Blister Sealing Machine

INSTRUCTION MANUAL

I. FUNCTION

500 model automatic high speed blister packing sealing machine is suitable to seal transparent PVC blister pieces and plastic paper card togather. It is transparent, artistic, moisture-proof, dustproof, guarding against disperses after sealing the product. It is widely used in commodity packing such as hardware, toy, stationery, eyeglasses, small daily use articles, battery, handicraft, auto fitting, electric appliance part, souvenir and so on.

II. CHARACTERS

1. Operate easily: so long as the delay time, the heat time and the cooling time and also the heating current switch gear is set, and then rotating the disc worktable manually, the time delay system, the heating system and the cooling system can operate automatically, and finally complete the sealing process.

2. There are three worktables for the machine which accelerate the packing speed, enhance the production efficiency.

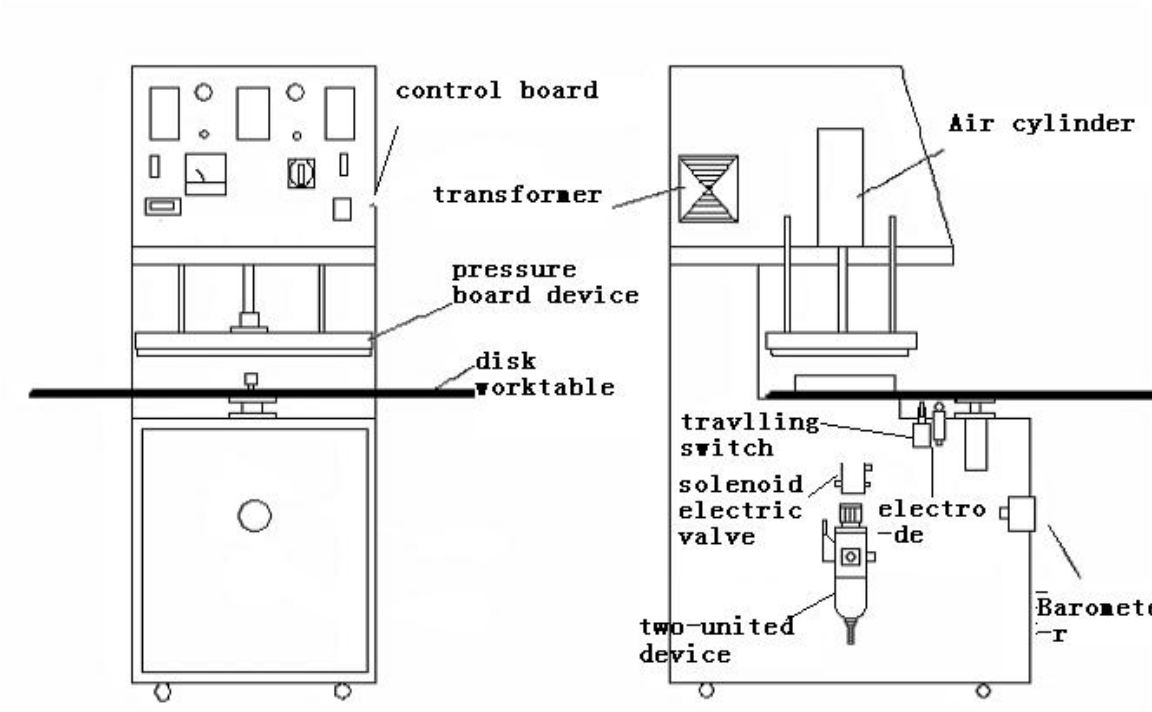
a)The mold is only applicable to seal the edge of blister pieces and part of paper card which will not affect the products, and keep both of them smooth and artistic.

b)The machine structure is solid, reliable, durable.

III.MAIN TECHNICAL PARAMETER

Model	XBF-500
Power source	220 V, 50Hz, 3KW
Delayed time (second)	0-10 seconds (Adjustable)
Heating time (second)	0-10 seconds (Adjustable)
Cooling time (second)	0-10 seconds (Adjustable)
Shifting thermoelectricity device	Eight adjustable channel
Counting	Six figures
Pressure area (mm)	480mm×340mm
Turntable area (cm)	Φ980mm
Capacity	3-7 seconds/mold
Qty of mold	1 set for 3 pcs (produce specially)
Height of packing objects	2mm-150mm (changeable)
Packing material	PVC blister pieces and plastic paper card
Using Air source	⩾0.4Mpa
Machine size	1080mm×980mm×1460mm
Weight	150kgs

IV. INDICATION OF STRUCTURE



V. OPERATION STEPS AND PRINCIPLE

Put the formed blister pieces in the mold first, and then, put the product, cover the card, turn the disc worktable to the proper position. Turn on the travel switch, turn the AC contactor. The pressure board pressurizes down side automatically. The mold heating element is charged with electricity, heats and cools to the fixed time, finish the sealing, then the pressure board returns to the position. Then, revolve the disc worktable to be 120°, to make the second worktable to enter into the working position. The three worktables can be continuous working.

VI. SET THE HEATING CURRENT CONVERSION, DELAYE TIME,COOLING & HEATING TIME

1.Inspect the size of the mold and the thickness of the blister pieces. Adjusting the heating current conversion switch from the low position first. To set the delayed time for 1 second, the heating time for 3 seconds and the cooling time for 3 seconds (for reference). Starts to debug the operation. Inspect the effect of packing. Adjust the heating current conversion switch lower and shorter the heating time. Do it oppositely if contrary.

2.Adjust the heating time and the heating current conversion switch. They are international. Generally, the smaller the electric and the longer the heating time, the better the packing quality will be.

VII.PRECAUTIONS AND MAINTENANCE

1. All the adjustable device must be adjusted from low to high slowly when debug the new mold which will protect the mold from damage.
2. The mold should be placed on the center of working position to guarantee the air cylinder to press down evenly.
3. In the production process, the mold is pressed many times. So, it is normal that the teflon adhesive tape on the mold is damaged. It should be replaced and repaired in time.
4. In the use of mold, the heating current conversion must be adjusted when the voltage is too high or too low.

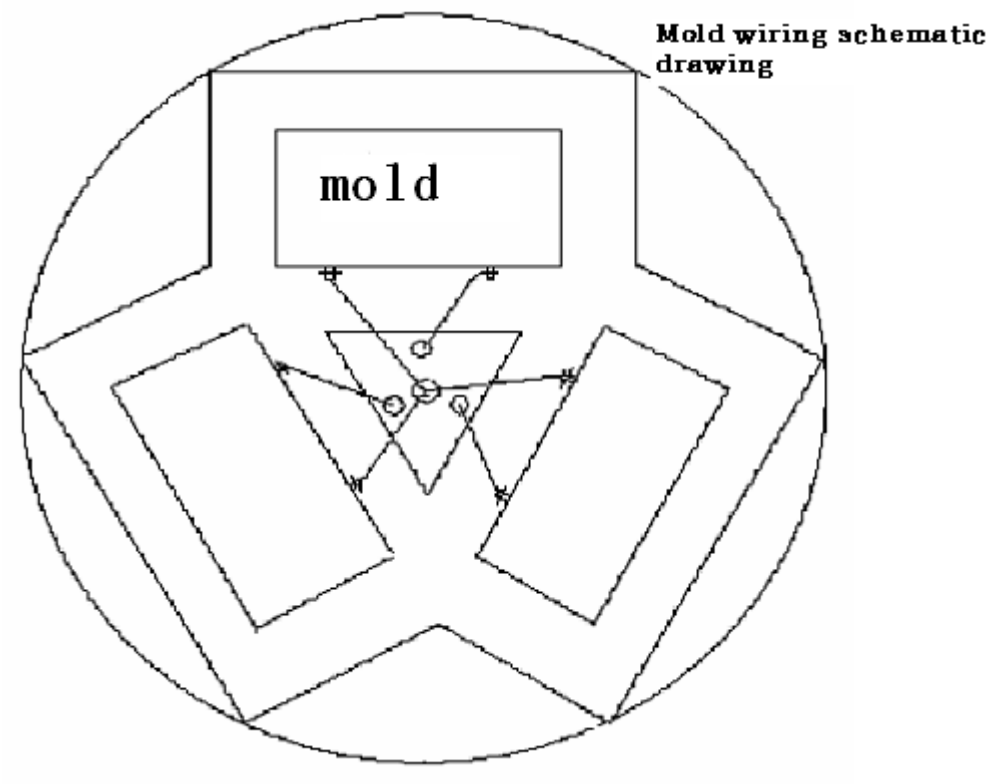
5. Please guarantee there is oil (white oil) in the lubricator of second air cylinder, but the oil level does not have to surpass 2/3, turn on the water filter to clean according to the situation.
6. Fill oil in the guide pillar 1 – 2 times each operation, clean once a season for the air operated parts.
7. Cut off the power once it has fault, and should be repaired by the specialist.
8. Power must connect the ground safely.

VIII. FAULTS AND PRECESSING MOTHOD

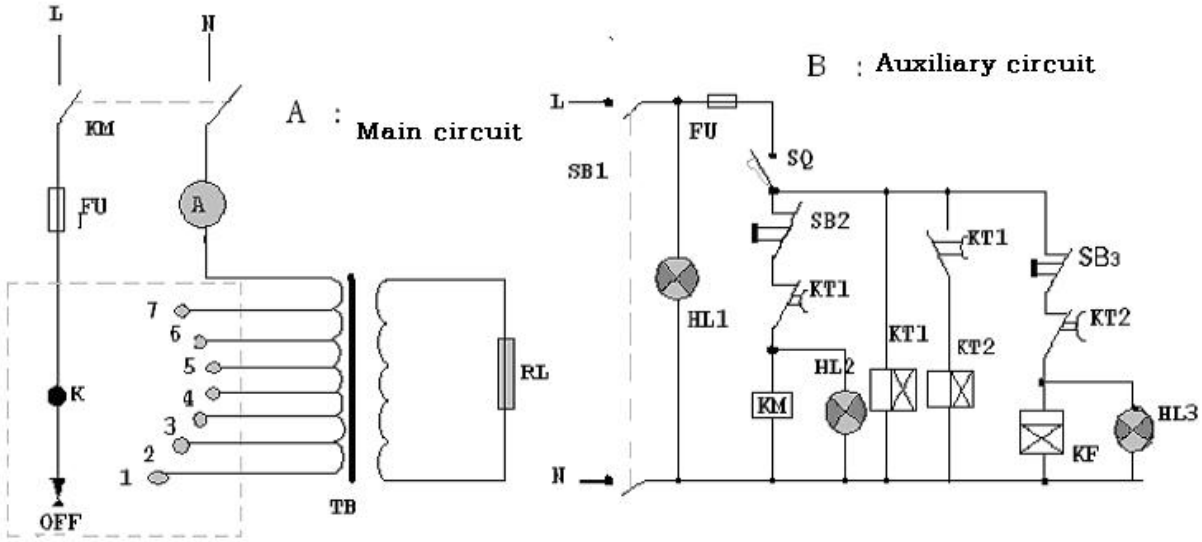
Phenomenon	Reason	Processing method
Burning	Current conversion gear too high	Adjust lower
Burning	Heating time too long	Adjust shorter
Cannot seal up	Current conversion gear too low	Adjust higher
Cannot seal up	Heating time too short	Adjust longer
Cannot seal up	Card paper have no glue	Stick glue on
Cannot seal up	The plastic material is not good	Change it
Mold hasn't heat	Connection of the electrode under the turntable is not good	Change it
Mold hasn't heat	Fuse burns out	Change it
Mold hasn't heat	AC contactor has malfunction	Change it
Mold hasn't heat	The mold wiring is not solid	Fix it
Mold hasn't heat	The transformer burns out	Change it
Product takes out difficultly	Cooling time too short	Delay longer
Partial wrinkle	Delayed time too shorter	Delay longer

Partial wrinkle	Mold is not smooth	Change it
Partial wrinkle	Side of the plastic is not straight	Change it
Partial wrinkle	Cooling time of mold is too short	Delay longer
Pressure board has no fluctuation	Air source doesn't supply	Connect the air source
Pressure board has no fluctuation	Air source is not enough	Adjust pressure of the air source
Pressure board has no fluctuation	The electrical magnet valve has malfunctions	Change it
Pressure board has no fluctuation	The blowhole is locked	Adjust and clean
Pressure board has no fluctuation	The traveling switch has malfunctions	Change it

IX. THE MOLDS' ELECTRICITY CONNECTION



X. CIRCUIT DIAGRAM



L.N: power source	KM:AC contactor	SB1-3: switch
FU: fuse	RL: load	HL1-3: Signal light
A: Ampere meter	K: shift switch	KT1-2: Time relay
TB: transformer	SQ:travelling switch	KF: electric magnet