

USER MANAUL

VACUUM PACKING MACHINE

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1 . Product Use

This machine is mainly applied to seal composite film or aluminum foil composite film packaging materials. The solid, liquid, powder, paste and other properties of objects can be vacuum packed even insert gas by this machine. After vacuum packaging, products can be prevented oxidation and mildew, food can be kept fresh and prolong its shelf life, for some items, it can effectively reduce the appearance size, easy to transport and storage. It can be widely used in food, medicine, electronics, chemicals and other field, one of the best choice for factories, shops, service industry and so on.

2. Features

Vacuum machines are controlled by a low voltage PCB, it is safe, reliable, simple operation and easy maintenance. Vacuum chamber and the body is made of high quality stainless steel, with good sealing performance, and nice appearance. Vacuum sealing, printing processes in one operation. Workers can set vacuum, sealing temperature, sealing time, cooling time to accommodate different packaging materials and packaging requirements. It equipped a printing device also, after sealing, it can printed expiration date, date of manufacture, serial number and other text on the sealing line.

3. The main structure and working principle

3.1 The main structure

Body, the upper and lower vacuum chamber, upper cover, electrical control systems, heating systems, vacuum pumps, panel.

3.2 Principle of operation

When the power is switched on, press down the upper cover, the limit switch will be touched, then solenoid valve and vacuum pump start to work. When vacuum reaches a predetermined value, the vacuum pump to stop working, the vacuum chamber and the airbag are in the state of negative pressure. Now the air valve will be opened, the air goes into the airbag, the airbag swell and attach the heating device to the silicon rubber, meantime the heating wire is heating up to complete sealing. Valve open again, upper cover open automatically to complete the work.

4 . Main models and technical parameters

| Model | TT-Z01A | TT-Z03A |
|------------------------------------|-------------|--------------------|
| Voltage and power V/W | 110/220V | 110/220V |
| Sealing size mm | 8X255 | 10X500 |
| Sealing type | Single seal | Single/double seal |
| Pump capacity m ³ /h | 14.4 | 20 |
| Chamber size mm | 387X295X50 | 525X525X100 |
| Dimension mm | 495X350X420 | 630X620X460 |
| Weight KGS | 36.5 | 105 |

Description: DZ is a desktop series, for example: DZ400/B/C/Q, means desktop, double sealing, sealing and cutting, with gas insert. DZQ floor type series, for example: DZQ400/B/Q, means floor type, double sealing, with gas insert. DZQ/2SA is a double chamber series, for example: DZQ500/2SA/Q, means a double chamber with gas insert.

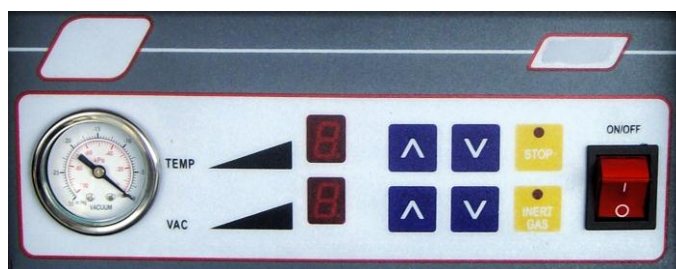
We also accept customized machine, please discuss and confirm with our sales and technicians. The machine parameters and function will be different from different requests, please refer to the actual subject.

5. Electrical schematics

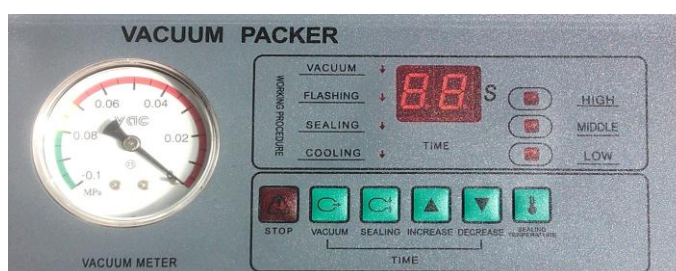
6. The use of Method

6.1. Control panel

6.1.1.DZ325/DZ250/DZ300A/DZ450 control panel。



6.1.2.DZ300B control panel



6.1.3. Other model control panel



6.2. Get ready to work

6.2.1. The machine should be placed horizontally, the room must be well ventilated, non corrosive gas and few of dust.

6.2.2. Access to power supply, and make sure the power supply adapt the machine voltage setting. The machine must be reliably grounded, ensure safety.

6.2.3. Before working, vacuum pump oil level should be 3/4 of view window. If the oil level less than 1/2 view window, you should fill the vacuum oil up to 3/4. Oil level too high or too low will affect the pump working and life time.

6.2.4. The client must set the heating time and temperature according to the thickness of the material. If you are not sure about the time and temperature setting, please test from low to high step by step, otherwise the heating element and teflon cloth will be burnt.

6.3. Operation Method

6.3.1. Control panel operation method.

6.3.1.1. turn on the power, the digital panel shows "-- --", machine is standing by.

6.3.1.2. press "v" or "∧" adjust the vacuum time, range from 0-9, every step is 3 seconds, for example "1" means 3seconds, "2" means 6seconds.

6.3.1.3. press "v" or "∧" **adjust the sealing time**, range from 0-9, every step is 0.3 seconds, for example "1" means 0.3seconds, "2" means 0.6seconds.

6.3.1.4. All of the data above, once set, the computer will automatically save.

6.3.2. DZ300B and other model control panel operation method

6.3.2.1. turn on the power, the digital panel shows "-- --", machine is standing by.

6.3.2.2. press vacuum button, then press ▲ and ▼ to adjust the vacuum time, range is 0-99seconds.

6.3.2.3. press flashing button, then ▲ and ▼ to adjust the gas insert time, range is 0-99seconds.[only available to the machine with gas insert function]

6.3.2.4. press sealing button, then ▲ and ▼ to adjust the sealing time, range is 0.1-9.9seconds.

6.3.2.5. press cooling button, then press ▲ and ▼ to adjust the cooling time, range

is 0-99seconds.

6.3.2.6. Press temperature, every time you press the button, the indication light will be activated from low to middle to high.

6.3.3. All of the data above, once set, the computer will automatically save.

6.3.3..put the empty bag on the sealing bar and buckle the bag with the steel rod. Press down the upper cover, the pump start working. When the vacuum is finished, the sealing bar will seal the bag. Upper cover open, the whole work is done.

6.3.4. If there is any accident during the working, please press stop, the machine will stop working and open the upper cover.

7. Common Faults and exclusion method

| Failure | Cause | exclusion method |
|--|--|---|
| Can not vacuum | ①contactor is damaged ②power is not linked ③limit switch is damaged or didn't touch | ①change contactor ②check power links ③change or adjust the limit switch |
| Vacuum is not good enough | ①Vacuum pump reverse working ②some connection is loose ③air leaks in air bag or vacuum chamber ④seal ring damaged ⑤vacuum time is not long enough | ①check ②check and change ③check and change ④change the seal ring ⑤adjust the time |
| Upper cover can not open automatically | Valve is damaged | change |
| Can not seal | ①temperature is not set ②temperature setting is too low ③transformer is damaged ④element is damaged ⑤contactor damaged ⑥relay is damaged ⑦bad connection | ①re-set ②re-set ③check and change ④check and change ⑤check and change ⑥check and change ⑦check and change |
| Bad sealing | ①air leak in airbag or the seal valve is damaged ②sealing temperature and time is not well matched ③dust on the sealing bar | ①check or change the air bagg ②adjust ③clean up ④clean up |

| | | |
|---------------------|--|--|
| | ④sealing bar is locked ⑤teflon cloth is finished ⑥heat element is finished | ⑤change the teflon ⑥change the heat element |
| Smoke after sealing | ①greasy dirt on the sealing bar ②sealing temperature and time over too much | ①clean up ②adjust time and temperature |
| Programe problem | ①PCB is damaged ②PCB cable is loose | ①check and change ②check and link again |

8. Maintenance and precautions

8.1.maintenance

8.1.1.Regularly check the vacuum pump oil level , if less than 1/2 , must refill the vacuum oil (the general use of vacuum pump oil in compliance with SH0528-92

standards. Vacuum pump oil temperature using ISO-VG100 viscosity grade at 10 °C

-40 °C, vacuum pump oil temperature using ISO-VG32 viscosity grade at 0 °C

-10 °C.

8.1.2.It is suggested that the first work is full 150 hours to change the oil, after that every 500 working hours pls change the oil. Oil filter should be replaced also.

8.1.3.Regularly check the machine screw, if loose, immediately fastening. Check the rotation shaft, vacuum chamber spring activities parts is flexible, if there is any block, please add lubricating oil.

8.1.4. Check the heating element and teflon cloth from time to time, change the new parts at once when you find any problem.

8.2.precautions

8.2.1.Must be grounded before using the machine, as this may lead to personal injury.

8.2.2.Read this manual and instructions before working.

8.2.3.When the machine has just completed work, sealing part is prohibited to touch or it may hurt you.

8.2.4.When the machine is ready to work, no hands or other objects placed on the sealing bar, otherwise you may damage or affect the machine work and hurt yourself.

8.2.5.When the machine is under installation and maintenance, please disconnect the main power supply to protect the personal safety

8.2.6.The machine is not used in a long time, you should cut off the main power supply and exhausted oil, clean the pump, refill new oil and storge in a dry place.

9. Parts list

| name | size | quantity |
|-------------------|------------------------|-----------------|
| Vacuum oil | 500ml | 1bottle |
| Seal ring | According to the model | 1pc |
| Heat element | According to the model | 2pcs |
| Teflon cloth | According to the model | 2pcs |
| Letter and number | According to the model | 1box |
| Teflon tape | According to the model | 1roll |
| docs | manual | 1pc |

Note: real quantity and sizes will be according to the actual subject