

DH-570

(Operation instruction of winding box sealing machine)



Preface

Thank you for your support to Dyehome. We are very happy to participate in your company's automatic plastic binding on-line wrapping and laminating system.

All the automatic packaging equipment, conveying equipment and control system used in this project are designed by the Technical Department of Dahong Group Company and produced by Jiasen Factory of Dahong Group Company in strict accordance with the production procedures of quality certification (with CE certification and ISO certification).

Dahong products can make you rest assured, high quality products and thoughtful after-sales service, can stand the test of time.

All the equipment is produced by our own factory, which is the guarantee of after-sales support and quality.

Special Statement:

1. The Company reserves the right to interpret all parameters and contents set forth in the specification;
2. The Company reserves the right to make technical changes to the products without prior notice.

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1. Application and Characteristics

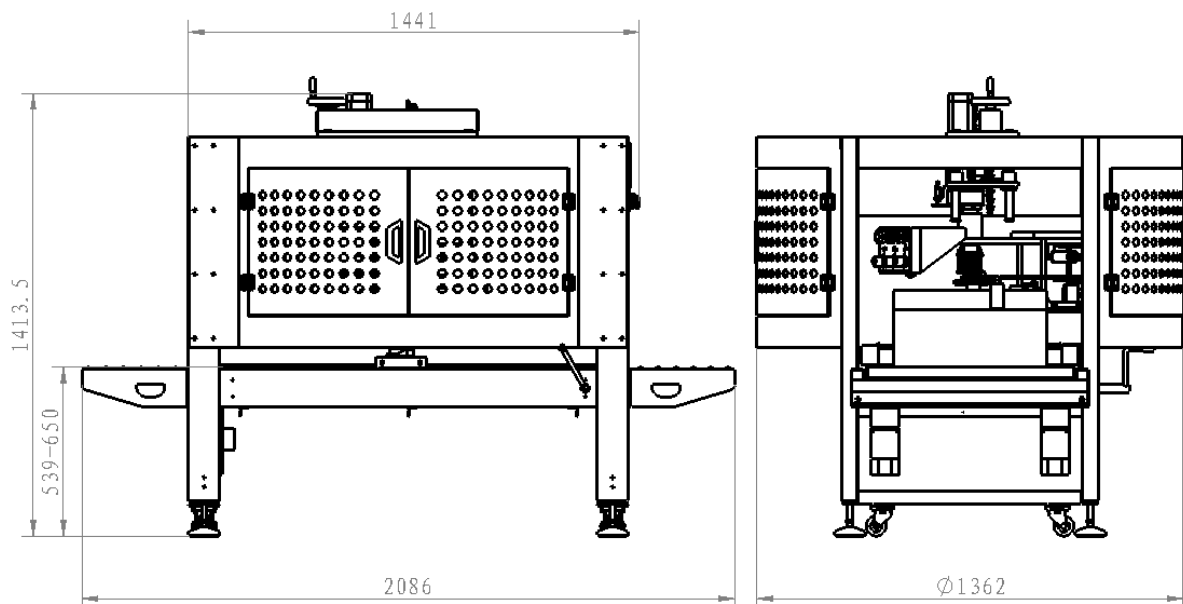
Purpose:

This equipment adopts adhesive tape sealing, which is economical, fast and easy to adjust. It can complete the top sealing action at one time. The side sealing mode of detachable conveyor belt is selected, especially suitable for foam boxes. If equipped with tape printing equipment, can improve the appearance of the product image. Widely used in seafood, fruit, express delivery and other industries.

Features:

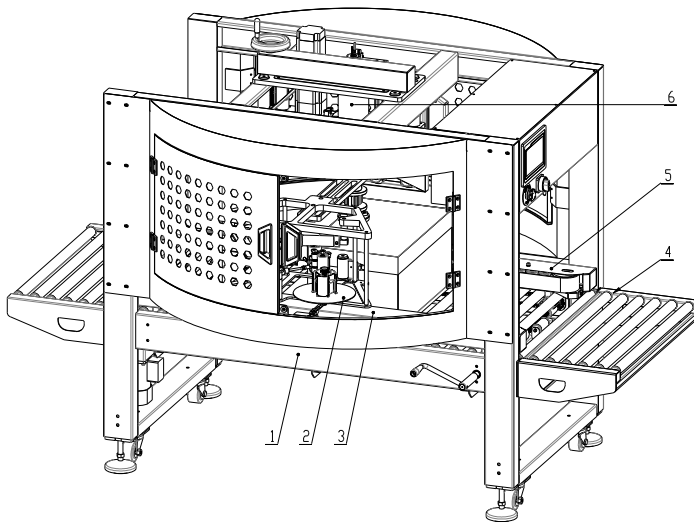
- ①With high gripping force can be separated conveyor belt, smooth transmission, adjustable;
- ②That is, tape sealing is smooth, firm, standard, beautiful, will not tear the box;
- ③Winding box sealing mode, the original need for 3 equipment to complete the action, now only one;
- ④The use of rotating sealing head mode, effectively protect the product from damage;
- ⑤Can be equipped with ink coding equipment, when the carton through, its side can be printed at the same time production date, production batch number and necessary text annotation;
- ⑥This machine can be used in single machine, also can be used with the production line.

2. Main technical parameters



Mode	DH-570
Power	AC220V/50~60Hz
Voltage	1000W
Speed	16C/min
Width	48mm 60mm
Move type	L.R. Conveyor belt drive
Max size (L×W×H)	490×310×245mm
Min size (L×W×H)	225×125×150mm
Machine size (L×W×H)	2086×1362×1420
Machine weight	

3. Machine shape structure and component name



1、 Rack

2、 Head

3、 L.conveyor

4、 Table

5、 R.conveyor

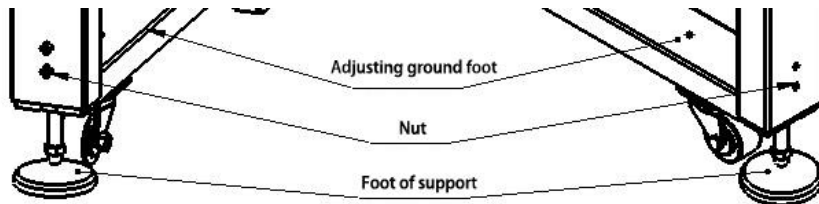
6、 Turnpar

4. Instructions for Use

4.1 Open the outer packing box, place the machine on the flat ground, check whether the moving parts of the machine are flexible, there is no jamming phenomenon, whether the fasteners are loose signs, otherwise it needs to be adjusted or corrected.

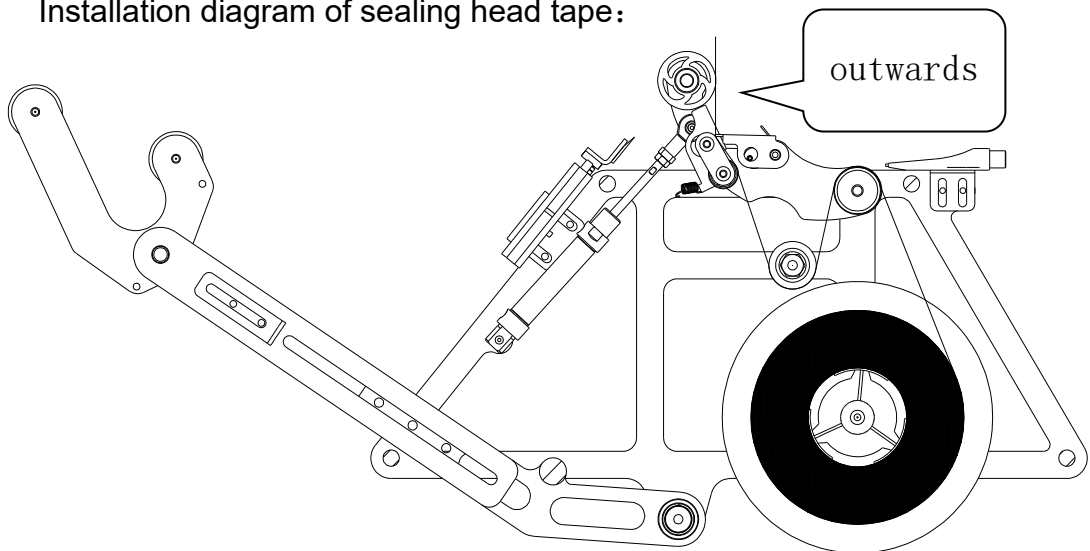
4.2 For the personal safety of the operator, the machine must be well grounded before use (**good grounding can effectively reduce electric shock injury and protect personal safety**).

4.3 As shown in the figure below, loosen the screws on both sides by turning the hex wrench counterclockwise, then press down the adjusting feet to make the machine at a comfortable operating height or consistent with the production line height, and then lock the screws. Finally, turn the supporting foot clockwise to make full contact with the ground.



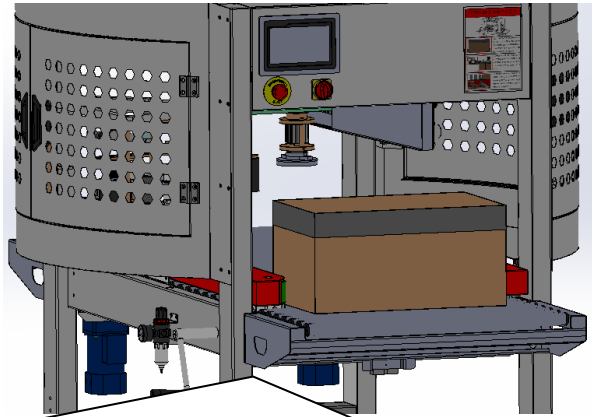
4.4 Adjustment of sealing head

Installation diagram of sealing head tape:



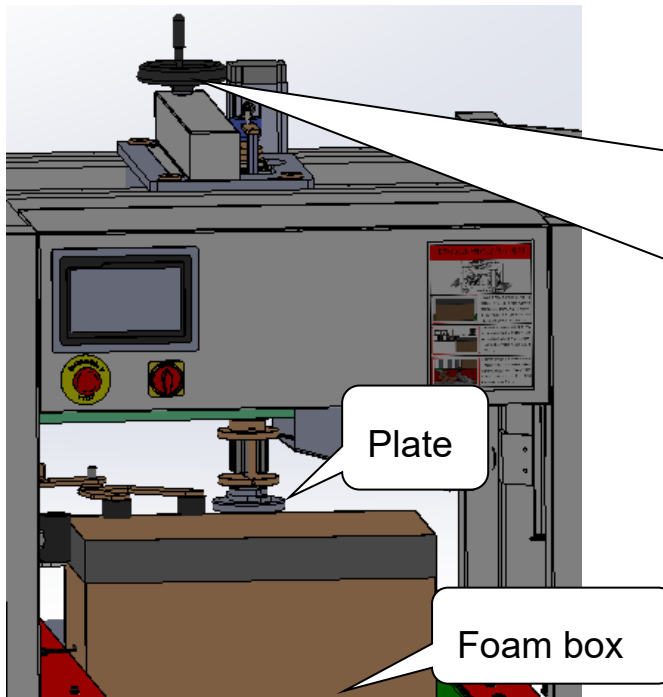
4.5 Place the carton to be sealed on the feeding platform and adjust the height and width according to the carton size

Conveyor belt width adjustment:



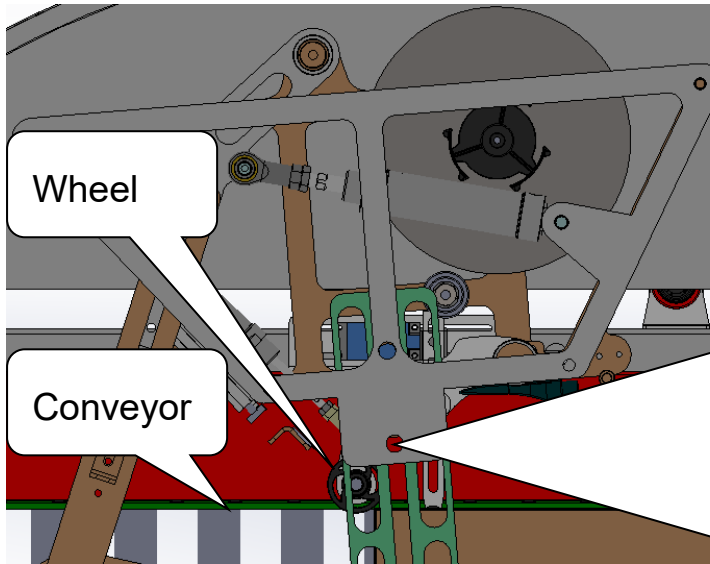
Rotate this shaft with a handle to make the conveyor belt close to the packing case
(**Note: It is necessary to master the friction between the conveyor belt and the packing box, too much friction will cause deformation of the packing box, too small carton may slip and can not be sent out**), Rotate the left and right conveyor belts clockwise to close (and vice versa).

The sealing height is adjusted :



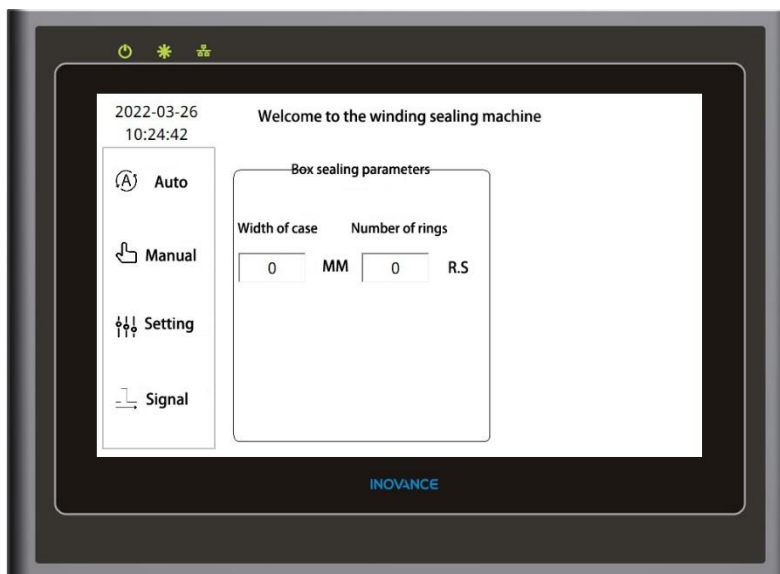
Rotate the hand wheel to adjust the height of the tape and foam box
(**Note: It is necessary to master the spacing between the press board and the carton, about 10mm**) Rotate the sealing head clockwise to rise and vice versa.

4.6 Adjustment of distance between sealing head and conveyor belt

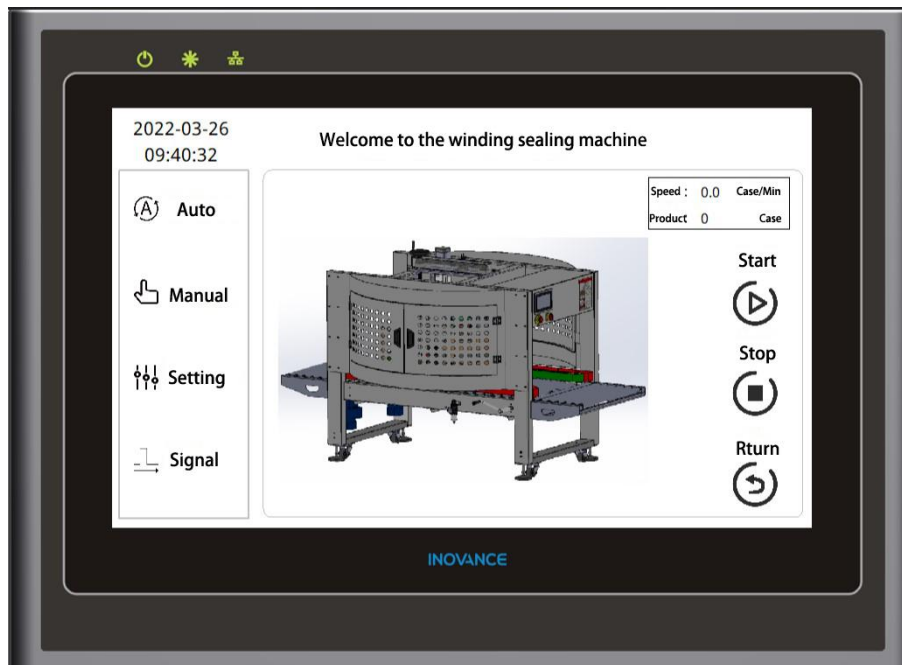


The two M12 bolts are rotated counterclockwise for two turns with a hexagon plate to loosen the sealing head, and the sealing head is moved to move the pressure belt rubber wheel to about 10mm beyond the conveying line. Then the two M12 bolts are twisted clockwise with a hexagon plate. (**Note Ensure that the device is at the origin before adjustment**)

4.7 Turn on the power switch and enter the parameter page for setting as shown in the following figure. Input box width (Width of foam box) and the number of sealing rings (How many laps is the tape sealed? Normally, it is 1 lap)

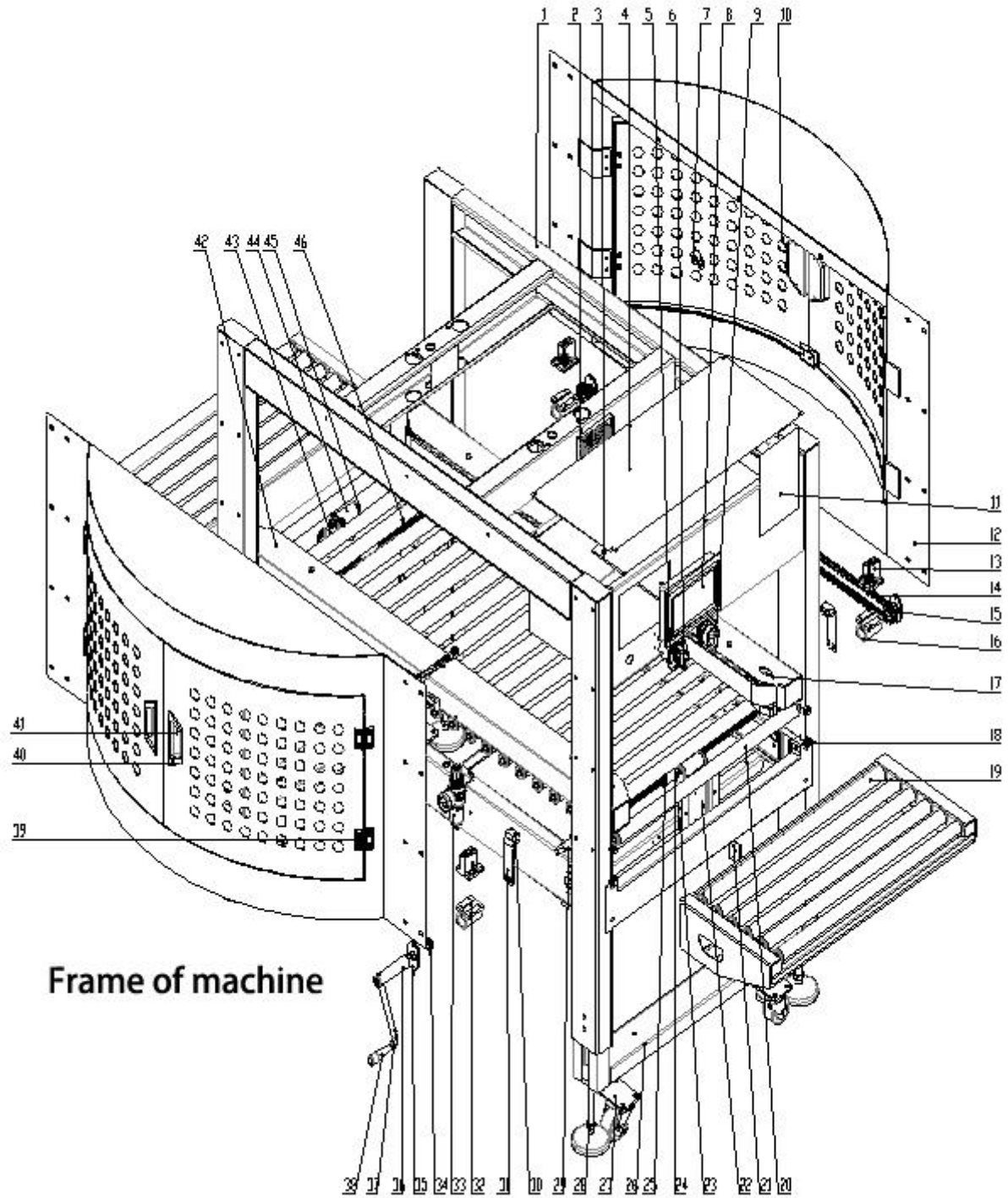


4.8 Press the start button to put the machine into working state. Push the foam box into the conveyor belt in a balanced way (note: the foam box must be pushed horizontally (i.e. the length direction of the foam box contact the conveyor belt)). At this time, the conveyor belt will automatically transmit the foam box forward and seal it. As long as the foam box is transmitted, the machine will continuously seal it and automatically send it out.

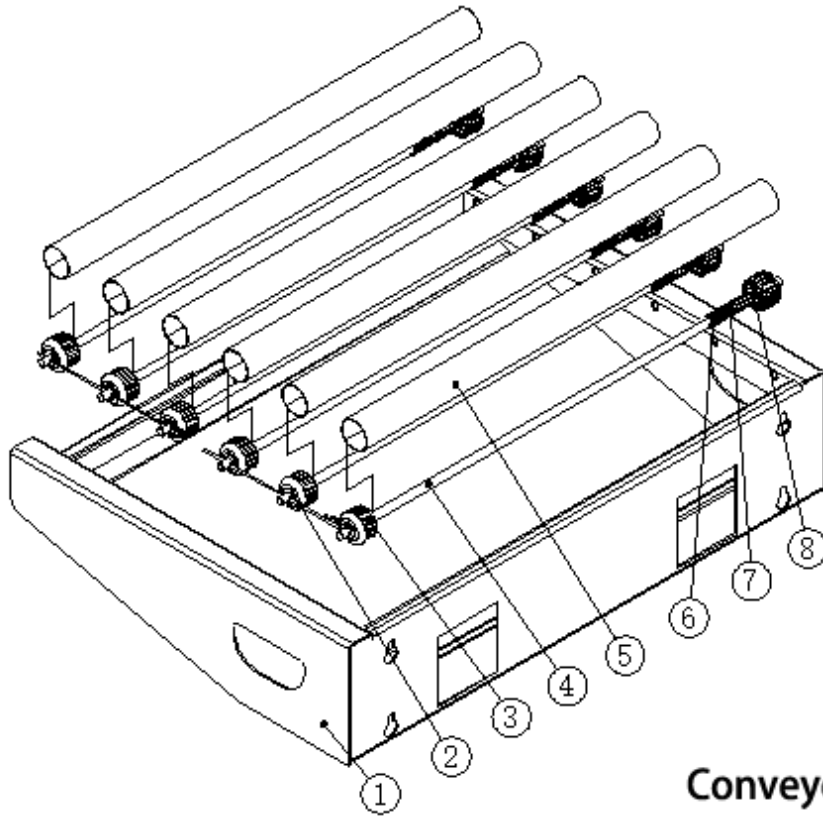


5. Electrical schematic diagram

6. Machine parts diagram

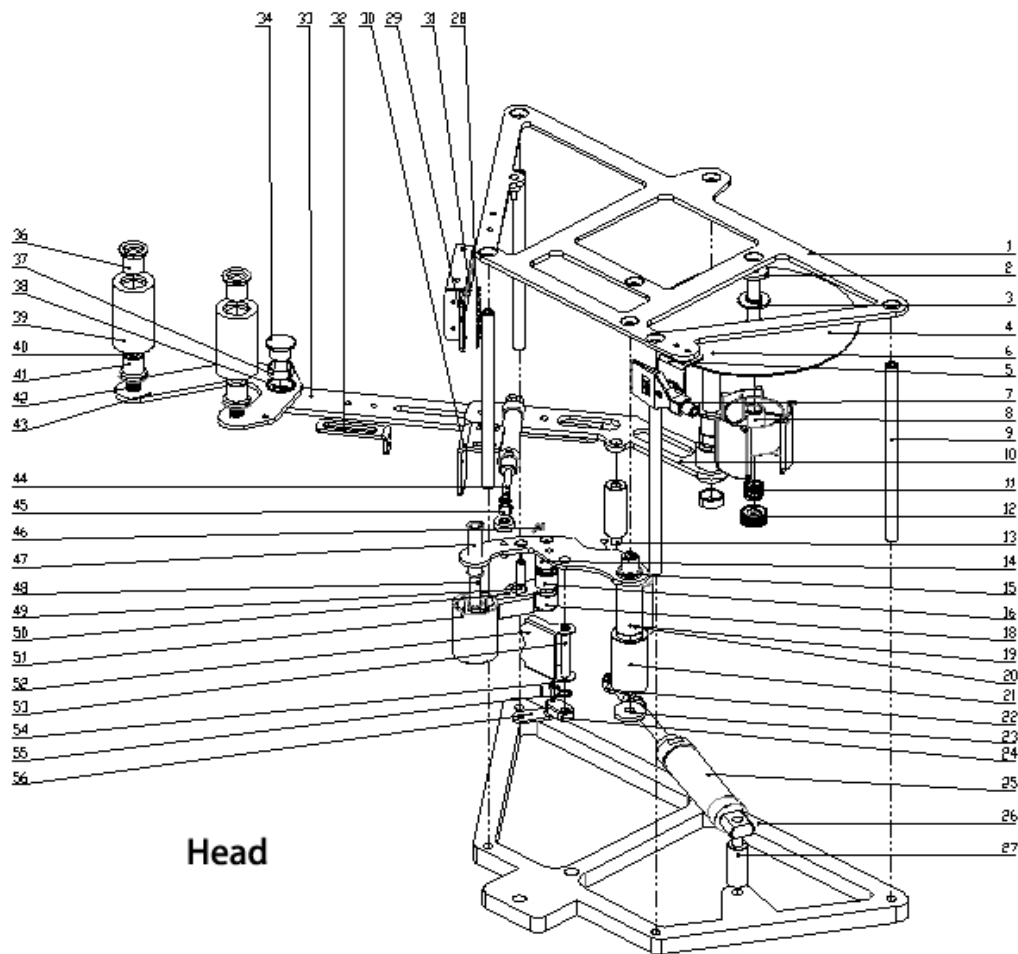


40	Hide the handle I	Hide the handle I	4	
39	Zinc alloy hinge (50×50×6)	Hinges	8	
38	SFX50500125V	Handle sleeve	1	
37	SFX50500123V	Rotating handle	1	
36	DFX5032M0011V	Handle holder	1	
35	FXZ50500110V	Bearing seat	4	
34	FXZ50500111V	Bearing housing bushing	4	
33	AFR2000	Pressure regulating filter	1	
32	FXC50500023AV	L.and R. adjustment nut (left)	2	
31	DQFXC5045X0056V	Photoelectric switching panel	2	
30	CX-411	Opposite beam photoelectric	1	
29	DFX5032M0005V	Active screw rod	1	
28	M16×120	Foot of support	4	
27	(75×45)	Castor	4	
26	DFX5032M0015V	Adjusting foot	2	
25	FXC5050X0016AV	Limit spacer sleeve	1	
24	DFX5032M0016V	Limit wheel connecting seat	1	
23	TN20X50S(0)+()	Baffle	1	
22	DFX5032M0017V	Limit cylinder seat	1	
21	FXA60500004V	Block of fixation	4	
20	DFX5032M0001	Long drum assembly	22	
19	DFX5032M0002	Discharge conveying platform	2	
18	FXJ6050A0205V	Coupling screw	8	
17	DFX5032M0004	Left conveyor belt	1	
16	FXC50500022AV	L.and R. adjustment nut (right)	2	
15	FXJ6050A0519V	Regulating sprocket	2	
14	06B (3 12Z, 248)	06B Chain	1	
13	FXC5050X0003AV	Connection base	4	
12	DFX5032M0014V	The door frame	2	
11	DFX5032M0019V	Stickers	1	
10	DFX5032M0013V	Door	4	
9	LW28GS-20/04-1	Load breaker switch	1	
8	Touch screen	Touch screen	1	
7	φ20×φ5×4	φ20 Magnet (center φ5.5 countersunk hole)	8	
6	YW1B-V4E01R	Emergency stop switch	1	
5	QL4518B0055V	Emergency stop tag	1	
4	DFX5032M0008V	Electrical box cover	1	
3	DFX5032M0010V	Electrical base plate	1	
2	120×120mmAC220	Dust proof cover	1	
1	DFX5032M0001V	Frame frame holder	1	
No.	Part drawing number	Name of Part	Q.u	Remark



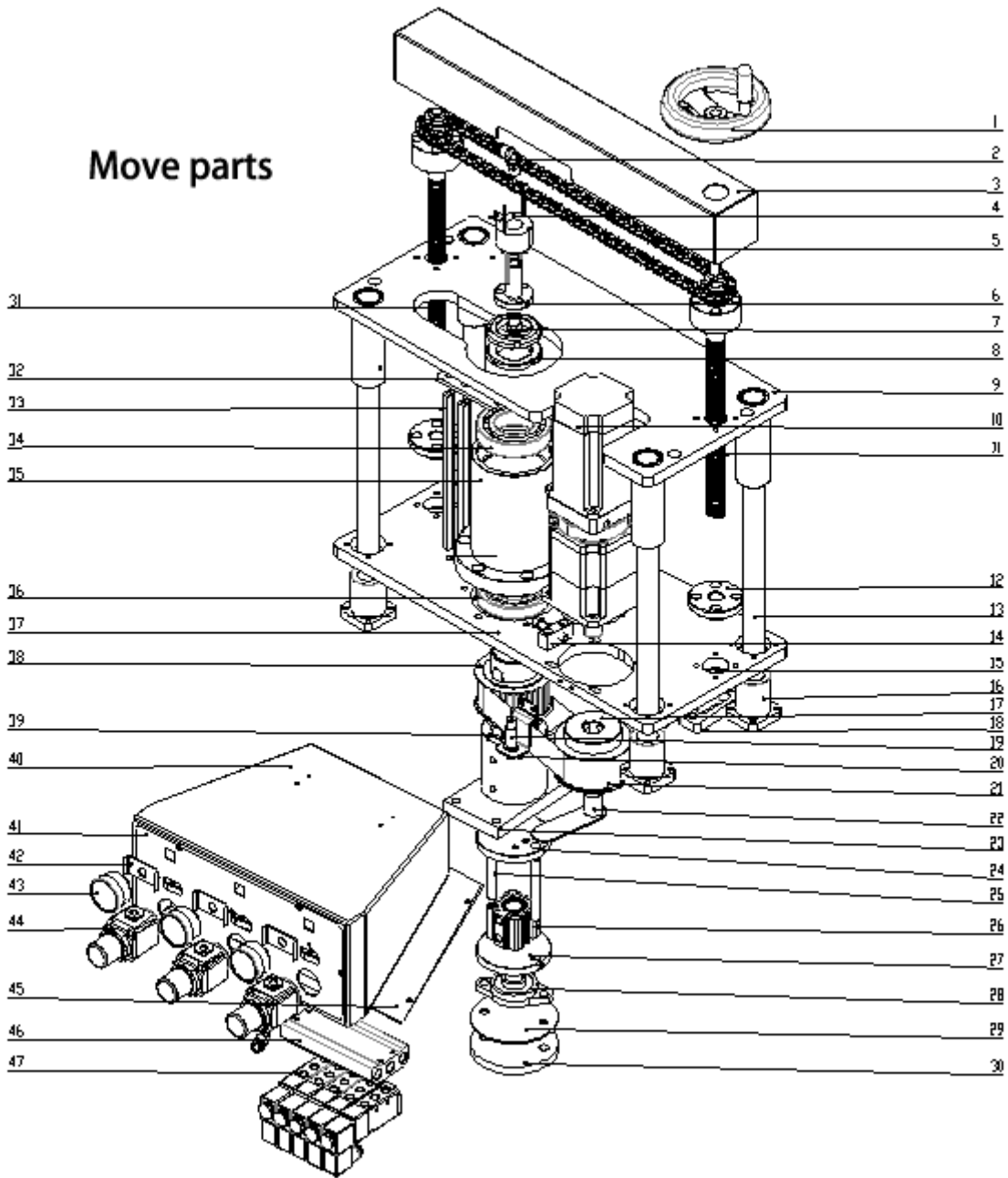
Conveyor table

8	Plain washer 8	12	GB/T 95-2002	
7	Compression spring	6		
6	Open retaining ring 6	12	GB/T 896-1986	
5	Conveyor table drum	6		
4	Conveyor table drum shaft	6		
3	Drum head	12		
2	Type B cotter pin	2		
1	Conveyer table	1		
No.	Part drawing number	Q.u	Model	Remark



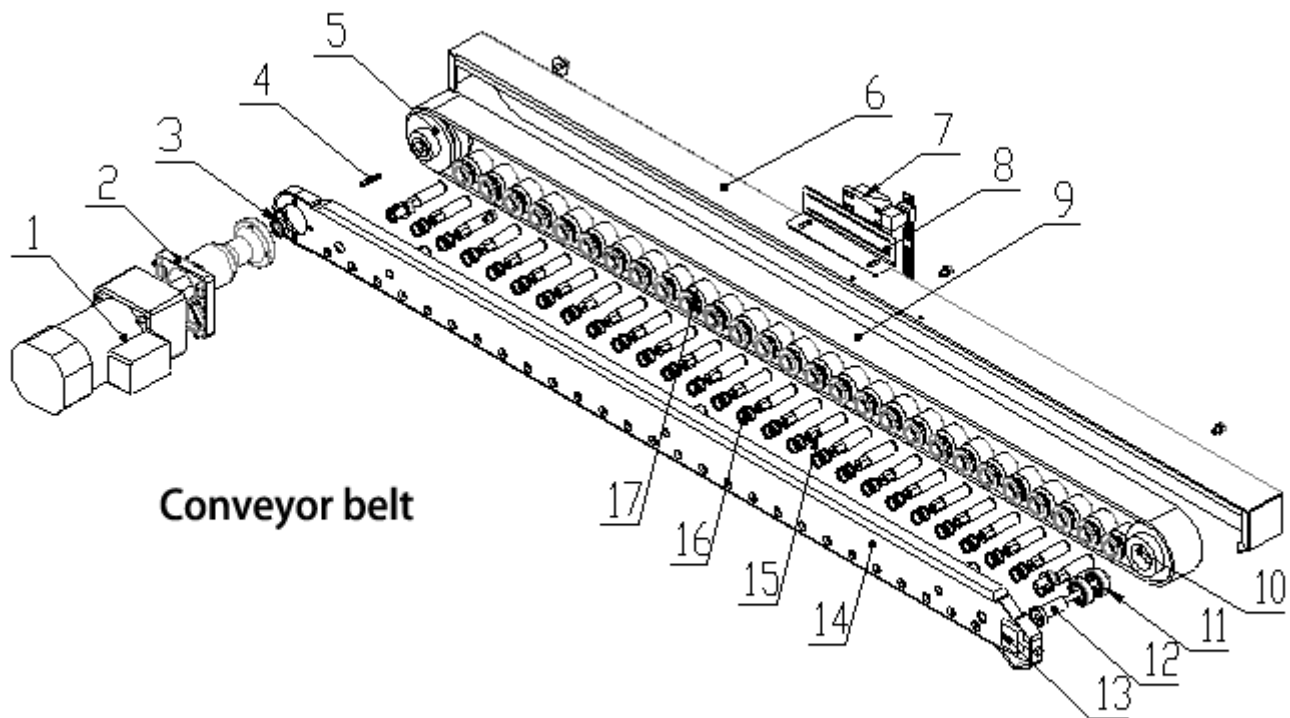
56	FXTA113065V	Connecting plate II	1	
55	FXTA113063V	Torsional spring	1	
54	GB/T 879.1-2000	Elastic cylindrical pin 4X16	1	
53	FXTA113032V	Press wheel support shaft	1	
52	FXTA113058V	Carton guide plate	1	
51	FXTA113077V	Rubber wheel outer wheel	1	
50	FXTA113062V	Carton pressing board	1	
49	FXTA113096V	The small tension spring holds the shaft	1	
48	FXTA113015V	Rubber wheel mandrel	1	
47	FXTA113076V	Rubber wheel core wheel III	1	
46	FXTA113064V	Small tension spring	1	
45	SIBJK6C	Rod-end joint bearings	1	
44	MA16x40SCA (0)+()	Cylinder	1	
43	DFX5032M0207V	Pressure belt wheel fixing plate	1	
42	FXTA113038V	Large knurled wheel press spring	2	
41	FXTA113054V	Rubber wheel core wheel II	2	
40	FXTA140015V	Rubber wheel mandrel	2	
39	FXTA140016V	Rubber wheel outer wheel	2	
38	DFX5032M0210V	Gasket	1	

37	Oil bearing bearing	Oil bearing bearing	3	
36	FXTA113047V	Rubber core wheel I	2	
34	DFX5032M0209V	Press wheel plate fixation screw	1	
33	DFX5032M0208V	Pressure wheel regulating plate	1	
32	DFX5032M0212V	Pressure wheel spring fixing plate	1	
31	TN10X40	Cylinder	1	
30	DFX5032M0217V	Cutting tape cylinder fixing seat	1	
29	DFX5032M0215V	Cutter fixing plate	1	
28	FXTA113051V	Cutting blade	1	
27	DFX5032M0219V	Pressure belt cylinder on the fixed column	1	
26	DFX5032M0214V	Sealing head fixing plate	1	
25	MA32x60SCA (0)+()	Cylinder	1	
24	FXTA113060V	Torsion spring fixing block	1	
23	DFX5032M0103V	Gasket	1	
22	(M10×1.25)	Fish eye connector 32	1	
21	DFX5032M0204V	Belt over roll	1	
20	DFX5032M0201	Transition wheel unit	1	
19	DFX5032M0202V	Rubber wheel rotation plate ii	1	
18	FXTA113092V	Press wheel support shaft	1	
16	FXTA113097V	Spacer wheel	2	
15	DFX5032M0203V	Rotary mandrel of rubber wheel connecting rod	1	
14	FXTA113067V	Spacer wheel	1	
13	DFX5032M0218V	Pressure belt cylinder under the fixed column	1	
12	FXTA113069V	Lock the knob	1	
11	FXTA113074V	Tape cartridge press spring	1	
10	DFX5032M0206V	Pressure belt wheel swing arm	1	
9	DFX5032M0213V	Box sealing head fixing rod	4	
8	FXTA113068V	Tape fixing roller	1	
7	F (F14 ABS)	Air blow nozzle	1	
6	DFX5032M0211V	Press wheel swing arm fixing rod	1	
5	DFX5032M0220V	Air knife fixing plate	1	
4	DFXA5050C0302V	Plate	1	
3	DFXA5050C0304V	Tray washer	1	
2	DFX5032M0221V	Tape cartridge mandrel	1	
1	DFX5032M0216V	Sealing head fixing plate	1	
No.	Part drawing number	Name of Part	Q.u	Remark



47	MVSC-220-4E1-DC24-L	Two position five way solenoid valve	5	
46	200M-5F	The base	1	200M-5F
45	DFX5032M0135V	Cover plate	1	
44	GAR20006LJNK	Control valve	3	
43	F-GS4004M	Air pressure gauge	3	
42	DQFXC5045X0038AV	Pressure gauge bracket	3	
41	DFX5032M0117V	Pressure gauge fixing plate	1	
40	DFX5032M0132V	Electric box	1	

39	DFX5032M0104V	Flat key	1	
38	DFX5032M0112V	Arc tooth synchronous wheel	1	
38	DFX5032M0105V	The spindle	1	
37	DFX5032M0107V	Nut fixing plate	1	
36	30209 GB 297-94	Taper bearing	1	
35	DFX5032M0122V	Spindle bearing seat	1	
34	6209 GB 276-94	Deep groove ball bearings	1	
33	DFX5032M0123V	Tracheal fixation stud	2	
32	DFX5032M0124V	High speed valve retaining rod	1	
31	DFX5032M0101	Driven by structure	1	
30	DFX5032M0134V	Rotary pressure plate sponge	1	
29	DFX5032M0133V	Rotary pressure plate	1	
28	FL004	FL004	1	
27	DFX5032M0114V	Cylinder connecting sleeve	1	
26	ACQ32x20	Cylinder	1	
25	DFX5032M0116V	Tighten the cylinder guide rod	2	
24	DFX5032M0115V	Cylinder fixing plate	1	
23	DFX5032M0108V	Rotating bottom plate	1	
22	DFX5032M0129V	Induction plate	1	
21	HTD 8M-576x40	Belt of synchronization	1	
20	DFX5032M0130V	Electric eye bracket	1	
19	NPN	Proximity switch	1	
18	DFX5032M0126V	Lock nut	1	
17	DFX5032M0120V	Arc tooth synchronous wheel	1	
16	(LMK25UU)	Flange straight line bearing	4	
15	DFX5032M0103V	gasket	6	
14	DFX5032M0131V	Anti-loose top block	1	
13	DFX5032M0125V	Lifting guide bar	4	
12	DQL6560PEG0057V	nut	2	
11	DFX5032M0102	Part of regulation	1	
10	Motor	Stepper motor + reducer	1	
9	DFX5032M0106V	Spindle fixed base plate	1	
8	M42X1.5-N	Round nut	2	
7	BPC8-02	Gas pipe joint	1	
6	DFX5032M0121V	Gas pipe coupling seat	1	
5	06B (106)	Chain (106 knots)	1	
4	(20/42 6/5A)	Conductive slip ring	1	
3	DFX5032M0012V	Chain wheel housing	1	
2	NRL KSL8-02	Joint of pipe	1	
1	12x125	Double hand wheel	1	
No.	Part drawing number	Name of Part	Q.u	Remark



17	FXC5050X0214V	Driven by drive wheel	27	
16	FXC50500204V	Compression spring	27	
15	FXC50500203V	Roller wheel shaft	27	
14	DFXC5050XI0201V	Right conveyor belt seat	1	
13	FXC5050X0211V	Passive wheel regulating block	1	
12	FXJ5050B0310V	Passive wheel mandrel	1	
10	FXC5050X0209AV	Passive wheel	1	
9	DFXC5050Z0205V	Rubber conveyor belt	1	
8	FXJ4030ZX0307AV	Switch adjusting seat II	1	
7	SD8108	Limit switch (extended)	1	
6	DFX5032M0009V	Right conveyor belt guard	1	
5	FXC5050X0210AV	Driving wheel	1	
4	GB/T 1096-2003	Normal flat bond 5 times 30	1	
3	GB 276-94	Deep groove ball bearing 6302ZZ	3	
2	FXC50500214AV	Motor fixing seat	1	
1	5IK120GU-CF+5GU-20K	120W Reduction motor	1	
No.	Part drawing number	Name of Part	Q.u	Remark

7. Machine FQA

Fault Symptoms	Cause Analysis	Method of elimination
The tape cannot be cut	The blade is not sharp enough or the blade has adhesive tape mucous membrane that makes the cutter dull	Replace or clean the blade
The tape is untidy after being cut	The M4 screw on the fixing plate of the cutter is loose. As a result, the blade is not parallel to the tape	Calibrate the cutting blade so that the blade is parallel to the tape and tighten the M4 screw
The tape doesn't quite stick to the box	<ol style="list-style-type: none"> 1. The rubber wheel is not flexible in rotation 2. The pressure of the rubber cylinder is too small 	<ol style="list-style-type: none"> 1. Add lubricant to the rubber wheel mandrel 2. Adjust the cylinder pressure
Case is stuck	<ol style="list-style-type: none"> 1. Improper adjustment of box sealing width; 2. The width and size of foam boxes are not uniform 	<ol style="list-style-type: none"> 1. Readjust the width 2. Replace the foam box
The blade scratches the foam box during sealing	The origin of the device does not move	Reset the origin

Maintenance and Maintenance

1. Keep the machine clean and dry inside and outside.
2. The blade must be kept clean and free of adhesion.
3. Lubricate each transmission part of the sealing head regularly.
4. Check all screws and nuts regularly. Tighten them in time if they are loose.

5. Requirements for foam boxes

- 1) The foam box should not be too soft.
- 2) There should be no dust and sundries on the sealing surface of the foam box.
- 3) The outer dimensions of the cartons to be sealed in the same batch must be the same (the outer dimensions of the cartons must be inconsistent with each other, which will cause the machine transmission jam or cannot be transmitted).

6. Requirements for tape

- 1) Deformed tape cannot be used.
- 2) Paper tape doesn't work.
- 3) Tape that is past its expiration date should not be used

7. Feedback of Opinions

Thank you for buying the DH-570 winding box sealing machine produced by our company. Thanks to your correct choice, you have a safe, practical and efficient packing machine. I hope you can become a long-term customer of our company.

Special note: When debugging the machine, any part of the body should not be in the position that the machine can move, so as to avoid bruises or pinprick!