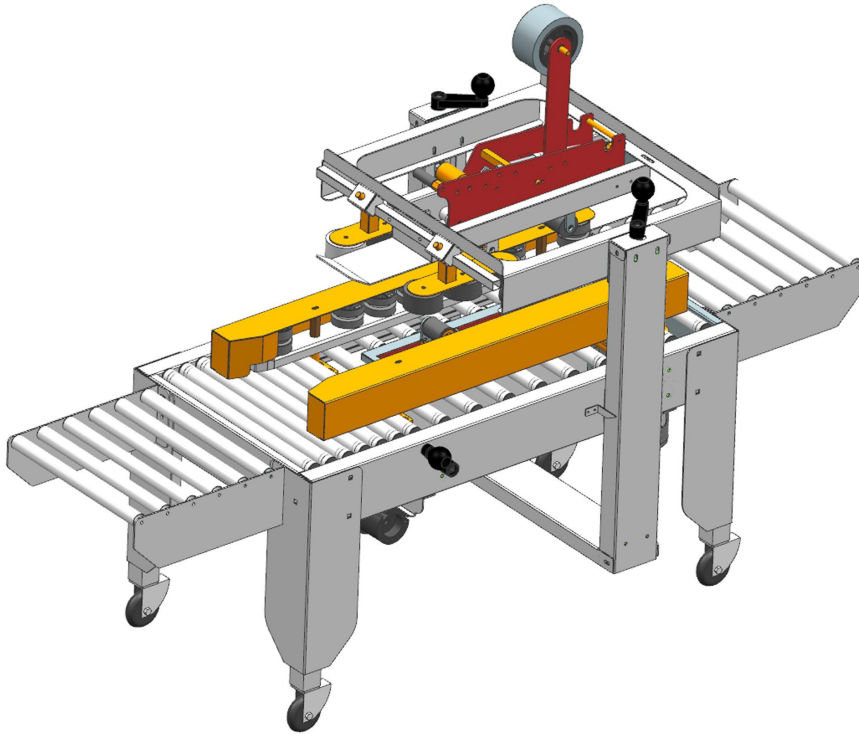


# **FXJ-4030 AUTOMATIC CARTON-SEALING MACHINE**



## **OPERATIONAL INSTRUCTION**

Read this operational instruction  
carefully before operation

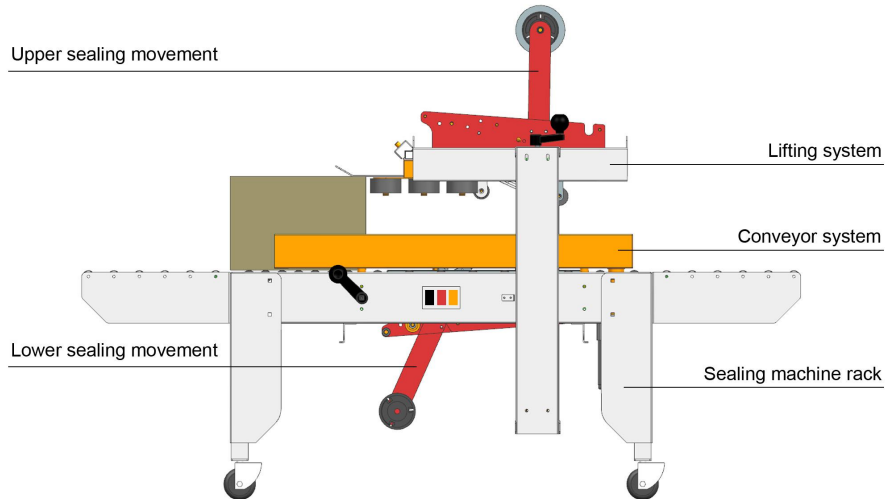
## I. FUNCTION

The FXJ-4030 carton-sealing machine adopts pneumatic principle to seal carton with adhesive tape automatically. It can be used independently as a single machine, or matched for production line. This machine adopts pneumatic method and adjusts packing size automatically according to carton. So it has much higher efficiency than manual and semi-auto carton-sealing machine. Additionally, pneumatic operation principle ensures the stable performance. The function of adjustment of cylinder pressure avoid from damaging carton. The machine is widely used in the field of electrical, domestic, textiles, foodstuffs, general merchandise, medicine and chemical industries.

## II. SPECIFICATION

Model	FXJ-4030
Power supply	220V 50-60Hz
Power consumption	180W
Sealing width	80 - 300 mm
Sealing height	90 - 400 mm
Sealing length	+∞
Table height	880 - 730 mm
Conveyor Speed	0-18 m/min
Machine size	L1060*W660*H1010 mm不含滚筒架

### III. STRUCTURE DIAGRAM



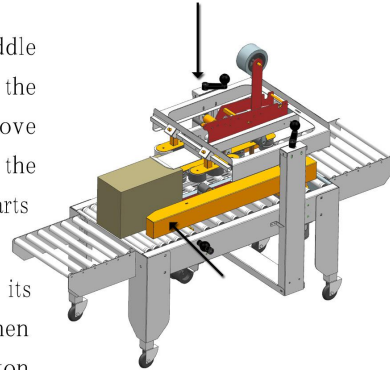
(Diagram 1)

### IV. OPERATIONAL PROCESS

1. Check each active part of machine to see if it runs well or there is block somewhere; check the connection of hose and electric wire.
2. Place the machine on the level ground, and make sure that there is no corrosive gas all around. Adjust the machine to be the same height with production lines, and make it on level.
3. Connection of outer gas-source:  
Connect one side of hose ( $\Phi$  6mm) with compressor; another end is connected with the pressure regulator. In order to disconnect gas-source, press inward circlip of regulator's connection head, then hose is able to be pulled out easily.
4. Check-up the pressure:  
Normal working pressure for pneumatic elements is 0.4-0.5MPa (it has been adjusted in the right position in the factory); do not exceed 0.5MPa during working, or damage the pneumatic elements. Notice that outer gas pressure may not exceed 0.95MPa.

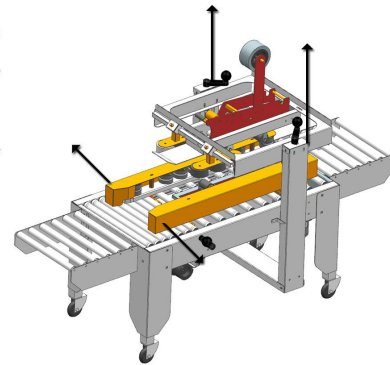
5. Plug in power and gas-source, then the upper tape seat unit ascends to the top automatically and two conveyor guiding sticks is opened to initial state.
6. Put on adhesive tape into upper & down tape unit (Refer to Chapter VI).
7. Put on power switch, and then the indicator light goes on. Adjust the high-pressure and low-pressure to the proper position. Now the machine is ready for packing.

8. Put carton on the front of worktable in the middle position. When the bottom of carton touches the mechanical valve, two conveyor guiding sticks move inwards and correct the position of carton to be in the middle. At the same time, upper tape seat unit starts to descend. (shown in diagram 2)



**(Diagram 2)**

9. The upper tape seat unit goes down until its mechanical valve is touched by carton; and then conveyor motor starts working and transmit carton through machine for packing.
10. When the carton moves away from down mechanical valve, two conveyor guiding sticks start to release as shown in diagram 3. When the carton moves away from upper mechanical valve, the conveyor motor stop running and upper tape seat unit starts to ascend as shown in diagram 3. Then it finishes packing.

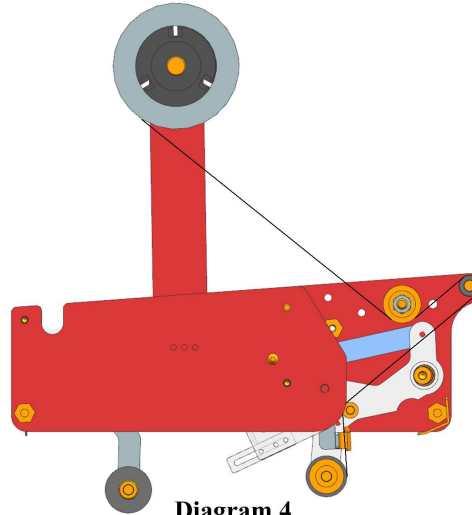


**(Diagram 3)**

11. Repeat above steps if to keep on packing. Press down "OFF" button to stop machine if you finish packing.

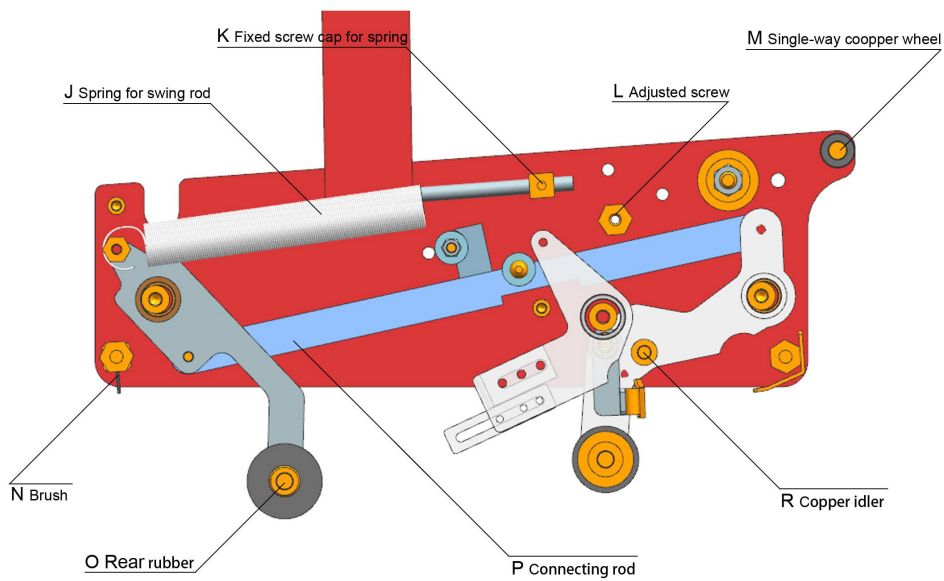
## VI. OPERATION OF TAPE SEAT UNIT

a. The way of putting on adhesive tape is shown in diagram 4.

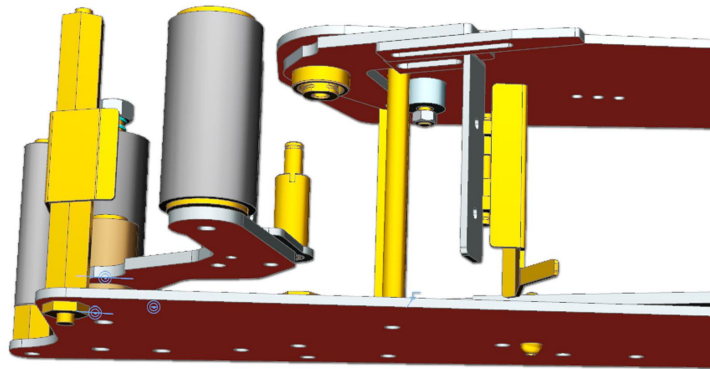


**Diagram 4**

b. When main spring becomes lax after using for certain time, fast “K” fixed screw cap for spring to increase bounce force of rubber wheels “O” and “Q” .



c. Press down rubber wheel to the end in order to check its height. The right position is in the same level with conveyor belt or 1-2mm higher; adjust the screw as shown in the diagram 6 if it is too low or too high. Generally, rubber wheel goes down slowly during operation, so it cannot press adhesive tape towards carton hardly while sealing. Consequently, it influences sealing effect and might have wrinkle as shown below. Hence check it every month.



( Diagram 6 )

## VII. MAINTENANCE

1. Switch off power every time while perform maintenance.
2. Clean the cutting knife and lubrication oil often. Exchange it when cutting knife is unable to cut tape smoothly.
3. Every week, supply all sliding shafts with enough lubrication oil.
4. For a certain time, tighten conveyor belt in order not to idle, adjust the height of rubber wheel as stated in chapter VI-c.

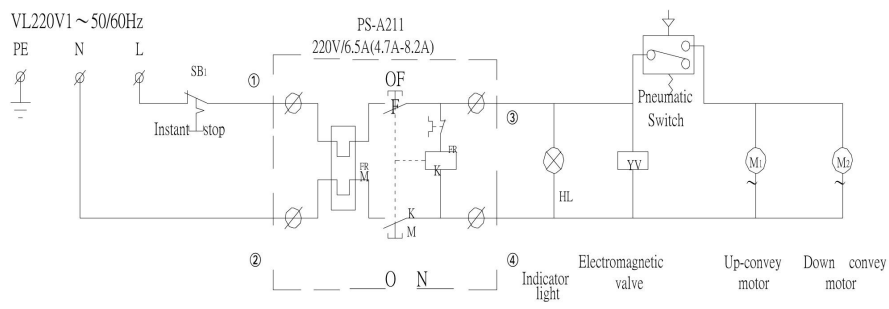
### VIII. COMMON MALFUNCTION

NO.	CASE	CAUSE	METHOD
1	Tape cannot be cut off	Knife is blunt; or tape sticks on knife	Exchange knife; or clear and oil knife
2	Tape cannot be cut off smoothly	Knife is blunt or main spring is not tight	Exchange
3	End of tape cannot stick on carton strongly	Main spring is lax, and bound speed of rubber wheel is not fast	Fasten "K" screw or exchange
4	Tape slips down easily	One-direction rubber wheel loses its function	Exchange

### IX. SPARE PARTS LIST

NO.	ITEMS	QTY.	NO.	ITEMS	QTY.
1.	Inner-hexagon spanner 4, 5, 6, 8, 10 mm	1 each	2.	Cross-head/flat head screwdriver	1 each
3.	Spanner 8*10, 12*14, 14*17, 19*22mm	1 each	4.	Hose connector	4
5.	Hose	9 m	6.	Brush	1
7.	Fuse pipe 3A	2	8.	Spring	3

### X. CIRCUIT DIAGRAM



**XI. Check-repair and feedback report**

Thanks a lot for purchasing our QXJ-5050 automatic carton-sealing machine. For your right choose, you possess reliable high-efficient packaging machine. We hope to establish long-term cooperation with you, and we will be appreciated very much if you would like to send us the feedback report or your kind suggestion.

**CHECK-REPAIR RECORD AND FEEDBACK REPORT**

(Copy is valid)

Owner :		Tel :		
Address :		Postal code :		
Seller :		Date of purchase :		
Model :		Invoice No. :		
Repair date	Case	Renew date	Repairman (signature)	Owner's stamp
Suggestion :				