



Table-Top Direct Heat Sealers
Models: W-300DAT, W-300DATS

Distributed By:

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Printed in the United States of America

General Information

Thank you for purchasing our W-Series Direct Heat 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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WHDH EQUIPMENT INFORMATION

❖ Model #

❖ Serial #

❖ Purchase Date:

❖ Reference # (found on packing slip)

❖ Owner:

Safety Instructions



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.
- ❖ 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 sealing bars with your bare hands 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.
- ❖ 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

W-Series Direct Heat Sealers are designed for sealing many different types of thermoplastic materials including: coated aluminum foil, Kraft paper, cellophane, polypropylene, poly-nylon, and other thicker materials up to 20mil in total thickness. Please note that our direct heat sealers would not be appropriate for sealing polyethylene and/or polyvinyl chloride.

Features of the W-Series Direct Heat Sealers

Your Direct Heat sealer is equipped with a wide range of standard features and capabilities.

- ❖ Direct heat sealing / constant heat sealing system
- ❖ Heavy duty all metal construction
- ❖ Table top design supported with anti-slip rubber feet
- ❖ Simple to use - minimal operator training
- ❖ German manufactured temperature controller that maintains the seal bars at a proper temperature providing consistent seal quality
- ❖ Electronic timer (0-6 seconds) to adjust sealing time providing for consistent seal quality
- ❖ Equipped with protector bars around the sealing bars to prevent injury
- ❖ Hands free sealing activated by footswitch
- ❖ Sealing width: 1/2" (15mm)
- ❖ Sealing length: 12" (300mm)
- ❖ Adjustable work table
- ❖ Options: meshed (W-300DAT) or serrated (W-300DATS) sealing bars

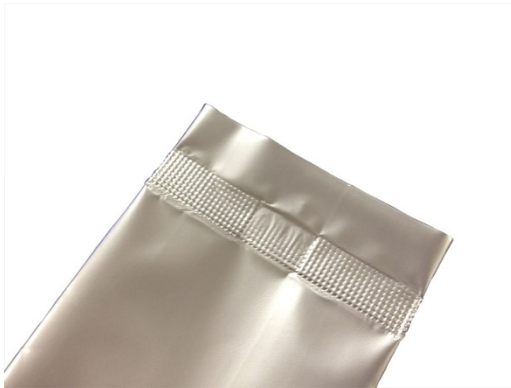


Figure 1. Meshed seal line



Figure 2. Serrated seal line

How Do W-Series Direct Heat Work?

Basic

Principles

Place material on lower sealing bar. Activate foot switch to bring upper seal bar down.

Our W-Series direct heat sealers maintain constant heat in both sealing jaws. Direct heat sealers consume power as long as the sealers remain on thus providing better heat penetration than impulse sealers. The temperature and length of the seal time will depend on the characteristics of the bag being sealed. The sealing process is simple: The operator places material on lower sealing bar of sealer and activates foot

switch to bring the upper sealing bar down. Upper sealing bar will release automatically based on timer settings.

Specifications

	W-300DAT	W-300DATS
Power	110V/60Hz	110V/60Hz
Watts	350W	350W
Seal Width	15mm	15mm
Sealing Length	12"	12"
Seal Type	Meshed	Serrated
Temperature Range	0°C-300°C	0°C-300°C
Dimensions	13" x 14" x 7"	13" x 14" x 7"
Shipping Dimensions	17" x 15" x 16"	17" x 15" x 16"
Net Weight	33lbs	33lbs
Gross Weight	38lbs	38lbs

Getting to Know your Direct Heat Sealer

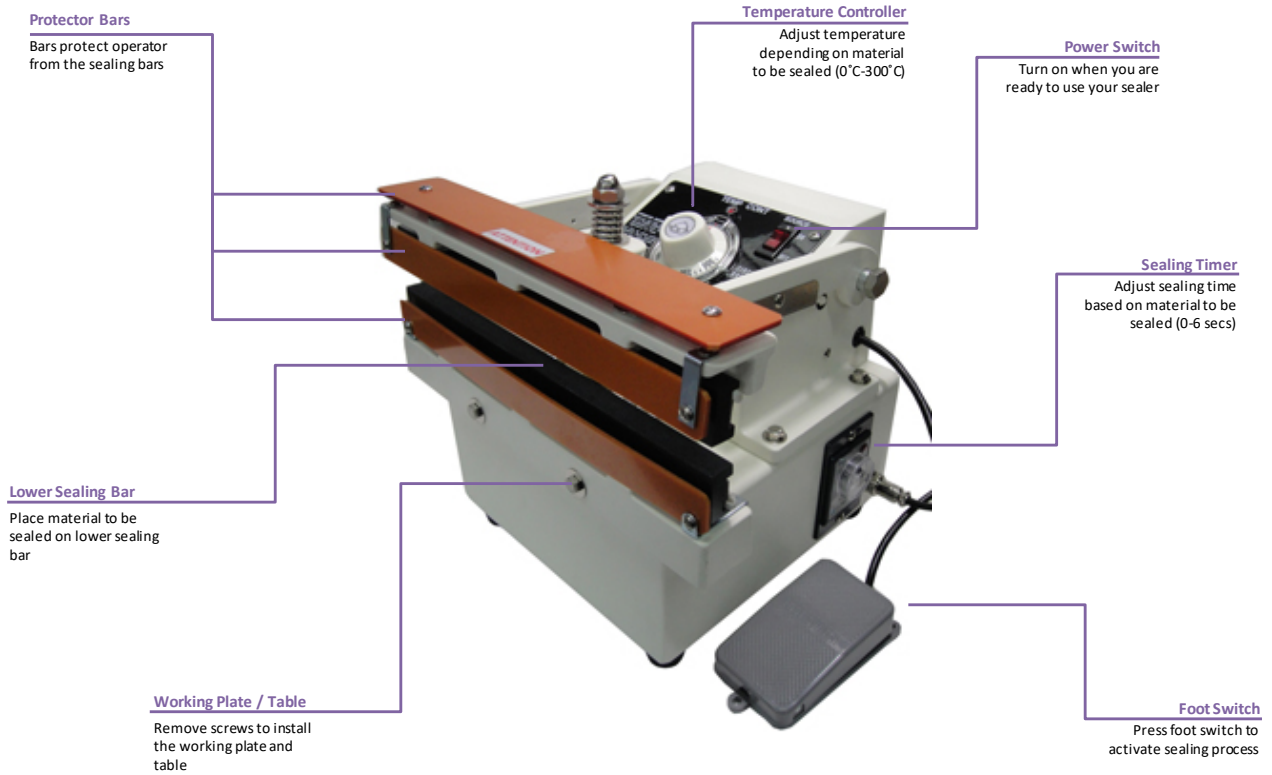


Figure 3. W-Series Table Top Direct Heat Sealer Overview

Electrical Circuit Diagram

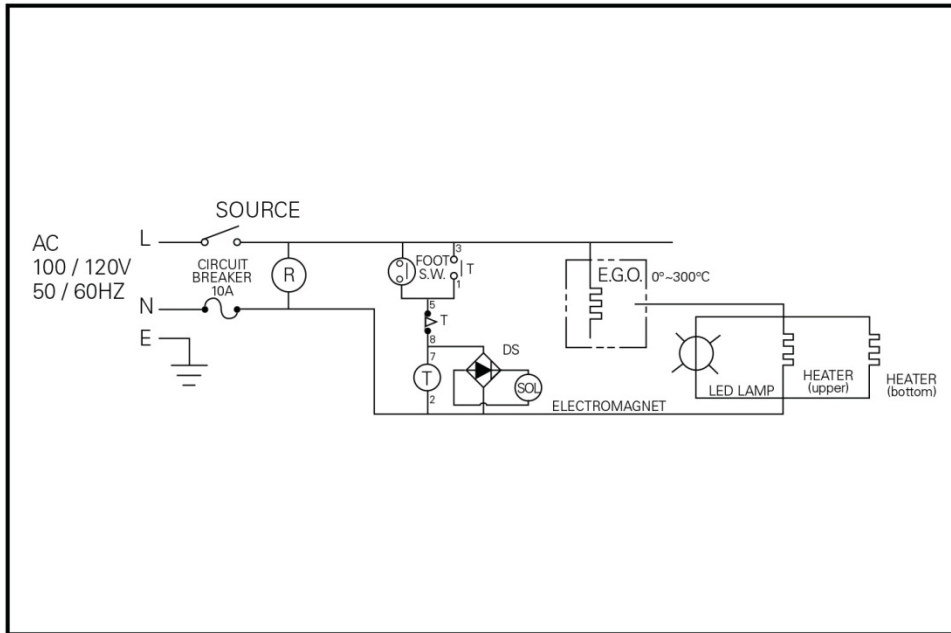


Figure 4. Electrical Circuit Diagram for W-Series Direct Heat Sealers

Operating your Sealer

Assembly Instructions

1. Connect the footswitch to the sealer unit.
2. To install the optional working plate and table, remove screws located at the front of the unit and install the working plate. Adjust working table height to your bag specifications.



Figure 5. Working Plate and Table Installation

Operation



1. Before operating, check for any worn parts of the sealer. Make sure the sealing bars are clean and without residue.
2. Insert the power cord into the correct receptacle (110V).
3. Turn the power switch on.
4. Set the sealing temperature on the temperature controller depending on the material to be sealed. *(Note: Temperature on the dial is Celsius, not Fahrenheit.) Always start with a lower temperature setting and gradually increase the temperature as needed.* Allow 5-10 minutes for the sealer to reach the set temperature. The light above the temperature controller will turn off when the unit has reached the set temperature.
5. Set the timer setting for the length of the sealing time. Adjust seal time as needed based on material to be sealed and temperature set on the temperature controller.
6. Place material to be sealed on the lower sealing jaw and press the footswitch to activate the sealing process. The upper sealing bar will release once seal time is achieved.

7. When sealer is not in use, turn off the power switch.



Please note: Sealing bars will be extremely hot. Do not touch the sealing bars as this could cause severe burns.

Tips for Successful Sealing

1. If the seal is broken or damaged, decrease the sealing time / temperature.
2. If the seal is not fully welded, increase the sealing time / temperature.
3. If the sealing material sticks to the sealing bars, decrease the sealing time / temperature.
4. Always keep the sealer clean. Remove any residue found on the sealing bars. Silicone spray may be used.



5. 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 W-Series Direct Heat Sealer.

Inspection and Cleaning

1. Inspect your machine daily.
2. Make sure the unit is not left on when not in use. Never leave unit on overnight. This will shorten the life of the parts.
3. Find the lowest temperature that will still seal the bag.
4. Use a clean cloth to remove any plastic residue remaining on the sealing bars. We recommend using silicone spray to clean. Spray the silicone spray onto a shop cloth or toothbrush. Wipe down the sealer when the sealer is turned off and cool to touch. Never spray the silicone spray directly on the unit.

Replacement Parts



Before changing any parts, turn off and unplug sealer.

Please make sure parts purchased are from an authorized distributor of W-Series sealing equipment.

Replacing Heater (s)

Our W-Series Direct Heat Foot Sealers will require new heaters from time to time. There are two heaters found on the unit, one in the upper sealing jaw and one in the lower sealing jaw. We suggest marking down the exact locations of the connections in order to accurately replace the new heaters. Before changing any parts, turn off and unplug sealer.

To remove the heaters:

1. Remove the brackets in the upper and lower jaw that are holding the heaters in place.



Figure 6. Remove the brackets holding the upper heater



Figure 7. Remove the brackets holding the lower heater

2. Loosen the screws on the sealer jaws in order to remove the heaters.
3. Remove the thermostat plate to access the other end of the heater.



Figure 8. Loosen screws found on sealing jaw

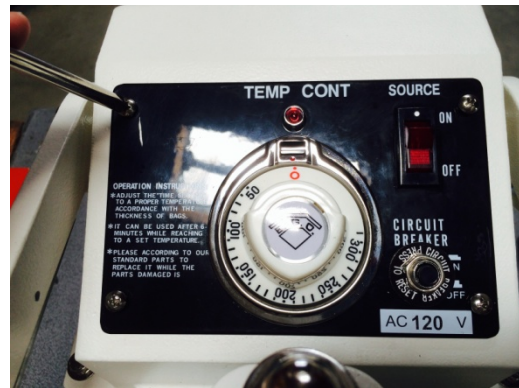


Figure 9. Remove thermostat plate

4. On the back of the unit, right side heaters are connected to the circuit breaker and the left side heaters are connected to the temperature controller. Separate the heaters from their respective connections.

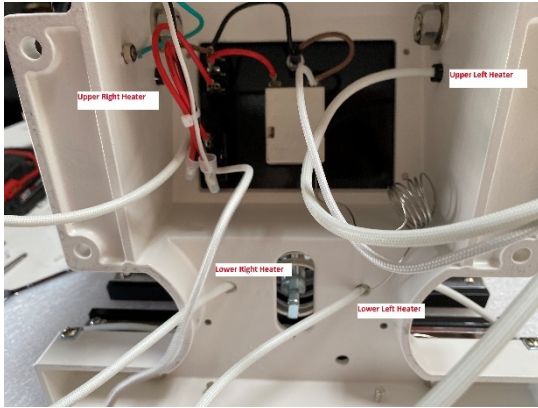


Figure 10. Heater locations from back of unit



Figure 11. Separate the heaters

Once the old heaters have been removed, replace with new heaters.

1. The temperature controller sensor is located on the lower jaw. Do not remove the sensor when a new heater is installed. Please note there is a groove on the lower jaw where the sensor should remain.



Figure 12. Keep sensor in its place in the lower jaw



Figure 13. Install lower heater over the sensor

2. Replace the washer, nut and screws on the lower heater.
3. Repeat the steps for the upper heater.
4. Replace the insulation on the new heaters.
5. Thread the heaters through the base/lower jaw of the sealer.

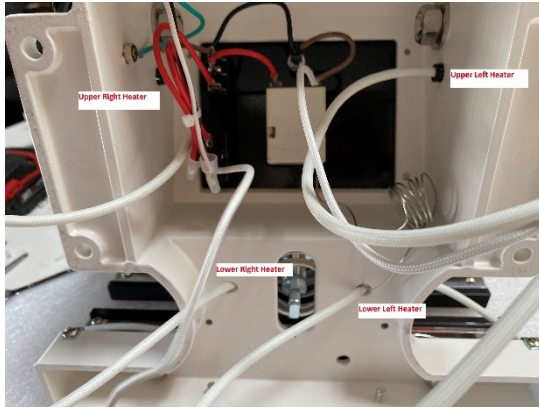


Figure 14. Heater locations from back of unit

6. Connect the wires of the left side heaters to the temperature controller. You may need to strip the temperature controller wire first then tightly crimp the wires from the heaters to the temperature controller wire.
7. Connect the wires of the right side heaters to the circuit breaker.
8. Replace the brackets.



Figure 15. Replace upper bracket keeping upper heater in place



Figure 16. Replace lower bracket keeping lower heater in place

Replacing Thermostat

1. To remove the thermostat, remove the thermostat cap and four screws from the thermostat control plate. Then, remove the two screws attaching the thermostat plate to the control panel.



Figure 17. Remove thermostat cap



Figure 18. Remove two screws attaching thermostat plate to the control panel

2. Unplug the two connections from the thermostat base.
3. Unscrew the heaters from the bottom sealing jaw in order to remove the thermostat sensor from the sealing jaw. Note: In order to fully remove and install the thermostat, one may also need to separate the head of the sealer from the base.

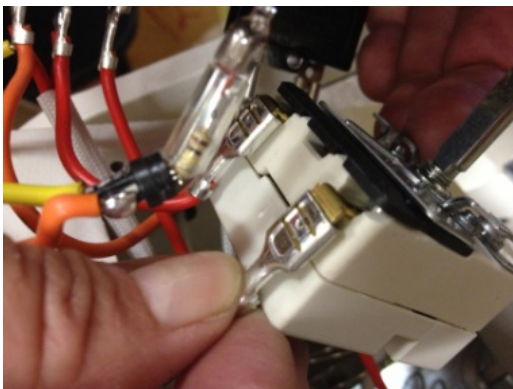


Figure 19. Unplug two connections from thermostat base found inside sealer head

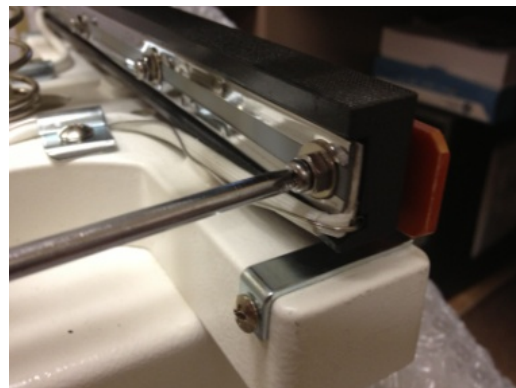


Figure 20. Unscrew heaters from bottom sealing jaw

Replacing Timer

1. Unscrew the two screws found on the timer. Remove the timer from the base of the sealer.
2. Unplug the timer and replace with new timer.



Figure 21. Remove the old timer

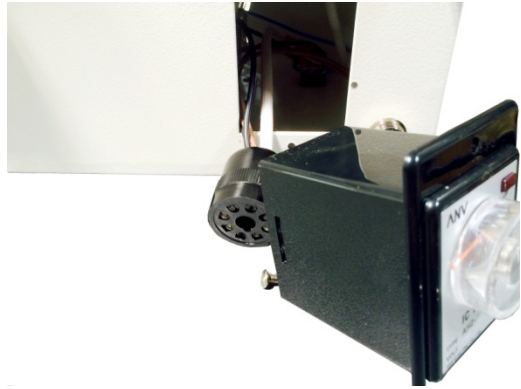


Figure 22. Replace with new timer

Parts Diagram

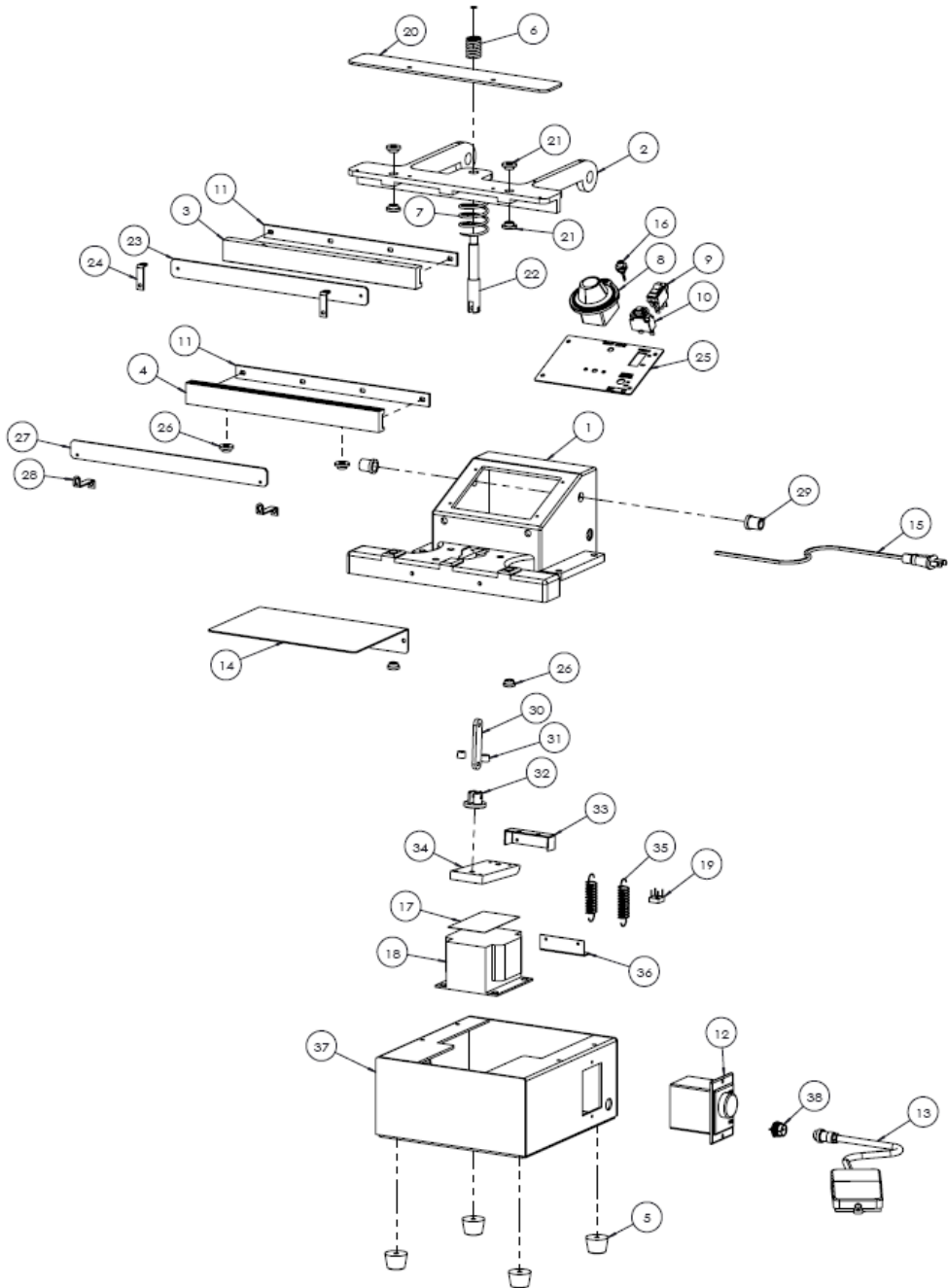


Figure 23. Spare Parts Diagram Overview

Item	Part #	Description	Comments
1	WHDH-1	Control Set Bracket	
1a	WHDH-1a	Bolt/Washer to attach control unit to body M6x25	
2	WHDH-2	Upper Bracket/Jaw (same as W-300T, but with holes)	
2a	WHDH-2a	Bolt and Washer for attaching the Upper Jaw/ Lower Jaw to the Seal Bar M6 x 30	
2b	WHDH-2b	Bolts (Washer and Nuts) to attach Upper Jaw to Control Unit	
	WHDH-1/2	Control Set Bracket (#1) and Upper Jaw (#2) and accompanying screws	
3		Upper PTFE Coated Seal Bar	sold as pair only - WHDH-3A / 3B
4		Lower PTFE Coated Seal Bar	sold as pair only - WHDH-3A / 3B
3A	WHDH-3A	PTFE Coated Sealing Bar, Pair, Meshed	
3B	WHDH-3B	PTFE Coated Sealing Bar, Pair Coated, Serrated	
5	WHDH-5	Rubber Foot	
6	WHDH-6	Pressing Spring, Small W-00403	
7	W-300T-12	Pressing Spring, Large (W-300T and W-300DAT)	
8	TMC-WHDH	Thermostats (E.G.O) E-010	
9	WHLH-7	Power Switch, 3P, 15A/125V (W-Series)	
10	WHI-11B	Circuit Breaker, 10A	
11	WHDH-11	Heater Element, 1 piece E-92302	
		Heater/Element, 2piece Set	
11b	WHDH-11B	Screw for Attaching the Heater to the Seal Bar	
12	T-W300DAT/S	Timer Set SH2-Y(6S) E-009A	
13	FS-WH	Foot Switch, 6.5 feet E-011	
13a	MSWF-WH	Microswitch for Foot Switch	
14	WHDH-14A	Working Table - 9" x 5.5"	
	WHDH-14B	Working Adjusting Plate	
15	PWC-WH	Power Cord	
16	WHDH-16	Lamp (R), LED for E.G.O. E-00302 for (W-Series)	
17	WHDH-17	Fiber Plate	
18	WHA-38	Solenoid (Electromagnet) TF-281 (2 for AA models)	
19	WHDH-19	Rectifier DCBR68	
20	WHDH-20	Protector Bar / Isolated Plate / Top of Upper Seal Bar (old #22) - 12 1/4" x 2"	
20a	WHDH-20a	Support for Protector Bar	
20b	WHDH-20b	Screw for Upside Protector Bar	
21	WHDH-21	Silicone Washer (big)	
22	WHDH-22	Shaft of Pole	
23	WHDH-23	Protector Bar / Isolated Plate / Upper Sealing Bar (old #22B) - 12" x 1" (holes - 1/2")	
23a	WHDH-23a	Screw for Bracket for Protector Bar/Isolated Plate Lower Bar & Upper Bar 4/set	
24	WHDH-24	Fixed Plate (upside) / Protector Bar Bracket	
25	WHDH-25	Control Panel	
26	WHDH-26	Silicone Washer (small)	
27	WHDH-27	Protector Bar / Isolated Plate / Lower Sealing Bar (old #22A) - 12" x 1" (holes - 1/8")	
28	WHDH-28	Fixed Plate (downside) / Protector Bar Bracket	
29	WHDH-29	Bushing (Upper Bracket)	
30	WHDH-30	Connected Plate / Shaft Plate	
31	WHDH-31	Rubber Foot w/ Screw and Nut	
32	WHDH-32	Fixed Bracket (spring)	
33	WHDH-33	Upper Bracket (Tension Spring)	
34	WHDH-34	Sucking Plate	
35	WHDH-35	Tension Spring	
36	WHDH-36	Bottom Bracket (Tension Spring)	
30-36	WHDH-30-36	Tension Shaft Unit (Parts #30-#36)	
37	WHDH-37	Base	
38	WHDH-38	Joint (Foot Switch)	
39	Screw-M4x8	M4*8 Screw	

Figure 24. Spare Parts Diagram List

Troubleshooting

Problem	Possible Causes	Solution
Upper and/or lower sealing bars not heating	1. Heater(s) are worn out.	1. Replace heaters(s) on the unit.
Unit does not heat up (both jaws are not heating up)	1. Heater(s) are worn out. 2. Temperature controller is worn out.	1. Replace heaters(s) on the unit. 2. Replace temperature controller
Temperature controller will not stay at set temperature (i.e. temperature set at 150 but temperature keeps going up)	1. Temperature controller is worn out. 2. Thermocouple is worn out (rare occasion).	1. Replace temperature controller. 2. Replace thermocouple.
Sealing jaw not activating	1. No power to the unit. 2. Timer is worn out. 3. Solenoid needs replacement. 4. Footswitch needs replacement.	1. Check power source. 2. Replace timer. 3. Replace solenoid. 4. Replace footswitch.