

Attention !!

1. In case you trouble shoot during run, please pay your attention to moving part during machine run,

2. B. Longsealer

3. Phenomenon	4. countermeasure
6. <input type="checkbox"/> In case both ends of fin are not aligned on the same line for fin seal.	5. In case, operator end fin is bigger than machine end fin, the cone on film holder is turned to clockwise.
	7. In case, operator end fin is smaller than machine end fin, the cone on film holder is turned to anti-clockwise.
12. <input type="checkbox"/> In case melt cut seal, scrap film is not cut smoothly.	8. Check if both longseal fin come out enough or not. If not enough, please refer to the previous shown item "Lonesealer fin does not come out from former bottom".
	9. Check if both longseal fin come out evenly or not. If uneven, please refer to the previous shown item "Lonesealer fins ends are aligned on the same line".
	10. Check if both film fins are machine end (hotter end) of guide plate or not. if so, operator end fin must come to operator end of guide plate.
	13. Check if scrap film fin round the machine end sealer disc(hotter end) or not, if so, resume to original position of the scrap film.
18. Not well being sealed when static long seal.	14. Check Power ON or OFF for Longsealer.
	15. Set higher temperature for Longsealer.
	16. Rise temperature of Longsealer
	17. Check if the top shape of anode still sharp or not. If it got dull, please scrub to be sharp.
	19. Check if 2 longseal fins are between forming box plate (polar) and Anode. Does not one fin come into forming box?
22. Not well being sealed when static long seal.	20. Check if the film has wrinkle or not as one side film go on the forming box bottom plate. go on the forming box bottom plate.
	21. At the polar of forming box, checking if two film fins are well contact or not. If only one side fin gets dull, it will be wrinkle.
	23. Check if the top point of Anode bar if clear or dirty, if it gets dirty, please clean up with close.
30. In case emergency stop (Instant stop) please restart after checking left side items.	24. Check indicated voltage if it is sable or not.
	25. Checking if the voltage is stable or not.
31. <input type="checkbox"/> When air cylinder does not activate.	26. Checking the film width, if the film roll was changed or not.
	27. <input type="checkbox"/> For the Printer and Perforator.
33. When make unusual noise.	28. When machine emergency stops, please check if printing head and cutter is on the film or not.
	29. <input type="checkbox"/> Look for the package that has perforation area or printed, not and reject poor package.
35. When make unusual vibration	32. Check compressed air supply with 0.5MPa.
	34. Checking all drive rollers and bearings.
38. When wrapping machine does not start.	34. <input type="checkbox"/> In case not recovering, please contact us.
	36. Check all drive rollers and bearings.
	37. <input type="checkbox"/> In case not recovering, please contact us.
	39. Check if all sensors detects error or not.
	40. <input type="checkbox"/> In case not recovering, please contact us.

41. Phenomenon	42. countermeasure
	43. Melt cut longsealer
44. Film is melted at longsealer	45. Down set temperature of the Longsealer.
46. Film is burned under the forming box bottom.	47. Down set temperature of the Longsealer.
48. Move adjust roller a little to infeed conveyor end so that suitable film tension can be made by contacting fully with forming not side and ceiling plate.	49. <input type="checkbox"/> Longsealer is equipped with a pair of pinch rollers, angle the pinch roller a little to lower to pull the film fins downward. If the angle too much, product may clog at forming box entrance.
	50. Longseal fins do not come out under forming box.
	51. The level of upper tubing conveyor up a little (reduce pressure to the product)
53. Move adjust roller a little to Endsealer end so that suitable film tension can be made by contacting fully with forming not side and ceiling plate.	52. Check if film fins and forming box bottom plate are parallel or not.
	54. <input type="checkbox"/> Longsealer is equipped with a pair of pinch rollers, angle the pinch roller parallel to forming box bottom plate.
	55. The level of upper tubing conveyor down a little (increase pressure to the product).
	56. Check if film fins and forming box bottom plate are parallel or not.
	57. Excessive Longseal fins come out under forming box.