
AUTOMATIC L SEALING PACKAGER

OPERATION INSTRUCTION

GPL-4535



- ※ Before using this machine, please read this manual instruction carefully!
- ※ Subject to the changing in technology, we will not give additional advice for any alternation in this manual.

Please be ware the following sign when operating this machine



**The power supply of this machine
1 phase 110V 50/60Hz**



**The power supply of this machine is
1 phase 220V 50/60Hz**



Indicate that the direction of conveyer



Must be connected with earth.



**Don't open it without the permission of professional
engineer.**



Dangers in possible cutting or burning operator's hand.

AUTOMATIC L SEALER

MANUAL INSTRUCTION

We are grateful for you choosing our products; here in this manual, we will provide you the correct operation to use this machine and other instruction for maintenance.

Please operate the machine after your careful reading from foreword till to last summary of this manual instruction.

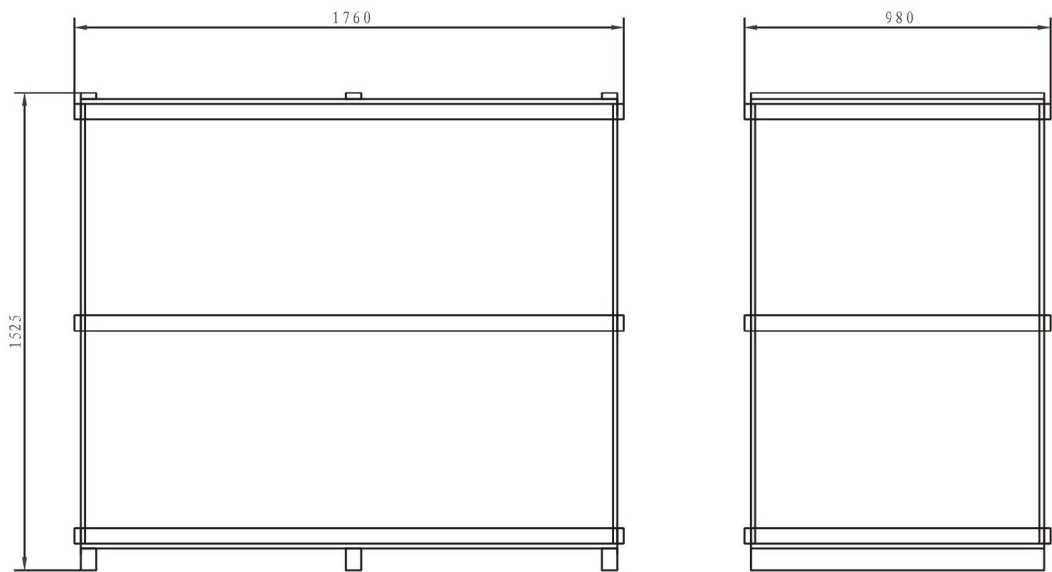
ATTENTION IN USING THIS MACHINE

1. The engineer who responsible for using this machine, please keep it in best situation to operate at any time.
2. Please shut off the power and air-pressure source regularly and to clean the machine after used the machine.
3. Don't put any tools or object inside or on the top of the machine.
4. Please shut off the power and air-pressure source regularly and to clean the machine after inspected the machine.

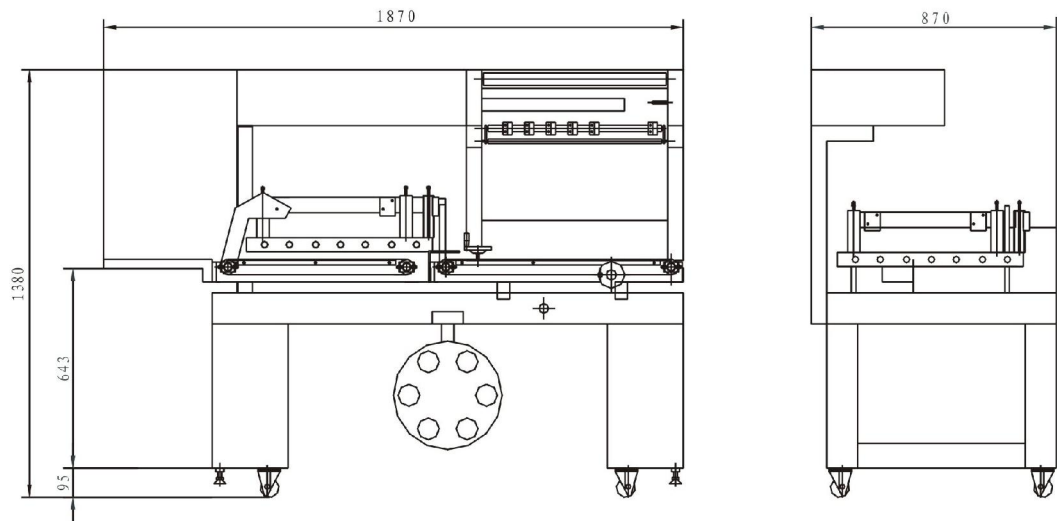
CATALOGUE

1. Machine's dimension and out size of its packing.
2. Machine's panel, each button's name and its function.
3. Spare parts sketch map.
4. Running preparation.
5. Processed material fitting.
6. Running order
7. Reclaiming process
8. Safety device
9. Maintenance
10. Drawing of electrical circuit
11. Attention when the machine is running
12. Trouble shooting
13. Packing list

1. MACHINE’S DIMENSION AND OUT SIZE OF ITS PACKING



GPL-4535wooden packing size

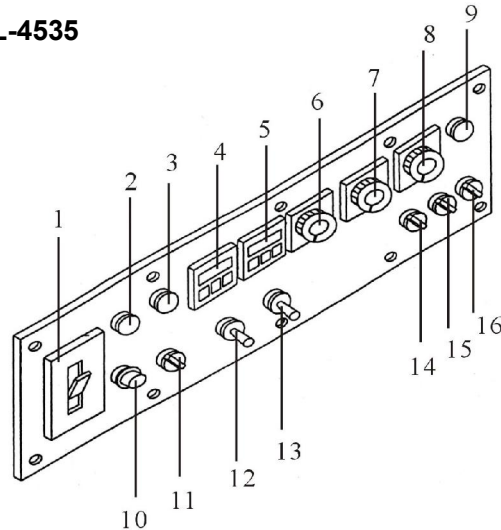


GPL-4535exterior dimension

1. Machine's dimension	L1600×W845×H137mm
2. the upper height of conveyor belt	800+70mm
3. Seal size	W450×L500mm
4. conveying speed	In feed conveyor belt 21.3M/Min Out feed conveyor belt 20.0M/Min
5. The speed of film rolling out	17.6m/min
6. The speed of film towing out	19.4m/min
7. Sealing temperature	The sealing temperature might be different caused by around environment according to different materials
8. Power supply	Single phase AC 200/220V 4P 50/60 Hz
	(1) In-feed conveyer motor 60W
	(2) Out-feed conveyer motor 60W
	(3) Film providing motor 25W (with brake)
	(4) Film clamping motor 40W (with brake)
	(5) Film reclaiming motor 15W
	(6) Heater Horizontal 450W Vertical 550W
9. Air source	5 Kg/cm ² 37NL/Min
10. Sealing time	Normally in one second, but it can be adjusted according to different package
11. Suitable Film	PE PVC POF

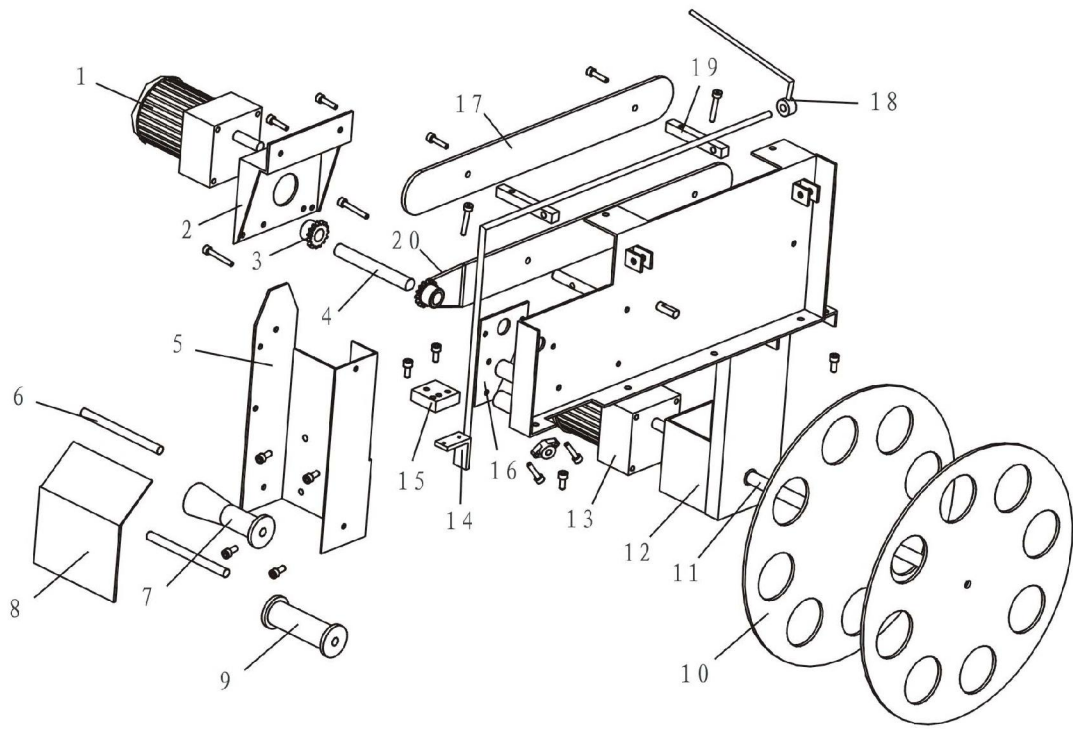
2. Machine's panel, each button's name and its function

The panel of **GPL-4535**

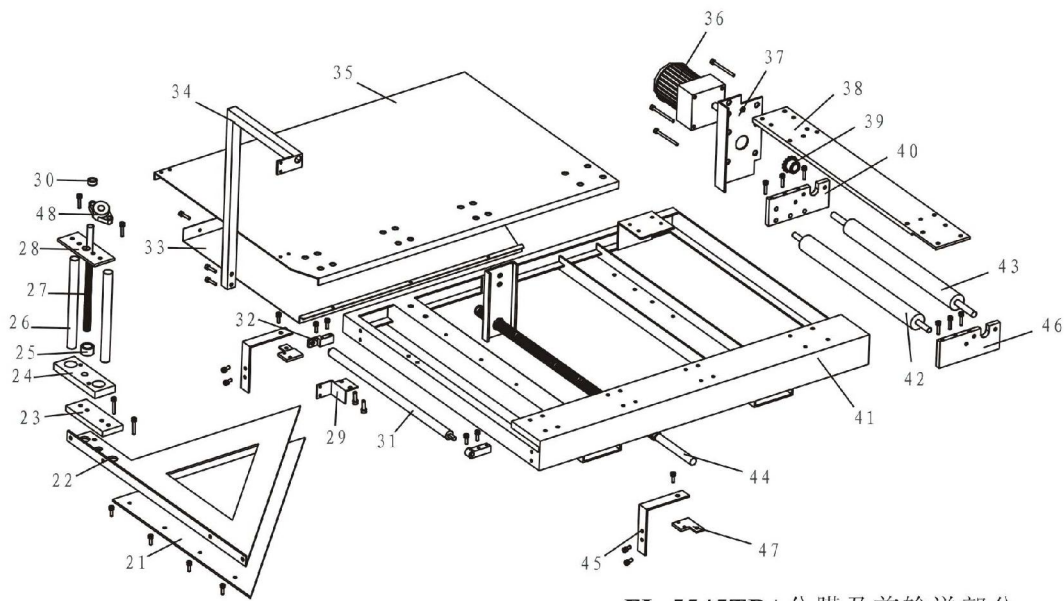


1. The switch of power supply	Control the general power of machine
2. Power indication light	Indicate the machine is connected with power supply
3. Operation indication light	Indicate that the machine is on working
4. Temperature controller of horizontal sealing	Preset the temperature of horizontal sealing blade
5. Temperature controller of vertical sealing	Preset the temperature of vertical sealing blade
6. Sealing time	Preset the sealing time
7. Advance	Control to leave remainder film before sealing as suitable distance for shrinking
8. Conveyor stop	Control to leave remainder film after sealing as suitable distance for shrinking.
9. Manual sealing	It can select to seal by manual operation
10. Start and reset button.	Restart whole running and reset the machine's trouble
11. Manual/automatic switch	Switch over from manual to automatic
12 The switch of horizontal blade heating up	turn on/off the horizontal blade heating up
13 The switch of vertical blade heating up	Turn on/off the vertical blade heating up
14. Kissing device	start the kissing system which can approach conveyor belt together for some small package
15. Conveying form	select the high-speed transporting or normal speed
16. Inspection photo electricity	Select the different products induction by horizontal photo-eye or vertical one

3. SPARE PARTS SKETCH MAP

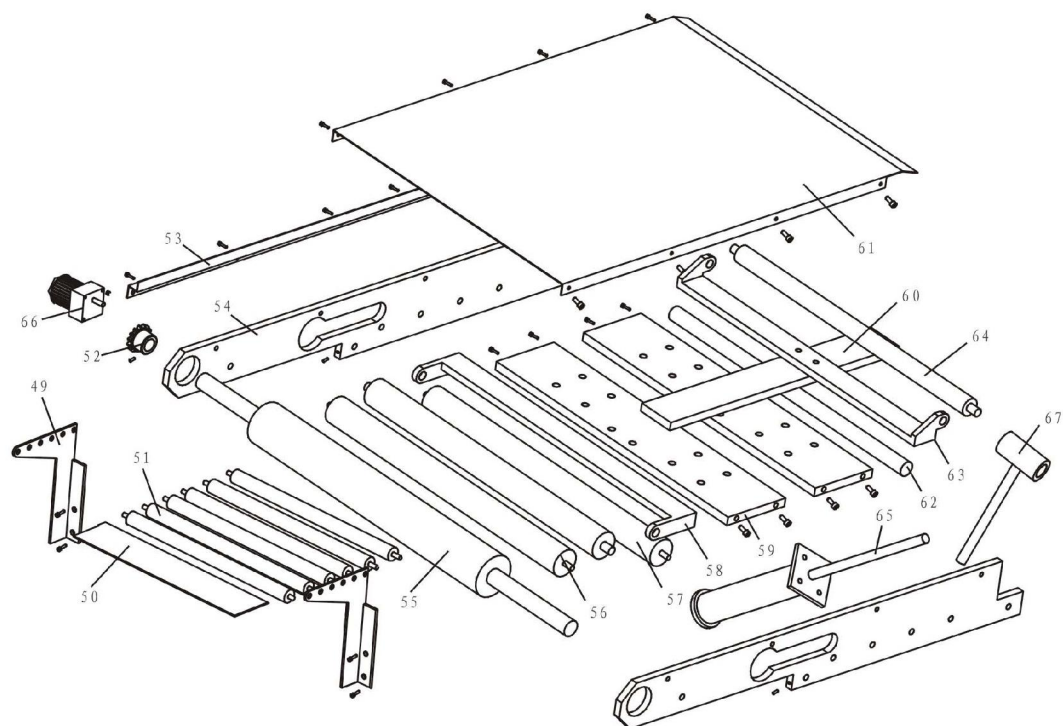


PARTS OF FILM PROVIDING--- GPL-4535

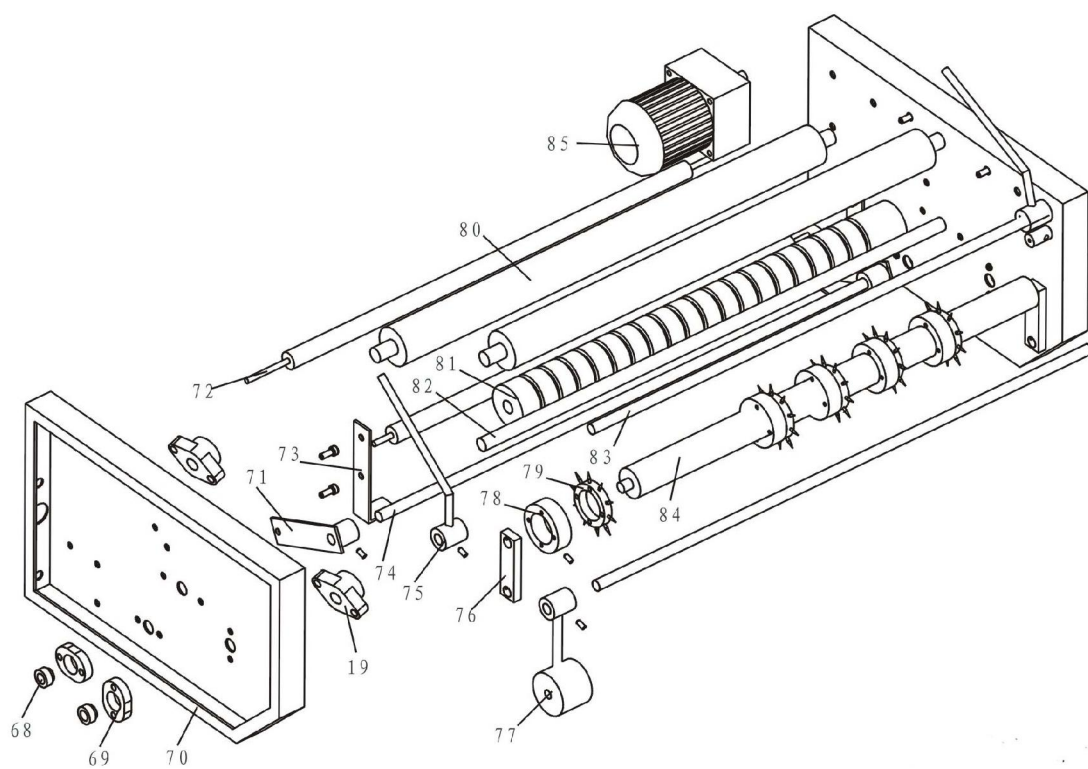


FILM DISPARTING AND FRONT CONVEYING PARTS---GPL-4535

NO.	NAME	QTY	NO.	NAME	QTY
1	Convey motor	1	32	supporting rack of driven shaft	2
2	Motor installing board	1	22	Under clapboard of conveyor belt	1
3	chain wheel	2	34	‘II’ Supporting rack of induce switch	1
4	chain wheel’s pole	1	35	upper clapboard of conveyor belt	1
5	supporting shaft for film reclaiming roller	1	36	Motor	1
6	I’ film reclaiming roller’s pole	2	37	Fixing board of motor	1
7	‘III’ film reclaiming roller	1	38	Fixing board of drive shaft	1
8	Side covering board for chain	1	39	chain wheel	1
9	I’ film reclaiming roller	1	40	Driven shaft installing board on right.	1
10	film reclaiming turnplate	1	41	conveying rack	1
11	roller’s pole	1	42	assistant roller	1
12	Motor installing board	1	43	drive roller	1
13	Motor	1	44	screw	1
14	film isolation shaft	1	45	‘I’ supporting rack of induce switch	2
15	shaft’s base of film isolation	1	46	drive shaft installing board on left	1
16	chain wheel installing board	1	47	Installing board of induce switch	2
17	chain board	2	48	axletree with base	1
18	Link staff of film isolation shaft	1	49	Supporting board of conveying rack	2
19	Supporting staff of chain wheel	2	50	Link board of conveying rack	1
20	chain	1	51	Conveying rack’s roller.	6
21	Upper triangular board	1	52	chain wheel	1
22	down triangular board	1	53	side clapboard	1
23	fixing board of lifting rack	1	54	Supporting rack of conveying line	2
24	sliding board of lifting rack	1	55	drive roller	1
25	sliding ringer	2	56	roller I	2
26	fixing staff of lifting rack	2	57	roller II	1
27	Screw	1	58	front fixing board for sliding slot	1
28	hand wheel installing board	1	59	fixing board of cylinder	2
29	‘III’ Supporting rack of induce switch	1	60	sliding slot	2
30	position limited block	1	61	clapboard	1
31	Driven shaft	1	62	fixing staff	1



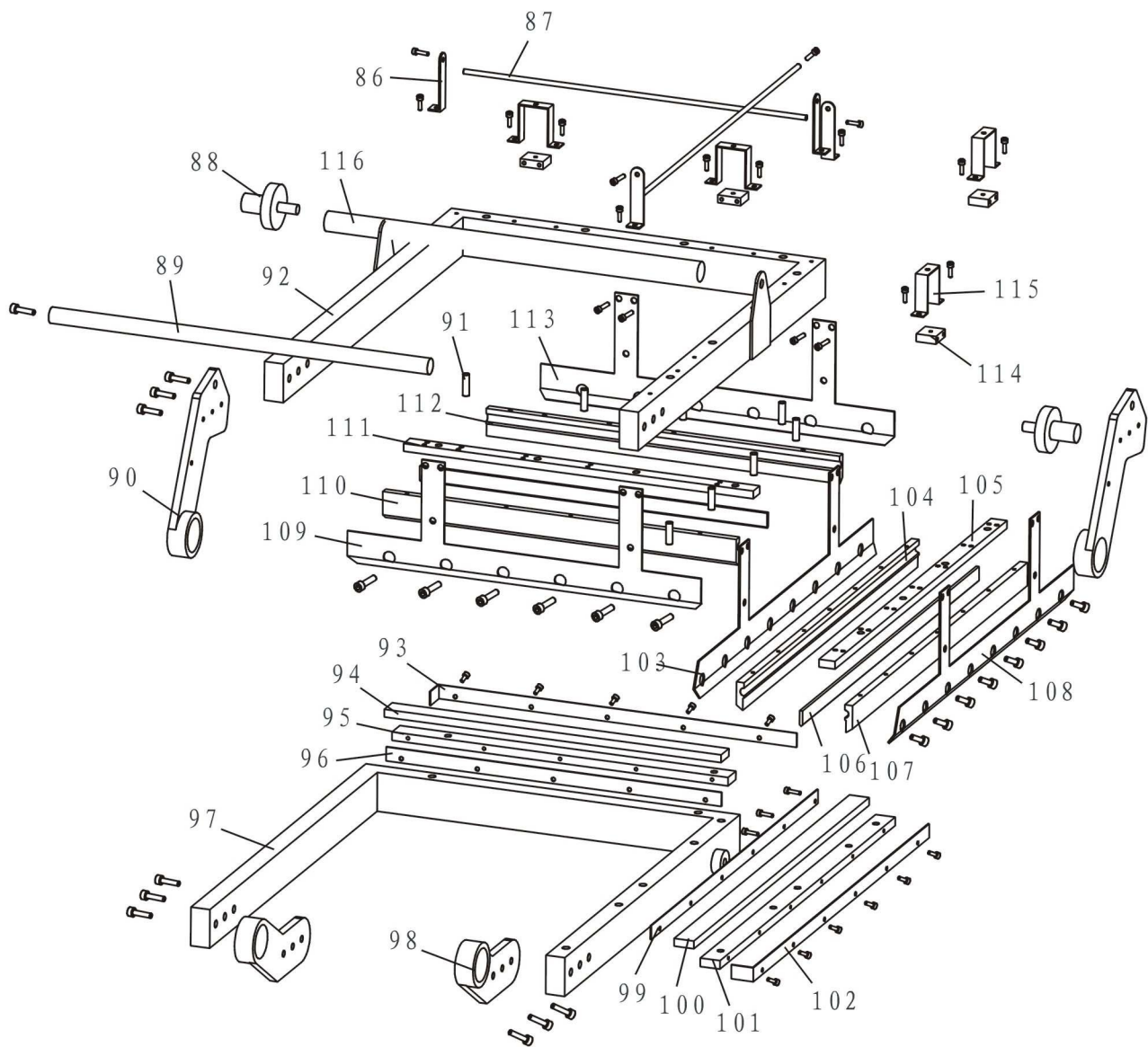
Hinder conveying parts of GPL-4535



Film providing parts of GPL-4535

NO.	NAME	QTY	NO.	NAME	QTY
63	hinder fixing board of sliding slot	1	90	linked board of upper sealing	2
64	Roller 'III'	1	91	screw	15
65	cylinder	1	92	upper sealing frame	1
66	motor	1	93	Side board IV of slot which for supported rubber.	1
67	screw	1	94	Supported rubber II	1
68	position limited block of guide staff V	4	95	supported rubber slot II	1
69	fix block of guide staff V	4	96	Side board III of slot which for supported rubber	1
70	supporting rack	2	97	upper sealing frame	1
71	turning board	2	98	Linked board of selectable sealing	2
72	guide staff I	1	99	Side board II of slot which for supported rubber.	1
73	position limited board	1	100	Supported rubber I	1
74	guide staff II	1	101	supported rubber slot I	1
75	film roller fix staff	2	102	Side board I of slot which for supported rubber	1
76	linked board	2	103	cover board II for front blade slot	1
77	sliding staff	1	104	front blade slot II	1
78	perforator wheel	7	105	fix board I of blade slot	1
79	perforator	6	106	sea ling blade	2
80	Roller I	2	107	front blade slot I	1
81	perforator base	1	108	cover board I for front blade slot	1
82	guide shaft III	2	109	cover board for side blade slot II	1
83	guide shaft V	2	110	Side blade slot II	1
84	perforator's pole I	1	111	fix board II of blade slot	1
85	motor	1	112	Side slot I	1
86	line rack	6	113	cover board I for side blade slot	1
87	line rack pole	3	114	string pad	4
88	linked staff of supporting shaft II.	2	115	string press board	4
89	Supporting shaft I	1	116	Supporting shaft II	1

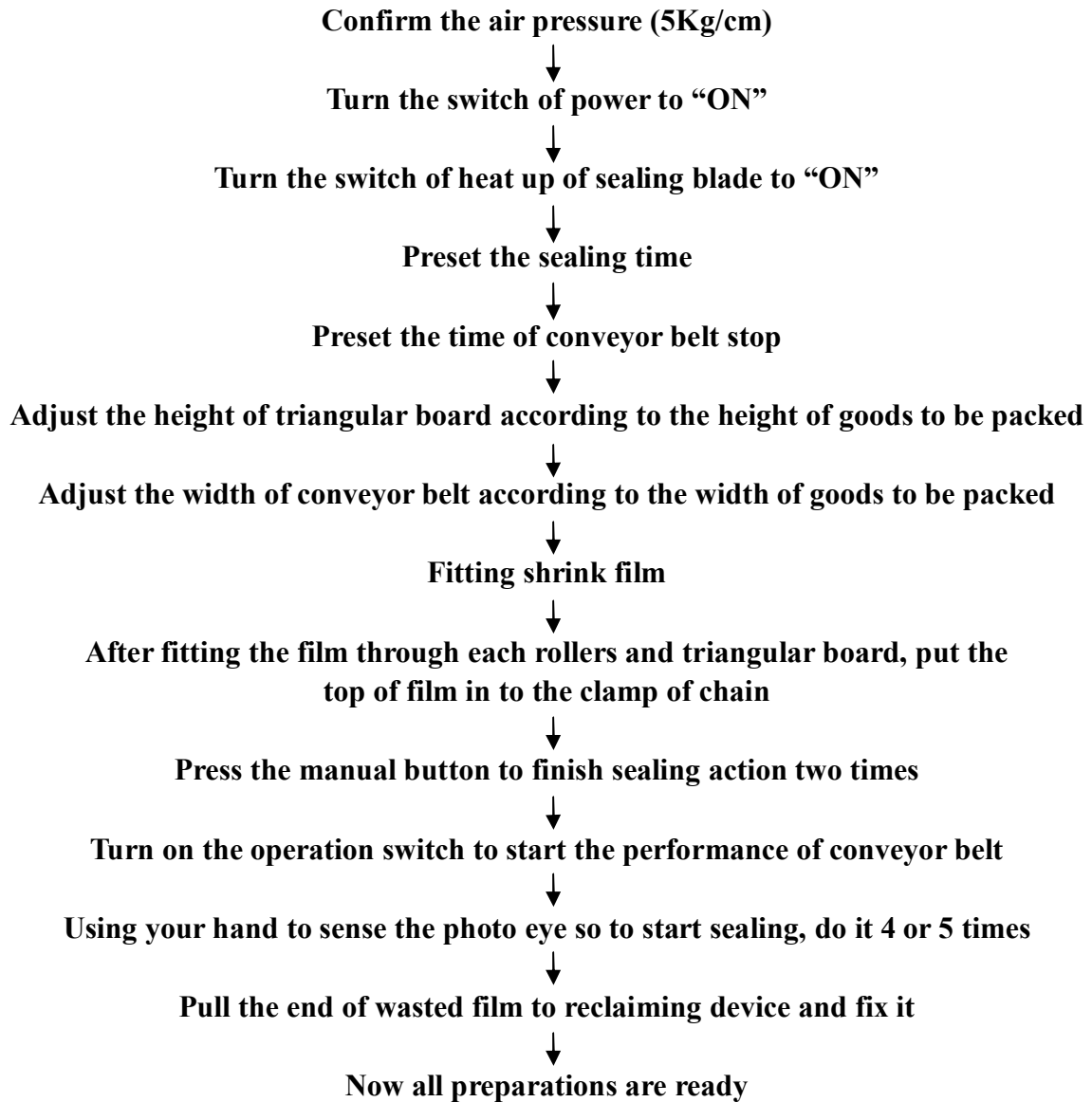
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GPL-4535SEALING PARTS

4. RUNNING PREPARATION

OPERATION ORDER



5. PROCESSED FILM FITTING

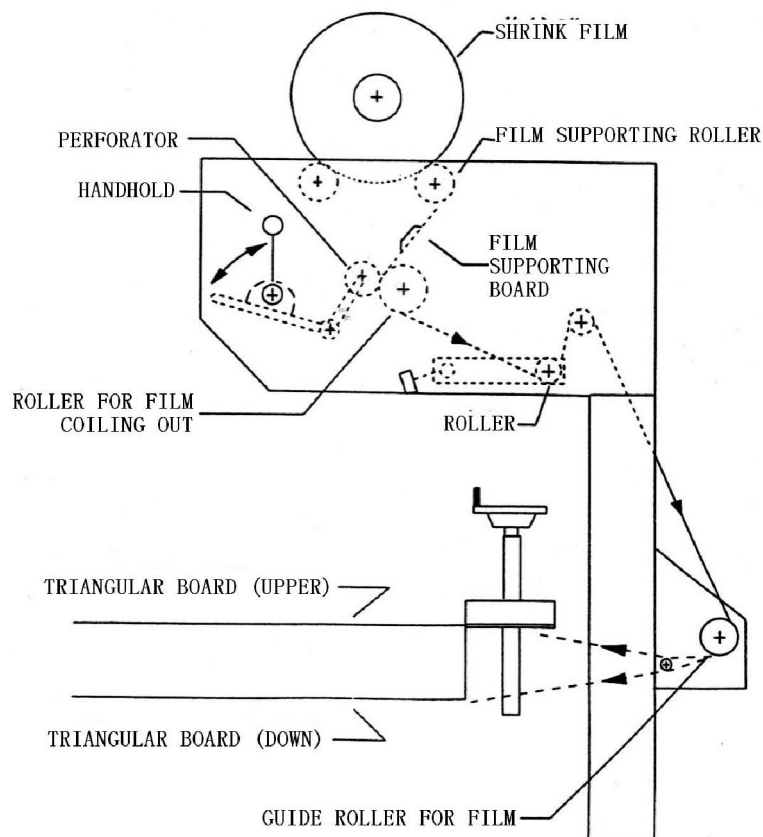
Turn off the switch of operation when installing film.

When the machines reached at destination, any operation or film installation may as well to do at assistance by our engineer, and give your full cooperation please.

1. Put film roller on the right position between the two supporting rollers.

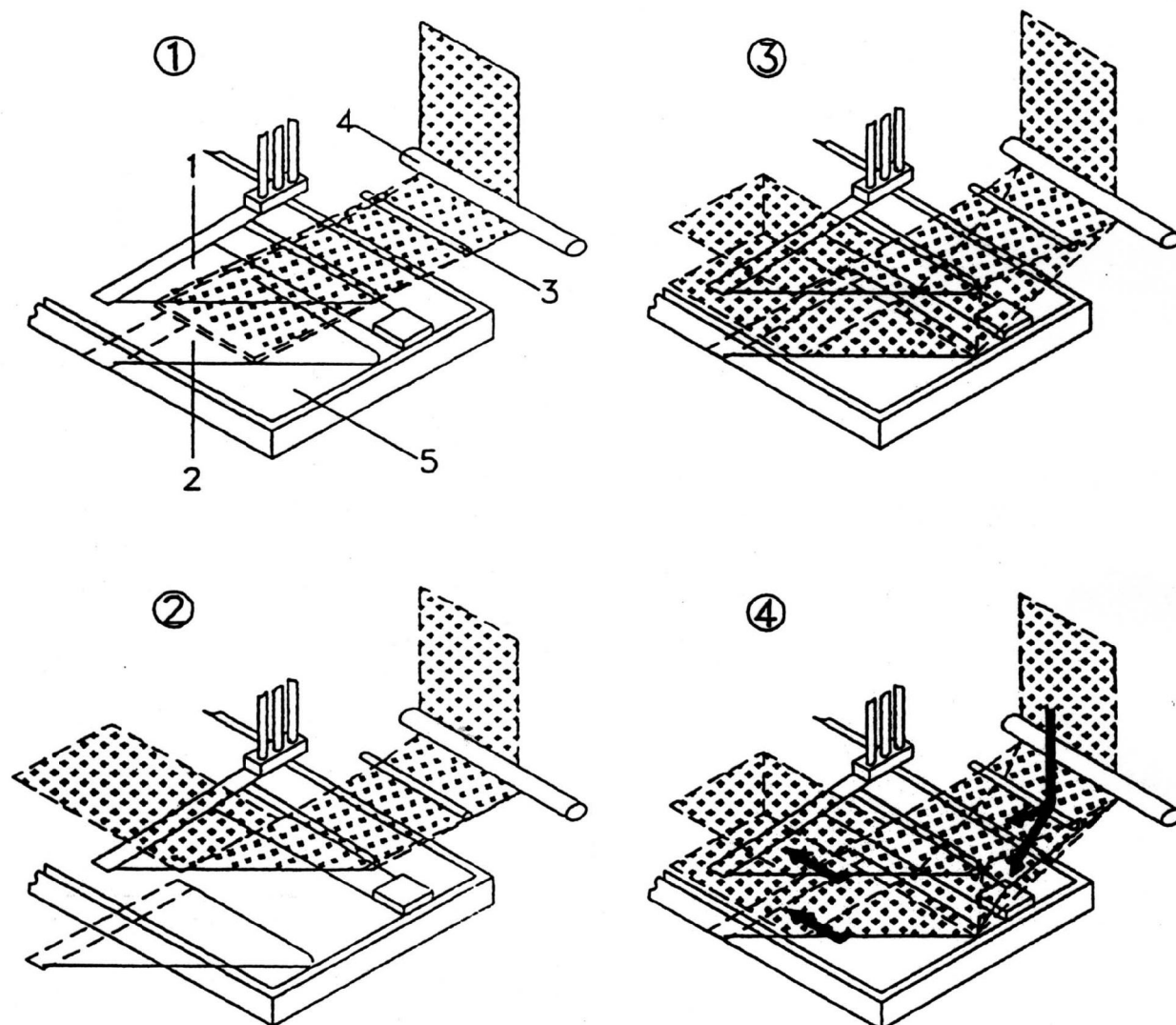
Position: the right position must be followed the guidance on the rollers (1/2 of the height of two triangular board).

2. Pull the handhold of perforator down about 90 degree.
3. Pull down the shrink film according to the drawing at following through each roller.
4. After film has been passed the sixth roller, return the handhold of perforator back.
5. Through the sixth roller, pull out a length film in about 1 foot and get it through both the conveying parts and triangular board to finish the film installation.



To continue the above steps at last page. Film passed through the sixth roller, please to install the film continuous according to the following drawing.

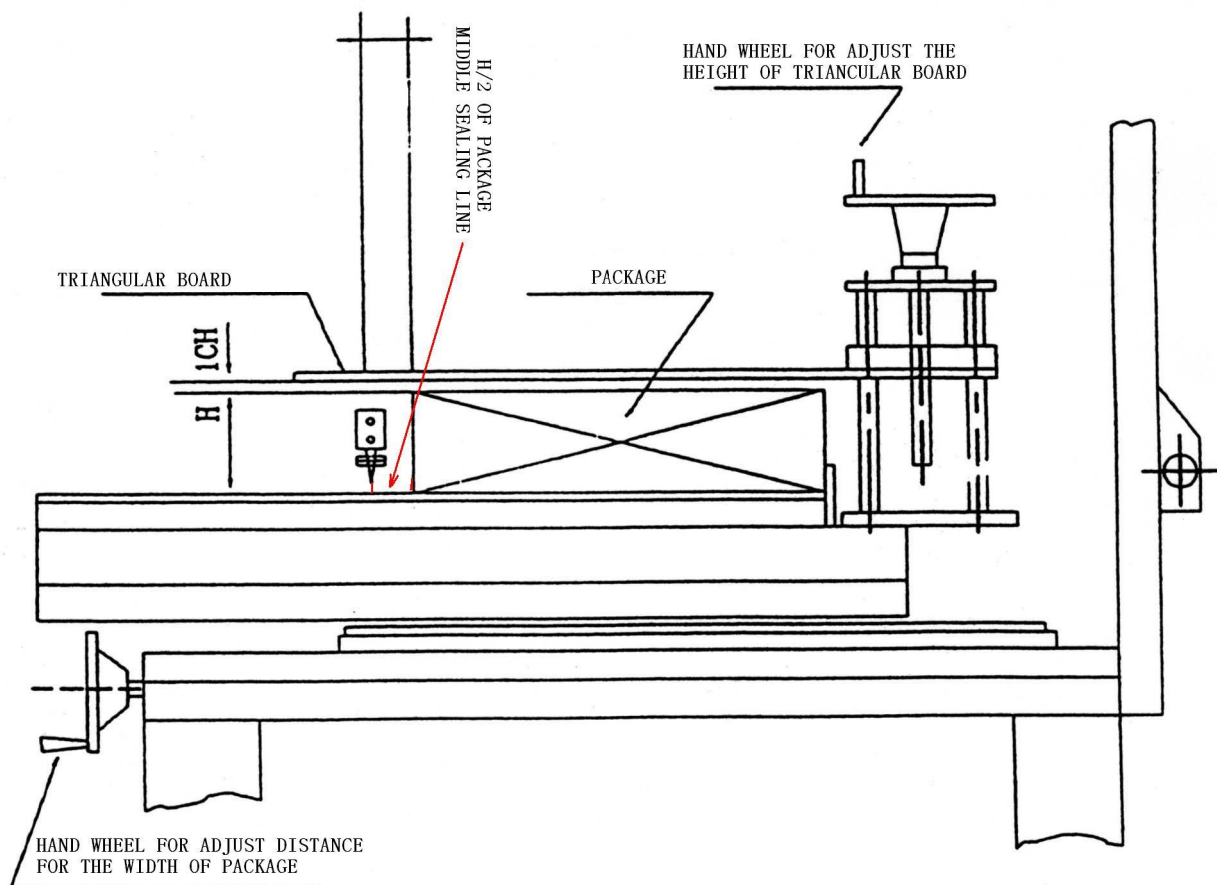
1. Spreading film at the front of triangular board.
2. To fold film by counter, the inside of film become outside. Let the top of film face to the direction of conveyor belt.
3. Using your left hand to press the film unmovable, pull the corner which formed by film folded on these two triangular board.
4. After the film already pulled on the both of triangular boards, pull out a length of film and clamped it in the conveying chain.



1	Upper triangular board	4	Film guide wheel
2	Down triangular board	5	Conveyor belt
3	Electrostatic stick		

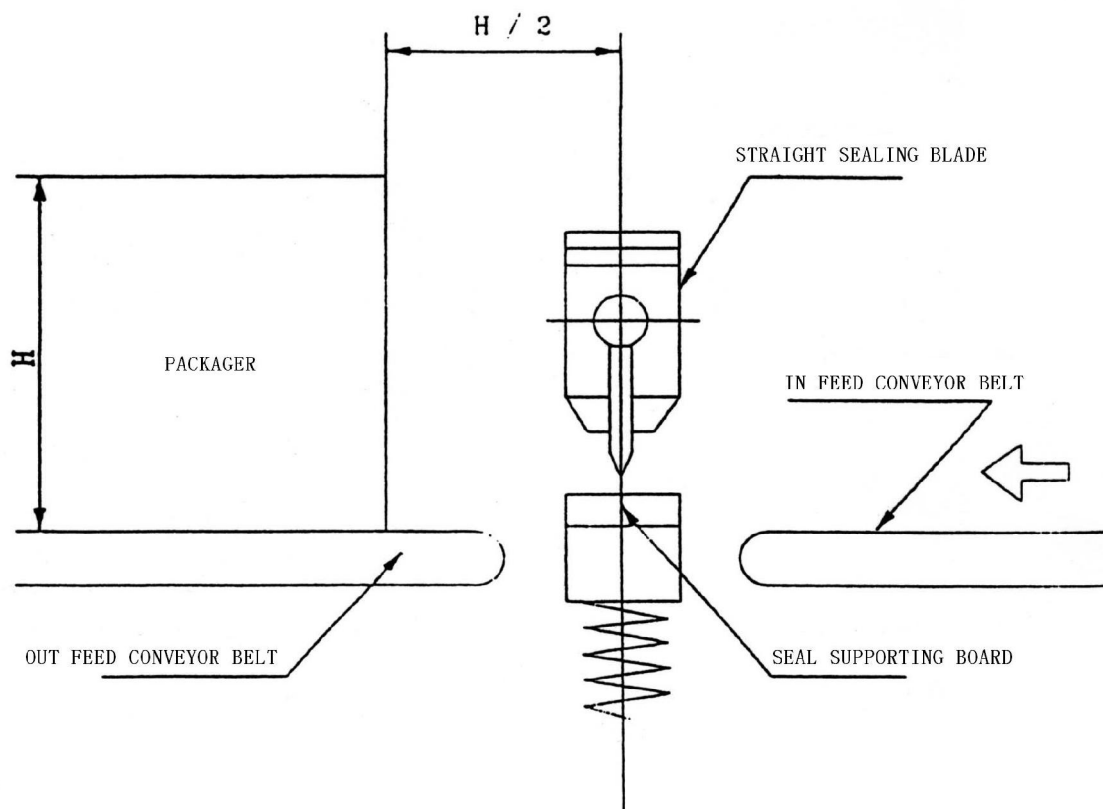
SIX RUNNING ORDER

1. Turn on the power supply, then adjust temperature controller to be in suitable degree for package. Better propose---Horizontal sealing blade: 150°C-180°C, straight sealing blade: 150°C-180°C. Sealing time: 0.8-1.5 second. It can be freely adjusted when there will different caused by room temperature and different thickness of material.
2. Adjusting the height of triangular board by the upper hand wheel according to the size of package, but please interspaced 10 mm with the package. And the fitted distance for width of package can be moved by the hand wheel which equipped at the front of feeding table.
3. Preset the distance between middle sealing line and the side of package when its stop at sealing table. It better set the distance at 1/2 of the height of the package.



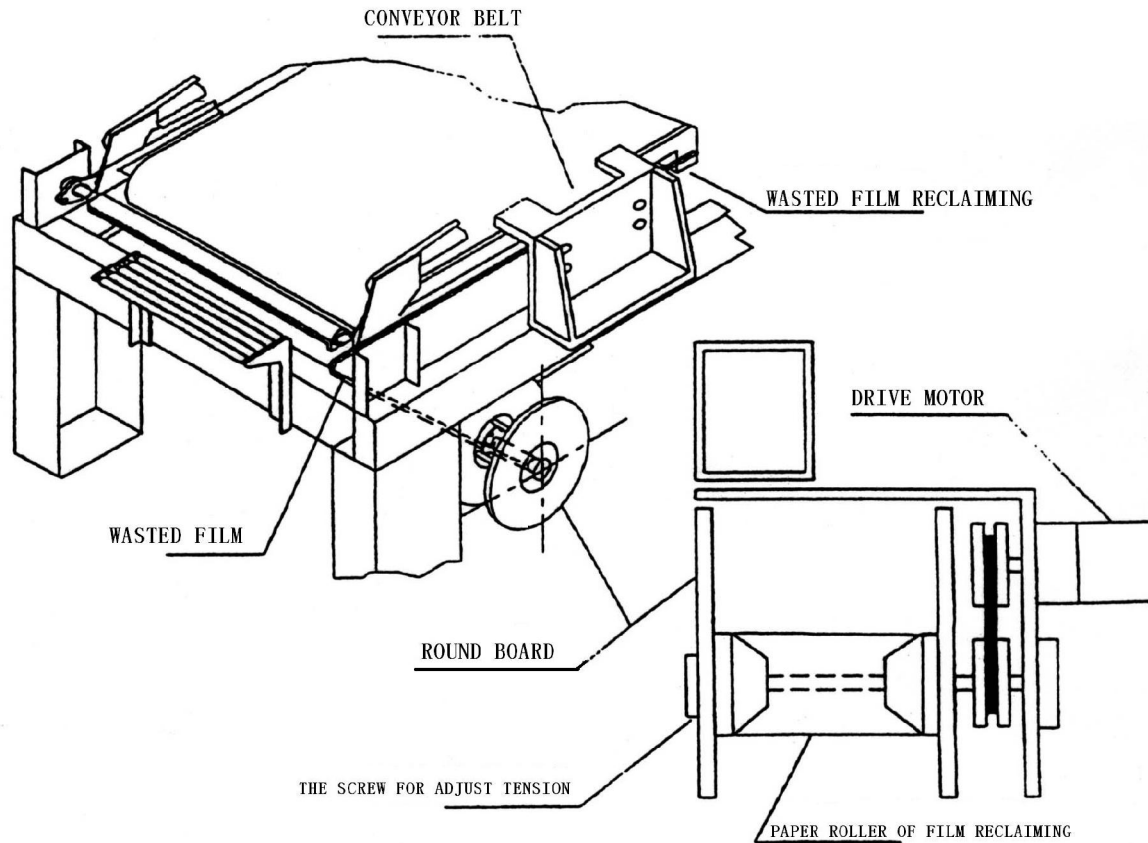
4. Preset the time controller of 'Conveyor stop' which for stop the package to seal, the suitable time is correspond with the distance between the end of package and middle sealing line. It better set the distance at $1/2$ of the height of the package.
5. On the situation of the height of package is more than 6cm, please setting the margin distance of film between the top of package and middle sealing time before to seal.
6. After the distance for width of package has already set, please installing the film according to the method from "shrink film installation".
7. After the temperature arrived at preset level, pulling out a length of film into the clamping chain, then pressing the "MANUAL SEALING" for several times till the side of film has clamped by the chain completely.
8. Turn on the operation switch, start the conveyor belt by "MAN TO AUTO" switch, then just to put the packages on conveyor belt to finish sealing automatically.

The drawing of the right position for stop package



SEVEN RECLAIMING PROCESS

1. To seal for several times by manual after the machine started, the wasted film would be coiled out from clamping chain. After about 1 meter wasted film out, take it to the biggest reclaiming plate and fix it.
2. When the reclaiming plate with full wasted film, please unloading the front round board of the plate then you can take out all film.



EIGHT SAFE DEVICE

The machine has designed and equipped with safe protect device which to prevent any no foresee accident very well. If there is miss cutting that the product was stopped under the sealing blade when the machine is running, the sealing blade would stop to seal and return back that to avoid any damage would happen at the machine.

(Considered the safety purpose, there is no stopped circuit in conveying device)

After repaired the troubles, pressing manual control switch to restart the machine's operation.

NINE MAINTENANCE

Be able to remain the perfectly sealing performance of the machine under long time used, please obey the following proceeding.

1. Please to clean the sealing blade carefully by soft fabric after used the machine.
2. Then plastering the sealing blade fully with some cleaning cream, it can be touched some cream on the fabric at first.
3. If the blade has damaged result imperfect sealing, replace it with new one.
4. Maintenance for pneumatic parts

4-1 Leak out the wasted water

1. The accumulated water must be leaked out before it is go up the metal baffle.
2. Water is out just to turn over the piston on bottom of the bottle. Please note it is possible that the piston can not return back if you press it, if the situation was happened, please unloading the bottle's bottom and press the piston from up to down.

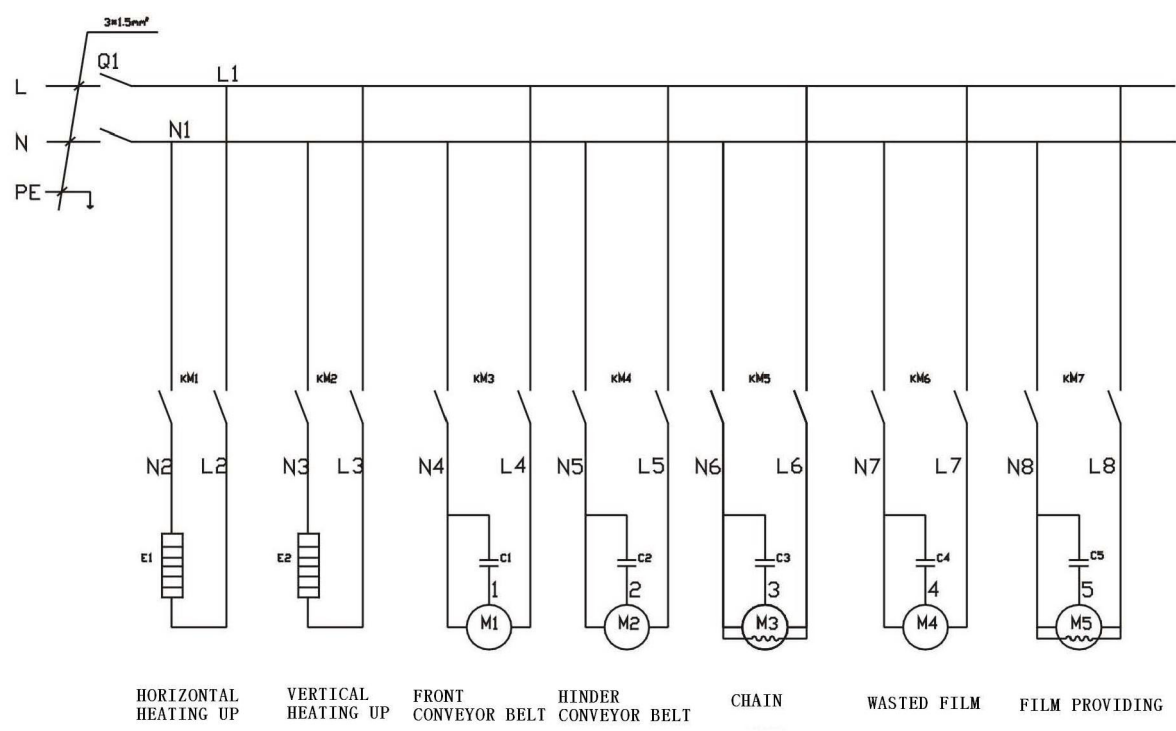
4-2 Air pressure adjustment

1. Turn right the adjust button, the second press is going up.
2. After the pressure been set, please fixed the lock at upper the button.

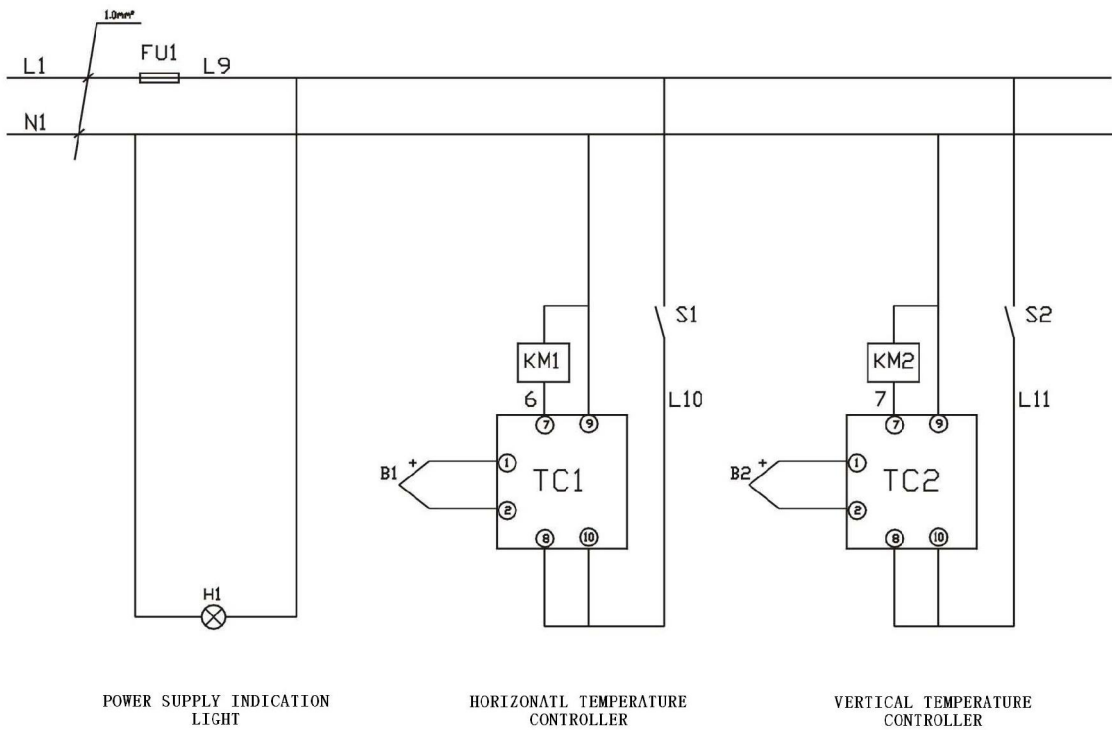
4-3 Disassembling

1. Cut off the air source
2. Loosing the four screws which assembled in the adjuster, and its cover, string, mould combination.
3. Follow the order to disassemble the plastic plate, baffles and so on.
4. Take out each screw, string and supporting board for piston.

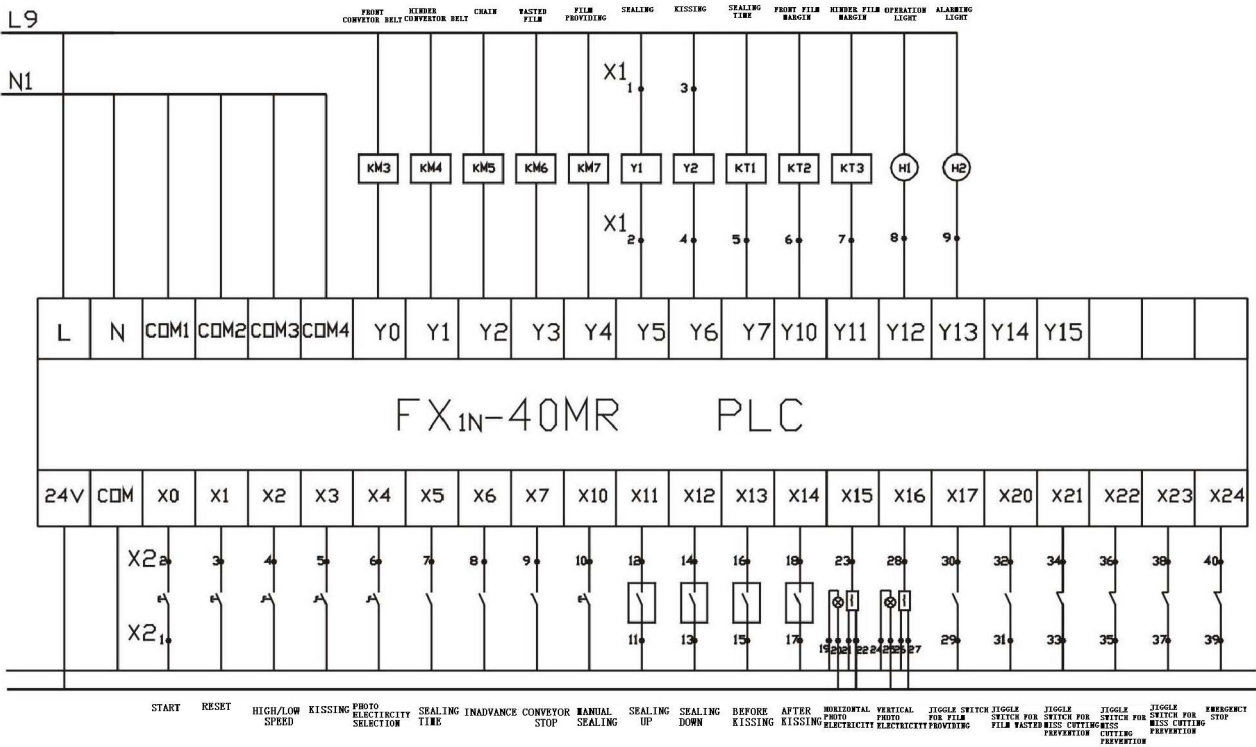
TEN DRAWING OF ELECTRICAL CIRCUIT



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ELEVEN ATTENTIONS WHEN THE MACHINE IS RUNNING

1. Don't put your hands under the sealing blade when the machine is running.
2. Please confirm all power connection is correct, right transporting direction of conveyor belt is from right to left. (Otherwise the film would not uncoil.)
3. If there are some troubles happened, please repairing it after turned off the main power, to try the performance by manual operation, and then open the automatic operation switch.

TWELVE TROUBLE SHOOTING

Troubles		possible causes	trouble shooting
1. Controller box	No lighting of power supply	no turn on the power	turn on the power
		the fuse was broken	replace spare parts
		Connection head was not well	
		Wires broken	
		Power light doesn't working	
	The Switch jump up	Bad wires connection	Confirm the position
2. Conveyor belt		Electricity leak out	inspect the circuit
		the tension was too loose	Adjust the screw
	Can movable by hand	the tension was too tight	Replace
	Can not movable by hand	The gear was not well	
	Can not movable in normal situation	The tension of chain was too tight	Adjust it
		Wires broken	replace spare parts
		The motor was bad	
		The continuous pin was bad	
		The delay was bad	
		The jiggle switch was bad	
3. Film	Transporting roller can not moved	Wires broken	replace spare parts
		The motor was bad	
		The delay was bad	
		Brake was bad	
	Bad performance of film providing	Fix position was bad	adjust it
	Film can not moved	The tension shaft was not on level	adjust it
		The position of tension roller was bad	
		the degree of triangular board was not well	
		The tension of clamping chain was too loose	adjust or lubricate
		The tension of clamping chain was too tight	
4. Sealing bar	No performance	Wires broken	replace spare parts
		The delay was bad	
		Electrical magnet was bad	
		Air pressure was not enough	inspect the air provider
	Sealing	the fuse was broken	Replace spare parts

TROUBLE SHOOTING 2

Troubles		possible causes	trouble shooting
5.Sealing	It can not heating up	The heater was broken	Replace spare parts
		The delay was broken	
		The power supply is single phase	Inspect the supply
	Temperature can not adjusted	Temperature controller was broken	Replace spare parts
		Thermal-couple was broken	
		Wires broken	
	Safety device doesn't work	Jiggle switch was broken	Replace spare parts
	Can not to seal by manual	Wires broken	Replace spare parts
		Jiggle switch was broken	
		The delay was broken	
		Air pressure is not enough	Inspect air source
	Seal is not firm	Sealing blade was broken	Replace new one
		The temperature is too lower	adjust it
		Sealing time is too short	Inspect air source
		Air pressure is not enough	
		The heater was broken	
6. Wasted film reclaiming	Clamping chain can not moved	Wires broken	Replace spare parts
		The motor was broken	
		The delay was broken	
		The brake was broken	
		Continuous pin was broken	
		The chain is too tight	adjust it
		Then chain is too loose	
		No lubrication	Add lubrication
	Reclaiming wheel doesn't work	Wires broken	replace spare parts
		The motor was broken	
7. Wrong performance		The voltage is too lower	Inspect the voltage
		The power supply is single phase	Confirm the supply
		The connection of delay is not well	Replace it
		Connection is not well	Connected it again

THIRTEEN PACKING LIST

No.	Article Name	quantity	remark
1	Main machines	1 set	
2	High temperature tape	1 roll	
3	Tool box	1 pcs	
4	Instruction	1 set	
5	Inside hexangular screw	1 set	
6	Movable spanner	1 pcs	
7	“+” screw driver	1 pcs	
8	Quality assurance	1 pcs	