

AUTO BAG SEALER

MANUAL



Preface

Thank you for purchasing our automatic bag sealing machine.

This manual explains its basic structure, usage method and operation precautions, in order to facilitate the safe and correct use of the machine and improve the service life of the machine. Please read this manual in detail before using the machine, please ensure

that the manual is delivered to the end In the hands of people, if the contents of this manual are changed due to technical updates, without notice.

Safety Precautions

1. Please read this manual carefully before operating this machine.
2. When operating the machine, the operator must not place the body parts in the machine running position.
3. Maintenance personnel must read this instruction manual in detail during maintenance.
4. During loading and unloading of PE film and normal maintenance or repair, please be sure to press the stop switch for safety.
5. Non-training personnel, please do not approach or touch the machine at will.

This machine is specially designed: only simple cleaning and maintenance (such as adding lubricating grease to moving parts) is required on a regular basis, and the operator only needs to use it correctly in accordance with the manual to save a lot of unnecessary trouble. Our company hopes that you can extend the service life of this machine by operating according to this manual.

CONTENT

1.The machine feature.....3

2.Description of mechanical structure and adjustment.....5

3.Machine operation process.....7

3.1.HMI operation and instruction.....9

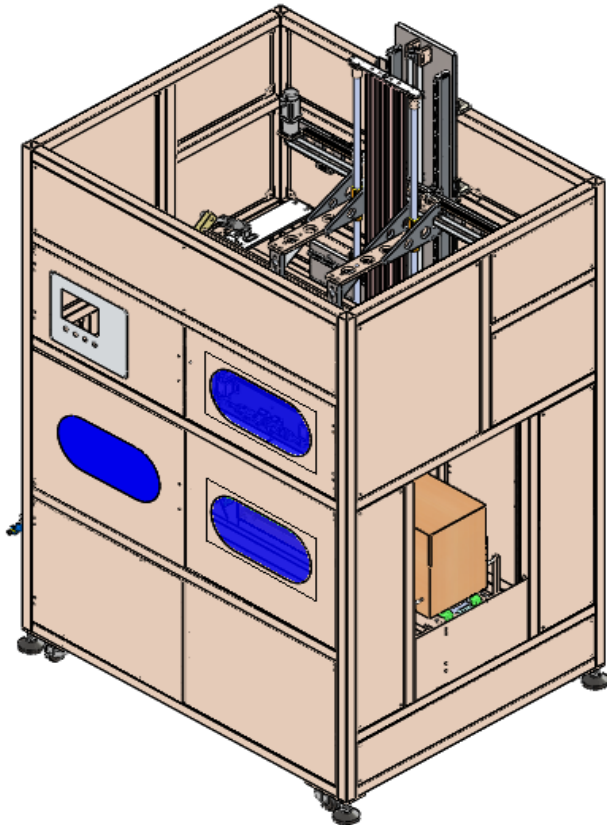
3.2.Electrical schematic diagram..... 14

4.Safety precautions.....16

5.Trouble shooting.....14

1.Characteristics

This machine is a product of a series of packaging machines with automatic bag lifting and automatic sealing functions. It is economical and efficient in stand-alone operation. It is an ideal packaging equipment.



Production: 4-6 ctn/min

Length: 400mm (Custom-made);

Width: 300mm (Custom-made);

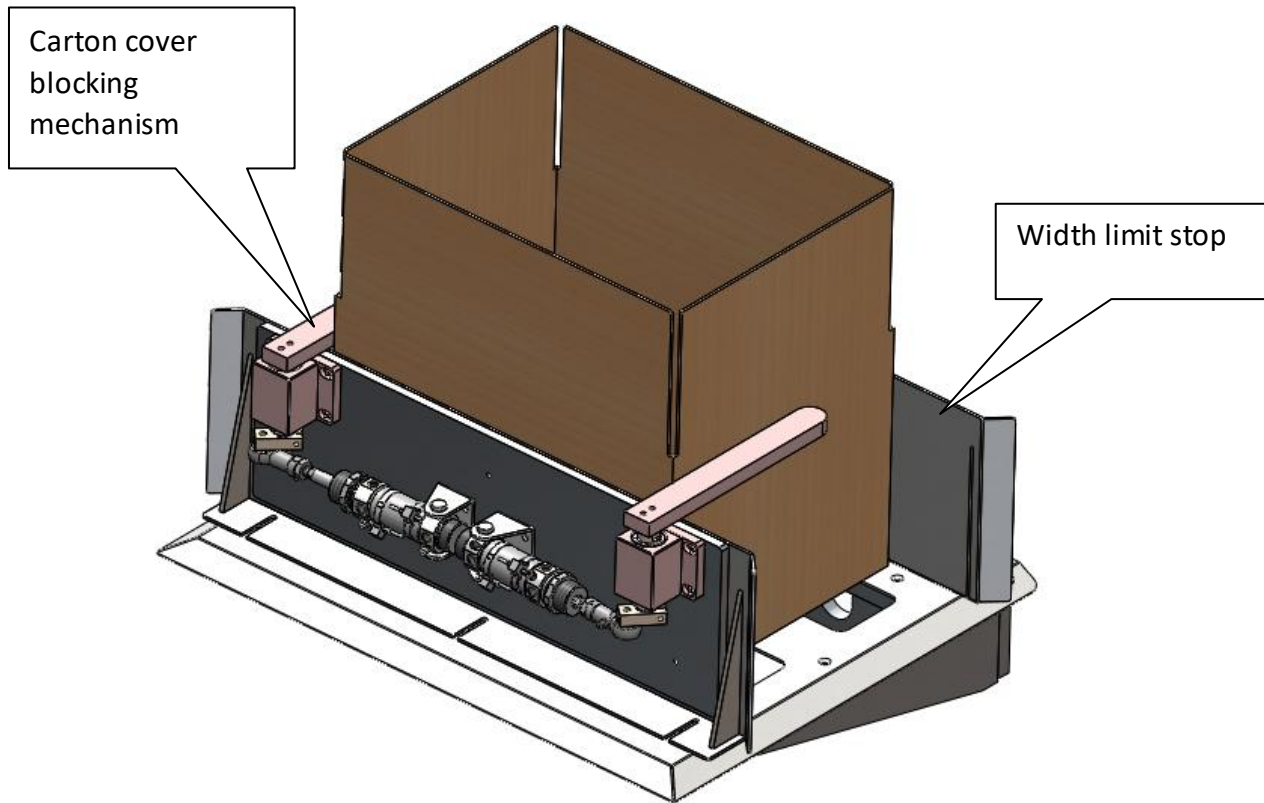
Height: 230&250mm;

Machine dimension: 2000mm*1500mm*1800mm;

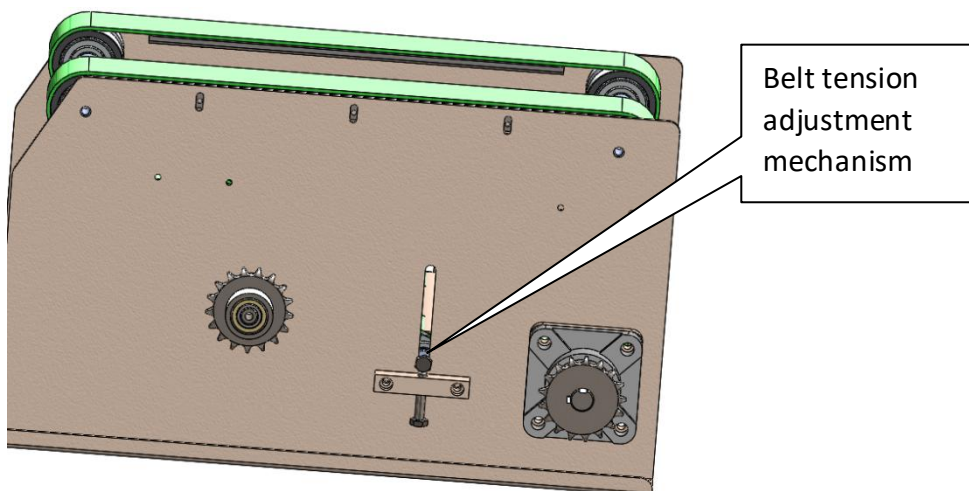
Power: 380v 4.5KW

Air pressure: 0.6Mpa

2: Mechanical structure and adjustment instructions

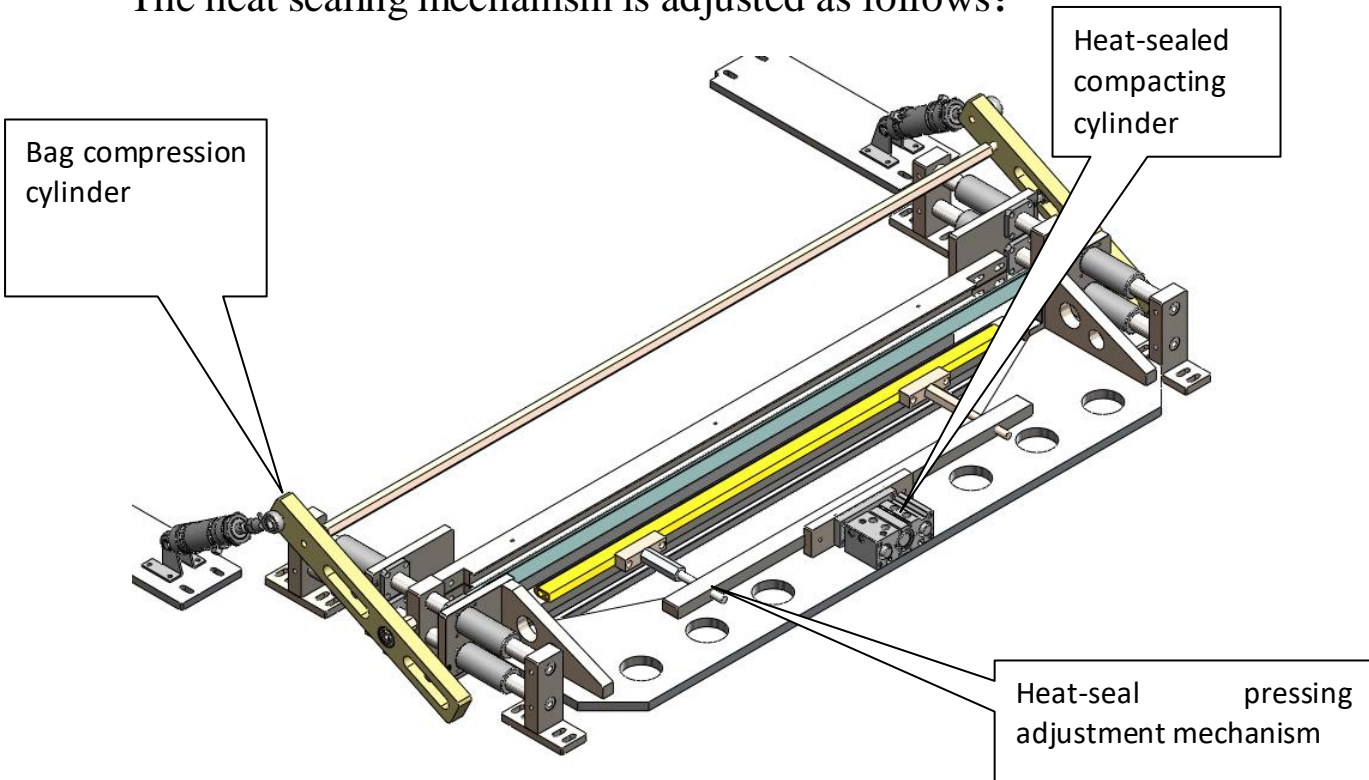


Note: The width limit stop restricts the carton in the middle of the conveyor belt, and the carton cover mechanism prevents the front and rear covers from supporting the carton during the process of opening.



Note: Adjust the tension of the belt by adjusting the screws of the tensioning mechanism.

The heat sealing mechanism is adjusted as follows:



Description: Adjust the bag tightness by adjusting the bag compression cylinder, and adjust the tightness of the heat-sealed bag by adjusting the heat seal adjustment mechanism

3: Machine operating instructions

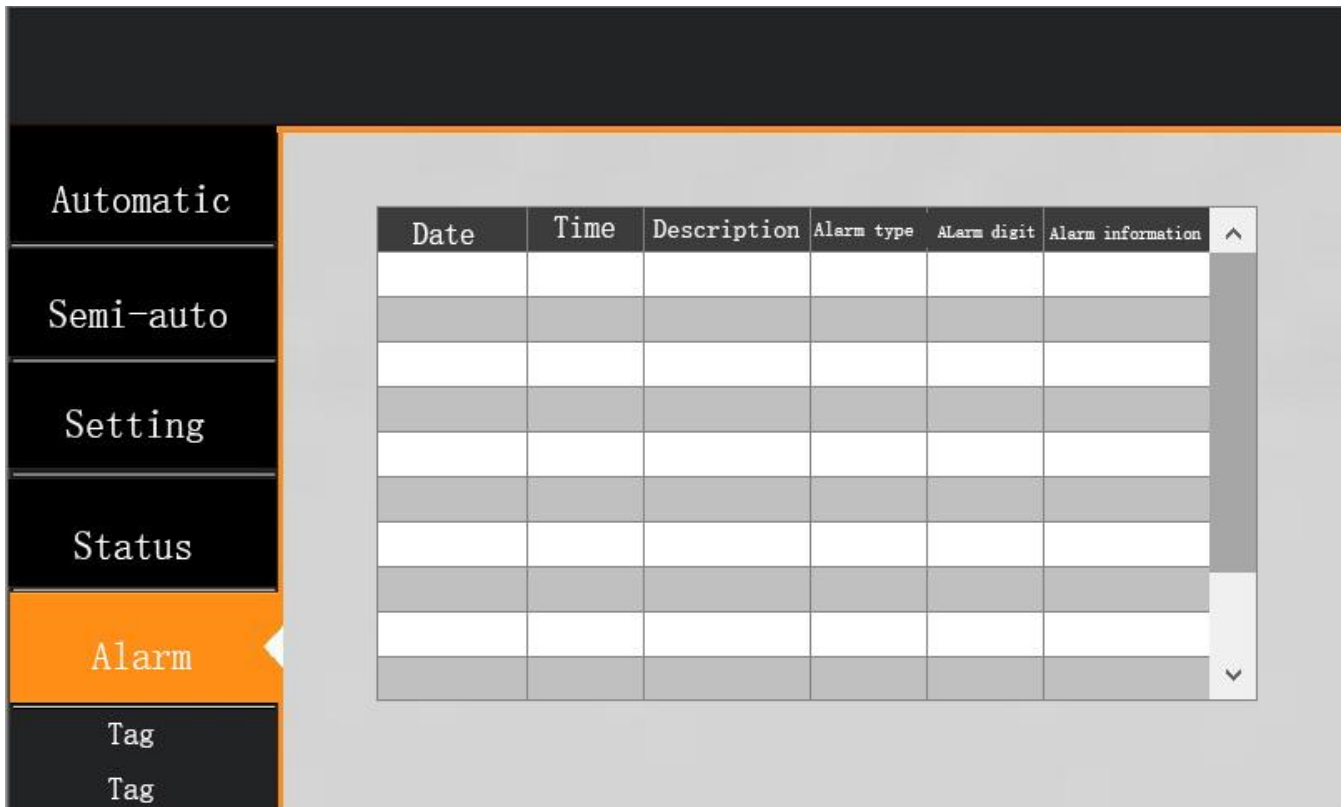
3.1 The touch screen display is as follows:

Automatic	Start	Single step	Stop	Reset
Semi-auto	<div> <div>Current production :</div> <div>Tag</div> <div>Zero</div> </div> <div> <div>Cumulative production :</div> <div>Tag</div> <div>Zero</div> </div>			
Setting				
Status				
Alarm				
Tag	Communication status 0 is normal			
Tag	Edit text			

Automatic	Carton raise&fall axis suck bag position	Tag	Adopt	Heating time:	Input	S	Save
Semi-auto	Bag sucking axis suck bag position	Tag	Adop	Carton raise&fall axis seize bag position	Tag	Adopt	
				Bag open axis seize bag position	Tag	Adop	
Setting	Carton raise&fall axis open bag position	Tag	Adop	Bag open axis sealing bag position	Tag	Adop	
Status	Bag-open axis pull up position	Tag	Adop	Bag suck axis insert bag position	Tag	Adop	
Alarm	Bag sucking axis pull bag left&right position	Tag	Adop	Bag open axis insert bag position	Tag	Adop	

Automatic		Up		On		Up
Semi-auto	Back	Raise	Back	Open bag	Back	Pull film
Setting		Down		Off		Down
Status	position	Tag		Tag		Tag
	Speed	Edit text		Edit text		Edit text
Alarm						
Tag						
Tag						
	Carton stop cylinder	Clamp cylinder		Seize film cylinder		Sealing cylinder
	Blower	Film-suck valve		Transport motor		Sealing test

Automatic	I0.0Raise&fall servo upper limit	I1.2Start	I2.4Sealing cylinder extend
	I0.1Raise&fall servo lower limit	I1.3Stop	I2.5Input detective sensor
Semi-auto	I0.2Raise&fall servo origin	I1.4Reset	I2.6Slow down sensor
	I0.3Bag open axis servo open limit	I1.5Carton-stop cylinder origin	I2.7 Position sensor
Setting	I0.4Bag open axis servo close up limit	I1.6Carton-stop cylinder extend	I3.0 Output sensor
Status	I0.5Raise&fall servo origin	I1.7Clamp carton cylinder origin	I3.1 Raise&fall servo alarm
	I0.6Film-pull servo upper limit	I2.0Clamp carton cylinder extend	I3.2 Bag open axis servo alarm
Alarm	I0.7Film-pull servo lower limit	I2.1Seize film cylinder origin	I3.3 Film-pull servo alarm
Tag	I1.0Film-pull servo origin	I2.2Seize film cylinder extend	I3.4 Sealing detective signal
Tag	I1.1E-stop	I2.3Sealing cylinder origin	Output



- 1) Make sure that the machine is powered on.
- 2) Turn on the power switch and wait for the [HMI](#) to start
- 3) Enter the operation screen directly after booting.

"Automatic" interface can operate the machine to start, reset, view the output and other information;

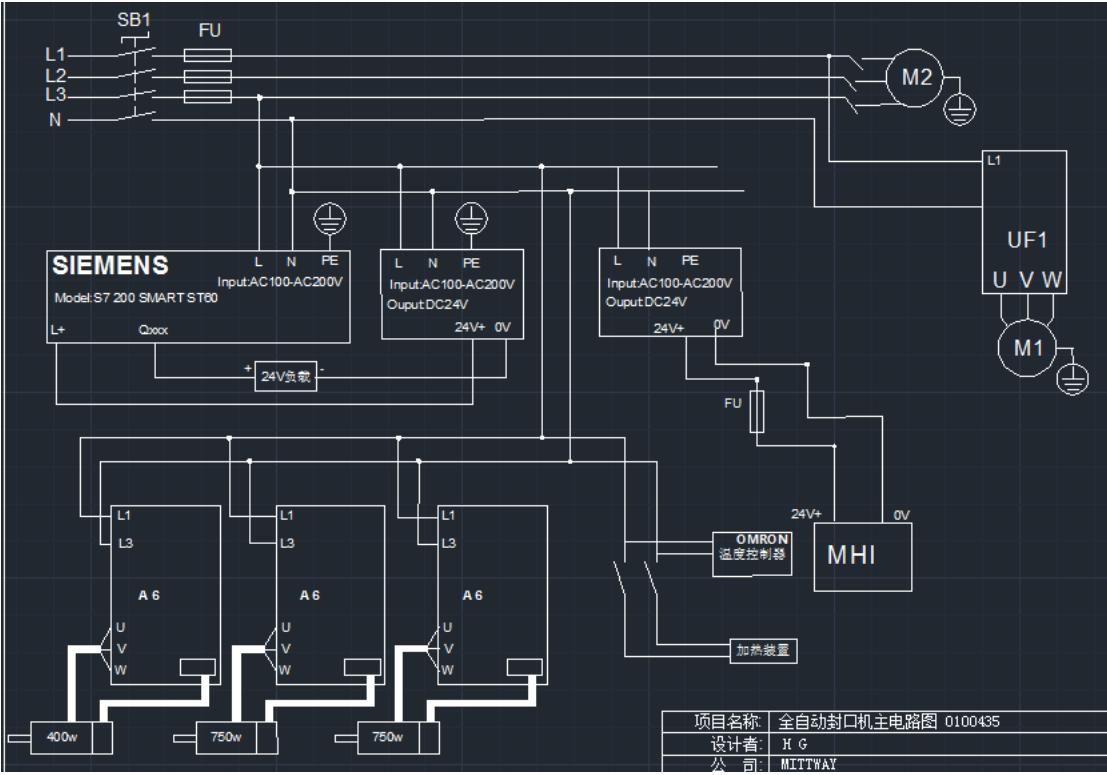
"Settings" interface to set each servo parameter and movement position;

"Manual" interface can control the operation of each servo manual and each cylinder;

"Status" interface can display various I / O status information;

"Alarm" interface can display alarm information under various abnormal conditions;

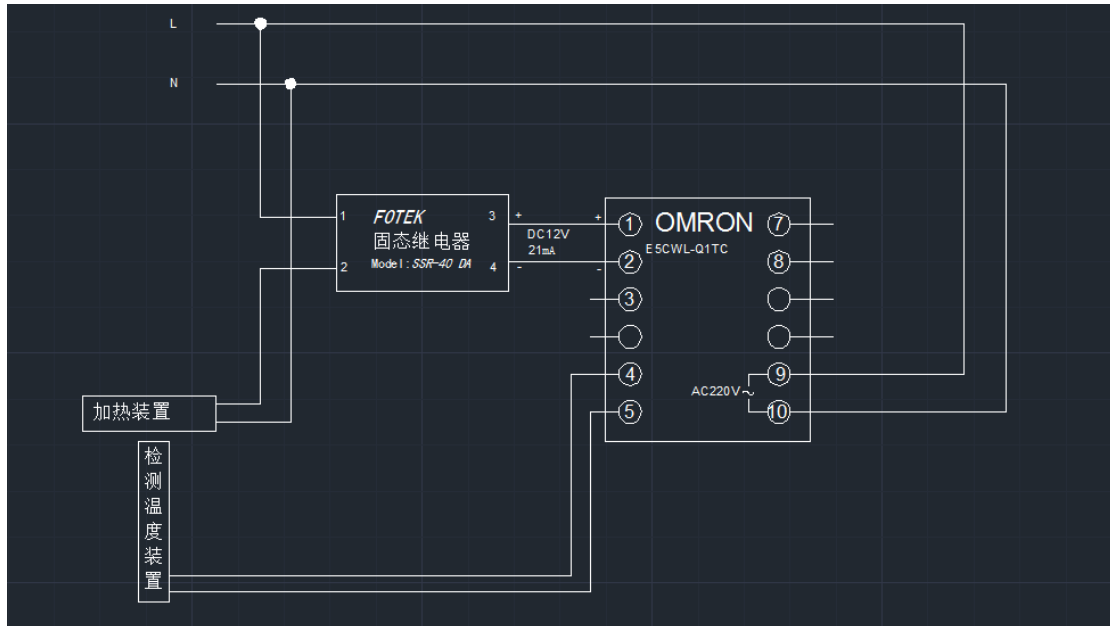
3.2 Electrical schematic diagram



Electrical schematic diagram



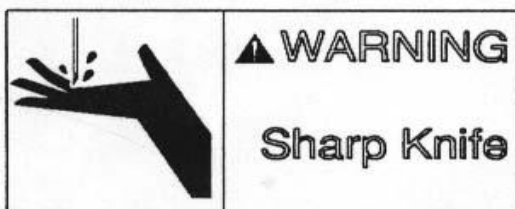
I/O



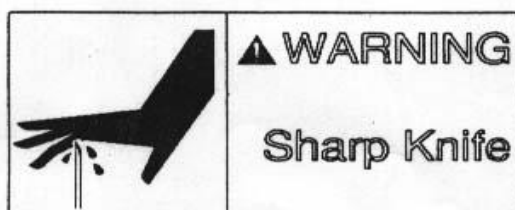
Heating temperature control principle wiring diagram

1. 4.Safety Precautions

2. Please pay attention to the safety labels on the machine, and pay attention to safety when using to avoid injury.
3. 1. Electrical box, junction box is affixed with "Electrical
4. "Warning signs", except operators and electrical maintenance
5. Personnel can open the operation and maintenance during operation or maintenance.
6. Other personnel are prohibited from opening.
7. 2. The drive part of the machine chain is affixed with a “driving danger warning sign” as shown in Figure 1-2. When the machine is running, please pay attention to the danger that it will be involved in clothes and hands. Please make sure that the machine is in a stopped state before maintenance service.
8. 3. The blade part is affixed with a "blade sharp warning sign" as shown in Figure 1-3. Please pay attention to the danger of cutting your hand when repairing or wearing the belt.



1 - 3



1 - 2

The user should read this manual carefully before using the machine, and should pay special attention to safety during use. Before preparing to turn on the machine, carefully check whether someone or someone's body parts are in contact with the moving parts of the machine. No professional training or non-professionals are allowed to repair the machine.

5. Troubleshooting and maintenance:

When there is a problem with the machine, first check if the following items are normal:

- a) Whether the power supply of the input control box INPUT is AC220V;
- b) whether all air switches NFB are tripped or damaged;
- c) Whether the PLC input and output lights are on, please refer to the touch screen I / O TABLE for comparison;

1. The motor does not rotate, please check the following steps:

- a) Check the inverter parameters according to the instructions;
- b) Whether the input voltage of the inverter (S310-210) is normal (AC220V);
- c) Make sure the air switch controlling the inverter is ON;
- d) The disc inverter has a frequency output. Check whether U, V, and W have voltage:

If there is voltage, then check whether the motor wire is loose and the wiring is not loose. Please change the motor; if not, change the inverter;

- e) Check if the PLC has output. Touch screen output screen

2. The servo motor does not rotate:

- a) The input power voltage is normal (AC220V);
- b) Whether the servo is overloaded. (x5.x6, x7)

c) Servo motor servo over limit position.

e) The air switch is switched to the ON position;

f) Check if the PLC has output. Touch screen output screen

3. The conveyor line does not turn:

a) Check whether the motor and transmission shaft are connected properly;

b) Check whether the drive shaft and the drum connecting belt are disconnected;

4. The cylinder does not work:

a) Check whether the gas supply is normal;

B) Check if the PLC has an output signal.

C) Check for looseness at the line connector

5, the seal is not suitable:

a) Check whether the power supply of the transformer is normally 220V input and 48V output.

b) Check whether the control circuit is faulty, whether the solid state relay and contactor are intact

C) Check whether the heating bar is damaged.

D) Whether the heating time setting is normal.