TABLE TOP TYPE SEALING MACHINE

ET-999S, 95S, 899S, 58S

OPERATION MANUAL

TAIWAN PACKAGING STAR (TP STAR)
GOOD DESIGN PRODUCT
TAIWAN EXCELLENCE
ISO 9001
UL CERTIFICATE

Y-FANG SEALING MACHINE LTD.

[CAUTION: BURN HAZARD]
Cleaning and maintenance should be performed by trained personnel only & Keep children away from machine.
CONTENT

(1) CHARACTERISTIC FOR ET-999S, 899S, 58S .................... P3
(2) USING OPERATION ............................................. P6
(3) FRONT PANEL INTRODUCTION ................................. P11
(4) USER’S MAINTENANCE ......................................... P14
(5) AJUSTMENT OF UPPER AND LOWER MOULD ................. P15
(6) STRIP DOWN AND REBUILD THE UPPER MOULD.......... P17
(7) AJUSTMETN OF CENTRAL BAR ................................. P19
(8) TROUBLE SHOOTING .......................................... P21
(9) CIRCUIT BOARD WIRING DIAGRAM ......................... P30
(11) ERROR CODE AND SOLUTION ................................. P35
(12) RELATIONSHIP AMONG MACHINE, FILM, AND CONTAINER .... P38
1. FILM CLAMP   2. FILM SENSOR   3. ROLLER   4. FILM PIN   5. LOWER MOULD PLATE
6. CUP JACK  7. LOWER MOULD  8. SAFETY DOOR  9. FRONT PANEL  10. FILM CLAMP
11. FILM COLLECTOR

1. UPPER MOULD   2. IN-OUT SENSOR   3. SLIDE   4. CUP JACK   5. BEARING
6. JUMP ROD   7. BEARING BUSH 605zz   8. BEARING BUSH 699zz

Way to fill in the film
ET-899

1. FILM CLAMP  2. FILM SENSOR  3. ROLLER  4. FILM PIN  5. LOWER MOULD PLATE  
6. CUP JACK  7. LOWER MOULD  8. SAFETY DOOR  9. FRONT PANEL  10. FILM CLAMP  
11. FILM COLLECTOR

Way to fill in the film

1. UPPER MOULD  2. IN-OUT SENSOR  3. SLIDE  4. CUP JACK  5. BEARING  
10. TEMPERATURE CONTROLLER  11. COUNTER  12. POWER  13. TEMPERATURE INDICATOR  
14. START KEY  15. AUTOMATIC/MANUAL CONTROL

Confidential by Lollicup USA, Inc.  - 4 -  2/25/2013
1. FILM SENSOR 2. FILM ANCHORAGE 3. LOWER MOULD PLATE 4. LOWER MOULD
5. SAFETY DOOR 6. FRONT PANEL 7. FILM CLAMP 8. FILM COLLECTOR

1. UPPER MOULD 2. SLIDE 3. CUP JACK(BIG) 4. BEARING 5. BEARING BUSH 605zz
6. JUMP ROD 7. BEARING WHEEL

Way to fill in the film
(2) USER’S OPERATION

FILL-IN THE FILM

1. Fill in the film in correct direction as the above picture. If you fill in the wrong way, the film would be stuck with the heater of upper mould. After loading the film, please match the eye-mark of film to the place of film sensor.

2. Plug the AC power wire, turn on the power button, the lower mould will push out at the same time. Further, the upper mould will be increasing the temperature automatically.

3. After 5-7 minutes, the TEMPERATURE INDICATOR shall shut off when the upper mould’s temperature set ready. Till now, the auto function is ready for work. It could be only in manual while the temperature is not ready.

4. The way to choose the container and film:
   (1) PET/ES film is suitable for any kind of trays. (temperature range 140~160 °C)
   (2) As for sealing well, the material of both container and film should be the same. (temperature range 160~180°C)

※PS: Unemployed and children are forbidden to close to the machines. To forbidden the accident, don’t put hands in the machines unless you pull out the power wire.
Step 1. Take off the Right side of  
「Plastic film clamps」 &  
「Spring」、「Washer」、「Butterfly Clamps」

Step 2. Put the Right side of  
「Plastic film clamps」 into  
the central paper roll of film  
to the both sides

Step 3. OK
Step 4. Put the Step 3 onto Rolling System

Step 5. After put the Film onto system than put on the 「Washer」 first, and 「Spring」 & 「Butterfly Clamps」
Step 6. 
**FILL-IN THE FILM**
Step 7.
Put the film behind the Iron Bar.

Step 8.
Turn on the 「Manual Operate」 the film is OK to be rolled on the film system.
I. Indicator

II. Function of buttons:
(1) Power indicator: Indicating the power is online or offline.
(2) Power key: Press power key to start up the machine. After displaying “YF-LCC” pattern, the machine begins to service you. Oppositely, “PO” pattern means the power is off.
(3) Auto/Manual choice key: Providing you to select auto or manual operation;
   A. If manual is selected, the machine is waiting for pressing the manual key to go on sealing process.
   B. If auto is selected, the machine is automatically doing sealing process. (Cups will be sealed automatically.)
4. Manual Operate KEY: Work in situation 3-B.
5. Set key: Reset the function of microcomputer’s parameters, and special function.
6. Temperature Key: Lighting up as increasing temperature, off oppositely.
7. Right screen: A. To display the temperature as usual condition.
   B. To display the parameter of function as changing the parameter setting.
   C. To display error code.
8. “UP” and “DOWN” Keys: To increase or decrease one unit value.
9. Counter Key: To display the amount or count back to zero.
10. Left screen: A. To display the amount as usual condition.
    B. To display the parameter setting. Symbolizing P1-P5.
III. Function of setting

1. System parameter table:

<table>
<thead>
<tr>
<th>Symbol</th>
<th>Function Setting</th>
<th>Range</th>
<th>Parameter Setting (Set in factory)</th>
</tr>
</thead>
<tbody>
<tr>
<td>P1</td>
<td>Temperature</td>
<td>PP (160<del>180℃) ES (140</del>160℃)</td>
<td>160℃</td>
</tr>
<tr>
<td>P2</td>
<td>Counter</td>
<td>LOK: LOCK / OPN: UNLOCK</td>
<td>N (can be reset)</td>
</tr>
<tr>
<td>P3</td>
<td>Sealing time</td>
<td>001<del>030 unit (0.1sec</del>3sec)</td>
<td>010 unit (1sec)</td>
</tr>
<tr>
<td>P4</td>
<td>Cup settled time</td>
<td>000<del>030 unit (0.0sec</del>3sec)</td>
<td>010 unit (1sec)</td>
</tr>
<tr>
<td>P5</td>
<td>Film rolling time</td>
<td>000<del>060 unit (0.1sec</del>6sec)</td>
<td>000 (controlled by sensor)</td>
</tr>
</tbody>
</table>

IV. Operating procedures:

The procedures of machine as: A->B->C->D->E->F->G->H->I

A. Press **POWER** to display **YF/LCC**, then left screen shows **counter** and right screen shows **TEMP**. The machine is now ready for using.

B. Press **SET** key, the left screen displays **P1**, the right screen displays temperature, then use **up** or **down** key to increase or decrease one degree. (PP film 160-180℃, ES film 140-160℃)

C. Press **SET** key, then the left screen display **P2**, the right screen shows counting mode, **OPN** means can be reset to zero and recounting from one, **LOK** means cannot be reset to zero, but continuously counting day after day.

D. Press **SET** key once more, the left screen shows **P3**, and right screen shows sealing time, then use **up** and **down** key to increase or decrease the value by one unit (0.1 second). Generally, the value is assigned between 005 and 015.

E. Press **SET** key once more, the left display shows **P4**, and right display shows cup settling time, then use **up** and **down** key to increase or decrease the value by one unit (0.1 second). Generally, the value is assigned between 005 and 010.

F. Press **SET** key once more, the left display shows **P5**, and right display shows plastic paper advancing time. If the paper has a sensed point (eye mark), then set the value at 000, else depends on the length of the paper unit, and use **up** and **down** key to adjust the correct time, generally, is set around 006 and 020.

G. Press **SET** key once again, the left display shows **YF**, and right display shows **LCC**, means all set procedures are finished. The left display goes to normal counting, and the right display shows the temperature of the heater, and going
to warm up.
H. As the temperature ready, the machine goes to normal working, according to AUTO mode or MANUAL mode.
I. To stop the machine, only need to press the POWER key once again, the lower mould will draw back; the left and right displays are going off. At this time, the power indicator is still on, and that’s normal. This means the controller is sleeping, press POWER key once again to wake it up if you want to work continuously. To off the power indicator, you need to unplug the power line.

V. System error codes:
The machine is going to buzz as the microcomputer detecting any failures.
A. E00: Temperature control system error.
B. E01: Heating circuit or temperature wire error.
C. E02: Upper motor draw back or micro switch error.
D. E03: Lower motor advanced or micro switch error.
E. E04: Sealing film is not in the right position or the eye-marks not detected.
F. E05: Lower motor draw back or micro switch error.
G. E06: Upper motor advanced or micro switch error.
H. E07: Safety door is touched or collided.
I. E19: P.C board error.

To stop the buzzer, please off the power for five seconds, then on power gain, if it is still buzzing, please contact your local dealer for service.
Any time do maintenance, should un-plug the AC power wire.

I. Daily check point
   (1) Check the upper mould and clean by wet cloth or rough plastic sheet. If not, the dirty plastic sheet or powder will stick on the heating plate.
   (2) Keep both the right and left slider those fixed under the lower mould plate clean and lubricated, if not, the input and output of the lower mould operation will be unsmooth.
   (3) Clean the groove of the lower mould.
   (4) Clean the jack system. (Jack slider, spring roller, bearing etc), keep it operate smoothly.
   (5) Clean the film sensor and lower mould in-out sensor.

II. Other maintenance and repair placement:
    Please contact with your local dealer for service and cooperate with the maintenance staff.
《5》UPPER AND LOWER MICRO SWITCHES OF UPPER MOULD

Graph 5-1 Open the front panel and control box.

Graph 5-2 Move the upper micro switch to the right position – match The plate to dotted line A. (Error code: E02)•
Graph 6-1 To lubricate axle and fish eye No. 8 once for a month.

Graph 6-2 Move the lower micro switch to the right position – Match the plate to dotted line B. (Error code: E06).
《6》STRIP DOWN AND REBUILD THE UPPER MOULD

Graph 7-1 Using a clam to strip down four B TYPE CLIPS, then take off the plate.

Graph 7-2、3 Using a wrench and box end wrench to separate the knife and heater. Then you can clean the mould and parts.
Graph 8-1 After cleaning, heater’s position should be higher than the knife for 1 mm.

Graph 8-2 The gap around the heater and knife should be equal.
1. The central bar will lie down or sloped by crash.

2. Using a pipe to adjust the bar to the right position.
3 To measure the angle between the bar and machine with an angle square. It should be in 90 degree.
You cannot turn on the machine with wrong voltage, the PCB will display AC for wrong voltage.

Graph 9-1 For error code E00: Check the temperature wire of upper mould.
Graph 9-2 For error code E01: Check the heating wire with a Electric meter.

Graph 10-1 For error code E01: Check the heater with a electric meter.
Annotation: Check for micro switch

※ Please strip the thin wire group of PCB as you check all the micro switches. To set the electric meter as above graph. Graph 13-2 While the switch is turning on, the pin of the electric meter should be in right side as normal situation.

※ While the switch is turning off, the pin of the electric meter should be in right side as normal situation.
Graph 10-2 For error code E02 - E06: Check the micro switch of upper micro switch with an electric meter or upper motor.

Graph 11-1 For error code E03 - E05: Check the micro switch with an electric meter at back or lower motor.
For error code E04:

1. Check if the sealing film is not detected by film sensor. (The eye-marks are not detected)
2. Clean the sensor or exchange the sensor.

Graph 12-1 For error code E04: Check the wheels beside the film collector.
Graph 12-2 For error code E07: Check the safety door and adjust the door to the right position. (Touch the micro switch.)

Graph 13-1 For error code E07: Check if the micro switch is broke.
Graph E08 Micro switches are abnormal. (Check with electric meter.)
Graph 14 For error code E03, E05: Check the micro switch of lower micro switch with a electric meter or lower motor.
E11. The micro switch of lower mould is not in the right position.

E12. The micro switch of upper mould is not in the right position.
Circuit board wiring Diagram (forty-four feet) for ET-999S sealing machine

System error codes:

<table>
<thead>
<tr>
<th>Code</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>E-AC</td>
<td>Wrong voltage</td>
</tr>
<tr>
<td>E-00</td>
<td>Temperature control system error</td>
</tr>
<tr>
<td>E-01</td>
<td>Heater collector or heating wire error</td>
</tr>
<tr>
<td>E-02</td>
<td>Micro switch of upper mould error</td>
</tr>
<tr>
<td>E-03</td>
<td>Micro switch of lower mould error</td>
</tr>
<tr>
<td>E-04</td>
<td>Sealing film is not in the right position or the eye-marks sensor error.</td>
</tr>
<tr>
<td>E-05</td>
<td>Micro switch of upper mould error</td>
</tr>
<tr>
<td>E-06</td>
<td>Micro switch of upper mould error</td>
</tr>
<tr>
<td>E-07</td>
<td>Safety door is crashed</td>
</tr>
</tbody>
</table>

E-16: The parameter is out of range
E-17: The parameter is not detected
E-18: The parameter is not loaded
E-19: P.C. board error
E-20: Short of DC12V(short of in-out sensor)

Digital switch(1.2): To roll the film before sealing, when it is "ON". To roll the film after sealing, when it is "OFF".
Circuit board wiring Diagram (forty-four feet) for ET-899S sealing machine

### Item | Digital Switch | Parameter Setting
--- | --- | ---
**S1** (SW1 · SW2) Control for input | SW1 + SW2 : OFF | 0 sec
| SW1 : ON | 0.3 sec
| SW2 : ON | 0.6 sec
| SW1 + SW2 : ON | 0.9 sec
**S1** (SW3 · SW4) Choice for film rewinding | SW3 : ON | Jog for 0.3 Sec after sealing
| SW4 : ON | Rolling film first as "OFF". Rolling film late as "ON".
| SW2 : ON | Test for film rewinding 0.5 sec
**S2** (SW2) Test for film rewinding | SW2 : OFF | Be "OFF" as usual
**S2** (SW1 · SW3 · SW4) Control for sealing time | SW1 · SW3 · SW4: OFF | 0.1 sec Upper mould turns a circle
| SW1 : ON | Pressing 0.3 sec
| SW3 : ON | Pressing 0.6 sec
| SW4 : ON | Pressing 0.9 sec
| SW1+SW3: ON | Pressing 0.9 sec
| SW1+SW4: ON | Pressing 1.2 sec
| SW3+SW4: ON | Pressing 1.5 sec
| SW1 · SW3 · SW4:ON | Pressing 1.8 sec

Confidential by Lollicup USA, Inc. - 31 - 2/25/2013
Circuit board wiring Diagram (forty-four feet) for ET-58S sealing machine

System error codes:

- **E-AC**: Wrong voltage
- **E-00**: Temperature control system error
- **E-01**: Heater collector or heating wire error
- **E-02**: Micro switch of upper mould error
- **E-03**: Micro switch of lower mould error
- **E-04**: Sealing film is not in the right position or the eye-marks sensor error.
- **E-05**: Micro switch of lower mould error
- **E-06**: Micro switch of upper mould error
- **E-07**: Safety door is crashed

- **E-16**: The parameter is out of range
- **E-17**: The parameter is not detected
- **E-18**: The parameter is not loaded
- **E-19**: P.C. board error
- **E-20**: Short of DC12V(short of in-out sensor)

Digital switch(1.2): To roll the film before sealing, when it is "ON". To roll the film after sealing, when it is "OFF".
## Specification of motor, gear box & capacitance

<table>
<thead>
<tr>
<th>Model</th>
<th>Model name</th>
<th>Standards</th>
<th>Gearbox</th>
<th>110V</th>
<th>220V</th>
</tr>
</thead>
<tbody>
<tr>
<td>ET-8995</td>
<td>Motor for upper mould</td>
<td>4RK25GN-A</td>
<td>4GN-75</td>
<td>12uf</td>
<td>3uf</td>
</tr>
<tr>
<td>ET-995</td>
<td>Motor for lower mould</td>
<td>2RK10GN-A</td>
<td>2GN-90</td>
<td>6uf</td>
<td>1.5uf</td>
</tr>
<tr>
<td>ET-955</td>
<td>Motor for film collector</td>
<td>15rpm/1min</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>ET-585</td>
<td>Motor for upper mould</td>
<td>4RK25GN-A</td>
<td>4GN-60</td>
<td>12-16uf</td>
<td>3uf</td>
</tr>
<tr>
<td>ET-595</td>
<td>Motor for lower mould</td>
<td>2RK10GN-A</td>
<td>2GN-90</td>
<td>6uf</td>
<td>1.5uf</td>
</tr>
<tr>
<td>ET-995 (old)</td>
<td>Motor for film collector</td>
<td>15rpm/1min</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>ET-595 (old)</td>
<td>Motor for upper mould</td>
<td>4RK25GN-A</td>
<td>4GN-75</td>
<td>12uf</td>
<td>3uf</td>
</tr>
<tr>
<td>ET-995 (old)</td>
<td>Motor for lower mould (teeth shape)</td>
<td>2RK6GN-A</td>
<td>2GN-30(10V) 2GN-25(220V)</td>
<td>4uf</td>
<td>1.5uf</td>
</tr>
<tr>
<td>ET-195</td>
<td>Motor for film collector</td>
<td>15rpm/1min</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>ET-195 (old)</td>
<td>Motor for upper mould</td>
<td>4RK25GN-A</td>
<td>4GN-75</td>
<td>12uf</td>
<td>3uf</td>
</tr>
<tr>
<td>ET-195 (old)</td>
<td>Motor for lower mould (teeth shape)</td>
<td>2RK4GN-A</td>
<td>2GN-120</td>
<td>4uf</td>
<td>1uf</td>
</tr>
</tbody>
</table>

※One-Phase motor needs a capacitor to adjust the suitable voltage for the motor.
※Technical staffs must know the standards of the above details.
Tray input sensor • film eye-mark sensor

<table>
<thead>
<tr>
<th>In-out sensor</th>
<th>MR-10NE</th>
<th>Bad at detecting the black containers.</th>
</tr>
</thead>
<tbody>
<tr>
<td>Film sensor</td>
<td>SU-07GB</td>
<td>Good at detecting the black film but bad at detecting the red film</td>
</tr>
</tbody>
</table>

※ film sensor =".green light" ḳ to display red light

※ To display PL (green) lights usual, and to display OP (red) light when detecting the containers.

※ To display both PW (green) and OP (red) light as usual, and to turn off OP (red) light when detecting the eye-marks of containers.

To adjust "strong", "weak" the signals.

Confidential by Lollicup USA, Inc. - 34 - 2/25/2013
## ERROR CODE AND SOLUTION:

<table>
<thead>
<tr>
<th>Code</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>E00</td>
<td>Temperature control system error.</td>
</tr>
<tr>
<td>E01</td>
<td>Heating circuit or temperature wire error.</td>
</tr>
<tr>
<td>E02</td>
<td>Upper motor or micro switch of upper mould error.</td>
</tr>
<tr>
<td>E03</td>
<td>Lower motor or micro switch of lower mould error.</td>
</tr>
<tr>
<td>E04</td>
<td>Sealing film is not in the right position or the eye-mark sensor error.</td>
</tr>
<tr>
<td>E05</td>
<td>Lower motor or micro switch of lower mould error.</td>
</tr>
<tr>
<td>E06</td>
<td>Upper motor or micro switch of upper mould error.</td>
</tr>
<tr>
<td>E07</td>
<td>Safety door is touched or collided.</td>
</tr>
<tr>
<td>E19</td>
<td>PCB error: The main control system of PCB error PCB crashed.</td>
</tr>
<tr>
<td>E20</td>
<td>Short of DC12V.</td>
</tr>
<tr>
<td>Err</td>
<td>Voltage error.</td>
</tr>
</tbody>
</table>
## Maintenance — 2

### ERROR CODE AND SOLUTION :

<table>
<thead>
<tr>
<th>Error Code</th>
<th>Description</th>
</tr>
</thead>
</table>
| 12         | Cannot in-put the containers under Auto setting:  
1. The film sensor of lower mould is too strong or too weak. Please clean the sensor or adjust the degree of sensor.  
2. The black paint on lower mould is peeled off. Please paint it again smoothly. Change a film sensor if above adjustment is useless. |
| 13         | Cannot seal the container smoothly:  
1. Clean up the surface of upper mould.  
2. Defacement of lower mould or silicon rubber.  
3. Deformation of the containers.  
4. To increase the temperature or adjust the time for sealing.  
5. The springs of upper mould is broken, so that the pressure is not at average. (it occurs about sealing 100 thousand times.)  
6. The springs of heater is broken, so that the pressure in not at average. (it occurs about sealing 300 thousand times.)  
The knife of upper mould is stuck. Please ask the technical staffs to clean up the knife. Wrong use of film material: Sealing paper containers with PP film. (WRONG) Sealing Styrofoam containers with ES film. (WRONG) |
| 14         | Film stops before sealing but PCB has no error code:  
1. Clean up the film sensor.  
2. To adjust the degree of the film sensor stronger.  
3. To change a new film sensor as it is broken.  
PCB crashed. |
| 15         | No power of the machine:  
1. Please plug the AC power wire.  
2. The fuse of PCB is broken.  
3. The short terminal of PCB is loosen. |
## ERROR CODE AND SOLUTION :

<table>
<thead>
<tr>
<th>Error Code</th>
<th>Description</th>
</tr>
</thead>
</table>
| 16         | Wrong position of the containers:  
To use lubricant on slide and jump rod everyday. |
| 17         | Cannot cut down the film:  
1. To clean the surface of the upper mould.  
2. Please ask the technical staffs to clean up the knife of upper mould.  
3. Defacement of lower mould or silicon rubber.  
4. Adjust the depth of pressing for upper mould.  
5. The springs of upper mould is broken, so that the pressure is not at average.  
6. The PET film is too thick to cut down.  
7. The knife of upper mould is not sharp enough or broken. |
| 18         | The lower mould lodge when sealing was finished:  
The micro switch is stuck by fructose. Please clean up the switch. |
| 19         | Shortage of voltage:  
1. The extended line is too thin.  
2. Conjoint with too many other electric machines for one extended line. |
| 20         | The safety door is crushed by the containers while sealing:  
1. The jack rod collide with the inner edge of lower mould.  
2. Clean up the jump rod/bar and use lubricant on it.  
3. Change a new spring of jump rod as it is broken. |
| 21         | The film is not in the right position or turning around and around:  
Please avoid to put the sealing machine under the sunshine directly, or it would cause the misunderstanding of in-put and film sensor. |
### 12) RELATIONSHIP AMONG MACHINE, FILM, AND CONTAINER

<table>
<thead>
<tr>
<th></th>
<th>ES Film</th>
<th>PP Film</th>
<th>PE Film</th>
<th>PS Film</th>
<th>Pool</th>
</tr>
</thead>
<tbody>
<tr>
<td>PP containers</td>
<td>○</td>
<td>○ 160-180℃</td>
<td>×</td>
<td>×</td>
<td>160-170℃</td>
</tr>
<tr>
<td>Styrofoam containers</td>
<td>○</td>
<td>×</td>
<td>×</td>
<td>△</td>
<td>×</td>
</tr>
<tr>
<td>Paper containers</td>
<td>○</td>
<td>×</td>
<td>×</td>
<td>○ 135-150℃</td>
<td>×</td>
</tr>
<tr>
<td>PS containers</td>
<td>△ 150-165℃</td>
<td>×</td>
<td>×</td>
<td>○ 150-165℃</td>
<td>×</td>
</tr>
<tr>
<td>PET containers</td>
<td>△ 120-140℃</td>
<td>×</td>
<td>×</td>
<td>×</td>
<td>×</td>
</tr>
</tbody>
</table>

#### Recognition for containers

<table>
<thead>
<tr>
<th>Item</th>
<th>Recycling Signs</th>
<th>Caliber</th>
<th>Characteristic</th>
</tr>
</thead>
<tbody>
<tr>
<td>PP containers</td>
<td></td>
<td>95、75Φ</td>
<td>Polypropylene, heat-resistant for 20-140℃ Tireless, light, bright, renitent, tear-resistant, heat-resistant, burning-nontoxic, non-smell, non-smoke</td>
</tr>
<tr>
<td>Styrofoam containers</td>
<td></td>
<td>95Φ</td>
<td>Polystyrene, heat-resistant for 75-95℃ light, easy-broken, good for keeping warm, heat insulation, cannot use in sour drink (would cause poisons), easy to be burn and cause smoke and smell</td>
</tr>
<tr>
<td>Paper containers</td>
<td></td>
<td>95、94Φ, 90、78Φ</td>
<td>heat-resistant for 80-100℃ light, not heat-resistant, easy broken by liquid, not plastic container, can be recycle and reuse, less damage of environment</td>
</tr>
<tr>
<td>PS containers</td>
<td></td>
<td>95Φ</td>
<td>Polystyrene, heat-resistant for 75-95℃ light, bad elasticity, easy-broken, cause smell while sealing, easy to be burn and cause smoke and smell</td>
</tr>
<tr>
<td>PET container</td>
<td></td>
<td>95Φ</td>
<td>Telephthaloyl chloride, heat-resistant for 50-60℃ light, limpid, firm, not heat-resistant, sour-resistant and salt-resistant, can be recycle and reuse</td>
</tr>
</tbody>
</table>