

JEFF EASTEY ENTERPRISES, INC.

THE OPERATING AND MAINTENANCE MANUAL

This operating and maintenance manual has been prepared to provide the user information on installation, operation and maintenance of Eastey Shrink Packaging Equipment.

Please read this manual carefully and refer to it for information on the care and use of your Eastey Shrink Packaging Equipment. It is recommended that additional copies be ordered for use by production, maintenance and supervisory personnel. Although the design of Eastey Shrink Packaging Equipment incorporates safeguards to protect personnel, extreme care must be used in operating, adjusting and servicing the shrink packaging equipment.

Your attention is directed to the limited warranty which accompanies Eastey Shrink Packaging Equipment. The terms and conditions of the limited warranty apply only to unmodified units. Any unauthorized modifications to the equipment or misuse of the equipment automatically invalidates the limited warranty.

EASTEY®

LIMITED WARRANTY

EFFECTIVE JANUARY 1, 2009

JEFF EASTEY ENTERPRISES, INC. ("EASTEY") warrants each new product it manufactures to be free from defects in material and workmanship for a period of two (2) years from the date of shipment by Eastey.

Defective parts under warranty must be returned to EASTEY, freight prepaid. EASTEY's sole obligation and purchaser's sole remedy in the event of a breach of this warranty shall be, at EASTEY's option, to repair or provide replacement parts for the product or refund the purchase price paid to EASTEY for the product.

THIS WARRANTY SHALL NOT APPLY IF ANY MODIFICATION, ALTERATION OR ADDITION IS MADE TO THE PRODUCT WITHOUT EASTEY'S PRIOR WRITTEN APPROVAL. FURTHERMORE, THIS WARRANTY DOES NOT APPLY TO PRODUCT DEFECTS DUE TO MISUSE, ABUSE, NEGLIGENCE, OR FAILURE TO FOLLOW RECOMMENDED PROCEDURES. ANY PRODUCT REPAIRED OR ALTERED BY PERSONS OTHER THAN AUTHORIZED EASTEY REPRESENTATIVES WILL NOT BE COVERED BY THIS WARRANTY. THIS WARRANTY DOES NOT APPLY TO CONSUMABLE ITEMS. (SEE FOLLOWING PAGES FOR FURTHER DETAIL)

EXCEPT AS EXPRESSLY PROVIDED IN THIS WARRANTY, EASTEY MAKES NO REPRESENTATION OR WARRANTY, EXPRESSED OR IMPLIED, WITH RESPECT TO THE PRODUCT, INCLUDING, WITHOUT LIMITATION, ANY WARRANTY AS TO MERCHANTABILITY, FITNESS FOR A PARTICULAR PURPOSE, NON-INFRINGEMENT OR ANY OTHER MATTER.

EASTEY SHALL HAVE NO LIABILITY TO ANY PERSON FOR INCIDENTAL, CONSEQUENTIAL, OR SPECIAL DAMAGES OF ANY DESCRIPTION WHETHER ARISING OUT OF WARRANTY OR OTHER CONTRACT, NEGLIGENCE OR OTHER TORT, OR OTHERWISE. NO AGENT, EMPLOYEE, OFFICER OR OTHER REPRESENTATIVE OF EASTEY ENTERPRISES, INC. HAS AUTHORITY TO BIND EASTEY TO ANY REPRESENTATION OR WARRANTY EXCEPT AS STATED HEREIN. UNDER NO CIRCUMSTANCES SHALL EASTEY'S LIABILITY HEREUNDER, FOR ANY REASON OR CAUSE EXCEED THE PRICE PAID TO EASTEY FOR THE PRODUCT.

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

LIMITED WARRANTY - THE MINI BY EASTEY

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

1. End Curtains
2. Conveyor Belt
3. Knurled Nuts

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

1. Fuses
2. 1/4" x 3/4" Sponge Rubber
3. Copper Heat Sinks
4. .036 Nichrome Wire
5. 3/4" Teflon Tape
6. 1/2" Teflon Tape

LIMITED WARRANTY - ECONOMY SEALERS ET1622M/T and EM1636M/T

The following parts are an exception to the warranty listed on the previous page. Each Part listed below shall carry a 30 day warranty unless designated otherwise:

1. Conveyor Belt
2. Knurled Nuts

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

1. Fuses
2. 1/4" x 3/4" Sponge Rubber
3. .036 Nichrome Wire
4. 3/4" Teflon Tape
5. 1/2" Teflon Tape

LIMITED WARRANTY- SEALERS w/HOT WIRE

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

1. Termination Post
2. Conveyor Belt
3. Hole Punches - Ball and Die
4. Knurled Nut

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

1. Fuses
2. 1/4" x 3/4" Sponge Rubber
3. Copper Heat Sinks
4. .036 Nichrome Wire
5. 3/4" Teflon Tape
6. 1/2" Teflon Tape

LIMITED WARRANTY - SEALERS, SLEEVEWRAPPERS/ BUNDLERS w/DUO SEAL®, & AUTOMATIC SEALERS

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

1. Felt Pad
2. Conveyor Belt

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

1. Coated Seal Bars, (Mushrooms Inserts, poly inserts, arrow inserts, pancake inserts, and cutting rules) if they have been scratched.
2. Fuses
3. 1/4" x 3/4" Sponge Rubber
4. 3/4" Teflon Tape
5. 1/2" Teflon Tape

LIMITED WARRANTY - ECONOMY TUNNEL ET1608 AND EET2010

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

1. Silicone Tubing (Roller Covering)
2. End Curtains

LIMITED WARRANTY - SMALL TUNNEL ET1610-36 and ET1610-48

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

1. Silicone Tubing (Roller Covering)
2. End Curtains

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

1. Fuses

LIMITED WARRANTY- ALL OTHER TUNNELS

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

1. Silicone Tubing (Roller Covering)
2. End Curtains

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

1. Fuses

WARNING

Every effort has been taken to insure safety while operating this machine, however, there still remains certain risks. Do not allow this machine to be operated before informing all personnel of the attached warning.

WARNING...

Do not tamper with electrical wiring. Use only licensed electricians for maintenance. Always disconnect electrical power before attempting maintenance to any electrical or moving parts.

WARNING...

In order to prevent injury to personnel and/or damage to your equipment **DO NOT INCREASE THE SETTINGS ON EITHER THE ELECTRICAL OR MECHANICAL OVERLOAD SAFETY DEVICES.**

WARNING...

Keep hands away from moving conveyors and assemblies. Conveyor belts that have become worn or frayed can be hazardous and should be replaced promptly.

WARNING...

Never operate this equipment without all covers and guards in place. The internal mechanism of most packaging machinery contains numerous shear, pinch, and nip points, many of which are capable of causing severe injury and permanent disfiguration.

WARNING...

To minimize the potential for personal injury, always insist that machine operators and others working on the equipment are properly trained in the correct usage of the equipment and are 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 during operation and use caution if the machine has been running recently.**

WARNING...

Do not make any modifications to either the electrical circuitry or the mechanical assemblies of this machinery. Such modifications may introduce hazards that would not otherwise be associated with this machinery. EASTEY ENTERPRISES will not be responsible for any consequence resulting from such unauthorized modification.

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 on this equipment, the manufacturer or supplier of the film should be contacted for specific information concerning the potential release of hazardous fumes. **Adequate ventilation should be provided at all times.**

WARNING

Keep combustible materials away from this equipment as the equipment may be a source of ignition.

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EASTEY ENTERPRISES, INC.

Instructions for operation and repair of Eastey Manual L-Bar Sealers.

This manual covers the following L-Bar Sealers Models:

EM1622MK DUOSEAL[®] SYSTEMS REYNOLDS
EM1622TK DUOSEAL[®] SYSTEMS REYNOLDS

IMPORTANT - PLEASE READ

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.

MODEL DESCRIPTIONS

MODEL EM1622MK:

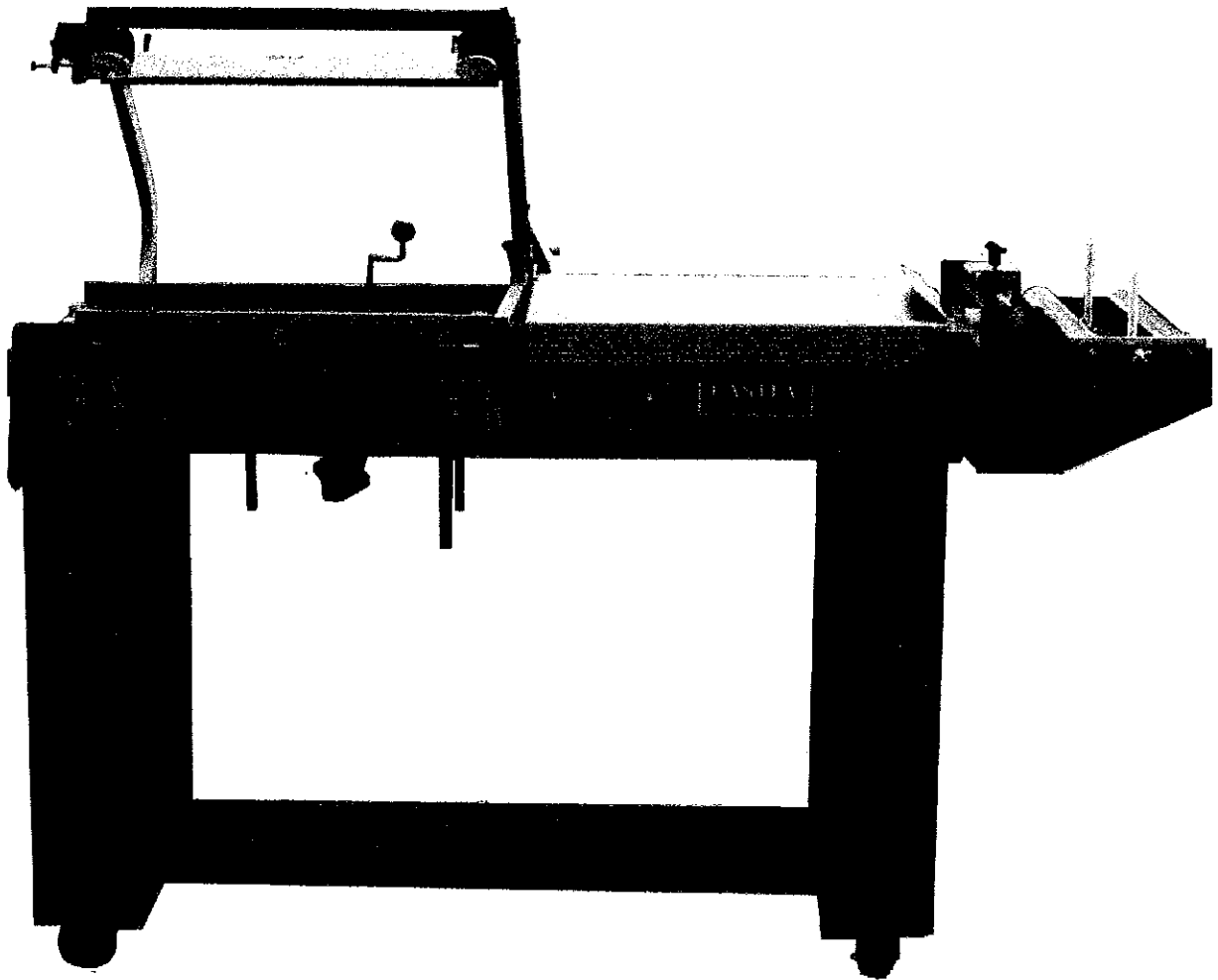
This model incorporates electric magnet process, which is a sealing head hold down system. This allows the operator to load another package while the preceding package is being sealed, thus assuring uniform sealing pressure over the entire length of the sealing bars. The system provides consistent sealing results.

MODEL EM1622TK:

This model possesses all of the features described in the above model. In addition it incorporates a package take away conveyor to increase production speed.

EASTEY L-Bar Sealer

Manufactured by Easteys



**Model EM1622TK DUOSEAL[®] SYSTEMS REYNOLDS
Shown**

INTRODUCTION OF “EASTEY” DUOSEAL[®] SYSTEMS REYNOLDS SEALERS

GENERAL DESCRIPTION OF SEALERS:

The Eastey L-Bar sealers utilize advanced sealing techniques to completely wrap almost any item, using most heat shrinkable or non-shrinkable films. When used with shrinkable films and a hot air tunnel, a tight contour fit is obtained for complete product visibility, sales appeal and protections.

EM1622TK
EM1622MK

E = Indicates that it is a **EASTEY** Sealer

M = Indicates that it is a manual sealer.

EM1622 = Indicates length of front bar: 22"

EM1622 = Indicates length of side bar: 16"

M (after any number) = Indicates that it is a magnet hold down sealer with no take away conveyor

T (after any number) = Indicates that it is a take away conveyor sealer with magnets

UNPACKING

Thoroughly inspect immediately upon arrival!

Carefully remove the protective wrapper. Inspect machine for any damage that may have occurred during transit. If goods are received short or damaged condition, it is important that you notify the carrier's driver "before they leave your company" and insist on a notation of the loss or damage across the face of the freight bill of lading; otherwise no claim can be enforced against the transportation company. Please note this same piece of paper is attached to the outside of every crate.

If concealed loss or damage is discovered, notify your carries at once and request **INSIST on an inspection. This is absolutely necessary. A concealed damage report must be made within 10 days of delivery of shipment.**

Unless you do this the carrier will not entertain any claim for loss or damage. The agent will 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 filled within FIVE months of delivery date or carrier will not accept them.

We are willing to assist you in every possible manner to help you collect claims for loss or damage, but this willingness on EASTEY'S part does not make EASTEY responsible for collection of claims or replacement of equipment.

DESCRIPTION

The purpose of an Eastey Machine is for low volume packaging requiring excellent seals and minimum maintenance. It uses an impulse or polyethylene mode for sealing bags.

SPECIFICATIONS OF EM1622 L-BAR SEALER DUOSEAL[®] SYSTEMS REYNOLDS

MODELS: EM1622MK EM1622TK

MODEL	SEAL AREA		VOLTS	AMPERAGE	MACHINE SIZE		WEIGHT
	SIDE	FRONT			WIDTH	LENGTH	
EM1622MK	16"	22"	220	10	27"	63"	300
EM1622TK	16"	22"	220	10	27"	63"	350

SEQUENCE OF OPERATION

- A. Product is placed on the film product separator tray.
- B. The product tray functions as a means to separate the film, allowing placement of product between upper and lower portions of film.
- C. Now move product into seal head area by pushing the product to the left.
- D. For magnet and take away models:
Manually pull the seal head down, as the seal head meets the lower seal pad, the machine automatically activates the seal wires. The timer activates the magnets and is adjustable from 1 to 6 seconds.
- E. Take away tray:
If your machine has a take away tray, manually move the product into the middle of the shrink tunnel opening and insert the product.
- F. Take away conveyor unit:
Once the seal is completed, the seal head automatically releases and the take away conveyor begins to run. It is adjustable from 1 to 6 seconds The timer is located on the front of the machine by your other controls, (take away model only).

NOTE: If too much tension is on the film while the bag is being made, your seals will more than likely be weak or they will blow out in the seal area while going through the shrink tunnel.

INSTALLATION - BASIC SET UP

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 - call 888-212-7715 to request additional copies. Be very careful when operating, adjusting or servicing this equipment. If in doubt, stop and obtain qualified help before proceeding.

INSTALLATION OF ALL MODELS

Place the sealer in the desired position with the required electric power source available, (see power requirements for each model). Make sure electric wiring is adequate to guard against low voltage. If the voltage is too low, the equipment will not perform.

INSTALLATION OF MODEL EM1622 SEALERS

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

1. Adequate power source
2. Relationship to source of product
3. Relationship to tunnel and any conveyors necessary to remove finished product
4. Convenience of operator

If there is any doubt, get qualified assistance to do your initial installation. **Do not take chances!**

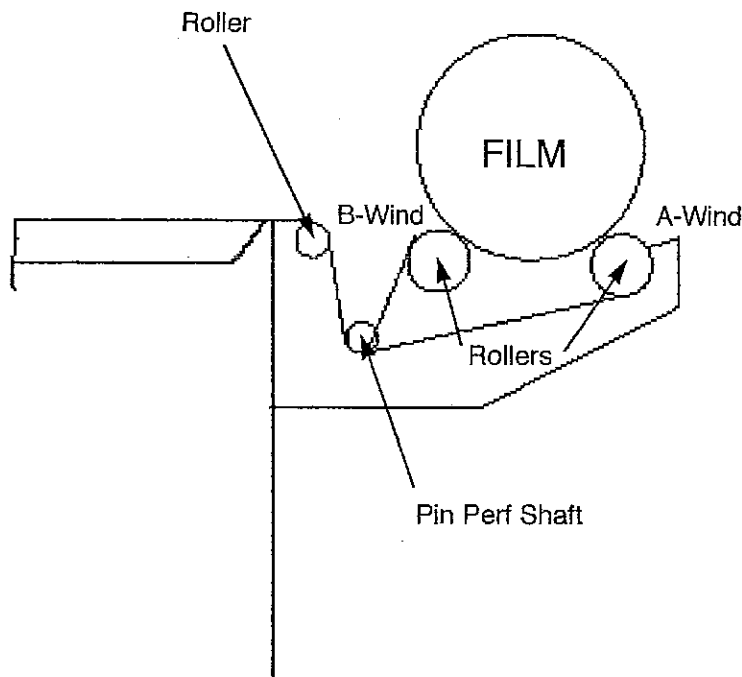
FILM MOUNTING & THREADING

Select the proper width of center fold 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 can readily be made without any possibility of open areas due to insufficient film.

Place film roll on cradle mount film rack. (Look at the detailed drawing at the bottom of this page) The center fold is to be placed toward the back of the machine. Position film roll on rack and tighten film guide nuts to hold film roll in position.

Decide whether the film is an A or B wind and then thread it through the pin perforator. Note that the perforator needles are sharp, so be careful. Also make sure perforator wheel turns freely and is not binding. Once threaded, separate film top from bottom and film is at the back of the product tray. This allows the operator to insert product between the 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.

Place product against back 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. This completes threading and or mounting film.



PRODUCT TRAY

The adjustable metal platform used to separate film and to insert product between top and bottom layers of film. The tray is adjustable to achieve proper depth of the package, thereby allowing product to be placed exactly in the center fold of the film each time.

PIN PERFORATOR

Located between the lower idler rollers it is completely synchronized with the seal arm and creates a hole (for air escape during shrinking) each time a new seal is made.

The pin perf is adjustable and must be properly placed in conjunction with the depth of the desired package. The positioning should always be reviewed when changing the machine for difference size product or different size film. It can be adjusted through use of the adjustment knob attached to the bottom of the film rack.

FILM BRAKE

Positioned at the front end of the cradle rollers. It serves to create drag on the dispensing of the film by keeping tension on the film. The operator should from time to time re-evaluate its setting, attempting to set it for proper tension. It functions to avoid over run and slack.

OPERATION OF EM-00 SEALERS

After performing film threading as described on page 13, plug the sealers cord into the power source.

Because of the importance of the adjustment of the element compensator to the successful operation of the sealer, the following explanation of its operation is given.

INSTRUCTIONS FOR PRODUCTION OPERATION OF SEALER

After setting the element compensator for the film type in use, proceed as follows:

- A. With film threaded, (see instructions for mounting film) using left hand, 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).
- B. Still using left hand, move package and film into lower right corner of sealing area and then slightly back and away from the corner formed by the sealing bars. This will allow some slack film between the package and the sealing bars.

THE STEPS WHICH FOLLOW APPLY ONLY TO EM-M AND EM-T SERIES, (MAGNET AND TAKE-AWAY CONVEYORS).

- C. Press sealing handle down, immediately release pressure. The sealing head will remain down for the duration of the time set on the dwell timer.
- D. During the timer the sealing head is being held down by the action of the magnets (the operator having removed his hand from the operating handle), it is not necessary to wait. The operator can load the next package into the package loading area on top of the product tray, thus speeding up the sealing operation.
- E. On the EM-M sealers, as soon as the sealing head rises, move the first package away from the sealing area and place the second package in position for sealing.
- F. On the EM-T sealers, initially set the conveyor timer to approximately 1 second on its scale. So, continuing from step E above, as the sealing head rises, the package take away conveyor will transport the package away from the sealing area, making room for the next sealing operation.

SERVICE ADJUSTMENTS

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 is given to assist the operator in that general fashion. If the problem does not rectify itself with these general explanations, discuss it with a certified representative of Eastey or with Eastey Enterprises directly.

REPLACING CONVEYOR MOTOR

- A. Disconnect breaker or power plug from source of power. Remove conveyor mesh belt (see pages 19-22).
- B. Disconnect the wire #'s 8 & 7 from inside electrical panel and pull back through.
- C. Loosen the 2 1/4-20 bolts that hold the conveyor in place in lift mechanism. Lift conveyor out of machine.
- D. Loosen set screws on sprocket that is attached to the motor and remove sprocket.
- E. Remove 4 10-32 screws. These screws hold the motor in place. Hold motor while removing these screws so the motor does not drop.
- F. Follow steps B - E in opposite order to reinstall new motor against the conveyor frame and tighten both set screws.

SERVICE ADJUSTMENTS

ELEMENT TEMPERATURE ADJUSTMENT

Adjustment of the temperature controller may be required under the following conditions:

- A. If charring of film is noted (too much heat).
- B. If sealing is incomplete (too little heat).

TEMPERATURE AND PAD SPECS FOR DUOSEAL[®] SYSTEMS REYNOLDS

Mushroom Insert

P.V.C. Temperature 325° front, 325° side.
 Felt pad, dwell time approximately 1 second.

FELT PAD SEALING PAD REPLACEMENT

Occasionally it will be necessary to replace the felt pad sealing pads. This should be done if the following effects are noted:

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

TO REPLACE FELT, PROCEED AS FOLLOWS:

Seal pads are designed with a channel for easy replacement. Pull felt pad out of channel and replace with new felt pad. Press felt back into channel.

SEALING PAD PRESSURE ADJUSTMENT FOR HEAD RETURN CYLINDER

Uniform pressure between the sealing elements and the sealing pads must always be maintained for proper sealing uniformity, and to prevent element hot spots and premature burnout. This adjustment should be checked periodically, and should always be checked when sealing gaps occur. Proceed as follows:

- A. Disconnect the sealers power plug from the power source. Holding seal head in the up position, loosen 4 set screws for head return cylinder. Slowly lower seal head so it is resting on lower seal pads. Shim seal clamps up so inserts are resting on pad.

- B. With head inserts on lower pads, make sure there are no air gaps, then tighten head casting bolts.
- C. Adjust magnets (see adjustment of magnets below).
- D. Around back side of machine (making sure head cylinder is straight from front to back) grab air cylinder bracket and pull full length of cylinder and tighten down 5/16 set screws.
- E. Cycling head up and down, adjust set screw for proper head speed and cushion.

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 as viewed from above). The correct adjustment has been obtained when the magnets are energizing just as the seal bar comes into contact with lower pads.

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 the side seal bars. However, if an adjustment is required proceed as follows:

- A. Disconnect the sealers power source.
- B. Loosen the lower magnet screws on all lower magnets so the magnets settle to their lowest position in the mounting slots.
- C. Lower the sealers operating handle fully and lift lower magnets to within the thickness of a dime from the holders. Tighten the mounting screws securely to retain the proper adjustment.

SERVICE ADJUSTMENTS

ASSEMBLY OF A DUOSEAL[®] SEAL HEAD

1. Use 10-32 screw with lock washer and bolt front and side bar together. It uses only 1 screw to bolt the two together.
2. Insert knife into mushroom insert. The knife should move freely inside mushroom insert. The slots in the knife and mushroom insert should line up with each other.
3. Insert mushroom insert into front and side bars. Very carefully tap on the ends of the mushroom insert until the two 45 degree angles match up with each other.
4. Tap very carefully on the two knife blades until they come in contact with each other at the 45 degree point. If you leave a gap between the knives, you are more than likely going to get a poor cut at the 45 degree point.
5. Start all of the 8/32 x 3/8 flathead screws but do not tighten them yet. Normally you want the knife sticking out of the mushroom insert as far as possible now. Tighten the 8/32 x 3/8 flathead screws.
6. Install the saddles using a 3/16 x 3/4 roll pin. The saddles should move freely.
7. Now you can install the film clamps. Start with the corner block. Using 10/32 x 3/8 screws, screw the two outside clamps on first, then screw on all the square blocks. The film clamp right next to the front and side bar like you are going to bolts them on. Then you can screw the two inside clamps on. At this point, your front and side bars should be in between the inside and outside clamps.
8. Install the 1/4 x 1 shoulder bolts with a spring and a flattened 1/4-20 lock washer.
9. There should be one hole on the top of the front bar and the side bar. This is where the heat sensor will go. When you screw the heat sensor in do not over-tighten it, just snug it.
10. At the end of the front and side bar there will be a hole where the heater cartridge will slide into. The heater cartridge should slide in all the way until it hits the brass curved piece.
11. Install the 5/6 threaded rod into the saddles. Turn threaded rod down until it bottoms out on the seal bars, then back threaded rod off 1 turn and lock threaded rod down with 5/16-18 bolts. Before installation be sure to put one 5/16-18 bolt and flat washer on threaded rod about halfway down. Install bars onto castings, then put 5/16-18 nut and flat washers on threaded rod. Refer to basic set up.



154 HARVEY ROAD, LONDONDERRY, NEW HAMPSHIRE 03053 (603) 644-2500 FAX: (603) 644-3800

MAINTENANCE OF FLAT-FLEX® WIRE BELT

The life of Flat-Flex® Wire Belt depends on you and the belt circuit design. Belt failure is most often caused by accident. Metal fatigue causes many more failures. Accidents often cannot be prevented, but fatigue failure can be minimized. Basically, fatigue is caused by bending or flexing of the wire many times and results in embrittlement. Belt life can be improved by following basic maintenance procedures.

Common causes that will make belts brittle:

1. Too much tension on belt. Flat-Flex® is a low tension system.
2. Belt circuit has reverse bend rolls with diameters less than 10 times the mesh. Example: The 1/2" mesh reverse bend roll would be $10 \times .5" = 5"$ diameter.
3. No clearance between belt joints and sprockets. Belt must be able to move sideways at all rolls 1/4" minimum, 3/8" maximum.
4. Belt being run upside down (sprockets will not operate properly on the smooth side of the belt).
5. Drive sprocket are out of alignment causing belt snapping from interference with the sprocket teeth (also from improper spacing across the shaft).
6. Improperly designed drive sprockets are being used causing continual belt climbing and snapping. Commercially available spur gears and sprockets in most sizes will not fit the belt properly and should not be used. Flat-Flex sprockets are specifically designed to fit and pull the belt properly.

manufacturers of  WIRE BELTING

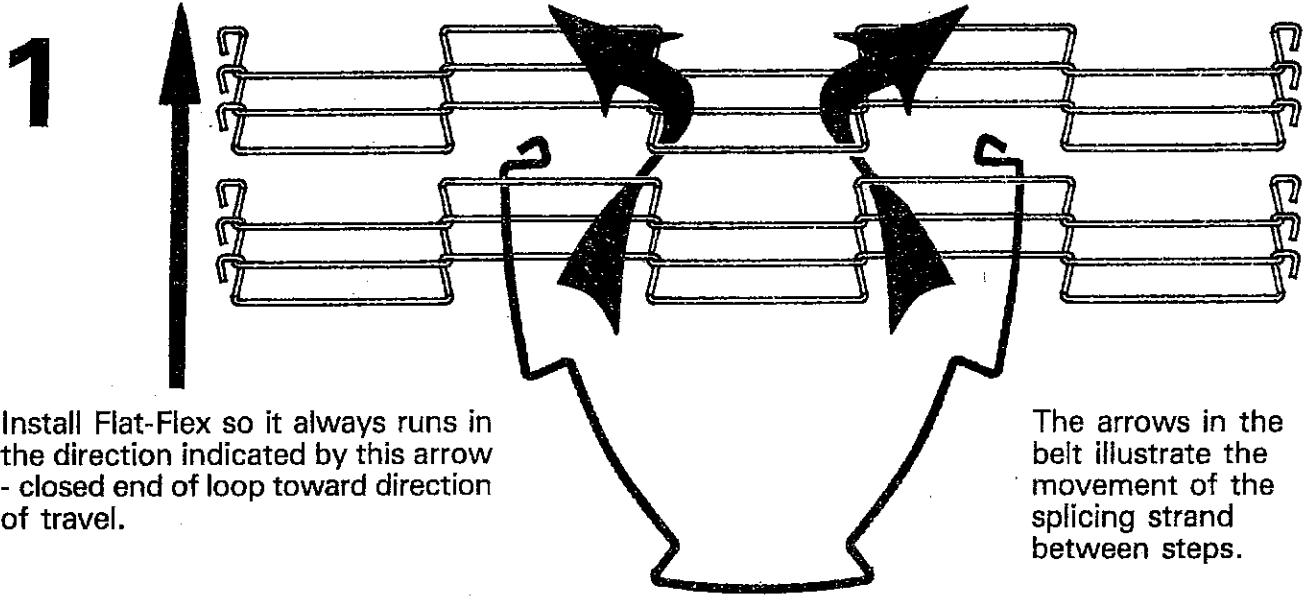
Packaging - Processing
Bid on Equipment
1-847-683-7720
www.bid-on-equipment.com

If a belt is breaking up at one or two joints and is otherwise strong, then there is something wrong in the belt conveyor circuit, as it is not possible for this condition to occur during manufacturing. Examine the belt circuit to see what is causing the trouble at the brittle joints.

Maintenance of belts is easy and when done routinely will increase belt life substantially. We recommend the following:

1. Generally belts will stretch some after initial use and belt tension will have to be checked. Proper tension is difficult to describe but basically is the lowest tension required to keep the belt meshed properly with the drive sprockets. Always locate the drive roll at discharge end of conveyor for lowest possible belt tension.
2. Distorted or broken strands should be straightened or repaired promptly to prevent a major failure from occurring.
3. It is generally best to replace an old belt that is breaking up all over, however, temporary repairs can be made with one and three space splicing clips that are available for all belts.
4. It is advisable to have a spare belt for two reasons. Obviously it takes time to get a replacement and a spare belt may be installed while repairs are made on the original. Down time costs money.
5. When a jam or unusual belt wear occurs, be sure to determine the cause and take corrective action. If you cannot pinpoint the trouble we will be happy to try to assist you. If you can send us a section from the belt you are having the problem with (1 or 2 feet), generally we can determine the trouble.
6. After installation, a belt should be checked for tracking, proper fit with the drive sprockets, and must be tensioned properly.
7. When designing an installation you should always use the heaviest mesh consistent with your product and application. We are always glad to assist you with our recommendations and urge you to ask for our help when in doubt.

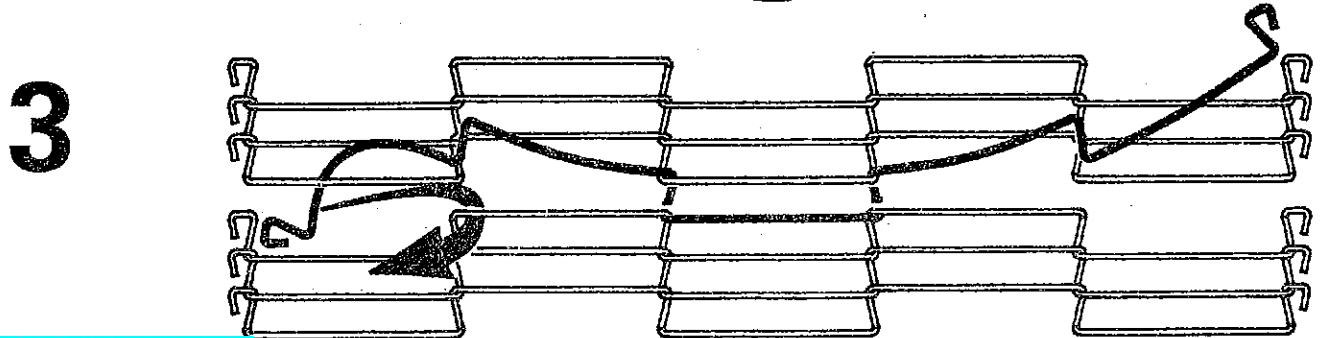
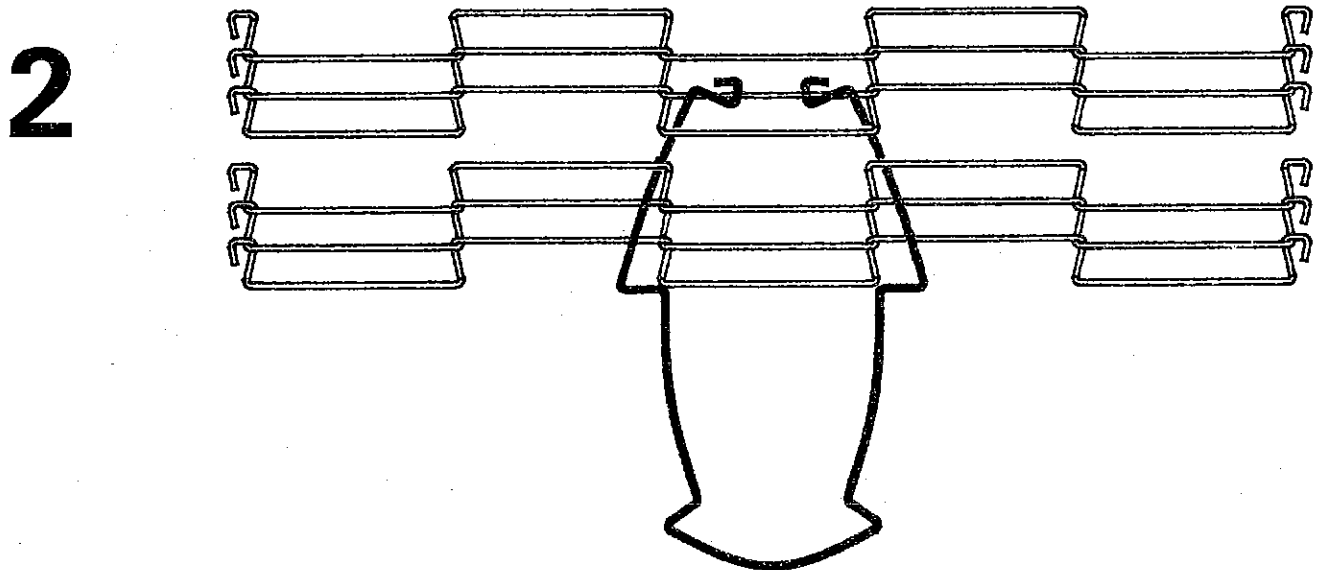
FLAT-FLEX® SPLICING INSTRUCTIONS



Install Flat-Flex so it always runs in the direction indicated by this arrow - closed end of loop toward direction of travel.

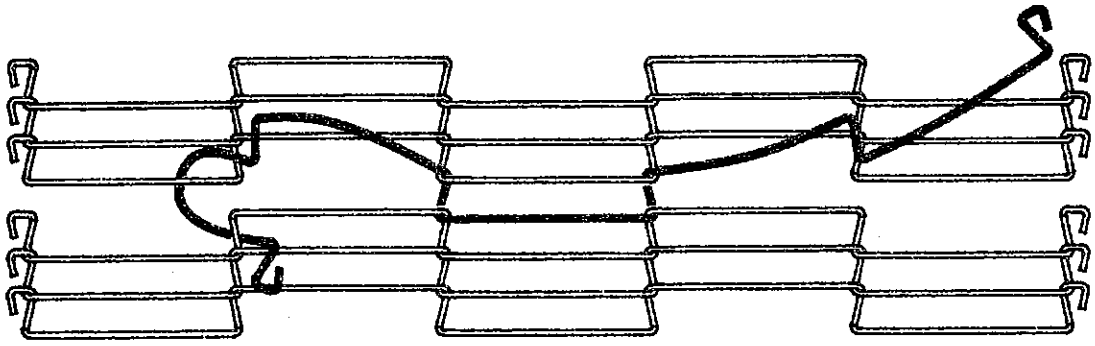
The arrows in the belt illustrate the movement of the splicing strand between steps.

When bending the splicing strand, try to limit bending to straight portions of the strand rather than in the "Z" bend area.



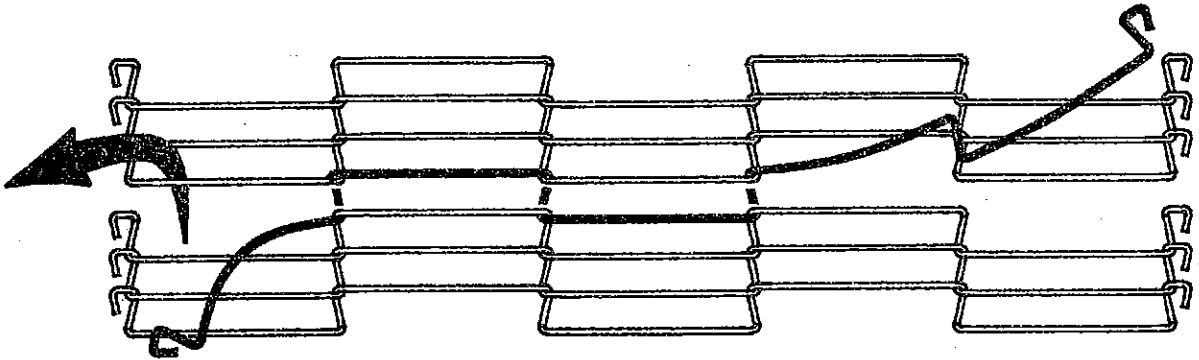
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4

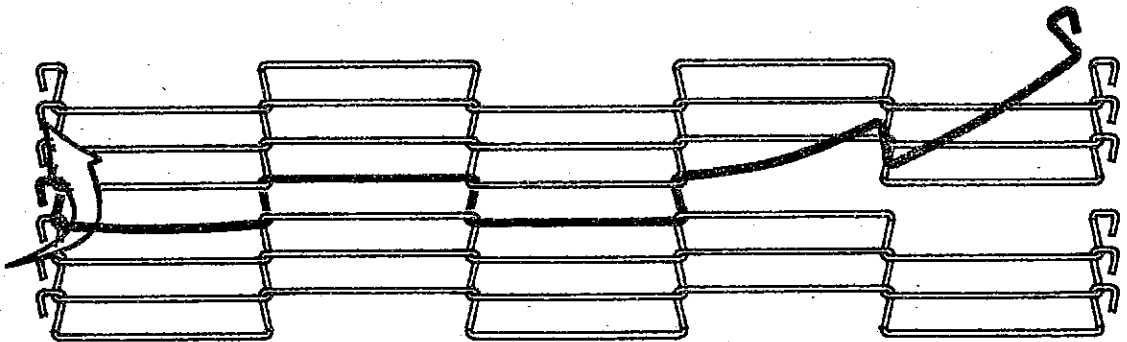


Splice one side completely before starting the other side.

5

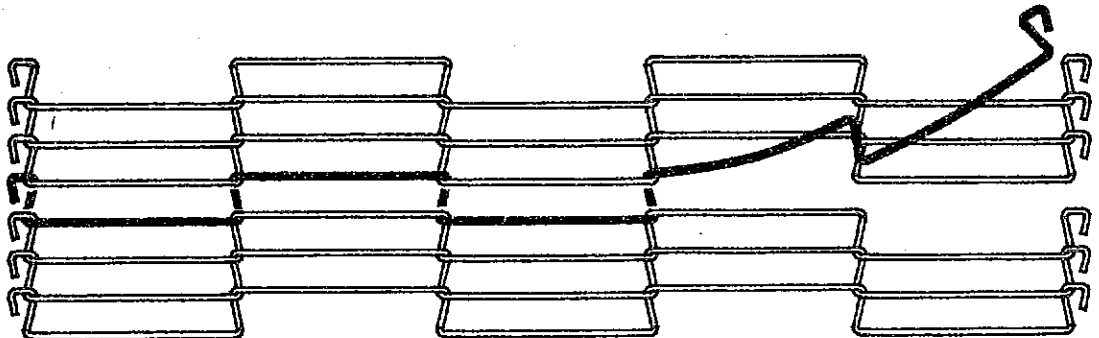


6



After completely splicing the belt, it is advisable to go along the width of the belt straightening the spliced-in strand.

7



TROUBLE SHOOTING CHART

The following trouble shooting chart is provided to aid in determining the source of any operation difficulties which 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 and so on. For checking electrical problems, use a voltage meter.

NOTE: While trouble shooting 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.

Refer to electrical components placement sheet and electrical schematic diagrams to assist you in you trouble shooting efforts.

PROBLEM

No element heat

PROCEDURE

- A. Check that the sealer is plugged in and that power is present at the socket.
- B. Check fuses.
- C. Do the trouble shooting checks below with seal bar temp set below set temp.
- D. Check for 220 volts going to heater cartridges at SSR-1 or SSR-2 by putting your test leads on heater cartridge wires. If there is 220V change heater cartridge.
- E. If not, check for 10-24 volt D.C. on wire #'s 21 & 20 on SSR-1 or #'s 22 & 23 on SSR-2. If there is 240 volts, change SSR, (be sure cartridge are calling for heat).
- F. If not, check voltage for 220V at coil of TT1 (wire #'s 4 & 3) or TT2 (wire #'s 4 & 3). If there is 220 volts, check temp controller manual for set up or replace temp controller.
- G. If no voltage at coil, check fuses again.
- H. Check thermocouples for broken wires or for dead short (seal bars may just keep heating if thermocouples have dead short).

Weak and/or poor seals

- A. Improper setting of temperature film cut off controller.
- B. Improper operating technique, (see operating instructions pg 14).
- C. Check sealing element cleaning.
- D. Wavy felt pad. Replace - see instructions pg 16.
- E. Sealing pad pressure incorrect (see page 16).
- F. Hold down pressure uneven or incorrect on magnets.

Magnetic hold down magnets not operating on magnet sealers (sealing head will not stay down) sealer operates normally otherwise

- A. Check for 220 volts (nominal) to primary of transformer T-1.
- B. If voltage is present to primary winding of T-1.
- C. Check for 30 (nominal) volts AC output from secondary of transformer T-1.
- D. Check for 30 (nominal) volts DC output from + (positive) and - (negative) terminals of REC-1. If no DC voltage, replace REC-1.
- E. Check wire circuit continuity to hold down magnets from REC-1.
- F. Check for circuit continuity through windings of hold down magnets.

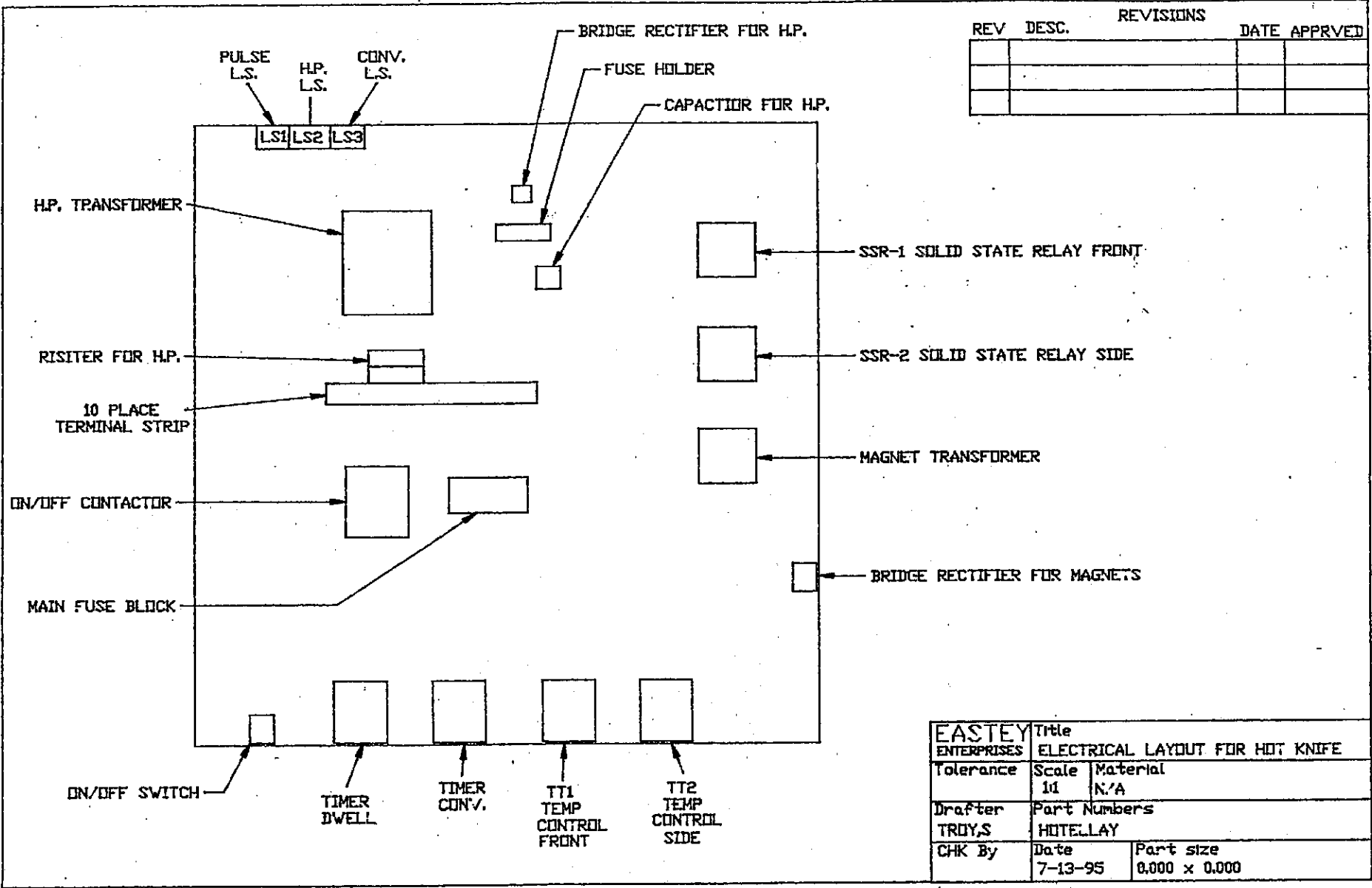
Excessive film drag

- A. Check for proper film threading, (see diagram pg. 13).
- B. Loosen film roll brake (see diagram pg. 13)

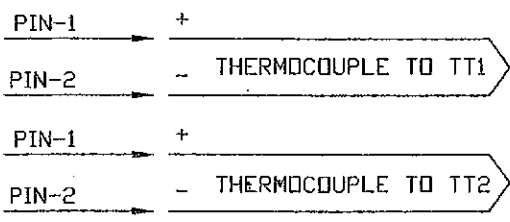
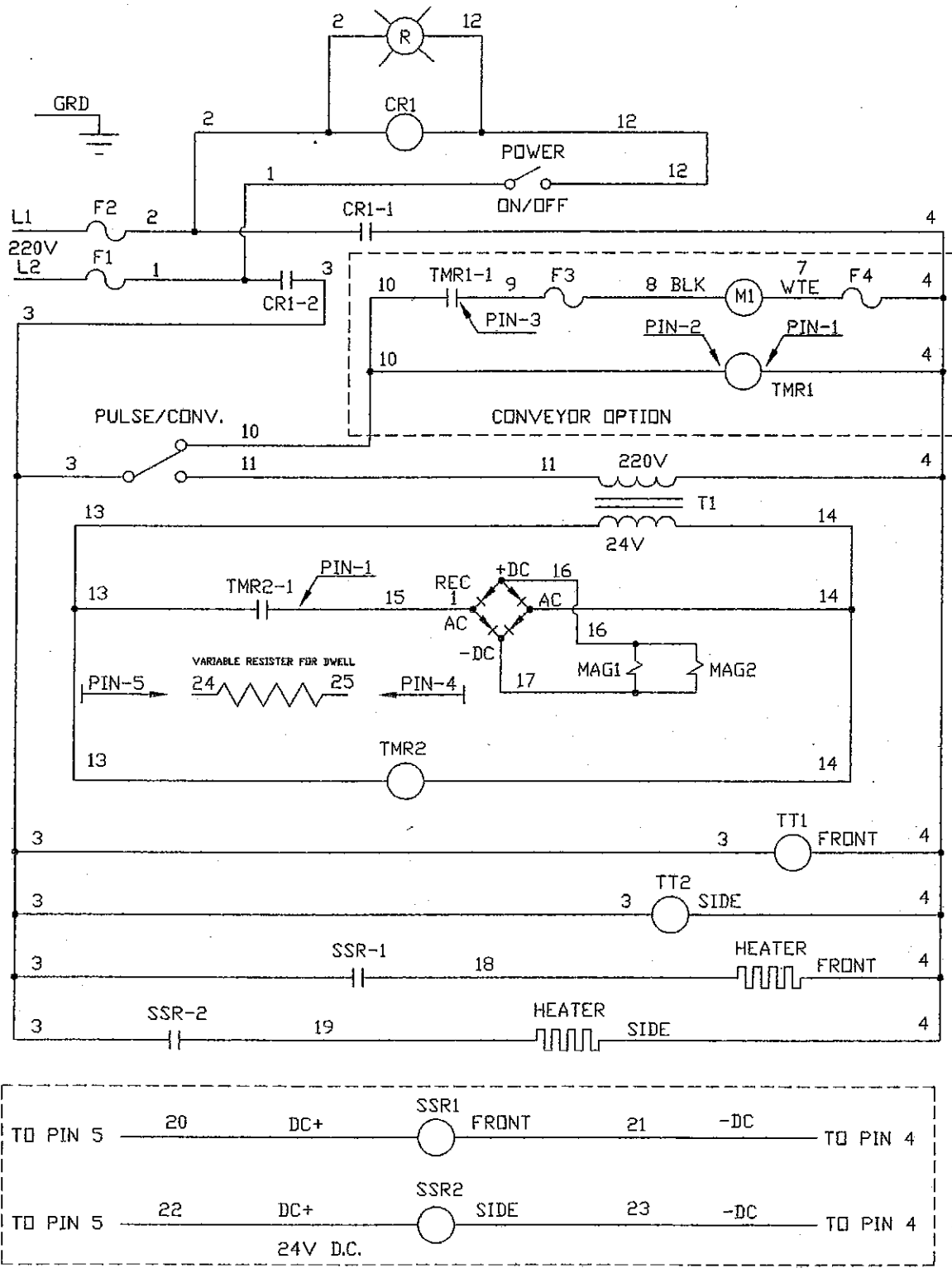
Excessive film winding or "spill"

- A. Tighten film roll brake

REV	DESC.	REVISIONS	DATE	APPROVED



EASTEY ENTERPRISES	Title ELECTRICAL LAYOUT FOR HOT KNIFE	
Tolerance	Scale 1:1	Material N/A
Drafter TROY,S	Part Numbers HOTEL,LAY	
CHK By	Date 7-13-95	Part size 0.000 x 0.000



EASTEY ENTERPRISES		Title ECONO SEALERS 220V W/CONV. OPTION	
Tolerance	Scale NONE	Material NONE	
Drafter TROY,S	Part Numbers RM000489		
CHK By	Date 12-4-98	Part size NONE	

PARTS LIST

Ordering Parts is Easy

Please indicate:

- A: The part number listed next to the picture of the part you need.**
- B. Quantity needed.**
- C. When needed.**
- D. Model of Eastey sealer parts are being requested for.**

**All parts are shipped UPS whenever possible
F.O.B. Rogers, Minnesota, 55374 U.S.A.**

Warranty: 1 year

Visa, Master Card & American Express accepted.

Phone: (888)212-7715 or (763)428-4846

Fax: (763)428-8361

parts@eastey.com

EASTEY ENTERPRISES HOT KNIFE SEAL SYSTEM

EM1622MK or TK SEAL SIZE 22"x16"	FRONT BAR WATTS 800	SIDE BAR WATTS 800	NAMEPLATE CURRENT RATING 10AM220v/20AMP110v
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ITEM	PART NUMBER	DESCRIPTION
F1 & F2	ET000301	10 AMP FUSE
	EAST1009	20 AMP FUSE
	ETC00309	POWER ON/OFF SWITCH
CRI	EAST0421	MAIN CONTACTOR (220v)
	ECOS0083	MAIN CONTACTOR (110v)
TMR-2	ECOS0051	TIMER DWELL (24v)
TMR-1	ECOS0052	TIMER CONVEYOR (220v)
	ECOS0085	TIMER CONVEYOR (110v)
LS-1	EAST0029	PULSE/CONVEYOR LIMIT SWITCH
M1	ECOS0095	CONVEYOR MOTOR
T1	EAST0036	MAGNET TRANSFORMER
REC-1	EAST0038	AC TO DC BRIDGE RECTIFIER
MAG 1 & 2	ECOS0057	ELECTRIC MAGNET HOLD DOWN
TT1 & TT2	ECOS0291	TEMPERATURE CONTROLLER
HEATER FRONT	ECOS0290	CARTRIDGE HEATER 22" (220volt)
	EAST0677	CARTRIDGE HEATER 22" (110volt)
HEATER SIDE	EAST0497	CARTRIDGE HEATER 16" (220volt)
	EAST0674	CARTRIDGE HEATER 16" (110volt)
SSR-1 & SSR-2	EAST0495	SOLID STATE RELAY
	EAST0493	THERMOCOUPLE FRONT & SIDE
F3 & F4	ECOS0515	.5 AMP FUSE (220volt)
F3	EAST0210	1 AMP FUSE (110volt)

EasteY Economy Sealer w/Hot Knife Replacement Parts List

EASTEY ENTERPRISES, INC
21480 147th Ave. No.
Rogers, MN 55374

Phone: (763) 428-4846
Fax: (763) 428-8361
Toll Free: (800) 835-9344

<i>Our Item #</i>	<i>Item Name</i>	<i>(Prices subject to change without notice)</i>
ECOS0282	ARM CASTING, INFEED - 16" SIDE SEAL	
ECOS0283	ARM CASTING, OUTFEED - 16" SIDE SEAL	
EAST0378	BEARING, FILM RACK ROLLER - LARGE	
EAST0379	BOLT, FILM RACK ROLLER - LARGE	
EAST0038	BRIDGE RECTIFIER	
ECOS0090	BUSHING, DRIVE - 1/2" BORE	
EAST0044	CASTER, 3" X 1 3/4"	
ECOS0045	CHAIN - #35 MASTER LINK (ECONO - MINI)	
ECOS0044	CHAIN - #35 RIVETED (ECONO & MINI)	
EAST0043	CONDUIT	
EAST0101	CONDUIT CONNECTOR, 1/2" 90 DEGREE	
EAST0102	CONDUIT CONNECTOR, 1/2" STRAIGHT W/NUT	
ECOS0083*	CONTACTOR - 1 POLE, 20 AMP, 110 VOLT	
EAST0421**	CONTACTOR - 2 POLE, 25 AMP, 220 VOLT	
ECOS0068	CONVEYOR ADJUSTING BRACKET - ECONO	
ECOS0099	CONVEYOR BELT, SS WIRE MESH - 14" WIDE, 1/4" X .050, 5SPL	
ECOS0069	CONVEYOR BELT, SS WIRE MESH - 16" WIDE, 1/4" X .050, 7SPL	
SUB00089	CONVEYOR CRANK HANDLE ASSEMBLY - OLD STYLE (ECONO)	
SUB00067	CONVEYOR W/MOTOR, EM1622 - COMPLETE	
ECOS0285	CROSS OVER BAR	
ECOS0817	CUTTING RULE, 16" - SIDE (SUPRA SILVERSTONE)	
ECOS0818	CUTTING RULE, 22" - FRONT (SUPRA SILVERSTONE)	
ECOS0816	DUO SEAL MUSHROOM INSERT, 16" SIDE BAR - SUPRA SILVERSTONE	
ECOS0815	DUO SEAL MUSHROOM INSERT, 22" FRONT BAR - SUPRA SILVERSTONE	
ECOS0286	DUO SEAL SEAL BAR, 16" UPPER SIDE	
ECOS0287	DUO SEAL SEAL BAR, 22" UPPER FRONT	
EAST0509	FELT PAD	
SUB00059	FILM RACK - W/O PIN PERF, (ECONO)	
SUB00051	FILM RACK - W/PIN PERF, (ECONO)	
SUB00123	FILM RACK GUIDE ASSEMBLY	
EAST0674	FIREROD CARTRIDGE HEATER, 16" - 110 VOLT	
EAST0497	FIREROD CARTRIDGE HEATER, 16" - 220 VOLT	
EAST0677	FIREROD CARTRIDGE HEATER, 22" - 110 VOLT	
ECOS0290	FIREROD CARTRIDGE HEATER, 22" - 220V, 600W	
ECOS0515	FUSE - .5 AMP, CERAMIC - SLO BLO / CONVEYOR	
EAST0210	FUSE - 1 AMP, 250 VOLT	
ET000301	FUSE - 10 AMP, 250 VOLT	
EAST1009	FUSE - 20 AMP, 250 VOLT - SEALERS	
ETC00125	FUSE BLOCK - 30 AMP, 2 POLE, 250 VOLT	
EAST0077	FUSE HOLDER	
EAST0165	HANDLE GRIP MATERIAL	
ECOS0020	HANDLE, METAL - FOR EM1622 ECONO SEALER	
EAST0461**	HEAD RETURN CYLINDER - COMPLETE	
EAST0087	HOLE PUNCH STRAIN RELIEF CONNECTOR	

Our Item # Item Name (Prices subject to change without notice)

EAST0511 HOT KNIFE SADDLE W/SLOT
EAST0514 HOT KNIFE SPACER BLOCK
ECOS0054 KNOB, DWELL SPEED POT
EAST0463 KNOB, FILM RACK GUIDE
ETC00210 KNOB, PIN PERF
ETC00002 KNOB, S HANDLE CONVEYOR
ECOS0060 LEGEND PLATE FOR DWELL SPEED POT - ECONO
ECOS0057 MAGNET, LOWER - NEW STYLE
SUB00065** MAGNET, UPPER - NEW STYLE
EAST0029* MICRO LIMIT SWITCH - SAFETY OVERRIDE - PULSE - CONVEYOR
ETC00310 MICRO SWITCH <ON/OFF> FACE PLATE
ECOS0095 MOTOR, CONVEYOR DRIVE - HIGH RPM
65000085AP PAINT, BLACK EPOXY PART A - PINT
65000085BP PAINT, BLACK EPOXY PART B - PINT
EAST0022 PILLOW BLOCK, 1"
SUB00061 PIN PERF ASSEMBLY ON SHAFT (ECONO)
SUB00057 PIN PERF ASSEMBLY ONLY
SUB00130 PIN PERF ASSEMBLY, TABLE TOP - 7 1/2" SHAFT W/1 PIN WHEEL
SUB00129 PIN PERF ASSEMBLY, TABLE TOP - 12 1/2" SHAFT W/1 PIN WHEEL
SUB00129A PIN PERF ASSEMBLY, TABLE TOP - 12 1/2" SHAFT W/2 PIN WHEELS
SUB00129B PIN PERF ASSEMBLY, TABLE TOP - 12 1/2" SHAFT W/3 PIN WHEELS
SUB00128 PIN PERF ASSEMBLY, TABLE TOP - 24" SHAFT W/8 PIN WHEELS
EAST0367 PIN PERF GUARD
EAST0368 PIN PERF LOWER PAD
EAST0366 PIN PERF WHEELS - FOR 5/8" SHAFT
ECOS0089 POWER CORD - USED ON 110V
ECOS0010 PRODUCT SEPARATOR TRAY, ECONO
EAST0495 RELAY, SOLID STATE
ECOS0048 ROLLER, 20" FILM RACK - LARGE
SUB00060 ROLLER, FILM RACK - COMPLETE (ECONO)
ECOS0255 SAFETY SHIELD, FRONT - INNER
ECOS0254 SAFETY SHIELD, FRONT - OUTER
ECOS0253 SAFETY SHIELD, SIDE - INNER
ECOS0252 SAFETY SHIELD, SIDE - OUTER
ECOS0026 SEAL BAR, 16" SIDE - LOWER
ECOS0025 SEAL BAR, 22" FRONT - LOWER
ECOS0018 SHAFT, 25 1/2" REAR HEAD RETURN (ECONO)
ECOS0039 SHAFT, CONVEYOR DRIVE - FOR LIVE ROLLER (ECONO)
ECOS0038 SHAFT, CONVEYOR IDLER - COMPLETE (ECONO)
ECOS0049 SHAFT, PIN PERF
ECOS0047 S-HANDLE FOR CONVEYOR (OLD STYLE - NOT THREADED)
EP000095 SPACER BLOCK WITH HOLE, HOT KNIFE
EAST0515 SPACER BLOCK, CORNER
ECOS0050 SPEED POT DWELL (ECONO & MINI)
EAST0209 SPONGE RUBBER, 1/4" X 3/4"
EAST1007 SPRING, SAFETY SHIELD RETURN
ECOS0036 SPROCKET, CONVEYOR DRIVE SHAFT - DELRON (ECONO & MINI SEALER)
ECOS0037 SPROCKET, IDLER BLANK - 3/4" BORE (ECONO & MINI SEALER)
ECOS0040 SPROCKET, LIFT MECHANISM (ECONO)

<i>Our Item #</i>	<i>Item Name</i>	<i>(Prices subject to change without notice)</i>
ETC00309	SWITCH, ON/OFF POWER	
ETC01026	TEFLON SLEEVE 6" (ONLY) FOR GUIDE BOLT ON FILM RACK	
ECOS0291	TEMPERATURE CONTROLLER - 220V	
ECOS0292	TEMPERATURE CONTROLLER SOCKET	
EAST0493	THERMOCOUPLE	
EAST0560	THREADED ROD, 5/16-18 X 6" HOT KNIFE	
ECOS0085	TIMER, CONVEYOR - 110 VOLT (ECONO)	
ECOS0052	TIMER, CONVEYOR - 220 VOLT (ECONO)	
ECOS0051	TIMER, DWELL (ECONO)	
SUB00488	TRANSITION CHUTE - TRANSFER BETWEEN SEALER & TUNNEL	
ECOS0080	WEAR RAIL, TEFLON - LOWER (NO CHANNEL NEEDED)	
ECOS0079	WEAR RAIL, TEFLON - UPPER (NO CHANNEL NEEDED)	
ECOS0251	WIRE GUARD, 16" - SIDE	
ECOS0250	WIRE GUARD, 22" - FRONT	



Shrink Packaging Equipment

PREVENTATIVE MAINTENANCE FOR ALL SEALERS

Once A Day:

1. On hot wire sealers with power on, activate the pulse switch to heat up the seal wires, then with a fine brass brush clean off any film residue on the seal wires and green beads.
2. On hot knife sealers heat the seal bars up to temperature, (be careful of the coatings on the bars and inserts) then using a soft cloth wipe the seal surfaces clean , never use anything abrasive.
3. Check the condition of the Teflon tape and the Silicone sponge rubber in the lower seal bar, replace as necessary.

Once a Month:

4. Check seal head alignment, and the magnets gap, refer to the service adjustment section in your owner's manual, and make adjustments as needed.
5. Check the compensator for correct air gap, and that the wing nut is tight, adjust as needed.
6. Check the conveyor drive belt condition, replace if necessary.
7. Check the conveyor belt for nicks, and tears, for tracking and moving smoothly, repair or replace as needed.
8. Check that the conveyor lift jack moves the conveyor up and down smoothly, lubricate and adjust as needed.
9. Check the film rack rollers for excessive endplay, for turning freely, and that the film brake works, adjust as needed.
10. Check the condition of the power cord for wear (is it exposed to traffic ?).
11. Check the hot knife seal heads ability to maintain the set temperature, if not refer to your owners manual.
12. Check for loose fasteners tighten as necessary.
13. Check the condition of all warning and instructional labels, replace as necessary.