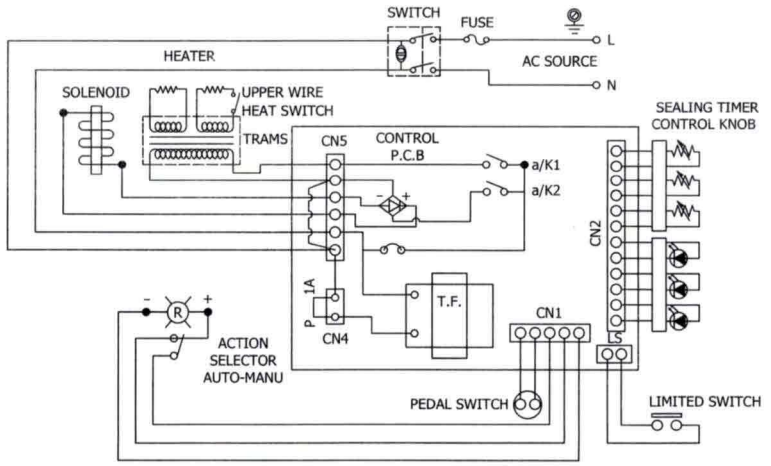
9. ELECTRICAL DIAGRAM



10. SPECIFICATIONS

Model	305/309	455/459	605/609
Max Seal Length	300mm	450mm	600mm
Seal Width	5mm/10mm	5mm/10mm	5mm/10mm
Max Seal Thickness	2x0.4mm	2x0.4mm	2x0.4mm
Heating Timer	0.2~2.2 sec	0.2~2.2 sec	0.2~2.2 sec
Congealing Timer	1.0~8.0sec	1.0~8.0sec	1.0~8.0sec
Re-Cycle Timer	1.0~8.0sec	1.0~8.0sec	1.0~8.0sec
Power	1600W/2100W	1900W/2500W	2300W/2900W
Weight	22Kg/24Kg	24Kg/26Kg	26Kg/28Kg
Dimensions	36x37x30cm	51x39x30cm	66x40x30cm

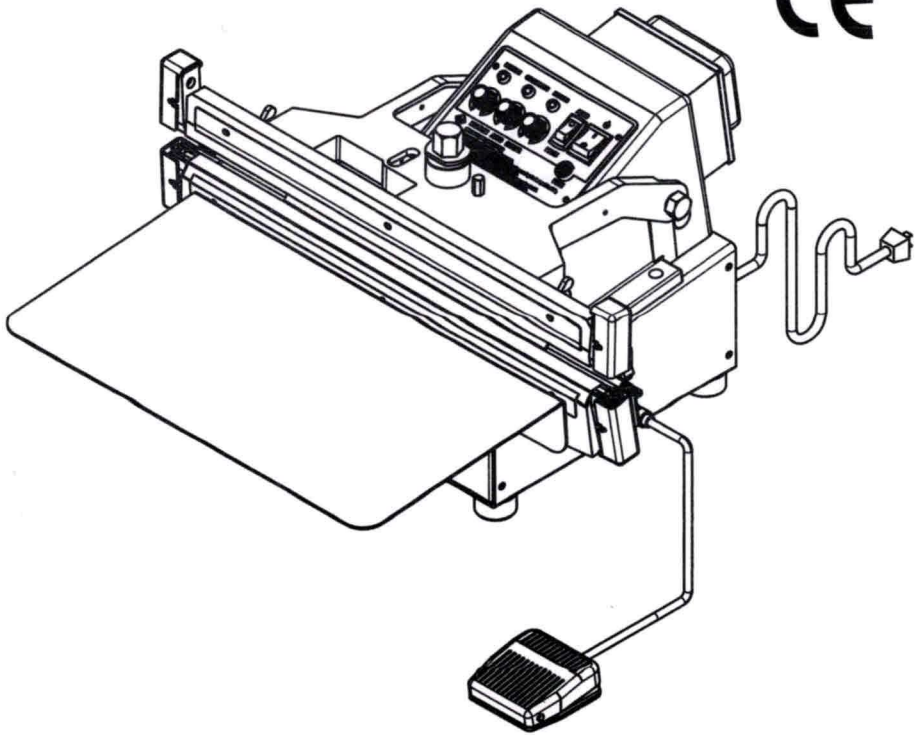
11. OPERATION CONDITIONS

The machine must be used in a well ventilated area where there are no explosive materials or fire hazards.

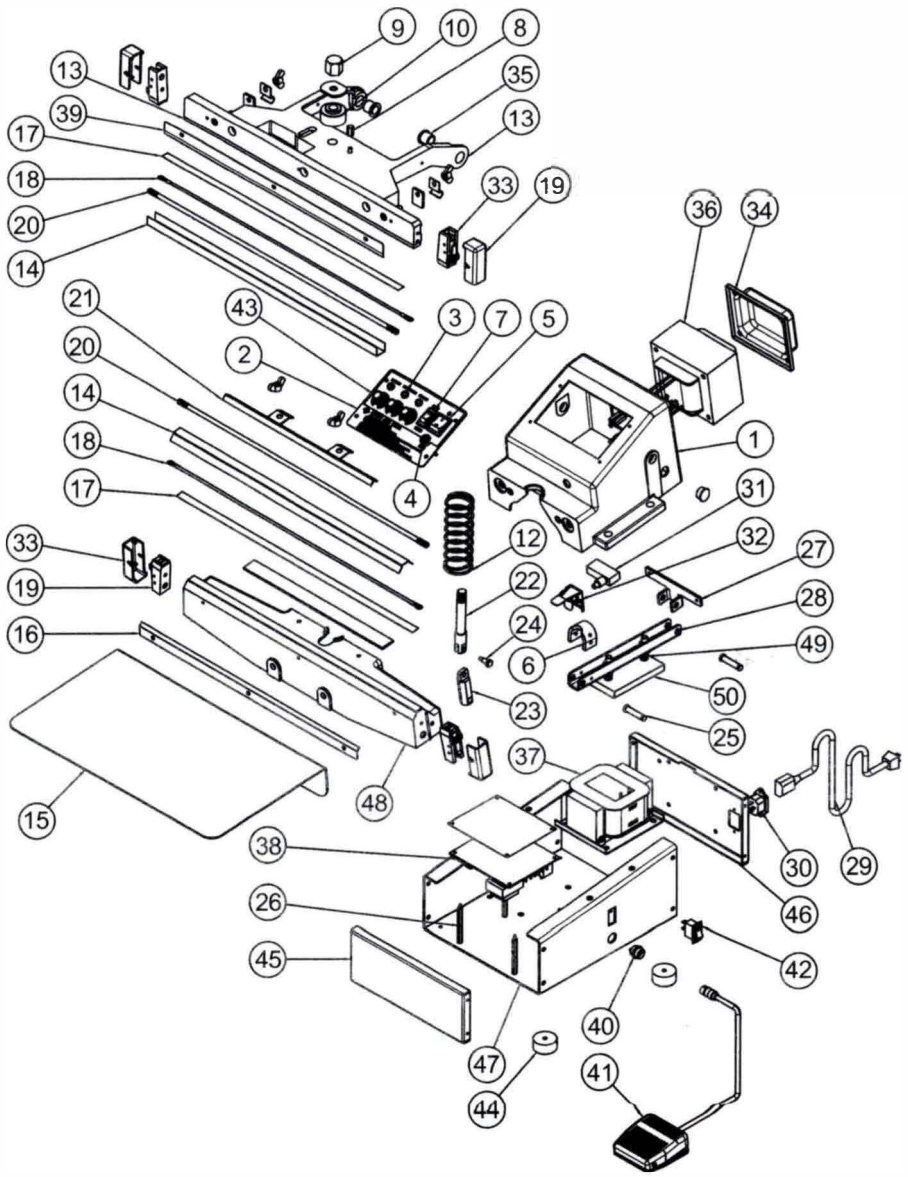
Only use the machine in an area free of moisture, flammable materials, gas or explosives. Ensure the machine is placed on a level surface where the operating temperatures range from 5°C to 50°C and Relative Humidity ranges from 25% to 80%

VHVD/III - 305/309/455/459/605/609 IMPULSE SEALER

CE

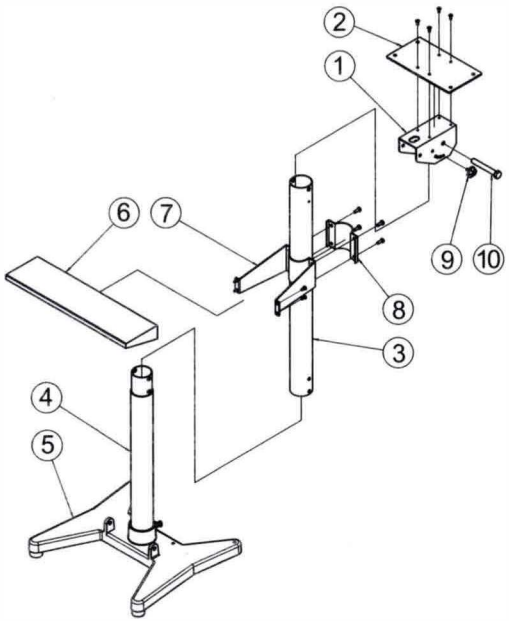


1. EXPLODED VIEW



7. STAND FOR HORIZONTAL USE

1. Body Adjusting Bracket
2. Body Connecting Plate
3. Upper Standing Tube
4. Lower Standing Tube
5. Pedal Base
6. Working Plate
7. Working Bracket
8. Clip for Working Bracket
9. M6x12mm Thumb Screw
10. M8x80mm Bolt Screw



8. REPLACEMENT OF PARTS

1. Always keep the sealing platform clean. Particular care should be taken to remove any residue from the PTFE cloth.

2. Do not clean the sealing platform with water based solvents.

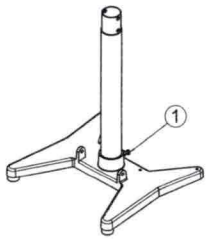
3. Make sure to change the bottom PTFE strip (beneath the element wire) when they become worn or burnt. If this is not replaced, the element wire may become damaged.

4. When replacing the heating element always check the condition of the bottom PTFE strip. It is important that you replace the element wire only with the one made for this machine.

Note: You can damage the transformer with the wrong element wire.

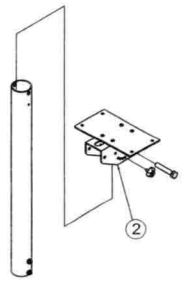
5.Periodically inspect and check the condition of the top pressure pad (silicon rubber) for wear or burn. A poor rubber pad will affect on the quality of your seal.

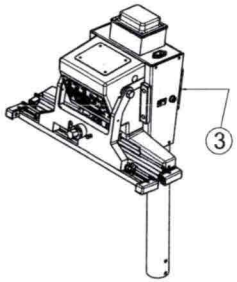
6. ASSEMBLY OF VERTICAL STAND



1.Insert the short standing tube into pedal base and fix with two short screws.

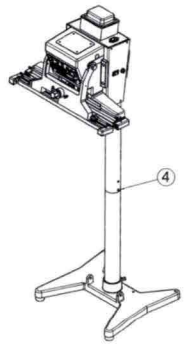
2.Insert the upper stand tube platform onto the adjusting bracket of body then fasten with one M8 bolt screw and two M6 thumb screws.





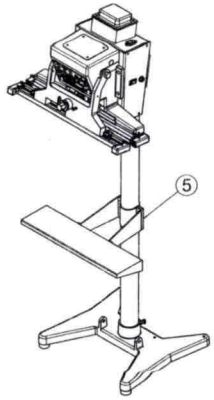
3.With four M8 screws, connect the upper stand platform to the bottom of enclosure body.

4.Insert body upper stand tube set into lower stand tube base then fixed by two M8 bolt screws.

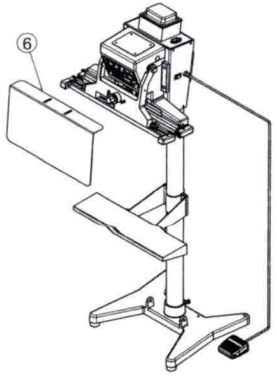


5.Attach working Platform to standing tube with four M6 screws.

Note: When attaching working Platform to standing tube, ensure there is sufficient space between lower sealing body and bracket to allow Fixed Working Plate to be attached easily.



6. Attach Fixed Working Plate (Vertical Back Plate) to under body jaw with two thumb nuts then connect the foot switch to the connector of body base.



2. PARTS LIST

No.	Description	Part No.	No.	Description	Part No.
1	Enclosure Body	2B10-4003	26	Support for PCB	1A10-4010
2	Control Panel	1K70-4021	27	Hinge Bracket	1C10-4053
3	Pilot Lamp	1E40-3001	28	Upper Jaw Lever	1C10-4052
4	Fuse Holder	1E70-4002	29	Power Plug	1E30-1032
5	Main Power Switch	1E10-3000	30	Socket (EMI Filter)	2E90-2013
6	Rubber Pad	1G10-5001	31	Limit Switch	1E10-3004
7	Action Selector	1E10-3002	32	Interlock Set	1C10-4003
8	Setting Hexagon Nut	1D10-4008	33	End Cap	1A10-3003
9	Upper Lever Nut	1D10-4004	34	Transformer Cover	1C10-4021
10	Pressing Rubber	1G10-4002	35	Flange for Press Jaw	1D20-3004
11	Upper Press Jaw	2B10-4031	36	Transformer	1E20-4503*
12	Return Spring	1R10-4003	37	Solenoid	1E20-3504*
13	Sealing Silicone Rubber	1G20-3002*	38	Main Control PCB	1F30-3002*
14	PTFE Roll Cloth	1J50-3445*	39	Upper PTFE Fixed Plate	1C10-4009*
15	Working Plate	1C10-4046*	40	Connector for Switch	1E10-3007
16	Lower PTFE Fixed Plate	1CI0-3016*	41	Foot Switch	1E10-3003
17	PTFE Strip	1J50-4422*	42	Element Selector Switch	1E10-3002
18	Heating Element	2E50-6455*	43	Time Adj. Knobs	1A01-1001
19	Element Terminal Assy	2A10-3000	44	Rubber Foot	1G10-4001
20	Bar for PTFE Cloth	1D10-3005*	45	Front Cover	1C10-4025
21	Clip for PTFE Cloth	1CI0-3013*	46	Back Cover	1C10-4026
22	Upper Lever	1D10-4005	47	Enclosure Base	1C10-4051
23	Down Lever	1D10-4012	48	Lower Sealing Body	2B10-4006*
24	Bolt for Lever	1D10-3017	49	Spring for Magnet Plate	1R10-3002
25	Groove Pin	1D10-3007	50	Magnet Plate	1C10-3008

3. OPERATING INSTRUCTIONS

The VHVD model is designed for continuous sealing of thicker thermoplastic film. This model incorporates twin elements for heavy-duty applications. It makes a 5mm or 10mm wide seal and fuses the material from both sides at the same time. A Selector switch is fitted to allow the operator to choose whether a single element or a double element is required for sealing, this provides the operator an option to seal thinner or thicker material using this model of sealer.

1. Turn main switch to ON position, yellow light appears.
2.Select MANU position for manual operation or select AUTO position for automatic operation by the timer.
3.Adjust the Sealing timer (heating time) knob according to bag thickness and material.
4.Adjust the Congealing timer (cooling time) knob according to the heating time.
5.Adjust Re-Cycle timer knob according to the frequency of continuous work.

NOTE: Sealing and Congealing time are according to the thickness and material of the poly bags. Re-cycle timer is according to working speed of the operator.

CAUTION: The machine has an added safety feature for your protection. Upper Sealing Jaw will fail to close completely if a foreign object as a finger or tool is between the jaws. To reactivate the sealer, turn Off the main Power switch, wait 3 seconds and switch machine ON.

4. HELPFUL INFORMATION

CAUTION

1.To reduce the risk of electric shock, disconnect power cable from the main AC supply before any service or maintenance work.

2. To provide continued protection against risk of electric shock, connect to properly grounded outlet only.

3. If the Power cable is damaged, replace with identical or equivalent cable available from the manufacturer or its service agent.

WARNING:

1. A live heating element is located in the jaw under the PTFE cloth. Use caution during operation. **DO NOT TOUCH THE ELEMENT.**

2. For continued protection against fire or electric shock, replace only with equivalent type fuse.

3. Close supervision is required when the machine is used near children.

5. REPLACING PTFE TAPE AND ELEMENT

To replace burnt out PTFE cloth or broken Element Wire, Please follow these instruction: **REMOVE PLUG FROM MAIN AC SUPPLY AND USE ONLY GENUINE REPLACEMENT PARTS**

1. **To replace PTFE cloth**.

a. Remove PTFE fixed plate and loosen PTFE press clips.

b. Pull out PTFE cloth just enough to cut off burned area, Place cut end of PTFE cloth under Lower PTFE Fixed Plate and re-fix the PTFE Fixed plate.

c. Rotate PTFE bar to pull PTFE roll tight. Retighten the PTFE press clips.

2. **Replacing heating element wire**

a. Loosen PTFE press clips and Remove the PTFE fixed plate.

b. Lift up PTFE cloth and remove broken element wire from heater terminal connector Heater Element Attachment)

c. Put new element wire on heater terminal connector. Do not bend or crimp the Wire.

d. Reattach PTFE cloth and PTFE fixed plate. Tighten PTFE roll cloth with PTFE bar.