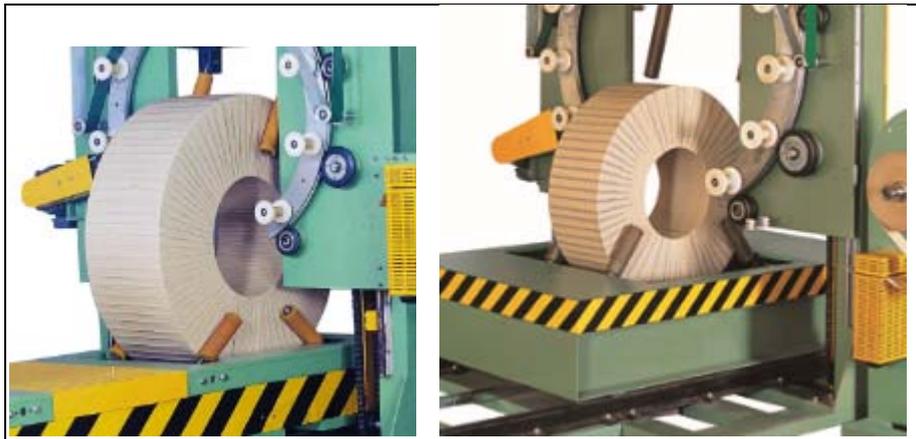
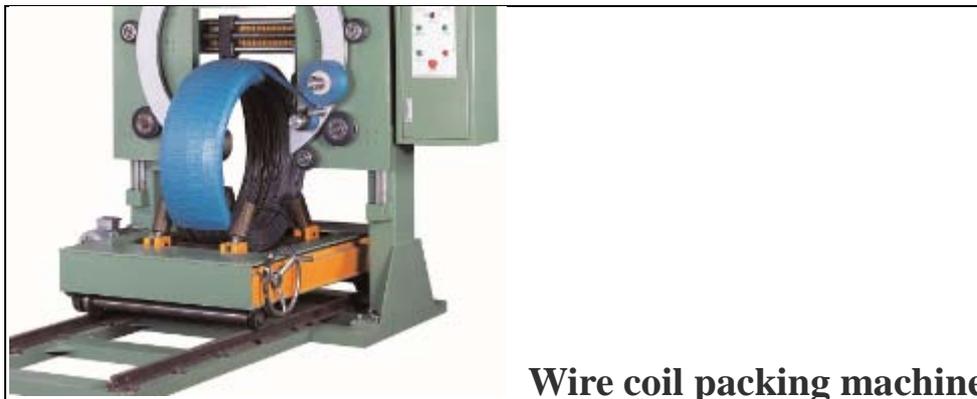




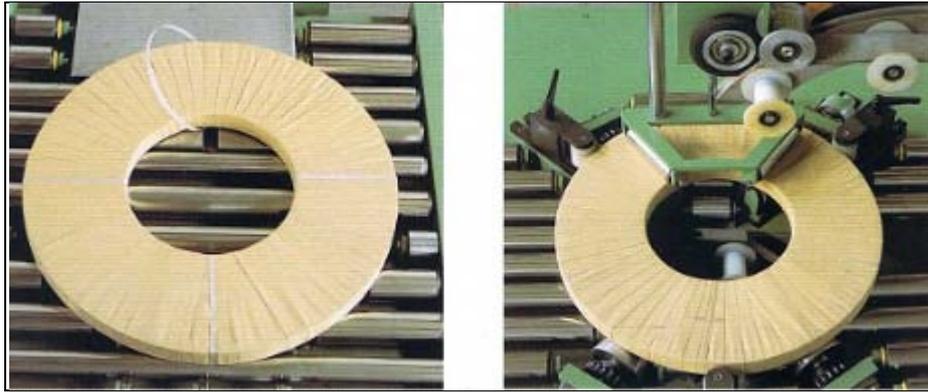
**Steel coil wrapping machine**



**Coil packing machine with trolley for loading and unloading**



**Wire coil packing machine**



### **Horizontal type coil wrapping machine**

### **Conveyor for loading and unloading**

**POWER:** The main switch of machine power supply which is used to connect or shut off the machine power supply.

**EMERGENCY STOP:** The control switch which is used to control circuit. Press this switch to shut down the whole machine in the case of emergency.

**MANUAL/AUTO:** The working mode of this machine is classified into manual operating mode and automatic operating mode. “MANUAL” mode is generally used for inspection, adjustment, troubleshooting and specific conditions. In normal operation conditions, “AUTO” mode is adopted.

**RING START:** It is usually used as startup button in “AUTO” mode. Press the button to make the ring work in “Manual” mode.

**RING STOP:** It is used to stop the machine in “AUTO” mode. Press the button to make the ring stopped in “MANUAL” mode.

**RING RESET** : It is used to have the ring and the support rollers

reset. (Only operate in “MANUAL” mode.)

**CUTTER**: It is used to cut the packaging tape. This button is valid both in “AUTO” and “Manual” mode.

**ROLLER RUNNING** ( FWD/REV ) : Used to put the roller under clockwise or anticlockwise under running status in “MANUAL” mode.

## II. Introduction to Main Content of HMI

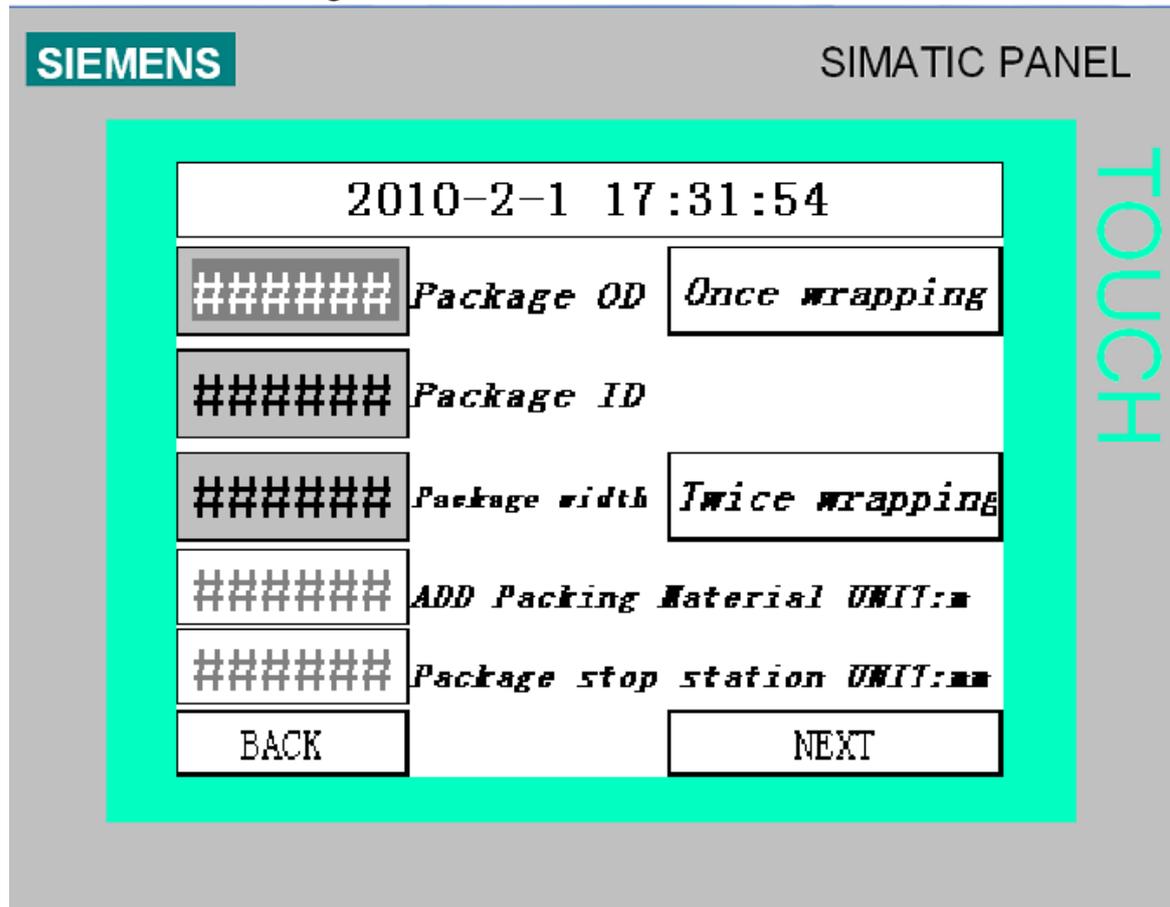
### 1、 Wrapping mode (display automatically after touching):

Ring speed	.....setting range 0 ~ 61.5HZ. Open the electrical cabinet, use the potentiometer to set the parameter
Roller speed	.....setting range 30 ~ 50HZ , Open the electrical cabinet, use the potentiometer to set the parameter

Note: “**Ring speed**” and “**Roller speed**” not only define the running speed of ring and roller respectively, but are also in connection with the overlapping of packaging tape. The two setting

parameters can be set by touching. If the ring speed is high and roller speed is low, the packaging tape features a large overlapping range; on the contrary, the overlapping range is small.

## 2、Parameter setting



**Package OD**: Input in actual size, with its unit as “mm” .

**Package ID**: Input in actual size, with its unit as “mm” .

**Package Width**: Input in actual size, with its unit as “mm” .

**ADD Packing Material**: When the calculated packing material by PLC is not enough, add the material appropriately to finish the packing process. Setting range 0-3, normally be 0.

**Package stop station**: Used to revise the deviation of the package

stop station. If the package stops when the process is not completed, increase the setting parameter appropriately to finish the process. Setting range 0-50.

**Once wrapping:** In the Auto control mode, when the needed packing material can be stored in the tape-storage wheel at one time, once wrapping can be used. It's usually the default setting of the equipment.

**Twice wrapping:** In the Auto control mode, when the needed packing material can not be stored in the tape-storage wheel at one time, twice wrapping should be used. The packing process is separated into 2 parts and machine will stop automatically when half finished.

### **III. OPERATIONS:**

( 1 ) Rotate the "POWER" switch clockwise to connect to the power supply of the machine.

( 2 ) Rotate the "EMERGENCY STOP" switch clockwise. At this time, the indicator lamp on the top of electrical box is on.

( 3 ) Turn the "MANUAL/AUTO" switch on the operating panel to "AUTO" position, and then the machine will work in automatic mode. Operate HMI, set the parameter of "ring speed" and "roller speed" and make confirmation.

( 4 ) Use flexible sling to safely hoist the unpackaged object to the central position of machine roller. Adjust the up & down protective

rollers.

( 5 ) Fixed Packing tape on unpacking object as fixed route, Tape-Threading Schemata for reference as follow.

( 6 ) Press the “RING START” button to have the machine run in automatic manner until one complete packaging is finished.

Then use adhesive tape or other method to fix the ends of packaging tape.

( 7 ) Use sling to take the packaged object away safely. A whole packaging process is completed. Start next new packaging operation according to the above-mentioned operating process.

## Tape-threading Schematic

