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EASY PACKAGING

STEP FAC-N980AC

High Speed Bag Closing Machine
with Auto-lubrication System

INSTRUCTION
MANUAL-EN

CE

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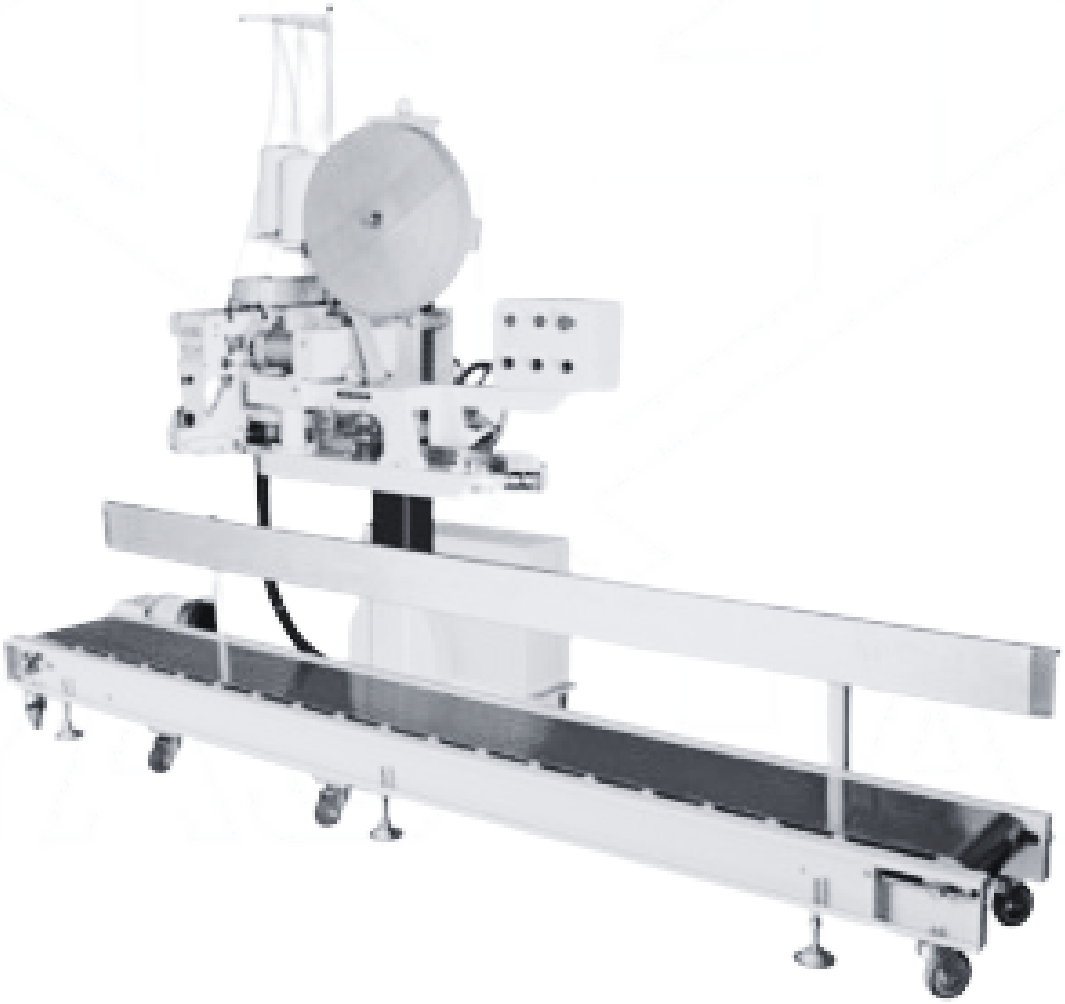
INSTRUCTIONS

AUTOMATIC BAG CLOSING WITH CONVEYER

STEP FAC-N980AC



F300A

1-thread

F302A

2-thread

Specifications

Model	Thread	Speed	Stitch	Needle	Cutter	N.W.	G.W.
F300A	1	300 ~ 400 Bags/Hour	7.2 mm	FD - 5 # 25	Mechanical Thread Cutter	5.9 kg	7.3 kg
F302A	2					6.4 kg	7.8 kg
MF300A	1	300 ~ 400 Bags/Hour	7.2 mm	FD - 5 # 25	Mechanical Thread Cutter	26.1 kg	29.6 kg
MF302A	2					26.4 kg	29.9 kg
N600A	1	250 ~ 350 Bags/Hour	7.2 mm	DN x 1 # 25	Mechanical Thread Cutter	6.1 kg	7.5 kg
N602A	2					6.7 kg	8.1 kg
N600H	1	350 ~ 450 Bags/Hour	7.2 mm	DN x 1 # 25	Mechanical Thread Cutter	6.3 kg	7.7 kg
N602H	2					6.9 kg	8.3 kg
N600AC	1	250 ~ 350 Bags/Hour	7.2 mm	DN x 1 # 25	Manual Tape Cutter	7.5 kg	8.9 kg
N602AC	2					8.1 kg	9.5 kg
N620A	2	250 ~ 350 Bags/Hour	7.2 mm	FD - 5 # 25	Mechanical Thread Cutter	6.6 kg	8.2 kg
N640A	4	250 ~ 350 Bags/Hour	7.2 mm	FD - 5 # 25	Mechanical Thread Cutter	7.0 kg	8.6 kg
FN600A	1	200 ~ 300 Bags/Hour	7.2 mm	DN x 1 # 25	Mechanical Thread Cutter	55.1 kg	59.2 kg
FN602A	2					55.5 kg	59.6 kg
MN600A	1	200 ~ 300 Bags/Hour	7.2 mm	DN x 1 # 25	Mechanical Thread Cutter	26.3 kg	29.8 kg
MN602A	2					26.7 kg	30.2 kg
N320A	2	160 ~ 230 Bags/Hour	8.5 mm	DN x 1 # 25	Mechanical Thread Cutter	7.2 kg	8.6 kg

Drive motor 90W 50 / 60Hz, 1ph / 12V, 24V, 110V, 115V, 220V, 230V, or 240V

(Please specify one when order)

N600A · N600H

1-thread 1-thread High Speed

N602A · N602H

2-thread 2-thread High Speed

Bag Closer for Heavy Use

N320A

2-thread

Equipped Tapping Attachment

N600AC · N602AC

1-thread 2-thread

N620A

2-needle 2-thread

N640A

2-needle 4-thread

Moved Closing machine

MN600A MF300A
MN602A MF302A

Sliding Board Closing machine

FN600A · FN602A

1-thread 2-thread

TAIWAN patent NO. : M425132

I. General Definition

STEP FAC-N980AC Series is formed by four major components: main frame, zipping machine, conveyor and sewing machine. (See **Fig.1**)

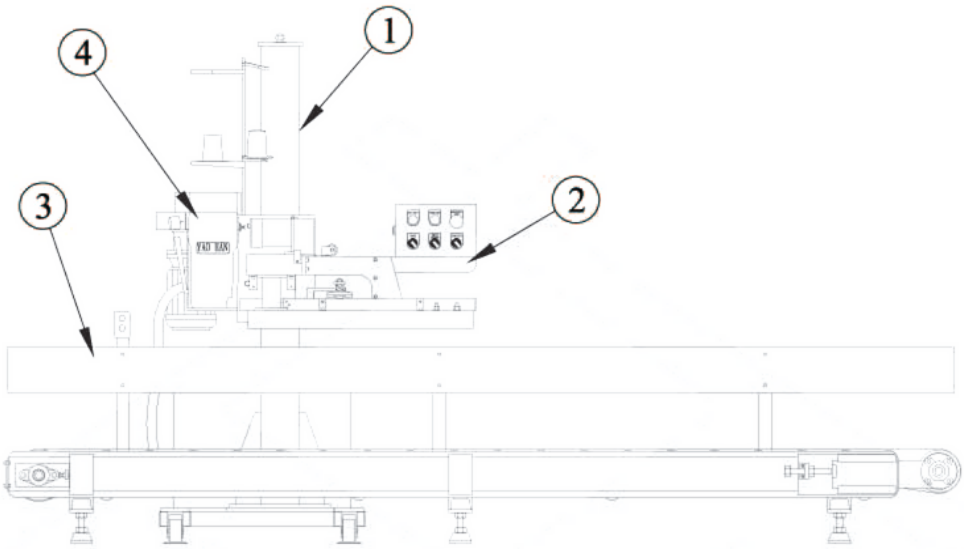


Fig.1

1. Main Frame: (including upper and lower slide carriage, motor of sewing machine, cable rack and control panel)

1.1 Its lifting platform can alter the sewing height according with the needs. The wheels attached at the base make the machine to be moved conveniently. The breaks and foot stands can fasten the wheel and position the machine to increase operation stability.

1.2 The sewing machine and its motor are attached separately, in order to simplify adjusting and changing operations and to shorten maintenance hours.

2. Zipping Machine: (including bag cutter, delivering chain and control switch)

2.1 The bag cutter can trim paper bags, improving the package appearance and neatness.

2.2 The tension of the delivering chain can be adjusted, ensuring clipping and delivery. The delivery speed can be coordinated with the sewing machine.

2.3 The switches are installed separately, thus the machine can be operated according to instant circumstances. Emergency stop button is also provided to improve working safety.

2.4 Zipping machine can be disassembled from the main frame, and arranged its position forward or backward per the sewing machine model.

3. Conveyor:

3.1 Specification of the conveyor:

Length	300cm
Width	30cm
Delivery Speed	10m/min
Delivery Capacity	500~600 bag/hr
Maximum Load	50 kg/bag

4. Sewing Machine: See the relevant specification an operation instruction in Sewing Machine's User's Manual and Component Catalog.

II. Fixing and Adjusting

1. Adjusting and Fixing Height:

1.1 To adjust the height of sewing point, first, please loosen the black fixing handle at the back (along the direction of green arrow).

1.2 Then arrange the height with the hand wheel at the left.

1.3 After arranging to fix position, tighten the fixing handle (along the direction of yellow arrow). See **Fig.2a**.

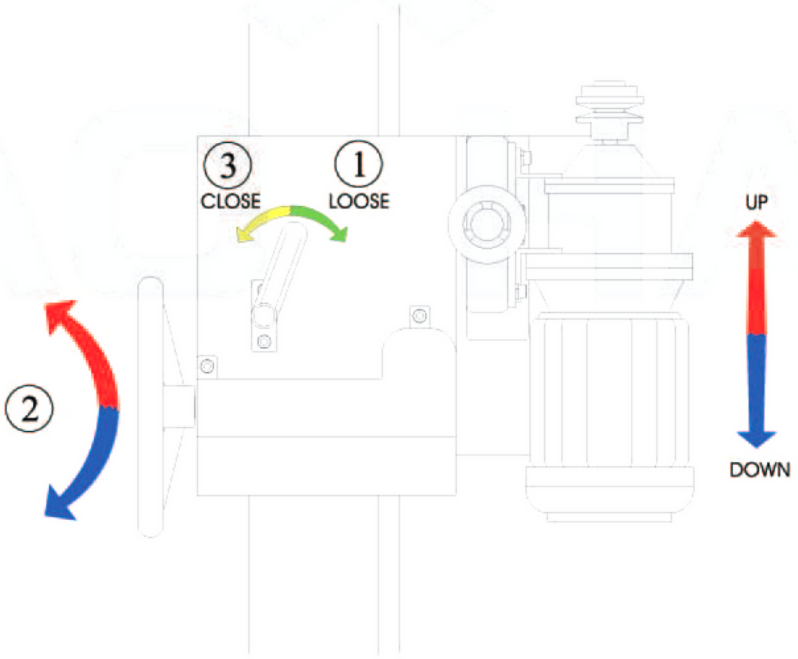


Fig.2a

2. Adjusting Sewing Machine Belt Tension:

When you adjust sewing machine belt tension, please take off the belt cover above to ease the operation.

2.1 Loosen No. 1 Screws (four totally).

2.2 Rotate the hand wheel on motor mount behind to modify the belt tension; the red direction is loosening, and the blue direction is tightening. See **Fig.2b** and **Fig.2c**.

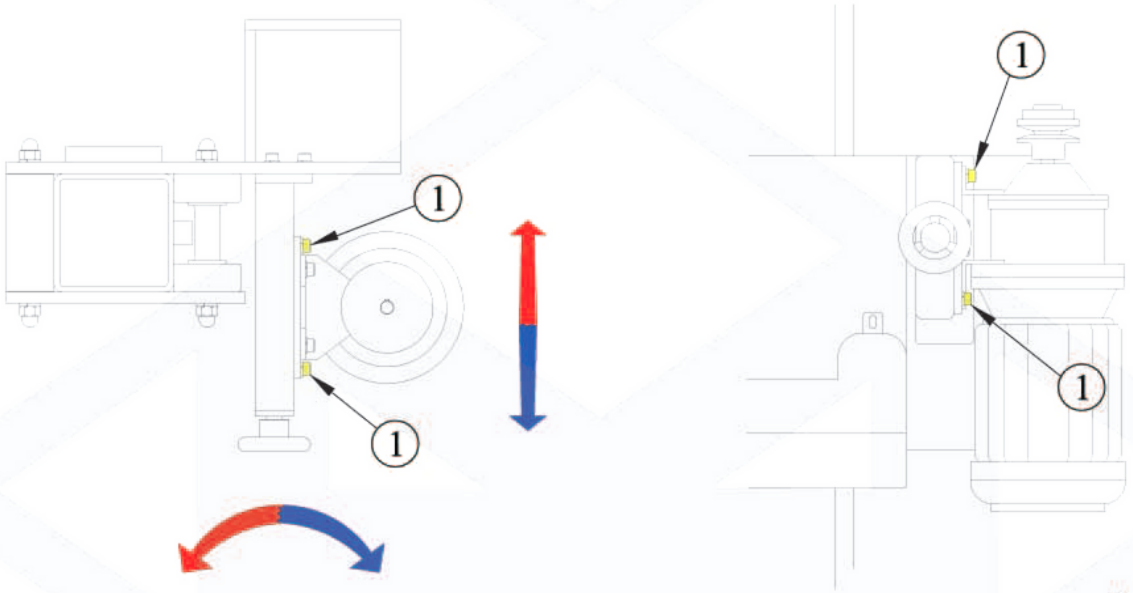


Fig.2b

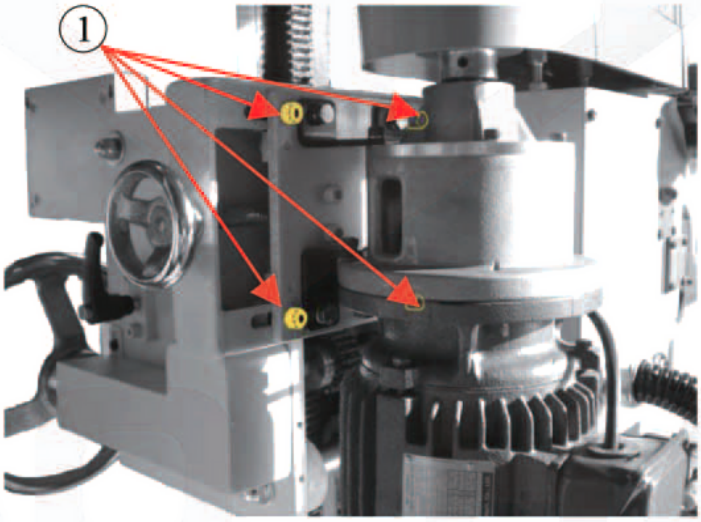


Fig.2c

3. Adjusting Delivery Speed:

If the sewing speed was different from delivery speed, the stitch intervals would vary or the paper bags would be squeezed. To prevent the problem, please adjust the speed according to the following steps to improve the sewing outcome.

Caution: Please arrange the delivery speed according with the speed of zipping machine and conveyor.

3.1 Error of the Speed of Zipping Machine and Conveyor

How to Distinguish: If the machine appears like **Fig.3a** during sewing process, the zipping machine is slower than the conveyor; if it appears like **Fig.3b**, the zipping machine is faster than the conveyor.

The machine shall be stopped to be adjusted immediately.

How to Adjust:

a. Take off the belt cover of the zipping machine (see **Fig.3d**), and arrange the gap width of the zipping machine's bell pulley. The wider the gap, the slower the spinning speed; the narrower the gap, the faster the spinning speed.

b. After adjusting, please make sure the fixing screw of the bell pulley is fastened to its position. At last, lock the bell pulley cover back.

3.2 When the sewing machine is faster than delivery:

How to Distinguish: If the sewing stitches appear like **Fig.3e**, the sewing speed is faster than delivery.

How to Adjust:

a. Take off the bell pulley cover, and arrange the gap width of the sewing machine's bell pulley (see **Fig.3c**).

b. The wider the gap, the slower the sewing speed

c. After adjusting, please make sure the fixing screw of the bell pulley is fastened to its position. At last, lock the bell pulley cover back and fix it.

3.3 When the sewing machine is slower than delivery:

How to Distinguish: If the sewing stitches appear like **Fig.3f**, the sewing speed is slower than delivery.

How to Adjust:

a. Take off the bell pulley cover, and arrange the gap width of the sewing machine's bell pulley (see **Fig.3c**).

b. The narrower the gap, the faster the sewing speed

c. After adjusting, please make sure the fixing screw of the bell pulley is fastened to its position. At last, lock the bell pulley cover back and fix it.

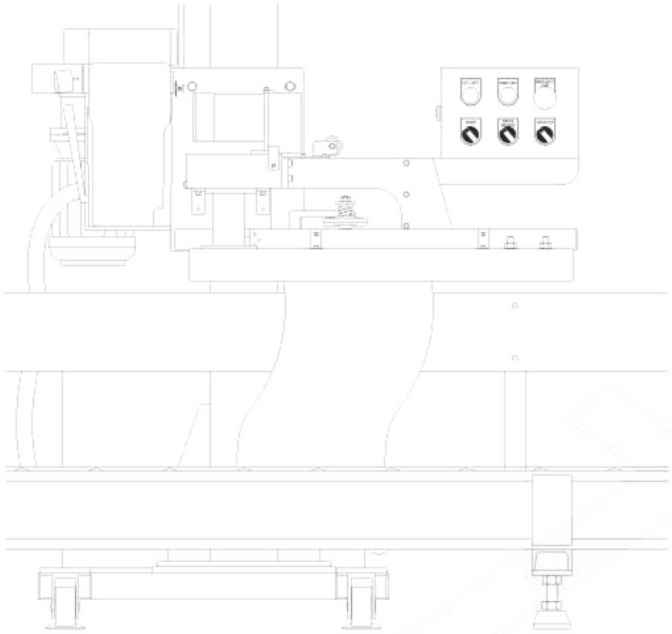


Fig.3a

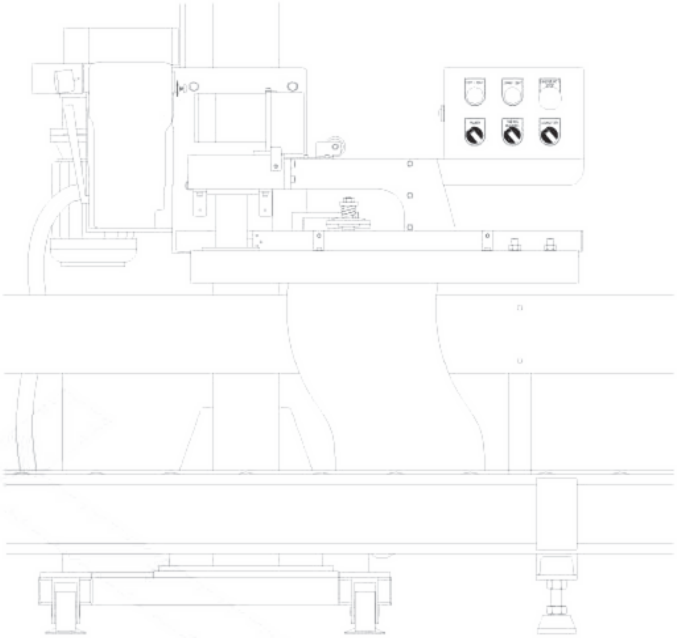


Fig.3a

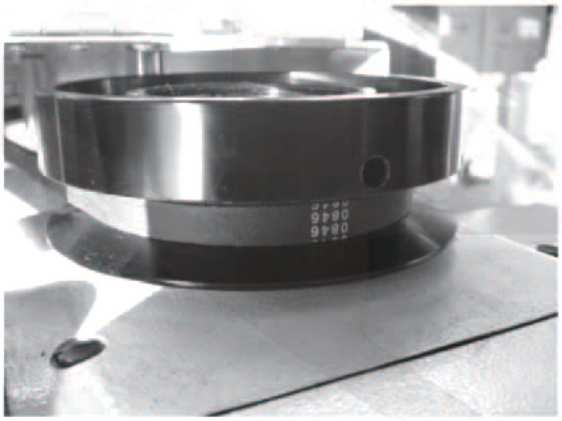


Fig.3c

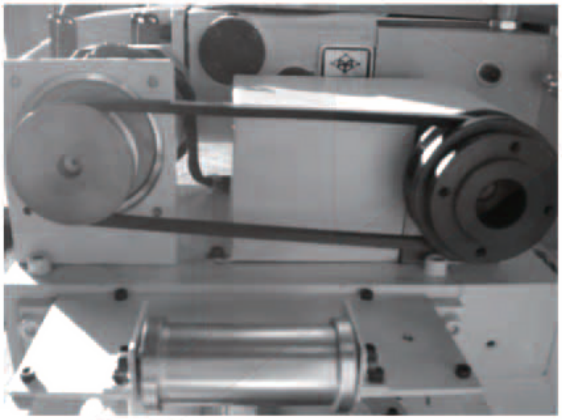


Fig.3d

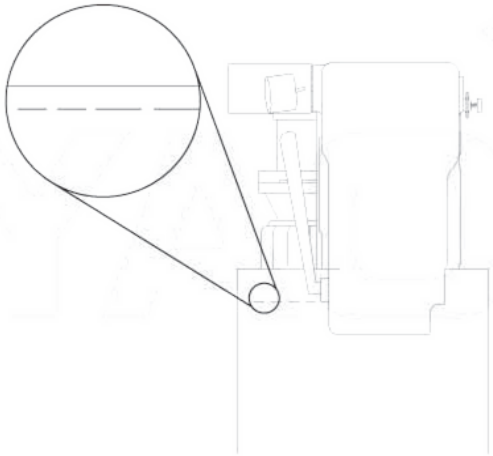


Fig.3e

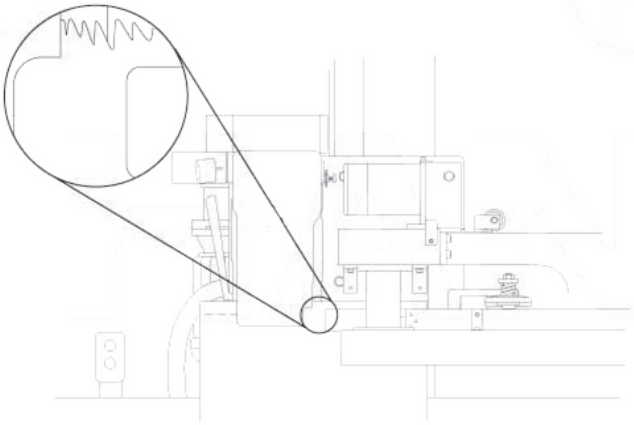


Fig.3f

4. Adjusting Chain Tension:

When abnormal sound occurs on the chain during operation,

How to Adjust:

4.1 When the chain is too tight:

a. Take off both side covers of the zipping machine for inspection and adjusting.

b. Loosen No. 1 Nut at the front of the side which needs adjusting. (See **Fig.4a**)

c. Loosen No. 2 Nut below the zipping machine. (See **Fig.4b**)

d. Rotate No. 3 Nut outward to fasten it. Increase Distance A of supporting mount to the required chain tightness, then fasten No. 2 Nut.

e. Fasten No. 1 Nut at the front, and lock up the side covers.

4.2 When the chain is too loose:

a. Take off both side covers of the zipping machine for inspection and adjusting.

b Loosen No. 1 Nut at the front of the side which needs adjusting.

c. Loosen No. 2 Nut below the zipping machine.

d. Rotate No. 3 Nut inward. Decrease Distance A of supporting mount to the required chain tightness, then fasten No. 2 Nut.

e. Fasten No. 1 Nut at the front, and lock up the side covers.

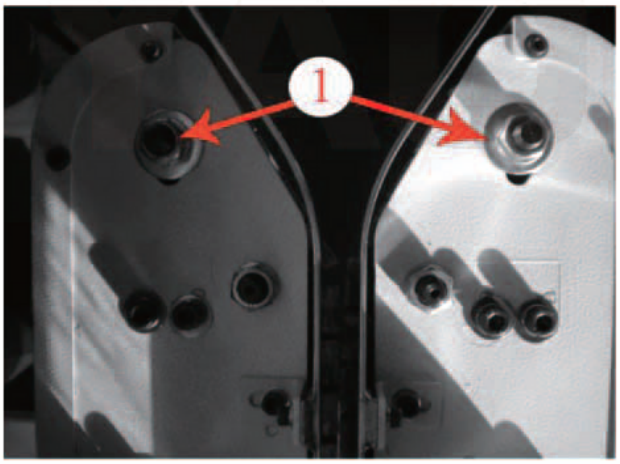


Fig.4a

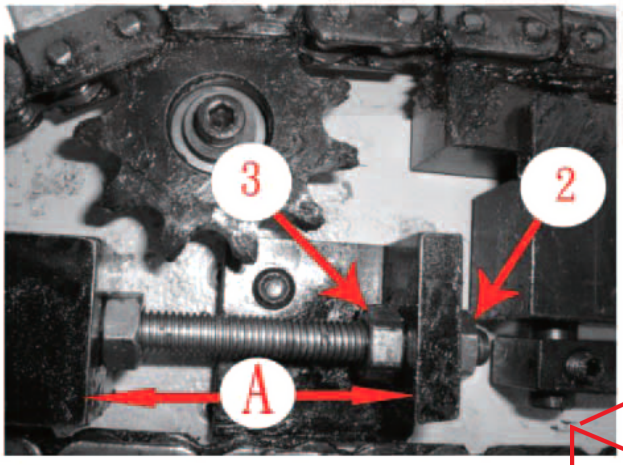


Fig.4b

5. Adjusting the Photoelectric Switch Reaction:

When the reflection distance needs to be adjusted, please arrange as the following steps:

How to Adjust:

a. Turn off all the switches on the control panel for safety.

b. According with the reflection distance, choose an altering screw driver in the accessory package to adjust the knob on the photoelectric switch to increase or decrease the distance (see **Fig.5a**).

c. After adjusting, ensure the work is completed, then test.

d. The machine can be operated after testing. If further modification is required, please repeat Step 1~3 until completion.

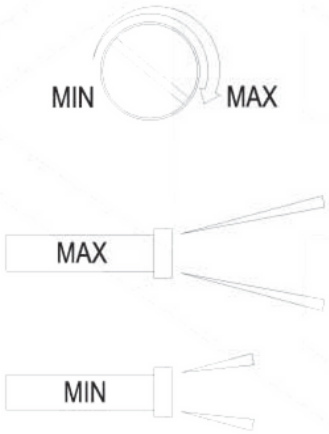


Fig.5a

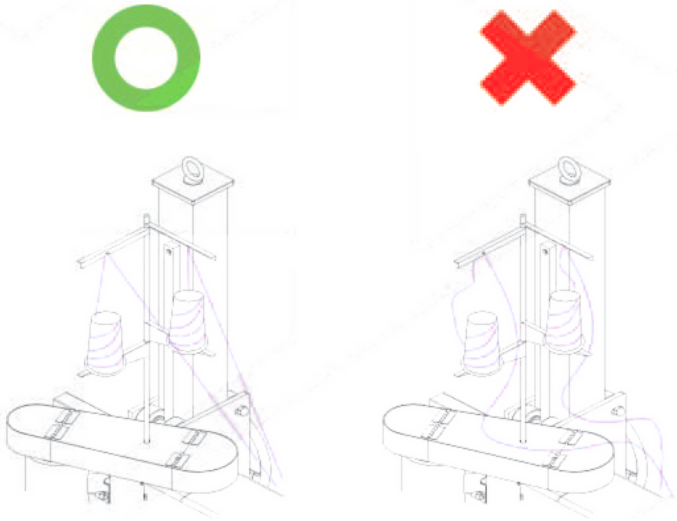


Fig.6a

III. Threading:

For threading, the plastic bag can be kept to prevent thread knotting and winding caused by vibration during sewing. Therefore, the operation safety and machine life can be protected. (See **Fig.6a**)

Please follow the threading method in F900A/AC user's manual (page 8~9).

IV. Using Switches:

1. Before the machine starts, please make sure: if threading is correct, if power is properly connected, and if machine height is fixed.
2. The machine has five switches totally, including four on the control panel and one power switch on lower electrical panel. The switches on the control panel are for power source, sewing machine, conveyor and emergency stop. Two signal lamps are also provided.
3. There is a master power switch at the upper left corner in lower electrical panel. Input power requirement is 220V/3P. The switches on the control panel can function only if the master switch is turned ON and power is supplied. If it is OFF, no power would be supplied to the machine. (See **Fig.7a** for the switches)
4. When the switch on the control panel is turned to left, the machine would stop (see **Fig.7b**). When the switch is turned to right, the machine would start and the signal lamp would light up (see **Fig.7c**).
   If emergency stop is needed, please press the emergency stop button to stop operation (see **Fig.7d**).
   Don't press the emergency stop button during operation when it's not needed.
5. The sewing machine switch and conveyor switch would function only if the power switch of the control panel is turned on. If the power switch is off, no operation can proceed.

Fig.7a

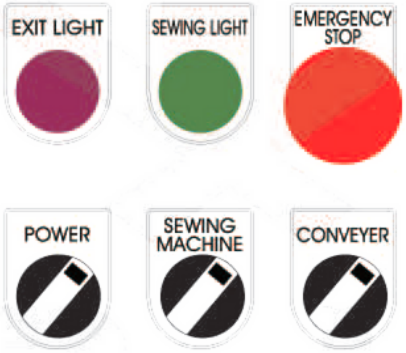


Fig.7b

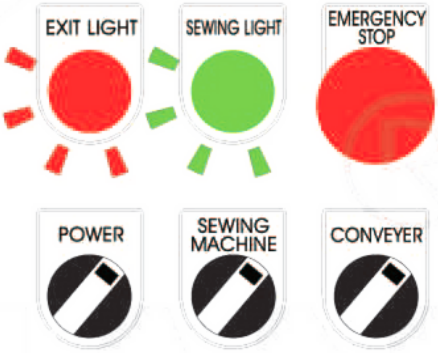


Fig.7c

Fig.7b-1

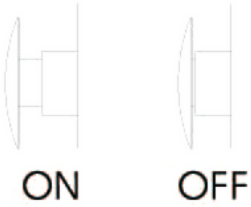


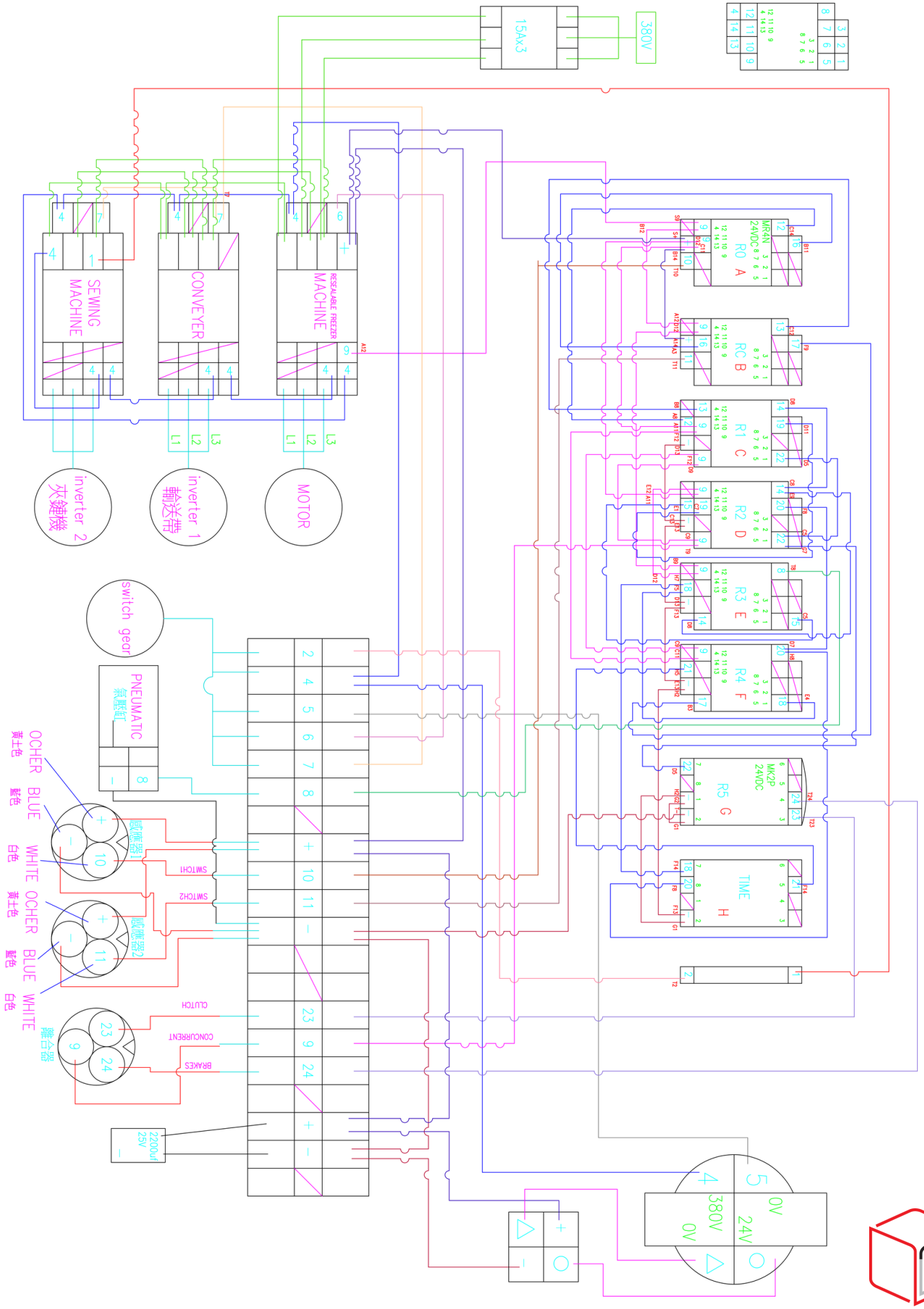
Fig.7d

V . Control Panel System:

Please operate the control panel system with caution and keep fire source away. Don't touch directly with wet hands for safety. For the circuit diagrams of master control panel and upper switch panel, please see the given diagrams inside master control panel.

We appreciate your purchase for our product. Please contact us for any questions.

Electric Diagram



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