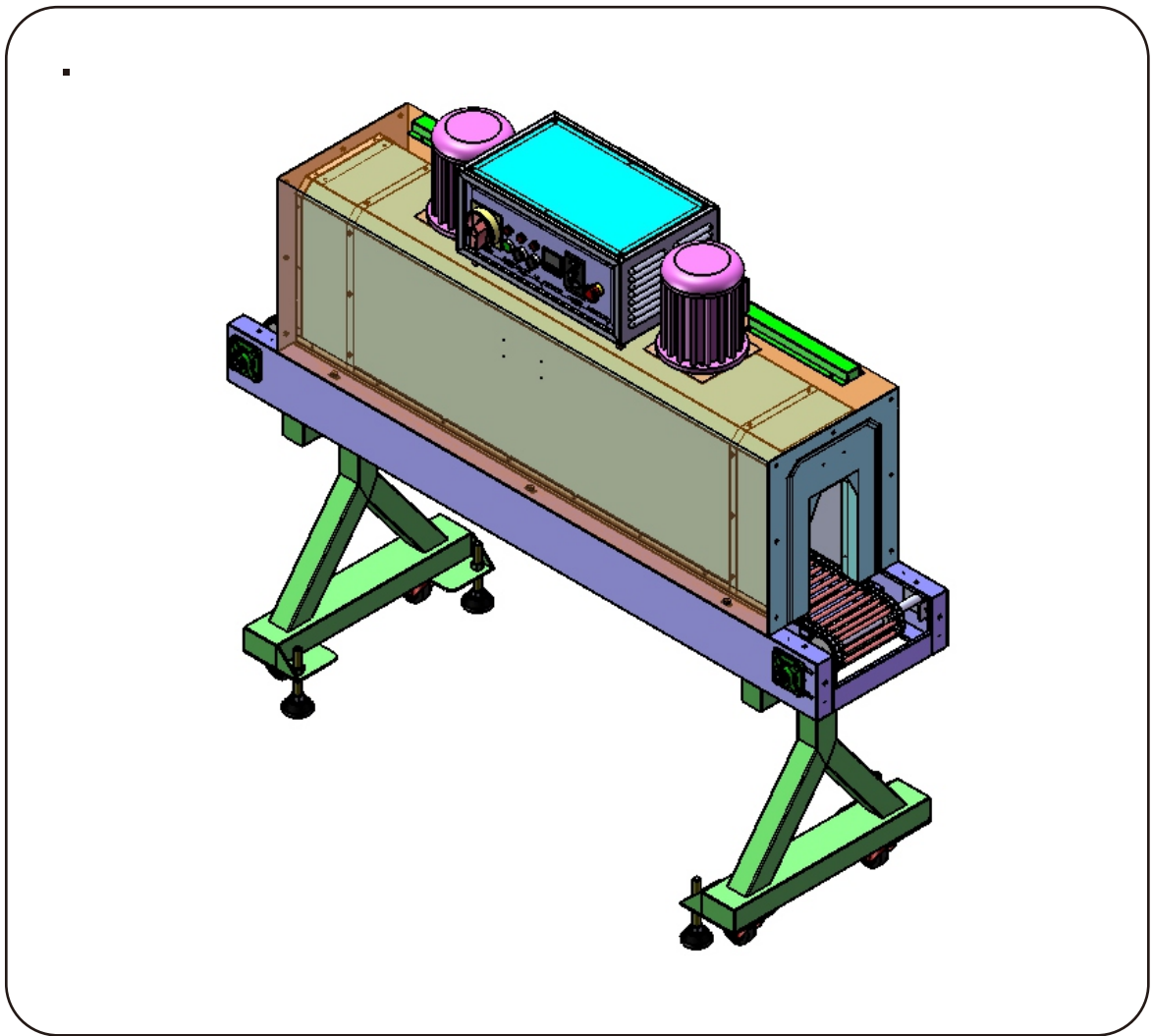


Manuals

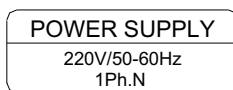
Label Shrink Tunnel



※ Please read this manual carefully before operate the machine.
※ If there are any technical changes, we reserve our rights to inform.

Safety Signs

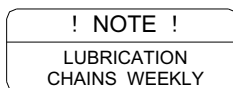
Please note below signs when operate the machine



Power supply specification must be
1 phase AC220V 50/60Hz



Beware of high temperature



Lubricate the chains weekly



Beware of electric shock
Non-electrical professionals do not open



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1, Preface


Summary


Thank you for using our products, you are using a safe, practical and efficient constant temperature shrink packing machine. The machine adopt high quality carbon steel or stainless steel, with reasonable structure and re-design incorporating advanced cooling technology to ensure good shrinking effect. It is widely used in beverage, household appliances, metal, plastic and other industries. Product packaging is beautiful, moisture-proof, dust-proof, which greatly improves the product and brand image.

Readers' Guidance

- A) Please read the manuals carefully before operate the machine.
- B) The manuals is the full description of the product, please keep it with the machine.
- C) Please do not delete or revise this manuals
- D) We reserve our right to revise this manual owing to continuous machine improvement.

Precautions for safety and use :

 No other breakers or electricity wires without the equivalent capacity to this machine are allowed. Any usage of the breakers with smaller capacity or electricity wires with smaller diameters will cause damage of the circuit and major components.

 Liquid materials , when packaged , shall not leak. Any usage of this machine to seal the poorly-sealed liquid materials may cause damage of the machine or electric shock



Do not use machine in a highly humid environment;

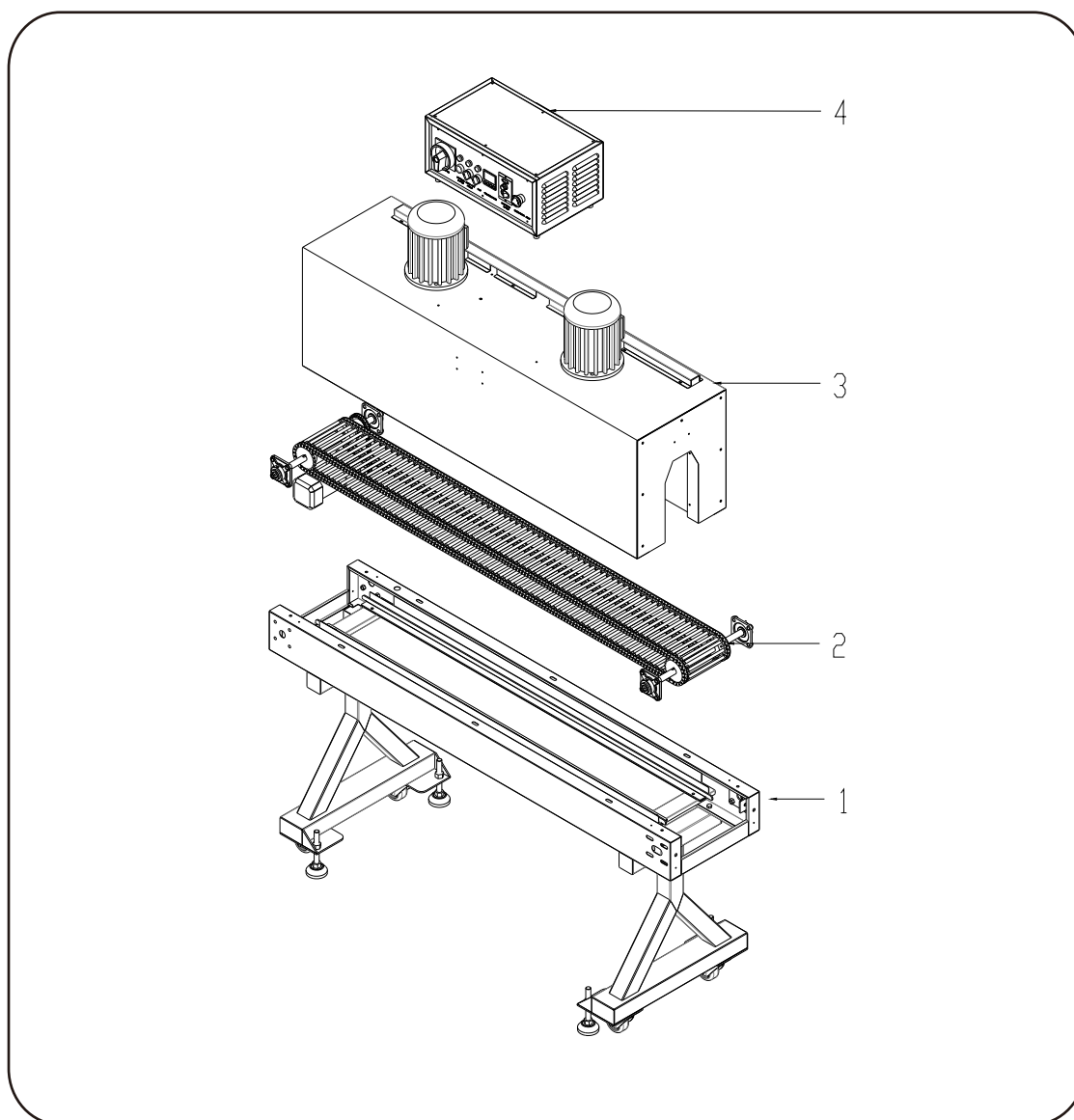


Do not use or place this machine in a dusty places,

© The use of the machine will wear out such components as heating tube, conveyor rollers, etc. Therefore, make proper reservation for such consumable parts. Power off before replacing parts according to right steps.

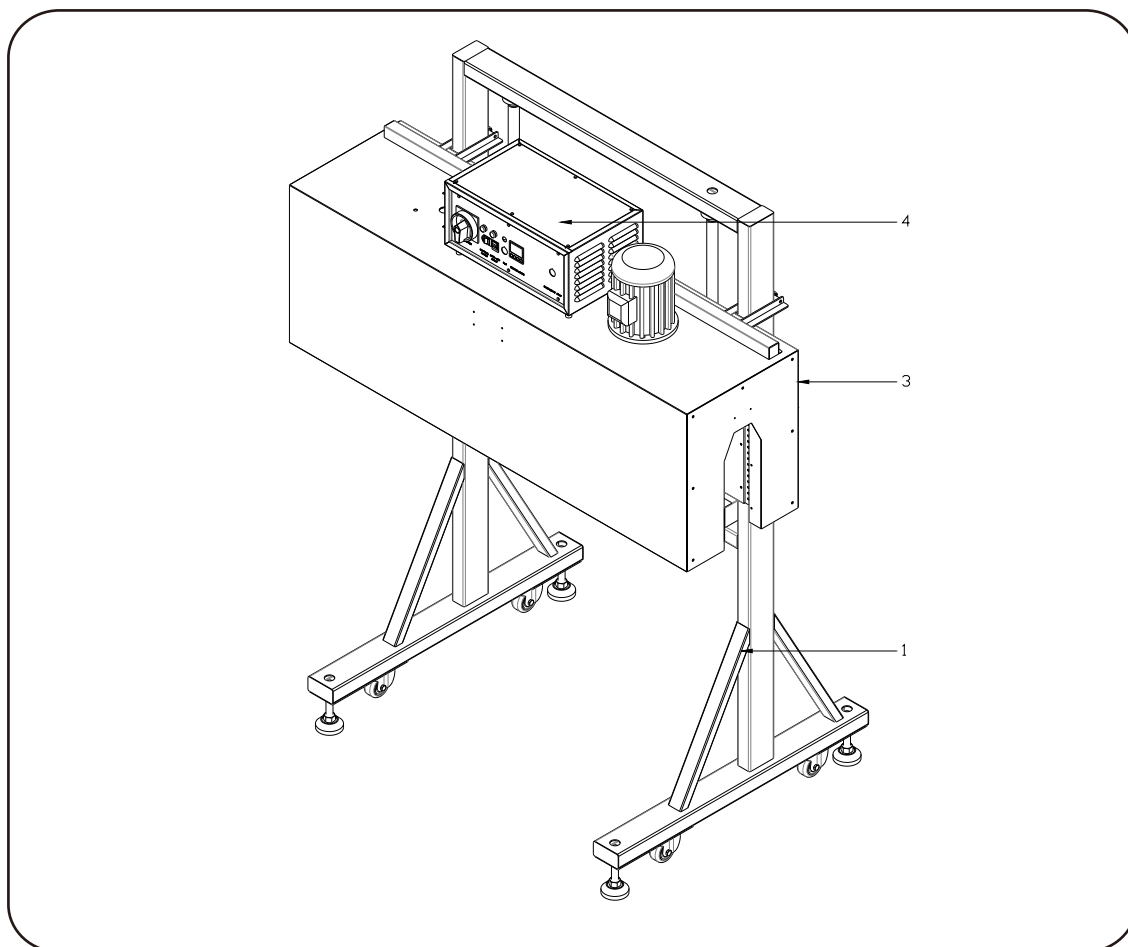
2, Parts

◆ General Assembly Drawing (SM-1230)



Code	Name	Quantity
1	Machine Frame	1
2	Conveying System	1
3	Blowing and Heating System	1
4	Electronic Control System	1

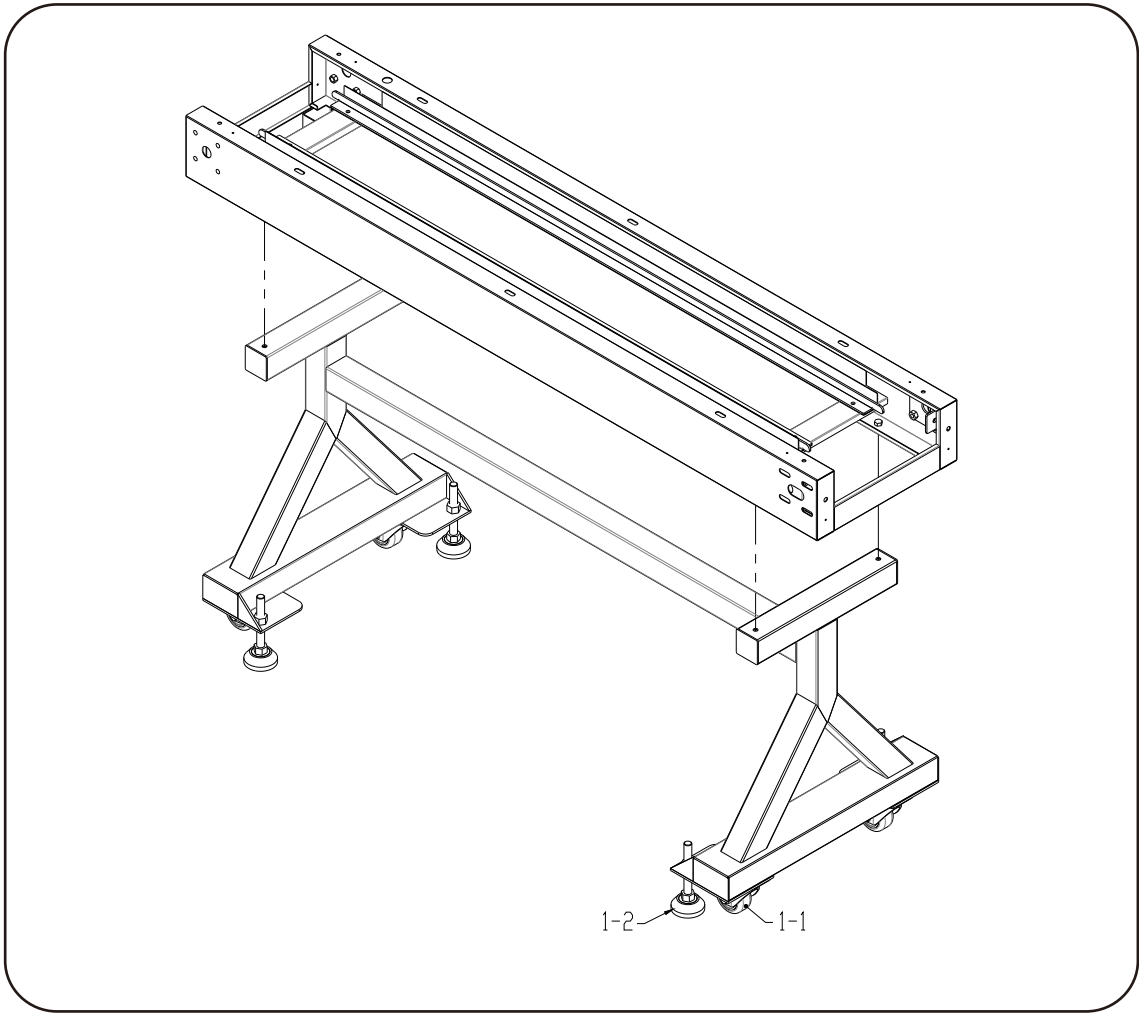
◆ General Assembly Drawing (SM-1230X)



Code	Name	Quantity
1	Machine Frame	1
2	/	1
3	Blowing and Heating System	1
4	Electronic Control System	1

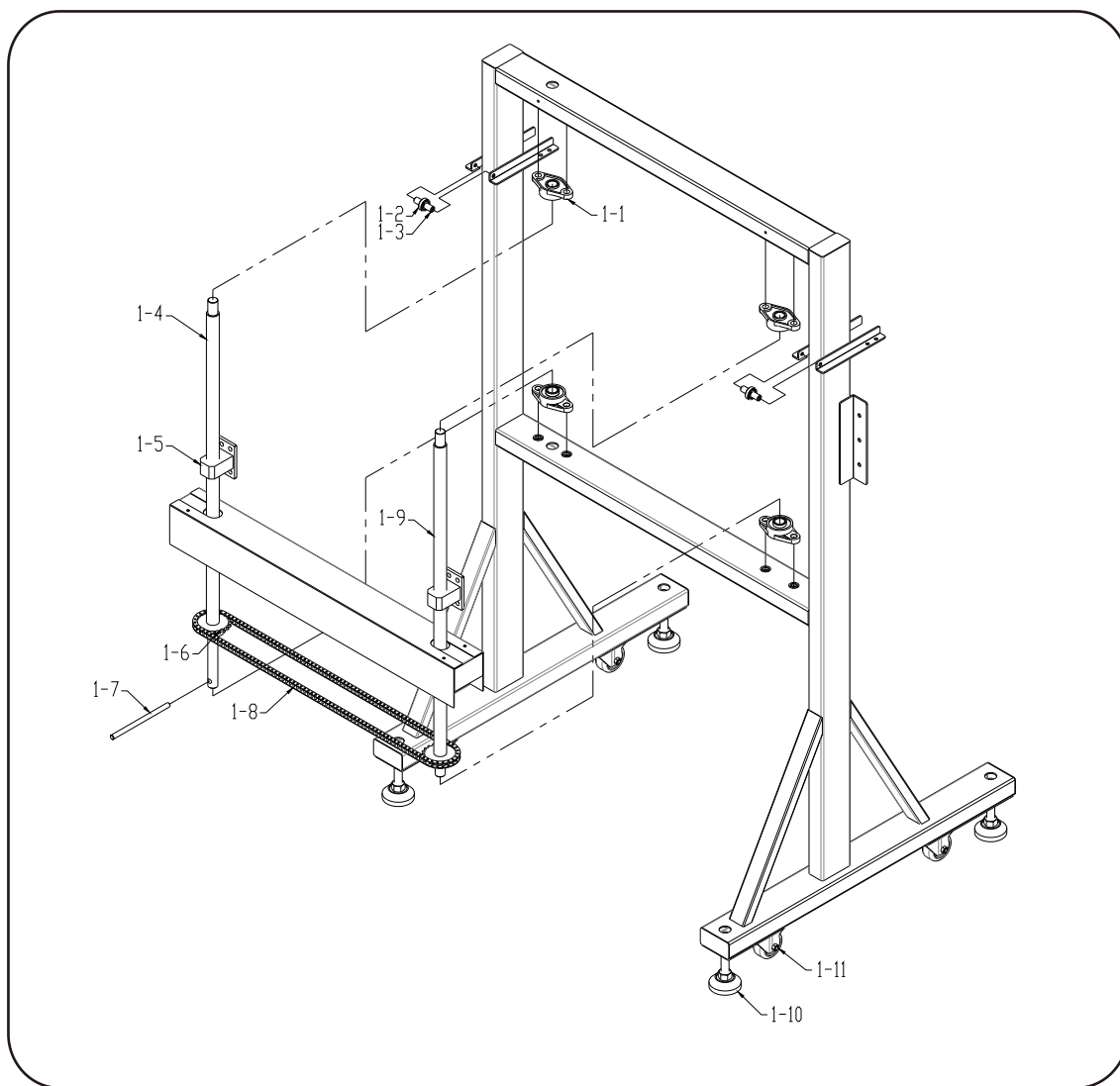


◆ Frame (SM-1230/2020/2535)



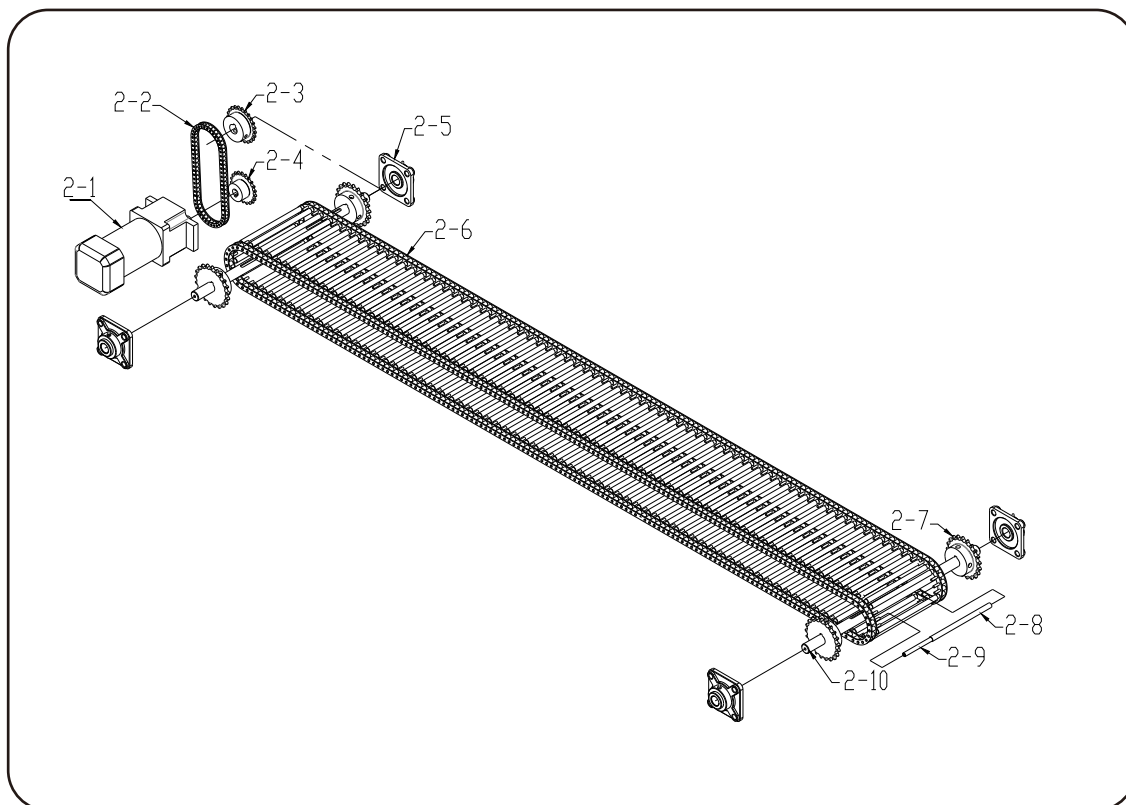
Code	Drawing No.	Name	Quantity
1-1	S4-3305-351	Castor	4
1-2	M16X150	Anchor Bolt	4

◆ Frame (SM-1230X)



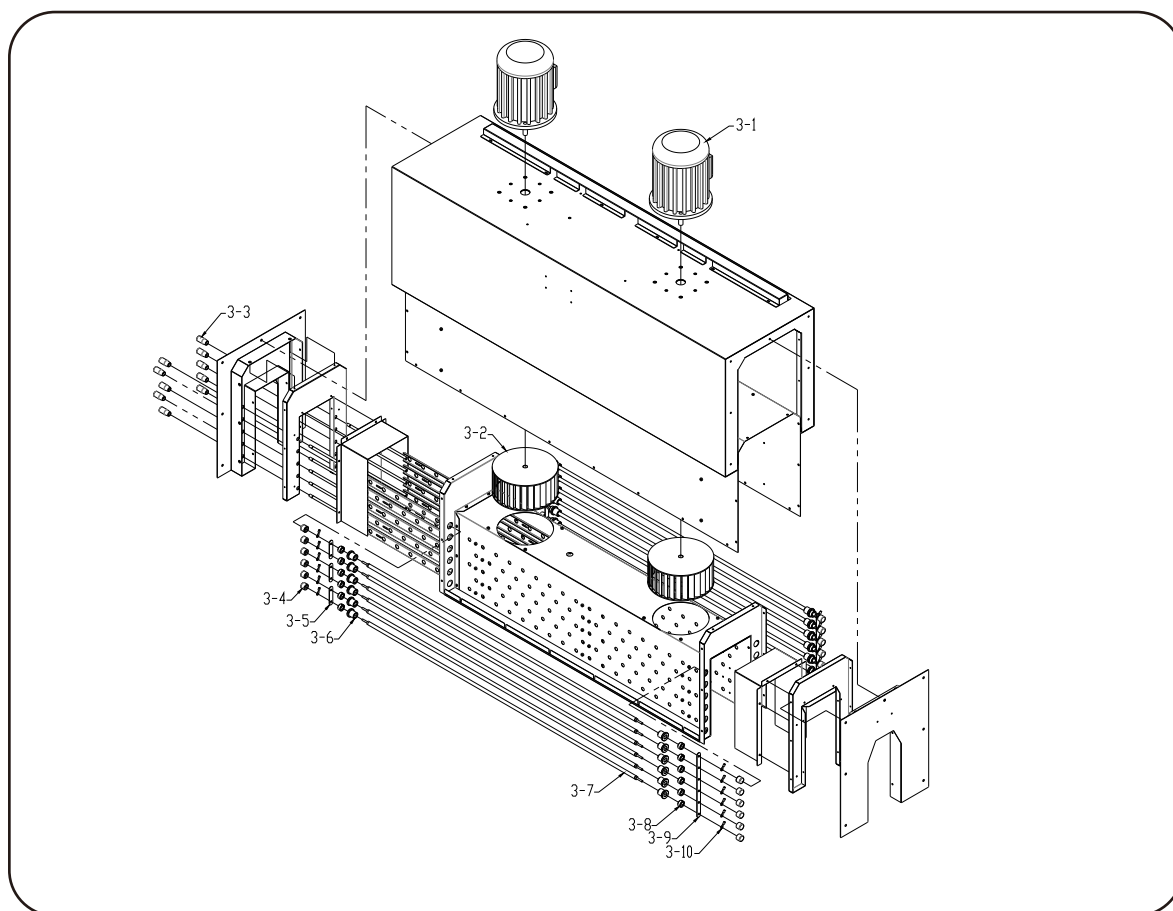
No.	Drawing No.	Name	Quantity
1-1	UC205	Bearing with a Base	4
1-2	6002	Deep Groove Ball Bearing	2
1-3	SM12-02-011-A	Lifting Guide Rail Fixator	2
1-4	SM12-01-004-A	Screw Rod 2	1
1-5	SM12-02-012-02-A	Lifting Block-2	2
1-6	SM12-01-007-A	Lifting Transmission Gear	2
1-7	SM12-01-005-A	Crank	1
1-8	08B	Chain	1
1-9	SM12-01-006-A	Screw Rod 1	1
1-10	M20X150	Anchor Bolt	4
1-11	S4-3305-351	Castor	4

◆ Conveying System (SM-1230/2020/2535)



No.	Drawing No.	Name	Quantity
2-1	M590-502/5GU-30K	Conveying Motor	1
2-2	06B	Roller Chain	1
2-3	SM11-05-007-A	Transmission Sprocket	1
2-4	SM11-05-006-A	Motor Shaft Sprocket	1
2-5	UCF204	Plummer Block	4
2-6	08B	Roller Chain	2
2-7	SM11-05-008-B	Driving Shaft Sprocket	4
2-8	SM11-05-005-A	Heat Resistance Silicone Tube	141
2-9	SM11-05-003-A	Conveying Roller	141
2-10	SM11-05-002-B	Driven Shaft	1

◆ Blowing and Heating System



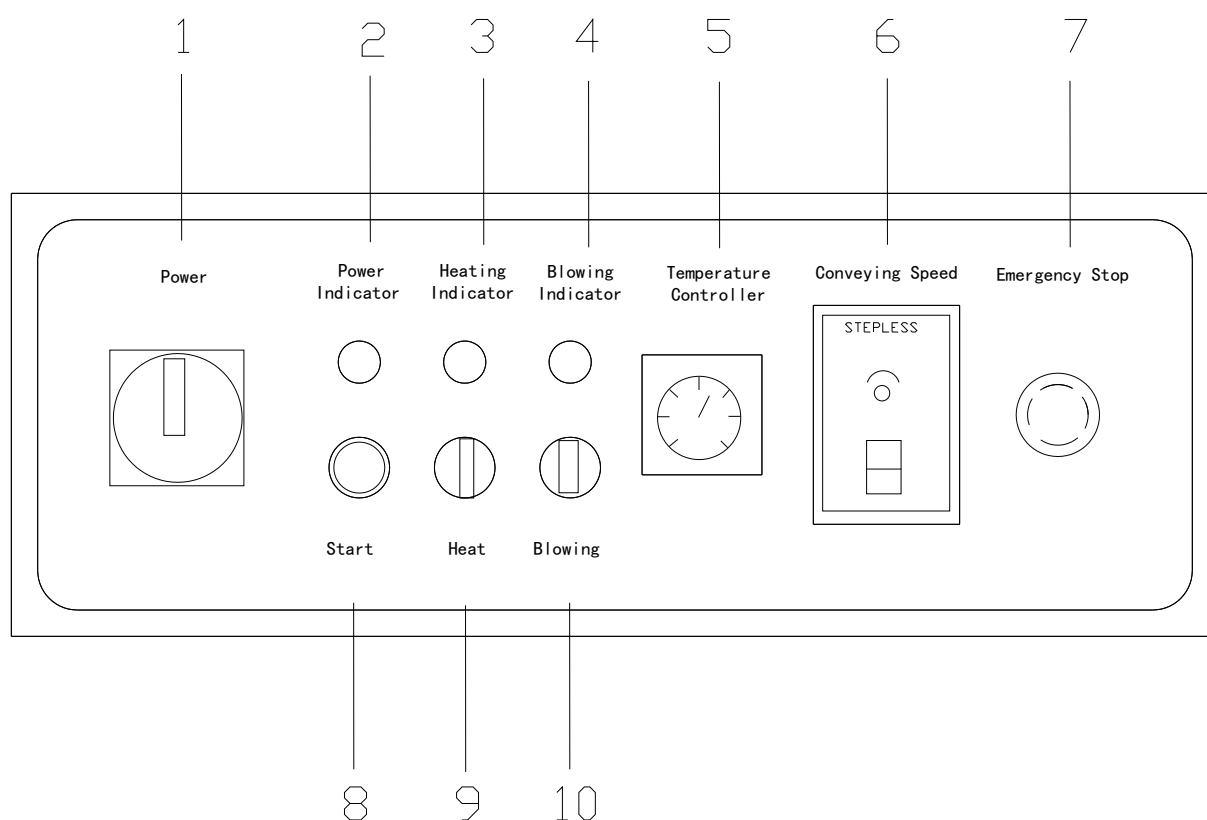
No.	Drawing	Name	Qty
3-1	1HP 2P Erecting L:100 3/380/220	Long Shaft Motor	2
3-2	8" forward direction	Fan Wheel	2
3-3	M8X40	Handle	10
3-4	/	Porcelain Pot-head	24
3-5	SM11-06-006-A	Heating Tube Connecting Plate(short)	6
3-6	SM11-06-003-A	Heating tube Porcelain Sheath	24
3-7	φ11*1200/1200W/220VAC	Heating Tube	12
3-8	SM11-06-004-A	Heating Tube Fixing Ring	24
3-9	SM11-06-005-A	Heating Tube Connecting Plate(Long)	2
3-10	/	Wire Connection	24

3,Technical Parameter

Spec.	Model	SM-1230	SM-1230X	SM-2020	SM-2535
Electrical Supply	3PH AC220V/380V 50/60Hz (Conform to the duty plate)				
Power		17KW	17KW	20KW	22KW
Suitable Film		POF PE			
Tunnel Mouth Size		W=120mm	W=120mm	W=200mm	W=250mm
		H=300mm	H=300mm	H=200mm	H=350mm
Conveying Speed		0~20m/min			
Shrinking Temperature		0~250℃ adjustable			
Weight		350Kg	380Kg	420Kg	450Kg

4, Operation

I Operation Panel



Code	Name	Function
1	Main Power Switch	Switch on/off the main power
2	Power Indicator	Indicate the machine power on or off
3	Heating Indicator	Indicate the working status of heating system
4	Blowing Indicator	Indicate the working status of blowing system
5	Temperature Controller	Set the temperature of tunnel chamber
6	Speed controller	Adjust the speed of conveyor roller
7	Emergency stop	Press this button to stop the machine immediately
8	Power on button	Press to set the control power on
9	Heat switch	Set the heat on/off
10	Blowing switch	set the blowing on/off

※ No Conveying System equipped on SM-1230X

II Operation

- 1, Switch on the “Main Power Switch” to set the main power on .
- 2, Press the “Power ON” button to connect the control power, “Working indicator” lit on.
- 3, Press “Conveying ON” button to set the conveying system on, with its speed adjustable via the speed controller on the operation panel
- 4, Put Blowing switch into ON position, blowing motor working.
- 5, The machine will heat up after blowing system and conveying system working , set the suitable shrinking temperature.
- 6, Start operation till the temperature reaches the target degree.
- 7, Switch off the main power supply.

Cautions:

- ◎ Check the wind volume, if small, exchange any two phase wires whose connecting way determines the wind volume.
- ◎ Temperature controller setting range : 0–200℃
- ◎ Please follow the operation rules to switch on/off the machine.

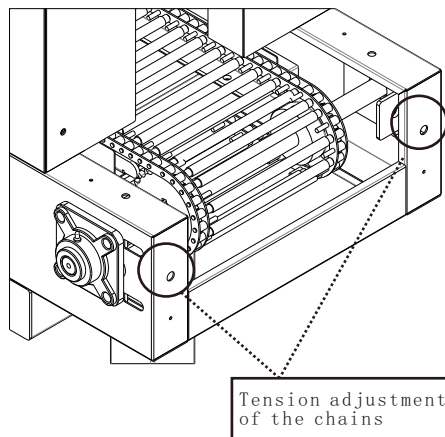
5, Care and Maintenance

◆ Care

- ◎ Clean the conveyor rollers after a work shift
- ◎ Lubricate such moving parts as chains and bearings weekly.
- ◎ Check and replace the lubrication oil in conveyor motor gear box quarterly.
- ◎ Check the wires and cables in electrical cabinet regularly and clean the dust and foreign matter

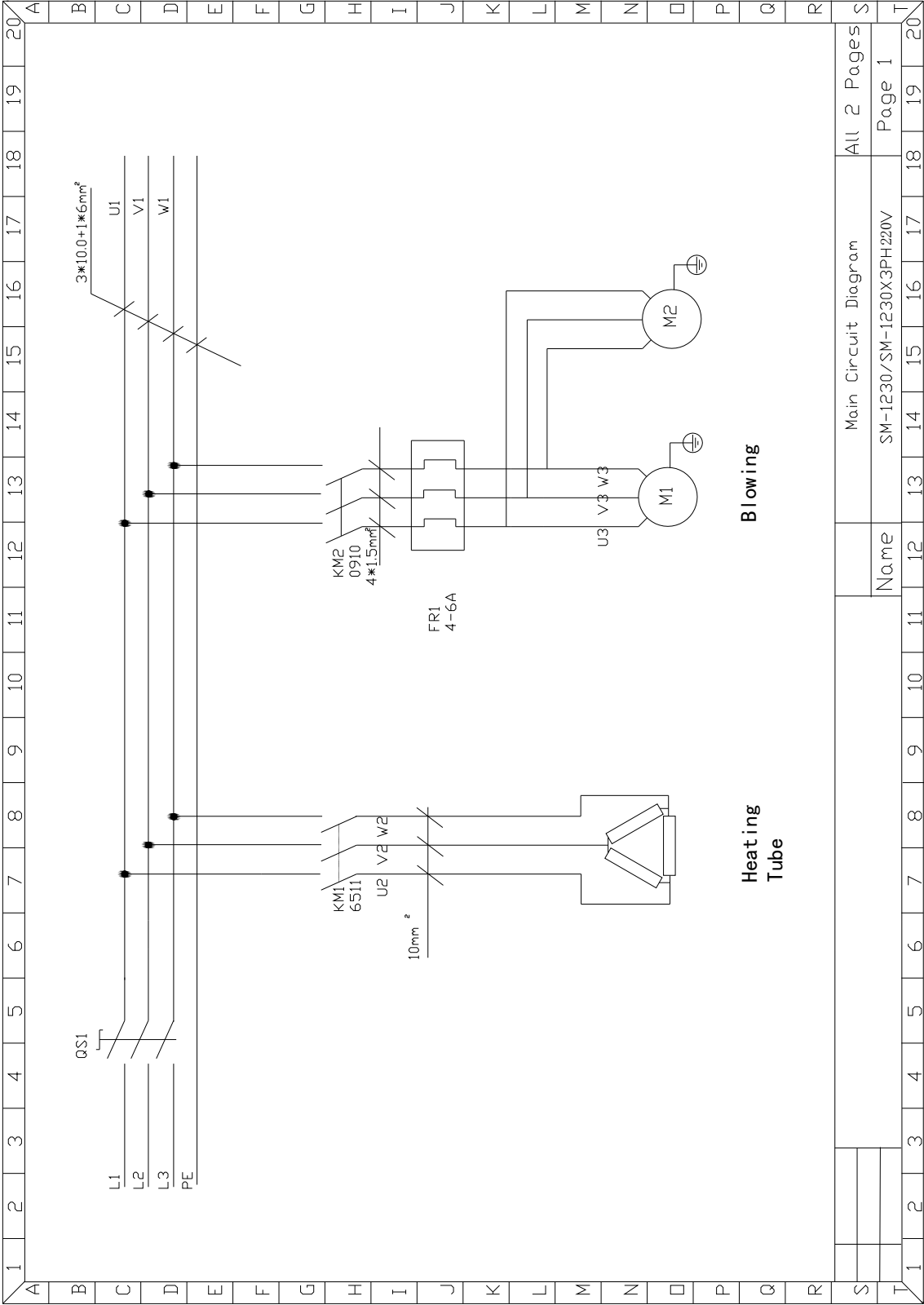
◆ Maintenance

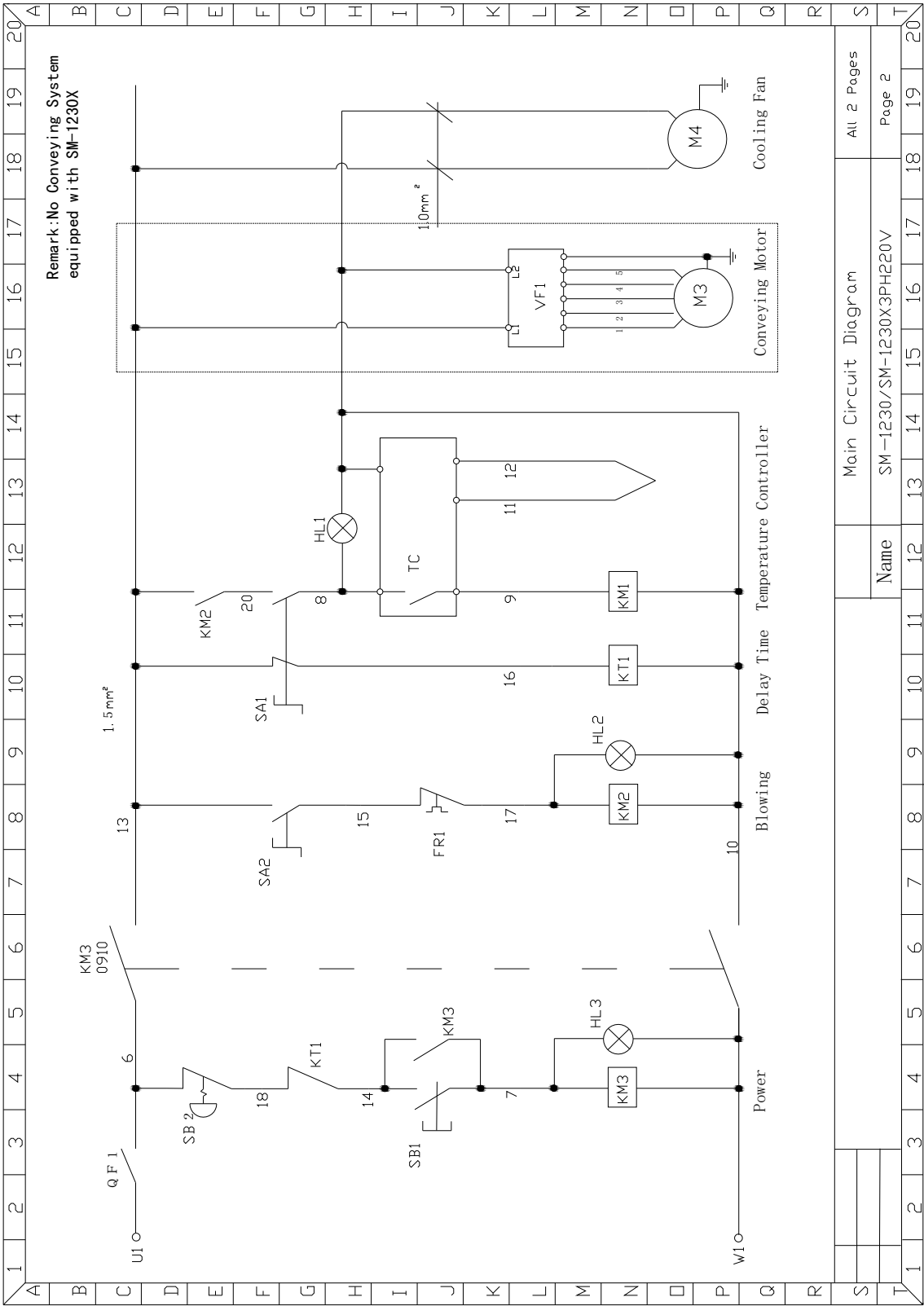
- ◎ How to replace the conveyor rollers

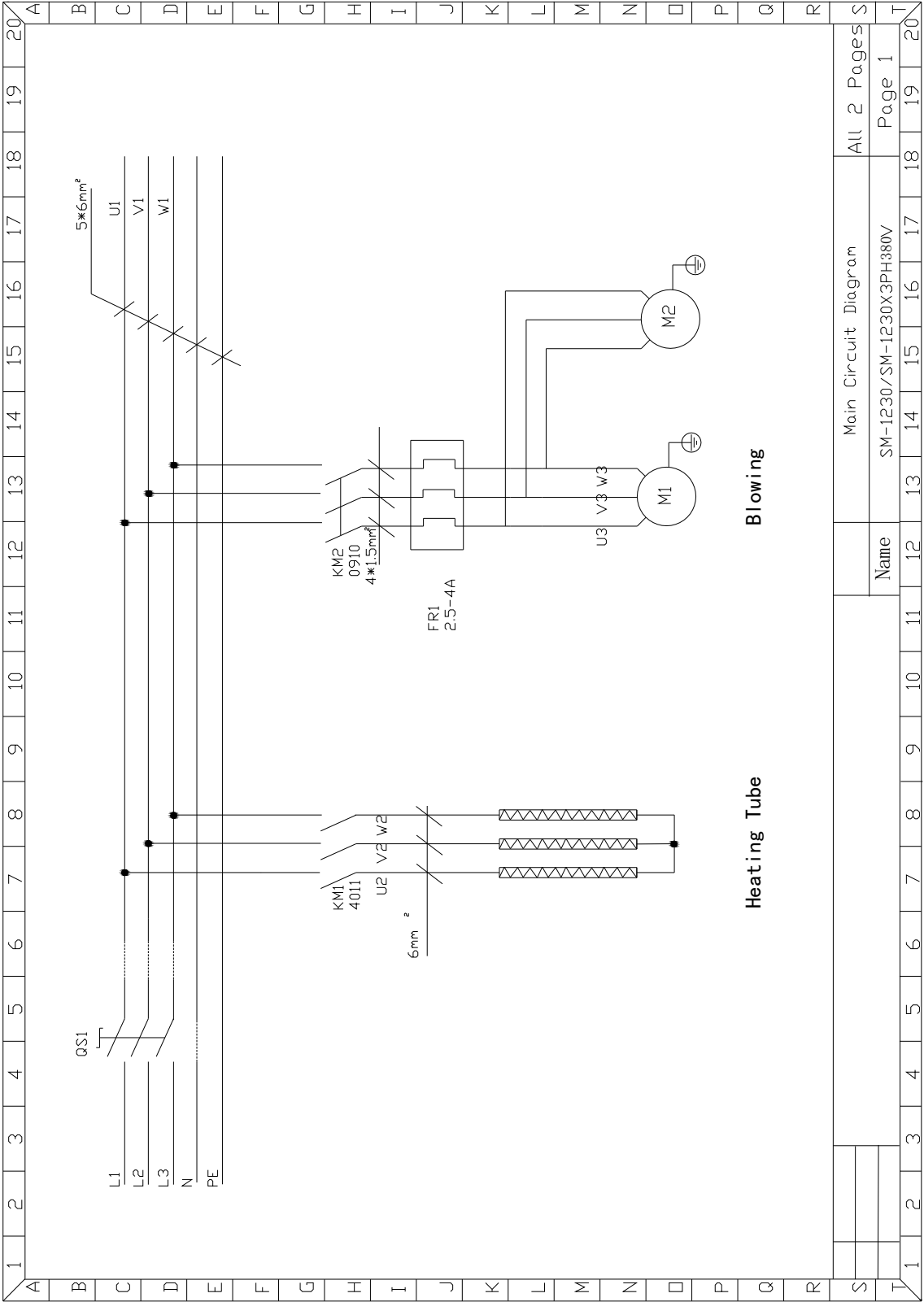


- 1, Adjust the chain tension screws to loosen the chains.
- 2, Separate the chains outward to remove the broken rollers
- 3, Install the new rollers.
- 4, Tighten the chains.

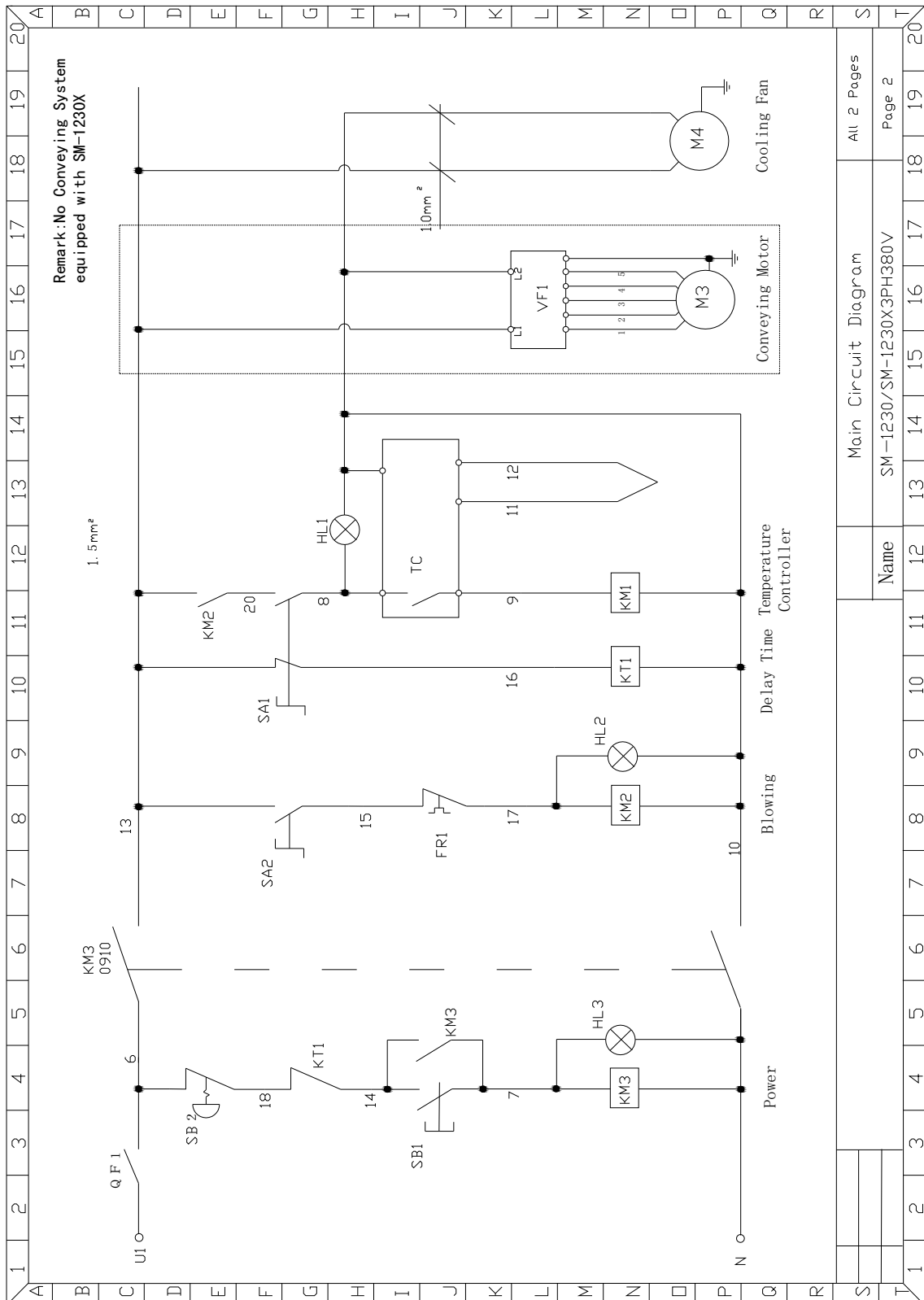
6, Circuit Diagram



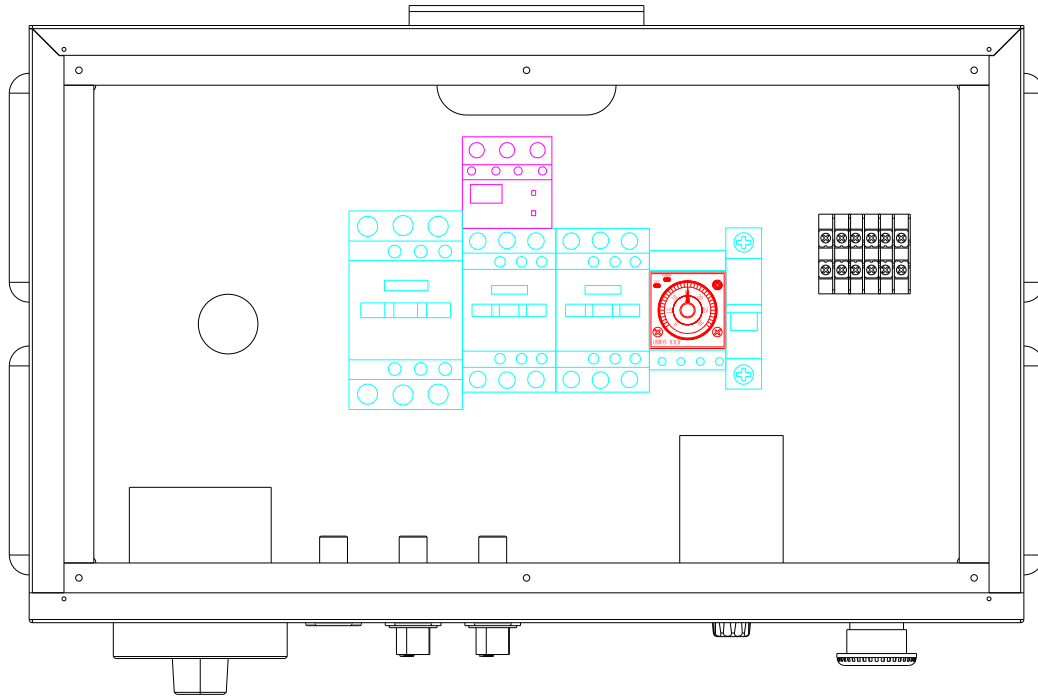




			Main Circuit Diagram										All 2 Pages						
			Name										Page 1						
			SM-1230/SM-1230X3PH380V																



◎ Electrical Control Box Layout



7, Trouble Shooting

Fault Symptoms	Causes	Eliminating Methods
Poor Shrink Effect	Temperature Too High or Too Low	Fine-tune the Temperature
	Conveyor Belt Running Too Fast	Adjust the Speed
	Conveyor Rollers Not Rotating	Add Lubricating Oil
Machine Noise	Lubricant Starvation	Add lubricating Oil
Temperature Anomaly	Temperature Controller Failure or Thermocouple Failure	Replace Temperature Controller or Thermocouple
	Solid Heating Relay Failure or Alternating Contactor Failure	Replace
	In-put Voltage Anomaly	Examine In-put Line
	Loosened Wires	Examine then Reconnect
	Heating Tube Failure	Replace
	Heating Switch Failure	Replace
Abnormal Machine Halt	Breaker Tripping	Check out the Overload or Short Circuit
Conveying Belt Out-of- Operation	Motor Failure or Frequency Inverter Failure	Replace
	Frequency Inverter Wrong Setting	Reset
	Machine Jammed or Driving Chain Loosened	Reset and Eliminate