



**MW-18**  
**Gasket Wrapping Machine**

# **Operation Guide**

**SUZHOU INDUSTRIAL PARK MATE AUTOMATION**

**TECHNOLOGY CO.,LTD**

[www.suzhoumate.com](http://www.suzhoumate.com)

Thanks for using our products. Before use, please read this menu carefully and keep it for future reference. Thanks for your understanding if there's any discrepancies between the manual and practical operation process due to technical update ceaselessly.



## **Company brief**

Suzhou Industrial Park Mate Automation Technology Co., Ltd. is a metallic gasket and equipment manufacturing and selling company. We are located in Suzhou - a city well known for its Chinese classic garden, south of Jiangsu Province, China. With our technology, we offer our customer very wide variety of metallic gasket equipment, such as

Spiral wound gasket winding machine;

Kammprofile machine;

Guide rings grooving machine;

Inner ring Chamfering machine;

Bend & weld machine;

Laser marking machine;

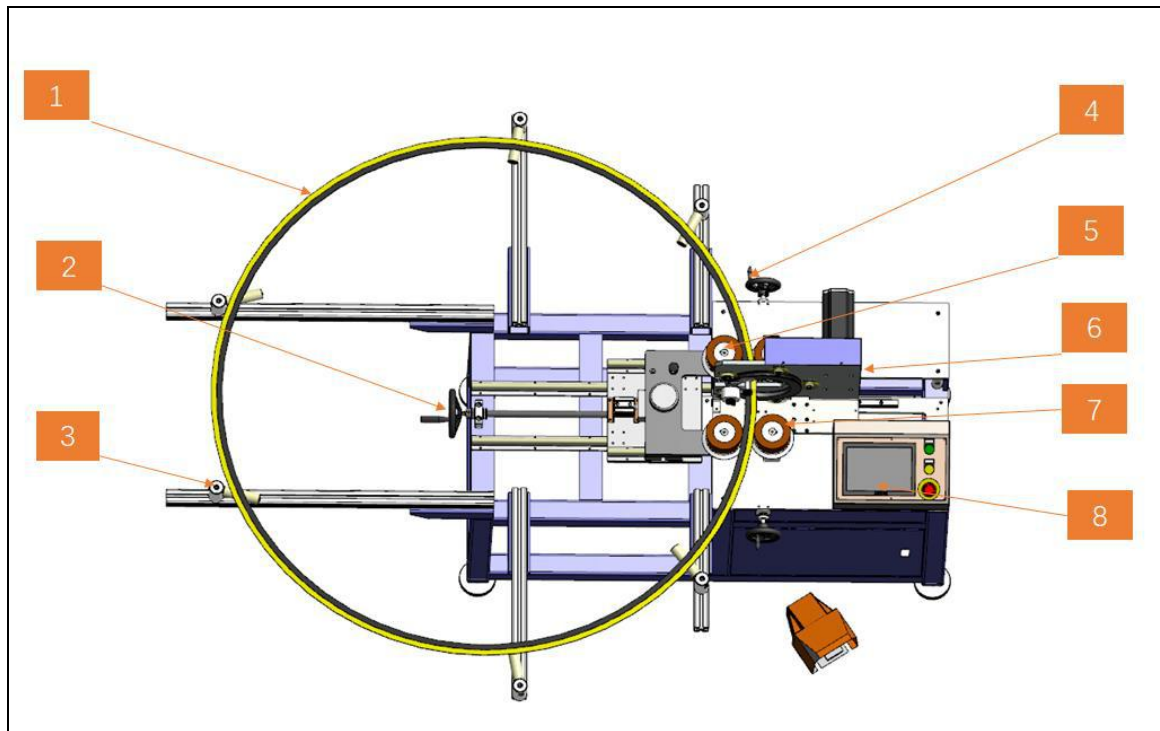
as well as computer controlled compression tester.

Our concept is to provide our customers with one-stop service for all metallic gasket related products, parts, and equipment. We have successfully sold our products and equipment to customers in the Asia India USA Europe and South America.

We welcome all customers from abroad and home.



## MW-18 Gasket Wrapping Machine



(Machine details)

1. Gasket --- This machine can wrapping 5 pieces gaskets, 10 pieces is optional.
2. Hand wheel 1--- Adjust the press roller's position to fit for different sizes of gasket, new version changed to motor control.
3. Support roller --- There are few support rollers on the top of frame work, they provide support for gasket seat on top of them.
4. Hand wheel 2--- There are 2 hand wheels at each side, adjust the driven rollers.
5. Press roller--- Press rollers provide pressure to hold gasket, so driven rollers can drive gasket turn around.
6. Wrapping head --- Wrapping head move forward to work position, and wrapping the film on the gasket, and return back after wrapping finish.
7. Driving roller --- Provide driven force to drive the gasket turn around.

## MW-18 Gasket Wrapping Machine Main Features

1. Film wrapping machine, wrapping the larger sizes of gasket from 3"-48";
2. Work mode semi-automatic, operator load the gaskets, then machine do all rest of work, then cut off film and take off the gasket;
3. Very productive, roughly about 3-5 times quicker than hand wrapping;
4. Only need to set up OD of gasket, then machine automatically find the work position.



## Machine Specification

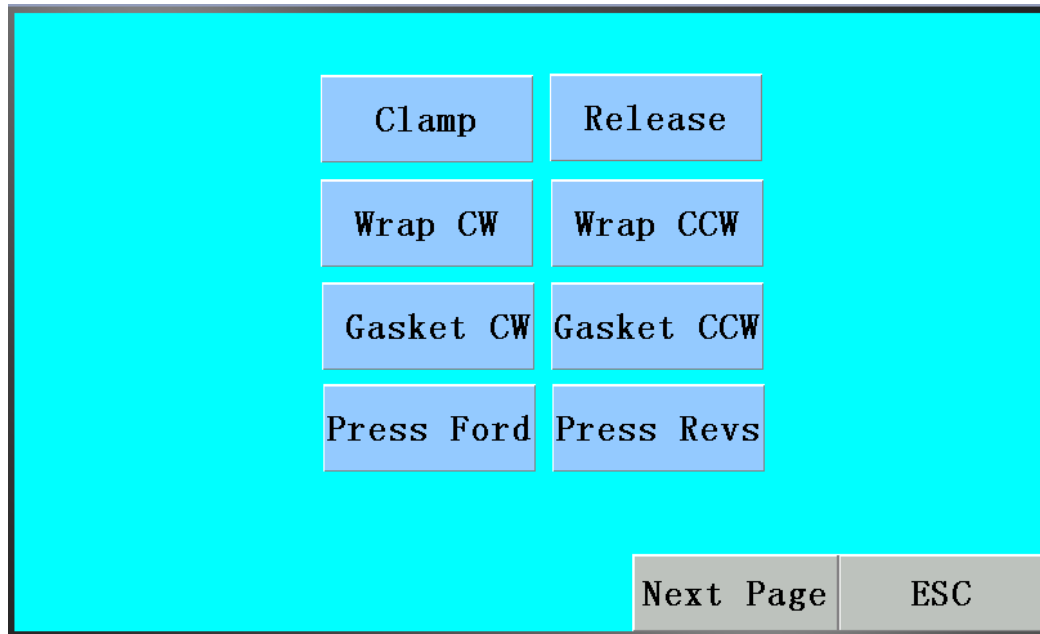
Type	MW-18
Profile	1550*800*1350
Net weight	460KG
Power Supply	1.5KW
Voltage	380V
Size scale	4"-60"
File thickness	0.1 mm
Film Width	30-50 mm
Max wrap width	50 mm
Cycle time	40-120 Seconds
Process control	Automatic
Spacer feeding	Automatic

## Machine set up

1. Connect cable to power. 380V 3 phase.
2. Connect air pipe to compressed air source.
3. Turn on power, the interface will show the manual page as following pic,



Press “Manu”, it will display the following page as manul control buttons,



Clamp --- Clamp the gasket

Release --- Release the gasket

Wrap CW --- Wrapping head turn around clockwise

Wrap CCW --- Wrapping head turn around counter clockwise

Gasket CW --- Gasket turn around clockwise

Gasket CCW --- Gasket turn around counter clockwise

Press Ford --- Control the press roller move forward to wrapping head

Press Revs --- Control the press roller departure wrapping head

**Press Next Page, it will show below screen,**



Position Setting

Home

Standby Posi + 0 MM - Save

Work Posi 0 MM

Initial Posi 0

UP Page

Standby posi --- Stand by position is the wrapping head stay temporary position after finish one gasket wrapping, it will return to stand by position, and be ready for next gasket.

Work posi --- After load the gasket, press button “start” the wrapping head will move forward to the work position, and start wrapping the gasket

Initial posi --- Means initial position, normally user don’t need to change its setting unless you move the two driven rollers position by hand wheels. The principle is as following,

If you move the two press rollers outward, you will need to make Initial posi value greater; if you move two rollers inward e.g. closer, then you will need to set value smaller.

Press “Auto” button, it will display the following page,

Para Setting

中文 ENG

Gasket OD	0
Flange Width	0
Wrap Speed	0
Volume	0

Zero

PARA ESC

Gasket OD --- Show the out side dimeter of gasket under wrapping

Flange Width --- Flange width of gasket you are wrapping



Wrap Speed --- Show the speed of wrapping head turning around

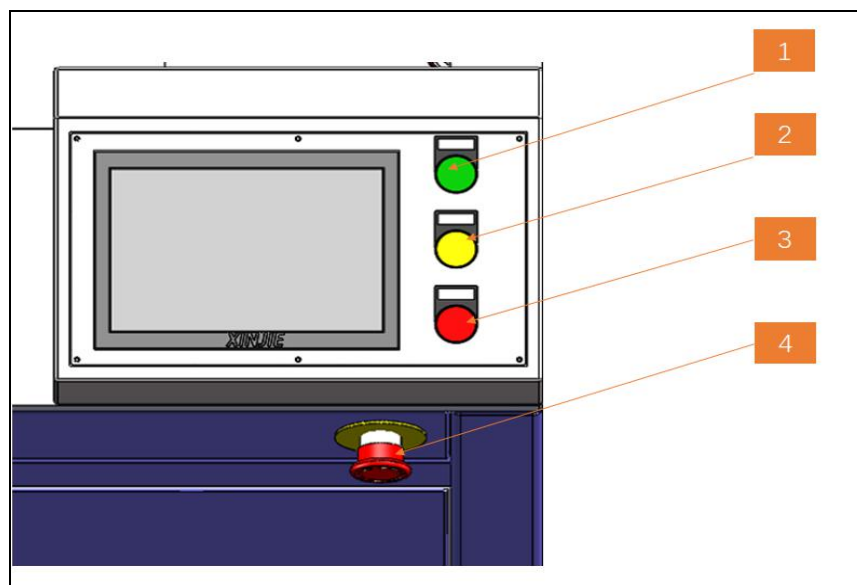
Volume --- Count volume you wrapping totally

Press “ADM” it will shows the following page, This page is only for machine maker purpose.

56-60" S1	0		6-10" S9	0	
50-54" S2	0		3-5" S10	0	
44-48" S3	0		Servo Motor Speed	0	
38-42" S4	0				
32-36" S5	0				
26-30" S6	0				
18-24" S7	0				
12-16" S8	0				
			ESC		

There are only 3 buttons on control panel

1. Green button --- Start button
2. Yellow button --- Reset
3. Red button --- Pause button, Pause will be used if film run out during processing.
4. Emergency button Located in front of machine, people can even use body to press it stop the machine in case of emergency.

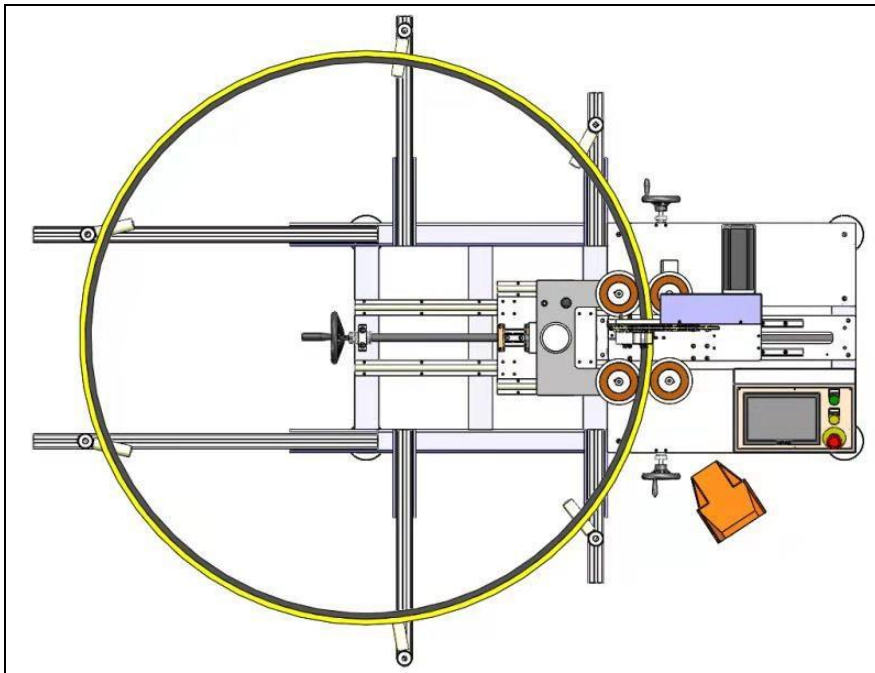


## Machine operation

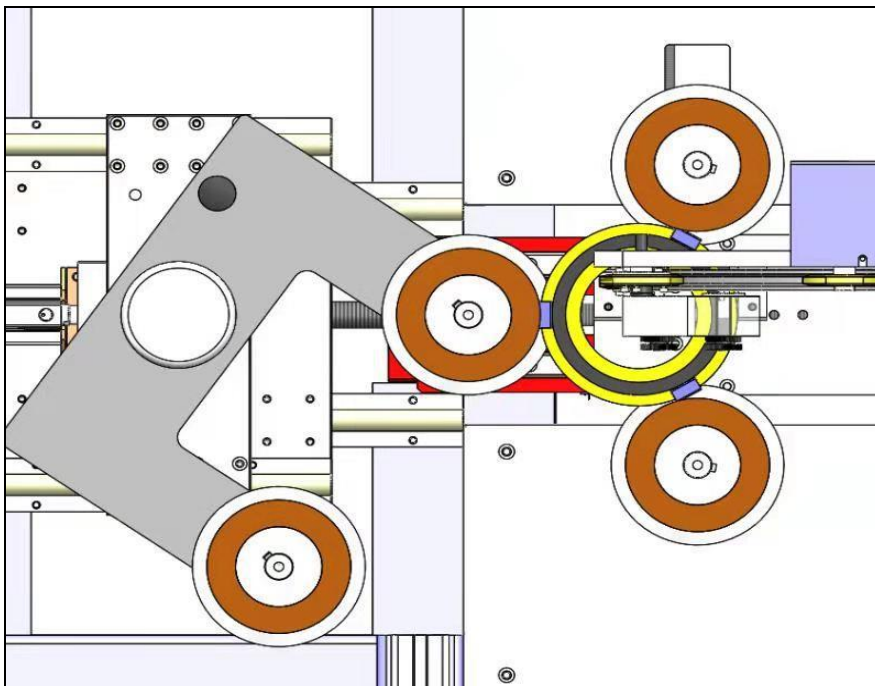
1. Load the gasket as shown in following pictures. The gasket holding mechanism is a special patent design, it is suitable for hold wide range sizes of gasket, see below 2



pictures.



(Large size of gasket loading)



(Small size of gasket loading)

2. After load the gasket, then press foot switch to clamp the gasket.
3. Press the start button, the wrapping head will move forward to the work position.
4. Manually bring the film to the gasket initial position, and wrap the film overlap on the gasket, then press start “button”, the machine will start wrapping the gasket automatically, slowly first, then accelerate to setting wrapping speed until wrapping process is over.





5. Wrapping head stop, manually cut off the film by hand.
6. Press the “Start” button again, the wrapping head return back to home position.
7. Press “foot switch” to release the gasket, and take off.
8. Reload another gasket, and repeat the above process.

### **Safe Instruction**

1. After overlap the film on gasket, move hand away quickly.
2. Do not touch the wrapping head and gasket during wrapping process.
3. Do not open electronic box when electrician is absence.

**End**