



JIALONG

OPERATION MANUAL

Semi-Auto Gluer Machine
Model: **BZX2800**

REV 08/26

Serial: **DX20260224-1**

US

English



Chapter 1: SAFETY

A) General	5
B) Safety Warning Labels	6

Chapter 2: MACHINE IDENTIFICATION

A) Identification Plate	12
-------------------------	----

Chapter 3: MACHINE DESCRIPTION

A) Main Machine	14
-----------------	----

Chapter 4: TECHNICAL PARAMETER

Technical Parameter Table	16
---------------------------	----

Chapter 5: INSTALLATION INSTRUCTIONS

A) General	18
B) Pre-Installation	21
C) Installation	21

Chapter 6: OPERATION AND SAFETY PRECAUTIONS

A) Operation and Safety Precautions	24
-------------------------------------	----

Chapter 7: COMPONENT ADJUSTMENT GUIDE

A) Component Adjustment Guide	26
-------------------------------	----

Chapter 8: OPERATION PANEL AND ELECTRICAL CONTROL

A) Description of the Controls on the Control Panel	29
---	----

Chapter 9: ELECTRICAL DIAGRAMS

Electrical Diagram	32
--------------------	----

Chapter 10: LAYOUT

Layout	34
--------	----

Chapter 11: MAINTENANCE

Maintenance Spare Parts	36
-------------------------	----

Chapter 12: WARRANTY CONDITIONS

Warranty Conditions	38
---------------------	----

Chapter 13: CONTACT INFORMATION

Contact Information	40
---------------------	----

Chapter 1: SAFETY

This document is aimed for the people, who, for different reasons, directly or indirectly are responsible of the machine handling. The people who interact with the machine, have different levels of training and expertise. Thus, in order to ensure a high level of security, it's necessary that the people that directly interacting with the machine, are well trained and with experienced.

The customer has to make sure that the operator is adequately qualified and trained for the tasks he performs. This manual is intended for anyone involved in the usage of the machine. As far as general safety standards are concerned, this document is directed to the machine operator and user, who are most prone to accidents, as well as people who interact directly with the machine.

A) General

1. Users are advised to carefully read this manual and follow general instructions.
2. This document is a tool necessary for the previous understanding of the **Semi-Auto Gluer Machine BZX2800** that will be used.
3. Its reading and understanding are mandatory before using the machine, as it is necessary to know all its operation, maintenance and safety aspects.
4. Correct operation shall be determined by its appropriate installation and use.
5. Any modification performed on this mechanical or electrical parts can compromise the safety parameters arranged by **JIALONG Carton Machinery**. **JIALONG Carton Machinery** declines all responsibilities such as accidents or damages caused by safety systems tampering attempts concerns.
6. It is advised to only utilize replacement parts recommended by the manufacturer. In case of detecting any shortcoming, the manufacturer must be informed to mend it.
7. Repairs for this unit as well as its periodical maintenance, should be performed by qualified professionals.
8. Before commissioning, cleaning or making any adjustments to the machine, be sure all moving parts are in standby.
9. In case of detecting any deficiency, the manufacturer must be informed in order to solve it.
10. Necessary information shall be provided to workers using the machine, as well as a specific training for its use.
11. This instruction manual shall be made available imperatively to the workers.
12. Appropriate individual protective equipments recommended by the manufacturer shall be provided to each worker. A documental record of maintenance, revisions and malfunctions of the machine shall be carried out.

B) Safety Warning Labels

It is important to know that in this document **JIALONG Carton Machinery** gathers all the information necessary to use the machine in safety conditions, it cannot however obviate them in the whole.

As a complete and capillary test on every machine always shows residual dangers, that is to say those dangers that can not be avoided or sufficiently reduced through planning and against which protections are not completely effective, **the operator must take the safety warning labels applied on the machine and the following advice into serious considerations:**

1. The Operators must memorize the exact position of control devices able to stop the machine in case of emergency.
2. The Operators must control their workmates in case they are operating in dangerous area.
3. It is forbidden to perform maintenance work on the machine before interrupting voltage, or before the starting up device of the part to be inspected or on which maintenance has to be carried out is deactivated.
4. Each foreign object placed on parts in movement such as keys, screw drivers and bolts, must be removed before machine is started up.
5. The machine's working signaling must be kept cleaned and easily legible, in particularly the warning one.
6. It is widely recommended not to remove barriers and protection devices restricting the access to the machine components.
7. Examine the efficiency of safety device periodically in order to keep the unit's reliability if required.
8. Do not use the machine until all security devices have been restored.
9. Guards and panels opened or removed in order to carry out repairs must be always closed and replaced.
10. Do not execute repairs or adjusting operations on operation parts. Whenever it is necessary to perform such operations, safety precautions must be taken in order to protect workers.
11. When an emergency occurs, press the "emergency stop switch" to cut off electrical power boxes and stop the machine action.
12. 12. Wear proper working garments, such as clothing, protective helmets and gloves.
13. Wear rubber shoes to avoid electrical shock.
14. Always follow the instructions on the warning labels attached to the equipment.
15. Never handle the switches with wet hands.
16. Before operating any switch, always confirm its position and function.

17. Before running the machine, always tidy up your work area to ensure safe working conditions.
18. Make sure there are not other people or obstacles on the protective covers or rotating parts.
19. Always enter the machine after it has completely stopped.
20. In order to protect the operator, all the driving parts of the machine are equipped with protective cover.
21. If you have noticed any unusual noise, vibration and/or electronic control system's failure, immediately stop the machine.
22. The electric part must have a good grounding protection when the machine is to be installed.
23. If the machine is not working, please check whether the power is working properly or whether the fuse has blown.
24. The working voltage must be consistent with specification.
25. In the event of the machine being used after a transfer or a long period of inactivity, it is advisable to ask for the assistance of **JIALONG Carton Machinery**.
26. In case you are not able to solve a malfunction by yourself or find yourself in difficulties, do not make risky repair attempts, please call an agent of **JIALONG Carton Machinery** of your district.

The following safety warning labels are attached to this machine. The operators and maintenance personnel must follow the safety warnings. If any of the safety warnings has come off or become unreadable, always attach a new warning label.

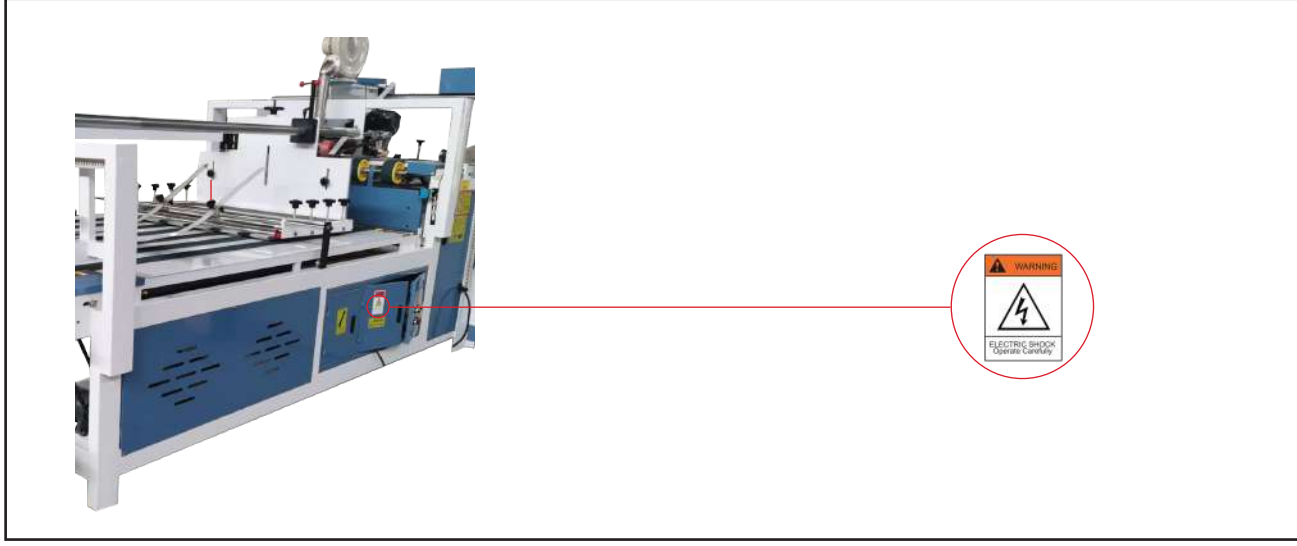
Safety Warning Labels are used on the machine and procedures on this manual, they alert the user of it's existence and relative degree of hazards, it contains important information about personal safety during operation or near the machine. Understanding safety alert symbols guarantee operator safety, review carefully following symbols.

Safety Alert Symbols

	Potentially destructive situation which if not avoided, may result in damage or reduce the longevity of the equipment.
	Potentially hazardous situation, which if not avoided, may result in minor or moderate injury. It may also be used to alert against unsafe practices.
	Potentially hazardous situation, which if not avoided, could result in death or serious injury.

Review the safety warning labels that are applied on the machine, which shows the warning positions:

	ALWAYS,keep hands away from machine when running.
	ALWAYS, turn off all power before starting maintenance or do inspection.
	ALWAYS, turn off all power before starting maintenance or do inspection.



Chapter 2: MACHINE IDENTIFICATION

A) Identification Plate



Here, after taking note of the name plate attached to our machines. Which is generally placed on the top, on the left or right side, it can be consulted by customers each time it is necessary.

The following data is reported on the name plate:

Code	Description
A	Machine Model
B	Max Cardboard Size
C	Voltage
D	Factory Number
E	Factory Date
F	Manufacturer's Data

A) Main Machine



Code	Description
1	Main Machine
2	Conveyor

Semi-Auto Gluer Machine Model BZX2800			
Electrical Requirements		Product	Semi-Auto Gluer Machine
Voltage	440V	Brand	DESSION JIALONG
Phase	3 PH	Model	BZX2800
Frequency	60 Hz	Origin	China
		Application	Gluing all kinds of corrugated cardboards single, double, and triple.
Operation Conditions		Overall Dimensions	
Operating Temperature (°C)	50°C	Length	5300 mm
Maximum Operating Temperature (°C)	50°C	Wide	2100 mm
Installation Place Room Temperature (°C)	Min 5°C Max 30°C	High	2000 mm
Relative Humidity (%)	Min 45% Max 75%	Weight	1450 Kg.
		Floor Area Requirement	
		5600 mm x 2400 mm	
Technical Specifications			
Max. size (L+W) × 2	2800mm		
Min. size (L+W) × 2	340mm		
Max. size (W+H) × 2	1515mm		
Min. size (W+H) × 2	260 mm		
Height of Feeder	1000 mm		
Max. Speed	60 Pieces/min		

A) General

The machine is usually installed by **JIALONG Carton Machinery** technicians. In case it must be removed, the operation must be performed by skilled and authorized personnel. Once they have reached the customer, our technicians begin the machine/plant loading/unloading operations. Afterwards, they must control packings are undamaged, which means, the machine has not suffered any damages caused by shocks, wrong handling or atmospheric elements.

The technician will check the integrity of the equipment also during the phases subsequent to the packing's first opening. The technician also must control the foundation's conditions and relative pre-arrangements necessary for installation; which means: the accuracy of foundations, cement quality and drilling testing on the area where the rails are going to be installed. **When apply.**

Prearrangements must be provided by: water supply distribution, compressed-air distribution, the presence of a power supply cable, and the installation of a line side isolate. The installation starts, with the installation of main tracks, using the suitable tools for subsequent levelling. When apply.

The technician concludes the mechanical assembling and checks that each part is closed down, adjusted and tightened so it can perform its final functions.

Now there is nothing left but, to supply of power to the main control panel, so it's required the customer provides an adequately electric infrastructure.

Each group of functionality at this point, is tested and it is advisable that from now on and for on, your maintenance personnel and your production manager or operator, support our technician, because, it is very useful for them, to follow functional test operations in order to know the functions of each operation, mechanisms and even the ones that in the future the operator will never have to adjust or repair.

The technician, makes sure each button of the control panel correlates to the suitable function: Start, stop, acoustic signal, pressure raising or lowering, movements, etc.

These operating mechanisms, responsible for the safety of workers assigned to the machine or plant are very carefully controlled: Stop button and alarms to signalize that photocells limiting the access are working.

According to us, the operations above mentioned must be performed with the assistance of your personnel, thereby, will become acquainted with troubleshooting problems that often occur during this phase. In order to achieve a correct professional personnel training, the technician, will perform adjusting, inspecting and working operations.

The technician will mention the dangerous maneuvering for the safety of workers. The operator must maintain a safe distance from the machine and not to stand under the fastening bands or under the machine.

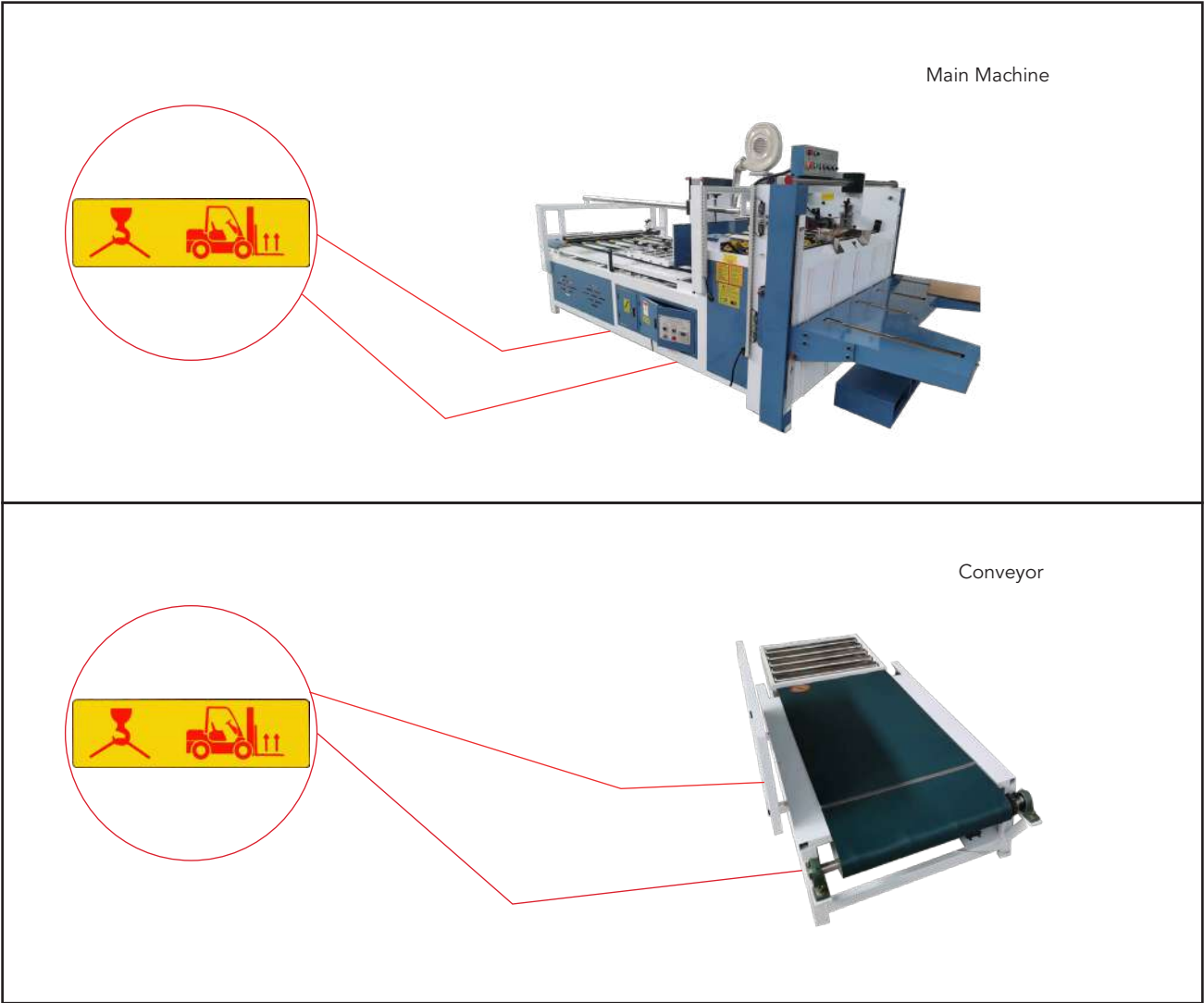
The personnel have to learn all production cycles in order to become familiar with the machine's main functions and its operating mechanism until it is self-sufficient, always under technician's control.

The technician will also simulate with personnel possible emergency conditions, in order to control that operators perfectly remember the position of stop and emergency buttons at the plant.

The machine arrives to customer's facilities, in a plywood box, handle with care and unloaded according to the following **Unloading Equipment Requirements**, the operator must keep a safe distance from the machine and not to stand under the fastening bands or under the machine.

Photo	Description	Unloading Equipment Requirements
	Main Machine	Forklift 5 Ton.
	Conveyor	Dolly

Make sure to do the unloading of the Main Module and Conveyor, from the unloading points already determined, which are located in each unit, please see the photos below.



B) Pre-Installation

- 1) Remove the plastic film.
- 2) Check each unit of the machine and in case of finding any unit damaged, take some pictures and get in touch with an agent from JIALONG Machinery Carton.

C) Installation

In order to install the **Semi-Auto Gluer Machine BZX2800**, it is not required any type of special equipment, it should be installed on a flat concrete ground.

I.- Steps for installation

- 1) Power Connection: Connect power cables to terminals A, B, C, N inside the electric box (See Figure 1)



Figure 1

- 2) Check motor rotation direction: Judge whether the motor rotates correctly by observing the running direction arrows of the gluing head, front conveyor belt and middle conveyor belt (See Figure 2 & Figure 3).



Figure 2



Figure 3

Chapter 6: OPERATION AND SAFETY PRECAUTIONS

OPERATION & SAFETY PRECAUTIONS

WARNING

The machine must be started up and used only after that service and maintenance personnel has carefully read the present manual. The entrusted personnel must have fully read and understood its contents. The firm **JIALONG Carton Machinery** declines all responsibility for each failure occurring in consequence of improper and incautious operations, not in conformity with the present manual directions, carried out by unskilled or skilled personnel.

The present instructions are directed to qualified or experienced operators. In order to avoid damaging people or things, **JIALONG Carton Machinery** recommends Customers to adequately inform operators about the risk deriving from the use of the machine. In case of the machine being used by inexperienced personnel, it is advices that qualified personnel supports inexperienced workers at using the device. The operator must always make use of their personal protection means by law and what the employer places at his disposal.

Personnel responsible for the equipment maintenance must be experienced and fitting for the kind of duties, they must show the necessary reliability in order to ensure safety and scrupulous controls and maintenance works.

A) Operation and Safety Precautions

I. Operation Steps

- 1) Fix the gluing head and adjust its height properly.
- 2) Adjust left & right baffles to align the gluing area of carton directly under the gluing roller.
- 3) Adjust the height of the red rubber roller set on the right of gluing head, do not over-tighten the rollers.
- 4) Calibrate the flattening mechanism.
- 5) Adjust middle platform baffles, feeding rollers and discharging rollers.
- 6) Switch on the main power supply.
- 7) Start front conveyor, middle conveyor, fan and gluing roller, set target production counting quantity.
- 8) Fill white glue into the gluing head to start formal production.

II. Maintenance and Safety Notes

- 1) Dismantle and clean the gluing head after every production shift. Clean gluing rollers thoroughly with a toothbrush. Lubricate gears, shafts and bearings before reassembly.
- 2) The gluing roller and gear shaft have fixed assembly orientation: align the flat surface on gear shaft with the flat notch inside gear bore. Never hammer parts during installation.
- 3) Only neutral adhesive is allowed for this machine. Acidic or alkaline glue will corrode all parts of the gluing head assembly and are prohibited.

A) Component Adjustment Guide

I. Gluing Head Adjustment

Raise Gluing Head

- 1) Loosen fixing bolts of gluing head support and height locking screw.
- 2) Rotate height adjustment screw upwards to lift the gluing head.
- 3) Tighten both fixing bolts after adjustment.

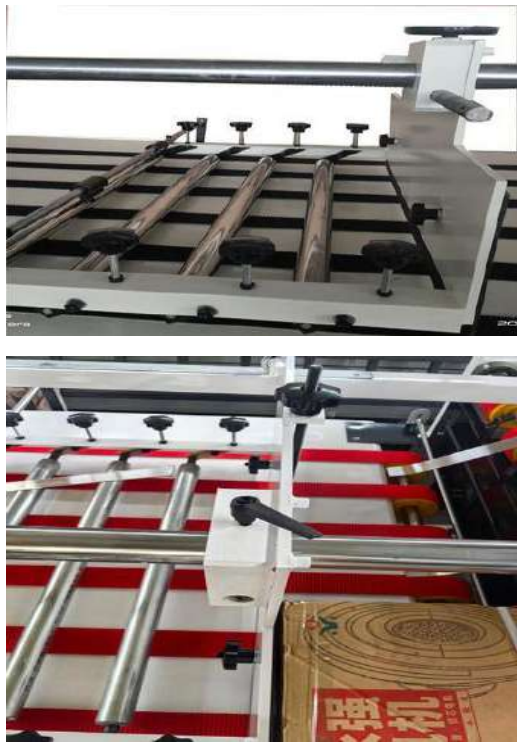
Lower Gluing Head

- 1) Loosen fixing bolts of gluing head support and height locking screw.
- 2) Rotate height adjustment screw downwards to lower the gluing head.
- 3) Tighten both fixing bolts after adjustment.

Adjust Right Non-powered Feeding Rollers

There are 5 red rubber rollers on the right side of gluing head. Adjust roller spacing as required to ensure smooth paper feeding

II. Middle Platform Mechanical Adjustment



- 1) Adjust height of middle platform baffle: Loosen black plastic locking knobs on baffles, rotate the top handwheel to reserve clearance for one carton to pass through smoothly.

- 2) Adjust flattening clearance of middle platform: Rotate the handle on sliding sleeve of baffle mount, slide the baffle forward/backward to set gap between baffle and flattening plate equal to carton total height (including top & bottom flaps), then lock the position.
- 3) Adjust feeding rollers: These rollers rely on self-weight to press carton gluing area. Set gap between rollers and conveyor belt according to carton thickness: too narrow gap will cause carton jam, excessive pressure will lead to motor burnout.



- 4) Adjust rear pressing rollers: Turn adjustment screws inside roller lifting arm to set proper pressing clearance matching carton thickness.
- 5) Adjust finished product conveyor rack: Loosen hex socket screws to slide front/rear baffles according to carton size, lock screws after adjustment.
- 6) Adjust middle platform photoelectric sensor & counting sensor: The optimal sensing distance of middle platform sensor is 2/3 of machine width; adjust counting sensor above upper pressing roller to stably detect paperboard, sensing sensitivity is adjustable.



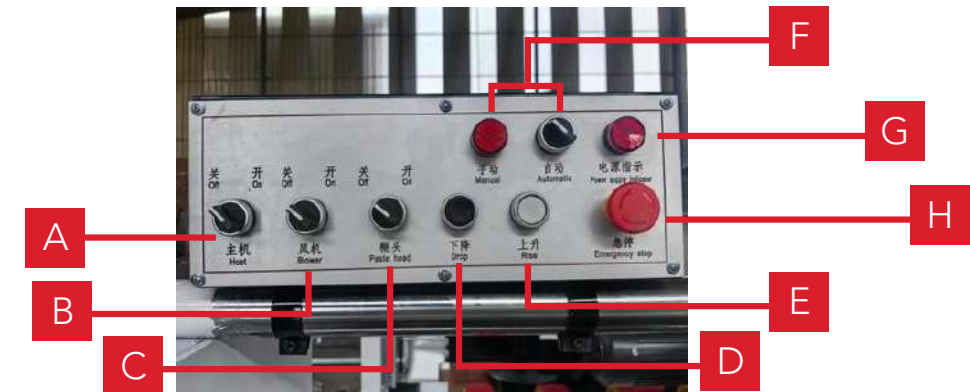
OPERATION PANEL AND ELECTRICAL CONTROL

Chapter 8: AND ELECTRICAL CONTROL

OPERATION PANEL AND ELECTRICAL CONTROL

A) Description of the Controls on the Control Panel

I. First control panel



Code	Description
A	Host: Off/On
B	Blower: Off/On
C	Paste head: Off/On
D	Drop
E	Rise
F	Manual/Automatic
G	Power supply indicator
H	Emergency stop

II. Second Operation Panel

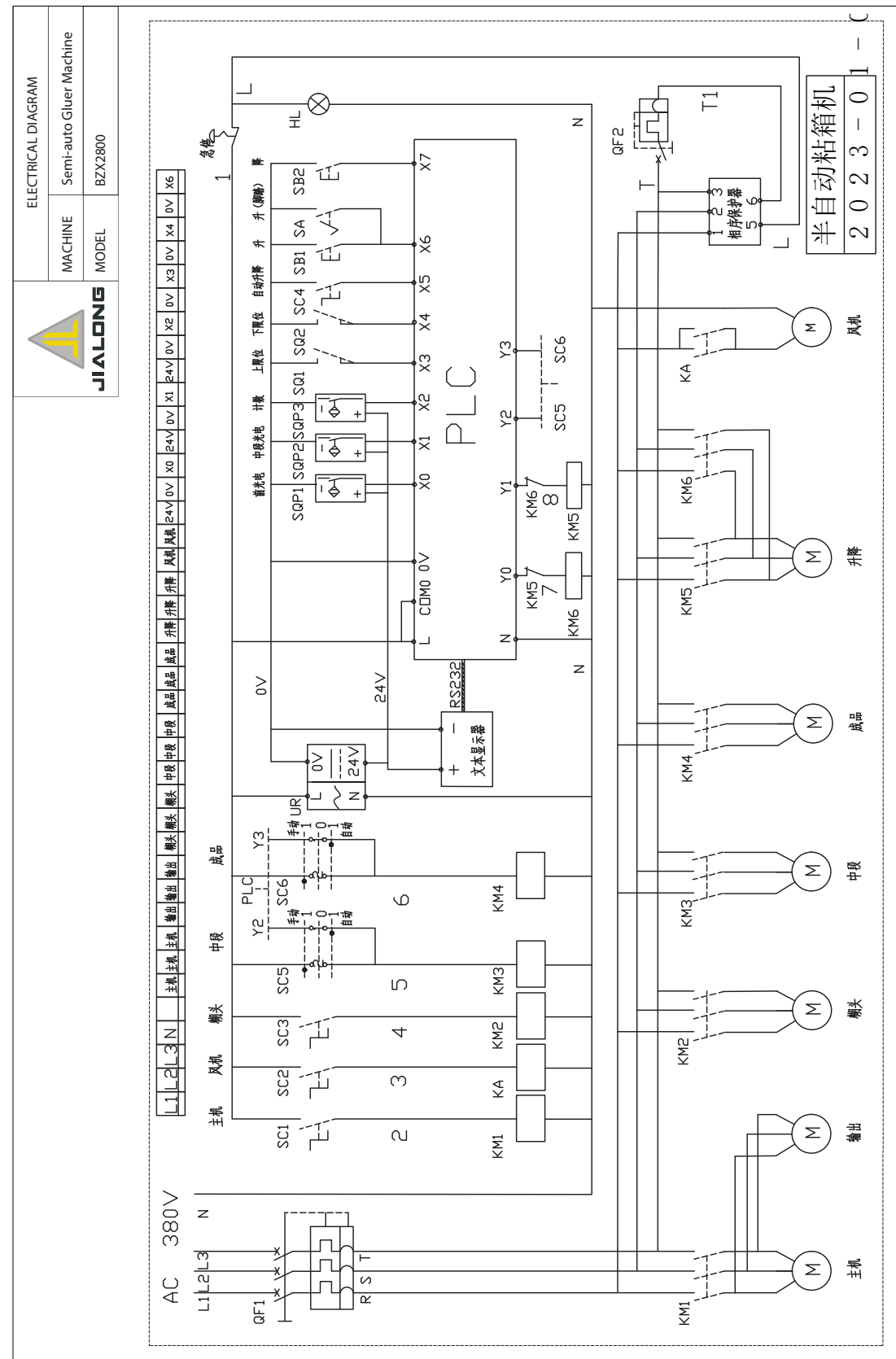


Code	Description
A	Middleground Transport
B	Finished Product
C	Power Switch
D	Power Indicator
E	Finished Enacement

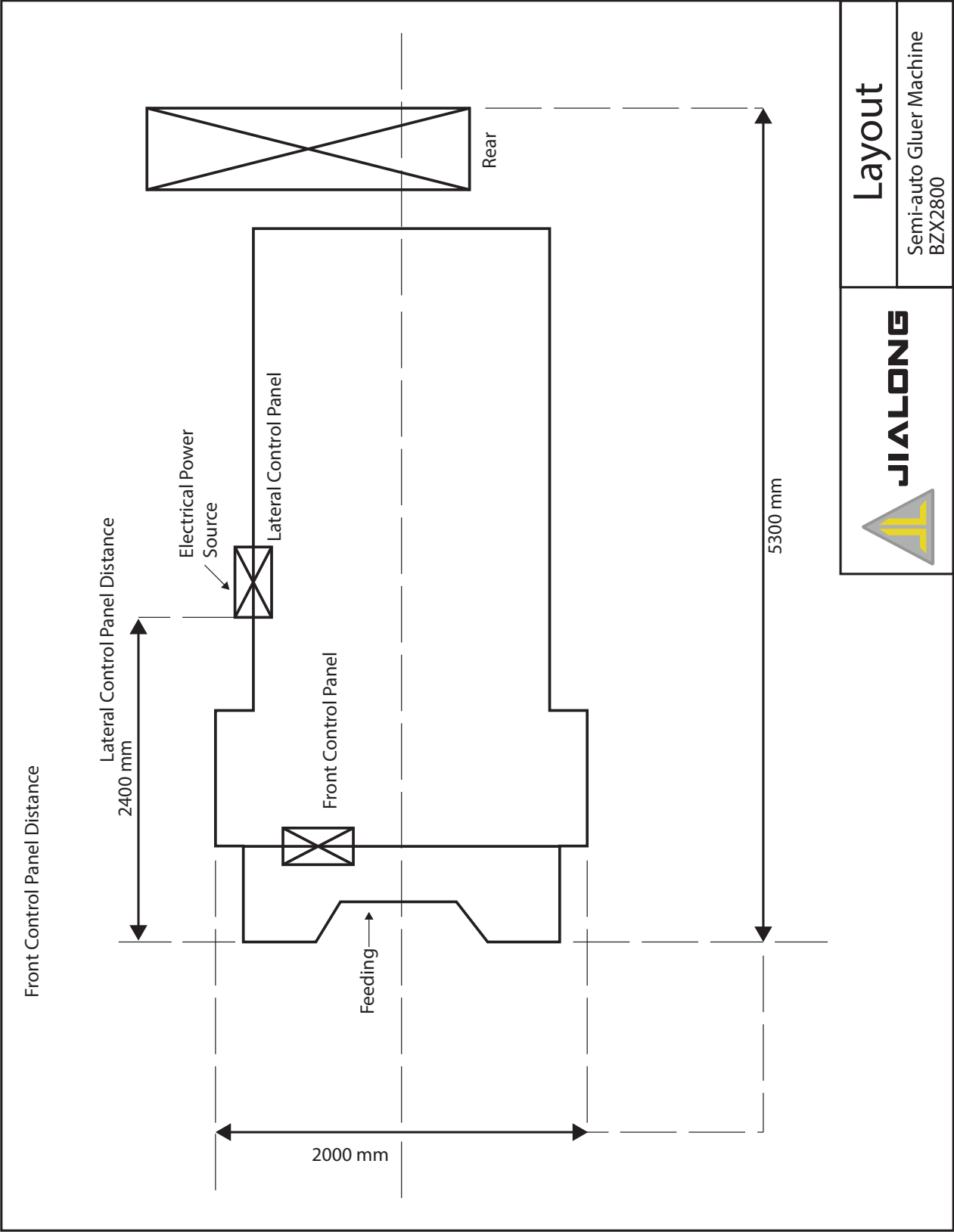
III. Interior of the Electrical Control Cabinet

The electrical control cabinet integrates all machine contactors, circuit breakers, relays, and terminal blocks in a centralized installation. All wiring is color-coded in accordance with standard electrical practices.





Layout



Chapter 11: MAINTENANCE

A) Maintenance Spare Parts

- I. All the oil cups and moving parts must be replenished with lubricating oil frequently. This should be done not less than two or three times during each shift.
- II. Pay constant attention to the movement of the machine. If anything seems to be unusual, stop the machine immediately for examining.
- III. Keep the machine clean.
- IV. Make sure the machine undergoes a thorough overhaul every year.

Spare Parts List

Piece name	Code's name	Quantity	Notes
Gluing Head	SP-001-BZX2800	1	For Semi-Auto Gluer Machine BZX2800
Gear Shaft	SP-002-BZX2800	1	For Semi-Auto Gluer Machine BZX2800
Glue Wheel	SP-003-BZX2800	1	For Semi-Auto Gluer Machine BZX2800
Sensor	SP-004-BZX2800	1	For Semi-Auto Gluer Machine BZX2800
Glue Doctor Block	SP-005-BZX2800	1	For Semi-Auto Gluer Machine BZX2800
Bushing	SP-006-BZX2800	1	For Semi-Auto Gluer Machine BZX2800

1. **JIALONG Carton Machinery** warrants that the equipment is guaranteed to be free from defects in material and workmanship at time of shipment. If during the first year of the date of shipment, the buyer establishes to the seller's satisfaction that any parts manufactured by **JIALONG Carton Machinery** were defective at the time of shipment, **JIALONG Carton Machinery** will, at its own expense, repair or replace (but not install) replacement parts.

Sellers liability under this warranty is limited to replacement parts only and the seller will make no allowance for corrective work to be done unless agreed to by the seller in writing. Charges for correction of defects by others will not be acceptable, unless authorized in writing, prior to the work being performed, by an officer of the company.

Damage caused by deterioration due to extraordinary wear, improper maintenance or lubrication and improper storage prior to installation, shall not be taken as manufacturing defects. Failure to install equipment properly shall not be taken as manufacturing defects. Warranty does not cover consumable items. Warranty does not cover adjustment to installation or periodic adjustment that may be required during normal operation.

2. The term of guarantee is equal to 12 (twelve) months from the date when the installation and commissioning of the equipment fulfilled. Within one year from the date of accomplishing the installation and commissioning of the equipment fulfilled (don't guarantee the serving life of the wearing parts).

Within the period of quality guarantee, in case of any defects or malfunctions of mechanical parts, which have been proven to be caused by seller's poor materials and assembly technology, upon receipt of the buyer's information in writing and photos, the seller will post spare parts which were mentioned by the buyer as soon as possible at its own cost and the spare parts should be installed by the buyer. The expense of the spare parts and the freight will be borne by the buyer.

3. The following components are not covered by the warranty;
a. The repair, service and/or installation of any electric component or related replacement part for use with the equipment.
b. The consumables, that are parts that have limited life expectancy and are designed to be replaced.

4. **JIALONG Carton Machinery** has made no representation, warranties, or guarantees, expressed or implied, not expressly set forth on above paragraph. **JIALONG Carton Machinery** shall not be liable hereunder for any consequential damages, losses of profit, loss of production, or contract, financial, economic or any other indirect loss or consequential damage that in any form could suffer the other party.

5. No representative of **JIALONG Carton Machinery** has been conferred with any authority to waive, alter, vary or add to the terms of the warranty state herein, without prior authorization in writing executed by an officer of the company.



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