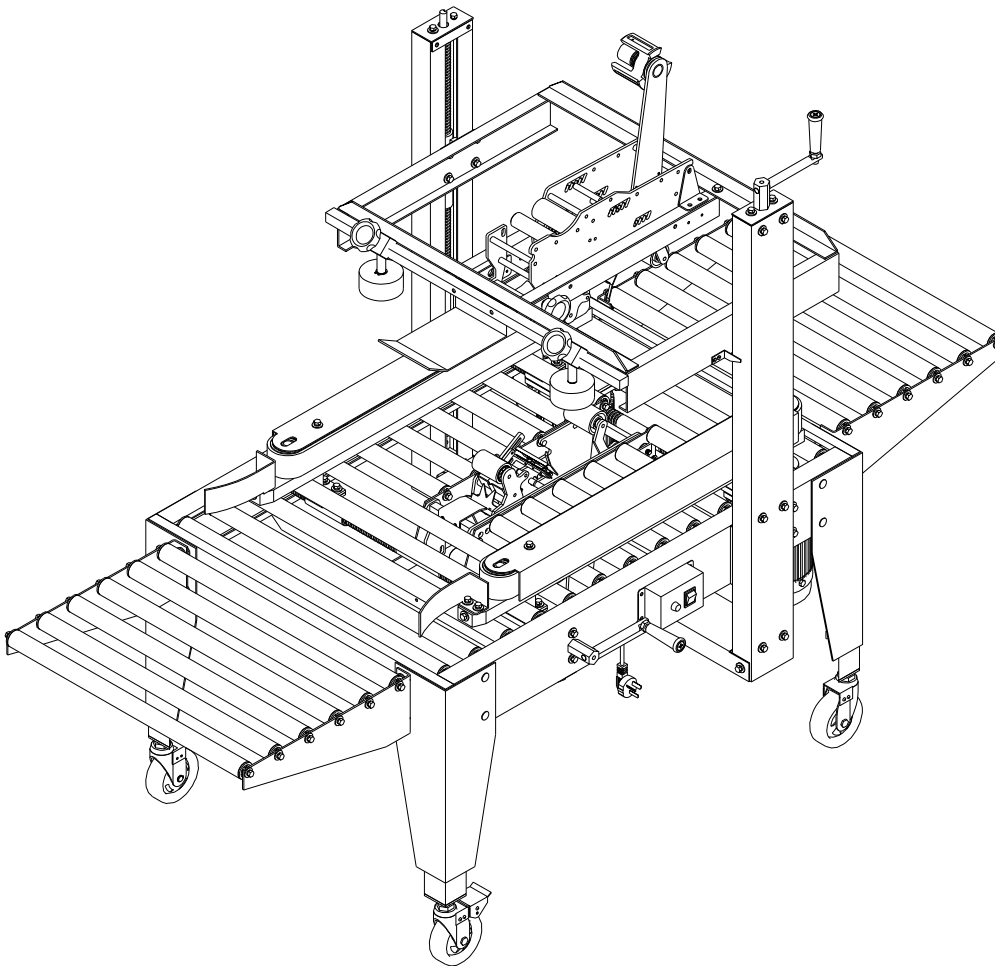


# SEMI AUTO CARTON SEALER MACHINE

ZF-FA500



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## PREFACE

- ※ We are pleased that you have chosen the SDW-FC500 automatic sealing machine, the structure of this machine is quite solid, and also can be easily to perform maintenance work.
- ※ To get the higher efficiency, please read the manual carefully before starting the machine.

## WARNING LABELS



ELECTRICAL SHOCK

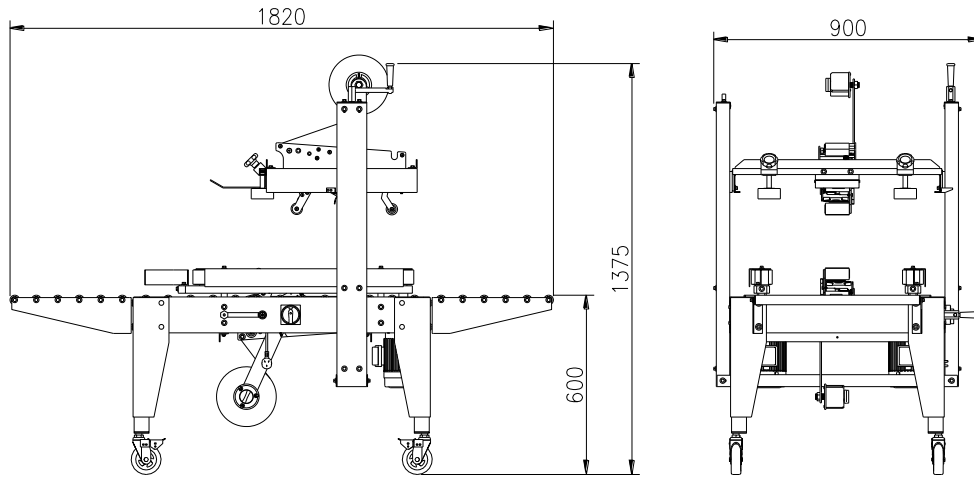


CLAMP INJURE

## SAFETY RULES

- ※ The machine can not be operated by untrained personal.
- ※ Please observe all the precautions and warning labels.
- ※ Do not remove or make any changes of the safety device.
- ※ When the machine is operating, do not make other maintains or repair works.
- ※ Please replace the cover after completing the machine adjustment work.
- ※ If the machine was in frames, to put out the fire by water is forbidden.
- ※ Please follow the instructions of the machine to operate the machine.
- ※ When the machine is not in use, please turn the power off.

## TECHNICAL DATA



NO.	NAME	SPECIFICATION
1	MAHCINE MODEL	SDW-FA500
2	SEALING SPEED	20 miter/ min
3	CARTON DIMENTION (L)	150mm ~
4	CARTON DIMENTION (W)	120mm~500mm
5	CARTON DIMENTION (H)	110mm~500mm
6	TAPE APPLICABLE	48~60~72Wmm
7	TABLE HEIGHT	560 ~750 mm (ADJUSTABLE)
8	DIMENSION	L1820 x W900 x H1370mm
9	GROSS WEIGHT	≈175Kgs
10	NOISE DEGREE	MAX: 70dBA
11	ELECTRIC CONSUMPTION	MAX: 0.2KW
12	VOLTAGE USAGE	220V/50Hz/60Hz/1Ph

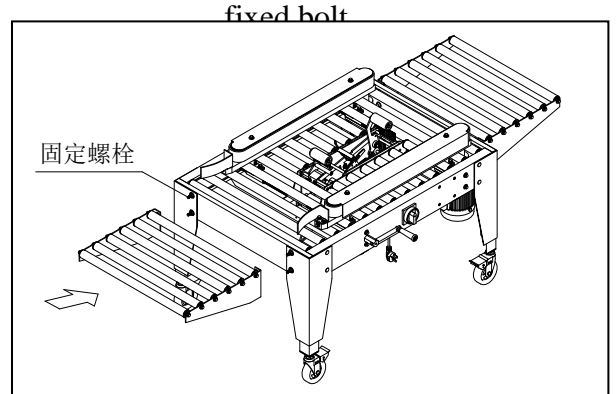
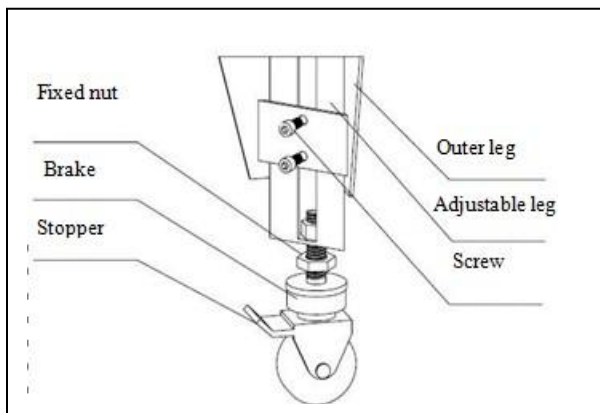
## INSTALLATION

- ※ The power supply system, voltage and frequency must correspond to the regulation label attached to the machine.
- ※ Connect the plug.
- ※ Operate the machine by the side switch.

### NOTICE :

Please install the machine where a power supply can be easily connected.  
It is necessary to disconnect the power supply plug prior to open the control box's cover.

## ADJUSTMENT



### NOTICE:

Before performing adjustment works, please disconnect the power supply.

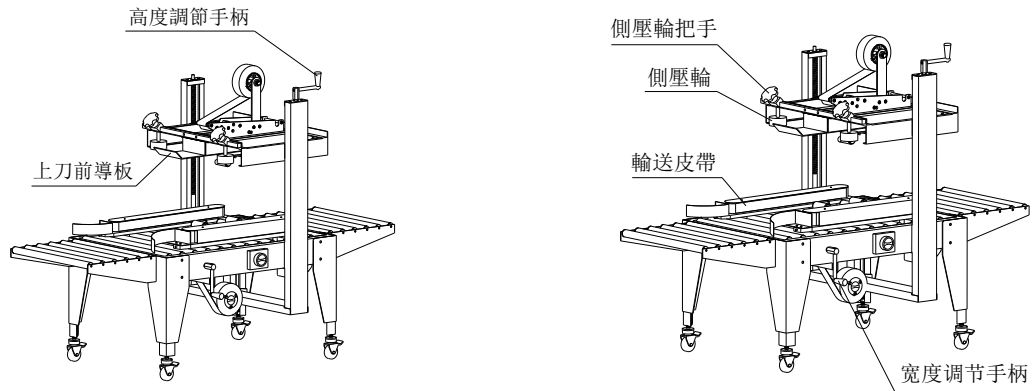
#### Step1: Table height adjustment

Ground the equipment on the properly storage place, adjust the table top to the desire height.

- (1) Loose the adjustable screw.
- (2) Adjust the height of the table leg.
- (3) Lock the screw.
- (4) Press the stopper to fix the position.

#### Step2: Install the roller frame

- (1) Let roller frame near to the machine frame, fixed to the corresponding fixed bolt, and then lock them.



### Step3: Height adjustment

- (1) Put a carton on the table.
- (2) Rotate the height adjustment crank to adjust the table height.
- (3) The front guide plate just need to be adjusted to touch the carton top.

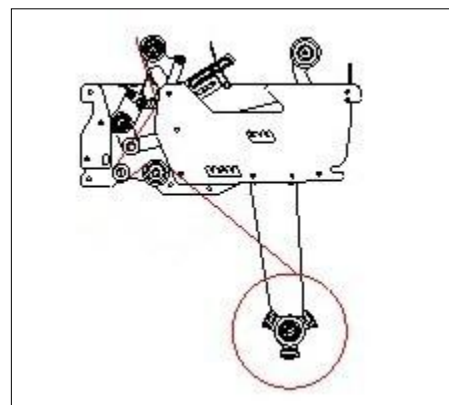
### Step4: Width adjustment

- (1) Rotate the width adjustment crank, the width just needs to be adjusted to clamp the carton properly and let it can be welled pass through.
- (2) Loose the handle of the side roller, adjust the gap between side rollers to touch the carton tightly, then turn the handle again to fix it.

### Thread illustration



Upper tape head

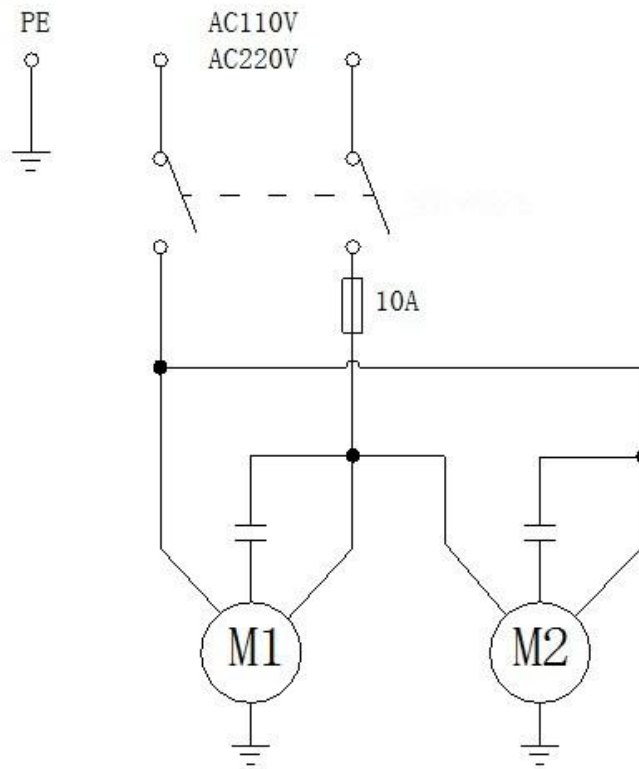


Lower tape head

## MAINTENANCE AND LUBRICATION

- ※ Please read the instruction manual prior to perform maintenance and inspection works.
- ※ Before performing maintenance work, please shut down the machine and disconnect the power supply, it is an important step to avoid missed the electricity.
- ※ If it is necessary to use the different specification of tape, please refer to the part list in this manual.
- ※ Periodically clean the grime, dust and dirt stuck on the belt and clean up any other parts of the machine.
- ※ To extend the blade longevity, please check if there are too much surplus viscose stuck on the blade, please clean it up and lubricate it.
- ※ To maintain the normal operation of the machine, please lubricate the movable parts of the machine weekly.

## ELECTIC DIAGRAM



## TROUBLE SHOOTING

Fault	Cause	Elimination
The carton can not be transported by the side driven belt	The carton width is too narrow.	Please use the appropriate size of the carton.
	The belt was worn.	Replace a new belt.
	The pressure of the upper tape head is not enough.	Adjust the upper tape head's height.
	Upper tape head's roller is positioned too low.	Adjust the roller position.
	The upper tape head's spring is too tight.	Loosen the spring to reduce the tension.
The driven belt will not move.	The belt's tension is not strong enough.	Adjust the belt's tension.
	The power is not being connected.	Please check the power line.
	The motor will not work.	Inspect the motor.
The belt was broken.	The belt was worn.	Replace a new belt.
	The belt tension is too tight.	Adjust the belt's tension.
The carton was jammed in too outlet.	Upper head's position is low.	Please adjust the upper tape head's height.
Noise occurred during machine operation.	The bearing was worn.	Replace the bearing.
The tape is not adhered to the center of the carton.	The carton is not being properly positioned.	Adjust the carton position.
The tape adhered to the carton is too long.	The way to thread the tape is wrong.	Please check the tape thread chapters of this manual.
The tape can not be cut, or the cut's edge is uneven.	The blades are blunt or break	Please replace a new blade.
	The tape tension is not strong enough.	Turn the screw clockwise to tighten it.
	Excess tape sticks on the blade.	Clean up the blade.
	The fixing nut is loose.	Replace a new nut.

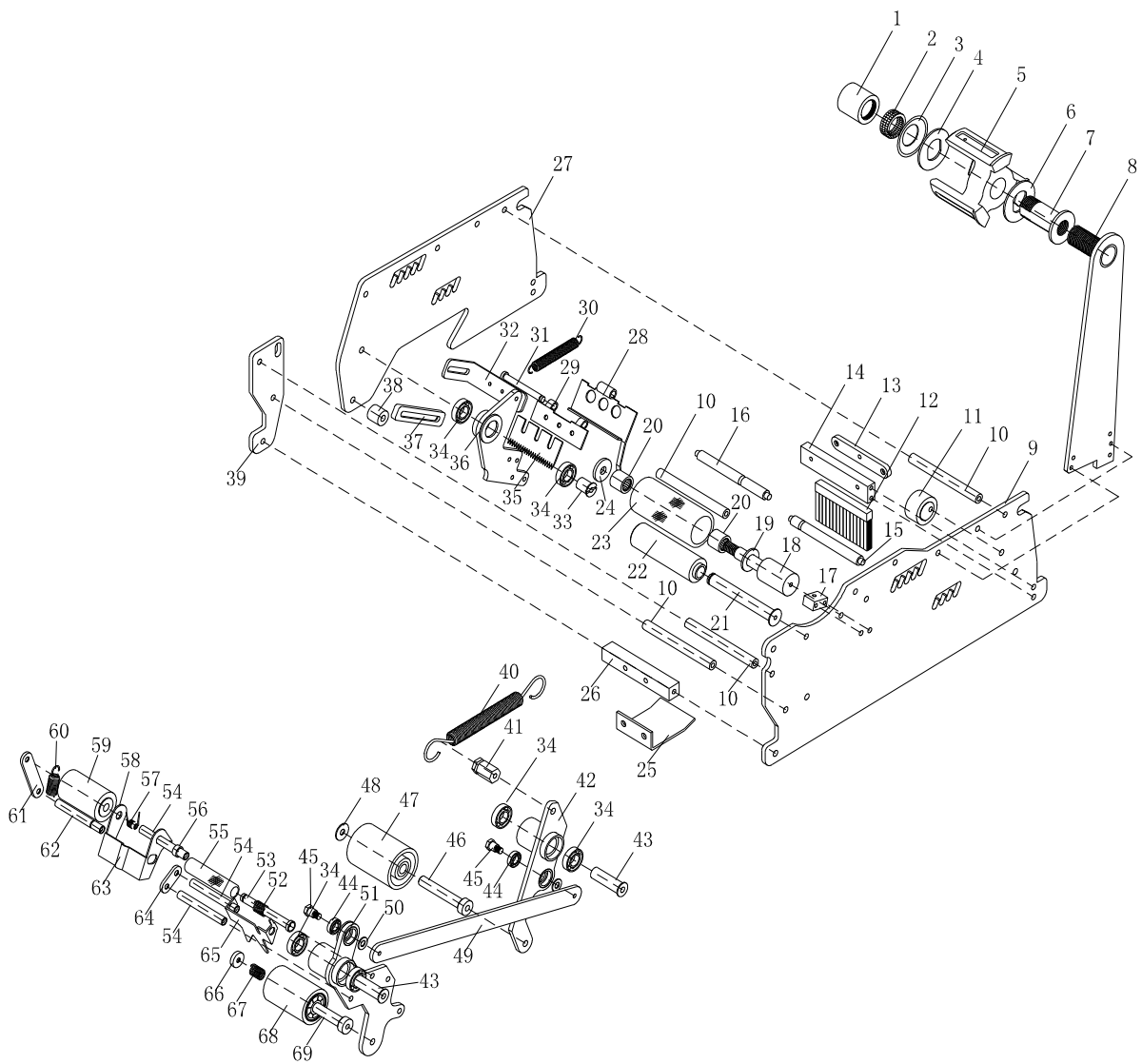
The carton is jammed.	The upper tape head is positioned too low.	Adjust the upper tape head's height.
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The tape adhered to the carton is too short.	The upper and lower guide roller can not spin very well.	Clean up the roller and lubricate it.
	The blade's position is displaced.	Adjust the blade position.
	The way to thread the tape is wrong.	Please check the tape thread chapters of this manual.
The tape is wrinkled and can not adhere to the carton very well.	The tape head's roller can not spin very well.	Clean up the roller and lubricate it.
	The tension of the tape base is too tight.	Loose the screw by turning the nut counterclockwise.
	The upper tape head's position is too high.	Adjust the upper tape head's height.
The tape draws back.	The single way roller is broken.	Replace a single way roller.
The lower tape's edge curves down.	The tape is too thin, or the tape's outer shape is changed	Please replace a new tape.

# Part List

# Tapping Head Assembly



# Tapping Head Assembly

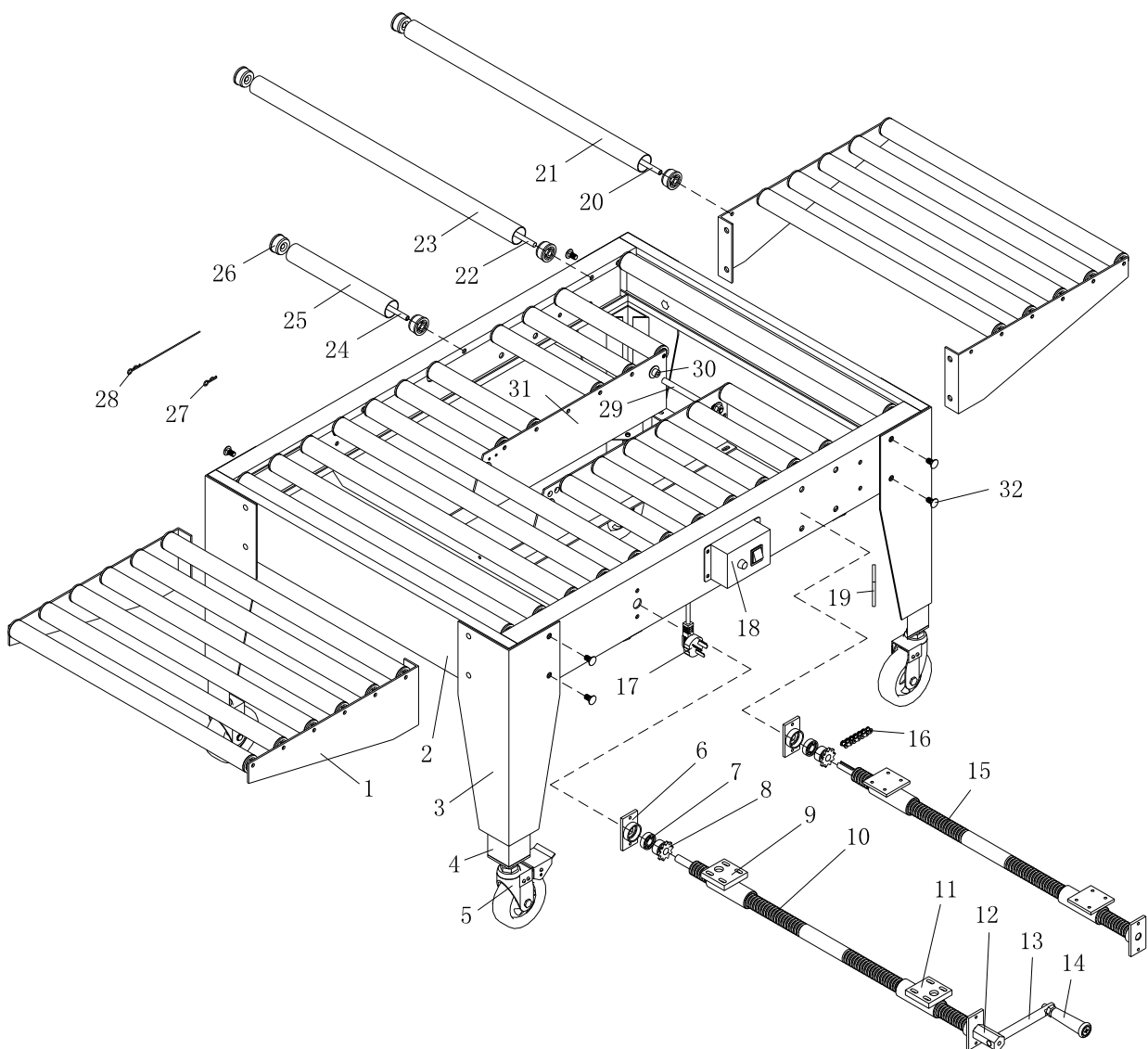
## ZF-FA500-MANUAL

NO.	PART NO.	PART NAME	QTY
1	SDW-100001	SCREW	1
2	SDW-100002	SPRING	1
3	SDW-100003	SPACER	1
4	SDW-100004	ACCESSORIES	1
5	SDW-100005	TAPE HOLDER	1
6	SDW-100004	ACCESSORIES	1
7	SDW-100006	FIXED SHAFT	1
8	SDW-100007	BASE SUPPORT PLATE	1
9	SDW-100008	LEFT PLATE	1
10	SDW-100009	LOCKING SHAFT	4
11	SDW-100010	STOP ROLLER	1
12	SDW-100011	BRUSH	1
13	SDW-100012	FIXED SEAT	1
14	SDW-100013	BRUSH PRESSING PLATE	1
15	SDW-100014	BLADE SPRING	1
16	SDW-100015	MAIN SPRING SHAFT	1
17	SDW-100016	ADJUSTALE BLOCK	1
18	SDW-100017	SINGLE WAY SHAFT	1
19	SDW-100018	SINGLE WAY SHAFT ACCESSORIES A	1
20	SDW-100019	SINGLE WAY BEARING HF1216	2
21	SDW-100020	PE GUIDE SHAFT	1
22	SDW-100021	PE GUIDE ROLLER	1
23	SDW-100022	SINGLE WAY ROLLER	1
24	SDW-100023	SINGLE WAY SHAFT ACCESSORIES B	1
25	SDW-100024	FRONT GUIDE PLATE	1
26	SDW-100025	FIXED SHAFT	1
27	SDW-100026	RIGHT PLATE A	1
28	SDW-100027	BLADE COVER	1
29	SDW-100028	BLADE LINK PLATE B	1
30	SDW-100029	SPRING	1
31	SDW-100030	BLADE LINK PLATE SHAFT	1
32	SDW-100031	BLADE LINK PLATE A	1
33	SDW-100032	FIXED SHAFT	1
34	SDW-100033	BEARING 6901Z	6
35	SDW-100034	BLADE	1
36	SDW-100035	BLADE ASSEMBLY	1
37	SDW-100036	EXTENSION PLATE	1
38	SDW-100037	STOP ROLLER	1
39	SDW-100038	RIGHT PLATE B	1
40	SDW-100039	MAIN SPRING	1
41	SDW-100040	MAIN SPRING HEXAGON SHAFT	1
42	SDW-100041	BACK PENDANT ASSEMBLY	1
43	SDW-100042	FIXED SHAFT	2
44	SDW-100043	BEARING 688Z	2
45	SDW-100044	LINK LOCKING SHAFT	2

## ZF-FA500-MANUAL

NO.	PART NO.	PART NAME	QTY
46	SDW-100045	BACK TAPE SHAFT	1
47	SDW-100046	BACK TAPE ROLLER	1
48	SDW-100047	SPACER	1
49	SDW-100048	LINK PLATE	1
50	SDW-100049	SPACER	2
51	SDW-100050	FRONT PENDANT ASSEMBLY	1
52	SDW-100051	GUIDE SPRING	1
53	SDW-100052	GUIDE SHAFT	1
54	SDW-100053	FIXED SHAFT	1
55	SDW-100054	GUIDE ROLLER	1
56	SDW-100055	STOP ROLLER	1
57	SDW-100056	FIXED PLATE SPRING	1
58	SDW-100057	FIXED PLATE	1
59	SDW-100058	AUXILIARY ROLLER	1
60	SDW-100059	SPRING	1
61	SDW-100060	SHAFT PRESSING PLATE	2
62	SDW-100061	SPRING	2
63	SDW-100062	FIXED PLATE	2
64	SDW-100063	SHAFT PRESSING PLATE	1
65	SDW-100064	TAPE TOP PLATE	1
66	SDW-100065	PINCH ROLLER CIRCLE	2
67	SDW-100066	SPRING	1
68	SDW-100067	FRONT TAPE ROLLER	1
69	SDW-100068	FRONT TAPE SHATT	1

# FRAME ASSEMBLY



## FRAME ASSEMBLY

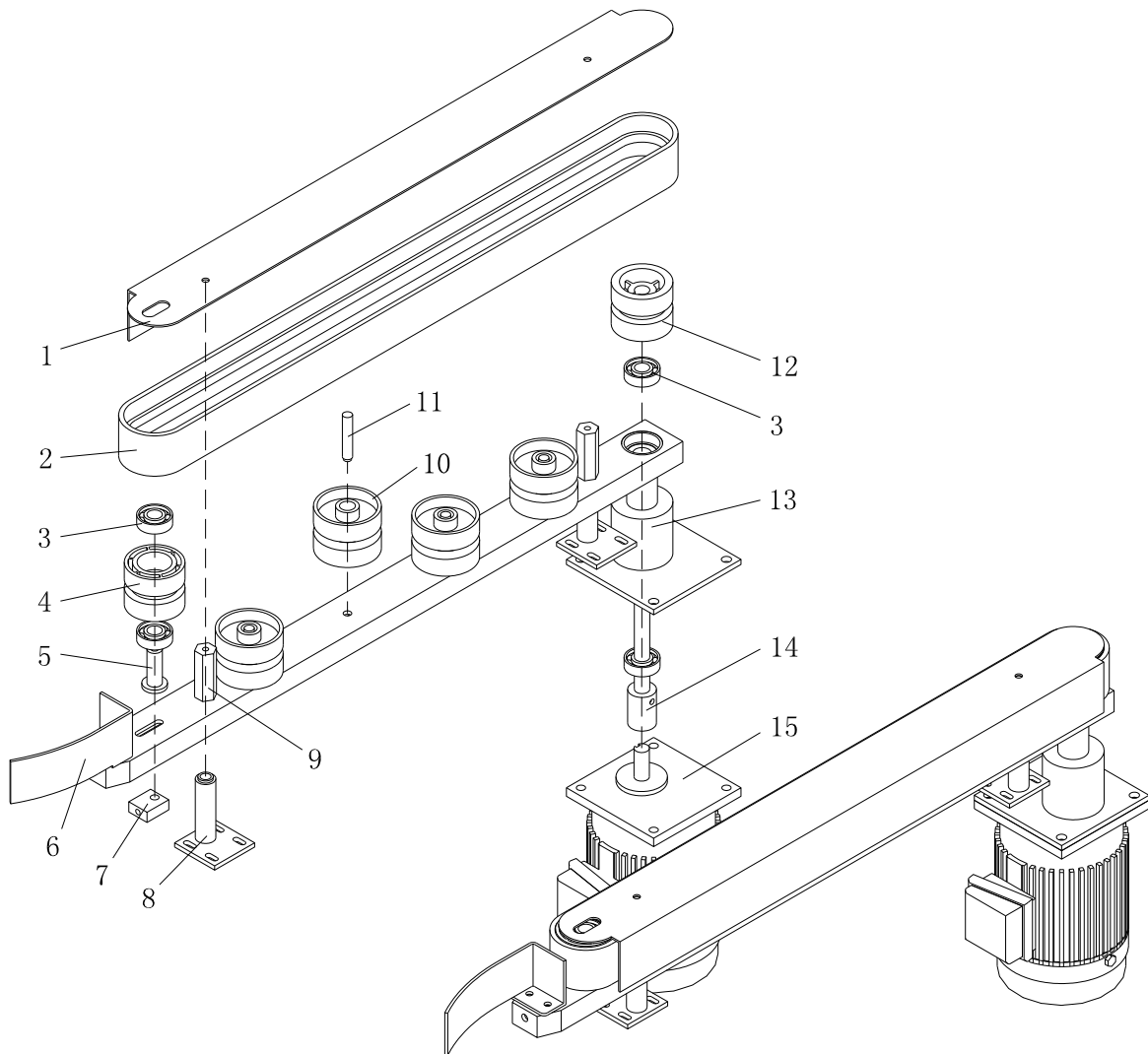
NO.	PART NO.	PART NAME	QTY
1	SDWF1-101011	PLATE OF ROLLER	4
2	SDWF1-101150	F1 FRAME	1
3	SDWF1-101001-400	LEG(400H)	4
4	SDWF1-101002-300	ADJUSTABLE LEG(300)	4
5	PA001	CASTER	2
	PA001B	CASTER(WITH BRAKE)	2
6	SDWF1-102001	SHAFT FIXED BASE	4
7	G04-216001	6001BEARING	4
8	06B-101200	SCREW $\Phi$ 12	2
9	SDWF1-102014	DENTAL TUBE - RIGHT	2
10	SDWF1-102009	DENTAL TUBE - FRONT	4
11	SDWF1-102015	DENTAL TUBE - LEFT	2
12	SDWF1-102016	CRANK PILLER	1
13	SDWFJ-1A-61	CRANK	2
14	SDWFJ-1A-110	CRANK HANDLE	1
15	SDWF1-102010	DENTAL TUBE - BACK	1
16	06B-1*170L	CHAIN	1
17	E61-125321	PLUG	1
18	SDWFJ-MD-40	ELECTRICAL BOX	1
19	SDWF1-101003	FIXED PLATE	1
20	SDWF1-102022-25	ROLLER AXLE	1
21	SDWF1-102021-25	ROLLER	4
22	SDWF1-102022-35	FRONT & BACK ROLLER AXLE	8
23	SDWF1-102021-35	FRONT & BACK ROLLER	32
24	SDWF1-102022-15-2	ROLLER AXLE(500W)2"	12
	SDWF1-102022-15-3	ROLLER AXLE(500W)3"	12
25	SDWF1-102021-15-2	ROLLER(500W)2"	8
	SDWF1-102021-15-3	ROLLER(500W)3"	2
26	SDW-CG-1	ROLLER PLUG	4
27	SDW-10750001	ROLLER BOLT(SHORT)	4
28	SDW-10750001	ROLLER BOLT(LONG)	2
29	SDWF1-102025-2	LOCK SHAFT 2"	
	SDWF1-102025-3	LOCK SHAFT 3"	
30		M8*20L SCREW	

## ZF-FA500-MANUAL

31	SDWF1-101350-2	PLATE 2"	
	SDWF1-101350-3	PLATE 3"	
32	SDWF1-102023	SCREW M8*19	



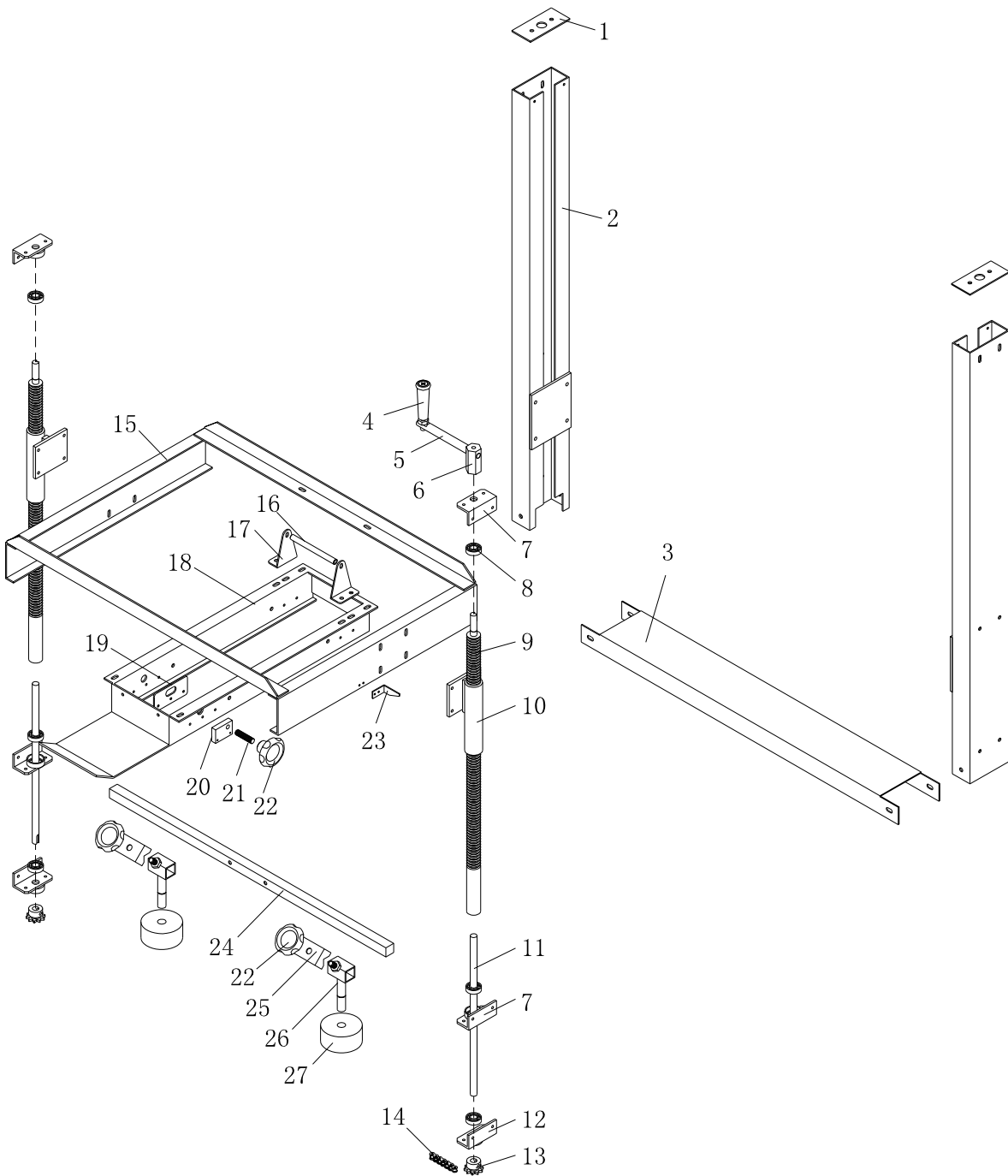
# SIDE DRIVEN ASSEMBLY



## SIDE DRIVEN ASSEMBLY

項次	品 號	品名規格	數量
1	SDWF1-101009	BELT COVER	2
2	PD-154050	BELT 1540*W50	2
3	G04-216003	6003BEARING	8
4	SDWFJ-1A-102	CYCL	2
5	SDWF1-102003	SHAFT	2
6	SDWF1-101010	FRONT GUIDE PLATE	2
7	SDWF1-102005	BELT ADJUSTMENT BLOCK	2
8	SDWF1-102004	BELT SUPPORT ASSEMBLY	4
9	SDW-CA301700	SUPPORT AXLE	4
10	SDWFJ-1A-85	ROLLER	8
11	SDWF1-102007	ROLLER AXLE	8
12	SDWFJ-1A-103	MAIN ROLLER	2
	SDWFJ-1A-111	FRICTION CYCL	2
13	SDWF1-101250	BELT ASSEMBLY	2
14	SDWF1-102002	MAIN SHAFT	2
15	MD-2201618	MOTOR 1:15 Φ16 1/8HP 220V	2

# MAST ASSEMBLY



ZF-FA500-MANUAL  
MAST ASSEMBLY

項次	品 號	品名規格	數量
1	SDWF1-101005	COVER	2
2	SDWF1-101004	PLATE	2
3	SDWF1-101008	CHAIN COVER	1
4	SDWFJ-1A-110	CRANK HANDLE	1
5	SDWFJ-1A-61	CRANK	1
6	SDWF1-102016	CRANK PILLER	1
7	SDWF1-102012	FIXED PLATE	4
8	G04-216001	6001 BEARING	6
9	SDWF1-102008	DENTAL RACK	2
10	SDWF1-102011	DENTAL TUBE	2
11	SDWF1-102020	EXTENTION SHAFT	2
12	SDWF1-102013	FIXED BASE	2
13	06B-101200	TOOTHED CHAIN WHEEL $\Phi$ 12	2
14	06B-1*120L	06B CHAIN 120L	1
15	SDWF1-101550	UPPER FRAME	1
16	SDWFJ-1A-67	SUPPORT AXLE PLATE	1
17	SDWF1-101450.1	SUPPORT AXLE PLATE	2
18	SDWF1-101450-2	UPPER TAPE HEAD FRAME	1
19	SDWF1-101450.2	FIXED PLATE	2
20	SDWF1-101450.3	HANDWEEL BLOCK	1
21	SDWFJ-1A-125	HANDWEEL ROD	1
22	SDWFJ-1A-109	HANDWEEL	3
23	SDWF1-101007	INDICATOR	1
24	SDWFJ-MA-53	SQUARE SHAFT	1
25	SDWFJ-MA-56	FIXED PLATE	2
26	SDWFJ-MA-50.1	CASTER ASSEMBLT	2
27	SDW-CA100600	SIDE ROLLER	2

