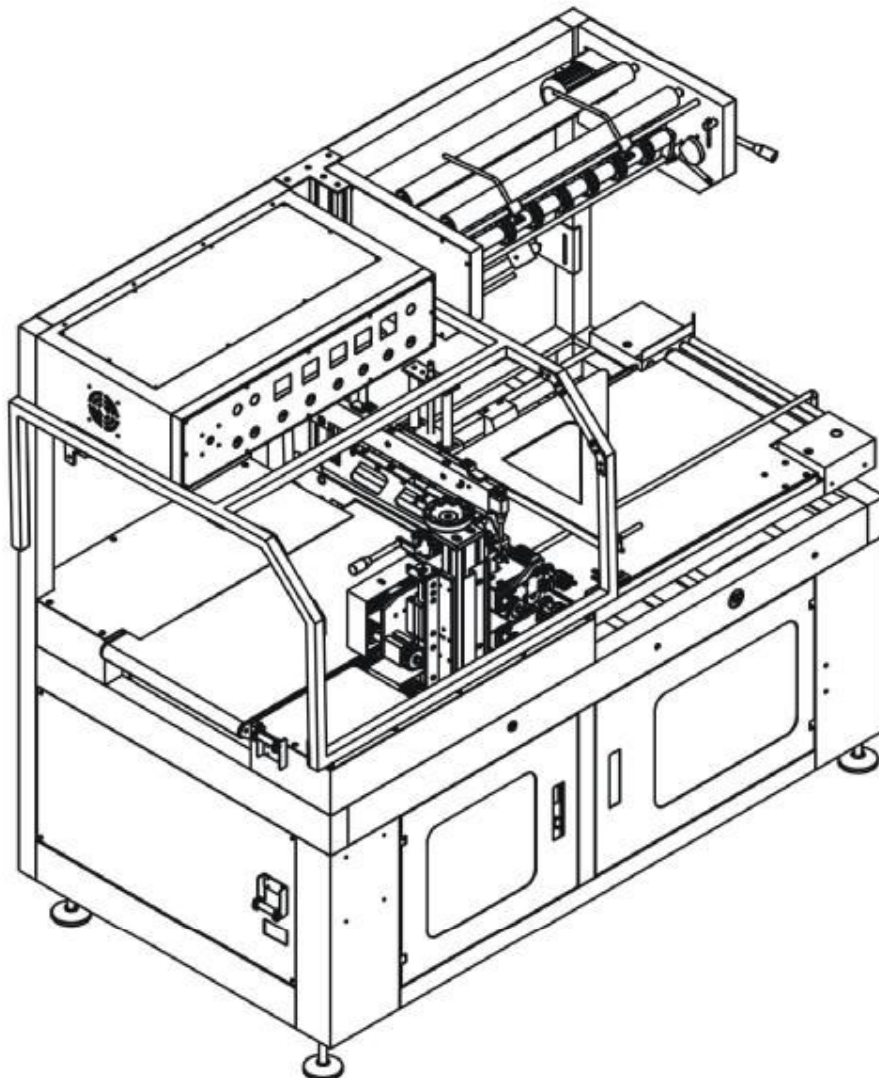


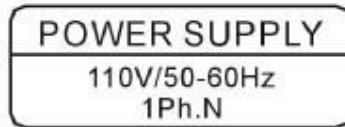
/// **GPL-5545C**

**FULLY AUTOMATIC SEALING PACKAGER**  
**MANUAL**

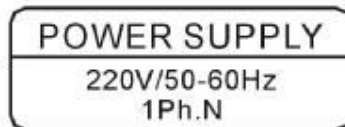


Please read carefully and fully the manual before using the machine  
For any technical modification, we won't inform you.

## Note the blow marks before use the machine:



Power supply :  
110V/50~60HZ, 1 PH.N



Power supply:  
220V/50~60HZ, 1 PH.N



Direction of the conveyor belt



It must be connected to the ground



Non-professional maintain person  
doesn't open the door



It is very dangerous to  
make your hands hurt and cut

## Foreword

---

### Operating instruction

Thanks for using our products, we provide the right method for operating the machine and all maintain instruction in the manual

Operating the machine after reading the full manual.

The machine is auto sealing packing machine suitable for PE, OPP, POF.

### Attention

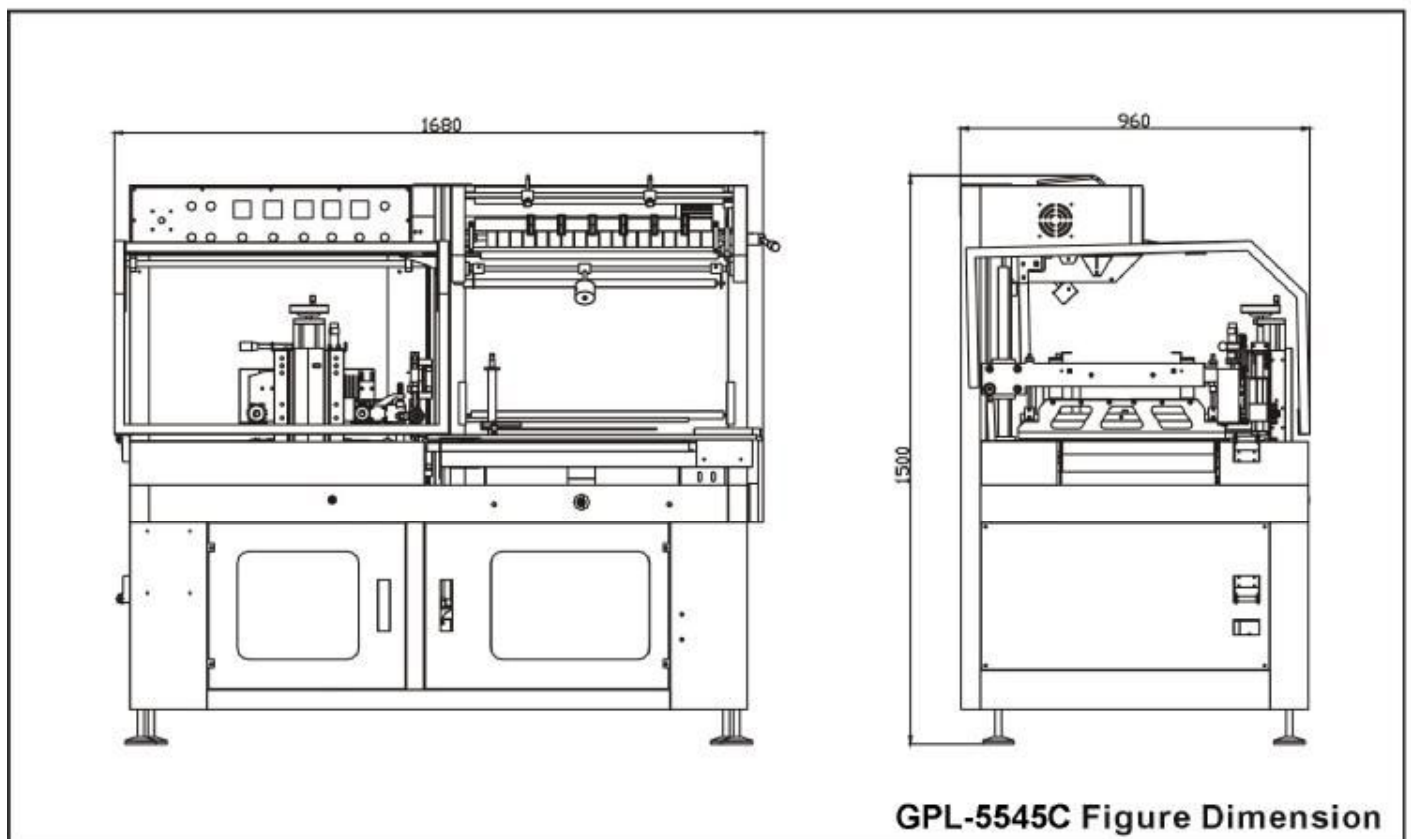
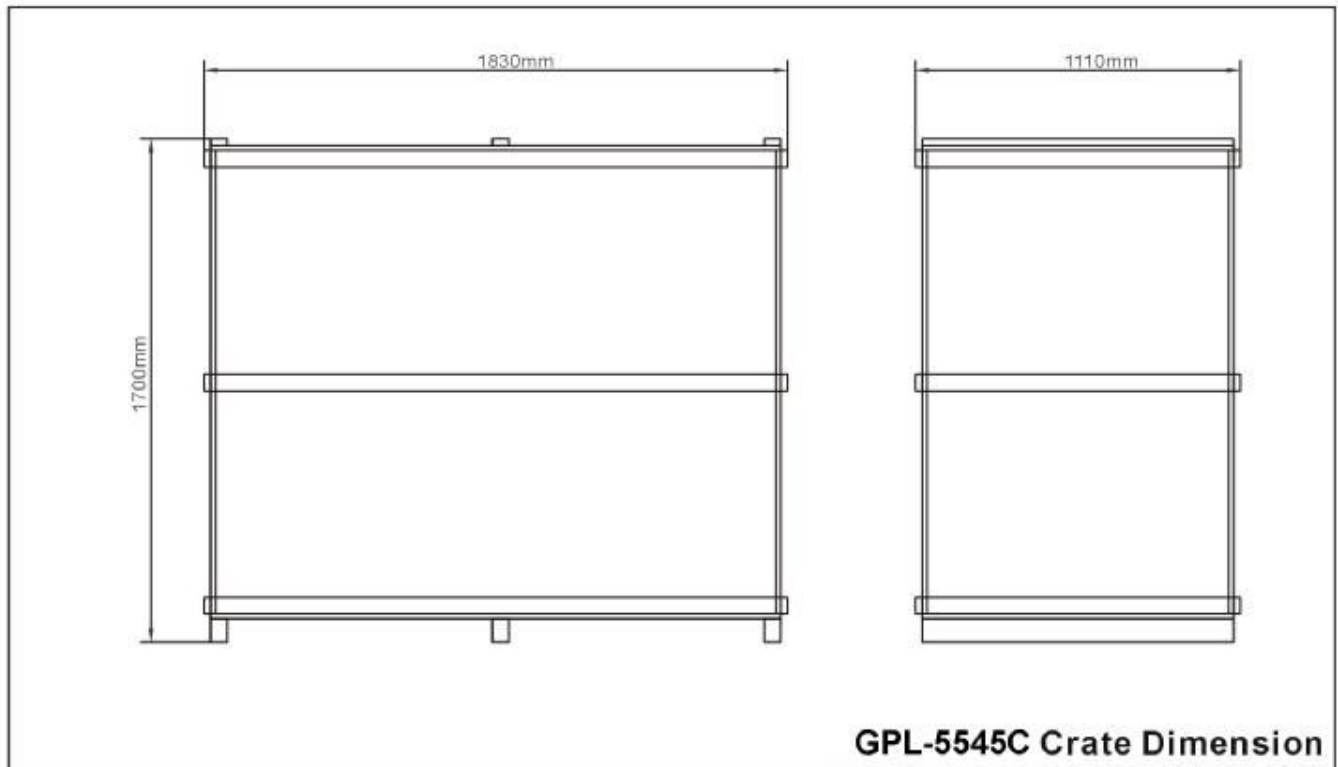
- 1). Maintain the machine in the best situation all the time.
- 2). Switch off the power and the air source after use the machine.
- 3). Please don't put anything inside of the machine and on the machine.
- 4). Switch off the power and air source before check the machine.

## Catalogue

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I. Machine specification and packing crate dimension-----	#
II. Specification sheet of the machine-----	#
III. machine face-sheet, and button name and function of the face-sheet----	#
IV. Instruction map of the machine part-----	#
V. Preparation for running-----	#
VI. Installing film-----	#
VII. Running process-----	#
VIII. GPL-5545C closing work status -----	#
IX. Disposing of wasted film-----	#
X. Safety device-----	#
XI. Maintenance -----	#
XII. Circuit diagram-----	#
XIII. Attention as running-----	#
XIV. Troubleshooting-----	#
XV. Packing list-----	#

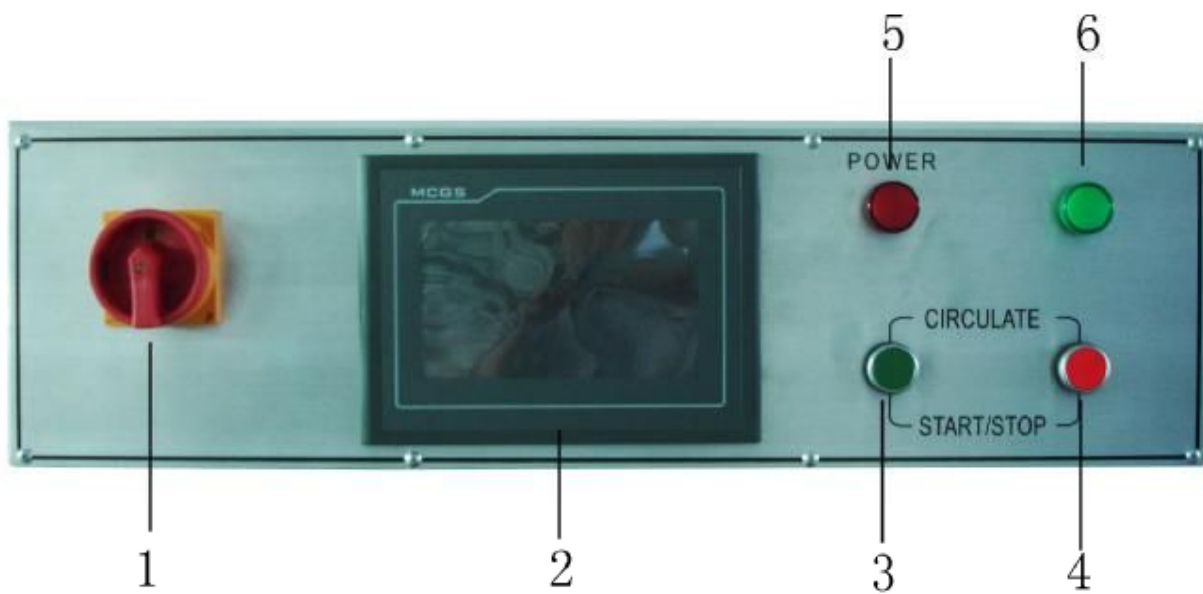
## I. Machine specification and packing crate dimension



## II. Specification sheet of the machine

1. machine dimension	(L)1680mm * (W)96mm * (H)1500mm	
2. height on the conveyor belt	800mm+70mm	
3. sealing dimension	(W)450mm	
4. feeding speed	IN	21.3M/MIN
	OUT	20.0M/MIN
5. speed of sending film	17.6M/MIN	
6. speed of clipping film	19.4M/MIN	
7. sealing temperature	it depends on the different film. Temperature is a little different for the ambient environment	
8. power	1□AC 200/ 220V 4P 50/ 60 HZ	
	(1) motor for in- feed belt	90W
	(2) motor for out- feed belt	120W
	(3) motor for sending film	25W(with brake)
	(4) motor for clipping film	120W
	(5) motor for rolling film	15W
	(6) Heater	horizontal 450W longitudinal 80W
9. air pressure	5KG/CM2 37NL/MIN	
10. sealing time	1 second it is adjustable base on the different wrappage	
11. Film	PE, OPP, POF	

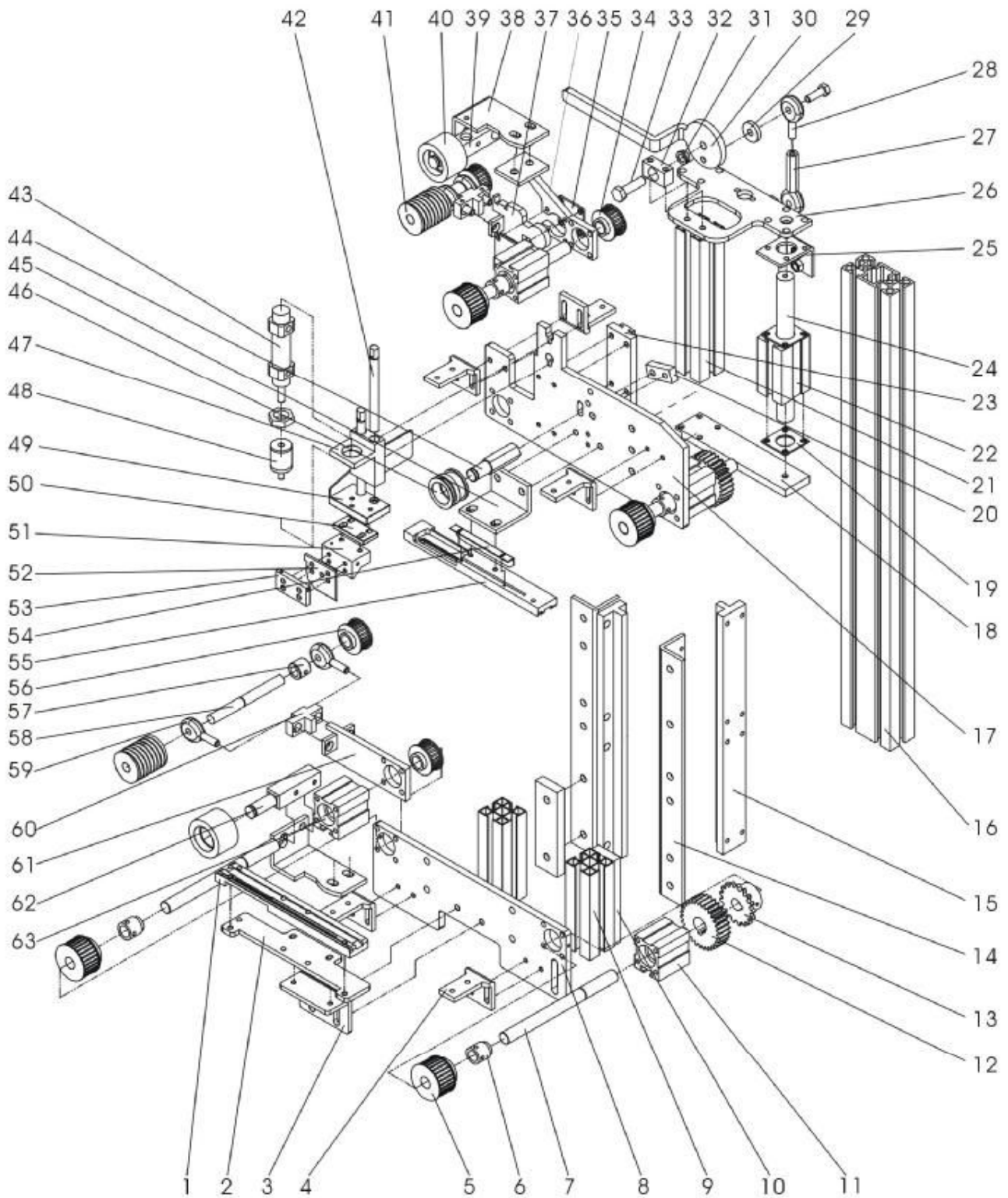
### III. machine face-sheet and function of the button



1. Power switch
2. Touch screen
3. Start bottom
4. Stop bottom
5. Power light
6. Running



# IV. Instruction map of the machine accessory

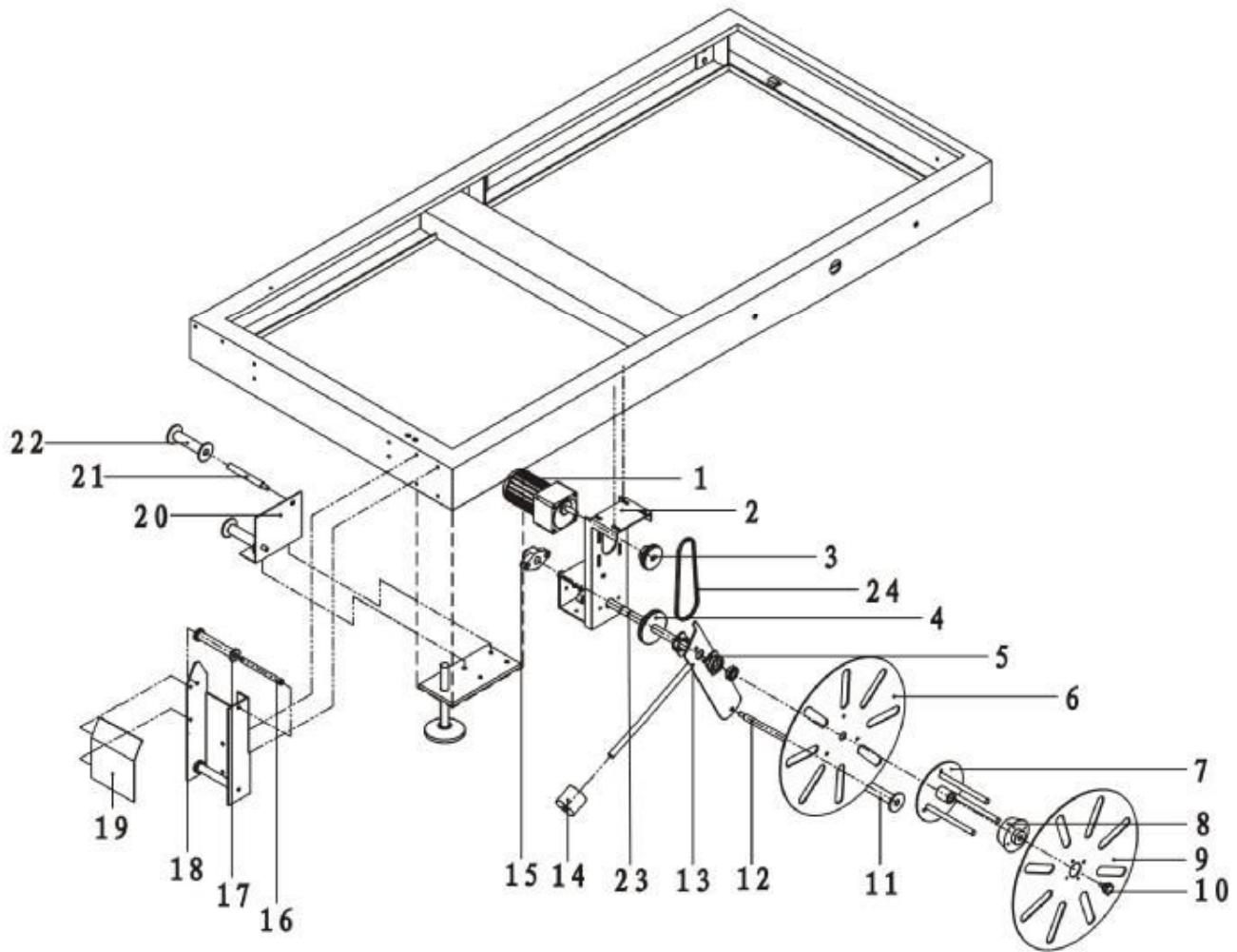


GPL-5545C M.D. BLADE SYSTEM



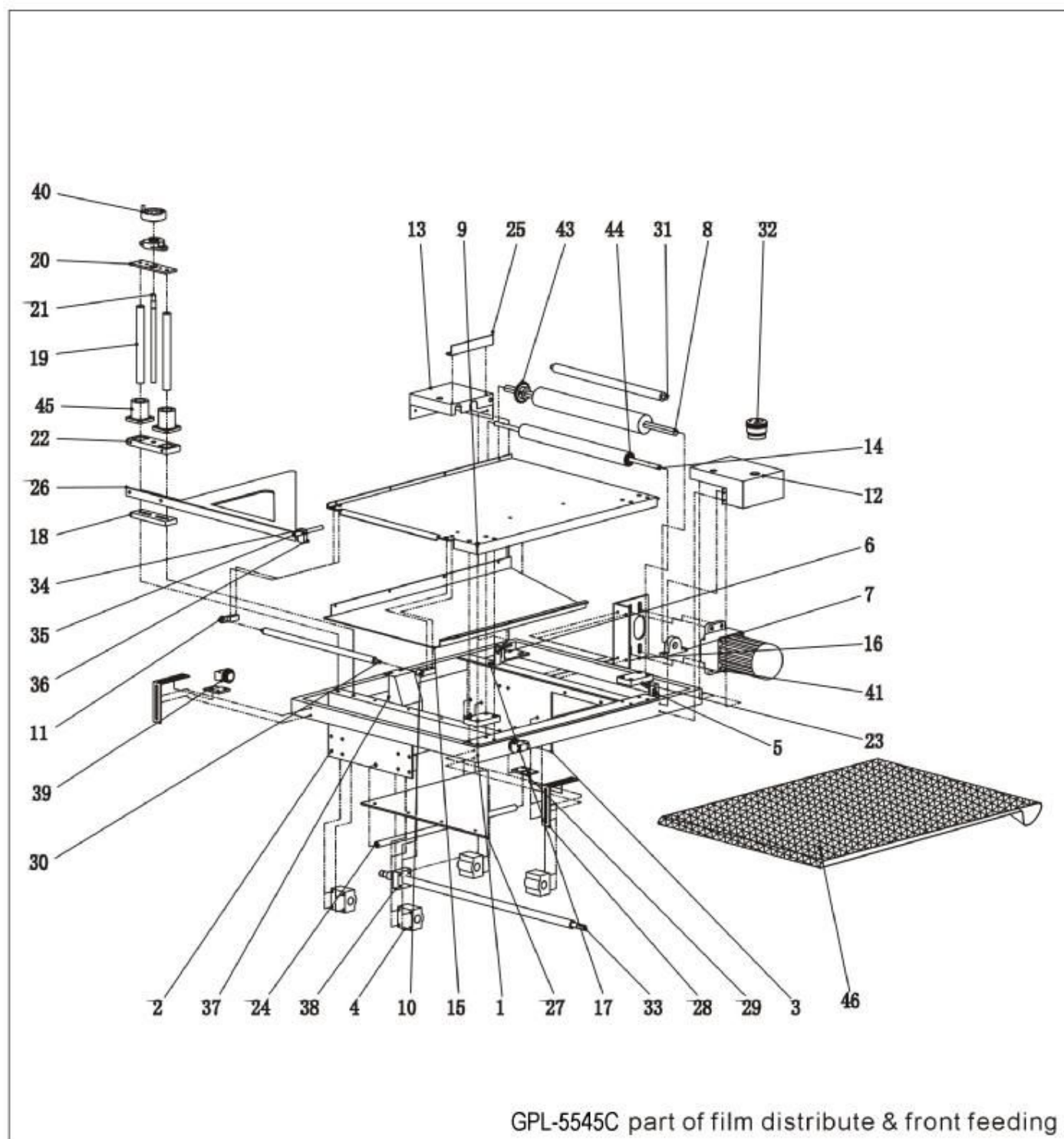
SN	Number	Name	Qty	SN	Number	Name	Qty
1	BF01-01-069	synchronization pushdown block	1	36	BF01-01-012	adjustable board of plastic wheel for pulling film	1
2	BF01-01-074	board of synchronization pushdown block	1	37	BF01-01-013	fixing board of plastic wheel for pulling film	1
3	BF01-01-075	rack of synchronization pushdown block	1	38	BF01-01-063	rack of auxiliary plastic wheel axle for pulling film	2
4	BF01-01-011	rack of protecting longitudinal sealing blade	5	39	BF01-01-062	upper axle of auxiliary plastic wheel for pulling film	1
5	BF01-01-003	synchronization belt wheel	4	40	BF01-01-078	auxiliary plastic wheel for pulling film	2
6	BF01-01-022	ringer	4	41	BF01-01-015	main plastic wheel for pulling film	2
7	BF01-01-006	main axle	4	42	BF01-01-017	cylinder column	2
8	BF01-01-070	lower board	1	43	WGBZ002	lifting cylinder	1
9	BF01-01-036	main abuttal	2	44	BF01-01-051	synchronization tension axle	1
10	BF01-01-086	fixture block of main abuttal	2	45	BF01-01-067	fixing rack of synchronization pushup board	1
11	BF01-01-071	synchronization back entablature	2	46	BF01-01-004	synchronization tension axle	1
12	BF01-01-001	synchronization gear	2	47	BF01-01-085	main rack of the cylinder	1
13	BF01-01-014	auxiliary gear	1	48	WGBZ003	auto-suitable block of the cylinder	1
14	BF01-01-080	block rack	2	49	BF01-01-009	connector rack of heavy duty	1
15	BF01-01-066	jacking block	2	50	BF01-01-025	fixture block of blade seat	1
16	BF01-01-098	fixing abuttal	1	51	BF01-01-026	blade seat	1
17	BF01-01-057	upper board	1	52	BF01-01-030	blade seat	1
18	BF01-01-028	lifting board	1	53	BF01-01-016	fixing block of the thermocouple	1
19	BF01-01-077	close board of straight axle	2	54	BF01-01-052	blade for separating film	1
20	BF01-01-050	fixing block of tension axle	1	55	BF01-01-064	synchronization pushup block	1
21	BF01-01-042	lifting block abuttal	1	56	BF01-01-035	synchronization belt wheel for auxiliary pulling film	2
22	BF01-01-039	straight entablature	1	57	BF01-01-020	ringer of main plastic axle	2
23	BF01-01-079	lifting block	1	58	BF01-01-002	belt axle for pulling film	2
24	BF01-01-027	guide abuttal	1	59	WGBZ004	switch axle bearing	4
25	BF01-01-008	slide fixing seat	1	60	BF01-01-021	block of plastic wheel for pulling film	2
26	BF01-01-010	lifting abacus	1	61	BF01-01-088	rack of plastic wheel for pulling film down	1
27	BF01-01-019	adjustable bar of lifting hand	1	62	BF01-01-068	lower axle of auxiliary plastic wheel for pulling film down	1
28	WGBZ001	switch axle(up/down)	2	63	BF01-01-024	synchronization front entablature	2
29	BF01-01-045	adjustable limit block	1				
30	BF01-01-046	lifting hand	1				
31	BF01-01-092	hand copper cover	1				
32	BF01-01-047	fixing seat of lifting hand	1				
33	BF01-01-048	hand safety screw	1				
34	BF01-01-023	synchronization belt wheel for pulling film	4				
35	BF01-01-049	fixing clamping plate of upper rack	2				

## IV. Instruction map of the machine part



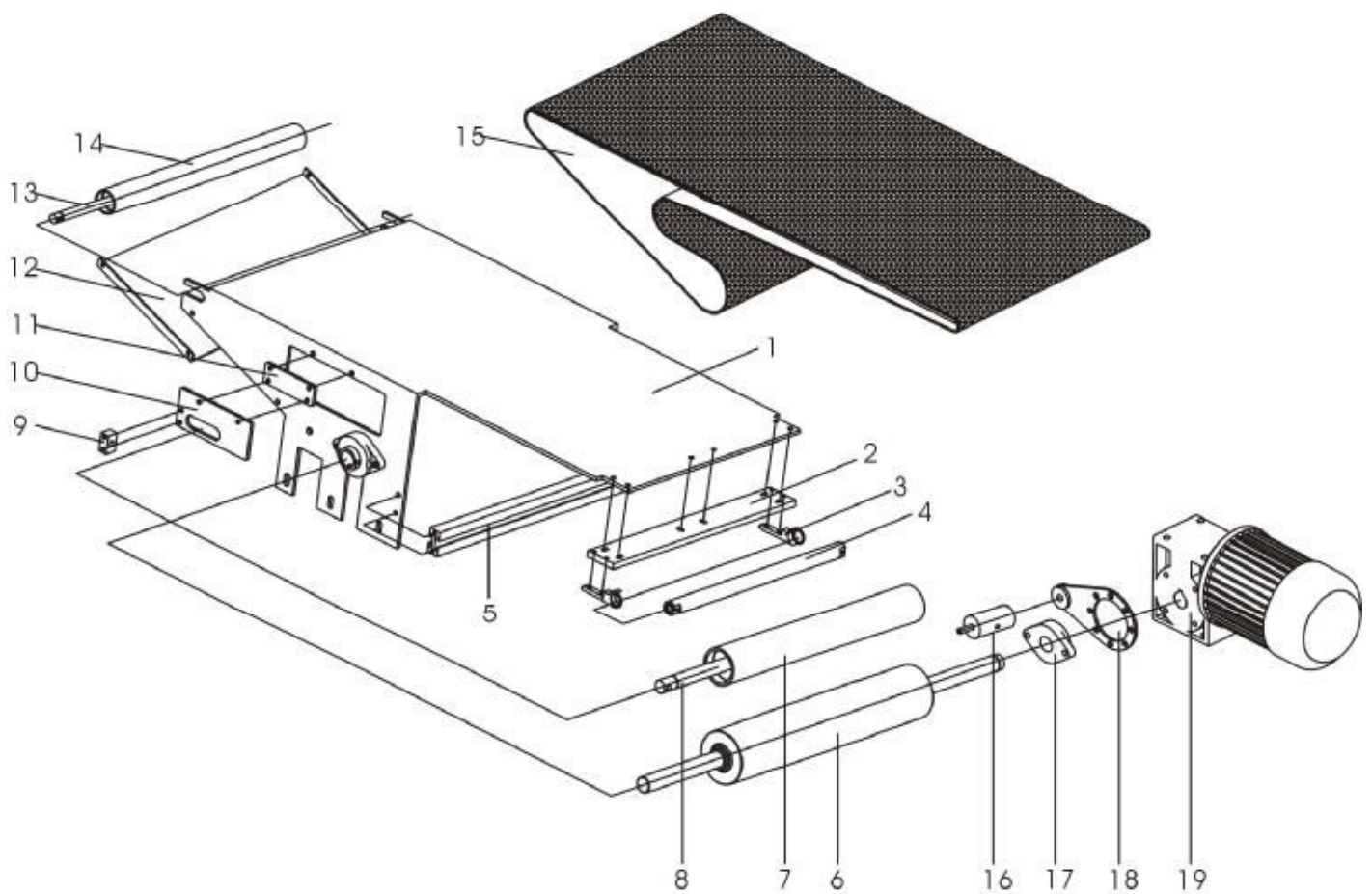
GPL-5545C part of disposing of film

1	motor for disposing of the film
2	setting board for motor
3	belt wheel 2
4	belt wheel 1
5	axletree seat
6	tray of wasted film
7	link board for tray of wasted film
8	link rack for tray of wasted film
9	tray of wasted film
10	adjust screw by hand
11	wheel
12	wheel axle
13	sway bar
14	mate weight rack
15	axle with seat
16	axle
17	wheel
18	rack
19	side cover board of chain
20	setting rack of wheel
21	wheel axle
22	wheel
23	wheel axle for disposing of film
24	spring for synchronization with tension



1	front convey rack
2	setting board 2 of front convey rack
3	setting board 1 of front convey rack
4	straight line axletree SC20UU
5	setting board 1 of axletree
6	setting board 2 of axletree
7	vertical axletree with seat
8	drive roll
9	above blocking board of belt
10	right rack of driven axle
11	left rack of driven axle
12	emergency setting box
13	setting box
14	auxiliary roll
15	below blocking board of belt
16	setting board of motor
17	hold board for above blocking board
18	fixing board of erector
19	fixing bar of erector
20	setting board for hand- wheel
21	screw
22	slip board of erector
23	backing board
24	brace
25	blocking board
26	above triangle board
27	blow triangle board
28	rack 1 of inducing switch
29	rack of inducin switch
30	driven axle
31	holding axle
32	emergent stop
33	screw
34	seat for holding film
35	branch bar for holding film
36	bar for holding film
37	screw cover
38	female screw
39	photoelectricity switch
40	hand- wheel
41	motor for conveyor belt
42	chain- wheel(diameter= 15- M6- 15)
43	chain- wheel(diameter=15- M6- 17)
44	axletree6200Z
45	beeline axletree
46	back conveyor

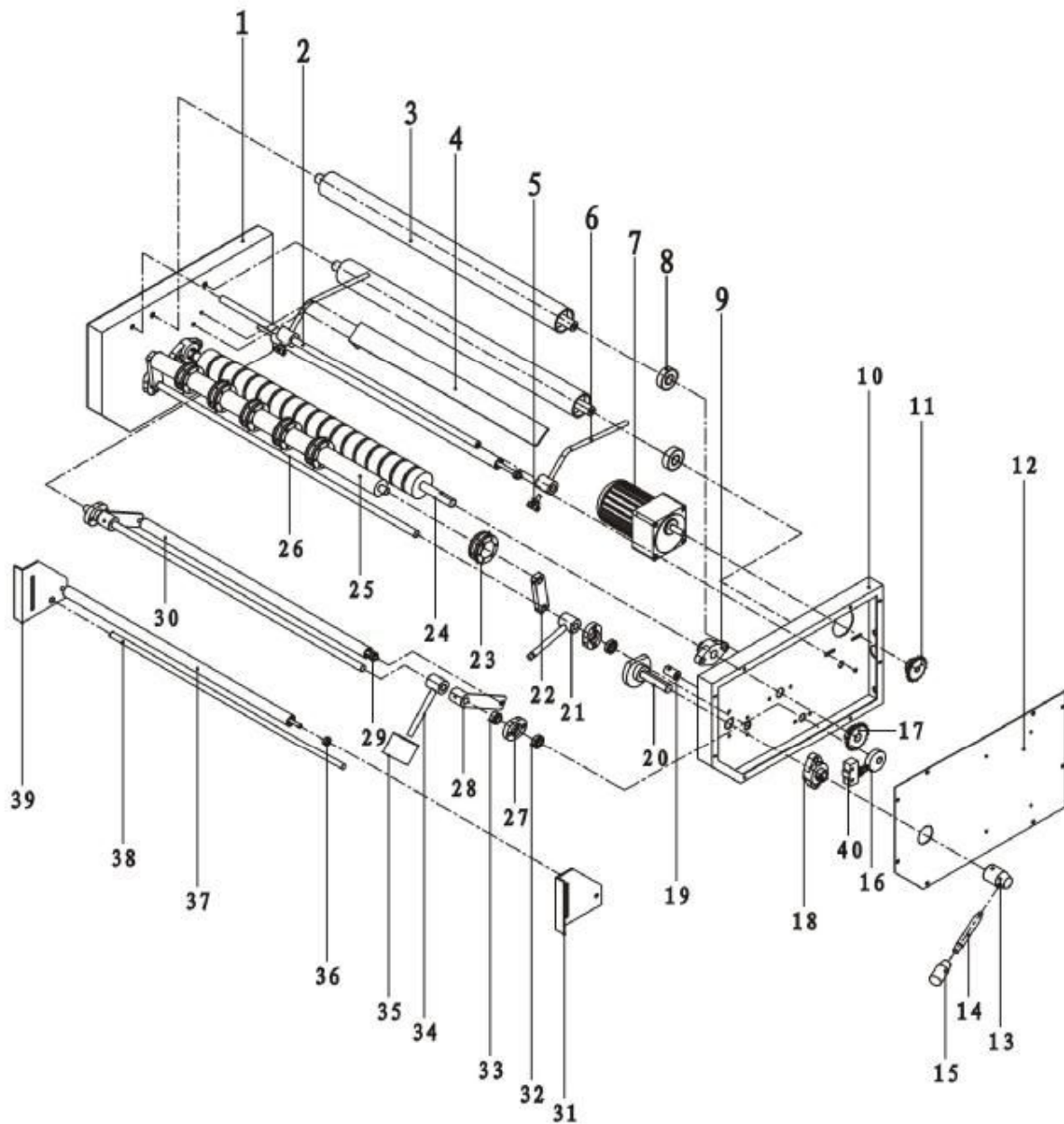




GPL-5545C OUT-FEED SYSTEM

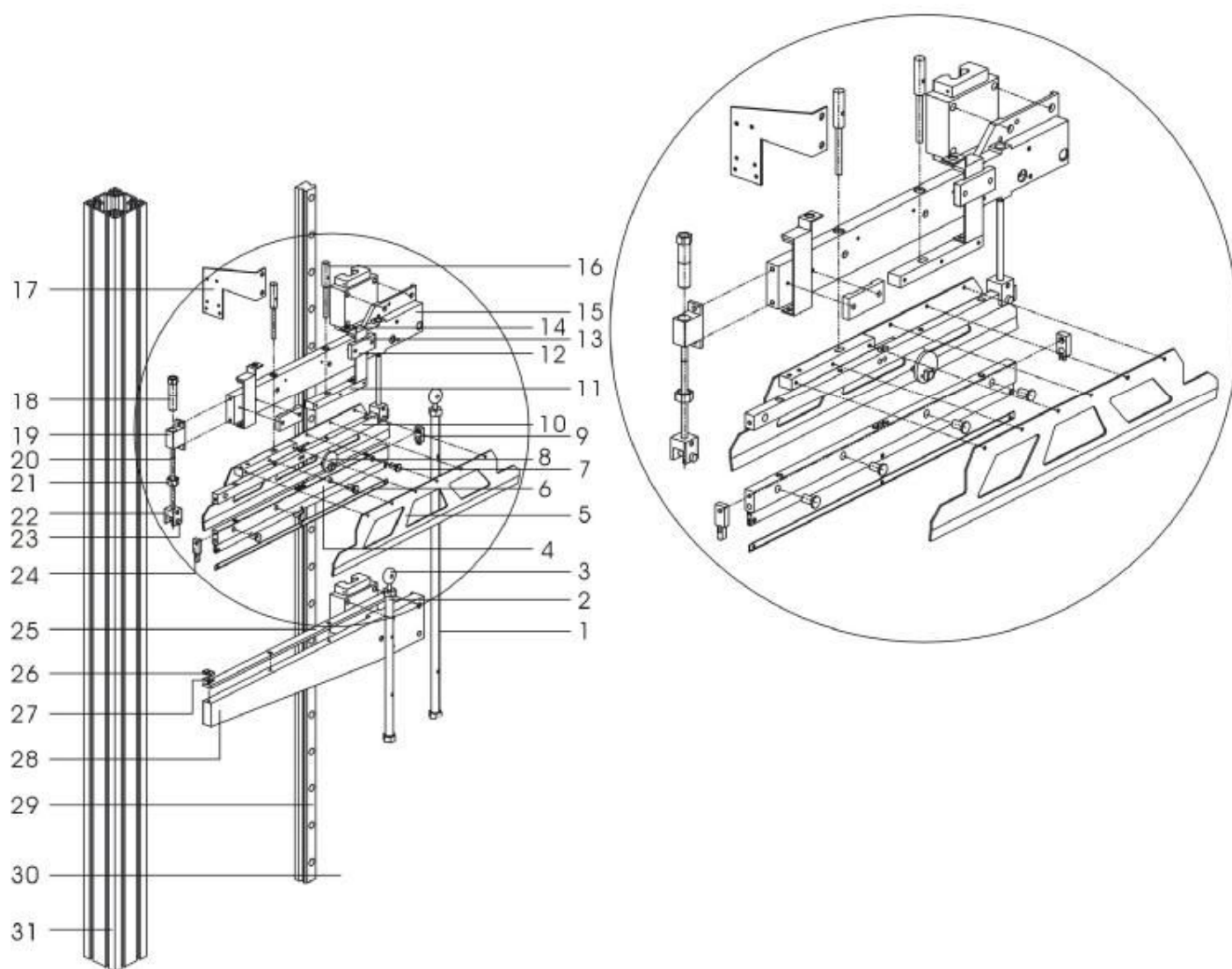


SN	Number	Name	Qty
1	BF01-05-002	board	1
2	BF01-05-013	rack of back wheel	1
3	BF01-05-004	axle rack of back wheel	2
4	BF01-05-014	back wheel	1
5	BF01-05-022	main rack	1
6	BF01-05-001	drive axle	1
7	BF01-04-008	tension axle	1
8	BF01-04-007	core of tension axle	1
9	BF01-05-005	tension block of tension axle	2
10	BF01-05-007	lower tension board of drive axle	2
11	BF01-01-071	upper tension board of drive axle	2
12	BF01-05-003	cover	1
13	BF01-04-009	core of end axle	1
14	BF01-04-010	end axle	1
15	WGBZ022	belt	1



GPL-5545C part of sending film

1	left rack
2	guide bar/IV
3	roll 1
4	blocking board
5	adjust screw by hand
6	bar for fixing film
7	motor
8	axletree
9	axletree with seat
10	right rack
11	chain- wheel(diameter= 10, tooth= 15)
12	cover of right rack
13	link bar of hand- wheel handle
14	hand- wheel handle
15	plastic heat of hand- wheel handle
16	eccentricity wheel
17	chain- wheel(diameter= 15, tooth= 17)
18	axletree with seat
19	bar for pulling spring
20	hand- wheel
21	link bar for pulling spring
22	link board
23	pinhole equipment
24	axle 2 of pinhole equipment
25	axle 1 of pinhole equipment
26	guide bard IV
27	fixing block of guide bar V
28	rotate board
29	axletree619/ 6Z
30	guide bar 2
31	guide bar 3 rack 2
32	axletree61901Z
33	guide bar V limit block
34	slide bar
35	cover of slide bar
36	axletree 61900Z
37	guide 2
38	guide 3
39	guide bar 3 rack 1
40	micro- drive switch

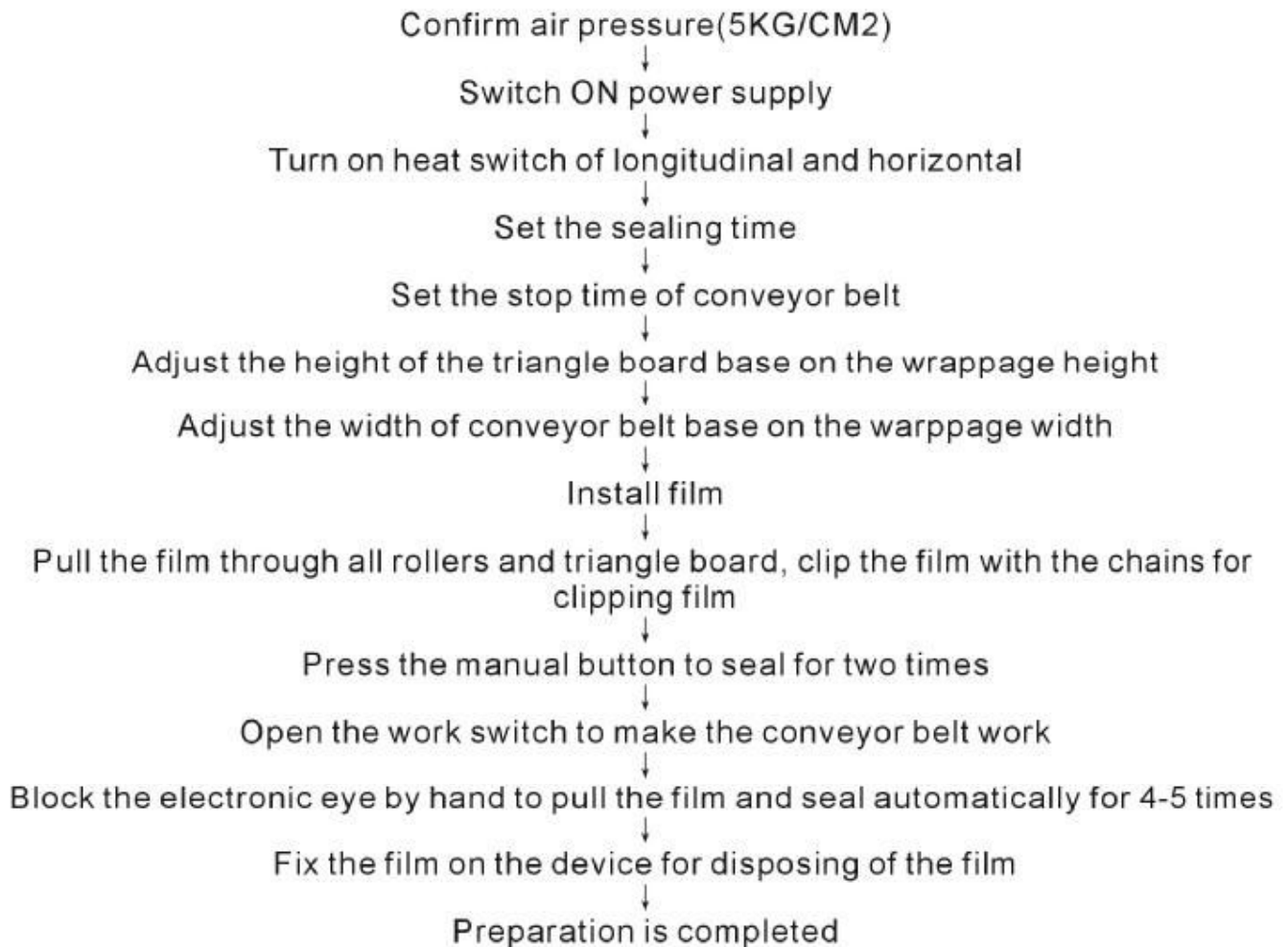


GPL-5545C T.D. BLADE SYSTEM

SN	Number	Name	Qty
1	BF01-02-014	moving arm 1	1
2	BF01-02-015	moving arm 2	1
3	WGBZ006	switch axle gearing	4
4	BF01-02-049	blade seat	1
5	BF01-03-036	safety cover	2
6	BF01-02-050	horizontal blade	1
7	BF01-02-034	safety screw	4
8	BF01-02-035	male rotor	1
9	BF01-02-039	rack of thermocouple and heater	1
10	BF01-02-032	brace bar of the blade seat	1
11	BF01-02-023	photo electricity block	2
12	BF01-02-038	safety cover of the approach switch	2
13	BF01-02-024	photo electricity rack	2
14	BF01-02-025	silicon rubber for antihunt	2
15	BF01-02-019	fixing board	1
16	BF01-02-022	connector bar	2
17	BF01-02-040	fixing board of inserter	1
18	BF01-02-026	cover of balance adjustable axle	1
19	BF01-02-021	fixing block of cover of adjustable axle	1
20	BF01-02-029	adjustable axle	2
21	BF01-02-027	screw of adjustable axle	1
22	BF01-02-028	adjustable fixing rack	2
23	BF01-02-037	adjustable screw	2
24	BF01-02-033	close head of the rack	1
25	BF01-02-042	under block	1
26	BF01-02-044	plastic block	2
27	BF01-02-043	wood block	2
28	BF01-02-041	fixing board	1
29	WGBZ007	slide bar	1
30	WGBZ008	slide block	3
31	WGBZ009	80*80 aluminum bar	1

## V. Preparation for running

---





## Operating instructions

### I. Preparation for opening the machine.

- 1) Switch on power supply: AC220V 50-60Hz.
- 2) Use industry safety power supply.
- 3) Connect to the dryness and filtration air source.
- 4) Make sure the good situation of equipment, for example safety door is closed, sealing knife is safe and detection device is good and soon.

### II. Process for opening the machine.

- 1). Turn on the switch 1 of power supply, indicator 2 of power supply lights.
- 2). Turn on the heat switch 12 of horizontal sealing, indicator lights; Controller 4 of horizontal sealing works.
- 3). Turn on the heat switch 13 of longitudinal sealing, indicator lights; Controller 5 of longitudinal sealing works.
- 4). Set the suitable temperatures through controller 4 of horizontal sealing and controller 5 of longitudinal sealing.
- 5). Set the sealing time 6, front rest time 7 of in-feed, back rest time 8 of out-feed.

[VERTI]: vertical detection.

### III. Manual operate

- 1) After above processes are completed, choose the switch 17 of Man/Auto, [MANUAL]: manual operate.
- 2) Detection mode, front rest time of in-feed, back rest time of out-feed don't work in manual mode.
- 3) Keep pressing the button 14 of [Manual Film Feeding], conveyor belt of out-feed and chains for clipping film run; Loosen the button, they stop. Debug for installing film can be made.
- 4) Keep pressing the button 15, close backs and sealing knife goes down; Loosen the button 9, sealing knife goes up and close is forward.

### IV. Automatic operate

- 1). Attention, Set the detection mode, sealing knife, front rest time of in-feed, back rest time of out-feed.
- 2). The switch 17 of [MAN/AUTO]→[AUTO], indicator lights.
- 3). The button 15 of [Manual seal] doesn't work in automatic mode.

#### 4). Process of automatic operating

The switch of [Manual/Auto]→[Auto], the machine starts to run, and conveyor belt of in-feed and out-feed runs. Put the wrappage on the conveyor belt of in-feed, wrappage is forward, after detection switch induces the wrappage, chains for clipping film run, back rest time of out-feed start to time. Chains for clipping film stop when it is time for the back rest time of out-feed; Sealing knife goes down. Sealing time starts to time. It is time for the sealing time, sealing knife goes up and the chains for clipping film run, the front rest time of in-feed starts to time. It is time for the front rest time of in-feed, the chains for clipping film stop. One work circle is completed.

If choose the hispeed mode, when it is sealing, next wrappage will stay at its detection device on arrival, and wait for next circle.

#### V. Alarm or abnormality solve

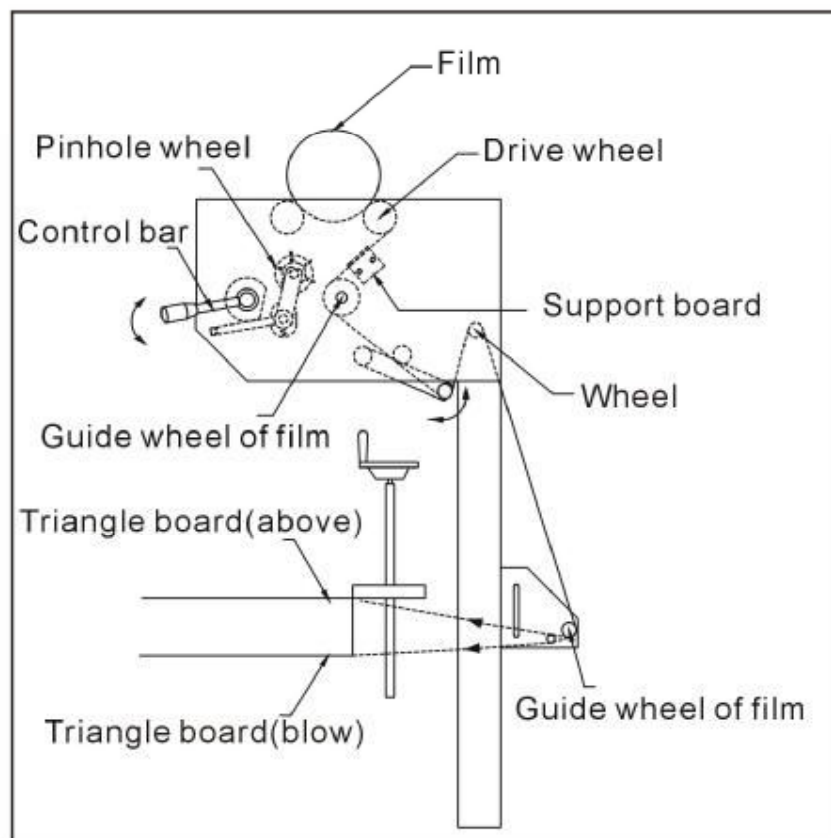
- 1). The wrappage is sealed, or the wrappage is under the sealing knife when the sealing knife is going down. Alarm indicator 3 lights, all activity stop.
- 2). Press the emergency button immediately when some problem happen. Alarm indicator 3 lights. All activity stop at the same time.
- 3). After three work circles are completed in automatic mode, the motor for disposing of film still runs, indicator 3 lights. All activity stop. Maybe the film is cut, or wrappage switch has problem.
- 4). Don't press the button 3 of alarm reset immediately when above problems happen. Turn the button 17 from [Auto] to [Manual]. Press the button 3 after solve all problems. Restart the emergency button if the button is pressed.

## VI. Installing film

Make sure the [stop] is pressed.

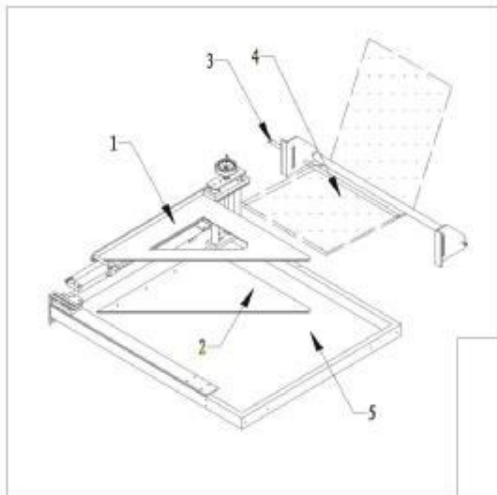
Our technical person will help you install the film when the machine arrives at your company.

- 1). Put the film on the two rolling wheels under the machine.
- 2). Loosen the handle of pinhole equipment in order to separating pinhole wheel and axel.
- 3). Pull the film through all rolling wheel according to the below chart.
- 4). Make the pinhole wheel reach to the original position.
- 5). Pull the film for about one meter, film cross triangle diverter form belt conveyor.

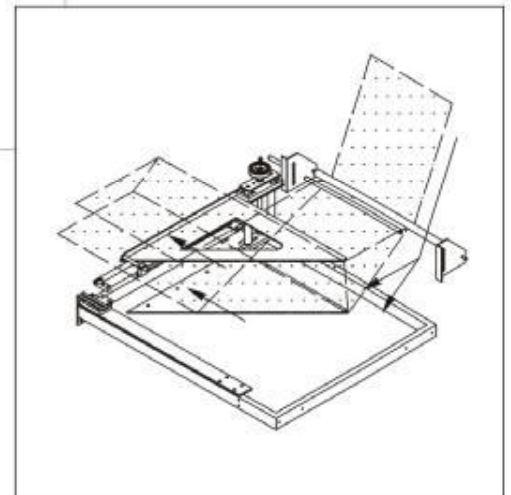
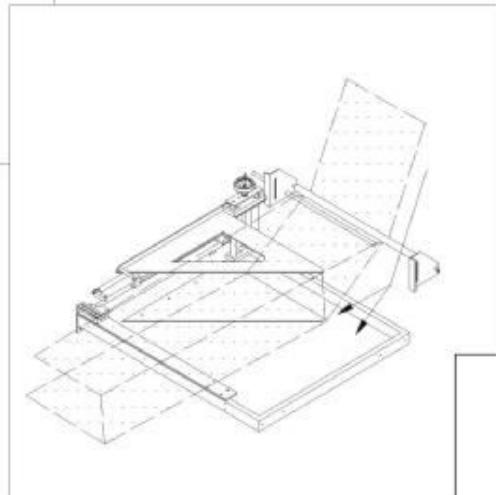


**Film cross the triangle diverter according to the below chart**

- 1). Load the film on the triangle diverter
- 2). Fold the film back-forward to the conveyor belt
- 3). Cross the above triangle diverter by left hand, then cross the below triangle diverter
- 4). Pull out the folded film, and fix the film between the wheel and belt for clipping film



1. Above triangle board
2. below triangle board
3. Static bar
4. guide wheel for film
5. conveyor belt





## VII. Running process

1). After opening the power switch, adjust the temperature to reach to the suitable Temperature.

Maybe temperature difference exists for the indoor temperature and the filmthickness.

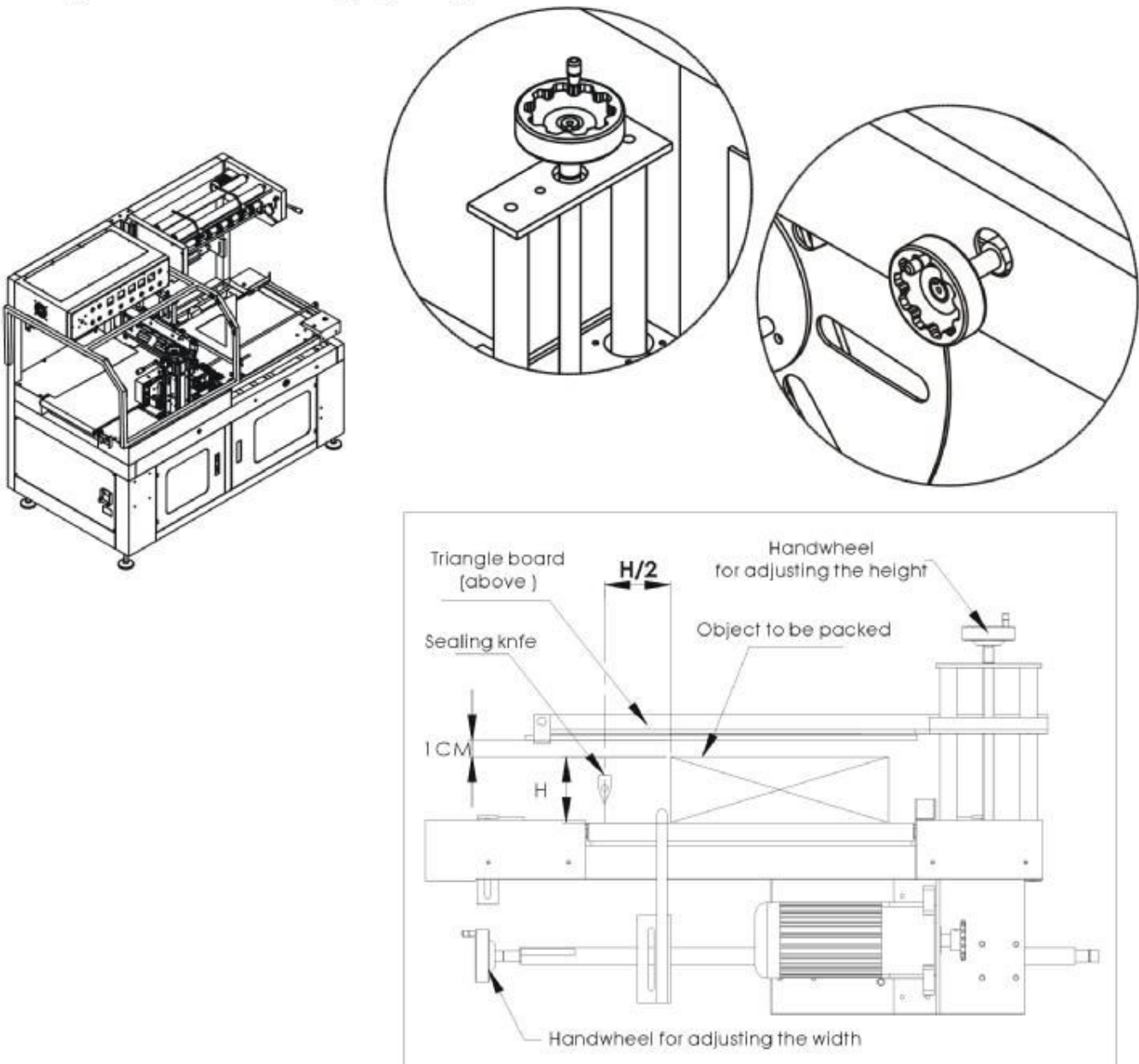
Longitudinal sealing knife ( $150^{\circ}\text{C}$ --- $180^{\circ}\text{C}$ ), horizotal sealing knife ( $150^{\circ}\text{C}$ --- $180^{\circ}\text{C}$ ), sealing time (0.8---1.5 second)

2). Adjust the triangle diverter height base on the wrappage

Adjust the width by hand-wheel, adjust the height by hand-wheel on the triangle diverter.

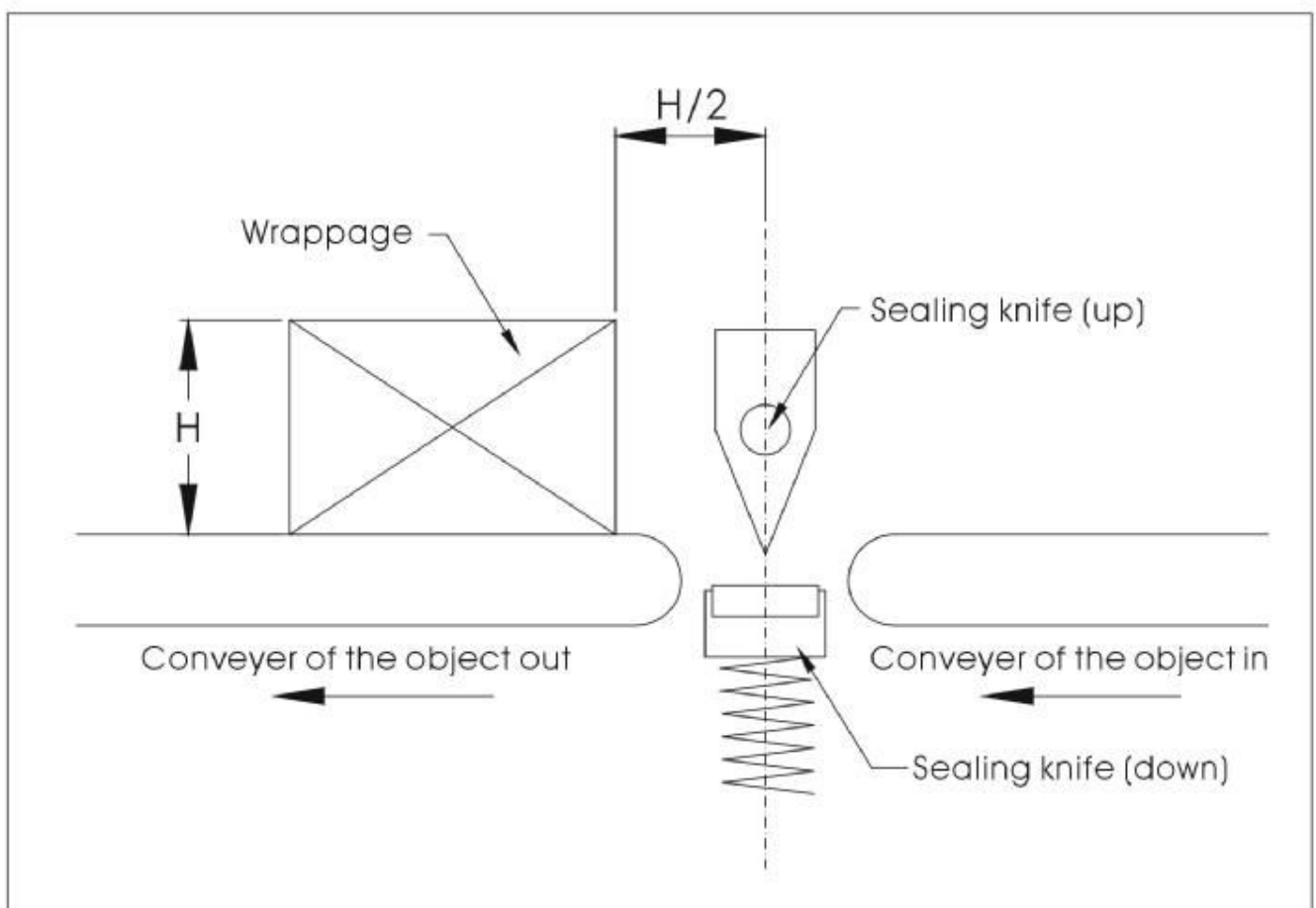
The distance is 1cm between the triangle diverter and the wrappage.

3). The distance between the position wrappage stops and the middle line of horizontal Sealing knife is half of the wrappage height



- 4). The distance between the position wrappage stops and the middle line of longitudinal sealing knife is half of the wrappage height.
- 5). Set the prepare length of the film if the wrappage height is more than 6cm.
- 6). After the wrappage width is set, install the film according to the installing film
- 7). Pull the film to clip the film by the chains for clipping film.
- 8). Open work switch, open conveyor belt.

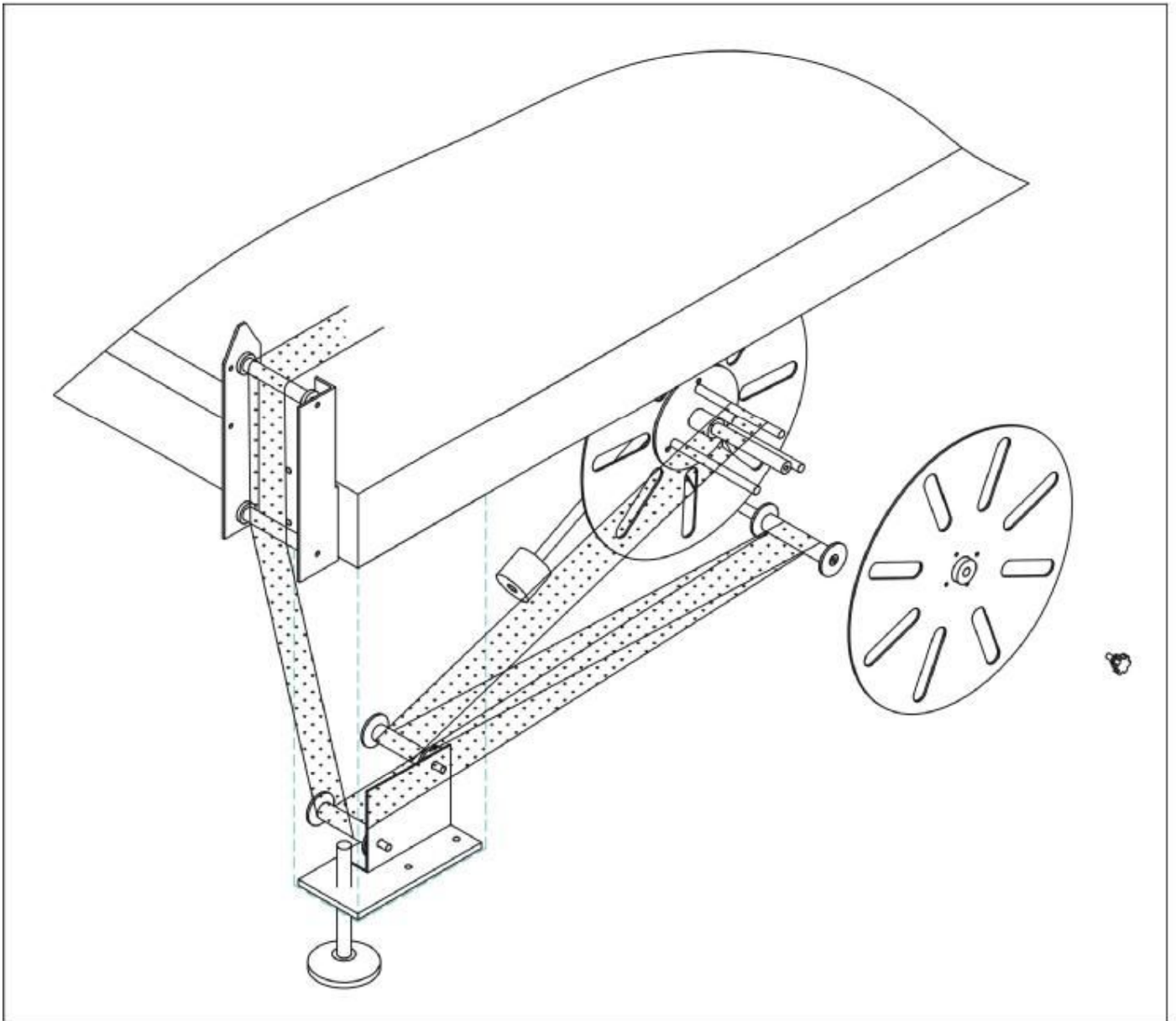
Setting chart of stopping of wrappage





## VIII. dispose of wasted film

- 1). After the machine starts, seal for several times to make sure the wasted film reach to 1m, then fix the wasted film on the rolling wheel.
- 2). Take out all wasted film when the wasted film is full in the rolling wheel.



## IX. Safety device

---

Safety device protect the machine from any harm. Sealing knife will come back if the package stops under the sealing knife . Conveyor belts don't have safety.

After the faults are repaired, the machine works again if you press the work switch

## X. Maintenance

---

Please follow the below terms to make sure the machine seals completely for long-term Use.

1). Clear the sealing knife by soft cloth after working.

Clear the sealing knife when the temperature is more than 70?, or the sealing knife may be broke.

2). After clearing the sealing knife, daub the sealing knife by soft cloth with cleanness ointment

3). Changing the sealing knife when the sealing knife is broke.

4). Air pressure device

4-1 discharge the wasted water

1) wasted water is discharged before it reach to the metal block board.

2) wasted plunger of the bottle bottom turns on, wasted water is discharged, pressing2)e plunger may result in plunger can't come back.

In case of plunger can't come back, unload the bottom device of the bottle and press the plunger from up to down.

4-2 adjust the air pressure

1). damper valve is turn right, then the air pressure will go up.

2). after setting the air pressure, please fix the damper valve.

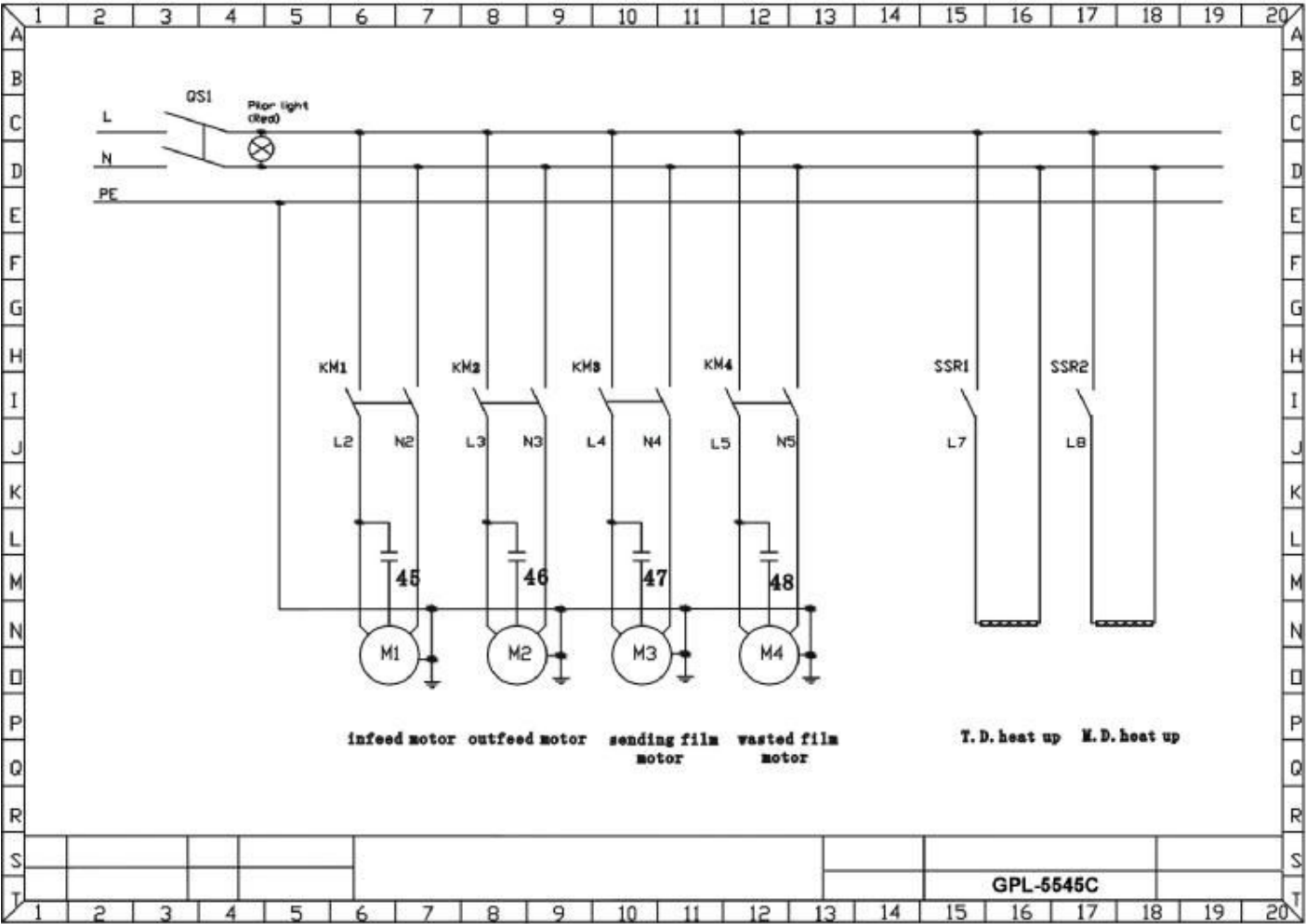
4-3 unpack

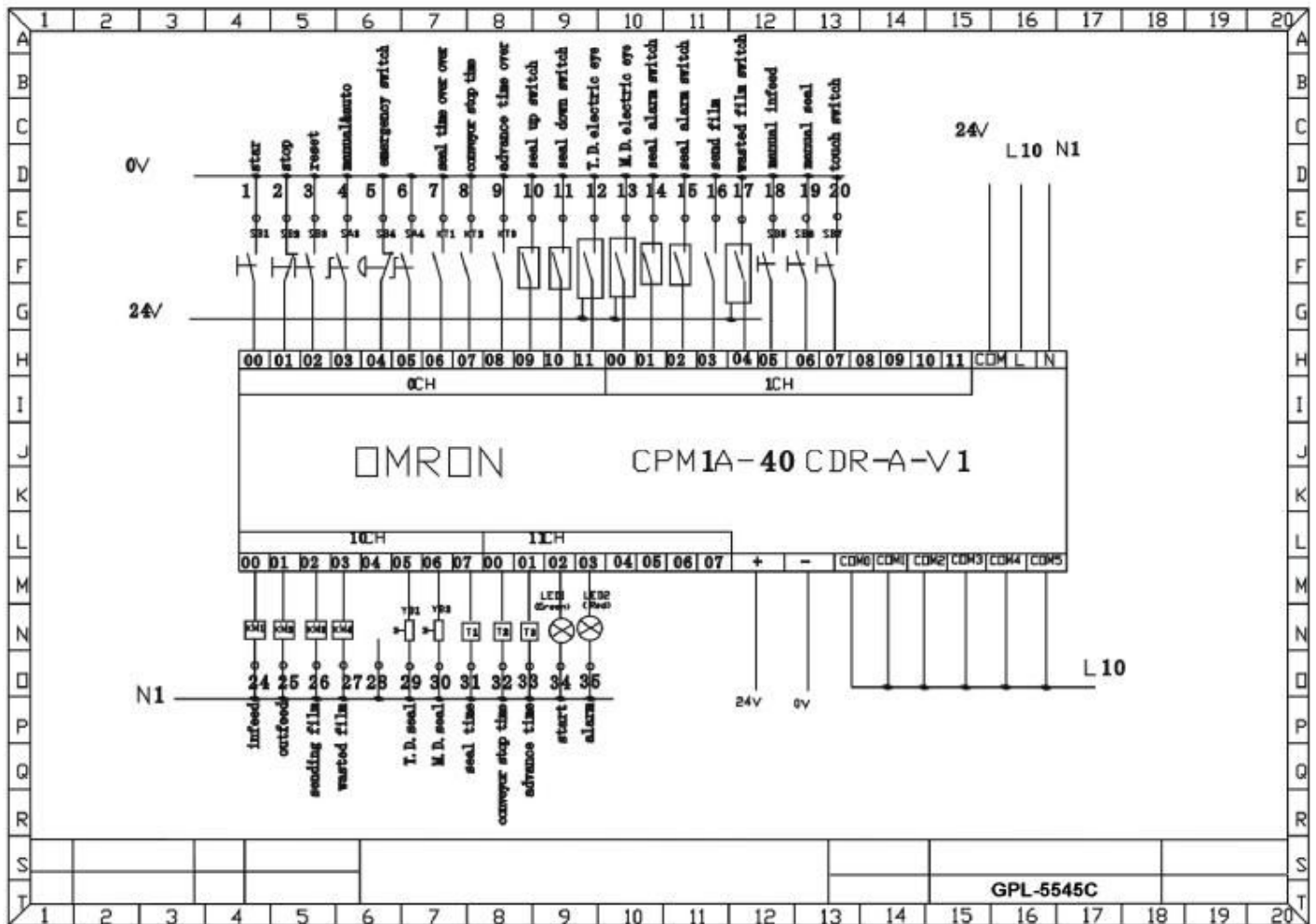
1). close the air source

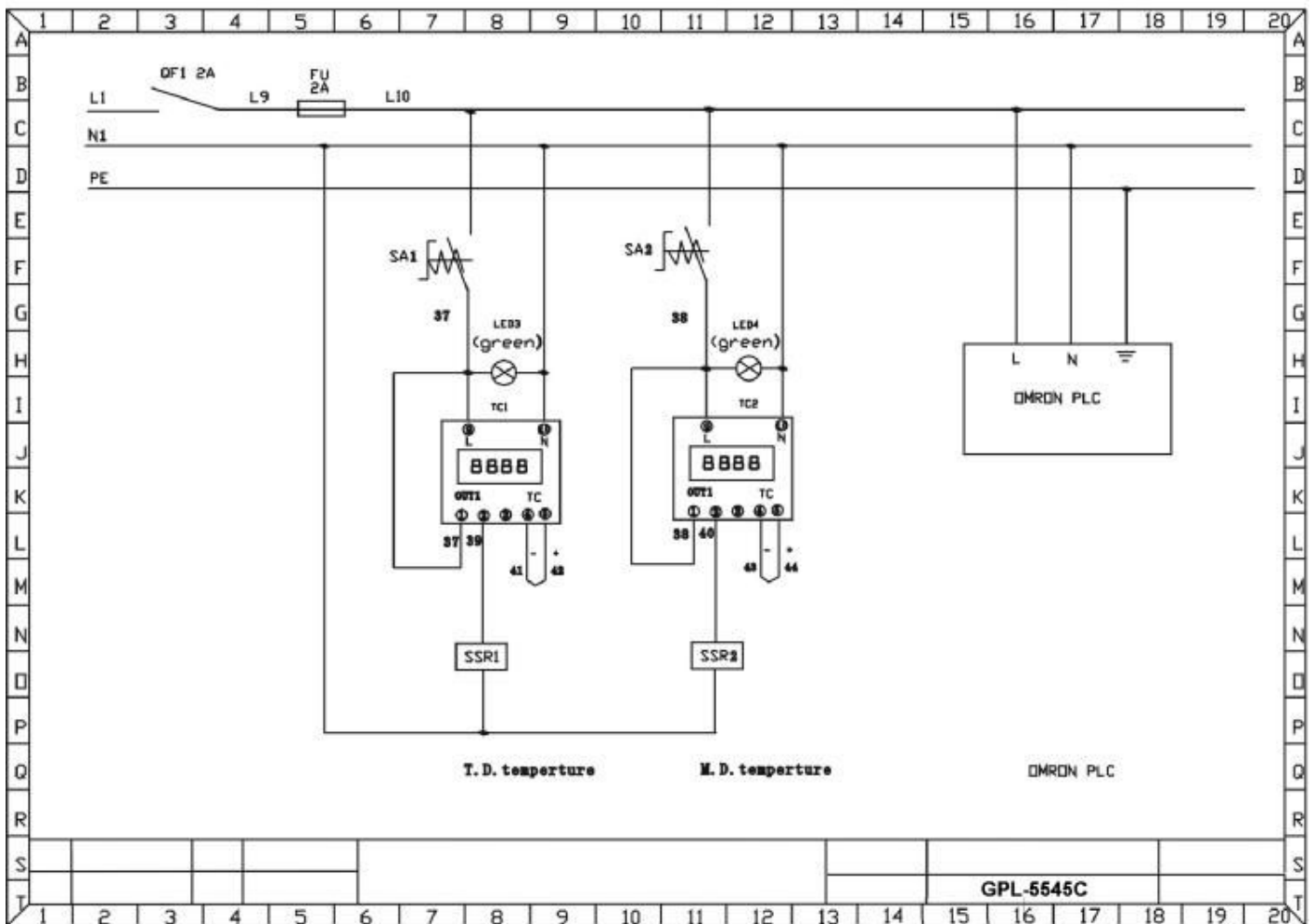
2). loosen the four screws, backplate, spring and so on.

3). unpack the plastic broad-bottom plate, block board and so on.

4). take out bolt, spring, filler of piston and so on.







## **XII.Attention on the operating**

---

- 1.Do not put hand under the sealing knife when the machine is running.
- 2.Conveyor belt should go from right to left. The film would not roll out if go backward.
- 3.Turn off the power when any problem happen. After fixing, please use manual mode to Operate, then turn on the automatic mode.



## XIII. Troubleshooting1

phenomenon	reason	repair fault
1. control box power indicator light breaks control switch jumps	power is close	open the power
	fixed fuse is cut	change the accessory
	switch is bad	
	electric lines break	
	connection of the electric lines is bad	confirm electric heat lines
	power leaks	confirm all electric lines
2. conveyor belt belt moves if you push the belt belt doesn't move if you push the belt belt doesn't move in normal situation	tension of the belt is too loose	adjust the tension screw
	tension of the belt is too tight	adjust the tension screw
	motor gear is bad	change the accessory
	chain is too tight	adjust the chain
	electric lines break	change the accessory
	motor is bad	
	socket head of the electric lines is bad	
	decelerator is bad	
	micro-drive switch is bad	
3. film rolling wheel of sending film doesn't move direction of the moving film is not correct. Film doesn't move	electric lines break	change the accessory
	motor is bad	
	decelerator is bad	
	break box is bad	
	setting position of the film is bad	adjust
	film tension bar is not horizontal	
	the position of the tight rolling wheel is not correct	
	angle of the triangle diverter is bad	
	it is loose between pinhole rolling wheel and axle	adjust the spring
	the rolling wheel of the film is bad	add oil
	the chain tension of clipping film is too tight	adjust
	the chain tension of clipping film is too loose	
	oil is little	add oil
4. sealing arm sealing arm doesn't move sealing arm goes up at once when it is going down. Sealing arm goes down at once when it is going up.	electric lines break	change the accessory
	decelerator is bad	
	electromagnetism head is bad	
	air pressure is not full	confirm the air-pump
	safety device does that	
	response of safety device is too fast, but the sealing time is short	adjust the micro-drive switch of safety device and the micro-drive switch of safety changing.
	horizontal and longitudinal mistakes of electric eyes	adjust, clean
	electric eyes are not clear	adjust
	the time of micro-drive switch pressed is wrong	

## XIII. Troubleshooting2

phenomenon	reason	repair fault
5. sealing temperature doesn't go up. Temperature can't be adjusted. safety device doesn't work. Don't seal by manual sealing mouth is bad	fixed fuse is cut	change the accessory
	electric heat lines is cut	
	decelerator is bad	
	power is 1 pin	
	temperature controller is bad	change the accessory
	temperature heat detector is bad	
	electric lines break	change the accessory
	Jiggle switch is bad	adjust
	block board can't press the micro-drive switch	
	electric lines break. Air pressure is not full	change the accessory
	Jiggle switch is bad.	
	Decelerator is bad.	
	air pressure is not full	confirm the air pressure
	sealing knife is bad	change the sealing knife
	temperature is too low	adjust
	sealing time is too short	confirm
	air pressure is weak.	
	electric heat of sealing knife is bad	change it
6. dispose of wasted film chains of clipping film don't move. The wheel of rolling wasted film doesn't move. wasted film is cut when rolling the wasted film.	electric lines break	change the accessory
	motor is bad	
	deteractor is bad	
	brake box is bad	
	socket head of the electric lines is bad	
	chain is too tight	adjust
	chain is too loose	
	no oil	add oil
	elcetric lines break	change the accessory
	motor is bad	
	fluent of the film is not good	adjust the spring, add oil adjust
	the belts of clipping film is not fitted	
7. the action is wrong	voltage is too low	confirm the voltage of the power
	power is one pin	
	connection of the electric lines is bad	
	lines connected is not good	connecte with the lines again

## XIV. Packing list

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NO	NAME	QUANTITY	REMARK
1	machine	1 set	
2	hight temperature frictiontape	1 pcs	
3	tool box	1 pcs	
4	manual	1 pcs	
5	cap screw driver	1 set	
6	shifting spanner	1 pcs	
7	screw driver of crossing	1 pcs	
8	conformity certification	1 pcs	