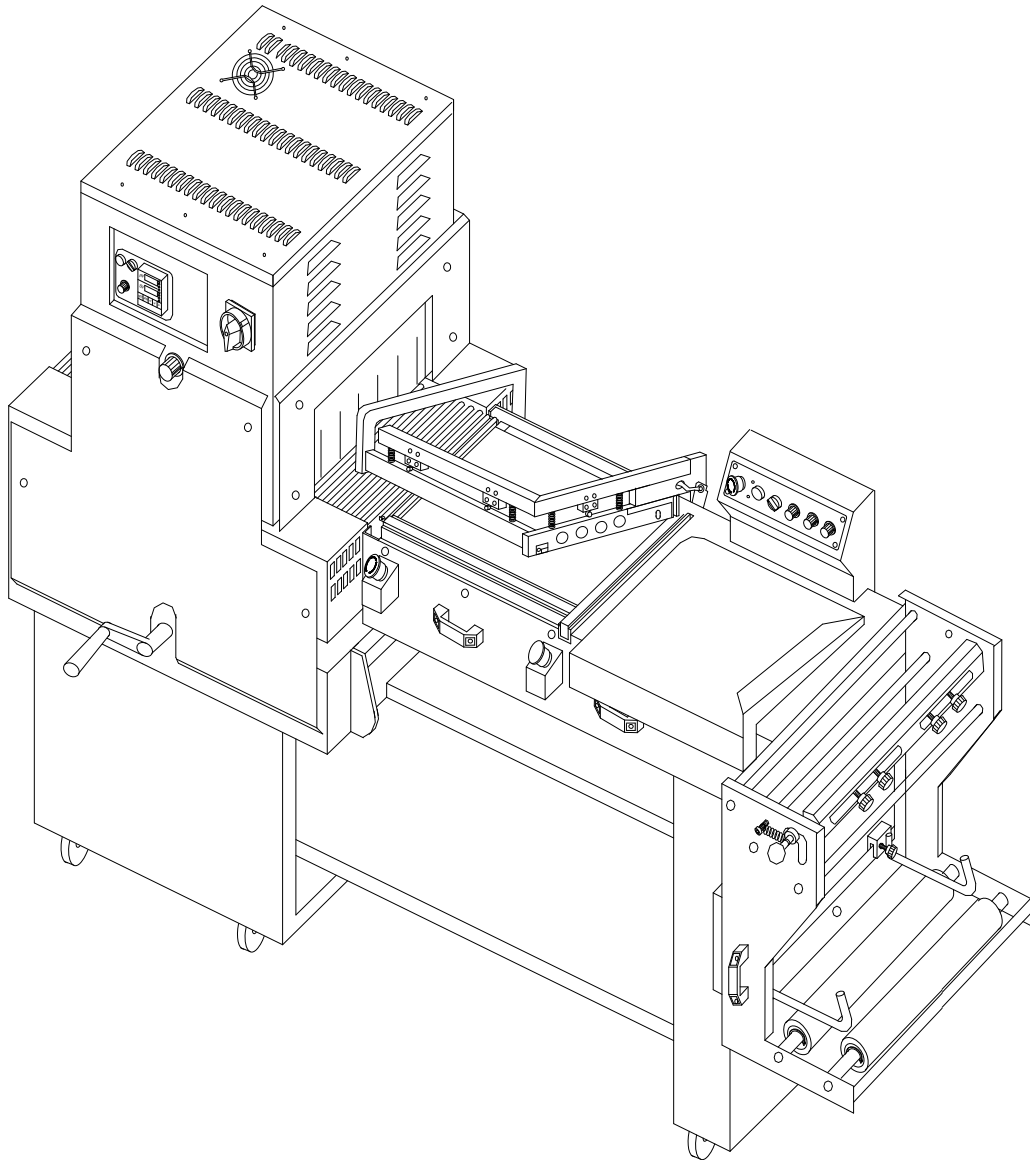




SEMI-AUTOMATIC SEALER AND SHRINKING MACHINE

OPERATION MANUAL

EKL-455PT



2013.08.06



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Safety Instruction

Please read the manual and instructions carefully before operating machines.
Careful reading brings the safety operation.

General Safety:

1. Before operating and maintaining the machines please read the manual and instructions carefully.
2. Please check the power supply is suitable to machine electronic specifications.
3. Please not maintain and fix machine while the machine is working and operating.
4. Please not clear and wipe the machine by water and steam.
5. Please mind operator body and hand away from warning place in machine.
6. Please not change the spare part that is incompatible with machine.
7. Please switch off the power while maintaining the machine.
8. Please keep machine away from flammable and explosive places.
9. Please not wrap the flammable package in machine.
10. Please follow the warning stickers and instructions in machine seriously.

Machine Description

Semi Auto L-Sealer & Tunnel machine is a complete system crafted by integrating a quality L-Sealer with high performance shrink tunnel which is able to apply on the film material: POF and PVC.

The machine comes with two different types: Manual and Automatic models.

Standard feature of this machine include of high quality heating components with the facility of heat circuit and have thermostatically controlled heat, variable conveyor speed and manual seal bar hold down

It surpasses comparable machines in performance, flexibility and value. It can be used for a variety of applications including: Cosmetic, Electronics, hardware and light industries.

Machine Specification

Model number	EKL-455MT & EKL-455PT
Power Supply	400V 50hz –3Phase , 220V 60HZ-3Phase
Power Max	9Kw
Air Pressure	3.5~4.5 Kg/Cm2
Working Table Height	900mm
Max Film Roll Dimension	φ 300*600
Sealing Bar Dimension	400mm (w) x 550mm (D)
Max Packing Height	150 mm
Weight of the machine	400Kg
Film materials	POF & PVC

Machine Accessories

The Following Spare parts and Tools come along with machine:

1. Teflon tape. 1
2. Sponge bar..... 2
3. Heating blade. 1
4. Red tube. 2

Tools:

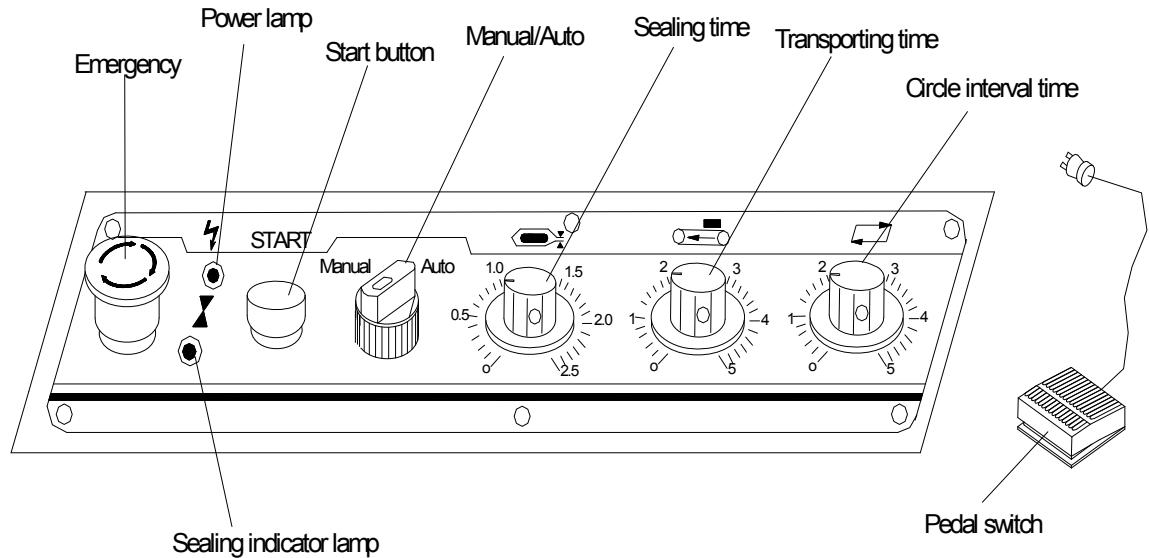
1. Screw driver. 1
2. 8mm-10mm Open wrench (273C01-0810). 1
3. Allen wrench 2.5#-6#. 1 (each)

Recommending Spare Parts:

1. Spring (2210893025)
2. Teflon tape (297f0072)
3. Silicon bar-A (7B-01000-200)
4. Silicon bar-B (7B-01000-210)
5. Heating blade (7B-04000-340)
6. Heating bar (7B-04000-300)
7. Heating bar (7B-04000-310)
8. Insulation spacer (7B-04000-350)
9. Nylon spacer (7B-04000-360)
10. Insulation tube (7B-04000-360)
11. Heater (7E-04010-180)

Operation of Control Panel

A. Control Panel



1. Emergency button--- switch off 24V power
2. Power indicator lamp ---It is light when the machine power is ON.
3. Sealing indicator lamp ---It is light while sealing.
4. Start button with indicator lamp ---to press the start button, then the indicator lamp is on; the machine is ready to be operating.
5. Manual and Auto mode
 - a. Manual mode, to press the start button, the machine will seal only once.
 - b. Auto mode, to press the start button, the machine will seal Constantly.
6. Sealing Time Dial: There is 5-reference number for adjusting the sealing time.
7. Transporting time Dial - There is 5-reference number for adjusting the transporting time.
8. Circle interval time adjustment
To adjust put packaging: set 0-5s (according to the operator and the size of packaging.)
9. Pedal switch--- Operate the machine by pedal

.B. Control Panel of Tunnel

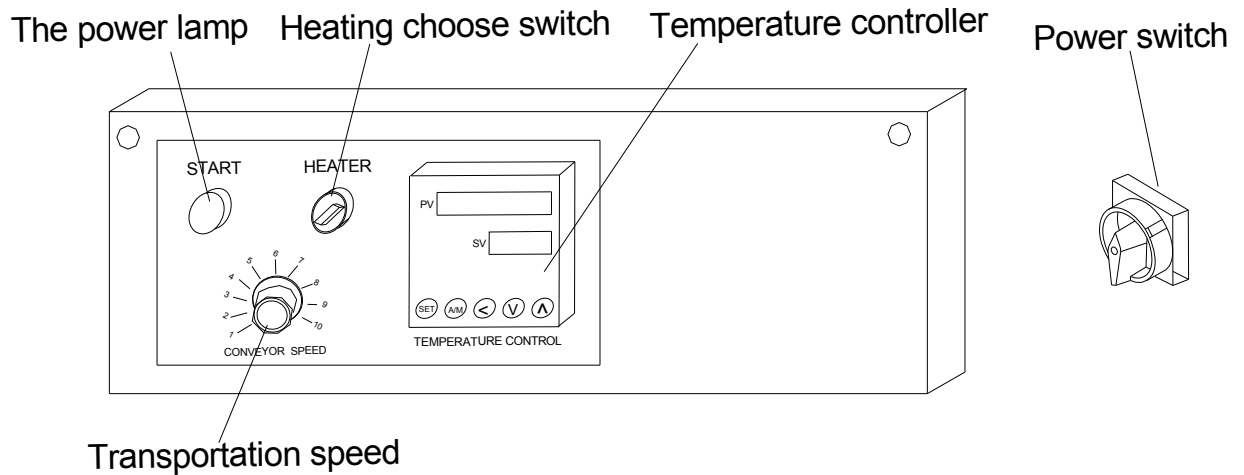


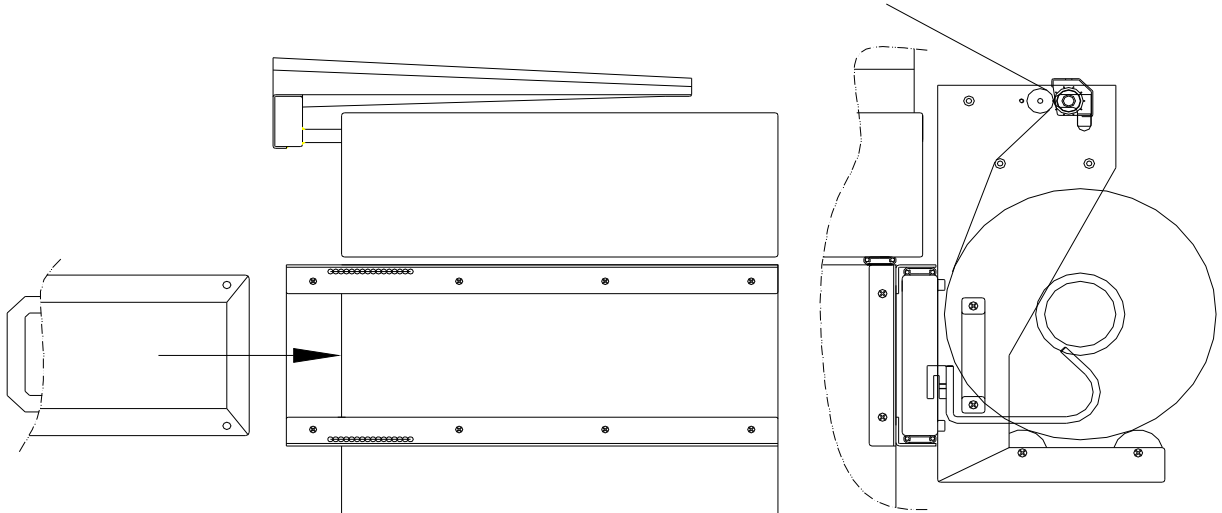
FIG.2 Control panel

1. Power: Indicating Tunnel power
2. Start indicator lamp: Light is on when the tunnel is working.
3. Heating switch with indicator lamp-----ON: heating; OFF: stop heating
4. Roller Conveyor speed adjustment--- Adjusting the Conveyor speed
- Temperature controller: setting the temperature on the tunnel (General set for 130-170°C)
5. Press \angle to set temperature, press \square to increase temperature while the temperature number is flashing, press \square to decrease the temperature, and then to press Set to memory the setting.

Installation

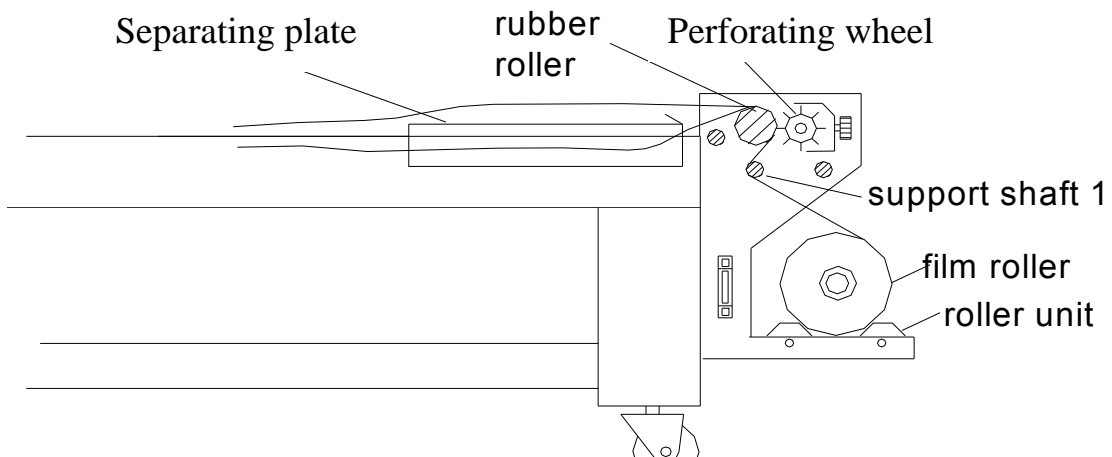
1. Installing Film supporter

- (1). Install the Film Supporter with machine parallel, according to drawing. Make sure Film supporter moving smoothly on tracking guide.
- (2). Tighten 6 of M8 screws and make sure the film supporter fix on machine
- (3) Install Film supporting Shaft
- (4) Install Handle Crank to adjust the Tunnel Height.



2. Install film

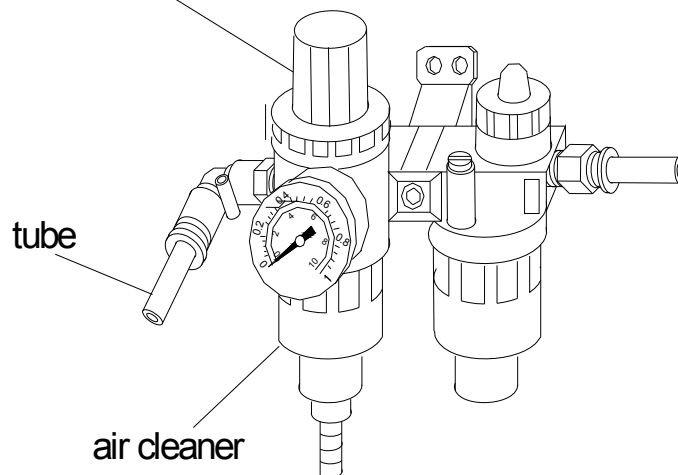
1. Put the film on the Film Supporting shaft.
2. Opening perforator
- 3 Installing the film according to the route of Film Supporting shaft.
4. Back position of Film Supporter
5. Dividing the film into two layers, cross the separator.



3.The connection of air pressure

1. Connecting the Air tube $\varnothing 8$ on air pressure
2. Switch on the pressure adjusting valve and set the necessary required press
3. By adjusting the screws let cylinder to have proper cushion release

pressure adjusting vavle



4. Connect the machine power and switch on the heating power on Tunnel.
5. Press the Start Button, and the green indicator light is on. The machine is ready to be operating.
6. Switch the heating power on and Tunnel starts heating and set the required temperature.
7. Tunnel reaches the required temperature (about 10 minutes)
8.
 - a. Please adjust the position of film supporters and separator
 - b. Set the position of sealing line. (Adjusting the height of working table and let the package at the middle of sealing line for the good shrinking results.)
 - c. Adjusting the inside height of tunnel and let package enter smoothly.
9. Put the package on the separating table (Between the two layers of film), pull the package with films on the working tables. The front and side distance with Package on the working table is 10mm and let the film status as fluffy not too tight. (The sealing time will be various according to different film materials) The general setting of sealing time like 0.7s ~ 1s, Machine working hour is longer and sealing time is shorter.
10. Package will be transporting to Tunnel to start the shrinking after sealing

Advantage and feature

Advantage and feature of the machine

1. Heat Sensing protector on the motor (90°C)

After overload long hour work, the temperature of machine's motor might over the limited temperature and Heat Sensing protector will work and stop heating automatically.

2. Automatic Stop running function

After long hours work, the component and machine are under the high temperature situations. In this case, if turn off the machine immediately it will reduce machine's working life. Please switch the heating power off and till temperature down to the accepting temperature (Heating sense protecting will sense and stop the motor.

Adjustment

The Adjustment of Transporting Belt

1. By tighten and losing the screws to adjust the belts to make sure belts run smoothly without sliding. In general, the belts are closed to the same side that the screw has been adjusting (tighten and lose)

2. The adjustment of sealing clearance

In order to get good sealing results, the sealing blade must stick with silicon bar perfectly. The clearance is able to adjust by M10 screw that tight on rubber plate of the aluminum seat.

3. The adjustment of Air Velocity. In order to have good shrinking results, please adjust the air velocity according to the shrinking performance. If shrinking is too over please decrease the air velocity and shrinking is uncompleted please increase the air velocity.

4. The transporting speed adjustment

In order to have the good shrinking results please adjust the transporting speed by adjusting the speed dial. If shrinking is too over please decrease the transporting speed and shrinking is uncompleted please increase the transporting speed.

Maintenance

It is helpful to extend machine working life and circle by regular Maintenance.

1. Please use special outlet, the ground protect line must be strong and firm.
2. Please check chain roller regularly; make sure the roller running smoothly.
3. Please clean dust and stain regularly
4. Please wipe conveyor roller frequently keep the machine clean.
5. Please not increase temperature constantly while the machine is working.

Please switch the power off as soon as you find trouble, and let the maintenance operator to check and repair

6. Please switch off the power while maintaining the machine.

Trouble shooting and solution

Trouble	Cause	Solution
The film is broken	Perforator is not working Properly.	Adjusting Perforator
Conveyor belts not moving	<ol style="list-style-type: none"> 1. Motor & Capacitance are damaged 2. The belts are too tighten 	<ol style="list-style-type: none"> 1. Changing motor & capacitance 2. Loosen the belts
The sealing hood bounce back without sealing	The micro switch has not contacted	Adjusting the micro switch
The sealing hood is unable to be pressing down	<ol style="list-style-type: none"> 1. Air Cylinder is not working 2. the electrical valve is power off 3. the safety switch is on 	<ol style="list-style-type: none"> 1. Check air Cylinder 2. Check Electrical valve 2. Check safety switch
No heating	<ol style="list-style-type: none"> 1. Heat sense protector is off 2. The heat switch is off 3. The connector is damage 4. The temperature controller is broken 	<ol style="list-style-type: none"> 1. Turn on protector 2. Turn on switch 3. Change connector 4. Change temperature controller
The heating time is too long	Heating elements is damaged	Change heating elements
Conveyor belts does not rotate	<ol style="list-style-type: none"> 1. motor, capacitance damaged 2. Conveyor roller are stock 3. electronic controller speed is damaged 	<ol style="list-style-type: none"> 1. Change capacitance 2. repair and adjustment 3. change electronic speed controller
Motor not run or in reverse	Capacitance damaged	Change Capacitance

Note: The trouble caused by electricity. Please repair it by the professional operator according to the circuit diagram, the others issues are not repairable please contact supplier in time.

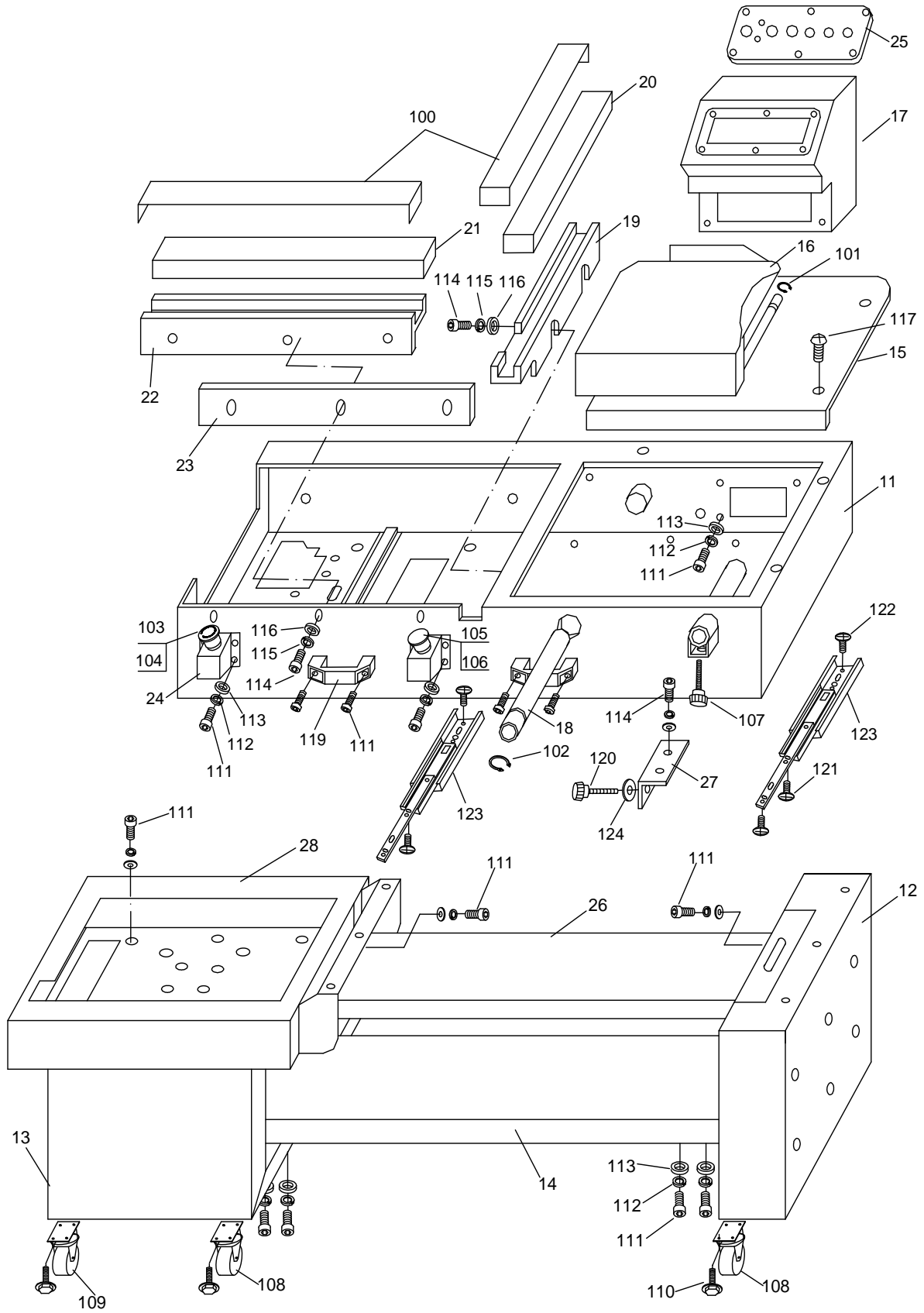
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PARTS LIST, FIGURE 1-2 CABINET(1) UNIT

KEY	QTY	PART NO.	DESCRIPTION	LST-4055P-012
11	1	7B-01200-110	Cabinet	
12	1	7B-01200-120	Support	
13	1	7B-01200-130	Caster fixed box	
14	1	7B-01200-140	Connect support	
15	1	7B-01000-150	Cover	
16	1	7B-01000-160	Seperator	
17	1	7B-01200-170	Electrical control box	
18	1	7B-01000-180	Seperator guide	
19	1	7B-01000-190	Silicon bar seat(1)	
20	1	7B-01000-200	Silicon bar	
21	1	7B-01000-210	Silicon bar	
22	1	7B-01000-220	Silicon bar seat(2)	
23	1	7B-01000-230	Spacer	
24	2	7B-01000-240	Button support	
25	1	7B-01000-250	Operation plate	
26	1	7B-01200-260	Connect support	
27	1	7B-01200-270	Connect small plate	
28	1	7B-01200-280	Supporting table	
100	1	297F0072	Teflon tape,0.18*19*2000mm	
101	1	212AS16	Ring,S-16	
102	1	212AS20	Ring,S-20	
103	1	104K001	Stop buttonZB2-BS54-R	
104	1	104K001-1B	Connecting points,ZB2-BZ102-1B	
105	1	104F201	Start button ZB-BC3C	
106	1	104F201-1A	Connecting point unit,ZB2-BZ101C	
107	1	200R06025	Star-type handle,M6*25	
108	4	229A075PU-BK	Wheel,swivek 75mm	
109	2	229C075PU-BK	Wheel fixed 75mm	
110	16	200M06012	Hex bolt with washer,M6*12	
111	29	200A06016	Socket head cap screw,M6*16	
112	29	202B06	Lock washer,M6	
113	29	202A0612	Plain washer,M6*12	
114	18	200A08020	Socket head cap screw,M8*20	
115	18	202B08	Lock washer,M8	
116	18	202A0816	Plain washer,M8*16	
117	3	200H06012	Truss head machine screw,M6*12	
119	2	297J085120	Handle	
120	1	200R10040030	Star-type handle,M10*40*30	
121	6	200E04008	Philips head machine screw,M4*8	
122	6	200E05008	Philips head machine screw,M5*8	
123	2	210K33012500	Slide guide 3301-2500	
124	1	202A1020	Plain washer,10*20	

FIGURE 1-2: CABINET(1) UNIT



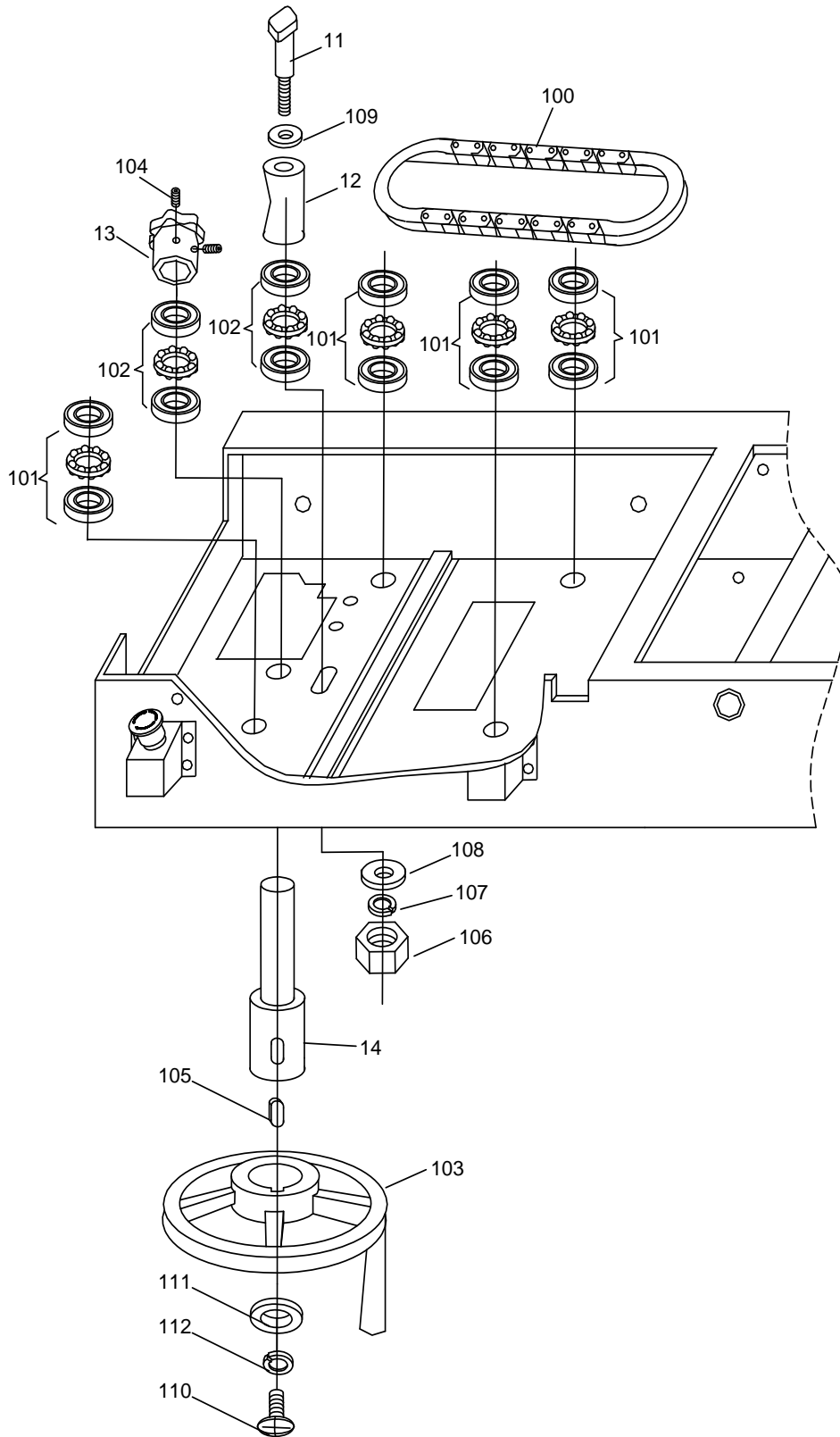
PARTS LIST, FIGURE 2 DRIVE TABLE UNIT

KEY	Q'TY	PART NO.	DESCRIPTION	LS-4055-020
11	1	7B-02000-110	Conveyer bracket	
12	1	7B-02000-120	Up and down bracket	
13	1	7B-02000-130	Support plate	
14	1	7B-02000-140	Bearing house B	
15	1	7B-02000-150	Bearing house A	
16	2	7B-02000-160	Bearing house C	
17	1	7B-02000-170	Chain wheel	
18	1	7B-02000-180	Driving roller	
20	1	7B-02000-200	Driving chain wheel	
21	1	7B-02000-210	Motor bracket	
22	1	7B-02000-220	Chain wheel cover	
23	1	7B-02000-230	Bracket 1	
24	1	7B-02000-240	Bracket 2	
25	4	7B-02000-250	chain wheel	
26	2	7B-02000-260	Conveying shaft	
27	1	7B-02000-270	Driven roller	
28	2	7B-02000-280	Heat-resistant tube	
29	4	7B-02000-290	Screw	
100	1	101G23500025-15	Reducer motor,220-240V/50-60Hz,25W,1:15	
101	1	215A0308-38	Chain,3/8"	
102	5	202F152204	Plastic circllet,M15*22*4	
103	4	210A6001ZZ	Ball bearing,6001ZZ	
104	1	214M1307361018	Belt,1307(C)*361(W)*1.8	
105	4	201A12	Hex nut,M12	
106	1	201N12	Nut,M12	
107	8	200A06020	Socket head cap screw,M6*20	
108	8	202B06	Lock washer, M6	
109	8	202A0612	Plain washer, M6*12	
110	9	200H04008	Truss head machine screw,M4*8	
111	2	200C05025	Hex bolt,M5*25	
112	2	202A0510	Plain washer, M5*10	
113	4	200G06008	Socket head set screw,M6*8	
114	6	200H05012	Truss head machine screw,M5*12	
115	4	200A06012	Socket head cap screw,M6*12	
116	4	200C06012	Hex bolt,M6*12	

PARTS LIST, FIGURE 3 DRIVE TABLE (UP&DOWN) ADJUSTMENT UNIT

KEY	QTY	PART NO.	DESCRIPTION	LST-4055-030
11	1	7B-03000-110	Tensive roller shaft	
12	1	7B-03000-120	Tensive roller	
13	1	7B-03000-130	Chain wheel	
14	1	7B-03000-140	Handle wheel shaft	
100	1	215A0308-184	chain,3/8"	
101	4	210L51101	Bearing,51101	
102	2	210L51100	Bearing,51100	
103	1	297M12125B	Hand-whwwl	
104	2	200G06008	Socket head set screw, M6*8	
105	1	213A0404016	Key,4x4x16.	
106	1	201A08	Hex nut,M8	
107	1	202B08	Loxk washer,M8	
108	1	202A082230	Plain washer,M8*22*3	
109	1	202A0816	Plain washer,M8*16	
110	1	200H06012	Truss head machine screw,M6*12	
111	1	202A061620	Plain washer.M6x16	
112	1	202B06	Lock washer,M6	

FIGURE 3: DRIVE TABLE(UP&DOWN) ADJUSTMENT UNIT



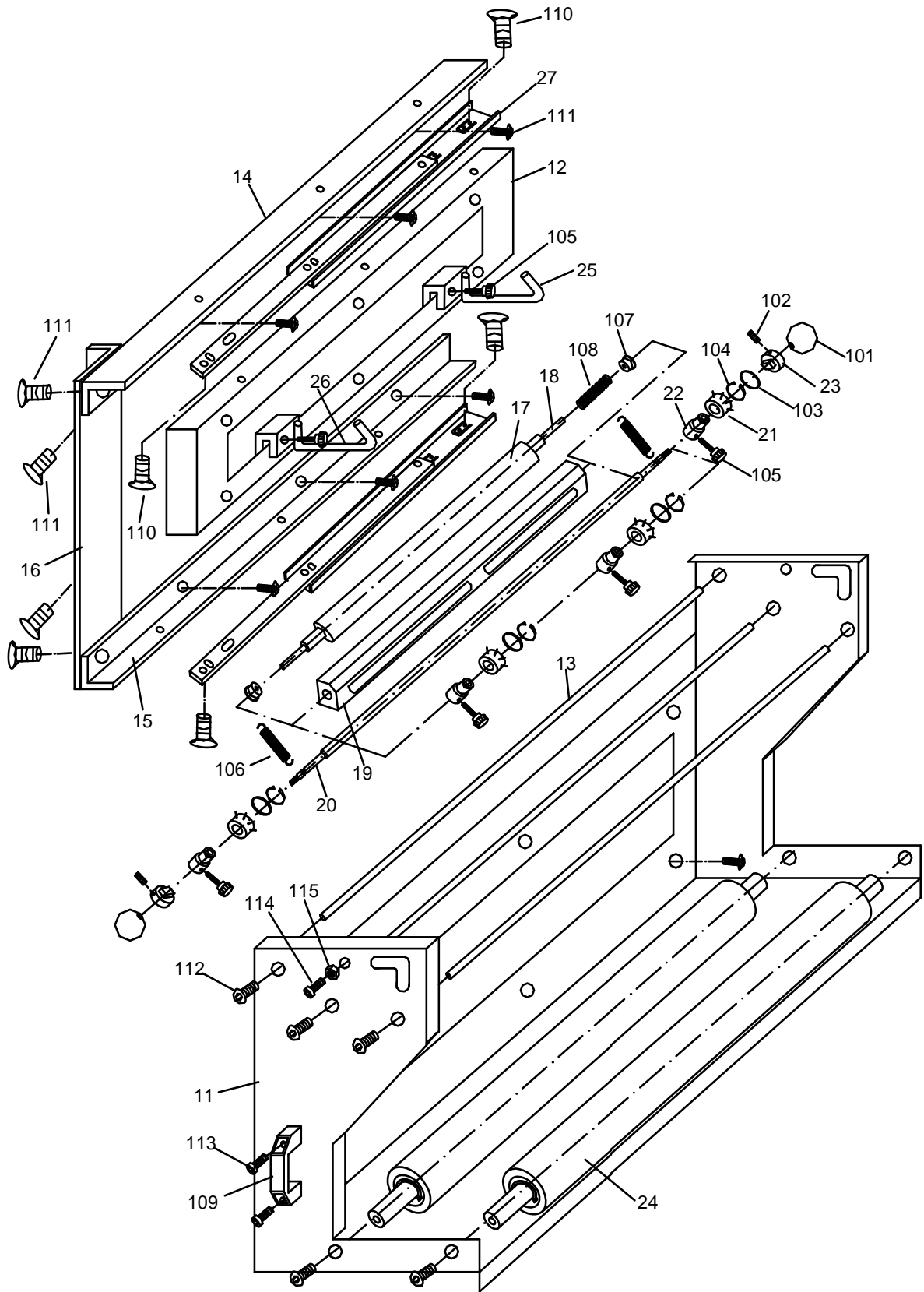
PARTS LIST, FIGURE 4-2 SRALING FRAME UNIT

KEY	Q'TY	PART NO.	DESCRIPTION	LST-4055P-042
1	1	7B-04010	Cylinder base unit	
2	1	299R-AFC2000	Pneumatic components unit	
11	1	7B-04200-110	Arch arm	
12	1	7B-04200-120	Arm	
13	1	7B-04000-130	Arm shaft	
14	1	7B-04000-140	Bracket	
15	2	7B-04000-150	Hrating blade clip block	
16	2	7B-04000-160	Nylon spacer	
17	2	7B-04000-170	Clip block guider	
18	2	7B-04000-180	Bearing pad	
19	1	7B-04000-190	Connecting plate	
20	1	7B-04000-200	Connecting pin	
21	1	7B-04000-210	Wire chute 1	
22	1	7B-04200-220	Wire chute 2	
23	3	7B-04200-230	Switch bracket	
24	3	4-02000-270	Plate	
25	4	7B-04000-250	Screw	
26	1	7B-04000-260	Heating bar cover 1	
27	1	7B-04000-270	Heating bar cover 2	
28	1	7B-04000-280	Hrating bar seat 1	
29	1	7B-04000-290	Hrating bar seat 2	
30	1	7B-04000-300	Heating bar 1	
31	1	7B-04000-310	Heating bar 2	
32	1	7B-04000-320	Bronze joint	
33	1	7B-04000-330	Joint seat	
34	1	7-05000-250	Heating blade	
35	2	7B-04000-350	Insulation spacer	
36	2	7B-04000-360	Insulation tube	
100	1	299B-QGB63175	Cylinder,Φ63*175	
101	1	210JSI16TK	Joint bearing,16*1.5	
103	2	299K-JSC802	Throttlw valve	
104	2	299N-SL018	Silencer	
105	1	299E-4V21008	Vavle	
106	2	299J-PC802	Straight joint	
107	3	299H-PL802	Square bent	
108	2	210GUBPP20518	Bearing,UBBP205-18	
109	2	273N-PG16	Pipe joint	
110	1	153W-212	Ripple pipe	
111	6	200E03020	Phillips head machine screw ,3*20	
112	11	202B08	Lock washer,M8	
113	11	202A0816	Plain washer,M8*16	
114	1	201A08	Hex nut,M8	
115	12	200A08020	Socket head cap screw,M8*20	
116	9	200G08016	Socket head set screw,M8*16	
117	1	200C06020	Hex bolt,M6*20	
118	1	201A06	Hex nut,M6	
119	2	200A06012	Socket head cap screw,M6*12	
121	2	200A04050	Socket head cap screw,M4*50	
122	2	2210975061	Spring, 0.9*7.5*61.5	
123	13	200H04008	Truss head machine screw,M4*8	
124	2	200E03012	Phillips head machine screw ,3*12	
125	6	200A05012	Socket head cap screw,M5*12	
126	3	104GV151A5	Microswitch,V-15-1A5	
127	4	2210893025	Spring, 0.8*9.3*25	
128	10	200G03003	Socket head cap screw,M3*3	
129	2	200A04016	Socket head cap screw,M4*16	
130	6	202B05	Lock washer,M5	
131	6	202A0512	Plain washer,M5*12	
132	1	200G03012	Socket head sets screw M3*12	
133	1	201A03	Hex nut,M3	
135	2	200H05015	Truss head machine screw,M5*15	
136	2	200H04035	Truss head machine screw,M4*35	
137	4	200F03008	Flat head cap screw,M3*8	

PARTS LIST, FIGURE 5-2 REEL CARRIER UNIT

KEY	Q'TY	PART NO.	DESCRIPTION	LST-4055-052
11	1	7B-05200-110	Film holder body	
12	1	7B-05200-120	Film holder body support	
13	3	7B-05000-130	Click wheel shaft	
14	1	7B-05200-140	Guide support(1)	
15	1	7B-05200-150	Guide support(2)	
16	1	7B-05200-160	Intensive plate	
17	1	7B-05200-170	Rubber roller	
18	1	7B-05200-180	Spindle	
19	1	7B-05200-190	Adjustment support	
20	1	7B-05200-200	Adjustment shaft	
21	4	7-04000-170	Click pulley	
22	4	7-04000-190	Scored pulley fastener	
23	2	7-04000-280	Slide	
24	2	7B-05000-190	Roller unit	
25	1	7B-05200-250	Block film lever (right)	
26	1	7B-05200-260	Block film lever (left)	
27	2	7-02000-190	Film holder guide	
101	2	227BA-3008	Grip ball(Black)	
102	2	200G06010	Socket head set screw,M6*10	
103	4	227A03528	Rubber washer,28*3.55	
104	4	212AS20	Ring,S-20	
105	4	200R06025	Star-type handle,M6*25	
106	2	2201411055	Spring,1.4*11.4*55	
107	2	210AF606ZZ	Bearing F606ZZ	
108	1	7-04000-230	Conical spring	
109	1	297J085120	Handle	
110	14	200F04008	Flat head cap screw,M4*8	
111	8	200F04010	Flat head cap screw,M4*10	
112	16	200AR08010	Hex.soc.hd.screw M8*10	
113	2	200A06016	Socket head cap screw, M6*16	
114	2	200A05030	Socket head cap screw, M5*30	
115	2	201A05	Hex nut, M5	

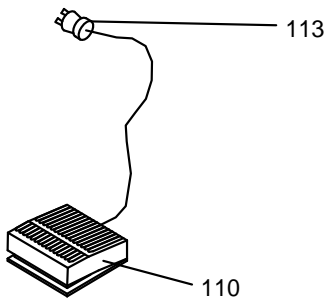
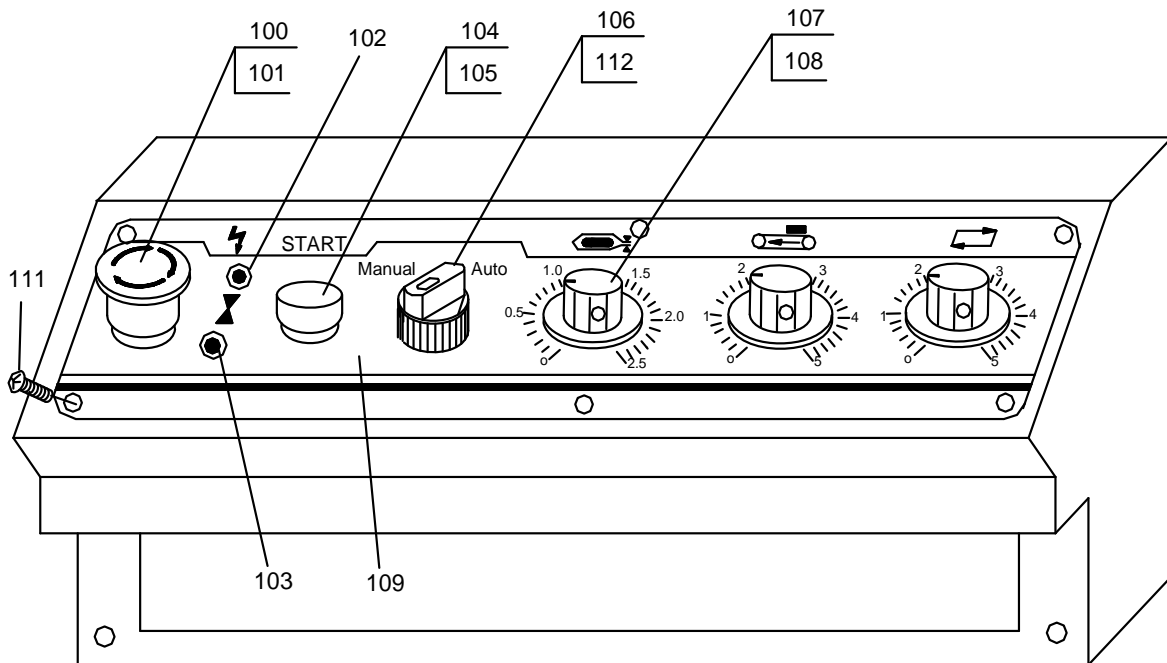
FIGURE 5-2: REEL CARRIER UNIT



PARTS LIST, FIGURE 6-1 PANAL UNIT

KEY	Q'TY	PART NO.	DESCRIPTION	LST-4055P-061
100	1	104K001	Stop button ZB2-BS54-R	
101	1	104K001-1B	Connecting points,ZB2-BZ102-1B	
102	1	109A003-G	Lamp(DC12V)	
103	1	109A003	Lamp	
104	1	104F-ZB2BW33C	Start button,ZB2BW33C	
105	1	104F-ZB2BWB31C	Connecting point unit,ZB2BWB31C	
106	1	104L002	Toggle switch,ZB2-BD2C	
107	3	153K-99D	Knob	
108	3	108BK200-1	Potenriometer,adjustable BR-200KB(24D)	
109	1	254A0191	Lable	
110	1	104N-TFS201	Foot switch,TFS-201	
111	4	200E03006	Phillips head machine screw,M3*6	
112	1	104F201-1A	Connecting points,ZB2-BZ101C	
113	1	152M003-XS16J2Y	Foot switch socket,XS16J2Y	

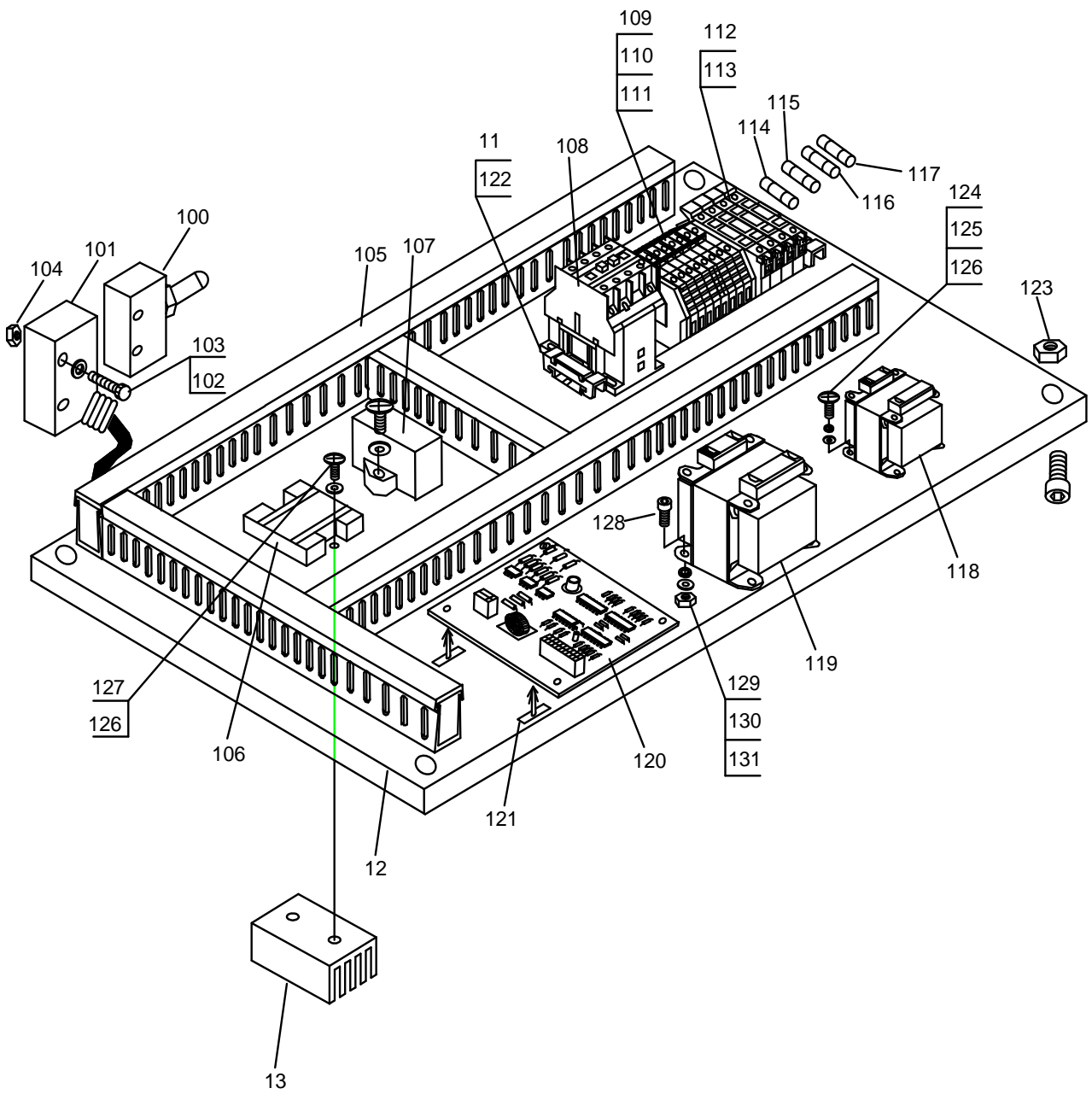
FIGURE6-1: PANEL UNIT



PARTS LIST, FIGURE 7-1 ELECTRICAL COMPONENTS UNIT

KEY	QTY	PART NO.	DESCRIPTION	LST-4055-071
11	2	3-14000-170	Clip	
12	1	7B-07000-120	Electrical fixed board	
13	1	7B-07000-130	Radiator	
100	1	104H1307	Proximity switch	
101	1	153C001	Cut safety switch cover AMC-1	
102	2	200E04025	Phillips head machine screw, M4*25	
103	2	202A0412	Plain washer, M4*12	
104	2	201A04	Hex nut, M4	
105	1.4M	153F2535	Wire track 25*35mm	
106	1	107F-SR-D2540	Solid relay	
107	1	101W02-5060500	Motor capacitance, 2uF, 500V/50/60Hz	
108	1	106A0910024	Contact, LC1-D0910-24VAC	
109	13	152P-HT-4-30A	Terminal	
110	7	152PC-HT-4PA01	Terminal cover	
111	4	152PD-01	Short circuit connector	
112	4	115N-FT-4	Fuse seat	
113	1	115N-FTC-4	Seat cover	
114	1	115A2015	Fuse, 15A 20mm	
115	1	115A2002	Fuse, 2A 20mm	
116	1	115A2001	Fuse, 1A 20mm	
117	1	115A2003	Fuse, 3A 20mm	
118	1	103B2424050	Transformer, 240-220-200V/24V, 50VA	
119	1	103B2450850	Transformer, 240-220-200V/50V, 850VA	
120	1	PC-FP-80A11	PC board assembly	
121	4	153J002	Speed clamp	
122	0.25M	153FC45	Wire track C45	
123	4	201A06	Hex nut, M6	
124	4	200E04008	Phillips head machine screw, M4*8	
125	4	202B04	Lock washer, M4	
126	6	202A0408	Plain washer, M4*8	
127	2	200E04016	Phillips head machine screw, M4*16	
128	4	200A05012	Socket head cap screw, M5*12	
129	4	202B05	Lock washer, M5	
130	4	202A0510	Plain washer, M5*10	
131	4	201A05	Hex nut, M5	

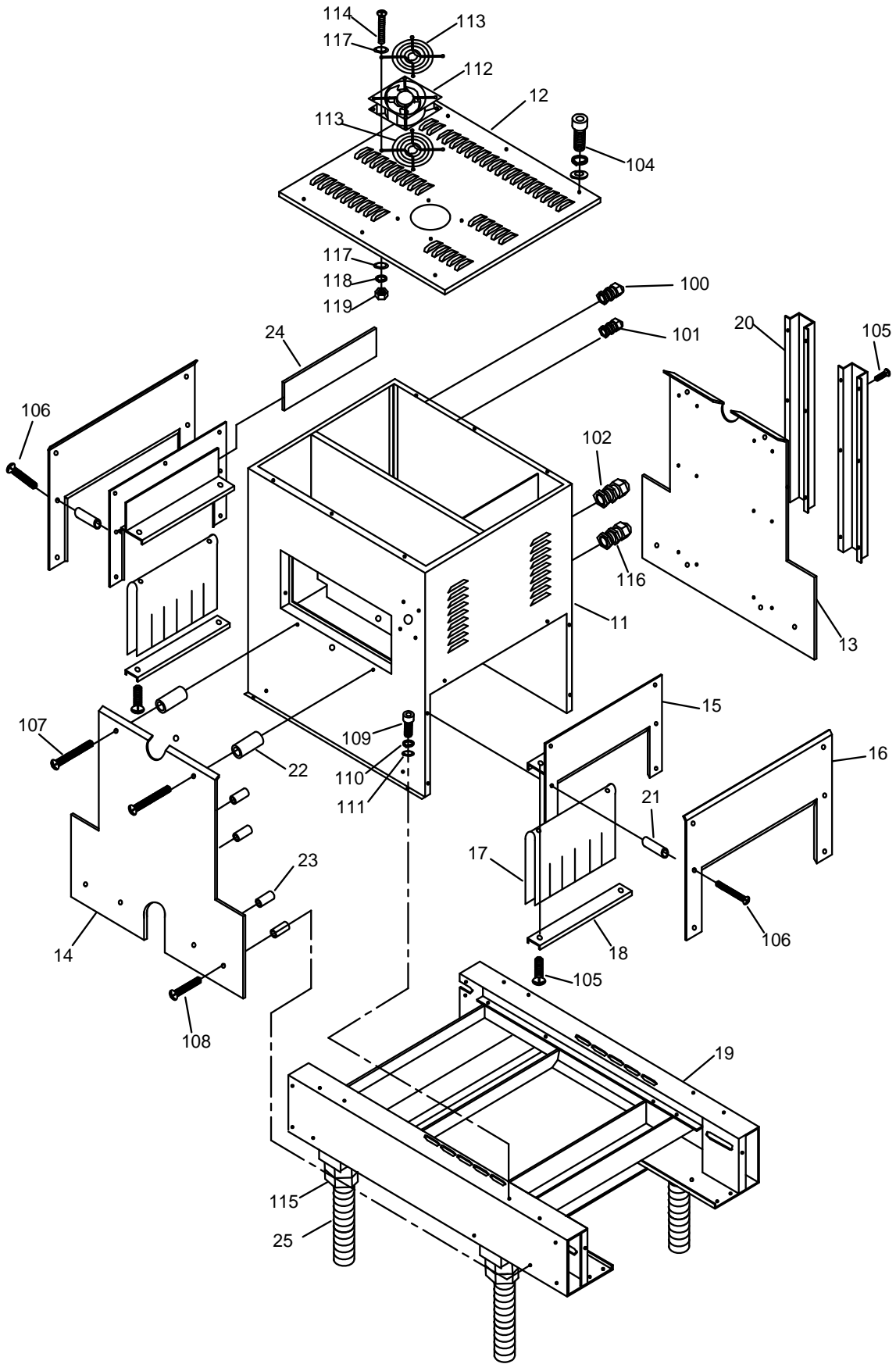
FIGURE 7: ELECTRICAL COMPONENTS UNIT



PARTS LIST, FIGURE 8 CABINET(2) UNIT

KEY	Q'TY	PART NO.	DESCRIPTION	LST-4055-080
11	1	7E-08000-110	Tunnel cover	
12	1	7E-08000-120	Cover	
13	1	7E-02000-130	Heat insulation plate(rear)	
14	1	7E-08000-140	Heat insulation plate(front)	
15	2	7E-02000-150	Heat insulation wall	
16	2	7E-02000-160	Heat insulation plate(side)	
17	2	7E-02000-170	Heat insulation curtain	
18	2	7E-02000-180	Lock curtain plate	
19	1	7E-08000-190	Tunnel baser	
20	2	7E-02000-200	Wire through chute	
21	12	7E-02000-210	Spacer(3)	
22	4	7E-02000-220	Spacer(1)	
23	8	7E-02000-230	Spacer(2)	
24	1	YL-02B002	Ceramic fibre blanket	
25	4	7E-08000-250	Screw(for table up&down)	
100	1	153N001	Waterproof tie-in,PG 13.5	
101	1	153NPG090	Waterproof tie-in	
102	1	273N-MG25A18B	Wire tie-in	
104	6	200A06030	Socket head cap screw, M6*30	
105	16	200H04008	Truss head machine screw,M4*8	
106	14	200H04035	Truss head machine screw,M4*35	
107	4	200H06050	Truss head machine screw,M6*50	
108	8	200H06025	Truss head machine screw,M6*25	
109	4	200A06016	Socket head cap screw, M6*16	
110	10	202B06	Lock washer, M6	
111	10	202A0612	Plain washer, M6*12	
112	2	116BA220	Smoke fan,220-240VAC 50/60HZ 120*120	
113	4	116H002	Smoke fan net 120*120mm	
114	8	200E04050	Phillips head machine screw, M4*50	
115	4	201A20	Hex nut,M20	
116	1	273N-MG20A14B	Wire tie-in	
117	16	202A0409	Plain washer, M4*9	
118	8	202B04	Lock washer, M4	
119	8	201A0408	Hex nut,M4	

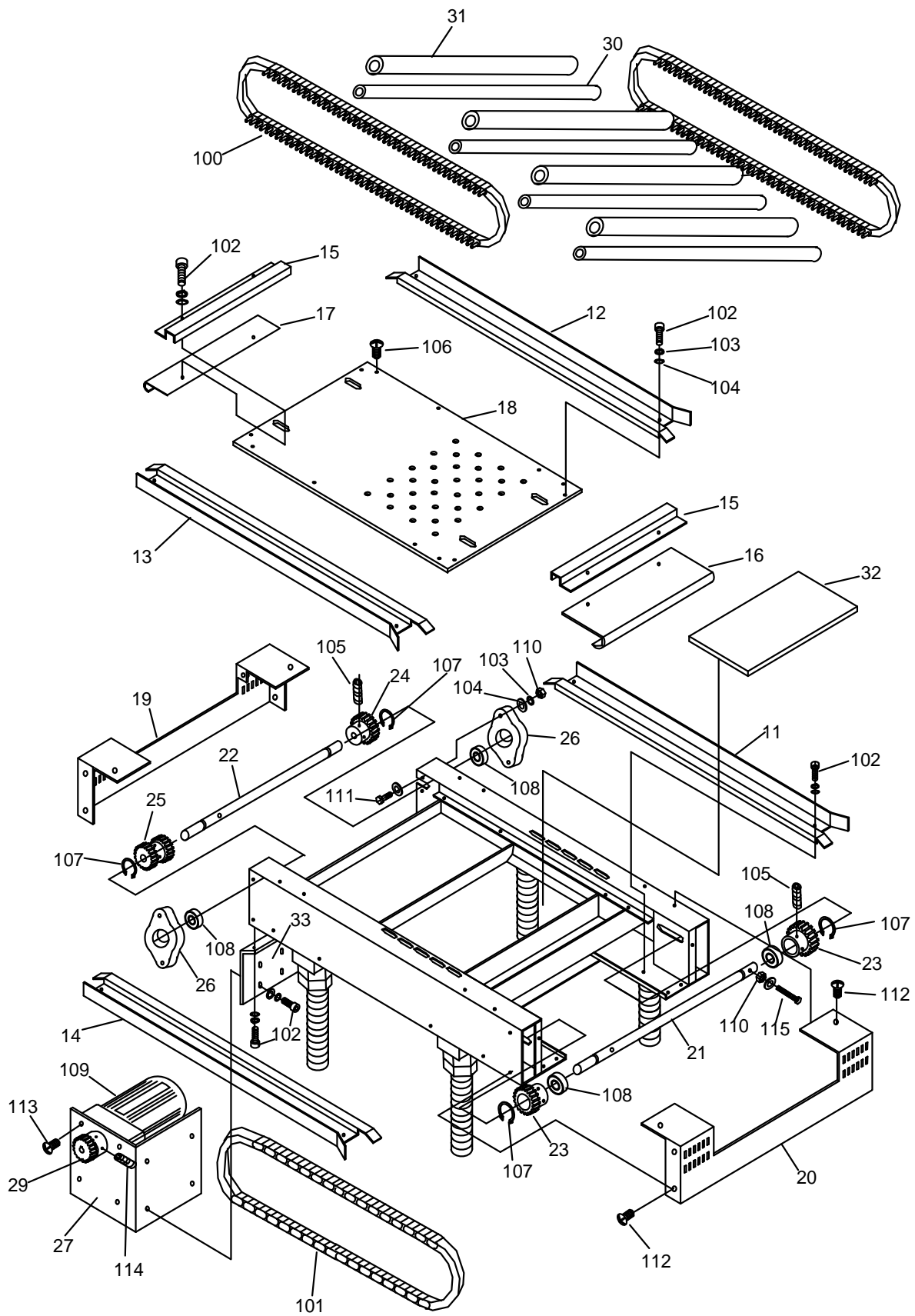
FIGURE 8: CABINET(2) UNIT



PARTS LIST, FIGURE 9 TRANSPORTATION UNIT

KEY	Q'TY	PART NO.	DESCRIPTION	LST-4055-090
11	1	7E-03000-110	Chain track(1)	
12	1	7E-03000-120	Chain track(2)	
13	1	7E-03000-130	Chain track(3)	
14	1	7E-03000-140	Chain track(4)	
15	2	7E-03000-150	Plate	
16	1	7E-03000-160	Second supporting plate	
17	1	7E-03000-170	First supporting plate	
18	1	7E-03000-180	Cover	
19	1	7E-09000-190	Transportation cover(L)	
20	1	7E-03000-200	Transportation cover(R)	
21	1	7E-03000-210	Second running shaft	
22	1	7E-03000-220	First running shaft	
23	2	7E-03000-230	Chain wheel	
24	1	7E-03000-240	Driving chain wheel	
25	1	7E-03000-250	Driving chain wheel(1)	
26	2	7E-03000-260	Bearing house	
27	1	7E-03000-270	Motor tray	
28	1	7E-03000-280	Motor support plate	
29	1	7E-03000-290	Chain wheel	
30	163	7E-03000-300	Transportation shaft	
31	163	7E-03000-310	Tube	
32	1	YL-02B002	Ceramic fibre blanket	
33	1	7E-03000-330	Motor tray	
100	2	215A0102-162	Chain, 1/2"	
101	1	215A0102-48	Chain, 1/2"	
102	18	200A06016	Socket head cap screw, M6*16	
103	22	202B06	Lock washer, M6	
104	28	202A0612	Plain washer, M6*12	
105	8	200G08010	Socket head cap screw, M8*10	
106	8	200H04008	Truss head machine screw, M4*8	
107	4	212AS15	Ring, S-15	
108	4	210A620ZZ	Ball bearing, 6202ZZ	
109	1	101G23500025-20	Reducer motor, 220-240V/50-60Hz, 25W, 1:20	
110	6	201A06	Hex nut, M6	
111	4	200C06020	Hex bolt, M6*20	
112	12	200H06010	Truss head machine screw, M6*10	
113	4	200H05012	Truss head machine screw, M5*12	
114	2	200G06010	Socket head cap screw, M6*10	
115	2	200C06090	Hex bolt, M6*90	

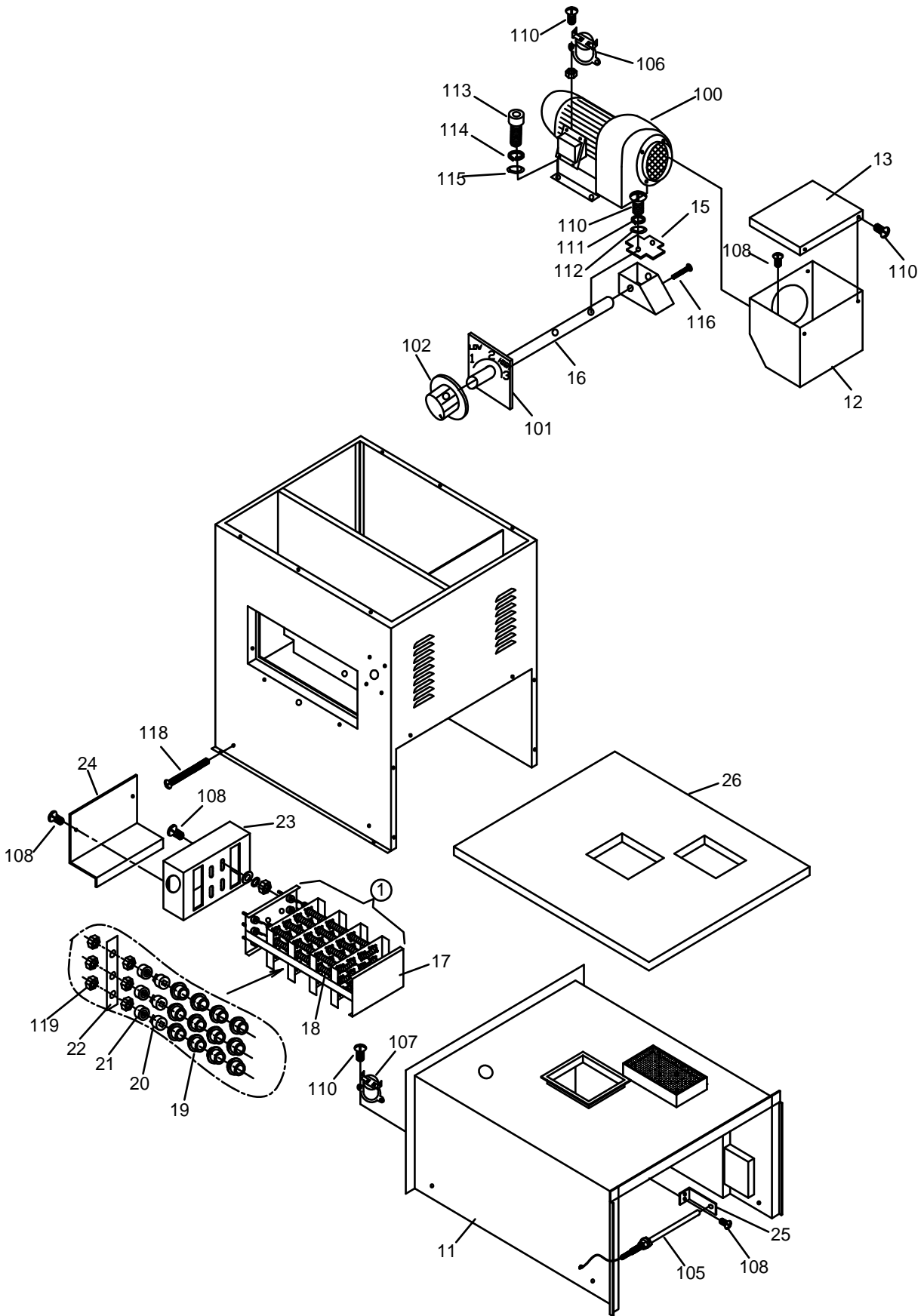
FIGURE 9: TRANSPORTATION UNIT



PARTS LIST, FIGURE 10 HOTTING AND BLOWING UNIT

KEY	Q'TY	PART NO.	DESCRIPTION	LST-4055--100
1	1	7E-04010	HEATER UNIT	
11	1	7E-04000-110	Tunnel inner cover	
12	1	7E-04000-120	Chamber(1)	
13	1	7E-04000-130	Chamber cover	
15	1	7E-04000-150	Damper	
16	1	7E-04000-160	Damper adjustment shaft	
17	1	7E-04010-170	Heating box bracket	
18	3	7E-04010-180	Heating blade	
19	48	7E-04010-190	Ceramic sleeve	
20	6	7E-04010-200	Ceramic cover	
21	6	7E-04010-210	Ceramic cover	
22	1	7E-04010-220	Connecting plate	
23	1	7E-04000-230	Cinnection Box	
24	1	7E-04000-240	Cover	
25	1	7E-04000-250	Thermocouple bracket	
26	1	YL-02B002	Ceramic fibre blanket	
100	1	116JCY150B2P225	Air blower	
101	1	254A0192	Lable	
102	1	153K-99A	Knob	
105	1	104Y-K5M81802M	Thermocouple,K5M81802M	
106	1	110GNC.090	Heat-variable resistor,90℃	
107	1	110GNO.090	Heat-variable resistor,90℃	
108	8	200H04008	Truss head machine screw,M4*8	
110	8	200E03008	Phillips head machine screw,M3*8	
111	2	202B03	Lock washer,M3	
112	2	202A0308	Plain washer,M3*8	
113	4	200A06016	Socket head cap screw,M6*16	
115	4	202A0612	Plain washer,M6*12	
116	1	200E03020	Phillips head machine screw,M3*20	
118	4	200H04035	Truss head machine screw,M4*35	
119	9	201A05	Hex nut,M5	
120	4	202A0409	Plain washer, M4*9	
121	4	202B04	Lock washer, M4	
122	4	201A0408	Hex nut,M4	

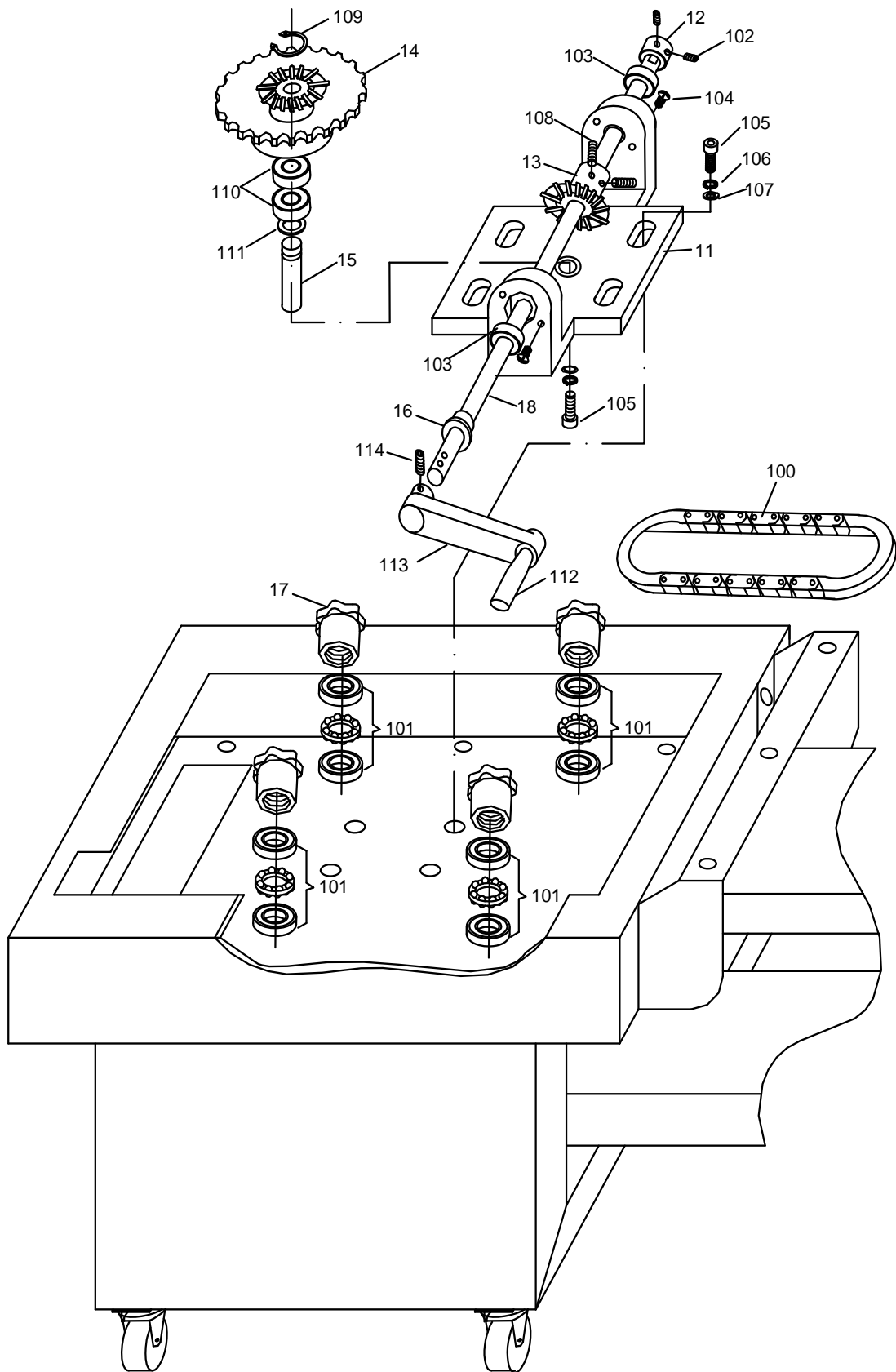
FIGURE 10: HOTTING AND BLOWING UNIT



PARTS LIST, FIGURE 11 TUNNEL CHAMBER(UP&DOWN) UNIT

KEY	Q'TY	PART NO.	DESCRIPTION	LST-4055-110
11	1	7E-11000-110	Aluminum set	
12	1	7E-11000-120	Sleeve	
13	1	7E-11000-130	Bevel gear(driving)	
14	1	7E-11000-140	Bevel gear(driven)	
15	1	7E-11000-150	Bevel gear shaft	
16	1	7E-11000-160	Copper sleeve	
17	4	7E-11000-170	Chain wheel	
18	1	7E-11000-180	Transmission shaft	
100	1	215A0308-246	Chain,3/8"	
101	4	210L51104	Bearing,51104	
102	2	200G06006	Socket head set screw,M6*6	
103	2	210A6001ZZ	Ball bearing,6001ZZ	
104	4	200H06012	Truss head machine screw,M6*12	
105	5	200A08025	Socket head cap screw M8*25	
106	5	202B08	Lock washer, M8	
107	5	202A0816	Plain washer, M8*16	
108	2	200G08010	Socket head set screw,M8*10	
109	1	212AS15	Ring,S-15	
110	2	210A6202ZZ	Ball bearing,6202ZZ	
111	3	202E152102	Shim,M15*21*0.2	
112	1	297L08063	Handle arm	
113	1	297N12	Handle	
114	1	200G06010	Socket head set screw,M6*10	

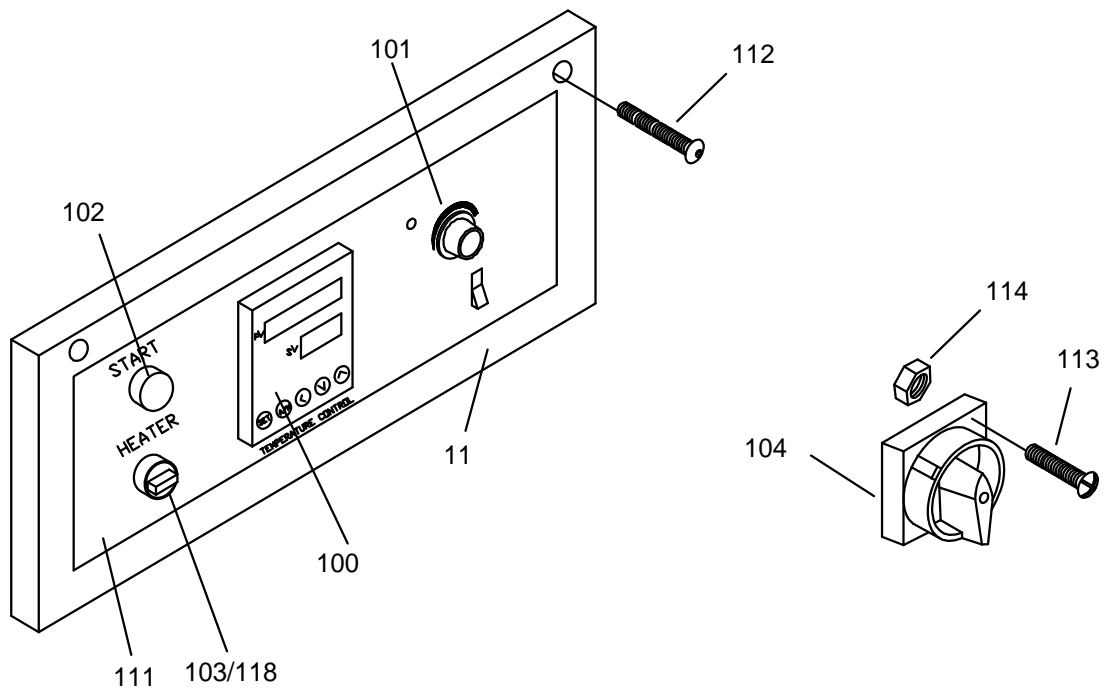
FIGURE 11: TUNNEL CHAMBER(UP&DOWN) UNIT



PARTS LIST, FIGURE 12 PANEL UNIT

KEY	Q'TY	PART NO.	DESCRIPTION	LST-4055-120
11	1	7E-05000-110	Electrical fixed board	
12	1	7E-05000-120	PC board fixed board	
13	2	3-14000-170	Clip	
100	1	134C-H721	Thermoregulator,24VDC	
101	1	101W-SCU25	Speed control	
102	1	109A-TN2LTGI	Indicator light	
103	1	104FTN2IT7W11AB	Knob	
104	1	104C011-32	Main power switch	
111	1	254A0193	Lable	
112	2	200A05025	Socket head cap screw,M5*25	
113	4	200E04016	Phillips head machine screw,M4*16	
114	4	201A04	Hex nut,M4	
118	1	104F201-1A	Connecting points,ZB2-BZ101C	

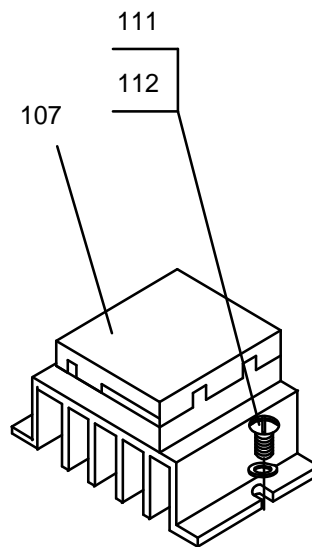
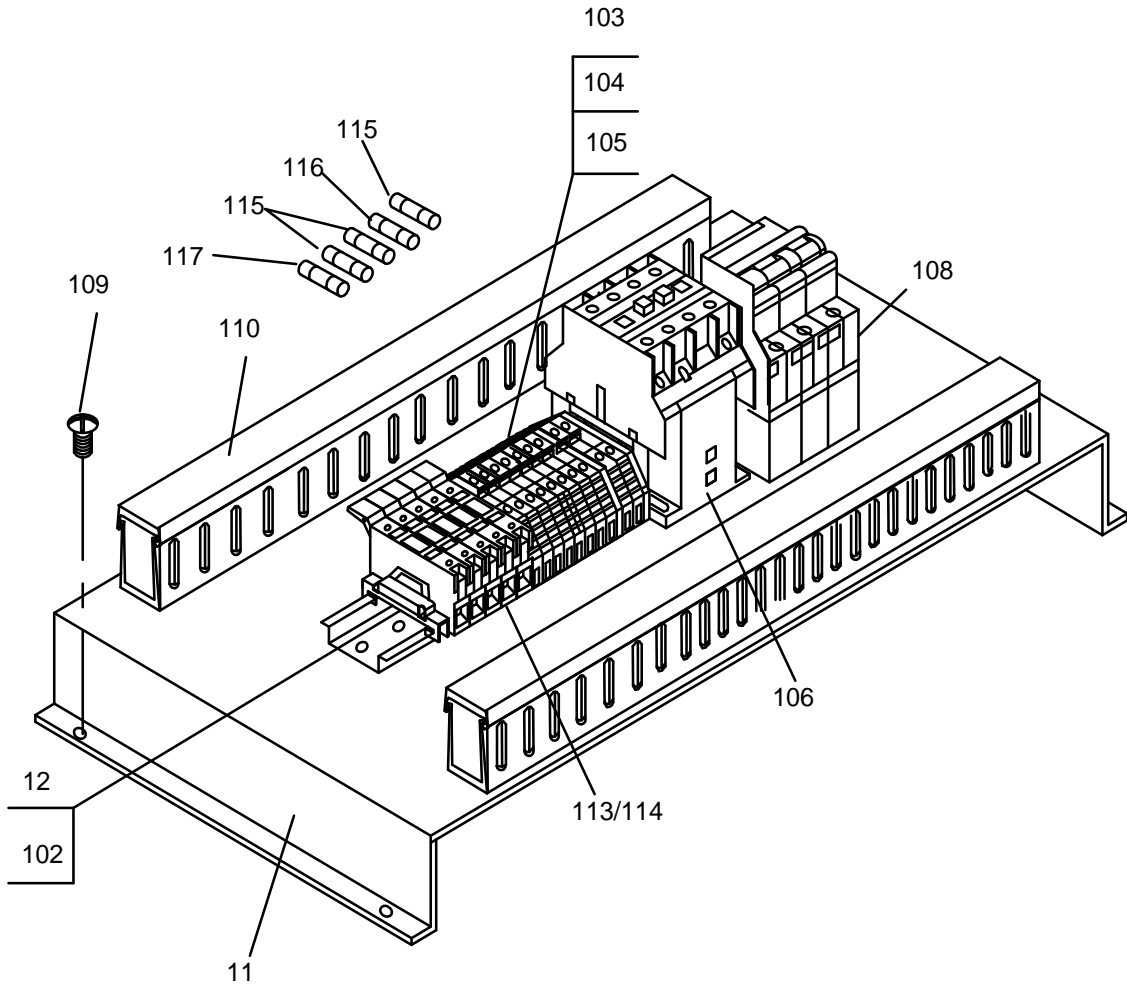
FIGURE 12: PANEL UNIT

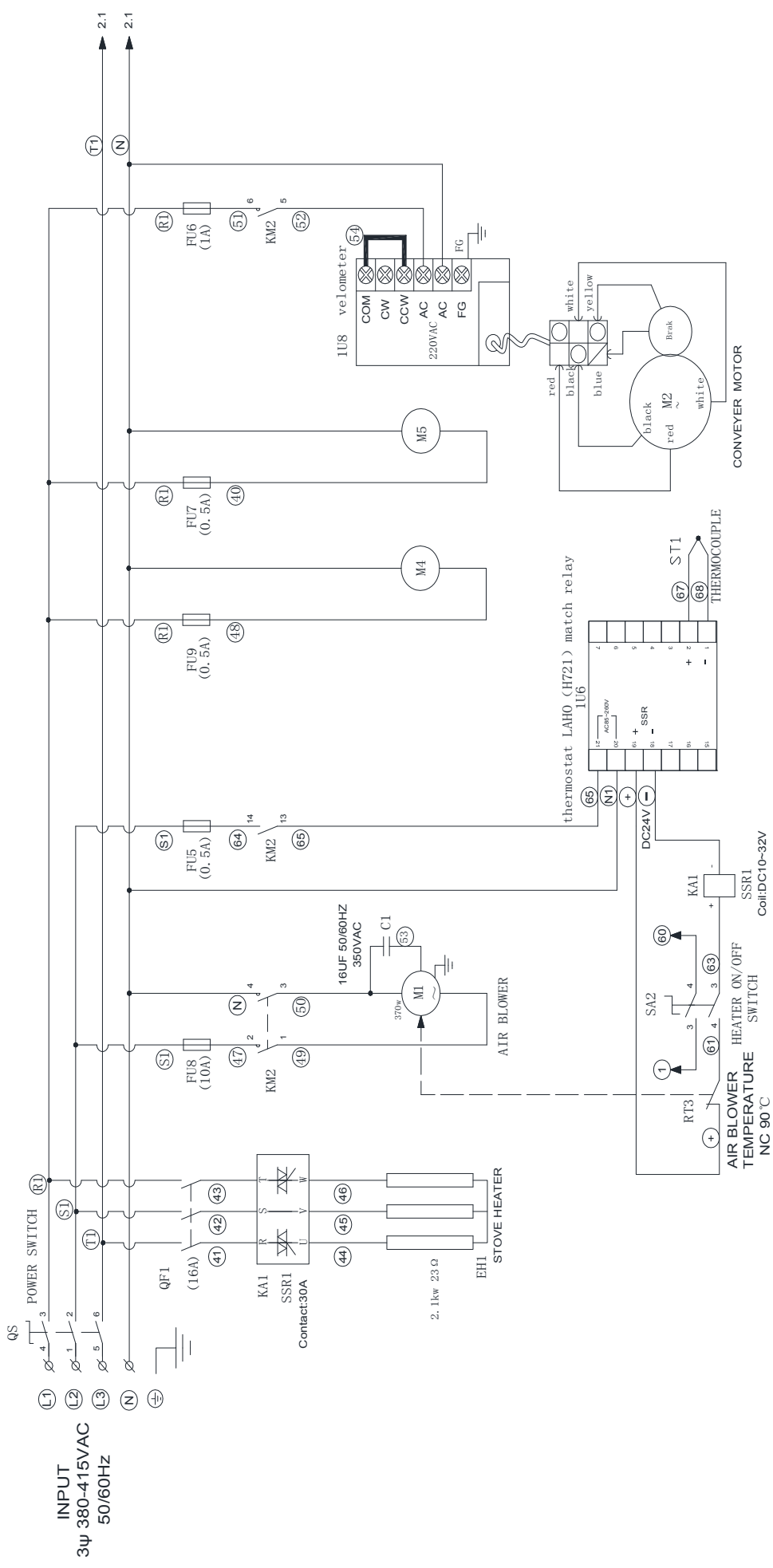


PARTS LIST, FIGURE 13 ELECTRICAL COMPONENTS UNIT (2)

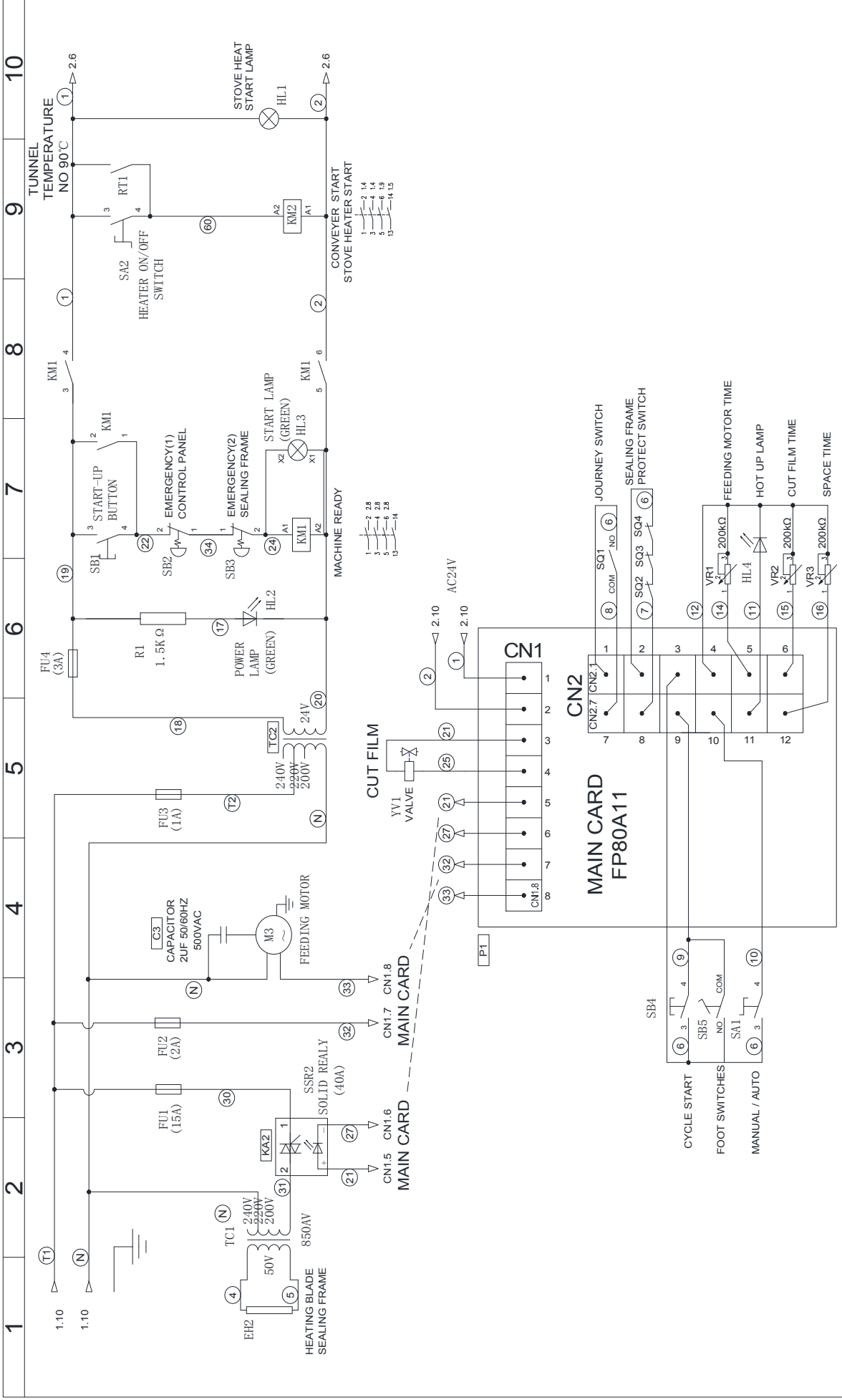
KEY	Q'TY	PART NO.	DESCRIPTION	LST-4055-130
11	1	7E-06000-110	Electrical fixed board	
12	2	3-14000-170	Clip	
102	0.25M	153FC45	Wire track C45	
103	10	152P-HT-4-30A	Terminal	
104	5	152PC-HT-4PA01	Terminal cover	
105	5	152PD-01	Short circuit connector	
106	1	106A0610024	Contactor,LC1-D0610-24VAC	
107	1	107FJK3C25275	Solid relay,JK3C25A-2A75	
108	1	104K61172C32N16	Circuit breaker	
109	4	200E04008	Phillips head machine screw,M4*8	
110	0.5M	153F2535	Wire track 25*35mm	
111	2	200E04016	Phillips head machine screw,M4*16	
112	2	202A0408	Plain washer,M4*8	
113	4	115N-FT-4	Fude deat	
114	1	115N-FTC-4	Seat cover	
115	3	115A20005	Fuse,0.5A 20mm	
116	1	115A2001	Fuse,1A 20mm	
117	1	115A2010	Fuse,10A 20mm	

FIGURE 13: ELECTRICAL COMPONENTS UNIT

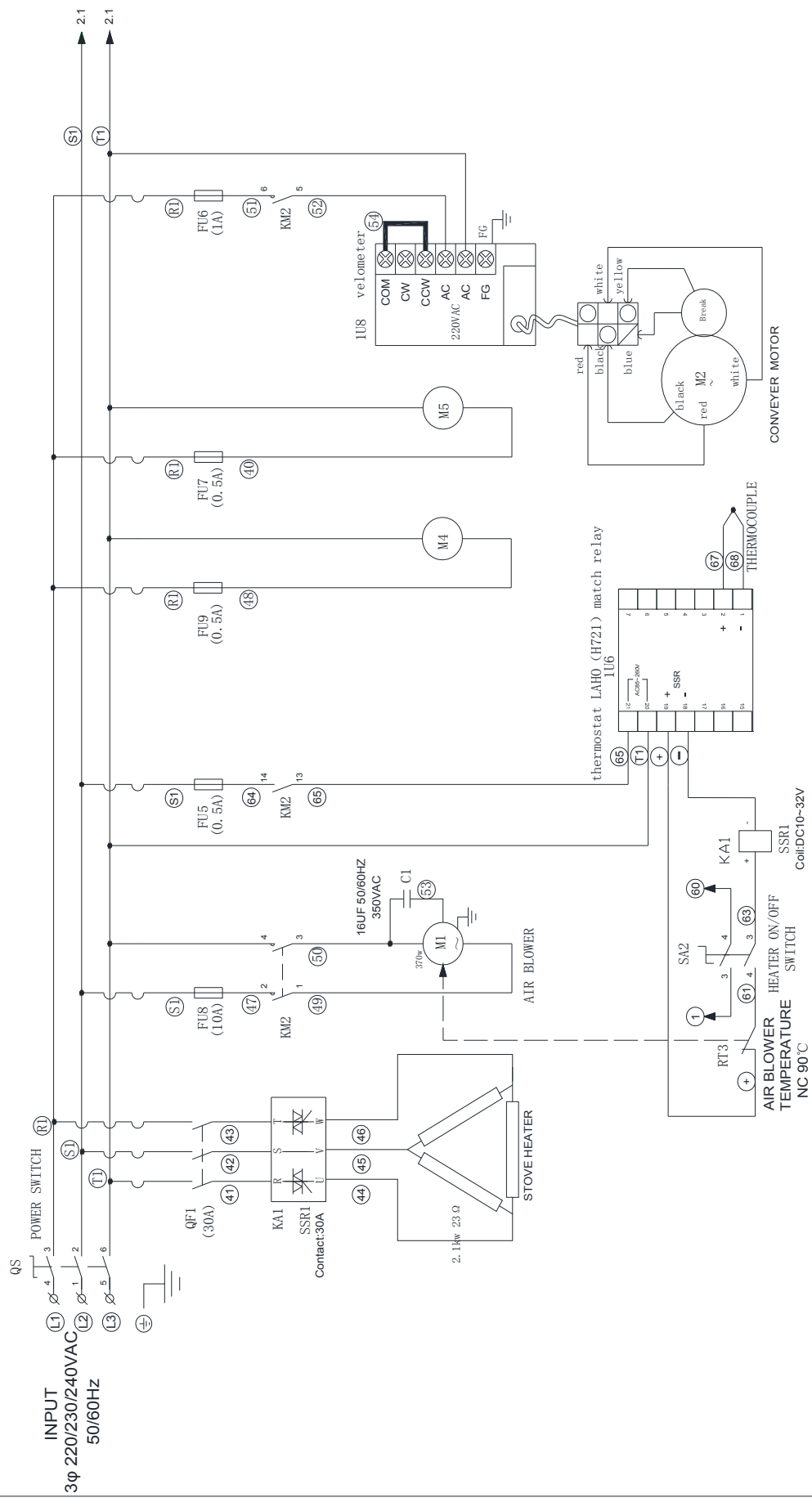




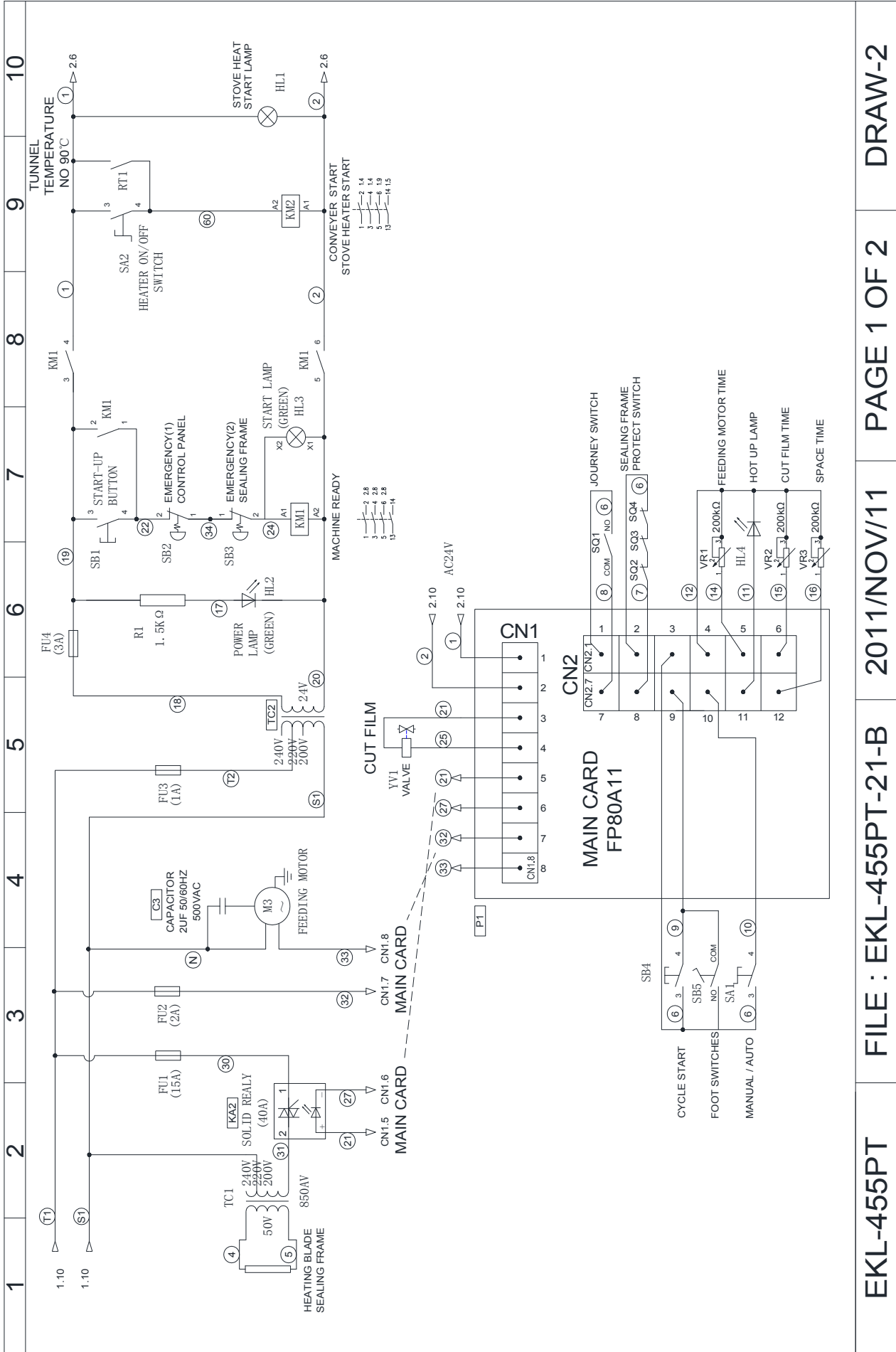
CIRCUIT DIAGRAM



1 2 3 4 5 6 7 8 9 10



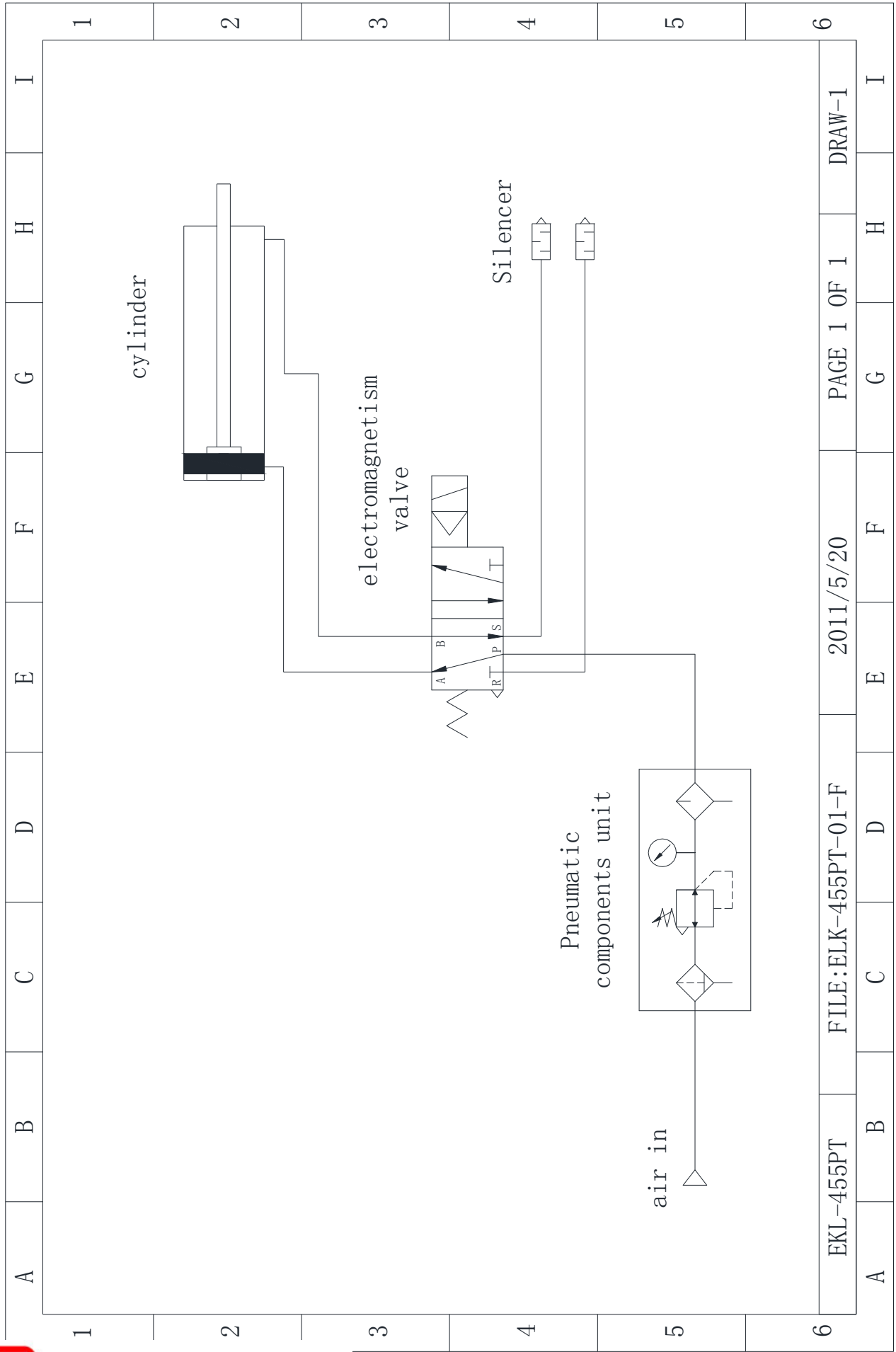
CIRCUIT DIAGRAM





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