FHOPEGROUP
PACKING SOLUTION FOR YOU

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
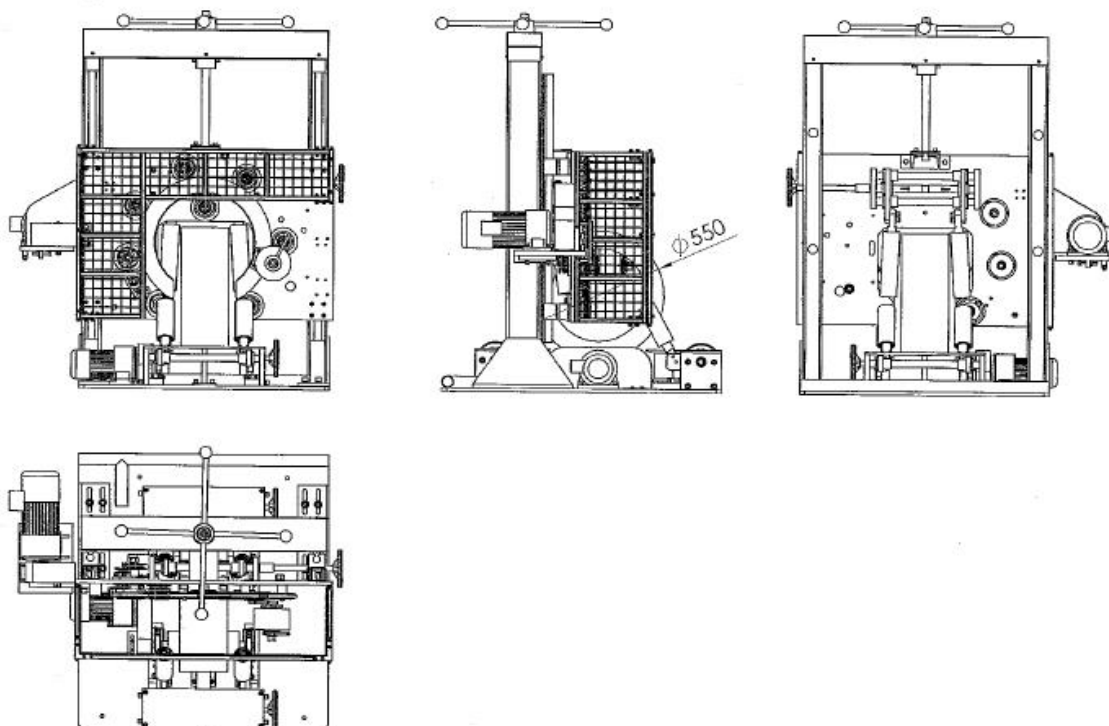
Model	FPH-200N	FPH-300N	FPH-400N	FPH-500N
Coil OD	500-800mm	600-900mm	800-1000mm	800-1200mm
Coil ID	200-600mm	250-800mm	500-650mm	500-800mm
Coil width	30-200mm	80-300mm	100-400mm	150-500mm
Coil weight	5-50kg	5-80kg	10-100kg	20-200kg
Roller speed	2-4m/min	2-4m/min	2-4m/min	2-4m/min
Rotating speed	40-120 r/min	40-110 r/min	40-90 r/min	40-70 r/min
Wrapping material	LLDPE/PE/Stretch film/PVC/	LLDPE/PE/Stretch film/PVC/	LLDPE/PE/Stretch film/PVC/	LLDPE/PE/Stretch film/PVC/
Material width	70mm	90mm	100mm	120mm
Material OD	80-120mm	80-120mm	80-120mm	120-200mm

Material ID	55mm	55mm	55mm	55mm
Power output	App. 1.2kw	App. 1.2kw	App. 1.8kw	App. 2.0kw
Power voltage	380V/50Hz	380V/50Hz	380V/50Hz	380V/50Hz
Wrapping speed	15-20sec/pcs	15-20sec/pcs	15-20sec/pcs	15-20sec/pcs
Overlapping rate	20%-90%	20%-90%	20%-90%	20%-90%

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 alert 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 stetted 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

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.
The packing tape is easier to drop off after running the machine	1.The relative time of the ring &roller running is too short.	1. Make the value of the "time setting" larger.

The object turns difficultly or shakes seriously.	1.The gap between the up and down rollers is too small or too big.	1. Adjust the up & down protective rollers and side press roller to a proper place.
The packing tape is stretched out unsmooth.	1. Incorrect tape threading or inappropriate running direction of the ring.	1. Check the tape threading method or reconfirm the ring turning direction.
The ring don't running smoothly	1. Improper direction of ring running. 2. The transmission friction wheel of the ring is too loose.	1.Confirm the ring running direction. 2.Adjust the position of the friction wheel to make its pressure to the ring equal.
The overlapping degree of packaging tape cannot be adjusted.	1. The relative speed of the roller and the ring is improper.	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.

Electrical diagram:

KT1

Power SQ1

SA3/SA4	SA1/SA2	备用	HL3	
上卷 托辊 下卷 FED ROLLER REV	上升 缠膜 下降 UP RING DOWN	SPARE	报警指示 ALARM	电源指示 POWER INDICATOR

SB2	SB1	SB4	SB3	SB0
启动 START	停止 STOP	转环点动 RING JOG	转环复位 RING RESET	紧急停止 EMERGENCY STOP

ring inverter VF1 M440 1.5KW		
5	6	9

V15　V16　V19

KA1　KA2　SB4 E　SB0

V10

2
0.5MM
black

roller inverter VF2 M440 0.37KW		
5	6	9

V25　V26　V29

SA3 F　KA1　SA4 F　SB0

KT2

V20

2
0.5MM
black

control circuit

power

| L11 | L12 | L13 | PE | N |

FAN5
20W X 1

0.5MM red
0.5MM blue

QU4 4A

L41

SB0

PD
30W 1A

0V

24V

0.5MM red
0.5MM brown

L51

0.5MM red

| KM1 | 007 | KM2 | 005 | FR1 | 002 | SQ3 | 001 | SA1 |
| KM2 | 008 | KM1 | 006 | FR2 | 004 | SQ4 | 003 | SA2 |

N   L51