

S-FS/FQ SERIES
IMPULSE PEDAL SEALER

INSTRUCTIONS

1.USAGE

The S-FS series impulse sealers is to seal the bag with material polyethylene, polystyrene, as well print the production date and expire date. Sealing time is controlled by electric and easy adjuston.

It is widely used in factory, shop and serivce filed, such as food, pharmacy, daily cosmetics, rice, soybean, hardware store and service sector.

2.MAIN DATA AND SPECIAFICATIONS

MODEL	S-FS/FQ 350	S-FS/FQ 450	S-FS/FQ 600	S-FS/FQ 800
LENGTH	350mm	450mm	600mm	800mm
WIDTH	2 ~ 5mm	2 ~ 5mm	2 ~ 5mm	2 ~ 5mm
VOLTAGE	220v	220v	220v	220v
Air pressure MPa	0.4(Pneumatic model only)			
TIME (S)	0 ~ 2.5	0 ~ 2.5	0 ~ 2.5	0 ~ 2.5
POWER (W)	1250	1200	1500	1500
DIMENSION (mm)	450*510*880	550*520*880	700*570*880	800*600*880
WEIGHT (kg)	32	34	37.5	40

3.ADJUSTMENT

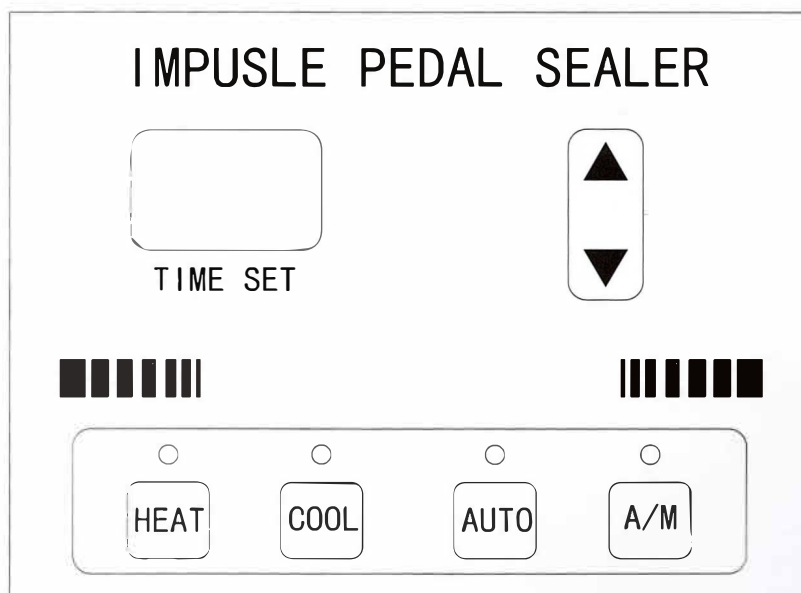


Figure 1) control panel

3.1 connect the power, note that the usage power must be the same as the machine mark. The red light is on, adjsut the sealing time according to the bag material and its thickness.

3.2 cooling (sealing jaw open time)time, press the A/M key, and press the cool key, then press the ▲ or ▼ key to adjust the time.

3.3 press the A/M key, the machine is in the state of manual operation. Put the bag into sealing jaw, and press the pedal switch, the electromagnetic works and drive the sealing jaw close and seal. When the seal time reach, the electromagnetic works and lift the upper sealing jaw. Then take out the bag and finish the sealing time.

3.4 if the bag isn't sealed, prolong the sealing time until good sealing. Press the A/M key to shift automatic state.

3.5 set the seal and cool time, and press A/M key to automatic work, press the A/M key again and shift to manual state.

4. CAUTION AND MAINTENANCE

4.1 Not allow to seal without bag. If plastic melt on the teflon sheet, don't scrap by hard obejct to clear. The clean way is that seal the plastic bag again, the plastic will be come with bag.

4.2 heating element replace, loose the nut and open the Teflon cloth. Loose the both sides of red cover and remover the botle in brass block and replace the new heating element. The heating element is in tension state under the funtion of spring. Clearn the oxidized brass block by sand paper and keep contact with heating element. Keep the heating element straight and smooth under the teflon sheet.

4.3 teflon sheet replace, remove the nut and press board, and cut the burn parts and pull out the teflon sheet, then fix back the press board and nut, keep the teflon sheet smooth, otherwise the seal quality will be affected.

4.4 proximity switch replace, there is one proximity swtich at the side of the machine head, it must be replaced when it is damaged, the adjustment of the pressing pole for

proximity switch: put 1 mm thick paper between the upper and low pressing nuts, check if the switch is pressed and a “click” sound from the switch. If it is not pressed, adjust down the pressing pole or tighten the nut until the switch is pressed 1-2mm down when it works.

4.4 always keep the sealing surface clean, otherwise the remains in the sealing surface will shorten the life of heater and teflon sheet. When working, never clean the sealing surface with wet cloth.

4.6 After long time usage, the rubber in the upper pressing arm must be checked if it is still flat and straight. Otherwise, the seal quality will be affected.

4.7 Lubricating oil into the moving parts periodically.

4.8 all parts in the machine should not be disassembled casually.

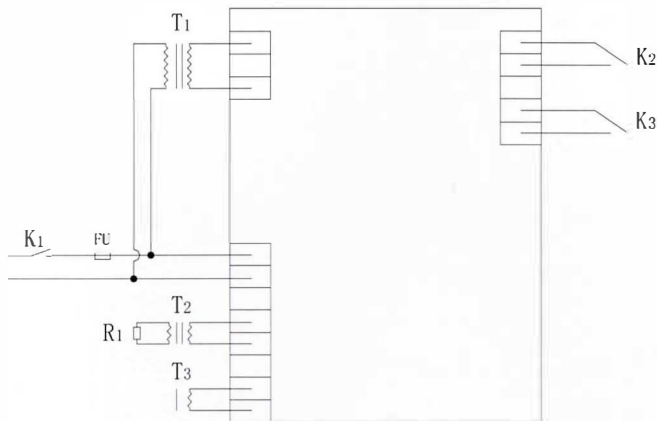
5. TROUBLES AND SOLUTION

1) Pedal impulse trouble solution:

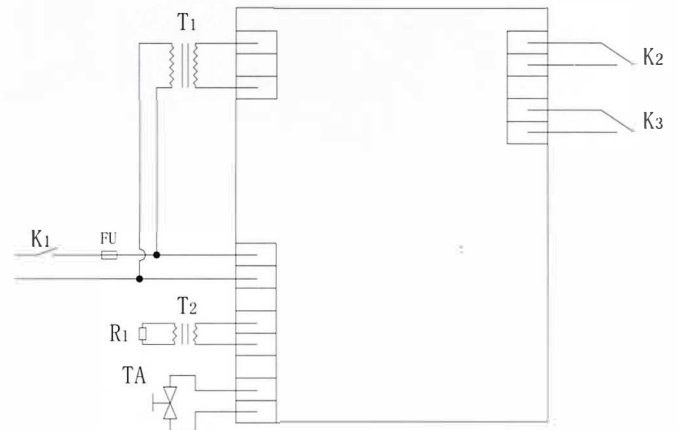
Trouble	Reason and solution
Machine don't work	1. check the inputting power is corrected 2. check if all contactors are connected well.
The seal isn't good	To lengthen the sealing time if seal is not tight enough, to shorten the sealing time if the seal is melted. Or the melted seal is caused by not being pressed tightly.
The seal is wrinkled	1. overheating, shorten the sealing time as possible on the condition that the good seal of the bag is guaranteed. 2. insufficient time for cooling, lengthen the cooling time
The power indication light off or the heat element don't work.	Check if the power switch is on, the fuse is well.
The power light on, heat indication light off, and the heat element don't work	Treadle the pedal, check if the proximity switch works, adjust the distance of proximity switch.
The sealer is always electrified when the power is on	Turn off the power at once, check if the proximity switch works.

6. DIAGRAM OF ELECTRICAL PRINCIPAL

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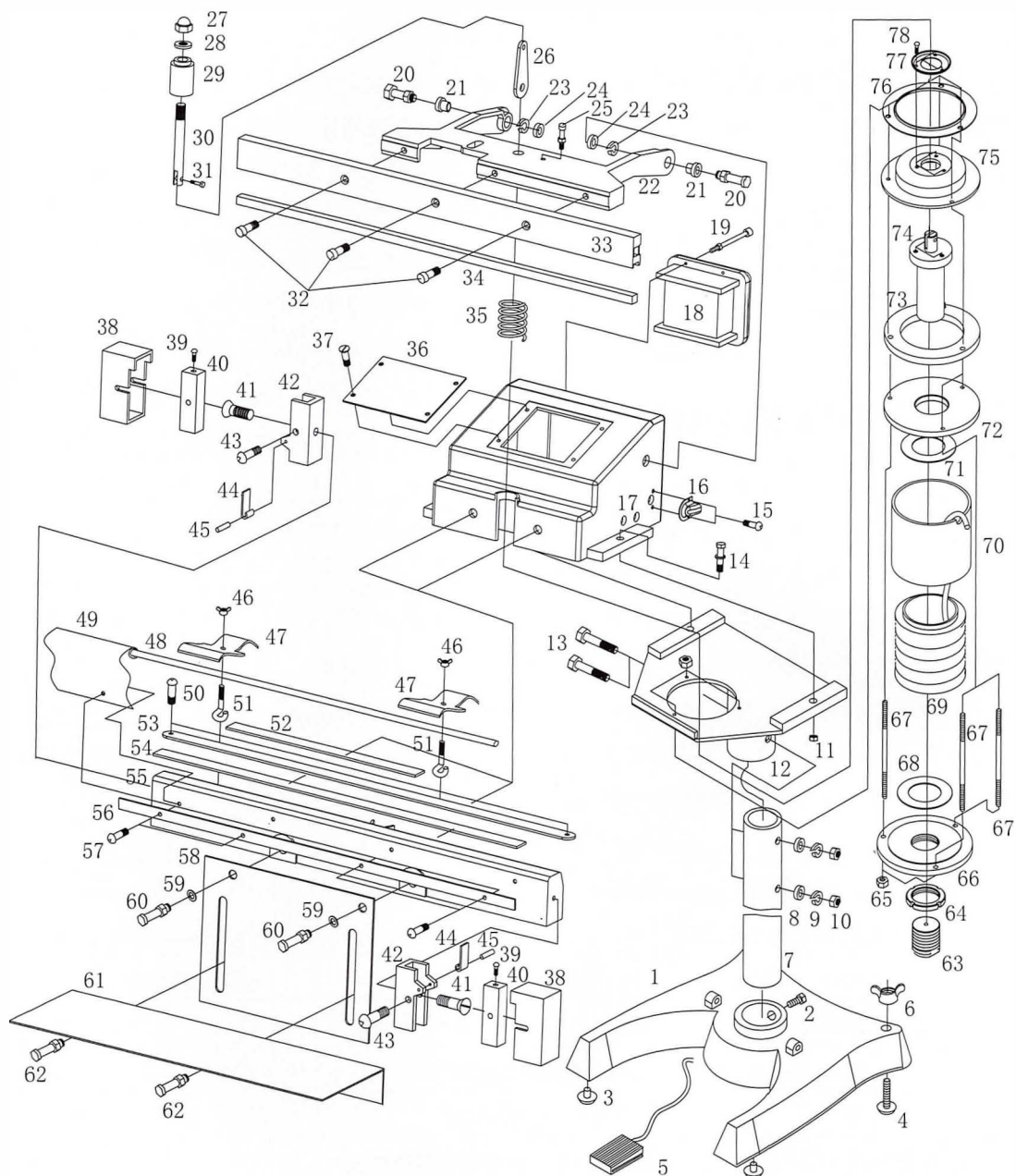


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7. ELEMENT LIST

NO	CODE	NAME	QUANTITY
1	K1	SWITCH	1
2	K2	MICROSWITCH	1
3	K3	PEDAL SWITCH	1
4	T1	SMALL TRANSFORMER	1
5	T2	BIG TRANSFORMER	1
6	T3	ELECTROMAGNETIC IRON	1
7	R1	HEATING ELEMENT	1
8	FU	FUSE	1

8. ACCESSORIES DIAGRAM



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9. SPARE PARTS S-FS SERIES

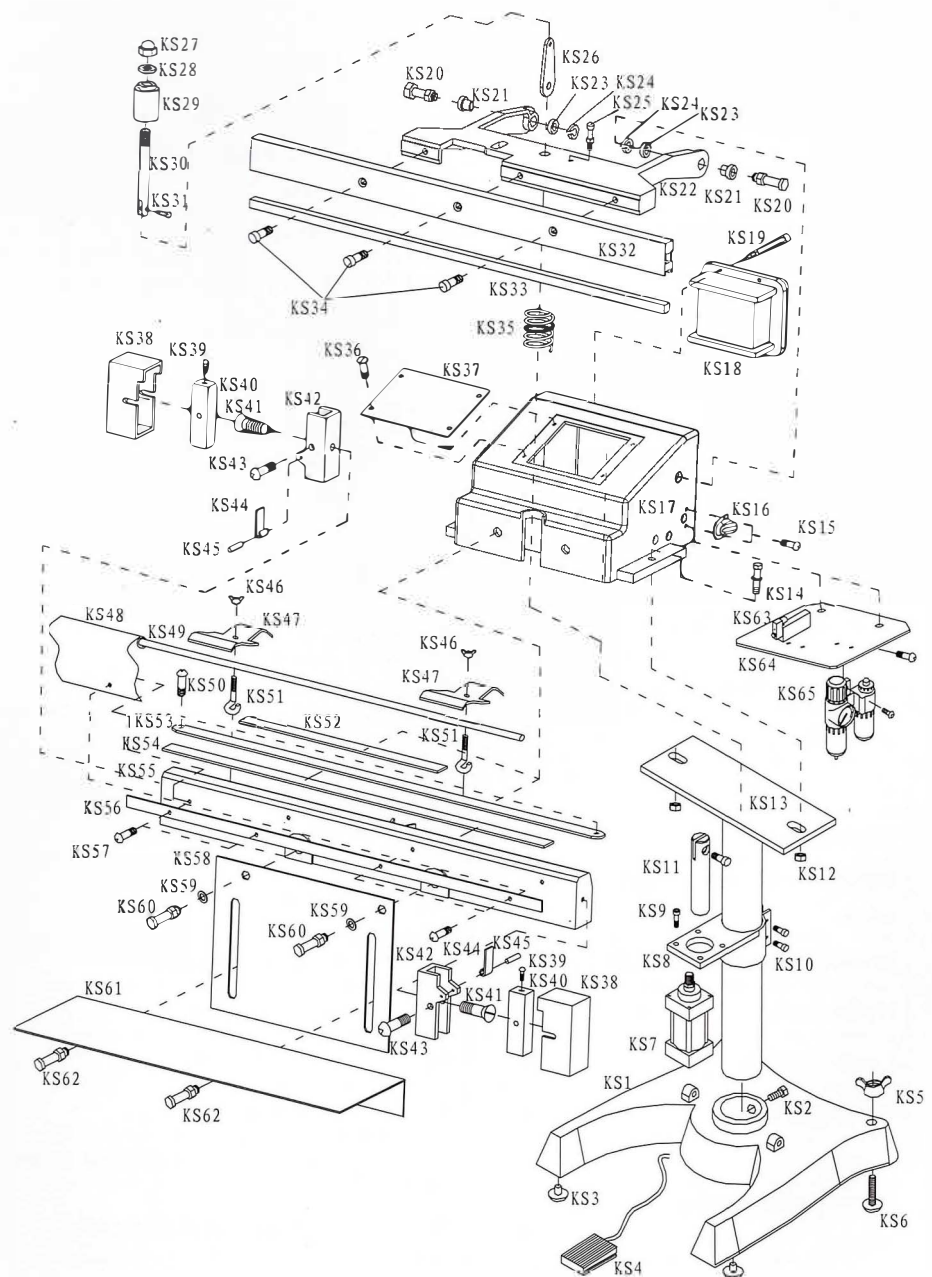
No	Name	Qty	No	Name	Qty
1	Machine base	1	33	Upper sealer	1
2	Bolt	1	34	Silicon rubber	1
3	Rubber washer	3	35	Spring	1
4	Foot screw	1	36	Operation panel	1
5	Pedal switch	1	37	Fixing bolt	4
6	Butterfly nut	1	38	Red protecting cover	2
7	Column	1	39	Fixing bolt	2
8	Pin washer	2	40	Fixing copper block	2
9	Spring washer	2	41	Front protection cover bolt	2
10	Lock nut	2	42	Front protection cover	2
11	Connecting nut	2	43	Copper block bolt	2
12	Sealing jaw base	1	44	Adjusting bock	2
13	Connecting bolt	2	45	Round bolt	2
14	Connecting bolt	2	46	Locking nut for teflon pole	2
15	wire protection bolt	2	47	Teflon pressing board	2
16	Wire protection	1	48	Teflon pole	1
17	Sealing jaw	1	49	Teflon	1
18	Big transformer	1	50	Heating element bolt	2
19	Transformer bolt	2	51	Locking screw	2
20	Connecting bolt for sealing frame	2	52	Pressing board	1
21	Washer	2	53	Heating element	1
22	Upper sealing frame	1	54	Sperated board	1
23	Spring washer	2	55	Base	1
24	Pin washer	2	56	Teflon pressing board	1
25	Proximity siwtch bolt	1	57	Pressing board bolt	4
26	Connecting board	1	58	Vertical flat pad	1
27	Cap nuts	1	59	Washer	2
28	Washer	1	60	Locking bolt	2
29	Rubber washer	1	61	Horizontal flat pad	1
30	Rubber washer	1	62	Flat pad bolt	2
31	pole	1	63	Adjusting screw	1
32	Fixing screw of upper sealer	3	64	Locking nut	1

No	Name	Qty	No	Name	Qty
65	Cap	6	72	Lower washer	1
66	Lower flange	1	73	Upper locking ring	1
67	Screw pole	3	74	Axis	1
68	Rubber washer	1	75	Rubber cap	1
69	Wire	1	76	Pressing ring	1
70	Shell	1	77	Locking ring	1
71	Upper washer	1	78	Locking nut	3

10. PACKING LIST

Name	Specification	Quantity
Machine		1pc
Manual guide		1pc
Accessory		
Heating element		2pcs
Active spanner	6inch	1pc
Teflon sheet		1pc
Screwdriver	Cross, straight 3inch	Each 1
Fuse	2-15A	2-4pcs

10. ACCESSORIES DIAGRAM



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11. SPARE PARTS S-FQ SERIES

No	Name	Qty	Name	Qty	No
1	Machine base	1	34	M8x16 inner hexagon sc	3
2	M10x25 HEX HEAD SCREW	1	35	Big spring	1
3	Foot Pad	3	36	M4x10 semi-round head screw	4
4	Pedal switch	1	37	Rear cover	1
5	M10 Butterfly nut	1	38	protection cover	2
6	Foot Pad screw	1	39	M4x6 semi-round head copper screw	2
7	SU50X40 cylinder	1	40	Connection cover	2
8	Cylinder holder	1	41	M5x12 socket head cap screw	2
9	Cylinder bolt	4	42	Connection cover	2
10	Cylinder holder set screw	2	43	M3x8 semi-round head screw	2
11	Connecting bar	1	44	Small tabletting	2
12	Machine head connecting nuts	2	45	pin	2
13	Base support	1	46	M6 Butterfly nut	2
14	M10x50 HEX HEAD SCREW	2set	47	Press block	2
15	M4x8 semi-round head screw	1	48	Heat sealing cloth	1
16	cable clamp	1	49	Press bar	1
17	Machine body	1	50	M6x25 semi-round head screw	2
18	transformer	1	51	Press block screw	2
19	M5x45 semi-round head screw	4	52	Pressing bar	1
20	M10x40 HEX HEAD SCREW	2	53	Heating element	1
21	Nylon cover	2	54	bakelite plate	1
22	Lower washer	1	55	Lower washer	1
23	Nylon cover	2	56	Lower washer	1
24	washer	2	57	M4x8 semi-round head screw	4
25	M6 hexagon socket head cap screw	1	58	Vertical connection plate	1
26	Connecting board	1	59	gasket	2
27	M12 cap nuts	1	60	M8x25 HEX HEAD SCREW	2

28	nuts	1	61	Horizontal connection plate	1
29	Rubber washer	1	62	M8x25 HEX HEAD SCREW	2
30	pole	1	63	electromagnetic valve	1
31	Fixing screw of upper sealer	1	64	Fixing board	1
32	Upper washer	1	65	Two piece	1
33	Silicon rubber	1			

12. PACKING LIST

Name	Specification	Quantity
Machine		1pc
Manual guide		1pc
Accessory		
Heating element		2pcs
Active spanner	6inch	1pc
Teflon sheet		1pc
Screwdriver	Cross, straight 3inch	Each 1
Fuse	2-15A	2pcs