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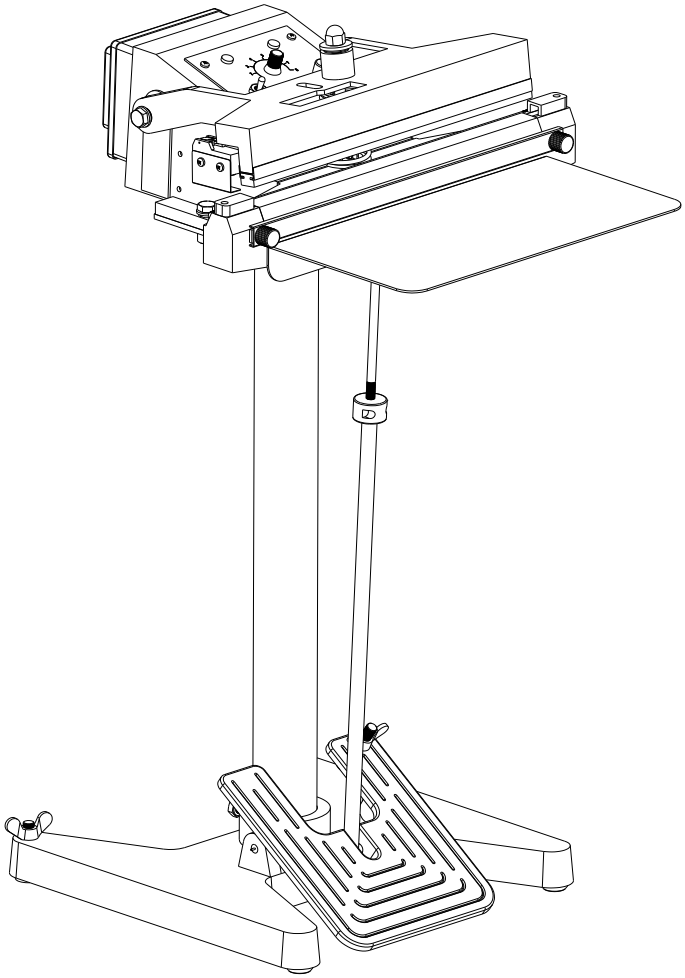
# DIRECT HEAT SEALER

## Foot-operated Sealer Operation Instruction



# Content

## Ⅰ. Use scope and characteristics

The Foot-Operated Sealer has two types: Instant-Heat Type and Direct-Heat one. The Instant-heat Foot-operated Sealer is suitable for bag sealing and marking of PVC and polyethylene material. The Direct-heat One is for for bag sealing and marking of cellophane, tin foil, copper foil, aluminum foil, biaxial Stretching polystyrene, and other composite material. Meanwhile the manufacture date and the expiration date could be printed when in sealing. It adopts the temperature electronic controller which is easy to adjust the temperature and keep constant temperature.

**II. The main technical parameters**

| **Type** | **Instant-Heat Type** | | | **Direct-Heat Type** | | |
|---|---|---|---|---|---|---|
| **Model** | FIS-14 | PFS-450 | PFS-600 | PFS-DD200 | PFS-DD300 | PFS-DD400 |
| **Sealing length** | 350 | 450 | 600 | 200 | 300 | 400 |
| **Sealing width** | 10 | 10 | 10 | 12 | 12 | 12 |
| **Input voltage** | 110V□220V□ 50-60HZ | | | | | |
| **Heating time** | 0-2.5 | | | -- | | |
| **Power** | 850W | 1050W | 1500W | 300W | 350W | 550W |
| **Heating temperature** | Controlled by the timer. | | | 0-300℃ | | |
| **Overall dimension** | 80X54X25cm | | | 80X54X25cm | | |
| **Weight** | 22 | 24 | 26 | 19 | 21 | 23 |

Diagram 1 Main Technical parameters

III. Adjustment and usage

1. Adjustment and usage of the Direct-Heat Operated Sealer

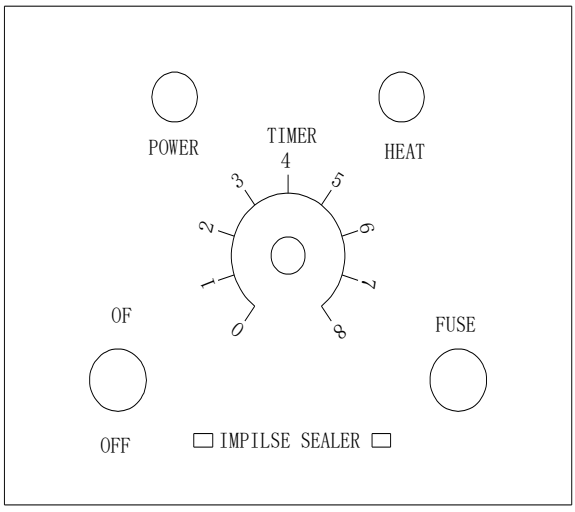


**Diagram 2 The panel diagram of the Direct-Heat Type**

1. Adjustment and usage of the Instant-Heat Type

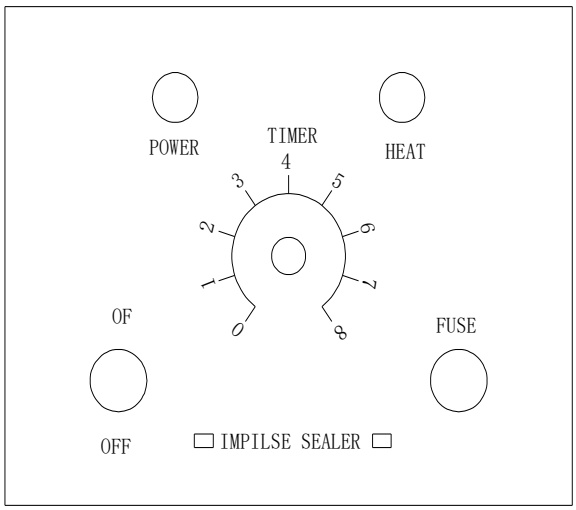



**Diagram 1 The Instant-heat panel diagram of**

A. Connect the 110V/220V AC. Attention: the voltage should matched with the required voltage of the machine. Turn on the power switch and the red indicator light is on. Adjust the sealing temperature based on the material and its thickness.
B. Turn the heating time to 1 gear before sealing. Put the bag on and press the footboard. And the yellow light is on. Raise the footboard after the yellow light is off. Then get the plastic bag out.
C. If it seals unfirm, lengthen the heating time. When it seals tight and prints clear without any destruction or wrinkle after trying several times, the machine could operate according to the set time and temperature.
D. The cooling time could not be too short, or there will be wrinkle in the sealing side. The longer the heating time, the longer the cooling time. Turn off the power switch, then cut off the power after work.

2. Adjustment and usage of the Direct-Heat Type

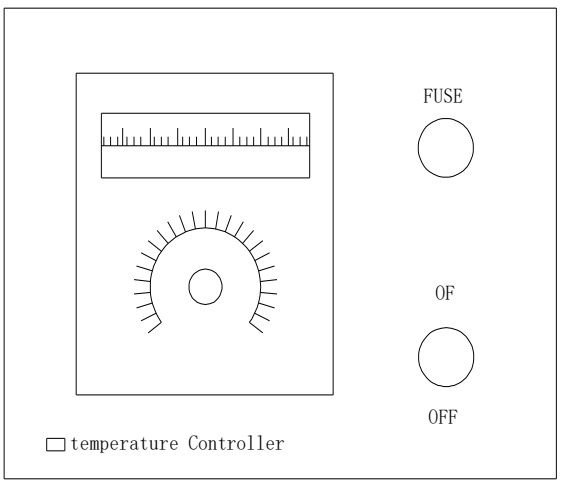


**Diagram 2 The Instant-Heat panel diagram**

A. Connect the 110V/220V AC. Attention: the voltage should matched with the required voltage of the machine. Turn on the power switch and the red indicator light is on. Adjust the sealing temperature based on the material and its thickness. When the green light of the temperature controller is on, it shows that it does not reach the set temperature and it still heats. When the red light is on, it reaches the set temperature. Then place the bag needing sealing on the sealing line and press the footboard for 0.2-1.3 seconds. Get out the plastic bag after 1-2 seconds' waiting.

B. If it seals loosen or prints unclear. One of the reason is that the temperature is low; The other is that the pressing time is too short. Then increase the temperature and lengthen the pressing time reasonably.

C. If there is any damage in the sealing part or printing part, it because the heating time is too long. Then just lower the heating temperature or shorten the foot pressing time.

D. Turn off the power switch and cut off th power after work.

IV.Maintenance

1. Maintenance of the Instant-Heat Type

A. When in usage, do not connect to seal without any plastic bag. Do not set the high temperature blindly without any sealing test. Or it will damage the Teflon linoleum. If the plastic stick sto the Teflon linoleum, do not cut it using the hard object and just lower the temperature to seal it again. Then get the bag off slightly from the Teflon linoleum with the plastic.

B. The change of the heating wire: Loosen the trim strip screw of the Teflon linoleum above the heating wire, fold back the Teflon linoleum to expose the heating wire, loosen the ebonite box in the two ends, remove the tensioning screw of the copper block, then remove the heating wire and install the new one. Normally, the heating wire should in a tensioning state. If the copper block is oxidized, clean it with the sandpaper to make it connect well with the heating wire. Attention: place the Teflon linoleum smooth without any wrinkle when install the wire, meanwhile insulate the wire with the machine body. Or it will cause short circuit and damage the heating wire, or other accidents.

C. Change of the Teflon linoleum: remove the screw and the trim strip, unscrew the linoleum roller. Pull the broken part out and cut it down, then replace the new. The install every parts smoothly again, or it will affect the sealing quality.

D. Change of the travel switch: When the travel switch beside the machine head is broken, replace it timely. Attention: weld it tightly with the original switching line and check whether the travel switch is pressed down( If it is, there is clicking sounds).

E. Keep the sealing table tidy. If there is any residue on it, it will reduce the using time of the heating wire and the linoleum. When start the machine, do not use wet cloth to wipe the sealing table.

F. Check whether the rubber on the trim strip is level or broken after long-time usage. Inject the lubricant oil into the moving parts.

2. Maintenance of the Direct-heat Type

A. Keep the sealing table tidy so as to prevent any foreign matters stick to the sealing plane, therefore ensure the sealing and printing quality and the service life.
B. When in the live working, do not use wet cloth to wipe the sealing table and avoid to touch the heating block, or it will cause scald.
C. If there is a need to replace the heating parts, choose the required heating pipe.
D. After long-time usage, notice whether the rubber on the compressing frame is still level or broken, or it will affect the sealing quality. And check whether the connecting line on the two ends of the heating pipe and the heater are loosen.
E. Add the lubricant to the moving parts.

## V. The common fault and clearance

1. Fault and clearance of the Instant-Heat Type

| Fault | Reason and clearance |
|---|---|
| The sealing quality is bad. | Lengthen the heating time properly. If the bag is burnt through, shorten the heating time. Check whether there is foreign matters in the sealing plane. |
| Wrinkles appear in the sealing part. | One reason is that the sealing temperature is too high. Just shorten the heating time on the premise of ensure the sealing quality. The other is that the cooling time is not enough. Lengthen the cooling time. |
| The machine's temperature rises after using some time. | Because the machine's temperature is the room temperature. In the beginning, the machine will absorb some heat. So just shorten heating time. |
| The power light is not on and the heating wire does not heat. | Check whether the power switch is turned on, the fuse is good, and the power cord is broken. |
| The power light is not on and the heating wire does not heat. | Check whether the travel switch is compressed or broken, the heating wire works off, the circuit board is damaged. Check and change. |

| | |
|---|---|
| The heating wire is always heating after startup of the machine. | Turn off the machine at first. Check the travel switch and the circuit. If damaged, just replace it. |

**Chart 1 Fault and clearance of the Instant-Heat Type**

2. Fault and clearance of the Direct-Heat Type

| | |
|---|---|
| It seals bad. | Raise the heating time properly or lengthen the foot pressing time. If the bag is burnt through, shorten the heating time or shorten the pressing time. |
| Wrinkles appear in the sealing part. | One reason is that the temperature is too high. Just reduce the heating temperature on the premise of ensure the sealing quality. The other is that the foot pressing time is too long. Just shorten it properly. |
| The machine's temperature rises after using some time. The temperature controller light is not on. | Check whether the power switch is turned on, the fuse, the power cord and the temperature controller are broken. If the controller or the thermocouple is broken, just replace it. |
| Both of the power light and the temperature controller light are on. Bur the temperature is not increasing. | Check whether the heating pipe and the thermocouple are loosen, burnt or connecting well. If damaged, replace it. |
| The temperature is out of control. | One reason is the thermocouple is broken or connecting bad. The other is that the temperature controller is broken. Just adjust or replace them. |

**Chart 2 Fault and clearance of the Direct-Heat Type**

VI. Name of the component and number

| Number | Name | Amount | Number | Name | Amount |
|---|---|---|---|---|---|
| L1 | Handpiece | 1 | F16 | M8 self-made hex head bolt | 2 |
| L2 | Upper compressing frame | 1 | F17 | Shield | 2 |

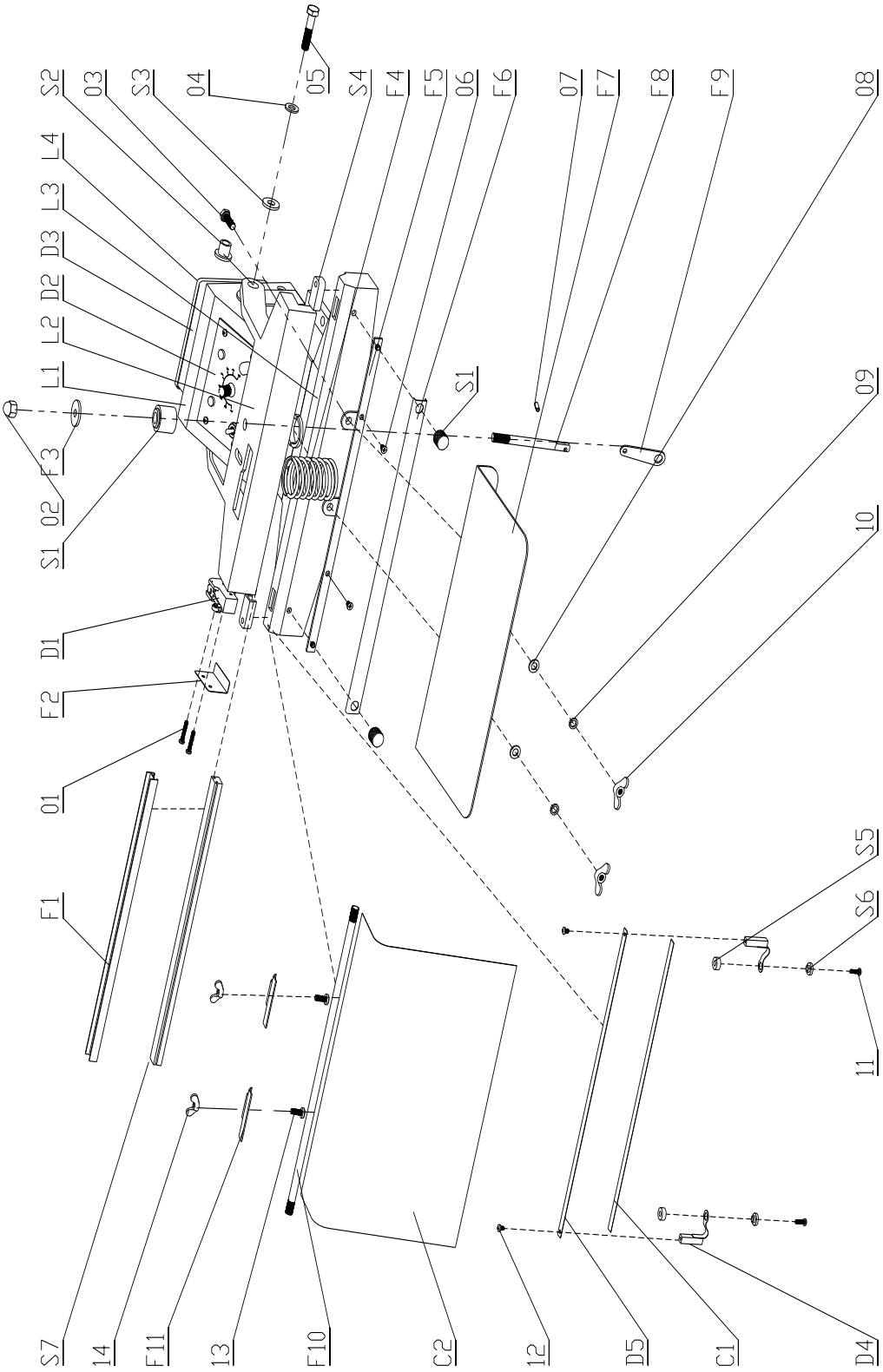
| | | | | | |
|---|---|---|---|---|---|
| L3 | Lower compressing frame | 1 | S1 | | 1 |
| L4 | Back cover | 1 | S2 | Plastic cover of the upper compressing frame | 2 |
| L5 | Foot plate | 1 | S3 | Plastic cushion of the upper compressing frame | 2 |
| L6 | Base | 1 | S4 | Decorative Plastic cover | 2 |
| C1 | Teflon tape | 1 | S5 | Insulating washer | 2 |
| C2 | Teflon | 1 | S6 | Insulation covering | 2 |
| C3 | Insulation piece | 2 | S7 | Rubber | 1 |
| D1 | Travel swith | 1 | S8 | Base cushion | 3 |
| D2 | Electronic panel | 1 | S9 | Bolt cushion | 2 |
| D3 | Transformer | 1 | S10 | Nylon casing | 6 |
| D4 | Heating wire rod | 2 | S11 | Small nylon cushion | 4 |
| D5 | Heating wire | 1 | 01 | Pan head cross screw M4X25 | 2 |
| D6 | Heating bar | 2 | 02 | Hexagon cap nut M10 | 1 |
| D7 | Wire terminal | 2 | 03 | Hexagon cap bolt M8X25 | 2 |
| D8 | Thermocouple | 1 | 04 | Washer 10 | 8 |
| D9 | Heating pipe casing | 1 | 05 | Hexagon head bolt M10X40 | 2 |

| | | | | | |
|---|---|---|---|---|---|
| D10 | Heating pipe | 1 | 06 | Panhead cross Screw M5X8 | 2 |
| D11 | Heating pipe cover | 1 | 07 | Elastic straight pin 5X12 | 1 |
| F1 | Rubber fixator | 1 | 08 | Washer | 2 |
| F2 | Travel switch holder | 1 | 09 | Spring washer 8 | 2 |
| F3 | Pull rod nut | 1 | 10 | Wing nuts M8 | 2 |
| F4 | Pull pipe spring | 1 | 11 | Panhead cross Screw M4X14 | 2 |
| F5 | Rubber holder | 1 | 12 | Panhead cross Screw M4X6 | 2-16 |
| F6 | Rubber casing | 1 | 13 | Panhead cross Screw M6X16 | 2 |
| F7 | Front shelf | 1 | 14 | Wing nuts M6 | 2 |
| F8 | Short pull rod | 1 | 15 | Hexagon cap bolt | 3-5 |
| F9 | Pull plate | 1 | 16 | Spring washer | 4-6 |
| F10 | Rubber scroll | 1 | 17 | Hex nuts M10 | 4-6 |
| F11 | Rubber scroll frame | 2 | 18 | Wing nuts M10 | 2 |
| F12 | Support | 1 | 19 | Bolt pin M10X40 | 2 |
| F13 | Draw hook | 1 | 20 | Elastic straight pin 8X40 | 1 |
| F14 | Draw tube | 1 | 21 | Inner hexagon screw M8X25 | 2 |

| | | | | | |
|---|---|---|---|---|---|
| F15 | Back cover plate of the heating strip | 2 | | | |

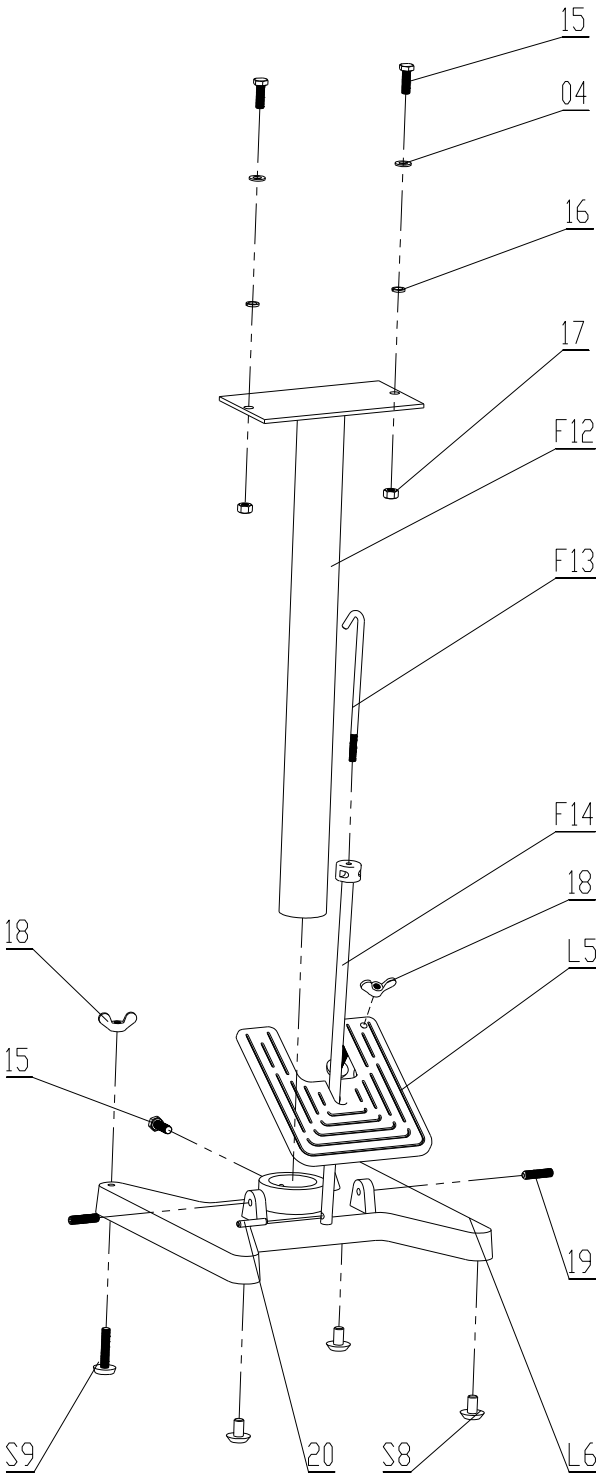
**Chart 2 Name of the component and number**

VII. External Axonometric Drawing and Assembly Drawing

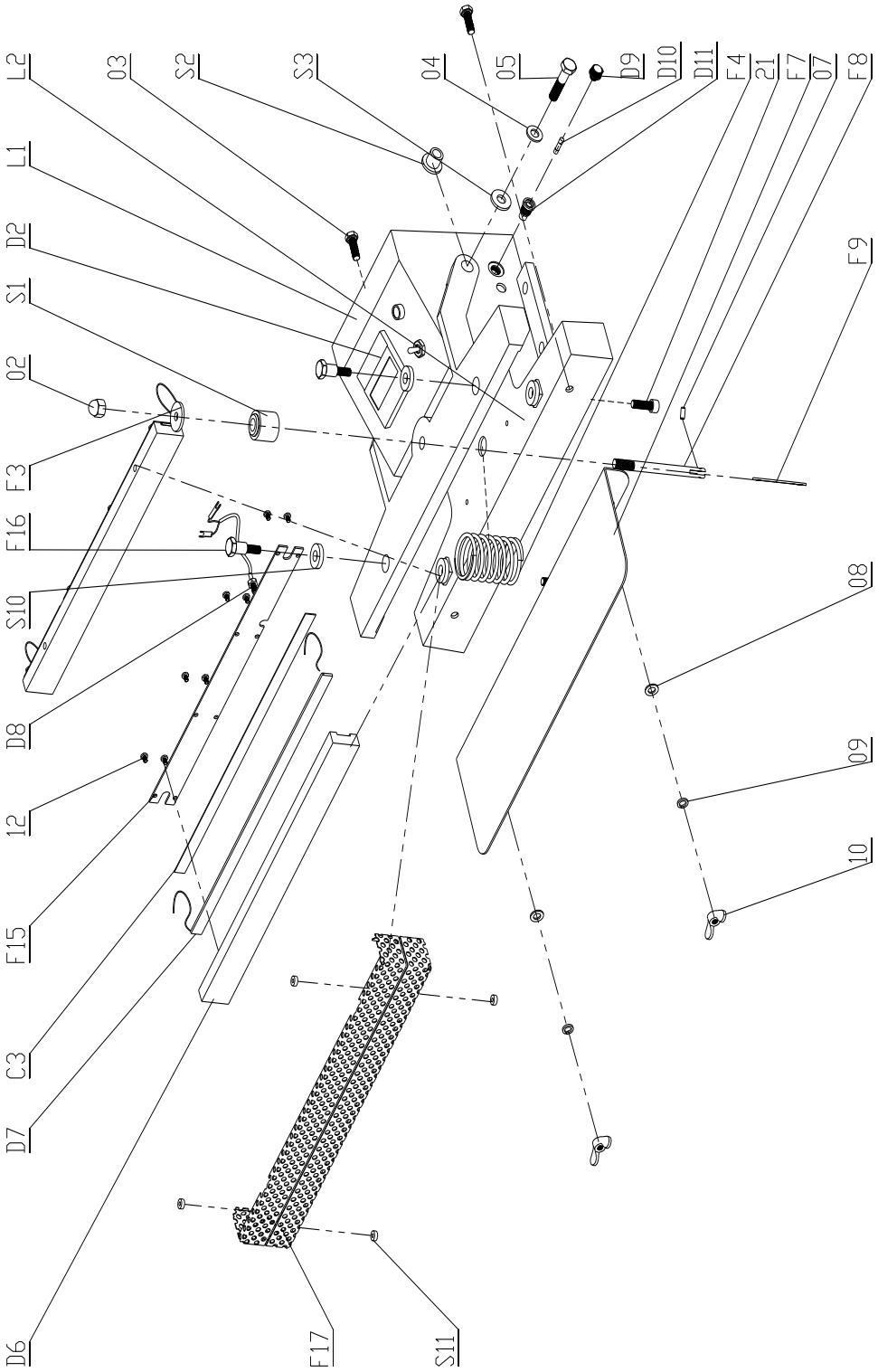



7. 图 3　瞬热式机体轴测图

**Drawing 3 External Axonometric Drawing of the Instant-Heat Type**

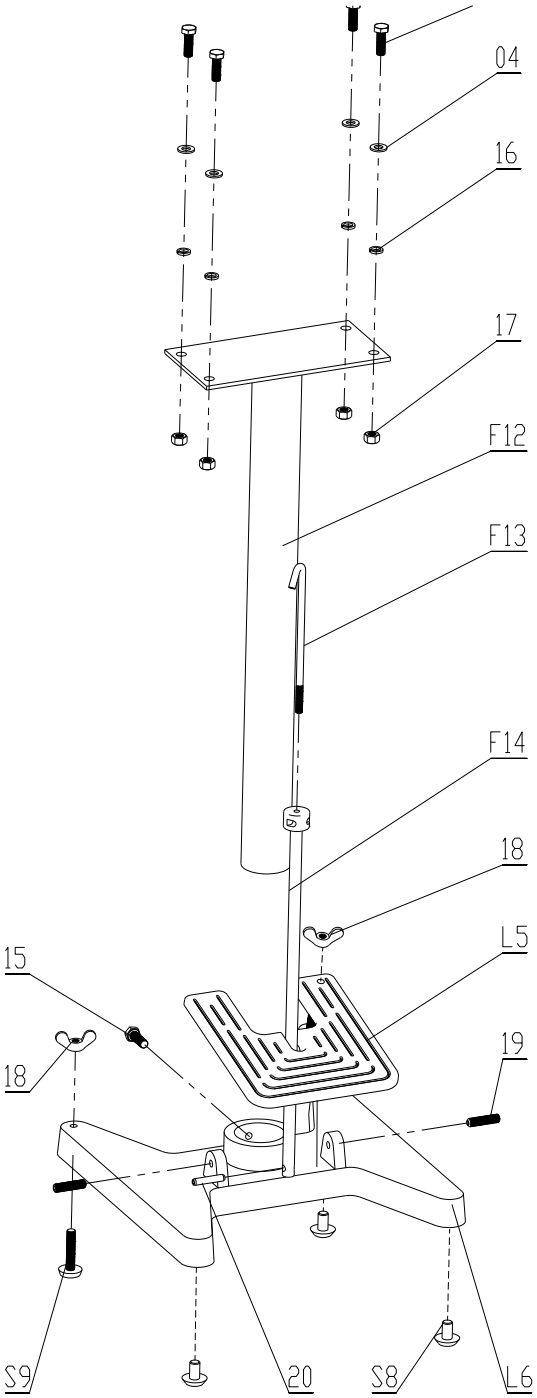


**Drawing 4 Axonometric Drawing of the Instant-heat Type base**

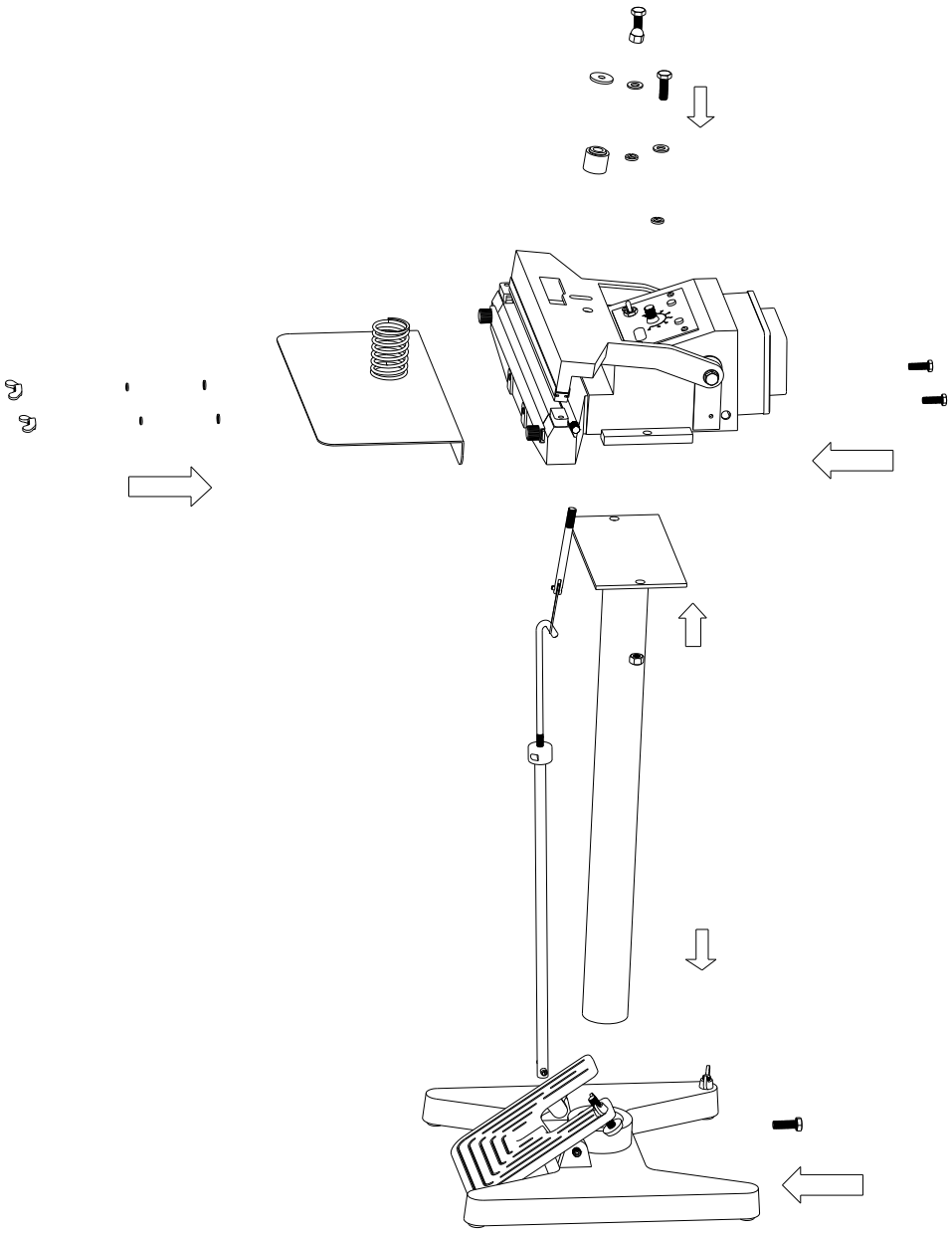



7.2.图5 直热式机体轴测图

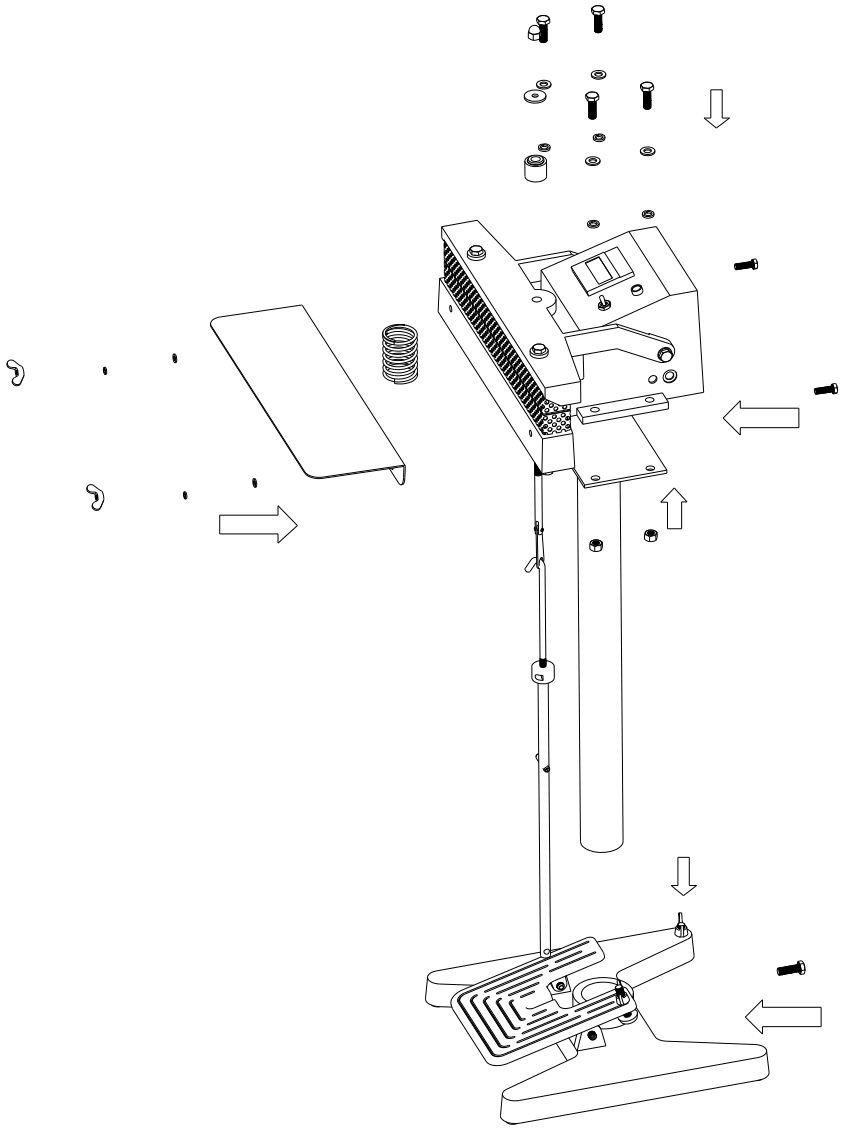
**Drawing 5 External Axonometric Drawing of the Direct-Heat Type**



**Drawing 6 Axonometric Drawing of the Direct-heat Type base**

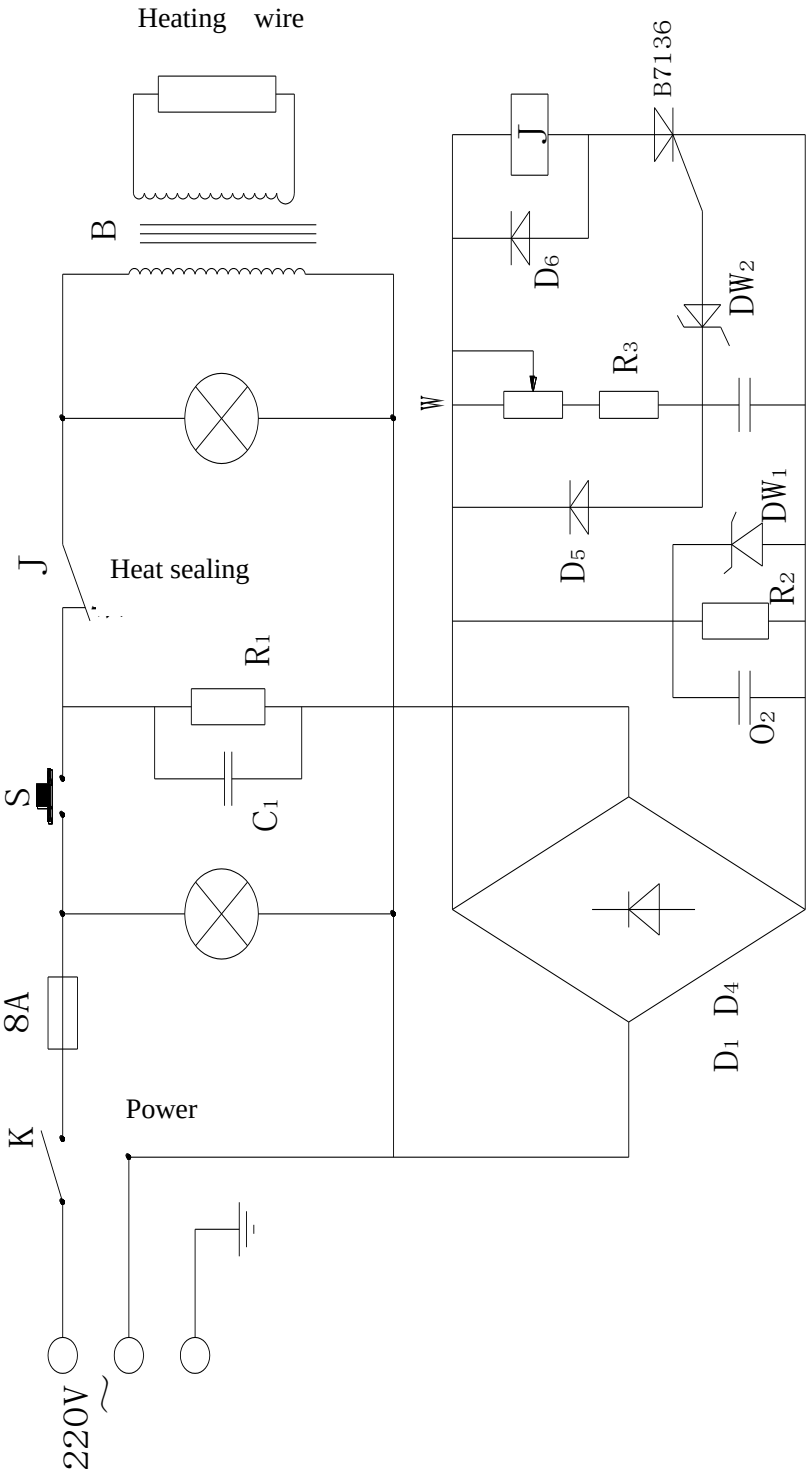


**Drawing 7 Assembly diagram of the Instant-Heat Type**

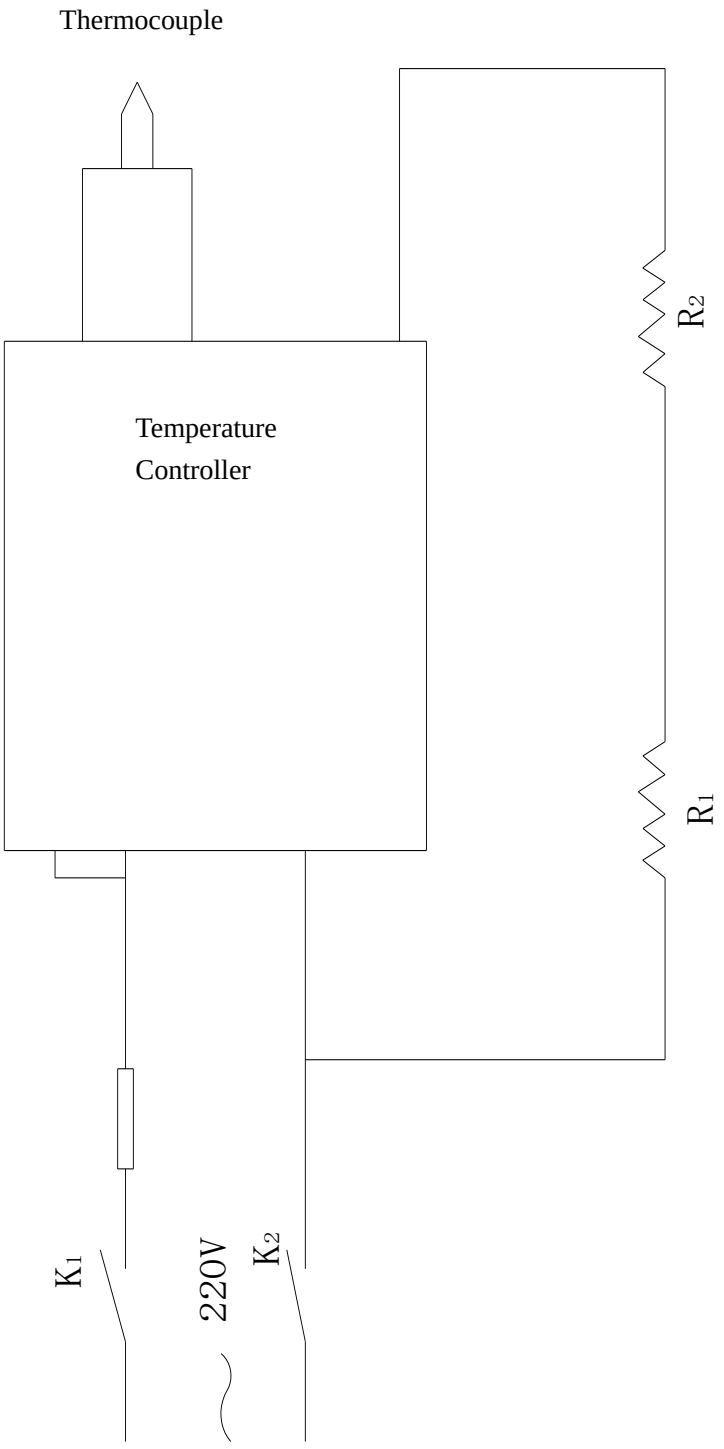


**Drawing 8 Assembly diagram of the Direct-Heat Type**

VIII. The electric c



**Drawing 9 The electric circuit diagram of the Instant-Heat Type**



**Drawing 10 The electric circuit diagram of the Direct-Heat Type**

IX. The packing list

| | |
|---|---|
| The pieces of the machine | One set |
| Cross-screwdriver | One set |
| Straight screwdriver | One set |
| Protective tube | Two sets |
| Heat-resistingTeflon | One set (Instant-Heat Type) |
| Heating wire | Two strings |
| Heat resistance rubberized fabric | One piece |
| Heating tube | One string( Direct-Heat Type) |
| Switch | One set |
| Operation Instruction | One copy |
| Certificate of quality | One copy |

## For after-sales service:

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