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ZGL-160 AUTOMATIC HIGH-SPEED DOUBLE-SIDED
ALUMINIUM-FOIL PACKAGER

OPERATION AND MAINTENANCE MANUAL



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General

ZGL-160 automatic high-speed double-sided aluminum-foil packager is used for packing of bare pills, sugar-coat pills and capsules by using aluminum-foil for packing material.

This machine is characterized by good performance and high efficiency. Import frequency-converting speed-regulator and advanced batch feed procedure are adopt on it. It is equipped with automatic Magic-eye for adjusting the speed of feed to achieve high speed. All the procedures are performed automatically and manual operations are needless. It meets the specification of GMP standard.

Specification

<i>Productivity</i>	22,000~38,000 pieces/h
<i>Max width of product</i>	160mm
<i>Power supply</i>	220V, 50/60Hz
<i>Power of motor</i>	0.4KW
<i>Power of heater</i>	2.4KW
<i>Number of cutting</i>	1~5 rows
<i>Thickness of material</i>	0.05~0.2mm
<i>Compressed air</i>	0.4Mpa
<i>Integral dimension</i>	1260x800x1650mm
<i>Weight</i>	420Kg



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Operation

1. Install left and right reels of material.
2. Install A and B sealing mold, line-up the mold holes and tighten the locking screws and temperature-feeling wire screws.
3. Install vibrancy orientation guide, arc guide and discharge controller.
4. Turn on the power supply and switch on the heating switch of sealing wheel A and B.
5. Adjust the number of holes of mold wheel that you need.
6. Adjust the number of rows that you need.
7. Switch on the button of motor, adjust the rev knob to rotate the sealing wheel, adjust the pattern refer to the method of sealing wheel pattern adjustment.
8. switch on CUT button, adjust the cutting position refer to the method of cutting adjustment.
9. Switch on vibrator button and calibrate vibrating feeding and batch feeding knob to make the feeding matching the speed of sealing wheel and the pills or capsules reach correct position.

Adjustment

1. Adjustment of temperature



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- a) The temperature setting varies due to different material and packing speed. It is determined by the quality of finished sealing surface. Too high temperature setting results in damage and deformation of material and too low temperature setting result in bad sealing.
- b) 100° C ~110° C of reference temperature for transparent paper and 130° C~140° C for aluminum foil.

2. Adjustment of number of mold holes of sealing wheel

- a) The number of mold holes of sealing wheel should be adjusted properly to make the mold holes and feeding synchronously.(See figure 1)
- b) Assume there are 8 holes on sealing wheel, move the adjusting handle (item 51) of mold hole number down to position of 8 holes and tighten.

3. Adjustment of cutting rows number and position

- a) Assume the cutting rows number is 5 rows. Move the adjusting handle (item 52) of cutting rows number down to position of 5 rows and the cutting unit will act when 5 rows pass.
- b) The properly cutting position locates on the position C (see figure 3). If cutting position locates on position A, loose the locking nut (item31) and turn the cutting adjusting knob toward SLOW, and if cutting position locates on position B, turn the knob towards QUICK. Tighten the locking nut (item 31) when finish.
- c) If bad cutting occurs, adjust the air pressure-adjusting knob (item 61) to increase the pressure of compressed air. The pressure should be properly



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adjusted to avoid too high noise.

4. Adjustment of pattern of sealing wheel

- a) In case of case 1 (see figure 2), adjust the knob (item 12) count-clockwise until the pattern become uniform.
- b) In case of case 2 (see figure 2), adjust the knob (item 11) clockwise until the pattern become uniform.
- c) Note: the tightness between the two sealing wheel should be suitable, too tight of contact will damage the foil, and too loose of contact will result in inconspicuous pattern.

5. Adjustment of discharge controller

- a) Switch on motor to make the sealing wheel rotating to the position of sealing and adjust the cam (item 24) to its highest position.
- b) Move the pause bar (item 25) upwards to make the pill or capsule passing through easily, and then tighten the locking screws (item 21).
- c) If the pill or capsule is not fed correctly, adjust the cam (item 24). If the pill or capsule is locate above the medicine bag caused by too slow feeding, adjust the cam clockwise, and if the pill or capsule is located below the medicine bag caused by too quick feeding, adjust the cam (item 24) count-clockwise. Increasing or decreasing the speed of machine will affect the feed position, so the speed of machine should not be changed in a hurry.



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Maintenance

1. Gears, chains should be greased every 3 months, calcium-base grease should be used.
2. The guides of cutting knife and disjunction line impressing knife should be oiled every day, #20 machine oil should be used.
3. Bearings on brush and roller speed adjusting unit and other drive unit should be oiled every day, #40 machine oil should be used.

Note: Stop the machine before oil and grease. The lubricating points should keep cleaning.



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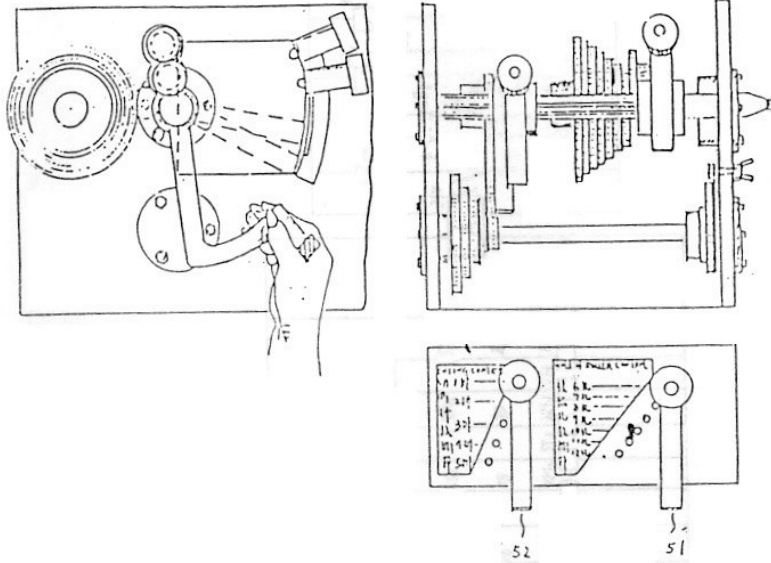


FIGURE 1

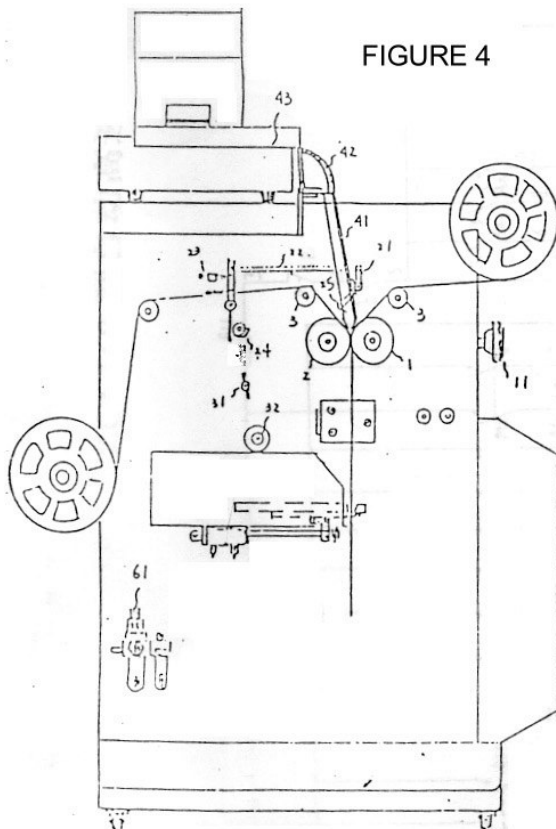


FIGURE 4

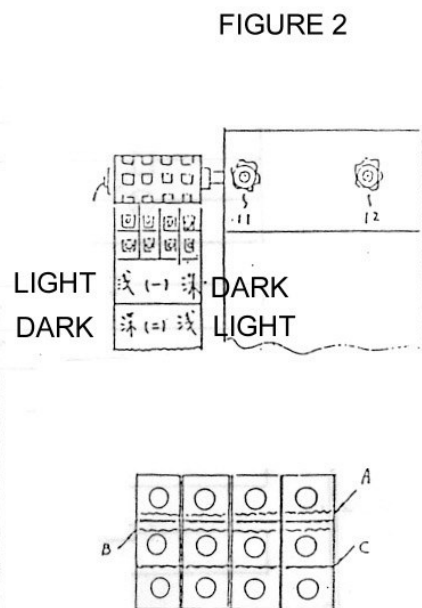


FIGURE 2

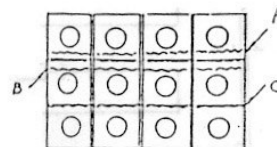
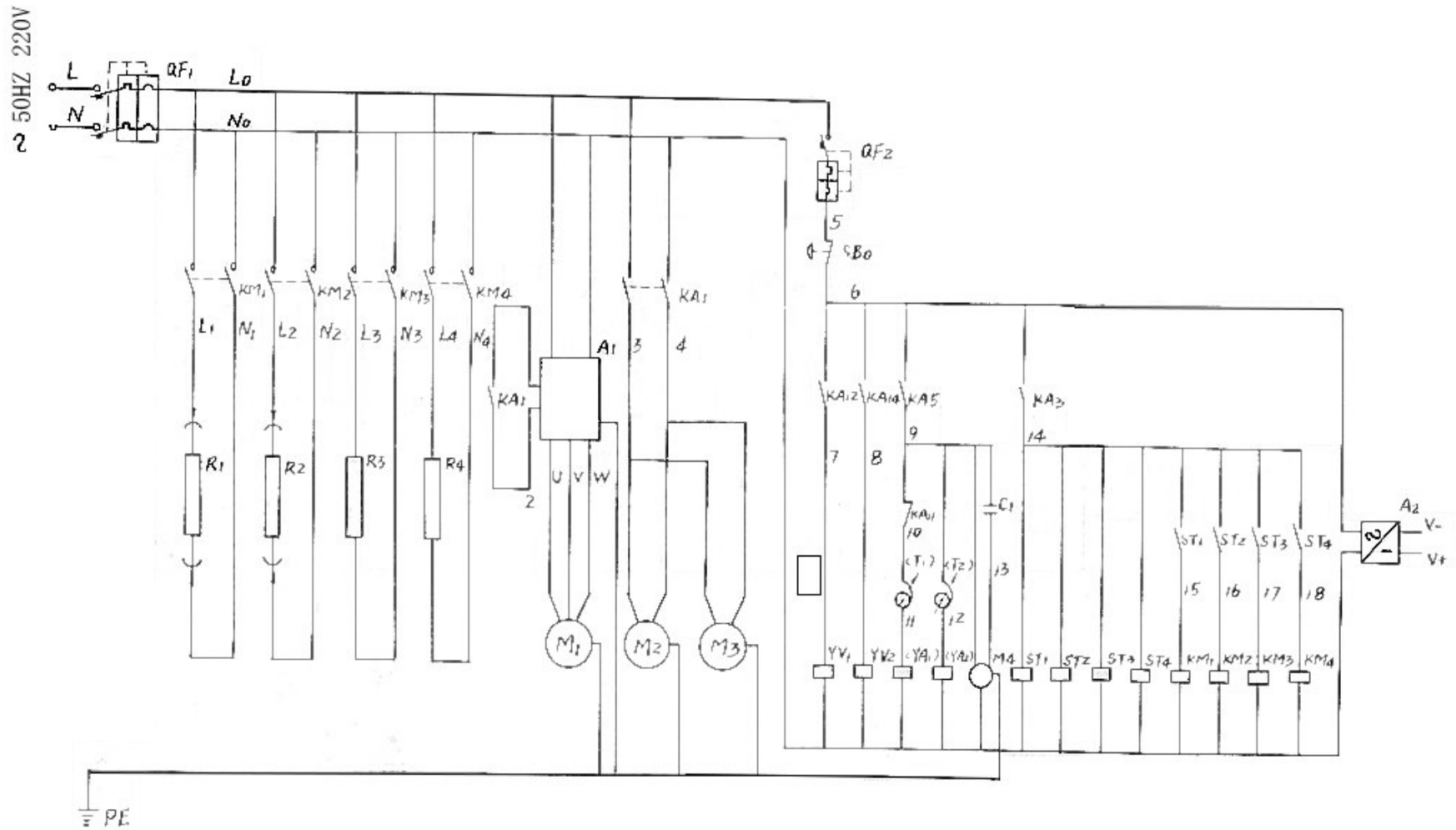


FIGURE 3

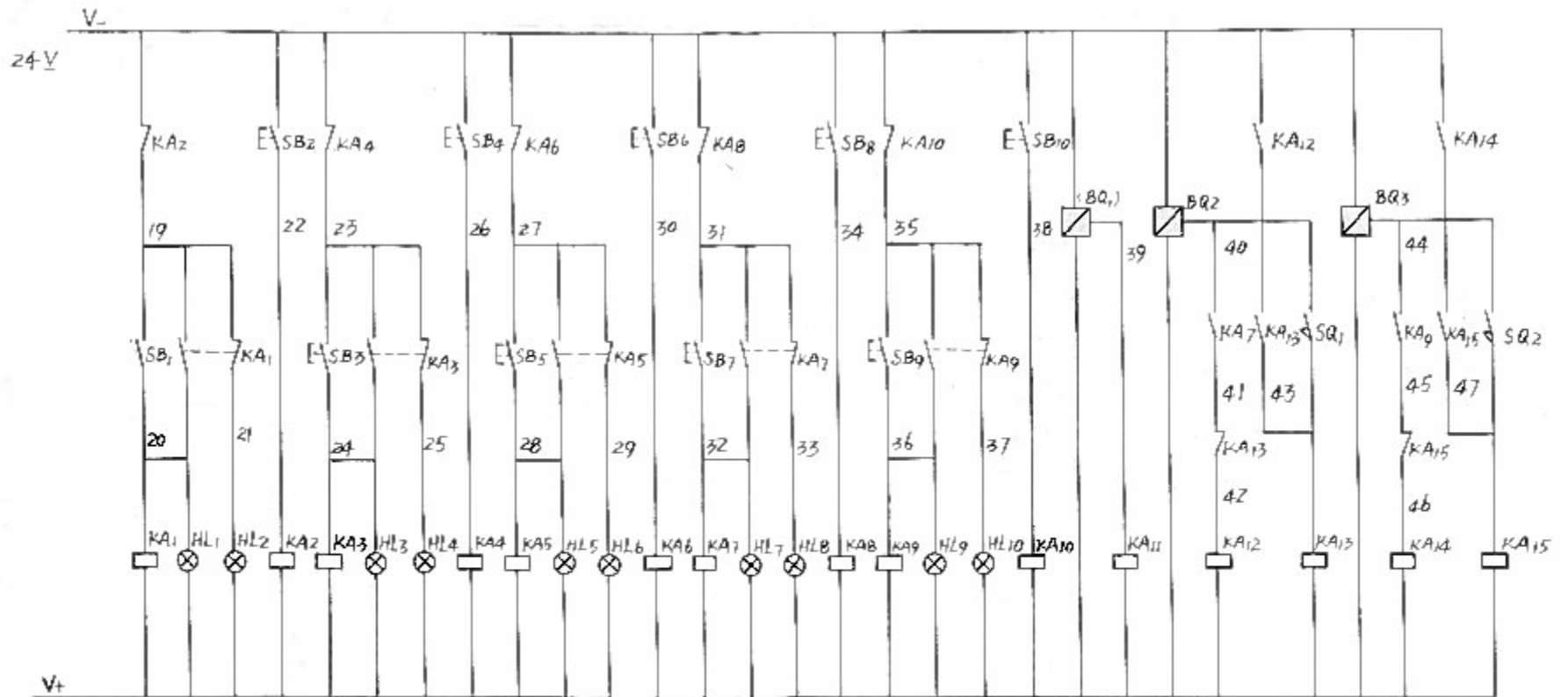


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注:当本机为转盘式加料时将3采用()中的元器件



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ZGL-160 automatic high-speed double-sided aluminum-foil packager component an its
Manufacturer

Nmme	Manufacturer	Type
minigear decelarate transmission machine	Taiwan	HP4POLE 220V 380V 1.KW
transducer	Panasonic in japanese	DV-700T400D1
Main motor	Taiwan	
Cylinder	Taiwan	



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Touch switch	Mitsubishi in japanese	
	#316 stainless steel, meet the GMP require	

Packing list

Automatic High-speed Double-sided Aluminium -foil Packager	Packing list		1 of 1 pages
Serial No.:		Model	ZGL-160



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No.	Designation	Unit	Quant ity	Specification	Remark
1	Main equipment and technical documents				
1.1	Aluminium -foil Packager	Set	1		
1.2	Introduction of frequency conversion adjustable instrument	Piece	1		
1.3	Operation manual	Piece	1		
1.4	Certification	Copy	1		
1.5	Packing List	Copy	1		



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2	Accompanied tools				
2.1	Pressure oiler	Piece	1		
2.2	Double-ended wrench	Piece	1	8×10	
2.3	Double-ended wrench	Piece	1	12×14	
2.4	Double-ended wrench	Piece	1	17×19	
2.5	Inner-hexagonal wrench	Piece	1	S=3	
2.6	Inner-hexagonal wrench	Piece	1	S=4	
2.7	Inner-hexagonal wrench	Piece	1	S=5	
2.8	Inner-hexagonal wrench	Piece	1	S=6	
2.9	Inner-hexagonal wrench	Piece	1	S=8	
2.10	Inner-hexagonal wrench	Piece	1	S=10	
2.11	Inner-hexagonal wrench	Piece	1	S=12	
2.12	Screw driver, ‘-’ type	Piece	1	125×6	
2.13	Screw driver, ‘+’ type	Piece	1	100×5	



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2.14	Joint pliers				
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