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佛山市瑞普华机械设备有限公司

包装机故障处理图解



How to run a flow packaging machine softly?

Flow packaging machine operation instruction and some main errors you might be occurred.

- 本资料包含我司ZP100、ZP320、ZP380、ZP500、ZP420、ZP500SG
- 主要内容：
 1. 各部件名称及功能
 2. 常见故障及排除
 3. 日常保养
 4. 操作安全

This information contains our ZP100, ZP320, ZP380, ZP500, ZP420, ZP500SG

main content:

1. Name and function of each part
2. Common faults and troubleshooting
3. Daily maintenance
4. Operational safety

包装膜托纸部份 Film support for packaging machine

主要功能：固定包材、对中微调、平稳供料

Main function: Fix the packaging material , centring adjustment and film feeding smoothly

中封对中微调，顺时针进，逆时针出(请参考标识)；最大调整为20mm

Centring adjust, clockwise in,
anticlockwise out. Max.adjust 20mm

活动锁紧螺母，锁紧包膜

Adjust the screw to fix the film

刹车皮带，控制包膜松紧，若包材直径变小时袋长变短请调节松动些
Brake belt, control the tightness of the coating, if the diameter of the packaging material becomes smaller, the length of the bag becomes shorter, please adjust it to loosen it

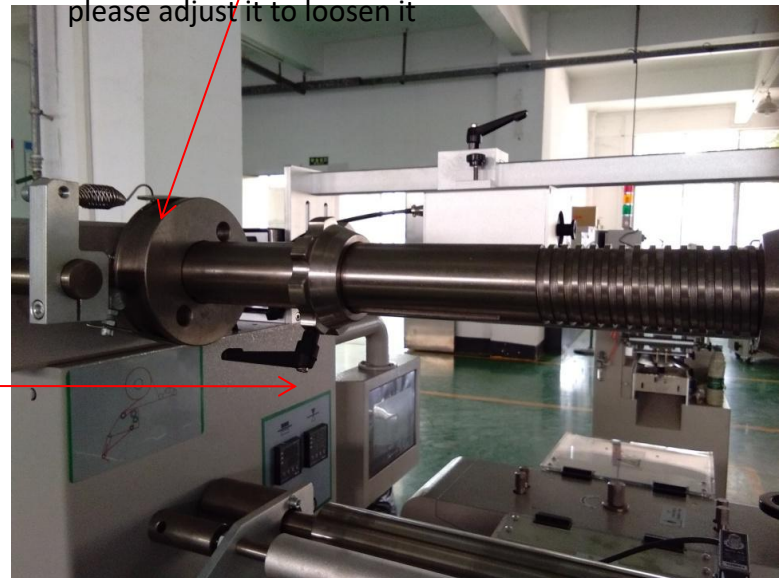


1. 固定包装材料
2. 包膜中封对中微调
1. Fixed packaging materials
2. Fine-tuning the center seal of the envelope

2. Envelope limit locking handle

包膜限位锁紧把手，包材宽度变化时调节

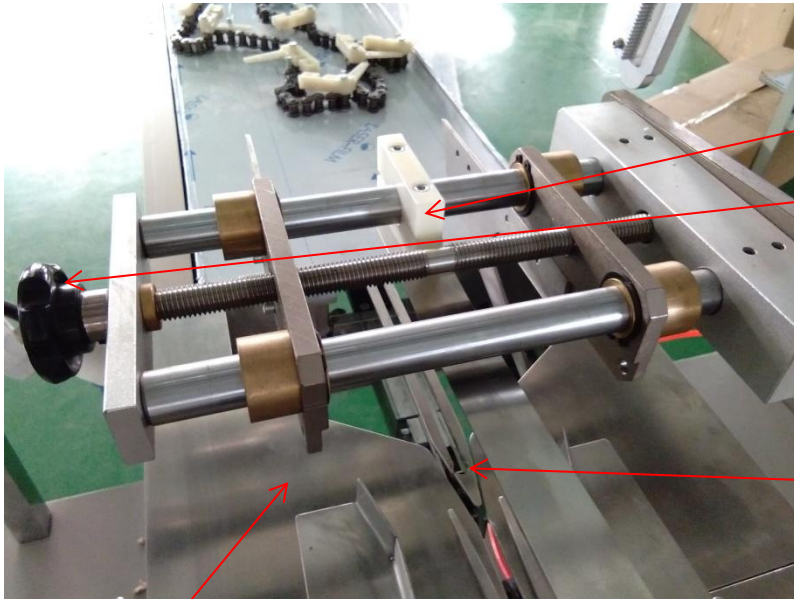
Envelope limit locking handle
Adjust when the width of the
packaging material changes



成袋器部份 Bag former

主要功能：包装材料预制成扁筒状，利于物料进入包装

Main function: The packaging material is pre-made into a flat tube shape, which is conducive to the material entering the packaging



压条，辅助产品进包装代
Layering, auxiliary products
into the packaging generation

制袋器宽度调节 Adjust bag
width

三角支撑板，高度同短远短近平齐
此板同产品宽度（直径）有关系
Triangular support plate,
the height is the same as the short distance

This board is related to the product
width (diameter)

短远短近支撑板
此板同产品宽度（直径）有关系
Short and short support plate
This board is related to the product width (diameter)

1. 包膜成型关键部件 Key components of envelope molding

成袋器部份 Bag former

主要功能：包装材料预制成扁筒状，利于物料进入包装

Main function: The packaging material is pre-made into a flat tube shape, which is conducive to the material entering the packaging

成袋器燕尾板 Bag
Former Dovetail
Board



制袋器高度固定镙丝，同产品高度有关
The height of the bag maker is fixed with
the screw, which is related to the height
of the product

1. 包膜成型关键部件 Key components of envelope molding

包装膜传送部份

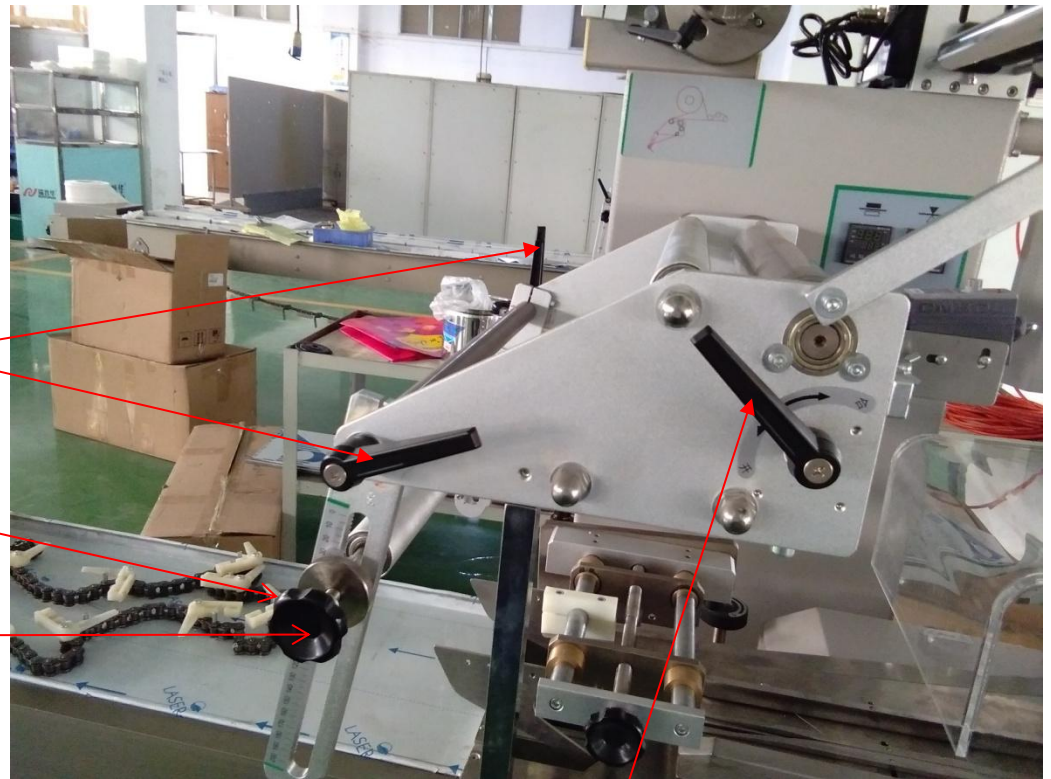
Packaging film transfer part

主要功能：制袋平整、保障顺畅送包装膜
Main functions: make the bag smooth and ensure smooth delivery of the packaging film

摆臂张紧手柄 Swing
arm tension handle

可调张紧滚筒 Adjust
roller tension

摆臂 Swing arm



送膜压合辊手柄
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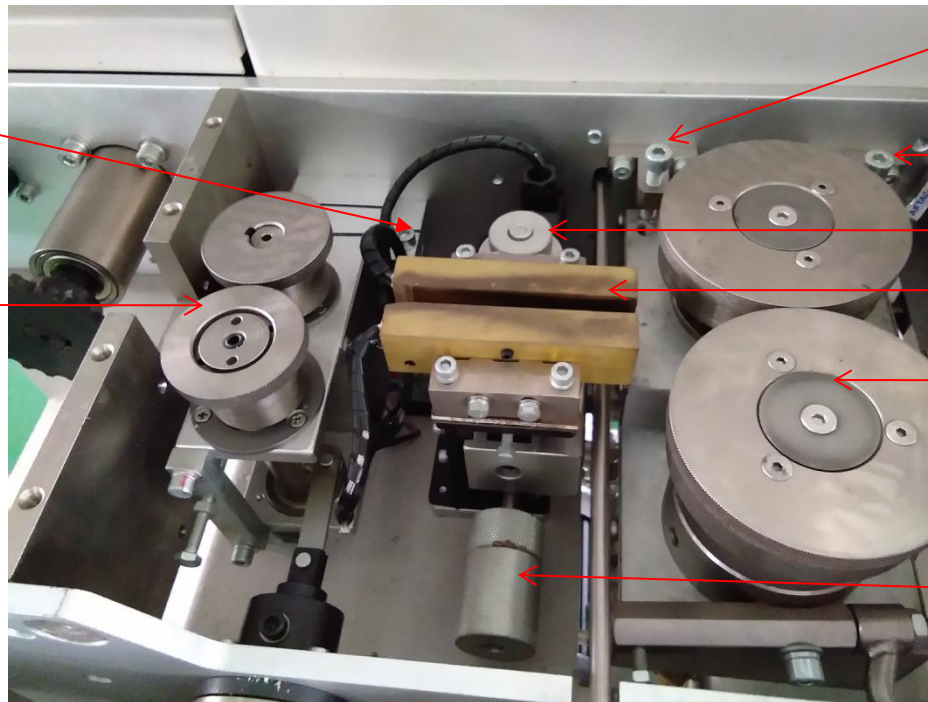
中封部份1 Middle sealing part

主要功能：中封预加热、压合封口

Main functions: pre-heating for middle seal, pressure-sealing

送纸轮紧固镙丝
Fill feeding roller
screw

送纸轮
Film feeding roller



B

A

电磁铁
Electromagnet

中封烫块 Mid-seal
heater

印花轮（压合轮）
Embossing roller

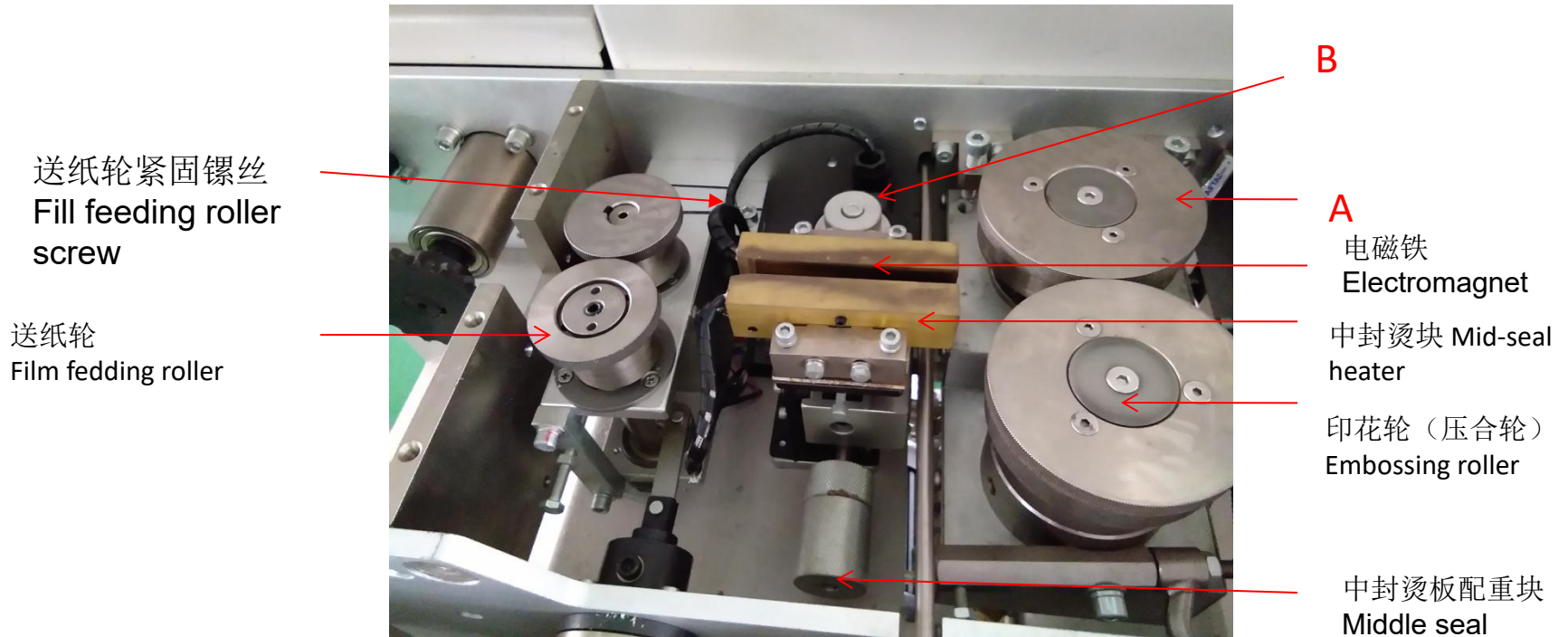
中封烫板配重块
Middle seal
ironing board
counterweight

1. 送纸轮，正常情况下应保持水平状态。
2. 印花轮，正常情况下应向刀座方向倾斜，约5度左右；A点松B点紧是向前上倾斜。
3. 中封烫板，前后烫板水平一致，两间隙左右平行一致；常温下，间隙接近于包装膜的厚度较理想。
4. 印花轮线速度应略大于送纸轮纸速度；若过快，整个中封会出现斜拉痕迹；若偏慢，中封易跑出烫板或中封偶尔出现折痕。
5. 中封烫板配重块，设备运行过程中，暂停时中封烫板快速打开，避免包材烫坏，此部件正常时如果不能快速打开的，清洁内部齿轮和传动轴

中封部份1 Middle sealing part

主要功能：中封预加热、压合封口

Main functions: pre-heating for middle seal, pressure-sealing



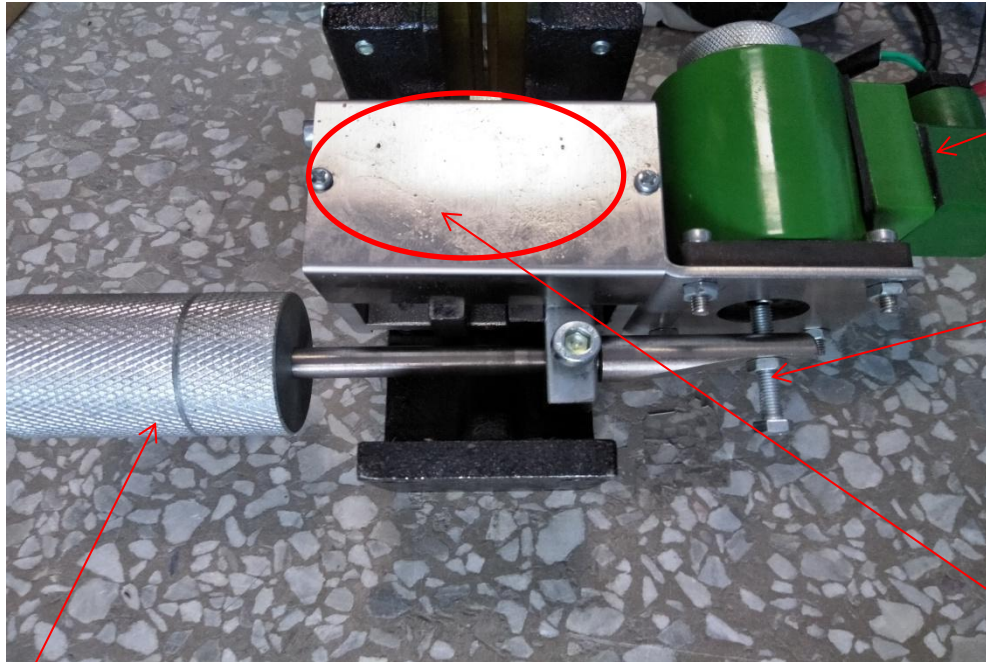
1. The paper feed roller should be kept horizontal under normal circumstances.
2. The printing wheel, under normal circumstances, should be inclined to the direction of the tool holder, about 5 degrees; point A is loose and point B is tight, and it is inclined forward and upward.
3. In the middle seal ironing board, the front and back ironing boards are of the same level, and the two gaps are parallel to the left and right; at room temperature, the gap is close to the thickness of the packaging film.
4. The linear speed of the printing wheel should be slightly higher than the paper speed of the paper feeding wheel; if it is too fast, the entire middle seal will appear diagonally; if it is too slow, the middle seal will easily run out
5. Occasionally creases appear on the ironing board or the middle seal.
6. 5. The middle seal ironing plate counterweight, during the operation of the equipment, the middle seal ironing plate is opened quickly when the equipment is paused to prevent the packaging material from being burned. If this part cannot be opened quickly when it is normal, clean the internal gear and drive shaft

中封部份2

主要功能：运行和停止时，改变包材受热状态

Middle seal part 2:

Main function :change the heating state of the packaging material when running and stopping



中封电磁铁，工作时指示灯亮
Middle seal electromagnet,
indicator light is on when working

中封配重顶杆镙丝，当停机时，中封烫板张开缓慢时，可向下调节
The middle seal counterweight jack screw, when the machine is stopped, the middle seal ironing plate opens slowly, it can be adjusted downwards

中封烫板齿轮安装处，当烫板动作受阻时，拆开外盖检查清洁
The middle seal ironing plate gear installation position, when the ironing plate action is obstructed, disassemble the outer cover to check and clean

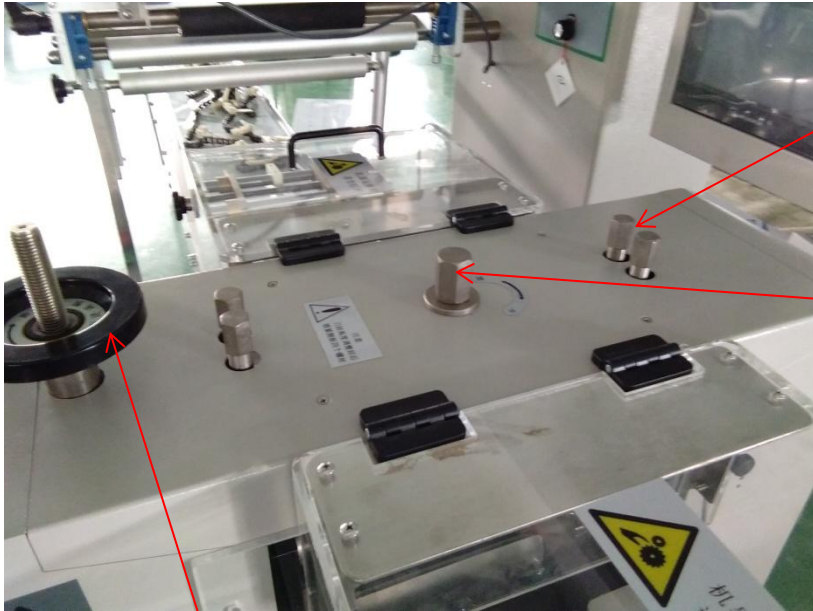
中封烫板配重块，加速启动瞬间闭合
The counterweight of the middle sealing ironing board, accelerates the start and closes instantly

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刀封机构部份1 **Cutter part**

主要功能：刀速调整、刀座中心高度调整、压力调整、横向密封

Main functions: knife speed adjustment, tool holder center height adjustment, pressure adjustment, horizontal sealing



刀封压紧螺杆，刀座压力可在此微调The knife seal compresses the screw rod, and the pressure of the knife holder can be fine-tuned here

刀座高度调节，产品高度变化时，由此调节The height of the knife holder is adjusted, when the height of the product changes, it can be adjusted accordingly

刀速调节手轮，袋长变化后，刀封速度由此调节，顺时针调整刀速慢，逆时针调整刀速快Knife speed adjustment hand wheel, after the bag length changes, the knife sealing speed is adjusted accordingly, Clockwise adjustment of knife speed is slow, counterclockwise adjustment of knife speed is fast

刀封压力弹簧
Spring for cutter

切刀顶丝Cutter top wire

上刀座
Upper cutter jaw

下刀座
Down cutter jaw



刀封机构部份2 **Cutter part**

主要功能：导电加热、温度传送、上下刀座同齿位调整及传动
Main functions: conductive heating, temperature transmission, adjustment and transmission of the upper and lower tool holders at the same tooth position

上刀座碳刷 Upper tool holder
carbon brush

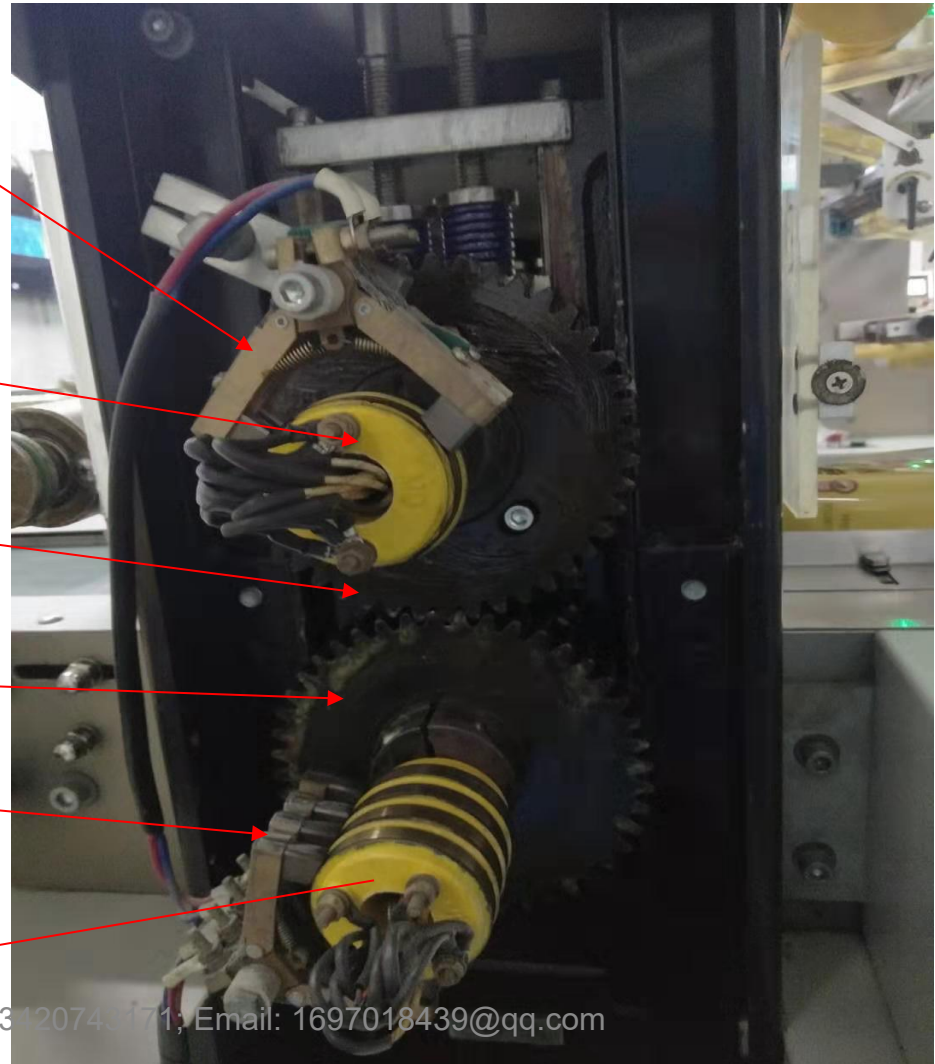
上刀座导电环 Upper knife seat
conductive ring

上刀座报紧齿轮 Upper cutter jaw
tightening gear

下刀座报紧齿轮 Down cutter jaw
tightening gear

下刀座碳刷 Carbon brush for down
cutter
jaw

下刀座导电环 Conductive ring for down
cutter
jaw

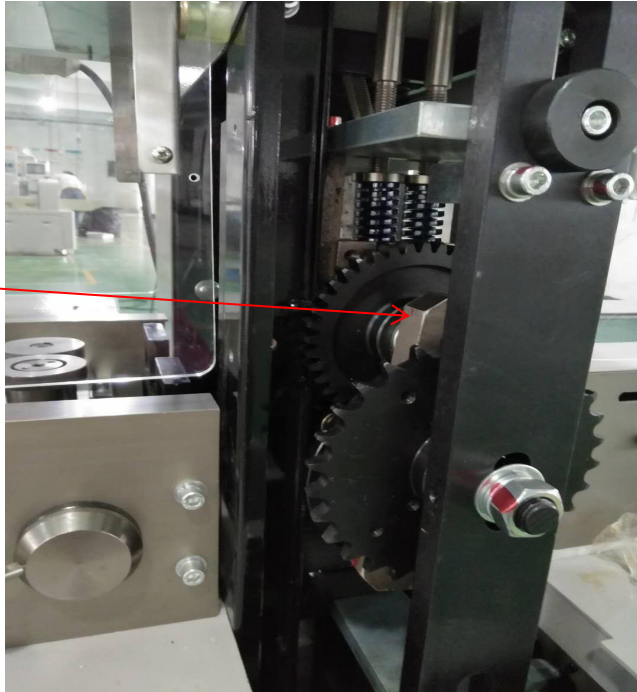


刀封机构部份3 Cutter part 3

主要功能：刀座变速角度调整

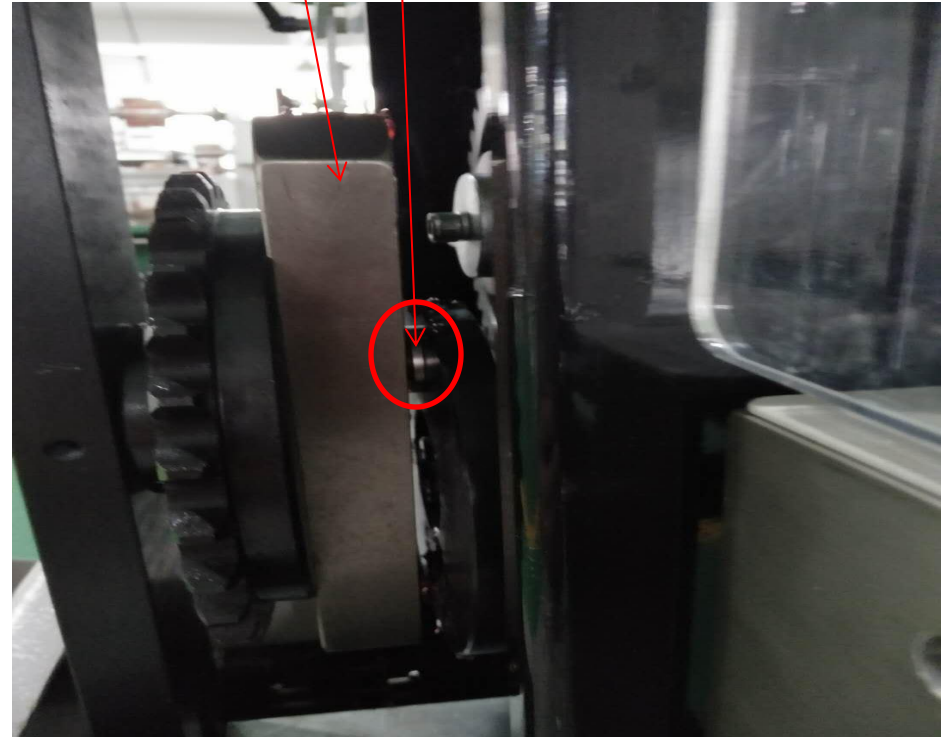
Main function: adjustment of the shift angle of the tool holder

滑槽
Chute



滑槽Chute

偏心位轴承Eccentric bearing



1. 滑槽正确位置，上下刀封垂直对齐时，滑槽垂直，偏心位轴承位于12点位置
1. The chute is in the correct position. When the upper and lower knife seals are vertically aligned, the slide The groove is vertical, the eccentric bearing is located at the 12 o'clock position

物料位置调节和中封压合轮线速度调节

Material position adjustment and center seal pressing wheel linear speed adjustment

物料位置调节手柄

主要功能：保证物料处理包装袋的中间位置
Material position adjustment handle
Main function: to ensure the middle position of the material handling bag

压合轮速度调节手柄

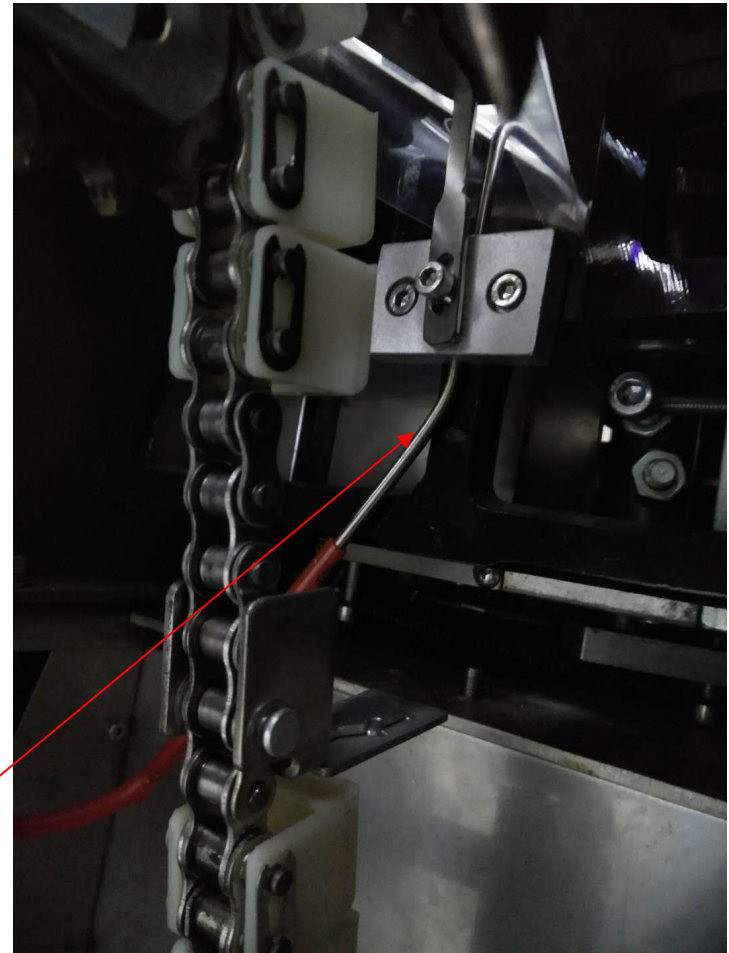
主要功能：保证压合轮线速度略大于送纸轮线速度
Pressing wheel speed adjustment handle
Main function: to ensure that the linear speed of the pressing wheel is slightly greater than the linear speed of the paper feed wheel



充气部份（选配） **Air charging (optional)**

主要功能：挡条保障气管不接触物料，防走位

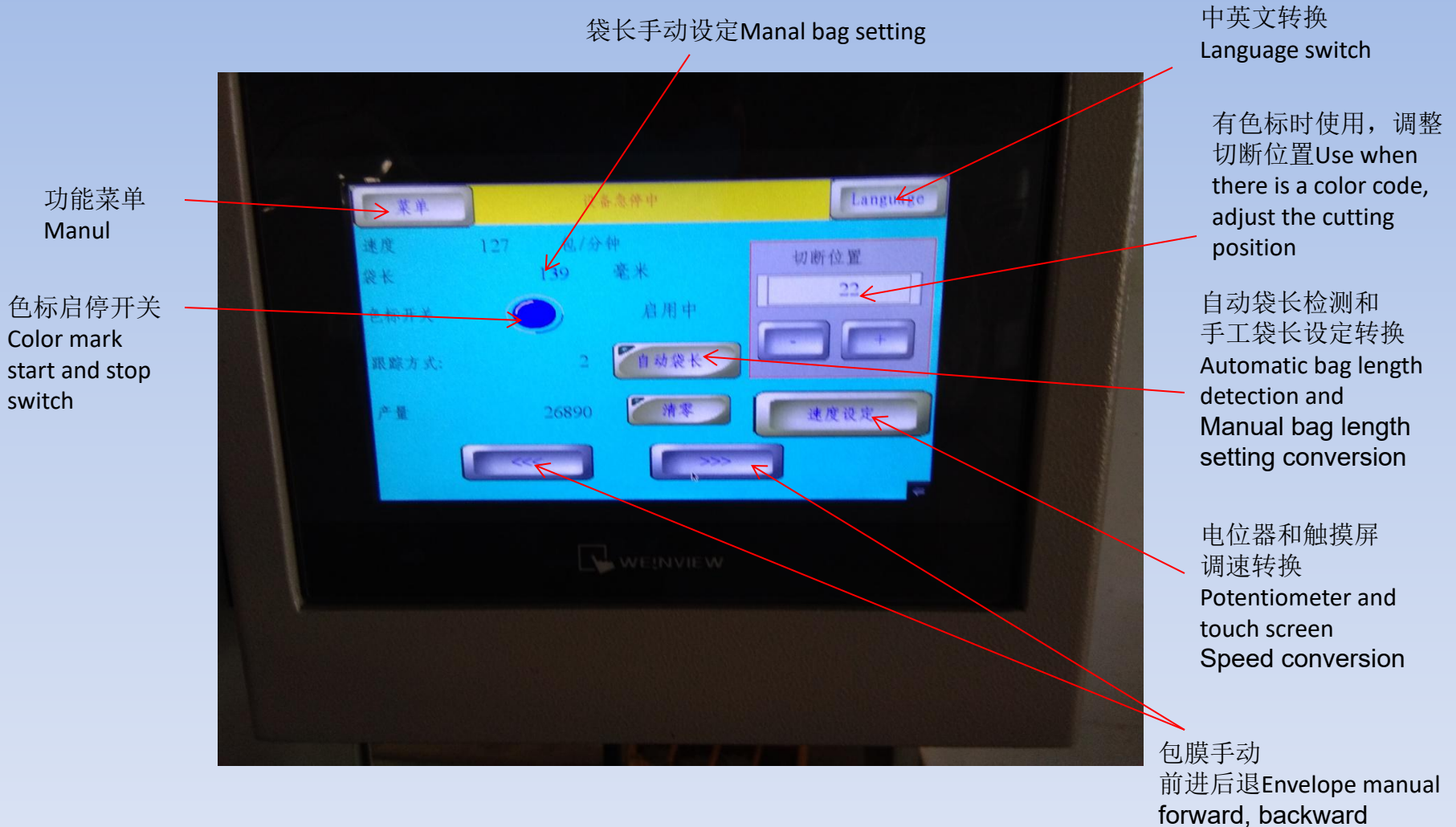
Main function: The retaining strip ensures that the air pipe does not touch the material and prevents it from moving



充气挡条，充气管必须低于
气管压条Inflatable barrier,
the inflatable tube must be
lower than the tracheal layer

充气管 **Air charging pipe**

触摸屏部份 1 Touch screen

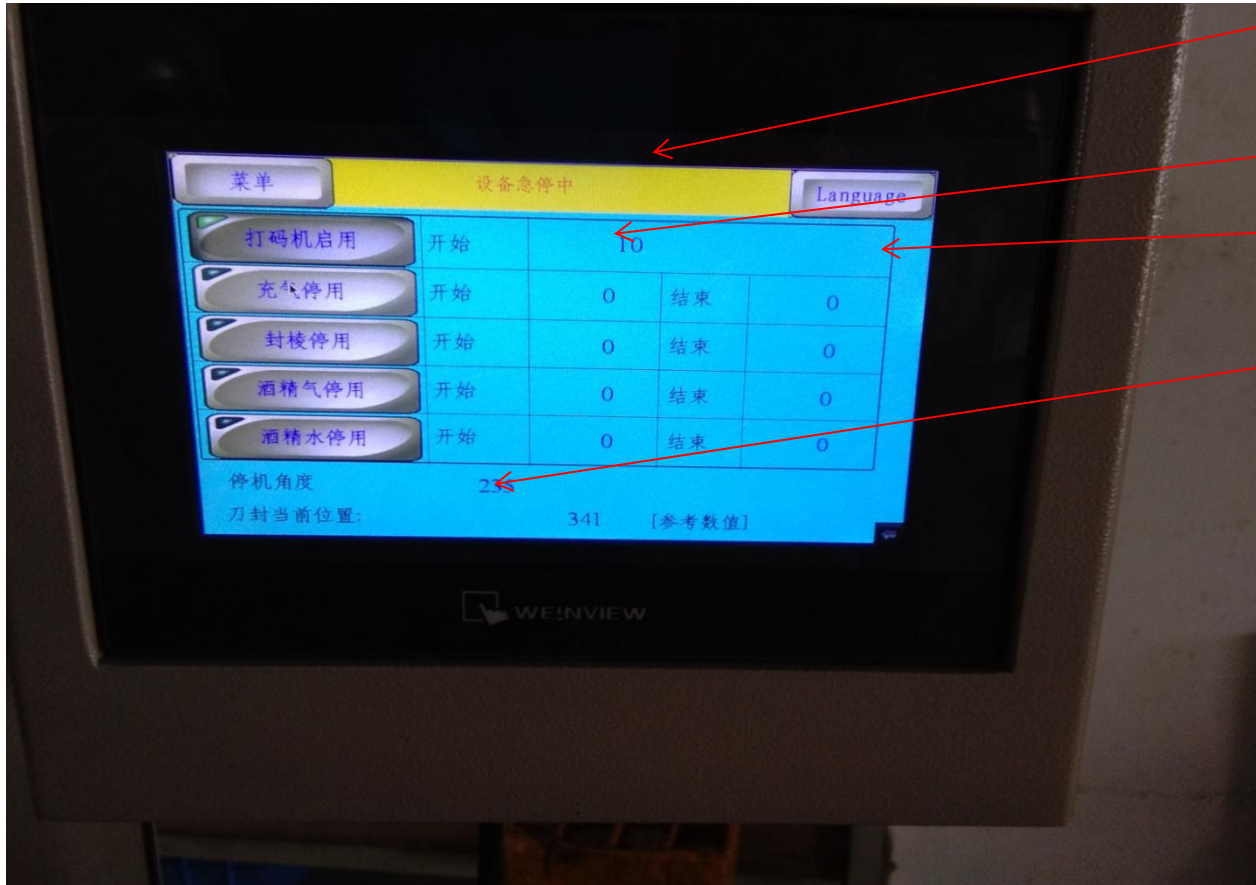


主控画面 Main control

触摸屏部份 2 Touch screen

点击菜单 → 功能设置

Click on the menu → Function settings



打印位置调整 Printing location adjust

充气结束角度 Air charging finishe angle

充气开始角度 Charging start angle

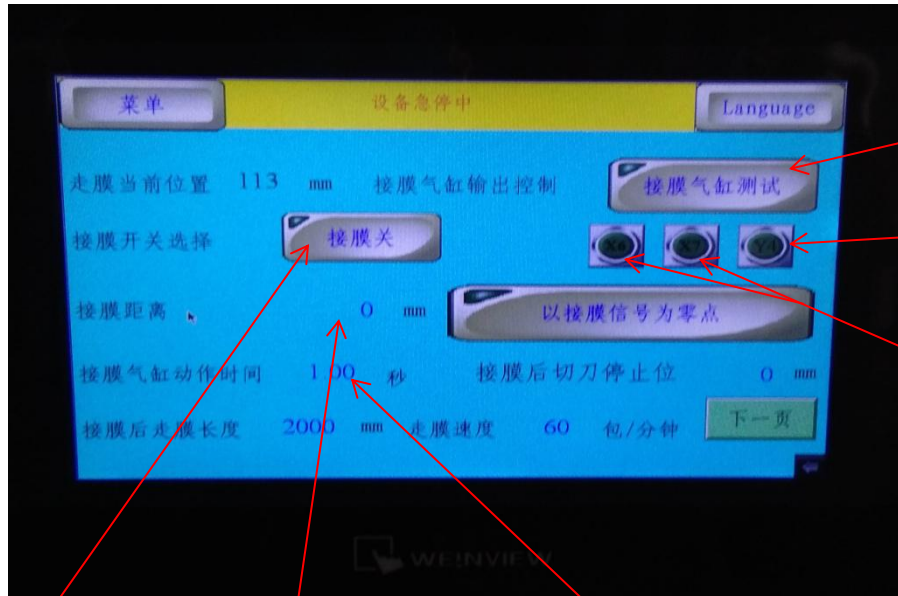
刀封停止角度，循停时有用
Knife seal stop angle, useful for cyclic stop

充气开始位置，应在刀座快闭合的时候，两刀间隙应该在15mm左右开始，结束位置比开始多10--20左右较宜；其他几项设置方式同充气相同。充气量同刀速，氮气压力，充气时间和刀座高低有一定关联。The start position of inflation should be when the knife holder is about to close. The gap between the two cutters should start about 15mm, and the end position should be about 10-20 more than the beginning; the other settings are the same as the inflation. The inflation amount is related to the knife speed, nitrogen pressure, inflation time and the height of the knife holder.

功能设置菜单

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触摸屏部份 3 Touch screen



接膜动作测试按钮 Auto splicing film testing

接膜输出指示 Splicing output

包膜状态指示 Film situation instruction

接膜功能开关
Splicing on

信号到接膜
的距离 Single and splicing film distance.

接膜工作时长 Splicing working time

自动接包装膜功能（选配功能）

温度控制仪表

Temperature control instrument

正常情况下，速度5-10包左右波动，温度可以不改变，充气产品请注意渗漏检测
Under normal circumstances, the speed fluctuates about 5-10 packs, and the temperature does not need to change. Please pay attention to leakage detection for inflatable products

中封表
Middle seal

横封表
Horizontal seal

135
135

150
150

设置键
Setting

数字加减 number
add/lee

黄灯闪烁 请勿调试刀封

常见问题预防及处理

新包材的压力测试

Prevention and treatment of common problems

Pressure test of new packaging materials

- 新包材确认

1. 购包装材料前，请先取样进行压力测试。
2. 建议检测方法，取同材质，同厚度的包装材料约5Kg以上（视材料厚度和宽度、袋长增加数量）。
3. 用一台正常使用的包装机（充气和不充气之分），先设定好需求速度、温度和充气压力（若是需要充气量很足，建议在0.3-0.35Mpa；若含氧量需要在5%以下时，可延长充气时间值；一般充气时间值建议不要超过20）。相关参数可参考原有包装使用过的参数值。
4. 连续预制（充气）空袋20个，进行气密测试，根据要求调测试压力，保障无漏气条件下，再连续预制（充气）空袋50--100个测试，保障无漏气条件下，可视为能满足要求。

New packaging material confirmation

1. Before purchasing packaging materials, please take samples for pressure test.
2. The recommended testing method is to use the same material and thickness of the packaging material above about 5Kg (depending on the thickness and width of the material, The bag length increases the number).
3. Use a normal packaging machine (inflated and non-inflated), first set the required speed, temperature and charging Air pressure (if sufficient inflation is required, it is recommended to be 0.3-0.35Mpa; if the oxygen content needs to be below 5%, The inflation time value can be extended; the general inflation time value is recommended not to exceed 20). Related parameters can refer to the original package Install the used parameter value.
4. Continuously prefabricated (inflated) 20 empty bags for air tightness test, and adjust the test pressure according to requirements to ensure no air leakage

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Under the conditions, the prefabricated (inflated) empty bags are continuously tested for 50-100 times to ensure that

常见问题预防及处理

新包材的压力测试

Prevention and treatment of common problems

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Air pressure (if sufficient inflation is required, it is recommended to be 0.3-0.35Mpa; if the oxygen content needs to be below 5%,

The inflation time value can be extended; the general inflation time value is recommended not to exceed 20). Related parameters can refer to the original package

Install the used parameter value.

4. Continuously prefabricated (inflated) 20 empty bags for air tightness test, and adjust the test pressure according to requirements to ensure no air leakage

Under the conditions, the prefabricated (inflated) empty bags are continuously tested for 50-100 times to ensure that under the condition of no air leakage, they can be regarded as energy fulfil requirements.

横封封口漏气处理

- 横封封口漏气主要分四个类型：
 1. 渗漏（红色区内）
 - 测漏表现为，从横封封口切断处外溢气泡
 - 故障原因：温度不够或者刀座压力不足
 - 处理方法：提升温度；加紧压弹簧或需调校刀座
 2. 切破包材漏气（绿色区）
 - 测漏表现为，在横封封口靠产品侧第一道牙纹处外溢气泡
 - 故障原因：刀速过快；刀座错齿或者温度过高
 - 处理方法：降低刀速；调整刀座或降温度
 3. 横封封口处夹渣漏气
 - 主要是充气产品和肉松类面包
 - 处理方法：减小充压力、充气量或者改善产品特性；提高肉松附着力
 4. 充气产品时，充气压力过大时，易撑破中封和刀封交叉处，请注意包装材料的热合时间、温度、抗压能力，适当增减充气压力和充气量



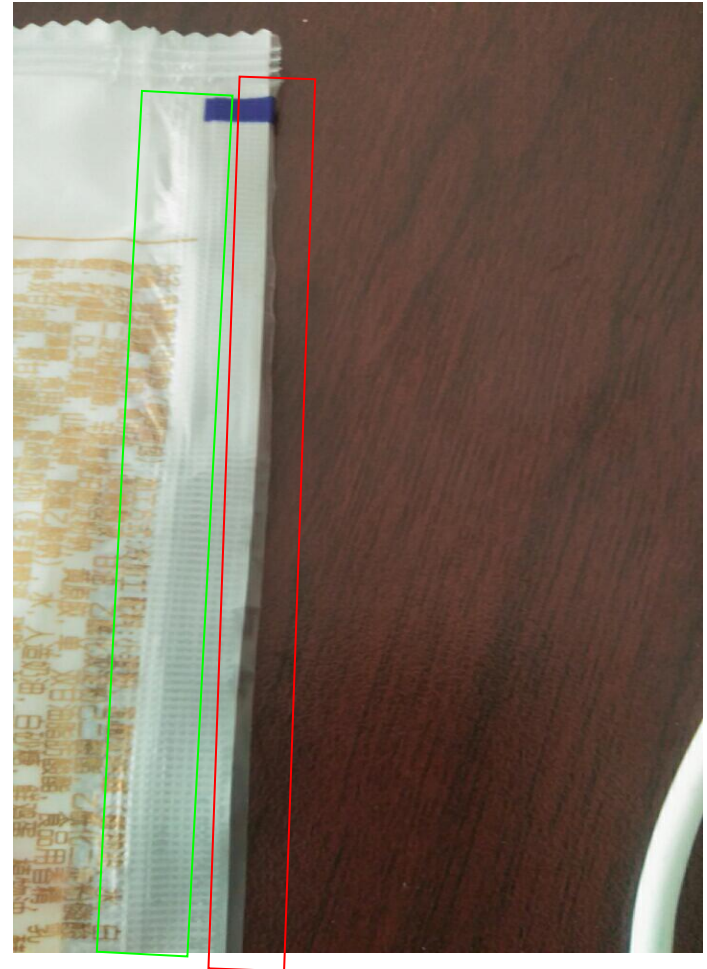
Horizontal sealing sealing air leakage treatment

- There are four main types of horizontal seal leakage:
 1. Leakage (red area)
 - Leak detection is manifested as bubbles overflowing from the cut-off part of the horizontal seal
 - Cause of failure: insufficient temperature or insufficient tool holder pressure
 - Treatment method: increase the temperature; tighten the compression spring or need to adjust the tool holder
 2. Cut the packaging material to leak air (green area)
 - Leak test performance is that bubbles overflow from the first tooth pattern on the product side of the horizontal seal
 - Cause of failure: tool speed is too fast; tool holder has wrong teeth or temperature is too high
 - Treatment method: reduce the knife speed; adjust the knife seat or lower the temperature
 3. Air leakage due to slag inclusion at the horizontal seal
 - Mainly aerated products and meat floss bread
 - Treatment method: reduce the filling pressure, the amount of aeration or improve the product characteristics; improve the adhesion of the meat floss
 4. When inflating products, when the inflation pressure is too high, it is easy to break the intersection of the middle seal and the knife seal. Please pay attention to the heat sealing time, temperature, and pressure resistance of the packaging material, and increase or decrease the inflation pressure and the amount of inflation appropriately



中封封口漏气处理

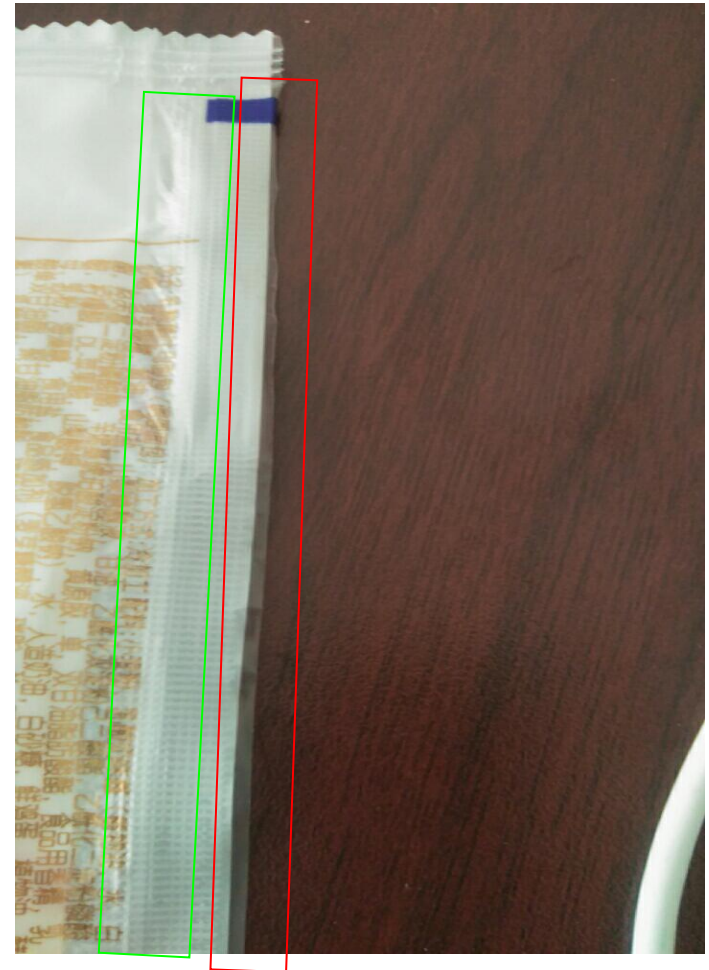
- 中封封口漏气主要分三个类型：
 1. 渗漏（红色区内）
 - 测漏表现为，从中封封口外边沿处渗气泡
 - 故障原因：温度不够或者烫板间隙过大
 - 处理方法：提升温度；调小烫板间隙
 2. 粘合不牢漏气（绿色区）
 - 测漏表现为，在中封封口靠产品侧，出现渗气泡
 - 故障原因：铜块上边沿90度直角处有磨损，导致受热不均，封口成点状热合
 - 处理方法：提高温度或更换加热烫板
 3. 中封封口处夹渣漏气
 - 主要是充气产品和肉松类面包
 - 处理方法：减小充压力、充气量或者改善产品特性；提高肉松附着力；以上均无法解决时，请评估更换机型



Treatment of air leakage in the middle seal

- **There are three main types of air leakage in the middle seal:**

- 1. Leakage (red area)
- Leak test performance is that bubbles seep from the outer edge of the seal
- The cause of the failure: the temperature is not enough or the ironing board gap is too large
- Treatment method: increase the temperature; adjust the gap between the ironing plates
- 2. Poor adhesion and air leakage (green area)
- The performance of leak detection is that there are bubbles appearing on the side of the middle seal close to the product.
- The cause of the failure: the upper edge of the copper block has abrasion at a 90-degree right angle, resulting in uneven heating, and the sealing becomes a spot-like heat seal
- Treatment method: increase the temperature or replace the heating ironing board
- 3. Air leakage due to slag inclusion at the middle seal
- Mainly aerated products and meat floss bread
- Treatment method: reduce the charging pressure, the amount of aeration or improve the product characteristics; improve the adhesion of the meat floss; if none of the above can be solved, please evaluate and replace the model

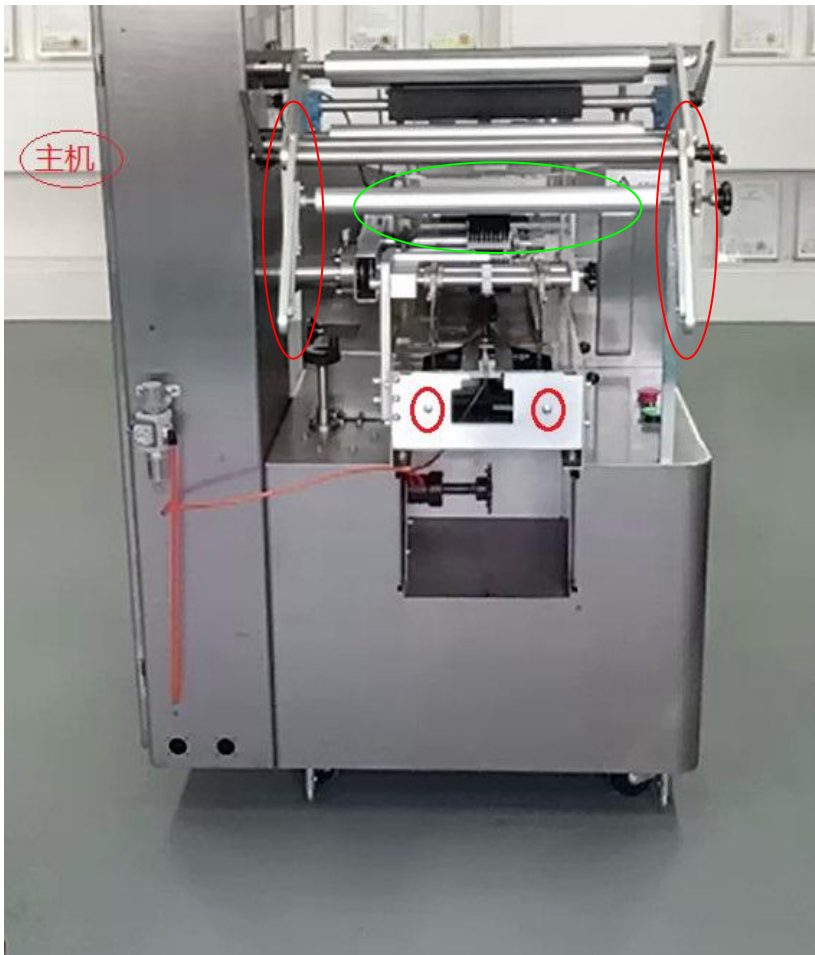


横封封口处折皱处理₁

- **横封口处折角因素有6种**
- 1. 空袋对折不平整，有折皱现象
- 处理方法：检查以下两点，
 - 一、可摆动调节臂左右尽可能保持平行；
 - 二、可调张紧滚筒左右不平行，尽可能调致平行；
- 2. 刀座中心点与产品高度中心点不一致，调整刀座高度，使其一致；
- 3. 物料位置不在包装袋的中心位置，或者位置随机变化，调整料位或检查压条、推杆的灵活性；
- 4. 刀速过慢，加快刀速，提高包装材料的延展性
- 5. 充气，充气角度不同，主要会引起物料位置发生了变化，导致折皱现象
- 6. 制袋器成型板同可调张紧臂角度过小，导致包装膜划痕偏深，易出现折角



横封封口处折皱处理₂



空袋对折不平整，有折皱现象

处理方法：检查以下两点，

一、可摆动调节臂左右尽可能保持平行；（红色区域）

二、可调张紧滚筒左右平行，尽可能调致平行；（绿色区域）

Wrinkle treatment at the horizontal seal 2



The empty bag is not flat and wrinkled

Solution: Check the following two points,

1. The swingable adjusting arm should be kept parallel as far as possible; (red area)
2. The adjustable tension roller is parallel to the left and right, and adjust it as parallel as possible; (green area)

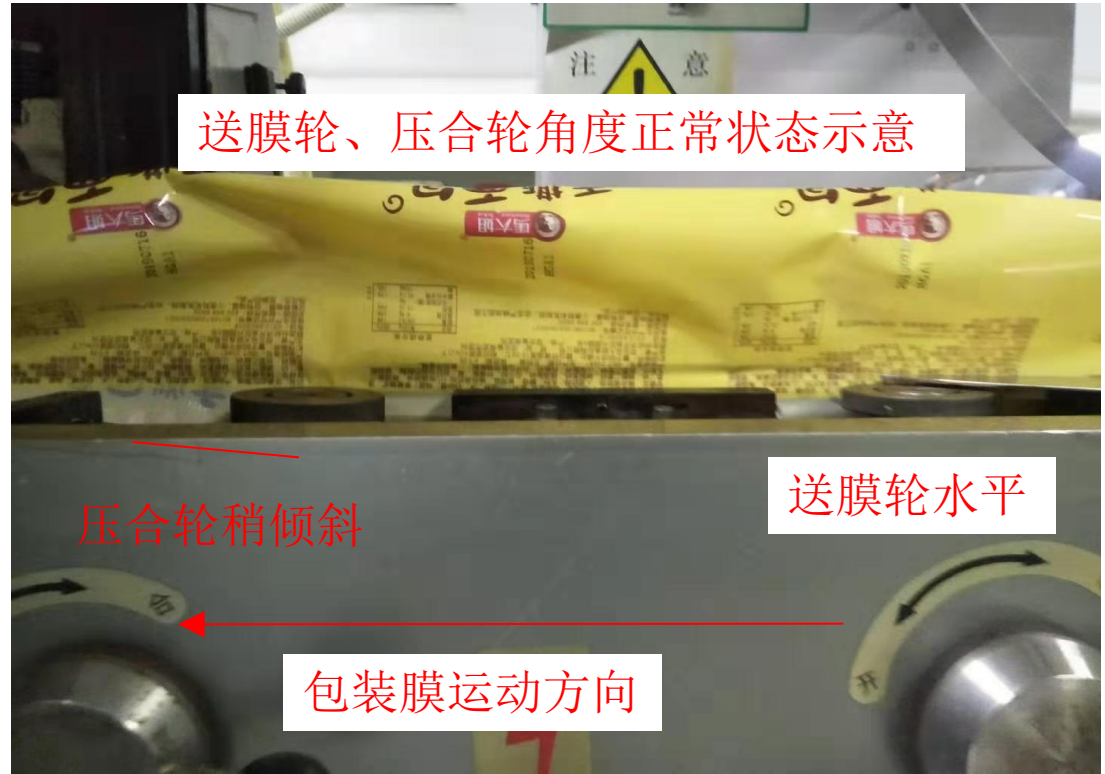
中封封口处折皱处理

中封出现折皱原因：

1. 压合轮线速度小于或等于送膜轮时，会出现偶有折皱，甚至爆中封

2. 压合轮线速度太大于送膜轮时，中封封口会出现比较细密的斜拉痕

处理方法：调节压合轮速度手柄，改变其线速度，致其美观为止

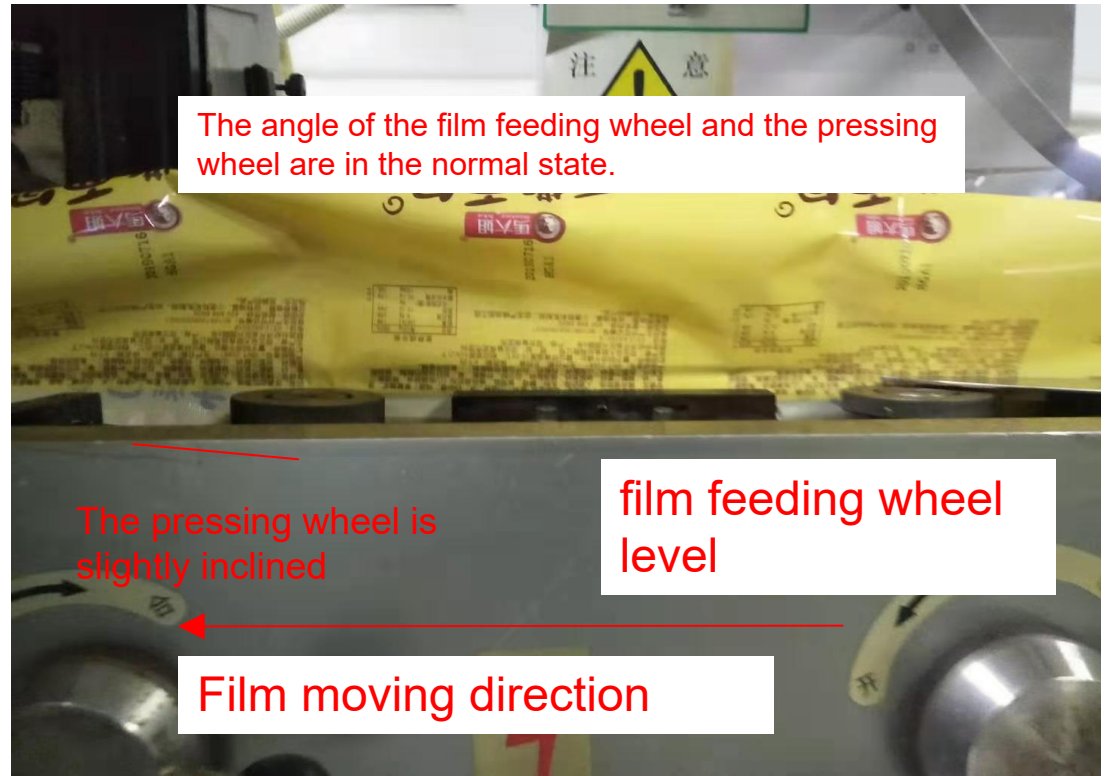
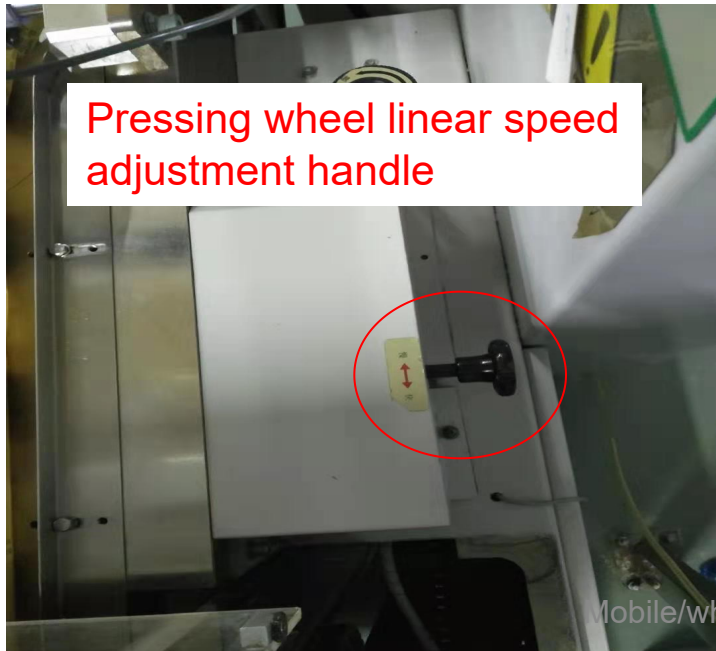


Wrinkle treatment at the horizontal seal 2

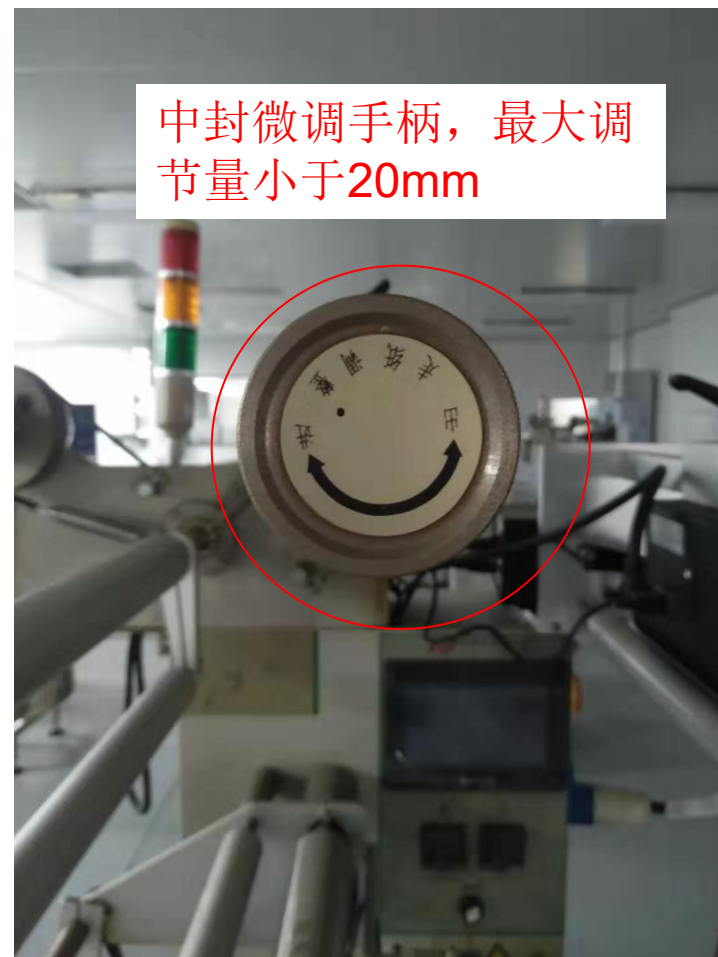
Reasons for wrinkles in the middle seal:

1. When the linear speed of the pressing wheel is less than or equal to the film feeding wheel, there will be occasional wrinkles, or even burst seal
2. When the linear speed of the pressing wheel is too large than the film feeding wheel, a relatively fine diagonal pull mark will appear on the middle seal.

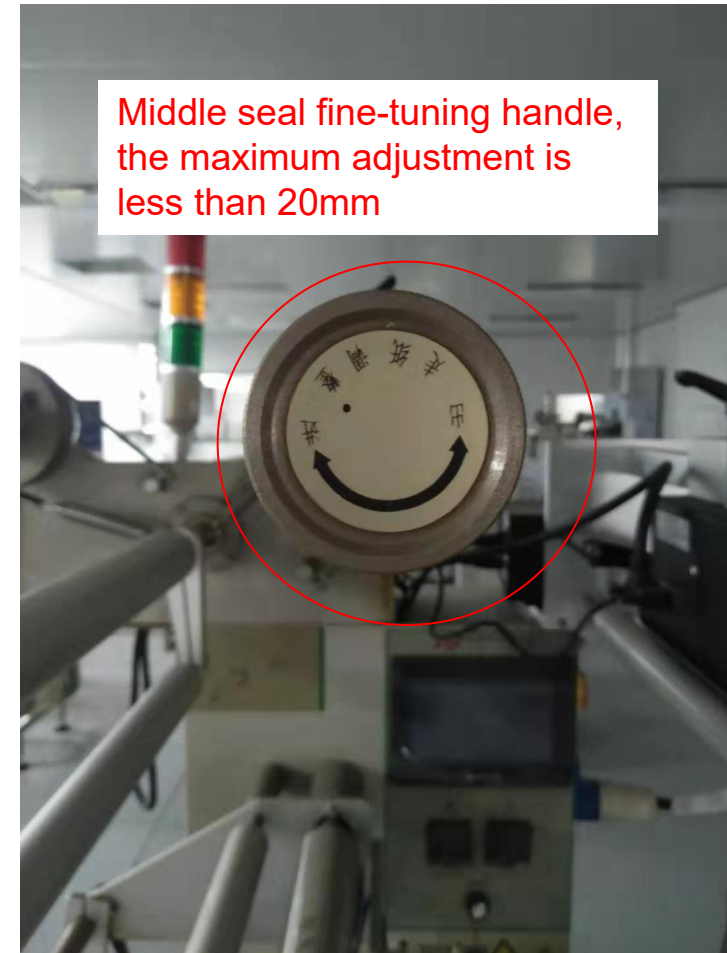
Processing method: adjust the speed handle of the pressing wheel and change its linear speed to make it beautiful



中封封口两边对不齐处理

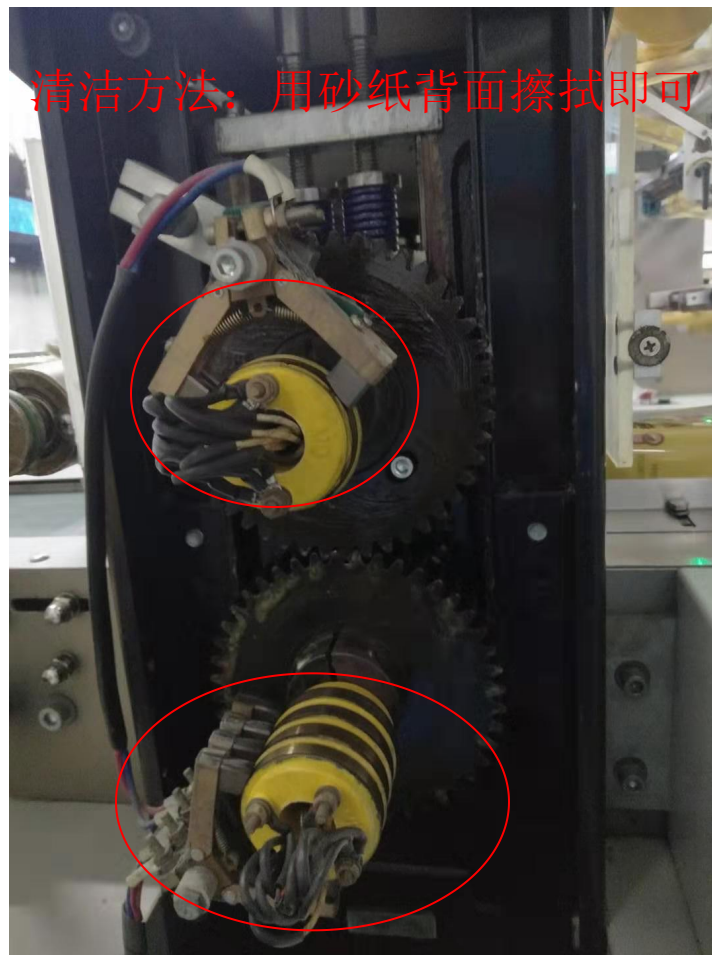


Misalignment of both sides of the middle seal



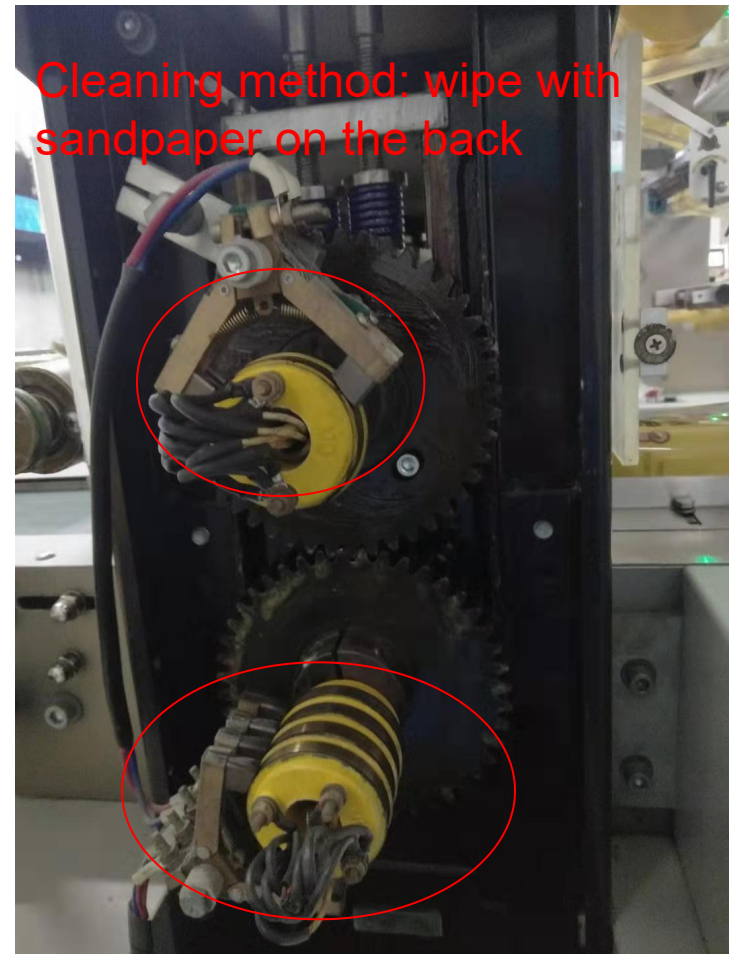
封口温度波动大处理

- 封口温度显示异常
- 状态：仪表显示比设定值高很多或者HHH时
- 原因：1. 与实际温度明显不符时，控表坏；2. 刀封碳刷磨损或有污垢附着在导电环；3. 传感器（热电偶）故障；4. 传感器线路松动或损坏
- 处理方法：1. 检查温度控制仪表或更换；2. 清洁碳刷和导电环，无效时请更换；3. 检查传感器或更换；4. 检查线路是否有松动断裂、锈蚀或有鼠虫害，修复
- **注：** 清洁前，请确认电源处于关闭状态，以保证人身安全



Large sealing temperature fluctuations

- Abnormal sealing temperature display
- Status: when the meter display is much higher than the set value or HHH
- Reasons: 1. When the actual temperature is obviously different, the control meter is broken; 2. The carbon brush of the knife seal is worn or there is dirt attached to the conductive ring; 3. The sensor (thermocouple) is faulty; 4. The sensor circuit is loose or damaged
- Treatment method: 1. Check the temperature control instrument or replace; 2. Clean the carbon brush and conductive ring, please replace if it is invalid; 3. Check the sensor or replace; 4. Check whether the wiring is loose, broken, rusted or damaged by rats and insects, repair it
- **Note: Before cleaning, please confirm that the power is off to ensure personal safety**



机器的保养和检查

- 1、每天或每班对机器的保养和清洁：
 - (1) 每次完成包装后，都要清洁机器。
 - (2) 在清洁该机之前，关闭电源。
 - (3) 清洁时，不要直接把水或蒸汽喷在机器上。
 - (4) 要清洁的主要部件：
 - * 若产品碎屑积聚在产品运输线，用压缩空气或其他方法清除它。
 - * 若薄膜碎屑粘附在密封器的封口表面，用涂上硅滑油的钢丝刷将其刷掉。
 - * 用软布抹掉控制板，安全盖，油漆面上的污物。
 - * 温控器的导电环：每隔一周或二周，停机切断主电源后，用砂纸背面清理导电环。
- 2、每月对机器的保养和检查：
 - (1) 给末端密封器（刀封部件）轴承上加润滑脂；
 - (2) 给传动部件中的齿轮和链条（轮）加润滑脂；
 - (3) 检查传动部件的链条和皮带是否此张紧，若有松动，将其调紧；
 - (4) 检查各部件的紧定螺钉或螺母是否有松动，若有松动，将其压紧。
- 3、每半年对机器做相关检查：
 - (1) 检查传动部份的皮带是否有磨损，若其磨损比较严重，则需要更换新件

Machine maintenance and inspection

1. Maintenance and cleaning of the machine every day or every shift:

- (1) Clean the machine every time after packaging.
 - (2) Turn off the power before cleaning the machine.
 - (3) When cleaning, do not spray water or steam directly on the machine.
 - (4) Main parts to be cleaned:
 - * If product debris accumulates on the product transportation line, use compressed air or other methods to remove it.
 - * If film debris adheres to the sealing surface of the sealer, wipe it off with a wire brush coated with silicone oil.
- * Use a soft cloth to wipe off the dirt on the control board, safety cover, and paint surface.
- * Conductive ring of thermostat: every other week or two weeks, after shutting down and cutting off the main power, clean the conductive ring with sandpaper on the back.

2. Monthly maintenance and inspection of the machine:

- (1) Add grease to the bearing of the end seal (knife seal part);
- (2) Add grease to the gears and chains (wheels) in the transmission parts;
- (3) Check whether the chains and belts of the transmission parts are tight, if they are loose, tighten them;
- (4) Check whether the set screws or nuts of each part are loose, if they are loose, press them tightly.

3. Check the machine every six months:

- (1) Check whether the belt of the transmission part is worn or not, if it is worn seriously, it needs to be replaced with a new one

- (2) 检查橡胶滚筒是否磨损，如果影响送纸效果则需要更换新的。
- (3) 调节托纸滚筒的刹车装置，使其合适。
- (4) 检查各种易损件，注意及时更换。
- (5) 检查电器接线板上的接线是否牢固，若有松动，将其紧固好，
- 检查变频器、线路板是否有灰尘或脏物，用压缩空气吹干净。
- 衷心希望阁下能坚持对机器每天进行清洁和保养，定期进行检
- 查，使本机器能够发挥其最大效能，安全生产，保持长时期的良
- 好性能。若有任何疑问，欢迎来电交流，
- 售后电话：075781263866 13420743171谢谢！

- (2) Check whether the rubber roller is worn or not, if it affects the paper feeding effect, you need to replace it with a new one.
- (3) Adjust the brake device of the supporting roller to make it suitable.
- (4) Check various wearing parts and pay attention to timely replacement.
- (5) Check whether the wiring on the electrical wiring board is firm, if it is loose, fasten it,
 - Check whether there is dust or dirt on the inverter and circuit board, and blow it away with compressed air.
 - I sincerely hope that you can insist on cleaning and maintaining the machine every day, and regular inspections.
 - Inspection, so that the machine can exert its maximum efficiency, safe production, and maintain long-term good
 - Good performance. If you have any questions, please call and exchange,
 - After-sales phone:+86 13420743171 Thank you!

故障原因及排除方法

故 障	原 因	排 除 方 法
跑纸	(1) 纸膜未对中 (2) 纸的张力未调好 (3) 成袋器太低，送料推杆碰纸 (4) 成袋器收得太窄 (5) 送纸太快或太慢	(1) 调节膜卷对中手轮正或反转来对中。 (2) 调整。 (3) 提高成袋器至刚好推块不碰纸为宜。 (4) 调节成袋器宽度调节手轮，放宽一点。 (5) 送纸光电盘及组件有故障，更换相应部件。
电眼跑位	(1) 长度不准确 (2) 送纸主动滚筒太脏 (3) 电眼无反应 (4) 刀轴上的接近开关无反应或偏位 (5) 刹车太紧或太松 (6) 补偿值设置不合适	(1) 重新设定长度。 (2) 清理滚筒上的脏物及黑点。 (3) 检查色标有无问题，调节电眼与纸之间的距离或电眼上的灵敏度旋钮，色标对正电眼，电眼上的灯要熄灭，移开要亮。 (4) 调节接近开关与凸轮上的距离（2~3mm），上下刀对齐时，接近开关要对着凸轮上的螺钉头，灯要亮。 (5) 调节刹车带上与弹簧连接夹块的角度。 (6) 改变补偿值。
切刀切在产品上	(1) 推杆同切刀未同步 (2) 成袋器内物料位置有变化 (3) 刀座太高或太低	(1) 饼位调整。 (2) 调整压物弹簧片对产品的压紧程度。 (3) 调节刀封部件高低，使刀座啮合中心处于产品高度的中间位置。

Causes of failures and troubleshooting methods

Error	Reason	Adjust methods
Run film	<ul style="list-style-type: none"> (1) The paper film is not centered (2) The tension of the paper is not adjusted properly (3) The bag former is too low and the feeding pusher touches the paper (4) The bag former is too narrow (5) Feeding paper is too fast or too slow 	<ul style="list-style-type: none"> (1) Adjust the film roll centering handwheel forward or reverse to center. (2) Adjustment. (3) It is advisable to raise the bag former to just push the block without touching the paper. (4) Adjust the width of the bag maker to adjust the handwheel to relax a little. (5) The paper-feeding photoelectric disk and its components are faulty, replace the corresponding parts.
Detecto r wrong	<ul style="list-style-type: none"> (1) Inaccurate length (2) The feed roller is too dirty (3) No response from the electric eye (4) The proximity switch on the knife shaft does not respond or is offset (5) The brake is too tight or too loose (6) Improper compensation value setting 	<ul style="list-style-type: none"> (1) Reset the length. (2) Clean the dirt and black spots on the roller. (3) Check whether there is any problem with the color code, adjust the distance between the sensor and the paper or the sensitivity knob on the sensor, the color code is aligned with the sensor, the light on the sensor should be off, and the light on the eye should be turned on. (4) Adjust the distance between the proximity switch and the cam (2~3mm). When the upper and lower knives are aligned, the proximity switch should face the screw head on the cam and the light should be on. (5) Adjust the angle of the clamp block connected with the spring on the brake band. (6) Change the compensation value.
Cut product	<ul style="list-style-type: none"> (1) The push rod is not synchronized with the cutter (2) There is a change in the position of the material in the bag former (3) Tool holder is too high or too low 	<ul style="list-style-type: none"> (1) Pie position adjustment. (2) Adjust the compression degree of the product by the pressure spring plate. (3) Adjust the height of the knife seal so that the engagement center of the knife holder is in the middle of the product height.

故 障	原 因	排 除
横封漏气或烂纸	(1) 温度不够或过高 (2) 刀座不清洁 (3) 上下刀座错位 (4) 纸质差 (5) 刀速太快或太慢	(1) 将温度调整合适。 (2) 清理刀座上的杂物。 (3) 重新调整刀座。 (4) 换纸。 (5) 调整刀速至合适
纸长显示不到设定值	(1) 纸长电眼故障 (2) 刀座接近开关故障 (3) 如果机器在运行过程，则因电眼跟踪系统参数调整不理想；纸长设定超限、电眼未调整好	(1) 更换电眼。 (2) 更换接近开关。 (3) 重调参数、重调电眼。
纸长不显示	(1) 电眼和齿盘位置不正确 (2) 刀座接近开关坏或位置不对	(1) 调整电眼和齿盘位置。 (2) 更换接近开关或调好位置。
温控表不能控制温度或无显示	(1) 发热体损坏 (2) 固态继电器损坏 (3) 热电偶损坏 (4) 由于电压过高或不稳定而损坏温控表	(1) 更换发热体。 (2) 更换固态继电器。 (3) 更换热电偶。 (4) 更换温控表。

Rrror	Reason	Adjust methods
Leakage/film broken	(1) The temperature is not enough or too high (2) The knife seat is not clean (3) Dislocation of upper and lower tool holders (4) Poor paper quality (5) The knife speed is too fast or too slow	(1) Adjust the temperature appropriately. (2) Clean up the debris on the knife seat. (3) Readjust the tool holder. (4) Change the paper. (5) Adjust the knife speed to the right
The paper length is less than the set value	(1) Paper long electric eye failure (2) Tool holder proximity switch failure (3) If the machine is running, the adjustment of the parameters of the electric eye tracking system is not ideal; the paper length setting exceeds the limit and the electric eye is not adjusted properly	(1) Replace the electric eye. (2) Replace the proximity switch. (3) Re-adjust parameters and re-adjust the electric eye.
Paper length is not displayed	(1) The position of the electric eye and the chainring is incorrect (2) The tool holder proximity switch is broken or the position is wrong	(1) Adjust the position of the electric eye and the chainring. (2) Replace the proximity switch or adjust the position.
The temperature control meter cannot control the temperature or has no display	(1) The heating element is damaged (2) The solid state relay is damaged (3) The thermocouple is damaged (4) The temperature control meter is damaged due to excessive voltage or instability	(1) Replace the heating element. (2) Replace the solid state relay. (3) Replace the thermocouple. (4) Replace the temperature control meter.

操作安全

- **人员安全**
- 禁止多人操控一台机的启动工作
- 清除刀座上的杂物时，请按下急停按钮
- 清洁热合部件和其周边时，请注意高温，以防烫伤
- 清洁传动部件时，请停机进行，并按下急停开关
- 机器运行时，禁止用手触摸传动部件
- 电气部件的保养及维修，请专业人员完成
- **机械安全**
- 禁止将尖硬物体这置在包装机中封、刀封或其他可能进入刀封机构的地方，以防损坏刀封
- 禁止将字粒类小物件放在包装机刀封上方，以防掉落造成电气短路或卡死刀封机构
- 禁止暴力操作

Operational safety for flow packaging machine

- **Personnel safety**
- It is forbidden for multiple people to control the start-up work of one machine
- When clearing the debris on the tool holder, please press the emergency stop button
- When cleaning the heat-sealed parts and their surroundings, please pay attention to the high temperature to prevent burns
- When cleaning the transmission parts, please stop and press the emergency stop switch
- When the machine is running, it is forbidden to touch the transmission parts by hand
- Maintenance and repair of electrical components should be done by professionals
- **Machinery safety**
- It is forbidden to put sharp and hard objects in the packaging machine, knife seal or other places that may enter the knife seal mechanism to prevent damage to the knife seal
- It is forbidden to put small words and grains on the top of the knife seal of the packaging machine to prevent electrical short-circuit or jamming of the knife seal mechanism due to falling
- Violent operation is prohibited