High Speed Bag Closer Machine

User Manual



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1.Introduction

Moonshan portable bag closer machine has obtained the national patent. This high-speed bag closer machine series can be applied for almost all of the kinds of packaging bags. For customers who have the need of packing a lot of bags, this high speed bag closer machine series is a suitable choice.

2.Feature

The Moonshan portable bag closer machine is simple, rational, durable, wearable, stable, durable and light. It can be used for thick material and thin material. The handle is insulated to ensure safety during operation. Automatic cutting thread function benefits much more convenient operation. Low noise creates a more comfortable working environment.

3.Specification

Stitch: Single thread
Needle: 230#
Thread: 21 yarn 2X3 polyester thread
Sewing speed: 1800-2600 stitches/minute
Motor: A. 110Volt, 190W, 15000-16000Rpm
B.36Volt, 190W, 12000-15000Rpm
C.220-230Volt, 190W, 18000-22000 Rpm
Dimension: 10x3x10 inches
Weight: 6.5 Lbs

4.Safety Warning

I.Unplug the bag closer machine before maintenance.
II.Your power supply(Voltage) should be the same with that of the bag closer machine.
III.Make sure the power cord is grounded nicely.
IV.Make sure the heat dissipation holes of the machine is not covered or stuffed.
V.DO NOT use hard tool hit bag closer machine.
VI.Let personnel who has learned how to maintain to regularly maintain the machine.
VII.DO NOT put machine in wet environment to protect the machine from moisture.

5.Maintenance

I.Installation of needle: lift the needle to maximum height, loosen the fastening screws, pull out and replace the needle, ensures the needle to be stopped in needle bar hole and the notch plane of needle faces inward, then fasten the fixing screw. **(Fig. 6-2)**
II.Crochet adjustment: lift the feed dog up to its highest point, open hex screw B, then incline outside and draw upward the needle head. **(Fig. 7-3, 7-4)**
(3) Threading: **(Fig. 3-1)**
(4) Adjustment of stitch tension: rotate stitch tension nut clockwise to tighten the stitch and turn anti-clockwise to loose the stitch. **(Fig. 6-1)**
(5)Adjustment of pressing force: rotate the screw clockwise to increase the pressing force, and rotate anticlockwise to decrease, it is suggested to properly reduce the pressing force without effecting feeding effects, so as to lighten electric load and elements wearing.**(Fig. 6-3)**

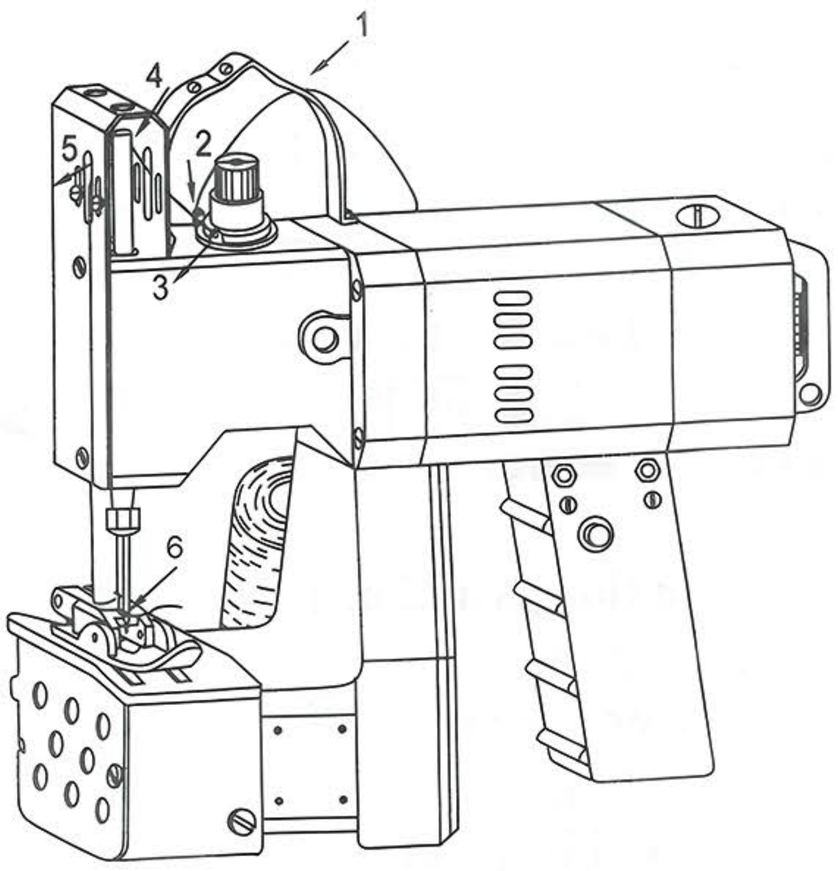


Fig. 3-1 Threading the machine

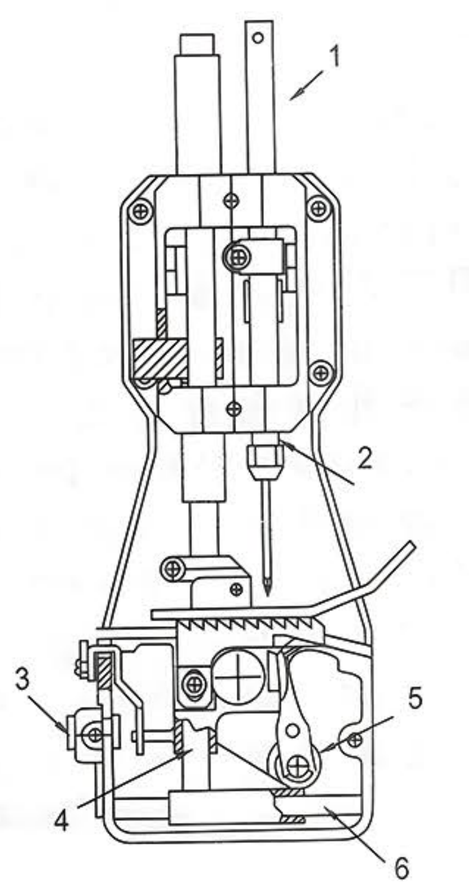


Fig. 3-2 Oil the machine

6.Stitch Tension Adjustment & Pressing Force Adjustment

Adjustment of stitch tension: Rotate stitch tension nut clockwise to tighten the stitch and turn anti-clockwise to loose the stitch.

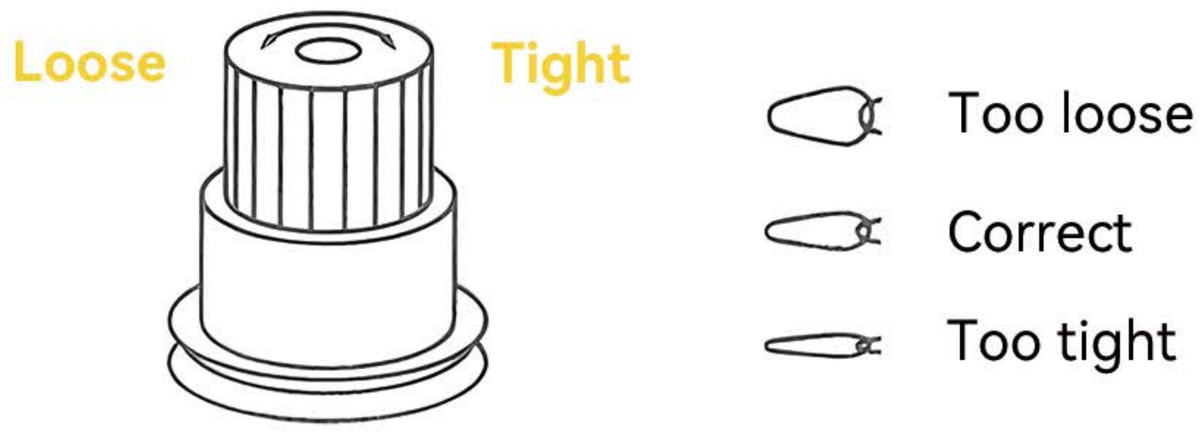
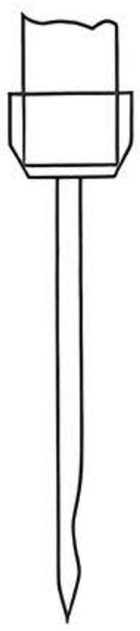


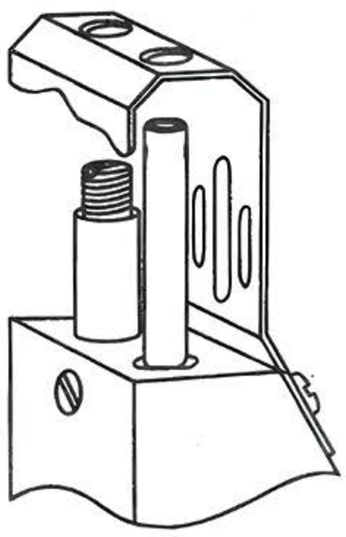
Fig. 6-1



Needle installation： Needle installation: raise the needle to the highest position, pull out the needle and replace it with a new one, make the end of the needle touch the bottom of the needle bar hole, and the needle slot should be facing the front, then tighten the screw.

Fig. 6-2

Loose ⟲ Tight



Adjustment of pressing force: rotate the screw clockwise to increase the pressing force, and rotate anticlockwise to decrease, it is suggested to properly reduce the pressing force without effecting feeding effects, so as to lighten electric load and elements wearing.

Fig. 6-3

7.Correct Position of Needle and Crochet

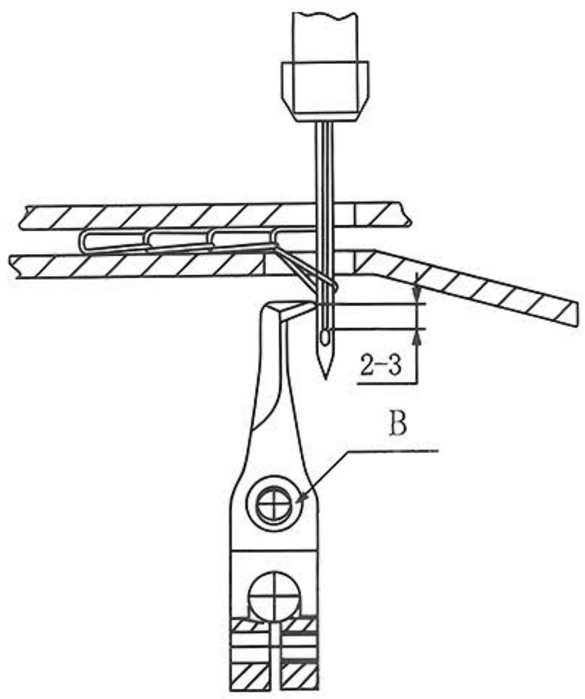


Fig. 7-1
During repair, please check whether the crochet and the upper edge of the straight needle hole are within the range of 2-3 mm, as shown in the figure. If not, it is necessary to adjust the depth of the crochet. (See Screw B in the Fig.)

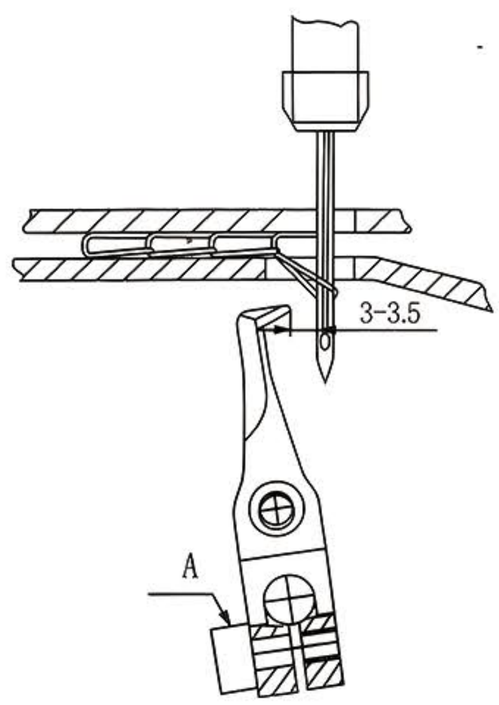


Fig. 7-2
When the needle descends to the lowest point, the distance between the crochet tip and the edge of the straight needle should be within 3-3.5, or screw A should be loosened for adjustment.

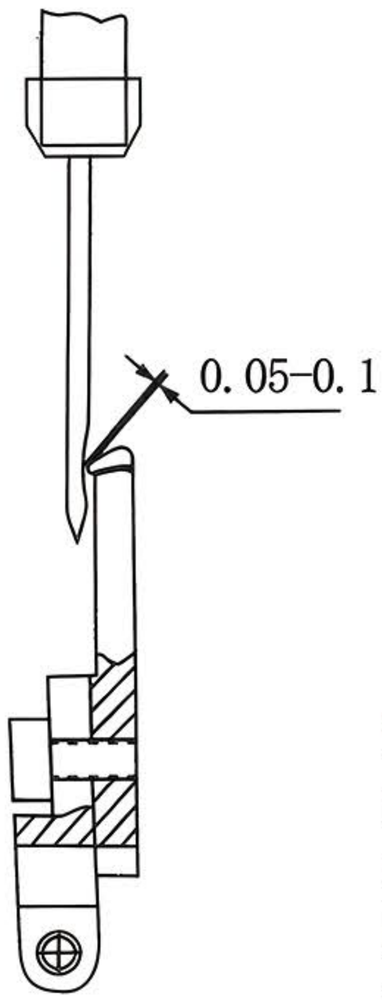


Fig. 7-3
needle groove, the clearance should be within 0.05-0.15 mm.

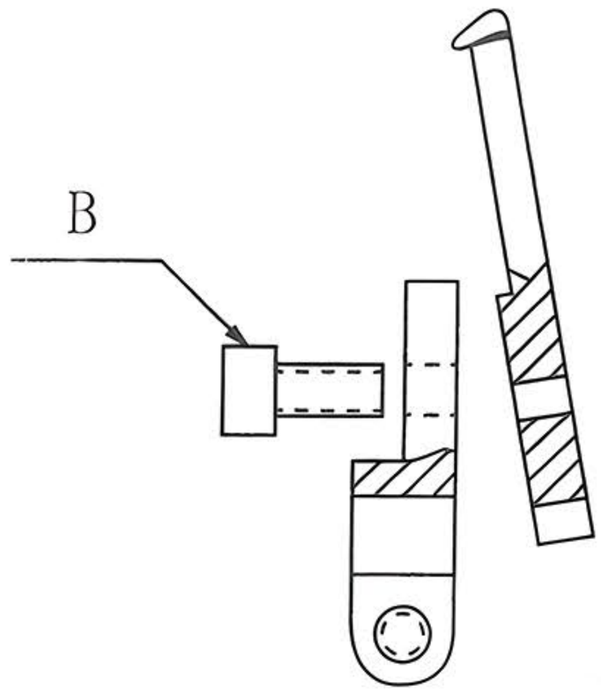


Fig. 7-4
Change the crochet: raise the feeding dog to the highest point, loosen the hexagonal screw B, then tilt the needle outward (as shown in the figure) and pull it upwards.

8.Lithium Battery Version Bag Closer Machine

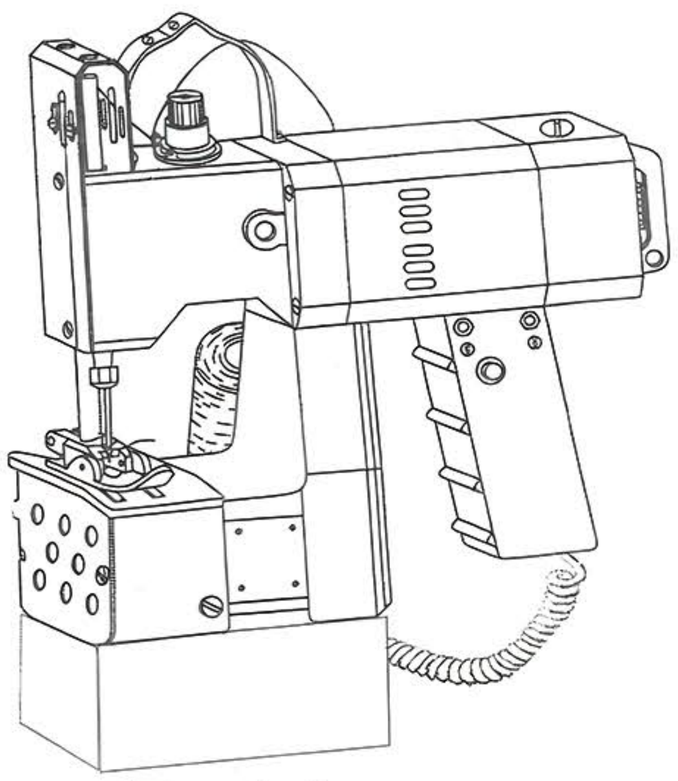


Fig. 8-1

I.Transportation requirements: the battery shall be packed in boxes for transportation, and during transportation. Prevent violent vibration, impact or extrusion, sunshine and rain. Vehicles such as cars, trains, ships and planes can be used for transportation.
II.Use requirements: in order to give full play to the battery performance, please charge the battery for more than 5 hours with the matching charger for the first use. When the battery indicator light is red, it is needed to charge again.
III.Storage requirements:
A.The battery shall be stored in a clean, dry and ventilated room with an ambient temperature of 23°F~95°F and a relative humidity of no more than 75%. The battery shall not be exposed to corrosive substances, and keep away from fire and heat sources.
B.The battery must be stored in a semi charged state. If the storage time is more than three months, the battery must be recharged (storage in a discharged state is strictly prohibited).
C.In case of any doubt about the battery during use, please contact our sales personnel or technicians in time, and we will reply in time.

Safety regulations

I.When charging the battery, please use the special charger for lithium ion battery and connect it with the special equipment correctly.
II.Do not disassemble or damage the battery; Do not weld directly on the battery.
III.Do not short-circuit the battery. Do not wet the battery, and do not put the battery into water.
IV.It is prohibited to heat and burn batteries, and use batteries near high temperature heat sources or in high temperature environments (above 176°F).
V.It is strictly prohibited to connect the battery directly to the power socket and to mix it with other batteries.
VI.It is strictly forbidden to use abnormal batteries (with peculiar smell, deformation, discoloration or distortion)
VII.Do not use the battery with other devices.
VIII.The battery charging site shall be guarded by a specially assigned person, away from inflammables, and equipped with fire-fighting devices.

9.Troubleshooting

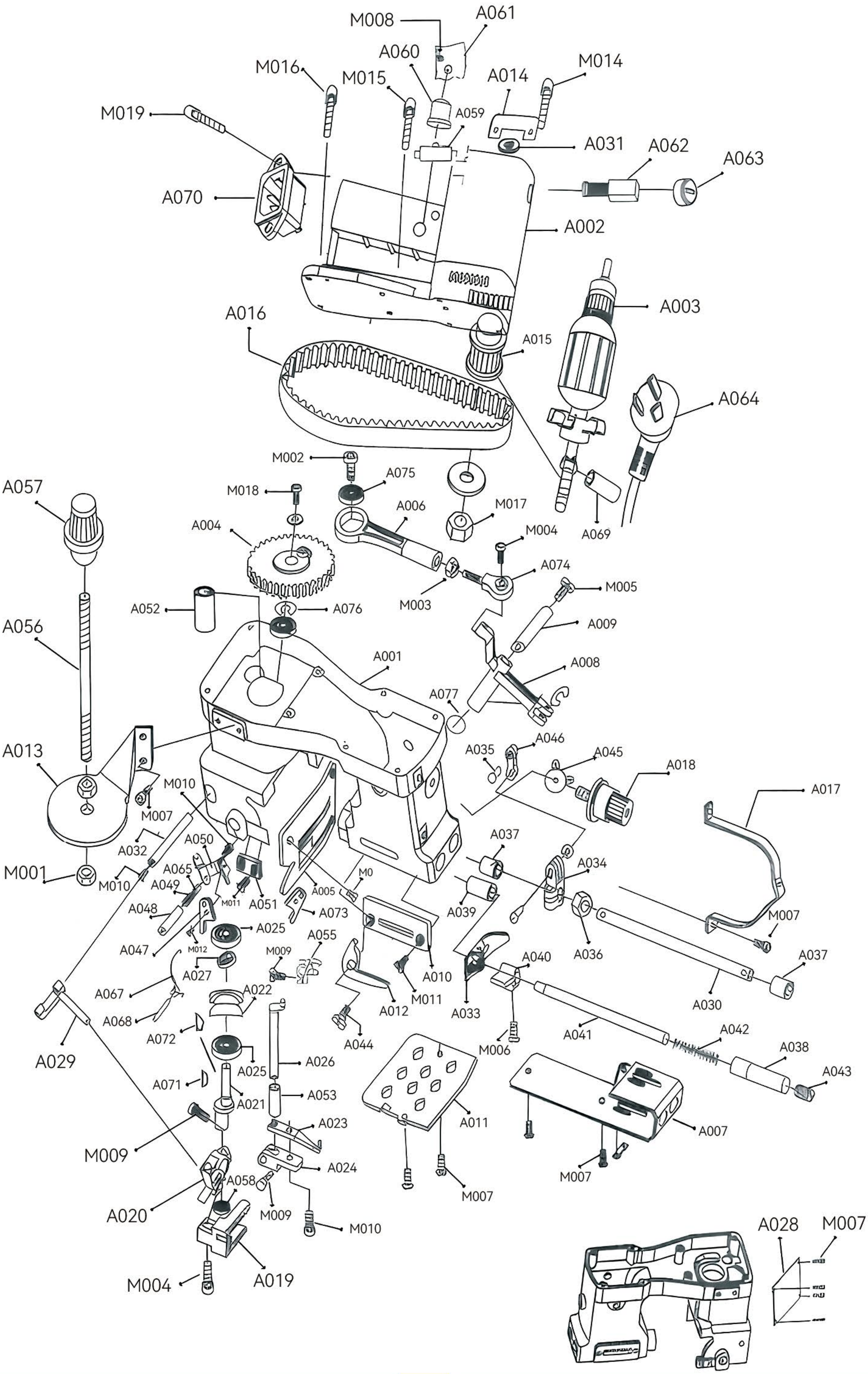
Issue	Detail	Cause	Solution
Needle broken	Bag is too thick	Needle tip deflection or bending	Replace the needle
Skip stitch	Needle touches presser foot or crochet	Presser guide holder or presser foot or crochet screw loosen	Check it and fix it
	The needle does not pass through the crochet coil	The needle is too high, and the needle action is relatively delayed when going down	Adjust the needle according to the instruction
	The crochet doesn't hook the thread	The gap between the crochet and the needle notch plane is too large	Adjust the needle according to the instruction
		The needle is too high, and the crochet action is relatively delayed when going down	
	Occasionally skip stitches when quickly sewing thick material	The needle notch plane is inclined Stitch tension is not stable	Adjust needle notch plane Replace better thread

Thread broken	Thread ends are stripped	The needle eye is not smooth	Replace the needle
	The end thread is very rough	Surface of needle plate hole and crochet head is rough	Grind with gauze
	Thread ends are cut	The needle eye is rough and the presser foot is too tight	Check and adjust
		Thread take-up lever is too high	
Others	Feeding is not smooth	The presser foot surface is not smooth, the feeding dog tip is not sharp, and the lifting height of the feeding dog is not enough	Replace the presser foot, replace the feed dog, and raise the feed dog height
	The end is not smooth	Uneven contact between feed dog and presser foot bottom	Adjust/polish the bottom of the presser foot
Motor	Motor won't rotate	Check whether the carbon brush for wear	Replace the carbon brush
	Motor does not rotate or rotates too quickly	Poor contact of switch and rectifier tube is burnt	Replace the switch and rectifier tube

10.Parts

Parts No.	Name	Parts No.	Name	Parts No.	Name
A001	Machine casing	A033	Presser foot buttom	A065	Sleeve of tool post axis
A002	Motor	A034	Needle pole joint	A066	230#Needle
A003	Rotor	A035	Chain joint pin	A067	Torsion spring
A004	Diskslot belt sheave	A036	Clip	A068	Torsion spring screw
A005	Needle plate	A037	Needle pole sleeve	A069	Cylindrical pin Φ2
A006	Big connecting rod	A038	Presser rod upper sleeve	A070	Socket
A007	Plate	A039	Presser rod lower sleeve	A071	Cam semi-circle pin
A008	Carrying pole	A040	Presser rod guide frame	A072	Disc pulley semi-circle pin
A009	Carrying pole axis	A041	Presser rod	A073	Manual blade

A010	Small plate	A042	Presser rod spring	A074	Joint bearing
A011	Enclosed plate	A043	Spring screw of presser foort	A075	Universal bearing
A012	Presser foot wrench	A044	Wrench screw of presser foort	A076	Pin circlip
A013	Enrouleur	A045	Thread presser guide	A077	Swivel pin ring
A014	Handwheel cage	A046	Chain joint	M001	Nut M6
A015	Belt sheave	A047	Driving blade	M002	Left tooth screw M6X8
A016	Synchronous belt	A048	Tool post axis	M003	Nut M5
A017	Threading loop	A049	Tool post spring	M004	Hex head cap screw M5x14
A018	Thread presser	A050	Tool post	M005	Hexagon socket head cap screw M5X10
A019	Feeding tooth	A051	Fixed blade	M006	Socket head cap screw M6x6
A020	Feeding tooth base	A052	Hook axis lower sleeve	M007	Cup head screw M4X6
A021	Main axis	A053	Hook axis upper sleeve	M008	Self tapping screw 3x10
A022	Cam	A054	Crank roller ball	M009	Socket head cap screw M5X10
A023	Hook	A055	Roller ball base	M010	Hexagon socket head cap screw M4X8
A024	Hook base	A056	Thread nail	M011	Countersunk head screw M4X5
A025	Bearing Φ30x10x9	A057	Thread nail cap	M012	Cup head screw M3x4
A026	Hook guide axis	A058	Feeding tooth base bearingΦ16xΦ8x6	M013	Countersunk head screw M5x6
A027	Main axis cushion	A059	Switch	M014	Self tapping screw M3.5x30
A028	Main case cover	A060	Switch button	M015	Socket head cap screw M4x16
A029	Slipper	A061	Switch shield	M016	Socket head cap screw M4x12
A030	Needle pole	A062	Carbon brush	M017	Nut M6
A031	Handwheel	A063	Carbon brush cover	M018	Left screw M5X6
A032	Parallel axis	A064	Power cord	M019	Self tapping screw M4x10
				M020	Needle plate screw


M008
A061
A060
M016
M015
A014
M014
M019
A059
A031
A062
A063
A070
A002
A003
A016
A015
A064
M002
A075
M018
A006
M017
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A030
A068
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A041
A072
A044
A038
A026
M006
A043
A071
A053
A021
A023
A011
A007
M009
A024
A058
M007
A020
M009
M010
M004
A019
A028
M007

11.Product Catalog

			
Model	GS8-015	GS8-015D	GS1-033 Pro
Power	110Volt	100-240 Volt	110Volt
Cordless	×	√	×

			
Model	GS7-017	GS7-017D	
Power	110Volt	100-240 Volt	
Cordless	×	√	

			
Accessories	Sewing thread	36V battery	