

TEKOPACK T-5540 Shrink Wrapping Packaging Machine Instruction Manual

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TEKOPACK T-5540 / TEKOPACK T-3028 shrink wrapping packaging machine working instruction

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T-5540 Shrink Wrapping Packaging Machine

Please read this manual carefully before boot

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

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.

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.

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

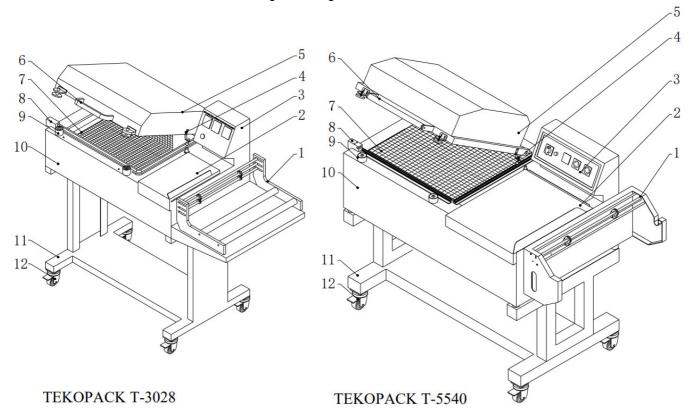
4. Dimensions:1400*690*1320 (L*W*H)

5. Capacity 7-8 cycles/minute

Machine construction

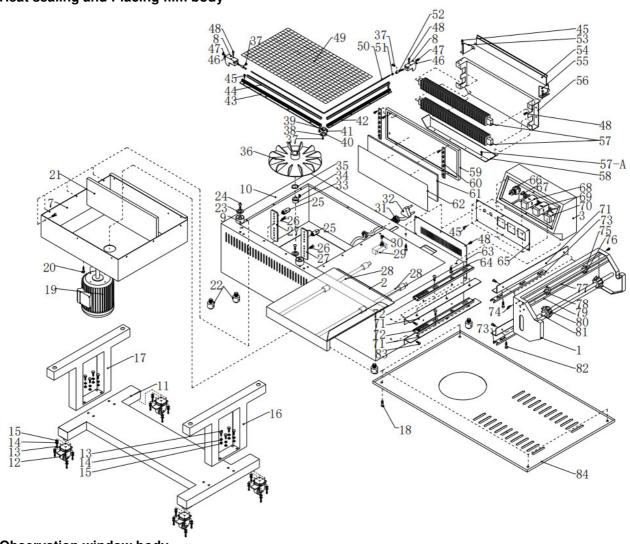
4.1 Complete machine sketch map

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

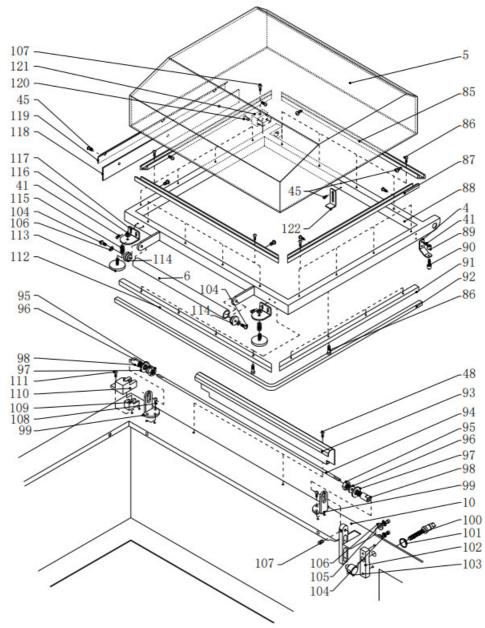


- 1. Placing membrane devices
- 2. Putting material table
- 3. Putting material table
- 4. Electric control panel
- 5. Proximity Switch
- 6. Observation Cover
- 7. Handle
- 8. Studio
- 9. Electromagnet
- 10. Rack
- 11. Chassis
- 12. Caster

4.2 Heat sealing and Placing film body

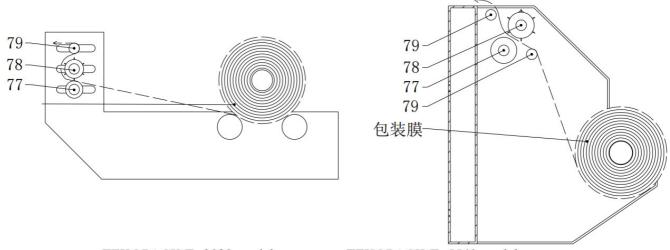


4.3 Observation window body



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.

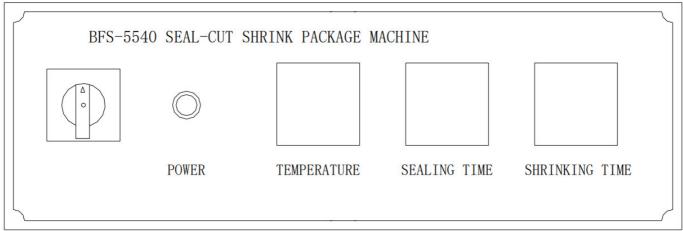


TEKOPACK T -3028 models

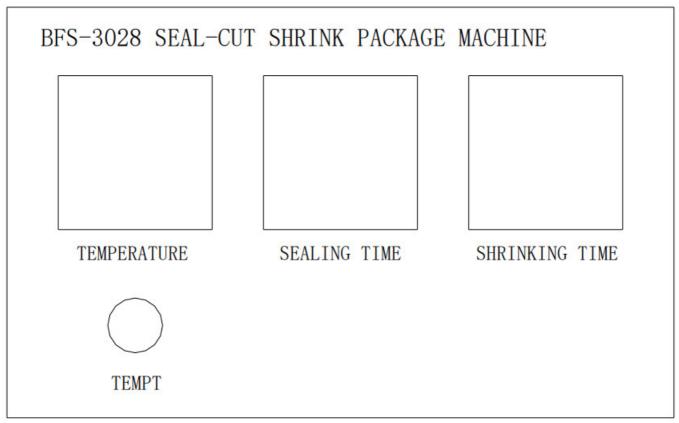
TEKOPACK T -5540 models

4.5 Control Panel

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



TEKOPACK T -5540 models



TEKOPACK T -3028 models

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

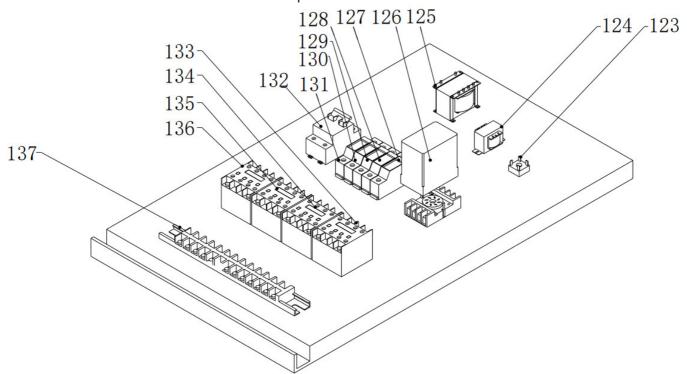
Name: button switch

Manufacturer: Sanmenxia Hongda Electrical Equipment

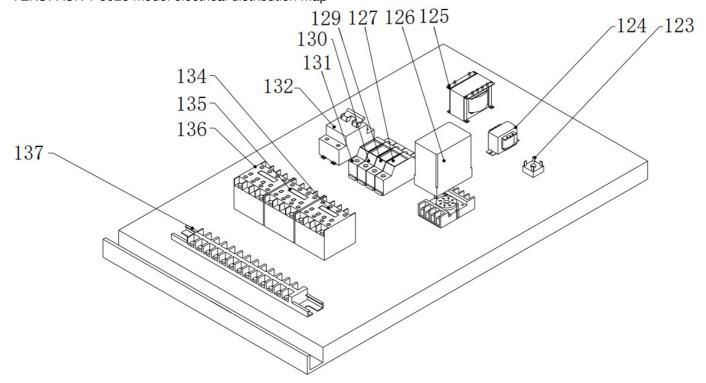
Specification: KD16-1b 1 pcs TEKOPACK T-3028 Name: indicator light Manufacturer:

Specification: XDN1-220V 1 pcs TEKOPACK T-5540

TEKOPACK T-5540model electric distribution map



TEKOPACK T-3028 model electrical distribution map



Operating steps

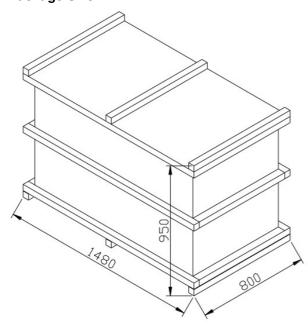
5.1 Pre-boot operation

1. When place machine, avoid collision.

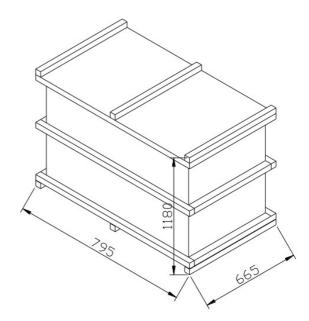
- 2. The machine is 220V single-phase, and connect the body to the ground reliably.
- 3. Fill lubricating oil to the various moving parts regularly.
- 4. Remove machine debris promptly after each frequency, keep the machine clean.

5.2 Machine's transport, assembly and placement space size.

1. Package Size





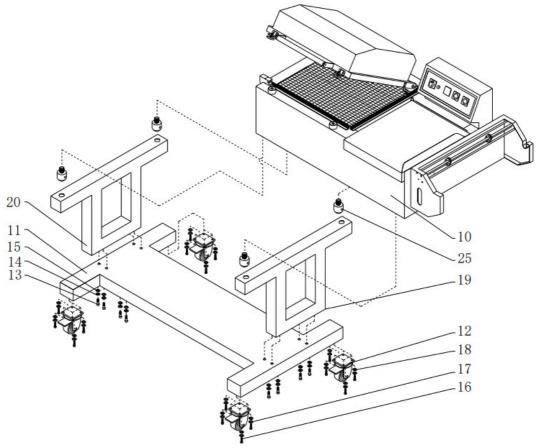


TEKOPACK T -5540 models

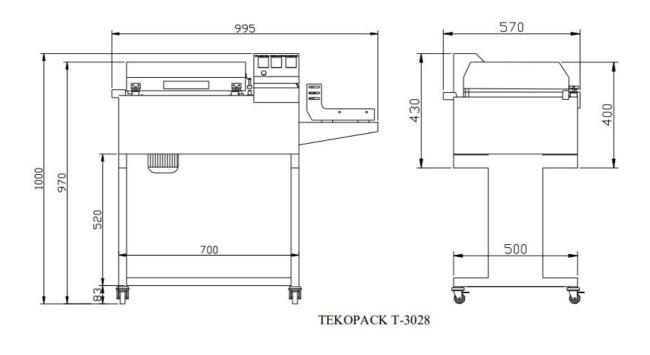
2. Assembly of machine

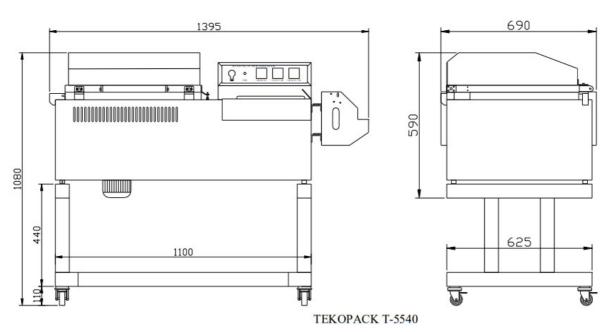
- 1. Put the caster screw through gasket to connect with the underpan, and tighten the screw.
- 2. Put the connecting screw of support through the gasket to connect with both the right and left support of body, tighten the screw.
- 3. Connect the connection pin with the main body of work; the connection 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



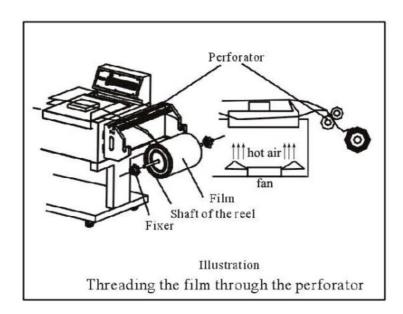


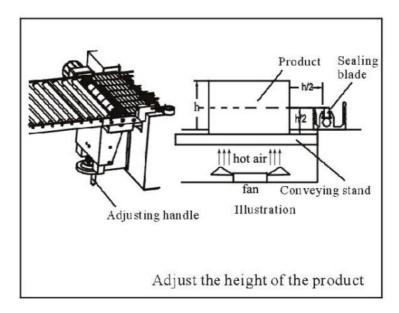
5.3 Boot operation

- 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.



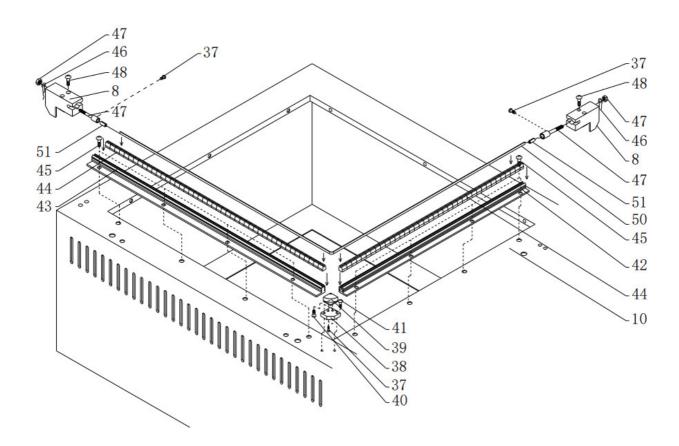


Maintenance

- 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.

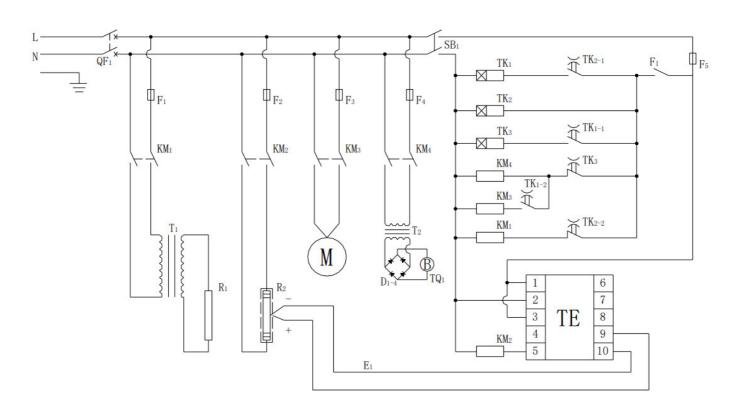
Replacement method of heating wire is: release a fixed nut (47) and the heating wire nip the screw (37), and top wire of heating wire seat (40), pull screw (52) back. In this way, you can make heating wire clip column break away from the fixed screw. Take the heating wire out, separate heating wire and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



Common Faults and exclusion method

Failure	Remedy
Can not start the machine, there is I eakage	 Check the input single-phase power supply and ground lines are cor rect and normal. Check the connection point, point of contact is good contact Check the power cord skin whether has been damaged.
2. Does not shrink or the result of shrink is not satisfactory	 Check whether the heating pipe is damaged or replaced. Check whether the input voltage is too low. Rule out the connection errors of cycle blower and cycle blower da mage. Did not set contraction time goodly,minorly readjust the contraction time, according to the thickness of packaging film or material. 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 incisionis not satisfactory	 Check whether the heating wire is damaged, if it is ,replace the heat ing wire. Check whether the sealing and cutting line of the heating wire sticke d organic matter, clean it up. Sealing and cutting time is not set good. Check whether (29) switch in Figure 2 is damaged or bad wiring, correct or replace.
4. Temperature Controller without disp lay or numerical value in instability	Replace thermocouple or temperature controller. Parts of the wiring is bad
5. The supply membrane unit slides di fficultly	 Fill the three slide with lubrication regularly. open the slide device, remove debris in the slide. Three slide is damaged, in need of replacement.

Electrical schematic:



Packing list

Name	Specifications	Amount
1. Host		1
2. Instructions		1
3. Certificate		1
4. Detergent		1
5. Hexagon wrench	3 4 5 6	1
6. Screwdriver	Regular, Cross,2.5	1
7. Heating pipe		2
8. Fuse		1
9. Cloth tape		1
10. Silicon adhesive tape		1

Electrical components in table

No.	Code	Name	Type and specifications	Amount	Notes
1	QF	Breaker	DZ47/C16	1	
2	F1-5	Fuse box	RT18-32	5	
3	KM1-4	Contactors	CJX2-1210	4	
4	T1-2	Transformers	220V/40V/32V	2	
5	TQ1	Electromagnet		2	
6	D1-4	Bridge Rectifier	KBPC2510	1	
7	SB	Combination Switch		1	
8	TK1-3	Time Relay	AH5-6S	3	
9	K1	Micro Switch		1	
10	TE	Temperature Controller	1101D	1	
11	E	Thermocouple	K2mm	1	
12	R2	Heating pipe	1500W(5540)	2	1000W(3028)
13	R1	Sealing blade	4xδ0.5×1200(5540)	1	4xδ0.5×780(3028)

serial nu mber	name	quant ity	serial num ber	name	quanti ty
1	Placing membrane devices	1	77	Indicator	1
2	Putting material table	1	78	Temperature controller	1

3	Electric control panel	1	79	Time relay	1
4	Proximity switch bracket	1	80	Time relay	1
5	Observation window	1	81	Chute support plate	4
6	handle	1	82	Up section of three slide	2
7	studio	1	83	Down section of three slide	2
8	plastic seat	2	84	M4 screw	2
9	electromagnet	2	85	Pin wheel	2 set
10	rack	1	86	Roller	2
11	chassis	1	87	Roller shaft	1
12	Caster	4	88	Pin axle	1
13	M8 screw	8	89	Through film axis	2
14	Spring washer	8	90	Top round	2
15	Flat gasket	8	91	Top film axis	1
16	Caster fastening screw	16	92	M4 screw	12
17	Caster fastening screw	16	93	Rack backplane	1
18	Flat gasket	16	94	Observation window fixed slot	2
19	Right bracket	1	95	M4 screw	12
20	Left bracket	1	96	Observation window fixed slot	2
21	Set screw	6	97	Rack	1
22	Motor	1	98	M4 screw	2
23	M6 screw	4	99	Nut	1
24	Asbestos tape	1	100	Proximity Switch handle	1
25	Pin	4	101	Right silicone strip installation s	1
26	Gasket	2	102	Silicone rope	1
27	Screw	2	103	M4 screw	8
28	Screw	1	104	M4 screw	2
29	M5 set screws tight	4	105	Shield	1
30	Pre-conditioning panel	2	106	Shaft	1
31	Rod	1	107	Nut	2
32	Rod	1	108	Spring Washer	2
33	Proximity Switch	1	109	Flat gasket	2
34	Nut	1	110	Shaft sleeve	2

35	Care-line device	1	111	Shaft support	2
36	Power Line	1	112	Adjustment screw	1
37	Fan connecting shaft	1	113	Location circlip	1
38	Connection pin	1	114	Adjustment screw block	1
39	Circlip	1	115	Activity block	1
40	Fan	1	116	Adjustment block fastening dev ice	2 set
41	M4 set screw	1	117	M8 top wire	1
42	Heating wire gasket plate	1	118	M6 screw	6
43	Heating wire seat	1	119	Handle sleeve	1
44	Top wire of heating wire seat	1	120	Limit block	1
45	M4 screw	2	121	Screw	2
46	Right knife installation block	1	122	Front silicone strip installation s	1
47	Front tool post mounting seat	1	123	Sucker	2
48	Ceramic knife	1	124	Flat Gasket	2
49	Heating wire screw	8	125	Handle screw	2
50	Heating wire clip column screw	2	126	Cover	2
51	Heating wire fixed film	2	127	Reset spring	2
52	Nut	2	128	M4 screw	4
53	M4 screw	4	129	M6 nut	2
54	Glove bar	1	130	Sucker block	2
55	Heating wire	1	131	M4 screw	4
56	Heating wire clip column	2	132	Adjustment block	1
57	Screw	2	133	Shaft fastening screw	1
58	Screw	4	134	Thermal Window Switch frame	1
59	Left heat shield bracket	1	135	M4 screw	2
60	Heat shield	1	136	Observation window top wire	8
61	Right heat shield bracket	1	137	Rectifier	1
62	Heating tube Holder	1	138	Small transformer	1
63	Screw	4	139	Large transformer	1
64	Heating pipe	1	140	Relay	1
65	Heating pipe	1	141	Control power safety switch	1
66	Platen	1	142	Electromagnets safety switch	1

67	Insulation board	1	143	Fan safety switch	1
68	Back adjustment plate	2	144	Heating pipe safety switch	1
69	Filler	1	145	Heating wire safety switch	1
70	Rubber wood	1	146	Breakers	1
71	M5 screw	1	147	Electromagnets AC contactor	1
72	Rack back cover	1	148	Fan AC contactor	1
73	Electrical box screw	2	149	Heating pipe AC contactor.	1
74	Panel fixed screw	6	150	Heating wire AC contactor	1
75	Control Panel	1	151	Terminal	1
76	Combination switch	1			

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Documents / Resources



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Manuals+,