

Double Chamber Vacuum Packing Machine



Shandong Kangbeite Food Packaging Machinery Co., Ltd.
ADD: No.458 Changzhan Road, Zhucheng, Shandong, 262200, China

Tel.: +86-536-6083899 FAX: +86-536-6083799

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1. Brief introduction

Double chamber vacuum packing machine is a typical type of packing machine for plastic bags vacuum and sealing (Fill in modified air in some cases). This technique helps prolonging the shelf life of the products in bags by oxygen isolation, moisture proof, anti-corrosion, insect prevention, anti-pollution, etc.

2. Applications

This machine applies to vacuum sealing of various laminated plastic bags and aluminum foil bags.

It's ideal packaging solution for vacuum sealing and gas filling-sealing of multiple types of food and non-food products, including fresh/cooked food, fruits, vegetables,, medicine, chemical products, textile products, hardware, electrics, etc.

3. Features

Whole machine frame and surface is made of food grade SUS304 stainless steel, easy cleaning, anti-corrosion, long-lasting.

The packing process is controlled by pre-set program. Users are allowed to setup parameters like vacuum time, heating time, heating temperature in accordance with various packing material and requirement, for best vacuum packing quality.

Two working plates with 1 chamber lid, works alternatively to enhance packing speed. Chamber lid for smaller machines are lightweight for ordinary operators to handle (DZ600, DZ800); For heavy duty double chamber vacuum packing machines (DZ800, DZ850), the chamber lid is heavy and moves automatically for convenient operation.

According to sealing bar length, standard models are: DZ600/2S, DZ600/4S, DZ700/2S, DZ800/2S, DZ850/2S.

4. Specifications

Model No.	DZ600/2S	DZ600/4S	DZ800/2S	DZ850/2S
Chamber size (mm)	690*620*160	720*620*160	920*780*220	970*780*220
Sealing bar	600mm*2*2	600mm*4*2	800mm*2*2	850mm*2*2
Power supply	380V/50 or 60HZ/ 3Phase, or customize			
Total power (KW)	2.2	2.2	6	6
Packing speed	3-6 cycles/minute			
Pack max. length (mm)	490	260	620	630
Vacuum pump	BUSCH 100	BUSCH 100	BUSCH 200	BUSCH 200
Overall size (mm)	1400*720*950	1420*800*950	1835*910*1060	1935*960*1060
Machine weight (kg)	260	270	600	650

5. Main components and working process



- | | | |
|-------------------|------------------|---|
| 1. Chamber lid | 2. Handles | 3. Silicone strips, bag opening press bar |
| 4. Connecting rod | 5. SUS304 frame | 6. Emergency stop |
| 7. Vacuum pump | 8. Control panel | 9. Wheels with brake and anchor bolts |

Working process:

1. setup parameters, such as heating temperature, sealing time, vacuum time;
2. Place vacuum bags at the plate, press bag opening with the press bar
3. Press chamber lid, start to vacuum till the pre-set time; Place vacuum bags at the other side simultaneously
4. Automatically sealing
5. Vacuum and sealing completed, chamber lid opened for vacuum and seal at the other side
6. Collect finished packs
7. Load vacuum bags for another cycle

6. Installation and operate

1)Installation:

- a. Place the machine at absolute flat area
- b. Check vacuum pump oil level through oil level window, make sure of ideal status of 2/3 full
- c. Make sure of safety ground connection with ground cable
- d. Confirm us with your local power supply standards, make sure our machines comply with the standard
- e. Power on, turn on the machine, press chamber lid, check if vacuum pump and motor running correctly. (If vacuum pump runs, but not works to vacuum, that might be cause by vacuum pump motor reverse. Exchange the position of the phase lines to fix this)

2) Pre-set



1. Air evacuate time (Vacuum time)
2. 3. Heating time control units for each sealing bar (for machines with 4*2 sealing bars, there will be 4 pieces of heating time control units)
4. Power light 5. Vacuum meter 6. Heating temperature 7. On/off switch

- a. Setup air evacuate time (vacuum time): 0-99.9 seconds
- b. Setup heating temperature according to bag material for best sealing quality.
- c. Setup heating time according to bag material and pre-set heating temperature.

3) Operate

- a. Power on. Power light up
- b. Place the vacuum bags filled with products to the working plate, press the bag opening with the press bar, make sure bag opening flat and clean.
- c. Manually press the chamber lid to cover the working plate, complete vacuum and sealing process automatically
- d. For manual moved lids, the lid bounces up a little after sealing finished, handle it to press working plate of the other side; For automatically moved lids, it will automatically move to cover the working plate of the other side
- e. Take out finished packs, load new bags for another cycle
- f. Press EMERGENCY STOP if anything unexpected happens
- g. Switch off and cut the main power when off work

7. Maintenance

Machine maintenance is important to keep best packing quality and prolong machine's service life.

- 1) Working environment temperature -10°C- 60°C, humidity less than 85%, no hazard air around, no dust, no explosive articles.
- 2) Check vacuum pump oil level, keep it at 2/3-3/4 of the oil window. Always use vacuum pump special oil.
- 3) Change vacuum pump oil immediately if it turns black or milk white, or find water drops in oil, or viscosity increases. Ordinarily, change vacuum pump oil every 1-2 months.
- 4) **Change vacuum pump oil:** Let the vacuum pump run for 15-30 minutes to rise its temperature, then stop and cut off main power. Release the used oil completely before refilling.
- 5) **Clean magnetic valves every 2-3 months:**
 - a. Cut off main power, take off magnetic valves
 - b. Disassemble magnetic valves, wash every parts (valve seat, circuits, valve body, valve element, springs) in gasoline or kerosene.
 - c. Wipe dry every parts before reassembling (apply some lubrication oil to valve element)
 - d. Power on and test. If the valve vibrates drastically or make noises, take the valve off and reassemble correctly.
- 6) Apply lubrication oil to connecting rod bearings, spring hook points, wheel swivel bearings, etc every 30 days.
- 7) Keep the machine and components clean, especially heating bar, silicone strips.
- 8) In movement of the machine, keep it steady, no collision, no upside down.
- 9) Always have professional electricians to fix any issues.

8. Troubleshooting

What	Why	How
Machine doesn't work after pressing the chamber lid	Vacuum pump not working or motor reverses	Exchange any 2 phase lines
	Travel switch not connected	Adjust switch picks
	Power outlet not correctly connected	Check and reconnect
	Power supply under voltage	Change power supply
	Air evacuate time (vacuum time) set to 0	Reset vacuum time
	Broken circuit terminal	Replace
	Broken contactor	Repair or replace
	Chamber lid or working plate deformed	Repair
Power light doesn't work	Broken power switch	Replace
	Broken power light	Replace
	Broken wire or connection	Replace
Vacuum pump running but no vacuum	Loose chamber lid	Press chamber lid harder
	Motor reverse	Exchange position of phase lines
	Blocked air circuit or severe air leaking	Check air circuit and connectors and fix
	Broken magnetic valve	Repair or replace
	Vacuum pump lack oil	Fill vacuum pump oil
Bad vacuum degree	Air leaking	Check circuits, connectors, vacuum pump, vacuum degree, magnetic valves
	Vacuum meter not accurate	Replace
	Gasket in pressurizing valve fall off	Disassemble pressurizing valve restore gasket
	Vacuum pump oil quality and quantity	Refill or replace
Phase loss	Wire and connectors	Replace
	Broken A.C. contactor touch spot	Replace A.C. contactor
	Broken section disconnecting switch	Replace
	Power supply phase loss	Consult local power supply bureau

Electric elements overload frequently	Vacuum pump oil viscosity too high	Replace
	Motor reverse	Exchange position of phase lines
	Environment temperature too low	Run without loading for a few cycles
	Vacuum pump oil excess	Adjust to standard oil level range
	Vacuum pump exhaust gas filter blocked	Replace filter or filter element
	Short circuit points	Check and fix
	Instable voltage	Fix main power supply
Air leaking	Pipes aging	Replace
	Gas circuit fittings loose	Fix
	Sealing washer broken	Replace
	Magnetic valve leaking	Repair or replace
	Vacuum pump leaking	Repair or replace
	Vacuum meter leaking	Replace
	Broken air bag	Replace
Vacuum pump won't stop	A.C. contactor no resetting	Fix or replace
	Broken time relay	Fix or replace
	Travel switch no resetting	Replace
No heating	Broken heating bar	Replace
	Broken heating wire	Replace
	Broken range switch	Replace
	Broken time relay	Fix or replace
	Broken heater transformer	Fix or replace
	Circuit loose or fallen off	Check and reconnect
	Broken heater relay	Replace
Upward bag opening press bar cause short circuit	Fix	
Heating won't stop	Heater contactor no reset	Replace
	Broken heater relay	Replace
No pressure when sealing	Broken pressurizing valve	Fix or replace
	Short circuit	Fix
	Broken air bag	Replace
	Too much space between sealing bar and silicone strip	Adjust Phenolic Foam Board or silicone strip
	Inflating pipe blocked	Fix
	Misplaced heating bar	Fix
	Misplaced silicone strip	Fix
	Dirty sealing area	Keep it clean

Sealing wrinkles	Too much space between sealing bar and silicone strip	Adjust Phenolic Foam Board or silicone strip, space between heating bar and silicone strip should be 6-9mm
	Heating temperature and time	Reset
	Isolation fabric wrinkles	Keep it flat
	Isolation fabric adhere to bags	Replace isolation fabric
Sparks when sealing	Heater power wire misplaced	Adjust wiring terminal
	Sealing wire short circuit	Clean sealing wire
	Upward bag opening press bar	Fix
No air deflating	Broken deflation valve	Fix or replace
	Broken time relay	Fix or replace
	Deflation valve wire broken	Fix
	Blocked air circuit	Clean
	Broken travel switch	Fix or replace
Noises	Loose magnetic valve	Fix (consider voltage)
	Loose A.C. contactor	Fix or replace
	Broken vacuum pump coupler	Replace coupler
	Blocked or broken exhaust gas filter	Clean (gasoline/kerosene) or replace filter
Vacuum pump starts when chamber lid opened	Travel switch won't reset or switch picks misplaced	Replace travel switch or adjust switch picks
Chamber lid only works at one side (only for automatic swing lid machines)	Sensor/ magnetic switch misplaced	Open the back door, adjust switch position

9. Contacts

Feel free to ask us any questions any time.

Chinese : Tel.: +86-536-6083899

FAX: +86-536-6083799

English: 008615006621108

admin@kbtfoodpack.com