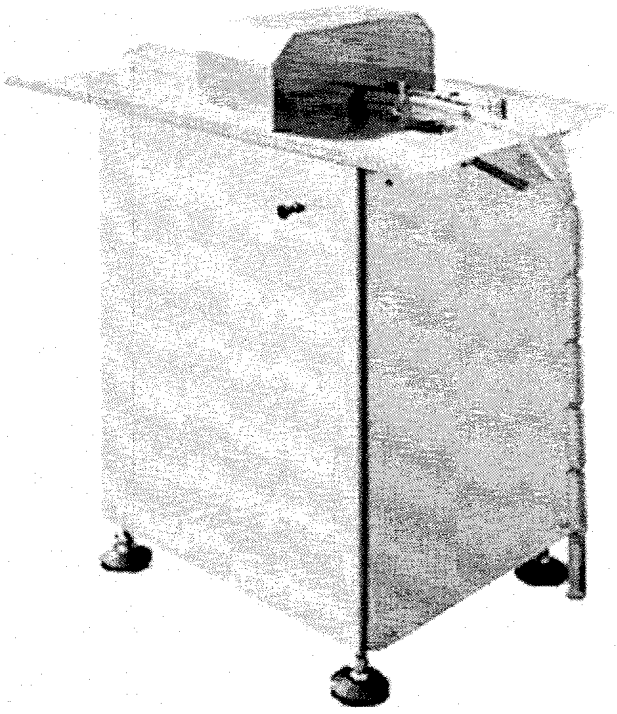
HALF-AUTOMATIC SAUSAGE TYING MACHINE

OPERATION MANUAL

FST- 01



NOTE: READ THIS MANUAL BEFORE USE.

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Introduction to the Machine

1. Introduction of the Performance

Half-automatic Single Sausage Binding Machine WZC-100 is small in size, easy to operate and of high efficiency. It has the following advantages. First of all, the length of the sausage products can be adjusted according to your varied requirements. Secondly, it can make the dull work easy and enjoyable. Thirdly, the structure which requires least maintenance gives you no worries about your production. It is the best choice for medium-scaled and small-scaled food enterprises.

2. Technical Parameters

a) Suitable sausage diameter: 9-30mm

b) Length of single sausage: adjustable

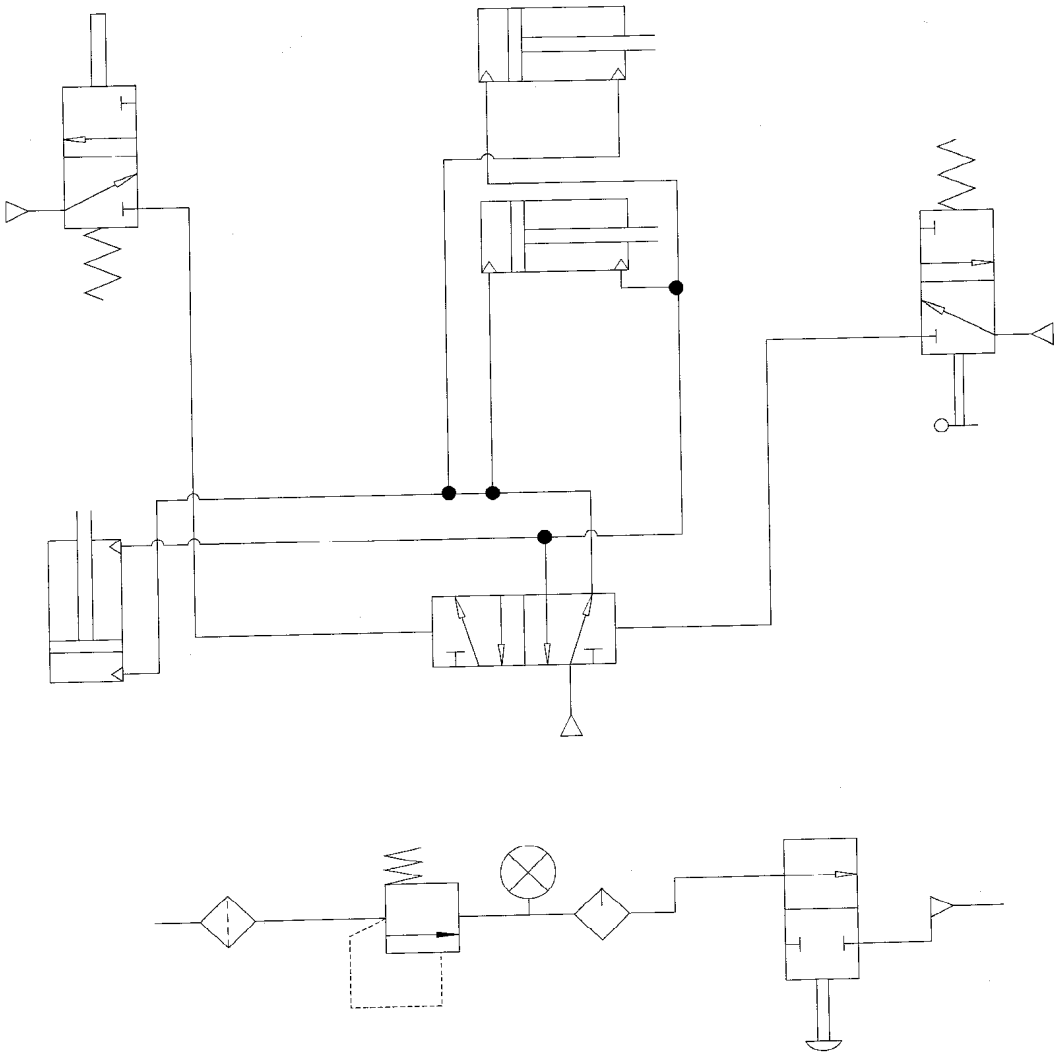
c) Working pressure: 0.4-0.6MPa

d) Capacity of production (depending on the size of products): about 3600 per hour

e) Size (L×W×H): 85×56×100cm

3. Diagram of the Aerodynamic Working Mechanism

Diagram of the Aerodynamic Working Mechanism



Operating Manual

I Operating Procedure

Connect the standard air source to the two connected parts, adjust the air pressure to 0.6 MP, pull out the manual valve to open the air source, adjust the length positioning board to the required length, and pass the stuffed sausage through the opening. Press the locating lever in the end of the first sausage and move back to the peach-shaped clamp for thread winding. When the thread has been wound, nip this end of the sausage with the thumb and the first finger, pull it to the locating lever and press the lever. Repeat the above operation. Thus, with the proficiency of hands increased, the binding speed be increased. Because of the manual control, even the first sausage can be bound. So it can save the small-sized casing.

II Changing of Thread Roller

a) Before changing the thread roller, you have to push the manual valve in, cut the air, open the cover of the winding box, push the thread bobbin to the suitable operating position clockwise manually, loose the nuts of the grommet at the bottom of the thread roller, pull out the grommet, remove one bolt and loose the other one of the two bolts, move the grommet to the other side, remove the thread roller when pressing the nut, and take out the vacant thread roller. Then install the new thread roller in the position of the former one, install the grommet in the original

position and screw down the nuts and bolts, check whether there is even clearance between thread roller and the thread bobbin, pass the thread through the module, the thread directing pole, and the opening of the peach-shaped clamp, and finally put the thread in the front.

b) Passing the thread through according to the picture:

Pull the end of the thread on the thread roller, pass it through the opening on the thread directing pole a, the opening on the short thread pole b, the two sides of the thread pressing device c, the opening on the long thread directing pole d, and finally the cylinder and the mouth of the peach-shaped clamp.

III Adjustment of the Degree of Tightness of the Thread

Different casings have different requirements for the degree of tightness. Hard casings, such as plastic smoked casing, require high-degreed tightness. First of all, push the manual valve in and cut the air. Then screw the positioning nut behind the centrifugal presser outward so that it can achieve the highest degree of tightness. On the contrary, natural casings and soft collagen casings require low-degreed tightness. So you should screw the positioning nut inward so that you may get looser thread.

IV Failure and Repair

a) Mechanical Failure

When repairing, you should push the manual valve in and turn off the air. Then remove the upper board and the revolving box. When there is no air supply, it should be easy to push the cylinder of the peach-shaped clamp and that of the winding thread. If not, there must be broom-finish, distortion or seizure. It can go back to the normal condition if you clean it up.

b) Air Passage Failure

After examining the mechanical part and confirming that there is no problem with it, open the air source by pulling out the manual valve. You should be careful for safety. When turning and pushing, you had better not stand close for safety reasons. If it doesn't work when you press manually, check whether there is air in the main windpipe first. If there is air, then check the tubule of the machine-controlled valve. Remove it to check whether there is air in it. If there is air in it, there must be something wrong with the reversing valve. If not, there must be something wrong with the machine-controlled valve. Check whether the valve disc is in position when you press the pressing pole. If it is in position but there is no air, the machine-controlled valve must be broken and you should replace it with a new one of the same type. If the peach-shaped clamp cannot nip the winding thread when pressing the pressing pole, then check

the machine-controlled valve touched by the cylinder of the peach-shaped clamp. Use the same method to find out the problem. If the thread can be wound but the clamp does not open after winding and the thread is still being wound without stop, then use the same method to deal with the machine-controlled valve touched by the cylinder of the winding thread.

V Maintenance

a) Use the machine normally and observe the two parts every day. If there is water, you should drain the water. As we use the most advanced cylinder in the world, the atomization oil cup can be in normal use, no matter whether you fill in oil or not.

b) Keep the chain and the chain wheel oily. The main axis of the thread winding base, the sliding bar and the sliding sleeve should also be kept oily.

c) Every time when the machine has been used, wash it and wipe it up with dry cloth.

Parts List

NO.	Serial NO.	Spec.	Name	Remark
1	BX0001		The Cover of the Coiling Box	
2	BX0002-01		Pillar of the hand lever(I)	
	BX0002-02		Pillar of the hand lever(II)	
	BX0002-03		Hand Lever	
	BX0002-04		Fastness Ring	
	BX0002-05		Pressure Board	
	BX0002-06		Pressure Lever	
3	BX0003		Slide Board	
4	BX0004-01		Extension Spring	
	BX0004-02		Lever(I)	
	BX0004-03		Operating Lever	
	BX0004-04		Mechanical valve	
5	BX0005		Front Panel	
6	BX0006		Pillar of the Chain Wheel	
7	BX0007-01		Retaining Ring	
	BX0007-02		Bearing	
	BX0007-03		Tensioner	
8	BX0008		Stay Lever	
9	BX0009		Revolving Board	
10	BX0010		Mechanical valve	
11	BX0011-01		Hand-draw Valve	
11	BX0011-02		Board	
12	BX0012		Cylinder(I)	

Parts List

NO.	Serial NO.	Spec.	Name	Remark
13	BX0013-01		Chain	
	BX0013-02		Oilless Bearing	
	BX0013-03		Slide Piston	
	BX0013-04		Transversal Assembly	
	BX0013-05		Vertical Assembly	
14	BX0014		Slide Lever	
15	BX0015		Pneumatic Valve	
16	BX0016		Pillar of the Slide Lever	
17	BX0017		Left panel	
18	BX0018-01		Cylinder(II)	
	BX0018-02		Pillar of the Cylinder	
19	BX0019		Frame	
20	BX0020		Foot	
21	BX0021-01		Flywheel	
	BX0021-02		Inner Bushing	
22	BX0022		Chassis of the Drive Shaft	
23	BX0023-01		Drive Shaft	
	BX0023-02		Bearing	
	BX0023-03		Retaining Ring	
24	BX0024-01		Clamp Shaft	
	BX0024-02		Loop	
	BX0024-03		Peach shapr Clamp	
	BX0024-04		Isochronous Rocker	

Parts List

NO.	Serial NO.	Spec.	Name	Remark
24	BX024-05		Rocker	
	BX0024-06		Connecting Rod	
25	BX0025		Holder	
26	BX0026		RevolvingBox	
27	BX0027-01		Pig Tail(I)	
	BX0027-02		Fixing Nut	
	BX0027-03		Line fastness Set	
	BX0027-04		Guild(I)	
	BX0027-05		Base Plate for the line	
	BX0027-06		Splint	
	BX0027-07		Guild(II)	
28	BX0028-01		Bottom plate	
	BX0028-02		Notch	
	BX0028-03		Pig Tail(II)	
	BX0028-04		Centrifugal Chunk	
	BX0028-05		Bolt	
	BX0028-06		Lock Nut	
	BX0028-07		Pole	
	BX0028-08		Gripping Slice	
	BX0028-09		Pressure Slice	
	BX0028-10		Pressure Spring	
29	BX0029-01		Inner Tube	
	BX0029-02		Brake Disc	
	BX0029-03		Drum	

Parts List

NO.	Serial NO.	Spec.	Name	Remark
29	BX0029-04		Chain Wheel	
	BX0029-05		Support	
	BX0029-06		Chassis of the Drum	
	BX0029-07		Bearing	
	BX0029-08		Retaining Ring	
30	BX0030		Panel	
31	BX0031		Revolving Board(II)	
32	BX0032		Back Panel	
33	BX0033		Pneumatic Duplex Cylinder	
34	BX0034		Square Bar	
35	BX0035		Drive Shaft	
36	BX0036-01		Tensioner	
	BX0036-02		Bearing	
	BX0036-03		Tensioning Lever	
	BX0036-04		Tensioning Cover	
37	BX0037-01		Chassis of the Drive Shaft	
	BX0037-02		Bearing	
	BX0037-03		Retaining Ring	
38	BX0038-01		Left Brake Brance	
	BX0038-02		Ring Brake Brance	
	BX0038-03		Retaining Ring	
	BX0038-04		Brake Sheet	
39	BX0039		Chain Wheel	
40	BX0040		Cylinder	

Diagram