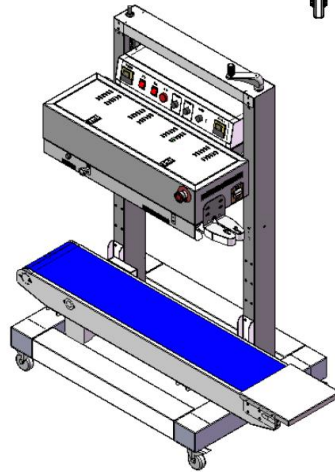


# MFRMG-1280 PLASTIC BAG SEALING MACHINE

U



USER MANUAL

# INDEX

I. FEATURES.....	1
II. STRUCTURE AND WORKING PRINCIPLE.....	1
III. TECHNICAL SPECIFICATIONS.....	1
IV. OVERVIEW OF MACHINE.....	2
V. PREPARATION.....	4
VI. START AND OPERATION.....	5
VII. CHANGE COPPER LETTER.....	6
VIII. CHANGE BELTS.....	7
IX. MAINTENANCE.....	8
X. TROUBLE-SHOOTING.....	9
XII. PACKING LIST.....	11

## I. FEATURES

- ◇ Unlimited sealing length
- ◇ User-friendly
- ◇ Number and letter embossing
- ◇ Heavy loading conveyor

◇ Digital temperature controlling

◇ Durability

## II. STRUCTURE AND WORKING PRINCIPLE

This machine is composed by frame, speed controlling system, heating system, Conveyor and embossing system.

Power on the machine and switch on the heating system, 1 minute later the copper blocks is heating.

Adjust the temperature and speed according to thickness and material of bags, to find out the best parameter.

Put the mouth of bag between the 2 running sealing belts, to let the sealing belts convey the bag to the heating area.

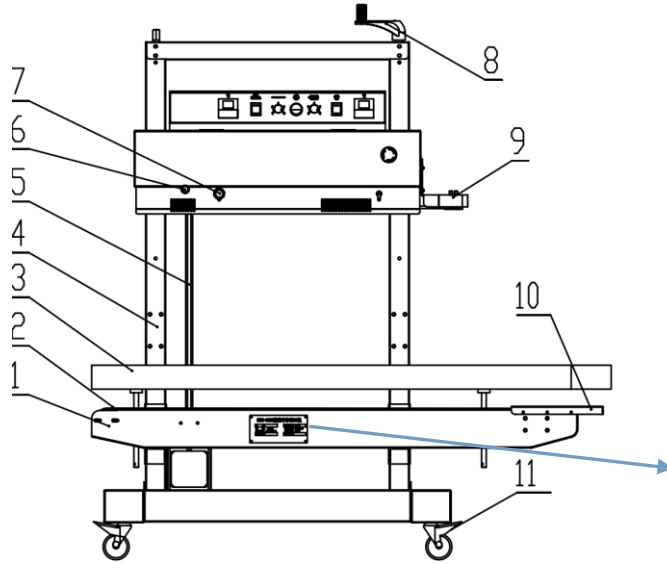
The mouth of bags is clamped and heated by the copper blocks.

Then the sealed bag is conveyed to the cooling area where the embossing wheel is rolling.

## III. TECHNICAL SPECIFICATIONS

Voltage	220V 50HZ
Power	1100 W
Adjustable speed	0-12 m/min.
Sealing width	10 mm
Distance from sealing center to conveyor	600 mm
Temp.range	0-300°C

Max.loading	25 KGS
Printing type	Hot ink roller printing, 3 - lines, each line accommodate 14 copper letters or numbers
Machine weight	120 KGS
Machine size	H 1415 *W 620 * L1280 mm
Size of wooden case	1480*690*1420

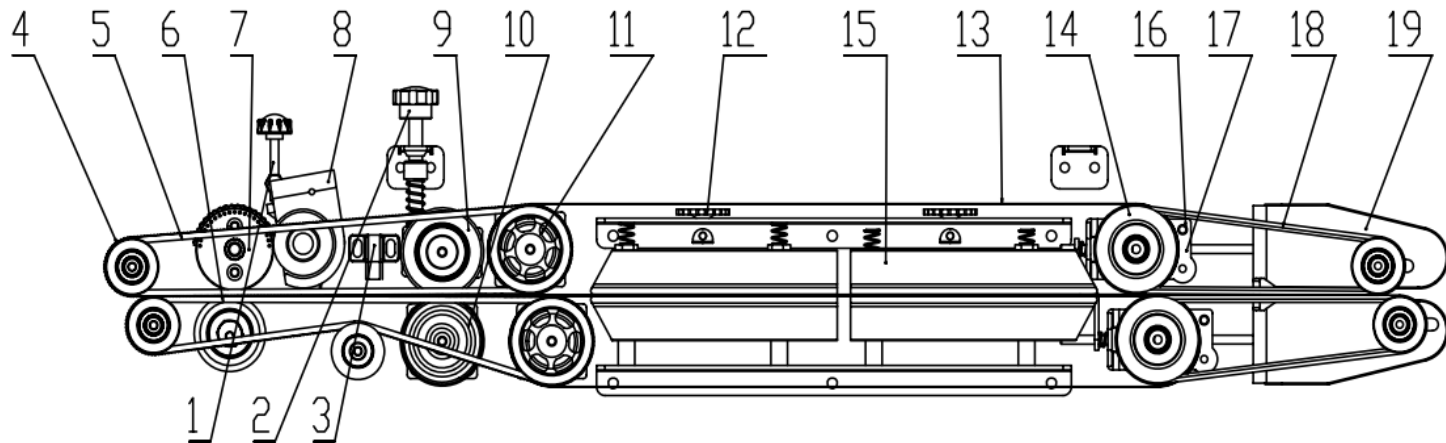


IV. OVERVIEW OF MACHINE

Fig.1

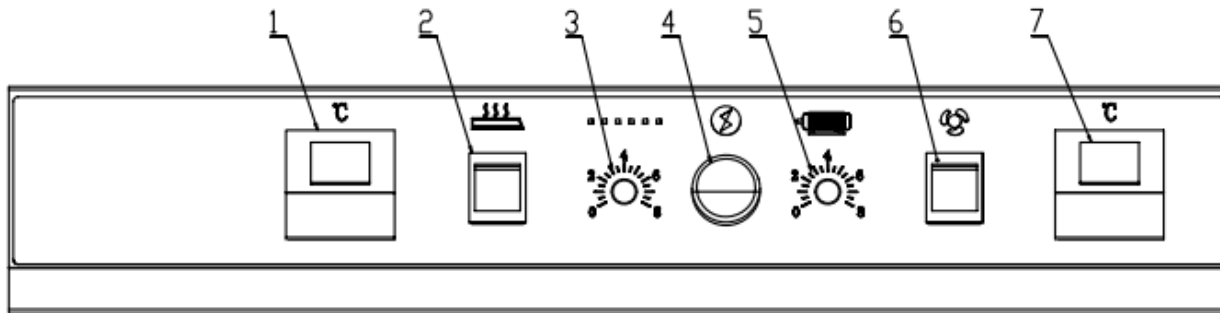
- |                               |                    |                    |                  |                 |
|-------------------------------|--------------------|--------------------|------------------|-----------------|
| 1. conveyor                   | 2. conveyor belt   | 3. banister        | 4. pillar        | 5. driving rod  |
| 6. knob for printing pressure | 7. knob for emboss | 8. handle for lift | 9. feeding mouth | 10. placing pad |
| 11. footing wheel             |                    |                    |                  |                 |

Fig.2 vertical machine



- |                               |                        |                     |                    |                  |
|-------------------------------|------------------------|---------------------|--------------------|------------------|
| 1. knob for printing pressure | 2. knob for emboss     | 3. objective sensor | 4. guild wheel     | 5. toothed belt  |
| 6. silicone wheel             | 7. letter holder       | 8. ink roller       | 9. embossing wheel | 10. rubber wheel |
| 11. driving wheel             | 12. pressure of heater | 13. Teflon belt     | 14. passive wheel  | 15. heater       |
| 16. screw for Teflon belt     | 17. slidable sit       | 18. toothed belt    | 19. feeding mouth  |                  |

Fig.3 Control panel



- 1.thermostat for ink 2. sealing temperature 3.printing position 4.power indicators 5.speed controller 6. Switch for cooler  
7. Thermostat for sealing

#### V. PREPARATION

- (1) For safety, the housing should be earthed, please make sure the 3-pin plug can be well connected.
- (2) Preheat for 1 minutes with low temperature, and if it is unused for a long time, 3 minutes for preheating is necessary.
- (3) Adjust the height of conveyor by bolt and nuts to match bags.
- (4) Adjust the thermostat (1) for printing date, 90°C is recommended, and 100°C or more is recommend for an old ink roller.
- (5) Adjust the space between the 4 heating copper blocks if the bags are very thick, but normally not necessary.

#### VI. START AND OPERATION

- (1) Power on the machine, all indicator light and all belt and wheel run synchronously.
- (2) Adjust the pressure embossing wheel.
- (3) Turn on the heating switch, and adjust the temperature according to material, thickness and speed.

The following setting is only for reference at the maximum conveying speed.

Material	Thickness of entire bag (mm)	Temperature (°C)
Polyethylene	0.4	100 ~ 140
Polypropylene	0.6	170 ~ 180
Polyolefin compound	1	180 ~ 189
Aluminum compound	0.8	200 ~ 250

When the red indicator of the temp. controller light up, please test it with the bags, and re-adjust the temperature, speed and embossing pressure if necessary. Then start continuous sealing work.

- (4) To prevent bags from being wrinkle, please open the fan, if necessary.
- (5) Put bag to the feeding, and let the belts grip the mouth of bag which should be aligned with the feeding, and let bag be conveyed automatically.

## VII. CHANGE COPPER LETTERS



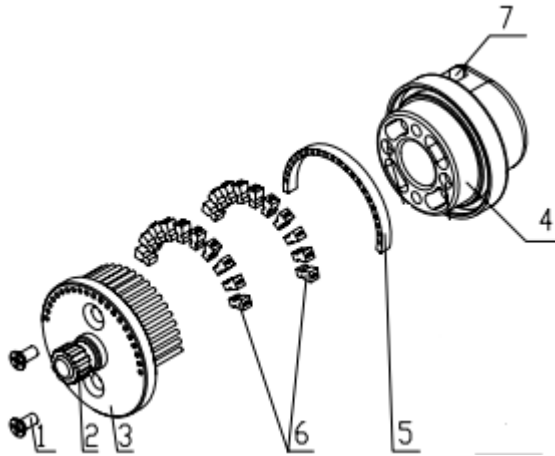


Fig. 4

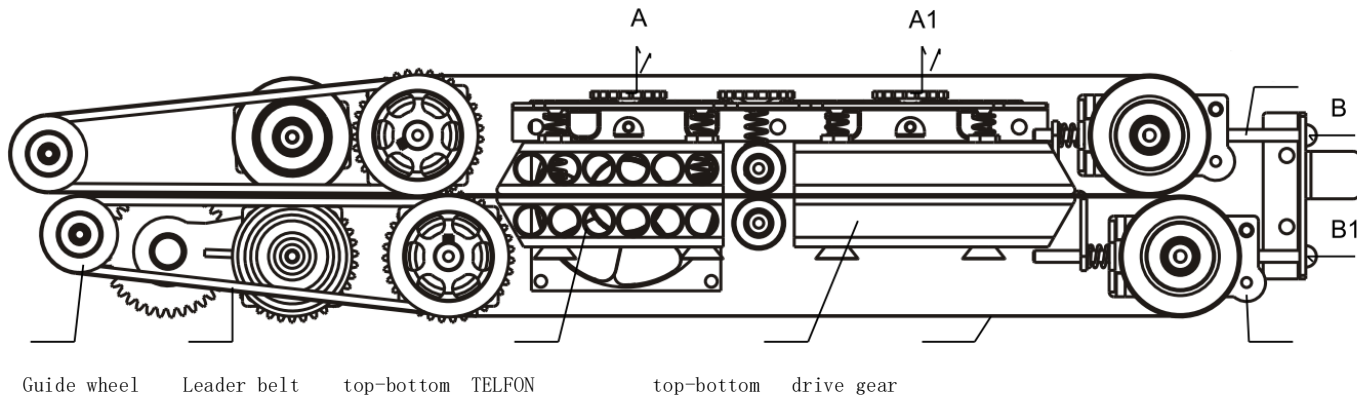
Lose the screw (1), take off the letter holder, take off the rubber (5), change the letters (6), fix the letter holder to the sit (4).

## VIII. CHARGE BELTS

a) Take off the hood.

b) Unscrew the guide wheel.

Fig. 5



c) Take off the gear belt from the passive wheel.

d) Lift a little the copper coppers block by adjusting A and A1.

e) Push B or B1 to loosen the sealing belts and change them.

f) Put the gear belt to the passive wheel.

g) Put the other end of gear belt to the guide wheel, meanwhile put the wheel back to its axle.

h) Screw the guide wheel.

## X. TROUBLE-SHOOTING

MALFUNCTION	POSSIBILITY	SOLUTIONS
Do not works	<ol style="list-style-type: none"> <li>1. No well connected to the power</li> <li>2. The speed controlling circuit is broken</li> </ol>	<ol style="list-style-type: none"> <li>1. Inspect if the machine is correctly connect to the power supply, and the fuse is in good condition</li> <li>2. Change the speed controlling circuit</li> </ol>
Can not adjust speed	The speed controller is broken	Change the speed controller
Do not heat	<ol style="list-style-type: none"> <li>1. The heating tube is broken</li> <li>2. The wire of heating tube is not well connected</li> <li>3. The temperature controller is broken</li> <li>4. The thermal sensor couple is broken</li> </ol>	<ol style="list-style-type: none"> <li>1. Change the heating tube</li> <li>2. Connect it and screw the terminal with force</li> <li>3. Change temperature controller</li> <li>4. Change the thermal sensor couple</li> </ol>
Embossing pattern is unclear	<ol style="list-style-type: none"> <li>1. Not enough pressure</li> <li>2. Rubber wheel is aged</li> <li>3. The embossing wheel is stained</li> <li>4. Hot enough temperature</li> </ol>	<ol style="list-style-type: none"> <li>1. Adjust the knob of embossing pressure</li> <li>2. Change the rubber wheel</li> <li>3. Clean te embossing wheel</li> <li>4. Adjust the temperature</li> </ol>
Sealing belt is fragile	<ol style="list-style-type: none"> <li>1. Not enough space between the 2 heating copper blocks</li> <li>2. The space between the copper blocks is not clear</li> <li>3. The sealing belt is stained with plastic</li> <li>4. Temperature is still high when machine stopped</li> </ol>	<ol style="list-style-type: none"> <li>1. Adjust the wheel A1 in Fig.4</li> <li>2. Clear copper blocks</li> <li>3. Clear the sealing belt</li> <li>4. Switch off heating firstly, few minute later power off the machine.</li> <li>5. Loose the bolt and nut B or B1 in Fig.4</li> </ol>

	5. The bolt and nut B or B1 is too tight	
Sealing belt slips	1. It is slack 2. Not enough space between the copper blocks	1. Tighten the bolt and nut B or B1 in Fig.4 2. Adjust A or A1 in Fig.4
Conveyor belt slips	3. It is slack	3. Adjust the N.15 knob in Fig.1
No printing	1.Heater for ink roller is broken 2.Thermostat is broken	1. Charge the heater 2. Charge the thermostat
Can not control printing position	1. The screw (7) in Fig.4 is loose 2. Objective sensor is broken 3. Position controller is broken	1.Fix it tightly 2.Change the objective sensor 3.Change the controller

## XII. PACKING LIST

Machine	1 unit
Cable	1 unit
Sealing belt (980mm)	20 units
Toothed belt (660mm)	4 units

Small toothed belt(410mm)	2 units
Heater for printing	1 unit
Spanner M5	1 unit
Cross-headed screwdriver (4#)	1 unit
Ink roller	1 unit
User manual	1 unit
Crescent wrench	1 unit
Ceramic washer	2 units
Letter and number	1 box
Rubber wheel	1 unit