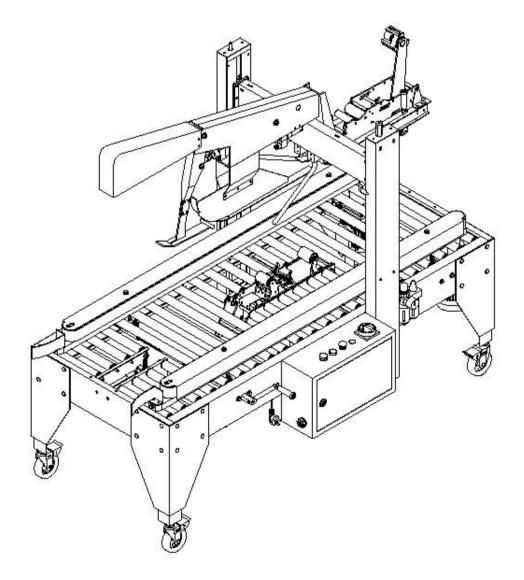
# SEMI AUTO CARTON SEALER MACHINE

# ZF-FC500



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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 staring the machine.

#### SAFETY RULES

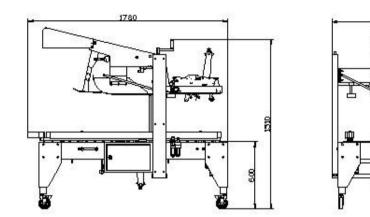
- \* The machine can not be operated by untrained personal.
- ※ Please observe all the precautions and warning labels.
- \* Do not remove or make any changes of the safety device.
- \* When the machine is operating, do not make other maintains or repair works
- \* Please replace the cover after completing 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.

#### WARNING LABELS





# TECHNICAL DATA



NO.	NAME
	1 12 111112

SPECIFICATION

940

1	MAHCINE MODEL	SDW-FC500
2	SEALING SPEED	800~900 / PER HOUR
3	CARTON DIMENTION (W)	150mm~500mm
4	CARTON DIMENTION (H)	120mm~500mm
5	CARTON DIMENTION (L)	200mm~600mm
6	TAPE APPLICABLE	48~60~75W x 1000ML
7	TABLE HEIGHT	570 ~770 mm (ADJUSTABLE)
8	DIMENSION	L1880 x W900 x H1510mm
9	WEIGHT	≈180Kgs
10	NOISE DEGREE	MAX: 80dBA
11	ELECTRIC CONSUMPTION	MAX: 0.2KW
12	VOLTAGE USAGE	220V/50Hz/60Hz/1Ph
13	PNEUMATIC USAGE	380V/50Hz/60Hz/3Ph 3kgf/cm 100nl/min

#### INSTALLATION

% The power supply system, voltage and frequency must correspond to the regulation label attached to the machine.

※ Connect the plug.

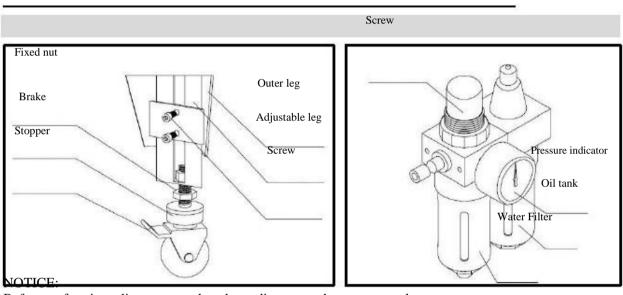
% Operate the machine by the side switch.

#### NOTICE:

Please install the machine where a power supply can be easily connected.

It is necissary to disconnect the power supply plug prior to open the control box's cover.

#### ADJUSTMENT



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.

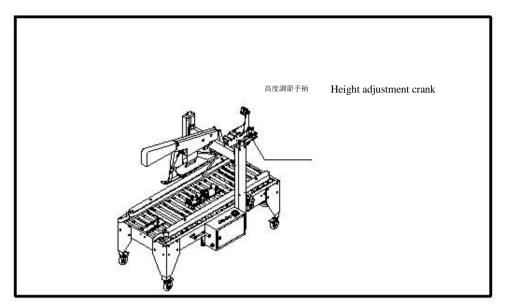
Step2: Pneumatic adjustment

(1) Link the machine to the pneumatic supply.

(2) Pull the screw and turn it clockwise to increase the pressure or counterclockwise to decrease the pressure

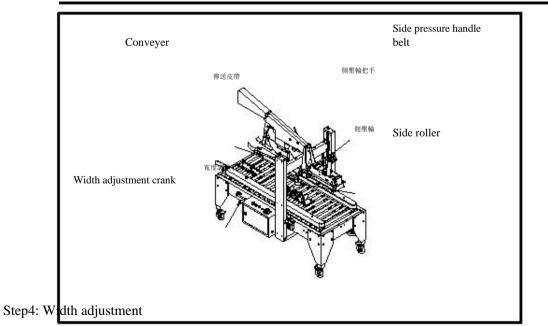
(3) The pneumatic pressure should be adjusted to about 5-6kg/cm.

(4) Turn the screw tightly after completing the adjustment works.



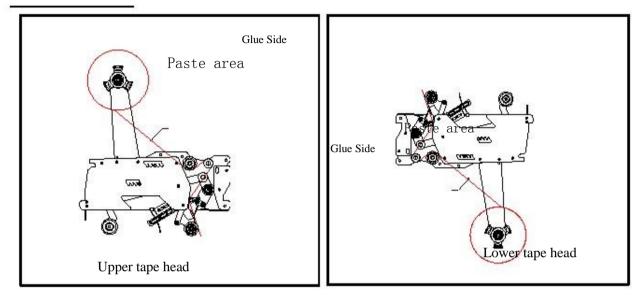
Step3: Height adjustment

- (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.



- (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.

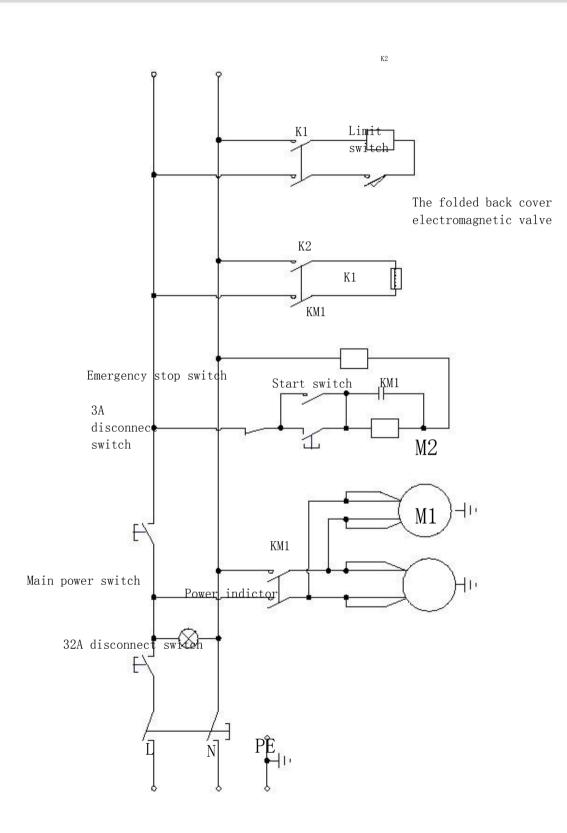
#### Thread illustration



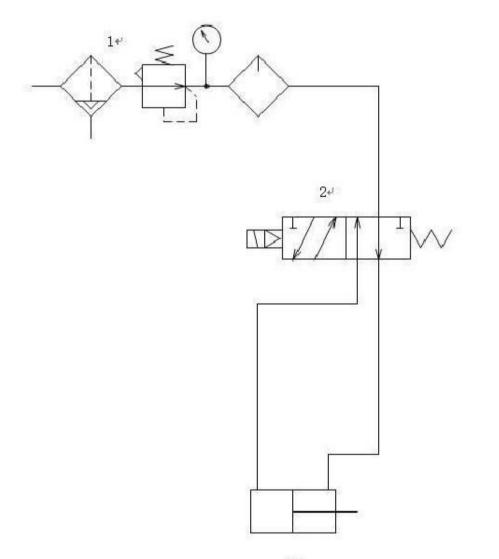
MAINTENANCE AND LUBRICATION

- \* Please read the instruction manual prior to perform maintenance and inspection works.
- \* Before performing maintenance work, please shout down the machine and disconnect the power supply, it is an important step to avoid missed the electricity.
- X 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.
- X To maintain the normal operation of the machine, please lubricate the movable parts of the machine weekly.

#### ELECTIC DIAGRAM



#### PNEUMATIC CONTROL DIAGRAM



3+

NO.PARTS NO.SPECIFICATIONQTY1AFR/L-02FILTER12VS520-02-2SSOLENOID VALVE13Q01-040150CYLINDER 40\*1501--

# TROUBLE SHOOTING

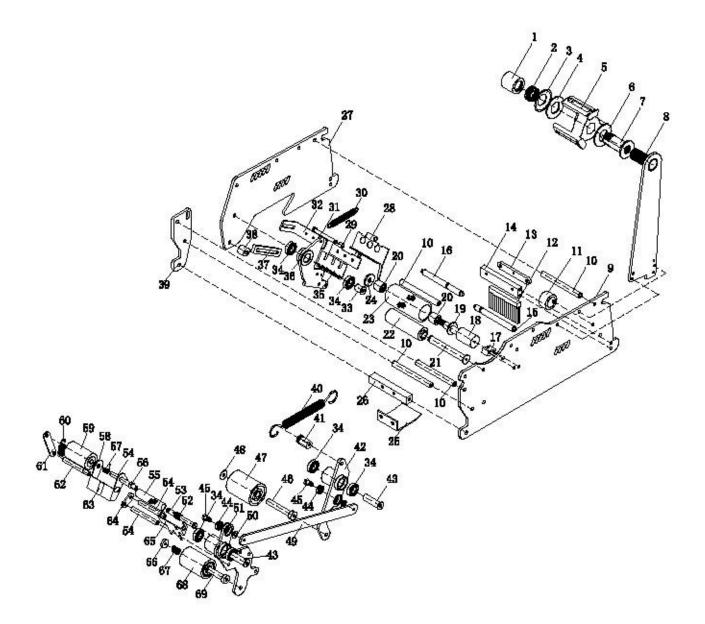
Fault	Cause	Elimination
	The carton width is too narrow. Pleas	e use the appropriate size of the carton.
	The belt was worn Replace a new b	elt
The carton can not be transported by the side driven belt	The pressure of the upper tape Adju head is not enough height. Upper tape head's roller is Adjust th	
	positioned too low.	
The driven belt will not	The upper tape head's spring Loose is too tight. tension. The belt's tension is not strong Adju enough.	
move.	The power is not being connected.	Please check the power line.
	The motor will not work.	Inspect the motor.
8	The beit was worn.	Replace a new belt.
The belt was broken.	The belt tension is too tight.	Adjust the belt's tension.
The carton was jammed in Upp Outlet .low .head's height.	per head's position is too Please adjus	t the upper tape
Noise occurred during The bea	ring was worn.	Replace the bearing.
machine operation. The tape is not adhered to The the center of the carton. proper	•	Adjust the carton position.
The tape adhered to the way to	thread the tape is Please check the ta ters of this manual.	pe thread
	The blades are blunt or break. Pleas tape tension is not strong Turn the scr	· · ·
the cut's edge is uneven, enoug	1. 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. The upper and lower guide	Adjust the upper tape head's height. Clean up the roller and lubricate
	roller can not spin very well.	it.
The tape adhered to the blade' carton is too short.	s position is lisplaced.	Adjust the blade position.
	The way to thread the tape is Please wrong. chapters of this manual.	check the tape thread
The tape is wrinkled and The t	The tape head's roller can not Clean spin very well. it.	_
can not adhere to the too tight.		
The tape draws back.	The single way roller is broken. Rep	lace a single way roller.
The lower tape's edge curves down.	The tape is too thin, or Please replac tape's outer shape is changed	e a new tape.

# Part list

SDW-FC500

# TAPPING HEAD ASSEMBLY

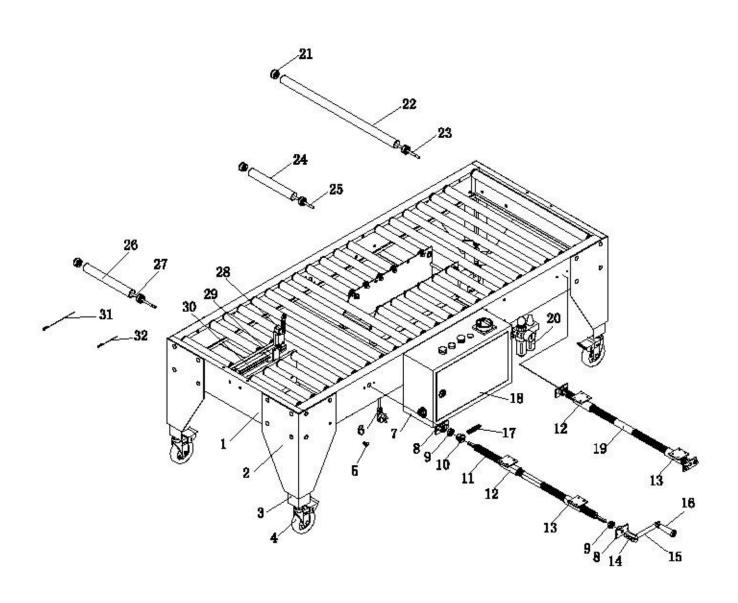


# Tapping Head Assembly

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 10
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
8 H	SDW-100010	STOP ROLLER	1
-12	SDW-100011	BRUSH	1
13	SDW-100012	FIXED SEAT	
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	
<u></u>	SDW 100017	SINGLE WAY SHAFT	1
19	SDW-100018	SINGLE WAY SHAFT ACCESSORIES A	
20	SDW-100019 SDW-100020	SINGLE WAY BEARING HF1216 PE GUIDE SHAFT	2
21			1
-22 23	SDW-100021 SDW-100022	PE GUIDE ROLLER SINGLE WAY ROLLER	
24	SDW-100022 SDW-100023	SINGLE WAT ROLLER SINGLE WAY SHAFT ACCESSORIES B	1
25	SDW-100024	FRONT GUIDE PLATE	1 10
26	SDW-100024 SDW-100025	FIXED SHAFT	1
-20	SDW-100025	RIGHT PLATE A	
	SDW-100027	BLADE COVER	
29	SDW-100028	RI ADE 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
	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
<u> </u>	SDW 100038	RIGHT PLATE B	
40	SDW-100039	MAIN SPRING	
41	SDW-100040	MAIN SPRING HEXAGON SHAFT	1
42	SDW-100041	BACK PENDANT ASSEMBLY	1
43	SDW-100042 SDW-100043	FIXED SHAFT BEARING 688Z	2
45	SDW-100043 SDW-100044	LINK LOCKING SHAFT	2
4.)	S12 W - 100044		
3 <del>35</del>			
31			
83 10			
-			
	-		
167 1899			10
600 1			

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	I
	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
	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
	SDW-100062	FIXED PLATE	2
64	SDW-100063	SHAFT PRESSING PLATE	1
65	SDW-100064	TAPE TOP PLATE	1
66	SDW-100065	PINCH ROOLER CIRCLE	2
67	SDW-100066	SPRING	1
	SDW-100067	FRONT TAPE ROLLER	1
69	SDW-100068	FRONT TAPE SHATT	1
8			
100 100			

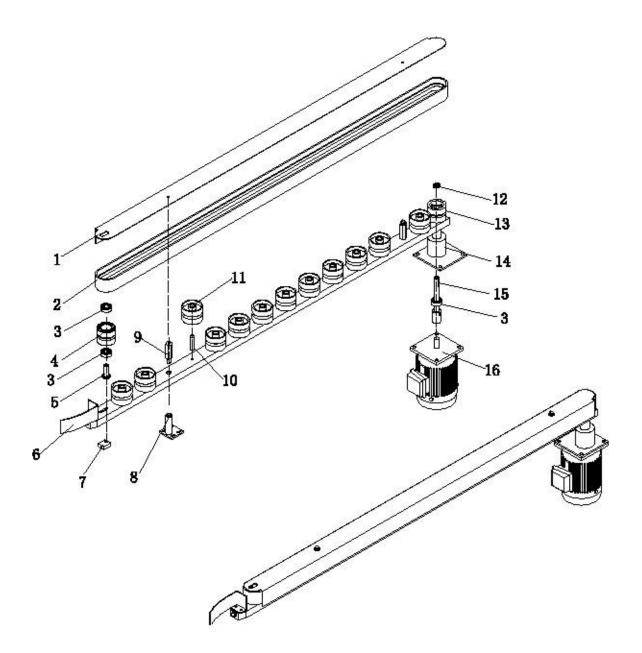
## FRAME ASSEMBLY



#### FRAME ASSEMBLY

NO.	PART NO.	PART NAME	QTY
1	SDWF3-101350-500	F3 FRAME	1
2	SDWF3-101001-400	F3 LEG	4
3	SDWF1-101002-300	ADJUSTABLE LEG(300)	4
4	PA001B	CASTER(WITH BRAKE)	4
5	SDWF1-102023	SCREW M8*19	32
6	E61 125321	PLUG	1
7	SDWFJ 3A 20	ELECTRICAL BOX	1
8	SDWF1-102001	SHAFT FIXED BASE	4
	G04 216001	6001BEARING	4
<u>    10   </u>	06B101200	SCREW Φ12	2
11	SDWF1-102009	DENTAL TUBE - FRONT	1
12	SDWF1 102014	DENTAL TUBE RIGHT	2
13	SDWF1-102015	DENTAL TUBE - LEFT	2
14	SDWF1 102016	CRANK PILLER	
15	SDWFJ-1A-61	CRANK	1
16	SDWFJ-1A-110	CRANK HANDLE	1
17	06B 1*170L	CHAIN	2
18	SDWFJ 3A 21	DOOR OF ELECTRICAL BOX	1
10	SDWF1-102010	DENTAL TUBE – BACK	1
<u>19</u> 20	AFR2000 1V	FILTER	1
21	SDW CG 1	BOLLER PLUG	68
<u></u>			12
22	SDWF1 102021 35 SDWF1 102022 35	FRONT & BACK ROLLER (500W)	12
	SDWF1_102022_35 SDWF1_102021_15	FRONT & BACK ROLLER AXLE (500W) ROLLER (500W)	
			12
	SDWF1 102022 15	ROLLER AXLE (500W)	
<u>26</u>	SDWF3-102011-1F	FRONT ROLLER (500W)	8
7	SDWF3-102010-F	FRONT ROLLER AXLE (500W)	
<u>28</u>	SF 8108	TRAVEL SWITCH	
<u>    29  </u>	SDWFJ-3A-76	TRAVEL SWITCH FRAME	
	SDWF3 4	TRAVEL SWITCH SLIDING FRAME	
31	SDW-10750001	ROLLER BOLT(SHORT)	6
32	SDW-10750001	ROLLER BOLT(LONG)	3
10			
<u>)</u>			
2			

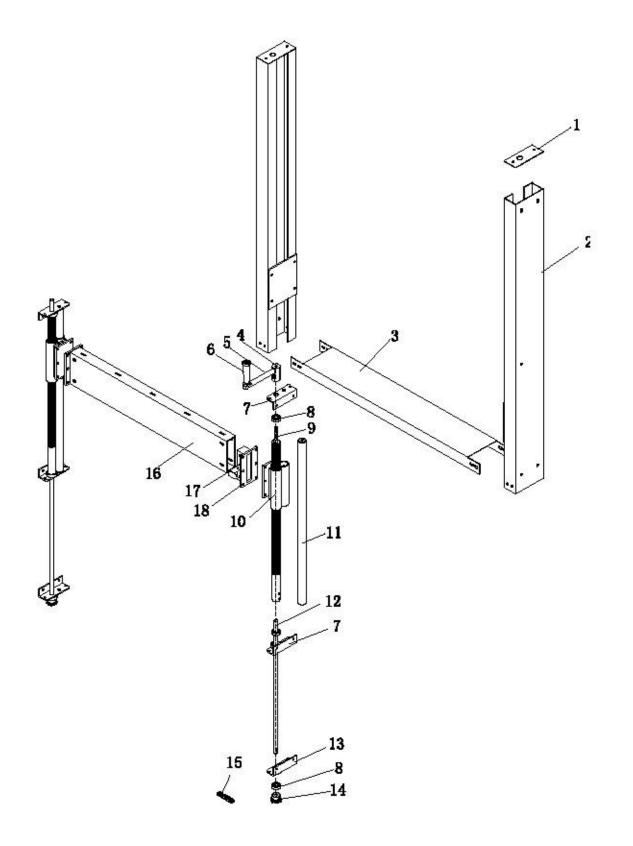
SIDE DRIVEN ASSEMBLY



#### SIDE DRIVEN ASSEMBLY

1     SDWF3-101002     F3 BELT COVER     2       2     PD-316050     BELT 3160*W50     2       3     G04-216003     6003 BEARING     8       4     SDWFJ-1A-102     CYCL     2       5     SDWF1-102003     SHAFT     2       6     SDWF1-102003     SHAFT     2       7     SDWF1-102005     BELT ADJUSTMENT BLOCK     2       8     SDWF1-102004     BELT SUPPORT ASSEMBLY     4       9     SDW-CA301700     SUPPORT AXLE     4       10     SDWF1-102007     ROLLER AXLE     8       11     SDWF2-102004.1     ROLLER CLAMPING RING     2       12     SDWF1-102004     BELT ADJUSTMENT GUING     2       13     SDWF1-102007     ROLLER AXLE     8       11     SDWF2-102004.1     ROLLER CLAMPING RING     2       13     SDWF1-1A-103     MAIN ROLLER     2       14     SDWF3-101250     BELT ASSEMBLY     2       15     SDWF1-102002     MAIN SHAFT     2       16     MD-2201618     MOTOR F115 Φ16 1/8HP 220V     2	NO.	PART NO.	PART NAME	QTY
3       G04-216003       6003 BEARING       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       SDWF1-102007       ROLLER AXLE       8         11       SDWFJ-1A-85       ROLLER       24         12       SDWFJ-1A-85       ROLLER CLAMPING RING       2         13       SDWFJ-1A-103       MAIN ROLLER       2         14       SDWFJ-1A-111       FRICTION CYCL       2         14       SDWFJ-102002       MAIN SHAFT       2	1	SDWF3-101002	F3 BELT COVER	2
4SDWFJ-1A-102CYCL25SDWF1-102003SHAFT26SDWF1-101010FRONT GUIDE PLATE27SDWF1-102005BELT ADJUSTMENT BLOCK28SDWF1-102004BELT SUPPORT ASSEMBLY49SDWF1-102007ROLLER AXLE410SDWF1-102007ROLLER AXLE811SDWFJ-1A-85ROLLER CLAMPING RING213SDWFJ-1A-103MAIN ROLLER214SDWF3-101250BELT ASSEMBLY215SDWF1-102002MAIN SHAFT2	2	PD-316050	BELT 3160*W50	2
5SDWF1-102003SHAFT26SDWF1-101010FRONT GUIDE PLATE27SDWF1-102005BELT ADJUSTMENT BLOCK28SDWF1-102004BELT SUPPORT ASSEMBLY49SDW-CA301700SUPPORT AXLE410SDWF1-102007ROLLER AXLE811SDWFJ-1A-85ROLLER2412SDWFJ-102004.1ROLLER CLAMPING RING213SDWFJ-1A-103MAIN ROLLER214SDWFJ-102002BELT ASSEMBLY215SDWF1-102002MAIN SHAFT2	3	G04-216003	6003 BEARING	8
6SDWF1-101010FRONT GUIDE PLATE27SDWF1-102005BELT ADJUSTMENT BLOCK28SDWF1-102004BELT SUPPORT ASSEMBLY49SDW-CA301700SUPPORT AXLE410SDWF1-102007ROLLER AXLE811SDWF1-102007ROLLER CLAMPING RING2412SDWF2-102004.1ROLLER CLAMPING RING213SDWFJ-1A-103MAIN ROLLER214SDWF3-101250BELT ASSEMBLY215SDWF1-102002MAIN SHAFT2	4	SDWFJ-1A-102	CYCL	2
7SDWF1-102005BELT ADJUSTMENT BLOCK28SDWF1-102004BELT SUPPORT ASSEMBLY49SDW-CA301700SUPPORT AXLE410SDWF1-102007ROLLER AXLE811SDWFJ-1A-85ROLLER2412SDWF2-102004.1ROLLER CLAMPING RING213SDWFJ-1A-103MAIN ROLLER214SDWF3-101250BELT ASSEMBLY215SDWF1-102002MAIN SHAFT2	5	SDWF1-102003	SHAFT	2
8SDWF1-102004BELT SUPPORT ASSEMBLY49SDW-CA301700SUPPORT AXLE410SDWF1-102007ROLLER AXLE811SDWFJ-1A-85ROLLER2412SDWF2-102004.1ROLLER CLAMPING RING213SDWFJ-1A-103MAIN ROLLER214SDWF3-101250BELT ASSEMBLY215SDWF1-102002MAIN SHAFT2	6	SDWF1-101010	FRONT GUIDE PLATE	2
9SDW-CA301700SUPPORT AXLE410SDWF1-102007ROLLER AXLE811SDWFJ-1A-85ROLLER2412SDWF2-102004.1ROLLER CLAMPING RING213SDWFJ-1A-103MAIN ROLLER214SDWF3-101250BELT ASSEMBLY215SDWF1-102002MAIN SHAFT2	7	SDWF1-102005	BELT ADJUSTMENT BLOCK	2
10SDWF1-102007ROLLER AXLE811SDWFJ-1A-85ROLLER2412SDWF2-102004.1ROLLER CLAMPING RING213SDWFJ-1A-103MAIN ROLLER214SDWFJ-1A-111FRICTION CYCL215SDWF1-102002MAIN SHAFT2	8	SDWF1-102004	BELT SUPPORT ASSEMBLY	4
11SDWFJ-1A-85ROLLER2412SDWF2-102004.1ROLLER CLAMPING RING213SDWFJ-1A-103MAIN ROLLER213SDWFJ-1A-111FRICTION CYCL214SDWF3-101250BELT ASSEMBLY215SDWF1-102002MAIN SHAFT2	9	SDW-CA301700	SUPPORT AXLE	4
12SDWF2-102004.1ROLLER CLAMPING RING213SDWFJ-1A-103MAIN ROLLER213SDWFJ-1A-111FRICTION CYCL214SDWF3-101250BELT ASSEMBLY215SDWF1-102002MAIN SHAFT2	10	SDWF1-102007	ROLLER AXLE	8
Image: 13SDWFJ-1A-103MAIN ROLLER2Image: 13SDWFJ-1A-111FRICTION CYCL2Image: 14SDWF3-101250BELT ASSEMBLY2Image: 15SDWF1-102002MAIN SHAFT2	11	SDWFJ-1A-85	ROLLER	24
13	12	SDWF2-102004.1	ROLLER CLAMPING RING	2
SDWFJ-1A-111       FRICTION CYCL       2         14       SDWF3-101250       BELT ASSEMBLY       2         15       SDWF1-102002       MAIN SHAFT       2	10	SDWFJ-1A-103	MAIN ROLLER	2
15 SDWF1-102002 MAIN SHAFT 2	13	SDWFJ-1A-111	FRICTION CYCL	2
	14	SDWF3-101250	BELT ASSEMBLY	2
16       MD-2201618       MOTOR 1:15 Φ16 1/8HP 220V       2	15	SDWF1-102002	MAIN SHAFT	2
	16	MD-2201618	MOTOR 1:15 Φ16 1/8HP 220V	2
		62 69		

## MAST ASSEMBLY

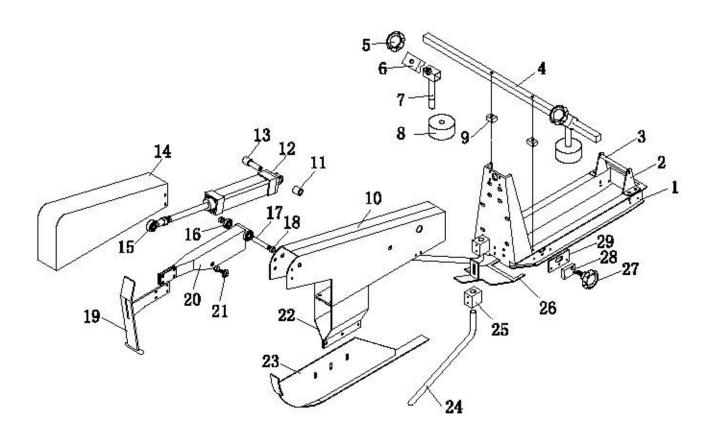


## MAST ASSEMBLY

NO.	PART NO.	PART NAME	QTY
1	SDWF1-101005-A	COVER	2
2	SDWF3-101003-500	PLATE	2
3	SDWF3-101005-500	CHAIN COVER	2
4	SDWF1-102016	CRANK PILLER	1
5	SDWFJ-1A-61	CRANK	
6	SDWFJ-1A-110	CRANK HANDLE	
-7-	SDWF1-402012	FIXED BASE	4
8	G04-216001	6001 BEARING	6
9	SDWF3-102001-500	F3 DENTAL RACK (500H)	2
10	SDWF3-102004	F3 DENTAL TUBE	2
11	SDWF3-102002-500	F3SLIDING SHAFT(500H)	2
12	SDWF3-102003	EXTENTION SHAFT	2
13	SDWF1-402013	FIXED BASE	2
14	06B-101200	TOOTHED CHAIN WHEEL Φ12	2
15	06B-1*120L	06B CHAIN 120L	1
16	SDWF3-102005	CONNECTING BASE	2
17	SDWF3-101016	INDICATOR	1
18	SDWF3-101006	LINK BASE	1

SDW-F3

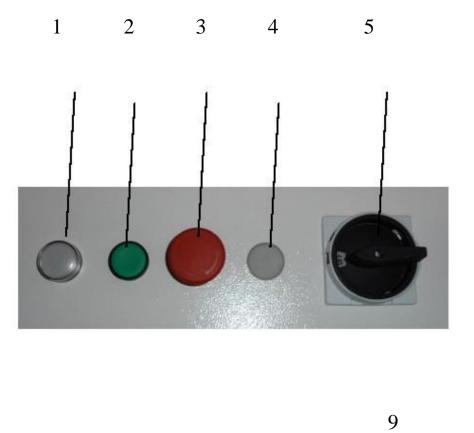
# GRIP & KNOCK BAR ASSEMBLY

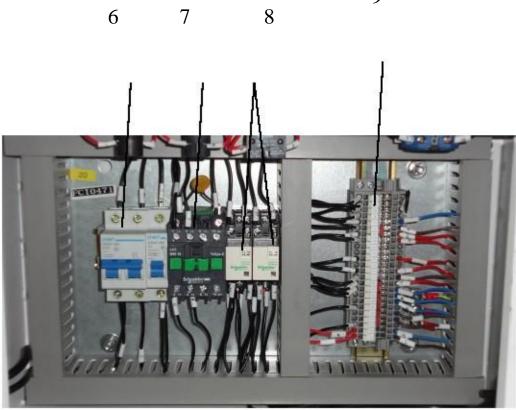


# SDW-F3

#### GRIP AND KNOCK BAR ASSEMBLY

1	SSDWF3-101007		
2		F3 UPPER BLADE	1
	SDWF1-101450.1	SUPPORT AXLE PLATE	2
3	SDWFJ-1A-67	SUPPORT AXLE PLATE	1
4	SDWF3-2	SQUARE SHAFT	1
5	SDWFJ-1A-109	HANDWEEL	3
6	SDWFJ-MA-56	FIXED PLATE	2
7	SDWFJ-MA-50.1	CASTER ASSEMBLT	2
8	SDW-CA100600	SIDE ROLLER	2
9	SDWF3-3	SQUARE SHAFT BLOCK	2
10	SDWF3-101009	BAR HOLDER	1
11	SDWF3-6	CYLINDER FIXED SLEEVE	1
12	QG-040150	CYLINDER40*150	1
13	SDWF3-5	CYLINDER BACK SHAFT	1
14	SDWF3-101014	PROTECT COVER	1
15	YY-100012	12F魚BALL BEARING	1
16	G04-216001	6001BEARING	2
17	SDWF3-7	KNOCK BAR SHAFT	1
18	SDWF3-8	KNOCK BAR SLEEVE	3
19	SDWF3-101011	KNOCK HEAD	1
20	SDWF3-101010	KNOCK BAR	1
21		M12*50 SCREW	1
22	SDWF3-101012	PLATE FIXED BASE	2
23	SDWF3-101013	PLATE	1
24	SDWF3-102007	FOLDING ARM	2
25	SDWF3-102006	FOLDING ARM FIXED BASE	2
26	SDWF3-101015	FRONT GUIDING PLAT	······································
27	SDWFJ-1A-109	HANDWEEL	3
28	SDWF1-101450.3	HANDWEEL BLOCK	1
29	SDWF1-101450.2	FRONT GUIDE PLATE	2





NO.	PART NO.	PART NAME	QTY
1	K01-010002R	POWER LIGHT(WHITE)	1
2	K01-010001G	START SWITCH (GREEN)	1
3	K01-010003	EMERGENCY STOP SWITCH	1
4	5	STOPPER	1
5	K01-010004	MAIN POWER LIGHT	1
6	K01-010032	32A CUT-OUT SWITCH	1
0	K01-010030	3A CUT-OUT SWITCH	1
7	K01-010005	CONTACTOR	1
8	K01-010006	RELAY 230V/AC 5A	2
	K01-010007	RELAY BASE	2
9	K01-010008	TERMINAL BLOCK	24
	6		0.3