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Fully automatic swing arm suction cup type  
sewing  
labeling machine

***INSTRUCTION  
MANUAL***

*HEBEI ZHONGGONG SEWING MACHINE CO., LTD*

**1. Summary**

The automatic swing arm suction type stitching labeling machine is a device which automatically adding labels to the sewing machine when the bag mouth is stitched. It is suitable for all kinds of bag closers with 4900 folding machine. With one button start, PLC intelligent control automatic induction woven bag placing labels, making it become more stable, and reliable tag placement equipment.

The labeling machine can be used to place paper, cloth, silk labels to rice bags, grain bags, feed bags and other woven bags.

This instruction manual includes information about safety and warnings. Please read the contents carefully and strictly follow all warnings and precautions.

## **2. Unpacking inspection**

Open the package and take out the equipment. Please carefully check whether the accessories are missing or damaged. If any of the items are missing or damaged, please contact your supplier immediately.

- |                         |      |
|-------------------------|------|
| 1) Instruction manual   | one  |
| 2) Arm mounting bracket | one  |
| 3) M10 Countersunk bolt | four |
| 4) M10 Hexagon bolt     | five |
| 5) Main engine          | one  |
| 6) Spare suction cup    | one  |

## **3. The safe working guidelines**

Electrical equipment of this equipment with exposed mobile devices meets safety standards. If you fail to use the equipment in accordance with the relevant operating instructions, you may weaken or lose the protection provided by the instrument.

1) Before using the equipment to check the mechanical parts and electrical parts are normal, beware of any damage or abnormal phenomenon, such as any abnormal situation: wire exposed core, chassis damage, high or low pressure, cylinder lock, fixed bolt Loose.

Please do not use it.

2) The damaged wires must be replaced with the cables of the same type or the same electrical specifications.

3) Tighten the loose bolts, adjust air pressure to normal air pressure, eliminate cylinder stuck fault

#### **4. Technical parameter**

1) Dimension : 709 \*267\* 519mm

2) Power supply: 220V 50HZ      Power consumption: 240W

3) The environment of the machine is minus 5 degree Celsius to

The machine only needs 5-6 kilograms of compressed air to above 40 degrees Celsius.

4)The machine needs a pressure of 5-6 kg dry compressed air to run normally.

5) In theory the maximum speed of 720pcs / hour. The actual speed will change due to environmental factors.

6)Label material: airtight paper, cloth labels.

7)Label width: 40-60 mm range can be adjusted according to the actual width of the labels(when the width difference is too large, the corresponding slider needs to be replaced).

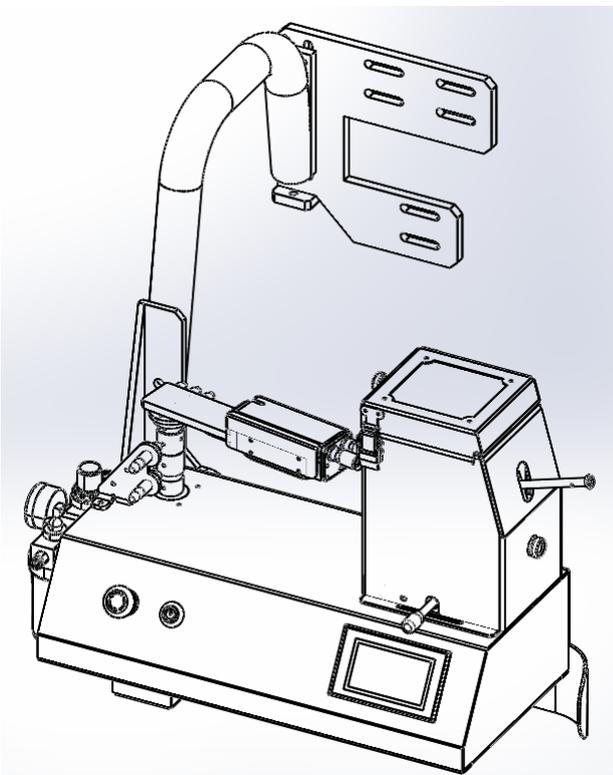
8)Label height: 80-135 mm range can be adjusted according to the actual height of the labels.

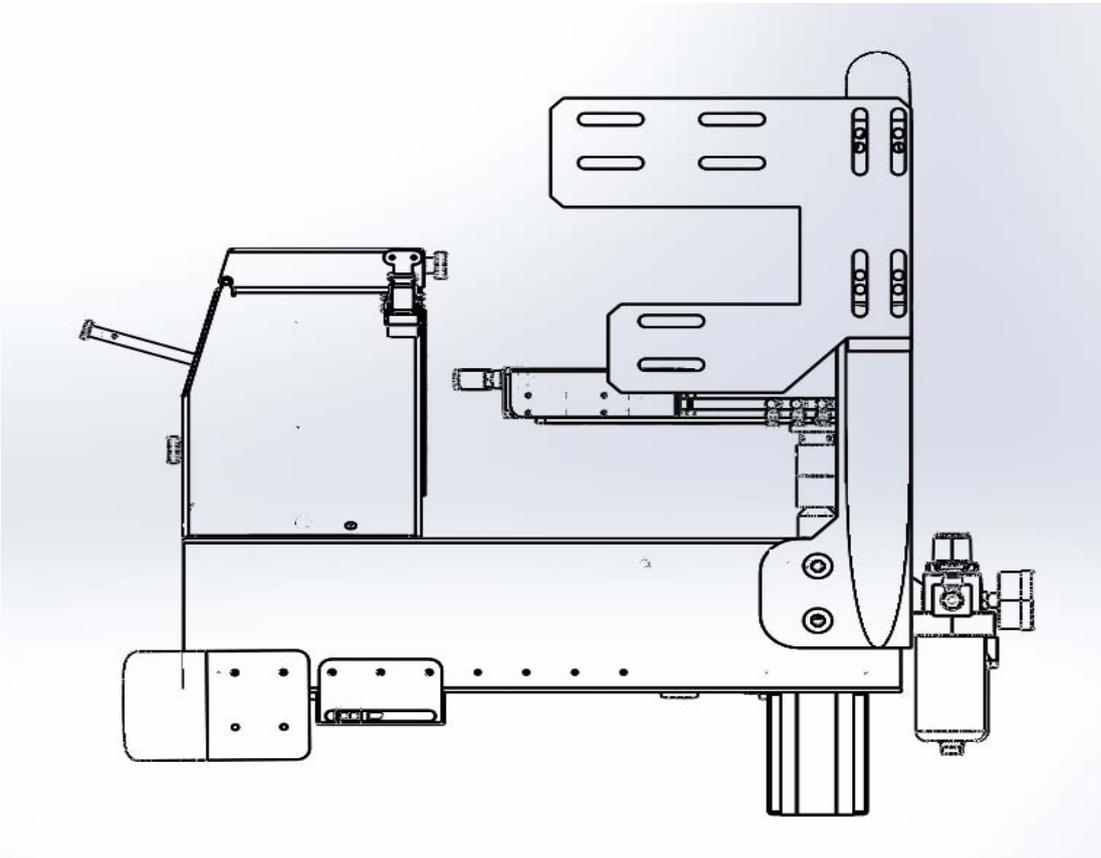
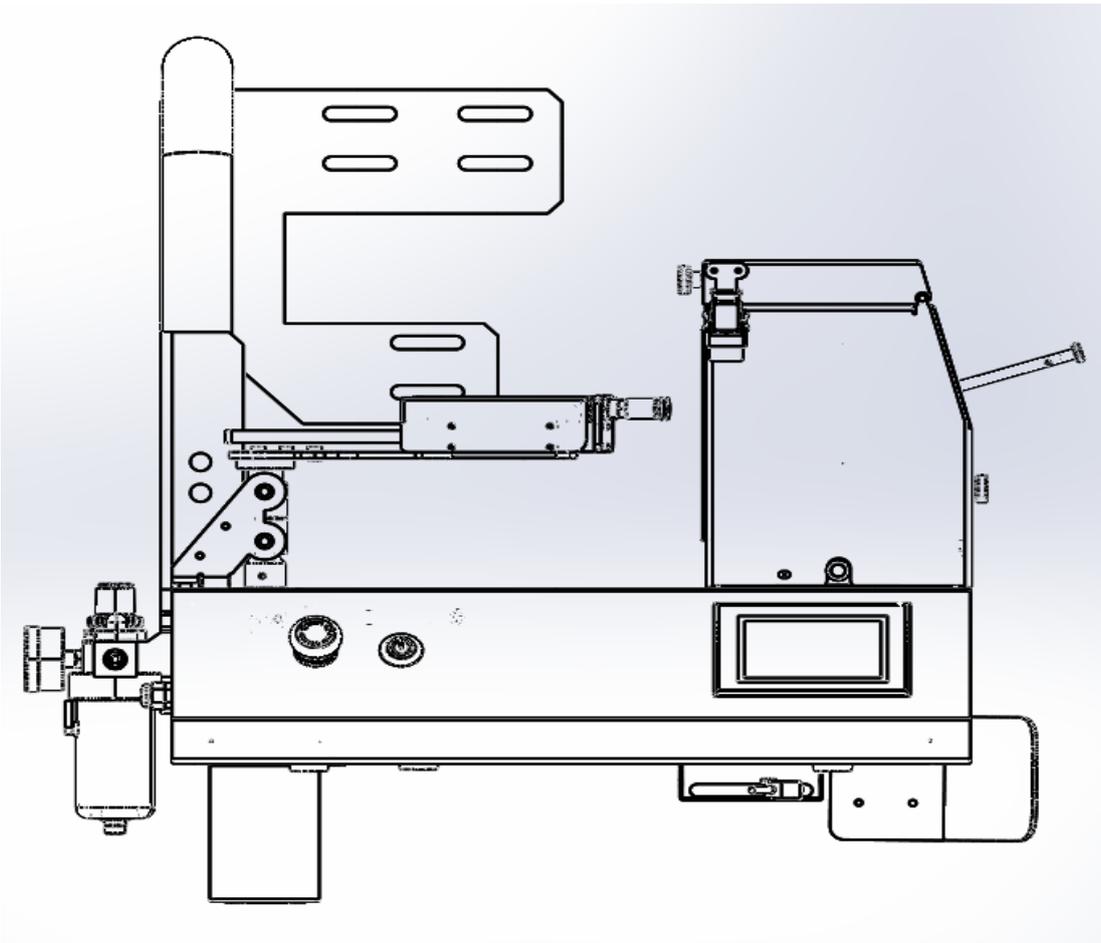
9)Label capacity:  $\leq 300$  sheets

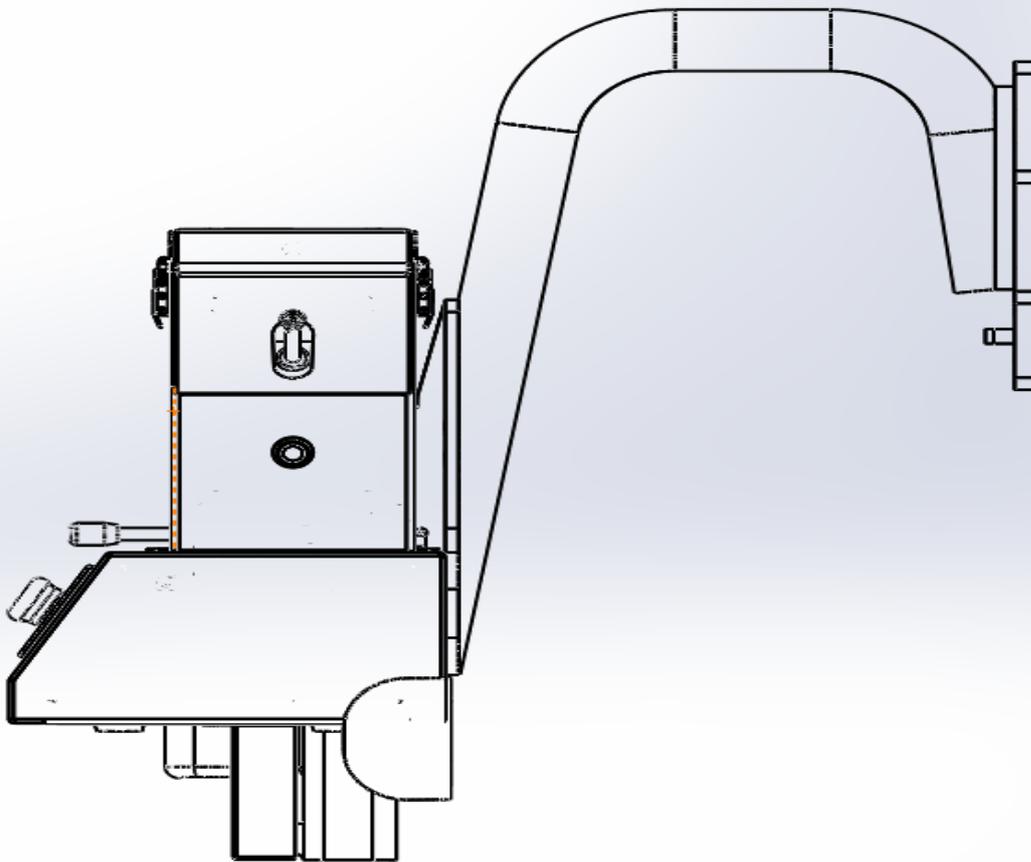
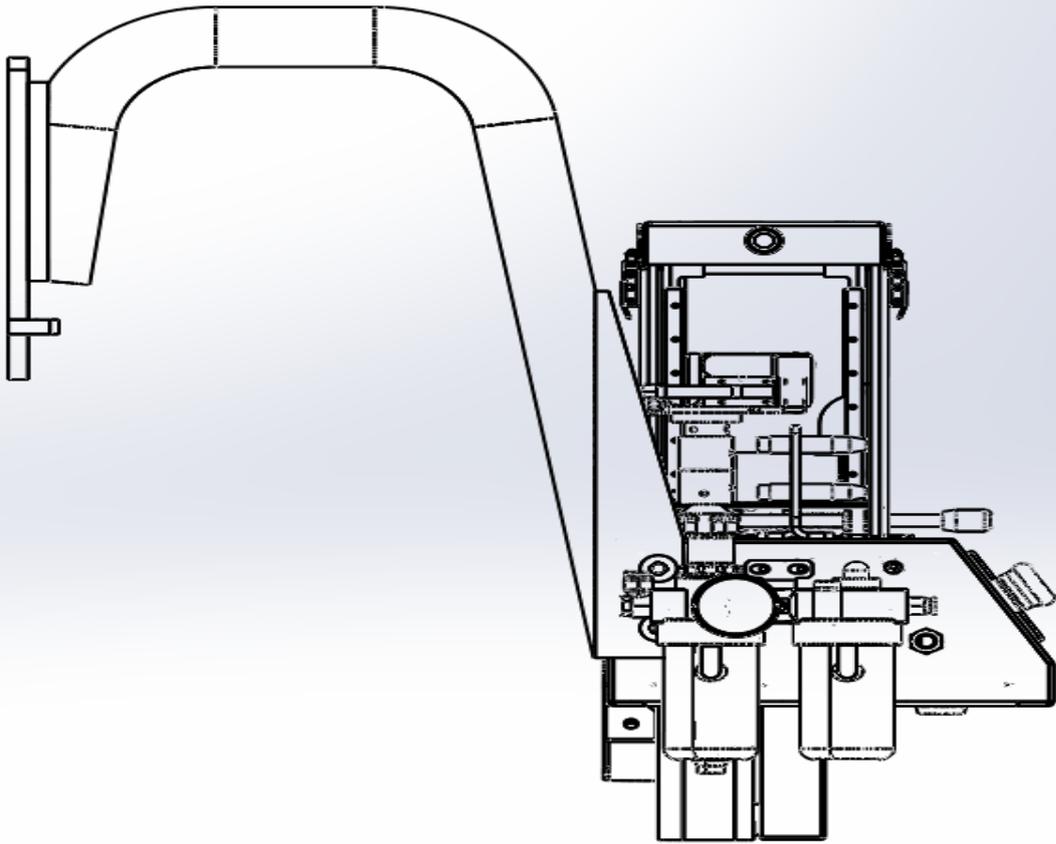
10)It connects with the square column and sewing machine in a curved arm type. The conveyor installation space is not limited.

11)Suggestion: The label machine is best to use with our company folding machine.

## 5. Outline structure







## 6. Switch function

Switch	Function
 Start switch	The main power supply switch of the label machine. Open the power switch, the blue power symbol lamp is lightened, and the equipment starts to enter the automatic working state.
 Emergency stop	When the machine occurs abnormal action, press the emergency stop switch, the label machine immediately stop grabbing and placing action.

## 7. Touch screen interface

1> After the labeling machine is turned on, enter the language selection screen.



Select the language in this screen to enter the label machine operation interface.

2> Label machine operation interface

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送签位置延时 9999.9 秒



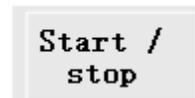
返回

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Tag position delay  
9999.9 second



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(1) **Start/Stop button:** Press the start/stop button, the labeling machine to start automatic positioning. After the positioning is completed, the robot grabs a label and waits for the arrival of the bag to prepare the label.

Press the Start/Stop button again to automatically stop the system. Manually perform the grab test and the suction test or turn off the power.

(2) **Twisting Label On/Off button:**

For the thin and light standard paper, you need to press the “twist label on/off button” to start twisting labels function to ensure that the robot can grab a single sheet of paper.

For the thicker label, you can turn off this function to protect the robot .

**(3)Test button:**

Press the start/stop button, the labeling machine to start the automatic positioning. Then pressing the run test button, the robot will transport a label paper to the sewing machine.

**(4)Grab test button:**

It is valid when the start/stop button is not turned on. Press the grab test switch to extend the robot, and then press the grab test switch to retract the robot

**(5)Suction test button:**

It is valid when the start/stop button is not turned on. Press the suction test switch to inhale, and then press the suction test switch to stop the inhalation.

**(6)Delivery positioning delay setting:**

Change this parameter to adjust the position of the label on the front and back of the bag. ESC is return and ENTER is confirmation.

**(7) Return button:** Press the return button to return to the standby screen.

**(8) Next page button:** Press the next page button to enter the labeling machine parameter setting screen.

**3 >Label machine parameter setting interface**

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Delivery speed

999999

Second extension delay

9999.9

Twisting speed

999999

Twisting distance

999999

Return

Continuous  
test

next page

### **(1) Delivery speed setting:**

Set the delivery speed parameter according to the speed of the package on the sewing machine. Generally set at around 15,000.

### **(2) The second extension delay setting of the suction cup:**

When the robot delivers the labels to the package, the position that the robot extends again when approaching the packaging bag. The larger the value is, the closer the distance is to the package, the smaller the value is. The farther the bag is.

### **(3) Twisting speed setting:**

Adjust the adjustment range of this parameter according to the thickness of the label paper (60000-20000).

### **(4) Twisting distance setting:**

Adjust the adjustment range of this parameter according to the thickness of the standard paper (1000-700)

## **4>Advanced parameter setting interface**

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Swing arm return speed 999999 HZ

Swing arm return position 999999

Twisting return position 999999

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### **(1) Swing arm return speed setting:**

By adjusting this parameter, set the speed of the robot reset.

### **(2) Swing arm return position setting:**

By adjusting this parameter, set the position of the robot starting point.

### **(3) Twisting return position setting:**

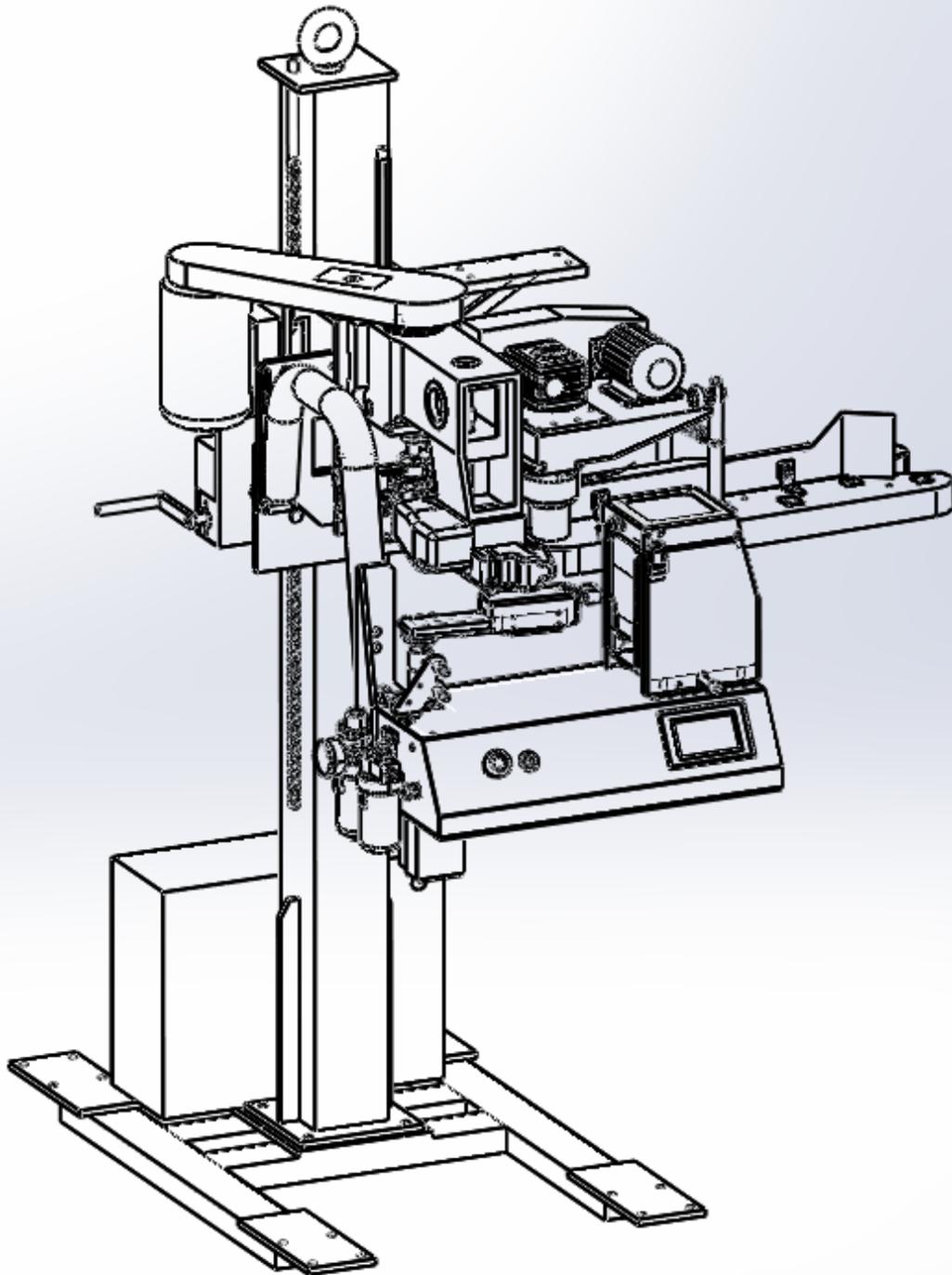
By adjusting this parameter, set the position of the label delivery starting point after twisting

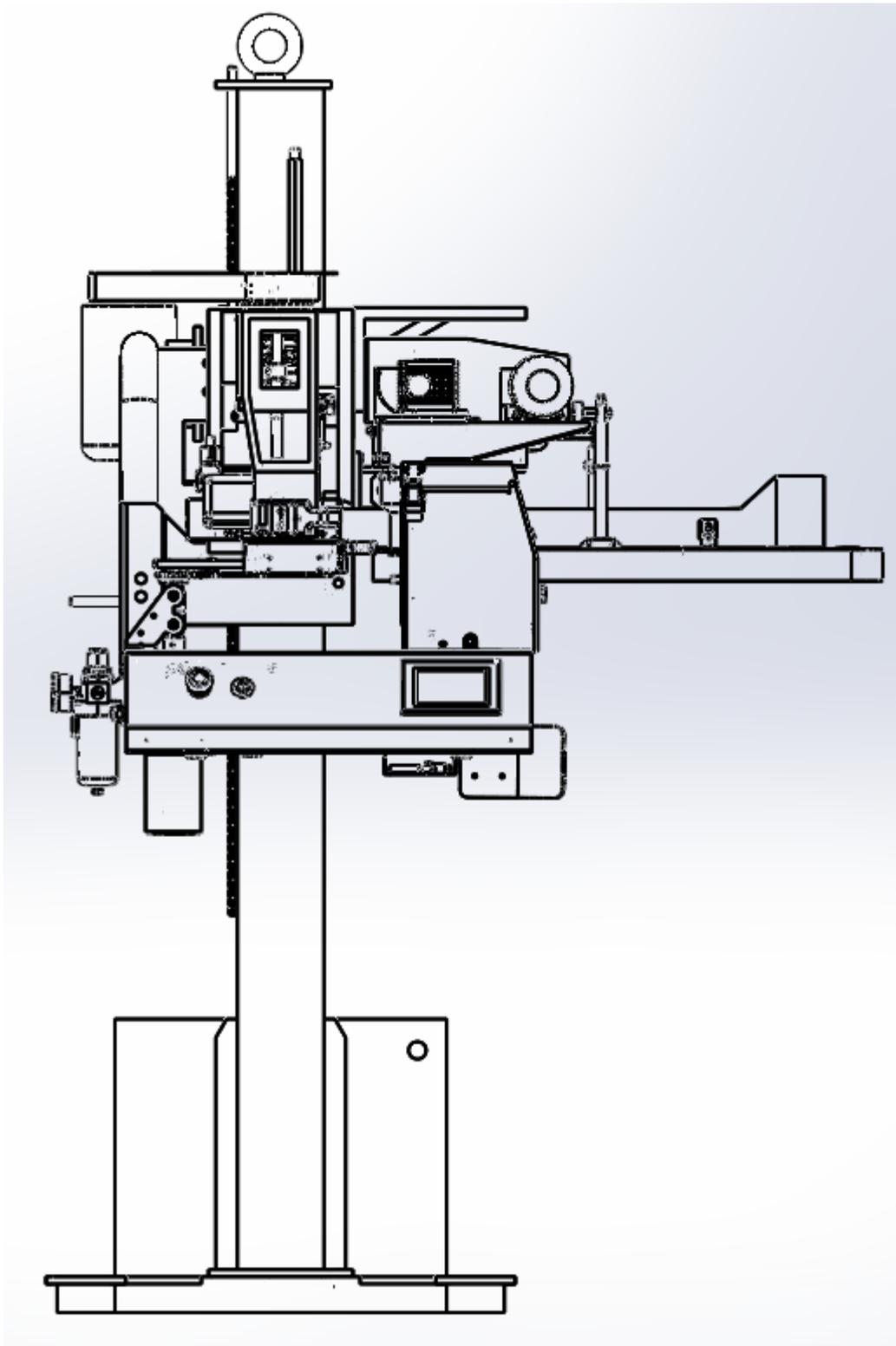
## **8> Common faults**

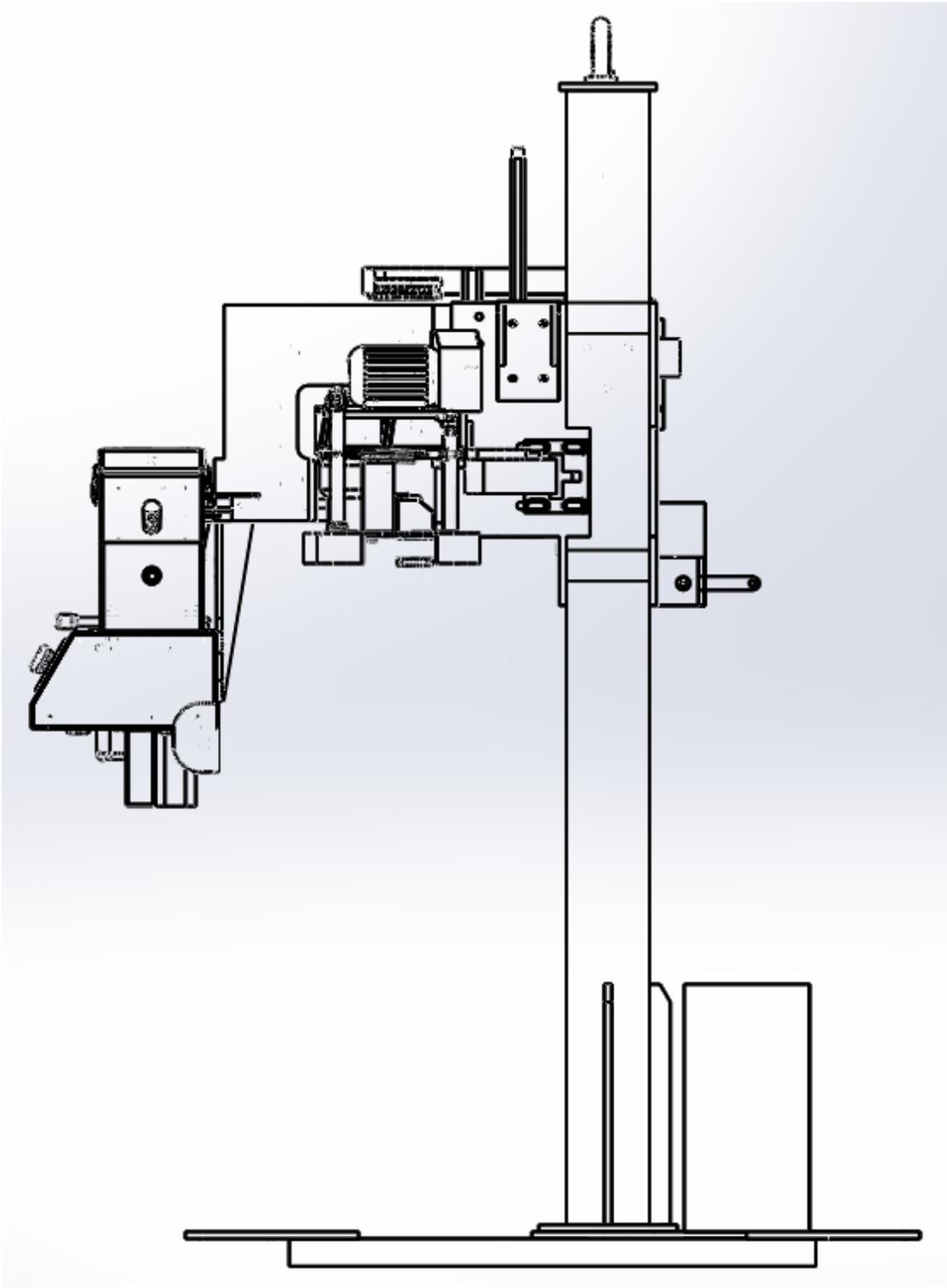
<b>common faults</b>	<b>solution</b>
1、 Turn on the power, the label machine does not work after the action, and the test button does not respond.	The photoelectric sensor is blocked and the sensor red light is on. Remove the obstruction or adjust the sensitivity of the photoelectric sensor until the red indicator light goes out
2、 Press the test button to work	Adjust the sensitivity of the

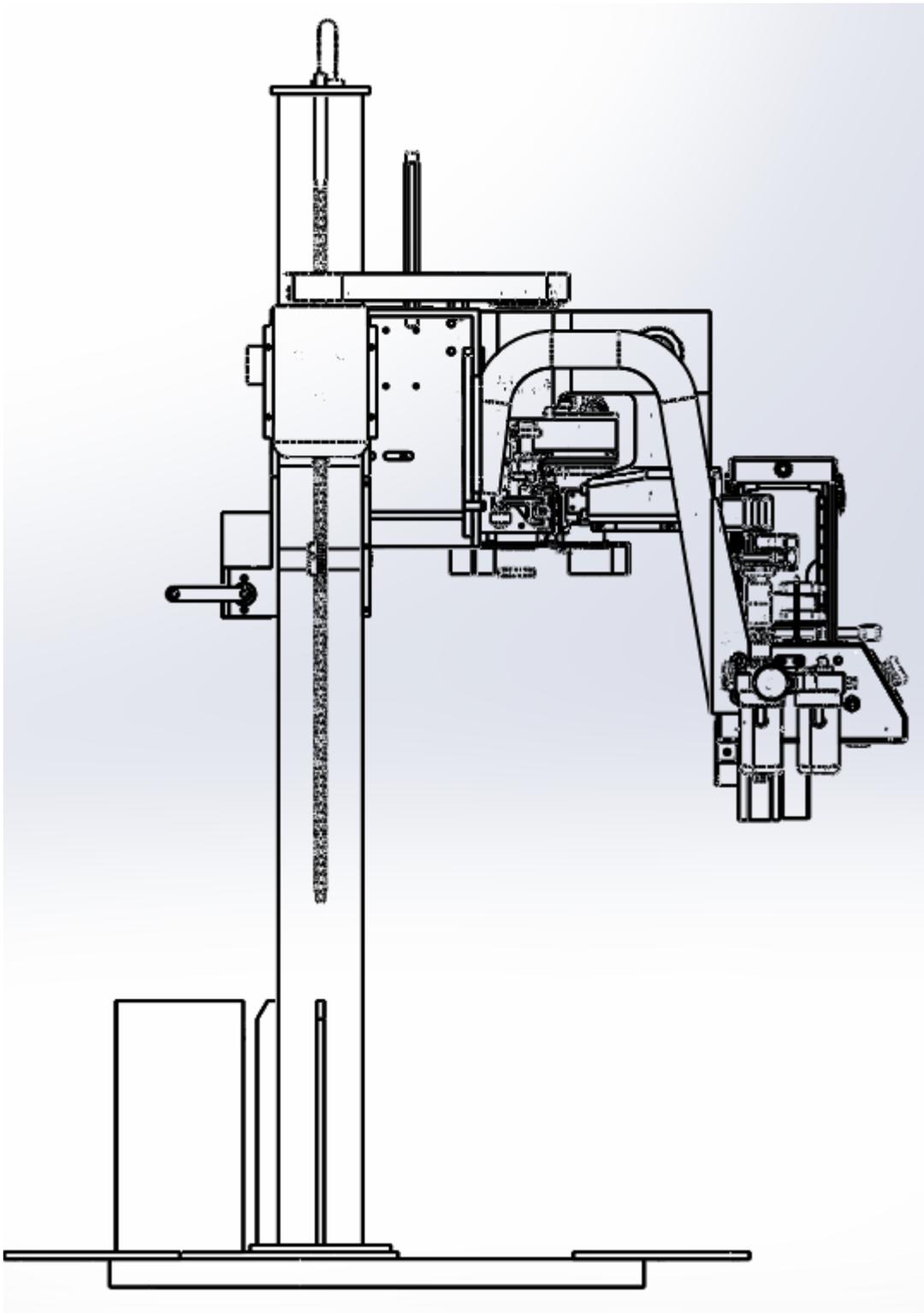
normally. The device does not respond when the product passes.

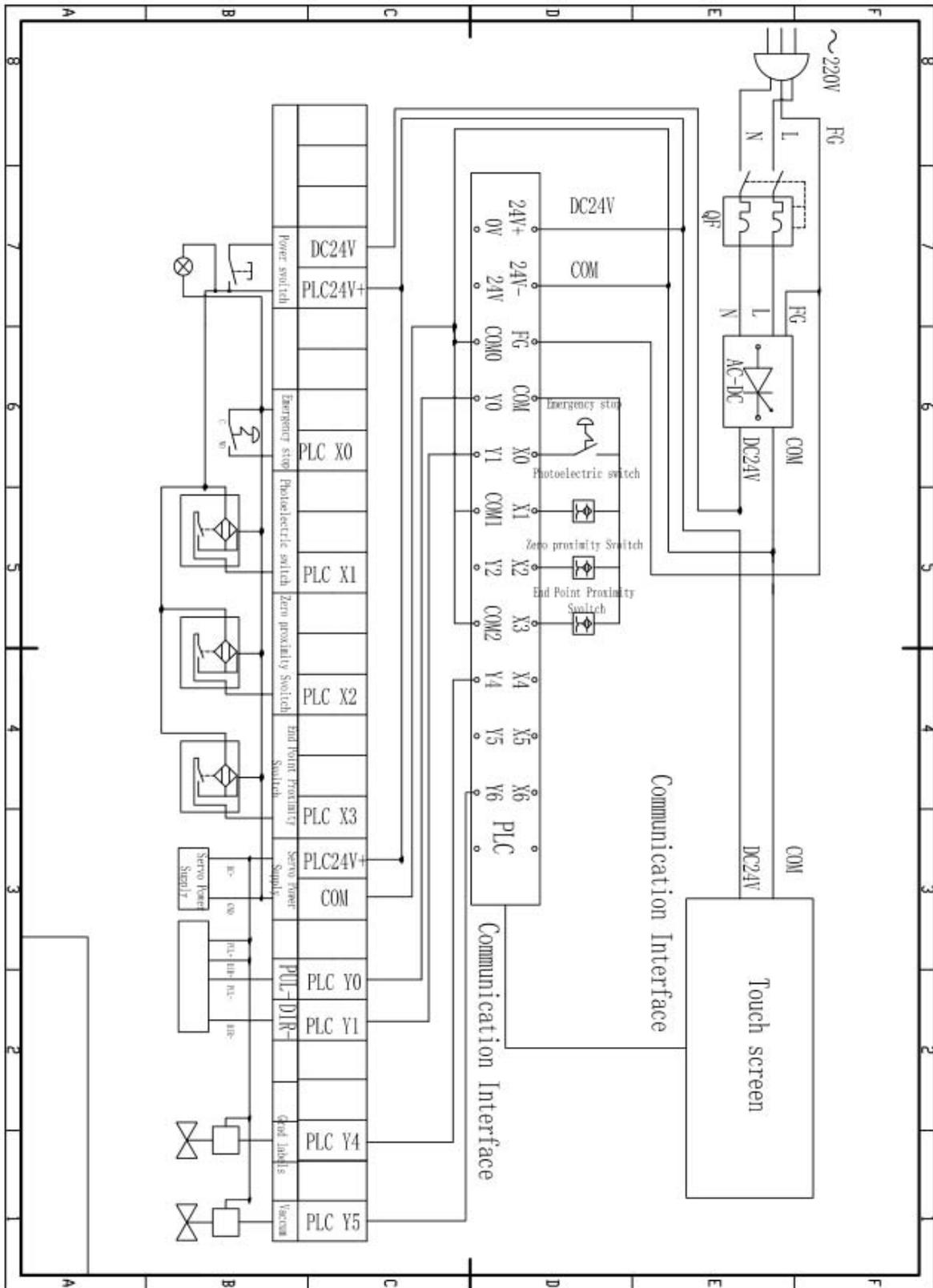
photoelectric switch until the red light on the photoelectric switch lights up when the product passes.











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