



Double Impulse Foot Sealers  
Model: W-300T, W-450T, W-600T

**Distributed By:**

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# General Information

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Thank you for purchasing our W-Series Double Impulse 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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## WHDF EQUIPMENT INFORMATION

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❖ Model #

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❖ Serial #

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❖ Purchase Date:

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❖ Reference # (found on packing slip)

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❖ Owner:

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# Safety Instructions

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

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

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



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

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

# Introduction

W-Series double impulse foot sealers are ideal for high volume poly bag and other thermoplastic sealing. Equipped with top and bottom heating elements, our double impulse sealers can seal thicker thermoplastic materials up to 20mil in total thickness. Single/double sealing switch selector provides the sealer with the flexibility to seal different types of materials. The sealer allows you to keep both hands free for quicker and more accurate sealing.

## Features of the W-Series Double Impulse 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
- ❖ Single or double sealing switch selector
- ❖ Heavy duty all metal construction
- ❖ Sits on rectangular stand for stability
- ❖ Adjustable work table height
- ❖ Optional: Taller stand and tension rod available adding 10" height
- ❖ Manufacturer spare parts kit includes: 2 heating elements

## How Do W-Series Double Impulse Foot Sealers Work?

### Basic

#### Principles

Place material on lower jaw and activate footboard

Our W-Series double impulse foot 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. Our W-Series double impulse sealers utilize twin heating element wires, one on the upper sealing jaw and one on the bottom sealing jaw providing greater heat penetration for sealing through thicker materials (up to 20mil total thickness).

## Specifications

	W-300T	W-450T	W-600T
Power	110V/60Hz	110V/60Hz	110V/60Hz
Watts	1000W	1900W	2800W
Sealing Length / Width	11.8" / 5mm	17.6" / 5mm	23.4" / 5mm
Standing Height	33 1/2"	33 1/2"	33 1/2"
Working Table Dimensions	12" x 6"	12" x 6"	12" x 6"
Tray Adjustment Height	Up to 6.5"	Up to 6.5"	Up to 6.5"
Throat Depth	1 1/2"	1 1/2"	1 1/2"
Dimensions	13" x 14" x 34"	21" x 14" x 34"	26 1/4" x 14" x 34"
Shipping Dimensions	21" x 20" x 12" 38" x 19" x 10"	26" x 20" x 12" 38" x 19" x 10"	33" x 20" x 12" 38" x 19" x 10"
Gross Weight	34lbs / 29lbs	45lbs / 29lbs	49lbs / 29lbs

# Getting to Know your Foot Sealer

W-Series Double Impulse Foot Sealers are simple and efficient sealing machines.

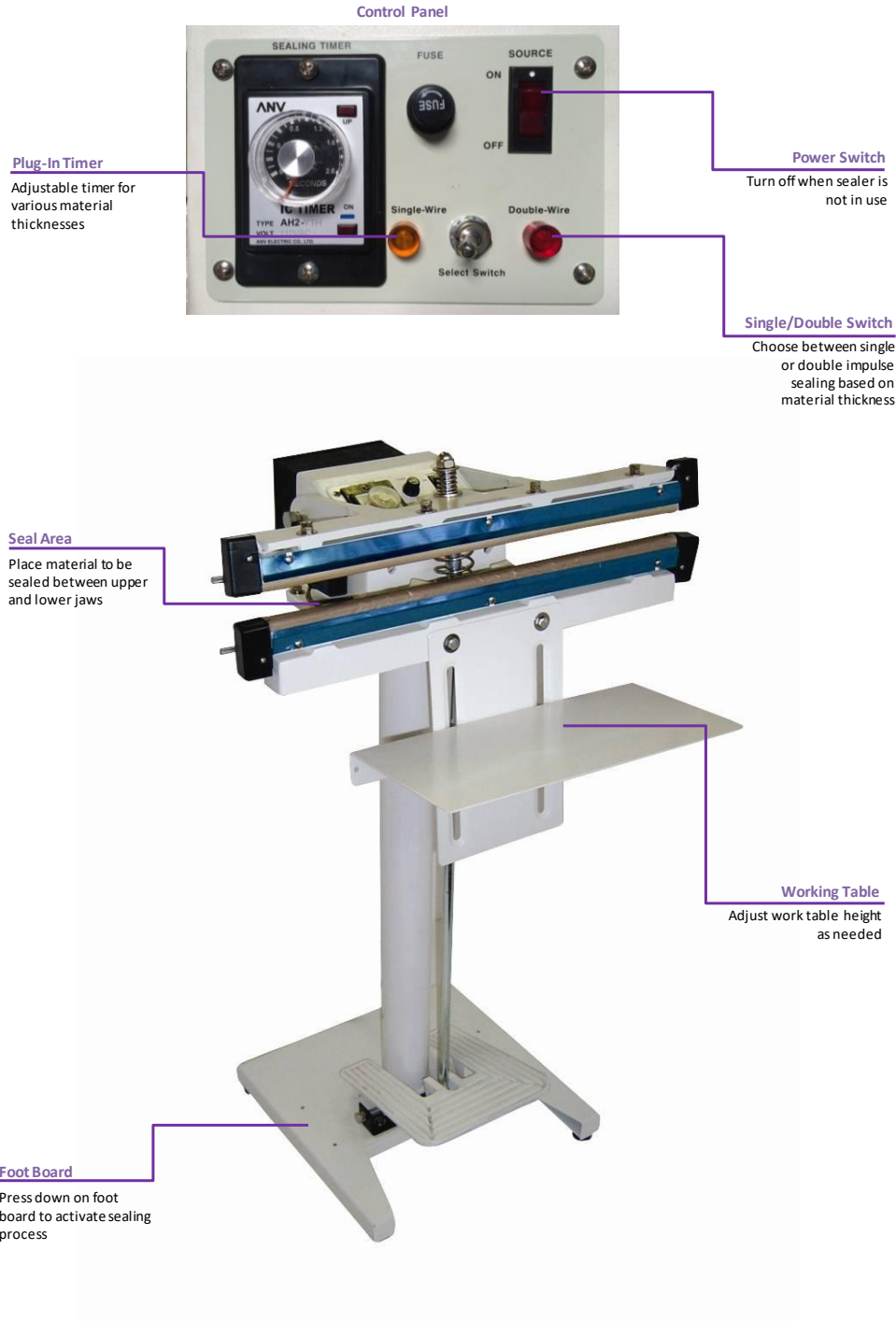


Figure 1. W-Series Double Impulse Foot Sealer Overview

# Operating your Sealer

## Assembly Instructions

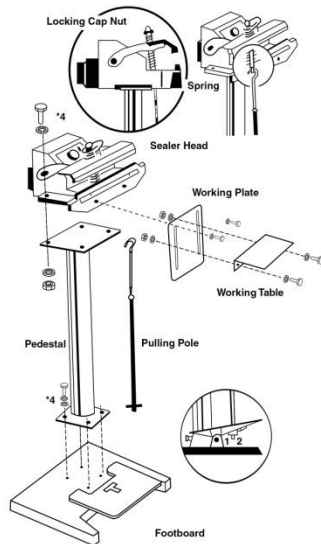


Figure 2. Double Foot Assembly Diagram

1. Position the pedestal on the floor standing upright.
2. Mount the complete sealer head to the top of the pedestal and attach with four screws.
3. Bring the upper jaw down and position the small pulling pole/plate set (Figure 8, Item #12A) through the pressing spring (Figure 8, Item #12B).
4. Gently push the upper jaw to meet the lower jaw. While jaws are compressed, reach under the unit and hook the pulling pole (Figure 8, Item #5). onto the small pulling pole/plate set.
5. With jaws still compressed, lift up the foot pedal to a 45° angle and slide the metal foot pedal rod onto one of the two pre-molded slots. This will create tension on the foot pedal and cause the pedal to stand upright at 45°.
6. Sealer is now ready to operate.
7. To install the optional working plate and table, remove the screws from bottom sealing jaw and install the working plate and table.



## Operation



1. Before operating, check the heating element, PTFE cover, PTFE adhesive and the silicone rubber.
2. Insert the power cord into the correct receptacle (120V).
3. Turn the power switch on.
4. Select single or double impulse sealing using the switch selector. Use double impulse sealing when sealing thicker materials.
5. Set the timer knob to the lowest setting. Always start with a low setting and increase gradually as needed.
6. Place material to be sealed under the upper jaw and press down on the foot board gently, but firmly. The UP light found on the timer will turn on when sealing time is complete.
7. ***When UP light turns on, 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 W-Series double impulse 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 W-Series double foot impulse sealers will require new heating elements and PTFE from time to time. Heating elements will break through wear and tear. A good rule of thumb is to replace the PTFE adhesive every time you change your heating element. The PTFE cover prevents the plastic or other thermoplastic material you are sealing from sticking to the heating element.

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

	W-300T	W-450T	W-600T
Replacement Kit	RK-12FD-W-300T	RK-18FD-W-450T	RK-24FD-W-600T
Heating Element	HE-12-5-W-300T	HE-18-5-W-450T	HE-24-5-W-600T
PTFE Adhesive	TA-12	TA-18	TA-24
PTFE Cloth (1ft. roll)	TR-12	TR-18	TR-24
Silicone Rubber <i>(not included in RK)</i>	SR-W-300T	SR-W-450T	SR-W-600T

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.
2. Remove the terminal assembly block cover (Figure 8, Item #7a).



Figure 3. Loosen screws on PTFE plate.



Figure 4. Remove heating element cover.

3. Lift up the PTFE cover to expose the heating element (Figure 8, Item #12).
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 heating element from twisting.)
5. Peel off the PTFE adhesive under the heating element.

### Installing New Replacement Parts.

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



Figure 5. Screw element in place.



Figure 6. Lift latch on heating block to screw element in place.

4. Cut off any worn out PTFE cover. Ease out enough footage of PTFE cover to cover the heating element and extend to the front of the PTFE cover plate.
5. Tighten the screws to affix the PTFE cover plate.
6. If a whole roll of PTFE cover needs to be replaced, loosen the multi-star knob (Figure 8, Item #31) found on the plate for PTFE (Figure 8, Item #30) and remove the PTFE roller (Figure 8, Item #14). 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 7. Loosen multi-star knob to remove the PTFE roller.

# Parts Diagram

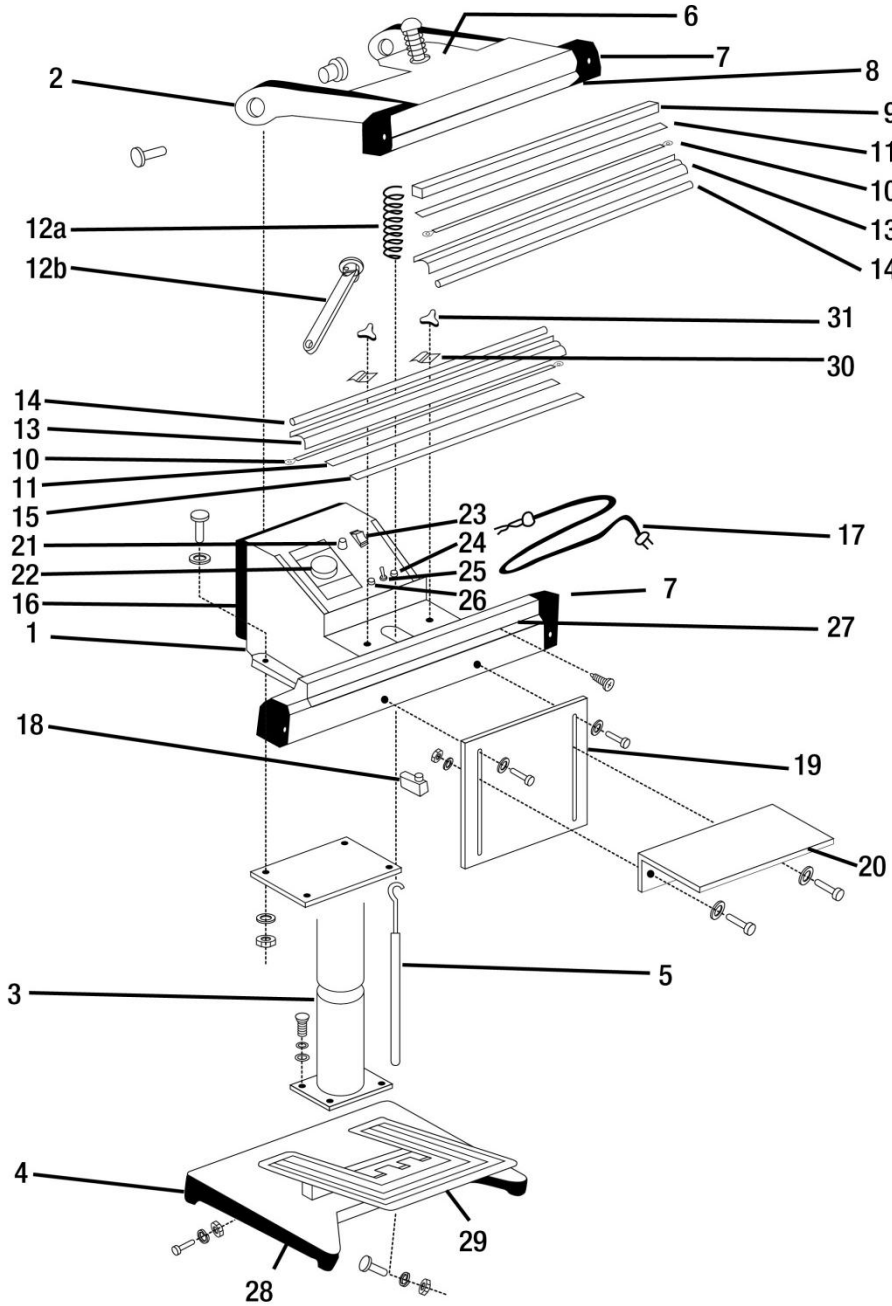


Figure 8. Spare Parts Diagram Overview

Figure 9. Spare Parts Diagram Overview

Item	Part #	Description	Comments
RKs	RK-Model#	<b>REPLACEMENT KITS</b> Includes (2) elements, (2) PTFE adhesives, and (2) 1ft PTFE cover	specify model # when ordering
1		Control Set Bracket/Skull (18", 24")	specify model # when ordering
2		Upper Jaw (18", 24")	specify model # when ordering
3	ST-WH	Standing Tube	
3a	STE-WH	Standing Tube Extended, 36"	
4	WHDF-4	Pedal Base	
5	PPS-WH	Level Set, Pulling Pole Set	
5a	PPSE-WH	Level Set, 36"	
	ST+PP-WH	Standing Tube + Pulling Pole Set	
	STE+PPE-WH	Standing Tube, Extended, 36" + Pulling Pole Set	
6	WHDF-6	Pressing Spring, Small W-00403	
6a	WHDF-6A	Cap Screw and Washer on top of Pressing Spring	
6b	WHDF-6B	Upper Bracket including Screws and Washers	
7	HTAB-WH	Element Spring Hook Unit W-00803	
7a	WHDF-7a	Element Hook Cover	
8		Silicone Rubber Holder Plate	
8a		Extra Strip for Bottom Silicone Holder - silver	
9	SR-	Silicone Rubber, 3/8" Flat/no groove	specify model # when ordering
10	HE-specifymodel#	Heating Wire 5mm	specify model # when ordering
11	TA-specifymodel#	PTFE Cover	specify model # when ordering
12	W-300T-12	Pressing Spring, Large (W-300T and W-300DAT)	specify model # when ordering
	WHDF-12-450/600	Pressing Spring, XL (same as WHLF) W-00402	specify model # when ordering
12A	WHLF-9A	Short Pulling Pole and Plate Set	
13	TR-specifymodel#	PTFE Cover	specify model # when ordering
14		PTFE Roller, Iron Stick	
	WHA-18a	Iron Stick 300 (WHA / WHDF)	
	WHA-18b	Iron Stick 450 (WHA / WHDF)	
	WHA-18c	Iron Stick 600 (WHA / WHDF)	
15	WHLH-49	Fiber Plate	
16	TRNS-specifymodel#	Transformer W-00612	specify model # when ordering
17	PC-WH	Power Cord	
18	MSW-WHF	Limit/Microswitch MSW-WHF W-00701	
19	WHDF-19	Working Adjusting Plate - 6 1/4" x 9 1/2" (W x L)	
19A	WHDF-19A	Working Adjusting Plate Screw Set - (Includes: 2-screws, 4-washers, and 2-wing nuts) - WHA, WHDF	
20	WHDF-20	Working Plate - 13 1/2" x 7" (W x L)	
20A	WHDF-20A	Working Plate Screw Set - WHA, WHDF	
21	WHDF-21	Fuse Holder, 15A, 125Vac E-00205	
22	T-W-Double	Timer, E-009A T-W-300T/450T/600T, SH2-Y1-2S	
23	WHLH-7	Power Switch, 3P, 15A/125V (W-Series)	
24	WHDF-24	Lamp for Double Wire, Red	
25	WHDF-25	Single/Double Select Switch, 4P E-00102	
26	WHDF-26	Lamp for Single Wire, Yellow	
26a	WHDF-26a	Lamp for Single Wire, Orange	
27		PTFE Cover Fixed Plate	specify model # when ordering
28	WHDF-28	Foot Board Bracket	
28A	WHDF-28a	Screws for Pedal	
29	FB-WH	Foot Board	
30	WHA-14	Plate for PTFE Sheet (Clip) (W-Series)	
31	WHA-15	Multi Star Knob (W-Series)	
32a	Fuse-15amp	Fuse 12" 15 amp, E01904	
32b	Fuse-20amp	Fuse 18" 20 amp	
32c	Fuse-25amp	Fuse 24" 25 amp	
33a	W-600T-33A	Relay 40A for W-600T	
33b	W-450T-33B	Relay 25A for W-450T	
34	WHI-11A	Circuit Breaker, 7A	

# Troubleshooting

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