



AN ISO 9001:2008 CERTIFIED COMPANY

USER MANUAL

Semi automatic L - Sealer
QS5545LPTA



www.sevana.com

YOUR PACKAGING PARTNER

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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
Fax	:	+91-484-2680680	

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.

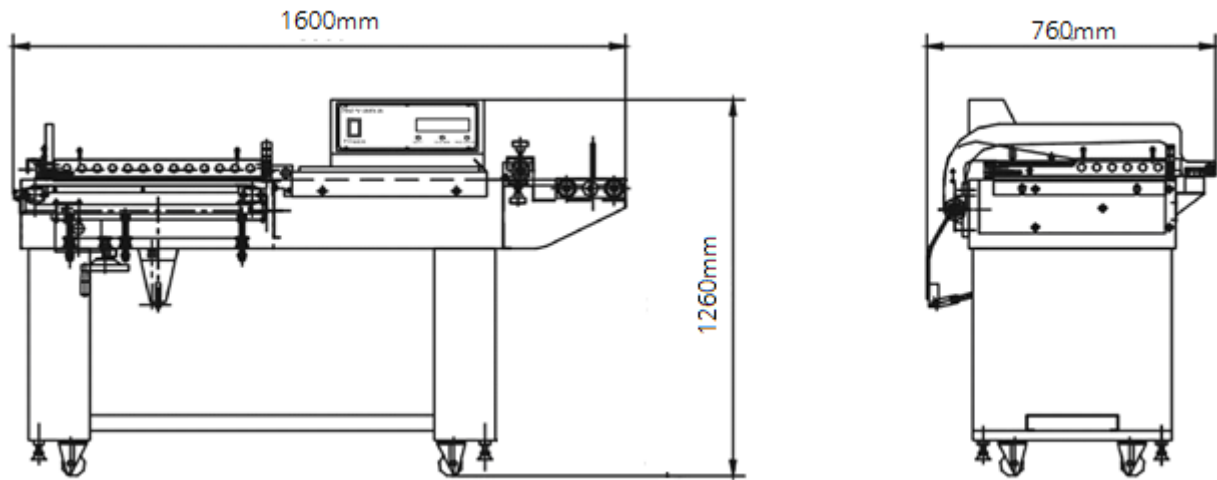
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3. SAFETY PRECAUTIONS

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 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. 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 power is isolated to prevent any injury to the person.

4. MACHINE DIMENSIONS



5. PACKING SLIP

Name	Quantity
User manual	1
Teflon belt	1
Sealing blade	1
Allen key	2

6. TECHNICAL SPECIFICATIONS

Model	Power supply	Power	Sealing dimensions	Machine dimensions	Weight
QS5545 LPTA	1Φ/240V/50Hz	1.4KW	L500 x W450	L1600xW760xH1260	110 kg

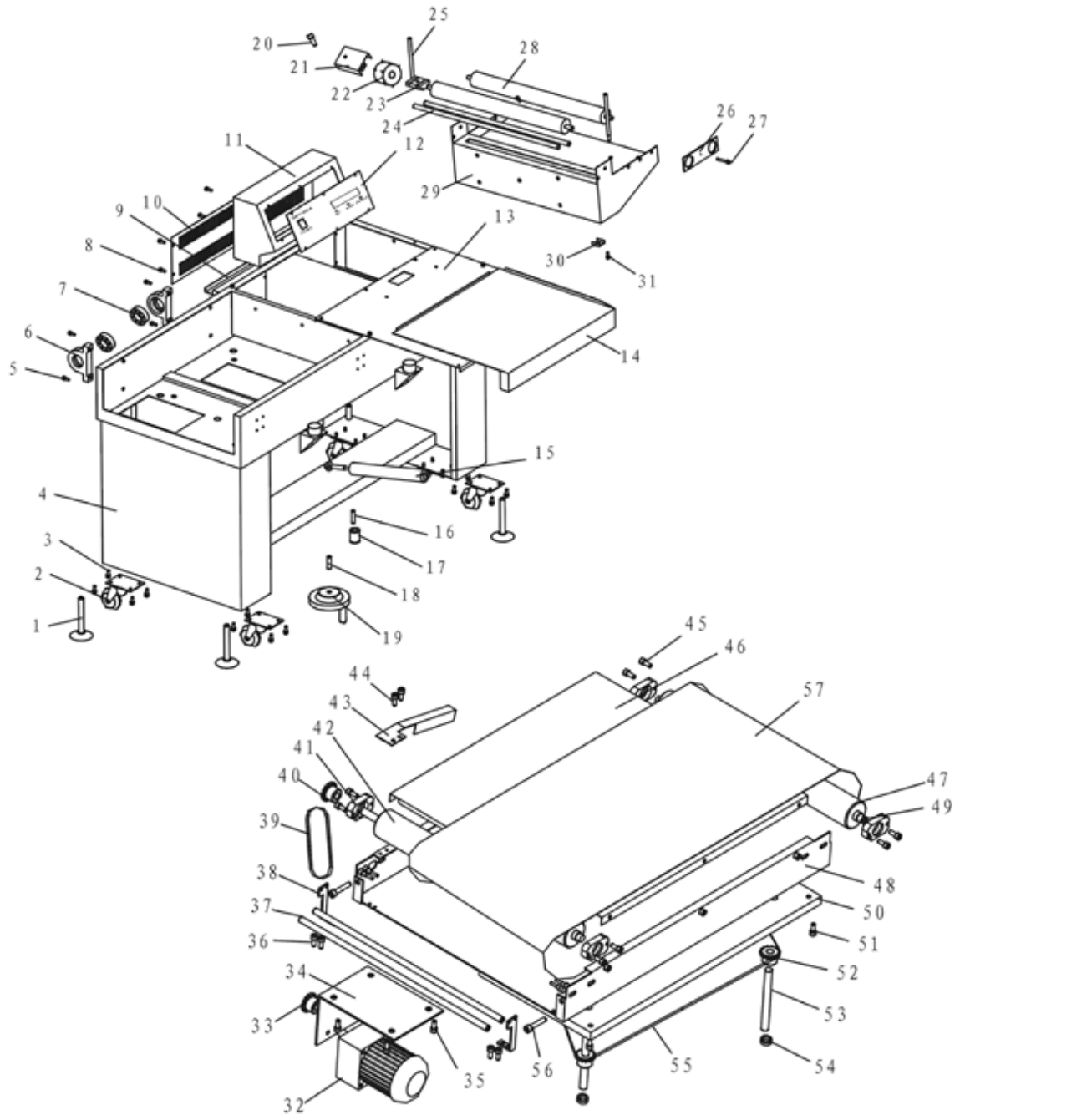
7. UNPACKING

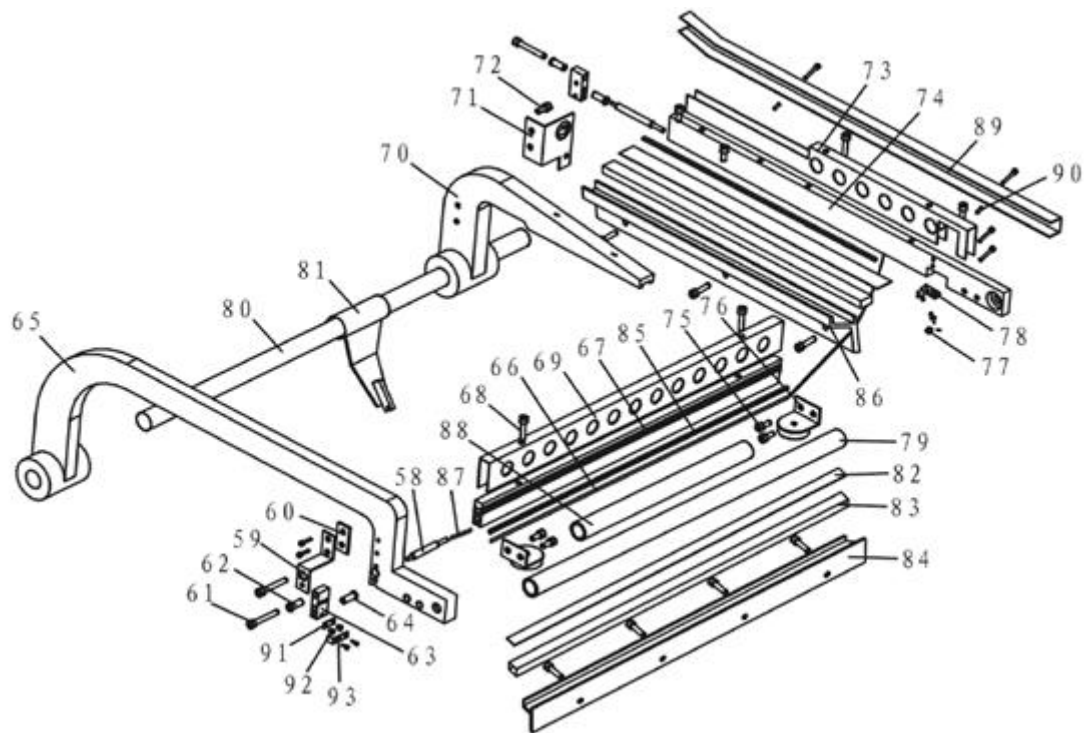
Note: Please verify the items with the packing slip.

- ❖ Inspect for any transit damages. 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.

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

8. LIST OF PARTS



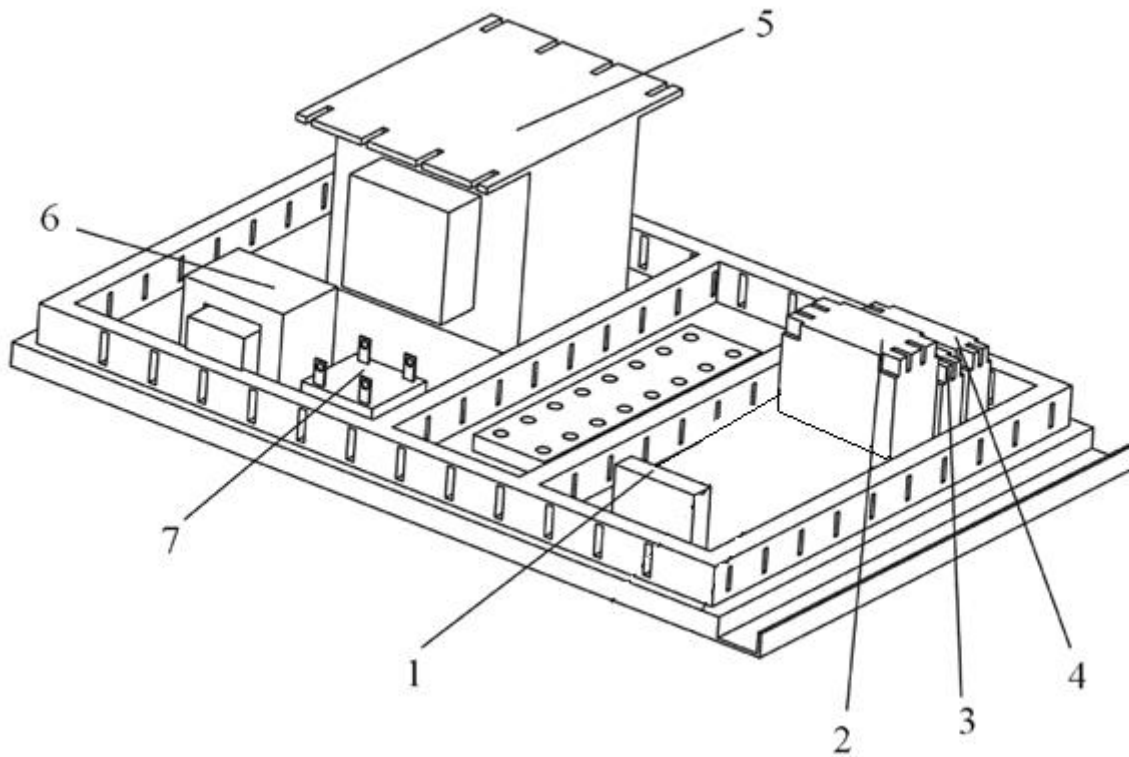


No	Name of item	Quantity
1	Base bolt	4
2	Castor wheel	4
3	Bolt M6*30	16
4	Machine stand	1
5	Bolt M8*20	4
6	Bearing housing	2
7	Bearing	2
8	Bolt M4*10	4
9	Power distributing board	1
10	Cover – power distribution board	1
11	Control box	1
12	Control panel	1

13	Cover board for electrical units	1
14	Working board	1
15	Pneumatic spring	1
16	Tightening wheel axle	1
17	Tightening wheel	1
18	Hand wheel axle	1
19	Hand wheel	1
20	Pentagonal bolt M8*20	1
21	Movable localizer	1
22	Idler wheel	1
23	Compaction plate	1
24	Stay bar	2
25	Support bar	2
26	Adjusting plate	1
27	Pentagonal bolt M8*30	1
28	Roller	2
29	Reel holder	1
30	The board of the pressing plate	1
31	Bolt M8*10	1
32	Conveyor motor	1
33	Sprocket wheel - motor	1
34	Motor mounting plate	1
35	Bolt M6*15	4
36	Bolt M4*10	4
37	Extend roller	2
38	Stand	2
39	The chain of the motor	1

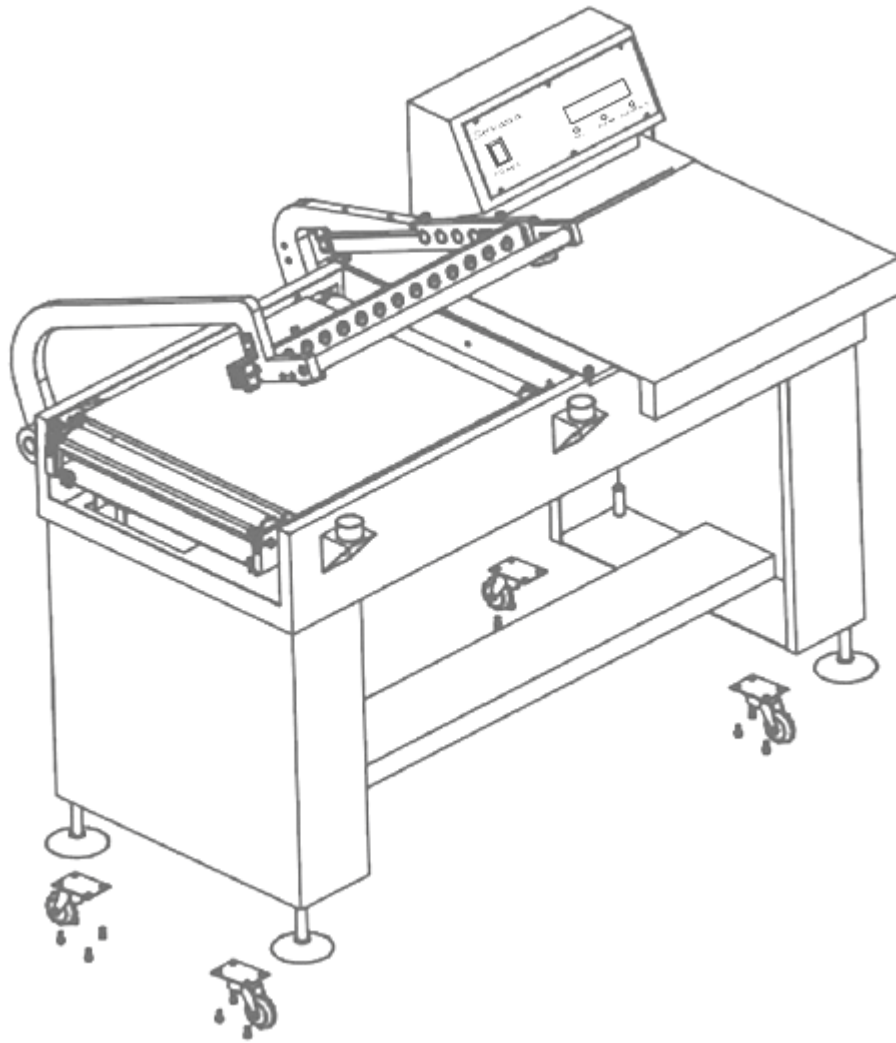
40	Revolving chain wheel II	2
41	Stator	4
42	Shaft of idler wheel	1
43	Pressing plate	1
44	Bolt M4*8	2
45	Bolt M4*20	8
46	Supporting board of the belt	1
47	Shaft of idler wheel	1
48	Rise-and-fall stand	1
49	Bearing	4
50	Fixing board	1
51	Bolt M6*10	4
52	Revolving chain wheel II	4
53	Screw	4
54	Bearing	4
55	Chain	1
56	Adjusting bolt M6	2
57	Conveyor belt	1
58	Tension scabbard	2
59	Switch stand I	1
60	Stay plate	1
61	Bolt M4*40	3
62	Insulated cover 1	2
63	Switch stand II	2
64	Insulated cover II	2
65	Upper let frame	1
66	Sealing blade	1

67	Upper sealing blade slot I	1
68	Bolt M6*40	4
69	Cover of the sealing blade slot	1
70	Upper right frame	1
71	Switch stand III	1
72	Bolt M6*10	2
73	Cover of the sealing blade slot II	1
74	Upper sealing blade slot	1
75	Bolt M6*15	4
76	Magnet	2
77	Fixing corner	1
78	Board of fixing corner	1
79	Hand bar roller	1
80	Movable shaft	1
81	Revolving plate	1
82	Teflon belt	2
83	Neoprene rubber	2
84	Slot neoprene rubber I	1
85	Slot of sealing blade	2
86	Slot of neoprene rubber II	1
87	Spring	2
88	Protective cover	1
89	Wire cover	1
90	Supporting bar of the wire cover	2
91	Stay plate II	1
92	Insulated cover	2
93	Switch stand IV	1



1	The starter capacitor of the conveyor motor
2	Contactator for sealing
3	MCB
4	MCB
5	Transformer for sealing
6	Transformer for magnet
7	Bridge rectifier

9. INSTALLATION



- i. Place the machine on level ground.
- ii. Fix the four castor wheels at the bottom of the base plate. The castor wheel with brake shall be in the front.
- iii. Fix the four foot bolts at the bottom, the Machine can be moved by the castor wheels when the foot bolts are turned up and not touching the ground.
- iv. When the machine is in operation in conjunction with any shrink tunnel, these foot bolts are turned down and the machine will be resting on the bolt not on castor wheels.
- v. Mount the reel holder on the side of the machine by the screws provided.
- vi. The machine can now be plugged into a grounded 15A 3 pin power socket.

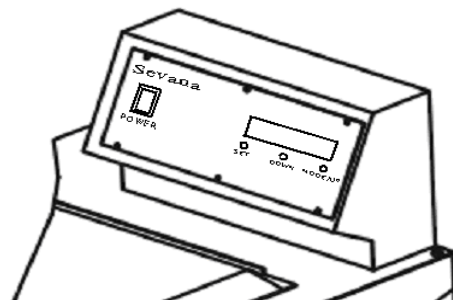
10. FEATURES

- ❖ This machine is widely used for wrapping the product before shrinking in shrink tunnels.
- ❖ All shrink films can be used with this machine such as shrinkable PVC, POF and Shrinkable LDPE etc. However POF is best suited with this machine.
- ❖ The sealing blade is Nickel chromium alloy.
- ❖ The sealing time, cooling time, conveyor on time etc can be easily set by push button switches provided on the control panel.
- ❖ The product being wrapped is automatically moved by the conveyor belt and will be fed to the shrink tunnel.
- ❖ This is a continuously rated machine. This will work in conjunction with all models of shrink wrapping tunnels of Sevana.

11. OPERATION

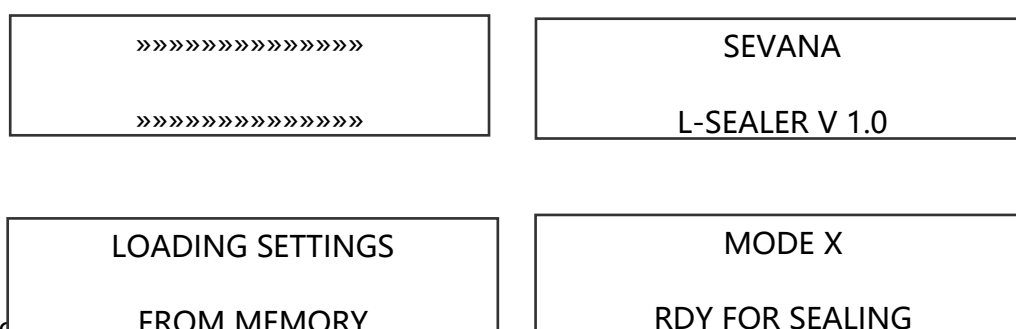
CONTROL BUTTONS:

- ❖ POWER switch
- ❖ SET button
- ❖ DOWN button
- ❖ MODE/UP button



To start the machine, connect the machine to appropriate power supply and switch on the "POWER" switch.

A LCD check function is done first, version of the software is displayed.



SEVANA RDY FOR SEALING

PROGRAM MODES:

The machine has four modes/program presets. Each mode/preset parameters are

1. Sealing time
2. Cooling time
3. Conveyor motor on time
4. Buzzer on/off

These parameters can be modified by the operator if required. (Each mode can be used for different type of films/products).

The machine will automatically go to the previously used mode after initializing.

TO PRESET PROGRAM MODES:

Sealing time : 1.1 Seconds

Cooling time : 3 Seconds

Conveyor motor on time : 3 Seconds

Buzzer : on

Select the mode by pressing "MODE/UP" button

To set the temperature press "SET" button. It displays "SET-HEATER ON TIME: X.X"

SET-HEATER ON TIME: 1.1 SEC

To increase the temperature press the "MODE/UP" button till the required value is reached.

SET-HEATER ON TIME: 1.3 SEC

Press the "SET" button.

SET-COOLING ON TIME: 5 SEC

To decrease the cooling time press the "DOWN" button till the required value is reached.

SET-COOLING ON TIME: 3 SEC

Press the "SET" button.

SET-MOTOR ON TIME: 1 SEC

To increase the conveyor time press the "UP" button till the required value is reached.

SET-MOTOR ON TIME: 3 SEC

Press the "SET" button.

SET-BUZZER ON/OFF:OFF

Press the "UP" button to set the buzzer "ON" .

SET-BUZZER ON/OFF:ON

Note: Press the "DOWN" button to set the buzzer "OFF" .

Press the "SET" button.

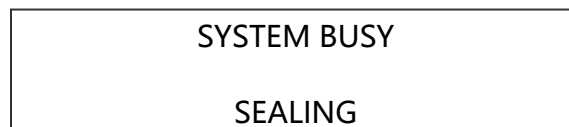
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PLEASE WAIT...

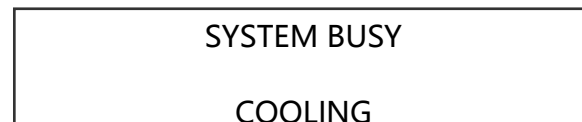
SETTINGS UPDATED.

OPERATION SEQUENCE:

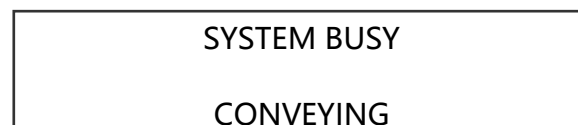
Sealing



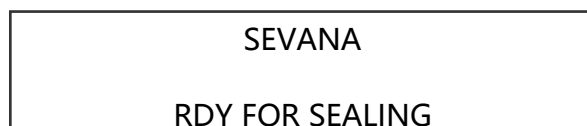
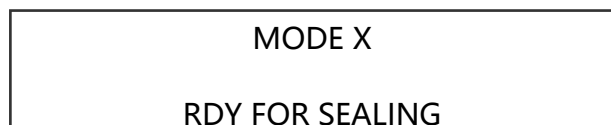
Cooling



Conveyor working

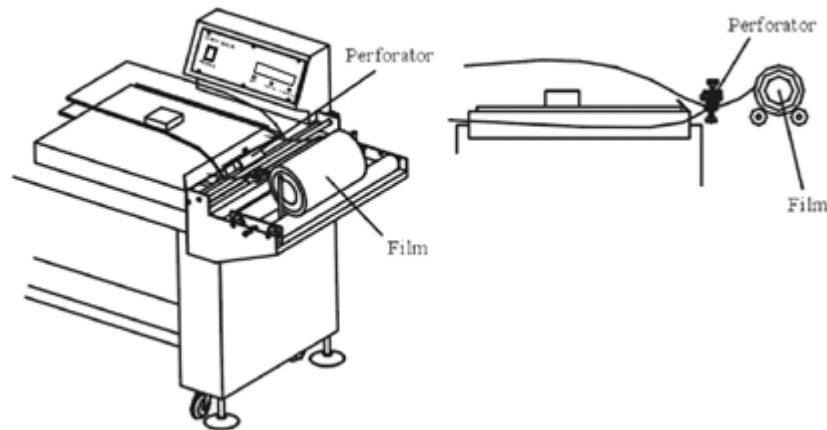


When cycle completes



FEATURES: If the heating element is overheated then the operation is aborted.

12. LOADING OF FILM AND WORKING



- ❖ Set the sealing time, cooling time and the conveyor on time with the help of the tact switches on the control panel according to the thickness and characteristics of the shrink film; size and weight of the item being packed. (The Appropriate sealing time leads to the film to be cut off completely and a good sealing effect. If the sealing time is too short, the film may not cut off. If the sealing time is too long, it will spoil the sealing blade, pressure pad and Teflon tape. The power consumption also will be high.)
- ❖ Place the film reel between the two poles (film guided)on the reel holder (make the open side of the film toward to the operator), position the two poles and fasten them.
- ❖ Take the film through the perforating wheel; separate the two layers; guide the working table between the layers.
- ❖ Adjust the height of the conveyor belt such that the sealing blade falls at the centre of the height of the product.
- ❖ Stretch the film to the sealing area and seal to close the open end.
- ❖ Place the product on the working table, covered by the upper sheet of the film, stretching the film and the product to the sealing area in the left.
- ❖ Keep a distance of $\frac{1}{2}$ height of the product between the product and the sealing blade in order to have enough film for shrinking.
- ❖ Press down the sealing bar. The sealing bar will be held down by the hold down magnet and the sealing will be done automatically.
- ❖ The sealing bar releases automatically when sealing is finished, the conveyor belt starts and convey the wrapped product to the shrink tunnel for shrinking.

13. MAINTENANCE

- ❖ Daily maintenance

Clean the working table and the transporting belt after the use with compressed air or an air blower.

❖ Weekly maintenance

- Clean the sealing blade weekly. Notice: Clean the sealing blade by a piece of dry cotton with the release agent. Don't use any metal article to scratch the sealing blade.
- The movable parts (such as transmission chains, bearings) may be oiled with suitable lubricating oil.
- The sealing blade, Teflon tape, pressure pad rubber may be inspected. If seen worn out, replace worn out parts.

❖ Consumable Spares

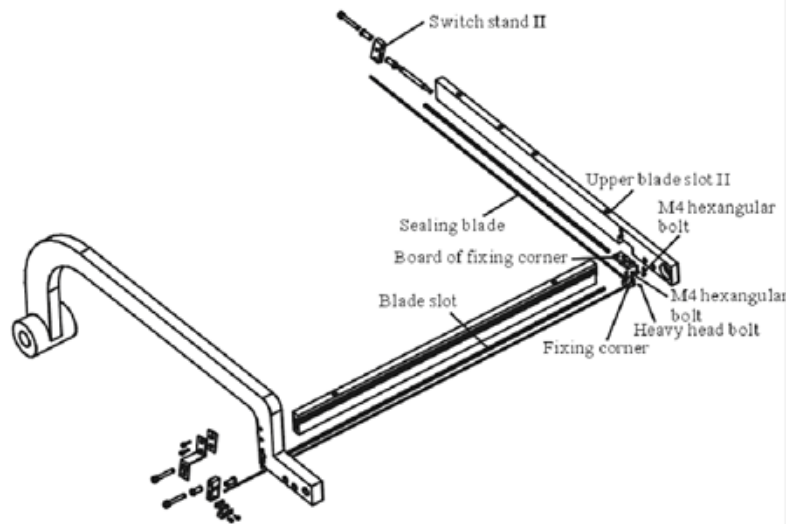
The below given spares are categorised as consumables and it will not be considered as warranty spares.

- Teflon tape
- Heating element
- Synthanum (Heat insulator)
- Gasket (Neoprene rubber)

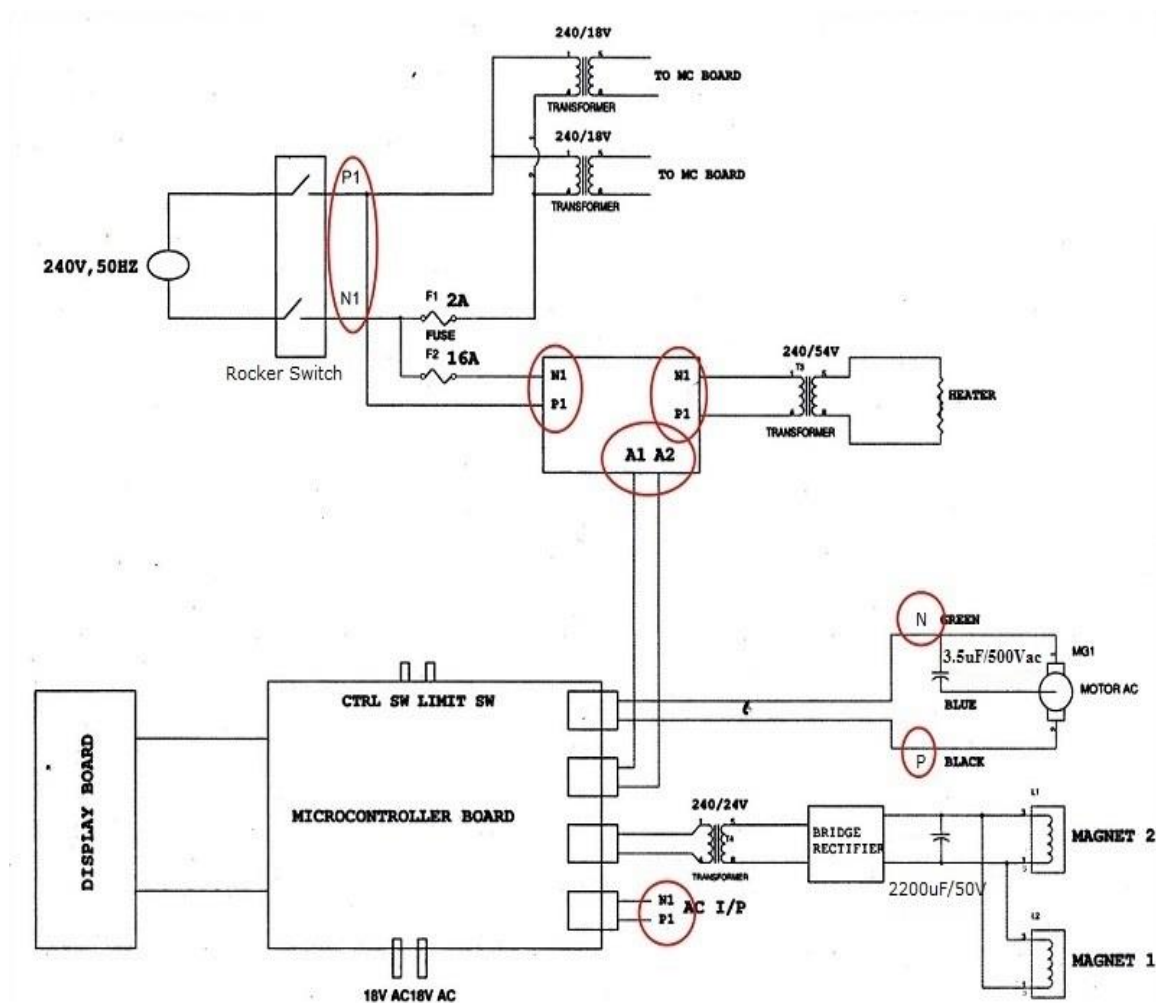
Note : After installation, any physical damage of body parts due to the mishandling is not cover the warranty of the specific parts. It will be strictly inspected by SEVANA team.

REPLACING SEALING BLADE:

- a) Turn the machine power off.
- b) Make the curl part of the two ends of the sealing blade straight Notice: Please do it lightly in order to avoid the rupture of the nylon cover of the blade clamp.
- c) Unfasten the screws on the tow ends of the blade clamp, take the worn sealing blade out.
- d) Put on end of the new sealing blade into the slot of the blade clamp, 5 mm left outside of the clamp, then tighten the screws and curl the extend blade outside the clamp.
- e) Put the new sealing blade into the ceramic blade slot lightly, then put the other end of the sealing blade into the slot of the other blade clamp.
- f) Straighten the sealing blade, fasten the screws and curl the two ends of the sealing blades.



14. ELECTRICAL SCHEMATIC



VERSION: V1.0

15. TROUBLESHOOTING

Problem	Cause	Solution
The machine does not seal	The fuse blown out	Replace the fuse with a new one
	The heating element is damaged	Replace the sealing blade with a new one
	The thermal expansion protection gap is too small	Keep the gap to 3.5 mm between the screw and the blade clamp to protect the sealing blade.
	Sealing Transformer damaged	Replace the transformer with a new one
The heating element heats up, but the film does not cut off properly	Partial damage for the heating element	Replace the heating element with a new one if damage found.
	Something unknown attached on the sealing blade	Clean the sealing blade by a piece of dry cotton and the release agent
	The Teflon belt damaged	Replace the Teflon belt with a new one
	Neoprene rubber is damaged	Replace the neoprene rubber with a new one if its surface is not smooth
	The screws for fixing the ceramic slot of the sealing blade found to be unfastened.	Level the ceramic slot and fasten the screws
The conveyor belt does not move	The conveyor time set is too low	Increase conveyor time
	The conveyor section fuse blown out	Replace the fuse with a new one
	The conveyor belt tension too low	Tighten the belt
	Defective conveyor motor	Replace the motor
	Defective capacitor	Replace the capacitor

16. SERVICE LOG

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