



Operating Instruction AMTEC VERTIwrap ECO-Complete VFFS Liquid/Pump L



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1 General

Thank you for choosing our VERTIwrap Machine. It is user-friendly, safe and efficient machine. We hope you will be satisfied with your choice and use our product for a long time.

1.1 Using these instructions

- Read these operating instructions carefully before using the machine.
- These instructions explain the functioning and operation of this machine.
- Please keep them with the machine.
- If the machine is resold, the instructions belong with the machine. Do not damage these instructions.
- You must not make any changes to these instructions without our express approval.
- Should there be any alterations to the specifications of the machine, please enter them into these instructions accordingly.
- We reserve the right to make changes due to the reliability and improvement of the machine or instructions.
- Please contact us if you have any recommendations for improving the machine or these instructions.

All information in these operating instructions must only be used with sufficient technical understanding and in compliance with current occupational health protection regulations.

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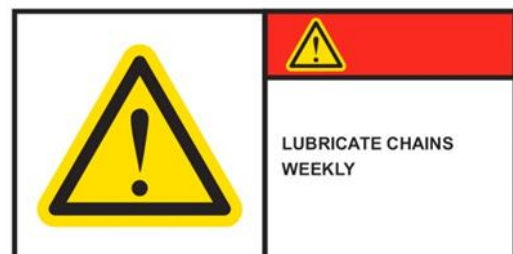
Internet: www.bluepack-machines.com

Original operating instruction

2 Safety

Never start this machine until you have familiarized yourself with the correct operation and safety information.

2.1 Typographical conventions



2.2 Proper use

The *AMTEC VERTIwrap ECO-Complete VFFS Liquid/Pump L* is intended for the packaging of liquids into bags. The liquid is dosed by a piston pump. The bags are made by the machine from a suitable flat film fed from a roll. Then the bags will be sealed after the filling. Suitability of the liquids, film and used materials must be confirmed in advance with a sample from the machine manufacturer.

Proper use includes compliance with the instructions and notes in these guidelines.

Any use beyond the scope of the intended purpose or other type of use is deemed to contravene the intended use and is improper use.

If products are used with the machine that do not correspond to sample products given to the manufacturer beforehand, it is considered improper use. The user/operator of the machine is solely liable for any resulting damages.

If the operator intends to use products that do not correspond to the sample products provided, written approval must be obtained from the manufacturer. The operator is obliged to provide all the necessary information.

2.3 Safety instructions for operating the machine

- It is forbidden to remove, damage, change or cover the safety devices, warning and information signs.
- If it is however necessary or unavoidable to disassemble the safety devices during maintenance or repairs, the safety devices must be reinstalled immediately after the work.
- Alterations to the machine or individual parts of the machine can affect the safety functions. Please obtain written approval from us before any alteration. We take no liability for unauthorized modification to/in the machine.
- Make sure that the power input required for using the machine is supplied by the electrical installation (fuse, wire size etc.). Otherwise there is a risk of damage to the machine or electrical installation!
- Only start operating the machine once it has been fully installed and adjusted.
- Before operation, ensure that the machine is in its proper condition.
- Before starting the machine, ensure that there are no tools or objects on or inside the machine.

- Only persons who have received official training may use this machine.
- Never leave the machine running unsupervised.
- Switch off the machine and unplug it from the mains before opening the machine.
- Do not use the machine in areas with high air humidity.
- Avoid the machine being in contact with a lot of steam.
- Don't use the machine in dusty surroundings.
- Often put lubricate oil on the drive part of the machine, and check it at some time.
- The equipment is combined with touch screen and PLC, make sure the main electric box is clear and dry. Do not put any sundries in the control box for avoiding serious result.

2.4 Safety instructions for operating personnel

The different tasks and work on the machine place different requirements on the qualification of the persons responsible for carrying out the work. In the interests of safety of staff and the machine and to avoid dangers:

- All work must be carried out by persons qualified to do it
- Insufficiently qualified persons must be kept out of the work area
- Only staff with sufficient training in operating the machine and safety measures should be allowed to work on the machine. Faulty operation can cause serious accident and loss of lives.

Additionally, the following points must be noted:

- When operating the machine staff should wear suitable protective clothing such as gloves, goggles etc.
- Close safety doors before starting the machine to avoid any accident.
- When the machine is running, it is forbidden to touch the sealing and machine accessory, or there will be injured.
- Never touch the heaters.
- Before the machine is running, make sure the safety equipment such as emergency stop is working so that the machine can be stopped in an emergency.
- Keys of electric box and control system must be kept by special authorized person who is familiar with the machine's control. Such keys must be unique.
- Check the cooling system, electric circuit, air passage and the working situation of each part before start the machine, seeing if there is any leak, dilapidation, rupture and some

other hidden trouble. If there is something abnormal, please ask professional person to check at once and make sure all hidden trouble is removed, then you can run the machine.

- When the machine is working, the operator must be on duty and other people can't approach the working area;
- When abnormality appear, such as abnormal noise, sudden halt and the cruddy is instability, must stop the machine immediately and check.
- When the machine is running, do not approach the machine's back area.
- If faults or irregularities occur while operating the machine, such as unusual noises, sudden shutdown etc., the machine must be immediately stopped and checked by the operating staff.
- Only operate the machine in accordance with these instructions and current operational health guidelines. This will prevent accidents and faults.
- Only carry out work that has been assigned to you.
- Keep the work space tidy, as messiness increases the risk of accidents.
- When the machine is cleaned the electricity and compressed air supply must be switched off.

2.5 Safety instructions for handling electrical equipment

- Switch off the machines before repair or maintenance work and before starting work check that there is no voltage.
- The connection of the machine to the external power supply, as well as work on and inside the electrical area of the machine should only be carried out by qualified electricians.
- Make sure that electrical cables to and in the machine cannot be damaged.
- Switch it off fully before starting repair or maintenance work.
- Modifications or alterations to the electrical safety devices are forbidden.
- Changes to the programming of the SPS are permitted only with written approval from BluePack Machines GmbH.

2.6 Possible hazards

Even if used properly, there is a possibility of hazards caused by the machine. To avoid dangerous situations, personal and material damage, the following lists residual risks that must be taken into consideration alongside the information given above.

2.6.1 **Electrical hazards**

There is risk of death due to electrical shock if any of the parts carrying live voltage are touched. Faulty or damaged insulation and damage to the electrical components could also cause fatality:

- All work on the electrical equipment of the machine must only be conducted by electricians.
- If the insulation is damaged, the machine must be immediately disconnected from the power supply and repairs carried out.
- The power must be switched off before any work is carried out on the electrical equipment of the machine.
- Keep the voltage carrying parts away from moisture.
- Never bypass or deactivate the safety equipment.

2.6.2 **Hazards from mechanical parts**

Mechanical parts can cause serious injury by their movement, such as crushing. Therefore:

- When operating the machine never open covers, reach into or fiddle with moving parts.
- Before opening covers it is essential to adhere to stopping times, i.e. to ensure that no parts are moving after the machine has been switched off.

2.6.3 **Stability**

If the machine has not been secured or is on an unsuitable surface it could cause the machine to move or tip over. This could result in injury or material damage. Therefore:

- Machines must be installed on a suitable load bearing surface.
- The machine should be secured against rolling away.

2.6.4 **Possible hazards from the filling material**

Hazards can occur from the filling material used, resulting from the chemical composition, temperature and other specific properties of the medium. Therefore:

- You must comply with the safety leaflet for the filling material and the instructions and information it contains.
- Persons handling the material must be sufficiently qualified and appropriate protective equipment must be available in accordance with the safety leaflet.

2.6.5 Explosion hazards

There is a risk of explosion if ignition sources, such as open flames, hot surfaces, sparks etc. are present in the explosion hazard areas. It is essential to:

- Comply with current explosion protection measures and to follow the specified operating instructions.
- Comply with specified maintenance intervals.
- Keep cigarettes or flames away from explosion hazard areas.
- Ensure that the machine is earthed when installing parts.

Electrostatic charge (friction from parts during operation) in a hazardous explosive atmosphere can cause serious injuries and death. All necessary measures must be taken to prevent electrostatic charge.

2.6.6 Hazards from flammable filling material

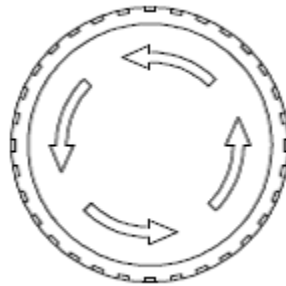
Flammable filling material presents a danger to life. It is essential to:

- Avoid igniting flammable filling material.
- Stop work immediately in the case of fire. Leave the hazardous area and call the fire service.
- Keep suitable fire extinguishers in the workplace.

2.7 Safety equipment

The machine has an emergency stop button, a main switch and is equipped with safety doors. The emergency stop button and the main switch are located at the user control pad.

2.7.1 Emergency Stop

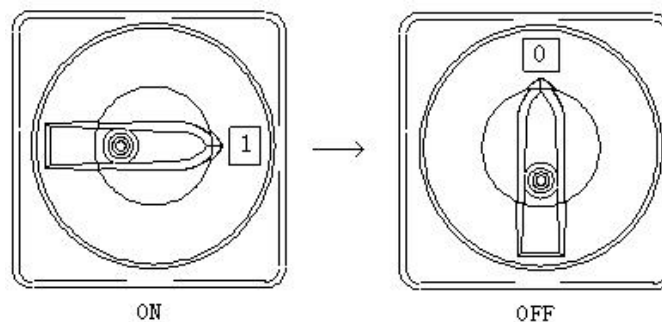


Emergency Stop Button

Pressing the emergency stop button immediately interrupts the power supply.

To turn the electricity supply back on, turn the emergency stop button in the direction of the arrow (unlock).

2.7.2 Switch off



Switch Off

To switch the machine's power off, turn the main switch anti-clockwise to position '0' or in 'OFF'.

2.7.3 Safety doors

When the machine is running and safety doors will open, electricity supply immediately interrupted.

2.8 Operator's obligations

The operator uses the machine for commercial purposes and is subject to legal obligations on occupational safety. The operator must comply with the specified safety information, as well as the current accident prevention, safety and environmental regulations relevant to the application area of the machine.

The operator:

- Must inform themselves of the occupational protection guidelines and identify hazards in a risk assessment. These result from the specific working conditions of the site where the machine is operated.
- Must implement the resulting measures in the form of operating instructions.
- Must check whether the operating instructions they have drafted correspond to the current status of guidelines and must adjust the instructions where necessary. This applies to the entire period in which the machine is used.
- Must inform themselves of hazards that could arise from the filling medium and only use qualified staff to handle the filling medium.
- Regulate and specify the responsibilities for maintenance, cleaning, fault rectification, installation and operation.
- Regularly check that all the safety equipment is complete and functioning.
- Ensure that the machine is always free from technical faults.
- Ensure that all staff who handle the machine have read and understood these instructions.
- Provide the necessary protective equipment for staff.

3 Technology

3.1 Comments

The vertical form fill and seal machine has been designed to make bags from reels of flexible materials (laminated materials, such as polyethylene + polyester, polyethylene + paper, polypropylene as well as simple polyethylene). The working principle is split in two main functions:

- Film unwinds and films tracking
- Sealing of the bags

The film unwind system is composed by two vacuum belts, working in contact with the forming tube, which pull and measure the length of the film. The sealing system is composed by a vertical sealing bar and two cross sealing bars, heated by means of cartridges; the temperatures are controlled by electronic thermo-regulators. The film pulling speed, the sealing time and the temperatures can be individually set and can be varied independently among one another

3.2 Structure and domination principle

This machine adopts touch screen to input parameter, combine with PLC and pneumatic function to control the machine. In the way of mechanical to make the seal system, drive by pneumatic to improve the speed and reduce the noise, use servo to carry film, respond to the high speed and quick positioning, apply for improve machine's working capability under rugged environment.

3.3 Factors influence machine's working

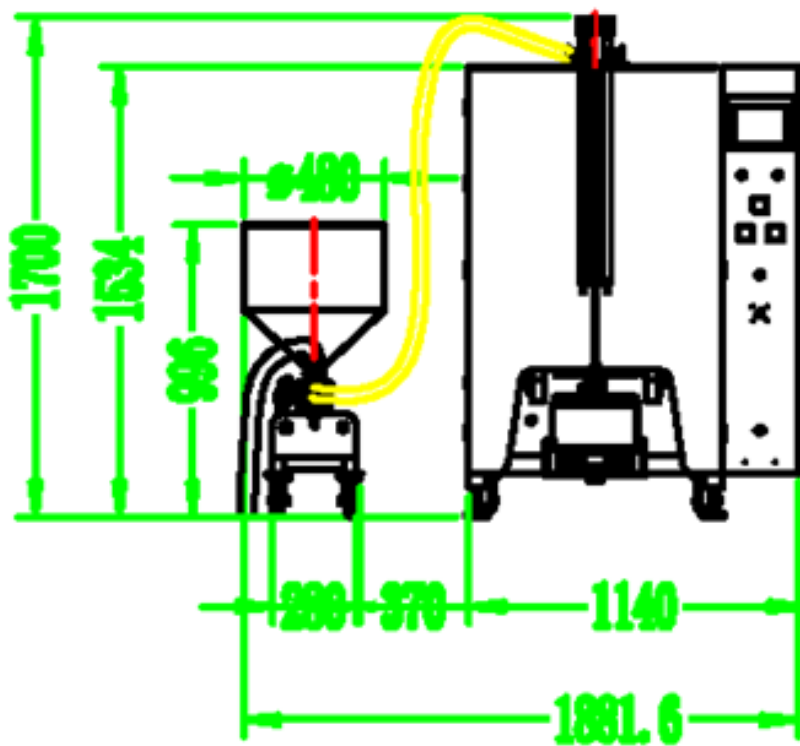
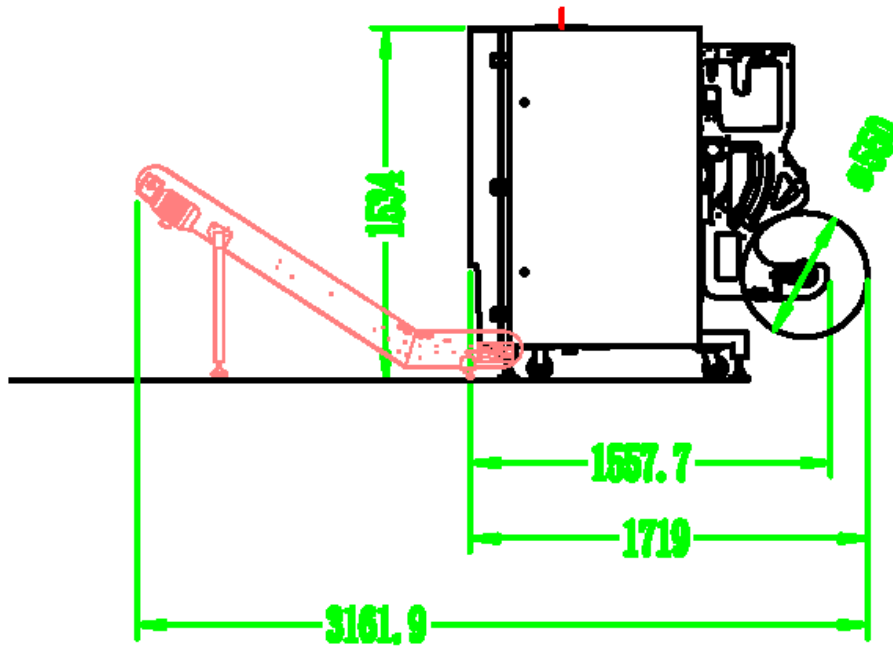
- (1) The seal knife joggle situation will affect the bagging seal quality.
- (2) Temperature will affect the bagging seal and appearance quality.
- (3) Packing film technological parameter will affect the bag's quality.

3.4 Specifications

Model	AMTEC VERTIwrap ECO-Complete VFFS Liquid/Pump L
Cycles per Minute*	90
Film thickness	0.04-0.12mm
Film width	100-520mm
Max. film roll diameter	customized
Bag width	Max. 250mm
Bag length	100-500mm
Filling range	300-3000ml
Capacity of storage hopper	50 Liter
Power supply	3P, 380 V, 50 Hz, 13kW
Air requests	0.4m ³ /min, 0.6-0.8Mpa
Outer Dimension	Approx. L3162xW1882xH1770mm
Weight of VFFS	480kg

* Note: It is the maximum speed of the machine in neutral. Actual packing speed depends on bag size, film material and the speed of joined filling equipment.

3.5 Layout



4 Installation, packing & transportation

4.1 Machine's packing

(1) Packing requirements:

Use special packing film and wood to packing the machine, annex such as built for purpose tools, spare parts and catalog should use paper box or wooden box to pack, the whole machine use plywood to pack.


(2) Packing notes:

Notice that each part of the electric components, equipment's precision and appearance cannot be damage during packing.

4.2 Transportation of the machine

(1) Safety of machine's transportation

- Transportation include the transit of machine, annex etc. The carrier must not less than 20KN, the height is not less than 3m.

 **Notice: Abide the crane, truck's working criterion**

(2) Notice on packing and transportation

 **Notice: Please take care the following proceeding to avoid accident, injure and electric shock.**

- When the machine is transporting, please use the right lifter to avoid hurt;
- The pile height of the packing boxes can be less than 2.3 meter;
- Avoid strenuous vibration, extrusion, drench and corrode of the chemistry goods

(3) Store

- Put the machine in dry and ventilated place, machines out of use for a long time should be
- cleaned and the moving part should add lubricating oil and fat.

4.3 Installation of the machine

(1) Preparation and check before installing:

- Set a safe area not less than 4000mm(length)x4000(width), and at the same time prepare a truck (not less than 2t), clean cloth, amortize gasket and wood. Warning sign must set up defense fence or countercheck in the installing area, prevent irrelevant people to come in.

- Unpacking and check: after the packing is open, first of all, check the machine's nameplate to confirm whether the model and product are match with the order form. At the same time, compare with the manual's limb, annex list and machine's whole drawing to check whether the machine is damaged during the transportation or missing any limb. After everything is all right,
- please sign and seal on the goods confirm form. The form will take back by our company man or our agent.

⚠️ Notice: We take responsibility for the parts of the machine which is offered from our company and have a clear indication, the other things not give a clear indication is derelict of our duty! (The other special requirement brings forward from customer about offering other annex must give a clear indication in supply agreement.)

⚠️ Notice: Please check the coherence about the machine and annex is the same as the document information before sign and seal. We are derelict of duty on the disaccord after the signing and sealing.

(2) Installing and store environmental condition:

The temperature should be 5°C~45°C (not freeze), relative humidity should be less than 85% RH, height above sea level should be ≤1000m. During the installing, considering that the magnetic field and electric field will cause some effect to the control system.

(3) Installed power: voltage rating 220V AC; single-phase; frequency: 50Hz.

(4) Safe working area: Length x width ≥ 4000mm×4000mm

(5) Install and adjust:

- Installing process:
- Move the machine to the working area, and put the machine on the flat concrete floor, use the gradient to adjust the base of every aspect and make it fix the level of the machine (special meter), it demands level error of the four angles ≤0.5mm. Take care that the machine's precision and appearance cannot be damaged during installing.
- Means of adjusting: Consult the machine's outside drawing, adjust the adjustable bolt, the way should be: loosen the adjustable bolt to install nut, then adjust every part to level and once more fasten.

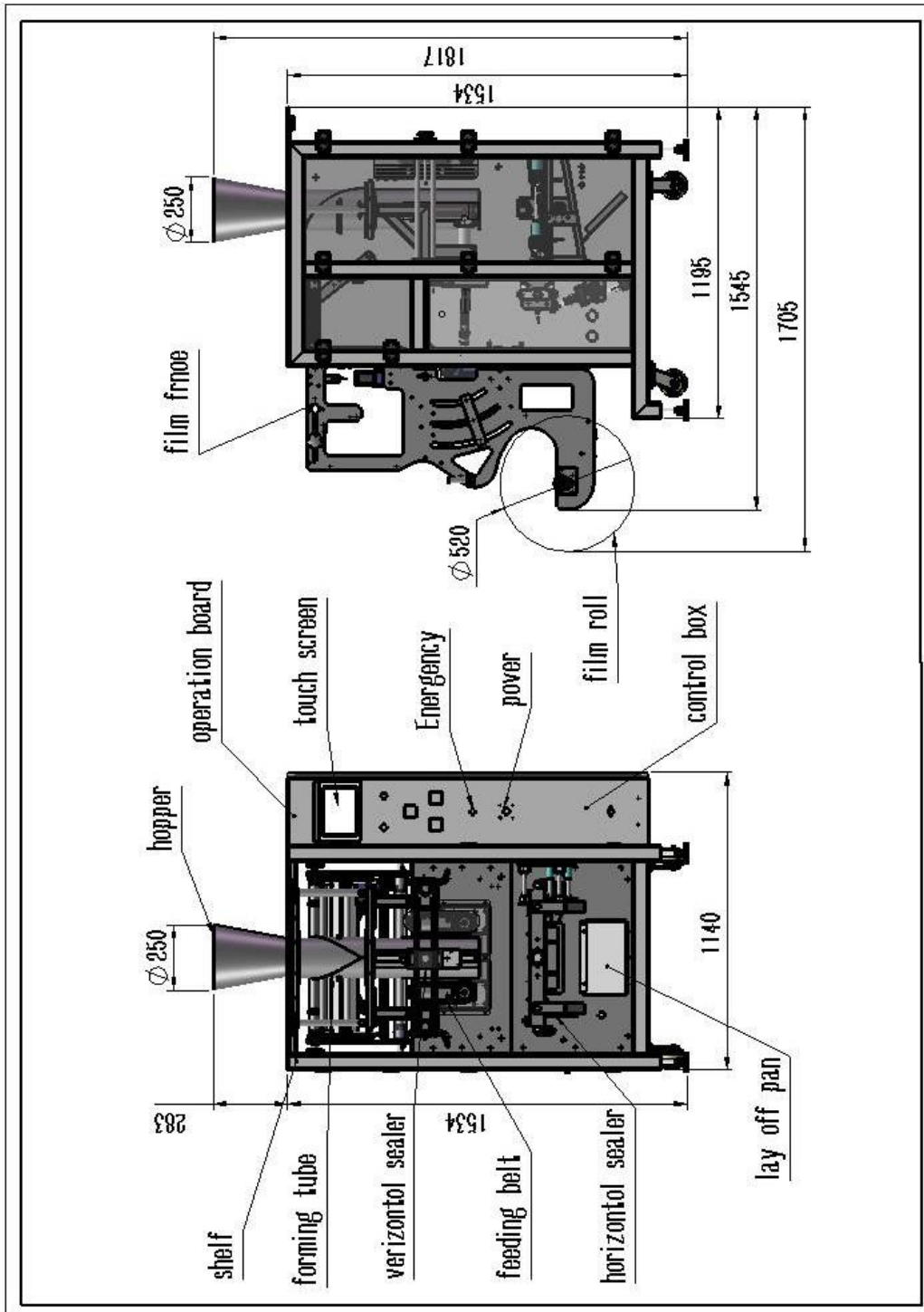
⚠️ Notice: Not allow to put the branch legs into the dust, it will have some limit to the machine's thermal expansion.

5 Machine description

There may be occasional deviations in sketches, pictures or illustrations of machine components. However, the functional principle remains unaffected.

5.1 Main components of VFFS

Deviation from the picture possible



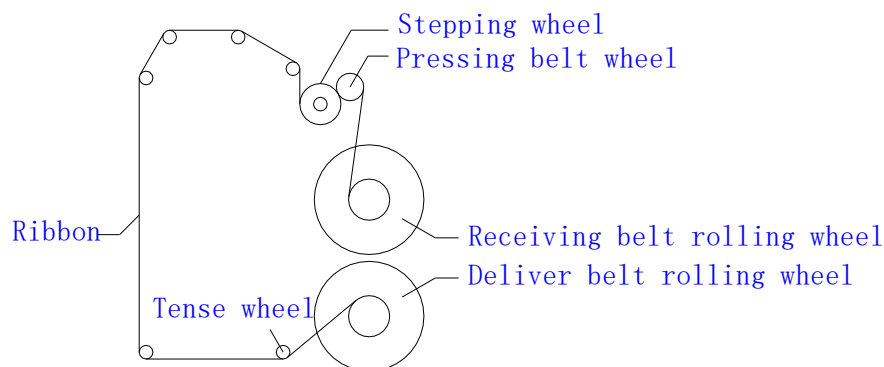
5.1.2 FORMER changing instruction:

- before changing the former, check that whether the new former going to set is bigger than the one now is using or not? If yes, first need to loosen the two setting bars to make more space for the new former.
- loosen the screw and then take out the former and install a new one.
- adjust the two setting bars to be a suitable place, to make the horizontal sealer keep about 3-4mm from the former.
- adjust the two long screws behind the former, to make it withstand the former but keep about 2mm to allow the film to go through.
- adjust the film, when the film on the former is left side wider than right side, you need to adjust the "CORRECT" to move right.

5.1.3 Printer

Function: use to print date of production, guarantee period, serial number etc.

Fixing ribbon: change the color belt in the same way like the empty color belt as the following:



Color belt diagram

Exchange the words:

Push the handle inside (about 1.5-2mm), turn the handle 90-180 at the same time, turn off the hook head, pull out the mould, make the mould's fixed screw loosen, replace the moving character, then the level of the installment should be the same. Remember not to knock the moving character with the metal bar, in order to prevent damage of it.

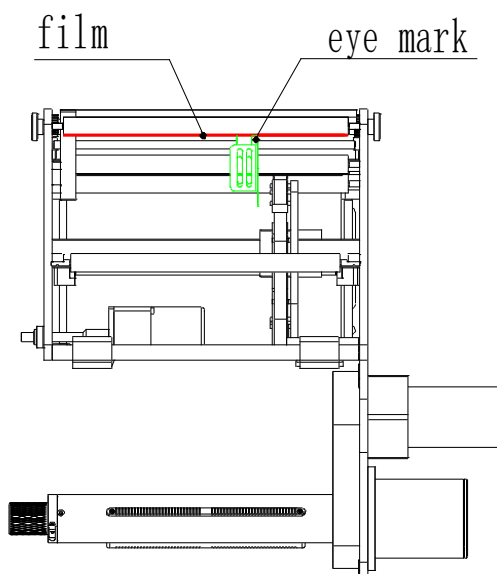
The adjustment of printing position:

Turn the side wheel, make sure the printing position, move the adjusting wheel front and back, make sure the vertical printing.

5.1.4 Photocell eye and sensitivity adjustment

Photo cell Sensor with integrated optics, semiconductor optoelectronics technology, modern technology, with high sensitivity, fast response, anti-interference ability of background light, compact, easy to use and so on. Control system in the packaging machinery as supporting the use of sensors and other instruments, on the color or other color patterns can be used as markers, lines or objects detection, automatic positioning, length, color defense, cutting, correction, On the version, and technology functions. Positioning for the length of the bag to determine the cut off position, because of the packaging film used by customers of our test machine with the packaging film may be inconsistent background, color detection sensor will not necessarily detect the color, then need to re-set Color sensitivity of the sensor.

- 1) Release the locking handle color sensors, mobile color sensors, the beam will be sent aligned background detected edge packaging films (light side) in the middle position, and fixed.



- 2) will align the measured surface spot darker (dark) color (usually color), the sensitivity knob clockwise to the bottom, and then adjust the sensitivity knob, so that light is just off the state, Remember this time under the knob position (set point A)
- 3) and then measured the surface of the spot aimed at lighter color (light) the color (usually the background), the sensitivity adjustment knob counter-clockwise, so that light is just off the state, remember that this time the position of the knob (Set B point)
- 4) and then the knob to the A, B between the center of the location. At this point the output of the sensitivity of the best. A, B the greater the distance between two points, indicating greater color detection more stable, but A, B at least two points from a grid, or testing will not be stable, may be appropriate to adjust the tilt sensor and measured surface.
- 5) color block detection: hand-pulling forward packaging film, so that the beam shines on the color block (black points), Office of photoelectric light will light up and change the top off, then set the normal optical tracking, packing bag length Must be set to (X +20 mm) or more.

6 Operating

6.1 Control Panel of the Piston Pump



Name	Function
Outlet Valve	Control wheel outlet throttle for cylinder
Inlet Valve	Control wheel inlet throttle for cylinder
Manual/Auto	Switch; Manual = not controlled by VFFS
Reset	To reset piston pump
Pressure Gauge	To monitor the pressure
Pressure Regulator	To control the pressure
Air Switch	Compressed air connection



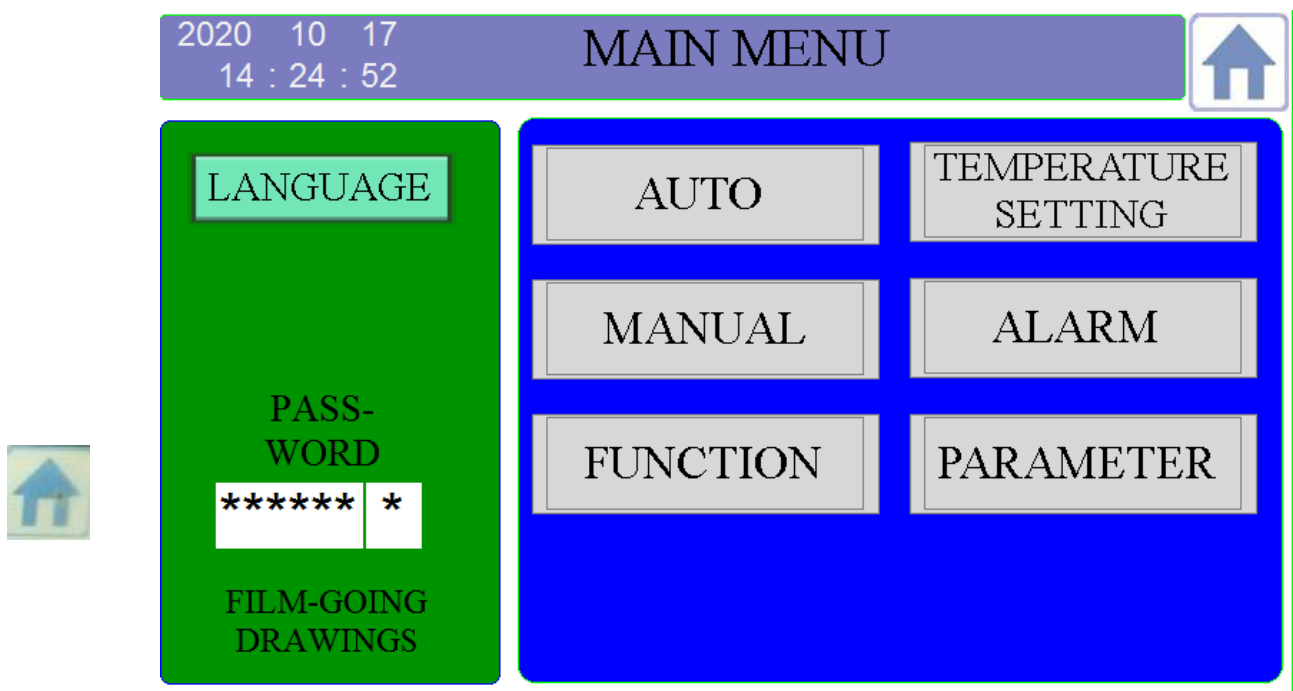
Setting the dosing volume by hand wheel.

6.2 Software

Notice: The touch screen is high sensitivity, please touch it lightly. Too much force may damage it. It is possible that some functions and parameters are not available (N.A.) in your version.

When connecting with electricity, packaging machine will display as following.

6.2.1 Main Menu



Please use that button to go back to main menu. It is located at every page right on the top.

The touch screen consists of eight functions as following.

LANGUAGE:

To set the language, 【ENGLISH】 / 【GERMAN】

LOGIN:

Login for different user levels. Each level has different write permissions.

Level 1: User has access to the pages “Options” and “Parameters”, where is to modify the data Password for level 123456,

level 3: the user has access to the page “Options” but just to choose signal feedback “ready” or “finished”. Password 111111

USER LOGOUT:

To logout from user level 3

AUTO:

Mode for production. There are start and stop buttons for 【FILL BAG】 and 【TESTING】 , hotkey for 【MAKE ONE BAG】 , display of 【PACKING SPEED】 and 【FILLING COUNTER】
【RESET】 .

MANUAL:

Mode to use functions manually for debugging, testing such as 【FILM PULL】
【MAKE ONE BAG】 【FILL ONE TIME】 【HORI. SEAL OPEN】 【HORI. SEAL CLOSE】
【CENTER SEAL】 【CUTTER】 【GAS FLUSH】 【FILM PUIL】 【FEEDING】
【GUSSET UNTREAD】

FUNCTION:

To able and disable functions such as 【EYE MARK】 【FILL AIR】 【GUSSET】 .
It is convenient for you to choose one or all that functions.

TEMPERATURE SETTING:

To set and monitor temperature of sealing jaws.

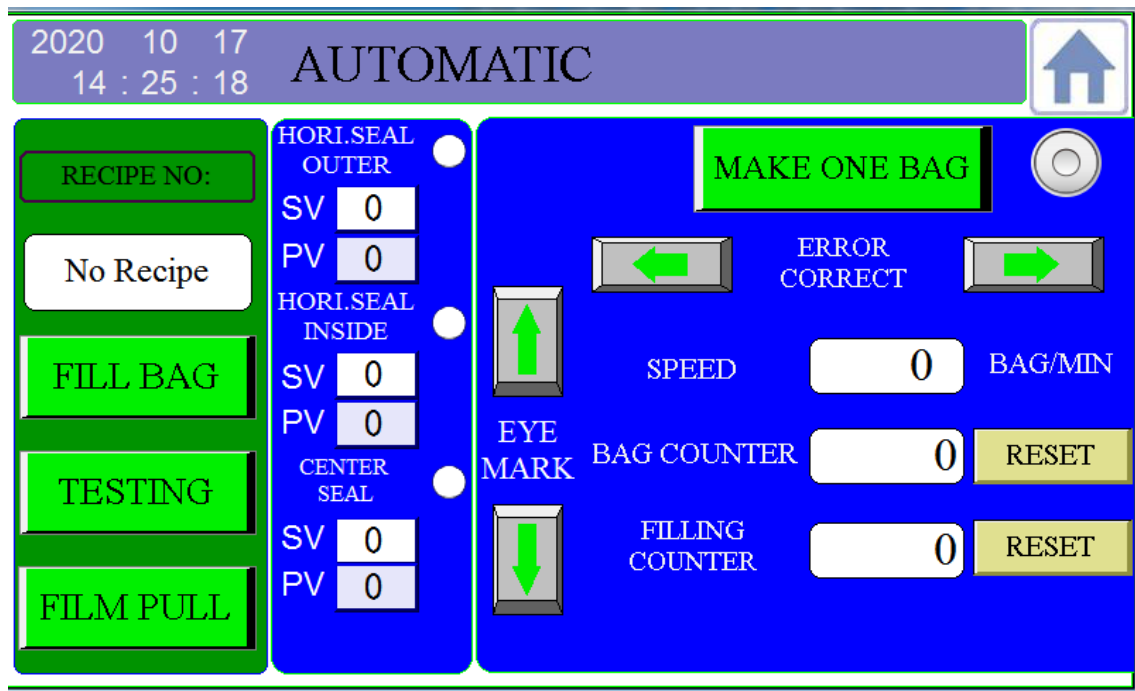
ALARM:

Displays error messages such as 【HORI. VERT. TEMPERATURE NORMAL】
【PRINT SYSTEM NORMAL】 【DELIVER SERVO SYSTEM NORMAL】
【FILM PULL SYSTEM NORMAL】 【STORE PRODUCT SYSTEM NORMAL】

PARAMETER:

To set parameters such as 【DELAY】 and 【TIME】 settings such as 【BAG LENGTH】
【SPEED】 【FILM PULL DELAY】 【SERVO FREQUENCY】 .

6.2.2 AUTOMATIC



RECIPE NO:

It is only used for displaying the current program number, and cannot be changed over here. Please go to the parameter setting page to switch program number to meet different demands.

FILL BAG

It is used with measuring system. When packaging machine is connecting with measuring system, press 【FILL BAG】 to start production. Y5 signal of PLC will keep outputting signal, and drive other feeding system to work together. Y7 signal will send signal at preset speed, and ask for feeding. With this function the machine will fill product continuously by adopting the principle of sending signal to each other. Press button again or Emergency switch to stop it.

Note: before execute this control instruction, it is necessary to push button

【FILM PULL】 otherwise the machine will not run.

TESTING

It is only used for testing the bag making. Press it to start and the packaging machine will make one empty bag at preset bag length, speed and other parameters. Press it again or emergency switch to stop it.

Note: before execute this control instruction, it is necessary to push button

【FILM PULL】 otherwise the machine will not run

FILM PULL

It used for making forming tube to clamp the pulling belt to make it pull film downward. Press once (Y12 signal) and pulling belt will move closer to forming tube to make it pull film. Press it again or emergency switch, pulling belt will depart from forming tube and stop working. Reset emergency switch, pulling belt system will move closer to the both sides of forming tube. That function needs to be executed before starting of production.

HORI SEAL OUTER

Temp. display horizontal sealing jaws:

PV: actual value

SV: Set value

HORI SEAL INNER

Temp. display horizontal sealing jaws:

PV: actual value

SV: Set value

CENTER SEAL

Temp. display vertical sealing jaws:

PV: actual value

SV: Set value

Error Correct ← →

It is used for correcting vertical sealing jaws. If the vertical sealing jaws are not matched the sealing position well, press left or right arrow to adjust.

EYE MARK ← →

It is used for correcting the cutting position, what the print marks serve as orientation points for.

SPEED

It is only for showing the actual packing speed of packaging machine or measuring system. It cannot be changed over here, please enter the parameter setting (1/3) page to change the speed.

BAG COUNTER

It shows the total number of packed bags from press 【FILL BAG】 till stop it. Press 【RESET】 to reset the number.

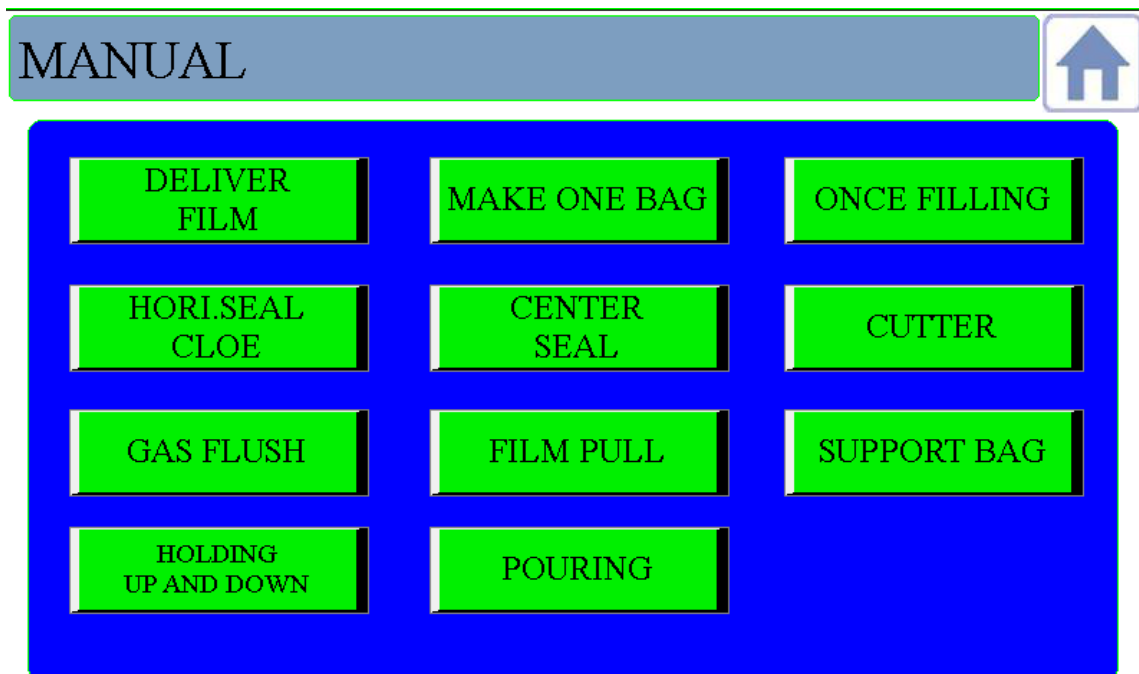
FILLING COUNTER

It shows the total number of packed bags from press 【TEST】 till stop it. Press 【RESET】 to reset the number.

6.2.3 MANUAL

The manual function is only used for testing. It is no necessary to open all above functions before using Automatic. Under the Automatic order, the machine will operate automatically and continuously.

Note: The screen shown below is the standard version. Some functions are not available.



FILM PULL / DELIVER FILM

Press it, PLC sends Y0 signal to make servo driver pull film once at preset length or 20mm longer. At the same time, other functions don't work. Press the button again if necessary.

MAKE ONE BAG

It makes one empty bag at preset parameters when press **【MAKE ONE BAG】**. Press the button again if necessary.

FILL ONE TIME / ONCE FILLING

Press **【FILL ONE TIME】**, PLC sends Y1 signal to measuring system to fill product once at preset parameter. At the same time, other functions don't work. Press the button again if necessary.

HORI SEAL CLOSE

It is used for closing horizontal sealing jaws. When the machine is in stand-by condition, press **【HORI. SEAL CLOSE】**, PLC sends Y1 signal to drive electromagnetic valve and cylinder, making horizontal sealing jaws close. When press **【HORI. SEAL OPEN】** or emergency switch, horizontal sealing jaws will open. Other functions don't work.

CENTER SEAL

It is used for opening or closing vertical sealing jaws. When the machine is in stand-by condition, vertical sealing jaws are open. Press **【CENTER SEAL】**, PLC sends Y2 signal to drive electromagnetic valve and cylinder, making vertical sealing jaws be closed. By pressing button again or emergency switch sealing jaws open. Other functions don't work.

CUTTER

It is used for outstretching or withdrawing the cutter. When the machine is in stand-by condition, cutter withdraws. Press **【CUTTER】**, PLC sends Y6 and Y15 signal to drive electromagnetic valve and cylinder, making cutter outstretch. When press it again or emergency switch, cutter will withdraw. Other functions don't work.

GAS FLUSH

It is used for opening or closing charging valve. When the machine is in stand-by condition, charging valve is close. Press **【GAS FLUSH CLOSE】**, PLC sends Y7 signal to drive electromagnetic valve and cylinder, making charging valve discharge.

Press button again or emergency switch, charging valve will close. Other functions don't work.

FILM PULL

It is used for stopping or starting the film pull motor – no pulling of film. When the machine is in stand-by condition, film pull motor stops. Press **【FILM PULL】** , PLC send Y13 signal to drive solid state relay and motor, making film pull motor start to work. Press the button again or emergency switch to stop it. Other functions don't work.

SUPPORT BAG

Bag tipping.

HOLDING UP AND DOWN

Hold of the bottom of the bag.

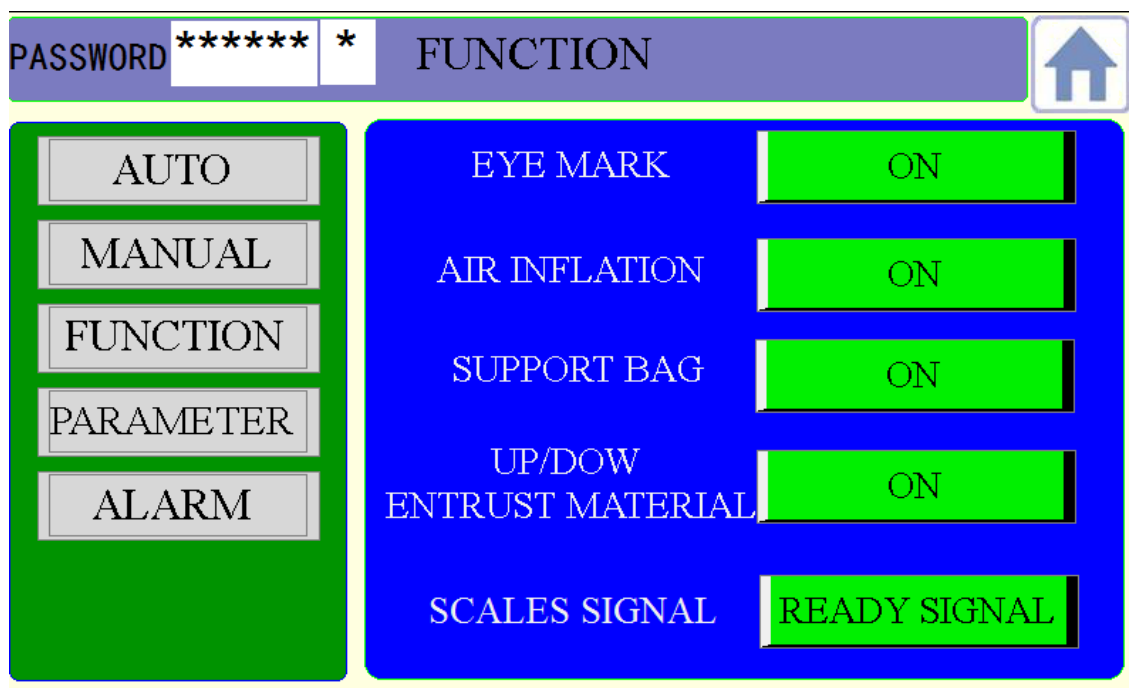
POURING

Shake the bag so that the product is better dispersed.

6.2.4 FUNCTION

【FUNCTION】 , it enters next page. There are start and stop buttons for 【EYE MARK】 , 【 FILL AIR】 , 【GUSSET】 . Please 【SAVE】 to save the data after switched. So that user can choose package multiple or single package freely.

Note: The screen shown below is the standard version. Some functions are not available.



EYE MARK

It is used for tracking photocell on the film to identify bag length (specific bag length is related to the design of the using film). Press 【OFF】 , it turns to 【ON】 condition, the machine will operate under the order of tracking bag length. Please reference to 【PARAMETER】 (1/3) to know how to set bag length. Press 【ON】 , it turns to 【OFF】 condition, the machine will operate at preset bag length under the order of fixed bag length.

GAS FLUSH / AIR INFLATION

It applies to fill air or nitrogen into bag for breakage-proof or preserving freshness. Press 【OFF】 , it turns to 【ON】 condition, the machine will fill air or nitrogen into bag automatically. Please reference to 【PARAMETER】 (2/3) to know how to set parameter of flush delay. Be sure that there is enough air or nitrogen. Please adjust the throttle valves to meet different saturations. Press 【ON】 , it turns to 【OFF】 condition, in this case the packaged bag is filled with natural air.

SUPPORT BAG

Hold of the bottom of the bag.

UP/DOW ENTRUST MATERIAL

Hold of the bottom of the bag.

SCALES SIGNAL

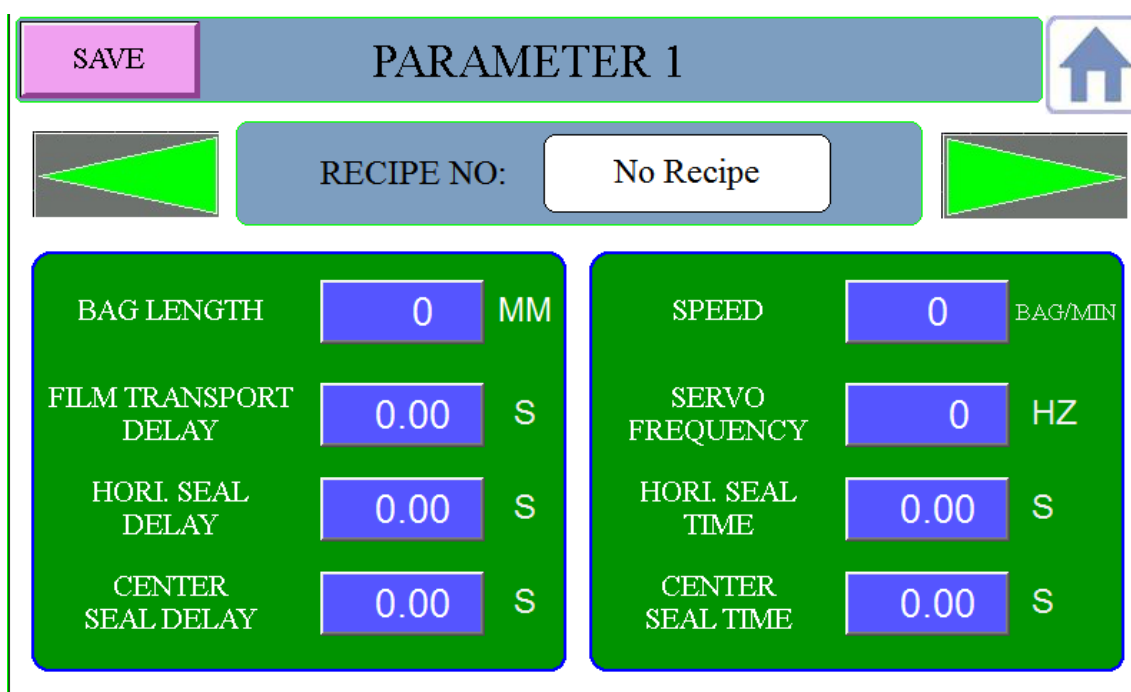
Turn ON and OFF of receiving signal from external dosing unit.

6.2.5 PARAMETER (1/3)

Press **【PARAMETER】** , it enters next page

There are 3 pages in total for **【PARAMETER】** .

Note: The screen shown below is the standard version. Some functions are not available.



Attention: Press the button lightly, it will pop up a number keyboard. After inputting the parameter, press **【ENT】** to confirm, **【CE】** to eliminate, **【ES】** to quit. Press **【SAVE】** to save data.

RECIPE NO.:

It is used for storing different packaging specifications. Different products require different parameters. All programs are preset at ZERO before ex-factory. As long as the Recipe NO.: is set up, you can switch functions through pressing the Recipe NO.: directly.

Range :(1-8)

BAG LENGTH (mm)

It is used for setting bag length under two patterns, fixed bag length and tracking bag length. Under the order of fixed bag length, it is advised to set the parameter as X-20mm. For example, if bag length is 200mm, then parameter should be set at 200-20=180mm. We change parameter of servo motor driver before ex-factory in case of slipping, which will cause about 20mm longer than preset. Please set 20mm shorter or else according actual situation until it is acceptable. Under the order of tracking bag length, the parameter should be set as X+20mm. For example, if distance between two color codes is 200mm, the bag length should be set at 200+20mm or more. The function is used for tracking eye mark.

Range: (10-500) mm Recommend: (50-200)mm

SPEED

It is used for setting package speed. When testing, the machine will work at preset speed. When filling package with measuring system, the package speed is subject to the actual combinative speed.

Range: (1-99) bags/min Recommend: (10-55) bags/min

FILM TRANSPORT DELAY

It is used for preventing crashing product. The higher you set the lower packaging speed.

Range (0.00-9.99) S Recommend: (0.00-0.10) S

SERVO FREQUENCY

It is used for controlling the speed of servo motor to prevent crashing product. The smaller you set the slower it runs. However, the high setting value may cause belt slipping.

Range: (2500-10000) HZ Recommend: (3500-6500) HZ

END SEAL DELAY / HORI SEAL DELAY

It is used for outputting horizontal sealing signal. You can set the parameter here to avoid crashing product, when with gusset device (optional device). The smaller you set the slower packaging speed.

Range :(0.00-9.99) S Recommend: 0.00 S

END SEAL TIME / HORI SEAL TIME

It is used for setting horizontal sealing time. You can reduce temperature to prolong sealing time or raise temperature to reduce sealing time to meet different demands.

Range: (0.00-9.99) S Recommend: (0.45-0.75) S

CENTER SEAL DELAY

It is used for outputting vertical sealing time signal. You can set parameter here to avoid folding in the vertical sealing place.

Range (0.00-9.99) S Recommend: (0.00-.150) S

CENTER SEAL TIME

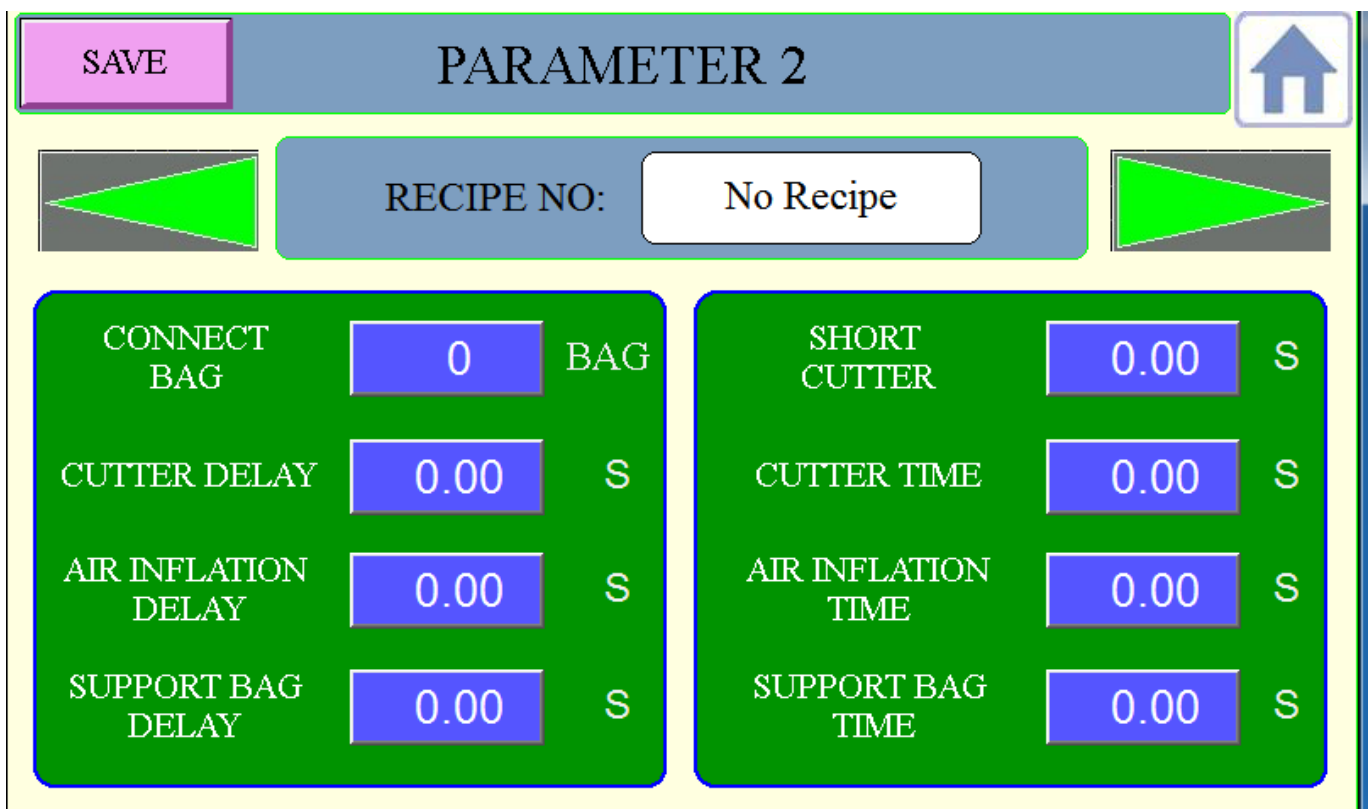
It is used for setting vertical sealing time. You can reduce temperature to prolong sealing time or raise temperature to reduce sealing time to meet different demands.

Range (0.00-9.99) S Recommend (0.45-0.75) S

6.2.6 PARAMETER (2/3)

Press **【NEXT】** ,it enters next page. There are **【STRIP BAG】** , **【SHORT CUTTER】** , **【CUTTER DELAY】** , **【CUTTING TIME】** ,etc.

Note: The screen shown below is the standard version. Some functions are not available.



RECIPE NO: It is used for storing different packaging specifications. Different products require different parameters. All programs are preset at ZERO before ex-factory. As long as the Recipe

NO: is set up, you can switch functions through pressing the Recipe NO: directly.

Range: (1-8)

TRIP BAG / CONNECT BAG

It is used for controlling package patterns, single bag or connect bags (optional device). When the setting value is "0", Y4 sends gusset signal, in this case setting value of gusset delay and gusset time is valid. When the setting value is "1", Y4 and Y6 sends cutting signal at the same time, setting value of connect bags and cutter delay as well as cutter time is valid.

When the value is preset above "2", Y6 sends connect signal, and Y4 sends cutting signal, the setting value of short cutter is valid.

Range: (0-99) bags

Recommend: (0, 1, 2-10).

SHORT CUTTER

It is used for setting short cutter. When the value is "0", the parameter is invalid. When the value is "1", Y4 and Y6 sends cutting single signal together, and the parameter is valid. When the value is set above "2", Y4 outputs cutting signal, the value is the time of short cutter.

Range: (0.00-9.99) S

Recommend: (0.20) S.

CUTTER DELAY

It is used for controlling the cutter. If it happens that the bag cannot be cut off, you can set parameter here. The best time to cut off is after horizontal sealing jaws closed.

Range: (0.00-9.99) S

Recommend: (0.40) S

CUTTING TIME

It is used for controlling the cutter. If it happens that the bag cannot be cut off during the procedure of packing single bag or connect bags, you can set parameter here.

Range: (0.00-9.99) S

Recommend: (0.20) S

AIR INFLATION DELAY

To set gas flushing delay.

AIR INFLATION TIME

To set duration time of gas flushing.

SUPPORT BAG DELAY

To set delay time of tipping the bag

SUPPORT BAG TIME

To set duration time of tipping the bag

6.2.7 PARAMETER (3/3)

Press **【NEXT】** , it goes to next page. There are, **【TIME OF FILM PULL ONCE】** **【VERT. SEAL LENGTH】** **【FILLING TIMES】** . Press **【PREVIOUS】** go back to the previous page.

Note: The screen shown below is the standard version. Some functions are not available.

PARAMETER 3	
SAVE	RECIPE NO: No Recipe
HOLDING UP AND DOWN TIME	0.00 S
BAG SUPPORTER HOLDING UP DOWN TIME	0.00 S
BAG SUPPORTER PUSHING DELAY	0.00 S
POURING TIME	0.00 S
CENTER SEAL LENGTH	0 MM
SIGNAL DELAY	0.00 S
FILLING	0 Order

HOLDING UP AND DOWN TIME

It is used for setting duration time of holding up and down action.

BAG SUPPORTER HOLDING UP DOWN TIME

It is used for setting delay time of bag support action.

BAG SUPPORTER PUSHING DELAY

It is used for setting delay time of bag support action.

POURING TIME

It is used for setting the duration time of pouring action

CENTER SEAL LENGTH

Just available for high speed version with continuous sealing

SIGNAL DELAY

It is used for setting delay time of filling action.

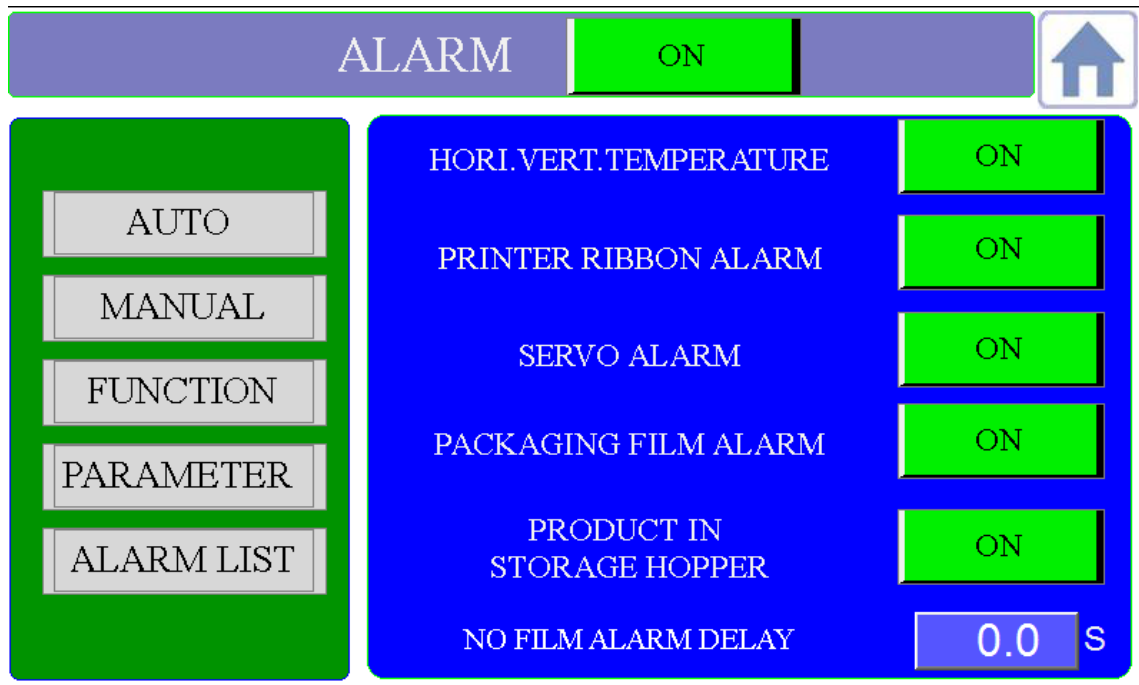
FILLING

It is used for setting the number of fillings per cycle.

6.2.8 ALARM

Press **【ALARM】** , it enters next page. There are a series of alarms, such as **【HORI. VERT. TEMPERATURE NORMAL】** **【PRINT RIBBON SYSTEM NORMAL】** **【DELIVER SERVO SYSTEM NORMAL】** **【FILM PULL SYSTEM NORMAL】** **【STORE PRODUCT SYSTEM NORMAL】** **【GLASS DOOR CLOSED COMPLETELY】** **【ELECTRIC DOOR CLOSED COMPLETELY】** **【EMERGENCY SWITCH REPLACEMENT STATE】** **【DELAY ALARM】** .

Note: The screen shown below is the standard version. Some functions are not available.



ALARM

It is the main switch of the following alarms, when it is **【OFF】** , all options below are invalid. When it is **【ON】** , all options below are valid.

HORI. VERT. TEMPERATURE NORMAL

When it is **【ON】** , when the temperature of horizontal seal jaws and vertical seal jaws is lower than preset, please press **【FILL BAG】** or **【TESTING】** , it will go to another page and showing **【CHECK HORI.VERT. TEMPERATURE】** . Press any key to quit, and wait until temperature raise up to preset temperature. When it is **【OFF】** , the function is invalid.

PRINT RIBBON SYSTEM NORMAL

When it is **【ON】** , when print ribbon is run out, please press **【FILL BAG】** or **【TESTING】** , it will go to another page showing **【PRINT RIBBON IS RUN OUT】** . Press any key to quit, and replace with new print ribbon. When it is **【OFF】** , the function is invalid.

DELIVER SERVO SYSTEM NORMAL / SERVO ALARM

When it is **【ON】** , when servo system is out of order, please press **【FILL BAG】** or **【TESTING】** , it will go to another page showing **【CHECKING SERVO SYSTEM CODE】** . Press any key to quit after resolving the error. When it is **【OFF】** , the function is invalid.

FILM PULL SYSTEM NORMAL

When it is **【ON】** , when packaging film is run out, please press **【FILL BAG】** or **【TESTING】** , it will go to another page showing **【FILM ROLL RUN OUT】** . Press, any key to quit, and replace with new one. When it is **【OFF】** , the function is invalid.

STORE PRODUCT SYSTEM NORMAL / PRODUCT INSTORAGE HOPPER

When it is **【ON】** , if it detects that the product in the store is not enough, please press **【FILL BAG】** or **【TESTING】** , it will go to another page showing **【PRODUCT RUN OUT】** . Press any key to quit, and after filling product in store, the machine will work normally. When it is **【OFF】** , the function is invalid.

GLASS DOOR COLSED COMPLETELY

When press **【FILL BAG】** or **【TESTING】** , if the glass door is not close completely, it will go to another page showing **【CLOSE THE GLASS DOOR PLEASE】** . Press any key to quit, and close the glass door, the machine will work normally.

ELECTRIC DOOR CLOSED COMPLETELY

When press **【FILL BAG】** or **【TESTING】** , if the electric door is not close completely, it will go to another page showing **【CLOSE THE ELECTRIC DOOR PLEASE】** . Press any key to quit, and close the glass door, the machine will work normally.

EMERGENCY SWITCH REPLACEMENT STATE


When press **【FILL BAG】** or **【TESTING】** , if emergency switch is locked, it will go to another page showing **【RESET EMERGENCY SWITCH PLEASE】** . Press any key to quit, and reset emergency switch.

NO DETECTING EYE MARK SIGNAL

If it has not yet detected any photocell signal after film pull signal finishing quantitative pulse, please press **【FILL BAG】** or **【TEST】** , it will enter another page showing **【NO DETECTING EYE MARK SIGNAL】** . Press any key to quit. The machine will operate after the photocell signal is positioned.

6.2.9 TEMP SETTING

Menu for setting and monitoring of temperature of each sealing jaw.

TEMPERATURE SETING 				
	HORI.SEAL OUTER	HORI.SEAL INSIDE	CENTER SEAL	SPARE
Bit value				
Selection	OFF	OFF	OFF	OFF
Set value	0	0	0	0
Upper deviation	0	0	0	0
Lower deviation	0	0	0	0
Measurements	0	0	0	0
Heating	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>
Alarm	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>	<input type="radio"/>

6.3 Production mode

6.3.1 Starting the machine

The following procedure is for orientation only. Adapt the sequence or sequence to your situation if necessary.

- Check that the safety doors are closed. Close the safety doors if necessary.
- Switch on the compressed air supply.
- If necessary, unlock the EMERGENCY STOP button by turning it in the direction of the arrow.
- Set the main switch to position "I" or "ON" to switch on the machine
- Then load a program or set the parameters or use current parameters according to your requirements
- Wait until the heaters have reached the target temperature for sealing (approx. 10 min.).
- Enter menu "AUTO"
- Push button **【FILM PULL】** , **Note: it is necessary to execute, otherwise the machine will not run**
- Make some test runs via pushing button **【TESTING】** , if everything is fine you start with series production by pushing button **【FILL BAG】**

Note: The machine has an emergency stop device. If an abnormal machine condition occurs or in case of danger, press the EMERGENCY STOP button. The power and compressed air supply will be cut off immediately and the machine will stop immediately. The alarm indicator will start flashing until the fault has been rectified and the EMERGENCY STOP button is unlocked.

6.3.2 Stop production and switching off the machine

- Production can be stopped normally in two ways. Either the specified quantity is reached, or you press the button **【FILL BAG】** while the machine is running.
- After stopping the machine wait until the heaters have cooled down.
- Then switch off the machine by turning the main switch to position "0" or "OFF". The is disconnect from the mains.
- If necessary, close the compressed air supply.

WARNING! Open the compressed air supply again before starting the machine!

General note: If the compressed air supply is cut off, watch out for the cutting area and welding area, it could suddenly move.

6.4 The safety check of debugging

- a) Check whether all the snails are fastened, whether adding lubricating oil, whether the electric power is correct.
- b) Check whether the air supplier has connected to the entrance of triplet microtubules.

6.4.1 The process and description of debugging

- a) Mount the film roll, frap the film roll, cut the film end to triangularity and put the film through each roller, then insert it into the former.
- b) Close the door, of electricity box and the defend door, turn on the electric power, set the end seal temperature controller on 100°C-180°C, vertical end seal temperature controller on 90°C-160°C (The temperature is decided by the thickness of film and material.)
- c) When temperature reach the set point, make vertical and end seal action by manual drive to make certain whether the temperature is suitable, and set precedence relationship on time.
- d) Input parameter, adjust the length of the bag and color mark, test every function and try to run the machine by making bags continually.
- e) After making bags continually at good state, it can be connected with the weigher and try to produce.

6.4.2 Safety of debugging

- a) During debugging, do not put hands to the sealing jaw.
- b) The testing man should wear heat protective gloves when testing the sealing roller, in order to prevent getting burnt.
- c) When pulling belt is moving, do not touch by hands.
- d) Judgement of the testing: whether has abnormal noise, whether the pulling film belt is fit according to the former, whether the bag is symmetry by both sides.

7 Heat Printer

7.1 Heater printer ribbon

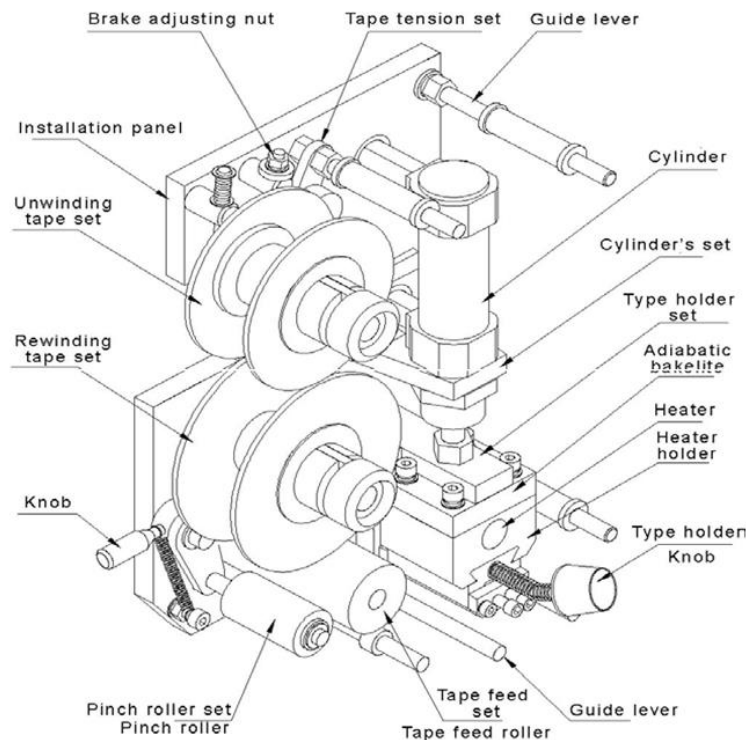
The machine uses heater printer ribbon, and the standard ribbon's inner diameter is 1 inch, Max width is 35mm, Length is 100m. The width and color is according to your requirement

7.2 Parameter

- 1) Speed: Max 150times/min (Controlled by host)
- 2) Print area: Single row max $4*35\text{mm}^2$. It can put 15 characters on printer.
- 3) Print area: Double row max $10*35\text{mm}^2$. It can put 30 characters on printer
- 4) Number, English, Chinese can be accepted.
- 5) Ribbon max width: 35mm
- 6) Power supply: Single phase 220V, 50 Hz.
- 7) Dimension: 225mm*165mm*152mm
- 8) Weight: 3.5kg

7.3 Structure

Printer structure is shown in picture below. Printer head will move up and down at preset speed when it is working. Notice: Do not touch the printer head in case of scalding.

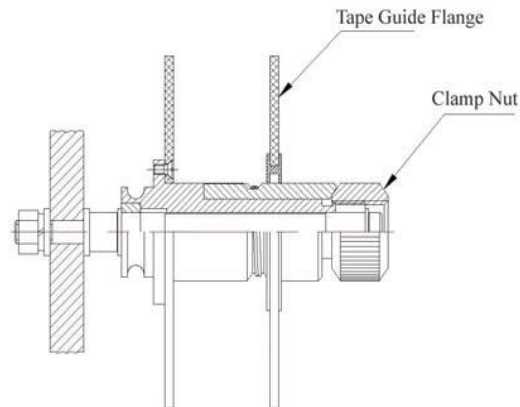


7.4 Installation

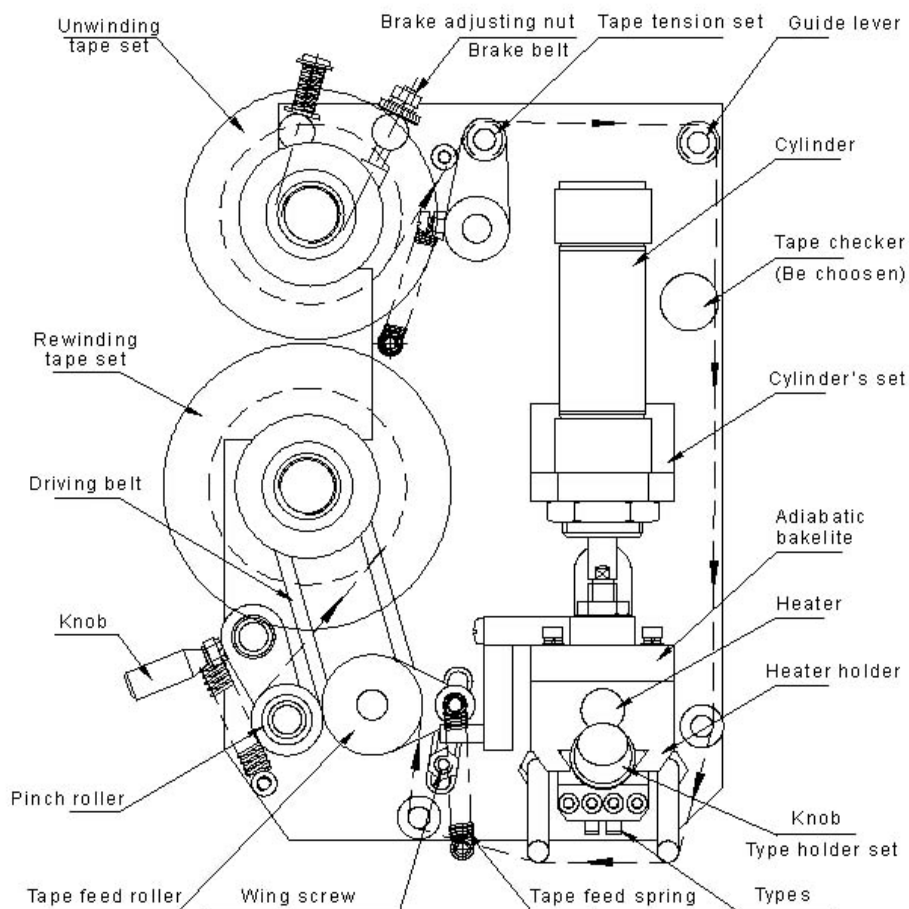
1) Install ribbon

First, loosen the nut on ribbon axis (Do not have to take off the nut), and take off plexiglass. Secondly, input the heater ribbon, and put back the baffle (the baffle should close to the ribbon side). And finally, fix ribbon according to instructed direction.

Loosen nut on axis, and take off the movable baffle, then input the empty tube, on which stick a bit ribbon according to the instructed direction. And then put back the movable baffle, and finally tighten the nut.

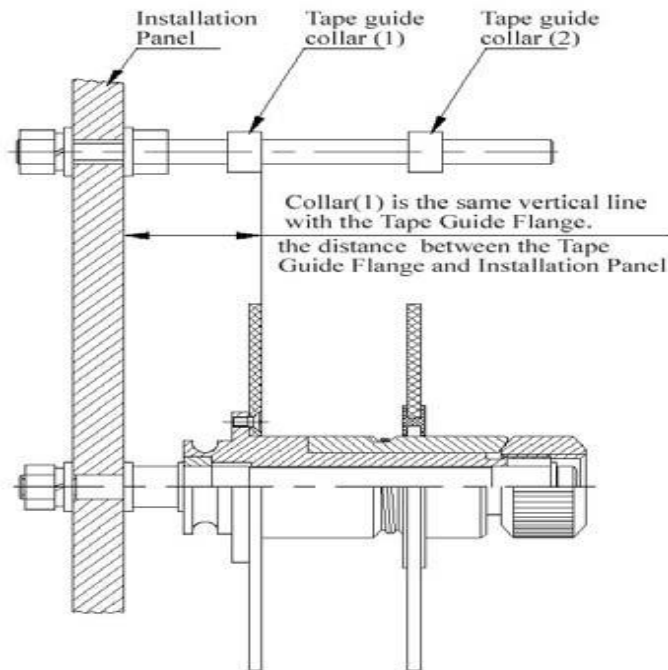


Attention: The ink (rough) side of the ribbon should toward the material which is to be printed



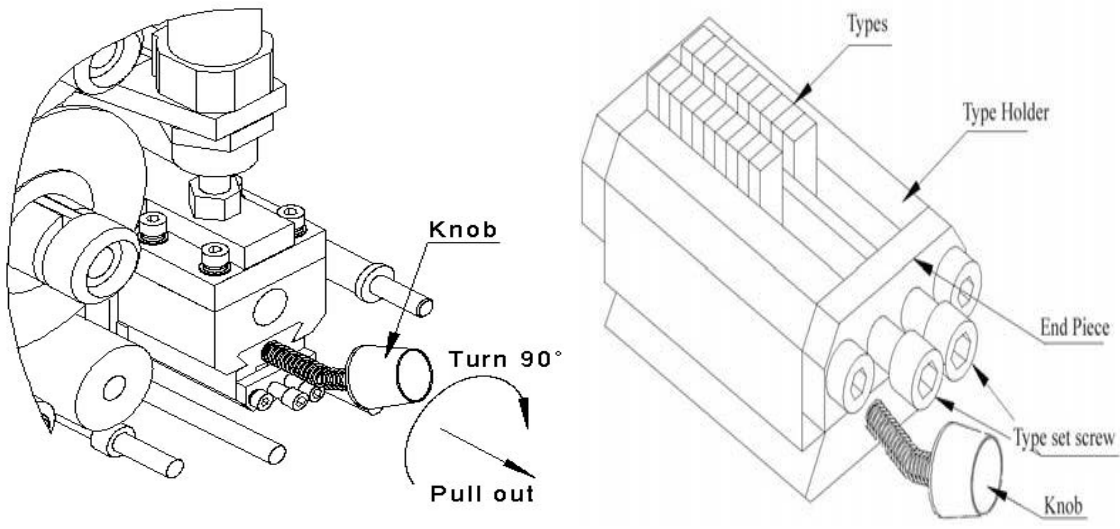
2) Adjust ribbon width

Adjust the location of external circlip plier, and let internal circlip plier stay. AS shown in Picture (3). Make sure the alignment between internal plier and fixed baffle (lay the plexiglass). Adjust the external plier to keep the distance between the both baffles at 1mm wider than ribbon width.



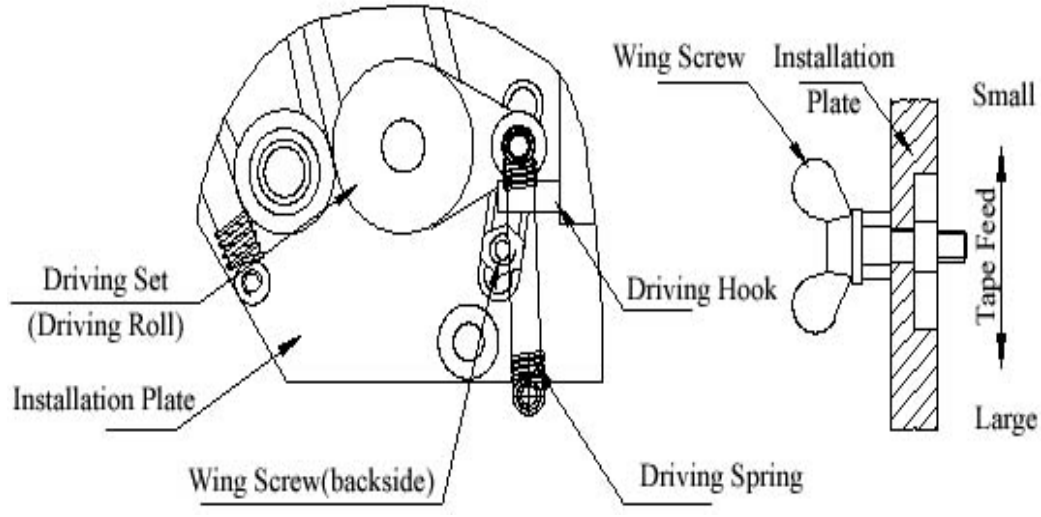
3) Code number replacement

Push inward the handle on printer lightly (1.5~2mm) and rotate 90° at the same time, and then take off printer head. Shown in following picture. Lay the code number flatly on the workbench. Loosen the nut on the printer head, now you can replace or uninstall number code. Using alcohol to clean the dust and using copper brush to clean the ink. Make sure those number codes are keep alignment and clean, do not knock them with metal. Then tighten the nut, install the printer head as the inverse installation, push the handle inward lightly (1.5~2mm).



4) Ribbon step value adjustment.

As shown in picture below, with the lowering of the printer head, the step gear will turn back to its position under the action of step spring. Adjust ribbon step valve through the butterfly-shaped nut which is at the back of the host. Move it up and down to change the vibration of the step gear. For the purpose of saving ribbon, it is advised to keep the distance between the two code numbers at 1mm. Finally, tighten the butterfly-shaped nut after adjustment.



8 Maintenance and cleaning

Note! Maintenance and cleaning must only be carried out when the machine is switched off. There is a high risk of injury! All maintenance and cleaning must only be carried out by trained personnel.

8.1 Maintenance and lubrication

Every machine must be checked at regular intervals to see that it is functioning properly, to identify any defects and immediately rectify them and to identify defects developing. Regular maintenance of the machine ensures that the machine has a long and problem-free lifespan with low maintenance costs.

Check regularly:

- the fixing screws of the sealing bars
- no screws have come loose
- all safety devices (EMERGENCY STOP, interlock switches, etc.) are working.
- whether the air pressure is normal
- rubber suction cups on wear
- the Teflon tape on the sealing jaws wears off and must be changed regularly.
- filter of the vacuum pump on cleanliness
- function of the vacuum unit

8.1.1 Replacement of the pulling belt:

If pulling belt is slipping or damaged. Please replace with the new one. Firstly, remove the external covering, loosen the M12 screw and rotate M6 nut, let the axis of drive wheel move down, take off the pulling belt, and replace with the new one, finally fasten the screw.

Attention: Don't adjust the pulling belt too tight or too loose.

8.1.2 Replacement of the cutter:

Loosen 2pcs M5 nuts, and take off old cutter. Attention not to be scalded if the vertical jaws are heating. And replace with the new one. Make sure to keep alignment of the two cutters.

8.1.3 Ribbon:

When ribbon is run out, remove the old ribbon from printer, and replace with new one.
(Reference to Printer Manual)

Should the condition of components make it necessary to replace them, please use only original spare parts to ensure proper and faultless operation of your system.

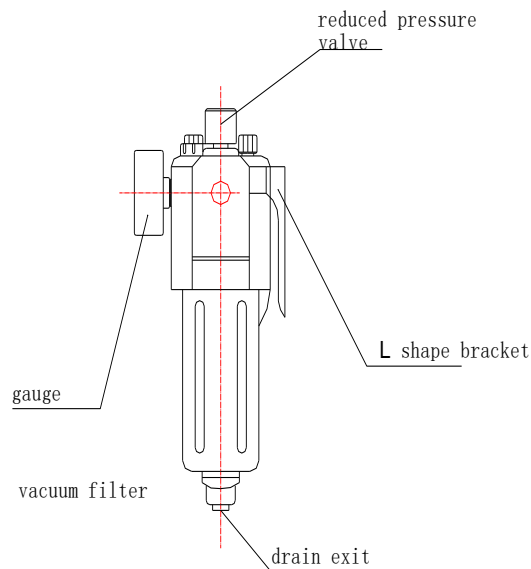
8.1.4 Lubricating the machine

Most of the rolling bearings of the plant are encapsulated and do not require any maintenance. Check the oil level once a week to ensure that it is over 1/3. If it is below 1/3, add 20# of pure engine oil until it is above 1/3.

Note: The lubrication intervals depend on the average load and use of the system. The lubrication requirement may change due to use, humidity, dust, environmental conditions, etc. and must then be adjusted accordingly.

8.1.5 Compressed air control unit

- If the liquid container is 2/3 full, it must be emptied. To do this, push the emptying nozzle downwards and let the liquid run out.



8.2 Cleaning

General guidelines: if the machine is used in the food sector, relevant hygiene regulations must be observed. This also applies to the cleaning materials used. Non-compliance can lead to contamination of the product and injury and health damage among consumers. Before cleaning the machine, cut off the power supply to the machine so as to ensure the safety of people and the machine.

Clean all components that come into contact with the product daily after the work is finished or when changing product - during long breaks or before renewed use. Also, regularly clean dust and dirt from the machine, including the control panel and switch box.

Carefully remove impurities from the sealing bars with a copper wire brush. The Teflon tape must be removed first.

Clean the photo sensors regularly.

Keep dust and moisture away from electrical components.

Clean the outside of the machine with a cotton cloth and a little water if necessary.

Clean the filters of the pressure and vacuum system regularly.

Each time before using the machine check for and clean away any remnants from previous use.

If the machine will not be used for a longer period of time, disconnect the power supply and clean the machine thoroughly.

9 Troubleshooting

Fault	Reason	Treatment
circuit-breaker tripping	<ol style="list-style-type: none"> 1. Insulated cable is damaged and contacts with frame of machine. 2. Horizontal and vertical seal heating system uses the 220V power. 	<ol style="list-style-type: none"> 1. Check the cable and replace the warn one. 2. Replace with new sealing heater, and check other electric components.
No display in touch screen.	<ol style="list-style-type: none"> 1. No output from 24V DC power transformer. 2. Fuse of touch screen is burn out. 	<ol style="list-style-type: none"> 1. Check the fuse or replace power transformer of machine. 2. Replace the fuse of touch screen or touch screen itself.
Vertical or horizontal sealing heater without heating.	<ol style="list-style-type: none"> 1. Circuit-breaker tripped. 2. Sealing heater is damaged. 3. Solid state relay is damaged. 4. Cable or thermocouple is in open circuit. 5. Thermostat is damaged 	<ol style="list-style-type: none"> 1. Check the circuits to exclude short-circuit, turn on the switch. 2. Replace sealing heater. 3. Replace solid state relay. 4. Replace cable or thermocouple. 5. Replace thermostat.
When working, the Temperature is unstable. When off, it is normal.	<p>The circuit is in mid-open circuit from solid state relay to sealing heater, When working, the cable of vertical sealing and horizontal sealing heater is bent down, the cable will be damaged after a long time in such a situation. But when machine is off, the cable is connectable. When it is working, the cable is disconnecting.</p>	<p>Replace cable that connecting sealing with heater solid state relay.</p>

<p>Sealing effect is not good, or even exist air leakage.</p>	<ol style="list-style-type: none"> 1. Temperature of sealing jaws it too low. 2. Time of sealing is too short. 3. There are some other things in sealing jaws. 4. The two sealing jaws match not well. 5. Air pressure is too low. 6. Film quality is not good. 	<ol style="list-style-type: none"> 1. Increase temperature of vertical or horizontal sealing jaws. 2. Extend sealing time. 3. Clean sealing jaws by copper brush. 4. Adjust two sealing jaws to make them connect with each other tightly. 5. Increase air pressure. Above 6KG pressure is better. 6. Replace film.
<p>Deviation of bag length is too high.</p>	<ol style="list-style-type: none"> 1. Pulling belt does not run enough. 2. The setting bag length is shorter than the distance between the two colors code on the film. 3. Sensitivity of photocell eye is not set correctly. 4. There is stain or pattern in the color code. 5. The laminated board under photocell eye is damaged so that it cannot detect the color code correctly. 6. Eye mark and ray shifts during the operation of eye mark. 	<ol style="list-style-type: none"> 1. Switch off tracking function of photocell eye. Make 5 empty bags continuously to check bag length (Longer than 10MM). Clean the pulling belt until it is normal. 2. If distance between two color codes is X, set the bag length parameter as X+50mm. 3. Reference to photocell eye adjustment manual. 4. Replace the film. 5. Adjust the laminated board to keep the distance as it can just pass a piece of film. 6. Adjust the location of photocell eye and color code.
<p>The film cannot be cut off.</p>	<ol style="list-style-type: none"> 1. Cutter is damaged. 2. The two sealing jaws are not matched well. 3. Cutter delay and cutting time don't match well 	<ol style="list-style-type: none"> 1. Sharpen the cutter or replace with a new one. 2. Adjust symmetry of the sealing jaws; let the cutter fit the groove properly. 3. Reset the parameter of cutter delay and cutting time.
<p>Gear motor doesn't run or it keeps running when it is on.</p>	<ol style="list-style-type: none"> 1. Capacitor for starting gear motor is damaged. 2. Solid state relay or intermediate relay of controlling gear motor is damaged. 3. Gear motor is damaged. 	<ol style="list-style-type: none"> 1. Replace capacitor of same model. 2. Replace solid state relay or intermediate relay. 3. Replace gear motor.

<p>Pulling belt and bucket conveyor doesn't work.</p>	<ol style="list-style-type: none"> 1. Servo motor or servo driver sends alarm sign. 2. Transducer alarming or overload thermal error. 	<ol style="list-style-type: none"> 1. Switch off host, and restart one minute later. Check the alarm signal code display on servo driver, or inform us. 2. Switch off host, and restart one minute later. Check the alarm signal code on transducer, or inform us.
<p>The machine doesn't work when it is on.</p>	<ol style="list-style-type: none"> 1. The emergency switch is off. 2. Parameters are not set correctly. 3. PLC error. 	<ol style="list-style-type: none"> 1. Reset emergency switch. 2. Reset parameters. 3. Replace PLC.
<p>Print illegibly or air-leakage at printing place.</p>	<ol style="list-style-type: none"> 1. Setting temperature is inappropriate so that the ribbon cannot be printed. 2. The distance between printer and laminated board is over-large. 3. Temperature or air pressure of printer is too high. 4. Ribbon problem. 	<ol style="list-style-type: none"> 1. Rise the temperature. 2. Adjust the distance between printer and laminated board, making it touch the film exactly. 3. Lower the temperature, or decrease the cylinder pressure. 4. Replace ribbon.
<p>Crash product</p>	<ol style="list-style-type: none"> 1. Time of feeding is inappropriate. 2. Packaging speed is too fast, and product is too light. 3. Preset bag length is too short. 4. Packaging machine parameter and weigher parameter don't match correctly. 	<ol style="list-style-type: none"> 1. Reset feeding time. 2. Lessen packaging speed. 3. Reset bag length. 4. Reset parameter of packaging machine and weigher.

10 Declaration of conformity



CE-Konformitätserklärung Confirmation of conformity

Hiermit erklärt die
This is to certify by

BluePack Machines GmbH, Gutenbergstrasse 38,
21465 Reinbek, Germany

dass das Produkt
that the product

Marke / Brand: AMTEC
Modelreihe / Model Series: VERTIwrap
Beschreibung / Description: VFFS Maschine inkl. Flüssigkeits-
Dosierung / VFFS machine incl.
liquid dosing
Model-Typ / model type: s.u. angebrachter CE Aufkleber /
according to below ce label
Nr. der Serie / No. of Series: s.u. angebrachter CE Aufkleber /
according to below ce label

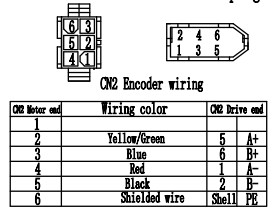
die Anforderungen erfüllt: Maschinenrichtlinie / Machinery Directive 2006/42/EC
meet the requirements of:

Eine technische Dokumentation ist vollständig vorhanden. Die zur Maschine gehörende Betriebsanleitung liegt in der Originalfassung und in englischer/deutscher Sprache vor.
A technical documentation is available. The machine operating instructions are available in its original version and in English / German.

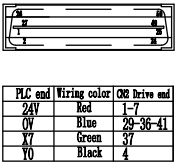
Unterschrift / Signature: Martin Conrad
Mitglied der Geschäftsleitung / Member of the management,
BluePack Machines GmbH (Vertrieb für AMTEC Maschinen /
Distribution of AMTEC machines), Gutenbergstrasse 38,
21465 Reinbek - Germany, 22.10.2020:



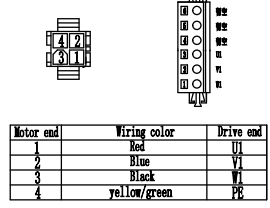
A. CN2 connection motor end plug CN2 connection drive end plug



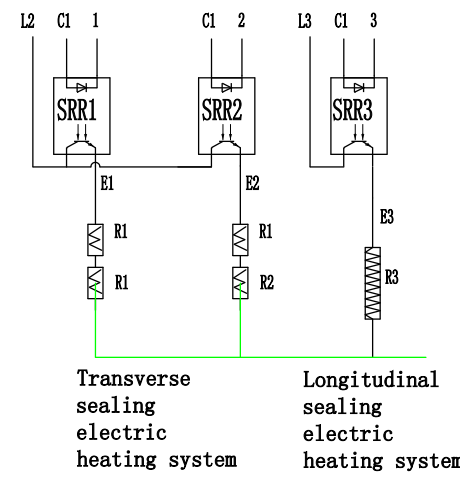
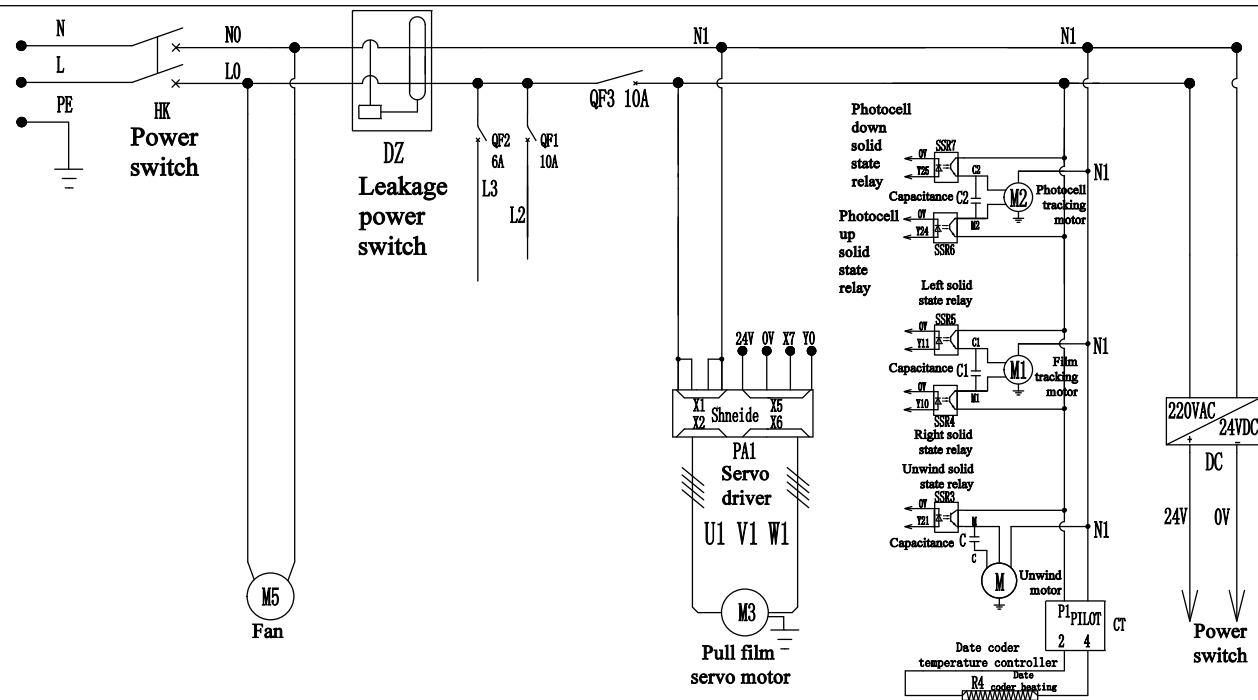
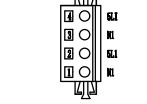
B. CN1 connection drive end plug



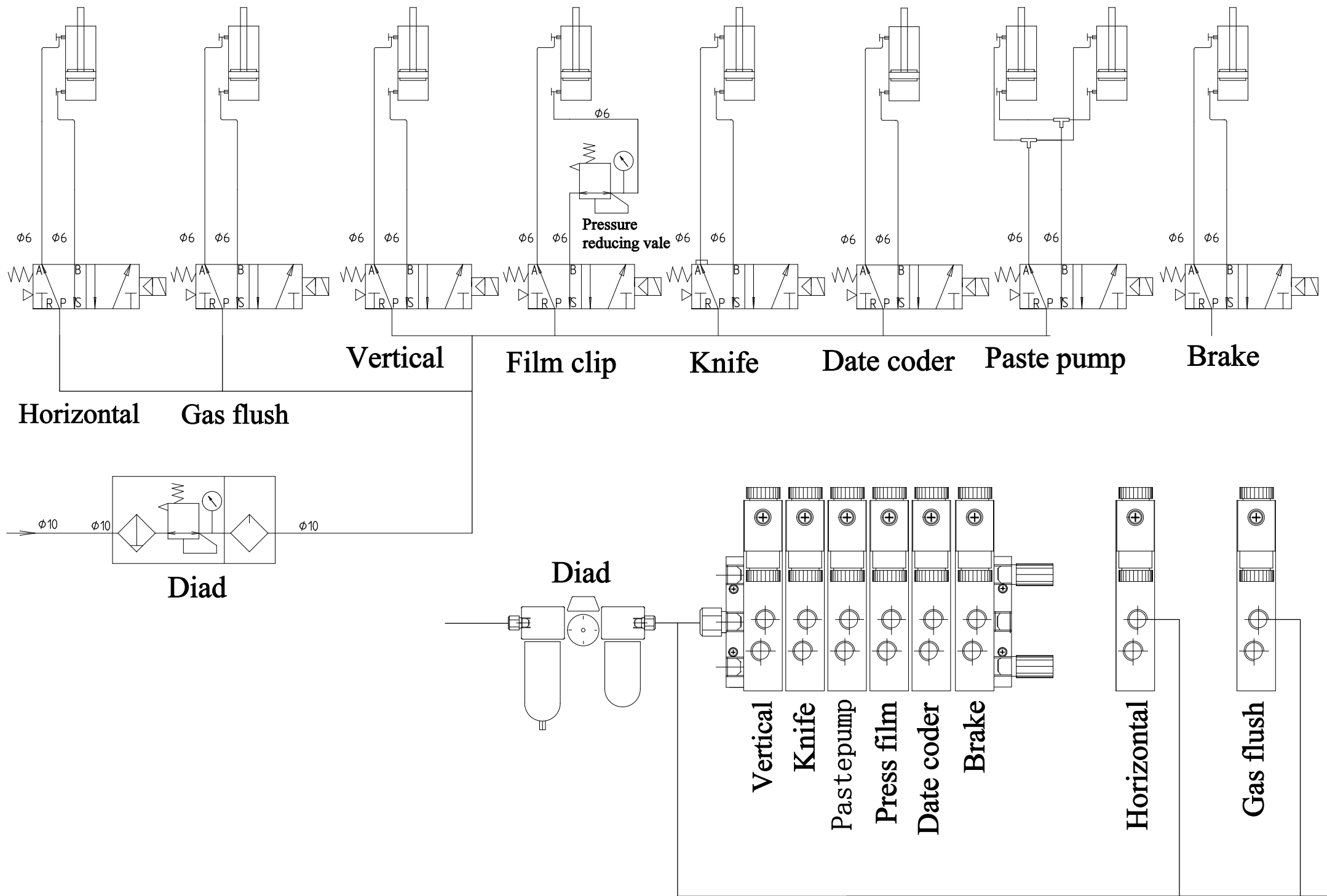
C. Connection motor end plug Connect the drive end plug

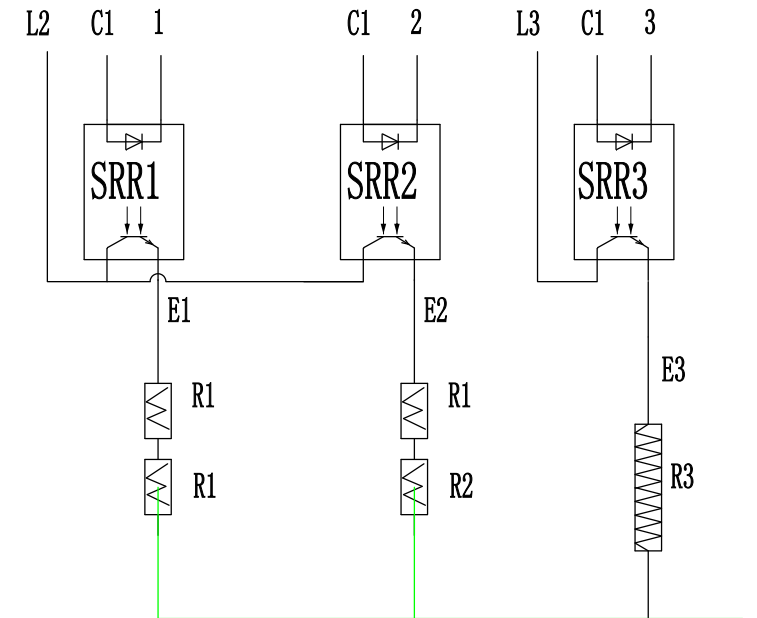
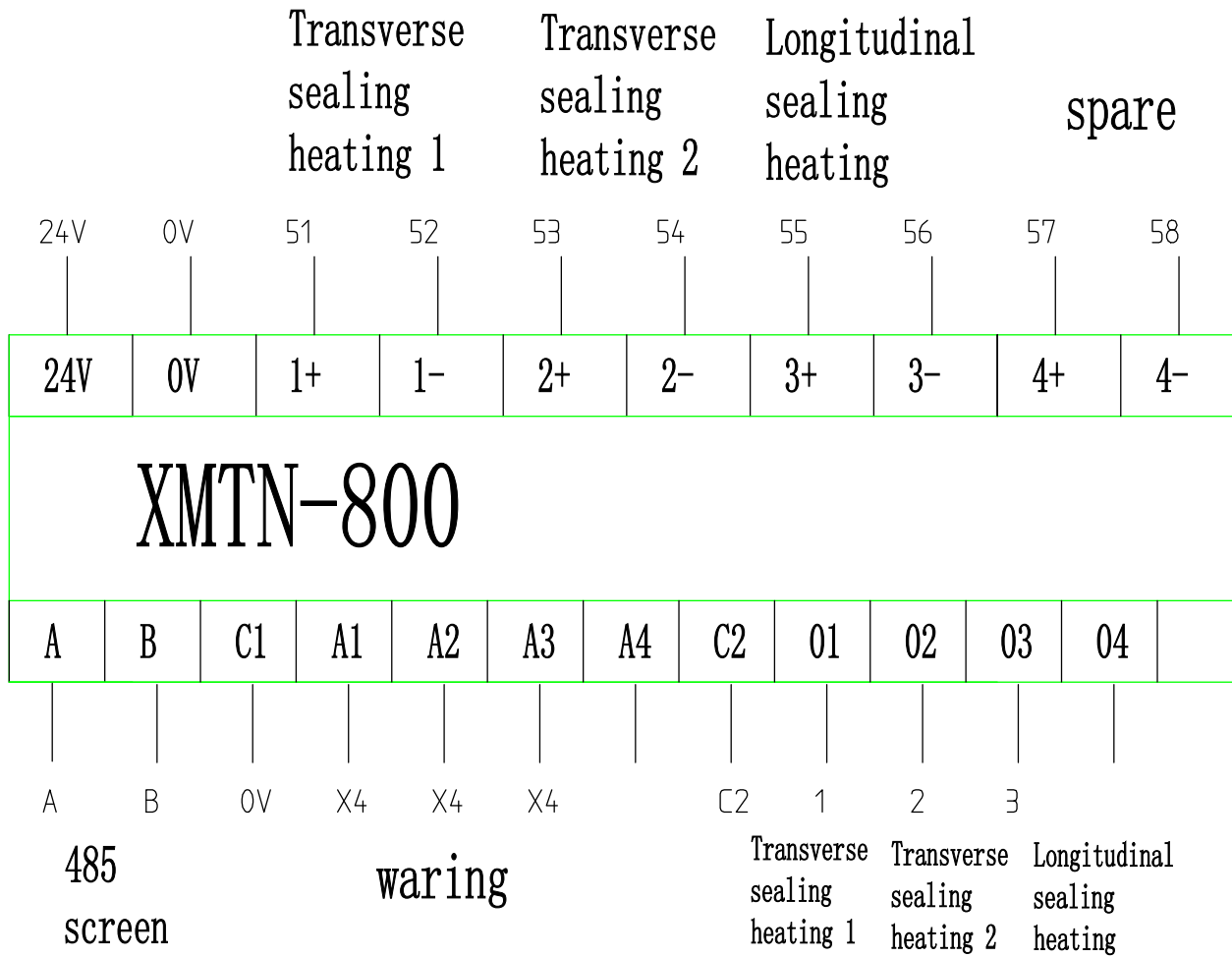


D. Main power input plug



Transverse sealing electric heating system Longitudinal sealing electric heating system





Transverse
sealing
electric
heating
system

Longitudinal
sealing
electric
heating
system