

HRS-255

---

# Continuous Band Sealer Instruction Manual

**Distributed By:**

Version 2.5

## **Preface**

**Thank you for buying the Continuous Band Sealer of HRS-225.**

**This instruction manual has following content:**

- Instruction on the product
- Precaution on safety
- Transportation and storage
- Installation and commissioning
- Instruction for use
- Troubleshooting
- Spare parts

This manual gives a description of the installation and use of the product, and it includes following contents: the product's transportation, storage, installation, operation conditions, maintenance, troubleshooting and repairing.

### **Notice:**

- Please read this manual carefully and understand it thoroughly before using..
- Make sure this manual is possessed by the operator or the managerial personnel of this product.
- Please retain this manual after reading and make sure it is available for reference if needed.
- Any questions, please contact the manufacturer or distributor.

### **Responsibilities:**

- Because of violation of the notices in the manual or the mistakes due to misunderstanding, the manufacturer does not take any responsibility.
- The manufacturer will not be responsible for the damage or problems caused by having not adopted the specified spare part.
- The manufacturer keeps the right of amendment on the parameter or parts without prior notice.
- All rights are reserved by manufacturer. And without written approval, printing of any part of this manual is forbidden.

# 1. Instructions on products

## 1.1 Application fields

HRS-255 series continuous paper/plastic sealers are designed to heat seal paper/ plastic bags, paper/plastic cubic bags and paper/ paper bags etc. It adopts continuous sealing type without restriction of bag width.

## 1.2 Heat-sealable materials

- Bags and bag rolls that comply with guidelines of EN868-5 and YY/T0698-5
- Paper bags that comply with guidelines of EN868-4 and YY/T0698-4
- High density polyethylene materials such as Tyvek
- Aluminum foil compound materials

## 1.3 Non heat- sealable materials

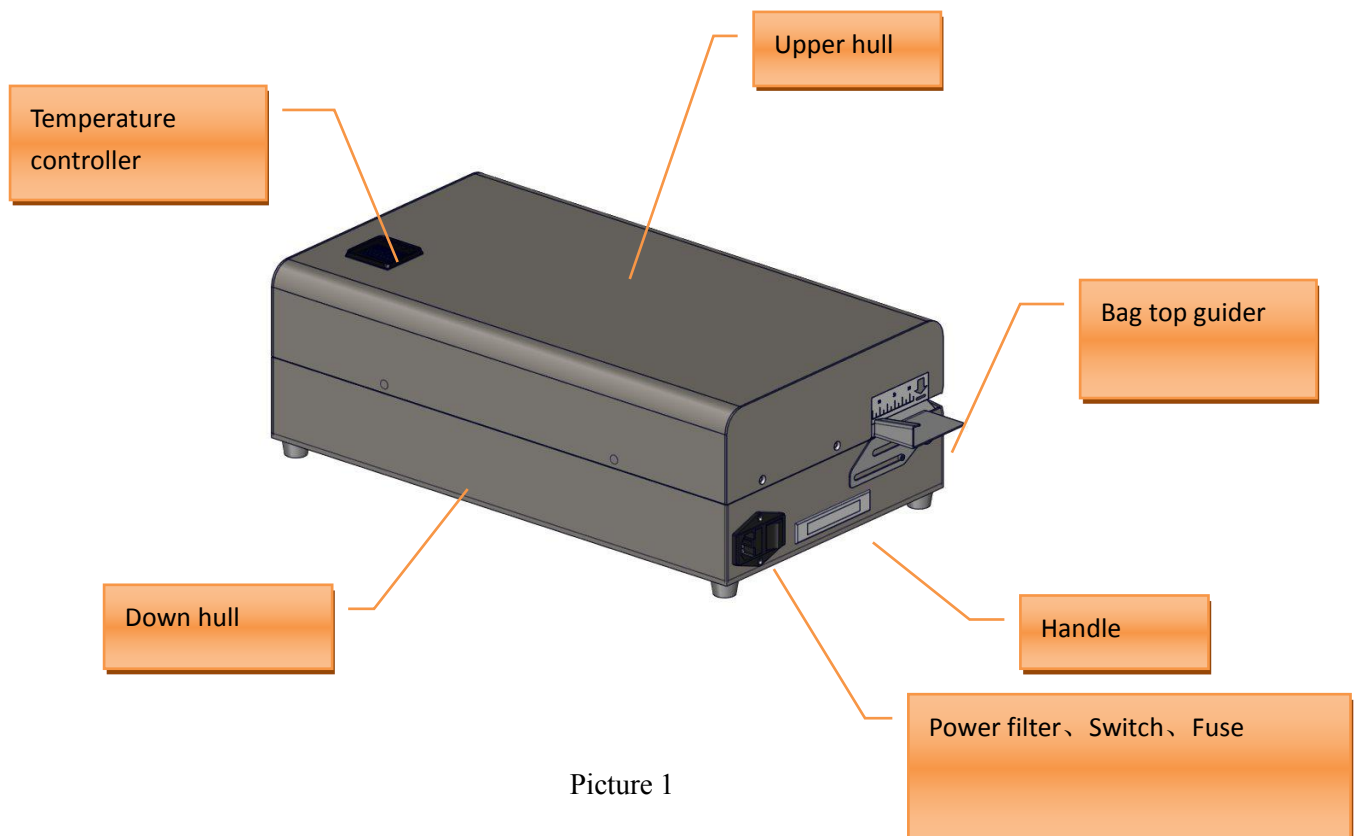
- Polyethylene film
- Flexible PVC film, rigid PVC film
- Nylon film, polypropylene film

## 1.4 Products' features

Adopting Electronic Constant Control device and driven by AC motor, this model has the advantages of efficient and reliable sealing, superior structure, easy operation and low noise, etc

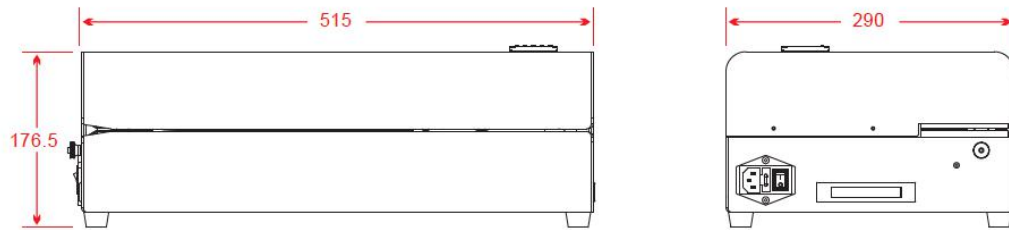
### Main parts

Including hull (upper hull and down hull), power switch, guiding board, transmission mechanism, heat seal mechanism, temperature controller (See below Picture 1)



Picture 1

## 1.5 Parameters of products



- Speed: 10m/min
- Distance from sealing center to bag top: 0~60mm Adjustable
- Seal width: 12mm
- Operation temperature: 60~220°C Adjustable
- Temperature Accuracy:  $\leq 1\%$
- Working environment: 5~30°C
- Voltage: AC 220V 50HZ or AC110V 60HZ
- Motor power: 25W
- Heater Power: 200W
- Fuse: 5AX2
- External dimensions(L\*W\*H): 515x290x176.5mm
- Net weight: 21kg

## 2. Safety

### 1. Preparation:

This instruction is a detailed description of the Carrying, Storage, Installation, Startup, Operating condition, Maintenance, troubles & solutions and Repairing.

The installation of machine is suggested to be operated by trained person.


#### Pls follow the the maintenance instructions

- **Before operating the machine, pls be sure to read the operation manual carefully and fully understand it.**
- **If there is any question, pls contact the supplier.**


### 2. Notice for Security:

- This machine is produced as per the latest technology and security standard. There maybe danger or damage under improper operation. Please notice the keywords “DANGEROUS”, “WARNING”, “TAKE CARE”.


- **E.g.:**

	<b>DANGEROUS!</b> Ignorance of this notice will lead to damage even fatal accident.
---	--

- 

	<b>WARNING!</b> Ignorance of this notice will lead to damage even fatal accident.
---	--

- 

	<b>TAKE CARE!</b> Ignorance of this notice will lead to injury or property loss.
---	---

### 3. Operating Environment:

This product is designed to run under room temperature. If the environment is in bad condition (such as corrosive atmosphere, high temperature or temperature in frequent changes), please contact the manufacturer or distributor

## **3. Equipment movements and storage**

### **1. With Carton Packing**

If the machine is packed by carton with expanded gasket,

- Remove the expanded gasket from the carton.

If the machine is packed by carton with foam material,

- Remove the foam material from the carton.

### **2. Storage for short time**

- Power off, unplug the power and put the power cord away.
- Cover the machine with plastic bags in case of dusts if possible.
- Store the machine in a dry, dustless and shockproof room.

### **3. Storage for long time**

The internal of the machine has its anti-corrosion treatment before it leaves the factory, so there is no need to treat it with preventive oil in addition. You can use the preventive oil if it is stored in bad condition, such as corrosive atmospheric environment, overheat or frequently changed temperature. If any question, please contact the manufacturer or distributor.

- Power off, unplug the power and put the power cord away.
- Cover the machine with plastic bags in case of dusts if possible.
- Keep the original package if possible.
- Store the machine in a dry, dustless and shockproof room.

### **4. Restart after storage**


Operate according to the instruction in the INSTALLATION and START chapter.

## 4. Installation

Before installation and operation, please read this manual carefully. You can get the information of the installation, starting, maintenance and operation of the machine. Supplier is not responsible for the problem caused by the operation against this manual.

Supplier wants all client use this machine without any problem. If any question, feel free to contact supplier or dealer.

### 1. Essential condition for installation



	<p><b>Caution! Harm to machine!</b></p> <p>Without essential condition for installation, machine will be damaged.</p> <p>Be careful injured!</p> <p>Please obey the essential condition for installation.</p>
---	---

Please assure the installation environment satisfy basic safety regulations.

### 2. Installation environment

- No inflammable and explosive gas is allowed.
- Environment temperature : 5-30°C. If need operation under other temperature, please confirm with supplier or dealer first.
- Environment pressure, standard atmospheric pressure
- Assure power environment satisfy requirements (refer to nameplate).
- No inclined is an important factor of the machine successful operating.
- Leave enough space to assure good ventilation for heat dissipation. At least 10cm interspace.
- Machine cannot be exposed to heat source and steam device directly. ( such as steamer, dish-washing machine or stove )

### 3. Electrical connection


		<p><b>DANGER! ELECTRIC SHOCK!</b></p> <p>Assure all socket equipped with protective grounding wire.</p> <p>Caution! Mismatching power supply damage machine!</p> <p>Please check all parameter for machine power (refer to nameplate).</p> <p>Please obey operation safety guidelines and national accident prevention measures.</p>
---	---	--

### 4. Power supply / Grounding

- **Check whether the voltage of power supply in accordance with nameplate of machine.**
- **Assure the machine connect with grounding receptacle in case of fire or electric shock (ground wire color is yellow green).**
- **Power line must be ok to move freely. Avoid any squeezing on power line.**
- **When power line broken, replace it immediately.**
- **When machine have problem or need maintenance, please cut down the power supply firstly.**
- **When machine will be left idle for a long period of time, please collect the power line.**



## 5.Starting and operating

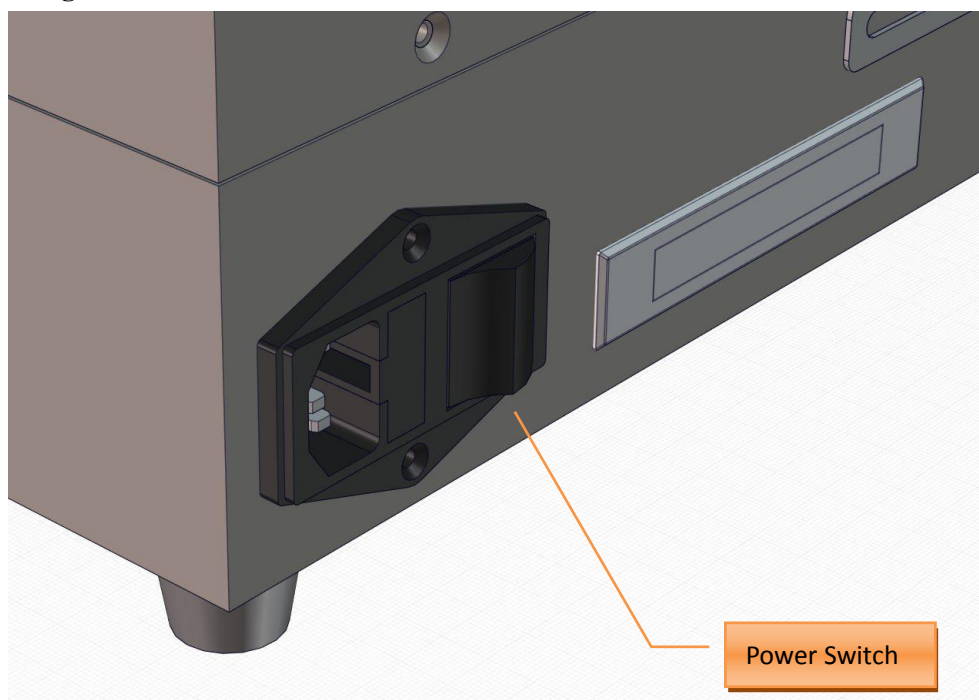


**TAKE CARE! SCALD!**

The sealing blade can reach to the high temperature of more than 200°C when it is heating sealing. Even after cooling, it is still in a high temperature.

- If you have any questions about the operation and the function that not offered in this manual, please contact the manufacturer or the supplier.
- If the machine is running irregularly or makes strange noise, please turn off the power immediately, stop the running and finally cut off the power.
- If the machine is running irregularly or makes strange noise, please turn off the power immediately, stop the running and finally cut off the power.

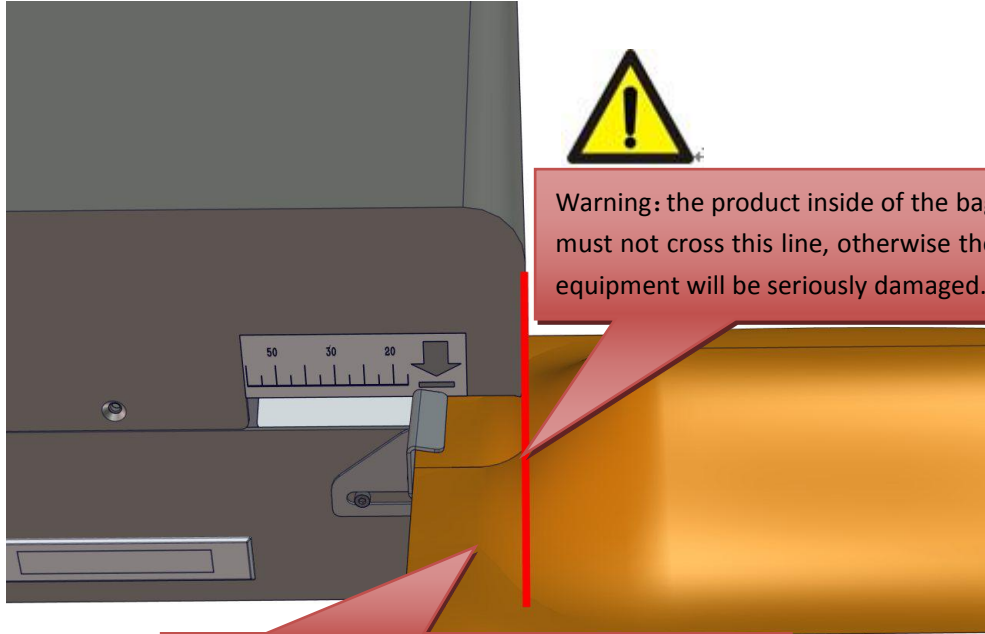
### 1. Starting



Picture 2

Starting up: after the power supply being connected, turn on the power switch (as Picture 2). The machine runs automatically, and the temperature controller starts and shows the temperature. Please check the usage for temperature controller in the attachments.

Working: Please keep enough space between product and bag month!! (as Picture 3)



Warning: the product inside of the bag must not cross this line, otherwise the equipment will be seriously damaged.

Note: the part entered in the equipment must be kept flat and no paste.

## 2. Replacement for the fuse



**DANGER! ELECTRIC SHOCK!**

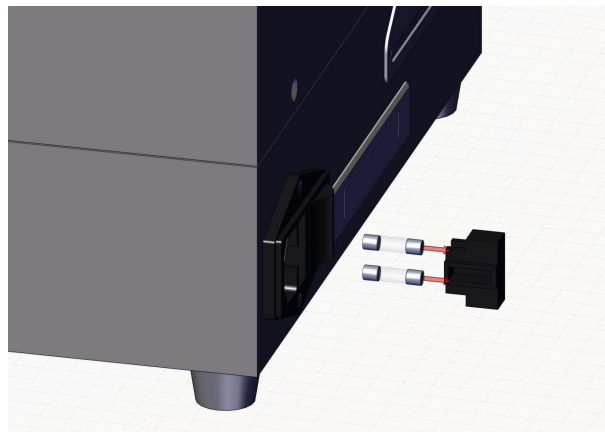
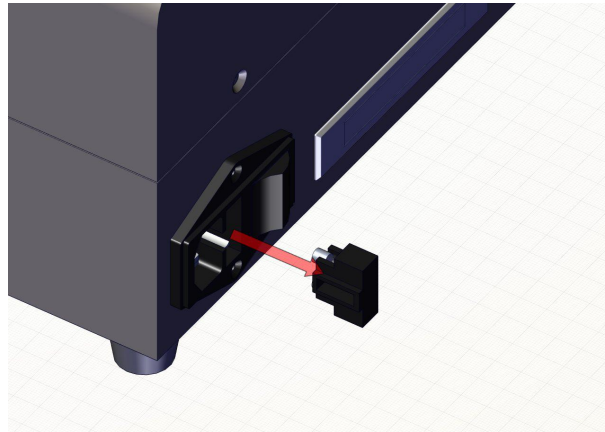
Please cut down the power before replacing the fuse.



**TAKE CARE! MACHINE DAMAGED!**

Different voltage or machine type equip with different fuse.

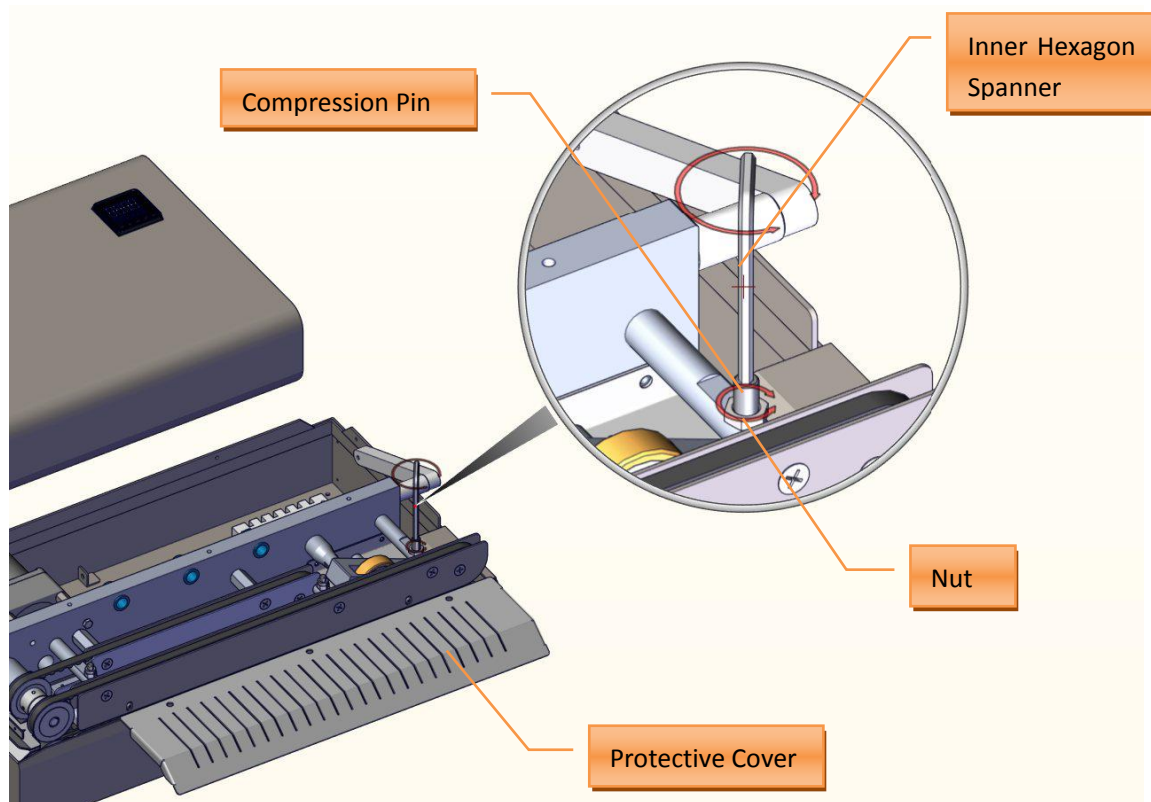
To avoid the machine damage, please replace the fuse with same specifications and types.



The main circuit fuse is located in the power socket.

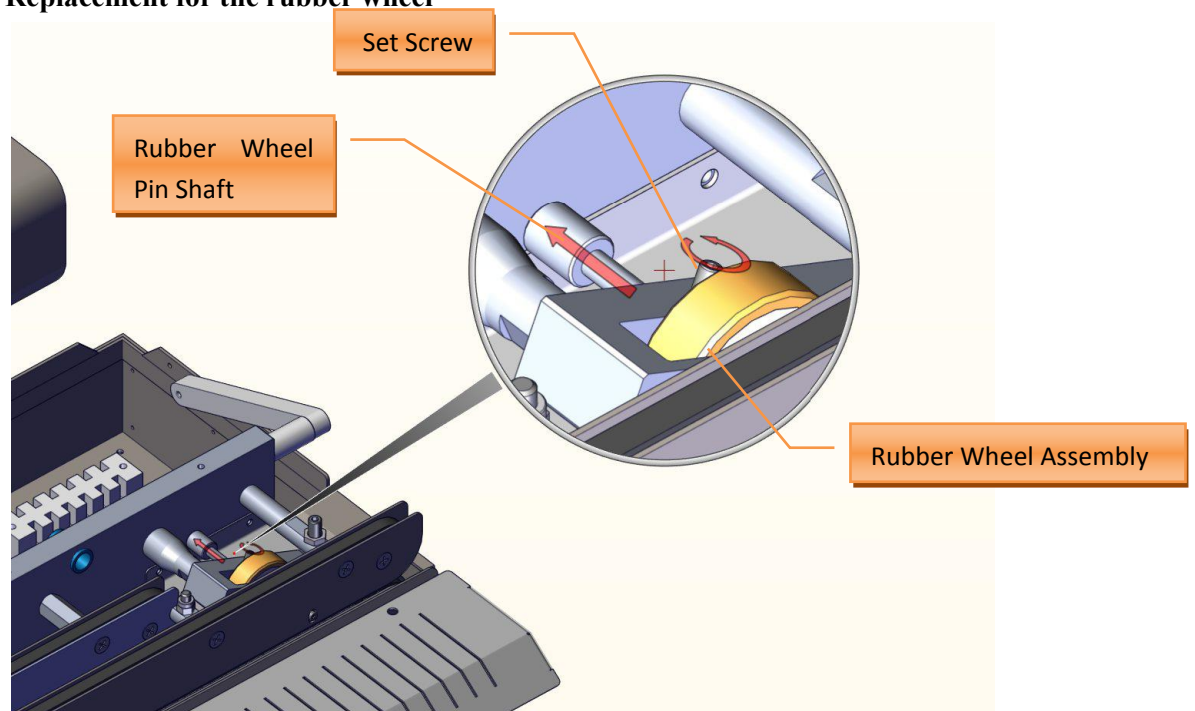
- Pull out the power cord.
- Pull out fuse socket.
- Take out the damaged fuse from the fuse socket.
- Install the new fuse into the fuse socket
- Insert fuse socket back into power socket.

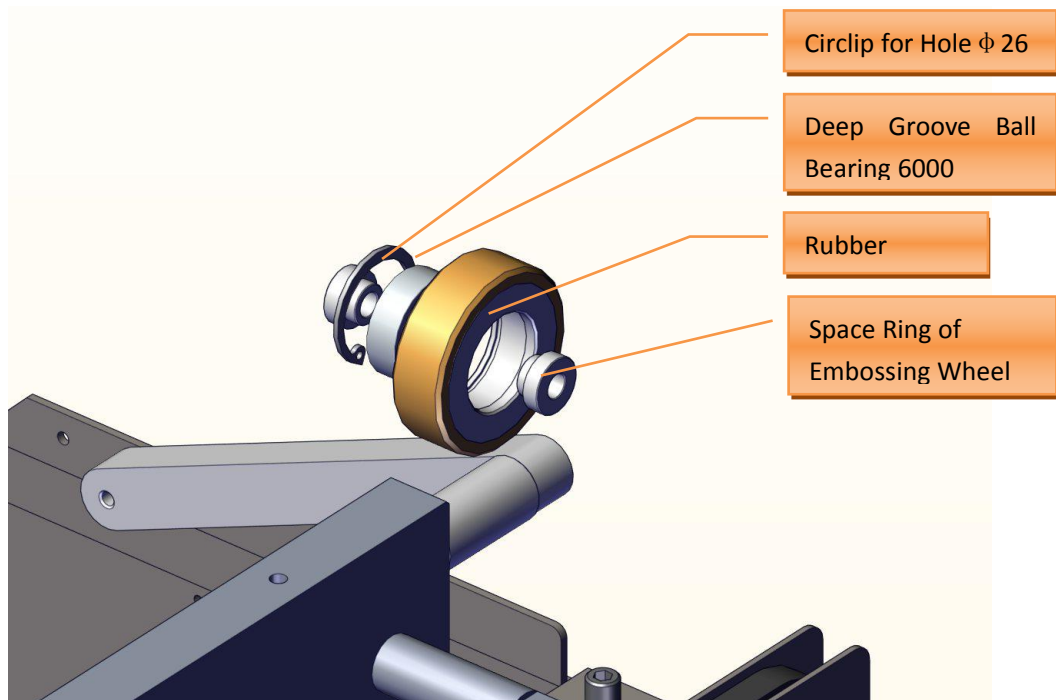
### 3. Adjustment for Embossing wheel pressure



- Remove the upper machine hull and protective cover.
- Loosen the nut with inner hexagon spanner.
- Adjust the compression pin with inner hexagon spanner.
- Lock nut after adjusting after the adjustment.
- Install the upper machine hull and protective cover.

### 4. Replacement for the rubber wheel





- Loosen the set screw with inner hexagon spanner.
- Pull out the rubber wheel pin shaft.
- Take out rubber wheel assembly.
- Install the assembled rubber wheel assembly.
- Lock the set screw tightly, place the protective cover back.

## 6. Breakdowns and Troubleshooting

### Breakdowns and Troubleshooting

Malfunction	Cause	Solution(s)
The machine does not work and the temperature controller doesn't have reading.	The machine is not connected to power supply.	Plug in to connect the power supply
	The fuse of main circuit blew out	Replace the fuse (with right specification)
	The junction of the power switch loosens	Check, fasten, repair or replace with a new one
The embossing is not clear.	The embossing wheel is worn out.	Replace the embossing wheel.
	The compression spring for the seat of embossing wheel is not tightened enough.	Adjust the compression spring
There is resistance while conveying	There is too much stress on the spring of heating plate	Adjust the spring of the heating plate