Cleveland Equipment

CE-5500-HVE

Continuous Band Sealer with Nitro Flush Option

Operation Manual

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Contents

I. Use

This sealer is suitable for sealing all kinds of plastic films, which is widely used in fields of food, medicine, chemicals, etc. It is the best sealing equipment for packing batch products from factories and shops.

II. Safety Instructions

1. Make sure that the adopted power supply is correct.

   The machine adopts single-phase three wire system (AC 220V/50Hz). The yellow and green wire the is leakage protection ground wire and cannot be removed. The power line should be prevented from touching the ground wire.

2. After the power is connected, do not touch any electrical parts.

3. When the machine is on, do not touch any moving parts.

4. When the machine is on, do not touch heating blocks or ink roller heating block.

5. Do not operate the machine in a corrosive environment.

6. Do not change any parts of the machine.

7. Keep the machine clean (both inside and outside), and clear of dirt from sealing belt.

8. Oil the gear and sprocket with semiliquid gear oil. Fill and exchange oil in worm-gear box regularly.

9. Turn off the power when not use. Allow the machine to run long enough to cool down.

10. Keep this manual near the machine, for easy reference.

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III. Specifications

Voltage	AC 220V/50 110V/60
Motor power	50（0-24m/min 100W）
Sealing power	300×2（W）
Printing power	40×2（W）
Sealing speed	0~16（m/min）
Sealing width	8、10（mm）
Temperature control range	0~300（℃）（Stepless adjustable）
Distance from sealing center to conveyor table	10~40（mm）
Film thickness (monolayer)	≤0.08 mm
Conveyor loading for single package	≤1 Kg
Overall loading of conveyor	≤3 Kg
Dimension（L x W x H)	950×550×950（mm）
Weight	52Kg

IV. Performance Features

This sealer uses an electronic thermostat control unit and stepless speed-adjusting transmission mechanism. It can seal various plastic film bags in different materials and can also be used with varied packaging production lines. The machine has no limitations on sealing length with high efficiency continuous sealing, reliable sealing quality, and convenient operation.

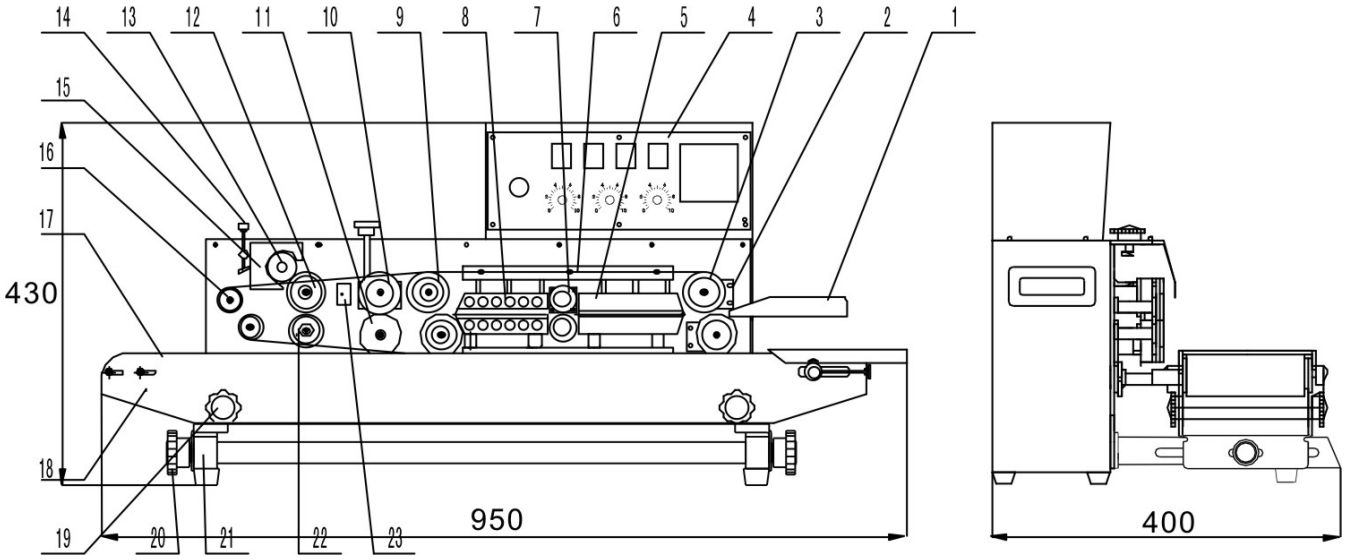
The sealer uses a solid-ink roller to print the desired colored label on a bag while sealing; with the characteristics of high definition, instant print and instant dry, and strong adhesion. The roller cylinder can accept typeface in longitude / horizontal arrangement (R arrange) and jn axial / vertical arrangement (T arrange). For typefaces in R arrange, the machine can print two lines in font size two (18PT) and three lines in font size five (10.5PT), and 20 typeface characters can be arranged in each line.

V. Structure & Working Principle

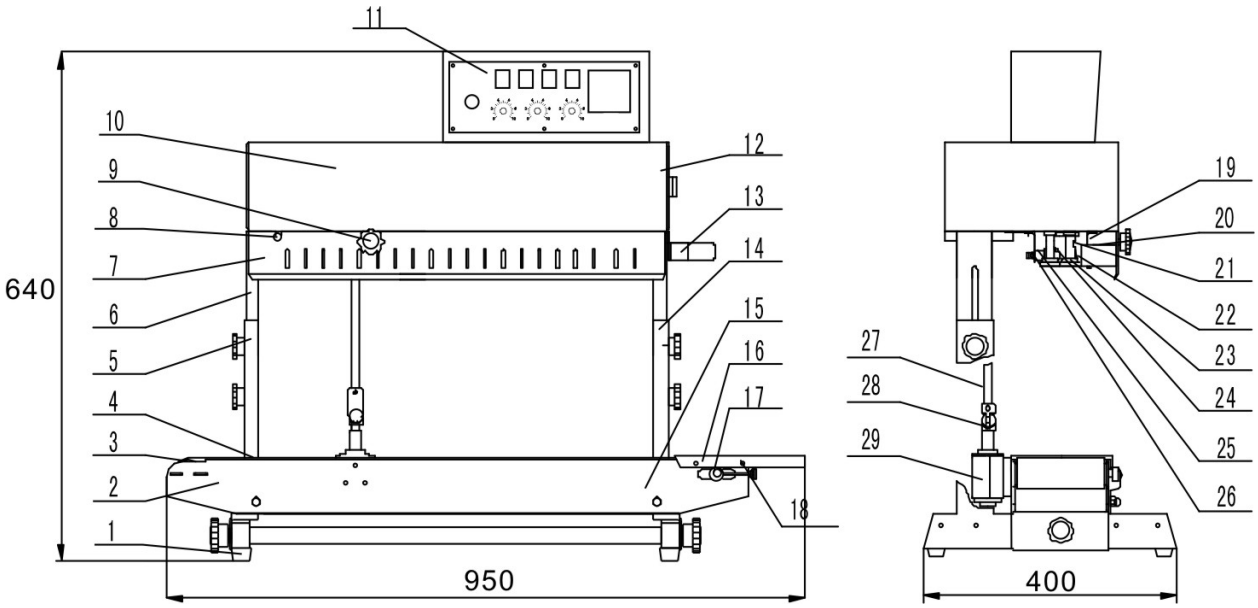
This machine is made up of the machine frame, speed regulator, sealing temperature control system, transmission and conveyor system, and printing device (see Diagram).

The sealing and printing transmission are driven by one motor, which drives the sealing belts, guiding belts and conveyor belt to work synchronously, as well as make printing mechanism working intermittently.

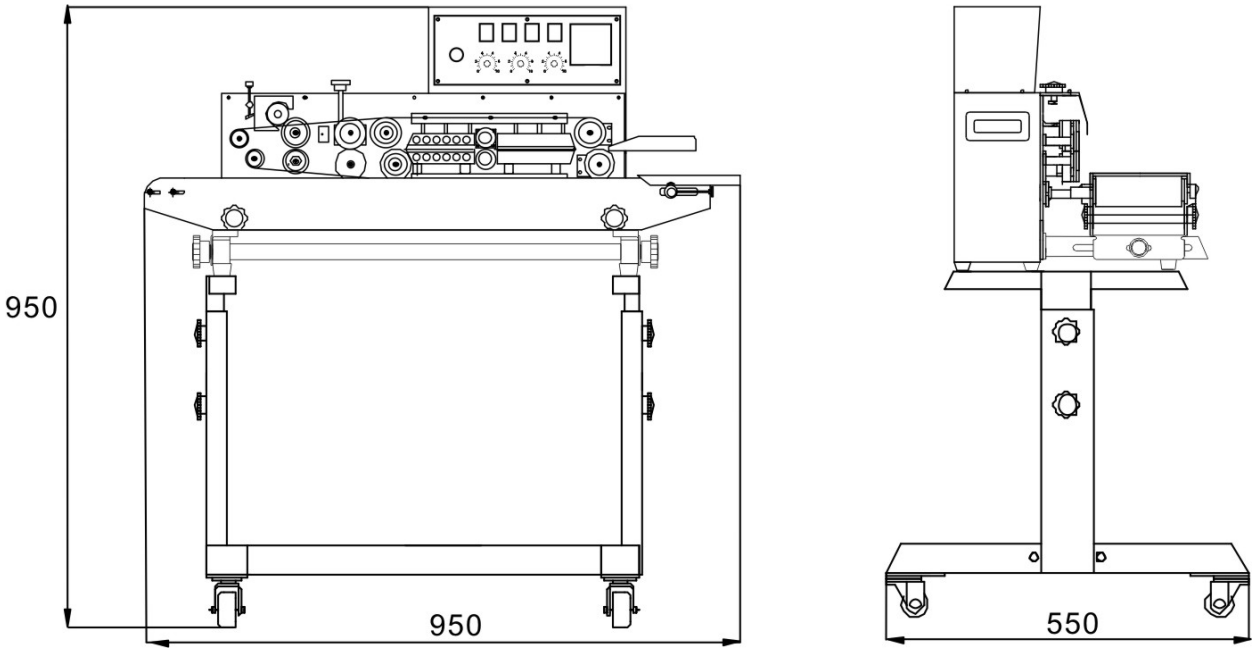
1. Once the power is turned ON, the electrothermal elements start to produce heat, which leads to a rapid temperature rise of both upper and lower heating blocks.
2. Adjust the temperature control and speed control to the required temperature and speed for your application.
3. The plastic packing bag is transferred by the conveying belt, and its sealing part will be guided into the clearance between two sealing belts,
4. The bag is clamped by two sealing belts and conveyed into the heating area.
5. Sealing belts are pressed by two heating blocks and impressing wheels which fuse the plastic film together.
6. The sealed bag is conveyed into the cooling area for cooling
7. The sealed bag is pressed by embossing wheel to make stripe or netted pattern.
8. The print wheel prints a colored label code on the sealed bag.



1	feed opening	13	solid ink roller
2	adjusting block for driven wheel	14	adjusting screw for ink roller swing pole
3	driven wheel	15	heating block of ink roller
4	control cabinet	16	guiding wheel
5	heating block	17	conveyor belt
6	sealing belt	18	conveyor table
7	pressing wheel	19	fastening knob for lifting conveyor table
8	cooling block	20	tightening knob for horizontal conveyor-adjusting
9	driving wheel	21	ledge
10	embossing wheel	22	silicone wheel
11	silicone wheel for embossing	23	sensor
12	printing wheel		



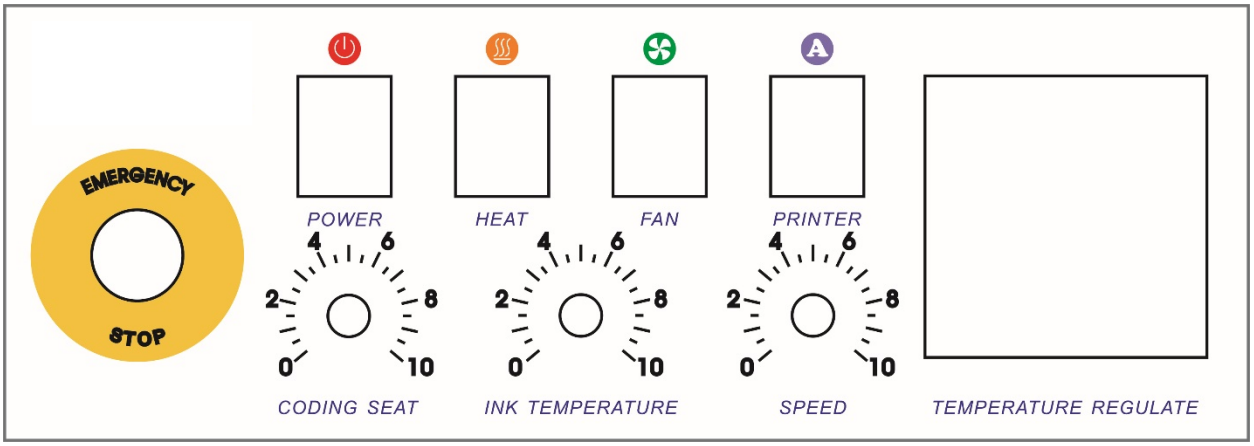
1	under-chassis	16	worktable
2	conveyor table	17	driven roller
3	driving roller	18	adjusting knob for conveyor belt
4	conveyor belt	19	upper holding plate
5	fixed bracket	20	heating block of ink roller
6	slip bracket	21	guiding wheel shaft
7	safety cover	22	guiding wheel
8	adjusting knob for ink roller swing pole	23	guiding belt
9	adjusting knob for embossing wheel	24	heating block
10	housing case	25	lower holding plate
11	control cabinet	26	sealing belt
12	air-break switch	27	vertical shaft
13	feed opening	28	gimbal assembly
14	fastening knob	29	bevel gear assembly
15	fastening nut		



1. caster
2. aerating device
3. aerating pipe
4. fixed bracket
5. fastening knob
6. slip bracket
7. fastening knob
8. conveyor table
9. driving roller
10. conveyor belt
11. guiding wheel
12. guiding belt
13. embossing wheel
14. adjusting knob for embossing
15. silicone wheel
16. driving wheel
17. cooling block
18. heating block
19. left guiding plate
20. splint
21. charging connector
22. guiding plate
23. sealing belt
24. driven wheel seat
25. driven wheel
26. feed opening
27. worktable
28. adjusting knob for conveyor belt
29. driven roller
30. control cabinet
31. round nut
32. connecting shaft
33. driving shaft

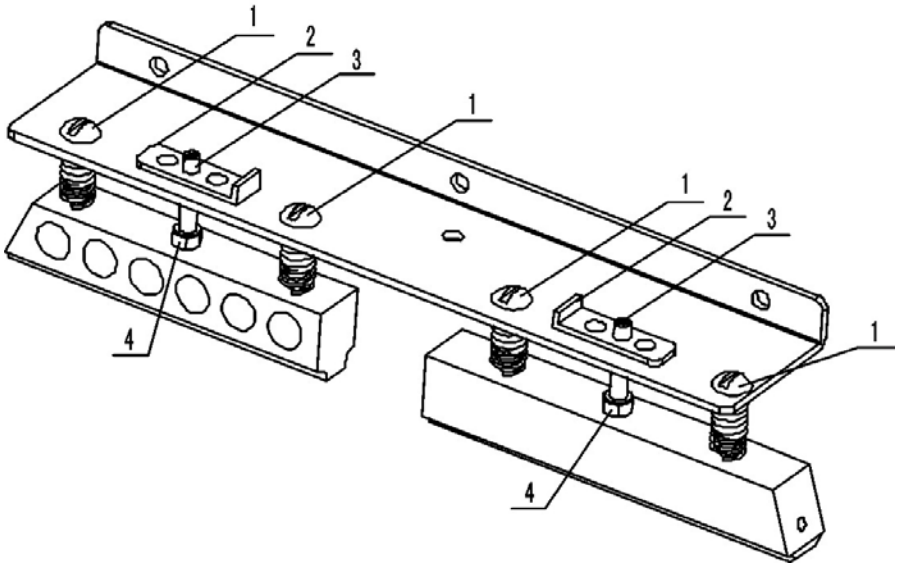
VI. Operation Instruction

1. Control panel (see Diagram 2)



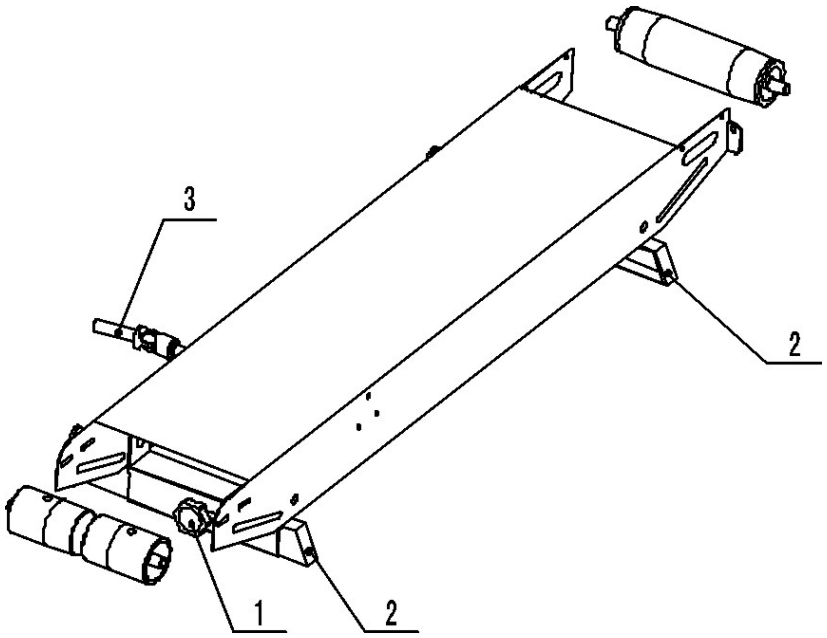
2. Prepare the machine for use

1) This machine is equipped with three crust grounded socket, please check if it is well connected so as to ensure safe operation.
2) First-time use or too long intermission will make the electronic heating elements moistened, so several minutes' low-temperature preheating is necessary before the normal operation.
3) Adjust the conveyor table's height and horizontal location to get required sealing position.
4) According to the external size from sealing line to bag opening, regulate the position of feed opening.
5) According to the thickness of material that to be sealed, adjust the clearance between heating blocks and cooling blocks. Adjust the clearance between two sealing belts by adjusting the stopping flakes, specifically, turn the stopping flake clockwise to raise block or counterclockwise to lower block. The clearance between two sealing belts should be equal to the thickness of packing bag in one layer approximately, which must guarantee the firmness of sealing and high definition of embossing, and ensure suitable length extended from two ends of sealing part. After making adjustment, fix the limiting screws. (see diagram 3)



1. screw 2. stopping flake 3. fastening screw 4.nut
Diagram 3

6. The transverse adjustment of conveyor table: loosen two nuts (1) on two sides. There are three location holes on the foot rest (2). Just insert square head bolts into them as needed, then fasten. After moving the conveyor table outward, please install the connecting shaft (3) saved in the spare parts kit into gimbal. (see diagram 4)



1. adjusting knob 2.foot rest 3. gimbal
Diagram 4

3. Starting procedure

1) Connect the power supply and start switch, indicating light will light, then adjust the speed-adjusting knob and all transmission parts start to run synchronously.

2) Micro-adjust the knob of embossing wheel to make that wheel swivel, after getting a proper pressure, fix limiting screw.

3) Once turn the heating switch on, the green light of the electronic temperature controller will light. According to the material and thickness of the packing bag, adjust the temperature controller to the temperature required, then set the position of heating knob of ink roller. Once the heating blocks and ink roller heating block begin to preheat, Once the heating blocks and ink roller heating block begin to preheat, the machine needs to be started meanwhile and kept running at low speed.

4) That whether it is necessary to turn on the fan for cooling depends on the material and thickness of packing bag.

5) Flatten and align sealing opening, then deliver the bag by aligning the bag opening with the feed opening, when the bag opening is gripped by the sealing belts, which makes the bag move forward automatically, at that moment, please do not push it in or pull it out by force, otherwise irregular sealing or breakdown will happen.

4. If it is found that there is dirt attached to the sealing belt or the heating block, you need to stop the sealer and clear it.

5. Ways of exchanging and adjusting the sealing belt

1) Remove the safety cover, turn stopping flakes on both upper heating block and upper cooling block by 30° to lift these two blocks after the heating block being cooled, then loosen the springs both on embossing wheel and pressing wheel, then remove the guiding belt, so as to make it ready for removing sealing belts. (see diagram 3)

2) Move the driven wheel seat (adjusting block) toward heating block, and remove the sealing belt then.

3) Replace with a new sealing belt and install the guiding belt back.

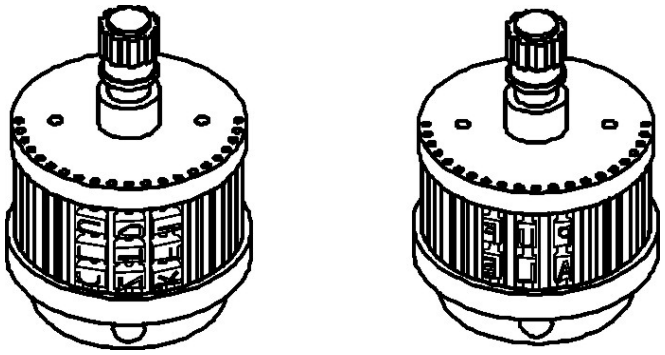
4) Put the driven wheel, heating and cooling blocks, and pressing wheel etc to the original position.

5) Connect the power supply and test the machine, if irregular sealing appears on the belt, you can make adjustment through adjusting screws on driven wheel seat (adjusting block).

6) Install the safety cover. Once the temperature reaches the set temperature, the machine is ready for continuous working.

6. The selection of the type arranging way:

The types in longitude arrange belongs R arrange, while types in axial arrange belong T arrange. (see diagram 5)



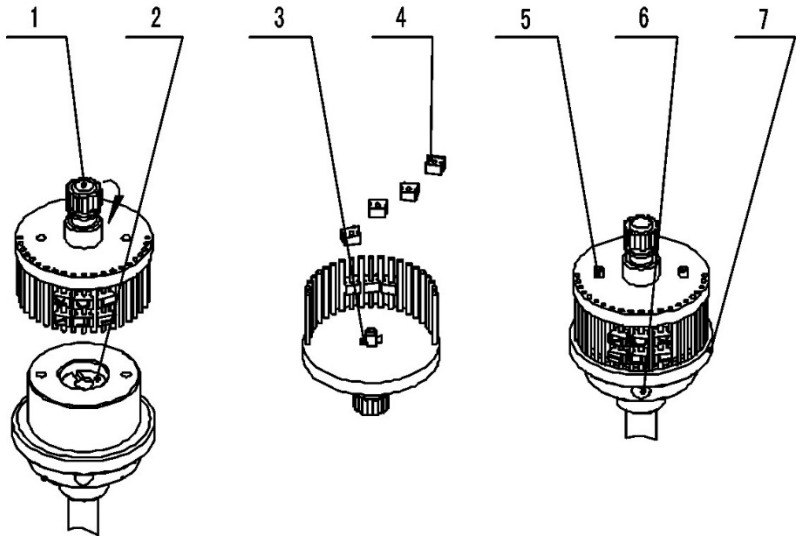
T arrange R arrange

Diagram 5

7. The adjustment of ink roller, printing wheel and silicone wheel

1) Exchanging words on printing wheel(see Diagram 6):

Rotate the holding latch on the printing wheel cover by an angle to take the traverse pin out of the groove, the printing wheel cover will bounce by itself and types can be exchanged after removing its cover, then press the silicone bar on it and install printing wheel cover. At last, insert the traverse pin into the groove on the end cover of printing wheel, and rotate by an angle for fastening.

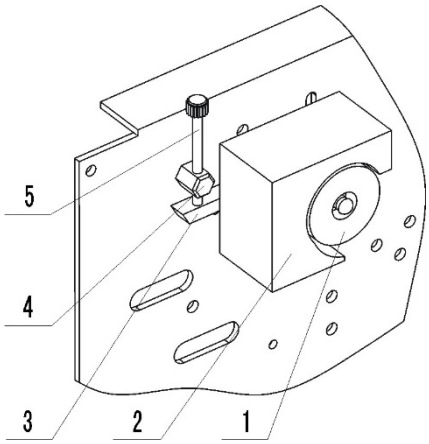


1. holding latch 2. end cover of printing wheel shaft 3.tranverse pin 4. type 5. fixed pin 6. fastening screw for printing wheel 7. printing wheel

Diagram 6

2) The adjustment of the clearance between ink roller and types:

Adjust the adjusting screw (5) for the ink roller's swing pole, rotate the printing wheel, and make the types' surface touch the ink roller's (1)surface slightly. When you use your hand to touch printing wheel, if the ink roller can be easily be driven, it should be ok. (see diagram 7)

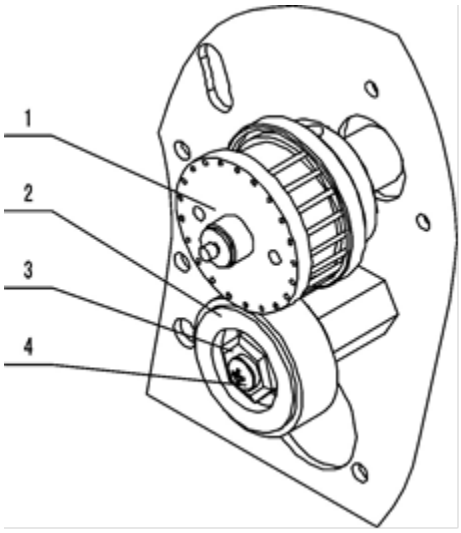


1. ink roller 2. heating block of ink roller 3. swing pole 4. adjusting strut 5. adjusting screw

Diagram 7

3) Adjustment of the pressure between printing wheel and silicone wheel:

When printing work is not in process, the types on the printing wheel must not touch the silicone wheel, and they only touch each other when printing work is in process. Loosen the screw (4) in the front of the silicone wheel, then rotate the eccentric sleeve (3), so as to make the types' surface slightly touch the silicone wheel's (2) surface. If the machine is used to print relatively thicker packing bag, the screw should be loosened accordingly as the pressure can't be too much, fasten the screw after making adjustment.(see Diagram 8)



1. printing wheel 2.silicone wheel 3. eccentric sleeve 4.screw
Diagram 8

4) Temperature adjustment for printing wheel and ink roller:

All the knobs of this machine are set to 0 position before leaving factory, users need to make adjustment by themselves. For a new ink roller, during previous time of use, the temperature should be relatively lower, after a period time of use, the temperature can be raised to higher degree, which can make the deep-seated ink ooze and prolong the ink roller's life-span. When the ink roller reaches the working temperature, you can use a piece of white paper to touch ink surface, as long as it can stick a little ink, it should be ok. The temperature can't be too high or too low.

The ink roller that suits for this machine specified in following table, including colors of white, yellow, red, blue, green, brown and black. If the packing bag needs steam cooking after printing, you should choose the ink rollers of moderate temperature or high temperature, in this situation, the temperature must be set in higher degree accordingly while using.

Model	Outer dia.（mm）	Height（mm）
Low temperature series 120-150℃ （NO:935）	Φ36	16
	Φ36	32
	Φ36	40
Moderate temperature series 135-165℃ （NO:932）	Φ36	16
	Φ36	32
	Φ36	40
High temperature series 150-175℃ （NO:930）	Φ36	16
	Φ36	32
	Φ36	40

9. Adjustment of coding position

Considering length of bag opening, the user can locate the coding position by adjusting coding position switch.

10. Adjustment of line number for printing label

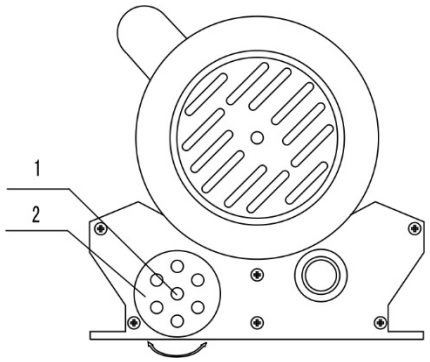
Arrange types within range stipulated in **IV Performance Features** in this manual, then use the provided silicone bar to fix the types in required axial position.

11. Operation instruction for aerating sealer:

1) Insert the power line of the jet pump into the socket at the bottom of the machine, then turn the aerating switch on.

2) Aerating sealer is suitable for packing bulking food and other easy broken goods, which adopts swirl jet pump to aerate filtrated air into packing bag, as the sealing belt is clamped tightly by the aerating opening, you should stop for a while when put the packing bag onto the aerating opening, once the aerated air reaches the required degree, it can be conveyed into the heating area to be sealed.

3) The adjustment of aerated air volume:
Loosen the fastening screw (1) of the aerating opening center at the back of the jet pump, rotate the air intake cover (2) by an angle to adjust the size of the air intake opening, and tightly screw the tight bolt (see Diagram 9).



1)
2) 1.fastening screw 2. air intake cover

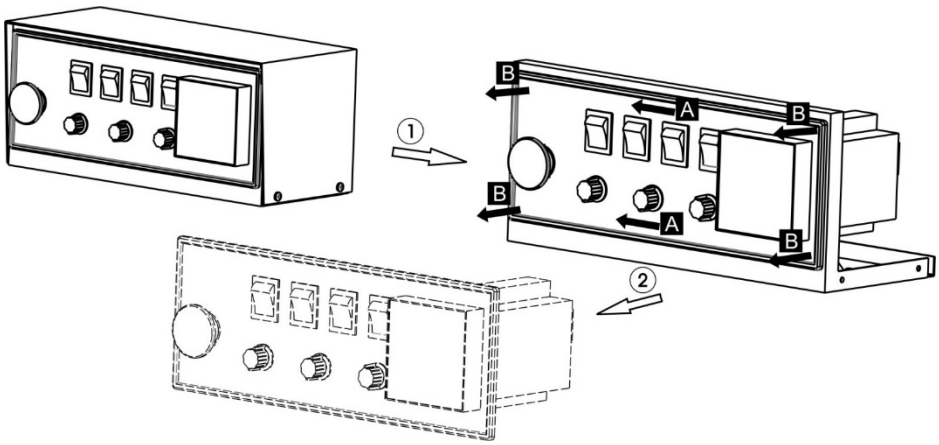
Diagram 9

4) There is an air-filtering room at the lower side of the jet pump, where placed a sponge for filtrating; you should clean or change the sponge if it becomes dirty. Please note that the cover of the filter room should be tightly sealed.

12. The unloading method of the control panel:

(1) Remove the guard cover of the electric control box.

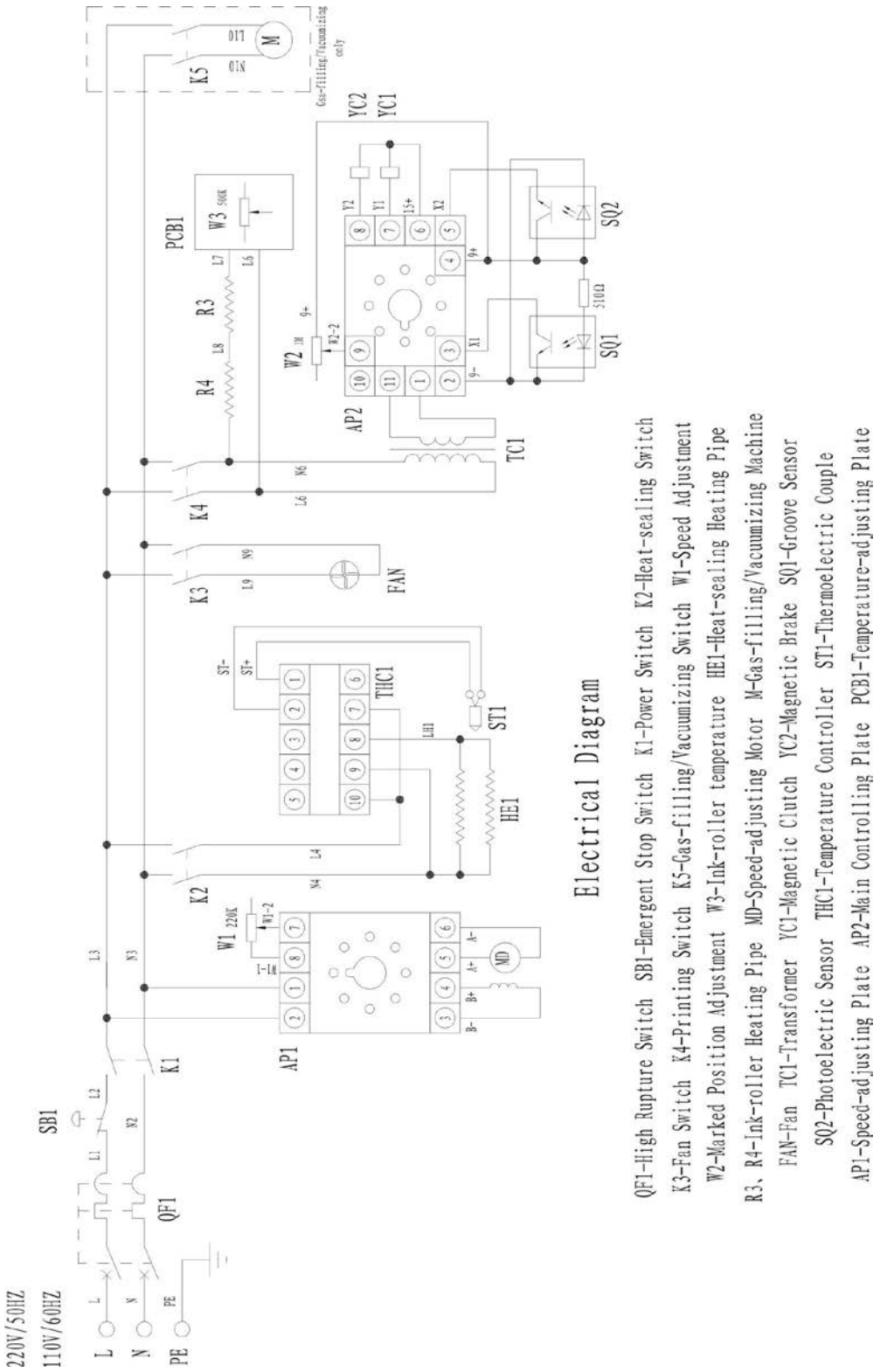
(2) Push the panel along the arrow A (the electric control box is not connected with the control panel now.), then remove the panel along the arrow B.



13. Stop operation

In order to prolong the using life-span of the sealer, please remember, before shutting down the machine, you should return the temperature regulating knob to 0 position first, then turn on the fan, at this time, the temperature on the indicator begins to fall and the sealing belt should still be in state of running. About several minutes' later, when the temperature drops below 100℃, only can you turn off the fan and main power supply.

VII. Circuit Diagram



Electrical Diagram

QF1-High Rupture Switch SB1-Emergent Stop Switch K1-Power Switch K2-Heat-sealing Switch
K3-Fan Switch K4-Printing Switch K5-Gas-filling/Vacuumizing Switch W1-Speed Adjustment
W2-Marked Position Adjustment W3-Ink-roller temperature HE1-Heat-sealing Heating Pipe
R3、R4-Ink-roller Heating Pipe MD-Speed-adjusting Motor M-Gas-filling/Vacuumizing Machine
FAN-Fan TC1-Transformer YC1-Magnetic Clutch YC2-Magnetic Brake SQ1-Groove Sensor
SQ2-Photoelectric Sensor THC1-Temperature Controller ST1-Thermoelectric Couple
AP1-Speed-adjusting Plate AP2-Main Controlling Plate PCB1-Temperature-adjusting Plate

VIII. Breakdown Drawing of Machine Body

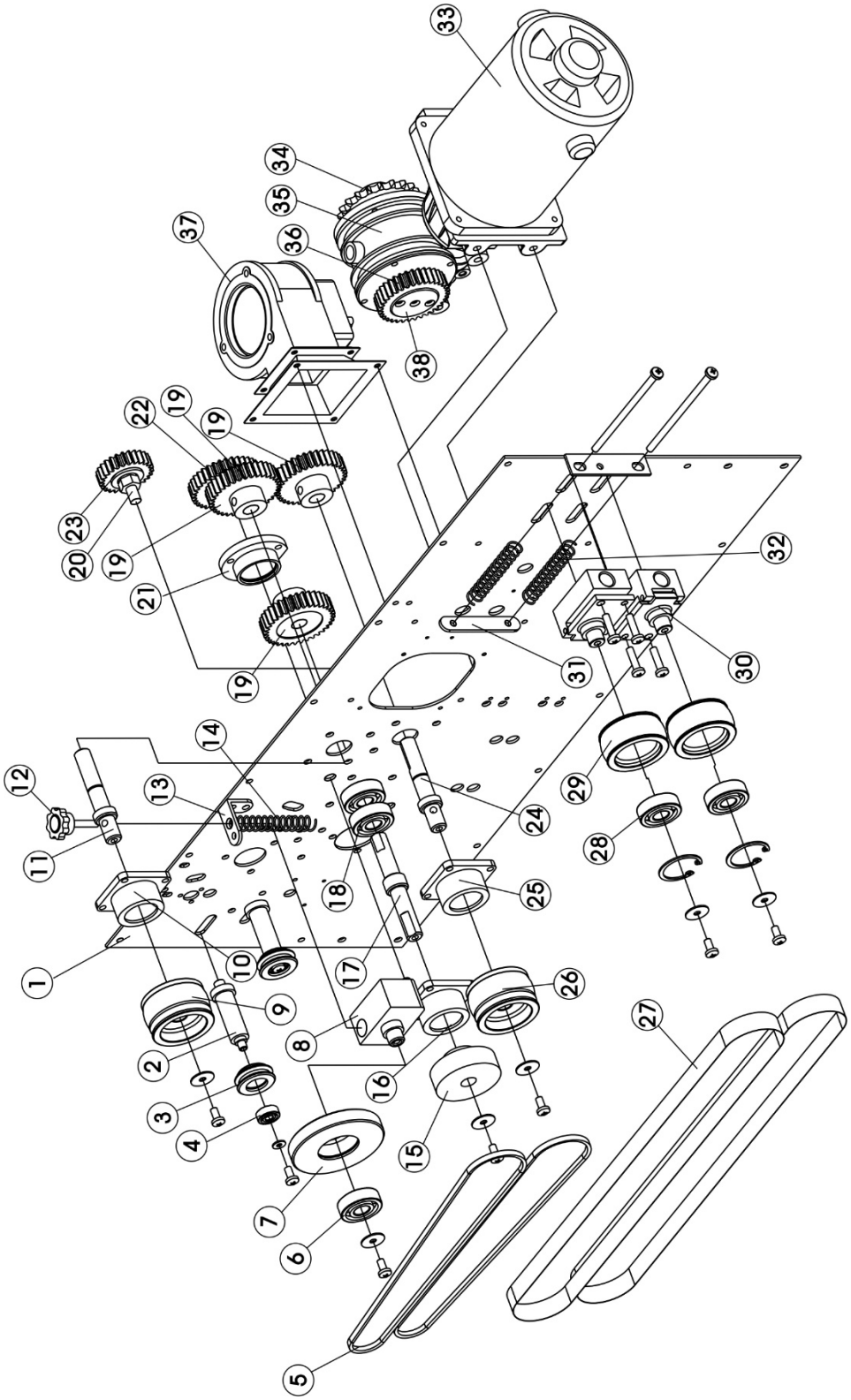


Diagram 11

Item	Part number	Quantity	Description
1	105211	1	bottom board
2	101015	2	guiding wheel shaft
3	105023	2	guiding wheel
4		2	bearing
5	910801	2	guiding belt
6		2	bearing
7	101018	1	embossing wheel
8	101017.1	1	bearing seat
9	105022	1	driving wheel
10	101026	1	bearing seat of driving wheel
11	101027	1	driving wheel shaft
12		1	adjusting knob for embossing wheel
13		1	hood support
14		1	adjusting spring for embossing wheel
15	101036	1	silicone wheel assembly
16	105041	1	silicone wheel seat
17	201010	1	silicone wheel shaft
18		2	bearing
19	105030	3	connecting gear
20			
21	105013	1	bearing seat for connecting shaft
22	105030	1	connecting gear
23	105011	1	medium gear
24	101027	1	driving wheel shaft
25	101017	1	bearing seat of driving wheel
26	105022	1	driving wheel
27	910903	2	sealing belt
28		2	bearing
29	101024	2	driven wheel
30	101023.4	1	adjusting seat for driven wheel
31	101062	1	connection piece
32		2	spring of driven wheel seat
33	921003	1	motor（220V 50W）
34	A10503	1	sprocket
35		1	flange assembly
36	105050	1	output gear
37	921102-2	1	fan assembly (CY063)
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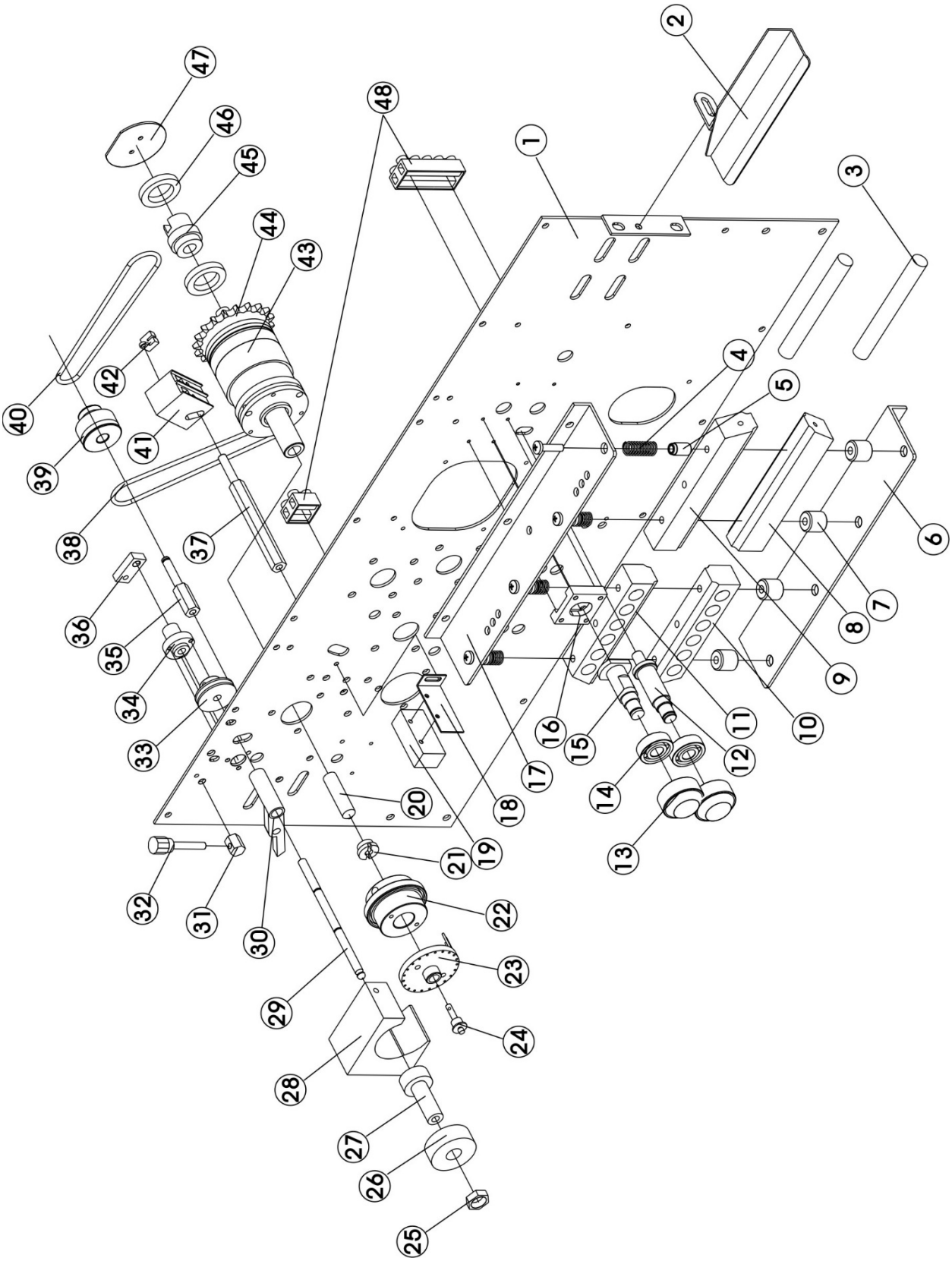
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Diagram 12

Item	Part number	Quantity	Description
1	105003	1	bottom board
2	101035	1	feed opening
3	921303	2	heating pipe (heat for sealing)
4		4	spring of copper block
5		4	guide sleeve of upper holding plate
6	105005	1	bottom holding plate
7	101050	4	heating block support
8	930301	1	upper heating block
9	930301	1	bottom heating block
10	930302	1	upper cooling block
11	930302	1	bottom cooling block
12	105008	1	bottom pinch roller shaft
13	105009	2	pinch roller
14		2	bearing 24×8
15	105007	1	upper pinch roller shaft
16	105017	1	slide carriage
17	105005	1	upper holding plate
18		1	support for photoelectric sensor
19	940705	1	photoelectric sensor
20	921301	1	heating pipe Φ10 110V 40W
21	201015	1	end cover of printing wheel shaft
22	201013	1	printing wheel seat assembly
23	201014	1	printing wheel cover
24	201016	1	holding latch for printing wheel
25		1	straining ring for ink roller sleeve
26	911005	1	ink roller（Φ35×32）
27	201008	1	ink roller sleeve
28	201002	1	heating block of ink roller
29	105036	1	ink roller shaft
30	201007	1	swing pole of ink roller
31		1	adjusting post for ink roller’s swing pole
32		1	adjusting knob for ink roller’s swing pole
33	105039	1	pulley of ink roller shaft
34	201006	1	seat for ink roller swing pole shaft
35	105035	1	middle pulley shaft
36		1	pull rod
37	105031	1	support for brush
38		1	small adhesive tape Φ30×60
39	105032	1	middle pulley
40		1	small adhesive tape Φ30×50
41	920423	1	carbon brush holder

Item	Part number	Quantity	Description
42	940702	1	groove sensor
43	A10501	1	electromagnetic clutch assembly
44	105021	1	driven sprocket
45	201004	1	slip-ring core
46	201003	2	copper slip ring
47	201024	1	anti-dazzling screen
48	20415-32	3	connecting terminal

IX. Breakdown Drawing of Conveyor

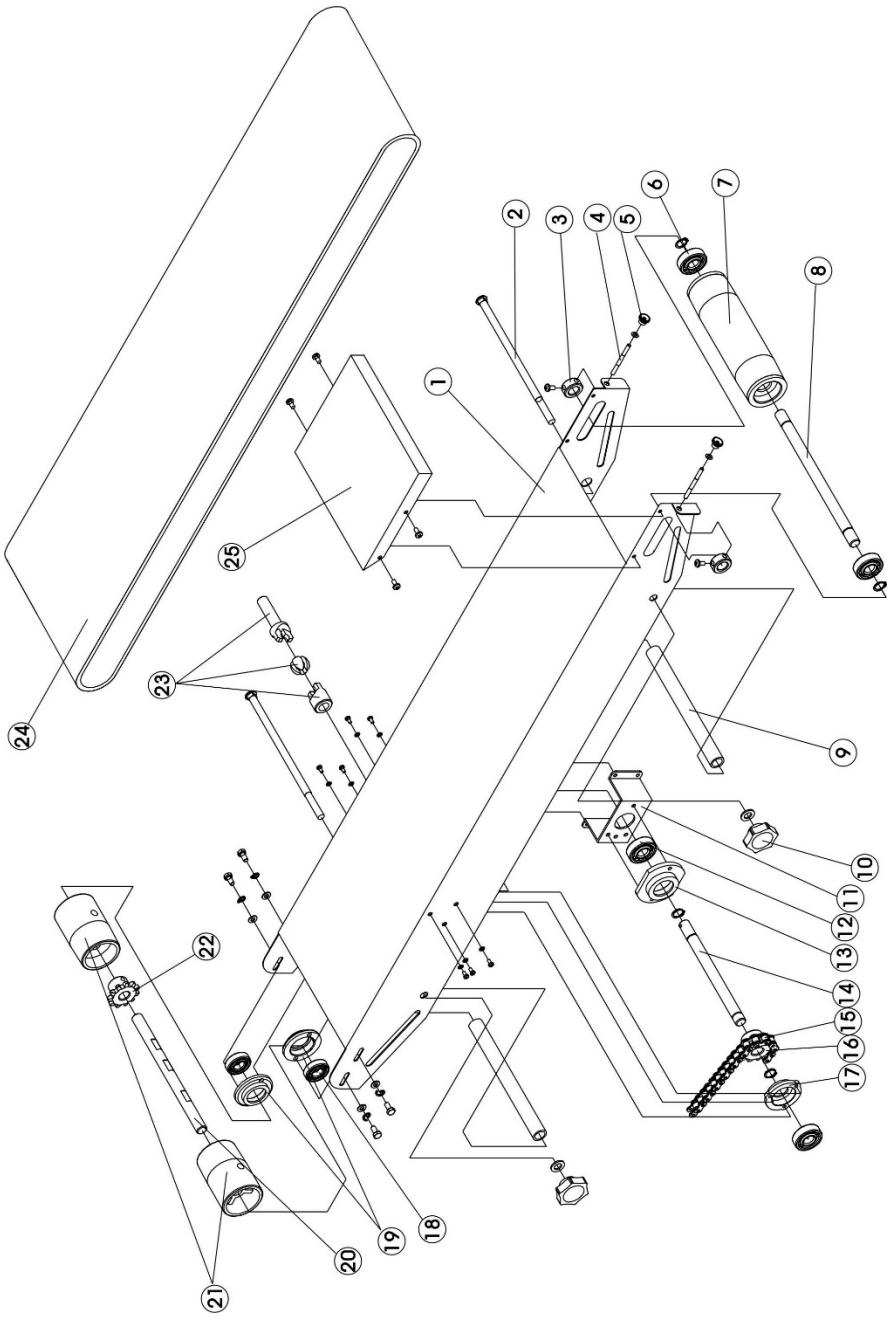

Diagram 13

Code	Part number	Quantity	Description	Remark
1	910701	1	Conveying table （980）	
2	GB12-1988	2	oval head square neck bolt	M8x160
3	101007	2	FR-770 conveyor adjusting block	
4		2	stud bolt	M5x55
5	930113	2	Trandfer table adjusting knob	M5
6	935602-01-1	2	Bearing 6002N	Φ32xΦ12x10
7	101005	1	FR-770 rear roller	
8	101008	1	FR-770 conveying table rear shaft	
9	101049	2	Spacer FR-770	
10	9301109-11	2	674 knob	M8
11	105014	1	Central shaft plate FRM-980	
12	935602-01-1	3	Bearing 6201-Z	Φ38xΦ12x10
13	101003	1	Conveying table central shaft support I	
14	105015	1	Conveying table central shaft	
15	101010	1	Conveying table sprocket wheel	
16	930603-16	1	Driving chain	
17	101013	1	Conveying table central shaft support II	
18	935602-01-1	3	Bearing 6201-2Z	Φ38xΦ12x10
19	101003	2	Front roller shaft bearing support (two holes)	
20	101002	1	Front roller shaft	Φ12x197
21	101012	2	Front roller	
22	101010	1	Conveying table sprocket wheel	
23	105037	1	980 Gimbal assembly	
24	910706	1	Conveyor 1800x135	1800x135x2
25	101006	1	FR-770 working table	

X Breakdown Drawing of Aeration Assembly

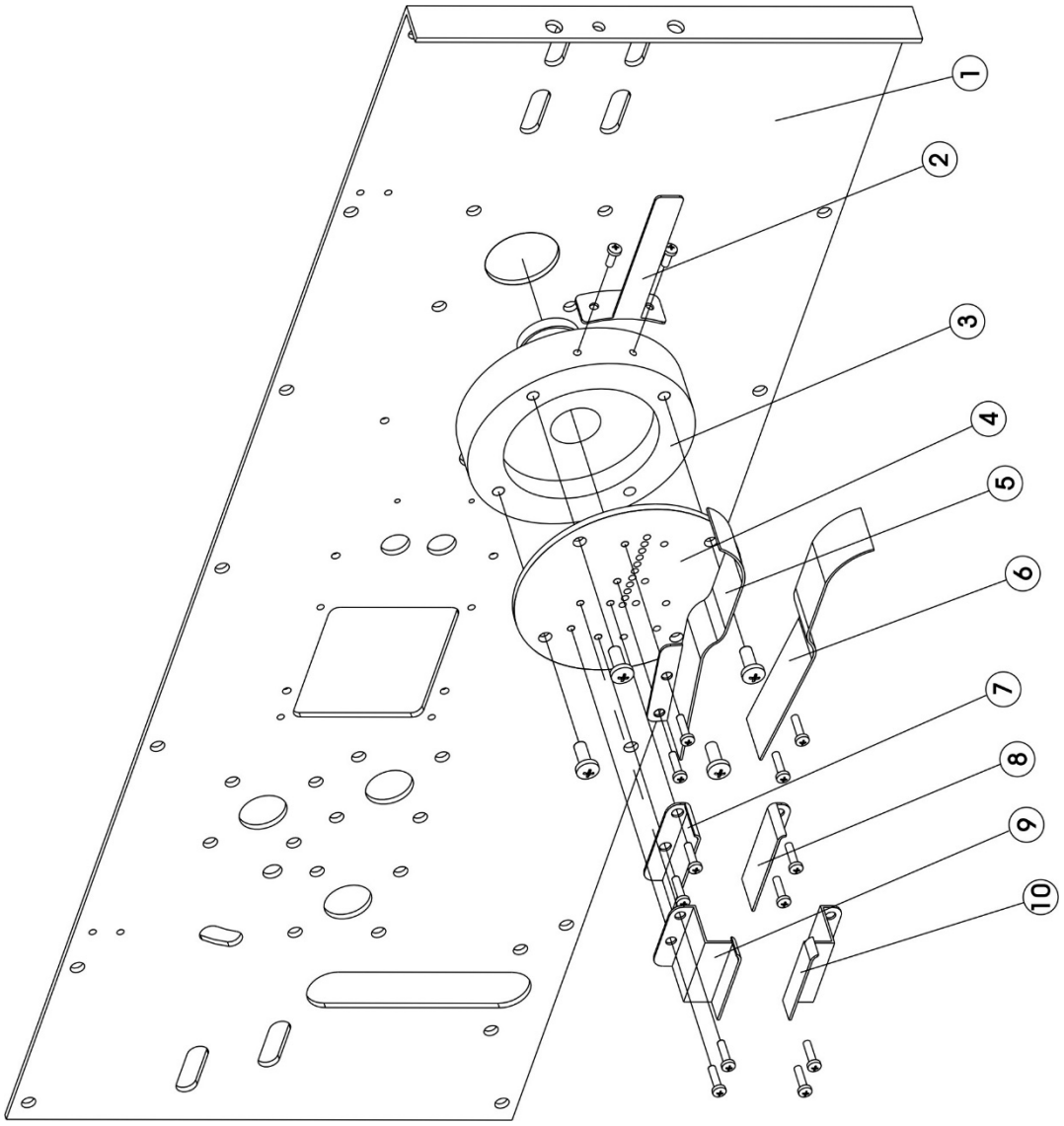

Diagram 14

Code	Part number	Quantity	Description
1	103103	1	Bottom plate
2	103013	1	Receptive plate
3	103005	1	Charging connector support
4	103006	1	Charging connector cover
5	103008	1	Upper directing plate
6	103008	1	Lower directing plate
7	103008	1	Upper splint
8	103008	1	Lower splint
9	103008	1	Upper guide plate
10	103008	1	Lower guide plate

XI Troubleshooting

Problem	Reason	Solution
Sealing belt is off-tracking.	Driving wheel shaft is not parallel to driven wheel shaft.	Adjust two adjusting screws on driven wheel seat.
Sealing belt is easy to broke.	1.Too much tension on sealing belt. 2. Sealing belt is off tracking. 3. Crease on sealing belt. 4. Adhesive film or other dirt attached to sealing belt surface. 5. Sealing belt is easy to burn.	1. Adjust the vertical adjusting screw on driven wheel seat, so as to make sealing belt less loose. 2. （see the point above）. 3. No crease on sealing belt. 4. Clean its surface in time. 5. Clearance between two heating blocks is too small or temperature is too high.
Embossing is not clear	1. Embossing wheel is worn out. 2. Pressing spring on embossing wheel is not tightened to enough degree.	1. Replace embossing wheel 2. Adjust the embossing wheel's tightening spring
There is resistance when the sealing belt is conveying.	The clearance between heating blocks or cooling blocks is too small, the friction is too much.	Adjust the clearance between sealing belts properly, which should be about thickness of packing bag in one layer, so that not only ensure the strong sealing and clear printing, but not make the two ends of sealing part extend too long.
There is block or fold phenomenon when the packing bag is conveyed to pressing wheel or embossing wheel.	Too much pressure caused by pressing wheel or embossing wheel.	1. Adjust the pressing wheel or embossing wheel to proper pressure, so as to make the clearance between two sealing belts be about thickness of packing bag in one layer. So that not only ensure the strong sealing and clear printing, but not make the two ends of sealing part extend too long. 2. Adjust limiting screw after adjusting clearance.
Conveyor belt is off-tracking.	The driving roller shaft is not parallel to driven roller shaft.	Adjust two adjusting screws of driven roller shaft (rear shaft) on conveyor.

Conveyor belt and sealing belt don't move synchronously.	Too small tension on conveyor belt.	1. Tighten the chain of driving roller shaft(front shaft) and middle shaft properly. 2. Tighten the conveyor belt properly.
Ink roller printing mechanism doesn't work.	1. The power supply is not connected. 2. Main control PC board is not inserted in place or poor contact. 3. Main control PC board is damaged.	1. Check whether the power line is connected and indicating light is on. 2. Check whether plug for PC board is inserted in place or wire end falls off. 3. Check and replace PC board.
Printing wheel doesn't work.	1. Start sensor's touching head is blocked. 2. Start sensor is not clean, whose hole is blocked by dust. 3. Main control PC board has been damaged 4. Round pin on clutch falls off or is damaged. 5. Electromagnetic clutch's wire is broken.	1. Clean the obstacle. 2. Clean the dust on sensor's surface. 3. Check and replace PC board. 4. Repair round pin. 5. Repair clutch.
Printing wheel doesn't stop.	1. Sensor (groove sensor) is damaged, moved, or its surface covered by dust. 2. Main control PC board is damaged.	1. Replace or correct position of sensor or clean its surface. 2. Check PC board and replace it.
No heat for ink roller heating block or printing.	1. Heating pipe or wire is damaged 2. Heating PC board is damaged 3. The potentiometer on knob is damaged 4. Carbon brush seat is not in place. 5. Carbon brush is damaged	1. Replace heating pipe. 2. Replace PC board. 3. Replace potentiometer. 4. Adjust and tighten nut then. 5. Replace.
The temperature of heating block for ink roller printing mechanism is out of control.	The relay for temperature control PC board is damaged.	Check and replace temperature control PC board.
The printing position is out of control.	1. Tightening screw on printing wheel is loose. 2. Main control PC board is damaged.	1. Tighten the screw. 2.Check and replace PC board.
Control panel loosen or drop.	strenuous vibration during transportation.	Push the panel to its original location.

XII. Spare Parts List

Item	Part number	Specification	Unit	Quantity
1	201008	ink roller sleeve	pc	1
2	201020	straining ring for ink roller sleeve	pc	1
3	910152	silicone ring	pc	1
4	910153	silicone hold-down strip	pc	2
5	910353-50	O type ring（Φ50X3.1）	pc	4
6	910353-80	O type ring（Φ80X3.1）	pc	4
7	910805	guiding belt (598X4.5X3.5)	pc	4
8	910903-2	sealing belt (810X15)	pc	20
9	911005-01	ink roller (black, Φ35X16)	pc	2
10	920205	power line	pc	1
11	920452-02	carbon brush (for ink roller, 6X8X20)	pc	2
12	921301	heating pipe for ink roller (40W/110V,Φ10X30)	pc	2
13	930101	cross screwdriver	pc	1
14	930102	slotted screwdriver	pc	1
15	930121	2mm inner hexagon spanner	pc	1
16	930122	3mm inner hexagon spanner	pc	1
17	930124	5mm inner hexagon spanner	pc	1
18	930132	8-10 solid wrench	pc	1
19	930133	12-14 solid wrench	pc	1
20	930309-21	English types	case	1
21	930403	nipper	pc	1
22	940801-06	groove nipper	pc	1
23	940801-01	main control PCB assembly （printing mechanism）	set	1
24	940801-11	speed-regulating PCB assembly （printing mechanism）	set	1
25	940801-02	temperature-regulating PCB assembly （printing mechanism)	set	1

Warranty Card

1. According to the national regulates, we promise three guarantees to users since the day the products sold. The details are as following:
   1.1 The users should read the manual in details and operate according to the manual.
   1.2 Warranty time: one year for machine parts, six months for electrical components.
   1.3 During the warranty time, we don't guarantee the problems if the user operate and maintain the machine without the instruction or remove the parts privately. We do reparation for the machine, while the buyer pays for the repairing.
2. Please check the model type of the machine according to the invoice and the warranty card after purchasing. If the model type doesn't unify with each other please contact us promptly and we will correct it.
3. Please keep safely the purchasing invoice and the warranty card. There is no replacement of these two if lost. Private modification is invalid. Please present the invoice and the warranty card when repairing.

User			
User's detailed address			
Area code and telephone		Area code and fax	
Post code		Contact	
Distributor			
Model type		Machine No.	
Purchasing date		Invoice No.	

Maintenance record

Date	Problems	Maintenance condition	Repairer

Note: The warranty card is valid only when sealed by the distributor.