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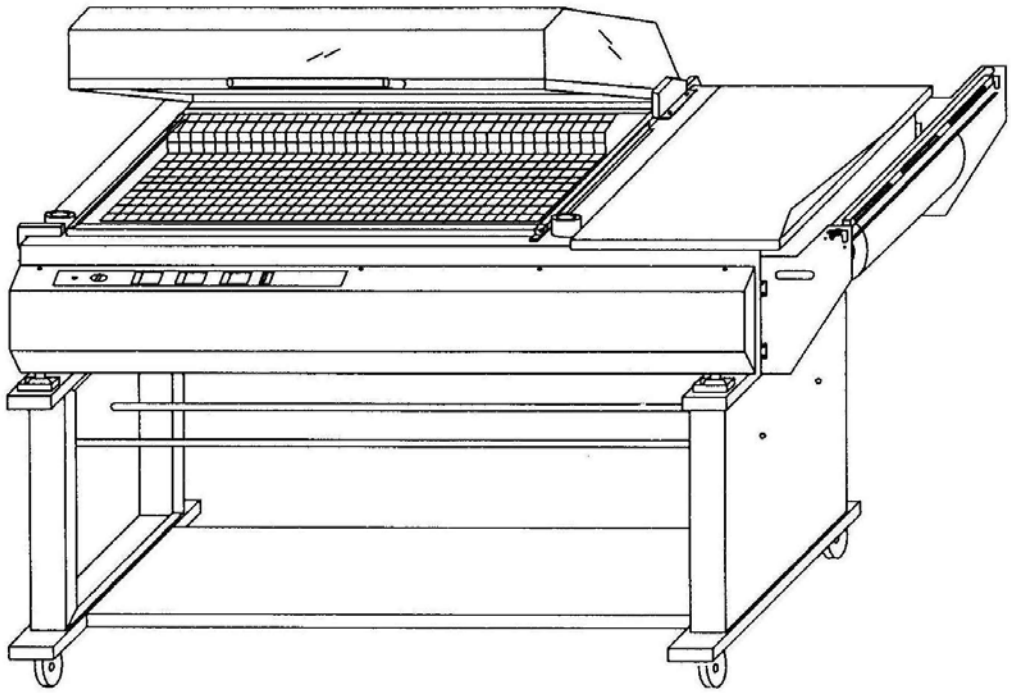
SHRINK-WRAPPING MACHINE

OPERATION & MAINTENANCE MANUAL



SAFETY INFORMATION

Before attempting to service or use this machine carefully read this instruction manual.

Please pay particular attention to features showing the WARNING SYMBOL:

1. DO NOT replace any safety parts of different Specifications

2. DO NOT use the machine in an atmosphere of high humidity

3. Metal parts at the back of the machine close to the heater box .will become hot during machine operation. There parts are marked with an appropriate symbol –staff should take care not to touch these parts when the machine is operating.

4. Keep the instruction manual available at all times and ensure that your operators are fully familiar with the machine and its controls and method of operations. The machine will then give your long and trouble free service in safety.

5. All technical queries must be refer to US. No liability is accepted for personal injury or consequential loss suffered as a result of unauthorized repair/alterations, or failure to use the machine strictly in accordance with these instruction

6. Remember that if the machine is being moved ,or film rolls weighting in excess off 15 kgs are being handled-use at least 2 peoples

7. The machine must be protected by a 25 Amp fuse. The supply MUST BE EARTHED

8. Shut off all electrical power after machine operation or servicing machine.

TABLE OF CONTENTS

MACHINE DESCRIPTION

Our machine is a manually operated shrink wrapping machine for use with PVC or polyolefin shrink films
It can be used either to make loose bags, or to shrink the film tightly around your products circulating heated air inside the hood.
Suitable for use with single products or for collation of several products in one packagi
The shrinking of the film can be carried out the same times as the cutting and is achiev by the circulation of hot air forced around th package
notice: ⚠

THE FOLLOWING SHOULD NOT BE USED WRAP:
Liquid and/or gelatinous products if not contained in another package
Anything that could damage the Machine or constitute a danger to the health of the operator(for example, acids, corrosive substance, salt)

Explosive products;

Highly inflammable products;

Liquid or moist products, unless contained within other packaging;
Loose or granular products;

Notice ⚠

If you are wrapping foodstuffs with direct film contact you. Should always ensure that you use a film approve for direct contact with that type of food.

PLEASE PAY PARTICULAR ATTENTION TO THE FOLLOWING

LIMITS OF USE
The machine must not be used in the following location: open-air environments and /or those exposed to the elements, environments containing steam, fumes corrosive and/or abrasive dusts, environments with fire or explosion hazards, and in any case wherever the use of fireproof components is required
The electrical equipment operates correctly within an ambient temperature range of +5℃ to 40℃and with relative humidity limits of less than 50% at 40℃and less than 20% at 20℃
The machine is not suitable for operation in the presence of ionizing and other kinds of radiations(X-rays ,lasers ,microwaves ultraviolet-rays)
The machine must be stored at temperature between-5℃and +55℃

PACKING

Machine is film wrapped for protection and packed for transport in corrugated sleeve and top, and secured to a pallet.

Particular care must be taken in opening the case not to damage the machine

The MACHINE STAND is packed in a separate corrugated case

The machine packaging contains:

----the machine body
----the film reel carrier
----the film shaft with 2 cones
----plastic bag with spare parts
----aerosol can of silicone lubricant
----maintenance manual

Care must be taken in unpacking the machine
not to damage the plastic hood!

please pay attention to the following, If you had purchased the machine stand

The machine stand case contains:

-----1base section
-----2upright sections
-----3basketry bracket shaft
-----1waster film basketry
-----plastic bag containing nuts/bolts for stand assembly

Optional bag containing:

-1spare sealing wire;(7-05200-250)
sponge strip; 1
(7-05200-130&7-05200-131)
-2spring; (2201411055)
-1spare roll of Teflon tape
297F0074
-Manual for installation, use and maintenance

Tools parts:
-1 screwdriver
-1 2.5mm Allen wrench
-1 3mm Allen wrench
-1 4mm Allen wrench
-1 5mm Allen wrench
-1 6mm Allen wrench

MACHINE ASSEMBLY

STAND (see also Fig.1)

---Secure the 4castors to the stand base section using the nuts provided, and position the BRAKED castors at the FRONT of the stand

--Next assemble the UPRIGHT sections to the base unit, Be sure to use the STRENGTHENING WASHERS when fitting the upright sections

--Next assemble the basketry bracket and basketry

--The BASE section is a useful storage area for spare film rolls

MACHINE BODY(see also Fig2)

--Put the machine on the stand (ensuring that the adjustable leveling feet locate in the cups on the UPRIGHT sections).OR the machine on your bench if no machine stand has been purchased.
NOTE: do not hold it by the handle of the hood or the film holder unit (it is advisable to use two people for this operation)
-Slide the reel carrier assembly from the back of machine forwards, into the twin slides, until the carrier extends about 300mm
to the front of the machine body ,the reel carrier will have to be “eased” past the stop at
the rear of slides, the travel of the reel carrier is now limited front and rear

--Cut the adhesive tape holding the hood closed ,and position the wire package tray using the 2 sets of hoods at the chamber, and
fitting the 2thumb screws to match at the front
of the chamber.

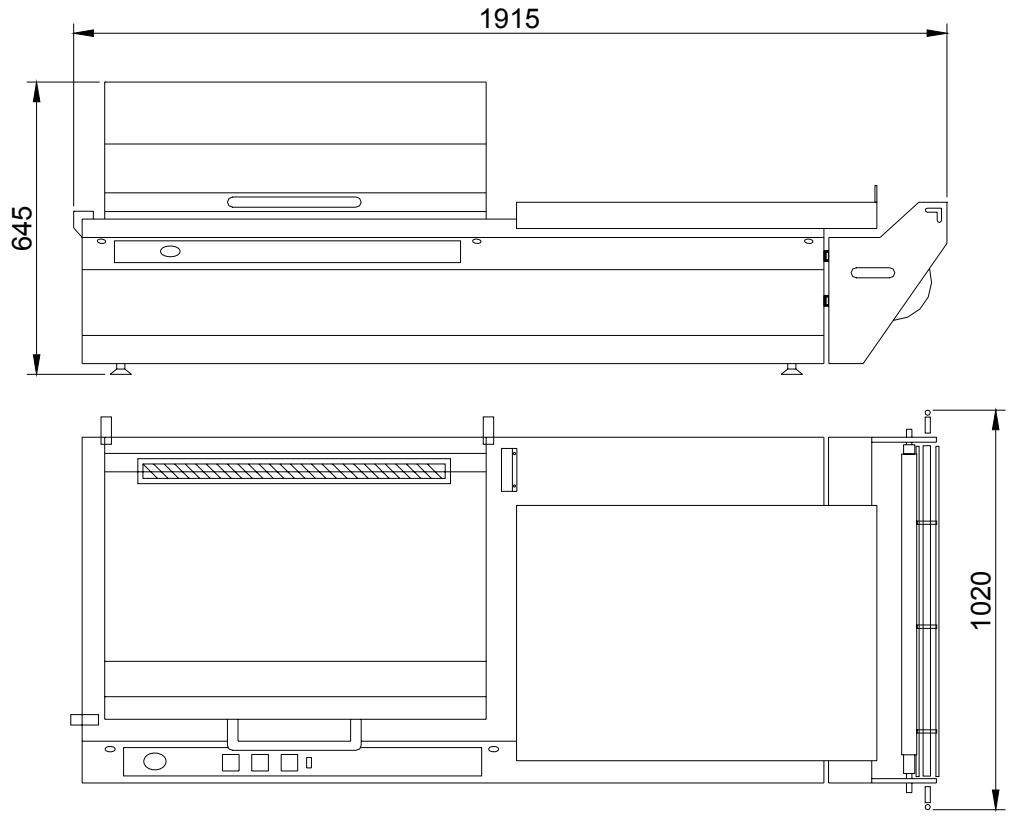
⚠--Ensure that nothing remains loose in the
base of the chamber-it could seriously damage the fans

--The hood should remain in the OPEN positions, if necessary adjust by means of the
torsion bar adjustment bolt on the back of the machine

--Fit the roll of center-folded film centrally on
the film shaft and lock in position using the cones and the Allen key provided, the folded edge of the film is fitted to the rear of the machine-open edge to the front.

--Pull the end of the film through the 2 rods carrying the perforator wheels. Over the top roller ,and around the film separation table.

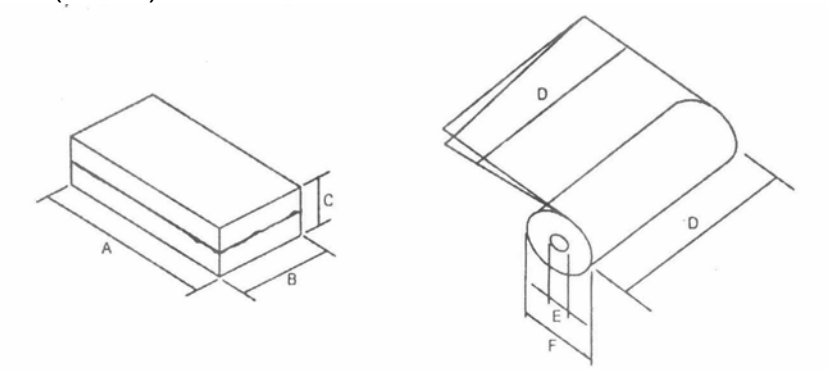
SPECIFICATIONS OVERALL DIMENSIONS



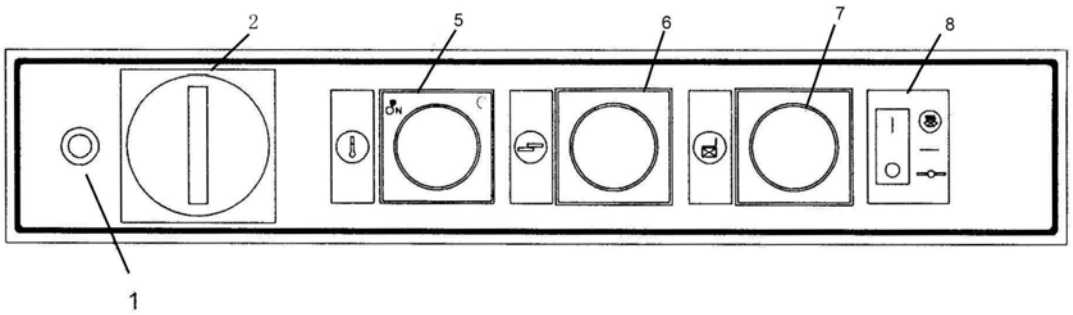
SPECIFICATIONS

Machine weight (without stand):135kg
Machine working height (without stand) 370mm
Machine height incl. stand : 910mm
-Dimensions of sealing:620×800
-Power:5.3kw
-Power supply voltage220v/380v/400v/3-phase

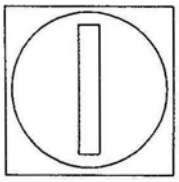
-packaging capacity:
min: A×B×C 50×50×1mm
max: A×B×C 770×590×250mm
NOTES: B+C must never exceed 750;it is not possible to create packages with the maximum dimension A×B×C,
-film to be used for packaging :center-fold sealing film, thickness 60 gauge.
dimensions(D-F-E) 800×250×75mm



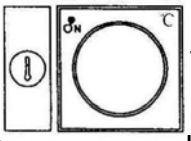
CONTROLS



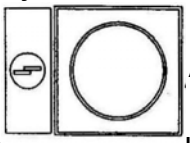
[1] PILOT LAMPS (POWER SUPPLY)

[2]  MAIN POWER SWITCH

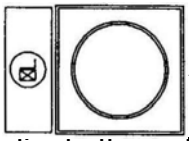
This is the main power switch on the machine. Electrical power supply to the machine from the power source is controlled through this switch.

[5]  TEMPERATURE CONTROL

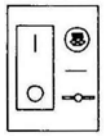
It adjusts the value of the temperature

[6]  ANALOG TIMER

It adjusts the value of the sealing time

[7]  ANALOG TIMER

It adjusts the value of the eletro -magnet close time

[8]  SEAL/SHRINK SWITCH

If press the key of "○" the machine only seal film
If press the key of "I' the machine can seal and shrink film

SETTING –UP PRODEDURE

1. Set the MIAN SWITCH to position “on make the lamp light. 2 Set the SEAL TIMER ,adjust the time to suitable value. Pull the leading edge of the film into the chamber and cross the sealing blade. Close the hood and check if the film cuts and seals cleanly. If not , increase the setting of the SEAL TIMER until a good seal and clean cut are obtained. Always set this timer at lowest value where good sealing occurs . 3 Set machine in “SEAL&SHRINK” mode . through temperature controller to adjust the temperature . suitable setting for your film-usually120-135 degrees for PVC films Operating experience will soon tell you the optimum for the film you use 4.Through the analog timer to adjust the electric-magnet closed time, The magnets will clamp the hood whilst the fans circulate heated air. The hood will open automatically when the sequence is finished. Again, operating experience will quickly show Whether longer or shorter magnet/shrink cycle times are required to successfully shrink wrap Your produce.	5 You can choose cooling time if you need when the sealing is finished, after several seconds (cooling time) the fans start to run, shrinking the products, Maybe the sealing line is beautiful. according to your film(such as PVC film) Operation :Open the front frame(see fig 2-2 Item 14), adjust the timer fixed in the electrical fixed board(see fig 6 item 127). The adjusted time is 0～3s(this is the cooling time) The REEL and FILM DIVIDING TABLE slide forwards and backwards to suit the size of film and product being used. The WIRE PRODUCT TRAY can be raised or lowered Inside the chamber using the hooks at the Back and the 2 screws at the front. The tray Should normally be positioned so that the Seal appears about half-way up the side of the product Micro Switch Striker Adjustment The adjustable pin which operates the machine micro-switch has been pre-set and its adjustment locked by means of two nylon nuts. If for any reason this adjustment should be lost or altered during operation then the striker should be reset GENTLY to strike the micro-switch, IF THE MICRO-SWITCH STRICKER IS SET TOO LOW IT WILL DAMAGE THE OPERATING MICRO-SWITCH

OPERATION

The way to thread film:

Adjust the position of the connector shaft through pulling the sphere-type handle(the black sphere on the two side of connect shaft) to locate it at the lowest point of the “ ”groove
Thread the film across between the rubber roller and the connector shaft
Pass the lower and upper edge of the Film under and over separator respectively
In according with customers ’s request ,you can adjust click pulley to stitch the film. If so, please move the connector shaft to the right of the “ ”groove to make spike press the rubber roller closely

Draw the leading edge of the film from Right to Left into the chamber area and cross the sealing blade. Ensure the top and bottom leaves of film around the dividing table are equal in length, and operate the hood to produce a seal on the Left –hand end of the film
Remove the waste film-cut off by this operation from inside the chamber

Place your product on top of the dividing Table and inside the film –against the fold at back. and the seal at the Left–hand side
Draw product and film into the chamber and place approximately 10mm or 15mm from the front and side seals .Operate the hood and the shrink/seal process is carried out automatically with the hood opening on completion of the cycle.

If the film is not fully shrunk –increase MAGENT TIMER and /or TEMPERATURE until good results are obtained.

If the film burns or punctures-reduce TEMPERATURE and/or MAGENT TIMER until good results are obtained.

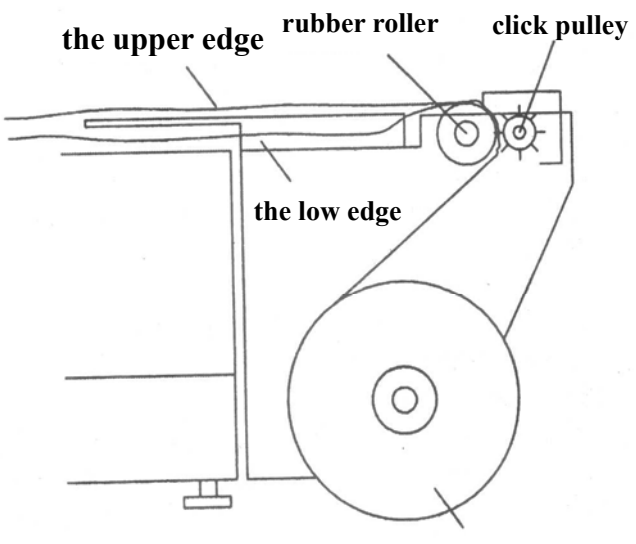
FILM SIZE/ADJUSTMENT

Select a suitable film width for your Product (-usually WIDTH OF PRODUCT (front To back) and HEIGHT OF PRODUCT + about 75mm), Fit the film on the reel carrier with the folded side to the rear of the machine .and thread as described previously. The front OPEN side of the film should be about 50mm Over the front seal blade, and the DIVIDING TABLE should be positioned so that inside the film it is about 20mm from the folded edge.

DO NOT attempt to seal and shrink if there is any tension on the film as the hood is close-the pack will split open as it shrinks. ALWAYS allow the film to be relaxed as the seal takes place.

If the film BALLOONS and does not shrink fully around your product-then the machine is making too good a seal !Use one or both sets of perforator wheels on the reels carrier during the shrink process

TAKE CARE –THE PERFORATOR WHEELS HAVE SHARP SPIKES which are behind the film during operation but which are EXPOSED DURING ADJUSTMENT AND FILM THREADING



GENERAL MAINTENANCE

⚠Operations to be carried out by the machine operator.

The machine operates with plastic films which may leave deposits on the sealing blade and so effect quality

The sealing blades:
Keep the sealing blades clean by using a rag or NON-METALLIC scraper (or thumb –nail!)and keep the Teflon tape on the both top jaw clear in same way .Apply a SILICONE LUBRICANT spray to both top and Bottom jaws, several times a day, for easier And cleaner machine operation

Transparent hood
The transparent machine hood may be kept clean with glass polish or similar-DO NOT USE SOLVENT CLEANERS

CAUTION IN OPERATION
To in order to make your packaging products Sealed and shrunk completely, you can operate The machine as following:
1. To in order to shrink the product, you must make the chamber to be hot by opening and closing the hood repeat when you start or you are asked to operate again in the case of your operation is interrupted.
2. the experience is important to seal and shrink .you will know the appropriate sealing time\shrinking temperature and operating frequency by operating the machine continually.
3 you will be known that only have a good product sealer, your product will be shrunk completely. So when you operate the machine for sealing or sealing and shrinking, you can close the hood with your high hand, almost at the same time, pull the film by the waste film to move from left to right after sealing time is finished.

ROUTINE MAINTENANCE

It is advisable to use two qualified people for Maintance .

⚠ BEFORE ATTEMPTION ANY MAINTENANCE TURN MAIN SWITCH OFF AND DISCONNECT POWER SUPPLY!

⚠ CAUTION HOT!! CAUTION HOT!!
SEALING BLADE REPLACEMENT

Undo the screws on the expansion blocks and the central knuckle. Remove the broken seal blade and fit new one after cleaning the sealing base of any deposits/dirt. Apiece of Teflon tape around the corner of the wire helps seal quality and insulation of heat. Introduce the end of the front seal blade15mm inside the plunger to the RIGHT I order to compress the spring .then tighten the screws ,Repeat the process with the tighten the screws on the center buckle.

SILICONE RUBBER REPLACEMENT

The silicone rubber strip inside the top jaw must remain flat and undamaged .if it is necessary to replace the rubber, pull the damaged strip out and clean away any silicone adhesive. Replace the rubber strip using fresh silicone adhesive sparingly. Leave to cure overnight.

REGULAR REPLACEMENT of the TEFLON BARRIER TAPE will increase the life of the Silicone rubber.

TEFLON BARRIER TAPE REPLACEMENT

Remove old Teflon barrier tape before it burns or marks bodily. The tape is supplied on a roll, with self-adhesive backing. Simply cut to length .Remove backing protection and stick in place

TROUBLE SHOOTING

THE HOOD WON'T STAY OPEN
Torsion bar out of adjustment? Torsion bar broken ?
Solution: Replace the torsion bar

THE HOOD WON'T STAY OPEN COMPLETELY
Solution: Tighten the special screw.

FAILURE TO CUT FILM CLEANLY
Sealing blades dirty? Seal time too low?
Solution: Check the clamps of the sealing wire and make sure that the latter is not broken, replace if interrupt.
Adjust according to the type of film.

SEAL SPLITTING
Seal timer too high? Film under tension during seal?

FAN WON'T CYCLE
Operating micro-switch out of adjustment or broken? Toggle switch set to seal only? motor condenser of fan motor faulty?

SEALING BLADE LEAVES SEALING BASE

Worn sealing base? Seal time too low? Operator not detaching film before the hood opens?

THE PACKAGING IS AWOLLEN AFTER SHRINK-WRAPPING

The film used is not micro-perforated?
Solution: Make the film pass through the Micro-piercing device of the machine.

ELECTRO-MAGNETS WON'T CLAMP

Magnet pole pierce pads out of adjustment? Magnet timer set too low/defective?

INCOMPLETE SEAL

Solution: Check sealing blades and Teflon tape for cleanliness. Clean and lubricant With silicone. Check Teflon tape for burning And/or wear-
Replace if necessary. Check silicone rubber in top jaw(beneath Teflon tape).If cut or damaged ,replace.

HEATERS NOT OPERATING

Toggle switch set to seal only? Temperature controller set low? Temperature controller /thermocouple/elements defective

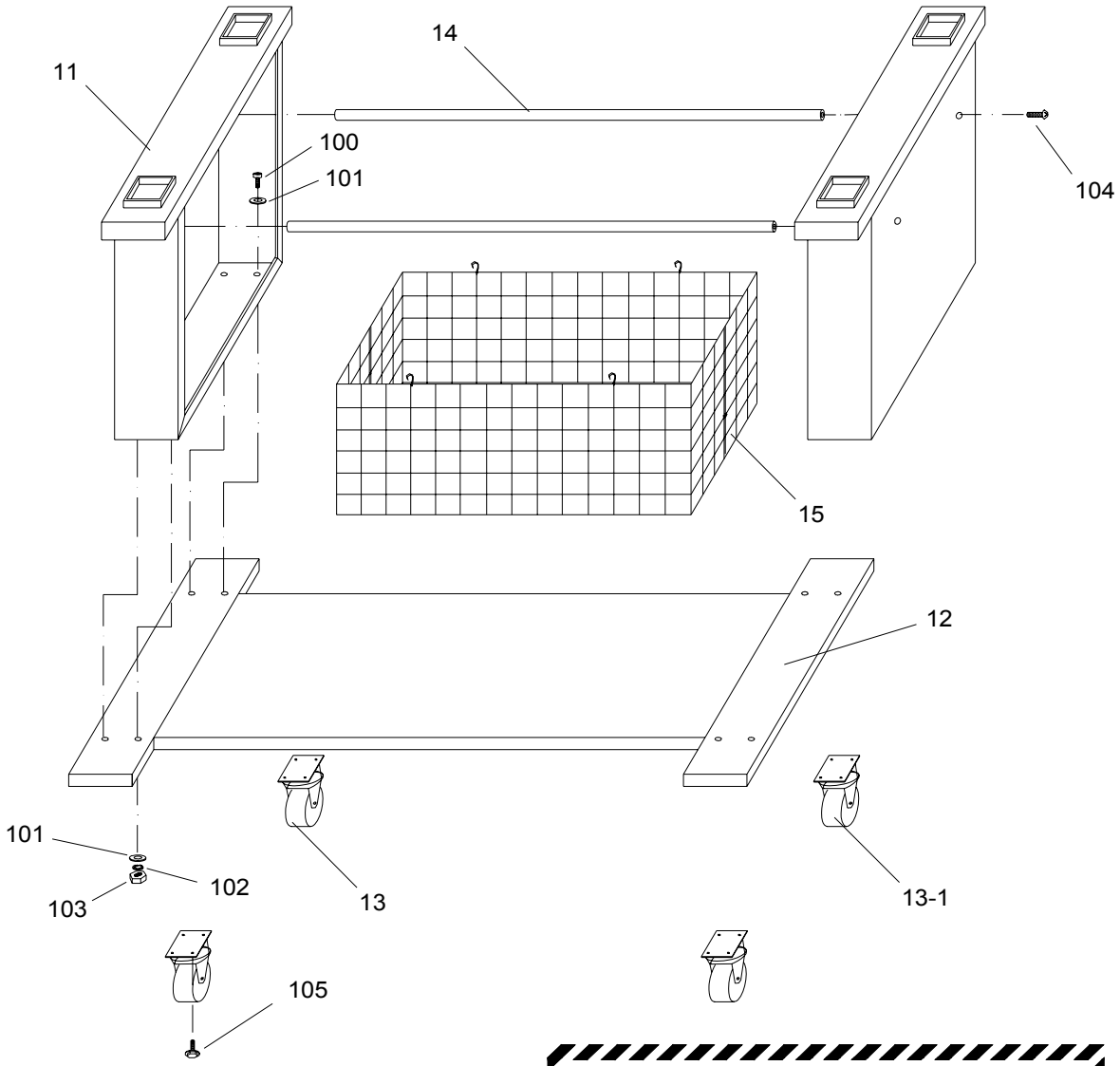
MACHINE NOT –BUT NO SHRINK

Film type/grade correct?(some plastic film do not shrink). Shrink temperature incorrect for this type of material? Fan impeller loose on motor shaft?

PARTS LIST, FIGURE 1-7 ASSEMBLY OF THE STAND

KEY	Q'TY	PART NO.	DESCRIPTION	FPH-206-017
11	2	7-01200-111	Upright	
12	1	7-01200-121	Lower platform	
13	2	229A075PU-BK	Wheel,swivel 75mm	
13.1	2	229C075PU-BK	Wheel fixed 75mm	
14	2	7-01200-140	Basket bracket shaft	
15	1	7-01200-150	Waste film basketry	
100	8	200A08045	Socket head cap screw, M8*45	
101	8	202A0816	Plain washer, M8*16	
102	8	202B08	Lock washer, M8	
103	8	201A08	Hex nut, M8	
104	4	200AR08016	Socket screw, M8*16	
105	16	200M06012	Hex bolt with washer, M6*12	
106	1	202A082230	Plain washer, M8*22*3	

FIGURE 1-7 : ASSEMBLY OF THE STAND



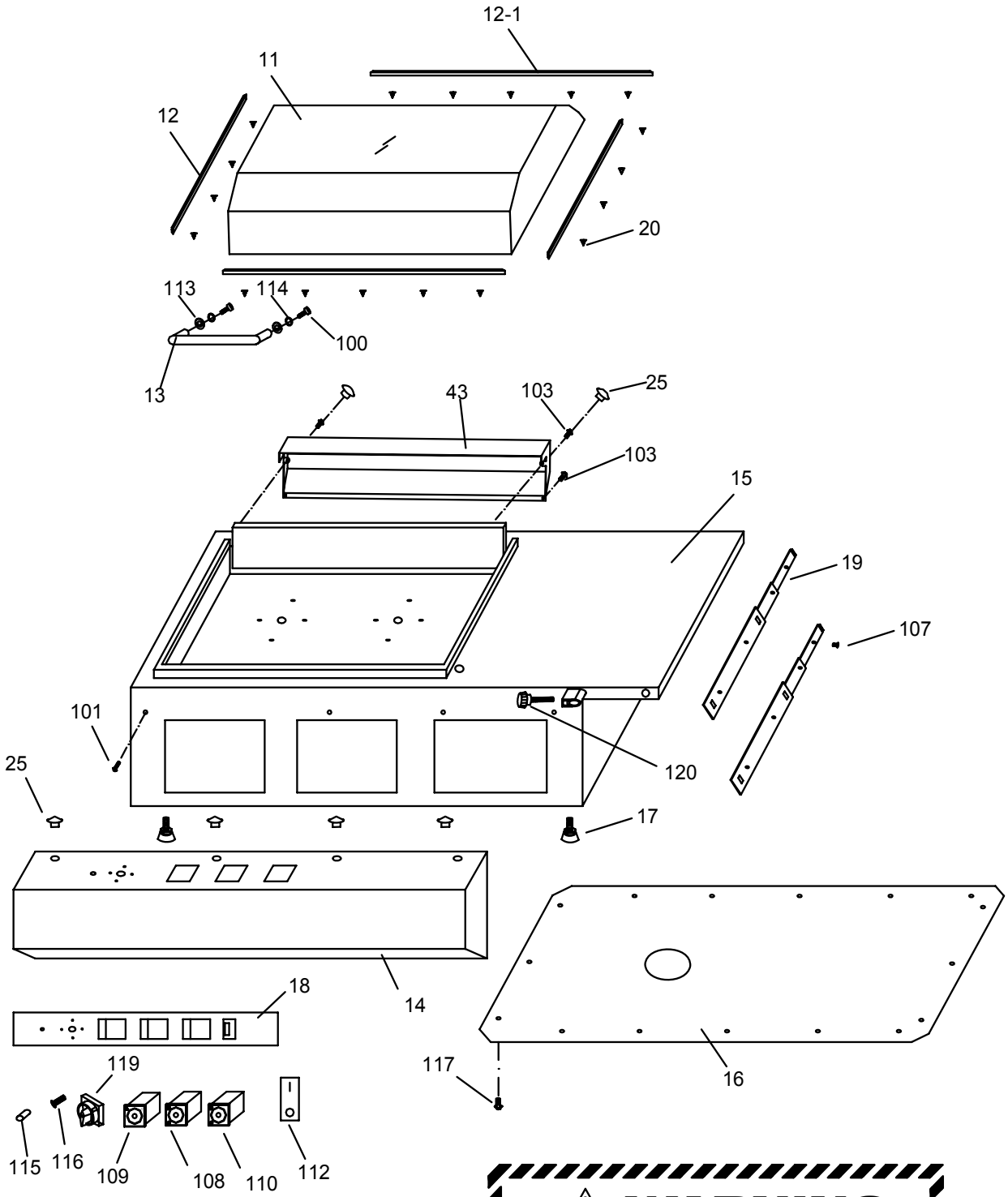
⚠ WARNING

All parts must be periodically inspected and replaced if worn or broken.Failure to do this can affect a tool's operation and present a safety hazard.

PARTS LIST, FIGURE 2-5 MACHINE BODY - HOOD

KEY	Q'TY	PART NO.	DESCRIPTION	FPH-206-025
11	1	7-02200-110	Hood	
12	2	7-02200-120	Transparent hood seat I	
12.1	2	7-02200-121	Transparent hood seat II	
13	1	7-02000-130	Handle	
14	1	7-02200-141	Front frame	
15	1	7-02200-150	Body	
16	1	7-02200-160	Bottom plate	
17	4	7-02000-170	Feet	
18	1	7-02200-180	Lable	
19	2	210K37235000	Slide guide	
20	18	7-02000-200	Spring buckle	
25	6	7-02000-250	Plastic plug	
30	1	YL-02A505004	Liner	
42	1	7-02200-420	Heat insulation plate	
43	1	7-02500-430	Heat insulation plate	
100	2	200A08012	Socket head cap screw, M8*12	
101	3	200H04015	Truss head machine screw, M4*15	
103	12	200H04008	Truss head machine screw, M4*8	
107	12	200F04012	Flat head cap screw, M4*12	
108	1	107E-H5B03220	Timer,3sec AC220 FOTEK M3	
109	1	134C002-220AC	Temperature controller,220VAC-200℃	
110	1	107E-H5B03220	Timer, 10sec AC220 FOTEK M1	
112	1	104M001	Throwback switch	
113	2	202A0816	Plain washer, M8*16	
114	2	202B08	Lock washer, M8	
115	1	109A003	Indicator light 12VDC	
116	4	200F04016	Flat head cap screw, M4*16	
117	27	200L04015	Tapping screw ,M4*15	
119	1	104C011	Main power switch, GN20 H-06-40U06,15A/600VA	
120	1	200R05016	Star-type handle M5*16	

FIGURE 2-5 : MACHINE BODY - HOOD



⚠ WARNING

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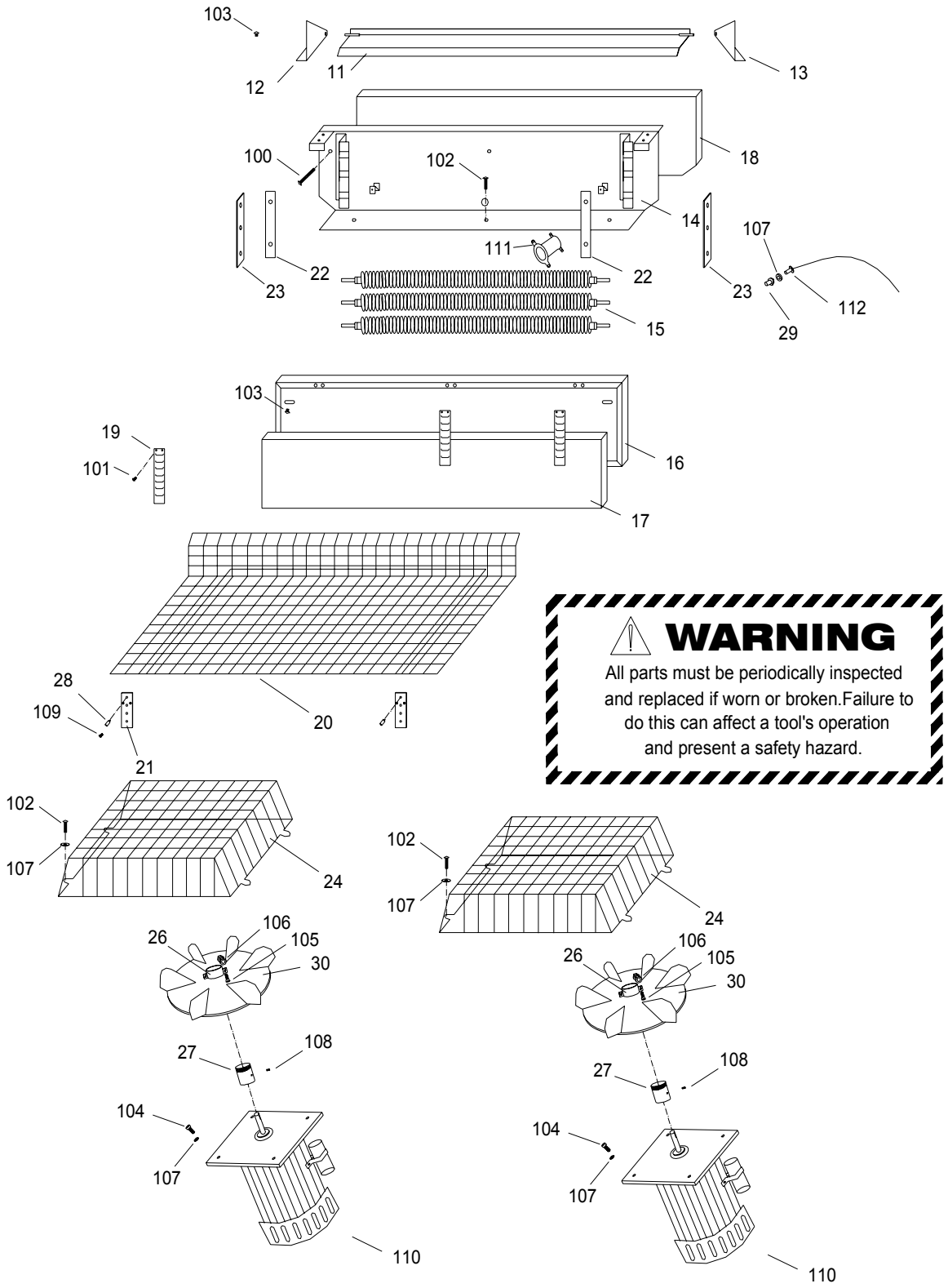
PARTS LIST, FIGURE 3-9 BASIN - RESISTOR UNIT

KEY	Q'TY	PART NO.	DESCRIPTION	FPH-206-039
11	1	7-03200-110	Hinge	
12	1	7-03100-120	Hinge adjustable support (L)	
12.1	1	7-03100-121	Hinge adjustable support (R)	
14	1	7-03200-140	Fin fasting board	
15	3	7-03200-320D	Heating tube，230VAC 1300W	
16	1	7-03200-160	Baffle	
18	2	7-03200-180	Anti-high tem.clothe	
20	1	7-03900-200	Tray	
21	4	7-03000-211	Tray uphold	
22	2	7-03000-220	Heater transmission fastener	
23	2	7-03000-230	Heating tube connector	
24	2	7-03000-240	Fan protection	
25	1	7-03900-250	Plate	
26	4	7-03000-260	Clip ring	
27	2	7-03000-270	Fan shell	
28	4	7-03000-280	Tray uphold screw	
29	1	7-03100-290	Copper connector	
30	2	7-03000-300	Fan	
102	11	200H04015	Truss head machine screw, M4*15	
103	11	200H04008	Truss head machine screw, M4*8	
104	8	200A06020	Socket head cap screw, M6*20	
105	4	200A05020	Socket head cap screw, M5*20	
106	8	201A05	Hex nut, M5	
107	16	202A061620	Plain washer, Φ6*16*2	
108	2	200G08015	Socket head set screw, M8*15	
109	4	200F04008	Flat head cap screw, M4*8	
110	2	101D4050037	Motor, 400V50Hz3Ph 370W	
111	1	110GNC.220	Heat-variable resistor,220℃	
112	1	104Y004	Thermocouple	
118	2	200F03008	Phillips head machine screw, M3*8	

FIGURE 3-9 : BASIN - RESISTOR GROUP



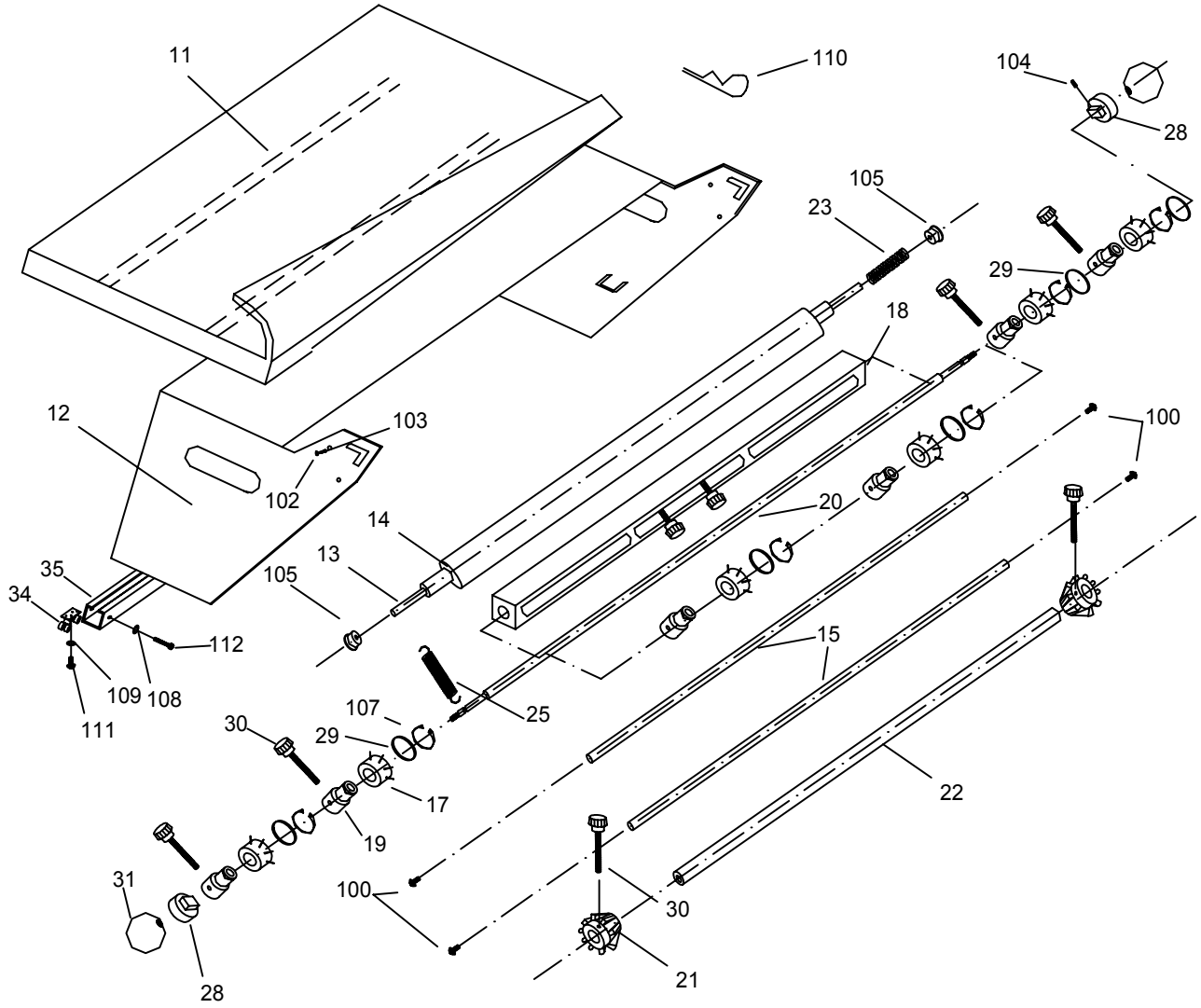
WARNING

All parts must be periodically inspected and replaced if worn or broken.Failure to do this can affect a tool's operation and present a safety hazard.

PARTS LIST, FIGURE 4-2 REEL CARRIERGROUP

KEY	Q'TY	PART NO.	DESCRIPTION	FPH-206-042
11	1	7-04200-110	Separator	
12	1	7-04200-120	Film holder body	
13	1	7-04200-130	Spinder	
14	1	7-04200-140	Rubber roller	
15	2	7-04200-150	Shaft	
17	6	7-04000-170	Click pulley	
18	1	7-04200-180	Adjusting bracket	
19	6	7-04000-190	Scored pulley fastener	
20	1	7-04200-200	Connector shaft	
21	4	7-04000-210	Lock wimble	
22	1	7-04200-220	Film shaft	
23	1	7-04000-230	Conical spring	
25	2	2201411055	Spring,1.4*11.4*55	
28	2	7-04000-280	Slide	
29	6	227A03528	Rubber washer, Φ28*3.55	
30	8	200R06025	Star-type handle, M6*25	
31	2	227BA-3008	Grip ball(Black)	
34	1	7-04200-340	Pulley	
35	1	7-04200-350	Supporting guideway	
100	4	200H05012	Truss head machine screw, M5*12	
102	2	200A05030	Socket head cap screw, M5*30	
103	2	201A05	Hex nut, M5	
104	2	200G06010	Socket head set screw, M6*10	
105	2	210AF606ZZ	Bearing F606ZZ	
107	6	212AS20	Ring, S-20	
108	4	202A061620	Plain washer, Φ6*16*2	
	2	201A08-1	Hex nut, M8	
109	2	202A0409	Plain washer, M4*9	
110	1	212CR15	Snap pin-R15	
111	2	200E04012	Phillips head machine screw, M4*12	
112	2	200A06060	Socket head cap screw, M6*60	

FIGURE 4-2 : REEL CARRIER GROUP



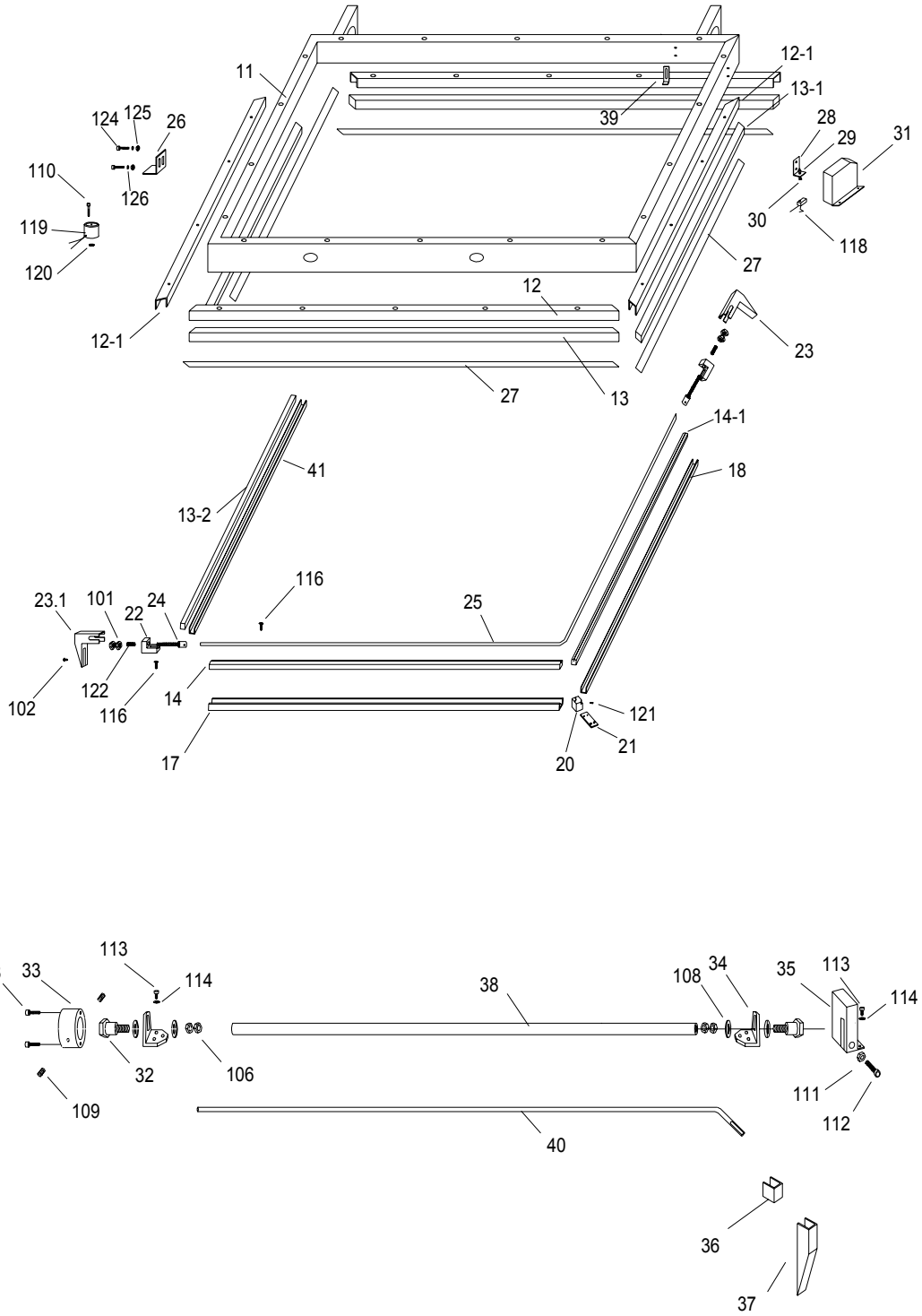
⚠ WARNING

All parts must be periodically inspected and replaced if worn or broken.Failure to do this can affect a tool's operation and present a safety hazard.

PARTS LIST, FIGURE 5-9 SEALING BAR GROUP

KEY	Q'TY	PART NO.	DESCRIPTION	FPH-206-059
11	1	7-05200-110	Rim	
12	2	7-05200-120	Aluminum seat (long)	
12.1	2	7-05200-121	Aluminum seat (short)	
13	2	7-05200-130	Sponge strip(long)	
13.1	2	7-05200-131	Sponge strip(short)	
13.2	1	7-05200-132	Sponge strip	
14	1	7-05200-140	Heating row(long)	
14.1	1	7-05200-141	Heating row(short)	
17	1	7-05900-170	Heating row fastener I	
18	1	7-05900-180	Heating row fastener II	
20	1	7-05000-200	Bronze joint	
21	1	7-05000-210	Joint seat	
22	2	7-05000-220	Limit block ABS	
23	1	7-05000-230	Plastic cover	
23.1	1	7-05000-231	Plastic cover	
24	2	7-05000-240	Heating thread clamping pilehead	
25	1	7-05200-250	Heating thread	
26	1	7-05000-260	Supporting seat	
26.1	1	7-05000-261	Supporting seat(Ⅱ)	
27	1	7-05000-270	Adhesive band	
28	1	7-05000-280	Adjusting screw bracket	
29	1	7-05000-290	Adjusting nut	
30	1	7-05000-300	Proximity switch adjustable screw	
31	1	7-05000-310	Proximity switch cover	
32	2	7-05200-320	Torsion spring supporting cover	
33	1	7-05200-330	Torsion spring block	
34	2	7-05200-340	Torsion spring seat	
35	1	7-05000-350	Torsion spring adjuster	
36	1	7-05000-360	Rubber	
37	1	7-05000-370	Limit block	
38	1	7-05200-380	Tube	
39	1	7-05000-390	Hinge pressing bar	
40	1	7-05200-400	Torsion spring	
41	1	7-05900-410	Aluminum seat	
101	4	201G05	Hex nut, M5	
102	4	200H04008	Truss head machine screw, M4*8	
103	2	202A0409	Plain washer, M4*9	
105	2	200F03008	Flat head cap screw, M3*8	
106	4	201F16	Shim nut, M16	
108	4	202A1632	Plain washer, M16*32	
109	2	200G08015	Socket head set screw, M8*15	
110	2	200A05035	Socket head cap screw, M5*35	
111	1	201A08-1	Hex nut, M8	
112	1	200A08045	Socket head cap screw, M8*45	
113	10	200A06016	Socket head cap screw, M6*16	
114	10	202A061620	Plain washer, Φ6*16*2	
116	29	200F03008	Flat head cap screw, M3*8	
118	1	104H1307	Proximity switch	
119	2	103T024B	Solenoid 24VDC	
120	2	202F062503	Silica gel washer	
121	1	200G03012	Socket head sets screw M3*12	
122	2	2211008022	Press spring	
123	10	200E04008	Phillips head machine screw, M4*8	
124	4	200A05012	Socket head cap screw, M5*12	
125	4	202A0512	Plain washer, M5*12	
126	4	202B05	Lock washer, M5	
127	1	201A03	Hex nut, M3	
128	2	200A05025	Socket head cap screw, M5*25	

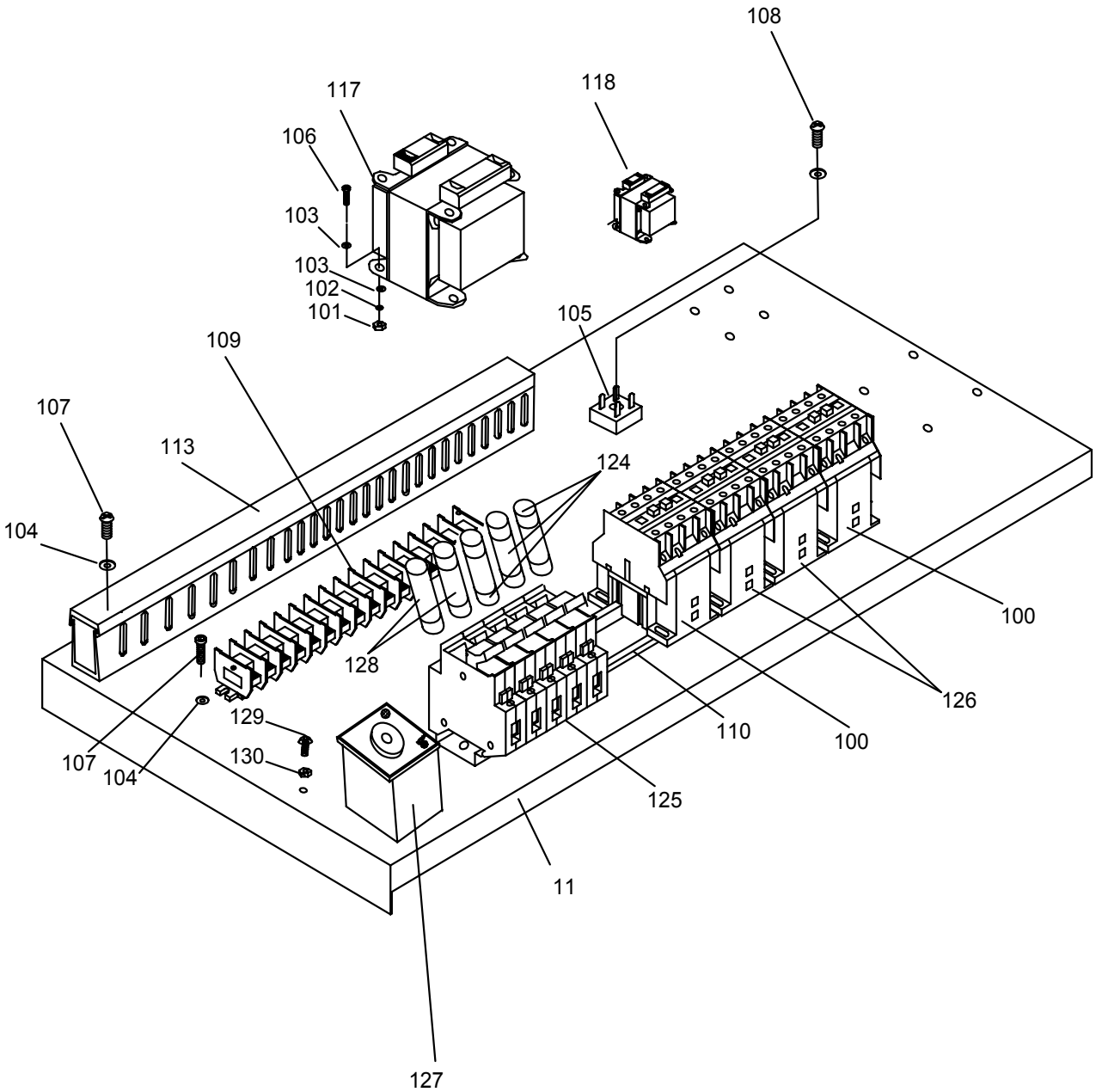
FIGURE 5 -2 : SEALING BAR GROUP

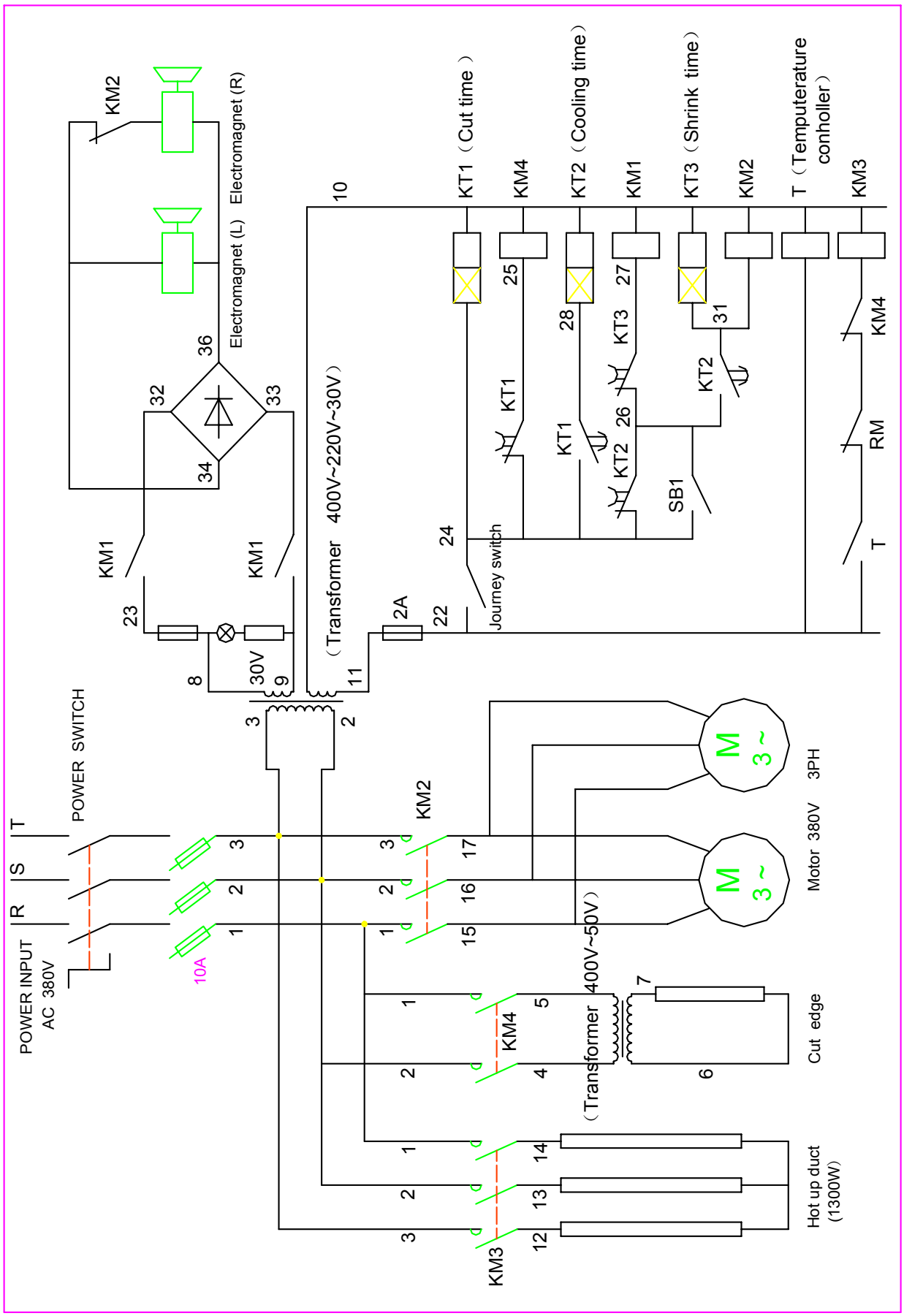


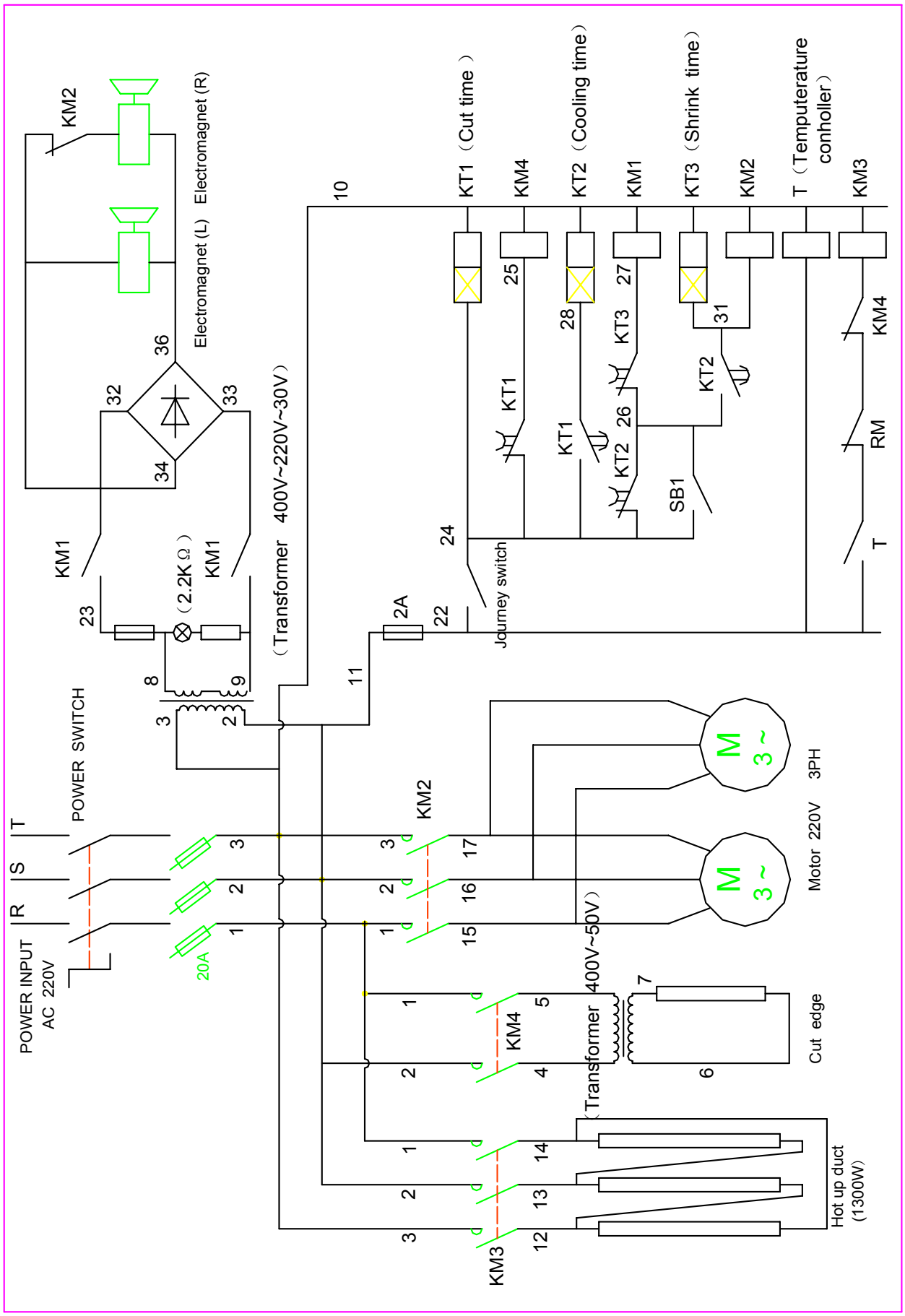
PARTS LIST, FIGURE 6-2 ELECTRICAL UNIT

KEY	Q'TY	PART NO.	DESCRIPTION	FPH-206-062
11	1	7-06200-110	Electrical fixed board	
100	2	106A0610220	Contactor, LC1-D0610-220V	
101	8	201G05	Hex nut, M5	
102	8	202B05	Lock washer, M5	
103	16	202A0512	Plain washer, M5*12	
104	20	202A0409	Plain washer, M4*9	
105	1	113H060006	Rectifier KBPC2510 6A/600V	
106	4	200A05012	Socket head cap screw, M5*12	
107	19	200E04008	Phillips head machine screw, M4*8	
108	1	200E04016	Phillips head machine screw, M4*16	
109	17	152P001	Terminal bracker	
110	0.34m	153FC45	Wire track C45	
113	1.22m	153F3525	Wire track 35*25mm	
117	1	103B2260600	Transformer,220V/60V,600VA	
117	1	103B4050600	Transformer,JBK-600,380-400V/50V,600VA	
118	1	103B2230100	Transformer,220V/30V,100VA	
118	1	103B4030100	Transformer,JBK-100,380-400V/30V,100VA	
124	3	115B3820	Fuse, 20A-38mm 250V	
125	4	115N-RT1832	Fuse seat,RT18-32	
126	2	106A0601220	Contactor, LC1-D0601-220V	
127	1	107E-AH03220	Timer,AH3-2(0-3s)220VAC	
128	2	115B3805	Fuse, 5A-38mm (For 220-240V)	
129	1	200E04035	Phillips head machine screw, M4*35	
130	1	201A04	Hex nut, M4	
131	1	107C024-01	Relay seat PF-083A	

FIGURE6-2: ELECTRICAL UNIT




POWER INPUT
AC 380V
R
S
T
POWER SWITCH
10A
KM2
KM1
KM1
KM2
Electromagnet (L)
Electromagnet (R)
36
32
33
34
23
8
30V
9
3
2
（Transformer 400V~220V~30V）
10
11
2A
22
24
Journey switch
KT1（Cut time）
KM4
KT2（Cooling time）
KM1
KT3（Shrink time）
KM2
T（Temputerature conholler）
KM3
25
28
27
31
KT1
KT1
KT3
KT2
KT2
26
SB1
KM4
RM
T
M
3~
M
3~
Motor 380V 3PH
17
16
15
KM2
（Transformer 400V~50V）
7
6
KM4
5
4
Cut edge
14
13
12
KM3
Hot up duct
(1300W)


POWER INPUT
AC 220V
R
S
T
POWER SWITCH
20A
KM1
KM2
KM3
KM4
Electromagnet (L)
Electromagnet (R)
（2.2KΩ）
（Transformer 400V~220V~30V）
（Transformer 400V~50V）
Journey switch
KT1 （Cut time ）
KT2 （Cooling time）
KT3 （Shrink time）
T （Temputerature conholler）
SB1
RM
Motor 220V 3PH
Cut edge
Hot up duct
(1300W)
2A