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Auto L-Bar Shrink Wrapper Operation Hand Book



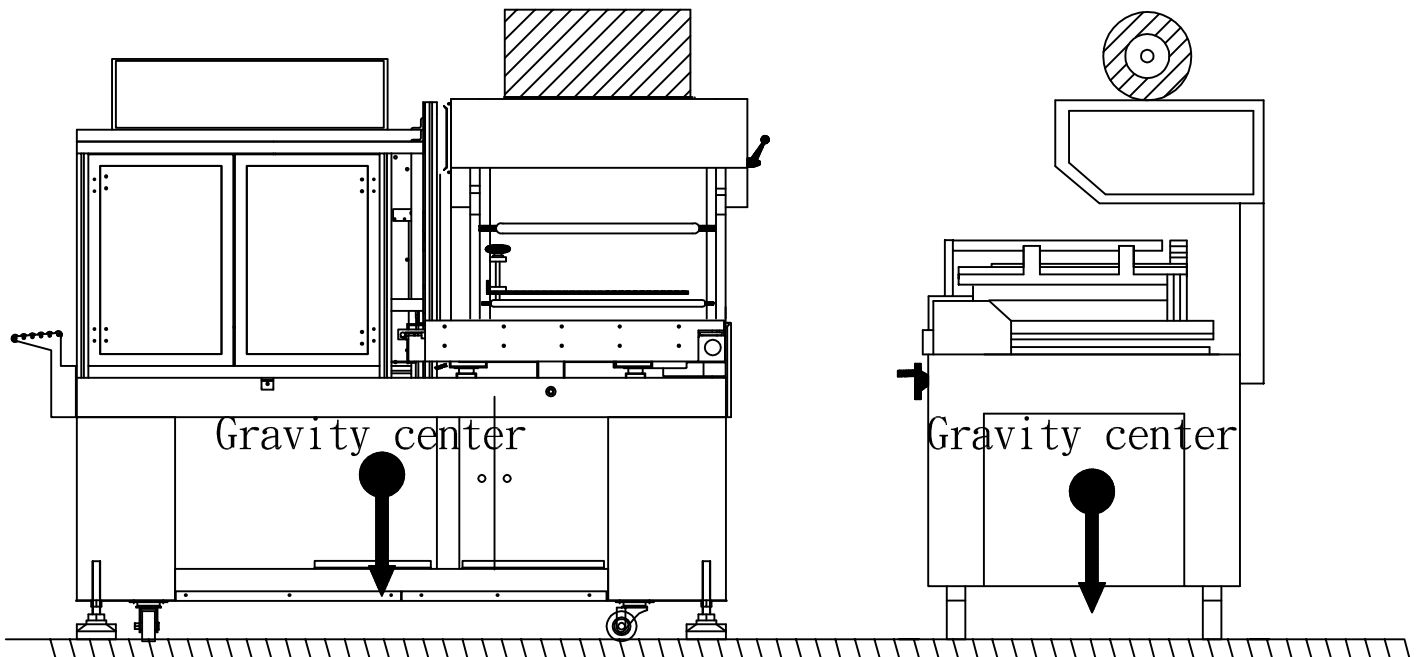
INDEX

	PAGE
1. TRANSPORTATION	
1.1 PACKING _____	<u>1</u>
1.2 UNPACKING _____	<u>2</u>
2. INSTALLATION	
1.1 THE PREPARATION FOR INSTALLATION _____	<u>5</u>
2.2 THE PROCESS OF INSTALLATION _____	<u>6</u>
3.3 THE REQUIREMENT OF ELECTRICITY & AIR PRESSURE _____	<u>7</u>
3. THE COMPONENTS OF MACHINE	
3.1 GENERAL IDEAS _____	<u>8</u>
3.1.1 PREFACE	
3.1.2 DIMENSION	
3.1.3 SPECIFICATION & CAPACITY	
3.2 THE PRE-CAUTION & SAFETY INSTRUCTIONS FOR TURNING ON/OFF _____	<u>10</u>
4. OPERATING INSTRUCTIONS	
4.1 THE PARTS' DETAIL _____	<u>12</u>
4.2 THE FILM SET UP PROCEDURE _____	<u>14</u>
4.3 THE OPERATION PROCEDURE _____	<u>22</u>
4.4 THE TESTING AND ADJUSTING _____	<u>22</u>
5. TROUBLE SHOOTING	
5.1 HOW TO DEAL WITH THE TROUBLE _____	<u>42</u>
5.2 THE PARTS REPLACEMENT & TECHNOLOGY _____	<u>44</u>
6. MAINTENANCE	
6.1 GREASING _____	<u>45</u>
6.2 CLEANING & MAINTENANCE _____	<u>47</u>
7. TECHNOLOGY	

1. TRANSPORTATION

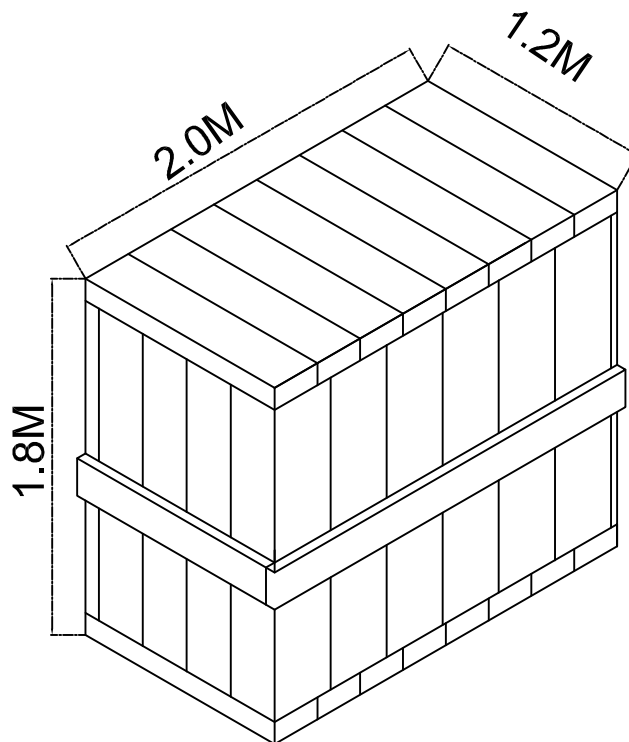
1.1 DOMESTIC

- (1). The auto L-Sealer is wrapped by a plastic film and transported by truck the machine weight is 290kg.
- (2). It is required at least 2 persons to move the machine. (excluding forklift operator)
- (3). All the operator should wear the protecting clothing such as safety helmet, protecting shoes and glove.
- (4). Please note about the gravity center of the machine when moving it.



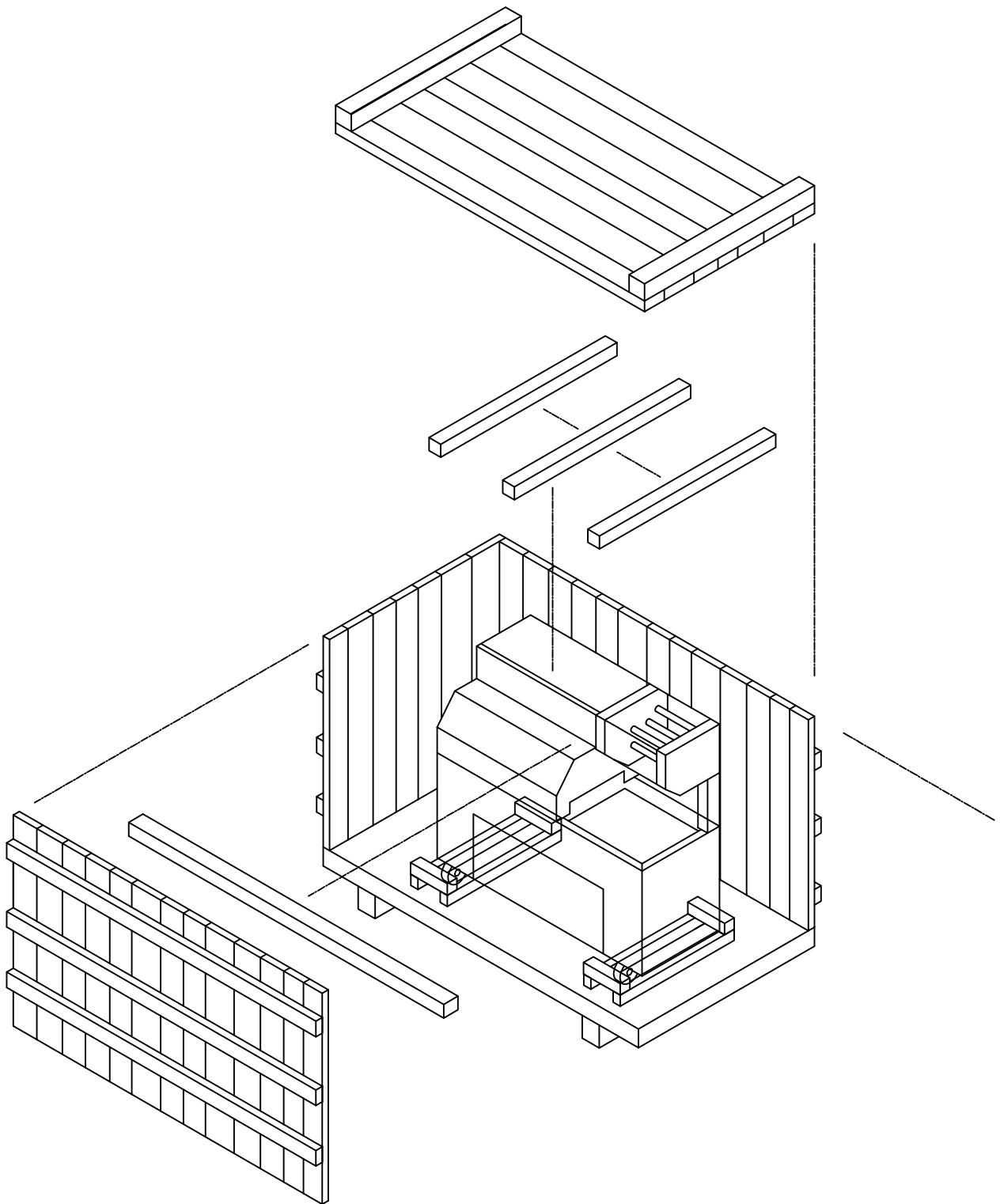
1.2 UNPACKING

- (1). The machine is packed by wooden crate Dimension is 2.0M(L), 1.2M(W) & 1.8M(H). It weight is 400kg . It require at lease 1.25 tons above fitter to move the machine from truck.
- (2). It is required at least 4 operators(excluding the forklift operator)
- (3). The operators should wear safety helmet, protecting shoes & glove etc... for protection.
- (4). Please note about the machine gravity point for machine moving.
- (5). please prepare the saitable tools to unpack the wooden case such as pincer,fammer & ladder... etc.
- (6). The unpacking process should be done from the case top to the bottom,Dispose of the waste of unpacking is necessary for reduction of danger.
- (7). The machine cannot be moved unless all the mess from unpacking which is clean.
- (8). Please refer the under figure for case climension and packing appearance.

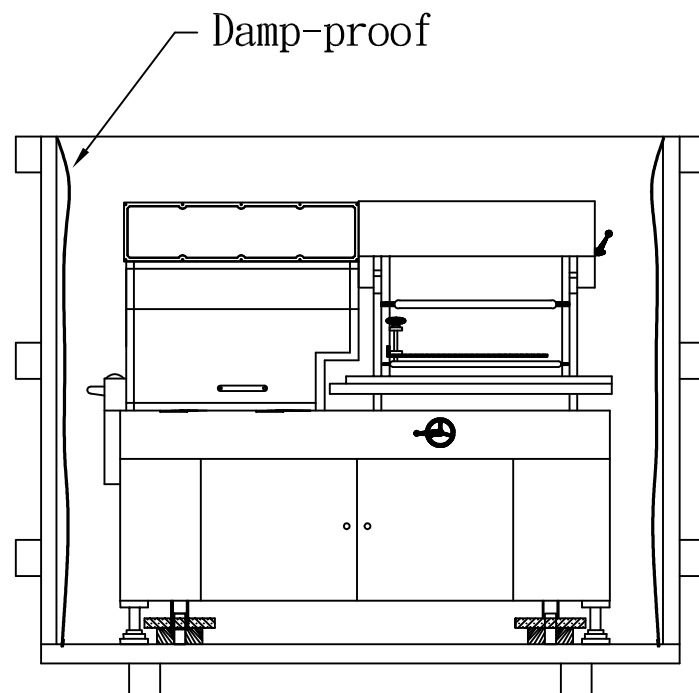
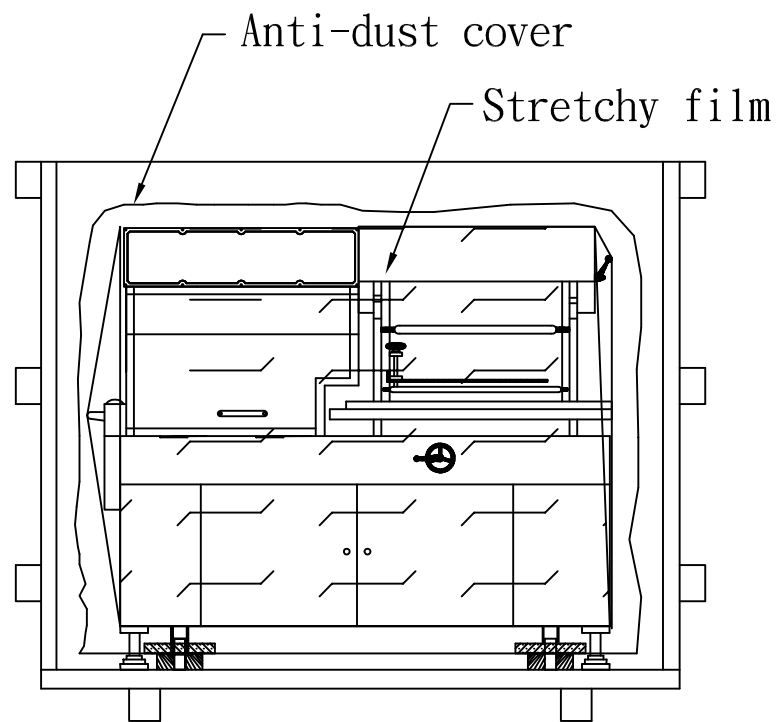


The woodon crate appearance

The packing method for machine in wooden crate



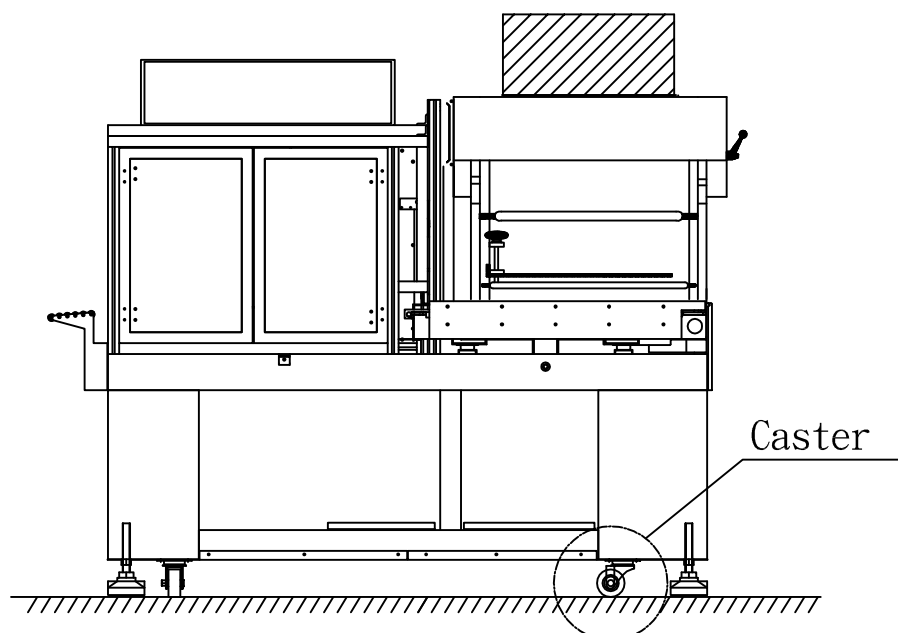
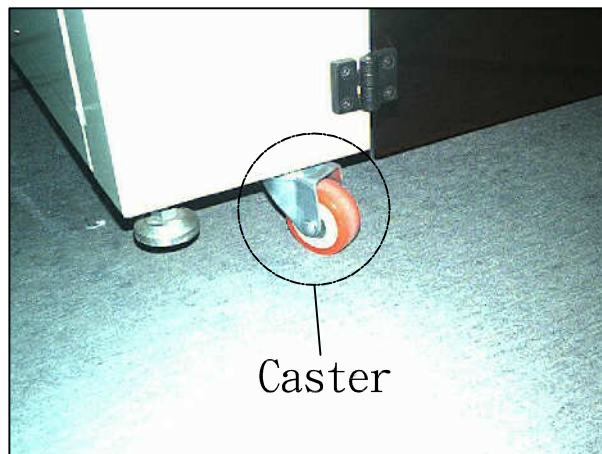
Inside of wooden crate



2. INSTALLATION

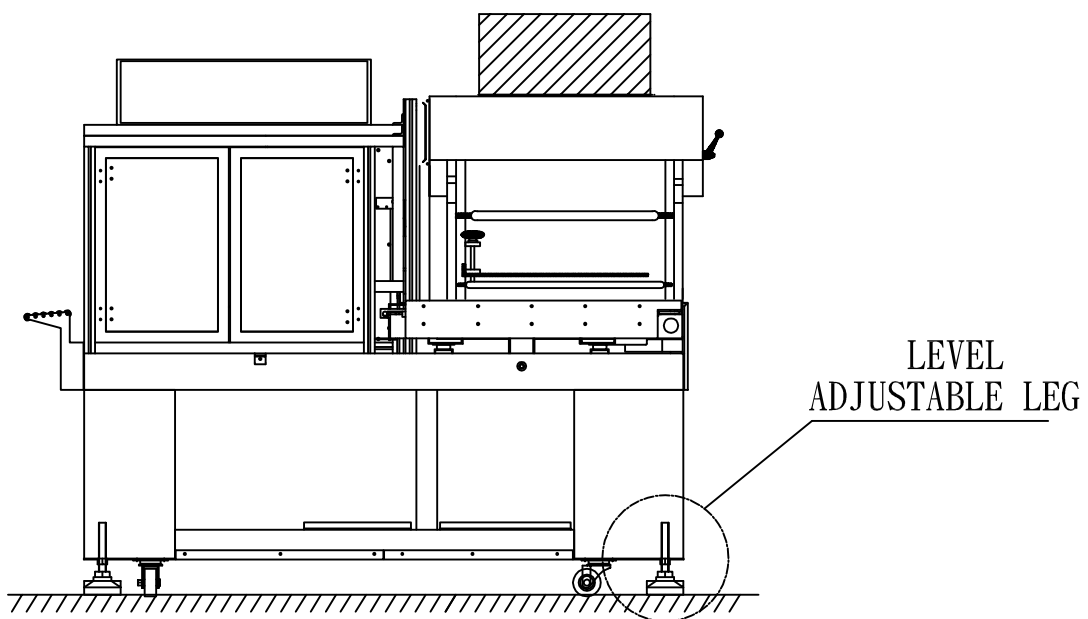
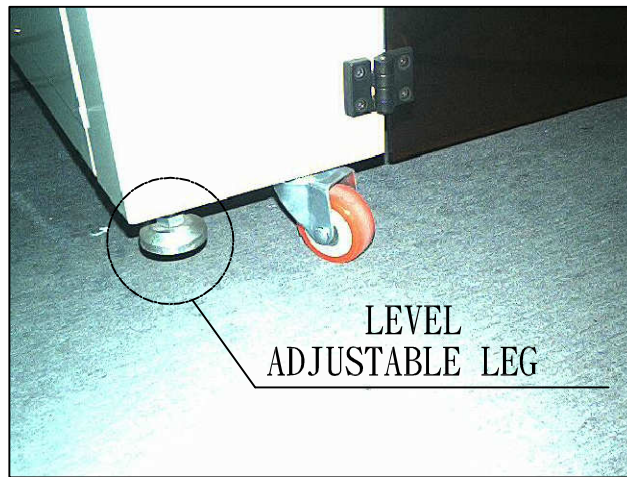
2.1 The preparation for machine installation

- (1).The auto L-TYPE sealing machine is 280kg weight
There are 4 casters mounted under the machine. It can be moved easily.
- (2).It is required at least 2 persons for machine moving.
- (3).The workers should wear protecting clothing such as safety helmet, protecting shoes and gloves ... etc.
- (4).The machine can be only moved on the smooth place. It is possible to fall down if move on the rough or massy surface.
- (5).If it needs to use lifter, it will be required for 1.25 tons capacity. Also a licenced operator is requested.



2.2 THE POSITION OF INSTALLATION

- (1). When the machine set on required location, Please take off the covering plastic film.
- (2). If the machine connect with the coveyor of production line, the machine must be adjusted on the proper stand.
- (3). To use wrench adjusting the screws of level adjustable leg on the proper height.



3. THE REQUIREMENT OF ELECTRICITY & AIR PRESSURE

- (1). POWER : Single phase 220V,50/60HZ
- (2). AIR PRESSURE: 5.5kg/SQUARE cm (80 PSI)
- (3). To ensure operating normally, the ground wire must be properly connected.
- (4). to pressing the inching button slowly making sure The motor is running to the right direction once power being supplied.

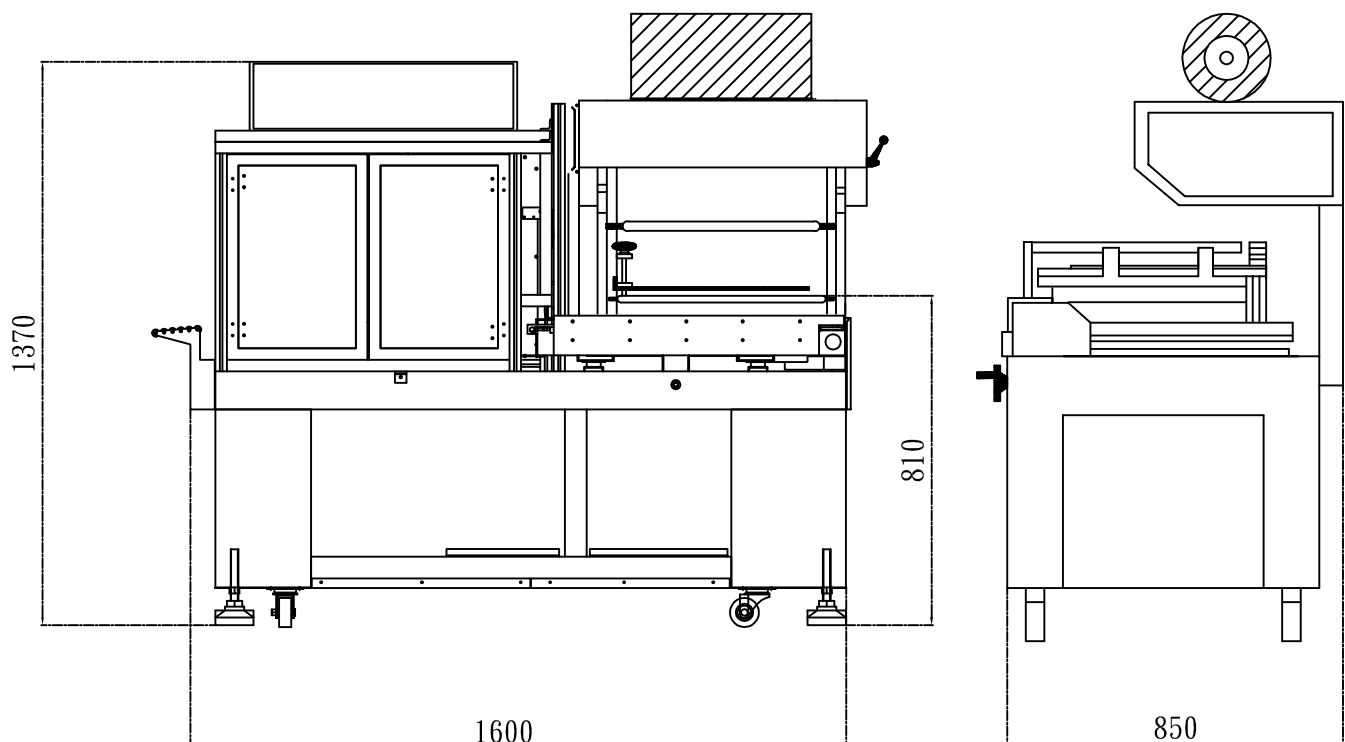
3. THE COMPONENTS OF MACHINE

3.1 GENERAL IDEAS

(1).PREFACE

Thank you to purchase our product, By this manual, We would like to provide you the standard operating procedures and maintenance.

(2).DIMENSIONS



FRONT VIEW

SIDE VIEW

3.SPECIFICATION & CAPACITY

POWER: AC single phase , 220V, 50/60HZ

(1). Infeed conveyor Motor: 60w

(2). Outgoing conveyor Motor: 60w

(3). Film leading Motor: 25w

(4). Film clamp Motor:40w

(5). Winding Motor: 15w

(6). Heater(TD): 500W

(7). Heater(MD): 600W

AIR PRESSURE: 5.5kg/SQUARE cm,80PSI

MACHINE DIMENSION: (L) 1600mm (W) 850mm (H) 1370mm

TABLE HEIGHT : 810mm + 70mm

SEALING SIZE: (W) 450mm X (L) 550mm

CONVEYOR SPEED :Infeed conveyor (MAX SPEED) 21.3 M/min

Outgoing conveyor (MAX SPEED) 20.0 M/min

The running speed for film roll: 17.6 M/min

The pulling speed for film roll: 19.4 M/min

Sealing Temperature: 200 °C(See remark)

Sealing Time: 0.5 (See remark)

Applied Material: PE, OPP, POF

REMARK

Both sealing line & temperature are adjustable according with the different material, thickness and working condition.

3.2 SAFETY AND PRE-CAUTION OF TURN ON,TURN OFF THE MACHINE

1. All operators should study this manual thoroughly before operating the machine. Warranty does not cover machine break downs due to operator error or improper setups.
If those operators do not follow the rules to run the machine leading to injury, Benison won't be responsible for the wounded.
2. Before turn on the machine, please check the details as below :
 - (1). The machine outlook and the attachments are they good condition.
 - (2). Be sure has no obstacle objects on the convey belt.
 - (3). Machine inside or upper part cannot put any tools or other articles, to avoid danger.
3. For maintenance or adjust the machine, must turn off the electricity and be sure the machine is completely stop.
4. Pay attention to all warning sign stickers, and must follow the safety regulations.
5. THE OPERATOR must follow all the rules of above, and must oftenly check up the machine keeping it clean and running normally.
6. If there are any problem happened, please contact our company technicians immediately.
- 7.To prevent from danger, in any case, never pull out & turn off the safety switch when the machine is electrified. Also, keep off your hands & any tools in the scope of cutting zone.
- 8.All operators must strictly observe the above guild line and keep the machine clean & well-run.

WARNING SIGNS



Caution sign, be alert.



Grounded sign, Notice here is the grounded location.
Please ground the earth cable to Class-3 (lower than 100Ω).
Incomplete grounding connection may lead to electric shock.



Electrical hazard, electrical danger if touched.
Only the trained electrician can uncover the electric panel or box.



Cut warning.
In any case, do not place your hands or any object on the sealing or cutting zone. Shut down the machine before doing the maintenance, parts replacing or trouble shooting in these zones.



Pinch warning.
Do not put your hands or any object on the moving mechanism.
Shut down the machine before doing the maintenance, repair or adjustment.



Crush hazard.
Do not put your hands or any object on the moving mechanism.
Shut down the machine before doing the maintenance, repair or adjustment.



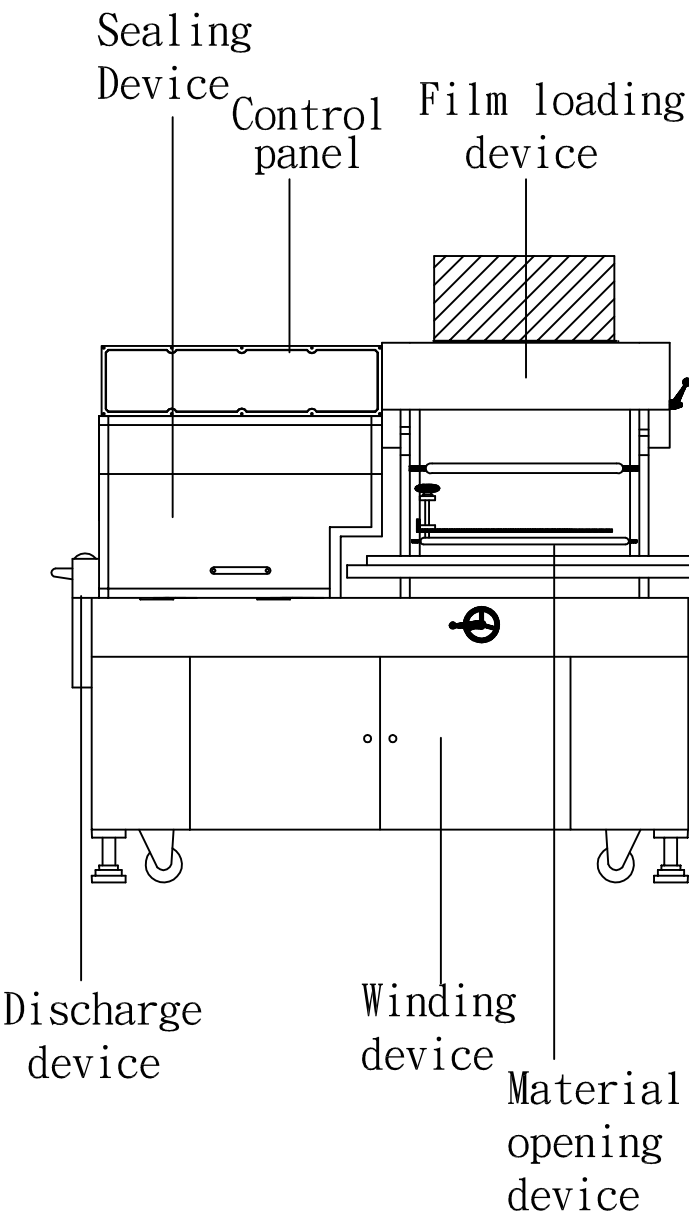
High temperature warning.
Do not touch or close to the heating source to prevent from getting burn. Proceed any maintenance only when the temperature of heater or heating source cool down to room temperature.



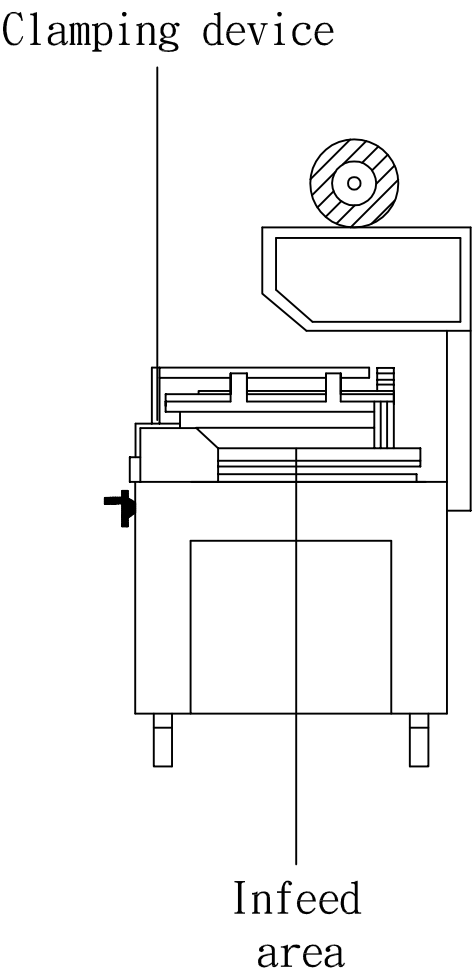
Moisture warning, keep dry.

4. OPERATION INSTRUCTION

4.1 THE PARTS DETAIL

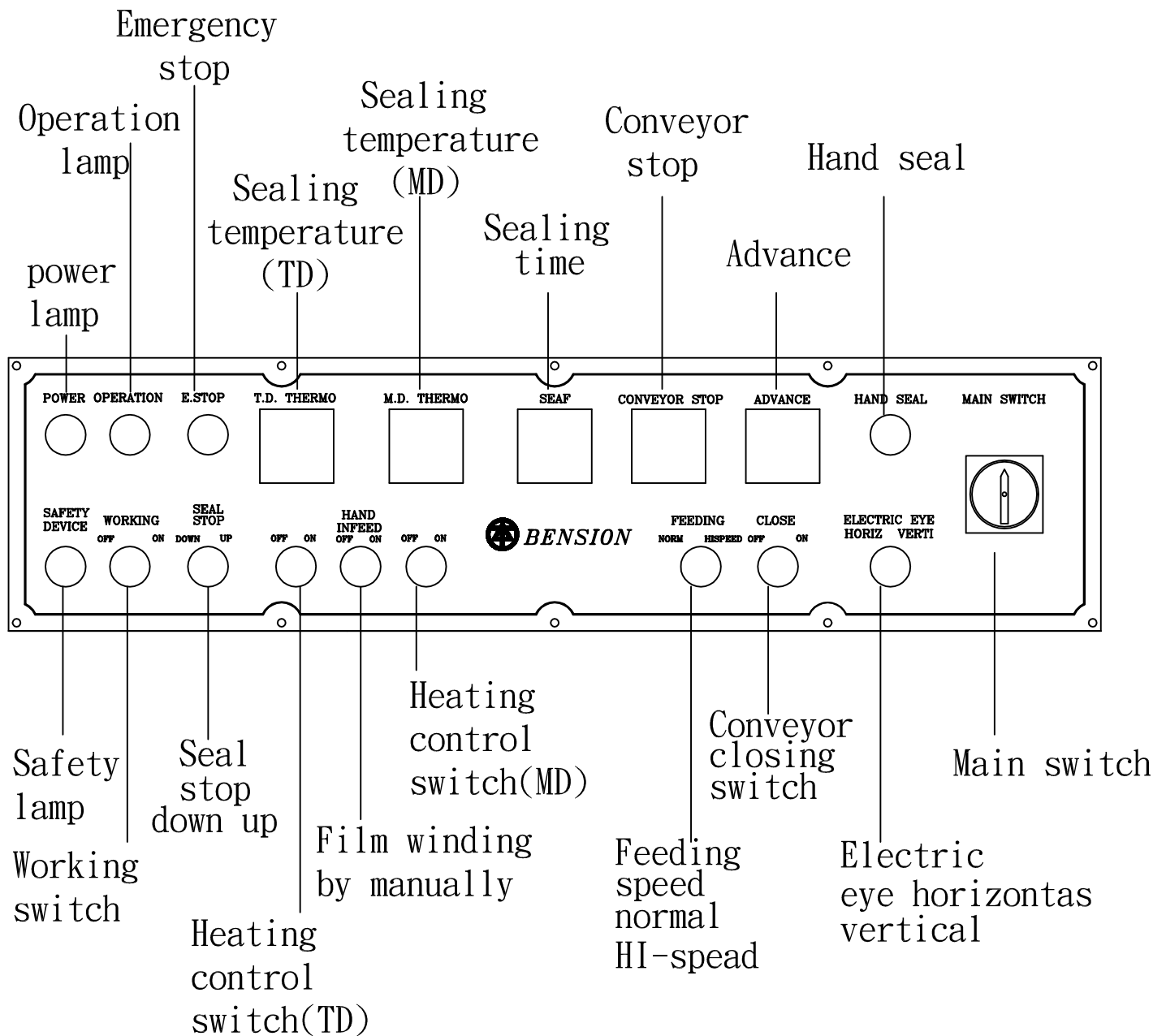


FRONT VIEW



SIDE VIEW

The instruction for control panel

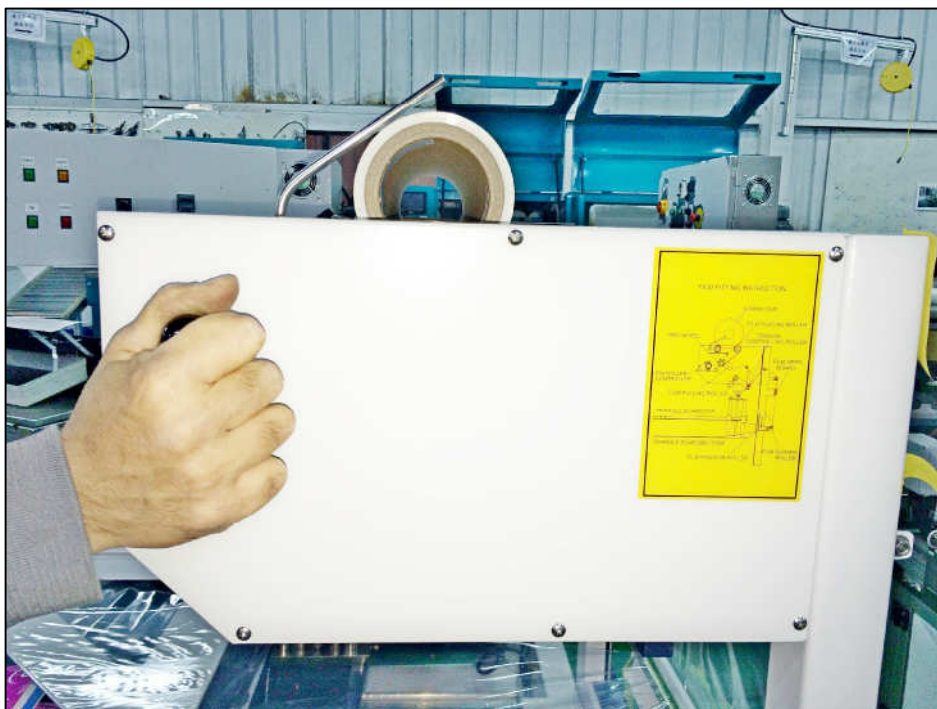


4.2 The Film Set up Procedure

STEP1. Turn off the working switch when set up the film.
place the filmroll on the 2 rollers.



STEP2. Pull down the handle of punch device.



STEP3.To set up the film on the rollers.
(Follow the setting fitting diagram)



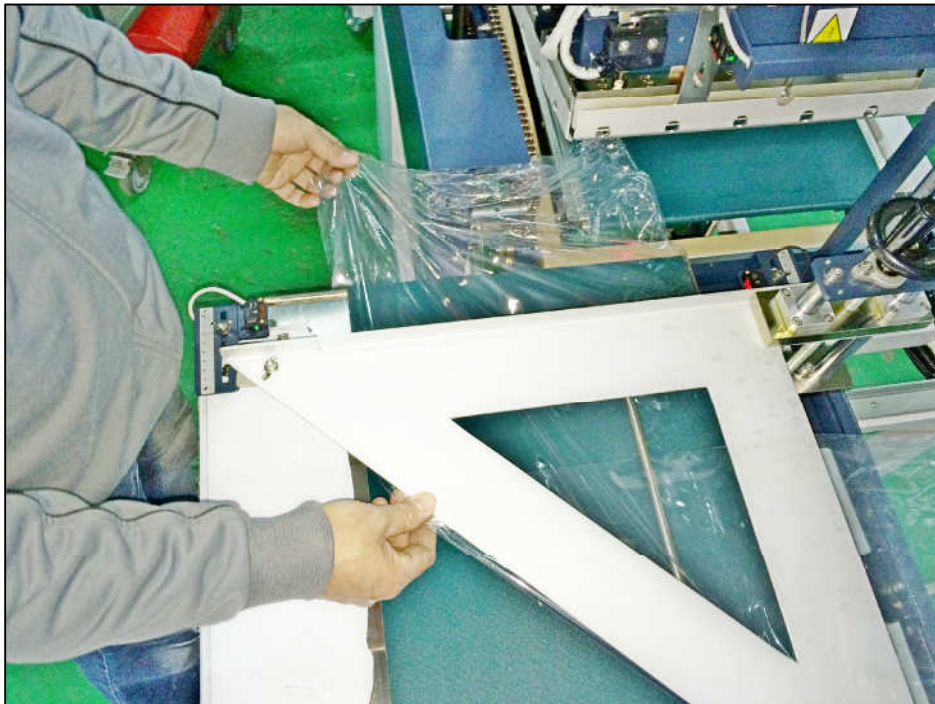
STEP4.Pull film pass the film open & blowing tube.



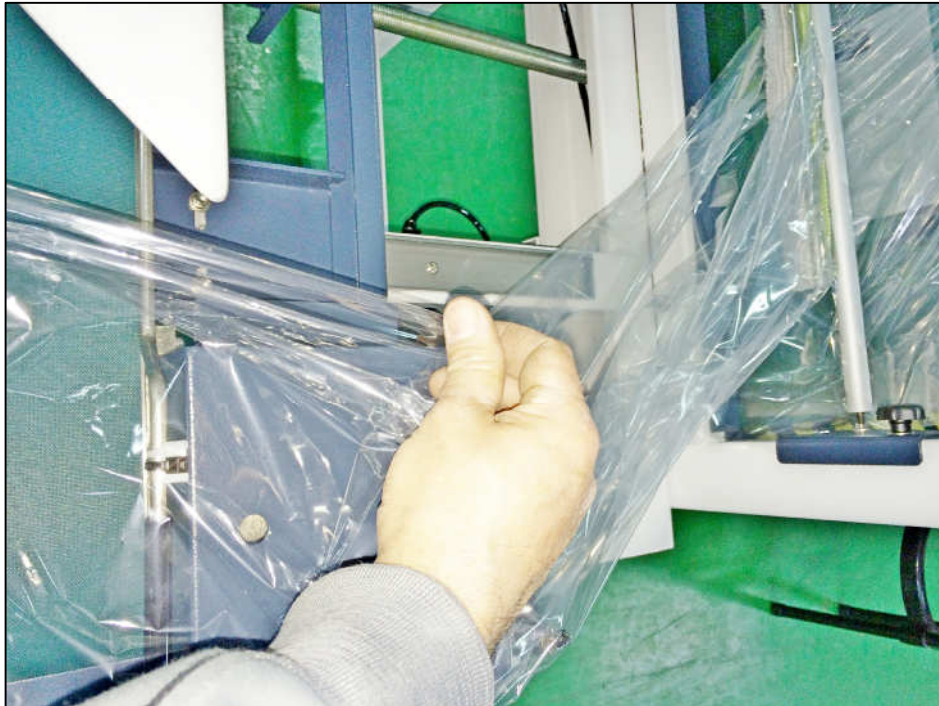
STEP5.Pull above 1 meter film for working.



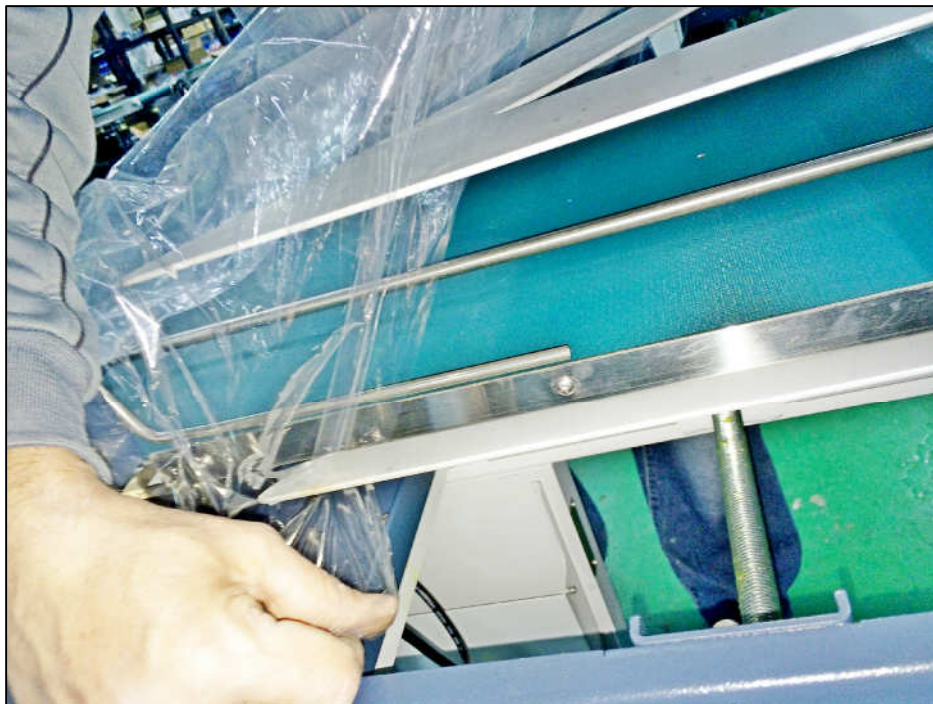
STEP6.Open the film centerfold.



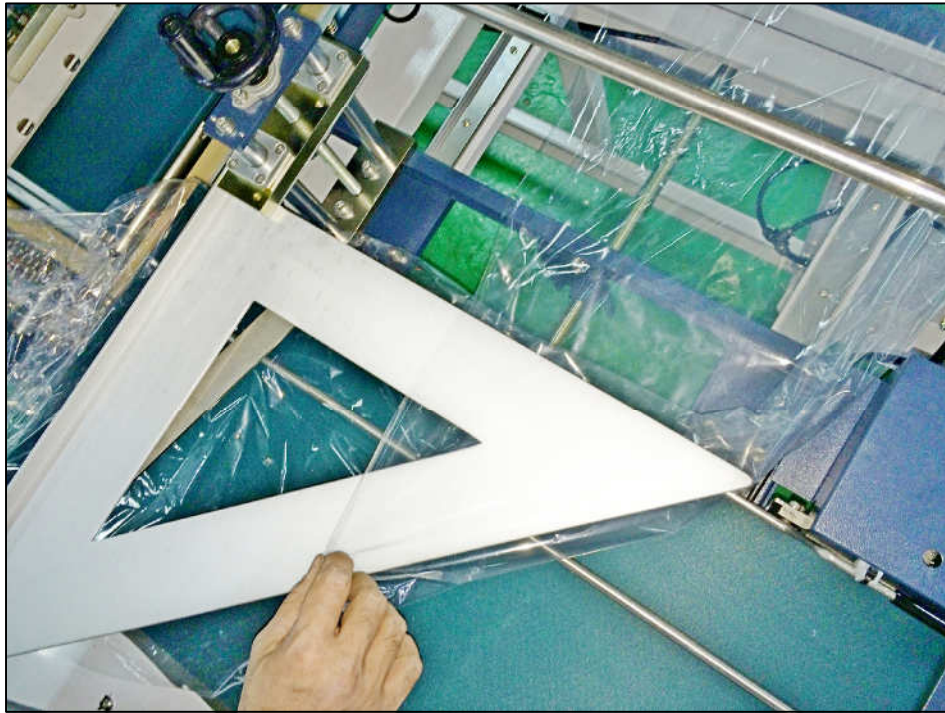
STEP7.Fit the film at the bottom of triangle board.



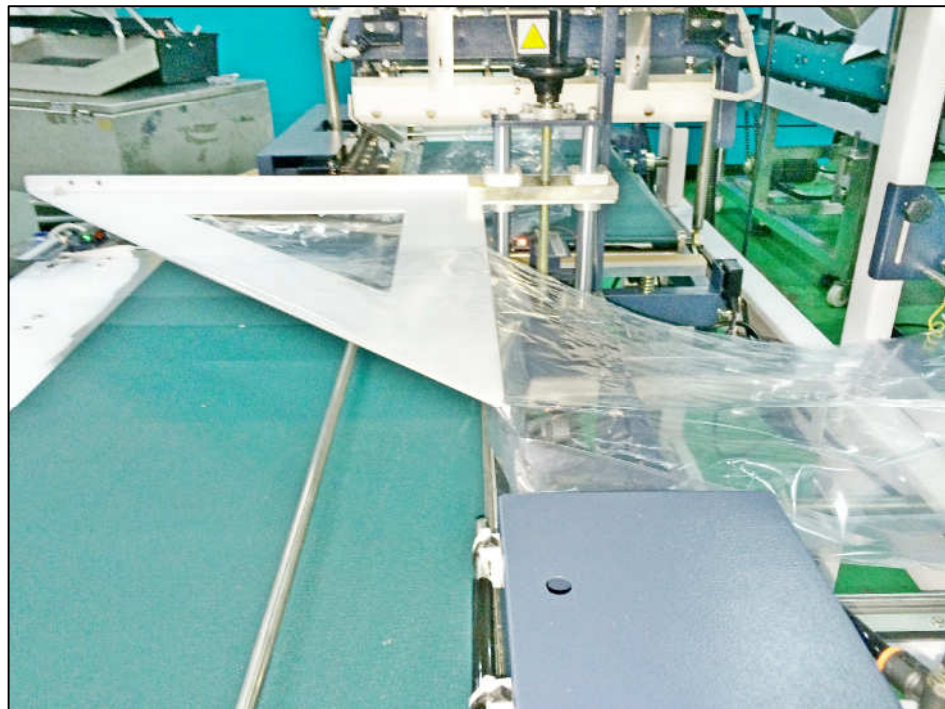
STEP8.Hold the film by right hand,and pull the film against the triangle board toward to the sealing bar by left hand.



STEP9.Hold with left hand,and pull the film to sealing bar by right hand.



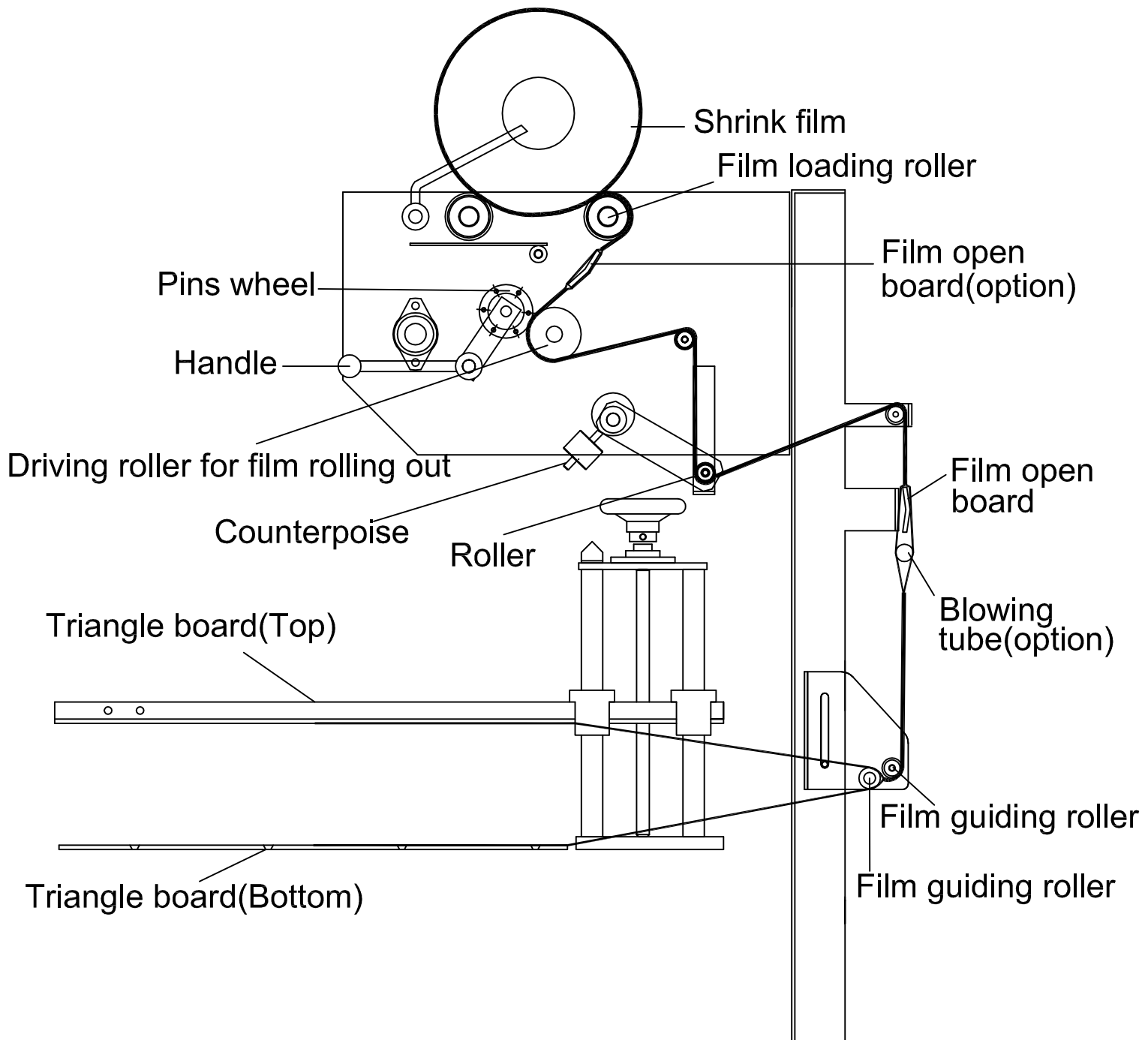
STEP10.Match the film both top & bottom sheets.



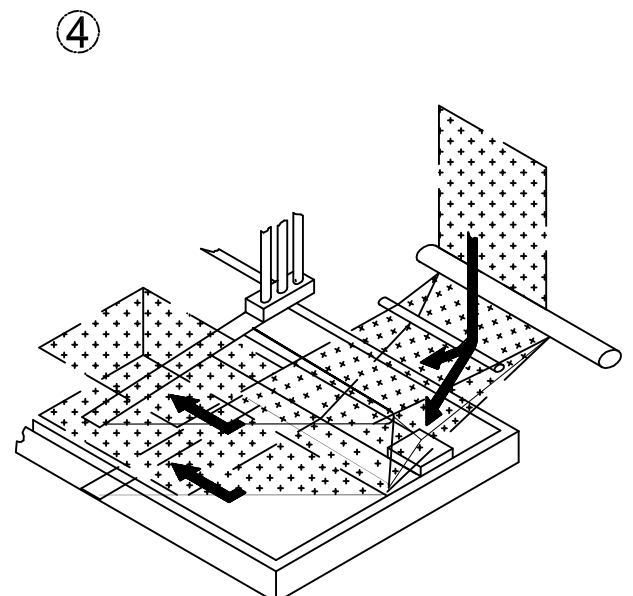
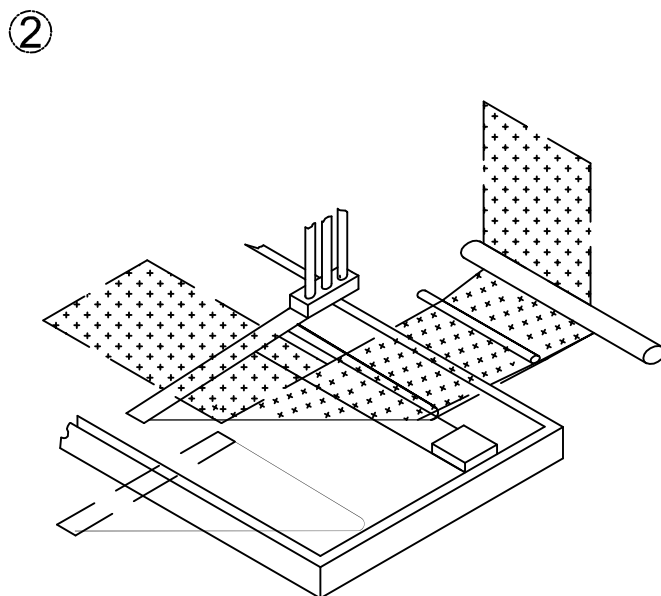
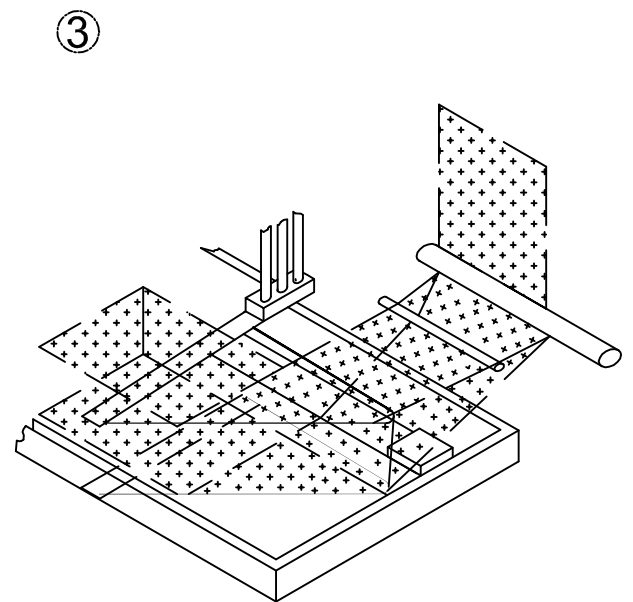
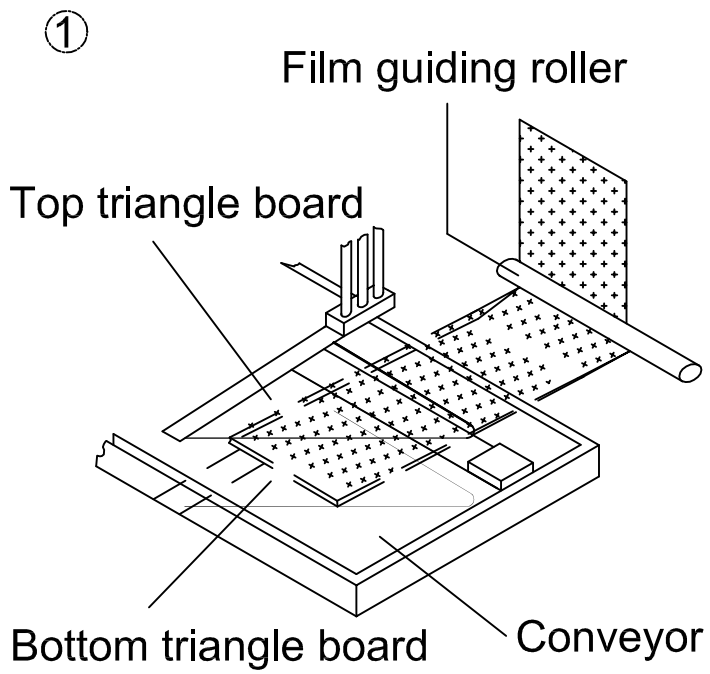
STEP11.Pull the film on the damping device.



Film Setting Diagram

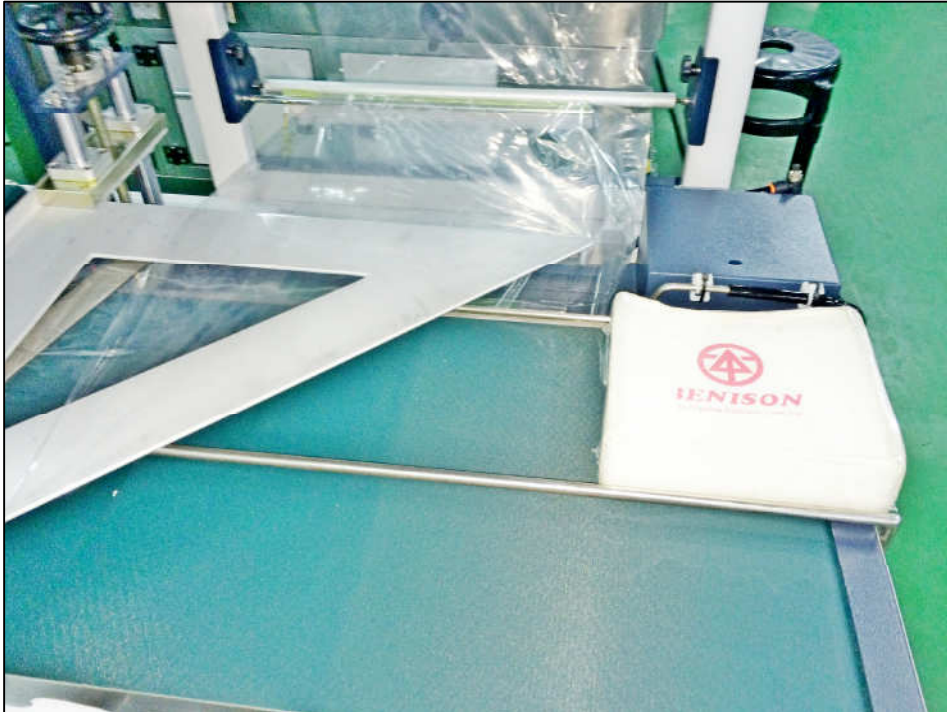


The Film Setting For Triangle



4.3 THE FILM SET UP PROCEDURES

STEP1.Place the object on conveyor.



STEP2.Adjust the width for package.



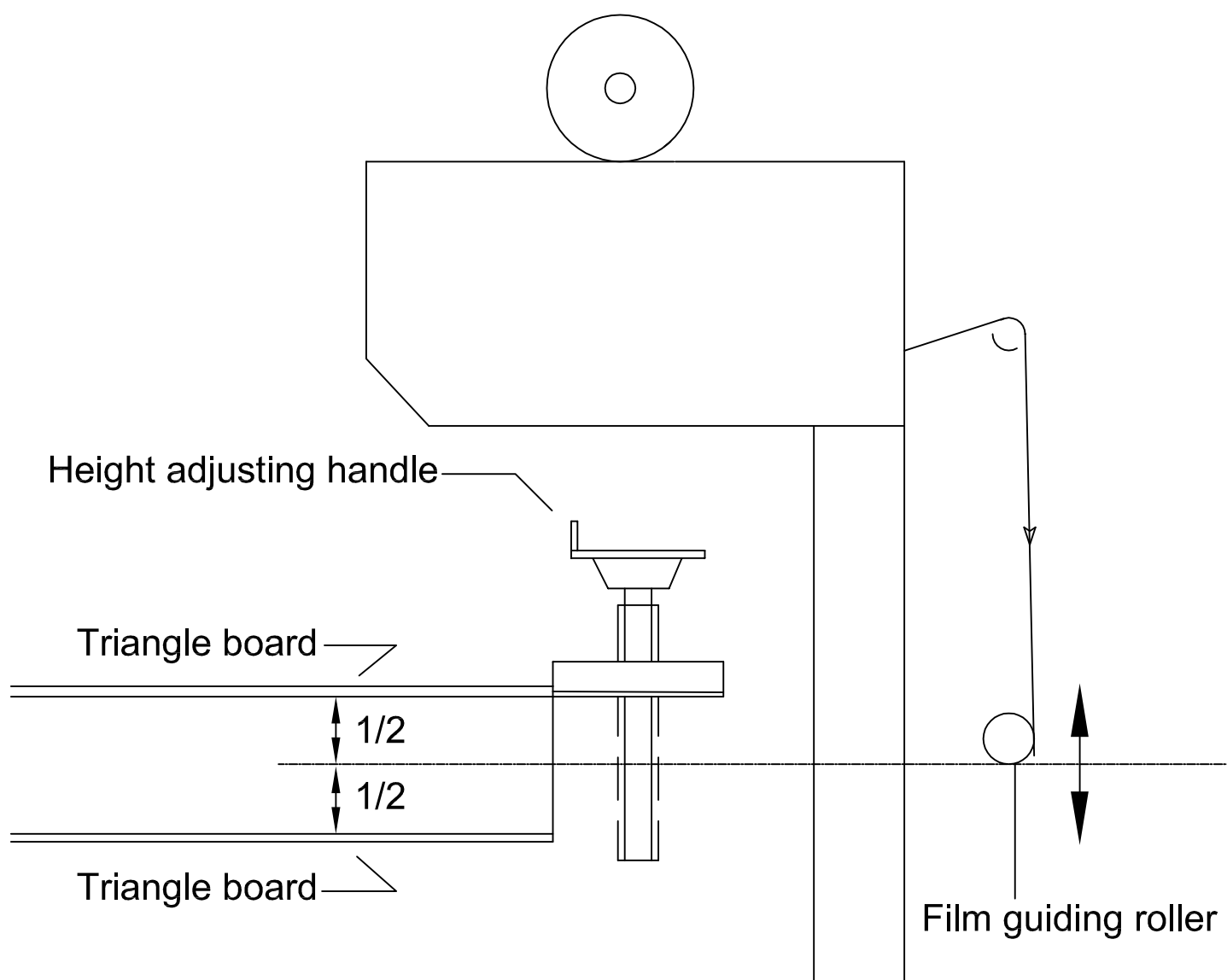
STEP3.Adjust the height of triangle boards
(There should be a gap about 1 cm between
the object and triangle board.)



STEP4.Adjust the height of the film guiding roller
(Refer to next page24)



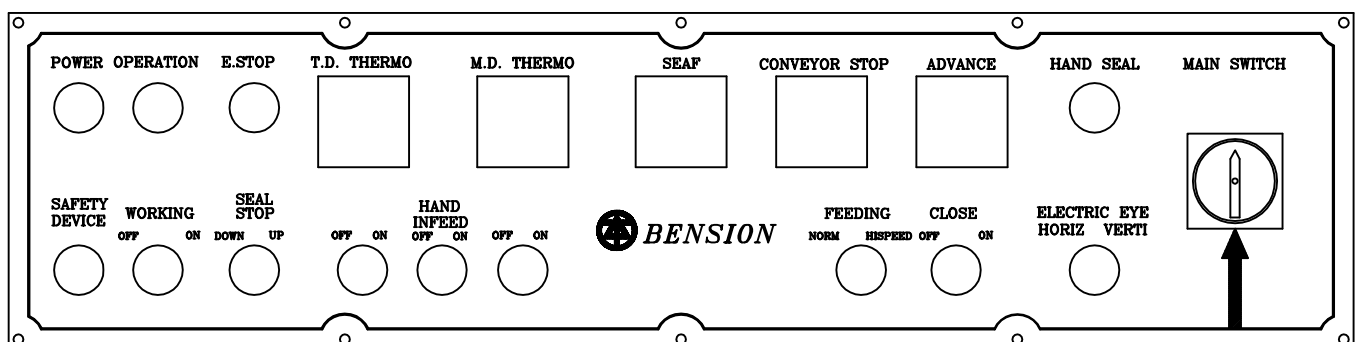
Adjust the film guiding roller setting the roller on the middle position of 2 triangle boards.



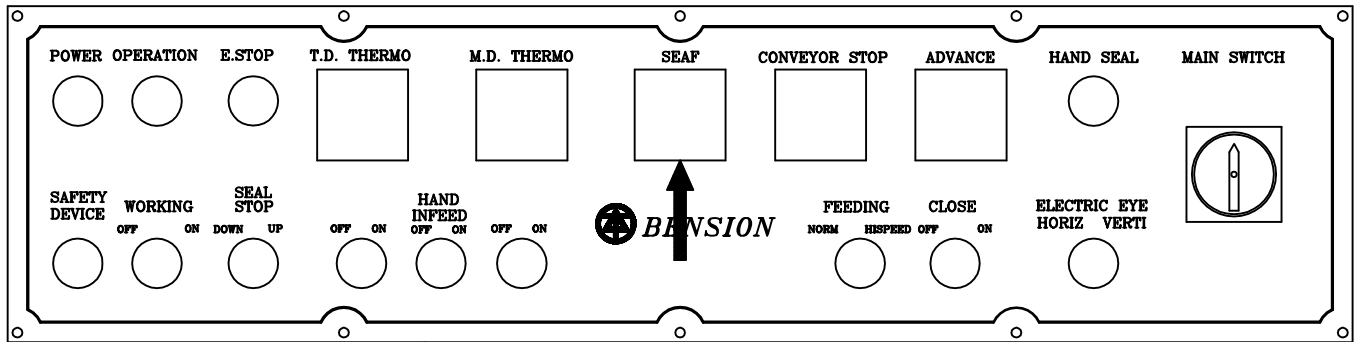
STEP5.Setting (Referring to the film setting diagram.)



STEP6.Turning on the power switch.

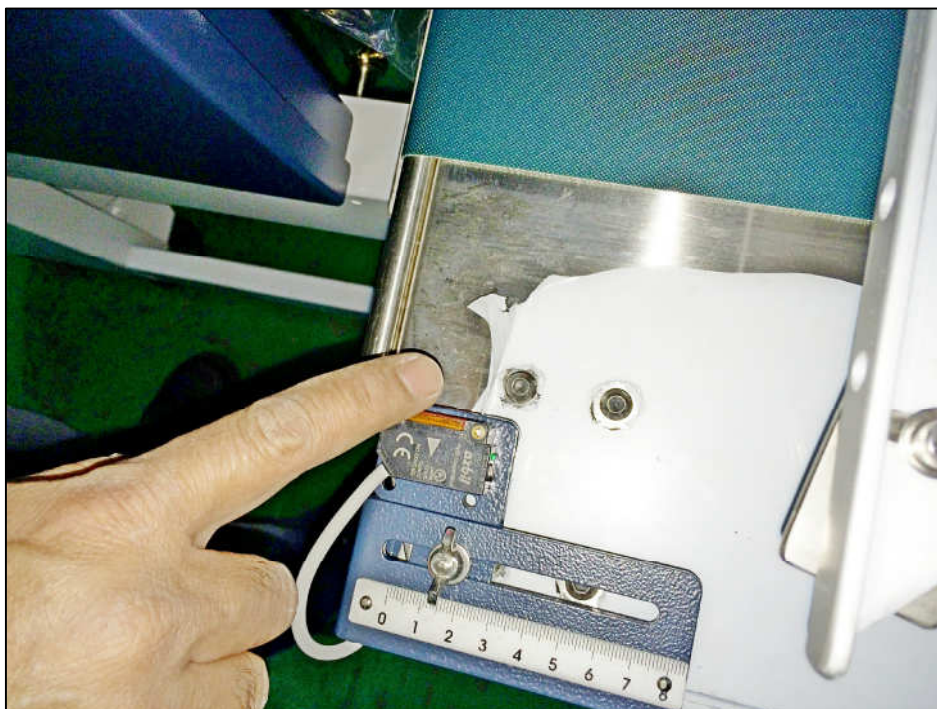


STEP7.Adjust the sealing temperature & time.



(The sealing temperature & time may be changed according to the film thickness & different material.)

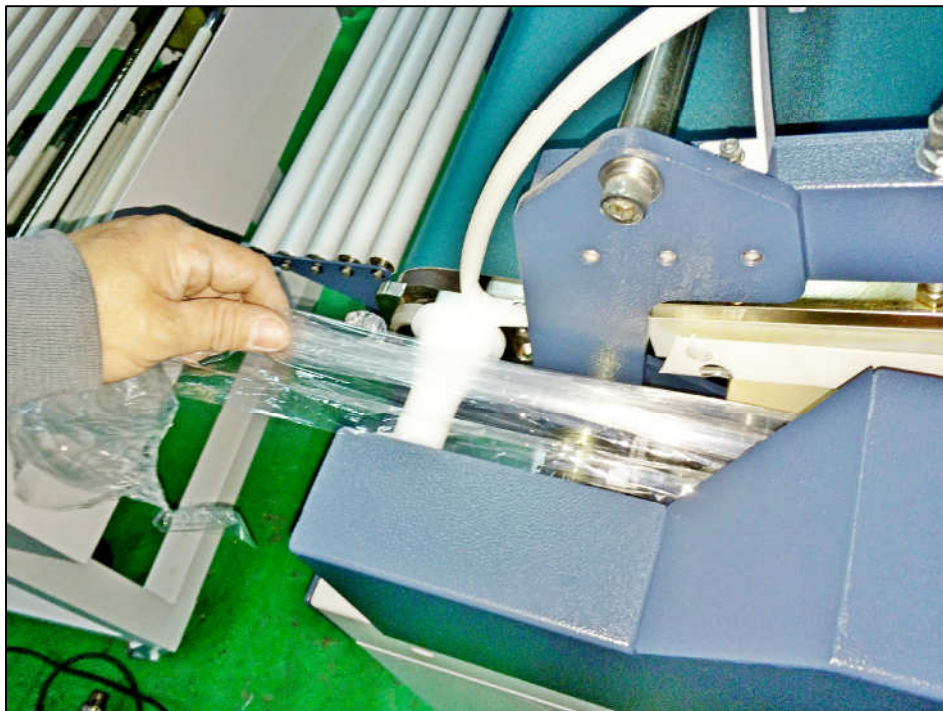
STEP8.When the sealing temperature reach the setting digits , to cover the sensor by hand for sealing function test.



STEP9.Sealing function test by manual.



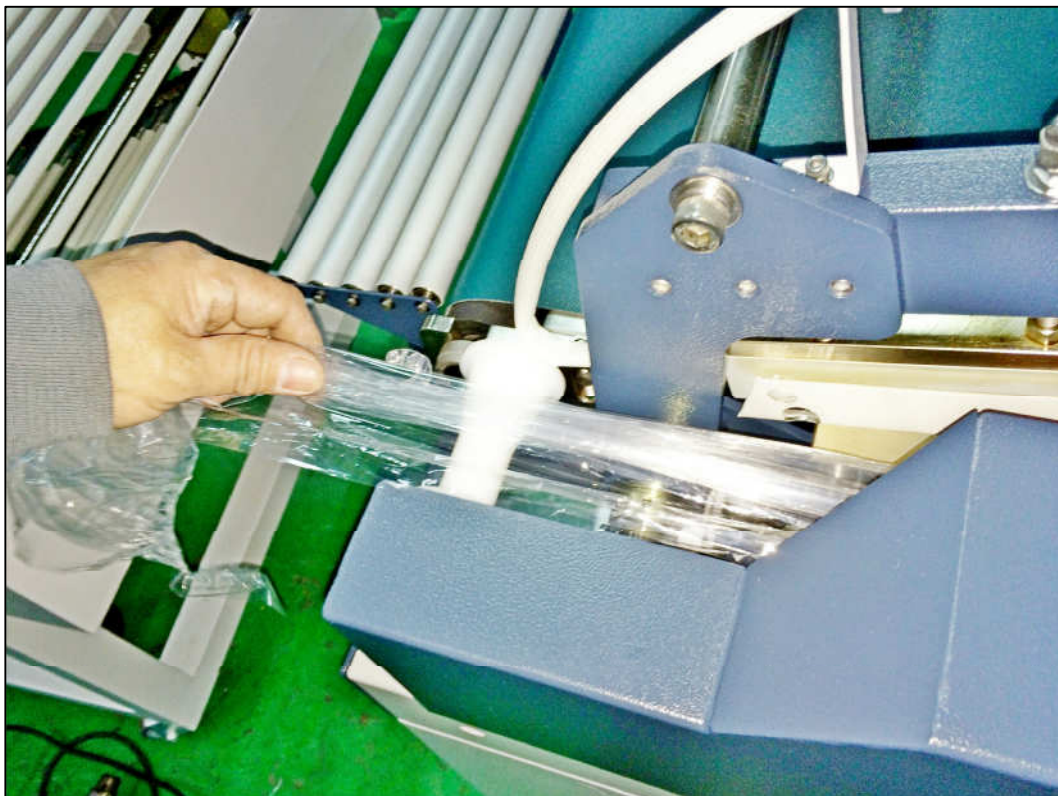
STEP10.For winding of waste film refer to the follow.



STEP11.Pull 1 mater waste film.



STEP12.Pass the waste film through the plastic guiding wheel.



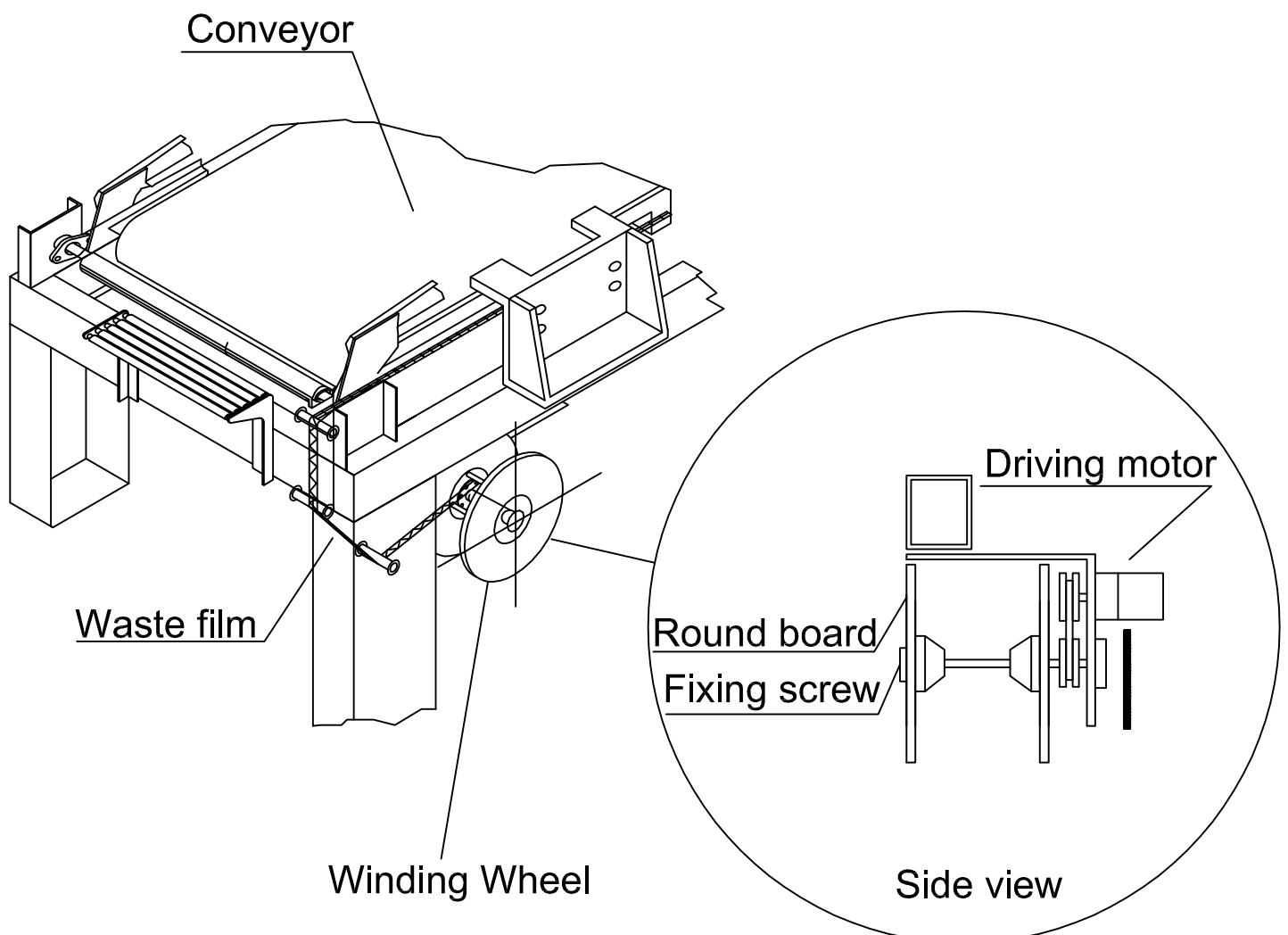
STEP13.Pass the plastic wheel which is under machine.



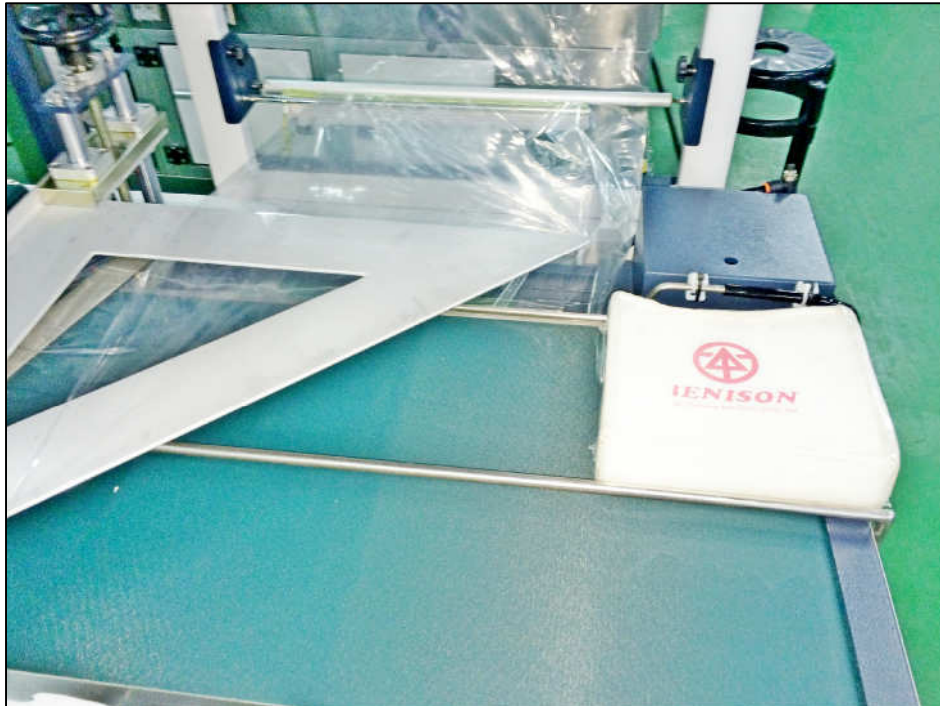
STEP14.Connect the waste film on winding wheel.



STEP15.Process finsh.



STEP16.Turn off the power ,then place the object
on the conveyor.



STEP17.Width adjusting handle.



1/2 height of object = the space between object with guide stick.

Example : = Object's height = 10 cm

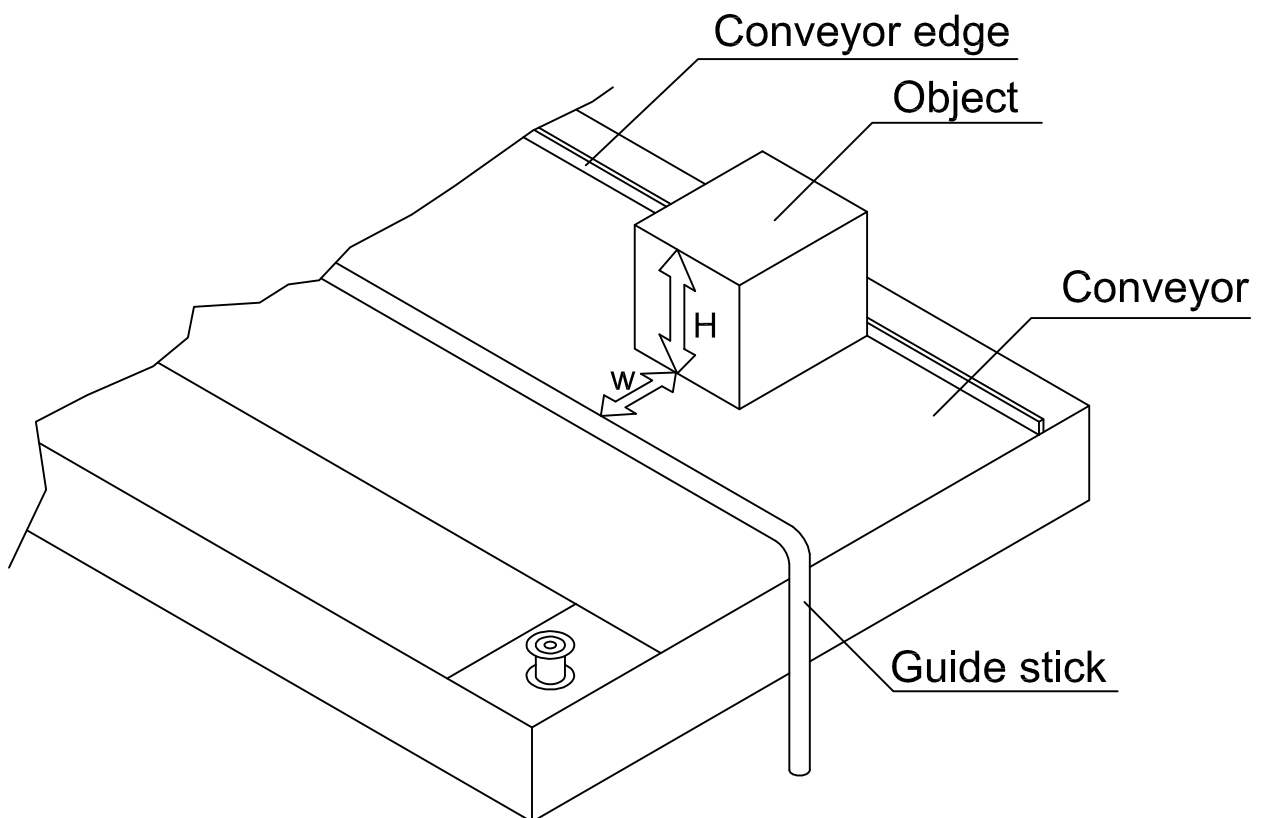
The space between object with guide stick.

$$W = 1/2 H$$

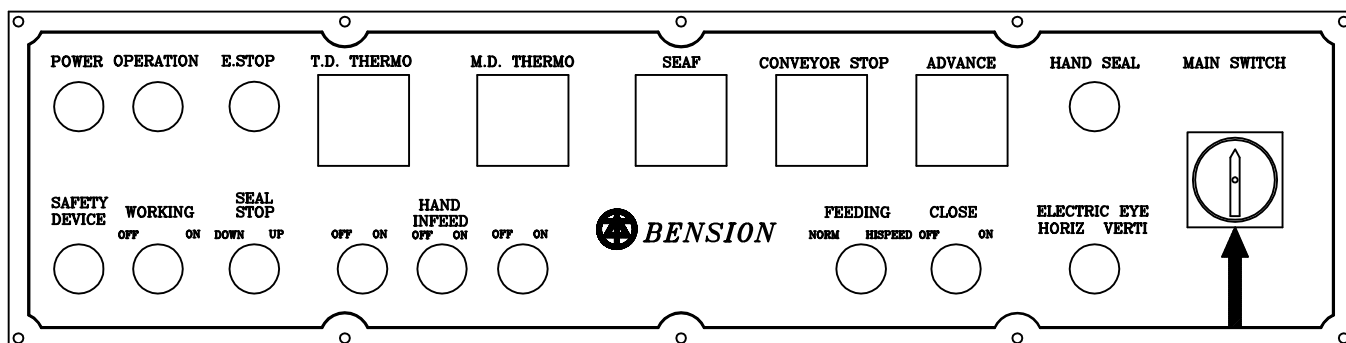
$$\text{space} = 5\text{cm}$$

H=Object's height

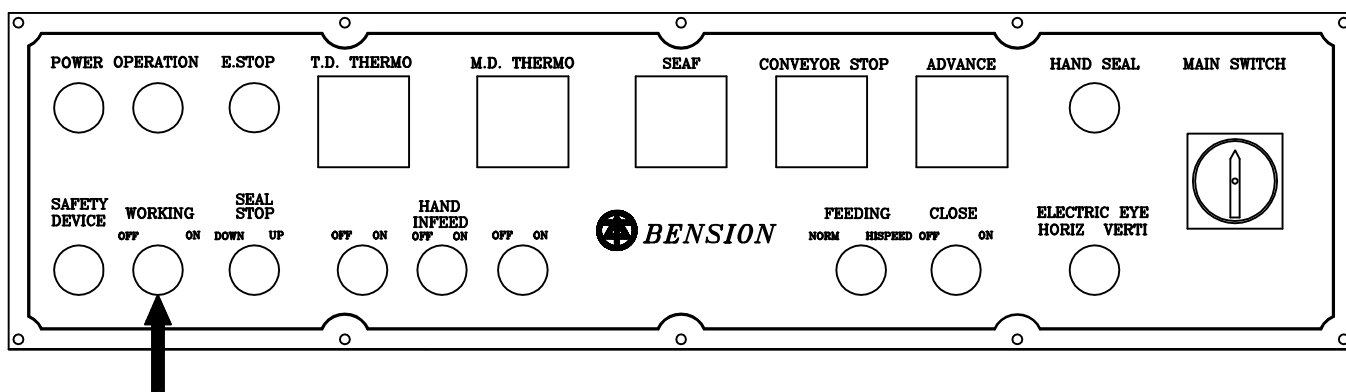
W=The space between object with guide stick.



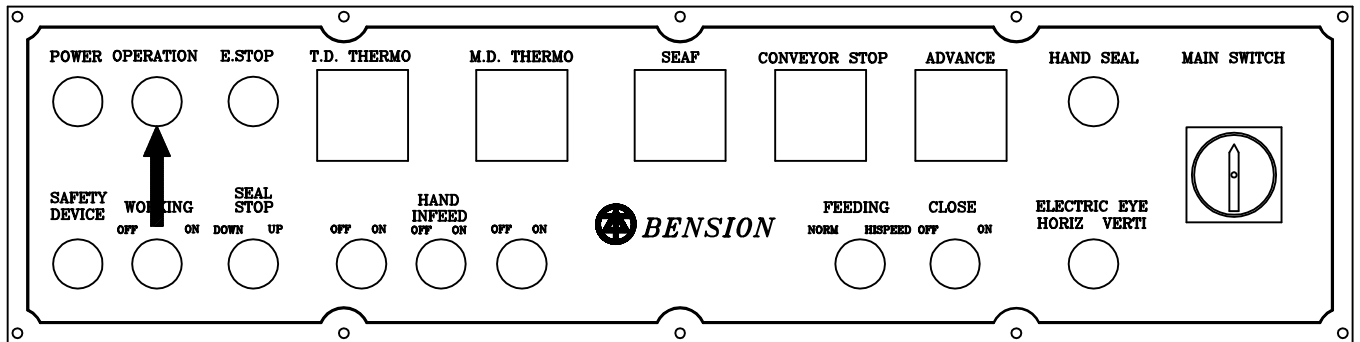
STEP18.Turn on the power.



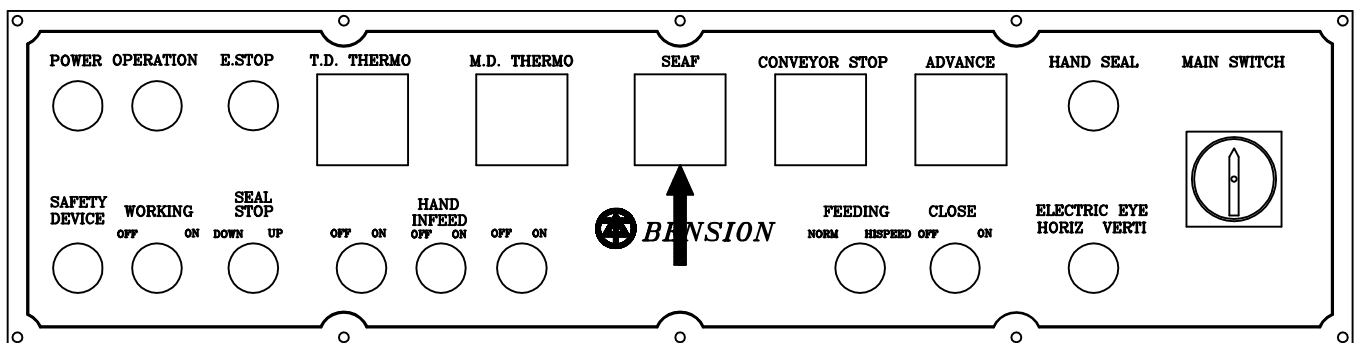
STEP19.Turn on the working switch.



STEP20.The working lamp lighted up after pressed the working switch.



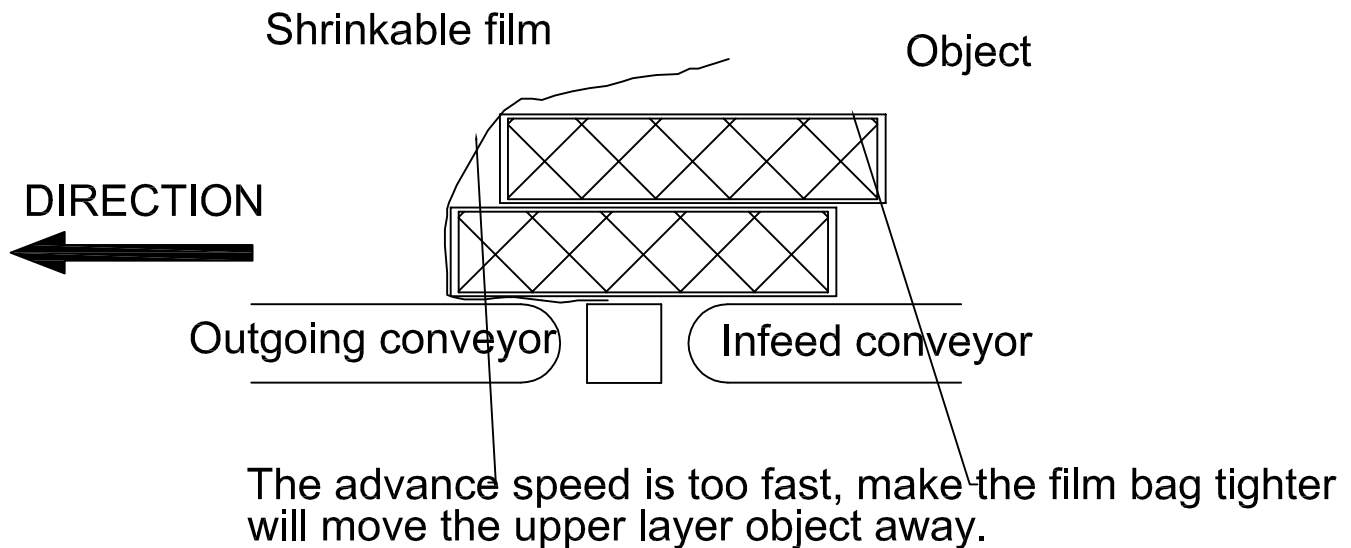
STEP21.Adjusting the times of conveyor stop & advance.



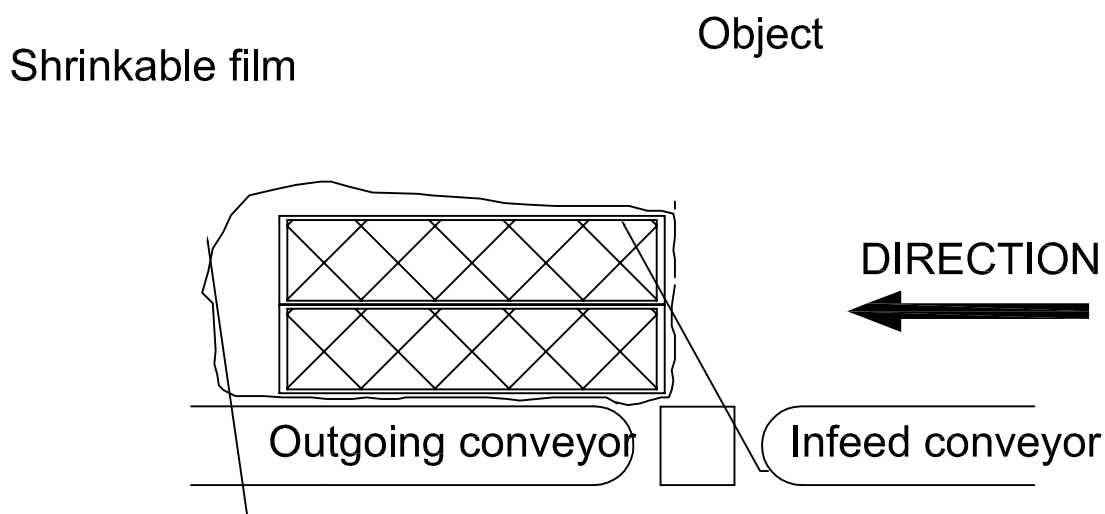
To adjust the function of conveyor stop & advance.

Advance

- (1). If the package height is more than 6 cm, the "Advance speed" must be adjusted. The speed too fast would influence the package.

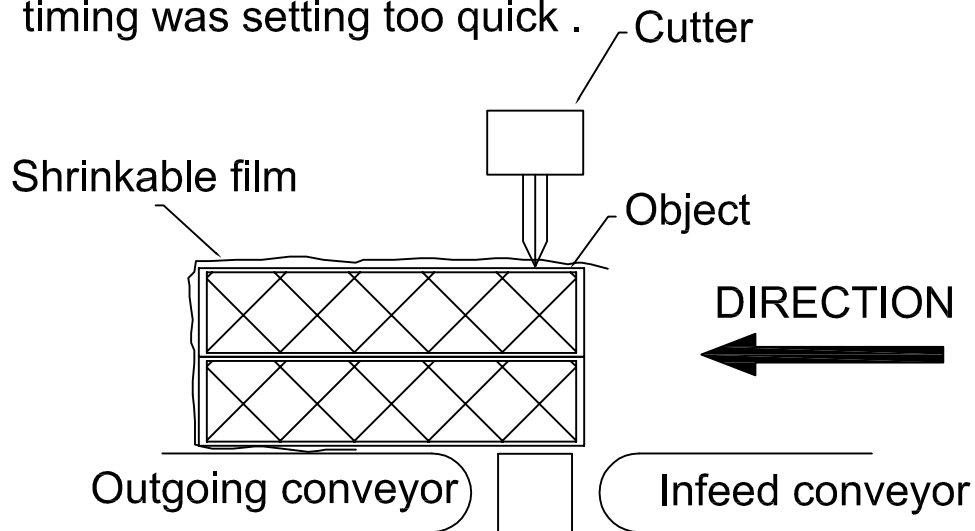


- (2). The advance speed is too slow, make the film bag looser; it will be effected on the quality of backage.

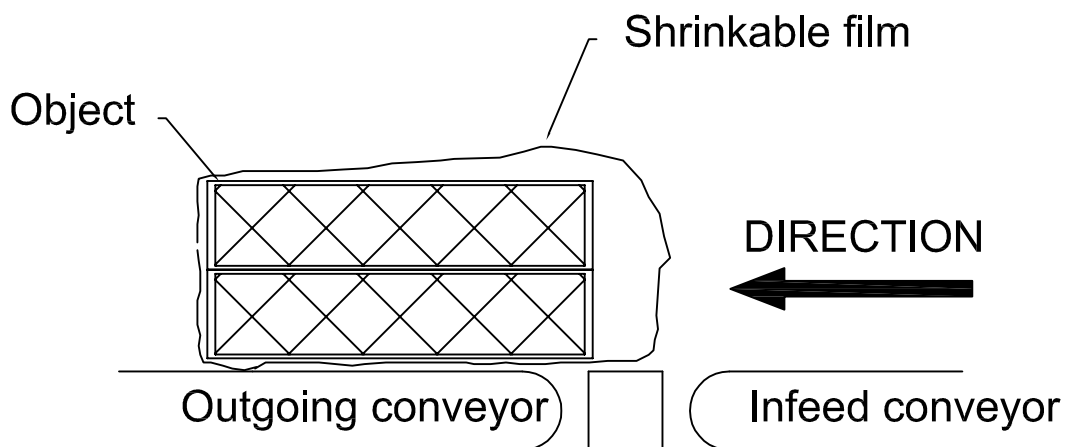


Conveyor stop

- (1). If the object's height is more than 6 cm, the function of conveyor stop timer must be started. The object might be cut by sealing cutter because of conveyor stop timing was setting too quick .

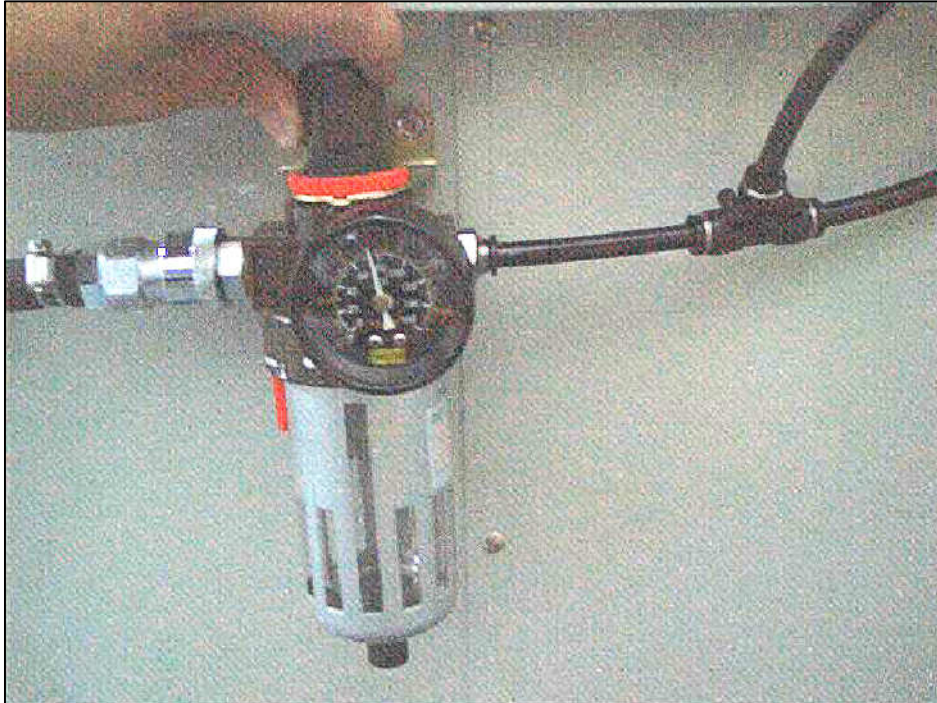


- (2). The conveyor stop timing setting too long make the film bag looser; it would effect on the quality of package.



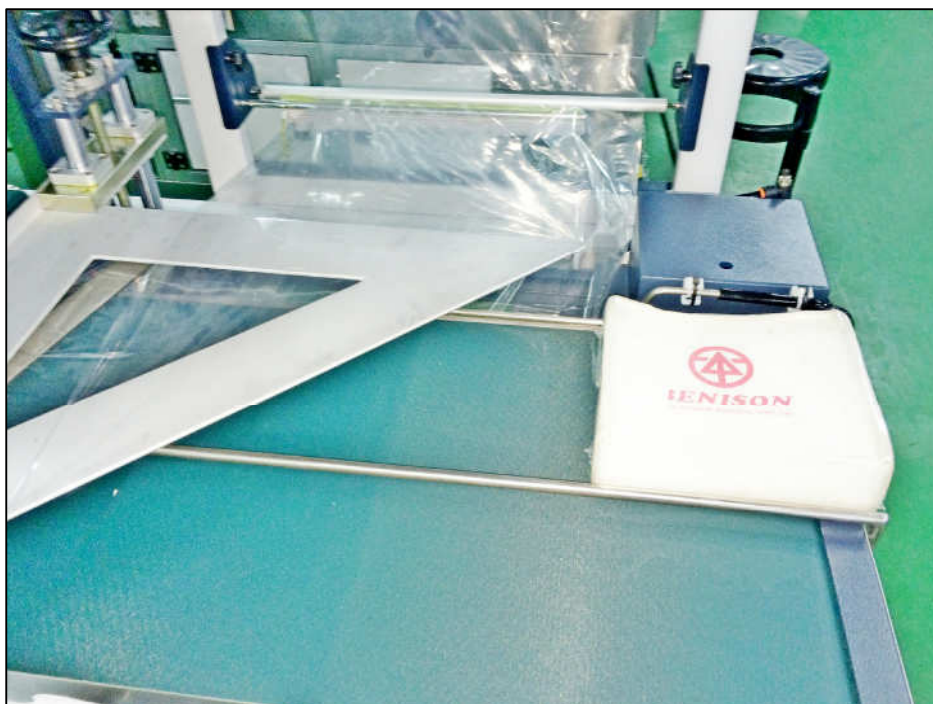
The conveyor stop timing setting too long make the film bag looser.

STEP22.Adjusting the air compressure.
(Pull up the button, set the air pressure on 5.5kg/square cm)

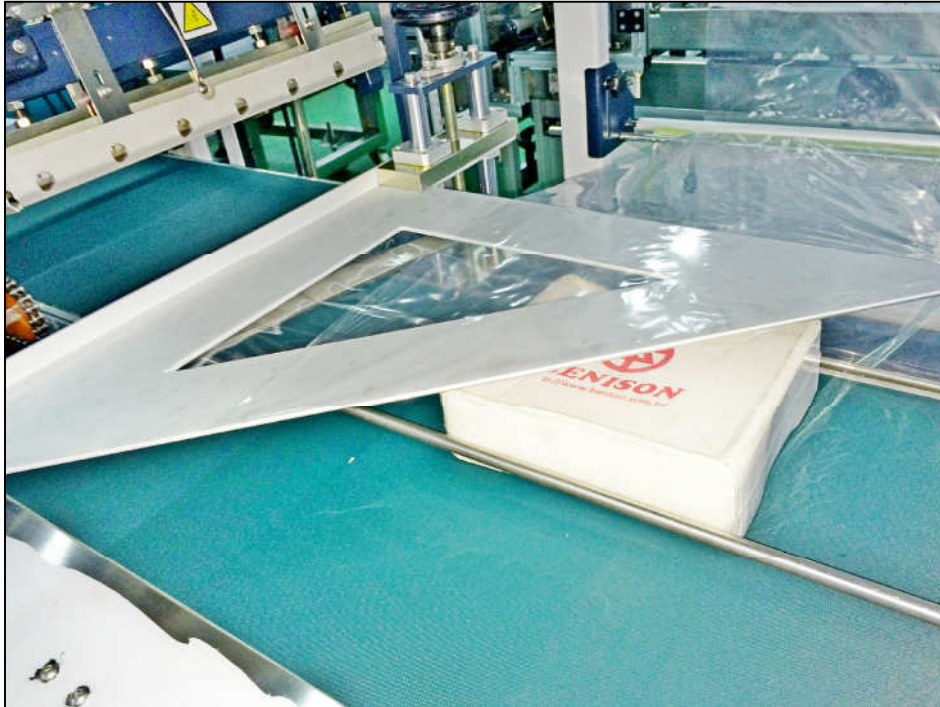


Notice : The machine would be operated unsmooth
because of air pressure is too weak.

STEP23.The packaging test.



STEP24. Passing through the triangle.



STEP25. Passing through the sealing area , than L-bar sealing.



STEP26. When the packaging process to be finished, the object is transferring to the rollers rack.



Test finished.

Emergency Stop

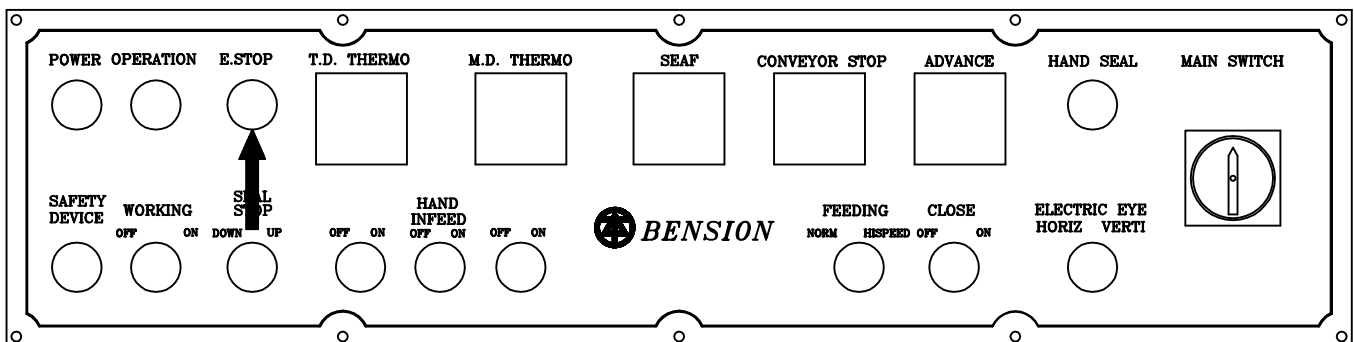
The machine has 2 emergency stop switch.

(1).emergency stop button.

(2).stop working switch .

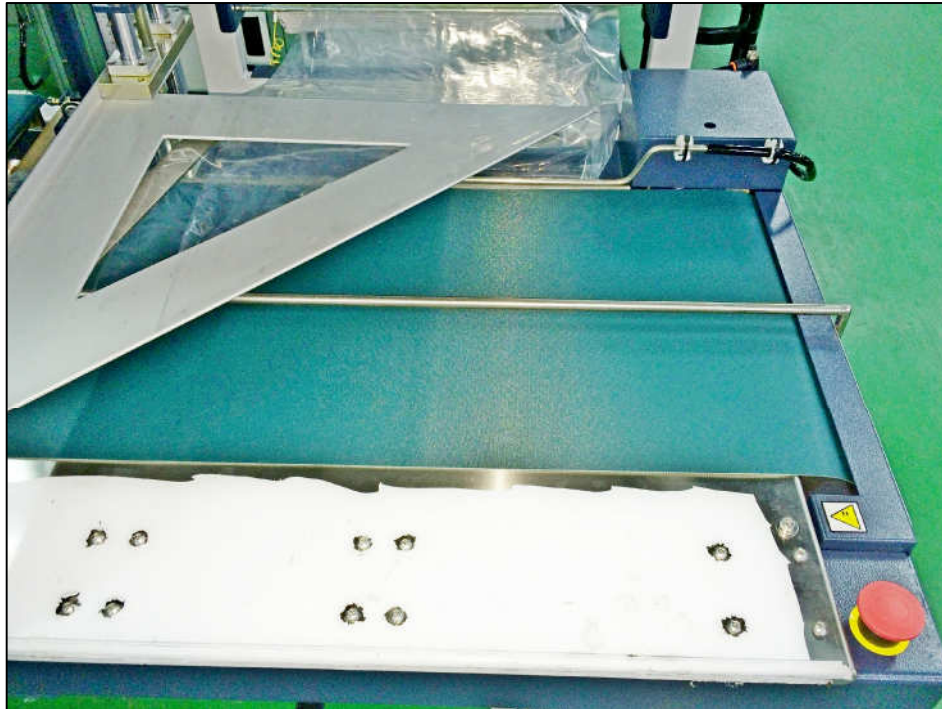
The emergency stop button is set on the front board of electric panel.

When pushing the button,the machine will stop operating and turn off the power.



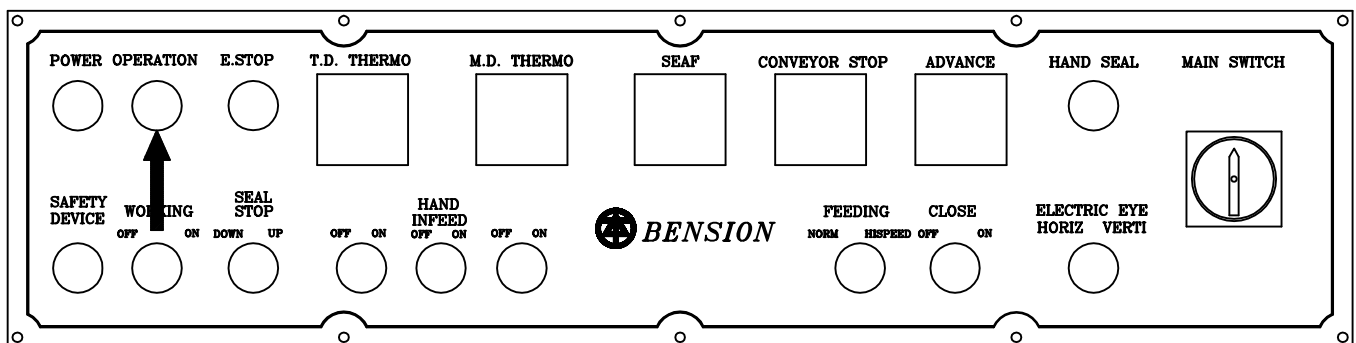
Twisting the button for reset.

(2).The stop working switch is set on right side of the machine,When pressing this button,the machine will be stopped running.



"Stop working switch"
is on the right side of machine.

Pressing the working switch,the machine resume work.



5. TROUBLE SHOOTING

5.1 HOW TO DEAL WITH THE TROUBLE

TROUBLES	CAUSES	SOLUTION
1. Control Power lamp Dose not light No-fuse braker Tripped	Power not connected. Fuse burned. Switch defective. Disconnected wire. Poor connection. Electrical leakage.	Replace part Switch on power Check heating wire Check all wiring Sections
2. Conveyor belt Belt can be Pushed by hand Belt cannot be Pushed by hand Failure under Normal status	Belt tension to loose. Belt tension too tight. Defective motor gear Head. Too tight driving chain Tension. Disconnected wire Defective motor Defective contact plug Defective relay unit Defective limit switch	Adjust belt tension Screw Adjust belt tension Screw Replace part Adjust driving chain Replace part
3. Materials Material output Roller failure Material moves	Disconnected wire Defective driving motor Defective relay unit Defective brake box Wrong material setting Position	Replace part Adjust

Zigzag line	Unbalanced material Tension lever. Wrong tension roller Posttion Wrong triangle Unfolder angle	
Material does Not move	Material punching Does not let material Roll-out Wrong rpm of material Mounting roller. Too tight clamping Chain tension. Too loose clamping Chain tension Insufficient oil.	Adjust spring Fill oil Adjust Fill oil
4. Sealing arm Sealing arm Fails to move	Disconnected wire Defective relay unit. Defective solenoid Insufficient air Pressure. Defective throttle valve	Replace part Check air Compressor
Sealing arm rises Abruptly	Throttle valve open Too quick Sealing time too short.	Adjust flow Control Adjust the time of Limit switch in Safety device Lengthen sealing Time
Sealing arm Lowers abruptly	Electronic sensor not Aligned horizontally Or vertically or dirty	Adjust, wipe clean Adjust

5. Sealing Heating temp. does Not rise	Fuse burned Disconnected heating Wire Defective relay unit Power of single phase	Replace part
Adjusting Temperature Inability	Defective temperature Regulator Defective temperature Sensor	Replace part
Safety device Failure	Disconnected wire Defective limit switch Defective relay unit Insufficient air pressure	Replace part Adjust Replace part Check pressure
Sealing not Strong	Sealing cutter defective Heating temperature Too low Sealing time too short Air pressure too weak Sealing cutter heat Insufficient	Replace new Cutter Adjust Check Replace

5.2 Parts replacment & technical support

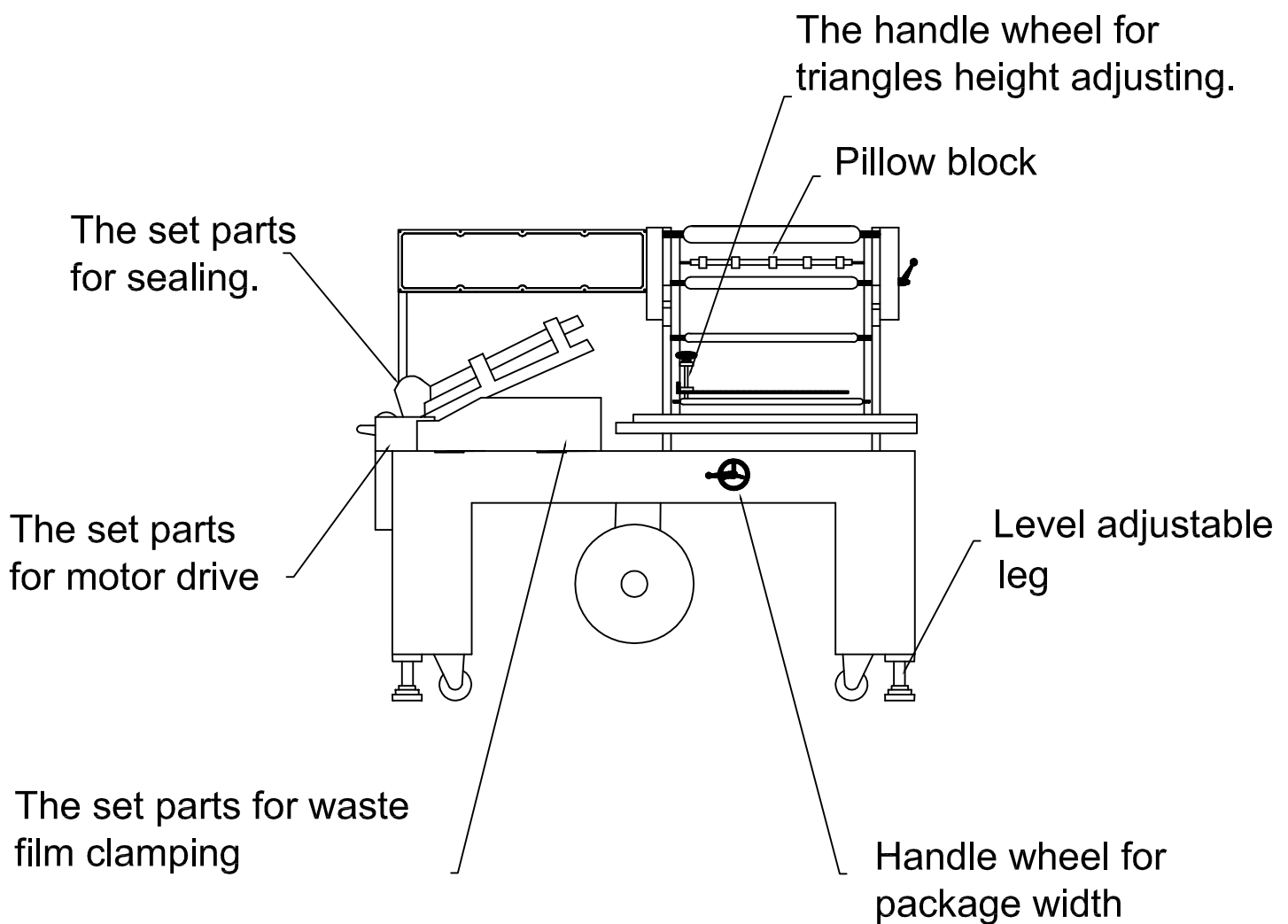
We have a technical service department to offer the service 24 hours a day.

- 1.The technical service engineers stands by for machine installation , customer training & maintenance.
- 2.We offer one year warranty for new machine.
- 3.The machine is prohibited to change the design, or use the parts of different specification. If so we reserve the rights to cancel the warranty.
- 4.However, please inform our engineer for parts replacement
The customer could replace the parts by themselves, but the parts model & brand must be as same as original one.
- 5.All the maintenance process should be followed the instructions in this manuel to prevent danger from maintaining.

6. MAINTENANCE

6.1 greasing

1. Please use the brush, cloth or compressed air to clean the surface of machine.
2. Please grease the machine just follow the arrow head.
3. Don't grease the conveyor belt to avoid the belt sliding.
4. Please use the silicon oil to protect the cutter.



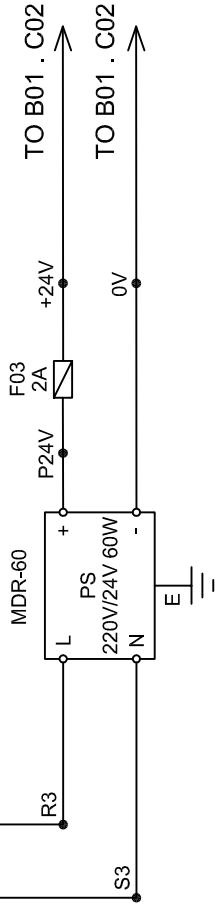
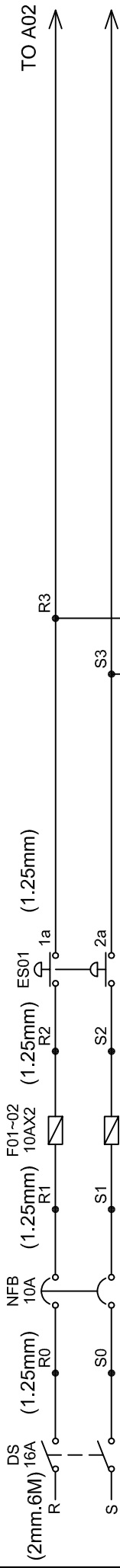
6.2 OUTWARD CLEANING AND MAINTENANCE

1. After daily operation, carefully wipe clean the sealing cutter with a soft cloth.
2. The machine is not built to be waterproof function. Please clean the machine by wet cloth.. It is prohibited to splash water on the machine.
3. The machine has been coated by anti-dust process, but still should avoid to contact with acid liquid or gas.

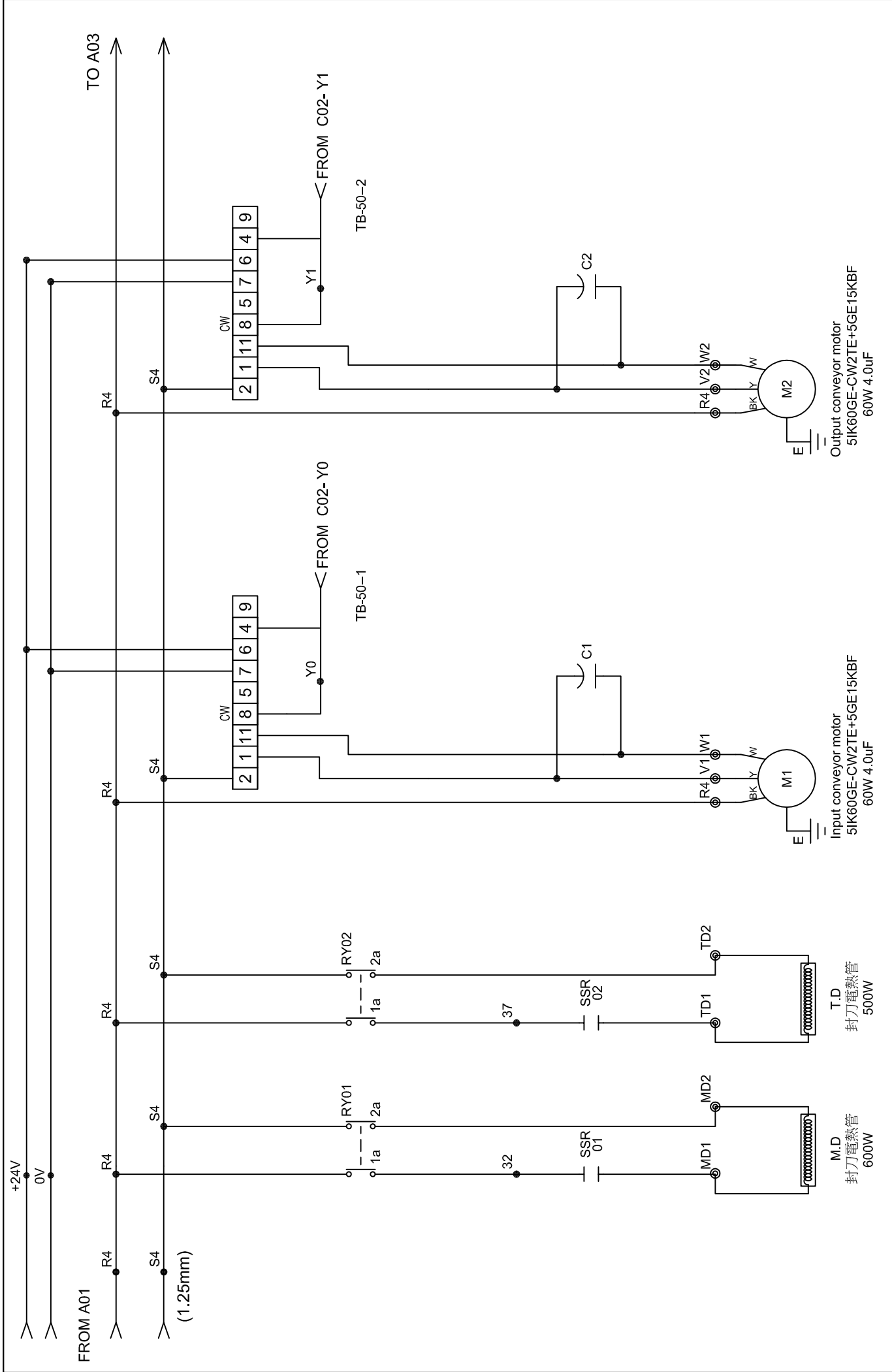
7.2 BE CAUTION OF WASTED MACHINE DISPOSAL

When the machine is wasted, please dispose it according to the wastage regulations, must do not dumping it willinly.

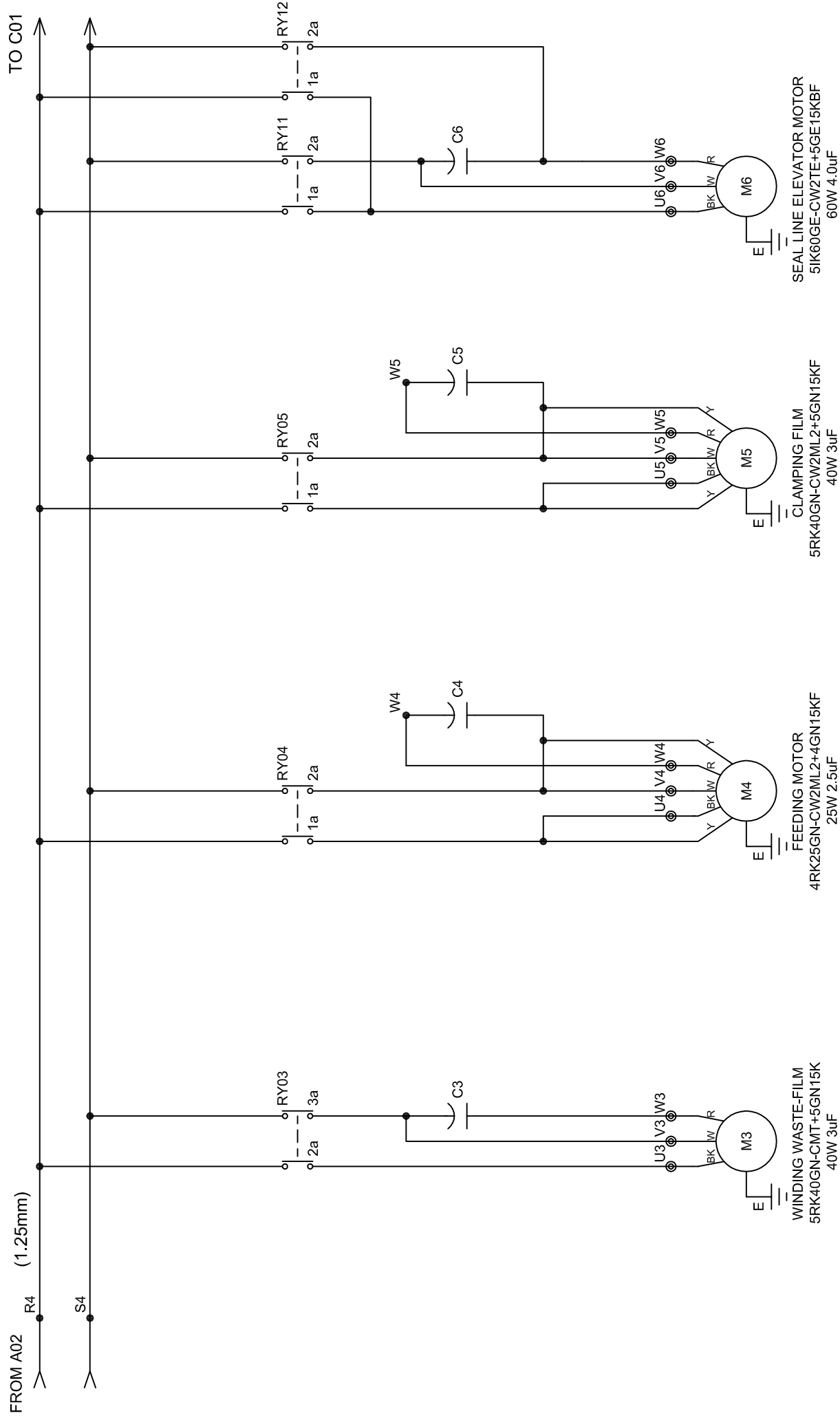
1ØAC220V 50/60HZ



 BENISON & CO., LTD.		Electric circuit diagram	Machine codename	Date	Approved	Check	Draw
		LSA-504G(CE)-A01	LSA-504G(CE)	2021.09.16			Sam.Xuan



	BENISON & CO., LTD.		Electric circuit diagram		Machine codename	Date	Approved	Check	Draw
			LSA-504G(CE)-A02		LSA-504G(CE)	2024.09.03			FRANK



BENISON & CO., LTD.



Electric circuit diagram

LSA-504G(CE)-A03

Machine codename

LSA-504G(CE)

Date

2021.09.16

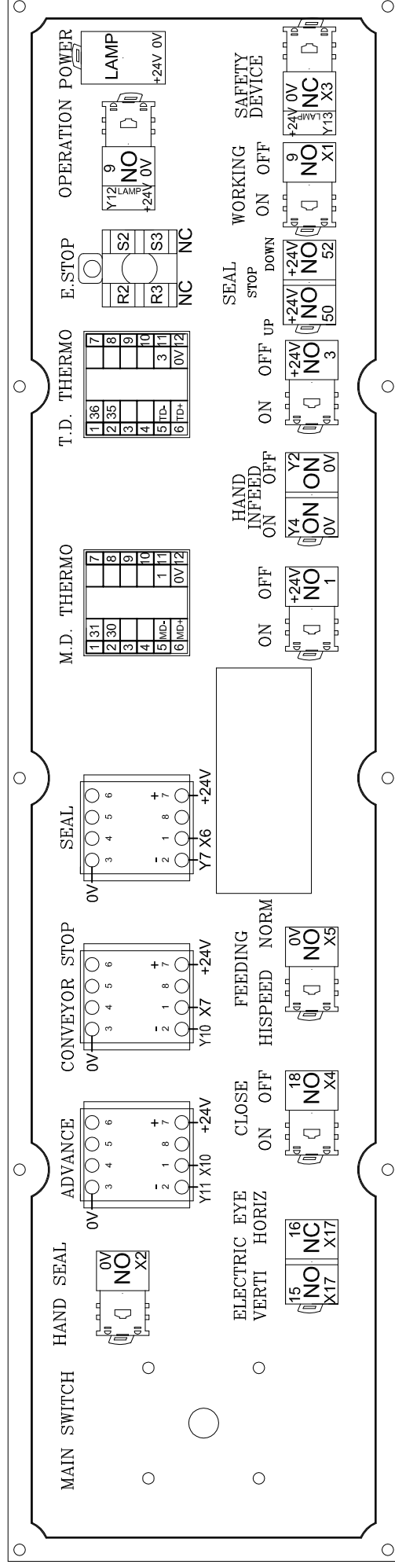
Approved

Check

Draw

Sam.Xuan

BS-003-004



 BENISON & CO., LTD.		Electric circuit diagram		Machine codename	Date	Approved	Check	Draw
		LSA-504G(CE)-E01		LSA-504G(CE)	2021.09.16			Sam.Xuan

