

RS-140 Operation Procedures.



Manual must be read and understood before any operation of this machine.

Installation:

Remove the machine from packing crate or skid. Check machine to make sure there is no damage from shipping; if there is damage report it to the carrier immediately.

Install four locking casters by setting stand in a horizontal position then set vertical and mount sealer by engaging mounting pin at the back of sealer onto slot on stand. (See diagram A)

Adjust appropriate height on sealer by turning hand crank on stand. (Ref C)

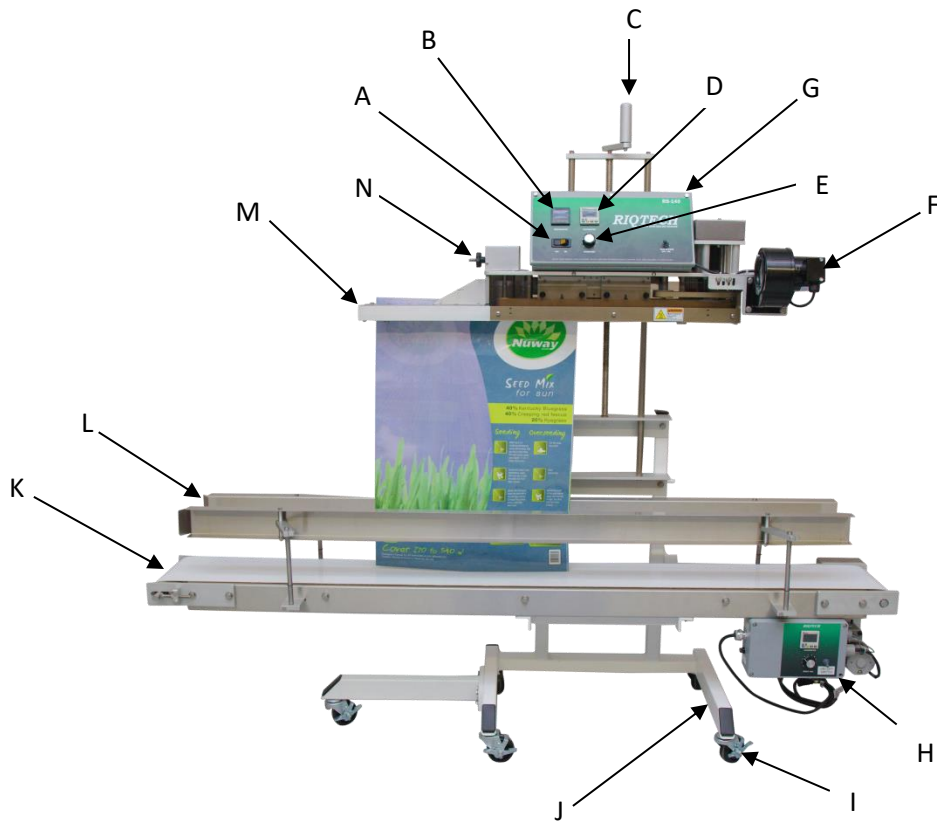
OPERATION

Plug the electrical cord into required voltage for machine.

See back panel of machine for voltage requirement.

Turn on machine by using rocker switch on the front panel (see A) the light on rocker switch will light up. Set motor speed to 30 FPM by turning speed dial clockwise the tachometer will display actual speed in feet per minute (Ref D&E). Use up/down arrow key on temperature controller to set temperature (Ref B) for a 2 mill poly bag start off by setting temperature to 130 degree Celsius and wait approximately three minutes for temperature to stabilize. Start off by doing some sample test by feeding one or two bags through the sealer then do a pull test on bags to test seal.

For sealer with conveyor speed on tachometer **must** match in order for speed to synchronize.



A: Sealer Main Switch

B: Temperature Controller

C: Hand Crank

D: Tachometer (Speed Display in Feet Per Minute)

E: Speed Dial

F: Trim Blower

G: Sealer Control Box

H: Conveyor Control Box

I: Casters (4) + (1) for 8.5" x 6' conveyor

J: Stand

K: Conveyor

L: Conveyor Guide Rails

M: Sealer In-feed Rails

N: Teflon belt / sealing belts adjustment knob

SEALER BOTTOM VIEW

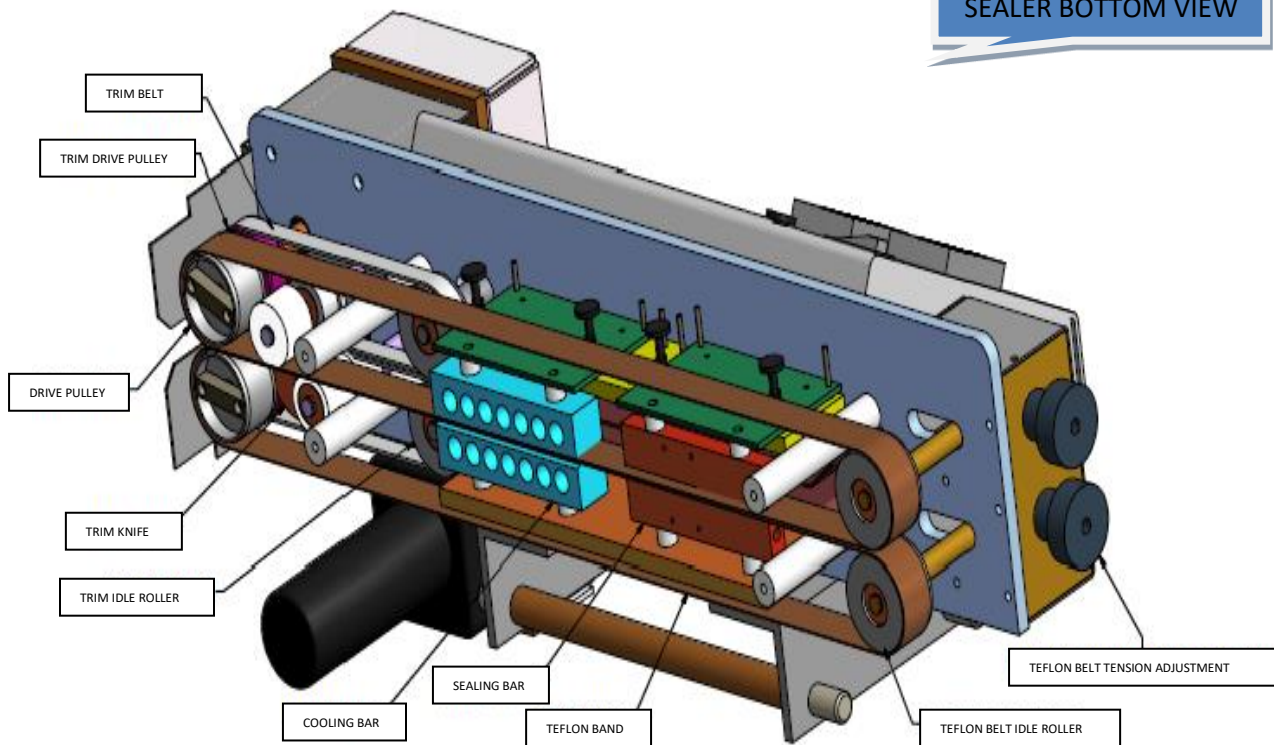


DIAGRAM C

Note: Setting the correct temperature is very important since too much heat will weaken the material below and above the seal and insufficient heat will result in a weak seal.

Seals are made as the material is sandwich between two Teflon coated belts and conveyed through the heating and cooling section of the machine. Each of these sections consists of one fixed side and one spring loaded side. This allow for the gauge variation in material. The spring tension is set at the factory to suit most sealable bags, However if needed to make adjustment, it can be done by turning the black thumb knobs clockwise to increase pressure an counter clockwise to decrease pressure (Ref P).

Feeding the bags through the machine by setting the top of the bag at least one inch in from the top of the in-feed rails (see D). For thinner material feed the leading edge of the bag into the sealer and lightly hold onto the trailing edge of the bag this is done to avoid bunching or creasing of the material as it enter the sealer.

Please be careful when changing sealing bands not to make contact with heating bars especially when machine is in operation. Make sure band are tension correctly if there are too tight they will break and if too loose they will slip, tension enough so it can convey material through the sealer.

INSTALLING SEALER ON STAND

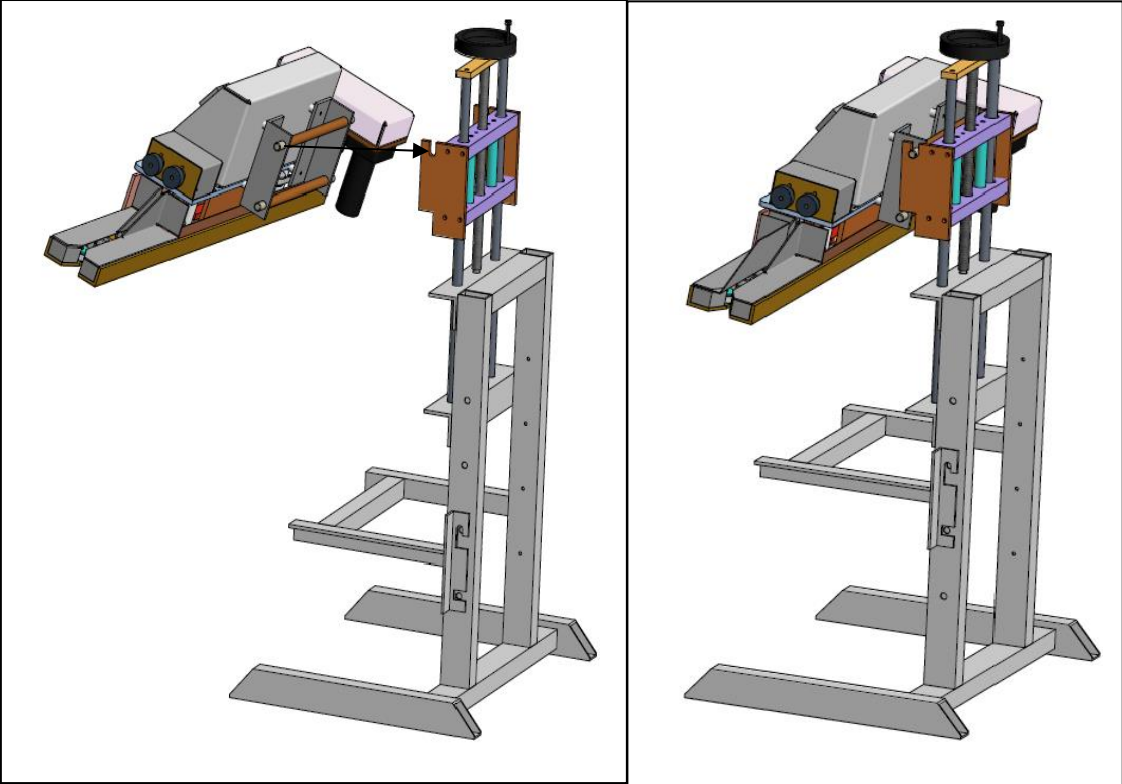


DIAGRAM A

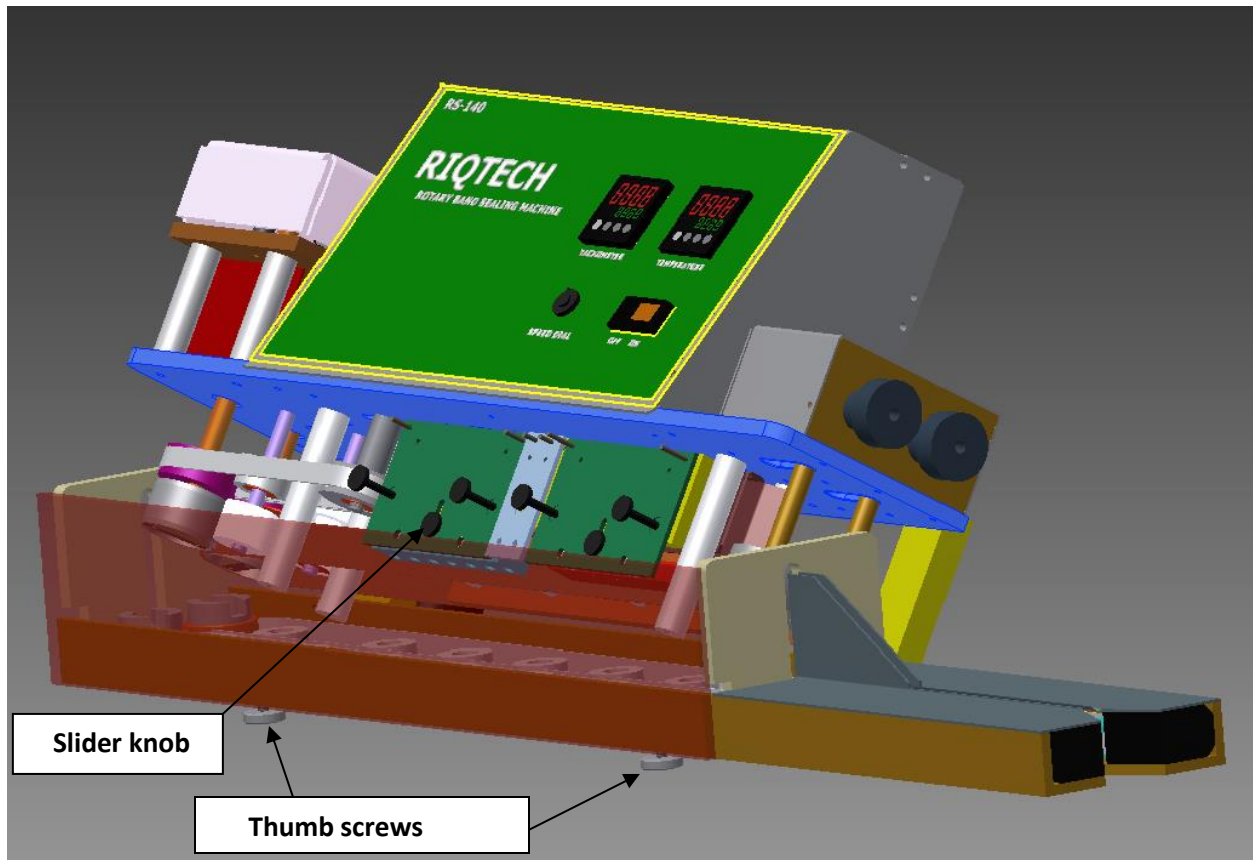


DIAGRAM B

REPLACING TEFLON BANDS.

Power off machine , drop sealer in-feed rails by undoing two thumb screws located at the bottom of rails (see diagram B) then turn tension adjustment knob counter clockwise, one full turn should be enough to get Teflon bands around drive and tension roller.

Slightly lift spring loaded cooling and heating plate while pushing slider knob upwards to create gap to change Teflon bands, Place new Teflon band around drive pulley and slide band between heating and cooling bars then place band around tension roller, Turn adjustment knob clockwise to tension band. Correct adjustment is very important. If the bands are too loose they will slip and if they are too tight they will break.

When finish slightly lift cooling and heating plate while pushing slider knob downwards to normal position. (video tutorial available online)

REPLACING TRIM KNIFE. (Unplug machine)

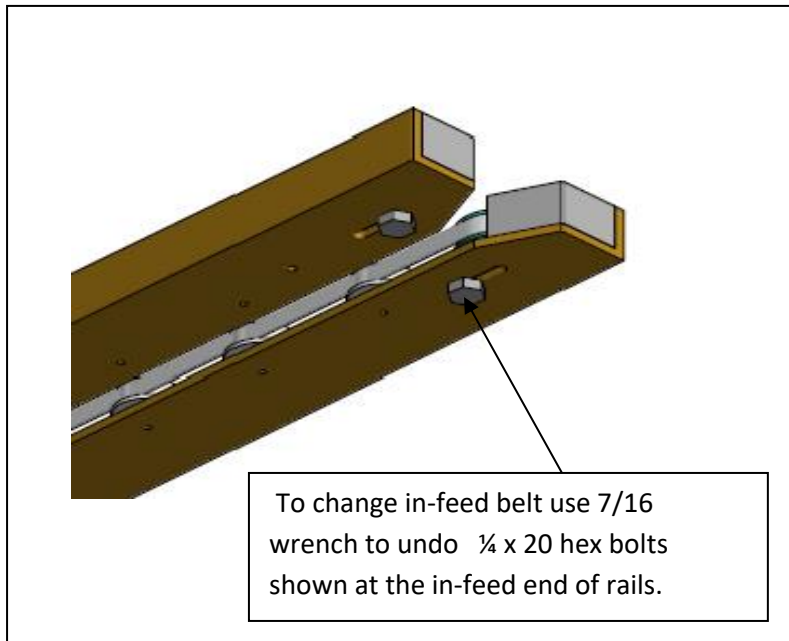
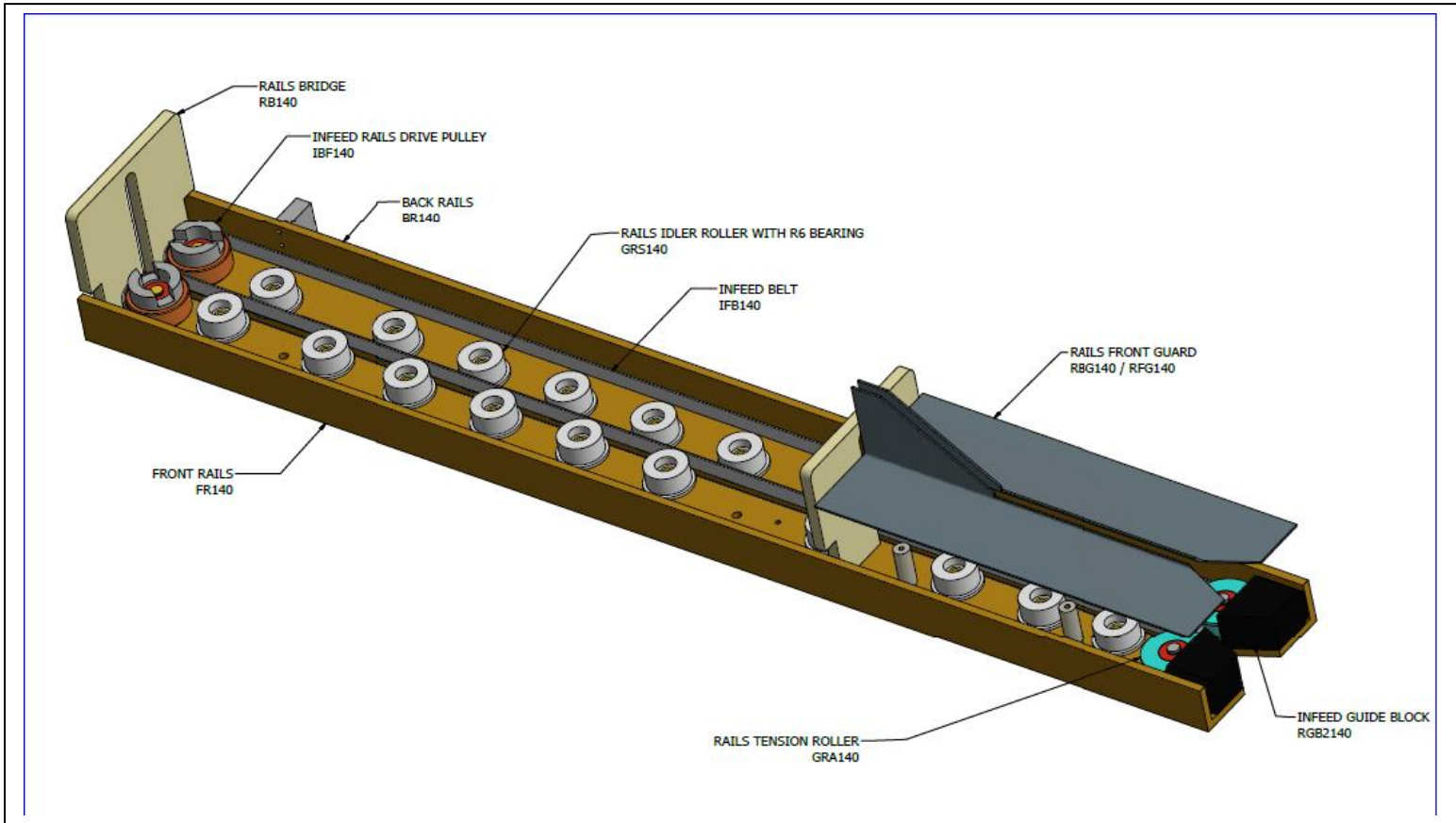
Power off machine , drop sealer in-feed rails by undoing two thumb screws located at the bottom of rails (see diagram B) then turn tension adjustment knob counter clockwise, one full turn should be enough to loosen teflon bands.

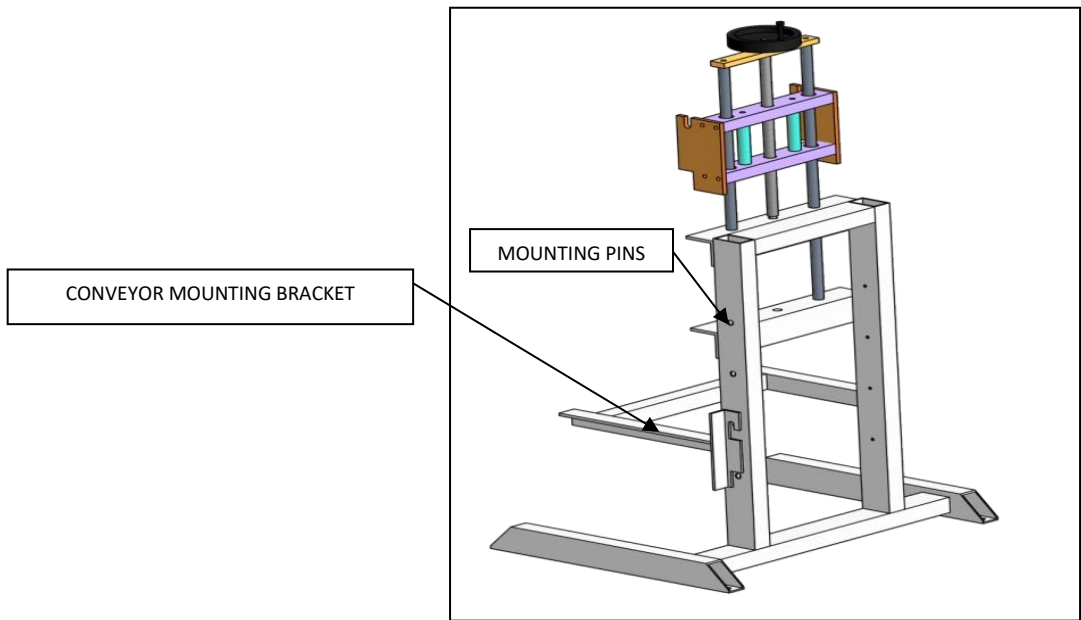
(See diagram B) Trim Knife is located at the rear exit end of the sealer, To change knife use a Phillips screw driver to undo pan head screw that hold knife in place, gently remove knife and replace with new one. (use extra caution when changing knife)

REPLACING TRIM BELT.(Unplug Machine)

Trim belt is located at the exit end of the sealer above Teflon bands (See diagram C)

To replace trim belt you will need to drop in- feed rails, take off teflon bands and trim knife. Open front cover on sealer and use a ½” wrench to loosen trim belt tension roller bolt located inside the control box, then slide tension roller back and install new trim belt , to tension trim belt, push tension roller towards in-feed end and tighten bolt. (See diagram D)





TO ADJUST CONVEYOR HEIGHT REQUIRE 2 PERSON LIFT UP AND OUT THEN MOVE BRACKET TO REQUIRE HEIGHT MOUNTING PINS

