FHOPEGROUP
PACKING SOLTUION FOR YOU

STEEL Coil Wrapping Machine FPS-500

Product catalogue Manual & Operation

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I.Machine Overview

1.1 Packaging Machinery

Vertical coil packaging machine is mainly used for coil product packaging, mainly including opening side up / down type, main wrapping station moveable, bottom coil car moveable... mainly is suitable for all kinds of coil wrap packaging, such as copper coil, steel coil, aluminum coil, alloy aluminum coil, aluminum wire coil, plastic coil, hose coil, rubber hose coil, tire, etc. The packaging is relatively sealed, not only the product is beautiful and generous, and has the function of waterproof, dust proof and rustproof.

1.2 Vertical Coil Wrapping Machine

1.2.1 Machine composition

Ring body winding packaging machine is mainly composed of lifting screw, protect roller, wrapping ring, control panel and other parts.The two membrane shafts of this vertical wrapping machine FPS-500, are located on the ring. Following figure 1-1 is the specific position distribution of parts of FPS-500.

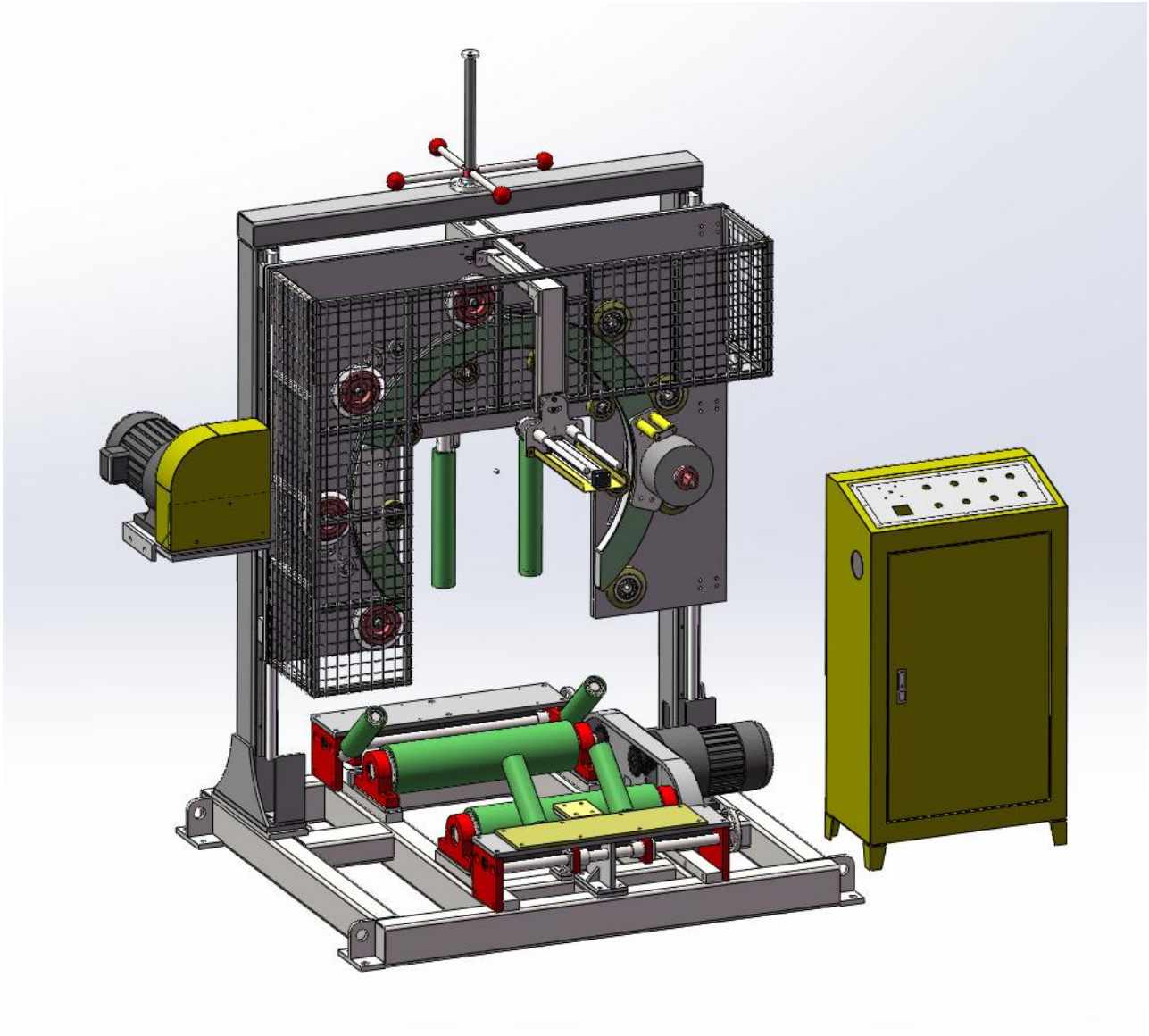


Figure 1-1

Figure 1-1 shows the appearance of this device,

1——Lifting Screw Control Cabinet

2——Safety Guard

3——Wrapping Ring

4——Support Roller

5——Label Roller

6——Down Roller

7——Label Shaft

8——Upper Roller

9——Membrane Film Shafts

10——Woven Material roll Shafts

11——Upper Roller Handle

12——Down Roller Handle

13——Control Cabinet

1.2.2 Supporting materials

The package material used in this machine is stretch film and VCI paper.

II.Machine Application

2.1 Introduction for panel and switch function

图 2-1

Figure 2-1 is the control panel of machine. The button functions as follows:

电源 Power Supply: The button controls main power supply of the cabinet.

暂停 E-STOP: Press this switch in case of emergency, the whole machine will not work.

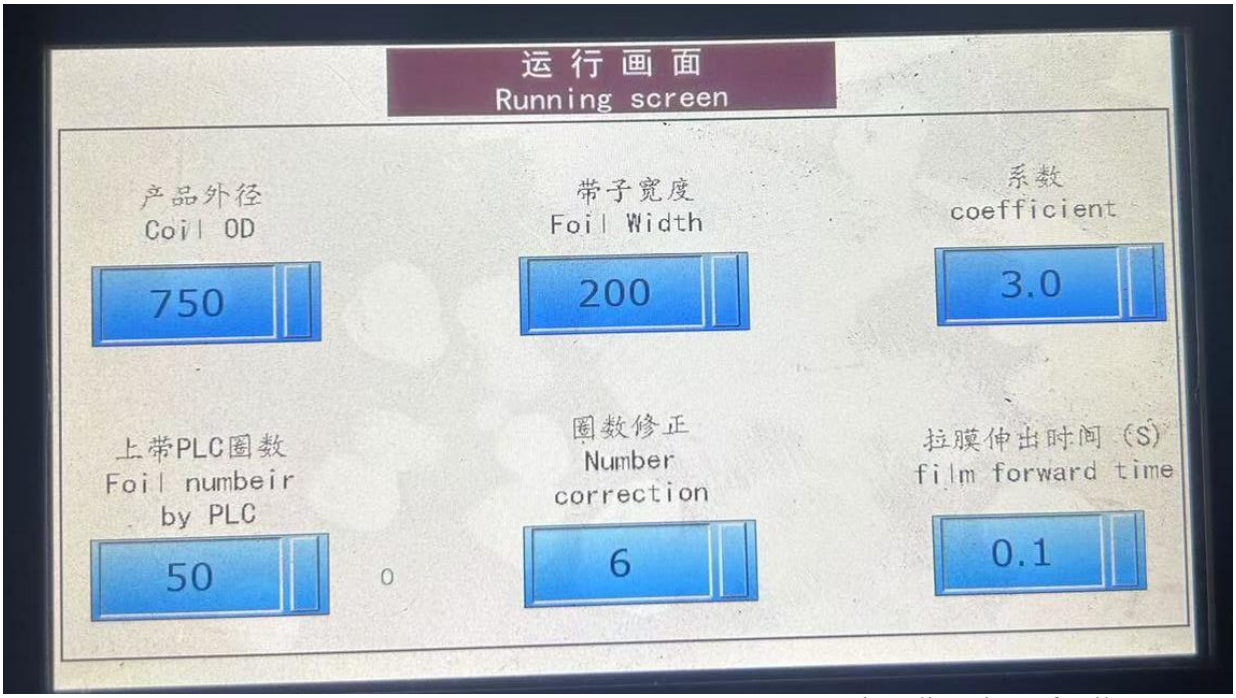
启动 START: The start button of the package makes the ring run.

停止 STOP: For suspending equipment running.

转环点动 RING JOG: This button can make the swivel ring run freely, start and stop at any time.

复位 RING RESET: Mainly used for rotating ring reset, convenient packaging in and out.

锥度辊正转/反转 SUPPORTING ROLLER POSITIVE/NEGATIVE: Control the



running direction of roller.

产品外径 Coil OD: Steel coil outside diameter.

带子宽度 Foil Width: The width of the packaging material.

系数 Coefficient: Refer to the overlap rate, our benchmark is 1.0. If the packaging film is longer after the packaging, it needs to be modified to 0.99.0.98.0.97.0.96..... Reduce data to achieve packaging effect.

上带 PLC 圈数 Foil number by PLC:

In order to pack the objects, the actual swivel need to turn the circle number, cannot be changed, automatically creating it.

圈数修正 Number correction:

1. Due to the friction drive structure has a certain error, another store on swivel wheels, around a circle of packaging material has a certain length, a circle more or less a circle a circle will error the length of the packaging material, so need to modify the number of turns, guarantee the packaging waste not, specifically for + 1, + 2... Or -1, -2... .

2. The number of turns correction to coefficient of correction at the same time, in order to achieve the best effect. For example, when the +1 circle is added, the packaging material will be more, and the -1 circle will be less. At this time, it is set according to +1 circle of packaging material, and the coefficient is corrected, such as 0.95, so that the idler speed is

appropriately slowed down and just matches the good effect.

拉膜伸出时间 **Film forward time:** a tension membrane stretched out matching time, a tension membrane action time.

2.2 Technical Specification

Machine Name	Steel Coil Wrapping Machine
Model	FPS-500
Coil size	ID=480-620mm； OD=720-830mm； Width =220mm -480mm;
Coil weight	20-2000kg
Packing material	Stretch film
	ID:50mm; OD:120-180mm; Width:90-100mm

2.3 Equipment operation process

1、 Check that the machine is properly powered on.

2、Put the package into the packaged into the feeding position, and observe whether the state is normal.

3、Check whether the whole packaging machine is in a reset state (ring; roller, etc.)

4、 Adjust protective rollers to proper position as required. In principle, the spacing between the two horizontal machine heads should be appropriately greater than the thickness of the packaging.

5、Adjust film to the appropriate tightness and confirm the horizontal position of the rotating ring to ensure that the packaging ring can accurately package. The film head is fixed on the hot knife device.

6、Press start to transport the package to the position of the package ring and wrap the

package until the end. The manipulator controls the cutter to automatically cut off the wrapped film and confirm that the rotating ring is in a reset state. The product is transferred to the next package, such cycle operation.

7、If the packing tape is used up in the process of packing, press the stop switch to suspend the machine.After reversing the package to a position favorable for butt joint, fix the replaced package tape on the package again according to the above requirements and restart the machine until the end of the package.

8、The ring ring should be in an appropriate position for convenient packing.On the one hand, the rotating ring and the packaging belt on the rotating ring cannot collide with the packaging or mutual friction.On the other hand, the section of the package should be as close as possible to the middle of the rotating ring, so that the package tape can be wrapped more evenly on the package.

9、Pay attention to the safety in the process of lifting the package.Turn off the power after the machine is used.

10、The package belt can be moved to a more suitable position by operating the rotary point switch.

11、When the inner diameter and outer diameter thickness of the packaging has changed, it is necessary to readjust the height of the distance between the two horizontal machine heads and the tightness of the packaging belt according to the actual needs.

12、For small inner diameter packaging, need to use a small outer diameter and narrow point packaging tape.

2.4 Equipment operation process

After the start button is pressed, the roller and the rotary ring of the packaging machine start to rotate at the same time to wrap the product. Then the staff manually attaches the rubber belt on the label roller to the end of the packaging material and then places the label roller on the end of the belt.After the end of packaging, reset the press label roll and

manually cut off the packaging materials and rubber belt;Product transfer, proceed to the next packaging, so the cycle operation.

2.5 Operating Cautions

1.If the packaging belt is used up in the process of a packaging, you can press the stop switch to suspend the machine to reverse the packaging to a position conducive to docking, replace the good packaging belt according to the above requirements to re-fix on the packaging, restart the machine to the end of packaging.

2.In order to facilitate packaging, the rotating ring should be in a proper position. On the one hand, the rotating ring and the packaging belt on the rotating ring should not collide with the packaging or rub against each other during operation.

3.To pay attention to the packaging lifting process of the safety of the machine after the use of power off.

4. The packaging belt can be moved to a more suitable position by operating the ring jog.

5. When the inner diameter and outer diameter thickness of the packaging changed, it is necessary to readjust the height of the roller spacing and the tightness of the packaging belt according to the actual needs.

6. If you come across a small inside diameter of the packaging, the need to use a small outside diameter and a narrow point of the packaging belt.

III Important Warning

1. Illegal operation will cause serious consequences.
2. Be sure to use it grounded.

3. In case of machine failure, please be sure to turn off the emergency stop switch or cut off the power supply. After confirming the safety, the relevant troubleshooting can be carried out.

4. Do not change the program and related Settings without permission.

5. Please do not tear off all marks on the machine.

6. Do not open the electrical box when the machine is working.

7. Packaging in and out must be safe, stable and orderly.

8. When the machine is in operation, the human body should stay away from the machine in case of accidents.

9. When operating the machine, it is strictly forbidden to wear long hair with a long robe or overhanging long tie, so as not to be twisted in.

IV. Equipment Specification

4.1 Technical Specification

Machine Name	Steel Coil Wrapping Machine
Model	FPS-500
Packing material	Stretch film
Machine weight	850kg
Packing speed	20-40sec/pcs
Power	2.6kw
Voltage	415V,50Hz,3ph
Wrapping speed	≤100r/min

4.2 Note for machine installation

10. In the whole installation process, it is necessary to prevent all kinds of accidents such as smash, crush, crush and collision.

11. As the machine is transported and moved, manual inspection of all moving parts is required.

12. The entire installation process must be completed when the power supply is disconnected.

13. The machine must be placed on a flat hard ground, and the external power supply must be consistent with the machine nameplate description.

14. Non-professionals, do not enter the installation site.

15. Only after the installation work is completed, can we enter the next procedure.

16. Place the machine in a dry, dust-free environment.

V.Troubleshooting

Problem	Possible cause	Solution
Package too loose	1. The package tension belt is too loose. 2.The ring is too high or too low.	1.Adjust the screw on the film carriage to suitable tightness. 2.Adjust the height of the ring.
packing tape easier drop off	The relative time of the ring &roller running too short.	Make the value of the “time setting” larger.
packing belt can't exit normally	Wrong way to wear the belt or wrong direction to turn the ring.	Check the running mode of the belt or reconfirm the running direction of the ring.

slip ring can’t work well	Rotating ring running direction is not suitable rotating ring transmission; friction wheel is too loose.	Confirm the rotation direction. Adjust the position of the friction wheel so that the pressure on the rotating ring is even and moderate.
packing belt too sparse	1.Film tension system is not suitable; 2.ring position too high or too low.	1.Adjust the tension nut on the film frame to the appropriate tightness; 2.Adjust ring height.