

TEKOPACK T-5540 / TEKOPACK T-3028

shrink wrapping packaging machine

working instruction

Please read this manual carefully before boot
Catalogue

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You are prompted to pay particular attention to: During the machine operation to prohibit hand-to, Otherwise it will result in personal injury.

1. Product usage

Shrink packaging is one of the best packaging at the market at present, it is adopted plastic shrink film to wrap products or packing boxes, then heat the shrink film to packaging the products and the packing boxes, in this way to show the appearance of items, to improve the aesthetics and the value of items. Meantime the items after packaging can be sealed, anti-corrosion, anti-pollution. And the packaging can protect the items against external shocks, especially when you package containers, can prevent fragmentation. This machine can be widely used for shrink package metal, chemicals, commodities, books, etc.

2. Performance characteristic:

This machine can cut, seal, shrink in one time. The heating system uses stainless steel heat sink to heat, it is durable. Energy-saving effect (more than 15%). You can operate and control the machine just on the panel. There is a cycle blower in the studio, which can make the shrink film shrink in a very short time, to achieve satisfactory effect of the contraction. The advantage of this machine is that it can be used in a variety of shrink film.

3. Main technical data:

1. Packaging range:

550*400*370 Maximum (TEKOPACK T-5540)

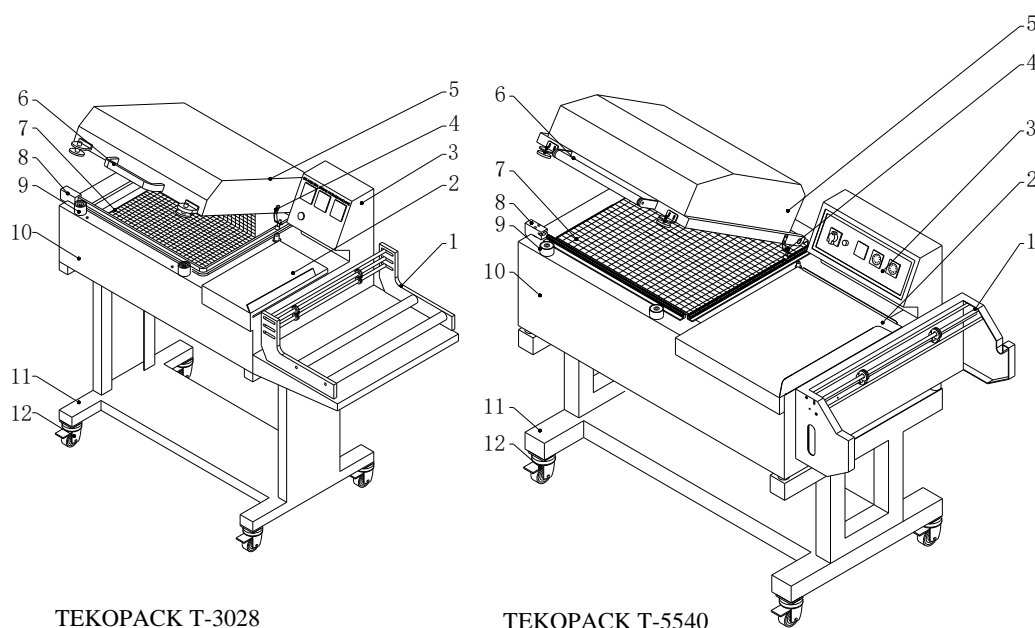
280*250*150 Maximum (TEKOPACK T -3028)

1. Wrapper object: Utensils Hardware Chemical Books Etc.
2. Power: 4 KW
3. Voltage: Single 220V
4. Dimensions: 1400*690*1320 (L*W*H)
5. Capacity 7-8 cycles/minute

4. Machine construction

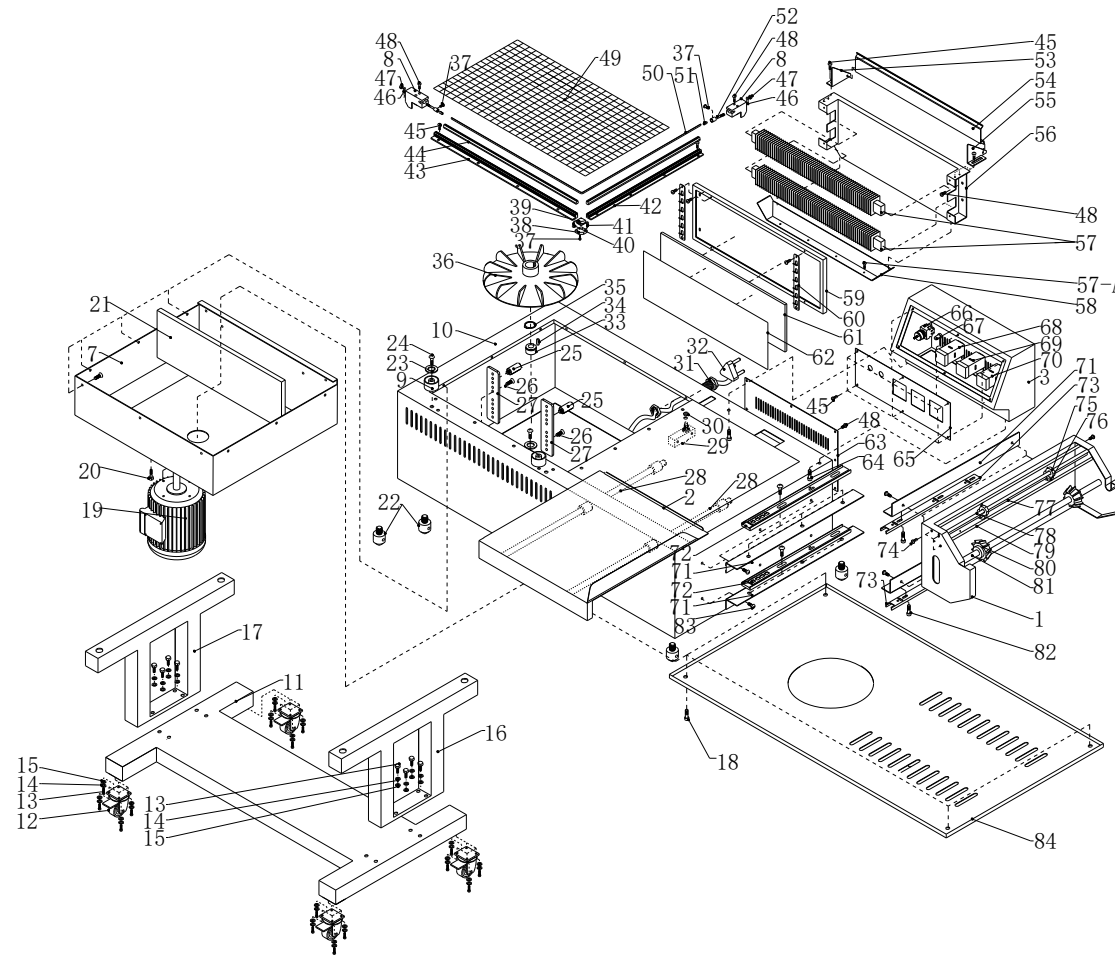
4.1 Complete machine sketch map

This machine consists of for film, seal cutting, shrinkage, and a series of bodies.

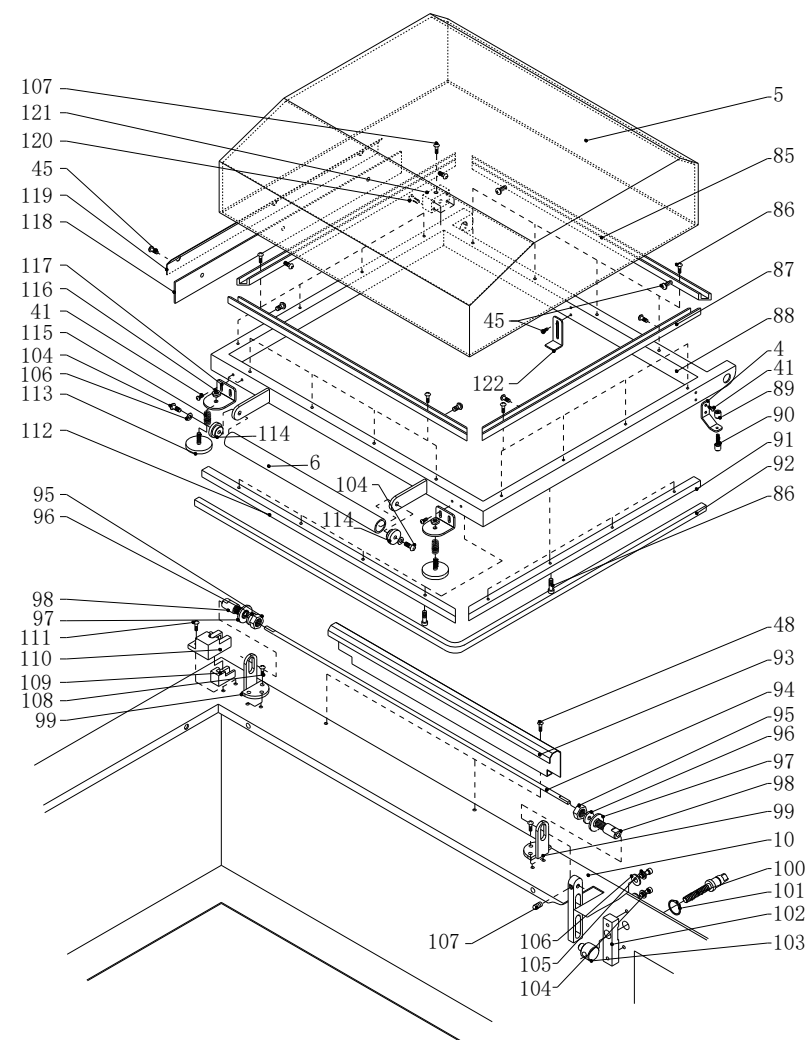


1.Placing membrane devices 2.Putting material table 3.Putting material table 4.Electric control panel 5.Proximity Switch 6.Observation Cover
 7.Handle8.Studio 9.Electromagnet 10.Rack 11.Chassis 12.Caster

4.2 Heat sealing and Placing film body

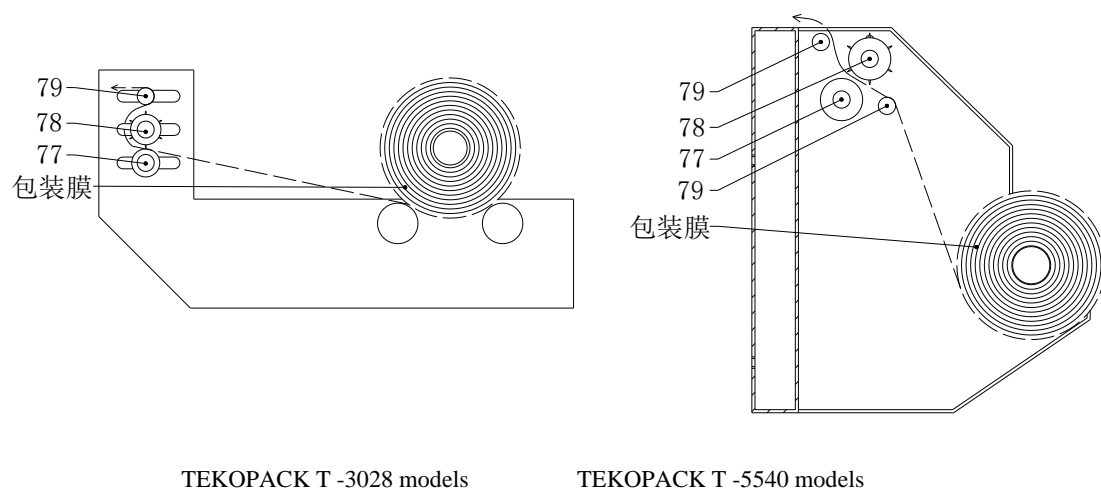


4.3 Observation window body



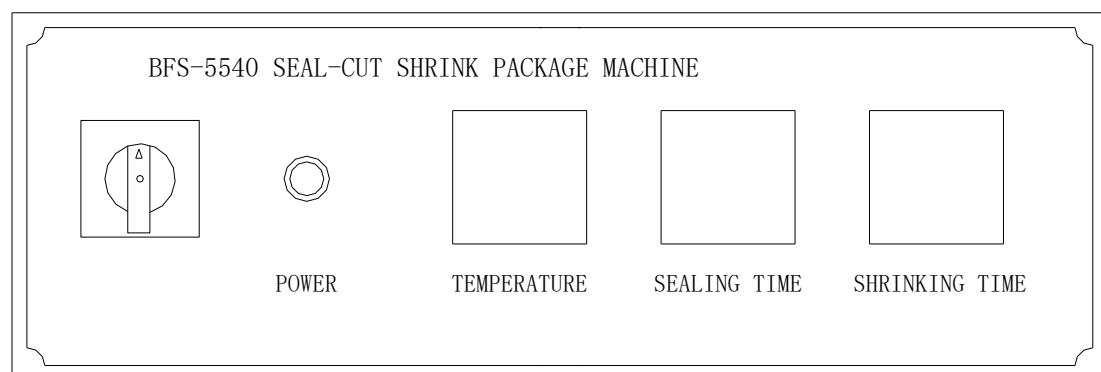
4.4 For film parts and the installation of packing film

As shown in the figure, install the packaging films in the for film body correctly.

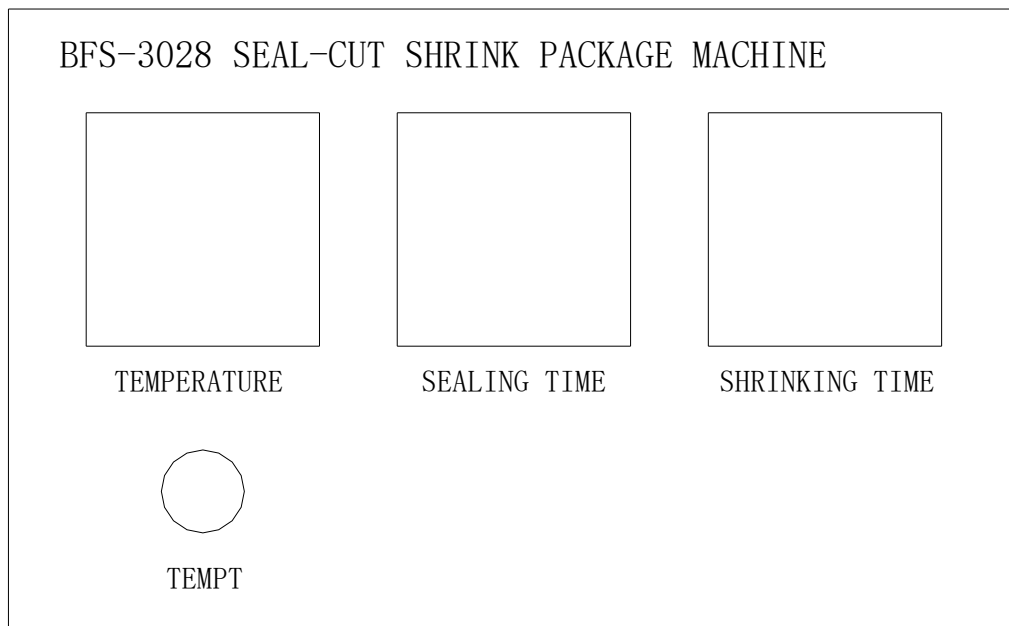


4.5 Control Panel

The machine mainly through the control panel to set the operating parameters of the machine.



TEKOPACK T -5540 models



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POWER/TEMPT: Total power switch

TEMPERATURE: Temperature control device, used to control the temperature setting of the machine heating system.

SEALING TIME: Sealing and Cutting time control device, used to set the seal cut time, through the addition and subtraction settings on the instrument to complete setting the necessary time to seal and cut.

SHRINKING TIME: Heat shrinkage time control device, used to set the time of film shrinkage, through the addition and subtraction settings on the instrument to complete setting the necessary time to seal and cut.

Specification of accessories of electrical control panel and manufacturer information

Accessory Name: combination switch

Manufacturer: Yaming Electrical Equipment

Specification: HZ5-20-4

1 pcs (TEKOPACK T-5540)

Name : Digital Time Relay

Manufacturer: Jinda Electrical Equipment

Specification: HA5B-35-AC220V

2 pcs (TEKOPACK T-5540) (TEKOPACK T-3028)

Name: Temperature Controller

Manufacturer: Yijialong

Specification: YJC-1101D

1pcs (TEKOPACK T-5540) (TEKOPACK T-3028)

Name: button switch

Manufacturer: Sanmenxia Hongda Electrical Equipment

Specification: KD16-1b

1 pcs (TEKOPACK T-3028)

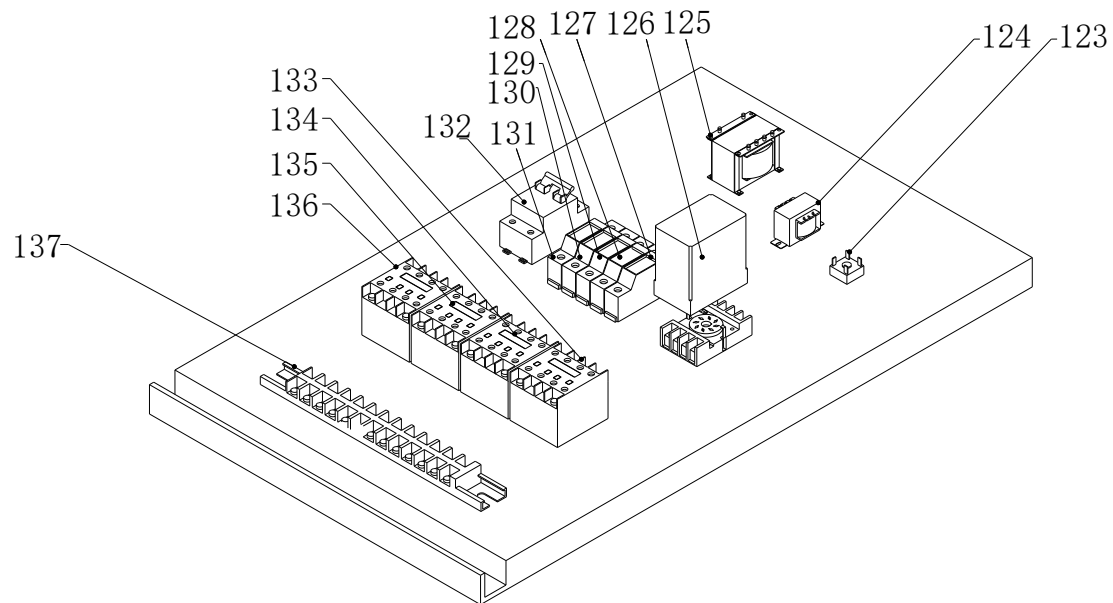
Name: indicator light

Manufacturer:

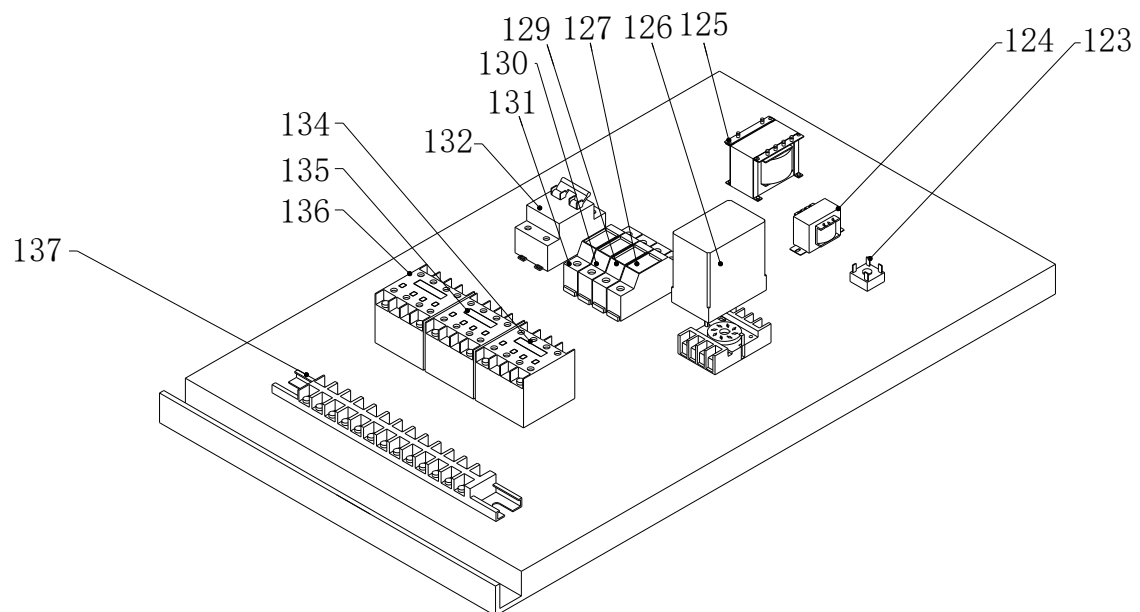
Specification: XDN1-220V

1 pcs (TEKOPACK T-5540)

TEKOPACK T-5540 model electric distribution map



TEKOPACK T-3028 model electrical distribution map



5. Operating steps

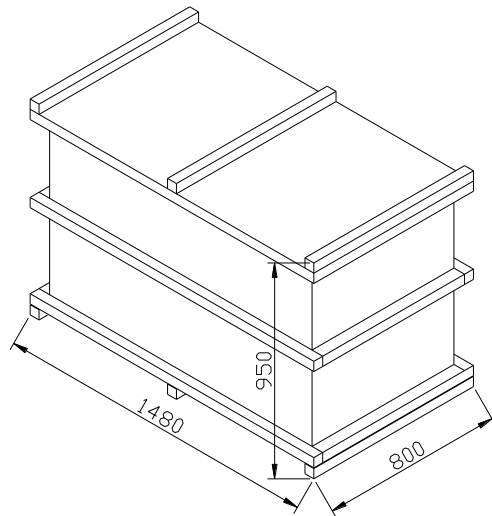
5. 1 Pre-boot operation

1. When place machine, avoid collision.
2. The machine is 220V single-phase, and connect the body to the ground reliably.
3. Fill lubricating oil to the various moving parts regularly.

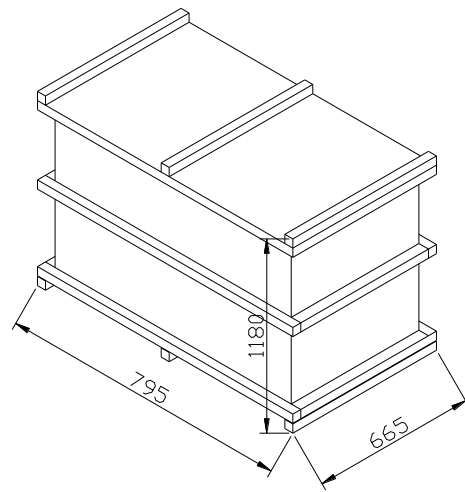
4. Remove machine debris promptly after each frequency, keep the machine clean.

5. 2 Machine's transport, assembly and placement space size.

1) Package Size



TEKOPACK T -3028 models

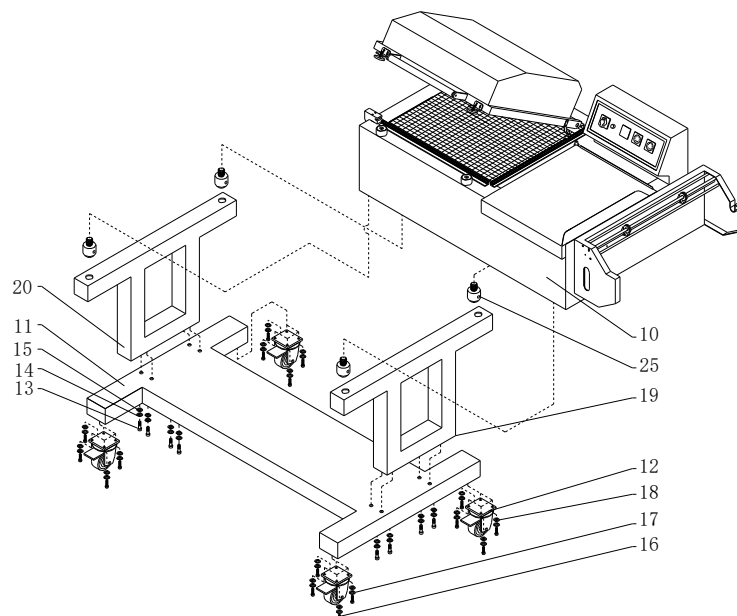


TEKOPACK T -5540 models

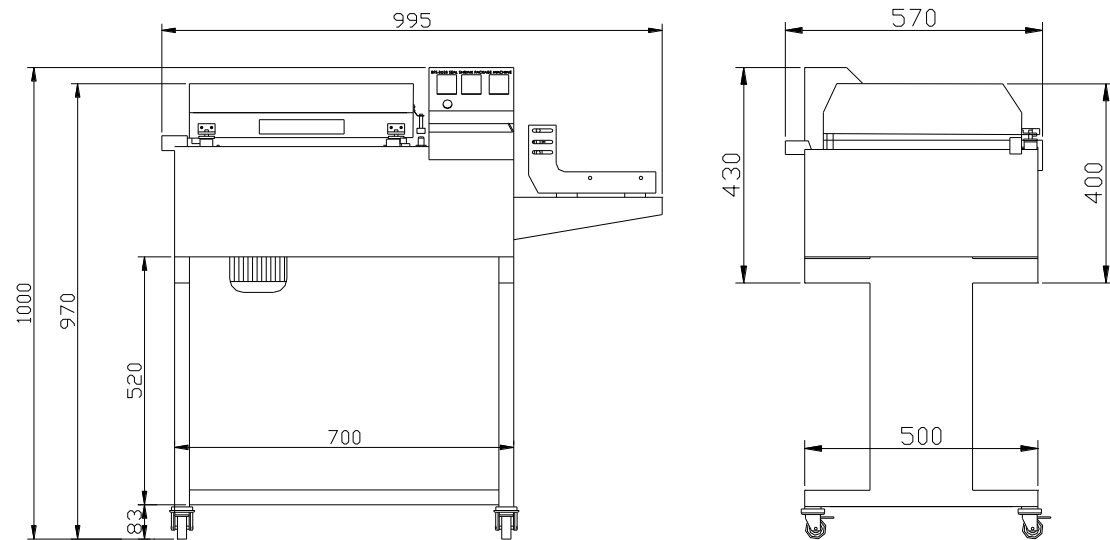
2) Assembly of machine

1. Put the caster screw through gasket to connect with the underpan, and tighten the screw.
2. Put the connecting screw of support through the gasket to connect with both the right and left support of body, tighten the screw.
3. Connect the connection pin with the main body of work; the connection method is, screwing the threaded portion of the pin into the screw hole of bottom of body.
4. Lift the body which is installed pin into the base which has been assembled. Align the circular cone of pin with the hole of support to complete the assembly.

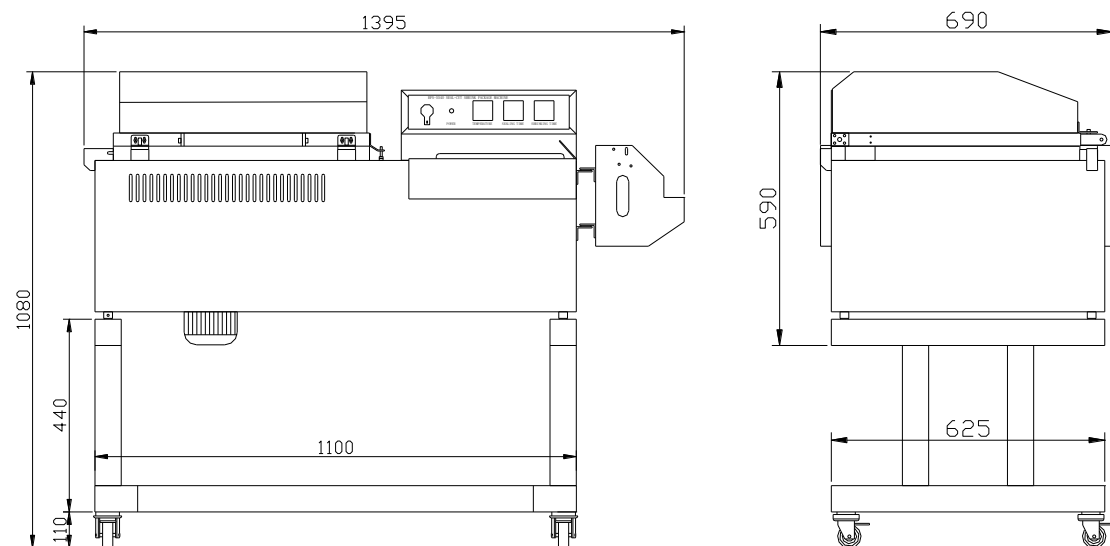
TEKOPACK T-3028 do not need to assemble, when the packaging is completed, it is assembled



3) Parameters of the machine's size



TEKOPACK T-3028



TEKOPACK T-5540

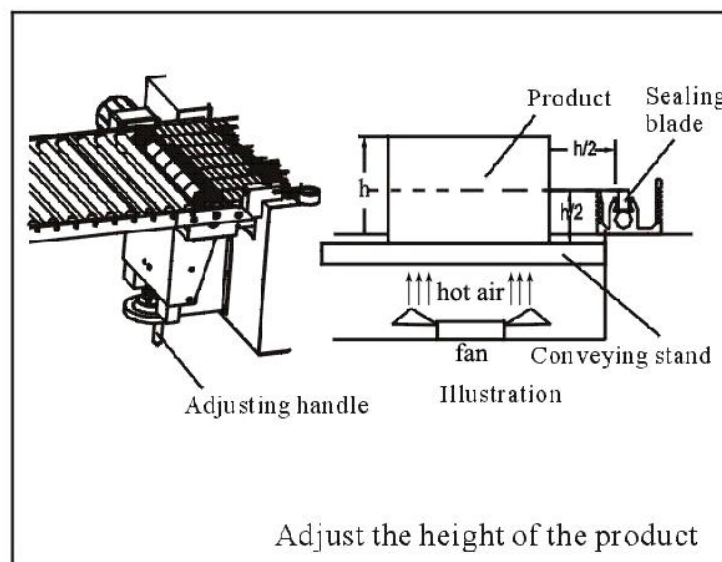
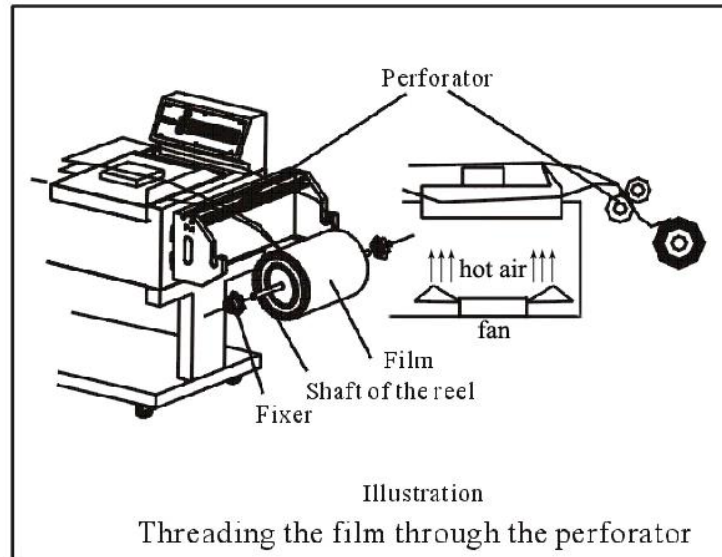
5. 3 Boot operation

1. After the preparation of pre-boot work correctly, you can conduct packaging.
2. After install packaging films correctly, according to the size of the packaging to adjust the location of pin wheel and wheel.
3. Adjust the location of the fence to the fit height, according to the size of the packaging.
4. Connect the power, turn the power switch and temperature switch, warm according to the thickness of shrink film, adjust the temperature to 150-200 ° C until appropriate.
5. Thread the shaft of the reel through the film reel, move the fixer to the center of the reel and fasten the screws. Use center folded (semi-sleeve) film.
6. Put the shaft of the film reel on the reel holder, make the open side of the semi-sleeve toward to the operator.
7. Thread the film through perforator, separate the two layers of film get it surround the working table.
8. Stretch the film to the sealing area, be sure that you sealing the film only.

9. Place the product on the working table, inside of the semi-sleeve (semi-folded film) under upper sheet of film, stretch the film and product to the sealing area in the left.
10. Keep a distance of $1/2$ height of the product between the product and the sealing blade in order to have enough film for shrinking.
11. Adjust the time of seal cutting and time of shrinkage goodly.
12. Begin packaging of products.

After set up parameters, press down the chamber hood then the sealing procedure are automatically finished. Then the hot air blowing is automatically run by fan and will provide the heat shrinkage of film shrinking. In the packaging work you can see heat shrinkage situation through the Plexiglas lid of chamber hood, after shrinkage is completed, the hood opens automatically.

Then remove the goods, the whole packaging process is completed.

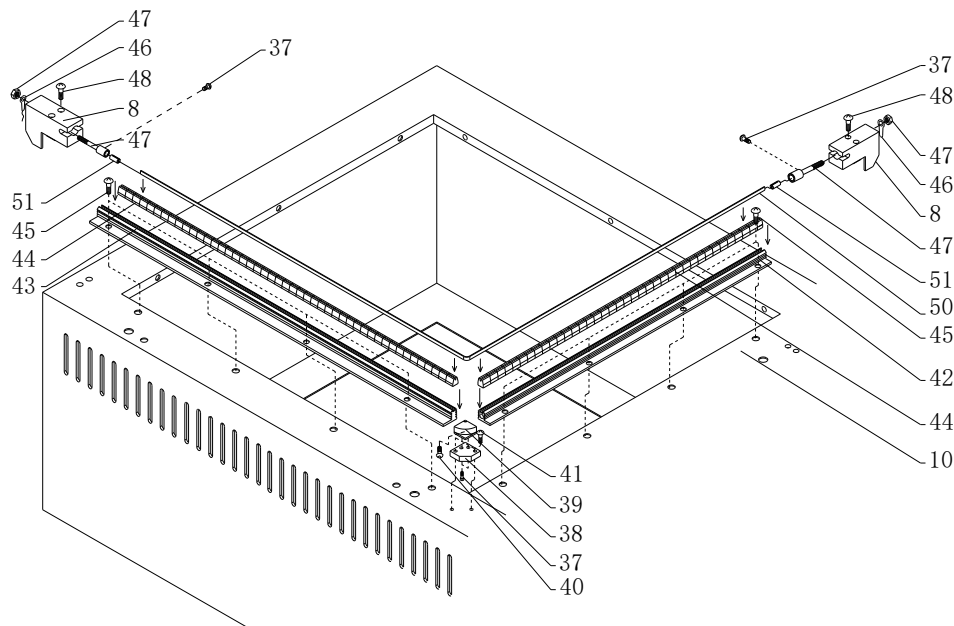


6. Maintenance

1. Do cleaning and maintenance to the machine at regular time, and replace damaged components.
2. Please do not adjust the location of spare parts at will, in order to avoid uncoordinated work of each body.
3. Please do not let the machine to work in high humidity environment, in order to avoid shortening the life of electrical components.
4. Please periodically clean up the sticky material on the cutter in order to ensure a good sealing effect.
5. Please add or replace the butter to three slide (72 73), motor (19), guide rod (28) every other six months.
6. The input voltage should be stable; instability will affect the entire packaging effect.
7. Cutter is a key part of this sealing machine, if the cutter is damaged, please installs a new cutter by the following method.

Replacement method of heating wire is: release a fixed nut (47) and the heating wire nip the screw (37) , and top wire of heating wire seat (40), pull screw (52) back. In this way, you can make heating wire clip column break away from the fixed screw. Take the heating wire out, separate heating wire and heating wire clip column by hand to complete the removal of the damaged heating wire.

Method of install a new heating wire: put the heating wire into the ceramic knife, and install heating wire clip column (51), and then put heating wire and heating wire clip column into a fixed screw, tighten heating wire clip column screw (37), pull screws (52)inside, to enable the heating wire in a smooth linear state, tighten nut (47)at last to complete the installation of a new electric wire.



7. Common Faults and exclusion method

Failure	Remedy
1. Can not start the machine, there is leakage	<ol style="list-style-type: none">1. Check the input single-phase power supply and ground lines are correct and normal.2. Check the connection point, point of contact is good contact3. Check the power cord skin whether has been damaged.
2. Does not shrink or the result of shrink is not	<ol style="list-style-type: none">1. Check whether the heating pipe is damaged

satisfactory	<p>or replaced.</p> <ol style="list-style-type: none"> 2. Check whether the input voltage is too low. 3. Rule out the connection errors of cycle blower and cycle blower damage. 4. Did not set contraction time goodly, minorly readjust the contraction time, according to the thickness of packaging film or material. 5. Check (29) switch in Figure 2 whether is damaged or bad wiring, correct and replace it.
3. Seal and cut can not heat or sealing incision is not satisfactory	<ol style="list-style-type: none"> 1. Check whether the heating wire is damaged, if it is, replace the heating wire. 2. Check whether the sealing and cutting line of the heating wire stuck organic matter, clean it up. 3. Sealing and cutting time is not set good. 4. Check whether (29) switch in Figure 2 is damaged or bad wiring, correct or replace.
4. Temperature Controller without display or numerical value in instability	<ol style="list-style-type: none"> 1. Replace thermocouple or temperature controller. 2. Parts of the wiring is bad
5. The supply membrane unit slides difficultly	<ol style="list-style-type: none"> 1. Fill the three slide with lubrication regularly. 2. open the slide device, remove debris in the slide. 3. Three slide is damaged, in need of replacement.

8. Electrical schematic:

10	TE	Temperature Controller	1101D	1	
11	E	Thermocouple	K2mm	1	
12	R2	Heating pipe	1500W(5540)	2	1000W(3028)
13	R1	Sealing blade	4x80.5x1200(5540)	1	4x80.5x780(3028)

序号	名称	数量	序号	名称	Qty
1	Placing membrane devices	1	42	Heating wire gasket plate	1
2	Putting material table	1	43	Heating wire seat	1
3	Electric control panel	1	44	Top wire of heating wire seat	1
4	接近开关支架	1	45	M4 screw	2
5	观察窗	1	46	Right knife installation block	1
6	手柄	1	47	前刀架安装座	1
7	工作室	1	48	Ceramic knife	1
8	塑料座	2	49	Heating wire screw	8
9	电磁铁	2	50	Heating wire clip column screw	2
10	机架	1	51	Heating wire fixed film	2
11	底盘	1	52	Nut	2
12	Caster	4	53	M4 screw	4
13	M8 screw	8	54	Glove bar	1
14	Spring washer	8	55	Heating wire	1
15	Flat gasket	8	56	Heating wire clip column	2
16	Caster fastening screw	16	57	Screw	2
17	Caster fastening screw	16	58	Screw	4
18	Flat gasket	16	59	Left heat shield bracket	1
19	Right bracket	1	60	Heat shield	1
20	Left bracket	1	61	Right heat shield bracket	1
21	Set screw	6	62	Heating tube Holder	1
22	Motor	1	63	Screw	4
23	M6 screw	4	64	Heating pipe	1
24	Asbestos tape	1	65	Heating pipe	1
25	Pin	4	66	Platen	1
26	Gasket	2	67	Insulation board	1
27	Screw	2	68	Back adjustment plate	2
28	Screw	1	69	Filler	1
29	M5 set screws tight	4	70	Rubber wood	1
30	Pre-conditioning panel	2	71	M5 screw	1
31	Rod	1	72	Rack back cover	1
32	Rod	1	73	Electrical box screw	2
33	Proximity Switch	1	74	Panel fixed screw	6
34	Nut	1	75	Control Panel	1
35	Care-line device	1	76	Combination switch	1
36	Power Line	1	77	Indicator	1
37	Fan connecting shaft	1	78	Temperature controller	1
38	Connection pin	1	79	Time relay	1

39	Circlip	1	80	Time relay	1
40	Fan	1	81	Chute support plate	4
41	M4 set screw	1	82	Up section of three slide	2

序号	名称	数量	序号	名称	Qty
83	Down section of three slide	2	118	M6 screw	6
84	M4 screw	2	119	Handle sleeve	1
85	Pin wheel	2 套	120	Limit block	1
86	Roller	2	121	Screw	2
87	Roller shaft	1	122	前硅胶条安装槽	1
88	Pin axle	1	123	Sucker	2
89	Through film axis	2	124	Flat Gasket	2
90	Top round	2	125	Handle screw	2
91	Top film axis	1	126	Cover	2
92	M4 screw	12	127	Reset spring	2
93	Rack backplane	1	128	M4 screw	4
94	Observation window fixed slot	2	129	M6 nut	2
95	M4 screw	12	130	Sucker block	2
96	Observation window fixed slot	2	131	M4 screw	4
97	Rack	1	132	Adjustment block	1
98	M4 screw	2	133	Shaft fastening screw	1
99	Nut	1	134	Thermal Window Switch frame	1
100	Proximity Switch handle	1	135	M4 screw	2
101	右硅胶条安装槽	1	136	Observation window top wire	8
102	Silicone rope	1	137	Rectifier	1
103	M4 screw	8	138	Small transformer	1
104	M4 screw	2	139	Large transformer	1
105	Shield	1	140	Relay	1
106	Shaft	1	141	Control power safety switch	1
107	Nut	2	142	Electromagnets safety switch	1
108	Spring Washer	2	143	Fan safety switch	1
109	Flat gasket	2	144	Heating pipe safety switch	1
110	Shaft sleeve	2	145	Heating wire safety switch	1
111	转轴支座	2	146	Breakers	1
112	Adjustment screw	1	147	Electromagnets AC contactor	1
113	Location circlip	1	148	Fan AC contactor	1
114	Adjustment screw block	1	149	Heating pipe AC contactor.	1
115	Activity block	1	150	Heating wire AC contactor	1
116	Adjustment block fastening device	2 套	151	Terminal	1
117	M8 top wire	1			