Xytronic LF-90 Automatic Sealing Machine User Manual

Contents

Xytronic LF-90 Automatic Sealing Machine

Product Information

Product Specifications

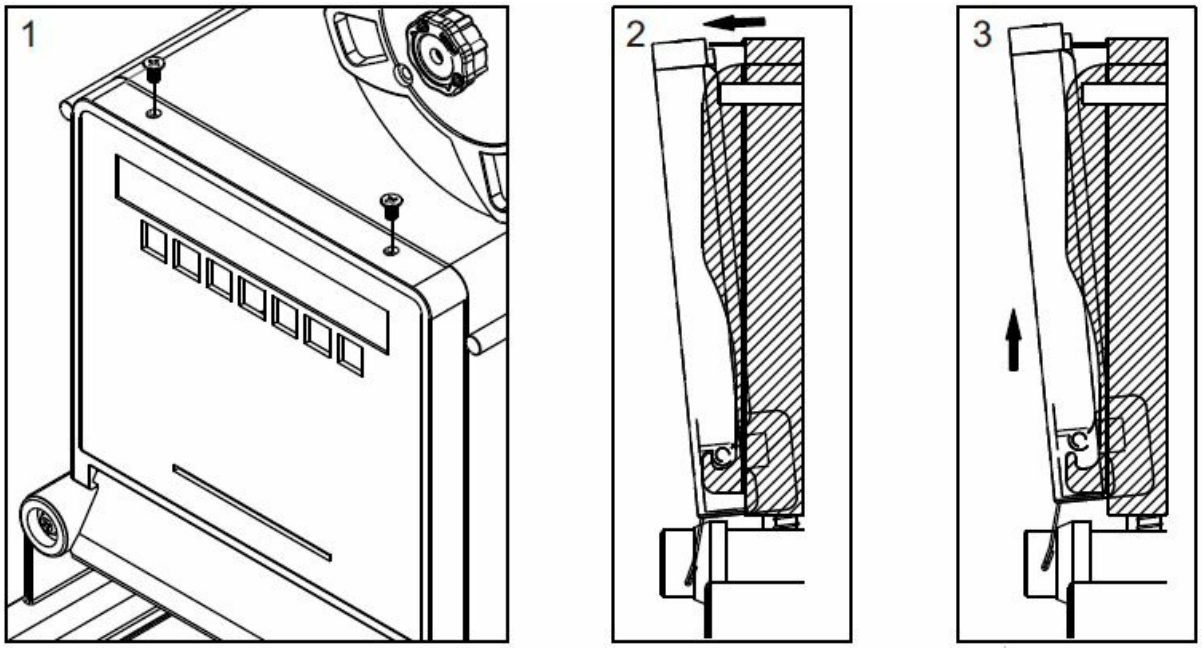
- **Model:** LF-90, LF-95, LF-98, LF-120
- **Product Name:** Automatic Sealing machine
- **Voltage:** 120V, 220V, 120V, 220V, 120V, 220V, 120V, 220V
- **Power:** 400W, 380W, 400W, 380W, 400W, 380W, 560W, 540W
- **Frequency:** 50/60Hz
- **Net Weight:** 22kg
- **Caliber:** 90mm, 95mm, 98mm, 120mm
- **Cupsealing Speed:** 50Hz – 450 cups/h, 60Hz – 530 cups/h
- **Maximum Cup-sealing Height:** 180mm
- **Dimensions:** 253*365*560mm

FAQ

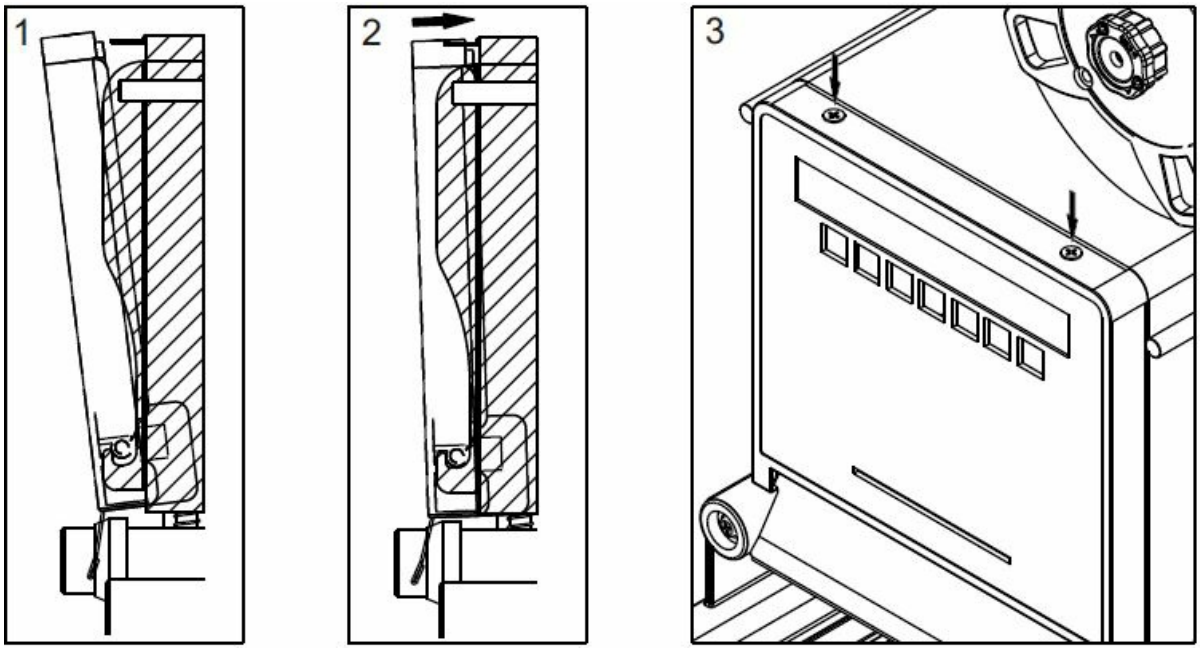
- Are business machines available for use by non-professionals?
  - No, business machines are only available for use by professionals.
- Can parts or specifications of the machine be changed?
  - Yes, the company reserves the right to change any parts or specifications of the complete machine at any time.

Dismounting/mounting the control panel

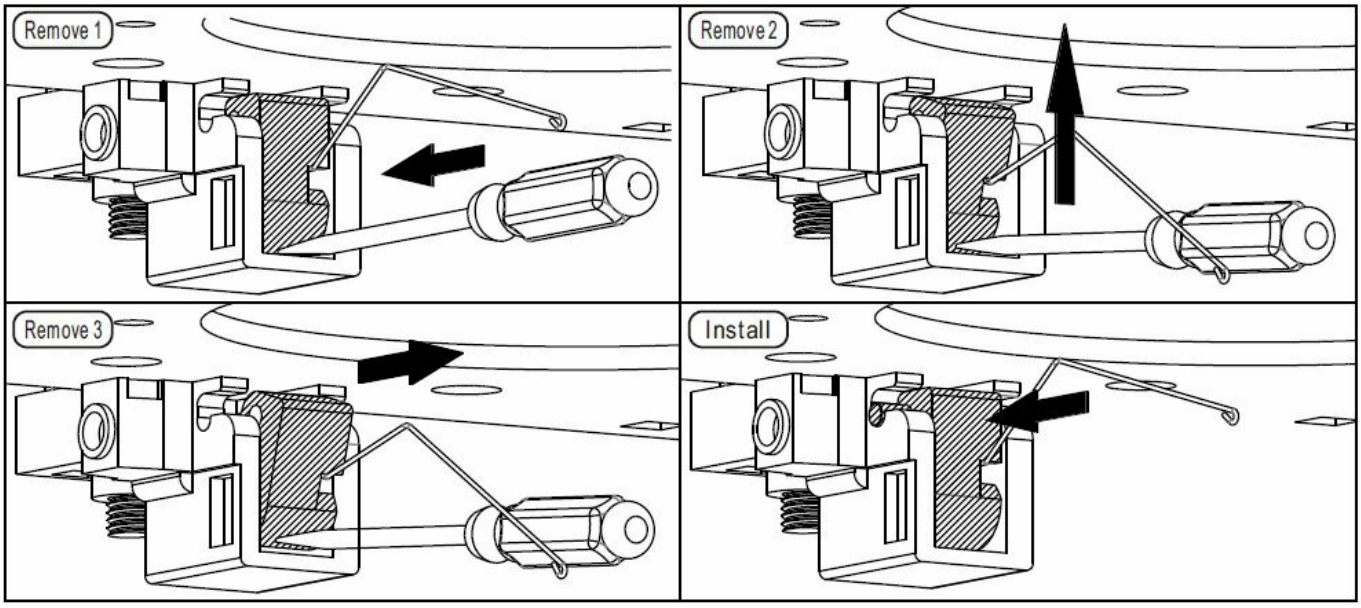
Dismounting



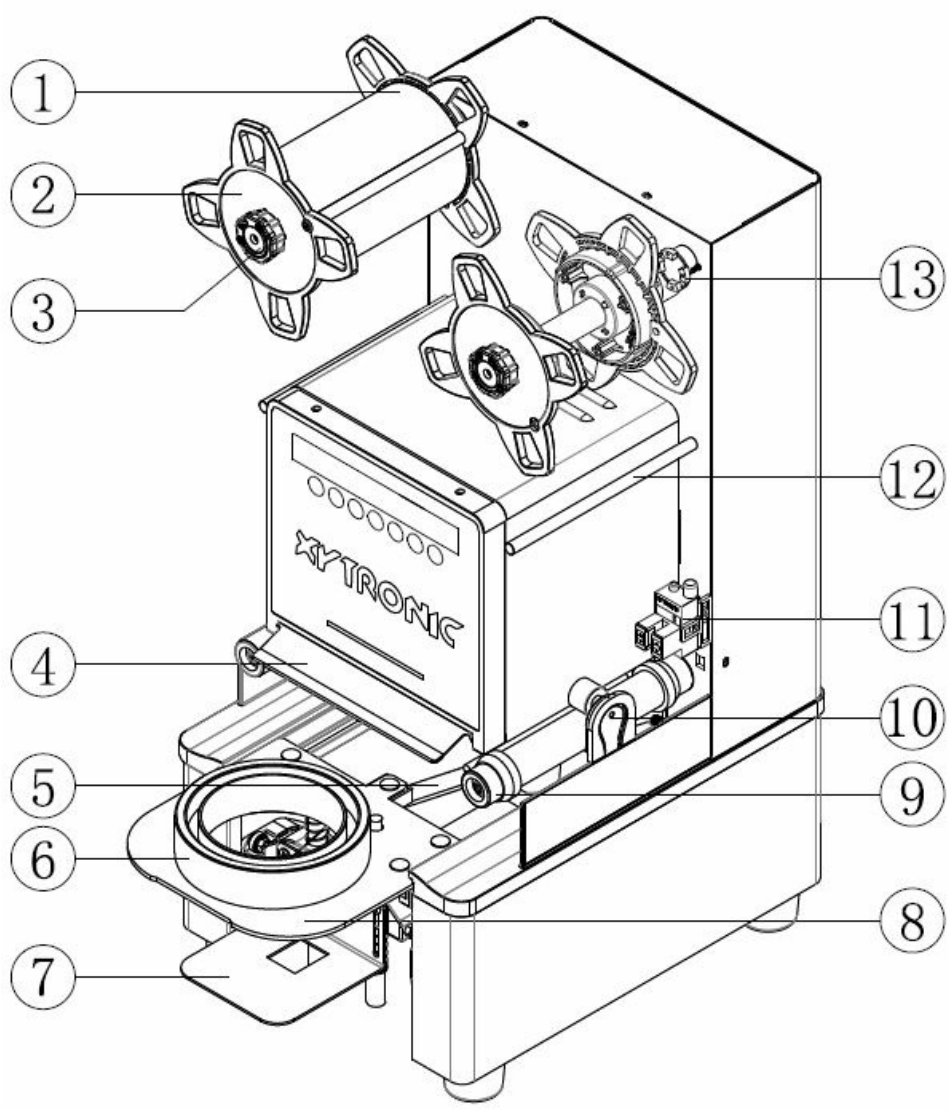
Mounting



Replacing the cup spring wire


Remove 1
Remove 2
Remove 3
Install

Main Parts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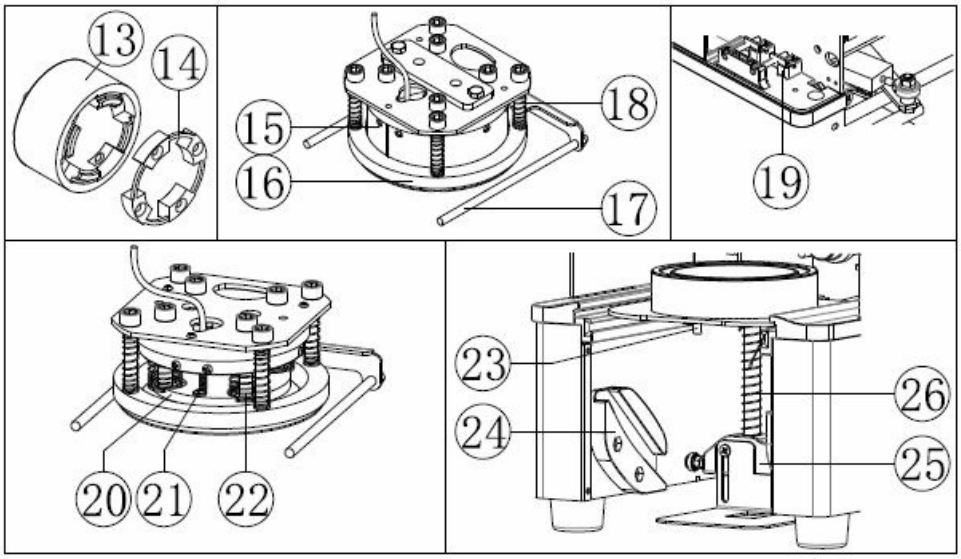
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1	Film-collecting cylinder
2	Film-pressing sheet
3	Lock
4	Safety door
5	Lower mold pull rod
6	Lower mold ring
7	Cup support
8	Lower mold support plate
9	Tension cylinder
10	Puncher
11	Film photo sensor
12	Film-smoothening rod
13	Shaft coupler
14	Damping block
15	Film cutter
16	Film-pressing ring
17	Film support rod
18	Film-pressing spring
19	Access sensor
20	Heating disk
21	Temperature sensor
22	Cup-sealing spring
23	Drainer
24	Jacking sheet
25	Cup supporting bracket
26	Cup-jacking rod and spring

Panel Indicator Lamps

1	Cup-in indicator lamp	2	Down-press lamp	3	Film-rolling indicat or lamp	4	Information display a rea
5	Manual mode in dicator lamp	6	Heating indicator lamp	7	Warning indicator lamp	8	Touch indicator lamp
9	Hibernation indi cator lamp	10	Constant-temperature indi cator lamp	11	Automatic mode i ndicator lamp	12	Film photo sensor in dicator lamp
13	Rising lamp	14	Cup-out indicator lamp				

Panel Functions

Operator panel

Panel key functions

- 

After turning on the main power switch, press this key for starting-up to extend the lower mold and make sure the heater works, then, press this key for shutdown to return the upper mold to the upper locating point, and send the lower mold to the internal locating point, as well as cut off the power output of the main board.
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During starting-up, the default mode is manual mode. Under standby state, press this key to switch

between automatic mode and manual mode.

-  Use this key together with SET, and press this key to reduce the set value.
-  Use this key together with SET, and press this key to increase the set value.
-  Press this key to enter FUNCTION SET, and continuously press this key to enter the next option till P-8, and then press to automatically save the set value and exit.
-  Under stand-by state, press this key to select information display area to display present temperature or cup counter.
-  Under manual mode, touch this key to implement cup-sealing operation (this key is a touch key).

Special Function Specification

Under starting-up state, press the following keys at the same time as follows:

 **Cutter soaking mode**

Please pull down the drainer to block the drain hole first, then fill the groove of the lower mold ring with boiled water until full. After this function is started, the lower mold is sent to the internal locating point without any film-rolling operation and the upper mold is pressed downwards for 600s. After time out, the upper mold automatically rises up and the machine automatically powers off.

 **Maintenance mode ***High Temperature Danger*****

After this function is started, the lower mold keeps extending out. After the upper mold drops to the lowest position, the machine automatically powers off. After the heater is cooled to normal temperature, the professional maintenance staff may remove the power wire, dismount the panel, the upper cover and the rear cover for necessary cleaning, maintenance or repair.

 **Read the total cup number of the main board**  **Page turn**

When the cup number is displayed in the information display area, start this function to display LXXX, wherein L is the home page identification code, and XXX is the cup number ended with a decimal point and can include 7 figures, for example, L523. represents 523 cups; L523 without a decimal point represents a number more than 999. Press AUTO to display the next page. For example, 168. means that the total cup number information of the main board is equal to L523168., namely the total cup number is 523168 cups. Only press Counter to exit from the reading function for normal display.

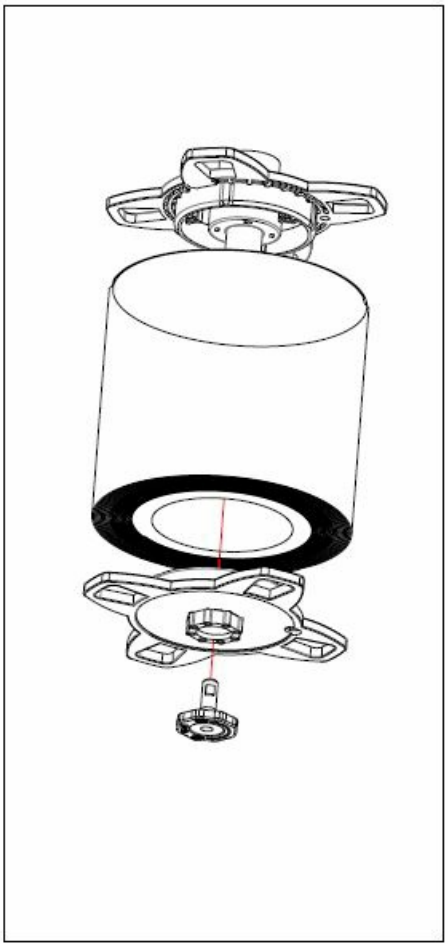
 **Cup number record resetting**

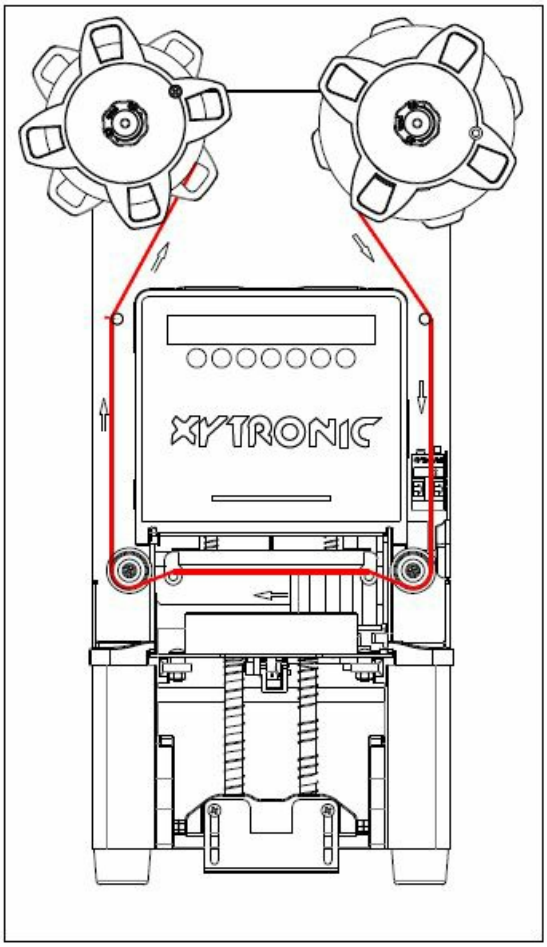
- When the cup number is displayed in the information display area, long press this key to reset the cup number record, wherein the total cup number is not reset.

Cup-sealing again

- Under manual mode, long touch this key for cup-sealing, without rolling the film or recording the cup number.

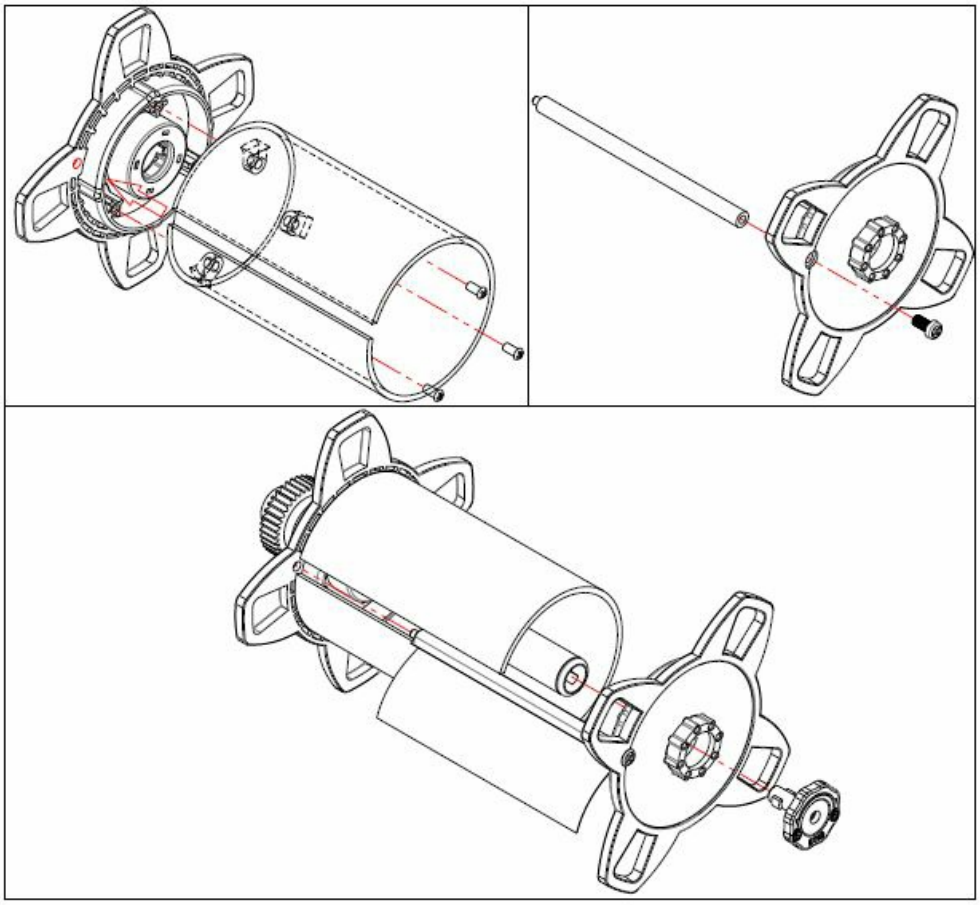
Preparation before Operation





- As shown in above Fig.1 and Fig.2, install and guide the film (note 1*), and align the film photo sensor point of the film to the film photo sensor induction position.

Note: If the film fails to pass through above the film-supporting rod, the film may adhere to the heater and accordingly cause a weak cup seal.



1. Plug the (accessory) power cord into the socket at the back of the machine.
2. According to the machine voltage indication, plug the power cord into the correct outlet to ensure the effectiveness of the grounding pin.
3. After the main power switch at the back of the machine is turned on, the key lamp goes on and the LED lamp on the information display area on the panel goes on with “-” and has an anticlockwise slip rotation to indicate that the host machine is powered on.
4. Press START to automatically extend out the lower mold and start the heater for heating. After about 2.5min, the constant-temperature indicator lamp goes on along with 6 tick sounds and flickers, thus indicating that the machine is under the standby state and the manual cup-sealing operation can be started (note 2*).
5. For automatic cup-sealing operation, press AUTO to turn on the automatic mode indicator lamp, namely the automatic cup-sealing operation can be started (note 3*).
6. When P-6 is set as 010, if no key is touched within 20 min, the machine will automatically enter the sleep mode under the hibernation temperature of 80℃, and the display window will rotate anticlockwise and display lamp number, when any key is pressed, the machine will enter the standby state and quickly (about 80s) automatically raise the temperature to the set temperature.

Note 1*: Reference for material compatibility between glue film and cup, and film-sealing temperature

Pull film is applicable to plastic cup and paper cup.	Temperature setting:130℃-165℃
PE film is applicable to paper cup.	Temperature setting:140℃-150℃
PP film is applicable to plastic cup.	Temperature setting:160℃-190℃

Note 2*: Manual start is a touch switch; under constant-temperature state, when the fingers are moved nearby, the touch indicator lamp will go on along with one tick sound before cup-sealing operation. If P-8 is set as 010, two tick sounds will be sent out to reminder the operator that there is no cup or action.
Note 3*: Before the set temperature is reached, you are allowed to press the start key or the AUTO and put the cup; the machine will automatically implement the cup-sealing operation under the set temperature after the prompt sound.
Note 4*: In order to avoid invalid or unsuccessful cup-sealing operation, the cup-sealing operation will not be implemented automatically in the machine before the temperature reaches the set value.
Note 5*: Puncher can be used only the temperature inside the cup is below 70℃.The air may not complete escape in time if above 70℃.(Excessive temperature can be dangerous.)

Function Setting Method

Function code

Code/Function	Adjustable Parameters	Default
P-1 Temperature setting	80℃-200℃	160
P-2 Counter locked	000:Disable,010:Enable	000
P-3 Hot-pres keep time	005-030,0.5s-3s	010
P-4 Start-sealing delay time	000-030,0-3s Delay	010
P-5 Film scroll time	000,Marked film, 001-060, Blank film	000
P-6 Sleep mode	000: Disable,010:Enable	000
P-7 Temperature unit	℃,℉	℃
P-8 No cup tips	000: Disable,010:Enable	000

Setting method

Code/Function	Under Starting-up State	Input Value Adjustment	Setting End
P1 Temperature setting	Press ***SET*** to display ***P1*** and then display present set value.	△or▽	Then press ***SET*** to enter the next option or wait for 10s to automatically save the settings and return to the standby state.
P2 Counter locked	Press ***SET*** to display ***P2*** and then display present set value.		
P3 Hot-pres keep time	Press ***SET*** to display ***P3*** and then display present set value.		
P4 Start-sealing delay time	Press ***SET*** to display ***P4*** and then display present set value.		
P5 Film scroll time	Press ***SET*** to display ***P5*** and then display present set value.		
P6 Sleep mode	Press ***SET*** to display ***P6*** and then display present set value.		
P7 Temperature unit	Press ***SET*** to display ***P7*** and then display present set value.		
P8 No cup tips	Press ***SET*** to display ***P8*** and then display present set value.		
Setting end	Then, press ***SET*** to enter the next option or wait for 10s to automatically save the settings and return to the standby state.		

Analysis and Solutions

Fault Code	Fault Status	Fault Cause	Solutions
E00	The heating indicator lamp and the green temperature-reaching indicator lamp fails to go on.	1. Temperature sensor fails. 2. Temperature sensor plug is not properly inserted.	1. Open the panel, then, pull out and insert the temperature sensor plug again, and restart the machine after confirmation. 2. Please contact the company.

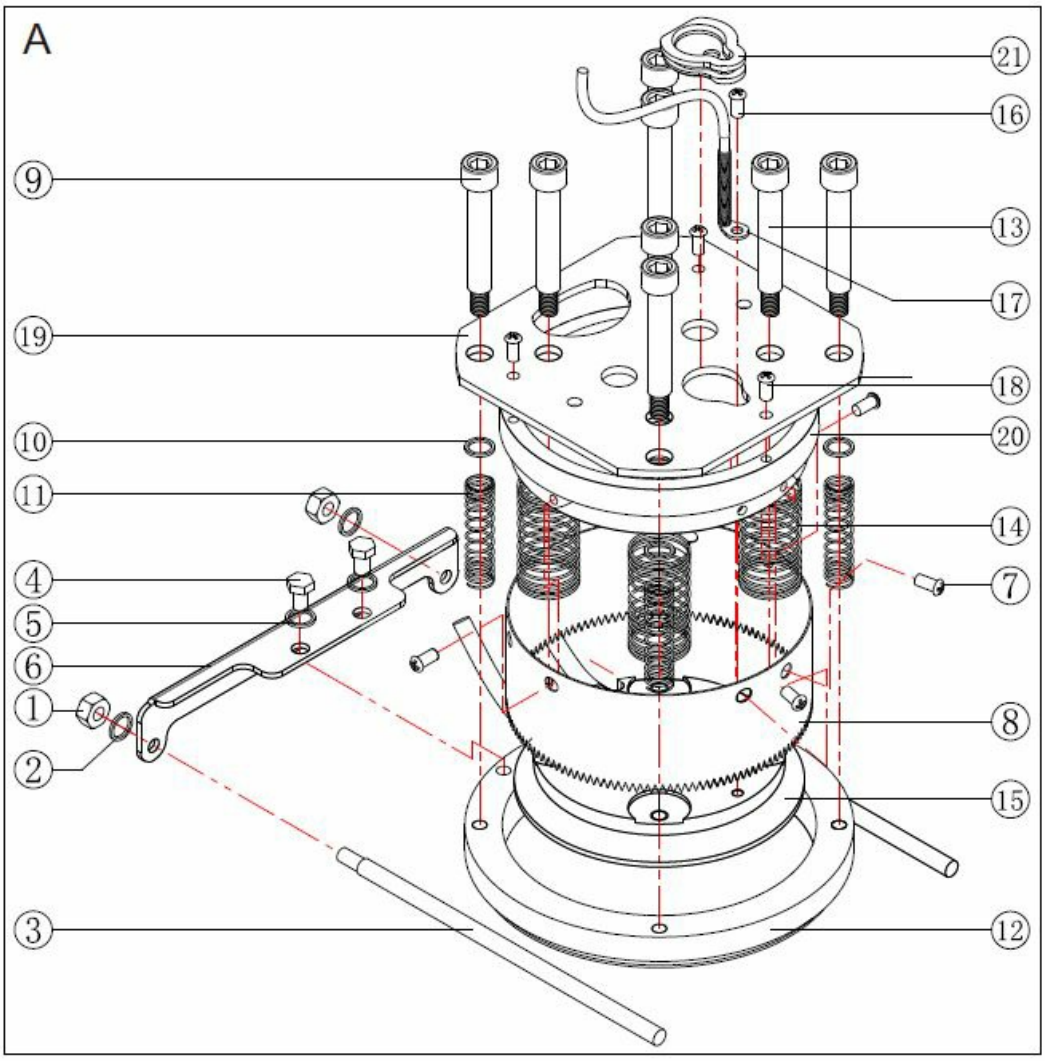
E01	The heater fails or slow heating rate.	1. The wire of heater is loosened. 2. Heater burn-out: 90/95/98 normal heater resistance 120V/about 50Ω, 220V/about 200Ω, 120 normal heater resistance 120V/about 33Ω, 220V/about 130Ω	1. After opening the rear cover, confirm whether HEAT at the adapter plate is properly connected and locked. 2. Measure HEAT resistance; in case of abnormal resistance, please contact the company.
E02	1. Appear during starting- up	1. Upper sensor fails or poor contact of upper sensor plug 2.Hot-pres keep motor fails.	1. Open the rear cover, then, pull out and insert UP at the adapter plate, and restart the machine after confirmation. 2. Please contact the company.
	2. While using, the upper mold fails to rise up to the located position.		
E03	1. While starting-up, the lower mold fails to extend out.	1. External sensor fails or poor contact of external sensor plug 2. Lower mold motor fails	1. Open the rear cover, then, pull out and insert PUSH at the adapter plate, and restart the machine after confirmation. 2. Please contact the company.
	2. While using, half of the lower mold extends out, or the lower mold fails to extend out to the located position or has abnormal sound or works inefficiency.	One or more of lower mold bearing, cup-jacking rod, cup-jacking rod spring, cup support bracket bearing, jacking sheet track, etc. is blocked.	Remove dirt, clean and scrub the lower mold, and add lubricating grease or sewing machine oil.
E04	1. Appear during starting- up.	1. The film fails to pass through the film photo sensor induction point. 2. The transmitting lens of the film photo sensor is dirty. 1. The sensitivity of the film photo sensor is too low.	1. Correctly guide the film to pass through the film photo sensor induction point. 2. Clean the transmitting lens of the film photo sensor. 3. Rotate the film photo sensor adjustment shaft clockwise by one or more circles.
	2. The film is half sealed.		
	3. The film is always rotated.		

E05	1.During the film-sealing process, the lower mold is not sent to the located position.	1. Internal sensor fails or poor contact of internal sensor plug 2. Lower mold motor fails	1. Open the rear cover; then, pull out and insert PULL at the adapter plate, and restart the machine after confirmation. 2. Please contact the company.
	2.During the film-sealing process, the upper mold fails to move.	1. Upper sensor fails or poor plug contact. 2. Upper mold motor fails	1. Open the rear cover, then, pull out and insert UP at the adapter plate, and restart the machine after confirmation. 2. Please contact the company

E06	1. Appear during start up	1. Lower sensor fails or poor contact of lower sensor plug. 2. Upper mold motor fails	1. Open the rear cover, then, pull out and insert DOWN at the adapter plate, and restart the machine after confirmation. 2. Please contact the company.
	2. While using, the upper mold fails to drop to the designated position.		
	3. The lower mold touches the lower limit column.		
E07	The warning indicator lamp goes on, and the lower mold extends out along with continuous tick sound	The safety door cannot be set at the located position due to the touch on safety door switch, the safety door or micro-switch fails or there is a foreign matter blockage.	1. Remove the foreign matter which touches the safety door, or move the safety door back and forth to make it naturally swing to the located position. 2. Please contact the company.
E19	All keys have no response.	1. Main board fails. 2. The temperature of the heater is above 250℃.	Please contact the company.
None	The film-sealing pattern is uneven on left and right sides.	Incorrect film photo sensor position	Adjust the film photo sensor position, for pattern deviation to the left, please adjust the film photo sensor upwards. For pattern deviation to the right, please adjust the film photo sensor downwards.

None	After film-sealing operation, the film is melted to the cup mouth.	The temperature is too high.	It is suggested to adjust the operating temperature according to the film or properly reduce the set temperature.
None	The sealing film is not tight, water or air leakage.	1. The film is incompatible with the cup material.	Adopt the film applicable to the cup material.
		2. The heater is adhered with syrup or foreign matter.	Cut off the main power, and scrub the heater with slightly wet cloth after it is completely cooled.
		3. The cup-sealing time is too short.	Increase P-3 film-sealing time.
		4. The set temperature for cup- sealing is too low.	Increase P-1 film-sealing temperature.
		5.The cup may be deformed due to improper storage	Replace the normal cup
		6.The paper cups film is too thin to sealing	Replace the normal cup
None	Draggy film cutting	The film cutter is not sharp enough, or the film cutter is adhered with foreign matter.	Continuously execute the cutter soaking program, and then remove the foreign matter.
None	The film cannot be completely cut off.	Film chip or foreign matter exists between the film cutter and the heater.	Cut off the main power, and remove the foreign matter after it is completely cooled.

Explosive View for Dismounting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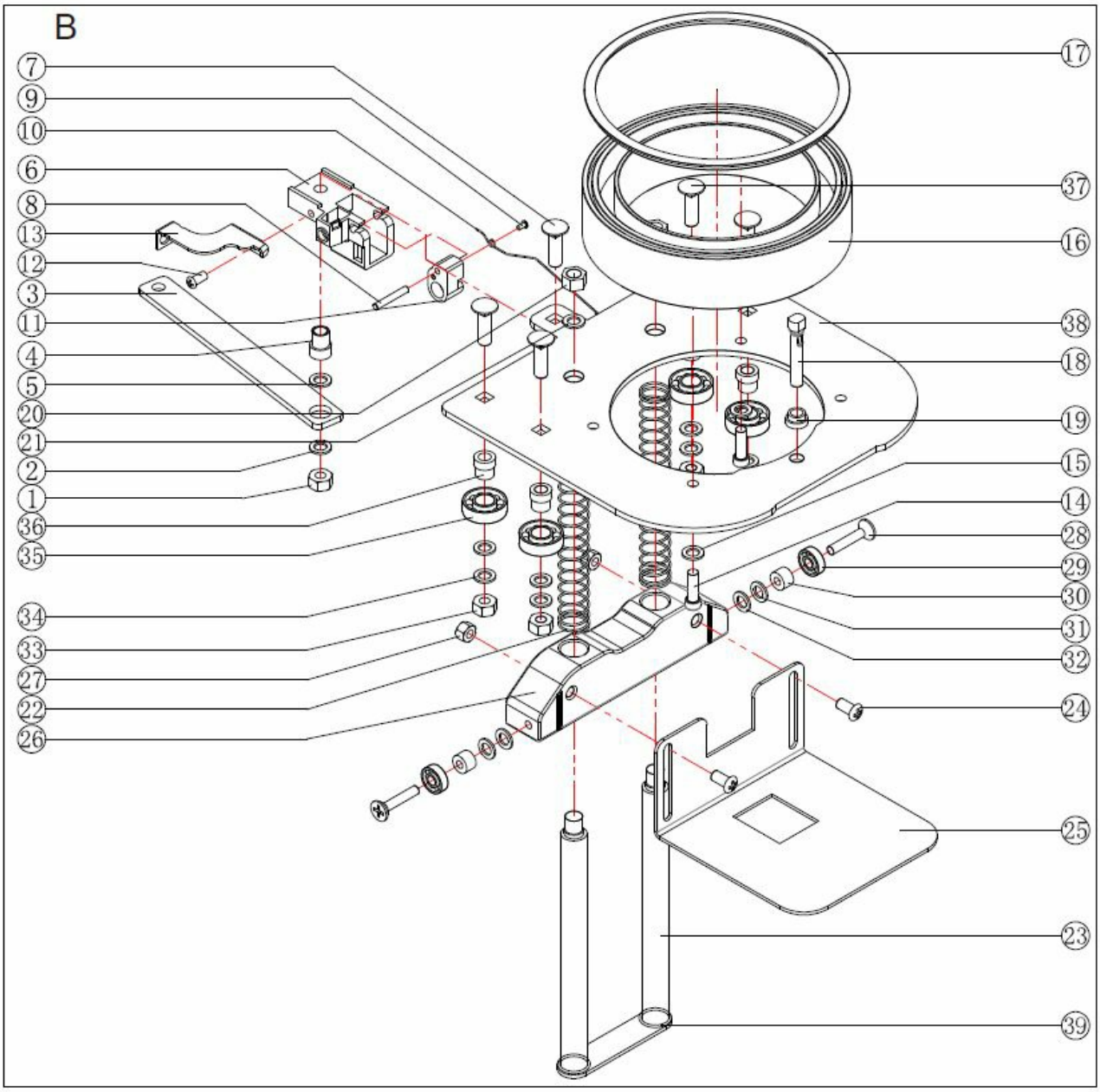
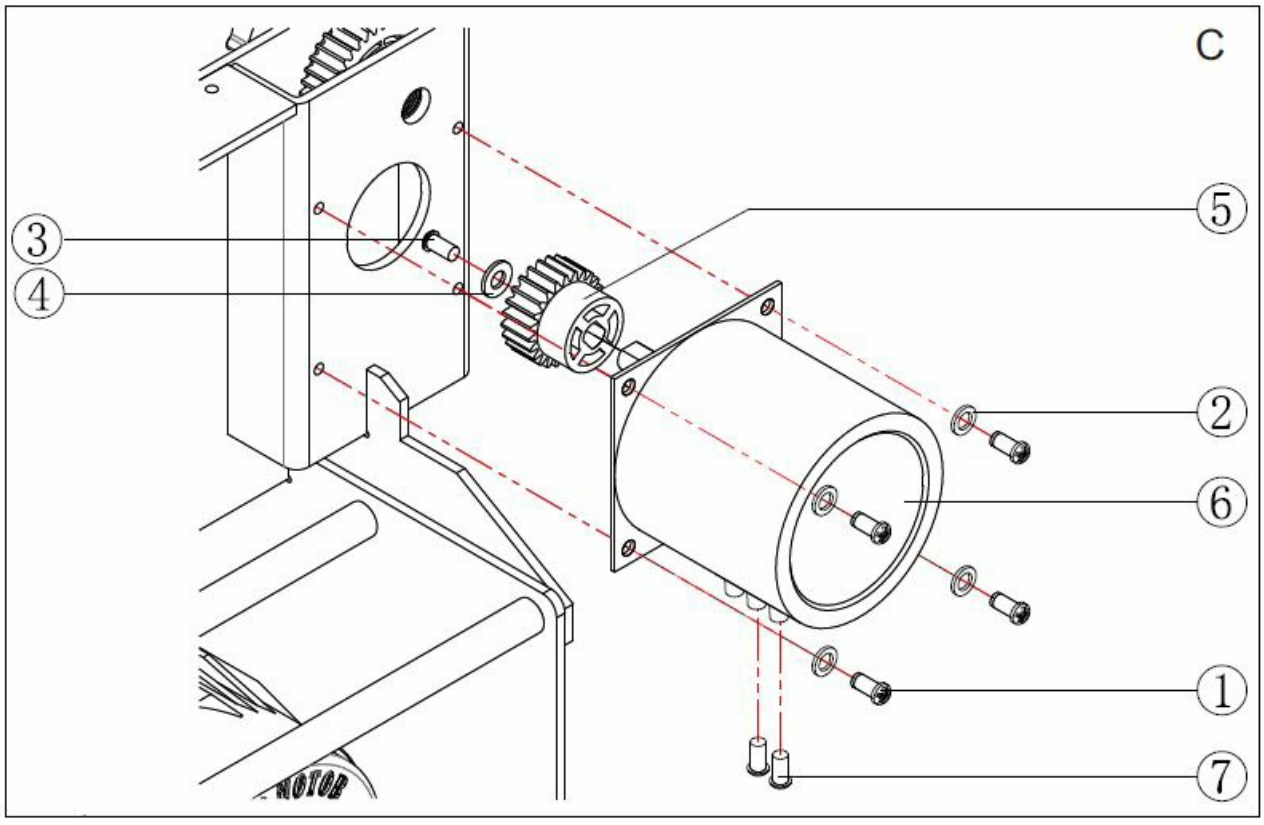
No.	Name	Quantity	No.	Name	Quantity
A1	Nut	2	A2	spring-washer	2
A3	Film support rod	2	A4	Screw	2
A5	Spring-washer	2	A6	Film support rod bracket	1
A7	Screw	4	A8	Film cutter	1
A9	Screw	4	A10	Flat-washer	4
A11	Spring	4	A12	Film-pressing cup	1
A13	Screw	4	A14	Film-sealing spring	4
A15	Heater	1	A16	Screw	1
A17	Temperature sensor	1	A18	Screw	3
A19	Support plate	1	A20	Film cutter holder	1
A21	Sealing cap	1			

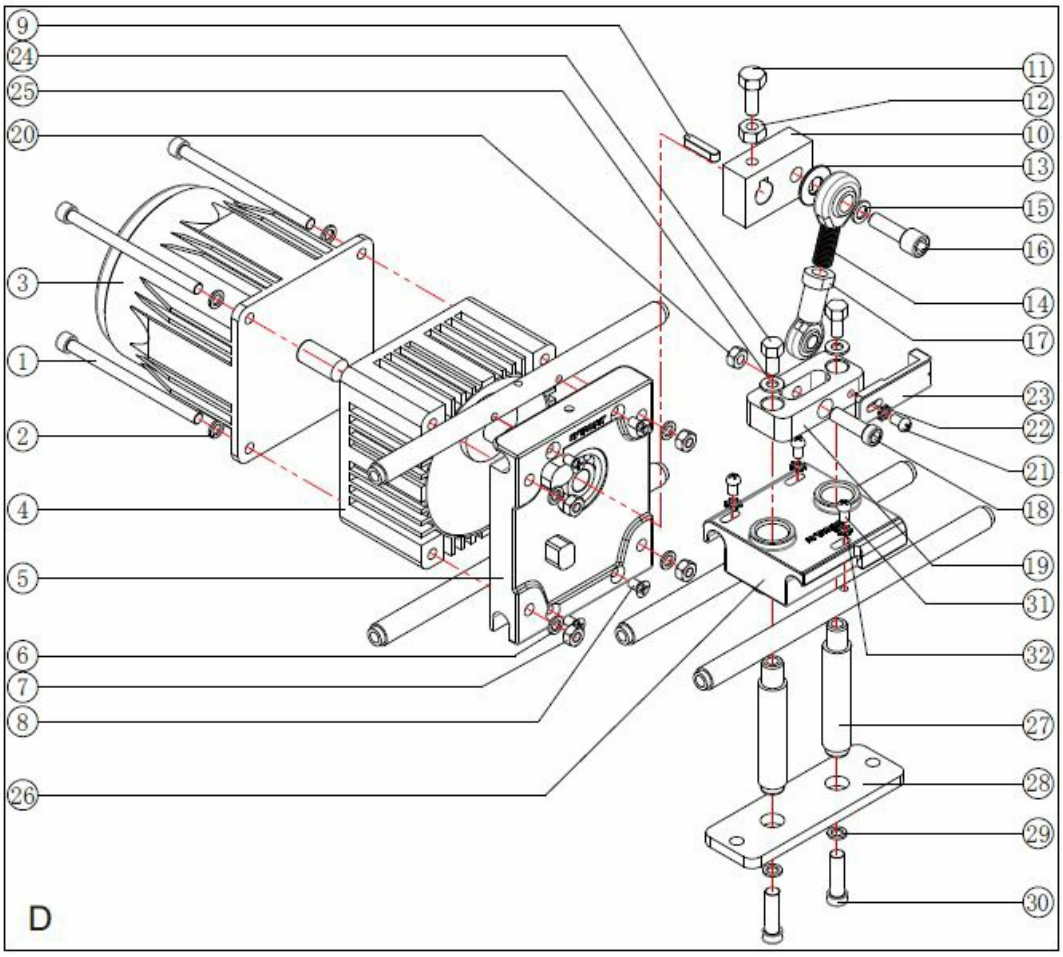


No.	Name	Quantity	No.	Name	Quantity
B1	Nut	1	B2	Spring-washer	1
B3	Lower mold pull rod	1	B4	Connector	1
B5	Revolving shaft Flat-washer	2	B6	Mouse tail base	1
B7	Screw	1	B8	Mouse tail plug	1
B9	Mouse tail lock screw	1	B10	Mouse tail spring wire	1
B11	Action block	1	B12	Lock screw	1
B13	Bunch sheet	1	B14	Lock screw	2
B15	Spring-washer	2	B16	Lower mold ring	1

B17	Lower mold silicone ring	1	B18	Drainer	1
B19	Drainer shaft seal	1	B20	Nut	2
B21	Spring-washer	2	B22	Cup-jacking spring	2
B23	Cup-jacking rod	2	B24	Screw	2
B25	Cup support	1	B26	Cup support bracket	1
B27	Nut	2	B28	Screw	2
B29	Cup-jacking bracket bearing	2	B30	Screw rod	2
B31	Spring-washer	2	B32	Bearing flat-washer	2
B33	Nut	4	B34	Spring-washer	4
B35	Bearing	4	B36	Bearing seat	4
B37	Screw	4	B38	Lower mold support plate	1
B39	Washer	2			

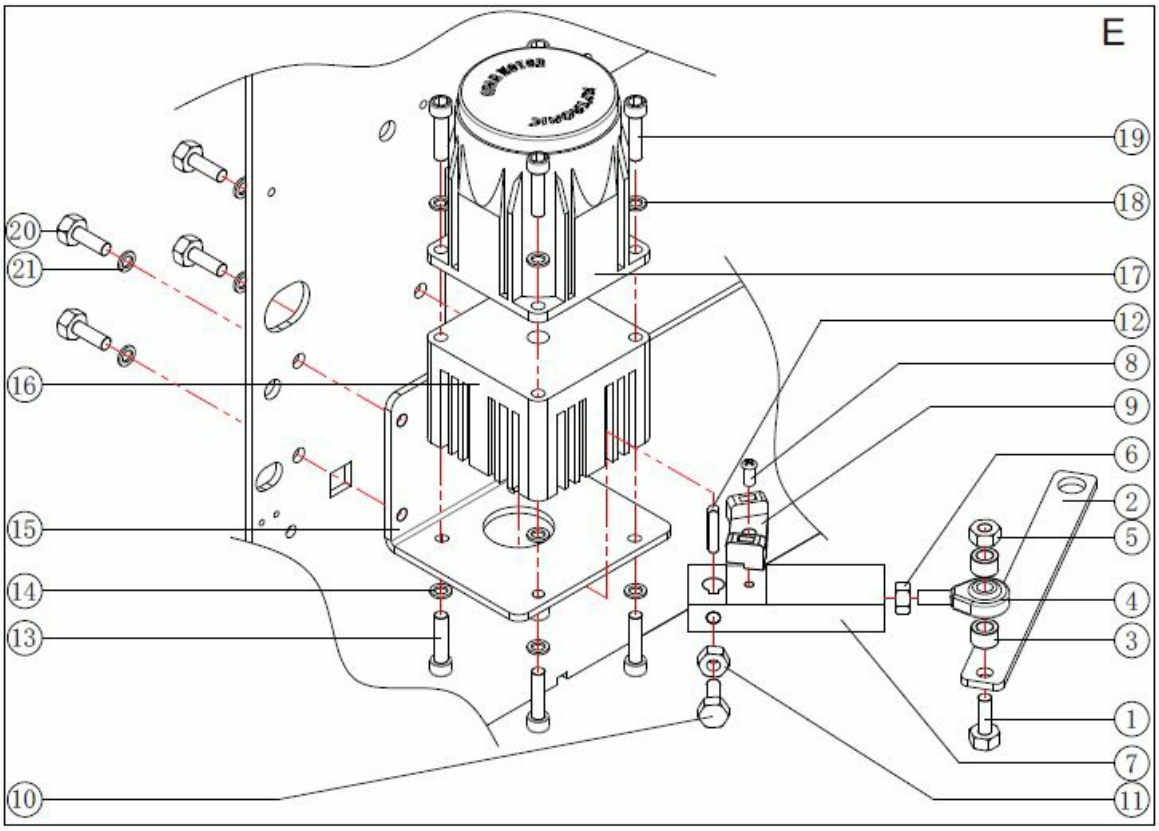


No.	Name	Quantity	No.	Name	Quantity
C1	Screw	4	C2	Spring-washer	4
C3	Screw	1	C4	Spring-washer	1
C5	Film-rolling drive gear	1	C6	Film-rolling motor	1
C7	Screw	2			



No.	Name	Quantity	No.	Name	Quantity
D1	Nut	4	D2	Flat-washer	4
D3	Hot-pres motor	1	D4	Reduction gear box	1
D5	Motor Bracket	1	D6	Spring-washer	4
D7	Screw	4	D8	Screw	4
D9	Key of motor	1	D10	Drive rod	1
D11	Screw	1	D12	Nut	1
D13	Flat-washer	1	D14	Joint bearing	1
D15	Spring-washer	1	D16	Screw	1
D17	Joint bearing	1	D18	Screw	1
D19	Middle Axis	1	D20	Nut	1
D21	Screw	1	D22	Washer	1
D23	Magnet Seat	1	D24	Screw	2

No.	Name	Quantity	No.	Name	Quantity
D25	Spring-washer	2	D26	Shaft seat	1
D27	Double Connecting Rod	2	D28	Middle Axle lower Block	1
D29	Spring-washer	2	D30	Screw	2
D31	Screw	3	D32	Washer	3



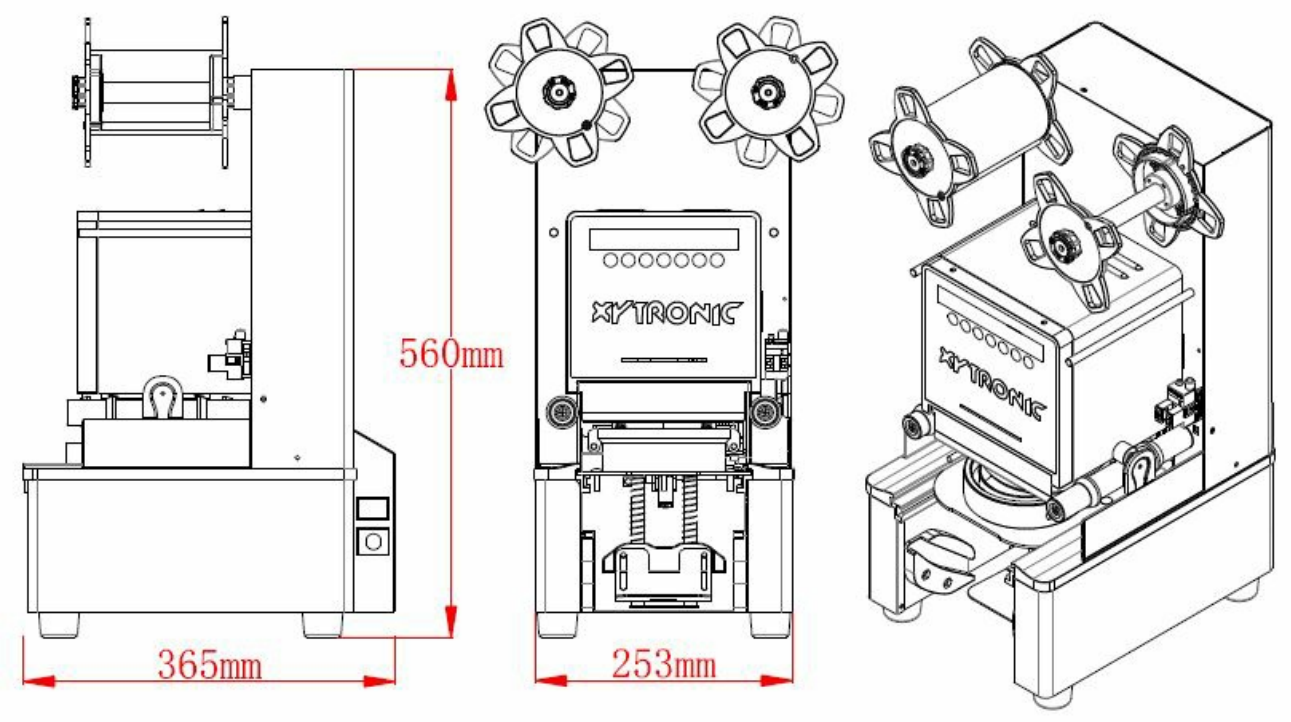
No.	Name	Quantity	No.	Name	Quantity
E1	Screw	1	E2	Rod	1
E3	Sleeve	2	E4	Joint bearing	1
E5	Nut	1	E6	Nut	1
E7	Drive Rod	1	E8	Screw	1
E9	Magnet Seat	1	E10	Screw	1
E11	Nut	1	E12	Key of 2RK lower motor	1
E13	Screw	4	E14	Washer	4
E15	Motor bracket	1	E16	Conveyor motor	1
E17	Reduction gear box	1	E18	Washer	4
E19	Screw	4	E20	Screw	4
E21	Spring-washer	4			

Warning: To reduce the risk of electric shock or damage to your equipment:

1. High temperature and high voltage inside, be careful.
2. If exception occurs (such as the burning odor), stop the operation and cut off the power supply.
3. The ground wire must be properly connected, otherwise it may be risk of electric shock.
4. When the machine is running, it is forbidden to insert the hand or other parts of the body into the machine, or it may lead to scalding or being hurt by a sharp knife.
5. The vents shall not cover any obstruction, or other problems may be caused by poor heat dissipation.
6. Ensure that the power supply voltage, frequency and current is the same as the rating in the product specification, otherwise it may cause an electric shock or fire.

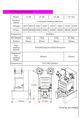
7. If there is an electrical paralysis ,When touching the housing ,Stop operation and cut off the power supply, otherwise it may be risk of electric shock.
8. Please place the machine on a stable and reliable plane, otherwise it may be risk of dumping and falling.
9. Do not touch the power switch and plug with wet hand, otherwise it may be risk of electric shock.
10. Do not place articles on the machine , otherwise it may be risk of electric shock, fire or personal injury.
11. Unplug the power plug before cleaning.
12. Do not spray water directly on the surface of this product for cleaning.
13. Do not repair, refit or disassemble the machine without authorization, if there is a fault, please hand it over to the technician to detect and repair.

Product Parameter



Model	LF-90		LF-95		LF-98		LF-120	
Product Name	Automatic Sealing machine							
Voltage	120V	220V	120V	220V	120V	220V	120V	220V
Power	400W	380W	400W	380W	400W	380W	560W	540W
Frequency	50/60Hz							
Net Weight	22kg		22kg		22kg		22.5kg	
Caliber	90mm		95mm		98mm		120mm	
Cup- sealing Speed	50Hz450cups/h,60Hz530cups/h							
Maximum Cup- sealing Height	180mm						150mm	
Dimensions	253*365*560mm							

Documents / Resources

	Xytronic LF-90 Automatic Sealing Machine [pdf] User Manual LF-90 Automatic Sealing Machine, LF-90, Automatic Sealing Machine, Sealing Machine, Machine

References

- User Manual