GPC-50D Automatic Cover-folding and Sealing Machine

Operation and Maintenance Manual

※ Before using the machine, please read the manual carefully

※ We reserve right to change technologies without prior notice

Preface

Thank you for purchasing the carton automatic sealing machine of our company.

The manual mainly describes its basic structure, use method and operation precautions to facilitate the safe and correct use of the machine and improves the service life of the machine. Please read the manual carefully before using the machine and confirm the manual is delivered to the final user. Please confirm that the manual is delivered to the final user, and the contents in the manual will be changed due to technical update without prior notice

GPD series sealing machine is a machine used to seal various cartons using OPP tape as the main material. The machine is characterized by its simple structure, convenient operation and easy maintenance, and is widely applied in various industries, achieving the ideal effects of beauty and efficiency.

Safety Precautions

I. Operator must read the instructions carefully before operating the machine;

II. The operator shall not place the body parts at the running location of the machine when operating the machine;

III. The maintenance personnel must read the instructions carefully before conducting repair and maintenance;

IV. Please turn off the power source, air source during the handling of tapes and normal maintenance or repair;

V. Untrained personnel shall not operate the machine at will.

Contents

1. Features:

The machine is a product of series automatic sealing machines with cover-folding function, stand-alone operation, economic and efficient, and is an ideal sealing equipment. The functional features are as follows:

Sealing width: 150mm~500mm

Sealing height: 150mm~500mm

Sealing length: 200mm~600mm

Sealing speed: 18m/min

Applicable power source: 220V/380V 50Hz

Applicable power: 400W

Pneumatic supply: 6kg/cm^2

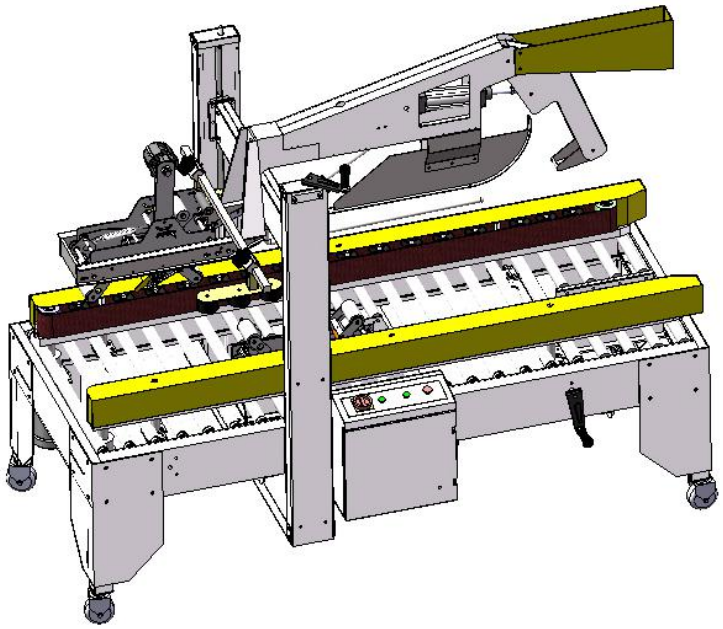
Applicable tape: W48mm, 60mm, 72mm

Overall dimension: L1770 mm ×W850 mm ×H1520 mm

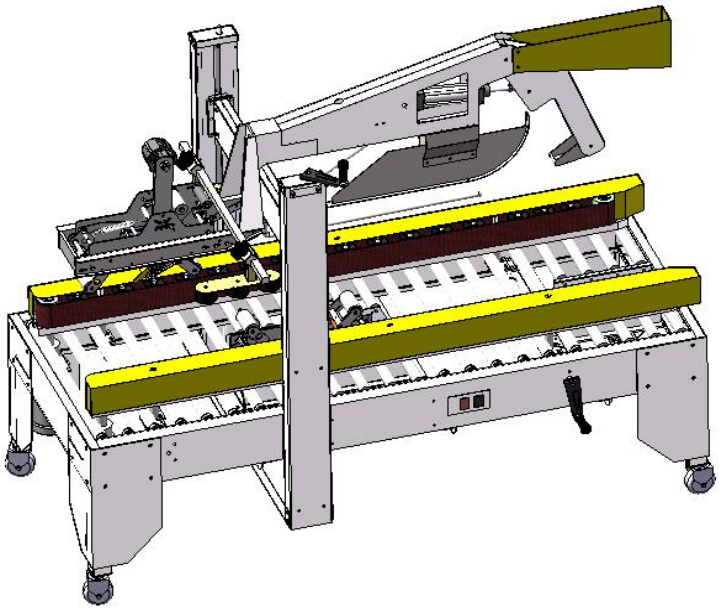
Weight of machine: 250kg

2 Basic structure:

2.1 Outline drawing (Figure 1)



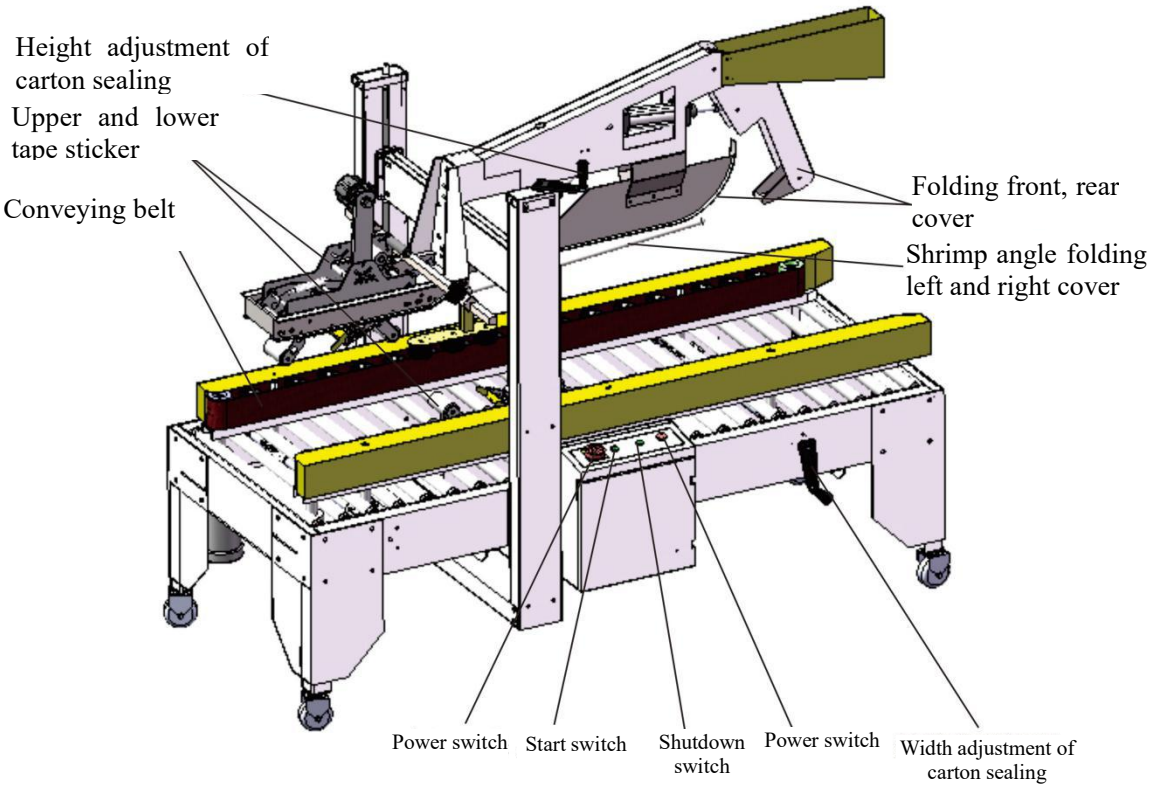
Non-standard type (GPC-50D, with electric box)

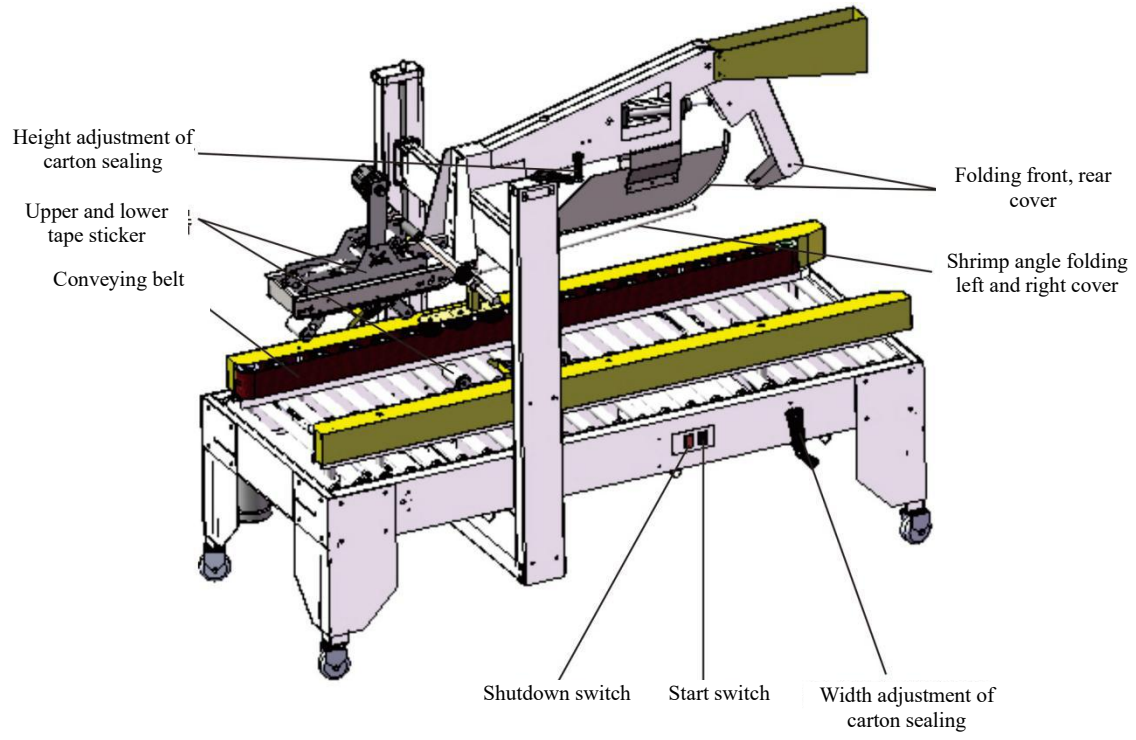


Standard type (GPC-50D, economic, without electric box)

Figure 1

2.2 Introduction to the main structure (Figure 2)





(Economic)

Figure 2

3 Description of Adjusted Parts

3.1 Height adjustment of machine stand

Loosen the screw b31, the stand bar slides upper and lower, and the height of the machine stand can be adjusted. (Figure 3)

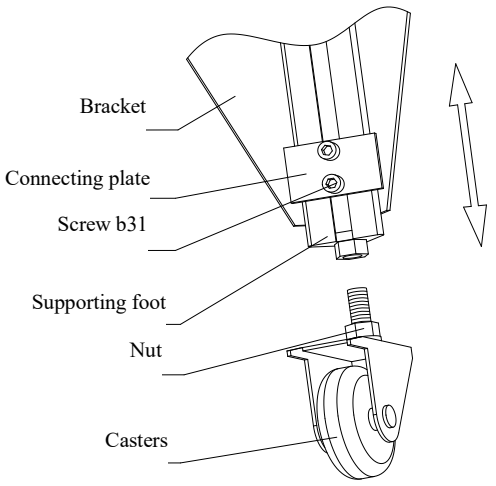


图3

3.2 Sealing width adjustment

The sealing width can be adjusted by rotating the crank handle, rotating the crank clock-wise (side looking from the operation side) to narrow, and rotating anticlockwise to widen. (Figure 4)

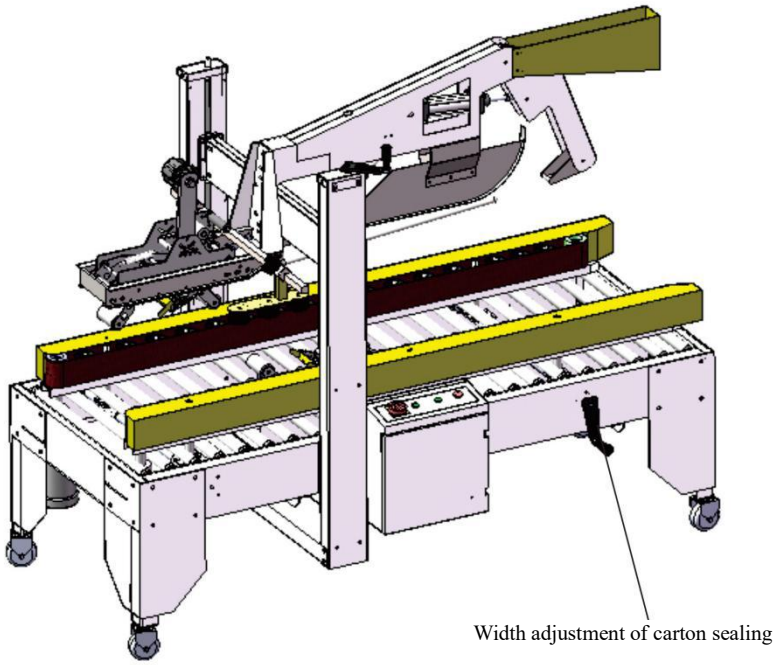


Figure 4

3.3 Sealing height adjustment

The sealing width can be adjusted by rotating the crank handle, rotating the crank clock-wise (looking down) to heighten and rotating anticlockwise to lower. (Figure 5)

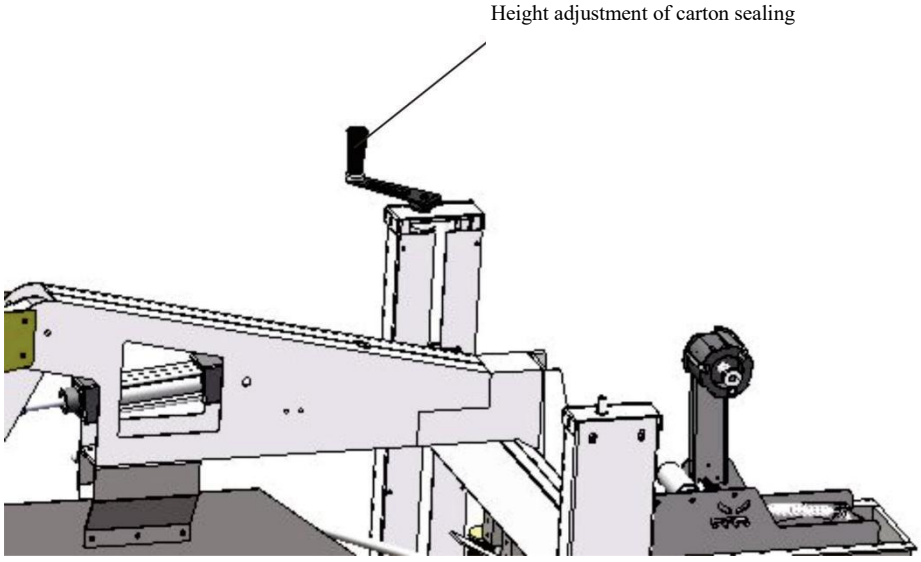


Figure 5

3.4 Lateral pinch roller adjustment (Figure 6)

Loosen the handle, the lateral pinch roller can be pushed by hand to move to the left and to the right.

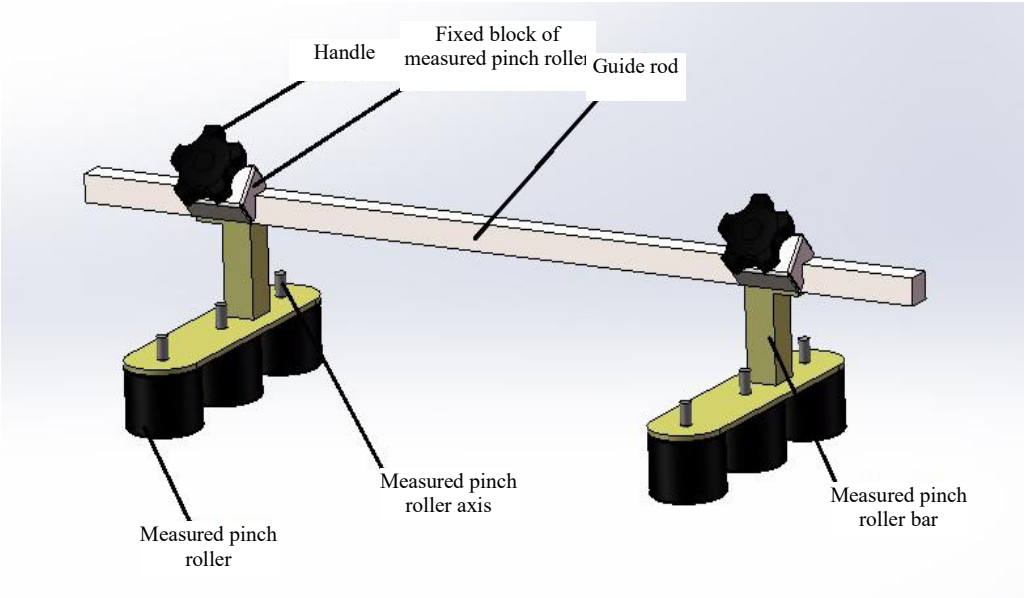


Figure 6

3.5 Location adjustment of shrimp angle pincher (Figure 7)

Loosen the screws, and rotate the shrimp angle pincher to a proper location

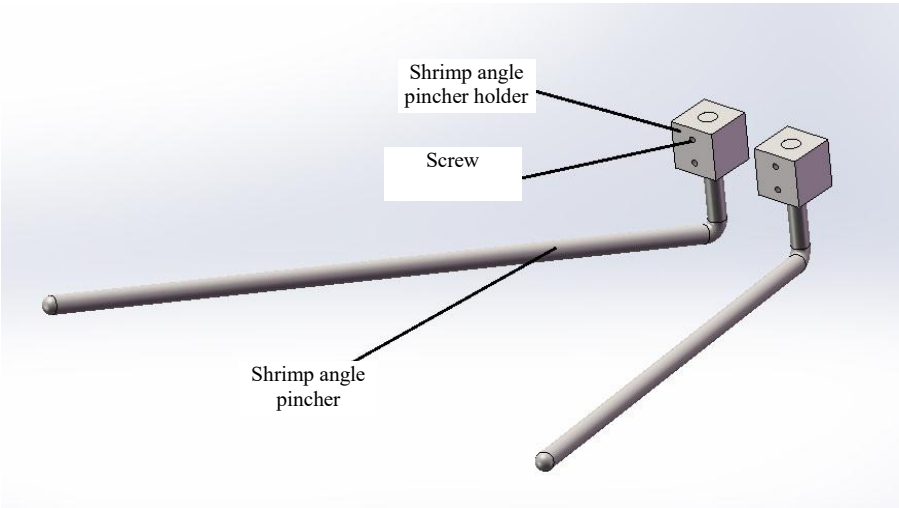


Figure 7

3.6 Tape installation and adjustment (Figure 8)

1. Firstly, put the new OPP tape coil onto the central spindle, as shown in the figure; secondly, pull out the tape to bypass PE wheel and then bypass the one-way wheel along the line; thirdly, bypass the small knurl wheel, finally pass the tape through the black polyformaldehyde inner sleeve and go out, as shown in the figure below. During the whole process, attention shall be paid to that the adhesive face of the tape must be outward.

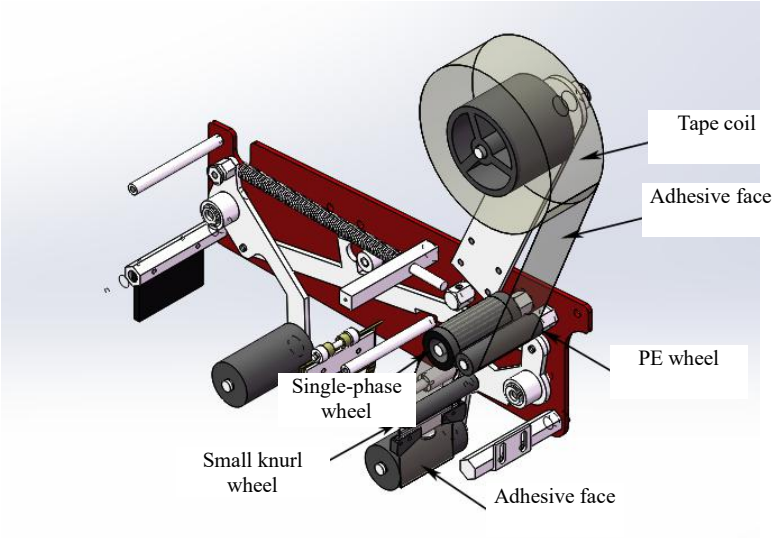


Figure 8

3.7 Tape threading diagram, as shown in Figure 9:

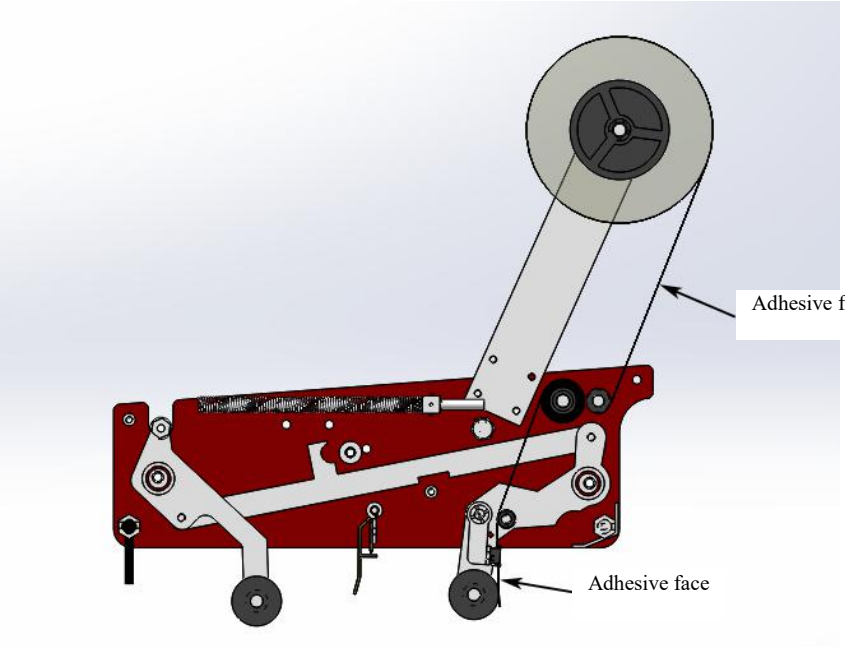


Figure 9

3.8 Tape location adjustment, as shown in Figure 10:

If the tape is not on the center line of the carton, please adjust referring to the figure below: Loosen M18 nut and adjust the tape holder central spindle, thus to adjust the tape location.

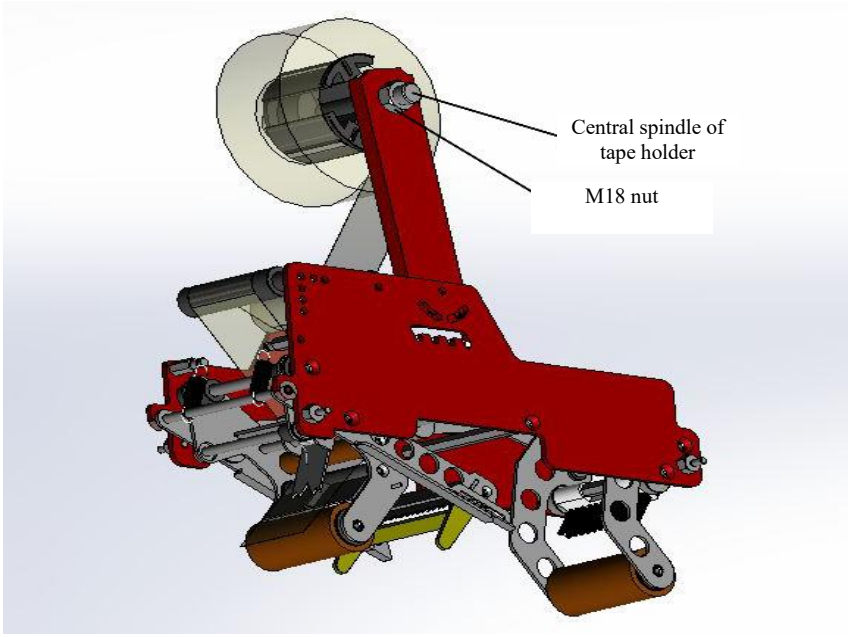


Figure 10

3.9 Tape tension adjustment, as shown in Figure 11:

Adjust the front and rear nut locations of the main tension spring screw as shown in the figure, and change the elastic force of the swing rod spring to control the size of tape tension.

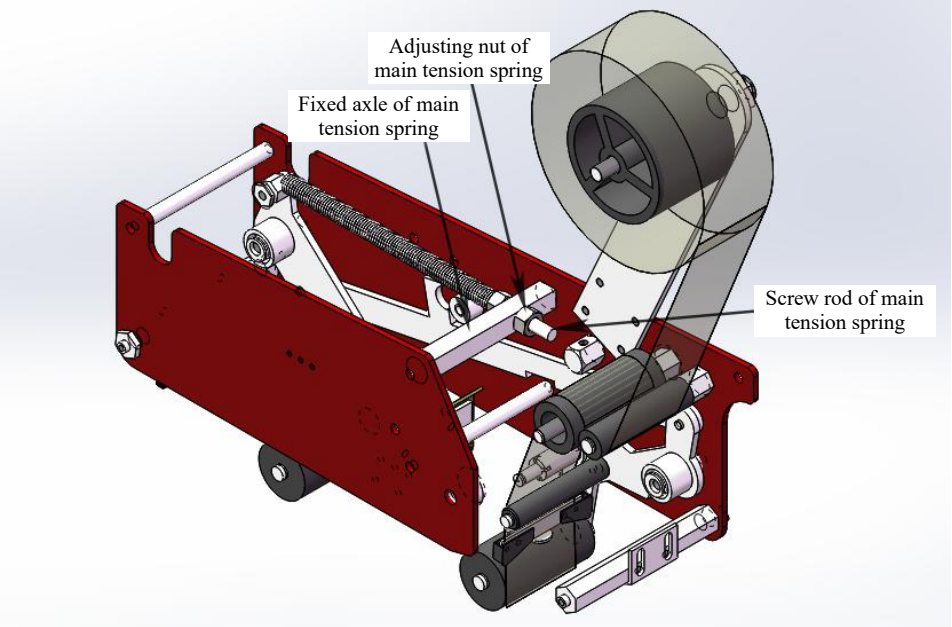


Figure 11

4. Operation and Use Instructions

4.1 Switch in air tube, and feed air

4.2 Adjust air pressure

4.3 Inspect the oil-water separator for water, and drain off the water; Inspect to see whether the oil volume is enough, if not, add some more

4.4 Adjust the sealing height and width

4.5 Adjust the location of lateral pinch roller

4.6 Adjust the shrimp angle pincher to proper location

4.7 Connect the power source, switch on the power switch and press the Start button, the machine starts running (for economical type,

directly press "ON" button after connecting the power source).

4.8 Fold the lower cover of the carton manually, after packing, fold the front and rear covers inwards slightly with a certain angle (as shown in Figure 12), after folding, feed the carton into the cover folding machine, the carton is conveyed to complete sealing with belt tightening, (as shown in Figure 13), and then subject to the next operation.

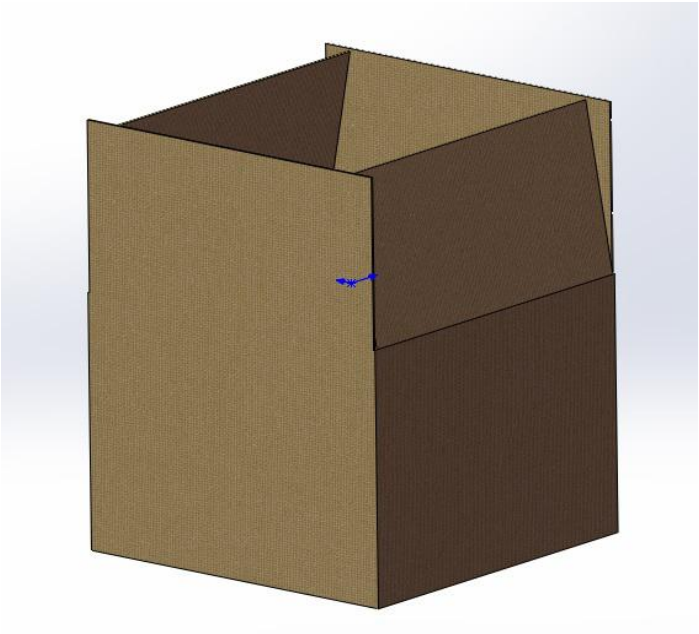


Figure 12

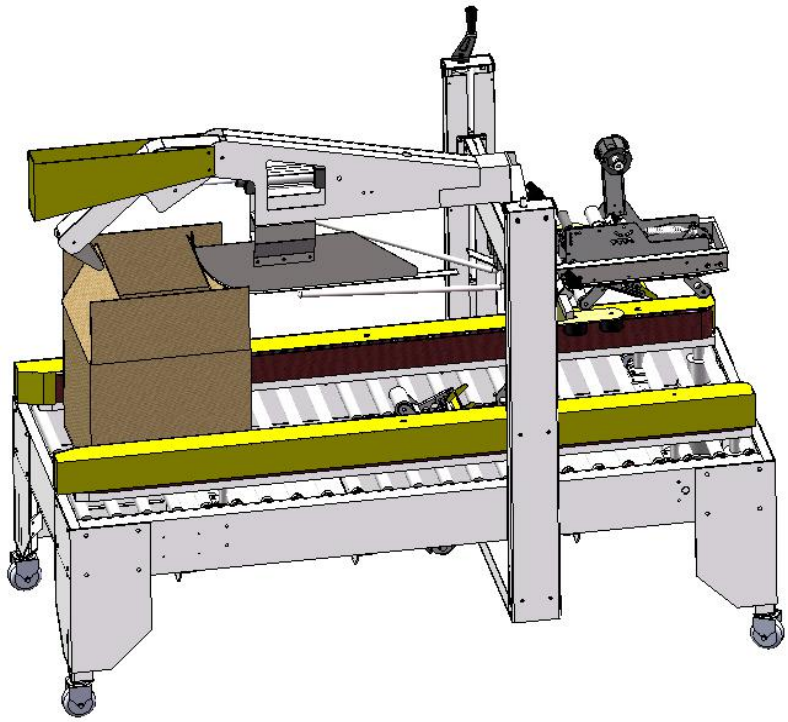


Figure 13

4.9 Cover folding sequence: front and rear cover folding pneumatically, then left and right cover folding with shrimp angle pincher.

4.10 Twist the power switch to OFF to disconnect the power source and stop machine running (for economical type, directly press "OFF" to stop machine running).

5 Repair and Maintenance

5.1 Before maintenance, repairing and adjustment, turn off the power supply and air supply of the machine.

5.2 Check whether there is enough oil mass in oil-water separator and timely fill it with special oil (turbine oil) of air pressure. Be sure not use other substituting oil.

5.3 Inspect the water-filtering cup of oil-water separator and if there is too much water, release it timely

5.4 Frequently wipe the shaft of air cylinder to prevent dust penetrating into piston for a long time, leading to air leakage.

5.5 If there is a need to disassemble the parts of air pressure pipelines for maintenance, check whether there is any pipe-bending phenomenon occurred in gas pipe, if any, make it straight immediately for fear of airflow blocked

5.6 Add machine oil once every three months for the screw rod

5.7 Add machine oil once every three months for the chain

5.8 Keep the machine clean and prevent it from damp to extent the service life of machine

5.9 Before repairing and adjustment, turn off the power supply and air supply of the machine.

5.10 Clean and lubricate the blade before usage

5.11 It is normal that the adjustable belt may become a little tight after being used for a while.

6. Limitations on Carton

6.1 Cartons with plastic film coating cannot use this sealing machine.

6.2 The carton must be dry (wet board-carton box cannot be sealed).

6.3 The carton cannot have any dust or waste.

6.4 Deformed carton cannot use this machine (as burrs are likely to hurt people and cause some faults to the sealing machine).

6.5 Tapes with inconsistent width and thickness cannot be used.

7. Exploded View

7.1 General exploded view

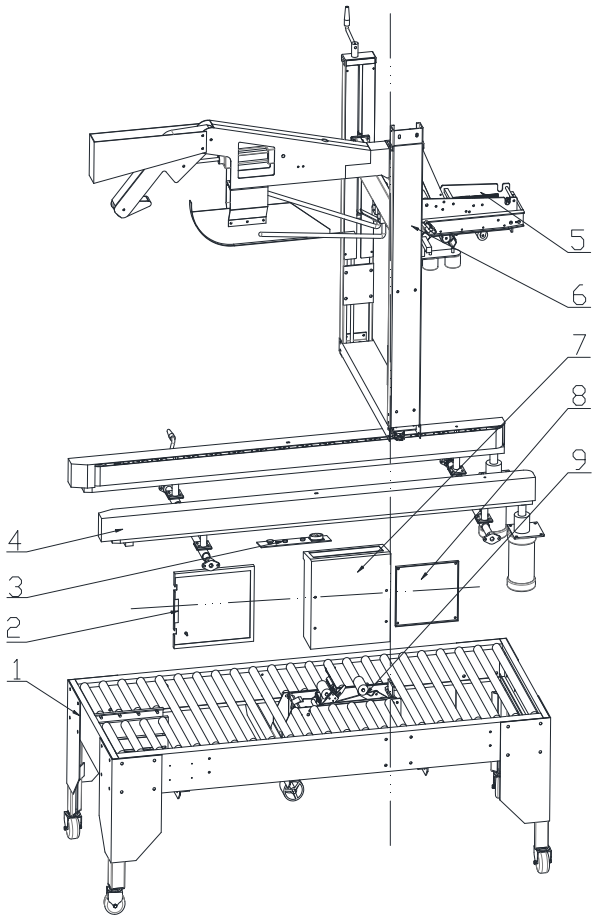


Figure 14

Parts list:

S/N	Name	S/N	Name
1	Main frame	6	Adjusting mechanism
2	Electric box door	7	Electric box body
3	Control panel	8	Switch panel
4	Belt conveying mechanism	9	Lower mandrel
5	Upper mandrel		

7.2 Main frame exploded view

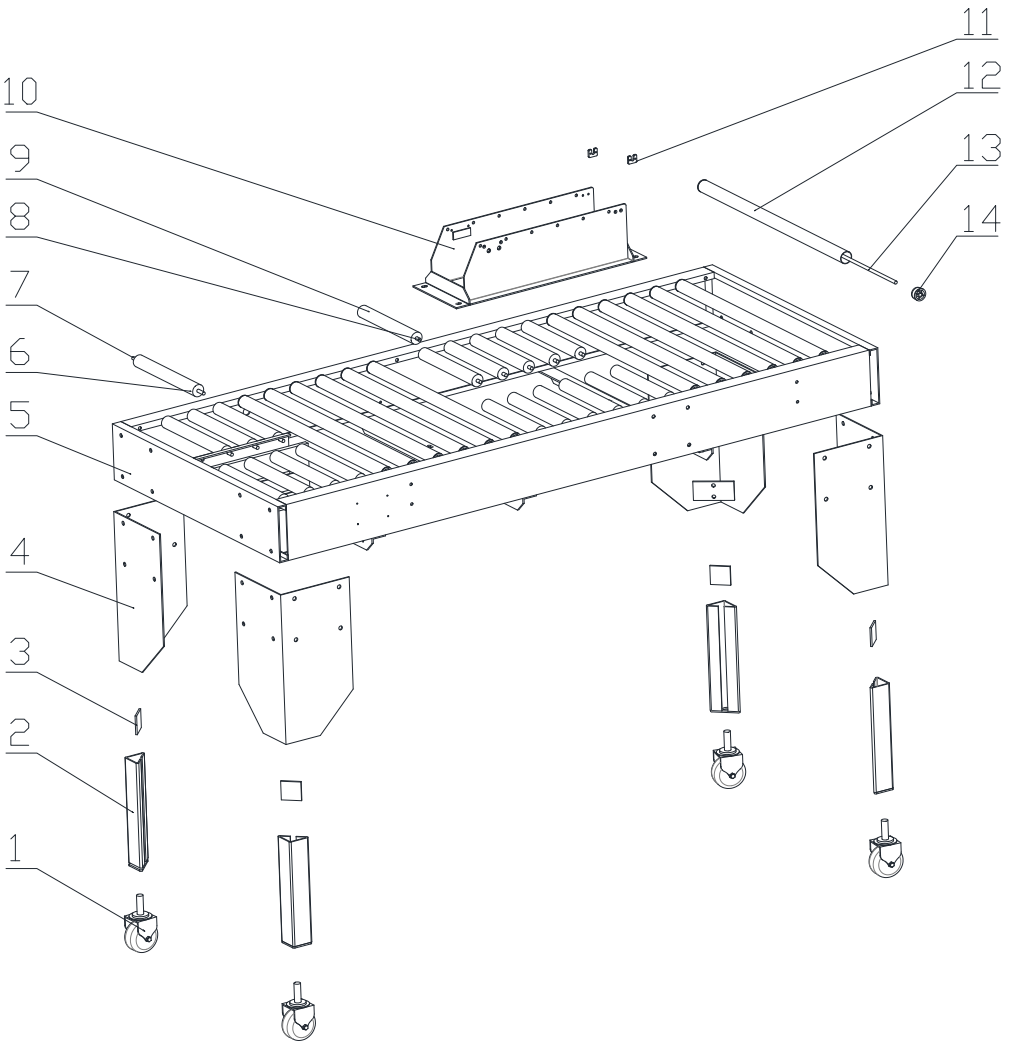


Figure 15

Parts list:

S/N	Material No.	Name	Part No.	Unit	Quantity
1	2.16.01.0600400	Casters		Pcs	4
2	4.30.03.0700120	Adjusting	GPC50D-01-004	Pcs	4
3	4.30.03.0210102	Lining board	GPC50-01-003	Pcs	4
4	4.30.03.1170120	Undercarriage	GPC50D-01-002	Pcs	4

5	4.30.03.1180120	Frame	GPC50-01-001	Pcs	1
6	4.30.03.0581800	Roller 260	GPC50-01-014-02	Pcs	8
7	4.30.03.0610300	Roller shaft 310	GPC50-01-015-02	Pcs	8
8	4.30.01.0281600	Roller 235	GPA50-01-005	Pcs	12
9	4.30.03.0600300	Roller shaft 260	GPC50-01-015-01	Pcs	12
10	4.30.03.1120120	Lower bracket	GPC50-01-007	Pcs	1
11	4.30.02.0210102	Single U-shaped	GPB56-03-008	Pcs	2
12	4.30.03.0591800	Roller 625	GPC50-01-014-03	Pcs	13
13	4.30.03.0620300	Roller shaft 670	GPC50-01-015-03	Pcs	13
14	4.16.01.0065100	Roller rubber plug	GPB56-01-023	Pcs	66

7.3 Exploded view of adjusting mechanism

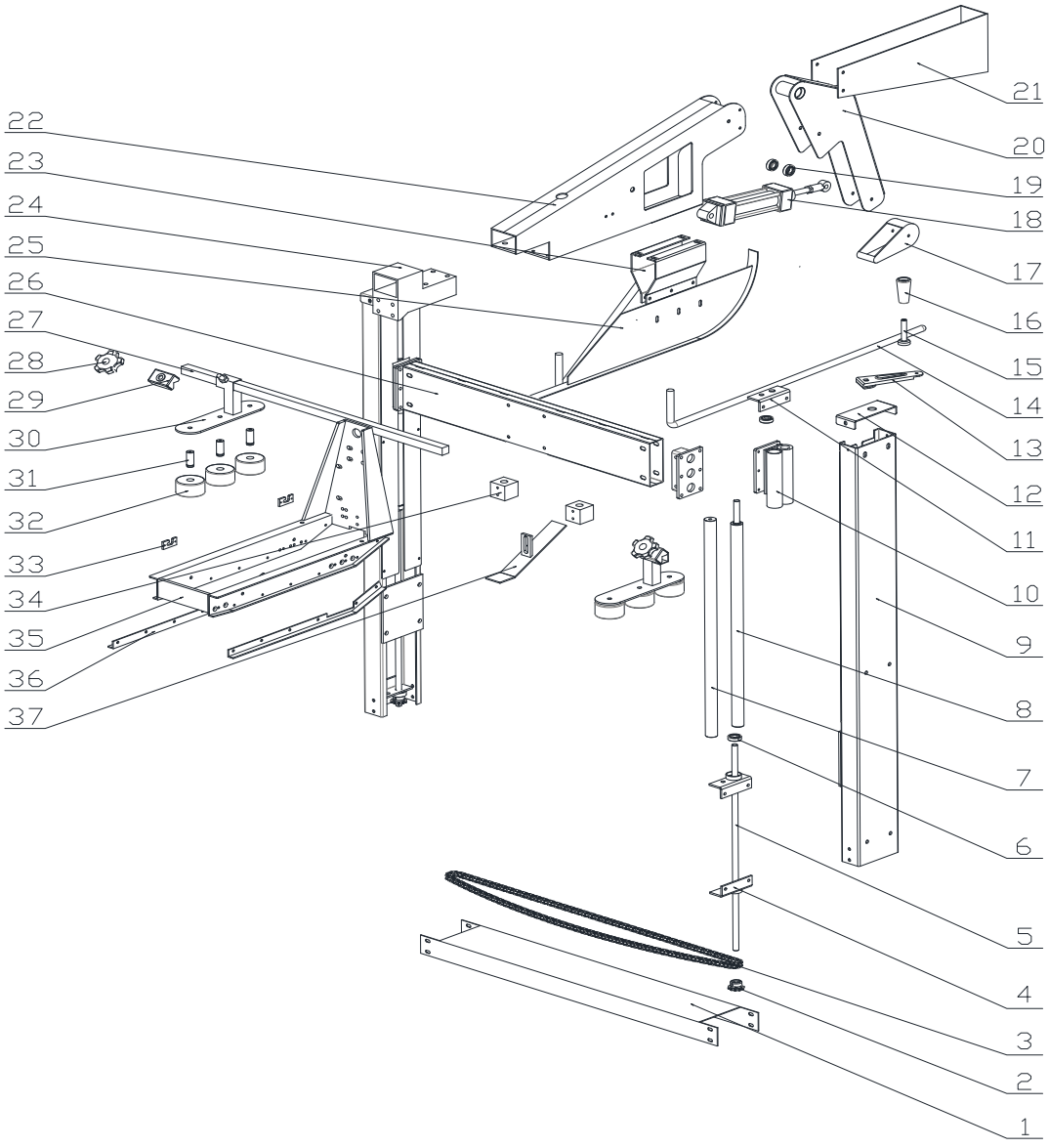


Figure 16

Parts list:

S/N	Material No.	Name	Part No.	Unit	Quantity
1	4.30.03.1190120	Chain cover	GPC50D-03-007	Pcs	1
2	4.12.17.0010301	3/8-inch chain wheel	GPB56-01-008	Pcs	4
3	2.12.44.0000030	3/8-inch chain		Pcs	2
4	4.30.03.0380102 4.30.03.0380202	Lifting bearing seat (external)	GPC50-03-033	Pcs	2
5	4.30.03.0720300	Lifting spindle extension	GPC50-03-022	Pcs	4
6	2.11.01.1560010	Bearing 6001		Pcs	18
7	4.30.03.0730600	Lifting guide rod	GPC50-03-023	Pcs	2
8	4.17.03.0040301	Lifting threaded rod	GPC50-03-021	Pcs	4
9	4.30.03.0680120	Pillar	GPC50D-03-001	Pcs	4
10	4.30.03.0300102 4.30.03.0300202	Single upright double threaded tube (right/left)	GPC50-03-024	Pcs	4
11	4.30.03.03601023 4.30.03.0360202	Lifting bearing seat (internal)	GPC50-03-032	Pcs	8
12	4.30.03.1200120	Upper cover plate	GPC50D-03-008	Pcs	4
13	4.30.02.0100102	Hand crank	GPB56-01-018	Pcs	1
14	4.30.03.0411600	Shrimp angle pincher	GPC50-03-036	Pcs	2
15	4.30.02.0090102	Crank shaft	GPB56-01-017	Pcs	1
16	2.12.24.0300650	Rubber handle		Pcs	1
17	4.30.03.1031700	Rear cover folding accessories	GPC50-03-019	Pcs	1
18	3.20.05.1340102	Cylinder		Pcs	1
19	2.11.01.1562020	Bearing 6202		Pcs	6
20	4.30.03.0820300	Strike rod	GPC50-03-014-03	Pcs	1
21	4.30.03.0980100	Strike rod shield	GPC50-03-018	Pcs	1
22	4.10.20.0130100	Strike rod connecting seat	GPC50-03-12-04	Pcs	1
23	4.30.03.0961900	Partition board fixed seat	GPC50-03-016	Pcs	2
24	4.30.03.1210120	Strike rod fixed seat	GPC50D-03-011	Pcs	1
25	4.30.03.0531800	Partition board	GPC50-03-017	Pcs	1
26	4.30.03.1220120	Lifting beam	GPC50D-03-003	Pcs	1
27	4.30.03.0811700	Guide rod	GPC50-03-030	Pcs	1
28	2.12.20.1000630	Quincunx handle		Pcs	2
29	4.30.02.0300102	Lateral pinch roller gland	GPB56-04-002	Pcs	2

30	4.30.03.0350120	Lateral pinch roller rod	GPC50-03-031	Pcs	2
31	4.30.01.0160102	Active lateral pinch roller rod	GPA50-03-007	Pcs	6
32	4.16.01.0085100	Lateral pinch roller	GPB56-04-010	Pcs	6
33	4.30.02.0210102	Single U-shaped cleat	GPB56-03-008	Pcs	2
34	4.30.03.0400102	Shrimp angle pincher holder	GPC50-03-035	Pcs	2
35	4.30.03.1230120	Upper bracket	GPC50D-03-004	Pcs	1
36	4.30.03.1021900	Upper bracket guide plate	GPC50-03-015	Pcs	2
37	4.30.03.0951900	Inlet front guide plate	GPC50D-03-010	Pcs	1

7.4 Exploded view of belt conveying mechanism

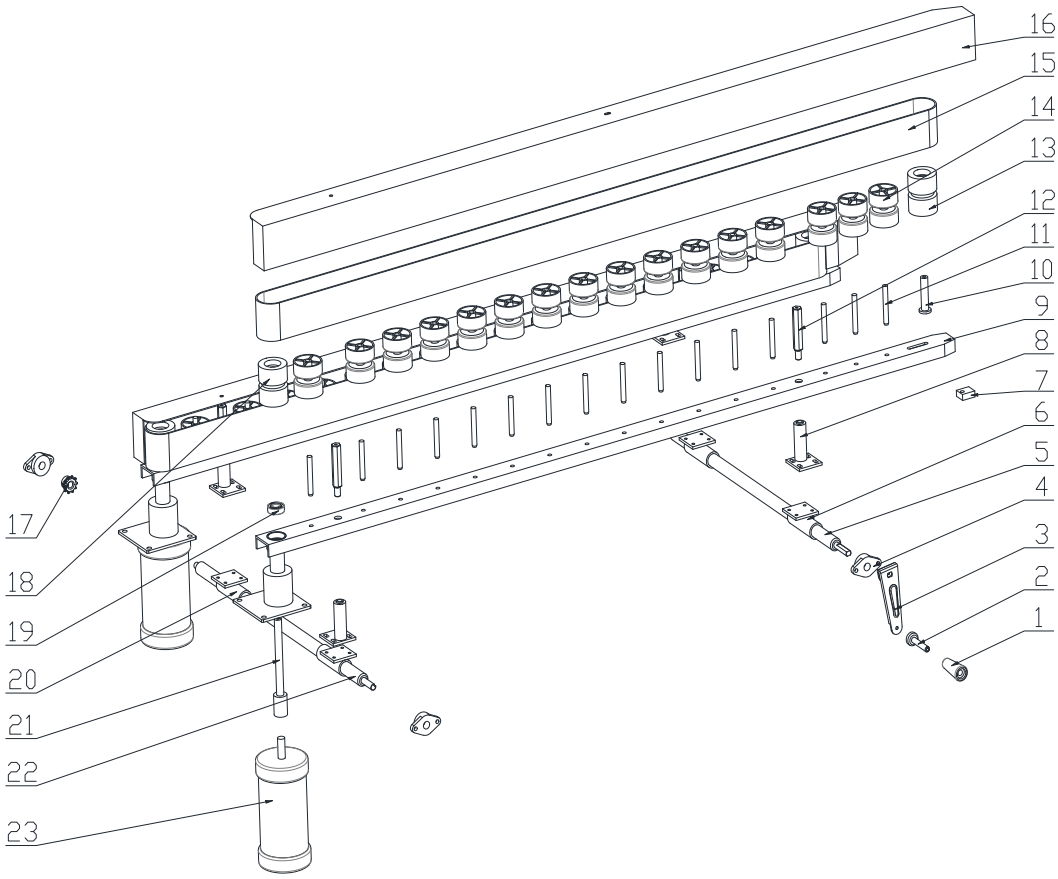


Figure 17

Parts list:

S/N	Material No.	Name	Part No.	Unit	Quantity

1	2.12.24.0300650	Rotary handle sleeve	M10XL65	Pcs	1
2	4.30.02.0090102	Crank shaft	GPB56-01-017	Pcs	1
3	4.30.02.0100102	Hand crank	GPB56-01-018	Pcs	1
4	4.30.02.0080102	Prismatic bearing seat	GPB56-01-007	Pcs	4
5	4.17.03.0140301	Left and right threaded rod (front)	GPC50-02-007	Pcs	1
6	4.30.02.0040102	Left and right threaded tube (left)	GPB56-01-006-L	Pcs	2
7	4.30.01.0090102	Belt adjusting block	GPA50-02-007	Pcs	2
8	4.30.01.0020102	Belt holder support seat	GPA50-02-002	Pcs	4
9	4.30.03.1150120	Belt holder	GPC50-02-001	Pcs	2
10	4.30.03.0280102	Driven shaft	GPC50-02-013	Pcs	2
11	4.30.03.0230102	Single-hole idler shaft	GPC50-02-005	Pcs	32
12	4.30.03.0220102	Belt cover support pillar	GPC50-02-004	Pcs	4
13	4.30.03.0291012	Driven wheel	GPC500-2-014	Pcs	2
14	4.16.01.0035100 4.16.01.0025100	Idler wheel	GPB56-03-016 GPB56-03-015	Pcs	32 96
15	2.13.05.7532900	Belt		Pcs	2
16	4.30.03.1160120	Belt cover	GPC50D-02-002	Pcs	2
17	4.12.17.0010301	3/8-inch chain wheel	GPB56-01-008	Pcs	2
18	4.30.03.0271012	Driving wheel	GPC50-02-011	Pcs	2
19	2.11.01.1562020	Bearing 6202		Pcs	1
20	4.30.02.0060102	Left and right threaded tube (right)	GPB56-01-006-R	Pcs	2
21	4.18.03.0020301	Driving shaft	GPC50-02-012	Pcs	1
22	4.17.03.0130301	Left and right threaded rod (rear)	GPC50-02-006	Pcs	1
23	3.18.05.0200510	Motor		Pcs	2

7.5 (Old mandrel) tape sticker

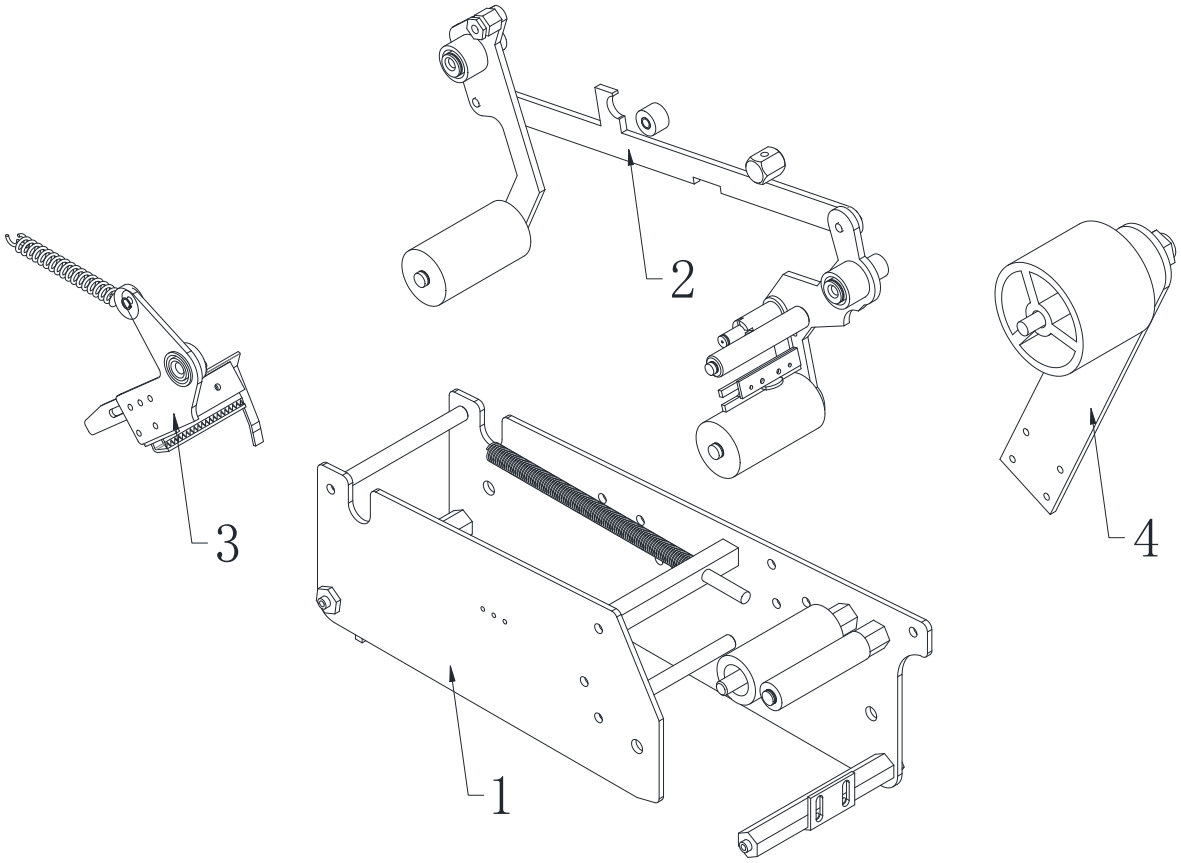


Figure 18

Parts List

S/N	Name	Quantity	Remarks
1	Mandrel rack	1	
2	Swing arm	1	
3	Cutter	1	
4	Tape holder	1	

7.5.1 Tape sticker mandrel

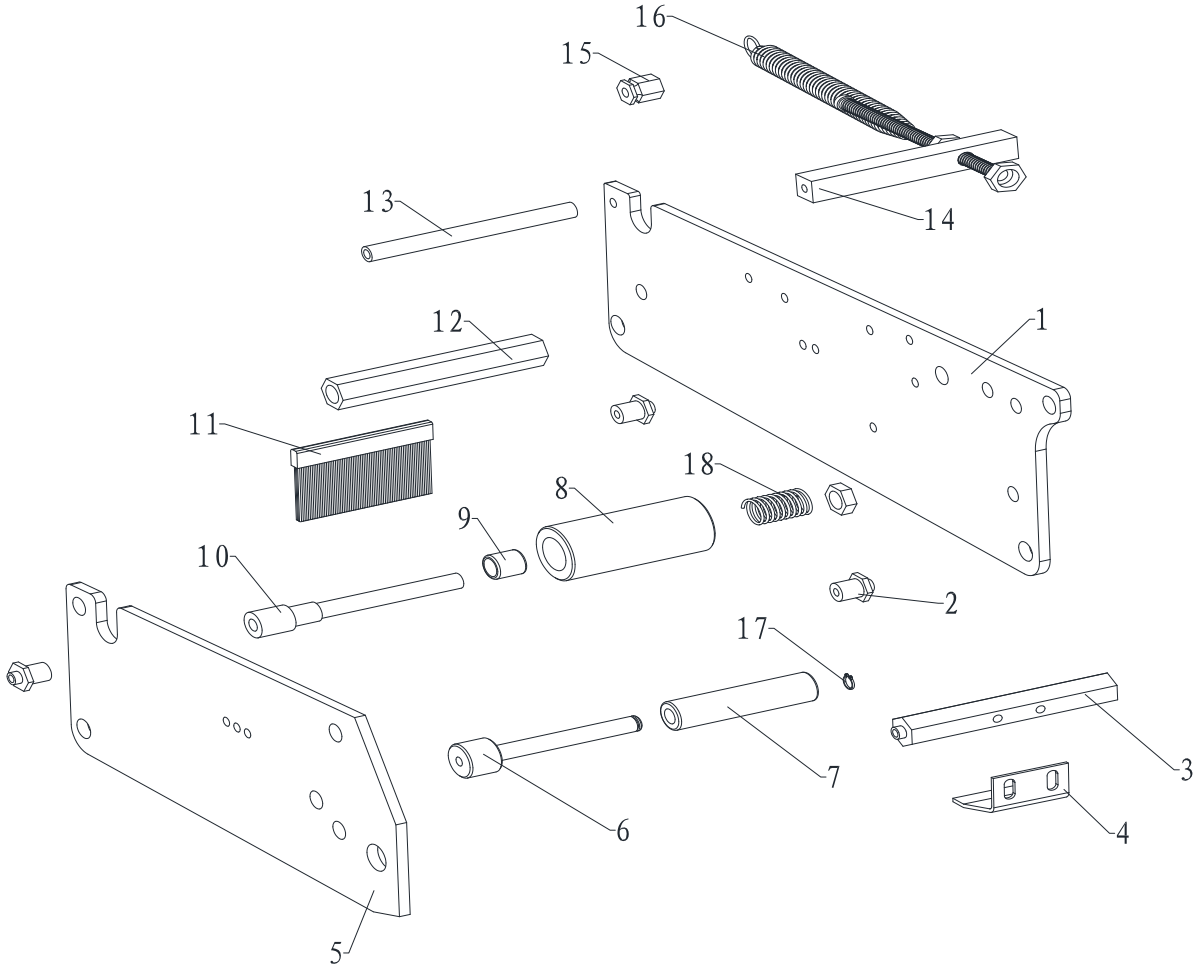


Figure 19

Parts List

S/N	Material code	Specification	Drawing No.	Name	Quantity
1	4.19.04.0060320	434*147*4	T3-001-1	Left panel (large)	1
2	4.19.04.0280302	17*20//45/galvanized	T3-21	Hexagonal threaded axle	3
3	4.19.04.0360302	Subtense 17*128	T3-06	Front pivot axle	1
4	4.19.04.0330302		T3-050A	Front guide plate	1
5	4.19.04.0440302	310*135*4	T3-002-1	Small right panel	1
6	4.19.04.0040302	Subtense 17*101	T3-07	PE guide wheel shaft	1

7	4.19.04.0035300	∮ 20*80	T3-08	PE tape guide roller	1
8	4.19.04.0071002	∮ 35*80	T3-01	One-way knurl wheel	1
9	2.11.01.1816160			One-way bearing	1
10	4.19.04.0080302	Subtense 14*118	T3-03	One-way wheel axle	1
11	2.13.14.1100750	8*11*46*75MM/3-cun (cun: a Chinese length unit)		Brush	1
12	4.19.04.0290300	Subtense 17*116	T3-10	Brush locked axle	1
13	4.19.04.0300402	∮ 10*116	T3-09	Panel locked axle	1
14	4.19.04.0460302	Subtense 14*116	T3-11	Square locking axle of main tension spring	1
15	4.19.04.0470402	Subtense 14*17	T3-19	Main tension spring locked hexagonal axle	1
16	4.13.06.0040502	∮ 1.8* ∮ 13.5*220	dh-01-02	Long tension spring (lower)	1
17	2.12.02.0000100	∮ 10		Shaft circlip (external circlip)	1
18	4.13.06.0120502	∮ 1.6* ∮ 12.5*25	dh-01-06	One-way wheel pressure spring	1

7.5.2 Tape sticker swing arm

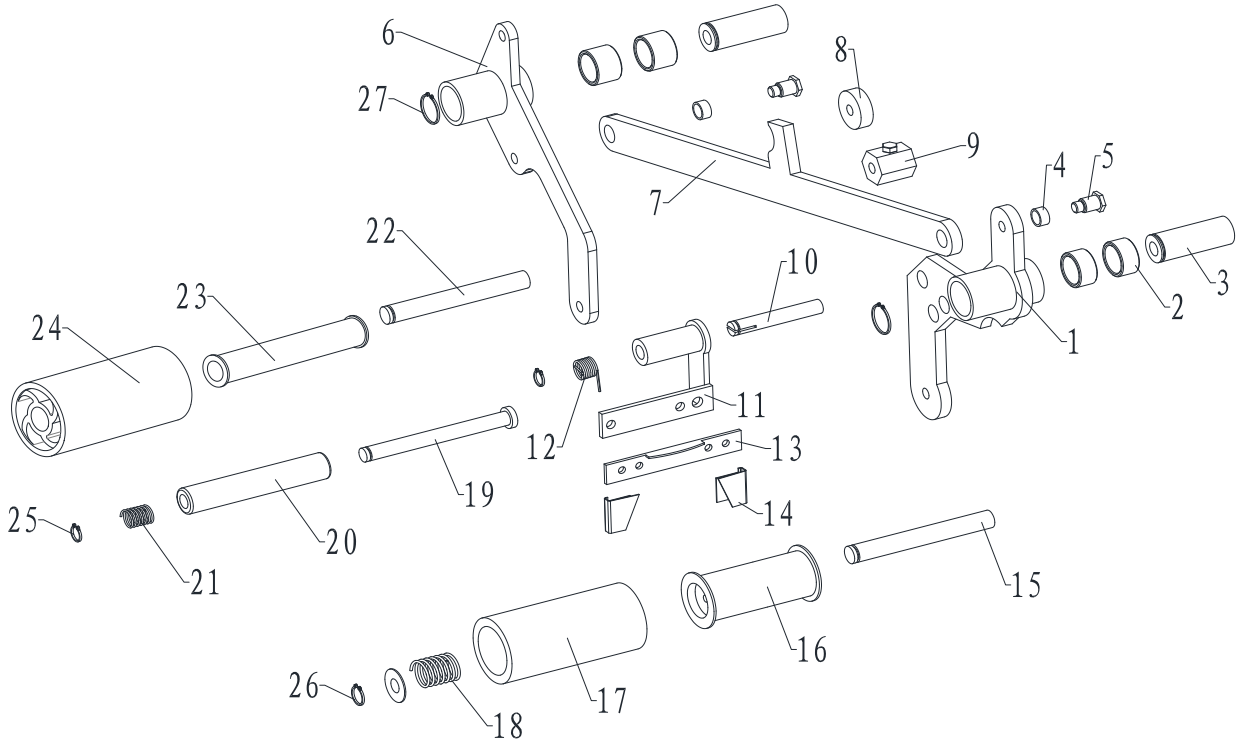


Figure 20

Parts List

S/N	Material code	Specification	Drawing No.	Name	Quantity
1	4.19.04.0320320		T3-003	Front swing arm/forward	1
2	4.19.04.0350000	ϕ16* ϕ20*12	TG-101	Forward and backward swing cutter copper bush	4
3	4.19.04.0340302	15.9*43	T3-15	Front and rear swing arms fixed axle (eccentric shaft)	2
4	4.19.04.0260000	ϕ8* ϕ10*4.9	T3-901	Connecting rod copper bush	2

5	4.19.04.0250302	10*10*15.5//45/galvanized	T3-18	Connecting rod hexagonal threaded axle	2
6	4.19.04.0130302		T3-004	Rear swing arm/forward	1
7	4.19.04.0230302	356*20*5	T3-005	Connecting rod	1
8	4.19.04.0245500	∮8*∮18*12	T3-50	Connecting rod catch wheel	1
9	4.19.04.0430302	Subtense 17*20	T3-24	Tape sticker wheel adjusting hexagon prism	1
10	4.19.04.0050302	∮8*50	T3-12	U-shaped tape guide holder axle	1
11	4.19.04.0170302		T3-009	Tape support rack (right, U-shaped)	1
12	4.13.06.0140502	∮1.2*∮10*14		Top flat torsion spring/right torsion spring	1
13	4.19.04.0160302	78*12*2	T3-008	Tape top plate	1
14	4.19.04.0210508		T3-27	Cleat	2
15	4.19.04.0020302	∮10*81	T3-05	3-cun tape sticker wheel axle	1
16	4.16.02.0145200	∮10.1*∮28*82/black rubber	FX03A-14	Front rubber wheel center sleeve 3-cun	1
17	4.16.02.0125200	∮26*38*80.5/black	FX03A-15	Front	1

		rubber		rubber wheel 3-cun	
18	4.13.07.0060502	∮1*∮ 14*22//65N/galvanized	FX03-01-14-22	Rubber wheel pressure spring - pressure spring	1
19	4.19.04.0100312	∮11*84	T3-04	Knurling guide wheel axle	1
20	4.19.04.0091002	∮15*80	T3-02	Knurling guide wheel	1
21	4.13.06.0210502	∮0.8*∮ 9.9*12//65N/galvanized	dh-01-10	Small knurling guide wheel pressure spring	1
22	4.19.04.0480402	∮10*85.5//A3/galvanized	T3-05E	Tape wheel axle	1
23	4.16.02.0155200	∮10.1*∮16*83/black rubber	FX03A-17	Rear rubber wheel center sleeve 3-cun	1
24	4.16.02.0135200	∮15*43*82/black rubber	FX03A-16	Rear rubber wheel 3-cun	1
25	2.12.02.0000080	∮8		Shaft circlip (external circlip)	2
26	2.12.02.0000100	∮10		Shaft circlip (external circlip)	2
27	2.12.02.0000160	∮16		Shaft circlip (external circlip)	2

7.5.3 Cutter

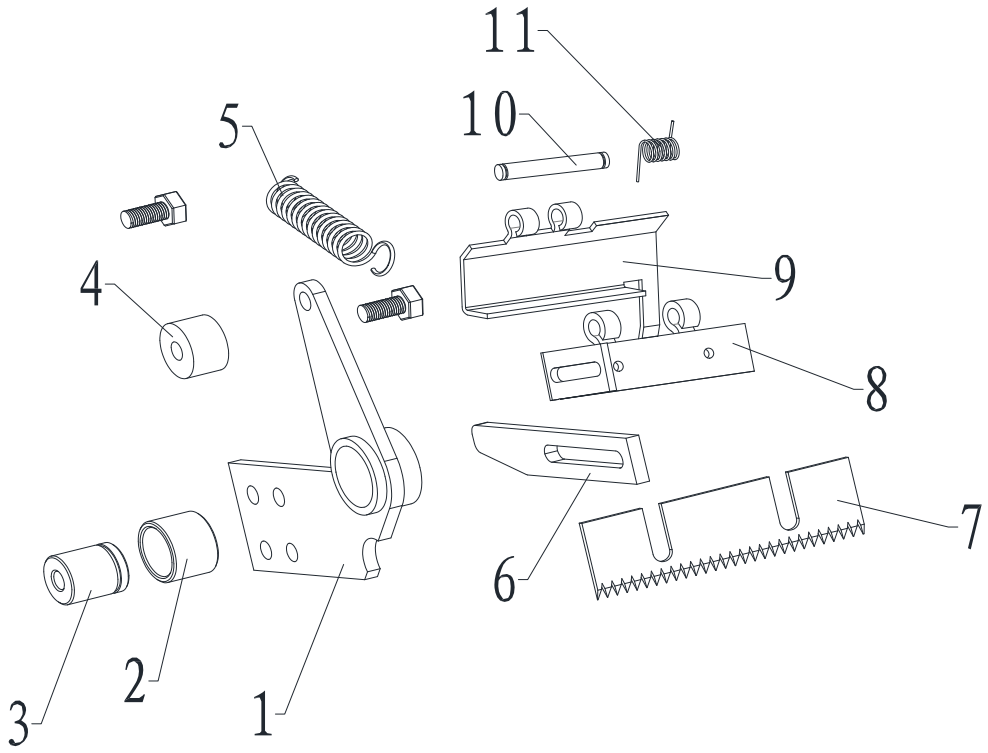


Figure 21

Parts List

S/N	Material code	Specification	Drawing No.	Name	Quantity
1	4.19.04.0390312	95.2*95*12//45/galvanized	T3-012	Cutter holder: One side is triangular (regular)	1
2	4.19.04.0350000	∮16*∮20*12	TG-101	Forward and backward swing cutter copper bush	1
3	4.19.04.0410302	∮15.9*15.5	T3-17	Cutter seat fixed axle	1
4	4.19.04.0375500	∮18*∮22*6	T3-51	Cutter rack catch wheel	1

5	4.13.06.0060502	∮1.2*∮10*51.6	dh-01-03	Cutter tension spring	1
6	4.19.04.0420302	90*15*4	T3-007	Extended sheet	1
7	2.12.47.0100030	K-84*25*1.5-28T		Blade: 3-cun/old	1
8	4.19.04.0450302	93*20	FX500-00-01-50	Bracket/cutter rack: L-shaped	1
9	4.19.04.0140302	85*66	FX500-00-01-52	Cutter cover	1
10	4.19.02.0110402	∮5*50	T2-05A	Cutter cover shaft center	1
11	4.13.06.0170502	∮0.8*∮6*10.2	dh-01-08	Cutter cover torsion spring	1

7.5.4 Tape holder

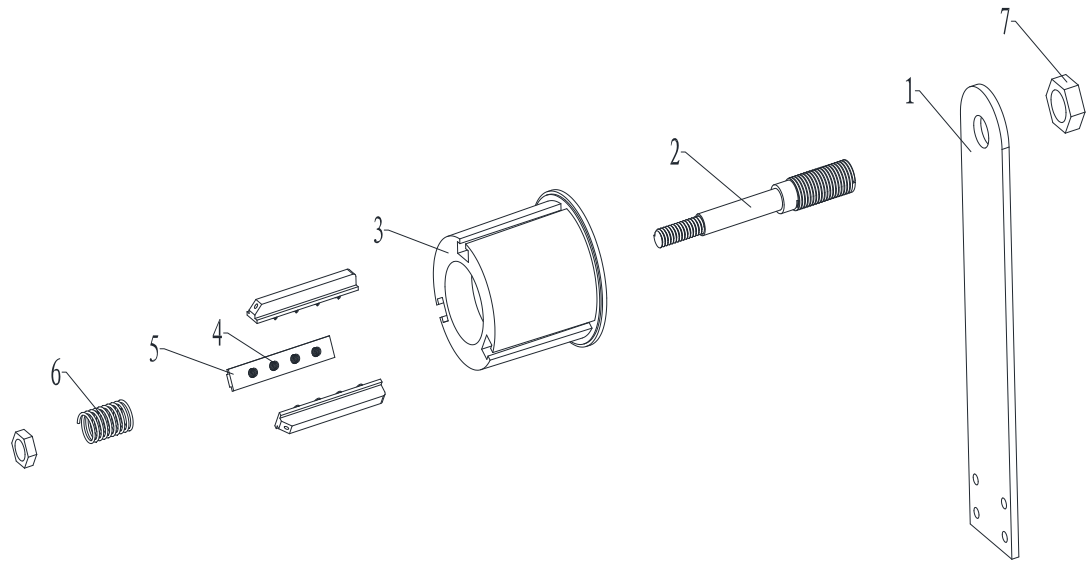


Figure 22

Parts List

S/N	Material code	Specification	Drawing No.	Name	Quantity
1	4.19.04.0200302	270*50*5	T3-010	Tape holder support chip	1

2	4.19.04.0190302	M18*1*130	T3-25	Tape holder fixed axle	1
3	4.16.02.0055100	∮85*∮12.1*64/polyamid (PA)	FX3A-10	Tape holder (round tape)	1
4	4.13.06.0230502	∮0.6*∮3.5*13//65N/galvanized	dh-01-05A	Small pressure spring of tape wheel	12
5	4.16.02.0045100	12*9*61/polyamid (PA)	FX3A-10	Tape holder tensioning block/tape holder (round tape) accessories	3
6	4.13.06.0190502	∮2.2*∮18*32	dh-01-09	Pressure spring of tape wheel	1
7	4.19.04.0180302	M18*1*10	T3-20	Tape holder fixed nut	1
8					

7.5.5 (New mandrel) tape sticker

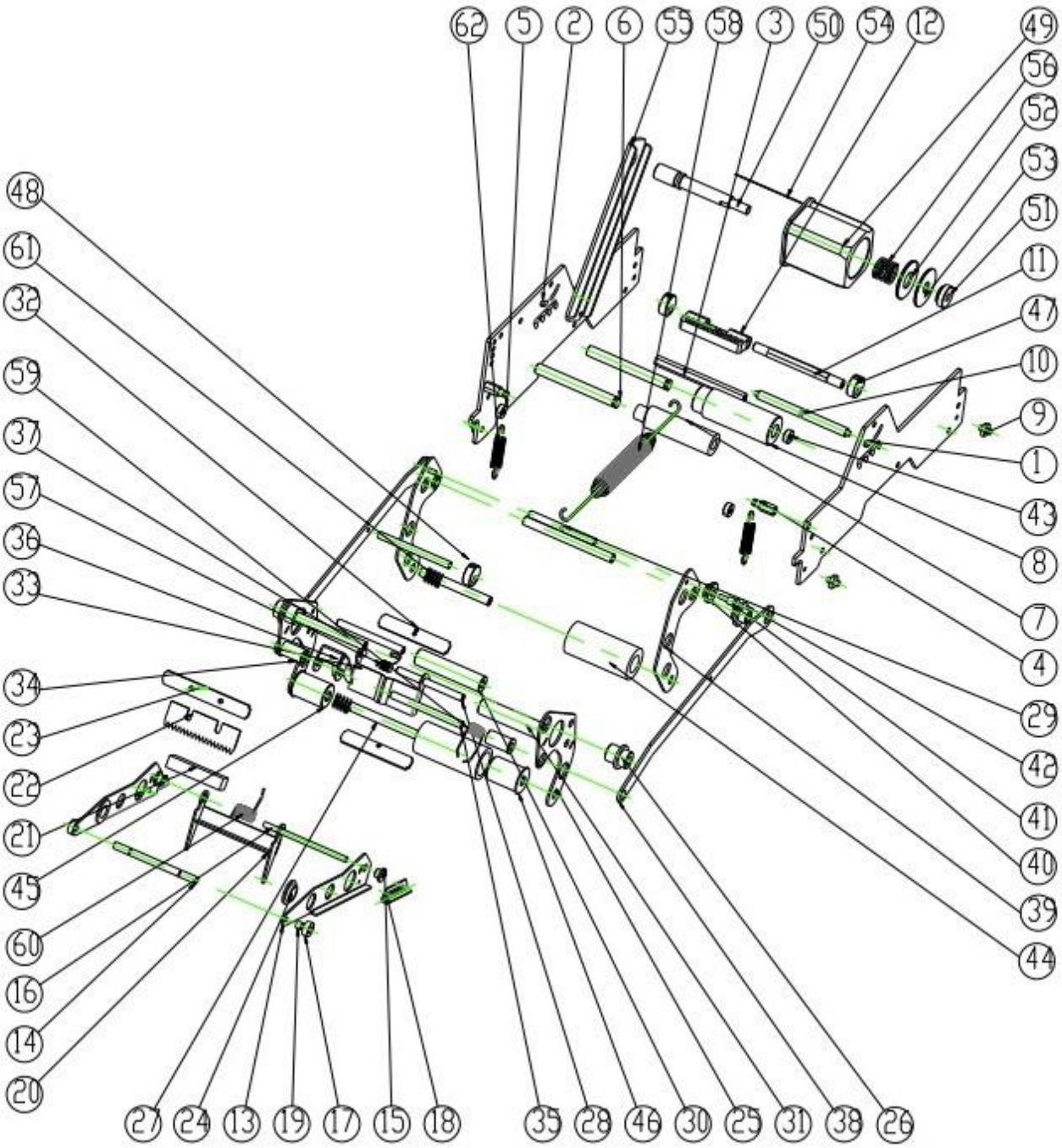
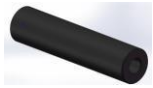

62
5
2
6
55
58
3
50
54
12
49
56
52
53
51
11
47
10
9
1
43
8
7
4
29
42
41
40
39
44
48
61
32
59
37
57
36
33
34
23
22
21
45
60
16
14
20
27
24
13
19
17
15
18
35
28
46
30
25
31
38
26

Figure 23

Parts List

S/N	Material code	Graph	Drawing No.	Name	Quantity
1	BJ-FJX-01-T001		FX03-01-01 2-cun shared	Mounting plate A	1
2	BJ-FJX-01-T002		FX03-01-02 2-cun shared	Mounting plate B	1
3	JJ-FJX-01-0001		FX03-01-03	Hexagon fixed axle	1
4	JJ-FJX-01-T002		FX03-01-04 2-cun shared	Cutter tension spring axle	2
5	JJ-FJX-01-T003		FX03-01-05 2-cun shared	ter rack positioning nut	2
6	JJ-FJX-01-0004		FX03-01-06	One-way wheel axle	2
7	JJ-FJX-01-0005		FX03-01-07	PE wheel	1
8	JJ-FJX-01-0006		FX03-01-08	One-way wheel	1
9	JJ-FJX-01-T008		FX03-01-09 2-cun shared	e sticker fixing screws	4
10	JJ-FJX-01-0009		FX03-01-10	Main tension spring axle	1
11	JJ-FJX-01-0010		FX03-01-11	Brush locked axle	1
12	JJ-FJX-01-0011		FX03-01-12	Brush	1
13	BJ-FJX-01-T003		FX03-01-13-1 2-cun shared	Cutter plate	2
14	JJ-FJX-01-0012		FX03-01-13-2	Cutter rack fixed axle	1
15	JJ-FJX-01-T013		FX03-01-13-3 2-cun shared	Cutter cover shaft sleeve	2
16	JJ-FJX-01-0014		FX03-01-13-4	Cutter cover fixed axle	1
17	JJ-FJX-01-T015		FX03-01-13-5	Cutter rack ring washer	2
			FX03-01-13-6		

18	BJ-FJX-01-T004		2-cun shared	Extended sheet	2
19	*JJ-FJX-01-T016*		*FX03-01-13-7*	ber sleeve of cutter rack ring washer	*2*
20	BJ-FJX-01-0005		FX03-01-13-8	Cutter cover	1
21	JJ-FJX-01-0017		FX03-01-13-9	Cutter cotton cushion	1
22	BZ-DJP-01-0018		FX03-01-13-10	Blade	1
23	JJ-FJX-01-0019		FX03-01-13-11	Blade fixed plate	1
24	JJ-FJX-01-T020		FX03-01-13-12 2-cun shared	Cutter rack stiffening ring	2
25	BJ-FJX-01-T006		FX03-01-14-1 2-cun shared	Front swing arm	2
26	JJ-FJX-01-T030		FX03-01-14-12 2-cun shared	ed axle sleeve of front swing arm	2
27	JJ-FJX-01-0021		FX03-01-14-2	Front rubber wheel fixed axle	2
28	JJ-FJX-01-0024		FX03-01-14-4	er setting seat fixed axle	2
29	JJ-FJX-01-0025		FX03-01-14-5	n tension spring axle of rear swing arm	1
30	JJ-FJX-01-0026		FX03-01-14-6	Small knurl wheel	1
31	JJ-FJX-01-0027		FX03-01-14-20	Small PE gear	1
32	BJ-FJX-01-0007		FX03-01-14-7	Front swing arm stop plate	1 for each
33	BJ-FJX-01-0008		FX03-01-14-8	Rubber setting seat	1
34	JJ-FJX-01-0028		FX03-01-14-9	pe upper-frame fixing sleeve	2
35	JJ-FJX-01-0029		FX03-01-14-10	upper-frame fixed axle	2
36	BJ-FJX-01-T009		FX03-01-14-11 2-cun shared	Rubber setting sheet	1

37	JJ-FJX-01-0031		FX03-01-14-13	Front swing arm fixed axle	1
38	BJ-FJX-01-T010		FX03-01-14-14 2-cun shared	Connecting rod	2
39	BJ-FJX-01-T011		FX03-01-14-15 2-cun shared	Rear swing arm	2
40	JJ-FJX-01-T033		FX03-01-14-17 2-cun shared	Rear swing ring fixing sleeve	2
41	JJ-FJX-01-T032		FX03-01-14-16 2-cun shared	Rear swing connecting rod screws	2
42	JJ-FJX-01-T034		FX03-01-14-18 2-cun shared	ecting rod axle sleeve of rear swing arm	2
43	JJ-FJX-01-T007		FX03-01-08-01 2-cun shared	One-way wheel copper bush	1
44	SJ-TLL-03-0002		FX03-01-14-3	External rubber wheel of tape sticker	2
45	JJ-FJX-01-0022		FX03-01-14-3A	Rubber wheel fixing sleeve A1	2
46	JJ-FJX-01-0023		FX03-01-14-3B	Rubber wheel fixing sleeve A2	2
47	JJ-FJX-01-T035		FX03-01-15 10-hole 2-cun shared	Rear swing arm limit wheel	2
48	JJ-FJX-01-T036		FX03-01-14-20 8-hole 2-cun shared	Connecting rod limit wheel	1
49	SJ-JLL-01-0037		FX03-01-19	3-cun tape holder	1
50	JJ-FJX-01-0015		FX03-01-23	Front tape holder fixed axle	1
51	JJ-FJX-01-T042		FX03-01-24 2-cun shared	pe holder fixed axle nut	1
52	JJ-FJX-01-T040		FX03-01-22 2-cun shared	e holder fixed gear film	1
53	JJ-FJX-01-T039		FX03-01-21 2-cun shared	holder fixed gear film	1
54	JJ-01-0018		FX03-01-20	Tape holder limit sheet	1
			FX03-01-18	Tape holder fixed plate	

55	BJ-FJX-01-T012				1
56	JJ-THL-10-0007		FX03-01-14-23	Tape holder pressure spring	1
57	JJ-THL-10-0004		FX03-01-14-21	Tape setting seat torsion spring	1
58	JJ-THL-10-0002 JJ-THL-10-0008		FX03-01-17B FX03-01-17A	Main tension spring (upper/lower)	1
59	JJ-THL-10-0005		FX03-01-14-28	Tape setting sheet torsion spring	1
60	JJ-THL-10-0003		FX03-01-14-20	Cutter cover torsion spring	1
61	JJ-THL-10-0006		FX03-01-14-22	Rubber wheel pressure spring	1
62	JJ-THL-10-0001		FX03-01-16	Cutter tension spring	1

8 Faults and Removal Methods

Faults and removal methods for cover-folding and sealing part			
No.	Fault	Possible causes	Removal method
1	Tape cannot be cut off.	Blade is not sharp enough, or the cutter sharp is jammed by adhesives.	Replace blade/wash blade.
2	Tape has streaking after cut-off.	The blade is not sharp enough or the cutter holder has block, and the tension spring is too loose.	Inspect the screws on the cutter holder for looseness, if necessary, lubricate them.
3	The tape cannot completely glue the carton.	The main spring is too loose, the roller axle has deposited glue and cannot work normally. The tape is not qualified.	Tighten the main spring, and lubricate the roller shaft. Replace the tape.
4	The carton gets stuck midway.	The adjusting nut of the rubber wheel is too tight, the carton height is not adjusted properly, and the active spring is too tight.	Loosen the tape wheel adjusting nut, re-adjust the carton height and loosen the active spring.
5	The tape breaks during the sealing process.	The blade extends out too long.	Lower the blade position.
6	Tape is often off track.	The stress applied by the guide roller on the carton	Re-adjust the distance between the guide roller.

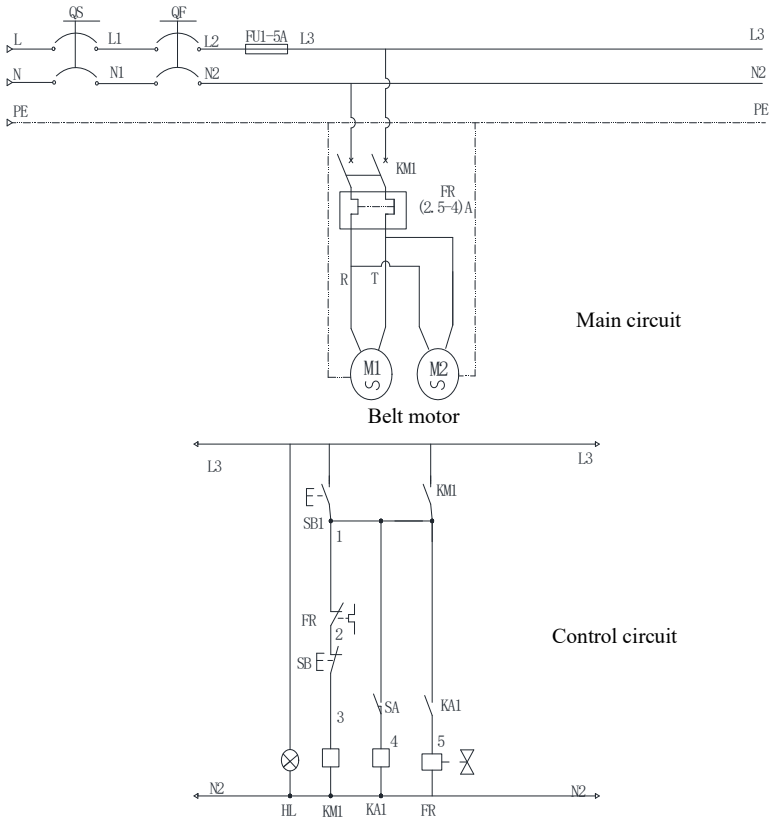
		is not even.	
7	Tape is not on the center line.	The non-return wheel is damaged.	Replace the non-return wheel.
8	There is an abnormal noise during the sealing process.	There is dust on the bearing seat.	Clean the dust and lubricate the bearing seat.
9	The carton extends out before sealing, and the rear edge of the seal has folds.	The belt speeds are not consistent, when the carton is pushed into the machine the carton is not at right position.	Keep the belt speeds consistent, and place the carton at right position.
10	The surface has folds after tape sealing.	The tape tension is too big.	Reduce the tape tension.

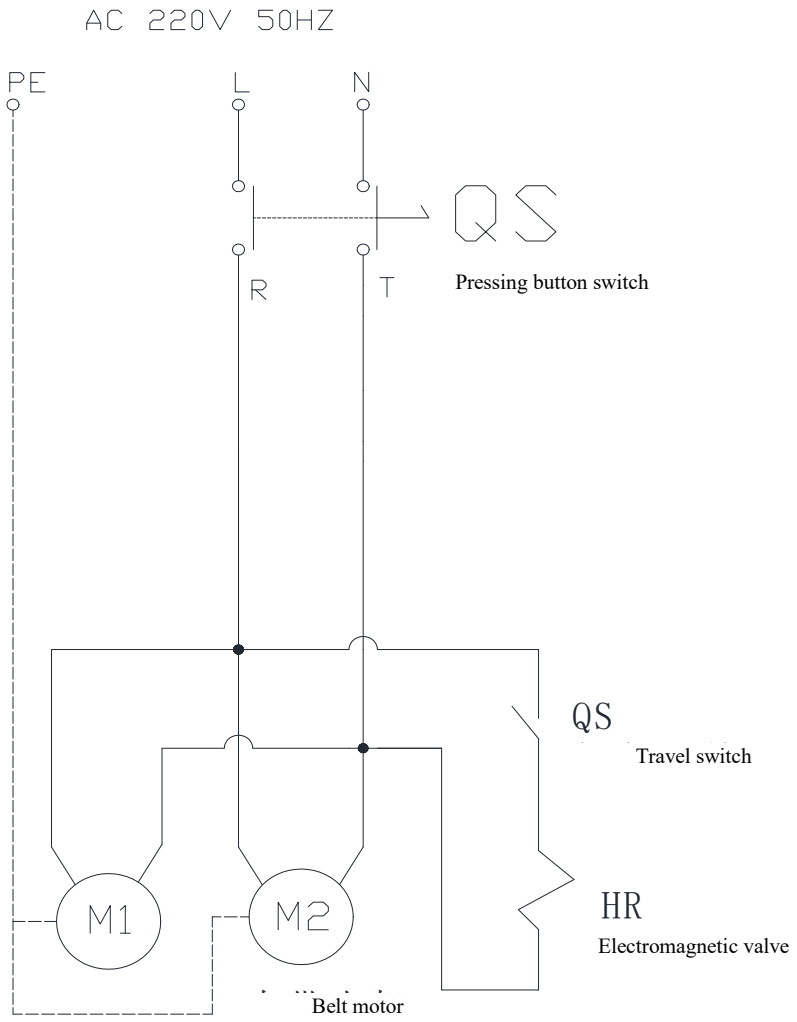
9 Pneumatic components and outsourcing list

S/N	Material No.	Name	Part No.	Unit	Quantity
1	2.11.06.0600120	Fisheye, internal	SI M12*1.25	Pcs	1
2	3.22.30.0102080	Throttle valve	2/8-inch 8-tooth	Pcs	2
3	3.18.05.0200510	Taibang Motor CV/for	CV18-200-15A(G1/G2)	Set	2
4	2.11.01.1562020	Domestically	6202	Pcs	8
5	2.11.01.1560010	Domestically	6001	Pcs	12
6	3.20.05.1340102	AirTAC cylinder	SI40*100-CA	Pcs	1
7	2.12.44.0000030	Chain	3/8-inch B (35B-1)	Pcs	3
8	2.13.05.7532900	Sealing machine belt	3290*75	Pcs	2
9	2.12.24.0300650	Turning handle sleeve	M10*L65	Pcs	2
10	2.16.01.0600400	Caster: Blue	4-cun M16*38	Pcs	4
11	2.12.20.1000630	Quincunx handle	M10*63 /65	Pcs	2
12					
13					

10. Electrical control

10.1 Electrical control diagram





(Economic)

Figure 24

10.2 Pneumatic control diagram

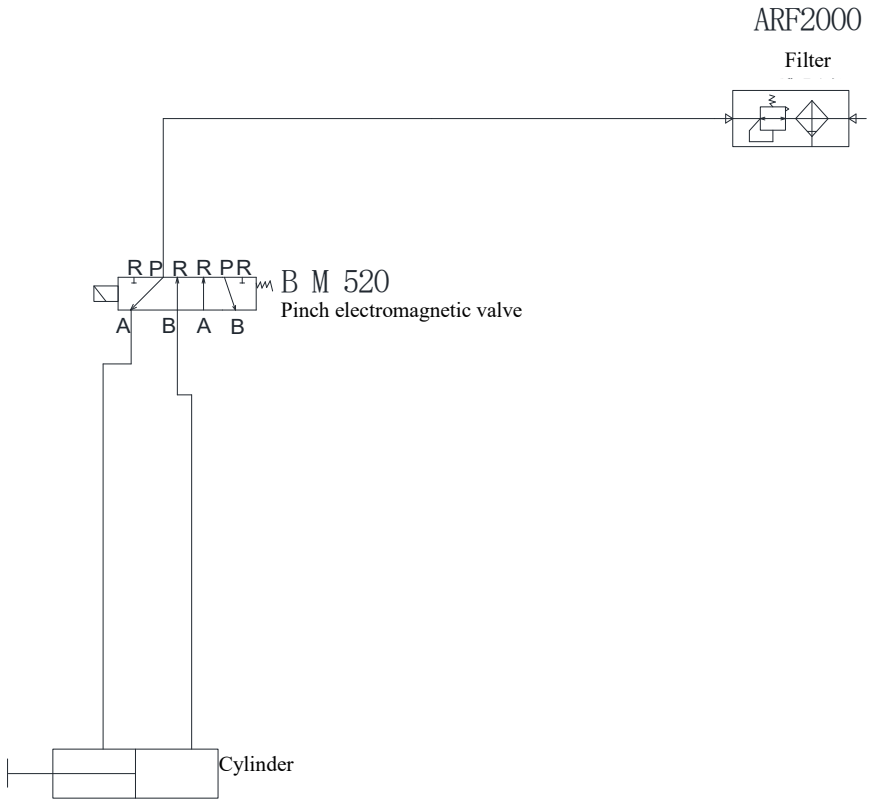


Figure 25

10.3. Electrical control operation instructions

Before operating the machine, you must read this manual over and over again, understand the motion performance of each machine part and understand the functions of each control position. Although we have been thoughtful to the operation instructions of the machine, if you have any unclear parts or find any errors and unsatisfied points, please contact the company.

1. Electrical compositions

Pneumatic control: The supply pressure of the pneumatic supply of

the machine is 6kg/cm^2; The air circuit is composed of the air source processor, cylinder, electromagnetic valve, air pipe, etc.

Electrical control: Power voltage is 220V/110V 50/60HZ; The circuit is composed of position switch, power switch (with overload protection), indicator light, motor, etc.

2. Operating sequence

Startup order: ① Manually adjust the sealing height and width.

② Switch on the air source.

③ Twist the power switch to "ON", press the Start button, the machine will be started and in standby status.

Shutdown order: ① Twist the power switch to "OFF".

② Turn off the air source.

3. Running situation

① After the machine is switched on, press the Start button, the feeding belt rotates and enters the working status.

② When running has a fault, immediately press the Stop button, and after the fault is removed, switch on the power source again to continue operation. Before disconnecting the power source, do not put the hand into the machine to remove faults.

③ If the belt does not operate, please immediately disconnect the power and press Stop to prevent motor burning.

Note: Be sure to disconnect the power firstly before removing the fault, and keep safety first in mind.

10.4 Pneumatic Overhauling Method

The general pneumatic overhauling method is very simple, but before overhauling the machine, you must understand the action performance of the machine parts and the functions of the control positions to prevent safety accidents.

1. Pneumatic control components of the machine: air source processor, electromagnetic valve, cylinder and air pipe composite a pneumatic circuit system. The action requirements of the components of the pneumatic control circuit of the machine associated with the electrical control system are indispensable.

2. General fault description and solutions

① Air source processor fault

Cause: Generally there will be no fault, except man-made damage or overdue use, or lack of maintenance, which results in leakage.

Removal method: Frequently maintain or replace for new products.

② Electromagnetic valve fault

Cause: The electromagnetic valve is blocked inside, the coil is burnt-out, or the screw is loose, causing poor contact between the coil and the valve, the electromagnetic valve piston wears, resulting in internal leakage.

Removal method: Repair or replace for a new product.

③ Cylinder fault

Cause: The cylinder piston wears, causing internal leakage, and the

piston is still used out of service.

Removal method: Replace new products

The above are general removal methods, and the lubrication of pneumatic control components is very important.

10.5 Description of general faults and removal methods

1. Running is abnormal:

a) Inspect whether the air pressure is normal, and whether the pressure regulating valve is at the right position.

b) Inspect whether relevant machine components are normal.

2. Power supply is abnormal:

① Inspect whether the switch is damaged.

② Inspect whether the voltage is stable.

③ Inspect whether the wiring is loose.

3. The cylinder action is not normal.

① Inspect the air tube for air output.

② Inspect whether the electromagnetic valve is damaged and whether the electric coil is in good contact with the electromagnetic valve.

③ Inspect whether the voltage regulator is normal.

④ Inspect whether the cylinder interior is normal.

⑤ Inspect the screws for looseness.

4. The motor does not run.

① Inspect whether the thermal relay at the power switch trips and whether the power source is disconnected.

② Inspect the motor for damages.

③ Inspect whether the chains are normal.

④ Inspect whether the motor shaft works normally.

⑤ Inspect the screws for looseness.

5. The belt runs abnormally.

① Inspect whether the belt tightness needs to be adjusted.

② Inspect the belt for damages.

③ Inspect whether the motor bearing is normal.

Shenzhen Gurki Packaging Machinery Co., Ltd.

Tel: 0755-89502889

Fax: 0755-89502966

Http: //www.gurki88.com

Address: Shuiwei Industrial Park, Longhua Dalang Sub-district, Baoan District, Shenzhen City