FPH-200/300/400/500N MODEL

COIL WRAPPING MACHINE

OPERATION MANUAL
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Reference Picture:
I. Application Note

This machine can be used to conduct relatively closed packaging for different dimensions of pipe coils or coiled unpackaged objects so as to play a role of waterproof, dustproof, anti-damage and anti-aging etc.

The packaging material mating with this machine is of stretch film.

II. Important Alert

I. Abuse will lead to serious result.
II. Do have the machine grounded.
III. In the event of urgent failure occurrence, do shut off or cut off power supply, and then carry out relevant troubleshooting operations after safety confirmation.
IV. Never modify the control program and relevant parameter settings of this machine without authorization.
V. Never tear off various signs marked on the machine.
VI. Never open the electrical box when the machine is working.
VII. In the case of the lifting and lowering of unpackaged object, do ensure safe, steady and orderly operation, and unpackaged object’s collision with the machine shall be strictly forbidden.
VIII. Standing under the running path of the objects is forbidden.
IX. Do not wear long hair, long gown or other long garments to avoid being involved into the machine.
## III. Technical Parameter

<table>
<thead>
<tr>
<th>Model</th>
<th>FPH-200N</th>
<th>FPH-300N</th>
<th>FPH-400N</th>
<th>FPH-500N</th>
</tr>
</thead>
<tbody>
<tr>
<td>Coil OD</td>
<td>500-800mm</td>
<td>600-900mm</td>
<td>800-1000mm</td>
<td>800-1200mm</td>
</tr>
<tr>
<td>Coil ID</td>
<td>200-600mm</td>
<td>250-800mm</td>
<td>500-650mm</td>
<td>500-800mm</td>
</tr>
<tr>
<td>Coil width</td>
<td>30-200mm</td>
<td>80-300mm</td>
<td>100-400mm</td>
<td>150-500mm</td>
</tr>
<tr>
<td>Coil weight</td>
<td>5-50kg</td>
<td>5-80kg</td>
<td>10-100kg</td>
<td>20-200kg</td>
</tr>
<tr>
<td>Roller speed</td>
<td>2-4m/min</td>
<td>2-4m/min</td>
<td>2-4m/min</td>
<td>2-4m/min</td>
</tr>
<tr>
<td>Rotating speed</td>
<td>40-120 r/min</td>
<td>40-110 r/min</td>
<td>40-90 r/min</td>
<td>40-70 r/min</td>
</tr>
<tr>
<td>Material width</td>
<td>70mm</td>
<td>90mm</td>
<td>100mm</td>
<td>120mm</td>
</tr>
<tr>
<td>Material OD</td>
<td>80-120mm</td>
<td>80-120mm</td>
<td>80-120mm</td>
<td>120-200mm</td>
</tr>
</tbody>
</table>
### IV. Machine Installation

1. Prevent against the occurrence of bruise, compression injury, crushing injury, contusion and other accidents during the installation.

2. As the machine has been transported and moved, all flexible components shall be inspected carefully.

3. The entire installation shall be completed under the condition that the power supply is cut off.

4. The machine shall be mounted on flat, hard ground; The power supply should be in accord with stated in the nameplate of the machine.

5. Only trained personnel can be allowed to enter the installation site.

6. Next working procedure can be executed only after all the installation operations are completed.

7. The machine shall be mounted in dry and dust free environment.
V. Machine Operation

I. Introduction to operating panel switch and function:

**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 it to shut down the whole machine in the case of emergency.

**START**: Used as startup button to make the ring and roller start work.

**STOP**: Used as stop button to make the ring and roller stop work.

**ROLLER FWD&REV**: Used to put the roller under clockwise or anticlockwise under running status.

**RING JOG**: Jog operation. Make the ring rotate freely.

**RING RESET**: It is used to have the ring and the support rollers reset, convenient for packaging object in and out.

**RING FAST & SLOW**: Ring speed can be adjusted by this button. Clockwise is for fast, while is slow.

**ROLLER FAST&SLOW**: Roller speed can be adjusted by this button. Clockwise
is for fast, while is slow.

**ALARM**: When the ring, roller and baseboard motor trouble occurs, the alarm will be alerted automatically.

**ROLLER FWD & REV**: Used to put the roller under clockwise or anticlockwise under running status.

**RING UP&DOWN**: Used to adjust the ring height for different objects’ ID&OD.

**TIME**: Machine automatic stop time. It is setted according to your packing need.

## II. OPERATIONS:

1. Check whether the power supply of the machine is correctly connected.
2. Adjust distance of up &down protective roller and side press roller effectively according to needs. The gap between the rollers should be larger than the object width in principle.
3. Push the object into the machine roller position and check if it’s in normal condition. Then push the sliding board to the suitable position by operates “ring jog” (until the ring can run through the object center.)
4. Adjust the film carriage to regulate the tension of the packing tape to suitable degree, and check the roller situation to make sure the roller can pass through the package object central smoothly.
5. Set a proper cutting time.
6. Press ring start button, the machine begins to work.
7. When a packing process is finished, press stop button to stop the machine. Cut off the packing material manually and fix it on the coil by tape.
8. Reset the ring and move packaged object away, one packaging is completed.
9. If the packing material is used out during the process of packaging, press the ring stop button to stop the machine. Switch the roller button to the opposite direction, then press start button, when the object has turned to a position easy for reconnection, press stop button. Then switch the roller to the normal direction.
Fix the packing material into the object, restart the machine.

10. The ring should be in a suitable position for easier packing. One hand, the ring and the tape in the ring should not collide or clash with the object. On the other hand, make the object section approach the middle place of the ring to let the object even wrapped with the packing tape.

11. Pay attention to the safety during in& out of the object. Shut off the power after the packing operation completed.

12. The button “ring jog” can be operated to make the ring stop in a position more suitable for operation.

13. When the ID, OD, width of the object change, the gap between the up and down protective roller, side press roller, ring height and tension of packing tape should also be adjusted.

14. For packing objects with small ID (inner diameter), packing tape with small ID and narrow tape should be adopted.

### VI. Troubleshooting

<table>
<thead>
<tr>
<th>Problem</th>
<th>Possible cause</th>
<th>Solution</th>
</tr>
</thead>
<tbody>
<tr>
<td>Package too loose</td>
<td>1. The package tension belt is too loose.</td>
<td>1. Adjust the screw on the film carriage to suitable tightness.</td>
</tr>
<tr>
<td></td>
<td>2. The ring is too high or too low.</td>
<td>2. Adjust the height of the ring.</td>
</tr>
<tr>
<td>The packing tape is easier to drop off</td>
<td>1. The relative time of the ring &amp; roller running is too short.</td>
<td>1. Make the value of the “time setting” larger.</td>
</tr>
<tr>
<td>Issue</td>
<td>Solution</td>
<td>Solution</td>
</tr>
<tr>
<td>----------------------------------------------------------------------</td>
<td>--------------------------------------------------------------------------</td>
<td>--------------------------------------------------------------------------</td>
</tr>
<tr>
<td>The object turns difficultly or shakes seriously.</td>
<td>1. The gap between the up and down rollers is too small or too big.</td>
<td>1. Adjust the up &amp; down protective rollers and side press roller to a proper place.</td>
</tr>
<tr>
<td>The packing tape is stretched out unsmooth.</td>
<td>1. Incorrect tape threading or inappropriate running direction of the ring.</td>
<td>1. Check the tape threading method or reconfirm the ring turning direction.</td>
</tr>
<tr>
<td>The ring don’t running smoothly</td>
<td>1. Improper direction of ring running.</td>
<td>1. Confirm the ring running direction.</td>
</tr>
<tr>
<td></td>
<td>2. The transmission friction wheel of the ring is too loose.</td>
<td>2. Adjust the position of the friction wheel to make its pressure to the ring equal.</td>
</tr>
<tr>
<td>The overlapping degree of packaging tape cannot be adjusted.</td>
<td>1. The relative speed of the roller and the ring is improper.</td>
<td>1. Adjust the parameter values of “ring speed” and “roller speed”, check whether the displayed convertor value in the electrical box changes accordingly. If not, please check the connecting wire of the HMI and the convertor.</td>
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</tbody>
</table>