

# VACUUM SEALERS with NOZZLE

355VA, 3510VA, 455VA, 4510VA, 605VA, 6010VA

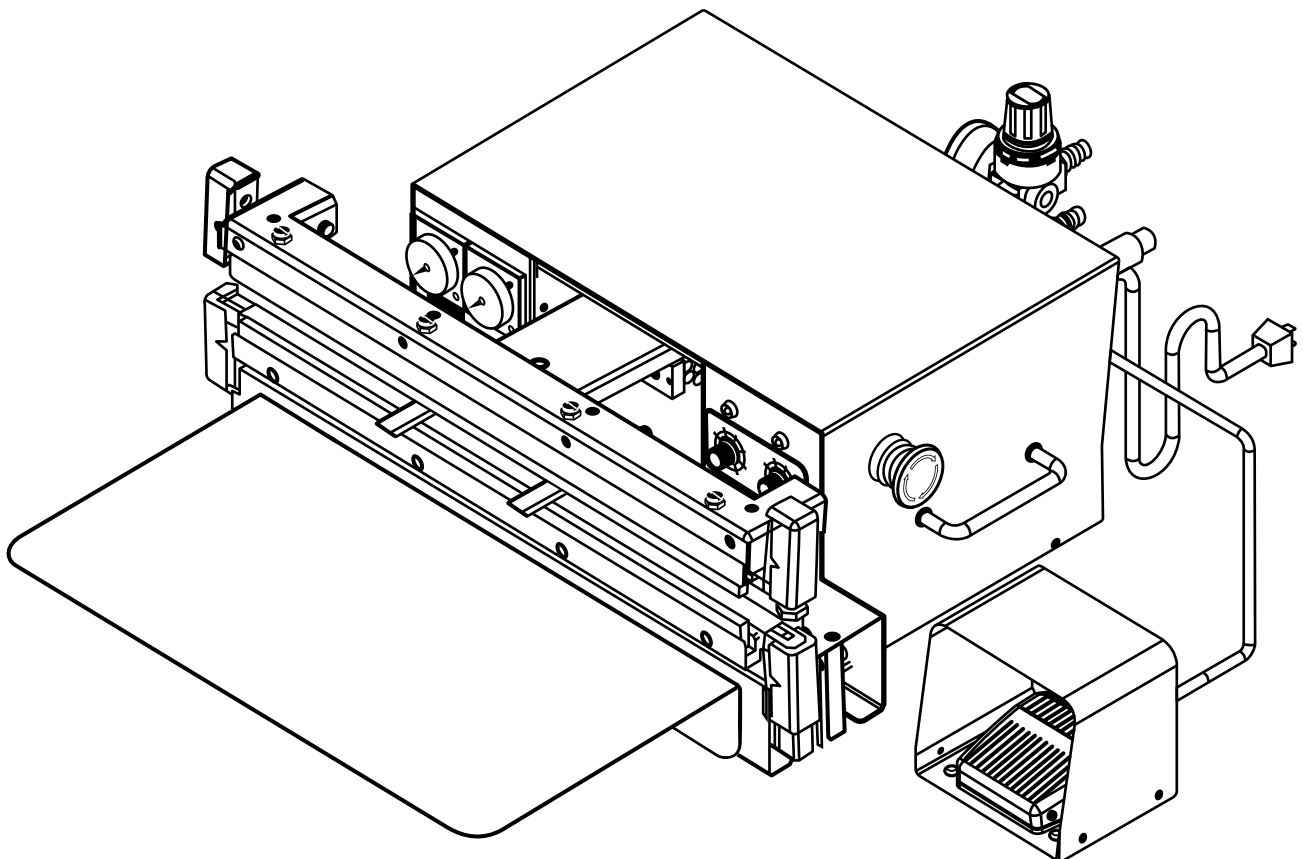
355VAD, 3510VAD, 455VAD, 4510VAD, 605VAD, 6010VAD

255VG, 3510VG, 455VG, 4510VG, 605VG, 6010VG

355VGD, 3510VGD, 455VGD, 4510VGD, 605VGD, 6010VGD

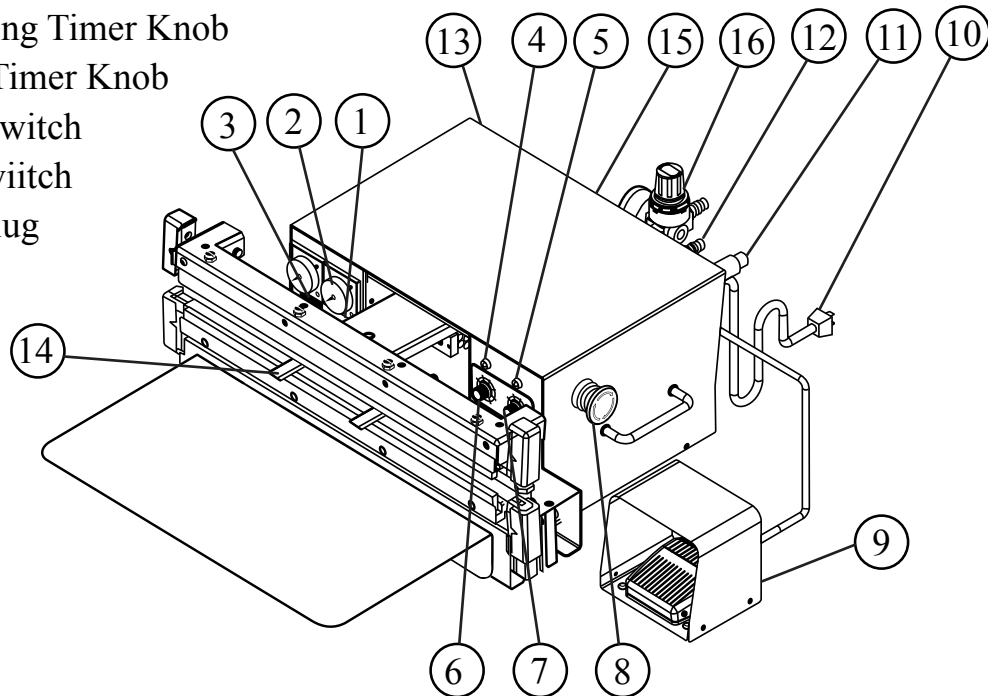
## INSTRUCTION

CE



# 1 INSTRUCTION BOOKLET

1. Function Select SW.
2. Gas & Vacuum Timer
3. Power Main SW.
4. Congealing Indication Lamp
5. Sealing Indication Lamp
6. Congealing Timer Knob
7. Sealing Timer Knob
8. Urgent Switch
9. Pedal Switch
10. Power Plug
11. Silencer
12. Air Inlet
13. Pressure Regulation & Gauge
14. VAC Nozzles
15. VAC Filter
16. Gas Inlet Regulation Set
17. VG Series use only



# 2 SET UP INSTRUCTION

1. After unpacking your sealer. Place the unit on a level and stable surface.  
WHEN YOU OPENED YOUR CARTON YOU SHOULD HAVE FOUND THE FOLLOWING.  
Vacuum Sealer, Operation Manual, Operating Board, Pdal Switch, Silencer, Gas Inlet Regulation (VG series use only).  
\*Spare Parts Kit. : Heating Wire \*2, Rubber Pad \*2, Fuse, 5/32 Allen Wrench.
2. Connect power plug to AC outlet and connect the pedal switch to FOOT SWITCH outlet.
3. Connect a clean filtered air supply to the AIR INLET and put the Silencer into EXHAUST.  
Note: Air consumption needed 7.8 SCFM (220L/min) and 85 PSI (6.0 Kg/cm2).
4. If VG/GSD series add to attach a gas regulator set and flushing supply into GAS INLET.
5. Attach the working table to the sealer.
6. Turn on the main switch to ON position. A yellow indicator light will turn on.
7. You are now ready to begin sealing



## 3 OPERATING INSTRUCTIONS

1. Once all your connections (air and electrical) are made, you are ready to begin.
2. Turn on main switch. Yellow light appears, indicating power to the unit.
3. Program pressure settings
  - \* Set 25 PSI (1.8 Kg/ cm<sup>2</sup>) for low pressure gauge.
  - \* Set at 78 PSI (5.5 Kg/ cm<sup>2</sup>) for high pressure gauge.
4. Select the GAS & VAC. switch according to your packing needed. Then follows to set the Vacuum timer and Gas timer, you should be to increase time turn knob clockwise or to decrease it turn knob counterclockwise. (Gas timer made VG/VGD series use only.)
  - \* GAS position will flow from vacuum (Timer1) to gas (Timer2)
  - \* VAC. position will flow from gas (Timer1) to vacuum (Timer2)
5. Note: If it is VA/VAD series, when select the SEAL & VAC. switch been settled to SEAL position, then the nozzles will retract the jaws automatically.
6. Follow above the same operation to set sealing program. Adjust the sealing and congealing knob according to bag thickness and material.
7. With bag open, position the bag onto seal bar with nozzles as far as it will extend
8. To operate unit, step on pedal switch, the sealing jaws will close. The act of Vac./Gas will begin and then be followed by sealing and cooling. The jaws will open automatically when cycle is completed and you can
9. remove the sealed package and begin the cycle anew.
10. Caution: the vacuum and gas timer MODE must kept in 'A' type.

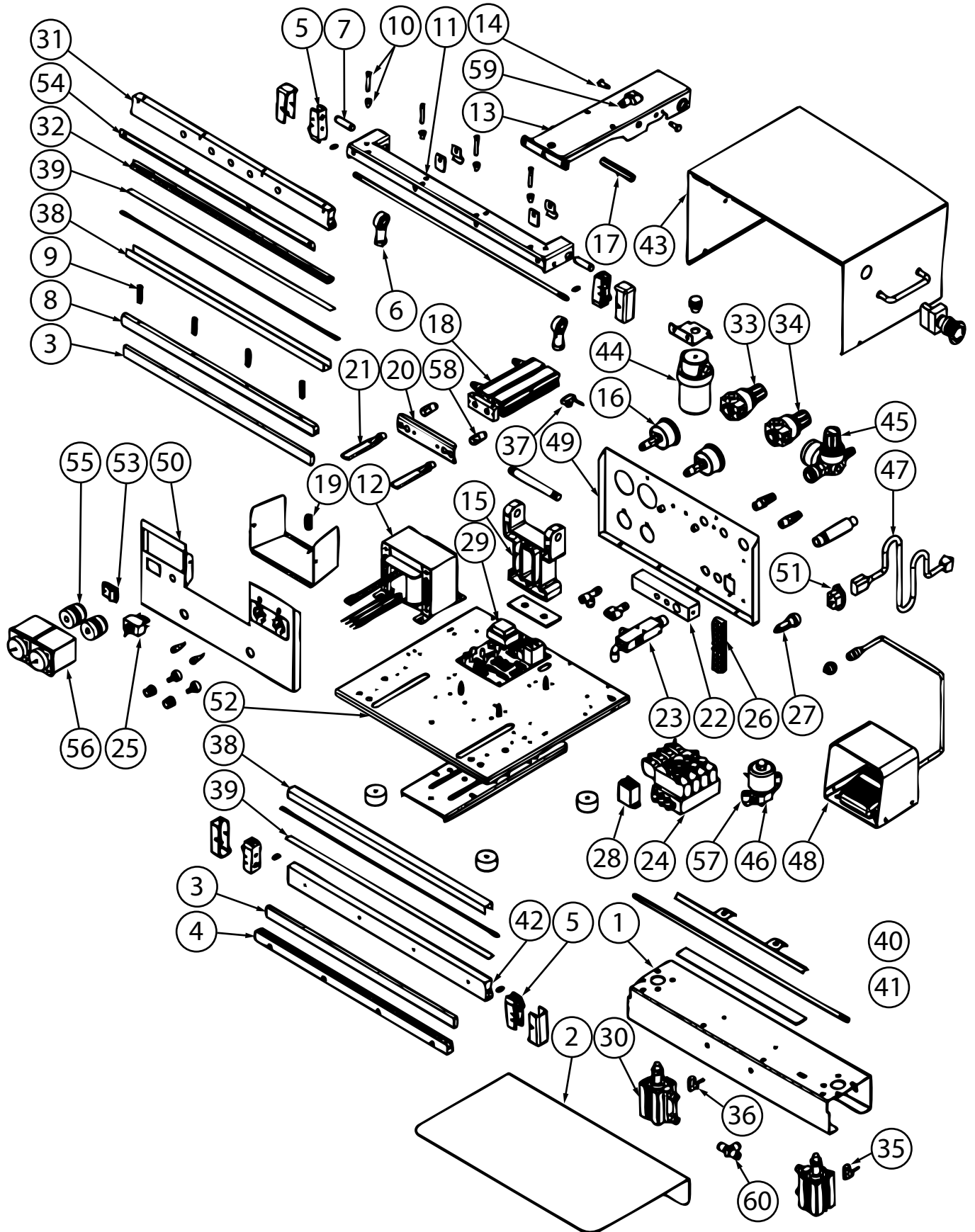
## 4 SPARE PARTS

ACCESSORIES	Q'TY
Heating wire	2
VAC. Rubber Pad	2
Fuse	10Ax1 or 20Ax1

Spare Parts Kit: Working Table, Silencer, Pedal Switch, 5/32 Allen Wrench, Gas Regulator Set. (VG and VGD type use only.)



# 5 CONSTRUCTION DIAGRAM



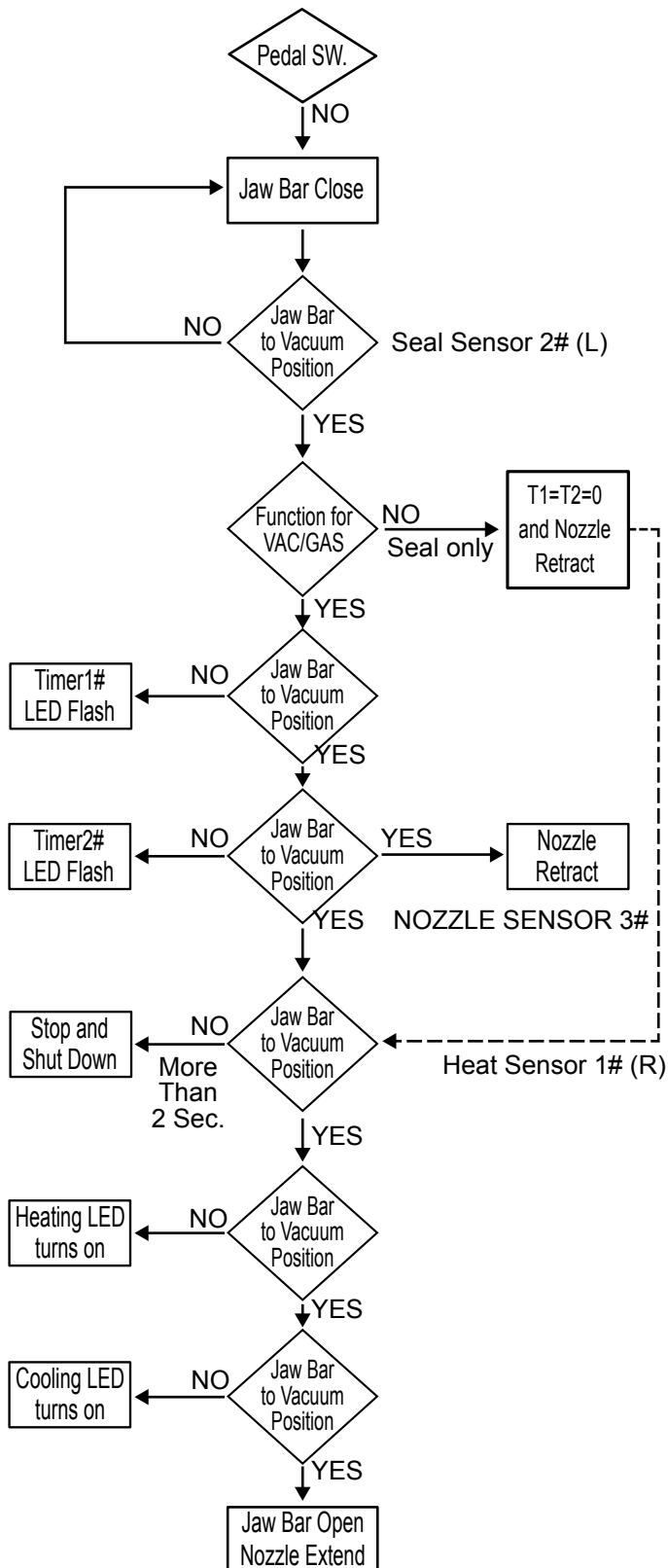
No	DESCRIPTION	Part No.	No	DESCRIPTION	Part No.
1	Jaw Bar Base	2C10-9007*	31	Upper Jaw	1B40-9001*
2	Operating Board	1C10-4046*	32	Silicon Pad	1G20-3002*
3	Rubble Pad for VAC.	1G10-9001	33	Low Pressure Regulator	1P50-9003
4	PTFE Cloth Fixed Bar	1B40-9004*	34	High Pressure Regulator	1P50-9004
5	Heater Element Attachment	2A10-3000	35	Heat Sensor No 1# (R)	1P10-9010
6	Connect Poles	1D10-9002	36	Seal Sensor No 2# (L)	1P10-9010
7	Bolt Pin for Upper Jaw	1D10-9001	37	Nozzle Sensor No 3#	1P10-9010
8	Upper Rubble Holder	1B40-9003*	38	PTFE Roll Cloth	1J50-3445*
9	Springs for Rubble Holder	1R10-2003	39	PTFE Coated Strip	1J50-4422*
10	Bolt & Flange Sets	1D10-1004	40	Clip for PTFE Cloth	1C10-3013*
11	Press Playe for Jaw	2C10-9004*	41	Bar for PTFE Cloth	1D10-3005*
12	Heater Transformer	1E20-4507*	42	Lower Jaw	1B40-9002*
13	Fixed Plate for Nozzle Pneumatic	1C10-9023	43	Enclosure Cover	1C10-9003
14	Screws for Nozzle Pneumatic	1D10-3017	44	VAC. Filter	1P50-9008
15	Hinge Bracket	1B10-3007	45	Gas Regulator Set	1P50-9005
16	Pressure Gauges	1P50-9001	46	Gas Valve	1P20-9002*
17	Bolt for Nozzle Pneumatic	1D10-9003	47	Power Plug	1E30-1032*
18	Nozzle Pneumatic	1P10-9001	48	Pedal Switch Set	1E10-3003
19	Spring for Nozzel	1R10-1001	49	Back Plate	1C10-9002
20	Nozzle Fixed Plate	1C40-9001	50	Front Plate	1C10-9031
21	Nozzles	1D40-9001	51	AC Socket (EMI Filter)	2E90-2013
22	Air Exhaust Bracket	1P50-9007	52	Bottom Plate	1C10-9011
23	Single Stage Pump & Silencer	1P50-9015	53	Main Switch	1E10-3000
24	Valve Set of Four	1P20-9012*	54	Upper PTFE Fixed Plate	1C10-9018*
25	Toggle Switch	1E10-9010	55	Timer Sockets	1E90-9001
26	Terminal Block	1E60-9001	56	Timers	1E10-9004
27	Fuse Holder	1E70-2001	57	1/8 L Elbow Thread	1P30-9009
28	AC Relay	1F10-9002*	58	1/8 Straight Thread	1P30-9005
29	Controller PCB	2F80-9001*	59	Y Shaped Union	1P30-9018
30	Jaw Pneumatics	1P10-9002	60	T Shaped Union	1P30-9001

\*Model type/sizes will be selected.

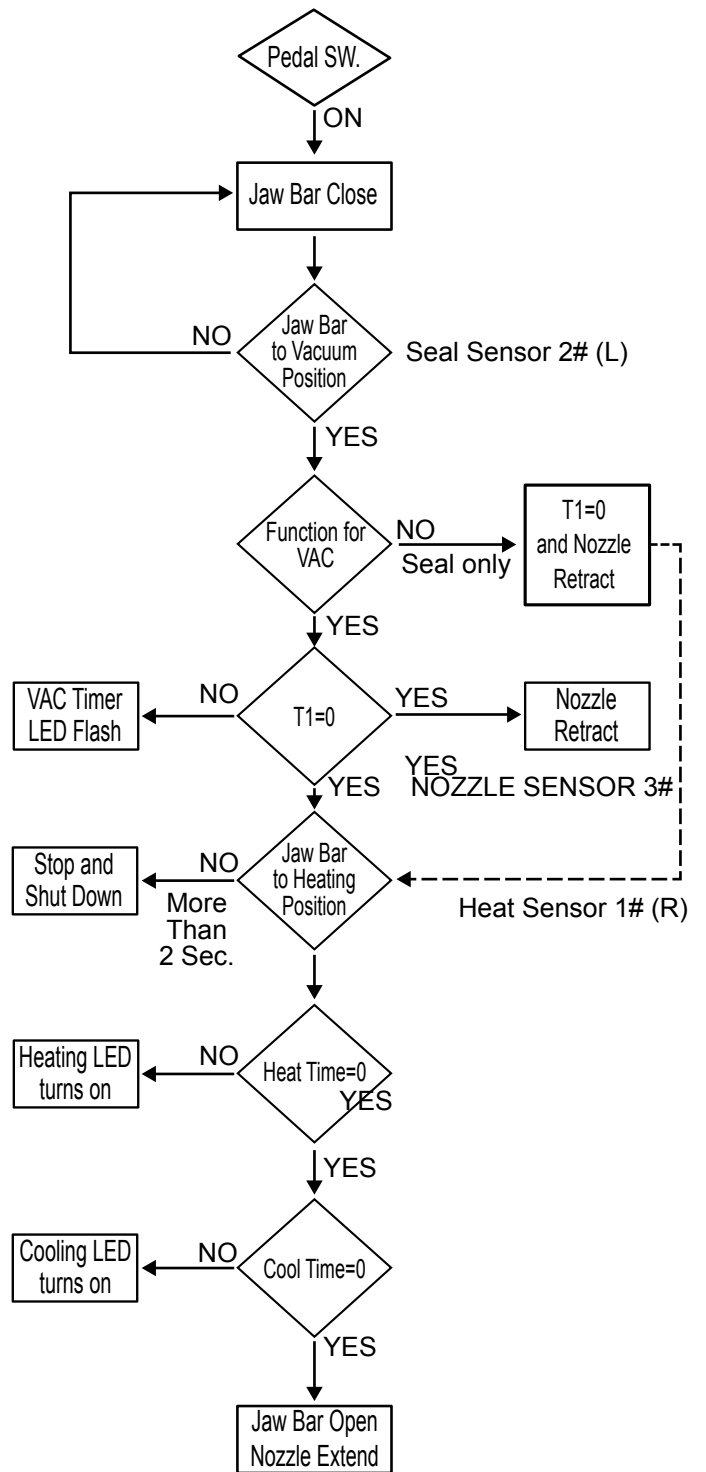


# 7 FLOW DIAGRAM

## VG/VGD FLOW

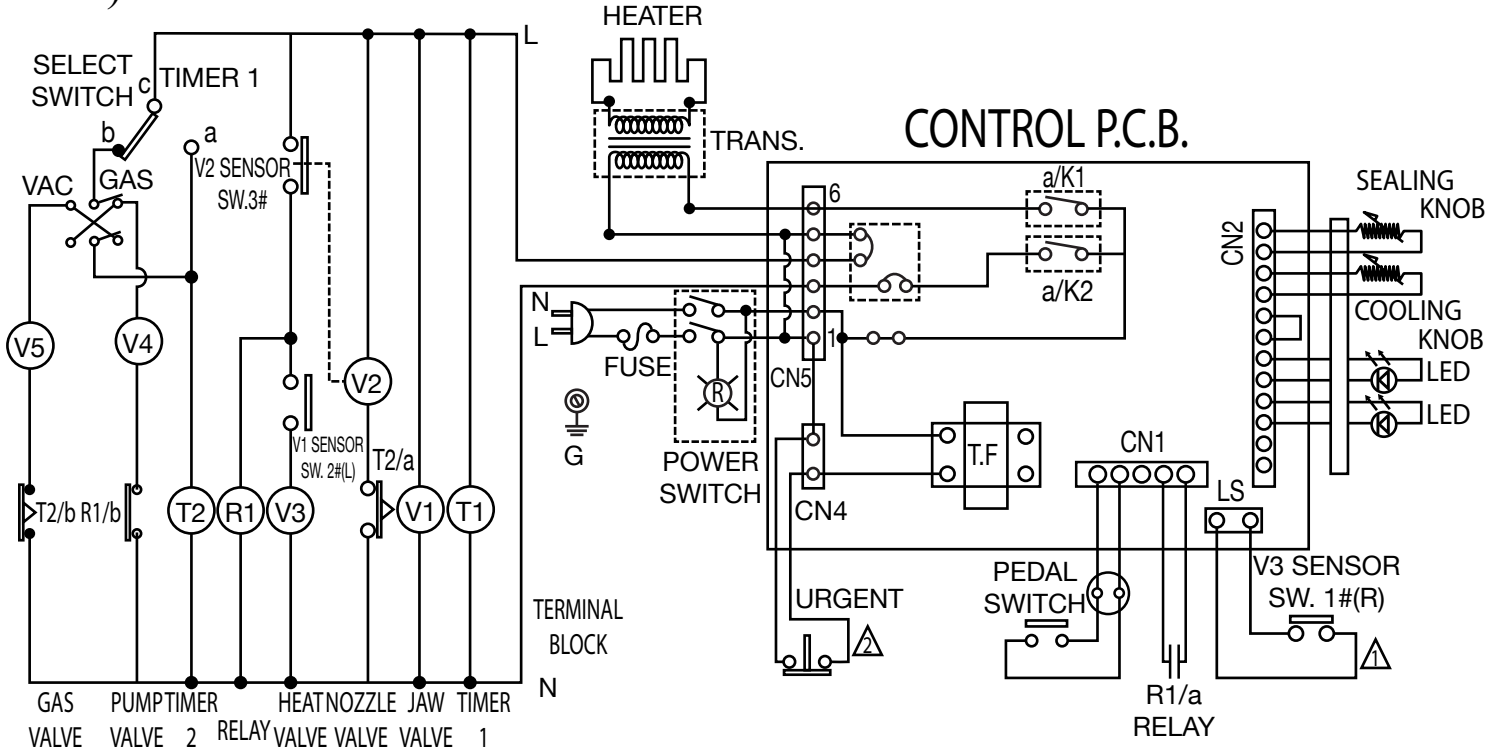


## VAVAD FLOW

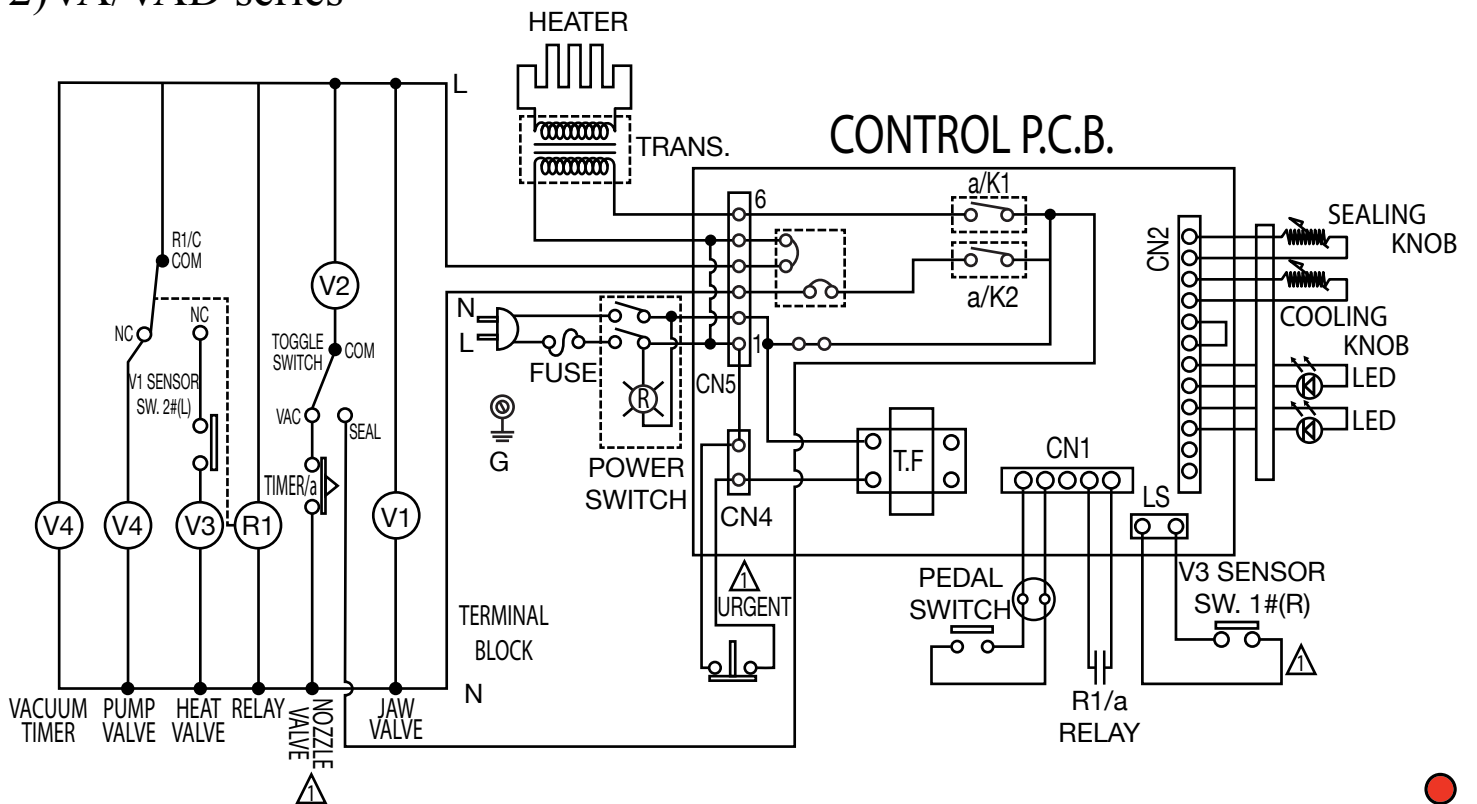


# 8 ELECTRIC CONNECTION DIAGRAM

## 1) VG/VGD series



## 2) VA/VAD series



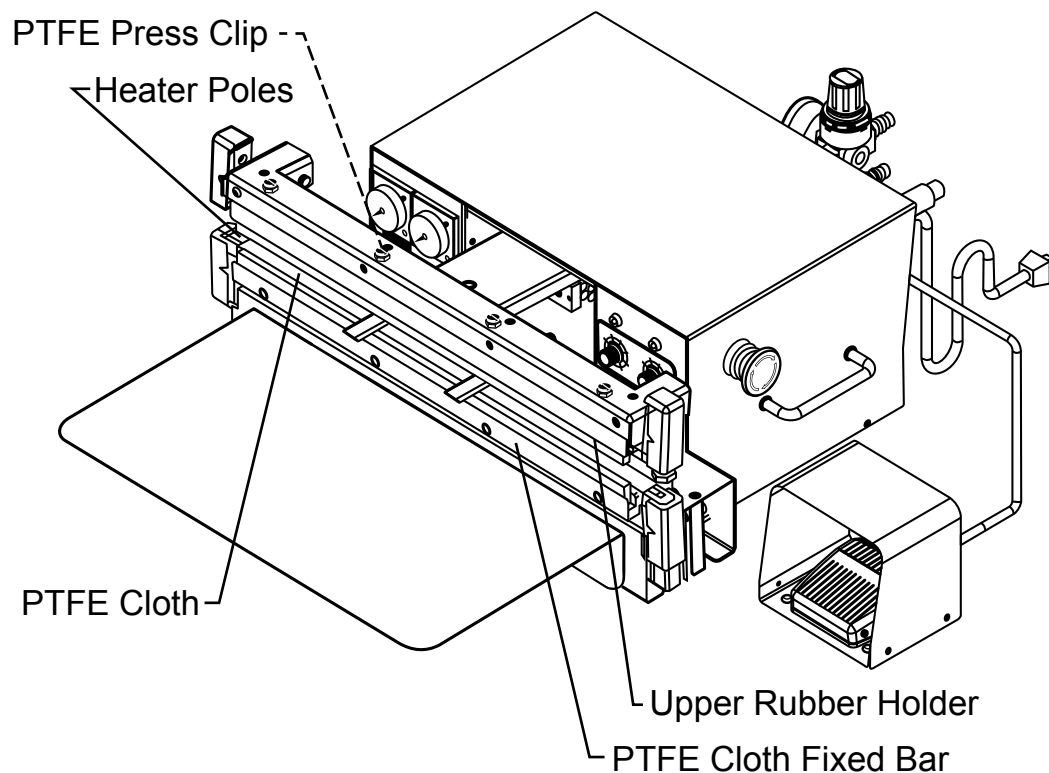


To replace burnt out PTFE cloth or broken element wire, please follow these instructions:

REMOVE PLUG FROM ELECTRIC OUTLET

USE ONLY GENUINE REPLACEMENT PARTS

1. To replace PTFE cloth.
  - A. Remove PTFE cloth fixed bar and loosen PTFE press clips.  
 VAD/VGD model series for replace upper PTFE cloth, added to remove the upper rubble holder.
  - B. Pull out PTFE cloth just enough to cut off burned area, then changing a new PTFE cloth and re-fix the PTFE fixed bar.
  - C. Rotate PTFE cloth bar to pull PTFE roll tight. Re-tighten the PTFE press clips.
2. Replacing heating element wire.
  - A. Loosen PTFE press clips. Remove the PTFE cloth fixed bar.  
 \* VAD/VGD model series for replace upper heating element wire, added to remove the upper rubble holder.
  - 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 cloth rolled with PTFE cloth bar. Tighten PTFE press clips.  
 \*VAD/VGD model series added to re-fix the upper rubble holder.





## 10 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.
4. Close supervision is required when the product is used near children.

### WARNING:

5. A live heating element is located in the jaws under the PTFE cloth. Use caution during operation. **DO NOT TOUCH THE ELEMENT.**
6. For continued protection against fire or electric shock, Replace only with tape cartridge and suitable ampere fuse, provided in legible adjacent to fuse holder.
7. Keep hands, fingers and flammable object out of seal Jaws area. If a foreign object is caught between the jaws, turn main power switch to off immediately to prevent possible burns.

## 11 SEALING SCALE FOR TIMER AND MATERIAL

Scale	Heat Time	Cool Time	PE Bag for VA, VG	PE Bag for VAD, VGD
1 (80°C)	0.3 sec	1.0 sec	2x 0.03mm	
2 (100°C)	0.6 sec	2.0 sec	2x 0.05mm	2x 0.10mm
3 (125°C)	0.9 sec	3.0 sec	2x 0.08mm	2x 0.16mm
4 (150°C)	1.2 sec	4.0 sec	2x 0.11mm	2x 0.22mm
5 (175°C)	1.5 sec	5.0 sec	2x 0.14mm	2x 0.26mm
6 (200°C)	1.8 sec	6.0 sec	2x 0.17mm	2x 0.30mm
7 (225°C)	2.0 sec	7.0 sec	2x 0.20mm	2x 0.36mm
8 (250° C)	2.2 sec	8.0 sec		2x 0.40mm

\* Adjust the heat timer for suitable scale to material of plastic bag.

\* Useful recommended cool time is twice the length of the heat time.



# 12 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 (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 effect on the quality of your seal.
6. Always keep the VAC. filter dry or don't use anything wet to clean.
7. USE ONLY GENUINE REPLACEMENT PARTS.

# 13 TROUBLESHOOTING

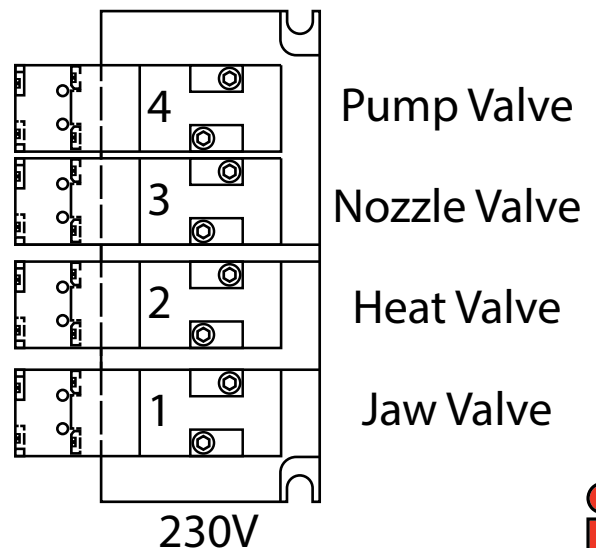
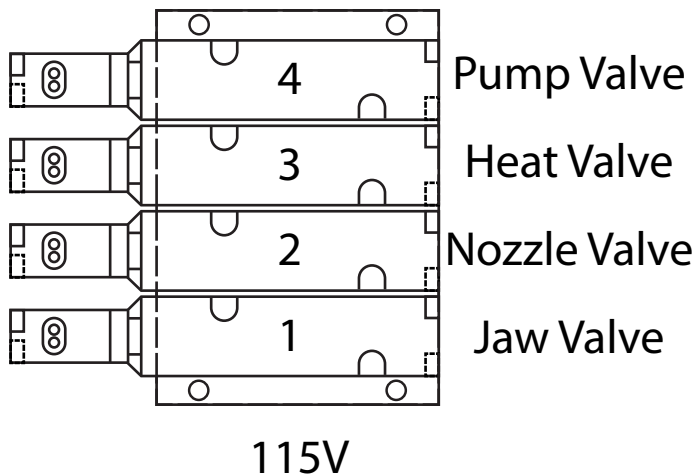
ISSUE	REASON	RECOMMENDATIONS
Power light off	Sealer fuse is burned out.	1. Replace fuse. 2. If machine is operating but power switch light is out, replace power switch.
Jaws do not close	1. LED of controller PCB isn't lit, the PCB fuse or transformer is burned out. 2. Pedal switch is damaged.	1. Replace 0.3A / 250V fuse or transformer for PCB. Replace new controller PCB if necessary 2. Replace pedal switch
Poor vacuum or weak seal. (Heating / cooling LED appears nozzle does not retract)	Heat sensor 1# (R) erroneous action. It isn't in correct position. (Red light appears).	Adjust the sensor to lower position for leave sensitive area.
Vacuum exhaust doesn't stop. Gas flush doesn't stop. (VG/VGD series only)	1. Timer damaged. 2. As nozzle valve of valve set damaged, prevent the nozzle from retracting. 3. Relay / nozzle sensor 3# damaged.	1. Replace timer. 2. Replace nozzle valve for valve set.* 3. Replace new relay/sensor
Poor vacuum or weak seal (Nozzle retracted)	1. Jaw sensor 2# (L) incorrect action. Isn't in proper position. (Red light is not illuminated) 2. Weak seal for heat valve of valve set is damaged preventing jaws from pressing to create seal.	1. Adjust the position for sensitive area or change new one. 2. Check high pressure gauge at 75-80 PSI and replace new heat valve for valve set.*



# 12 TROUBLESHOOTING (continued)

Machine shuts down	<ol style="list-style-type: none"> <li>1. Heat sensor 1# (R) erroneous action. It isn't in proper position. (Red light is off)</li> <li>2. The machine jaw will fail to close completely if a foreign object.</li> <li>3. The jaw valve of valve set damaged.</li> </ol>	<ol style="list-style-type: none"> <li>1. Adjust the sensor to upper position for sensitive area or change new one.</li> <li>2. Clean the sealing platform. To reactivate the machine, by turning off the power switch wait 3 sec and turn switch back on</li> <li>3. Replace new jaw valve for valve set.*</li> </ol>
Nozzle does not extend or retract too slow/fast	<ol style="list-style-type: none"> <li>1. Incoming air pressure is low.</li> <li>2. Adjust nozzle extent flow control</li> </ol>	<ol style="list-style-type: none"> <li>1. Check high pressure gauge at 75-80 PSI.</li> <li>2. The flow control is fixed on nozzle pneumatic.</li> </ol>
No VAC. pump	<ol style="list-style-type: none"> <li>1. The pump valve of valve set damaged</li> </ol>	<ol style="list-style-type: none"> <li>1. Replace new pump valve for valve set.*</li> </ol>
No gas flush (VG.VGD series only)	<ol style="list-style-type: none"> <li>1. The gas valve is damaged.</li> </ol>	<ol style="list-style-type: none"> <li>1. Replace with new gas valve.</li> </ol>
Not cooling	<ol style="list-style-type: none"> <li>1. Congealing is not strong enough</li> </ol>	<ol style="list-style-type: none"> <li>1. Increase cooling time.</li> </ol>
Not heating	<ol style="list-style-type: none"> <li>1. Heat wires are not heating.</li> <li>2. Transformer is burned out.</li> </ol>	<ol style="list-style-type: none"> <li>1. Replace heating wire.</li> <li>2. Replace transformer.</li> </ol>

\* Valves position diagram for valve set



# 14 SPECIFICATIONS

MODEL	355VG/ 351VG	355VGD/ 3510VGD	455VG/ 4510VG	455VGD/ 4510VGD	605VG/ 6010VG	605VGD/ 6010VGD
Max. Seal Length	350mm (14")	350mm (14")	450mm (18")	450mm (18")	600mm (24")	600mm (24")
Seal Width	5mm/ 10mm	5mm/ 10mm	5mm/ 10mm	5mm/ 10mm	5mm/ 10mm	5mm/ 10mm
Vacuum Level	635mmHg (25")	635mmHg (25")	635mmHg (25")	635mmHg (25")	635mmHg (25")	635mmHg (25")
VAC Timer (Option)	0-30S	0-30S	0-30S	0-30S	0-30S	0-30S
GAS Timer (Option)	0-30S	0-30S	0-30S	0-30S	0-30S	0-30S
Heat Timer	0.3-2.2S	0.3-2.2S	0.3-2.2S	0.3-2.2S	0.3-2.2S	0.3-2.2S
Congealing Timer	0.5-8.0S	0.5-8.0S	0.5-8.0S	0.5-8.0S	0.5-8.0S	0.5-8.0S
Max. Seal Thickness	2x0.2mm	2x0.4mm	2x0.2mm	2x0.4mm	2x0.2mm	2x0.4mm
Watts	900W/ 1200W	1100W/ 1800W	1100W/ 1800W	1500W/ 2400W	1400W/ 2200W	1900W/ 2800W
Weight	20Kg/ 22Kg	23Kg/ 25Kg	23Kg/ 24g	26Kg/ 28Kg	25Kg/ 27Kg	29Kg/ 31Kg
Dimension(W*D*H)	41*38*20cm	41*38*20cm	51*38*20cm	51*38*20cm	66*38*20cm	66*38*20cm

VG and VA specification are same ; VGD and VAD specification are same.

