

User's Manual

Automatic Clothes Folding & Packing Machine

Model: FPS-FA(heat-cut sealing)

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● Preface

Thank you for choosing a FPS-FA Automatic clothes folding and packing machine. The FPS-FA adopt platen-folding mode to realize the whole folding and packing process automatically and with high quality. Spray paint parts make its appearance generous, neat and durable. It features compact body and low power consumption , which can adapt to various environments.

It is suitable for the folding and packaging process of large quantity knitting, T-shirt, polo shirt, thermal underwear, thin coat, etc. It realizes folding and packing automatically. Both folding width and length are adjustable. Highly automatic design make it's easy to operate; there's no professional technical requirements for the operator. Imported electrical parts which ensure trouble - free operation and easy maintenance. Environment protection material and the smooth material which avoid the damage of clothes. Adopt touch screen to set and adjust working parameters and modes. Machine production capacity is about 300-500pcs per hour. It's easy to realize 24-hour non-stop work.

Notes on this Manual

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(2) The product specifications and other information in this manual are subject to

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(3) While every effort has been made to provide complete and accurate information, please contact your sales representative or nearest HUAPU vendor if you find any unclear or erroneous information or wish to make other comments or suggestions.

● **Caution about safety in use**

Attention:

Please read the warning carefully and run the machine safely.

1. Don't stand nearby when the machine is hoisted to avoid injury or damage.
2. Circuit wiring must be performed by a professional.
3. Don't use the machine in a potential explosion environment.
4. Make sure that the power supply of machine is properly grounded to avoid electric shock and fire.
5. Choose a convenient place for machine's operation, loading and unloading. The space between machine and surroundings should not be less than 80 cm for maintenance and repair.
6. Install the machine in a flat ground; use rubber pad under the base if there is a source of vibration to prevent the impact on the work of the machine.
7. Calibration level is required during the installation.
8. Wiring should be performed after installation and adjustment of the machine.
9. Check the voltage, current, and frequency applied to both ends before using the machine, otherwise it may cause a fire, shock or damage of machine.

10. Use special tools for installation and wiring.
11. Connect the air pipe according to requirements.
12. Stop running machine once there's any abnormal situation(smoke, burning smell, strange noise), otherwise it may cause a fire or shock. Disconnect power immediately and resolve the problem.
13. The machine must be operated by trained operators.
14. Lock the control cabinet door before turning on the power switch. Keep it shut during the working process.
15. Do not use wet hands to operate various electrical switches, buttons, touch screen to avoid to be shocked. Handling faults or cleaning equipment must be power off!
16. Live maintenance must be done by professionals!
17. Operator should pay attention to the running of machine. Don't leave without permission.
18. Press emergency stop button and turn off the power if there's any emergency happens.
19. No violence handling when checking the failure to avoid the damage of machine.
20. Check and fasten the screw of each terminal regularly.
21. Check the mechanical parts, lubrication parts and quick-wear part regularly.
22. Don't modify any key parts of the machine to avoid accident and potential dangerous.

● Installation

Machine specification

Over size: : 3480MMX910MMX1200MM (L*W*H)

Working space: 5500MMX1900MMX2000MM

Power supply: 500W, 100V-240V, 50/60HZ (provide grounded AC)

Air supply: Not less than 0.6MPA (main air inlet)

Requirement of installation

Provide not less than 500W, 100V-240V (50/60HZ) grounded AC Power supply

Provide not less than 4.5KW air pump, not less than 0.3M³ air tank, not less than 0.6MPA air inlet and PU hose (inner diameter 10MM).

Environment: Run it on a flat ground at normal temperature and pressure. Don't use it in bad condition to avoid machine damage and reduction in service life.

Transport of machine

Provide forklift (at least 500KG load) to carry the machine. The Min. height of forklift arm should be within 10cm, the length should not be less than 100cm.

Carry near the position of electric cabinet when lift main down box to avoid unbalance of machine.

Gently lift the machine to avoid the damage of precision parts such as weighing sensor.

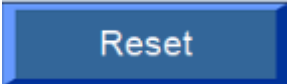
Casters under the machine enable operator to push it.

Detachable structure enable it enter the standard cargo elevator.

- **Parts of machine**

- **Touchscreen instruction**

- 1. Reset page:**

Turn on the power supply, enter the reset page. Click the  to enter system.



- 2. Loading page:**

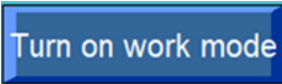
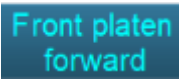
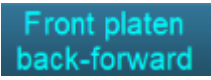
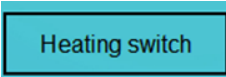
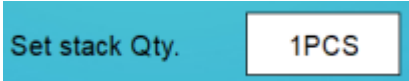
After the system loaded well, click anywhere on the screen, to enter work page.

- 3. Work Page**

The screenshot shows a control interface with a top navigation bar containing a home icon and four menu items: Manual Adjust, Folding Setting, Function settings, and Sealing settings. The main area is divided into several sections:

- Left Panel:** Contains buttons for 'Turn on work mode', 'Front platen forward', and 'Front platen back-forward'. Below these are a 'Heating switch' (set to OFF), a 'setting temperature' field (150.0°C), and a 'Current temperature' field (0.0°C).
- Right Panel:** Contains a table for alarm descriptions, 'Daily output' (0PCS), and 'Total output' (0PCS).
- Bottom Panel:** Contains a 'Reset' button, a 'Set stacking Qty.' field (1PCS), and a 'Set stack Qty.' field (1PCS).

Time	Alarm description
11:31:37	PLC-1 connection error

- ❖ 1. Click  to enter the Menu page.
- ❖ 2. Click  to start to work.
- ❖ 3. Click  to make the front platen move forward;
- ❖ 4. Click  to make the front platen move backward;
- ❖ 5. Turn on  OFF, set the temperature. **Remark: The heating temperature for plastic bags varies with the material. Please adjust accordingly based on the actual situation.**
- ❖ 6. Input the stack Qty  to enable machine to pack multiple pieces in one bag.
- ❖ 7. Alarm description: This area displays the real-time alarm record. Worker can solve the problem based on the alarm description.

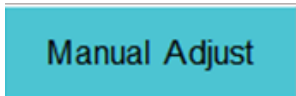
Time	Alarm description
10:13:20	PLC.1 link error

- ❖ 8. Output: This area displays the real-time daily output and total output.

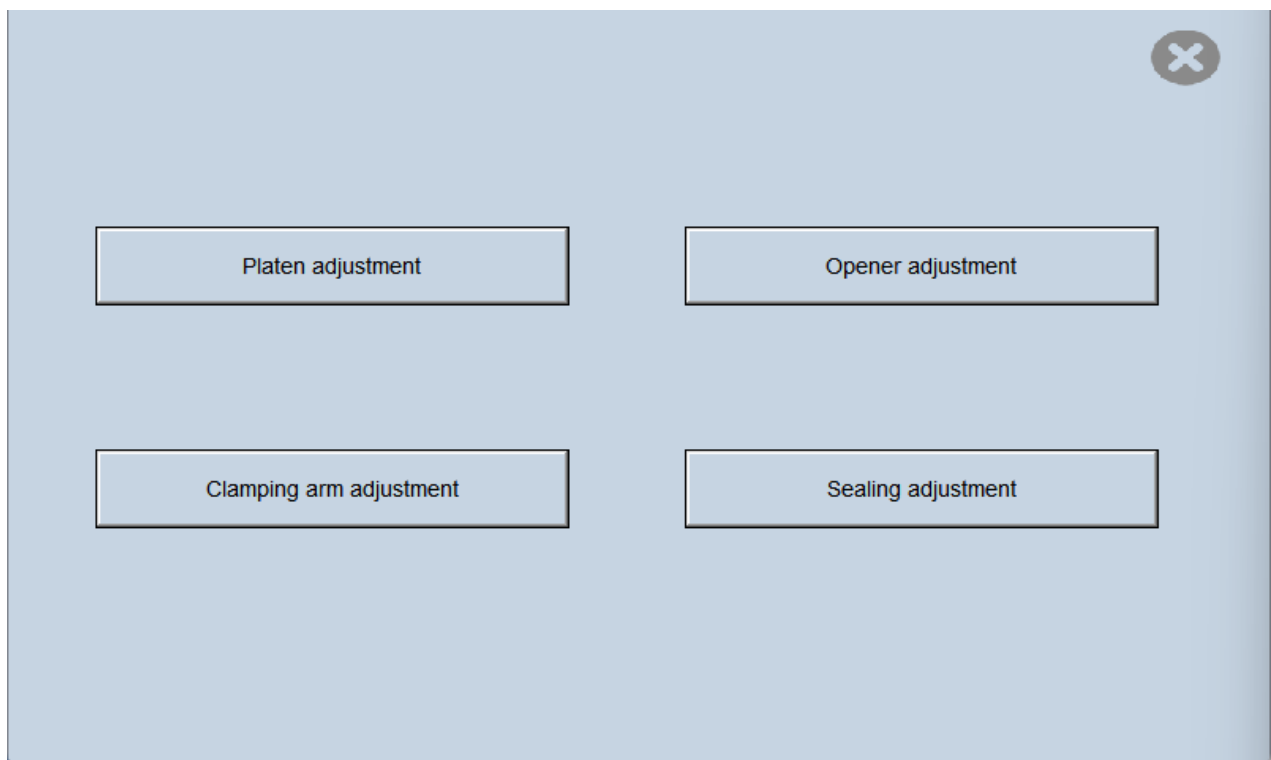
Click the number to clear the counter.

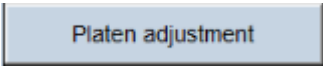
Daily output	0PCS
Total output	0PCS

- ❖ 9. Click , machine will return to initial state.

- ❖ 10. Click  to enter Manual Mode page.

4. Manual Mode

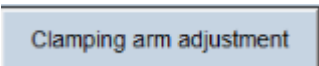


❖ 1. Click  to enter the Platen adjustment page.

Click  for a while, machine will be restored to factory settings.

User turn on/off the certain function by click the  button.

Data Initialization 			
Name/Function	ON/OFF state	Parameter	Delay time
Left platen		2.0S	0.2S
Right platen		2.0S	0.2S
Front platen work		2.0S	0.3S
End platen		2.0S	0.3S
Open-shut platen		0.5S	0.1S
Positioning pin up & down		0.3S	0.5S
Positioning pin left & right		0.3S	

❖ 2. Click  to enter the clamping arm adjustment page.

Data Initialization ✕			
Name/Function	ON/OFF state	Parameter	Distance parameter
Clamping arm backward	OFF	600.0mm/s	0.0mm
Clamping arm forward	OFF	600.0mm/s	570.0mm
Upper clamping arm	OFF	0.7S	
Lower clamping arm	OFF	0.5S	
Clamping arm rotate	OFF		
Open-shut platen	OFF		
One-key adjust clamping arms	OFF		

Click **Data Initialization** for a while, machine will be restored to factory settings.

User turn on/off the certain function by click the **OFF** button.

- ❖ 3. Click **Open bag adjustment** to enter the open-bag adjustment page.

Data Initialization ✕					
Name/Function	ON/OFF state	Parameter	Name/Function	ON/OFF state	Parameter
Opener up & down	OFF	0.7S	Conveyor-1 moving cylinder	OFF	1.2S
Opener arm	OFF	0.6S	Conveyor-1 pressing cylinder	OFF	0.5S
Iron bag holder	OFF	0.4S	Conveyer 1 motor	OFF	500.0mm/s
Opener auxiliary claws	OFF		Switch the button function	OFF	
Opener blower	OFF	1.0S			
Suction cup up & down	OFF	0.5S	Open-shut platen	OFF	
Suction adhesion	OFF	0.4S	One-key open bag	OFF	

Click **Data Initialization** for a while, machine will be restored to factory settings.

User turn on/off the certain function by click the **OFF** button.

❖ 4. Click **Sealing adjustment** to enter the sealing adjustment page.

Click **Data Initialization** for a while, machine will be restored to factory settings.

User turn on/off the certain function by click the **OFF** button.

Data Initialization

Name/Function	ON/OFF state	Parameter	Name/Function	ON/OFF state	Parameter
Conveyor-1 backward	OFF	0.5S	Sealing pressing board	OFF	0.5S
Heat-cut backing plate	OFF	0.5S	Blower 1	OFF	1.5S
Heat-cut front pressing plate	OFF	0.5S	Detection plate	OFF	
Heat-cut blade					
			Conveyer motor 2	OFF	500.0mm/s
Heat-cut sealing time		0.3S	Exit speed from the conveyer		800.0mm/s
Cooling time		0.5S	Transport distance after		800.0mm

5. Folding Setting

Normal fold

Reversed fold

Big size clothes

Small size clothes

Tops

Bottoms

Pack thick clothes into bag

OFF

Current stacking Qty. 0

Set stacking Qty. 1PCS



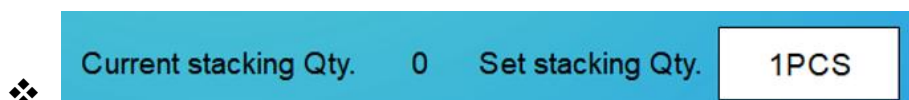
❖ “Normal fold”, user should put the t-shirt collar on the front platen and the folded t-shirt collar in the bottom of bag; “Reversed fold”, user should put the t-shirt collar on the end platen and the folded t-shirt collar in the top of bag.



❖ “Big size clothes”, the end platen work; “Small size clothes”, the end platen doesn't work.



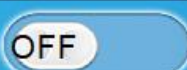
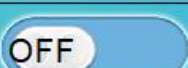
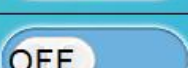
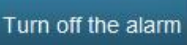
❖ Choose “bottoms”, then user can choose . In such case, the other side platen doesn't work.



❖ Show how many pieces will be packed in one bag and how many pieces are stacked.

6. Function settings



Positioning pin		No packing	
Bags detection		No sealing	
Successful open-bag detection		Press bag again	
Suit mode			
Pack without folding		Sealing motor detect	
Pause for tidy up			
Suction cup open bag		0.4S	

The above table shows the time of each action.

Remark: All above data is factory setting for your reference. You may change them according to your specific requirements.

7. Sealing settings



Current parameter	setting temperature	Heat-cut sealing time	Distance compensation for sealing	Bag length	
	150.0°C	0.3S	60.0mm	400.0mm	
Clothes style					
	0.0°C	0.0S	0.0mm	0.0mm	Read style
	0.0°C	0.0S	0.0mm	0.0mm	Read style
	0.0°C	0.0S	0.0mm	0.0mm	Read style
	0.0°C	0.0S	0.0mm	0.0mm	Read style
	0.0°C	0.0S	0.0mm	0.0mm	Read style

setting temperature

Set the temperature. **Remark: The heating temperature for plastic bags varies with the material. Please adjust accordingly based on the actual situation.**

Heat-cut sealing time

Set the heat-cut blade sealing time.

Distance compensation for sealing

Distance compensation for sealing is the distance between the heat-cut blade and the sensor. User can make the heat-cut blade fall down at the proper position by adjusting this parameter.

Bag length

Bag length is the length of bag currently used on the machine.

Clothes style				
	0.0mm	0.0mm	0.0mm	Read style
	0.0mm	0.0mm	0.0mm	Read style
	0.0mm	0.0mm	0.0mm	Read style
	0.0mm	0.0mm	0.0mm	Read style
	0.0mm	0.0mm	0.0mm	Read style

User can set five different styles sealing parameter and click **Read style** to use certain set of parameters.

8. Main page

❖ Click  to enter the Main page.

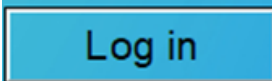


❖ 1. Choose language :



❖ 2. Check the Serial number of machines, such as

NO. FPS-PR2025040101.S1.00

❖ 3.  to log in as an administrator to enter the administrator page.

❖ 4. The administrator page can change the necessary parameters and passwords of the machine. (You need to obtain administrator rights to enter the operation, please contact the manufacturer or your buyer to obtain administrator rights.)

● Frequent Questions and Answers

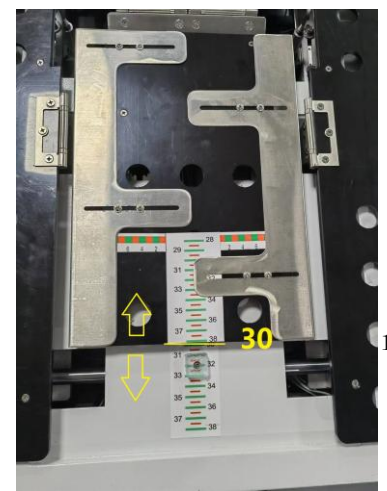
Question 1. *How do you adjust the folded width and length?*



①Please move the front platen by click the “front platen forward” or “front

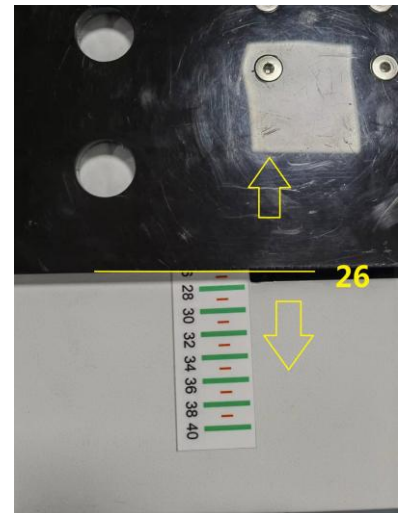
platen backward” on work page on touch screen.

②The bottom of front platen reaches the number on

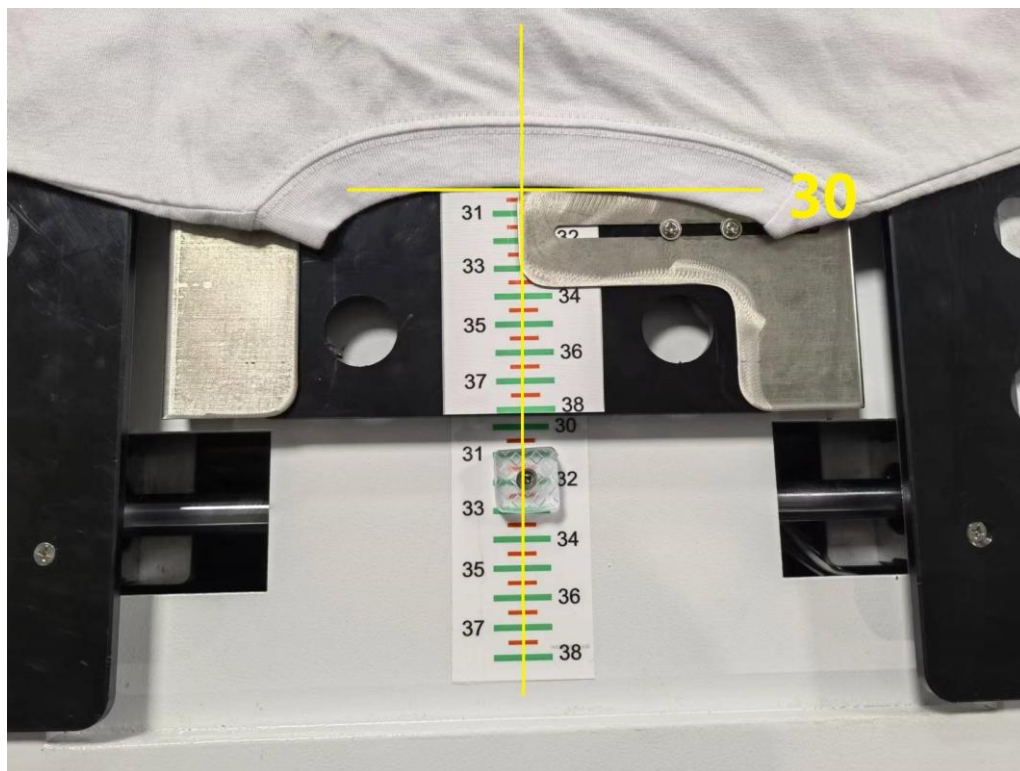


the scale is the folded length.

③On the right side there is another scale near the handle. Clockwise handles, the folded width turn bigger. The edge of right platen reaches the number on the scale is the folded width.

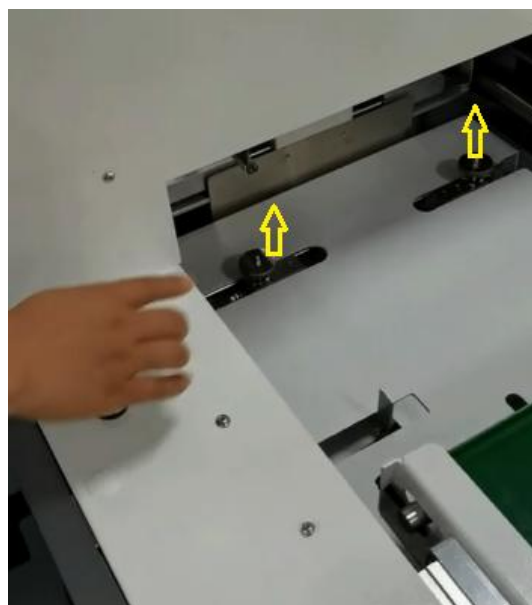
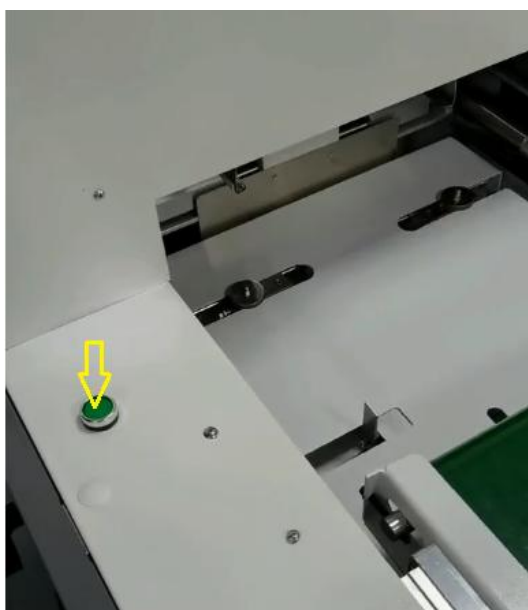


④When you put the T-shirt, please keep the center align the center scale and the collar bottom align the scale of the folded length.



Question 2. How do you load bags?

① Press the green button, make the pressing block up



② Clockwise the handle, make the width bigger



③ Put the plastic bags in the loading position

④ Counter-clockwise the handle until the bags in proper position.



⑤ Press the green button, make the pressing block down.

