

SEMI AUTO CARTON SEALER MACHINE

ZF-FC500

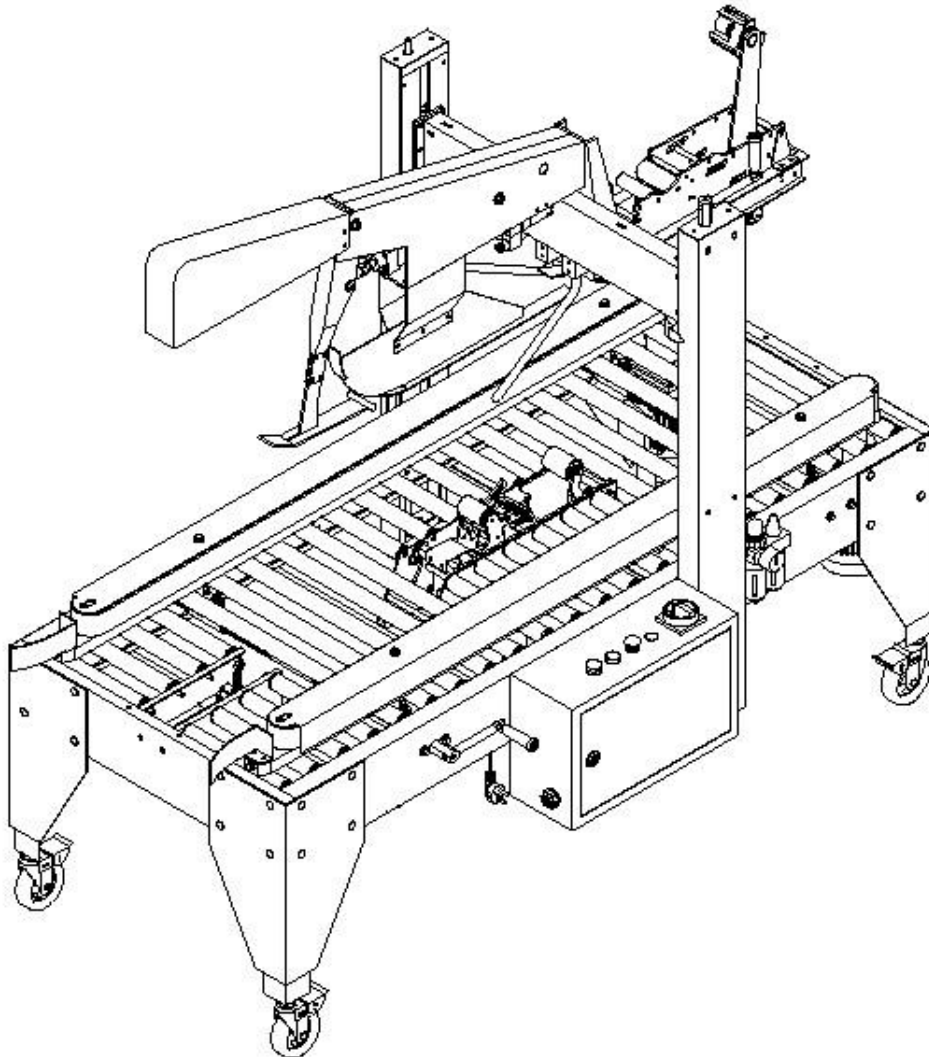


TABLE OF THE CONTENT

1. PREFACE	3
SAFETY RULES	3
WARNING LABELS	3
TECHNICAL DATA	4
INSTALLATION	5
<hr/>	
2. ADJUSTMENT	5
MAINTENANCE & LUBRICATION	7
<hr/>	
3. ELECTRIC DIAGRAM	8
PNEUMATIC DIAGRAM	9
<hr/>	
4. TROUBLE SHOOTING	10
<hr/>	
5. TAPPING HEAD ASSEMBLY	13
<hr/>	
6. FRAME ASSEMBLY	16
<hr/>	
7. SIDE DRIVEN ASSEMBLY	19
<hr/>	
8. MAST ASSEMBLY	21
<hr/>	
9. GRIP & KNOCK BAR ASSEMBLY	23
<hr/>	
<hr/>	

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.

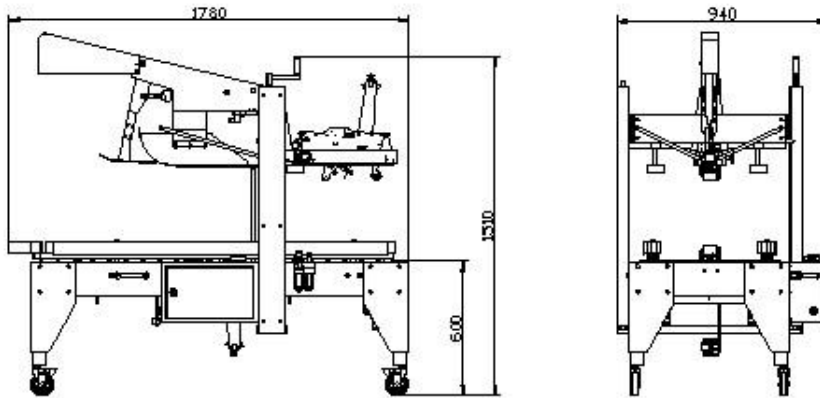
SAFETY RULES

- ※ 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	SPECIFICATION
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 100ml/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.

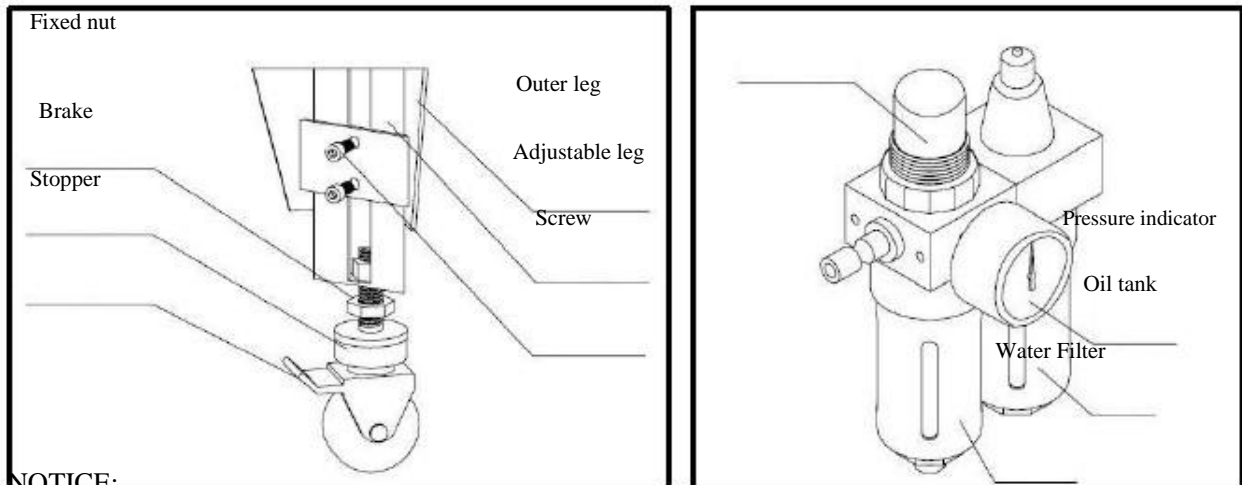
NOTICE:

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

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

ADJUSTMENT

Screw



NOTICE:

Before performing adjustment works, please disconnect the power supply.

Step1: Table height adjustment

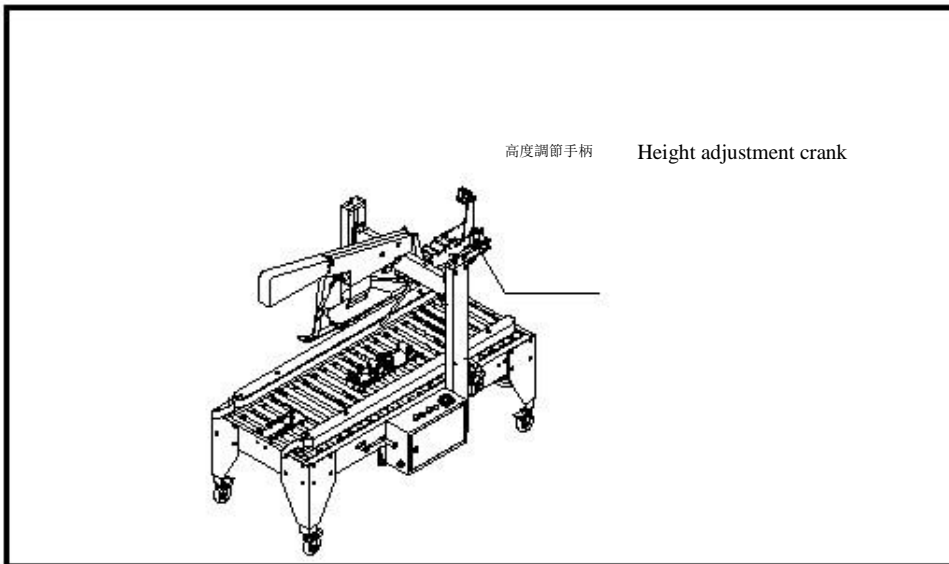
Ground the equipment on the properly storage place, adjust the table top to the desire height.

- (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.

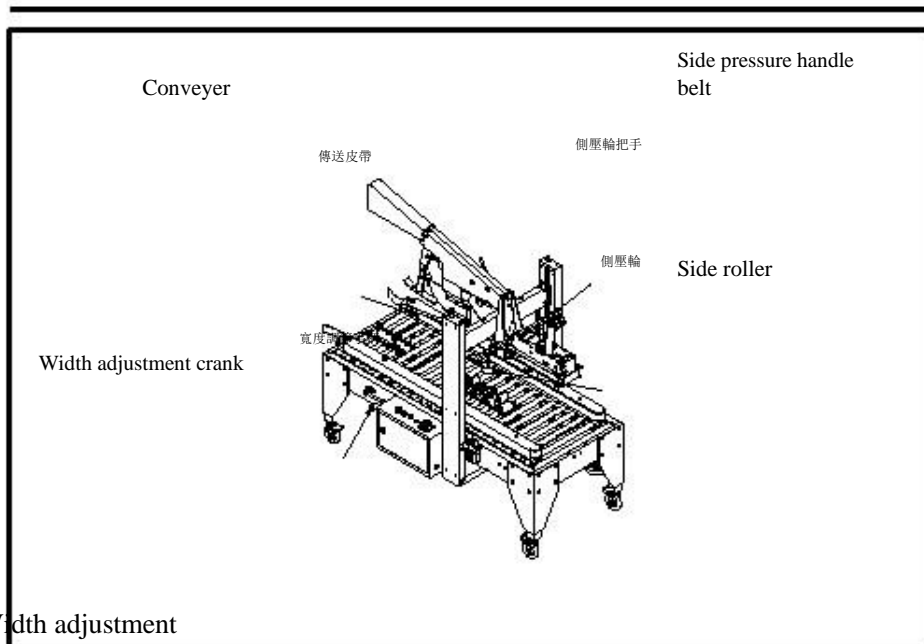
Step2: Pneumatic adjustment

- (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

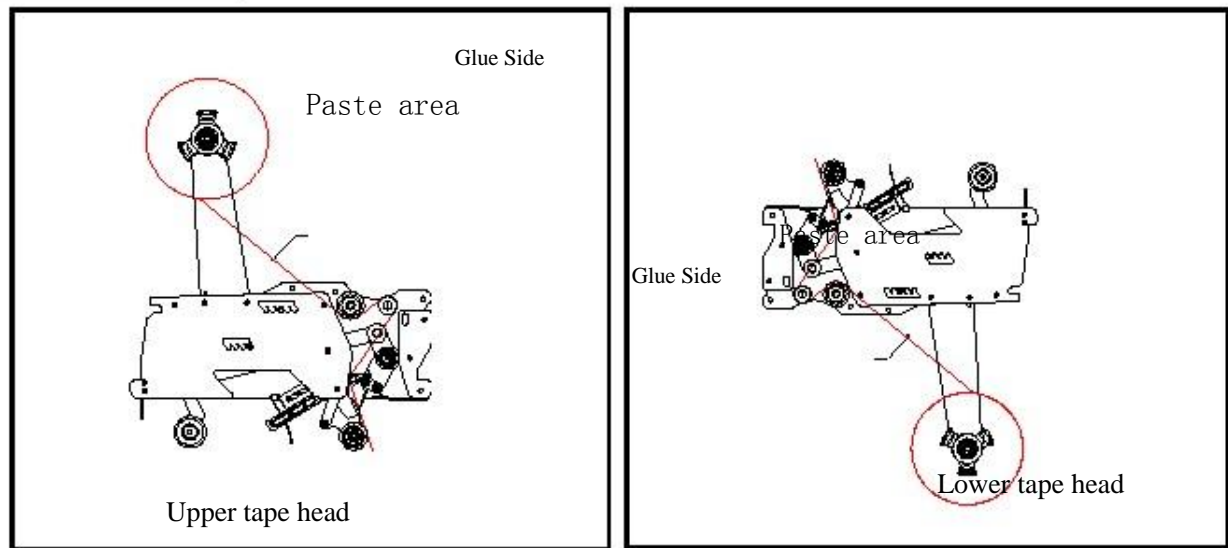
- (1) Put a carton on the table.
- (2) Rotate the height adjustment crank to adjust the table height.
- (3) The front guide plate just need to be adjusted to touch the carton top.



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.

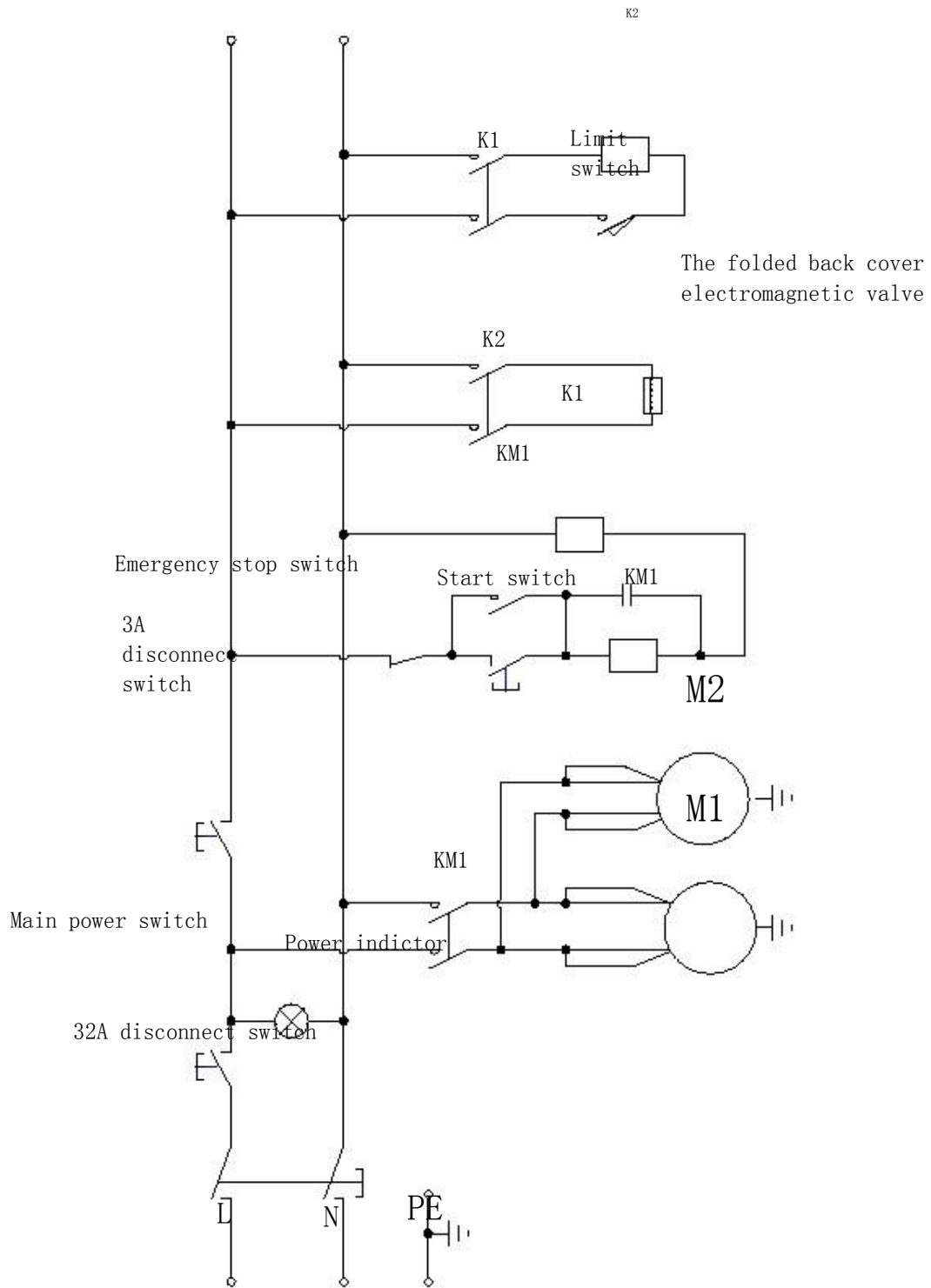
Thread illustration



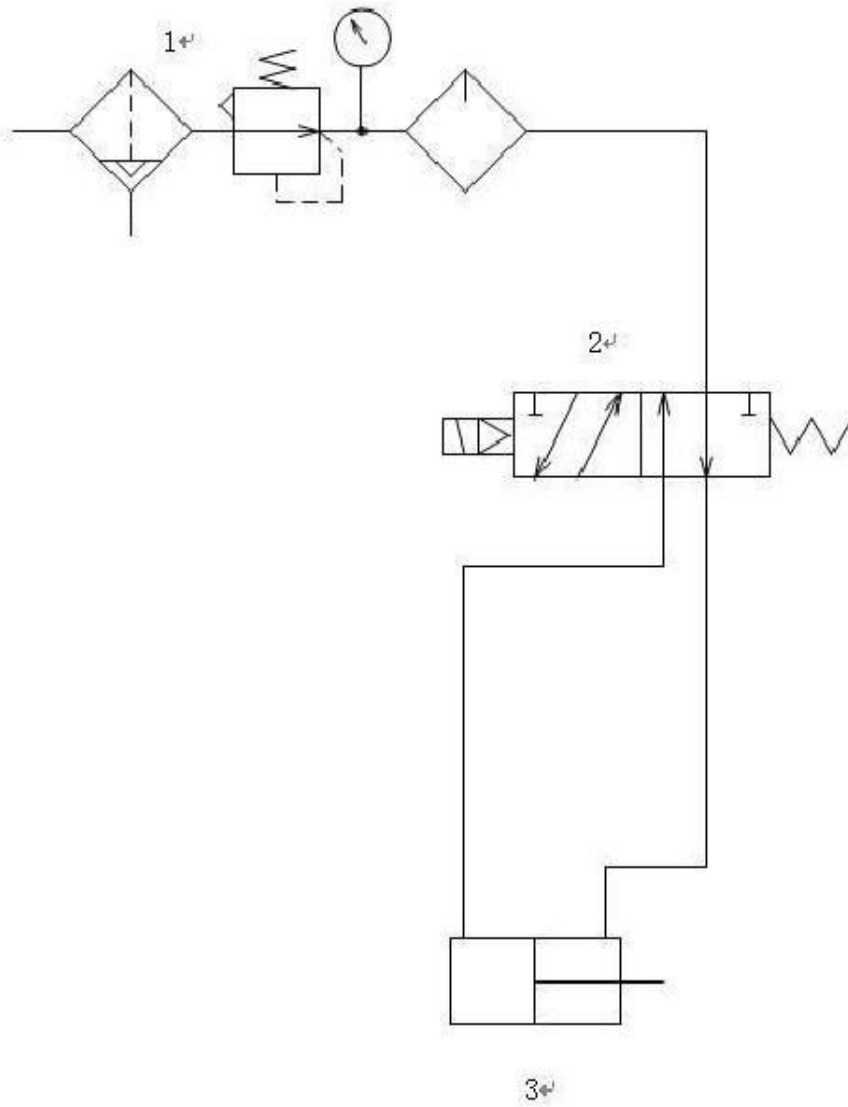
MAINTENANCE AND LUBRICATION

- ※ 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



PNEUMATIC CONTROL DIAGRAM



NO.	PARTS NO.	SPECIFICATION	QTY
1	AFR/L-02	FILTER	1
2	VS520-02-2S	SOLENOID VALVE	1
3	Q01-040150	CYLINDER 40*150	1

TROUBLE SHOOTING

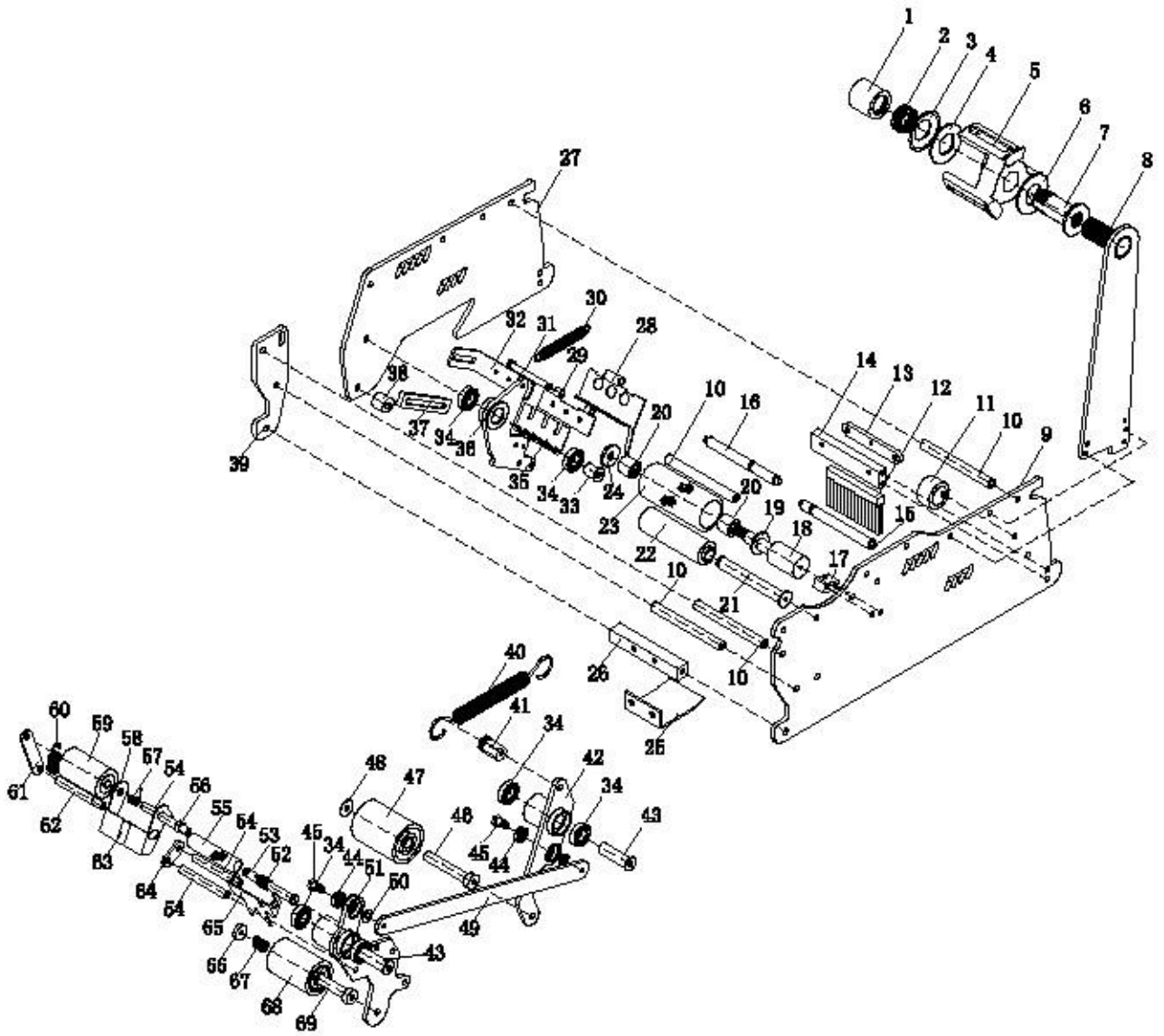
Fault	Cause	Elimination
	The carton width is too narrow. Please use the appropriate size of the carton.	
The carton can not be transported by the side driven belt	The belt was worn	Replace a new belt
	The pressure of the upper tape head is not enough height.	Adjust the upper tape head's
	Upper tape head's roller is positioned too low.	Adjust the roller position.
	The upper tape head's spring is too tight. The belt's tension is not strong enough.	Loosen the spring to reduce the tension. Adjust the belt's tension.
The driven belt will not move.	The power is not being connected. The motor will not work.	Please check the power line.
The belt was broken.	The belt was worn.	Inspect the motor.
	The belt tension is too tight.	Replace a new belt. Adjust the belt's tension.
The carton was jammed in Upper Outlet .low .head's height.	Upper head's position is too 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. The upper and lower guide roller can not spin very well.	Adjust the upper tape head's height. Clean up the roller and lubricate it.
The tape adhered to the blade's carton is too short.	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.	Please check the tape thread
	The tape head's roller can not spin very well. it.	Clean up the roller and lubricate it.
The tape is wrinkled and can not adhere to the carton very well. The upper tape	The tension of the tape base is too tight. Loosen the screw by turning the nut counterclockwise.	Loosen the screw by turning the
	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 tape's outer shape is changed	Please replace a new tape.

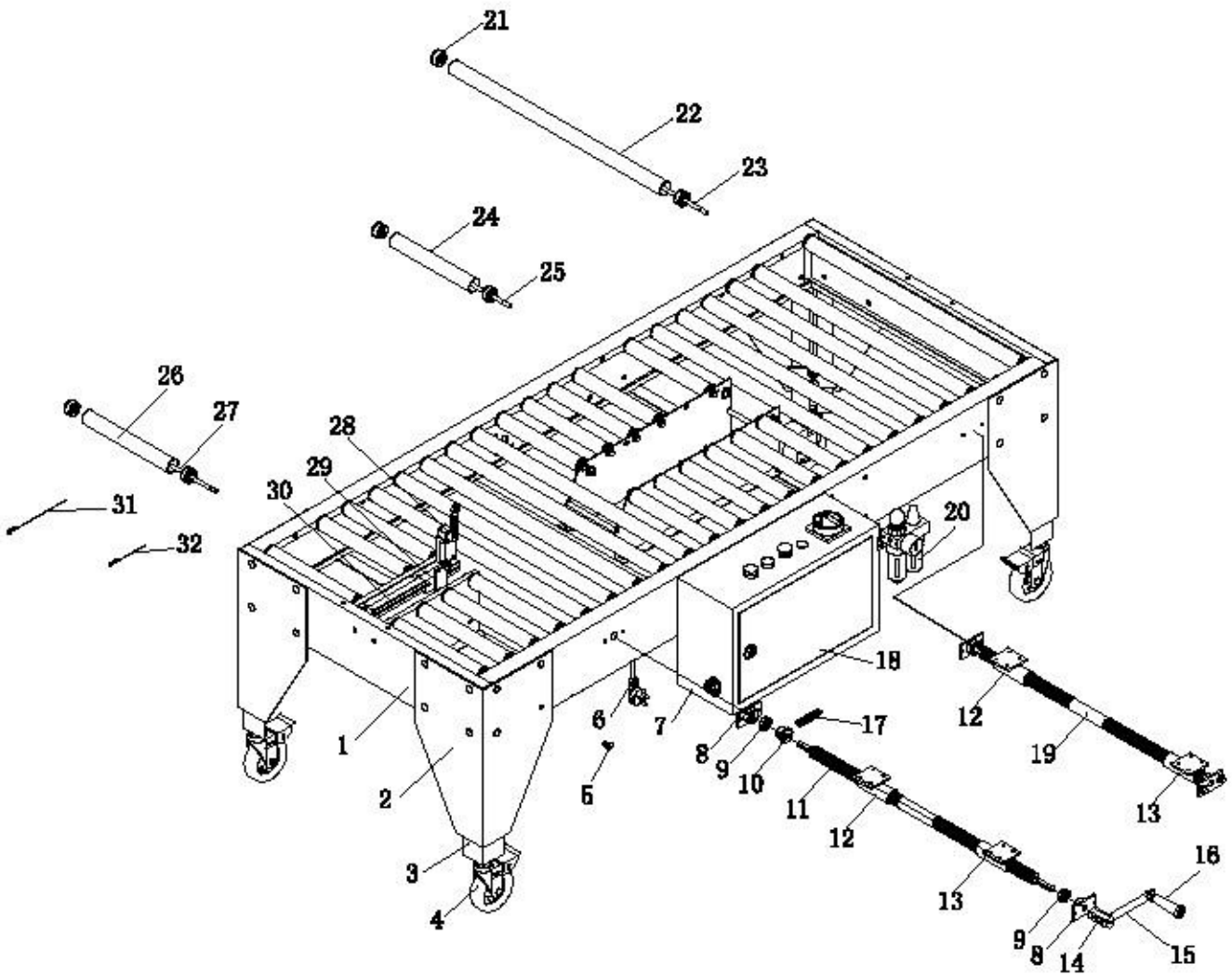
Part list

SDW-FC500

TAPPING HEAD ASSEMBLY



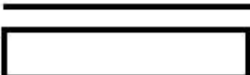
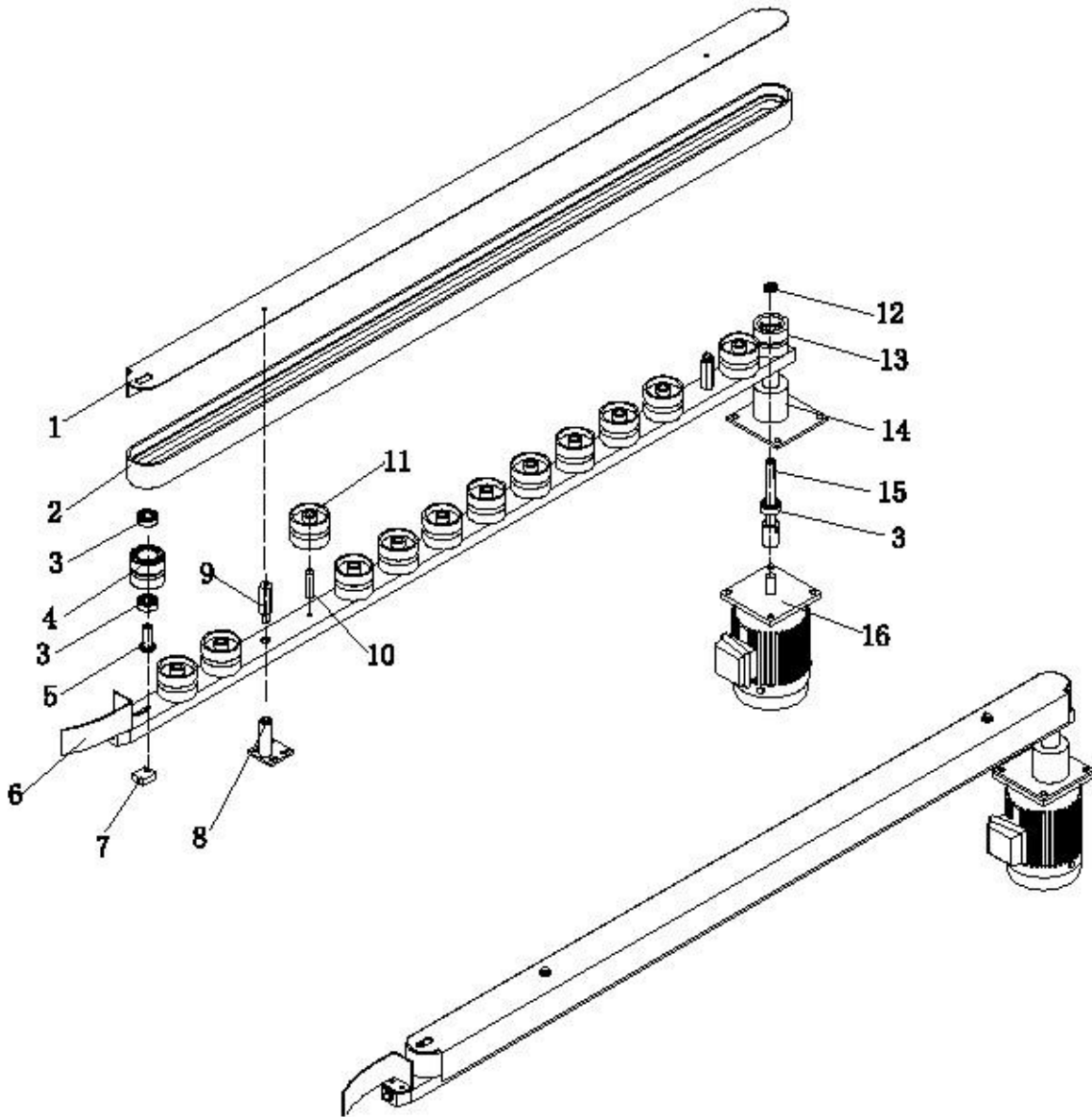
FRAME ASSEMBLY



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
9	G04-216001	6001 BEARING	4
10	06B101200	SCREW Φ 12	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	1
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
19	SDWF1-102010	DENTAL TUBE - BACK	1
20	AFR2000-1V	FILTER	1
21	SDW-CG-1	ROLLER PLUG	68
22	SDWF1-102021-35	FRONT & BACK ROLLER (500W)	12
23	SDWF1-102022-35	FRONT & BACK ROLLER AXLE (500W)	12
24	SDWF1-102021-15	ROLLER (500W)	12
25	SDWF1-102022-15	ROLLER AXLE (500W)	12
26	SDWF3-102011-1F	FRONT ROLLER (500W)	8
27	SDWF3-102010-F	FRONT ROLLER AXLE (500W)	8
28	SF-8108	TRAVEL SWITCH	1
29	SDWFJ-3A-76	TRAVEL SWITCH FRAME	1
30	SDWF3-4	TRAVEL SWITCH SLIDING FRAME	1
31	SDW-10750001	ROLLER BOLT(SHORT)	6
32	SDW-10750001	ROLLER BOLT(LONG)	3

SIDE DRIVEN ASSEMBLY

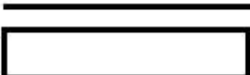
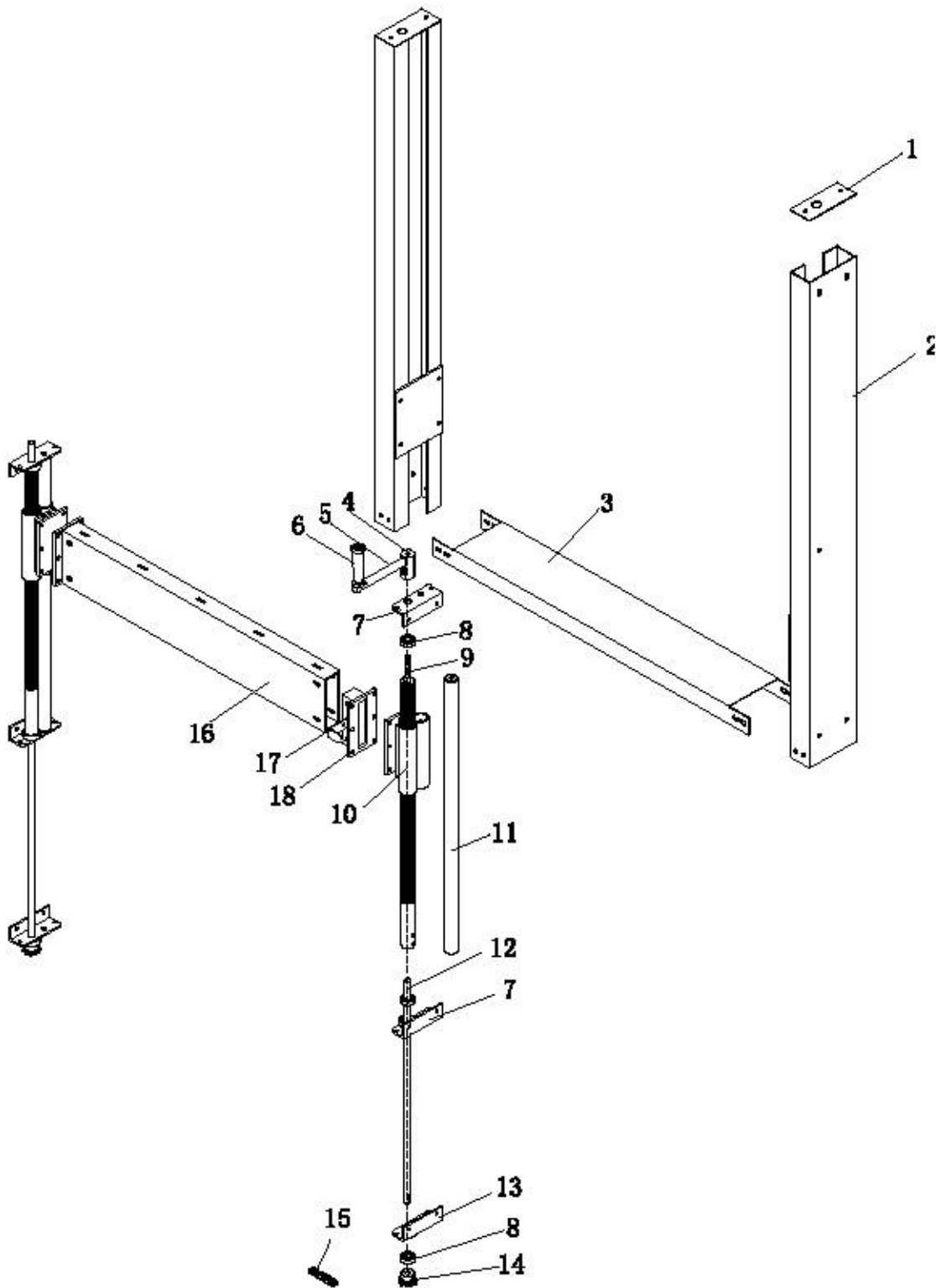


SIDE DRIVEN ASSEMBLY

NO.	PART NO.	PART NAME	QTY
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	SDWF1-101010	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	SDWF2-102004.1	ROLLER CLAMPING RING	2
13	SDWFJ-1A-103	MAIN ROLLER	2
	SDWFJ-1A-111	FRICTION CYCL	2
14	SDWF3-101250	BELT ASSEMBLY	2
15	SDWF1-102002	MAIN SHAFT	2
16	MD-2201618	MOTOR 1:15 Φ 16 1/8HP 220V	2



MAST ASSEMBLY



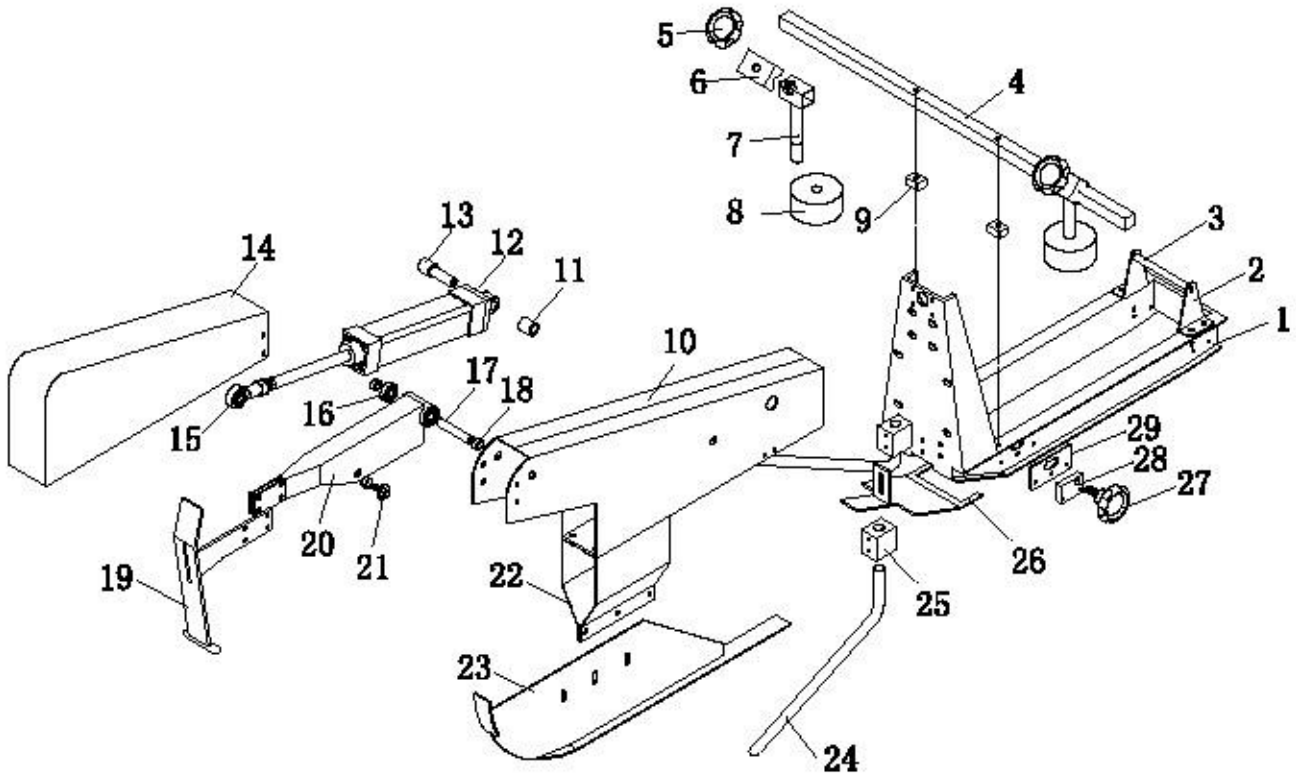
MAST ASSEMBLY

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	1
6	SDWFJ-1A-110	CRANK HANDLE	1
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 Φ 12	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

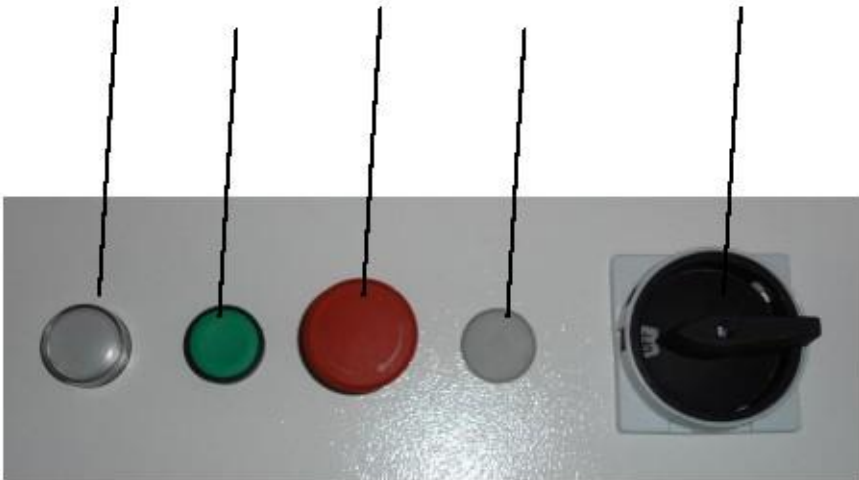


GRIP AND KNOCK BAR ASSEMBLY

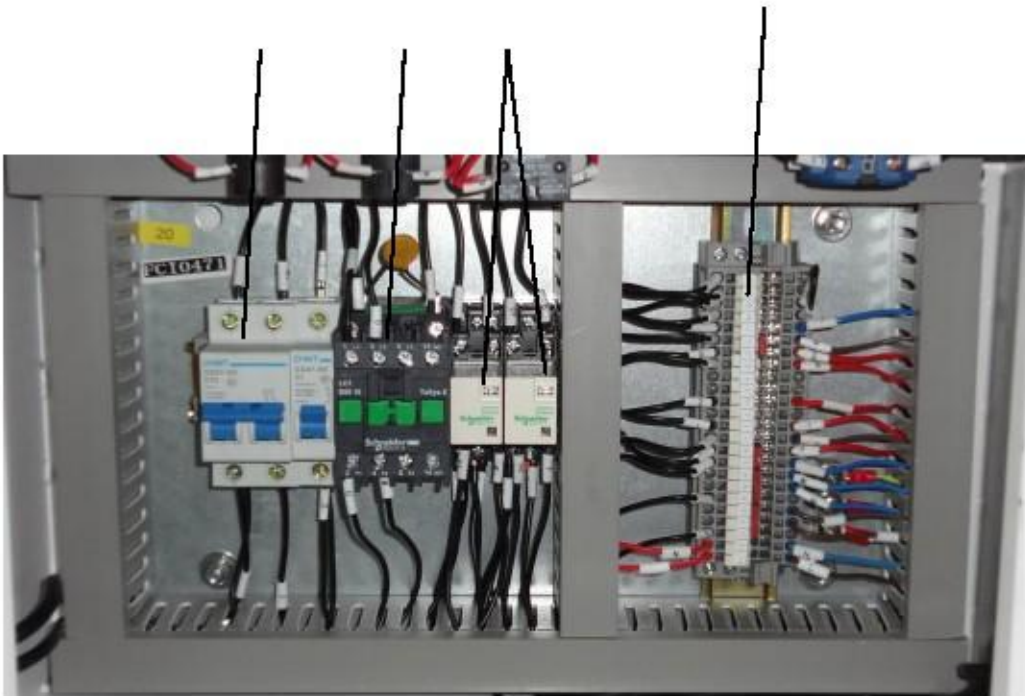
NO.	PART NO.	PART NAME	QTY
1	SSDWF3-101007	F3 UPPER BLADE	1
2	SDWF1-101450.1	SUPPORT AXLE PLATE	2
3	SDWFJ-1A-67	SUPPORT AXLE PLATE	1
4	SDWF3-2	SQUARE SHAFT	1
5	SDWFJ-1A-109	HANDWEEL	3
6	SDWFJ-MA-56	FIXED PLATE	2
7	SDWFJ-MA-50.1	CASTER ASSEMBLT	2
8	SDW-CA100600	SIDE ROLLER	2
9	SDWF3-3	SQUARE SHAFT BLOCK	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	1
27	SDWFJ-1A-109	HANDWEEL	3
28	SDWF1-101450.3	HANDWEEL BLOCK	1
29	SDWF1-101450.2	FRONT GUIDE PLATE	2



1 2 3 4 5



6 7 8 9



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		STOPPER	1
5	K01-010004	MAIN POWER LIGHT	1
6	K01-010032	32A CUT-OUT SWITCH	1
	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

