

# AUTOMATIC MICROCOMPUTER SEALING MACHINE

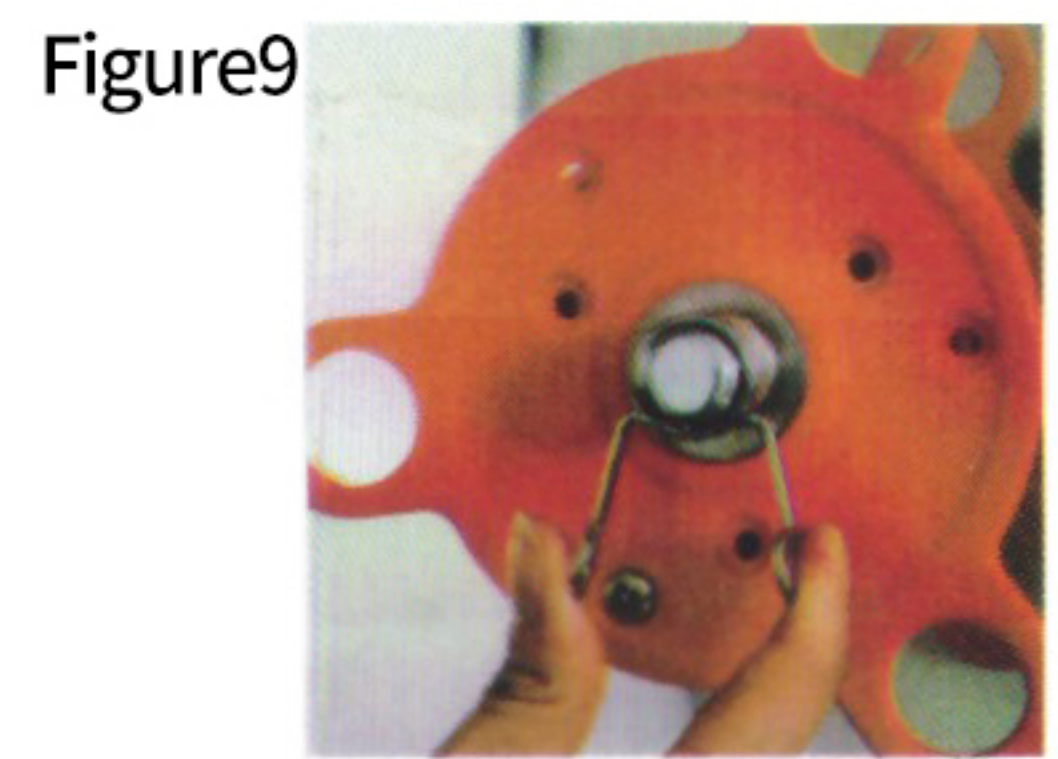
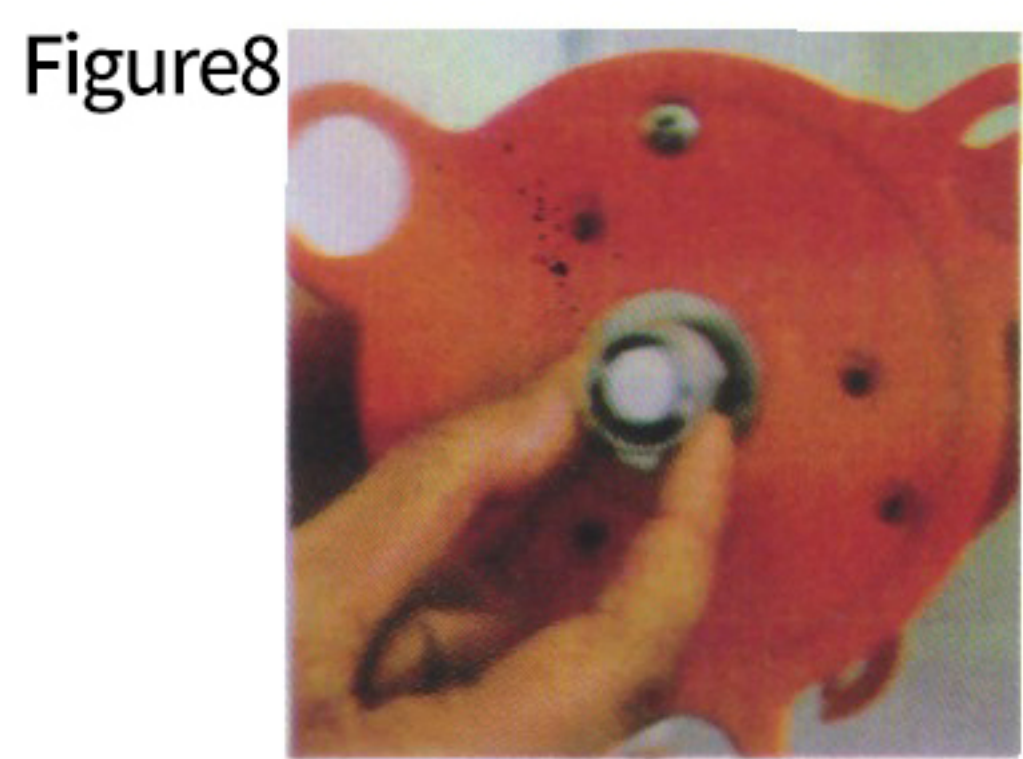
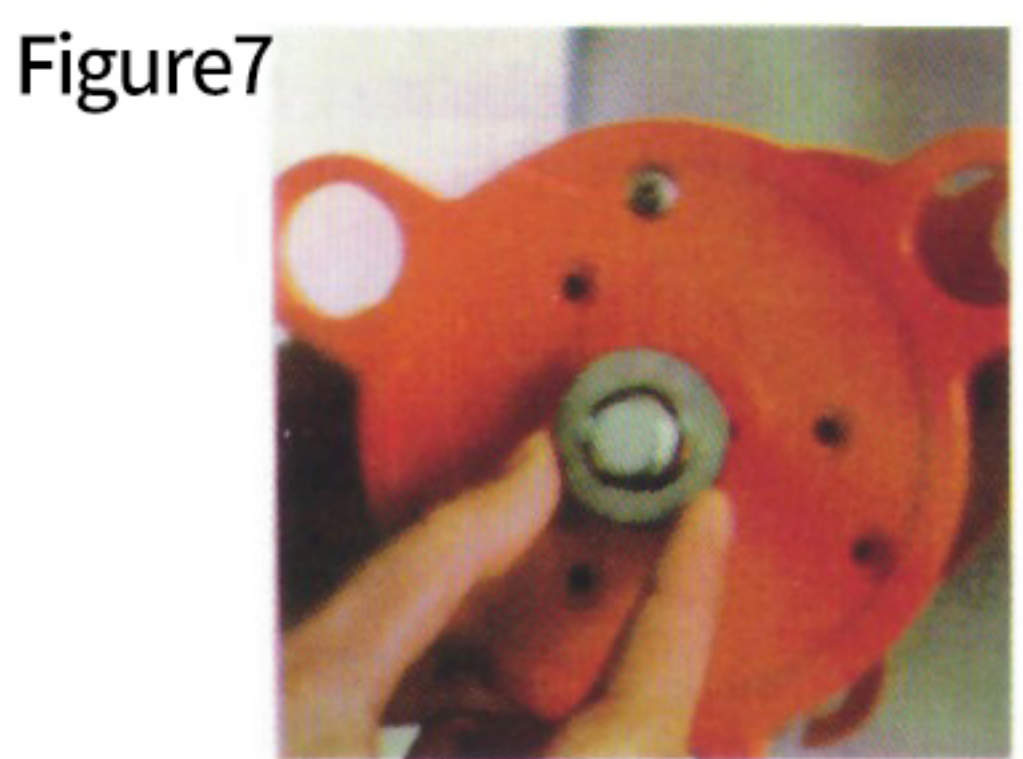
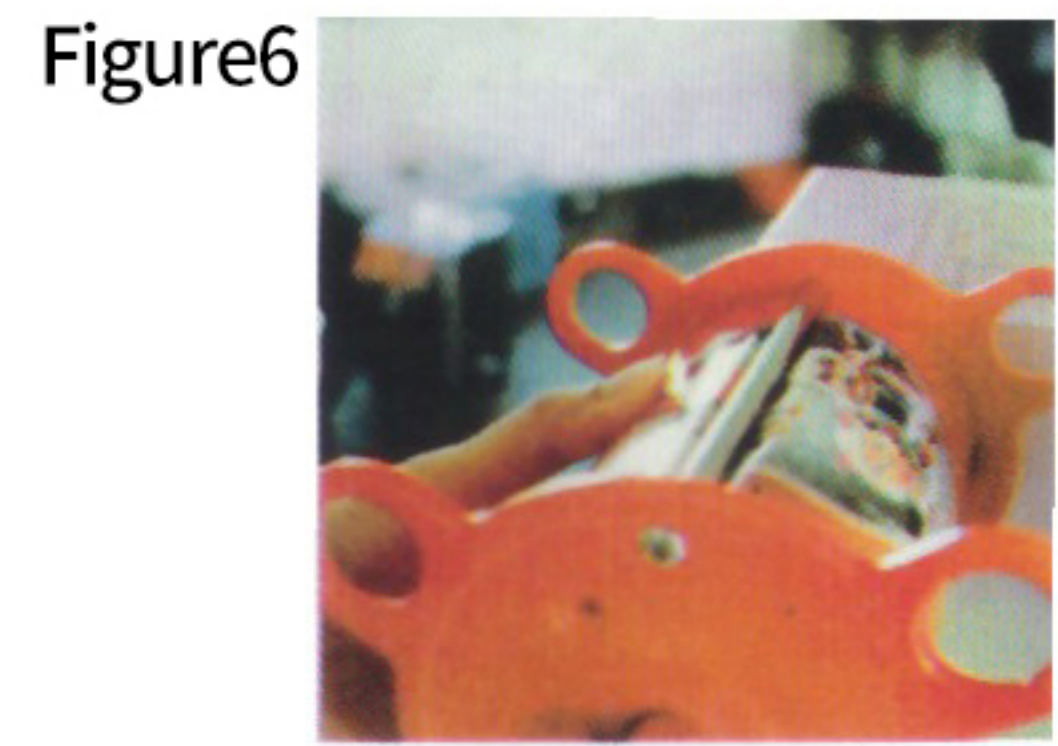
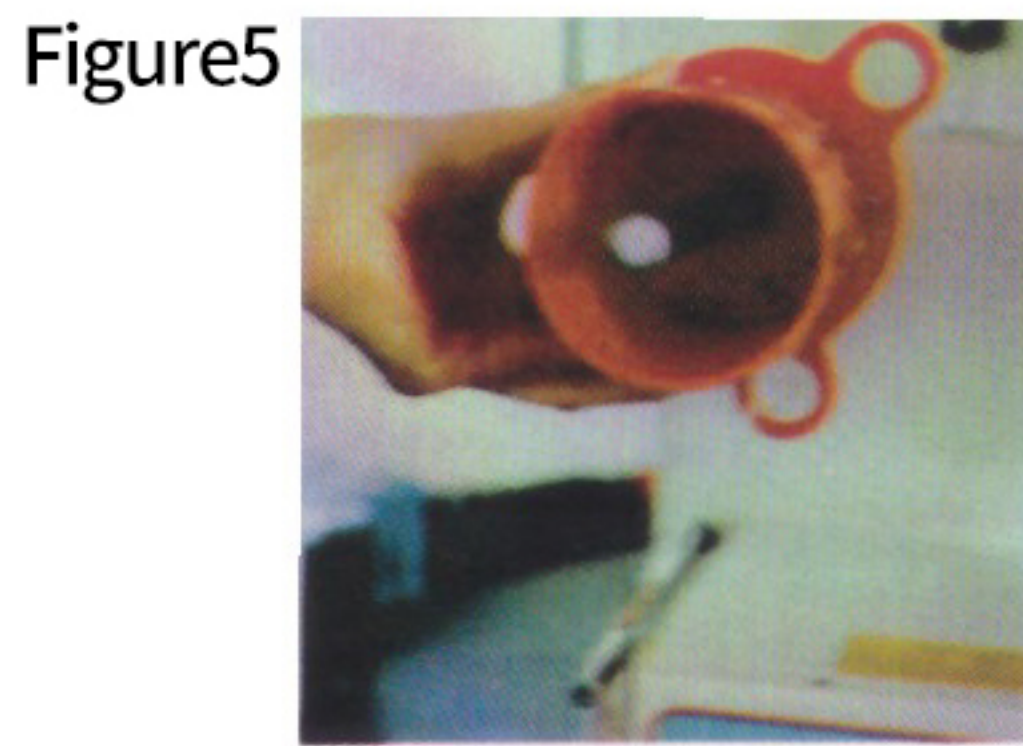
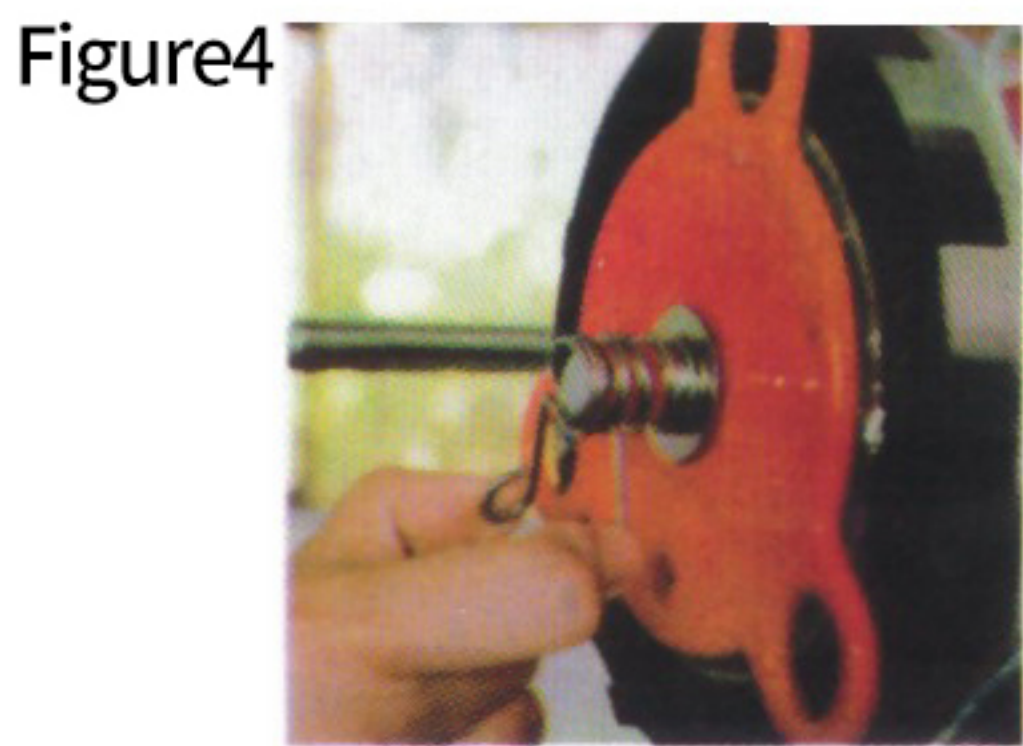
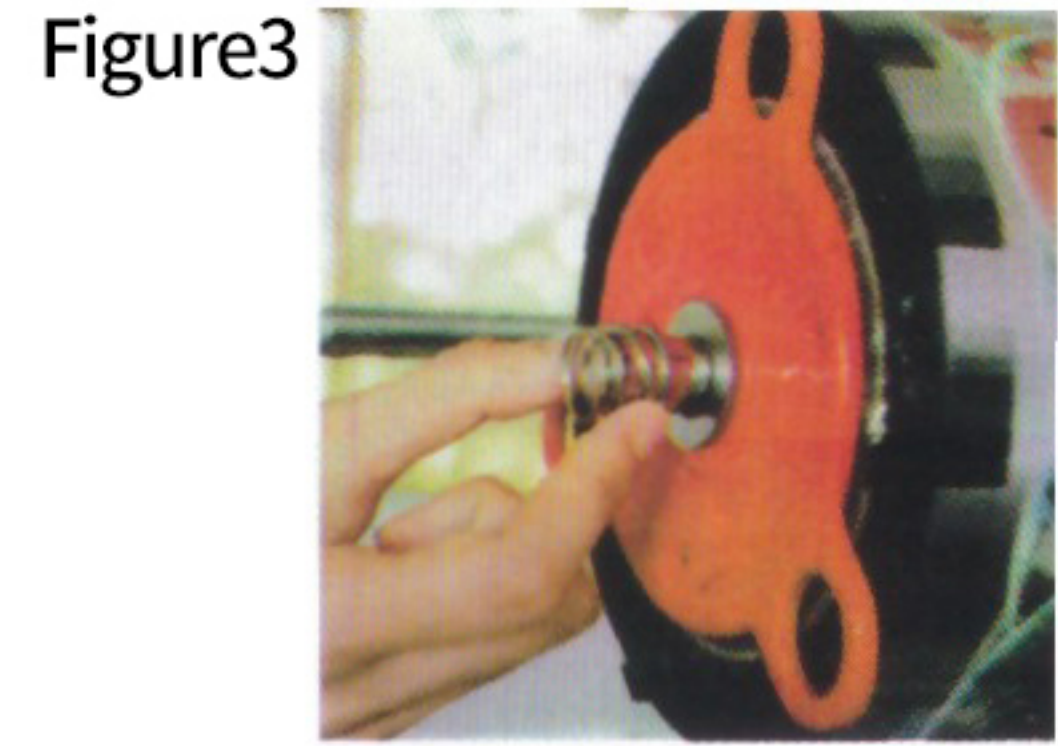
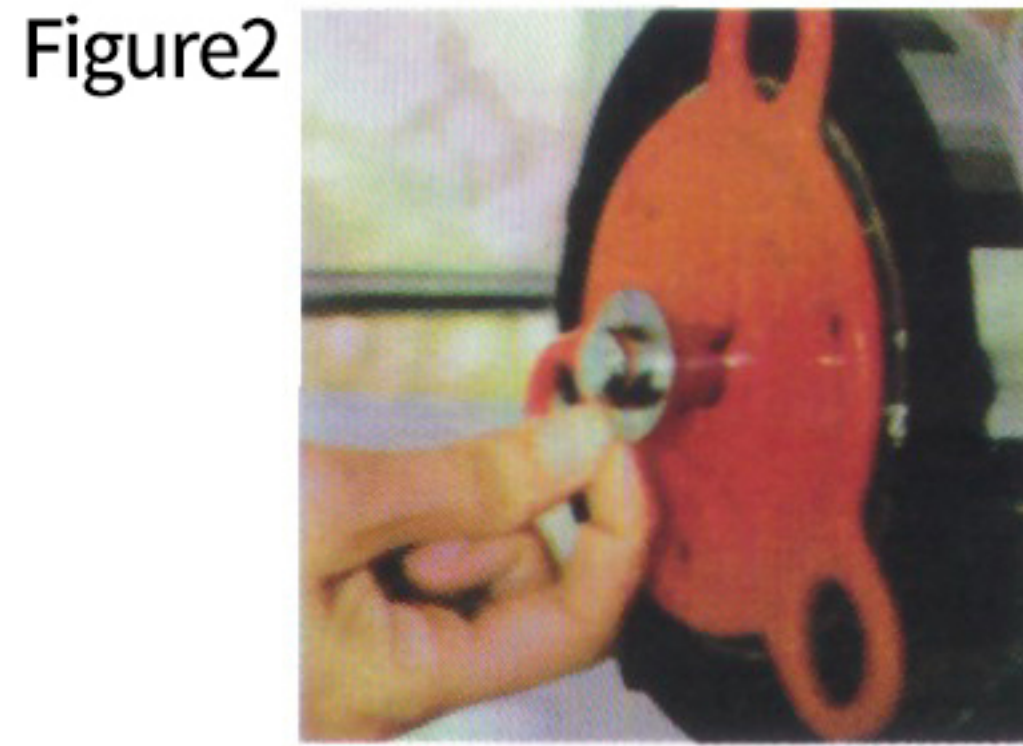
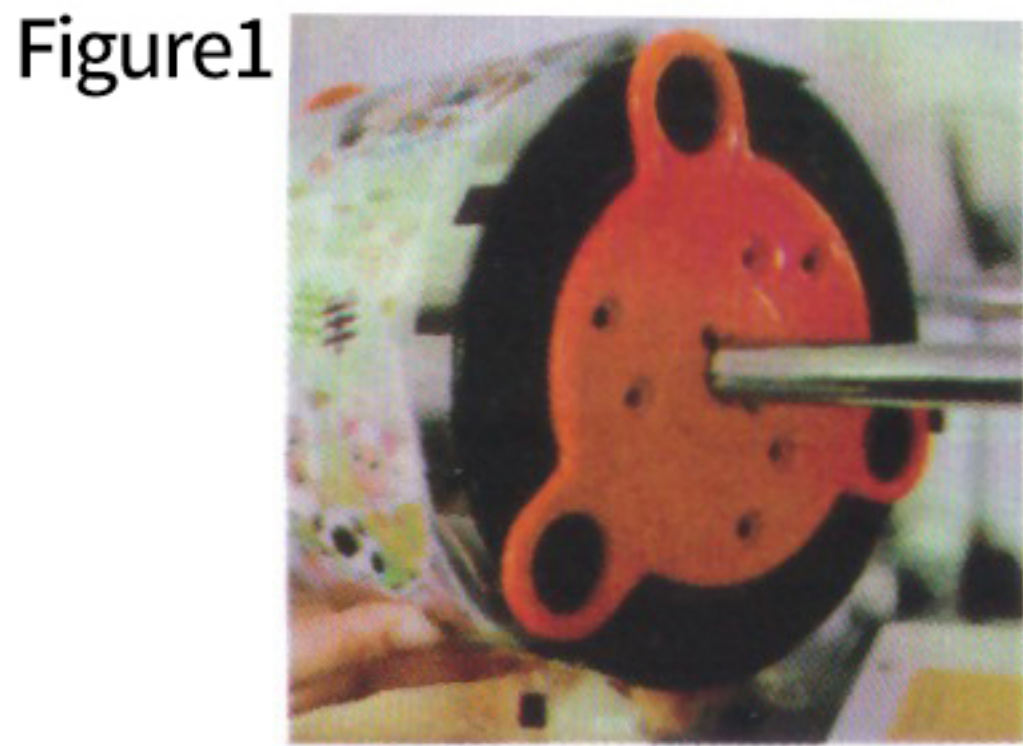
## OPERATING INSTRUCTIONS

It is absolutely forbidden for  
children and non related personnel to operate



# FILM LOADING METHOD AND SCHEMATIC DIAGRAM

A. Install the sealing film in the order shown in the figure below



B. Ensure that the film material passes through the six guide pillars in strict accordance with the position shown in Figure 7

Figure 7 shows the location

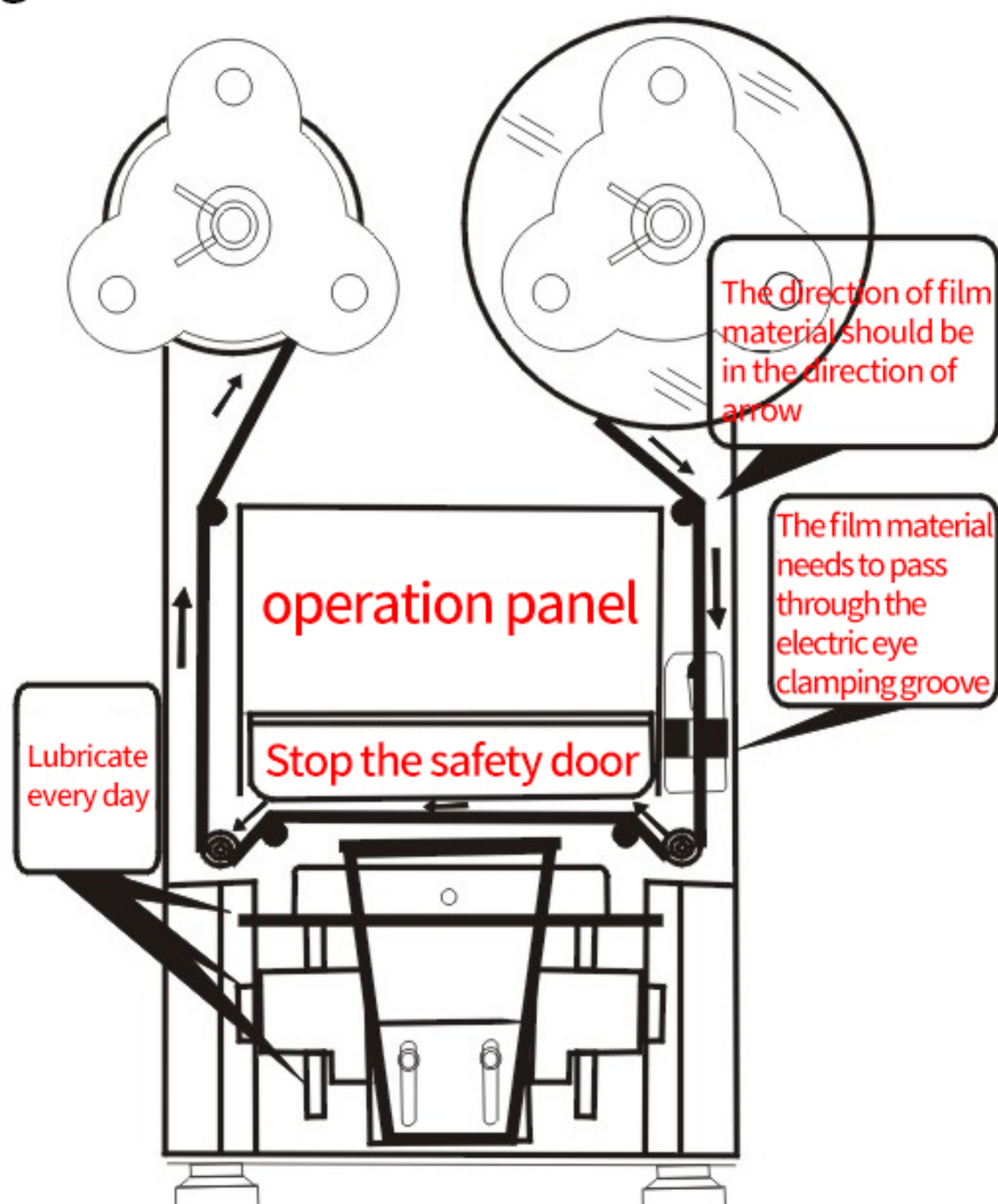


Figure 10

The waste film cylinder can drive the rotation of the membrane (FIG. 11)

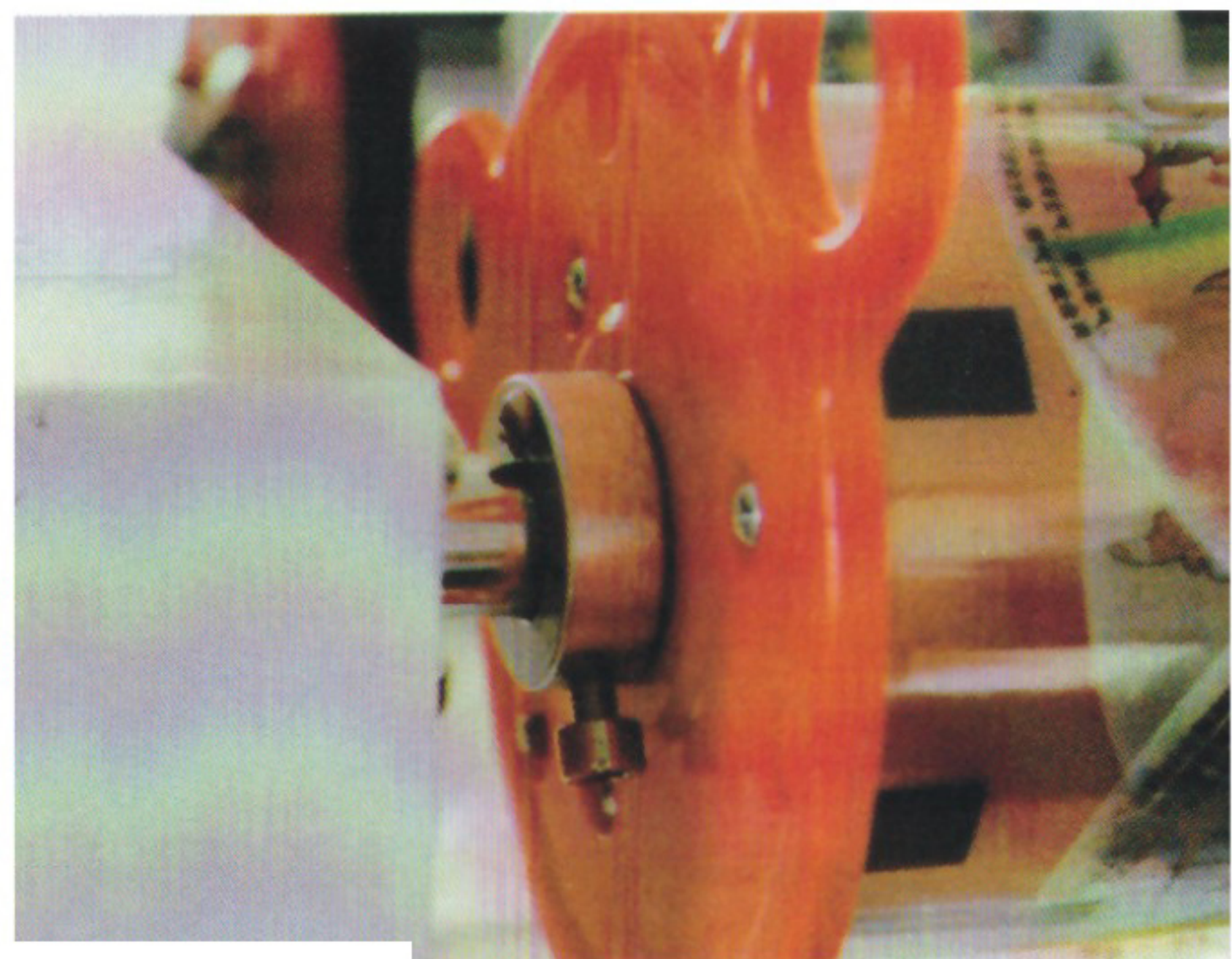
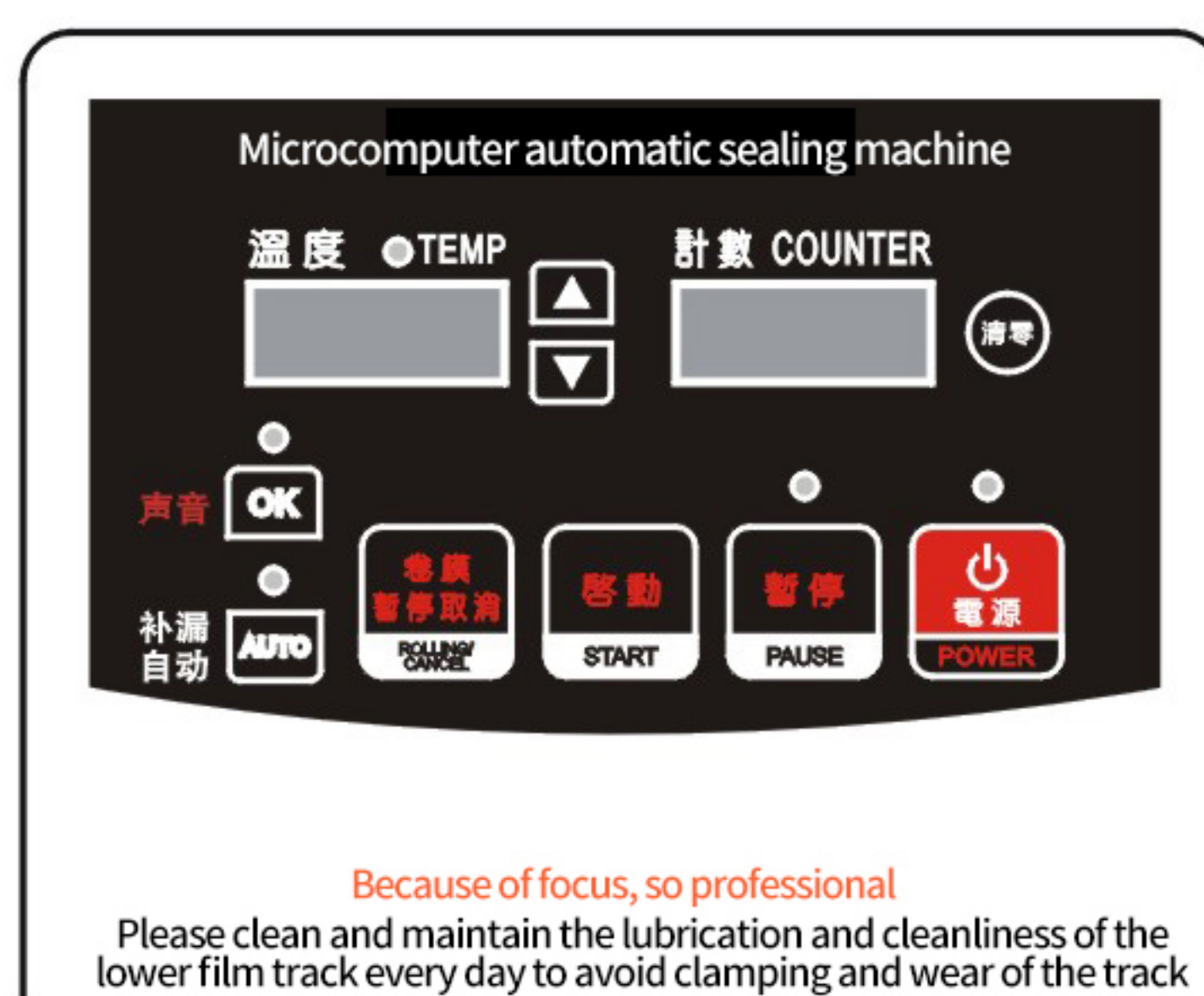


Figure 11



# INTRODUCTION TO OPERATION PANEL

Figure 12



The machine is connected to the power supply with grounding (in line with the rated voltage of the machine of 220V), and the power signal flashes to indicate that the machine has been connected to the power supply and is in the state of waiting to be started

**【power key】** press this key, the machine will enter the standby mode, and the power signal light will be on for a long time

**【pause key】** press this key to stop the current action immediately and maintain the current action posture.

To continue the current action, press the **【start】** key:

To cancel the current action, press the **【cancel / roll film jog】** key:

**【start key】** in "automatic mode IV" or "semi-automatic mode", press this key and the machine will automatically seal the cup once

**【cancel / roll film inching】** when the machine is suspended, this key is used to cancel the function;

In the standby mode, press this key and the waste film drum will rotate continuously;

**【sound key】** this key controls the machine sound on and off;

**【auto key】** long press this key to switch between "automatic mode" and "semi-automatic mode"

When the automatic signal lamp is always on, it is "full automatic mode", and when the automatic signal light is off, it is "semi-automatic mode"; Press this key and the machine will enter the "intelligent auxiliary function mode"

**【zero key】** press this key once, and the machine will enter the "counting hidden mode". Press this key again to restore the counting function. Press this key for a long time, and then release it to clear the current count

**【leak proof and repair function】** in standby mode, press the **【auto key】**, and the automatic signal light flashes, indicating that the machine enters the "intelligent auxiliary function", puts the container with problem sealing, and then presses the **【start】** key. The relevant parameters of the machine are improved instantly, and the operation of "leak proof and make-up" is carried out automatically. After the container is taken out, the machine automatically returns to normal standby state.

**【automatic knife washing function】** in the standby mode, put the cleaning cotton into the groove of the lower film, or fold the tissue paper (plant fiber) into a strip and fill it up. Block the water outlet of the lower film circle with the plug attached with the machine. Press the **【pause】** key for 3 seconds and then release the hand to enter the automatic knife washing. Press up and down for 5 times to exit automatically

**【automatic parameter setting】**

1. According to the actual use, the machine can adjust the sealing and the time of entering and leaving the cup.
2. We can choose whether to use electric eye or not, so as to be suitable for some non-standard films such as light film or aluminum film
3. Press and hold the **【sound】** key for 3 seconds to enter the parameter adjustable state. In p1-p5, press the **【sound】** key to switch the adjustable parameters, and press the temperature + or temperature - to switch. After 5 seconds of adjustment, it will be automatically saved or the **【pause Cancel】** key will be saved

| Serial number | project                       | Gear left nixie tube | Parameter adjustment right nixie tube | remarks  |
|---------------|-------------------------------|----------------------|---------------------------------------|--|
| 1             | The temperature is adjustable | P001                 | Adjustable from 100 ° C to 230 ° C    | Adjust this parameter, lock the temperature, factory default 184 ° C |
| 2             | Count clear / not clear       | P002                 | OFF ON                                | The factory default is off, and the count is not cleared             |
| 3             | Cup sealing delay             | P003                 | (0 ~ 50 ° C) adjustable               | Represents 0-5 seconds, factory default 12                           |
| 4             | Cup intake delay              | P004                 | (0 ~ 30 ° C) adjustable               | Represents 0-3 seconds, factory default 10                           |
| 5             | Receiving time                | P005                 | (0 ~ 99 ° C) adjustable               | Represents 0-9.9 seconds, factory default 0                          |



## DAILY MAINTENANCE

### 1. The following maintenance items must be carried out every day:

- ① Check whether the heating plate on the film is clean every day to prevent the film from sticking with foreign matters, resulting in poor sealing effect or sealing failure. After the heating plate is cooled, wipe it with warm cloth.

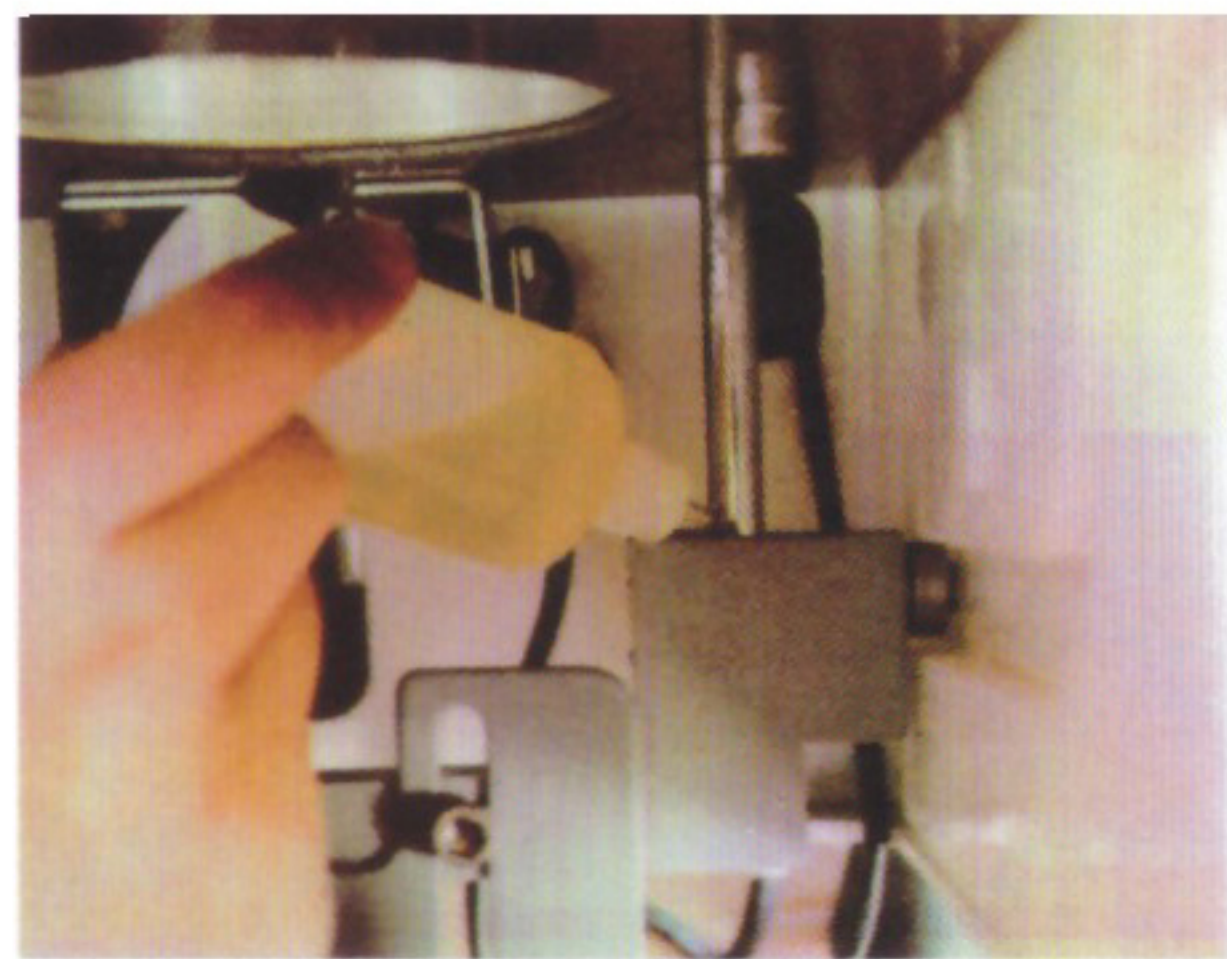
**Note: please turn off the power and pay attention to high temperature**

- ② The worktable must be wiped clean every day, and check whether the working platform and track are lubricated smoothly, and add guide rail oil in time

Figure 13



Figure 14



- ③ Keep the lower film groove clean to prevent the upper film blade from contacting with dirt
- ④ Keep the film rolling eyes and in and out eyes or microswitches clean and clean
- ⑤ Clean the film blade every day (using the automatic knife washing function)

### 2. Other maintenance items and repair

- ① Users actively cooperate with after-sales service personnel for telephone guidance, and carry out relevant operation or maintenance according to instructions
- ② The user should contact the regional personnel or future service personnel for handling

## COMMON PROBLEMS AND SOLUTIONS IN THE PROCESS OF CUSTOMER USE

### 1. Temperature display area, display "E023"

- ① Possible cause: thermal sensing system error  
Solution: check whether the connectors of the thermal sensor system are in good contact, or replace the thermal sensor (pay attention to the "+" connection through color during replacement)
- ② Possible cause: poor contact between thermal sensor plug and computer board  
Solution: replace the thermal sensor, or strip the copper wire and screw it to the computer motherboard directly (pay attention to the red connection "+" when connecting)

### 2. In the temperature display area, the display temperature greatly exceeds the set temperature, reaching more than 200 degrees, or even more than 250 degrees

- ① Possible cause: the motherboard of computer board is broken  
Solution: replace the computer board motherboard

### 3. Fault code "E1"

- ① Possible cause: the trigger piece on the guide post touches the upper switch and still displays "E1". The switch of the upper position plug is not plugged in properly and is loose  
Solution: clamp the upper switch plug and plug it in again
- ② Possible cause: the upper trigger is pressed to the upper switch, but "E1" is still displayed. Check whether the "R" trigger switch has been broken  
Solution: replace the upper switch
- ③ Possible causes: the upper and lower motors do not move, indicating "E1". The power cord plug of the motor is not tightly connected with the computer motherboard  
Solution: open the rear cover, check the upper and lower motor power cord plug, and plug it in again.
- ④ Possible cause: the upper and lower motors do not move, indicating "E1", and the motor is broken  
Solution: replace the upper and lower machine

### 4. Fault code "E2"

- ① Possible cause: when the upper and lower motors are pressed to half, an alarm will be given and "E2" will be displayed, and the voltage will not be 220V  
Solution: install a 300 Watt, 220V power supply regulator as shown in the figure below, or replace the large capacity 4.5u capacitor for voltage compensation



Figure 15



- ② Possible cause: the upper and lower motors do not move, and "E2" is displayed. The power cord plug of the motor is not tightly connected with the computer motherboard  
Solution: open the rear, check the upper and lower motor power plug, and plug it in again
- ③ Possible causes: press the upper and lower motors to the lower switch position, and display "E2". Check whether the "R" type lower switch has been damaged and broken  
Solution: Replace the lower switch
- ④ Possible causes: The upper and lower motors do not move, indicating "E2", the motor is broken  
Solution: Replace the upper and lower motors

### 5. Fault code "E3"

- ① Possible causes: The guide rail groove is not cleaned and there are impurities such as syrup, Need to clean and add special lubricating oil
- ② Possible causes: The guide rail groove is too tight, it is necessary to loosen the side forcing screw
- ③ Possible causes: Once the rocker contact is in place, the carry switch roller needs to move up the plate, 1~2mm
- ④ Possible causes: The signal line of carry switch is short circuited, or the plug of signal line and computer board are not plugged in properly, so the contact is poor
- ⑤ Possible causes: The carry switch is broken and needs to be replaced

### 6. Fault code "E4"

- ① Possible causes: Rocker arm contact is not in place, out of position switch roller
- ② Possible causes: The signal line of the output switch is short circuited, or the plug of the signal line is not plugged in well with the computer board, resulting in poor contact
- ③ Possible causes: The output switch is broken and needs to be replaced

### 7. Fault code "E51" ,The sealing film is not sealed all the time. The sensitivity of the electric eye is too high and needs to be adjusted,Methods: turn the sensitivity knob clockwise or erase the dust of electric eye

- ① Possible causes: There is too much dust at the luminous place of the power supply bayonet, which causes the red signal light to be on all the time  
Solution:Wipe with a damp, soft cotton cloth to remove dust
- ② Possible causes: The sensitivity of the electric eye is not right  
Solution:To adjust the sensitivity of the power supply, refer to the instruction label on the right side of the machine
- ③ Possible causes: Check whether the power supply has power and check whether it is damaged  
Or the electric eye plug and the computer board motherboard are not plugged tightly

### 8. Fault code "E52" , The sealing film does not seal all the time

- ① Possible causes: The sealing film is not in the bayonet of the electric eye, resulting in the red signal light not on all the time  
Solution:Put the sealing film into the electric eye bayonet
- ② Possible causes: The sensitivity of electric eye is too low and needs to be adjusted  
Solution:Turn the sensitivity knob counterclockwise
- ③ Possible causes: Is there electricity in the electric eye? Is there a mouse biting off the power line  
Or the electric eye plug and the computer board motherboard are not plugged tightly

Figure 16



Figure 17



Figure 18



Adjust the position of the electric eye after closing to make the cursor of the sealing film pass through the luminous place of the electric eye



Figure 19



Figure 20



### ADJUSTMENT METHOD OF ELECTRIC EYE SENSITIVITY

Use the white plastic slotted screwdriver (in the accessory bag) attached with the machine:  
Clockwise rotation weakens the sensitivity of electric eye, while anticlockwise rotation makes the sensitivity of electric eye stronger  
Green light - power light    Red light - signal sensing light

#### 9. The sealing film is not sealed firmly or completely

The paper cup can not be sealed firmly (but the plastic cup can be completely sealed)

Solution: the model of the sealing film is wrong, the sealing film can only seal the plastic cup

The paper cup and plastic cup can not be sealed. (it can be sealed before, but appears after changing a roll of sealing film)

Solution: The new sealing film is installed reversely. Please remove the roll sealing film and install it again

After a period of time, the paper cup and plastic cup are not sealed tightly

Solution: Check whether the upper heating plate is stained with impurities or sintered materials, and clean with warm and wet cloth

#### 10. The sealing film can only be sealed by skipping several patterns

① The sealing film is not in the electric eye bayonet

Solution: Put the sealing film into the electric eye bayonet

② There is too much dust at the luminous place of electric eye bayonet

Solution: Wipe with a damp, soft cotton cloth to remove dust

③ Wrong sensitivity of electric eye

Solution: To adjust the sensitivity of the electric eye, refer to the instruction label on the right side of the machine

#### 11. The sealing film can only be sealed by skipping several patterns

As soon as the socket of the machine is plugged in, the sealing film keeps turning without turning on the machine

#### 12. The machine can't seal automatically, only press the "start" key to seal the cup

① The automatic button is not turned on, and the automatic light is not on

Solution: Press and hold the Auto button for three seconds to turn on the light

② Long needle sensor broken

Solution: Replace long needle sensor

#### 13. The temperature does not rise and the room temperature is always displayed

Heater power line short circuit, please check whether there is an open circuit and connect it

#### 14. There is static electricity when people touch the machine

This is a normal induction motor, with more than ten volts, will not cause harm to human body

① Solution: When the power plug is connected with the ground wire, the induced electricity can be eliminated

② Solution: Screw out the anchor screw of the machine and wrap it with wire. Then connect it to the metal water pipe or stainless steel water bar



### 15. The paper cup was squashed

The machine is debugged with a maximum capacity of 500cc cup. When using a large capacity cup, it is necessary to adjust the height of the cup holder so that when the cup enters the machine, the cup will leave the cup holder. If the cup holder is not adjusted and a 650-700cc cup is used, the cup will be crushed.



Figure 21



Figure 22

### 16. The paper cup can be sealed well, but the plastic cup is not

- ① The temperature is too low

Solution: When sealing the paper cup, the temperature is relatively low, generally only 120 ~ 175 °C is needed, and 175 ~ 190 °C is required for the plastic cup, so it is necessary to increase the temperature to the applicable temperature of the plastic cup.

- ② Cup sealer (ring) not taken out

Solution: Generally, the caliber of paper cup and plastic cup are different. The caliber of paper cup is smaller than that of plastic cup. Just after sealing the paper cup, when sealing the plastic cup again, the paper cup sealer (ring) needs to be taken out from the access platform, otherwise the plastic cup will not be sealed tightly.

### 17. The long wire of long needle trigger switch does not rebound

The switch was stuck due to the long needle trigger switch which was not cleaned for a long time.

Solution: go to the local hardware store to buy "derusting lubricant" to spray liquid and remove sugar.

### 18. Shaking in and out of working platform

Lead to the need to add guide rail oil (three parts: stainless steel working platform guide groove, cup supporting beam, upper and lower guide pillars, bearing groove).

In particular, the upper and lower guide pillars of the two cup holders under the platform must be lubricated.

Note: never use sewing machine oil.

### 19. When the cup is put in, the sealing film will not roll, or it will make a sound of "sticking"

- ① Incorrect installation of sealing film

Solution: Scissors seal film, re-install the machine top schematic diagram installation, or check the manual installation.

- ② Scroll the list to make "card" sound

Solution: Film winding motor damaged, replace the film winding motor.

### 20. The logo is not in the seal film

Due to the difference in the mark interval of film materials produced by various manufacturers on the market, the seal film pattern may deviate. At this time, it can be adjusted through the following figure:

- (1) As shown in Fig. 23, there is a left-right deviation of the sealing film when the cup is out of the cup, which can be adjusted by adjusting the position of the electric eye (Fig. 24 is adjusted upward when it is left).

- (2) As shown in Figure 25, the offset of the pattern can be adjusted by adjusting the position of the plastic locating ring (use the hexagon wrench in the accessory bag).



Figure 23



Figure 24



Figure 25



Figure 26



## COMMON ERRORS AND OPERATIONS IN USER USE

1、 The spring position of the right film rolling rod (driven rod) is wrong or not compressed. (Fig. 27, 28, 29, 30)

Figure 27



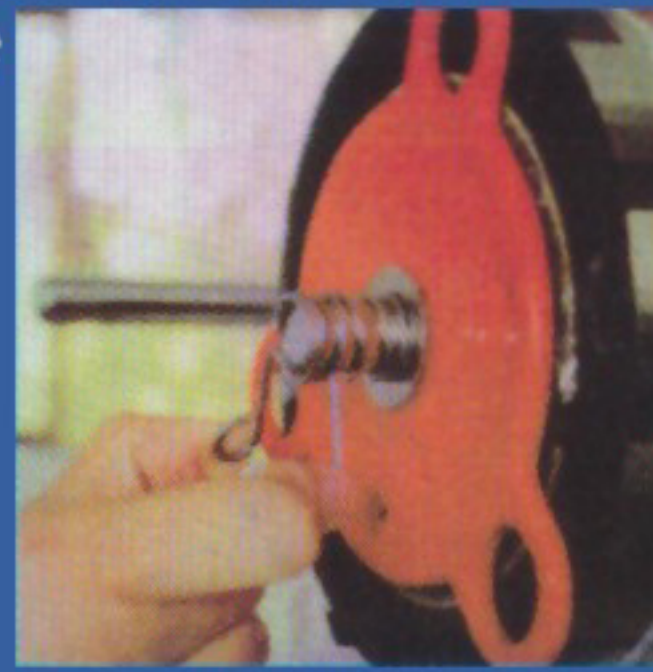
correct

Figure 28



correct

Figure 29



correct

Figure 30



error

2、 The sealing film is not placed in the U-shaped hole of the electric eye

Figure 31



correct

Figure 32



correct

Figure 33



correct

Figure 34



error

3、 The cursor (small black square) on the sealing film does not pass through the light emitting position of the electric eye. (Fig. 33, 34)

4、 The sealing film does not pass through the film lifting rod (as shown in Fig. 35 and 36)

Figure 35



correct

Figure 36



error

5、 The plastic locating ring on the left roll is considered to be moving

6、 The gap of the splint of the waste film drum is not stuck into the screw of the positioning ring of the driving rod (as shown in Fig. 37 and 38)

Figure 37



correct

Figure 38



error