

It is the user's responsibility to appoint the operators with the appropriate qualification levels and to supply them with the suitable training and operation instructions as defined in this manual.

A. Qualification 1-Machine operator

This operator is trained and enabled to use the machine and carry out operations such as loading and unloading pallets, wrapping pallets, changing film reels.

The factory and division managers should ensure that the operator has been properly trained on all functions of the machine before starting work.

B Qualification 2-Mechanical maintenance technician

This operator is qualified to use the machine as the machine operator and is also able to operate the machine with disconnected safety protections, to check and adjust mechanical parts, to carry out maintenance and repairs.

He is not allowed to work on live electrical parts.

C. Qualification 2a -Electrical maintenance technician

This operator is qualified to use the machine as the machine operator and is also able to operate the machine with disconnected safety protections, to check and adjust electrical parts, to carry out maintenance and repairs.

He is allowed to work on live electrical panels, control equipment, etc

D. Qualification 3--Manufacturer's technician

Skilled operator sent by the manufacturer of his agent to perform complex repairs for modifications, when agreed with the customer.

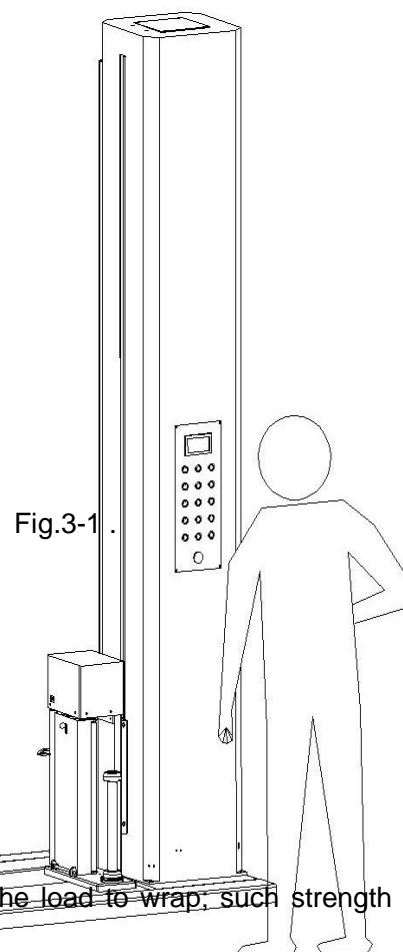
2. Operating areas

Correct operator position

The operator's correct position is in front of the control panel (Fig. 3-1)

During the entire pallet wrapping phase, whether manual or automatic area B indicates the position for carrying out film reel loading. Area C indicates the loading area.

When functioning, the operator must exclusively be in area.



3. Residual dangers

A. Always check load is stable before starting the machine

B. Always adjust tension strength of film on the basis of the load to wrap, such strength can in fact make

unstable for every light loads drop.

C. Notwithstanding are safety precautions conceived by the designers of the machine, it is essential that the operator and maintenance technicians be warned that the following residual hazards can not be eliminated:

- Turntable: never stop on the turntable, even when the machine is not working
- Never touch the area between the base of the machine and the turntable. Danger of crushing.
- Moving pallet: stay clear and never touch the pallet when the turntable is moving
- Always make sure that the dimensions of the load do not exceed those of the turntable.
- When the film carriage comes down do not remain under its range of action paying particular attention not to have parts of the body between the floor and the carriage.
- Do not touch the area between the moving film carriage and the column. Danger of crushing.
- Don't walk between the column and the pallet
- For machines with presser, never stay under the up/down range of action of the presser.
- Do not go near the turntable during its rotation cycle. Danger of crushing.

D. Following the winding process, light electrostatic charges may occur near the film reel and the pallet. There do not constitute a risk, as long as the machine is not installed in areas with a potentially explosive atmosphere.

E. This might in any case cause consequences on the product to be wound, if electrostatically susceptible

4. Safety

A. Protections and prohibitions

Actions which are incorrect or prohibited

- Never try to hold the pallet while the turntable is rotating. Use only the emergency stop button.
- Never work without the safety protections and never remove or disable the safety devices
- Do not use the machine unless it is completely assembled. Installed and fixed to the ground in accordance with the instructions indicated in this manual.
- Do not carry out unauthorized adjustments, repairs and maintenance which require the machine to be actioned with reduced guards. During these operations. Access to the machine is only granted to suitably qualified staff.
- Cleaning and maintenance operations must be performed after disconnecting the electric power.
- Never modify the machine or parts of it. The manufacturer will not be responsible for any consequence.
- Clean the machine using dry cloths or light detergents. Do not use solvents, petroleums, etc
- Do not use the machine in areas with potentially explosive atmosphere.
- Never transport the machine if unpacked and assembled.

B.Warnings and labels

In case of damage or export immediately substitute the labels applied to the machine.

1. Carriage in movement

2. Disconnect the electric plug from the mains before any cleaning/maintenance operation and before opening the electrical panel
3. Running direction of the turntable
4. Danger of falling from the turntable
5. Do not step on the turntable
6. Danger of being trapped between pallet and film
7. Danger! High voltage
8. Point for earth wire connection on the machine

Chapter 4 Installation

1. Transport and handling

A. Transporting and handling the packed machine

The machine is fixed in a wooden crate box with screws and/or straps and each part is adequately protected and fixed.

In order to transport the packed machine use a forklift truck, transpallet or bridge crane adequate to the weight indicated or the type of machine.

The packaging is suitable for any kind of transport: by land, sea and air

B. Transporting and handling the unpacked machine

Never move the unpacked and assembled machine for any reason. The handling may cause damage and serious injury as the weight and height of the column can unbalance the machine and make it overturn. Furthermore, the fixing of the column to the machine basement is unsuitable to bear the transport mechanical stress.

In order to move the machine it is necessary to restore the transport conditions by proceeding backwards along the assembly points.

2. Handling and installation

A. Unpacking

Remove nails and take off the cover of the case, using the correct tools and the protective gloves. Pay attention to the nails and wood splinter

For all the other operations please follow the instructions contained In the manual.

Cut the plastic straps which fix the machine t the pallet

B. Storage

Storing the packed or unpacked machine

If the machine is to remain inactive for a long period, please take the following precautions.

Store the machine in a dry and clean place

If the machine is unpacked it is necessary to protect it from the dust; do not stack anything on the machine

C.Packaging disposal

For packaging disposal follow rules in force in your country.

3. Environmental conditions

Min temperature=+-5 Max=+40

Min humidity=30% max= 80%

The environment must be dust-free

4. Space required for use and maintenance(Fig 4-1)

Min distance from wall A=1000mm B=2000mm

Min height=3600mm

Positioning bases type 16 and type 18

Use an adequate fork-lift truck, slide the forks in the lower parts of the base, lift it and carry it to its installation location.

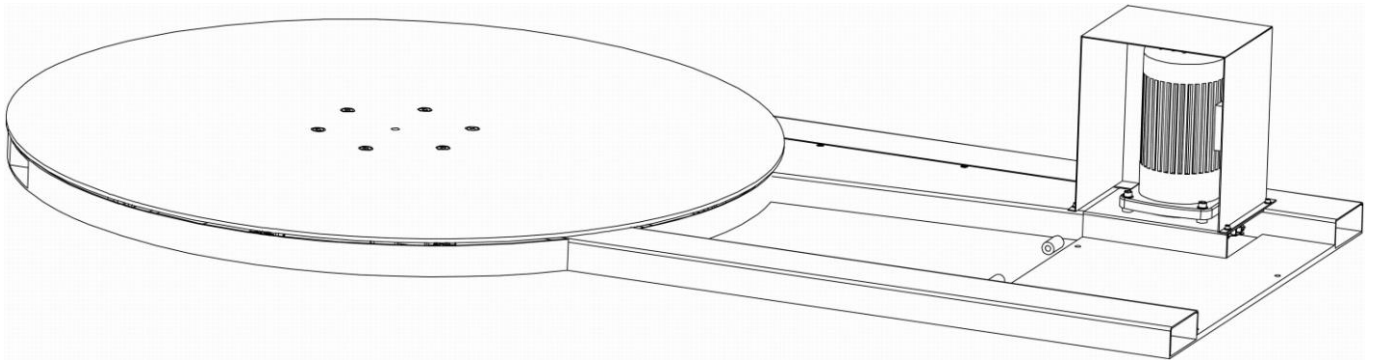


Fig. 4-1

5. Assembling column (Fig.4-2;--- Fig.4-4)

--Unscrew the 2 screws placed on the base of the column.

-Fix a suitable belt for the weight to be lifted to the motor-reducer placed on the higher part of the column. And with an adequate device lift the column until the base is adjacent to that of the turntable.

-Screw the 2 screws previously removed, fixing the column to the support installed onto the base.

Make absolutely sure that the screws are tightened.

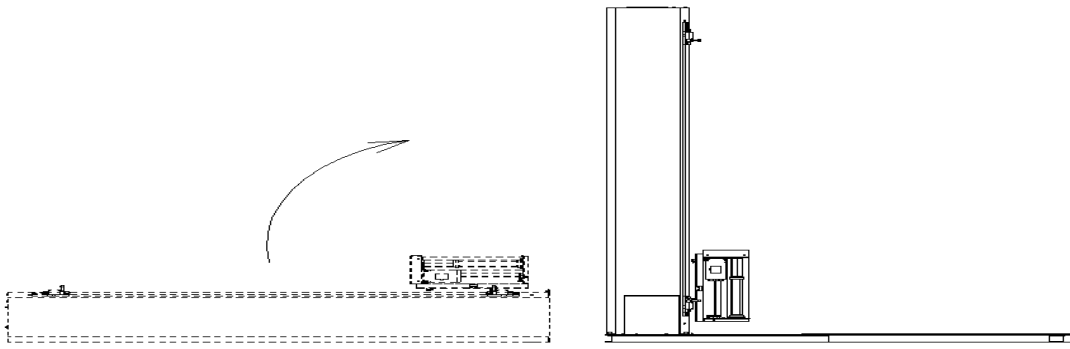


Fig.4-2

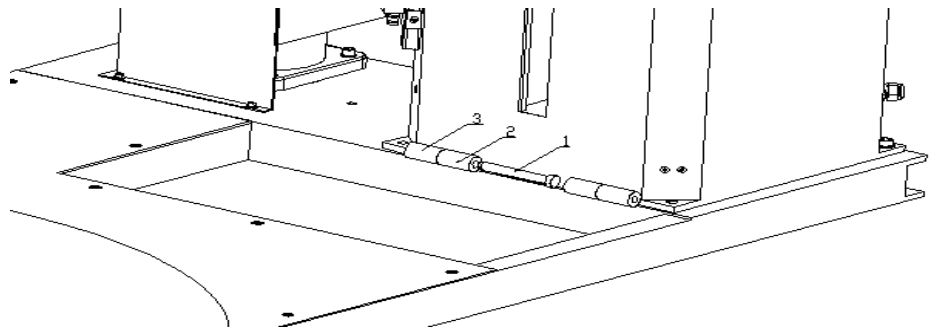


Fig.4-3

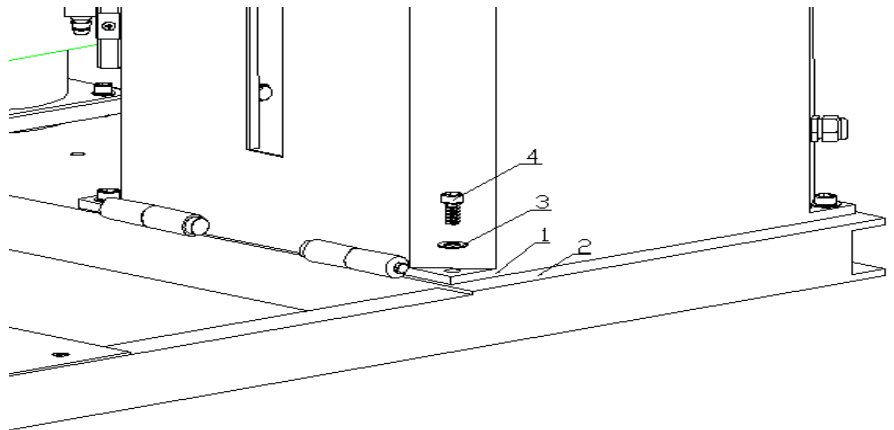


Fig.4-4

Note: During installation never step onto the turntable as it is free to rotate.

6. Precautions to follow during machine fixing and leveling operations

Before placing the stretch wrapper in the required area, make sure the floor is perfectly flat and does not have any hollow parts, considering that all the lower surface of the base must adhere to the floor, particularly the part with the wheel supports under the turntable and the column supporting area.

It these conditions are not respected, the machine will malfunction.

When all the above conditions are respected, it is possible to carry out the installation of the stretch wrapper to the ground.

A. Check machine stability(Fig.4-5;Fig.4-6)

- Connect the turntable engine power cable movable male plug to the movable socket on the column
- Place and fix with the 2 screws the turntable engine protection carter
- Link the connectors as shown, making sure the indicated markings correspond.

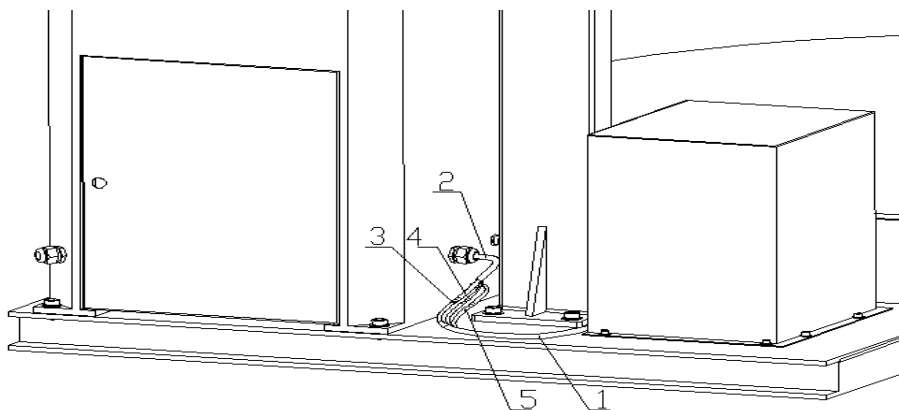


Fig.4-5

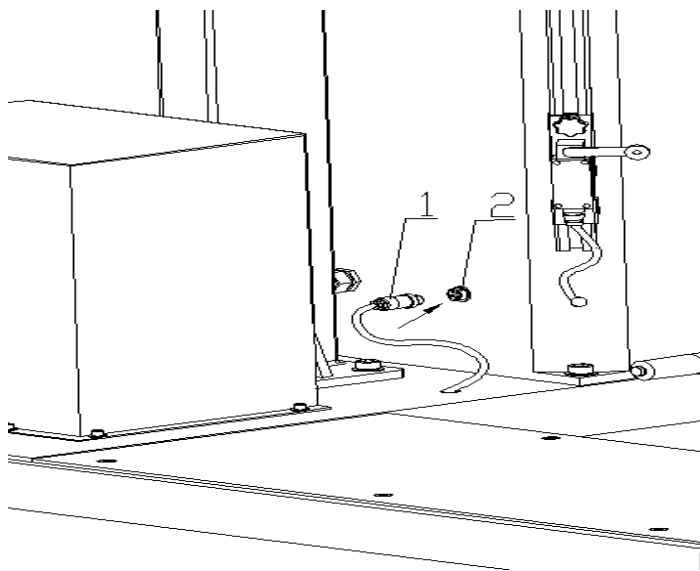


FIG4-6

B.Preliminary electrical checks

- To be carried out before connecting the plug to the mains.
- Make sure the socket is fitted with an earth protection circuit and that the voltage and power frequency correspond to those indicated by the manufacturer.

--It is the user's responsibility to make sure that all parameters indicated by the manufacturer and the laws are force in the country of installation are respected.

7. Electrical connections

- Machine connection to the mains and relevant checks
- Check that the main switch is on position "off"
- Connect the cable supplied with machine to a plug which complies with regulations, considering the type of power supply indicated on the data table
- Connect the plug to the mains

Procedure for the correct connection of the order of the power supply phase (consider the board supplied with the machine) remove any tools placed on the machine

- A. Rotate the main switch onto "on"
- B. Unblock the emergency stop button
- C. Press the luminous button system inserted
- D. Action manually carriage up (or down)

Check that the running direction of the film reel carriage corresponds to that of the button pressed. In case it dose not correspond, invert the connection of the two phases in the supply plug.

8. Photocell regulation

- Place the pallet at the maximum signal acquisition distance
- Use the trimmer placed in the higher parts of the photocell, decreasing or increasing sensitivity.
- Sensitivity is correct when the red led placed on the photocell comes on.

9. Film reel loading

Before carrying out any operation, read all "safety" instructions

- Place a film reel on the reel holder and fix it with the blocking ring nut.
- Remove the first parts of the film corresponding to one complete turn.
- Open the door of the carriage feed the film between the rubber coated rolls and counter-rolls, following the direction shown on the label placed on the higher part of the carriage.
- The film must pass in front of the feeler pin and in front of the last roll
- Close the door, if there is one, considering that the machine can not work with the door open

10. Film path

The picture on the machine shows the labels which identity the film reel path. On each film reel carriage there

is its corresponding label.

Chapter 5 Control Panel

1. Key buttons. (Fig.5-1)

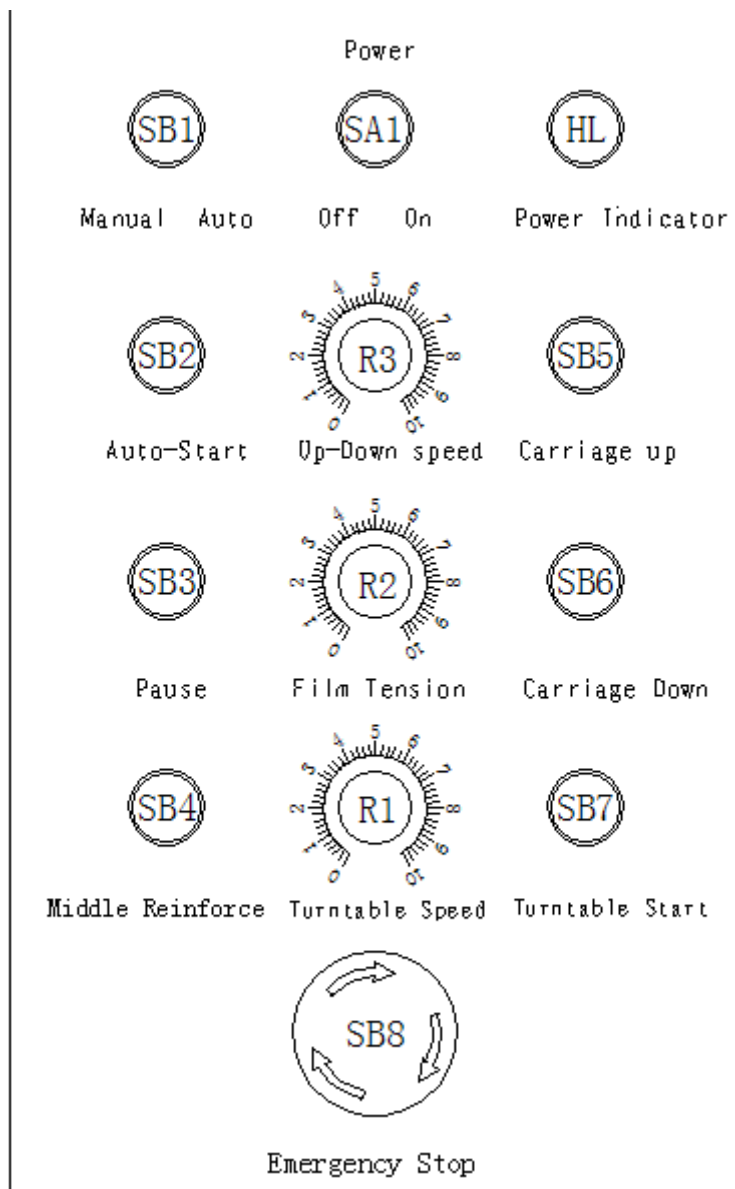


Fig.5-1

SA1 Power switch: Rotate clockwise onto position ON to give power to the machine

HL Power indicator: Power on, led on

SB1 Mode: Manual mode selection (led Manual), Automatic mode (led Auto)

SB8 Emergency stop: Press down to stop turntable and film carriage immediately. Rotate clockwise to

release Emergency stop button.

SB7 Turntable Start/stop: Press down to start, Again press down to turntable stop

SB5 Film carriage up: Press down to go up. Go up to upper limit switch, or Photocell auto reading, or Press again to stop going up.

SB6 Film carriage down: Press down to go down. Go down to lower limit switch, or Press again to stop going down.

R1 Turntable speed: Clockwise to faster, Anticlockwise to slower

R3 Film carriage up&down speed: Clockwise to faster, Anticlockwise to slower

R2 Pre-stretch rate: Clockwise to get more tension, Anti-clockwise to get less tension.

SB2 Semi-auto/Auto Mode: Under the situation of (Manual/auto mode), press this button to use semi-auto/auto mode.

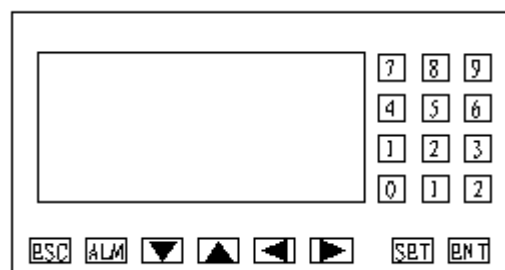
SB3 Pause: Under auto mode, press to pause working; press again to continue working. This function is unavailable under manual mode.

SB4 Middle re-inforce: Set the cycles first, when film carriage comes to the parts needed re-inforce, press down this button

Exchange between photocell and limit switch functions: This switch is put in control box. On: Photocell mode on, Off: Photocell mode off. Normal setting is photocell on. When the packing products are with black surface, photocell won't work, Please turn off this switch to use limit switch.

Note: Please turn off the power switch when doing this operation.

2,Text digital screen(Fig.5-2)



A.Wrapping cycles:

Setting range:1-99 cycles. Press "set", when number flash, clear previous setting, input new value, Press"enter" to finish.

B. Upper part cycles

Apply cycles to the upper part of product. Setting range:1-99. Setting way as above.

C. Lower part cycles

Apply cycles to the lower part of product. Setting range:1-99. Setting way as above.

Page down to set below parameters:

D. Re-infoce cycles. Setting range:1-99

E. Overhead height: To set the delay time to do overhead wrapping. Setting range:0-9S seconds

F. Press down time: to set the time during the press unit start to go down and stop.

3. Machine operation

This machine has below 2 functions

A. Single Manual mode: When set **manual mode** by SB1(mode), SB7(turntable start), SB5(film carriage up), SB6(film carriage down) is available.

B. auto mode: When set **auto mode** by SB1(mode), setting wrapping parameter through text screen, press SB2(auto mode), machine will work as per the parameter set by text screen.

Chapter 6 Maintenance

1. Checks and interventions(Fig.6-1-- Fig.6-4

Chain lubrication: to be carried out every 3 months by operation with qualification 2

Cleaning machine: to be carried out each week by operator with qualification

Safety devices check: to be carried out each week by operator with qualification 1

Lifting chain wear and tear check: to be carried out each week by operator with qualification 1

Compressed air condensation: to be cleared out each week by operator with qualification 1

Cleaning rubber coated rollers: to be cleared out each week by operator with qualification 1

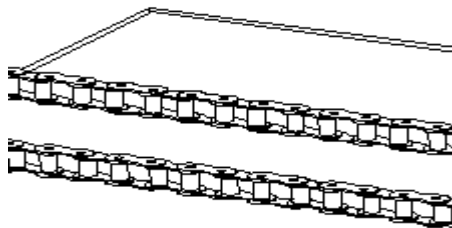


Fig.6-1

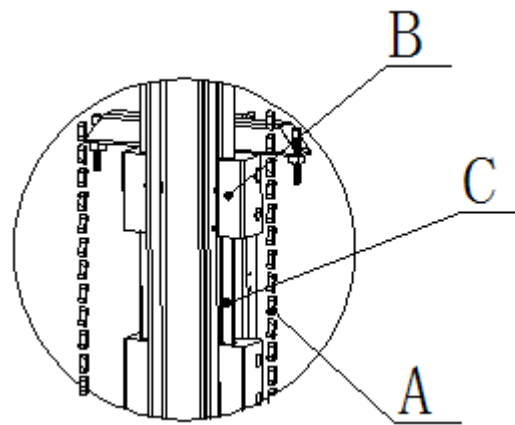


Fig.6-2

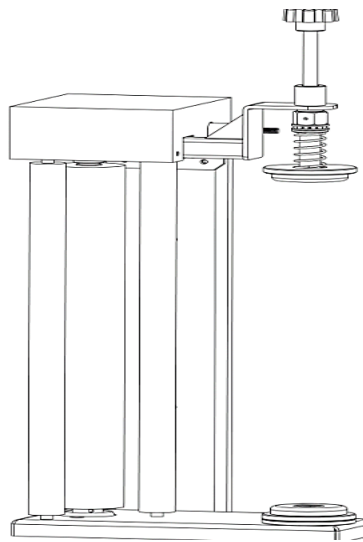


Fig.6-3(anti-stretch)

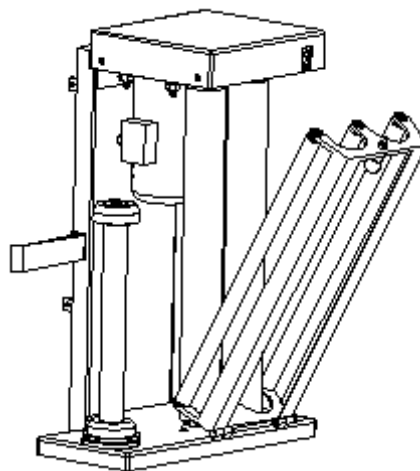


Fig.6-4(Pre-stretch)

Note:

- Before any operation rotate main switch onto OFF and remove mains plug.
- During maintenance on the machine, only the appointed and qualified operator may be present.
- To end maintenance, always check functioning status of all safety devices and protections: EMERGENCY STOP lockable button

2. Ordinary and extraordinary**A. Chain lubrication**

Remove the protection cover

Lubricate with brush oil or oilcan, using exclusively lubricant type "SAE30"

Replace and fix protection cover

B. Running guides cleaning

Clean with a clean cloth

C. Rubber coated rolls cleaning

Clean regularly (at least once a week) film reel rubber coated rolls with a cloth or sponge and neutral non-lubricating detergent.

This will guarantee adherence of the rolls

D. Photocell cleaning

Clean the photocell regularly with a dry cloth as shown in the picture.

E. Replacement of turntable running wheels

Remove the 6 screws from turntable

Push turntable onto transpallet forks

Remove wheel group upwards from its U shaped housing

Remove shaft 1 and recover spacers 2 and 3

F. Replace damaged wheels

Reassemble everything inserting shaft 1 in the two wheels 4 with the longest spacer 2 in the center and the two shortest spacers 3 at the sides of the wheels

Pay particular attention when inserting the shaft with the rollers into the guide

Only use original spare parts

G.Chain tensioning

- Check chain tensioning
 - If necessary to adjust the tensioning, only loosen but do not remove the 4 screws next to the motor-reducer.
 - Adjust the screw placed at the back of the base under the column, loosening or pulling it according to the need.
 - Check the tensioning is correct and if so, tighten the screws in fig.11 and double check
- A correct tensioning enables a 10/20 mm. Unilateral oscillation.

H. Substituting Chain for column

- Lower the column following installation chapter backwards
- Lifting the column with an adequate device
- Bring the film reel carriage to the lower part of the column. Remove the screws placed in the upper part of the column and Bring the column to a horizontal position
- Remove covers placed in the higher part of the column, removing the fixing screws.
- Using a fixed spanner and a ring spanner completely unscrew the nut and remove the lock from the Chain slot.
- Remove the film reel carriage from the top of the column, leaning on a support suitable to hold the weight
- Remove the screw and the belt holding lock from the back of the film reel
- Insert the new Chain and follow all operations backwards, to carry out re-assembly.

Note:

Before carrying out any cleaning or maintenance operation turn the main switch onto position **OFF** and remove the plug from the mains. Use dry cloths or neutral detergents. Do not use water or solvents.

Chapter 7 Accessories

1. Press unit(to select part)(Fig.7-1, Fig.7-2)

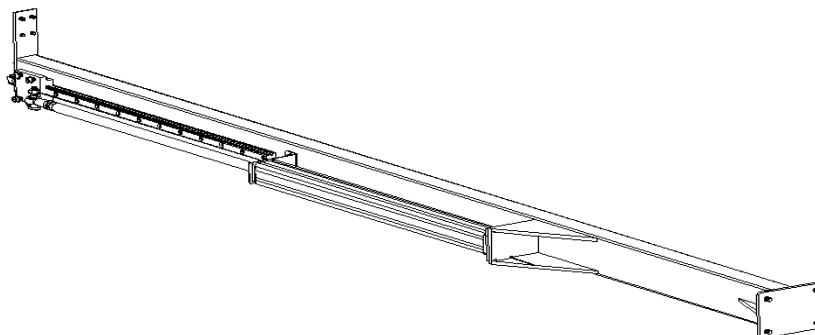


Fig.7-1

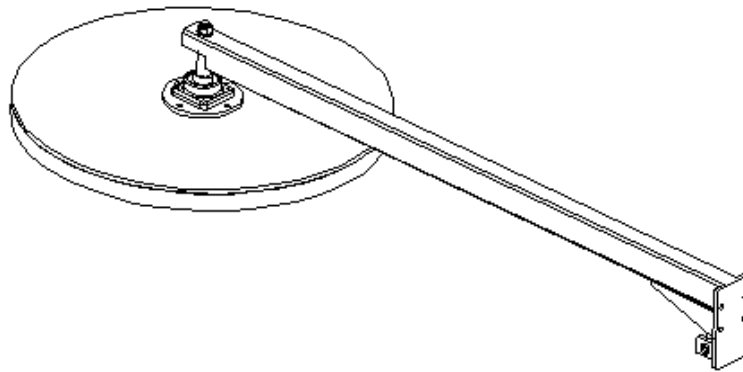


Fig.7-2

Charcteristics

- Electro-pnematic accessory deigned especially to stabilize unstable loads
- Minimum height of load:1200mm
- Minimum supply press:6 bar
- Air consumption L/cycle:20/40

Installation

- Turn off the machine
- Remove the column carter unscrewing the screws and the eyebolts
- Mount the pumps onto column
- Lift and place the presser column fixing it with the screws to the base and to the pumps assembled before
- Remove the electric valve operating cable from the column, through the hole on the head plate, and insert it into the machine column connect the electric panel
- Connect a pneumatic tap to a pneumatic tube in the space between motor reduce and column.
- Turn the machine on by rotating the main switch and pressing button 8 from the operator panel. Position in manual mode, button 13 and action the presser descent with button 14
- Assemble arm onto the presser carriage and cap onto the column
- Before assembling the cap onto the machine column, before 3 discharge holes.

Function

The presser can function in both manual and automatic mode.
The presser will automatically go up at the end of the cycle.

2.Ramp

Characteristics

- Accessory especially designed for loading the pallet onto the machine with the transpallet.

- Maximum load: 2000kg
- Weight: 14.5kg

Installation:

Bring the ramp closer with a suitable lifting device and place the 2 plugs in the foreseen placements on the base and in the desired position

Note: Do not leave lifting devices on the ramp and do not stay on the ramp during operations.

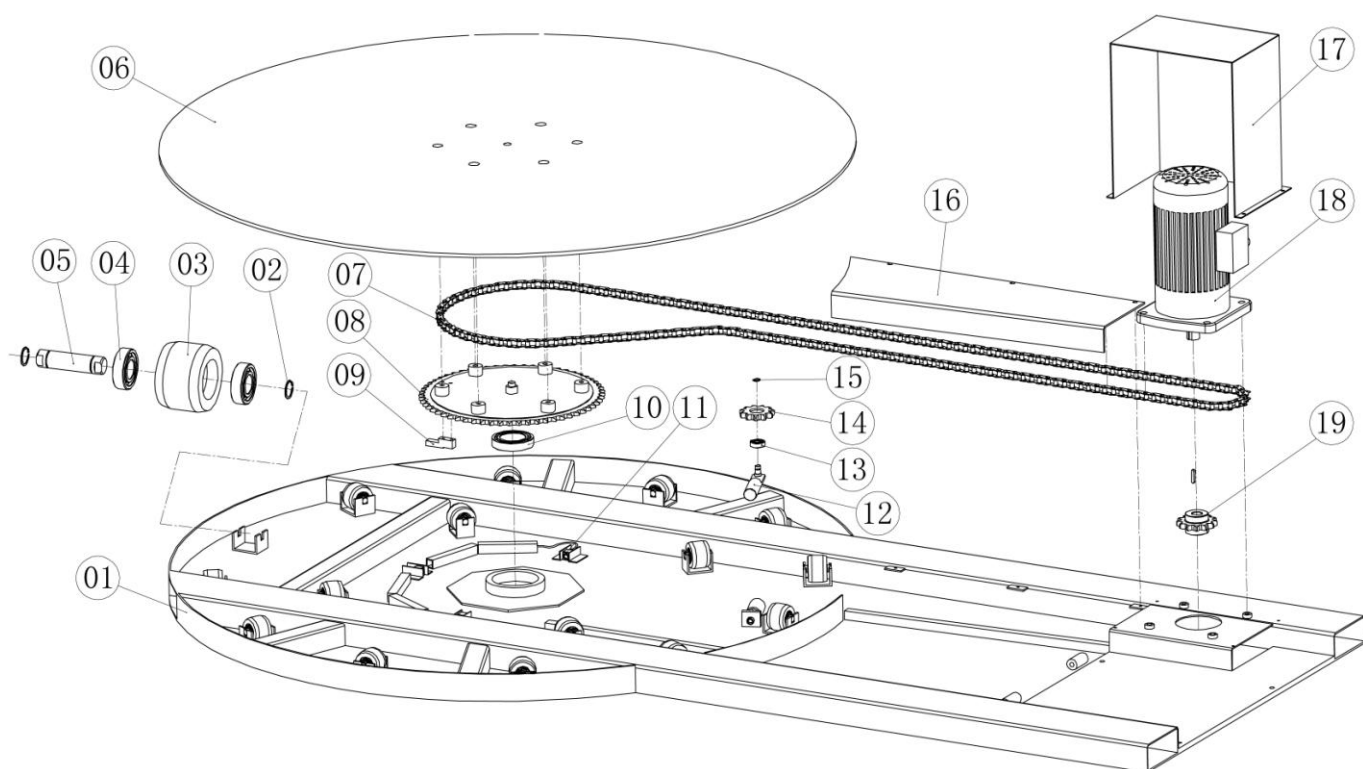
Chapter 8 Troubleshooting

Situation	Cause	Solution
Power on button does not switch on	Emergency stop button pressed; pre-stretch door open, fuse	Unlock by turning anticlockwise; close door and press Reset button; check and maybe replace
Turntable dose not turn when pressing start	Machine not in position 0; wrong speed setting in wrapping program, turntable inverter motor	check turntable speed setting, check
Film tension not regular	Wrong film tension setting, electronic check chart damaged, feeler pin potentiometer	Check potentiometer "reg, film tension", check and replace
Carriage dose not stop at top of pallet but continues to top of column	Pallet photocell	Adjust sensitivity
Presser dose not go down	Presser disabled, electric valve, pneumatic cylinder	Checking setting, check and / or replace; check regulators on cylinder and /or replace
Carriage puts too much film on lower part of pallet	Programmed LOW turns number too high	Check no. Of set turns and reduce
Carriage ascent/descent speed too slow/fast	Carriage speed set on wrong value	Adjust speed
Machine dose not stop to put cap	Wrong wrapping program	Check no. Of chosen program
Carriage puts too much film on upper part of pallet	Programmed high turns number too high	Check no. Set turns on display and reduce
At the end of wrapping cycle Presser dose not go up	Pneumatic valve Pneumatic valve Single direction valve	Check/replace

Pressure of Press disc on pallet is too high	Pressure regulator	Adjust/replace
Turntable disc not stable and / or stops	Chain too loose	Adjust chain stretcher
Film slips on rubber coated rollers	Dirty rubber coated rollers	Clean with alcohol
Strange noise	Loose chain, one or more wheels under the turntable are broken due to wear, worn out turntable motor reducer	Reducer adjust tension or replace chain, replace wheels, replace reducer

Chapter 9 Spare parts

1.Turntable spare parts

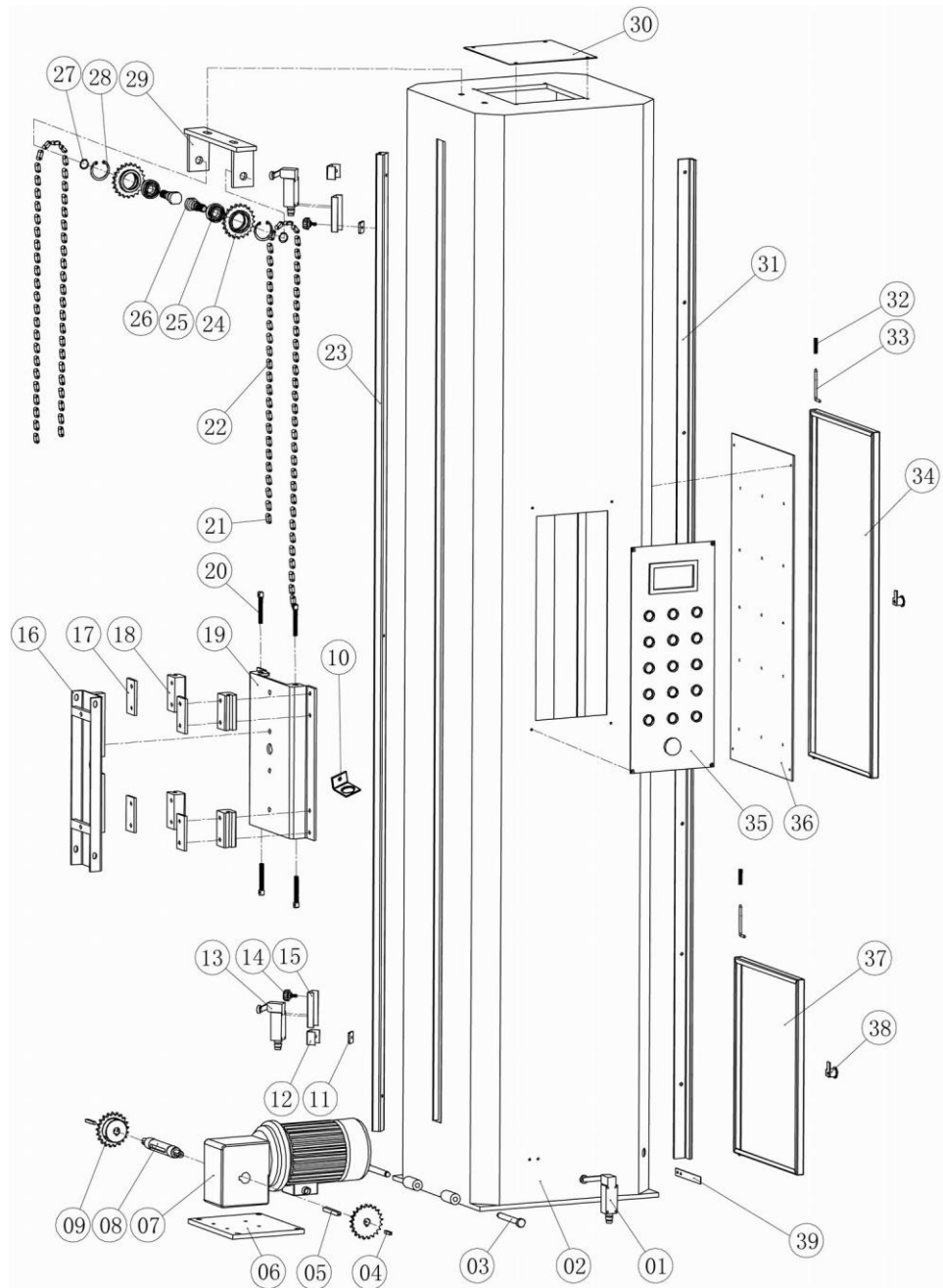


No	QTY	Description	Specification
1	1	Base unit	
2	30	15 ring	∅ 15
3	15	Roller	

4	30	Bearing	6202
5	15	Shaft	
6	1	Turntable	Diameter=1800mm
7	1	Chain	12A-1
8	1	Chain Wheel	12A64Z
9	1	Panel	
10	1	Bearing	6211
11	1	Photocell	12A11Z
12	1	Adjusting bracket	
13	1	6004 bearing	6004
14	1	Adjust Chain Wheel	
15	1	Outer ring	
16	1	Chain cover	
17	1	Motor cover	
18	1	Motor	0.75KW
19	1	Chain wheel	12A13Z

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2. Column spare parts



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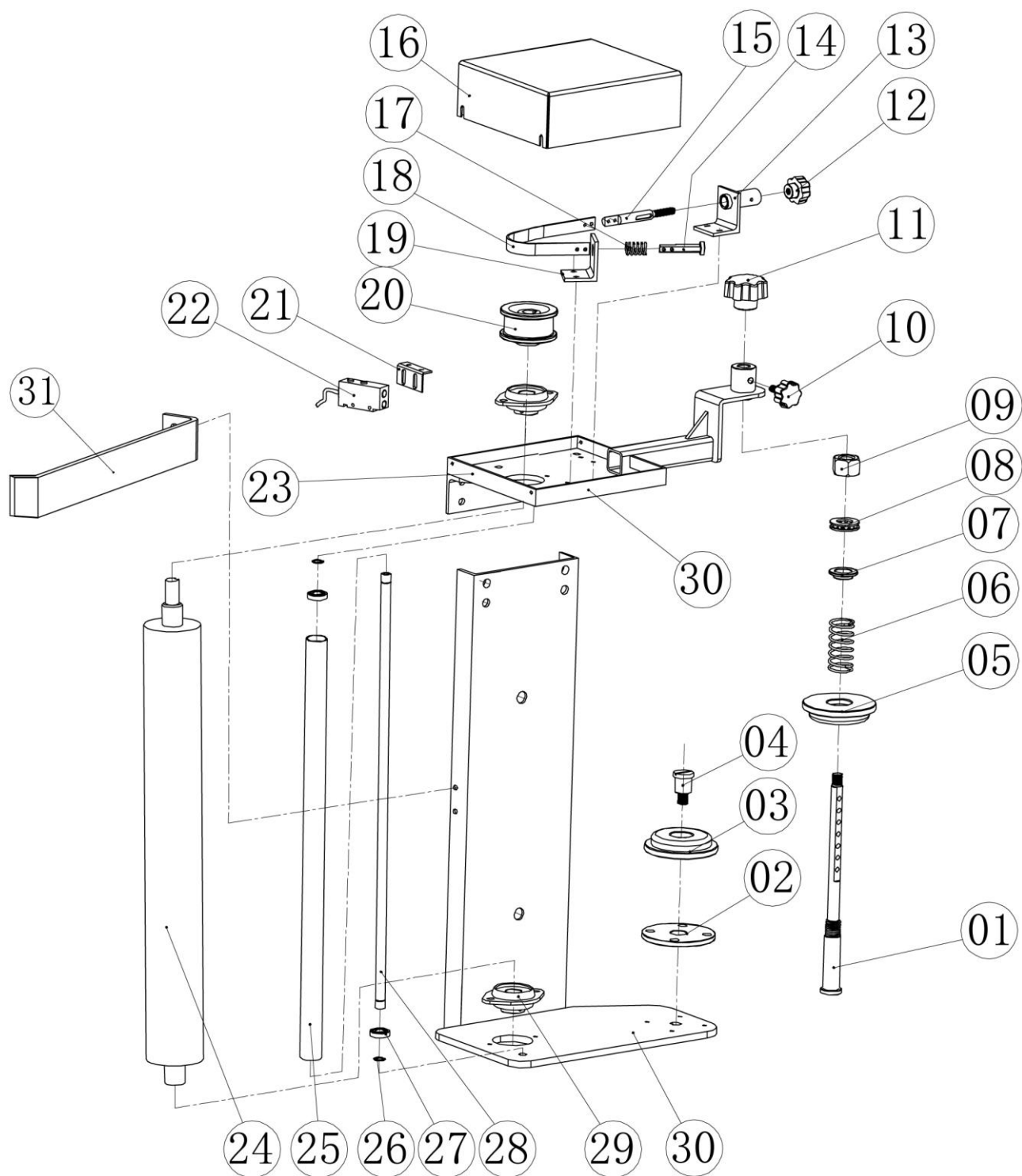
NO	QTY	Description	Specification
1	2	Limit switch	
2	1	Column	
3	2	Bolt	
4	2	srew	
5	2	Key	
6	1	Plate	
7	1	Motor	0.37W 1:80

8	1	Motor shaft	
9	2	Chain wheel	08B21Z
10	1	Bracket	
11	2	screw	
12	2	Limit block	
13	2	Limit switch	LSM-8108
14	2	M6 knob	
15	2	Bracket	
16	1	Bracket	
17	2	Plate	
18	4	Nylon slip block	
19	1	Bracket	
20	4	screw	
21	4	Chain connecting ring	
22	2	chain	08B-1
23	1	Limit switch guide	
24	2	Chain wheel	08B19Z
25	2	Bearing	6004
26	2	Upper shaft	
27	2	Nut	
28	2	Inside ring	
29	1	Chain wheel bracket	
30	1	Column top cover	
31	1	guide	
32	2	spring	
33	2	bolt	
34	1	Control box door	
35	1	Control panel	
36	1	Electric Control plate	
37	1	Bottom column door	
38	2	door lock	
39	1	plate	

3. Film carriage spare parts(Anti-stretch film carriage)

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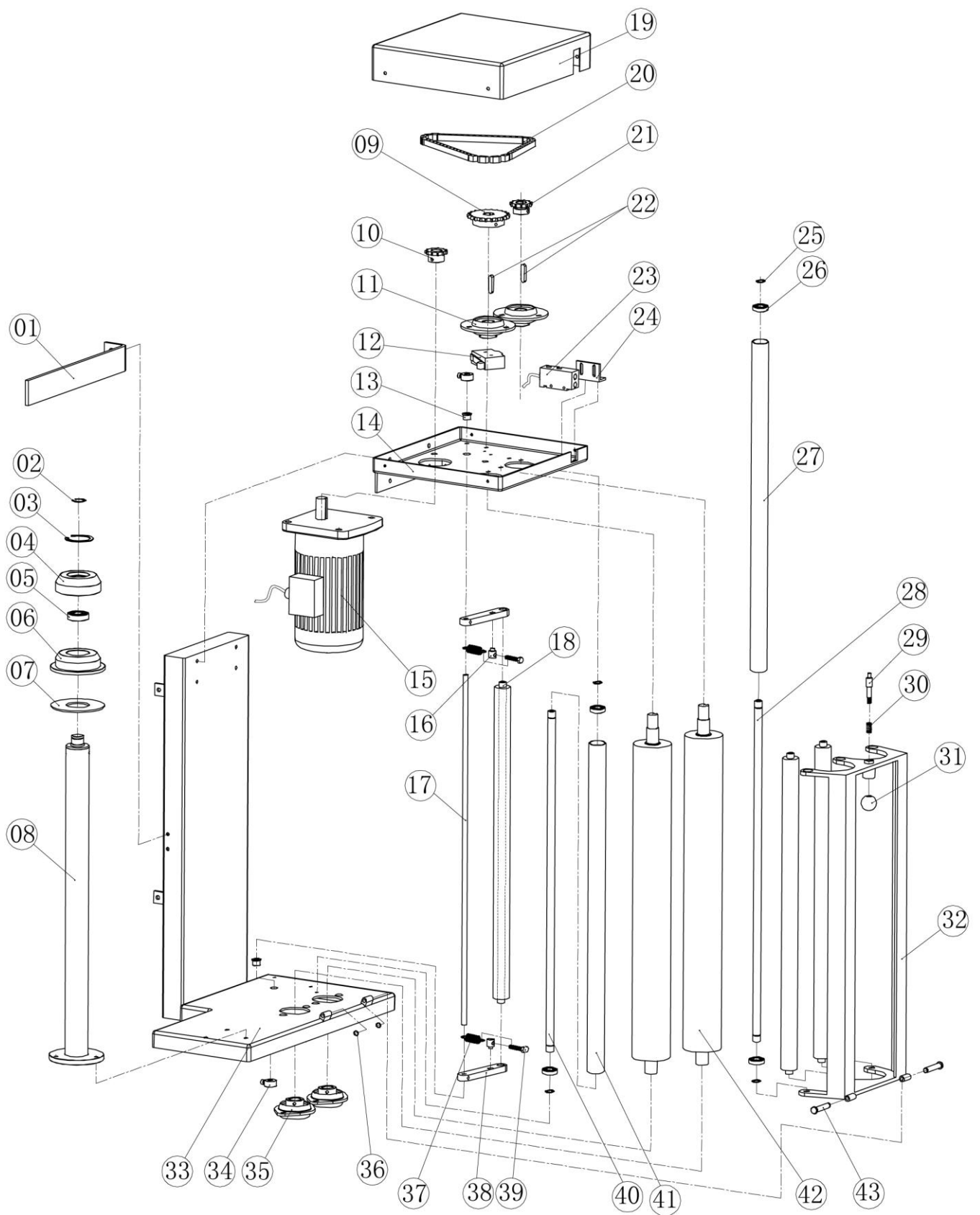


NO	QTY	Description	Specification
1	1	Carriage shaft	
2	1	ring	
3	1	Nylon bottom press block	

4	1	Srew	
5	1	Nylon top press block	
6	1	Press spring	6004
7	1	Shaft sleeve	
8	1	Bearing	5114
9	1	Shaft ring/Nut	M12
10	1	Five-star handle	
11	1	Five-star knob	
12	1	Five-star knob	
13	1	Bracket	
14	1	Tension screw/Bolt	
15	1	Tension nut/ Bolt	
16	1	Top cover	
17	1	Spring	
18	1	Belt	
19	1	Bracket	
20	1	Belt wheel	
21	1	Photocell Bracket	
22	1	Photocell	FR-2MX
23	1	Film carriage top plate	
24	1	Zinc roller	
25	1	Zinc roller	
26	1	Outer ring	∅ 12
27	2	Bearing	6901
28	1	Shaft	
29	2	UCPF204	
30	1	Film carriage bottom plate	
31		Limited Bracket	

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4,Film carriage spare parts(Pre-stretch film carriage)



NO	QTY	Description	Specification
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1	1	Top Protection cover/Limited bracket	
2		Outer ring	∅ 12
3	1	Inside Ring	∅ 52
4	1	Nylon sleeve	
5	1	bearing	6004ZZ
6	1	Nylon sleeve	
7	1	Washer	
8	1	Film shaft	
9	1	Chain wheel	06B22Z
10	1	Chain wheel	06B13Z
11	2	SBPF-204	SBPF-204
12	1	Microswitch	Z-15GW2-B
13	2	Sleeve	
14	1	Film carriage top plate	
15	1	Motor	0.2KW 1:7
16	1	Spring buckle	
17	1	Shaft	
18	1	Zinc roller	527mm
19	1	Top cover	
20	1	Chain	06B-1
21	1	Chain wheel	06B11Z
22	2	Key	6*6*30
23	1	Photocell	FR-2MX
24	1	Photocell bracket	
25	2	Outer ring	∅ 12
26	8	Bearing	6901
27	3	Zinc roller	
28	1	Shaft	
29	1	Srew pin	
30	1	Spring	
31	1	Ball knob	∅ 30
32	1	bracket	
33	1	Film carriage bottom plate	
34	1	Sleeve	
35	2	SBPFL-204	
36	2	pin	
37	2	Spring	
38	2	Spring buckle	
39	4	M6 socket screw	M6*10
40	1	Shaft	