

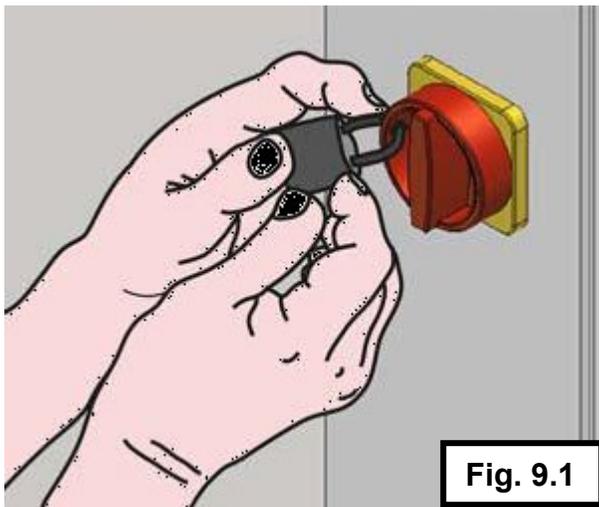
## **9.0 MAINTENANCE and REPAIR**

### **9.1 Precautions**

1. This sealer should only be maintained by qualified personnel.
2. Persons performing maintenance and repair work on this sealer must wear any personal protective equipment that is appropriate to the task. Refer to Section 2 of this manual.
3. If the sealer is not working properly, it should be taken out of service. Do not put it back into service until repairs are completed and tested, and the sealer is completely reassembled.
4. Follow lock-out / tag-out procedures when working on the sealer.

### **9.2 Lock-out / Tag-out Procedure**

1. Confirm that the area surrounding the sealer is safe to work in. It should be-
  - Clear of obstacles and other physical hazards
  - Out of the path of material handling equipment
  - Clean and dry
  - Not subject to any hazards created by air or electrical supply to the sealer.
2. Turn-off the sealer at the main power switch. See Fig. 9.1.
3. Secure the main power switch with a lock or tag.
4. Allow the seal bars to cool fully before working around them.
5. If the sealer has air-powered options, turn-off the air supply valve. It should automatically purge air pressure. See Fig. 9.2.
6. Erect any signs or barricades necessary to insure safety until repairs are completed.



### 9.3 Scheduled Maintenance

| Daily Maintenance      |                | End of shift                                       |
|------------------------|----------------|--|
| Item                   | Care Needed    | Specifics  |
| Exterior               | Clean          | Wipe-off debris with moist cotton cloth            |
| Infeed belt            | Clean          | Wipe-off debris with moist cotton cloth            |
| PTFE seal<br>Pad cover | Clean, inspect | Wipe-off with moist cotton cloth<br>Check for wear |
| Seal bar               | Clean          | Wipe-off with moist cotton cloth while warm        |
|                        |                |  |

| Daily Maintenance           |                | Start of shift  |
|-----------------------------|----------------|---|
| Item                        | Care Needed    | Specifics   |
| Side seal knife             | clean, inspect | Remove guards to check-<br>Wipe-off with moist cotton cloth while warm  |
| Film drag belts             | Clean, inspect | While guards are off-<br>Clean any debris from film drag belts<br>and the tracks they fit in using compressed air.      |
| Heat shields                | Inspect        | Make sure guards are in-place around<br>transverse seal bar and side seal knife.  |
| Safety switches<br>Hoods    | Check function | Sealer should display and error code and<br>abort cycle if either hood, or the film load<br>door are open               |
| Safety switches<br>Seal bar | Check function | Sealer should display and error code and<br>abort cycle if seal bar hits an obstruction.<br>(Use 759-00001 No-Go gauge) |
| E-STOP switch               | Check function | Sealer should display and error code and<br>abort cycle if Emergency Stop is pressed                                    |
| Seal quality                | Check          | Examine seals at start of production to<br>verify that wear is not affecting quality.                                   |

**CAUTION:** Do NOT use a machine with any inoperative safety features

### Weekly and Monthly Maintenance

| Item                             | Care Needed | Specifics   |
|----------------------------------|-------------|---|
| Guide bars                       | Lube        | Bi-weekly, wipe B1 guide bars with light oil                      |
| Drive belts                      | Check       | Monthly, Adjust or replace if needed                              |
| Film drag belts                  | Check       | Monthly, Replace if needed  |
| Infeed belt<br>Outfeed belt      | Check       | Monthly Adjust tension and check tracking                         |
| Inverting plow<br>lift mechanism | Lubricate   | Monthly, Lube with T08010 Lubri-slip                              |
| Gearmotors                       | Clean       | Monthly, Wipe of blow dust off motors and drives                  |
| Photocells                       | Clean       | Weekly, Wipe off photocells and sensors with a moist cotton cloth |
| Safety labels                    | Check       | Weekly, Check for any missing safety labels. Replace as needed.   |

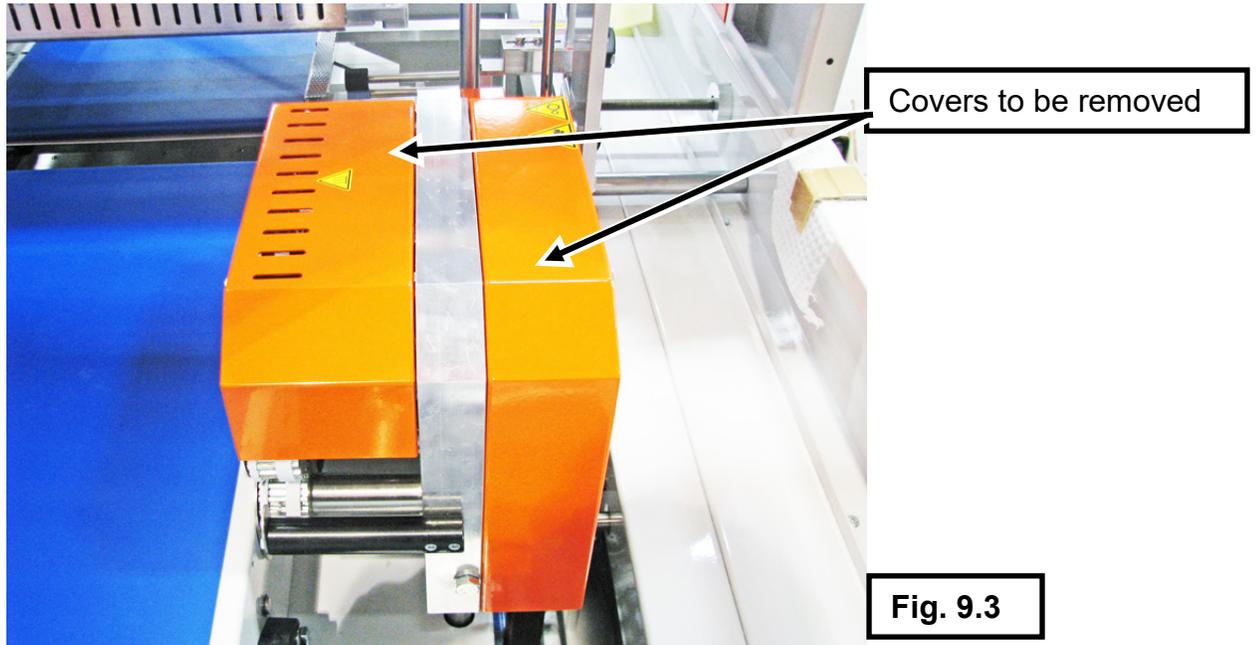
**CAUTION:** Do NOT operate a machine with any inoperative safety features

### Cycle Determined Maintenance

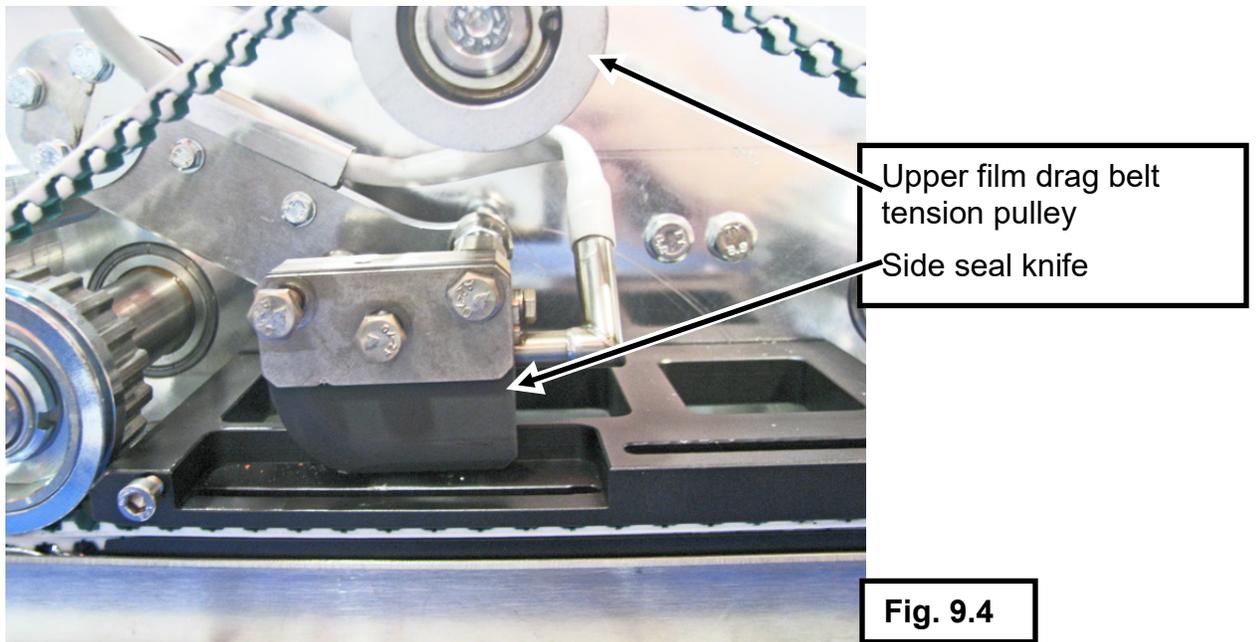
| Item                                 | Care Needed            | Specifics   |
|--------------------------------------|------------------------|---|
| PTFE cover<br>300,000 cycles         | Replace,<br>check      | Replace top layer of PTFE seal pad cover<br>Inspect second layer. Replace as needed |
| Seal pad<br>800,000 cycles           | Replace                | Replace silicone seal pad profile and<br>second layer of PTFE seal pad cover.       |
| Seal bar guides<br>500,000 cycles    | Clean and<br>lubricate | Wipe-off with a soft cloth. Apply a sparing<br>amount of 800-1 white grease         |
| Rod ends<br>500,000 cycles           | Clean and<br>Lubricate | Wipe-off with a soft cloth. Apply a sparing<br>amount of 800-1 white grease         |
| Film guide roller<br>500,000 cycles  | Lubricate              | Lube bearings with T08010 Lubri-slip  |
| Sealing bar<br>2,000,000 cycles      | Replace                | Replace Transverse seal bar   |
| Welder Blade<br>500,000 M of film    | Replace                | Replace the side sealer blade   |
| Drive belts<br>250,000 M. of<br>film | Replace                | Replace drive belts. Infeed conveyor drive<br><br>Exit conveyor and side seal drive |

#### 9.4 Side Sealer Film Drag Belts

1. Open the exit-end hood and remove any film and residue from the side seal area.
2. Turn-off the sealer, and allow it to cool completely.
3. Remove both orange covers using a 7mm wrench. See Fig. 9.3.



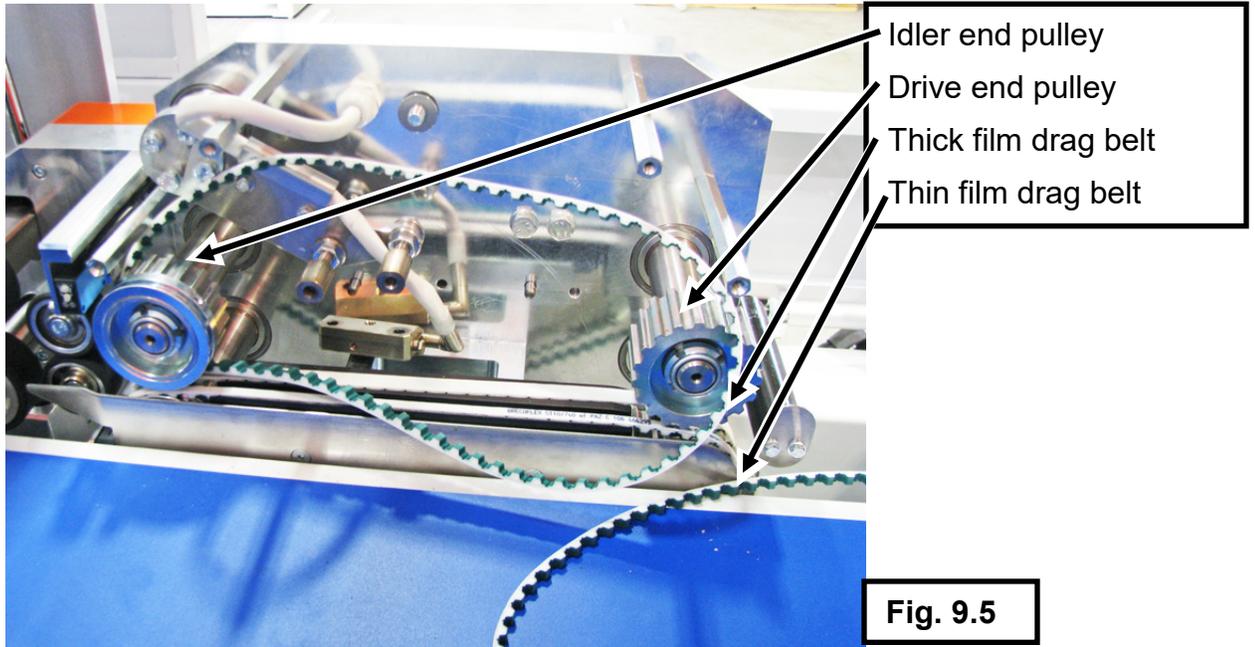
4. Remove the upper Stainless steel film guide using a 3mm hex key.
5. Remove and inspect the side seal knife using a 10mm wrench. See Fig. 9.4.



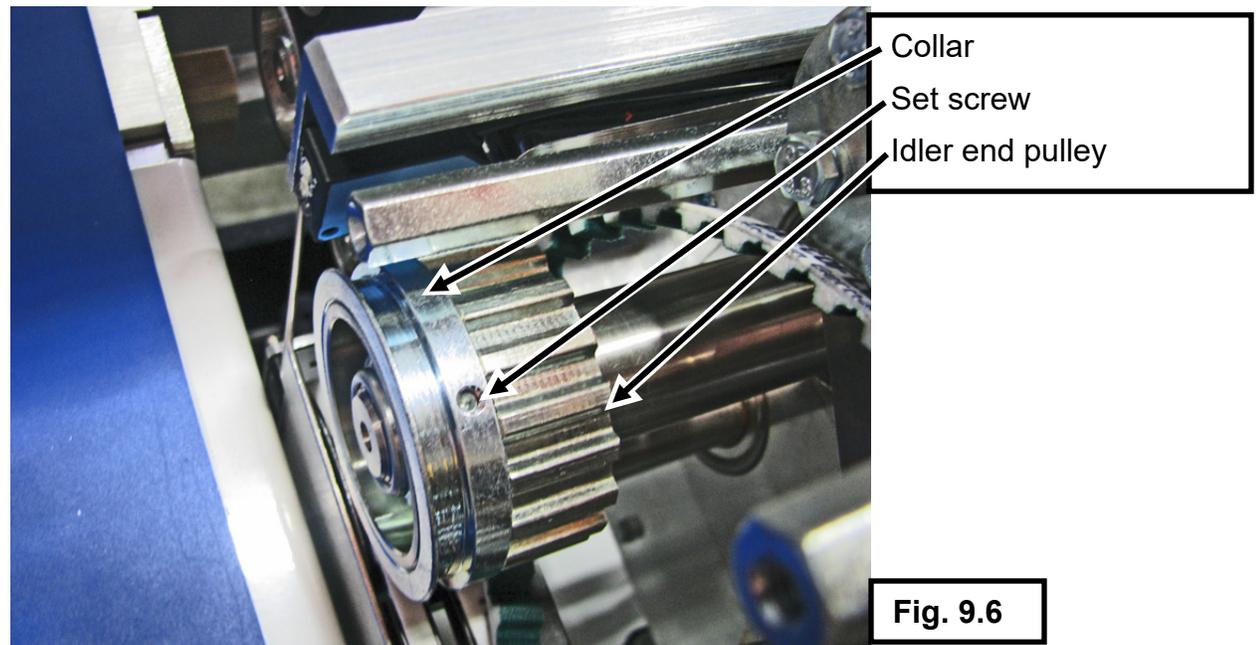
6. Remove the upper film drag belt tension pulley using a 13mm wrench. A crescent wrench may be needed for the hex shaft.

**NOTE:** There is a washer between the side sealer frame and the hex shaft.

7. Slip the upper film drag belts off of the drive-end pulley. See fig. 9.5.



8. The wide upper film drag belt will be trapped on the idler pulley by a collar. Remove the collar using a 2mm hex key. See Fig. 9.6.



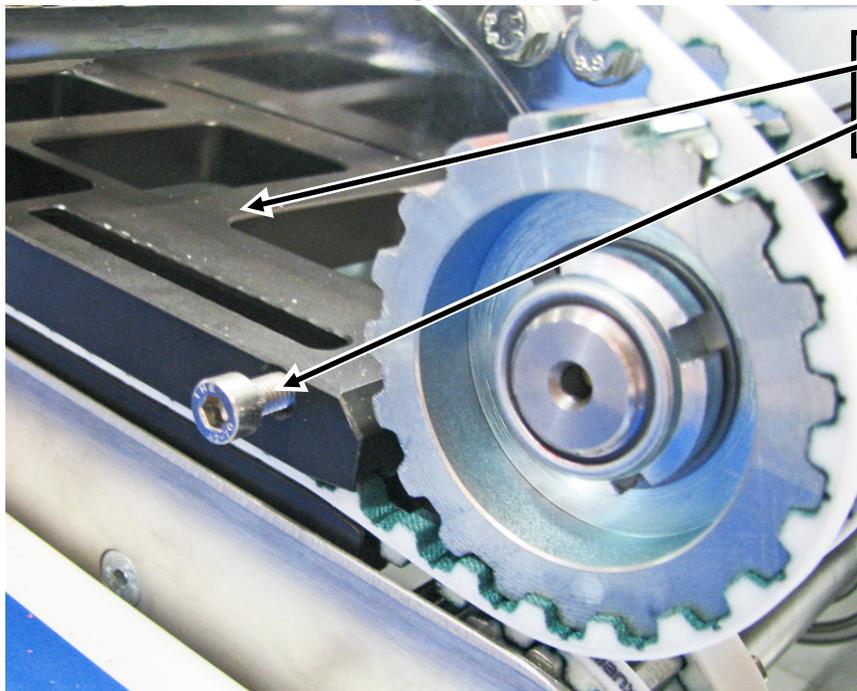
9. Use a 5mm hex key to remove the screws that hold the upper drag belt guide to the side seal frame. See Fig. 9.7.



Fig. 9.7

**IMPORTANT:** A ball drive hex key generally will not have enough contact area to turn these screws. Use a regular profile, straight hex key to avoid stripping the screw heads.

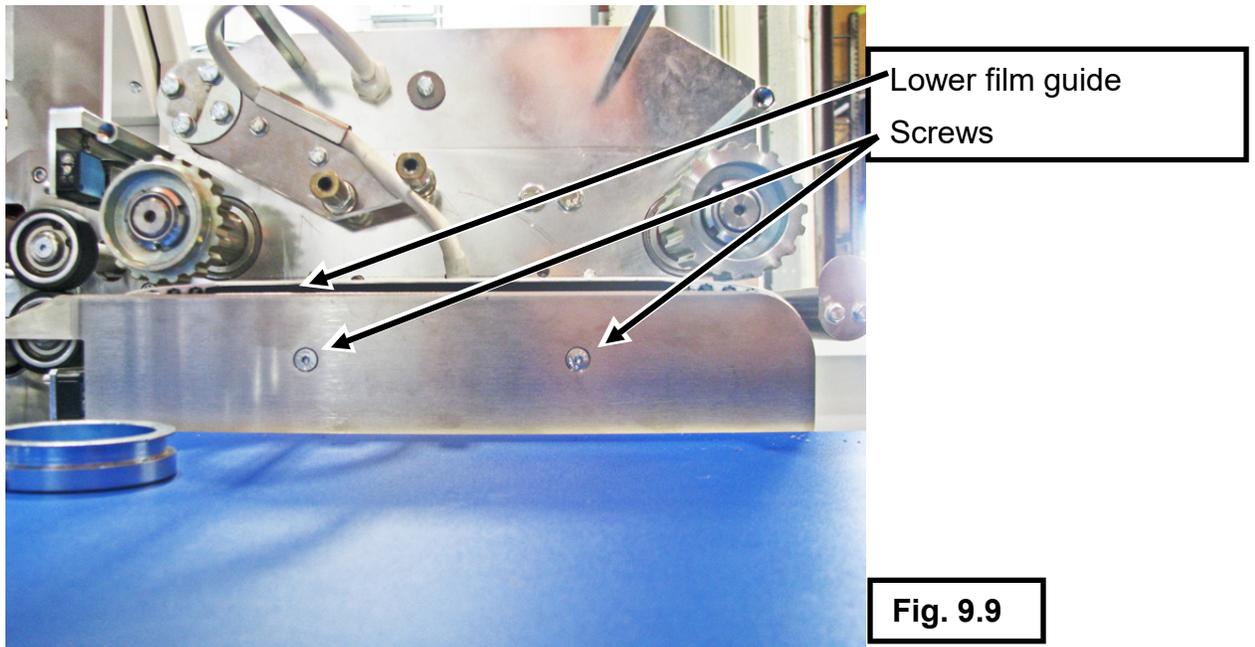
10. Install two M4 socket head cap screws into the holes used for attaching the upper stainless steel film guide. See fig. 9.8.



Upper belt guide  
Cap screw

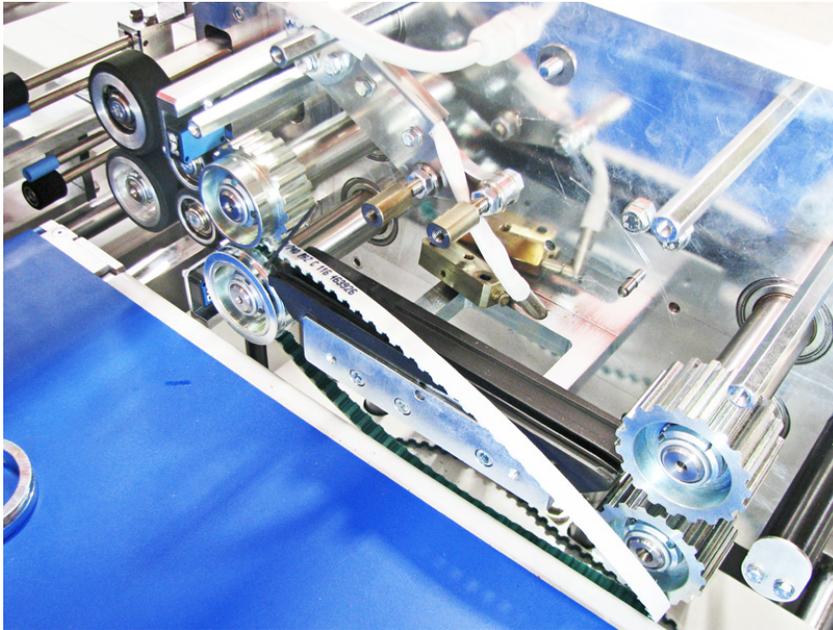
Fig. 9.8

11. Use the heads of the cap screws to pry on, pulling the upper belt guide off of the dowel pins that locate it on the side sealer frame. The wide upper film drag belt will come off with the upper belt guide.
12. Using the knurled knob, adjust the take-away conveyor height all the way down to expose the screws to remove the lower stainless steel cover. See Section 5.6
13. Remove the two screws that hold the top of the lower film guide using a 3mm hex key. See fig. 9.9.



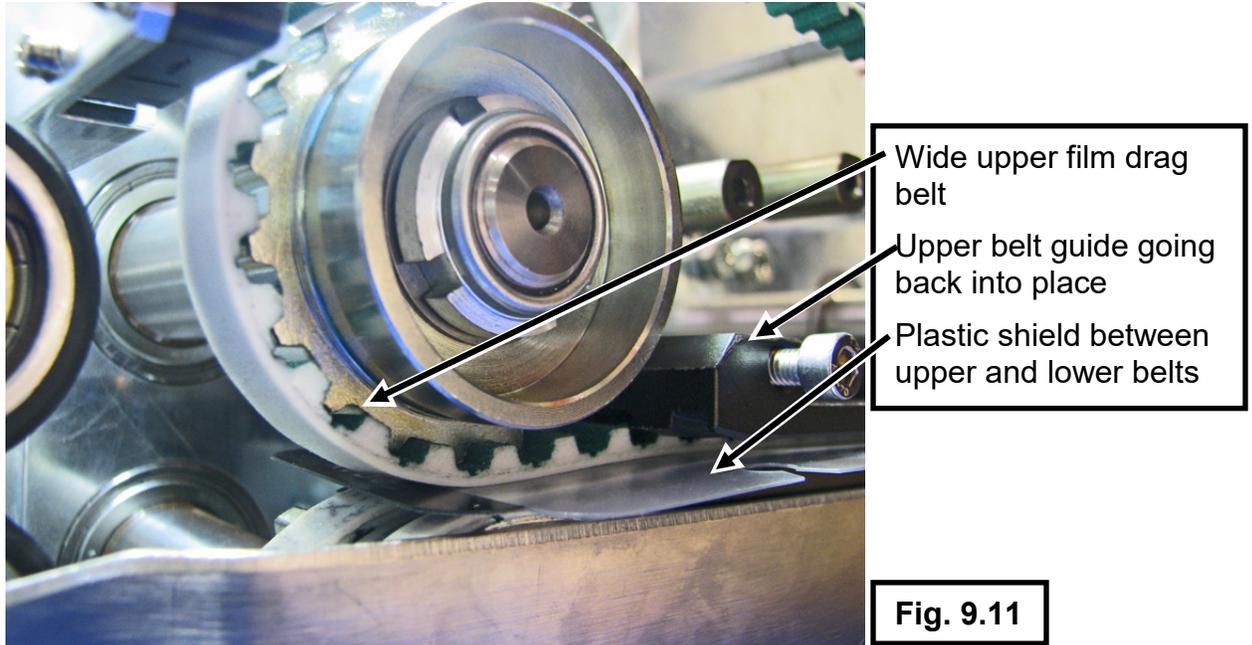
14. Cap screws fasten the hexagonal mounting posts for the lower film guide to the side sealer frame. Remove the cap screws holding the two lower hexagonal mounting posts to the side seal frame using a 7mm socket.
15. Carefully lower the bottom film guide with the lower mounting posts still attached to it, and maneuver it out of the machine.

16. Remove the lower film drag belts in a similar sequence to the removal of the upper film drag belts: See Fig. 9.10
  - a. Remove the lower film drag belt tension pulley.
  - b. Move the thin lower film drag belt as needed to reach the set screw that holds the collar on the idler pulley.
  - c. Remove the collar.
  - d. Remove the belts.



17. Inspect the lower film guide:
  - a. There are two separate spring-loaded guide tracks.
  - b. The guide tracks should each pivot like a see-saw on the central locating pin.
  - c. The guide tracks should each push down in their entirety, and spring back up.
  - d. There should be no binding in either motion.
  - e. If there is binding, remove the lower film guide assembly and clean or repair it as needed to get smooth, consistent motion.
18. Reinstall the lower film drag belts, reversing the removal process.
19. Place a semi-rigid shield on top of the lower film drag belts. The back cover of this manual is about the right thickness and rigidity. The shield should run the full length of the contact area between the upper and lower film drag belts.

20. Position the wide upper film drag belt in the wide groove of the upper belt guide, and start the belt as far as possible onto the drive and idler pulleys while slipping the upper belt guide into place. See Fig. 9.11.

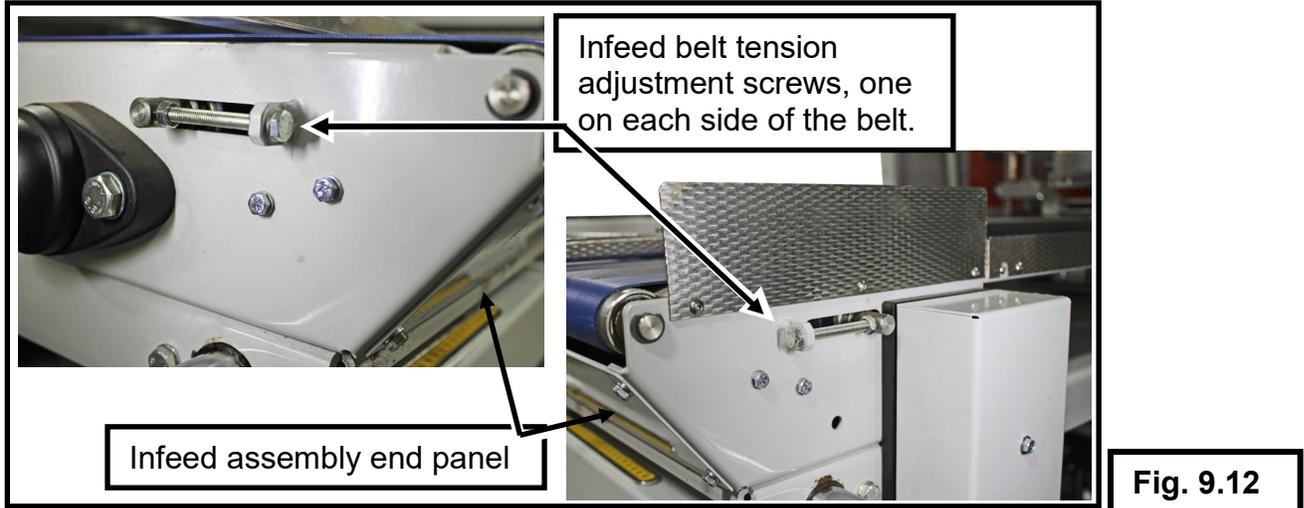


21. Once the upper belt guide is started over the dowel pins, start and tighten the socket head caps screws to draw it into place. As the groove for the thin film drag belt moves in, start the thin film drag belt through the groove and around the pulleys and collar.

22. Complete reassembly, installing film guides, tension pulleys, seal knife, and covers.

### 9.5 Infeed Belt Idler Roller

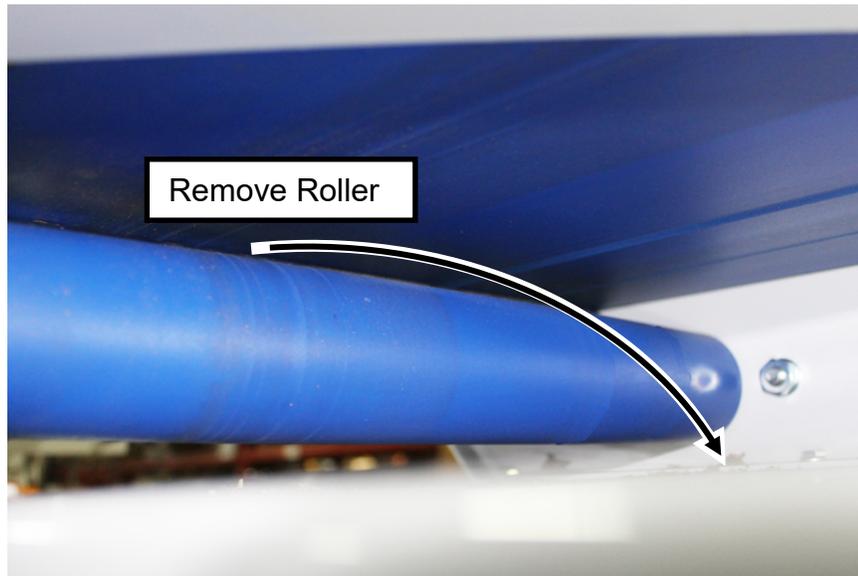
1. Use the infeed assembly release knob to slide the infeed assembly toward the front of the sealer.
2. Remove the end panel from the infeed end of the base of the machine.
3. Note the positions of the belt tension adjustment screws, bearing in mind that they may have been adjusted to compensate for a bearing that is loose. See Fig. 9.12.



4. Loosen the jam nuts and turn the adjuster screw to relieve as much tension from the belt as possible.
5. Remove the infeed assembly end panel.
6. Attempt to slide the tension roller out of the slot that holds it. If it will not come out, remove the retaining rings from the ends of the infeed end roller shaft, and maneuver it to remove it from the infeed assembly. This will provide more slack in the belt.

**NOTE:** There are spacer sleeves on the ends of the idler roller shaft and the infeed roller shaft.

7. Working from interior side of the infeed belt, withdraw the idler roller. See Fig. 9.13.



**Fig 9.13**