

Operating Manual

Continuous Band Sealer (Horizontal Orientation)

Model No: FR-900S

Figures 1, 2 and 3 shown below will familiarize you with the various parts of the FR-900S horizontal band sealing machine

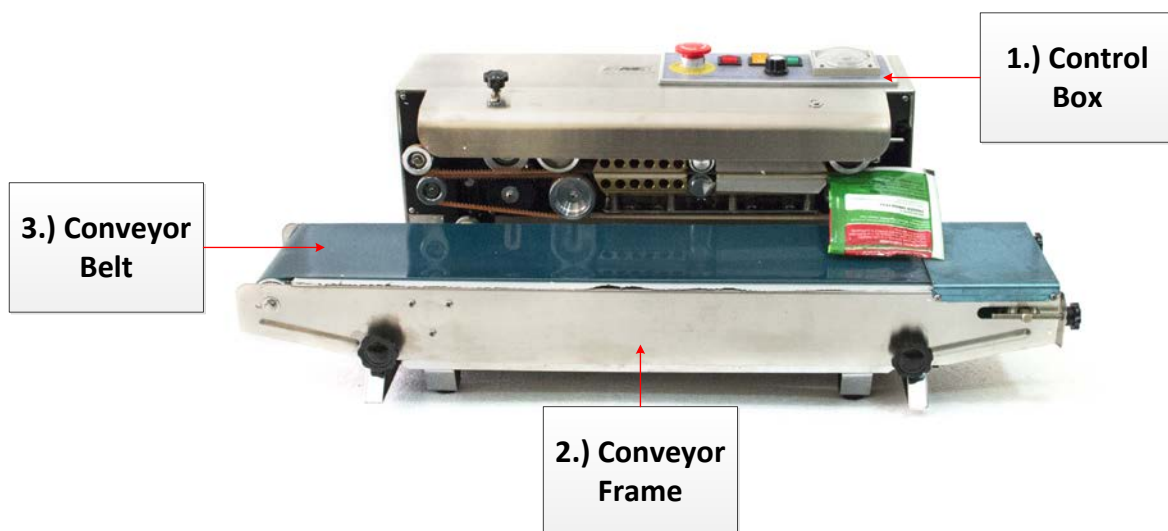


Figure 1: Component Descriptions 1-3

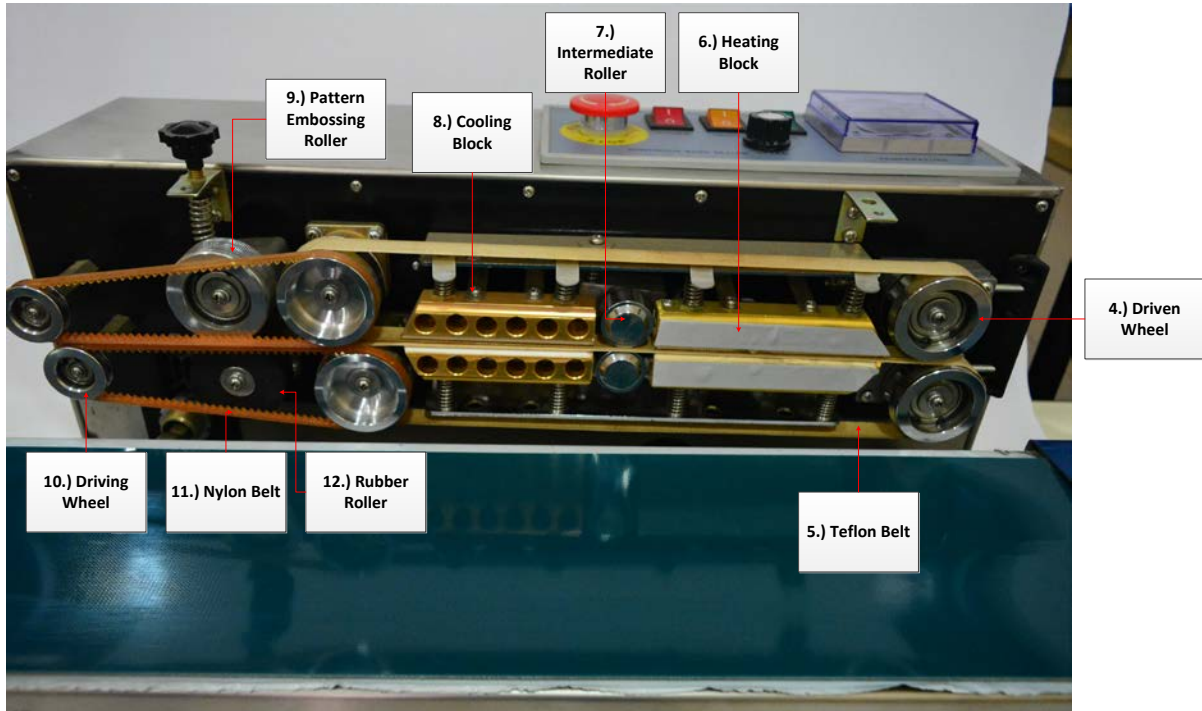


Figure 2: Component Descriptions 4-12



Figure 3: Component Descriptions 13-18

Note: This machine is suitable for clients with high volume production of at least 20,000 bags per day. Bags made of varied material can be sealed by adjusting the temperature and/or the conveyor speed.

Starting Instructions

- Plug in the 3-pin socket into a 220V power supply
- Turn on the machine (Part No: 17)
- Turn on the cooling fan (Part No: 14)
- Turn on the heating switch (Part No: 15)

Operating Instructions

- Once the heating switch is on; set the temperature on the controller (Part No: 13) by adjusting the knob on the centre to an appropriate value; we recommend a temperature of around 160 degrees Celsius for an initial trial
- Wait for 5 minutes till the set temperature has been reached; this can be observed on the scale at the top of the temperature controller (Part No: 13)
- Adjust the conveyor speed using the knob (Part No: 18); we recommend a speed of 3 for an initial reading
- Now place the bag between both the sealing belt wheels (Part No: 5) as shown in figure 1 and let the belts (Part No: 6) carry the bag through the heating block, cooling block and embossing block (Part No's: 6, 8 and 9)
- Observe the seal quality and test if it's completely airtight
- If the seal is not secure, increase the temperature and/or conveyor speed; alternatively, if the bag has melted, lower the temperature and/or conveyor speed until the desired seal has been achieved
- Commence production at this setting until your bag material/thickness changes in which case temperature and conveyor speed adjustments will be required (Repeat above steps)

Precautions

- While running the machine, operators should stay well clear of the heating block
- Always make sure that the cooling fan is turned on during production
- When shutting down the machine; turn off the heater first and keep the cooling fan and conveyor running for approximately 10 minutes before completely turning the power off (This ensures even heat distribution)
- While carrying out maintenance work or part replacement, make sure that the heating block is cooled to room temperature and the machine is turned off

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