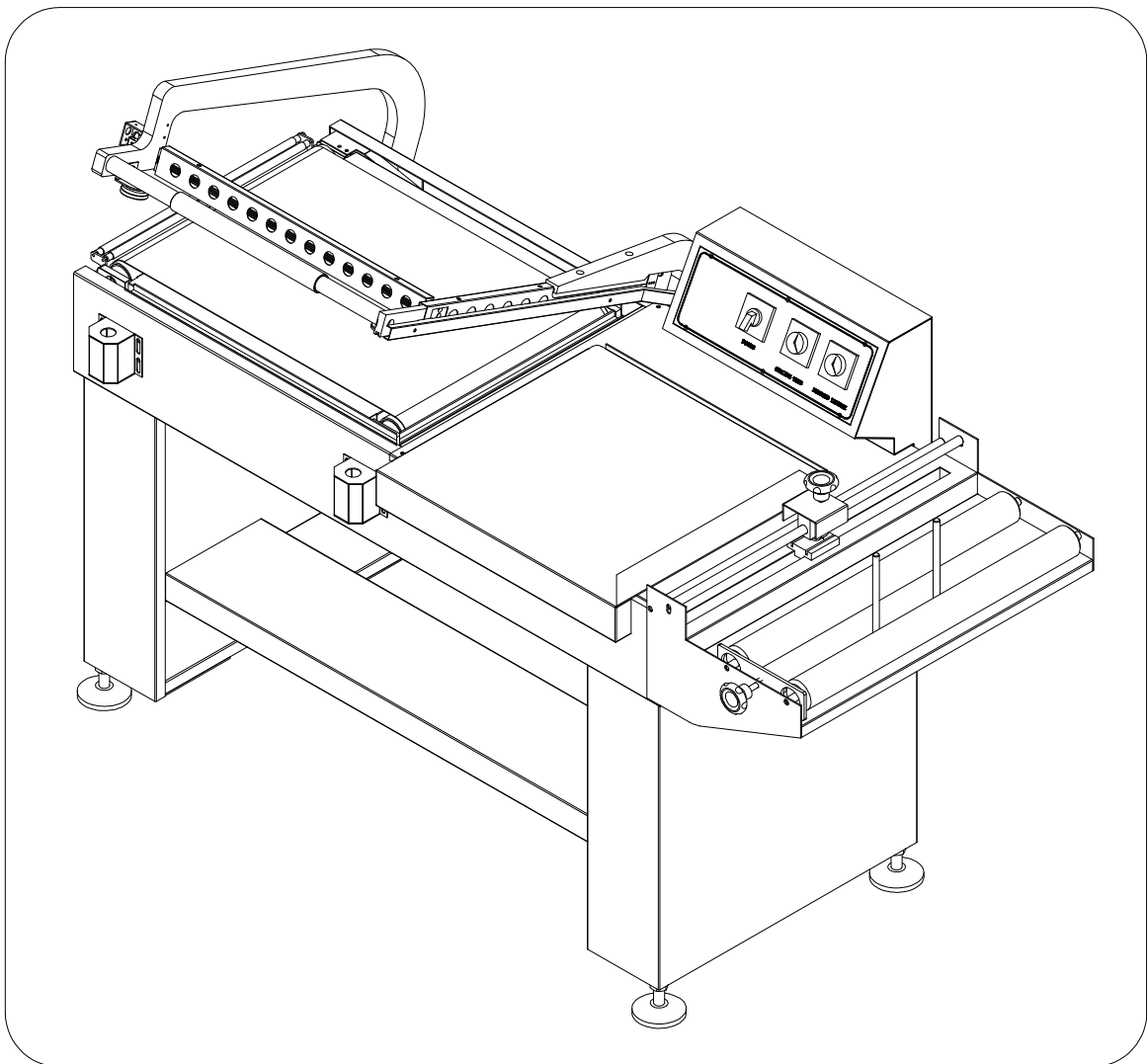


FL series manual L sealer

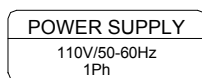
Use and maintenance manual

FL-5545T/FL-7555T

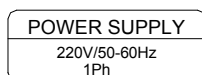


※Please read this manual carefully before operation
※Sorry for changing technical without else notice

Please notice as below sign when use this machine



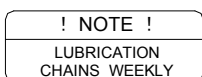
1PH 110V 50/60Hz



1PH 220V 50/60Hz



HOT



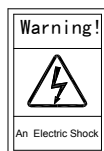
Lubrication chains weekly



Conveyor Direction



It must be connected with the ground



Non professional maintain doesn't open the door



It's dangerous to make your hands hurt or cut

Note:

2 voltages are available for this machine, please connect the power supply as on faceplate.

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ONE、 Foreword

1、 Summarize

Thanks to buy our product, this machine are safe, practic, effect sealing packager.

2、 Carefully for manual

- A. Please read carefully this manual before using machine.
- B. Please use machine after on top of machine knowledge.
- C. Please keep this manual, and read it at any moment.
- D. Please give the manual to end user.
- E. Due to ceaseless improve and perfect machine, our company reserve right to amend machine and manual.
- F. If have good suggestion for this machine or manual, please connect with our company.

3、 Safety notice

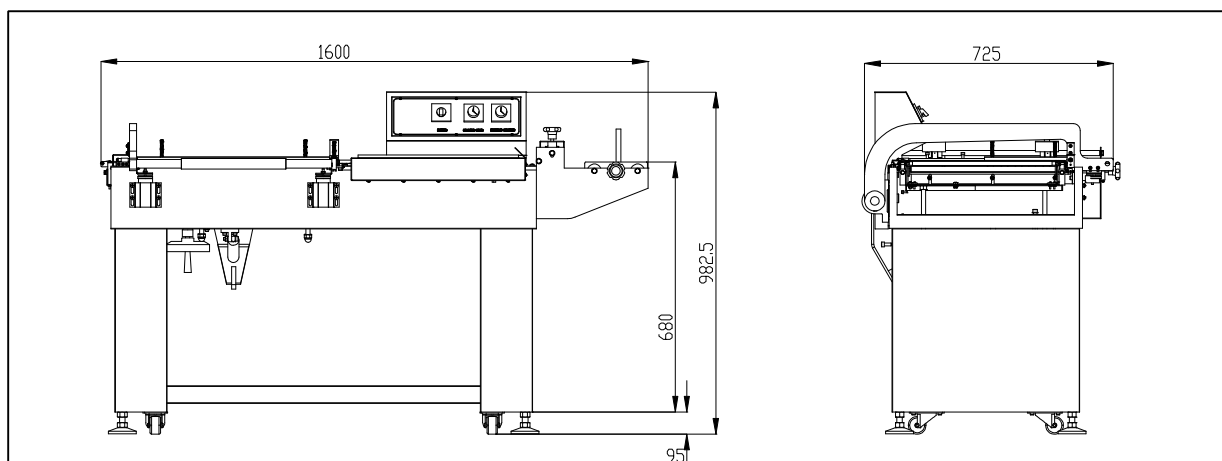
- A. Must use considerable breaker and power wire for this machine. If use big capacity breaker or small power wire, that make circuitry or parts damager.
- B. Please sure liquid would not leap out when packing liquid product. If not , damager would be made to the machine and the operator would possibly get an electric shock.
- C. Don't use the machine in a very moist and humid environment, or a place full of a lot of vapor.
- D. Don't use the machine in a place which full of dust.

- E. Don't put your hand on the parts for sealing.
- F. Don't put any metal article on part for sealing avoid damage for sealing blade.
- G. The sealing time should be of 0.8-1.5s in general, the sealing blade would be damaged if the sealing time be set too long.
- H. The sealing blade, Teflon belt, neoprene rubber is easy to be worn after some time, so please prepare some damageable parts like these and examine and repair the machine periodically.
- I. The power of the machine should be turn off first when you want to replace the spare parts and please do it according to the right procedures.

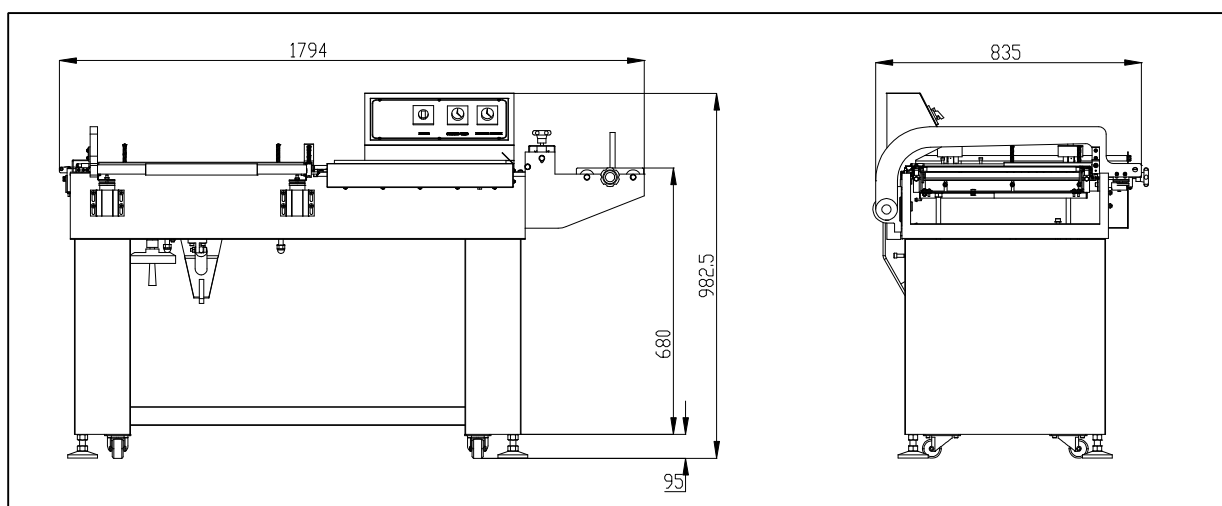
4、 features of machine

- A. This machine is widely used for the packaging application of these industries: food, toy, hardware, cosmetic, medicine, daily commodity, books, bamboo products, wooden products
- B. Suit for PVC、 POF etc;
- C. The sealing blade is made of alloy, stick proof and high temperature –proof, with out carbonization and smoking when sealing.
- D. The sealing time is easy to be adjusted based on the thickness of the film;
- E. The product to be packaged is unloaded automatically by the conveying belt and the conveying time is adjustable;
- F. Sealing and shrinking for one time, safe and reliable, easy to operate, the part sealed of the film is firm and looks well;
- G. the machine can working longtime continuum, which meet for large output

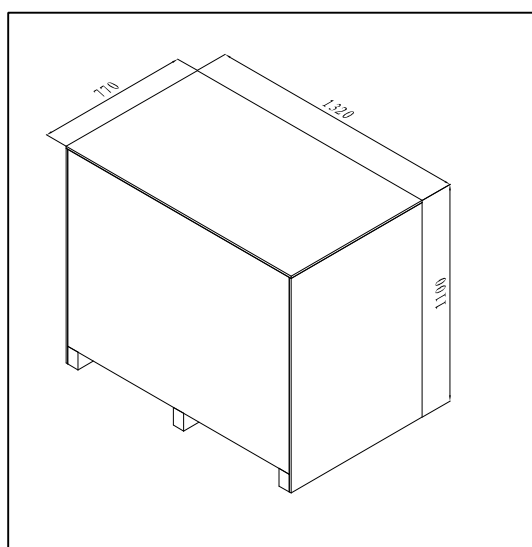
TWO、 Machine dimension and wooden carton dimension



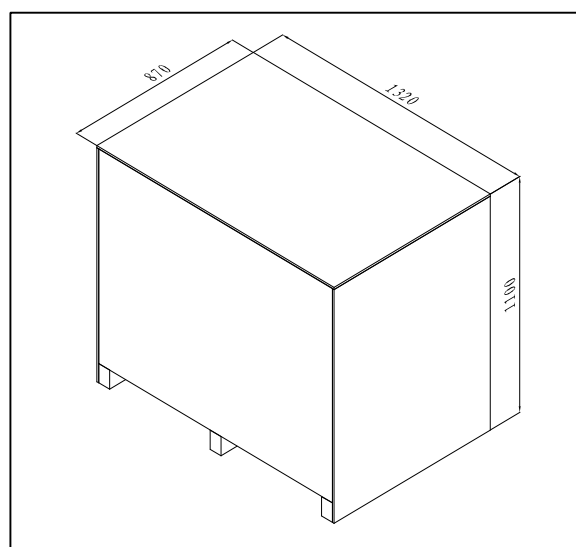
FL-5545T machine dimension



FL-7555T machine dimension

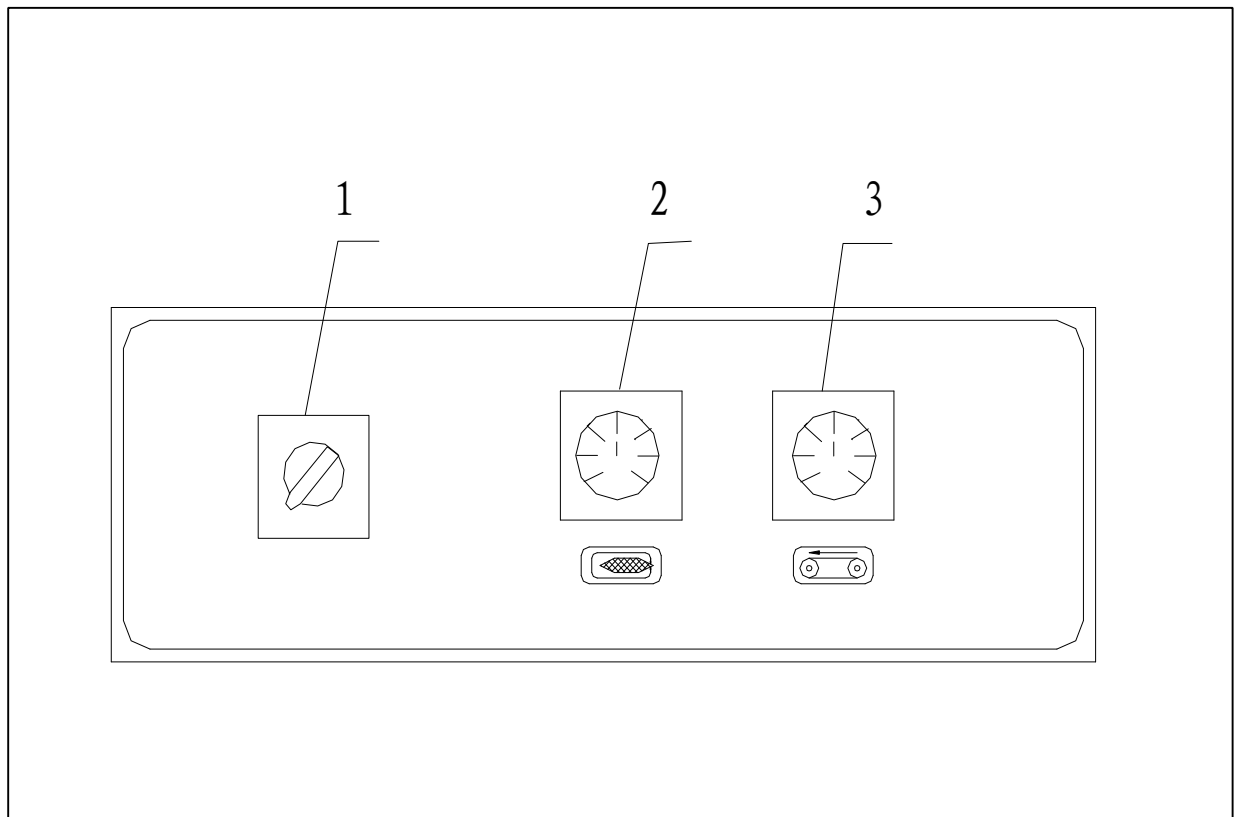


FL-5545T be packed dimension



FL-7555T be packed dimension

THREE、 Machine panel and each button name and function



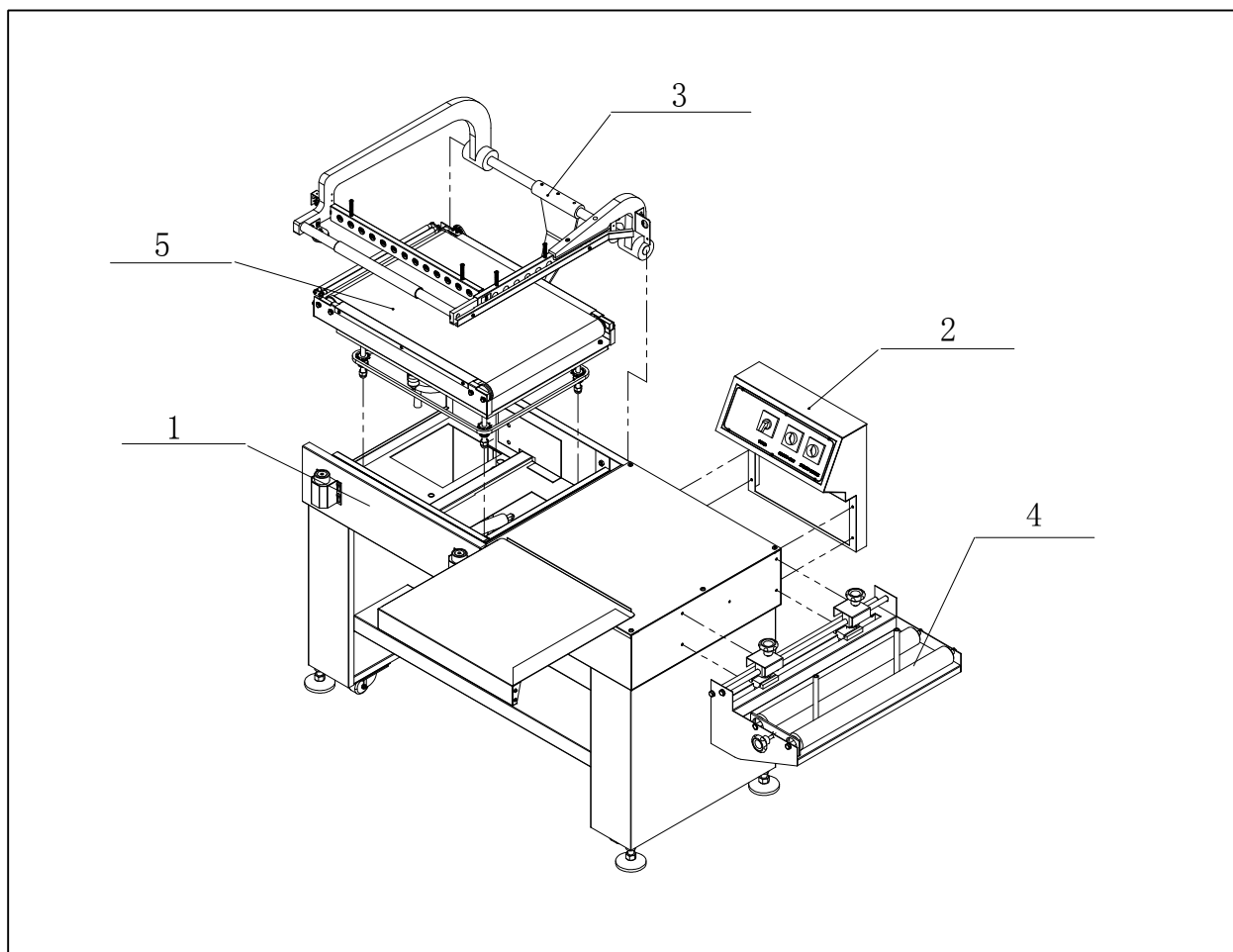
1、 power switch: on or off the total power;

2、 relay: set sealing knife heating time;

3、 relay: set convey belt running time;

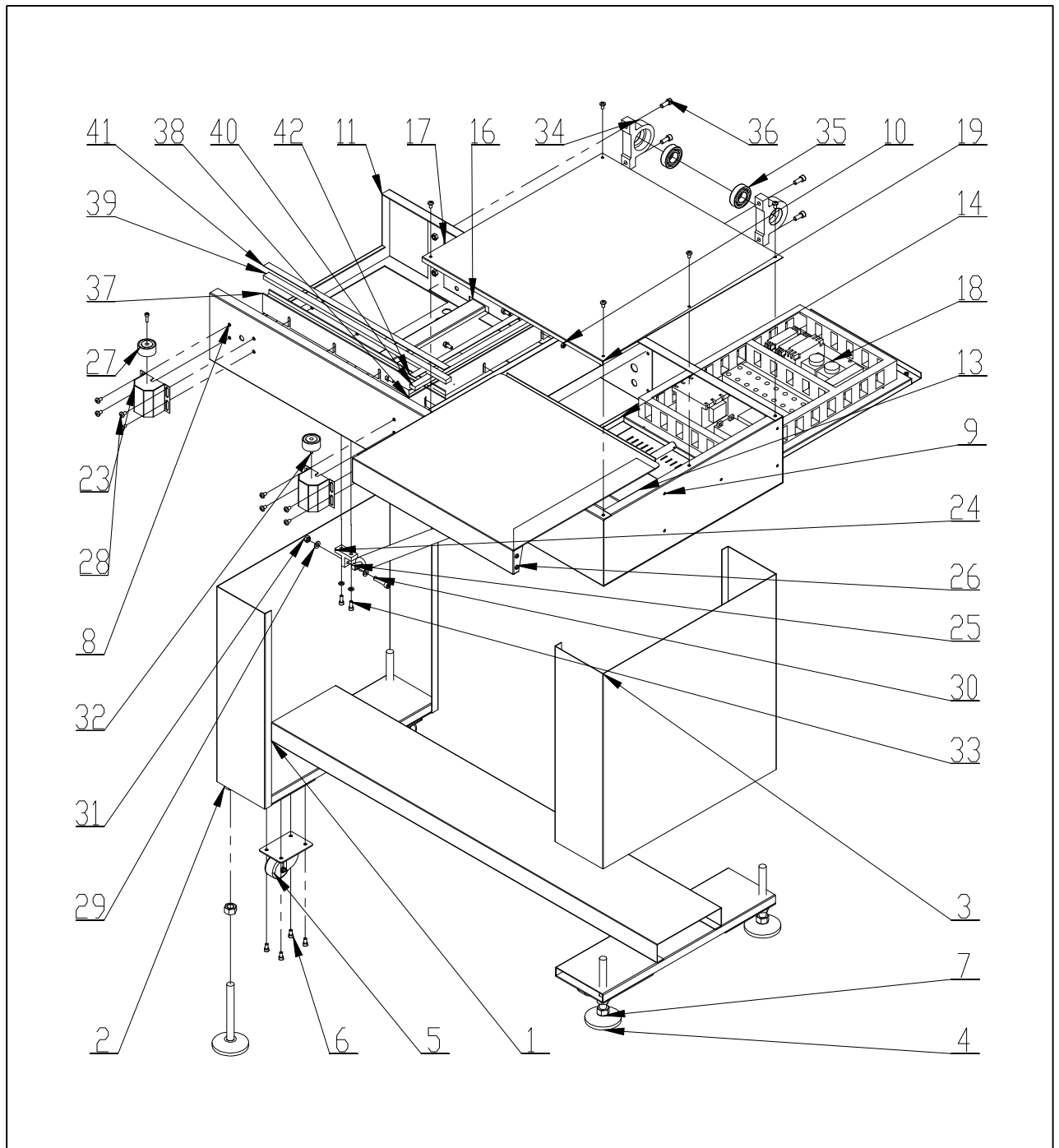
FOUR、 Machine parts illuminate drawing

1、 machine total install drawing



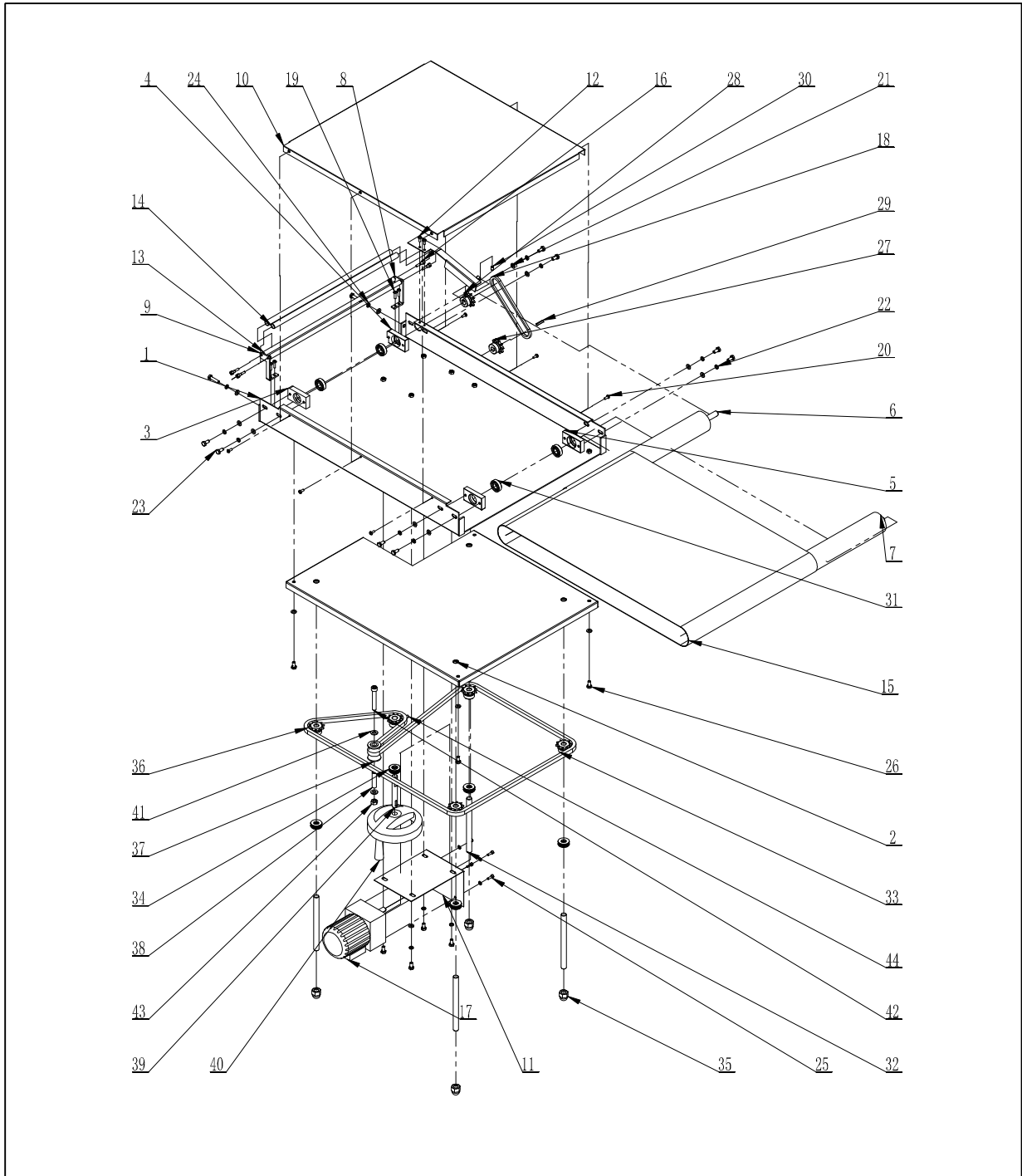
No.	name	Qua.
1	Machine frame	1
2	Electrical connect system	1
3	Sealing system	1
4	Film frame system	1
5	Convey system	1

2、 machine frame parts drawing



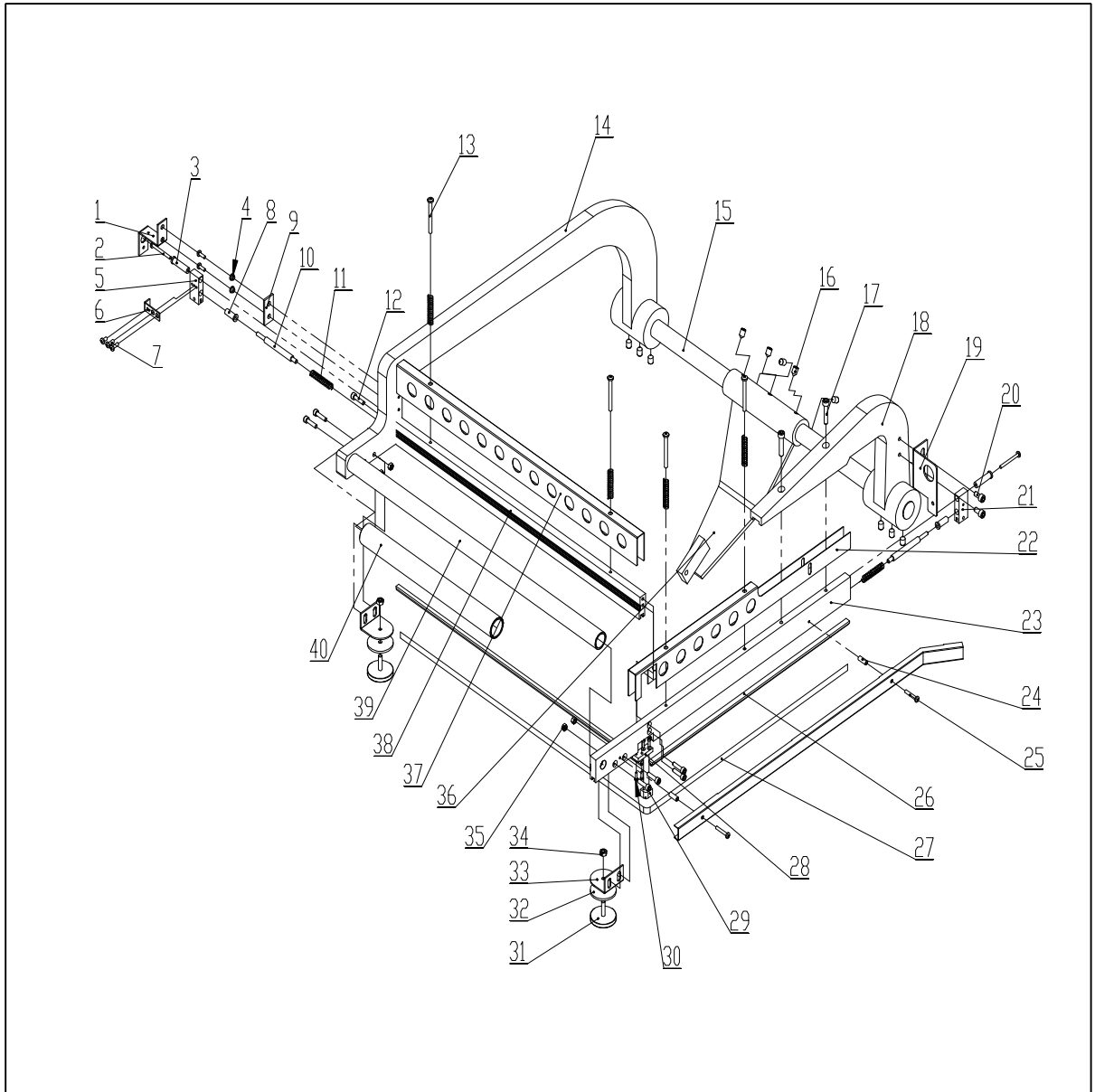
No.	Drawing No.	name	Qua.
1	1-04	undergird board	1
2	1-03	Jointing foot board	2
3	1-02	Lower frame	2
4	WGBZ001	Foot	4
5	WGBZ002	Foot wheel	4
6	WGBZ003	Bolt M6X12	16
7	WGBZ004	Nut M6	4
8	1-01	Upper frame	1
9	1-06	Right sealing board	1
10	1-07	Middle tendon board	1
11	1-05	Left sealing board	1
12	1-09	Side tendon board	1
13	1-01-02	Support board of working table	1
14	4-L	Runner of control box	1
15	4-R	Runner of distributing board	1
16	1-12	Strengthen board	1
17	1-01-01	Strengthen board behind upper machine frame	1
18	8	distributing board	1
19	02	Cover of electric appliance	1
20	1-08	Hand wheel fix board	1
21	1-10	Steel tube 1	1
22	1-11	Steel tube 1	1
23	3-23	Switch seat	2
24	3-16	Air cylinder bracket	1
25	WGBZ005	Air cylinder	1
26	01	Working board	1
27	3. 3-4	magnet	2
28	WGBZ006	Bolt M8X10	13
29	WGBZ007	washer	2
30	WGBZ008	Bolt M6X35	1
31	WGBZ009	nut	1
32	WGBZ010	Bolt M5X16	2
33	WGBZ011	Hexangular screw M6X16+washer	9
34	1-13	Bearing base	2
35	WGBZ012	bearing6205	2
36	WGBZ013	Bolt M8X20	5
37	3-17-1	Slot of rubber 1	1
38	3-17-2	Slot of rubber 2	1
39	WGBZ014	Rubber 1	1
40	WGBZ015	rubber2	1
41	WGBZ016	Teflon belt 1	1
42	WGBZ017	Teflon belt 2	1

3、convey parts drawing



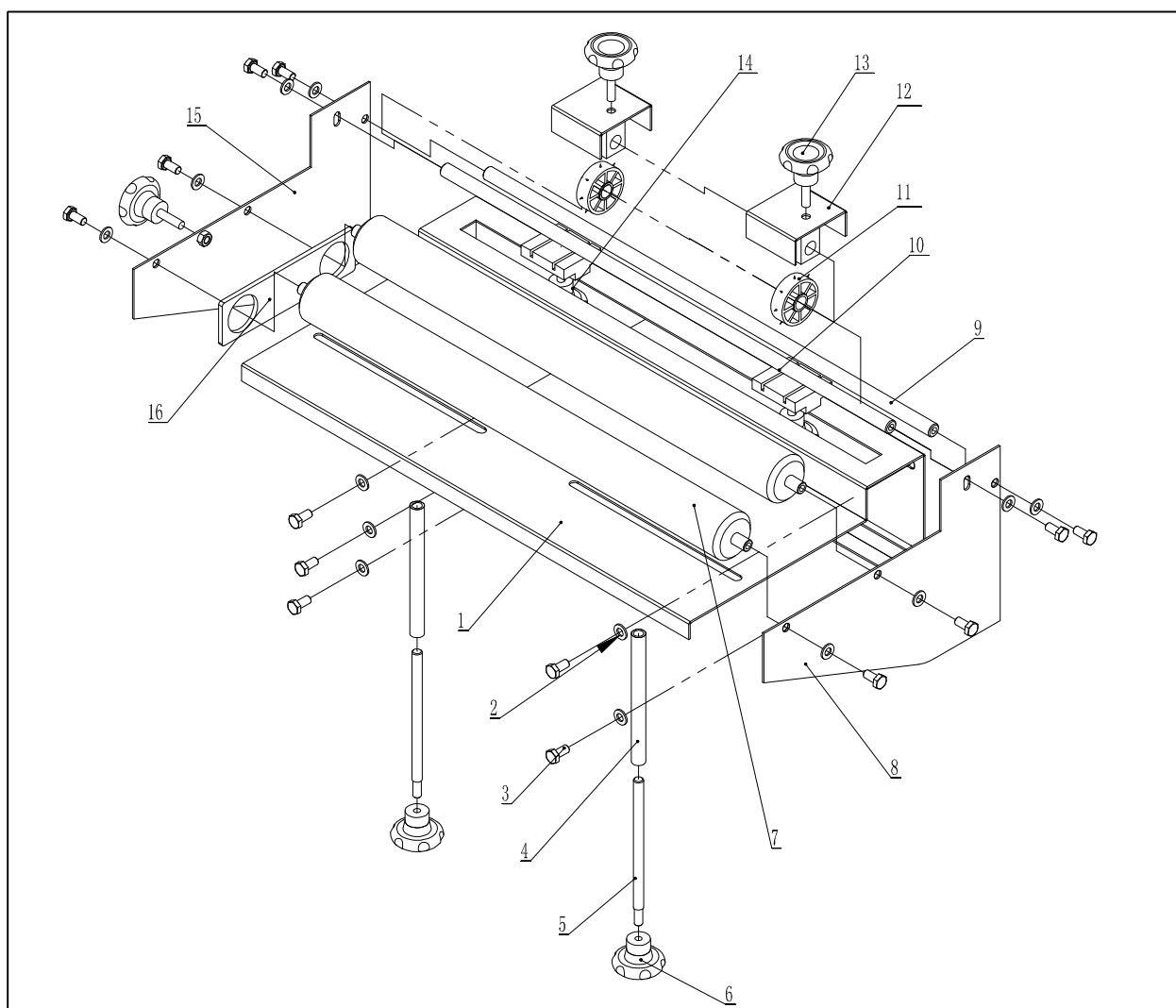
No.	Drawing no.	name	Qua.
1	2-1	Rise & fall stand	1
2	2-2	stator	1
3	2-9	Right stator	1
4	2-10	Left stator	1
5	2-10A	stator	2
6	2. 2	Shaft of idler wheel2	1
7	2. 1	Shaft of idler wheel 1	1
8	2-13-L	Left small stand	1
9	2-13-R	Right small stand	1
10	2-3	Block board	1
11	2-6	Motor install board	1
12	2-17	pressing plate	1
13	2-15	Extended roller	2
14	2-16	Extended roller pastern cover	2
15	WGBZ018	Convey belt	1
16	2-19	Extended roller support bar	4
17	WGBZ019	motor	1
18	WGBZ020	chain	1
19	WGBZ021	boltM4X16	4
20	WGBZ022	boltM4X10	8
21	WGBZ023	Washer 6	16
22	WGBZ024	Spring washer6	12
23	WGBZ025	boltM6X12	12
24	WGBZ026	Hexangular bolt +spring washer+ washer M6X25	2
25	WGBZ027	Hexangular bolt +washerM4X12	4
26	WGBZ028	Hexangular bolt +washerM6X12	4
27	WGBZ029	Chain wheel	1
28	WGBZ030	Chain wheel	2
29	WGBZ031	Connect block	1
30	WGBZ032	boltM6X10	2
31	WGBZ033	Bearing 6001	4
32	2-8	screw	4
33	WGBZ034	Chain wheel	4
34	WGBZ035	Bearing 51101	5
35	WGBZ036	nutM12	4
36	WGBZ037	Adjusted chain	1
37	2-11	Tightening wheel	1
38	2-12	Tightening wheel axle	1
39	2-18	Hand wheel axle	1
40	WGBZ038	Hand wheel	1
41	WGBZ039	washer	2

4、 sealing system drawing



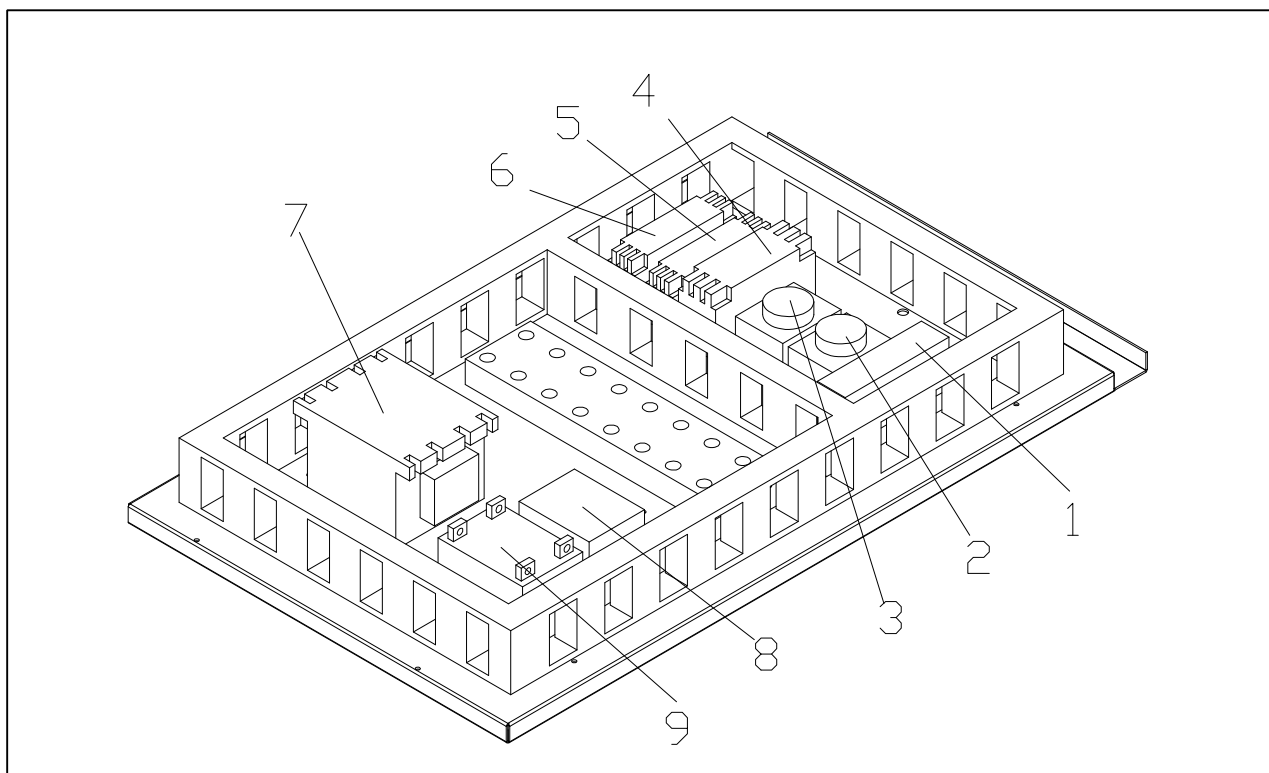
No.	Drawing no.	name	Qua.
1	3-3	Switch stand 1	1
2	WGBZ043	Cross bolt M4X10	2
3	3-5A	Insulated cover 2	2
4	3-3A	Separate electrical cover	2
5	3-6	Switch stand 2	2
6	3-3B	Switch stand 4	2
7	WGBZ044	Cross bolt cM4X12	6
8	3-5	Insulated cover	2
9	3-4	washer	1
10	3-7	Tension scabbard	2
11	WGBZ045	spring	6
12	WGBZ046	Cross bolt M5X20	10
13	WGBZ047	Cross bolt M5X40	4
14	3-1	Left stand on sealing box	1
15	3-15	Movable shaft	1
16	WGBZ048	Fixing bolt	11
17	WGBZ049	Hexangular column bolt	2
18	3-2	right stand on sealing box	1
19	3-8	Switch stand 3	1
20	WGBZ060	Hexangular column bolt	2
21	3-6A	Switch stand 2	1
22	3-13	Cover of sealing slot 2	1
23	3-12	Upper sealing slot 2	1
24	3-22	Insulated cover	2
25	WGBZ061	Cross bolt M4X20	2
26	WGBZ062	sealing slot	2
27	WGBZ063	Sealing blade	1
28	3-21	Board of fixing corner	1
29	3-20	fixing corner	1
30	WGBZ064	Cross bolt M3X10	4
31	3. 2-2	Upper absorb iron	2
32	3. 2-3	Transition washer	2
33	3. 2-1	Fixing corner iron	2
34	WGBZ065	nutM6	2
35	WGBZ066	nutM5	4
36	3. 1	Running board	1
37	3-11	Cover of sealing slot1	1
38	3-10	Upper sealing slo1	1
39	3-9	Hand bar roller	1
40	WGBZ067	Protective cover	1

5、 send film system



No.	Drawing no.	name	Qua.
1	4-01	Fixing board	1
2	WGBZ068	Bolt M8X16	13
3	WGBZ069	washer	13
4	WGBZ070	Pastern cover	2
5	4-07	shaft	2
6	WGBZ071	Club handle M8 inside tooth	2
7	4-10	idler wheel	2
8	4-03	Side board 2	1
9	4-06	Stay bar	2
10	4-8	Pressing plate	2
11	4-10	idler wheel	2
12	4-9	Movable orientation plate	2
13	WGBZ072	Club handle M8X30out side tooth	3
14	4-02	Side board 1	1
15	4-04	Adjusted board	1

6、 distribution panel parts diagram



No.	code name	Name
1	C1	The starting capacitance of the transporting motor
2	K1	220V middle relay
3	K2	24Vmiddle relay
4	KM1	Sealing blade contactor
5	QF1	Sealing blade loop breaker
6	QF2	Control loop breaker
7	T1	Sealing blade transformer
8	T2	Magnetic transformer
9	V1	Magnetic rectifier bridge

FIVE、 machine technology parameter

model	FL-5545T	FL-7555T
Power supply	1 phase 220V 50Hz 1 phase 110V 60Hz	1 phase 220V 50Hz 1 phase 110V 60Hz
power	1.2kw	1.5kw
Max sealing size	L550*W450	L750*W550
Machine size	L1400*W700*H1000	L1830*W780*H1000
weight	110kg	135kg

SIX、 machine installation

A. Remove four side boards after open upper cover of the crate;

B. Carry out the main machine, place the machine on the place ground steadily;

C. Unpack the protective film wrapping on the machine.;

D. Put up one side of the machine bottom,

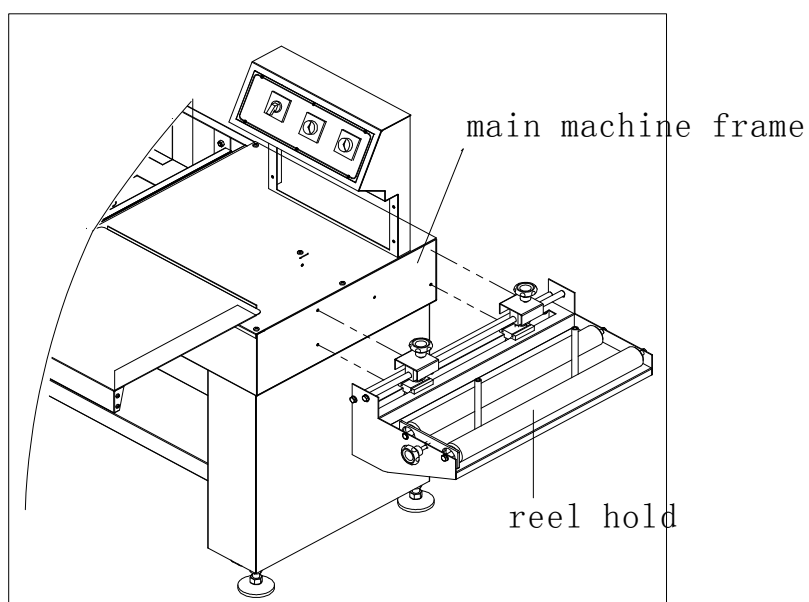
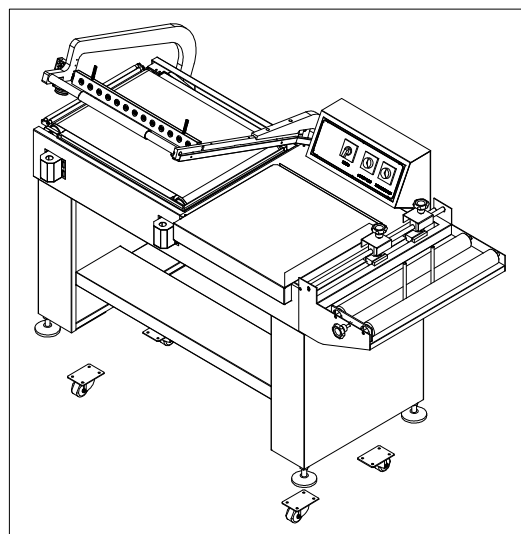
install two foot wheel of this side; then put up other side again, install other two foot wheel;

E. Fasten the four foot bolts at the bottom, the machine can move only by the wheels;

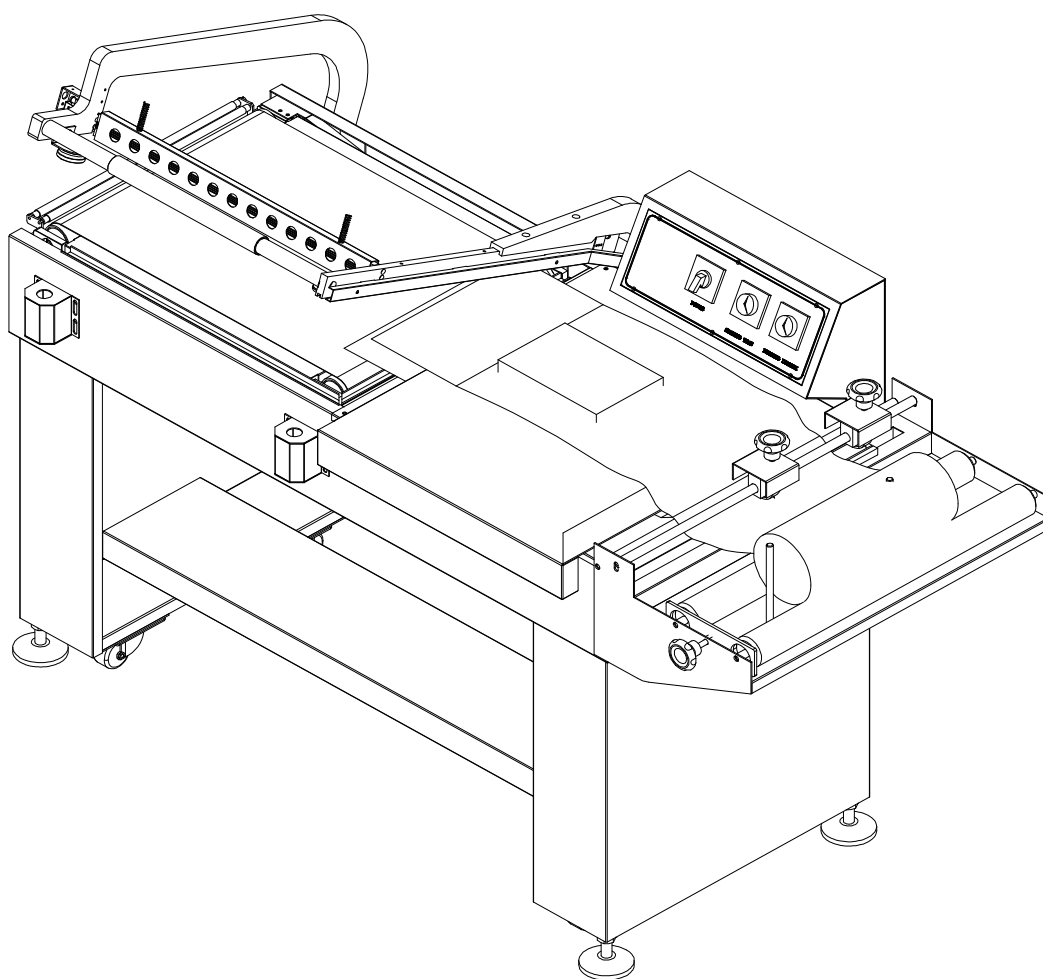
F. Take out of the reel holder, then fix to side of the machine with the bolt;

G. according to volt from nameplate, and connect with wire,

remark: with fail connect earth.



SEVEN、 machine operation method



Install film drawing

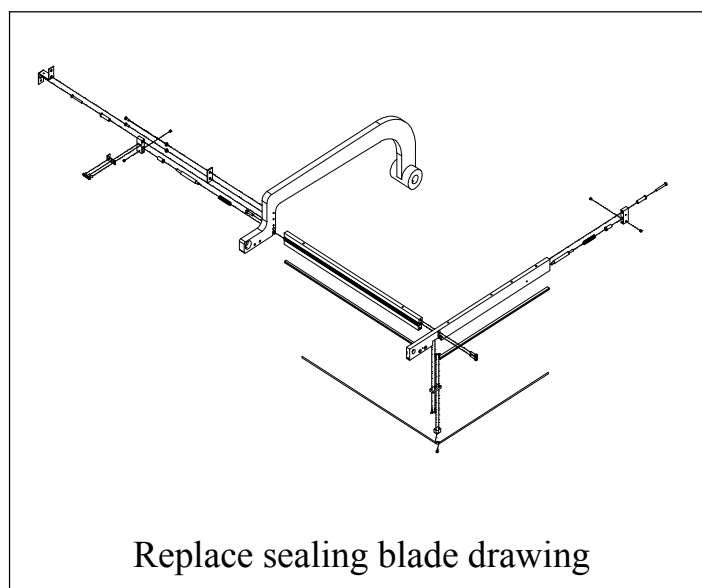
- A. Set the sealing time according to the thickness and characteristics of the shrink film 0.5-1.5s in general (the appropriate sealing time leads to the film to be cut off completely and a good sealing effect. If the sealing time is too short, the film can not be cut off, or the sealing blade, blade slot and the Teflon belt would be easily damaged if the sealing time to be set too long);
- B. Usually, set the sealing time a litter longer when turn the power on at the beginning due to there is no any accumulation of the heat on the blade. Set the

- sealing time a little shorter than beginning due to the accumulation of the heat on the blade;
- C. Set the transporting time according to the size of the product to be packed and the specific requirements for packing;
 - D. Place the film reel there between the two poles on the reel holder, (make the open side of the film toward to the operator), position the two poles and fasten them;
 - E. Thread the film through the perforator, separate the two layers, get it surround the working table;
 - F. Adjust the height of the product parallelizing the center line of the products to be packed with the sealing blade;
 - G. Put the film to sealing area, sealing first time;
 - H. Place the product on the working table covered by the upper sheet of the film, stretching the film and the product to the sealing area in the left;
 - I. Keep a distance of 1/2 height of the product between the product and sealing blade in order to have enough film for shrinking;
 - J. Press down the sealing upper frame, machine is working;
 - K. Upper frame auto go up after sealing. then convey working , and put the product to shrink system.◦

EIGHT、 machine maintenance

- A. Clean the working table and the transporting belt after the use every day;
- B. Clean the sealing blade periodically .Notice: clean the sealing blade by a piece of dry cotton with the release agent, Don 't use any metal article scratch the sealing blade.
- C. The movable parts(such as transmitting chains, bearing base) needs to be oiled with lubricant often;
- D. The sealing blade, Teflon belt, rubber must be kept well. If the sealing blade or the Teflon is worn or damaged, replace it with a new one soon
- E. Turn the power off before repairing let professional to do it;
- F. The procedures of replacing the sealing blade:

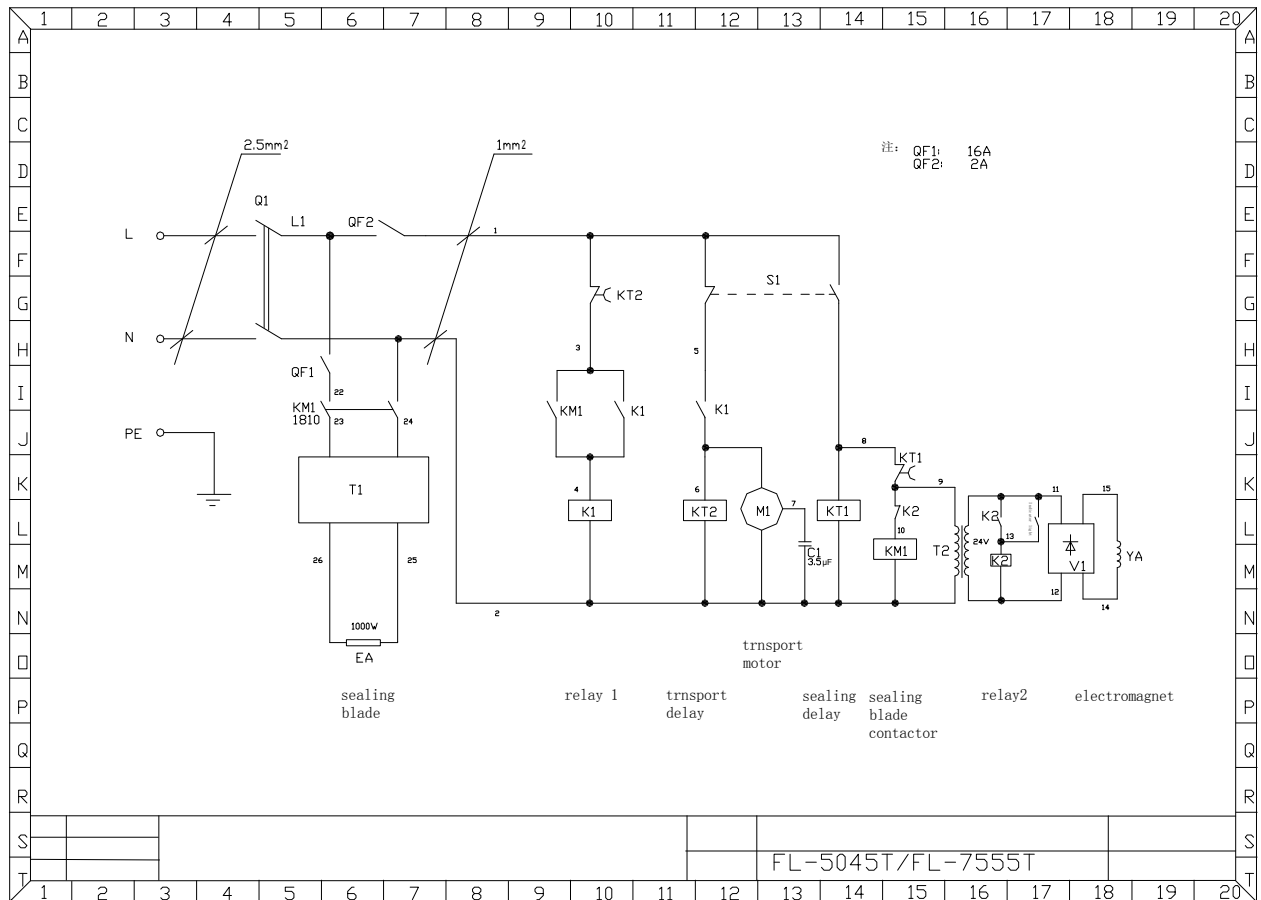
- 1. turn the machine power off;
- 2. make the curl part of the two ands of the sealing blade straight (notice: please do it lightly in order to avoid the rupture of the nylon cover of the blade clamp);



- 3. unfasten the screws on the tow ands of the blade clamp, take the worn sealing blade out;
- 4. put one and of the new sealing blade into the slot of the blade clamp, 5mm left outside of the clamp, then tighten the screws and curl the extended blade outside the clamp;

5. put the new sealing blade into the ceramic blade slot lightly, then put the other end of the sealing blade into the slot of the other blade clamp;
6. straighten the sealing blade , fasten the screws and curl the two ends of the sealing blades;
7. end.

NINE、 machine circuit diagram



ELEVEN、troubleshooting

trouble	cause	solution
Sealing blade not heating	Breaker off	Check reason and put it on
	Sealing blade damaged	Replace new one
	Transformer damaged	Test the output of the transformer when sealing, If no volt output, please replace new one
	The device protect the sealing blade from worn was not set well	Keep distance 3-5mm for the screws and avoid sealing blade worn bolt
Sealing blade can be heated, but can not cut off film	Partial damage for the sealing blade	Replace new one
	Something unknown on the sealing blade	Clean the sealing blade by a piece of dry cotton and the release agent
	Damaged for Teflon belt	Replace new one
	Damaged for rubber	Replace new one
	The bolt of the fixing sealing slot be unfasten, leading to sealing slot uneven	Level the sealing slot and fasten screws
Convey system do not work	Transport time is set to be 0	Adjust transport time
	Breaker off	Put it on
	Transport device can not move	Check chain of the transport system
Shake of the convey belt	The transport belt is too tight	Adjust it again

ELEVEN、 packing list

No.	name	spec	Qua.
1	Machine		1pc
2	breaker	C32N1P16A	1pc
3	breaker	C32N1P2A	1pc
4	manual		1pc
5	Teflon belt		1set
6	Sealing blade		1set
7	Hexangular screw	M6	1pc
8	Hexangular screw	M4	1pc