I. FEATURES

- Unlimited sealing length
- Number and letter embossing
- Digital temperature controlling
- User-friendly
- Horizontal and vertical double usage
- Durability

II. STRUCTURE AND WORKING PRINCIPLE

This machine is composed by frame, speed controlling system, heating system, Conveyor and embossing 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 convey to the cooling area where the embossing wheel is rolling.

There are many patterns optional, including mesh, strip, smooth and letter-number embedded.

III. TECHNICAL SPECIFICATIONS

Voltage: 220 ±10V/50Hz or 110 ±10V/50Hz (customizable)

Max overall power: 620W

Power of motor: 60W  Power of heater: 280W x2 (adjustable)

Speed: 0-16M/min.

Sealing width: 10mm (customizable)

<table>
<thead>
<tr>
<th>Dimension</th>
<th>Gross weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>Horizontal</td>
<td>810x395x300mm</td>
</tr>
<tr>
<td>Vertical</td>
<td>810x330x525mm</td>
</tr>
</tbody>
</table>
IV. OVERVIEW OF MACHINE

Fig. 1 Horizontal machine

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. 2 vertical machine

1. base beam
2. rubber footing
3. left base
4. bevel gear seat
5. long vertical axle
6. left column
7. back cover
8. control panel
9. lock
10. power input
11. power switch
12. handle
13. right base
14. transverse beam
15. bolt and nut
16. right base
17. passive axle
18. bolt and nut
19. level adjusting rack
V. PREPARATION

(1) For safety, the housing should be earthed, please make sure the 3-pin plug can be well connected.
(2) Preheat for 1 minute with low temperature, and if it is unused for a long time, 3 minutes for preheating is necessary.
(3) Adjust the position of conveyor by bolt and nuts to match bags.
(4) Adjust the feeding according to the desired sealing width.
(5) Adjust the space between the 2 heating copper block and between the 2 cooling block if the bag is very thick.

VI. START WORK

(1) Power on the machine, all indicator 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.
a) Polyethylene: 150 ~ 160°C  
b) Polypropylene: 170 ~ 180°C  
c) Polyolefin compound: 180 ~ 189°C
When the red indicator of the temp. controller light up, please test it with the bags, and re-adjust the temperature, speed and embossing pressure if necessary. Then start 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.2, now the vertical frame is ready.
2. 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 nutss.
VIII. HOW TO CHANGE THE EMPOSSING WHEEL
1. Unscrew and take off the top hood.
2. Take off the 2 gear belt, and unscrew embossing wheel.
3. Lift the moveable seat and change the
4. Re-fix the parts took off before, and re-adjust the pressure of embossing wheel, then power on the machine and try.

IX. MAINTENANCE
1. To charge the belts
   a) Take off the hood.
   b) Unscrew the guide wheel.

Fig. 4

Guide wheel  Leader belt  top-bottom TELPON  top-bottom drive gear
Cooking blocks  belt  heating blocks  seat
c) Take off the gear belt from the passive wheel.
d) Lift a little the copper coppers block by adjusting A and A1.
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.

2. To maintain the gear box

Assuming that the machine work 8 hours daily, please add 50g of 20# engine oil monthly, and clean it yearly.

X. TROUBLE-SHOOTING

<table>
<thead>
<tr>
<th>MALFUNCTION</th>
<th>POSSIBILITY</th>
<th>SOLUTIONS</th>
</tr>
</thead>
<tbody>
<tr>
<td>Do not work</td>
<td>1. No well connected to the power</td>
<td>1. Inspect if the machine is correctly connect to the power supply, and the fuse is in good condition</td>
</tr>
<tr>
<td></td>
<td>2. The speed controlling circuit is broken</td>
<td>2. Change the speed controlling circuit</td>
</tr>
<tr>
<td>Can not adjust speed</td>
<td>The speed controller is broken</td>
<td>Change the speed controller</td>
</tr>
<tr>
<td>Do not heat</td>
<td>1. The heating tube is broken</td>
<td>1. Change the heating tube</td>
</tr>
<tr>
<td></td>
<td>2. The wire of heating tube is not well connected</td>
<td>2. Connect it and screw the terminal with force</td>
</tr>
<tr>
<td></td>
<td>3. The temperature controller is broken</td>
<td>3. Change temperature controller</td>
</tr>
<tr>
<td></td>
<td>4. The thermal sensor couple is broken</td>
<td>4. Change the thermal sensor couple</td>
</tr>
<tr>
<td>Embossing pattern is unclear</td>
<td>1. Not enough pressure</td>
<td>1. Adjust the knob of embossing pressure</td>
</tr>
<tr>
<td></td>
<td>2. Rubber wheel is aged</td>
<td>2. Change the rubber wheel</td>
</tr>
<tr>
<td></td>
<td>3. The embossing wheel is stained</td>
<td>3. Clean te embossing wheel</td>
</tr>
<tr>
<td></td>
<td>4. Hot enough temperature</td>
<td>4. Adjust the temperature</td>
</tr>
<tr>
<td>Issue</td>
<td>Possible Causes</td>
<td>Solutions</td>
</tr>
<tr>
<td>-----------------------</td>
<td>---------------------------------------------------------------------------------</td>
<td>---------------------------------------------------------------------------</td>
</tr>
</tbody>
</table>
| 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 minutes 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    | It is slack                                                                 | Adjust the N.15 knob in Fig. 1 |
XI. EXPLODED VIEWS

Fig. 5
### XII. PACKING LIST

<table>
<thead>
<tr>
<th>Item</th>
<th>Quantity</th>
</tr>
</thead>
<tbody>
<tr>
<td>Machine</td>
<td>1 unit</td>
</tr>
<tr>
<td>Cable</td>
<td>1 unit</td>
</tr>
<tr>
<td>Sealing belt (772m)</td>
<td>4 units</td>
</tr>
<tr>
<td>Fuse</td>
<td>2 units</td>
</tr>
<tr>
<td>Cross-headed screwdriver (4#)</td>
<td>1 unit</td>
</tr>
<tr>
<td>User manual</td>
<td>1 unit</td>
</tr>
<tr>
<td>Crescent wrench</td>
<td>1 unit</td>
</tr>
<tr>
<td>Ceramic washer</td>
<td>2 unit</td>
</tr>
</tbody>
</table>

**ADDITIONAL PART FOR VERTICAL TYPE**

<table>
<thead>
<tr>
<th>Item</th>
<th>Quantity</th>
</tr>
</thead>
<tbody>
<tr>
<td>Frame</td>
<td>2 sets</td>
</tr>
<tr>
<td>Bevel gears</td>
<td>1 set</td>
</tr>
<tr>
<td>Bolt (M8)</td>
<td>2 units</td>
</tr>
<tr>
<td>Nut (M4×8)</td>
<td>2 units</td>
</tr>
<tr>
<td>Screw (M4×25)</td>
<td>8 units</td>
</tr>
<tr>
<td>Screw (M4×25)</td>
<td>3 units</td>
</tr>
<tr>
<td>Screw (M4×25)</td>
<td>2 units</td>
</tr>
<tr>
<td>Washer (φ8)</td>
<td>2 units</td>
</tr>
</tbody>
</table>