

Operating Manual for BOPP Adhesive Tape Slitting Machine



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I. Safety Precautions:

1. Move all combustibles away to leave sufficient space for machine installation.
2. Power supply to this machine must be fixed with air-break switch equivalent to the machine installed power.
3. When run the machine for the first time or power supply changes, do pay attention to the direction of rotation of the units.
4. The power supply voltage to this machine must be bigger than what stated on the data plate of this machine. It is prohibited to change the fixed machine voltage without our permit.
5. When there is breakdown or any potential dangerous factors, do not start the machine, and do cut off power and mark the problem obviously.
6. The blades and electrical parts of this machine are dangerous. Make sure every inspection or maintenance to this machine should be managed after cutting off the power and put obvious **“In maintenance, do not switch on”** attention device at the power source.
7. When machine is running, the doors of the machine cabinet should be closed. Only when do inspection and maintenance to the machine, the doors can be opened. Additionally, pay

attention to the rotating parts and high temperature to avoid injury to people.

8. CAUTION: any operation against the safety precautions may lead hazard.

II. Safety reminders

1. About Lifting and Moving

Use proper power lifting device according to the machine weight

Pay attention to the lifting position to prevent steel ropes to damage the machine body

When move the machine by forklift, use some soft material to protect the machine. Additionally, make sure the fork is put under the machine base completely

2. About Working Area plan

It's better to locate the machine as closed to the power source and air source as possible. This will reduce the power waste and tubes length to ensure air pressure.

It's suggested to plan a bigger working area for this machine future extending purpose.

The working area should be well ventilated, in shade, free from dust and moisture

III.Application:

This machine is mainly applied for slitting BOPP tape, cellophane tape, small quantity of waterless Kraft paper and masking tape.

Features:

1. Centralized panel control, simple and easy operating
2. Automatic exchange shafts: when winding complete, two winding shafts exchange position to continue working.
3. Variable frequency control to regulate speed. When stopping machine, the tape can be stopped instantly.

Voltage:

Main slitter, 380v 3 phase 4 lines

Small rewinder, 220v, single phase

IV.Operation steps:

1. First tear off the tape roll surface packaging, and the put it on the forklift for prepare. Take the unwinding shaft from the slitting machine, and loosen nut fixed at the end to take off the core clamper. Put the unwinding shaft into the core tube of the

jumbo roll. Install back the core clamper to the shaft and faster the nut. Lift the tape roll and push it to machine to make the unwinding shaft fixed to its place.

2. Loosen the screw(this screw use to fixes the cutter shaft) and take the cutter shaft out, unscrew the cross screw which on the one side of cutter shaft. Fix the spacer ring and blade on the blade shaft in sequence until the cutter shaft full, and then reinstall the cross screw and put the blade shaft back to the machine.
3. The digital length counter is equipped on the left of the machine panel. You can set speeds in 3 stages as starting, normal running and stopping.
4. Turn the Auto/Manual switch to Auto mode, press start switch, turn the speed regulator knob slowly to increase speed. Control the machine speed to make it between 80 and 120. (shown as RMP). When the tape reach the first meter segment, machine speed will slow down. When the tape reaches the second segment, machine will stop. After sticking the label, press the second start switch, machine will exchange the shaft

automatically and then stop. Cut the tape and then loosen the machine's lock. Take out the finished rewinding shaft and prepare for unloading the finished tape.

V. Maintenance

Principle motor: 5HP ac motor + ac inverter (SAJ)

Meter counter: 3 segment control electronic meter counter

Blade: industrial razor blade

Automatic shaft exchange system: 1 HP ac motor

Scraps winding: synchronous control