1.Home page

Turn to Subpages

Run window

Speed: `###` b/min Length: `###` mm

Feed position: `###` mm Film position: `###` mm

Un track **Back**

2.Speed

How many bags per minute

3.Bag length

The bag length out of packing film

4.Feed Position

The location of the product in the packaging film,it will affects the knife cutting into the middle of the two bag products directly.
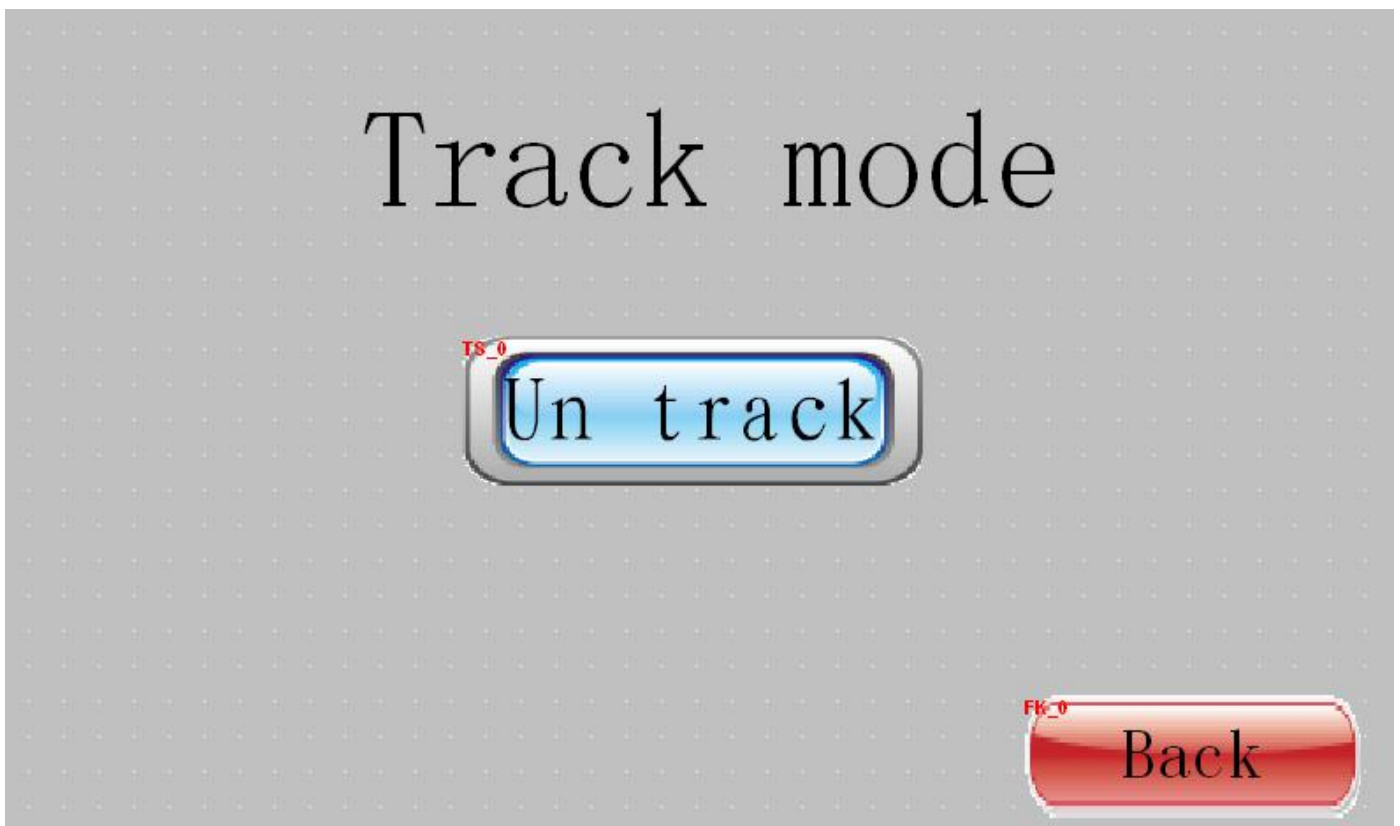
5.Film Position

The position which the knife cutting on the film, the parameters can be adjusted to make the knife cutting on the Color Mark on the film.
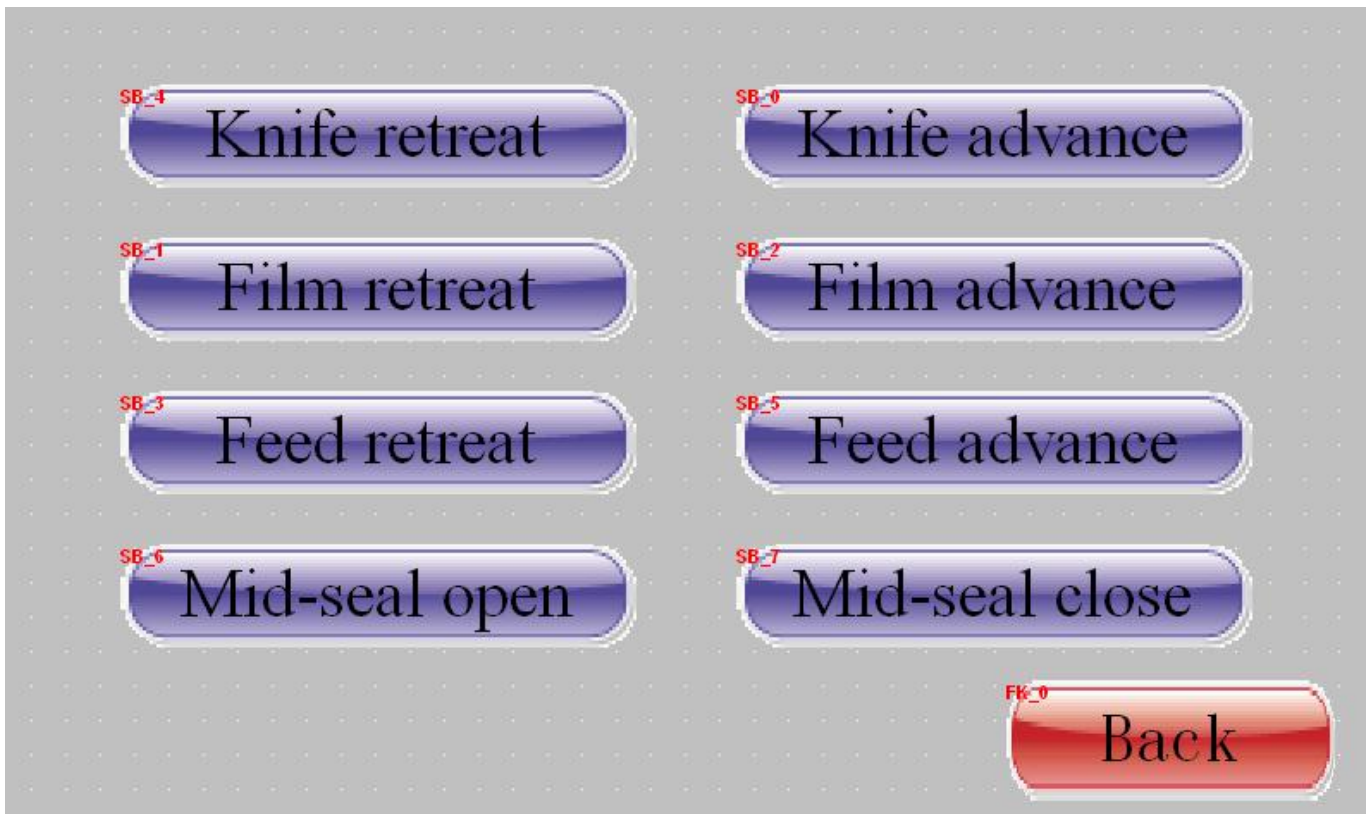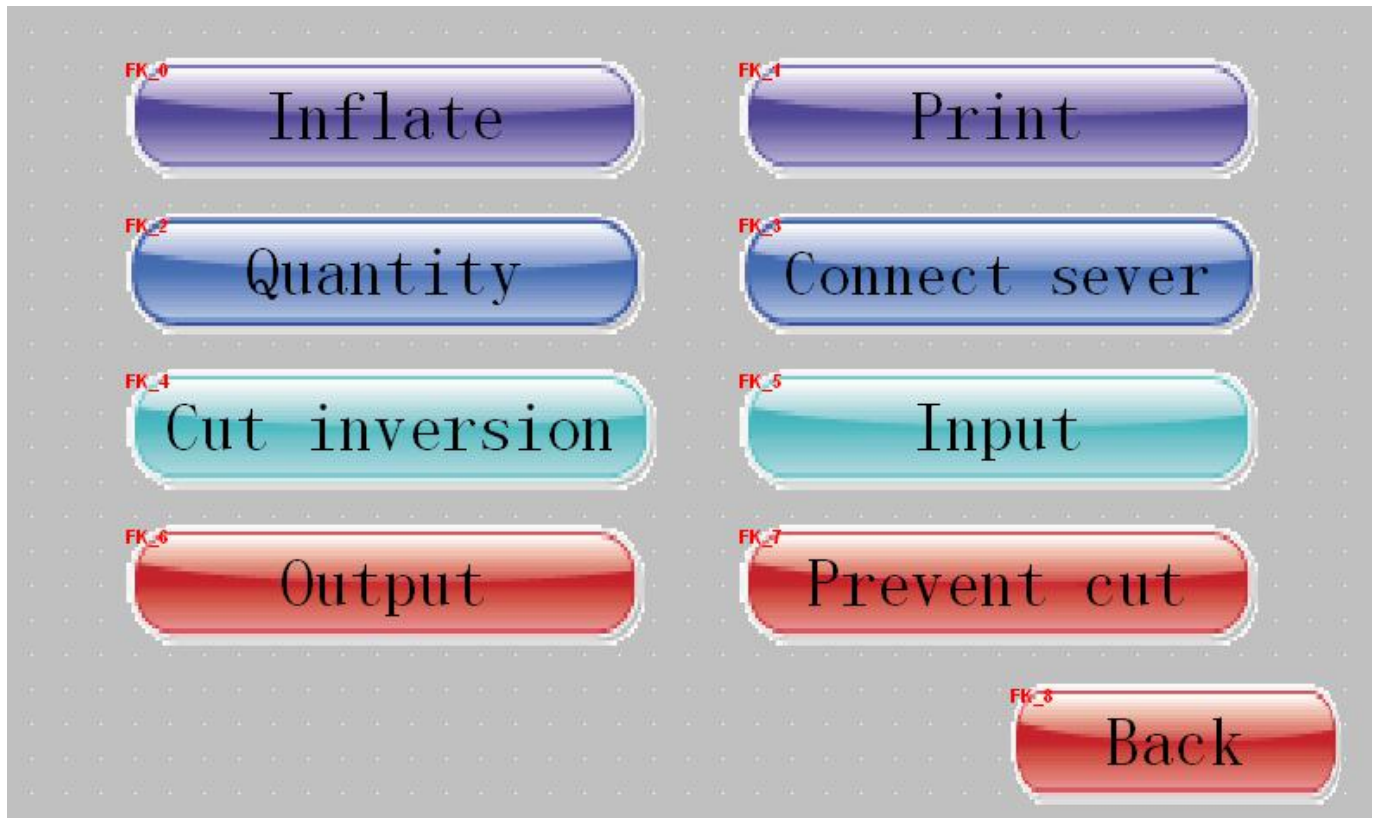
6.Manual operation

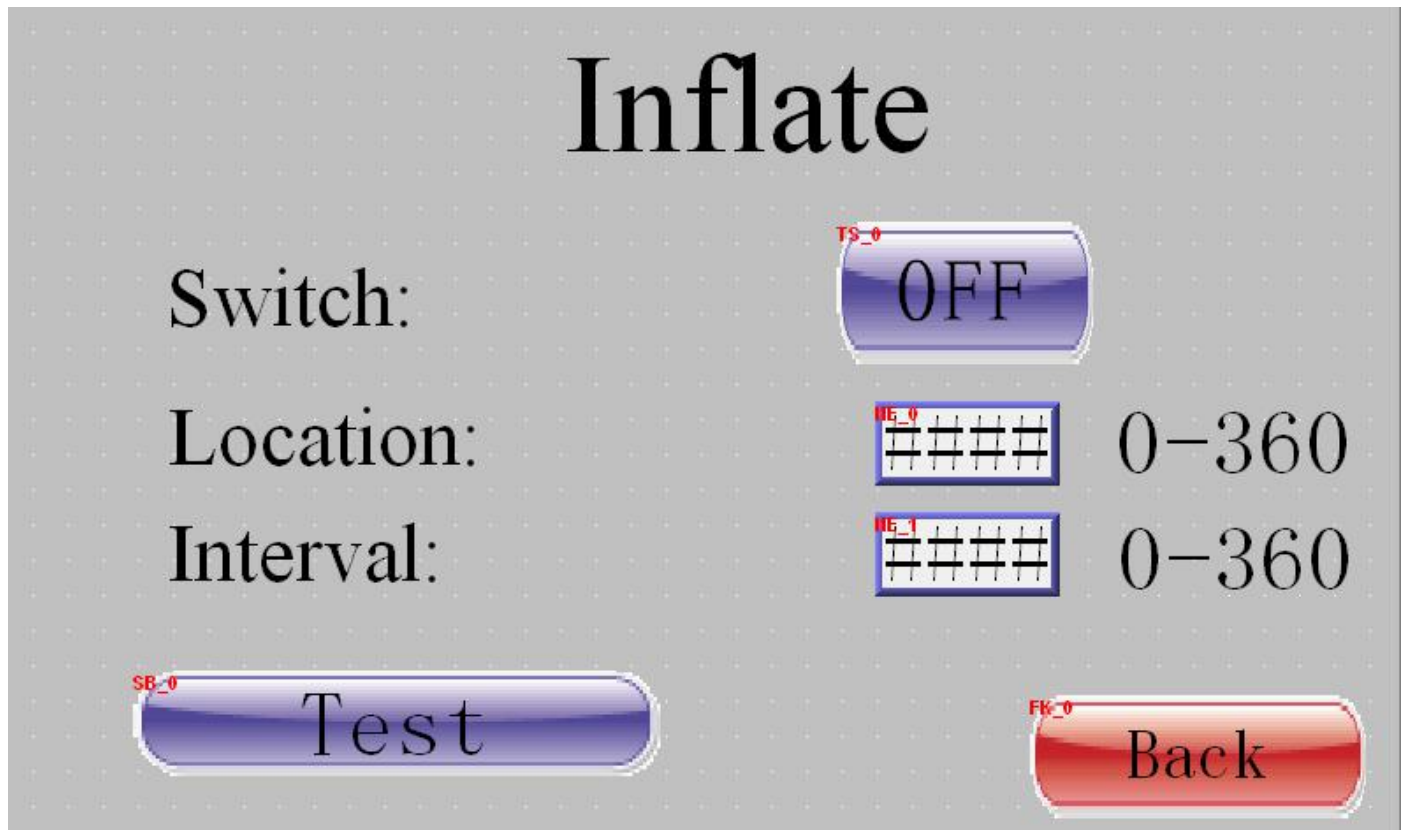Step by step according to Shows

7.Track mode

There are two ways to running the film for packing the bag. One is fixed bag length which setting by yourself. Another is tracking bag length, which is tracking the film dots by the electric eye,it can be adjusted to cutting on the right film dots through Film position.

8．Other functions

Auxiliary functions of packaging machine

Inflate

Switch: TS_0
                           OFF

Location: NE_0
                 ####   0-360

Interval: NE_1
                 ####   0-360

SB_0
        Test   FK_0
                                    Back

9．Inflate Air

Inflatable position between 0-360, recommended around 220, Inflatable interval between 0-360, recommended around 10, inflatable test can test whether inflation is normal

Print

Switch: `TS_0` OFF

Location: `NG_0` ####   0-360

`SB_0` Test   `FK_0` Back
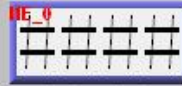
10. Code Print

Set the location of the code between 0-360, according to individual

requirements set, you can click the code test, to test code signal.

11．Quantity

The number of quantitative packages can be setting,packaging to the specified number,then the machine stopped.

BL_0 🟢	X0 Electrical eye	BL_8 🟢	X8 Inching button
BL_1 🟢	X1 End-seal origin	BL_9 🟢	X9 End-seal alarm
BL_2 🟢	X2 Feed origin	BL_10 🟢	XA Film alarm
BL_3 🟢	X3 Feed A posture	BL_11 🟢	XB Feed alarm
BL_4 🟢	X4 Feed B posture	BL_12 🟢	XC Empty eye
BL_5 🟢	X5 Start button	BL_13 🟢	XD Prevent cut eye
BL_6 🟢	X6 Stop button	BL_14 🟢	XE
BL_7 🟢	X7 Emergency stop botton	BL_15 🟢	XF

FK_0 **Back**   FK_1 **Output**

BL_0 🟢	Y0 End-seal pulse	BL_8 🟢	Y8 Alarm clear
BL_1 🟢	Y1 End-seal direction	BL_9 🟢	Y9 Inflate
BL_2 🟢	Y2 Film pulse	BL_10 🟢	YA Print
BL_3 🟢	Y3 Film direction	BL_11 🟢	YB
BL_4 🟢	Y4 Feed pulse	BL_12 🟢	YC
BL_5 🟢	Y5 Feed direction	BL_13 🟢	YD
BL_6 🟢	Y6 Make prepare	BL_14 🟢	YE
BL_7 🟢	Y7 Mid-seal control	BL_15 🟢	YF

FK_0 **Back**   FK_1 **Input**

12．Input / output monitor

Input and output monitoring can display the input and output state, and to determine the electrical fault
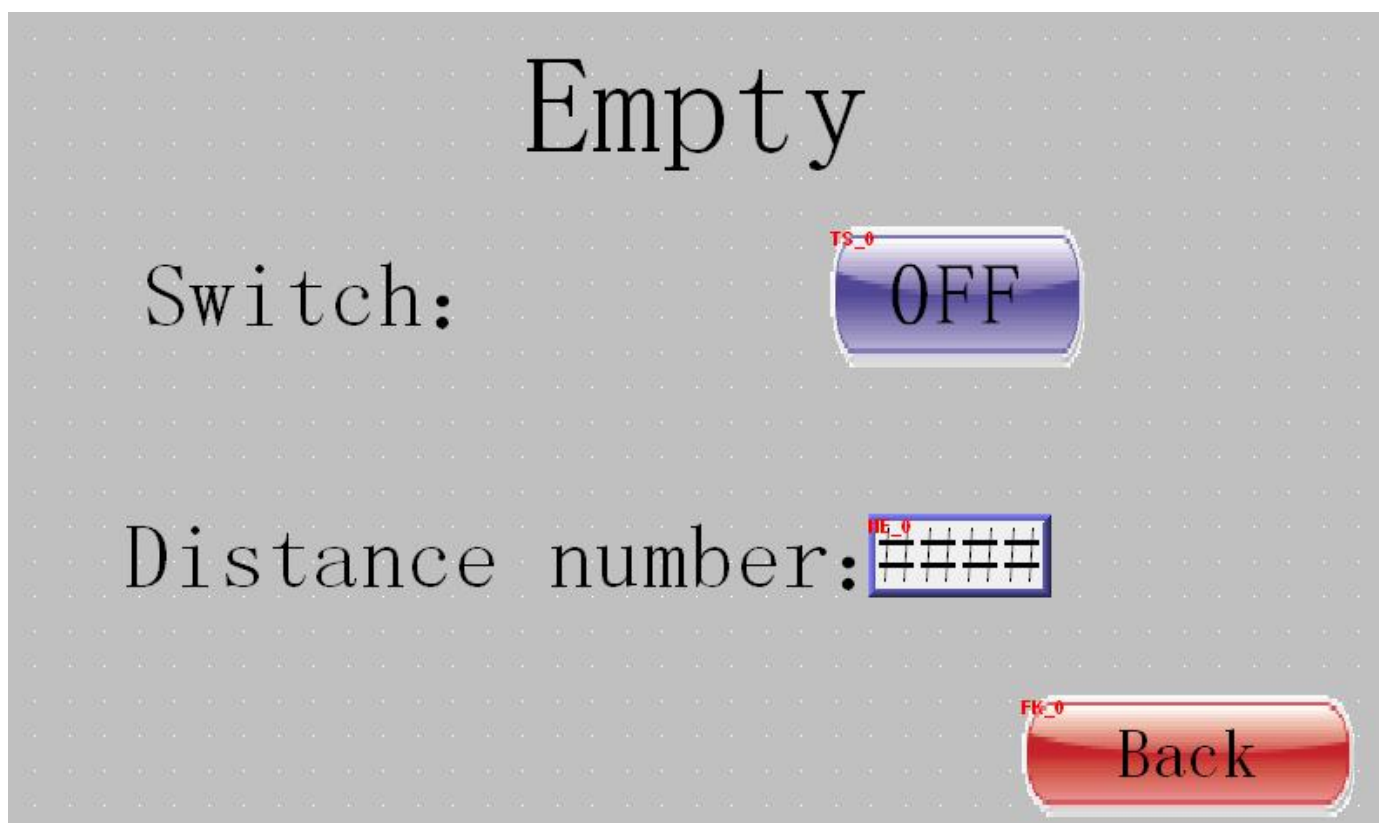
13. Empty packing

In order to prevent the empty bag, and save film material, it needs an electronic eye detector on the feeding frame,combined with the perspective position of the cutter knife stopped completely on the packaging film, it would be better to detector the product only by one signal, or the empty bag will be happened.

14．Prevent cutting products

To prevent cutting the product , it needs to installed electric eye on the detection station near knife, anti cutting position is confirmed after finish adjusting feed position, the machine can be normal running, then move to the middle of two products by Inching, after confirmed, the distance of two products is used to detect cutting and make alarm to stop, the longer the distance, the more protective will be sense, just let don't cutting products.

Cut inversion

Inversion switch: `OFF` TS_0

Run again switch: `OFF` TS_1

`Back` FK_0

15. Cut inversion or say Cutting reversal

Automatic reversal when cutting products, you can choose only to reversal when cutting product, or you can choose to reversal and then running again.

Total time: ########## min

Total output: ########## bag

Shift output: ########## bag clear

Back
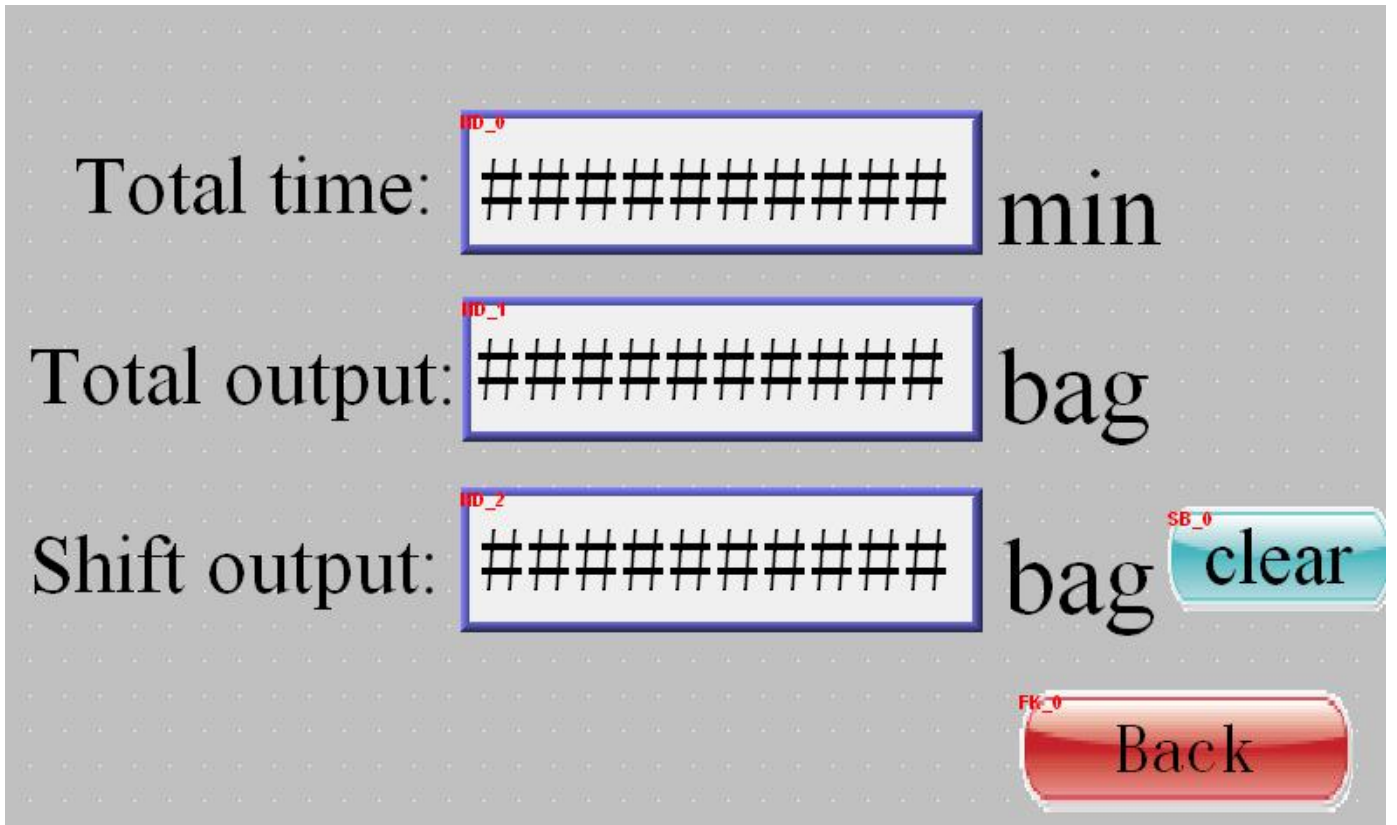
16．Counting

The total running time, total output, unit output (total time, total output, no return to zero after power failure. But unit output to zero after power failure).

Knife ratio: ####   Feed ratio: ####

Knife diameter: ####   Feed roller diameter: ####

Film ratio: ####   Knife operational error: ####

Knife accelerate compensation: ####   Film operational error: ####

Back
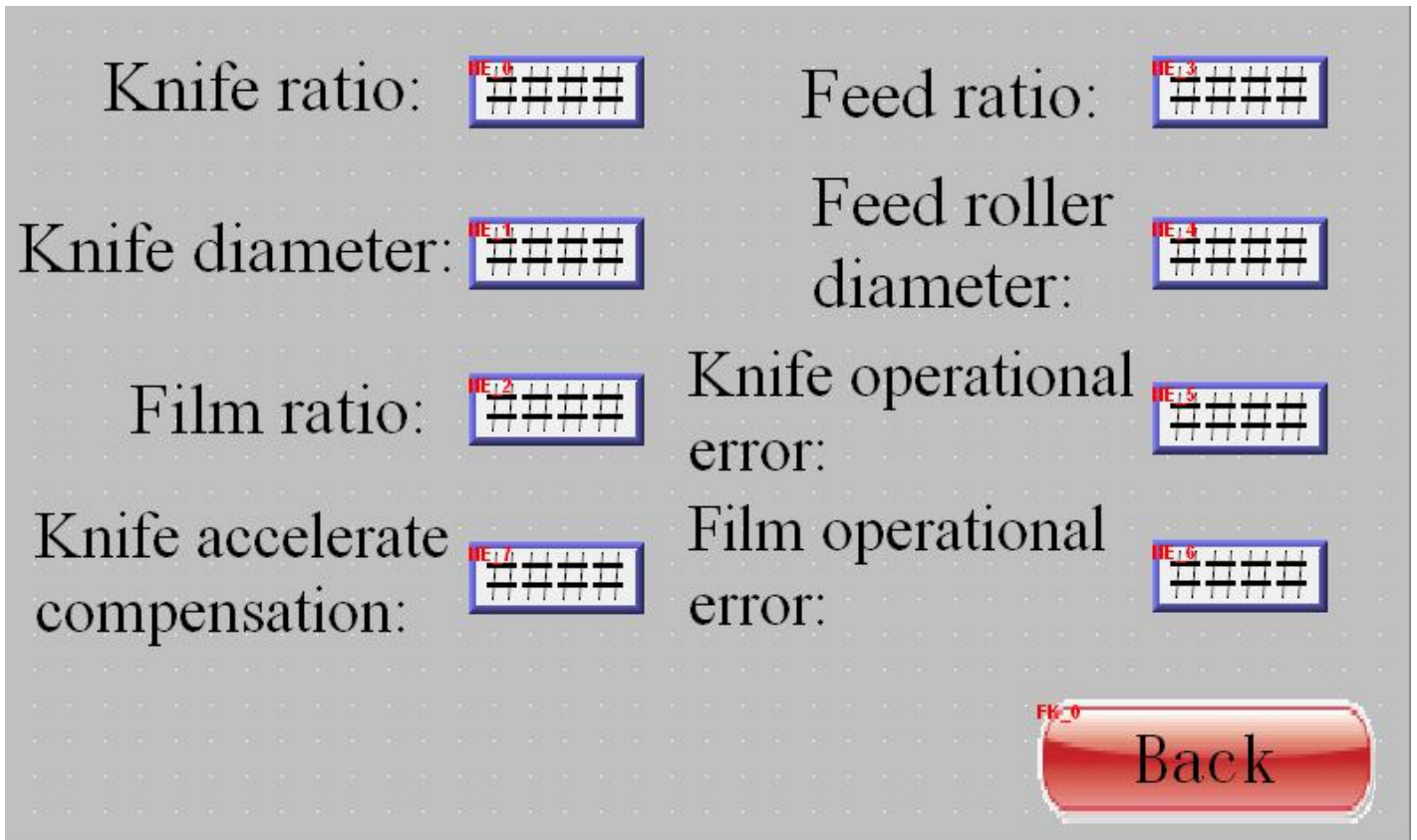
17．System parameters（The parameters have already been setting, please don't change the parameters without changing the mechanical parts ）

1.Knife ratio, that is, the knife go one around,How many turns of servo motor go around . 2 Knife diameter, that is, the center distance of the two film axis.3.Film ratio, the paper roller to go a circle, how many laps servo motor goes.4. Machine tail frame transmission ratio, the tail drum to take a lap, servo motor to go how many laps. 5.Machine tail frame pitch, tail frame pitch length, here is the product level adjustment range.6. knife acceleration compensation, knife operation error, film operation error, according to the factory settings is ok, this is also the PLC data acquisition, and operation will produce a certain error, given a certain operation difference

Synchro angle: `####`   Knife inching: `####`

Cut speed ratio: `####`   Film inching: `####`

Stop position: `####`   Feed inching: `####`

Start speed: `####`

Accelerate rate: `####`

Back
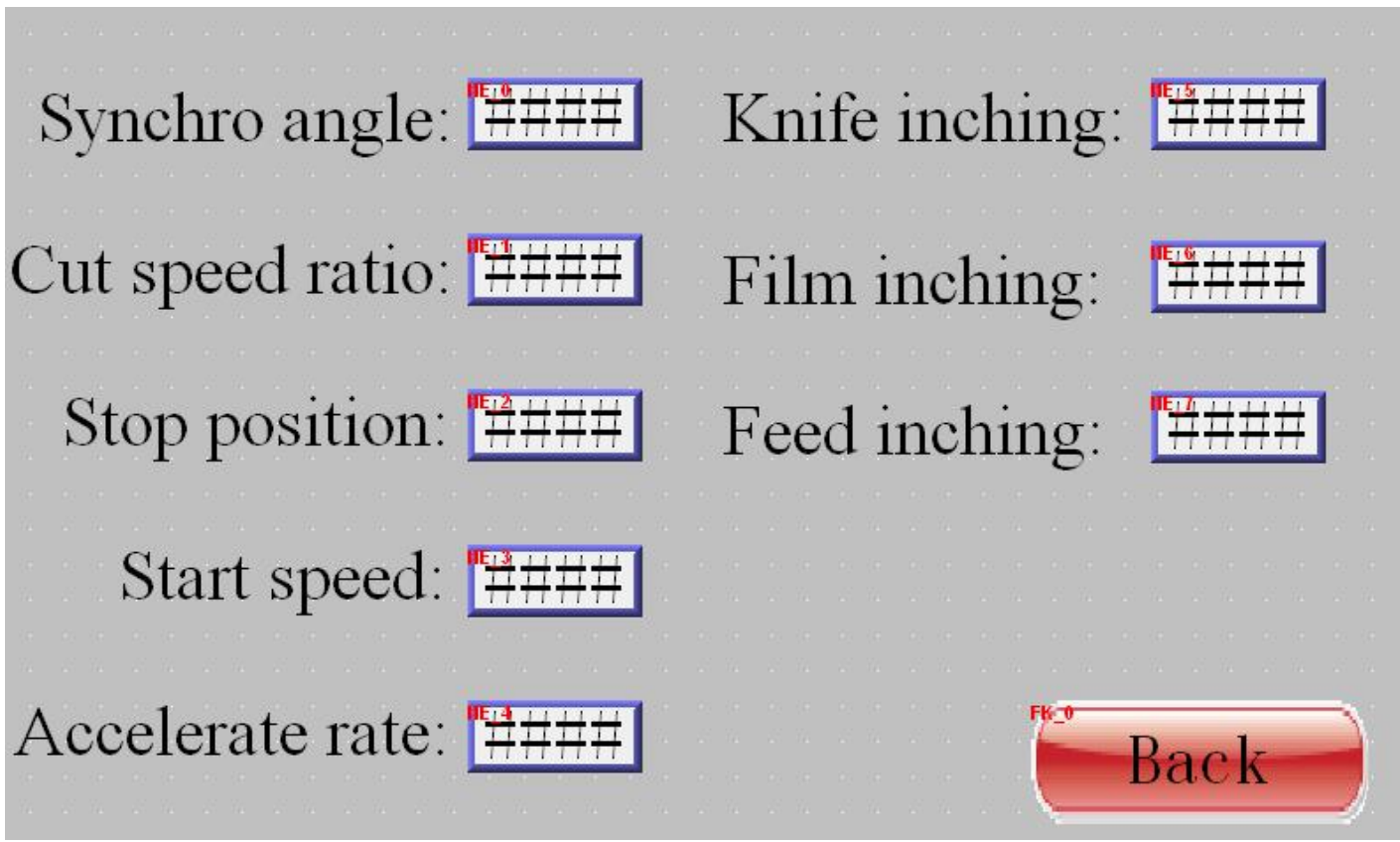
18．Parameter setting

1.Synchronous angle, knife cut film need to synchronize, then there is a synchronous angle to ensure synchronization (generally set 60).   2.knife speed ratio,the cutter pulling film adjust to small, film fouling tune, 60-150. 3 Knife inching, pulse speed of knife manual operation. 4 Film inching, pulse speed of film manual operation. 5 product inching, the pulse speed of product manual operation. 6 starting speed, speed and starting point of packing machine. 7 acceleration rate, packaging machine from the start speed to the speed of running speed, the larger the number, the slower the acceleration.

Cut servo malfunction!

Press Emergency stop button clear

Feed,film servo malfunction!

Press Emergency stop button clear

Emergency stop button was pressed!

Approach switch error!

Back

Feed encode error!

Back
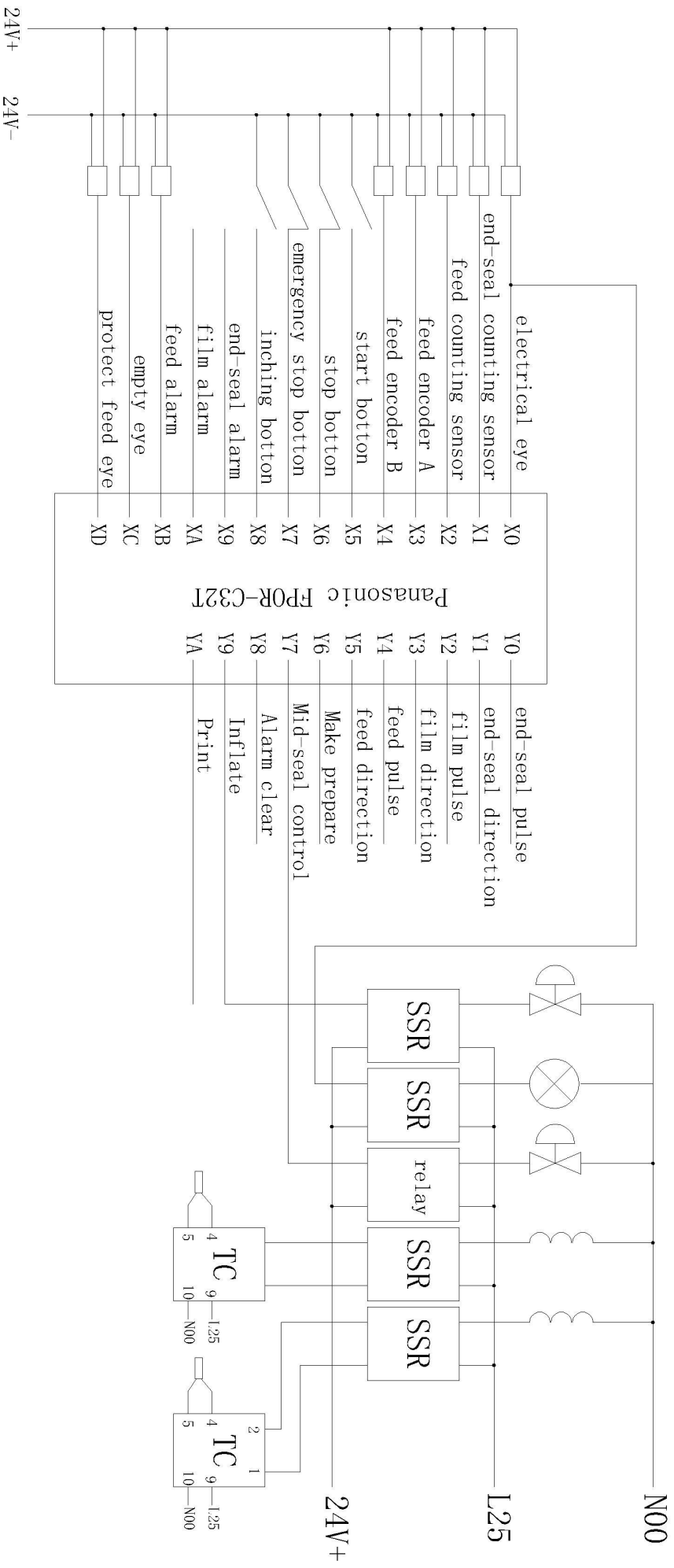
Color mark magic eye error!

Back

Feed encode AB opposite!

Back

Feed position abnormal!

Back

19. **Alarm screen**

Each alarm screen display

24V+
24V-

end-seal pulse — Y0
end-seal direction — Y1
film pulse — Y2
film direction — Y3
feed pulse — Y4
feed direction — Y5
Make prepare — Y6
Mid-seal control — Y7
Alarm clear — Y8
Inflate — Y9
Print — YA

Panasonic FP0R-C32T

X0 — electrical eye
X1 — end-seal counting sensor
X2 — feed counting sensor
X3 — feed encoder A
X4 — feed encoder B
X5 — start botton
X6 — stop botton
X7 — emergency stop botton
X8 — inching botton
X9 — end-seal alarm
XA — film alarm
XB — feed alarm
XC — empty eye
XD — protect feed eye

SSR
SSR
relay
SSR
SSR

TC   4 5   9 10   L25 N00
TC   1 2 4 5   9 10   L25 N00

24V+
L25
N00

20. Circuit diagram

Machine circuit diagram