

DPP-80 Blister Packing Machine

Service Manual

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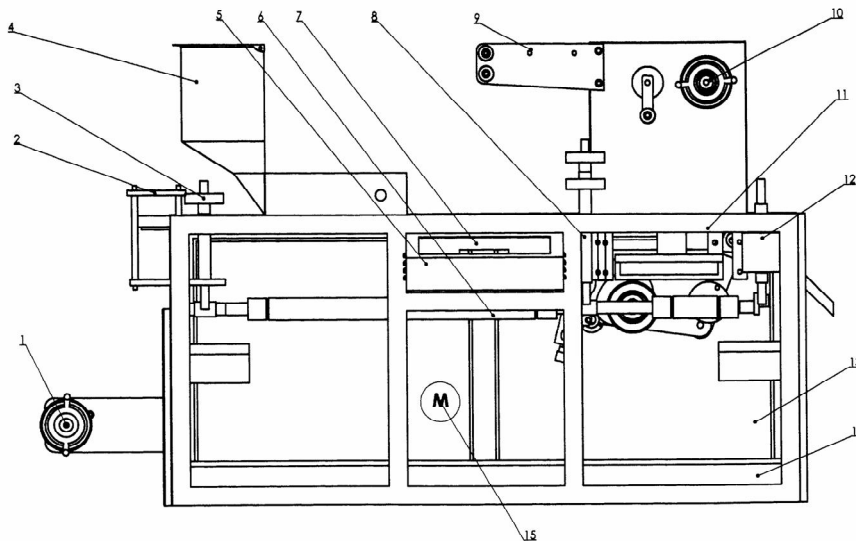
Attentions

A, Please read this note seriously when you begin to use the machine. In order to prevent the operation mistake and the damage.

B, Please connect to the ground carefully.

C, Forbid to touch to the circulating parts(especially the vertical and the horizontal heating parts) ,When the machine is working. Make sure the personal and machines' safeties.

One, Mechanical plan



1、PVC Turning stick 2、Heating Part 3、Forming Mold 4、Rotary Feeder 5、Running Track 6、Spindle site 7、Touch switch plate
8、Heat sealing Mold 9、Turning stick 10、Al-Foil 11、Binary Device 12、Cutter Mold 13、Mainframe face 14、Floor 15、Main Motor

Two, Summary

Since the company was founded, we specialize in the production of DPP-80 automatic aluminum-plastic packaging machine series. The function has reached at the leading level in China.

Implementation of Al-plastic composites sealed package, with the extended period to maintain and beautify the advantages of goods and reduce the cost of packaging.

It is a ideal packaging equipment for the purification plant and the hospital reagents room

because the machine is small area, low investment, the use of multi-function, high efficiency, non-polluting, low noise and so on.

There, the product usage scope and characteristics:

1, Adopt the high-power transmission of the domestic latest model, and spread to move the stalk from the row chain to remove other gear transmission error and noise.

2, Imports of used electrical control systems, customers can request configuration shut fill leakage detection and missing tablets removed devices (Omron sensors). Used imports Frequency Converter.

3, Unit stages portfolio : PVC shape, feed, heat sealing as a tropical aluminum cold forming, heat sealing, Punching a section of the body for hours packaging.

4, Photoelectric control systems, PVC, PTP, tropical aluminum packaging automatic feed, scrap automatic admission Device, to ensure the long-synchronous multi-position stability.

5, Additionally photoelectric detector may calibration device, service imports stepper motor drive, the transmission version printing and packaging, optimize packaging grades.

6, The machine applies : capsules, tablets, sugar-coated, capsules, injections, and other special-shaped medical device, light industry and food, electronic components sealed blister packaging.

Four, Main technical parameters

Punching frequency : 10-40 times/min 1 Plate / time	
General plate : 57 x 88MM 1 Plate / time	Reference specifications: 27 x 88MM 1 Plate / time
Max. forming area: 60 x 100MM	60x100MM 1 Plate / time
The standard scope 30-70MM	In accordance with the requirements of users
Yield > 98%	Electrical power : 0.37KW
Forming heating power : 1.8KW	Heating power : 1.8KW
Heat sealing heating power : 0.8KW	Mercury Air volume > 0.3 CM (own)
Cooling : circulating water or tap water	Weight: 300 kg
Size: 1500x600x1200(LxWxH)	
Packaging materials specifications: Medicinal PVC 0.3x80MM Aluminum foil 0.023x80MM	

Five, Installation and attention :

1, check the degree before installation whether the ground level is balanced.

2, Signs shall be designated location grounding access earth.

3, Professional training of personnel to operate and maintain.

4, keep the machine clean and neat.

5, before the machines must refueling site (Senate took the Provisions)

6, machinery factory gearbox strap lubricants, production before refueling.

7, it is proposed to use the machine the best oil-free air compressor.

8, molding, heat sealing, such as indentation pressure on the site should not be too large, otherwise affect life. Forming indentation Zhi-pad should have a turn-mm floating around room.

Six, Before the operation

- 1, the safe use of electricity, lighting power supply connected to the electrical power transmission test, turn the power on, to move the mainframe, whether normal operation.
- 2, Water : Signs on the fuselage Block significant characters into the cooling water, leading missed out droplets, water-jin, whichever is fluent in the water.
- 3, and the pump : the air-gas pipeline access to the airway leading, open air compressors, pressure of more than 0.6 ~ 0.8MPa be used.
- 4, oil : refueling joined boxes and gearbox, Note : The Case for refueling 2 / 3 oil.
- 5, VC commitments on plastic materials axis, is the outside-Nut Cone, modulus operation to the next point, Guo and PVC plastic, behind the starting blocks to open suppress primer, PVC plastic to board the plane to orbit prevail on both sides, the same uniform.

Seven, Operating procedures

- 1, Green indicator light, heat sealing and forming next two heating switch operation were opened position. Temperature Controller forming temperature control, the general respectively preset 100 ° C, second only instrument control temperature heat sealing, preset temperature of 130 ° C to 140 ° C. Next Molding and heat sealing temperature control instrument preset temperature, specific discretion involved.
- 2, put aside primer material effect on Roller Press, molding temperature of heating plate in place, to open mainframe, first of PVC plastic molding, foam Molding eyes and the heat with these Kong Die, Die attention to the heat cylinder blocks down the heat embossed foil live, aluminum foil will lead to Chong closed. Observation of plastic (referring machine board has been forming PVC) running around whether migration. If there is bias should be adjusted with the pressure roller Block mobilize primer direction.
- 3, if the aluminum foil around Bias, adjustable roller switch Festival Block hand rotation is. If both mobile deviation adjustable box.
- 4, heat sealing Chong contained normal after opening the Feeder switch and lock to make drugs (tablets capsules grain clothing) into the appropriate feeding room, where a small cylinder aggregate artificial Buchen, if drugs are being brought into the heat dies, Synchronization will be seriously affected, this should be the timely closure sticky foil mold, stands to handle.
- 5, due to the increase in the weight of drugs foil Rally and machinery temperature changes gradually varying degrees, Molding and may have simultaneous heat sealing, lead or lag, the first inspection of PVC plastic and aluminum foil Yam has separated then on fine-tuning available for institutional adjustments. Fine-tuning agencies in Mold forward backward, or away from their box adjustment after adjustment. See figure (2) Therefore, the boot should be placed before the median position, before moving forward after, he can box before moving regulation, mobile right after plate to wait after the end of a dozen version is correct, why has not finished in time and not transferred to the redeployment.
- 6, plastics, aluminum foil to the heat sealing quality (uniformity firmly sticking fair) from the temperature or pressure, halftone plates fair degree certificates to see, if the heat adverse generally to temperature, a slightly lower pressure, temperature regulator is, the final adjustment Lo List pressure.
- 7, blanking abduction, the Conference format using offsets, figure (3). Parking will be hand-Box Mobile has been able to transfer mode shift.
- 8, the day-to-day operational knowledge for the operation must know to understand

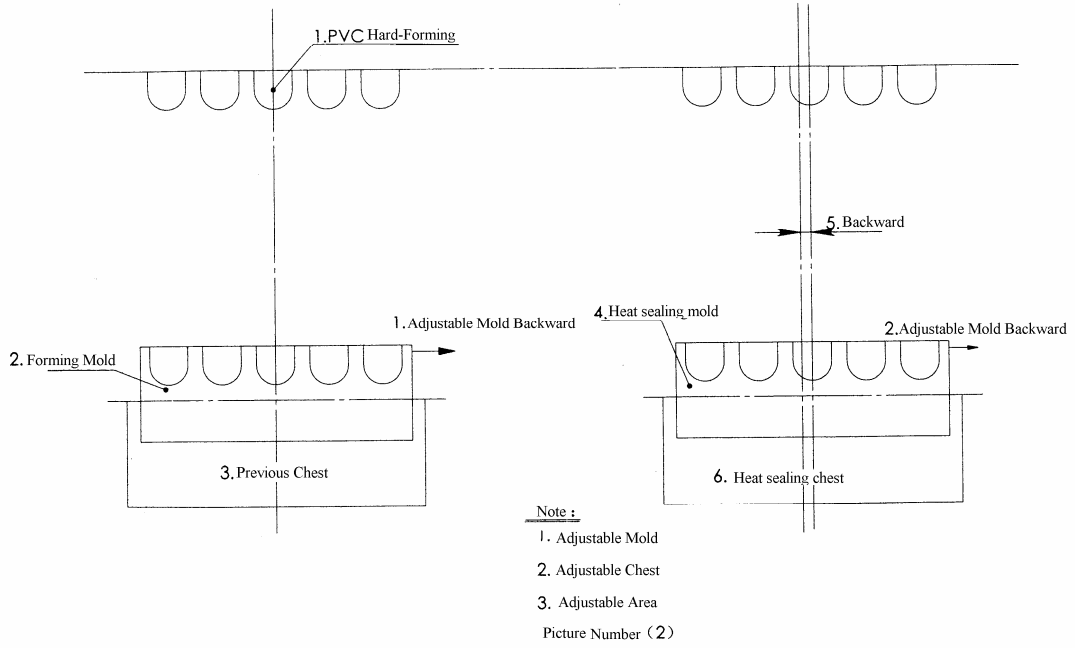
aircraft structural principle, stem from the cam drive wheel Block, The next trip, site location fixed template death, there Blister bad state, the attention or Die under the heat of the only point on, Solid tight column nut, neglect of vulnerable to failure, mandril pressure Needle Roller killed, Pai method for the plan (4).

Eight, Malfunctions and Solutions

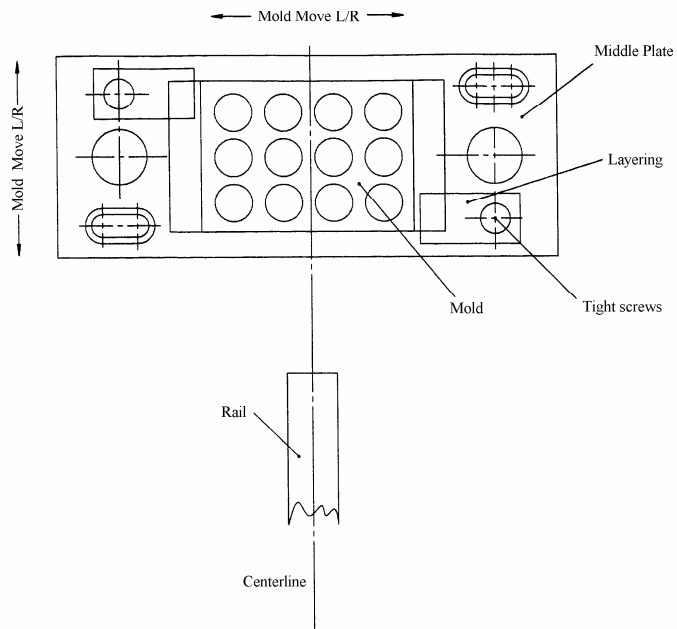
Malfunctions	Reason	Solutions
Forming bad	<ol style="list-style-type: none"> 1. Air flow overload 2. Heating temperature is too low or too high 3. Cooling water flow away to remove excessive heat 4. Air pressure should not be too early or late 5. Attention air filter valve contained 6. Under Die vent plug 7. The next model planes gas leakage 8. Poor quality PVC plastics 	<ol style="list-style-type: none"> 1. Two lower ventilation flow. 2. Temperature Control Device according to the appropriate temperature control is transferred (as voltage control) 3. Regulating water valves to control water flow 4. Correction machinery release valve position to maintain the general air pressure of 0.6 ~ 0.8MPA 5. Normal check valve will air filter when Qingfang 6. With Steely implemented dredge 7. More re-tooling and processing required to wear Plane 8. Turnover plastic

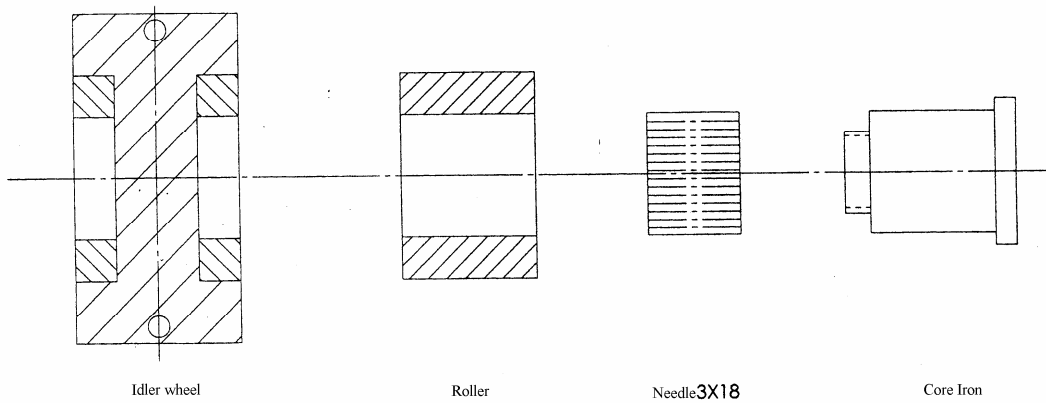
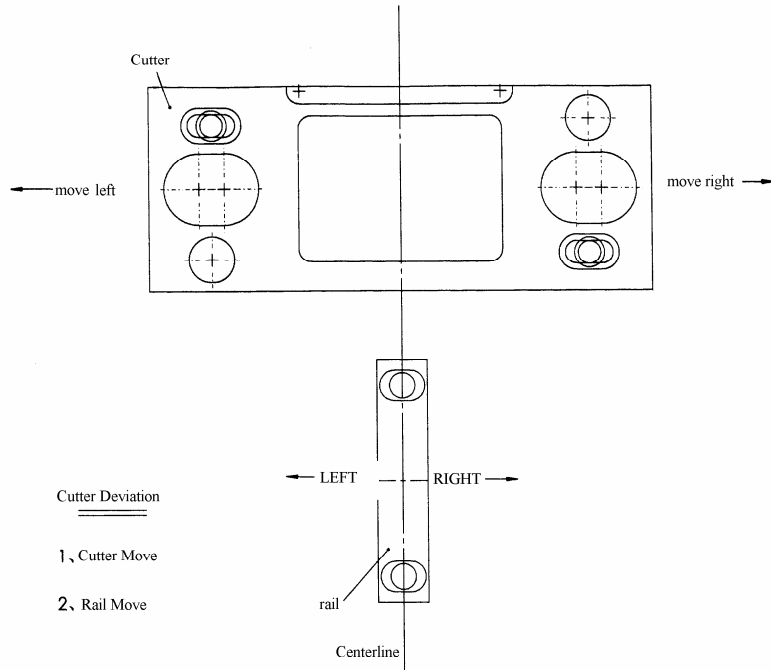
<p>The simultaneous operation (defined as forming blister failure to accurately model the heat entering Holes)</p>	<ol style="list-style-type: none"> 1. Die and not for the heat sealing of the entire trip several times 2. Pressure running parallel with primers Block, excessive or too small 3. Forming, heat sealing module that is bad cold 4. Die Mold to the heat between obstacles 5. Plastic materials for rotating the poor 6. High temperature heat sealing 	<ol style="list-style-type: none"> 1. Die regulate mobile and manufactured mobile Box has been highlighted not be good for mold, usually is not so high upset 2. Regulation play primers Block axis, the axis starting blocks primer increase lubricating oil 3. That modest increase cold water 4. Feeding checks from the heat sealing operation to whether there are obstacles to feed and machinery space between the plate surface 5. Cleaning or replacement of bearings 6. Low-temperature heat sealing temperature lowered
<p>Foil wrinkling and migration</p>	<ol style="list-style-type: none"> 1. Foil and PVC plastic adhesive ADR (parallel) 2. Turn the stick aluminum foil and PVC plastic film longitudinal vertical routes 3. Netted on rust and dirt 4. Netted plate and die anastomosis bad 5. Aluminum foil layer uneven. 	<ol style="list-style-type: none"> 1. Tear off aluminum foil, glue re-adjusted position 2. Cypriot turning point cushion adjustment roll stent and correction not die 3. Steel side liquidation or saw blade is sharpened 4. With two-layer aluminum foil folded halftone mode depending on the heat or oilstone situation, local grinders under planar 5. Replace foil.

<p>Partial after punch and Heat sealing bad</p>	<ol style="list-style-type: none"> 1. Die Mold pitch with the heat wrong 2. The temperature is too low or too high 3. A low pressure or heat sealing trespassing on the cylinder side phenomenon 	<ol style="list-style-type: none"> 1. Overall mobile Die, Box injection at the factory have been mobilized, but consider the long-term transport and the use of vibration displacement deformation or template for other factors 2. Temperature temperature regulation, as far as possible by the regulator to control, maintain a steady temperature at about 140 ° C (as appropriate) 3. Reconciliation adjustments cylinder pressure (pressure regulating valve) of silicon rubber checks only whether the board, may change, it is desirable, copper tracks cylinder and heat sealing between Block (copper mentioned in books as appropriate) (Note : emphasize the importance of being on the stands only points)
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7





Idler wheel assemblage
Needle installation plan

DPP-88 automatic machine aluminum-plastic packaging machine
product testing

Date: _____

Items tested		Standards	Result	Note
A: Basic Parameters	a. Punch Frequency	35time/min	Qualified	
	b. Max. forming area	60×100mm		
	c. forming depth	<28mm		
	d. Motor Power	0.37kw		
	e. Forming district heating power	1.8kw		
	f. Heat sealing district heating power	0.8kw		
B: Assembly Quality	a. Die Gap	0.01~002mm		
	b. Soda pipeline system	not allow unimpeded obvious leakage		
C: Appearance Quality	a. Non-casting surface processing	no convex tumors, depression, porosity, phenomena such as scarification		
	b. The exposed surface	no corroded, bumps, scratches and other phenomena		
	c. Electroplate	Smooth, no scratches, scarring shedding phenomenon		
	d. Drug contact with the parts	OCT18Nig should be used at room temperature or under drug-free anti-corrosion materials		
	e. paint	In line with provisions of JB2855		
	f. Electrical Wiring	Neat, aesthetics		
D: Safety Performance	a. Security Grounding	Security grounding devices and clearly marked		
	b. Insulation Resistance	>2MΩ		
E: Empty Moving to Performance	a. Transmission	Transmission smooth and no blocking, unusual noise and vibration.		
	b. Roller counterparts intermittent operation	Synchronous		
	c. Bearing temperature	<35K		
	d. Electric Control Equipment	Accurate and reliable		

	e. Lubrication System	Lubrication good, and no use leakage		
	f. Unit noise	<78-82db(A)		
	g. Temperature measurement instrument display and error	sensitive, reliable, error 5°C		
F: Assembly Quality	Filling rate	>95%		
	Finished incision	Formation		
	Foil and PVC glue, halftone, hot pressing, lot numbers	Solid, Formation, Netted and lot numbers clearly		

Inspector _____

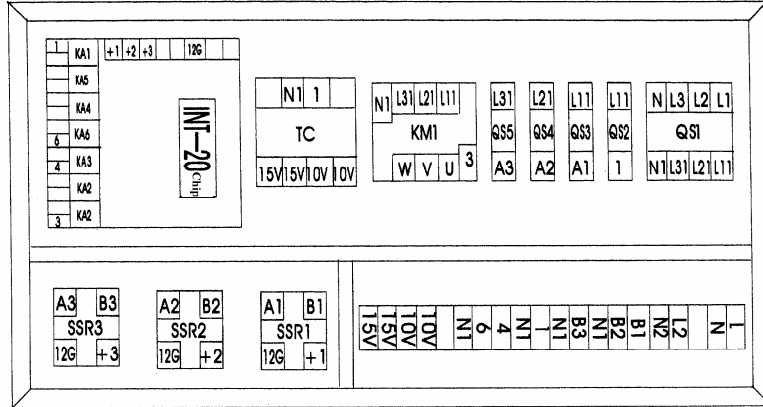
Nine, Check List

Name	Type	Quantity
Automatic aluminum-plastic blister packaging machine	DPP-80	1
Within the six Kok Wrench	2、4、5、6、8、10、12	1
Stiff SPANNER	17-19	1
Activities Spanner	10 Inch	1
Activities Spanner	14 Inch	1
clamp	6 Inch	1
Level screwdriver	4 Inch	1
"Cross" screwdriver	4 Inch	1
High pressure oil tank		1
Hone		1
Gas joints	Φ6、Φ8、Through、Elbow	2
Steel code word	0~10	1
Copper wire brush		1
Socket wrench	Φ17	1
Product brochures, certification		1

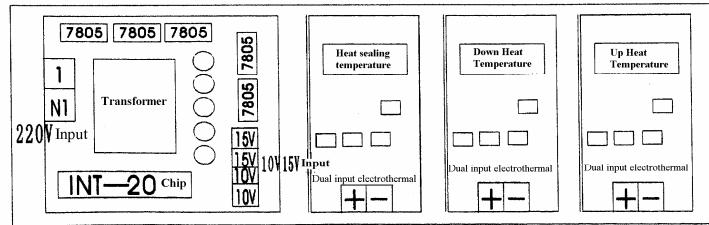
Pack the member _____

Pack the date _____

***** 80 Electrical Installation Diagram *****



Back diagram



***** 80 Series Electrical schematics *****

