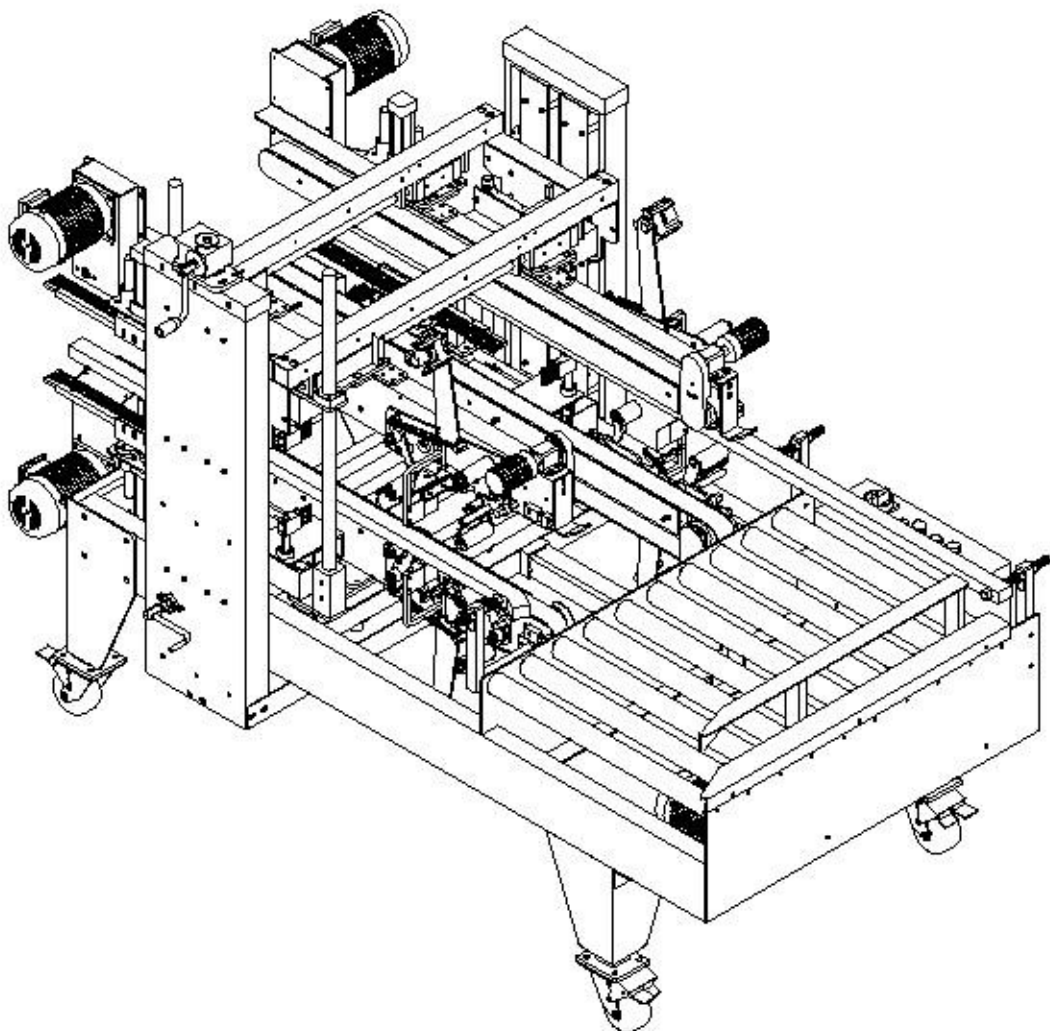


---

# L SHAPED SEMI-AUTOMATIC CARTON CORNER SEALER

ZF-FG500L





Only professional are allowed to operate the machine.

Daily safety instructions:

Before:

- Make preparation to read the manual.
- Check all the cover plates of machine, if any damaged please change new parts.
- Keep the machine clean.
- Read the manual seriously.
- Read carefully the important signs.

In this time:

- Don' t dress the loose clothes, in case not to get into the machine.
- Please dress with shoes during maintenance.
- Don' t pack the machine with carton box.

After:

- Please turn off the machine.



Only professional are allowed to operate the machine.

Service and safety rules:

- Please keep this service manual.
- Please do not setting or lubricate when machine is working.
- Power off before open the protective cover.
- Do not install any unauthorized additional parts.
- Please use the parts of original.

## TABLE OF THE CONTENT

1.	Machine character & safety info .....	
	1-1 Parameter .....	
	1-2 Machine logo .....	
	1-3 Overview & application.....	
	1-4 Standing position .....	
	1-5 Notice when using the machine .....	
	1-6 Radiation safety .....	
	Specification, installation and adjustment .....	
	2-1 Spec .....	
	2-2 Storage condition.....	
	2-3 Adjustment .....	
	Operating principle.....	
	Operation.....	
	4-1 Control panel.....	
	4-2 Install the tape.....	
	4-3 Operating steps.....	
	4-4 Daily maintenance.....	
	Repair.....	
	5-1 Security warning.....	
	5-2 Maintain and clean regularly .....	
	5-3 Common fault and solution .....	
	5-4 Parts list changed by professional.....	
	Main parts .....	
	6-1 Frame .....	
	6-2 Column components.....	
	6-3 Brush device .....	
	6-4 Brushing device .....	
	6-5 Top and bottom driven .....	
	6-6 Lifting gear .....	
	6-7 Motivate transmission and stretching device.....	
	6-8 Taping head .....	
	<b>Electric wiring diagram &amp; schematic diagram</b> .....	
	7-1 <b>Photoelectric control</b> .....	
	7-2 Travel control 1 .....	
	7-3 Travel control 2 .....	

## 1. Machine character &amp; safety info

## 1-2 Performance and parameter

Item	Parameter
Power	110V/50Hz, 1000W (5 motors)
Carton size	L(340-700)mm *W(200-500)mm*H(180-500)mm
Sealing tape	Kraft paper tape/BOPP tape
Tape width	48-72mm
Sealing speed	8 cartons/min
Configuration	“GPG” motor from Taiwan
Worktable height	620mm
Machine size	L2150×W1230×H1500mm
Machine weight	300kg



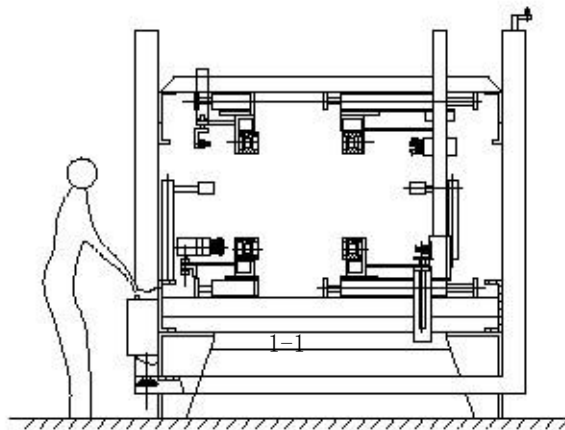
1-3 Machine logo

1-4 Overview and application

The machine is based on the sealing materials of PVC and BOPP these pressure-sensitive tape.

1-5 Working standing position

When the machine is working, the operator should stand in front of the machine with 100mm distance.



1-6 Safety notice when using the machine

- ①. Ensure the power supply of the machine.
- ②. Please do **not touch the blade by hand**.
- ③. Do not flush the machine.
- ④. Do not change, add or subtract the machine parts.
- ⑤. Do not put the hands into the driven device.

1-7 Machine radiation safety

1.7.1 Noise:  $\leq 75\text{DB}$



2. Machine spec, installation and adjustment

2-1 Specification

2.1.1 Machine model:

2.1.2 N.W. : 300kg

2.1.3 G.W. : 330kg

2.1.4 Volume: 5.5 m<sup>3</sup>

2.1.5 Date of manufacture: See the certification

2-2 Handling and storage conditions

2.2.1 The machine structure and the main components (See Fig 2-1)

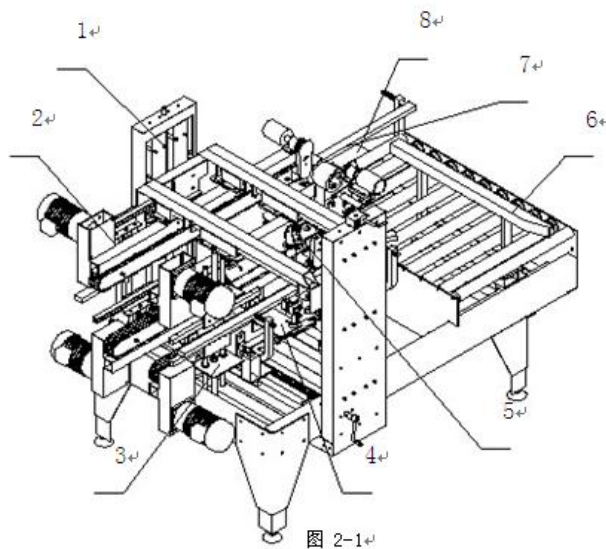
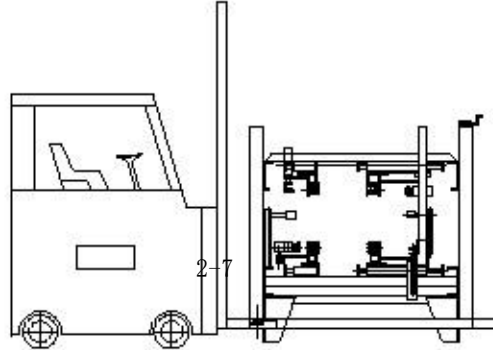


图 2-1

- |                        |                     |
|------------------------|---------------------|
| 1. Standing members    | 5. Pusher mechanism |
| 2. Drive up and down   | 6. Guiding bar      |
| 3. Brush holder device | 7. Electrical box   |
| 4. Movement            |                     |

### 2.2.2 Transport

Use a forklift to move (See figure 2-7)



### 2.2.3 Working conditions

Working environment should stay away from fireworks, dry and ventilated and non-corrosive substances erosion, humidity  $\leq 98\%$ , normal ambient temperature in the range of 0-40 °C, electromagnetic radiation no special requirements.

## 2-3 Debugging

### 2.3.1 Check before operation

- ①. Check for loose fasteners
- ②. Check the motor and electrical equipment is dry, insulation is good.
- ③. Check whether the external power supply requirements of the machine

### 2.3.2 Checking

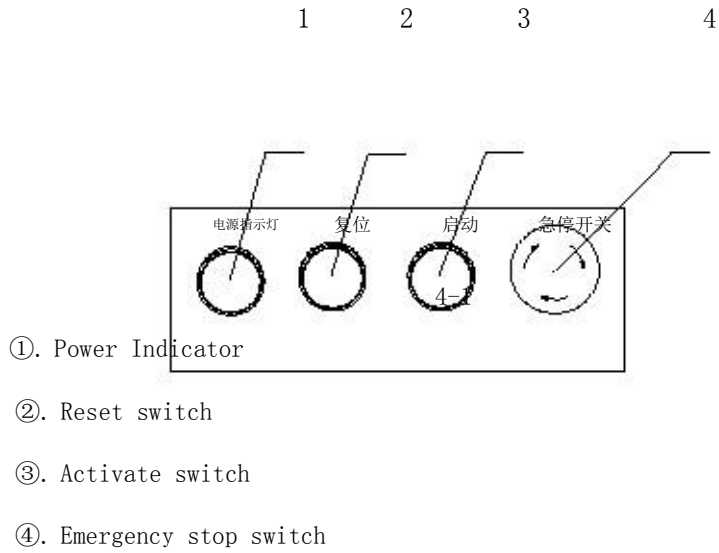
- ①. After the pass on the power and gas operation after 2-5 minutes to check whether the operating normally, pressure is stable
- ②. Check whether the cylinder to move back and forth level
- ③. Check whether the belt running side
- ④. Adjust the belt tightness
- ⑤. Check the tape within the movement is smooth flow

### 3. Working principle

Connect the power plug, power indicator light, according to the direction of the arrow rotate emergency stop button, then press the start button if the automatic roller conveyor to the upper and lower body at the gearing, automatic sealing of cartons.

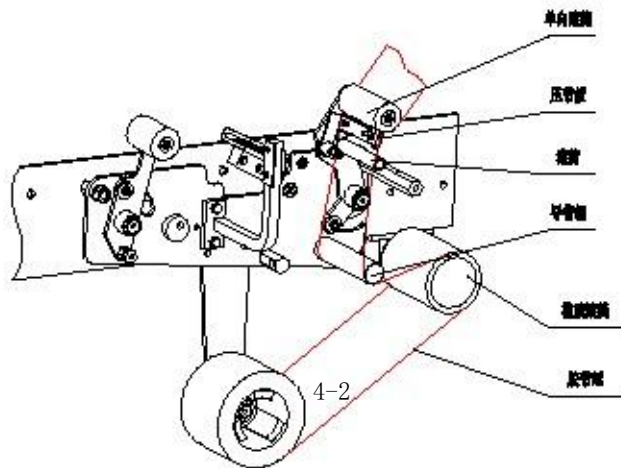
### 4. Machine operation

4-1 Control panel features (See figure 4-1)



4-2 Wear paper tape method

See figure 4-2 shown



#### 4-3 Steps

- a. Connect the power plug, a power indicator light, the rotation direction of the arrow 4 emergency stop button on the control panel.
- b. Press the start button 3, put artificial objects, roller automatic transmission objects arriving at the upper and lower gear driven automatic corners sealing objects.

#### 4-4 Routine Maintenance

Often sealing machine proper care and maintenance, not only can extend the life of sealing machine, sealing machine also makes less failure, thereby improving productivity.

##### 4.4.1 Quantitative refueling reducer

The amount of fuel oil at the surface is at the center of the oil standard is appropriate too much affected the sealing machine is working properly.

### 5. Maintenance and Troubleshooting

#### 5-1 Security warning when Repair

- ①. Ensure that cut off the mains
- ②. Do Barefoot maintenance personnel for maintenance

#### 5-2 Regular maintenance and cleaning

- ①. To check whether the parts screws loose on a regular basis
- ②. To an important component of the machine regularly lubricated with oil
- ③. Clean the surface of the machine
- ④. Remove foreign blade on a daily basis
- ⑤. Machine when not long, the blade should be oiled protection

#### 5-3 Common Faults and exclusion method

. Cut paper tape continuously: The blade is too high, easy to scratch the box

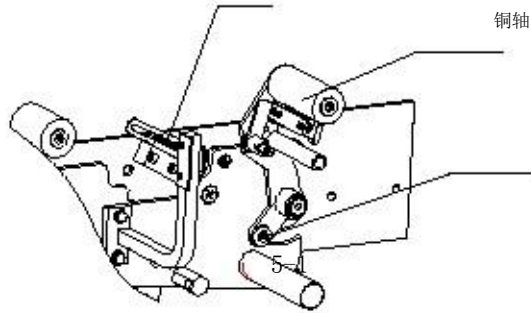
Blade too low, easily lead to tape continuously cut (See Fig. 5-1)

- ②. Tape pressure is not past (box not pressure prison): 1) Poor quality tape or a bad one-way roller

2) Copper shaft wear (See Fig. 5-1)

刀片

单向滚筒

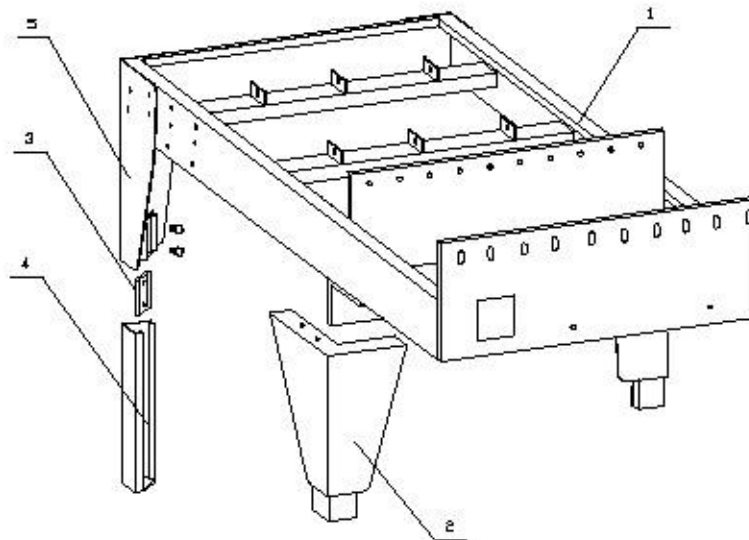


5-4 By the project's professional repair or replacement of components

No.	Replacement parts name	备注
1	Gear	FB-06-03
2	Rack	FB-06-08
3	Major axis	FB-06-02
4	Spinal	FB-03-10
5	Sprocket drums	FB-03-19

6. The main components and parts list FIG.

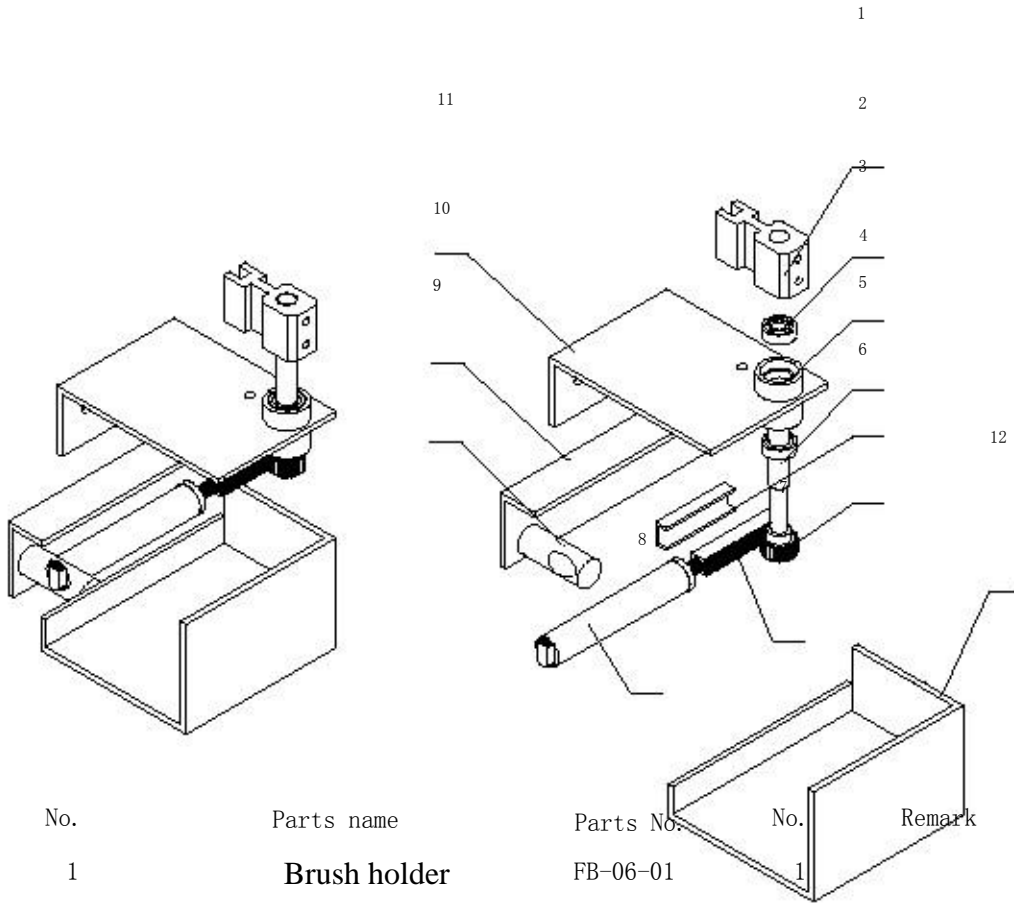
6-1 Frame



NO.	Name	Parts No.	Qty	Remark
1	Frame	FB-01-01	1	
2	Forefoot	FB-01-25/26	2	
3	Platen	FB-01-29	4	
4	Telescopic legs	FB-01-27	4	
5	Rear	FB-01-24	2	



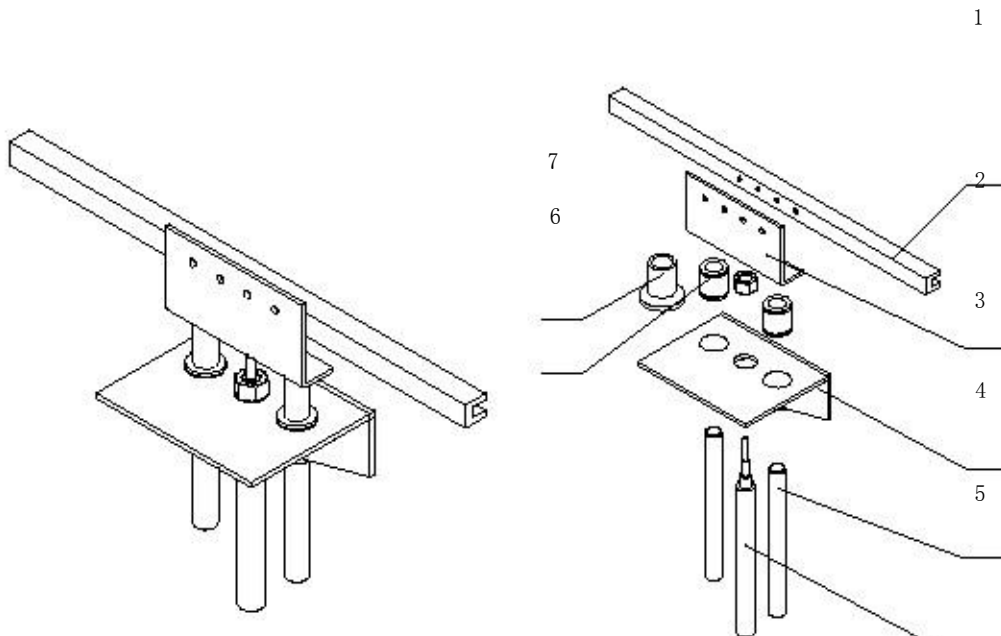
6-3 Angle brush device



No.	Parts name	Parts No.	No.	Remark
1	<b>Brush holder</b>	FB-06-01	1	
2	Bearing	6001Z	2	
3	Bearing base	FB-06-06	2	
4	<b>Major axis</b>	FB-06-02	1	
5	<b>Rack carriage</b>	FB-05	1	
6	Gear	FB-06-03	1	
7	Rack	FB-06-08	1	
8	Cylinder	MAL25X40	1	
9	<b>Cylinder fulcrum</b>	FB-05	1	
10	<b>Brush holder</b>	FB-06	1	
11	<b>Support plate</b>	FB-06-04	1	
12	Protecting cover	FB-06-10	4	

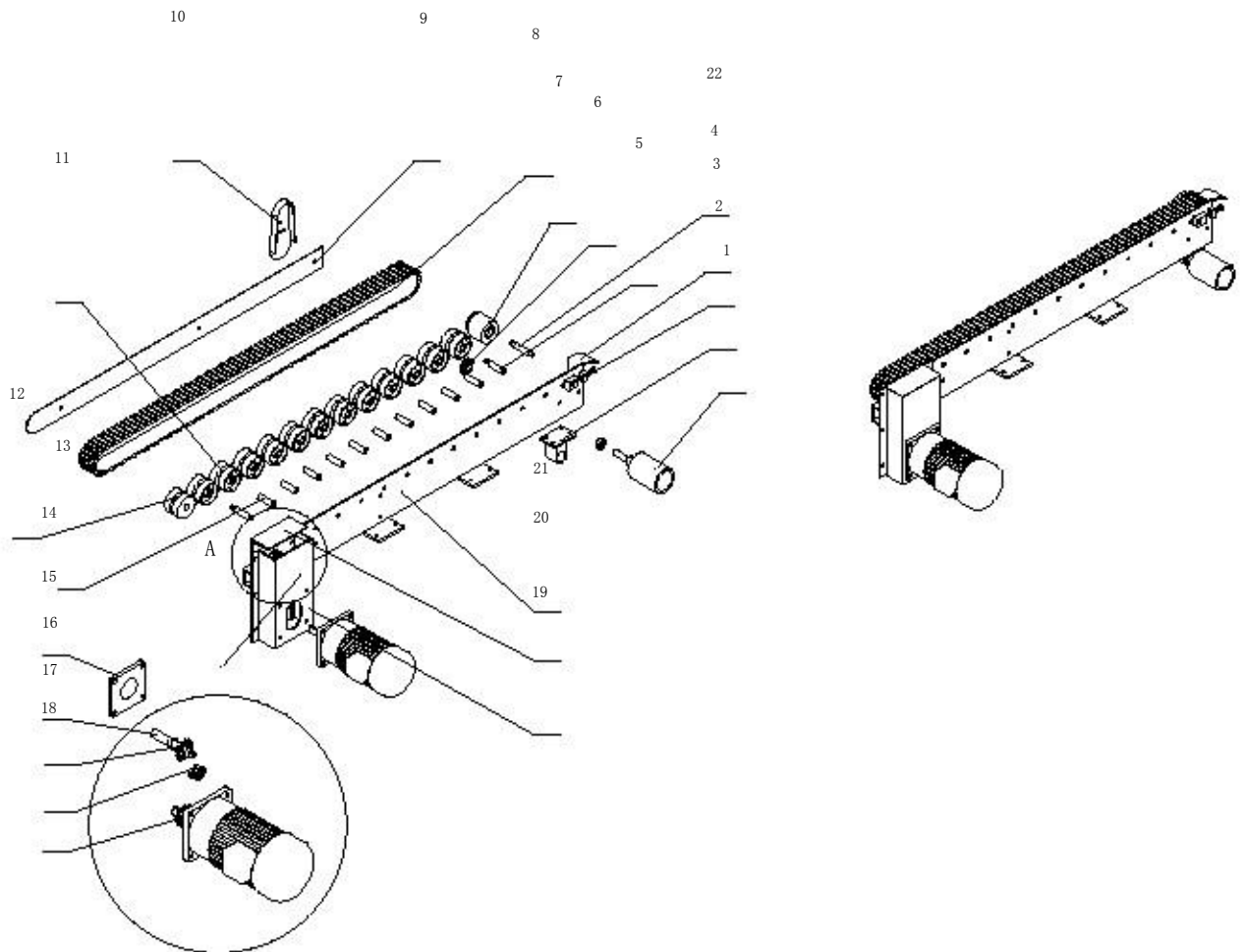


6-4 Bristles device



No.	Parts name	Parts No.	Qty	Remark
1	<b>Brush the clip</b>	FB-05-01	1	
2	<b>Support</b>	FB-05-02	1	
3	Bracket	FB-05-04	1	
4	<b>Guide rod</b>	FB-05-03	2	
5	Cylinder	SC32*25	1	
6	<b>Linear Bearings</b>	LM20UU	2	
7	<b>Linear Bearing base</b>	FB-05-05	2	

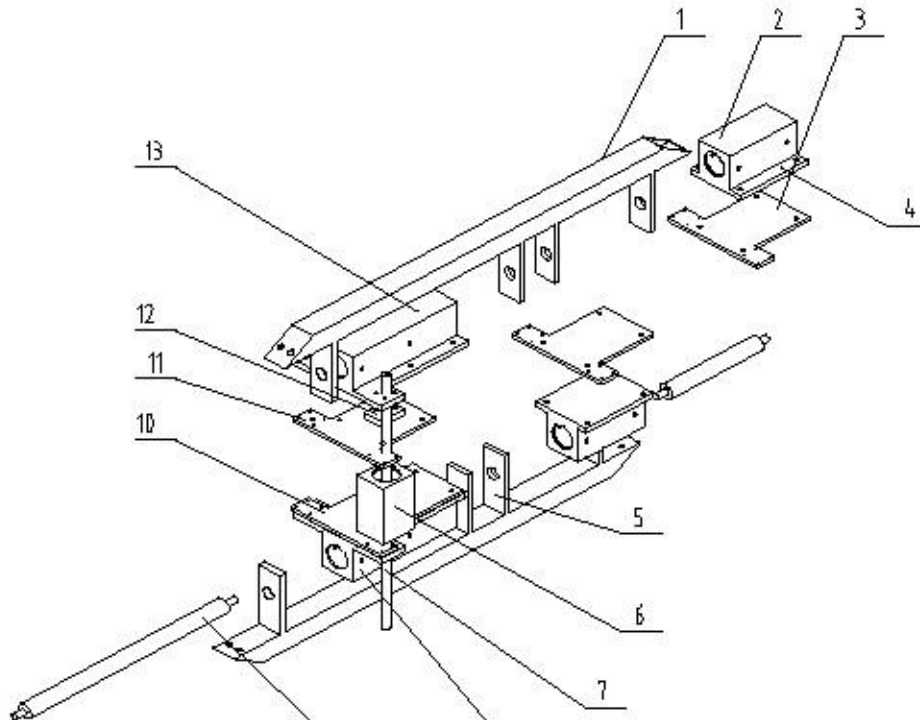
6-5 Top and bottom driven



No.	Parts name	Parts No.	Qty	Remark
1	<b>Tape roller</b>	FB-03	1	
2	Bearing base	FB-03-10	1	
3	<b>Slider</b>	FB-03-22	1	
4	<b>Guide plate</b>	FB-03-25	2	
5	Pin II	FB-03-16	1	

6	Chain wheel	FB-03-20	1	
7	<b>Pull belt sprocket</b>	FB-03-12	1	
8	Belt	2747*50*5	1	
9	Apron	FB-03-07	1	
10	Chain cover	FB-03-23	1	
11	Nylon roller	FB-03-14	1	
12	Capstan	FB-03-09	1	
13	Pin I	FB-08-15	10	
14	Bearing base	FB-03-03	1	
15	Spindle	FB-03-10	1	
16	Driven sprocket	FB-03-12	1	
17	Bearing base	FB-03-13	1	
18	Main sprocket	FB-03-11	1	
19	Motor mount	FB-03-08	4	
20	Cover	FB-04	1	
21	Steel beam (right)	FB-03-01-00	1	
22	Round pins	FB-03-21	4	

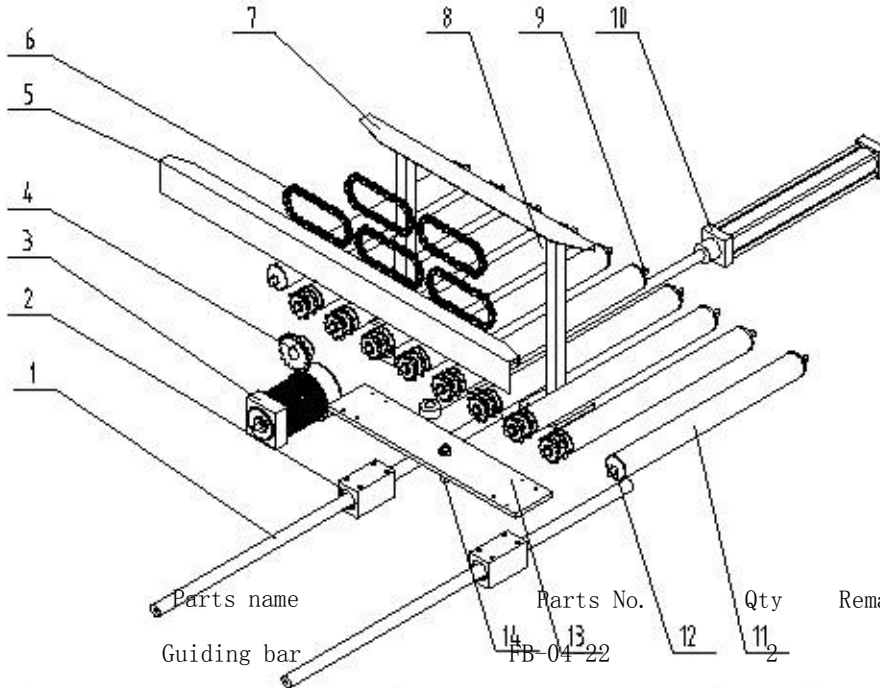
6-6 Lifting mechanism



No.	Parts name	Parts No.	Qty	Remark
1	Roof Beam	FB-01-03	1	
2	Sleeve	FB-01-07	4	
3	Connecting plate	FB-03-06	4	
4	Connecting plate	FB-01-12	4	
5	Block	FB-01-05	2	
6	Column Block	FB-01-17	2	
7	Column	FB-01-13	2	
8	Linear Bearings	LM25UU	2	
9	Support rail	FB-01-08	2	
10	Pallet	FB-01-18	1	
11	Support plate	FB-01-14	2	
12	Nylon cover	FB-01-15	1	

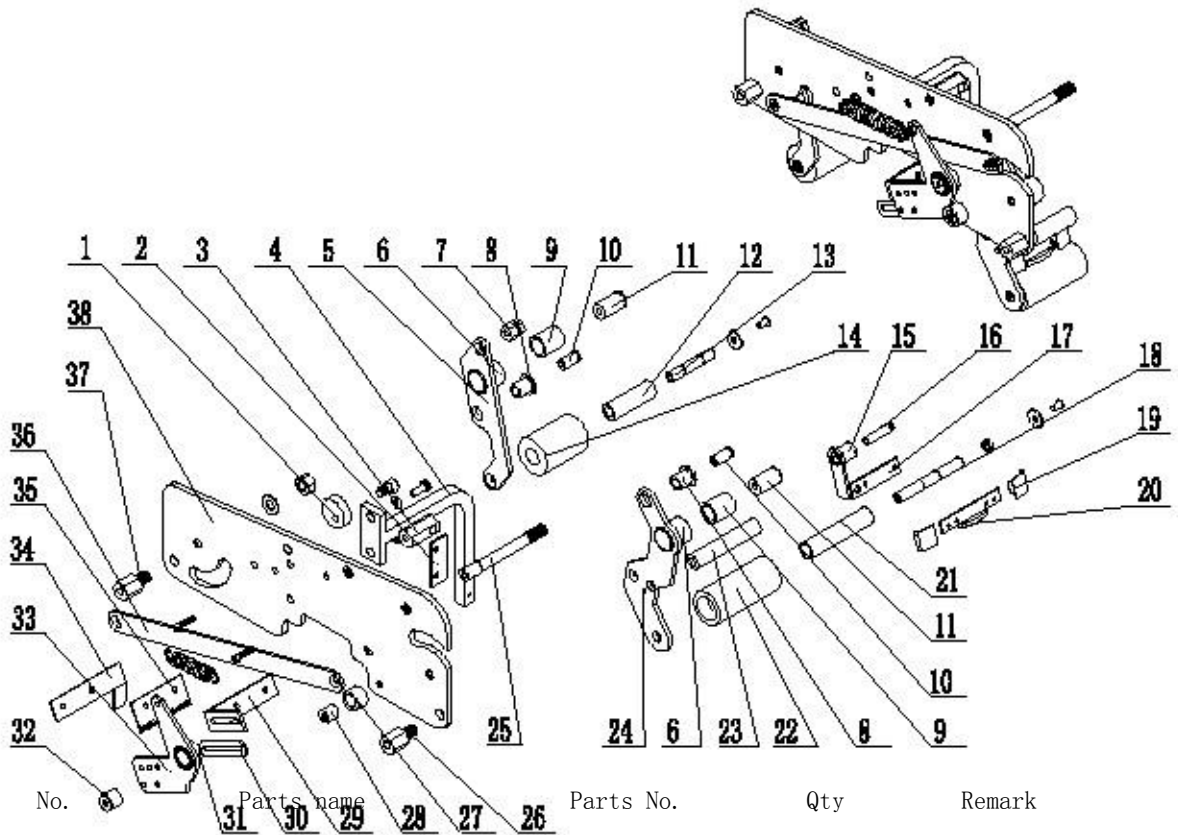
6-7 Power transmission and stretching device

--	--	--	--	--



No.	Parts name	Parts No.	Qty	Remark
1	Guiding bar	FB-04-22	2	
2	Sleeve	FB-04-21	2	
3	Motor	CV200-20ZG3	1	
4	Motor sprocket	FB-04-04	1	
5	Chain Cover	FB-04-16	1	
6	Chain	08B	5	
7	Putter	FB-04-17	1	
8	Motorized conveyor	FB-04-10	8	
9	Power shaft	FB-04-11	8	
10	Cylinder	SC50*450-S	1	
11	Powerless conveyor	FB-04-07	2	
12	Powerless shaft	FB-04-08	2	
13	Backing	FB-04	1	

6 8 Taping head				
-----------------	--	--	--	--

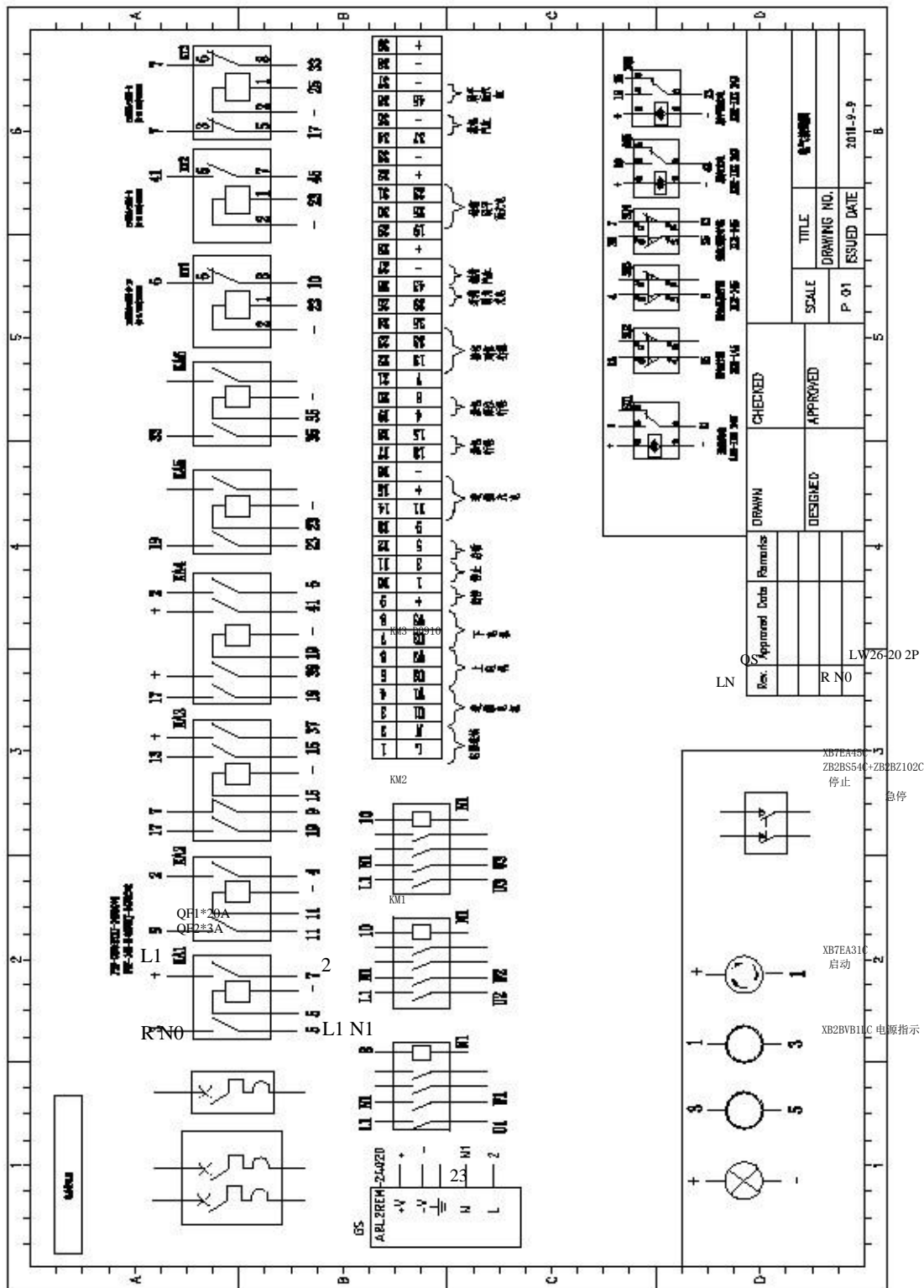


No.	Parts name	Parts No.	Qty	Remark
1	Eccentric iron	FB-08-23	1	
2	Platen	FB-08-35	1	
3	Tension spring base	FB-08-22	1	
4	Curved rod	FB-08-33	1	
5	Front conveyor rack	FB-08-20	1	Welding
6	Outer cover	FB-08-09	2	
7	Tension spring column	FB-08-21	1	
8	Copper sets	FB-08-06	2	
9	Bearing	6901Z	2	

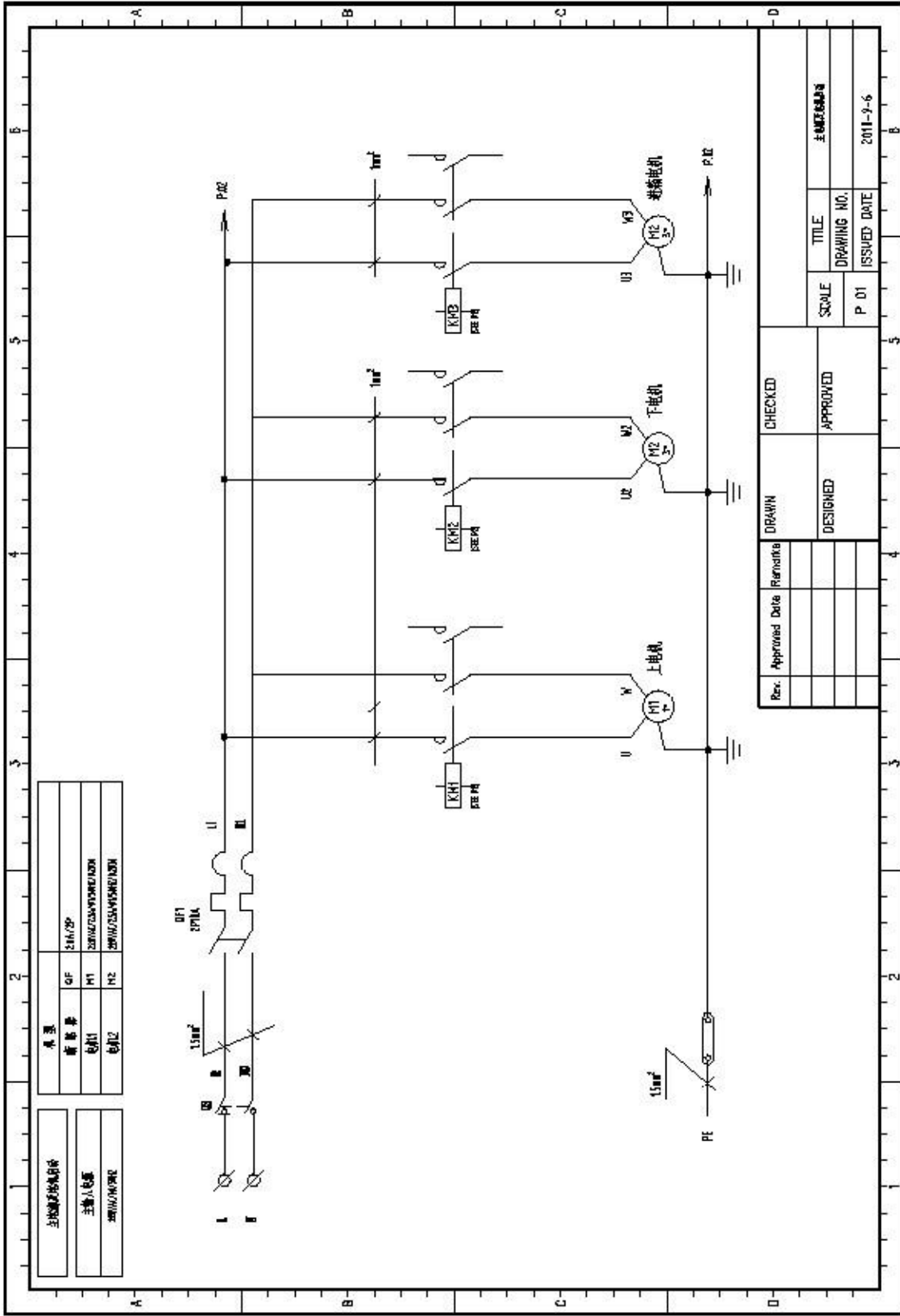
10	Trabeculae	FB-08-05	2	
11	Fixed column	FB-08-07	2	
12	Rear roller sleeve	FB-08-40	1	
13	Mandrel	FB-08-39	1	
14	Rubber roller	FB-08-41	1	
15	Spring base	FB-08-14	1	
16	Rocker shaft	FB-08-16	1	
17	Shake plate seat	FB-08-13	1	
18	Mandrel	FB-08-39	1	
19	Swash plate	FB-08-18	1	
20	Pinch plate	FB-08-17	1	
21	Check rubber rollers	FB-08-38	1	
22	One-way roller	FB-08-24	1	
23	Conveyor	FB-08-10	1	
24	Rear conveyor rack	FB-08-19	1	
25	Mandrel	FB-08-25	1	
26	Joint bolt	FB-08-02	1	
27	Collar	FB-08-36	1	
28	Limit ring	FB-08-37	1	
29	Tool holder	FB-08-31	1	
30	Block board	FB-08-30	1	
31	Bushings	FB-08-28	1	
32	Slit film base	FB-08-26	1	
33	Cut tool holder	FB-08-27	1	
34	Knife clip	FB-08-32	1	
35	Blade		1	
36	Pull rod	FB-08-01	1	
37	Joint bolt	FB-08-02	1	
38	Lateral plate	FB-08-00	1	

7. Electric wiring diagram & schematic diagram

7-1 Photoelectric control





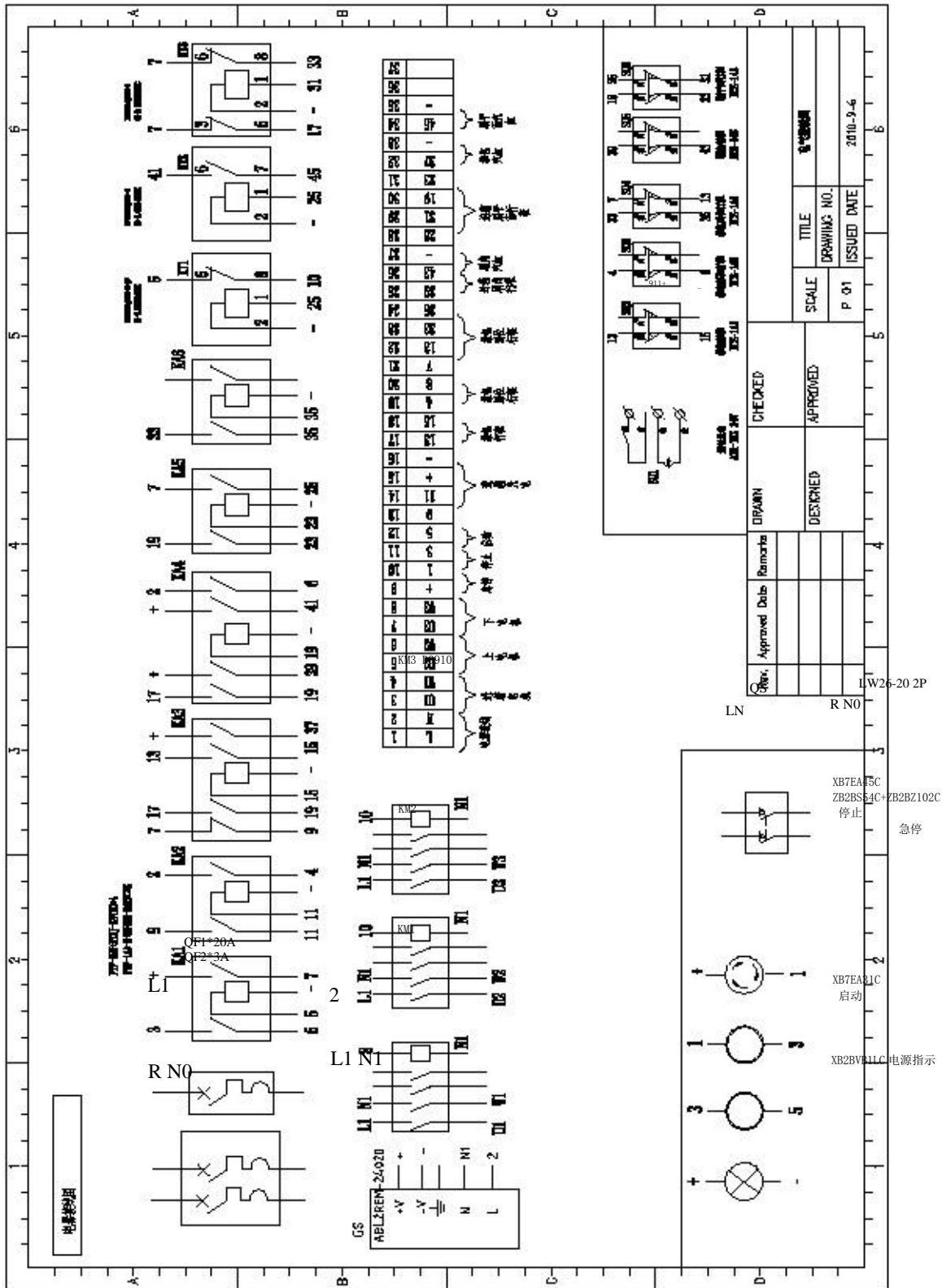


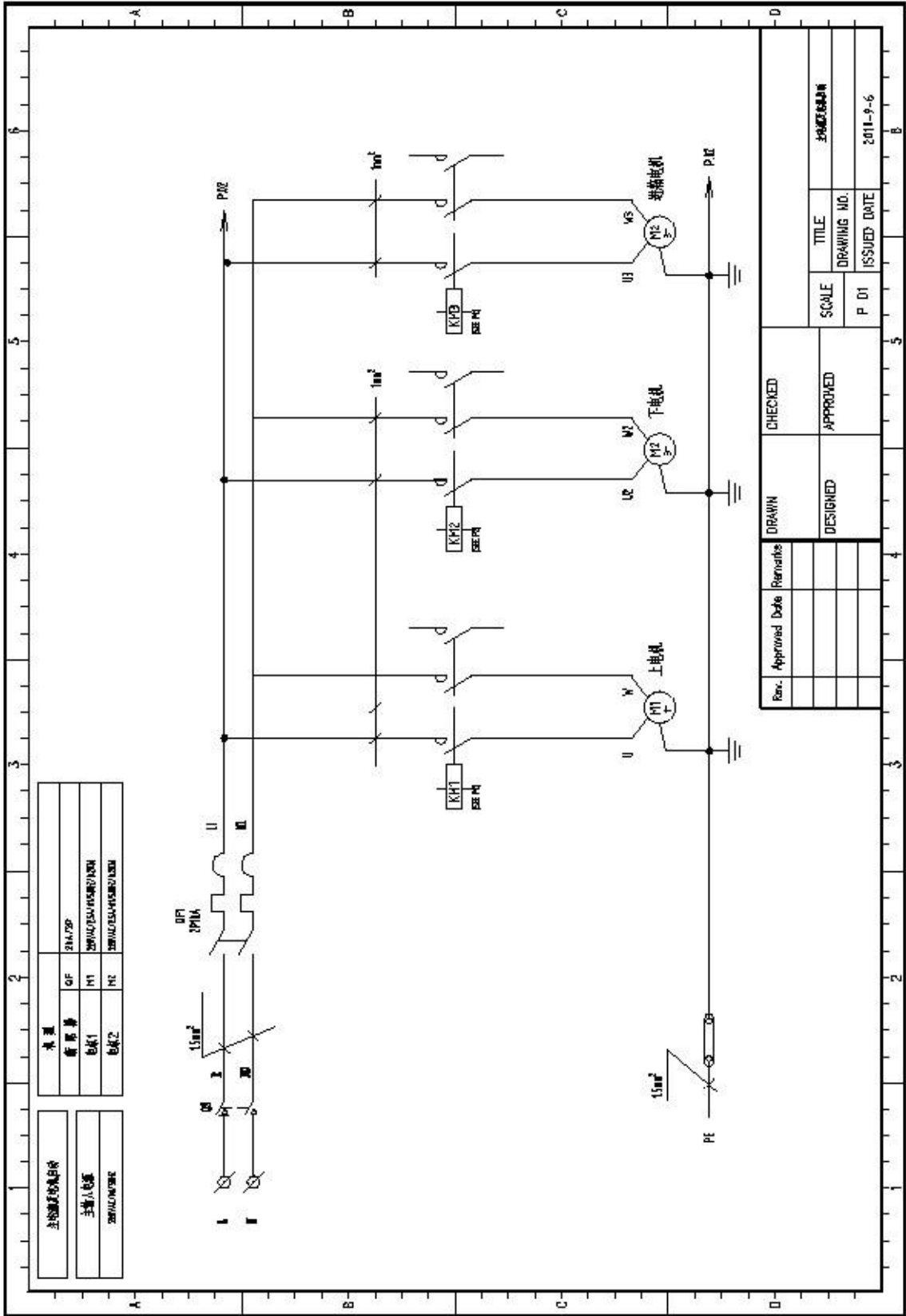
主电动机控制设备	
机型	QF
规格	250V/250V/250V/250V/250V
主电动机	M1
电动机	M2
电动机	M3

Rev.	Approved Date	Remarks	DRAWN	CHECKED
			DESIGNED	APPROVED
TITLE			SCALE	
DRAWING NO.			P. 01	
ISSUED DATE			2011-9-6	



7-2 Travel control 1



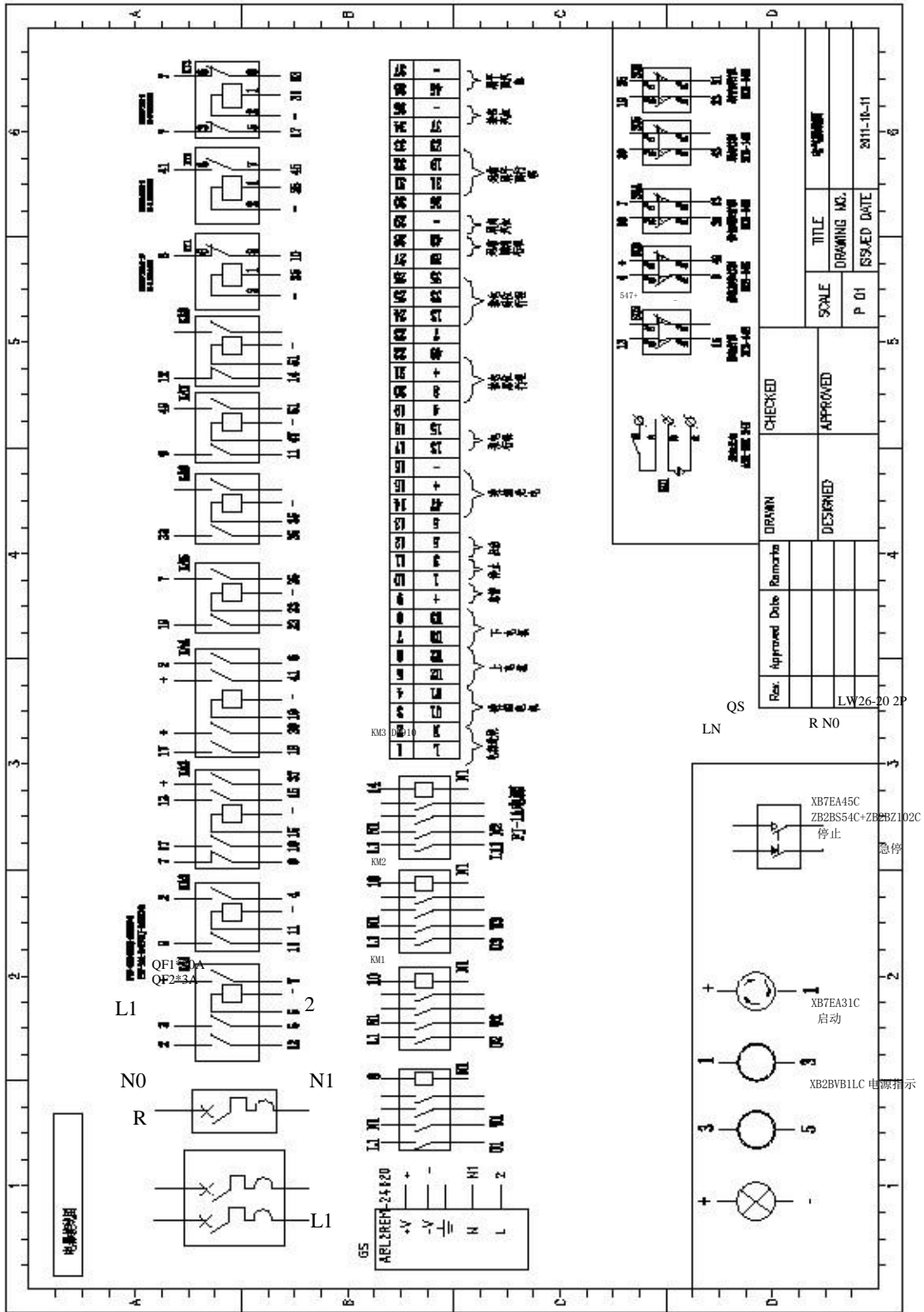


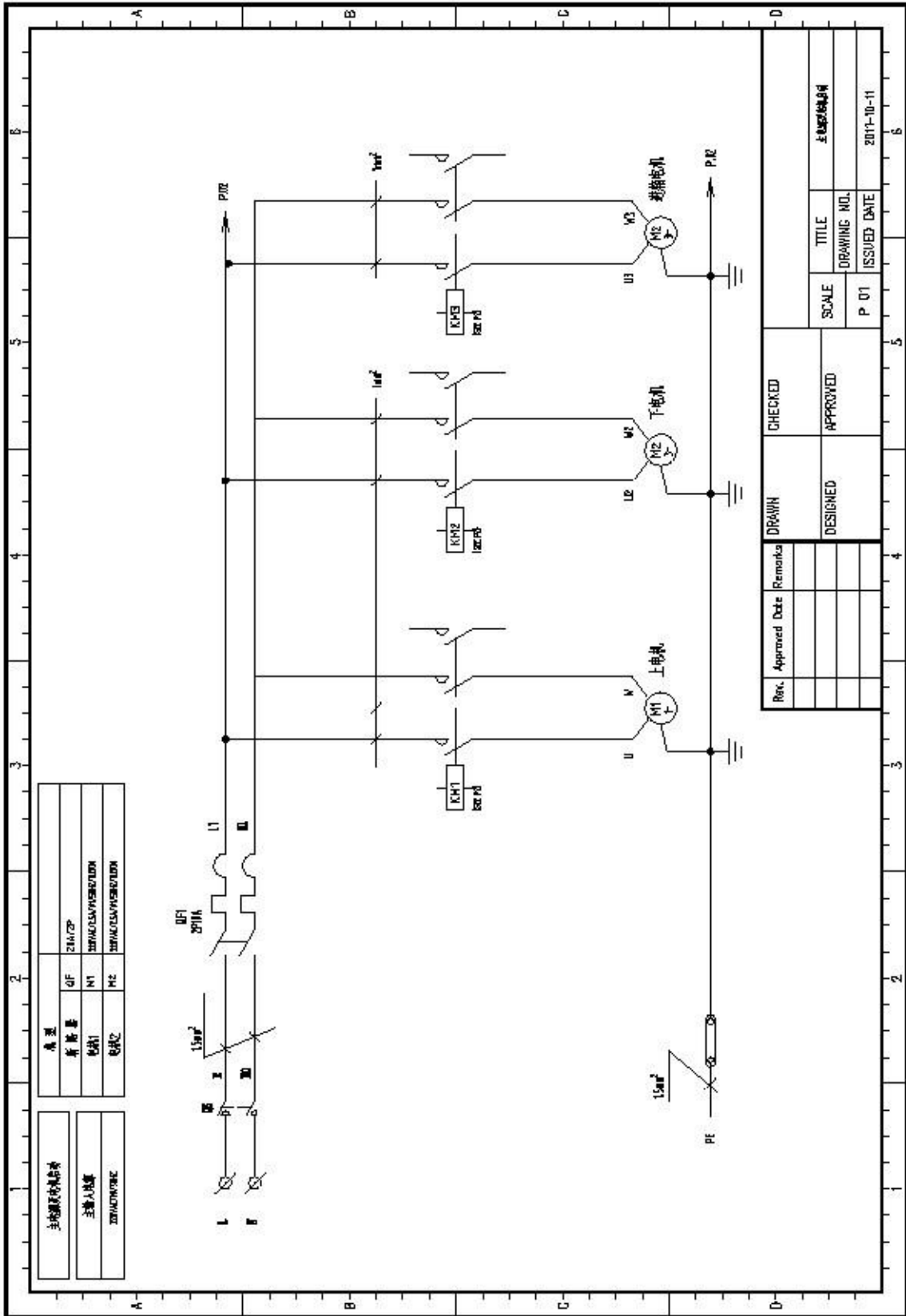
全部竣工合格印		来源	
主理人姓名		GF	21A/75P
2001/10/28		M1	2001/02/25/10/28/10/28
		M2	2001/02/25/10/28/10/28

Rev.	Approved Date	Remarks	DRAWN	CHECKED	SCALE	TITLE
			DESIGNED	APPROVED	P. 01	电动机控制
						DRAWING NO.
						ISSUED DATE
						2011-9-6



7-3 Travel control 2





主电路及控制电路	
类型	ZR/CP
额定容量	GF
电动机	M1
电动机	M2
电动机	M3
主输入电压	
ZD/MO/0/0/2	

Rev.	Approved Date	Remarks	DRAWN	CHECKED	SCALE	TITLE
			DESIGNED	APPROVED	P 01	DRAWING NO.
						ISSUED DATE
						2011-10-11

张明强

