

Shrink Tunnel Manual



I. Purpose:

The shrink wrapping machine is one of the more advanced packaging method the international market. It uses shrink film to wrap around a product or package, which is then heated to shrink the film tightly around the item. This method fully displays the item's appearance, enhances its marketability, and increases its aesthetic and perceived value. Additionally, the wrapped item is sealed, protected from moisture, contamination, and external impacts, providing a certain level of cushioning. This is particularly useful when packaging fragile items, as it prevents shards from scattering if the container breaks. Furthermore, it reduces the risk of tampering and theft. The tension generated during the shrinking process can tightly bundle a group of items, serving a similar function to strapping, making it especially suitable for multi-item packaging and pallet wrapping. Therefore, this product is widely used for packaging various small goods.

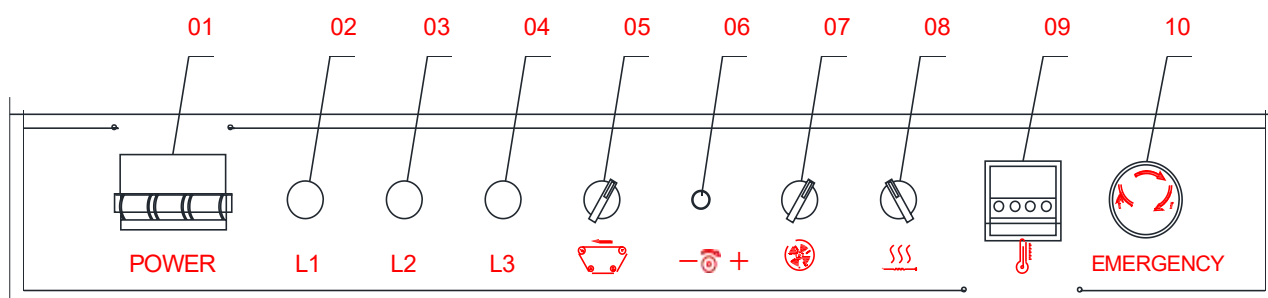
II. Features:

The jet-type heat shrink wrapping machine is the latest automatic continuous shrink wrapping equipment in China. It uses heat pipes for heating, offering energy efficiency and high performance (saving over 15% in electricity). The shrink temperature and motor speed are stable and adjustable over a wide range. The unique jet-type design ensures advanced engineering, extremely stable and reliable performance, excellent shrink packaging results, a novel and aesthetically pleasing structure, and easy operation and maintenance. The product's lifespan is significantly longer than similar products. The extended jet-type heat shrink wrapping machine is suitable for shrink packaging with PVC, POF, and PP shrink films, particularly ideal for POF shrink film.

III. SPECIFICATION:

Model	Voltage	Power	Load Capacity	Heating furnace size (mm)	External dimensions(mm)	Conveying speed	weight
KS4525	380V	12KW	15kg	1400×450×250	1700×800×1150	0- 10m/min	140kg
KS5530	380V	14KW	15kg	1600×550×300	1900×900×1200	0- 10m/min	170kg
KS6530	380V	18KW	15kg	1800×650×300	2100×1000×1200	0- 10m/min	200kg
KS7540	380V	19KW	15kg	1900×750×400	2200×1100×1300	0- 10m/min	230 kg

IV. CONTROL PANEL:



- (1) Main power (2) Live Wire 1 (3) Live Wire 2 (4) Live Wire 3
 (5) Conveyor Switch (6) Conveyor Speed Control (7) Fan Switch
 (8) Heating Switch (9) Temperature Setting (10) Emergency Stop

V. TEMPERATURE & TIME FOR SHRINK FILM:

Film \ Term	Name	Thickness (mm)	Heating (S)	Shrinking room temperature (°C)
Polyvinyl chloride	PVC	0.01-0.06	5- 10	120
Polypropylene	PP	0.01-0.04	10-20	150
Polyolefin	POF	0.01-0.03	10-20	130

VI. OPERATION PROCEDURES & NOTICE:

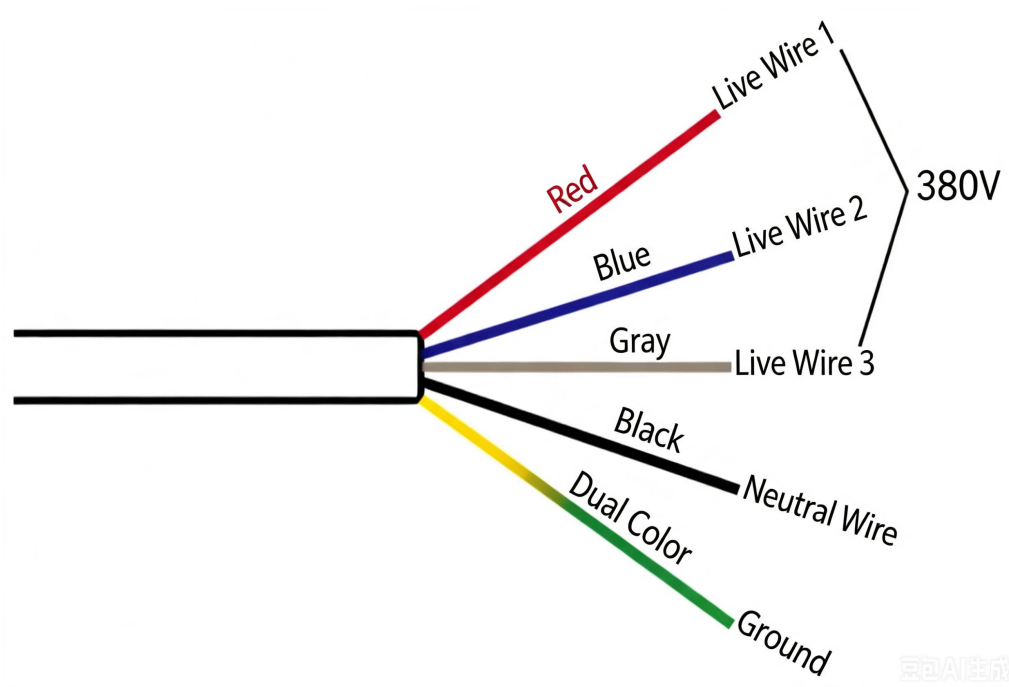
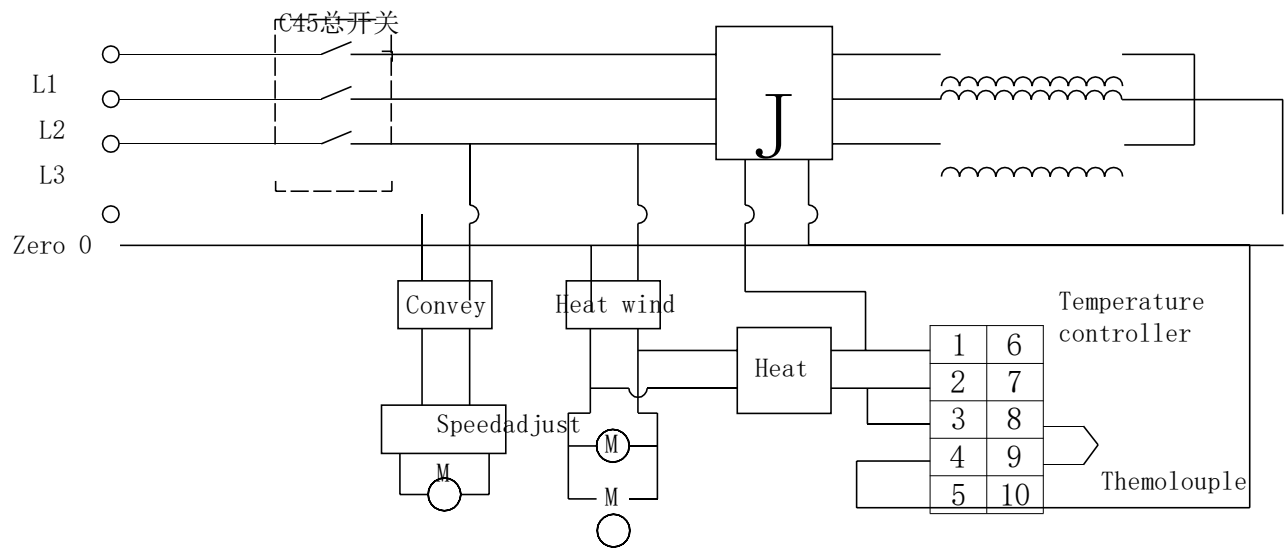
1. This machine is three phases (380V),
2. Closing the convey switch, and adjust the speed knob to the medium or slow speed.
3. Closing the heat wind switch, and the wind motor starts to work.
4. Pressing the heating switch, the machine starts to heat. The shrinking temperature is generally set at 135°C or so, if you want to set the temperature, please firstly press SET key, then press UP or DOWN key, and at last press SET key after your confirmation.
5. During the operation, if there are too many rumples, please decrease the conveying speed or increase the heating temperature. Whereas, if the shrinking film is broken, then please increase the conveying speed or decrease the heating temperature.
6. After rinsing package, firstly, please shut off the heating switch, and let the conveying motor and fan work for another 10 minutes or so, then shut off the other power switch, master heating switch and master controlling switch.
7. The diameter of the inputting wire for this machine should be more than 3mm², and do not put your hand into the machine in case there's an electric shock.
8. The machine should be put flatly at the ground, or the mesh-belt would be aberrant; after three months using, please check the aging of the electricity wire, and exchange it if it's necessary.

VII. MALFUNCTION & TROUBLESHOOTING:

If there' s a malfunction, firstly please have a check whether the inputting voltage is normal and also it is in the right wire connection.

1. There' s no heating phenomenon in the shrinking tunnel.
 - a. Check input power is all right, whether there is any lack of phase.
 - b. The temperature regulator has seized up: maintain of exchange it.
 - c. AC contactor has been damaged: exchange it.
 - d. The wire connectors have been aging and lead to turnoff: reconnecting them.
 - e. The heating tube has been damaged: exchange it.
2. The conveying motor doesn' t work:
 - a. Check whether the chain is too tight, loosening the tighten bolts at two ends.
 - b. The motor switch has seized up: exchange it.
 - c. Speed regulator has been burnt due to high temperature: exchange it .
3. Hot wind motor doesn' t work:
 - a. The fan has been damaged: exchange it.
 - b. Hot wind switch has been damaged: exchange it.
 - c. The fan leaf has been blocked: reset the machine after solving this problem.

八、电器原理图：



Three phase (380V) wining:

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Notes:

1. Among the four models mentioned above, there might be slight differences in individual units without further explanation; design improvements for new products will not be separately explained.
2. Customized models share this manual, and parameter modifications will not be separately specified.