



VT-109

TRAY SEALER PACKAGING MACHINE

Operation Manual

Version 6.9.1

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S/N:

QC SIGNATURE:

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1. PRODUCT FEATURE

- 1) The Machine body is Stainless in nature.
- 2) Using PLC control , uneasy to be broken.
- 3) Safe,saving electricity ,long-life,easy to clean.
- 4) A wide variety of container of different size and material can be used.
- 5) Production of machine can be designated according to the container size acquired by individual customers.

2.SUITABLE APPLICATION

- 1) Packaging of various fresh,moisture,frozen and microwave products.
- 2) Packaging of various take away products for restaurants.
- 3) Humidity resistive packaging of products for lab,factories of all kinds.

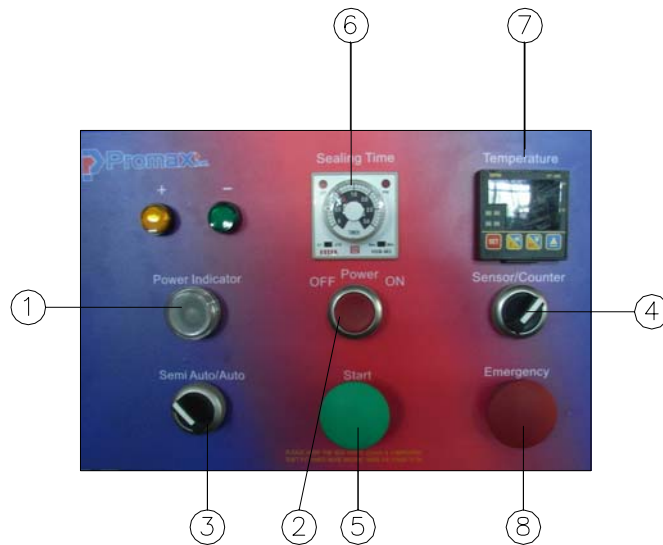
3.MACHINE DIMENSIONS

- 1) Machine model:VT-109
- 2) Electricity usage :AC110v/60Hz or AC220V/50Hz.
- 3) Electricity consume rate: 450W.
- 4) Machine dimension: 350 x 540 x 640 mm.
- 5) Maximum container size : 220 x 170 x 100 mm.

4.SAFETY / WARNINGS

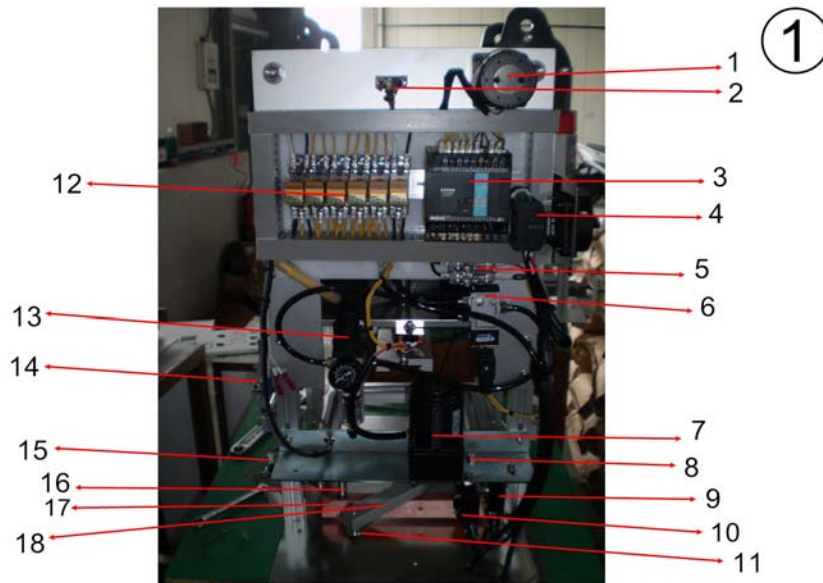
- 1) Please read the operation manual before usage.
- 2) Please read the safety and warnings section before usage.

5. OPERATIONAL PROCEDURES

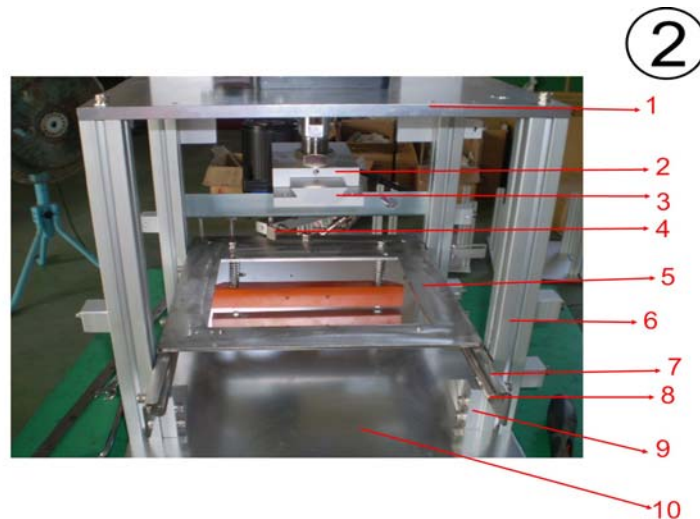


- 1) Power indicator: indicating the power in online or off line.
- 2) Power off/on: press power key to start up the machine. after displaying the “PO” pattern, the machine begins to service you
- 3) Semi auto/auto choice key: provide you to select either semi automatic or automatic sealing operation. if auto is selected then after the cup is settled, the machine is automatically doing sealing process, otherwise the machine is waiting for pressing the semi automatic key to go on sealing process.
- 4) Electric sensor/counter: displays counted number, parameter setting. symbol .
- 5) Start: the key for manual operation start button
- 6) Sealing time: showing the sealing time.
- 7) Temperature: showing the temperature of top mould.
- 8) Emergency: push this button to stop the operation.

6.PARTS

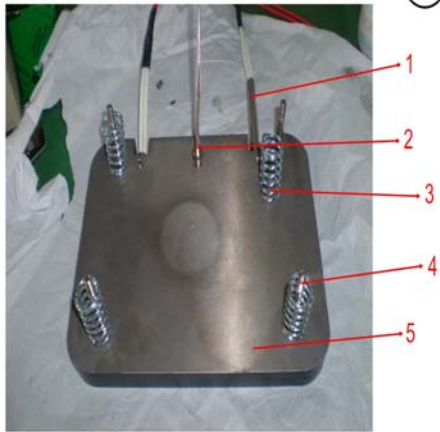


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|----------------------|------------------------|----------------------|
| 1. Filmwind-up Motor | 7. In/Out Motor | 13. Regulator |
| 2. Capacitor | 8. Bolt | 14. Film sensor |
| 3. PLC | 9. Back Limit switch | 15. Counter sensor |
| 4. Power switch | 10. Front Limit switch | 16. Bakelite rod |
| 5. Fuse | 11. In/Out shaft | 17. Bakelite |
| 6. Valve | 12. Relay | 18. Motor in/out rod |

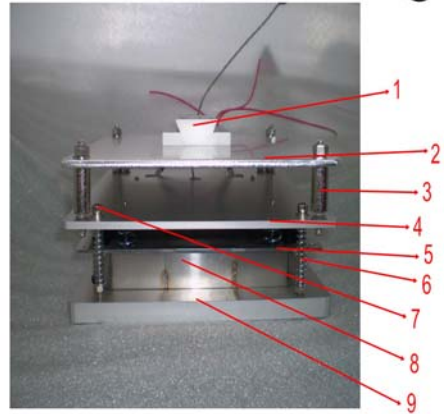


- | | |
|----------------------------|-------------------|
| 1. Frame top plant | 6. Mast |
| 2. Mold salver(top) | 7. L plant salver |
| 3. Mold salver(bottom) | 8. Salver rod |
| 4. Fixed plant bottom mold | 9. Fixed mount |
| 5. In/out salver | 10. Frame bottom |

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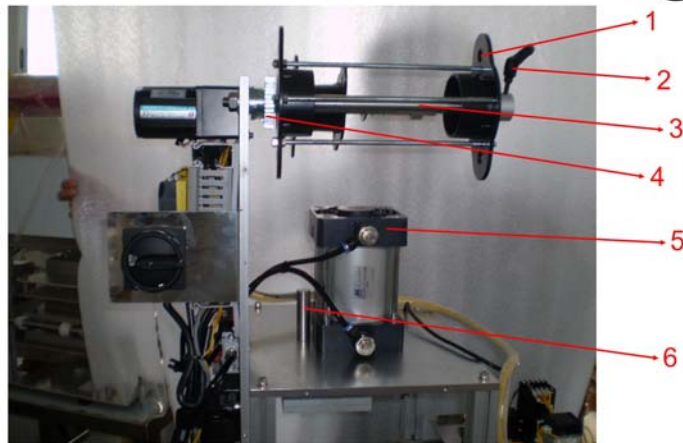


- 1. Heater
- 2. Temperature sensor line
- 3. Spring
- 4. Bolt
- 5. Heat slice fixed plate

- 1. Mold salver(bottom)
- 2. Mold top plant
- 3. Mold mast
- 4. Mold bottom plant
- 5. Mold knife

- 6. Spring
- 7. Bolt
- 8. Cutter mount
- 9. Mold fixed plant

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- 1. (VT1090501) Frame
- 2. (VT1090502) Frame fixed bolt
- 3. (VT1090507) Shaft
- 4. Gear
- 5. Cylinder
- 6. Fixed shaft

7.AVOIDANCE

- 1) Check the alternating current (AC) before plug in.
- 2) Do not use multi-outlet or extended-outlet with other electric appliances when using .
- 3) Follow the operation manual procedure in order to avoid misuse of machine that results in injury and damage to the machine.
- 4) Keep the lip of the cup clean to avoid bad sealing quality.
- 5) Keep away from infants and children to avoid danger when using.
- 6) Keep heating board clean to assure the quality.
- 7) Do not disassemble the machine by any circumstance or seller does not take the responsibility.
- 8) Do not use containers or films that was not approved by the seller.
- 9) Only when the power plug is pulled off from the wall, otherwise do not put your hand into the machine in order to avoid any accidents.

8.USER MAINTENANCE

- 1) The following points must be taken care of by the user in daily maintenance of machine:
 - Check the upper mould and clean by wet cloth or rough plastic brush. If not, the dirt will stick on the heating plate affecting the quality of sealing.
 - Keep both sides of slider and those fixed under the lower mould plate clean and lubricated, if not , the input and output of the lower mould operation will not be smooth
 - Clean the groove of the lower mould
 - Clean the jack system. (jack slider , spring roller, bearing etc), keep it operate smoothly
 - Clean the film sensor and lower mould in-out sensor
- 2) Monthly check point: take off the rear outside case, check the air pressure controller, if the lubricant oil is lower than 50%, please increase the oil again.(NO. 45 engine oil).the process is:
 - Turn off the air control valve which fixed on the air compressor.

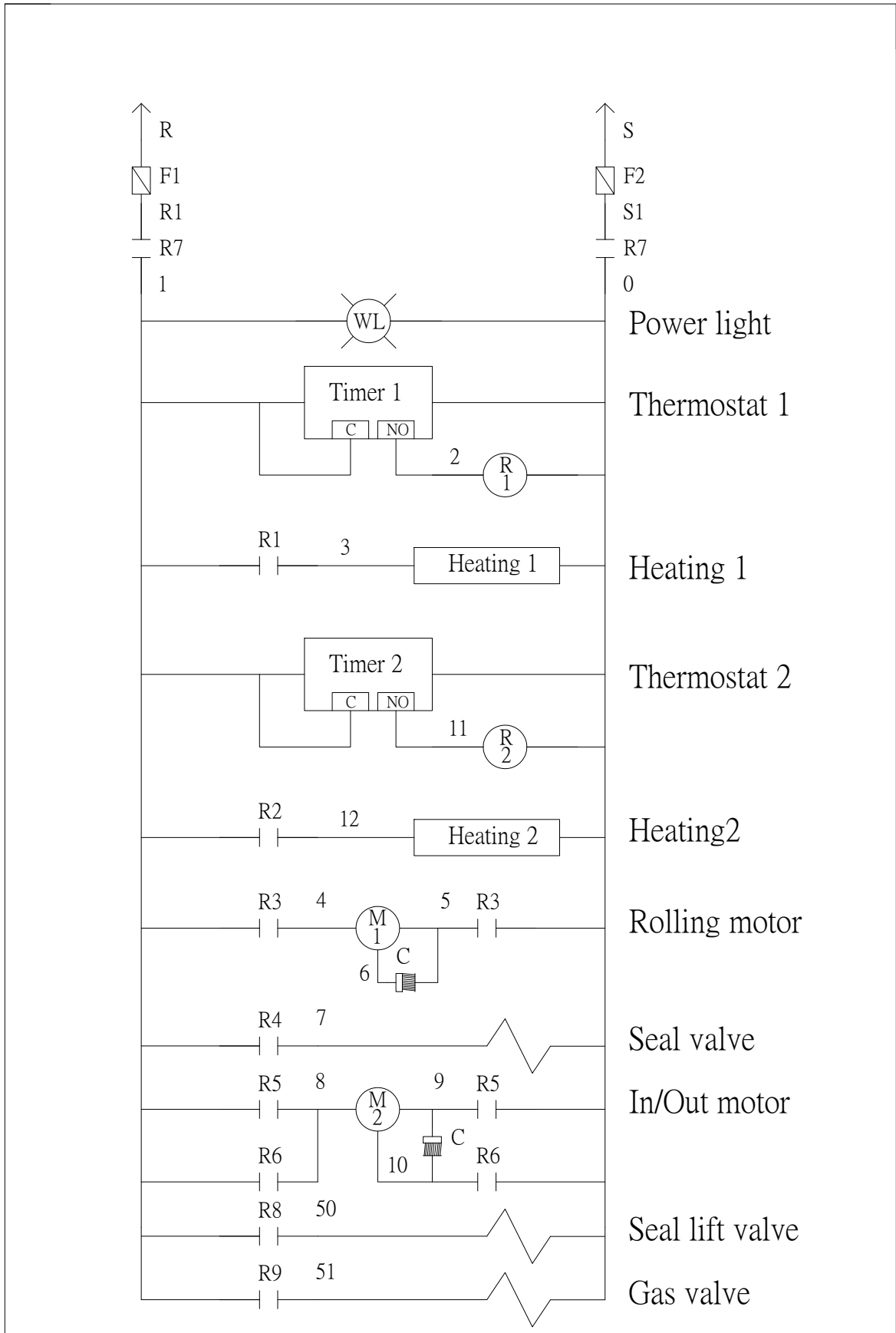
- Use hand to push up the air output valve, let the air leak out and release the air pressure totally.
 - Loosen the auto-lubricator, and re-fill lubricant oil.
- 3) Other things to be checked or maintained: the operator of the machine may contact the repairing agent in their area or co-operate with the repairing agent's explanations while fixing up the problem him or her self.

9. TROUBLE SHOOTING

<u>PROBLEM</u>	<u>POSSIBLE CAUSE</u>	<u>REMEDY</u>
Film Surface Not Smooth		
	Film and container incompatible	Be sure you are using the same film material as the material of the container
	Residue on the mold	Use a damp cloth or plastic brush to clean the mold
	Sealing time too short	Increase sealing time
	Temperature too low or high	Adjust temperature
	Top mold knife is dull	Clean or change the knife
	Debris in top mold cavity between knife & heating plate	Eject the top mold and clean obstruction from the cavity
Sealing Plate Does Not Heat		
	Heating wire damaged	Mend any break in the wire
	Heating plate cracked	Replace the heating plate
Film Imprint is Not Centered on Container		
	Imprint is too far front	Move the film sensor up
	Imprint is too far back	Move the film sensor down
Sealing Film Displaced After Rotation		
	Dust on film sensor	Clean the film sensor window
	Electric eye on too long	Turn film sensor clockwise to increase its sensitivity
	Faulty film sensor	Replace film sensor
Sealing Film Rotates Continuously		
	Sensor unable to detect film	Thread film through film sensor
Upper Mold Stays Down During Operation		
	Micro switch not responding	Move upper micro switch down so it contacts plate
	Faulty micro switch	Replace micro switch
	Faulty contact	Repair connection
Upper Knife Cutting Container Edges		
	Base mold not contacting safety door	Move base mold micro switch back
	Base mold unable to spring back from safety door	Move base mold micro switch to front
	Upper mold position incorrect	Remove the 2 screws securing upper mold in place; align upper mold with lower mold and reset screws.
Base Mold Does Not Retract		
	Faulty micro switch at rear of base mold	Replace faulty micro switch.

Upper Mold Does Not Descend		
	Faulty micro switch or wire connection to micro switch	Repair or replace as needed
Base Mold Does Not Eject		
	Faulty micro switch or wire connection to micro switch	Repair or replace as needed
	Bearing off track	Turn off machine & push base mold bearing into place.
	Debris in base mold bearing track	Clean / brush away any accumulated in track and around bearing and lubricate with oil
Faulty Safety Door		
	Faulty safety door micro switch	Repair or replace as needed

10 ELECTRICAL DLGRAM



10 ELECTRICAL DIAGRAM

