

Manual Book

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Chapter one、 Introduction

100 series automatic packing machine is a small vertical packing machine developed by our company, with back sealing, three-side or four-side sealing bags. Computer controls the intermittent packaging machine, which can automatically complete bag making, metering, filling and sealing, printing the production date, tearing, cutting, counting, etc. This series includes four types: granule packing machine, liquid packaging machine, powder packaging machine and tablet packaging machine. In addition, a variety of forming-filling-sealing non-standard packaging machines can be designed.

This machine is pneumatic type, needing to connect with air, and customer should prepare matched air compressor by himself.

Chapter two、 Operation Precautions

- 2.1 Before leaving the factory, all the devices and mechanisms of the machine have been strictly debugged and calibrated. Users can adjust or modify one part of the machine according to their material and package characteristics to ensure that it meets the packaging requirements of users. Do not arbitrarily debug or modify any part . If there is still something unclear after reading this manual, please contact our customer service department.
- 2.2、 If there is a partial improvement on the machine, the contents of this manual may be different, please understand.
- 2.3、 This instruction only gives a brief description of the maintenance part, to ensure that the user can debug and repair according to this instruction. If there is a machine failure, the manual can not use for trouble elimination, please contact our customer service department in time.

Chapter three、 Safety Precautions and Warning



: Avoid power hurting, you must connect the ground line to keep safety.



: When wiring, please note that the power supply fluctuation caused by load change should not exceed $\pm 10\%$, that is to say, the power supply voltage must be within the range of 200V~240V to use the machine, beyond which, the normal use of the machine will be affected.



: Install the machine horizontally on a firm platform without vibration. Do not install the machine in a wobbly or tilted place with unstable state.



: The machine should be placed away from damp areas, Stay away from direct sunlight places, and high-voltage

power supply.



: Don't put the machine next to hot things.

: Keep machine power off when doing cleaning.



: Please add oil every certain time, to make sure all the parts and screws not loose, to make machine working at best station.



: Don't use wet hands to operate the machine.



: During machine working, don't touch the parts, which has the note " don't touch", or put your hands inside the protection cover.



: During machine working, please notice the machine noise, if not normal, please stop the working and begin to check the machine station.



: Please clean the sealing moulds by bronze brush after using for some time, to avoid the sealing has problem.

Chapter four、 Machine Introduction



- ①Auger filler and Hopper-Measuring and Filling Function
- ②Bag former - bag forming,different bag width need different bag former.
- ③Control panel - please refer to the following for detailed introduction.
- ④Bag-making room - completely sealing, bag-making and cutting functions. The protective cover is a transparent Acrylic panel.
- ⑤Triplet - connecting gas source, which functions as oil-water separator of gas source, and regulating the operating pressure of equipment.
- ⑥Roll film placement rack - Roll film installation and fixation.

Introduction of Control Panel

- ①Text operation panel
- ②Temperature control meter
- ③Emergency stop switch
- ④Turn off/turn on switch
- ⑤Power Switch

Chapter five、 Specification and Operation

5.1. Technical Parameters

Item	100 Pneumatic Powder Packing Machine
Model	KL-100FS
Bag size	W.30-110 L.50-160mm
Packing Speed	50 bags/min, maximum
Filling range	1-50g/bag
Control System	Mitsubishi PLC
Power	220V 50Hz
Machine material	Stainless steel
Weight	Net weight:300kg Gross weight: 320kg
Dimension	L950 x W750x H1550mm
Packing film	Paper/polyethylene; cellophane/polyethylene; Plated aluminum/polyethylene; BOPP/polyethylene; nylon/polyethylene

5.2. Operation

1. Connect with power;
2. Connect with air pipes from machine side , another side to connect with air compressor;



3. Turn on the power switch , set the machine sealing temperature, waiting for the temperature reach to the suitable sealing temperature



Actual temperature: machine actual sealing temperature;
 Target temperature: the suitable sealing temperature for a certain film

Buttons Introduction



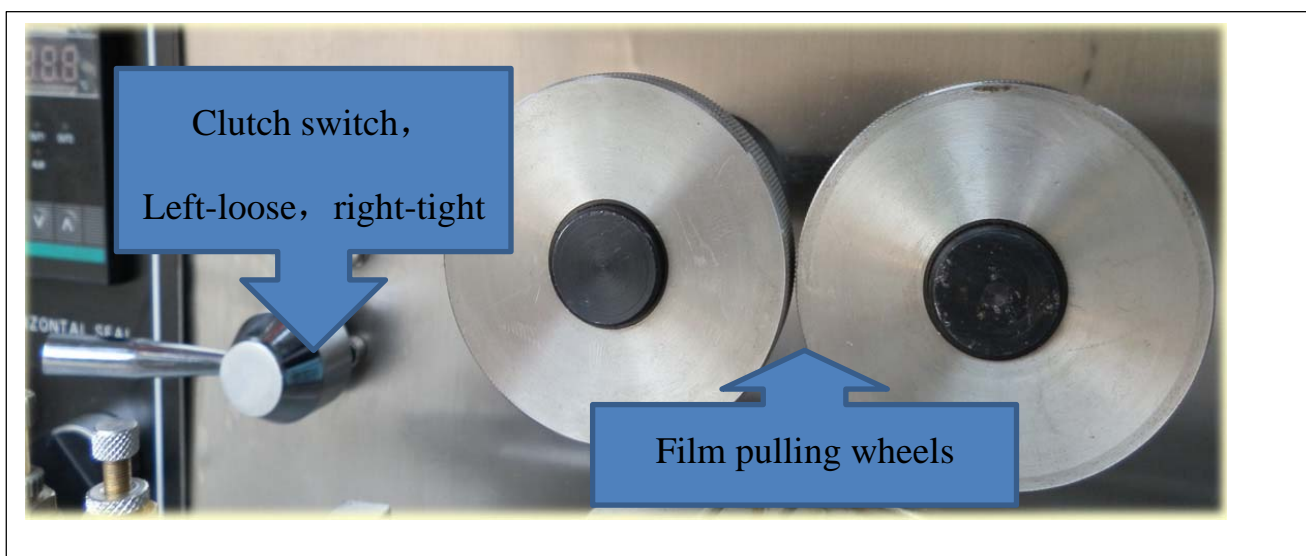
Power switch : power connection
 Emergency stop : press this button to stop
 Turn on/off : turn on or turn off the machine

4. Firstly turn on each page to check and learn all the parameters and items,



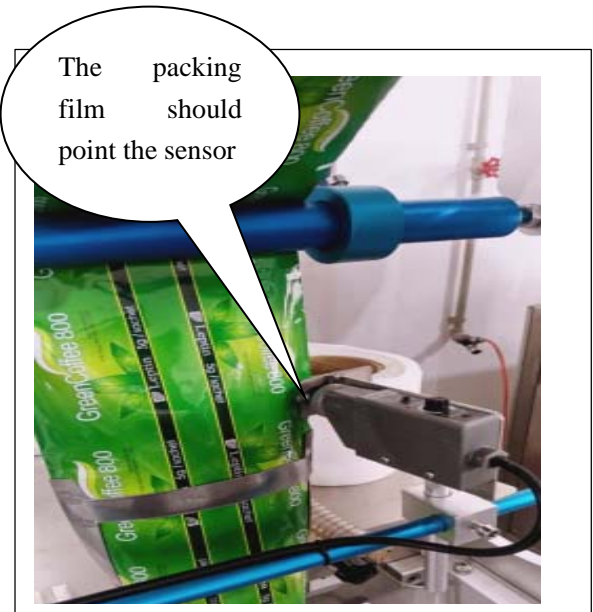
**5. Adjusting bag dimension,
and then feeding the film,
adjusting eye mark(if there is no eye mark, pls ignore).**

A: Loos the clutch(100 model), Folding the package film up and put the folded edge into pulling wheel, and then close the clutch(exact position as shown in the figure);



A: After film roll installation, turn off the eye mark switch firstly. Point the eye mark light to the non-eye mark position on the film(the below of the packing film), and then rotary the eye mark sensor switch by clockwise direction till the light is on, and then point the eye mark sensor to eye mark position, rotary the switch by anti-clockwise direction till the light off. In other words, the eye mark light will be on when the packing film pass through eye mark sensor, the eye mark light will be off when the eye mark point to sensor. The package can be completed one time after this whole process.

Sensor introduction



Film Roll Diameter:

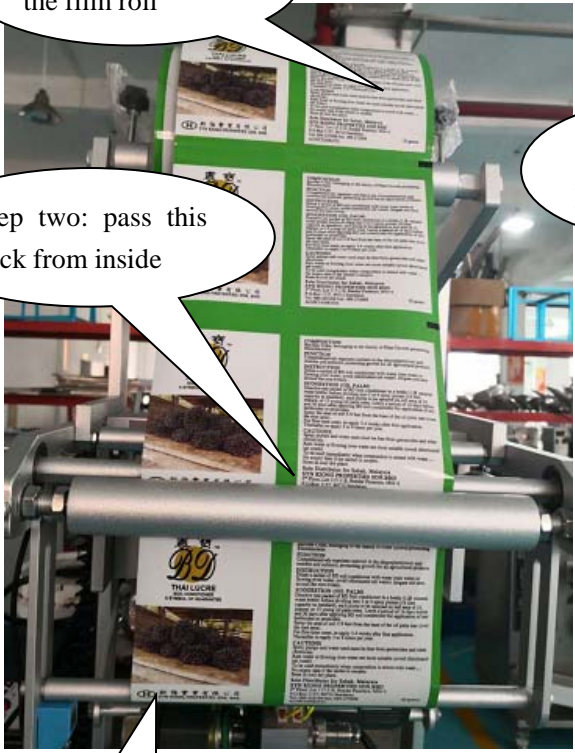
inner diameter around 75mm;

Outer diameter within 350mm



How to hang film:

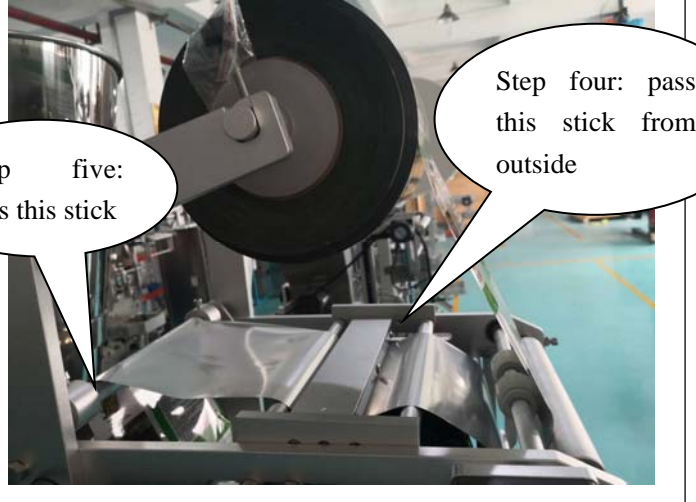
Step one: put on the film roll



Step two: pass this stick from inside

Step five: pass this stick

Step four: pass this stick from outside



Step three: pass this stick from outside

Step six: pass by this bag former



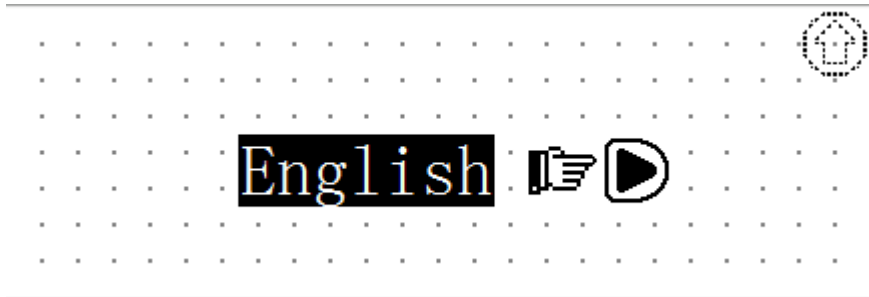
A. Turn off the filling switch before turn on the cutter switch function in the

display panel, Try to make 5-6 of empty bags to check whether they are qualified(Whether the bag is flat, whether the sealing is firm, etc) If it's qualified,turn on the feeding switch function in the display screen and the machine will run normally.

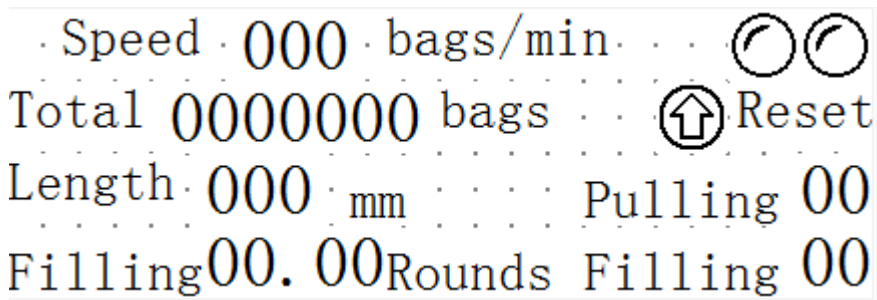
5.3 Control Panel Introduction




- ① Return button, return to the front pages
- ② Turn Left button---function one: according to the screen
Function two: move numbers to left when setting parameters
- ③ Turn Right button---function one: according to the screen
Function two: move numbers to right when setting parameter
- ④ Turn down button---function one: turn to next page
Function two: reduce the number value when setting parameters
- ⑤ Turn up button---function one: turn to next page
Function two: increase the number value when setting parameters
- ⑥ Adjust some figures
- ⑦ Confirmation

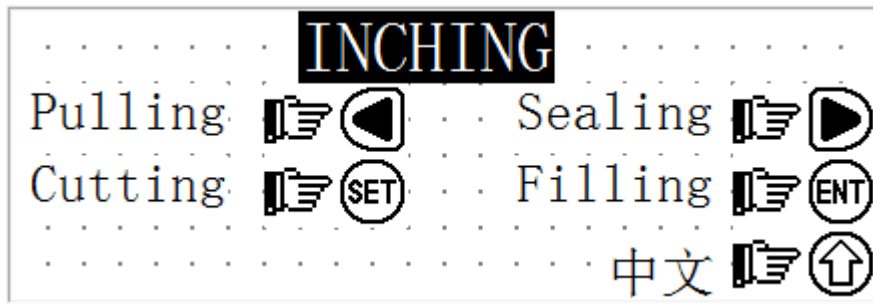


First page, press  into main operation page.







This interface is mainly to display the data when the machine is running.

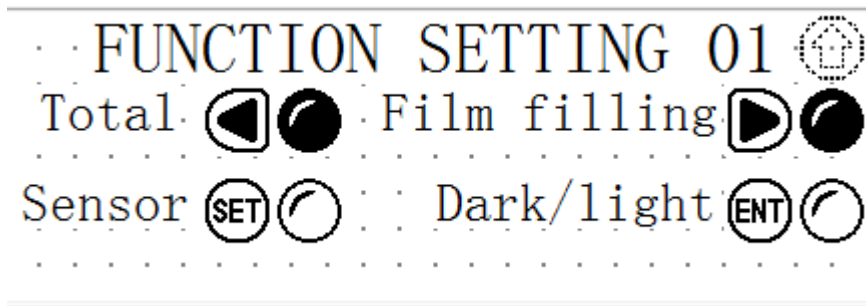
If you need to adjust the length of the bag, click  and adjust the ideal bag length according to the instructions of the function keys.






The meaning of INCHING is that we can make the bag by hand manually.

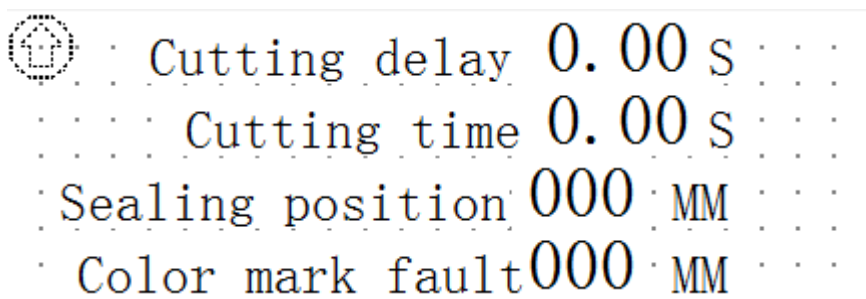
Every time when we click: Pulling , Cutting , Sealing , Filling , machine will give us a feedback about pulling, cutting, sealing, filling.

Click  into Chinese version.



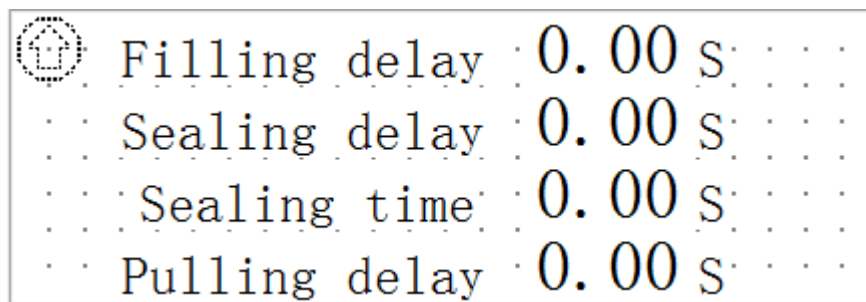
click  to open the film feeding function, click , the white circle becomes dark, indicating that the photoelectric function is turned on.


Click , please choose Dark or light according to the color mark on your packaging film.



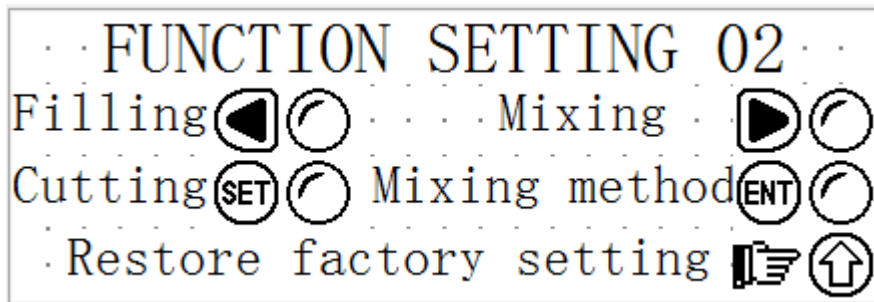
If you want to adjust the cutter time, please click , after each adjustment of a parameter,



click  to enter the next parameter to be adjusted. An analogy.

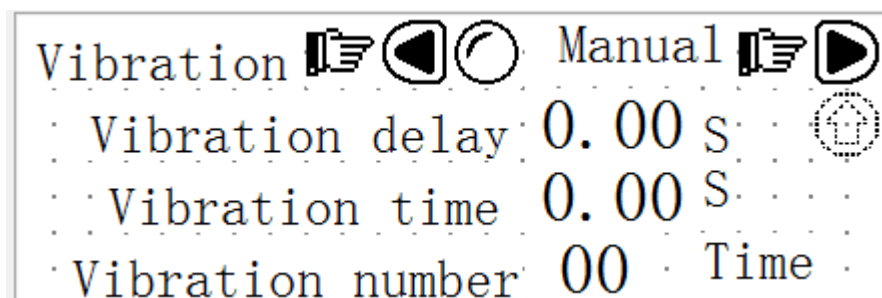




If you want to adjust these time, please click , after each adjustment of a parameter,



click  to enter the next parameter to be adjusted. An analogy.

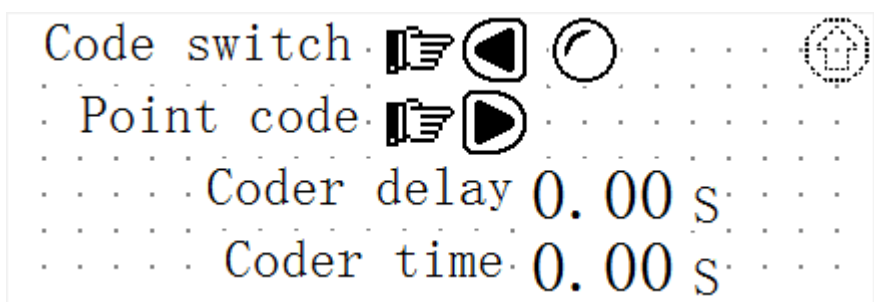



With this function, click  and the circle color will be darker, indicating that the powder filling switch is turned on. Click , the color of the circle becomes darker, indicating that the mixing switch inside the powder head is open, otherwise, click again, this function is turned off. Click SET, the cutter function is turned on, and click ENT to determine the mixing method. .





click , the circle color will be darker, means vibration function si turned on, Click , means you manually vibrate this machine.


If you want to adjust these time, please click , after each adjustment of a parameter, click  to enter the next parameter to be adjusted. An analogy.













click , the circle color will be darker, means printer function is turned on,

Click , means you manually print, if the printer effect not good, then you can adjust delay time or code time.

If you want to adjust these time, please click , after each adjustment of a parameter,


click  to enter the next parameter to be adjusted. An analogy.


Length amend 0000 
 Pull amend 0000
 Rounds amend 0000 Factoryvalue
 Full amend 0000  

Factory No. 1381 
 Ex factory 04-18-2019
 First seal   Factory value
 First pull    

First seal or first pull the bag, according to the factory settings: First seal, no need to change.

The following items are reflected on the display screen according to the conditions encountered when the machine is running.




 Film finished


 Sensor abnormal

Emergency opened

Material shortage stop

Chapter six: Filling part introduction and adjustment

Speed 000 bags/min 
 Total 0000000 bags  Reset
 Length 000 mm Pulling 00
 Filling 00.00 Rounds Filling 00

The first page of the screen, the parameter: filling_ rounds;

If you want to adjust the packing weight, adjust this screw filling circles value;

Adjust this value smaller, then the packing weight will be less;

Adjust this value bigger, then the packing weight will be more.

Chapter seven、 Maintenance

7.1 Maintenance

7.1.1 After each shift, the machine should be cleaned in time, and the remaining materials in the measuring tray and machine table to prevent becoming damp, affecting the next work.

7.1.2 Frequently check the fastening screw of each part, the tightness condition, ensure the reliable work.

7.1.3 Clean photo electricity head regularly

7.1.4 Electrical parts should pay attention to moisture and dust.

7.2 Normal problems and solution

problem	reason	solution
Machine didn't work	<ol style="list-style-type: none"> 1. Power connection problem 2. breaker tripping 3. Motor damage 4. Ac contactors do not match 	<ol style="list-style-type: none"> 1. Check the connections 2. Reconnect 3. Replace motor or damaged parts 4. Check voltage or replace ac contactor
Leakage switch trip	Heat pipe, motor leakage	Check all electronic parts to eliminate leakage problems
Heat sealing mould is not hot (Display outdoor temperature)	<ol style="list-style-type: none"> 1. The heating pipe or temperature control meter is broken 2. The solid state relay is broken 3. The wire break 	<ol style="list-style-type: none"> 1. Replace the damaged parts 2. Replace the relay 3. Check the wirings
Stop at normal temperature, but when the machine is working, the temperature will suddenly drop	Low voltage leads to low power of heating pipe	Slow down or use a steady power supply to instead.。

Packaging film damage	<ol style="list-style-type: none"> 1. Poor packaging film quality 2. Paper feeding motor does not work 3. The proximity switch is broken 4. The circuit is reversed, causing the motor to reverse 	<ol style="list-style-type: none"> 1. Replace the packaging film 2. Repair or replace paper supply motor and proximity switch
Product leakage	<ol style="list-style-type: none"> 1. The temperature is too low 2. The molds are not aligned 3. Not enough pressure 4. packaging film is irregular 	<ol style="list-style-type: none"> 1. 1. Increase the temperature 2. adjust the molds 3. Replace the packaging film

Chapter eight、 After-sales Service

- 1、 This machine, the seller provide warranty for one year time and technical support for life-long time.
- 2、 During the warranty period, if the machine has some problems, our company will help to repair in time. If the problem is caused by human reasons or adjustment reasons, then we will charge for labor cost.
- 3、 We provide some easy wearing spare parts free with the machine when delivery, customers can change it accordingly. If customers want more spare parts, please ask us for buying them.