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Strapping Machine

MODEL: XQD19, XQD19B, XQD25

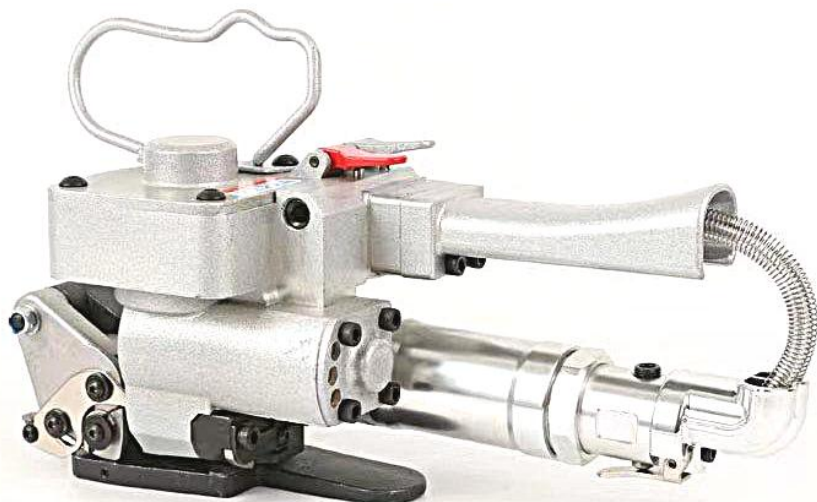
We continue to be committed to provide you tools with competitive price. "Save Half", "Half Price" or any other similar expressions used by us only represents an estimate of savings you might benefit from buying certain tools with us compared to the major top brands and does not necessarily mean to cover all categories of tools offered by us. You are kindly reminded to verify carefully when you are placing an order with us if you are actually saving half in comparison with the top major brands.

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NEED HELP? CONTACT US!

Have product questions? Need technical support? Please feel free to contact us:

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This is the original instruction, please read all manual instructions carefully before operating. VEVOR reserves a clear interpretation of our user manual. The appearance of the product shall be subject to the product you received. Please forgive us that we won't inform you again if there are any technology or software updates on our product.

INSTRUCTIONS

Thank you very much for choosing this Strapping Machine
- Please read all of the instructions before using it. The information will help you achieve the best possible results.
The products carried in this catalog may be different in color than the actual item.

1. Safety Instructions

Please read the Manual carefully before using this packaging machine.

General safety rules

1. Bear in mind "safety-foremost" principle, and operate this pneumatic tool properly;
2. Read the Manual carefully before operation;
3. Don't dismantle safety parts of the tool;
4. Don't tear or damage label or mark of the product;
5. Don't put your hand or other parts of your body between packaging belt and packaging tool.

Application

This tool is specially designed for binding articles with PET packaging belt;
Applicable width of packaging belt: 13, 16, 19mm;
Don't use the packaging belt for lifting.

Correct dressing

Wear safety glasses, earmuffs, protective gloves, helmet, protective footwear and long sleeve shirt, fasten all buttons; take care, your necktie, long hair and cloth shall not be hooked by the packaging machine.

Gas source

- Ensure the air supply pipe can bear pressure and is resistant to oil;
- Do not use the special quick union for air pipe; the air pressure shall not exceed 116psi/8bar;
- Use only clean compressed air, rather than gas source or dynamic source,

Ventilation

Indoor air can easily be polluted by lubricating oil;hence,the ventilation should be proper.

Vibration

It's harmful to operators if they come into contact with excessive vibration for a long time.The operation specification should conform to relevant requirements of ISO5349.

Noise

Operators shall wear earmuffs if the noise is higher than 85Db(A).Even if the noise is lower than 85Db(A),it is also recommended to wear earmuffs.

Safety glasses

If the tensing packaging belt breaks suddenly,it may hurt eyes and result in blindness,so operators shall wear safety glasses.

Note:

While cutting the packaging belt,hold its upper part,and stand at its side;the upper belt will be cut down;be careful,there should be no people in the surrounding.During maintenance and cleaning,the dust brought by air duster gun is harmful to eyes.

Moving part

During operation,the moving part (tightening pulley)may clip glove or other part of your body,so when the take-up pulley is rotating,don't touch it.

Maintenance

- Conduct daily maintenance to the machine;
- Check regularly,and remove dust with an air duster gun;
- Tighten the screws of hook;
- Turn off gas source while replacing parts.

Hazard while cutting

The sharp blade on the blade holder may hurt your hand and finger,so please wear safety gloves.

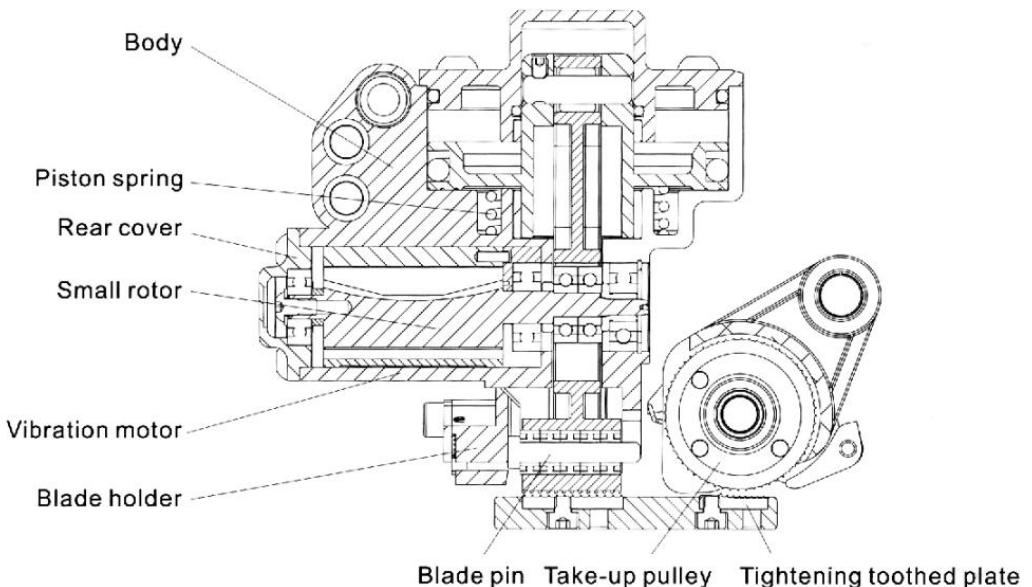
2. Principle of Friction fusion

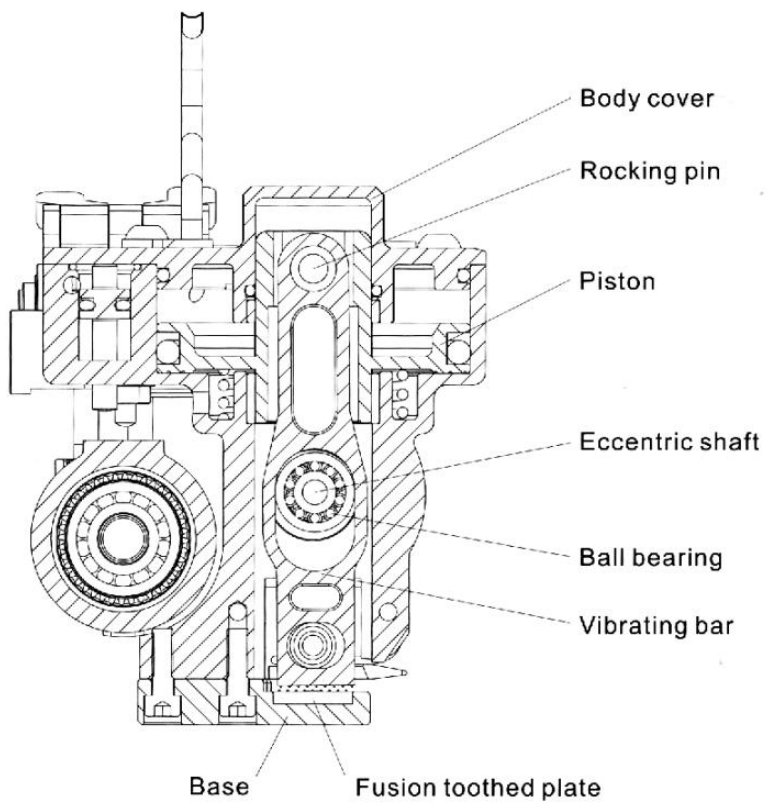
This tool is a kind of friction fusion packaging machine. The lapped thermoplastic packaging belt is fused by the heat produced by friction motion; hence, it is called "friction fusion"

The compressed air will push the piston within air cylinder. The upper part of piston and vibrating bar is connected to the rocking pin, so the vibrating bar will press the lapped part of packaging belt when moving down.

There is an elliptic hole at the center of vibrating bar, This hole is connected to the eccentric shaft of pneumatic motor. The pneumatic motor rotates at a high speed (10000rpm), so the vibrating bar conducts reciprocal motion quickly. The lower part of packaging belt is fixed by the peg teeth of fusion toothed plate, and its upper part is driven by the peg teeth of vibrator for strenuous friction. Hence, the lapped part of packaging belt is fused by the heat produced by friction. When the vibration timer reaches the set time, vibration stops and fusion completes.

Both upper and lower parts of the packaging belt are stuck while extruding.





3. Specification and Parts

| Mode | XQD19 | XQD19B | XQD25 |
|--|---------|---------|---------|
| Material of packaging belt | PET/PP | PET | PET |
| Width of packaging belt(mm) | 13~19 | 13~19 | 19~25 |
| Thickness packaging belt(mm) | 0.5~1.2 | 0.5~1.2 | 0.5~1.5 |
| Tension force of binding band (when input air pressure is 0.63Mpa) | 3000N | 3000N | 3500N |

Max.allowable working pressure:0.8Mpa

Required scope of working pressure:0.5~0.7Mpa(72~100psi)

Ideal working pressure;0.63Mpa

Material of packaging belt:PET

Allowable lubricating oil:51#

Consumption of compressed air:0.3L/Min

Adjusting scope of fusion time:2~5s

Heavy cutting device

The heavy cutting device is composed of blade holder and blade and is used to cut 0.5~1.5mm thick packaging belt.

Friction cutting device

The friction cutting device is used to cut 0.5~0.7mm thick light PET packaging belt.

Suspension

Proper hooks may be suspended at different positions(top sealing,vertical sealing; and horizontal sealing).

4. Gas Source Instruction

Requirement of air pressure

The required scope of air pressure:72-100psi (0.5-0.7Mpa).

Installation of gas source

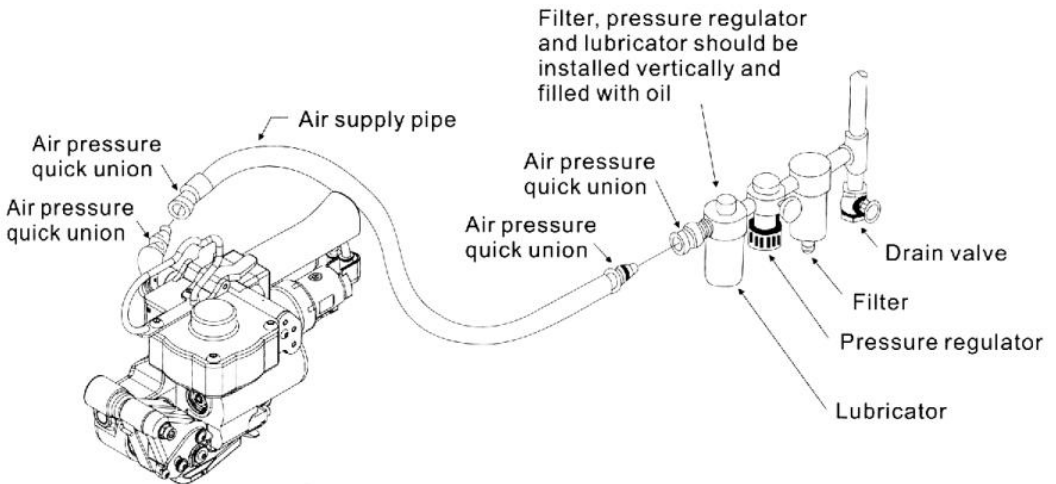
Filter,pressure regulating valve and lubricator assembly shall be close to the pneumatic tool.The min.inner diameter of air hose is 6.0mm(1/4).Both ends of air supply pipe should be equipped with quick unions.

Moisture filtration

A drain valve must be mounted at the bottom of the air supply circuit's bypass to drain once every day.

Lubrication

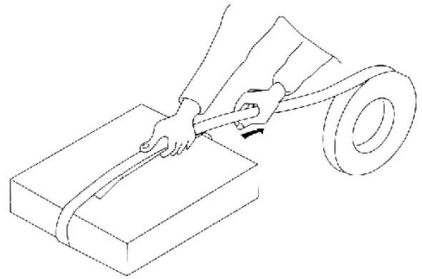
Pneumatic motor should be lubricated properly,and the lubricator should be full and well-regulated (a drop every 2min).



5. Operation Instruction

(1)How to bind

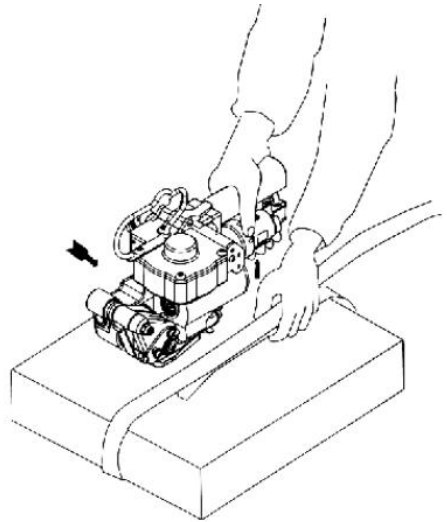
As shown in the left figure, bundle the article with packaging belt, hold the lapped part with left hand, leave about 300mm tail, pull the remaining part out with right hand.



(2)Place packaging belt

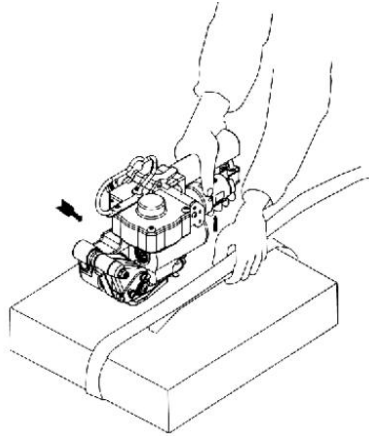
Hold handle and tighter with right hand (to ensure the maximum opening dimension between take-up pulley and tightening toothed plate), insert both upper and lower parts of the packaging belt into the packaging machine.

Note:the lapped part of packaging belt must be separated by the blade of blade holder; release the tightener (the take-up pulley clips the packaging belt tightly)



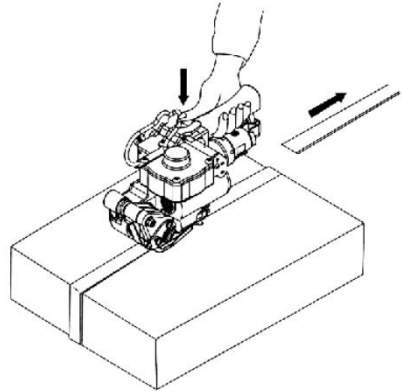
(3)Tighten the packaging belt

Press the tightening button (right side)with the thumb of right hand till the packaging belt is tight fully.



(4)Vibration and cutting

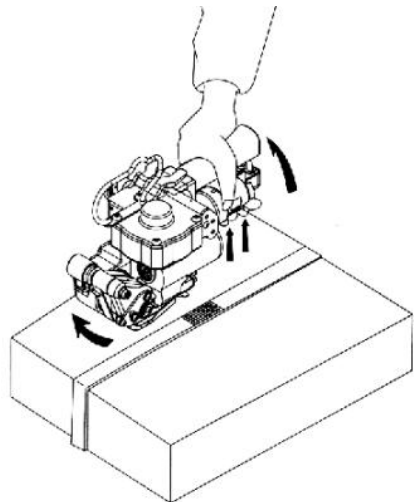
Press the fusion button (left side)with the thumb of right hand till the packaging belt is fused and cut off



(5)Take down the packaging machine

Press handle and tightener tightly with right hand.Press the rewinding button with the little finger of right hand till the belt is released from the take-up pulley.Press handle and tightener tightly,remove the tool from the packaging belt.

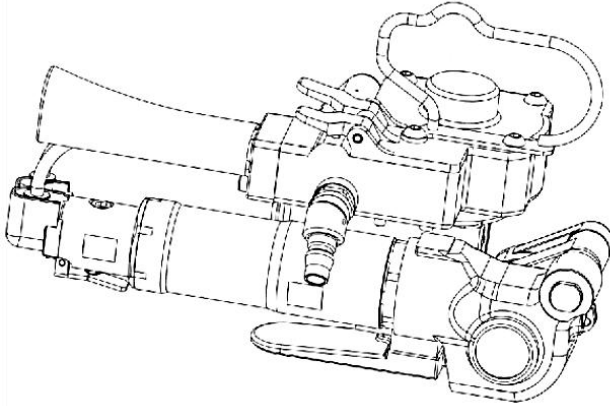
Note:don't remove the packaging machine until the packaging belt is released.



6. Tension Adjustment

Tension of packaging belt

The tension of packaging belt may be adjusted with a screwdriver through the tow valve stem mounted below the tightening button beside the handle.



Warning:

light packaging belt (<0.7mm) may bear 150kg of tension. Don't apply excessive tension; otherwise, the packaging belt may break.

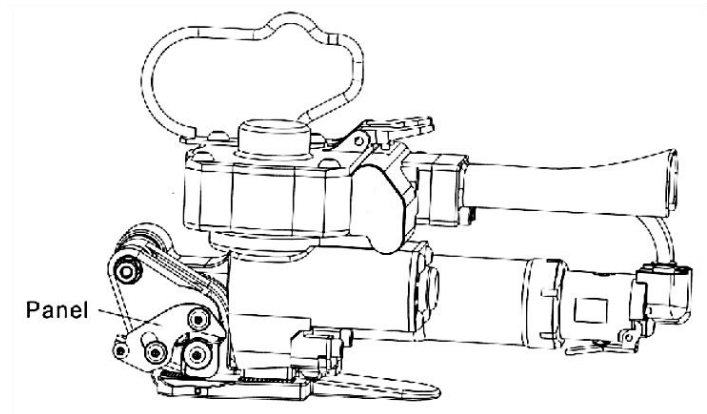
Time of friction fusion

The time of friction fusion can be adjusted according to the dimension of packaging belt, quantity of air pressure, and the condition of packaging machine. For this reason, a small screwdriver is used to adjust the small screw below the fusion button (red). The time will increase if rotating clockwise and decrease if rotating anticlockwise. Tighten the lock nut after adjustment. Sound fusion can ensure smooth and burr-free joints.

Width of packaging belt

(1) Panel

The panel can be dismantled from the packaging machine by removing its screws. Replace a new panel according to the dimensions of the used packaging belt and the installation method of the previous panel.



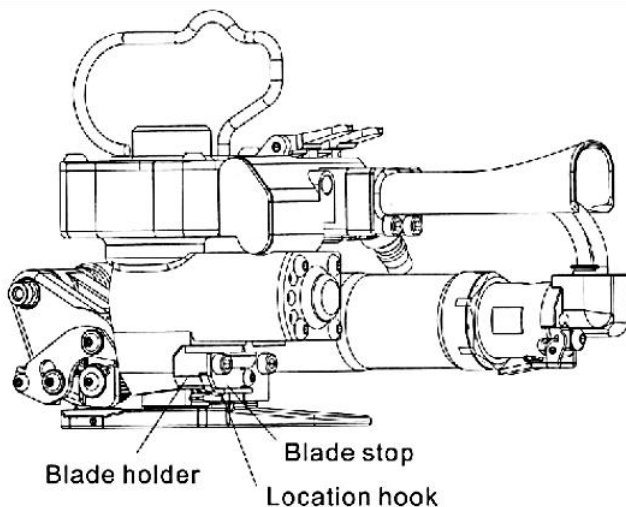
(2)Location hook

The location hook of blade holder may be reassembled by taking the spring pin from the blade holder.

Note: There is a small compression spring within the location hook. Don't lose it.

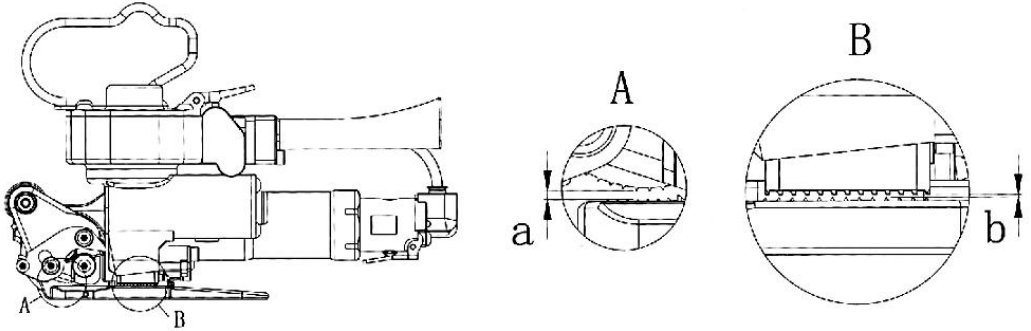
Reassembly

Choose a hole from the three holes of blade holder according to the dimension of packaging belt. The external hole is used for 19mm packaging belt; medium hole is for 16mm packaging belt; and internal hole is for 13mm packaging belt.



Distance(a)between tightening pulley and tightening toothed plate

The distance between take-up pulley and tightening toothed plate should be adjusted according to dimensions of the used packaging belt. Check the distance (a)between take-up pulley and tightening toothed plate with a feeler (as shown in the figure below).



The distance (a)should be no less than the thickness of packaging belt. While delivery,this distance is set to 1.0mm more than the thickness of packaging belt.

- (1)If the thickness of packaging belt is 0.8mm,place a 0.2mm thick gasket under the tightening toothed plate;
- (2)If such thickness is 0.6mm,place two 0.2mm thick gaskets under the tightening toothed plate;
- (3)If such thickness exceeds 1.4mm,insert two 0.2mm thick gaskets into the middle of body and bade.

Distance (b)between the bottom of vibrating bar and the fusion toothed plate

Measure the distance between the bottom of vibrating bar and the fusion toothed plate(see the above figure)with a feeler.While measuring,please follow the following steps:

- (1)Press the fusion button (red)for at least 2S,so that both piston and vibrating bar will be downward fully.
- (2)Measure the distance(b)with a feeler; if no gasket is used,the distance(b)has been set to 0.5mm.If the thickness of packaging belt is less than 0.6mm,insert a 0.2mm gasket to the bottom of fusion toothed plate.

Note:

- Don't reduce the distance (b)by inserting too many gaskets;
- The packaging machine may be damaged if there is no clearance between the bottom of vibrating bar and the fusion toothed plate;
- If the vibrating bar strikes the fusion toothed plate,teeth of the plate will be damaged immediately.

7. Failure and Trouble-shooting

Common failure and trouble-shooting:

(1) Tightener operation

| Phenomenon | Causes | Trouble-shooting |
|---|---|--|
| Motor body can't start. | <ol style="list-style-type: none">1.There is foreign material in the motor.2.The motor is too dry and in need of lubrication.3.Improper adjustment for air valve results in lack of air pressure. | <ol style="list-style-type: none">1.Deliver packaging machine to factory for repair2.Add several drops of lubricating oil to motor from air intake3.Readjust air valve |
| Tightening pulley presses the upper packaging belt. | <ol style="list-style-type: none">1.Distance between take-up pulley and toothed plate is too wide.2.In point of thickness of packaging belt, tension force is too strong.3.Take-up pulley is blocked by dust or residue from packaging belt.4.The teeth of taking-up pulley are blunt. | <ol style="list-style-type: none">1.increase gasket.2.Adjust the tension of packaging belt by adjusting air valve with a screwdriver.3.Clean the teeth of taking-up pulley with air blow gun or brush.4.Replace take-up pulley. |

| | | |
|---|--|---|
| When packing, packaging machine moves forward or can't clamp the end of packaging belt. | <ol style="list-style-type: none"> 1. Take-up toothed plate is blocked by residue of packaging belt. 2. The teeth on the take-up toothed plate are blunt. 3. The tension of packaging belt is too strong. | <ol style="list-style-type: none"> 1. Clean the teeth of take-up toothed plate, blow off the residue with air blow gun. 2. Replace take-up toothed plate. 3. Adjust throttle valve with a small screwdriver. |
|---|--|---|

Cautions during the tension operation

① After the article is tied by packaging belt, hold the overlapping part with left hand to pull out redundant part.

② Make sure the overlapping part of packaging belt in the packaging machine is in alignment.

③ When packaging, if the tension is too high, the packaging belt will break. Control the tension of packaging belt by adjusting air valve.

(2) Fusion operation

| Phenomenon | Causes | Trouble-shooting |
|--------------------------------|---|--|
| Incomplete fusion or no fusion | <ol style="list-style-type: none"> 1. Fusion time is too short 2. Air pressure is not enough 3. ID of air pipe is too small 4. The teeth of fusion toothed plate or vibrating bar is blocked by residue or worn out 5. Vibration motor is too dry and in need of lubrication | <ol style="list-style-type: none"> 1. Refer to this Manual for adjusting fusion time. 2. Supply air at the air pressure of 72psi or higher. 3. Replace the air pipe to an air pipe with an internal diameter of over 6.4mm. 4. Clean teeth part or replace vibrating bar and fusion toothed plate. 5. Add lubricating oil from air intake |

| | | |
|--|---|--|
| <p>Packaging belt is excessively fused or broken off during the Fusion process</p> | <ol style="list-style-type: none"> 1.The thickness of packaging belt is not enough 2.Fusion time is too long 3.The cooling time for friction fusion part is too short. | <ol style="list-style-type: none"> 1.Use the packaging belt that has correct specification 2.Reduce fusion time as required.Refer to this Manual 3.Keep at least 3 seconds after fusion |
| <p>Packaging machine can't move off From packaging belt after fusion</p> | <ol style="list-style-type: none"> 1.Take-up pulley can't reverse.Packaging belt can't loosen. 2.Vibrating bar fails to rise from packaging belt. | <ol style="list-style-type: none"> 1.Press rewind button to release the tension of packaging belt 2.Hold the handle of lightener to enable tightener to connect with exhaust valve,and then turn on shut-off valve |

Cautions during fusion

- ①Sound fusion can ensure smooth and burr-free joint,however,overlong fusion will reduce the adhesive force of PET packaging belt.
- ②After fusion,keep 3S,otherwise fusion joint will be deformed or separated.

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