



# Soap Warping Machine

## Operation Instructions



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## Important warning and risk considerations

- Note and pay attention to the technical parameters of the machine, especially the environmental conditions must meet the requirements.
- The machine operator must undergo strict training.
- Installation and fault inspection must be conducted by professionals.
- Before installation, check whether the various components of the machine complete.
- The machine safety instructions must be strictly observed.
- Before power connection, must carefully check the installation and connection is correct, the system must be reliably grounded.
- While the machine is running, please do not put hand on the machine belt and conveyor belt to avoid fingers injured.
- Prohibit to disassemble the machine without stop the machine, must turn off the power supply before open control box and the driving part.
- Please do not put the flammable material on the machine, lest cause an accident
- Must carefully read this manual before start the machine, please post a copy to the using site in order to safe operation
- The operators who use this machine must ensure that all work and electrical components won't cause any danger of accident or personal injury!!

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## I. The equipment Introductions

### Usage:

Suits for PE stretch film packaging for various shapes of soap, different size of soap packing without mould replacement. One person can operate two devices at the same time, reduce the manpower cost, improve the production efficiency, easy to use, the operation is simple.

The main features:

1. This machine is driven by cylinder, compact smooth operation, the packaging effect is good.
2. Packaging film automatic stretch forming! Automatic recovery!
3. Automatic convergent welding.
4. Packaging different shape and size soap no need replace the soap mold (except for very specific)
5. Drive system is simple, reliable operation, maintenance more convenient

### Technical parameters:

Packing speed	0-15pcs/min	
The soap specification	Diameter	≥40mm
	Thickness(height)	No limit
Film specification	Stretch film outside diameter	≤φ200mm
	Stretch film width	≤260mm
	Tensile membrane tube core diameter	≤φ75mm
Power	100w	
Power supply	220V	
Air pressure	5~7kgf/cm <sup>3</sup>	
Overall dimensions	2400x1000x1600mm(L*W*H)(with conveyer)	

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## II. Turn on the machine

### 1. Turn on the main power switch.



plug in charge, connect the power supply



Turn on the switch of the machine

### 2. Rotation to the right to reset the emergency stop button

(if you want to stop the machine then push the emergency stop button)



### 3. Open the air valve



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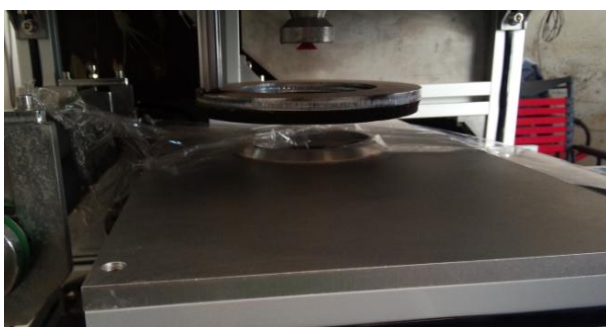
#### 4. Install the film



PE stretch film



wear the film



Across the bottom of pressing ring



Through the middle of roller



Fix the film

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### III. Control Panel & Parameter Settings



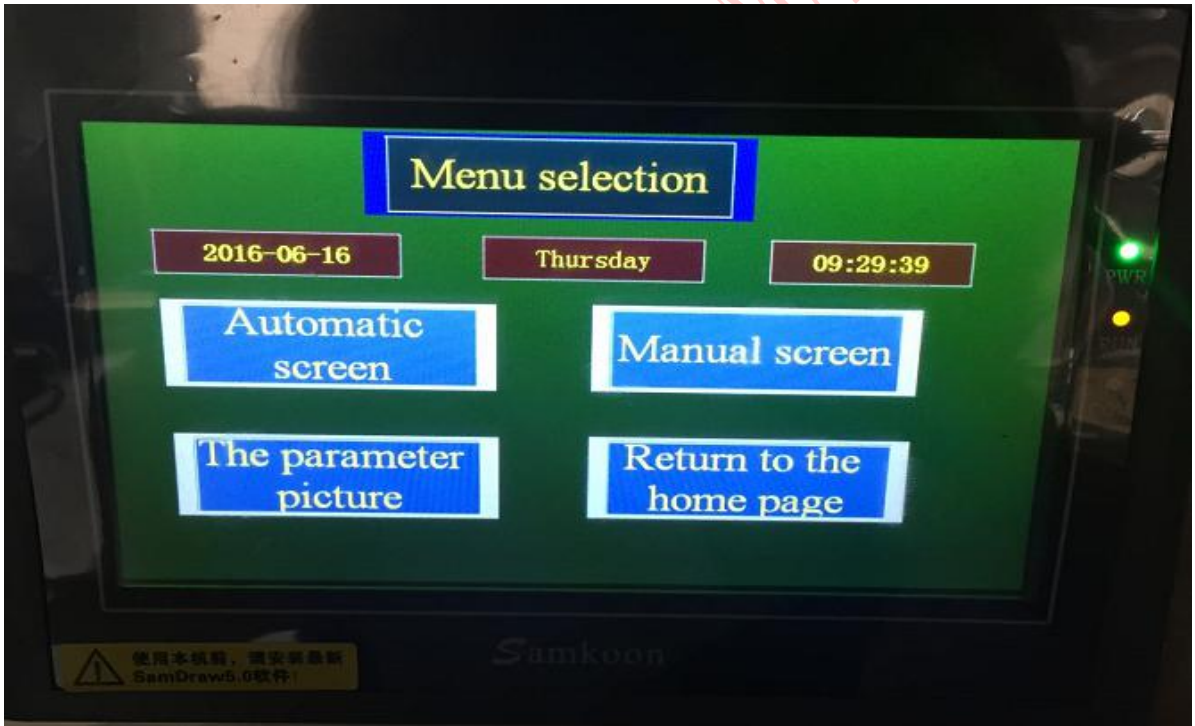
#### 1. PLC control & Parameter Setting

##### 1.1 Enter the "Programming" interface

Press "English" to choose the language version and it will go to "Menu Selection" screen .

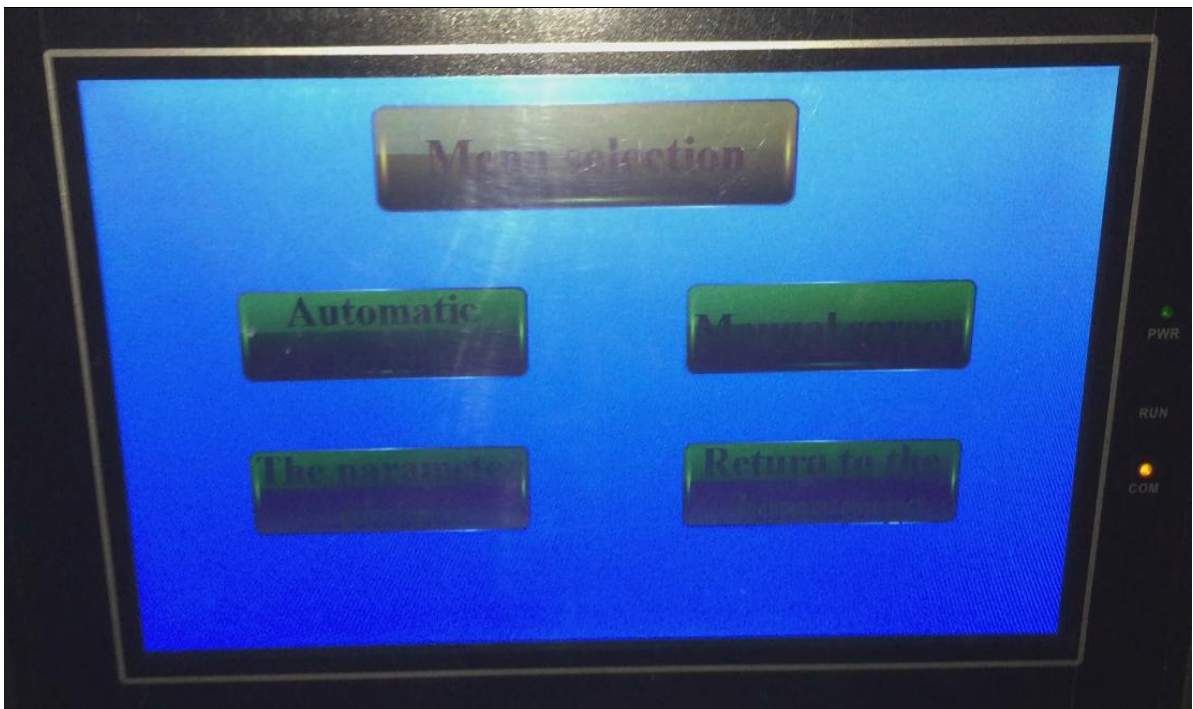


Old Operation System Version:



New Operation System Version:





**Automatic screen:** where to set the machine to automatic mode

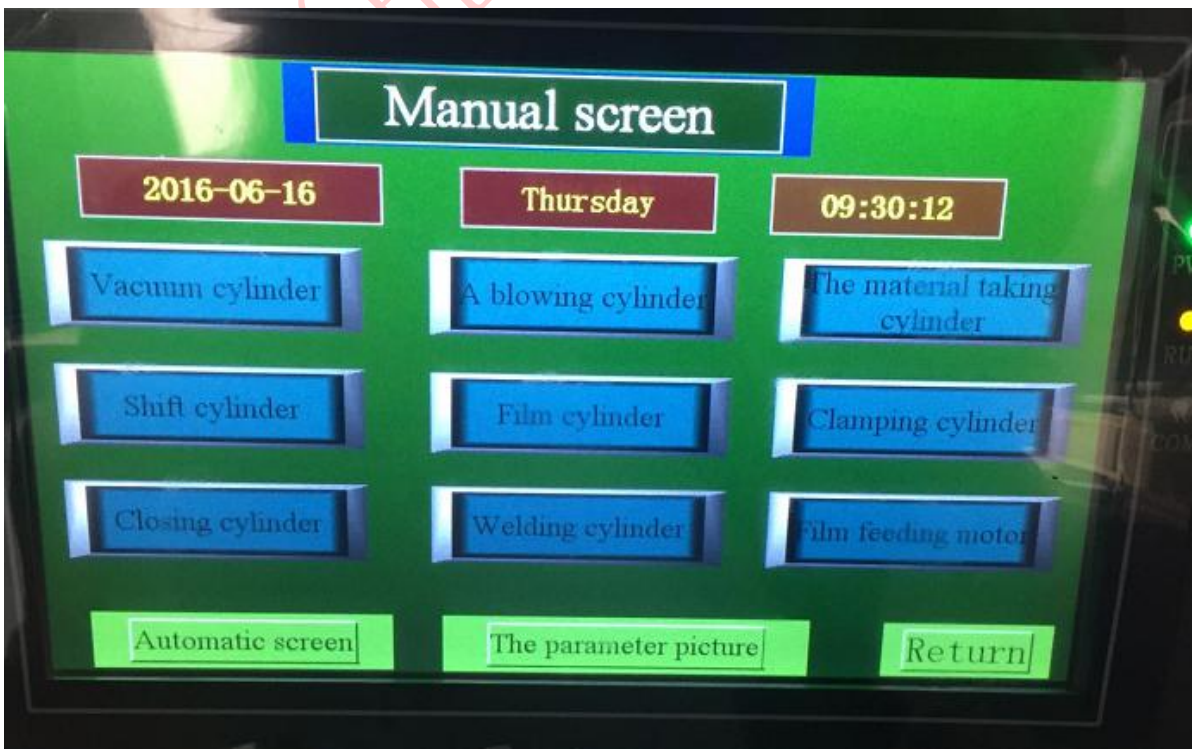
**Manual screen:** where to control the different part of the machine manually(cylinder,motor)

**The parameter picture:** where to set the parameter of the machine

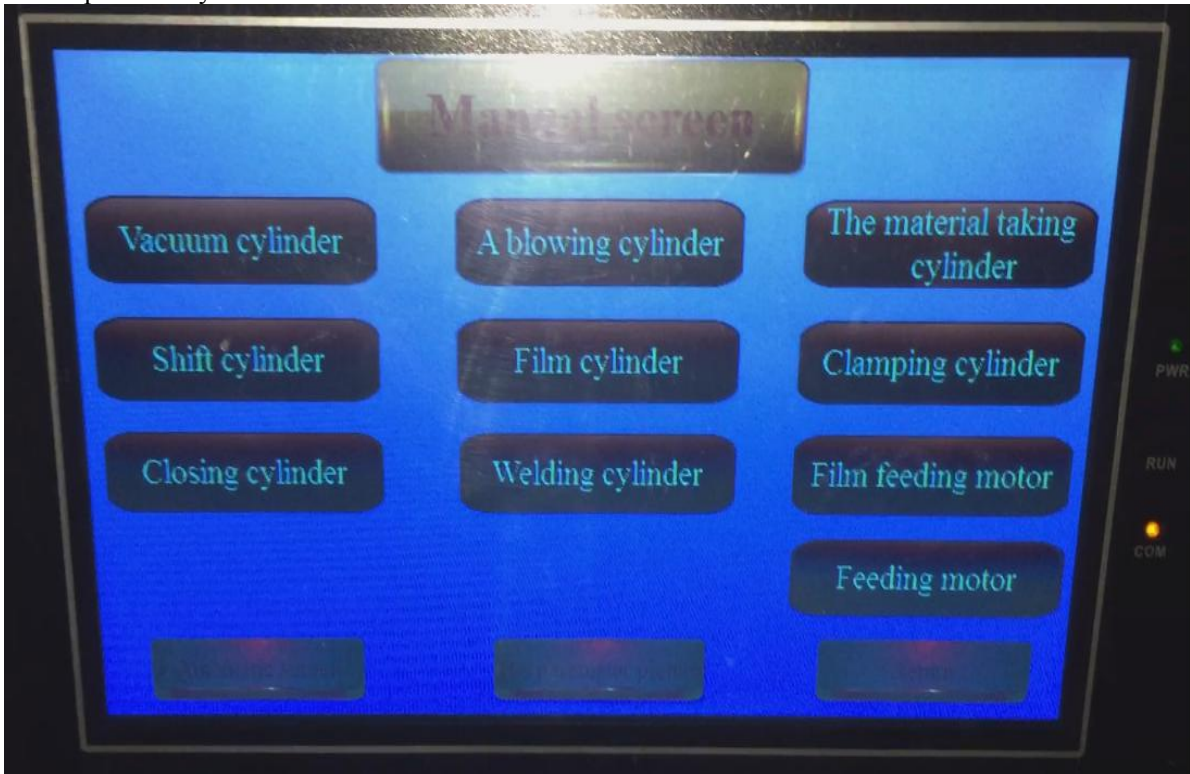
### 1.2 Enter the Manual screen

To set the time parameter according to your requirement.

Old Operation System Version:



New Operation System Version:



### 1.3 Enter the Automatic screen

Old Operation System Version:



New Operation System Version:



**Count:** count how many pieces have been produced

**Reset:** reset the count number

**Feed Conveyor belt On/Off:** turn on/off the feed conveyor belt during automatic mode.(the feed conveyor belt have been set not moving if the machine is not running in automatic mode to reduce attrition.You can manually turn on the **Feeding motor** in **Manual screen** to set the feed conveyor belt keep moving).

**START/STOP:** start/stop automatic mode

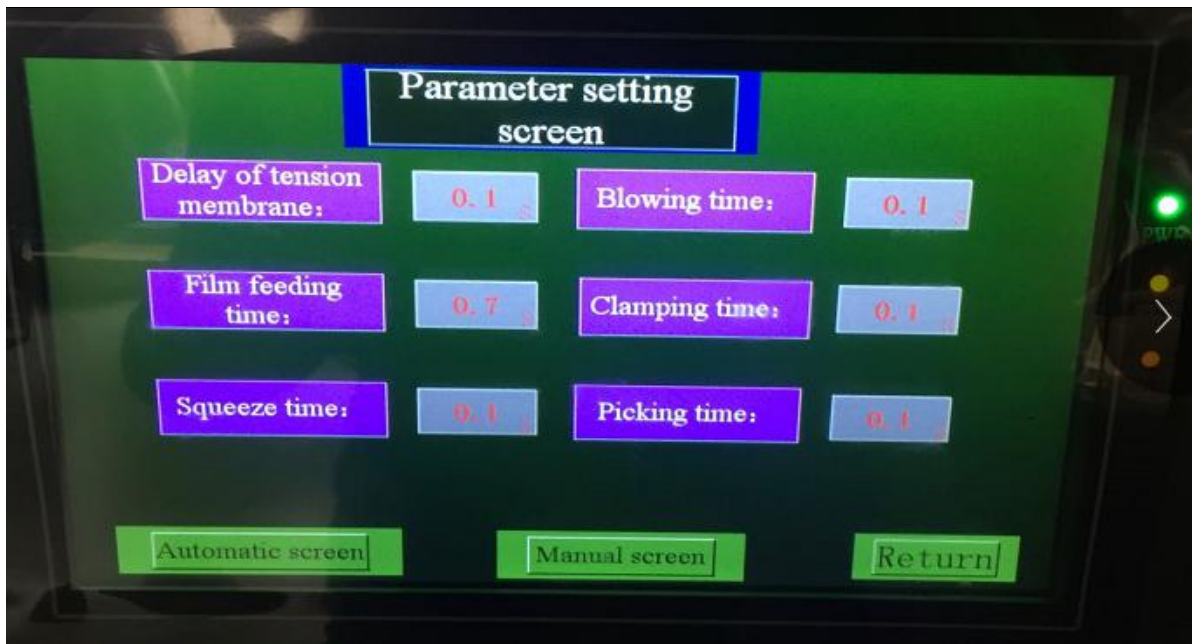
#### 1.4 Enter the Parameter setting screen

To set the time parameter according to your requirement.

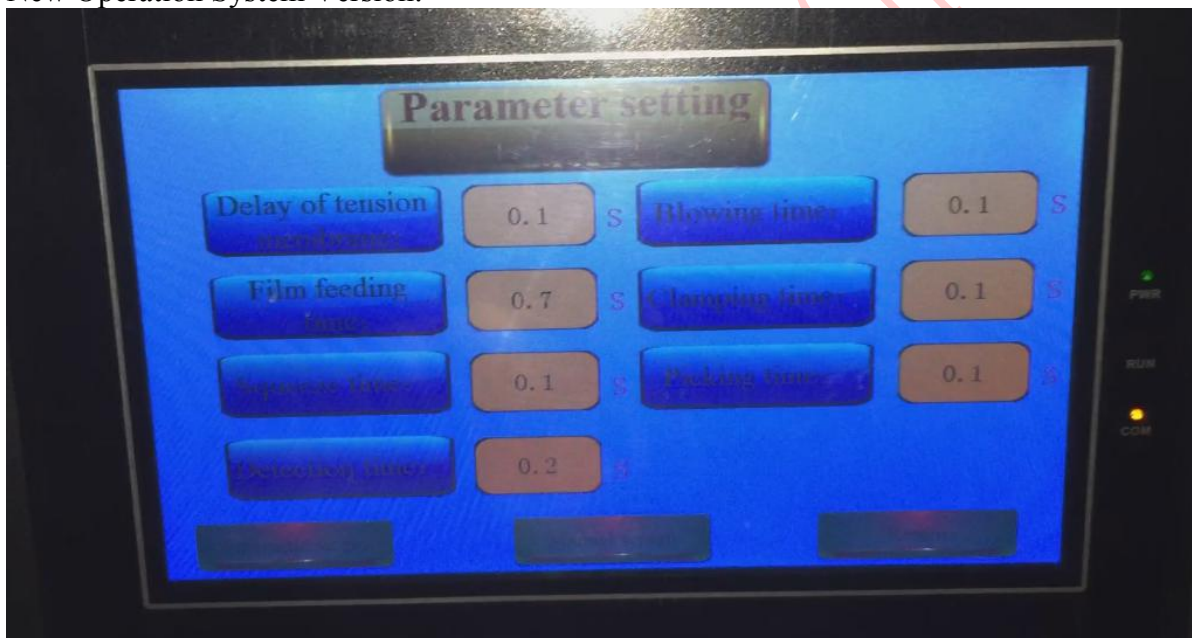
**Film feeding time:** adjust the film feeding time according to the size of the soap

**\*Please keep the rest setting as the default, to be advised by the engineer if the parameter need to be changed\***

Old Operation System Version:



New Operation System Version:



## 2. Automatically open button

Push to open the Automatic mode



## 3. PLC screen on/off button

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Turn on/off the PLC screen



#### 4. Manual off button

Manually turn off the machine, the machine will still finish the last once automatic production action after push the button, it is different with emergency stop button.



#### 5. Emergency stop button

Push the emergency stop button to stop the machine immediately. Rotation to the right to reset the emergency stop button



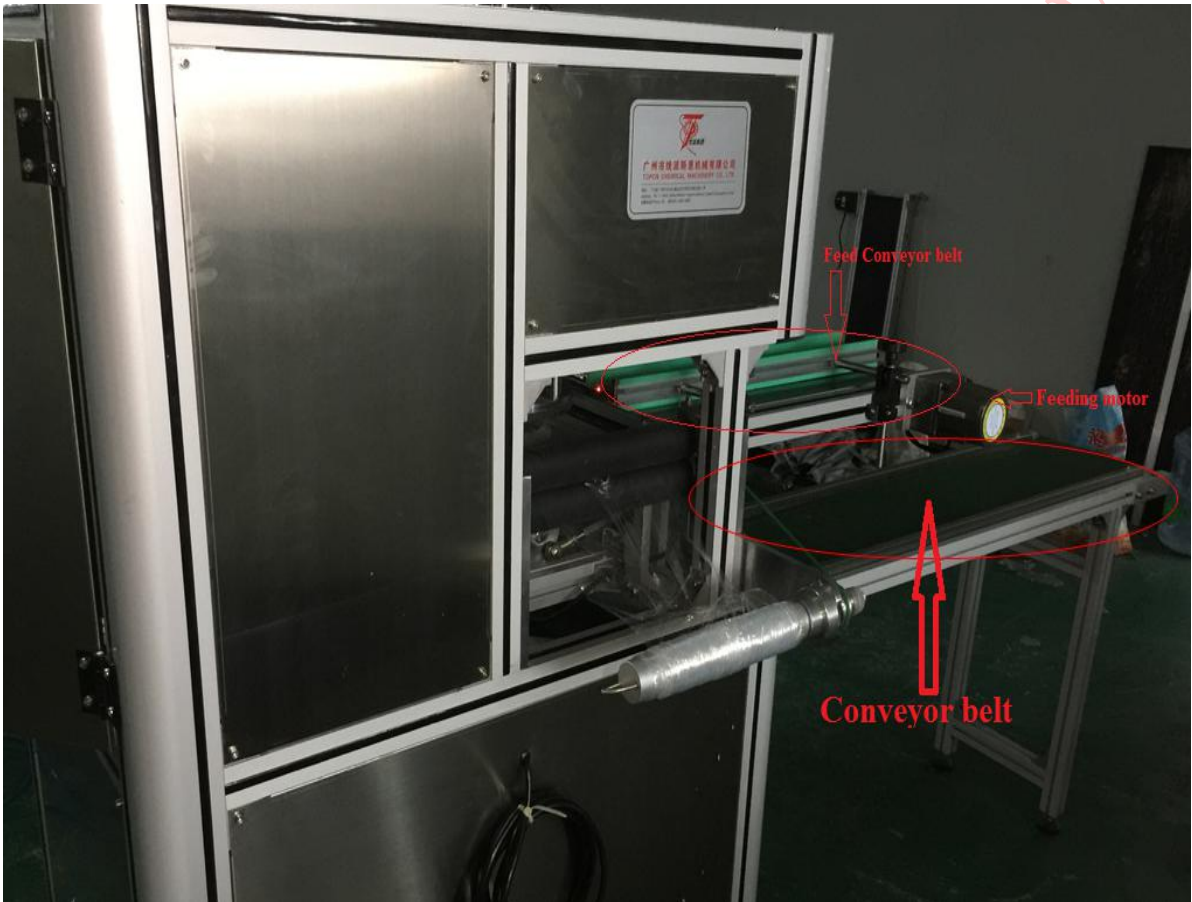
#### 6. Heating tube regulator



#### 7. Switch on the conveyor

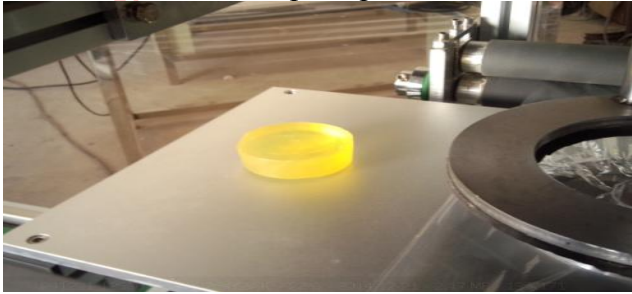
Switch on the conveyor belt for finished product, and adjust the corresponding speed.

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#### IV. Testing

Put the Handmade soap in specified location



Open automatic mode, try to pack

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### 1. If there are air bubbles

Then adjust as below: adjust it to be a **little bit** lower(better to be advised by engineer)



Unscrew -> adjust it to be a little bit lower -> screw it again

If can't pack well after the adjustment, then adjust to the opposite way.

### 2. If the film is broken

Adjust the place below a **little bit** if the film is broken because of film too tight or not well packed because of film too loose.(better to be advised by engineer)

Too tight adjust press plate upper,too loose adjust press plate lower



Unscrew -> adjust press plate upper or lower -> screw it again

### 3. If the sealing point is not good

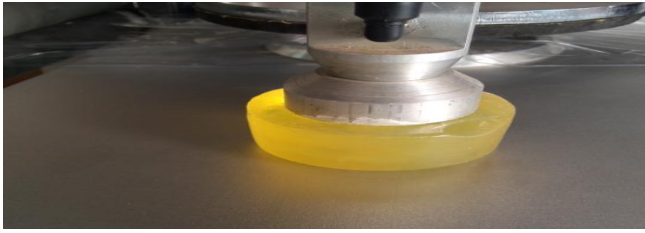
Adjust the place below a **little bit** if the seal point is not good(better to be advised by engineer)



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Unscrew -> adjust cylinder screw mandrel -> screw it again

Adjust till everything are okay , then try to pack again



Check the effect after pack



If it is okay, then the adjustment is okay. If not, then adjust again base on the finished pack.

**\*\*Feel free to contact us if you need help on above adjustment, better to be advised by the engineer before any adjustment\*\***

## **V. Turn off the machine**

1. Press the "STOP" button to make the machine stop running, and then shut off the main power switch button
2. Encounter emergency can directly push "emergency stop" button
3. If do not need to operate the machine for a long time, must to unplug the power cord, clean the entire surface of the machine, and covered with dust cover

## **VI. Maintenance**

The machine operator must go through training before operate the machine. In order to make the best use of this machine, the operator must pay close attention to the operation of the machine during the machine is running and must have regular maintenance to the machine.

Maintenance on the following guidance:

1. Daily maintenance

Daily before start the machine:



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- 1) Before daily power-on, should check to see whether there is sundry, such as: wrench, screwdriver, etc
  - 2) Observe the power supply, air source condition if is normal, the power cord, trachea, to see if there is any breakage.

Daily before get off work:

Every day before get off work should shut off power supply and air source, after confirmed the power has been disconnected then must to do the following work:

- 1) To clean the machine, can use the dry soft cloth to wipe the surface of the machine,if there is more dust where can't be wiped, purge with compressed air.
- 2) When wiping the machine, pay attention if there is a loose screw. The loose screw should be screwed tightly immediately.

## 2. Regular maintenance

Every year should do the maintenance for the machine, the transmission gear, and guide, clean-up dirty oil, coated with new oil.

## VII. Common problem analysis

Phenomenon	Reason	Solution
The film cant move	Check if the film feeding motor stuck the film	Re-install the film
If can't seal	Check if the heating pipe is break or not	Change the heating pipe
If the conveyor belt can't move	Check the speed adjuster or the conveyor motor	Turn the speed adjuster faster/ replace conveyor motor

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## Enclosure:

For the irregular shape soap, we have to feed the soap manually. Since the new operator is not familiar with the production process in automatic mode of the machine, we could adjust the moving speed of the cylinder slower to get enough time for us to feed the soap. We could adjust the moving speed of the cylinder faster to increase productivity once we could manually feed the soap follow by the automatic mode.

