

# Maintenance

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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	W-2510HT
Replacement Kit	RK-12FD-W-300T	RK-18FD-W-450T	RK-24FD-W-600T	RK-10HD-W-2510HT
Heating Element	HE-12-5-W-300T	HE-18-5-W-450T	HE-24-5-W-600T	HE-10-10-W-2510HT
PTFE Adhesive	TA-12	TA-18	TA-24	TA-10-6mil-1/2
PTFE Cloth (1ft. roll)	TR-12	TR-18	TR-24	TR-10-12
Silicone Rubber <i>(not included in RK)</i>	SR-W-300T	SR-W-450T	SR-W-600T	

## REPLACEMENT KIT INSTRUCTIONS

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).

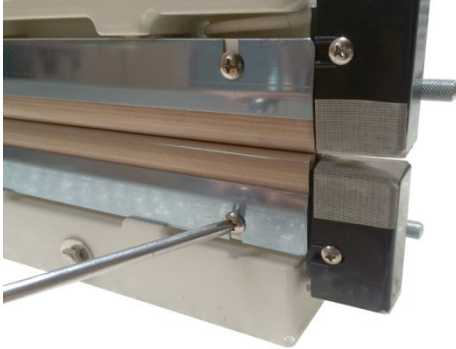


Figure 1. Loosen screws on PTFE plate.

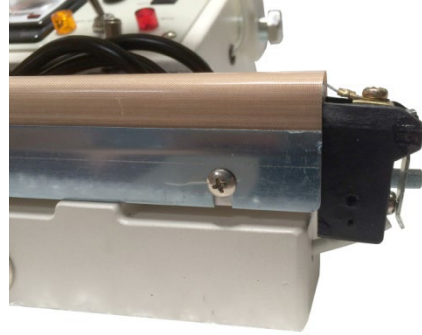


Figure 2. Remove heating element cover.

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.

## REPLACEMENT KIT INSTRUCTIONS



Figure 3. Screw element in place.



Figure 4. 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 5. Loosen multi-star knob to remove the PTFE roller.