



SEAM SEALING MACHINE

USER'S MANUAL



Qiaoge (Shanghai) Enterprise Co, Ltd

Address: No.381, Meizhou Road, Yangpu District, Shanghai, China

Tel: +86 21 65437622 Email: john@joegoing.com



ENGLISH OPERATION MANUAL

I. Purpose

Seam sealing Machine, has the following purpose.

1. Most of the fabric required for waterproof need taping, because the water permeate the fabric through the needle hole.
2. This machine is designed for the waterproof of seam part by taping with hot air.

II. Application of the machine

The machine is designed to provide a fast, simple and reliable method for application of a hot melt tape over a sewn seam or glued joint to create a waterproof product.

- **Marine Suits**

Rainwear, Dry suits, Waders

- **Industrial Protective and High Visibility Clothing**

Military, Emergency Services, Public Services

- **Leisure Waterproofs**

Golf, Ski, Motorcycle, sailing, fishing, walking, Tents, Boat Covers

- **Chemical Protective Clothing**

- **Advertisement balloon**



III. Standard Specification of the machine

No.	ITEM NUMBER	DESCRIPTION
1	POWER SUPPLY	AC220V±10%, 50/60HZ
2	ELECTRIC POWER CONSUMPTION	2.5K VA
3	COMPRESSED AIR	3.8KG/CM ²
4	DRIVE AND TRANSMISSION	60W
5	HEATER POWER	2000W
6	NOZZLE TEMPERATURE	Adjustable 0~750°C
7	ROLLER WIDTH	25MM standard/other optional
8	TAPE WIDTH	14-22MM standard/other optional
9	UPPER ROLLER LIFT	20-30MM
10	ROLLER VELOCITY	1-23M/MIN
11	DIMENSION	1180 x600 x 1700MM
12	WEIGHT	150KG

(Specification subject to change without prior notice)

IV. Unpacking

1. The machine should be flat.
2. During transit, the upper part (head part) should be solidly fixed.
3. Completely remove rust with cleaner.
4. During moving indoor, the wheel should be OFF-state.
5. When the machine arrived at installed place, the Wheel should be ON-state.



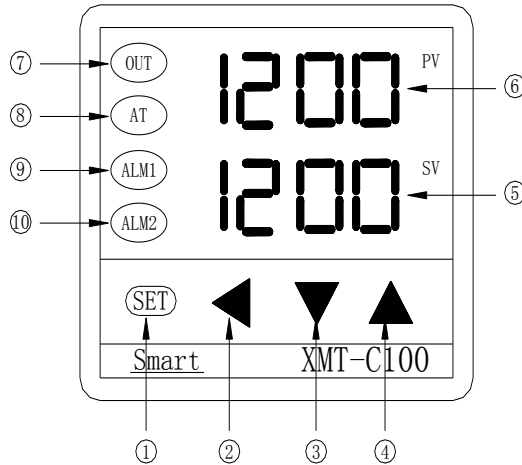
V. Installation

1. The machine should be installed away from the wall not less than 500mm.
2. The machine should be installed confirming the following conditions.(Before power switch is on)
 - 1) Air pressure is 0.3Mpa
 - 2) Air connect
 - 3) Confirm the power S/W is off state and 220V
 - 4) Pick A Nozzle hole wire to confirm the clean hole

VI. How to Work

1. Plug in
2. Power switch on
3. Input the temperature(400~600 °C)

■ How to set temperature on the thermometer



- 1) press ① “SET”, “SV” digital sparklingly
- 2) move digital moving key② to the place you want to set
- 3) digital moving key ③ reduce the digital, digital moving key ④ add the digital.
- 4) Press①“SET” again, “SV” digital stop sparkling. Temperature setting is ok.

1. When input the temperature, the temperature is going up. If the temperature is not going up, then we have to check whether the heater air pressure is below 1kg/CM²
2. Start to work when the temperature is increased at the input temp. (About 2~3 minutes)

3. How to stop work

- 1) Setting the temp.(000)
- 2) Wait until below 50 °C
- 3) Air off
- 4) Power off



Caution: Do not off the air before below 50°C, it can cause the heater broken.

■ Control of Pedal

- 1) Put your foot on pedal.

*Position of pedal and the height of chair are controlled by worker's physical condition.

- 2) Upper roller up and down

Upper roller up and down each time the right pedal is stepped on.

- 3) How to start

The nozzle and machine is start to working when the upper roller is down state.

①If the upper roller is up-state, nozzle heater is not moving even though the felt pedal is stepped on.

②The roller moves only while the left pedal is stepped on.

③Auto cutting:

While the left pedal stepped on, the tape is automatically cut while right pedal is stepped on simultaneously.

■ Panel Control

Parameter setting and adjustment on the machine control center LCD DISPLAY:

OPERATION FOR LCD DISPLAY

LCD DISPLAY:



■ How to use the Display:

After power on, Display show as follows :

Welcome to use
Hot air seam Sealing Machine

POWER ON PAGE

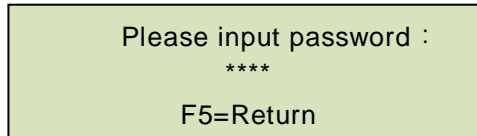
After 4 second

Speed: 12.3 m/min F1 → set
F2 → shearing F4 → heating
-- --

MAIN PAGE

After 4 seconds, automatic to MAIN PAGE, show as above page. In the MAIN PAGE, Operation function as follows :

- (1) PRESS F2, HAND CUTTING (shearing) ;
- (2) PRESS F4, ON or OFF HEATING(heating words black color is heating on) ;
- (3) PRESS F3, ROLLER REVIND (reverse) ;
- (4) PRESS F1, Display show INPUT PASSWORD PAGE, as following page :



Please input password :

F5=Return

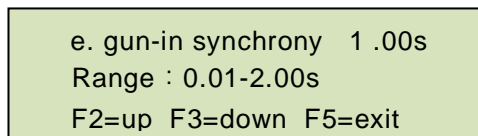
INPUT DATA PROCEDURE :

- (1) PRESS Enter, then PRESS → / F1, Can choose the change data place ;
- (2) PRESS ▲ or ▼ ,Can change flash place data ;
- (3) After change data, PRESS Enter to confirm the changed data ;

User password “2222”, other parameter changing similar to input data as password.

show user parameter page, user can change parameter data according to data period show ;

When input password “2222” is User password, show following Parameters page :



e. gun-in synchrony 1.00s
Range : 0.01-2.00s
F2=up F3=down F5=exit

As above photo show, Press F2 to up parameter, Press F3 to Next parameter, Press F5 to MAIN PAGE.

■ **As Sequence of a\b\c..., explanation as following:**

a: Work speed----

it is to adjust the speed of upper and lower Rubber roller.
Reference value: 10m/min

b: Reverse speed----

it is to adjust the reverse speed of upper and lower Rubber roller. Reference value: 7m/min

c: Micro-recede speed----

it is to adjust the micro-recede speed of Rubber roller when the hot air gun in and out.
Reference value: 7m/min

d: Tape feeding speed----

it is to adjust the speed of tape feeding to set position after the clipping.
Reference value: 7m/min

e: Gun-in synchrony----

it is to adjust the timing of gun-in to make sure when the gun-in the rubber roller can actions at the same time.
Reference value: 0.30s

f: Gun-out synchrony----

it is to adjust the time of pinch wheel stop in order to make sure the hot air gun out and the pinch wheel stop at the same time.
Reference value: 0. 10s



g: Micro-recede delay----

it is to adjust the time of rubber roller recede when the working is suddenly stopped.

Reference value: 0.02s

h: Shearing speed----

it is to adjust the speed of opening and closing of the shearing when tape clipping.

Reference value: 0.20s

i: Tape pressing delay----

it is to adjust the time of pressing the left tape after clipping.

Reference value: 0.55s

j: Tape feeding delay----

it is to adjust the time of sending tape to the set position after clipping and left tape feeding.

Reference value: 0.40s

k: Shearing pattern----

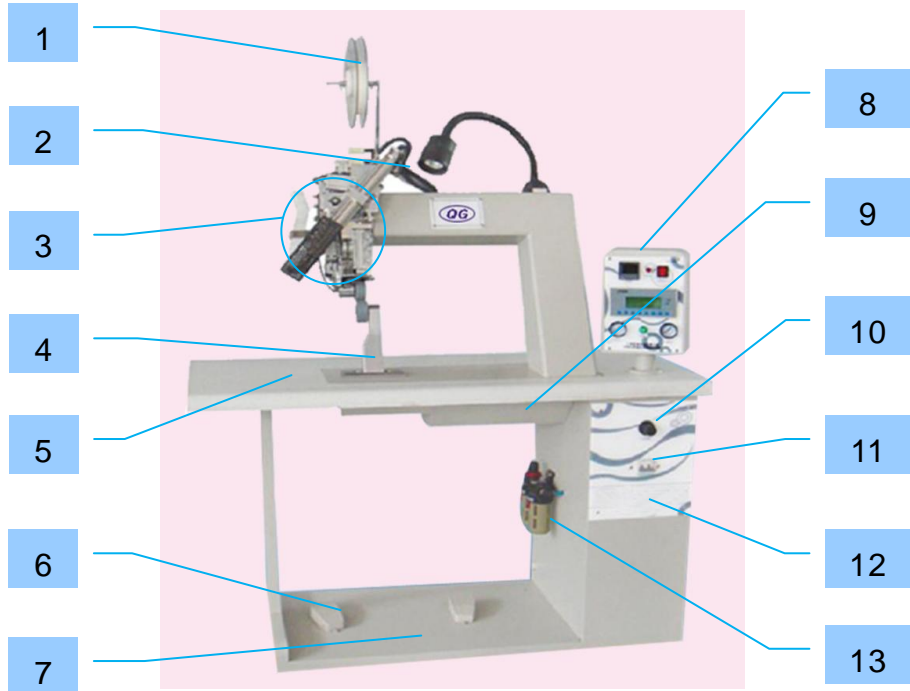
it is to set the mode of tape feeding, which including automatic tape shearing and manual tape shearing.

m: Blow tape delay----

it is to adjust the time of tape blowing after tape

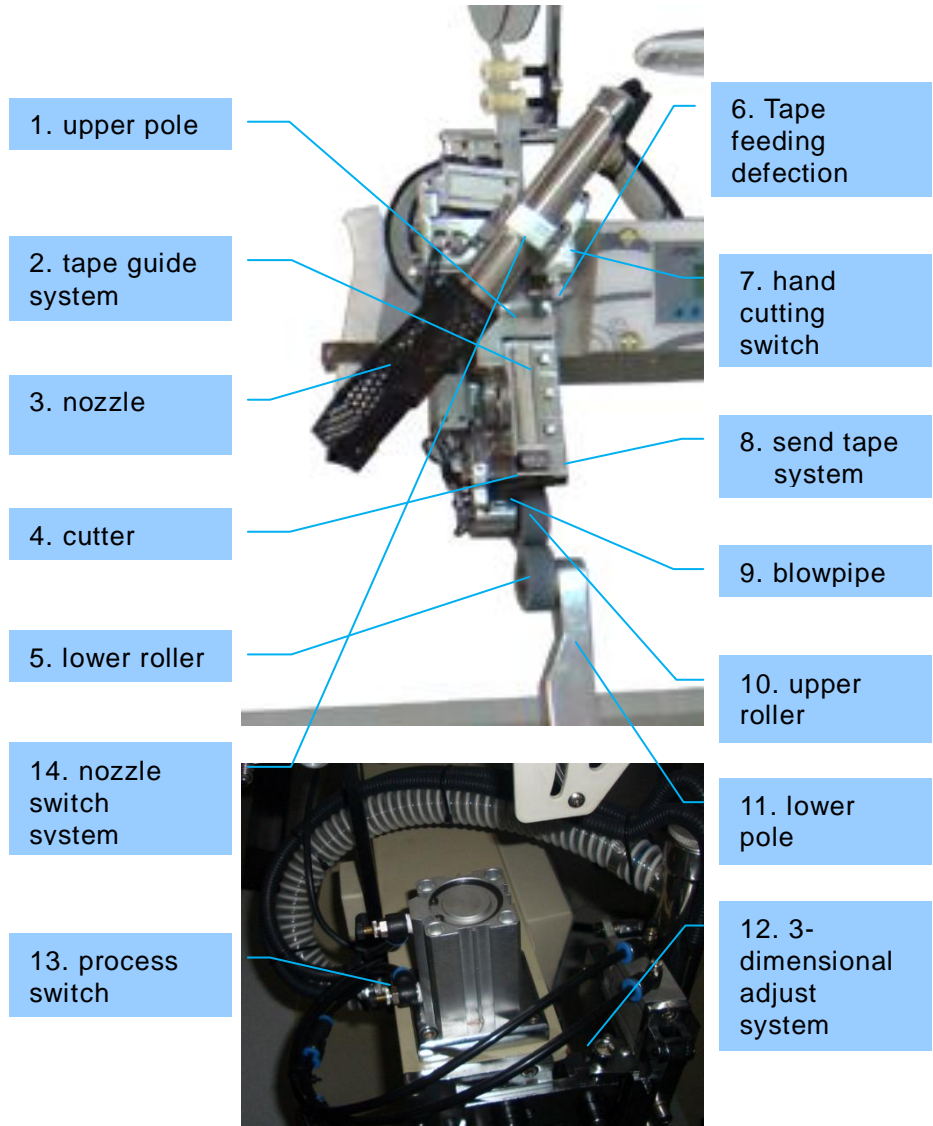
Summarize of SEAM SEALING MACHINE

Apparent structure of SEAM SEALING MACHINE

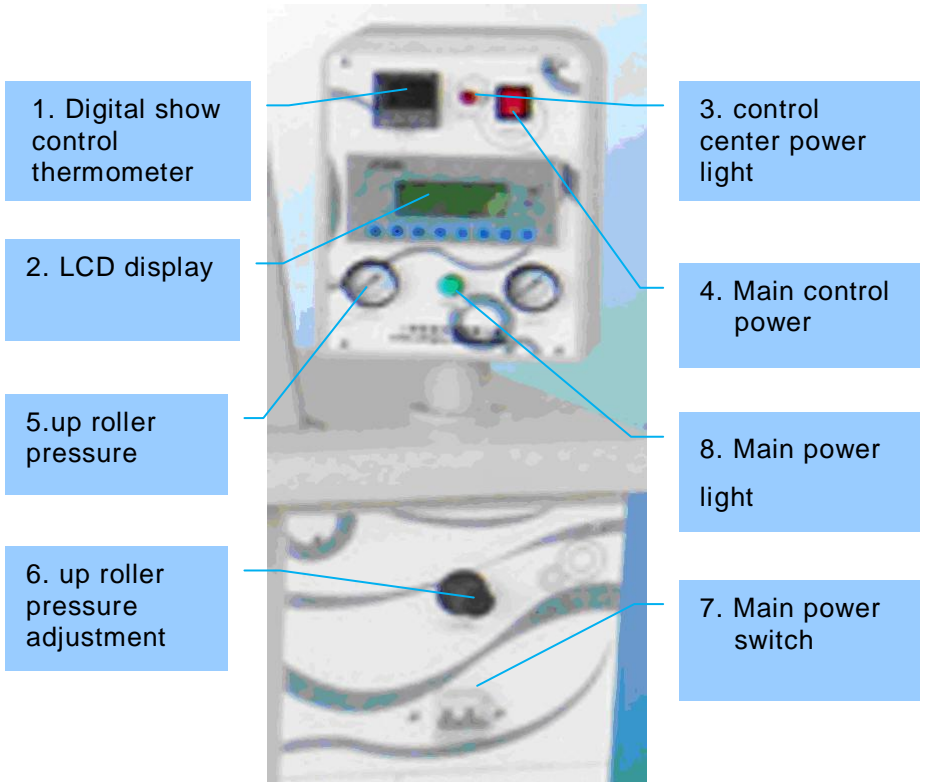


1	Tape feeding system	8	Control center (LCD display)
2	Send air pole	9	Full direction wheel(Inside)
3	Upper pole, nozzle and adjustment system	10	Pressure adjustment
4	Lower pole	11	Power switch
5	Table	12	Air blow(Inside)
6	Pedal switch	13	Oil and water separator
7	Soleplate		

■ Illustration 1 Apparent structure



■ Illustration 2 Upper pole, nozzle and adjustment system



Introduction of the parts and relevant functions

The machine is mainly composed of machine shelf, transmission system, nozzle system, nozzle adjustment, upper pole and lower pole, table and pedal switch etc. and electric control system.

■ **Following is the introduction of the main parts and relevant functions:**

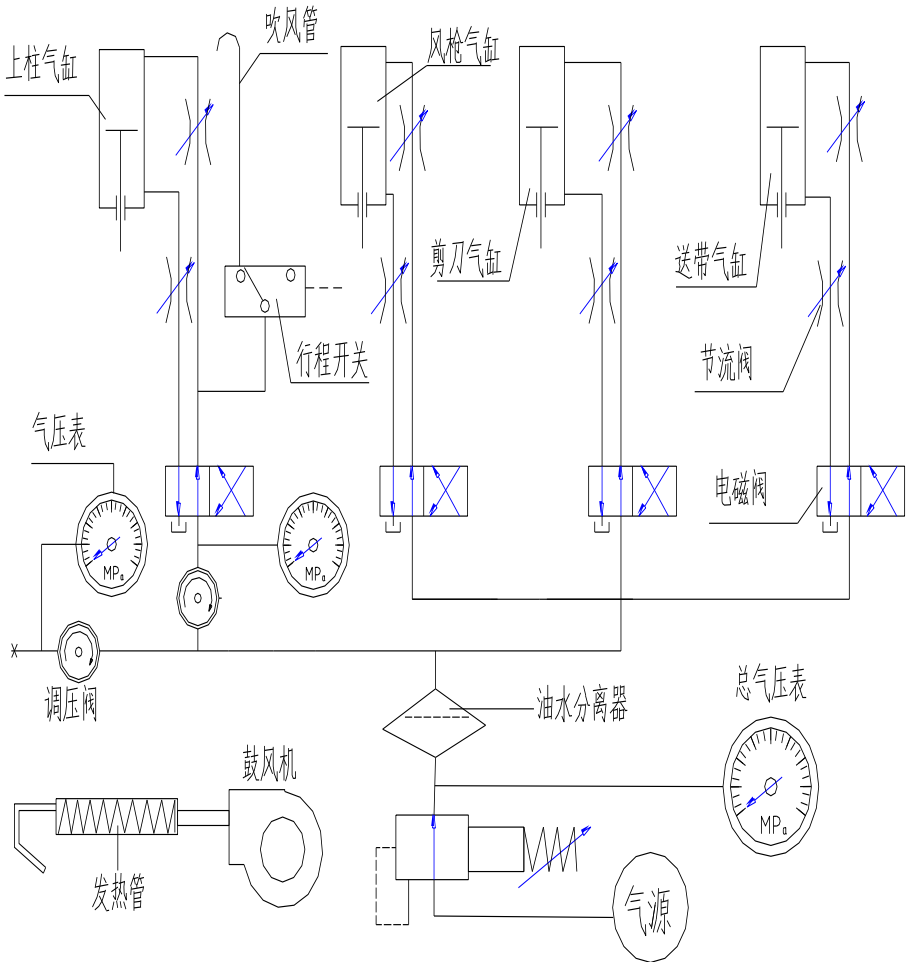
- ◆ **UPPER POLE:**(Illustration 1 No.10)
used for press and transfer the tape and material for process, it can slip up and down, the height can adjust from 0 MM to 30 MM;
- ◆ **LOWER POLE:** (Illustration 1 No.11)
used for press and transfer the tape and material for process, been fixed on the table;
- ◆ **NOZZLE:** (Illustration 1 No.3)
a heater in the nozzle and the end is nozzle, it can transfer the hot air to work area;
- ◆ **NOZZLE SWING SYSTEM:** (Illustration 1 No.14)
used for swing the nozzle in and out;
- ◆ **THREE-DIMENSIONAL ADJUST SYSTEM:** (Illustration 1 No.12)
used for adjust the position of the nozzle;
- ◆ **PEDAL SWITCH:** (I. No.6)
used for control up and down of the upper pole、 auto tape cutter and circumrotate of the upper roller and lower roller;
- ◆ **CUTTER:** (Illustration 1 No.4)
cut the tape (manual control by Illustration 2 No.7 and auto control);
- ◆ **CONTROL PANEL:** (Illustration 2 No.4)
there are many switches for heat thermometer 、 feeding speed and upper roller pressure etc.
- ◆ **POWER SWITCH:** (Illustration 2 No.7)
power switch of the machine;

- ◆ OIL AND WATER SEPARATOR: (I.No.12)
separate the oil and water from the air source, there are one pressure gauge and one tie-in the pressure gauge can adjust the pressure of the ingoing air, the tie-in can connect with the air source;
- ◆ TAPE FEEDING DEFLECTION SYSTEM:: (Illustration 1 No.12)
used for control the position and width of the feeding tape;

Following is the introduction of the parts and relevant functions on the control panel:

- DIGITAL SHOW CONTROL THERMOMETER: (Illustration 2 No.1)
show the air temperature from the nozzle and set the temperature from the nozzle that needed;
- CONTROL CENTER POWER SWITCH: (Illustration 2 No.4)
Control LCD display and main card, control center power on, light (Illustration 3 No.3) will lighting.
- MAIN POWER SWITCH: (Illustration 2 No.7)
General power switch for whole machine, power on, light (Illustration 3 No.8) will lighting.
- UP POLE AIR PRESSURE ADJUST SWITCH: (Illustration 2 No.6)
Adjust the up pole air pressure, the air pressure barometer can tell the pressure

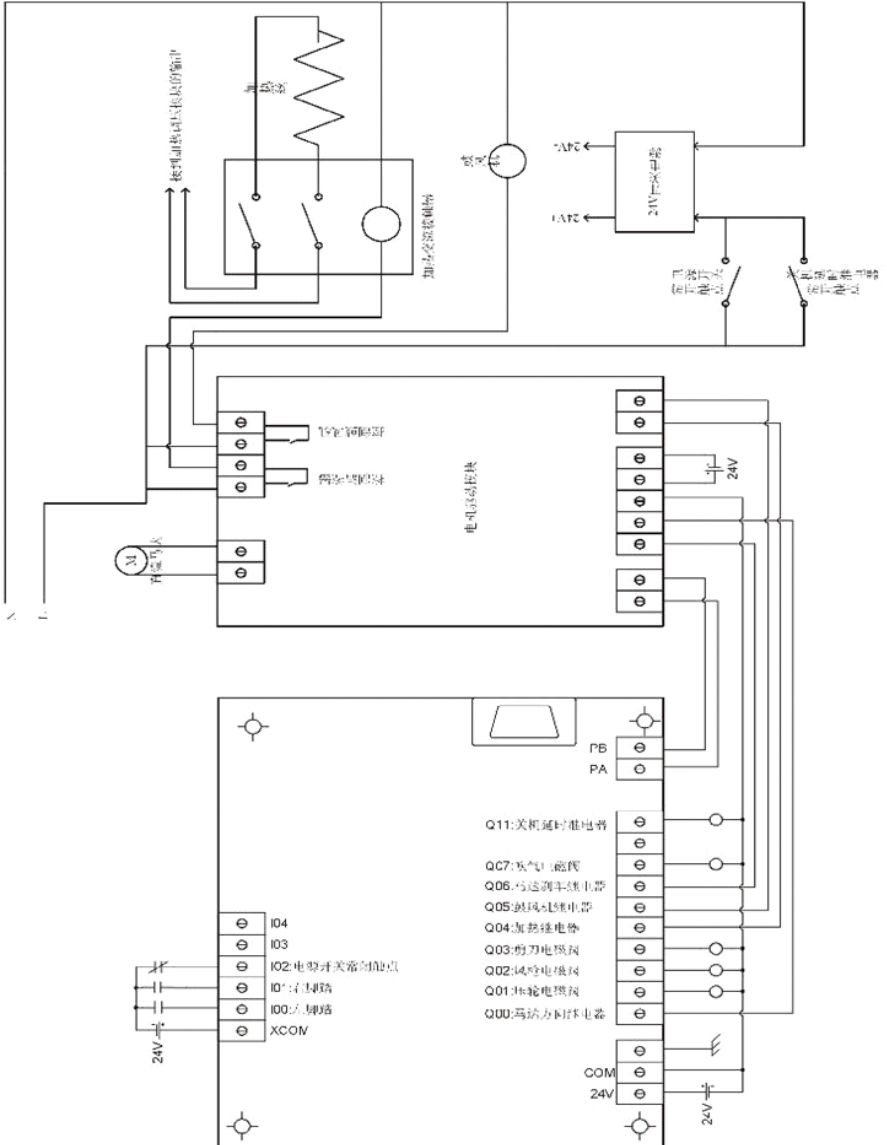
AIR ROAD CONTROL



PICTURE(6) Air road control



ELECTRIC LINE CONTROL





Malfunctions of machine and how to eliminate them A

N	Malfunction Phenomenon	Malfunction Reason	Eliminate Malfunction
1	Power switch on, no power or power pilot lamp not light	<ol style="list-style-type: none">1. Pilot lamp damaged2. Fuse damaged3. Nozzle air pressure not high enough or Air pressure controller with high air pressure when open4. Power switch damaged	<ol style="list-style-type: none">1. Replace pilot lamp2. Replace fuse3. Adjust nozzle air pressure or adjust lower pressure of air pressure controller4. Replace Power switch
2	Press Pedal, machine not work	<ol style="list-style-type: none">1. Air pressure not enough2. Solenoid Valve damaged3. Relay damaged, its pilot lamp not light4. Malfunction of Speed adjustment	<ol style="list-style-type: none">1. Improve general enter air pressure to 0.35M Pa2. Replace related Solenoid Valve3. Replace related Relay4. Contact us
3	Press Pedal, machine working not right	<ol style="list-style-type: none">1. Air Pipe Plug not right2. Main circuit diagram connection wrong	<ol style="list-style-type: none">1. Adjust air pipe plug2. Contact us
4	After auto cutting tape, upper roller not up	Upper pole Cylinder damaged	Replace Upper pole Cylinder



Malfunctions of machine and how to eliminate them B

N	Malfunction Phenomenon	Malfunction Reason	Eliminate Malfunction
5	Motor move first, Nozzle not down	<ol style="list-style-type: none">1. Adjustment Bolt position not right2. Machine set wrong parameter	<ol style="list-style-type: none">1. Adjust Adjustment Bolt position and lock it2. Reset Machine Parameter
6	Digital show control thermometer appear wrong temperature	<ol style="list-style-type: none">1. Set not suitable parameter in the Thermometer2. Heater short	<ol style="list-style-type: none">1. Adjust Thermometer parameter (Under guidance of our technician) or according to this Manual2. Replace Heater
7	Others		<p>Contact us Tel: +86 21 65437622 Email: john@joegoing.com</p>



Quality win the market

Service win the customer