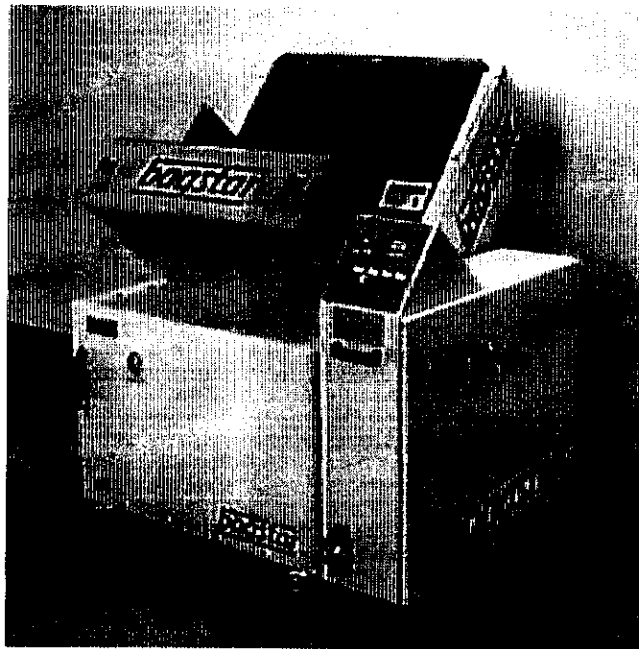


# INSTRUCTION MANUAL

## BAGSTAR 2



Automatic  
Sealing Machine

OPTIMA CORPORATION  
1330 Contract Drive  
Green Bay, WI 54304  
U.S.A.

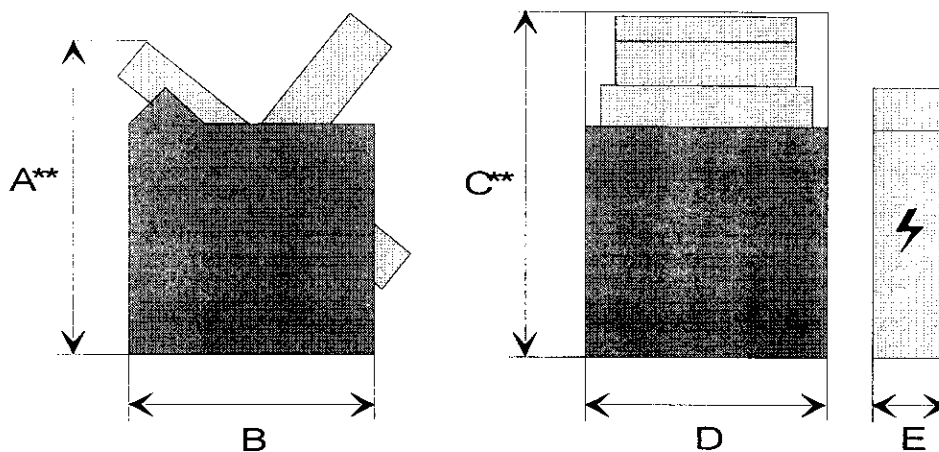
Tel. (414) 339 2222  
Telefax (414) 339 2233

**B. Technical data**

**I. BAGSTAR 2 Slant version**

**1. Weight and dimensions**

	approx. weight in kg
Bagstar 2 with control cabinet	450



A**	B	C**	D	E
900	760	1250	780	200

\*\* Add 100 mm for machine on castors (all dimensions shown are mm)

**2. Output Bagstar 2 Slant Version**

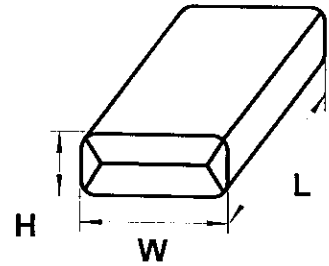
Max. output up to 25 bags / minute

(depending on pack size, accessories and operator skills)

### 3. Format range

Dimensions of formation (mm)

Length	min / max	100 / 400
Width	min / max	60 / 320
Height	min / max	40 / 160



### 4. Electrical requirements

Voltage	110 / 220	V
Frequency	60 / 50	Hz
Power consumption	approx. 1	kW



Please note: Check voltage and frequency before connecting!!!

### 5. Pneumatic requirements

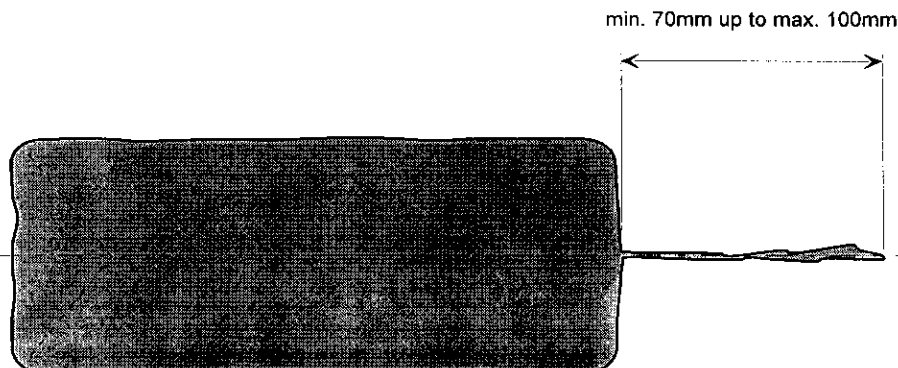
Air pressure	min. 6	bar, oil free
Connection diameter	1/2	inch
Air consumption	approx. 38	NL/cycle*

(\* +/- 20% depending on product infeed, accessories and machine settings)

### 6. Required bag dimensions



Please note: For proper machine operation it is necessary that the bag trim is neither too long nor too short!

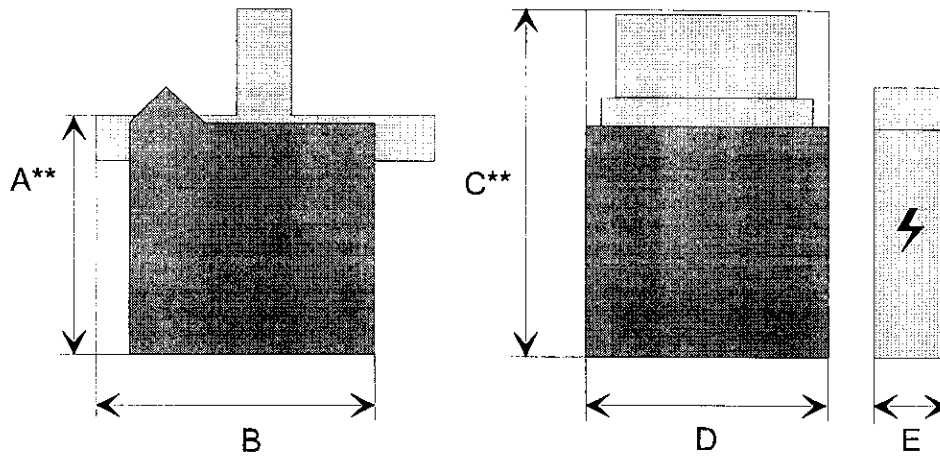


**B. Technical data**

**II. BAGSTAR 2 Horizontal version**

**1. Weight and dimensions**

	approx. weight in kg
Bagstar 2 with control cabinet	500



A**	B	C**	D	E
700	910	1250	780	200

\*\* Add 100 mm for machine on castors (all dimensions shown are mm)

**2. Output Bagstar 2 Horizontal Version**

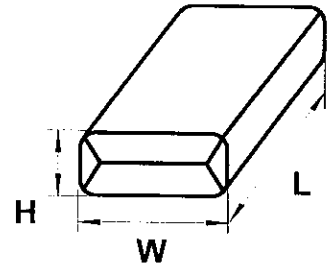
Max. output up to 25 bags / minute

(depending on pack size, accessories and operator skills)

### 3. Format range

Dimensions of formation (mm)

Length	min / max	100 / 400
Width	min / max	60 / 320
Height	min / max	40 / 160



### 4. Electrical requirements

Voltage	110 / 220	V
Frequency	60 / 50	Hz
Power consumption	approx. 1	kW



Please note: Check voltage and frequency before connecting!!!

### 5. Pneumatic requirements

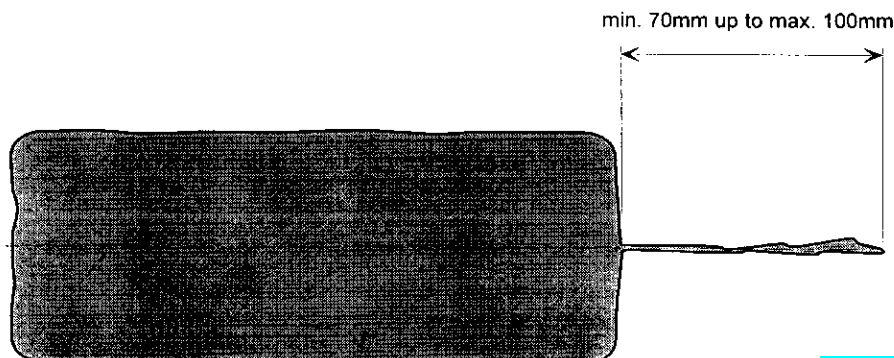
Air pressure	min. 6	bar, oil free
Connection diameter	1/2	inch
Air consumption	approx. 38	NL/cycle*

(\* +/- 20% depending on product infeed, accessories and machine settings)

### 6. Required bag dimensions



Please note: For proper machine operation it is necessary that the bag trim is neither too long nor too short!



## 7. Film quality recommendations

### Packaging machine facts:

- The packaging machine works with impulse sealing.
- The shape of the sealing wire determines the cutoff welding.
- The force at the welding bar is approx. 1800 N.  
The lateral seal has to stand a stretching of 10 % with regards to flat bag width.
- The sealing temperature should be as low as possible as the impulse sealing wire is covered with teflon and a long lifetime should be guaranteed.
- The film should not keep the heat (welding temperature) too long after the welding process as otherwise the following package will "stick up"

### Film recommendations:

- Melting index MFI (g/10min) 1.8 - 2.2
- Blow ratio about 1 : 3
- Sliding means PPM 300 - 380
- Density (g/cm<sup>3</sup>) 0.920 - .922
- EVA influences the ability to be welded in a positive way, may therefore be added.
- Titanium dioxide should be avoided as it is not favorable for welding. Film with titanium dioxide takes up a lot of heat and keeps the temperature in the film. On the other hand titanium dioxide is necessary for the color if you use e.g. white film. Generally, 5 - 7 % color is used. These 5 - 7 % contain 70 % titanium dioxide with 3 - 4 % EVA.
- As far as laminated film is concerned we have to point out that the glue lamination between the film layers influences the welding ability in a negative way. Conclusion: As less glue running as possible. You also have to take care that the single film layers have the same melting temperature and MFI. If the temperature is different, the "window" for our impulse sealing will become too small.
- The film for single wrapped products may be very slick. This leads to a break out of the products when pressing them laterally. In this case blocking film may counteract which makes the outside a little rougher without reducing the printing quality.
- Open printing (opened to the outside) leads to an accumulation of color at the guiding parts and thereby to a strong draft of the lateral products.
- Closed printing may be too slick again. Remedy: blocking film.

Advice for machine operation

- According to film suppliers there may be the same bad result with a too high welding temperature when using critical films and with a temperature that is too low. Bag trim is not cut off.
- Under this aspect the new film qualities are much more sensitive.
- We always recommend a discussion between customer, film supplier, and OPTIMA.