

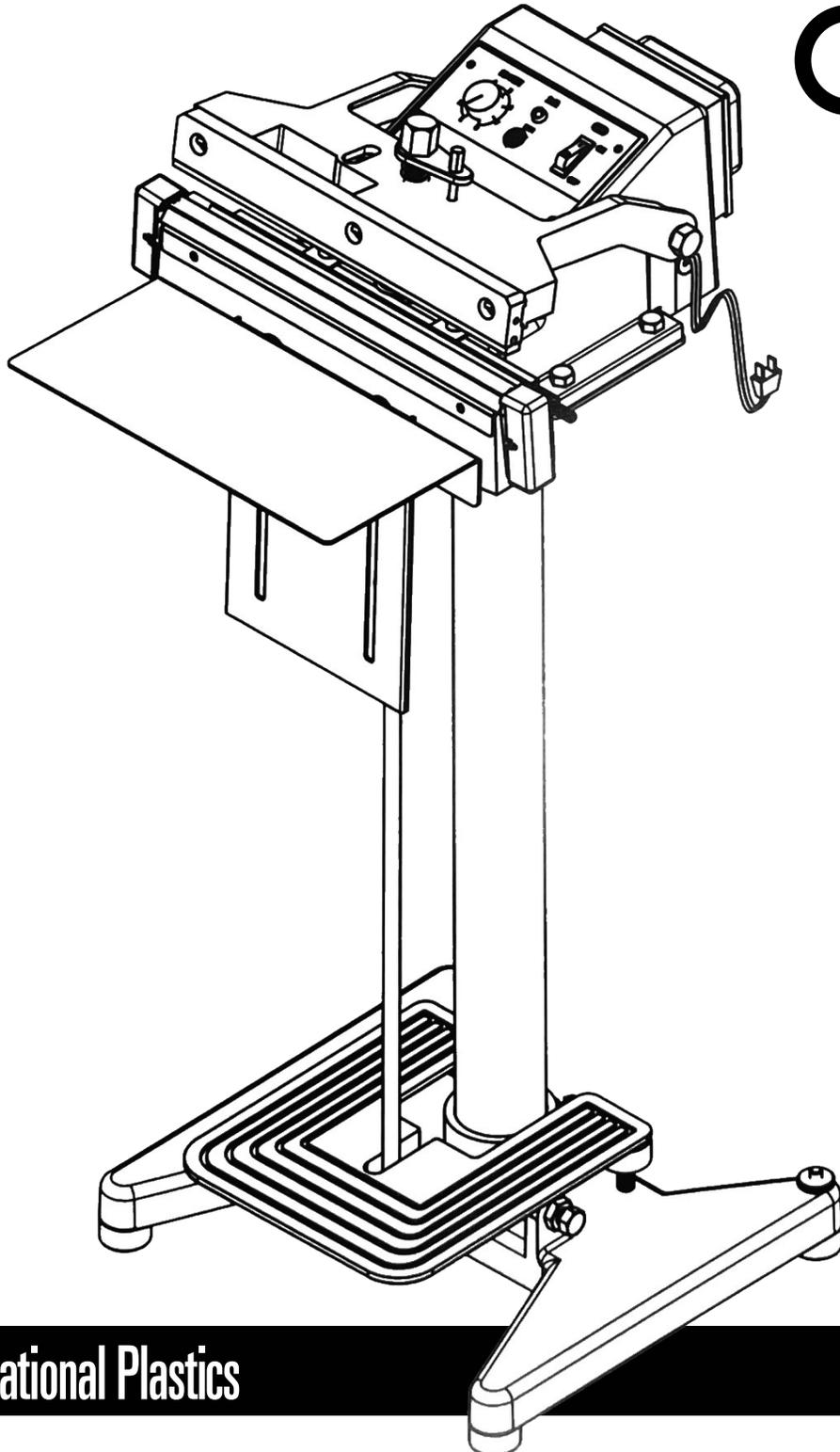
# IMPULSE FOOT SEALER

300FI, 450FI, 600FI, 800FI, 305FI, 455FI, 605FI, 805FI,  
3010FI, 4510FI, 6010FI (310FL, 410FL, 610FL)

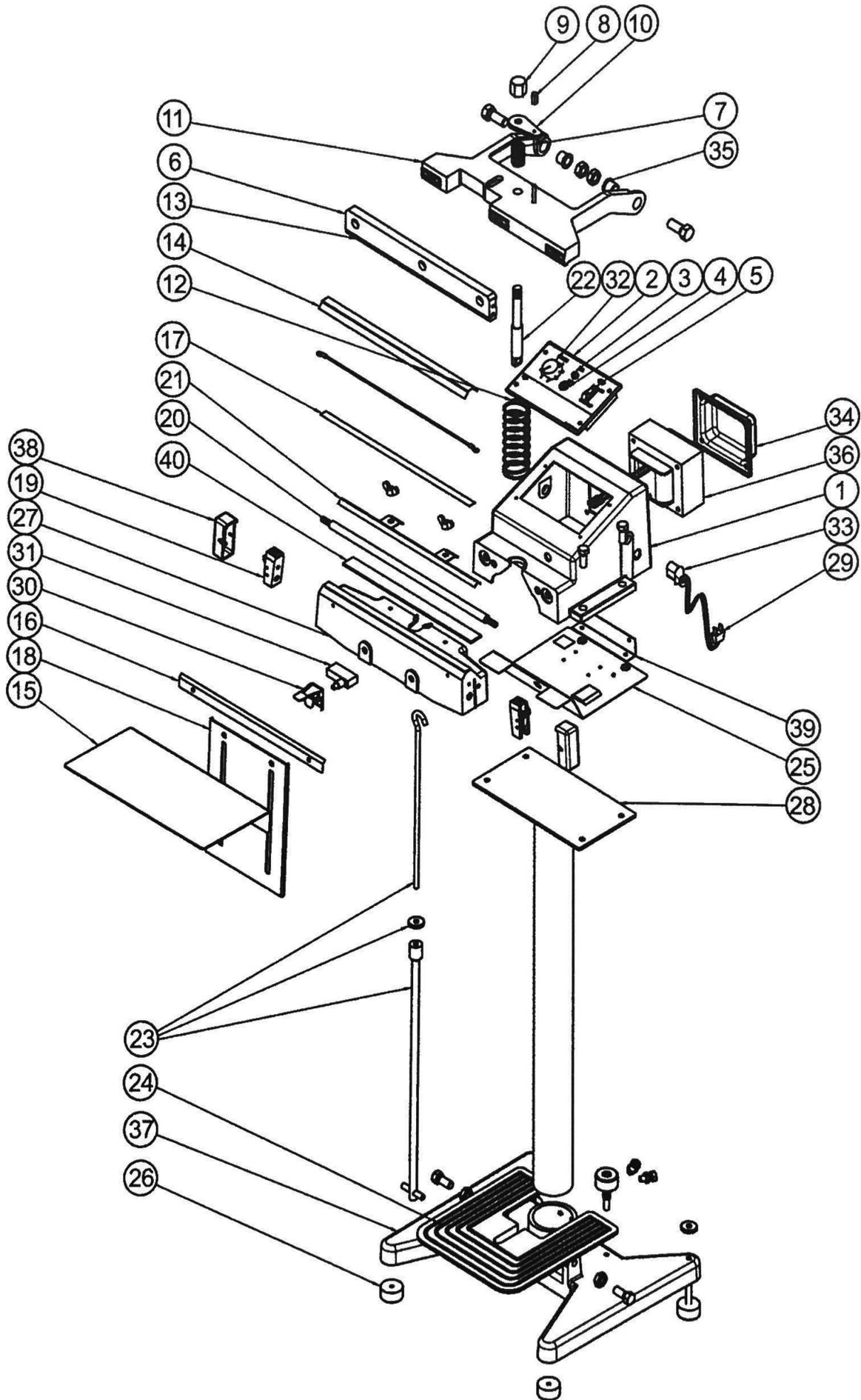
## INSTRUCTION MANUAL

[www.interplas.com/foot-impulse-sealers](http://www.interplas.com/foot-impulse-sealers)

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# 1. CONSTRUCTION DIAGRAM

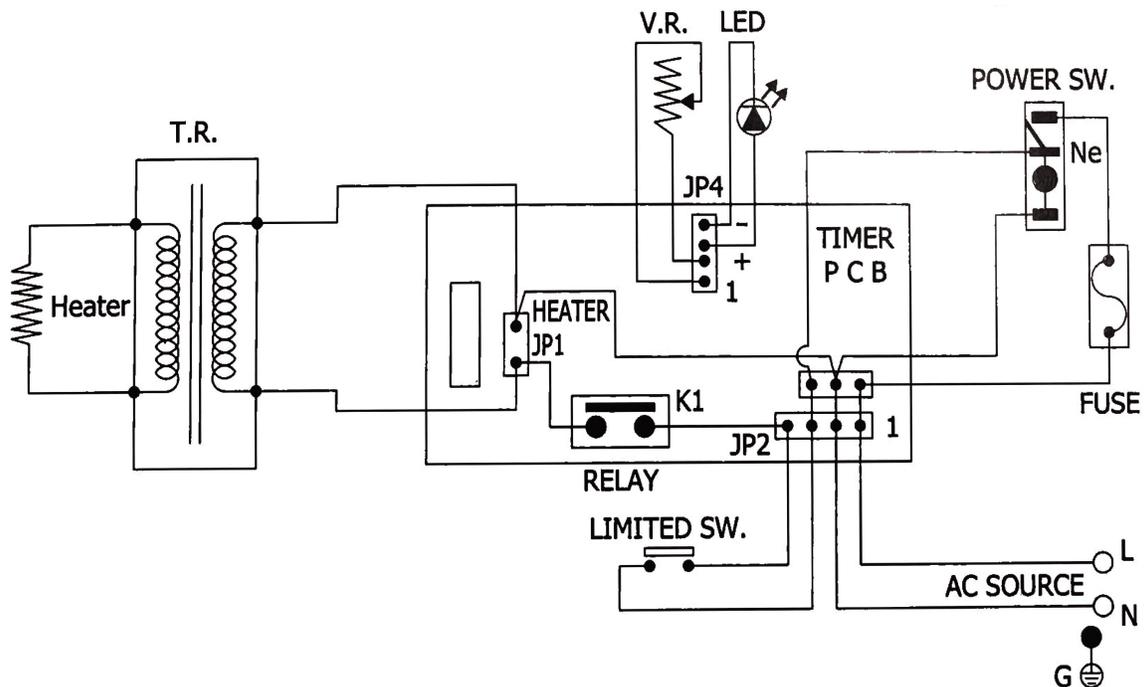


## 2. PARTS LIST

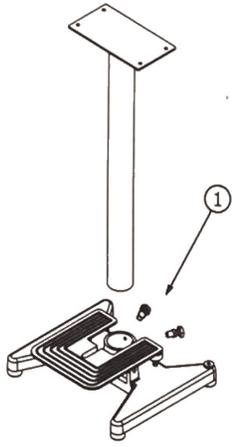
No	DESCRIPTION	PART No	No	DESCRIPTION	PART NO
1	Enclosure Body	2B10-4003	21	Clip For PTFE Cloth	1C10-3013*
2	Control Timer	2F80-4102*	22	Upper Lever	1D10-4003
3	Sealing Led Lamp	1E40-3001	23	Tension Rod Set	1D10-4002
4	Fuse Holder	1E70-4002	24	Foot Pedal	2B30-4002
5	Power Switch	1E10-2002*	25	Bottom Cover	1C10-4001
6	Sealing Rubber Holder	1E10-4114*	26	Rubber Foot	1G10-4005
7	Pressing Spring	1R10-4002	27	Lower Sealing Body	2B10-4006
8	Setting Bolt Nut	1D10-4008	28	Standing Tube	1C10-4035
9	Upper Lever Nut	1D10-4004	29	Power Plug	1C10-4035*
10	Fixing Lever Plate	1C10-4006	30	Interlock Set	1C10-4003
11	Upper Sealing Jaw	2B10-4004	31	Limited Switch	1E10-3004
12	Return Spring	1R10-4001	32	Timer Control Knob	1A10-1034
13	Sealing Silicon Rubber	1G20-3002*	33	Strain Relief Bushing	1A10-4001
14	PTFE Roll Cloth	1J50-3445*	34	Transformer Cover	1C10-4021
15	Working Board	1C10-3011*	35	Flangefor Press Jaw	1A10-3005
16	PTFE Cloth Fixed Plate	1C10-3016*	36	Transformer	1E20-4204*
17	PTFE Strip	1J50-4422*	37	Pedal Base	2Bb30-4001
18	Working Adjust Bracket	1C10-4002	38	End Cover	1A10-3010
19	Heater Terminal Assembly	2A10-3005	39	Cover Bracket	1C10-4005
20	Bar For PTFE Cloth	1D10-3005*	40	Rubber Sheet	1G10-3005

\*The Model & Sizes Of Parts Will Be Selected

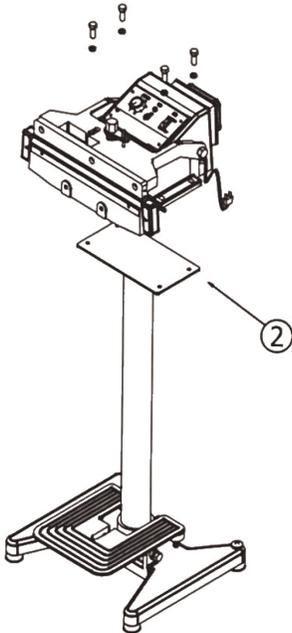
## 3. ELECTRICAL CONNECTION DIAGRAM



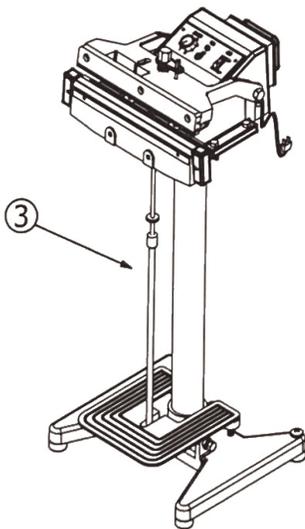
## 4. ASSEMBLING FOOT SEALER



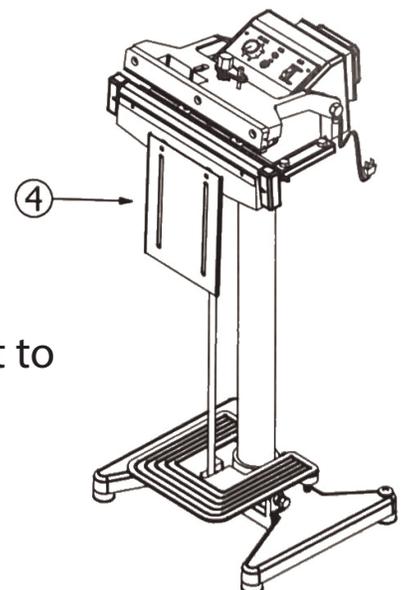
1. Insert standing tube into pedal base and fixed the short screw.



2. Use four long screws, connect enclosure body to standing tube



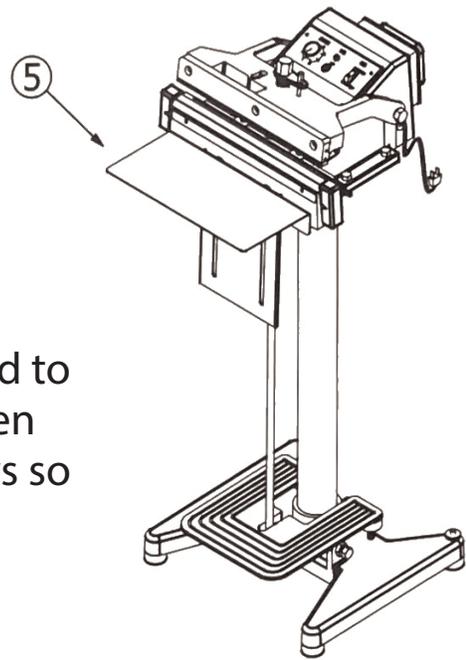
3. Attach puller tension rod to puller localized under lower sealing body and then attach to foot pedal.



4. Connect fixed adjust bracket to lower sealing body.

5. Attach working board over  
adjust bracket with two screws

Note: When attaching working board to bracket, leave enough space between lower sealing body and tap of screws so that working board can be attached easily.



## 5. OPERATING INSTRUCTIONS

After the machine is fully assembled and plugged into an AC outlet, do the following:

1. Adjust the foot pedal rod set (#23) to obtain firm contact of the jaw
2. Turn on main switch (#05) to the ON position, the yellow light will appear.
3. Adjust the sealing timer knob (#32) to suitable scale for bag thickness and material to between 1-8 (the smaller as possible).
4. Insert poly bag between jaws then press the foot pedal down. Sealing LED lamp (#03) will go on, it is the sealing time. Step on the pedal about one second after lamp is off automatically while you press the pedal, it is the congealing time.
5. If sealing does not complete, turn sealing timer knob up a little and go through step #4 again. Keep increasing the number until you get the desired seal. Then you can remove the sealed bag and begin the process again.
6. **FOR SAFETY: KEEP HANDS AND FINGERS FORM BETWEEN THE JAWS WHEN SEALING.**

## 6. HELPFUL INFORMATION

1. Always keep the sealing platform clean. Particular care should be taken to remove any residue from the PTFE cloth.
2. Do not clean the sealing platform with anything wet.
3. Make sure to change the bottom PTFE strip (blew 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 affect the quality of your seal

USE ONLY GENUINE REPLACEMENT PARTS

## 7. 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 the risk of electric shock, connect to a properly grounded outlet only.
3. Close supervision is required when the product is used near children.

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 suitable ampere fuse, provided in legible adjacent to the fuse holder.

## 8.

## CHANGING PARTS

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

REMOVE PLUG FROM ELECTRIC OUTLET USE ONLY GENUINE REPLACEMENT PARTS

### 1. To replace PTFE cloth.

- A. Remove lower PTFE fixed plate and loosen PTFE press clip.
- B. Pull out PTFE cloth just enough to cut of burned area then changing a new PTFE cloth and re-fix the PTFE fixed plate.
- C. Rotate PTFE bar to pull PTFE roll cloth tight. Retighten the PTFE press clips.

### 2. Replacing heating element wire.

- A. Loosen PTFE press clips. Remove the lower 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. Replace PTFE cloth and PTFE fixed plate. Tighten PTFE roll cloth with PTFE bar. Tighten PTFE press clip.

Note: Make sure to change the bottom PTFE strip (blew the element wire) when they become worn. If this is not done the element wire may short out and become damaged.

