Automatic Blister Packing Machine

Model: DPP-80

USER MANUAL

Finetech

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Link: https://pharmamachinecn.com/dpp-80-pvc-blister-packing-machine/

Catalog

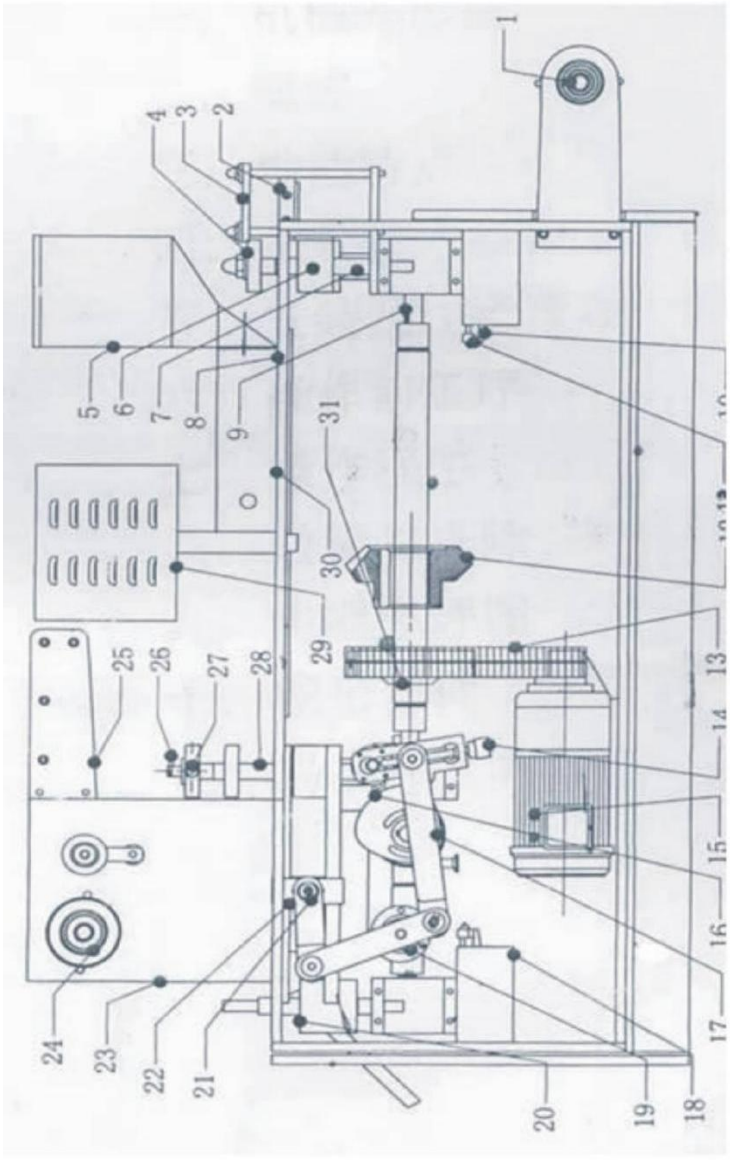
Attentions

A. Please read this note seriously when you begin to use the machine. In order to prevent the operation mistake and the damage.

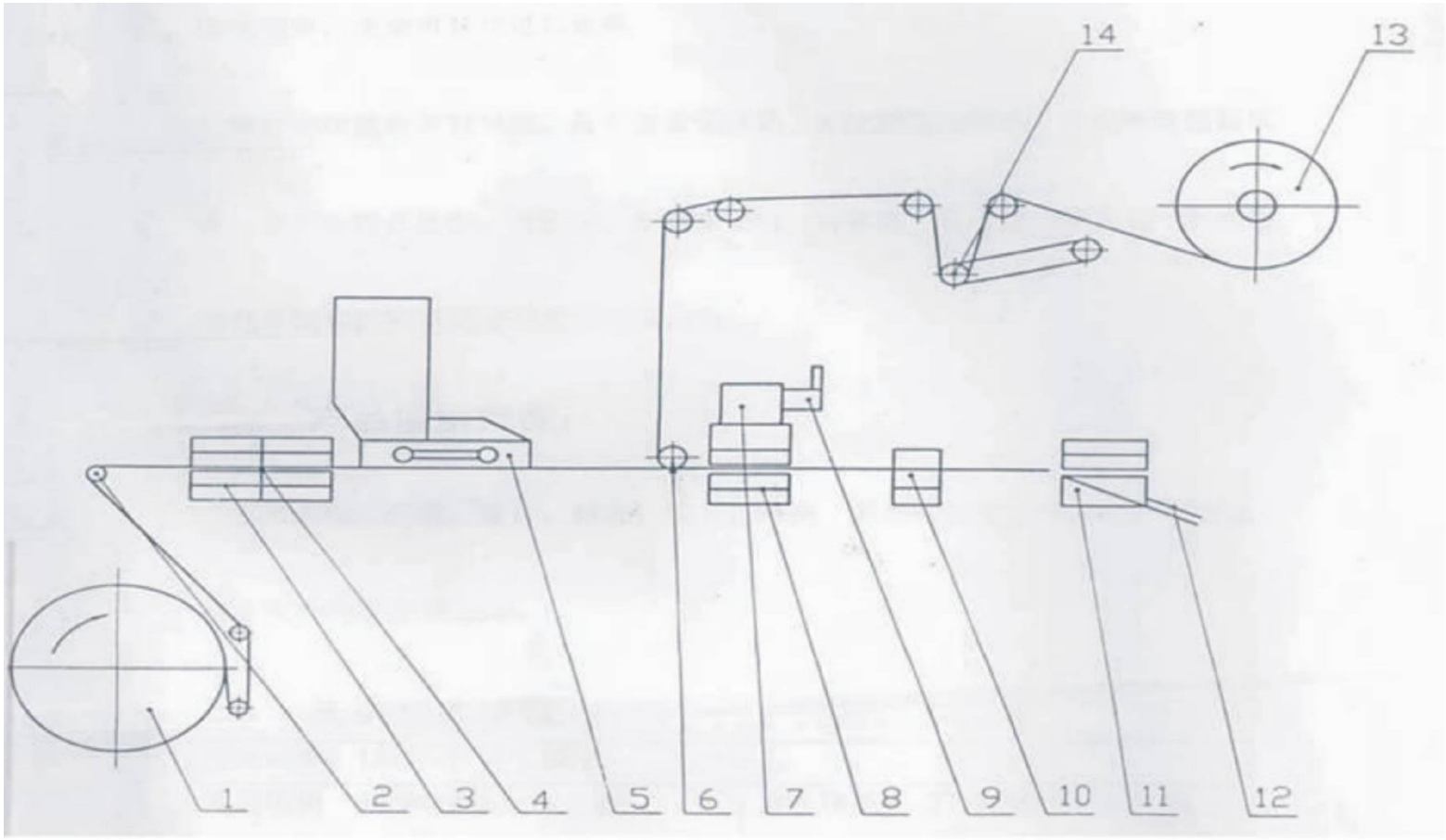
B. Please connect to the ground carefully.

C. Forbid to touch to the circulating parts (especially the vertical and the horizontal heating parts), When the machine is working. Make sure the personal and machines' safeties.

Ⅰ. Mechanical figure：



1. PVC swivelJoint holder 2. Upper & lower heating plates 3. Heating cover plate 4. Formation cover plate 5. Middle guider plate
6. Middle guider plate 7. Formation column 8. Face guide rail 9. Connecting axile bush 10. Adj. screw holder 11. Adjusting seat
12. Bevel gear 13. Drive chain 14. Adj. member 15. Elec. motor 16. Concave wheel for stroke 17. Rock arm 18. Punching care
19. Rocher bearing 20. Punchin mould 21. Stroke bearing seat 22. Stroke locating axes 23. Label 24. PTP
Bearing seat 25. Aluminum case bracket 26. Hot sealing press roll 27. Hot sealing press wheel 28. Hot saling pole 29. elec.
cabinet 30. Feeder 31. Transmi ssion



1.PVC plastic axes 2. Swivel-joint roller 3. Lower formation heating plate 4. Upper formation heating plate 5. Feeder 6. Aluminum foil swivel joint roller seat 7. Hot sealing press wheel 8. Lower hot sealing die holder 9. press wheel handle 10. Stroke air trap 11. Punching mechanism 12. Trash receptacle 13. PTP aluminum foil load shaft 14. Upper swivel-joint roller

Ⅱ. Summary：

Since the company was founded, we specialize in the production of DPP automatic aluminum-plastic packaging machine series. The function has reached at the leading level in China.

Implementation of Al-plastic composites sealed package, with the extended period to maintain and beautify the advantages of goods and reduce the cost of packaging.

It is an ideal packaging equipment for the purification plant and the hospital reagents room because the machine is small area, low investment, the use of multi-function, high efficiency, non-polluting, low noise and so on.

Ⅲ. Function and characteristic:

1. Adopt the high-power transmission of the domestic latest model, and spread to move the stalk from the row chain to remove other gear transmission error and noise.

2. Imports of used electrical control systems, customers can request configuration shut fill leakage detection and missing tablets removed devices. Used imports Frequency Converter.

3. Unit stages portfolio: PVC shape, feed, heat sealing as a tropical aluminum cold forming, heat sealing, Punching a section of the body for hours packaging.

4. Photoelectric control systems, PVC, PTP, tropical aluminum packaging automatic feed, scrap automatic admission Device, to ensure the long-synchronous multi-position stability.

5. Additionally photoelectric detector may calibration device, service imports stepper motor drive, the transmission version printing and packaging, optimize packaging grades.

6. The machine applies: capsules, tablets, sugar-coated, capsules, injections, and other special-shaped medical device, light industry and food, electronic components sealed blister packaging.

Ⅳ. Main technique parameter：

Punching Frequency: 18~35 times /min. Capacity: (1plate/time)	
Standard plate: 57×80mm (Standard), 57×88mm and 95×60mm Capacity: (1plate/time)	
Adjustable scope of travel: 30—105mm (It can design by customer's requirement)	
Max. formed area: 95×60 (mm)	Finished product rate: ＞98%
Motor power: 0.37kw	Heating power for forming: 0.8kw
Lower heating power: 0.8kw	Heating power for hot sealing: 0.8kw
Air pump capacity: ＞0.15m^3/mm（Customer-supplied）	
Cooling： Recycled water or running water	
Weight： 300Kg	
Overall size (L×W×H)：1560mm×440mm×950mm	
Packing material specifications： Medicinal PVC: 0.25×88mm; Al foil: 0.02×88mm	

Ⅴ. Install and regulation：

1. The machine is complete and no installation is needed. With rubber castors provide under the base, the machine is mobile.

2. Specialized personnel must be designated for the machine operation and maintenance.

3. Should according to the label appointment position to contact the earth line

4. Keep the machine clean.

5. Put oil to each location which should be lubricated before production begins.

6. As no lubricant is put in the gear box when the machine leaves the factory, so must put the lubricating oil before production.

7. The pressure for formation, hot sealing, and indentation cannot be too great. Otherwise the machine service life will be shortened. The cushion for the formation and indentation should have room of 1 mm.

Ⅵ. Before the operation：

1. Power connection： Connect the machine with a power supply（220V/single phase/50Hz）according to your local power consumption safety regulations. Turn on the power and set the machine in a crawl operation to see whether its operation is well.

2. Cooling water supply： According to the indications of the label on the machine to inspect the cooling water inlet and outlet switches for leakage. Besides, the water should flow smoothly.

3. Air pump： Connect the air compressor with the machine airline switch and turn on the compressor. Keep the air pressure at 0.3~0.5Mpa for operation.

4. Lubrication: Put oil into the shift gear box to the 2/3 box capacity.

5. Charging： Charge PVC plastic onto the load shaft. Adjust the inside and outside taper nuts and press the nuts tightly. Adjust the PVC material, subject to the rails on the charging deck.

Ⅶ. Operating procedures：

1. Turn on the power supply switch and the green indicator lamp is on. Put the two switches for upper and lower formation and hot sealing to the position. “ ON ” .

Generally, preset the formation temp. controller to 90℃~100℃ and the hot sealing temp. controller to 120℃~140℃ but concretely, the temp. for both the formation and sealing should be set depending on actual situation such as PVC material quality and ambient temp.

2. Do not start the machine till the temp. for formation, sealing and heating plates comes to the preset values. The PVC formation operation in advance, in which the formed blisters should comply with the hot sealing die holes and then by putting down the handle for the hot sealing die holder, charge aluminum foils, during which inspect the blister sheet position.

3. If the sheets deviate side to side, adjust the handle wheel of the swivel roller holder for correction.

4. If the blistered sheets prove qualified, begin to charge the material. First open the charger gate properly to let a proper amount of medicine (tablets, capsules or sugar-coated pills) enter the charging chamber. If only a few blisters are not filled with the medicine, manual filling can be made, when pay attention not to injure your hand or damage the aluminum foil. If the blisters not filled with medicine is located on one side of the hot sealing die， do not make up for failed fill constrainedly, for inaccurately-filled medicine may affect the filling synchronized operation. If a foil is found adhering to the die upon the foil sealing, shut down the machine for troubleshooting.

5. After the material is charged, increased medicine weight and gradually-varied aluminum foil tensile and machine temp. may result in asynchronous formation and hot sealing, such as leading or lagging, when check whether there is any obstruct between the PVC and the foil and then adjust the machine by inching of machine .The fault can also

be eliminated by moving the front case body but its moving correction can only be decided by inspecting more than a dozen sheets processed after the moving.

6. Temperature, pressure and net-patterned sheet flatness testify the quality of hot sealing (even, firm and flat adherence) between the plastic and the aluminum foil. Poor sealing is generally owing to slightly-low temp. and pressure. Adjust temp. and pressure to eliminate the failure.

7. If deviated sheet punching occurs, shut down the machine to adjust the case body or the die for its correction.

8. The machine operator has to know the mechanical principles of the machine. As the up-and-down motion of the middle guide plate is driven by a cam, upon the upper form board adjustment, pay attention to move the lower forming die or hot sealing die to the upper dead center before fastening the column nut. Otherwise failures will possibly occur.

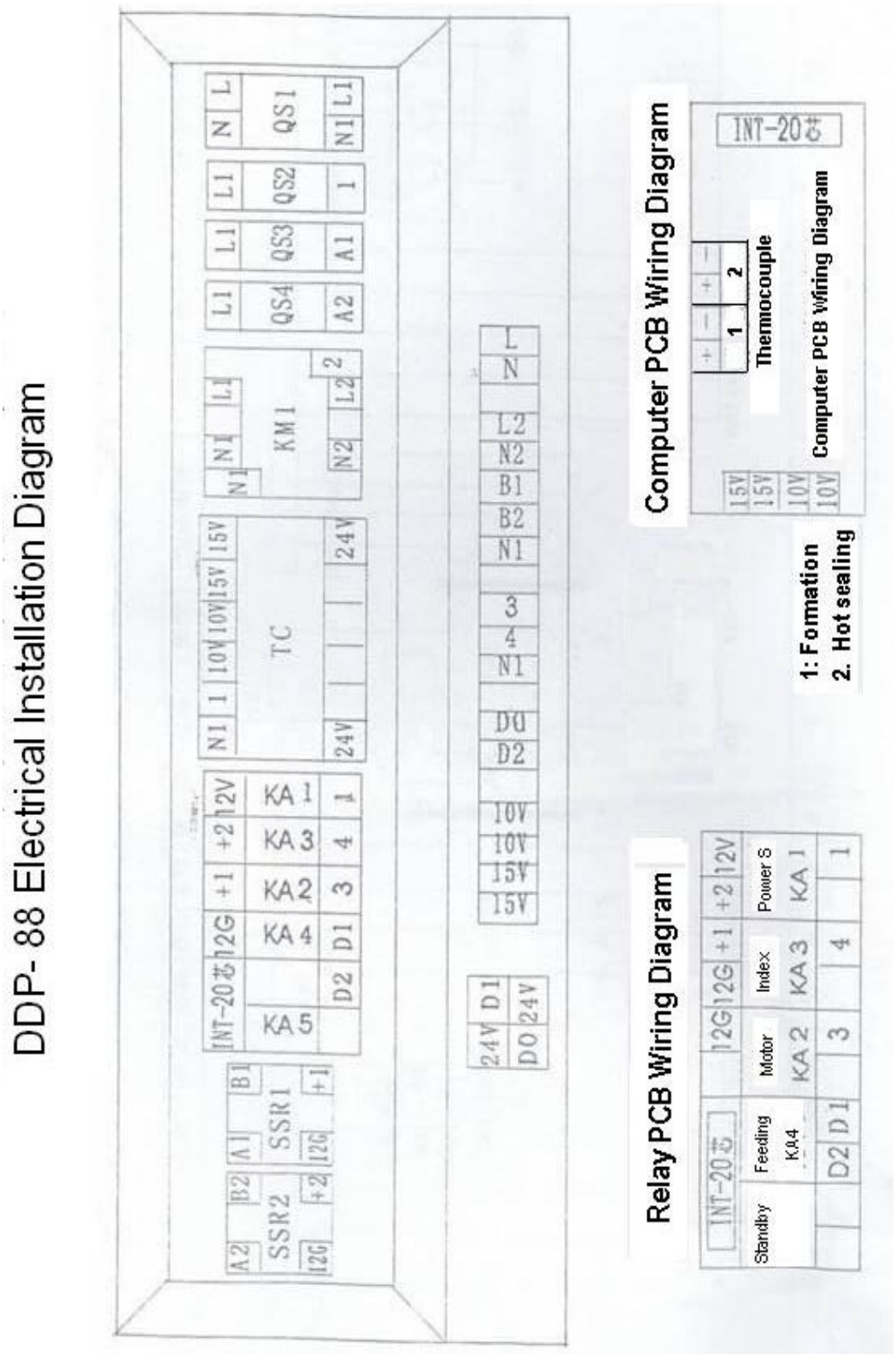
Ⅷ. Malfunctions and Solutions：

Failures	Causes	Elimination
Poor blister forming	1. Too much air flow at the operation site; 2. Too high or too low temp. at the heating areas; 3. Too much heat going by the excessive cooling water flow; 4. Air blowing time should not too late or early; 5. Pay attention to the water retained in the air- filtering valve；	1. Lower the air flow； 2. Adjust and control the temp. properly by voltage control as far as possible and alternatively by the temp. controller. 3. Adjust the water valve to control water flow; 4. Calibrate the machine air releasing valve position to keep the air pressure generally to 0.3-

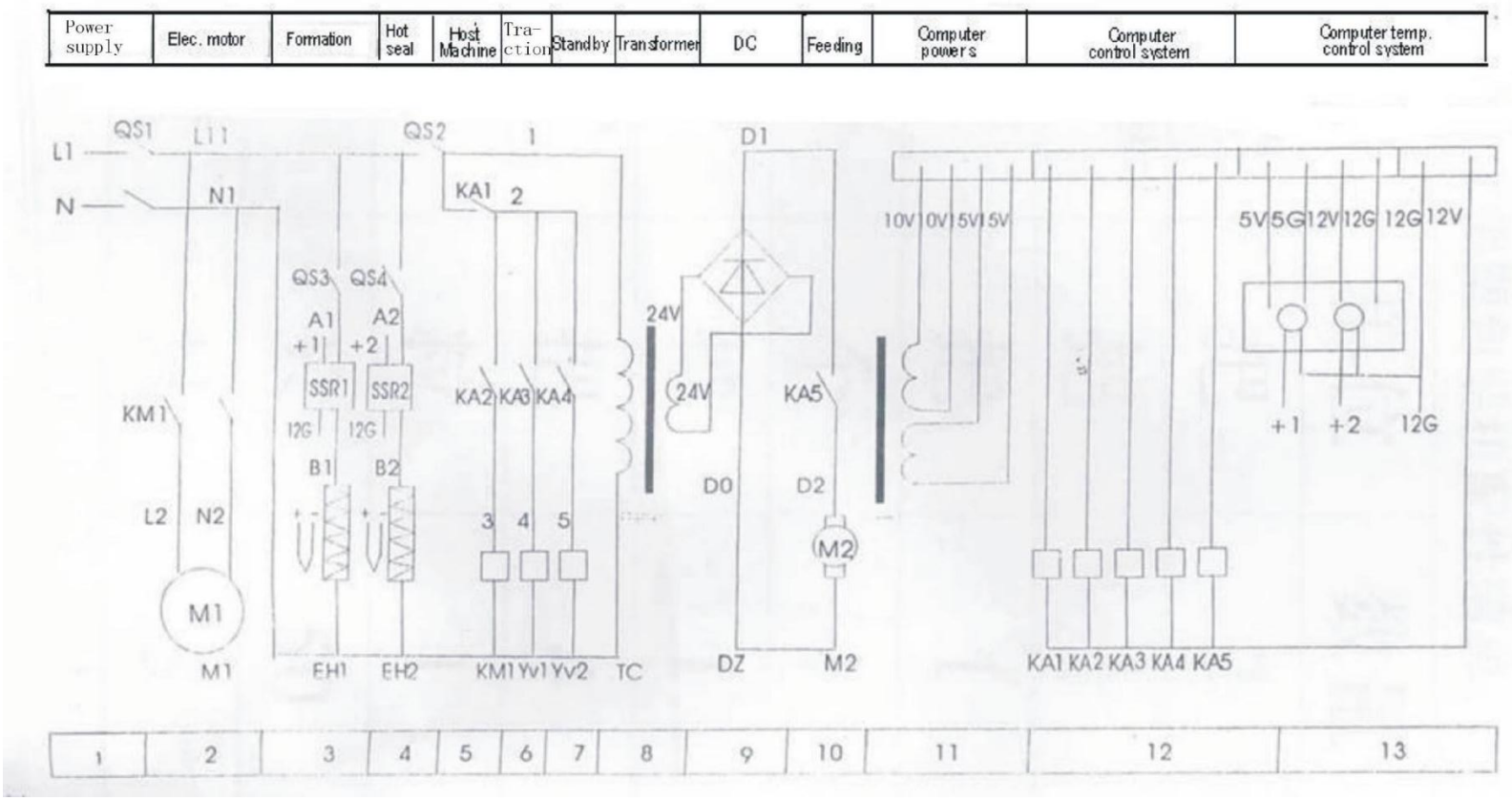
	6. Lower die air-exhausting holes clogged; 7. Air leakage through the plane between the upper and lower dies ; 8. Poor PVC plastic quality.	0.5Mpa； 5. Check and clean the air- filtering valve； 6. Make the holes unimpeded with a steel needle; 7. Repair the dies with a plane grinding machine ； 8. Exchange PVC.
Asynchronous operation(with formed blisters not accurately entering the hot sealing die hole position)	1. The forming die and the hot sealing die are not an integral multiple of the stroke; 2. Operating air pressure-causing holder parallelism too great or too small; 3. Poor forming die and hot sealing die cooling; 4. Obstacles exit between forming die and hot sealing die: 5. Poor running of the load shaft for plastic; 6. Hot sealing die temp. too high.	1. Adjust the die-type movable case body.（The case body has been adjusted before the machine leaves the factory and usually no readjustment is necessary）; 2. Adjust the indexing seat shaft and apply machine oil to the shaft; 3. Properly increase the cooling water flow; 4. Check whether obstacles exit between the forming die and the hot sealing die, and pay attention to the gap between the charging machine and the faceplate; 5. Clean or replace the bearing 6. Lower the sealing die temp.
Aluminum foil crinkled or deviated	1. Unparallel adherence between the aluminum foil and the PVC plastic; 2、The aluminum foil turning roller not in perpendicular to the ordinate of the PVC plastic sheet； 3. Rust or contaminants on the veins net;	1. Tear away the foil and adjust the adhering position for adherence once more； 2. Adjust the turning roller bracket and calibrate the dies; 3. Remove the stains with a steel wire brush or a saw blade；

	4. Poor bond between the veins net and the lower die； 5. Uneven glue layer of the aluminum foil.	4. Depending on the sealing conditions, grind part of the lower die plane with an oil stone； 5. Exchange the aluminum foil.
Poor hot sealing after deviated punching	1. Incorrect distance between the punching die and the hot sealing die； 2. Temp. too high or too low； 3. Deficient pressure or deviated upper hot sealing cylinder.	1. The integrally-movable punching die case body has been adjusted before the machine leaves the factory. Adjust the case body only under imminent necessity； 2. Adjust the temp. controller to keep the temp. constant at about 140ºC 3、Adjust the cylinder pressure by the pressure-adjusting valve and check the silicon rubber for any aging. Exchange the copper cushion between the cylinder and the hot sealing holder.

Ⅸ. Electrical Wiring Diagram



DDP-88 Electrical Wiring Diagram



XI. Machine testing

DPP automatic machine aluminum-plastic packaging
Machine product testing

Date: Sept, 2025

Items tested		Standards	Result	Note
A:Basic Parameters	a. Punch Frequency	35time/min	Qualified	
	b. Max. forming area	60×95mm		
	c. forming depth	<25mm		
	d. Motor Power	0.37kw		
	e. Forming district heating power	1.6kw		
	f. Heat sealing district heating power	0.8kw		
B: Assembly Quality	a. Die Gap	0.01~002mm		
	b. Soda pipeline system	not allow unimpeded obvious leakage		
C: Appearance Quality	a. Non-casting surface processing	no convex tumors, depression, porosity, phenomena such as scarification		
	b. The exposed surface	no corroded, bumps, scratches and other phenomena		
	c. Electroplate	Smooth, no scratches, scarring shedding phenomenon		
	d. Drug contact with the parts	OCT18Nig should be used at room temperature or under drug-free anti-corrosion materials		
	e. paint	In line with provisions of JB2855		
	f. Electrical Wiring	Neat, aesthetics		
D: Safety	a. Security Grounding	Security grounding devices and clearly marked		

Performance	b. Insulation Resistance	>2MΩ		
E: Emptily Moving to Performance	a. Transmission	Transmission smooth and no blocking, unusual noise and vibration.		
	b. Roller counterparts intermittent operation	Synchronous		
	c. Bearing temperature	<35K		
	d. Electric Control Equipment	Accurate and reliable		
	e. Lubrication System	Lubrication good, and no use leakage		
	f. Unit noise	<78-82db(A)		
	g. Temperature measurement instrument display and error	sensitive, reliable, error 5℃		
F: Assembly Quality	Filling rate	>98%		
	Finished incision	Formation		
	Foil and PVC glue, halftone, hot pressing, lot numbers	Solid, Formation, Netted and lot numbers clearly		

XI. Packing list：

Name	Type	Qty
Automatic aluminum-plastic blister packaging machine	DPP-80	1
Within the six Kook Wrench	2、4、5、6、8、10	1
Activities Spanner	10 Inch	1
clamp	6 Inch	1
Level screwdriver	4 Inch	1
"Cross" screwdriver	4 Inch	1
High pressure oil tank		1
Hone		1
Gas joints	Φ8、Through 、Elbow	2
Steel code word	0~10	1
Copper wire brush		1
Product brochures, certification		1

Pack the member_____ Pack the date ____2025