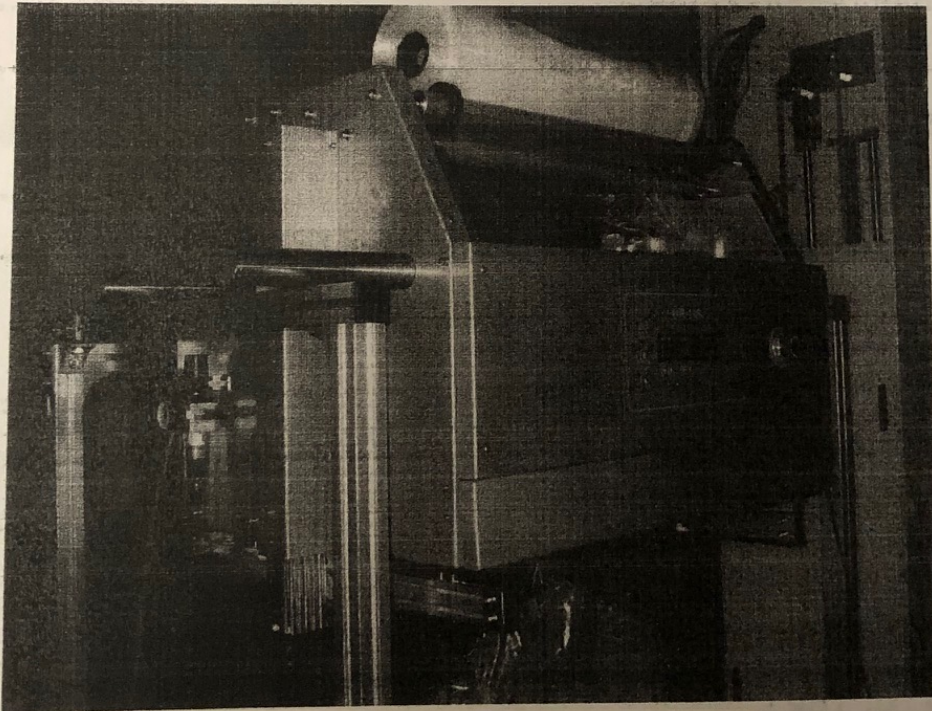


# Operation Manual

Automatic  
Bagger

**OH-70S**



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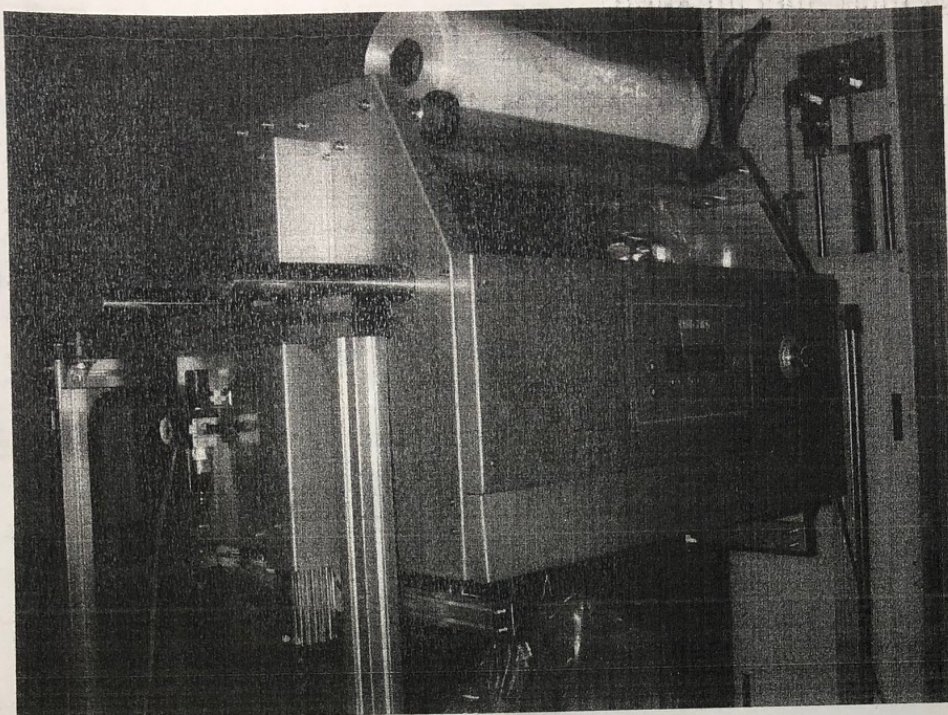
**SUNGJIN NC CO., LTD.**



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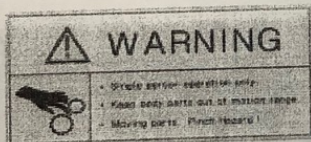




## 1. Safety Guide

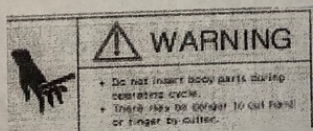
### Warning Label

(1)



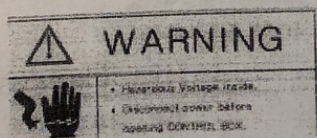
This area is on moving parts.  
Keep body parts out of motion  
area  
Be caution pinch hazard

(2)



This shows in cutting area.  
Keep body parts out of the area  
There may be danger to be cut  
hand or finger

(3)



Be caution of electric shock.  
Please disconnect power before  
opening control box.

Besides above the labels attached on the machine, other normal notes have to be informed to operator in advance to prohibit unexpected safety accidents.

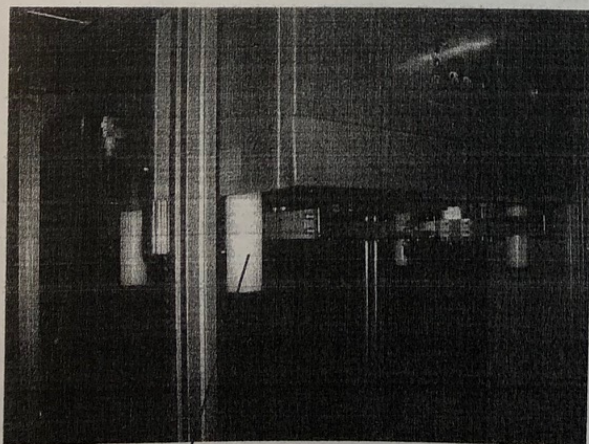


## 2. Machine Specification

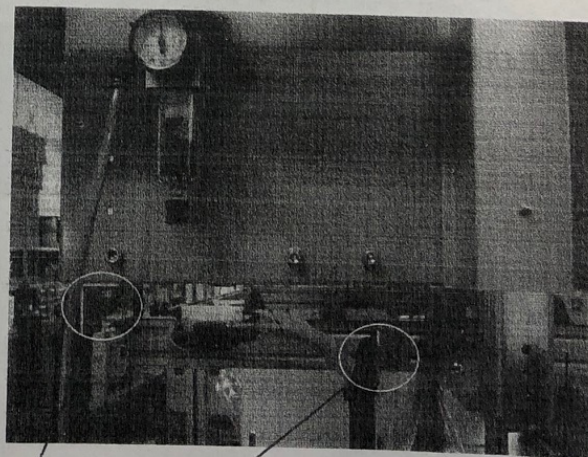
Measurement	W915* D580* H620mm
Capacity	Max. 400 Bags/hour
Mounting height	Abt. 2,000 mm (From the floor to the mounting pipe)
Clamp width	170mm
Weight	70kgs
Poly	21" wide with 7" gusset, Gauge : 0.018mm~0.020mm
Air Pressure	5 ~ 6 kg/cm <sup>2</sup> (72~85 PSI), Air hose : 5/16"
Power	110V 60Hz 1 P

## 3. Installation

This machine can be installed by mounting on the stand frame such as the below picture, or hanged on the bar from overhead pipes.



Remove the this 4pcs  
of plastic supporter with  
bit socket (enclosed)



Attach the cable bear  
brackets to here

The clamp set should  
be leveled.

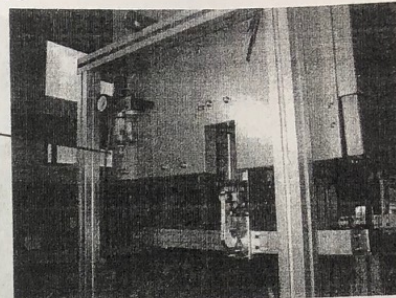


## 4. Operation

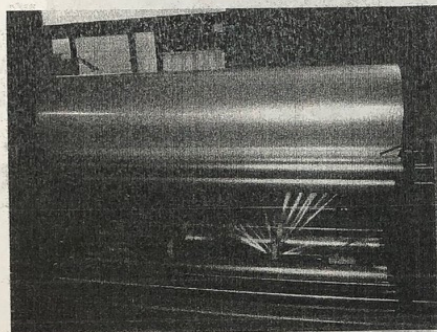
### 4-1 Preparation

The step of preparation for operation is as follows

- step 1. Connect electric cable to the power
- step 2. Connect air hose (5/16" ) to regulator

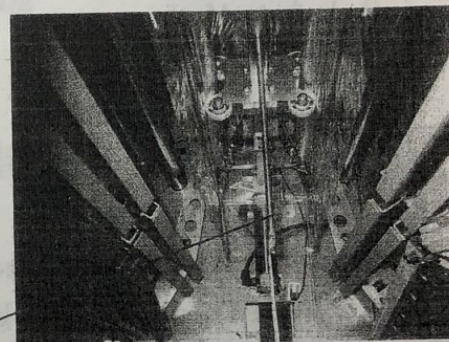


- step 3. Mounting the poly roll



The poly should be released from front side

Passing the poly like to the picture and pull down to 5" under the hook



Hook

- step 4. Control panel

- (1) Push <POWER>



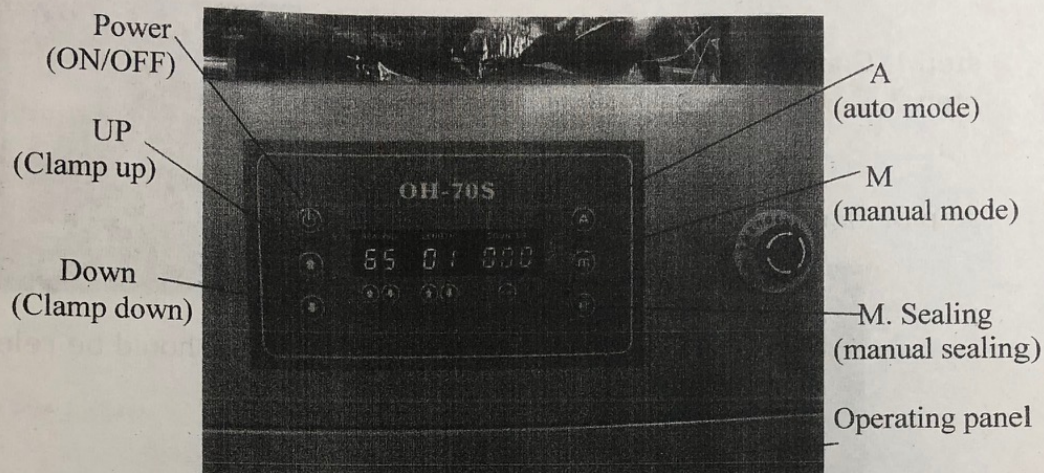
- (2) Push <□>, and let the clamp set go to middle of the machine height

- (3) Push <M.Sealing>, then tear the excess poly off
- (4) Push <↑> until the clamp set goes up to upper home position



## 4-2 Operation

After preparation, Select the mode " A " (auto mode), or " M" (manual mode) on control panel.



### 4-2-1. Auto Mode

step1. Push <A> .

step2. Put the garment on the hook

⇒ After about 1 sec, the clamp set goes down with poly and seal-cutting automatically

step3. When take the bagged garment out,

⇒ Then the clamp set goes up to home position automatically.

### 4-2-2. Manual Mode

step1. Push <M>

step2. Put the garment on the hook

step3. Push the <Operating panel> ,

⇒ then the clamp set goes down with poly and seal-cutting automatically

step4. When take the bagged garment out,

⇒ then, the clamp set goes up to home position automatically.

### 4-2-3. Manual bagging (For bagging too long garment)

step1. Push <M>

step2. Put the garment on the hook

step3. Push <Down>, and let the clamp set go to middle of height

step4. Push <Power>, then the power off and the clamp opened

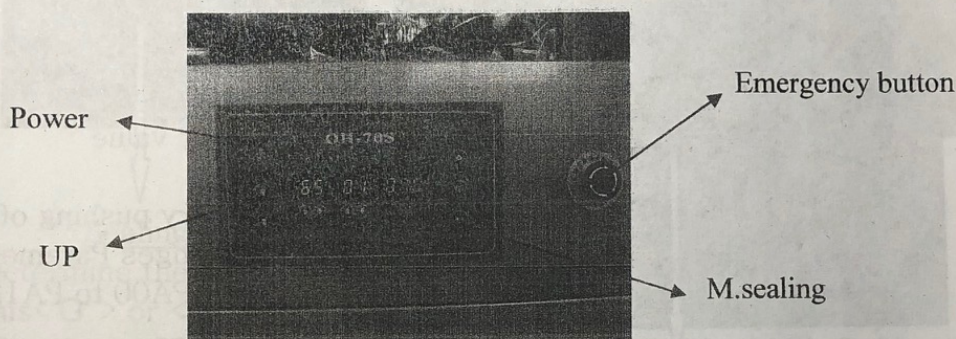
step5. Push <Power> again, then the power on.



- step6. Catch and pull down the poly with both hands.
- step7. Push <M.Sealing>
- step8. Take the bagged garment out,
- step9. push <UP> until the clamp set goes up to home position.

### 4-3 Trouble shooting

1. When the machine stopped by emergency button : (The lamp is on, but 110V off)



- step1. Push <Power> to be OFF
  - step2. Remove the causes
  - step3. Turn the emergency button clock wise to recover
  - step4. Push <Power> to be ON
  - step5. Push <M.Sealing>
  - step6. Take the garment with poly out
  - step7. Push <UP> until the clamp set goes up to home position.
2. Trip of Circuit breaker for overload ( All light of lamp off)
  - Open the rear cover and up the switch of Circuit breaker for recovery
3. Motor trouble (the clamp set does not move or of itself)
  - Check the relay for motor.
4. When the down limit sensor sensed,
  - step1. Push <Power> to be OFF
  - step2. Push <Power> to be ON
  - step5. Push <M.Sealing>
  - step6. Take the garment with poly out
  - step7. Push <UP> until the clamp set goes up to home position.

(Tip: It needs to raise slightly the clamp set with foot)

### 4-4 The end of daily work

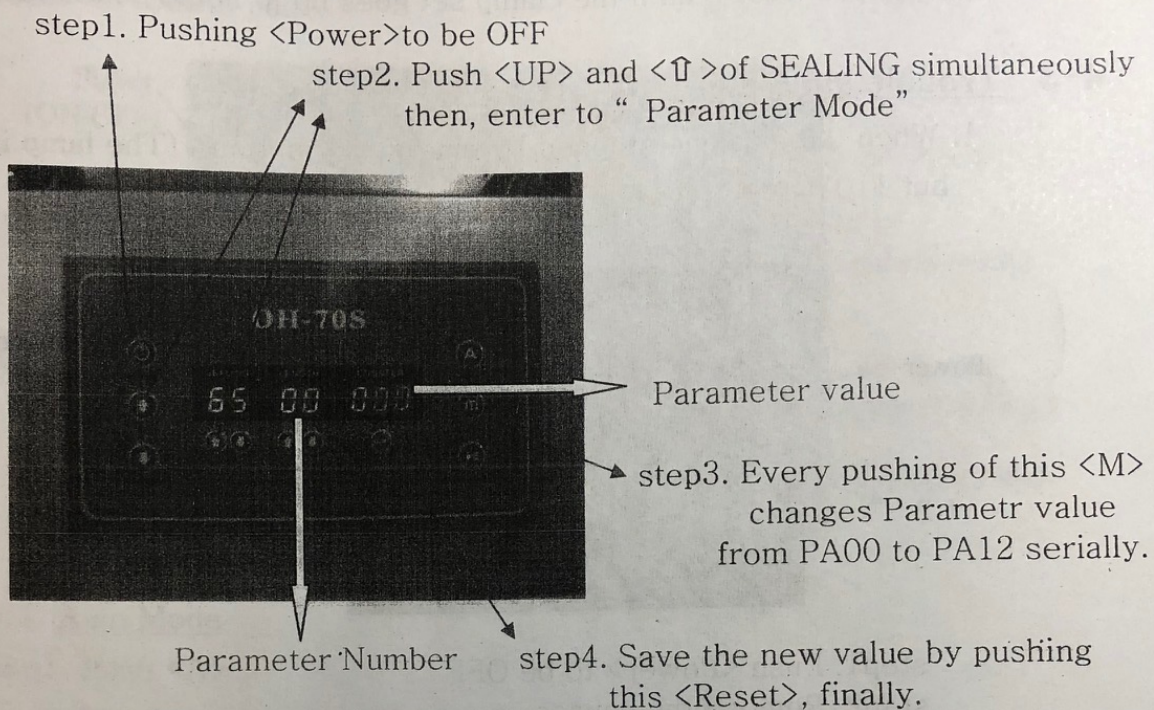
The clamp set should be located at upper home position after daily work to prevent the belt from damage, and then turn off power.



## 5. Maintenance

### 5-1 Change of Operation Condition

#### 5-1-1 How to input the Parameter (PA\*\*)



#### ● The List of Parameter

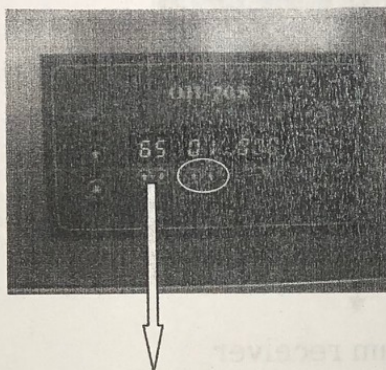
(These values of Parameter have been registered basically in factory, so should be kept except PA No.06 )

PA	Number	Value	Description
PA	00	10	No change
PA	01	10	No change
PA	02	35	No change
PA	03	07	No change
PA	04	10	No change
PA	05	01	No change
PA	06	10	Start delay time in auto mode
PA	07	0	No change
PA	08	1	No change
PA	09	**	No change
PA	10	10	No change



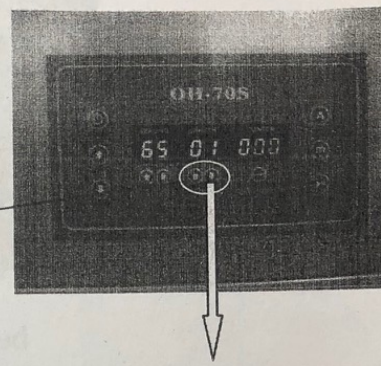
PA	11	1	No change
PA	12	00	No change

### 5-1-2. How to change sealing time and the poly length



#### Sealing time :

Determine the value by pushing this <□> or <□>  
(Standard : 65 ) **23 or 24**



#### Poly length:

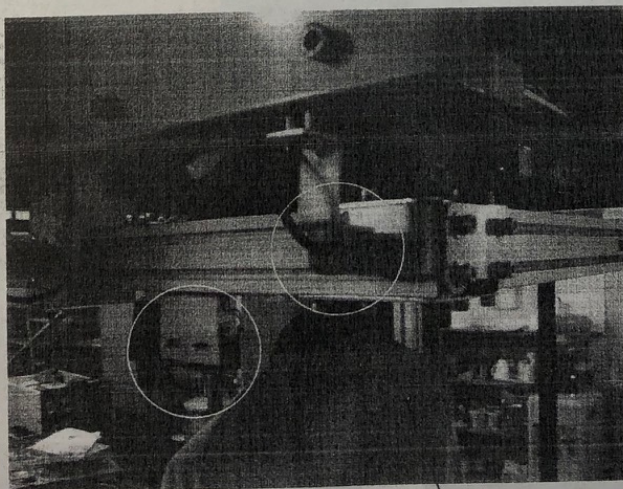
Determine the value by pushing this <□> or <□>  
(Standard : 0) **34**

Save by pushing these at simultaneously

\* Tip : The counter is counted every time the clamp set comes back to home position.

## 5-2 Checking main parts and maintenance

### 5-2-1 Sensors



#### Down limit sensor

This sensor is for down limit of clamp set in Auto-mode.

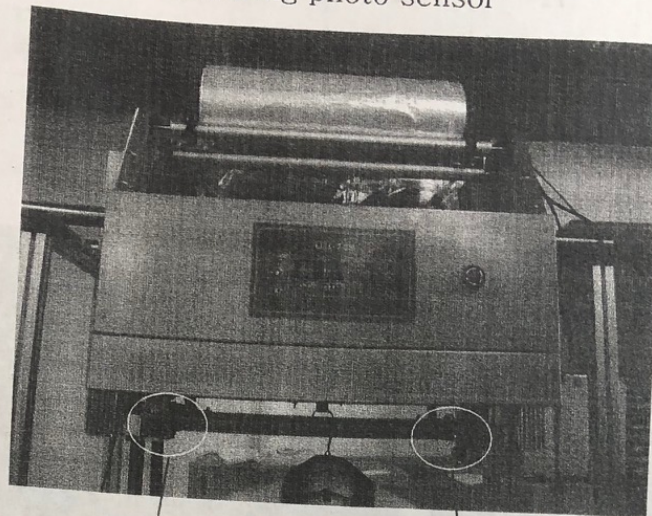
#### Upper home position sensor

This sensor is for upper home position sensor.

The position should be checked always.



(1) Garment length measuring photo sensor

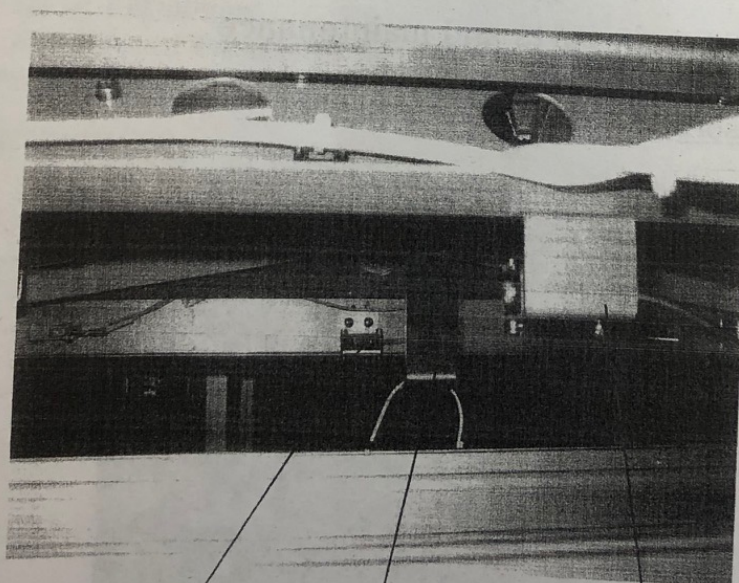


beam projector

beam receiver

This photo sensor is for measuring the garment length. The correct alignment is very important. The alignment should be checked always.

(2) Garment detecting photo sensor



beam receiver

Hook

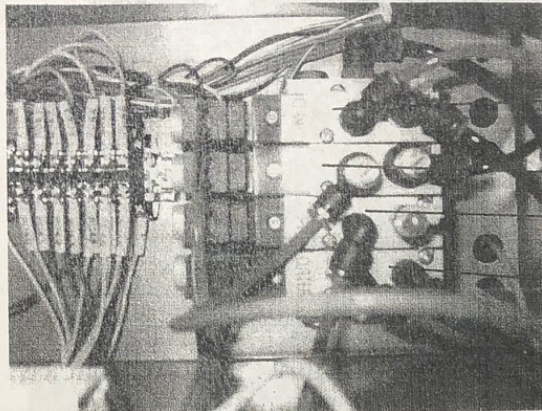
beam projector

This is the sensor for detecting the garment on hook  
The alignment of projector → hole of hook → receiver is very important. It should be checked always.



## 5-2-2 Solenoid Valves

(1) Solenoid valve for each air cylinder



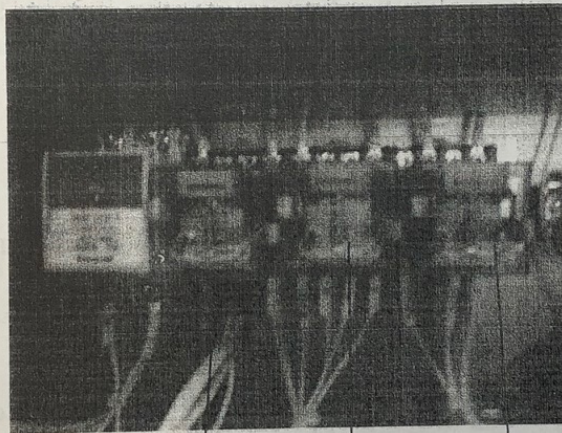
For clamp cylinder

For press cylinder

For stopper cylinder

For cutter cylinder

(2) Relay



Heater

Motor Up

Motor Down

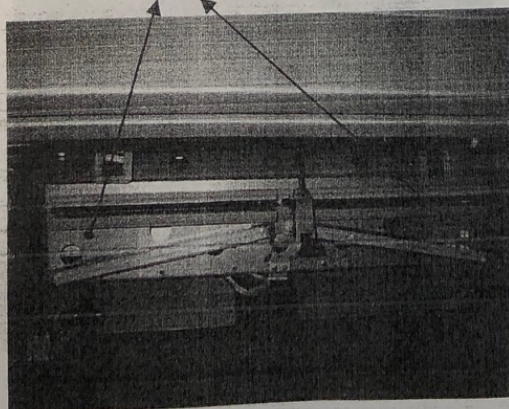
## 5-2-3 Cutter Blade

Clean frequently the cutter blade for long life and good condition with like to wood stick.

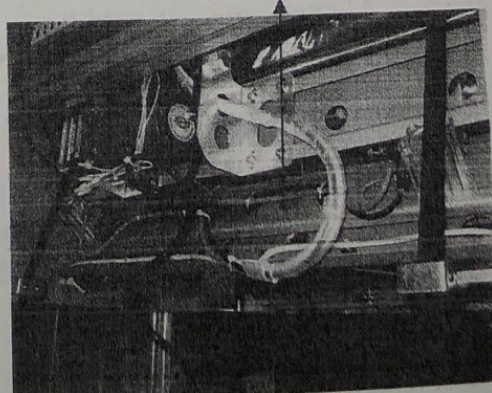
The unusable cutter blade should be changed with new one.

The step to exchange cutter blade as follows;

① loosen 2pcs of bolt

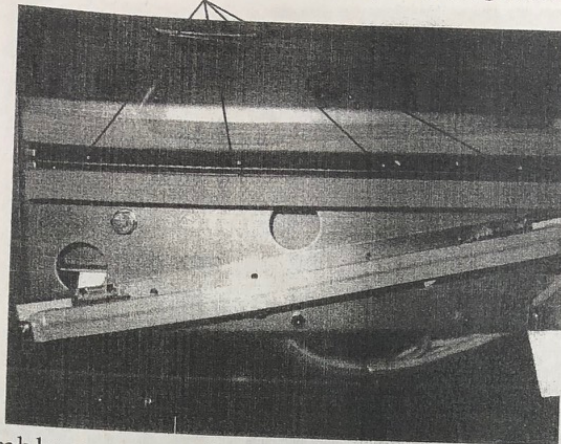


② Separate this bracket





- ③ loosen 4pcs of bolt, and separate cutter blade



Then, assemble new one by following above backward  
At that time, please carefully handle the cutter blade not to be hurted.

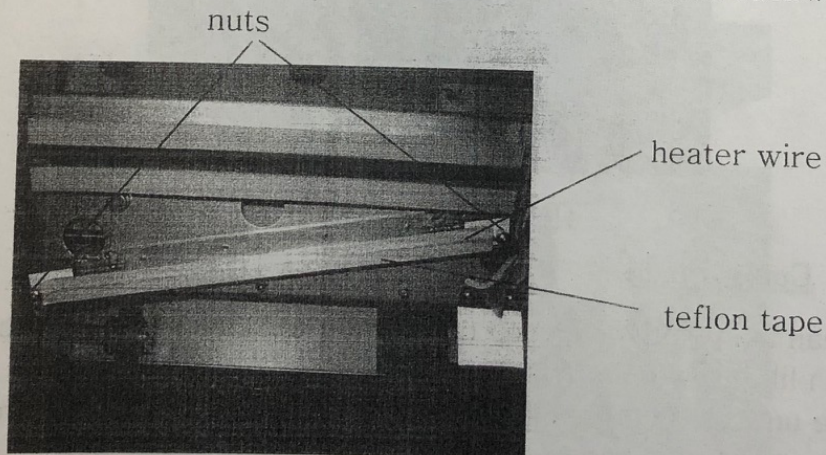
#### 5-2-4 Heater wire

When the heater wire is cut, change with new one like to bellow at once. ( It's better to change the Teflon sheet together. )

※ How to change the heating wire ;

- ① Strip the teflon sheet out
- ② Loosen both (right and left) nuts.
- ③ Take heating wire off.

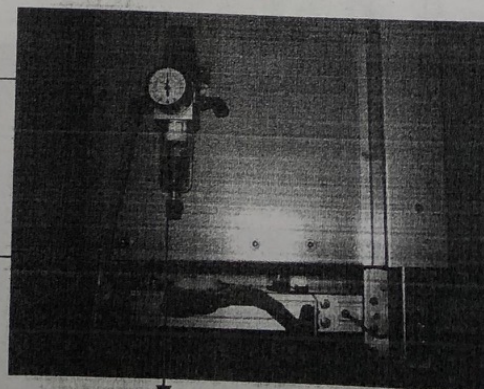
For assembling new one, follow this instruction backward.



#### 5-2-5 Air regulator

Air pressure should be kept at about 6kgs/cm<sup>2</sup>.

From Air compressor  
(Hose size: O.D. 5/16")

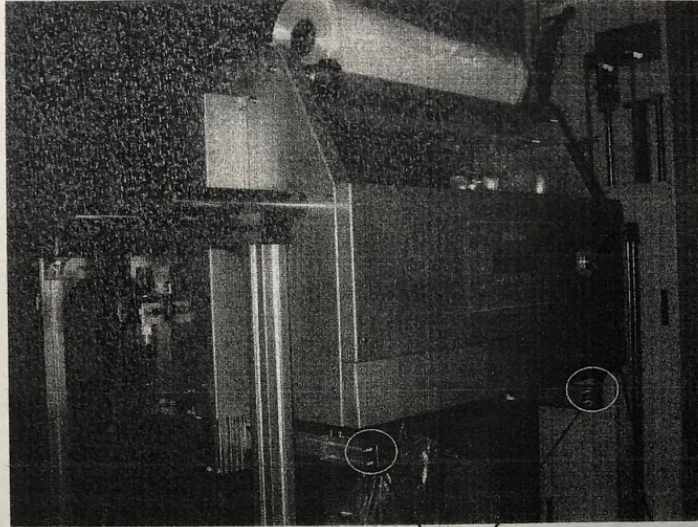


Auto drain



#### 5-2-6 Clamp set

Clamp set must be kept in level, If not, it should be leveled by adjusting the belt fixing bracket



Belt fixing brackets of each 4 corner

### 6. Accessories

1. Bit socket 1pce
2. Spare parts :
  - heater wire 1 pce
  - Relay 1 pce