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CLIENTE	_____
MACHINE	<b>Fully Automatic rotary wheel side seal</b>
MODEL	<b>PP 50 BM</b>
SERIAL	_____
POWER	<b>220 Volt , 1 Phase, 20 Amp</b>
AIR	<b>1 CFM @ 80 PSI</b>
MACHINE DIMENSIONS	<b>97”L x 47”W x 65”H</b>
INFEED DIMENSIONS	<b>76”L x 42”W x 33”H</b>
MACHINE WEIGHT	<b>2,500 lbs</b>



## IMPORTANT-PLEASE READ THIS CAREFULLY

The development of a good safety program, that is rigidly enforced, is absolutely imperative when involved in the operation of industrial equipment. Our machinery is well designed and includes extremely important safety features. The part you the user play through proper installation and maintenance procedures is of far greater significance than our designs. Only properly trained individuals following rigidly enforced safety rules, as recommended by A.N.S.I. and O.S.H.A., should be allowed to operate these machines.



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### **Important Notice**

All PP 50 BM series machines are equipped with a buck boost transformer. This will eliminate any problems you may experience as a result of low voltage

Prior to turning on the machine check voltage to make sure you have a solid ground. Test each leg to ground- you should have 110 to 120 volt to the ground.

Minimum air pressure required is 80psi.

Check you air compression line to make sure you supply clean & dry air to machine

If you have water in you lines you may cause premature damage to you machine. Install dryer on air line if required to supply clean and dry air to machine.

### **Important Notice**

Due to the servo technology used on your Preferred Packaging PP 50 BM series machine all measurements used to set up you machine are done in millimeters not inches.

1 inch = 25.4mm

6 inches = 152mm

12 inches = 305mm

18 inches = 457mm

24 inches = 610mm

Conveyor speeds (machine speed) are measured in meters.

1 meter = 40”(3ft 4inches)

Please remember these figures when setting up machine for package length and conveyor speeds.



## UNPACKING

### THOROUGHLY INSPECT EQUIPMENT UPON ARRIVAL

If goods are received short or in a damaged condition, it is important that you notify the carrier's driver **before he leaves your company** and **insist** on a notation of the loss or damage across the face of the freight bill. Unless this is done, no claim can be enforced against the transportation company.

If concealed loss or damage is discovered, notify the carrier at once and **insist** on an inspection. This is absolutely necessary! A concealed damage report must be made no later than ten (10) days from the date the shipment was delivered. Unless you do this, the carrier will not consider any claim for loss or damage. The carrier's agent will then make an inspection and grant a concealed damage notation. If you give the transportation company a clear receipt for the goods that have been damaged or lost in transit, you do so at your own risk and expense.

All claims must be filed within six (6) months of delivery date or carrier will not accept them.

Preferred Packaging is willing to assist in every possible manner to collect claims for loss or damage; however, this does not hold Preferred Packaging responsible for collection on claims or replacement of material.



## **IMPORTANT WARRANTY NOTICES**

### **OPERATING AND MAINTENANCE MANUAL**

The operating and maintenance manual has been carefully prepared to provide the user with all the information needed to properly install, operate, and maintain your Preferred Packaging equipment.

Please read this manual carefully and refer to it for information on the care and use of your Preferred Packaging equipment. It is recommended that additional copies be ordered for use by production, maintenance, and supervisory personnel. Although the design of this equipment incorporates safeguards to protect personnel, care should be used in operating, adjusting, and servicing.

Attention is directed to the warranty that accompanies all your Preferred Packaging equipment. The terms and conditions of this warranty apply only to unmodified units. **Any unauthorized modifications to the equipment automatically voids this warranty.**



## **PREFERRED PACKAGING SYSTEMS**

### **WARRANTY**

Preferred Packaging Systems, Inc. warrants each new product manufactured to be free from defects in material and workmanship for a period of (1) year from date of shipment by Preferred Packaging.

This warranty is not transferable with any subsequent resale.

Defective parts under warranty must be returned to Preferred Packaging freight prepaid. Preferred's sole obligation and purchaser's sole remedy in the event of a warranty dispute shall be, at Preferred's opinion, to repair or replace the part in question. Labor incurred in removing or installing the defective part is not covered by this warranty. Prior to returning any parts for any reason, contact Preferred Packaging for a Return Authorization Number. This number must accompany all returns.

This warranty shall not apply if equipment has been tampered with, misused, improperly installed, altered, or has received damage due to abuse, carelessness, accident or failure to follow recommended regular maintenance procedures or has been serviced by someone other than a duly authorized factory representative without the express written consent of Preferred Packaging Systems, Inc.

This warranty is in lieu of all other warranties, expressed or implied, including but not limited to warranties of merchantability and fitness for a particular purpose, non-infringement or any other matter.

Preferred Packaging shall have no liability to any person for direct, indirect, incidental or consequential damages or delay resulting from any defect negligence, or tort and customer hereby waives for itself any and all claims for punitive damages and all claims of negligence of strict liability or both. In no event shall our liability exceed the purchase price of the product that was actually paid.



Preferred Packaging reserves the right to make changes, additions, or improvements to our products with no obligation to make such changes in any previously shipped product covered by this warranty.

Preferred Packaging shall not be held liable for any damages arising out for nor in connection with the operation of the equipment should customer or its agent fail to maintain equipment in safe operating condition. This warranty shall become unenforceable if and to the extent the customer or its agent remove, disconnect, or otherwise render useless any safety device and or parts designed or affixed by us or fails to maintain and service equipment in a manner as advised.

Preferred Packaging provides a one-year warranty on parts, excluding shipping or freight costs for replacement parts. All warranty parts are shipped F.O.B. San Dimas, California. Service Labor to install part is not covered under warranty.



## **WARRANTY EXCEPTIONS**

The following parts are an exception to the general warranty list on page 10. Each part listed below shall carry a 30-day warranty unless designated otherwise.

### PP 50 BM Series

1. Conveyor Belt
2. Fuses

The following sealer parts are considered to be consumable and not under warranty:

1. Silicone Sponge
2. Teflon Tapets



## **WARNINGS**

Every effort has been taken to ensure your safety while operating this machine; however, there still remain certain risks. Do not allow this machine to be operated before informing all personnel of the following warnings.

### **WARNING.....**

Do not tamper with the electrical wiring. Only use a licensed electrician for maintenance. Always disconnect the electrical power before attempting any maintenance to all electrical and/or moving parts.

### **WARNING.....**

In order to prevent injury to personnel and/or machinery DO NOT INCREASE SETTINGS OR RATINGS ON EITHER ELECTRICAL OR MECHENICAL OVERLOAD SAFETY DEVICES.

### **WARNING.....**

KEEP HANDS AWAY FROM MOVING CONVEYORS AND ASSEMBLIES. Conveyor belts that have become worn or frayed are capable of being hazardous. They should be replaced promptly.

### **WARNING.....**

NEVER OPERATE THIS OR ANY MOVING EQUIPMENT WITHOUT ALL CONVERS AND GUARDS IN PLACE. The internal mechanism of most packaging machinery contains numerous shear, pinch, and inrunning nip points, many of witch are capable of causing severe injury and/or permanent disfigurement.

### **WARNING.....**

To minimize the potential for personnel injury, always be sure that machine operators and others working on the machinery are properly trained in the correct usage of the equipment and properly instructed regarding the safety procedures for operation.

**WARNING.....**

Heat sealing arms and sealing jaws on packaging machinery can become very warm after a period of use. **KEEP HANDS AWAY WHILE IN OPERATION AND USE CAUTION IF THE MACHINE HAS BEEN RUNNING RECENTLY.**

**WARNING.....**

ANY MODIFICATIONS TO EITHER THE ELECTRICAL CIRCUITRY OR THE MECHANICAL ASSEMBLIES OF THE MACHINERY WILL VOID ANY WARRANTIES ASSOCIATED WITH THIS EQUIPMENT. Such modifications may introduce hazards that would not otherwise be associated with this machinery. Preferred Packaging will not be responsible for any consequences resulting from such unauthorized modifications.

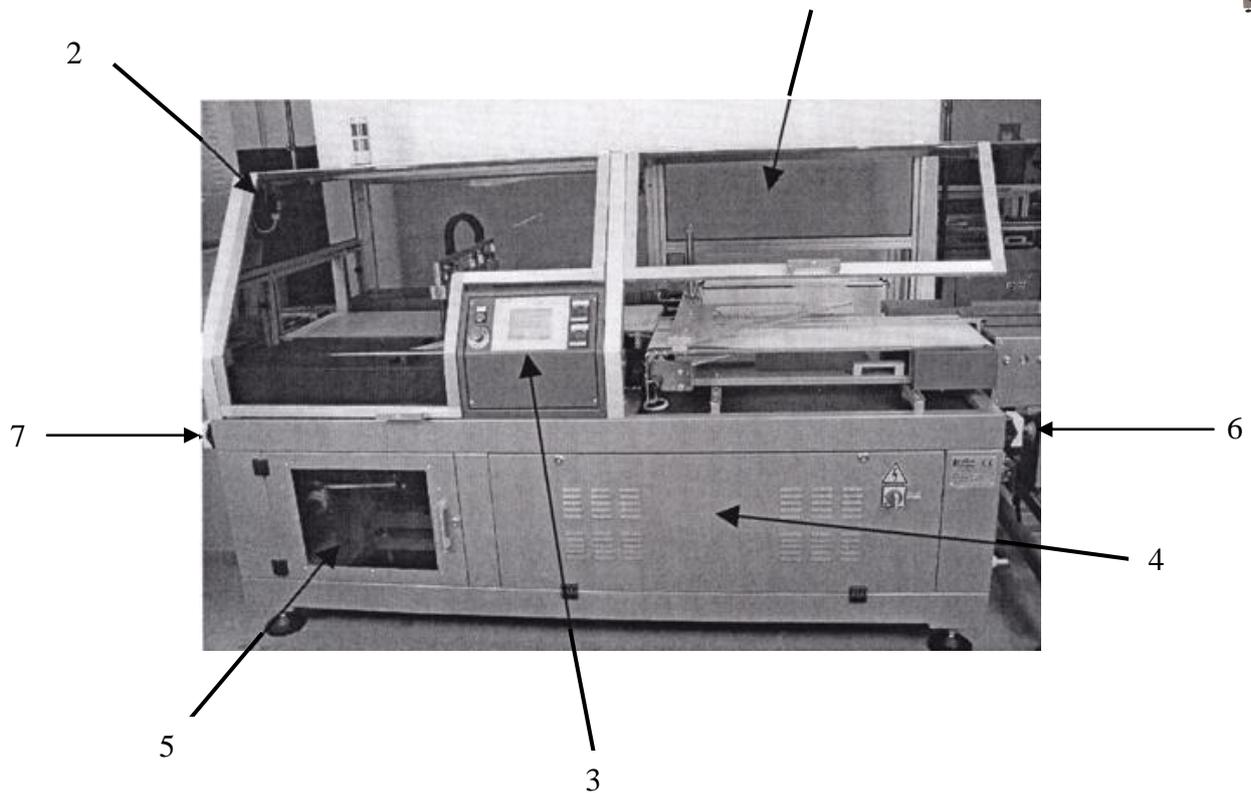
**WARNING.....**

The use of certain types of plastic films in sealing and/or shrinking equipment may result in the release of **HAZARDOUS FUMES** due to the degradation of the film at high temperatures. Before using any plastic film in this equipment, the manufacturer or supplier of the film should be contacted for specific information concerning the potential release of hazardous fumes. **ADEQUATE VENTILATION MUST BE PROVIDED AT ALL TIMES.**

**WARNING.....**

It is important that the machine operator turn off the Main Power Switch when he/she has finished operating the unit.

**Machine Overview**  
**PP 50 BM Front View**

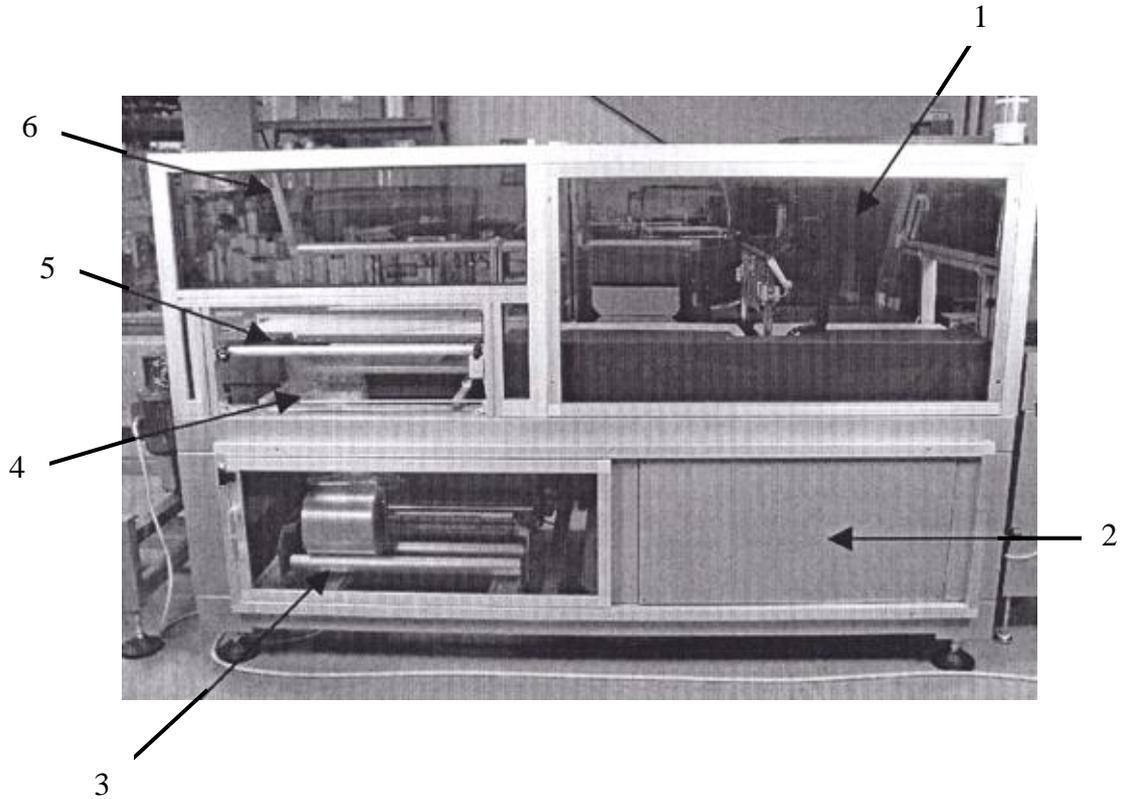


### Description

### Qty

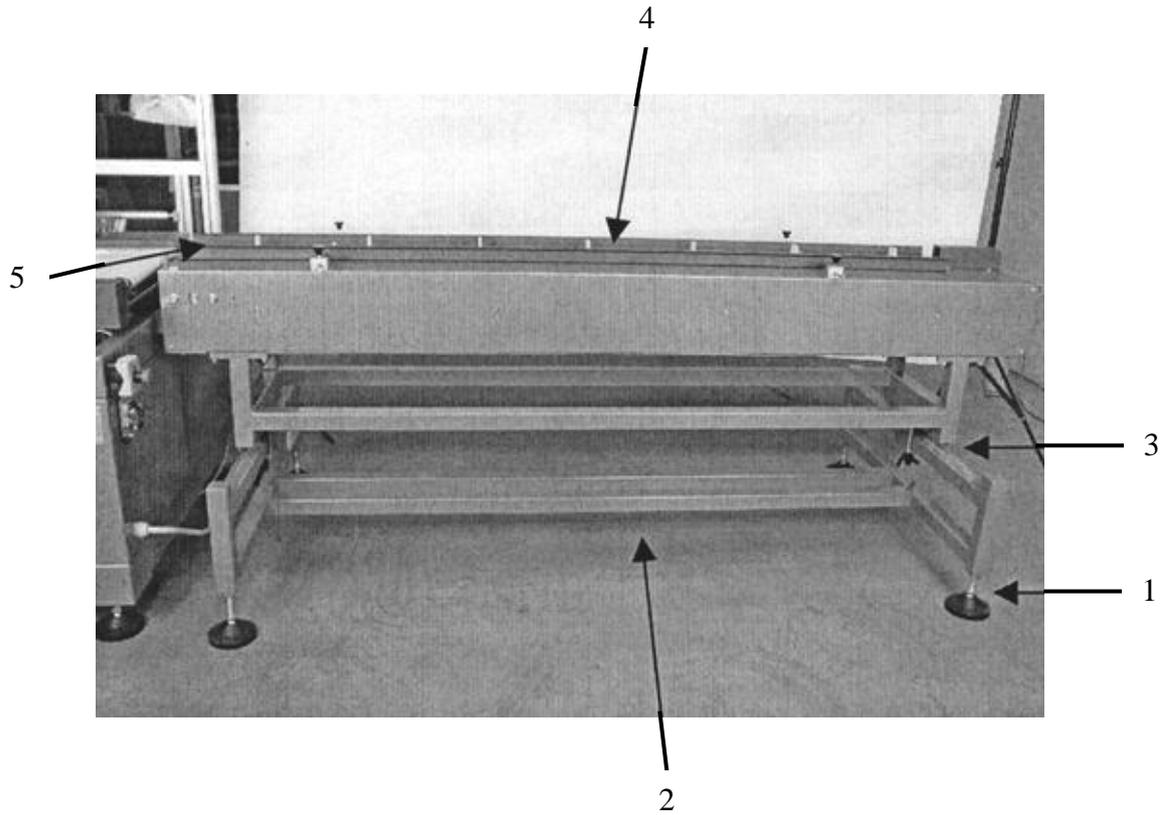
1. Infeed safety cover .....	1
2. Seal area safety cover .....	1
3. Main control panel .....	1
4. Electrical panel hinged door .....	1
5. Film scrap safety door .....	1
6. Emergency stop switch-infeed .....	1
7. Emergency stop switch-discharge .....	1

### **PP 50 BM Rear View**



<u>Description</u>	<u>Qty</u>
<b>1. Rear Lexan cover right side .....</b>	<b>1</b>
2. Rear mechanical access panel .....	1
3. Film safety door cradle .....	1
4. Film separator bar .....	1
5. Adjustable film tracking roller .....	1
6. Rear lexan cover-left side .....	1

**6ft Flighted Infeed**

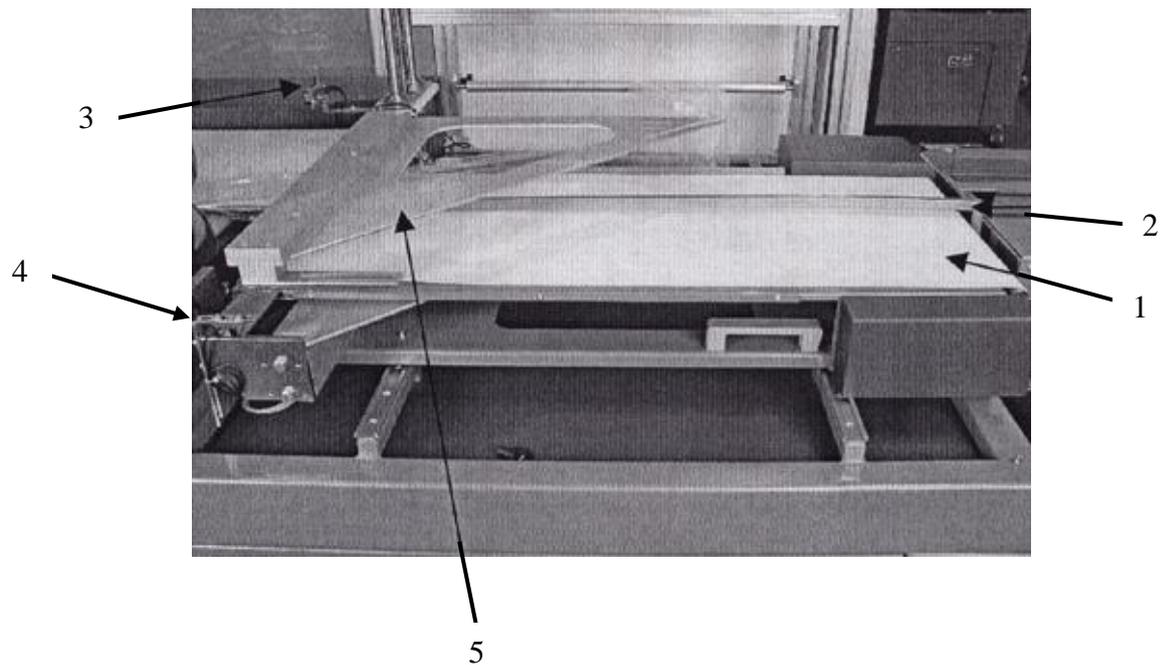


**Description**

**Qty**

1. Adjustable Leveling pad .....	4
2. Base Assembly .....	1
3. Base locking assembly .....	1
4. Plastic flight pusher .....	14
5. Adjustable side guard rails .....	2

**Belted PP 50 BM Infeed Conveyor**

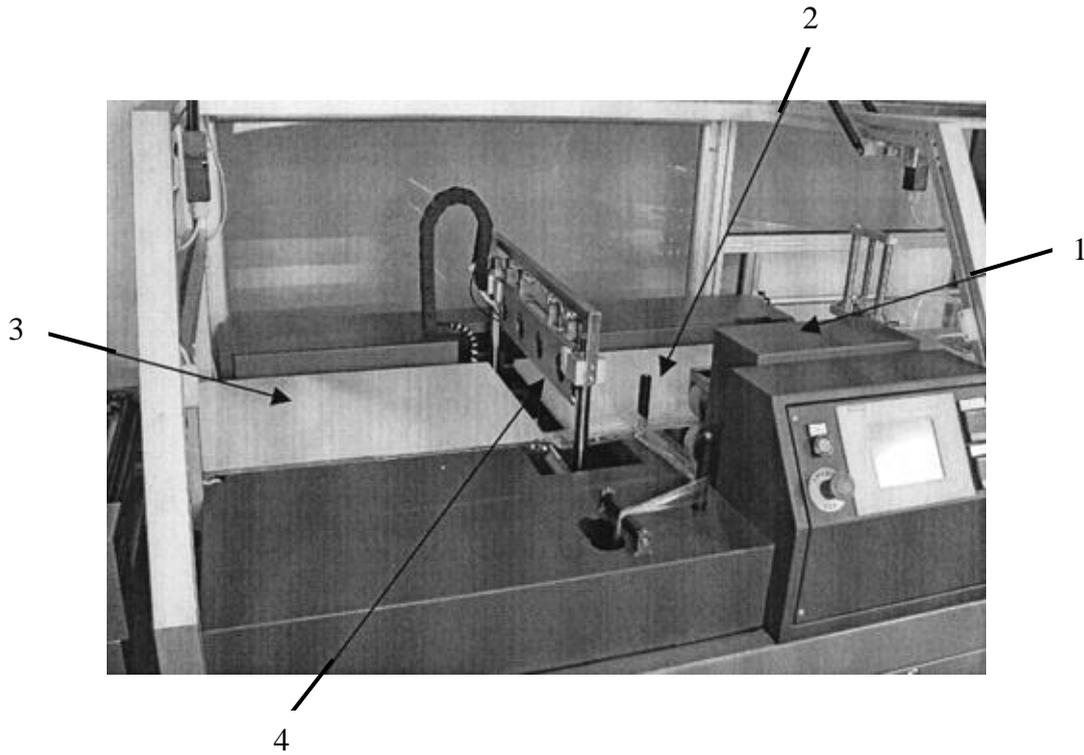


**Description**

**Qty**

1. Infeed Belt .....	1
2. Guide Bar .....	1
3. Vertical photo eye .....	2
4. Horizontal photo eye .....	2
5. Adjustable inverting triangle .....	1

**PP 50 BM Seal Area Assembly**



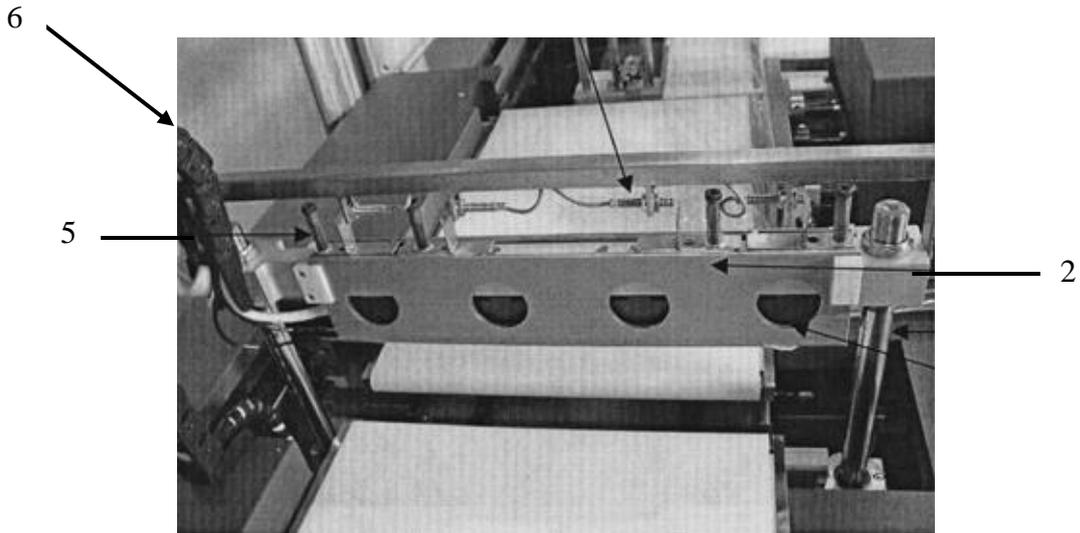
**Description**

**Qty**

1. Side seal assembly .....	1
2. Infeed belt-left side .....	1
3. Discharge conveyor .....	1
4. Hot knife seal head assembly .....	1

**PP 50 BM Seal Head Assembly**

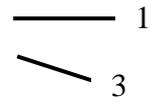




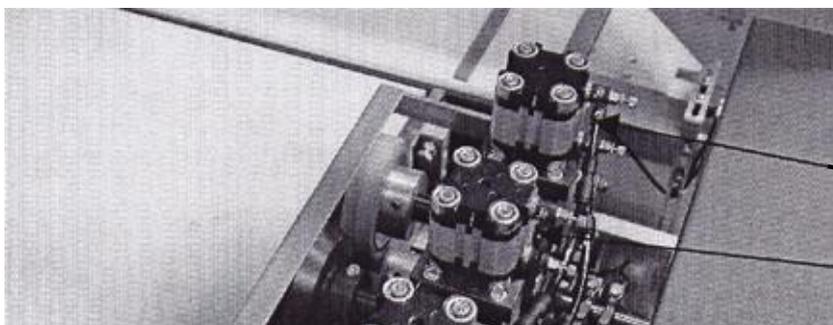
**Description**

**Qty**

1. Main shaft .....	2
2. Film Clamps .....	2
3. Seal bar .....	1
4. Safety sensors .....	4
5. Shoulder bolts with springs .....	4
6. Flexible wiring harness .....	4



**PP 50 BM Side Seal Assembly**



1  
 ic rotary wheel side seal PP 50 - BM



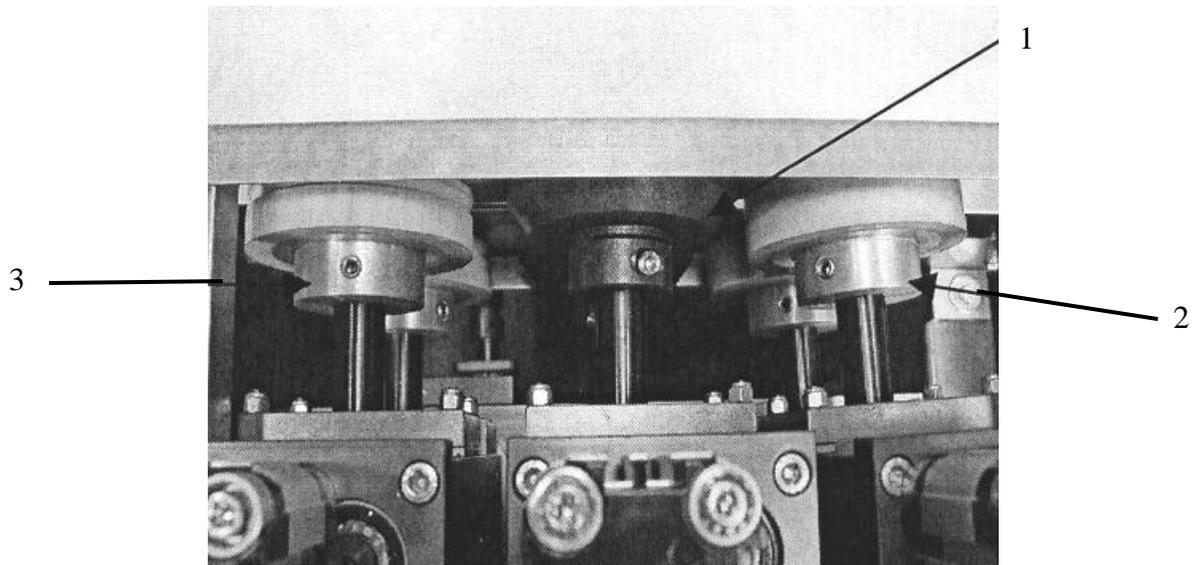
2

3

**Description**

**Qty**

1. Pneumatic Cylinder .....	1
2. Pneumatic Cylinder .....	1
3. Pneumatic Cylinder .....	1



1. Side seal wheel .....	1
2. Infeed film drive roller .....	1
3. Discharge drive roller .....	1

**PP 50 BM Film Cradle Assembly**

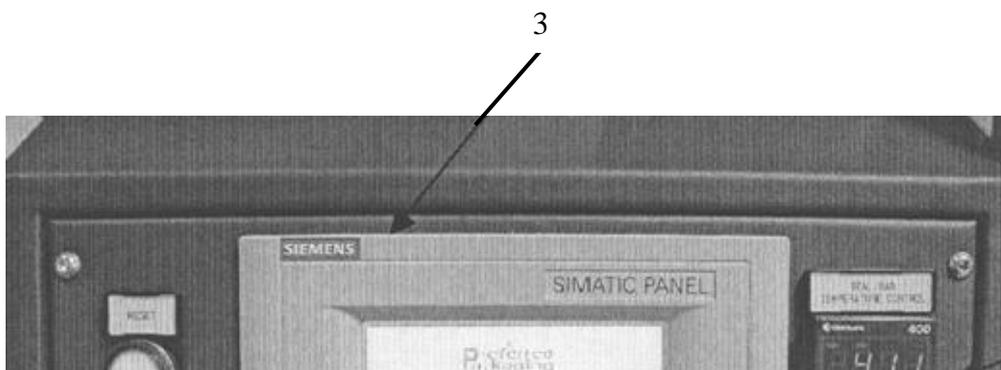


Side seal wheel side seal PP 50 - BM



<u>Description</u>	<u>Qty</u>
1. Film cradle rollers .....	2
2. Film roll guides .....	2
3. Pin perf roller assembly .....	2
4. Film drive rollers .....	2
5. Dancer roller .....	1
6. Pneumatic drive roller release switch .....	1

**PP 50 BM Front Control Panel**

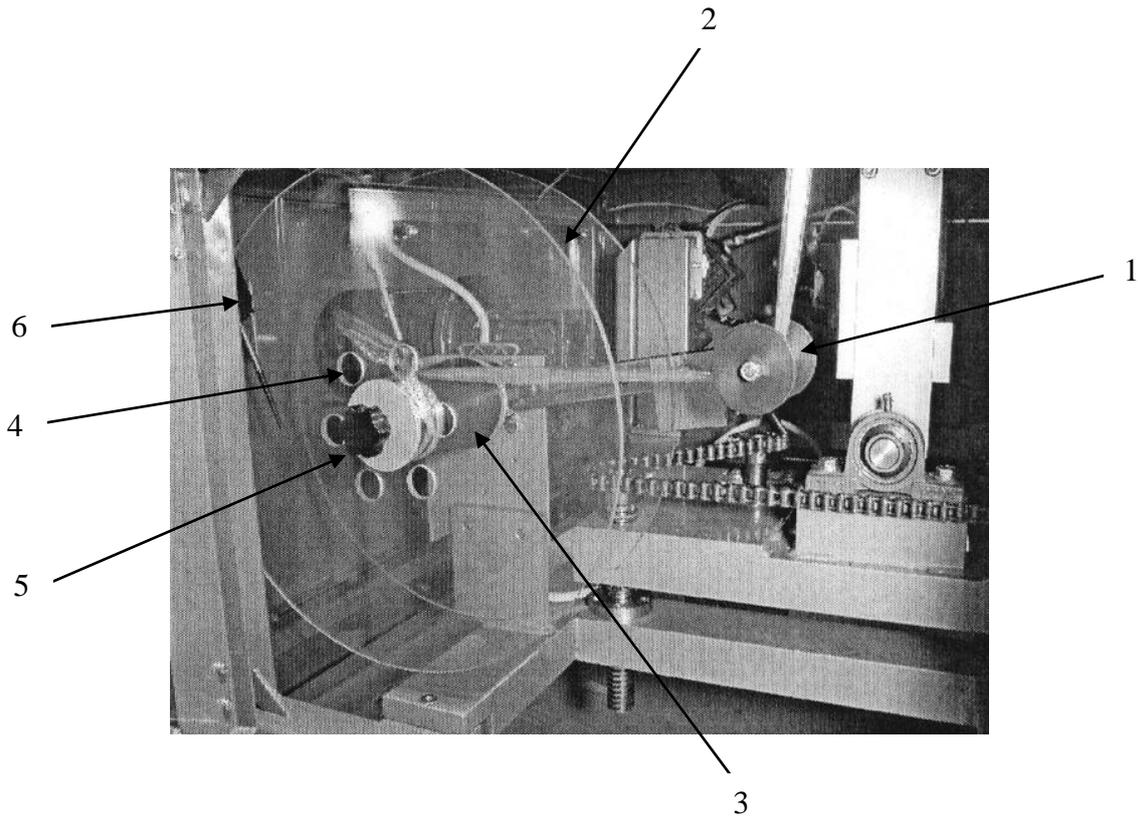


4  15  2**Description****Qty**

1. Seal bar temp control .....	1
2. Side seal temp control .....	1
3. Siemens PLC control .....	1
4. Reset switch .....	1
5. Emergency stop switch .....	1



## PP 50 BM Film Scrap Take Up Reel



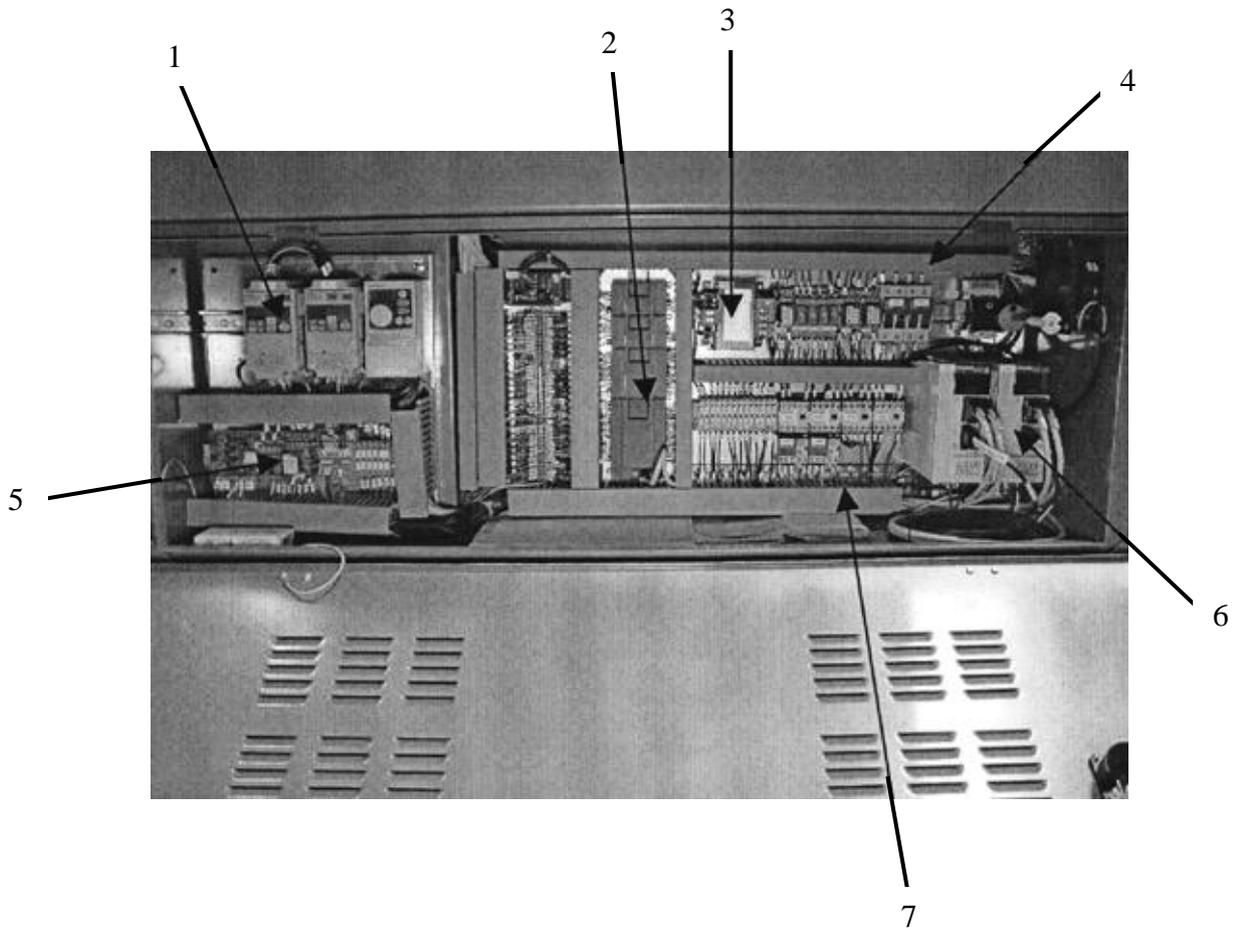
### Description

### Qty

1. Dancer bar .....	1
2. Lexan covers .....	2
3. Tapered center cone .....	1
4. Washer .....	1
5. Tension knob .....	1
6. Scrap full alarm .....	1



**PP 50 BM Electrical Control Panel-Details**



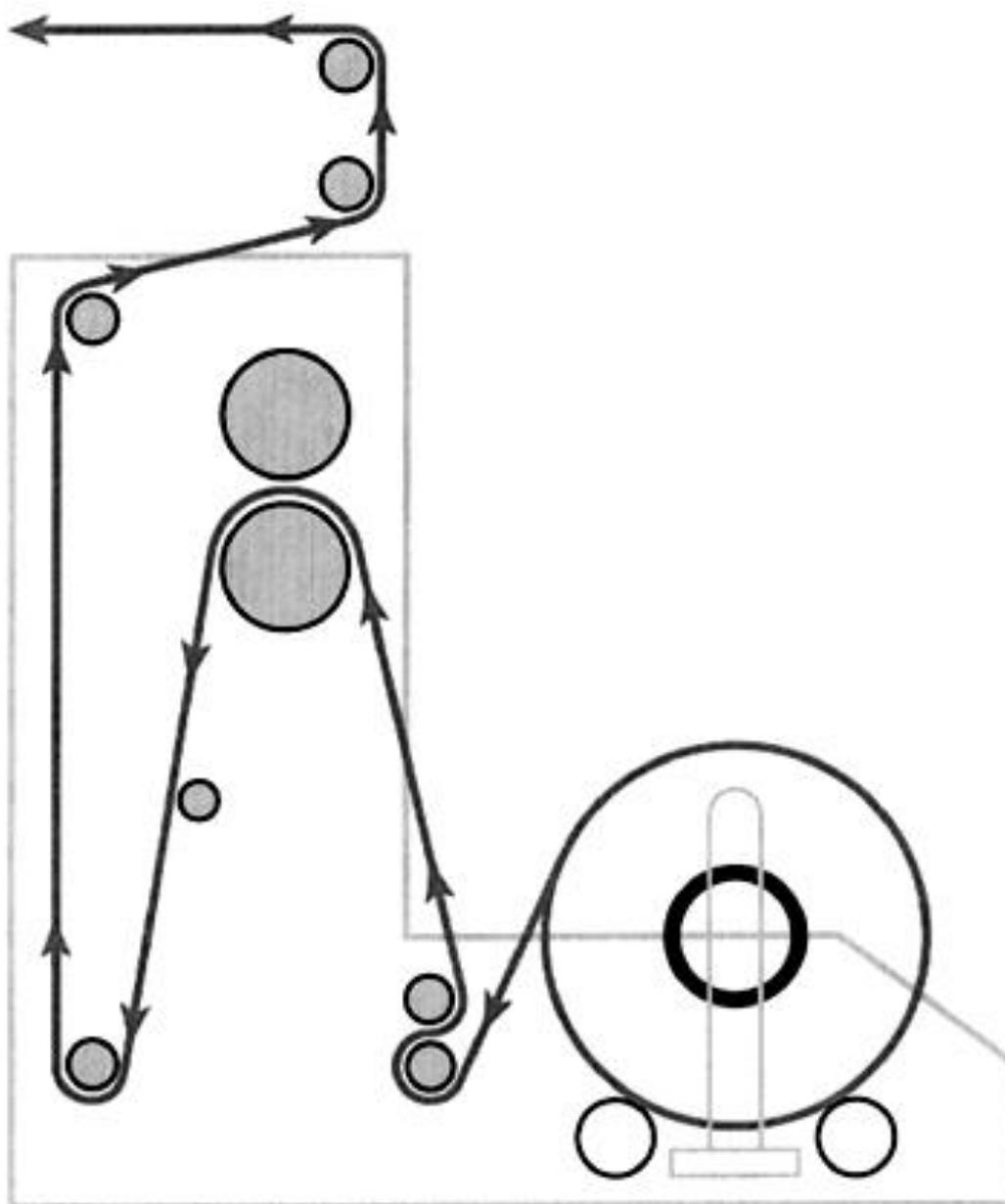
**Description**

**Qty**

1. Omron AC Invertors .....	2
2. Siemens PLC .....	1
3. Transformer .....	1
4. Fuses .....	4
5. Control Board .....	1
6. Servo drive .....	2
7. Solid state contactors .....	4

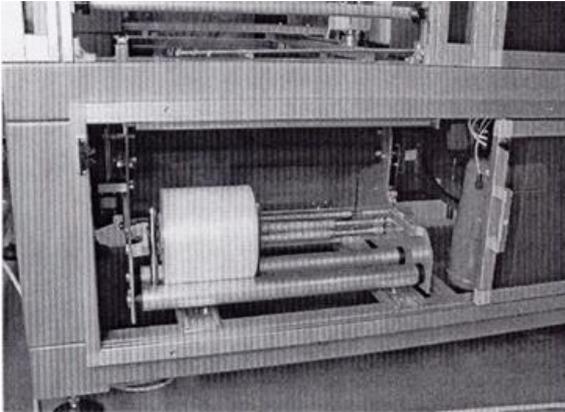


### PP 50 BM Film Threading Diagram

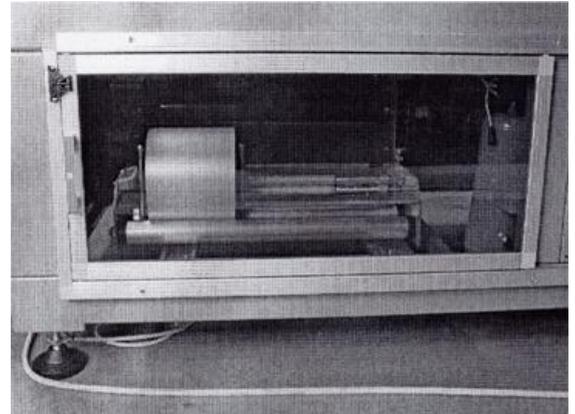




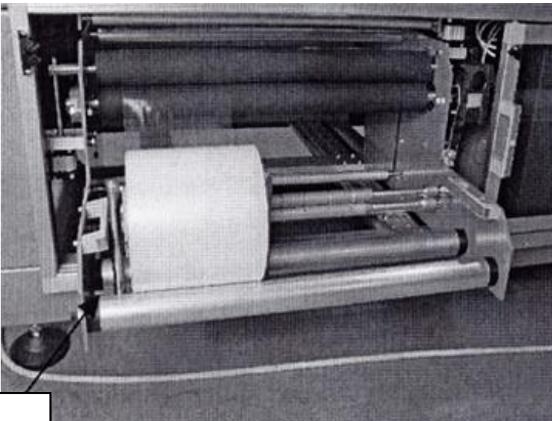
## Mounting Film Roll



**1. Open back cover that encloses film roll cradle.**

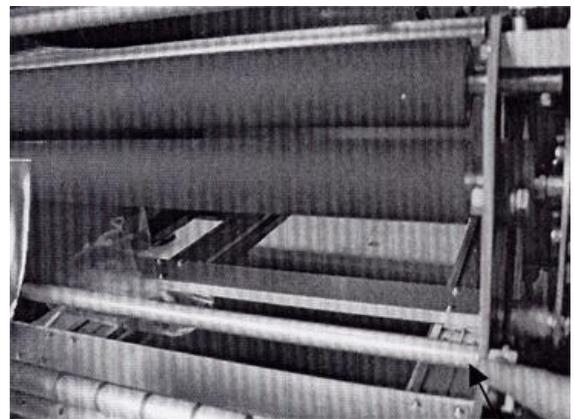


**2. Grab handles from both sides and slide cradle assembly out.**



Roll Guides

**2. Using 12mm wrench adjust roll guides to width of roll. Roll guides should be set 1/4" away from film roll cores.**



Switch

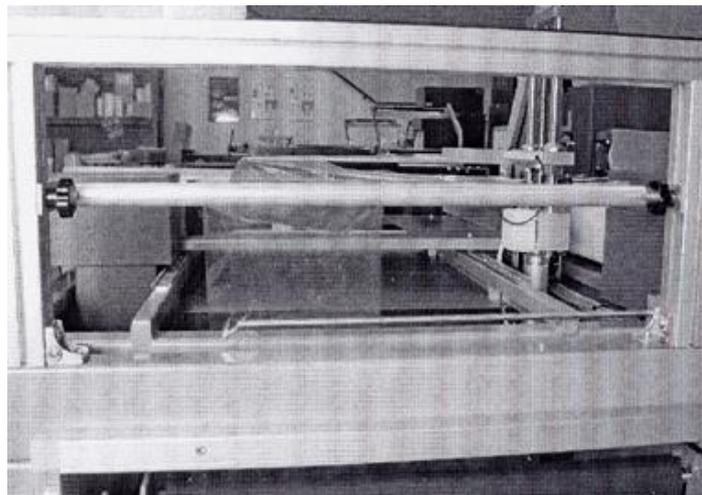
**4. Activate switch to open drive roller to thread film.**



## Turning Machine On



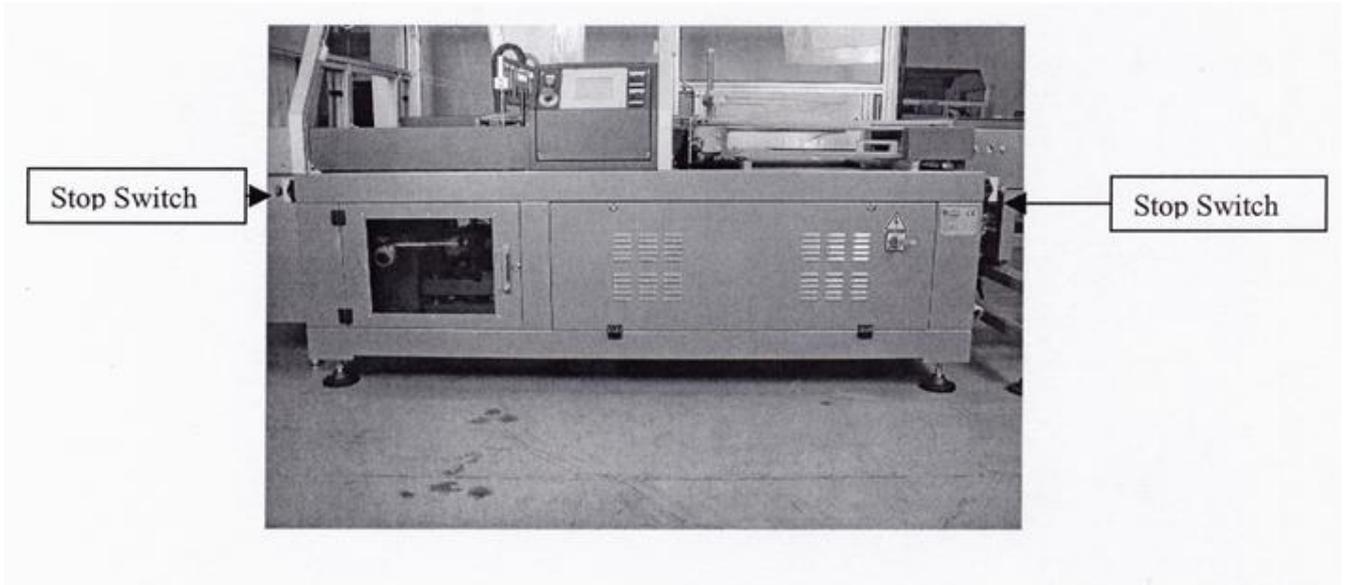
On/off switch is located on front of electrical control panel.



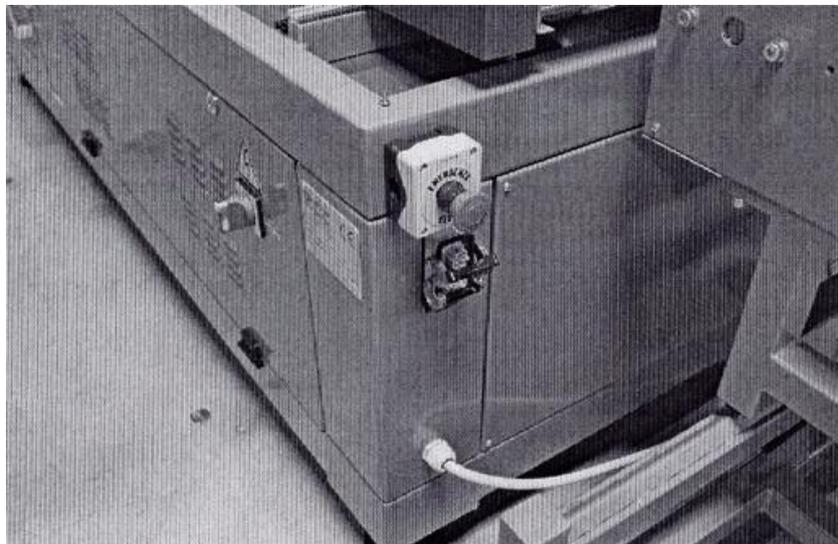
- 5 Continue to thread film up through film separating bar and over film tracking bar.
- 6 Refer to film threading diagram on page 30 for correct threading sequence.
- 7 Note\* make sure to close drive roller switch after threading is complete.



## Emergency Stop Switches



Emergency stop switch located at infeed side on PP 50 BM



Emergency stop switch located at infeed side on PP 50 BM



## Set Up

### Select Language Program



1. From main screen press language icon.



2. Select current language option of English or Spanish.



## Alarm List

The following functions will be displayed on the alarm list if a problem occurs.



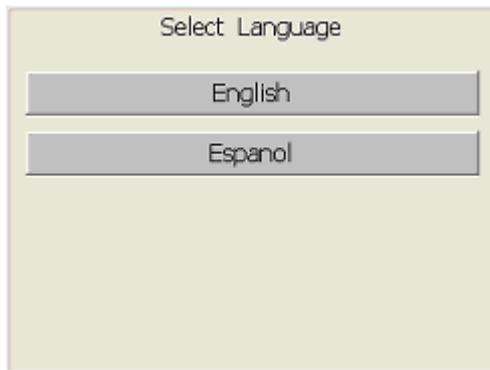
1. Sensor malfunction – Usually occurs when one of the 3 safety doors are opened when machine is on.
2. Malfunction must be corrected and (ACK) acknowledged on control panel.
3. Other malfunction include:
  - A. Film broker
  - B. Thermo overload
  - C. Inverter overload
  - D. Center seal unit unlock





## Initial Screen

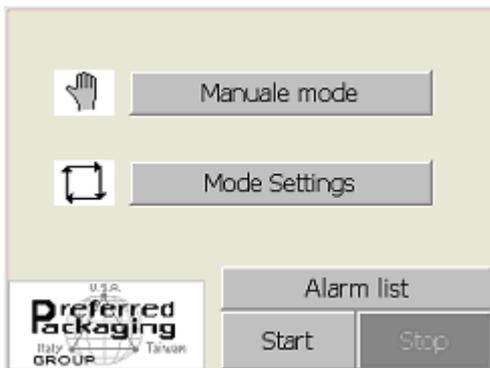
Pressing the button up on the right of the screen to enter or the “LANGUAGE” button to select the language.



### Select Language

To select the requested language.

## Principal Screen



-Manual Mode-

This enables the loading film, the adjusting of center seal and of the triangles.

-Options-

To select some options

-Mode Settings-

This enables of adjusting the parameters on the basis of the size of the product to pack

-Alarm List-

Show the alarm list





## Manual Mode

In manual mode activates the unwinders engine, the film loadings engine and the carter could be opened.

**-JOGGING-**

Activates the conveyors and the sealing

**-MAN.SEAL HEAD MOVEMENT-**

Activates the undulating motion of the sealing bar.

**-MANUAL SEAL-**

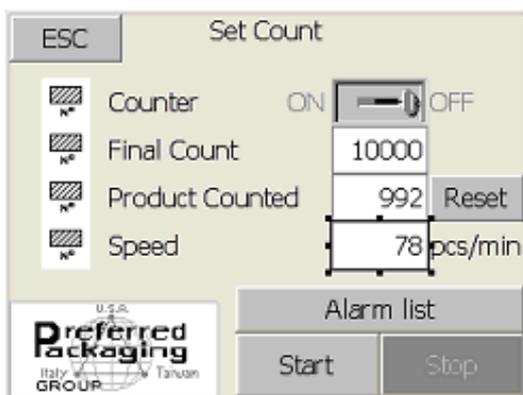
Activates the sealing (the carter must be closed)

**-UPPER WHEELS-**

This enables to lower or raise the sealing wheels to insert the film.



Pressing the button up on the right of the screen to return on the first page.



## Options

**-TEMP CONTROLLER-**

Activates/Deactivates the heaters of the sealing bar and the continuous sealing.

**-PHOTOCELLS-**

Pos.OFF deactivates the photocells and the machine work like a conveyor belt.



## Automatic Cycle



## -PRODUCT SELECTION-

Selects the kind of product to pack. This enables to learn 32 procedures. Selecting one procedure all parameters are loading. To modify the parameters press the MODIFY SETTINGS button.



## Modify Settings 1

### -PRODUCT LENGTH RANDOM-

The machine recognizes the begin and the end of the product automatically.

### -PRODUCT LENGTH MULTIP-

Select this option and set the MULTIPACK LENGTH when the product has the same size.

### -SPACING-

It is the space between the products.

### -PRODUCTS CENTERING-

To obtain a perfect center sealing of the product, is possible using and to move the sealing backwards and forwards. Press the button up on the right of the screen to enter the second page.

### -SEALING TIME-

This establishes how long the sealing cycle lasts in 1/100 sec.

### -MOTION DELAY-

This parameter establishes the closing early of the sealing bar with respect of the longitudinal motion.



### -CONVEYORS-

This establishes the speed of the conveyors in m/min.

### -EXTERNAL CONV.SPEED-



It is the speed of the infeed belt conveyor or the belt intermittent.

Press the button up on the right of the screen to enter the third page.

## Counter

-COUNTER ON/OFF-

Activates or deactivates the counter

-FINAL COUNT-

This establishes the maximum number of pieces after that the machine stops.

-PRODUCT COUNTED-

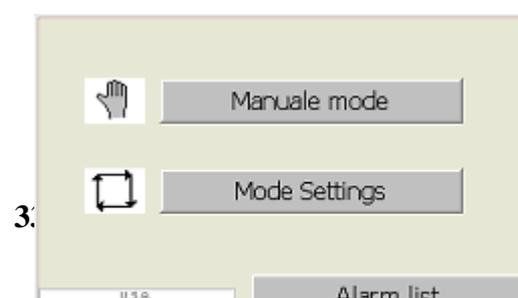
It is the number of the packed product and it could be modified.

-RESET-

Set to zero the number of packed products.

## Manual Mode

(A) Adjust Inverting Head





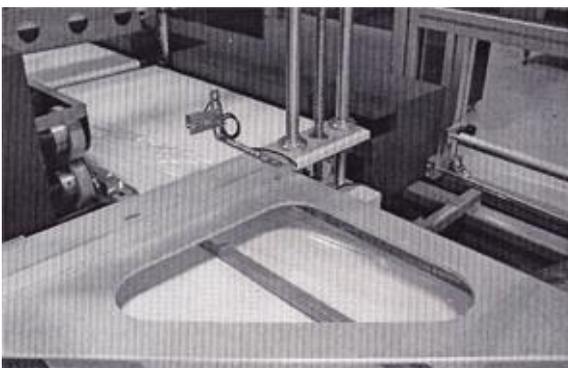
1. From Main control panel select next screen.

2. Select manual mode



3. Select next screen.

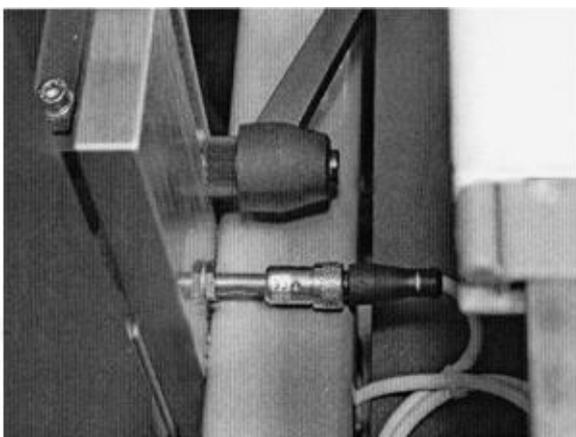
4. You may now select the inverting head up or down.



5. Inverting head should be set  $\frac{1}{4}$  to  $\frac{1}{2}$ " above height of product to be wrapped.



## Adjust Center Seal Unit



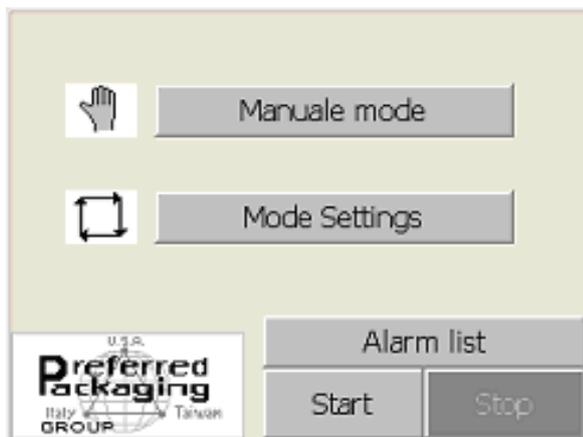
  
**PREFERRED PACKAGING**  
U.S.A. Corporate Headquarters  
440 S. Lone Hill Ave.  
San Dimas, CA 91773  
(909) 592-1784 Tel  
(909) 592-5640 Fax  
(800) 378-4777 Toll Free

Language -->

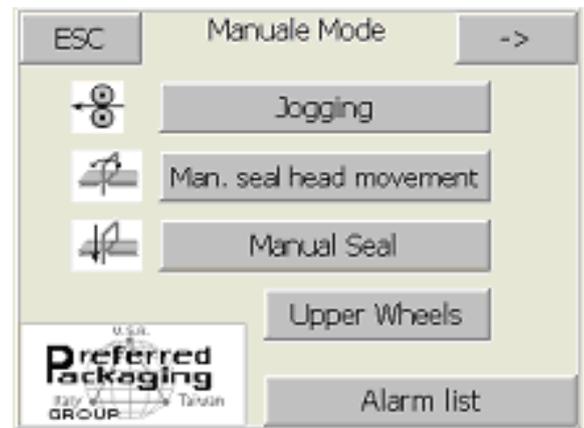


1. Side seal unit is protected by safety sensor. Loosen locking handle before attempting to adjust side seal.

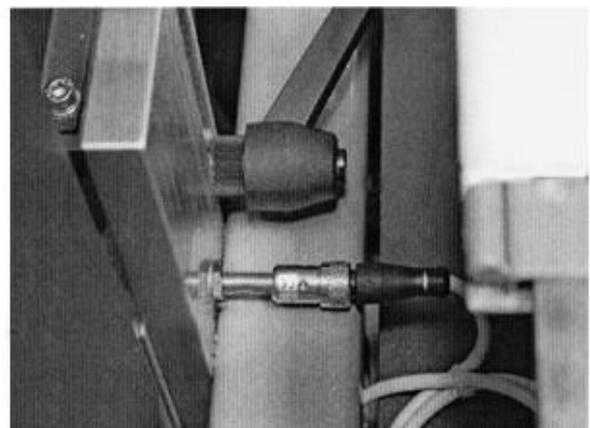
2. From main screen select next screen



3. Choose manual mode.

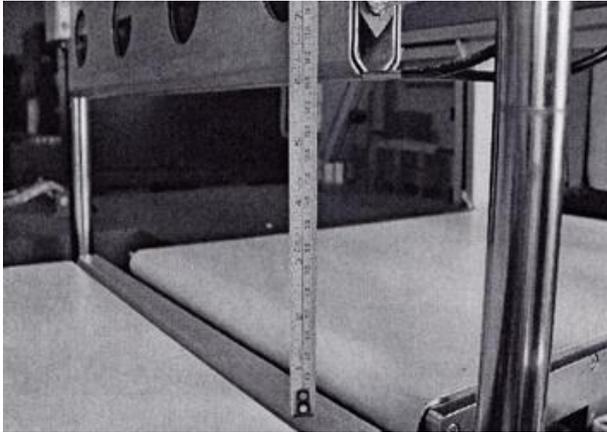


4. Choose next page.



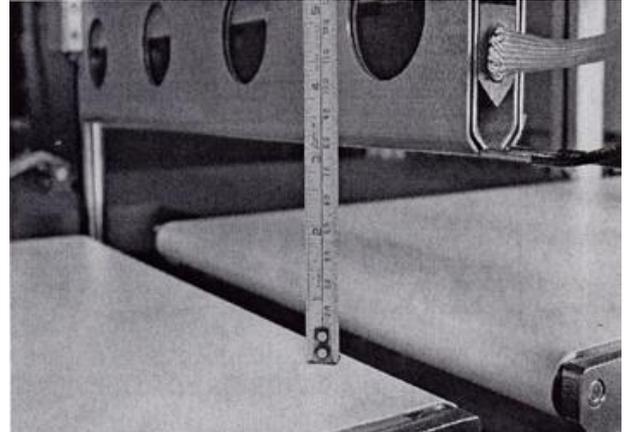


5 Adjust with up or down arrow keys.



7. Maximum height adjustment of seal jaw is 6:” (std)

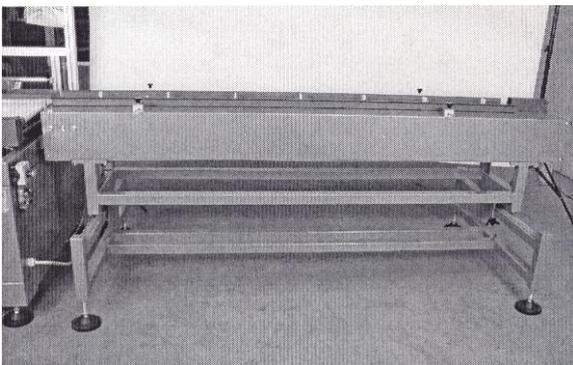
6. After side seal has been adjuste lock handle back in place. (Fig 1)



Minimum height of seal jaw is 3”

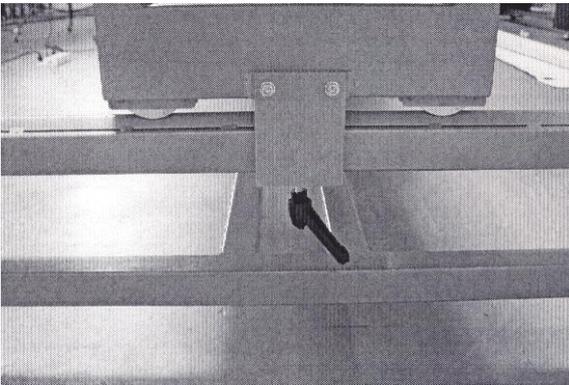
- **Seal jaw should be set at a height that is  $\frac{1}{2}$  the height of the package intended to wrap.**

### Adjustment of 6ft Flighted/Lugged infeed

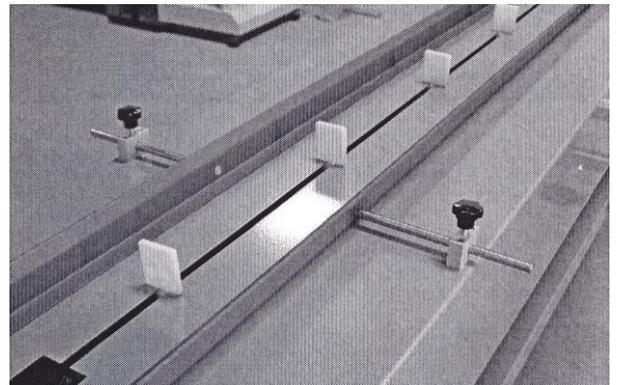




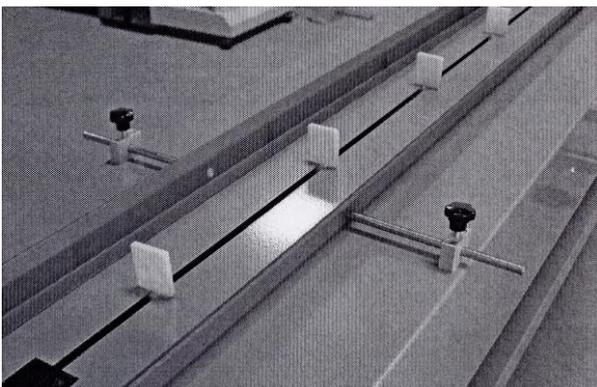
2. Loosen knob to adjust width of side guide rails.



3. Loosen bottom locking knob and slide conveyor to one side to allow alignment of conveyor to machine belted infeed conveyor.



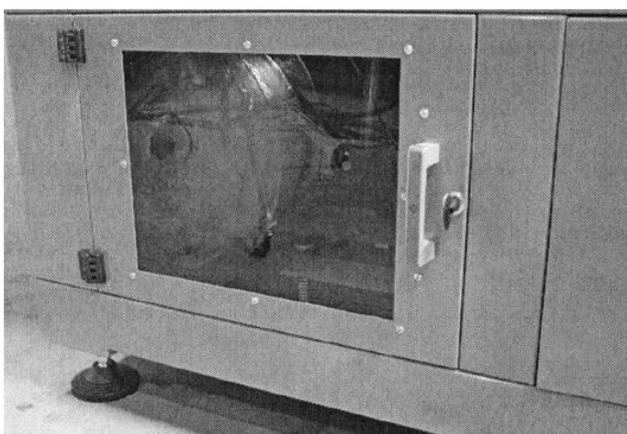
4. Standard flight spacing is 18".



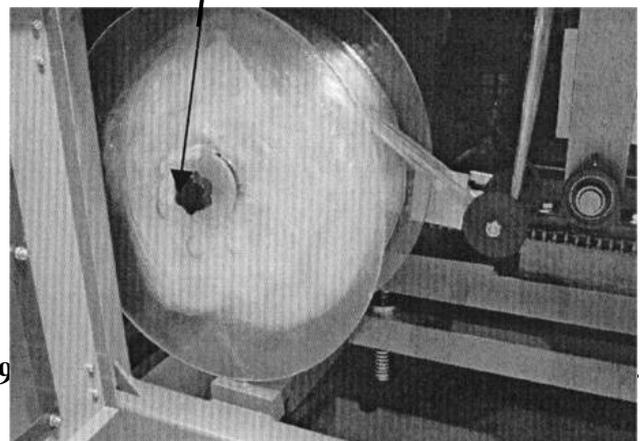


5 If longer products are required to wrap, remove plastic fight lugs until desired spacing is achieved.

## Film Scrap Removal



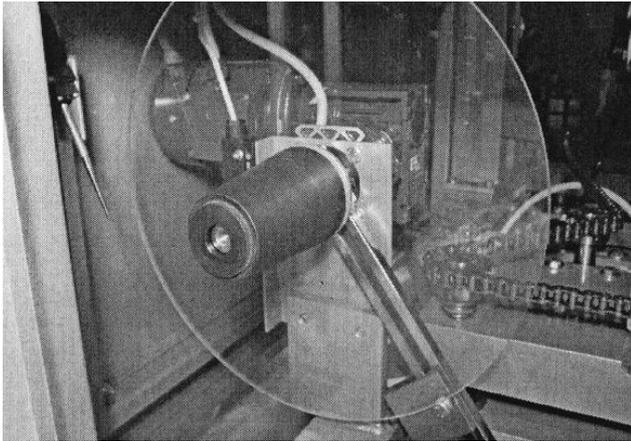
Locking Knob



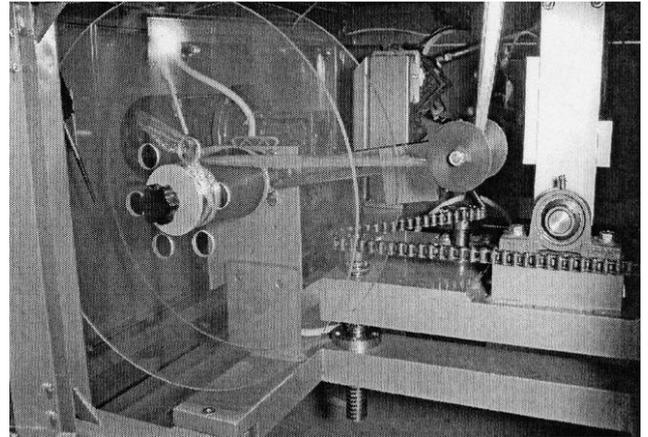


1 Use key to unlock door.

2 Loosen locking knob and remove lexan ring



3 Remove plastic from center hub.



4 Replace lexan cover and re-attach locking knob. Use excess film scrap to tie on hub.



Alarm



5 Scrap wheel has built in alarm. Alarm will sound when wheel is full.



Adjustment of Temperature Controls

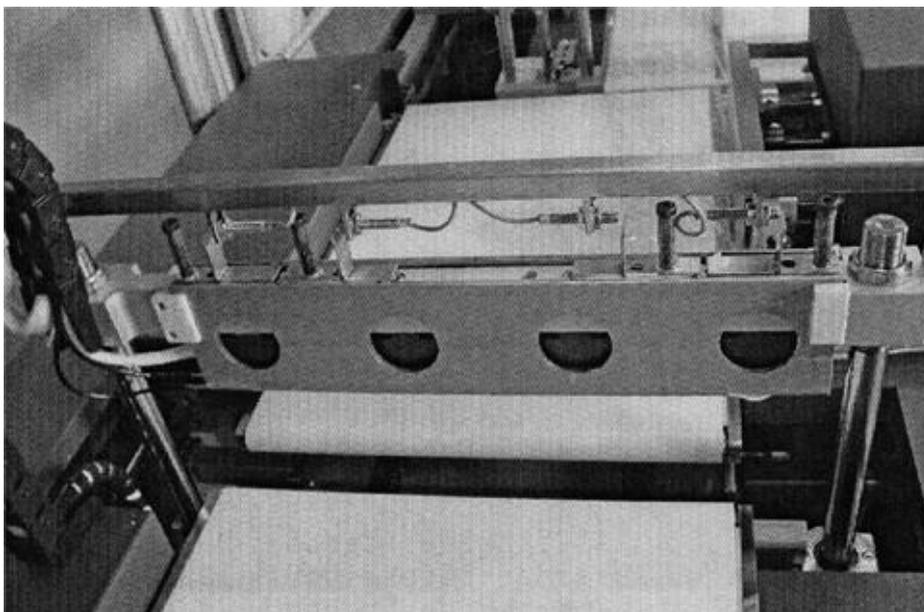


Press the F key and SP will appear on the temperature control screen SP= Set Point you may increase or decrease the set temperature by pressing the arrow key up to increase set temperature or down to decrease set temperature. When finished press F key which will reset to new temperature.

### **Important Notice**

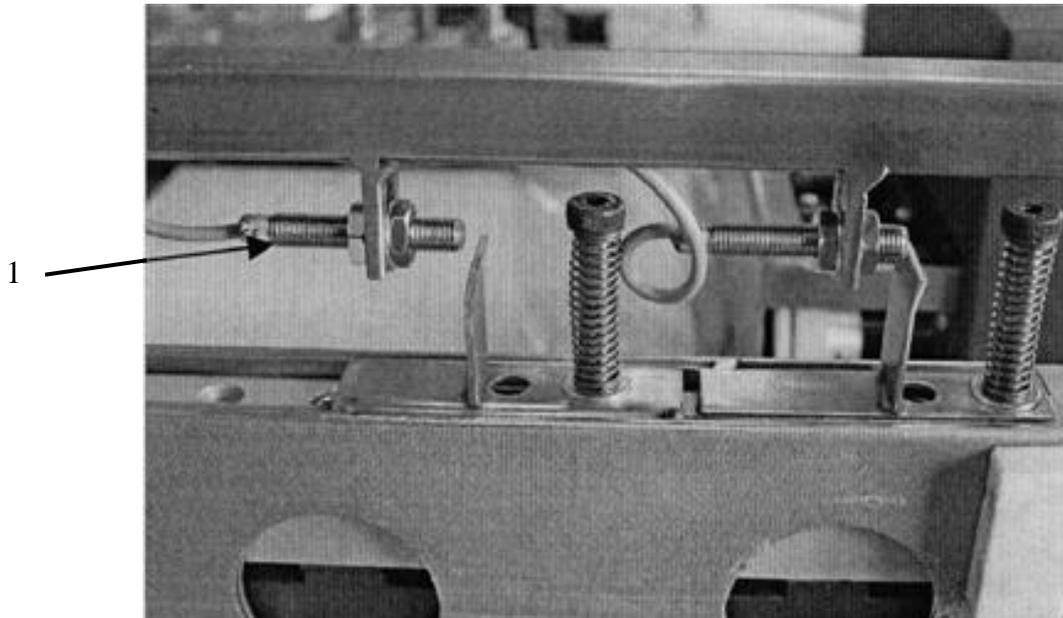
Once the machine is turned on it will require approximately 10-12 minutes for the temperature controllers to reach set temperature of 350 to 500 degrees.

### **Seal Jaw Safety Sensors**



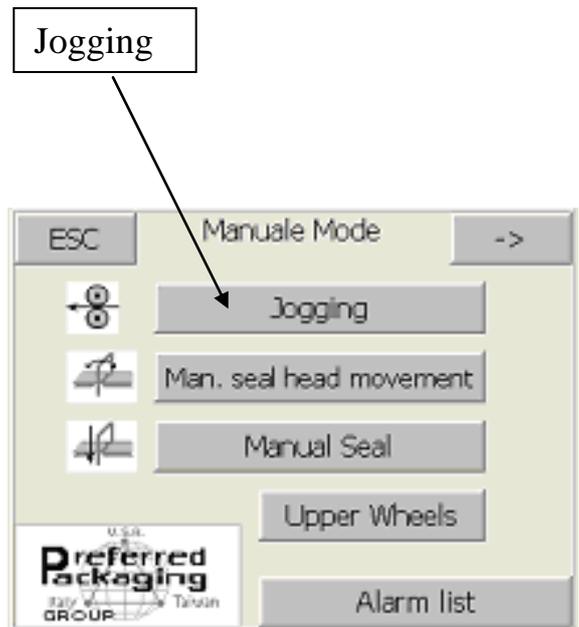
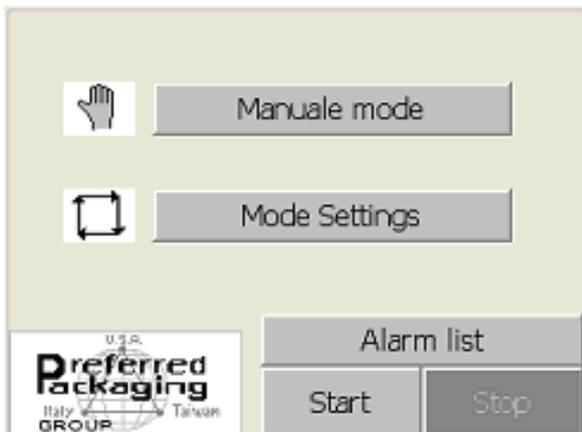


The seal jaw is equipped with independent seal jaw safety sensors.



Safety sensors should be set no more than 1/6” from adjustment bracket. (see fig 1)

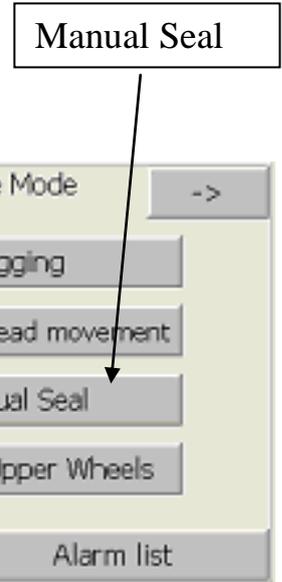
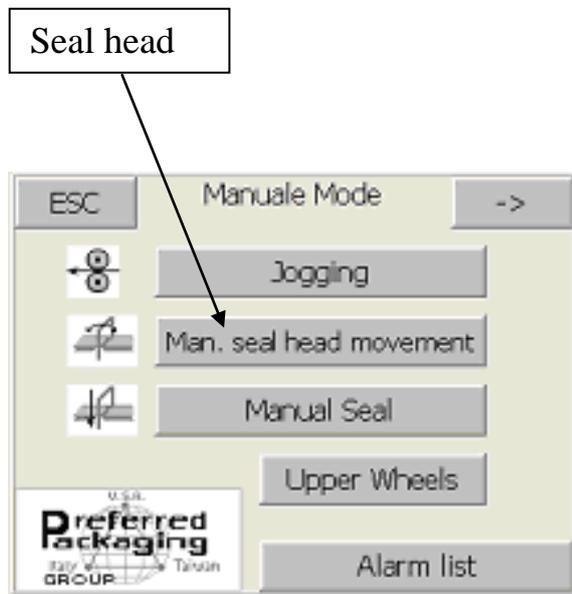
**Control Panel Settings**  
Manual Adjustments





1. Select manual mode

2 By pressing jogging, you will be able to manually advance the film feed.

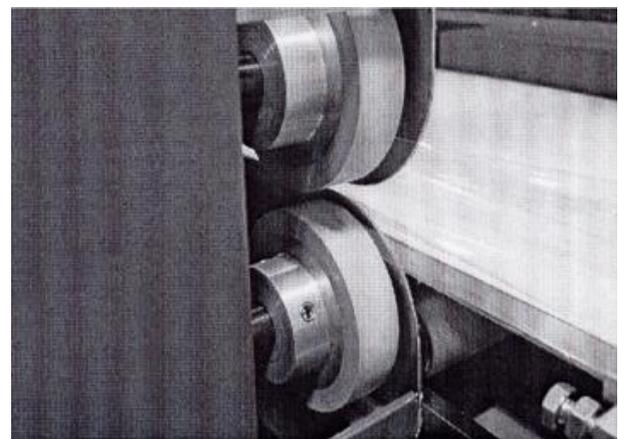


3 By pressing manual seal head movement you can change the position of the seal head.

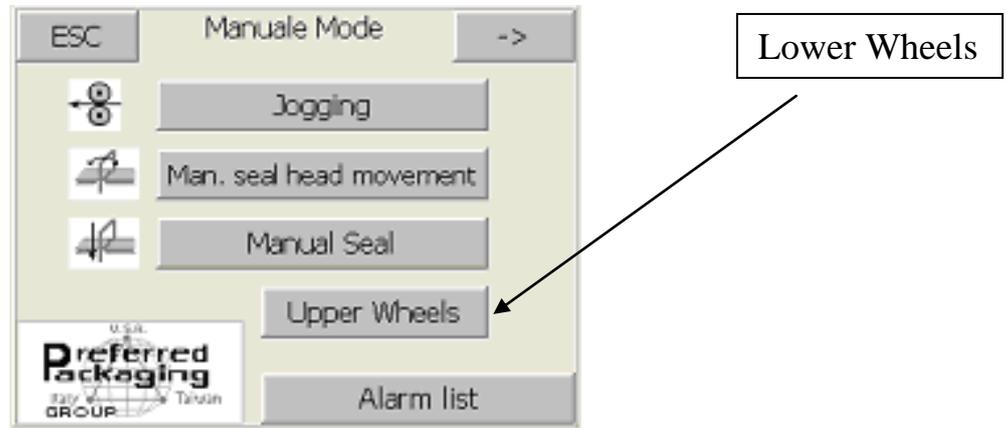
4 Press manual seal to activate seal head to close seal jaw.



5 Press upper wheels to open side seal film drive wheels.



6 Wheels in open position. You can now feed film into side seal wheels

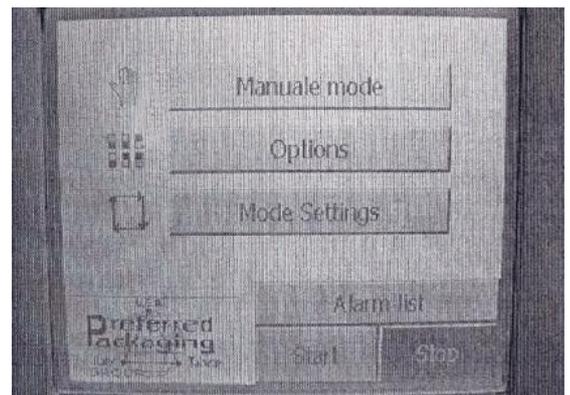


After you have feed film into drive wheels press lower wheels to grab film.

## Control Panel

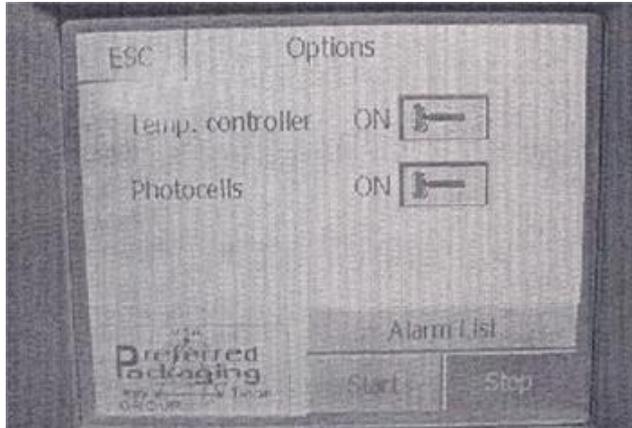
Options Setting:

1. Photo Eyes
- 2 Temperature Control
- 3 Closing Conveyor



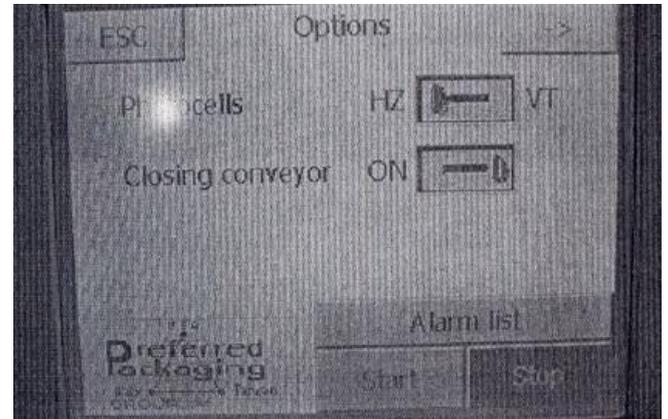


1. From main control panel press next screen.



3 Allows you to turn on/off temperature control and photo Celles

2 Press options



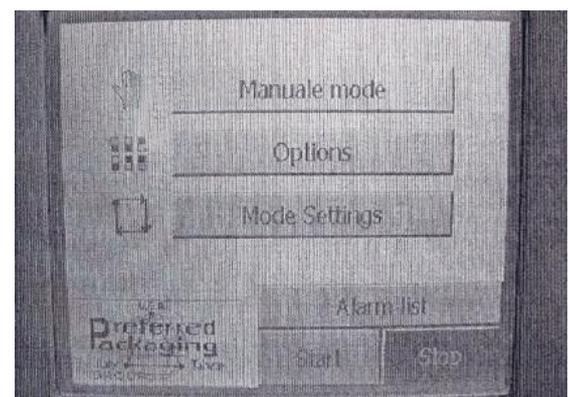
4 Allows you to choose between horizontal or vertical photo eyes, ot to turn the closing conveyor on or off

### Control Panel

Modify Setting:

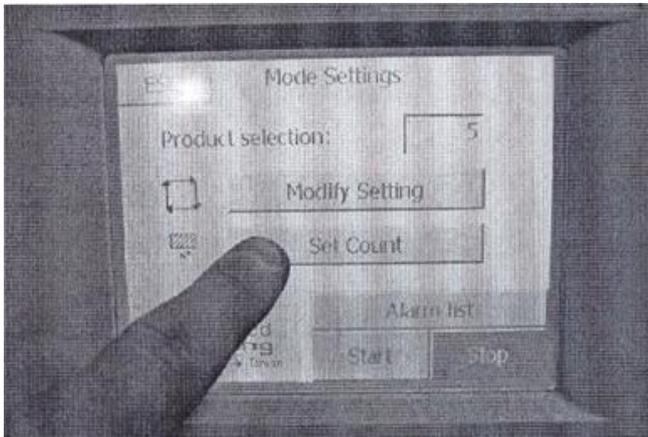
1. Product length
3. Multi-pack length
4. Spacing
5. Product centering

### Product Length

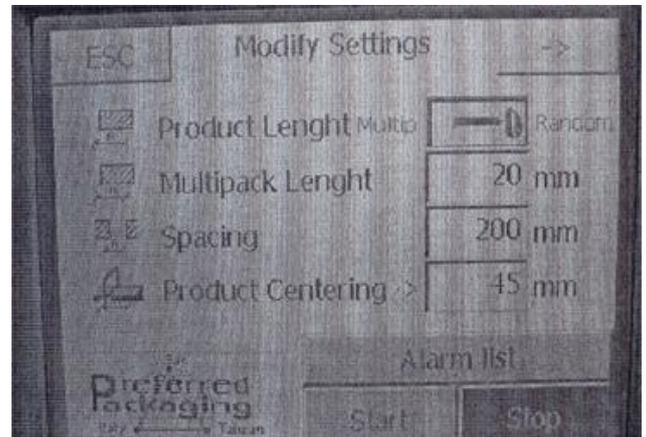




1 From main control screen advance to next screen.



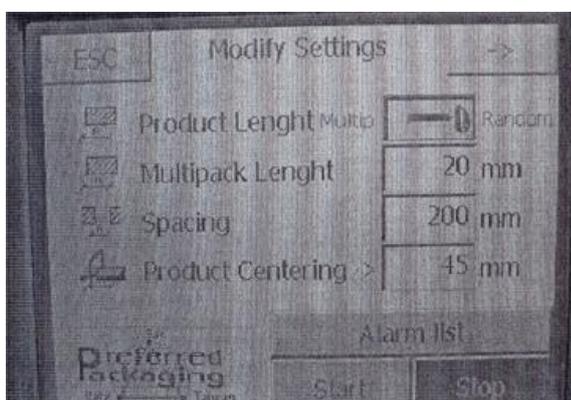
2 Select mode settings



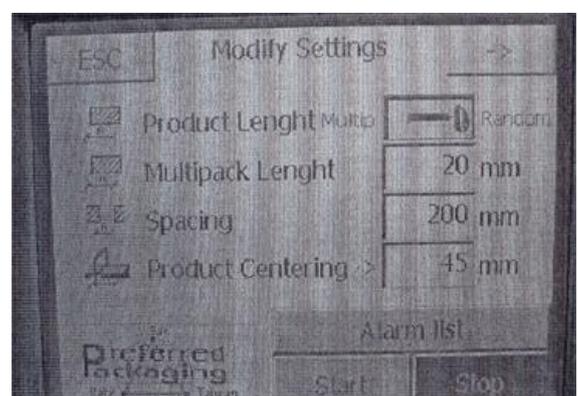
3 Select modify settings.

4 Selecting product length allows operation to choose between multipack or random length products. Photo eye will read length of product on random selections.

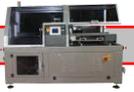
## Multipack Length



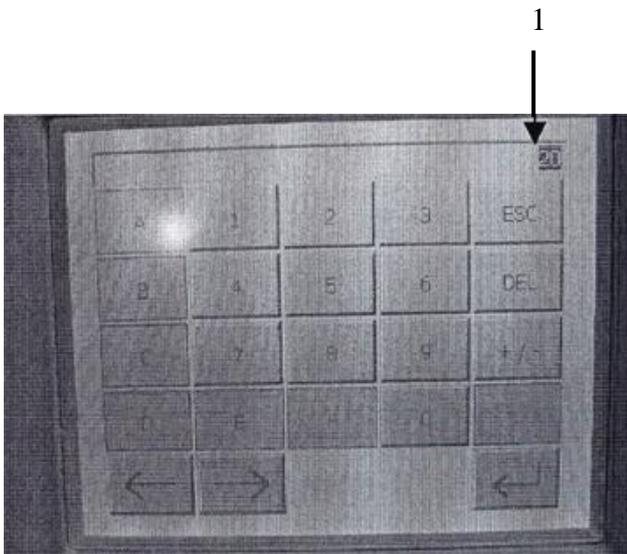
1 If operation chooses multipack length, this option is good for running 2 pack



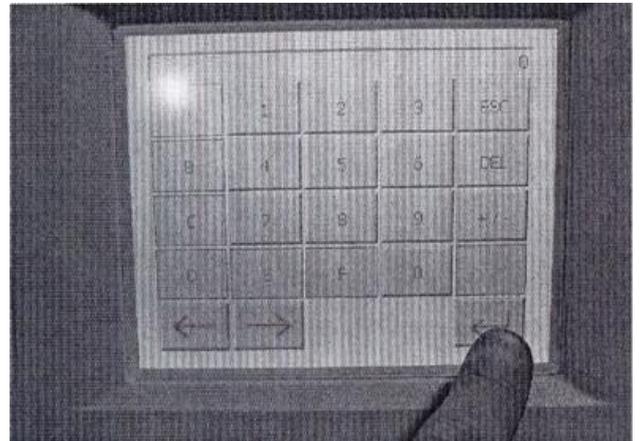
2 To adjust setting press number.



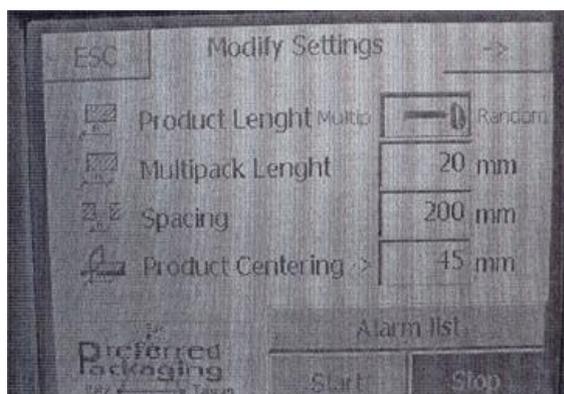
or 3 pack items of same or different lengths or single items that might be a problem for photo eye to read



3 Key pad will appear. To change setting press desired number. New number will appear in upper right hand corner. (Fig 1)



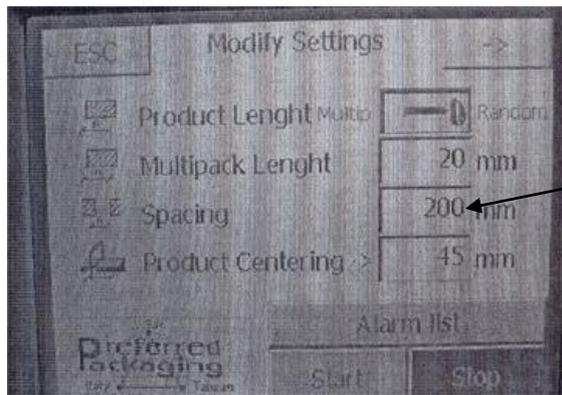
4 Once new number is selected press left arrow key, this will bring you back to settings control panel.



**9 Operator must be press the start key to set desired number into memory.**



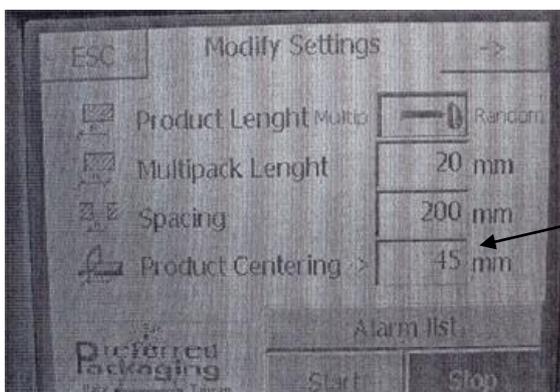
## Set Spacing



Set Spacing

Spacing is the dimension required between products. Adjust the same ways as described above in multiplied length.

## Product Centering



Product Centering

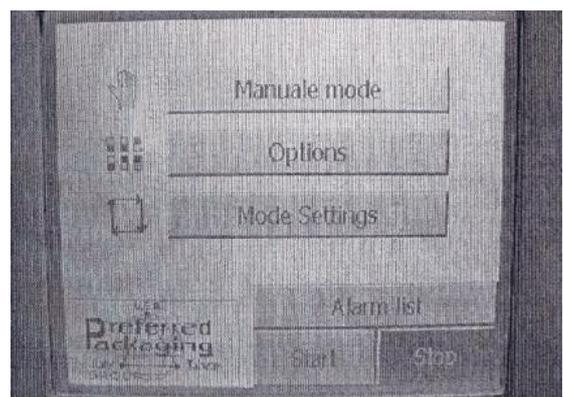


Product centering is the position of the seal head between two products.

## Control Panel

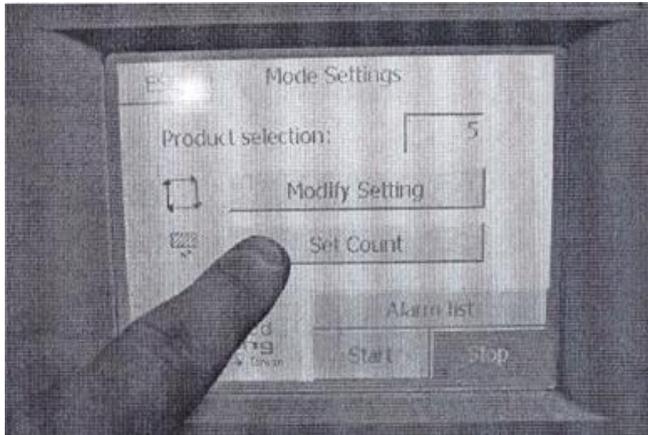
### Mode Settings – Set Count

- A. Counter
- B. Final Counter
- C. Product Counter

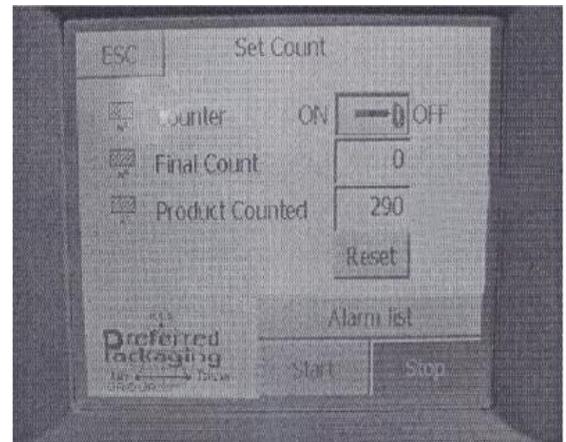




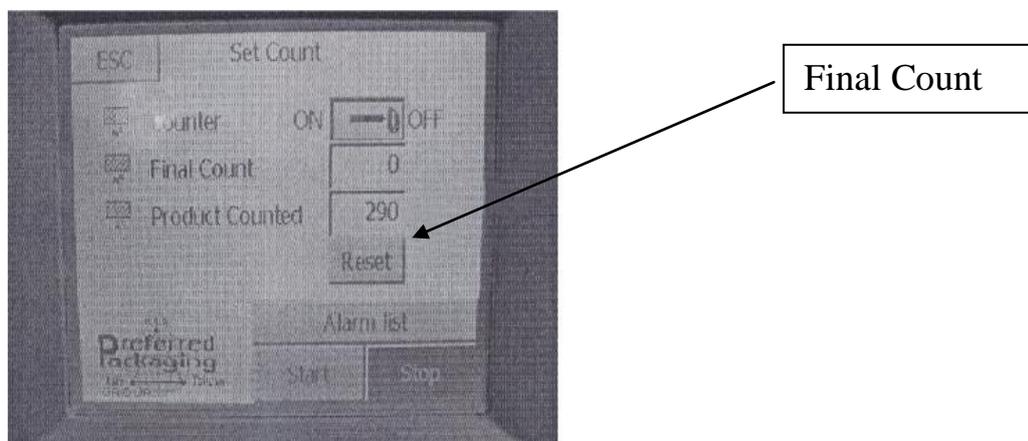
## 1. Select next screen



## 2. Select mode settings



After selecting mode settings the product selection window will appear. It is in this area where you may store up to 30 different programs. Once you have all of your parameters set press 0 the press now press start. This will memorize your program parameter.





You may set the total number of packages you want to run by setting the final count. When the product count = the final count the machine will automatically stop. To start machine again press reset or counter off.

## Trouble Shooting

### **Machine will not start or will not go into start mode**

1. Please note the side seal machine will not operate until the set temperature has been reached. It takes 10-12 minutes to reach the operating temperature.
2. Make sure the indicator light on the blue reset switch is on the demonstrate that the reset switch is operating.
3. The film feed switch on the film rack that activates the film feed rollers is in the up position. Must be in down position to operate
4. Make sure that the safety cover switches are not damaged or covers are not opened.
5. Seal bar safety switches are not activated.
6. Make sure your air supply is minimum 80 psi.
7. Make sure no emergency switches have been pressed or pushed.
8. Please make sure that the machine has been programmed with the parameters and you have not **entered into a no parameter program.**
9. Make sure the lugged infeed is not jammed or the pushers in the lugged infeed are not bent.



10. Make sure the three sensors on the main air cylinder are in correct position.
11. Please check all the fuses.
12. Please check all inverters to make sure they are not in alarm mode.
13. Press the alarm list to clear all the malfunctions then press ACK and hold for one second then press      then press start.
14. Make sure the film is not broken.
15. Check that scrap unwind is not full. – (Empty)
16. Make sure the center seal unit is locked and the center seal sensor red indicator light is on.
17. Make sure the heater switch is in the on position from the siemens front control panel.
18. Check to see if the main belt drive is not broken.
19. Check that the pulleys on the belt drive are not jammed or loose.

## **Trouble Shooting**

### **Machine will not seal ( front seal)**

1. Check the bottom seal pad and the 2” 3 mil Teflon tape are not worn. Replace if necessary.
2. Clean front seal bar with a dry cloth.
3. Make sure the seal bar is even and level.
4. Check the springs on the safety shields are not worn or damaged.
5. Check that the temperature controller is not set to high or to low.
6. Make sure the air supply has a minimum 80psi.
7. Make sure there is correct spacing between the packages and the seal bar is not attempting to make a seal under a lot of film tension.
8. Make sure the thermocouple and the temperature controller are not damaged.
9. Check that the heater cartridge is good.
10. Make sure the solid state relay is not burned or damaged.
11. Check all the fuses.



12. Check the wiring coming into the heater cartridge is not damaged or broken or there no loose connection on the terminal.

## **Trouble Shooting**

### **Side Seal Not Sealing (weak Seals)**

1. Make sure the side seal unit is clean. Clean with dry cloth.
2. Make sure the air pressure is set correctly on the side seal wheels.
3. Make sure the seal wheels come in contact together.
4. Check that the correct temperature is set depending on the film type and the gauge.
5. Make sure the side seal is not sealing under a lot of film tension.
6. Make sure temperature controller or thermocouple are not damaged.
7. Check the brushes on the commutator are not worn or damaged.
8. Make sure the shifting valve and cylinder are being activated and operating correctly.
9. Make sure the adjustable long thread or nuts have not come loose on the side seal unit.
10. Make sure solid state relay is not burned or damaged.
11. Check all fuses.



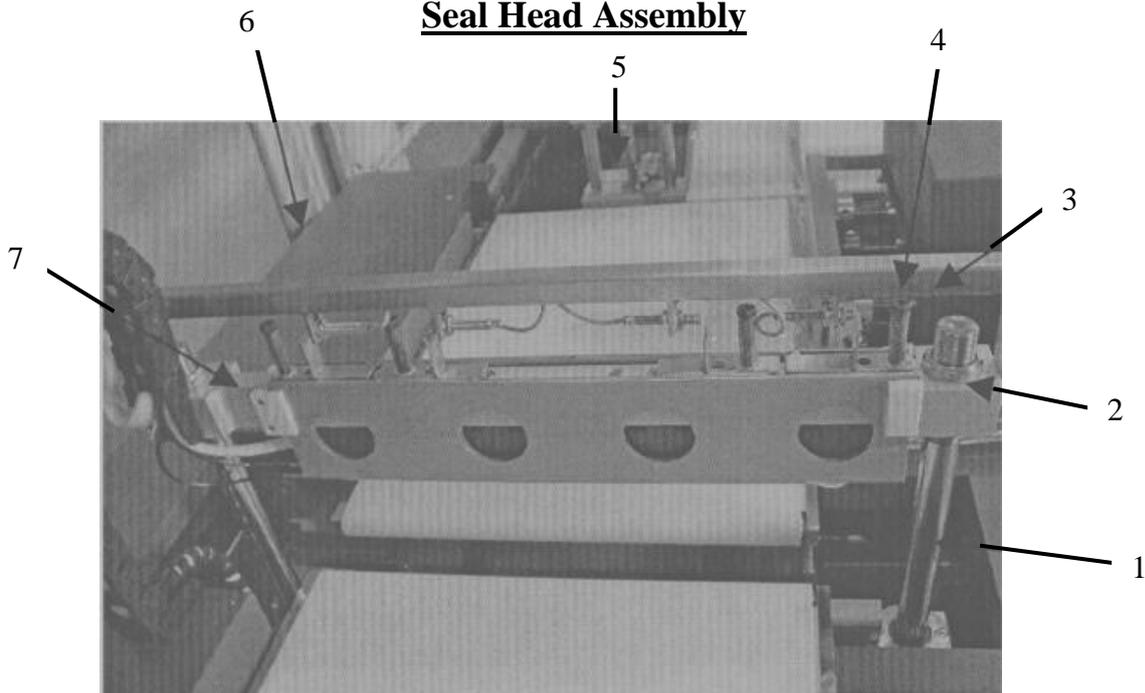
12. Make sure sealing wheels are not damaged or do not have a damaged spot.

**Trouble Shooting**

**Belts are not tracking (infeed belt, center belt, discharge belt)**

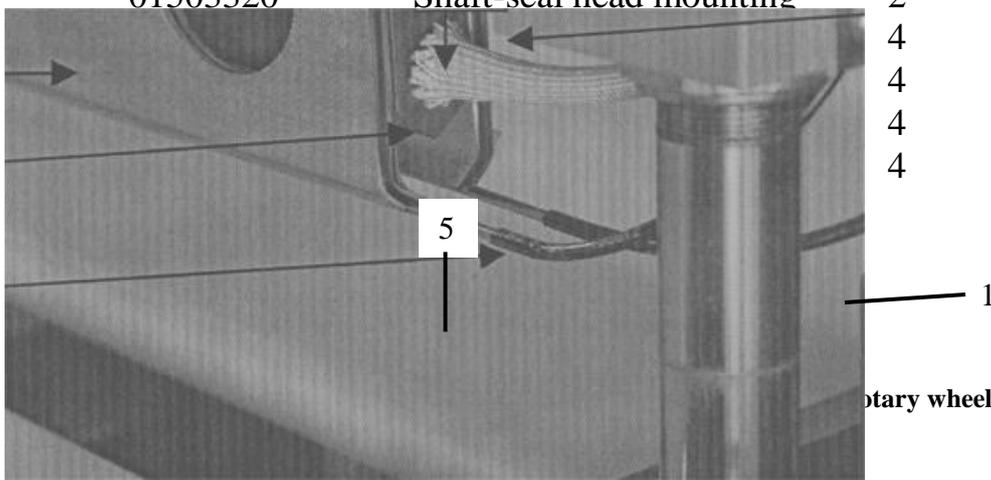
1. Make sure you keep belts clean. Wipe clean everyday or every week depending upon environment the machine is operating in.
2. Makes sure no excess film or products are under the belt.
3. All conveyors belts are adjustable with two bolts at each end of conveyor by tightened or loosening it will track the belt to the right or to the left.
4. Make sure no bolts have come loose or brackets. Make sure all the rollers are rolling freely and none of the bearing are damaged.

**Seal Head Assembly**



<u>Position</u>	<u>Part#</u>	<u>Description</u>	<u>Qty</u>
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1.	01503320	Shaft-seal head mounting	2
2.			4
3.			4
4.			4
5.			4





2 ———

4 ———

3 ———

<u>Position</u>	<u>Part</u>	<u>Description</u>	<u>Qty</u>
1.		Safety shield/film clamp-infeed side	1
2.		Safety shield/film clamp discharge side	1
3.		Air cooling tubes	2
4.		seal bar –20”	1
5.		Heater cartridge	1

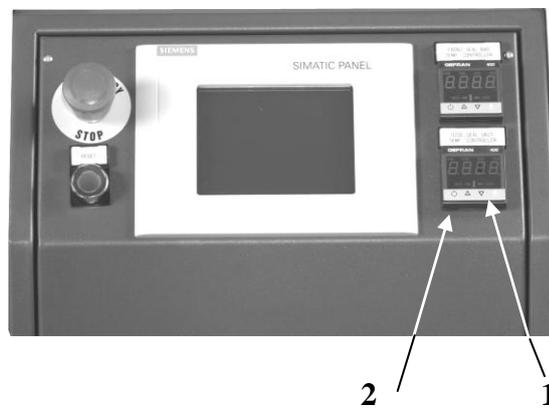


Fig. 7.3.8









