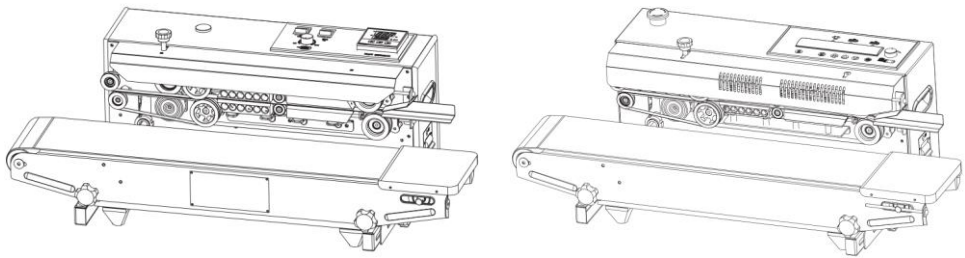
SF-150 and SMT-150
CONTINUOUS SEALING MACHINE



USER MANUAL

INDEX

I. FEATURES

◇ Unlimited sealing length ◇ User-friendly

◇ Date embossing ◇ Horizontal and vertical double usage

◇ Digital temperature controlling ◇ Durability

II. STRUCTURE AND WORKING PRINCIPLE

This machine is composed by frame, speed controlling system, heating system, Conveyor and printing system.

Power on the machine and switch on the heating system, 1 minute later the copper blocks is heating.

Adjust the temperature and speed according to thickness and material of bags, to find out the best parameter.

Put the mouth of bag between the 2 running sealing belts, to let the sealing belts convey the bag to the heating area.

The mouth of bags is clamped and heated by the copper blocks.

Then the sealed bag is conveyed to the cooling area where the optical sensor will find the bag, and printing system works.

There are any colors of ink rollers optional.

III. TECHNICAL SPECIFICATIONS

	SF-150	SMT-150
Voltage	220 ±10V /50Hz or 110 ±10V/50Hz	
Controlling panel	Analog thermostat (digital optical)	Intelligent PCB
Power	620W	
Counter	No	Yes
Speed	0 - 20 m / min	0 - 20 m / min
Temperature	0 - 300 ℃	
Max. loading weight	8 kg	
Dimension of machine	800*390*290 mm	
Shipping dimension	860*410*380 mm	
Gross weight	Horizontal 25 kg, vertical 28 kg	

IV. OVERVIEW OF MACHINE

Fig. 1

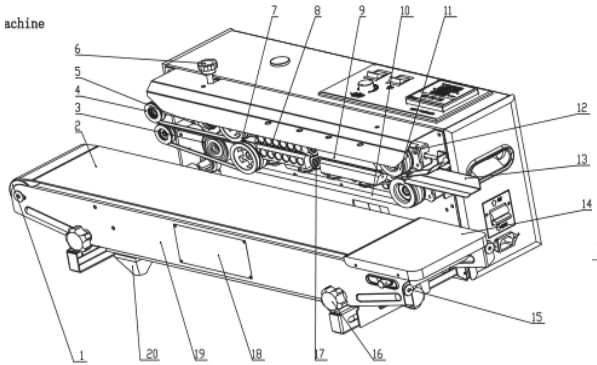
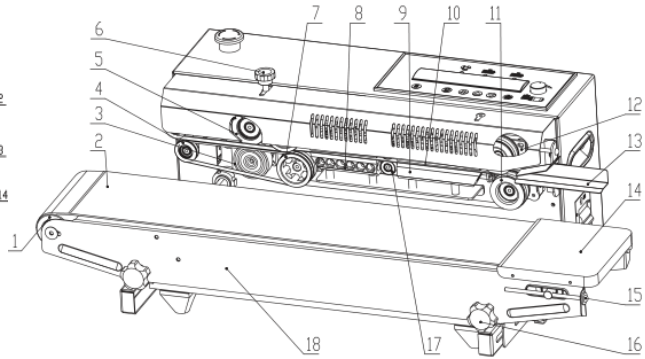


Fig. 2



1. driving roller for conveyor	2. conveyor belt	3. rubber wheel	4. guide wheel	5. embossing wheel
6. emboss adjusting knob	7. driving wheel	8. cooling copper block	9. heating copper block	10. sealing belt
11. passive wheel	12. sliding seat	13. feeding	14. platform plate	15. belt adjusting knob
16. bolt and nut	17. holding wheel	18. nameplate	19. conveyor	20. footing

Fig.3

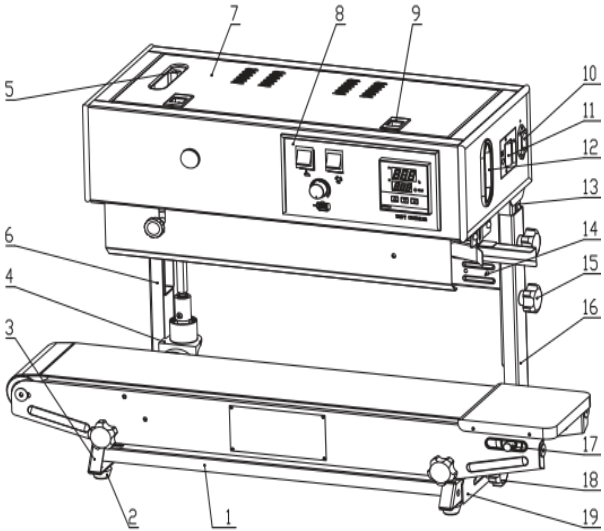
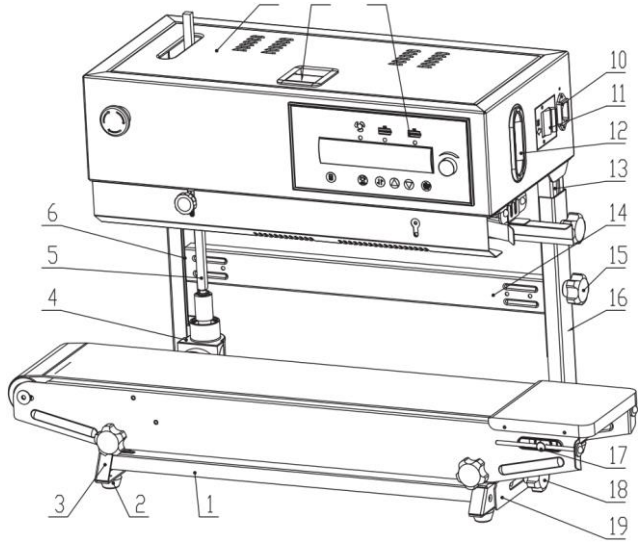


Fig.4



1.Base beam 2. Rubber footing 3. left base 4.bevel gear seat 5.long vertical axle

6.left pilar 7. back cover 8. Control panel 9.lock 10.power input

11.power switch 12.handle 13.right base 14.transverse beam 15.locking nut

16.Right base 17. Passive axle 18.locking nut 19.level adjusting rack

Fig.5

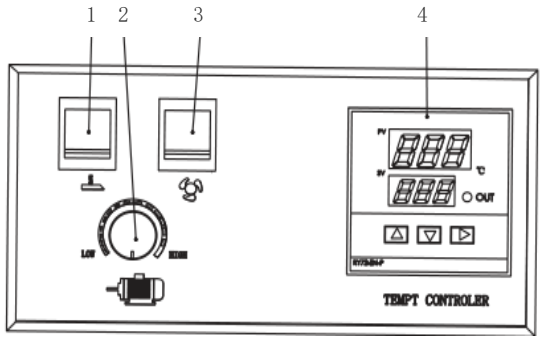
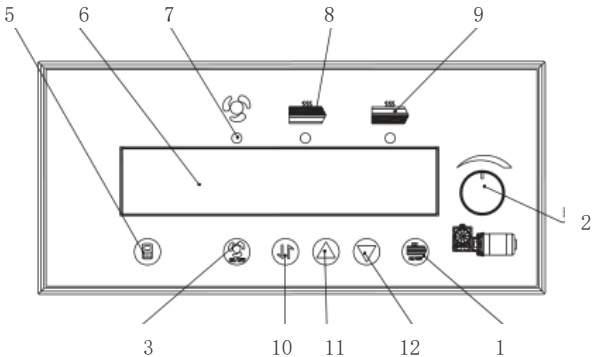


Fig.6



1.Heating switch 2.Speed controlling knob 3. Cooling switch 4. Thermostat 5. Counter

6. Screen 7.Cooling indicator 8.Upper heating indicator 9.lower heating indicator

10.Upper-lower selecting switch 11. Adjusting temperature 12. Adjusting temperature

V. PREPARATION

(1) For safety, the housing should be earthed, please make sure the 3-pin plug can be well connected.

(2) Adjust the position of conveyor by bolt and nuts to match bags.

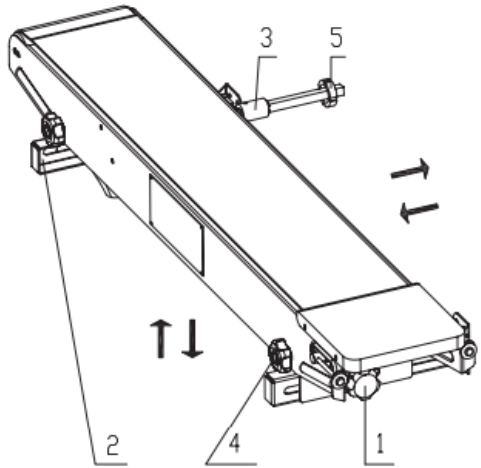
(3) Adjust the feeding according to the desired sealing width.

(4) Adjust the space between the 2 heating coppers block and between the 2 cooling blocks if the bag is very thick.

(5) lose the Knob 1 in Fig.7 to adjust the horizontal position of conveyor, the loose the Knob 4.

VI. START AND OPERATION

Fig.7



(1) Power on the machine, all indicators light and all belt and wheel run synchronously.

(2) Adjust the pressure embossing wheel.

(3) Turn on the heating switch, and adjust the temperature according to material, thickness and speed.

The following setting is only for reference at the maximum conveying speed.

Material	Thickness of entire bag (mm)	Temperature (℃)
Polyethylene	0.4	100 ~ 140
Polypropylene	0.6	170 ~ 180
Polyolefin compound	1	180 ~ 189
Aluminum compound	0.8	200 ~ 250

When the red indicator of the thermostat lights, please test it with bags, and re-adjust the temperature, speed and embossing pressure if necessary. Then start the continuous sealing work.

(4) To prevent bags from being wrinkle, please open the fan, if necessary.

(5) Put bag to the feeding, and let the sealing belt grip the mouth of bag which should be aligned with the feeding, and let bag be conveyed automatically.

VII. VERTICAL TRANSFORMATION

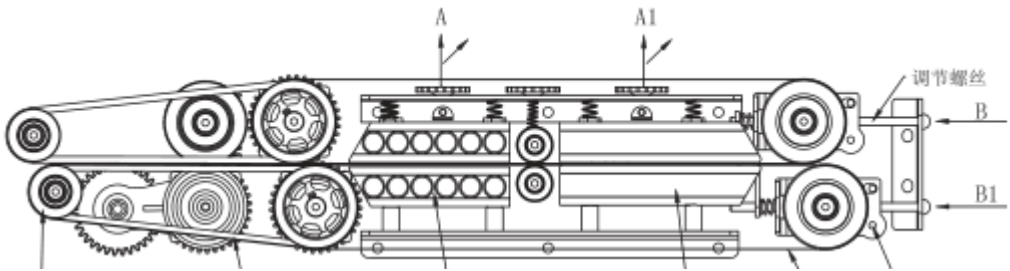
1. Fix the left base and right base to the base beam and transverse beam with nuts according to the Fig.3, now the vertical frame is ready.

1.Loose the two bolts and nuts on the conveyor nut and take the conveyor apart from the machine.

3. Fix the conveyor to right left base and right base which are combined in the first step.

4. Instead the short horizontal axle with the long vertical axle and the bevel gear seat.

5. Put the long vertical axle into the axle hole of the machine, in the meantime, put the right and left stand of the main body into right and left base, and tighten the bolts and nuts



VIII. CHARGE THE BELTS

a) Take off the hood.

b) Unscrew the guiding wheel according to Fig.2.

c) Take off the gear belt from the passive wheel.

d) Lift a little the copper coppers block by adjusting A and A1. Fig.8

e) Push B or B1 to loosen the sealing belts and change them.

f) Put the gear belt to the passive wheel.

g) Put the other end of gear belt to the guide wheel, meanwhile put the wheel back to its axle.

h) Screw the guide wheel.

X. TROUBLE-SHOOTING

MALFUNCTION	POSSIBLILITY	SOLUTIONS
Does not work	1. No well connected to the power 2. The speed controlling circuit is broken	1. Inspect if the machine is correctly connected to the power supply, and the fuse is in good condition 2. Change the speed controlling circuit
Can not adjust speed	The speed controller is broken	Change the speed controller
Do not heat	1. The heating tube is broken 2. The wire of heating tube is not well connected 3. The temperature controller is broken 4. The thermal sensor couple is broken	1. Change the heating tube 2. Connect it and screw the terminal with force 3. Change temperature controller 4. Change the thermal sensor couple
Embossing pattern is unclear	1. Not enough pressure 2. Rubber wheel is aged 3. The embossing wheel is stained 4. Hot enough temperature	1. Adjust the knob of embossing pressure 2. Change the rubber wheel 3. Clean the embossing wheel 4. Adjust the temperature

Sealing belt is fragile	1. Not enough space between the 2 heating copper blocks. 2. The space between the copper blocks is not clear. 3. The sealing belt is stained with plastic. 4. Temperature is still high when machine stopped 5. The bolt and nut B or B1 is too tight	1. Adjust the wheel A1 in Fig. 4 2. Clear copper blocks 3. Clear the sealing belt 4. Switch off heating firstly, few minute later power off the machine. 5. Loose the bolt and nut B or B1 in Fig. 4
Sealing belt slips	1. It is slack 2. Not enough space between the copper blocks	1. Tighten the bolt and nut B or B1 in Fig. 4 2. Adjust A or A1 in Fig. 4
Conveyor belt slips	3. It is slack	3. Adjust the N. 15 knob in Fig. 1

XI. EXPLOSION DIAGIAM Fig.9

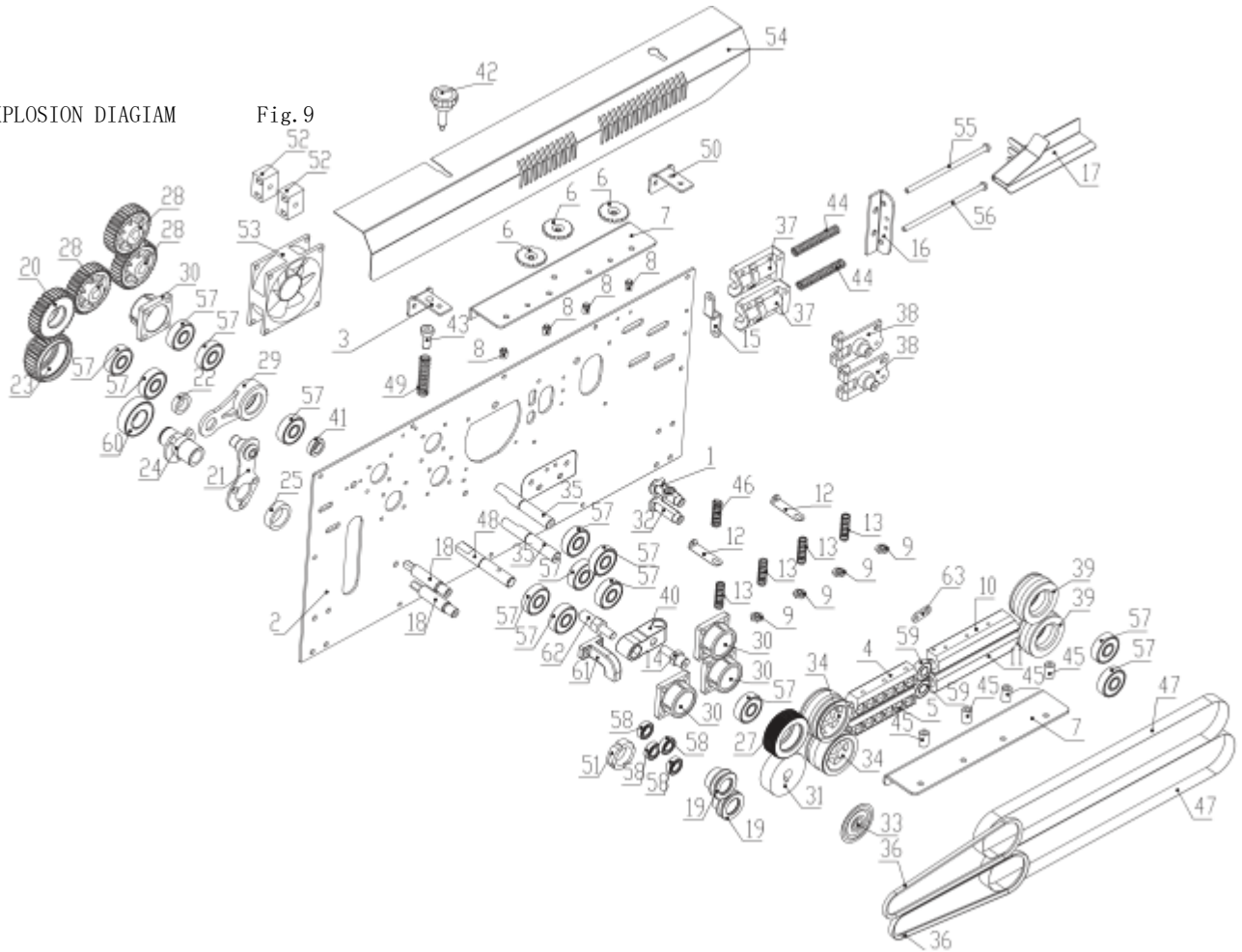
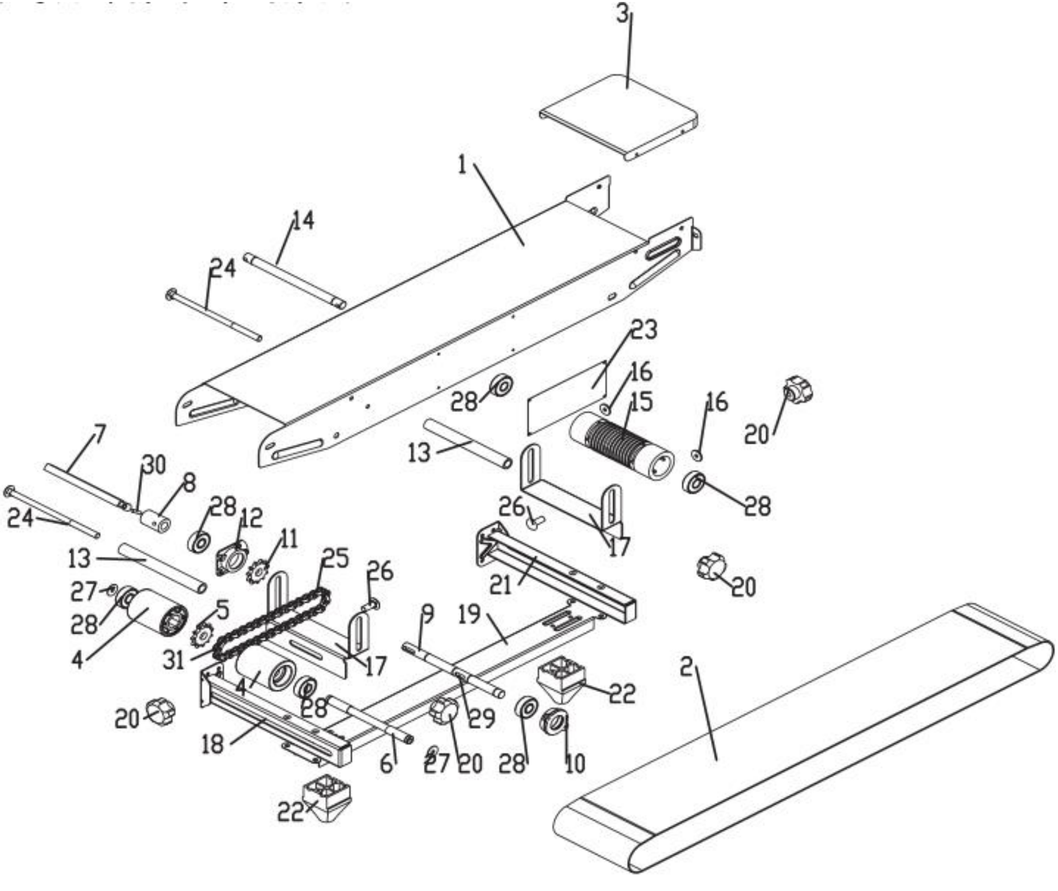


Fig. 11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XII. PACKING LIST

Machine	1 unit
Cable	1 unit
Sealing belt(772*15*0.2mm)	4 units
Letter box	1 set
User manual	1 unit
Crescent wrench	1 unit

ADDINIONAL PART FOR VERTICAL VERTION

Beam	2 sets
Bevel gears	1 set
Rubber Footing	4 units
Bolt (M8)	2 units
Nut (M4*8)	4 sets