

QUALITY COMES FROM PROFESSION
INTEGRITY COMES FROM RESPONSIBILITY

PACKAGING MACHINE OPERATION INSTRUCTION

Table of contents

Packaging and installation operation.....	1
The Control parameter is set to be.....	2
Packaging machine structure.....	4
Use considerations.....	6
After-sales service and troubleshooting of the...9	
Instructions for use of intimachine computer board.....	10
Simple troubleshooting of the.....	14
Digital display packaging machine computer board instruction manual.....	15
After-sales service and troubleshooting of the...17	
Warranty card for.....	19

Installation and operation

Unpack inside:

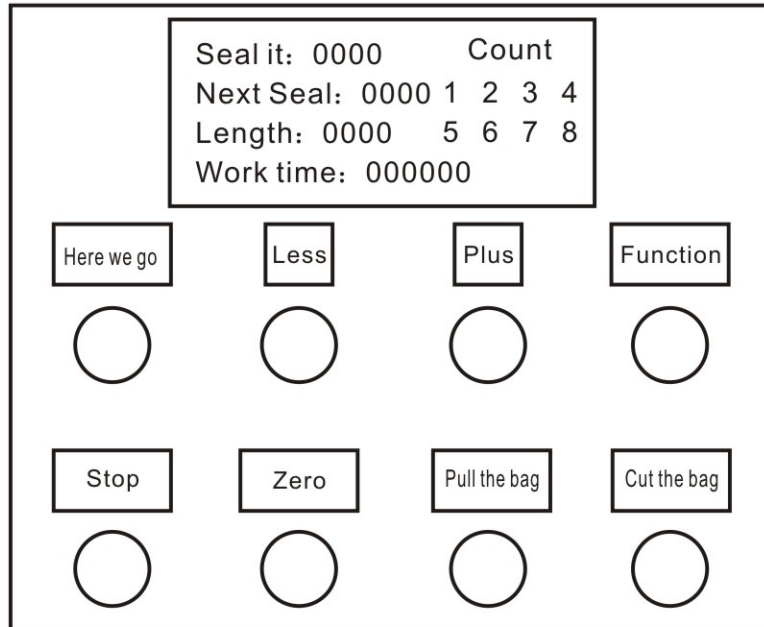
1. One packaging machine;
- 2, a set of rolling film fixed bracket (paste machine two support rod other one), support rod fixed screw;
- 3, rolling film positioning ring 3: white plastic rolling film fixing wheel two, a pressure film spring one;
4. One power line;
- 5, a instruction manual;
- 6, the powder particle machine has a data line (no division installed device with a wobbler, infrared sensor or a foot switch) ;
- 7, the paste packaging machine has a discharge pipe, direct pipe matching;

Installation and operation

Open the packing box, take out the fixing bracket and screws, fix the bracket on the right side of the machine (the paste machine bracket is on both sides), fix the packaging film on the white rotating wheel, the packaging film direction is lowered forward to the back of the bar (must pay attention to the direction);Cut the front end of the packaging film into an isosceles triangle shape, through the bag molding device three stainless steel block, open the handle to the left, (the handle is to control the opening and closing of the black sandwich film wheel), when the packaging film pulled over the black bag wheel, both sides close the rear handle to the right to clamp the packaging film. 1. The paste machine needs to install the air compressor trachea, and install the silicon nozzle of the discharge pipe to the feeding port.2. Powder and particle packaging machines need to be connected to the data line connected with the sub-installation machine.3. The liquid machine only needs to install the bracket and the packaging film.After the installation is completed, the power supply will set the sealing temperature and the length of the bag (the liquid machine needs to set the water time, the paste and the powder particle water time are 0000), when the machine warms up (the temperature reaches the set temperature length will flash), then cut the bag on the computer control board and pull the bag to push the button to seal the packaging film smoothly.After the protective cover is installed, the machine will press the button to work. In the process of work, we must pay attention to safety and do not let the child next to the machine.

Paste, liquid machine computer control board keys and parameters set

Buttons, displays, functions:



1. The power-on start display area displays each parameter setting and working process (12345678)。
2. After the temperature is set, the meter starts flashing. The work meter starts to flash.
3. Press the function key to turn the parameters back to the table below.

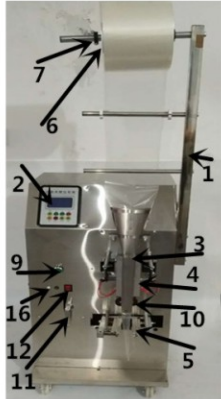
Paste, liquid machine computer control board keys and parameters set

Parameter table:

order number	Set the range	function	Ex-factory value
On the seal	0-300	Set the temperature of the upper seal	0120
Under the seal	0-300	Set the temperature of the lower seal	0120
length	0-999	Set the length of the bag	0100
delayed	0-99(100ms)	Waiting time after receipt of the signal	0001
On the proportion	0-99	Set the road heating proportion, large proportion of heating fast	0050
Under the proportion	0-99	Set the lower road heating ratio, large proportion of heating fast	0050
Pull the bag	0-999	Set the speed of the stepping motor	0500
Water time A	0-5000(10ms)	Set the time to pump water	0000
Since the whole	0-1	Set the alarm current	0000
vibration force	0-800	Set the force of the vibration	0001
colour code	0-1	Set use signal (0=length, 1= color scale)	0000
aerate	0-99(100ms)	Set the inflation time after vibration (reserved)	0000
Water delay	0-99(100ms)	Set the delay time when pumping is required	0003
Stop in the middle	0-999(10ms)	The delay time after the cylinder returns when the cylinder is pneumatic	0080
Water time B	0-5000(10ms)	Set the time to pump water	0001
Scaling polarity	0-1	Set the color mark for black and white signal selection	0000
flow path	0-1	Set the order of cutting 0 pull bag cutting, 1 cut bag cutting	0000
Electrical movement	0-1	0 use motor cut bag, 1 use cylinder cut bag	0000
pattern	0-2	0 packaging powder particle material, 1 packaging liquid double pump, 2 packaging powder particle + liquid double pump	0000
Knife time	0-999(10ms)	Cut the required action time in the middle and cut the pause time in the middle	0035
Pull bag delay	0-99(10ms)	Individual pull bag delay after electric power cutting bag exit	0000
Chinese and English conversion	0-1	0 Chinese 1 English	0000
Water pump speed	0-200	Set the water output of the water pump	1/200
Set the number of jobs	0-9999	Set the total number of times, stop after arrival, restart press reset key	9999
Cent alarm time	0-99	Set the alarm time for the motor delay of automatic operation, 3 times the manual time	1.0秒
Standard delay	0-999	Color label delay length	0000

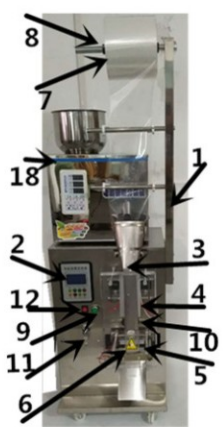
Packaging machine structure

Liquid machine



1. coil support frame, 2. computer control system, 3. bag molding, 4. upper sealing connector, 5. lower seal heater, 6. protection cover, 7. coil positioning wheel, 8. coil positioning ring, 9. power switch, 10. pull bag wheel, 11. pull bag wheel controller, 12. motor reverse switch, 13. leakage protection switch, input power, output power, 16. cleaning switch

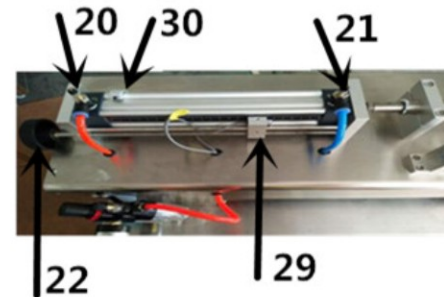
Packaging machine



2. 1. coil support frame, 2. computer control system, 3. bag molding, 4. upper seal connector, 5. lower seal heater, protective cover, 7. coil positioning wheel, 8. coil positioning ring, power switch, 10. bag wheel, 11. bag wheel controller, 12. motor reverse switch, 13. data line socket 14 input power, 15. output power, photoelectric port, 17 fuse, 18 swing device socket, 19 minutes installed

Packaging machine structure

Paste Machine



3. 1 Coiling support frame, 2. computer control system, 3. cleaning switch, 4. upper sealing connector, 5. lower seal heater, 6. protective cover, 7. coil positioning wheel, coil positioning ring, power switch, 10. bag wheel, 11. controller, 12. motor reverse switch, leakage protection switch, output power, pressure regulating valve, 17. Pressure gauge, 18 air inlet, 19 bag molding, 20 suction speed adjustment, 21 filling speed adjustment, 22 capacity adjustment, 23 stop valve, 24 discharge tube, 26 rotary valve swing arm, 27 hopper, 28 oil and water separator, 29 capacity control magnetic switch, 30 positioning magnetic switch

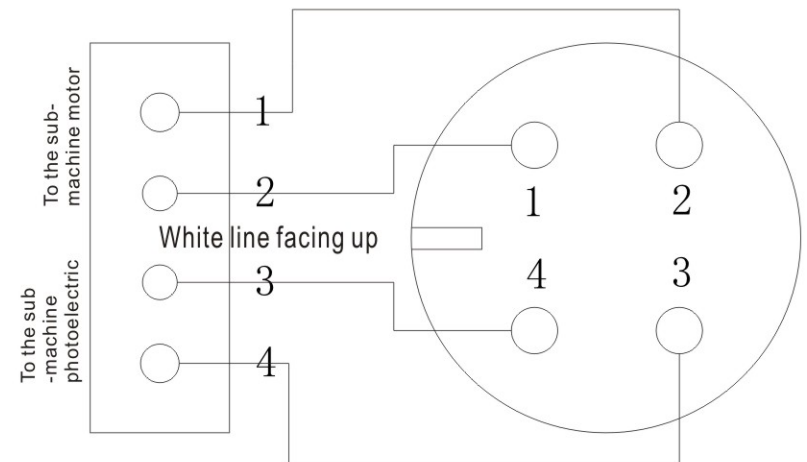
ge considerations

4. Notes for use: Please use the shell insulation, otherwise it will cause the electrical interference signal from the thermocouple into the circuit board, which can increase the temperature measurement error when slight, and can directly damage the circuit components when serious. The output rated working current of the cut bag of 3A voltage DC15-30V, the output rated current of 1A voltage DC6-24V, the AC heating current should be limited to 2A continuous, intermittent 3A, continuous 3A shall not exceed 5 minutes interval at least 30 seconds. Please install the protection element by yourself, not within the scope of the circuit board. The proportional parameter in this machine may be automatically adjusted when the temperature is changed and the first time of use. Please hold down the function key for more than 10 seconds after the temperature stabilizes, enter the parameter setting, press the length reduction key to save and exit the parameter setting. In order to prevent permanent damage caused by load short circuit, please use the insurance by using "quick melting" insurance for heating. Recommended specifications: up and down heating each 2A "quick melting", cut bag and pull bag 10A conventional insurance needs to be string into the transformer to the circuit board line five, fault code Upper temperature display above 700- -road thermocouple fault, The actual temperature is very high showing only room temperature-thermocouple or circuit board failure E02 Bag timeout-Step driver and motor, color scale sensor or circuit board failure E03 Cut bag timeout-Cut bag motor, cut bag hall or circuit board failure The E05 bag cutting module is too high and can not be used until cooling Lower temperature display above 700-down thermocouple fault, The new modular circuit board sets the

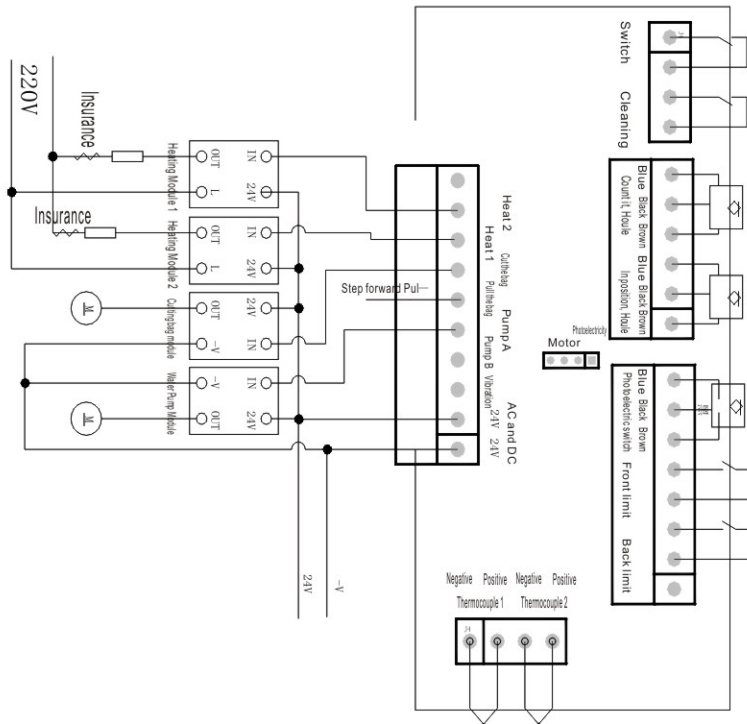
ge considerations

input and output signal indication, encounter a problem can first observe the signal situation, The input part, such as the light on the Hall is on but the corresponding light on the circuit board is not on, so you can use the black and blue line of the short circuit circuit board to see the light on the circuit board. If the light is on, the wire is loose, and if it is not bright, the circuit board is damaged. Again such as the output part of the heating 2, circuit board output 2 parts of the two lights must be bright and out at the same time, otherwise the circuit board fault, if the circuit board is normal but the heating module of the input light, then must be loose module or broken, if the module input and the circuit board of two lights can light out at the same time, but the module output part of the light is always not bright, so if the temperature has been rising, module must be broken, the temperature is not broken is broken or plug loose line. Conversely, if the output light of the module is on and the input is on or not, the heating module is broken.

Communication with the sub-loader



ge considerations



New module circuit board wiring diagram

Maintenance Guarantee

Thank you for purchasing our products. Our company products free warranty, lifetime maintenance (warranty outside and vulnerable parts at your own expense), after you buy the products, the company registration, to ensure that you can get better after-sales service.

1. If the product you buy fails or will not be used, contact the seller, or contact the dealer at the company's nearest place.

2. Please show the warranty card and the warranty card and the purchase voucher. If the fault occurs during the warranty period, you can enjoy the free after-sales warranty service stipulated by the company with the warranty card and the purchase voucher.

3. The warranty period to the contract or purchase date to enjoy 12 months of free warranty service.

4. Free after-sales warranty is not available for the following conditions:

1. The warranty period exceeds 12 months;
2. Damage caused by the failure of using the products and the regular maintenance of the products;
3. The product model of the warranty card is inconsistent with the physical object;
4. Change the warranty certificate without authorization;
5. Those who dismantle the machine or change the equipment without authorization shall be deemed to automatically give up the free after-sales service.

6. irresistible (such as natural disasters, fire or not suitable for machine voltage, etc.) caused by damage.

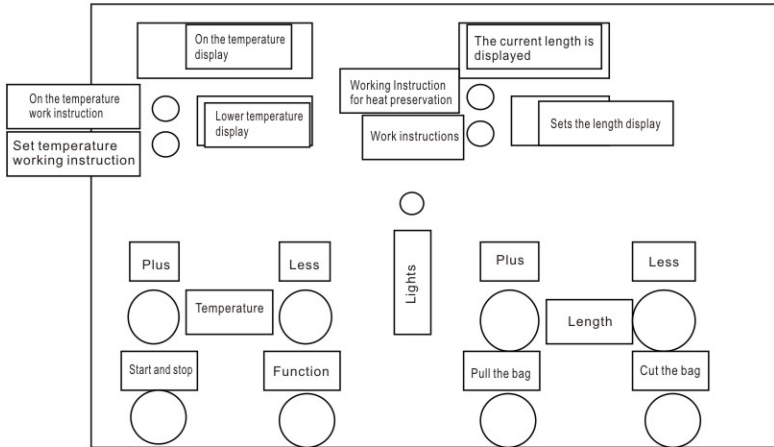
7. The damage caused by transportation and the customer has signed for it (not signed for the company negotiated logistics processing).

maintenance and repair cost

1. During the free after-sale warranty period, if the products enjoying the free warranty are faulty and damaged, the company shall bear the accessories and hourly costs (except for vulnerable parts).

2. If it is not within the free warranty or beyond the warranty period, the customer shall pay the maintenance and parts. If the product needs to be returned to the factory for maintenance, the transportation costs shall be borne by the customer himself, (including warranty or no warranty).

Inner membrane machine computer board instruction manual



Interface function:

1. Change the flicker setting temperature. Press the function key and flash in the lower left window. Press the add and subtract key to change the set temperature of the lower road.

2, long press the function key between 2-3 seconds and open, trigger automatic work once.

3, Length add and subtract key directly set the length.

4. Long press and hold down the function key for more than .5 seconds to enter the parameter setting:

At this time, jump to the parameter content adjustment, press the temperature plus the key to adjust the parameter content, press the function key parameter number + 1, press the length of the key to save and exit the parameter setting, through the parameter can make the temperature accuracy to 1 degree, in different regions, please change to the most appropriate parameter. Improper parameter setting can cause work improperly.

Inner membrane machine computer board instruction manual

Parameter table:

Serial number	Set the range	function	Ex-factory value
003	0-99(X100ms)	Time of vibration after receiving the signal	003
004	0-99	Set the road heating proportion, large proportion of heating fast	050
005	0-99	Set the lower circuit heating ratio, large proportion and heating fast	050
006	0-1	0 Put the material first and then pull the belt, 1 first pull the bag after putting the material	000
007			000
008			000
009	0-20	Set the force of the vibration	001
010	0-1	Set use signal (0=length, 1= color scale)	0
011			60
012	0-999(*10ms)	Pause time from the cut bag to the middle position (delay time after cylinder exit when pneumatic)	30
013	0-999(X10ms)	The walking time from cutting the bag to the middle position should be consistent with the actual time (the middle stop time in the cylinder)	35
014	0-999	Set the speed of the stepping motor	300
015	0-1	0 color label black signal, 1 color label white signal	000
016	0-1	0 motor cut bag, 1 cylinder cut bag	000
017	0-999(X1ms)	Acceleration time of the stepping motor	400
018	0-1	0 Step motor bag (remove the bag module) 1 DC motor bag	0
019	0-1	0 No action 1 restore the factory value (clear when you exit the saved parameter)	0
020	0-1	0 Ordinary heating mode.1. PID heating mode	0
021	0-99	Cent alarm time	10
022	0-2	work pattern	0
023	0-999	Water pump time	0
024	0-999	Water pump speed	1
025	0-999	Inflatable time	0
026	0-999	Cursor time delay	1
027	0-999	Low temperature difference control	
028	0-999	High temperature difference control	
029	0-99	Photoelectric delay	
030	0-99	Independent cutting knife	
031	0-30000	Set the number of jobs	
032	0-30000	Record the number of jobs	

9. Use considerations:

Please use the shell insulation, otherwise it will cause the electrical interference signal from the thermocouple into the circuit board, which can increase the temperature measurement error when slight, and can directly damage the circuit components when serious. The output rated working current of the cut bag of 3A voltage DC15-30V, the output rated current of 1A voltage DC6-24V, the AC heating current should be limited to continuous 5A, intermittent 10A, continuous 10A shall not exceed 5 minutes interval at least 30 seconds. Please install the protection element by yourself, not within the scope of the circuit board.

The proportional parameter in this machine may be automatically adjusted when the temperature is changed and the first time of use. Please hold down the function key for more than 10 seconds after the temperature stabilizes, enter the parameter setting, press the length reduction key to save and exit the parameter setting.

In order to prevent permanent damage caused by load short circuit, please access the insurance in each load room, and use "quick melting" insurance for heating

Recommended specifications: up and down heating each 10A "quick melting", cut bag and pull bag 3A conventional insurance needs to string into the transformer to the circuit board between the line using 110V120W heating tube needs to be in each heating pipe

8. Fault code

Upper temperature display above 700- road thermocouple fault,

The actual temperature is very high showing only room temperature-thermocouple or circuit board failure

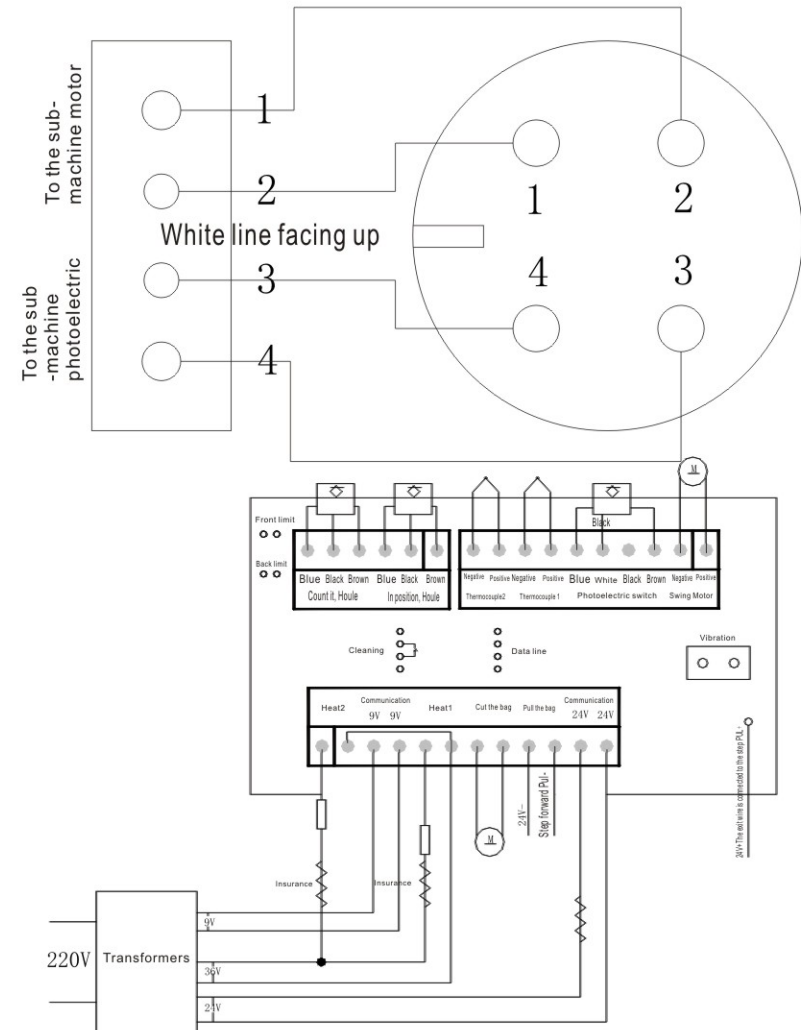
E02 Bag timeout-Step driver and motor, color scale sensor or circuit board failure

E03 Cut bag timeout-Cut bag motor, cut bag hall or circuit board failure

The E05 bag cutting module is too high and can not be used until cooling

Lower temperature display above 700-down thermocouple fault,

Communication with the sub-loader



Simple troubleshooting

Heating part of the failure

1, the temperature display is above 700, the heating indicator light is not on, the temperature can not be added. Cause of failure: thermocouple break, thermocouple and circuit board socket contact is poor.

2. After the temperature exceeds the set temperature, the heating indicator light is not on. Cause: Si C breakdown short circuit. You need to replace the sibr and check whether the heating pipe and heating pipe lines are short circuit or touched.

3. The heating indicator light is always on, but the actual temperature is always room temperature. Cause of failure: CR open circuit. You need to replace the sibr and check whether the heating pipe and heating pipe lines are short circuit or touched.

4, The heating indicator is always on but the actual temperature higher than room temperature is always below the setting temperature. Cause of failure: appropriately increased proportion or low voltage.

Cut-off bag partial fault:

1. E03 right power lamp bright cut bag motionless. Cause of failure: The circuit board is broken.

2. E03 The right power lamp is not on. Cause of failure: the 24V transformer has no power or a fuse break.

3. E03 Right power light on left power light on occasionally. Cause of failure: motor damaged or motor wire broken, plug poor contact.

4. E03 cut bag motor has action. Cause of failure: in place to detect broken Hall, broken line, or incorrect installation position, circuit board damage.

5. High temperature of E05 cut bag chip occurs during the work. Cause of failure: motor aging, cutting bag debugging pressure is too large.

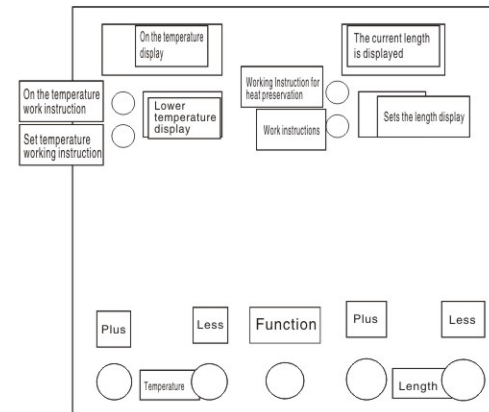
Pull ouch partial fault:

1. Stepper motor has power. Failure reason: damaged drive, broken signal line, bad plug contact, broken circuit board

2. The E 02 motor is running. Cause of failure: Count Hall damage, wire break, poor plug contact. The color scale switch is damaged, the wire is broken and the plug is not touched.

3. The drive has no power supply. The 24V AC has a power supply. Cause of failure: The circuit board is broken.

Digital Display Packing Machine Computer Board instruction



Interface function:

1, power on the upper left window number flashing, the upper left window shows the road set temperature, press the temperature plus and minus button can change the flashing setting temperature, press the function key, the lower left window number flashing, press the plus and subtract button can change the road set temperature, press the function key, the upper left and lower left window respectively on the road and the current temperature.

2, long press the function key between 2-3 seconds and open, trigger automatic work once

3, Length add and subtract key directly set the length.

4, long hold the function key more than 5 seconds, into the parameter setting: then jump to the parameter content adjustment, press the temperature button to adjust the parameter content, press the function key parameter number + 1, set the length button to save and exit the parameter setting, through the parameters can make the temperature accuracy of 1 degrees, in different areas please change to the most appropriate parameters. Improper parameter setting can cause work improperly.

Digital Display Packing Machine Computer Board instruction

Parameter table:

Serial number	Set the range	function	Ex-factory value
003	0-99 (X100ms)	Time of vibration after receiving the signal	010
004	0-99	Set the road heating proportion, large proportion of heating fast	050
005	0-99	Set the lower circuit heating ratio, large proportion and heating fast	050
006	0-1	0. Put the material first and then pull the belt, 1, pull the bag first and then put the material	000
007	0-1	0 with granular material packaging, 1 water pump packaging	000
008	0-1	0 in place detection in the side, 1 in place detection in the middle	000
009	0-20	Set the force of the vibration	030
010	0-1	Set use signal (0=length, 1= color scale)	0
011	0-99 (°C)	Set the maximum service temperature for the cut bag element	60
012	0-999 (*10ms)	Pause time from the cut bag to the middle position (delay time after cylinder exit when pneumatic)	30
013	0-999 (X10ms)	The walking time from cutting the bag to the middle position should be consistent with the actual time (the middle stop time in the cylinder)	35
014	0-999	Set the speed of the stepping motor	300
015	0-1	0 color label black signal, 1 color label white signal	000
016	0-1	0 motor cut bag, 1 cylinder cut bag	000
017	0-999 (X1ms)	Acceleration time of the stepping motor	400
018	0-1	0 Step motor bag (remove the bag module) 1 DC motor bag	0
019	0-1	0 No action 1 restore the factory value (clear when you exit the saved parameter)	0
020	0-1	0 Ordinary heating mode. 1. PID heating mode	0

5. Notes for use:

Please use the shell insulation, otherwise it will cause the electrical interference signal from the thermocouple into the circuit board, which can increase the temperature measurement error when slight, and can directly damage the circuit components when serious. The output rated working current of the cut bag is 3A voltage DC15-30V, the output rated current is 1A voltage DC6-24V, the AC heating current should be limited to continuous 5A, intermittent 10A, continuous 10A shall not exceed 5 minutes interval at least 30 seconds. Please install the protection element by yourself, not within the scope of the circuit board.

After-sales service and troubleshooting

4. Use considerations:

The thermocouple should use shell insulation, cut the bag motor should use DC motor below DC24V30W, the bag motor should use DC motor below DC24V15W, the AC heating current should be limited to 2A continuous, intermittent 6A, continuous 6A shall not exceed 5 minutes interval at least 30 seconds.

The proportional parameter in this machine may be automatically adjusted when the temperature is changed and used for the first time. Please hold down the function key for more than 3 seconds after the temperature stabilizes, enter the parameter setting, complete the automatic saving and exit the parameter setting.

5. Fault code

E01 push cylinder forward timeout, E02 pull bag timeout, E03 push cylinder back timeout, E04 bag cutting motor action timeout, E05 bag cutting motor current is too large.

E01: (1) check whether the power supply is connected; (2) check whether the perfusion regulating valve is too tightly closed; (3) check whether the stop valve is active and open; (4) check whether there is a material blocking the outlet; (5) whether the push cylinder is stuck; (6) whether the solenoid valve is moving; (7) whether the magnetic switch of capacity control is induced.

E02: (1) check whether the trolley bag is the color mark; (2) check whether the trolley bag motor is rotating; (3) check whether the drive is well connected or the driver is broken.

E03: (1) Check whether the suction regulating valve is closed too tightly. (2) whether the pull magnetic switch is bright.

E04: (1) whether the hall switch position is correct, whether the light is bright; (2) whether the carbon sand is stuck; (3) whether the computer board relay is working.

After-sales service and troubleshooting

Vii. Maintenance guarantee

Thank you for purchasing our products. Our company products free warranty, lifetime maintenance (warranty outside and vulnerable parts at their own expense), after you buy the products, the company registration, to ensure that you can get better after-sales service.

1. If the product you buy fails or will not be used, contact the seller, or contact the dealer at the company's nearest place.

2. For the warranty period, please show the warranty card and the purchase voucher. If the fault occurs in normal use during the warranty period, you can enjoy the free after-sales warranty service stipulated by the company with the warranty card and the purchase voucher.

3. The warranty period begins with the contract or the purchase date to enjoy twelve months of free warranty service.

4. Free after-sales warranty is not available for the following conditions:

1. The warranty period exceeds 12 months;

2. Damage caused by the failure of the products and the regular maintenance of the products;

3. The product model of the warranty card is inconsistent with the physical object;

4. Change the warranty certificate without authorization;

5. Those who dismantle the machine or change the equipment without authorization shall be deemed to automatically give up the free after-sales service.

6. irresistible (such as natural disasters, fire or not suitable for machine voltage, etc.) caused by damage.

7. The damage caused by transportation and the customer has signed for it (not signed for the company negotiated logistics processing).

Viii. Maintenance expenses

1. During the free after-sale warranty period, if the products enjoying the free warranty are faulty or damaged, the company shall bear the accessories and hourly costs (except for vulnerable parts).

2. If it is not within the scope of free warranty or beyond the warranty period, the customer shall pay the maintenance and parts expenses.

3. If the product needs to be returned to the factory for maintenance, the transportation costs shall be borne by the customer himself, (including warranty or no warranty).

Warranty card

warranty card

name of user:

contact number:

customer address:

marketing unit:

contact number:

Sales Address:

Machine model:

identification number:

Seal of the sales unit (signature)

Date:

Warranty card

Serial number	Date of submission for repair	Failure phenomenon	Date of repair	Notes

Maintenance Records:

Warranty card

name of user:

contact number:

customer address:

marketing unit:

contact number:

Sales Address:

Machine model:

identification number:

Seal of the sales unit (signature)

Date:

Serial number	Date of submission for repair	Failure phenomenon	Date of repair	Notes