一、Product overview……………………………………
二、Switch on electricity……………………………………
三、Operating………………………………………………
四、Production………………………………………………
五、control…………………………………………………
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Common fault solution and matters needing attention………………
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Semi-automatic filling packing machine is mainly composed of host, electrical distribution box filling of PLC, touch screen and electronic scale.

The filling packing function complete measuring, filling, etc. The machine all stainless steel, corrosion resistance; PLC touch screen man-machine interface, display in both Chinese and English, the operation is convenient intuitive; Conform to the state "QS" and "GMP" certification requirements; Filling adopts servo motor drive, mixing with Taiwan maintenance-free gear motor, stable performance, high precision packaging; Fully sealed, stainless steel and organic glass container combination, easy unpick and wash. The workbench convenient lift; Using special screw filling, computer real-time tracking, it has high speed and precision; All kinds of packaging parameters can be stored, can store up to 10 formula; For larger dust material packaging, can be added with dust collection system, clean workshop environment; By changing the screw attachment can adapt to milk powder, monosodium glutamate, solid drink, white sugar, glucose, coffee, medicine, pesticide, solid powder, granular additive, dyestuff, veterinary medicine and other packaging specifications for packing powder/ granule.

GF series automatic filling metering packaging machine have various models: there are single-machine, fully automatic, semi-automatic, canned, canned, bagged two machine and etc. Can adapt to different production requirements. (For the special materials, our factory can offer a special device.) Would you please read this manual carefully before using machine, so that more standardized maintenance machine, get the best working condition.

### 2. Technical parameters

<table>
<thead>
<tr>
<th>model</th>
<th>GF-1000</th>
</tr>
</thead>
<tbody>
<tr>
<td>Measurement methods</td>
<td>Direct call tracking and feedback</td>
</tr>
<tr>
<td>Packing weight</td>
<td>10—5000g (Transform the spiral components)</td>
</tr>
</tbody>
</table>
| Packaging accuracy | Packing weight 100 g or less deviation plus or minus 0.5 1 g or less  
> 100 g - 5000 g deviation plus or minus 0.5% or less |
<table>
<thead>
<tr>
<th></th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>Packing speed</td>
<td>10—50 Bags/min</td>
</tr>
<tr>
<td>Container volume</td>
<td>A30, B50 litre</td>
</tr>
<tr>
<td>power supply</td>
<td>Single-phase 220 v three-phase 380 v (or custom)</td>
</tr>
<tr>
<td>total Power</td>
<td>A1KW, B1.9kw</td>
</tr>
<tr>
<td>weight</td>
<td>A185kg\B260kg</td>
</tr>
<tr>
<td>Overall Dimensions</td>
<td>A800×750×1900mm, B800<em>850</em>2120mm</td>
</tr>
</tbody>
</table>
3. **Names of parts**

![Diagram of machine parts](image)

- **Screw Motor**: located at the bottom of the machine
- **Screw Attachment**: includes screws, hoppers, and hoppers
- **Parting Motor**: located at the top of the machine
- **Parting Port**: (Screw Attachment: screws, hoppers, hoppers)
- **Material Import**: placed at the bottom of the machine
- **Material Export**: (Screw Attachment: screws, hoppers, hoppers)
- **Screen**: placed at the top of the machine
- **Electronic Scale**: placed at the bottom of the machine
- **A type Work台**: (Screw Attachment: screws, hoppers, hoppers)
- **Foot Switch**: placed at the bottom of the machine
- **Touch Screen**: placed at the top of the machine

**Figure 1 (A type)**
4. Installation and adjustment

4-1. Install generally don’t have to establish a base. But casing need safety grounding (after the base to a grounding terminal to ground).

4-2. Move up and down worktable, change its export and filling the relative position, so that container can be easy to pass. Assembled electronic scale, place the electronic scale on the bracket, the cable and plug connected to the column on the left side of the interface electronic scale. Foot switch or infrared light electricity switch wire plug connected to the column on the left side of the interface should be corresponding.

4-3. Installation material box, screw accessories: material box, screw, material cup must be installed correctly, should according to sequence assembly and disassembly. Assembly sequence is: the container - screw feeding cup - the net. Disassembly sequence is: the net - cup, screw, material box, if not in accordance with the sequence of loading and unloading of the spiral and vulnerable to bending bin card.

料箱见图 1

![Material box components](image)

4-4. Close observation of screw and material of the eccentric degree: install screw, set is cup, should be able to easily set feeding cup holder. If there is friction, jam, unilateral by wait for a phenomenon, should increase or decrease suspension column gasket to adjust the concentricity, before that no set of feed cup, spiral around the circle core around, before and after the oscillation amplitude of the basic symmetry.

4-5. Watch stirrer installed correctly: installed container, spiral, cup, start the mixing machine. Agitator in rotation if there is abnormal sound, should immediately stop stirring machine. Observed deformation and container walls or spiral mixing motor whether touch, if touch, should move up blender or on the plastic
repair.

Note: it is strictly prohibited to not installed container will stir outside agitator exposed in the motor start, threatens the safety of operators.

4–6. Check whether the power supply is switched on. Note: empty machine screw can't long time running and observe the screw rotation direction is correct. You must stop if not correct, switching power supply phase.

4–7. Should ensure that sufficient to provide packaging materials, material in the material can not be less than 1/3 of the container to remember degree, otherwise affect precision of packaging. If material shall ensure that there is a certain space, in the material to fill the whole container will lead to the damage of the mixing system. (if the user has no feeding equipment should be matched to our factory form a complete set of automatic feeding equipment)

Note: it is forbidden to install the screw and not installed material cup will start a spiral.

A. Boot to electricity, wait for a few minutes, into the welcome screen
After the successful start, click on the "Chinese" button, enter the Chinese operation main interface; Click on the "ENGLISH" button, enter the ENGLISH operating main interface.

B. Enter the main interface to operate

B.1 Mainly produces operating interface, and interface:

B.2 Production recipe: to save or obtaining production parameters;

B.3 Parameter Settings: view or production parameters Settings interface;

B.4 Weight correction: weight value correction and the related numerical Settings interface;
B.5 Home page: return to the welcome screen;

C. Production into the interface

C.1 Pulse interface model production

C.1.1 Production for actual said left upper corner of the interface display area of the value.

C.1.2 Peel: the blue area on the left shows the actual said peel value for operation, made according to value of 0.

C.1.3 Filling weight: set the target weight of packaging production value, scope of numerical Settings: 0 ~ 30000 g.

C.1.4 Filling pulse: to set the filling screw motion parameters, set the value, the greater the filling screw motion, the longer the greater the filling weight. After the opening of the feedback function of parameter Settings interface, automatic feedback correction filling pulse number (see note parameter Settings). The scope of values: 0 ~ 65535.

C.1.5 Packing number: display the current total number of times a packaging.

C.1.6 Zero: to put the cumulative number of times a packaging is 0.

C.1.7 Save: to change the current parameters to save. If after the changes of production parameters, not click save button, cannot be saved when power supply drop.

: Display the current packaging control situation, under the parameters set interface can be changed.

: According to current working status of the machine, main show is: standby and processing in the two states.
According to material level, mixing, feeding working condition. In full, light continue to shine. Mixing and loading in the open, light continue to shine.

Packaging machine control button operation, can according to the requirements set up automatic mode or manual mode (see note meet parameter Settings).

Mixing and loading function switch.

C.2 Interface with direct said production

C.2.1 Pure bonus: when the actual filling weight reaches the set value, filling screw speed, the highest speed drop is starting speed。

C.2.2 Gap value: when the actual filling weight reaches the set value, screw filling stop motion, filling is complete.

The other parameters and pulse mode production the same interface.

D. Parameter is set into the interface
D.1 Every turn pulse: set screw rotation once required pulse value. The default setting is: 200. (not under the guidance of professional and technical personnel, please keep the factory default.)

D.2 Filling delay: hand, since the mode, in the last filling is completed after setting the delay time of the filling operation again. Parameter range: 1 ~ 60000 milliseconds, which is 1000 ms = 1 second, without delay, please set it to 0

D.3 Feeding delay: automatic mode, in the material level switch detects the material under, after setting of delay time, open the feeding motor. Parameter range: 1 ~ 60000 milliseconds, which is 1000 ms = 1 second.

D.4 Mixing time delay: in the filling process or when you start the automatic mixing function, detection to stop feeding or stop filling, after setting the delay time of stop stirring machine. Parameter range: 1 ~ 60000 milliseconds, which is 1000 ms = 1 second.

D.5 Starting speed: servo motor starting speed, as well as the essence of set bonus after the screw speed. Parameter range is: 1 ~ 3000. (not under the guidance of professional and technical personnel, please keep the factory default.)

D.6 Highest speed: the highest speed, servo motor for coarse feeding speed. Parameter range is: 1 ~ 3000. (not under the guidance of professional and technical personnel, please keep the factory default.)

D.7 Acceleration: starting speed switch with the highest speed acceleration. Parameter range is: 1 ~ 60000. (not under the guidance of professional and technical personnel, please keep the factory default.)

Fill the control mode selection, can choose pulse mode and direct said
Packing, loading, mixing control mode selection, divided into manual mode and automatic mode. (note: the motor is still in the process of running, switch control mode, the motor is not running or stopping situation may arise, then need to click on the motor control switch, until the normal situation.)

D.8 System plate number: view the current version of the controller, to avoid wrong operation.

Note: after to set each parameter, must save operation, otherwise cannot be saved when power supply drop.

F. Weight correction into the interface

Upper part shows the actual value, this interface can be set to at the upper part is need correction weight value.

F.1 Peel, peel and production in the interface functions are the same.

F.2 Calibration: correction of actual said.

F.3 Scope of filter coefficients: numerical Settings: 1 ~ 20, the smaller the value, the faster the reaction, image stabilization function; The numerical value, the greater the slow reaction, enhanced image stabilization function, numerical display relatively more stable.

Weight correction step:

1, remove all the things on the scale;

1、1, click the peel button;

2. place the calibration weight on the scale, and the weight of the weight value is set in the weight of the correction value;
2. click the calibrate button;

3. Check whether the correction is successful, if not successful, please repeat the above steps.

**E. Production recipe interface**

Loading: will choose the formula parameters loaded into the production of production.
Archive: to save the parameters of the current production to a specified formula in the group.
The goal of filling weight: according to save the filling weight value.
Control mode: if the display value of 1, is the pulse control mode; If the display value of 3, is the direct call control mode.
Return: return to the function selection interface.
故障分析与排除:

<table>
<thead>
<tr>
<th>fault</th>
<th>The cause of the problem and analysis</th>
<th>Failure analysis</th>
</tr>
</thead>
<tbody>
<tr>
<td>1、When filling the noise is too big</td>
<td>Container, screw, material cup of improper installation</td>
<td>See the instruction</td>
</tr>
<tr>
<td>2、The beaters from time to time noise</td>
<td>Agitator deformation, contact with the container 1、Noise reduction motor</td>
<td>Adjust the blender Repair or change motor</td>
</tr>
<tr>
<td></td>
<td>chain of sound</td>
<td>Adjust the chain</td>
</tr>
<tr>
<td>3、Don't feed (there are charging equipment)</td>
<td>1、Inside the suitcase is material 2、Material level is out of control on material viscosity 3、Material level, high sensitivity, or damage 4、Tube wall material, the feed motor is automatically protected 5、Feeding circuit malfunction 6、Motor damage 7、Agitator don't start</td>
<td>Cleaning material level Adjust or more refueling position Inversion of spiral feeder, cleaning, feeding tube Check, eliminate Repair or replace the motor Start the mixing motor</td>
</tr>
<tr>
<td>4、Kept feeding (configuration had charging equipment)</td>
<td>Material level sensitivity was low, low signal or damage 1、Is a line break 2、24v power supply damage 4、Whether automatic feeding way</td>
<td>Adjust or more refueling position Check, eliminate Check, eliminate Start the automatic feeding way</td>
</tr>
<tr>
<td>5、Don’t pack</td>
<td>The fill motor does not turn: the power switch is damaged, line breaks, fuse, ac contactor is damaged, broken motor damage. 1、Filling button or foot switch contact undesirable 2、Packing damage motor drives 4、Materials with other impurities will spiral stuck 5、Pulse number is set</td>
<td>Inspection, maintenance, ruled out Repair or replacement Replace or send factory maintenance Removal of impurities Set the number of pulses</td>
</tr>
<tr>
<td>6、Keep filling</td>
<td>1、Too large or pulse set disorder 2、Computer controller is damaged, the fill motor drives</td>
<td>To reset Replace or send factory maintenance</td>
</tr>
<tr>
<td>7、Packing weight deviation is too large</td>
<td>1、Works wrong choice 2、Some other impurities in the material 3、Feed not free to make the material in the material too little or too much</td>
<td>See the instruction Rule out other impurities Inspection, maintenance, material feeding device</td>
</tr>
<tr>
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<td>---</td>
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</tr>
<tr>
<td>4.</td>
<td>Not clean up the container for a long time, the material in the cabinet agglomerate</td>
<td></td>
</tr>
<tr>
<td></td>
<td>Clean the container</td>
<td></td>
</tr>
<tr>
<td></td>
<td>Weighing inaccurate: electronic scale come into contact with other objects, empty scale without peeling, vibration, aviation plug-in poor contact, sensor damage, damage of computer controller</td>
<td></td>
</tr>
<tr>
<td>5.</td>
<td>Inspection, maintenance, calibration electronic scale, replacement, or to send factory maintenance.</td>
<td></td>
</tr>
</tbody>
</table>