



02 9452-3566
sales@getpacked.com.au

Cap Seal Shrink Tunnel

4-SSTPM-BS4NC

User Manual

Contents

1. Description of the machine.....	2
2. Installation	2
3. Operation.....	3
4. Error and elimination	4
5. Maintenance	4
6. Technical Service	4
7. Items not belong to warranty scope.....	5
8. Parts list.....	5
9. Electrical diagrams.....	5

1. Description of the machine

1.1 Overview

Thanks for purchasing the Cap Seal Shrink Tunnel manufactured by our company, it adopts the hot air circulation method which can improve heat efficiency and shrink efficiency. It is widely used in food, medicine, daily used chemical, electrical components, rubber plastic products fields for packing and shrinking products.

1.2 Features

- 1) Adopt “Leister”(made in Europe) hot air gun, the temperature can be easily adjusted, maximum temperature up to 600°C.
- 2) The conveyor speed is adjustable .
- 3) Only shrinking around the cap part, won't affect the product inside the bottle because of the high temperature.
- 4) The whole machine adopts stainless steel with high quality polish-finish.
- 5) Suitable for all kinds of bottles with simple adjustment.

1.3 Performance and specification

Item	Model: PM-BS4	
Max. conveyor speed	M/min	30
Max. cap diameter	inch	4
Max. bottle height	mm	400
Total power	W	3500

2. Installation

The equipment should be installed on the dry and plain ground, and require the electricity of single-phase 220VAC with ground connection(one live wire, one neutral wire, one ground wire), which the power supply wire cutting area is not less than 2.5 square millimeter, and grounded wire cutting area is not less than 1.5 square millimeter.

Caution: The machine must be safety grounding!



02 9452-3566
sales@getpacked.com.au



3. Operation

Before start the machine, please make sure the machine is clean inside and outside.

3.1 Control panel:

No.	Name	Instruction
	Power indicator	Yellow
	Air volume adjust switch	1-10 grades, the higher the grade is, and the higher the air volume will be.
	Heating switch	1-10grades, the higher the grade is, and the higher the temperature will be.
	Digital Temperature controller	To display the temperature of the cap seal shrink tunnel.
	Main switch with function key	Press  3S or more to reset abnormally. Press  to turn on the start power supply.

3.2 Operation procedure

- 1) Put the product under the tunnel, adjust the height of the tunnel, until the lower line of the label is 15-20mm higher than the bottom of the funnel.
- 2) Turn on the main power switch.
- 3) Set up the conveyor and adjust the conveyor speed well.
- 4) Adjust the heating power to zero.
- 5) Turn on the blower button, let the blower on first, then turn on the heating button (It is very important that before turning on the heater, make sure you turn on the blower first, otherwise the “Leister” hot air gun would be damaged!!)
- 6) Adjust the conveyor speed till it meet your speed requirement.
- 7) Adjust the heating power until you get the satisfied shrink result.

Operation Flow:

- 1) Turn on the main power supply. The power supply indicator will be on. The temperature controller will show the temperature value.
- 2) Make the main switch with function key at .
- 3) Turn on the convey belt switch. The power light on the speed controller is on. Turn the black rotary button to adjust the belt speed. Set the value of the speed controller. Different value is for different speed. (the speed depends on the size of the products and the speed of sealing). At the beginning, it is in the middle position. When you have chosen a suitable speed, you can repeat the action to find the best shrink temperature.



02 9452-3566
sales@getpacked.com.au



- 4) Adjust the heat switch grade, until the temperature controller has showed all the requirement temperature.
- 5) According to the product characteristic, set the temperature of the heat switch. When you try the machine, you can rise or decline the temperature according to the effect of shrinking. So that you can find a best temperature and write down this value. Next time, you need not adjust it again.
- * According to the product and shrinking film, generally, the shrink temperature is 150-200°C. You'd better set the temperature in this scope when you set it first time.
6. Stop machine. Before you turn off the RUN switch, please turn off the heater switch firstly. You can stop the machine, until the tunnel temperature is below 70 degrees.

4. Error and elimination

When abnormal occur, please disconnect the power supply first.

4.1 No air flow or low air flow

- 1) Make the grade of air volume adjust switch bigger.
- 2) Check whether the air outlet is blocked.
- 3) Check whether motor is in normal running.

4.2 No heat or insufficient heat

- 1) Make the grade of air volume adjust switch bigger, until the temperature arrive at the value shown on the temperature controller.
- 2) Check whether the air outlet is blocked.
- 3) Check if the heating tubes work properly.
- 4) Check if the heating fuse is broken. If so, you need to replace the heater.

5. Maintenance

5.1 Maintenance instructions

- 1) The conveyor chains should be lubricated once a month with high temperature oil. The lubricant should be applied with a brush or sprayed while the conveyor is slowly running.
- 2) The silicone covering on the tunnel rollers should be inspected regularly to assure that no scrap pieces of film are wrapped around the rollers to cause sticking of packages. Make sure the conveyor is stopped before putting your hands or anything else in the conveyor area. If necessary to remove the film residue, use a dull, blunt-edged tool. Do not use any sharp instruments, as nicking the silicone may result in having to replace the roller covering.

6. Technical Service

Our company provide after-sales technical services , under the situation of proper use and maintenance of products.

- 1) Warranty, one year warranty from the date of delivery, life-long repair.
- 2) Replacement parts at preferential price, provide extended function service and corresponding technical support.



02 9452-3566

sales@getpacked.com.au



7. Items not belong to warranty scope

- 1) Damage due to the user's improper use, maintenance, transportation and storage.
- 2) The machine has been supplied incorrect power supply.
- 3) Damage is caused by Force Majeure such as natural disasters.
- 4) Exceed warranty period.
- 5) The machine is not been fully paid.

8. Parts list

Electrical Parts List					
Name: PM-BS4					
Production No.:					
Designer: Hua Peng					
Date:					
No.	Name	SPEC.	Brand	QTY	Remark
1	Main switch	LW42B32	TAYEE	1	
2	Breaker	DZ47-60, 2P, D25	CHINT	1	
3	Temperature controller	AI-218-D1-G-L0	YUDIAN	1	
4	Power indicator	AD16-22D/Y31	APT	1	
5	Switzerland Hot air gun	9C1	Leister	1	
6	Fan	DP200A		1	
7					
8					
9					

9. Electrical diagrams



02 9452-3566
sales@getpacked.com.au

