

# FS-SERIES FOOT SEALERS

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Model: FS-358F, FS-458F, FS-658F

**Distributed By:**

Version 1.0

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# General Information

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Thank you for purchasing our FS-Series Long Foot Sealers.

This owner's manual contains information relating to your sealer. The manual will provide you with basic information concerning both operation and maintenance of your new machine. Please read it carefully as failure to do so may result in bodily injury and/or damage to the equipment.

Please fill in the information below. You will find the information on the machine identification plate. You will need this information when ordering replacement parts or making technical inquiries.

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## EQUIPMENT INFORMATION

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❖ Model #

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❖ Serial #

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❖ Purchase Date:

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❖ Reference # (found on packing slip)

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❖ Owner:

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# Safety Instructions

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**WARNING!** Below are general safety precautions and warnings that should be understood prior to setting up or operating your equipment. Read and fully understand all instructions and warnings prior to using this unit. Your safety is most important! Failure to comply with procedures may result in serious injury or property damage. Remember: **Your personal safety is your responsibility.**

Unsafe practices or unauthorized modifications could result in accidents or property damage. Failure to follow these safety rules and take necessary precautions can result in serious injury as well as damage to equipment.

- ❖ Never operate or service your sealer until you have read this manual completely and understand it fully.
- ❖ Plug the sealer into a standard 120 Volt, 60Hz wall outlet or surge protector. If you have a 220 Volt unit, please make sure your warehouse has the appropriate electrical requirements.
- ❖ Do not use the sealer if the power cord, plug or any other parts are damaged. Be sure not to allow the power cord to drape into your work area. Check that all parts are operating properly and perform the intended functions. Check for any worn parts before starting operation. Check for all other conditions that may affect the operation.
- ❖ Reduce risk of unintentional starting. Make sure the power switch is in the "OFF" position before connecting to the power source.
- ❖ Always disconnect sealer from power source before servicing, changing accessories or cleaning the unit.
- ❖ To provide protection against the risk of electrical shock, the power connection must be properly grounded at all times.
- ❖ Do not leave the sealer unattended when in use. Disconnect the sealer from the power source before leaving the work area.
- ❖ Sealer is used solely for sealing thermoplastic materials. Using the machine for any other purpose can cause damage to the machine and operator.
- ❖ While operating machinery, wear close-fitting clothing and tie back long hair to prevent any external items from getting caught in the machine. Do not wear jewelry when operating the sealer.



- ❖ Never touch the heating elements with bare hand while the sealer is plugged into a power source, in operation or just finished operation. Touching heated areas may cause fire and/or severe burns.
- ❖ While machine is in operation, do not place fingers, tools, or other foreign objects on or into the machine. Do not place hands or fingers near pinch points. Do not touch machine while it is in operation. Perform all procedures carefully and watch where hands and fingers are at all times.
- ❖ The sealer is not water resistant or water proof. Spraying down the machine will damage machine or cause electrical shock. Do not submerge the sealer into water or liquid.
- ❖ Do not operate sealer in a corrosive or humid environment.
- ❖ Always keep the machine clean, lubricated and in good working condition. Follow any maintenance and lubrication procedures outlined in this manual. Make sure unit is disconnected from power source before cleaning.
- ❖ NEVER use any accessories or parts from other manufacturers. Machine should not be altered or modified using parts that are not genuine authorized parts. Doing so will VOID YOUR WARRANTY.
- ❖ *When replacing the heating elements, always replace the PTFE adhesive under the heating element. A worn PTFE adhesive can cause the heating element to break.* The PTFE adhesive works as a barrier between the body of the sealer and the element. Never allow the element to come in direct contact with the sealer body as that will damage the timer.
- ❖ Never leave the sealer unattended. Be safe, disconnect the sealer from power source before leaving work area.
- ❖ Always keep out of reach of children and pets.
- ❖ Close supervision is necessary when any appliance is near persons with reduced physical, sensory or mental capabilities or lack of experience and knowledge . This sealer is NOT to be used by children or by persons with reduced physical, sensory or mental capabilities or lack of experience and knowledge.
- ❖ DO NOT use the sealer outdoors.
- ❖ DO NOT use the sealer while under the influence of drugs, medications or alcohol.

**SAVE THESE INSTRUCTIONS - REFER TO THEM OFTEN AND USE THEM TO INSTRUCT OTHERS.**

# Introduction

FS-Series foot sealers are foot sealers ideal for high volume poly bag and other thermoplastic sealing. The sealer allows you to keep both hands free for quicker and more accurate sealing. Our FS-Series foot sealers can seal polyethylene, polypropylene, saran, nylon, static shielding bags, Mylar up to 16mil in total thickness.

## Features of the FS-Series Foot Sealers

*Your foot sealer is equipped with a wide range of standard features and capabilities.*

- ❖ Impulse sealing - no warm up time needed
- ❖ Plug-in electronic timer for variable control
- ❖ All metal construction
- ❖ Heavy duty
- ❖ Sits on rectangular stand for stability
- ❖ Adjustable work table height
- ❖ Manufacturer spare parts kit includes: 2 heating elements

## How Do FS-Series Foot Sealers Work?

### Basic

#### Principles

Place material on lower jaw and activate footboard

Our FS-Series foot impulse sealers fire a short burst of electricity through a specially designed heating wire to weld thermoplastic materials together. The length of the seal time will depend on the sealing characteristics of the bag being sealed. The sealing process is simple: The operator places the bag between the

sealing jaws and presses the footboard to activate the unit. The operator retrieves the sealed bag and repeats the process. Bags are sealed repeatedly and uniformly.

## Specifications

	FS-358F	FS-458F	FS-658F
Power	110V/60Hz	110V/60Hz	110V/60Hz
Watts	600W	800W	1000W
Seal Width	8mm	8mm	8mm
Sealing Length	13.7" / 350mm	17.7" / 450mm	25.5" / 650mm
Standing Height (at sealing jaw)	31"	31"	31"
Throat Depth	2 1/2"	2 1/2"	2 1/2"
Dimensions	20" x 16" x 33 1/2"	20" x 20" x 33 1/2"	20" x 28" x 33 1/2"
Shipping Dimensions	32" x 23" x 11"	32" x 23" x 11"	32" x 23" x 11"
Gross Weight	63-lbs	65-lbs	68-lbs

# Electrical Circuit Diagram

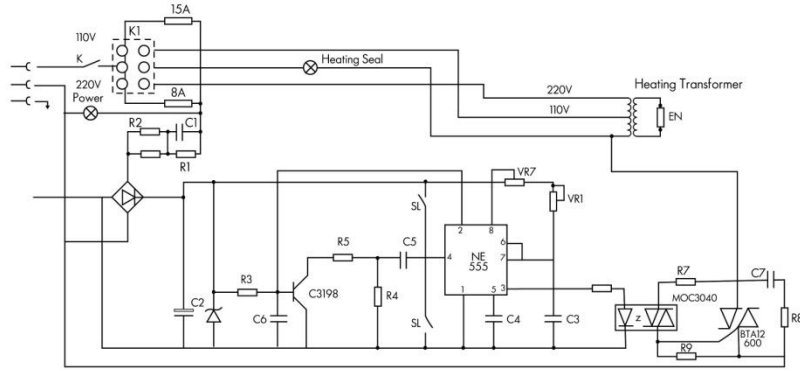


Figure 1. Electrical Circuit Diagram

## Getting to Know your Foot Sealer

FS-Series Foot Sealers are simple and efficient sealing machines.

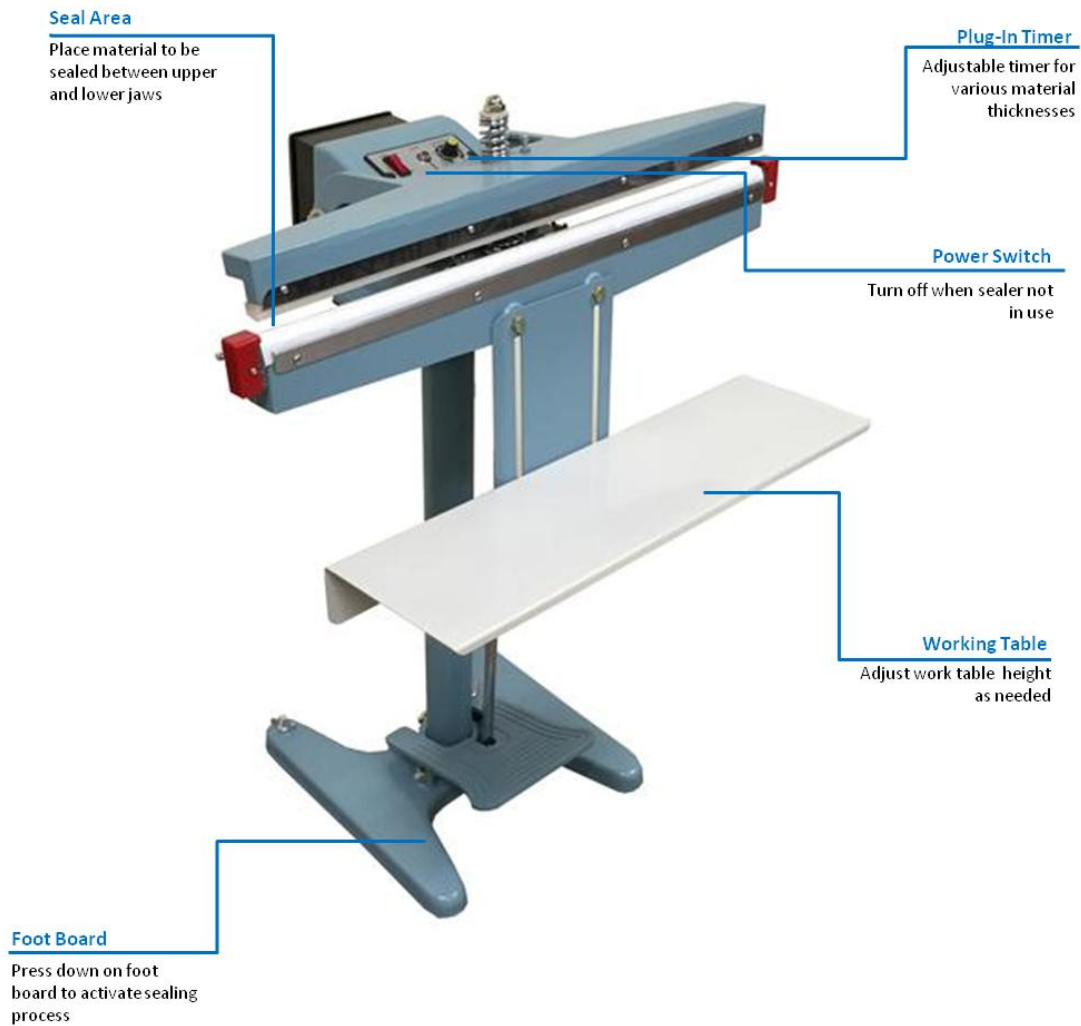


Figure 2. FS-Series Foot Sealer Overview



# Operating your Sealer

## Assembly Instructions

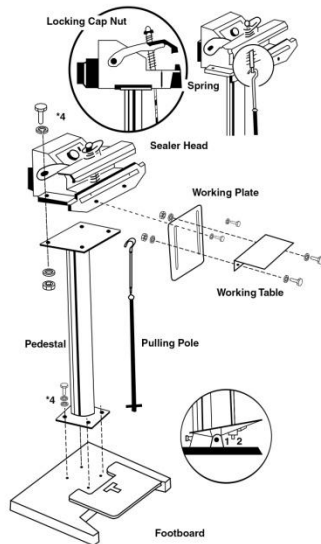


Figure 3.

1. Position the standing tube (Figure 12, Item #F2) on the footboard base (Figure 12, Item #L5). Tighten the base screw (Figure 12, Item #16) to lock the tube in place.
2. Attach the foot pedal (Figure 12, Item #L6) to the base (Figure 12, Item #L5). Tighten the screws on base to secure the foot pedal.
3. Position the sealer head (Figure 12, Item #L1) on the standing tube. Secure the sealer head to the standing tube with screws (Figure 12, Item #10) on both sides of the sealer head.
4. Insert the pulling plate/short pulling pole (Figure 12, Item #F8+F9) through the small spring (Figure 12, Item #S10) and set it on top of the upper jaw (Figure 12, Item #L2). Place the large spring (Figure 12, Item #C8) on the lower jaw.

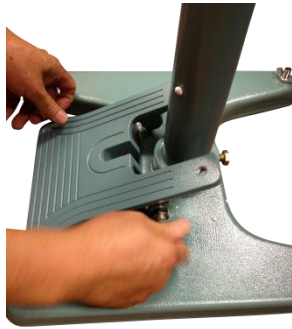


Figure 4. Tighten the screws on base to secure foot pedal



Figure 5. Insert the short pulling pole through the small spring.

5. Connect the upper part of the pulling pole (Figure 12, Item #F4) to the pulling plate/short pulling pole (Figure 12, Item #F8+F9). Gently push the upper jaw to meet the lower jaw. Insert the cross bar at the end of the lower pulling pole (Figure 12, Item #F3) into the notches on the foot pedal. Please note: The length of the pulling pole can be adjusted with nut. To lengthen, turn clockwise and to shorten, turn counterclockwise. Check the correct length of the pulling pole by pressing down on the pedal. The upper and lower jaws should touch when the foot pedal is pressed down. If not, please adjust the length.



Figure 6. Attach pulling pole to the foot pedal.

6. Sealer is now ready to operate.
7. To install the optional working plate and table, remove the screws from bottom sealing jaw and install the working plate and table.

## Operation



1. Before operating, check the heating element, PTFE cover, PTFE adhesive and the silicone rubber.
2. Insert the power cord into the correct receptacle (110V).
3. Turn the power switch on.
4. Set the timer knob to the lowest setting. Always start with a low setting and increase gradually as needed.
5. Place material to be sealed under the upper jaw and press down on the foot pedal gently, but firmly. The red light will turn off when sealing time is complete.
6. ***When red light turns off, keep pressing the foot pedal for an additional 2-3 seconds. For a high quality seal, seals must cool under pressure. We usually recommend a congeal setting of at least 2x that of the heat setting but every bag will have variations. Thicker materials will require a longer cool (congealing) time.***

## Tips for Successful Sealing

1. If the seal is broken or damaged, decrease the sealing time.
2. If the seal is not fully welded, increase the sealing time.
3. If the sealing material sticks to the sealing pad, decrease the congealing time.
4. If the width of the seal is not perfect or does not match the size of the element, increase the congealing time.
5. Always keep the sealer clean. Remove any residue found on the platform and PTFE cover. Silicone spray may be used for this purpose.



6. ***When replacing the heating elements, always replace the PTFE adhesive under the heating element. A worn PTFE adhesive can cause the heating element to break.*** The PTFE adhesive works as a barrier between the body of the sealer and the element. Never allow the element to come in direct contact with the sealer body as that will damage the timer.
7. Occasionally check the condition of the silicone rubber for wear or burns. A damaged silicone rubber will affect the quality of the seal.



8. Be sure to turn off the power or unplug the unit before replacing any parts.

# Maintenance

The following maintenance procedures should be followed to ensure the longevity of your FS-Series foot sealer.

## Inspection and Cleaning

1. Inspect your machine daily.
2. Use a clean cloth to remove any plastic residue remaining on the PTFE cloth.
3. When replacing the elements, always check the condition of the bottom PTFE tape.
4. Check the condition of the silicone rubber for wear and burns. A damaged silicone rubber will affect the quality of the seal.

## Replacement Kit Instructions

Our FS-Series foot impulse sealers will require new heating elements and PTFE from time to time. Heating elements will break through wear and tear. A good rule of thumb is to replace the PTFE adhesive every time you change your heating element. The PTFE cover prevents the plastic or other thermoplastic material you are sealing from sticking to the heating element.

Replacement kits are available from your distributor. Kits include (2) heating elements, (2) PTFE adhesives, and 1ft long roll of PTFE cover. For replacement kit part #s, refer to your model #.

	FS-358F	FS-458F	FS-658F
Replacement Kit	RK-14F-FS-358F	RK-18F-FS-458F	RK-26F-FS-658F
Heating Element	HE-14-8-FS-358F	HE-18-8-FS-458F	HE-26-8-FS-658F
PTFE Adhesive	TA-14	TA-18	TA-26
PTFE Cloth (1ft. roll)	TR-14-12	TR-18-12	TR-26-12
Silicone Rubber <i>(not included in RK)</i>	SR-FS-358F	SF-FS-458F	SR-658F

To install your replacement kit on your sealer, turn off power and unplug sealer.

### Removing Worn Parts.

1. Loosen the screws on the PTFE cover plate (Figure 12, Item #C6-1/C6-2/C6-3). Remove the heating element cover.
2. Lift up the PTFE cover to expose the heating element (Figure 12, Item #D4-1/D4-2/D4-3).



Figure 7. Loosen screws on PTFE plate.



Figure 8. Pull PTFE cover to expose heating element.

3. Remove the heating element by unscrewing the element screw (Figure 12, Item #12) (apply pressure to the heating element with your finger while unscrewing the screw to prevent the heating element from twisting).
4. Peel off the PTFE adhesive under the heating element.

### Installing New Replacement Parts.

1. Remove the backing of the liner found on the PTFE adhesive.
2. Apply it to the sealer's sealing platform. The PTFE adhesive must always extend past the sealing platform by approximately 1/4" to 1/2" on both ends. Bend down the excess on both ends. (The PTFE adhesive acts a barrier between the metal body and the heating element. Never allow the heating element to come in direct contact with the sealer's body because it will damage the timer.)
3. Place a new element on top of the PTFE adhesive by screwing the element in the heating terminal assembly block. To attach the element to the other side, lift the latch found on the heating terminal block to push the block inward and securely screw the element to the block. Check the elements to ensure it is tight and intact.



Figure 9. Screw element in place

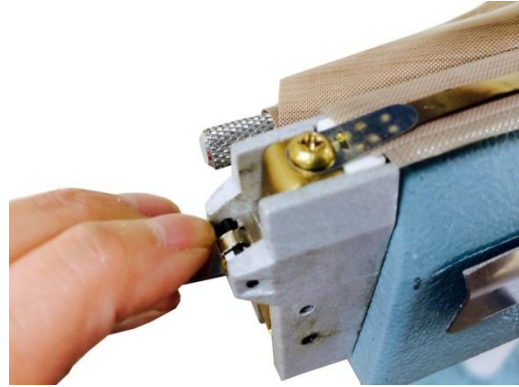


Figure 10. Lift latch on heating block to screw element in place.

4. Cut off any worn out PTFE cover. Ease out enough footage of PTFE cover to cover the heating element and extend to the front of the PTFE cover plate.
5. Tighten the screws to affix the PTFE cover plate.
6. If a whole roll of PTFE cover needs to be replaced, loosen the wing nut (Figure 12, Item #26) found on the plate for PTFE (Figure 12, Item #F11) and remove the PTFE roller (Figure 12, Item #F10-1/F10-2/F10-3). Tape one end of the PTFE cover to the rod and roll up the entire piece. Position the PTFE cover and rod using the plate for PTFE. Ease out enough footage of PTFE cover to cover the heating element and extend to the front of the PTFE cover plate.



Figure 11. Screw element in place



**FS-SERIES FOOT SEALER INSTRUCTION MANUAL**

**Figure 13. Spare Parts Diagram Overview**

Item	Part #	Description	Comments
RKs	<b>RK-Model#</b>	<b>REPLACEMENT KITS</b> Includes (2) elements, (2) PTFE adhesives, and 1ft PTFE cover	specify model # when ordering
C3	<b>FSF-C3</b>	Nut	
C4-1	<b>TA-14</b>	PTFE Adhesive 350	
C4-2	<b>TA-18</b>	PTFE Adhesive 450	
C4-3	<b>TA-26</b>	PTFE Adhesive 600,650	
C5		Front Table	
C6-1	<b>FS-358F-C6-1</b>	PTFE Holder, 350	
C6-2	<b>FS-458F-C6-2</b>	PTFE Holder 450	
C6-3	<b>FS-658F-C6-3</b>	PTFE Holder 600,650	
C7-1	<b>TR-14</b>	PTFE Cloth, 350	
C7-2	<b>TR-18</b>	PTFE Cloth 450	
C7-3	<b>TR-26</b>	PTFE Cloth 600, 650	
C8	<b>FSF-C8</b>	Spring, Large	
C9-1	<b>FS-358F-C9-1</b>	Silicone Rubber Holder 350	
C9-2	<b>FS-458F-C9-2</b>	Silicone Rubber Holder 450	
C9-3	<b>FS-658F-C9-3</b>	Silicone Rubber Holder 600, 650	
D1	<b>FSF-D1</b>	Panel, Front Panel	
D2-1	<b>TRNS-FS-358F</b>	Transformer 350	
D2-2	<b>TRNS-FS-458F</b>	Transformer 450	
D2-3	<b>TRNS-FS-658F</b>	Transformer 600, 650	
D3		Power Wire, Cord	
D4-1	<b>HE-14-8</b>	Heaing Element 350	
D4-2	<b>HE-18-8</b>	Heating Element 450	
D4-3	<b>HE-26-8</b>	Heating Element 600, 650	
D6	<b>MSW-FSF1</b>	Microswitch	
F1		Power Cord Holder, Bushing	
F2		Supporting Stand, Stand	
F3		Pulling Pole	
F4		Pulling Hook	
F7-1		PTFE Holder Base 350	
F7-2		PTFE Holder Base 450	
F7-3		PTFE Holder Base 600,650	
F8		Pulling Plate	
F9		Short Pulling Pole	
F10-1	<b>FS-358F-F10-1</b>	PTFE Roller , Shaft 350	
F10-2	<b>FS-458F-F10-2</b>	PTFE Roller, Shaft 450	
F10-3	<b>FS-658F-F10-3</b>	PTFE Roller, Shaft 600, 650	
F11		PTFE Roll Shaft Stand, PTFE Clip	
F13	<b>FSF-13</b>	Metal Plate	
L1		Machine Head, Skull	
L2-1	<b>FS-358F-L2-1</b>	Upper Arm 350	
L2-2	<b>FS-458F-L2-2</b>	Upper Arm 450	
L2-3	<b>FS-658F-L2-3</b>	Upper Arm 600, 650	
L3-1		Lower Arm 350	
L3-2		Lower Arm 450	
L3-3		Lower Arm 600, 650	



**FS-SERIES FOOT SEALER INSTRUCTION MANUAL**

**Figure 14. Spare Parts Diagram Overview**

Item	Part #	Description	Comments
L4	<b>FSF-L4</b>	Back Cover, Transformer Cover	
L5	<b>FSF-L5</b>	Machine Base, Base	
L6	<b>FB-FS</b>	Pedal	
S1		Nylon Sheath*	
S2		Nylon Cushion, O-ring	
S6		Bolt with Rubber Head on Pedal	
S7		Base Cushion, Rubber Foot	
S8		Bakelite Nut, on PTFE Plate	
S9-1		Silicone Rubber 350	
S9-2		Silicone Rubber 450	
S9-3		Silicone Rubber 600,650	
S10		Rubber Column (old gen)	
S10		Small Spring (new gen)	
1		Round Screw M5x70, Transformer*	
2		Washer, Cushion Transformer*	
3		Spring Cushion 5*	
4		Hex Nut M5*	
6		Hex Bolt M4x10	
7		Hex Bolt M10x30*	
8		Cushion 10*	
9		Spring Cushion 10*	
10		Hex Nut M10	
13		Rivet 3x10, w/30, S10*	
14		Round Crew M4x16*	
15		Butterfly Nut M10	
16		Hex Bolt M10x20, Base	
17		Elastic Column Peg 8x40*	
18		Postition Bolt M10x40	
19		Round Screw M4x8*	
20		Peg*	
21		Hex Screw M8x16*	
22		Butterfly Nut M6*	
23		Sink Screw M4x8*	
24		Elastic Column Peg 5x12*	
25		Round Screw M6x24*	
26		Butterfly Nut M4	
27		Round Screw M4x25	
28		Hex Nut M4*	
29		Hex nut M3* 	
30		Cover Nut M12w/13,510	
38		Heat Connector, Element Holder	Includes Parts#38, 42
42	<b>HTAB-FSF-B</b> <b>HTAB-FSF-C</b>	Heat Connector, Element Holder	Determine B or C Version
L3-1		* denotes not shown in diagram	

# Troubleshooting

Problem	Possible Causes	Solution
No sealing Timer lights off	<ol style="list-style-type: none"> <li>1. Disconnected power cord</li> <li>2. Power cord is broken</li> <li>3. Blown fuse</li> <li>4. Transformer is broken</li> </ol>	<ol style="list-style-type: none"> <li>1. Check or change plug</li> <li>2. Replace power cord</li> <li>3. Replace fuse</li> <li>4. Replace the transformer</li> </ol>
No sealing Timer lights are on	<ol style="list-style-type: none"> <li>1. Heating element is broken</li> <li>2. Poor contact at heating terminal blocks</li> </ol>	<ol style="list-style-type: none"> <li>1. Replace the heating element</li> <li>2. Clean, tighten or change the heating terminal blocks</li> </ol>
No sealing Power light on Heat indicator off	<ol style="list-style-type: none"> <li>1. Footswitch malfunction</li> <li>2. Microswitch malfunction</li> <li>3. Microswitch out of place</li> </ol>	<ol style="list-style-type: none"> <li>1. Replace footswitch</li> <li>2. Replace microswitch</li> <li>3. Adjust microswitch</li> </ol>
Burnt PTFE cloth	<ol style="list-style-type: none"> <li>1. Timer malfunction</li> <li>2. Timer setting too high</li> </ol>	<ol style="list-style-type: none"> <li>1. Replace timer</li> <li>2. Decrease timer setting</li> </ol>
Broken heating element	<ol style="list-style-type: none"> <li>1. Worn PTFE adhesive</li> </ol>	<ol style="list-style-type: none"> <li>1. Replace PTFE adhesive</li> </ol>
Wrinkled seal	<ol style="list-style-type: none"> <li>1. Seal time is set too high</li> <li>2. Cooling (congeal) time is too short</li> </ol>	<ol style="list-style-type: none"> <li>1. Decrease</li> <li>2. Increase congealing time</li> </ol>
Imperfect seal	<ol style="list-style-type: none"> <li>1. Worn PTFE cloth</li> <li>2. Worn silicone rubber</li> </ol>	<ol style="list-style-type: none"> <li>1. Replace PTFE cloth</li> <li>2. Replace the silicone rubber</li> </ol>
Burnt seal	<ol style="list-style-type: none"> <li>1. Seal time is set too high</li> </ol>	<ol style="list-style-type: none"> <li>1. Decrease seal time</li> </ol>
No seal	<ol style="list-style-type: none"> <li>1. Seal time is set too low</li> </ol>	<ol style="list-style-type: none"> <li>1. Increase seal time</li> </ol>
Seal sticking to PTFE cloth	<ol style="list-style-type: none"> <li>1. Worn or dirty PTFE cloth</li> <li>2. Worn or dirty silicone rubber</li> </ol>	<ol style="list-style-type: none"> <li>1. Replace or clean PTFE cloth</li> <li>2. Replace or clean silicone rubber</li> </ol>