

**CONTINUOUS BELT TYPE VACUUM
PACKAGING MACHINE**

OPERATION MANUAL

Parameters \ Models	DZ-1100-1 single sealed continuous belt type	DZ-1100-2 double sealed continuous belt type
Voltage	AC 380/50HZ	AC 380/50HZ
Motor Power	3000W	3000W
Sealing Power	2000W	2000W
Ultimate Vacuum Pressure	1KPa	1KPa
No. of Sealing Bars for Each	1pcs	2pcs
Chamber Dimension(LXWXH)	1170X460X100mm	1170X460X100mm
Sealing Length	1100mm	1100mm
Sealing Width	8mm	8mm
Vacuum Pump Rate	100m ³ /h	100m ³ /h
Material for Vacuum	Stainless steel	Stainless steel
External Dimension (LXWXH)	1950x1630x1300mm	1950x1630x1300mm
Net Weight	460kgs	460kgs
Max Size of Packing Bag	1100*400mm	1100*240mm
Max Size of Packed Goods	1100*330*82mm	1100*190*82mm



INTRODUCTION

This machine can be adjusted at multiple angles according to the packaging operation.

This machine is equipped with the cleaning switch for conveyor belt, the alarm reminder once unsealed, the PCL (Programmable Logic Controller) function and the adjustment for sealing temperature and vacuum degree.

SAFETY PRECAUTIONS

1. Power

1.1 You must use the power that matches the voltage and the electric capacity.

1.2 The grounding wire of the machine must be connected to a reliable grounding device.

1.3 Do not use wires which are smaller than the electric capacity of this machine. Otherwise, it will cause the electricity circuit damaged and lead to the fire.

2.This machine has no waterproof function

2.1 Do not use the machine in a highly humid environment.

2.2 Do not use or place the machine in a place with heavy dust.

2.3 When the machine is used in a highly humid

environment, a large amount of water vapor may cause machine parts rusted and insufficient insulation of electrical appliances. This may result in machine out of work , short circuit or leakage of electricity.

3. The main power switch must be turned off for maintenance or repair or parts replacement.

4. Repairing or replacing parts must be performed by a skilled technician.

5. The machine should not be used until troubleshooting or repair is completed!

6. Never making any alteration to the machine, we are not responsible for any damage caused by your changes. Please read the instruction carefully and use the machine correctly to avoid loss.

THE CONTROL PANEL

1. Display: display the current project
2. "SET" button: call out the setting item
3. "▲▼"key: select the item
4. "+"-" key: set the requirement of the project
5. "ENT" key: confirm and store
6. "Power": Indicate whether the machine is powered on or not
7. "Start": start the machine running
8. "Cleaning": Click this switch to rotate the conveyor belt for easy cleaning
9. "Emergency stop": When an emergency occurs, press this button to stop quickly. Once the emergency is handled, unscrew the emergency stop switch and the machine can work again.

PREPARATION BEFORE USE

- 1.** The machine must be placed in a place that meets the requirement of safe production. Putting up four support feet to make the machine steady and unshaken. All of this can ensure safety and avoid the accidents.
- 2.** The voltage and electricity capacity must meet the requirement of this machine.
- 3.** Check whether the oil level of the vacuum pump meets the requirement (the oil level should not be lower than the oil window calibration and should not be higher than the oil window 3/4).
- 4.** Adjust the machine tilt angle according to the operation and then lock the bolts. Check if the connecting bolts of each part are loose and tighten.
- 5.** Check if the electrical circuit is well connected. If it is loose or falling off, restore it (The screw may be loose or even shedding during the transportation).

THE CORRECT USE OF THE MACHINE

- 1.** Connect the power input line to the power switch of the place and connect the ground wire to the common grounding device.
- 2.** Turn on or turn off the machine “power” switch to check if the vacuum pump steering meets the indicated steering (if it does not match, please exchange any two phases of the three-phase line of the input power, and then access to power again. It is forbidden to exchange the power line of the vacuum pump, otherwise it will affect the steering of other motors).
- 3.** Turn on the “power” switch (vacuum pump works), the display is bright (it shows the word ‘Vacuum Packaging Machine Operation System’). Unscrew the emergency stop switch firstly, and then the chamber cover rises (Notice: when the machine is packed for transportation, the chamber cover is closed.).
- 4.** Press the “SET” button to call out the SET 1: Vacuum, Sealing, Cooling and Deflate. Press “▲” “▼” to select the item, press “+”“-” key to set the required time for the project. Each time after setting, press the “ENT” button to confirm. Usually, cooling time is set to 3.0 seconds. The deflate time is usually set to 5 seconds, which allows the negative pressure in the working chamber to be fully released.

Attention!

Not fully released negative pressure may damage the machine components or cause the open cover motor to be burn out.

5. Press the “SET” button to call out the SET 2: Interval, Seal Check, Count and Total. Press “▲” “▼” to select the item.

Interval. It refers to the time between the previous operating program and the next operating program. For example, if the packed goods cannot be kept up or the operator is unskilled, the interval time can be set longer. Press “+”“-” key to set the required interval for the project. After setting, press the “ENT” button to confirm.

Seal Check. It can be turned on or off, but usually turn on. It can detect whether the sealing circuit works well; if not, it will alarm. Press “+”“-” key to turn on or off for the project. After setting, press the “ENT” button to confirm.

Count. Extended press “ENT” key can clear the count of sealing.

Total. The cumulative count of sealing. It can not be cleared.

6. Press the “SET” button to call out the SET 3: Work Mode and Language. Press “▲” “▼” to select the item.

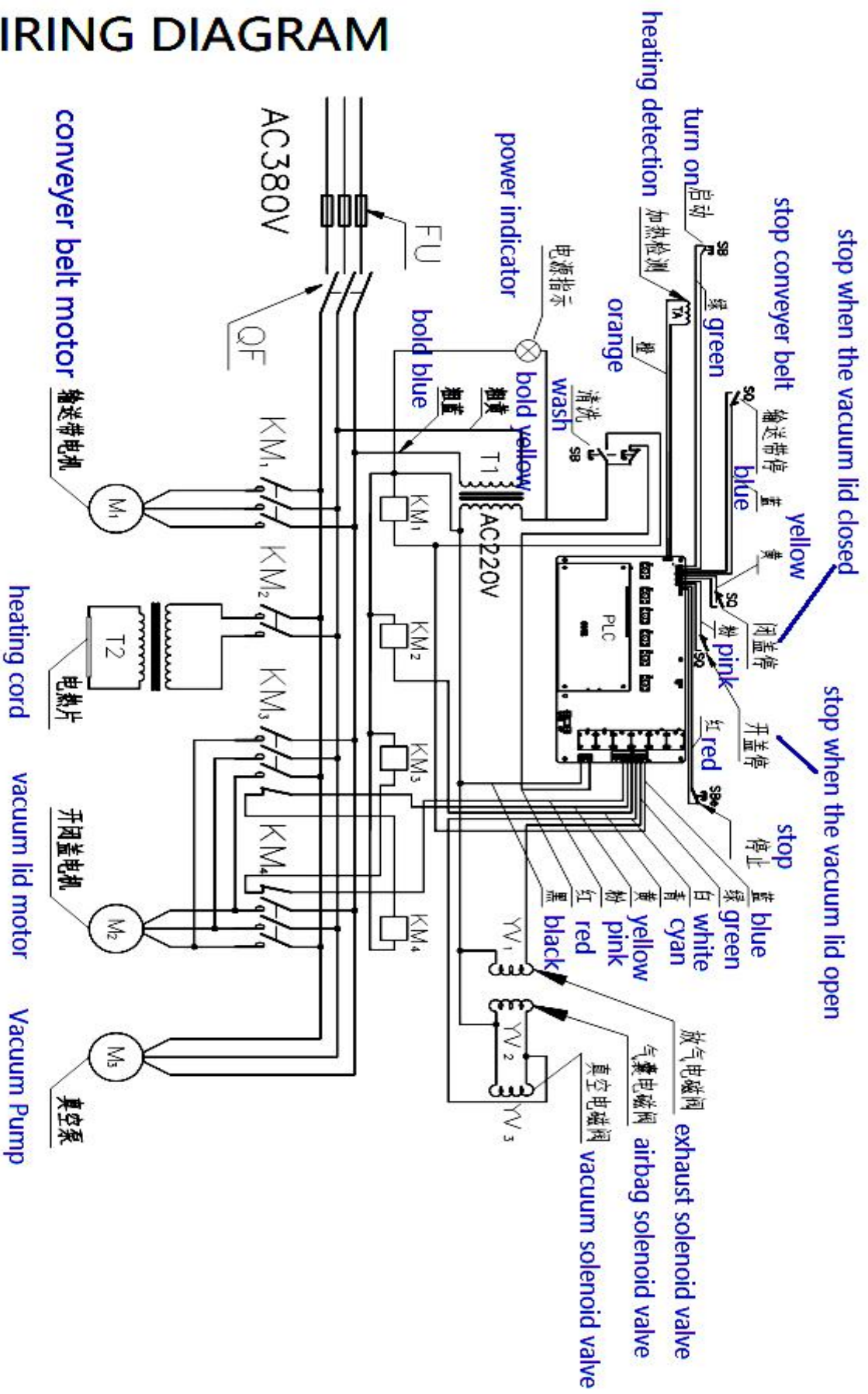
Work Mode. It has two modes: continuous or single. Press “+”“-” key to set the required work mode for the project.

After setting, press the “ENT” button to confirm.

Language. It has different languages. Press “+”“-“ key to set the required language for the project. After setting, press the “ENT” button to confirm.

7. After confirming all settings, press the “SET” button again. It displays: work mode (continuous or single), count and project items. At this time, press “start”, the cover of chamber is raised and the machine begins to pack goods.

WIRING DIAGRAM



MAINTENANCE

Remind: When you open the machine metal cover or vacuum lid, be careful to its corners.

Clean dust and stains. Check whether foreign matter falls into the conveyor belt and chain. Check if screws in each part are fixed well and properly apply lubricating oil into the transmission parts. Check the oil volume of the vacuum pump.

COMMON FAULTS, CAUSES & TROUBLESHOOTING

Symptom	CAUSE	REMEDY
Sealing not well	High-temperature cloth or silastical bar is dirty	Clean with a cloth
	High-temperature cloth is broken	Replacement
	Silastical bar is broken	Replacement
	Too long or too short time for Sealing or cooling	Adjust the sealing time or cooling time
Uneven sealing	Silastical bar is broken or uneven use	Make it even or Replacement
Failed Sealing	Heating circuit is poor contacted or broken	Checking
	Heating contactor does not work or be damaged	Checking
	Heating Transformer is damaged	Replacement
	Fracture of Heater	Replacement
Vacuum pump working but no vacuum	The Rotary vane of vacuum pump is broken or jammed	Checking or replacement
	Solenoid valve for vacuum is not opened	Checking or replacement
	Vacuum lid is not completely closed	Checking

 ***Attention!***

The machine must not be connected to the power supply before maintenance.