



L-Bar Sealer

Models: W-350L, W-500L, W-650L

Distributed By:

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

Printed in the United States of America

General Information

Thank you for purchasing our W-Series L-Bar 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.

No part of this manual may be duplicated, reproduced, stored in a retrieval system, translated, transcribed, or transmitted in any form without the express prior written permission of Sealer Sales.

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. Failure to comply with the safety instructions would also void the warranty.

- ❖ Never operate or service your sealer until you have read this manual completely and understand it fully.
- ❖ Only 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. Do 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 of your sealer.
- ❖ Reduce risk of unintentional starting. Make sure the power switch is in the "OFF" position before attaching 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.
- ❖ Do not use the machine for any other purpose other than to seal thermoplastic materials. Doing so may result in damage to the machine and injury to the 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 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

W-Series L-bar sealers are designed for quick and easy shrink film packaging. The L-bar sealers allow you to create sealed packages using centerfold shrink film in one step, producing products that have a factory fresh clean look and feel. Our L-bar sealers will create packages that are free from dust, moisture, fingerprints, and tamper-proof.

Features of the W-Series L-Bar Sealers

Your L-bar sealer is equipped with a wide range of standard features and capabilities.

- ❖ Ideal for quick and easy shrink film packaging
- ❖ Steel construction for heavy duty use and durability
- ❖ Adjustable height work table for sealing packages of different heights (1" increments)
- ❖ Heating element located on the upper jaw of the sealer
- ❖ Included: film roller, twin perforating hole punch, film separator, work table, and up right heat gun holder (w/ built in electrical outlet)

How Do W-Series L-Bar Sealers Work?

Basic

Principles

Place material on lower jaw and bring sealing arm to activate sealing process

Our W-Series 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 material on the base of the sealer and brings the sealing arm down to seal. The sealer will create an "L-shaped" seal

sealing two sides of your package.

Specifications

	W-350L	W-500L	W-650L
Power	110V/60Hz	110V/60Hz	110V/60Hz
Watts	1000W	1900W	2800W
Seal Type	Line	Line	Line
Sealing Length (V x H)	14" x 20"	20" x 26"	26" x 31"
Max Height	6"	6"	6"
Dimensions	49" x 24" x 13"	56" x 30" x 13"	60" x 26" x 13"
Shipping Dimensions	Box #1: 40" x 28" x 21" Box #2: 24" x 19" x 11"	Box #1: 46" x 35" x 21" Box #2: 29" x 18" x 9"	Box #1: 53" x 39" x 19" Box #2: 35" x 17" x 9"
Net Weight (lbs)	80 / 18	98 / 21	116 / 22
Gross Weight (lbs)	125	149	175

Getting to Know your L-Bar Sealer

W-Series L-Bar sealers are simple and efficient sealing machines.



Figure 1. W-Series L-Bar Sealer Overview

Electrical Circuit Diagram

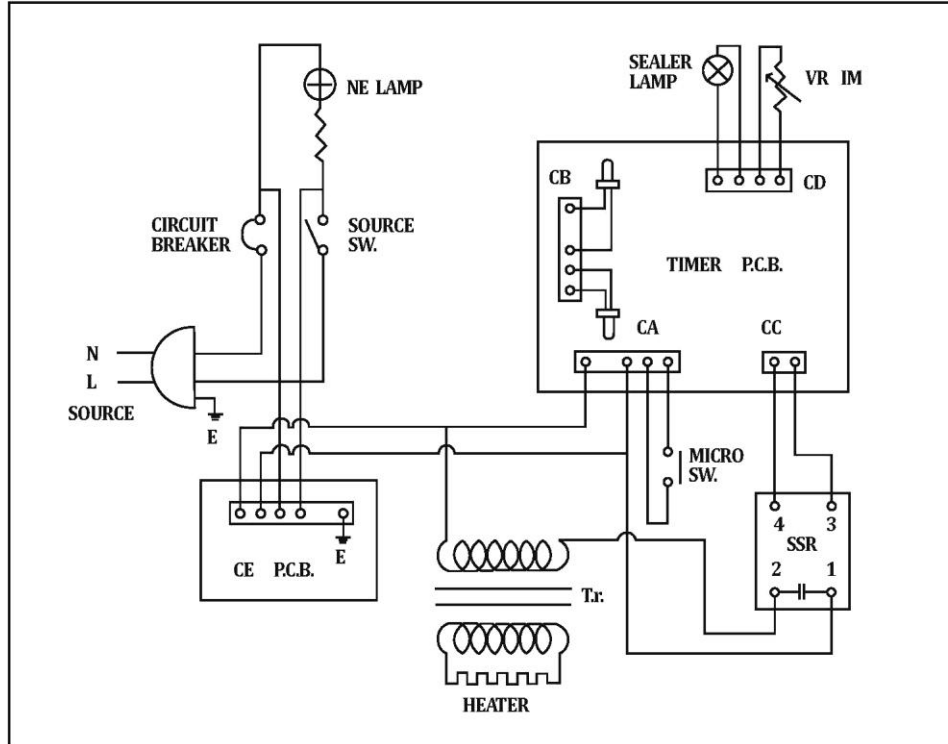


Figure 2. Electrical Circuit Diagram for W-Series L-Bar Sealers

Operating your Sealer

Important

Read this manual carefully, and make it available to everyone involved with the supervision, maintenance, and/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 L-Bar 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 remove finished product
 - ❖ Convenience of operator
1. Your new L-Bar sealer comes wrapped on a pallet to protect it. If your machine does not arrive in this condition, write on shipping paperwork that the box is damaged. Concealed damage may have occurred.



Figure 3. W-Series L-Bar on Crate

2. Once you remove the shrink wrapping, there will be two boxes. The first and larger box holds the L-Bar sealer and the second box holds the film roller.

3. Attach the film roller to the sealer using the four screws provided.
4. Adjust the bottom base of the L-bar sealer to the height of your product. Five options are available starting at 7 1/4" to 11 1/4" moving in 1" increments.

Operation



1. Before operating, check the heating element, PTFE cover, PTFE adhesive and the silicone rubber. The heating element should be intact.
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. Pull the film to be sealed.
6. Place the object to be sealed between the sheets of film. Place right hand on package and slide product into the sealed left edge (i.e. corner formed by folded rear edge of film and previously sealed left edge of film). Keep the object and film as close to the seal bars as possible for best quality seal. We recommend 1/2" to 1" of extra film around the package.
7. Press sealing handle down. Release when the timer light is turned off.
8. Repeat steps #6-7 on your next package.

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. Always keep the sealer clean. Remove any residue found on the platform and PTFE cover. Silicone spray may be used for this purpose.
4. Occasionally check the condition of the ceramics (holds the element in place). A damaged ceramic will affect the quality of the seal.
5. Occasionally check the condition of the silicone rubber for wear or burns. A damaged silicone rubber will affect the quality of the seal.



6. 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 Long Hand sealer.

Inspection and Cleaning

1. Inspect your machine daily.
2. Use a clean cloth to remove any plastic residue remaining on the PTFE adhesive.
3. When replacing the elements, always replace the PTFE adhesive.
4. Check the condition of the ceramics for wear and tear. A damaged ceramic will affect the quality of the seal.
5. 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

W-Series L-Bar sealers will require new heating elements and PTFE from time to time. Heating element will break through wear and tear. A good rule of thumb is to replace the bottom PTFE adhesive every time you change your heating element. The top PTFE adhesive 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 and (4) PTFE adhesives.

For replacement kit part #s, refer to your model #.

	W-350L	W-500L	W-650L
Replacement Kit	RK-14L-W-350L	RK-20L-W-500L	RK-26L-W-650L
Heating Element (2.7mm)	HE-1420-W-350L	HE-2026-W-500L	HE-2631-W-650L
PTFE Adhesive #1 (3/4" Wide x 3mil)	TA-14	TA-20	TA-26
PTFE Adhesive #2 (3/4" Wide x 3mil)	TA-20	TA-26	TA-31
Ceramic sold as each piece (total number on each unit)	WHL-12 (32)	WHL-12 (43)	WHL-12 (54)
Silicone Rubber	SRSer-W-350L	SRSer-W-500L	SRSer-W-650L

To install your replacement kit on your sealer, turn off power and unplug sealer.

1. Remove the PTFE adhesive to expose the heating element.
2. Loosen the screw on the front spring hook and remove heating element. **(Figure 4)**



Figure 4. Remove heating element

3. Remove the heating element from the rear spring hook.
4. Connect the new heating element to the front spring hook. Screw in the element but do NOT tightly screw in the element just yet.
5. Attach the other end of the heating element to the rear spring hook
6. Now that both ends of the heating element are attached, pull the middle of the heating element and place it in the copper turning set (lower right hand corner.) **(Figure 5).**

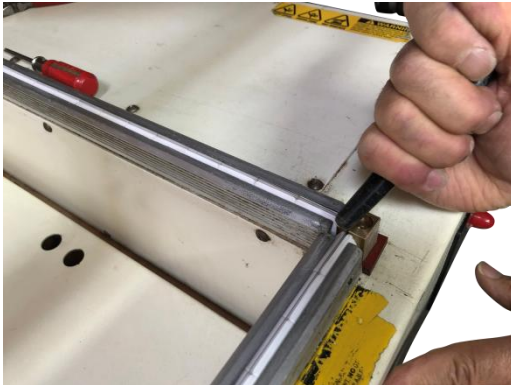


Figure 5. Place heating element in the copper turning block

7. You can use an object such as bottom of paint brush to assist with pushing the element into the copper turning set.
8. Tightly screw the front spring hook assembly.
9. Place a new adhesive over the heating element.
10. Replace the heating element cover.

Parts Diagram

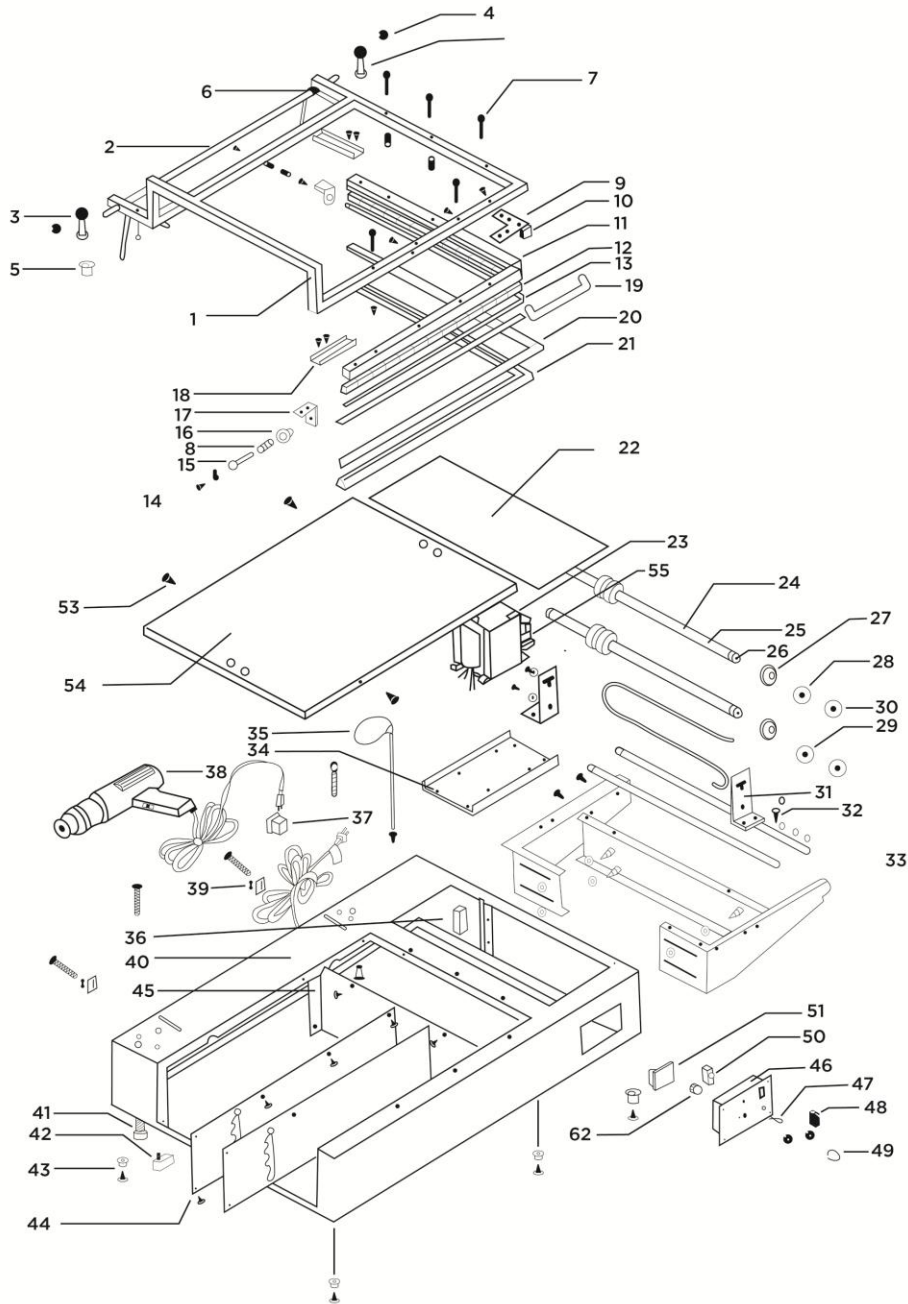


Figure 6. Spare Parts Diagram

WHL INSTRUCTION MANUAL

Item	Part #	Description	Comments
1		Upper Bracket	specify model # when ordering
2		Shaft	specify model # when ordering
3	WHL-3	Bearing-PHS12	
4		Ring / E-Clip	
5		Bushing / Nut	
6	WHL-6	Spring/Arm Set (2pc set)	
7	WHL-7	Screw 1/4, Hex/Black	
7a	WHA-7	Spring, Upper Bracket	
8	WHL-8	Spring (for Hook Pin)	
9	WHL-9	L-Type Fixed Plate	
10		Ceramic 90° Gen 1.0	
10a		Ceramic 90° Gen 2.0	Includes #9, 10a
11		Ceramic Bracket	specify model # when ordering
12	WHL-12	Ceramic	W-350L - 32pcs W-500L - 43pcs W-650L - 54pcs
13	HE-1420-W-350L HE-2026-W-500L HE-2631-W-650L	Heating Wire 3.2*0.32	specify model # when ordering
14	TA-14+20 TA-20+26 TA-26+31	PTFE Adhesive	specify model # when ordering
15	WHL-15	Hook Pin for Heating Wire	
15a	SHA-WHL	Spring Hook Assembly	Includes #8, 15, 16
16	WHL-16	Insulated Bushing	
17	WHL-17	Fixed Plate	
18	WHL-18	Fixed Bracket	
19	WHL-19	Handle	
20	SRSet-model#	Silicone Rubber (2pc set)	specify model # when ordering
21		Silicon Bracket (2pc set)	specify model # when ordering
22		Upper Cover	
23	TRNS-model#	Transformer	specify model # when ordering
24		Roller for EVA & PE Roller	
25	WHL-25	Film Separator	
26	WHL-26	Washer For Roller / White Silicone	
27	WHL-27	Eva Roller (L) Foam	
28	WHL-28	Eva Roller (S) Foam	
29	WHL-29	PE Roller w/Needle	
29a	WHL-2a	Eva Roller L(27) and S(28) + PE Roller w/Needle (29)	
30		Needle in Perforator	

Figure 7. Spare Parts Diagram List (Table 1 of 2)

WHL INSTRUCTION MANUAL

Item	Part #	Description	Comments
31	WHL-31	Bracket	
32	WHL-32	Spring for #31 Bracket	
33		Bracket for Film Holder	
34		Transformer Holder	
35		Heat Gun Holder	
36		Heat Gun Fixed Bracket	
37	WHI-13	Power Socket for Heat Gun	
38		Heat Gun (Not Included)	Model: HG-1-CY
39	WHL-39	Power Cord	
40		Body	
41		Screw M12 to adjust Lever	
42	MSW-WHF	Microswitch	
43		Rubber Foot	
44		Adjusting Frame for Working Plate	
45		Plate	
46	T-WHL	Control Panel / Timer	Includes #46, 47, 48, 49, 50, 51, 52
47	WHA-33	Led Lamp	
48	WHI-2	Power Switch, 3P, Red	
49	WHA-30	Knob	
50	WHI-11b	Circuit Breaker, 10A	
51	T-WHL	PC Board for Timer	Includes #46, 47, 48, 49, 50, 51, 52
52	WHA-36	Variable Resistor	
53		Screw for Working Plate	
54		Working Plate / Adjustable	
55	WHL-55	Magnetic switch S-P-11	
56		Box	
57		Roller, Complete w/ Bearings for Holding Shrink Film	specify model # when ordering

Figure 8. Spare Parts Diagram List (Table 2 of 2)

Troubleshooting

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