

IMPULSE AUTO-SEALER

305FDA, 3010FDA, 455FDA, 4510FDA,

605FDA, 6010FDA, 805FDA,

305FSA, 3010FSA, 455FSA, 4510FSA,

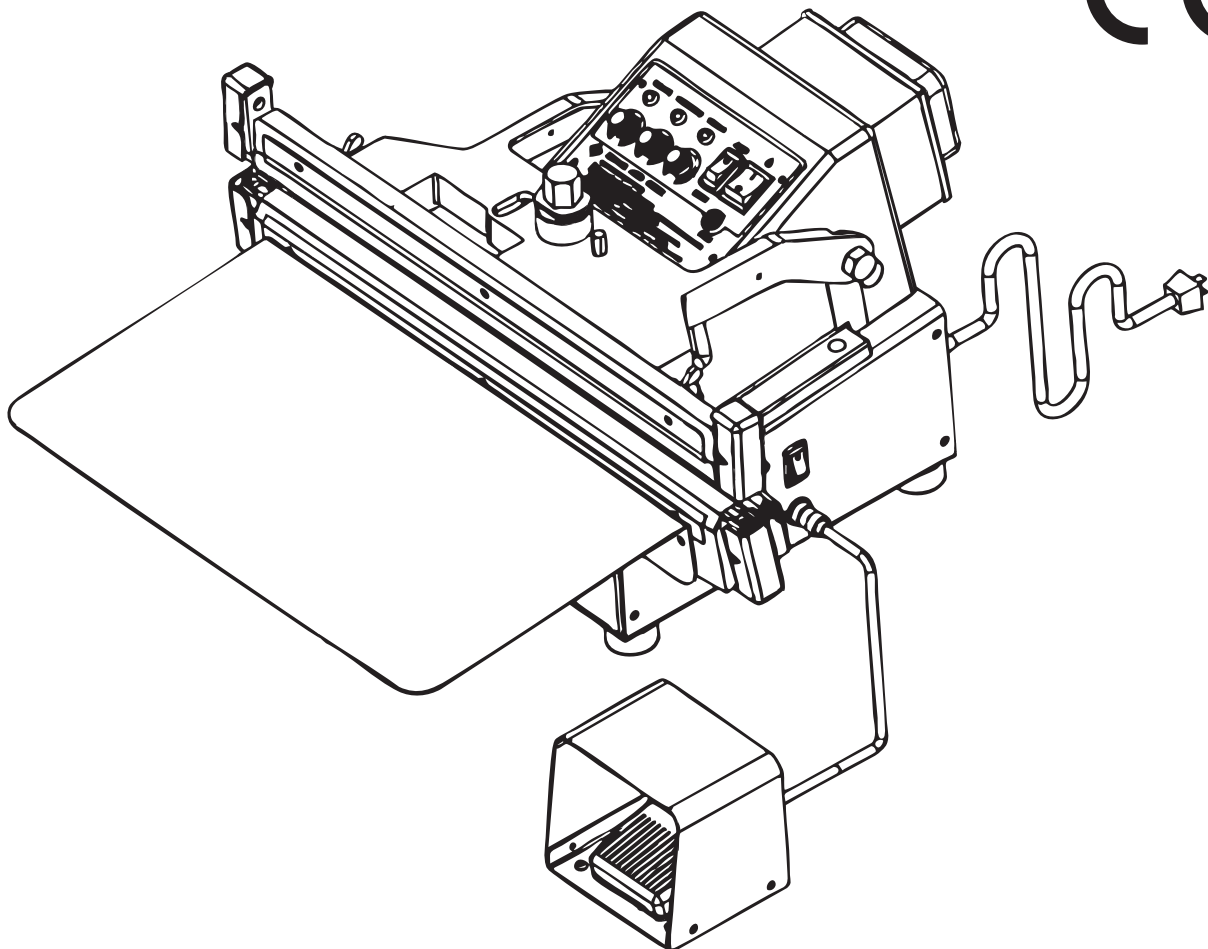
605FSA, 6010FSA, 805FSA with Temp. Controller

(FDV & FSV for VERTICAL SERIES)

310FDA, 410FDA, 610FDA, 310FSA, 410FSA, 610FSA

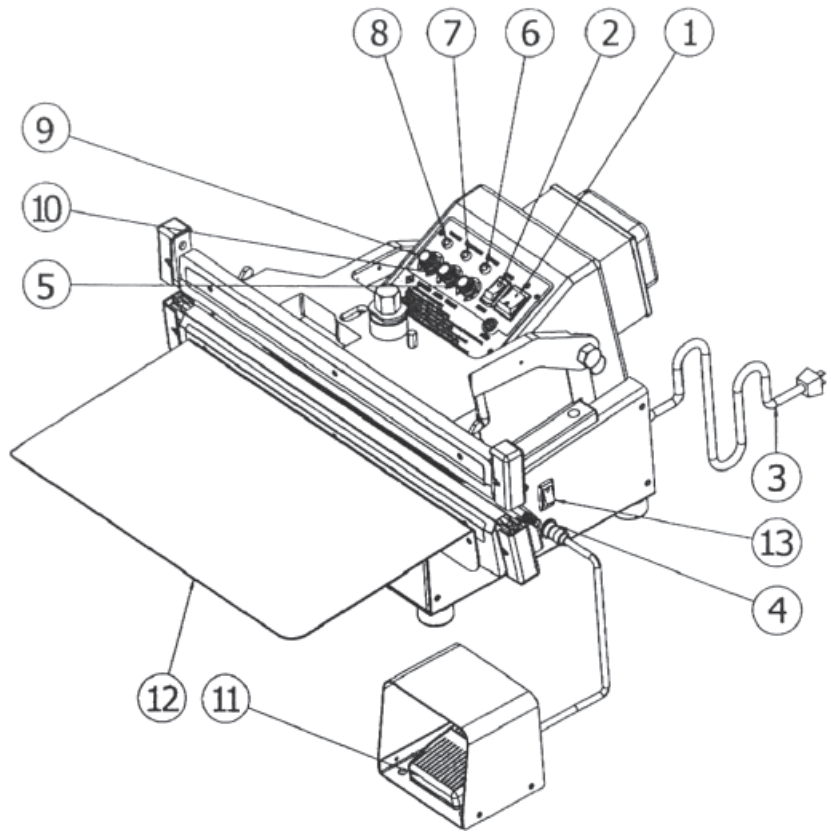
INSTRUCTION MANUAL

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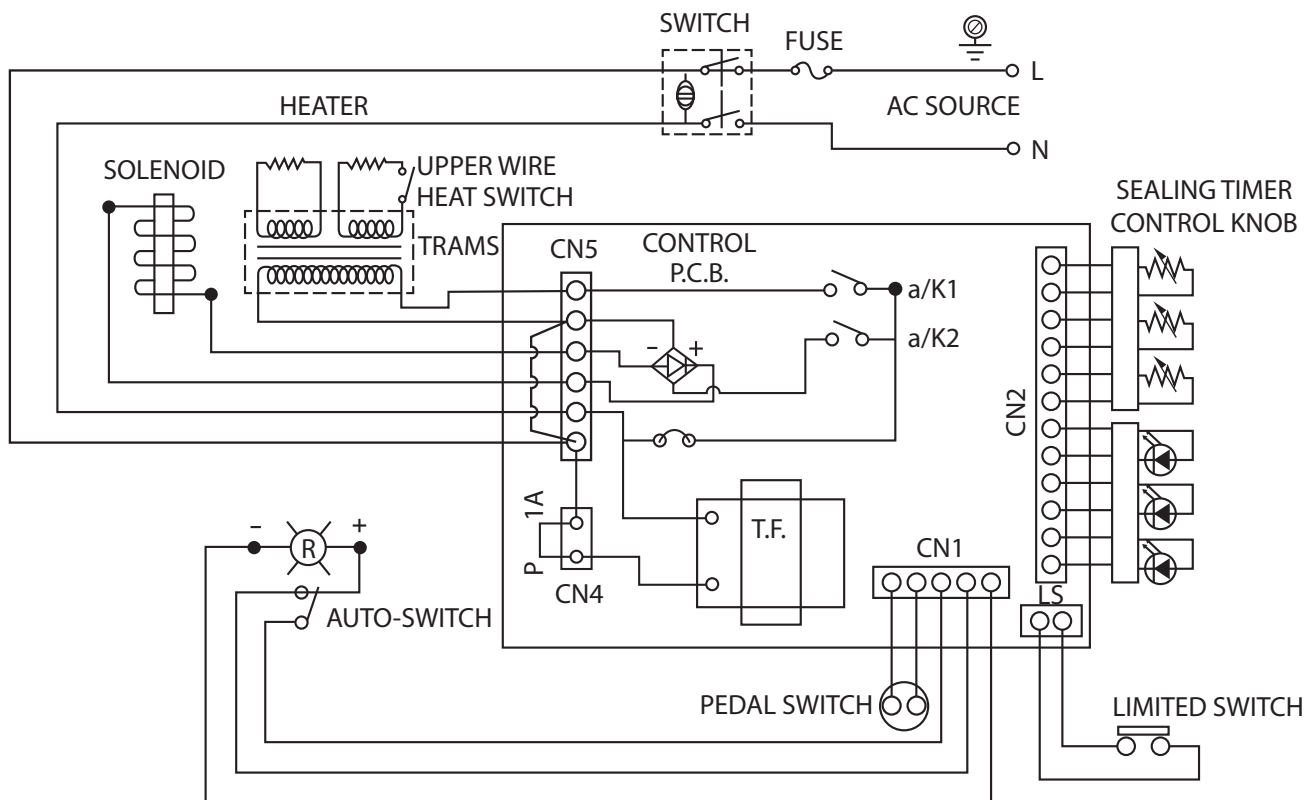


1. SEALER PARTS (FDA SERIES)

1. Power Main SW.
2. Auto Switch
3. Power Supply Card
4. Pedal SW. Socket
5. Sealing Timer Knob
6. Sealing Indication Lamp
7. Congealing Indication Lamp
8. Re-Cycle Indication Lamp
9. Re-Cycle Timer Knob
10. Congealing Timer Knob
11. Pedal Switch
12. Operating Board
13. Upper Wire Heat Switch



2. ELECTRIC CONNECTION DIAGRAM (FDA SERIES)



3. OPERATING INSTRUCTIONS (FDA SERIES)

The FDA 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. The operator can choose one single heating or dual side heating. This makes it possible to seal thinner or thicker material using one sealer.

1. With the power plug into an AC outlet.
2. Turn main switch to ON position. A yellow light will appear.
3. Select to MANU position for manual operation by pressing the foot pedal switch, or set to AUTO position for automatic operation by the timer.
4. Adjust the sealing timer (heating time) knob according to bag thickness and material.
5. Adjust the congealing timer (cooling time) knob according to the heating time.
6. Adjust re-cycle timer knob according to the frequency of continuous work.
7. Place sealed bag to seal in between sealing jaws, then press the foot pedal switch, the sealing jaws will close and sealing pilot lamp illuminate until the heating time is off. Follow the lamp change automatically for congealing time and Re-cycle time. The jaws will open automatically when seal cycle is completed, then you can remove the sealed bag. You are ready for another bag to seal.
8. Turn off machine when not in use.

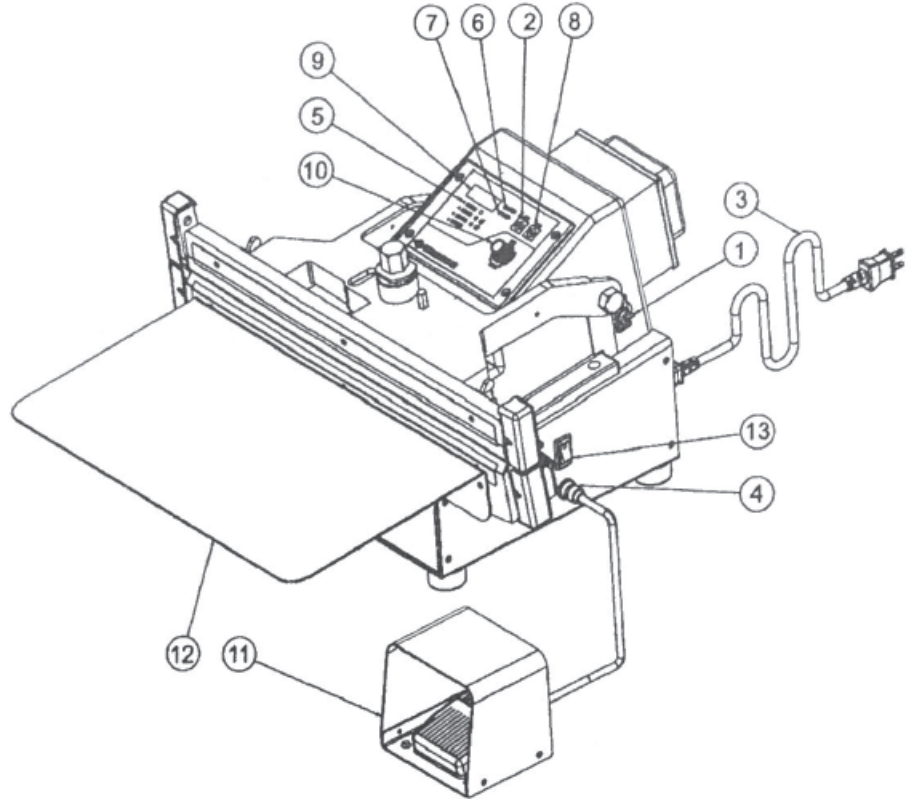
NOTE: Sealing and Congealing time are according to the thickness and material of the plastic bags. The congealing time should be double the heating time. Re-cycle timer is according to working speed of the operator.

CAUTION:

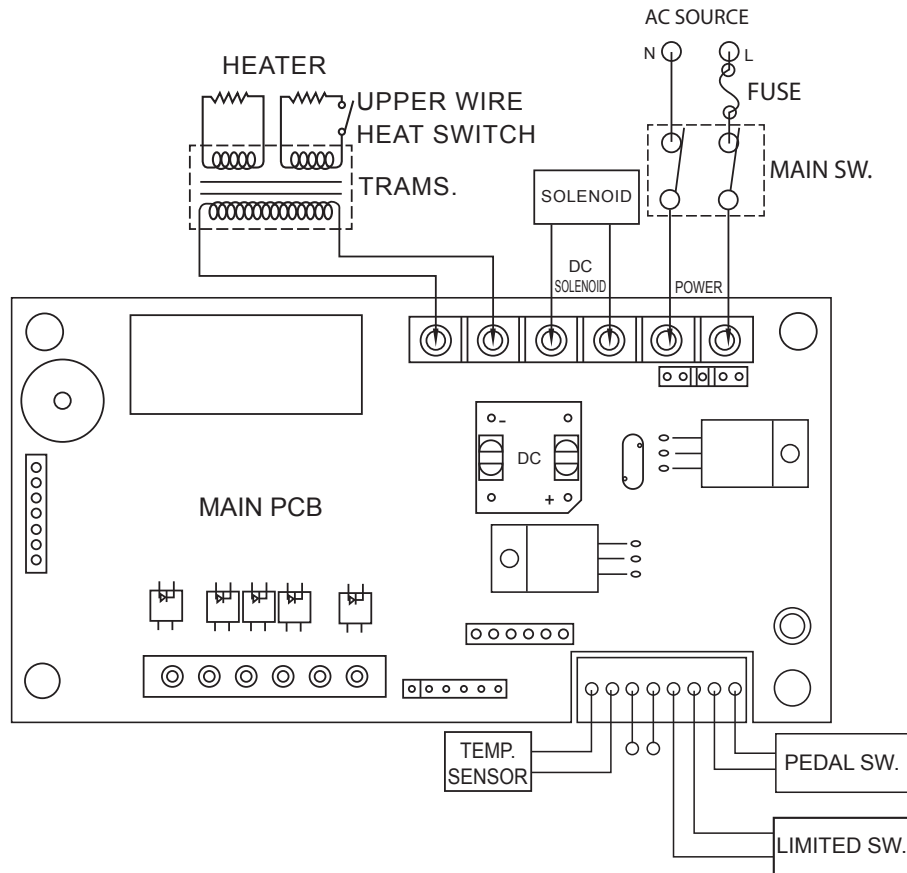
The machine has an added safety feature for your protection. The upper press jaw will fail to close completely if a foreign object, such as a finger or tool is between the jaws. To reactive the sealer, turn off the main power switch. Wait 3 seconds and turn switch back on, machine will again be operational.

4. SEALER PARTS (FSA SERIES)

1. Power Main SW.
2. Auto SW & Lamp
3. Power Supply Card
4. Pedal SW. Socket
5. Lamp Indicator for Temp. & Timer
6. Sealing Indication Lamp
7. Congealing Indication Lamp
8. Pause & Play SW. (Memory)
9. LED Lamp Window
10. Encode Knob
11. Pedal Switch
12. Operating Board
13. Upper Wire Heat SW



5. ELECTRIC CONNECTION DIAGRAM (FSA SERIES)



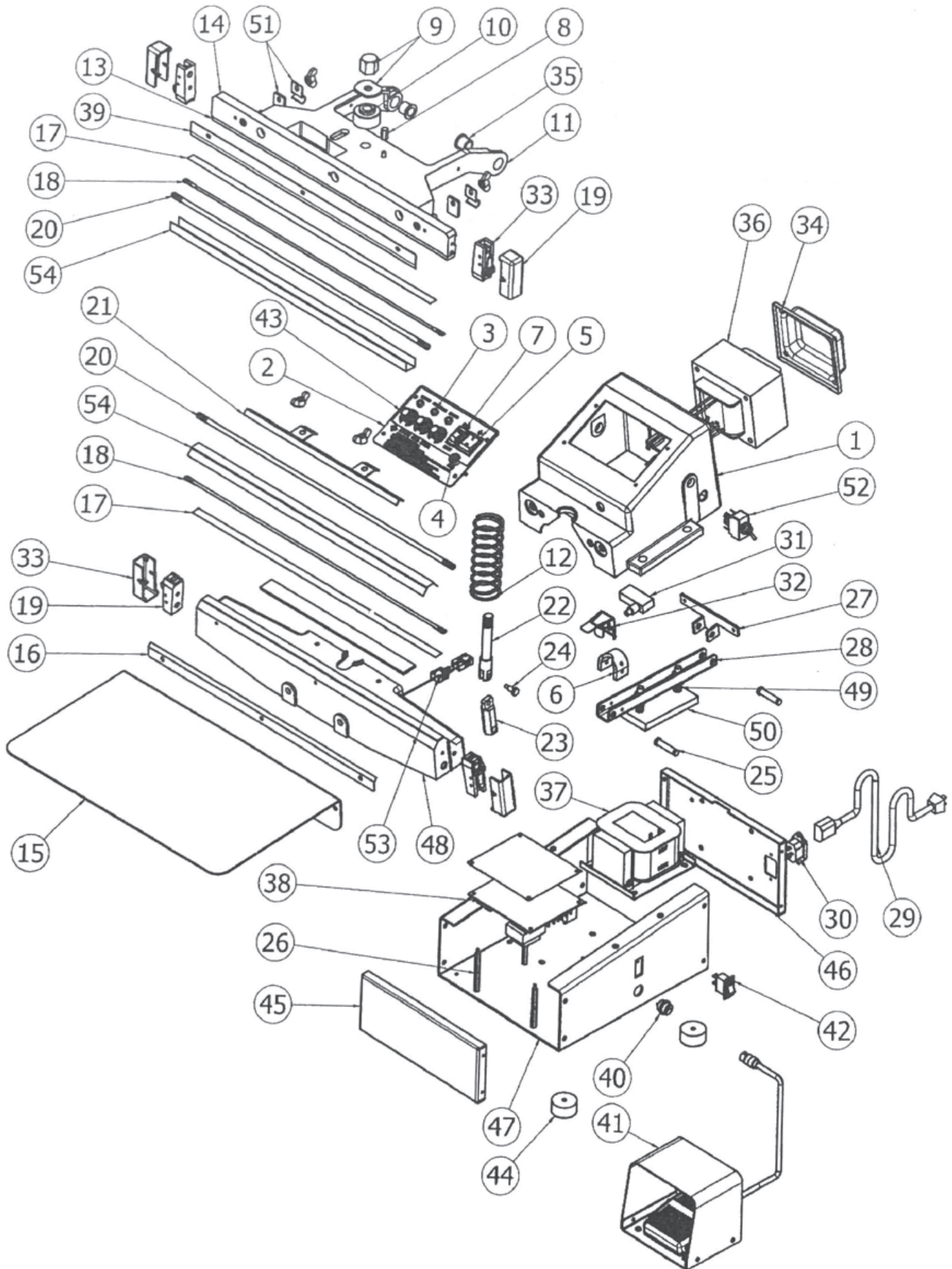
6. OPERATING INSTRUCTIONS (FDA SERIES)

To use the sealer after the machine is fully assembled, do the following:

1. Insert the power plug into an AC outlet.
2. Turn the main switch to the ON position. The sealer temp LED window will display the sealing temperature, indicating that the power is on.
3. Set the sealer to the appropriate operating program. Press the encode knob once and then the LED lamp of heat temperature will be illuminated. Adjust the encode knob for thickness and material of bag. To increase the temperature, turn temperature control knob clockwise or to decrease temperature, turn the knob counterclockwise. Follow the same procedure to adjust for Heat Time, Cool Time and Re-Cycle Time. All settings be made, you should be to press the Pause & Play SW. once more for memory.
4. With bag open, position the bag onto the sealer bar to operate unit. Step on the pedal switch, the sealing jaws will close, and then be followed by sealing and cooling. The jaws will open automatically when cycle is completed. If sealing does not complete, turn the knob up a little to increase the heating temperature and sealing timer, repeat the program. Keep increasing the number until you get the desired seal. When the desired seal is achieved remove the sealed bag and begin the cycle anew.
5. When you press "Pause & Play" switch, the unit will stop and the LED window will display "STOP" until the sealer is ready again and the LED window displays sealing platform temp.
6. When auto. switch was selected the sealer will operate automatically according to your packing timer setting.
7. Turn off the sealer when not in use.

NOTE: Heat temperature & Heat time is selected according to the thickness and material of the plastic bags. Cooling time should be double the heat time. Re-cycle timer is set according to working speed of the operator.

CAUTION: The machine has an added safety feature for your protection. The sealer jaw will fail to close completely if a foreign object such as a finger or a foreign object is between the jaws. The LED window appears "SEAL" and Beep automatically. To reactive the sealer, you need to press down the "Pause & Play" switch once, the beeping will stop and the LED window displays "Stop". User should press Pause & Play switch again and LED window displays sealing platform temperature. You are now ready to begin using the sealer again.



8.

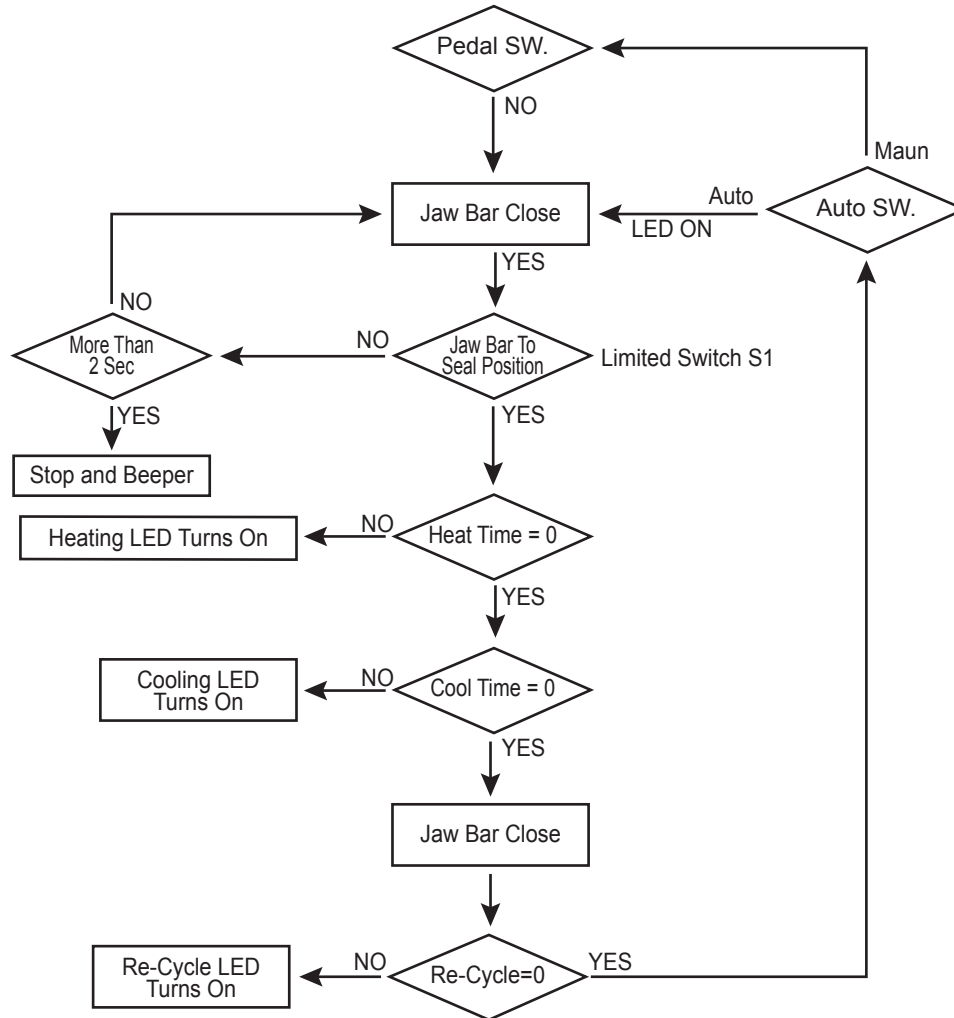
PARTS LIST

#	DESCRIPTION	PART #	#	DESCRIPTION	PART No.
1	Enclosed Body	2B10-4003	28	Upper Jaw Lever	1C10-4052
2	Temp. Controller (FSA)	2F80-4100	29	Power Plug	1E30-1032*
3	Pilot Lamp	1E40-3001	30	Sockey (EMI Filter)	2E90-2013
4	Fuse Holder	1E70-4002	31	Limited Switch	1E10-3004
5	Power Main Switch	1E10-3000	32	Interlock Set	1C10-4003
6	Rubber Pad for Lever	1G10-5001	33	End Caps	1A10-3003
7	AUTO Action Switch	1E10-3002	34	Transformer Cover	1C10-4021
8	Setting Hexagon Nut	1D10-4008	35	Flange for Press Jaw	1D20-3004
9	Upper Nut & Washer	1D10-4004	36	Transformer	1E20-4503*
10	Pressing Rubber	1G10-4002	37	Solenoid	1E20-3504*
11	Upper Press Jaw	2B10-4031	38	Control PCB (FDA)	1F30-3002*
12	Return Spring	1R10-4003	39	Upper PTFE Fixed Plate	1C10-4009*
13	Sealing Silicon Rubber	1G20-3002*	40	Connector for Switch	1E10-3007
14	Silicon Holder Jaw	1B10-4105*	41	Pedal Switch	1E10-9003
15	Working Plate	1C10-4046*	42	Upper Wire Heat Switch	1E10-3002
16	Lower PTFE Fixed Plate	1C10-3016*	43	Time Adj. Knobs	1A10-1001*
17	PTFE Cloth Strip	1J50-4422*	44	Rubber Foot	1G10-4001
18	Heating Wire	2E50-6455*	45	Forward Cover	1C10-4025
19	Heater Terminal Assembly	2A10-3000	46	Back Cover	1C10-4026
20	Bar for PTFE Cloth	1D10-3005*	47	Enclosure Base	1C10-4051
21	Clip for PTFE Cloth	1C10-3013*	48	Lower Sealing Body	2B10-4006*
22	Upperm Lever	1D10-4005	49	Spring for Magnet Plate	1R10-3002
23	Down Lever	1D10-4012	50	Magnet Plate	1C10-3008
24	Bolt for Lever	1D10-3017	51	Clip for Upper Cloth	1C10-4011
25	Grove Pin	1D10-3007	52	Toggle Switch (FSA)	1E10-9010
26	Support for PCB (FDA)	1A10-4010	53	Temper. Sensor (FSA)	1E70-5002
27	Hinge Bracket	1C10-4053	54	PTFE Roll Cloth	1J50-3445*

*Model type & sizes need to be known.

9.

FLOW DIAGRAM



10.

HELPFUL INFORMATION

1. Always keep the sealing platform clean. Particular care should be taken to remove any residue form the PTFE cloth.
2. Do not clean the sealing platform with anything wet.
3. Make sure to change the bottom PTFE strip (below the element wire) when they become worn. If this is not done the element wire may short out and 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. Occasionally check the condition of the top pressure pad (silicon rubber) for wear or burn. A poor rubber pad will effect on the quality of your seal.

11. CHANGING PARTS

To replace burnt out PTFE cloth or broken element wire please follow these instruction:

REMOVE PLUG FROM ELECTRIC OUTLET

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 then changing a new PTFE cloth and re-fix the PTFE fixed plate.

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

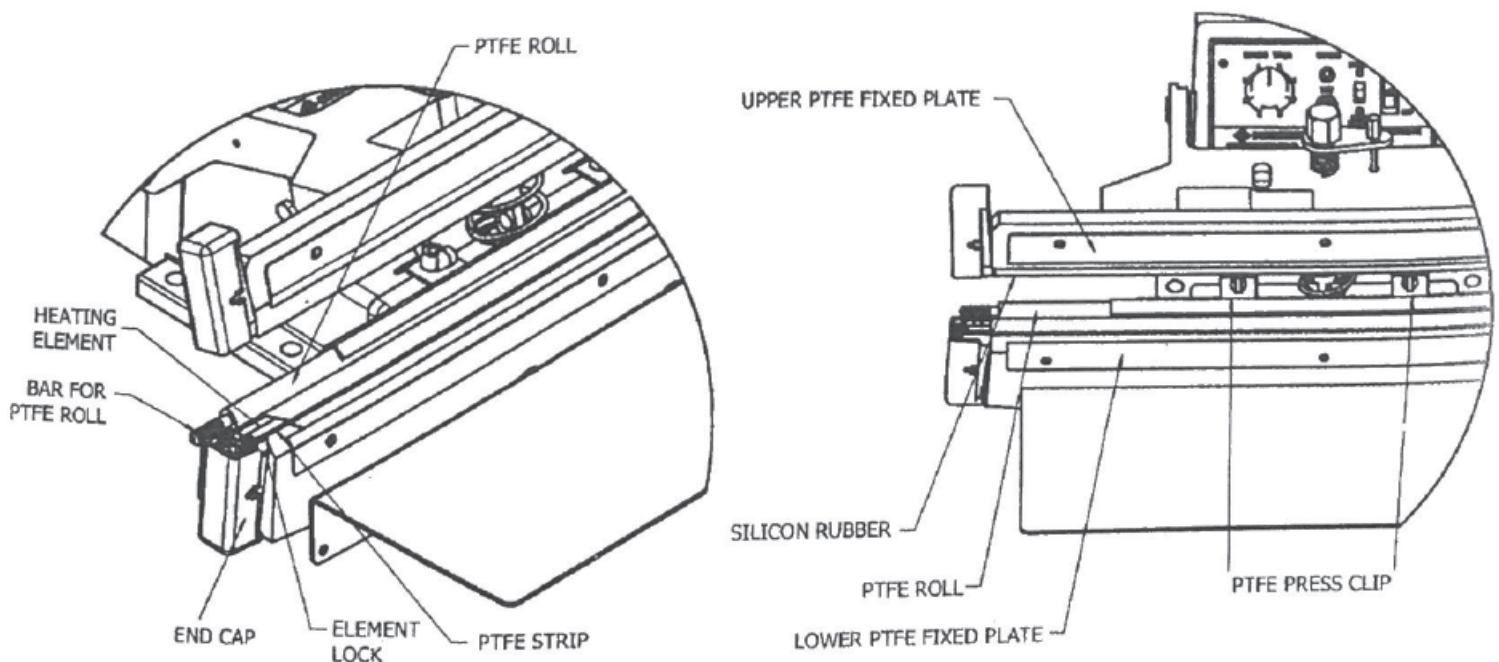
2. Replacing heating element wire

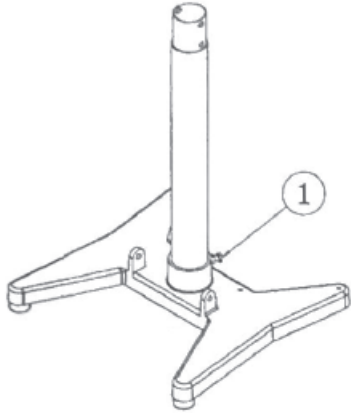
A. Loosen PTFE press clips. Remove the PTFE fixed plate.

B. Lift up PTFE cloth. and remove broken element wire from heater poles. (Heater Element Attachment)

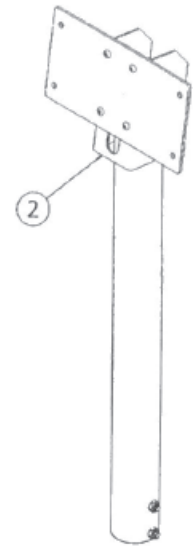
C. Put new element wire on heater poles. Do not bend or crimp the wire.

D. Reattach PTFE cloth and PTFE fixed plate. Tighten PTFE roll cloth with PTFE bar. Tighten the press clips.

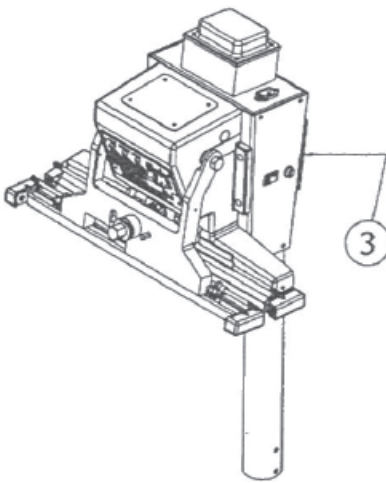




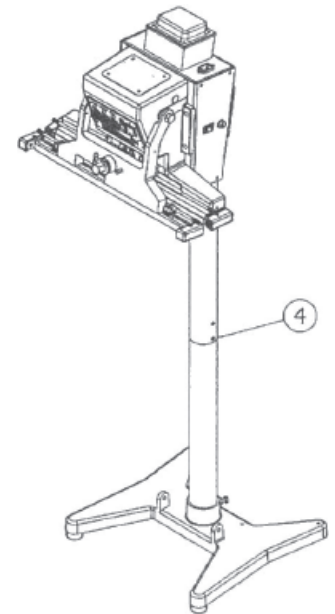
1. Insert the short standing tube into pedal base and fixed with two short screws.



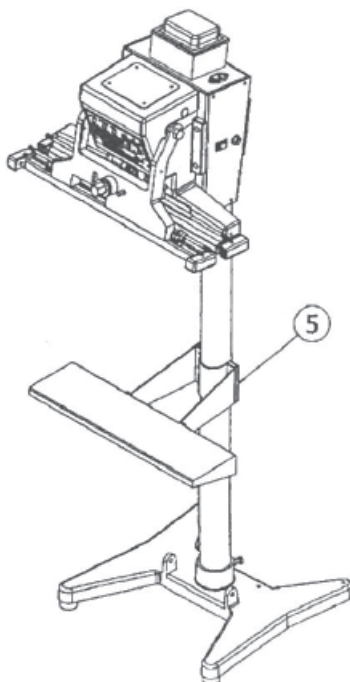
2. Adjust angles to keep same vertical between the stand tube and the bracket of body, and then with two M6 thumb knobs tighten fixed it.



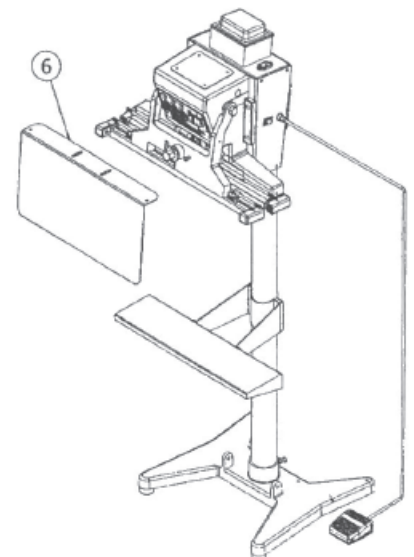
3. With four M8 screws connect the upper stand tube set to the bottom of enclosure body.



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



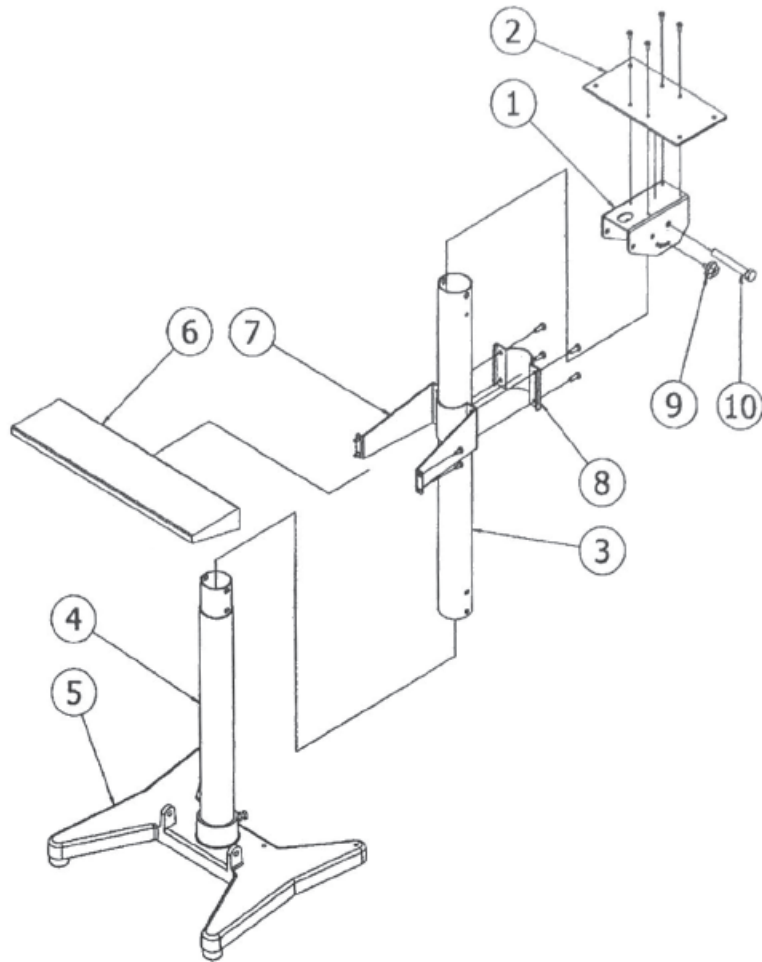
5. Fixed working bracket set to standing tube with four M6 screws. Note: When attaching working bracket to standing tube leave enough space between lower sealing body and bracket so that working plate can be attached easily.



6. Fixed back plate (working plate) to under body jaw with two thumb nuts then connect the foot switch to the connector of body base.

13. FDV SERIES ADDITIONAL CONSTRUCTION

1. Body Adjust Bracket
2. Body Connect 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 Knob
10. M8x80mm Bolt Screw



14. CAUTIONARY MARKING

CAUTION

1. To reduce the risk of shock, disconnect the unit from the supply circuit before servicing the replacement of the heating element.
2. To provide continued protection against risk of electric shock, connect to properly grounded outlet only.
3. If the supply cord is damage, it must be replaced by a special cord or assembly available from the manufacture 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 type cartridge and 20 ampere fuse, provided in legible adjacent to fuse holder.
3. Close supervision is required when the product is used near children.

15. SPARE PARTS

ACCESSORIES	QUANTITY
Heating Wire	2
Fuse	10Ax1 or 20A x 1 or 30Ax1

Kit: Working Plate, Pedal Switch, Power Plug.

16. SPECIFICATIONS

MODEL	305FDA / 3010FDA	455FDA/4510FDA	605FDA/6010FDA	805FDA
Max. Seal Length	300mm (12")	450mm (18")	600mm (24")	800m (32")
Seal Width	5mm / 10mm	5mm / 10mm	5mm / 10mm	5mm
Max. Seal Thickness	2x0.4mm	2x0.4mm	2x0.4mm	2x0.4mm
Heating Timer	0.3-2.2S	0.3-2.2S	0.3-2.2S	0.3-2.2S
Congeaing Timer	1.0-8.0S	1.0-8.0S	1.0-8.0S	1.0-8.0S
Re-Cycle Timer	1.0-8.0S	1.0-8.0S	1.0-8.0S	1.0-8.0S
Watts	1600W/2100W	1900W/2500W	2300W/2900W	2700W
Weight	22Kg/24Kg	24Kg/26Kg	26Kg/28Kg	30Kg
Dimension (WxDxH)	36x37x30cm	51x39x30cm	66x40x30cm	86x39x30cm

FDA & FDV series specifications are the same.

MODEL	305FDA / 3010FDA	455FDA/4510FDA	605FDA/6010FDA	805FDA
Max. Seal Length	300mm (12")	450mm (18")	600mm (24")	800m (32")
Seal Width	5mm / 10mm	5mm / 10mm	5mm / 10mm	5mm
Max. Seal Thickness	2x0.4mm	2x0.4mm	2x0.4mm	2x0.4mm
Heating Temp.	80-250°C	80-250°C	80-250°C	80-250°C
Heating Timer	0.3-3.5S	0.3-3.5S	0.3-3.5S	0.3-3.5S
Cool Timer	0.3-10S	0.3-10S	0.3-10S	0.3-10S
Re-Cycle Timer	1.0-10S	1.0-10S	1.0-10S	1.0-10S
Watts	1600W/2100W	1900W/2500W	2300W/2900W	2700W
Weight	22Kg/24Kg	24Kg/26Kg	26Kg/28Kg	30Kg
Dimension (WxDxH)	36x37x30cm	51x39x30cm	66x40x30cm	86x39x30cm

FSA & FSV series specifications are the same.