

# 1. USES AND FEATURES

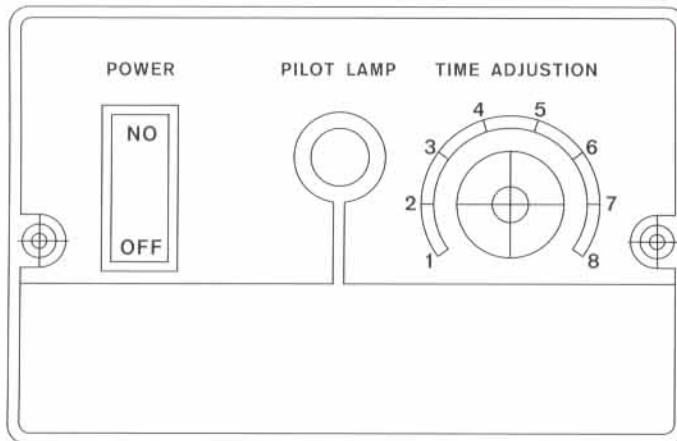
This machine has adopted the way of Foot Stamping & Instantaneous Heating. It is suitable for sealing the material of Polyvinyl chloride & Polythene, etc. And for making bags.

This machine can be widely used in fields for food, medicine, cosmetics, local specialities, chemical products, seeds, clothes, etc. It is the best sealing equipment used in batches of factories, shops as well as in service trades.

# 2. MAJOR TECHNOLOGICAL PARAMETERS AND SPECIFICATIONS

Type	Instantaneous Heating		
Model	PFS-350	PFS-450	PFS-650
Sealing length(mm)	350	450	650
Sealing width(mm)	2-5		
Input voltage (V)	AC220/110V 50-60Hz		
Heating time(S)	0-2.5		
Impulse power(W)	1200	1250	1500
Case size (mm <sup>3</sup> )	450×510×880	550×520×880	700×570×880
Weight(Kg)	19	21	24.50

# FIGURES OF CONTROL PANEL



### **3.REGULATION AND OPERATION**

Connect with the power supply (The voltage must be AC110/220V which is same of the voltage of the machine).Open the power switch,the redindicating light will flash. According to the kind and the thickness of the packing material regulate heating time.

Before sealing, please turn the heating time switch to 1 gear, then put into the sealing bag and stamp down the Stamping-Plate, the yellow light will flash. When this light turned off, after 1~2seconds release the Stamping-Plate, and take out the plastic bag.

In case of Non-tighten seal, please lengthen heating time. to the seal is tight and its drawing is clear. The sealing works continuously as this heating time and temperature.

The cooling time can be too short otherwise the sealing will be not flat and beautiful As the heating time is added, the cooling time must be lengthened too.

When finishing the work, First turn off the power switch, then cut off the power supply.

### **4.SAFEGUARD AND MAINTENANCE**

When using the machine,it is forbidden to heat sealing before putting into bags.And can't add the temperature too high, othwise the PTFE cloth will be burnt.

In case of the melting point of plastic sticked to the PTFE cloth, It's forbidden to scrape off it with hard thing. Provided reducing the temperature a little, then put into the plastic bag and seal again. While the yellow light has turned off for a little time, release the Stamping-Plate, take out the bag, so the melting point has removed from PTFE cloth. But while taking out the bag, please don't pull hard .

#### **4.1.1 Replace the heating wire**

Loosen the screws of the pressing-plate of the PTFE cloth on the heating wire, roll up the cloth, loosen the bakelite-case of both sides, remove the clamping screws on the copper block. Remove the heating wire, and assemble a new one. If the copper block was oxidized,please keep clean withsand paper to contact well with the heating wire.While Assembling the heating wire, the cloth must be kept flat and insulation between the heating wire and the case, otherwise making this machine into shortwayand to damage the heating wire.

#### **4.1.2 Replace the PTFE cloth**

Remove the screws and the pressing-plate on the PTFE cloth, loosen the shaft of the cloth and pull out,please wipe out the damaged part of the cloth. Assemble the pressing-plate and the screws again and fasten the shaft. But the cloth must be kept flat, otherwise it will influence the sealing effect.

#### 4.1.3 Replace the stroke switch

There is a stroke switch beside the head of the machine. Remove the damaged switch, then assemble a new one and weld well all of the wires. While adjusting the rod of the stroke switch, should check the stroke switch pressed well. If pressing is well, it can be heard the sound while pressed (put into a paper whose thickness is 1 mm) If Non-pressing well, please adjust down the rod or fasten the screw(C3) to press the frame of the stroke switch to 1-2mm(while the stroke switch works.)

4.1.4 Always keep the sealing surface clean, avoiding the oxidization of the residue which will reduce the life of the heating wire and of the PTFE cloth. Don't use the wet article to clean the sealing surface.

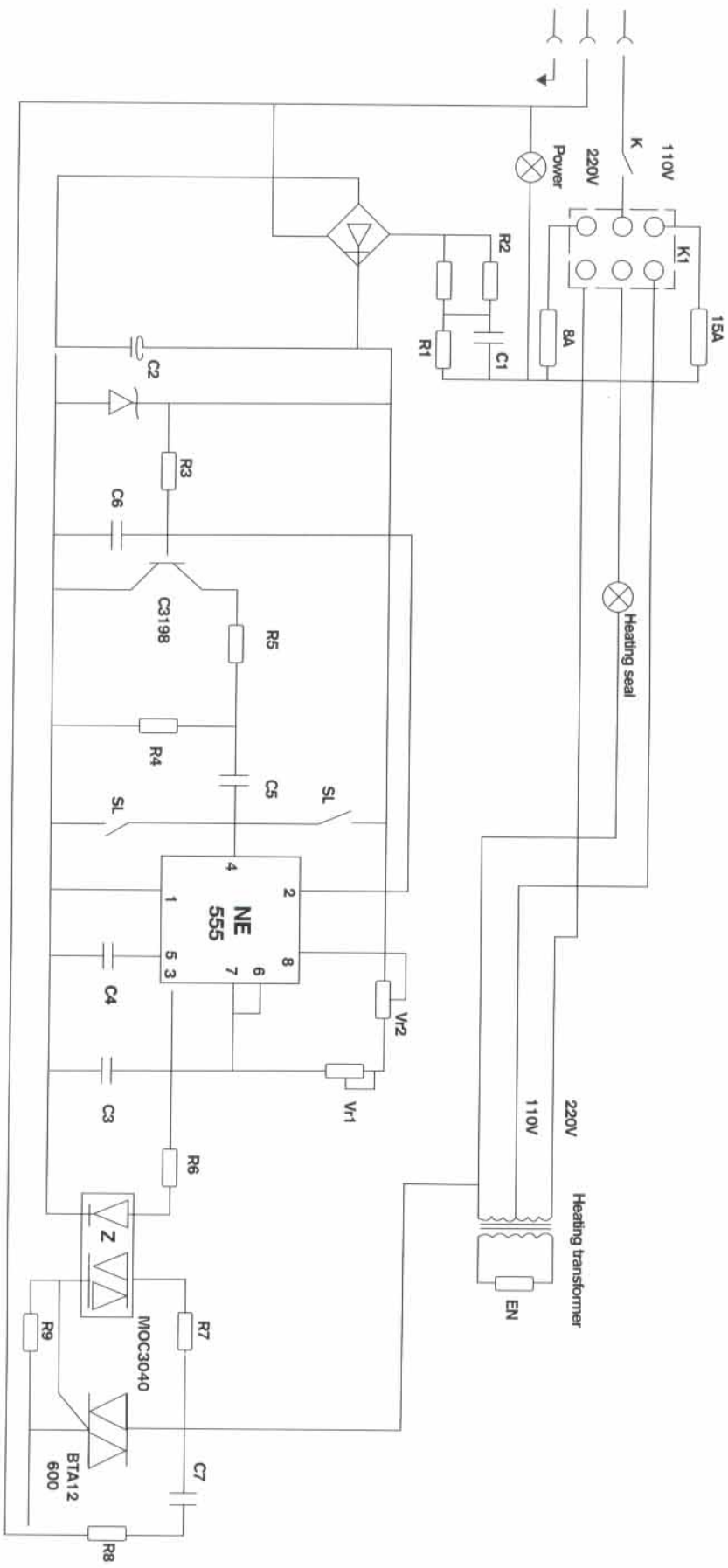
4.1.5 After a very long time usage, please check the rubber, the worn of rubber will influence the sealing effect.

4.1.6 Please often lubricate the movable parts.

4.1.7 All kind of parts of the machine don't be dismantled at random.

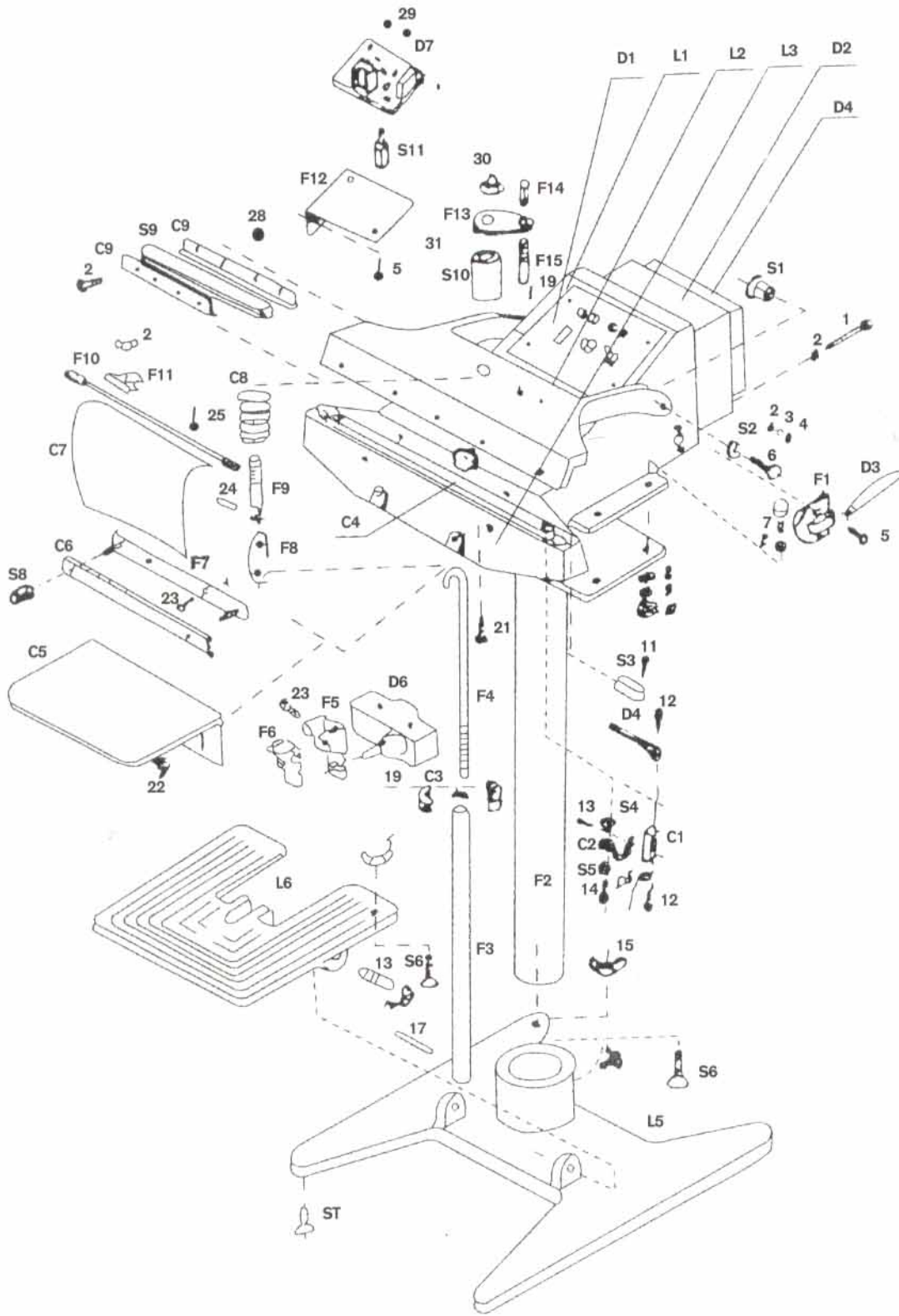
## 5. BREAKDOWN AND REMEDY

Breakdown	Cause and remedy
Abnormal sealing	If Non-tighten seal, please lengthen the heating time. If burnt seal, please reduce the heating time and press tightly.
Unflat sealing	Because the temperatur is too high or the cooling time is not enough. Please reduce or lengthen.
After a period of time usage, the temperature will go up.	It is normal, Please reduce or lengthen,
The red indicating light doesn't flash and the heating wire can't heat.	Please check if the power switch is opened and the fuse is well.
The red indicating light doesn't flash, but the heating wire can't heat.	Please stamp down the Stamping-Plate, check if the stroke switch is working. See section 4.1.3
After the machine was opened, the heating wire can't Stop heating.	Please turn off the machine immediately, and check the stroke switch. If it's damaged, please adjust. See section 4.1.3



**6. FIGURES OF ELECTRIC CIRCUIT**

# 7.No.OF THE PARTS



## THE NAME AND NUMBER OF SPARE PARTS

NO	Name	Quantity	NO	Name	Quantity
C1	Heating strip terminal	2	F5	Top base of switch	1
C2	Heating strip plate	2	F6	Top plate of switch	1
C3	Nut	1	F7	Teflon cloth fix base	1
C4	Teflon clth strip	1	F8	Pull plate	1
C5	Cargo shelf	1	F9	Short pull staff	1
C6	Cloth fixing bracket	1	F10	Teflon cloth roll axle	1
C7	Teflon cloth	1	F11	Bracket of Teflon cloth axle	1
C8(c1)	Spring	1	F12	Circuit board bracket	1
C9	Silica-gel bak fix bracket	2	F13	Press board	1
C10	Ally type	10	F14	Adjust screw cap	1
D1	Panel	1	F15	Top plate of switch	1
D2	Transformer	1	F16	Location plate of type	1
D3	Power wire	1	F17	Bottom heating strip	1
D4	Heating strip	1	F18	Bottom heating tube	2-4
D5	Terminal	2	F19	Printing adjust block	1
D6	Point-move switch	1	F20	Top heating strip	1
D7	Circuit board	1	S1	Nylon cover	2
D8	Ele-heating tube	1-2	S2	Nylon gasket	2
D9	Thermo couple	1	S3	Bakelite protection Cover	2
L1	Machine head	1	S4	Insulating cover	2
L2	Top press bracket	1	S5	Insulating gasket	2
L3	Bottom press bracket	1	S6	Rubber-head bolt	2
L4	Back cover	1	S7	Cushion of bottom base	3
L5	Bottom base	1	S8	Bakelite nut	2
L6	Foot stamping board	1	S9	Silica-gel bar	1
F1	Power wire protect plate	1	S10	Rubber pole	1
F2	Bracket	1	S11	Insulating bolt	2
F3	Pull tube	1	S12	Adiabatic cushion	2-4
F4	Pull hook	1			

## THE NAME AND NUMBER OF SPARE PARTS

NO	Name	Quantity	NO	Name	Quantity
1	Bolt M5×70	4	19	Bolt M4×8	6
2	Cushion 5	8	20	Forelock	1
3	Spring cushion 5	4	21	Hexangular bolt M8×16	2
4	Hexangular nut M4×10	4	22	Dishing nut M8	2
5	Bolt M4×10	2-4	23	Bolt M4×8	2
6	Hexangular bolt M10×40	2	24	Flexible forelock 5×12	1
7	Hexangular bolt M10×30	2	25	Bolt M6×24	2
8	Cushion 10	8	26	Dishing nut M6	2
9	Spring cushion	4	27	Bolt M4×25	5
10	Hexangular nut M10	6	28	Hexangular bolt M4	5
11	Bolt M3×10	2	29	Hexangular nut M3	2
12	Bolt M4×6	4	30	Cap-shaped nut M12	1
13	Rivet	4	31	Bolt M3×8	4
14	Bolt M4×6	2	32	Bolt M5×20	4
15	Dising nut M10×20	2	33	Hexangular bolt M6×25	2-4
16	Hexangular bolt M10×20	1	34	Hexangular bolt M6×16	2-4
17	Flexible forelock 8×24	1	35	Spring cushion 6	4-8
18	Location bolt M10×40	2	36	Cushion 6	8-16

## 8. PRODUCT CERTIFICATE

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**This machine has been inspected and qualified.**

**Accord with the standard of 《GB9400》 .**

**Inspector** \_\_\_\_\_

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## 9. PACKING LIST

<b>Name</b>	<b>Quantity</b>
Foot Stamping Sealer	1 set
Adjustable spanner(6 inches)	1pc.
Screwdriver('+ '3 inches)	1pc.
Screwdriver('- '3 inches)	1pc.
Fuse(2-15A)	2-4pcs.
PTFE cloth	1pc.
Heating wire	2pc.
Operation instruction	1copy
Product certificate	1copy