

PALLET STRETCH WRAPPING MACHINE

GPPW-1500B

OPERATION MANUAL



20220406 ERP part no.



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1. GENERAL

1.1 NOTICE OF INSTALLATION

To make sure a safe and correct operation, please check conditions below before install the machine:

- 1) Power source capacity must be equal of the machine need.
- 2) Machine standard power is AC110v/230v (+- 10%)
- 3) Machine standard power Hertz is 50/60 Hz. (+- 2%)
- 4) Machine is workable under the temperature between 0°C - 45°C
- 5) Make sure the wire is tidy on the ground.
- 6) There should not have vibration beside the machine during the installation, and make sure to ground is flat.
- 7) Read and follow the instruction of the installation.

1.2 NOTICE OF OPERATION

To have good protection for the operator, please make sure the following conditions:

- 1) Before operating, please read the machine operational manual carefully.
- 2) Make sure there is no object put on the power cable.
- 3) Make sure there is no object put on the upper elevator unit.
- 4) Avoid any damp object or water around the electric parts.
- 5) Avoid film winded into the turntable.
- 6) Do not stand on or across the machine during operation.
- 7) When the problem occurs, please check the section of 5 Trouble shooting

2. SPECIFICATION

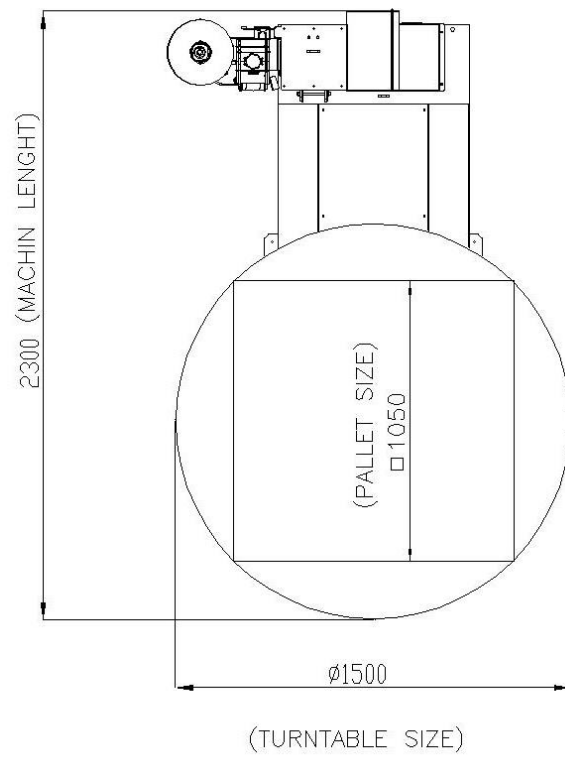
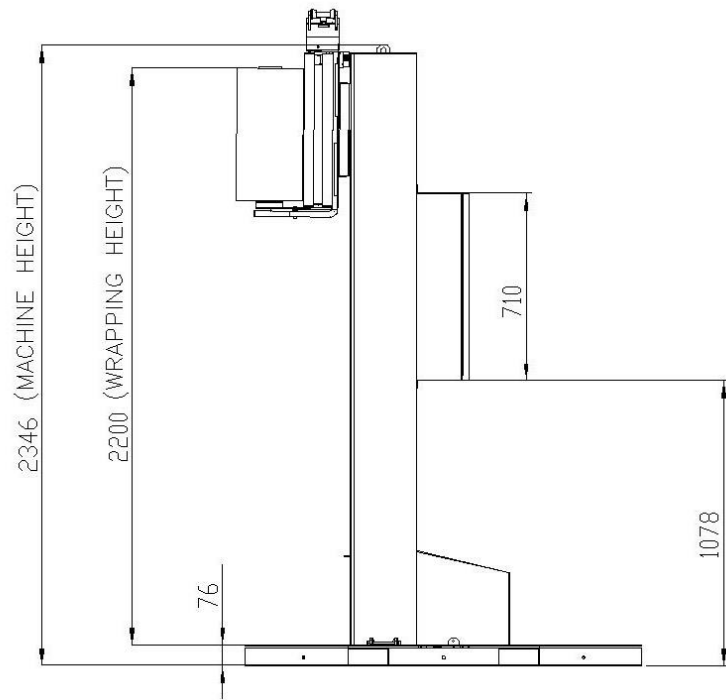
2.1 SPECIFICATION TABLE

| | |
|----------------------|------------------------|
| Model | TMD-P26B |
| Turntable Speed | 10 RPM |
| Turntable dia. | 1500mm |
| Max. Wrapping height | 2200mm |
| Max. Wrapping size | 1050x1050mm |
| Max. Loading weight | 1200Kg |
| Film stretch (%) | Infinite/manual adjust |
| Max. film spec. | φ250x500mm |
| Turntable height | 76mm |
| Ramp (slope) spec. | 1165x1000mm |
| Machine size | 2300x1500x2346 mm |
| Machine net weight | 335Kg |

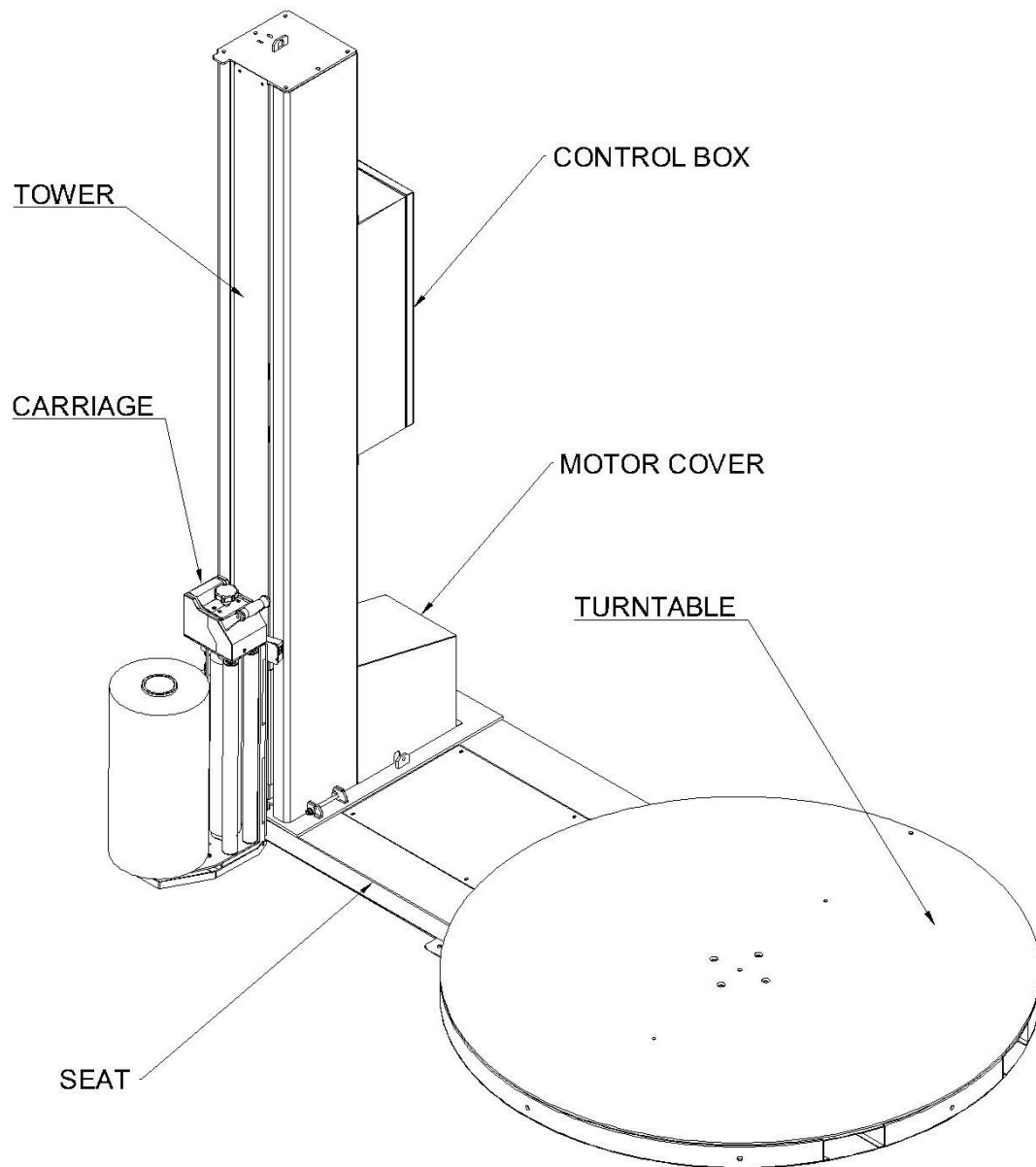
Standard option:

- 1.65 meters turntable dia. (Max Loading Weight 1650kg).
- 2.6 meters wrapping height
- 3.0 meters wrapping height
- Ramp

2.2 MACHINE DIMENSION



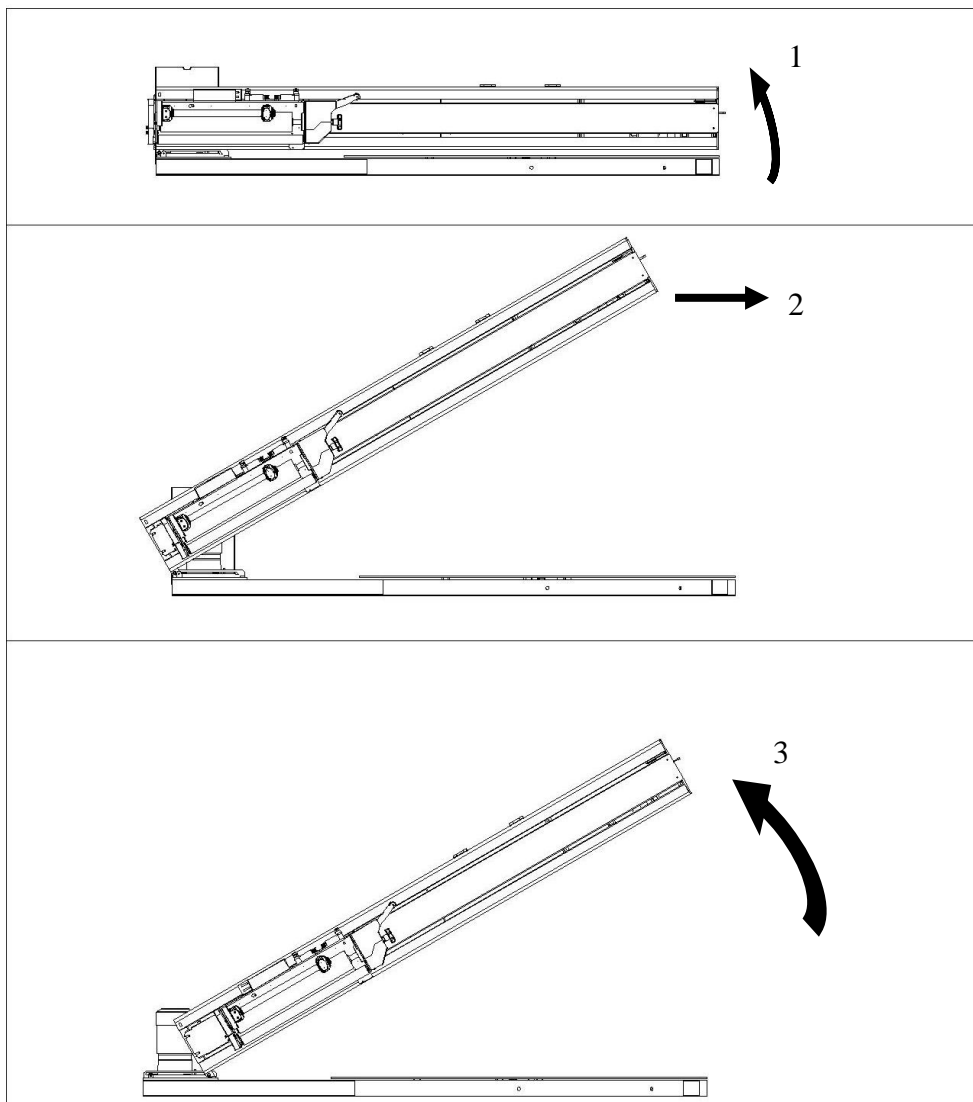
2.3 Machine Description



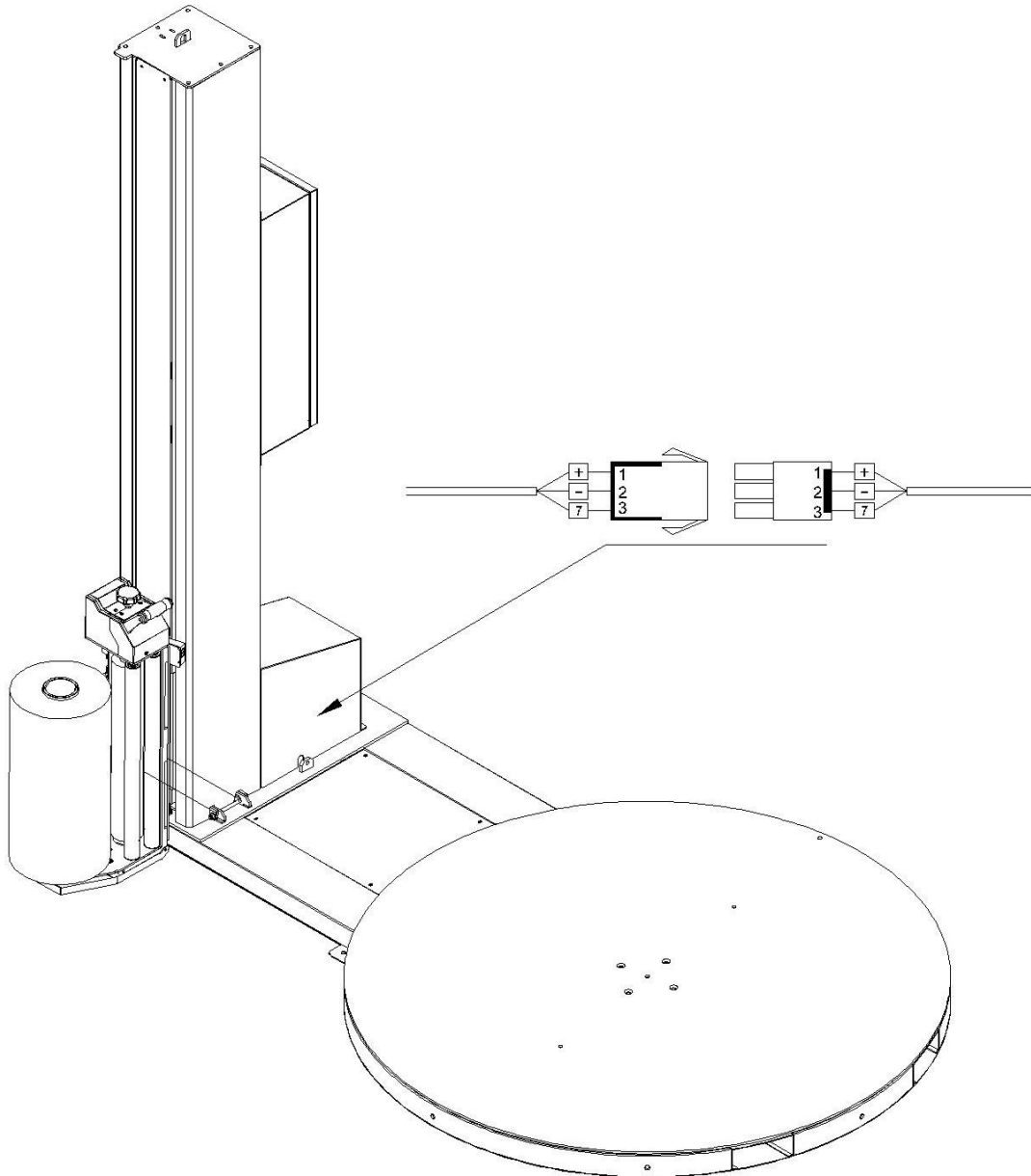
3. OPERATION DESCRIPTION

3.1 INSTALLATION

- 1) Apart the wooden package. Avoid damaging the machine.
- 2) a) Loosing 4 screws at the end of masters ◦ (Do not unscrew the sliding shaft, leave inside the track).
b) Lift up the master (Step 1).
c) Sliding the master towards turntable, until the sliding shaft move into locking position (Step 2).
d) Master is in position to be fully lifted and tighten all screws (Step 3).



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- 3) Connect the motor plug to the main control, by referring to the diagram below. Machine is ready to be connecting to the power cable with the socket by an 110V/230V power.



3.2 REMINDER OF INSTALLATION

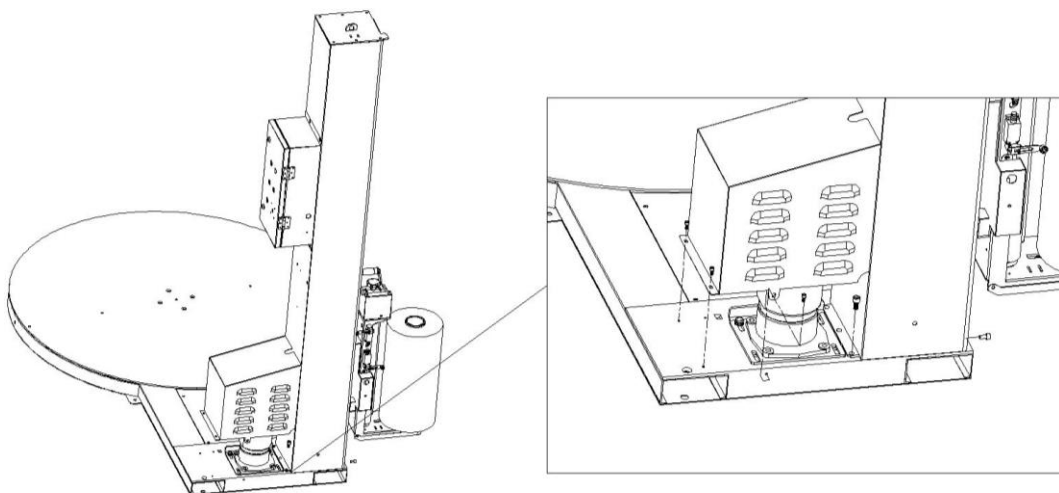
Please pay attention on:

Tower Installation

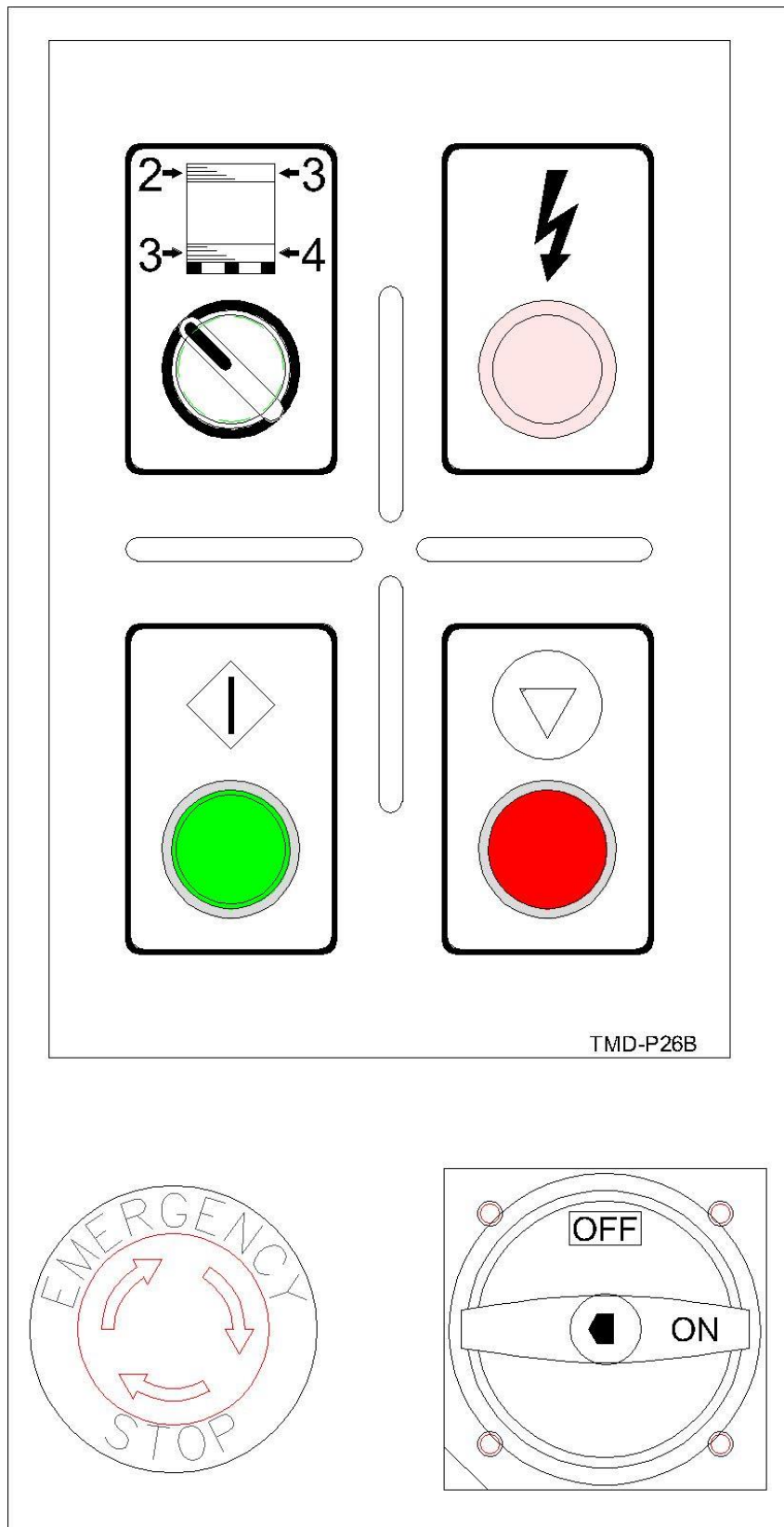
When installing the tower, the engineers must make sure all 4 screws are properly installed underneath the tower. 1 by carriage side, and 3 by the motor sides.

Motor Cover

After all the connections are complete, please carefully install the motor cover to cover up all the wire connections and the motor on the base of the machines.



3.3 OPERATION OF CONTROL PANEL



3.4 OPERATION DESCRIPTION



A. MAIN POWER

To switch ON and OFF the power



B. POWER INDICATOR

Show that power is ON when light illuminates.

Machine Running, LED "Continue Flash"

Power Cut circuit (EMG, KEY, ETC) Flash Twice.



C. MODE SELECTIONS

This selector is to choose the number of top and bottom

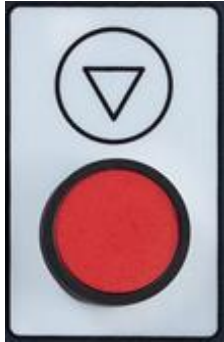
Mode 1: Top 2 wraps, bottom 3 wraps.

Mode 2: Top 3 wraps, bottom 4 wraps.



D. START

Press the button to get automatic program running.



E. PAUSE

During the wrapping cycle, if the machine is required to be stopped, press **E** button to pause the machine and press **D** button to resume back to operation.



F. EMERGENCY STOP

Press the button for emergency stop. For security consideration, the turntable will not be stopped instantly as the EMG. STOP switch is pressed. As the turntable power is switched off, the break will be release too. Turntable will be stopped in 10 °~ 70°. It depends on the weight load.

3.5 OPERATION CYCLE

1. Please turn the Main Power Switch into **ON** position and check if the **Power Light** illuminates.
2. Select the Button **C** for wrapping cycle.

Mode 1: 3 bottom wraps and 2 top wraps.
Mode 2: 4 bottom wraps and 3 top wraps.

Please note, during the machine operation, there is no need to stop the machine, for changing wrapping mode.

3. Press the Start (**D**) to wrap the Package.
4. During the wrapping cycle, if the machine is required to be stopped, press **E** button to pause the machine and press **D** button to resume back to operation.
5. When the wrapping cycle is finished, the carriage will return back to the bottom of the machine and the machine will automatically stop.
6. Return to **Operation Cycle** step 2, Start the Button Wrapping Cycle.
7. Please turn off the Main Power Switch (**A**) into **off** position when the machine is no longer in use.

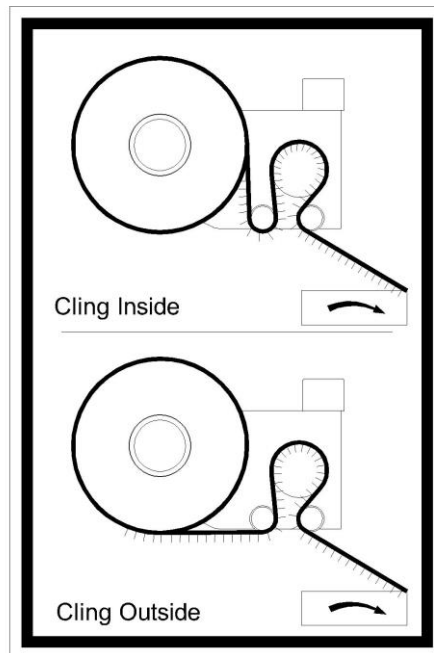
Please press the emergency stop button (**F**) to stop the machine instantly, when any **Emergency** occurs.

SECURITY BAR

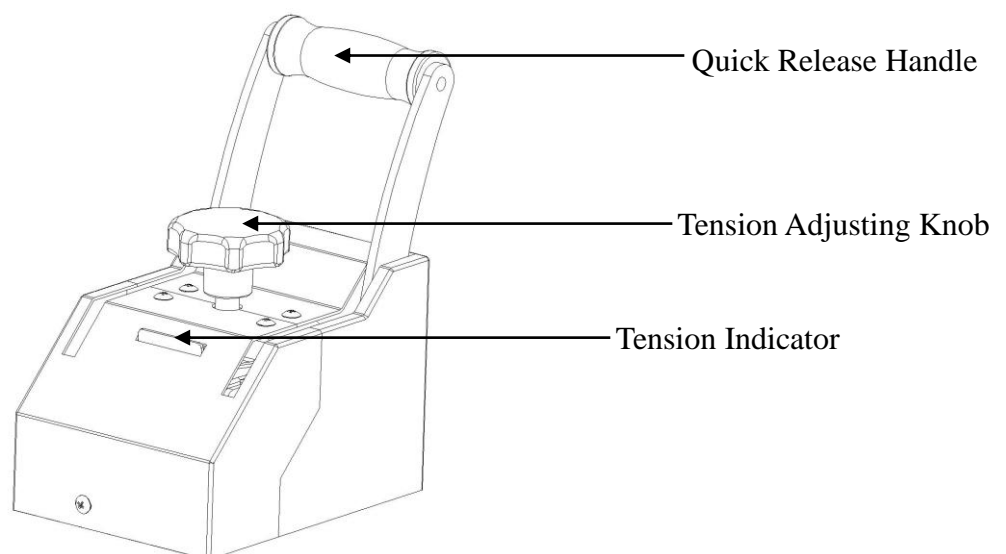
When this security switch is activated, the main power of motor of the machine will be cut off. Press START button to continue and complete the rest of wrapping cycle.

ELEVATOR UNIT

1) Illustration for film threading.

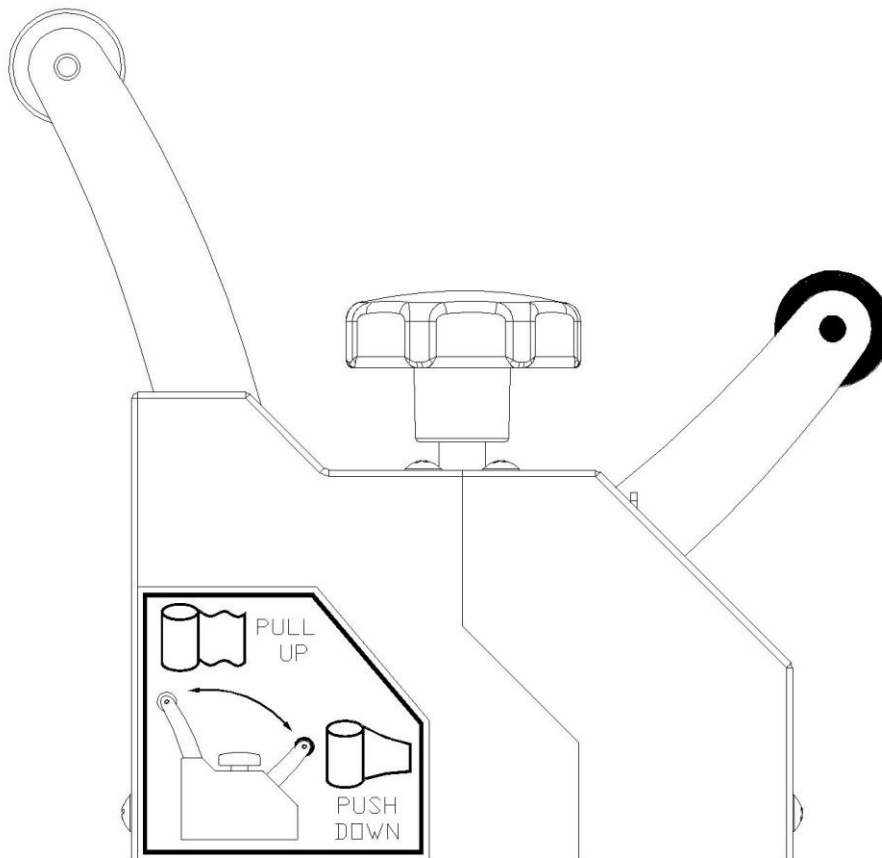


2) Stretch tension adjust knob: Turn the knob clockwise to increase the tension. Counterclockwise to decrease the tension. Adjust and set the indicate needle on the green zone can get the stretch tension is 1 meter Film stretched to be 1.65 meters.



3) Film Quick Release description:

- Pull up the quick release handle upon applying film to the loads.
- Push down the quick release handle to engage the brake during the wrap cycle.



4. ELETRIC

4.1 ELECTRIC CAPACITY

1) Power Consumption

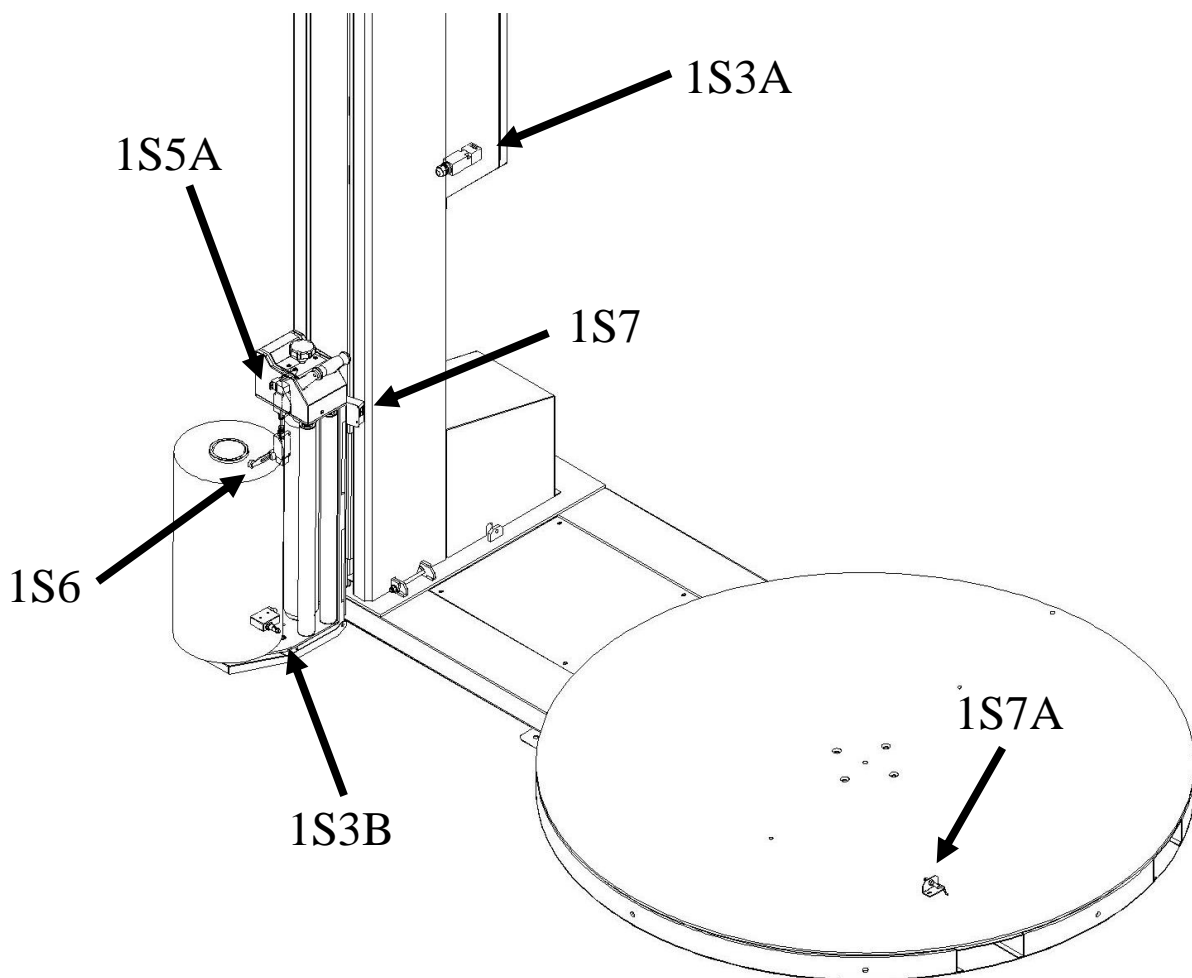
| | |
|----------------------|---------|
| Turntable motor | 0.4 KW |
| Elevator Motor | 0.4KW |
| Control & wiring box | DC 24V |
| Machine Power Use | 0.85 KW |
| Power Socket need | 1 KW |

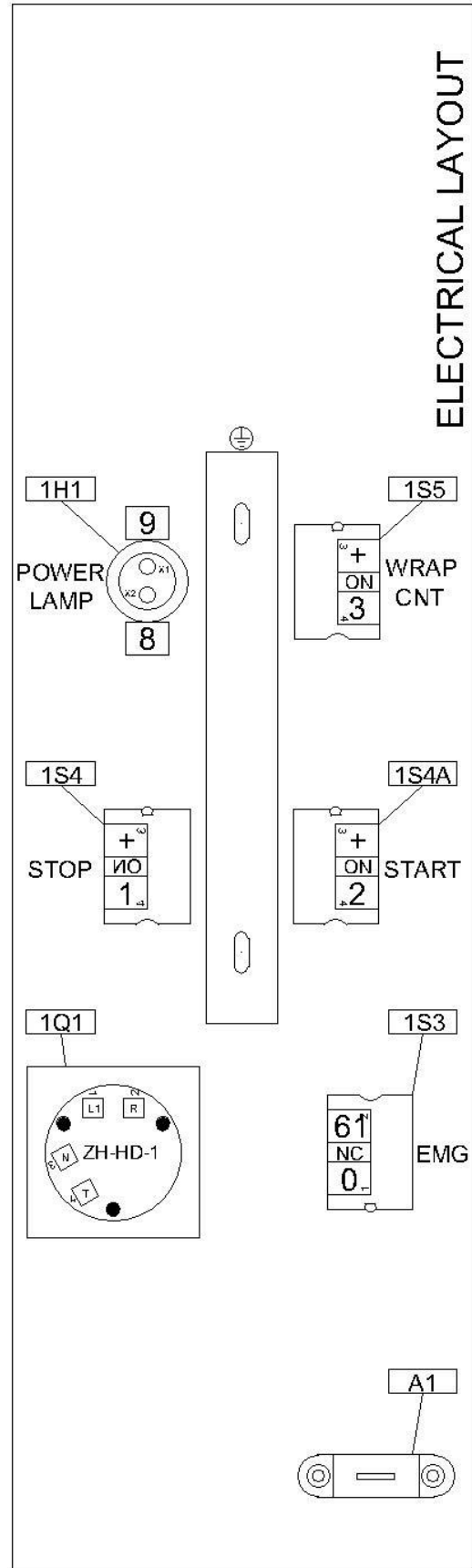
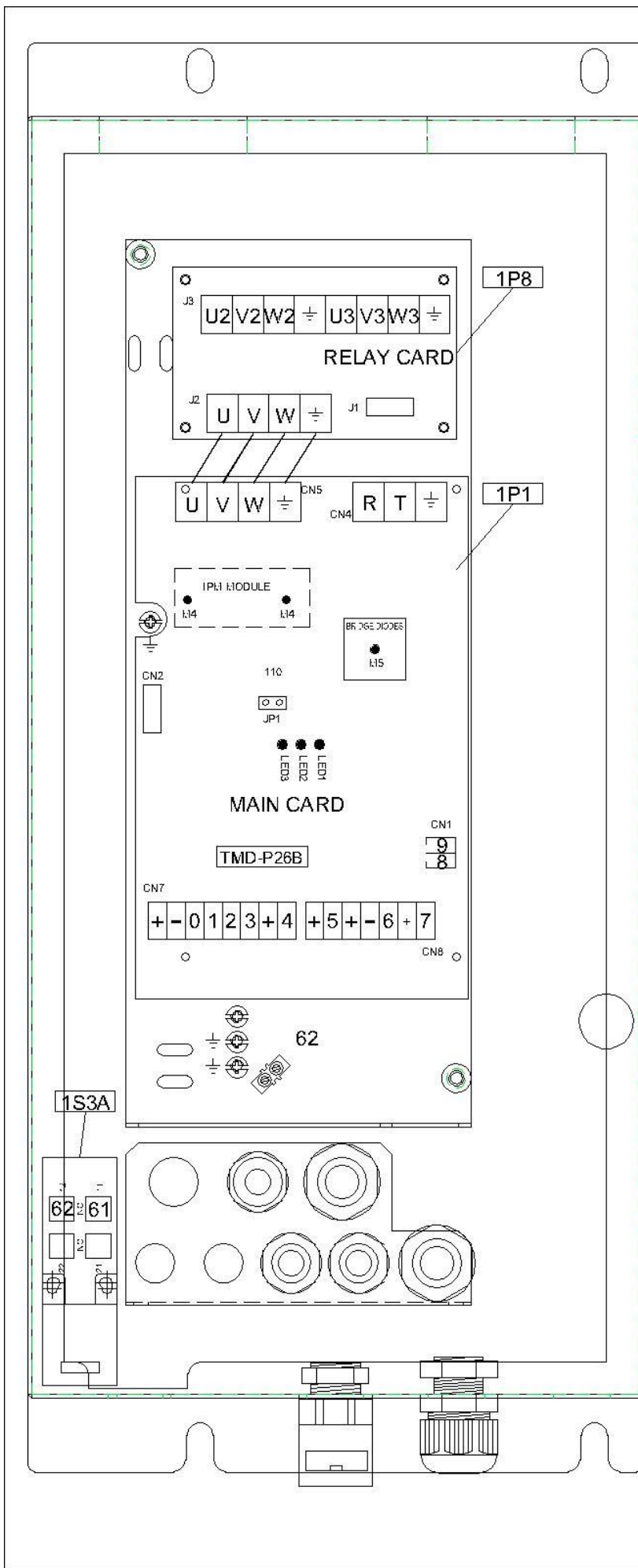
2) Power Cable ----- 1.25 mm²

3) Machine input ----- 110V / 230V 1-PHASE

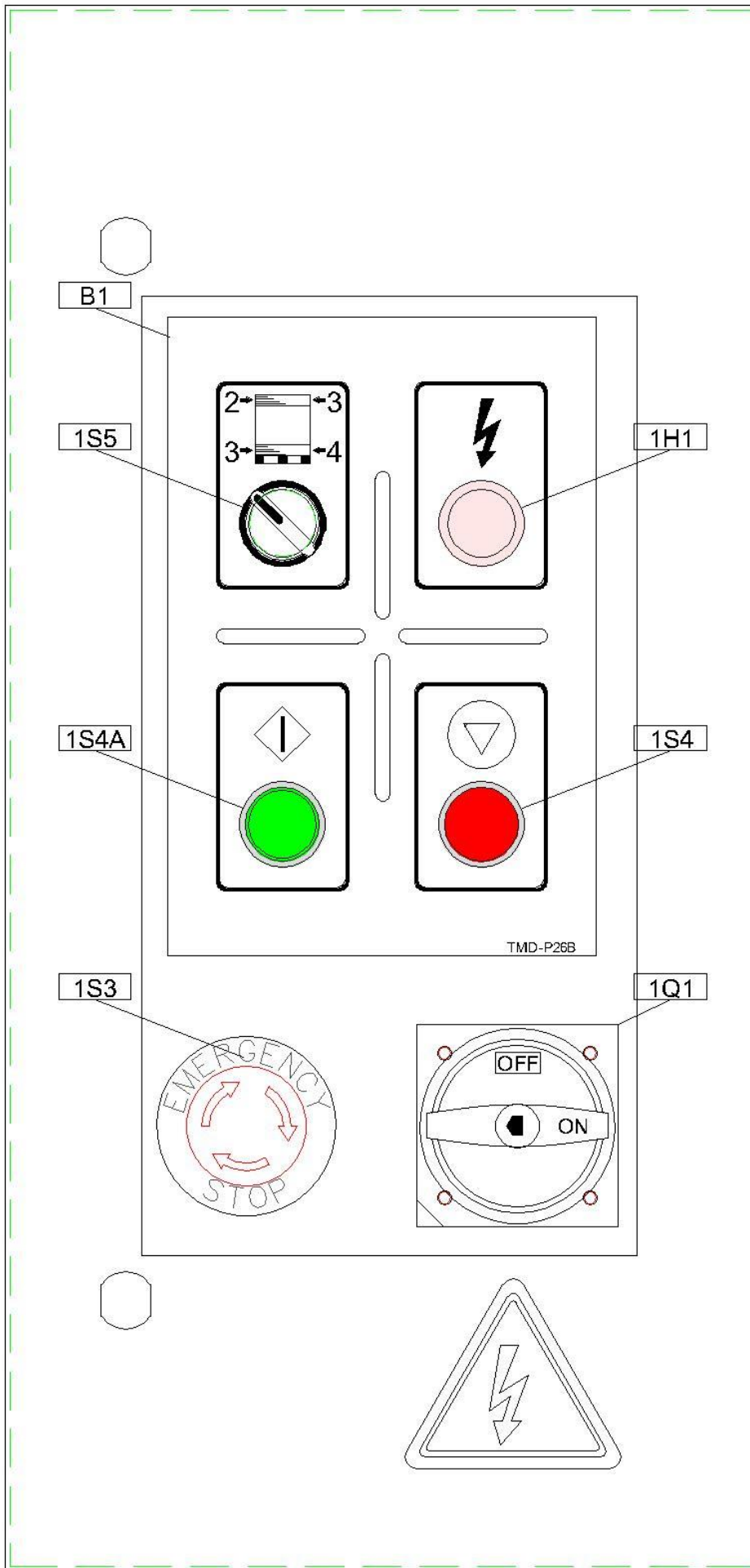
4.2 ELECTRIC DIAGRAM

| KEY NO | PART NO | DESCRIPTION | Q'TY |
|--------|-----------------|---|------|
| 1S3A | P0311-020000100 | ELECTRIC BOX DOOR <u>SWITCH</u> (TZ-93BPG) | 1 |
| 1S3B | P0311-060001400 | SAFETY <u>SWITCH</u> FILM CARRIAGE (ML-7312) | 1 |
| 1S7 | P0302-020000200 | <u>PHOTO EYE</u> (A3R-2MX) | 1 |
| 1S7 | P0319-10P26B08 | <u>PHOTO EYE</u> (A3R-2MX) w/ connector | |
| 1S5A | P0311-060001210 | TOP <u>LIMIT</u> (TZ-8108) | 1 |
| 1S6 | P0311-060001210 | BOTTON <u>LIMIT</u> (TZ-8108) | 1 |
| 1S7A | P0302-010002000 | TURNTABLE HOME <u>SENSOR</u> (PM12-04P-3M) | 1 |
| 1S7A | P0319-10P26B15 | TURNTABLE HOME <u>SENSOR</u> (PM12-04P-3M) w/ connector | 1 |





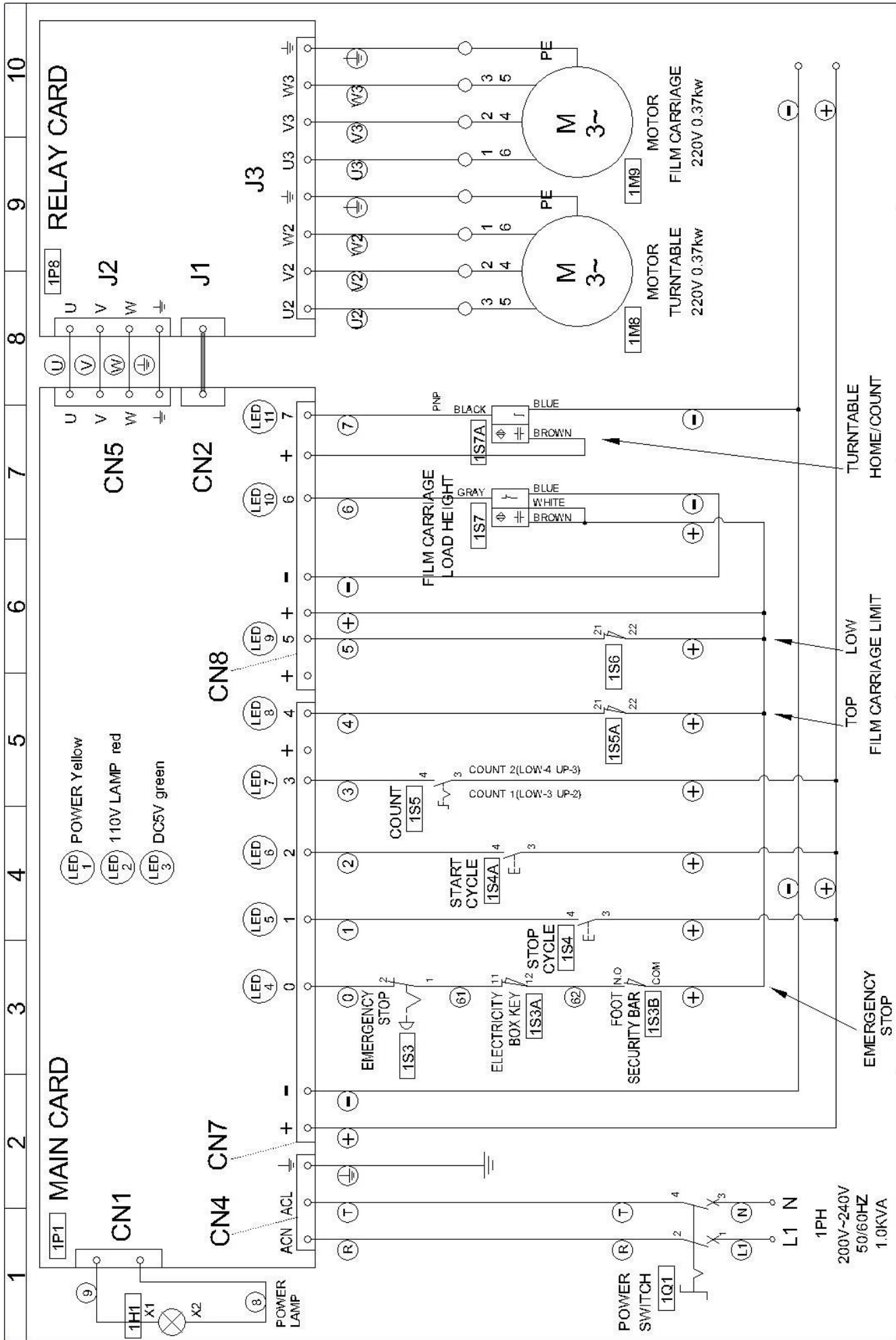
ELECTRICAL LAYOUT



ELECTRIC PARTS LIST FOR TMD-P26B

| KEY NO | PART NO | DESCRIPTION | Q'T Y |
|--------|-----------------|---|----------|
| 1H1 | P0312-010000100 | POWER LAMP (XB2BVB1C) | 1 |
| 1Q1 | P0311-010002800 | POWER SWITCH (ZH-HD-48-BY) | 1 |
| 1P1 | P0309-010007900 | MAIN CARD | 1 |
| 1S3 | P0313-020002800 | EMERGENCY.STOP (SKB2ES524-1B R) w/connector | 1 |
| 1S3A | P0311-020000100 | CARRIAGE BOX DOOR SWITCH (TZ-93BPG) | 1 |
| 1S4 | P0313-020002600 | STOP BUTTON COVER+ Contact (SKB2EA42-1A R) | 1 |
| 1S4A | P0313-020002500 | START BUTTON COVER+Contact (SKB2EA31-1A G) | 1 |
| 1S5 | P0313-020002700 | COUNT SWITCH(SK B2-ED21-1A) | 1 |
| 1P8 | P0309-010002000 | RELAY CARD | 1 |
| A1 | P0311-030000100 | CARRIAGE BOX DOOR KEY (TZ93-K3) | 1 |
| B1 | P1002-0006700 | PANEL STICKERS | 1 |





5. TROUBLE SHOOTING

5.1 GENERAL ADJUSTMENT

Turntable belt adjust

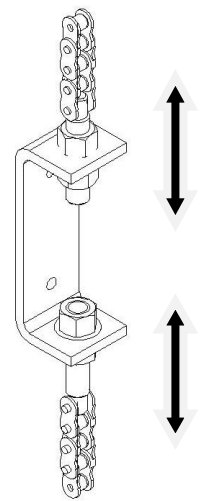
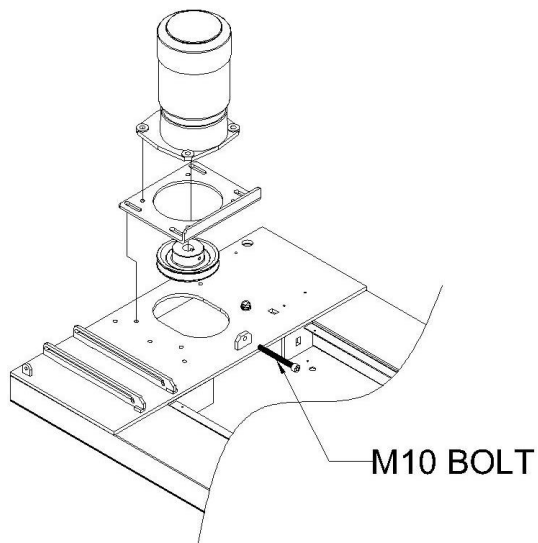
Please see the illustration below and then loosen the motor seat M10 screw 4 pcs.

Turn the (M10) on the seat until get enough tension. Turn and tight the motor seat screw 4 pcs again.

Elevator unit driving chain adjust:

Adjust the elevator to proper position and take off the cover tower

Adjust the M10 screw (Up and down) to proper tension

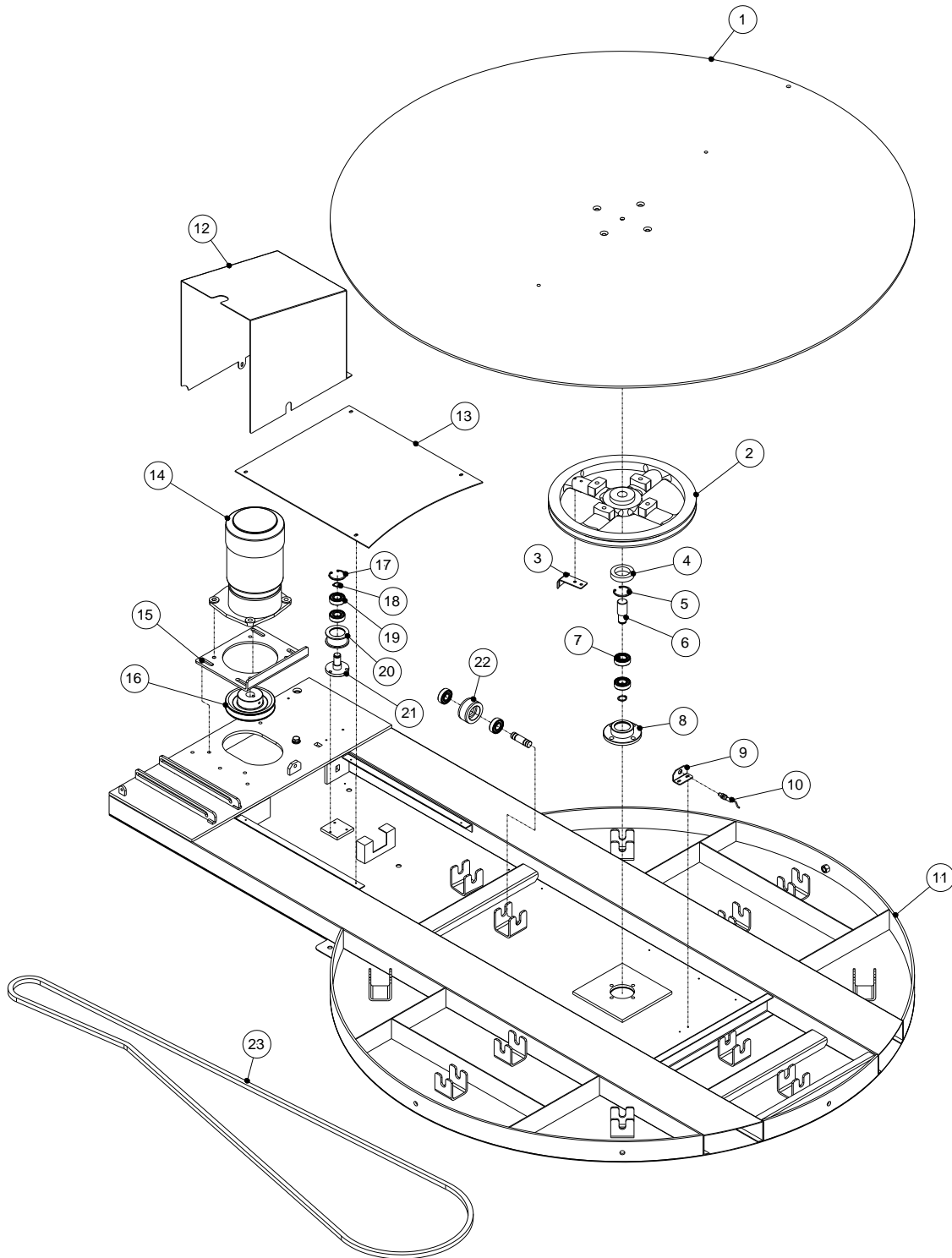


5.2 TROUBLE SHOOTING

| Machine trouble | Cause | Solution |
|---|--|---|
| Machine can not work | Power supply for motor is tripped Screen lamp not ON. Foot security is broken. | Activate the power switch. Check micro- processor board. Release the security s/w. |
| Turntable can not turn | Microprocessor board broken Motor stop turning | Change microprocessor board Check error message from inverter and refer to |
| Turntable can not Stop at home position. | Turntable proximity S/W is not working. | Check the proximity S/W sense. If it is no problem adjust the sensing plate. |
| CARRIAGE unit cannot move. | Microprocessor board broken Motor stop turning. | Change microprocessor board 1. Check the proximity S/W sense. If it is no problem adjust the sensing plate. 2. Check the top and bottom limit. 4.2 ELECTRIC DIAGRAM (1S5A),(1S6) |
| As doing AUTO RUN the CARRIAGE unit goes up and over the package height | Photo eye gets sense from another material except package. Photo sensor gets sense from another light source. | 1.Move away other objects Avoid the light source. 2. Check the photo eye 4.2 ELECTRIC DIAGRAM (1S7) |
| As doing AUTO RUN but CARRIAGE cannot goes up. | 1.Photo eye broken Photo eye cannot sense a black color package. 2. Photo eye broken Photo eye cannot sense a package. 3. Turntable proximity sensor is not working | 1. Change photo eye. Avoid a black color package or use manual operation. 2. Check the photo eye 4.2 ELECTRIC DIAGRAM (1S7) 3. Check the sensor 4.2 ELECTRIC DIAGRAM (1S7A) |

6. PART LIST

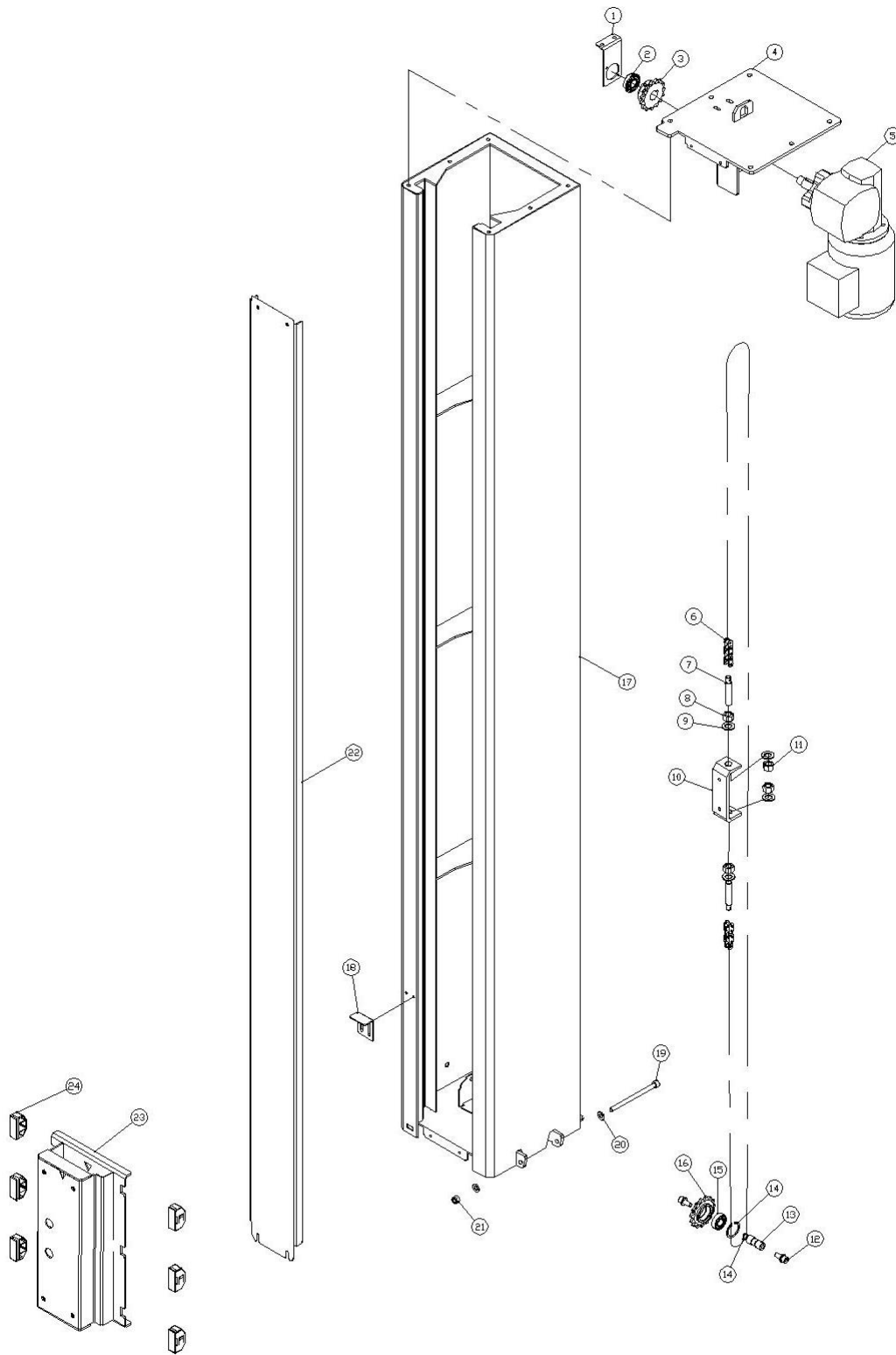
6.1 SEAT



PART LIST FOR TMD-P26B

| KEY NO | PART NO | DESCRIPTION | Q'TY |
|--------|-----------------|---------------------------------------|------|
| 1 | P01-001780A | 1.5M TURNTABLE | 1 |
| | P01-0452000 | 1.65M TURNTABLE | 1 |
| 2 | P0703-000020A | PULLEY | 1 |
| 3 | P01-000040A | SENSOR PLATE | 1 |
| 4 | P1104-11511080 | BEARING 51108 | 1 |
| 5 | P1105-0242B | RING RTW-42 | 1 |
| 6 | P02-000790A | BELT PULLY SHAFT | 1 |
| 7 | P1104-026004ZZ0 | BEARING 6004ZZ | 2 |
| 8 | P02-0008100 | BELT PULLEY BEARING SEAT | 1 |
| 9 | P01-0000300 | SENSOR SEAT | 1 |
| 10 | P0302-010002000 | PROXIMITY SENSOR(PM12-04P) | 1 |
| | P0319-10P26B15 | PROXIMITY SENSOR (PM12-04P)+connector | 1 |
| 11 | P01-044030A | 1.5M TURNTABLE SEAT | 1 |
| | P01-045190A | 1.65M TURNTABLE SEAT | 1 |
| 12 | P01-0440600 | MOTOR COVER | 1 |
| 13 | P01-0440400 | COVERING PLATE | 1 |
| 14 | P0501-0014200 | MOTOR 1/2HP 3-PH AC200V/380V 1/50 | 1 |
| 15 | P01-0440500 | MOTOR BASE | 1 |
| 16 | P0703-0007000 | MOTOR BELT PULLEY 5" | 1 |
| 17 | P1105-0242B | C-CLIP R-42 | 1 |
| 18 | P1105-0117B | RING STW-17 | 1 |
| 19 | P1104-026203ZZ0 | BEARING 6203ZZ | 2 |
| 20 | P06-0000600 | BELT PULLEY BEARING SEAT | 1 |
| 21 | P02-0000100 | BELT PULLEY BEARING SHAFT | 1 |
| 22 | P06-0003410 | SUPPORTING WHEEL | 12 |
| | P02-0007000 | SUPPORTING WHEEL SHAFT | |
| 23 | P0902-0007500 | BELT B-139 – 1.5M | 1 |
| | P0902-0007100 | BELT BX-143 – 1.65M | 1 |

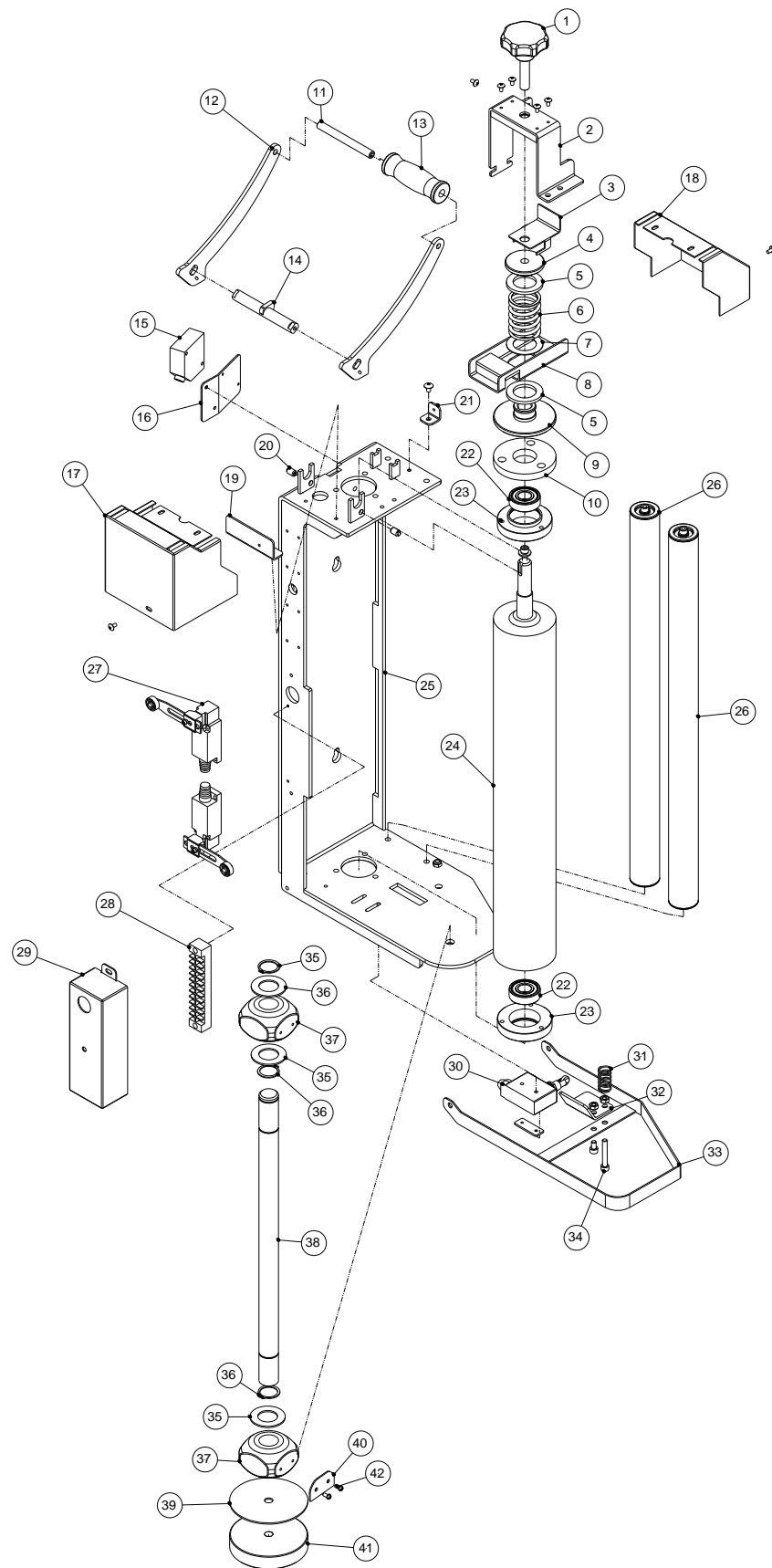
6.2 TOWER



PART LIST FOR TMD-P26B

| KEY NO | PART NO | DESCRIPTION | Q'TY |
|--------|-----------------|--------------------------------|------|
| 1 | P01-0441100 | SPPED REDUCER BEARING SEAT | 1 |
| 2 | P1104-076202ZZ0 | BEARING 6202-2NR(CWB) | 1 |
| 3 | P0702-0003200 | SPROCKET WHEEL #40,15T (Upper) | 1 |
| 4 | P01-0443200 | TOWER COVER | 1 |
| 5 | P0503-0009400 | MOTOR GEAR REDUCER 40 90VTM | 1 |
| 6 | P0901-0010400 | CHAIN – 2.2M, #40*326 | 1 |
| | P0901-0010600 | CHAIN – 2.6M, #40x398 | 1 |
| 7 | P02-0007500 | CHAIN SCREW SHAFT | 2 |
| 8 | P1102-0112AZ | NUT M12 | 2 |
| 9 | P1103-011224D5Z | WASHER M12 | 4 |
| 10 | P01-0018700 | CHAIN ADJUST SEAT | 1 |
| 11 | P1102-0106BZ | NUT M6 | 2 |
| 12 | P1101-0908020AN | SCREW M8x20L | 2 |
| 13 | P02-0289000 | SPROCKET WHEEL SHAFT | 1 |
| 14 | P1105-0235B | C-CLIP R-35 | 1 |
| 15 | P1104-026002ZZ0 | BEARING 6002ZZ(CWB) | 1 |
| 16 | P0702-0000200 | SPROCKET WHEEL (Lower) | 1 |
| 17 | P01-044070A | TOWER – 2.2M | 1 |
| | P01-0452100 | TOWER – 2.6M | 1 |
| 18 | P01-0441000 | LIMIT STOP | 1 |
| 19 | P1101-0508120AN | SCREW M8x120L | 1 |
| 20 | P1103-010816C5Z | WASHER M8 | 2 |
| 21 | P1102-0108BZ | NUT M8 | 1 |
| 22 | P01-0440800 | TOWER COVER – 2.2M | 1 |
| | P01-0452200 | TOWER COVER – 2.6M | 1 |
| 23 | P01-044090A | SLIDE CART | 1 |
| 24 | P06-0047300 | SLIDE BLOCK | 6 |

6.3 ELEVATOR



PART LIST FOR TMD-P26B

| KEY NO | PART NO | DESCRIPTION | Q'TY |
|--------|------------------|-----------------------------------|------|
| 1 | P1113-0003500 | ADJUSTING KNOB | 1 |
| 2 | P01-044200A | KNOB FIXING BRACKET | 1 |
| 3 | P01-044210B | TENSION INDICATOR PLATE | 1 |
| 4 | P02-028790B | PRESS WHEEL | 1 |
| 5 | P1104-18AXK30470 | BEARING | 2 |
| | P1104-19AS30470 | WASHER | 4 |
| 6 | P1201-0001700 | PRE-STRETCH SPRING | 1 |
| 7 | P1104-19AS30470 | WASHER | 1 |
| 8 | P01-044220A | RELEASE LEVER | 1 |
| 9 | P02-028800A | BRAKE PAD | 1 |
| 10 | P06-0011900 | BRAKE PAD | 1 |
| 11 | P02-0287800 | HANDLE BAR SHAFT | 1 |
| 12 | P01-0441700 | HANDLE BAR LEVER | 2 |
| 13 | P06-0047400 | HANDLE BAR | 1 |
| 14 | P01-044230A | HANDLE BAR POSITON SHAFT | 1 |
| 15 | P0302-020000200 | PHOTO SENSOR A3R-2MX | 1 |
| | P0319-10P26B08 | PHOTO SENSOR A3R-2MX w/ connector | 1 |
| 16 | P01-0441300 | PHOTO SENSOR SEAT | 1 |
| 17 | P01-0441800 | CARRIAGE COVER (REAR) | 1 |
| 18 | P01-0441900 | CARRIAGE COVER (FRONT) | 1 |
| 19 | P01-0442400 | FIXING PLATE (REAR) | 1 |
| 20 | P1122-0000200 | FIXING BALL (M8) | 2 |
| 21 | P01-0442600 | FIXING PLATE (FRONT) | 1 |
| 22 | P1104-026203ZZ0 | BEARING | 2 |
| 23 | P02-028810A | BEARING SEAT | 2 |
| 24 | P08-000780B | STRETCH ROLLER | 1 |
| 25 | P01-044160B | CARRIAGE BASE | 1 |
| 26 | P08-0001000 | ROLLER SET | 2 |
| 27 | P0311-060001200 | LIMIT SWITCH VL-8108 | 2 |
| 28 | P0304-010005600 | CONNECTOR HOUSING, 12P 15A | 1 |
| 29 | P01-0442500 | CABLE BRACKET | 1 |
| 30 | P0311-060001400 | LIMIT SWITCH ML-7312 | 1 |
| 31 | P1201-0008400 | FOOT SAFETY PEDAL SPRING | 1 |

PART LIST FOR TMD-P26B

| KEY NO | PART NO | DESCRIPTION | Q'TY |
|--------|-----------------|-------------------------|------|
| 32 | P01-0442800 | FOOT SAFETY PEDAL PLATE | 1 |
| 33 | P01-0442700 | FOOT SAFETY PEAL | 1 |
| 34 | P1101-0506040AN | SCREW M6X40L | 1 |
| 35 | P1105-0224B | C-CLIP R-24 | 3 |
| 36 | P01-0441500 | WASHER (45x25.5x2t) | 3 |
| 37 | P06-0047500 | FILM MANDREL | 2 |
| 38 | P02-0288200 | FILM SHAFT SEAT | 1 |
| 39 | P06-0048300 | FILM SEAT BASE SHEET | 1 |
| 40 | P01-0441400 | FILM STOPPER | 1 |
| 41 | P02-028830A | FILM SEAT | 1 |
| 42 | P1101-0104006AZ | SCREW M4X6L | 2 |

6.4 CONTROL BOX

PART LIST FOR TMD-P26B

| KEY NO | PART NO | DESCRIPTION | Q'TY |
|--------|-----------------|------------------------|------|
| 1 | P01-044300A | CONTROL BOX | 1 |
| 2 | P01-006580A | WIRING PLATE | 1 |
| 3 | P01-0442900 | CONTROL BOX COVER | 1 |
| 4 | P01-0021600 | HINGE (R) | 2 |
| 5 | P1118-010000200 | LOCK C-403*1" | 2 |
| | P1118-030000100 | LOCK PLATE | 2 |
| | P1118-020000100 | KEY | 2 |
| 6 | P0311-030000100 | KEY TZ93-K3 | 1 |
| 7 | P0311-020000100 | SAFETY SWITCH TZ-93BPG | 1 |

