

XTRAVAC RBF8

Providing Quality with Economical Solutions



XtraVac • RBF8 Rotary Filling and Sealing Machine for Pre-made Pouches Operation, Service & Parts Manual

XTRAVAC
Providing Quality with Economical Solutions

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PREFACE

Thank you for buying our Rotary Filling and Sealing Machine for Premade Pouches RBF8. This manual is used for guaranteeing the right way to use and operate this machine. Please read it carefully, the characteristic, procedure of operation and explanation of use in order to understand each function completely before starting this machine.

The RBF8 machine is designed with advanced HMI which makes operation simple and easy. We are sure you will be totally satisfied with the practicability, dependability and economic efficiency of this machine. But the structure of machine and operation will differ to some extent according to various use of characteristic and content of Packaging thing. Please consult the appendix of reading, by understanding special difference more completely cutting even more; it is a basic function to be stated in this manual.

This machine was designed according to the standard of the high safety in operation, so it will not damage and does not work because of careless operation or press the switch by mistake. If any question occurs, please read this manual carefully; implement the requisite measure, in order to operate this machine effectively.

Before shipping this machine, every part of devices had been careful detected and debugged. However, if any mechanical breakdown takes place in the course of shipping, or originally proves that if there is anything that isn't understandable, please contact our company or authorized sale agent of our company.

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CHAPTER 1 SAFETY PRECAUTION

1.Safety requirements

1.Operating personnel safety and compliance matters

Mechanical operation, maintenance, and installation must be authorized and specially trained personnel to perform. These personnel must have the machine possible risk that special courses. Especially the electric unit of work, must by trained personnel to operate.

Any assigned to operation, maintenance and installation personnel must read and understand the machine related technical documents. Recommends that all people must have written confirmation. On the premise of safety, operation, maintenance, and repair duties must be defined clearly and observe, can not have no clear regional and incompetent.

1.Operating safety rules and compliance matters:

- 1.unfair damage resulting from the use of machinery can not be attributed to the manufacturer, and not included in the project.The risk to be all alone.
- 2.according to the manufacturer to provide the installation, operation, transportation and maintenance instructions to correctly use the machine.
- 3.should avoid the use of any reduction in security methods to operate machinery.
- 4 the machine placed sit, should avoid direct sunlight and damp, dusty. Because it is caused by the fire and electric shock..
- 5 other improper use of machinery (such as "according to their own views and use the machine")
- 6 the machine design requirements, the normal preparation work, only the machine can work in the best shape under the stage.
- 7 confirmed that the machine is only used for general goods (excluding poisonous articles; acid: alkali items) can not be used, and other goods packaging, otherwise, manufacturers and agents do not bear any responsibility
- 8 installation, dismantling, moving the equipment should have professional operation or guidance.
- 9 must go through professional training qualified people to operate the machine.
- 10 the equipment only in accordance with the purposes specified by the manufacturer, unauthorized modification or the use of non zero accessories sold or recommended by the manufacturer may cause fire, electric shock and other injuries.
- 11 Does not allow the linen, scraps of paper, dust, metal debris, dirt and other debris into the electrical equipment.

12 Connect the power used by the cable shall ensure that there is sufficient capacity, the use of a terminal insulation casing.

13. After Long time preservation to use this equipment, must be checked and trial run before use.

14. When the power supply has been delivered or the machine is running, do not open the distribution box and junction box. Otherwise, electric shock may happen, cause personal injury; at the same time on the machine is not near the arc welding operation. Otherwise, easy cause the machine break down.

15. When the distribution box has been opened or bare wire, not running the machine and its ancillary facilities.

Otherwise, may be affected by the high voltage terminal or bare wire in the electric shock, injury.

16. In addition to the regular inspection or wiring, other any time all can not open the electrical equipment shell. Otherwise, may damage the equipment, affecting the normal operation of the machine.

17. When connect cable or inspection regular, should be operating in the demolition of the input power for at least 10 minutes. Otherwise, electric shock may happen, resulting in personal injury.

18. The machines must be reliable grounding, grounding resistance less than 100 ohm. Otherwise, electric shock may happen, resulting in personal injury.

19. don't make cable by scratches, extrusion, over voltage and over load. Otherwise, electric shock may happen, resulting in personal injury.

20. The machine please do not contact with water and steam, wet hands is best not to touch, with dry hands start switch. Otherwise, electric shock may happen, resulting impersonal injury

21. Substrate, switch, frequency converter, motor drive circuit, the program in the terminal state, the absolute prohibition of tested with high resistance tester. Otherwise lead to machine failure or accident.

22. Before using the machine, please clean up the environment, should not have dangerous goods etc..

23. Clothing is without prejudice to the operation, try to light. Especially the work shirt cuff must fasten, cannot open.

24. The machine after electrify, throughout the enclosure removed and put in his hand and other occasions, the risk may be involved.

25. Electricity, pay attention to high temperature mark, when the hand does not pay attention to the touch, may cause burns. Shaft and other parts of the machine prominent, do not pay attention to.

26. Even to switch off the power supply, heating area will not immediately cooling. Do not use hand touch, very likely scald, need to turn off the power after about 30 minutes, cooled to room temperature.

27. Don't put things on the machine. The machine around don't stack has items to do with the machine. Too much, there may be an accident. In addition, packing material mixed with foreign body or machine parts to bite into sundry goods, will damage the machine.

27. Open or shut down the safety cover, be careful not to hurt hands or fingers

28. Installation film reel to note, not slide from the hand, lest injured foot.

29. Put hand into the gap between the bag and feeding conveyor, easy to injury.

30. To change knife must be careful, the blade easy to hurt fingers.

Warn.

The operator can't change the structure and mode of production or modify the machine. The damage caused by the manufacturer, therefore, does not take any responsibility

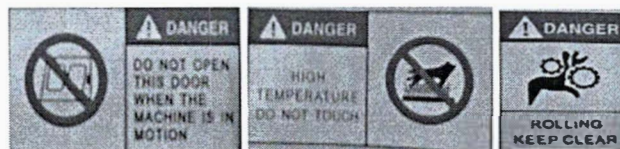
Emergency shutdown

When an error occurs, the operating personnel must be in accordance with their experience to judge whether things immediately emergency shutdown or shall take other steps (the first stop the controller).

The use of the main power to shut down

When the error occurred, if not improve in a short period of time (subject to repair or maintenance staff) can be used to shut down the main power supply.

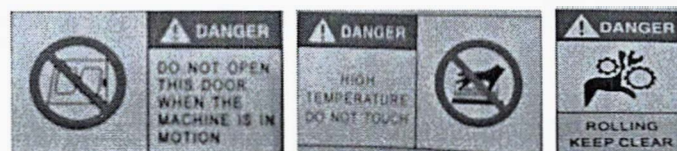
2. Danger Warnings and instructions



Please note that all of the security information on the device!

"The danger zone

According to (EN ISO 12100-1) defined, "danger zone" refers to the region and its surrounding machinery is located, safety or health hazards to any person may have in these areas.



DANGER. Not come into operation!

DANGER. High temperature!

DANGER. Carefully clip hand rolling!

Electric shock! DANGER.

Warn.



(1) DANGER. Careful

If the front Gate, back door, side door open during operation, emergency stop limiting device will start, the machine will stop.



(2) DANGER. High temperature! Crush!

With this warning components (sealing and cutting part) will become very hot in the machine during the operation. Be especially careful, burns in case detection, adjustment during operation.



(3) DANGER. Carefully clip hand rolling!

With this warning components (feeding part) is the automatic control, to be especially careful in testing, debugging or cleaning guide bag device.



(4) Electric shock! DANGER.

With this warning signs of parts (part of the control box) containing electrical appliances, operating in the process of finger touch electrical accidents.

Warn.

It must be the power source of the user to prepare the necessary ground facilities, to prevent electric shock or any other accidents.

☆ to prevent any electrical or mechanical failure, not to the distribution box into any water, liquid or metal materials.

☆ at boot time, must close the door control box, to prevent in the process inadvertently touch finger electrical accidents.

2.health and environmental requirements

1.Environmental Hygiene requirements:The equipment for food packaging: and the equipment, the environment needs to be dust, bacteria.

2.machine operators and maintenance personnel hygiene requirements for food packaging: with this equipment, and all equipment contact person, must wear masks,hats, dust control.

3.Personal protective equipment when working with 3 operators must be sterile

3. The standard basis of the machine design and manufacturing

The basic concept, 12100-1:2003 machine safety design with EN ISO general principle. The first part: the basic terminology, methodology

The basic concept, 12100-2:2002 machine safety design with EN ISO general principle. The second part: technical principles

EN 415-3:1999 packaging machinery safety Part third: forming, filling and sealing machine

EN 60204-1:1997 safety of machinery - electrical equipment of machines - part first: General technical conditions.

4. Machine installation, packing and shipping instructions

1. The first installation

1. Open the packing box, according to the packing list contents, check that all things are complete, if not please contact the company or agent,

2. The equipment installed in horizontal ground lighting is good, good ventilation, ground firm level. Apply level, the adjustment foot height, reaching the level of. Check the machine parts are loose in the transport process, the equipment in contact with food is not part of anhydrous alcohol carefully cleaned again, can be used.

3. The equipment with 20A above 380VAC power supply (a live wire, a zero line, a ground line), power line wire diameter of not less than 4 square millimeters of copper wire;

4. When the supply voltage is incorrect, please use the transformer (and other accessories).

In order to personal safety and protection of the machine, must ground (more than three types of grounding method).

5. The machine even if there is a slight leakage, the computer will not work properly.

Please avoid direct sunlight. The installation environment temperature 0 - 40 °C, relative humidity 35 ~ 85%, there should be no sharp temperature and humidity change.

6. Before the machine power line connected with the electric box, check the operation panel side of main power switch is in the OFF (open), if not here, please use the hand rotating to OFF, to avoid accidental injury.

5. Corrosion objects can damage the machine, should not contact

1. packaging

When the equipment for a long time not in use, must use sterile membrane package the equipment, stored in a cool dry place.

2. transport

When you prepare the equipment long-distance transportation, must use wooden cases the equipment bag, desiccant placed in wooden cases. If the device to navigation, so wooden material must be sailing wood material, and good anticorrosion work in the machine surface.

(1) General preventive measures:

The use of the equipment according to the standard operation procedure;

(2) In the use of the equipment, must carefully read this manual, understand the relevant operating procedures to thoroughly.

(3) Follow the instructions, pay attention to safety, all that information, to ensure proper operation and correct use of the special function of all.

(4) The manual shall be stored in a convenient to take place, in order to see.

Chapter 2 MAINTENANCE

2.1 Refill oil timely to the places where gears mesh, to the oil holes, and to the moving parts.

2.2 Never run the reduction gears without oil. Change the oil after 40 hours of initial run, and then change the oil every 3 months of operation.

Oils recommendation:

Ambient temperature	Oil selection
-5°C--50°C	gear oil HL-20 or machine oil HL-50
-40°C	Gear oil HL-30 or machine oil HL-50

2.3 Clean the machine one time at the end of each work-shift. Clear out any residuals in the measuring plates and in the platforms of the machine to avoid any moisture that would affect the next shift of operation.

2.4 Check regularly for loosening of fix screws at every component, to ensure a reliable operation.

2.5 Clean regularly the photo head.

2.6 Take care to prevent moisture and dust for the electric parts.

Caution.

Components must be replaced by the original configuration, can not find the original components, please contact with agents and manufacturers!

CHAPTER 3 GENERAL DESCRIPTION

3.1 General description:

RBF8 automatic Form Fill Seal packaging machine adopt the advanced technology from Oversea, we design it to a high quality, high-powered fully auto feeding, measuring, forming, filling, sealing, printing date and product carry-out packaging machine after improving. This machine adopt the high accuracy cam system, PLC control, advanced touch screen, photocell auto orientation tracking, PID temperature control, it can make the machine operation more simply, perfect, it is the best equipment for food line for high production efficiency, low labor intensity.

This is a unit of Automatic Packing Sealing Machine, suitable for cold rolled aluminum foil laminate or multi-layer laminate sachet packing. It adopts auger screw filling system. It can continuously supply and fill into sachet of different products, and to produce single cut or continuous sachet packing.

3.2 Specifications

- 1) Product:
- 2) Packing material: Nylon/ PET laminate; PET/PET laminate; Nylon/Aluminum Foil/PET laminate; PET/Aluminum Foil laminate; PET/any heat seal material laminate (the packing material mustn't be the material of flammable, explosive, corrosive listed on the dangerous chemical goods or substance)
- ☆ please consult Alpha-Pack for assistance, to reconfirm the base material and structure of laminates for special application.
- 3) Capacity: 0-40 pack/min.
- 4) Power: 220V, 50/60 Hz, three-phase, 4KW Current: 15A. Power: 380V/3PH, current: 8A.
- 5) Machine weight: 1000kg
- 7) Air pressure: 0.6-0.8Mpa
- 8) Gas consumption: 300NL/MIN

CHAPTER 4 CONTROL PANEL OPERATION

- 4.1 Turn on the power supply switch
- 4.2 Set up the temperatures
- 4.3 Set up parameters for the operation;
- 4.4 Install the packing film (according to the film installation drawing
- 4.5 Test run with empty bags;
- 4.6 Operate with filled bags.

[Caution]

Before starting the machine, check items as follows:

- ☆ Has the temperature at the heater reached the set value for the temperature as specified?

If the set temperature has not reached the specified value, please refer to Chapters and Sections concerning troubles shooting.

- ☆ Whether or not the safety items have been fulfilled? (The machine cannot be operated if the emergency stop switch has been pressed down, and the safety device has been activated.)

- ☆ Whether or not the settings of operational functions are all right?

Install the film, adjust every unit as the chapter 7 described, then the machine can be used.

CHAPTER 5 CONTROL PANEL OPERATION

5.1 Control panel operation instructions:



1) **Power switch(Equipment front)**

When you turn the power switch 90° clockwise, the machine will power on, at this time the panel parameter can be set and machine can be moved, the temperature controller working, when you turn the power switch 90° counter clockwise, the machine will power off.



2) **Start/stop switch(Equipment front)**

When press this start/stop switch, the machine will start, the button light will be on, when you press it again, the machine will stop, and the button light will be off.

[[CAUTION]]

If you want to start the machine, you must close the film transport cylinder by hand, otherwise, you can't start the machine, please refer to the manual operation section for the detailed operation.



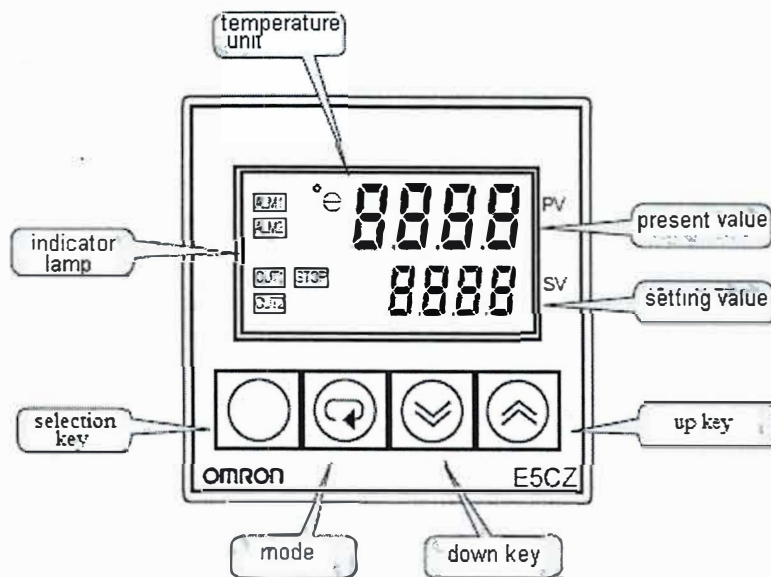
3) **Emergency switch(Equipment front)**

If the malfunction or emergency occur when the machine moving, press the emergency switch, the machine will stop immediately. And the touch screen will display "Emergency Stop!!" Unlock the switch (press the emergency switch and turn right), the machine will start again, at that time "Emergency Stop!!" will disappear

NOTICE: Please make sure that the thermal layer has been filled with water fully before starting the function.

Temperature control (PID control) operation instruction:

5.21 1) Omron temperature controller description, used for the sealing temperature of



the sealer 0 ~ 1000°C. The temperature sensor to this control is K type

As displayed in the above figure

1. Display:

The first line: Display the value of PV(Present Value) current temperature value or current values of other items. All the lights start will need about 1 second.

The second Line: Display the value of SP(Setting Point) temperature setting point or values of other setting items.

2. Mode Indicator Lamp:

ALM1: When it is ON, the lamp will light.

ALM2: When it is ON, the lamp will light.

ALM3: When it is ON, the lamp will light.

HA: When Heater disconnection or short circuit, the lamp will light.

3. OUT1: Control output 1, When it is ON, the lamp will light.

OUT2: Control heating and cooling output, When it is ON, the lamp will light.

4. STOP: When machine stops running, the lamp will light. When the machine is under controlling, set the Run/Stop to Stop, the lamp will light.

5. CMW: Control message write. When "Enable" message write, the lamp will light. When "Disable" message write, the lamp will not light.

6. MANU: Manual mode. When set AUTO/MANUAL mode to MANU, the lamp will light.

7. Locking key: When setting values change the protection the lamp will light. (when + is disable in Protection state)

8. Temperature Unit: When set the display unit parameter to temperature, it displays Temperature unit. The current Temperature unit value determines the display. The display C indicates “°C”, The display F indicates “°F”. In ST operation, this display lamp flashing.

9. Setting of the keys:

 : Press this key to select setup menu. The selection sequence of the setup menu is: Operation menu, Adjustment menu, Initial menu, Communication menu.

 : Press this key to set parameters.

operation step

Implement the automatic adjustment (AT).

Modulate the menu



Implement
cancel AT

(1) press  button, less than 1s, switch the “working menu” to “adjustment menu”



(2) press  start to implement AT (automatic implement) during AT implement, display “0n”.



(3) When AT finished, display “0FF”



PV

(4) Press  return back to rotating menu

 : Every time you press this key, the value of the second display will increase. The longer you press this key, the faster the value changes.

 : Every time you press this key, the value of the second display will decrease.

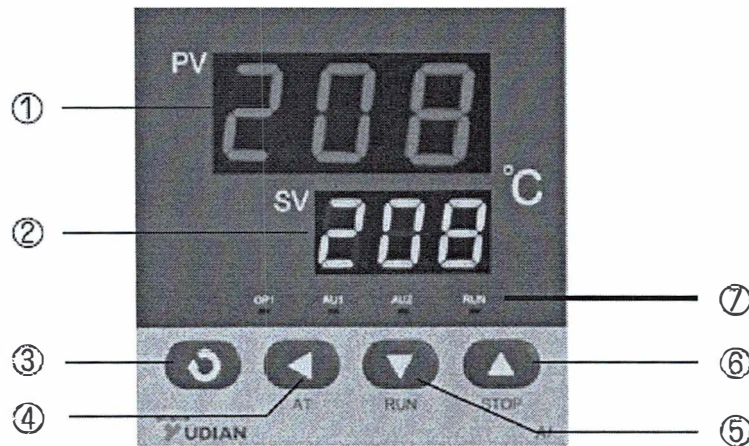
The longer you press this key, the faster the value changes.

 +  : Press the two keys simultaneously to enter into Protection menu.

 + ,  + : This is for restrict the setting values (In order to prevent accidents or misuse). Press those keys simultaneously to active this function.

2) Yudian Temperature Controller Description

1) Temperature control is used for the sealing temperature of the sealer 0 ~ 400 °C . The temperature to this control is K type



1) As displayed in the above picture:

- ① Display the value of PV (the present value), and the parameters.
- ② Display the value of SV (the temperature), alarm signals, and parameters.
- ③ For setting parameters, and confirming changes to them.
- ④ For data shift (start self-adjusting)
- ⑤ For decreasing data
- ⑥ For increasing data
- ⑦ LED indicator lamp : OP1 、 AU1 、 AU2 、 RUN suggest output, alarming assistant showing 1, 2, and running indicator lamp.

When the meter gets electrified, ① shows the measurement of PV; ② shows SV, which is the primary state of the meter. When the input value is beyond its range (for example, the thermocouple is off), it will display as “orA” or its minimum / maximum value, and it will stop showing values.

1、 Basic operation:

When the meter is in its primary showing state, adjustment to the measurement of temperature is available through    ; press  to decrease data, while  is to increase. The dot in the value is flashing when some changes is made to the value, and when keep pressing the button, the data showing will get decreased or increased rapidly, and the rate will get more and more rapid with the dot moving right (at 2nd class rate); press  to move changed data (cursor), and press  or  to change the data value of flashing easily.

2、 Operation of AT :

In the primary state, keep pressing  for 2 seconds, and it shows the parameter of At; press  to make OFF as on, and press  to start the function. When it shows “At” flashing, the meter is performing position adjustment, and after 2 cycles of vibrating, the inner processing unit will automatically make out the parameters of PID and finish the At. When it’s necessary to cancel the function, pressing  for 2 seconds again to make out the parameter of At, and make “on” as “off”, then press  to confirm.

3 、 Please refer to the following setting temperature for Common packing material:

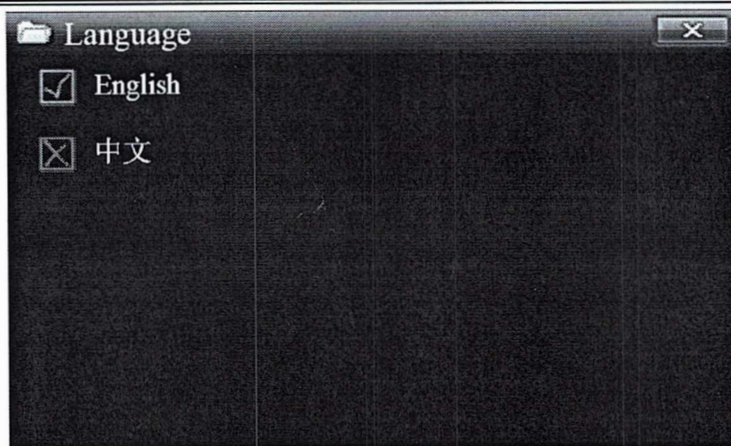
Packing material	Set temperature	Note
Paper/polyethylene, pure aluminum/polyethylene	160 ~ 180℃	This table for the common packing material reference choose, you must sure it according to the packing effect and reliability of seals.
Cellophane/polyethylene	110 ~ 130℃	
Paper/polyethylene	170 ~ 200℃	
Polypropylene/polyethylene	120 ~ 140℃	

Attention: When you set the temperature, horizontally seals temperature generally lower than vertical seals temperature for 10 ℃ ; After the temperature achieved the appropriate setting value, the temperature is whether appropriate according to the seal effect, if heat-seal temperature is low and seals will not reliably, if heat-seal temperature is too high consequently happen the corrugation, the temperature carries on the adjustment correspondingly.

After turning on the heater switch for about 5-10 minutes, the machine can achieve the setting temperature. The machine can run normally only after the temperature reached the setting point exactly.

5.3 Introduction to the HMI

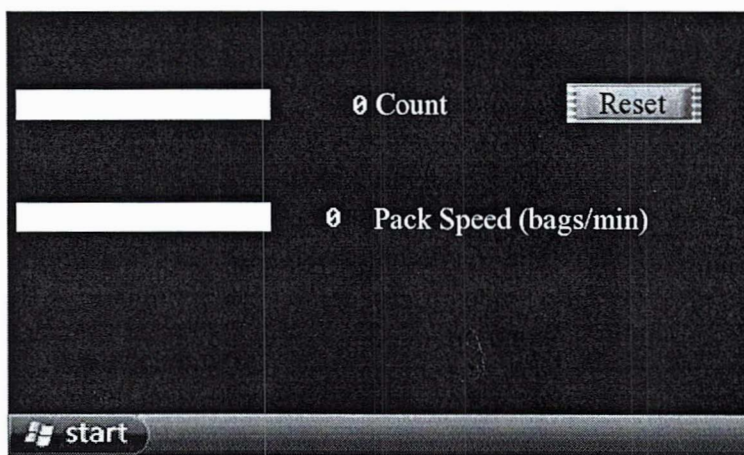
When getting started, it will display the screen

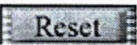


And then go to



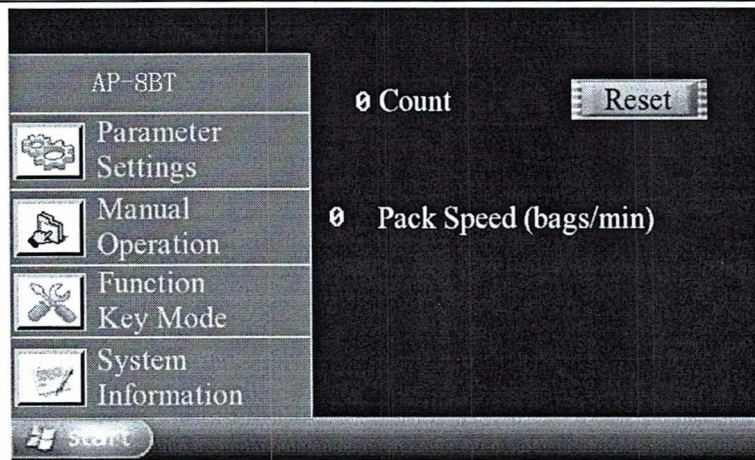
Press   to enter the main operation panel as



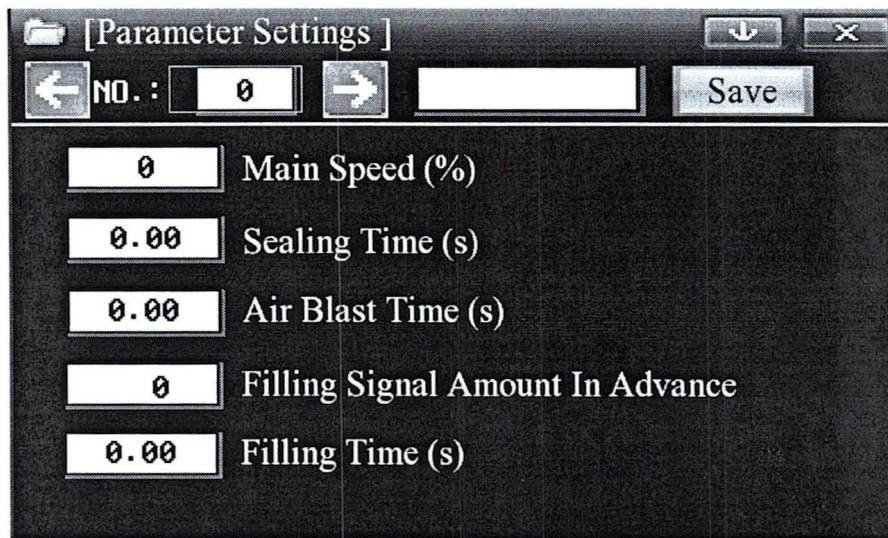
 **Count**: A counter for production; press  to reset it;

 **Packing Speed /min**: Show the present packaging capacity in normal running (unit: Bag/min)

Press  to get to the option list for functions as



Press  to enter the parameter setting interface for making bags.

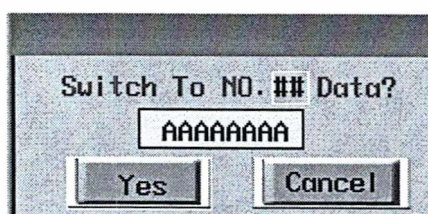


 NO:  : This is the data number of formula, you can press the 

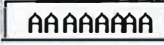
 key or clicking the window options will jump out the keyboard of input number and then switch into the different saved formula data. The range of formula number is 0 ~ 19, that is to say you can set 20 sets of formula numbers.

: This is for present number of formula; it is setting in accordance with the content of formula.

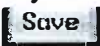
Attention: The formula number changed, it will jump out the following screen:

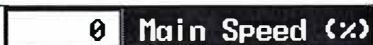
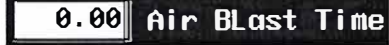
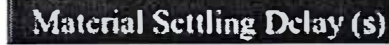


: This is for switching to the next formula number.

: This is for switching to the next formula mark number.

You can press the  key switch into  formula number, press  key will back to the present formula.

: Press this key can save the modified new number under the present number.

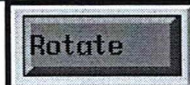
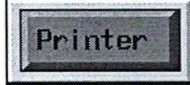
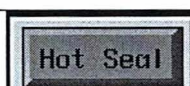
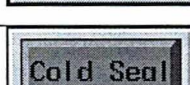
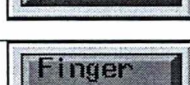
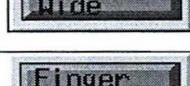
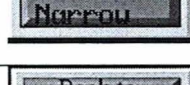
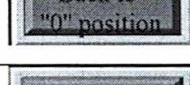
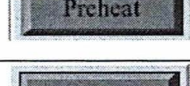
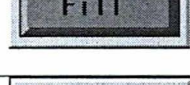
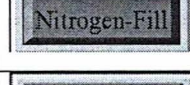
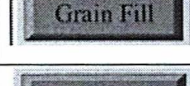
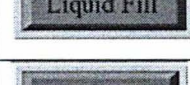
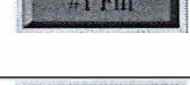
Parameter setting function	parameter declaration	Powder	Granule	Liquid
	Close the window, enter into the main screen	√	√	√
	enter into the second page parameter setting	√	√	√
 0 Main Speed (%)	The packaging speed, the largest set 100, the smallest 5.	√	√	√
 0.00 Sealing Time (s)	Sealing time	√	√	√
 Bag Forwarding Time (s)	The working time of smooth bag motor on the infedding convey belt	√	√	×
 0.0 Supply Material Delay (s)	When the sensor detects the material, after this delay time, begin to refill material.	√	×	×
 Supply Material Speed (%)	the feeding machine speed	√	×	×
 0.00 Preheat Time (s)	the sixth station preheat sealing time	×	√	×
 0.00 Air Blast Time	Bag open and blowing time	×	√	√
 0 Fill Speed (B)	The filling machine filling speed	√	×	×
 0 Fill Volume	The filling volume of filling machine	√	×	×
 0.00 Filling Time (s)	This is the filling signal time.	×	√	√
 0.0 Settling Time (s)	tray vibration time	√	√	×
 0.00 Settling Cycle (s)	tray vibration Cycle time, vibration cycle is small, the amplitude is smaller, the higher vibration frequency.	√	√	×
 Material Settling Delay (s)	The filling tray Start delay time	√	√	×

0.00	Spray Steam Delay (s)	Spray steam start-up delay time	×	✓	×
0.00	Spray Steam Time (s)	Spray steam time	×	✓	×
0.00	Nitrogen-Fill Delay (s)	Nitrogen filling delay time	×	✓	×
0.00	Nitrogen-Fill Time (s)	Nitrogen filling time	×	✓	×
Fling signal Amount In Advance		Issued in advance of blanking signal, the greater the value, the more early feeding	×	✓	×
#1 Fill Blowing Time (s)		#1 pump prevent wire drawing blowing time	×	×	✓
#2 Fill Blowing Time (s)		#2 pump prevent wire drawing blowing time	×	×	✓
Liquid Fill Blowing Time (s)		This is the blowing time of liquid filling. The bigger the machine speed is, the bigger the value is. Be inversely proportional to the viscosity of the product.	×	×	✓
0.00	Bubble Suction Delay (s)	Filling foam adsorption delay time, start filling pump long after the time delay starting bubble suction function	×	×	✓

* Note: the said equipment has the function ✓ x means the device does not have this feature

Press  **Manual Operation** access the manual debugging interface. You can manually key action units in the interface.



Manual screen function	Parameter description	Powder	Granule	Liquid
	Close the window, enter into the main screen	√	√	√
	Manual rotation	√	√	√
	Manual code print	√	√	√
	Manual Sealing	√	√	√
	Manual Cooling Sealing	√	√	√
	Manual finger to be wide	√	√	√
	Manual finger to be narrow	√	√	√
	Manual back to Original point	√	×	×
	Manual preheat	×	√	×
	Manual filling, need to open the filling function	√	×	×
	Manually fill nitrogen			
	Manual granule filling	×	√	×
	Manual liquid filling	×	√	×
	manual #1 pump filling. Need to open the #1 filling function	×	×	√
	manual #2 pump filling. Need to open the #2 filling function	×	×	√
* Note: the said equipment has the function , x means the device does not have this feature				



Press  to expansion function screen:



Expansion screen	funciton	Parameter description	Powder P	Granule G	Liquid L
		Close the window,enter into the main screen	√	√	√
		enter into the second page parameter setting	√	√	√
	Date Print	date print	√	√	√
	Printer Heater	Incoder heating	√	√	√
	Sealing Heater	Heating function	√	√	√
	Product OutFeed	Product Output	√	√	√
	Temperature Alarm	Temperature Alarm	√	√	√
	Sealing	Sealing Function	√	√	√
	Door Alarm	Safety door detection	√	√	√
 	Bottom Open Stand-up Pouches	bag bottom open function	√	√	√
	Settling Device	filling tray function	√	√	√
	Zipper Bag	Zipper bag function	√	×	√
	Preheat	Heating in advance. It is good for sealing.	√	×	√
	Nitrogen-Fill	Filling nitrogen	√	×	×

☒ Spray Steam	Steam jetting function	×	√	×
☒ Stagger Dump ☒ Filling confirm	Turn on/off falling material in sequence ; when bag comes to filling station, it send out filling signal, and the machine will stop and wait. Until it receives the filling ready signal, begin to fill.	√	√	×
☒ Exhaust	Air Exhaust function	×	√	×
☒ Intermittent Mixer	Intermittent mixer function	√	×	√
☒ Fill	Filling	×	√	×
☒ Liquid Fill	Liquid Filling	×	√	×
☒ Grain Fill	Granule filling	Attention: ☒ Grain Fill and ☒ Liquid Fill To turn off the electricity after the automatic recovery is closed state		
☒ Collect Hopper	Turn on the collection hopper function	×	√	√
☒ #1Fill	#1 Pump filling	Attention : ☒ #1Fill and ☒ #2Fill To turn off the electricity after the automatic recovery is closed state		
☒ #2Fill	#2 Pump filling			
☒ Grain	granule	Note : ☒ Grain and ☒ Powder , when turn off the power and turn on the		
☒ Powder	powder			

		power, the machine will choose one of these two automatically. They can not be chosen at the same time.			
☒ Cut Off Blowing	Prevent line drawing function pump filling finished. Then automatically blowing action one time to prevent the phenomenon of drawing	×	×	√	
☒ Fill Vacuum	Filling suction function: pump filling process automatically do suction action to suck the bubbles during produce.	×	×	√	
☒ Cleaning	Cleaning function: this function can only open in the non starting state. Injected into the cleaning liquid filling pump storage cylinder. Started washing, filling pump work continuously until the closure of this function	×	×	√	
☒ CIP Reverse Cleaning	Reverse cleaning function: this function can only be opened in the non starting state. the function it's action contrast with ☒ Cleaning Pumped into the cleaning liquid from the filling nozzle, the cleaning liquid pump out from the feed inlet, circulation continuous work until the turn off this feature, so open this function should be immersed in the cleaning liquid filling mouth, then open this function.	×	×	√	

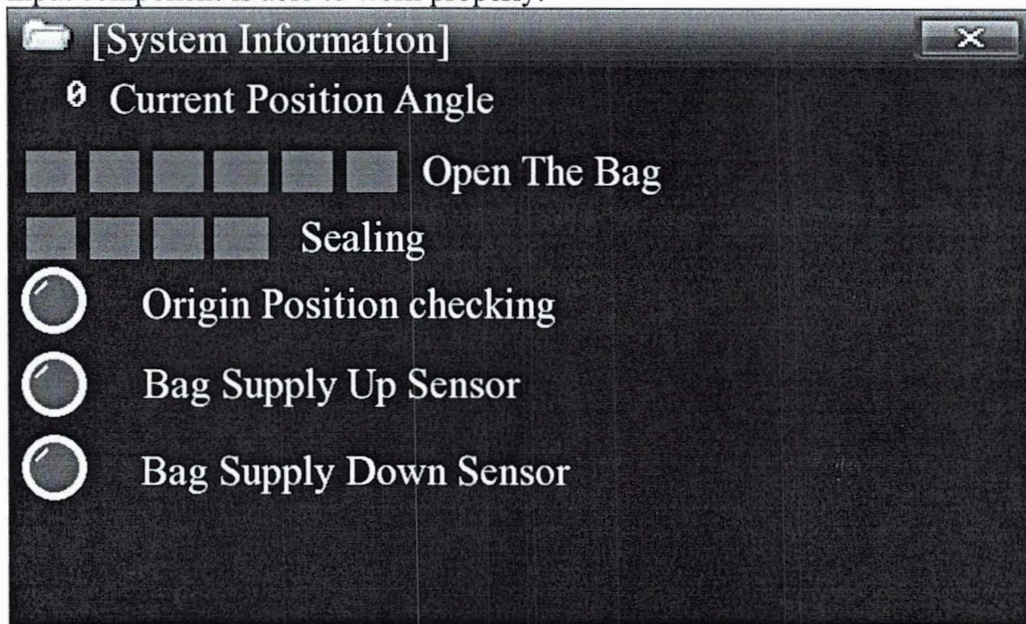
* Note: the said equipment has the function , x means the device does not have this feature

Operation push on the right box , means Opens this function, small box will tick .

Operation push on the right box , means turn off this function, small box will tick .

Press  to close the widow.

Press  to enter System Information screen. In this screen, you can check whether each input component is able to work properly.

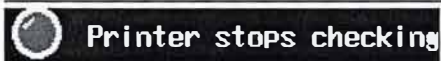


0 Current Position Angle: This shows the current station location.

 **Origin Position checking**: This is for checking the sensor of station home position. When an object passes the sensor probe, this  should reflect, or the sensor maybe broken and need to be replaced.

 **Bag Supply Up Sensor**: This is for checking the bag feeding sensor. When the bag feeding device on the top position, this  should reflect, or the sensor maybe broken and need to be replaced.

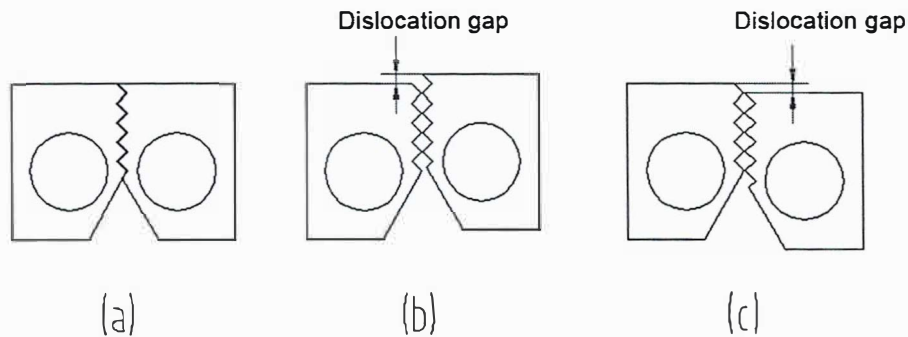
 **Bag Supply Down Sensor**: This is for checking the full bag sensor. When the bag feeding device on the down position, this  should reflect, or the sensor maybe broken and need to be replaced.

**Printer stops checking:**

This is for printer stops checking, when the product passes by, the  should reflect, or the sensor maybe broken and need to be replaced.

CHAPTER 6 ADJUSTMENTS

6.1 Readjustment for seal fittings



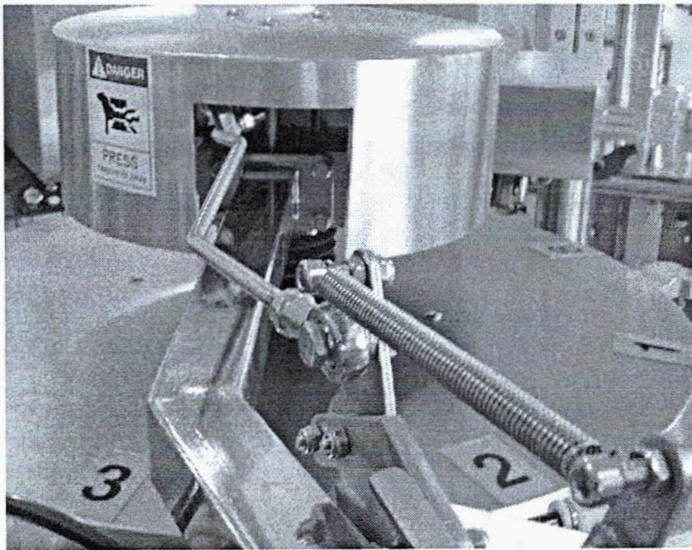
- (1) Make sure that the seal fittings are set as shown in Figure (a).
- (2) Adjust the seal fittings as follows if they are positioned as shown in Figure (b) or (c):
 1. Turn the o shape belt by hand and cling the left and right sealer, and loose the L-seal fixed bolt
 2. Loosen the fixed bolt, and turn the o shape belt to open the press arm slightly. When the tension arm is opened, the L-seal can be moved
 3. Put the left and right sealer together tight. When both sides are engaged properly, close the tension arm slowly and lock the fixed bolt.

6.2 Adjustment on the photocell:

1. Readjustment on the detection position of the photocell is to ensure that the distance from the photocell detection point to the horizontal seal center of the hot sealer is a whole number times of the proportion strip length. That is, the photocell aligns with the registration mark, where and when the hot sealer just makes a horizontal seal precisely.
2. Lens of the photocell is in a distance of about 3mm to the packing film. When the film is being fed the photo spot must detect a registration mark. After the photocell has detected a registration mark, the photocell's function indicator should show a change such that if the checked mark is in light color, the indicator will not turn on. The indicator only turns on when a dark color is checked up. Otherwise, the sensitivity knob has to be readjusted. If the base color is in a little difference with the registration mark, the sensitivity of the photocell should be readjusted once more in order to avoid erroneous action.

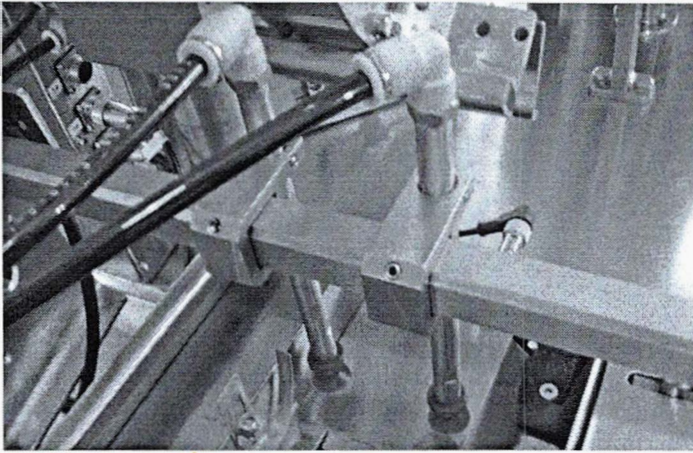
3. Adjustment on the sensitivity: When the packing material has been put in the right place, slide the film through the film guide plate at the photocell, make the packing material align with the registration mark area, switch the MODE key on the fiber amplifier to SET status, and press ON key, when put the fiber head on the non- registration mark area, then press the OFF key, at last, press the MODE key to return to the original status. At this time, slid the packing material, when light source casts on the non-color-mark area, the red indicator won't be on; When the light source casts on the non-color-mark area, the red indicator will on, if not, please readjust!

6.3 Pocket open adjustment



1. Make sure the slit pocket machine as shown in figure (a) correct assembly
2. If the pocket open machine assembly as shown, a displacement, please make the following adjustment
 - 1) Open the manual operation, make robots take the bag to the pocket open position.
 - 2) Loosen the hand bag opening and spindle fastening screws
 - 3) Loosen the fastening screw, and then turn the bag opening machine, makes the bag opener and mechanical alignment
 - 4) Locked tightly screw fixation

6.4 Bag Suction adjustment

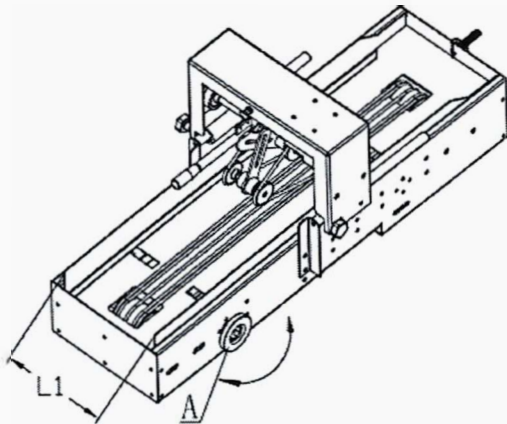


- 1) ensure the bag suction machine correct assembly as picture shown
- 2) If displacement of suction bag assembly: a. loosen the fixed link on left and right side suction bag of screws B. Adjust the position of the suction bag is made of suction bag location in bag 1/3 of the width of about two-thirds

6.5 Bag width adjustment

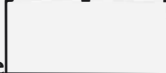
 Bag entering conveyor width adjustment

Turn the handwheel A, can adjust the conveyor width L1, make it suitable for the bag width

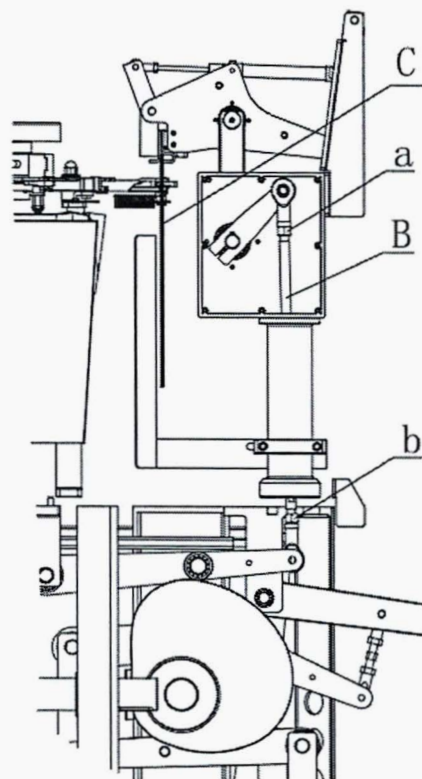
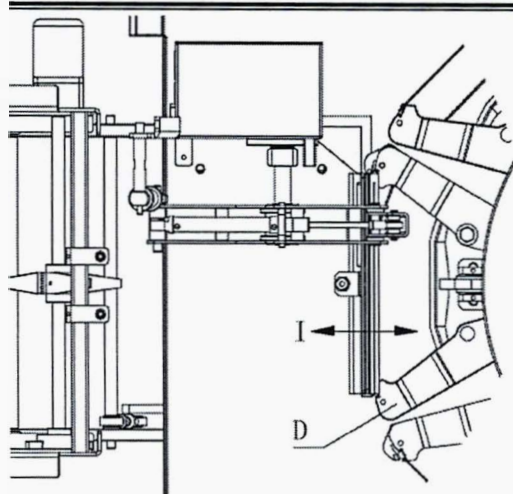


- 2) Bag supply before and after the position adjustment

When narrow from bag to bag wide moment, need to adjust the width of gripper D (can

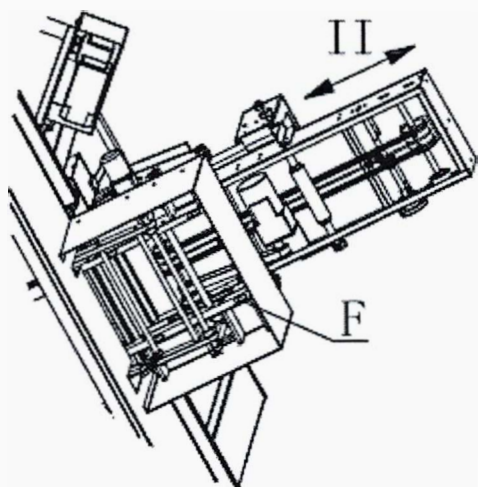
through manual debugging to adjust the interface  and .

Thus bag position has changed, at this point, loosen the nut at the ends of the connecting rod B a, B, B turn connecting rod, and can adjust the position of the bag bag C changes, at the direction of the I can make the gripper smoothly catch bag.



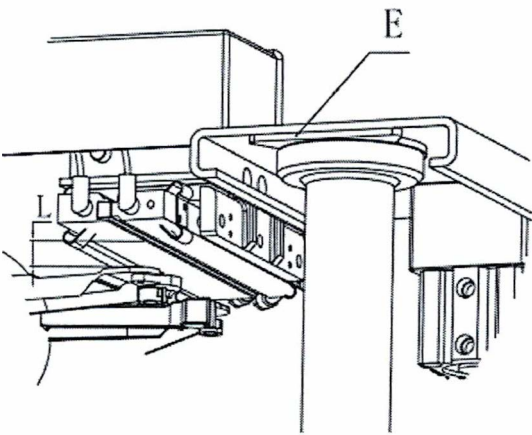
6.6 Mouth from gripper height adjustment

Loose the 4 screws located in F, move in the direction shown by the II into the bag of conveyor, can change the mouth to the height of the gripper

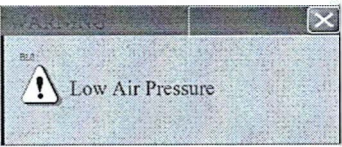
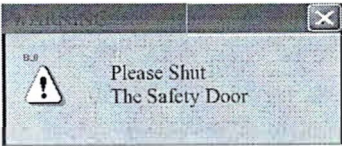
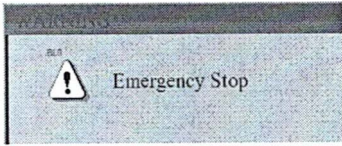
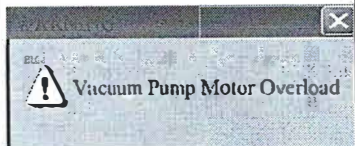


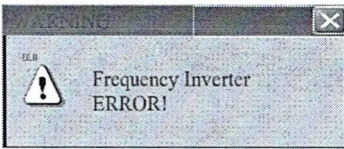
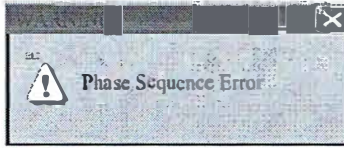
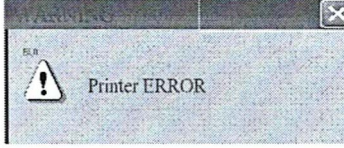
6.7 Sealing position adjustment

Add and subtract gasket E, can adjust the height of the sealing knife L, which changes the bag on the sealing position



CHAPTER 7 ERRORS AND ELIMINATION

Alarm Information	Reason	Elimination
	detection switch abnormal Line abnormal	1 check the X14 pressure switch if damaged. 2 check the vacuum pump is working properly, the line if damaged.
	The safety door is not closed Circuit damage	1 check an XA gate detection switch is damaged. 2 check the safety detection switch corresponding line is damaged.
	Emergency stop switch is opened or damaged	Check the emergency stop if open. Check the emergency stop circuit if damaged
	1 vacuum pump damage 2 line damaged	1 Check the vacuum pump is damaged, if damaged replacement of the same specifications motor. The thermal relay X18 whether the damage. 2 To reference circuit diagram, check the vacuum pump line if there is leakage, short circuit phenomenon.

	1 converter damage 2 line is damaged	The main motor 1 check for damage, replace if damaged the same motor specification. The main motor inverter X9 whether the damage. 2 reference circuit diagram, check the main motor line whether there is leakage, short circuit phenomenon.
	Cam switch power supply circuit phase sequence error.	Replace the cam switch power line.
	1. Color bar detecting sensor is damaged 2. Circuit damaged	Check if the XC the color bar detecting sensor is damaged.
Power can't connect on	Power plug haven't turn on	Connect the plug to the socket
press the stop button, can't stop the machine operation	1. the machine program wrong 2. Emergency stop button damaged	1. turn off the power, start the machine again 2. Check the control line if normal
Press the stop button, can not stop the machine's operation	1. The machine program error 2. Button damaged 3. suction bag position	1 regulation bag suction pressure again 2 replace or repair the same type sucking nozzles 3 adjust the suction bag position, suction nozzle in the bag
Because the color code detecting abnormal or failure, stop the machine operation	1. it's right to detect the color code 2. The packing bag length it's right	1. adjust the photoelectric switch again 2. Make sure the bag length setting right
Sealing can't opened	1 temperature set too low 2 heat sealing device calibration abnormality	1 according to the standards set the new temperature 2 adjust heat sealing device's flat and pressure

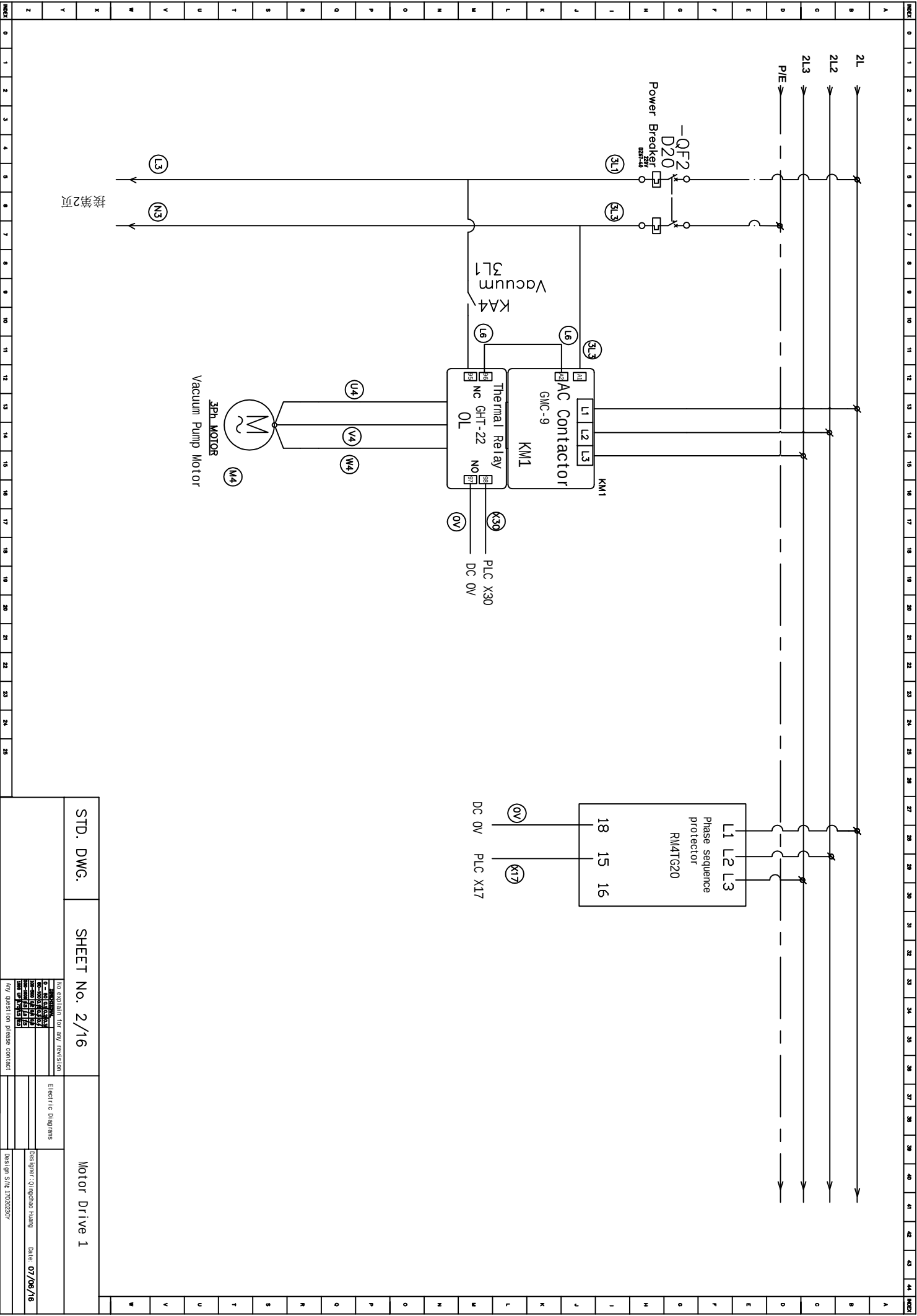
The power put on, the machine can't start	1. Power plug connect firm 2. The machine safety door opened 3. emergency stop switch opened?	1. the plug and the socket are firmly connected 2. machine Safety door to firmly closed, because if not firmly closed, will start the safety device 3. unlock the emergency stop switch
Bag open abnormal	Open the bag position Cylinder abnormal	1. adjust the bag opening position, aligning 2. A. Check cylinder pressure B. check cylinder if damaged
Filling abnormal	Filling pump Valve	1. A. Check whether the filling pump start B. check the air pressure if normal 2. A. check the filling nozzle valve if blocked B. check cylinder if working correctly
The temperature indicator abnormal	1. heater, heating tube break off 2. thermocouple circuit break off 3. temperature controller already damaged 4. blown fuse 5. relay damaged	1. Replace the heater 2. Replace the thermocouple 3. Replace the temperature controller 4. Replace the fuse 5. Replace the relay
Station does not rotate	1. motor abnormal 2. line is abnormal 3. Mechanical abnormal 4. converter abnormal	1. Replace the Power motor 2. check and repair line 3. cleaning and maintenance or replacement of defective parts 4. check and repair or replacement of the same model of inverter alarm

electrical parts list

Name: RBF8

Production No.:SZ1503003

No	Name	Spec.	Brand	Qty	Remark
1	PLC	AFPX-C60R	Panasonic	1	
2	PLC extension	AFPX-E14YR	Panasonic	1	
3	touch screen	MT4414TE	Eveiw	1	
4	temperature controller	AI-218	YUDIAN	1	
5	inveter	ATV312HU22M2	Schneider	1	
6	inveter	VFD001L21A	Delta	2	
7	pressure gage	ZSE40A-01-R	SMC	2	
8	intermediate relay	SJ1S-07L+RJ1S-CL-D24	IDEC	7	
9	proximity switch	PRCM12-4DN	Autonics	4	
10	connect line of proximity switch	CID3-2P	Autonics	4	
11	proximity switch	GL-18H	SUX	1	
12	Safety Gate Switch	TZ-93B	tend	7	
13	switching power supply	NES-150-24	mean well	1	
14	start button	LA39-A1-1D/G23	APT	3	
15	E-stop button	YW1B-V4E01R	IDEC	3	
16	thermocouple	Ktype(0-400°C)		2	
17	encoder	E50S8-360-3-2-24-2C	OMRON	1	
18	main power switch	LW42B32	APT	2	
19	solid relay	SAP-4825D	Gute	2	
20	2P breaker	DZ47-60 2P C10+leakage protect	CHINT	1	
21	3P breaker	DZ47-60 3P D32	CHINT	2	
22	2P breaker	DZ47-60 2P D10	CHINT	1	
23	2P breaker	DZ47-60 2P D20	CHINT	2	
24	tricolour light	TL-703ALLC/23+TL-CZ-4+TL-G-50	APT	1	red green yellow
25	Phase sequence protector	XJ3-S	CHINT	1	
26	A.C contactor	GMC-9	LS	1	
27	thermalrelay	GTH-22	LS	1	



STD. DWG.

SHEET No. 2/16

Motor Drive 1

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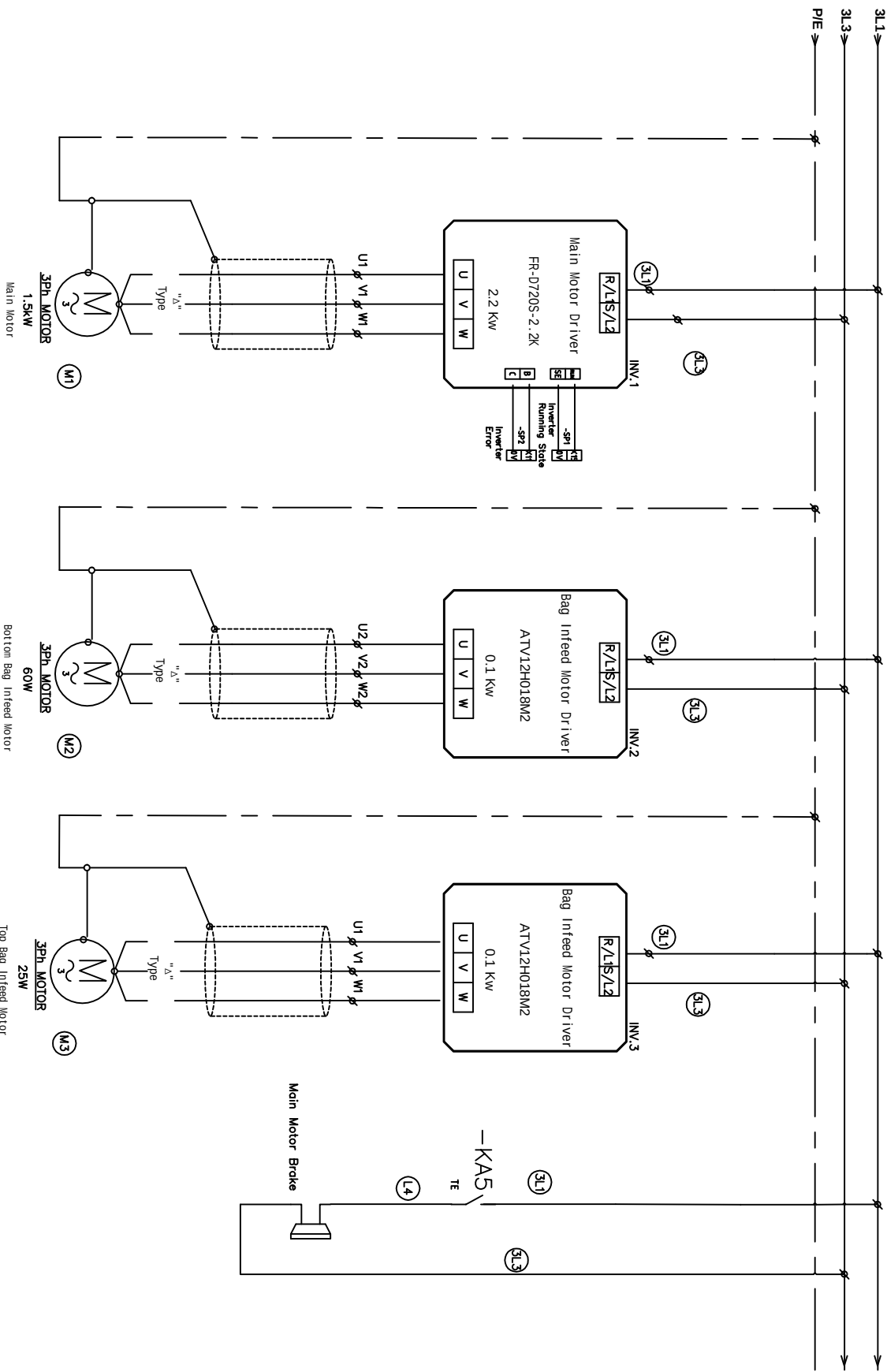
Electric Diagrams

Designer: Qingshan Huang Date: 07/06/16

Any question please contact

Design S/N: 17020207

From Page 1

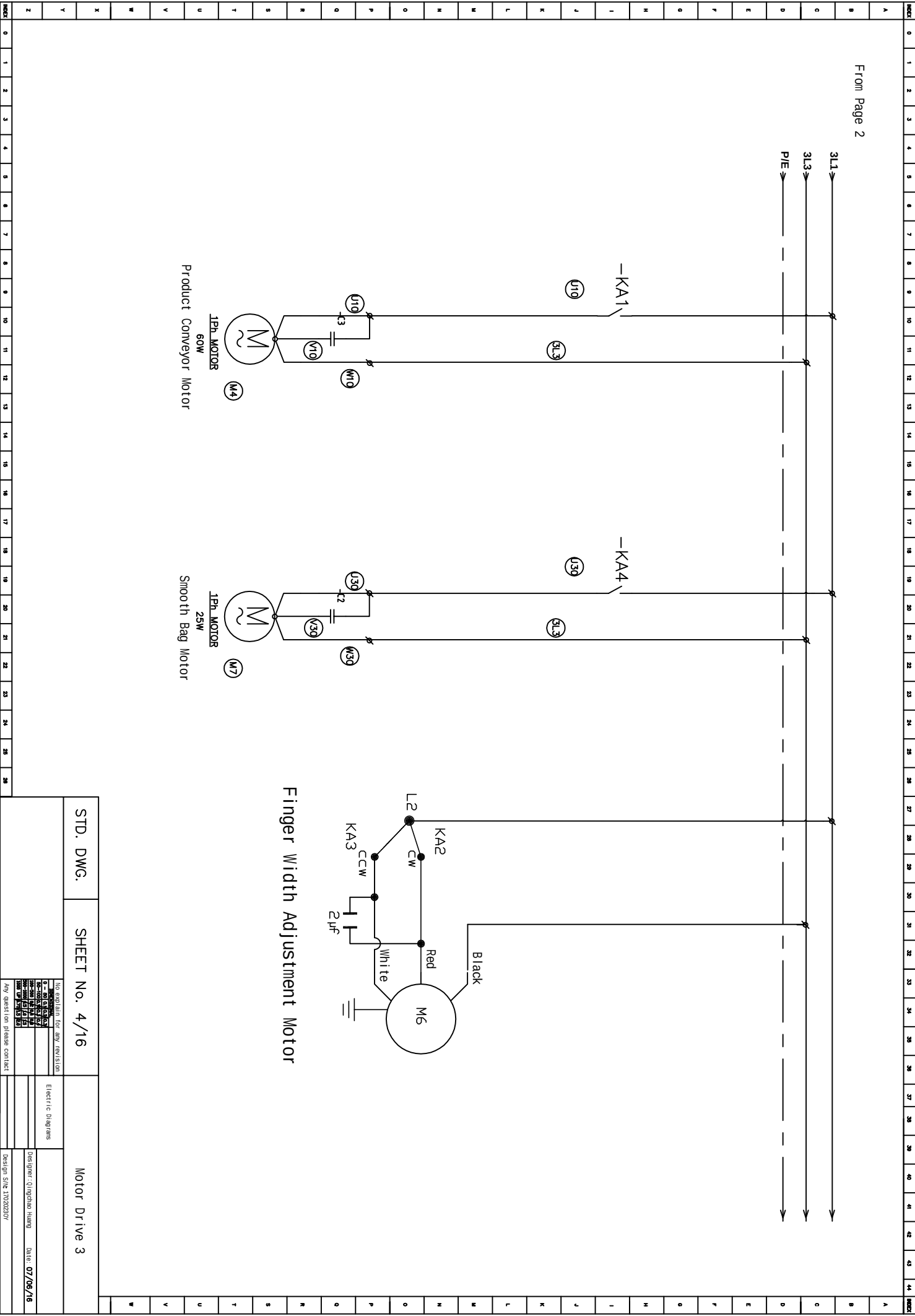


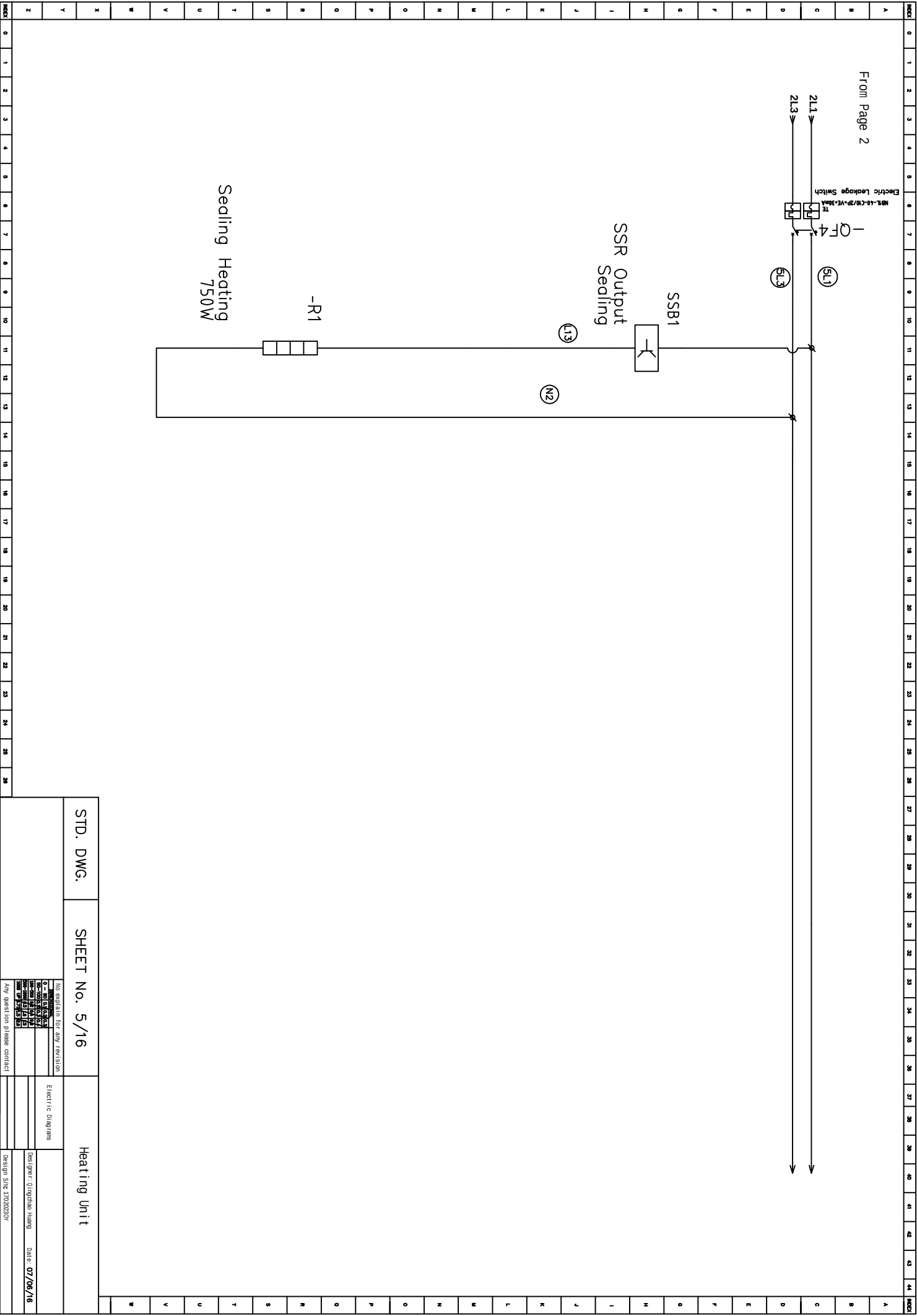
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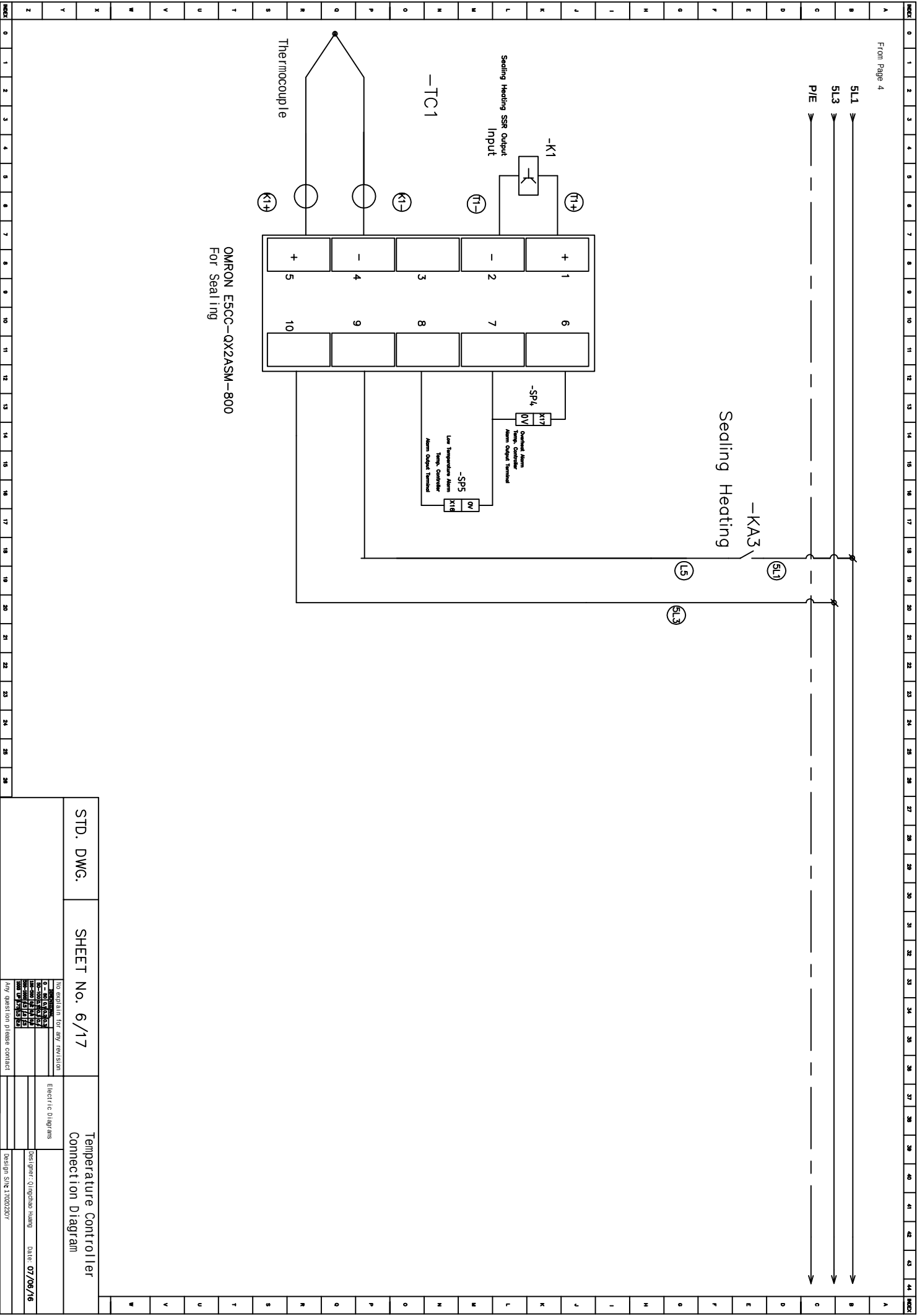
SHEET No. 3/16

Motor Drive 2

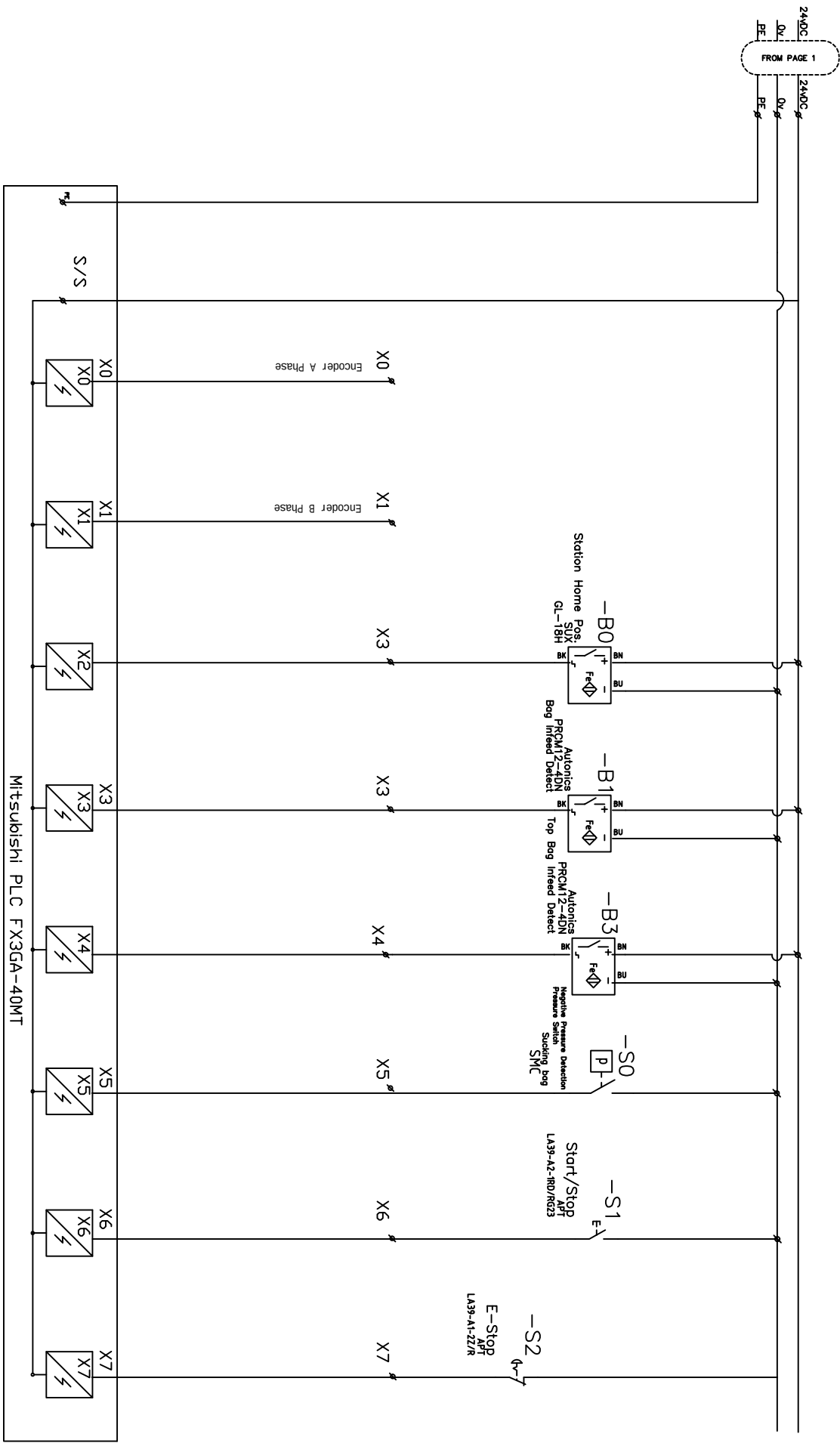
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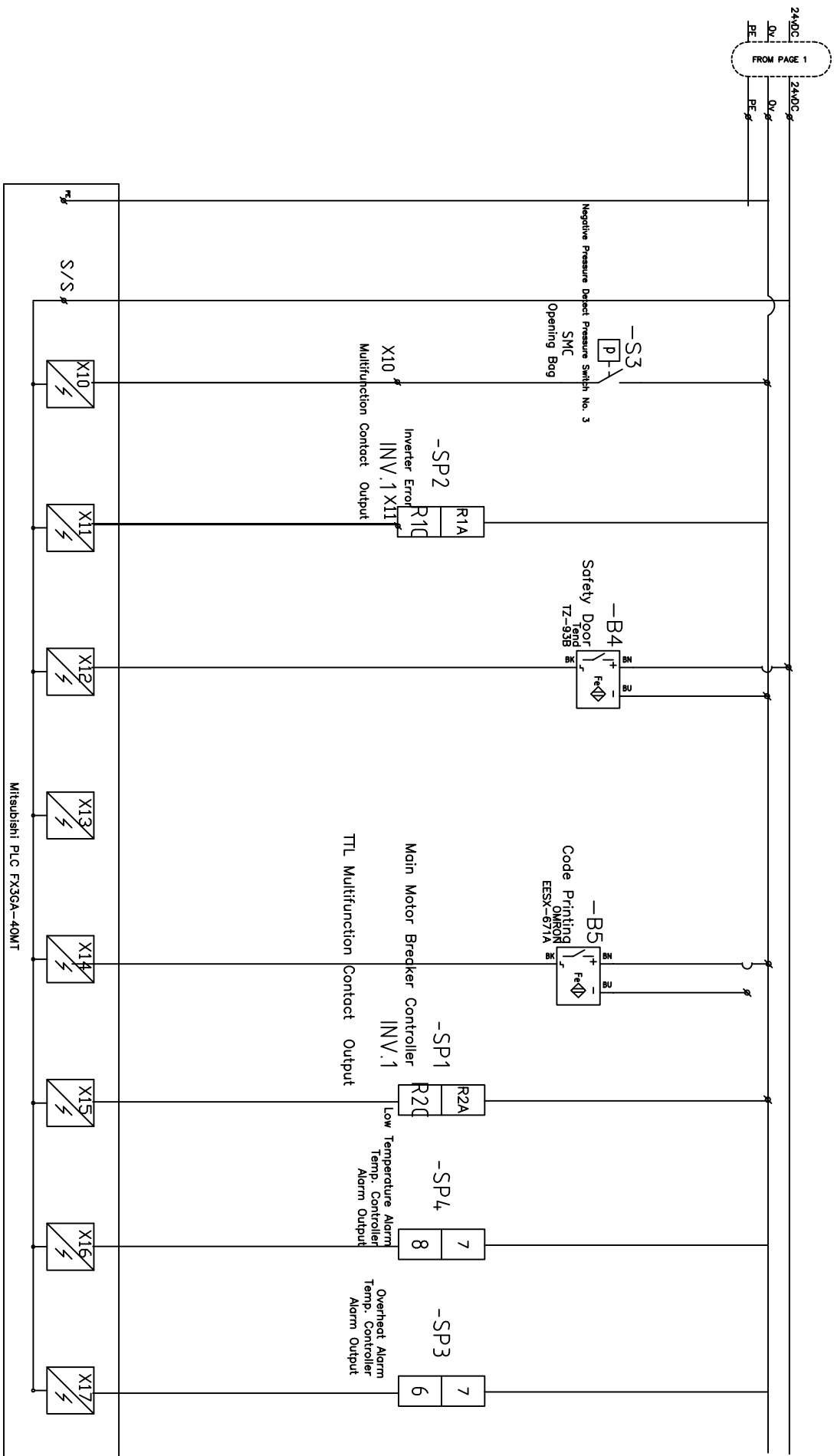
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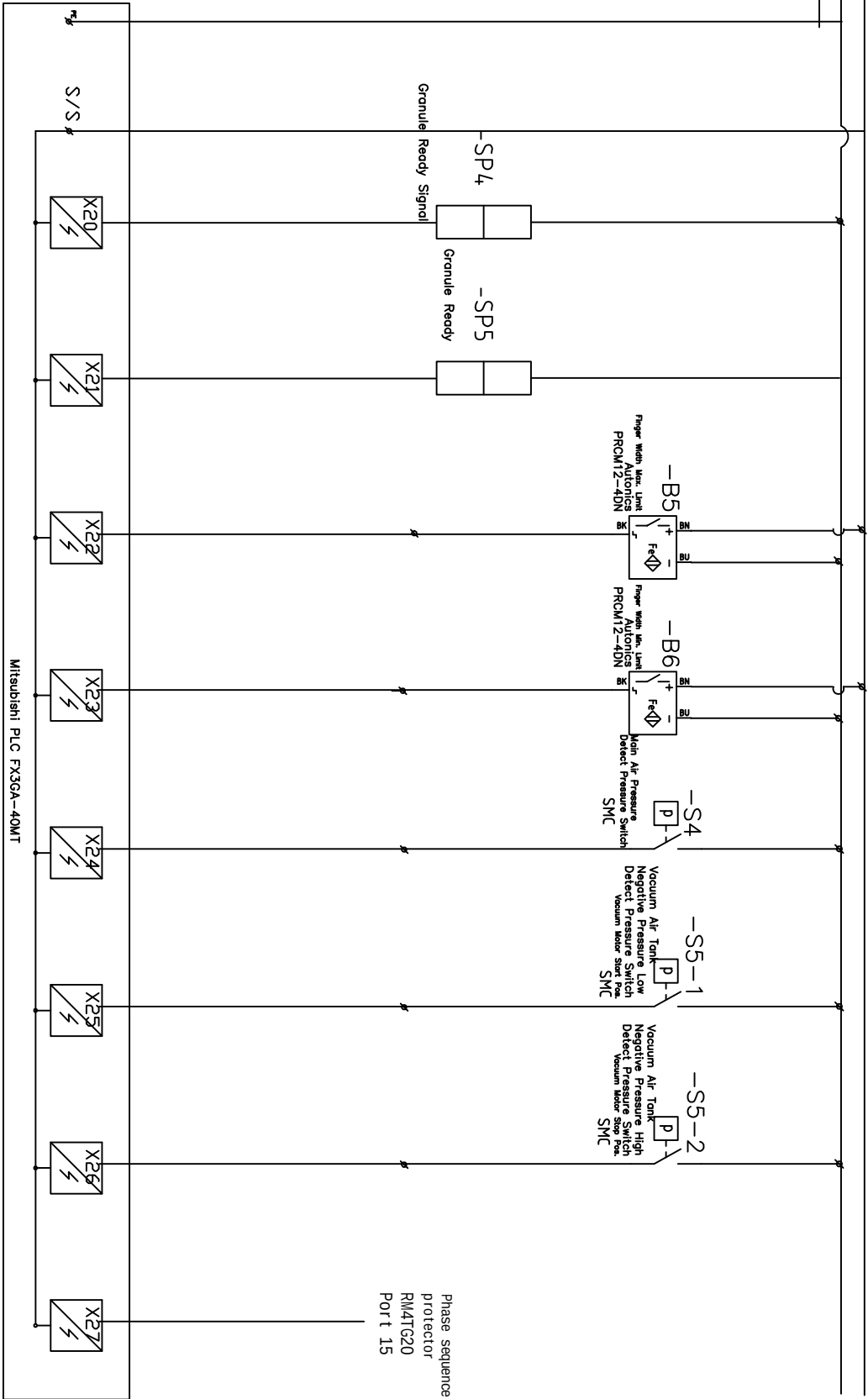
SHEET No. 8/17

FX3GA-60MT Input

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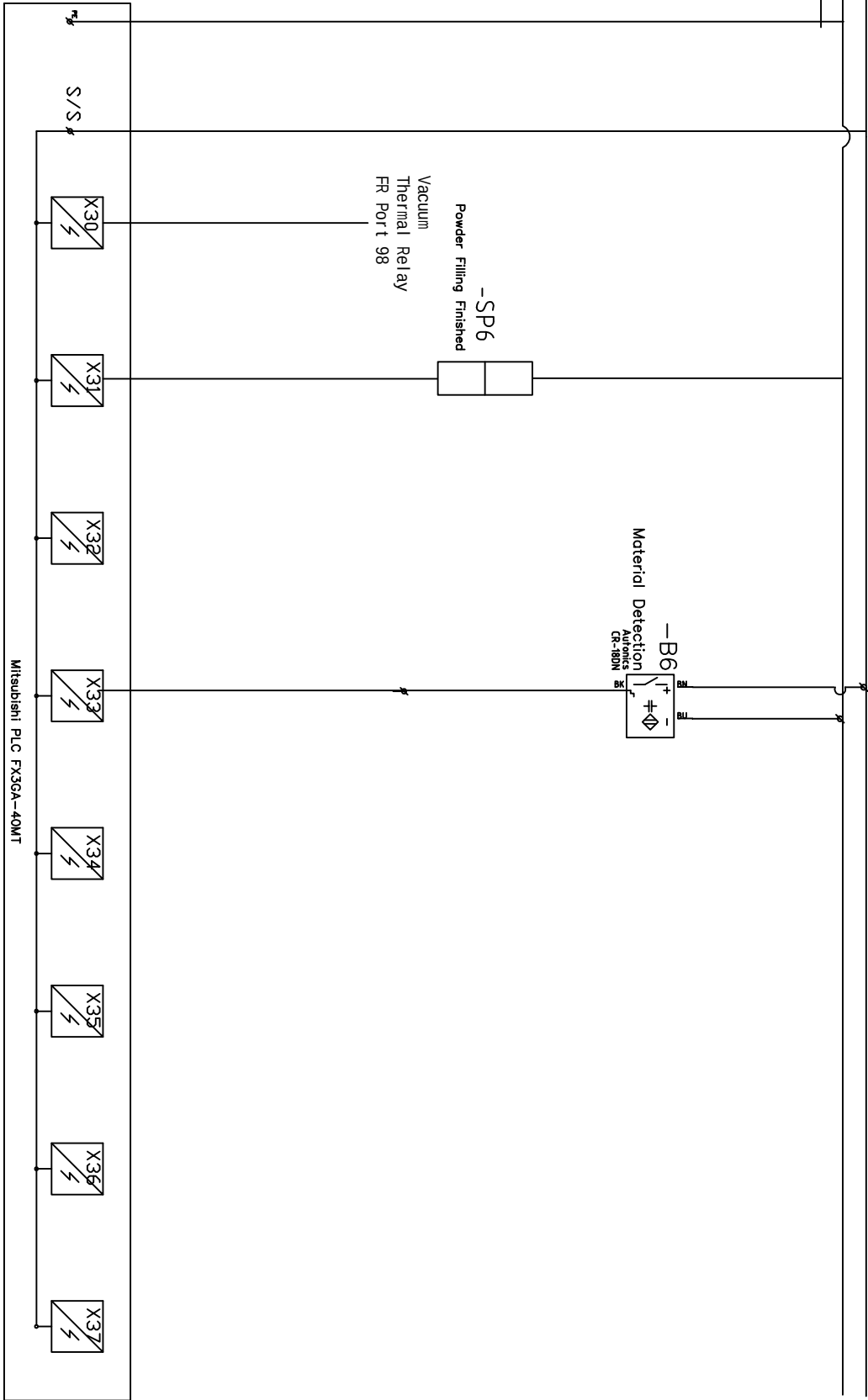
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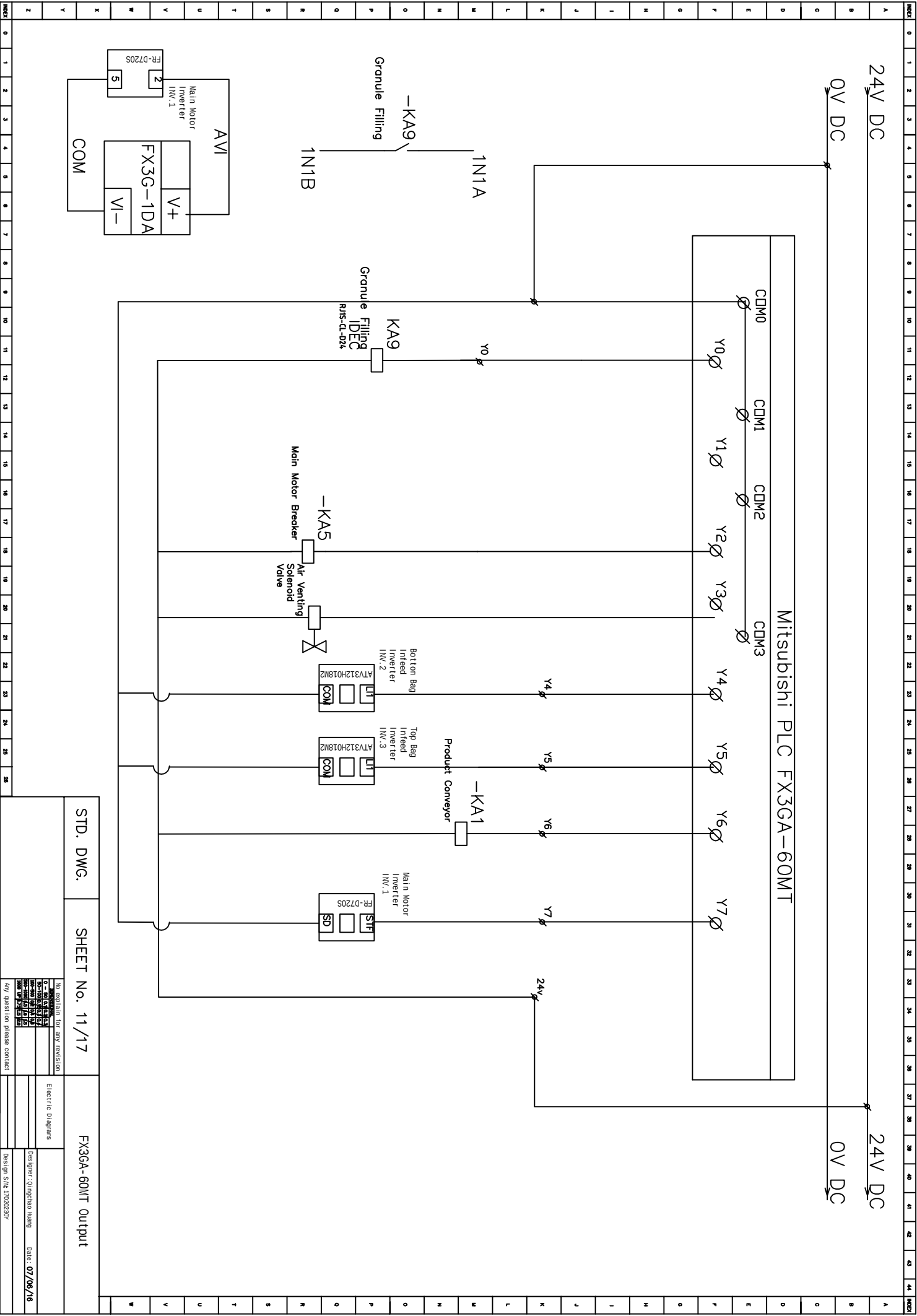
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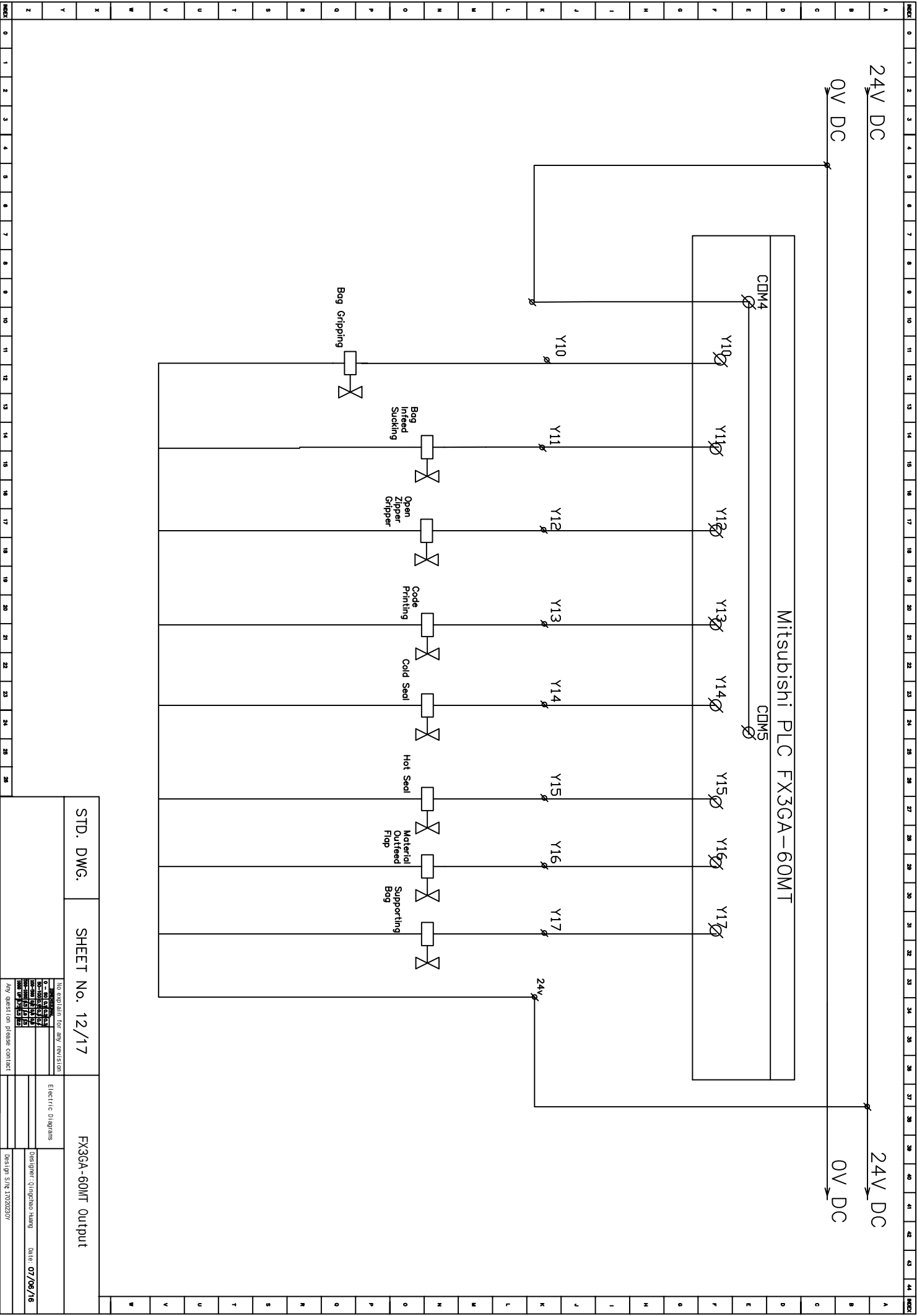
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Designer : Qingshan Huang	Date : 07/08/16
Design Size : 1700x2500	



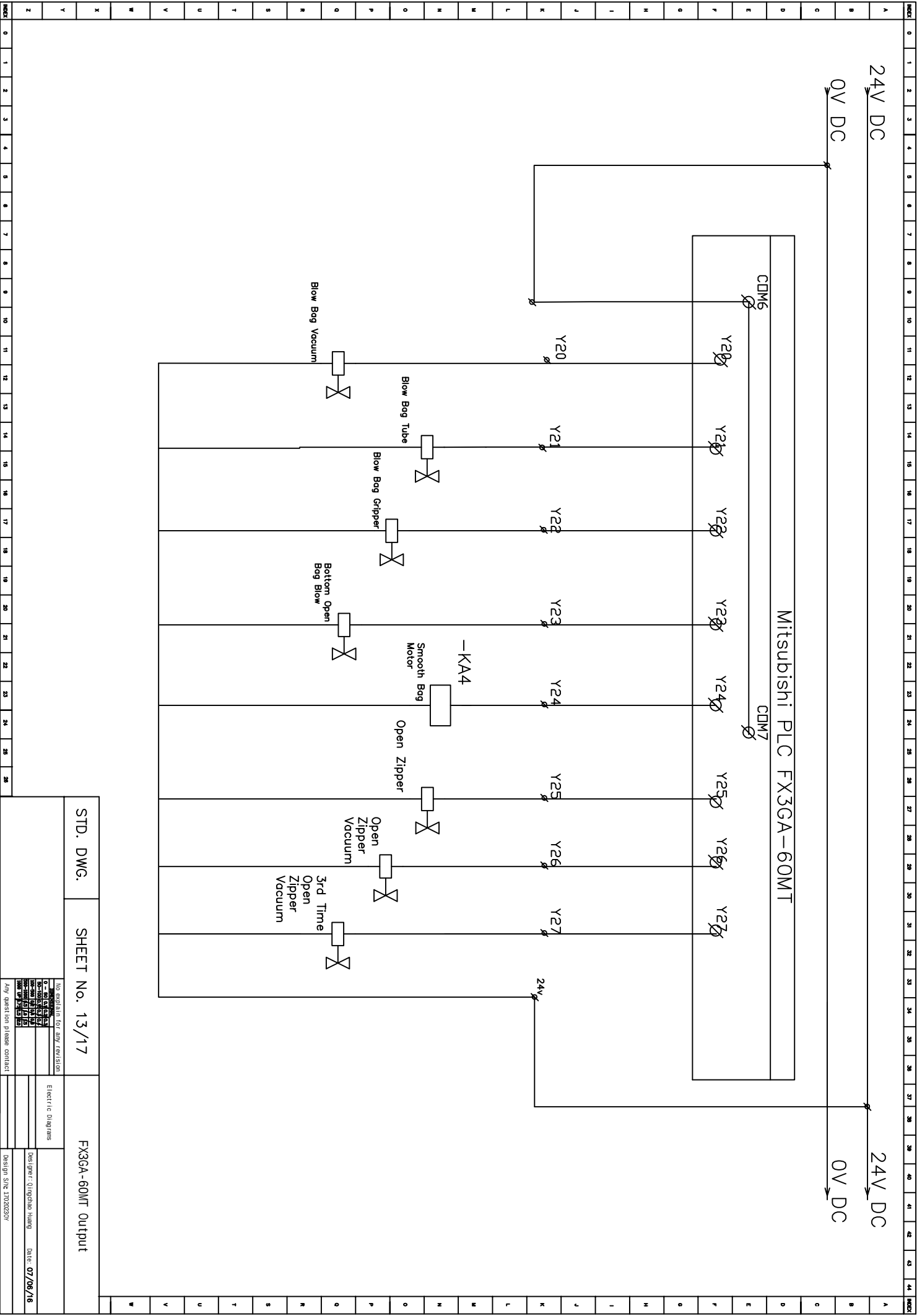


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SHEET No. 12/17

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SHEET No. 13/17

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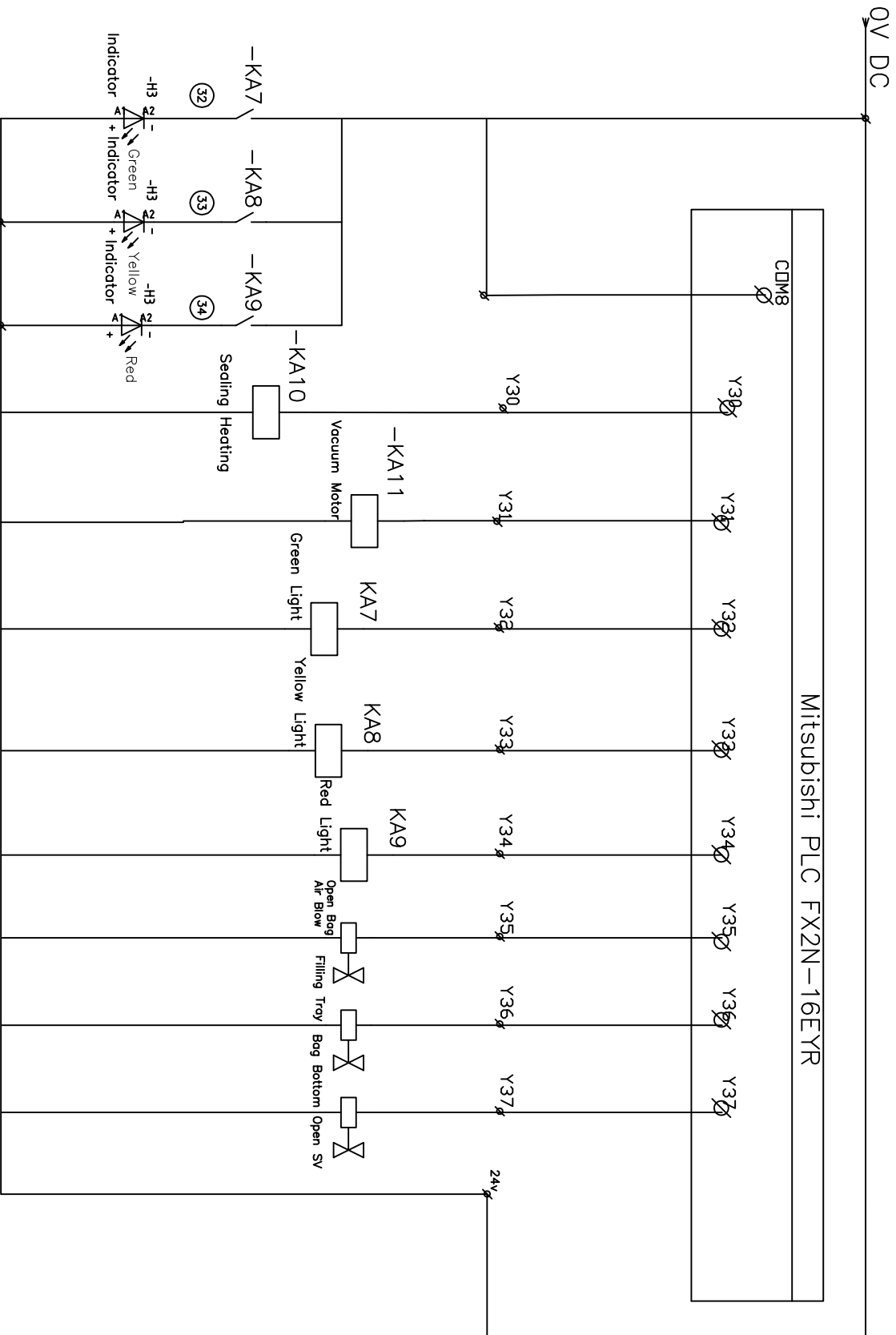
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Design: (Q) Jingchao Huang

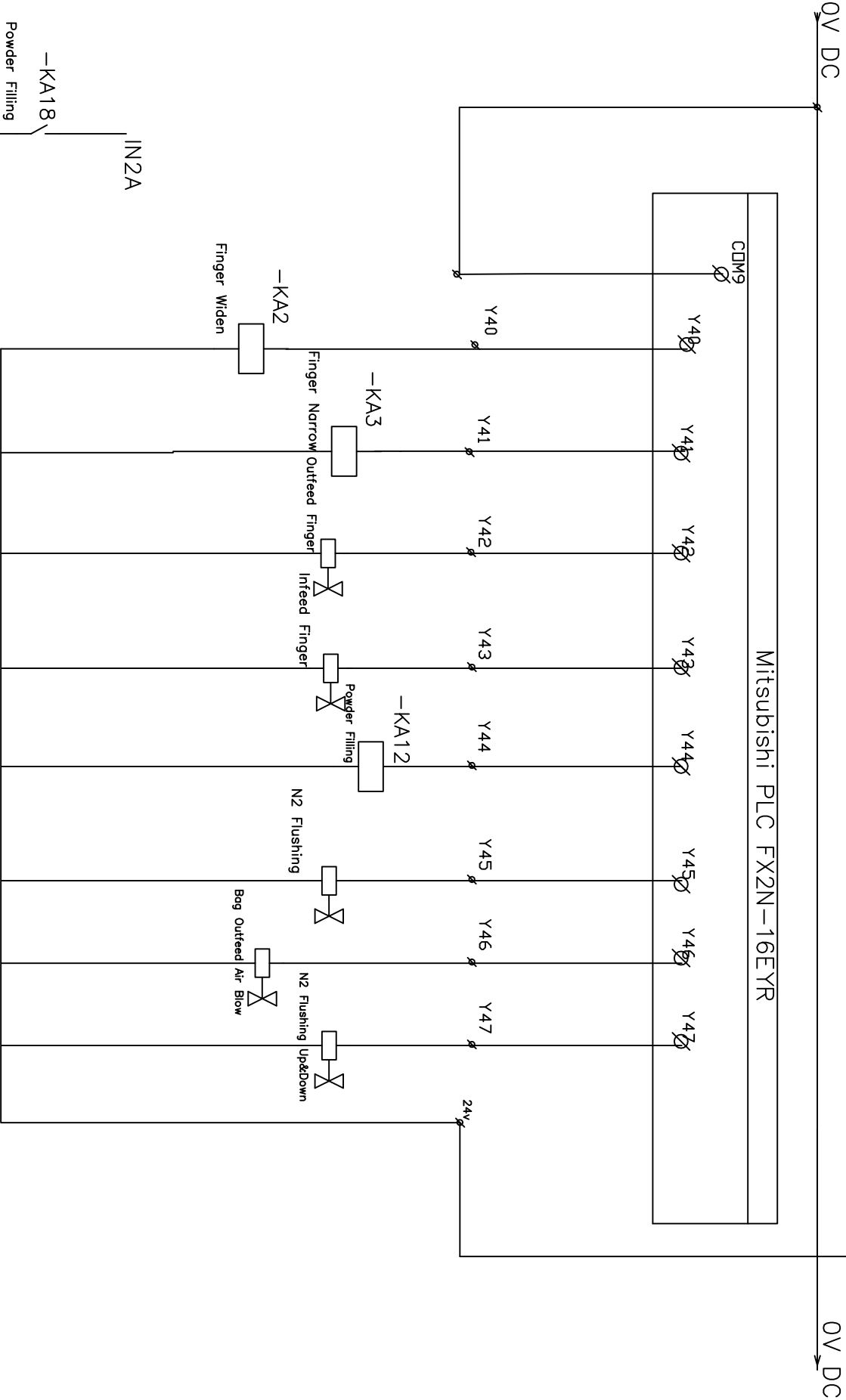
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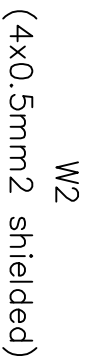
Any question please contact

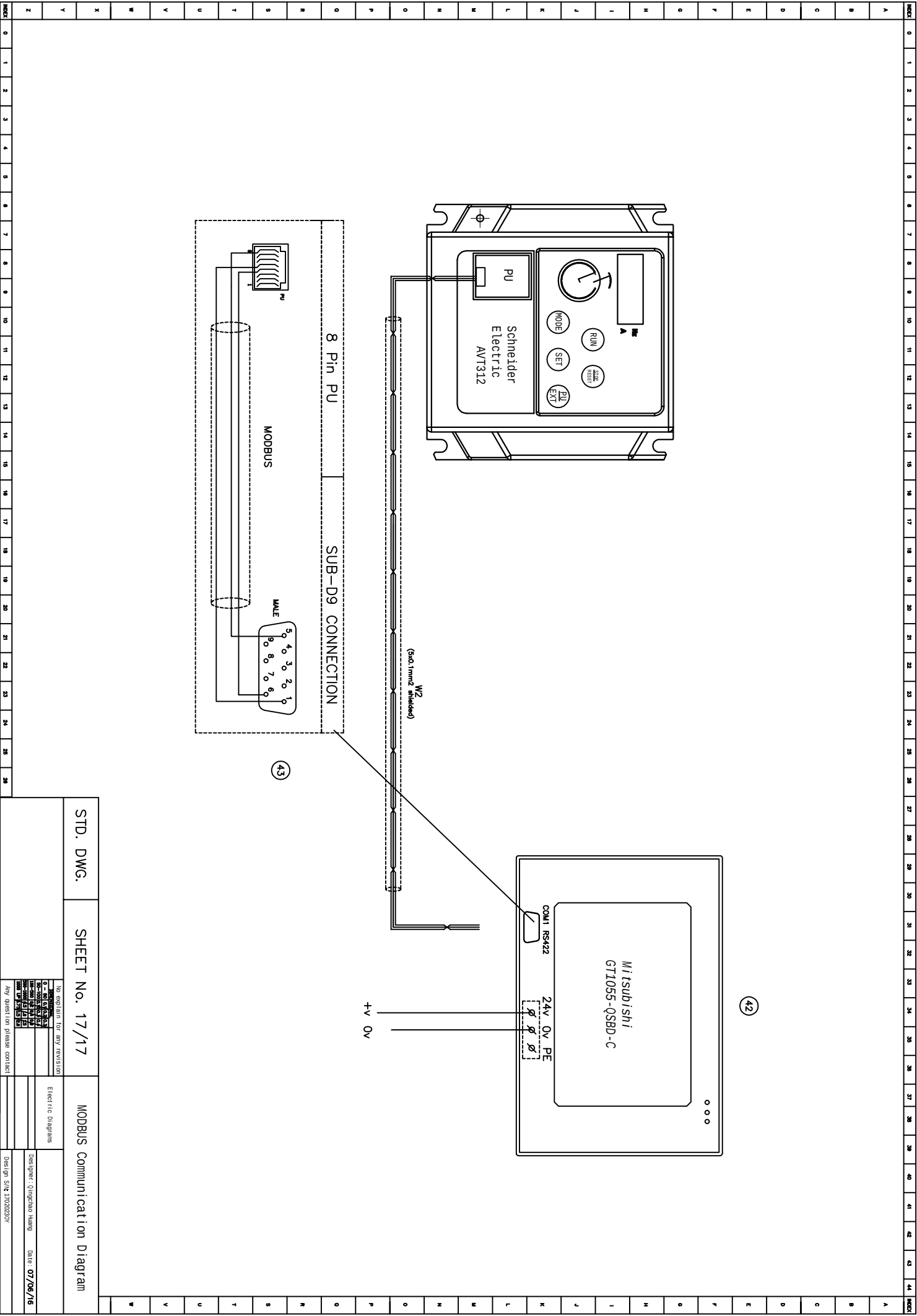
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XTRAVAC RBF8

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Parts Manual

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Sales@XtraVac.com

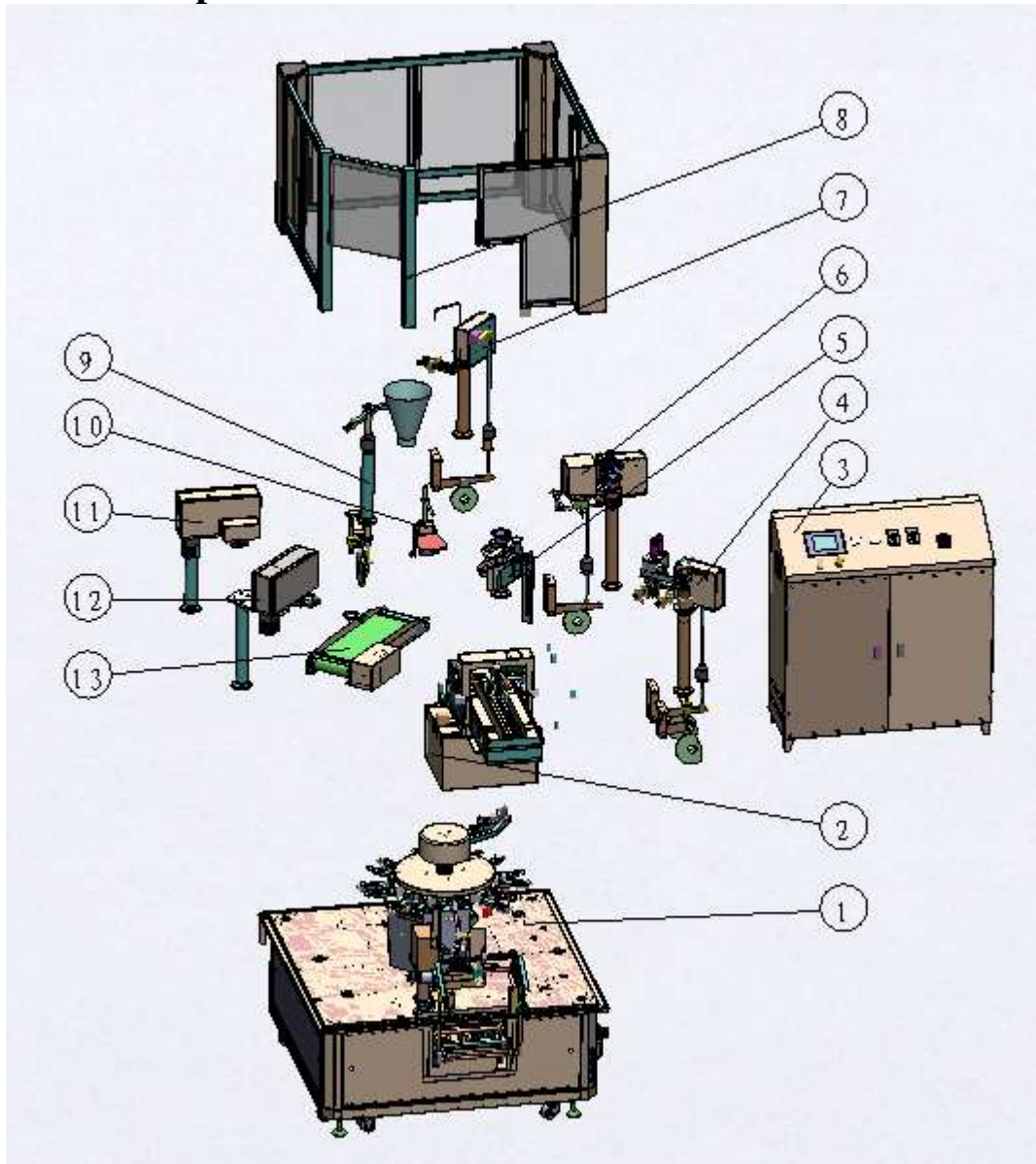
XtraVac Packaging Machines

RBF8 - Rotary Bag Filling & Sealing Machine

419 E. 11th Ave. North Kansas City, MO 64116 USA

+1 800-728-2999 • Sales@XtraVac.com

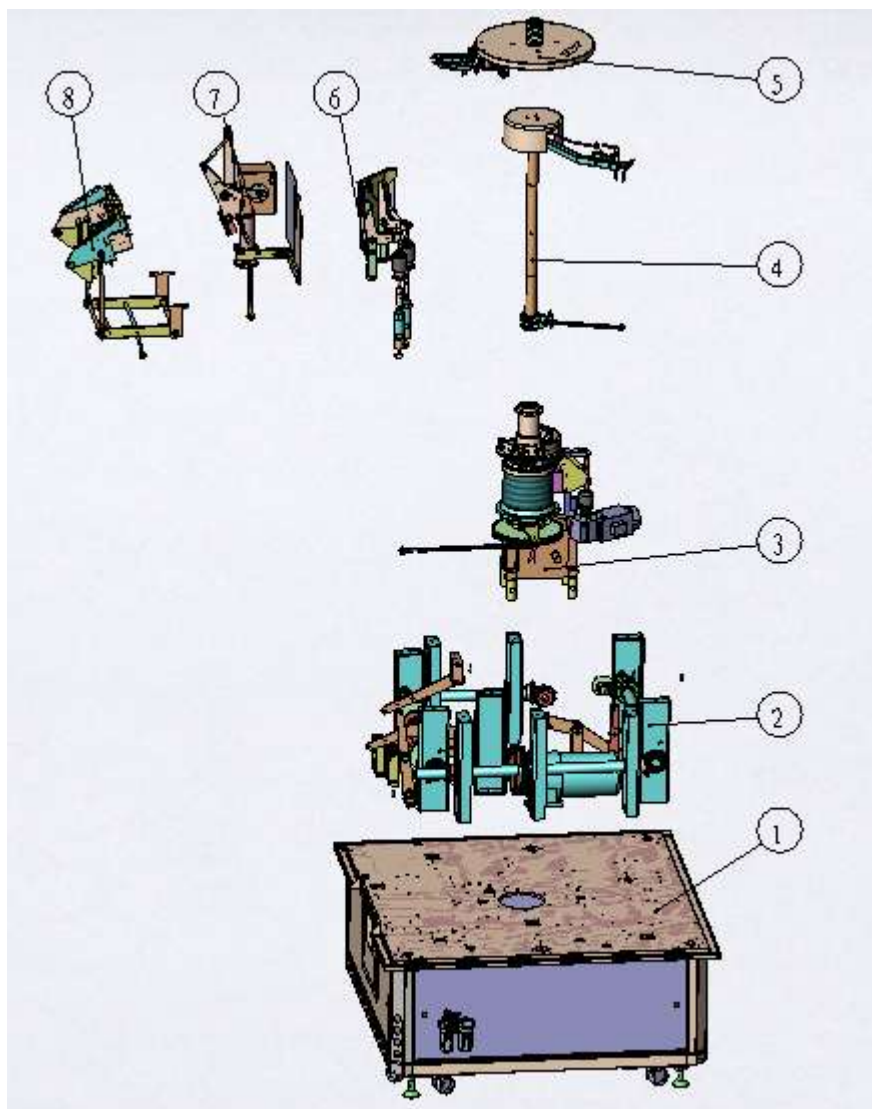
I. Machine parts



1. Main driving unit	8. Protection rail unit
2. Pouch feeding unit	9. Filling up and down unit
3. Electric cabinet unit	10. Pouch shaking unit
4. Zipper opening unit	11. Cold sealing unit
5. Printer unit	12. Sealing unit
6. Stand-up opening unit	13. Product out-feed conveyor unit
7. Pouch opening unit	

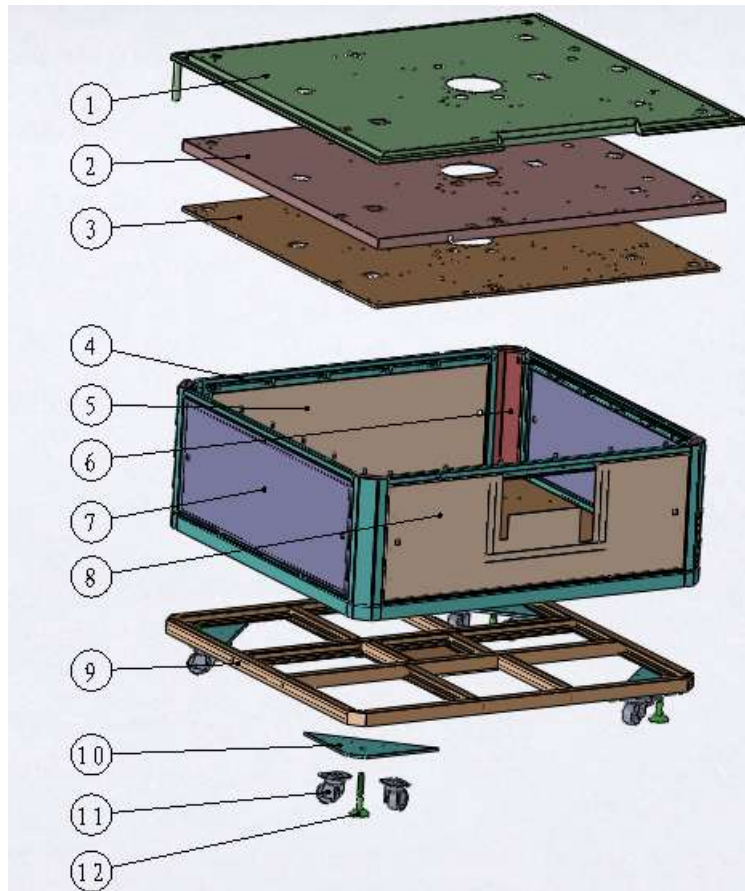
Notice: Pouch shaking unit is an optional device.

II. Main driving unit



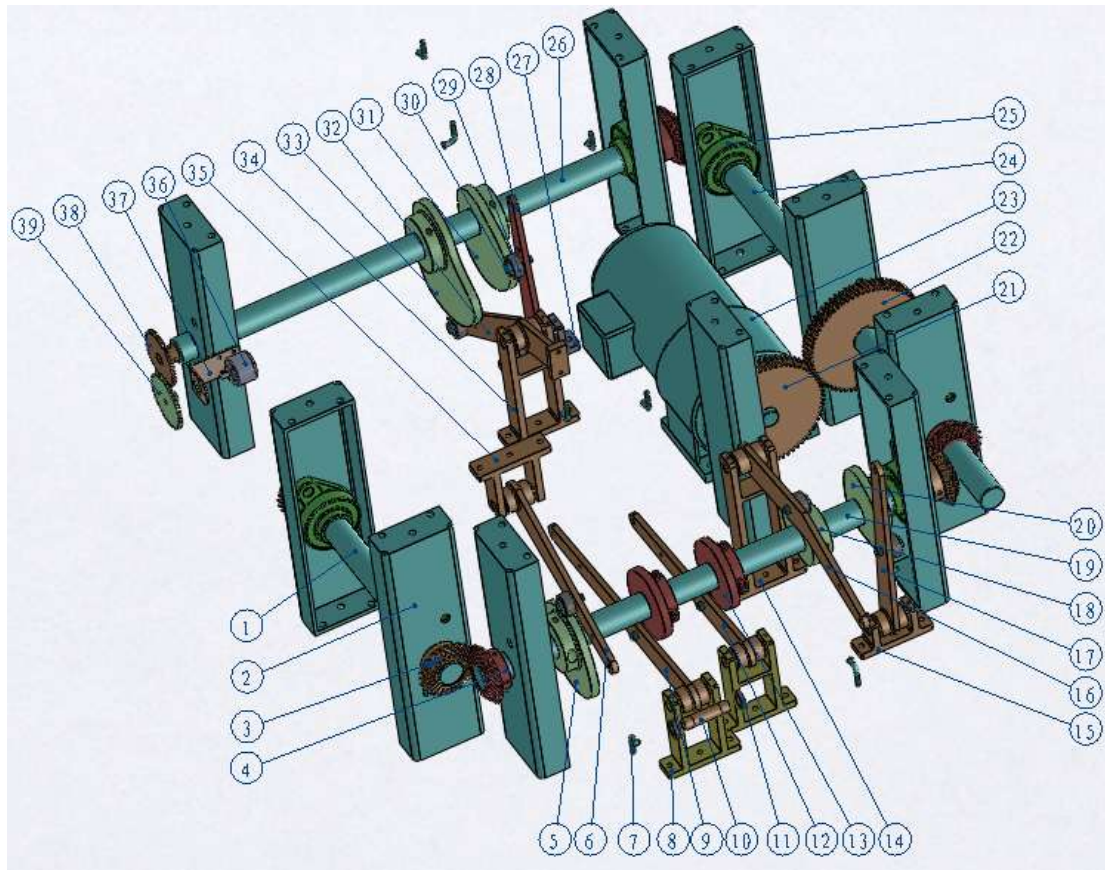
1. Machine box	5. Mechanical tongs unit
2. Main driving unit	6. Pushing tongs unit
3. Turn table unit	7. Pouch top unit
4. Swing arm unit	8. Pouch feeding unit

2.1 The Machine Box



No	Model	Name	Qty
1	AP-8BT-01-01A	Waterproof hood board	1
2	AP-8BT-01-01A	Hood board	1
3	AP-8BT-01-02A	Flat board	1
4	AP-8BT-01-00B	The hood board welding of machine frame	1
5	AP-8BT-01-21A	Back door	1
6	AP-8BT-01-05	Buck stay / Supporting column	4
7	AP-8BT-01-19A	Two-side door	2
8	AP-8BT-01-35	Front door welding	1
9	AP-8BT-01-00A	Bottom seat welding part	1
10	AP-8BT-01-09	The board on the leveling feet	4
11		60*85 Castors	8
12		M20Leveling feet	8

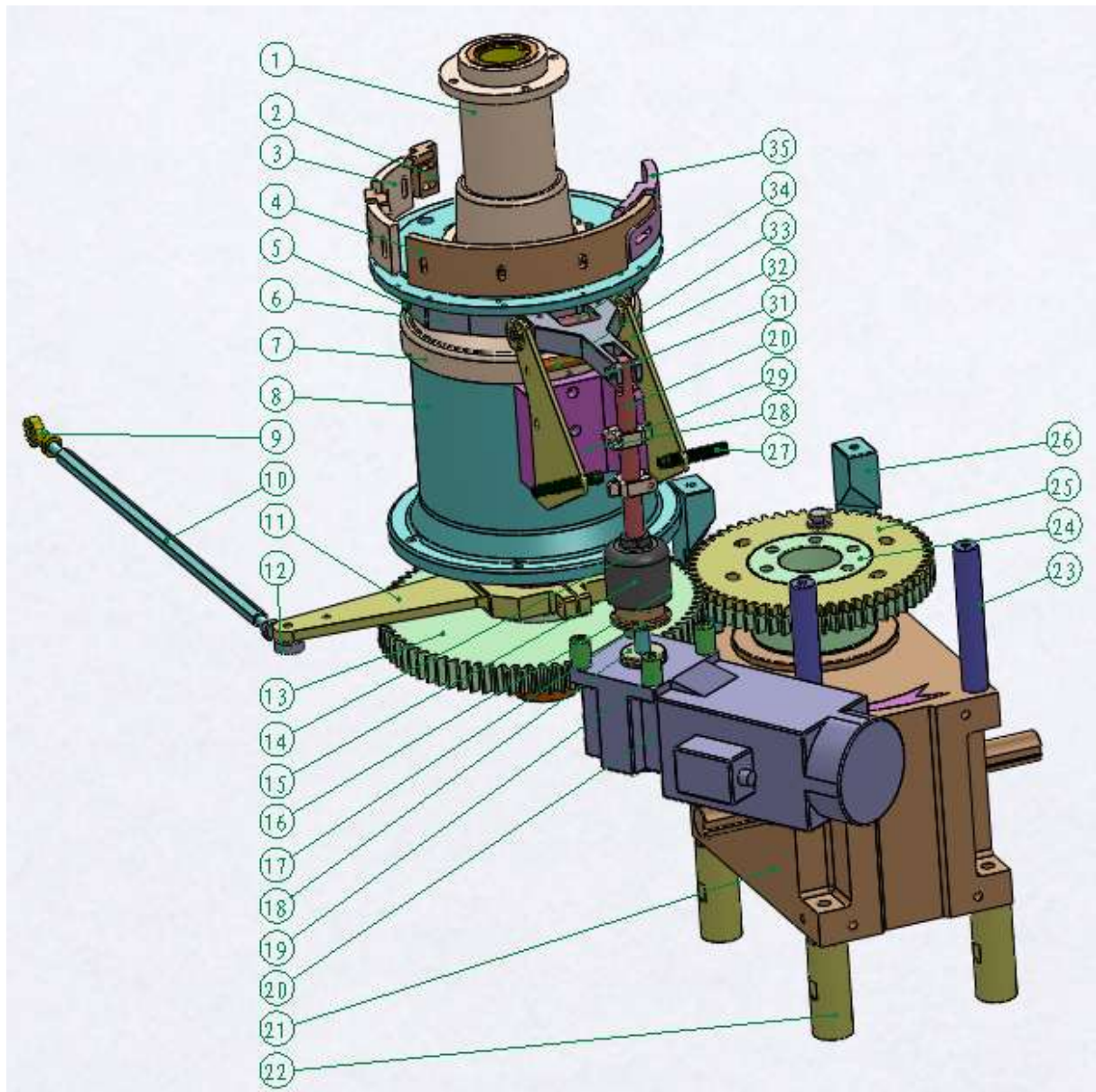
2.2 The Main Driving Unit

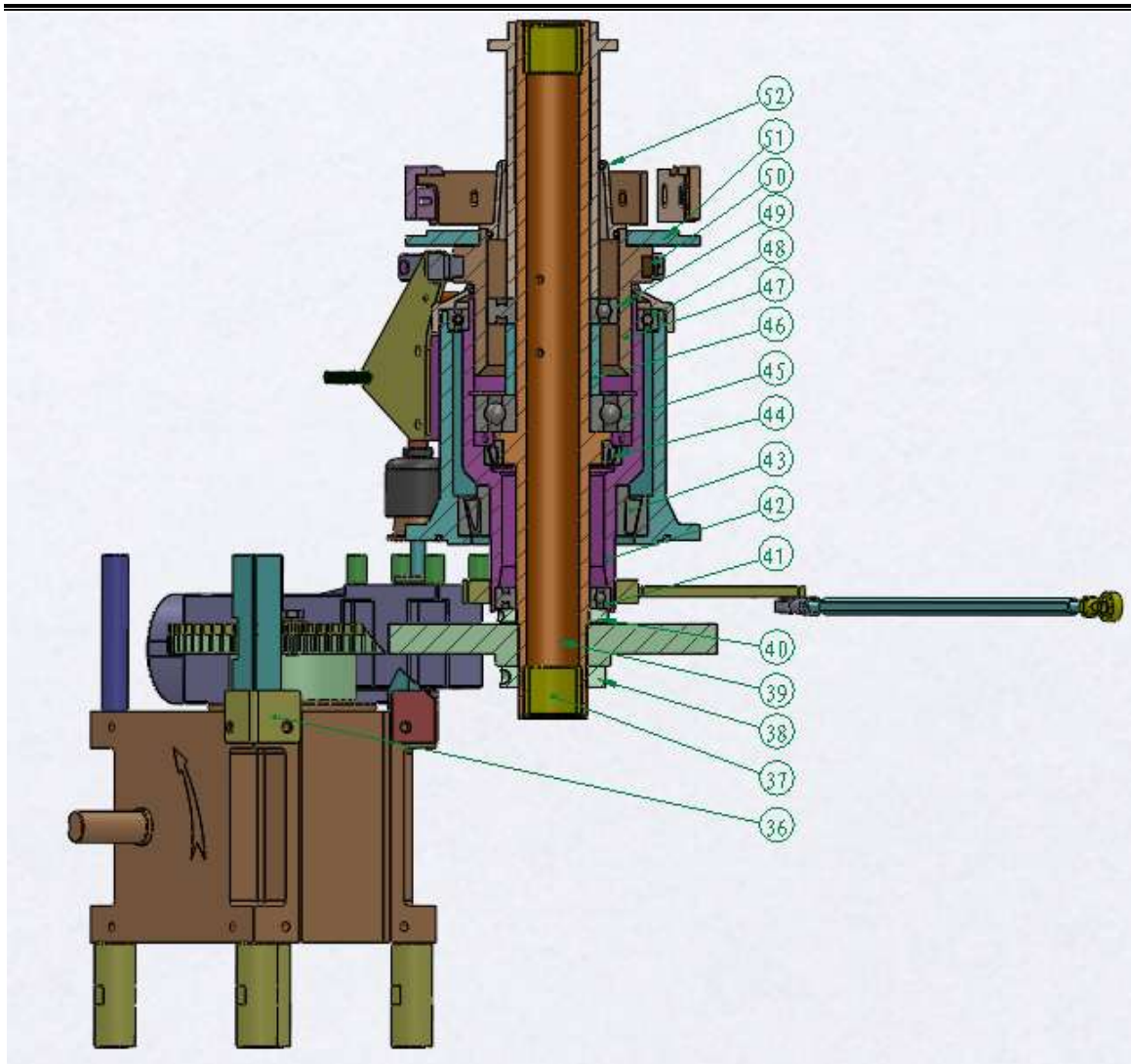


No	Model	Name	Qty
1	AP-8BT-02-03A	Shaft	1
2	AP-8BT-02-01	Bearing block	10
3	AP-8BT-02-05	Spiral bevel gear	4
4	AP-8BT-02-04A	Spiral bevel gear A	4
5	AP-8BT-02-16B	Cam for pouch top	1
6	AP-8BT-02-17	Connecting rod for pouch top	1
7	AP-8BT-02-15	Hook	12
8	AP-8BT-02-21	The connecting rod seat of flexible finger	2
9	AP-8BT-02-23	The connecting rod A of flexible finger	1
10	AP-8BT-02-21	The shaft of connecting rod for storing pouch up	7
11		Deep groove ball bearing 61804 ZZE	14
12	AP-8BT-02-20	The connecting rod of flexible finger	1
13	AP-8BT-02-19	The cam of flexible finger	2
14	AP-8BT-02-10	The connecting rod seat of pouch storing up	1
15	AP-8BT-02-26	The connecting rod seat of slide	1

		sleeve	
16	AP-8BT-02-09A	The connecting rod of pouch storing up	1
17	AP-8BT-02-25	The connecting rod of slide sleeve	1
18	AP-8BT-02-14	The cam of pouch storing up	1
19	AP-8BT-02-02A	Shaft	1
20	AP-8BT-02-27	The cam of slide sleeve	1
21	AP-8BT-02-07	Helical gear A	1
22	AP-8BT-02-08	Helical gear B	1
23	GH-32-1500-30-S-B	Triple-phase gear speed-down motor	1
24	AP-8BT-02-03	Shaft	1
25		Bearing with block UCFL209	8
26	AP-8BT-02-02	Shaft	1
27	AP-8BT-02-32	The connecting rod seat of swing arm	1
28	AP-8BT-02-31A	The connecting rod of swing arm	7
29		Double-lane angular contact bearing 3203A	7
30	AP-8BT-02-12	Pin roll	1
31	AP-8BT-02-33A	Swing arm cam	1
32	AP-8BT-02-34A	The lifting connecting rod of swing rod	1
33	AP-8BT-02-36	The lifting cam of swing arm	1
34	AP-8BT-02-35A	The connecting rod seat of swing arm	1
35	AP-8BT-02-18	The connecting rod seat of pouch top	1
36		Encoder E50SB-360-3-2-24-2C	1
37	AP-8BT-02-49	Encoder frame	1
38	AP-8BT-02-47	Gear to reflect the signal	1
39	AP-8BT-02-48	The gear for encoder	1

2.3 Turn table unit

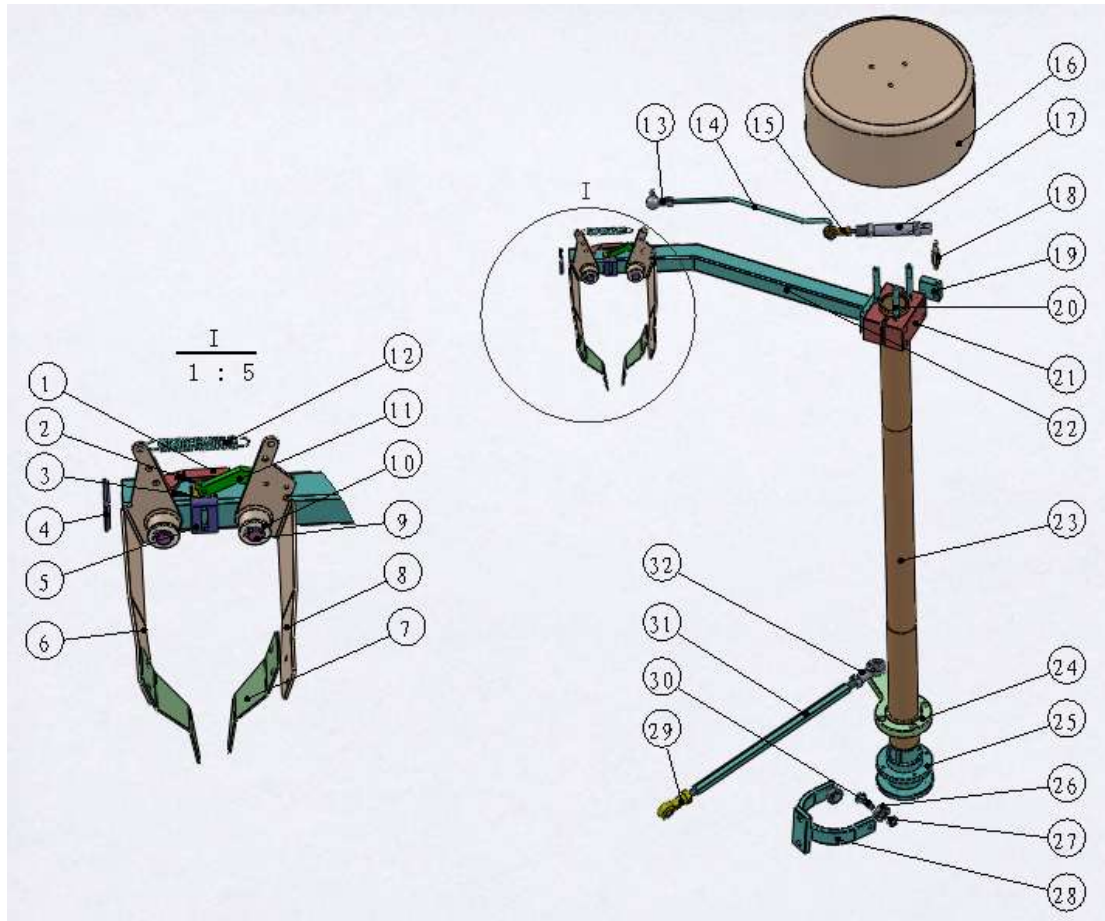




No	Model	Name	Qty
1	AP-8BT-07-10	The seat of turn table	1
2	AP-8BT-07-31B	Adjusting block B	2
3	AP-8BT-07-32	Adjusting block A	2
4	AP-8BT-07-31	Adjusting block	1
5	AP-8BT-07-23	Dowel	2
6	AP-8BT-07-17	U-shaped folk	1
7	AP-8BT-07-42	Big screw nut	1
8	AP-8BT-07-04	The seat of turn table	1
9		Joint bearing M10 with the left rotary inner teeth	1
10	AP-8BT-07-27A	Draft bar	1
11	AP-8BT-07-26	Connecting rod	1
12		Joint bearing M10 with inner teeth	1
13	AP-8BT-07-02	Driven gear	1

14	AP-8BT-07-25	Waterproof bushing	1
15	AP-8BT-07-24	Waterproof seat	1
16	AP-8BT-07-34	Pin roll	1
17	AP-8BT-07-19	Draft bar	1
18	AP-8BT-07-21	Flexible screw nut	1
19	AP-8BT-07-22	Insulation sleeve	4
20	100YS200GV22+100GF50RC	Motor & speed-down box with right angle but empty of inner box	1
21	RU-110DF061202RS3VW1	Indexing gear box	1
22	AP-8BT-07-40A	Steel column placed under the machine	4
23	AP-8BT-07-39A	Stand-up column	2
24	AP-8BT-07-01	Driving gear	1
25	AP-8BT-07-35	Gear with side pressing trace	1
26	AP-8BT-07-39	Stand-up column	2
27		Sensor PRCMT12-4DN	2
28	AP-8BT-07-13	Supporting seat	1
29	AP-8BT-07-20	Detecting block	2
30	AP-8BT-07-33	Draft bar joint	2
31	AP-8BT-07-18	Pin roll	1
32	AP-8BT-07-14	Side board	2
33	AP-8BT-07-15	Supporting rod	1
34	AP-8BT-07-16	Pin roll	1
35	AP-8BT-07-31A	Adjusting block A	1
36	AP-8BT-07-44	Positioning spacer	2
37	AP-8BT-07-05	Guiding copper bushing	2
38	AP-8BT-07-41	Screw nut	1
39	AP-8BT-07-03	Main shaft	1
40	AP-8BT-07-43	Screw nut	1
41		Deep groove ball bearing 6014 ZZE	1
42	AP-8BT-07-06	Bearing block	1
43		Conic roll bearing 33024	1
44		Conic roll bearing 32919	1
45		Deep groove ball bearing 6314 ZZE	1
46	AP-8BT-07-09	Insulation sleeve	1
47	AP-8BT-07-07	Slide sleeve	2
48		Deep groove ball bearing 61832 ZZE	1
49		Deep groove ball bearing 6214 ZZE	1
50	AP-8BT-07-12	Supporting block	1
51	AP-8BT-07-28	Flange disk	1
52	AP-8BT-07-31	Adjusting block	1

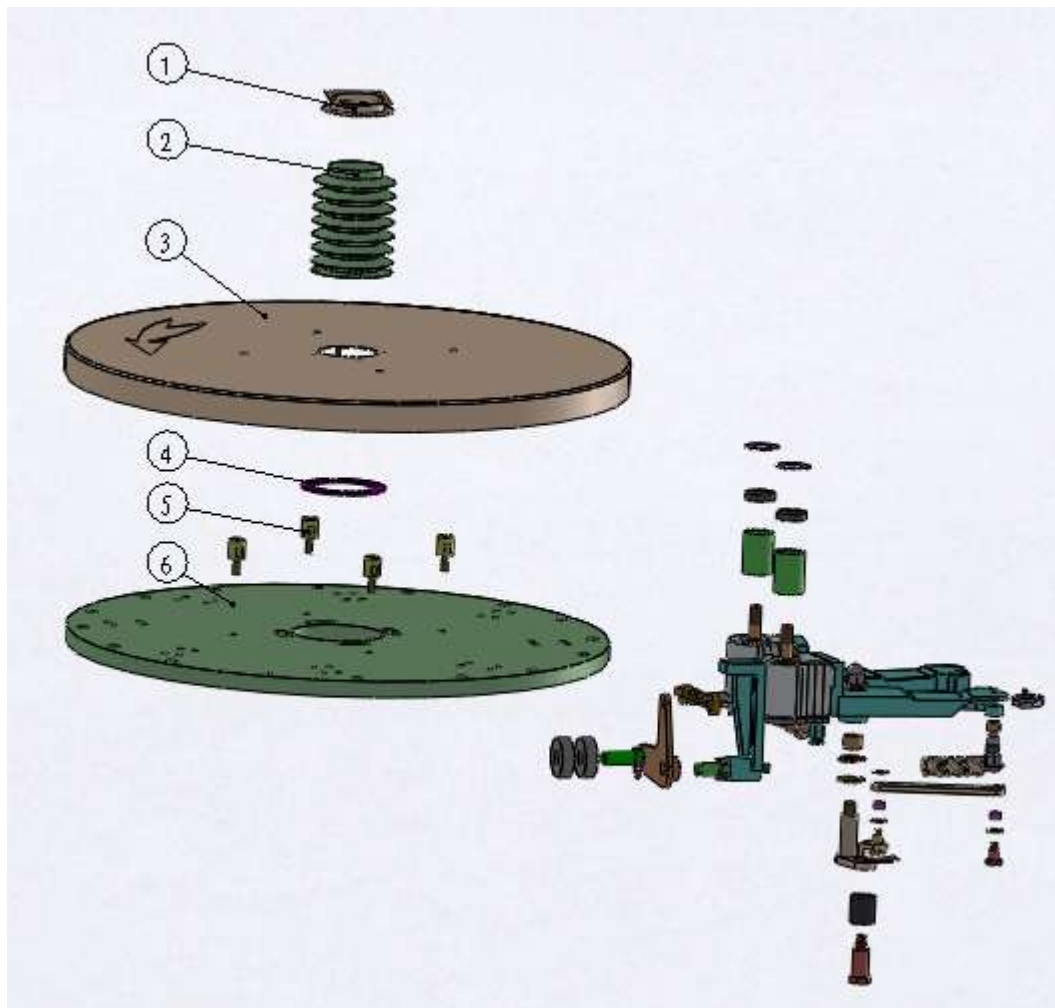
2.4 Swing arm unit

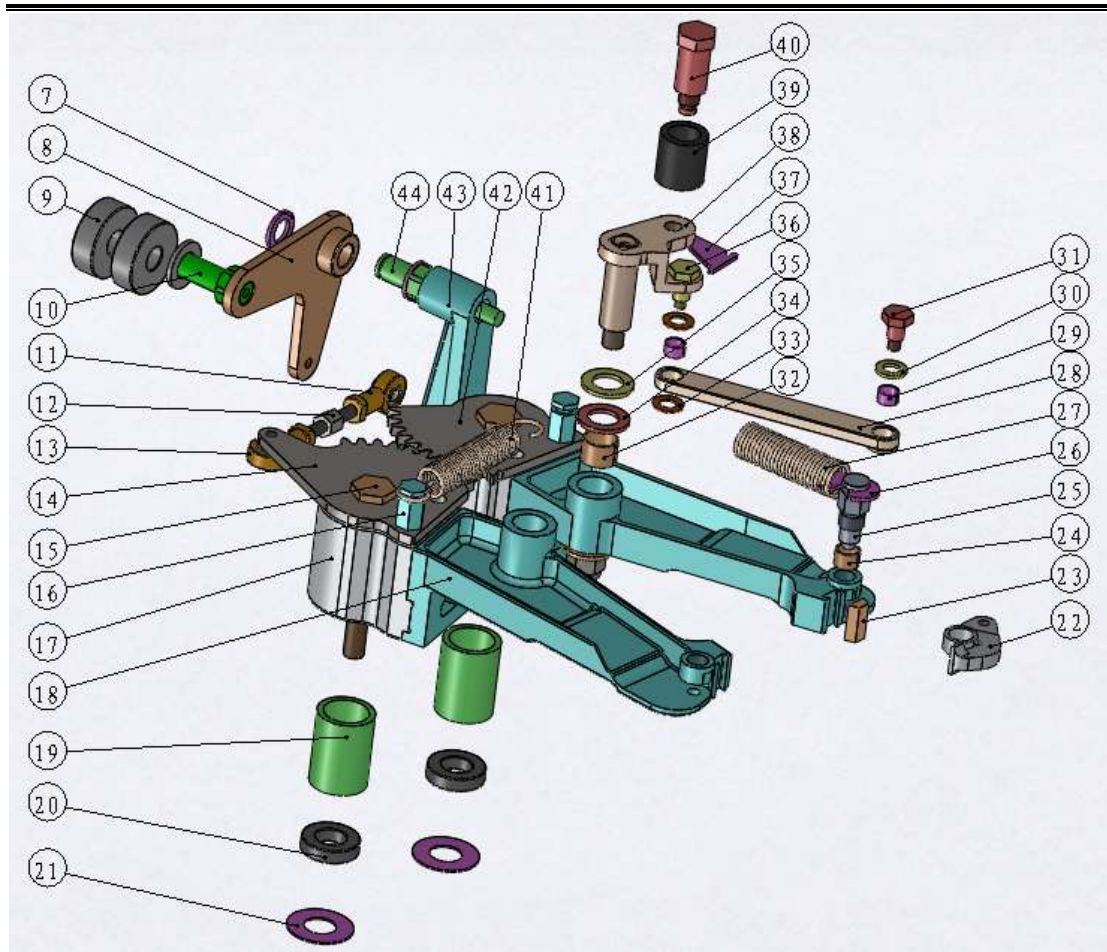


No	Model	Name	Qty
1	AP-8BT-08-11	Balance board	1
2		Deep groove ball bearing 605 ZZE	2
3	AP-8BT-08-23	Silicone cushion	1
4	AP-8BT-08-02	Plug	1
5	AP-8BT-08-13	Adjusting board	1
6	AP-8BT-08-08	The right clipping board	1
7	AP-8BT-08-09	The board for opening the pouch	2
8	AP-8BT-08-07	The left clipping board	1
9	AP-8BT-08-06	Pin roll	2
10	AP-8BT-08-27	Cushion	4
11	AP-8BT-08-10	Movable board	1
12	AP-8BT-08-12	Tension spring	1
13		SQ6-RS Tortuous rod shaped joint bearing	1
14	AP-8BT-08-14A	Draft bar	1
15		Joint bearingM6 with inner teeth	1

16	AP-8BT-08-19A	Round top hood	1
17		Cylinder C85N16-25C	1
18	AP-8BT-08-26	The threaded column of swing arm cylinder	1
19	AP-8BT-08-15	Support seat	1
20	AP-8BT-08-18	Support rod	3
21	AP-8BT-08-03	Swing arm seat	1
22	AP-8BT-08-01A	Swing arm	1
23	AP-8BT-08-04	Hollow shaft	1
24	AP-8BT-08-17	The board for switch angle	1
25	AP-8BT-08-16	Slide sleeve	1
26		Deep groove ball bearing 6000 ZZE	2
27	AP-8BT-08-22	Insulation sleeve	2
28	AP-8BT-08-20	U-shaped folk	1
29		Joint bearing M10 with left rotary inner teeth	1
30	AP-8BT-08-21	Pin roll	2
31	AP-8BT-08-24A	Connecting rod	1
32		Joint bearing M10 with inner teeth	1

2.5 Mechanical Tongs unit

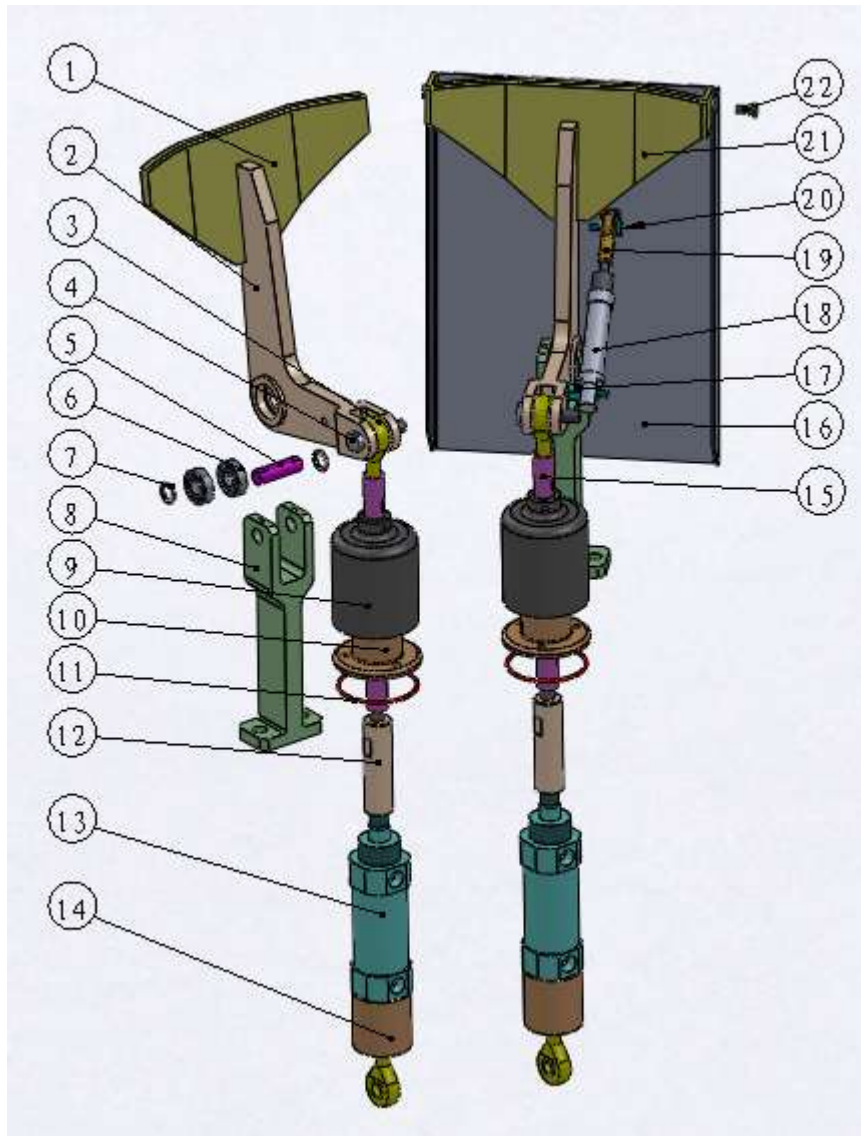




No	Model	Name	Qty
1	AP-8BT-06-32	The cover of dustproof sleeve	1
2	AP-8BT-06-33	Dustproof sleeve	1
3	AP-8BT-06-30A	Round bushing	1
4	AP-8BT-06-31	The cushion under the dustproof sleeve	1
5	AP-8BT-06-29A	Fixed distance rod A	4
6	AP-8BT-06-16A	Mounting disk	1
7	AP-8BT-06-25	Washer	16
8	AP-8BT-06-22	Pull board	8
9		6301 ZZE Deep groove ball bearing	16
10	AP-8BT-06-26A	Roll shaft	8
11		Joint bearingM6 with left rotary inner teeth	8
12	AP-8BT-06-20	Adjusting screw rod A	8
13		Joint bearingM6 with inner teeth	8
14	AP-8BT-06-18	Fan shaped gear B	8
15	AP-8BT-06-13	Links shaft	16

16	AP-8BT-06-21A	The column connecting with tension spring	16
17	AP-8BT-06-10	Bearing block	16
18	AP-8BT-06-01	Left& right mechanical tongs	16
19	AP-8BT-06-11	Insulation sleeve	16
20		61902 ZZE Deep groove ball bearing	16
21	AP-8BT-06-12	Washer	16
22	AP-8BT-06-02	Clamp of mechanical tongs	16
23	AP-8BT-06-02A	Protective block	16
24		Bushing A	16
25	AP-8BT-06-04	Dowel of clamp	16
26	AP-8BT-06-27	Tension spring hook A	16
27	AP-8BT-06-09	Tension spring	16
28	AP-8BT-06-07	Draft bar	16
29		Bushing B	16
30	AP-8BT-06-05A	Small washer	32
31	AP-8BT-06-05	Dowel A	16
32		Bushing C	32
33	AP-8BT-06-19C	Washer C	32
34	AP-8BT-06-19A	Washer A	32
35	AP-8BT-06-19B	Washer B	32
36	AP-8BT-06-06	Dowel C	16
37	AP-8BT-06-28	Tension spring hook B	16
38	AP-8BT-06-03-01	Left & right swing board	16
39	AP-8BT-06-14	Polyformaldehyde sleeve	16
40	AP-8BT-06-08	Dowel B	16
41	AP-8BT-06-21	Tension spring	8
42	AP-8BT-06-17	Fan-shaped gear A	8
43	AP-8BT-06-23	Support seat	8
44	AP-8BT-06-24	Connecting rod shaft	8

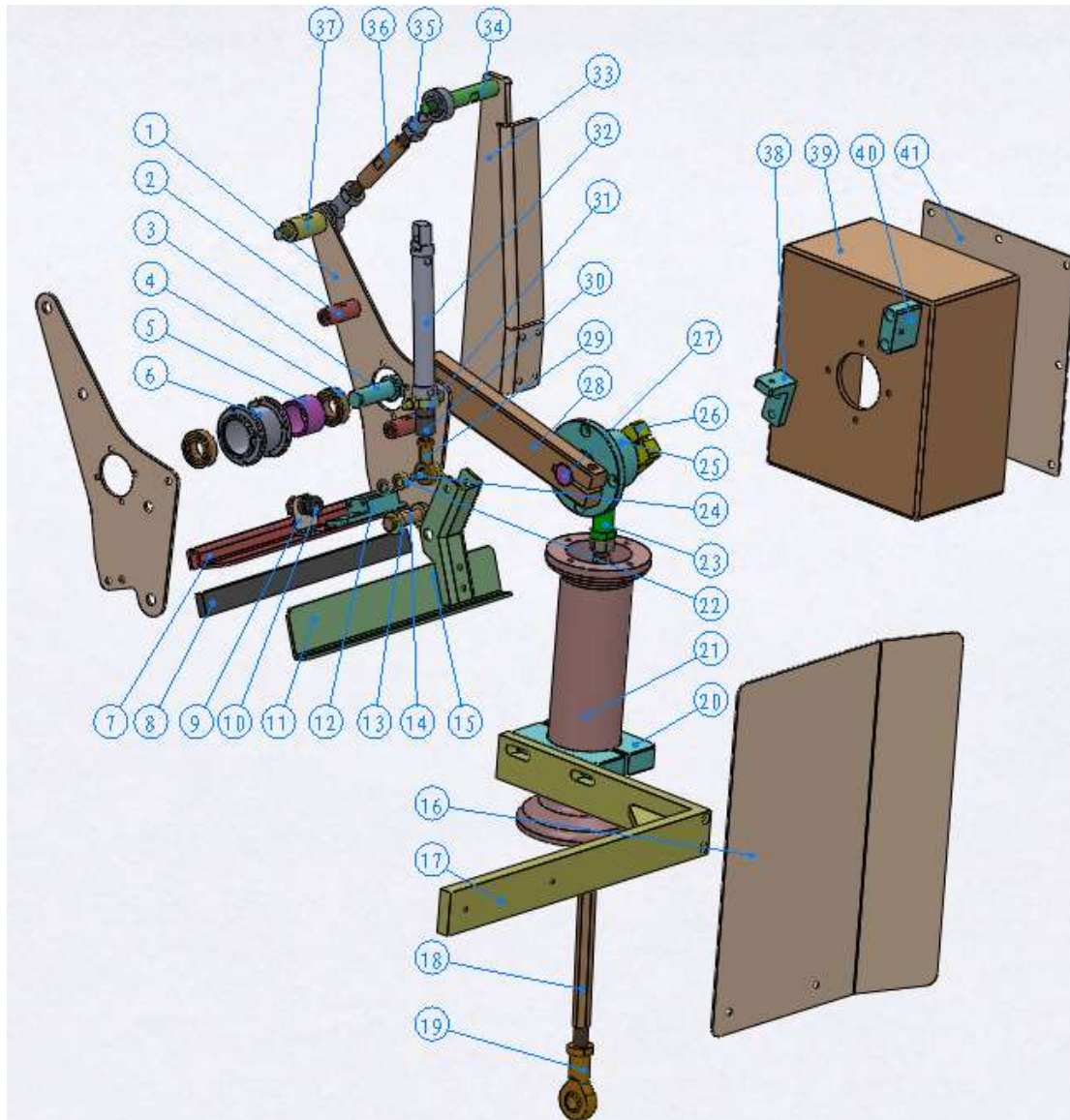
2.6 Pushing tongs unit



No	Model	Name	Qty
1	AP-8BT-10-20A	Rear board	1
2	AP-8BT-10-21	Pushing arm	2
3		Joint bearing M10 with outer teeth	4
4	AP-8BT-10-05	Small shaft of pushing seat	2
5	AP-8BT-10-04	Smooth shaft	2
6		Deep groove ball bearing 6002-2Z	4
7	AP-8BT-10-03	Insulation cushion	2
8	AP-8BT-10-22	Pushing rod seat	2

9	AP-8BT-10-13	Waterproof bushing	2
10	AP-8BT-10-12	Bushing	2
11		O Type sealing ring 58×2.65	2
12	AP-8BT-10-14	Transitional joint	2
13		Cylinder CM2B40-25A	2
14	AP-8BT-10-15	The seat of cylinder	2
15	AP-8BT-10-10	Draft bar	2
16	AP-8BT-10-01	Pusher	1
17	AP-8BT-10-02	Cylinder screw column	1
18		Cylinder C85N16-25C	1
19		Joint bearing M6 with inner teeth	1
20	AP-8BT-10-06	Pusher dowel	1
21	AP-8BT-10-20	Rear board	1
22	AP-8BT-10-07	Fixed screw of pusher	2

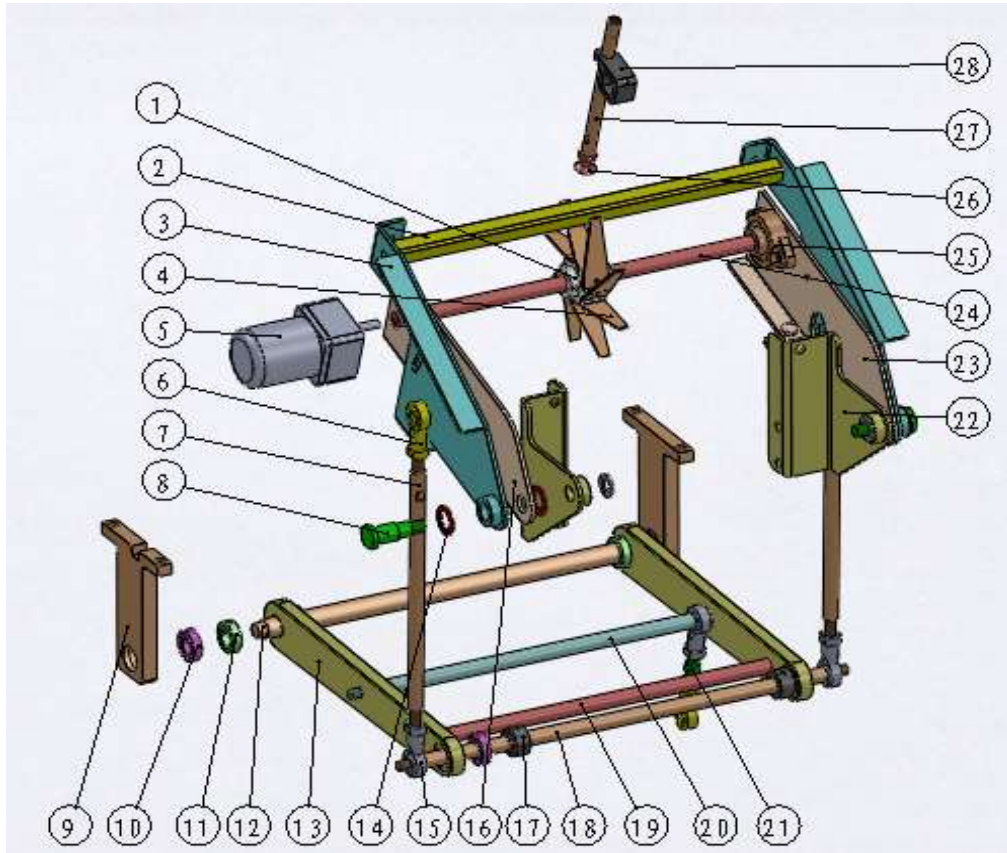
2.7 Product in-feed unit



No	Model	Name	Qty
1	AP-8BT-03-01	Connecting board	2
2	AP-8BT-03-13	Distance fixed shaft	2
3	AP-8BT-03-16	Fixed shaft	1
4		Deep groove ball bearing 6002 ZZE	2
5	AP-8BT-03-15	Insulation sleeve	1
6	AP-8BT-03-14	Bearing sleeve	1
7	AP-8BT-03-03A	Rear clipping board	1
8	AP-8BT-03-05A	Foam rubber cushion	1
9	AP-8BT-03-32	L type board	1
10		Conduction through joint	1

		with inner teeth APMF6-01	
11	AP-8BT-03-04A	Front clipping board	1
12	AP-8BT-03-02	Fixed board	1
13	AP-8BT-03-06	Nylon cushion	2
14	AP-8BT-03-08	Pin roll	1
15	AP-8BT-03-04A-00	Front clipping board welding	1
16	AP-8BT-03-35A	Stop pouch board A	1
17	AP-8BT-03-34A	Stop pouch frame	1
18	AP-8BT-03-24	Rod	1
19		Joint bearing M12with inner teeth	1
20	AP-8BT-03-33	Clamping band	1
21	AP-8BT-03-28	Stand-up column	1
22	AP-8BT-03-11	Insulation cushion	2
23		Joint bearing M12 with left rotary inner teeth	1
24	AP-8BT-03-10	Pin roll	1
25	AP-8BT-03-20	Bearing block	1
26	AP-8BT-03-23	Rocker	1
27	AP-8BT-03-19	Pivot shaft	1
28	AP-8BT-03-18	Swing rod /rod of pendulum	1
29		Joint bearing M6 with inner teeth	1
30	AP-8BT-03-09	Protective cushion	1
31	AP-8BT-03-01A	Double-lug mounting part	1
32		Cylinder C85N16-80	1
33	AP-8BT-03-26	Supporting board	1
34	AP-8BT-03-27	Supporting rod	1
35		Joint bearing M10with inner teeth	2
36	AP-8BT-03-17	Connecting rod	1
37	AP-8BT-03-12	The shaft of pull rod	1
38	AP-8BT-03-30	Tightening position board	1
39	AP-8BT-03-25	The seat of product in-feed device	1
40	AP-8BT-03-31	Tightening position block	1
41	AP-8BT-03-29	Cover board	1

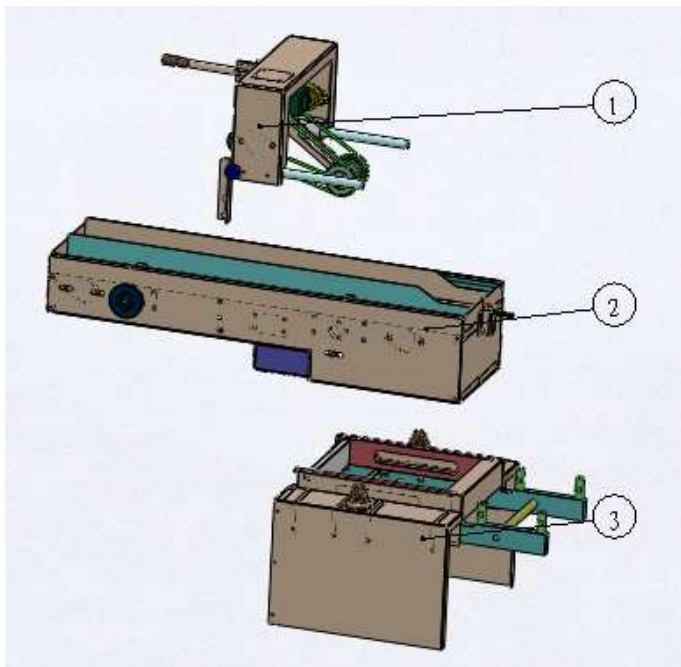
2.8 Pouch feeding unit



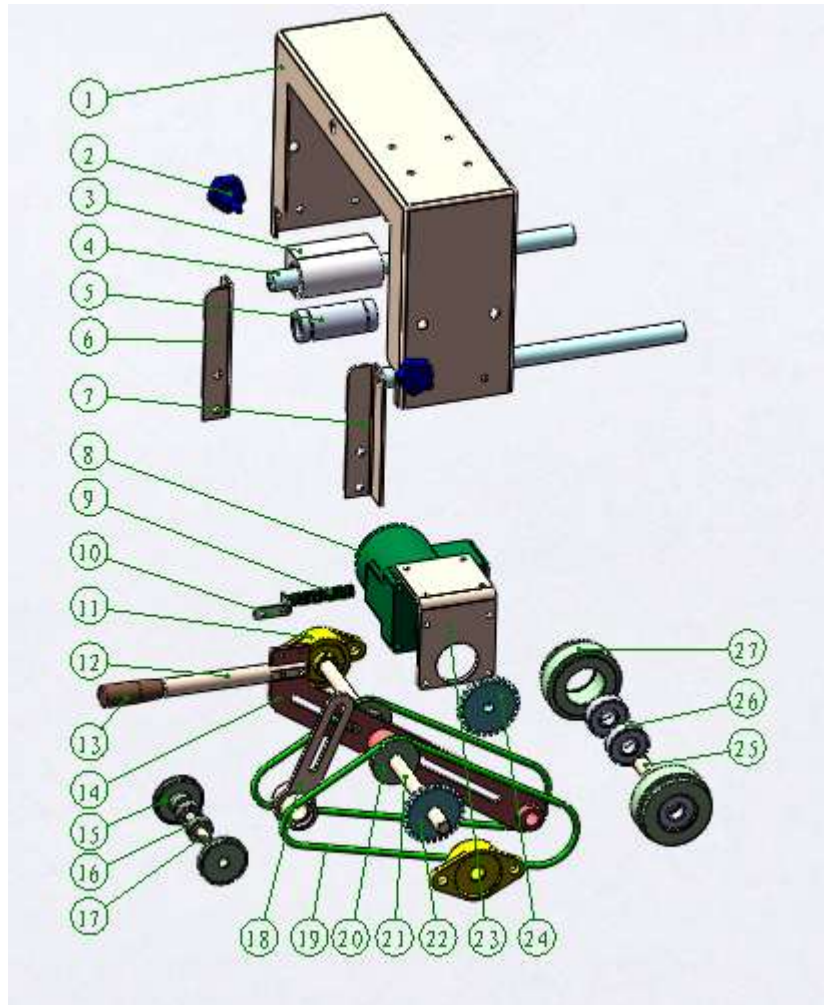
No	Model	Name	Qty
1	AP-8BT-09A-13	Round pulley	1
2	AP-8BT-09-22	Chuck frame	1
3	AP-8BT-09A-03	Left & right crank arm	3
4	AP-8BT-09A-16	Flexible blade	8
5	YN60-10/60JB12.5G8	Speed-down motor	1
6		Joint bearing M10 with left rotary inner teeth	3
7	AP-8BT-09-25	Rod	2
8	AP-8BT-09-38	Dowel	2
9	AP-8BT-09-37	The seat of shaft	2
10		Deep groove ball bearing6002 ZZE	4
11	AP-8BT-09-36	Blocking ring	4
12	AP-8BT-09-35	Pivot shaft	1
13	AP-8BT-09-33	Swing arm	2
14	AP-8BT-09A-31	Teflon washer	4
15		Joint bearing M10 with inner teeth	3
16	AP-8BT-09A-04-01	The base board A of round pulley	1

		motor	
17	AP-8BT-09-34	Tightening position cover	2
18	AP-8BT-09-30A	Horizontal rod	1
19	AP-8BT-09-33B	Connecting rod	1
20	AP-8BT-09-33A	Connecting rod	1
21	AP-8BT-09-25A	Rod	1
22	AP-8BT-09A-06	Left & right support seat	2
23	AP-8BT-09A-05-01	The base board B of round pulley motor	2
24	AP-8BT-09A-10	The shaft of round pulley	1
25		Bearing with block SBLLF202	1
26		Vacuum chuck	2
27	AP-8BT-09-27	Vacuum chuck joint	2
28	AP-8BT-09-26	The frame of pipe	2

III. Pouch In-feed Unit

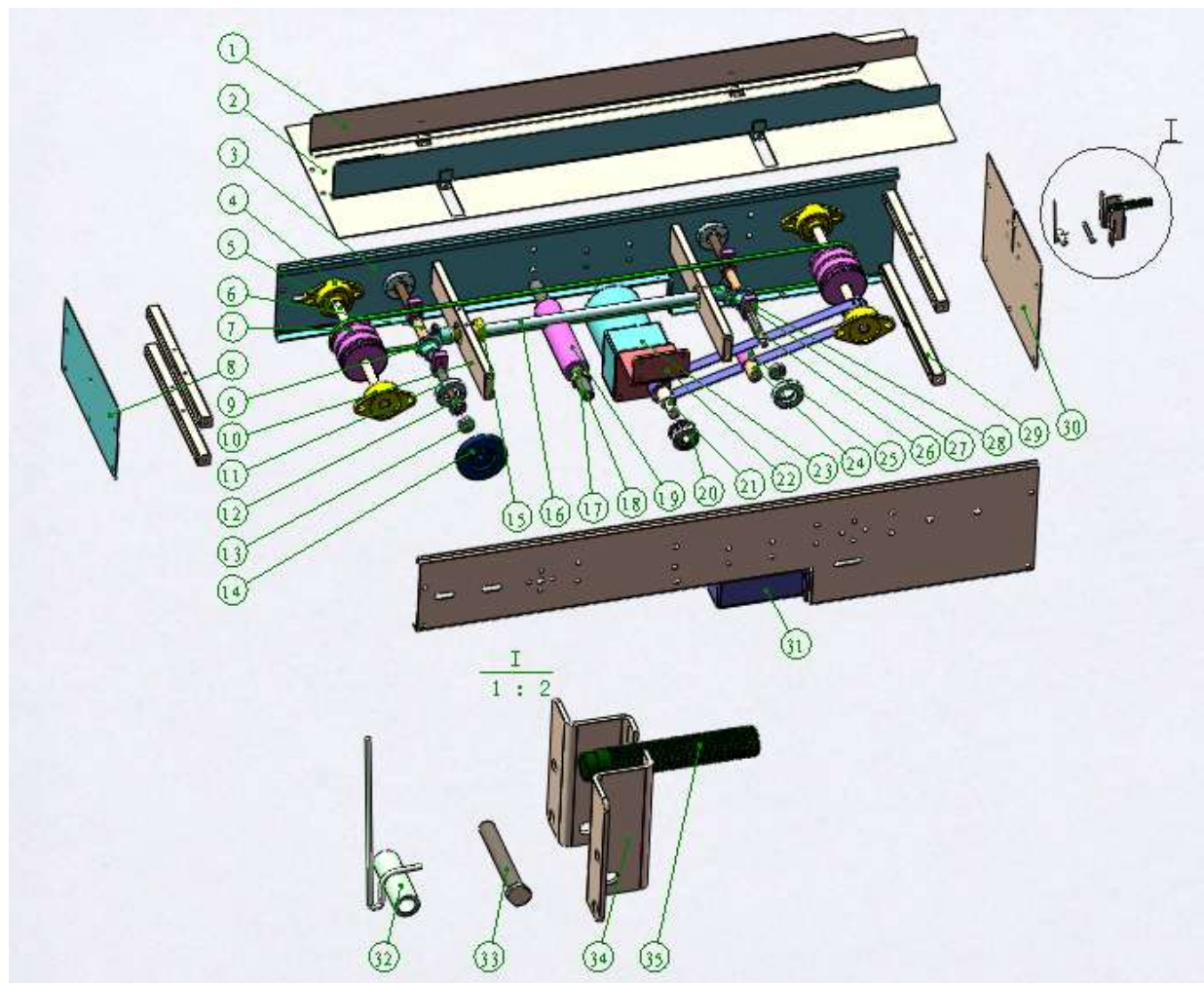


A



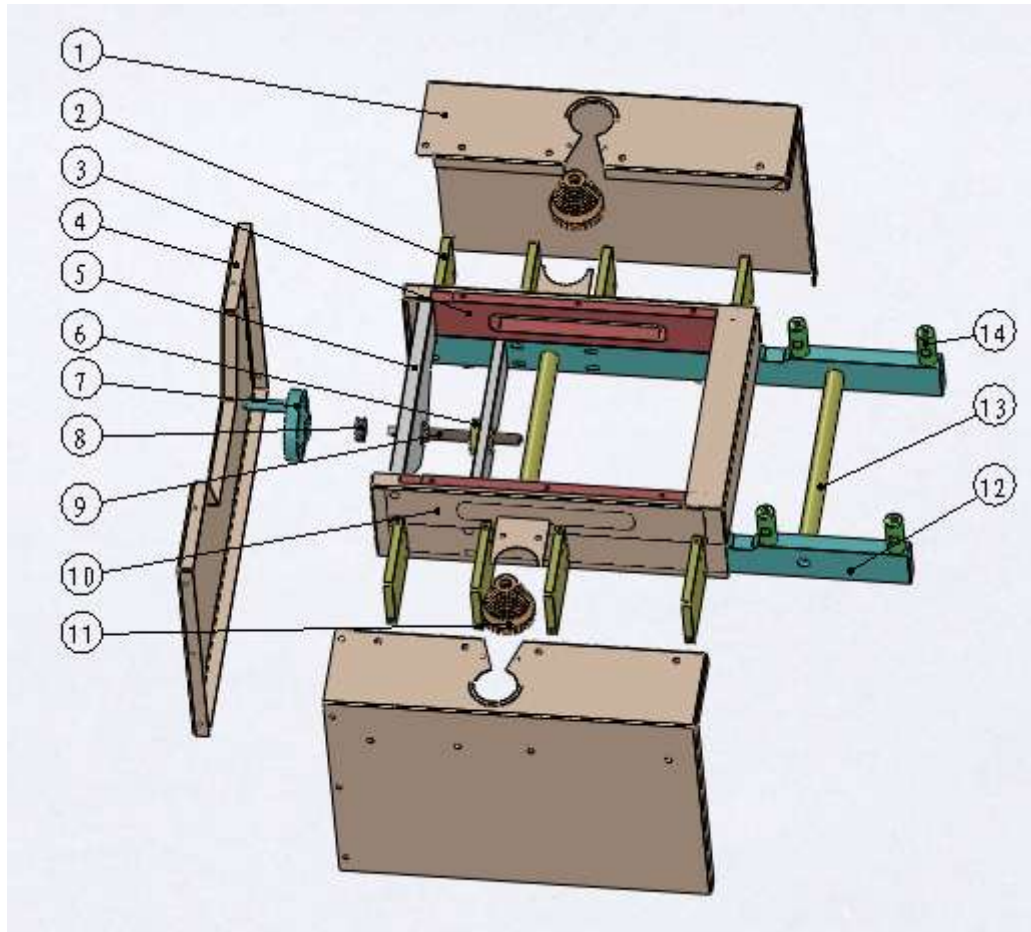
No	Model	Name	Qty
1	AP-8BT-09A-22	Hoisting frame	1
2		B type M8 five-star handle	2
3		Linear bearing block	2
4	AP-8BT-09A-09	Guiding column	2
5		Linear bearing LM20L	2
6	AP-8BT-09A-07	Right support pillar	1
7	AP-8BT-09A-08	Left support pillar	1
8	Y80-25/80JB10G10	Speed-down motor	1
9		Proximity switch	
10	AP-8BT-09A-44	Signal board	1
11		Bearing with block FL202	2
12	AP-8BT-09A-45A	The long rod of handle	1
13		Handle (M8)	
14	AP-8BT-09A-15	The arm of rubber wheel shaft	1
15	AP-8BT-09A-17	Tension wheel	2

16		Deep groove ball bearing 6000-2Z	2
17	AP-8BT-09A-18	The shaft of tension wheel	1
18	AP-8BT-09A-16A	The arm of tension wheel	1
19		Round belt	2
20	AP-8BT-09A-37	Small round belt wheel	2
21	AP-8BT-09A-25	Horizontal shaft	1
22	AP-8BT-09A-19	Driven gear	1
23	AP-8BT-09A-33	Motor board	1
24	AP-8BT-09A-21	Driving gear	1
25	AP-8BT-09A-14	Rubber wheel shaft	1
26		Deep groove ball bearing 6302-2Z	2
27	AP-8BT-09A-11	Pouch feeding roll wheel	2

B

No	Model	Name	Qty
1	AP-8BT-09A-32	Left & right blocking pouch board	2
2	AP-8BT-09A-29	Pouch pallet	1
3	AP-8BT-09A-27	Left & right side board for pouch feeding	2
4		Bearing with block FL202	2
5	AP-8BT-09A-23	The shaft of round belt wheel	2
6	AP-8BT-09A-49	The shaft B of screw rod	1
7	AP-8BT-09A-01	Driven wheel	2
8	AP-8BT-09A-26	Rear closing plank	1
9	AP-8BT-09A-54	Bearing blocking ring	1
10	AP-8BT-09A-51	Beam	2
11	AP-8BT-09A-50	Bearing block	4
12		Deep groove ball bearing 6000-2Z	4
13		Thrust ball bearing 51100	1
14		Hand wheel without handle 80	1
15		Automatic aligning bearing 1202	2
16	AP-8BT-09A-47	Smooth shaft	1
17	AP-8BT-09A-40	The shaft of support pouch	1
18	AP-8BT-09A-35	Blocking ring	2
19	AP-8BT-09A-39	Supporting roller	1
20	AP-8BT-09A-02	Synchronous pulley	2
21	AP-8BT-09A-30	Motor shaft	1
22	AP-8BT-09A-53	Motor fixed board	1
23	Y90-40/90GB36G12	Speed-down motor	1
24	AP-8BT-09A-34	The shaft of tension wheel	1
25	AP-8BT-09A-36	Tension wheel	1
26	AP-8BT-09A-48	The shaft A of screw rod	1
27	AP-8BT-09A-46	Conic gear	4
28	AP-8BT-09A-52	The seat of screw nut	4
29	AP-8BT-09A-24	Horizontal bracing rod	4
30	AP-8BT-09A-28	Front closing plank	1
31	AP-8BT-09A-67	Belt hood	1
32	AP-8BT-09A-43	The rod for reflecting signal	1
33	AP-8BT-09A-42	The shaft for reflecting signal	1
34	AP-8BT-09A-41	Proximity switch frame	1
35		Proximity switch	1

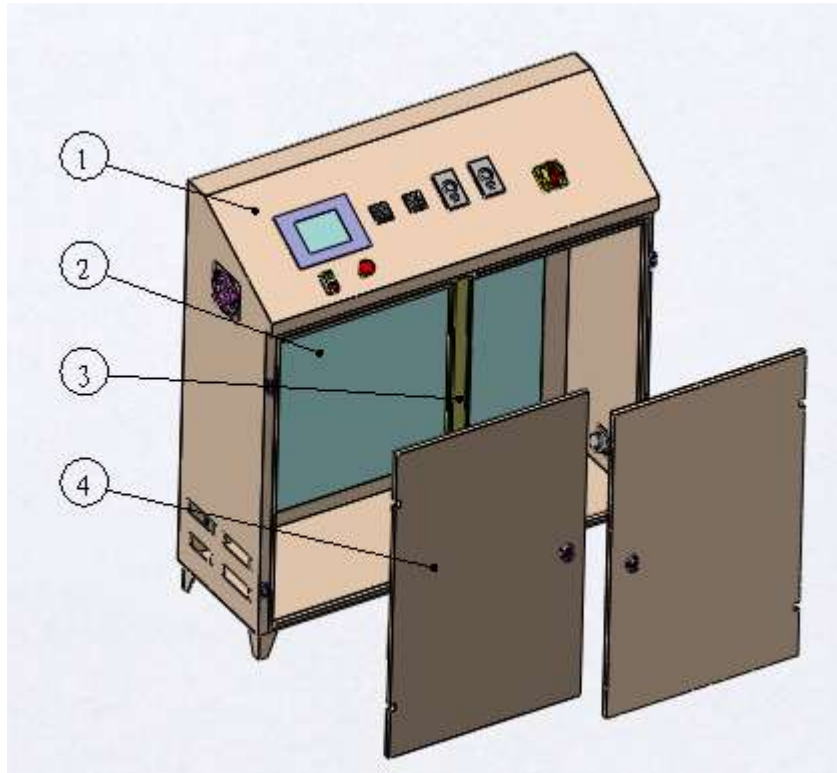
C



No	Model	Name	Qty
1	AP-8BT-09A-55	The second hood of pouch feeding device	2
2	AP-8BT-09A-57	The base board of the second hood of pouch feeding device	8
3	AP-8BT-09A-56	The seat of pouch feeding device	2
4	AP-8BT-09A-61	The rear seat of pouch feeding device	1
5	AP-8BT-09A-62	Adjusting board A of pouch feeding	1
6	AP-8BT-09A-65	Adjusting screw nut of pouch feeding	1
7		Hand wheel	1
8		Thrust ball bearing 51101	2
9	AP-8BT-09A-64	Screw rod moves forward and backward	1
10	AP-8BT-09A-63	Adjusting board B of pouch feeding	1

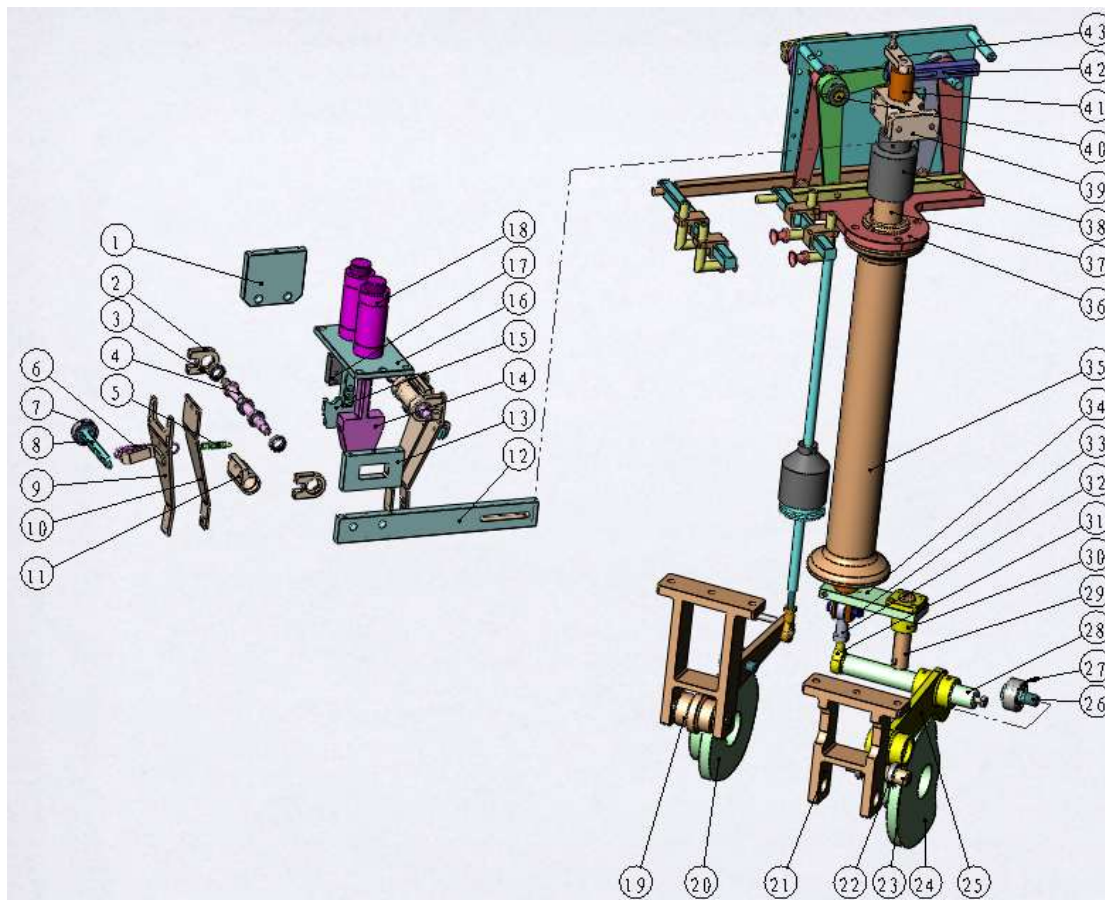
11	AP-8BT-09A-45	The hood A of pouch feeding	2
12	AP-8BT-09A-60	φ50 Pagoda-shaped protected hood	2
13	AP-8BT-09-28	Support arm	2
14	AP-8BT-09-29	Draft bar	2
15	AP-8BT-09-32	Standing pillar	4

IV. Electric cabinet unit



No	Model	Name	Qty
1	AP-8BT-15-01	Electric cabinet	1
2	AP-8BT-15-05	The base board of box	1
3	AP-8BT-15-02	Center beam	1
4	AP-8BT-15-03	The door of electric cabinet	1

V. Zipper opening unit

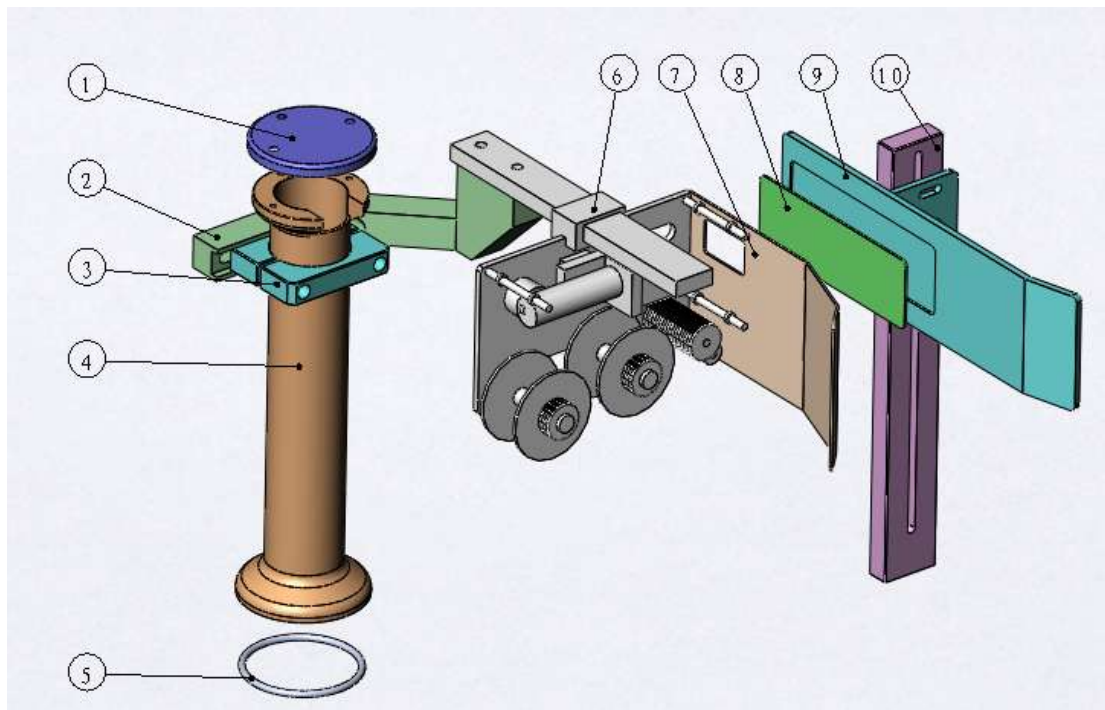


No	Model	Name	Qty
1	AP-8BT-04A-16	Side board	1
2	AP-8BT-04A-18	Bearing block	2
3		61801-2Z Deep groove ball bearing	4
4	AP-8BT-04A-17	Hinge shaft	1
5	AP-8BT-04A-30	Tension spring	1
6	AP-8BT-04A-29	Tension spring	1
7		6201-2Z Deep groove ball bearing	1
8	AP-8BT-04A-26	The shaft of arm	1
9	AP-8BT-04A-19	Finger	2
10	AP-8BT-04A-21	Middle finger	2
11	AP-8BT-04A-20	Middle shaft seat	1
12	AP-8BT-04A-24	Rotate arm	1
13	AP-8BT-04A-25	Lining board	1
14	AP-8BT-04A-22	Wedge	1
15	AP-8BT-04A-27	Wedge	1
16	AP-8BT-04A-23	Cylinder fixed board	1

17	AP-8BT-04A-28	Slide block	1
18		CM2B32-25A Cylinder	2
19	AP-8BT-02-28	Connecting rod for zipper opening	1
20	AP-8BT-02-30A	The cam of zipper opening	1
21	AP-8BT-02-29A	The seat of connecting rod for zipper opening	1
22		61804 ZZE Deep groove ball bearing	2
23	AP-8BT-02-11	Connecting rod shaft of storing pouch	2
24	AP-8BT-02-30B	The cam of zipper opening	1
25	AP-8BT-02-28B	Connecting rod for zipper opening	1
26	AP-8BT-02-12	Pin roll	2
27		3203A Double-lane angular contact bearing	2
28	AP-8BT-02-29B	Connecting rod	1
29	AP-8BT-02-31	Guiding pillar	1
30		LMK20UU Linear bearing	1
31		Joint bearing M10 with outer teeth	1
32		Joint bearing M10 with inner teeth	1
33	AP-8BT-13-11	Dowel	1
34	AP-8BT-13-15	Guiding board	1
35	AP-8BT-04A-10	Standing column	1
36	AP-8BT-04A-09	Zipper opening mounting board	1
37	AP-8BT-04A-13	Bushing	1
38	AP-8BT-04A-14	Waterproof sleeve	1
39	AP-8BT-04A-34	Zipper opening rack	1
40	AP-8BT-04A-08	Pivot shaft	1
41	AP-8BT-04A-33	Driven rod	1
42	AP-8BT-04A-07	The top tightening block B of zipper opening guiding rod	1
43	AP-8BT-04A-06	The top tightening block A of zipper opening guiding rod	1

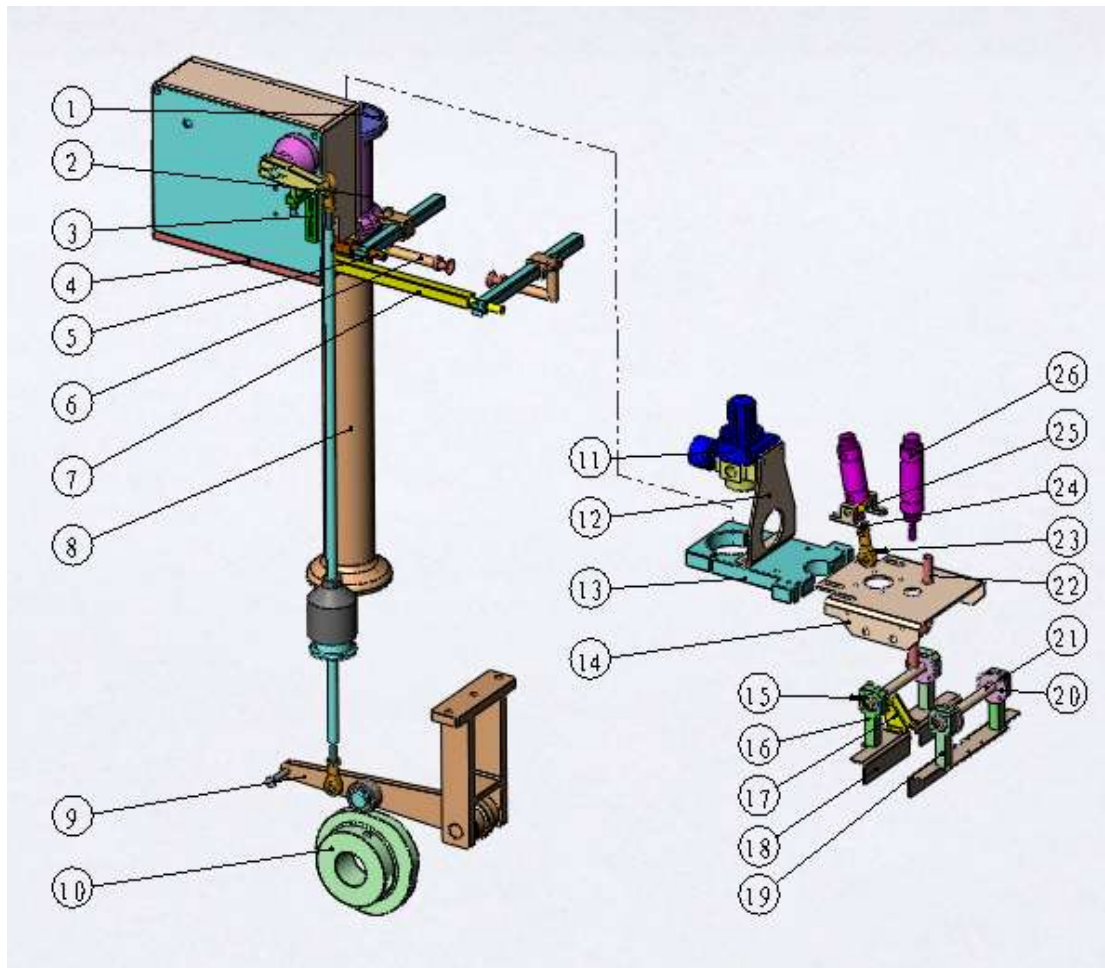
The other parts are same with chapter 7 (Pouch opening unit)

VI. Printer Unit



No	Model	Name	Qty
1	AP-8BT-04-08	The protective cover of printer tube	1
2	AP-8BT-04-01A	Cantilever	1
3	AP-8BT-03-33	Clamping band	1
4	AP-8BT-04-07	Printer stand-up pillar	1
5		O Type sealing ring 87.5×5.3	1
6		Printer	1
7	AP-8BT-04-02	Rear blocking board	1
8	AP-8BT-04-05	Silicone cushion	1
9	AP-8BT-04-04	Front blocking board	1
10	AP-8BT-04-03	Standing pillar	1

VII. Stand-up opening unit

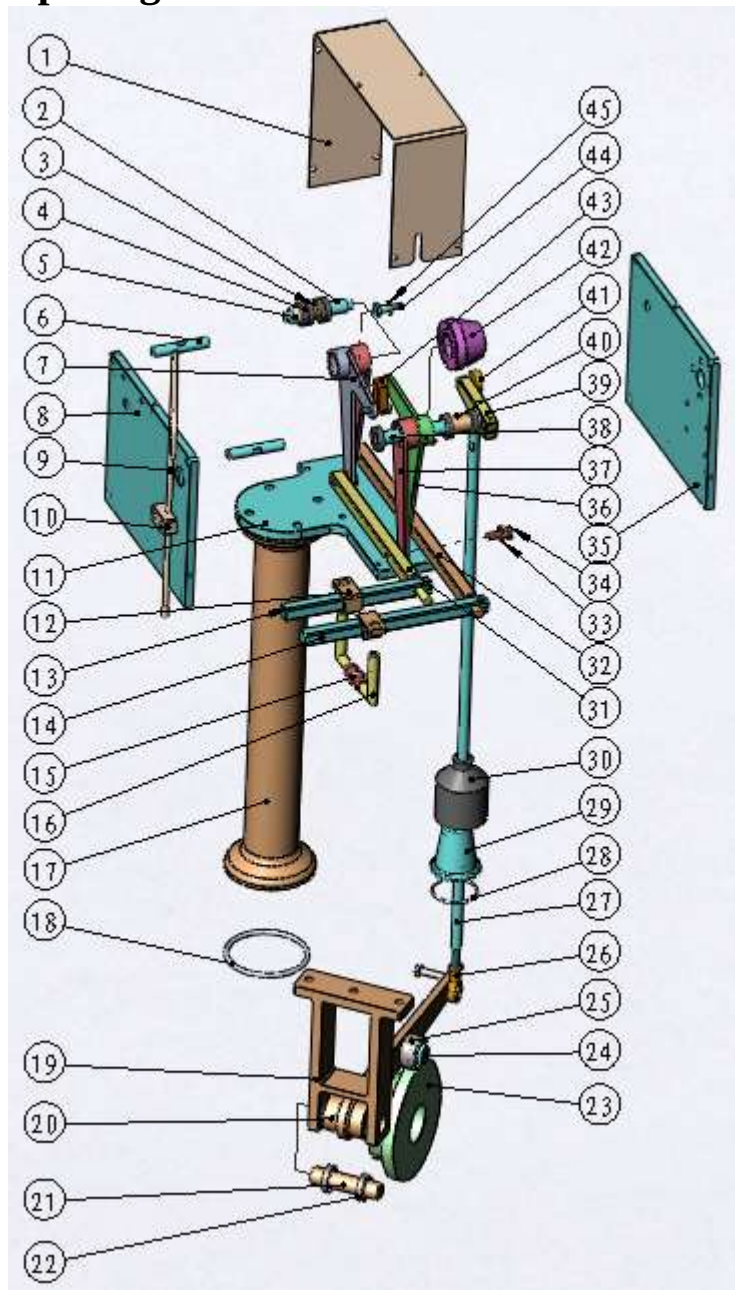


No	Model	Name	Qty
1	AP-8BT-04-08	The protective cover of printer tube	1
2	AP-8BT-05A-03	Stand-up opening pillar	1
3	AP-8BT-04A-05	Chuck tightening pad	1
4	AP-8BT-05A-18	Mounting board	1
5	AP-8BT-05A-17	Short slide rod of stand-up pouch	1
6	AP-8BT-05A-19	Chuck joint	2
7	AP-8BT-05A-16	Long slide rod of stand-up pouch	2
8	AP-8BT-05A-12	Stand-up pillar	1
9	AP-8BT-02-28C	Connecting rod of stand-up pouch	1
10	AP-8BT-02-30C	Stand-up top opening cam	1
11		AR30C-03B Pressure reducing valve (SMC)	1

12	AP-8BT-05A-20	L-type board	1
13	AP-8BT-05A-11	Stand-up opening fixed board	1
14	AP-8BT-05A-02	Mounting board	1
15		6001 ZZ Deep groove ball bearing	4
16	AP-8BT-05A-04	Swing arm A	2
17	AP-8BT-05A-08	Lug	1
18	AP-8BT-05A-01	The opening part of plier	2
19	AP-8BT-05A-15	Swing arm B	2
20	AP-8BT-05A-06	Gear B	4
21	AP-8BT-05A-03	Shaft	2
22	AP-8BT-05A-07	Joint through in three direction	1
23		Joint bearing M8	1
24	AP-8BT-05A-10	Trunnion seat	2
25	AP-8BT-05A-09	Trunnion	1
26		CM2B20-25A Cylinder	1
27		CM2B20-10A Cylinder	1

The other parts are same with chapter 7 (Pouch opening unit)

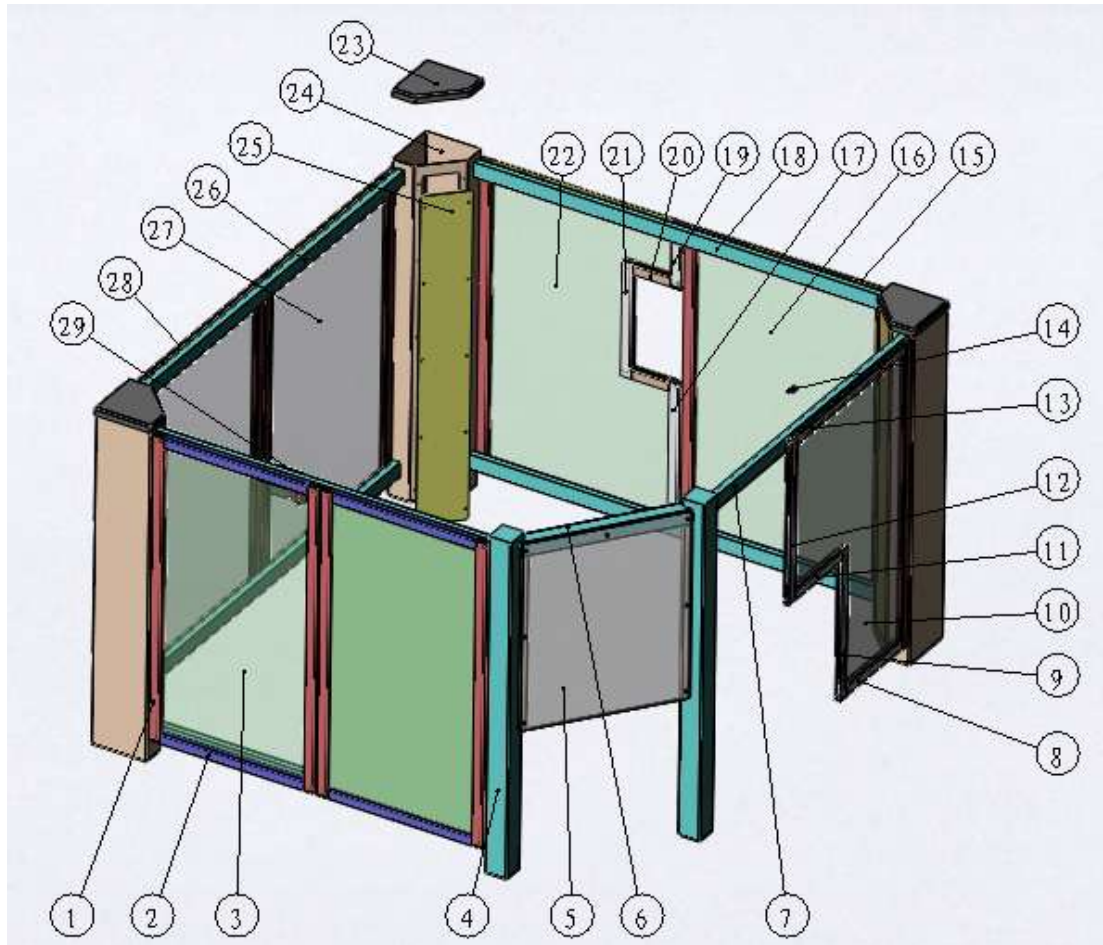
VIII. Pouch Opening Unit



No	Model	Name	Qty
1	AP-8BT-05-28	Protective hood	1
2	AP-8BT-05-16	Fixed shaft	1
3	AP-8BT-05-24	Insulation ring	1
4		61904 ZZF Deep groove ball bearing	7
5	AP-8BT-05-30	Sleeve	1
6	AP-8BT-05-26	Distance fixed rod	2
7	AP-8BT-05-17	Connecting rod B	1
8	AP-8BT-05-15	Right side board	1
9	AP-8BT-05-32	Air-flushing rod	1

10	AP-8BT-05-31	The fixed seat of air-flushing rod	1
11	AP-8BT-05-02	Mounting board	1
12	AP-8BT-05-09	Tube support frame	2
13	AP-8BT-05-07	The frame rod A	1
14	AP-8BT-05-08	The frame rod B	1
15		Chuck for pouch opening	2
16	AP-8BT-05-05	Chuck joint	2
17	AP-8BT-05-01	Stand-up pillar	1
18		O Type sealing ring 87.5×5.3	1
19	AP-8BT-02-29	the seat of connecting rod	1
20	AP-8BT-02-28A	Connecting rod of pouch opening	1
21	AP-8BT-02-21	The shaft of pouch storing up	1
22		61804 ZZE Deep groove ball bearing	2
23	AP-8BT-02-30	Pouch opening cam	1
24	AP-8BT-02-12	Pin roll	2
25		3203A Double-lane angular contact bearing	1
26		Joint bearing M8 with left rotary inner teeth	1
27	AP-8BT-05-27	Draft rod	1
28		O Type sealing ring 48.7×2.65	1
29	AP-8BT-07-24	Waterproof seat	1
30	AP-8BT-05-29	Waterproof sleeve	1
31	AP-8BT-05-04	Short slide rod	1
32	AP-8BT-05-03	Long slide rod	1
33	AP-8BT-05-20	Nylon cushion	4
34	AP-8BT-05- 23	dowel	4
35	AP-8BT-05-13	Left side board	1
36	AP-8BT-05-14	Connecting rod A	1
37	AP-8BT-05-18	Connecting rod C	2
38	AP-8BT-05-10	Pivot shaft	1
39	AP-8BT-05-06	Swing rod	1
40	AP-8BT-05-11	Insulation sleeve	1
41		Joint bearing M8 with inner teeth	1
42	AP-8BT-05-12	Bearing block	1
43	AP-8BT-05-19	Hinge	2
44	AP-8BT-05-22	Pin roll	2
45	AP-8BT-05-21	Insulation cushion	2

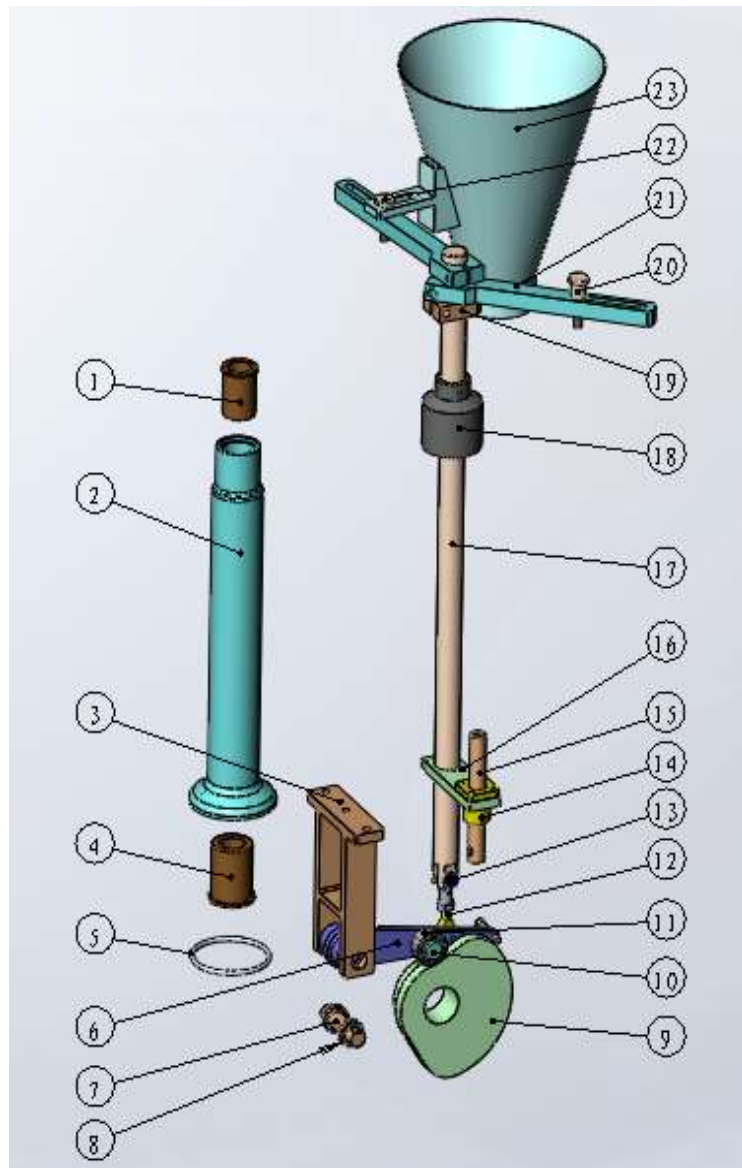
IX. Protection rail unit



No	Model	Name	Qty
1	AP-8BT-01-40A	Standing door beam A	12
2	AP-8BT-01-40B	Door beam B	4
3	AP-8BT-01-33A	Plexiglas door C	2
4	AP-8BT-01-25	Standing pillar	2
5	AP-8BT-01-30D	Glass board	1
6	AP-8BT-01-30A	Top beam E	1
7	AP-8BT-01-29A	Top beam D	1
8	AP-8BT-01-43D	Door beam D	1
9	AP-8BT-01-43E	Standing door beam E	1
10	AP-8BT-01-29D	Plexiglas board	1
11	AP-8BT-01-43C	Door beam C	1
12	AP-8BT-01-43B	Standing door beam B	1
13	AP-8BT-01-43A	Door beam A	1
14	AP-8BT-01-40C	Cover board	31
15	AP-8BT-01-42A	Door beam A	4
16	AP-8BT-01-34A	Plexiglas door D	1
17	AP-8BT-01-42E	Standing door beam E	1
18	AP-8BT-01-26A	Top beam A	1

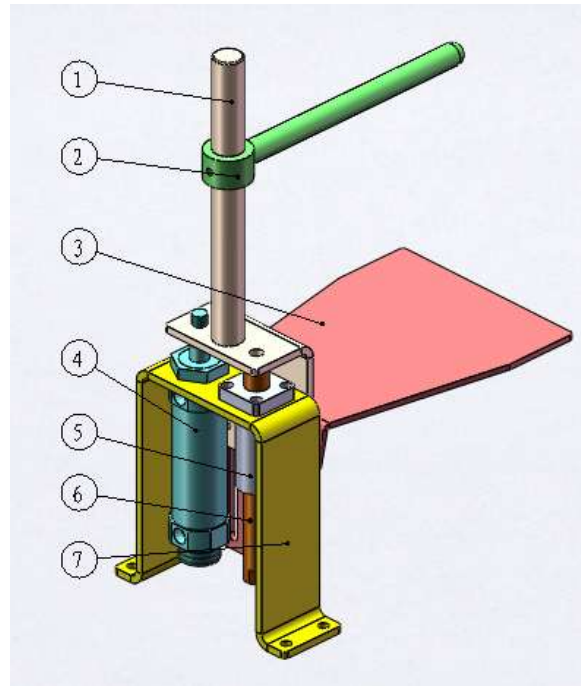
19	AP-8BT-01-42C	Standing door beam C	1
20	AP-8BT-01-42B	Door beam B	1
21	AP-8BT-01-42D	Standing door beam D	1
22	AP-8BT-01-31A	Plexiglas door A	1
23	AP-8BT-01-23	Top hood	3
24	AP-8BT-01-22	Protection rail column	3
25	AP-8BT-01-24	Cover board	3
26	AP-8BT-01-27A	Top beam B	1
27	AP-8BT-01-32A	Plexiglas door B	2
28	AP-8BT-01-41A	Door beam A	4
29	AP-8BT-01-28A	Top beam C	1

X. Filling up and down unit



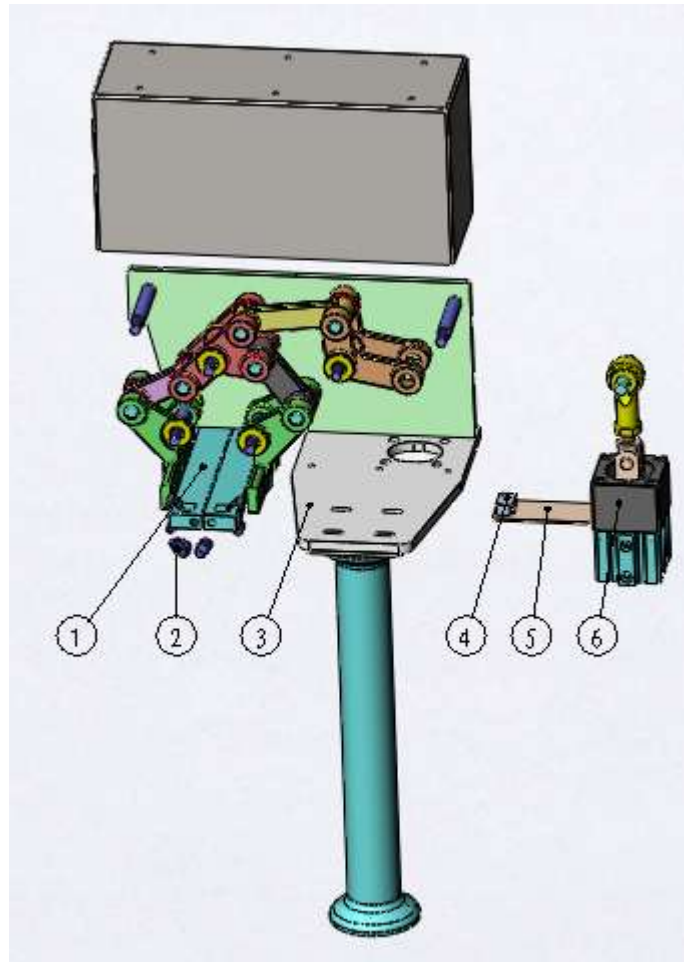
No	Model	Name	Qty
1	AP-8BT-13-02	Sliding bearing A	1
2	AP-8BT-13-01	Standing pillar	1
3	AP-8BT-0-38A	The seat of filling connecting rod	1
4	AP-8BT-13-03	Sliding bearing B	1
5		O Type sealing ring	1
6	AP-8BT-02-39A	Filling connecting rod	2
7	AP-8BT-02-11	Connecting rod shaft of pouch storing up	1
8		61804 ZZE Deep groove ball bearing	2
9	AP-8BT-02-40I	Filling cam	1
10	AP-8BT-02-12	Pin roll	1
11		3203A Double-lane angular contact bearing	1
12		Joint bearing M 10 with inner teeth	1
13	AP-8BT-13-11	Dowel	1
14		LMK20UU Linear bearing	1
15	AP-8BT-13-06	Guiding column	1
16	AP-8BT-13-05	Guiding board	1
17	AP-8BT-13-04	Sliding shaft	1
18	AP-8BT-13-08	Waterproof sleeve	1
19	AP-8BT-13-10	Tightening position block	1
20	AP-8BT-13-09	Tightening shaft	1
21	AP-8BT-13-07	Filling frame	1
22	AP-8BT-17-03	Tightening shaft	1
23	AP-8BT-17-12	Filling hopper	1

XI. Optional device – Material/ Pouch shaking unit



No	Model	Name	Qty
1	AP-8BT-19-03	Connecting board	1
2	AP-8BT-16-05	Pouch shaking rod	1
3	AP-8BT-16-04	Pouching shaking board	1
4		CM2B32-50A Cylinder	1
5		FJUMT-02-16 Tandem linear bearing	1
6	AP-8BT-16-02	Guiding rod	1
7	AP-8BT-16-01	Fixed board	1

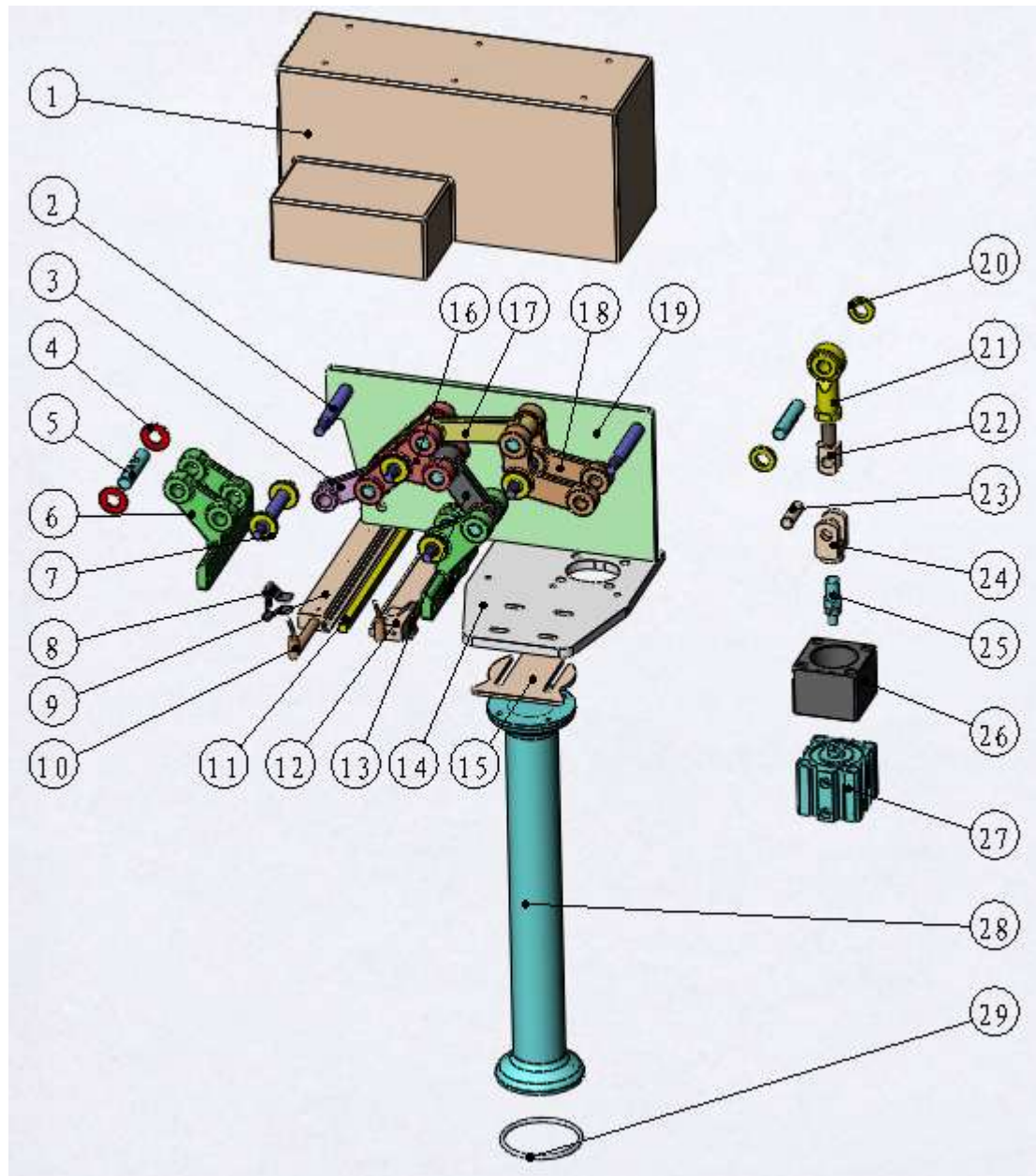
XII. Cold sealing unit



No	Model	Name	Qty
1	AP-8BT-12-02	Cold sealer	2
2		90 °Easily insert socket	2
3	AP-8BT-12-01	Mounting board	1
4		Photo electricity switch PZ-G42N	1
5	AP-8BT-12-10	Photo sensor frame	1
6	AP-8BT-12-04	Cylinder cushion board	1

The other parts are same with chapter 12 Sealing Unit

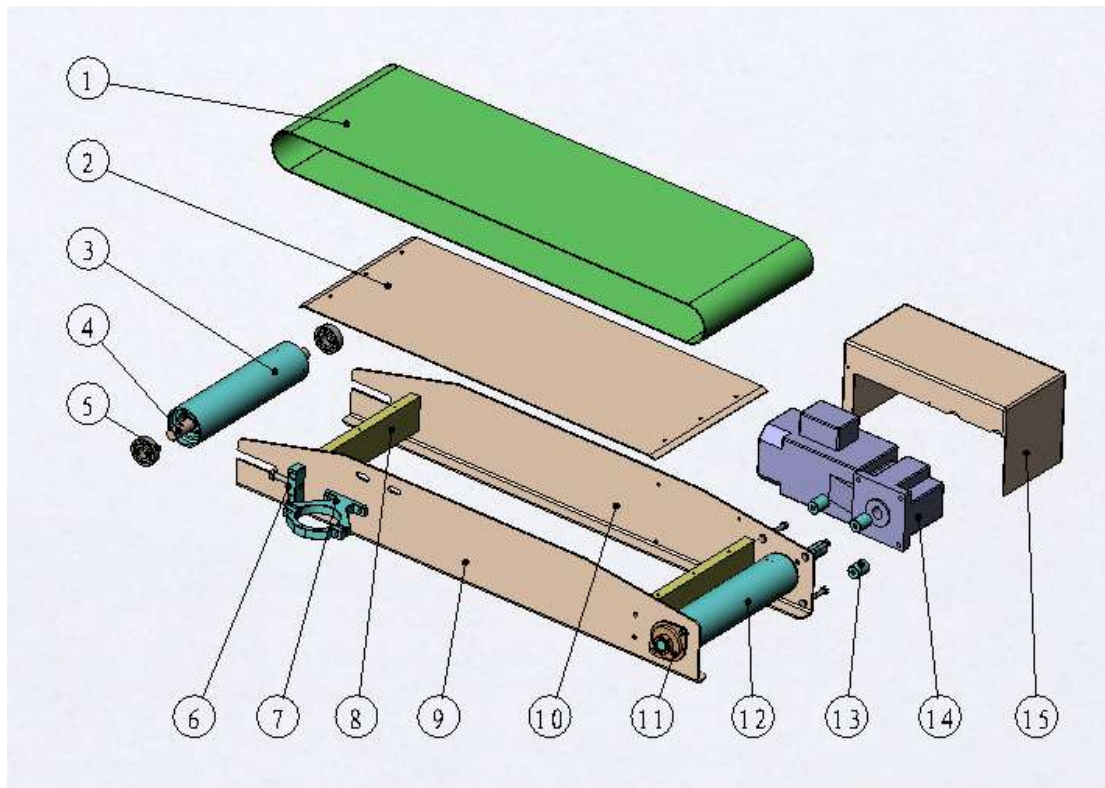
XIII. Sealing Unit



No	Model	Name	Qty
1	AP-8BT-11-9	Box cover	1
2	AP-8BT-11-11	Fixed shaft	3
3	AP-8BT-11-06	Connecting rod arm	1
4	AP-8BT-11-15	Nylon cushion B	12
5	AP-8BT-11-10	Fixed shaft	6
6	AP-8BT-11-01	Fan heater seat	2
7	AP-8BT-11-14	Nylon cushion A	8

8	AP-8BT-11-20	Binder clip	4
9	AP-8BT-11-04B	Fan heater B	1
10	AP-8BT-11-13	Heating element	2
11	AP-8BT-11-04C	Silicone cushion for sealing jaw	1
12	AP-8BT-11-04A	Fan heater A	1
13	AP-8BT-11-07	Rear connecting rod arm	1
14	AP-8BT-11-12	Mounting board	1
15	AP-8BT-11-21	Adjusting cushion	1
16	AP-8BT-11-05	Hinge	1
17	AP-8BT-11-09	Connecting rod	1
18	AP-8BT-11-08	Driving arm	1
19	AP-8BT-11-03	Right side board	2
20	AP-8BT-11-16	Nylon cushion C	2
21		Joint bearing M16 within screw thread	1
22	AP-8BT-11-05	I Joint	1
23	AP-8BT-11-06	Pin roll	1
24	AP-8BT-11-07	Y Joint	1
25	AP-8BT-11-03	Transitional joint	1
26	AP-8BT-11-04	Cylinder cushion board	1
27	CQ2A63-30DC	Thin type cylinder	1
28	AP-8BT-11-17	standing pillar	1
29		O-type sealing ring	1

XIV. Product out-feed conveyor unit



No	Model	Name	Qty
1	AP-8BT-14-10A	Conveyor belt	1
2	AP-8BT-14-09A	Belt pallet	2
3	AP-8BT-14-05A	Driven roll	1
4	AP-8BT-14-06A	Driven shaft	1
5		6203 ZZE Deep groove ball bearing	1
6	AP-8BT-14-07	Adjusting seat	1
7	AP-8BT-14-12	Draft board	1
8	AP-8BT-14-08A	Beam	2
9	AP-8BT-14-01	Left side board	1
10	AP-8BT-14-02	Right side board	1
11		SBPFL203 Stamping bearing with rhombic block	2
12	AP-8BT-14-04A	Driving roll	1
13	AP-8BT-14-03	Cushion block	4
14	90YS60GV22+90GF20RC	Motor & Speed-down box with hollow room in right angle	1
15	AP-8BT-14-11	Motor cover	1