

Full-Automatic
envelope and red pocket sealing machine

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1, An outline

The machine-bag is summed up by similar products on the basis of many years of development

Success in practice, further integration of domestic and international demand, with reference to the latest international technology

Based on the generation of innovation in the domestic paper, envelopes processing equipment. This machine is particularly suited in the - Conventional paper envelopes and similar production, and now compared to other models, structure more

Reasonable, compact, high efficiency, convenient adjustment, maintaining a simple, reliable and reasonable so

To be good value for money.

HD-230 automatic machine-bag main technical parameters:

Adaptation paper 70-157 g / m

The maximum speed of 15,000 / hour

1.1 kW engine power

Pump power of 2.2 kW

The weight of 1,200 kilograms machines

Minimum 70X90 Manimum 120X230 mm

2, principle and regulation

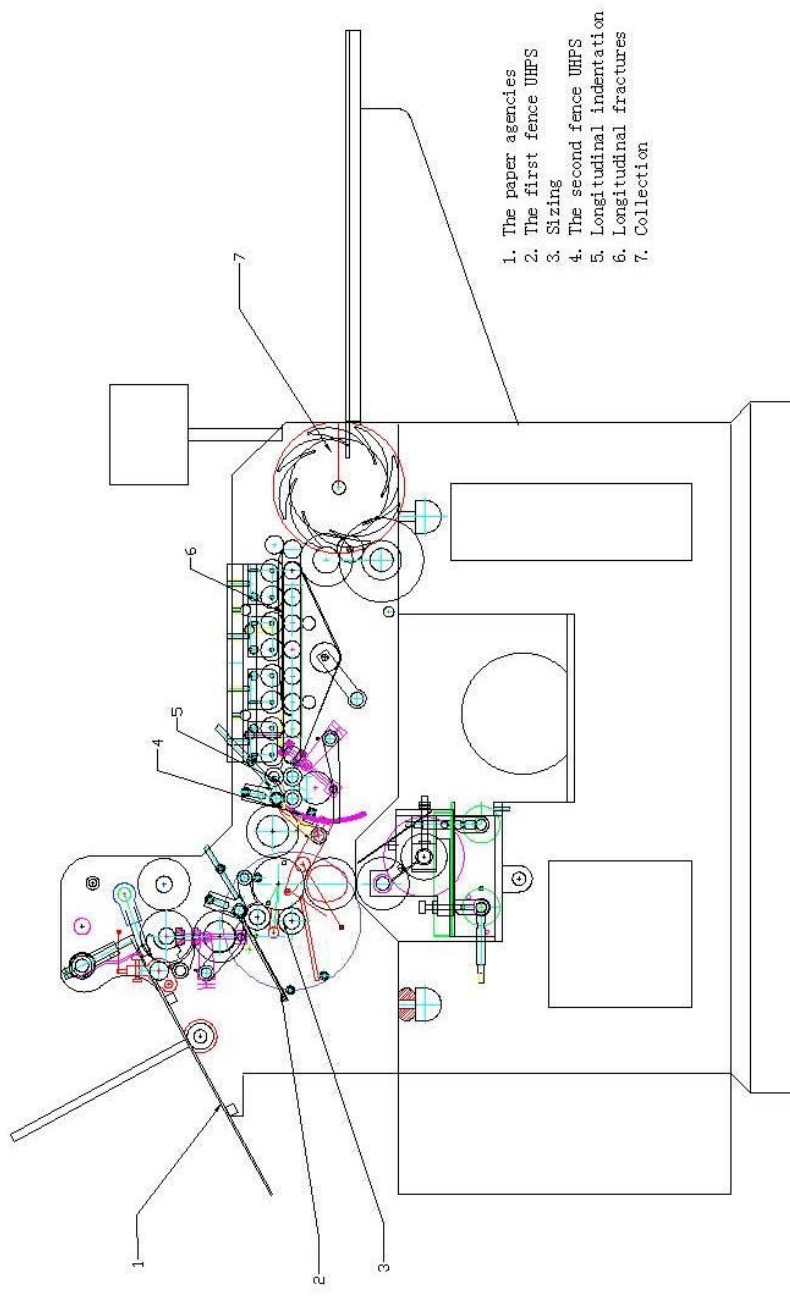
2.1 parts to the paper

2.1.1 paper prepared

Die paper to be accurate, to ensure that qualified processing paper bag.

Paper-transferring Mechanism to ensure the normal, on the stage before the paper should first Chuang-paper out of paper

Edge Crop residues and waste - burr and remove the adhesion between the paper.

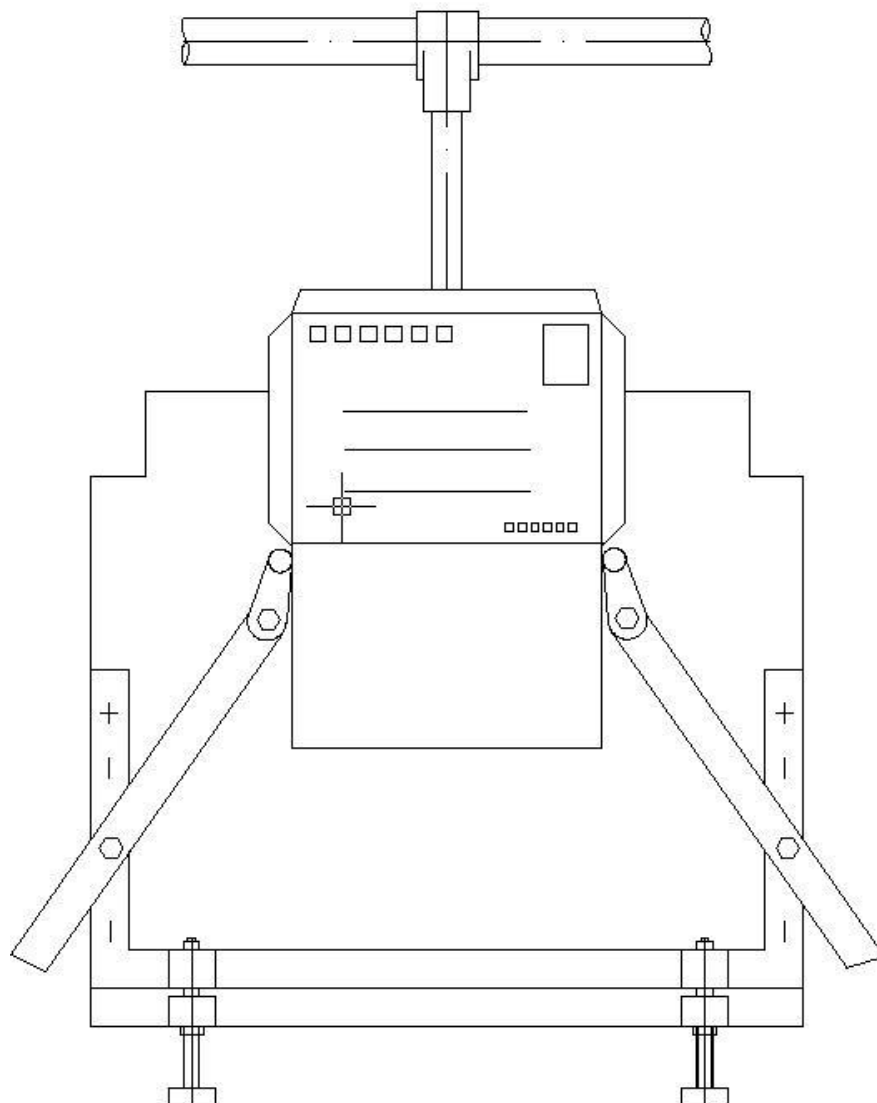


Sketch-bag machine

2.1.2 paper in the position paper on stage

As shown in figure 3, the paper Die occasional paper by the two-Support in Taiwan paper board.

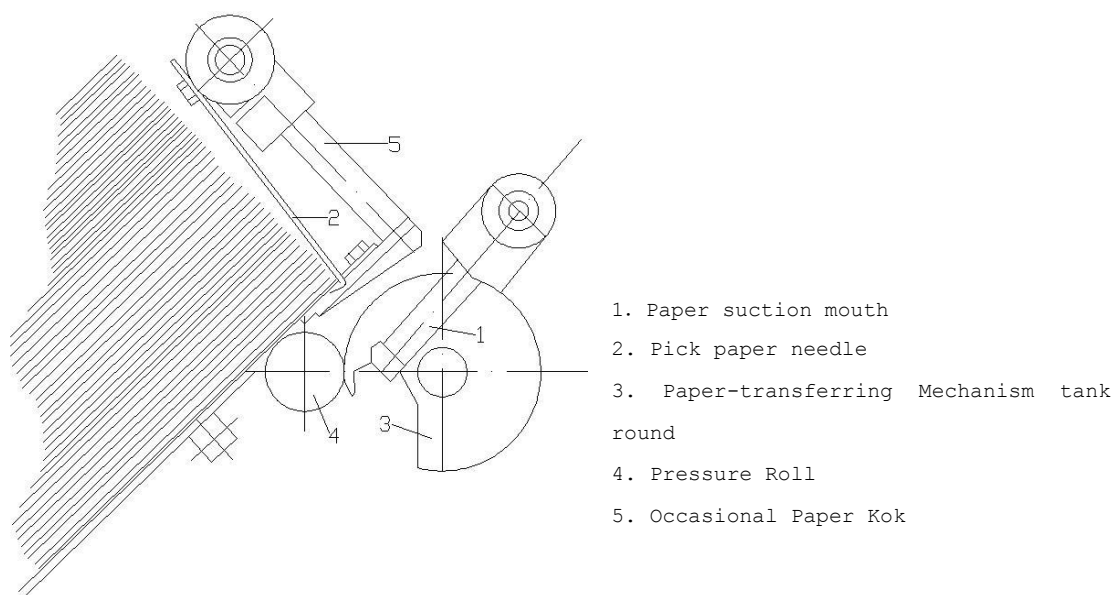
Occasional paper-paper should not squeezing reactor, the paper also allow around traverse to ensure Paper-transferring Mechanism Shun Murray and positioning accuracy. By adjusting the screw occasional paper-conditioning installation framework, adjustable paper And about the overall level. The paper should extend the forefront of the general paper about 35mm flat plate Taiwan; To Not after the end of the paper, can be bent front wheel and pressure trough Paper-transferring Mechanism stick to suppress the principle. The paper The platform, paper machine operators on side (the side-wheel drivers) should be closed polyline from the wall Tongue Plate side about 80mm.



(Figure 3) The paper in the position paper on stage

2.1.3 The paper points regulation

Figure 4 shows: the paper by the agency mouth suction paper (1), pick paper needle (1) Occasional Paper Kok (2) and the Paper-transferring Mechanism tank round, pressure roller composition. Paper suction mouth, pick paper needle and occasional paper Kok by their respective control cam control, centering swing work. Suction can be regulated, Paper mouth, pick paper needles occasional paper angle order.



(Figure 4) pm agencies sketch paper

2.1.3.1 Paper mouth suction regulation

Paper Paper on the future platform, manual jigger, the suction mouth of paper to put the highest Home, then their adjustment requests:

- (1) absorption of paper in the paper to the central mouth;
 - (2) paper suction mouth opened a sucker flat plane parallel with the paper;
 - (3) paper suction mouth close to or below USB paper, the two-contract 1.2mm, paper
- The front-cover sucker.

After the completion of the above regulation, regulation of paper

mouth suction valve core packages, it is beginning to yield
Vacuum location, then check suction mouth paper should adsorption paper.

2.1.3.2 pick paper needle regulation

When the suction mouth of paper at the highest position Jan. 1,
loosened former independent paper needle-rotation pick
Cam system, the needle placed to pick - the highest position after the
point (to pick paper or rotating cam
To hem), Cam-tight. Then pick loose paper clip needle, the needle front
of the pick-paper
With the mouth of the relative absorption of paper, paper and pick
front-needle aspiration - uttered nearly flat. Then Jigger
Inspection requirements:

(1) pick paper needle aspiration and hem will not interfere mouth -
and would not - suction mouth

Adsorption of a paper has provoked;

(2) pick paper needle can hem just after the second and subsequent
paper provoked to avoid

Paper platform paper bending ptosis caused Paper-transferring Mechanism
fault.

2.1.3.3 occasional paper angle adjustment

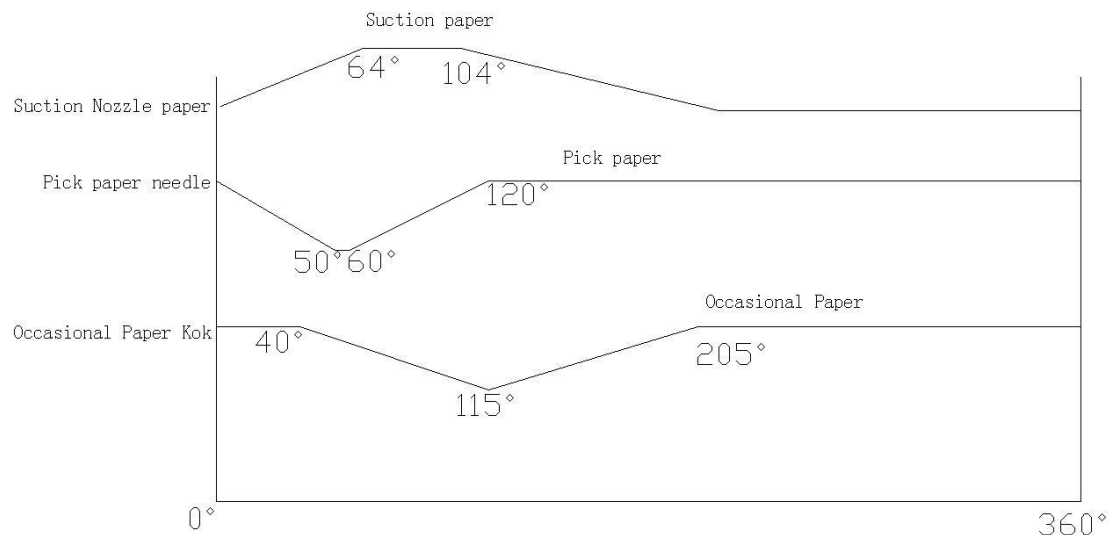
Turning to occasional paper Kok hem to the bottom position, holding
occasional loose paper bearing angle shot Lo

Nails occasional paper angle adjusting the level of requirements:

(1) about the occasional paper Kok occasional paper plane with the
paper flat coincidence, it can be used as ruler

Power tools on paper checks;

(2) occasional paper tablets pressure angle just tongue in pressure
along the pile of paper.



(Figure 5) pm working paper recycling plan

Will screw-solid tight end

Another loose paper and the occasional single rotation angle control cam, then swing angle occasional paper. May Occasional Paper placed on the left angle of paper than the suction mouth hem arrived at the paper - for a 24% fixed-D angle occasional paper Cam control.

Machines work, in a work cycle (such as the separation of a pile of paper from the paper),

The three points - all to control cam rotation 360% d, we call that a work

Circulation; The three cam control, suction mouth of paper, pick paper needles occasional paper should address angle of the swing

As shown in Figure 5 of the time.

2.1.4 components to the overall regulation of paper

The axial components to the paper by the regulatory agencies about the overall conditioning components of the axial position paper, So can change on paper and plastic folding vertical position.

2. Two components UHPS

UHPS components including two UHPS institutions, the paper can be twice UHPS processing;

During the interim, a drum-paper, paper after paper-cylinder, two perpendicular to each other along the side

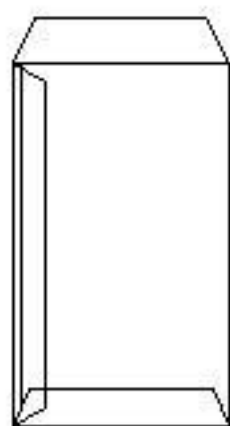
To be on the gum. For the three basic forms of a paper bag, two UHPS the principle figure

7.

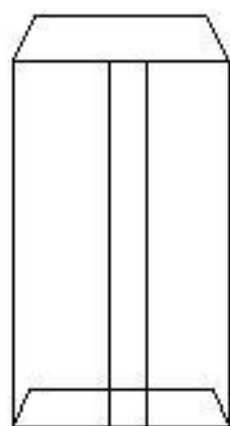
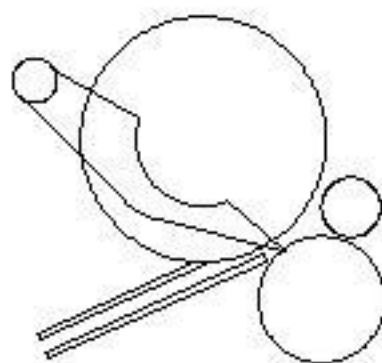
2.2.1 first UHPS

First UHPS from three different sizes of drum and the fence, positioning plates, micro-positioning plate

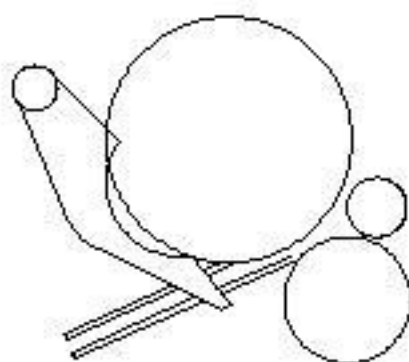
Transfer agencies. Only the first large drum on the vacuum suction hole.
When the vacuum suction to the hole and
Paper components trough round encounter when inspiratory. Adsorption
forefront of paper and paper accurate primer
The first fence. Touch the top position paper plate group, then the
forefront of the movement by not pressure
Roll-forward through the second, three roller, which completed the first
UHPS. The fence will
Adjustable-board position group, according to the form of product
requirements and specifications, can control the first UHPS
Size. Positioning plate group stands in the coarse-state; Regulatory
bodies can be placed under loose
The set screws tight, direct rotational positioning plate Group. Rough
screw should be re-finished
Fastening. Fine-tuning the positioning plate group in startup mode,
rotating through a fine-tuning screw.



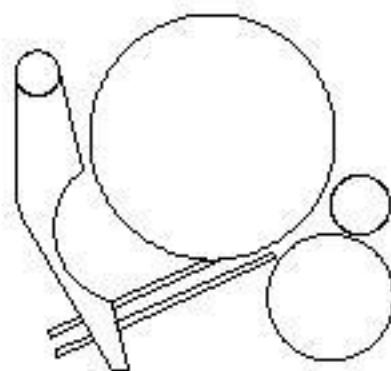
(a)



(b)



(c)



2.2.2-paper roller

First UHPS paper left after the group arrived through derivative cardboard-paper roller. -

Paper is by vacuum suction drum macroporous paper. In the roller-paper with the following Shi

Glue to the planes to the shelves with axial (Joints) and peripheral (or seal bag at the end of the tongue) of brushing

. Two seals should adjust the location, it passed without paper and paper-drum in a trench on the
Relative to avoid plastic drum rub, smear paper, affecting the normal Paper-transferring Mechanism.

2.2.3 second UHPS

After the glue on the paper before to enter the second fence, its work and the first fence

Similar. To avoid glue on the edge and the first part of UHPS with a timely revealed abnormal stack or crowded

Wrinkles are equipped with a compression cardboard. Fold in the first adopted under the pressure of cardboard, glue on the side that correct pressure

Above the fold in the first. Through weeks to conditioning control cam pressure can be controlled, cardboard Pressure Inter.

When the bag for 7 (C) form, the second fence positioning plate to promote the group into the paper

The second fence into the second, three roller. Therefore, in accordance with the specifications bag regulation
Positioning plate cam control group.

The second fence positioning plate group rough location of fine-tuning to reconcile with the same first fence.

Suction Nozzle 2.2.4 drum grooves and the regulation

Chuan paper drum and the drum of the second fence Suction Nozzle paper specifications required by the regulator Zhou

To ensure accurate Suction Nozzle adsorption paper frontier.

- Conditioned, first-jigger the paper drum Suction Nozzle at the Paper and Post-Roll Heart Link

Online, and through a side gate after the roll; Loose-paper on the roller drive gear (continued

When Chuan paper drum set and not two gate roller rotation); Then-loser into a normal car

Paper, paper-paper front-end live coverage on the drum Suction Nozzle hole, it will drive Gear Solid tight,

The paper did not cover living and the suction hole sealed with screw.

Paper-gate drum and two large drum grooves on the axial response to the plastic bag in the raphe

Location. Paper can be loosened roller-screw fixation, will regulate the cylinder pin-pin plug hole, Zhou
Adjusting to the drum. The use of chain gear, more than two-conditioned on the suction roller
Location trench mouth and no dislocation.

Two rollers on the operating side by side with occasional Tray, Tray in the occasional lateral care
Living at the end of the tongue 3cm to ensure reliable end of the plastic bag. Paper bag at the end of the tongue (circumferential), the plastic disc

The position paper should position the axial and circumferential adjustments. Take care not to glue -
To drum or the occasional placemat.

2.3 on the plastic parts

Overall, plastic components on both sides of the rack-bar supports, can pull into, pulled out when
Ease of cleaning or conditioning. The plastic components into working position, pin inserted into the guide bar
Pin hole location. Regulation 4 at the plate supporting bolts, adjustable be absorbed Cots and plastic

The pressure of the control-volume plastic. Cots two absorbed the pressure roll through flexible position change
The regulation, regulation will change the pressure-volume plastic.

2.4 indentation, longitudinal folding components

After the second fence, the paper roll through a dimple, ends at the end of the tongue to fold
The location of the indentation to facilitate longitudinal fracture.

Components used longitudinal fracture - type transmission belt and paper delivery round pressure, the pressure from pressure-round Festival Nut conditioning. All cardboard pressure regulator about the location, Get correct longitudinal fracture
The size and location of a paper bag.

2.5 parts collection

Face Chuck components will be used to collect paper bag vertical yards on the collection plate stage, along weeks to adjust
Face Chuck arc slot position to guarantee the normal paper bag can enter.

Counter to receive signals of photoelectric, finished with functional groups can preset packet
Number. Arrived at the preset number, counter control solenoid action, a paper launched an
Paragraph distance, as identification.

Three electrical control theory

Electrical control principle in figure 7

Four maintenance

Each stands 4.1, should be cleaning residual glue on the plastic parts.

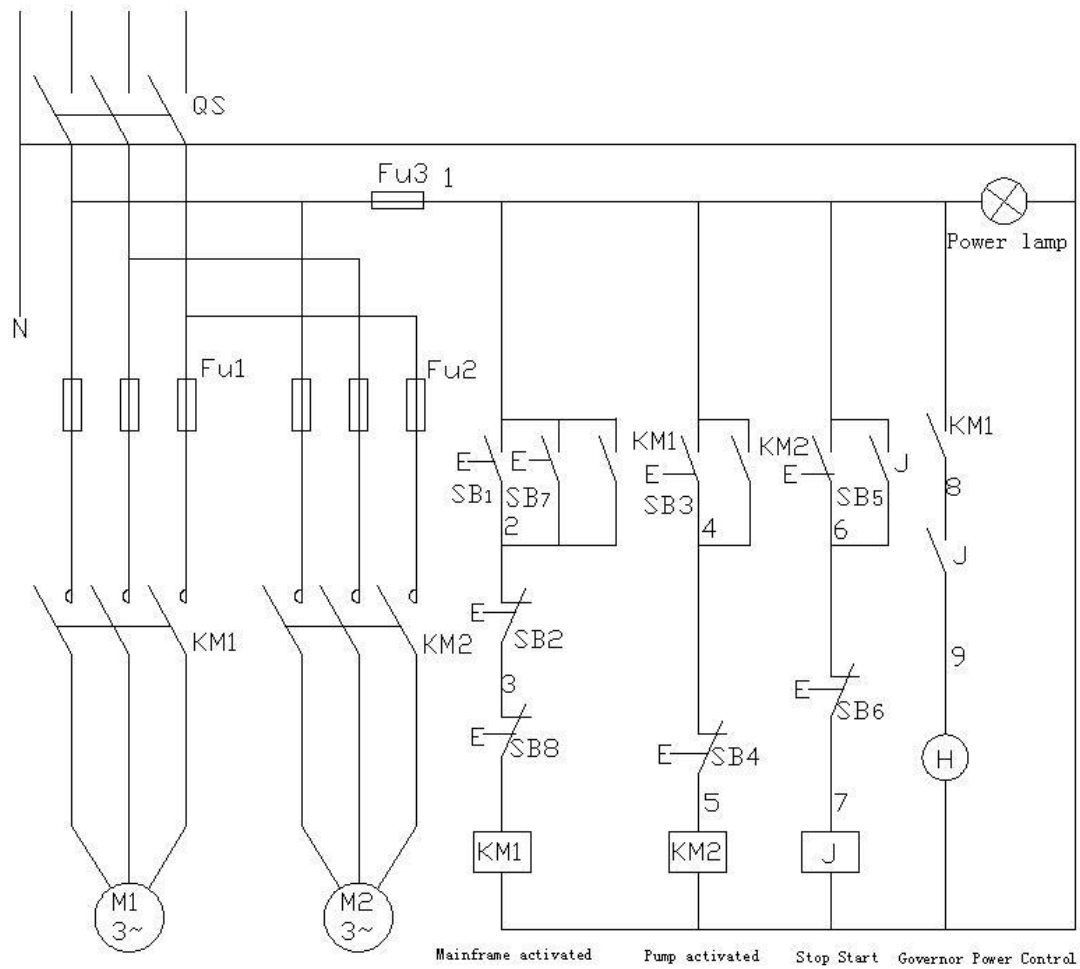
4.2 drive gear should increase every three days on the 30th a mechanical oil.

4.3 should drive chain on the 30th week and a mechanical oil.

4.4 If machinery longer stop using anti-rust protection should be made.

4.5 air routes may really work for a long time inhaling too much dust, caused pipe plug,

Monthly inspections should remove dust.



Electrical schematics

Symbols	Name	Role
QS	Switches	The power control
KM1 KM2	AC contactor	Pump motor control and the start and stop
Fu1 Fu2 Fu3	Breaker	Short circuit protection
SB1,2,3,4,5,6,7,8	Button	Starts and stops

One SB7, SB8 in the other side of the control panel.