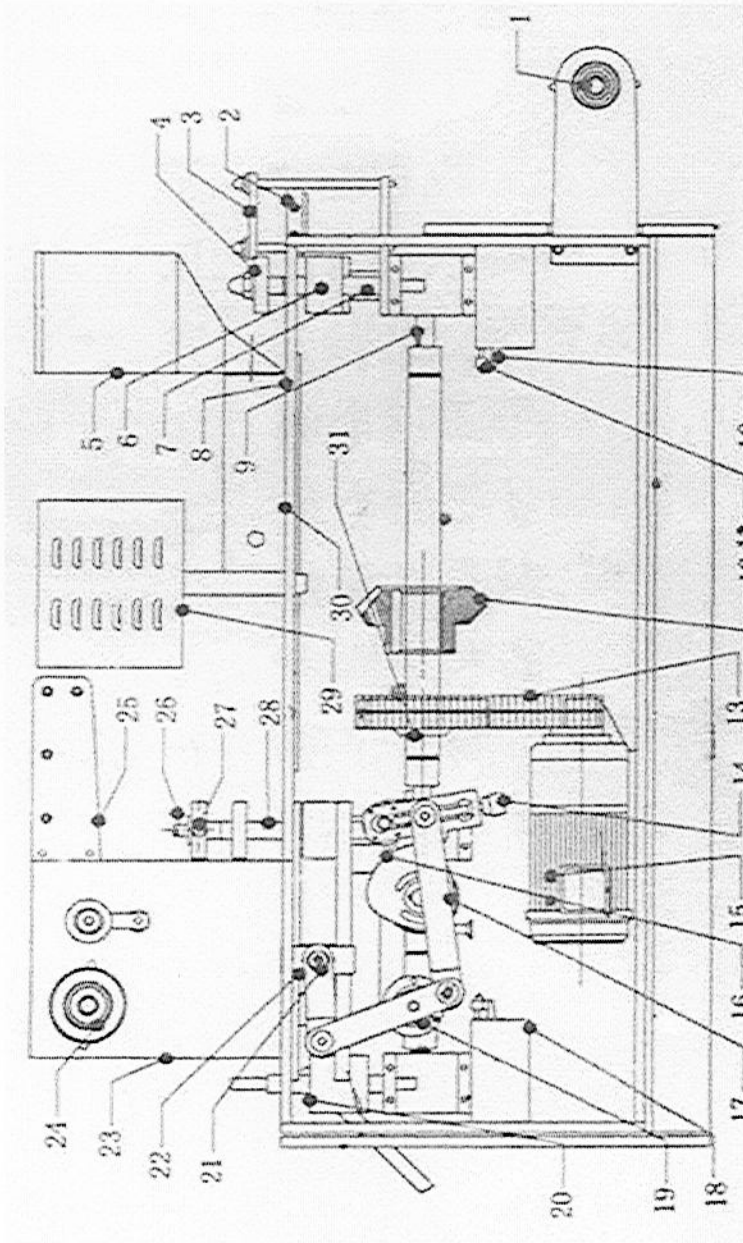


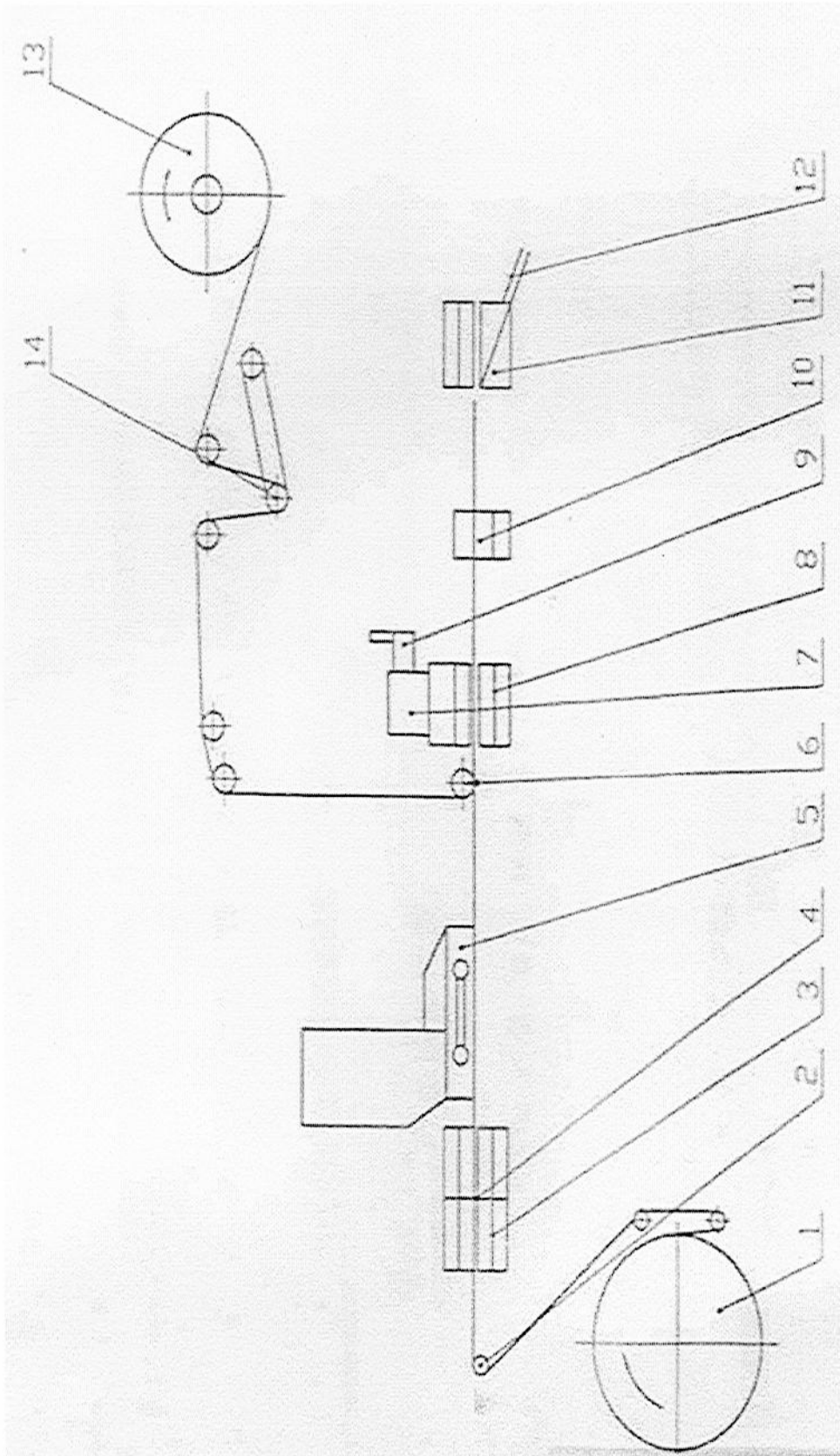
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1. Machire's figure



- 1. PVC swivel joint holder
- 2. Upper & lower heating plates
- 3. Heating cover plate
- 4. Formation cover plate
- 5. Middle guider plate
- 6. Middle guider plate
- 7. Formation column
- 8. Face guide rail
- 9. Connecting axle bush
- 10. Adj. screw holder
- 11. Adjusting seat
- 12. Bevel gear
- 13. Drive chain
- 14. Adj. member
- 15. Elec. motor
- 16. Concave wheel for stroke
- 17. Rock arm
- 18. Punching care
- 19. Rother bearing
- 20. Punchin mould
- 21. Stroke bearing seat
- 22. Stroke locating axes
- 23. Label
- 24. PTP Bearing seat
- 25. Aluminum case bracket
- 26. Hot sealing press roll
- 27. Hot sealing press wheel
- 28. Hot saling pole
- 29. elec. cabinet
- 30. Feeder
- 31. Transmi ssion



- 1.PVC plastic axes
- 2. Swivel-joint roller
- 3. Lower formation heating plate
- 4. Upper formation heating plate
- 5. Feeder
- 6. Aluminum foil swivel joint roller seat
- 7. Hot sealing press wheel
- 8. Lower hot sealing die holder
- 9. press wheel handle
- 10. Stroke air trap
- 11. Punching mechanism
- 12. Trash receptacle
- 13. PTP aluminum foil load shaft
- 14. Upper swivel-joint roller

2. Summarize:

The Model DPP-80 Automatic Al-Plastic Packing Machine series, used for the packing sealed with Al-Plastic composite, is featured by a prolonged guarantee period, attractive product appearance, and low packing cost. With a small space occupation, less investment required, multifunction, efficiency, no pollution, and low noise, the packing machine series are ideal packing equipment for cleaning shops and reagent preparation rooms in hospitals.

3. Applications:

The machine is used for the blister packing of capsules, plain tablets, sugar-coated tablets, gelatin pill, injections, special-shaped tablets, medical instruments, foodstuffs, electrical elements etc.

4. Specifications:

Punching Frequency:	18~35 times /min.	Capacity:	(1plate/tine)
Standard plate:	57×80mm (Standard), 57×88mm and 95×60mm		
Capacity:	(1plate/tine)		
Adjustable scope of fravel:	30—105mm (It can design by customer's requirement)		
Max. formed area:	95×60 (mm)	Finished product rate:	>98%
Motor pomer:	0.37kw	Heating power for formation:	0.8kw
Lower heating power:	0.8kw	Heating power for hot sealing:	0.8kw
Air pump capacity:	>0.15m ³ /mm (Customer-supplied)		
Cooling:	Recycled water or running water		
Weight:	300Kg		
Overall size (L×W×H):	1560mm×440mm×950mm		
Packing material specifications:	Medicinal PVC: 0.25×88mm; Al foil: 0.02×88mm		

5. Installation and notify:

1. The machine is complete and no installation is needed. With rubber castors provide under the base, the machine is mobile.

2. Specialized personnel must be designated for the machine operation and maintenance.

3. Should according to the label appointment position to contact the earth line

4. Keep the machine clean.

5. Put oil to each location which should be lubricated before production begins.

6. As no lubricant is put in the gear box when the machine leaves the factory, so must put the lubricating oil before production.

7. The pressure for formation, hot sealing, and indentation cannot be too great. Otherwise the machine service life will be shortened. The cushion for the formation and indentation should have room of 1 mm.

6. Preparations before operation:

1. Power connection : Connect the machine with a power supply (220V/single phase/50Hz) according to your local power consumption safety regulations. Turn on the power and set the machine in a crawl operation to see whether its operation is well.

2. Cooling water supply: According to the indications of the label on the machine to inspect the cooling water inlet and outlet switches for leakage. Besides, the water should flow smoothly.

3. Air pump: Connect the air compressor with the machine air line switch and turn on the compressor. Keep the air pressure at 0.3~0.5Mpa for operation.

4. Lubrication: Put oil into the shift gear box to the 2/3 box capacity.

5. Charging: Charge PVC plastic onto the load shaft. Adjust the inside and outside taper nuts and press the nuts tightly. Adjust the PVC material, subject to the rails on the charging deck.

7. Operation:

1. Turn on the power supply switch and the green indicator lamp is on. Put the two switches for upper and lower formation and hot sealing to the position.

“ON”. Generally, preset the formation temp. controller to 90°C~100°C and the hot sealing temp. controller to 120°C~140°C but concretely, the temp. for both the formation and sealing should be set depending on actual situation such as PVC material quality and ambient temp.

2. Do not start the machine till the temp. for formation, sealing and heating plates comes to the preset values. The PVC formation operation in advance, in which the formed blisters should comply with the hot sealing die holes and then by putting down the handle for the hot sealing die holder, charge aluminum foils, during which inspect the blister sheet position.

3. If the sheets deviate side to side, adjust the handle wheel of the swivel roller holder for correction.

4. If the blistered sheets prove qualified, begin to charge the material. First open the charger gate properly to let a proper amount of medicine (tablets, capsules or sugar-coated pills) enter the charging chamber. If only a few blisters are not filled with the medicine, manual filling can be made, when pay attention not to injure your hand or damage the aluminum foil. If the blisters not filled with medicine is located on one side of the hot sealing die, do not make up for failed fill constrainedly, for inaccurately-filled medicine may

affect the filling synchronized operation. If a foil is found adhering to the die upon the foil sealing, shut down the machine for troubleshooting.

5. After the material is charged, increased medicine weight and gradually-varied aluminum foil tensile and machine temp. may result in asynchronous formation and hot sealing, such as leading or lagging, when check whether there is any obstruct between the PVC and the foil and then adjust the machine by inching of machine .The fault can also be eliminated by moving the front case body but its moving correction can only be decided by inspecting more than a dozen sheets processed after the moving.

6. Temperature, pressure and net-patterned sheet flatness testify the quality of hot sealing (even, firm and flat adherence) between the plastic and the aluminum foil. Poor sealing is generally owing to slightly-low temp. and pressure. Adjust temp. and pressure to eliminate the failure.

7. If deviated sheet punching occurs, shut down the machine to adjust the case body or the die for its correction.

8. The machine operator has to know the mechanical principles of the machine. As the up-and-down motion of the middle guide plate is driven by a cam, upon the upper form board adjustment, pay attention to move the lower forming die or hot sealing die to the upper dead center before fastening the column nut. Otherwise failures will possibly occur.

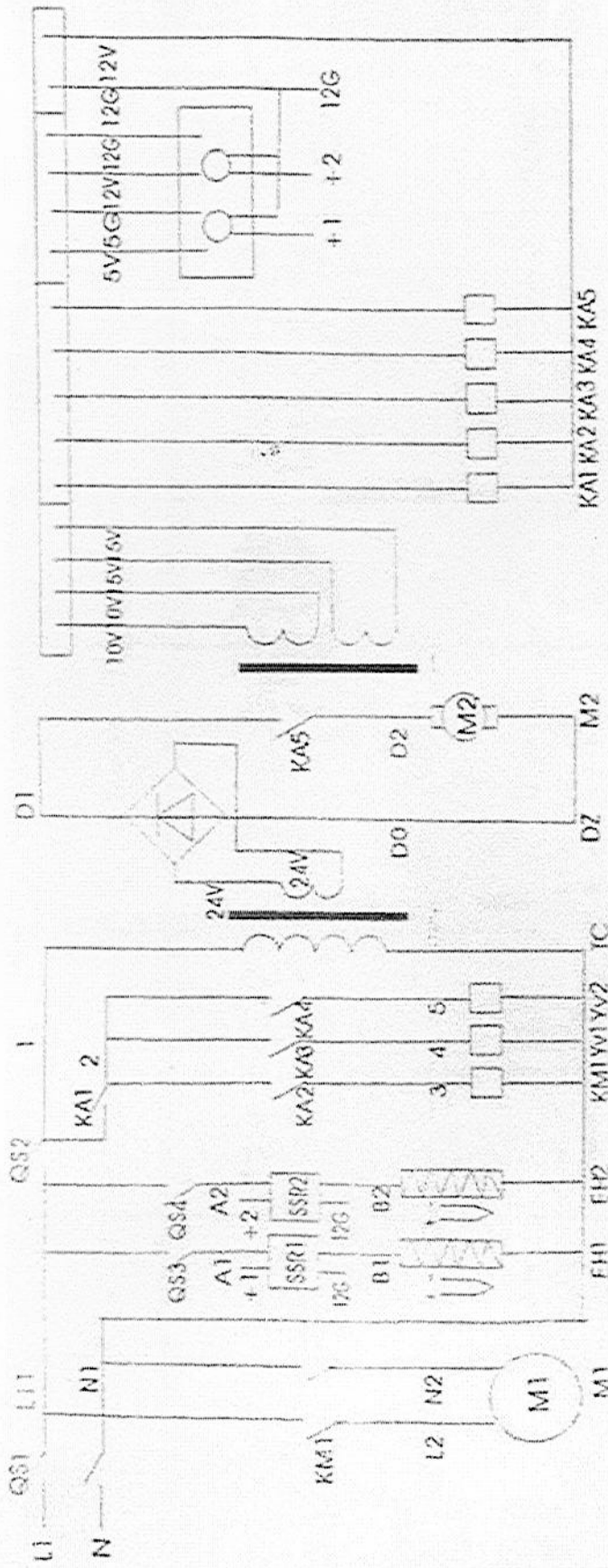
8. Troubleshooting:

Failures	Causes	Elimination
<p>Poor blister forming</p>	<ol style="list-style-type: none"> 1. Too great air flow at the operation site; 2. Too high or too low temp. at the heating areas; 3. Too much heat going by the excessive cooling water flow; 4. Air blowing time should not too late or early; 5. Pay attention to the water retained in the air- filtering valve; 6. Lower die air-exhausting holes clogged; 7. Air leakage through the plane between the upper and lower dies ; 8. Poor PVC plastic quality. 	<ol style="list-style-type: none"> 1. Lower the air flow; 2. Adjust and control the temp. properly by voltage control as far as possible and alternatively by the temp. controller. 3. Adjust the water valve to control water flow; 4. Calibrate the machine air releasing valve position to keep the air pressure generally to 0.3-0.5Mpa; 5. Check and clean the air-filtering valve; 6. Make the holes unimpeded with a steel needle; 7. Repair the dies with a plane grinding machine ; 8. Exchange PVC.
<p>Asynchronous operation(with formed blisters not accurately entering the hot sealing die hole position)</p>	<ol style="list-style-type: none"> 1. The forming die and the hot sealing die are not an integral multiple of the stroke; 2. Operating air pressure-causing holder parallelism too great or too small; 3. Poor forming die and hot sealing die cooling; 4. Obstacles exit between forming die and hot sealing die: 5. Poor running of the load shaft for plastic; 6. Hot sealing die temp. too high. 	<ol style="list-style-type: none"> 1. Adjust the die-type movable case body. (The case body has been adjusted before the machine leaves the factory and usually no readjustment is necessary); 2. Adjust the indexing seat shaft and apply machine oil to the shaft; 3. Properly increase the cooling water flow; 4. Check whether obstacles exit between the forming die and the hot sealing die, and pay attention

		<p>to the gap between the charging machine and the faceplate;</p> <p>5. Clean or replace the bearing</p> <p>6. Lower the sealing die temp.</p>
Aluminum foil crinkled or deviated	<p>1. Unparallel adherence between the aluminum foil and the PVC plastic;</p> <p>2. The aluminum foil turning roller not in perpendicular to the ordinate of the PVC plastic sheet;</p> <p>3. Rust or contaminants on the veins net;</p> <p>4. Poor bond between the veins net and the lower die;</p> <p>5. Uneven glue layer of the aluminum foil.</p>	<p>1. Tear away the foil and adjust the adhering position for adherence once more;</p> <p>2. Adjust the turning roller bracket and calibrate the dies;</p> <p>3. Remove the stains with a steel wire brush or a saw blade;</p> <p>4. Depending on the sealing conditions, grind part of the lower die plane with a oil stone;</p> <p>5. Exchange the aluminum foil.</p>
Poor hot sealing after deviated punching	<p>1. Incorrect distance between the punching die and the hot sealing die;</p> <p>2. Temp. too high or too low;</p> <p>3. Deficient pressure or deviated upper hot sealing cylinder.</p>	<p>1. The integrally-movable punching die case body has been adjusted before the machine leaves the factory. Adjust the case body only under imminent necessity;</p> <p>2. Adjust the temp. controller to keep the temp. constant at about 140°C</p> <p>3. Adjust the cylinder pressure by the pressure-adjusting valve and check the silicon rubber for any aging. Exchange the copper cushion between the cylinder and the hot sealing holder.</p>

DPP-80 Electrical Wiring Diagram

Power supply	Elec. motor	Formation	Hot seal	Host Machine	Tractor	Standby	Transformer	DC	Feeding	Computer powers	Computer control system	Computer temp. control system
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