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Location: Moldova

Translation Original - Operating Instructions

ENGLISH

Introduction

1.1 Preface

First of all we would like to thank you for purchasing the sealing machine.
In these instructions you will find information about using the machine, servicing and care as well as process validation.

The sealing machine is a microprocessor controlled rotary sealer with printer for packaging sealable pouches and
reels (SBS[1]).

Please read these operating instructions carefully before commissioning so that you are familiar with the capabilities of the machine and you can make optimum use of its functions.

Always keep these instructions close to the machine.

1.2 Legend

	The exclamation mark in the triangle draws your attention to important notes in the operating instructions, which must absolutely be observed.
	This warning sign refers to measures that could result in danger to human health if they are not observed. It is compulsory to observe it.
	Tips with a hand symbol next to them, which relate to daily practice.

[1] Steril-Barriere-System

1.3 Important notice

In accordance with the intended use, the CE marking is displayed based on the following EU directives:
2006/42/CE, 2006/95CE and 2004/108/CE.

Medical machine directive 93/42/CE is not applicable to sealing machines.

The limit values of IEC 60601-1 may not be applied in repeated electrical inspections.

The manufacturer accepts no liability whatsoever for damage caused by tests in accordance with standards not listed in the Conformity Declaration.

Note
Because we are constantly improving our products, we reserve the right to modify these operating instructions and the functions described in them.
These operating instructions apply to products from software version V1.38 onwards.

1.4 Safety instructions

1. Our products left the plant in perfect safety condition.

2. To maintain this condition, the content of these safety instructions as well as type plates, labeling and safety instructions attached to the machine must be observed while handling the machine (transport, storage, installation, commissioning, operation and maintenance).

3. This machine is suitable for processing laminated films in the heat-sealing process. See also chapter 2.1 "Designated use".

4. Please check the packaging and lodge a complaint for any damage with the carrier or parcel service immediately before installing the machine.

5. Before commissioning, ensure that the machine does not show any evidence of damage. In case of doubt, contact the manufacturer or a service partner authorized by the manufacturer.

6. Do not operate the machine if the power cable or the power plug is damaged. Do not use the machine if it does not operate correctly or it is damaged in any way. If the mains cable or the machine have been damaged, the machine must be repaired by the manufacturer or by one of the manufacturer's authorized service partners.

7. The machine must be connected using the mains cable included in shipment to a protective contact socket with a stable voltage. Operation on IT networks is not permitted.

8. Please place the machine on a stable base.

9. The machine e must not be installed and operated in explosive areas.

10. If the sealing machine is brought directly from a cold environment into a hot environment, bedewing may occur. Wait until temperature equalization has taken place.
Starting up the machine when it is bedewed causes danger to life!

11. Fuse changes and repairs must only be performed by the manufacturer or by one of the manufacturer's authorized service partners.

12. Switch off the machine when it is not in use or remove the power plug from the socket.

13. **Before cleaning: Disconnect from the mains!** Clean the machine only with a dry or damp soft cloth and a mild cleaning agent. Do not allow any water to find its way into the machine. **Caution!** Never wet clean the machine!!

14. Do not insert pointed or flat items into the import slot of the machine. This can result in damage to the machine and instruments.

15. Do not insert items into the louvers of the machine. You may receive an electric shock or the machine could be damaged.

16. Do not use the machine if you have any doubts about machine safety.

17. The machine must not be installed or operated by persons under 16 years of age.

18. The machine must not be operated unsupervised.

19. It is forbidden to operate the machine under the influence of drugs or alcohol.

20. Your appliance contains valuable materials which can be recovered or recycled. Leave it at a local civic waste collection point. This appliance is labeled in accordance with European Directive 2002/96 EC concerning used electrical and electronic appliances equipment-WEEE).
The directive determines the framework for the return and recycling of used appliances as applicable throughout the EU.

1.5 Notes on the operation of the device

Checking the sealing seam[2]

Each sealing seam must be subjected to a visual inspection after the sealing process and after sterilisation.

The sealing seam must be intact across the entire width and length and must be fully sealed.
There must be no channels, kinks, folds, air pockets or indents.
There must be no visible signs of scorching or melting.

[2] The ASTM F1886 test method listed in EN 11607-1 Appendix B, "Standard test method for determining integrity of seals for medical packaging by visual inspection" can be used for routine visual inspections.

2 Before starting Up

2.1 Intended use

The machine is intended only for commercial and industrial use and may only be used for the intended use and with following materials.

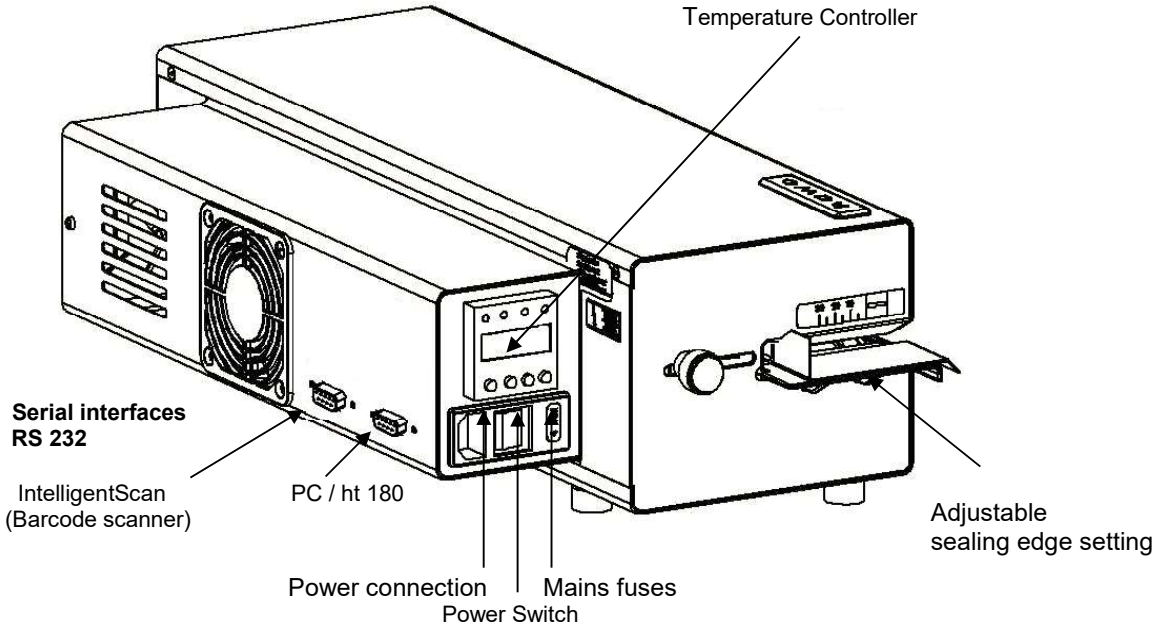
Sealable materials
Pouches and reels in accordance with EN 868-5 and EN ISO 11607-1*
Paper pouches in accordance with EN 868-4*
HDPE (e.g. Tyvek™, 1059B, 1073B and 2FS)*
Aluminum laminate film

* also with side gusset

The correct sealing temperature must be identified by means of test sealings (DIN 58953-7).
The machine output depends on the condition of the sealing material used.

Non-sealable materials
Polyethylene film
Soft PVC film
Hard PVC foils
Polyamide film
Polypropylene film

2.2 Composition and function



Sealing and printing process sequence

1. After the sterilization packaging has been inserted, the feed process is started automatically by means of photoelectric cell.
2. The sterilization packaging is now fed and the sealing seam area is heated up to the set sealing temperature by the heating units located at the top and bottom. The sealing temperature is monitored.
3. The sealing seam, which is now heated, is pressed together by the sealing roller and sealed.

4. The printing process is triggered by means of a photoelectric cell when the pressure is switched on and the activated print data is printed onto the sealed packaging.
5. The finished sterilization packaging is transported to the extraction side.
6. If no item to be sealed is fed in, the feed switches off after approximately 30 seconds.
7. The set parameters remain saved after the machine is switched on or off, or after a power failure. The date and time are updated automatically (auto safe).

2.3 Installation instructions and commissioning

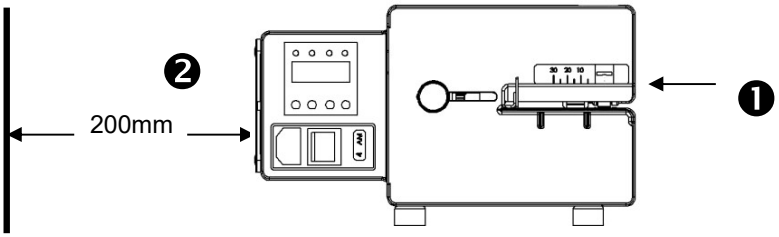
Prior to installation, read the safety notices in chapter 1.4

2.3.1 Installation

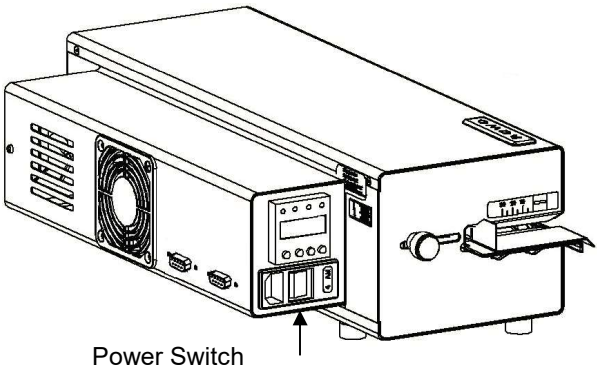
Place the machine on a horizontal surface.

❶ Please do not lift the machine by the in feed section.

❷ The distance from the machine to a wall must be at least 200 mm.



2.3.2 Commissioning



To switch on the machine, press the power switch on the left-hand side.

After a short self-test and after the selected sealing temperature has been reached, the machine is operational. You will see this when the "okay" indicator light has stopped flashing (see chapter 3.1).

3 Configuration of machine

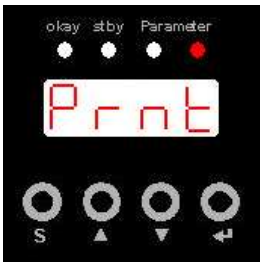
3.1 Basicf functions

Switch on the machine
The self test runs for approx. 5 seconds (see Chapter 2.3)

Indicator lights and display test

Software version indicator

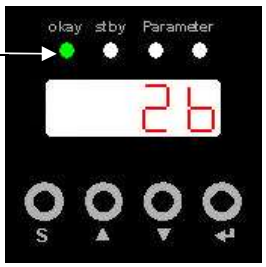
Configuration test



The "okay" indicator light flashes until the set temperature is reached, after about 3 - 4 minutes

"okay" inspection light flashes

Current actual temperature display

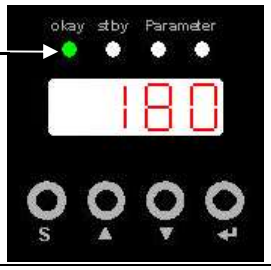


After reaching the set temperature, the indicator light remains permanently on

"okay" inspection light on

Selected actual temperature is reached

The machine is ready for use



3.2 Inspection light functions

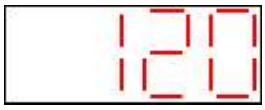
Function				
Machine switched on Warm-up phase	**flashes**	off	off	off
Sealing temperature = ± 5°	on	off	**on**	off
Sealing temperature <> ± 5°	off	on	off	**on**
Standby	off	**on**	off	on
warming up after standby or change in set temperature	**flashes**	off	off	**on**

3.3 Button functions

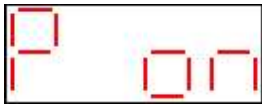
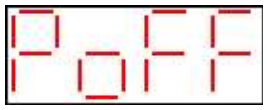
S	△	▽	↵
Menu level 1 Menu level 2 activation **Press for 3 s** Menu level 3 activation **Press for 7 s**	Switch printer off/on	Personal identification input	"Seal check" activation
Menu level 2 Sealing temperature input	Temperature value + 1	Temperature value -1	Confirm input
Menu level 3 **3.1** Sealing parameters view **3.2** Print data configuration **3.3** Data input	Switchover 3.1 - 3.2 - 3.3 I on Input value +1	Switchover 3.1 - 3.2 - 3.3 off Input value -1	Confirm input

3.4 Machine settings

3.4.1 Sealing temperature input

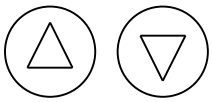
S Press button for 3s Change set value △ ▽	Display for 1s  Current temperature set value display  	↵ Confirm input

3.4.2 Switch printer off and on

△ Press button Switch printer off or on △ ▽	Display for 1s  Current setting display Printer switched on  Printer switched off 	↵ Confirm input

3.4.3 Personal code input

Press button

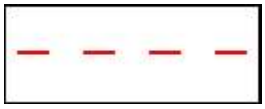


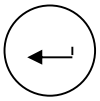
Select new code

Display for 1s

Current personal code display

☞ In this display
an alphanumeric code has been input by barcode scanner





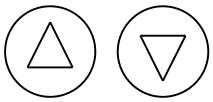
Confirm input

3.4.4 Data input

Activate

Press button for 7s

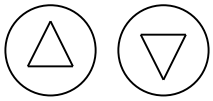
Switchover to data input

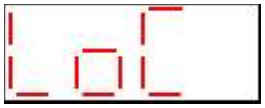


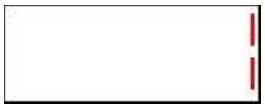
Keylock

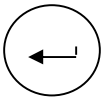
active
Input 1 - 9999

inactive
Input 0



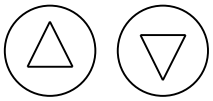


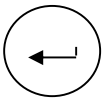




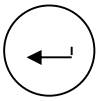
Confirm selection

Select data

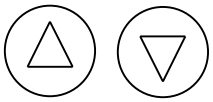
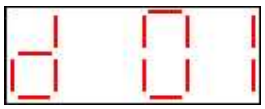
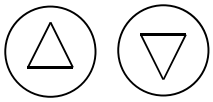
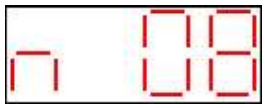
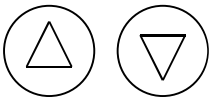
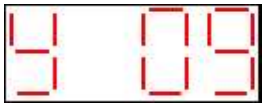
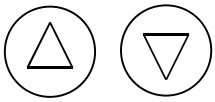
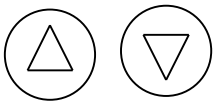
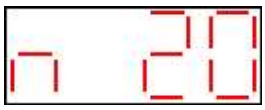


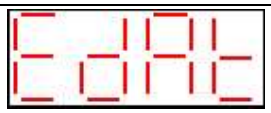
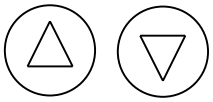
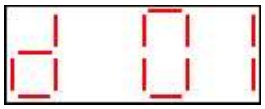
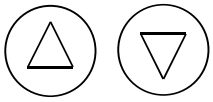
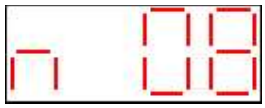
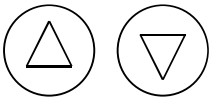
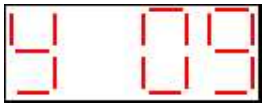


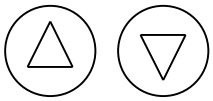
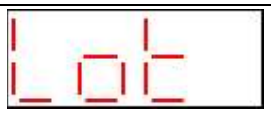
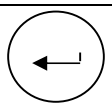
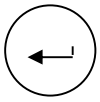
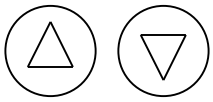
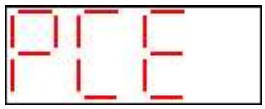
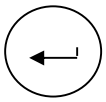
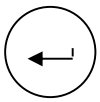
Confirm selection



Confirm input

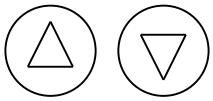
Date and time		Confirm selection
Day input 		Confirm input
Month input 		Confirm input
Year input 		Confirm input
Hour input 		Confirm input
Minute input 		Confirm input

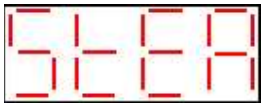
Expiry date		Confirm selection
Day input 		Confirm input
Month input 		Confirm input
Year input 		Confirm input

Batch Input 0000 - 9999 	 	 Confirm selection ☞ In this display an alphanumeric code has been input by barcode scanner   Confirm input
Pack content quantity Input 0 - 99 	 	 Confirm selection  Confirm input

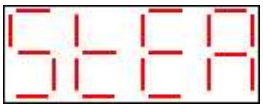
Sterilization type

Sterilization type selection

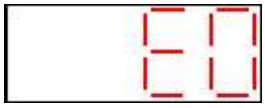




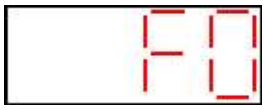
Steam



Ethylene oxide

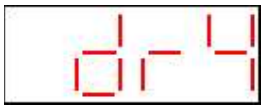


Formaldehyde

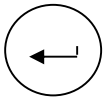


Plasma

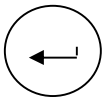
Trockene Hitze



Ionisierende Strahlung

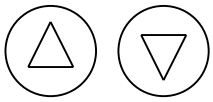


Confirm selection



Confirm selection

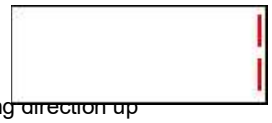
Batch counter
Input 0 - 9999



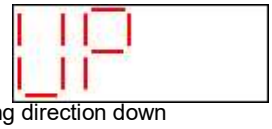
Counting direction selection

If counting direction down has been selected, an alarm sounds when the value 0 is reached

Switch off batch counter

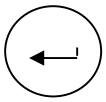


Counting direction up

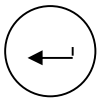


Counting direction down

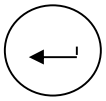
Switch off batch counter



Confirm selection

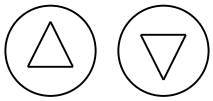


Confirm input

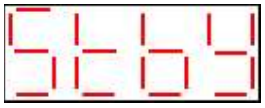


Confirm selection

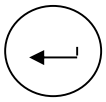
Standby
Input 0 – 60min



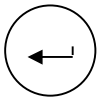
If the motor was not started before reaching the set time, then the temperature is set automatically to 50°C / 122°F.



The brief insertion of a package causes the temperature to reset to its previous set value. Once this has been reached, the machine is again ready for use



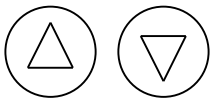
Confirm selection

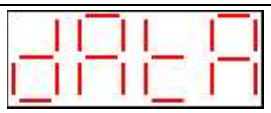


Confirm input

Operating data
View of the operating hours and the absolute batch counter

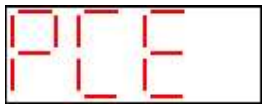
View selection

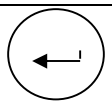




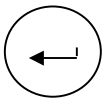
Operating hours

Absolute batch counter





Confirm selection



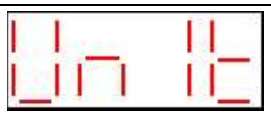
Confirm selection

Units of measurement

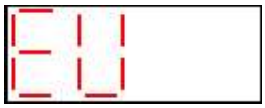
Units of measurement selection

Europe
Temperature in **°C**

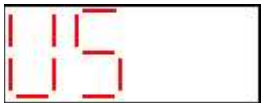
USA
Temperature in **°F**



Units of measurement Europe



Units of measurement USA



Confirm selection

Confirm selection

Character width

Input 0 - 2

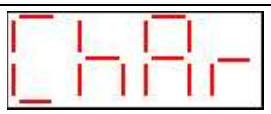
In accordance with the setting selected, the characters are printed in various widths

Input A
Automatic setting of the character width, depending on the width of the packaging and the length of the print line.

PNR

PNR

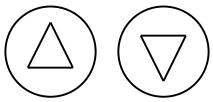
PNR



Confirm selection

Confirm input

Monitoring
Personal number
Input 0 – 60min

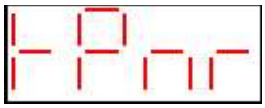


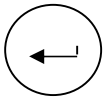
When inputting a time > 0 monitoring of the personal number is active and the motor can only be started if the value of the
personal number is 1-9999

Once the set time is reached, the personal number is automatically set to 0

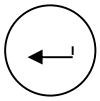
If the personal number is 0000 and a package is inserted, a command prompt appears

By inputting a personal number of 1-9999, the lock of the drive motor is disabled and the command prompt disappears





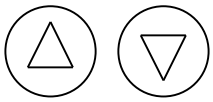
Confirm selection



Confirm input

Date format

Date format selection



1 DD.MM.YYYY

2 MM.DD.YYYY

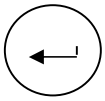
3 YYYY.MM.DD

4 YYYY.MM

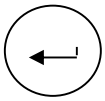
5 DD.MM.YY

6 MM.DD.YY

7 YY.MM.DD



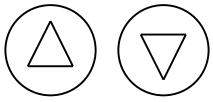
Confirm selection



Confirm selection

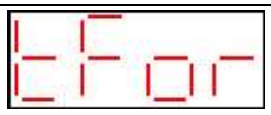
Time format

Time format selection

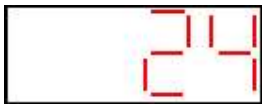


24 13:26

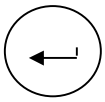
12 01:26 PM



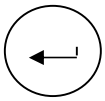
Time format 24h



Time format 12h



Confirm selection



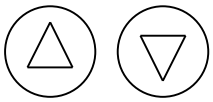
Confirm selection

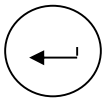
3.4.5 Print data selection

Activate

Press button for **7s**

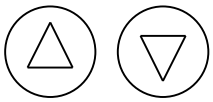
Switchover to print data





Confirm selection

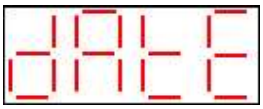
Select data to be printed

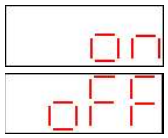


The print sequence is predefined.
Activated print data is always printed in this sequence

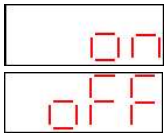
Sterilization date
Time
Expiry date
Batch counter
Personal identification
Batch counter
Sterilization type
Pack content quantity
Text
(with barcode list and attached barcode scanner)

Sterilization date

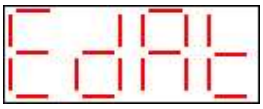


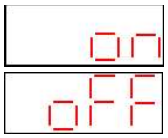


Time

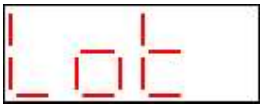


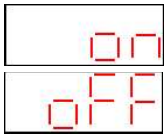
Expiry date



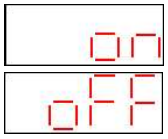


Batch number

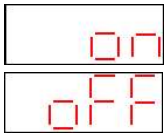




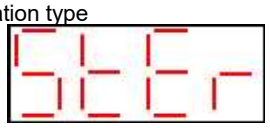
Personal identification

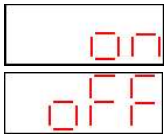


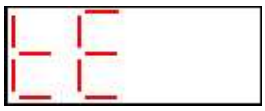
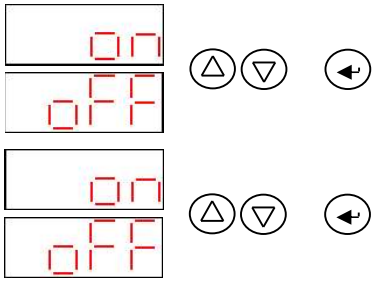
Batch counter



Sterilization type

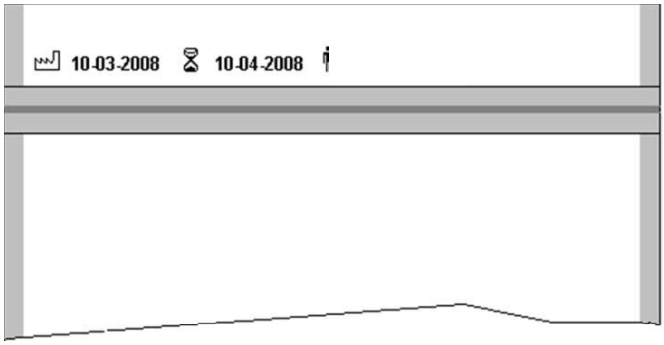




	Pack content quantity  Text 	

Example

Printing the sterilization date and the expiry date



3.4.6 IntelligentScan, connection of a barcode scanner

The following inputs and functions can be implemented using a hm 780 BR barcode scanner (item number 1.421.006) connected to the "IntelligentScan" interface (see page 9), and relevant barcode lists:

Inputs and functions via the controller or using the barcode scanner

Inputs

Functions

Inputs and functions only with the barcode scanner

Inputs
Input of a 10-digit alphanumeric personal code
Input of a 10-digit alphanumeric batch designation
Input of an alphanumeric text
Expiry dates in 1, 3, 6, 9, 12, 24 and 60 months

Functions
Switching the batch counter off or on

☞ The Tecno Scan barcode scanner (item number 1.421.017) is supplied with a CD (item number 1.490.016) enclosed, facilitating the generation and recording of the barcode lists on a PC.

⚠ Please only use barcode scanners approved by Tecno-Gaz
Tecno-Gaz accepts no liability for any damaged caused by the connection and use of other barcode scanners.

3.5 Operation and sealing process

- The material to be sealed must be sealed according to the manufacturer's instructions.

- Set the peel edge width:
  After the locking machine has been loosened, the peel edge can be set by shifting the in feed section variably between 0 mm and 35 mm. A sufficient protrusion must be available between the sealing seam and the reel interface given on the extraction side

- Sterilization packaging must be inserted from the left-hand side, always with the side to be printed face down.
  The drive is switched on automatically.

- Remove the sealed sterilization packaging and leave briefly to cool.

The correct sealing temperature must be identified by means of sealing tests. Sealing must be performed in such a way that the sealing seam meets the quality characteristics requirements of EN ISO 11607-2, even with varying material thicknesses. The following quality characteristics must be met:

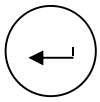
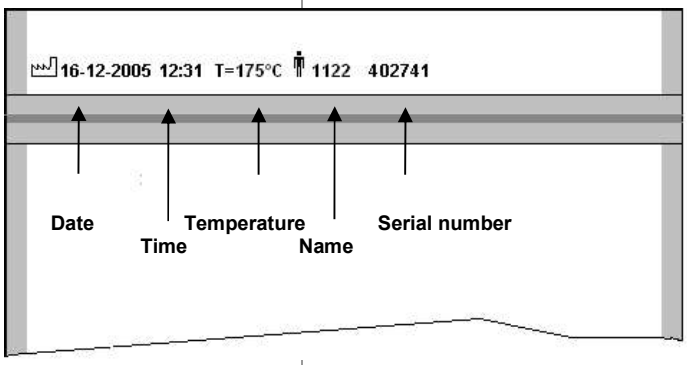
- Intact sealing across the entire sealing seam width
- No channels or open seals
- No punctures or tears
- No delamination or material separation

3.6 Sealing seam test – "Seal Check"

Testing of the critical process parameters temperature, contact pressure and sealing time with "SEAL CHECK".
This test should be performed before and after the daily working process and/or before/after each load and can be documented by routinely filing the printout (EN ISO 11607-2).

The additional use of the SEAL CHECK sealing indicator in combination with the SEAL CHECK function of the sealing machine is recommended.

Before the test, the machine must be ready for use and the set temperature must have been reached.

Machine ready for use **Specified set temperature has been reached**  Press button	
Sterilization packaging, minimum width 200 mm and insert SEAL CHECK indicator strips if necessary	

4 Troubleshooting and servicing

4.1 Troubleshooting checklist

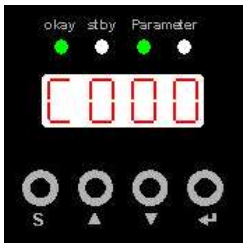
The trouble shooting suggestion marced with a * may only be carried of a service partner authorised by the manucaftuer.

Malfunction	Possible cause	Troubleshooting
Machine does not switch on No data in the display	Mains connection - Mains cable not plugged in	Check mains connection and connect to another socket if necessary
	- Mains cable defective	Replace mains cable
	Mains fuse	Replace mains fuse* ! In case of repeated failure you must have the machine fuse checked
	Temperature controller defective	Replace Temperature controller*
Machine not heating up	Set temperature too low	Increase set temperature (see page 13)
	Temperature limitation active	Reset the temperature limiter by pushing down the pin ! In case of repeated activation you must have the machine checked
	Temperature sensor	Replace temperature sensor*
	Heating element	Check heating element and replace if necessary*
	Temperature controller defective	Replace Temperature controller
	SST Module defective	Replace SST Module*
No feed	Conveyor belt - damaged - no feed	Replace conveyor belt Check belt tension
	Front flap not closed	Close front flap
	Motor - sensor	Replace light barrier*
	Front flaps - sensor	Replace front flap sensor*
	Motor	Replace motor*
	Temperature controller defect	Replace Temperature controller*

Malfunction	Possible cause	Troubleshooting
Uneven material feed or loud running noise	Conveyor belt guide Conveyor belt - damaged - no feed Motor	Replace PTFE belt on guide unit (see pages 25-26) Replace conveyor belt Check belt tension Replace motor*
Sealing seam does not hold	Temperature too low Contact pressure too low Sealing unit - Distance between sealing units too large	Increase temperature Adjust the contact pressure of the sealing roller or replace the sealing roller* Set sealing unit clearance to 0.5 mm*
Sealing seam distorted	Contact pressure too high	Adjust sealing seal roller contact pressure or replace sealing roller*
Paper side of the packaging discolored or side gusset shrunk	Temperature too high	Reduce temperature (see page 13)
No imprint or imprint incomplete	Programming - Printing start margin incorrectly set Ribbon Printer control Switched – mode power supply defective	Program the printing start margin again (see page 12) Ribbon not inserted correctly Replace ribbon. (see page 24) Replace printer control* Replace power supply*
Imprint too weak	Ribbon Print head Paper - pressure roller	Replace ribbon. Adjust print head again Paper - adjust pressure roller

4.2 Alarm functions and error displays

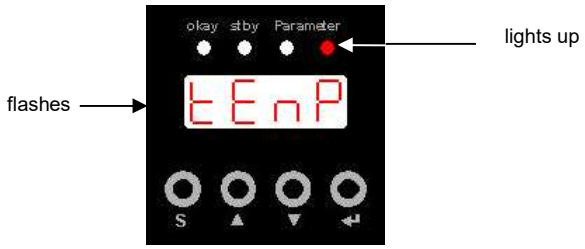
4.2.1 Alarm functions

Batch counter, set to count down, has reached the value 0	flashes → 	
		Canceling the Alarm
		Set batch counter to a value > 0 or Set batch counter direction to up **see page 19**

4.2.2 Error displays

> The trouble shooting suggestion marced with a * may only be carried of a service partner authorised by the manucaftuer.

Sealing temperature outside tolerance



Possible cause	Troubleshooting
Temperature sensor defective	Replace temperature sensor*
Temperature Controller defective	Replace controller*
SST module defective	Replace SST module*

4.3 Servicing / calibration

Like all technical machines, your machine is also subject to technical wear.
In order to guarantee continuous operational readiness, your machine should be inspected regularly by a competent person and serviced and calibrated at least once per year by the manufacturer or by one of the manufacturer's authorized service partners.

Maintenance chart	Ink ribbon	PTFE strip for guide die	Pressure roller	Toothed belt	Sealing die interval	Critical process parameters calibration
At least every 3 months						
Depending on use, at least once annualy						

Legend:

4.4 Parts Service

Simply order parts by fax:

- Please copy the following pages according to the parts required.
  Page 31: Parts required for maintenance and wear
  Page 32: Replacement parts

- Enter machine number. →
- Enter machine model →
- Enter name, address, fax number and order number.
- Mark items required
- Enter quantity required.
- Sign order.
- Fax order.

No.: 123456
Type: Tecno Seal Print

To: _____

Fax No. _____

Sender: _____

_____

Your order no.: _____		**Date** _____	
Machine model _____		**Seral number** _____	
☑	**Designation**	**Part No**	**qty**
☐	Ink ribbon black	6.813.104	
☐	Ink ribbon red	6.813.224	
☐	PTFE strip for upper guide rail	6.105.178	
☐	PTFE strip for lower guide rail	6.105.177	
☐	PTFE strip for heating die	6.105.125	
☐	Pressure roller plastic	2.230.008	
☐	Toothed belt drive	6.271.018	
☐	Toothed belt, material transport	6.271.019	
☐	Heating cartridge	6.536.024	
☐	Upper sealing die complete	1.616.049	
☐	Lower sealing die complete	1.616.050	
☐			
☐	Print head	1.653.002	
☐	Reed Contact	6.543.011	

Signature _____

To: _____ **Sender:** _____

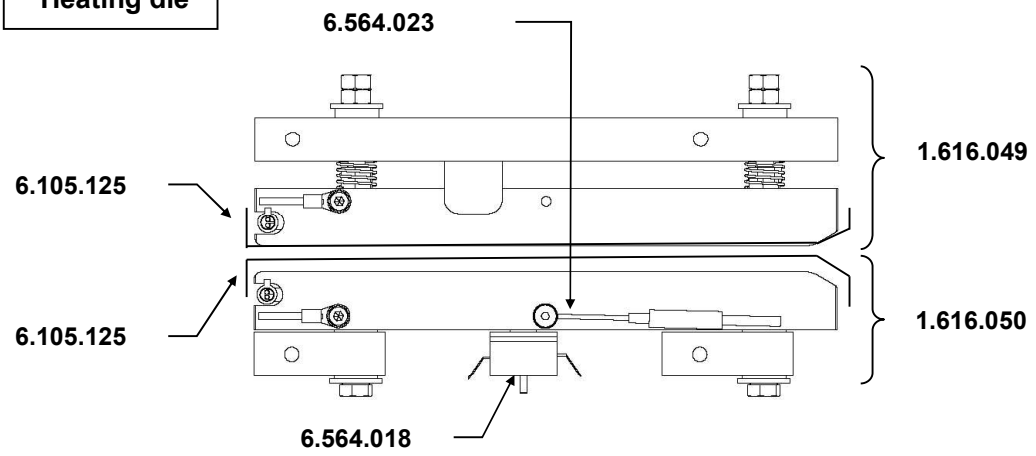
Fax No. _____ _____

Your order no.: _____		**Date** _____	
Machine Model _____		**Serial number** _____	
☑	**Designation**	**Part No**	**qty**
☐	Temperature control 100 - 245V	6.564.042	
☐	Printer control	1.461.013	
☐			
☐	SST Module	1.461.014	
☐	Switched –mode power supply	6.533.001	
☐	Light barrier printer	1.561.003	
☐	Light barrier motor	1.561.010	
☐ ☐ ☐	Gear motor 230V 115V 100V	1.212.026 1.212.027 1.212.028	
☐			
☐	Motor ink ribbon	1.212.012	
☐	Temperature limit switch	6.564.018	
☐	Thermocouple	6.564.023	
☐	Fan 24V	6.212.028	

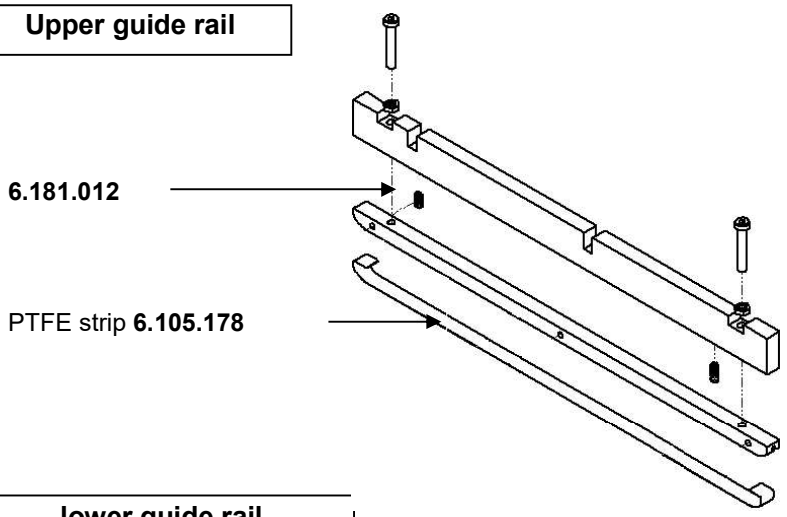
Signature _____

4.5 Replacement part orders- allocation of article numbers

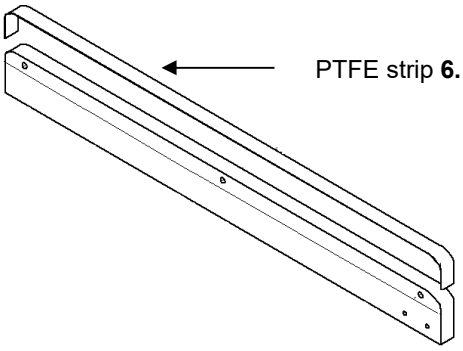
Heating die



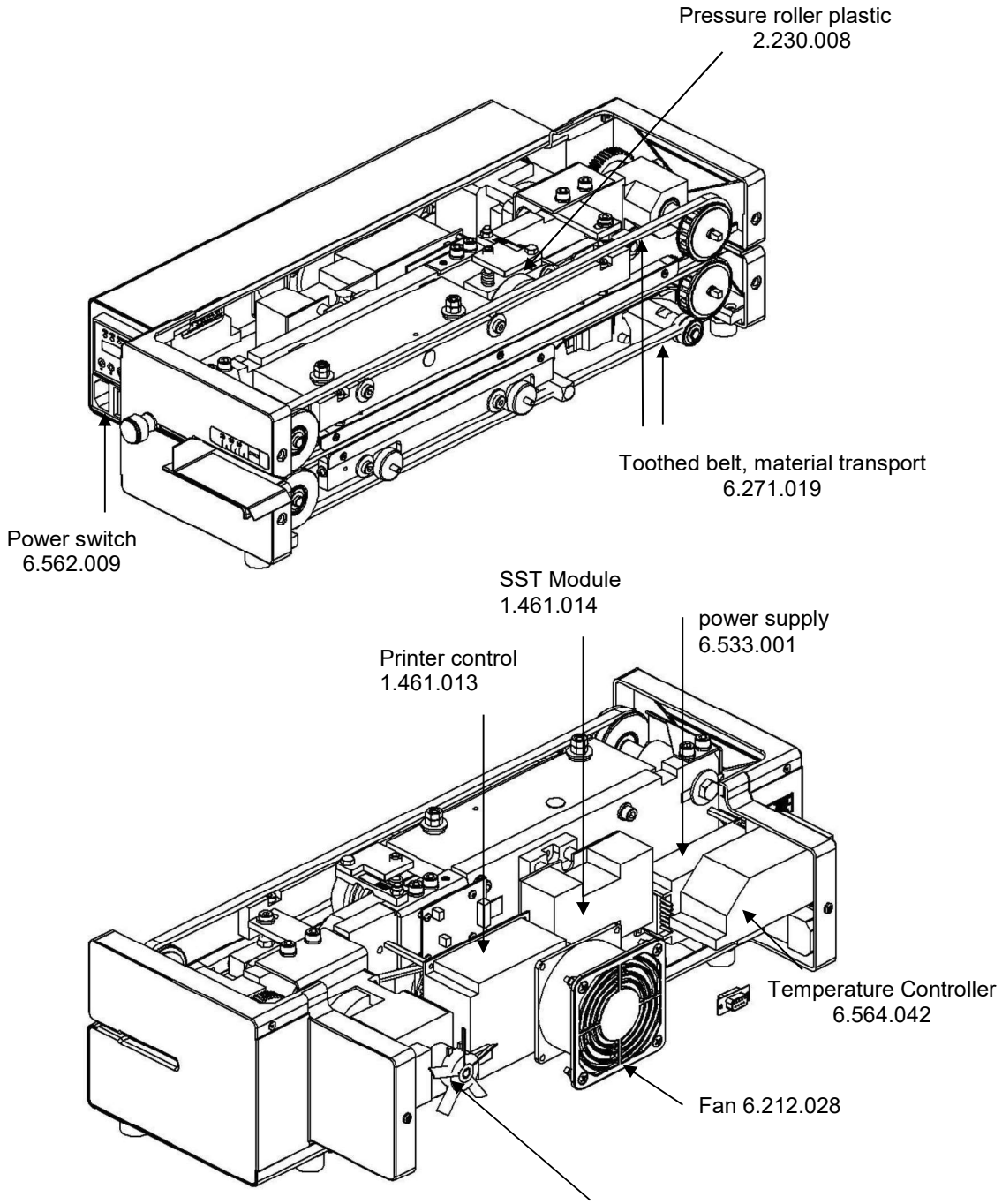
Upper guide rail



lower guide rail



4.6 Spare part ordering – Complete overview



	Gear motor 230V 115V 100V	1.212.026 1.212.027 1.212.028

4.7 Information about replacing wearing and spare parts

! Please use only **genuine replacement parts**

Replacing ink ribbon

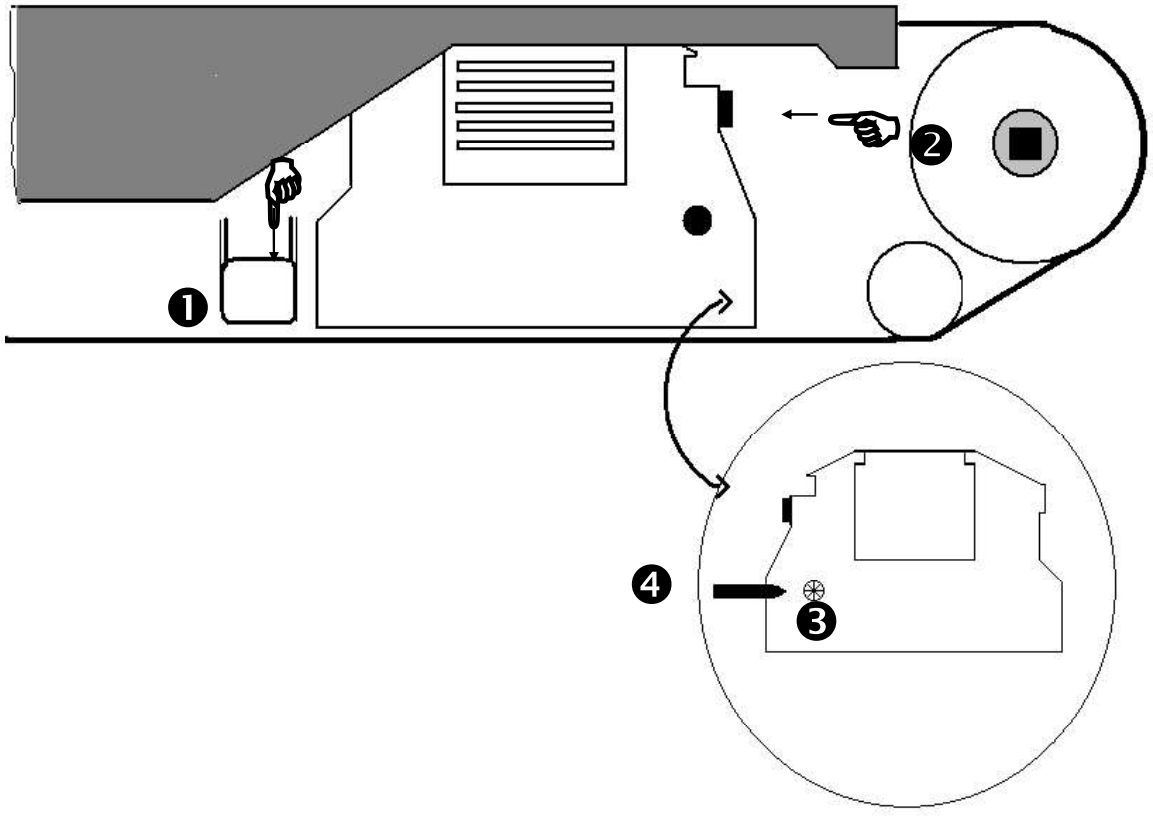
➔ **Switch off machine**

- Open front flap, set in feed section to 0 if appropriate
- Press lever for ink ribbon holder ❶ down with left hand.
- Press holder for rink ribbon cassette ❷ to side and remove cassette.
- Insert new ink ribbon cassette

Always ensure that the transport opening ❸ in the cassette is attached to the transport shaft ❹.

- Press ink ribbon cassette toward rear until holder ❷ catches
- Close front flap

➔ **Switch on machine and check printing function after reaching nominal temperature**



Maintenance Information

! Please use only **genuine replacement parts**

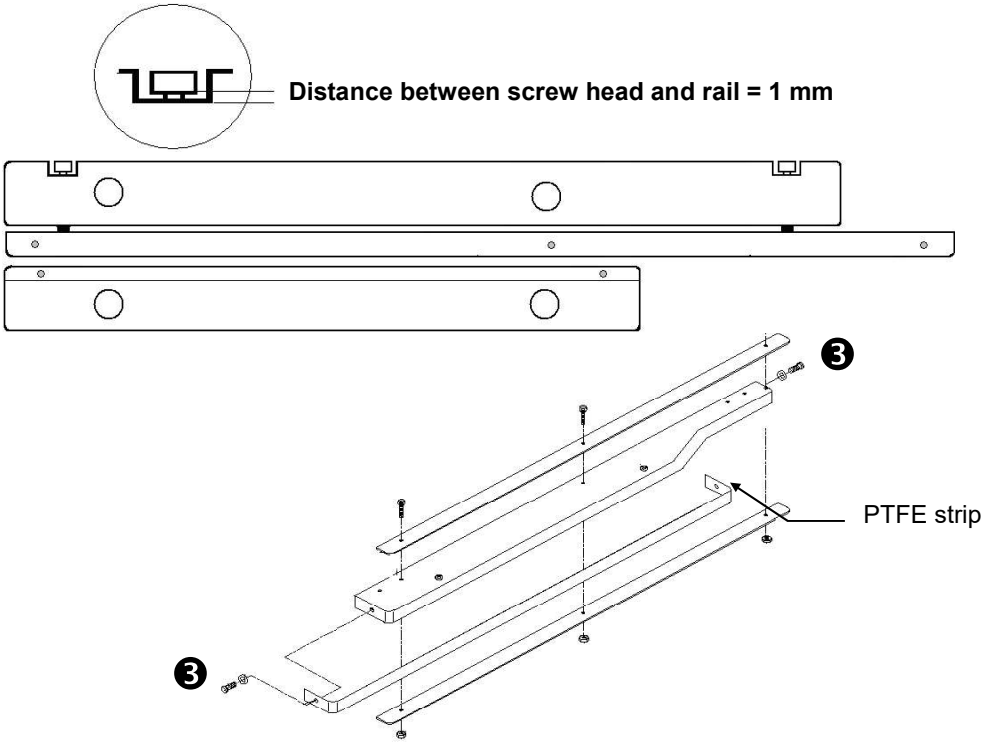
Replacing PTFE strip on guide rail

➔ Switch off machine and DISCONNET POWER PLUG !

- Open housing
- Remove mounting screws ❶ for upper guide rail and remove guide rail **or**
- Remove mounting screws ❷ for lower guide rail and remove guide rail
- Remove mounting screws ❸ and detach PTFE strip
- Pull backing foil off of new PTFE strip and glue new PTFE strip on straight and without wrinkles
- Fasten PTFE strip with screws ❸
- Install guide rail

☞ When installing the upper guide rail before fastening, push the die down so that the interval between the screw head and rail is 1 mm on both sides. This ensures the correct contact pressure for the guide rail.

- Close housing



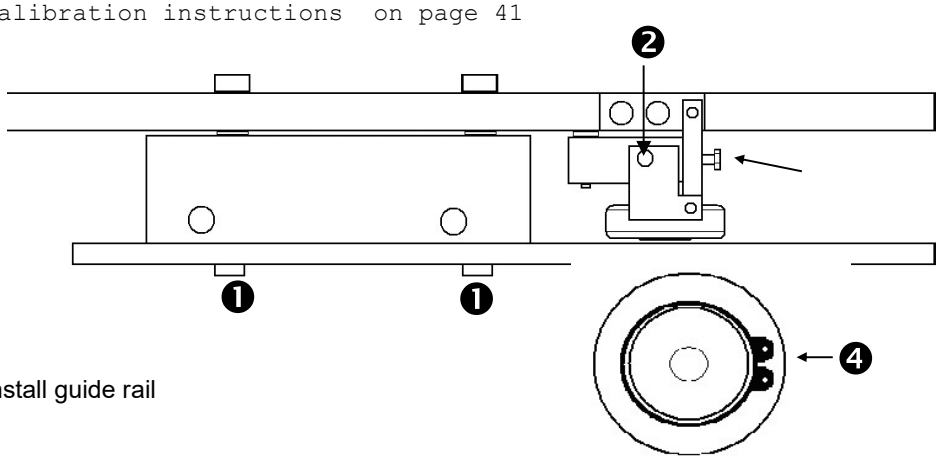
Maintenance Information

! Please use only **genuine replacement parts**

Replacing pressure roller

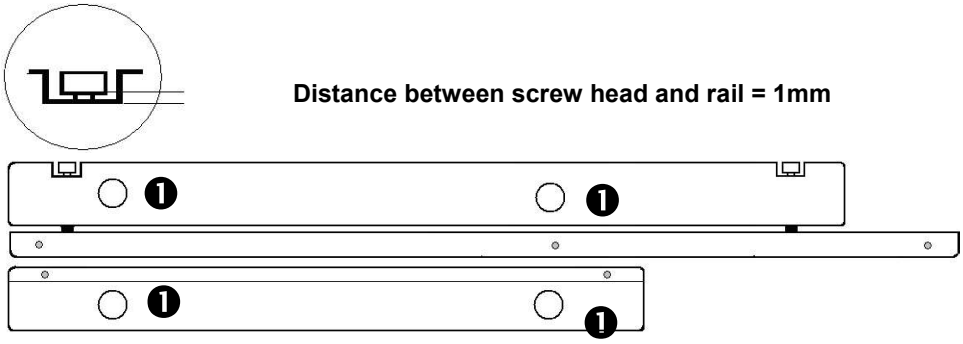
➔ Switch off machine and DISCONNET POWER PLUG !

- Open housing
- Remove mounting screws ❶ for upper guide rail and remove guide rail.
- Unscrew pressure adjustment screw ❷ approx. 5 mm
- Loosen mounting screw ❸ and pull pressure roller completely out of holder
- Detach snap ring ❹ and remove pressure roller
- Install new pressure roller and fasten with snap ring ❹
- Position complete pressure roller in holder, center in relation to bottom roller and tighten mounting screw ❸
- Adjust contact pressure by screwing in adjustment screw ❷ according to calibration instructions on page 41



- Install guide rail

☞ When installing the upper guide rail before fastening screws ❶, push the die down so that the interval between the screw head and rail is 1mm on both sides.
This ensures the correct contact pressure for the guide rail



- Close housing

4.8 Process parameters adjustment

☞ After adjustment, the machine should remain switched on for a further 10 seconds!

4.8.1 Temperature control

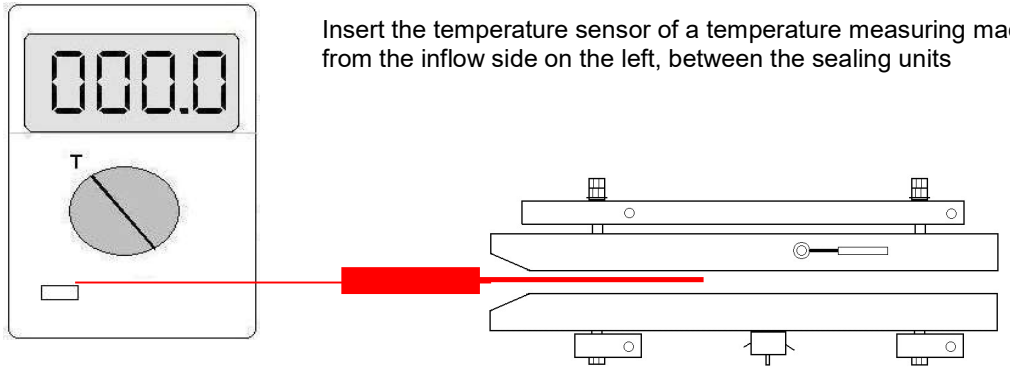
The temperature control adjustment should always be carried out after replacing a heating element,
after replacing the temperature sensor and after replacing the temperature control

The temperatures **120 °C and 200 °C** are measured consecutively and the difference between set and actual value corrected.

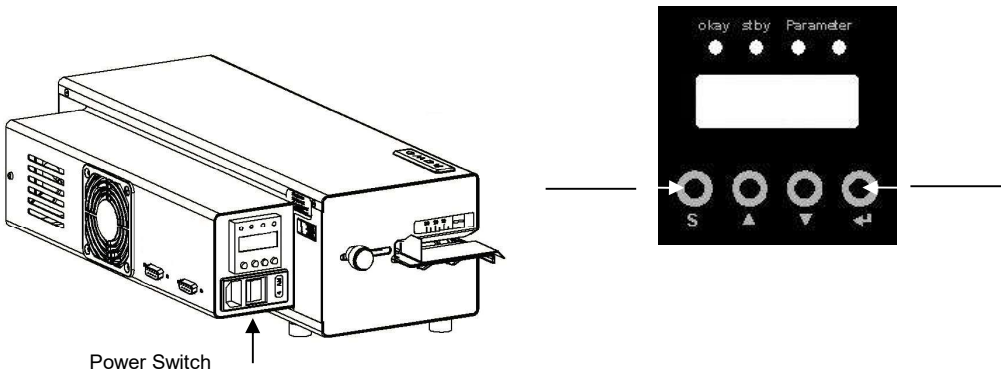
After reaching the set temperature, this is stabilized for 120 s.
At the end of 120 s, the temperature value measured with the temperature gauge is input

Process

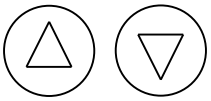
Insert the temperature sensor of a temperature measuring machine from the inflow side on the left, between the sealing units

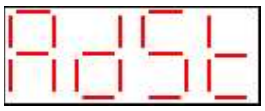


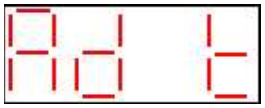
Press both buttons simultaneously and switch on the machine.



Select temperature adjustment



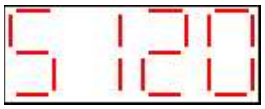




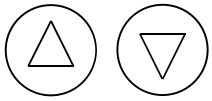
Confirm selection

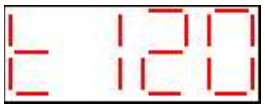
The set temperature of the machine is set automatically to 120 °C

After reaching that temperature the stabilizing time starts



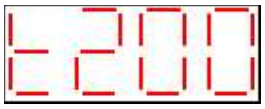
After expiry of that time input the temperature measured with the measuring device



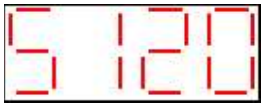


Confirm input

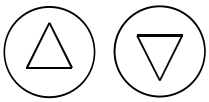
The set temperature of the machine is set automatically to 200°C

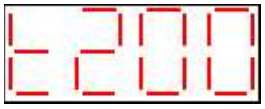


After reaching that temperature the stabilizing time starts



After expiry of that time input the temperature measured with the measuring device

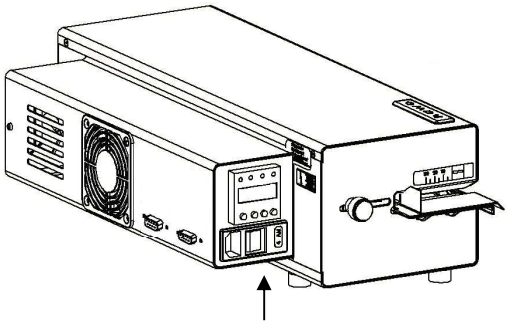


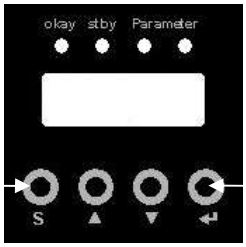


Confirm input

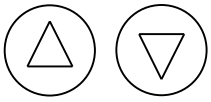
4.8.2 Setting the transmission rate (baud rate) of the serial interface

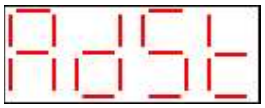
Press both buttons simultaneously and switch on the machine





Select baud rate setting

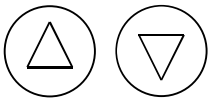




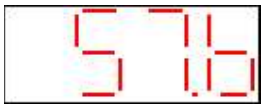
Confirm selection

Select baud rate

1200Bd – 57600Bd



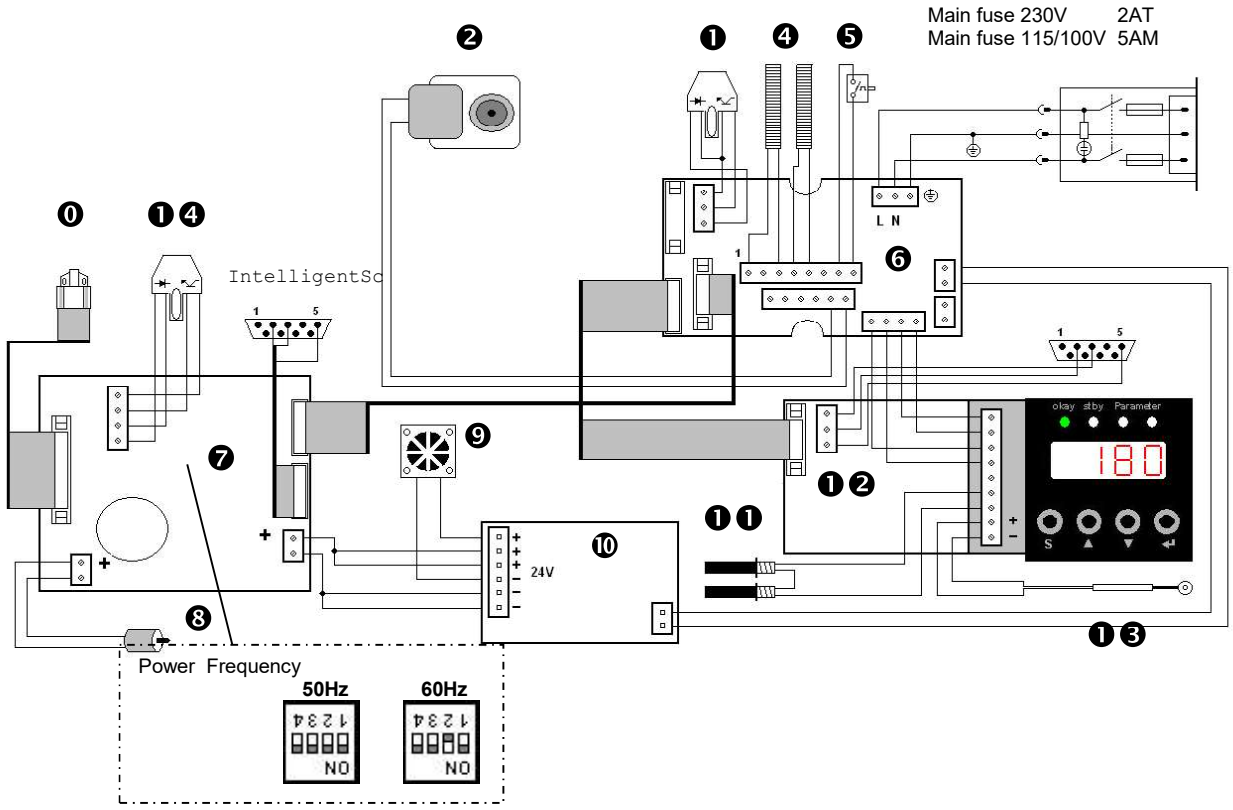
Example: Baud rate 57600Bd



Confirm selection

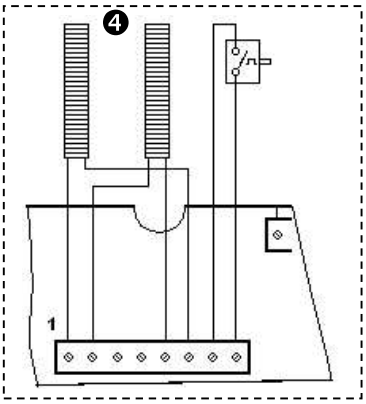
5 Technical Data

5.1 Circuit and Wiring Diagram



⓪	Print head	1.653.002
❶	Light barrier motor	1.561.010
❷	Gear motor 230V Gear motor 115V Gear motor 100V	1.212.026 1.212.027 1.212.028
❹	Heating cartridge	6.536.024
❺	Temperature limit swwitch	6.564.018
❻	SST Module	1.461.014
❼	Printer control	1.461.013
❽	Motor ink ribbon	1.212.012
❾	Fan	6.212.028
❿	Switched-mode power supply	6.533.001
❶❶	Reed contact	6.543.011
❶❷	Temperature control	6.564.042
❶❸	Thermocouple	6.564.023
❶❹	Light barrier printer	1.561.003

Heating elements connection at 115/100 V



5.2 Specifications

Connection data

Power connection	[V]	230 /115 /100
Power frequency	[Hz]	50 / 60
Power consumption standard	[W]	390
Power consumption max.	[W]	500
Main fuse 230V (110V / 115V)	[A]	2 T (5 M)

Mechanic

Dimension	Length Width Height	[mm]	560 250 145
Housing cover			Steel AISI 304
Housing buttom			Steel AISI 304
Weight		[kg]	14
Sealed edge infinitely adjustable		[mm]	0 – 35
Sealing seam width		[mm]	12
Length of sealing seam		[mm]	unlimited
Sealing seam distance from pack content		[mm]	>30 (DIN 58953-7:2003)

Process parameter / Sealing parameter

Sealing temperature max.	[°C]	220
Tolerance limit motor stop temperature	[°C]	± 5
Temperature ranges		1
Temperature-tolerance	[%]	±2

Electronic und Communication

System		Microprozessor
Serial Interfaces:	RS-232 connector for PC RS-232 connector for bar code scanner USB with adapter Ethernet (LAN) with adapter	yes yes optional available (Art.-Nr.: 1.596.024) optional available
Datea rate (Baudrate) [Bd]		RS 232 PC 1200 – 57600 RS 232 Bar Code Scanner 9600
Protection class		1

Environmental parameter

Heat dissipation	[kJ/s]	0,1
Noise intensity	[dB/ A]	<70