

## 9 Replacing the routine maintenance parts

Replace parts according to the following directions in order to maintain your machine in optimum operating condition.



Do not replace parts according to other methods not described in the operating instructions. It is dangerous if incorrect methods are used.



Always unplug power plug before replacing any parts. There is a danger of electrocution if conducted with the plug still inserted.



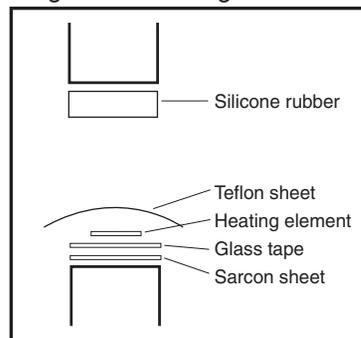
Always unplug power plug from the wall outlet before conducting any maintenance.

### Construction of the sealing section

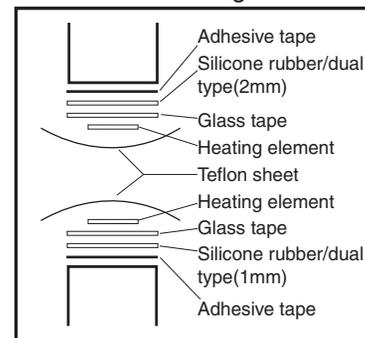
The sealing section is constructed with parts illustrated in the diagram below.

When replacing parts, be careful to arrange the parts in the same exact order.

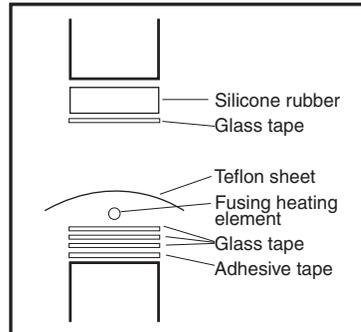
Single side heating



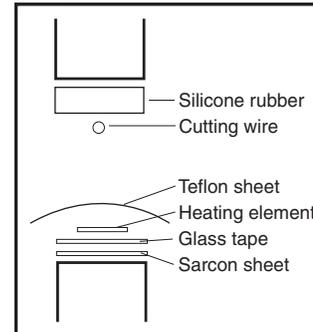
Double side heating



Melt-cut type



5C type



### Routine maintenance parts

As you use the sealer, the parts wear, sealing result is worse. The routine maintenance parts are sold by the unit described below. Order to your dealer, specifying the name of your machine, the name and quantity of parts you need.

Parts name	Selling unit
Teflon sheet	2 sheets per set
Silicone rubber	1 pc.
Plastic nut (Black)	5 pieces per set
Glass tape 25mm width	5M or 10M roll
Sarcon sheet	2 pieces per set or 5M roll
Heating element (10mm)	10 pieces per set
Heating element (5mm)	20 pieces per set
Silicone rubber / dual type	2pcs.per set
Electrode (800,1000,1200mmtype)	2pcs.per set
Electrode (1500mmtype)	1 pc.
Center dry tape (FiF-C double side heating type)	40mm X5M 1 roll

## 9-1 Slide the teflon sheet

[Replace when] When the teflon sheet is torn, burnt or sealing is dirty

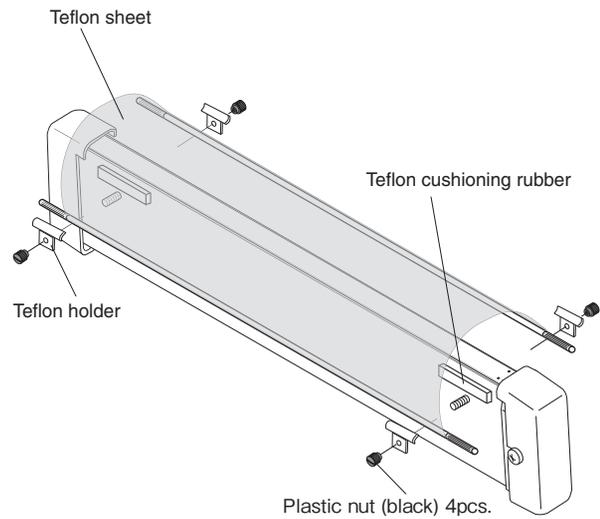
[Essential tools] Scissors

When the teflon sheet is damaged, slide the damaged part forward to appear the new (non damaged) part.

If the Teflon sheet has adhered to the heating element, peel off it carefully.

Teflon is rolled 25 - 30cm for the use as spare. When remained part becomes short, please replace the whole teflon sheet (Refer to "9-2 Change the Teflon sheet.")

- 1 Loosen the four plastic nuts (black) securing the teflon holder.
- 2 Wind the damaged parts – about 15mm length forward or backward.
- 3 Wind the teflon sheet tightly and fasten the plastic nuts (black).

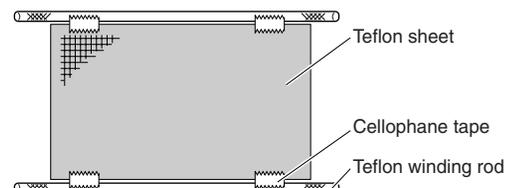


## 9-2 Change the teflon sheet

[Replace when] Reserved teflon sheet (rolled, clean part) has run short

[Essential tools] Scissors, Cellophane tape

- 1 Unscrew the plastic nuts (black) securing the teflon holder.
- 2 Remove the teflon holder, then remove the old teflon sheet from roll bar.
- 3 Attach the new teflon sheet by cellophane tape with roll bar.
- 4 Set the Teflon roll bar, attach the Teflon holder and screw plastic nuts (black) lightly.
- 5 To avoid wrinkles of the teflon sheet above the heating element, wind the teflon roll bar again.
- 6 Fasten the plastic nuts firmly.



### 9-3 Change the heating element (For single / double side heating)

[Replace when] The heating element has burned out.  
Sealing is dirty or uneven.

[Essential tools] Phillips screwdriver  
Hexagonal wrench 3mm (1500type only)

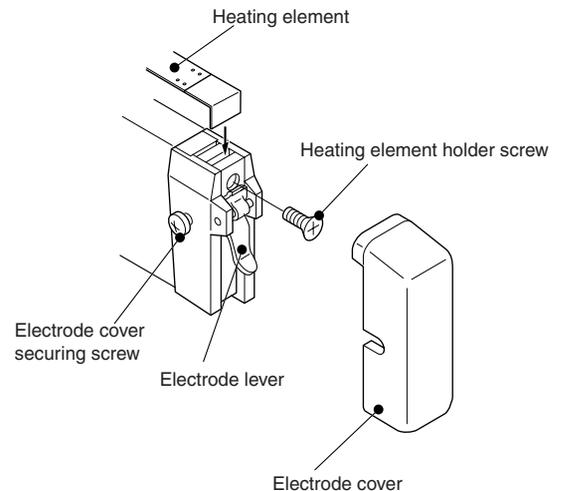
#### For sealing length 600, 800, 1000mm

- 1 The heating element is covered with the teflon sheet. Remove the teflon sheet, referring to "9-1" or "9-2".
- 2 The electrode cover is secured on the side. Loosen the electrode cover securing screw by Phillips screwdriver and pull to remove it.
- 3 Raise the electrode lever (on the upper lever: downward / on the lower lever: upward). Loosen the heating element holder screw by Phillips screwdriver.
- 4 Damaged heating element can be removed.
- 5 Insert the ends of new heating element terminal into the groove of electrode. Hold down the ends of heating element with your fingers so that it does not slip from the electrode. Secure the heating element holder screw. Then return the electrode lever.

 **Caution** For your safety, be sure to mount the electrode cover after installing heating element.

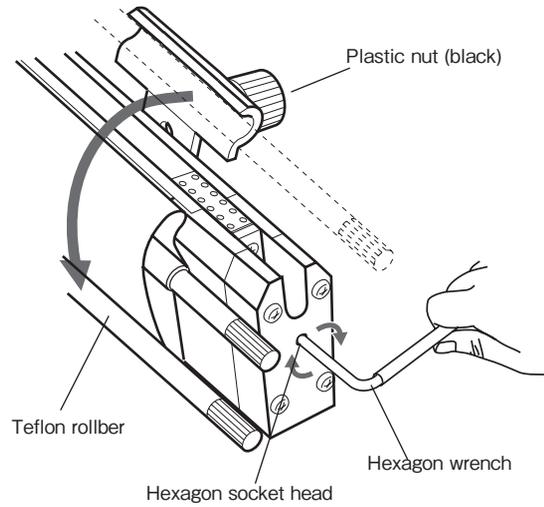
When replacing the heating element, always use the specified heating element for your machine.

If unspecified heating element is used, the transformer may fail.

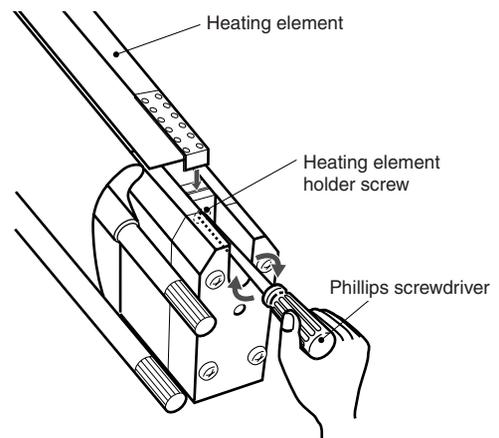


**For sealing length 1500mm model**

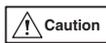
- 1 The heating element is covered with the teflon sheet. Loosen the plastic nut (black) and move the teflon roll bar forward to appear the heating element.
- 2 Slowly turn the hexagon socket head clockwise and loosen the heating element.



- 3 Loosen the heating element holder screw, and remove the heating element.



- 4 Insert the new heating element into the groove. Tighten the heating element holder screw so that the heating element does not slip from the electrode. Turn the hexagon socket head counterclockwise to extend the heating element. Return the teflon roll bar and fix it by plastic nut (black).

 **Caution** When replacing the heating element, always use the specified heating element for your machine. If unspecified heating element is used, the transformer may fail.

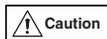
## 9-4 Change the fusing heating element (Melt-cut type)

[Replace when] The heating element has burned out.

Sealing is dirty or uneven.

[Essential tools] Phillips screwdriver, Screwdriver (-)

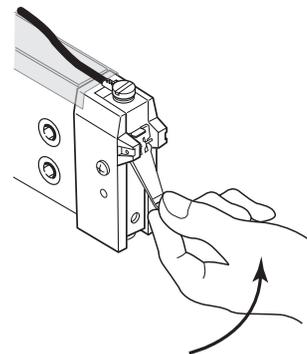
- 1 The heating element is covered with the teflon sheet.  
Remove the teflon sheet, referring to "9-1" or "9-2".
- 2 The electrode cover is secured on the side.  
Loosen the electrode cover securing screw by Phillips screwdriver and pull to remove it.
- 3 Raise the electrode lever. The tension of heating element is loosened.
- 4 Loosen the heating element holder screw by screwdriver (-).  
Damaged heating element can be removed.
- 5 Set the new heating element. Hold down the ends of heating element with your fingers so that it does not slip from the electrode.  
Secure the heating element holder screw.
- 6 Return the electrode lever so that heating element keep a tension.
- 7 Re-attach the electrode cover.



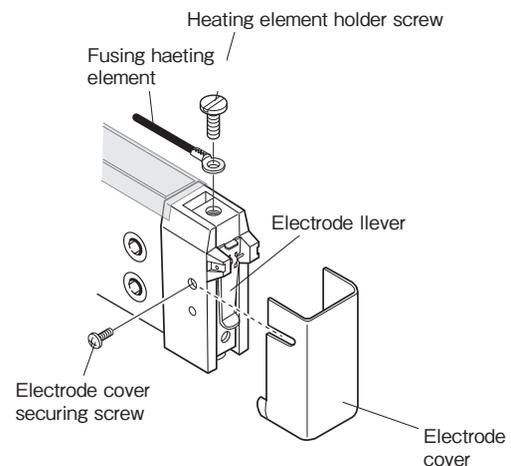
**Caution** For your safety, be sure to mount the electrode cover after installing heating element.

When replacing the heating element, always use the specified heating element for your machine.

If unspecified heating element is used, the transformer may fail.



Raise the electrode lever

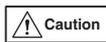


## 9-5 Change the cutting heating element (5C, 10C type)

[Replace when] The heating element has burned out.  
Cutting is dirty.

[Essential tools] Phillips screwdriver, Screwdriver (-)

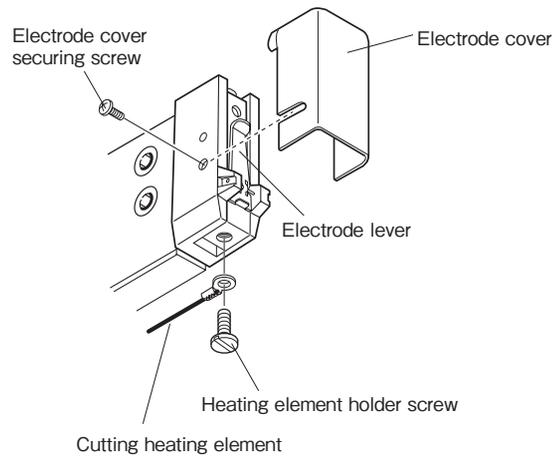
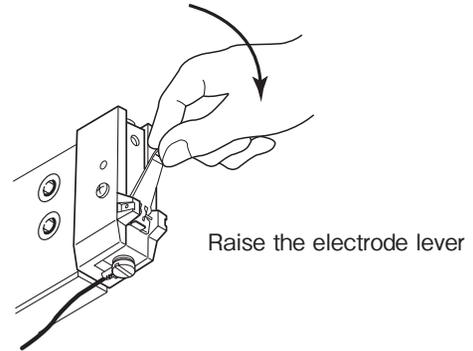
- 1 The heating element is covered with the teflon sheet. Remove the teflon sheet, referring to "9-1" or "9-2".
- 2 The electrode cover is secured on the side. Loosen the electrode cover fixing screw by Phillips screwdriver and pull to remove it.
- 3 Raise the electrode lever (on the upper lever: downward / on the lower lever: upward).
- 4 Loosen the heating element holder screw by Phillips screwdriver.  
Damaged heating element can be removed.
- 5 Set the new heating element. Hold down the ends of heating element with your fingers so that it does not slip from the electrode.  
Secure the heating element holder screw.
- 6 Return the electrode lever so that cutting heater keeps tension.
- 7 Re-attach the electrode cover.



For your safety, be sure to mount the electrode cover after installing heating element.

When replacing the heating element, always use the specified heating element for your machine.

If unspecified heating element is used, the transformer may fail.



## 9-6 Change the glass tape

[Replace when] Heating element is often burnt out.  
Sealing is dirty.

[Essential tools] Scissors, Phillips screwdriver, Alcohol  
(Ethanol) etc.

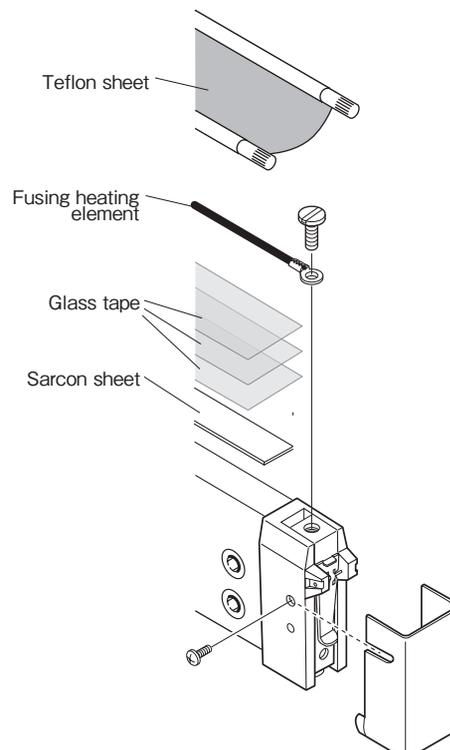
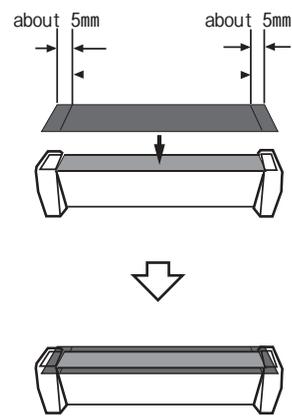
**Caution** If the glass tape under the heating element is damaged or burnt, the heater wire itself may cause a short circuit, or proper sealing may not be attained. Inspect the glass tape when replacing heating element, and change it if necessary.

- 1 Remove the teflon sheet and heating element (Ref.9-4,9-5,9-6)
- 2 Peel the glass tape located below the heating element completely off.

**Caution** Some adhesive remains make an uneven sealing surface and have an adverse effect on sealing. Please clean the surface thoroughly by Alcohol (Ethanol), etc..

- 3 Cut the new glass tape about 10mm longer than the length of the sealing section. Attach the glass tape so that it covers the electrode about 5mm at both ends.

**TIPS** On the melt-cut type sealer, attach the glass tape 3 pieces as shown in the right illustration.



## 9-7 Changing the sarcon sheet (For single side heating, 5C, 10C, FiF-C single side)

[Replace when] Heating element is often burnt out.  
Sealing is dirty.

[Essential tools] Scissors, Phillips screwdriver, Alcohol  
(Ethanol) etc.

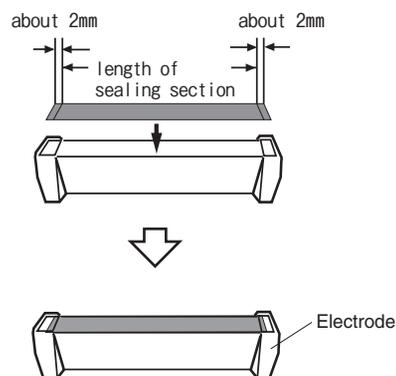


If the sarcon sheet under the heating element is damaged or burnt, the heater wire itself may cause a short circuit, or proper sealing may not be attained. Inspect the glass tape when replacing heating element, and change it if necessary.

- 1 Remove the teflon sheet and heating element (Ref.9-4,9-5,9-6)
- 2 Peel the sarcon sheet located below the heating element completely off.

**Attention !** Some adhesive remain makes uneven sealing surface and has an adverse effect on sealing. Please clean the surface thoroughly by Alcohol (Ethanol), etc.

- 3 Cut the new sarcon sheet about 4mm longer than length of sealing section. Attach the sarcon sheet so that it covers the electrode about 2mm at the both ends.



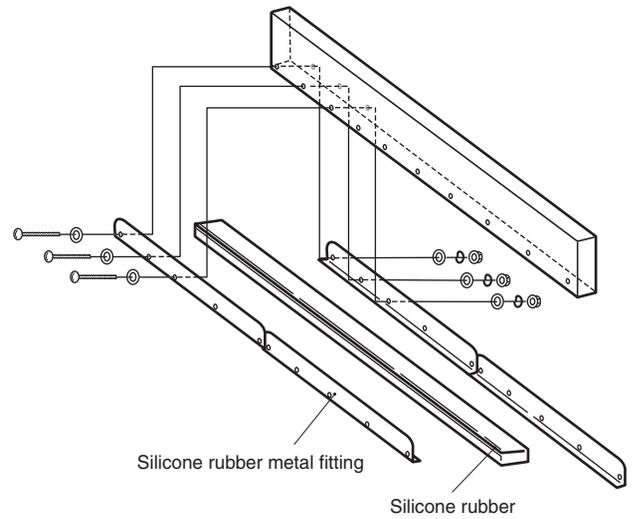
## 9-8 Change the silicone rubber (For single side heating)

[Replace when] The surface of silicone rubber is uneven

[Essential tools] Alcohol (Ethanol) Phillips screwdriver, Monkey spanner etc.

- 1 Loosen the all nuts on silicone rubber metal fitting and pull out the silicone rubber.
- 2 Insert the new silicone rubber in the extracted di-rection. Attach the metal fitting into the groove of silicone rubber.
- 3 Secure the nuts which were loosened in 1.

 **Caution** There is a danger of cut fingers by the silicone rubber metal fitting.  
Take care when replacing.



## 9-9 Change the silicone rubber (For double side heating / both upper and lower)

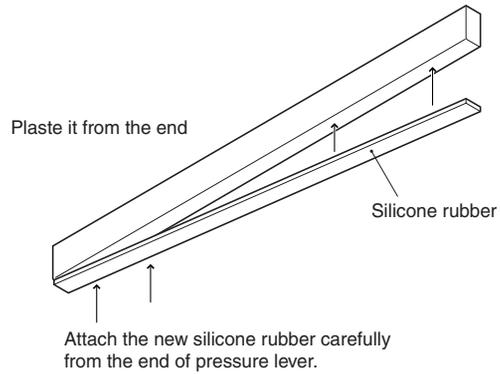
[Replace when] The surface of silicone rubber is un-even

[Essential tools] Industry alcohol, Thinner, Phillips screwdriver, Monkey spanner etc.

- 1 Remove the teflon sheet , heating element and glass tape.
- 2 Peel the silicone rubber completely off.

**TIPS** Some adhesive remain makes uneven sealing surface and has an adverse effect on sealing.

- 3 New silicone rubber has an adhesive tape on it. Peel the paper and attach the new silicone rubber carefully.



## 9-10 Connect and remove the tube

When remove the tube, push the release ring and pull out the tube.

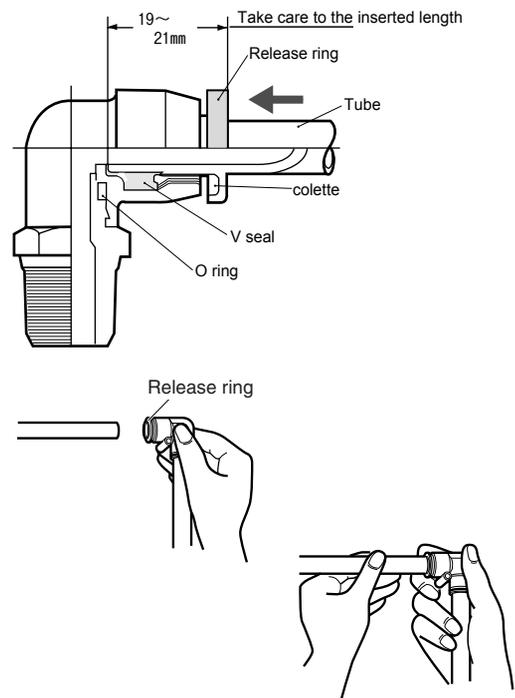
### How to remove the tube

If you press the release ring while pushing the tube in at the same time, you can remove the tube quite easily.

### How to connect the tube

Insert the tube fully to the tube end of the joint.

**Caution** To avoid the air leakage, please verify that the tube is jointed firmly.



## 10 Adjustment for each part

### Adjustment of sealing pressure

Sealing pressure of a brand-new machine is properly adjusted, so no adjustment is required.

Adjust the sealing pressure only when the pressure is not sufficient for sealing thick pouches.

#### Adjustment method

Turn pressure adjusting sleeves to the direction of the arrow indicated in the drawing on the right.



Turn pressure adjusting sleeves on both right and left sides of the pressure lever considering the balance of sealing pressure for each side; otherwise, sealing will result in uneven for each side of sealing area.

