



OPERATION INSTRUCTION OF FOLDER GLUER MACHINE

CONTENTS

Operation instruction of folder gluer machine

- 01 Notes
- 02 Safety rules
- 03 Machine installation
- 04 Performance and parameters of the machine
- 05 Machine operating instructions
- 06 Lubrication and Maintenance
- 07 Electrical operation instructions

01

NOTES

Before using the machine, you must read and understand the operating rules and safety rules of the machine in detail. This will enable you to have a comprehensive understanding of the structure and performance of the machine, so as to operate the machine more quickly and safely. Please follow the operating rules of this instruction correctly, install, debug, and use the machine. When there is a problem, please contact us in time. When connecting with us, you should pay attention to accurately provide the serial number of the machine so that we can know which machine you bought. Strictly observe the following regulations when using this machine, otherwise it will cause injury to people and machines.



Cautions! ! !

1. According to specifications and requirements, confirm that the equipment has a good power supply and is properly grounded.
2. The power supply must be cut off for any inspection and repair.
3. The equipment parts are not allowed to move in the locked state.
4. Before starting the equipment, make sure that all chains and belts are free of foreign objects and function normally before operation.
5. To reduce the damage of transmission, it is recommended to open the blank machine as little as possible.
6. Regularly check that the transmission parts and fasteners are normal, and adjust and tighten them in time.
7. Regularly add oil to each transmission part to ensure that the equipment has good transmission performance.
8. It is strictly forbidden to clean the transmission belt with solvents to avoid corrosion. When necessary, you can use some low-concentration detergent to wipe.
9. After the work is completed, the glue box must be cleaned to prevent dry glue, so as not to affect the normal work next time.
10. Non-professionals should not open the distribution box and change the circuit without authorization, lest the components will be damaged by electric shock.
11. Due to the structural limitations of the machine, there is no protective device. Please pay special attention to your hands, sleeves, hair, etc. during operation, and tie one side with a belt to prevent damage to your body.
12. If you find any problems during use, please contact our factory. Our technicians will provide you with fast and satisfactory service.
13. This manual is for reference only. For details, please listen carefully to the explanation of

02

SAFETY RULES

1. Workplace

- (1) Keep the workplace clean and bright. Chaotic and dark place can cause accidents.
- (2) Let the children and bystanders leave then operate the machine.

2. Electrical safety

- (1) The power cord must be connected to a leakage protector, and the main motor must be grounded. Never modify the circuit in any way. It may be unsuitable for this machine to cause accidents after random modification.
- (2) Do not abuse the power cord. A power cord of sufficient square size must be used. A power cord that is too thin may cause a burn and cause a fire.

3. Personal safety

- (1) Stay alert, pay attention to what you are doing and stay awake when operating machines. Do not operate the machine under fatigue, medication, alcohol, or treatment response. Distraction during operation of the machine can cause serious personal injury.
- (2) Use safety devices. Always wear insulated rubber shoes. Safety devices, such as safety helmets under appropriate conditions, hearing protection, etc. The device can reduce personal injury.
- (3) Avoid sudden start. Make sure that the motor is in a stopped state. Sudden start may cause injury to people who are adjusting the machine.
- (4) Before starting the machine, press the bell switch to prompt, and then turn it on. And remove the extra tools. Prevent people from operating the machine and the excessive tools left on the machine from falling and causing personal injury.
- (5) Dress appropriately. Do not wear loose fittings or accessories. Keep your hair, clothes, and sleeves away from moving parts. Loose clothes, accessories or long hair may be caught in moving parts.

03

MACHINE INSTALLATION

1. Sufficient space is required for installation. The production is easy to operate, the ground is flat, the two sides should be more than 1 meter away from the wall, and the equipment should be adjusted horizontally.
2. The equipment uses 380 V AC power supply, The power distribution box is directly connected to the terminal. Refer to the circuit schematic for details.
3. Please ground the machine well, the grounding wire is copper wire, not less than 6 square meters, and connect it to the fixed bolt of the frequency conversion motor.

CORRECTION AND OUTPUT UNIT



After the folding part, the bridge bracket is connected with the correction part with a 2-M8x20 hexagonal screw to fix the correction part first. After the correction part is leveled, install the folding part.

FOLDING UNIT

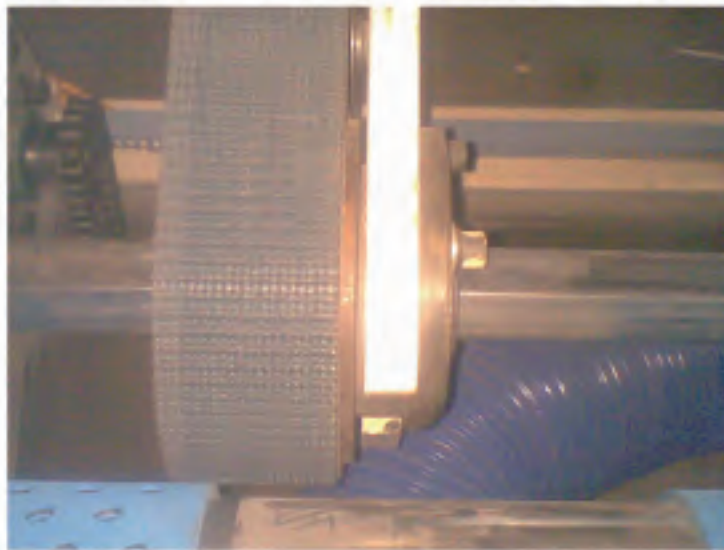


The two ends here are aligned with the frame of the calibration part, and the size of both ends can be measured with a tape measure.

GLUING UNIT



The two ends of the folding part here are connected with the paper feeding part with 2-M10X30 inner hexagonal bolts.



The middle large plate of the folding part is connected with 3-M10x35 hexagonal bolts.



M16 outer bolts are used to adjust the level of the paper feeding section.



Brand new high-speed box folder gluer, the highest speed is 120 m/min

1. Adopt belt vacuum adsorption type paper feeding.
2. Automatic glue supply, the circulating glue, saving time and effort, stainless steel coated wheels, corrosion-resistant and wear-resistant. Glue evenly to save glue.
3. The folding part is equipped with multiple adjustable crimping wheels to make the carton folding more smoothly and the appearance more beautiful.
4. The counting output part is fully digital input, safe and stable, accurate and error-free.
5. The whole machine is controlled by remote control, which is convenient and quick.

A. Paper feeding and gluing unit

1. Adopting belt leading edge suction and paper feeding technology, accurate and reliable
2. Using high-grade electromagnetic clutch, the paper feeding part can be controlled separately, and the operation is convenient and reliable
3. Linked with the folding part, using frequency conversion technology, energy saving and environmental protection
4. The glue box is adjusted by electric deceleration motor, and there is a self-adjusting glue scraping device

B. Folding unit

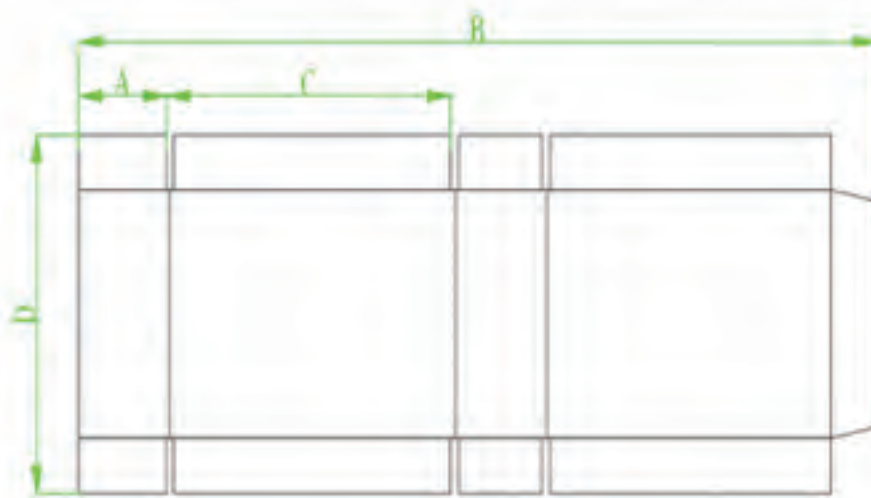
1. The main motor adopts frequency conversion speed regulation, no noise, flexible and stable speed regulation
2. The conveying part adopts a widened climbing belt and the pulley has the characteristics of anti-skid loss to ensure the accuracy of the cardboard conveying.
3. Equipped with pre-compression and indentation correction device

C. Correction and output unit

1. Using PLC touch screen control, quick and reliable response, data can be input without stopping the machine
2. With the function of correcting deviation, the deviation can be adjusted
3. The output adopts pneumatic mode, the action is reliable, fast and accurate

D. Parameter

Model	2200	2400	2600	2800	3000
A.	80-880	80-880	80-880	80-880	80-880
B.	700-2020	700-2220	700-2420	700-2620	700-2820
C.	160-840	160-840	160-840	160-840	160-840
D.	300-1050	300-1150	300-1250	300-1250	300-1250 *
Installation area	3400x1500	3600x1510	3800x1520	4000x1600	4200x1600
	0	0	0	0	0
Motor power	10KW	10KW	12 KW	12 KW	12 KW



05

OPERATING INSTRUCTIONS

First turn on the emergency stop switch on the operation panel. After making sure that the touch screen is operating normally, press the start switch, the green light is on, then press the host acceleration key to confirm that the main motor is running normally, and at the same time turn on the count switch to confirm normal operation, and then turn on the fan switch to confirm Normal operation. Turn on the paper feed switch again to confirm normal operation. After confirming that the whole machine is running well, close the above and shut off, open the air valve, and operate in the following order:





A. Cardboard positioning

1. Adjust the bracket according to the width of the cardboard to minimize the angle between the belt and the cardboard
2. Align the cardboard with the center and place it on the paper feeding belt, and adjust the left and right limit plates to the proper position
3. Use the left and right movement switches to move the left and right creasing wheels to the center of the cardboard creasing line
4. Adjust the gap between the front baffle and the cardboard, the gap is generally twice the thickness of the cardboard
5. Adjust the gap between the front and rear pressing wheels of the folding part according to the thickness of the cardboard. The gap between the front wheel is generally reduced by the thickness of the cardboard, and the gap between the rear wheels is generally twice the thickness of the cardboard.

B. Coating wheel positioning

1. Adjust the gap between the small pressure roller on the glue box and the glue wheel to the thickness of the cardboard
2. Start the machine to run slowly, send the cardboard to the gluing wheel and stop, and move the gluing wheel according to the glue position of the cardboard to make it face
3. Start the machine to make the cardboard pass through the gluing wheel, then observe the gluing position and gluing amount, and use fine-tuning to adjust to the ideal

C. Counting output

1. Put the folded cardboard between the flapping board (when the flapping board is at the forefront) and the trolley, move the trolley to a suitable position and lock it
Tight car
2. Set the base number according to the size and thickness of the carton, the height of the base number should be higher than the height of the baffle
3. Set the number of counting sheets, the setting range is generally 8-25 sheets
4. Adjust the height of the upper conveyor belt according to the thickness of the counted number of sheets, so that the belt can be properly compressed and the carton can pass through
5. The gas pressure is set by a regulator, generally around 5 air pressures. When the air pressure is less than 4 air pressures, the cylinder moves too slowly, and is greater than 5. When the air pressure is low, the cylinder moves too fast, which is not conducive to smooth work

D. Notes:

1. When adjusting the left and right width, pay attention to the extreme positions of the inner and outer sides to avoid burning the geared motor
2. All belts on the machine should not be too tight, otherwise the belts will be disconnected or the service life will be reduced.

06

LUBRICATION AND MAINTENANCE

Maintenance and maintenance are very important to the normal operation of the equipment and to extend the service life of the machine. Therefore, the equipment must be inspected, maintained and maintained regularly, and any problem should be dealt in time.

Periodic inspection:

Item	Date	Month	Remarks
All control, limit, emergency stop, photoelectric switches			
Gas pipeline and pressure			
Motor running status			
All sprockets and chains tightness			
Each bearing is operating normally or not			
Wear and tightness of various belts			
Whether the cylinder is normal			
Whether the screws of each part are loose			

Lubrication and oil injection:

Item	Machine oil	Grease	Date	Week
Cylinder and guide rod			Three times	
Each sprocket chain			Twice	
Rubber-coated wheel guide rod and lead screw				Once
Amplitude Modulation Screw				Once
All parts with seat bearings				Once every two months

