



CE-6800-HVE

Continuous Sealer Operation Manual



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Preface

This instruction manual has following content:

- Instruction on the product
- Precaution on safety
- Transportation and storage
- Installation
- Operation and commissioning
- Maintenance
- Troubleshooting
- Spare parts

This manual gives a description of the installation and use of the product, and it includes following contents: the product's transportation, storage, installation, operation conditions, maintenance, troubleshooting and repairing.

Notice:

- Please read this manual carefully and understand it thoroughly before using..
- Make sure this manual is possessed by the operator or the managerial personnel of e this product.
- Please retain this manual after reading and make sure it is available for reference if needed.
- Any questions, please contact the manufacturer or distributor.

Description:

- Before using the product* please read this manual carefully and fully understand it.
- Please ensure that operators or equipment managers who will eventually use this product are equipped with this manual.
- After reading, please keep this copy in a safe place and keep it within easy reach at all times for easy reference.
- Please contact the manufacturer or supplier with any questions.
- Responsibilities:
- This manual is written carefully and for possible mistakes or the mistakes due to misunderstanding, the manufacturer does not take any responsibility.
- The manufacturer will not be responsible for the damage or problems caused by having not adopted the specified spare part.
- The manufacturer keeps the right of amendment on the parameter or parts without prior notice. ● All rights are reserved by manufacturer. And without written approval, printing of any part of this manual is forbidden. If found, the company reserves the right to pursue legal responsibilities.

Terms:

Sealing belt (Teflon belt): to make the bag be out of touch of heating block to avoid influence the sealing effect.

Heater: consist of copper block and heating tube.



1 Product Introduction

1.1 Application

This machine is suitable for sealing plastic film and making bags. Suction packaging, inflatable packaging or inflatable packaging after exhaustion can be used for food, fruit, seeds, aromatics, pharmaceuticals, chemical products, electronic products, precision instruments and meters, rare and precious metals, etc. , can be filled with various inert gases. The packaged product is reduced in size and convenient for storage. It can also prevent oxidation, mildew, moth, corruption, moisture, and extend the storage period of the product to a certain extent. The inkjet control operation system adopts the free and open source Linux operating system, which is widely used in the world, has good portability, and the system has strong stability and scalability, and can run stably for a long time, Customers can freely adjust the size and length of the printing font according to their own needs, and the printing content is rich, and the machine has a sealing counting function, which can be widely used in food, medicine, chemical, daily use, agriculture and other industries. It is the best sealing equipment for batch product packaging in factories and shops.

1.2 Product feature

- This machine adopts sponge synchronous belt clamping bag delivery, with uniform clamping pressure and good airtight effect. The air nozzle extends into the bag to form an independent working space.
- The machine has the advantages of high efficiency for continuous sealing, reliable sealing quality, superior structure and simple operation etc-
- Inflatable air pressure can be adjusted, which can be applied to a variety of different sizes of packaging bags, and the gas to be filled can be selected by the customer.
- This machine is equipped with multiple functions such as pumping (charging), sealing, and printing, which can meet the needs of customers with multiple functions in one machine.
- Air conditioning has multiple modes to choose from, which can be pumped separately, inflated alone, and inflated after pumping.
- Touch screen control, simple interface, easy operation, you can freely adjust the value according to your own needs. Vacuum pressure gauge display, you can directly observe the pressure data, clear and intuitive.
- High-precision linear guide rail bearing, smooth operation, ensuring stability and no shaking, cylinder movement, simple mechanism, stable structure, and quick action.
- This machine adopts intelligent inkjet equipment. Customers can adjust the size and length of the printing font at will according to their own needs. The printing content is rich, and it can print text, date, symbol, LOGO image, two-dimensional code, barcode and other content. One-click language switching, support for more than 20 languages (including corresponding language input methods), support for any language customization.



1.3 Operation principles

After power supply being connected, electrothermal elements start to produce heat, which leads to rapid temperature rise of both upper and lower heating blocks, Required temperature and speed can be got through adjusting temperature controller and speed-adjusting mechanism. Flatten the opening of the plastic packaging bag, hold both sides of the bag mouth with both hands, put the air nozzle into the bag, and slowly move to the inside of the machine. The conveyor belt transports the plastic packaging bag together with the inner gas nozzle, the gas in the bag is discharged through the gas nozzle (filled with gas through the gas nozzle), and then the gas nozzle is pulled out from the inside of the plastic packaging bag, and the plastic packaging bag is sealed by the conveyor belt. The part is sent between the upper and lower sealing belts in operation, and the sealing part of the plastic bag is sent into the heating zone under the clamping of the upper and lower sealing belts. The plastic film is softened by heat and bonded by the extrusion of the pressure roller. The plastic sealing part is sent to the cooling zone under the clamping of the sealing belt to cool and set, and is rolled by the embossing wheel to make the sealing part of the plastic bag roll out stripes or net patterns, and finally pass through the inkjet printer to print the production date, QR code, and bar code etc., the sealing machine transmission part and the printing transmission part are driven by a motor to drive the sealing belt, guide belt and conveyor belt to run synchronously.



1.4 The main technical parameters

Item	Parameter	Model
		CE-6800
		Intelligent Ink-jet filling and pumping continuous band sealer
	Voltage(V/Hz)	AC 220/50 110/60
	Air Compressor(V/Hz)	0.5 (Equipped by user)
	Diameter of Air Supply Pipe (mm)	12
	Diameter of Charging Air Source Connecting Pipe (mm)	8
	Motor power (W)	180
	Sealing power (W)	400x2
	Speed (m/min)	0-24
	Sealing width (mm)	10
	Temperature range (°c)	0-300 (Stepless adjustable)
	Distance from sealing center to conveyor (mm)	0-40

Distance from base plate to interior conveyor (mm)	100-142
Max distance from sealing center to bag mouth (mm)	35
Min distance from sealing center to material (mm)	40
Maximum Tilt Angle of the Conveyor	15
Conveyor Size(LX W) (mm)	1730 x 300
Overall conveyor load (Kg)	15
Bag width range (mm)	80-400
External dimensions (LxWxH) (mm)	1730 x 660 x 1030
Net weight (Kg)	152
Inkjet technical parameters	



Operating System	Linux
Size of Touch Screen(inch)	5 inch
Touch Screen Resolution	
Processor	Quad-core high-performance processor, main frequency up to 1.5GHz (fast response, smooth operation)
Memory	
Printing nozzle	TIJ2.5 Hot foam nozzle
printing letter height	1.5-12.7mm
Printing length	unlimited
Max. Printing line	6 lines
Ink type and volume	oily/42ml
Languages in Touch Screen	Chinese, English, Arabic, Turkish, Spanish, Portuguese, Korean, Russian (support customization)
Printing Content	Chinese, English, numbers, symbols, graphics, QR codes, barcodes, variable dates, variable counts, variable QR codes Chinese, English, Numbers, symbols, graphics (support arbitrary pictures without conversion format), QR code, bar code (custom content, real-time variable barcode), variable date (custom), a variable count (custom), variable QR code (real-time variable data printing system, online system are both customized)
Counting	0-100000
printing volume of ink cartridge	about 200,000 times (take the production date of height 4mm and length 30mm as an example)
Printing content storage	can store 200 pieces (each piece of printing content has a separate counting storage function)
Printing font	adjustable (font can be customized)
External Terminal	USB
Online operation	Optional (one host can control 1+N units)



1.4 Product shape structure





2 Security, Preparation and Examination

2.1 Preparation before operating

This manual contains an elaborated description of carrying, storage, installation, activate, operation condition, maintain, troubleshooting of the product.

The installation of the machine is suggested to be operated by trained professionals.




Please be sure to follow the maintain instruction

- Please be sure to read the manual and fully understand it before operating the machine.
- If you have any problem with security, please contact the manufactory or your supplier.

2.2 Safety instruction

- Please confirm the voltage of this machine in order to avoid mistakes.
- This machine uses the single-phase three wire system, The yellow-green double colored wire is the protective ground wire, it has to be get connected to ground separately and steady, it cannot be removed. The voltage wire should not be compressed, it ought to be rolled up and keep it in a cool and dry place.
- Forbidding to touch the electric assembly after the machine get connected with power.
- Forbidding to touch any transmission parts while operating the machine, in order to avoid getting wounded.
- Forbidding to open the security devices such as chassis and cover after activating the machine.
- Forbidding to touch the heating elements, solid-ink heating elements in order to avoid getting scald.
- In order to avoid to get scald, please let the machine sufficient cooling before maintaining.
- Forbidding to operate the machine under a wet or corrosive conditions.
- Please do not change components of machines at will.
- Please keep the inside and outside of machine clean, removing the burrs on the surface of sealing area in time.
- Ought to refuel and change oil the worm gear case on schedule, and add lubricant oil to the gears of gear wheel and chain wheel. (YP7408 semi-fluid gear oil)
- The power should be cut off when the machine is out of using. If the operator leaves the machine, then the machine must be power off.
- Please keep the manual in order to consult.

For Example:

	DANGER! Ignoring this safety precaution can result in serious or fatal injury accidents.
	WARNING! Ignoring this safety precaution can result in a serious injury.
	WATCH OUT! Ignoring this safety precaution can result in personal injury or property damage.



2.3 Environment condition

This product is suggested to be operating in a condition of normal temperature and indoor. If your operating condition is tough (such as an environment condition with corrosively air, temperature higher than 30°C or lower than 5°C, please contact the manufactory and your supplier.

3 Installation

Before the operation of installation, please read this manual. By reading this manual, the things about how to install, start, and usage and maintenance of this machine can be learn. If there are problems caused because of not referring to this manual, the manufacturer will not take any responsibility.

The manufacturer hopes the client will use the machine without breakdowns for a long time. If there is any problem, please contact with the supplier or the manufacturer.

3.1 Essential condition for installation

**CAUTION! HARM TO MACHINE!**

Without essential condition for installation, machine will be damaged.

Be careful injured!

Please obey the essential condition for installation.

Please assure the installation environment satisfy basic safety regulations.

3.2 Installation environment

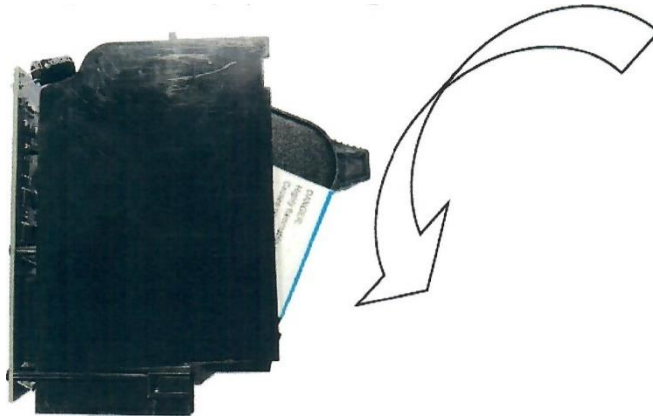
- No inflammable and explosive gas is allowed.
- Environment temperature: 5-30C. If need operation under other temperature, please confirm with supplier or dealer first.
- Environment pressure , standard atmospheric pressure
- Assure power environment satisfy requirements (refer to nameplate).
- No inclined is an important factor of the machine successful operating.
- Leave enough space to assure good ventilation for heat dissipation At least 10cm interspace.
- Machine cannot be exposed to heat source and steam device directly. (such as steamer, dish-washing machine or stove)
- Assure enough space to replace the easy worn spare parts.



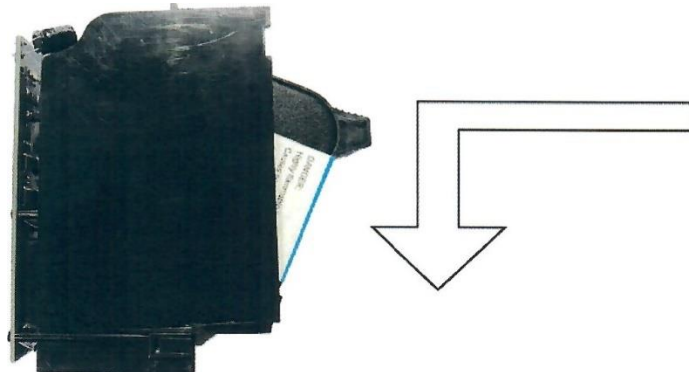
3.3 Installation steps

Ink cartridge installation steps

Take off the ink cartridge clip (be sure to keep the clip), pinch the end of the ink cartridge, and insert the nozzle of the ink cartridge into the inkjet printer along the track.



Align the nozzle of the ink cartridge with the nozzle hole of the inkjet printer, push the ink cartridge forward, and the ink cartridge will go down along the pouring slope above the marble.



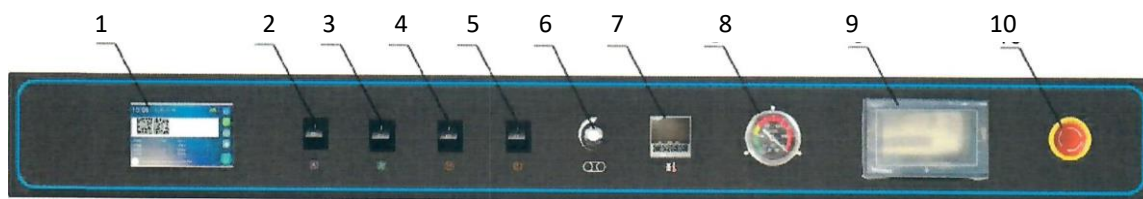
Press the tail of the ink cartridge and press it down. When you hear the sound of the marbles, the nozzle of the ink cartridge is aligned parallel to the head hole of the inkjet printer, and the ink cartridge is successfully inserted.





4 Start and Adjustment

4.1 Control panel



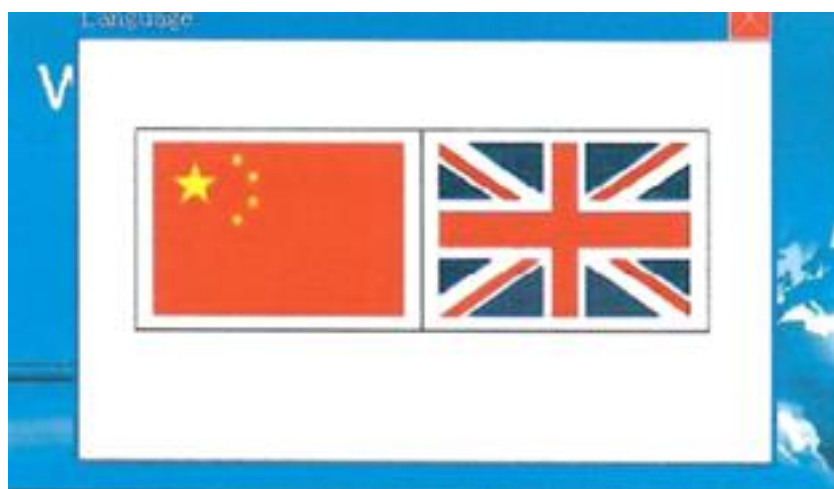
NO	Name	Description
1	Coding touch screen	Used to set the working parameters of the inkjet printer
2	Printing switch	You can choose to turn on or off the coding function.
3	fan switch	You can choose to turn on or off the fan.
4	heat seal switch	You can choose to open or close the heat sealing function.
5	switch	used to turn on or off the power of the machine.
6	speed knob	Adjust conveyor belt running speed
7	Temperature Controller	Adjust the temperature of the heating block.
8	pressure gauge	display pressure
9	inflatable touch screen	It is used to set the working parameters of pumping and charging
10	Emergency stop switch	It is used to terminate the operation of the machine, and the machine can be completely stopped by pressing the emergency stop button at any time. After pressing the emergency stop button, the machine will stop all work.



4.2 Start Page

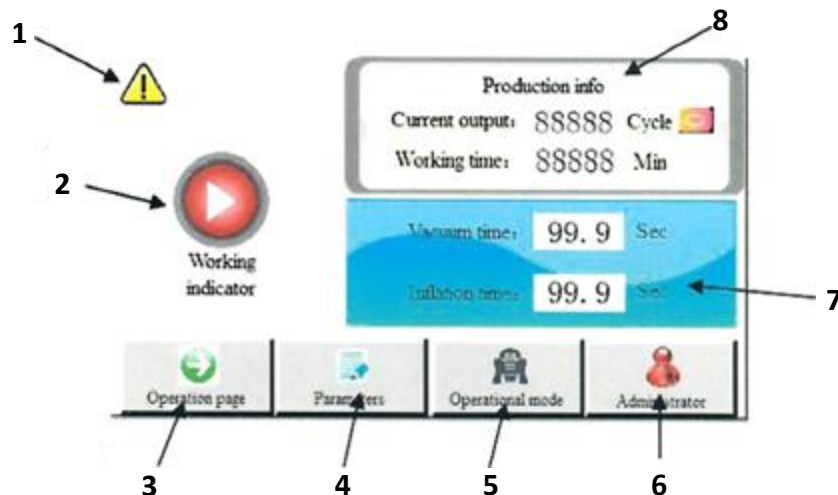


Click on the screen and the language selection window will pop up as shown below.



Click the language button in the window bat to enter the corresponding language running page.

4.3 Operation page



4.3.1 Equipment emergency stop display

Number 1: It will not be displayed when the emergency stop switch of the equipment is not pressed, and this pattern will be displayed after it is pressed;

4.3.2 Working indicator

Number 2: The indicator light is red when the device is in the shutdown state, and green when the device is in the running state;

4.3.3 Run page

Number 3: Click this button to jump to the running page

4.3.4 Parameter setting

Number 4: Click this button to jump to parameter setting

4.3.5 Operation mode

Number 5: Click this button to jump to the running mode

4.3.6 Administrator interface

Number 6: Click this button to jump to the administrator interface

4.3.7 Parameter preview

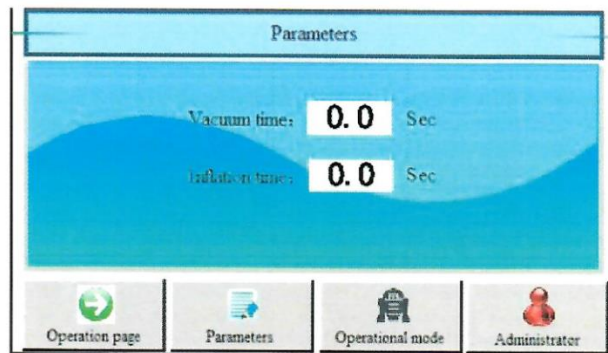
Number 7: Display the set time parameters.

4.3.8 Equipment emergency stop display

Number 8: Display the current number of sealed bags of the equipment and the running time of the equipment. The current number of sealed bags can be reset by pressing the button behind;



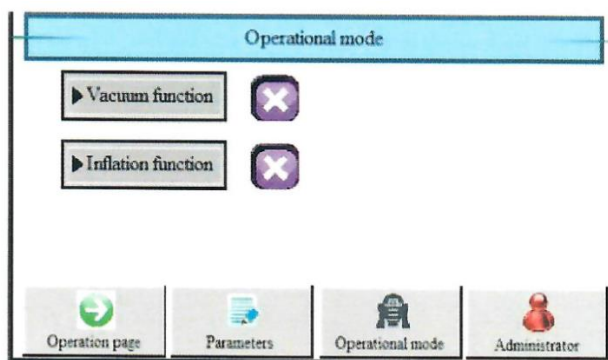
4.4 Parameters



Pumping time: Set the time for continuous pumping.

Inflation time: Set the time for continuous inflation.

4.5 Operational mode



4.5.1 Extraction function

Click the button to select the function, X means the air extraction function is not turned on, ✓ means the air extraction function is turned on, and the air nozzle will perform air extraction during operation after enabling it;

4.5.2 Inflatable function

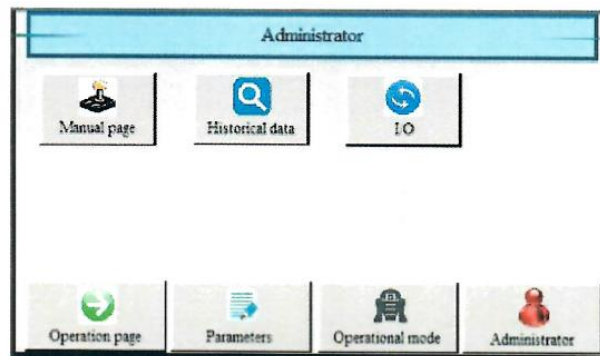
Click the button to select the function, X means the inflation function is not turned on, ✓ means the inflation function is turned on, and the air nozzle will inflate during operation after enabling it;

4.5.3 Pump first and then inflate

Click the button to select the function. When the pumping function is ✓ and the inflation function is ✓, the air nozzle will perform the action of pumping first and then inflating during operation after it is enabled.

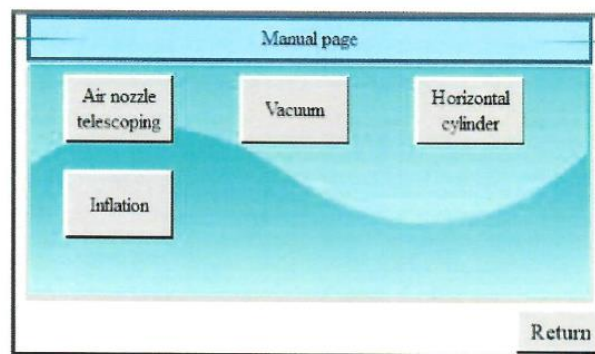


4.6 Administrator interface



4.6.1 Manual page

Click the manual page button to jump to the manual page interface, and you can adjust or control the operation of the equipment separately. It is generally not used in normal operation and requires professionals to use it.

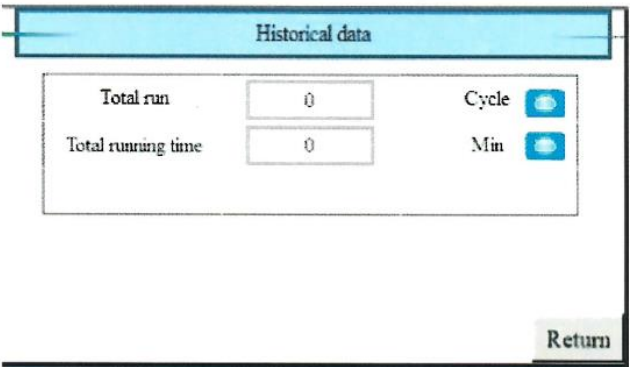


Click Back to return to the administrator page;



4.6.2 Historical data

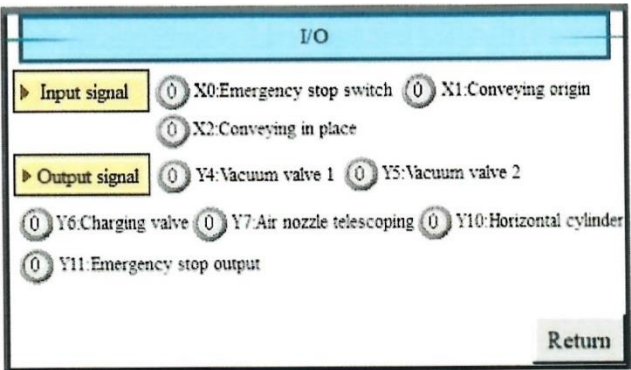
Click the historical data button to jump to the historical data interface, and you can see the total number of times and total time data of the equipment's historical operation



Click the clear button at the back to clear the data, and click return to return to the administrator page;



4.6.3 Input and Output

Click the input and output button to jump to the input and output interface, and you can refer to the current input and output points of the device



Click Back to return to the administrator page;

4.7 Power on



DANGER! ELECTRIC SHOCK!

Please follow the safe operation regulations.

Turn on the power of the machine by pressing or turning the "power switch".

After the power is turned on, the power indicator on the control panel will light up. Indicates that the machine is in standby state and can be used.



4.7.1 Connect the power supply

**DANGER! ELECTRIC SHOCK!**

Ensure that the socket used has a protective ground wire.

Be careful! Power mismatch will damage the machine!

Please check the power parameters of the machine and refer to the machine nameplate. Please follow the safety operation guidelines and accident prevention measures promulgated by the state.

Power/Ground

- Check whether the used power supply voltage is consistent with the voltage specified on the machine nameplate.
- Make sure that the machine is correctly connected to the grounded socket to avoid fire or electric shock (the grounding wire is a yellow and green wire).
- The cable must be able to move freely to avoid crushing.
- Once the cable is damaged, replace it immediately.
- When the machine fails or needs maintenance, please cut off the power first.
- If the machine is going to be idle for a period of time, please put away the cable.

4.7.2 Boot procedure

- Turn on the power supply and turn on the emergency stop switch, the indicator light will be on, adjust the heat-sealing speed knob, and all transmission components will run synchronously.
- Fine-tune the printing wheel knob to make the printing wheel rotate. Adjust to proper pressure, and then fix the limit screw.
- Turn on the heating switch, the green light of the electronic temperature controller is on. Adjust the temperature controller to the required temperature according to the material and thickness of the packaging bag. When the heating block starts to preheat, it should be turned on and run at low speed at the same time.
- Depending on the material and thickness of the plastic bag to be sealed, determine whether it needs to be cooled by a fan.
- According to actual needs, you can choose whether to open the printing function.
- Fine-tuning the marking position, you can adjust the printing position of the printing wheel on the film bag.
- The sealing part of the packaging bag should be aligned and flat, and the bag mouth should be fed in by the flat adjustment position (feeding mouth). When the sealing part is bitten by the sealing tape, the packaging bag will automatically move forward. Do not push or block arbitrarily at this time, otherwise it may cause the seal to collapse or malfunction.
- When it is found that the sealing tape and the heating block adhere to the dirt, the machine should be shut down to remove it. When the temperature is too high, do not remove it by hand.



4.7.3 Shutdown operation

In order to improve the service life of the sealing tape, before preparing to shut down, it is required to return the temperature adjustment knob to the zero position and turn on the fan. At this time, the temperature pointer begins to slowly drop, and the sealing tape should still be running. After a few minutes, let the temperature drop below 100 °c, then turn off the fan and main power switch.

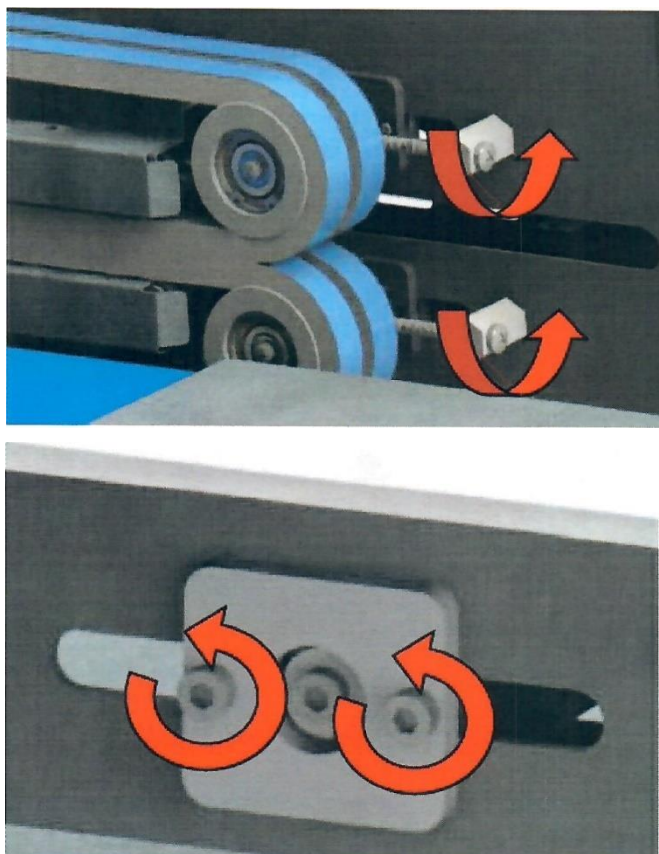
4.7.4 Emergency stop switch

At any time, press the emergency stop switch, and the equipment will stop immediately. The emergency stop switch is a self-locking switch, after it is locked, it needs to be turned 120 degrees clockwise to unlock it.

4.8 Adjustment

4.8.1 Sealing belt exchange method and adjustment

- Remove the protective cover, and after the heating block cools down, turn the handle of the adjustment screw of the copper block on the upper heating block and the upper cooling block counterclockwise to move the copper block up; loosen the spring on the printing wheel and the middle pressure wheel, and remove Lower the guide belt, unscrew the screws on the pillar counterclockwise and the bolts on the pressure plate inside the machine, then remove the upper and lower pressure plates, remove the sponge flat belt, and prepare for removing the sealing belt (see the picture below).

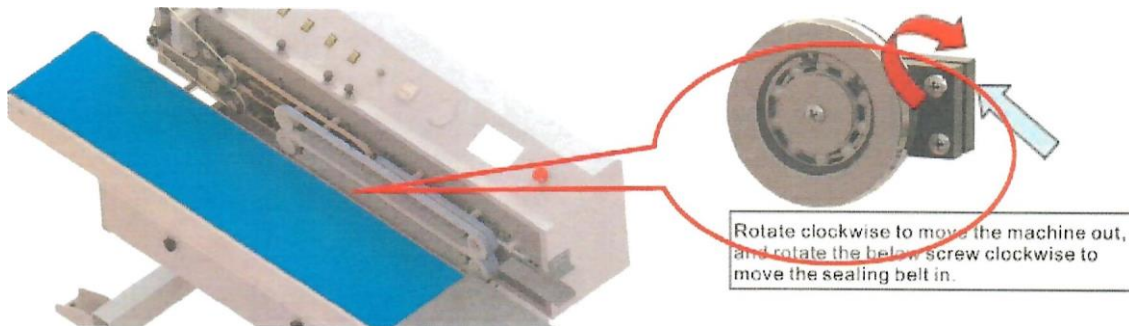




- Push the driven wheel seat (adjustment block) towards the heating block and remove the sealing tape.
- Replace with a new sealing tape and install the guide tape.
- Return the driven wheel, heating block, cooling block, pressure wheel, etc. to their original positions.
- Turn on the power and test the machine.
- Cover the protective cover, and the heating block can work after reaching the set temperature.

4.8.2 Adjustment of the deviation of the sealing belt

If the sealing belt deviates, it can be adjusted by adjusting the screw on the driven pulley seat (adjustment block) (as shown in the figure below).





4.8.3 Sponge flat belt replacement

Take off the protective cover, unscrew the screws on the support counterclockwise, and take out the entire upper platen (see the figure below); unscrew the screws on the support counterclockwise and the bolts on the pressure plate inside the machine (see figure 4.8,1), and insert the guide. The wheel seat is pushed toward the sealing mechanism, the flat sponge belt is taken off, and a new flat sponge belt is inserted into the guide wheel. Turn the screw on the pillar clockwise until the flat sponge belt enters a tight state; then tighten the bolts on the pressure plate inside the machine clockwise, and reinstall the upper pressure plate (the bearing on the upper pressure plate is in close contact with the flat sponge belt).



4.8.4 Front and rear adjustment of conveyor table

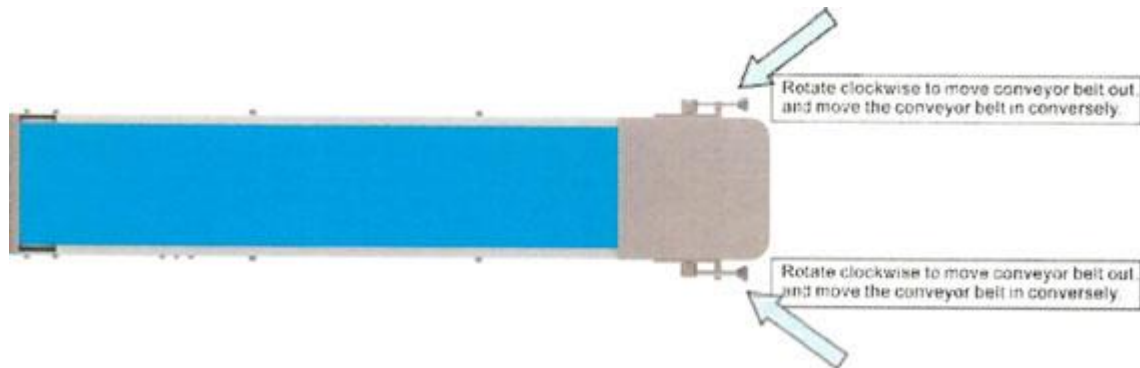
First loosen the knobs on both sides, and the conveyor table moves back and forth along the long slot. as needed, and then tighten the knobs on both sides after adjustment.





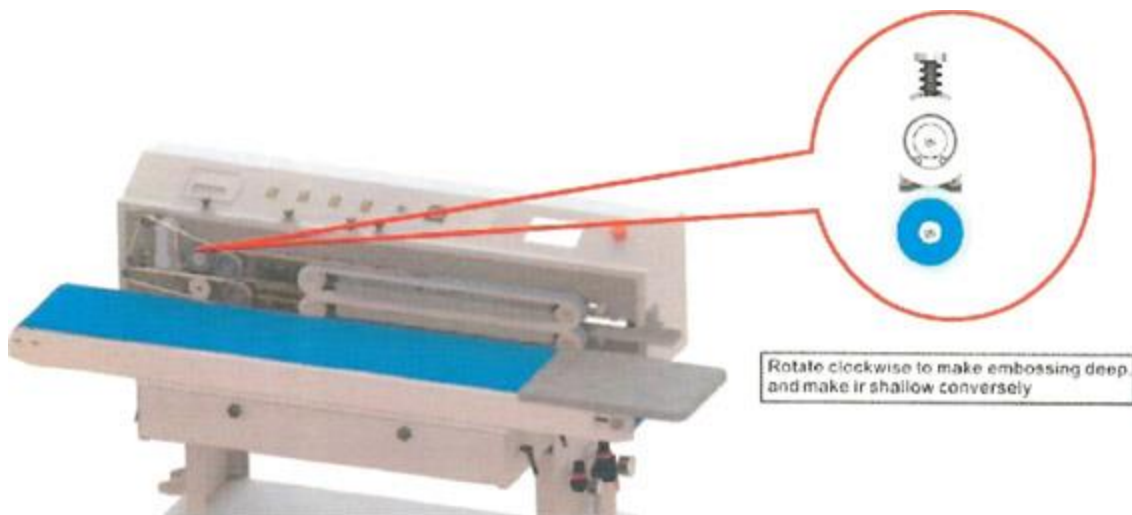
4.8.5 Adjustment of conveyor belt deviation

If the conveyor belt deviates, it can be adjusted through the adjustment knob on the right side of the conveyor table (as shown in the figure below). When adjusting the conveyor belt, keep the conveyor belt in a tensioned state, and must not adjust it when the conveyor belt is in a loose state.



4.8.6 Adjustment of embossing wheel pressure

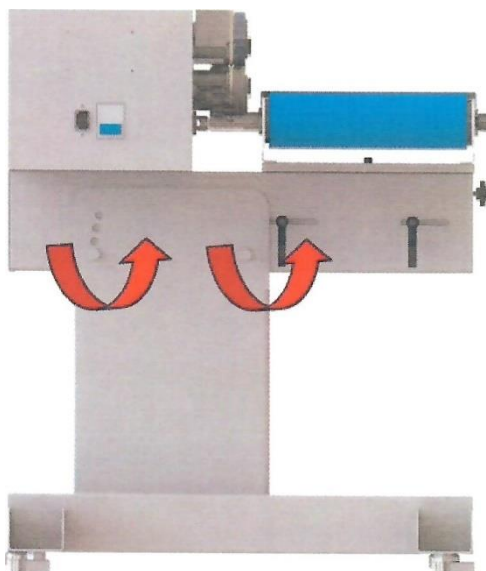
If you need to deepen or lighten the texture of the embossing wheel, you can adjust the adjustment knob above the embossing wheel (as shown below).





4.8.7 Angle adjustment of the whole machine

If you need to adjust the angle of the whole machine, you can adjust it through the adjustment screws on both sides of the support plate (as shown in the figure below), loosen the bolts with an open-ended wrench, and then adjust the angle of the whole machine, and tighten the screws after adjustment.





5 Standard Operation and Parameter Setting



TAKE CARE! INJURED!

Please refer to this manual to operate this machine. It is not allowed to discharge the necessary protection cover or hull.



TAKE CARE! CLAMPED!

When the machine is running, it is forbidden to put hands into the driving wheel to avoid clamping hands!



TAKE CARE! SCALD!

When sealing, the temperature outside the surface of heating block can reach over 2000. Even after cooling, it is still with high temperature.

- If any question about operation and function of the machine, when related information is not included in this manual, please contact manufacturer or distributor.
- If machine is not running in normal situation or produces strange noise, please turn off power immediately to stop machine running and cut off power supply.
- Once in trouble, please contact manufacturer or distributor.



5.1 Preparation, adjustment and inspection before operation

- This machine is equipped with a grounded three-hole socket. The power supply used should be well grounded to ensure safety in production.
- When in first time use or when there is too long time interval after use, the electric heating element will be affected with damp, it should be operated in normal operation after preheating in low temperature for a few minutes.
- According to the bag shape and size, adjust the conveying table height and forward-and-backward position.
- According to the shape and size of the sealing line to the mouth, adjust the position (inlet).
- According to thickness of the sealing material, adjust upper and lower heating blocks, and the clearance between upper and lower cooling blocks, adjust the pressing force of retaining washer to control the clearance between the two sealing tapes, adjust clockwise to lift (increase clearance) and counterclockwise to fall (narrow clearance). The clearance between two sealing belts is equal to about the thickness of one layer of packing bags, so that the sealing fastness and embossing sharpness of the bag can be ensured and the clearance between two ends of the seal are not too long.
- According to the external dimensions, internal volume and volume of the packaging, adjust the pumping time or the air pressure of the inflation source to ensure that the air in the packaging bag is discharged or a considerable amount of gas is filled into the packaging bag.



5.2 Parameter setting



TAKE CARE! DAMAGE!

Unreasonable parameter setting may damage machine or shorten machine service time.

- Unreasonable parameter setting may damage the machine or shorten the service time.
- Unreasonable parameter setting may cause all procedures or sealing not to be completed correctly.

Speed Parameter Setting

There is a speed adjusting knob in the control panel to adjust the sealing speed, clockwise rotation is to increase the sealing speed, counterclockwise rotation is to reduce the sealing speed.

Optimal Parameter

- The distance between bag sealing center to the edge of the bag is 10 20 mm.
- Bag sealing quality is determined by the three elements of heat sealing temperature, sealing speed and pressure.
- The set pumping and inflation time should be adjusted slowly from short to long according to the internal volume of the bag and the volume of the package.
- The quality of bag sealing is determined by three elements: heat sealing temperature, sealing speed and pressure.
- The setting temperature should be adjusted slowly from low to high according to the thickness of the bag.
- The setting speed should be adjusted slowly from slow to fast according to the sealing effect.
- Setting the sealing pressure The factory has adjusted to an appropriate pressure, which is suitable for most product bags. If your product bag still cannot achieve the ideal sealing effect after adjusting the temperature and speed, you can adjust the pressure roller, and the pressure will gradually increase from small to large. Adjust to achieve the desired sealing effect.

Common material heat-sealing temperature reference table

Material Name	Thickness (u m)	Recommended temperature setting CC)	Heat-sealing speed (m/min)
LDPE	30'V160	105—150	6—10
MDPE	40—120	119v120	7.2—10.2
HDPE		12+-150	7.2—10.2
pp	40 60	135 160	7.2 10.2



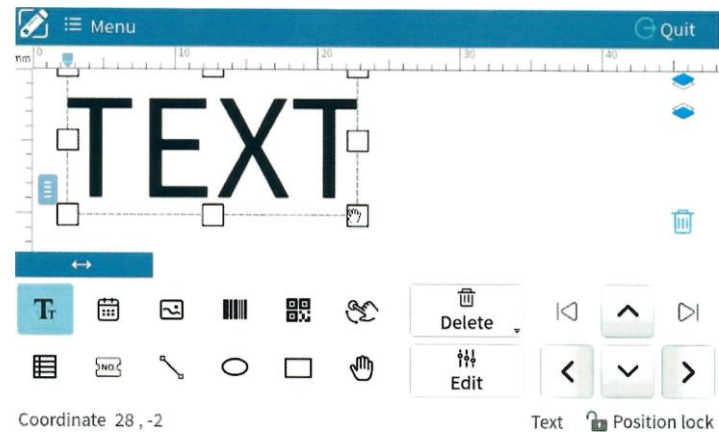
5.3 Main Menu

















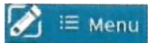


1. The first line: display the current system time and function
2. : Display text content length and height scale
3. : The current print information and its file name
4. Type: display a single file or a group of files in printing
5. File Num: show how many files are in the printing information
6. Open loop: display whether the group file is cyclically printed
7. Print count: display the number of times the text was printed
8. State: show that the machine is in standby or printing
9. Pulse width: display the set print pulse width value
10. Speed: display the set printing speed value
11. Grayscale: display the set print grayscale value
12. Display area of small tips for machine use
13. File editing: click to edit a new file
14. File selection: click to select the internal file saved in the machine
15. Advanced options: setting of machine general and printing parameters
16. Setting: general and printing parameters settings of the machine
17. Start printing: After the ink cartridge is installed, click this button to print (note: do not insert or remove the ink cartridge when printing); when printing is not required, click this button to stop working.



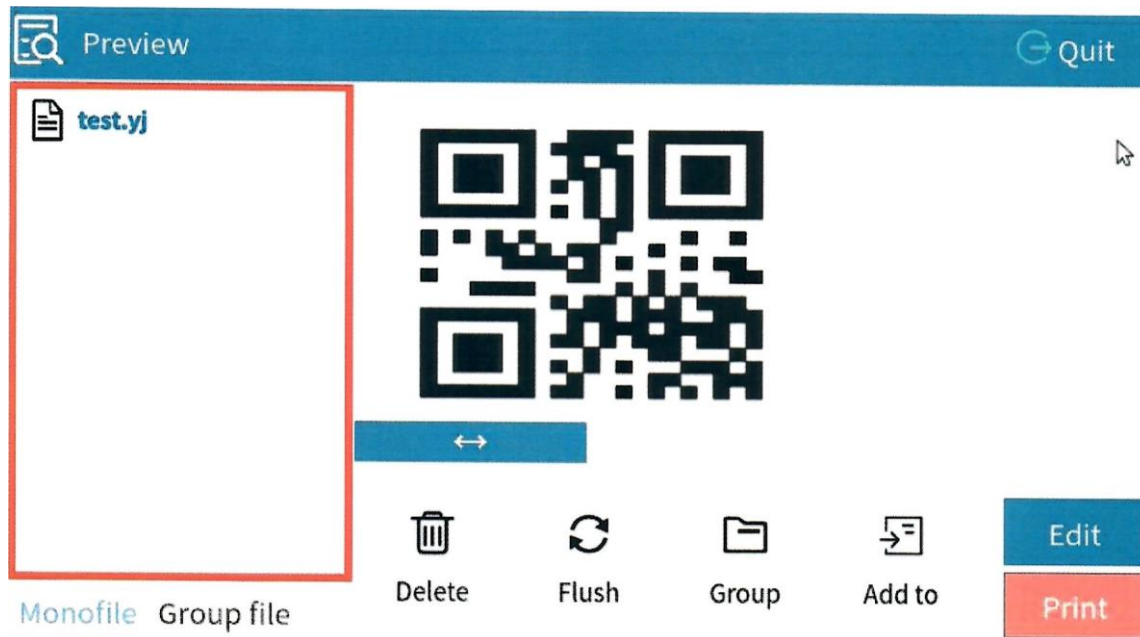
5.4 File Editing



- | | | | | | |
|---|---|---|----|--|----------------------------------|
| 1 |  | Add fixed text content | 7 |  | Add table |
| 2 |  | Add variable date and time | 8 |  | Add serial number counter |
| 3 |  | Add pictures | 9 |  | Add line segment |
| 4 |  | Add barcode | 10 |  | Add a circle or ellipse |
| 5 |  | Add a QR code | 11 |  | Add rectangle |
| 6 |  | Rotate selected objects
(fields or graphics) | 12 |  | Move or zoom the selected object |
-
- | | | |
|----|---|--|
| 13 |  | Delete a single selected object or clear information |
| 14 |  | Edit and modify the selected object |
| 15 |  | Fine-tune the selected object up, down, left, and right |
| 16 |  | Switch the selected field object when there are multiple field objects |
| 17 |  | Click this button to save information, create new information
or modify saved information |










5.5 File preview



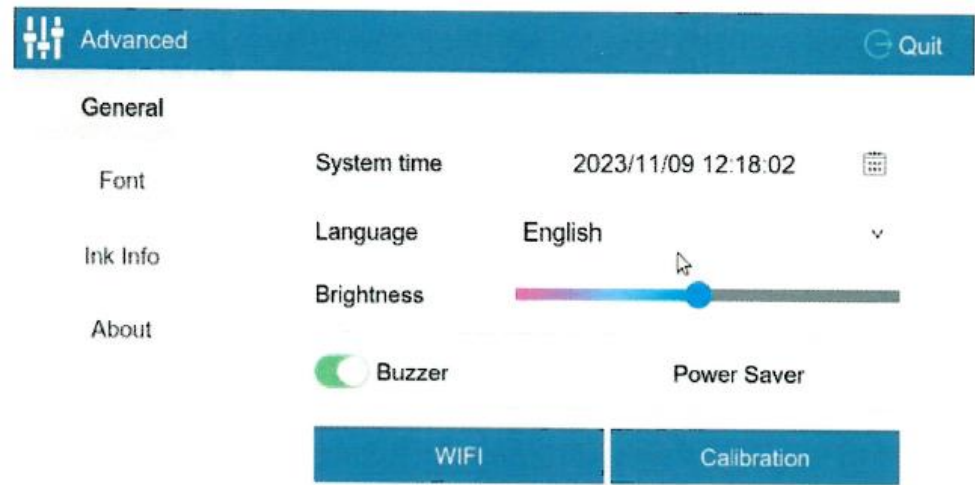
0,43KB [2021-11-16]

1. The file name of the saved information is displayed in the red solid line frame. You can click the file name to preview the file content, edit the file content or print the selected file

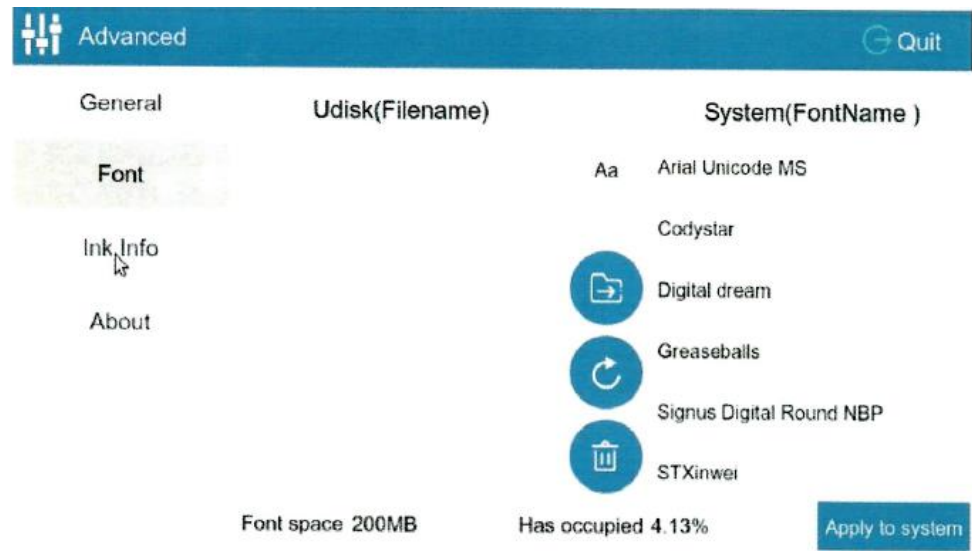
2.  Display the information content under the current file name
3.  Delete selected files
4.  Flush Refresh the information content
5.  Group Create group file
6.  Add to Add the selected single file to the group file
7.  Edit Edit and modify the selected single file
8.  Print Print the selected single file or group file



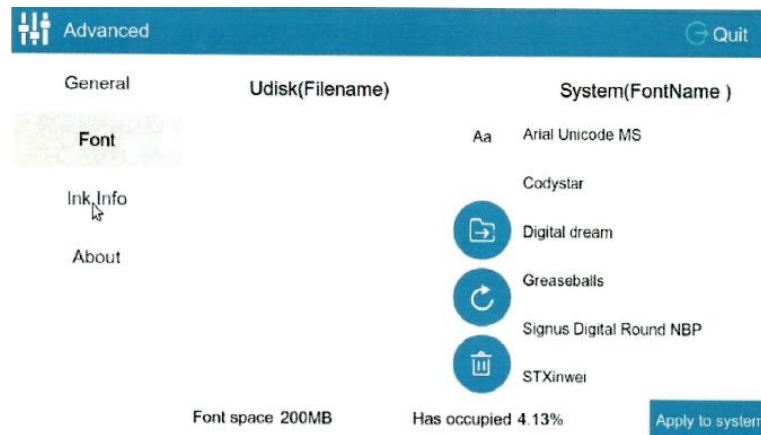
5.6 Advanced options



- 1.System time:adjust the current system year, month, day, hour, minute, and second
- 2.Language:select the desired language
- 3.Brightness:adjust the brightness of the screen backlight
- 4.Buzzer:when you select the ON state, there will be a "di ll" sound at the beginning and end of printing; if it is not turned on, there will be no sound when printing
- 5.Power Saver:when the on state is selected, the machine will automatically reduce the brightness of the screen after no operation to protect the life of the screen; otherwise, it will not
- 6.Calibration:when the touch screen is not sensitive, you can enter the screen calibration for calibration



When you need to print fonts that are not in the system, you can copy them on this page



- 1 1.Direction: the direction in which the font is printed, forward, reverse, forward and backward, reverse direction can be selected
- 2 2.tnkjet mode:The cartridge has two nozzles, you can choose to spray left or right
- 3 3.Trigger: electric eye
- 4 4.Speed: the faster the bag moves, the smaller the print speed value is set
- 5 5.Delay: the larger the delay, the later the printing position will be after the sensor is inducted, the smaller the delay, the forward the printing position
- 6 6.Grayscale:Print gray scale: adjustable font depth, the larger the number, the darker the color(No more than 2 is recommended)
- 7 7.Pulse width: recommended to be set to 110-150
- 8 8.Voltage: recommended to be set to 9
- 9 Note: The password is required to enter this parameter setting page. The password is 89989999.



6 Machine Maintenance



ALARM! ELECTRIC SHOCK!

The power of the machine should be fully cut off before maintenance.

Daily maintenance to the machine is necessary to lengthen the service life of the machine and to achieve best packing effect. If the machine is frequently used (more than four hours per day), it is suggested to do professional maintenance every three month. If the machine is used less than four hours per day, it is advisable to do comprehensive maintenance very six month (according to place, environment and product). However, some users could do simple following maintenance to the machine according to their practical needs.

6.1 Attention for maintenance

- The power of the machine should be fully cut off, the power cord should be pulled out from the socket in the wall.
- If the machine runs incorrectly or there is some abnormal noise during operation, please immediately turn off the power and contact supplier or manufacturer.
- Please do not wash the machine with high pressure washer which will do much damage to the electronic components and other spare parts in the machine.
- Please do not let the water flow into the control panel, or it will do damage to the electric circuit. If the operator's maintenance to the machine is not according to this manual, the manufacturer will not take responsibility for any failure or damage of the machine.



6.2 Maintenance period table

Schedule	Maintenance content
Daily	<ol style="list-style-type: none"> 1. Use the brush to remove the substance attached to the appearance of the sealing belt and guiding belt. 2. Use wet cloth to clean the appearance of the conveyor belt. 3. Whether there is noise or abnormal noise during the operation of the motor. 4. If the machine is not used for more than 20 minutes, the ink cartridge must be removed from the machine and covered with a special clip.
Monthly	<ol style="list-style-type: none"> 1. Check whether the sealing belt is worn or not. 2. Check whether the guiding belt is worn or not. 3. Check the sponge flat belt for damage.
Half a year	<ol style="list-style-type: none"> 1. Lubricate the meshing parts of the exposed gears with grease. 2. Add grease to the sprocket chain for lubrication. 3. Fill the oil nipple of the linear slide rail with grease.
Yearly	<ol style="list-style-type: none"> 1. Comprehensively check the machines according to above items. 2. Check whether the rubber wheel is aging or not, aged rubber wheel is better to be replaced. 3. Check whether the temperature controller could reach the temperature value set within ten minutes or not. If it could not reach the set temperature within ten minutes, the temperature controller should be replaced. 4. Check whether the electronic parts including emergency switch, buttons, potentiometer, fan and so on work normally or not. 5. Check and add lubricating grease to the transmission parts including gears, shafts and joints. If there are any worn seriously among these parts, it is necessary to change them.



7 Troubleshooting

7.1 Product faults analysis table

Problem	Reason	Solution
The machine does not work.	<ol style="list-style-type: none"> 1. The power supply is not connected. 2. A fuse breaks or a trip with high breaking capacity. 3. No reset when the emergency stop switch is pressed. 	<ol style="list-style-type: none"> 1. Check the power socket. 2. Replace the fuse or high breaking capacity. 3. Reset the emergency stop switch.
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.	<ol style="list-style-type: none"> 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. 	<ol style="list-style-type: none"> 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.	<ol style="list-style-type: none"> 1. Embossing wheel is worn out. 2. Pressing spring on embossing wheel is not tightened to enough degree. 	<ol style="list-style-type: none"> 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.	The gap between the heating blocks or cooling blocks should be moderate, so that the gap between the two sealing belts is approximately equal to the thickness of a layer of packaging bags, not only to ensure the sealing fastness and embossing clarity, but also not to make the two ends of the sealing arts extended too long



There is block or fold phenomenon when the packing bag is conveyed to middle pressing wheel or embossing wheel.	Too much pressure caused by pressing wheel or embossing wheel.	<ol style="list-style-type: none"> 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 table.
Conveyor belt and sealing belt do not move synchronously.	Too small tension on conveyor belt.	<ol style="list-style-type: none"> 1. Tighten the chain of driving roller shaft (front shaft) and middle shaft properly. 2. Tighten the conveyor belt properly
Bag leaks	<ol style="list-style-type: none"> 1. The clamping force of the sponge flat belt is not enough. 	<ol style="list-style-type: none"> 1. Loosen the screws on the pillar, press the upper and lower pressure plates to the middle, and then lock the screws on the pillar.
The pumping effect is not good	<ol style="list-style-type: none"> 1. Insufficient pumping time. 2. The material is too far away from the gas nozzle. 	<ol style="list-style-type: none"> 1. Extend the pumping time or reduce the sealing speed. 2. Place the material close to the air nozzle or extend the air nozzle close to the material.
Inflatable effect is not good	<ol style="list-style-type: none"> 1. Air source pressure is too high or too low. 	<ol style="list-style-type: none"> 1. Adjust the pressure reducing valve on the side of the casing to control the pressure of the air source. 2. Reduce or increase the sealing speed.
The sealing surface is not parallel to the mouth of the bag	<ol style="list-style-type: none"> 1. When put into the bag, the bag is tilted. 2. When the air nozzle is retracted, the packaging bag is inclined. 	<ol style="list-style-type: none"> 1. Align the packaging bag with the edge of the feed port before putting it in, and push it in with the help of hands. 2. Move the sensor inside the machine to control the retraction of the air nozzle to the feeding direction.



<p>Touch screen is out of order.</p> <p>Nothing happens when you click the screen</p>	<ol style="list-style-type: none"> 1. You need to recalibrate the screen. 	<ol style="list-style-type: none"> 1. Insert the mouse into the USB port on the side of the case; 2. Click the mouse to enter the advanced option -- General -- screen calibration; 3. When the screen restarts, pull out the mouse, and then the screen will enter the calibration interface. Click the anchor point on the screen successively, and click 5 times to complete the calibration of the screen.
<p>Incomplete printing, printing appears to be missing the upper or lower part of the print</p>	<ol style="list-style-type: none"> 1. The portal chip of the ink cartridge should not have ink marks, otherwise it may cause some contacts to burn out, resulting in some nozzle of the ink cartridge cannot work. 2. Part of the pin in the jetty did not pop out, resulting in the nozzle of the ink cartridge not working. 3. Part of the ink cartridge nozzle is blocked. 	<ol style="list-style-type: none"> 1. Check whether the gate chip of the ink cartridge has ink marks. 2. Check whether part of the pin in the jetty does not pop out. 3. Adjust the printing pulse width in the touch screen parameter setting page to 150 (if it is winter, the printing voltage can be adjusted to 12V if the printing voltage is low).



<p>The print is not black, and there is scattered ink next to it</p>	<ol style="list-style-type: none">1. The distance between the bag and the jetty is too large.2. The ink in the cartridge is running out.	<ol style="list-style-type: none">1. Check the distance of the guide plate below the jetty, and the jetty is within 5mm of the guide plate. Beyond this distance, the printed word will be pale in color, with scattered ink around the font.2. The print font is not black before use will not appear, in the ink cartridge will be used up. Adjust the print gray value in the parameter setting interface, the larger the value, the more black the word, the larger the ink printing machine. <p>After adjusting the gray font will become longer, and need to adjust the print speed value set small. (Adjust the gray value must adjust the printing speed).</p>
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<p>When customers adjust the sealing speed, they find that the font length changes and the kerning also changes.</p>	<p>1. This is a normal phenomenon, you can set the parameters to solve.</p>	<p>1.If the customer proposes that the printed word is too long and not compact in the sealing process, it is necessary to adjust the printing speed in the parameter setting interface to a smaller value. On the contrary, the customer feels that the printing word is too short and crowded together, so the printing speed in the parameter setting interface is adjusted to a larger value.</p> <p>2.The font height change of the injet machine is to adjust the appropriate height when editing the content and then printing. The printing height can not be solved by adjusting the printing speed, but can only be adjusted by adjusting the font size.</p>
<p>In the process of inkjet printing, the main interface prints count hops, but no words can be sprayed</p>	<p>1.The printed content is empty. 2.The ink cartridge contact is poor or the ink cartridge is not inserted in place. 3.The printing delay setting in the touch screen parameter setting page is too large or too small, resulting in the actual action of the inkjet, but did not hit the bag.</p>	<p>1.Whether the printed content is edited, and whether the printed content is visible on the main interface. 2.Check whether the cartridge is inserted properly. 3.Adjust the printing delay time in the screen parameter setting page.</p>



<p>In the process of jet code printing, the word can not be sprayed out, and the print count of the main interface does not jump</p>	<ol style="list-style-type: none"> 1.The trigger mode in the touch screen parameter setting page is not external electric eye. Please note that it should be set as external electric eye. 2.The synchronization wheel in the touch screen parameter setting page is open, and please note that the synchronization wheel should be closed. 3.The wiring fault between the spray wharf and the touch screen may be that the wiring is not inserted firmly or inserted backwards. 4.The spray wharf photoelectric is blocked by the lower guide plate, resulting in photoelectric failure. 5.Before the sealing machine inlet baffle is adjusted, the photoelectric can not shine on the bag. 	<ol style="list-style-type: none"> 1.Check whether the trigger mode on the parameter setting page of the touch screen is external electric eye. 2.Check whether the synchronization wheel is closed on the parameter setting page of the touch screen. 3.Check whether the wiring connecting the spray dock and the touch screen is inserted firmly or not. 4.Check whether the guide plate is blocked to photoelectric. 5.Check whether the position of the sealing machine inlet baffle is wrong.
<p>The jetty is burnt out</p>	<ol style="list-style-type: none"> 1.Live plugging ink cartridge will cause the contact piece to touch the two contacts, which will cause short circuit. 2.When the cartridge is removed for preservation or other operations, the touch piece is stained with ink, resulting in short circuit when it is installed and printed again. 	<ol style="list-style-type: none"> 1.The customer must insert and remove the ink cartridge in the case of power failure. 2.Before loading the ink cartridge, ensure that the ink cartridge door font chip is clean and no ink residue remains.



<p>After a few hundred prints, the machine stops printing and can be restarted to print again</p>	<ol style="list-style-type: none">1. The machine has no ground wire, or the ground wire is impassable, and the instantaneous current will cause the program to stop.2. In the process of machine operation due to the material of packaging materials, the instantaneous static electricity will cause the program to stop.	<ol style="list-style-type: none">1. the machine needs to be effectively grounded.2. The occasional printing stop requires the guest to restart the system.
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7.2 Motor maintenance

- 1 Stop and check the machine when any abnormal occurs to motor, do not use the machine until problem is solved.
- 2 Dedust and clean motor regularly. Ethyl alcohol, gasoline and liquid with benzene chemicals should be avoided, otherwise it will affect the paint of motor cover.
- 3 The motor should be used indoors under normal atmospheric temperature to avoid friction, exposure to rain, and chemical corrosion, etc.. Please contact the supplier or manufacturer first if the motor is to be used in bad condition (such as exposure to Corrosive atmosphere, temperature higher than 30 °C or lower than 50).



8 Storage

8.1.Packed in cartons

(Export packing cases): Export packing cases refer to packing cases that meet the export requirements. Export packing cases must meet the corresponding requirements in order to pass the inspection and allow export. And different countries have strict regulations on packing cases requirements also vary.) e Ensure the safety of goods and operators throughout the transportation process.

- The joints of the box boards should be tight, the combination of the box boards should be flat without dislocation, the cloth nails should be reasonable, the reinforcement wooden bars should not be less than 2, the printing should be clear, the handwriting should be clear, and the commodity inspection code should be printed correctly.
- The product should be fixed with fasteners inside the wooden box to prevent damage to the equipment during transportation.
- An appropriate amount of buffer foam protection equipment should be added inside the wooden box.

Note: When the machine is transported in a container, the highest should not exceed 2 floors.

- Please carry it according to the direction of the arrow on the carton, and do not carry it upside down.
- The wooden box structure is convenient for forklift handling. If you need to move it, please use a forklift to move the machine.

8.2 Storage of short time

- Turn off the power button, unplug the power cord, pack up the power cord.
- Clean the dust.
- If possible, cover it with the plastic bag to keep it from dust.
- Store it in a dry, dust-free and shockproof room.



8.3 Storage of long time

When the machine leaves the factory, it has been dealt with necessary anti-rust treatment, so there is no need to add more preservative oil to the machine. If the condition of the storage is poor (the surrounding environment is corrosive, higher or frequently changing temperature), it is suitable to add more preservative oil to the machine. If there is any question, please feel free to contact supplier or manufacturer.

- Turn off the power button, unplug the power cord, pack up the power cord.
- Clean the dust.
- cover it with the plastic bag to keep it from dust.
- If possible, please pack it as original.
- Store it in a dry, dust-free and shockproof room.

8.4 Start the machine after long-term storage

Please refer to the instruction of "Installation and Start" in this manual.



9 Electric Schematic Diagram

9.1 Electric schematic diagram (See annex)

