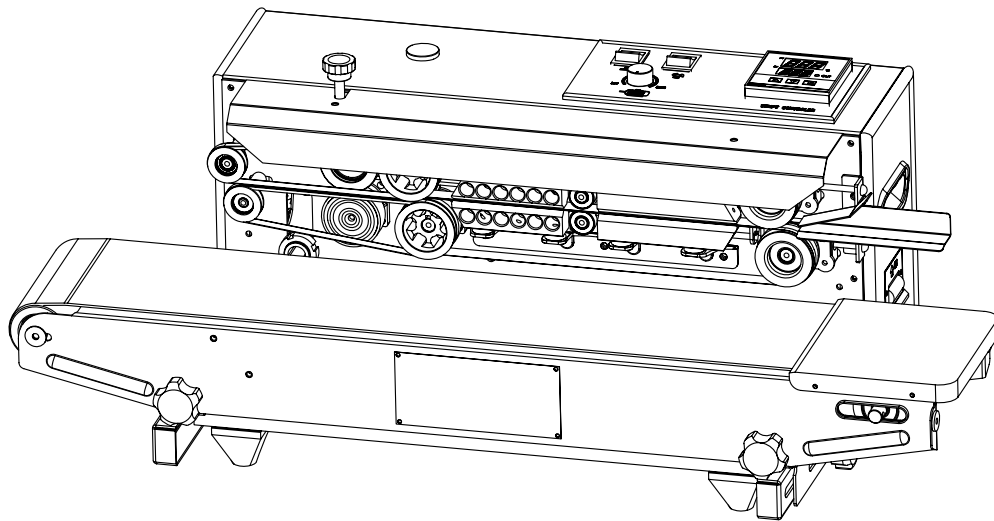


SF-150
PLASTIC BAG SEALING MACHINE
USER MANUAL



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I. FEATURES

- ◇ Unlimited sealing length
- ◇ Number and letter embossing
- ◇ Digital temperature controlling
- ◇ User-friendly
- ◇ Horizontal and vertical double usage
- ◇ Durability

II. STRUCTURE AND WORKING PRINCIPLE

This machine is composed by frame, speed controlling system, heating system, Conveyor and embossing system. Power on the machine and switch on the heating system, 1 minute later the copper blocks is heating. Adjust the temperature and speed according to thickness and material of bags, to find out the best parameter. Put the mouth of bag between the 2 running sealing belts, to let the sealing belts convey the bag to the heating area. The mouth of bags is clamped and heated by the copper blocks. Then the sealed bag is convey to the cooling area where the embossing wheel is rolling. There are many patterns optional, including mesh, strip, smooth and letter-number embedded.

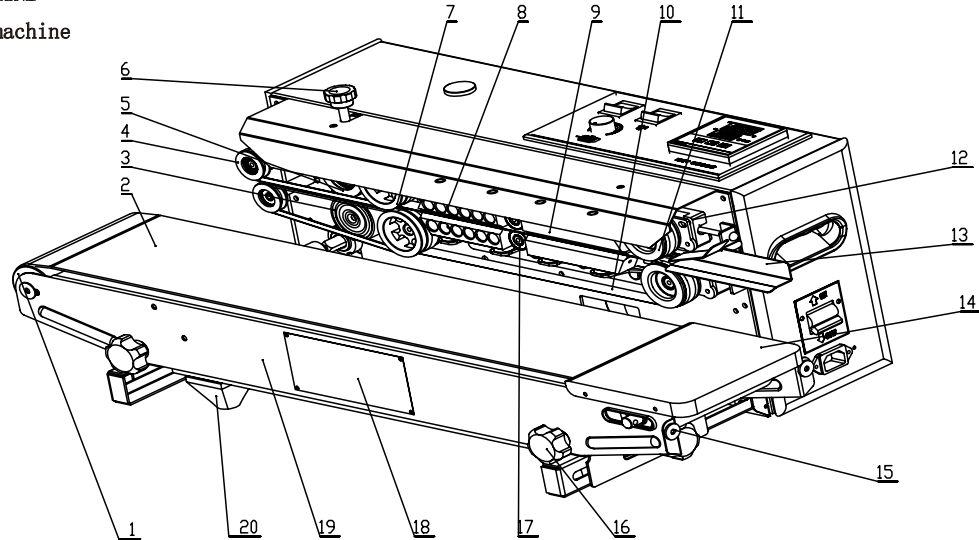
III. TECHNICAL SPECIFICATIONS

Voltage: 220 \pm 10V /50Hz or 110 \pm 10V/50Hz (customizable)
Max overall power: 620W Power of motor: 60W Power of heater: 280W x2 (adjustable)
Speed: 0-16M/min. Sealing width: 10mm (customizable)

	Dimension	Gross weight
Horizontal	810x395x300mm	24kg
Vertical	810x330x525mm	27kg

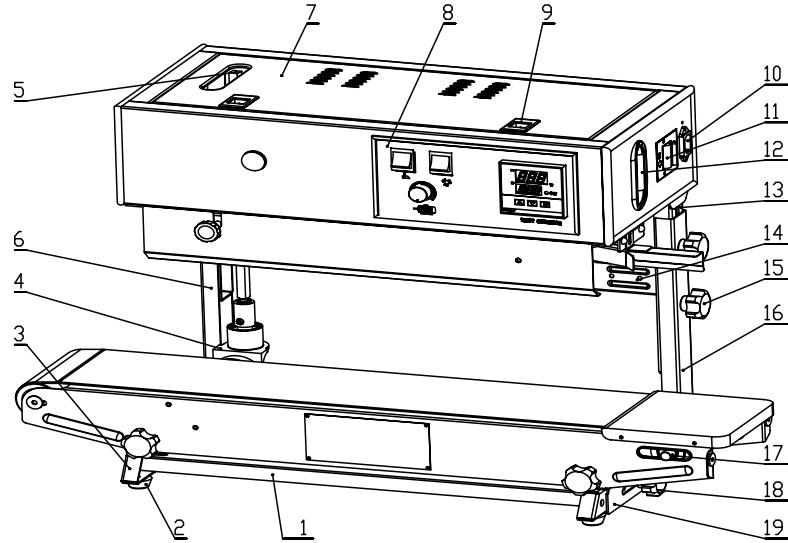
IV. OVERVIEW OF MACHINE

Fig.1 Horizontal machine



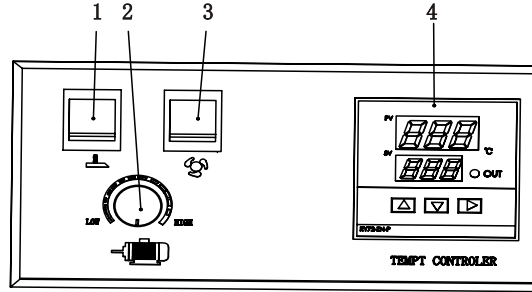
- | | | | | |
|-------------------------------|------------------|------------------------|------------------------|------------------------|
| 1.driving roller for conveyor | 2.conveyor belt | 3.rubber wheel | 4.guide wheel | 5.embossing wheel |
| 6.emboss adjusting knob | 7.driving wheel | 8.cooling copper block | 9.heating copper block | 10.sealing belt |
| 11.passive wheel | 12.sliding seat | 13.feeding | 14.platform plate | 15.belt adjusting knob |
| 16.bolt and nut | 17.holding wheel | 18.nameplate | 19.conveyor | 20.footing |

Fig.2 vertical machine



- | | | | | |
|-----------------|------------------|-----------------|-------------------------|----------------------|
| 1. base beam | 2.rubber footing | 3.left base | 4.bevel gear seat | 5.long vertical axle |
| 6.left column | 7.back cover | 8.control panel | 9.lock | 10.power input |
| 11.power switch | 12.handle | 13.right base | 14.transverse beam | 15.bolt and nut |
| 16.right base | 17.passive axle | 18.bolt and nut | 19.level adjusting rack | |

Fig. 3 Control panel



1. Heating switch 2. Speed knob 3. Fan switch 4. Temp. controller with indicators

V. PREPARATION

- (1) For safety, the housing should be earthed, please make sure the 3-pin plug can be well connected.
- (2) Preheat for 1 minutes with low temperature, and if it is unused for a long time, 3 minutes for preheating is necessary.
- (3) Adjust the position of conveyor by bolt and nuts to match bags.
- (4) Adjust the feeding according to the desired sealing width.
- (5) Adjust the space between the 2 heating copper block and between the 2 cooling block if the bag is very thick.

VI. START WORK

- (1) Power on the machine, all indicator light and all belt and wheel run synchronously.
- (2) Adjust the pressure embossing wheel.

(3) Turn on the heating switch, and adjust the temperature according to material, thickness and speed.

The following setting is only for reference.

a) Polyethylene: 150 ~ 160°C

b) Polypropylene: 170 ~ 180°C

c) Polyolefin compound: 180 ~ 189°C

When the red indicator of the temp. controller light up, please test it with the bags, and re-adjust the temperature, speed and embossing pressure if necessary. Then start continuous sealing work.

(4) To prevent bags from being wrinkle, please open the fan, if necessary.

(5) Put bag to the feeding, and let the sealing belt grip the mouth of bag which should be aligned with the feeding, and let bag be conveyed automatically.

VII. VERTICAL TRANSFORMATION

1. Fix the left base and right base to the base beam and transverse beam with nuts according to the Fig.2, now the vertical frame is ready.
2. Loose the two bolts and nuts on the conveyor nut and take the conveyor apart from the machine.
3. Fix the conveyor to right left base and right base which are combined in the first step.
4. Instead the short horizontal axle with the long vertical axle and the bevel gear seat.
5. Put the long vertical axle into the axle hole of the machine, in the meantime, put the right and left stand of the main body into right and left base, and tighten the bolts and nutss.

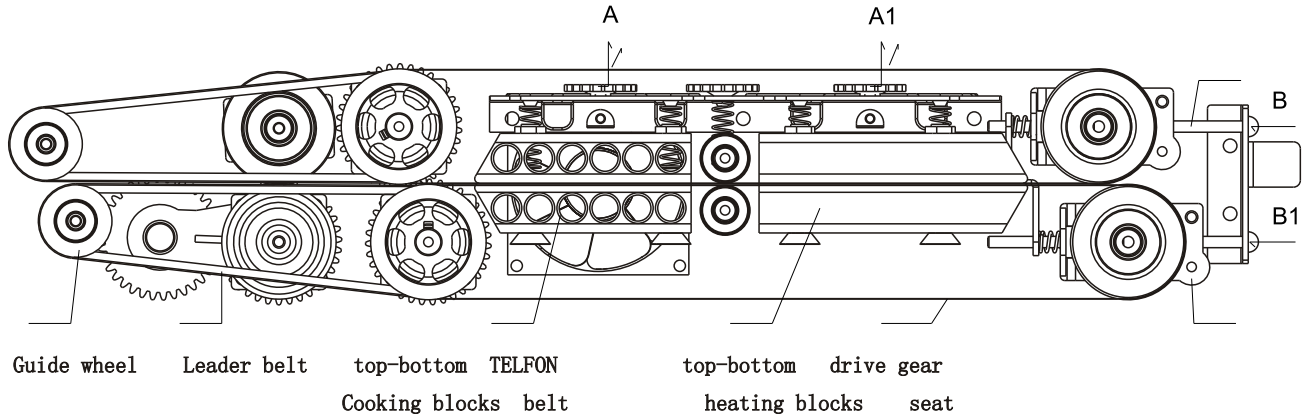
VIII. HOW TO CHANGE THE EMPOSSING WHEEL

1. Unscrew and take off the top hood.
2. Take off the 2 gear belt, and unscrew embossing wheel.
3. Lift the moveable seat and change the
4. Re-fix the parts took off before, and re-adjust the pressure of embossing wheel, then power on the machine and try.

IX. MAINTENANCE

1. To charge the belts
 - a) Take off the hood.
 - b) Unscrew the guide wheel.

Fig. 4



- c) Take off the gear belt from the passive wheel.
 - d) Lift a little the copper coppers block by adjusting A and A1.
 - e) Push B or B1 to loosen the sealing belts and change them.
 - f) Put the gear belt to the passive wheel.
 - g) Put the other end of gear belt to the guide wheel, meanwhile put the wheel back to its axle.
 - h) Screw the guide wheel.
2. To maintain the gear box

Assuming that the machine work 8 hours daily, please add 50g of 20# engine oil monthly, and clean it yearly.

X. TROUBLE-SHOOTING

MALFUNCTION	POSSIBILITY	SOLUTIONS
Do not works	<ul style="list-style-type: none"> 1.No well connected to the power 2.The speed controlling circuit is broken 	<ul style="list-style-type: none"> 1. Inspect if the machine is correctly connect to the power supply, and the fuse is in good condition 2. Change the speed controlling circuit
Can not adjust speed	The speed controller is broken	Change the speed controller
Do not heat	<ul style="list-style-type: none"> 1.The heating tube is broken 2.The wire of heating tube is not well connected 3.The temperature controller is broken 4.The thermal sensor couple is broken 	<ul style="list-style-type: none"> 1. Change the heating tube 2. Connect it and screw the terminal with force 3. Change temperature controller 4. Change the thermal sensor couple
Embossing pattern is unclear	<ul style="list-style-type: none"> 1. Not enough pressure 2. Rubber wheel is aged 3. The embossing wheel is stained 4. Hot enough temperature 	<ul style="list-style-type: none"> 1. Adjust the knob of embossing pressure 2. Change the rubber wheel 3. Clean te embossing wheel 4. Adjust the temperature

Sealing belt is fragile	<ol style="list-style-type: none"> 1. Not enough space between the 2 heating copper blocks 2. The space between the copper blocks is not clear 3. The sealing belt is stained with plastic 4. Temperature is still high when machine stopped 5. The bolt and nut B or B1 is too tight 	<ol style="list-style-type: none"> 1. Adjust the wheel A1 in Fig. 4 2. Clear copper blocks 3. Clear the sealing belt 4. Switch off heating firstly, few minute later power off the machine. 5. Loose the bolt and nut B or B1 in Fig. 4
Sealing belt slips	<ol style="list-style-type: none"> 1. It is slack 2. Not enough space between the copper blocks 	<ol style="list-style-type: none"> 1. Tighten the bolt and nut B or B1 in Fig. 4 2. Adjust A or A1 in Fig. 4
Conveyor belt slips	It is slack	Adjust the N. 15 knob in Fig. 1

XI. EXPLODED VIEWS

Fig. 5

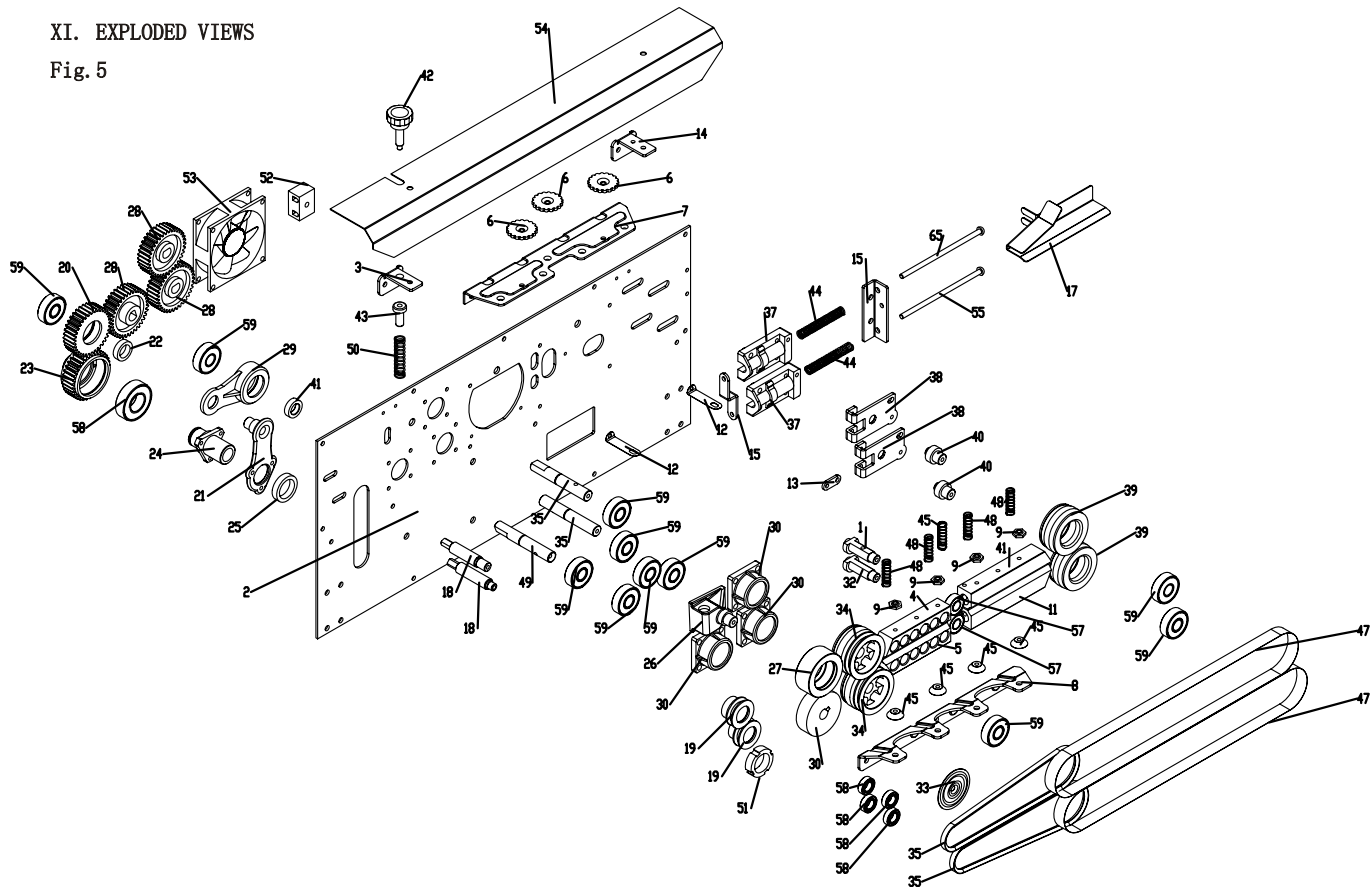


Fig. 6

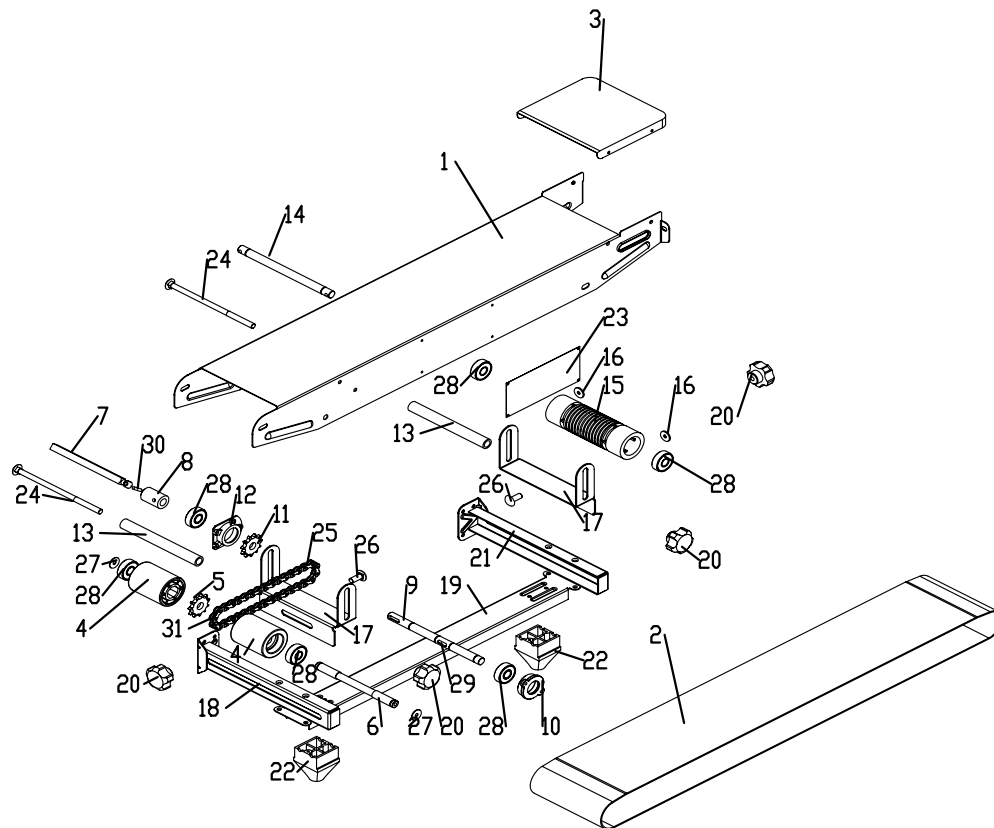
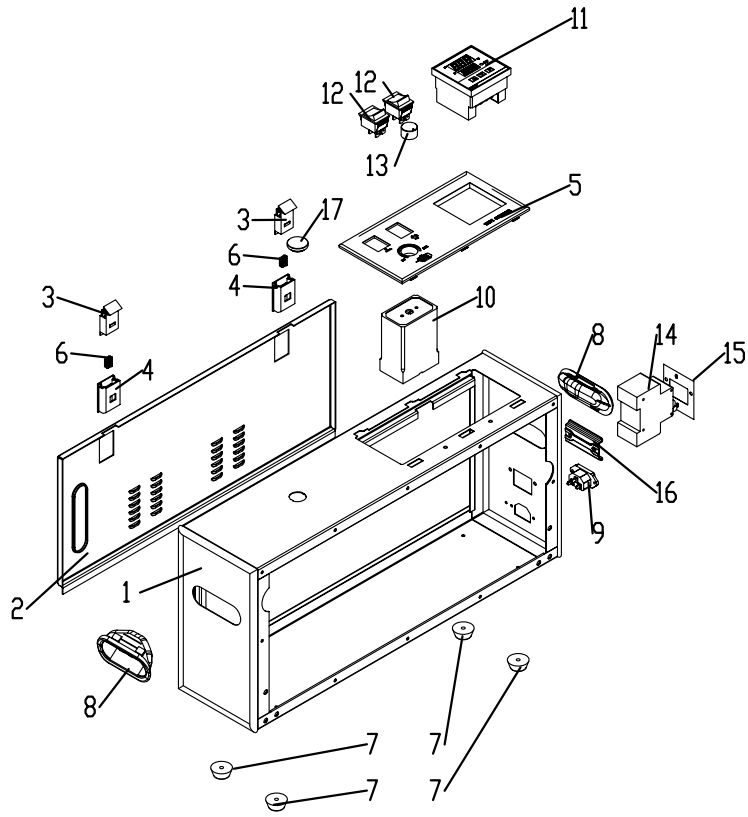


Fig. 7



XII. PACKING LIST

Machine	1 unit
Cable	1 unit
Sealing belt(772m)	4 units
Fuse	2 units
Cross-headed screwdriver (4#)	1 unit
User manual	1 unit
Crescent wrench	1 unit
Ceramic washer	2 unit
ADDINIONAL PART FOR VERTICAL TYPE	
Frame	2 sets
Bevel gears	1 set
Bolt (M8)	2 units
Nut (M4*8)	2 units
Screw (M4*25)	8 units
Screw (M4*25)	3 units
Screw (M4*25)	2 units
Washer (φ 8)	2 units