

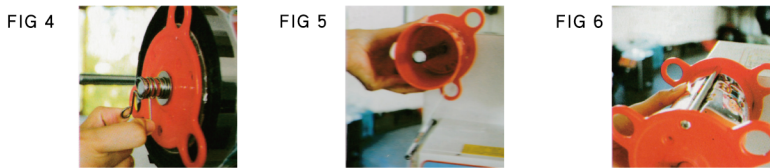
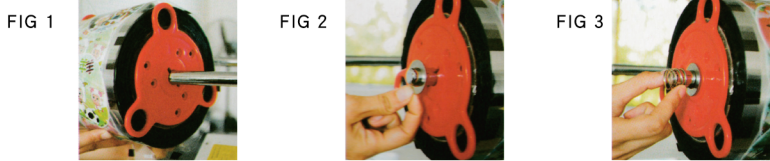
## Auto Sealing Machine For Beverage Cups

# OPERATING INSTRUCTIONS

It is absolutely forbidden for young children and non related personnel to operate

## FILM LOADING METHOD AND SCHEMATIC DIAGRAM

A:Install sealing film in sequence as shown below



B:Ensure that the film material strictly follow the position shown in Figure 7 when passing through the six guide posts

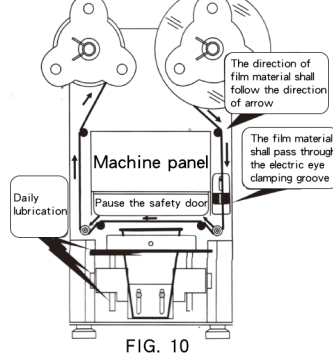


FIG. 10

C:The clamping groove on the waste film rolling slot must be clamped on the positioning ring wire of the driving shaft to drive the operation of the waste film. FIG. 11)

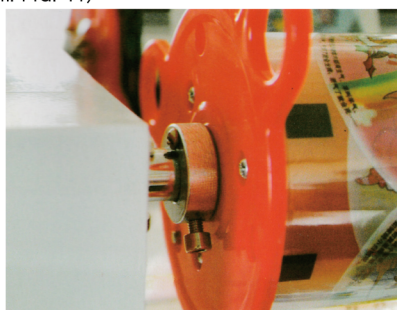
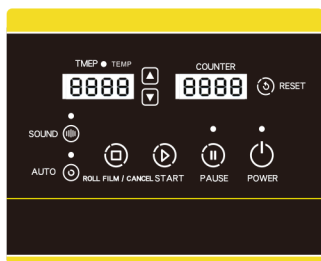


FIG. 11

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## INTRODUCTION TO OPERATION PANEL

FIG 12



The machine is connected to the grounded power supply (in accordance with the rated voltage of the machine 220V), and the power signal light flashes, indicating that the machine has been powered on and is in the state of waiting to be started

[Power button] Press this button and the machine enters the standby state, and the power signal light keeps on

[Pause button] Press this button to immediately stop the current action, and maintain the current action posture; If you need to continue when the action can press the [Start] key; To cancel the current action, press the 'Cancel/roll film' key

[Start button] Under "automatic mode IV" or "semi-automatic mode", press this key, and the machine will automatically seal the cup once

[Cancel / film winding inching] This key is used to cancel the function when the machine is suspended In standby mode, press this key and the waste film drum will rotate continuously

[Sound] This key controls the machine sound on and off

[Auto] Long press this key to switch between "Automatic mode" and "semi-automatic mode"; The automatic signal light is long on for "automatic mode", and the automatic signal light is off for "semi-automatic mode"; Press this button and the machine will enter "intelligent auxiliary function mode".

[Reset key] Press this key once to enter the "counting hidden mode", and press this key again to restore the counting function; Long press this key and release it after hearing the "tick" sound to clear the current count

[Leak prevention and repair function] In the standby mode, press the automatic key once, and the automatic signal light flashes, indicating that the machine enters the 'intelligent auxiliary function' and puts the container with sealing problems, and then press the start key. The machine will immediately improve relevant parameters and automatically perform a leak prevention and repair operation. After taking out the container, the machine will automatically return to the normal standby state.

[Automatic knife washing function] In the standby mode, press the automatic key once, and the automatic signal light flashes, indicating that the machine enters the 'intelligent auxiliary function' and puts the container with sealing problems, and then press the start key. The machine will immediately improve relevant parameters and automatically perform a leak prevention and repair operation. After taking out the container, the machine will automatically return to the normal standby state.

[Independent parameter setting] standby state, put knife washing cotton or face paper (plant fiber) into the groove of the lower film, fold it into a strip and fill it, plug the outlet of the lower film ring with the attached plug, long press [pause] key for 3 seconds and then release, enter the automatic knife washing, press up and down for 5 times and automatically exit.

1、 The sealing and cup in and out time of the machine can be adjusted according to the actual use.

2、 You can choose whether to use an electric eye to suit the use of some non-standard films such as optical film or aluminum film.

3、 Press and hold the [sound] key for 3 seconds to enter the parameter adjustable state. For gears p1-p5, press the [sound] key to switch the adjustable parameters. Press temperature + or temperature - to switch. After adjustment for 5 seconds, it will be automatically saved or press the [pause Cancel] key to save

Serial number	Project	Left gear	Parameter adjustment right ratchet tube	Remarks
1	Temperature adjustable	P001	100 °C ~ 230 °C adjustable	Adjust the parameters of this gear, and the lock temperature is 184 °C by default
2	Count not cleared count reset	P002	OFF ON	Factory default off, count not cleared
3	Cup sealing delay	P003	(0-50) adjustable	Indicates 0.5 seconds factory default 12
4	Cup feeding delay	P004	(0-30) adjustable	Indicates 0-3 seconds, factory default 10
5	Receiving time	P005	(0-99) adjustable	Indicates 0-9.9 seconds, factory default 25

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## ROUTINE MAINTENANCE AND REPAIR

- The following maintenance items must be carried out every day:
  - Check whether the upper film heating plate is clean every day to prevent foreign matters from sticking to the upper mold, resulting in poor sealing effect and failure to seal. After the heating plate is cooled, wipe it with a warm and wet cloth.  
**Note: before cleaning, turn off the power and pay attention to the high temperature.**
  - Clean the working platform every day, check whether the working platform and track are lubricated smoothly, and add guide rail oil in time.

FIG 13

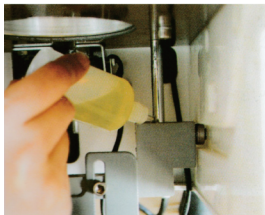


FIG 14

- The lower die groove shall be kept clean to prevent the upper die blade from contacting dirt.
- Keep the power in and out or microswitch clean and clean
- The blade must be washed every day (using the full-automatic washing force function)

- Other maintenance items and repairs

- The user shall actively cooperate with the after-sales service personnel for telephone guidance, and carry out relevant operation or maintenance according to the instructions
- The user shall contact the regional maintenance personnel and service personnel for handling

## COMMON PROBLEMS AND SOLUTIONS IN CUSTOMER USE

- Temperature display area, displaying "023"**  
Possible cause 1: the thermal sensing system is faulty  
Solution: check whether the connectors of the thermal sensing system are in good contact, or the hotter sensor (pay attention to chroma "+": during replacement).  
Possible cause 2: poor contact between the plug of the thermal sensor and the computer board  
Solution: replace the thermal sensor, or directly screw the measured copper wire to the computer motherboard with screws (pay attention to the red "+": when connecting)
- In the temperature display area, the display temperature greatly exceeds the set temperature, reaching more than 200 degrees, or even more than 250 degrees**  
Possible cause: the main board of the computer board is broken  
Solution: replace the computer board
- Fault code "E1"**  
Possible cause 1: The trigger plate on the guide pillar touches the upper switch, showing "E1". The plug of the upper switch is not properly inserted and loose  
Solution: clamp the upper switch plug and plug it again  
Possible cause 2: the upper trigger plate has been pressed to the upper switch, displaying "E1". Check whether the "R" trigger switch has been broken  
Solution: replace the upper switch with a new one  
Possible cause 3: the upper and lower motors do not move, indicating "E1", and the motor power cord plug is not tightly plugged into the computer motherboard  
Solution: open the rear cover, check the power cord plugs of the upper and lower motors, and plug them in again  
Possible cause 4: the upper and lower motors do not move, display "E1", and the motor is broken  
Solution: replace the upper and lower motors
- Fault code "E2"**  
Possible original 1: when the upper and lower motors are pressed to half, the alarm will display E2, the voltage is not enough 220V;

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Solution: add 300 watts,220V power supply voltage regulator as shown in the figure below, or connect a large capacity of 4.5U capacitor for voltage compensation

FIG 15



Possible cause 2: the upper and lower motors do not move, indicating "E2", and the motor power cord plug is not tightly plugged into the computer motherboard

Solution: open the rear, check the power cord ends of the upper and lower motors, and plug them in again

Possible cause 3: press the upper and lower motors to the lower switch position, and "E2" is displayed. Check whether the R-type lower switch has been damaged or broken

Solution: replace the lower switch

Possible cause 4: the upper and lower motors do not move, display "E2", and the motor is broken

Solution: replace the upper and lower motors

- Fault code "E3"**

Possible cause 1: the guide rail groove is not cleaned, and there are impurities such as syrup, so it needs to be cleaned and added with special lubricating oil

Possible cause 2: the guide rail groove is too tight and the side forcing screw needs to be loosened

Possible cause 3: the rocker arm is not in place, and the carry switch roller needs to move towards the outer plate, 1-2mm.

Possible cause 4: the carry switch signal line is short circuited, or the signal line plug is not plugged in well with the computer board, resulting in poor contact

Possible cause 5: the carry switch is broken and needs to be replaced

- Fault code "E4"**

Possible cause 1: the rocker arm is not in place, and the switch roller is out of position.

Possible cause 2: short circuit of out switch signal line, or poor contact between signal line plug and computer board

Possible cause 3: the out of position switch is broken and needs to be replaced

- Fault code "E51", sealing film has been rotating without sealing**

The sensitivity of the electric eye is too high and needs to be adjusted. Method: rotate the sensitivity knob clockwise or erase the dust of the electric eye.

Possible cause 1: there is too much dust at the luminous part of the electric eye bayonet, resulting in the red signal light always on

Solution: wipe gently with a wet and soft cotton cloth to remove dust.

Possible cause 2: the sensitivity of the electric eye is not correct

Solution: adjust the sensitivity of electricity. Refer to the instruction label on the right side of the machine.

Possible cause 3: whether the electric eye has electricity, whether a mouse bites off the power line or whether the electric eye plug is not tight with the main board of the computer board

- Fault code "E52", sealing film has been rotating without sealing**

Possible cause 1: The sealing film is not in the electric eye bayonet, resulting in the red signal light is not on

Solution: Put the sealing film into the electric eye bayonet.

Possible cause 2: The sensitivity of the electric eye is too low, so it needs to be adjusted.

Solution: Rotate the sensitivity knob counterclockwise

Possible causes 3: Whether the electric eye is powered, whether a mouse bites off the power cord or whether the electric eye plug is not tightly plugged into the main board of the computer board

FIG 16



FIG 17



FIG 18



After adjusting the position of the electric eye, make the sealing film cursor pass through the luminous spot of the electric eye

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FIG 19



FIG 20



Adjustment method of electric eye sensitivity

Use the attached white plastic slotted screwdriver (in the accessory bag) to rotate clockwise to weaken the sensitivity of the electric eye, and rotate counterclockwise to strengthen the sensitivity of the electric eye

Green light power lamp

Red light signal sensing lamp

- Sealing film can not be completely sealed, or sealed**

Paper cups cannot be securely sealed (but plastic cups can be completely sealed)

Solution: the sealing type is not correct, the sealing can only be plastic cup

Paper cups and plastic cups cannot be sealed (they could be sealed before, but appeared after changing a roll of sealing film)

Solution: The new sealing film is reversed, please remove the winding sealing film, turn the direction and reinstall

After a period of time, paper cups, plastic cups are not tightly sealed

Solution: Check whether there are impurities or sinter on the heating plate, and clean it with a warm and wet cloth

- The sealing film skips several patterns before sealing**

Possible cause 1: The sealing film is not in the electronic eye bayonet

Solution: Put the sealing film into the electronic eye bayonet

Possible cause two: There is too much dust at the glowing spot of the electronic eye bayonet

Solution: Lightly rub with a damp, soft cotton cloth to remove dust

Possible cause three: The sensitivity of the electronic eye is incorrect

Solution: Adjust the sensitivity of the electronic eye by referring to the instruction label on the right side of the machine

- As soon as the socket of the machine is plugged in, the sealing film rotates all the time before it is turned on**

The computer board is broken. Replace the computer board

- The machine cannot seal automatically. Press the "start" key to seal**

Possible cause 1: The automatic button is not turned on, and the automatic indicator is off

Solution: Long press the automatic button for three seconds to turn on the light

Possible cause 2: The long-needle sensor is faulty

Solution: Replace the long needle sensor

- The temperature does not rise, but always shows room temperature**

The heater power line is short circuited. Please check whether there is an open circuit and connect it properly

- When people touch the machine, there is static electricity (it feels like electric leakage)**

This is a normal motor induction, with more than ten volts, which will not harm the human body

Solution 1: connect the power plug to the ground wire to eliminate induced electricity

Solution 2: screw out the foundation screw of the machine and put on the metal wire, and then connect it to the metal incoming pipe or the stainless steel water bar

- The paper cup is flattened**

When the machine leaves the factory, it is debugged with a 500cc cup with the maximum capacity.

When using a high-capacity cup, it is necessary to adjust the size of the cup holder so that when the cup enters the machine, the cup leaves the cup holder

If you do not adjust the cup holder and use a 650-700cc cup, the cup will be flattened



FIG 21



FIG 22

- Paper cups can seal well, but plastic cups can't**

Possible cause 1: the temperature is too low

Solution: when sealing the paper cup, the temperature is relatively low, generally only 120-175 °C, and the plastic cup needs 175-190 °C, so it is necessary to increase the temperature to the applicable temperature of the plastic cup

Possible cause 2: the paper cup sealer (ring) is not taken out

Solution: generally, the caliber of paper cup is different from that of plastic cup. The caliber of paper cup is smaller than that of plastic cup. Just after sealing the paper cup, when sealing the plastic cup, take out the cup sealer (ring) from the access platform, otherwise the plastic cup will not be tightly sealed.

- The long steel wire of the long needle trigger switch does not rebound**

As a beverage flows into the long needle trigger switch, ignoring it for a long time causes the switch to stick

Solution: go to the local hardware store to buy rust removal lubricant and spray liquid to remove sugar

- The work platform in and out jitter**

The guide rail needs to be filled with guide rail oil (three parts: guide groove of stainless steel working platform, supporting cup, upper and lower guide columns, and bearing groove)

Especially the upper and lower guide posts of the two cup holders under the platform must be lubricated

Note: never add sewing machine oil

- When the cup is put in, the sealing film will not roll, or roll but make a "click" sound**

Possible cause 1: incorrect installation of sealing film

Solution: cut off the sealing film, reinstall it, install it according to the top schematic diagram, or check the installation instructions

Possible cause2: Roll but make a "click" sound

Solution: Roll film motor damage, replace the bad roll film motor

- The seal film logo pattern is not in the middle of the cup**

Due to the difference in the mark interval of film materials produced by various manufacturers in the market, the sealing film diagram may deviate. At this time, it can be adjusted through the following figure

(1) As shown in Figure 23, the sealing film deviates left and right when the cup is out, which can be adjusted by adjusting the position of the electronic eye

(adjust upward when it deviates to the left, figure 24)

(2) As shown in Figure 25, the pattern can be adjusted by adjusting the position of the plastic locating ring (using the Allen wrench of the accessory bag)



FIG 23



FIG 24



FIG 25

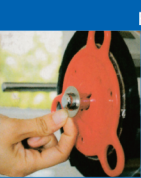


FIG 26

## COMMON ERRORS AND OPERATIONS IN USER USE

- The spring position of the right film winding rod (driven rod) is installed incorrectly or is not compressed (as shown in figures 27, 28, 29 and 30)

FIG 27



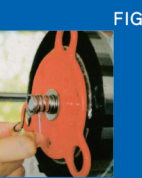
CORRECT

FIG 28



CORRECT

FIG 29



CORRECT

FIG 30



ERROR

- The sealing film is not placed in the U-shaped mouth of the electronic eye. (as shown in figures 31 and 32)

FIG 31



CORRECT

FIG 32



CORRECT

FIG 33



CORRECT

FIG 34



ERROR

- The cursor (small black square) on the sealing film does not pass through the light emitting position of the electronic eye (as shown in figures 33 and 34)

- The sealing film does not pass through the film lifting rod of the upper die (as shown in figures 35 and 36)

FIG 35



CORRECT

FIG 36



ERROR

- The plastic locating ring on the left film winding drum was manually moved

- The clamping plate notch of the waste film drum is not clamped into the driving rod locating ring screw (as shown in figures 37 and 38)

FIG 37



CORRECT

FIG 38



ERROR