

TROUBLE SHOOTING GUIDE

L- BAR SEALER:

| PROBLEM | POSSIBLE CAUSE |
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| No "Power-On" Indication | <ol style="list-style-type: none">1. Not connected to power source2. Switch/Breaker defective or switched to "off" position3. Indicator light defective. |
| Seal Bar not held down | <ol style="list-style-type: none">1. Machine turned off2. Magnet failed3. Bad fuse on PC board4. Gap between magnet and plate set too wide5. Pulse switch defective or out of adjustment6. PC board failed |
| Seal Bar not released by magnet | <ol style="list-style-type: none">1. PC board failed2. Magnet shorted to ground |
| Seal wires do not get hot | <ol style="list-style-type: none">1. Pulse switch defective or out of Adjustment2. Bad fuse3. Fuse on PC board failed4. Broken seal wire5. Pulse transformer defective6. PC board defective |

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| Front seal wire does not heat | <ol style="list-style-type: none">1. Broken wire2. Pulse transformer defective3. Pulse switch defective4. Bad fuse5. Loose wire connection |
| Side seal wire does not heat | <ol style="list-style-type: none">1. See "Front seal wire does not heat" |
| Seal wires overheat | <ol style="list-style-type: none">1. Wire temperature set too high2. PC board failed |
| Weak seals and/or poor cut-off | <ol style="list-style-type: none">1. Film too taut2. Inadequate seal pressure3. Build-up on wires4. Worn tape5. Improper seal wire installation6. Incorrect wire temperature7. Incorrect dwell setting8. Worn composite bead(s) or seal bed |
| Film sticking to seal wires | <ol style="list-style-type: none">1. Incorrect dwell setting2. Build-up on wires3. Incorrect wire temperature |
| Excessive seal wire smoke | <ol style="list-style-type: none">1. Incorrect seal wire temperature2. Incorrect dwell setting |
| Weak spot in seal | <ol style="list-style-type: none">1. Build-up on seal wires2. Worn beads or seal beds3. Inadequate seal pressure4. Improper seal wire installation5. Worn tape |

Seal failure in tunnel

1. See "Weak Seals"
2. Inadequate or incorrect positioning of perforator

Conveyor does not run

1. Bad fuse
2. Failed fuse on PC board
3. Adjustment time set too low
4. Defective motor
5. Failed PC board
6. Conveyor jammed
7. Worn bearings
8. Broken drive chain
9. Loose wire connection

Conveyor runs continuously

1. Reset parameter #15 to 50
2. Failed PC board

SHRINK TUNNEL:

| PROBLEM | POSSIBLE CAUSE |
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| No "Power-On" indicator | <ol style="list-style-type: none">1. No power connected or phase missing2. Switch/Breaker off or defective |
| No response from blower or conveyor | <ol style="list-style-type: none">1. Switch/Breaker off or defective2. Blown fuse3. Overheat situation4. Loose connection |
| Blower does not run | <ol style="list-style-type: none">1. Switch/Breaker off or defective2. Failed blower assembly3. Blown fuse4. Loose connection |
| Conveyor does not run | <ol style="list-style-type: none">1. Switch/Breaker off or defective2. Blown fuse3. Motor failed4. Conveyor jammed5. Defective speed control6. Chains too tight |
| No heat in tunnel | <ol style="list-style-type: none">1. Defective solid state relay2. Faulty thermostat (PC board)3. Failed heating element4. Overheat protective shutdown5. Loose connection |
| Low heat in tunnel | <ol style="list-style-type: none">1. Low source voltage2. Air flow restricted |

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| Heat not adjustable | <ol style="list-style-type: none">1. Defective solid state relay2. Defective thermocouple3. PC board failure |
| Low air flow | <ol style="list-style-type: none">1. Air flow restricted2. Blower assembly not tuning freely3. Blower wheel loose4. Lower baffle closed |
| Film burns on package bottom | <ol style="list-style-type: none">1. Silicone roller covering damaged2. Temperature too high3. Conveyor speed too low4. Inadequate air evacuation |
| Film burns on top or sides | <ol style="list-style-type: none">1. Temperature too high2. Conveyor speed too low3. Inadequate air evacuation4. Package too large |
| Improper film shrinkage | <ol style="list-style-type: none">1. Temperature too low2. Conveyor speed too fast3. Improper air evacuation4. Poor seal quality |