
SEMI AUTO CARTON SEALER MACHINE

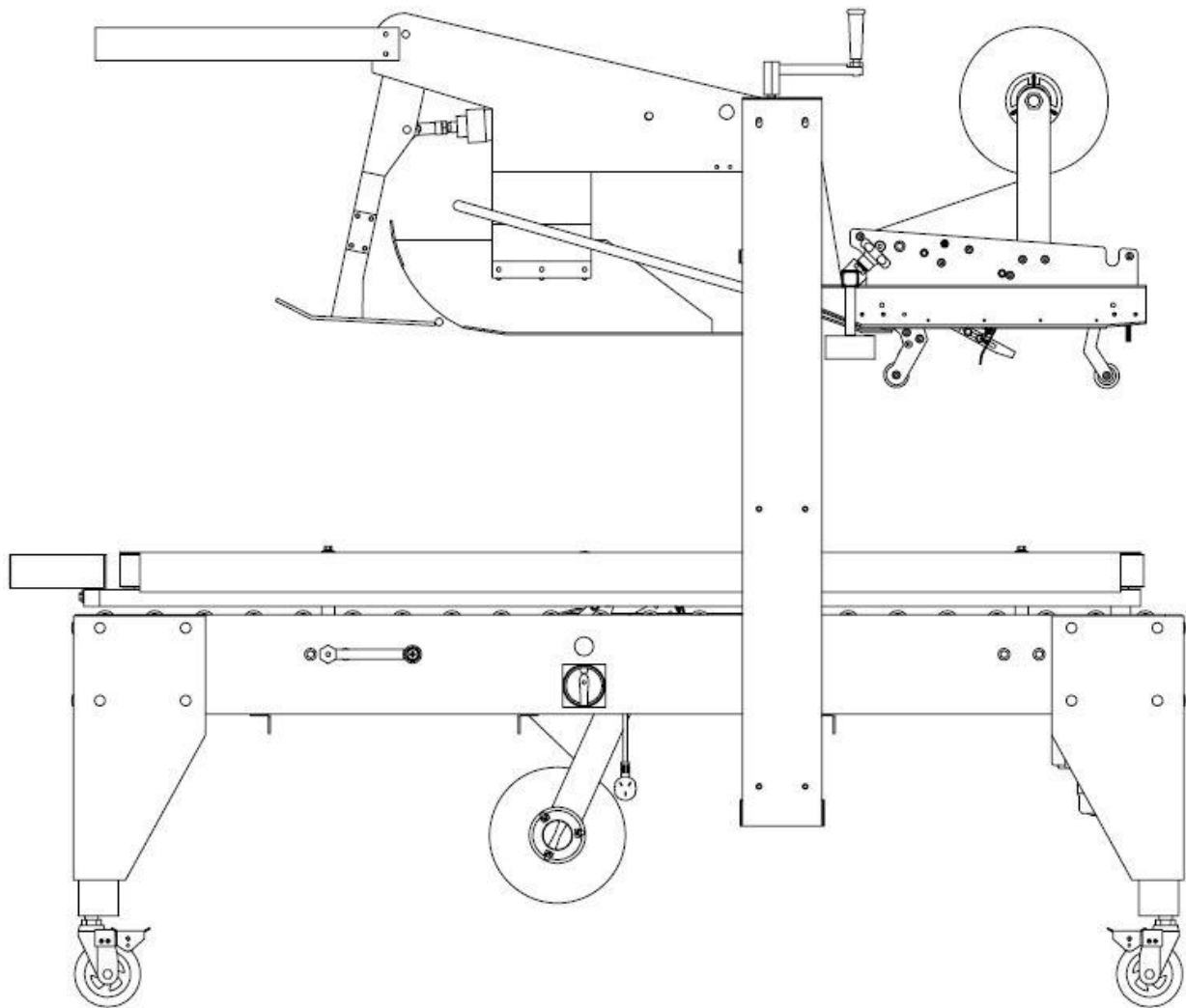


TABLE OF THE CONTENT

1. PREFACE (前言)	3
SAFETY RULES (安全规则)	3
WARNING LABELS (警告标识)	3
TECHNICAL DATA (技术资料)	4
INSTALLATION (安装)	5
2. ADJUSTMENT (安装调整)	5
MAINTENANCE & LUBRICATION 清洁及 润滑	7
3. ELECTRIC DIAGRAM 电控原理图	9
PNEUMATIC DIAGRAM 气控原理图	10
4. TROUBLE SHOOTING (故障排除)	13
5. TAPPING HEAD ASSEMBLY 攻丝头装配	16
6. FRAME ASSEMBLY 框架总成	19
7. SIDE DRIVEN ASSEMBLY 侧驱动总成	21
8. MAST ASSEMBLY 升降架组合	23
9. GRIP & KNOCK BAR ASSEMBLY 握&敲杆总 成	

PREFACE (前言)

We are pleased that you have chosen the FXJ-AT5050 automatic sealing machine, the structure of this machine is quite solid, and also can be easily to perform maintenance work.

To get the higher efficiency, please read the manual carefully before starting the machine.

(非常感谢您购买SDW-FC500半自动折盖封箱机，此款机器框架十分坚实、且易维修，在您使用本机器前、请详细研读此手册、以便获得更高的操作效率)

SAFETY RULES (安全规则)

- ※ The machine can not be operated by untrained personal. 这台机器不能让未经培训的个人操作。
- ※ Please observe all the precautions and warning labels. 请遵守所有的预防措施和警告标签。
- ※ Do not remove or make any changes of the safety device. 不要拆卸或进行任何更改的安全装置。
- ※ When the machine is operating, do not make other maintainness or repair works. 当机器运作时,不要进行维修工作
- ※ Please replace the cover after completing the machine adjustment work. 完成机器的调整后请更换盖。
- ※ If the machine was in frames, to put out the fire by water is forbidden. 如果这台机器着火,严禁用水灭火
- ※ Please follow the instructions of the machine to operate the mahcine. 请按照说明来操作机器。
- ※ When the machine is not in use, please turn the power off. 当机器不使用时,请关闭电源

WARNING LABELS

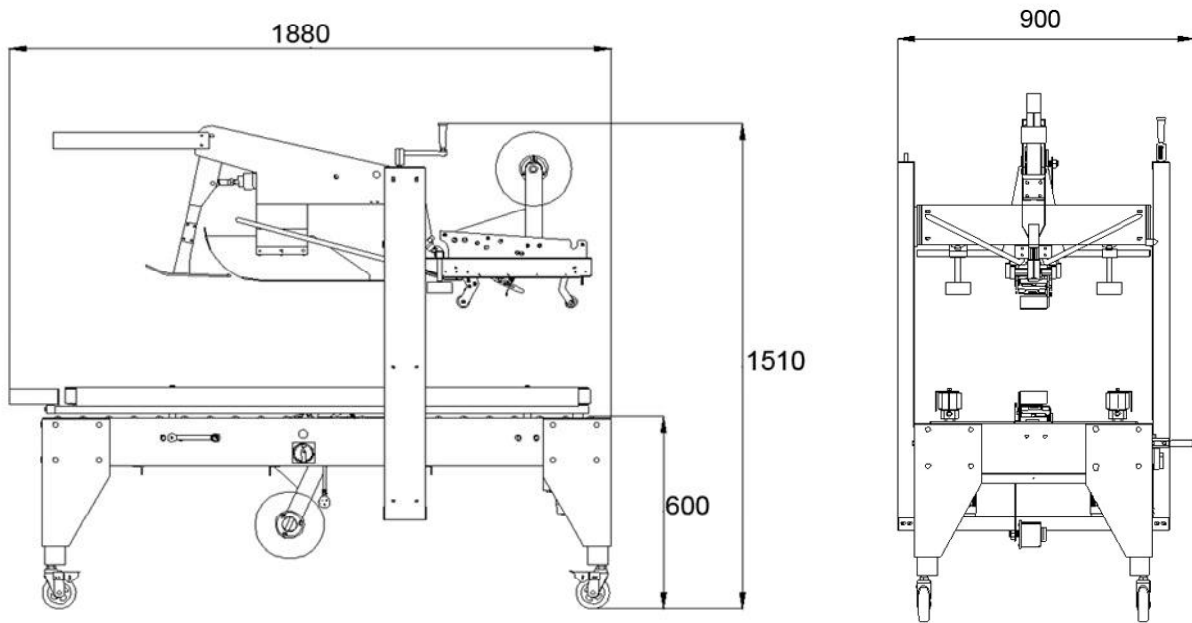


ELECTRICAL SHOCK 触电



CLAMP INJURE
夹手

TECHNICAL DATA 技术参数



NO.	NAME 名称	SPECIFICATION 规格
1	MAHCINE MODEL 机台型号	FXJ-AT5050
2	SEALING SPEED 封箱速度	800~900 UNIT/ PER HOUR
3	CARTON DIMENTION (W)	150mm~500mm
4	CARTON DIMENTION (H)	110mm~500mm
5	CARTON DIMENTION (L)	200mm~600mm
6	TAPE APPLICABLE 适用胶带	48~60~75W x 1000ML
7	TABLE HEIGHT 台面高度	570 ~770 mm (ADJUSTABLE)
8	DIMENSION 尺寸	L1880 x W900 x H1510mm
9	WEIGHT 重量	≈180Kgs
10	NOISE DEGREE 单机噪音	MAX: 80dBA
11	ELECTRIC CONSUMPTION 耗电量	MAX: 0.2KW
12	VOLTAGE USAGE 电压使用	220V/50Hz/60Hz/1Ph
13	PNEUMATIC USAGE 气动使用	380V/50Hz/60Hz/3Ph 3kgf/cm ² 100nl/min

INSTALLATION 安装

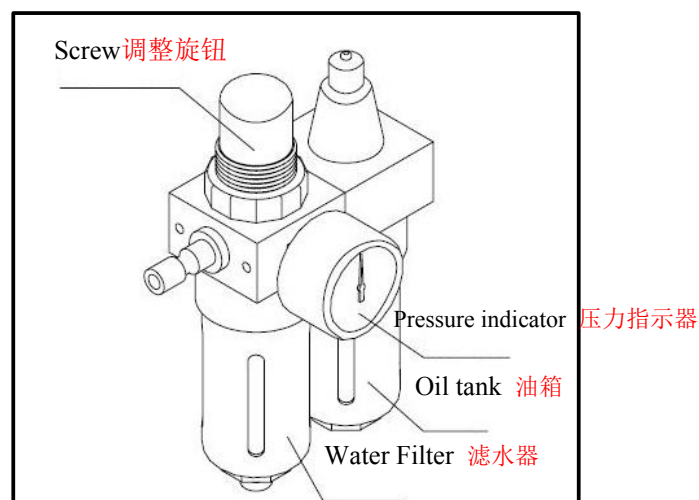
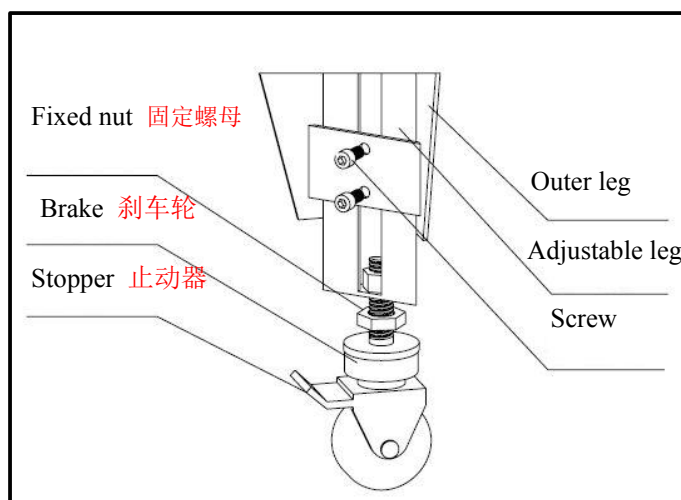
- ※ The power supply system, voltage and frequency must correspond to the regulation label attached to the machine. 电源系统、电压和频率必须对应监管标签附加到这台机器。
- ※ Connect the plug. 插头连接
- ※ Operate the machine by the side switch. 通过侧开关操作这台机器的。

NOTICE: 注意

Please install the machine where a power supply can be easily connected. 请将机器安装在电源易连接的地方。

It is necessary to disconnect the power supply plug prior to open the control box's cover. 断开电源插头之前打开控制箱的封面这是十分有必要的

ADJUSTMENT 调试



NOTICE:

Before performing adjustment works, please disconnect the power supply. 在进行调整工作前,请断开电源

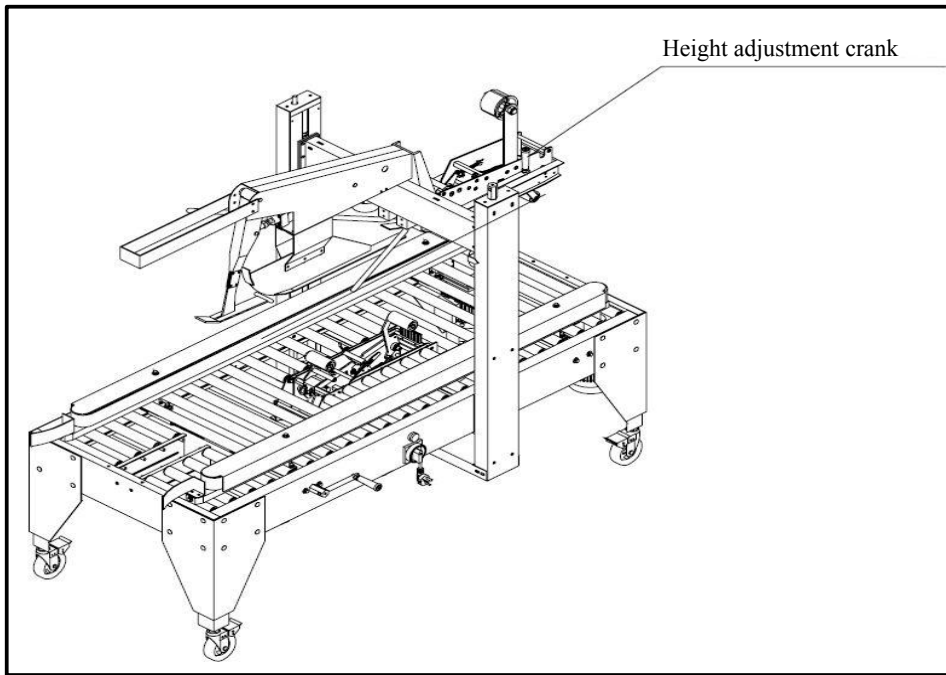
Step1: Table height adjustment 第一步: 机台高度调整

Ground the equipment on the properly storage place, adjust the table top to the desire height. 将设备放在妥善存储位置,将机台台面高度调整到需求高度

- (1) Loose the adjustable screw. 松开调节螺钉
- (2) Adjust the height of the table leg. 调整桌腿高度
- (3) Lock the screw. 锁定螺钉
- (4) Press the stopper to fix the position. 按下塞子固定位置。

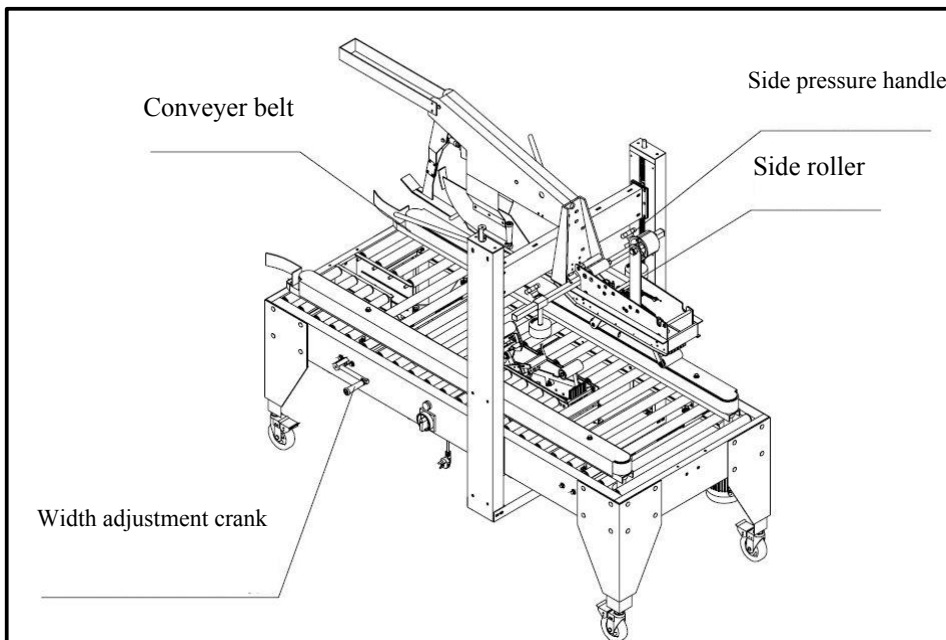
Step2: Pneumatic adjustment 第二步: 气动调整

- (1) Link the machine to the pneumatic supply. 连接机器的气动供应
- (2) Pull the screw and turn it clockwise to increase the pressure or counterclockwise to decrease the pressure 把螺丝朝顺时针方向旋转增加压力,逆时针方向旋转减少压力
- (3) The pneumatic pressure should be adjusted to about 5-6kg/cm². 气动压力应该调整到5-6kg / cm²。
- (4) Turn the screw tightly after completing the adjustment works. 完成调整工作后把螺丝拧紧。



Step3: Height adjustment 第三步:调整高度

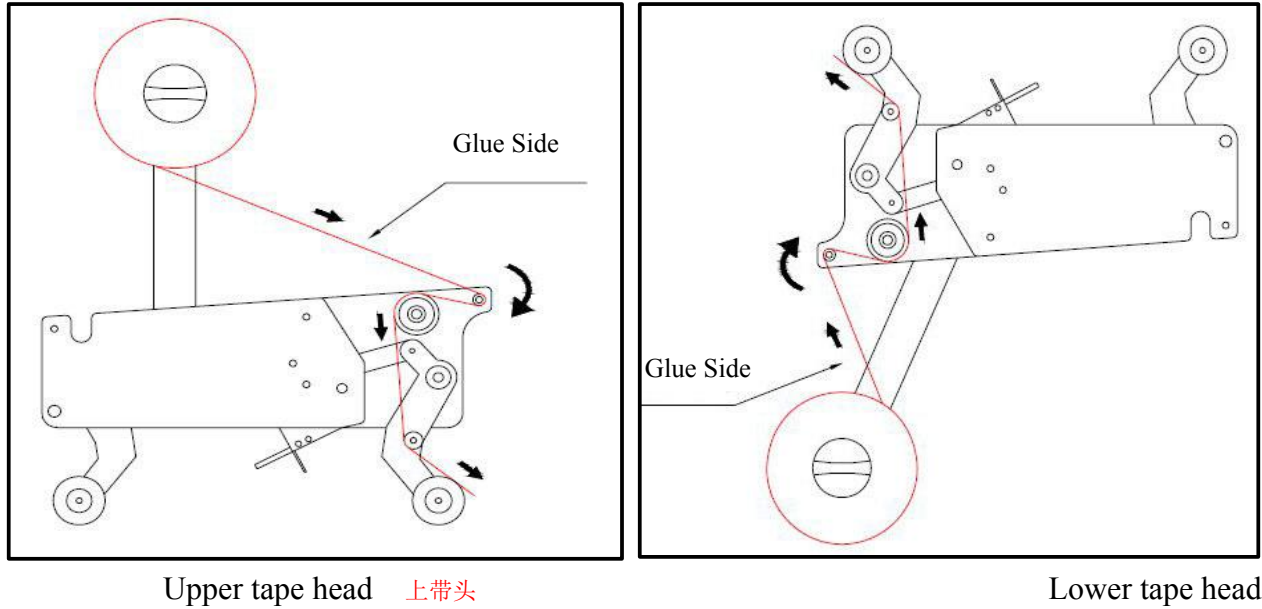
- (1) Put a carton on the table. 把一个纸箱放在桌子上。
- (2) Rotate the height adjustment crank to adjust the table height. 旋转高度调节曲柄,调整桌子的高度。
- (3) The front guide plate just need to be adjusted to touch the carton top. 前导流板要调整到碰纸箱顶部



Step4: Width adjustment 宽度调整

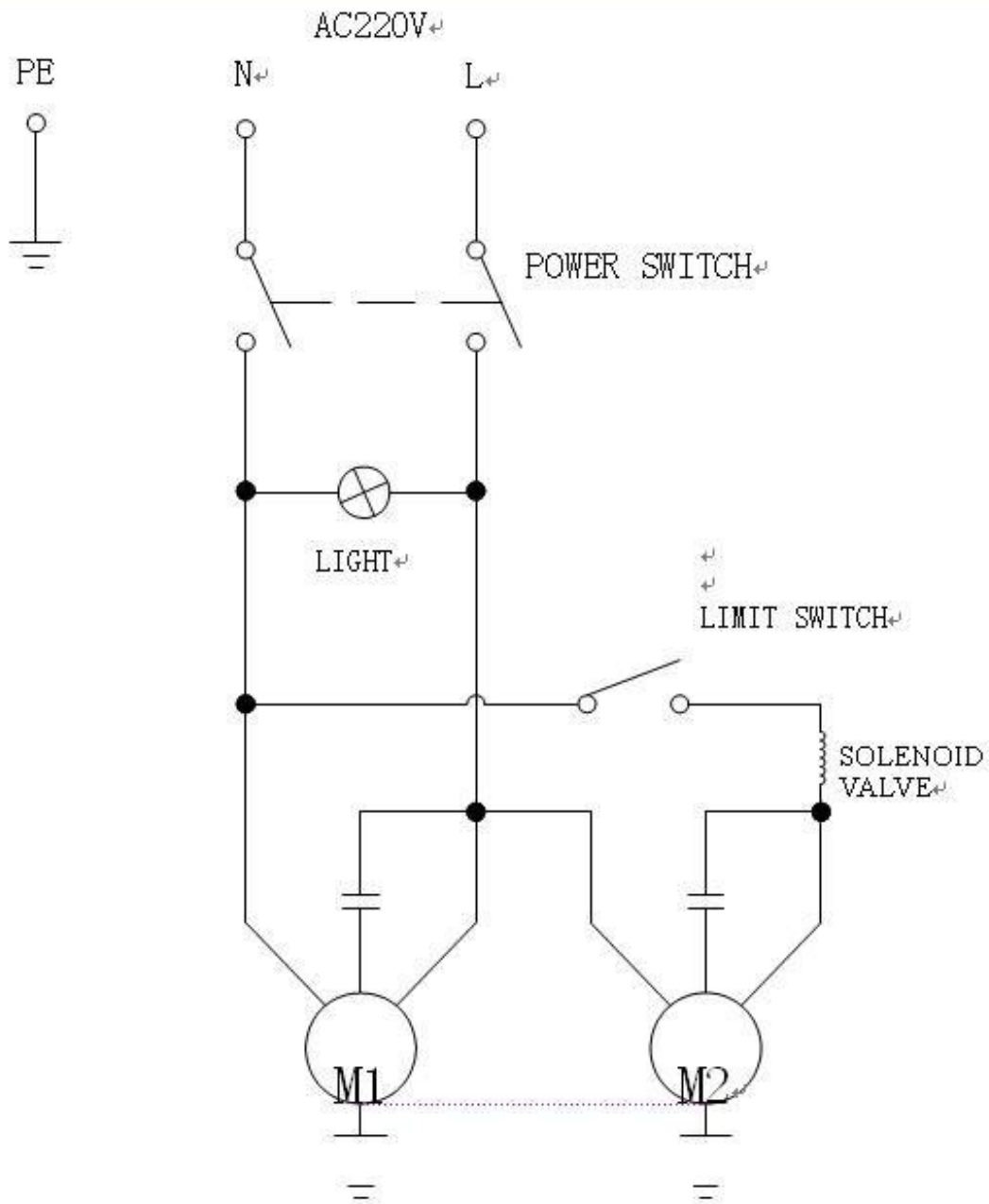
- (1) Rotate the width adjustment crank, the width just needs to be adjusted to clamp the carton properly and let it can be welled pass through. 旋转宽度调整曲柄,宽度需调整到将纸箱正确夹紧,以便纸箱可以顺利通过。
- (2) Loose the handle of the side roller, adjust the gap between side rollers to touch the caton tightly, then trun the handle again to fix it. 摇松侧边滚轮的提手、紧紧地调整侧边滚轮与碰金榜的差距,,然后再次转动把手调节。

Thread illustration 线程图解

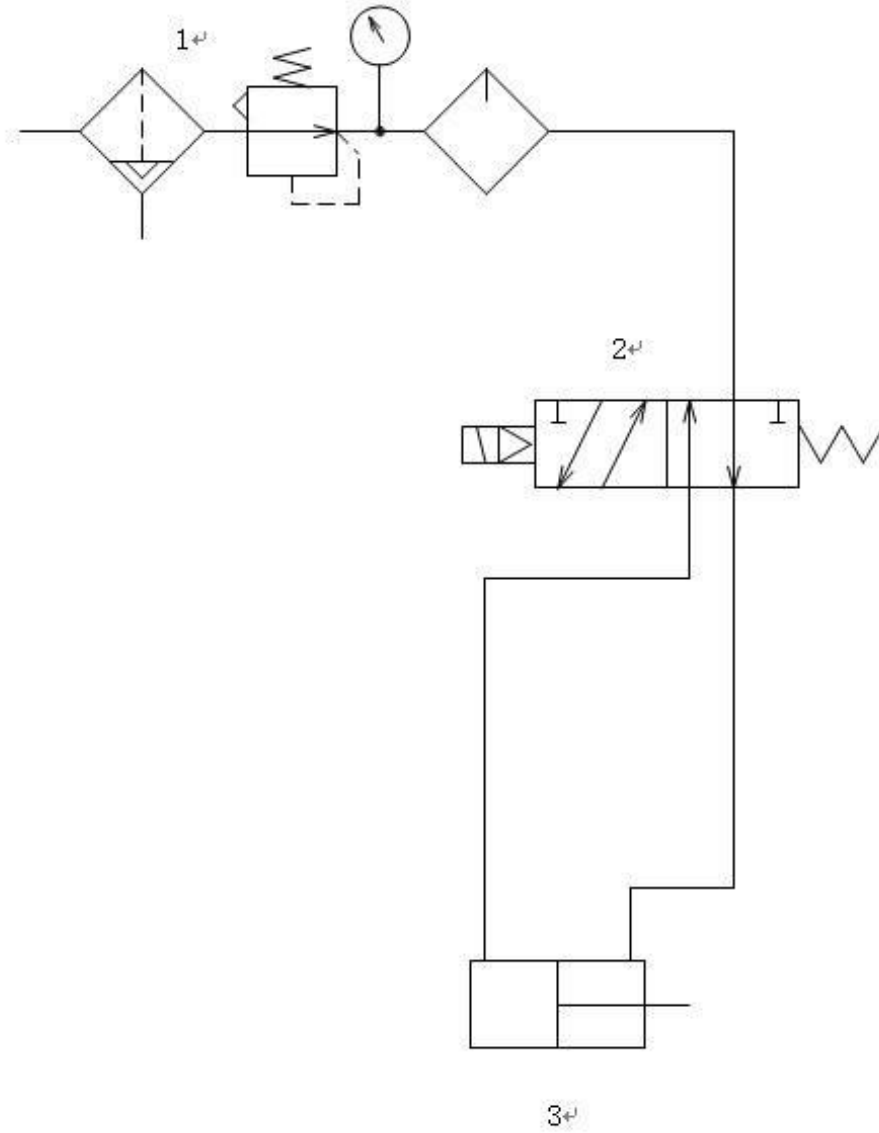


MAINTENANCE AND LUBRICATION 保养和润滑

- ※ Please read the instruction manual prior to perform maintenance and inspection works.
- ※ Before performing maintenance work, please shut down the machine and disconnect the power supply, it is an important step to avoid missend the electricity.
- ※ If it is necessary to use the different specification of tape, please refer to the part list in this manual.
- ※ Periodically clean the grime, dust and dirt stuck on the belt and clean up any other parts of the machine.
- ※ To extend the blade longevity, please check if there are too much surplus viscose stuck on the blade, please clean it up and lubricate it.
- ※ To maintain the normal operation of the machine, please lubricate the movable parts of the machine weekly.



PNEUMATIC CONTROL DIAGRAM 气动控制图



零部件型号

规格/说明

数量

NO.	PARTS NO.	SPECIFICATION	QTY
1	AFR/L-02	FILTER 滤波器	1
2	VS520-02-2S	SOLENOID VALVE 电磁阀	1
3	Q01-040150	CYLINDER 40*150 圆筒	1

TROUBLE SHOOTING 故障排除

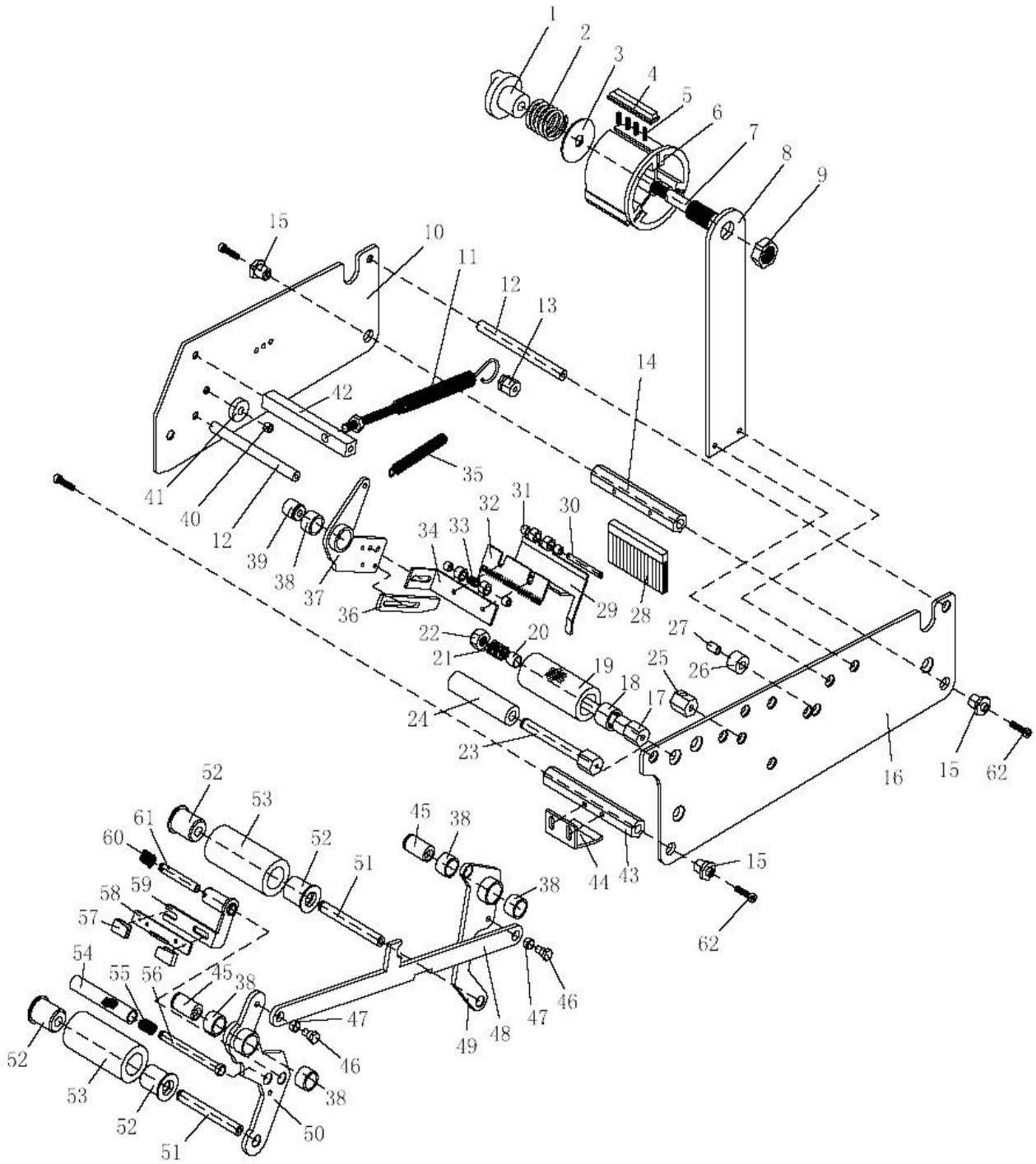
Fault 故障	Cause 原因	Elimination 解决
The carton can not be transported by the side driven belt	The carton width is too narrow.	Please use the appropriate size of the carton.
	The belt was worn	Replace a new belt
	The pressure of the upper tape head is not enough.	Adjust the upper tape head's height.
	Upper tape head's roller is positioned too low.	Adjust the roller position.
	The upper tape head's spring is too tight.	Loosen the spring to reduce the tension.
The driven belt will not move.	The belt's tension is not strong enough.	Adjust the belt's tension.
	The power is not being connected.	Please check the power line.
	The motor will not work.	Inspect the motor.
The belt was broken.	The belt was worn.	Replace a new belt.
	The belt tension is too tight.	Adjust the belt's tension.
The carton was jammed in too	Upper head's position is low.	Please adjust the upper tape head's height.
Noise occurred during machine operation.	The bearing was worn.	Replace the bearing.
The tape is not adhered to the center of the carton.	The carton is not being properly positioned.	Adjust the carton position.
The tape adhered to the carton is too long.	The way to thread the tape is wrong.	Please check the tape thread chapters of this manual.
The tape can not be cut, or the cut's edge is uneven.	The blades are blunt or break.	Please replace a new blade.
	The tape tension is not strong enough.	Turn the screw clockwise to tighten it.
	Excess tape sticks on the blade.	Clean up the blade.
	The fixing nut is loose.	Replace a new nut.

The carton is jammed.	The upper tape head is positioned too low.	Adjust the upper tape head's height.
The tape adhered to the carton is too short.	The upper and lower guide roller can not spin very well.	Clean up the roller and lubricate it.
	The blade's position is displaced.	Adjust the blade position.
	The way to thread the tape is wrong.	Please check the tape thread chapters of this manual.
The tape is wrinkled and can not adhere to the carton very well.	The tape head's roller can not spin very well.	Clean up the roller and lubricate it.
	The tension of the tape base is too tight.	Loose the screw by turning the nut counterclockwise.
	The upper tape head's position is too high.	Adjust the upper tape head's height.
The tape draws back.	The single way roller is broken.	Replace a single way roller.
The lower tape's edge curves down.	The tape is too thin, or the tape's outer shape is changed	Please replace a new tape.

Part list

零件表

TAPPING HEAD ASSEMBLY 攻丝头装配



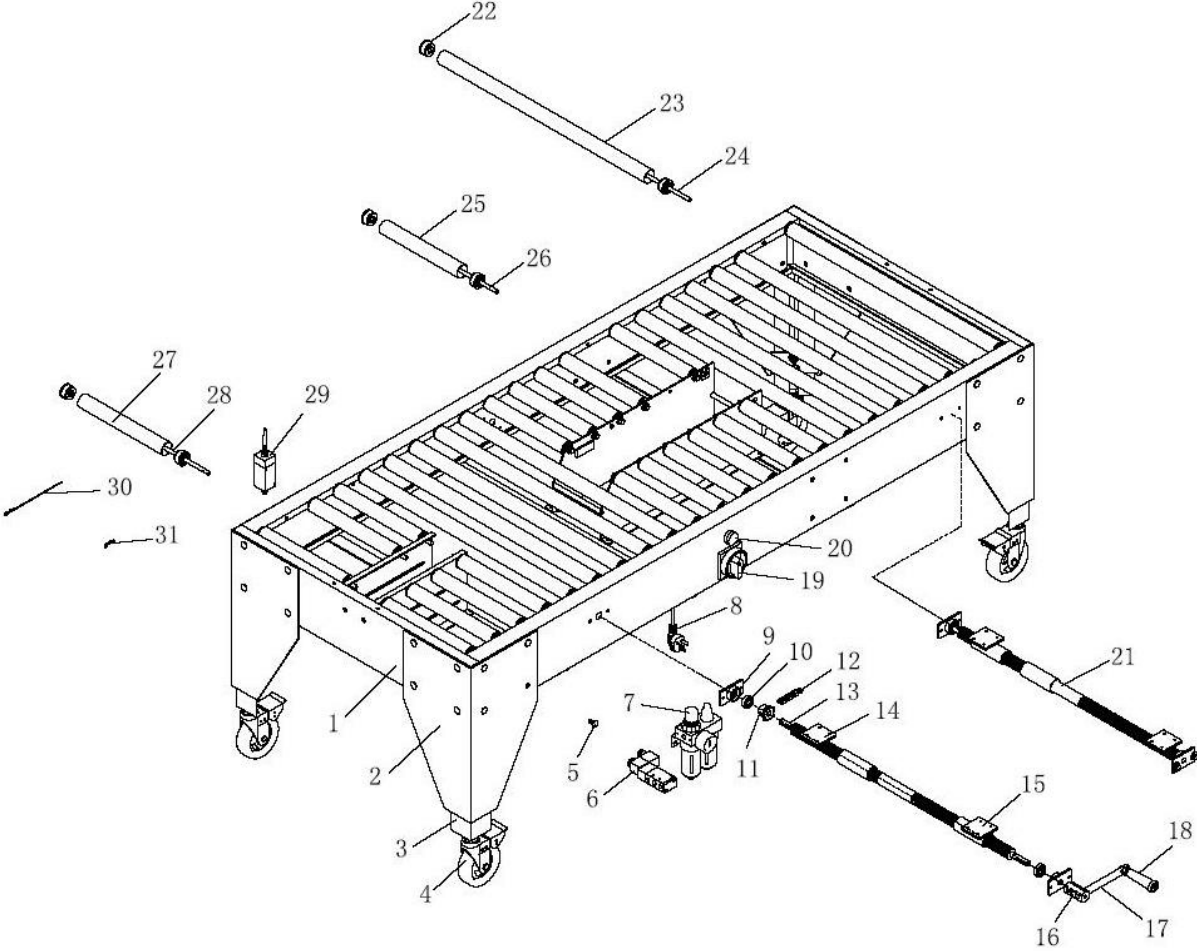
TAPPING HEAD ASSEMBLY

NO.	PART NO. 零部件型号	PART NAME 零部件名称	QTY 数量
1	JP-100212	SCREW 螺钉	1
2	JP-100211B	SPRING 弹簧	1
3	JP-200011	SPACER 垫片	1
4	JP-100208-A	ACCESSORIES 配件	3
5	JP-100211A	SMALL SPRING	12
6	JP-100208	TAPE BASE	1
7	JP-100121-2	SHAFT 2"	1
	JP-100121-3	SHAFT 3"	1
8	JP-100008	BASE SUPPORT PLATE	1
9	JP-100120	FIXED NUT	1
10	JP-100002-2	PLATE 2"	1
	JP-100002-3	PLATE 3"	1
11	JP-100209A	MAIN SPRING	1
12	JP-100109-2	SHAFT 2"	2
	JP-100109-3	SHAFT 3"	2
13	JP-100119	HEXAGON NUT	1
14	JP-100105-2	BRUSH SHAFT 2"	1
	JP-100105-3	BRUSH SHAFT 3"	1
15	JP-100122	FIXED NUT	3
16	JP-100001-2	PLATE 2"	1
	JP-100001-3	PLATE 3"	1
17	JP-100102-2	SINGLE WAY ROLLER 2"	1
	JP-100102-3	SINGLE WAY ROLLER 3"	1
18	CHHF-1616	BEARING HF1616	1
19	JP-100101-2	SINGLE WAY ROLLER 2"	1
	JP-100101-3	SINGLE WAY ROLLER 3"	1
20	G04-111010	BEARING	1
21	JP-100211D	SINGLE WAY SPRING	1
22	W20-102010	NUT M10	1
23	JP-100107-2	PE SHAFT 2"	1
	JP-100107-3	PE SHAFT 3"	1
24	JP-100108-2	PE SLEEVE 2"	1
	JP-100108-3	PE SLEEVE 3"	1
25	JP-100124	HEXAGON NUT	1
26	JP-100123B	STOP ROLLER	1
27	JP-100125B	STOP ROLLER ACCESSORIES	1
28	JP-100202-2	BRUSH 2"	1
	JP-100202-3	BRUSH 2"	1
29	JP-100013-2	BLADE COVER 2"	1
	JP-100013-3	BLADE COVER 3"	1
30	JP-100126	LINK SHAFT 上锁销杆转轴	1
31	JP-100127	FIXED NUT 固定螺母	4
32	JP-100201-2	2" BLADE 2"刀片	1
	JP-100201-3	3" BLADE	1
33	JP-100210C	SPRING 弹簧	1

TAPPING HEAD ASSEMBLY

NO.	PART NO.	PART NAME	QTY
34	JP-100014-2	LINK PLATE 2"	1
	JP-100014-3	LINK PLATE 3"	1
35	JP-100209B	SPRING	1
36	JP-100010-2	EXTENSION PLATE 2"	1
	JP-100010-3	EXTENSION PLATE 3"	1
37	JP-100009	BLADE ASSEMBLY	1
38	JP-100205	SHORT SLEEVE	5
39	JP-100117	FIXED SHAFT	1
40	JP-100125A	STOP ROLLER ACCESORIES	1
41	JP-100123A	STOP ROLLER	1
42	JP-100111-3	RECTANGULAR SHAFT 2"	1
	JP-100111-3	RECTANGULAR SHAFT 3"	1
43	JP-100106-2	HEXAGON SHAFT 2"	1
	JP-100106-3	HEXAGON SHAFT 3"	1
44	JP-100011	FRONT GUIDE PLATE	1
45	JP-100115	FIXED SHAFT	2
46	JP-100118	HEXAGON SCREW	2
47	JP-100204	TH SLEEVE	2
48	JP-100005-2	PLATE 2"	1
	JP-100005-3	PLATE 3"	1
49	JP-100004-2	PENDANT ASSEMBLY 2"	1
	JP-100004-3	PENDANT ASSEMBLY 3"	1
50	JP-100003-2	FRONT PENDANT ASSEMBLY 2"	1
	JP-100003-3	FRONT PENDANT ASSEMBLY 3"	1
51	JP-100110-2	SHAFT 2"	1
	JP-100110-3	SHAFT 3"	1
52	JP-100207	ROLLER PLUG	4
53	JP-100206-2	ROLLER 2"	2
	JP-100206-3	ROLLER 2"	2
54	JP-100103-2	ROLLER 2"	1
	JP-100103-3	ROLLER 3"	1
55	JP-100211C	SPRING	1
56	JP-100104-2	SHAFT 2"	1
	JP-100104-3	SHAFT 3"	1
57	JP-100012	CLIP	2
58	JP-100007-2	PLATE 2"	1
	JP-100007-3	PLATE 3"	1
59	JP-100006-2	TAPE HOLDER 2"	1
	JP-100006-3	TAPE HOLDER 3"	1
60	JP-100210A	SPRING	1
61	JP-100112	SHAFT	1
62	W01-210520	2"NUT M5*20	4

FRAME ASSEMBLY



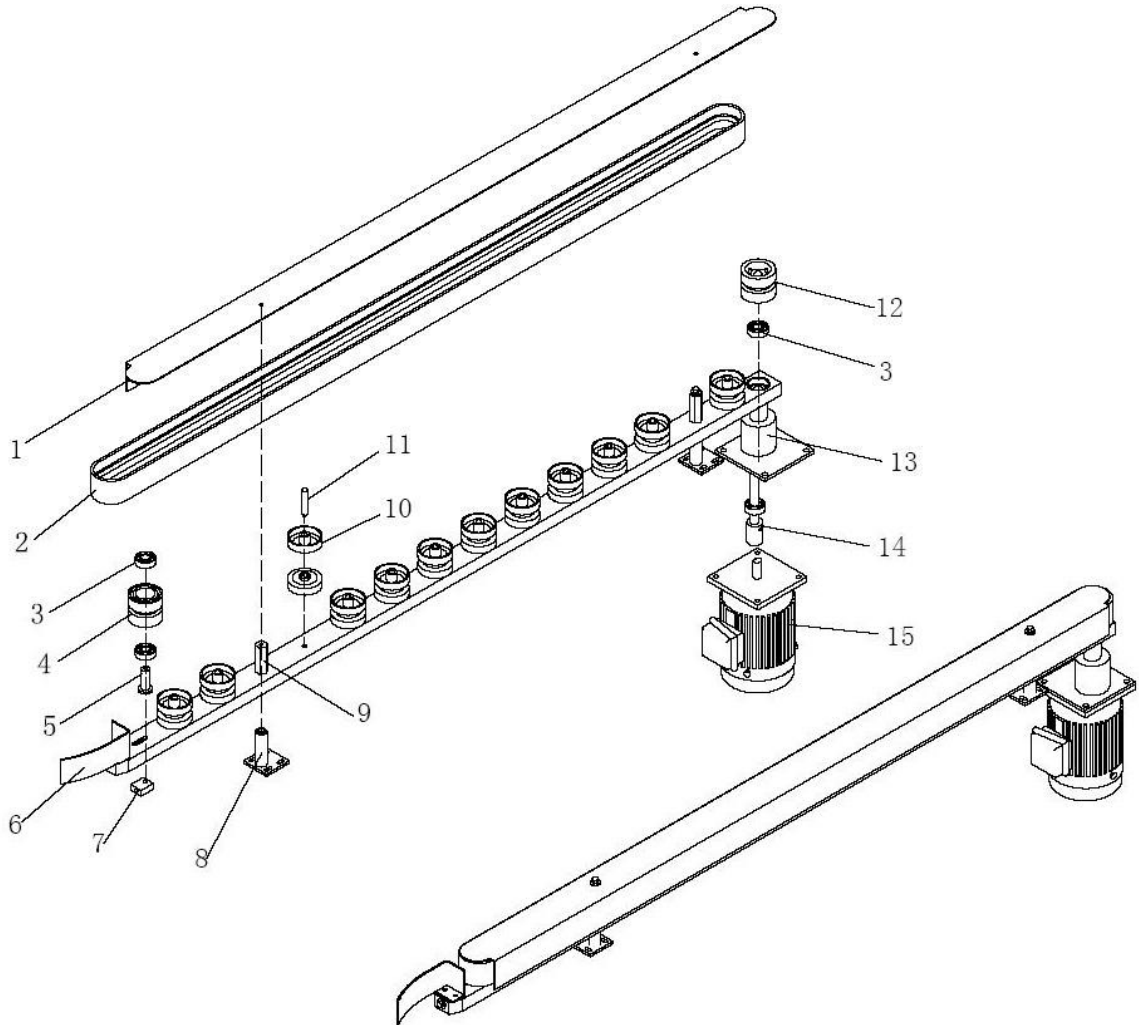
FRAME ASSEMBLY

NO.	PART NO.	PART NAME	QTY
1	JP503-101350-F	FRAME(500W)	1
	JP503-101350-G	FRAME (600W)	1
	JP503-101350-H	FRAME (700W)	1
2	JP503-101001-B	LEG(400H)	4
3	JP501-201002-B	ADJUSTABLE LEG(300)	4
4	PA001H	CASTER	4
5	JP501-102023	NUTM8*19	32
6	VS520-02-2S	SOLENOID VALVE	1
7	AFR/L-02	FILTER	1
8	E61-125321	PLUG	1
9	JP501-102001	SHAFT FIXED BASE	4
10	G04-216001	6001BEARING	4
11	06C-101200	SCREW Φ 12	2
12	L02-135000-1	CHAIN	1
13	JP501-102009-F	SHAFT(500W)	1
	JP501-102009-G	SHAFT(600W)	1
	JP501-102009-H	SHAFT(700W)	1
14	JP501-102014	DENTAL TUBE	2
15	JP501-102015	DENTAL TUBE	2
16	JP501-102016	CRANK PILLER	1
17	JP501-102017	CRANK	1
18	A1517A	CRANK HANDLE	1
19	E07-010015	MAIN POWER SWITCH CA10, A292	1
20	C07-2200122	INDICATOR LIGHT	1
21	JP501-102010-F	SHAFT(500W)	1
	JP501-102010-G	SHAFT(600W)	1
	JP501-102010-H	SHAFT(700W)	1
22	JP-200004	ROLLER PLUG	68
23	JP501-102021-35	ROLLER(500W)	12
	JP501-102021-36	ROLLER(600W)	12
	JP501-102021-37	ROLLER(700W)	12
24	JP501-102022-35	ROLLER AXLE(500W)	12
	JP501-102022-36	ROLLER AXLE (600W)	12
	JP501-102022-37	ROLLER AXLE (700W)	12

FRAME ASSEMBLY

NO.	PART NO.	PART NAME	QTY
25	JP501-102021-15-2	MIDDLE ROLLER (500W)2"	12
	JP501-102021-16-2	MIDDLE ROLLER (600W)2"	12
	JP501-102021-17-2	MIDDLE ROLLER (700W)2"	12
	JP501-102021-15-3	MIDDLE ROLLER (500W)3"	12
	JP501-102021-16-3	MIDDLE ROLLER (600W)3"	12
	JP501-102021-17-3	MIDDLE ROLLER (700W)3"	12
26	JP501-102022-15-2	ROLLER AXLE(500W)2"	12
	JP501-102022-16-2	ROLLER AXLE (600W)2"	12
	JP501-102022-17-2	ROLLER AXLE (700W)2"	12
	JP501-102022-15-3	ROLLER AXLE (500W)3"	12
	JP501-102022-16-3	ROLLER AXLE (600W)3"	12
	JP501-102022-17-3	ROLLER AXLE (700W)3"	12
27	JP503-102011-1F	FRONT ROLLER (500W)	8
	JP503-102011-1G	FRONT ROLLER (600W)	8
	JP503-102011-1H	FRONT ROLLER (700W)	8
28	JP503-102010-F	ROLLER AXLE (500W)	8
	JP503-102010-G	ROLLER AXLE (600W)	8
	JP503-102010-H	ROLLER AXLE (700W)	8
29	C06-015300	SWITCH	1
30	JP-200006A	ROLLER BOLT	1
31	JP-200006A	ROLLER BOLT	5

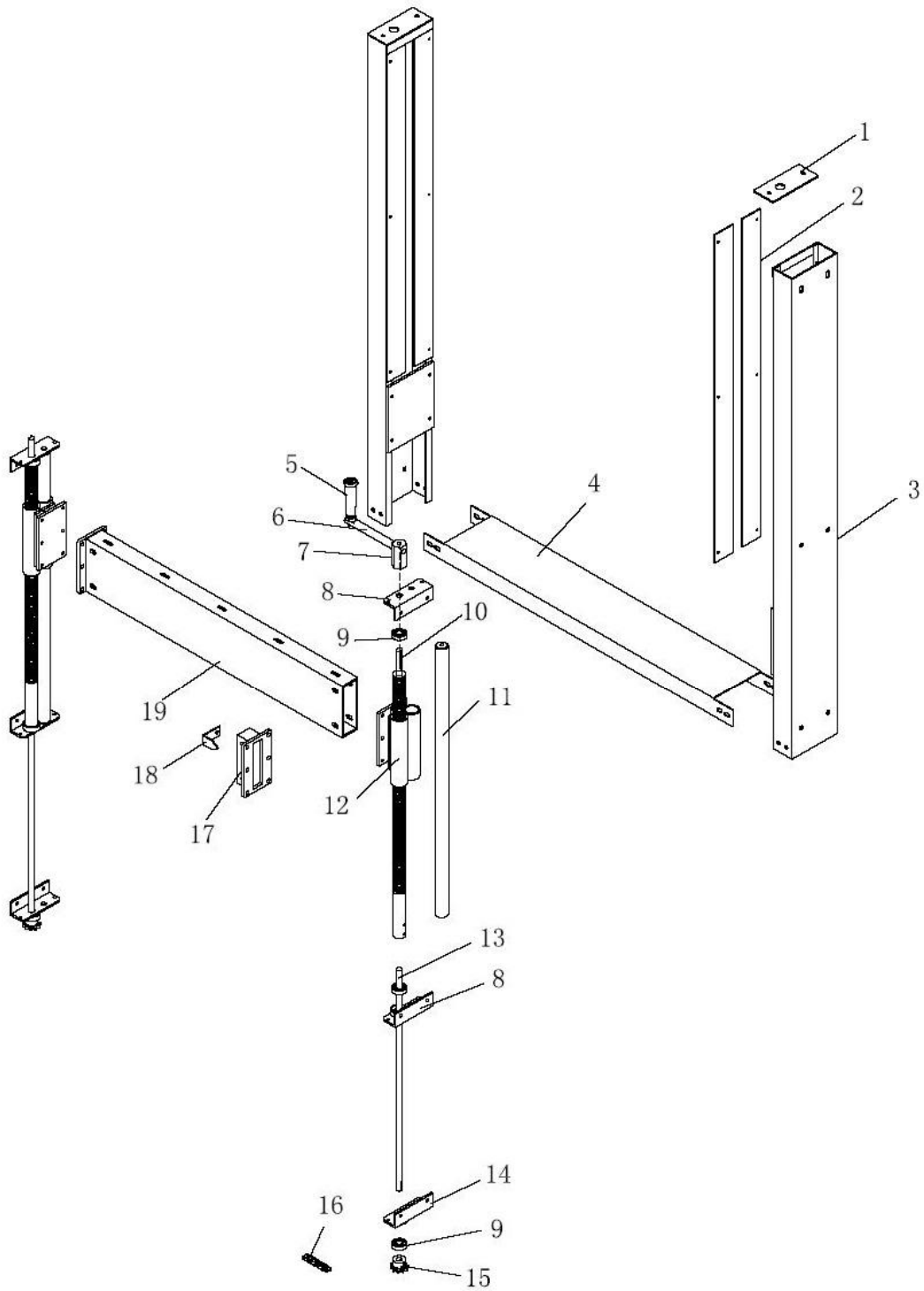
SIDE DRIVEN ASSEMBLY



SIDE DRIVEN ASSEMBLY

NO.	PART NO.	PART NAME	QTY
1	JP503-101002-A	503A BELT COVER(W50)	2
	JP503-101002-B	503A BELT COVER(W75)	2
2	P50-315048	BELT 3150*W48	2
	P50-315075	BELT 3150*W75	2
3	G04-216202	6202 BEARING	8
4	JP-200002-A	ROLLER(W50)	2
	JP-200002-B	ROLLER(W75)	2
5	JP501-102003-A	SHAFT(W50)	2
	JP501-102003-B	SHAFT(W75)	2
6	JP501-101010	FRONT GUIDE PLATE	2
7	JP501-102005	BELT ADJUSTMENT BLOCK	2
8	JP501-102004	BELT SUPPORT ASSEMBLY	4
9	JP501-102006-A	BELT SUPPORT(W50)	4
	JP501-102006-B	BELT SUPPORT (W75)	32
10	JP-200005	ROLLER	48
11	JP501-102007-A	ROLLER AXLE (W50)	24
12	JP-200003-A	MAIN ROLLER(W50)	2
	JP-200003-B	MAIN ROLLER (W75)	2
13	JP503-101250	BELT ASSEMBLY	2
14	JP501-102002-A	MAIN AXLE (W50)	2
	JP501-102002-B	MAIN AXLE (W75)	2
15	M03-814151	MOTOR 1:15 Φ15 1/8HP 220V	2
	M03-414151	MOTOR 1:15 Φ15 1/4HP 220V	2

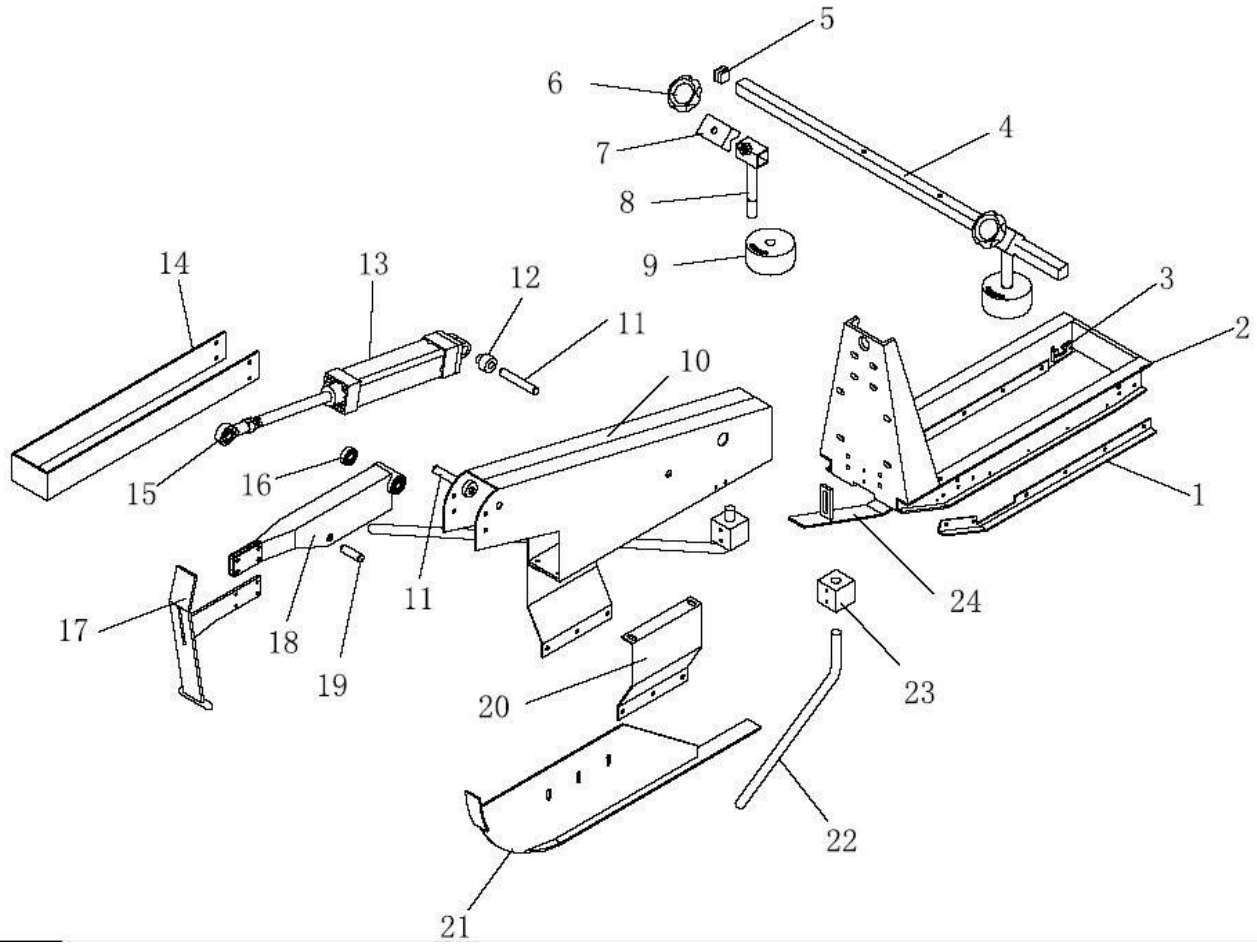
MAST ASSEMBLY



MAST ASSEMBLY

NO.	PART NO.	PART NAME	QTY
1	JP501-101005-A	END COVER	2
2	JP503-101003-F	PLATE (500H)	2
	JP503-101003-G	PLATE(600H)	2
	JP503-101003-H	PLATE(700H)	2
3	JP503-101004-F	503 SIDE COVER(500H)	4
	JP503-101004-G	503 SIDE COVER(600H)	4
	JP503-101004-H	503 SIDE COVER(700H)	4
4	JP503-101005-F	CHAIN COVER(500W)	2
	JP503-101005-G	CHAIN COVER(600W)	2
	JP503-101005-H	CHAIN COVER(700W)	2
5	A1517A	CRANK HANDLE	1
6	JP501-102017	CRANK	1
7	JP501-102016	CRANK PILLER	1
8	JP501-102012	FIXING PLATE	4
9	G04-216001	6001BEARING	6
10	JP503-102001-F	503 SHAFT(500H)	2
	JP503-102001-G	503 SHAFT(600H)	2
	JP503-102001-H	503 SHAFT(700H)	2
11	JP503-102002-F	503 SHAFT(500H)	2
	JP503-102002-G	503 SHAFT(600H)	2
	JP503-102002-H	503 SHAFT(700H)	2
12	JP503-102004	503 SLEEVE	2
13	JP503-102003	SHAFT	2
14	JP501-102013	FIXED PLATE	2
15	06C-101200	SCREW Φ 12	2
16	L02-135000-1	06C CHAIN	1
17	JP503-102005	LINK BASE	2
18	JP503-101016	INDICATOR	1
19	JP503-101006-2	SHAFT(2")	1
	JP503-101006-3	SHAFT(3")	1

GRIP & KNOCK BAR ASSEMBLY



GRIP AND KNOCK BAR ASSEMBLY

NO.	PART NO.	PART NAME	QTY
1	JP503-101008	BLADE COVER	2
2	JP503-101007-2	UPPER BLADE(2")	1
	JP503-101007-3	UPPER BLADE (3")	1
3	JP-200009	CLEAT	4
4	JP501-102019-F	SHAFT (500W)	1
	JP501-102019-G	SHAFT (600W)	1
	JP501-102019-H	SHAFT(700W)	1
5	JP-200010	END PLUG	2
6	A2512A	SIDE HANDLE	2
7	JP501-101012	FIXED PLATE	2
8	JP501-102018	JP-501 CASTER ASSEMBLY	2
9	JP-200001	SIDE ROLLER	2
10	JP503-101009	BAR HOLDER	1
11	JP503-102009B	SHAFT(LONG)	1
12	JP503-102008	CA FIXED SLEEVE	2
13	Q01-040150	CYLINDER 40*150	1
14	JP503-101014	COVER	1
15	Q05-190010	10F BALL BEARING	1
16	G04-216001	6001 BEARING	2
17	JP503-101011A	KNOCK HEAD	1
18	JP503-101010	KNOCK BAR	1
19	JP503-102009A	CYLINDER SHAFT	1
20	JP503-101012	FIXED PLATE	2
21	JP503-101013	PLATE	1
22	JP503-102007	FOLDING ARM	2
23	JP503-102006	SQUARE BASE	2
24	JP503-101015	FRONT GUIDE PLATE	1

