

SF-828 Multifunctional bonding Machine

Operation Manual



is powered by

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➤ **Introduction**

Thank you for choosing SF-828 multifunctional bonding machine by H&H.

The SF-828 multifunctional bonding machine is a new product developed of different characteristics of fabric, can be sticking strip, overlap, folding and wrapping and other processes.

In order to fully understand how to use this machine properly, and avoid damage to both the machine and operating personnel, please read this manual carefully and keep it safe for future reference.

➤ Specifications

Model	SF-828
Voltage	220 V, single phase
Frequency	50/60 Hz
Power Consumption	2680W
Compressed Air	>0.4Mpa
Working width	6~20(mm)
Overall Dimensions	1220mm (L) x 700mm (W) x 1450mm (H)
Overall Weight	130 kg

Note: due to continuous improvement, specifications are subjected to change without prior notification.

➤ **Features**

- ✧ Multi-function selection job: sticking strip, overlap, hemming and wrappingfunction
- ✧ Up and down four heating devices to ensure a more solid fit
- ✧ Touch screen center control, easy to operate
- ✧ Freely pressure regulation, speed independent control, suitable for different fabric operations.
- ✧ Temperature automatic control, according to different fabrics with different adhesive tape to adjust the use
- ✧ Automatic feeding device, according to different tension control adhesive tape tightness
- ✧ Suitable for a variety of fabric bonding use

➤ **Preparation for Installation**

Installation must be carried out by authorized personnel. Follow the steps below:

1. Position the machine on a flat surface and allow at least 50cm clearance on both sides as well as the back side, this is essential for the hot air ventilation and also to allow enough room for maintenance personnel to carry out necessary service and maintenance
2. Adjust the foot stand so that the machine is level and stable.
3. Loosen all packing cable ties and materials in order to free up all machine movements.
4. Connect the power plug to a suitable outlet with at least 10A capacity. Make sure grounded and reliable.
5. Locate the air hose supplied with the machine. Connect one end to the inlet of the compressed air water filter at the back side of the machine; connect the other end to a compressed air supply such as air compressor or central air supply. Make sure the compressed air supply has at least 0.4Mpa (4 bar) of pressure.
6. Install the tensioner at the top of the machine and align the tape spool at right angle to the working table of machine. (see diagram below)
7. Turn on the power, later it will show the languages page. (shown in Figure 1)



Fig.1

8. Select the language, then it will turn to the main page. (shown in Figure 2)



Fig.2

9. The control center internal parameter setting is the factory value parameter (shown in Figure 3)

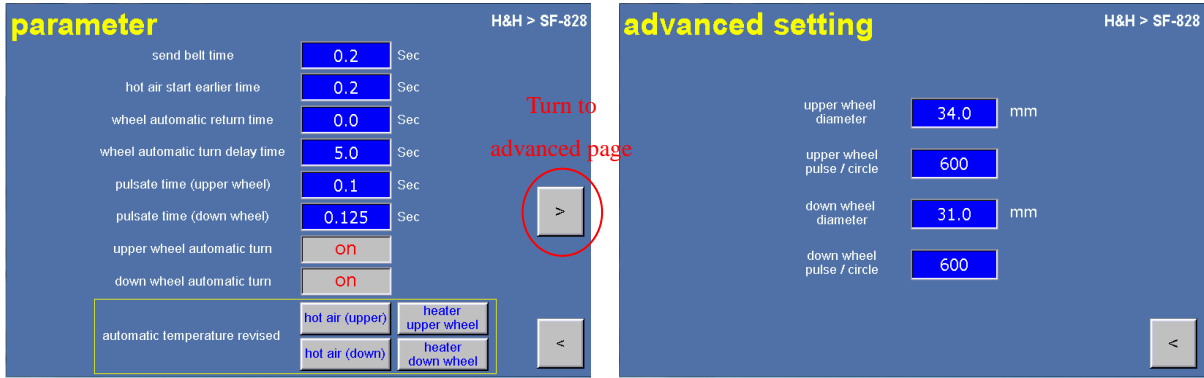


Fig. 3

Note: "parameter setting" factory password is "888888", "advanced setting" factory password is "88888899";

"advanced settings" parameter for the manufacturers to adjust the machine set the parameters, not free to change, otherwise it will affect the machine running performance.

➤ Boot test

■ Check the upper and lower wheel pressure

Adjust the top of the cylinder adjustable screw and lock cover

Press the foot switch of upper and lower mold at the same time

Gradually adjust the distance between the cutter wheel and the lower mold to change the pressure until you can completely cut the current work piece. (as shown in Figure 4);

A: the role of adjustable cylinder screw: adjust the distance between the upper wheel and the lower mold, to changing the working pressure;

B: the role of the lock cover: when the knife wheel and the lower mold spacing is better, tighten the fixed cylinder screw.



Fig. 4

➤ The choice and installation of the jet nozzle

- 1) The choice of jet nozzle: The machine is equipped with two jet nozzle, according to different functions to choose a different jet nozzle, sticking strip function is a separate nozzle, overlap, wrapping and hemming is a separate nozzle.

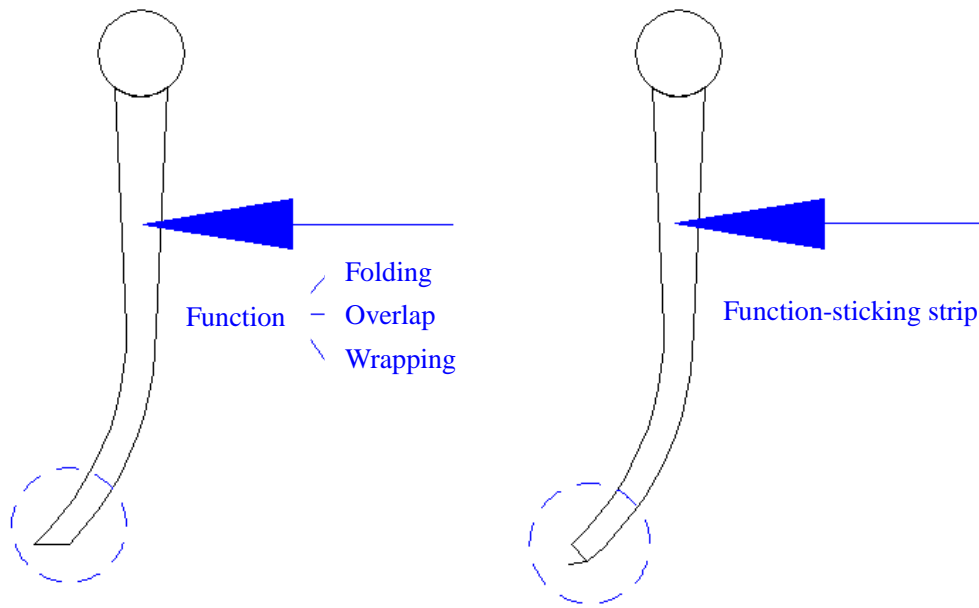


Fig.5

- 2) The installation of jet nozzle: Close the hot air adjust (upper) when installing the jet nozzle, that is tightened clockwise. "hot air indication" displayed as 0Mpa, After fitted with jet nozzle, In the upper wheel press down, the control center "upper hot air" in the "open" situation, press start stop pedal switch, the nozzle comes out automatically, the mouthpiece automatically protrudes you can move nozzle to find the desired location, after confirm the position, tighten the screws (as shown in Figure 6)

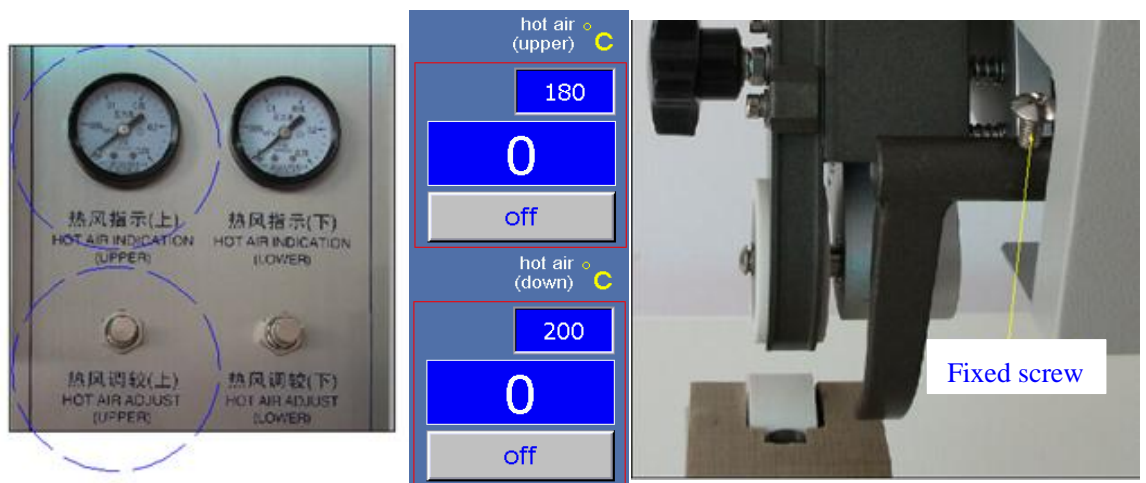


Fig.6

Note: the nearest distance between the gas nozzle and the heat conducting slot is about 1mm, which is the best distance (as shown in Figure 7).

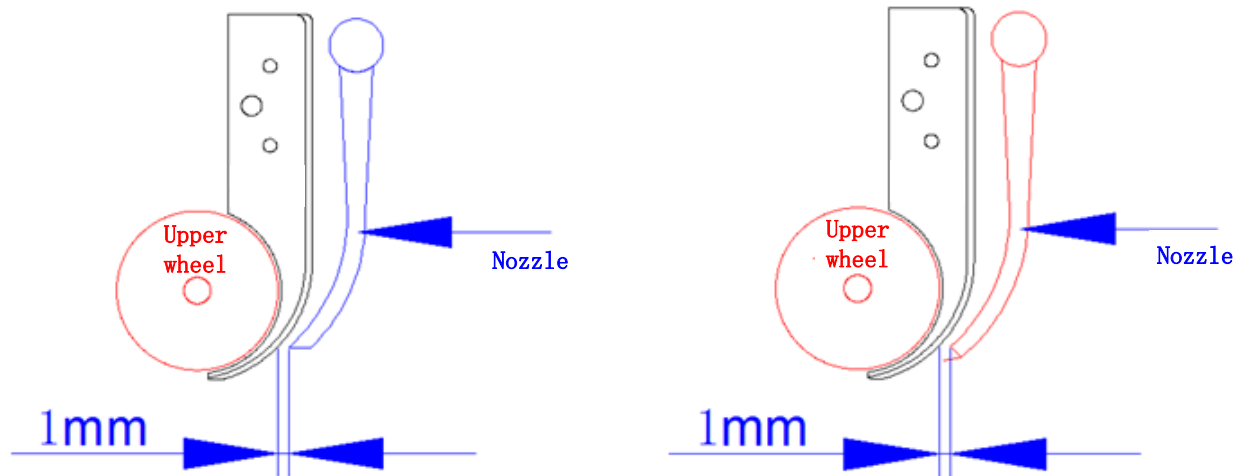


Fig.7

➤ The use and installation of each function parts

- 1) sticking strip function: After the adhesive tape is installed, you can use it directly. It should be noted that when the machine is doing the sticking process, the temperature of the “upper wheel heating” of the control center shall be lower than 25% of the adhesive strip temperature, and at the same time, the “lower hot air” temperature switch shall be switched off. Example: strip the actual temperature is 120 centigrade. The down wheel heating temperature should be about 90 degrees Celsius (as shown in Figure 8).



Sticking strip function

Fig.8

- 2) folding function: This function is used for cuffs and so on, Arc, straight and curved edges. adjust the position between it and the lower wheel before installing the folding brink frame, and tighten the retaining screws(as shown in Figure 9).

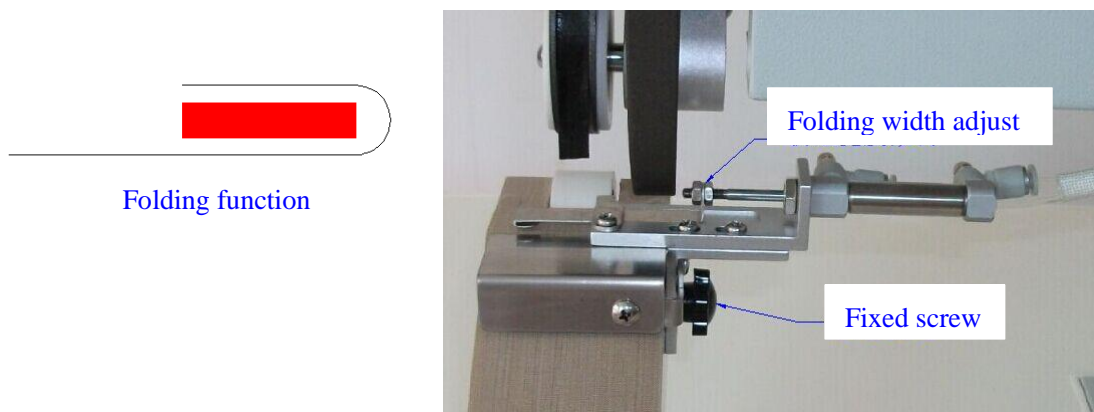


Fig.9

- 3) overlap function: This can be applied to overlap between two pieces of workpieces. Install the overlap device according to the picture, when you install, you can move the baffle, the width required to reach the overlapping cloth(as shown in Figure 10).



Fig.10

- 4) wrapping function: This function is suitable for all kinds of cloth single-fold wrapping operation. adjust the position between it and the lower wheel before installing the pack brink frame, and tighten the retaining screws(as shown in Figure 11).

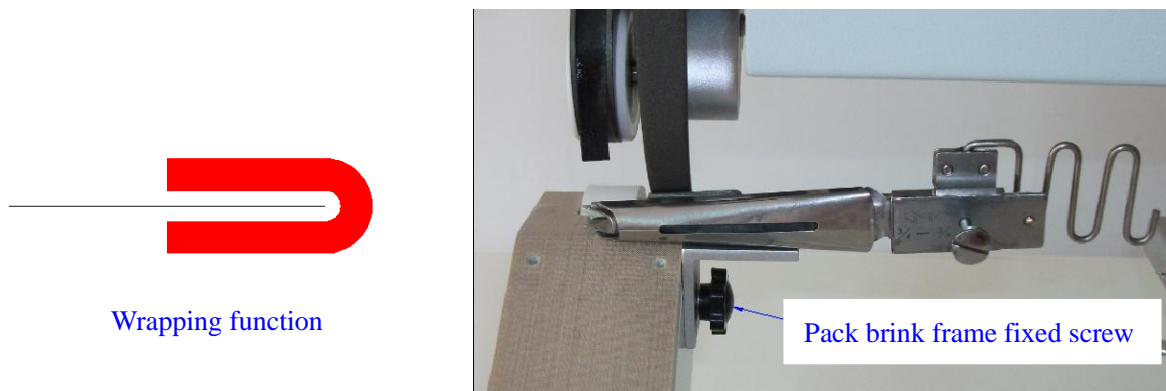


Fig.11

Note: In the use of folding, overlapping, wrapping function, The reading of the "hot air indication (lower)" table of the control panel must be less than the "hot air indication (upper)" reading, which can be achieved by adjusting the "hot air adjustment (upper)" and "hot air adjustment (bottom)"

➤ Belt inspection

- 1) As shown figure 12, tightening tension can be adjusted by adjusting the tension regulator (1) and tension adjuster (2) angle to achieve.



Fig.12

- 2) By adjusting the left and right movement of the biased device, the central distance between the adhesive tape and the cutting piece can be changed(as shown figure 13).

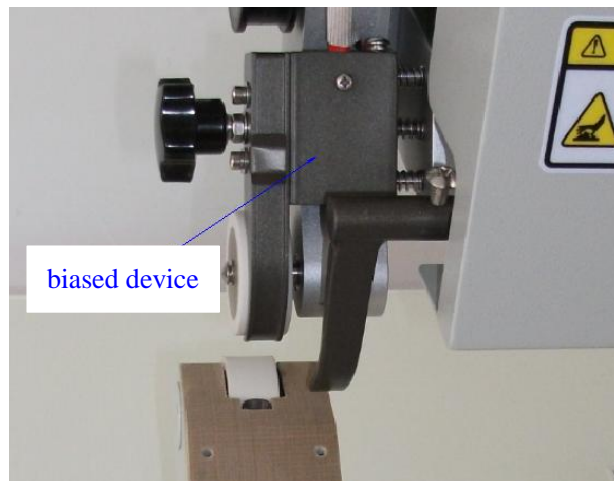


Fig.13

➤ **The role of the foot pedal(as shown Figure 14)**

1. Up / Down: The upper wheel is down or up. Press down one time and press again;
2. Start / stop: The action of the upper and lower wheels and the blowing start and stop. Press and hold, release is stopped;
3. Up and down: in the work to be a small turn when the rapid micro-beating up and down, making the turn more smooth
4. Folding: in the heel began to fix the pieces, the end of the arc and through the thick bone position is the telescopic effect. Press once to stretch, press again to shrink.



Fig.14

➤ **Control panel instructions (as shown in Figure 15)**

- 1) Hot air indication (upper): Upper blowing air volume display. At the same temperature setting, the greater the air flow, the higher the actual temperature;
- 2) Hot air adjust (upper): Adjust the air volume of the upper blow. Clockwise rotation of the air flow becomes smaller, counterclockwise rotation of the air flow becomes larger;
- 3) Hot air indication (lower): Lower blowing air volume display. At the same temperature setting, the greater the air flow, the higher the actual temperature;
- 4) Hot air adjust (lower): Adjust the air volume of the lower blow. Clockwise rotation of the air flow becomes smaller, counterclockwise rotation of the air flow becomes larger.
- 5) Pressure indication: The pressure between the upper and lower wheels is indicated.
- 6) Pressure adjust: When the distance between the upper and lower wheels is fixed. The upper and lower wheels pressure between the calibration.

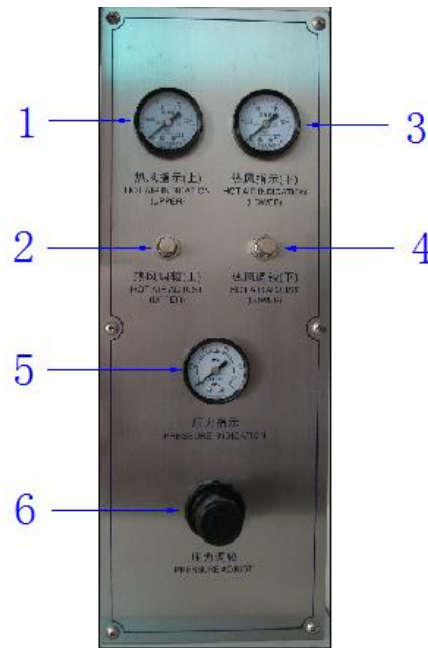


Fig.15

➤ **Boot steps**

- Adjust the temperature, pressure, speed, hot air volume required for the workpiece. In general, the speed ratio of the upper and lower wheels is 1: 1.2 (as shown in figure16-1) . When the hemming, overlapping, wrapping, the upper and lower wheel speed should be consistent (as shown in Figure 16-2).
- Foot press down the foot switch, the upper wheel press down.
- Foot press the foot switch, the upper wheel up.

Note: Stop working for a long time, the upper wheel should remain suspended



Fig.16-1



Fig.16-2

Maintain

■ Preventative

In order to keep the machine in top running condition, regular maintenance is important for trouble free operation. This will minimize possible down time and to prolong machine life.

- Check the tightness of the upper and lower wheel timing belt every 3 months, adjust the internal timing belt tension wheel can change the tightness of the belt;
- Always clean the upper and lower wheels and machine;
- Pay attention to the heating time, such as heating time becomes long, you need to check the heater is normal.

➤ **Appendix** **Wiring Scheme**

