



SS-Series Economy L-Bar Sealers
Model: SS-1519L, SS-1519LM, SS-1519LMC

Distributed By:

Version 1.0
Last Updated: 2/20/20

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Sealer Sales, Inc.
8820 Baird Avenue
Northridge, Ca 91324
www.sealersales.com

Printed in the United States of America

IMPORTANT - PLEASE READ THIS CAREFULLY

The development of a good safety program, that is rigidly enforced, is absolutely imperative when involved in the operation of industrial equipment. Our machinery is well designed and includes extremely important safety features. The part you the user play through proper installation and maintenance procedures is of far greater significance than our designs. Only properly trained individuals following rigidly enforced safety rules, as recommended by A.N.S.I. and O.S.H.A., should be allowed to operate these machines.

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UNPACKING

THOROUGHLY INSPECT EQUIPMENT UPON ARRIVAL.

If goods are received short or in a damaged condition, it is important that you notify the carrier's driver **before he leaves your company** and **insist** on a notation of the loss or damage across the face of the freight bill. Unless this is done, no claim can be enforced against the transportation company.

If concealed loss or damage is discovered, notify the carrier at once and **insist** on an inspection. This is absolutely necessary! A concealed damage report must be made no later than five (5) days from the date the shipment was delivered. Unless you do this, the carrier will not consider any claim for loss or damage. The carrier's agent will then make an inspection and grant a concealed damage notation. If you give the transportation company a clear receipt for the goods that have been damaged or lost in transit, you do so at your own risk and expense.

All claims must be filed within 5 days of delivery date or carrier will not accept them.

Sealer Sales is willing to assist in every possible manner to collect claims for loss or damage; however, this does not hold Sealer Sales responsible for collection on claims or replacement of material.

Do not throw away damaged pallets or box until freight inspection has occurred.

Your new Model SS-1519L Series L-Bar Sealer comes in a tri-walled corrugated box to protect it.

1. If your machine does not arrive in good condition, **write on shipping paperwork that outside of box is damaged. Concealed damage may have occurred.**

2. Remove stretch film and Poly Bag covering machine.



3. Remove film rack from under L-Bar Sealer.

4. Check film rack. You should have
 - (a) (1) Film Rack
 - (b) (1) adjustable center knob
 - (c) (2) film roll guides



5. Mount film rack on right side at end of machine and slid left. This is a boltless mounting system, No Tools Required!.

6. Place in desired location and use locking knob in center to set in place.

IMPORTANT WARRANTY NOTICES

OPERATING AND MAINTENANCE MANUAL

The operating and maintenance manual has been carefully prepared to provide the user with all the information needed to properly install, operate, and maintain your Sealer Sales equipment.

Please read this manual carefully and refer to it for information on the care and use of your Sealer Sales equipment. It is recommended that additional copies be ordered for use by production, maintenance, and supervisory personnel. Although the design of this equipment incorporates safeguards to protect personnel, care should be used in operating, adjusting, and servicing.

Attention is directed to the warranty that accompanies all your Sealer Sales equipment. The terms and conditions of this warranty apply only to unmodified units. **Any unauthorized modifications to the equipment automatically voids this warranty.**

Sealer Sales provides a two-year warranty on parts, **excluding shipping or freight costs for replacement parts. All warranty parts are shipped F.O.B. Rancho Cucamonga, California.**

Sealer Sales

WARRANTY

Sealer Sales, Inc. warrants each new product manufactured to be free from defects in material and workmanship for a period of (1) year from date of shipment by Sealer Sales.

This warranty is not transferable with any subsequent resale.

Defective parts under warranty must be returned to Sealer Sales freight prepaid. Sealer Sales' sole obligation and purchaser's sole remedy in the event of a warranty dispute shall be, at Sealer Sales' option, to repair or replace the part in question. Labor incurred in removing or installing the defective part is not covered by this warranty. Prior to returning any parts for any reason, contact Sealer Sales for a Return Authorization Number. This number must accompany all returns.

This warranty shall not apply if equipment has been tampered with, misused, improperly installed, altered, or has received damage due to abuse, carelessness, accident or failure to follow recommended regular maintenance procedures or has been serviced by someone other than a duly authorized factory representative without the express written consent of Sealer Sales, Inc.

This warranty is in lieu of all other warranties, expressed or implied, including but not limited to warranties of merchantability and fitness for a particular purpose, non-infringement or any other matter.

Sealer Sales shall have no liability to any person for direct, indirect, incidental or consequential damages or delay resulting from any defect negligence, or tort and customer hereby waives for itself

any and all claims for punitive damages and all claims of negligence of strict liability or both. In no event shall our liability exceed the purchase price of the product that was actually paid.

Sealer Sales reserves the right to make changes, additions, or improvements to our products with no obligation to make such changes in any previously shipped product covered by this warranty.

Sealer Sales shall not be held liable for any damages arising out of nor in connection with the operation of the equipment should customer or its agent fail to maintain equipment in safe operating condition. This warranty shall become unenforceable if and to the extent the customer or its agents remove, disconnect, or otherwise render useless any safety device and or parts designed or affixed by us or fails to maintain and service equipment in a manner as advised.

Sealer Sales provides a one-year warranty on parts, excluding shipping or freight costs for replacement parts. All warranty parts are shipped F.O.B. Rancho Cucamonga, California. Service Labor to install part is not covered under warranty!

WARRANTY EXCEPTIONS

The following parts are an exception to the general warranty list on page 10. Each part listed below shall carry a 30-day warranty unless designated otherwise.

- SS-1519L Series Sealer
Parts
 1. Fuses
 2. Conveyor Belt (Optional)

The following sealer parts are considered to be **consumable** and not under warranty:

1. Silicone Sponge
2. Band Ribbon
3. PTFE Tapes
4. Transite Channels

WARNINGS

Every effort has been taken to ensure your safety while operating this machine; however, there still remain certain risks. Do not allow this machine to be operated before informing all personnel of the following warnings.

WARNING.....

Do not tamper with the electrical wiring. Only use a licensed electrician for maintenance. Always disconnect the electrical power before attempting any maintenance to all electrical and/or moving parts.

WARNING.....

In order to prevent injury to personnel and/or machinery
DO NOT INCREASE SETTINGS OR RATINGS ON EITHER ELECTRICAL
OR MECHANICAL OVERLOAD SAFETY DEVICES.

WARNING.....

KEEP HANDS AWAY FROM MOVING CONVEYORS AND
ASSEMBLIES. Conveyor belts that have become worn or frayed are
capable of being hazardous. They should be replaced promptly.

WARNING.....

NEVER OPERATE THIS OR ANY MOVING EQUIPMENT
WITHOUT ALL COVERS AND GUARDS IN PLACE. The internal
mechanism of most packaging machinery contains numerous shear,
pinch, and inrunning nip points, many of which are capable of
causing severe injury and/or permanent disfigurement.

WARNING.....

To minimize the potential for personnel injury, always be sure that machine operators and others working on the machinery are properly trained in the correct usage of the equipment and properly instructed regarding the safety procedures for operation.

WARNING.....

Heat sealing arms and jaws on packaging machinery can become very warm after a period of use. KEEP HANDS AWAY WHILE IN OPERATION AND USE CAUTION IF THE MACHINE HAS BEEN RUNNING RECENTLY.

WARNING.....

ANY MODIFICATIONS TO EITHER THE ELECTRICAL CIRCUITRY OR THE MECHANICAL ASSEMBLIES OF THE MACHINERY WILL VOID ANY WARRANTIES ASSOCIATED WITH THIS EQUIPMENT. Such modifications may introduce hazards that would not otherwise be associated with this machinery. Sealer Sales will not be responsible for any consequences resulting from such unauthorized modifications.

WARNING.....

The use of certain types of plastic films in sealing and/or shrinking equipment may result in the release of HAZARDOUS FUMES due to the degradation of the film at high temperatures. Before using any plastic film in this equipment, the manufacturer or supplier of the film should be contacted for specific information concerning the potential release of hazardous fumes. ADEQUATE VENTILATION MUST BE PROVIDED AT ALL TIMES.

WARNING.....

It is important that the machine operator unplug the machine when he/she has finished operating the unit.

WARNING.....

Turn off machine and disconnect power cord from power source before attempting to work on machine.

**DESCRIPTION AND SPECIFICATIONS
OF
MODEL SS-1519L SERIES L-Bar Sealer**

DESCRIPTION

The purpose of a SS-1519L Series is for low to medium volume packaging requiring excellent seals and minimal maintenance. It features an impulse mode for sealing of films. This model incorporates an **optional** electromagnetic hold-down system, allowing the operator to load another package while the preceding package is being sealed. This system provides consistent seals. In addition, an **optional** package take-away conveyor increases production speed by automatically discharging product into a shrink tunnel.

SPECIFICATIONS

Model:	SS-1519L
Seal Area:	Series Length: 19" Width: 15"
Machine Size:	Length: 53" Width: 24" Height: 45"
Volts:	110
Amperage:	20
Weight:	150 lbs.

INSTALLATION AND BASIC SET-UP OF L-Bar Sealer

IMPORTANT

Read this manual carefully, and make it available to everyone connected with the supervision, maintenance, or production 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 OF SS-1519L SERIES L' SEALERS



Place the SS-1519L 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. **Machine comes complete with power cord and 110 volt plug.**

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

1. Adequate power source.
2. Relationship to source of product.
3. Relationship to L-Bar Sealer.
4. Relationship to any conveyors necessary to remove finished product.
5. Convenience of operator.

Make sure to connect machine to an Independent Power Source. **DO NOT run any other equipment on the same power line as your machine.**

Do not attempt to install, adjust, or operate this machine without first reading the contents of this manual. Although the design of the equipment incorporates safeguards to protect operating and maintenance personnel, care should be used in operating, adjusting, and servicing.

INSTALLING FILM RACK



IMPORTANT: Remove film rack from under sealer and install at the end of the sealer on the right hand side with the four bolts and center knob provided. Mounting holes are slotted for adjustment, set film rack flush with backside of the machine frame.

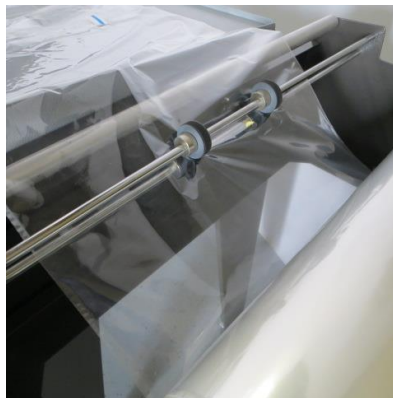
MOUNTING FILM

Select the proper width of centerfold film for the item being packaged, allowing for width and height of package. With the package properly positioned within the film in the sealing area, allow sufficient film to overlap the sealing bars so that a seal may readily be made without any possibility of open areas due to insufficient film.



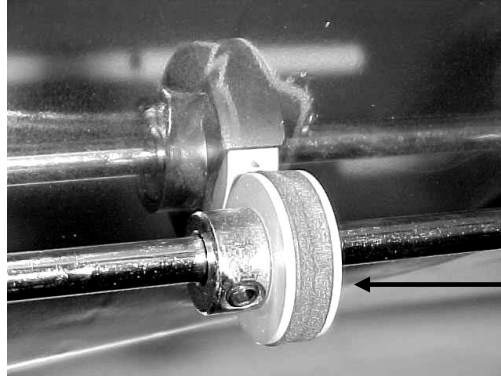
Place film roll on cradle mount film rack. The centerfold is to be placed away from the operator, toward the rear of the machine. Use core chucks to position film roll on rack and tighten film guide nuts to hold film roll in position.

PIN PERFORATOR



Located between the lower idler rollers, the pin perforator creates holes for air escape as the operator pulls on the film. This allows the air to escape as the package travels through the tunnel.

The pin perforator is adjustable and must be properly placed in conjunction with the width of the desired package. The positioning should always be re-evaluated when setting the machine for different size product or different size film.



*CAM Design to
Adjust Depth*

Thread film through the Pin Perforator. Note that the perforator wheel turns freely and is not binding. You can adjust the depth of pin holes by Loosening the Allen screw on the sponge wheel and rotate the cam to allow the pin to push deeper or shallower into the film.

PRODUCT TRAY



The product tray is an adjustable metal platform used to separate film and to insert product between top and bottom layers of film.

Once threaded, separate film top from bottom and insert product tray between. Make sure that the centerfold of film is placed at the rear of the product tray. This allows the operator to insert product between the layers of film on the product tray and to prepare to move product and film into the sealing area. When threading film, make sure to pull more than sufficient film through the rollers, across the product tray, and into the sealing area to ensure sufficient film to begin operation.

The tray is adjustable to achieve proper depth, equal to the depth of the package, allowing product to be placed exactly in the centerfold of the film each time. A locking wing screw allows you to set tray position.

Place product against rear of film separator tray. Then move product into seal area. Be sure to leave the bag loose around the product when making the seal. This helps eliminate the seals from blowing out in the shrink tunnel.

LOCKING WING SCREW



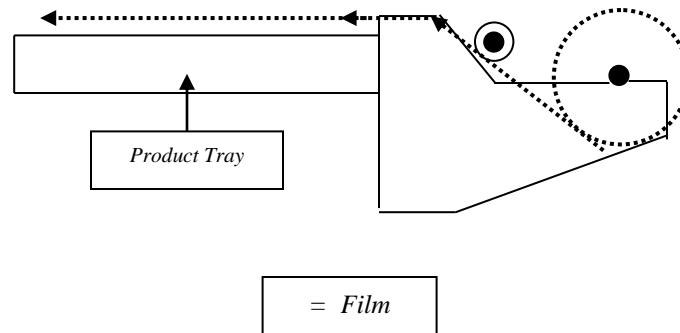
Once the product is placed in the desired location, tighten the wing screw under the loading tray to lock tray in position.

Optional Power Discharge Conveyor



Lower Power Discharge Conveyor using the crank wheel located underneath the Power Discharge Conveyor. The Conveyor should be set so the package height is centered to the seal pad. In essence, $\frac{1}{2}$ of the package is above the seal pad and the other $\frac{1}{2}$ of the package is below the seal pad. This will place the seal in the center of your package and help release any film tension that may occur.

FILM THREADING DIAGRAM



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SEQUENCE OF OPERATION

- 5. Set (Optional) Magnet Time** (5) to approximately $\frac{1}{2}$ to $\frac{3}{4}$ seconds. The sealing timer controls the length of time the magnets stay down in the sealing position.
- 6. Set Sealing Timer** (6) to approximately $\frac{1}{2}$ or .5 seconds. The Band Seal Technology seals very quickly with either PVC or Polyolefin shrink films. Use only enough Sealing Time to seal and cut film – no longer – otherwise overheating of Band Ribbon and Films will occur. **Note: Increasing seal time will increase band ribbon temperature, for thicker films you may need to run seal time longer.**
- 7. Set (Optional) Conveyor Time** (7) just enough to transfer product into shrink tunnel. If you are running a very small product, set conveyor time just long enough to move package out of immediate seal area and allow it to transfer into tunnel on the next cycle. This will allow you to speed up the operation of machine.

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SEQUENCE OF OPERATION

- A. Product is placed on the film separator tray.
- B. The product tray functions as a means to separate the film, allowing placement of product between upper and lower portions of the film.
- C. Move product into seal head area by pushing the product to the left.
- D. Manually pull the seal head down. As the seal head meets the lower seal pad, the machine automatically activates the band ribbon. The **optional** magnet hold down timer is activated, automatically holding seal bar down during seal cycle. Timer is adjustable from one to six seconds.
- E. Take-away Conveyor Unit **Optional**. Once the seal is completed, the seal head automatically releases and the take-away conveyor begins to run. It is adjustable from one (1) to six (6) seconds. The timer is located on the front of the machine.

NOTE: If too much tension is on the film while the bag is being made, the seals will, more than likely, be weak or will "blow out" in the seal area while passing through the shrink tunnel. Make sure to relax the film tension prior to sealing.

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SEQUENCE OF OPERATION

1. After completion of basic setup as described on pages 17-23 plug the sealer's cord into the power source.



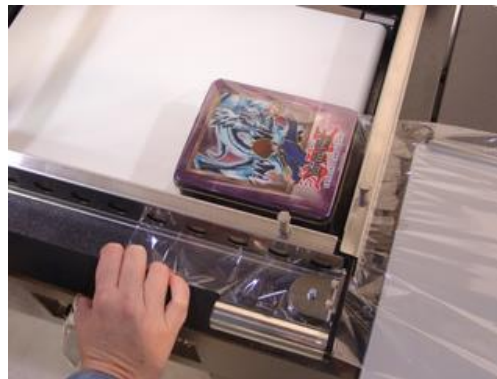
- A. With film threaded, (see instructions for mounting film) place right hand on package and slide product into the upper left hand corner of the film (i.e. corner formed by folded rear edge of film and previously sealed left edge of film), pushing the package up against the ½" high package stop at rear of product loading tray.



- B. Place **right hand** under top sheet of film and on front right corner of product. Place **left hand** on tail of both sheets of film. Now push the package with right hand and pull the film with left hand moving package and film

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into lower right corner of seal area. Allow from ½" to 1" of extra film around package. This will allow some slack film between the package and the sealing bars, reducing film tension.



- C. Press sealing handle down. **Applying pressure to produce seal.** Hold the sealing head down for the duration of the time set on the seal timer, release seal bar when **Red Impulse Light** goes out. If film will not cut off, incrementally increase pulse timer until desired result is achieved.



- D. If you have the **OPTIONAL MAGNETIC Hold Down** operator should simply bring seal head down to contact magnets and immediately release pressure. Magnet timer will engage holding seal arm down for duration of seal

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time. Seal head will automatically release to up position. Magnet hold down time should be slightly longer than pulse time.



- E. The operator may then load the next package onto the product tray, thus speeding up the sealing operation.



- F. Product transfers manually via operator or automatically with **Optional Power Discharge Conveyor** through shrink tunnel. Refer to Tunnel Control setup on page 26 until desired package appearance is achieved.
- G. If you have the **optional Power Discharge Conveyor**, once the seal timer releases the magnets, the Power Conveyor will automatically transfer the product into the tunnel.

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TROUBLESHOOTING – L-Bar Sealer

The following guidelines are provided to aid in determining the source of any operation difficulties that may develop. In performing the tests and checks which follow, carefully inspect for any loose components, broken or loose wires, poor electrical connections, etc., while testing the various switches, controls, relays, transformers, etc. For checking electrical problems, use a voltage meter.

Note: While troubleshooting use caution to avoid danger of electrical shock. When power is not required for checking for the presence or value of voltages used, always have it disconnected.

DISCONNECT ALL POWER BEFORE MAKING ANY REPAIRS.

REFER TO ELECTRICAL BOARD LAYOUT AND ELECTRICAL SCHEMATIC FOR LOCATION OF ELECTRICAL COMPONENTS

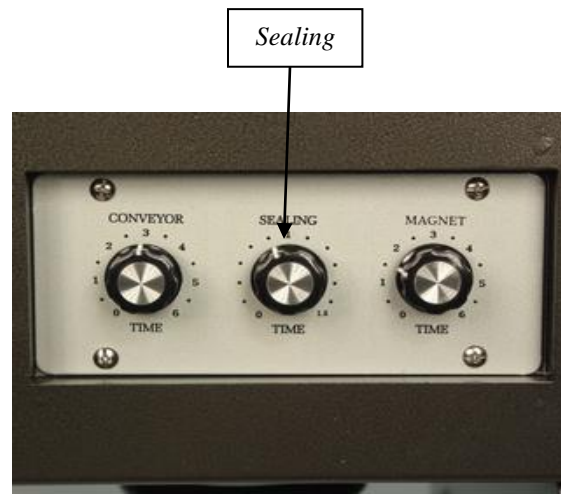
NO HEAT TO BAND RIBBON

Power Switch
OFF Position

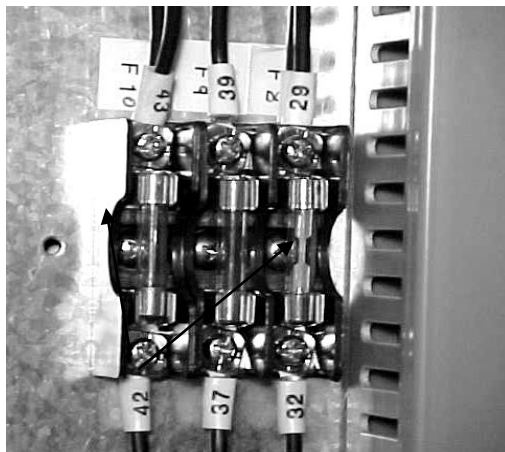


1. Check that the sealer is plugged in and that power is present at the socket. Make sure the power switch is in the **ON** position.

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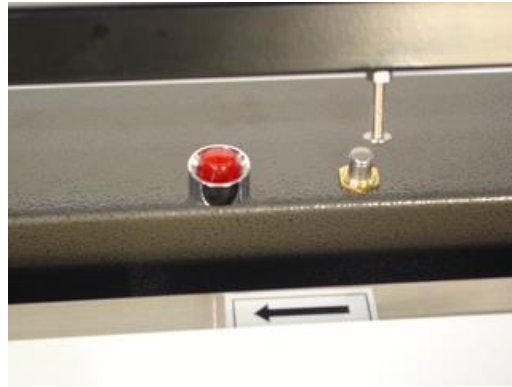


2. Make sure Sealing Timer is **not** set on zero (0).

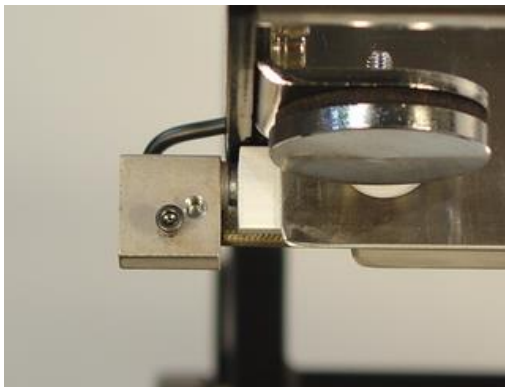


3. **Open top cover and check the fuse F8, 10 AMP wires #29 and 32, is not burned or that the band ribbon is not loose inside the compensators.**

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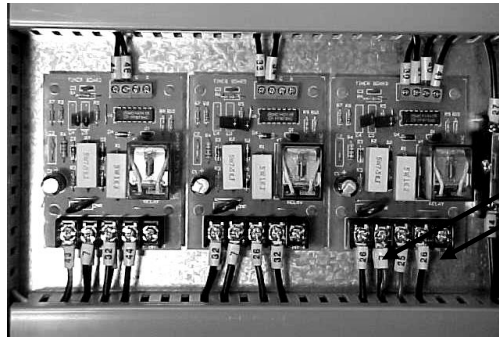


4. **Check Band pulse switch adjustment.**
 - (a) Make sure switch is being activated when the seal bar is within $\frac{1}{4}$ " of contact with band ribbon.
 - (b) Press switch by hand – if no click is heard, replace switch.



5. Check the connections at the end of each compensator of the band ribbon for loose or broken wires.
Make sure wires 7 and 25 are connected to each end of the band ribbon compensator.

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TR1. Wires 7 and 26.

6. Check Pulse Timer at TR1, wires 7 and 26.



7. Check for voltage present at primary and secondary of transformer T1 as per values shown in the voltage specifications.
8. Check main power switch to determine if damaged or broken.

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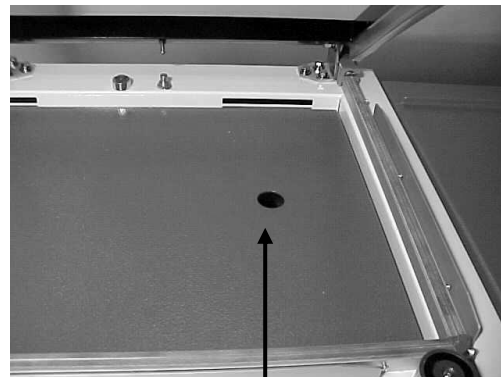
WEAK SEALS AND/OR POOR FILM CUT-OFF



1. Improper seal time – increase seal time.



Relax Film Before Sealing



Lower Product Tray to Center Package in Seal

2. Improper operating technique. Too much film tension-making sure film is relaxed prior to sealing. Make sure product tray is lowered so package is in center of seal bed.
3. Check Band Ribbon to see if cleaning or replacement is necessary.
4. Burned PTFE tapes ½" 10 mill or 2" 3 mill replace. If PTFE tapes become burned or worn, weak seal may occur. See page 75 for Replacement Instructions.

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5. Wavy silicone rubber sealing pad. Replace.
6. Hold down pressure uneven or incorrect on magnets.

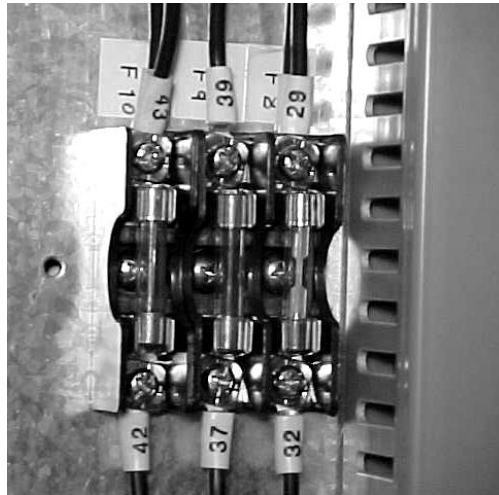


- a. When seal bar is lowered, the gap between the lower magnet and the upper magnet clamp should be 1/8".

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OPTIONAL CONVEYOR – WILL NOT RUN

F8 -- 20 AMP
 F9 -- 2 AMP
 F10 -- 1 AMP



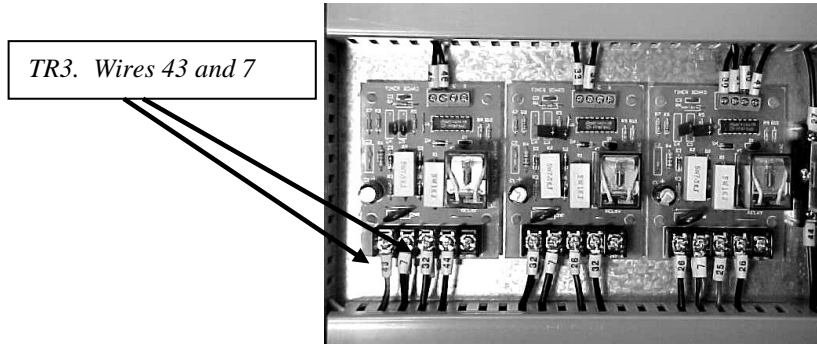
1. Check conveyor Fuse F10, 1 AMP, wires 42 and 43, replace if burned.
 - (a) Check main fuse F8, 20 AMP, wires 29 and 32.

Not set at zero.



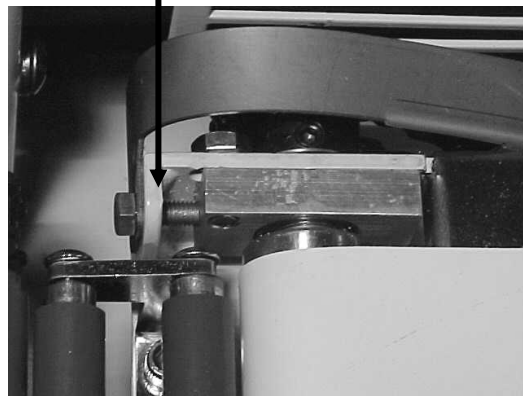
2. Check **optional** conveyor timer. Make sure it is not set at zero.

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3. Check **optional** conveyor timer at TR3 wires 7 and 43.

Drive Roller Adjustment Screw



4. Check **optional** conveyor belt and make sure it is not adjusted too tightly. Adjust conveyor belt using Drive Roller Adjustment Screw.

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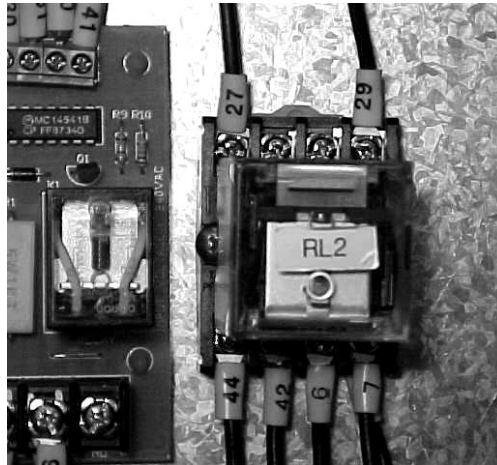
5. Check that conveyor motor sprocket set screws are not loose on shaft.
6. Check that conveyor chain is not jammed or broken.
7. Make sure wires 7, 7, and 43 are connected to the conveyor motor.



Wires 7, 7 and 43 at C2

8. Make sure wires number 7, 7 and 43 are connected to C2 capacitor.

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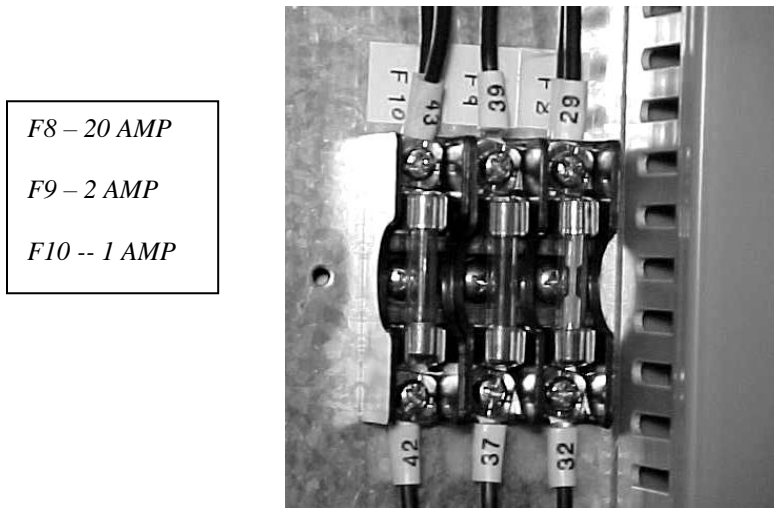
9. Make sure RL2, 110 V relay is secure in relay socket and points are not burnt.

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OPTIONAL MAGNETIC HOLD DOWN



1. Seal head will not stay down – sealer operates normally otherwise.



2. Check magnet Fuse F9, wire 37 and 39. Replace if burned.

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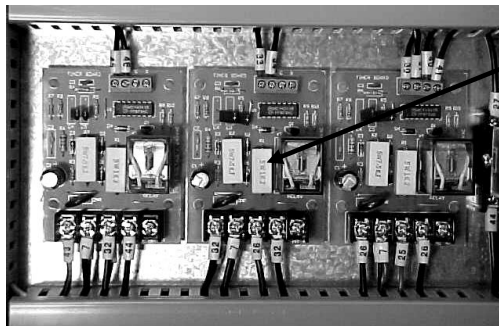


3. Hold-down pressure uneven or incorrect on magnets.
(Optional) See maintenance section, page 78, for proper adjustment.



*Sealing time
not at zero.*

4. Check seal timer (TR2) setting. Make sure it is **not** set at zero.



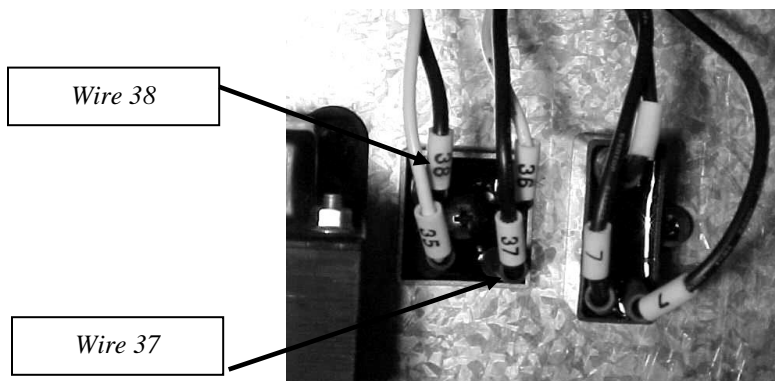
*Magnet Timer,
Center Timer*

5. Check **(optional)** Magnet Timer. Also, check to see if burned or damaged.

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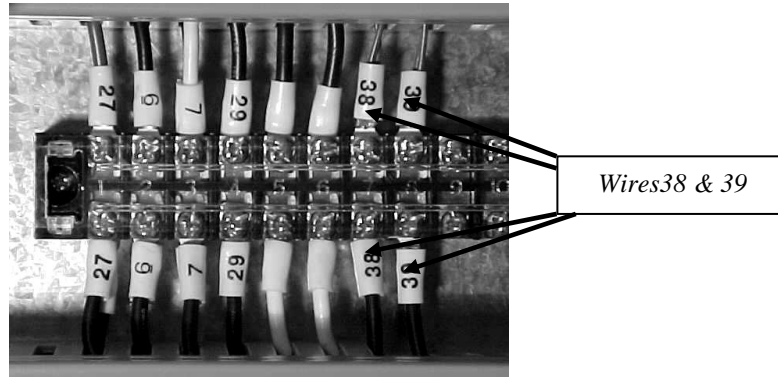


6. Check for 110 Volts (nominal) to primary of transformer (T2) wires 7 and 26.
 - (a) If voltage is present to primary winding of transformer (T1), check for 24 (nominal) volts output from secondary of transformer. Wires 35 and 36.



7. Check for 24 (nominal) volts DC output from + (positive) and – (negative) wires number 38 and 37 on terminals of rectifier. If no DC voltage, replace rectifier.

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8. Check for circuit continuity through windings of hold-down magnets. **Check on terminal strip wires 38 and 39. Disconnect from terminal strip before testing.**

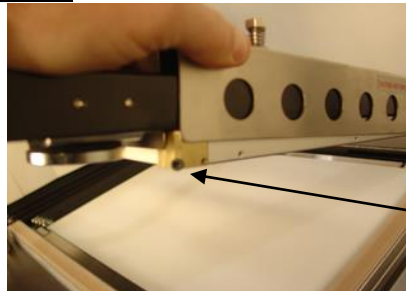
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IF UNSURE OF ANYTHING, CONTACT A QUALIFIED SERVICE TECHNICIAN.

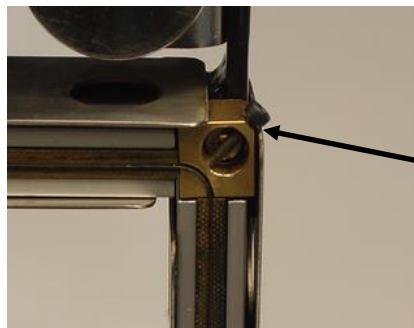
DOUBLE-CHECK ALL OF YOUR WORK BEFORE STARTING THE MACHINE.

MAINTENANCE -- L-Bar Sealer

Replacing Band Ribbon



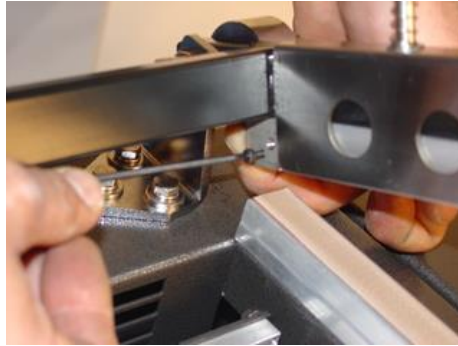
Loosen corner screws



Band Ribbon Corner Screw

- A. Loosen screw holding Band Ribbon in corner.

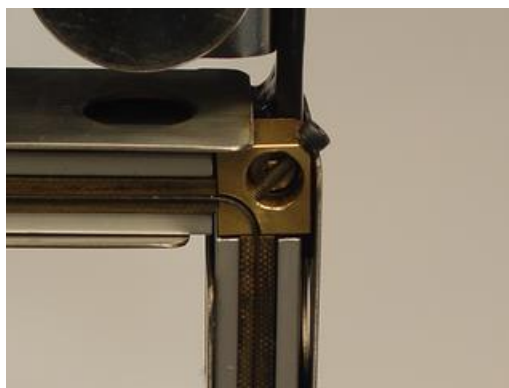
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- B. Loosen screw holding Band Ribbon inside rear compensator assembly.



- C. Loosen screw holding Band Ribbon in front compensator assembly.



- D. Remove old Band Ribbon.

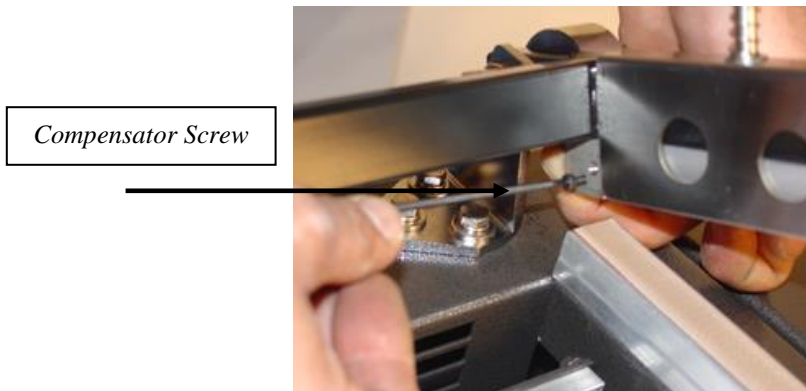
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- E. Use pre-cut Band Ribbon and place piece of PTFE tape $\frac{1}{2}$ "L x $\frac{1}{4}$ "W x 3 mill around corner of new band ribbon. Install Band Ribbon on corner first then insert into each end of front and side compensator. Band Ribbon may be oversized slightly, if so cut to fit ends.

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- F. Compensators are spring loaded. Use screwdriver to push in – flush to transite bars before fastening.

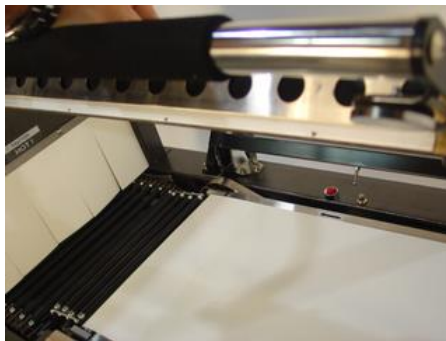


- G. Place other end of band ribbon in slot along front seal area. With band ribbon in slot, use screwdriver to move front compensator forward until band ribbon is inside compensator and compensator is resting against the front seal bar.
- H. Tighten the compensator screw to lock the band ribbon in position.

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Replacing Transite Channels

1. Remove band ribbon



- 2.

Remove the 4 each set screws holding the transite channels into place on the front and side seal bar.

3. Remove old transite channels and replace with new factory parts.

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TAPE REPLACEMENT

The item most subject to wear on the sealer is the PTFE tape used to cover the silicone sponge rubber on the sealing bar. This $\frac{3}{4}$ " x 10 mill tape should never be permitted to burn through. To replace tape, proceed as follows:



1. Strip off old tape.
2. Cut off proper length of new PTFE, peel off backing, and press new tape into position.
3. Apply $\frac{1}{2}$ " x 10 mill PTFE tape over the top of the 2" 3 mill PTFE tape.

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SILICONE RUBBER SEALING PAD REPLACEMENT

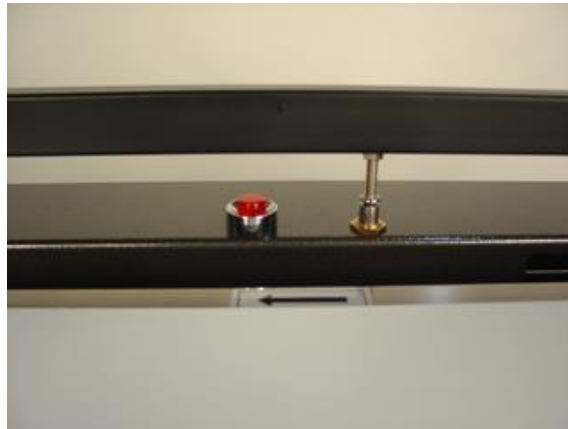
Occasionally it will be necessary to replace the silicone rubber sealing pads. This should be done if the following is noted:

- Gaps in the seal
- Weak seals
- Improper film cut-off
- Excessive sealing pressure required

To replace rubber, proceed as follows:

1. Seal pads are designed with a channel for easy replacement. Pull silicone rubber out of the channel.
2. Replace with new silicone rubber. Press rubber back into channel.
3. Install 3/4" - 10-mil PTFE tape on top of rubber.
4. Install 1/2" - 10 mil PTFE tape over the 3/4" tape.

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Element Pulse Switch Adjustment

The sealing cycle should not begin until the sealing head is within 1/4" or less of the film to be sealed. If the magnets energize before the head is within 1/4" of the film, loosen the lock-nut and turn the screw (located at the rear end of the side seal bar) up slightly (counterclockwise when viewed from above). The correct adjustment has been obtained when the magnets energize just as the seal bar comes into contact with lower pads.

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Optional Adjustment of Magnets for Correct Sealing Pressure

All magnets have been factory adjusted for equal sealing pressure throughout the length of both the front and side seal bars. However, if an adjustment is required, proceed as follows:

1. Disconnect the sealer's power source.

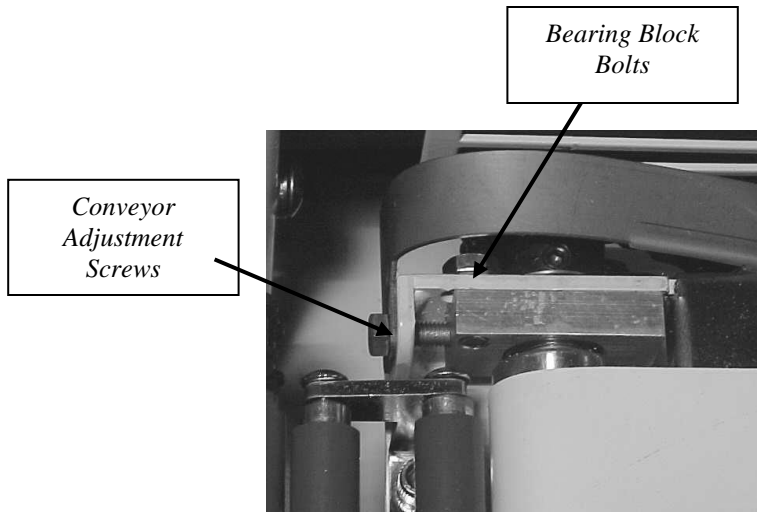


2. Loosen the lower magnet bolts on all lower magnets so that the magnets set to their lowest position in the mounting slots.
3. Lower the sealer's operating handle fully and lift lower magnets to within 1/16" from the holders. Tighten the mounting bolts securely to retain the proper adjustment.

Optional Conveyor

From time to time, it will be necessary to disassemble the conveyor as it will need adjustments or replacement of worn parts and general maintenance. The following information is given to assist the operator in that general fashion. If a problem persists, discuss it with an authorized distributor of Sealer Sales or with authorized service personnel.

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- A. Adjust Discharge Conveyor Belt by loosening the Bearing Block Mounting Bolts, then adjust the Conveyor Adjustment Screw in to loosen belt, or out to tighten belt.

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Replacing Conveyor Motor

1. Disconnect power plug from source of power.



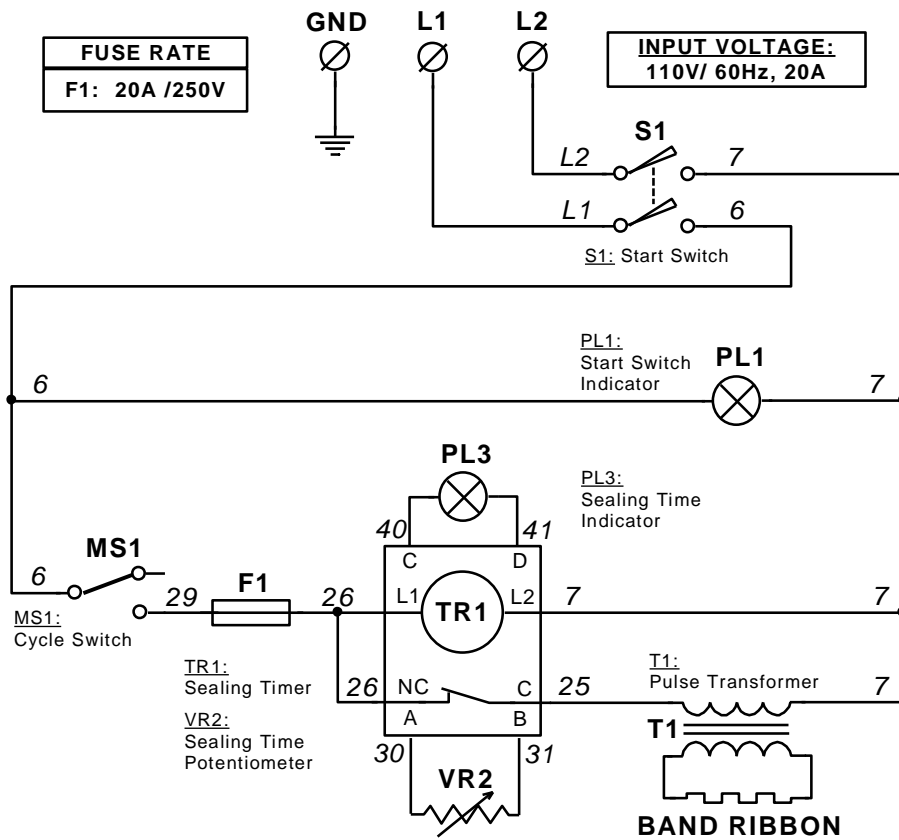
2. Disconnect the three power wires from the rear of the motor.
3. Loosen the four bolts that hold the motor mount bracket to the conveyor and slide motor mount forward.
4. Loosen set screws on sprocket that are attached to the motor and remove sprocket.
5. Remove four bolts. These bolts hold the motor in place. Hold motor while removing these bolts so the motor does not drop.

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ELECTRICAL SCHEMATIC NOTICE!

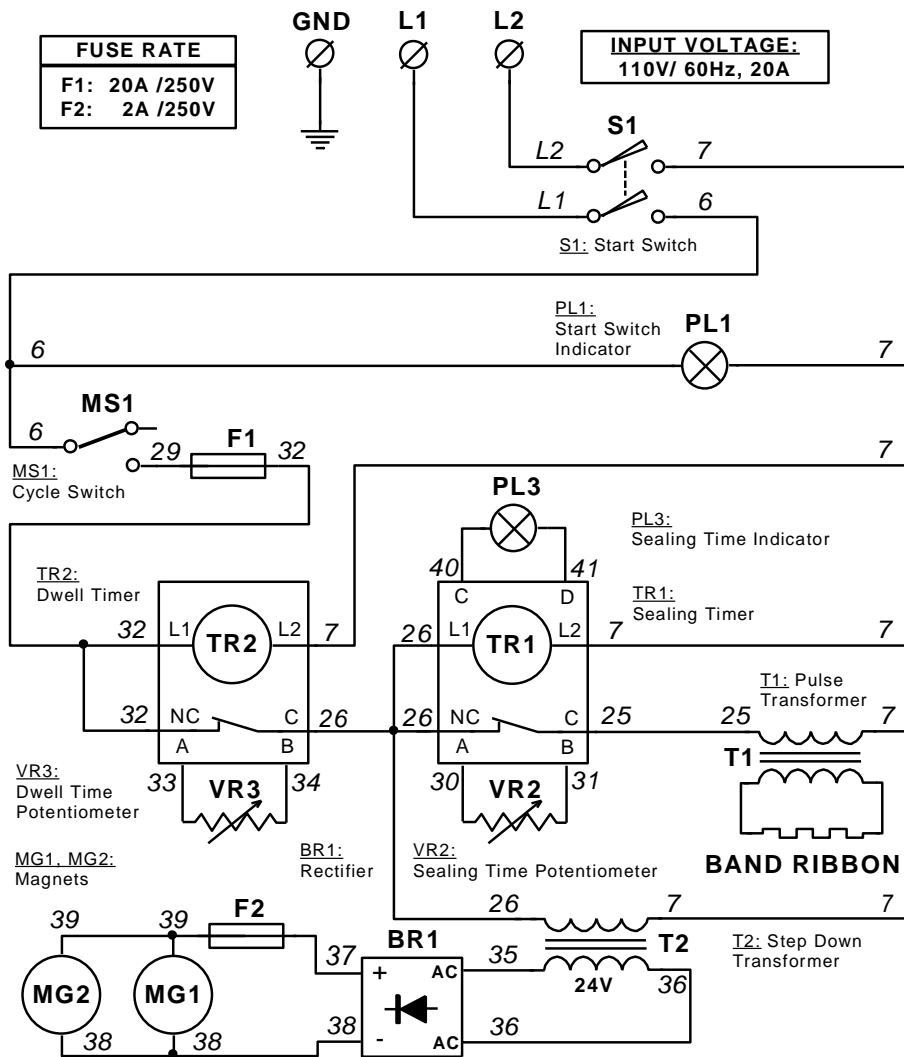
This manual contains wiring schematics for the SS-1519L Series Machines (**3 models**). Please verify your model and use the appropriate wiring schematic and electrical drawing that pertains to your machine.

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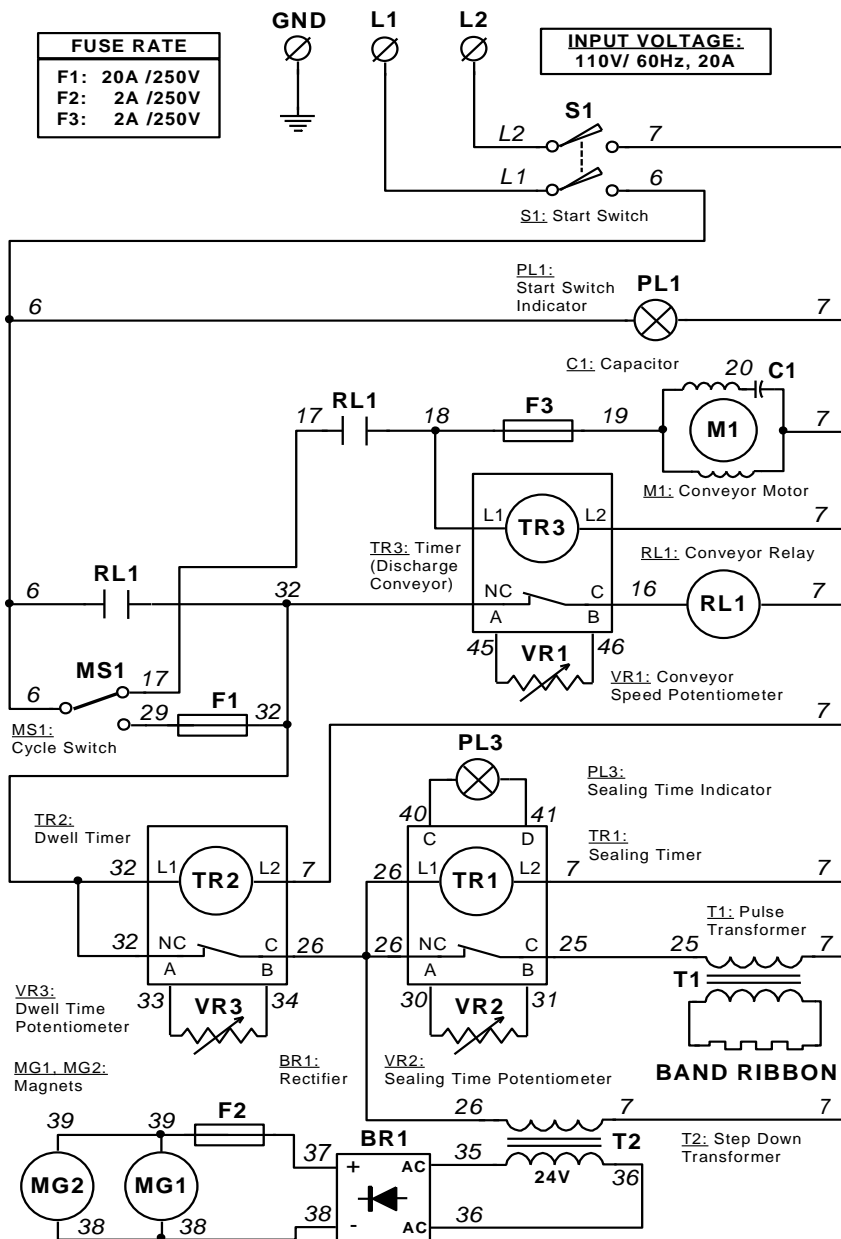
ECONOMY L-SEALER MODEL: SS-1519L (110V)

SS-1519L Series—110 Volt Sealer Service Manual



ECONOMY L-SEALER MODEL: SS-1519LM (110V)

SS-1519L Series—110 Volt Sealer Service Manual



ECONOMY L-SEALER MODEL: SS-1519LMC (110V)

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MODEL SS-1519L SERIES

Item	Part #	Qty	Parts List Nomenclature
ACT	3600-30	1	AC Terminal
C1	3500-02	1	Capacitor – 3 MF 400 VAC
F1	1519-330-110	1	Fuse – 20 AMP, 110V
F2	1519-340-110	1	Fuse – 2 AMP, 110V
MG1/MG2	1519-375	2	Magnets Hold Down (Optional)
PL-1	3600-10-110	1	Pilot Light, 110V
VR-1 2 3	3400-68	3	Potentiometer
LS	3400-47	1	Pulse Limit Switch
T1	1519-380		Pulse Transformer
BR1	1720-19	1	Rectifier (Optional)
RL1	1519-385	1	Relay Switching (110 Volt)
RL2	1519-385	1	Relay – Discharge Conveyor (24 Volt)
EG1	3500-25-110	1	Speed Control AC (PCB1) 110V
T2	1519-425	1	Stepdown Transformer – 110V/24V (Optional)
S1	3600-25	1	Switch-Start
TR3	1519-430	1	Timer – Conveyor 110V—Optional
TR2	1519-430	1	Timer – Magnet 110V—Optional
TR1	1519-430	1	Timer – Sealing 110V

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PP-1519EC 110 VOLT SEALER REPLACEMENT PARTS

Part #	Qty	Description
1519U-701	1	Aluminum "C" Channel- Top-Front 5/8" x 5/8"
1519U-702	1	Aluminum "C" Channel- Top-Side 5/8" x 5/8"
1519U-703	1	Aluminum "C" Channel-Front- Bottom 7/8" x 1/2"
1519U-704	1	Aluminum "C" Channel-Side- Bottom 7/8" x 1/2"
1519U-705	1	Aluminum- Front Bar stock 1" x 3/8"
1519U-706	1	Aluminum-Side Bar stock 1" x 3/8"
1519-013	1	Band Ribbon- 37"
1519-395	1	Belt – Discharge Conveyor
1519-010	2	Blocks – Seal Head Mounting
1519U-028	1	Brass Corner Block
1519U-026	1	Brass Corner Block—Screw
1519-015	4	Casters
1519-400	1	Chain – Discharge Conveyor
1519U-710	2	Compensator Assembly – Complete-Stainless steel
1519U-711	1	Compensator – Screws
1519U-712	1	Compensators – Spring
1519-032	1	Contactoer – 20 AMP, 110V
1519-713	2	Film Roll guides
1519-405	1	Discharge Conveyor Assembly-Complete
1519-714	1	Film Rack – Complete
3400-28	1	Fuse F1, 20 AMP
3500-14	1	Fuse F2, 2 AMP,
3400-32	1	Handle – Crank for Discharge Conveyor
1519-045	1	Head Rear Shaft
1519-046	2	L' Brackets – Seal Bar Mounting Bracket
1519-055	2	Magnets – Upper – Optional
1519-042	2	Magnets coil lower(Optional)
1519-320-110	1	Motor – Discharge Conveyor (Optional)
1519-720	2	Pin Perforator Assembly Complete with Shaft
1519-721	2	Pin Perforator Sponge Wheel
1519-070	2	Pin Perforator Wheels with Pins
1519-385	1	Relay-Discharge Conveyor (RL-2)
1519-390-110	1	Relay-Switching (RL-1 110 Volt)
1519-722	1	Roller – Film Rack Idler Roller

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Part #	Qty	Description
1519U-723	1	Seal Bar – Complete Assembly
3450-15	1	Seal Pad Sponge Rubber – Bottom
1519-130	1	Speed Potentiometer – Conveyor
3440-22	1	Sponge – Handle
1519-420	4	Sprockets – Conveyor Adjustment, Up and Down
1519-185	1	Sprocket – Conveyor Drive Shaft
1519-190	1	Sprocket – Conveyor Motor
3400-47	1	Switch – Impulse
100002	2	PTFE Tape—1/2" x 10 yards x 10 mill (Upper)
100003	1	3/4" 10 yd x 10 mil PTFE tape
1519-022	1	PTFE Insert/Insulator
1519-150	1	Terminal Strip
3400-77-110	3	Timer – Seal, Magnet or Conveyor
1519-3060	1	Torsion Bar
1519-325-110	1	Transformer – Pulse, 110V
1524-27-110	1	Transformer – Stepdown 110V to 24V – Optional
1519U-724	1	Transite channel –front top
1519U-725	1	Transite channel – side top
1519-165	1	Tray – Product Discharge
1519-075	1	Tray – Product Separator

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Spare Parts List

Item #	Part #	Description	Qty.	Price
1	1519-013	Band Ribbon	2	
2	1519U-028	Corner Block	1	
2	1519-332-110	Fuse – 20 Amp	2	
3	1519-335-110	Fuse - 2 Amp	2	
8	100002	½"x10 mill x 10yd PTFE Tape	1	
9	100003	¾" X 10yd x 10mill	1	
10	3450-15	Seal Pad Rubber-Bottom	10ft	
11	1519U-724	Transite channel – Front	1	
12	1519U-725	Transite channel – Side	1	
Total Cost				\$Call