

MECHANICAL SETUP & ADJUSTMENTS

NOTE: DISCONNECT MAIN POWER – LOCK OUT AND TAG BEFORE PERFORMING ANY PROCEDURES IN THIS SECTION.

NOTE: All adjustments should be made with the sealer cover removed, and the power turned off. All numbers in parenthesis refer to part numbers on the model 5000P heat sealer. Refer to 'ASSEMBLY DRAWINGS' for part location and orientation.

- ***REMOVING THE COVER***

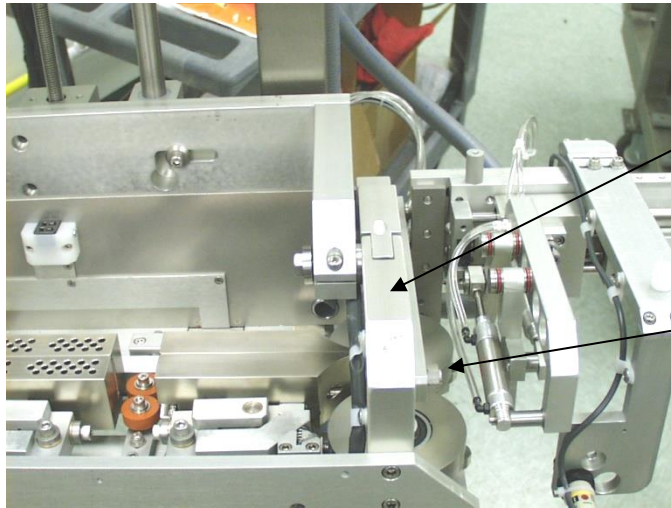
- 1 Locate the three (3) hinges (**#3516/#3517**) that hold the cover to the sealer.
- 2 The rightmost hinge (**#3517**) has a single #10-24 screw that is visible with the cover closed. Use a 5/32 Allen wrench to remove this screw.
- 1 Open the cover completely, and remove it by slowly pulling it to the left. This will disengage the hinges from their support pins.
- 2 Make sure to give the cover the proper support as you remove it from the machine.

- ***SQUARING THE SEALER HEAD***

- 1 With a 3/16 Allen wrench, loosen the ¼-20 socket head cap screws on the sealer pivot holder (**#3021**).
- 2 Next, use a 9/16 wrench to loosen the 3/8-24 sealer pivot bolts (**#3081**).
- 3 Rotate the sealer head until the rear upper main base (**#3002**) touches the pivot holder arms.
- 4 Finally, tighten the ¼-20 socket head cap screws and the 3/8-24 bolts in '**STEPS 1 and 2**'.

- ***ADJUSTING THE SEALER WIDTH***

- 1 Make sure that the sealer handle (**#3080**) is completely closed before you begin.
- 2 With a 7/16 wrench, loosen the two (2) ¼-20 locknuts on the sealer front hangers (**#3020**).



Sealer Front Hanger

Clamshell Adjustment Stud

- 3 Beginning at the drive end, hold the clamshell adjustment stud (#3022) securely with a 9/16 wrench. Locate the 1/4-20 socket head cap screw inside the adjustment stud. Loosen this cap screw with a 3/16 Allen wrench.
- 4 Measure the width of the sealer with a nine (9) to ten (10) inch micrometer. Measure across the edges of the lower front and rear main bases (#3003/#3001). Make sure to take the measurement at the outermost edge of the plate. The distance at the heater side should be 9.515 inches +/-0.003 inches, while the cooling bar side should be 9.525 inches +0.010/-0.000.
- 5 If adjustment is necessary, use the 9/16 wrench to turn the clamshell adjustment stud.
- 6 Turn the stud in small increments, and repeat 'STEP 4' until the reading falls within specification.
- 7 When the specified distance is reached, hold the adjustment stud steady with the 9/16 wrench while using the 3/16 Allen wrench to tighten the 1/4-20 socket head cap screw.
- 8 While holding the 1/4-20 screw steady with the 3/16 Allen wrench, use a 7/16 wrench to tighten the 1/4-20 locknut on the opposite side.
- 9 Finally, repeat 'STEPS 4 – 8' for the sealing end of the machine.

NOTE: When adjusting the sealer width, it is very important to observe the gap between the sealer drive belts. A very small belt gap must exist between the drive pulleys (#3033). If the gap exceeds 0.010 inches, the pouch may fall out of the machine. Gradually decrease the gap between the belts at the drive end in 0.001-inch increments until the belts lightly touch. If the gap is too small, the belts will rub together and cause premature wear. Gradually increase the sealer width until a very small gap exists between the belts.

- **CHECKING SPRING PRE-LOAD**

NOTE: The following procedure is applicable for all Model 2500, 3500, 4000 and 5000 rotary band heat sealers except for those equipped with a seal force monitoring system (Model 3500P/4000P). These units require a different procedure to set the force of the heating bars. The following procedure applies to the cooling bars of all models (including the 3500P/4000P and 5000P).

- 1 Make sure that the sealer handle (#3080) is completely closed.

- 2 Locate the front heating and cooling bar force adjustment blocks (#3007). The front of these blocks contains #10-32 setscrews. These screws control the force exerted on the bars by the springs. They can be accessed by way of the top through holes in the front main base (#3004).
- 3 Insert a 1/8 Allen wrench through the access hole and into the setscrew. Turn the screw out (counter-clockwise) between three (3) and four (4) turns.
- 4 Next, slowly turn the setscrew in (clockwise) until it contacts the force spring. Contact between the spring and the screw will be felt as a small resistance in the turning of the screw.
- 5 After contact between the spring and screw is made, continue another 1 1/2 turns in the clockwise direction.
- 6 Repeat for the other setscrew.

- **CHECKING SPRING RETAINER SCREWS**

- 1 Locate the spring retaining screws. These are the socket head cap screws below the spring force setscrews in the force adjustment blocks (#3007).
- 2 Rotate the sealer handle (#3080) slightly to cam the sealer head open and closed. Look for movement in the spring retaining screws. As the sealer opens, the retaining screws should pull back approximately 1/32 to 1/16 inch until they hit the force adjustment blocks.

NOTE: Use caution when using the sealer handle to open and close the sealer head. Make sure that the teeth of the sealer drive gears stay meshed as the head is opened and closed. If the sealer head is closed with the gears out of line, damage to the teeth and closing mechanism will occur.

- 3 If the screws do not have approximately 1/32 to 1/16 inch of travel, adjust them by loosening the #10-32 locknut with a 3/8 wrench.
- 4 Use a 5/32 Allen wrench to adjust the stop screw. These screws can be accessed by way of the lower through holes in the front main base (#3004). If necessary, the sealing belt can be gently twisted to gain access to the screws.

NOTE: It is important that a spring retaining screw does not rub the sealing belt. If this occurs, turn the screw clockwise until its head is equidistant between the sealing belt and force adjustment blocks. When the adjustment is complete, tighten the #10-32 locknut while holding the #10-32 screw with a 5/32 Allen wrench.

- 5 Look for movement in the rear sealer roller (#3100) and the timing belt floating bar (#3086). As the sealer is opened and closed, make sure these parts move freely. If there is little movement, check for binding conditions.
- 6 Finally, check that the wire leads for the heater blocks do not interfere with the operation of the floating bar pivot (#3006). If the leads do inhibit movement, bend them out of the way of the pivot.

- **ALIGNING THE SEAL BELTS THROUGH THE ROLLERS**

- 1 With the sealer fully closed, observe the sealing belts in the roller area.
- 2 Make sure that the belts exit the heater bars, enter the seal rollers, and enter the cooling bars along a straight line. It is best to look down from a position directly over the top of the sealer.
- 3 If the belts do not follow a straight line, loosen the #10-32 socket head cap screws that hold the front seal roller mount block (#3008) in place. Use a 5/32 Allen wrench.
- 4 Slide the front roller mounting block forward or backward until the seal belts are properly aligned with the heating and cooling blocks. Tighten the #10-32 cap screws when finished with this procedure.

- **ADJUSTING HEATING AND COOLING BAR HEIGHT**

NOTE: Before starting this procedure, be sure that the sealer is completely closed and both sealing belts are installed on the machine. Also make sure that the heaters are cool to the touch as to avoid a possible burn.

- 1 Make sure that the four (4) pivot bolts (located at parts #3101/#3604) are tight. Use a 3/16 Allen wrench to tighten these 1/4-20 socket head cap screws.
- 2 Next, pull the front heater (#3011) back until the pivot spring stops movement.
- 3 To center the heater bar, carefully allow it to return to its normal position. **DO NOT** let the heater snap back into place. This will damage the heater bar.
- 4 Repeat 'STEP 3' for the front cooling bar (#3012).
- 5 Check the heights of the bars. The top edge of the rear bars (#3010/#3013) should be even or slightly higher (> 0.005 inches) than the top edge of the front bars. If one or both rear bars are considerably higher than the corresponding front bar, adjustment is required.
- 6 Locate the four (4) rear adjustment plate screws. They are behind the rear mounting blocks (#3014/#3094). The top are #10-24 socket head cap screws, and the bottom are #8-32 socket head cap screws. Use a 5/32 Allen wrench to slightly loosen the top two. These hold the bar to the aluminum mounting block.
- 7 Loosen, but do not remove, the bottom two screws with a 9/64 Allen wrench. These lock the adjustment plate in place.

NOTE: DO NOT loosen the two (2) #10-24 socket head cap screws directly on top of the mounting blocks. These attach the block to the bottom sealer base (#3001). There is no adjustment in this area.

- 8 To adjust bar height, locate the two (2) small holes in the top of the adjustment block (#3111). Insert a 5/64 Allen wrench into the hole to turn the setscrew inside. Turn clockwise to raise one edge of the bar, and counter-clockwise to lower. When lowering an edge, a soft-faced hammer may be necessary to move the block down.
- 9 When the heaters are aligned, tighten the #10-24 socket head cap screws with a 5/32 Allen wrench. Then tighten the #8-32 socket head cap screws with a 9/64 Allen wrench.

- **ADJUSTING THE DRIVE BELT**

- 1 Check the tension of the sealer drive belts (#3601). The tension is checked at a point midway between the drive belt idler (#3039) and the sealer drive gear (#3032).
- 2 Use your index finger to push inward on the belt, and measure the deflection. A change of 1/8 inch for three (3) pounds of pressure applied is desired. If the belts are too loose or too tight, an adjustment is required.
- 3 Use a 7/16 box wrench to loosen the 1/4-20 nut on the drive belt idler.
- 4 Locate the 1/4-20 bolt underneath the lower sealer plate that mounts the drive belt idler. Push this bolt toward the center of the sealer to tighten the drive belt.
- 5 Once the required tension has been met, snug the 1/4-20 nut with a 7/16 box wrench. **DO NOT** over tighten this nut.
- 6 Use the same procedure to check the second belt.

- **CHECKING THE SEALER BELT TRACKING**

- 1 When the sealer is ready for operation, press the '**START/STOP**' button once to start the warm up cycle.
- 2 Once the sealer is at temperature, unlock the '**FUNCTION SECURITY KEYSWITCH**' selector switch. Press the go to setup screen button and set the belt speed to 250 in/min, and make note of the speed before setting this value for resetting later.
- 3 With the sealer running in the forward direction, check the tracking of the belts. They should be centered on the front sealer pulleys (#3038). If the belts start to climb or fall from the center of the pulley, adjustment is required.
- 4 Open cover.
- 5 Locate the front sealer pulley camber adjustment screws. They are two (2) #10-32 socket head cap screws located on top of the front sealer pulleys.

IF THE BELT IS CLIMBING

- 1 Looking at the entrance end of the sealer, use a 5/32 Allen wrench to slightly loosen the rearmost #10-32 screw approximately 1/4 of a turn (counter-clockwise).
- 2 Next, tighten the closer screw in a small increment.

IF THE BELT IS FALLING:

- 1 Looking at the entrance end of the sealer, use a 5/32 Allen wrench to slightly loosen the closer #10-32 screw approximately 1/4 of a turn (counter-clockwise)
- 2 Next, tighten the rearmost screw in a small increment.

Close cover and observe tracking – repeat if necessary.

SCHEDULED MAINTENANCE

BELT MAINTENANCE

- ***CHANGING SEAL BELTS***

INTERVAL:

Sealer Belt Life is often influenced by the product being sealed. A typical life of a set of low Teflon, #3600-LT, belts is approximately 40 hours. This includes idle time when the sealer is running, and no pouch sealing is occurring. The 40-hour figure is proposed as a starting point for manufacturers. This figure may be adjusted lower or higher as determined by historical data generated by the user. The Belt Life Timer may be used to monitor the interval of belt changes. The operation of the Belt Life Timer is explained on Page 16.

- 1 Allow the sealer to cool down as much as possible.
- 2 Remove all power from the machine.
- 3 Open the sealer cover.
- 4 Rotate the sealer handle upward to open the jaws of the unit.

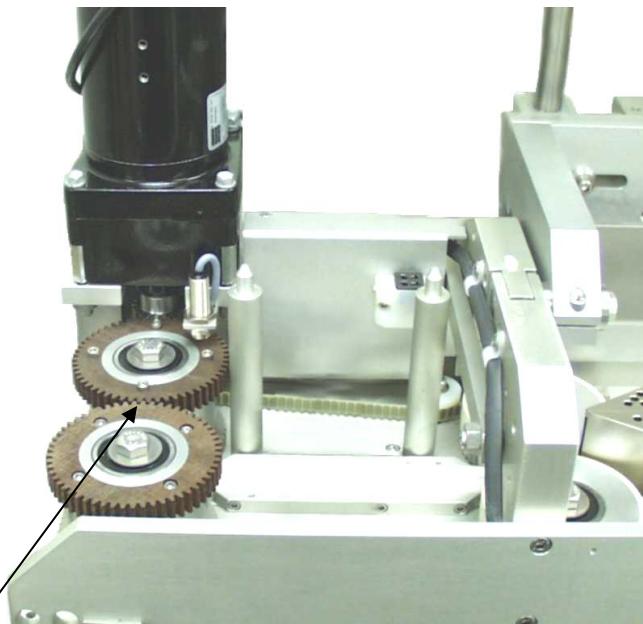
- ***FRONT BELTS (FIGURE FIVE)***

- 1 Rotate the Pressure Relief Cam (**ITEM 3050**) clockwise with the index finger until the cam contacts the Roller Pushback Stud (**ITEM 3048**) and prevents further rotation.
- 2 Place the Belt Removal Tool (**ITEM 3031**) over the Pressure Relief Cam as shown in '**FIGURE FIVE**'. The letter '**F**' should be visible on the face of the tool.
- 3 Rotate the Belt Removal Tool 90° clockwise. This will push the roller back, and remove all pressure from the Seal Belt. Be careful not to remove the tool from the cam at this point, as it may damage the cam or cause injury.
- 4 Remove the old seal belt from the rollers.
- 5 Clean away any remains of the old belt from the rollers, cam, or other surfaces.
- 6 Place a new Seal Belt (**ITEM 3600**) over the rollers. Check for proper alignment of the belt; make sure it clears all screw heads and other protrusions.
- 7 Slowly rotate the Belt Removal Tool counter-clockwise until the belt is tight and the Pressure Relief Cam no longer contacts the Pushback Stud. Check again for proper belt alignment.
- 8 Carefully remove the tool from the Pressure Relief Cam.

- **REAR BELTS (FIGURE SIX)**

- 1 Rotate the Pressure Relief Cam (**ITEM 3050**) counter-clockwise with the index finger until the cam contacts the Roller Pushback Stud (**ITEM 3048**) and prevents further rotation.
- 2 Place the Belt Removal Tool (**ITEM 3031**) over the Pressure Relief Cam as shown in **'FIGURE SIX'**. The letter '**R**' should be visible on the face of the tool.
- 3 Rotate the Belt Removal Tool 90° counter-clockwise. This will push the roller back, and remove all pressure from the Seal Belt. Be careful to remove the tool from the cam at this point, as it may damage the cam or cause injury.
- 4 Remove the old Seal Belt from the rollers.
- 5 Clean away any remains of the old belt from the rollers, cam, or other surfaces.
- 6 Place a new Seal Belt (**ITEM 3600**) over the rollers. Check for proper alignment of the belt; make sure it clears all screw heads and other protrusions.
- 7 Slowly rotate the Belt Removal Tool clockwise until the belt is tight and the Pressure Relief Cam no longer contacts the Pushback Stud. Check again for proper belt alignment.
- 8 Carefully remove the tool from the Pressure Relief Cam.

Next, close the sealer jaws by rotating the opening handle downward until it makes contact with the stop stud. Check the belt drive motor for proper gear tooth alignment. **Do not close the sealing jaws until the teeth are meshed properly.** Improper alignment will cause damage to the closing mechanism or the gears to become stripped. Finally, close the sealer cover, supply power to the machine, and re-start the sealer.



Properly meshed gear teeth

PLC BATTERY REPLACEMENT

The Allen-Bradley CompactLogix 1769 Series PLC used to control the Urania **5000P** heat sealer does not use a battery for program data backup or clock functions. Therefore, there is no battery replacement procedure.

TOUCH PANEL PC(HMI) BATTERY REPLACEMENT

The Advantech PPC-3120-3S51 touch panel PC (HMI) contains a standard coin-type lithium CR2032 battery, which must be replaced when its effective life has expired. The effective life under normal conditions is approximately five (5) years. The effective life will be reduced at higher temperatures. A battery error will occur when the voltage of the battery starts to drop, causing the alarm. This generates a battery error message readable from the display screen. The battery must be replaced within one week after a battery error has been indicated.

Use the following procedure to replace the battery.

- ***CHANGING THE DISPLAY SCREEN BATTERY***

- 1 Turn off the power to the display screen.
- 2 Remove the stainless steel U-shaped cover from the control panel.
- 3 Follow the procedure from the Advantech PPC 3100/3120 User Manual listed on the following two pages.

2.3 Installing Memory

1. Unfasten the screws on the rear cover (8 screws).



Figure 2.5 Unfastening Screws on Rear Cover

2. Unplug the switch wire from the main board and remove the rear cover.



Figure 2.6 Unplugging Switch Wire

3. Remove the rear cover.



Figure 2.33 Removing Rear Cover

4. Remove the IO shield.



Figure 2.34 Removing IO Shield

Note: the RTC clock battery is mounted in a holder on the main circuit board. In the picture above, the battery and holder are partially hidden under the large red multi-conductor cable, near the lower end of the red cable.

PREVENTATIVE MAINTENANCE

THE SEALER MAIN POWER DISCONNECT SWITCH MUST BE IN THE “OFF” POSITION AND LOCKED OUT AND TAGGED BEFORE PROCEEDING WITH ANY OF THE FOLLOWING PROCEDURES.

The following procedure schedule is for the **Model 4000P and Model 5000P** heat sealers, and should be followed on a quarter annual basis. Refer to ‘ASSEMBLY DRAWINGS’ for assistance.

SEALER DRIVE TIMING BELTS (2) (PART # 3601)

- 1 Check for wear, cracks, or other damage to the timing belts (**#3601**). Replace if necessary.
- 2 Check the tension of the timing belts. Tension is checked at the midpoint between the drive gears and the tensioning pulley. A deflection of one quarter (1/4) inch with approximately five (5) pounds of force is normal.
- 3 To adjust tension, loosen the 1/4-20 hex nut on the tensioning pulley (**#3039**). Use a 7/16 box wrench.
- 4 From below the sealer, push the 1/4-20 bolt toward the center of the sealer to set the belt tension.
- 5 Firmly tighten the 1/4-20 hex nut. **DO NOT OVER TIGHTEN.**

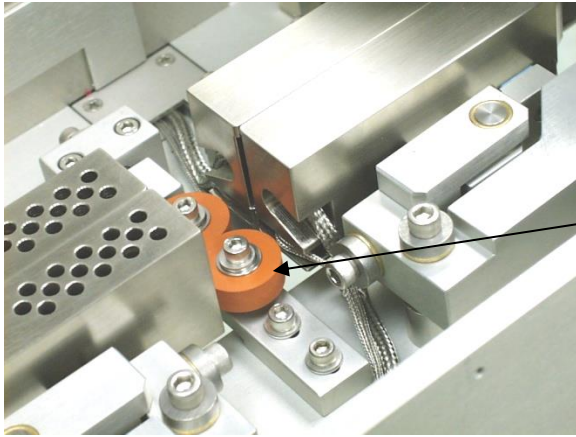
SEALER BELTS (2) (TEFLON COATED FIBERGLASS)

LOW TEFLON (PART #3600LT)

- 1 Watch travel path of sealing belts (**#3600**). Make sure the belts don't rub against any fasteners.
- 2 Make sure the sealing belts are centered on the front sealer pulleys (**#3038**).
- 3 Start the sealer and allow stabilization of operating speed and temperature. Observe tracking of belts - if adjustment is necessary, proceed to next step.
- 4 Remove cover. Sealer will stop.
- 5 Loosen the two (2) #10-32 socket head cap screws on the top of the front sealer pulleys. Use a 5/32 Allen wrench. Loosen each screw only 1/8 of a turn.
- 6 If the belt is too low on the pulley, tighten the rear screw and loosen the front. Use small adjustments as to not damage the sealer belt.
- 7 If the belt is too high on the pulley, tighten the front screw and loosen the rear. Use small adjustments as to not damage the sealer belt.
- 8 When all adjustments are complete, tighten both screws in small increments until both are tight.
- 9 Replace cover. Observe tracking after speed and temperature stabilize and belts are moving forward.
- 10 Repeat Steps 4 through 9 if necessary.

SEALER ROLLERS (GENERAL INSPECTION)

WHITE DRIVE ROLLERS (PART #3037A)
ORANGE SILICON (PART #3100)

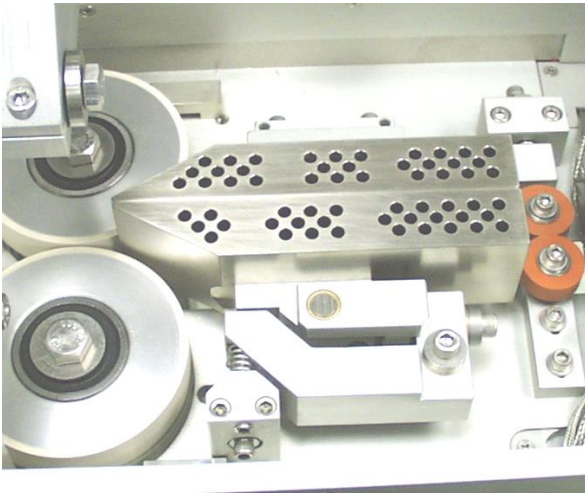


Orange silicon sealer rollers

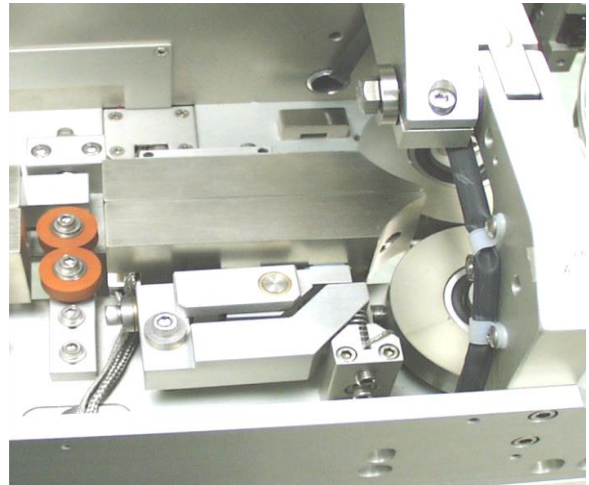
- 1 Check the rollers for any damage; pay special attention to the four (4) rubber rollers. They are: two (2) white sealer belt drive rollers, and two (2) orange silicon sealing rollers.
- 2 Remove any dirt build-up from the rollers with a soft cloth dampened with isopropyl alcohol.
- 3 Insure all roller fasteners are tight.
- 4 Insure rollers turn freely (with sealer handle opened) and exhibit no irregular or rough feeling in the bearings when turning. Replace bearings and rollers as a “set” if “rough” rotation is observed. Never replace individual components. Urania recommends replacing these assemblies at six-month intervals or sooner depending on workload.

SEALER HEATING AND COOLING BARS (GENERAL INSPECTION)

Cooling Bars



Heating Bars



WARNING:

Allow the sealer to cool before inspecting heating and cooling bars. With bars at temperature, severe burns can result.

- 1 Check the sealing surfaces of the heating/cooling bars (**#3010-#3013**) for any nicks or scratches. If damage begins to affect sealing belt life replace the bars.
- 2 Remove any melted pouch material from the sealer bars. Use an abrasive cleaning pad (Scotchbrite 9CP407-8 or equivalent) infrequently and only when necessary.
- 3 After cooling clean the heating/cooling bars with a soft cloth dampened with isopropyl alcohol.
- 4 Make sure that the heating/cooling bar mounting screws are tight.
- 5 Make sure that the pivoting mechanisms of the front heating/cooling bars do not bind.

OVERALL SEALER INSPECTION

- 1 Check for any loose fasteners. Tighten as necessary.
- 2 Check all moving parts for binding or restriction of movement.
- 3 Make sure all sealer adjustment screws are tight, but pivot points move freely.

URANIA HEAT SEALER CLEANING PROCEDURE:

The following describes the procedure necessary to properly clean a Urania Rotary Band Heat Sealer. A Rotary Band Heat Sealer requires cleaning on a regular basis. The advantages of cleaning are:

- Extended sealing belt life.
- Reduced wear on moving components.
- Higher quality pouch seals.

The first question usually asked about cleaning is, “How often?” The answer depends upon several factors. Some include:

- Type of material sealed: Pouch materials leave residues on the sealing belts. Each type of pouch creates a certain amount of build-up on the belts. Some create enough to warrant cleaning every eight (8) hours of operation.
- Temperature: Higher temperatures tend to create more residues on the belts.
- Speed: Higher belt speeds create more friction on the sealing belts and moving components. An increase in belt residue will result.
- Amount of ‘idle’ time: Allowing the sealer to operate at temperature, without actually sealing product can increase the amount of residue build-up. The sealer must be cleaned on a regular basis.

IF THE SEALER IS NOT TO BE USED FOR MORE THAN ONE (1) HOUR, PLACING THE UNIT INTO COOL-DOWN WILL EXTEND BELT LIFE.

As a starting point, Urania Engineering recommends that the sealer be cleaned before every production shift. As operators become more familiar with the process, they will be able to determine the frequency needed to properly maintain the heat sealer. Not only can cleanings become less frequent, but also each cleaning will require less time to perform. Keep in mind that if the time between cleaning becomes too large, seal belt life will decrease. Also, an excessively dirty sealer will not produce superior quality seals.

The second question asked is, “What is needed to clean the heat sealer?” Urania Engineering recommends that the heat sealer be cleaned with Isopropyl alcohol (70%) and a clean, lint-free cloth. A 3M Scotchbrite™ pad may be used on occasion to gently remove stubborn deposits. Use of Scotchbrite™ daily is **NOT** recommended, because it may harm the polished surfaces of the heating and cooling bars.

The use of harsh solvents, sharp objects (razor blades, screwdrivers, etc...) and/or abrasives (sandpaper, files, etc...) is **NOT** recommended and should **NEVER** be used. Using any non-approved materials to clean the heat sealer will result in damage to the heat sealer components.

The next question asked is, “How do you clean the heat sealer?” The process is as follows:

1. If the sealer is operating at temperature, place the unit into the “cool-down” mode. After the three (3) minute cooling process has completed, allow additional time for the sealer to reach room temperature.

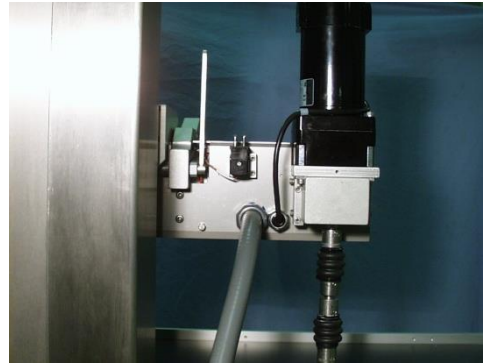
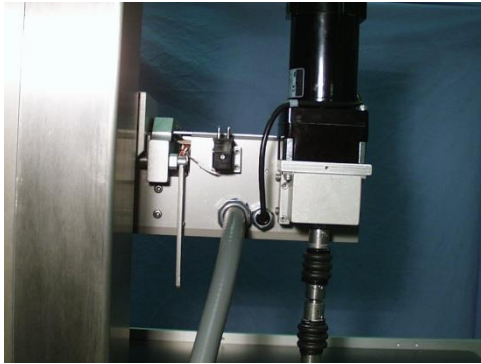
DO NOT ATTEMPT TO CLEAN A HOT SEALER UNIT!!!

Because of the inherent danger involved in any heated device, Urania Engineering recommends that the sealer be cleaned **BEFORE** the sealer is used.

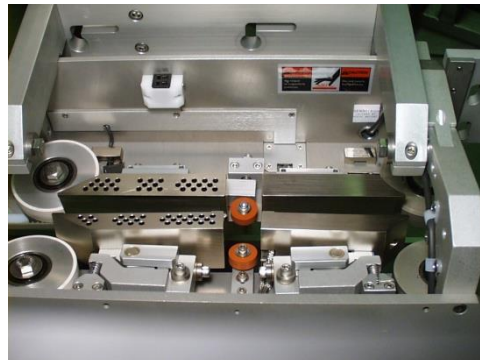
2. Disconnect the heat sealer from the main power supply.
3. Remove the sealer cover (if necessary). This is accomplished by first using a 5/32" Allen hex-key wrench to remove the cover retaining screw. Open the cover completely. Slide the cover off the hinge pins and set aside.

REMOVING THE COVER IS NOT NECESSARY FOR CLEANING.

4. Open the sealer by rotating the sealer handle to its full upright position.



5. Remove both the front and rear sealing belts. See the belt change section of the Heat Sealer Operations Manual for details.

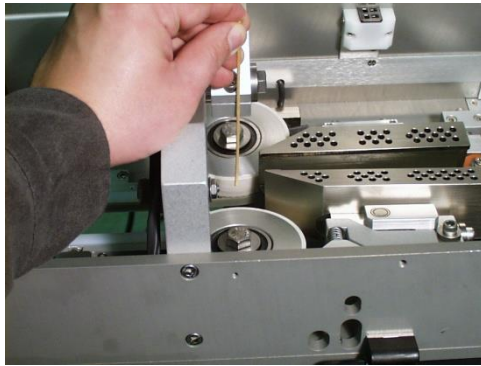


6. Use a clean, lint-free cloth dampened with Isopropyl alcohol (70%) to wipe down the heat sealer.

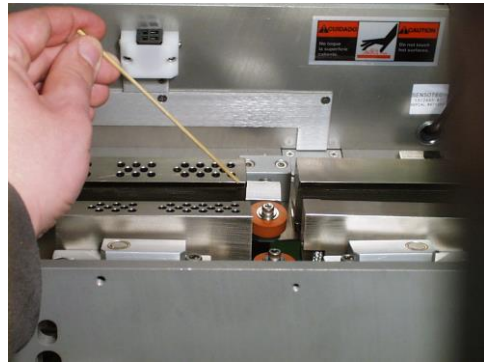
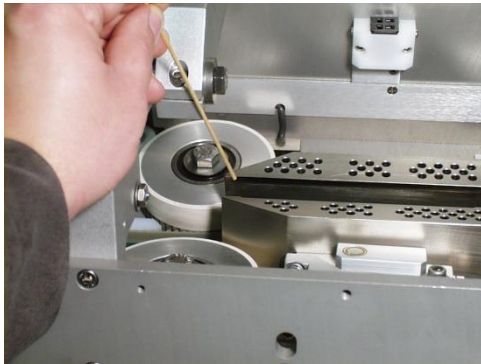
DO NOT USE EXCESSIVE AMOUNTS OF ALCOHOL.

Remove all deposits from the heat sealer surfaces. Areas to keep in mind are:

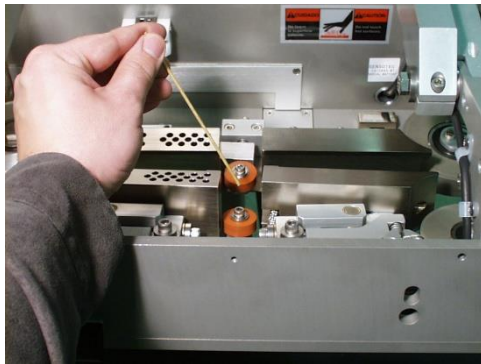
- a. White rubber seal belt drive rollers (2). The rear roller is indicated below.



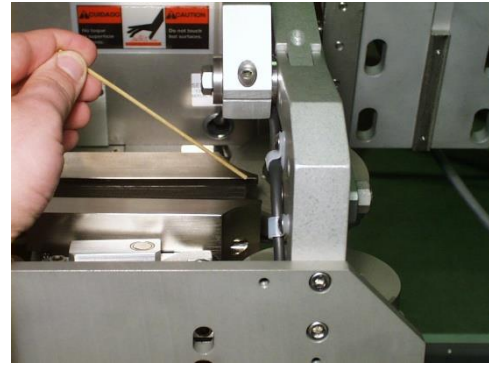
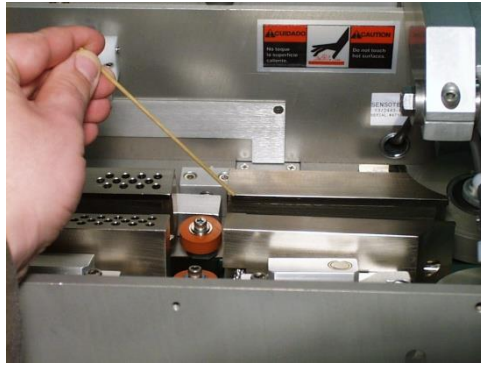
- b. Cooling bar upper contact points (2 per cooling bar, total of 4). The contact points of the rear cooling bar are indicated below.



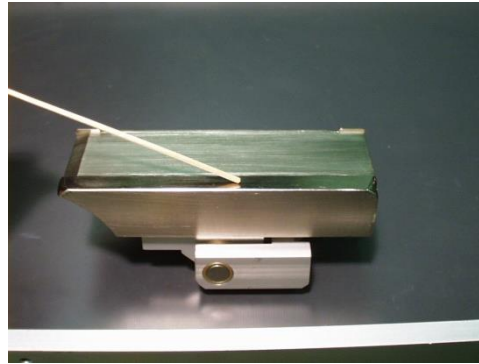
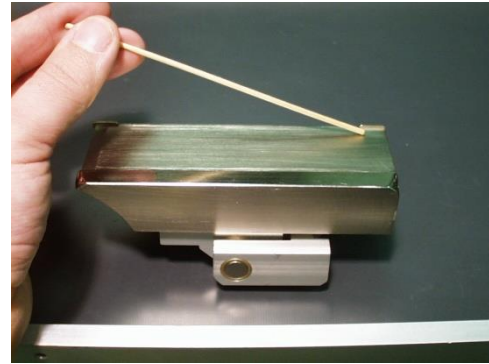
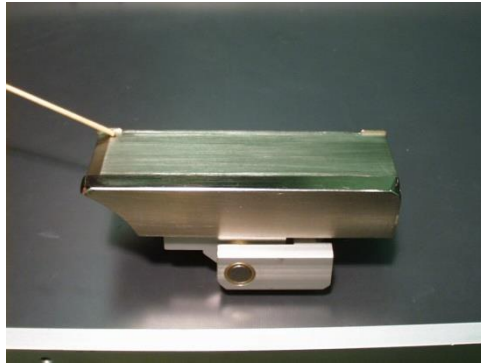
- c. Orange rubber homogenizing rollers (2). The rear roller is indicated below.



- d. Heating bar upper contact points (2 per bar, total of 4). The contact points of the rear heater are indicated below.

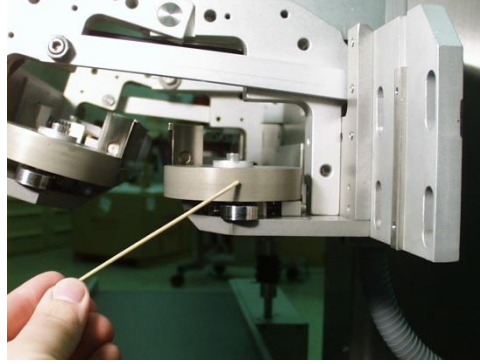


- e. The following three (3) pictures show all contact points for a front heating bar (The contact points of the front cooling bar are similar).



The upper contact surface for the rear heating and cooling bar (not shown) is a continuous edge across the entire top of the bar. The entire edge should be cleaned whenever the sealer is serviced. Excessive build-up on the upper surfaces of the rear heating and cooling bars will affect alignment. Also, the upper edges of the front and rear bars slide along each other as a pouch travels between them. Build-up will restrict proper motion, and may affect performance of the optional heat bar pressure monitor.

f. Sealing belt idler rollers (2). Rear roller is indicated below.



7. Make certain all the surfaces listed above are thoroughly clean before reassembly.
8. Replace the sealing belts if excessive wear is indicated. If the belts are to be reused, they may be carefully wiped down with alcohol and reinstalled.
9. Align gear teeth of the sealer drive rollers **BEFORE** attempting to close the sealer handle. Failure to do so **WILL** damage the drive gears.
10. Lower the sealer handle to its fully closed position. This will close the sealer head and prepare it for operation.
11. Replace the sealer cover if it was removed.
12. Restore power to the heat sealer.
13. Because the power was disconnected for cleaning, the pressure monitoring system will require time to stabilize before the sealer can process pouches. Typically, the amount of time that the power was off is the time required for the system to stabilize.
14. Once the power has been restored and allowed to stabilize, the sealer is now ready to resume operation.