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## KF-Series Foot Sealers

Model: KF-300F/305F, KF-450/455F, KF-600F/605F

**Distributed By:**

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Sealer Sales, Inc.  
8820 Baird Avenue  
Northridge, Ca 91324  
[www.sealersales.com](http://www.sealersales.com)

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# General Information

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Thank you for purchasing our KF-Series 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 110 Volt, 60Hz wall outlet or surge protector.
- ❖ Do not use the sealer if the power cord, plug or any other parts are damaged. Do not 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/or 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 and in good working condition. Follow any maintenance 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

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## Scan QR Code for Video Demo



KF-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 KF-series foot sealers can seal polyethylene, polypropylene, saran, nylon, static shielding bags, Mylar up to 10mil in total thickness.

## Features of the KF-Series Long 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
- ❖ ETL Listed (2mm seal width only)
- ❖ Optional: Taller stand and tension rod available, adding 10" height
- ❖ Manufacturer spare parts kit includes: Two (2) heating elements

## How Do Foot Sealers Work?

### Basic

### Principles

Place material on lower jaw and activate footboard

Our KF-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

	KF-300F	KF-305F	KF-450F	KF-455F	KF-600F	KF-605F
Power	110V/60Hz	110V/60Hz	110V/60Hz	110V/60Hz	110V/60Hz	110V/60Hz
Watts	400W	600W	600W	900W	800W	1200W
Seal Width	2.5mm	5mm	2.5mm	5mm	2.5mm	5mm
Sealing Length	12"	12"	18"	18"	24"	24"
Standing Height	33 1/2"	33 1/2"	33 1/2"	33 1/2"	33 1/2"	33 1/2"
Working Table Width	11-3/4"	11-3/4"	17-3/4"	17-3/4"	23-3/4"	23-3/4"
Tray Adjustment Height	Up to 6.5"	Up to 6.5"	Up to 6.5"	Up to 6.5"	Up to 6.5"	Up to 6.5"
Throat Depth	3 1/2"	3 1/2"	3 1/2"	3 1/2"	3 1/2"	3 1/2"
Weight	45-lbs	46-lbs	47-lbs	48-lbs	50-lbs	51-lbs
Shipping Dimensions	31" x 18" x 18"					

## Electrical Circuit Diagram

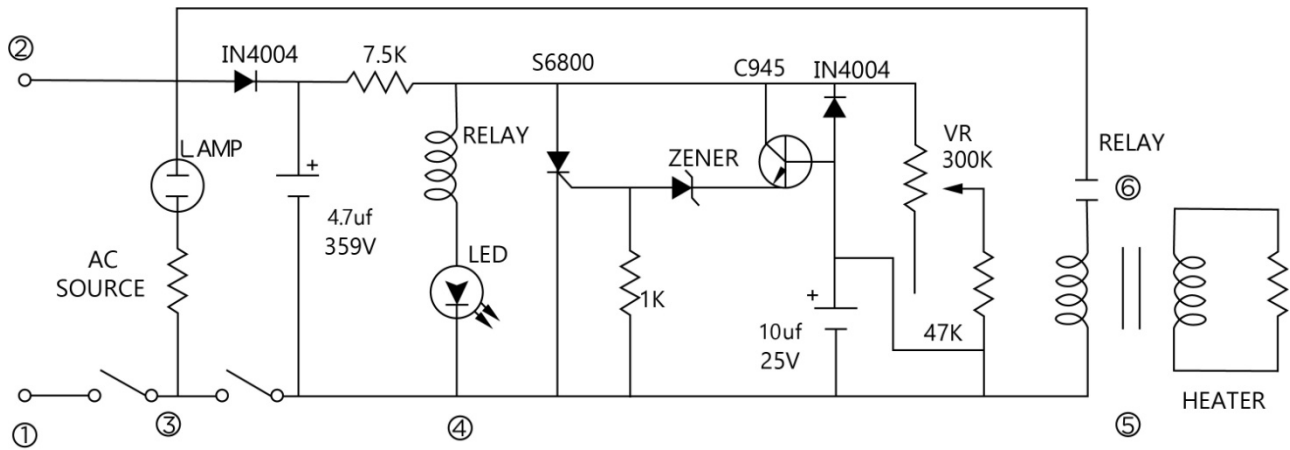


Figure 1. Electrical Circuit Diagram

## Getting to Know your Foot Sealer

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

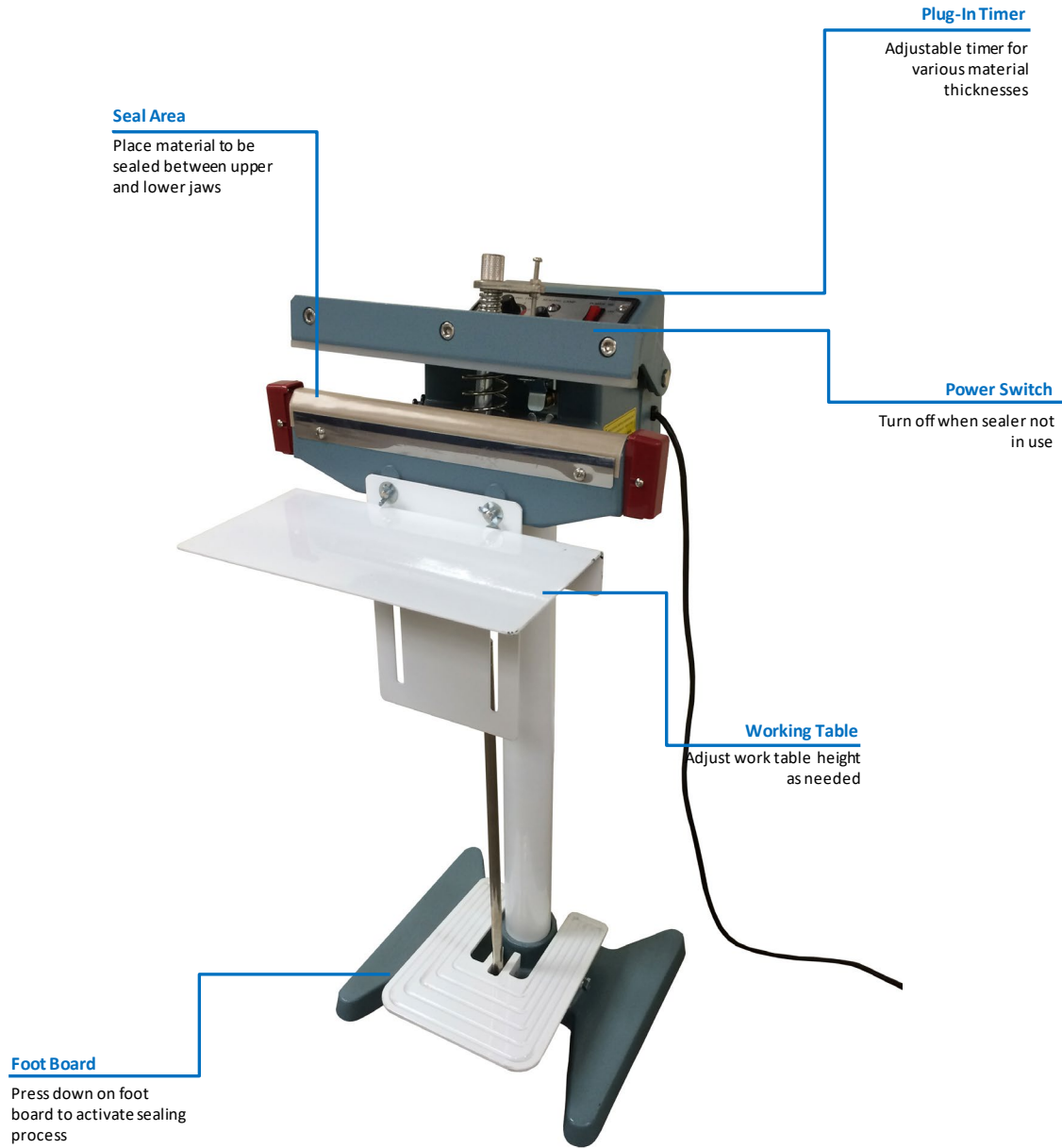


Figure 2. KF-Series Foot Sealer Overview



# Operating your Sealer

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## Important

Read this manual carefully, and make it available to everyone connected with the supervision, maintenance, or operation of this machine. Additional copies are available at your request. (Contact your distributor for this information.) Be very careful when operating, adjusting, or servicing this equipment. If in doubt, stop and obtain qualified help before proceeding.

## Installation

Place the sealer in the desired location with the required electrical power source available. (See power requirements.) Make certain that proper electrical wiring is provided to guard against low voltage. If the voltage is too low, the equipment will not function properly.

Finding the proper location is a most important function of the initial set-up. One must take several factors into consideration:

- ❖ Adequate power source
- ❖ Relationship to source of product
- ❖ Relationship to any conveyors necessary to transport finished product
- ❖ Convenience of operator

## Assembly Instructions

1. Insert standing tube into pedal base and connect with short screw. (Figure 3)
2. With the four long screws, connect the head (body) to the stand. (Figure 4)

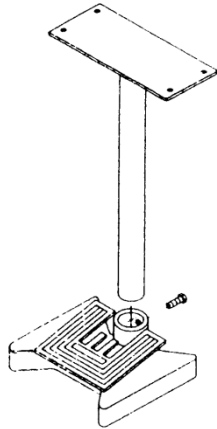


Figure 3. Insert standing tube

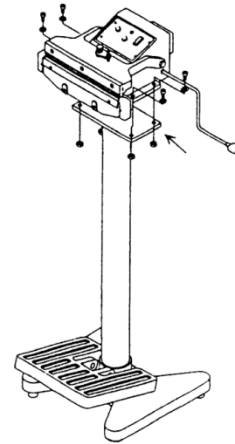


Figure 4. Attach head to stand

3. Attach the tension rod (pulling pole) to the upper puller (Figure 11, Item #12) which is located under the base. Next, attach the rod to the foot pedal. (Figure 5).
4. Connect the working plate to the body. Fit working plate over the bracket. Note: When attaching the working plate bracket, leave enough space between sealer body and top of screws of that the working plate can be attached easily. (Figure 6).

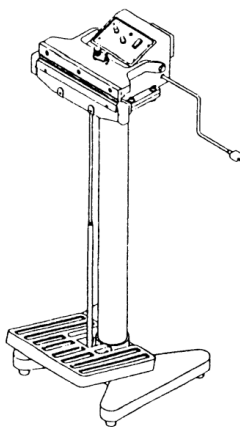


Figure 5. Attach pulling pole

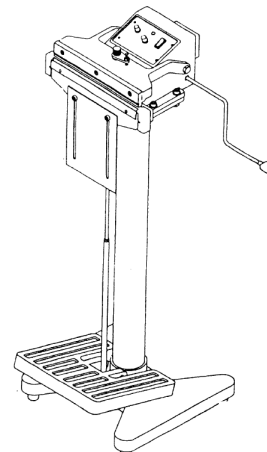


Figure 6. Connect working plate

## 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 between the jaws and press down on the foot board gently, but firmly. The red light will turn off when sealing time is complete.
6. *When red light turns off, keep pressing the foot board 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 KF-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 KF-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.

**\*\*Please note: 2.5mm and 5mm seal width sealers are NOT interchangeable.  
For example: If you purchased a KF-300F (2.5mm), you CANNOT purchase the heating element or kit for KF-305F (5mm).\*\***

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 #.

	KF-300F / KF-305F	KF-450F / KF-455F	K-600F / KF-605F
Replacement Kit (2.5mm)	RK-12F-KF-300F	RK-18F-KF-450F	RK-24F-KF-600F
Replacement Kit (5mm)	RK-12F5-KF-305F	RK-18F5-KF-455F	RK-24F5-KF-605F
Heating Element (2.5mm)	HE-12-2-KF-300F	HE-18-2-KF-450F	HE-24-2-KF-600F
Heating Element (5mm)	HE-12-5-KF-305F	HE-18-5-KF-455F	HE-24-5-KF-605F
PTFE Adhesive	TA-12	TA-18	TA-24
PTFE Cloth (1ft. roll)	TR-12-12	TR-18-12	TR-24-12
Silicone Rubber <i>(not included in RK)</i>	SR-KF-300F/KF-305F	SR-KF-450F/KF-455F	SR-KF-600F/KF-605F

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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 11, Item #32).
2. Remove the heating element cover (Figure 11, Item #40)



Figure 7. Loosen screws on PTFE plate.

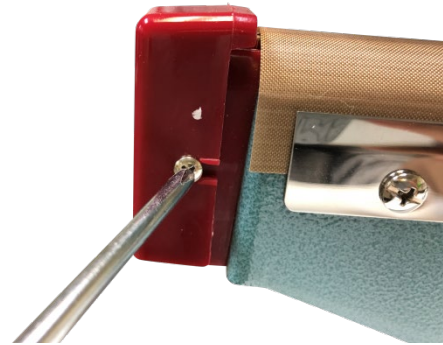


Figure 8. Remove heating element cover

3. Lift up the PTFE cover to expose the heating element (Figure 11, Item #27).
4. Remove the heating element by unscrewing the element screw apply pressure to the heating element with your finger while unscrewing the screw to prevent the heating element from twisting).
5. Peel off the PTFE adhesive under the heating element.

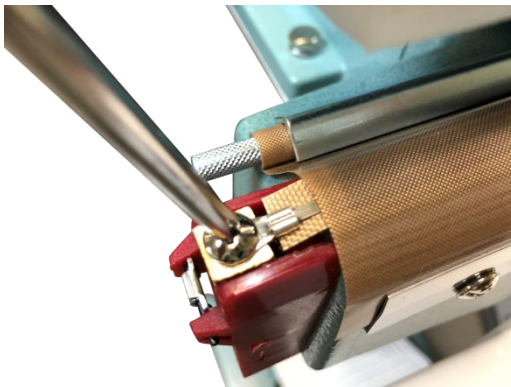


Figure 9. Remove heating element from terminal assembly

**Installing New Replacement Parts.**

1. Remove the backing of the liner 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.
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 nut (**Figure 11, Item #31**) found on the plate for PTFE and remove the PTFE roller (**Figure 11, Item #28**). 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 10.** Loosen knob to remove the PTFE roller.

# Parts Diagram

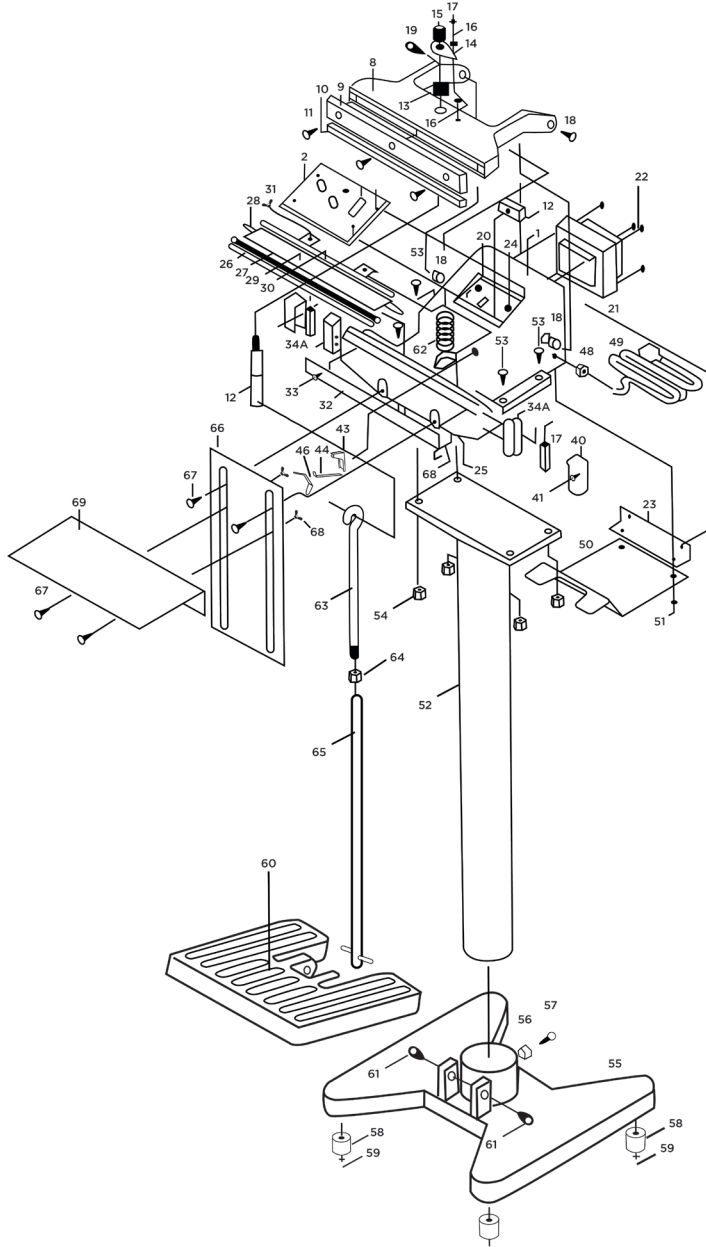


Figure 11. Spare Parts Diagram Overview

Figure 12. Spare Parts Diagram Overview

Item	Part #	Description	Comments
RKs	RK-Model#	<b>REPLACEMENT KITS</b> Includes (2) elements, (2) PTFE adhesives, and 1ft PTFE cover	specify model # when ordering
1		Body	
2	<b>T-KFF</b>	Timer	specify ETL or non-ETL
3	<b>KFF-3</b>	Pilot Lamp	
4	<b>KFF-4/4A</b>	Fuse Holder	
4A		Fuse 15amp	
5	<b>TISF-4</b>	Timer Knob	
6		On/Off Switch	
7		5/32 x 1/4 Plane Screw	
8		Upper Jaw	
9		Sealing Plate	
10	<b>SR-model#</b>	Silicone Rubber	specify model # when ordering
11		5/16 x 1/4 Screw	
12	<b>KFF-12</b>	Upper Puller	
13	<b>KFF-13</b>	Pressing Spring, Small	
14	<b>KFF-14</b>	Puller Fixed Plate	
15	<b>KFF-15</b>	Upper Puller Fixed Nut	
16	<b>KFF-16</b>	3/16 Nut	
17	<b>KFF-17</b>	3/16 x 2 1/2 Screw	
18		Axis Collar	
19	<b>KFF-19</b>	3/8 x 1 Screw	
20		3/8 Nut	
21	<b>TRNS-model#</b>	Transformer	specify model # when ordering
21-1	<b>KFF-21-1</b>	Transformer Cover	
22		3/16 x 2 1/2 Screw	
23		Guard Plate / Fixed Plate	
24		3/16 Nut	
25		1/4 x 3/4 6 Corner Screw	
26	<b>TA-12</b> <b>TA-18</b> <b>TA-24</b>	PTFE Adhesive Cloth	specify model # when ordering
27	<b>HE-Model#</b>	Heating Element	specify model # when ordering
28		PTFE Roller	specify model # when ordering
29	<b>TA-12-12</b> <b>TA-18-12</b> <b>TA-24-12</b>	PTFE Cloth	specify model # when ordering
30		PTFE Rear Press Bar	
31		1/4 Nut	
32		PTFE Front Press Plate	
33		3/16 x 1/2 Plane Screw	



Figure 13. Spare Parts Diagram Overview

Item	Part #	Description	Comments
34A	<b>HTAB-KFF</b>	Heating Terminal Assembly (Includes #34-38)	<b>Includes #34-38</b>
34	<b>HTAB-KFF</b>	Heating Element Fixed Ass. Case	<b>Includes #34-38</b>
35	<b>HTAB-KFF</b>	Heating Element Fixed Assorted Screw	<b>Includes #34-38</b>
36	<b>HTAB-KFF</b>	Heating Element Fixed Assorted Bolt	<b>Includes #34-38</b>
37	<b>HTAB-KFF</b>	Heating Element Fixed Assorted Driving Plate	<b>Includes #34-38</b>
38	<b>HTAB-KFF</b>	Heating Element Fixed Assorted Fixed Bolt	<b>Includes #34-38</b>
39		5/32 x 1 Screw	
40		Heating Terminal Cover, End Cap	
41		1 1/4 Plane Screw	
42	<b>MSW-KFF</b>	Microswitch	
43		Miscroswitch Upper Fixed Plate	
44		Miscroswitch Lower Fixed Plate	
45		Microswitch Fixed Nut	
46		Microswitch Driving Plate	
47		Microswitch Fixed Bolt	
48		Buckle (Bushing)	
49	<b>PWC-KF</b>	Power Cord	
50		Guard Plate / Fixed Plate	
51		5/32 x 1/4 Plane Screw	
52		Stand	
53		5/16 x 16 Corner Screw	
54		5/16 Nut	
55		Base	
56		5/16 Nut	
57		5/16 x 3/4 6 Corner Screw	
58		Rubbert Foot	
59		5/16 x 3/4 6 Plane Screw	
60	<b>FB-KFF</b>	Pedal	
61		3/8 x 1 1/2 6 Corner Screw	
62		Pressing Spring, Large	
63A		Pulling Pole Set (Includes #63, 64, 65)	
63		Down Puller Hook	
64		5/16 Nut	
65		Down Puller Hook	
66		Level Plate	
67		1/4 x 16 Corner Screw	
68		1/4 Nut	
69		Working Plate	

# Troubleshooting

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 sealing time</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>