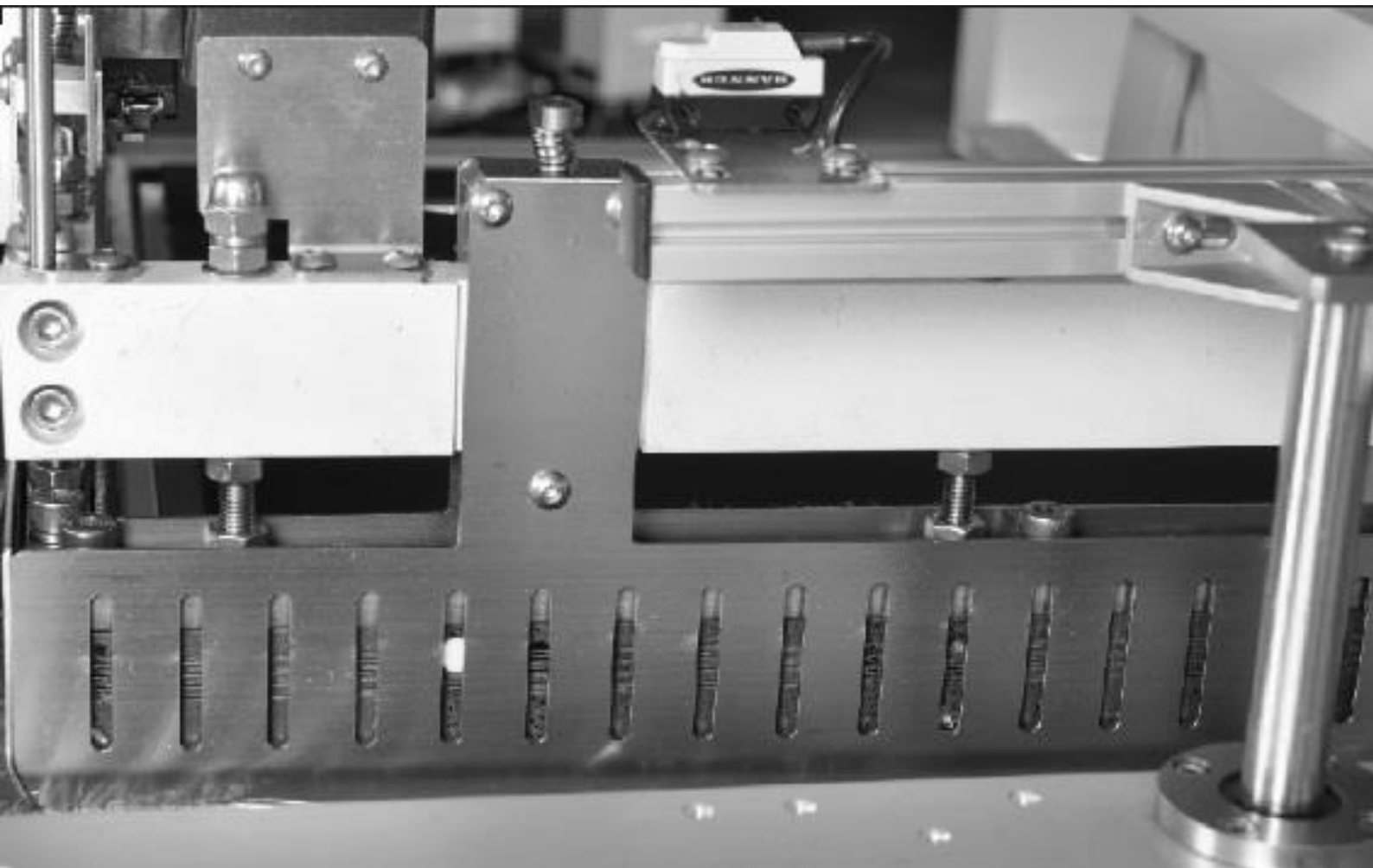




AN ISO 9001:2015 CERTIFIED COMPANY

USER MANUAL

Automatic L - Sealer

QS5545LA

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1. FOREWORD

Thank you for choosing Sevana. You now belong to the Sevana family of over one million satisfied customers across the world. We are confident that you will have many years of complete satisfaction from this Sevana product.

We want you to derive maximum value from Sevana's reliable service and support infrastructure in India. We maintain Sevana's service mission of working continuously to provide customers with highest level of service, thereby ensuring mutually successful long term business association.

You can contact us through

Email	:	support@sevana.com	
Phone	:	+91-484-2680780	Monday to Saturday
Mobile	:	+91-9388180781	8.30 am – 5.00pm IST

We value your partnership

Yours sincerely

For Sevana Electrical Appliances Pvt. Ltd.

Manager in charge, Customer support

While contacting the support centre kindly provide the following information for a speedier support and service.

- i. Model
- ii. Serial no.
- iii. The nature of problem

2. HOW TO USE THIS MANUAL

- ❖ Please read this manual carefully before installing and commissioning the machine.
- ❖ Please keep a copy of this manual for reference near the machine.

The information in this document is believed to be accurate and reliable. However, Sevana Electrical Appliances Pvt Ltd, cannot accept any financial or other responsibilities that may result from the use of this information. No warranties are granted or extended by this document.

Sevana Electrical Appliances reserves the right to change any or all information contained herein without prior written notice. Revisions may be issued at the time of such changes and/or deletions.

3. SAFETY PRECAUTIONS

Machines of Sevana have been designed to provide extremely safe and dependable operation when properly used. Safety precautions must be observed during normal operation and when servicing the machines of Sevana.

- a. The machine has to be grounded properly before using.
- b. Do not place your hand and finger on the sealing/cutting blade while the machine is in operation.
- c. Do not put any metal/hard parts on the sealing/cutting blade.
- d. Do not allow any liquid to go in to the machine.
- e. Isolate electric and pneumatic power at the end of every day's operation.
- f. Clean the machine with compressed air at the end of every day's operation
- g. Kindly do not leave any tools or objects on the machine.
- h. While doing any periodic or preventive maintenance on the machine; ensure that the electric and pneumatic power is isolated to prevent any injury to the person.

4. PACKING SLIP

Name	Quantity
User manual	1
Tool set	1
Machine	1

5. TECHNICAL SPECIFICATIONS

Machine's dimensions (L x W x H)		1720mmx1080mmx1470mm(+50*)
Conveyor belt top height		790 mm + 50 mm
Maximum seal dimensions(WXL)		450 mm × 500 mm
Conveyor speed	In feed	15 mtr/min
	Out feed	15 mtr/min
Sealing temperature		50-250°C The sealing temperature may be set depending on the ambient temperature, thickness and type of film.
Power supply		Single phase, 240 Vac , 50Hz, 2.5KW
		(1) In-feed conveyor motor : 90W
		(2) Out-feed conveyor motor : 90W
		(3) Film providing motor : 45W
		(4) Film clipping motor : 45W
		(5) Film rolling motor : 45W
		(6) Heater Horizontal sealing : 900W Longitudinal sealing : 1200W
Air supply input		6-8 bar
Sealing time		Normally 0.8sec; it can be adjusted according to grade and thickness of film
Suitable film		POF

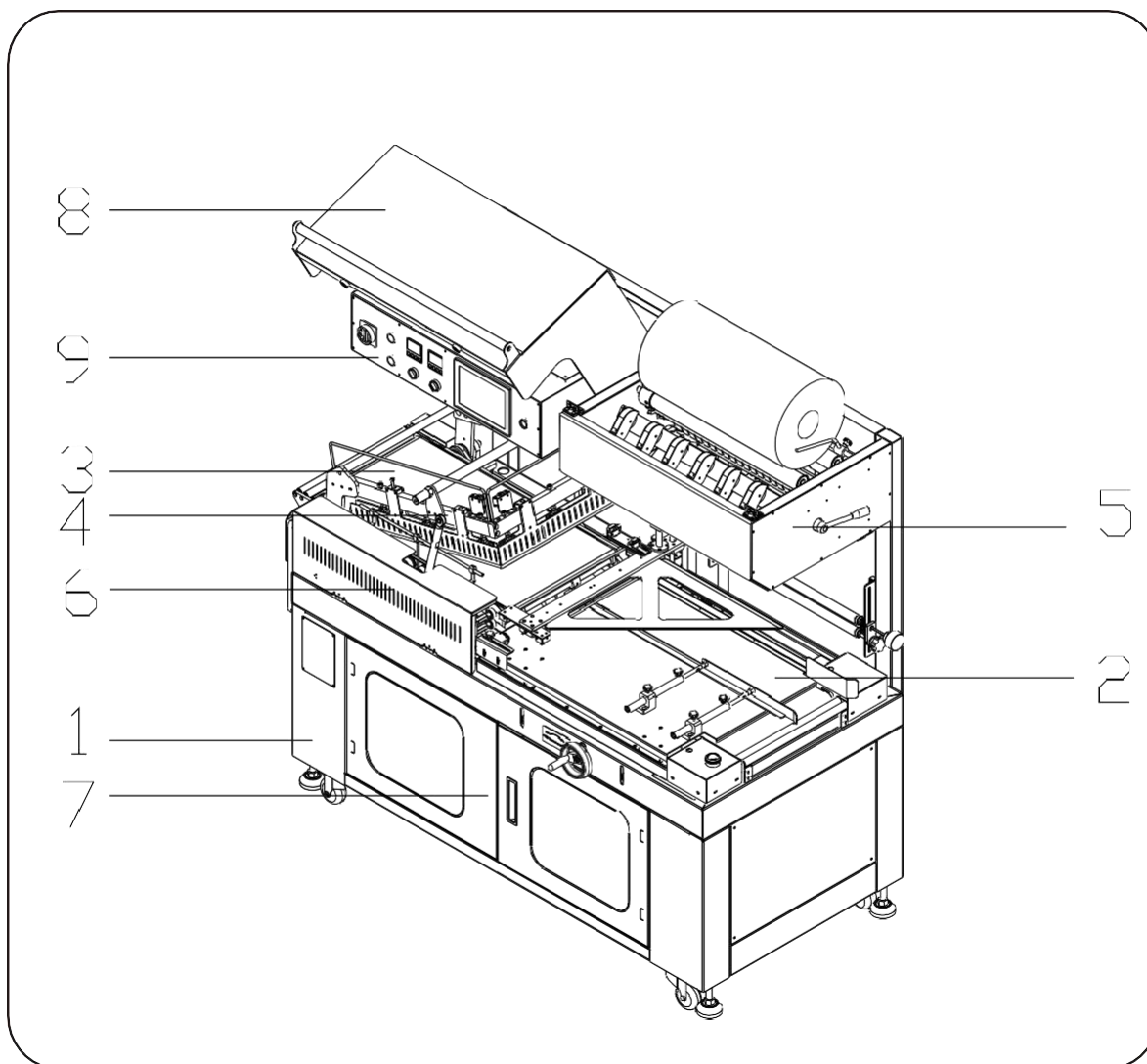
6. UNPACKING

Note: Please verify the items with the packing slip.

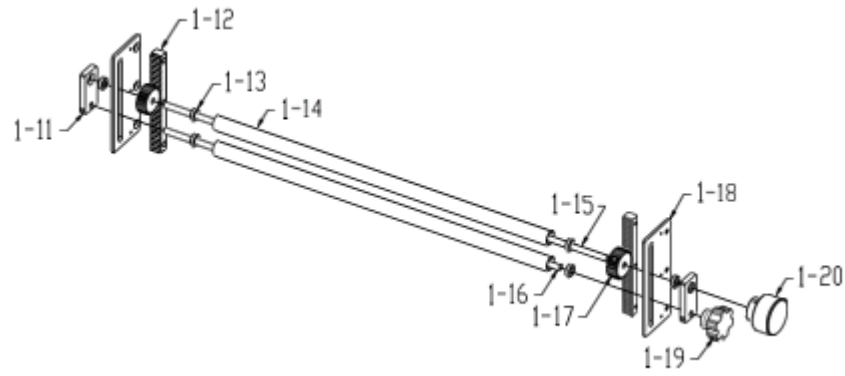
- ❖ Inspect for any transit damage. If there are any, notify your dealer/transporter/insurance company or us immediately.
- ❖ The machine is shipped well packed in a wooden box with four bolts holding the machine to the bottom panel.
- ❖ Place the wooden box with the “TOP” Marked to the top.
- ❖ Remove all the side panels and top panel of the box.
- ❖ Lift the machine with the bottom panel using a pallet jack.
- ❖ Remove the packing bolts.
- ❖ Remove all packing materials.
- ❖ Lower the pallet jack and slide the machine to the floor.

Tools required to unpack
• Pry bar/Crowbar • Claw hammer

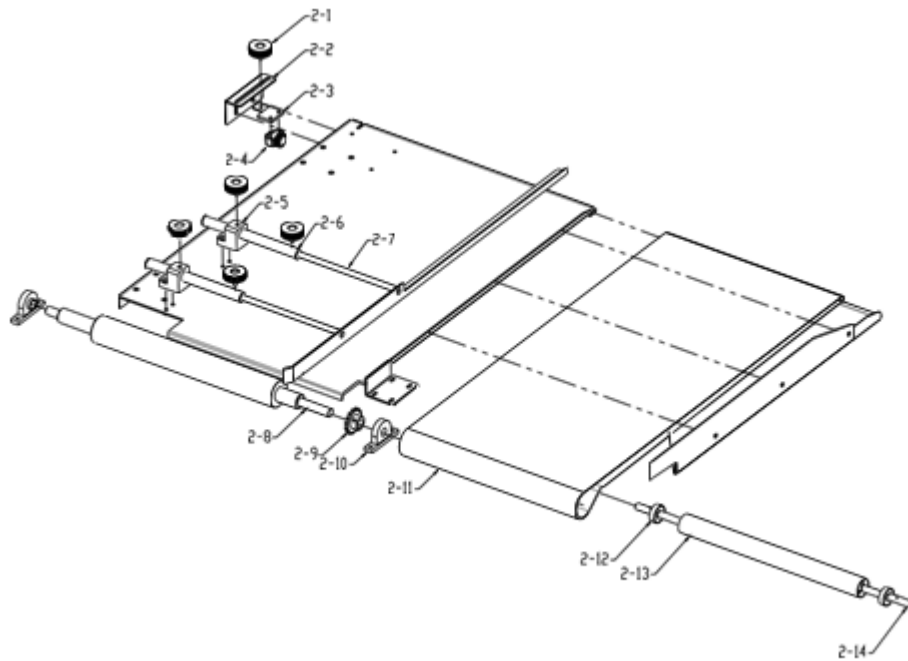
7. LIST OF PARTS



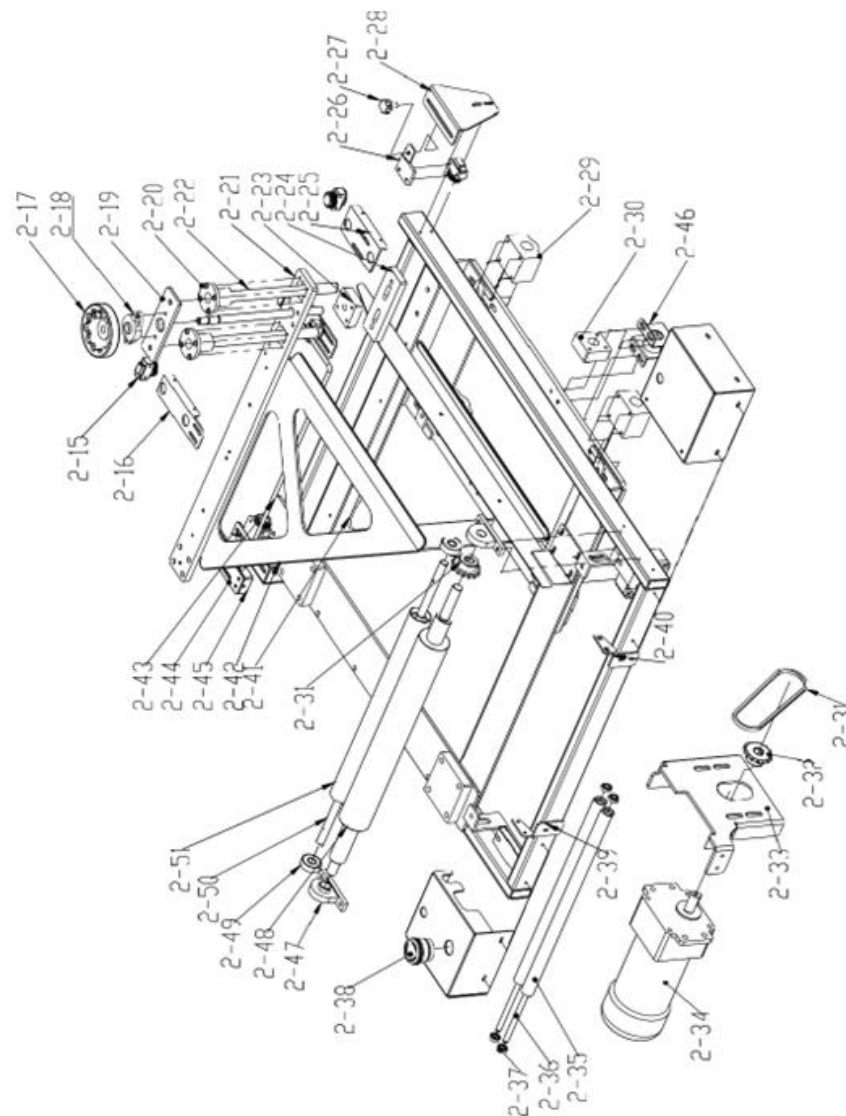
Code	Name	Code	Name
1	Frame	6	Film Feeding System
2	Input Conveyor System	7	Waste Film Collecting System
3	Output Conveyor System	8	Guard
4	Sealing System	9	Electrical Control Box
5	Film unwinding System		



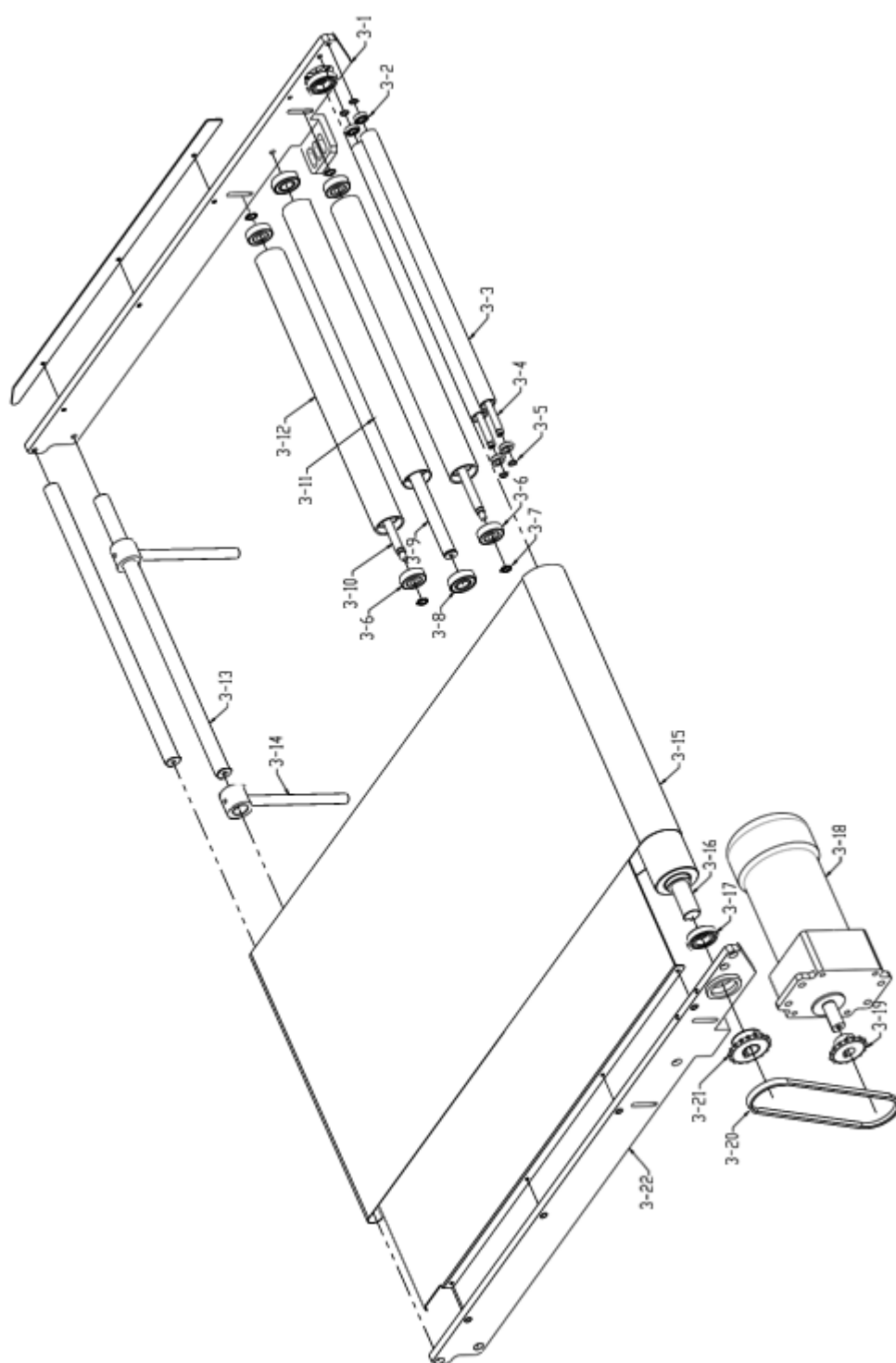
Code	Name	Qty
1-11	Adjusting Plate	2
1-12	Slide Rack	2
1-13	Deep Groove Ball Bearing	6
1-14	Drum	2
1-15	Drum Shaft	1
1-16	Drum Shaft	1
1-17	Slide Gear	2
1-18	Slide Rod Fixing Frame	2
1-19	M8 Internal-Crests Quincunx	1
1-20	Manual Adjusting Head	1



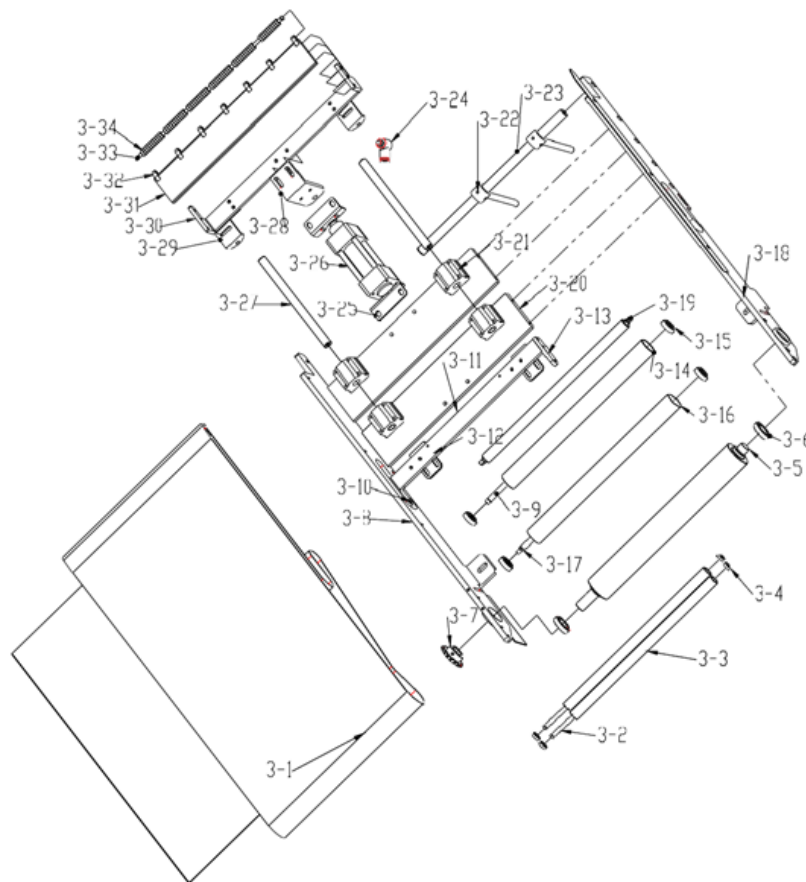
Code	Name	Qty
2-1	Plastic Handle	5
2-2	Front Sensor Support	1
2-3	Sensor Mounting Plate	1
2-4	Sensor	1
2-5	Adjusting Shaft Supporting Seat	2
2-6	Adjusting Shaft Sleeve	2
2-7	Adjusting Shaft	2
2-8	Driving Drum	1
2-9	Sprocket	2
2-10	Plummer Block	2
2-11	Input Conveyor Belt	1
2-12	Deep Groove Ball Bearing	2
2-13	Auxiliary Drum Shaft Sleeve	1
2-14	Auxiliary Drum Axis	1



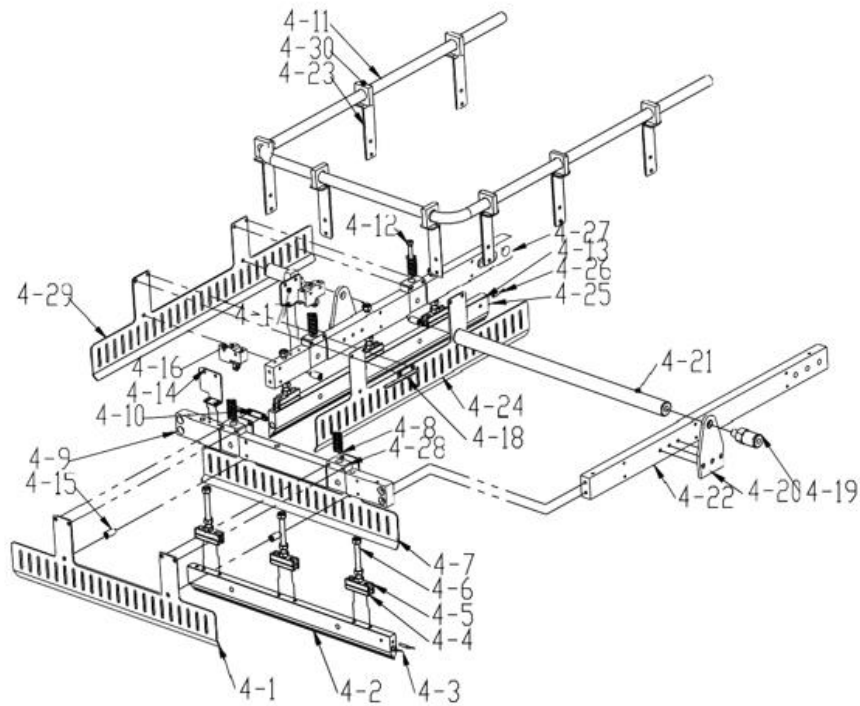
Code	Name	Qty
2-15	Sensor	1
2-16	Sensor Switch Support III	1
2-17	Hand Wheel	1
2-18	Plummer Block	1
2-19	HandWheel Mounting Plate	1
2-20	LinearSlide Block	2
2-21	LiftingSlide Plate	1
2-22	LiftingFrame Fixing Rod	2
2-23	LiftingSmall Nut	1
2-24	LiftingFrame Fixing Plate	1
2-25	Sensor Switch Support III	1
2-26	Sensor Mounting Plate	1
2-27	Plastic Handle	1
2-28	Sensor Support 2	1
2-29	LinearSlide Block	4
2-30	Nut	1
2-31	Chain	1
2-32	Sprocket	2
2-33	Input Conveyor Motor Mounting	1
2-34	PlateMotor	1
2-35	Supporting Shaft Sleeve	2
2-36	Supporting Shaft Axis	2
2-37	Deep Groove Ball Bearing	4
2-38	Emergency Stop Button	1
2-39	Auxiliary Drum Mounting Support	1
2-40	Auxiliary Drum Mounting Support	1
2-41	Lower Triangular Plate	1
2-42	Upper TriangularPlate	1
2-43	Film Blowing Rod	1
2-44	Film BlowingRod Fixing	1
2-45	Film BlowingRod Support 2	1
2-46	Nut Assembly seat	1
2-47	Plummer Block	2
2-48	DrivingDrum	1
2-49	Deep Groove Ball Bearing	2
2-50	Auxiliary Drum Axis	1
2-51	Auxiliary Drum Sleeve	1



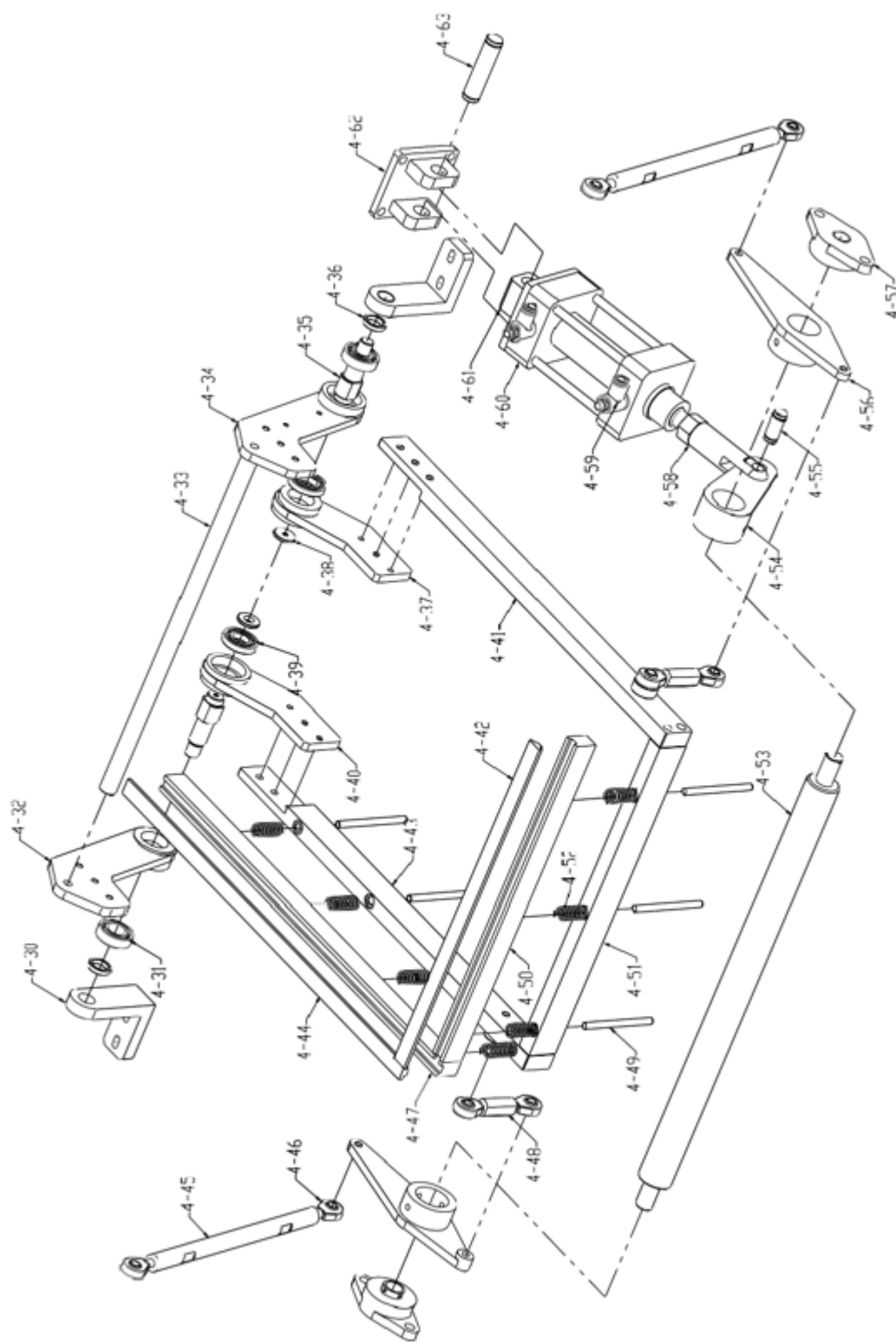
Code	Name	Qty
3-1	Conveying Left Support	1
3-2	Deep Groove Ball Bearing	2
3-3	Output Conveying Auxiliary Drum Shaft	2
3-4	Output Conveying Auxiliary Drum Axis	2
3-5	Sanp Spring for Shaft	4
3-6	Deep Groove Ball Bearing	4
3-7	Sanp Spring for Shaft	4
3-8	Deep Groove Ball Bearing	2
3-9	Drum II-Shaft	1
3-10	Drum I-Shaft	2
3-11	Drum II-Sleeve	1
3-12	Drum I-Sleeve	2
3-13	Fixing Rod	2
3-14	Screw Rod	2
3-15	Output Conveying Belt	1
3-16	Driving Drum	1
3-17	Deep Groove Ball Bearing	2
3-18	Motor	1
3-19	Sprocket	1
3-20	Chain	1
3-21	Driven Sprocket	1
3-22	Conveying Right Support	1



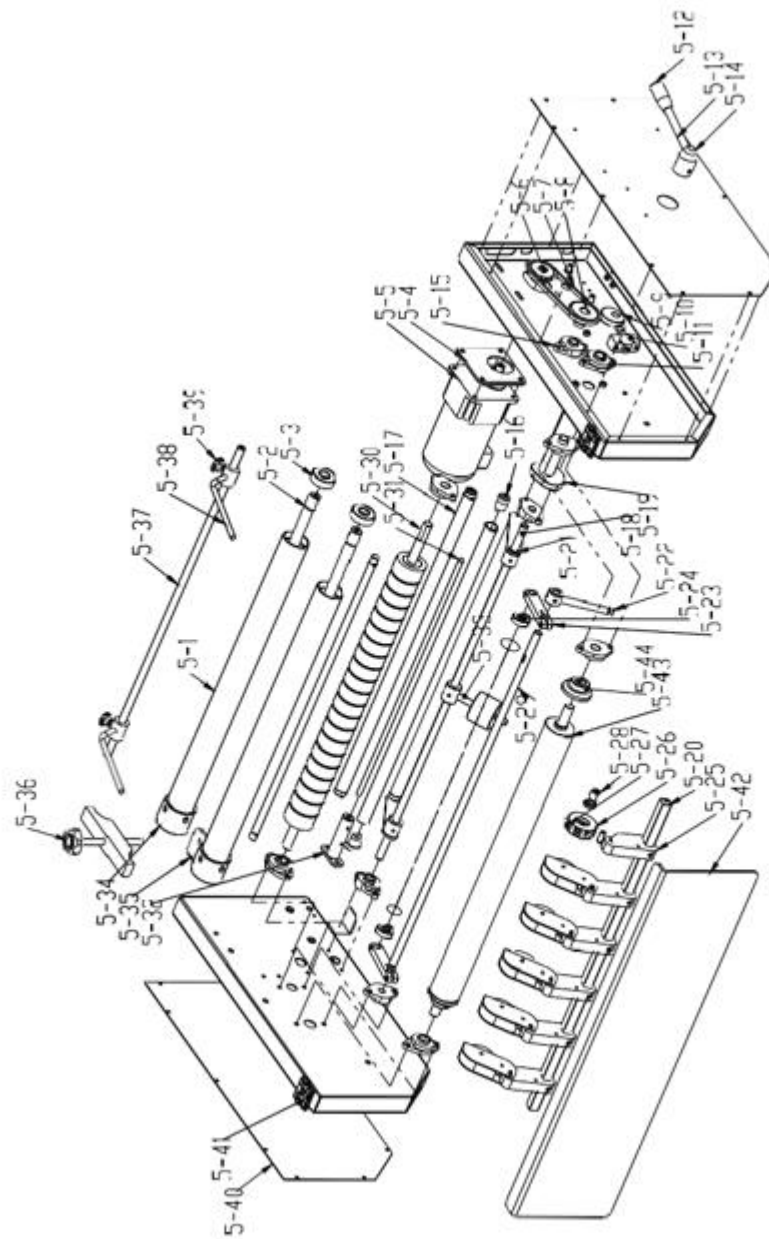
Code	Name	Qty
3-1	Output Conveying Improving Belt	1
3-2	Output Conveying Auxiliary Drum Axis	2
3-3	Output Conveying Auxiliary Drum Shaft	2
3-4	Deep Groove Ball Bearing	4
3-5	Driving Drum	1
3-6	Deep Groove Ball Bearing	2
3-7	Sprocket	1
3-8	Conveying Right Support	1
3-9	Drum II-Shaft	1
3-10	Slide Rail Front Fixing Plate-2	1
3-11	Slide Rail Front Fixing Plate-1	1
3-12	Guide Bar Fixing Plate	2
3-13	Slide Rail Front Fixing Plate-2	1
3-14	Drum II-Sleeve	1
3-15	Deep Groove Ball Bearing	4
3-16	Drum I	1
3-17	Drum I	1
3-18	Conveying Left Support	1
3-19	Kissing Device Tension Shaft	1
3-20	Cylinder Fixing Plate	2
3-21	Linear Bearing	4
3-22	Screw Rod	2
3-23	Fixing Rod	1
3-24	Cylinder Speed-Adjusting Connector	
3-25	Cylinder Mounting Seat	2
3-26	Air Cylinder	1
3-27	Guide Bar	2
3-28	Guide Bar Connecting Plate	2
3-29	Cylinder Connector	1
3-30	Slide Rail Rear Fixing Plate	1
3-31	Welding Fixing Plate	1
3-32	Conveyor belt support board -3	7
3-33	Kissing Device Drum Shaft Axis	1
3-34	Deep Groove Ball Bearing	66



Code	Name	Qty
4-1	Horizontal Sealing Slot Guard I	1
4-2	Horizontal Sealing Blade	1
4-3	Horizontal Sealing Heater	1
4-4	Heat Insulator	6
4-5	Fixing Adjustable Block	6
4-6	Screw Rod	6
4-7	Horizontal Sealing Slot Guard II	1
4-8	Sealing Blade Guard Pressure Spring	4
4-9	Horizontal Sealing Blade Frame	1
4-10	Micromovement Switch Contactor	1
4-11	rod	1
4-12	Sealing Plate Screw Rod	4
4-13	Vertical Sealing Blade	1
4-14	Micro Switch Mounting Plate	1
4-15	Supporting Rod	4
4-16	Micromovement Switch 2	2
4-17	Micro Switch Mounting Plate	1
4-18	Micromovement Switch Contactor	1
4-19	Supporting Rod II Connecting Rod	2
4-20	Vertical Sealing Lower Pressure Plate	2
4-21	Supporting Rod II	1
4-22	Vertical Frame Plate 2	1
4-23	Fastener support	8
4-24	Vertical Sealing Slot Guard II	1
4-25	Vertical Sealing Heater	1
4-26	Thermocouple	2
4-27	Vertical Frame Plate	1
4-28	Sealing Slot Guard Mounting Block	4
4-29	Vertical Sealing Slot Guard I	1
4-30	Fastener	8

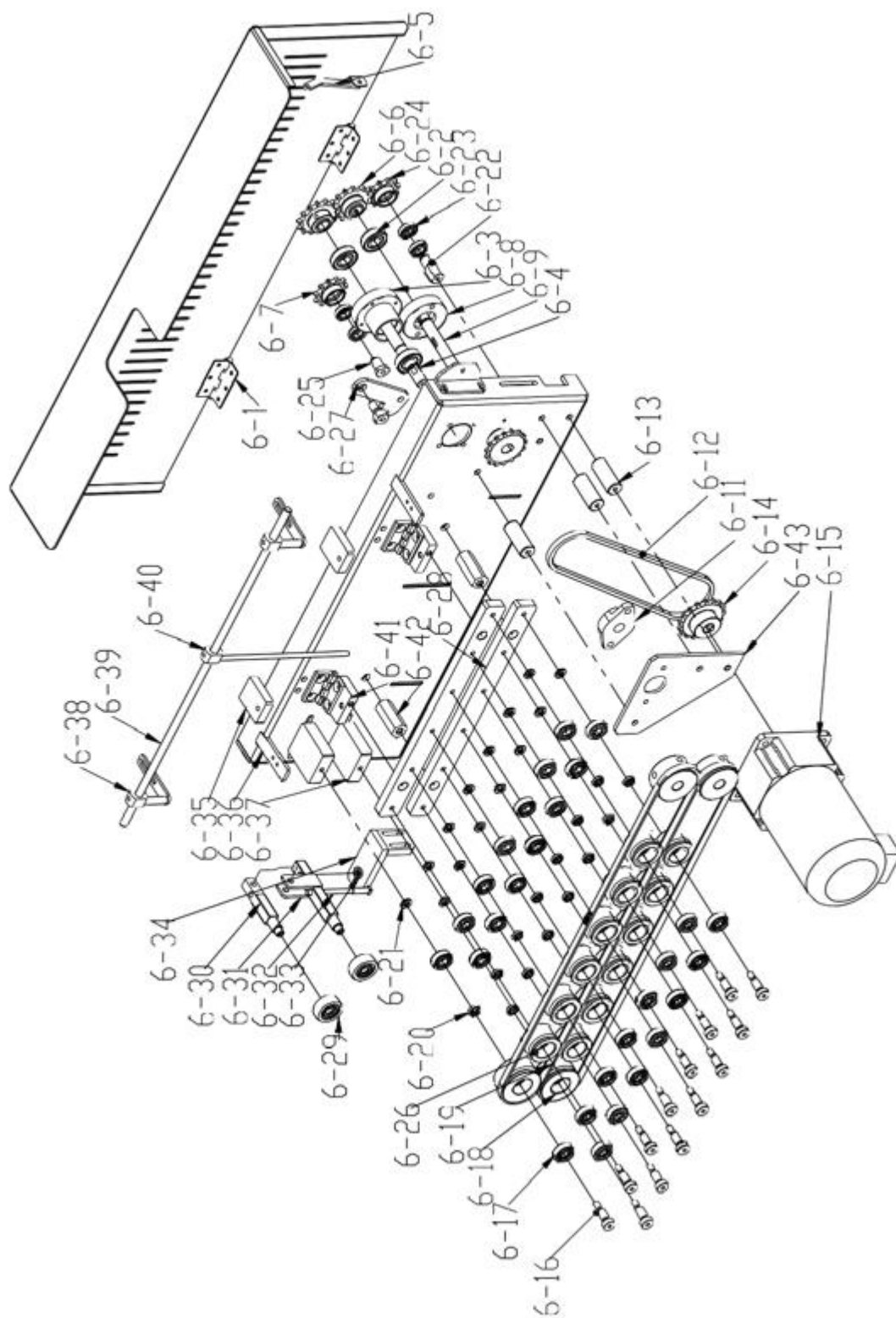


Code	Name	Qty
4-30	SealingFixingSeat Right	2
4-31	Deep Groove Ball Bearing	2
4-32	Upper Sealing Connecting Plate (Right)	1
4-33	Supporting Rod I	1
4-34	Upper Sealing Connecting Plate (Left)	1
4-35	SealingConnecting Plate Fixing Axis	2
4-36	Spacing Sleeve	2
4-37	Lower Sealing Connecting Plate (Right)	1
4-38	BearingRetaining Ring	2
4-39	Deep Groove Ball Bearing	2
4-40	Lower Sealing Connecting Plate (Left)	1
4-41	Lower BladeFrame A	1
4-42	Horizontal SealingBlade Rubber	1
4-43	Lower BladeFrame B	1
4-44	VerticalSealingBlade Rubber	1
4-45	Upper SealingConnectingRod	2
4-46	Joint bearing	8
4-47	Rubber Groove II	1
4-48	Upper Sealing Connecting Rod II	2
4-49	Screw Rod	13
4-50	Rubber Groove I	1
4-51	Lower Blade Frame C	1
4-52	SealingBlade Lower Seat Pressure	7
4-53	Cylinder Connecting Shaft	1
4-54	Cylinder Connecting Rod	1
4-55	Cylinder Connecting Rod Cross-Pin	1
4-56	Cylinder Connecting Rod Seat II	1
4-57	Plummer Block	2
4-58	Air Cylinder	1
4-59	Adjusting Valve	2
4-60	Air Cylinder	1
4-61	Cylinder Seat	1
4-62	Cylinder Connecting Seat	1
4-63	Cylinder Pin	1

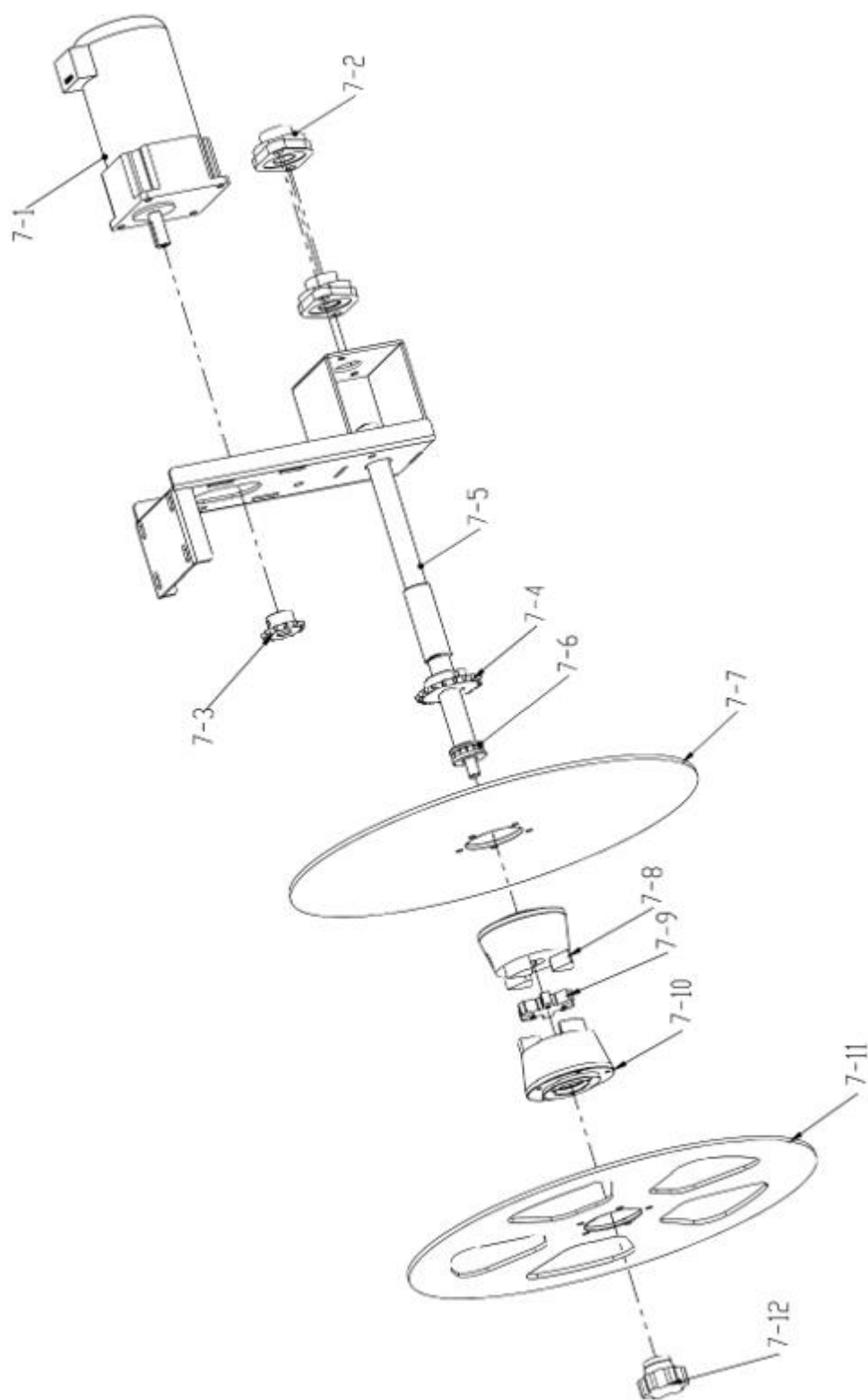


Code	Name	Qty
5-1	Drum I-Sleeve	2
5-2	Drum I -Shaft	2
5-3	Deep Groove Ball Bearing	4
5-4	Sanp Springfor Shaft	4
5-5	Motor	1
5-6	Sprocket	1
5-7	Chain	1
5-8	Sprocket	1
5-9	Eccentric	1
5-10	Micromovement Switch 1	1
5-11	Plummer Block	4
5-12	Handle Sleeve	1
5-13	Handle Wheel	1
5-14	Handle Wheel Connecting	1
5-15	Sanp Spring For Shaft	4

5-16	Plastic bearing	6
5-17	Transition Drum	2
5-18	Guide Bar V-1	1
5-19	Handle Wheel	1
5-20	shaft	1
5-21	Swing board	2
5-22	Tension Spring Rod	1
5-23	Connecting Plate	2
5-24	Deep Groove Ball Bearing	2
5-25	Perforator Swing Arm	6
5-26	Perforator	6
5-27	Needle	48
5-28	Perforator Axis	6
5-29	Guide Bar V-2	1
5-30	Perforator Shaft II	1
5-31	Guide Bar III-1	1
5-32	Film Spacing Rod Seat	1
5-33	Sliding Bar	1
5-34	Braking sleeve	2
5-35	Braking drum under seat	1
5-36	Plastic Quincunx Handle	1
5-37	Guide Bar IV	1
5-38	Adhesive rod	2
5-39	Plastic Quincunx Handle	2
5-40	Left support cover board	1
5-41	Hinge	2
5-42	Glass cover	1

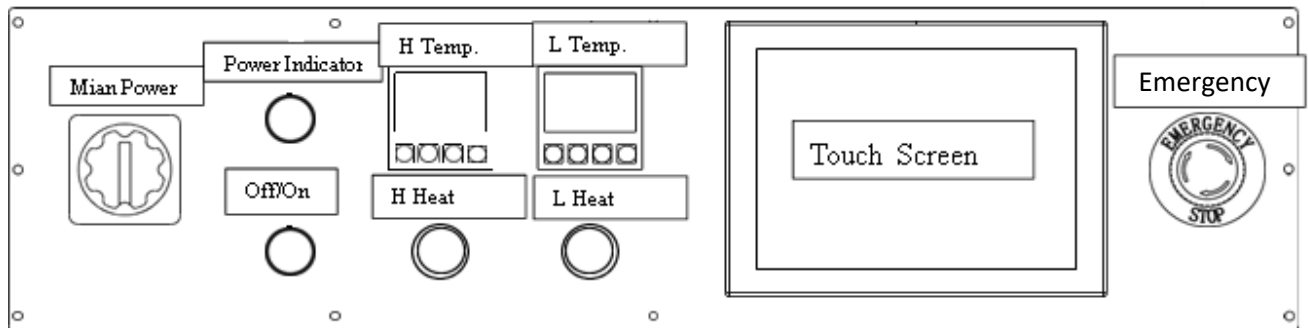


Code	Name	Qty
6-1	StainlessHinge	4
6-2	Deep Groove Ball Bearing	3
6-3	SprocketSeat II	1
6-4	SprocketShaft 2	1
6-5	ConnectingPlate	1
6-6	Sanp Spring for Shaft	4
6-7	Gear	2
6-8	SprocketSeat I	1
6-9	SprocketShaft 1	1
6-10	Sprocket	1
6-11	Plummer Block	1
6-12	Chain -Film Pulling Drive	1
6-13	SprocketMountingPlate Mounting Post	3
6-14	Sprocket	1
6-15	Motor	1
6-16	DrivingTiming Wheel	2
6-17	Film PinchingTiming Belt	1
6-18	Film PinchingTiming Belt	1
6-19	Driven Timing Wheel	2
6-20	Deep Groove Ball Bearing	4
6-21	Film PullingDriven Timing Wheel Axis	2
6-22	link plate I	2
6-23	link plate	1
6-24	link plate	1
6-25	AdjustingPlate	2
6-26	PressureSpring Guidep o s t	1
6-27	Deep Groove Ball Bearing	4
6-28	Film Pinching Wheel Spacer Ring	2
6-29	Film Pinching Wheel	2
6-30	Upper Film PinchingWheel Support	1
6-31	Film Pinching Wheel Axis Rotary Pin	1
6-32	Film PinchingPressure Spring	1
6-33	Lower SupportMountingScrew Rod	1
6-34	Lower Film PinchingWheel Support	1
6-35	Film PinchingWheel Spacer Cushion	1
6-36	Film Holding AssemblyMounting Seat	1
6-37	link plate Support Rod II	2
6-38	Film PullingPressure Spring	1
6-39	Timing Belt ClampingSupport Rod	2
6-40	Film SpacingRod ConnectingRod FixingSeat	2
6-41	Magnet Assembly	2
6-42	Film SpacingRod Connecting Rod	1
6-43	Film SpacingRod	1



Code	Name	Qty
7-1	Motor	1
7-2	Plummer Block	2
7-3	Film Collecting Driving Sprocket	1
7-4	Film Collecting Driven Sprocket	1
7-5	Film Collecting Central Shaft	1
7-6	Thrust ball bearing	1
7-7	Rear Material Reel	1
7-8	Film collection A	1
7-9	Connector Rubber cushion	1
7-10	Film collection B	1
7-11	Front Material Reel	1
7-12	Plastic Quincunx Handle	1

8. CONTROL PANEL



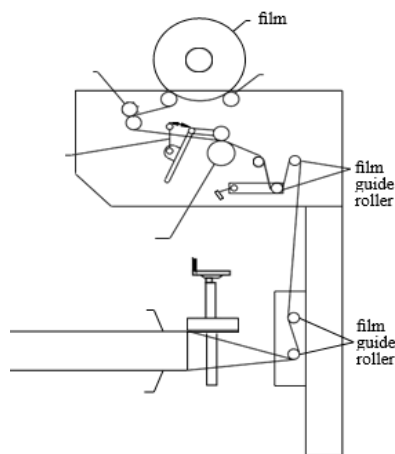
No.	Name	Function
1	Main Power Switch	Switch on/off the main power
2	Power Indicator	Indicate the main power
3	Heater H Temp controller	Set H sealing blade temperature
4	Heater L Temp controller	Set L sealing blade temperature
5	Touch Screen	Current machine operating parameters / data
6	Emergency stop	Press to stop the machine immediately
7	Power Off/On	Machine control power off / on
8	H Heater	On/Off H heater
9	L Heater	On/Off L heater

9. SETTING UP THE MACHINE FOR OPERATION

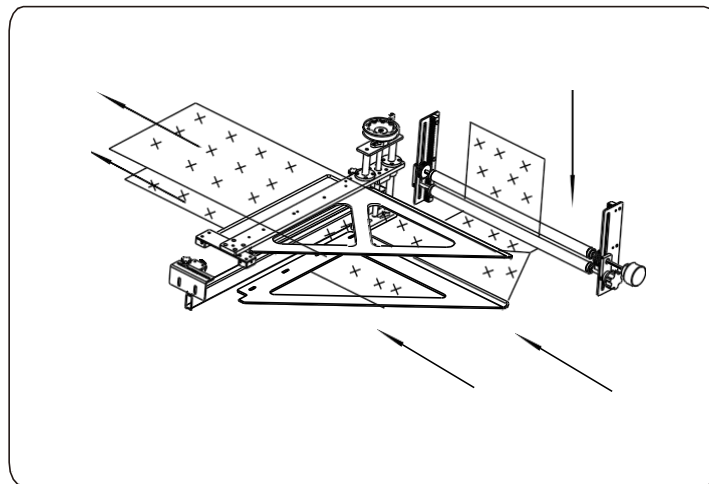
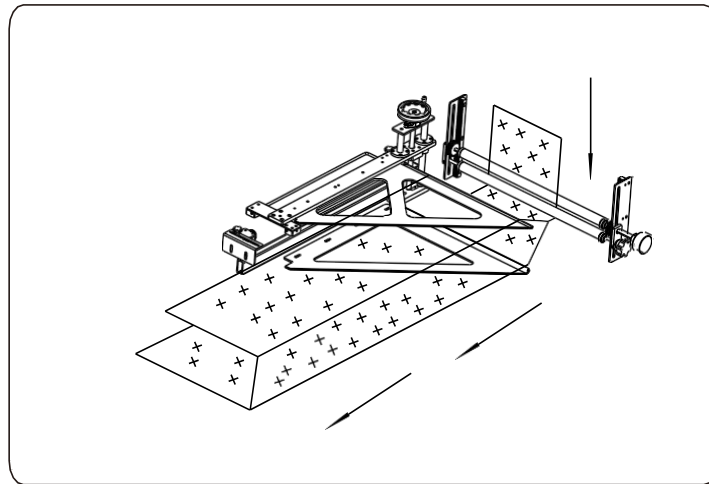
- Confirm the air pressure of regulating valve (6-7 Kg/CM²)
- Turn on the power switch.
- Turn on the heating switch.
- Adjust the suitable sealing temperature on the temperature controller.
- Load the suitable film into the machine in manual mode.
- Adjust the height between film guiding triangular plates and guide on the conveyor as per the product.
- Choose the suitable sensor according to the height of the packed product (Horizontal/vertical)
- Set the Sealing time and rear and front film reservation POF film.
- After the final adjustments and trials, put the machine on auto mode and continue the operation.

10. FILM ROLL MOUNTING

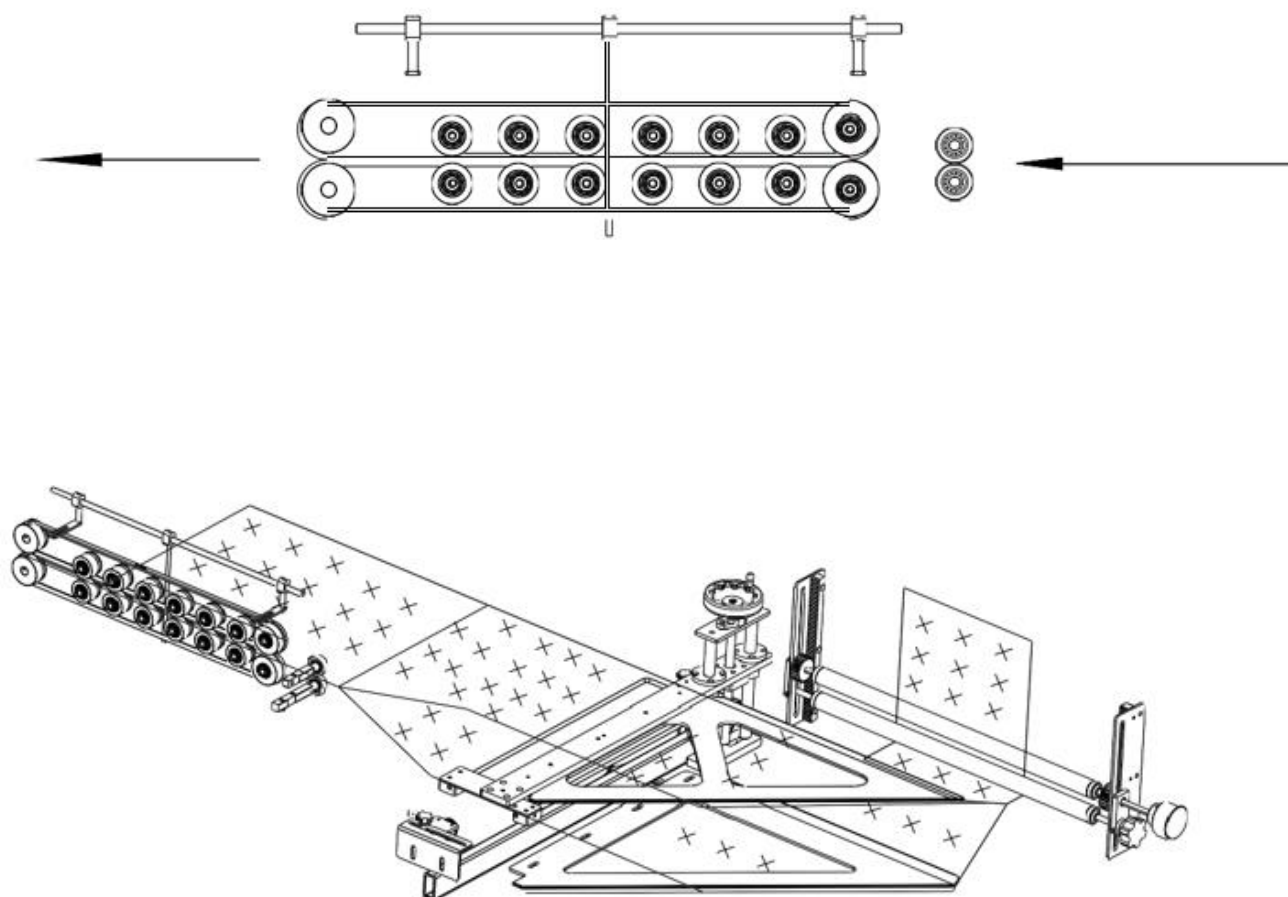
- The film used in this machine is central folded film
- Select the packing film with size and texture suitable to the product dimensions, then load the film according to the schematics.
- Place the reel onto the two rollers above, check the film opening and the rotation direction.
- Pull open the handle of the film perforator pin wheel to separate the pin wheel from the rubber-bundled roller.
- Load the film as per the schematics below based on the reel opening and rotation direction.
- Pull the pin wheel handle to reset the pin wheel after the film loads between the pin wheel and the rubber-bundled roller.
- Pull out the film around 30 cm beyond the machine frame.



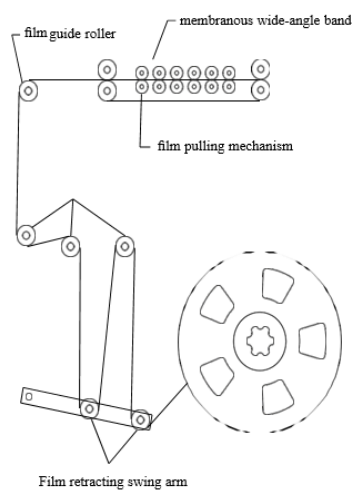
- Load the film past the triangular unfolders after the film loading through the film racks.



- After the film loading through the triangular unfolders, converge the film near the horizontal sealing blade after the film passing over the in-feed conveyor belt and direct the film through the vertical sealing film clamping system.
- Pull the film unfolded by the two triangular plates along the vertical sealing in forward direction.
- Converge the unfolded film and pull it through the horizontal sealing blade.
- When the film reaches the film pulling system through the horizontal sealing bracket, lift up the auxiliary film pinching wheels and the film compressing synchronous wheel, thread the film according to the schematics.

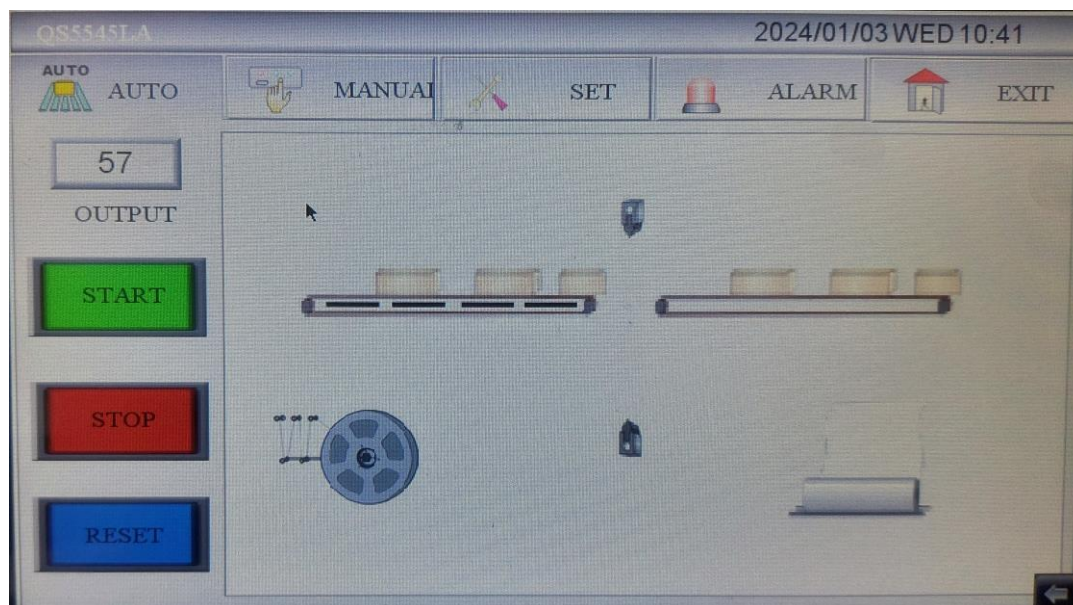


- After threading the film through the sealing system, shift the machine into manual mode to pull the film along with the waste film; direct the film as shown in the picture below into the waste film collecting box below the control cabinet and tie the waste film to the waste film collecting wheel.
- Waste Film Collecting Threading Schematics



11. SETTINGS

- Auto mode : touch any position in startup interface to enter into below auto mode interface

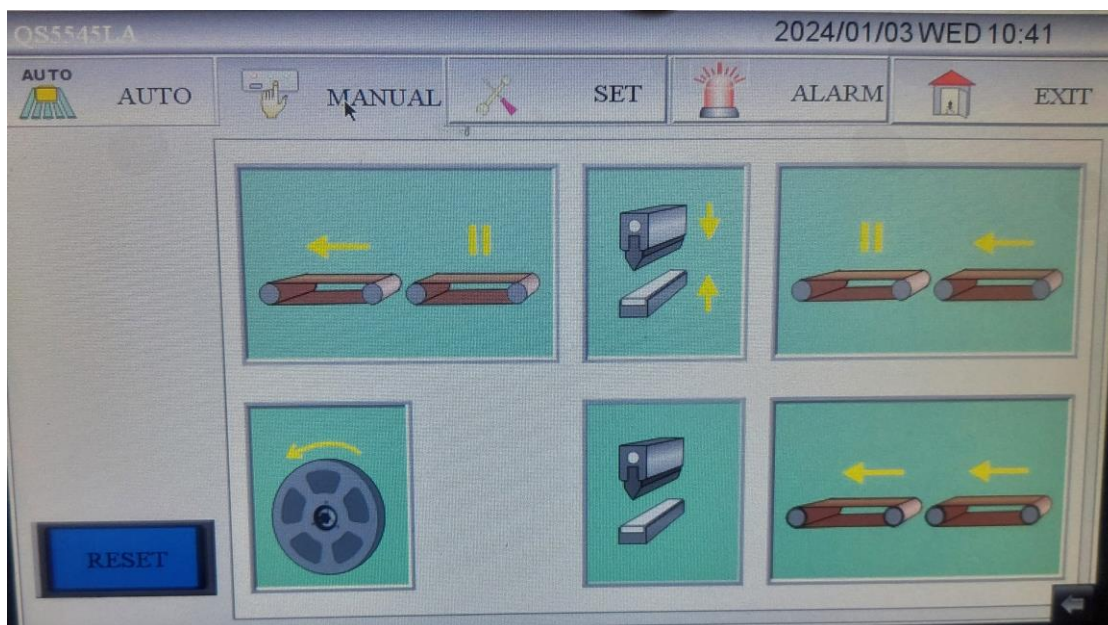


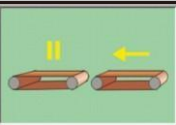
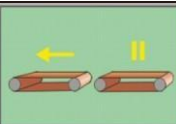
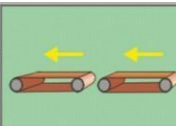
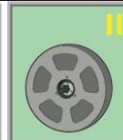
Buttons function in auto mode interface:

Button	Function
	Click to shift to auto mode.
	Click to shift to manual mode.
	Click to shift to parameters setting.
	Click to shift to alarm record.
	Click to shift to start up interface.
	Indicate the production quantity.

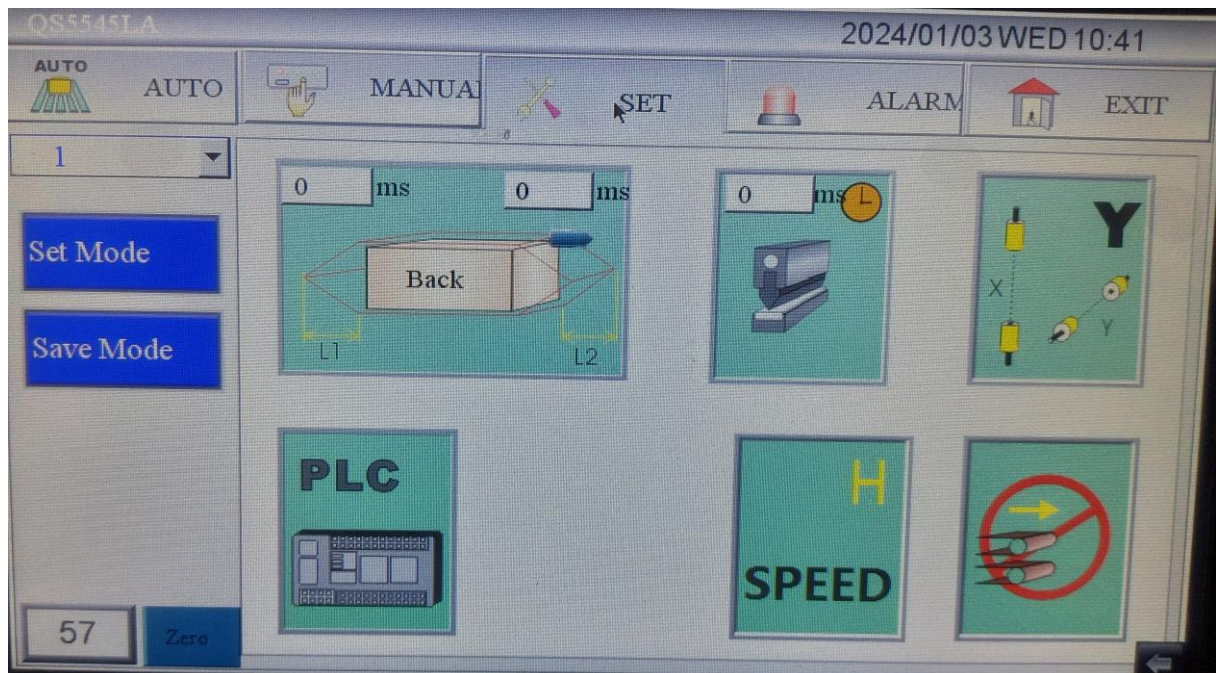
	Click to start auto mode when no alarm
	Click to stop auto mode when no alarm
	Click to reset the alarm after fault eliminated

- Manual operation: At auto mode stop condition, click  enter into manual operation interface

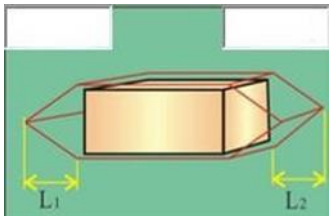
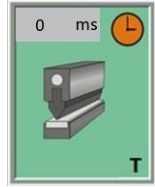
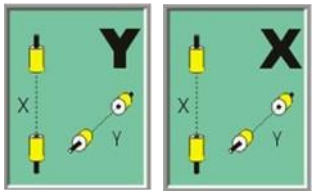
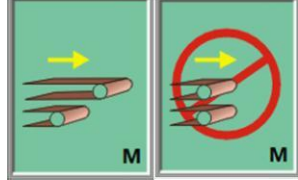


Button functions		Button functions	
	Click to drive input conveyor in manual mode		Click to drive sealing in manual mode
	Click to drive output conveyor in manual mode	 	Start/forbid sealingblade.
	Click to drive input / output conveyor synchronously in manual mode	 	Start/forbid film collecting wheel.
	Click to reset the alarm after fault eliminated		

- Parameters setting click  enter into to parameters setting



Value adjustment: click input to popup soft keyboard to input numbers, click, press to finish setting.

 L1 : Input Advance L2 : Output Advance	 Click to set the sealing time.
 Set the sensor. Y: Horizontal X: Vertical	 Set the input conveyor speed. H: High speed L: Low speed
 Indicate PLC input and output condition	 Turn On /OFF conveyor Bridge.
Set Mode: To set the required mode.	Save Mode: To save the parameter to the mode

- Machine failure alarm, click alarm to enter into alarm interface, This interface can be queried the reason of the machine failure

- ❖ “Vertical Cut alarm”: something detected by vertical sensor during sealing.
- ❖ “Cut alarm”: products under the blade during sealing.
- ❖ “Waste Film Broken”: The film collection motor running more than 6sec, check film broken or sensor detection or the tension arm lever is blocked.
- ❖ “Emergency Stop”: Emergency button be pressed.
- ❖ “Cutting Time too long”: Sealing cylinder failure or air source disconnection lead the knife closed.
- ❖ “Sealing cylinder alarm”: Cylinder failure, Blade does not reach the extended or retracted position.

12. MAINTENANCE

To get the best performance for a long time, kindly do the following maintenance.

1. Sealing Blade Cleaning:

- a. Use a clean, soft cloth to clear the sealing blade after each operation.
- b. Wear heat-resistant gloves to clean the sealing blade before its temperature falls.
- c. Avoid cleaning if the temperature is below 70 degrees to prevent damage to the Teflon coating.

2. Pneumatic Circuit Maintenance:

a. Waste Water Drainage:

- Discharge waste water when it reaches the fending plate.
- Screw out the stopper at the bottle bottom to discharge water. If the stopper is stuck, dismount the bottom and press down from above.

b. Pressure Adjustment:

- Rotate the adjustment knob to the right to increase pressure.
- Press the knob to lock the pressure after setting.

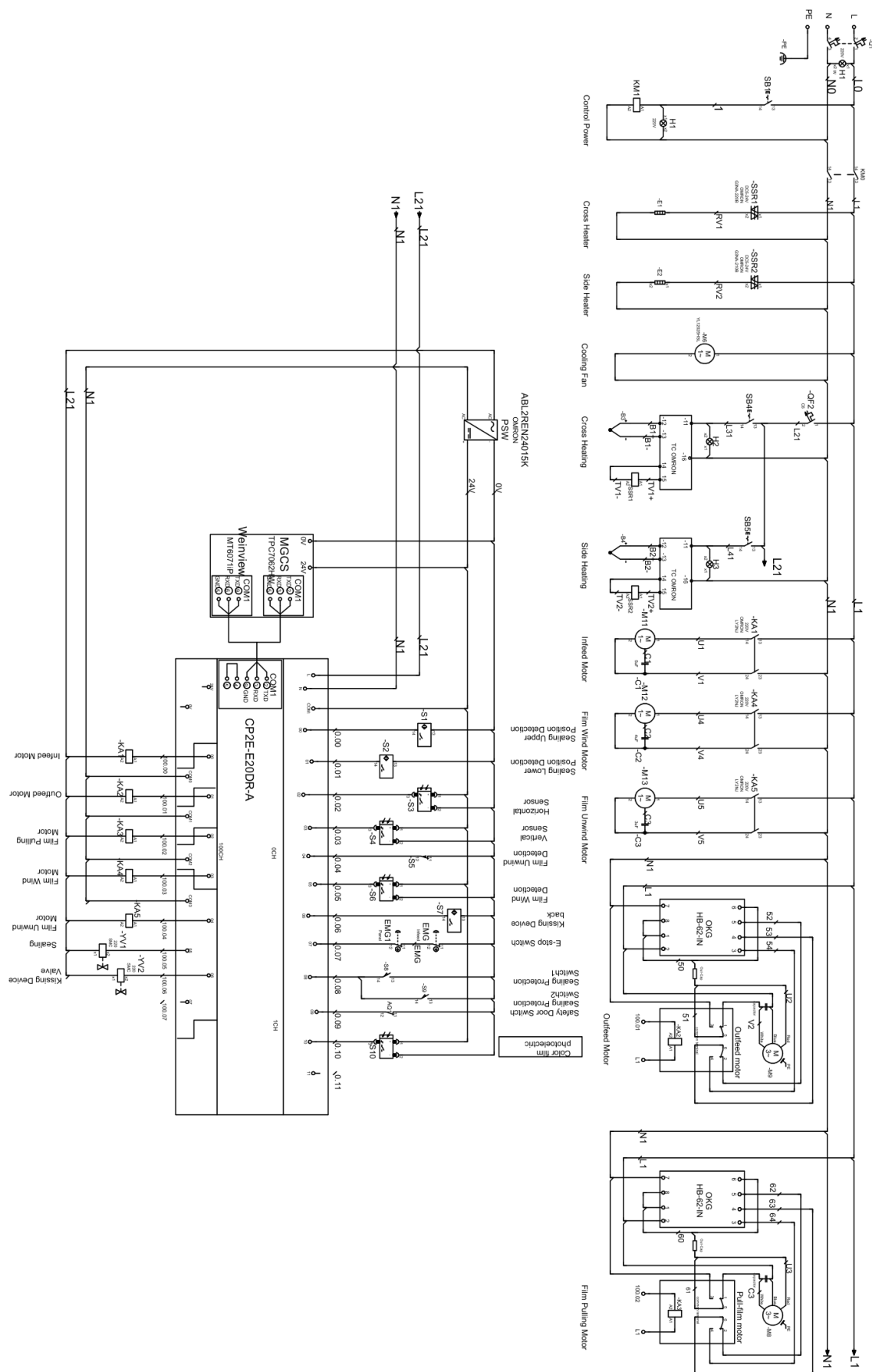
c. Dismounting:

- Cut off the air source.
- Loosen the four screws, guard, spring, and template.
- Rotate the bolt to the left to remove it; then, loosen the spring and stopper washer.

3. Lubrication:

- a. Keep all movable spare parts well-lubricated.
- b. Add lubricating oil to the sealing blade guide rail every 3 days.
- c. Add lubricating oil to the conveying belt support guide rail every 30 days.
- d. Add lubricating oil to the transmission chain every 30 days.

13. ELECTRICAL SCHEMATIC



14.TROUBLESHOOTING

No.	Complaint	Reasons	Remedy
1	Machine doesn't work/Power on LED doesn't light up/No display	1.No AC supply. 2.MCB tripped. 3.Mains cord failure.	1.Restore AC supply. 2.Check for any short circuit or replace the reset the MCB. 3.Replace mains cord.
2	Conveyor is not working and can move by hand	1.Conveyor belt tension may be too high/low. 2.Defective capacitor of motor.	1.Adjust the tension. 2.Replace the capacitor.
3	Conveyor is not working and cannot move by hand	1.Conveyor belt tension is too high. 2.Defective motor. 3.Damaged gear. 4.Defective limit switch.	1.Adjust the tension. 2.Check the motor connection for any breakage and replace it if defective. 3.Replace it. 4.Replace the switch.
4	Film feeding is not doing/Film roller is not moving	1.Defective limit switch. 2.Defective motor/Capacitor. 3.Defective motor brake. 4.The tension shaft is not on the level. 5.The position of tension roller is not proper. 6.The triangular plate is not properly fixed 7.The tension of clamping chain is too tight or loose.	1.Check the connections and replace it if defective. 2.Replace the defective part. 3.Replace it. 4.Adjust it. 5.Adjust it. 6.Adjust it. 7.Adjust or lubricate it.
5	Machine doesn't seal/Improper sealing	1.Low air pressure. 2.Defective cartridge heater. 3.Defective temperature controller/temperature sensor. 4.Voltage is too low. 5.Incorrect parameters settings. 6.Defective sealing blade. 7.Defective Teflon tape. 8.Defective limit switch. 9.Defective SSR.	1.Check and correct it. 2.Check for any open circuit and replace it if defective. 3.Replace the defective part. 4.Check the voltage. 5.Adjust the parameters as per film and product. 6.Replace it. 7.Replace them. 8.Replace it. 9.Replace it if defective.
6	Error messages doesn't work properly	1.Open connections. 2.Defective limit switch. 3.Misaligned sensor/ Defective sensor.	1.Check and do proper connections. 2.Check and replace if defective. 3.Adjust the position/Replace it if defective.
7.	Waste film collection system is not working properly.	1.Poor quality film. 2.Defective motor/Capacitor. 3.Incorrect alignment of guiding rollers.	1. Use quality film. 2. Replace the capacitor/motor. 3.Adjust the guiding rollers adjacent to the outer conveyor.

15 . SERVICE LOG

[illegible]