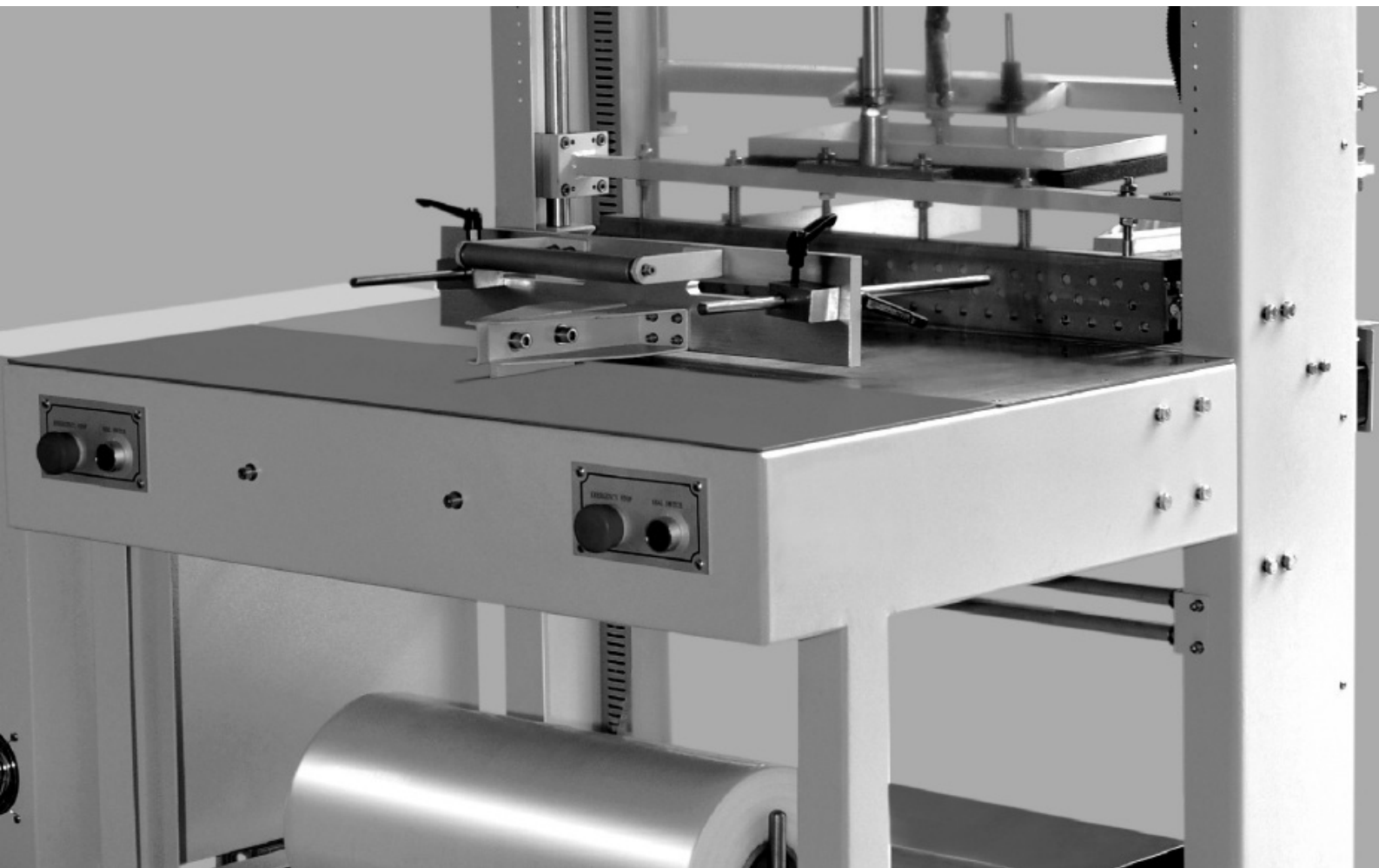




AN ISO 9001:2008 CERTIFIED COMPANY

USER MANUAL

Sleeve Wrapper/Web Sealer

Quick Wrap12040SW



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.

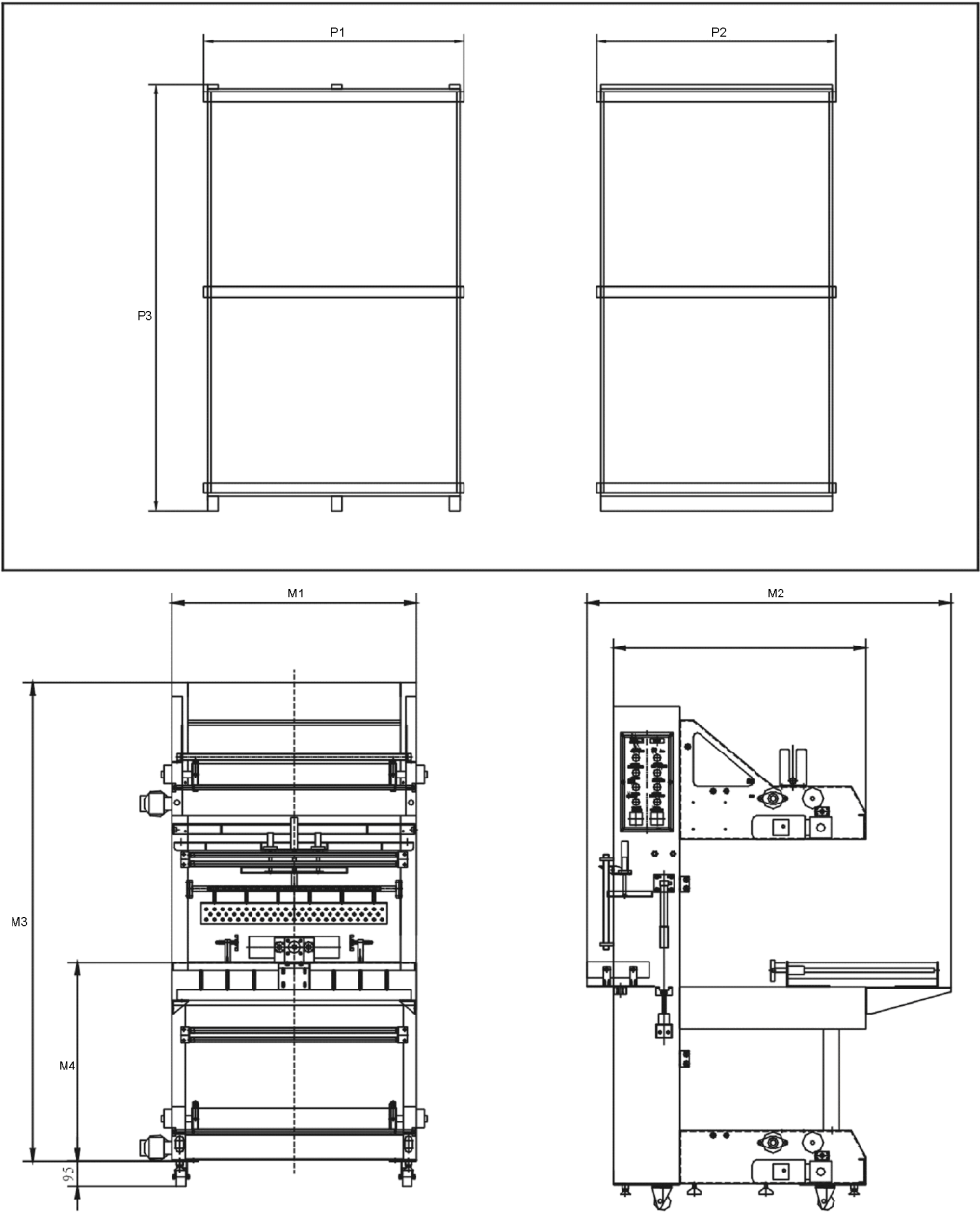
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3. SAFETY PRECAUTIONS

- ❖ The machine should be properly earthed before use.
- ❖ The machine should be fed from a TPN MCB or fuse switch of sufficient rating.
- ❖ The phase sequence should be proper. Otherwise the film unwinding motor will rotate in opposite direction causing damage to the film.
- ❖ Avoid spillage of liquid on to the machine to avoid electric shock and damage to machine parts.
- ❖ The machine should be installed in an area away from dust and humidity.
- ❖ Do not keep any metallic or hard material on the seal cutting area.
- ❖ Do not insert your hands in the seal cutting area while the machine is in operation.
- ❖ Provide clean power to the machine. The electric supply should be 415 V, 50 Hz three phase AC. The compressed air supply shall be dust and humidity free air at 8-10 atmospheres.
- ❖ Set sealing time and temperature according to material and thickness of the film, generally sealing time is 0.5-1.5 sec. and sealing temperature is 90 – 115 deg. Celsius. Shorter or longer sealing time and lower or higher sealing temperature may cause bad sealing of the film or damage to pressure pad and or to Teflon tape.
- ❖ The machine should be serviced only by trained/authorised technician.
- ❖ Isolate electric supply and compressed air input before attempting any service.

To avoid burn injury, do not touch the sealing head while the machine is in operation.

4. CASE AND MACHINE DIMENSIONS



Model	P1	P2	P3	M1	M2	M3	M4
QW12040SW	2385	2240	2365	1740	1630	2060	900

5. PACKING SLIP

No.	Name	Quantity
1	Machine	1 Set
2	Teflon tape	1 Roll
3	Quality Certificate	1 Sheet
4	Toolbox	1 Piece
5	User manual	1 Piece
6	Monkey wrench	1 Piece
7	Allen key	1 Set
8	" + " screwdriver	1 Piece

6. UNPACKING

- ❖ The machine is shipped well packed in a wooden box
- ❖ The following items are packed separately
 - The product push pneumatic cylinder and its cover
 - The castor wheels and foot screws
 - Tool box.

Please verify the items with the packing slip.

- ❖ Place the packing with the "top" panel facing upwards.
- ❖ Remove the top panel and the four side panels.
- ❖ The machine is bolted to the bottom Plank. Remove the bolts.
- ❖ Assemble the four castor wheels.

The machine now can be moved to the place of installation on castor wheels. It is recommended to keep the machine on its four foot screws. Assemble the four foot screws such that the machine is resting on the foot screws and not on the castor wheels. When the machine has to be moved, turn up the foot screws till the machine is resting on castor wheels.

7. TECHNICAL SPECIFICATIONS

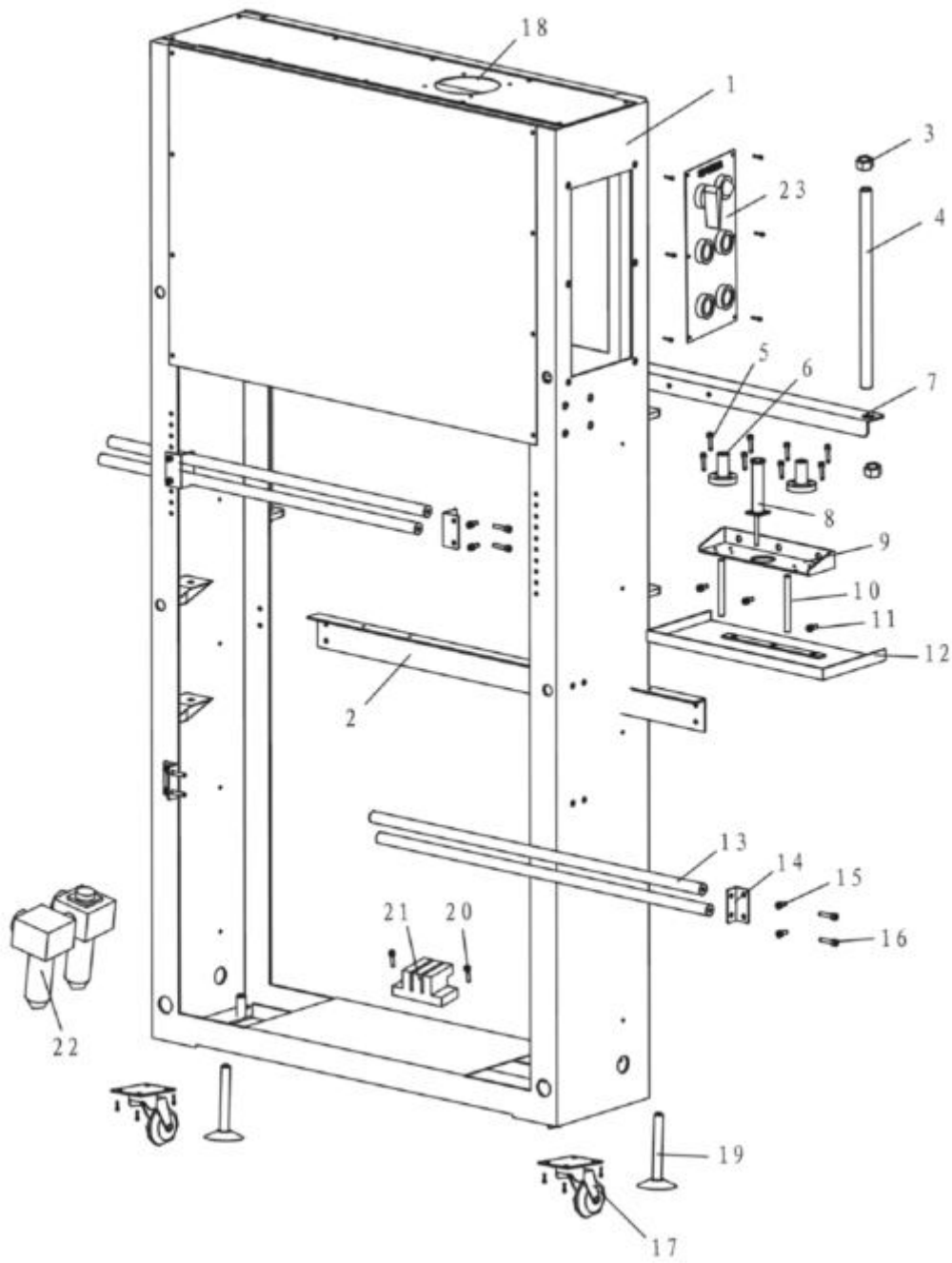
Model	12040SW
Power supply	3P/ 415V 50 Hz
Max packing size	L + H= 1200XW500XH400 (mm)
Sealing time	0.5 - 1.5sec
Power	1.8 KW
Compressed air supply	8 – 10 kg / cm ²
Film type	Shrinkable Poly Ethylene : 40 – 120 micron
Machine dimension	L 1740 x W 1630 x H 2060
Packing speed	5-8pcs / min
Sealing temperature	0-250
Width of film	Max : 1150 mm
Net weight	450 kg

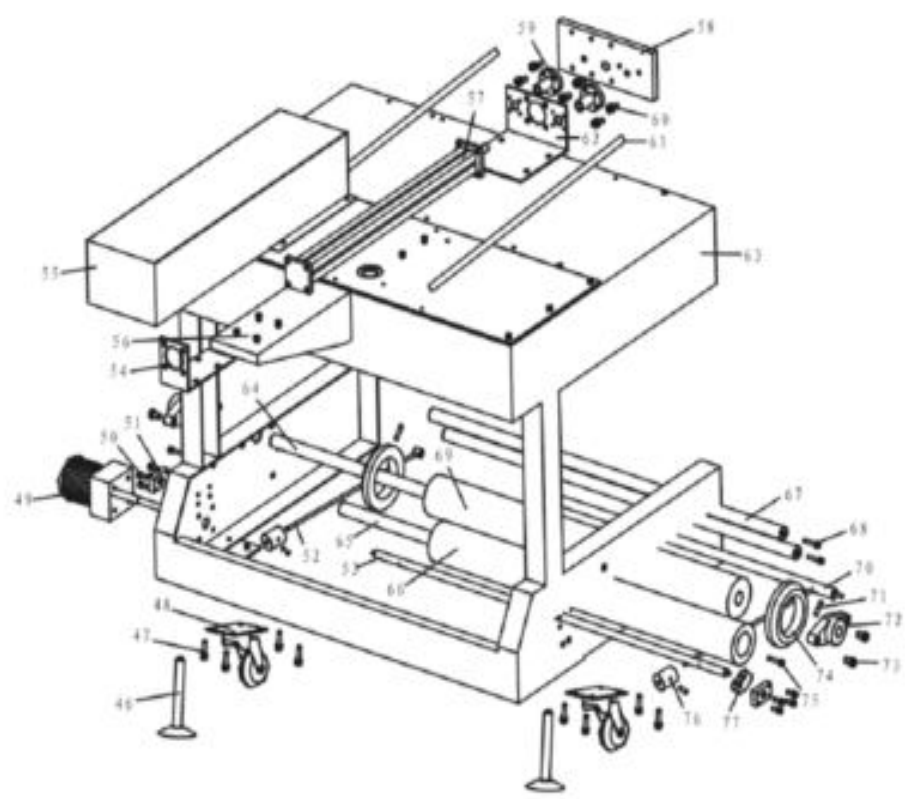
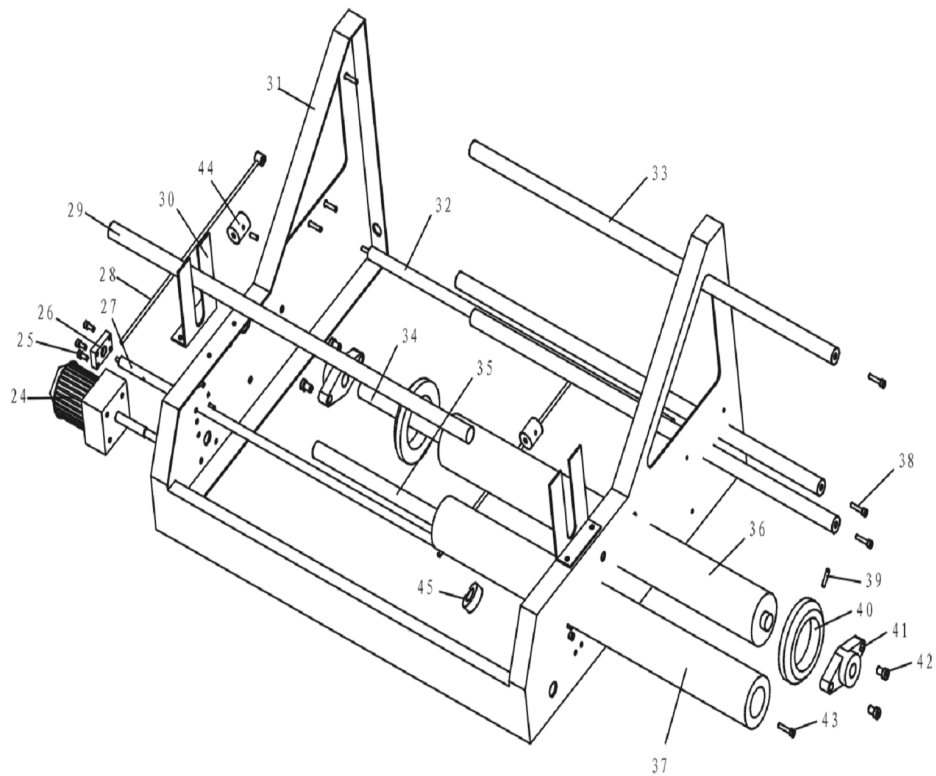
8. INSTALLATION

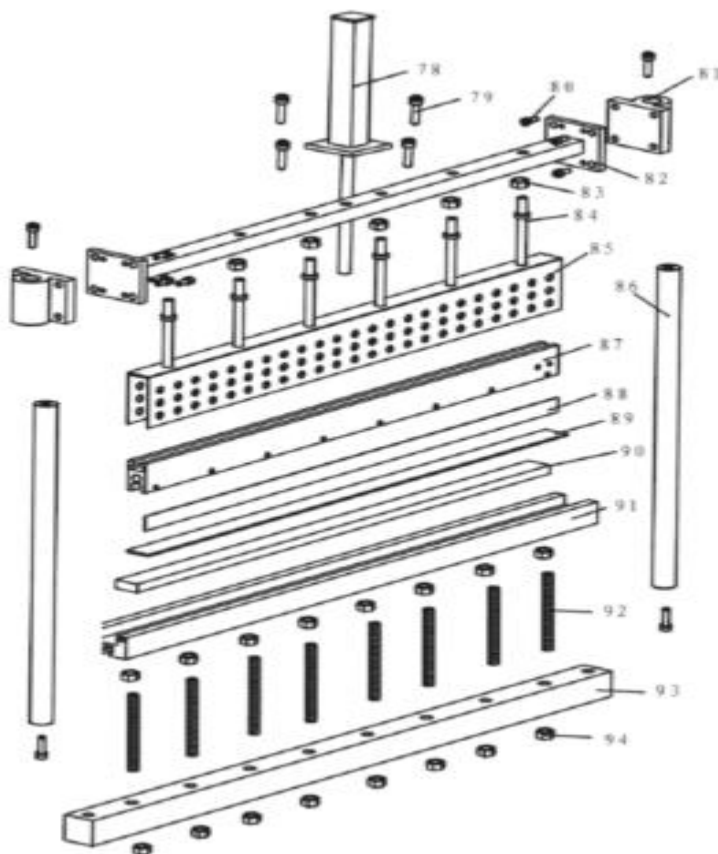
Please install the machine according to the following steps:

- ❖ The machine should be installed in well ventilated clean room free from dust or dampness. The work table should be horizontal in both the directions. If not, adjust the foot screws to achieve this.
- ❖ Check the insulation resistance of the machine between the three phase lines shorted and the body of the machine. The reading should be at least a few mega ohms.
- ❖ Earth the machine properly and connect the power line ensuring proper phase. This can be verified by slightly lifting the film tension pendulum when the film feed roller will rotate in anti clock wise direction when viewed from the left side of the machine. If the rotation is opposite, interchange any two phase lines.
- ❖ Install the product push air-cylinder and connect the pneumatic connections to it. Fix its cover.
- ❖ Fill the lubricator with oil and give the compressed air connection to the FRL unit. The compressed air supply should be at 8 -10 atmospheres. (8 -10 Kg/sq. cm)
- ❖ Remove all ties provided for arresting the movement of loose parts. Remove all stretch wrappings.
- ❖ Adjust the product pushing length as per the job requirement and fix the air –cylinder and protective cover.
- ❖ Adjust the FRL unit to get an out put pressure of 6 atmospheres (6 kg/sq. cm)

9. LIST OF PARTS







No.	Name	Qty
1	Machine frame	1
2	Joint board	1
3	Screws M 20	4
4	Screws for air-cylinder's rise & fall	2
5	Bolt M5x20	8
6	Air-cylinder guide base	2
7	Air-cylinder rise & fall girder	1
8	Air-cylinder	1
9	Air-cylinder installation base	2
10	Air-cylinder guide pole	2
11	Bolt M6x15	3
12	Pressing board	1
13	Film release handle	4
14	Film release handle installation base	4
15	Bolt M 6 x 15	8

16	Bolt M 6 x 20	8
17	Trundle	2
18	Fan	1
19	Base bolt	1
20	Bolt M 5 x 15	2
21	Electromagnetic valve	4
22	Filter bearing	1
23	Panel	1
24	Film feeding motor	1
25	Bolt M 5 x 20	8
26	Film holder shaft installation base	2
27	Film holder shaft	1
28	Film holder joint pole	2
29	Upper film protective pole	1
30	Upper film protective pole base	2
31	Upper film holder	1
32	Film release handle	1
33	Film release handle	3
34	Film holder axes	1
35	Film holder drive axes	1
36	Film holder axes bushing	1
37	Film holder driven axes bushing	1
38	Bolt M 8 x 20	6
39	Bolt M8 x 20	2
40	Drive wheel fixing ring	2
41	Bearing with a base	2
42	Bolt M 12 x20	4
43	Bolt M 10 x 30	4
44	Film holder balancer	2
45	Film release motor roller	1
47	Base bolt	2
47	Bolt M 6 x 30	8
48	Trundle	2

49	Film release motor	1
50	Bolt M 5 x 20	8
51	Film holder shaft installation base	2
52	Film holder joint pole	2
53	Film holder shaft	1
54	Rear base for air-cylinder installation	1
55	Air-cylinder protective cover	1
56	Air-cylinder installation base	1
57	Air-cylinder installation cover	1
58	Pushing board	1
59	Air-cylinder guide base	2
60	Bolt M 5 x 25	8
61	Air-cylinder guide pole	2
62	Air-cylinder installation base 2	1
63	Lower film holder	1
64	Film holder drive shaft	1
65	Film holder driven shaft cover	1
66	Film holder driven shaft cover	1
67	Guide handle	2
68	Bolt M 8 x 20	4
69	Film holder drive shaft cover	1
70	Film holder guide handle	1
71	Bolt M 5 x 10	2
72	Shaft with base	2
73	Bolt M 12 x 20	4
74	Drive wheel fixing ring	2
75	Bolt M 10 x 30	4
76	Film holder balancer	2
77	Film release motor roller	1
78	Sealing air-cylinder	1
79	Bolt M 8 x20	4
80	Bolt M 8 x 15	8
81	Sealing wire slide cover	2

82	Sealing wire installation beam	1
83	Bolt M 10	12
84	Sealing wire adjusting bolt	6
85	Sealing wire baffle	1
86	Sealing wire guide rail	2
87	Cutting system	1
88	Sealing wire	1
89	Teflon tape	1
90	Silicone gasket	1
91	Silicone gasket groove	1
92	Silicone gasket groove adjusting bolt	8
93	Silicone groove installation beam	1
94	Bolt M 12	16

10. APPLICATION

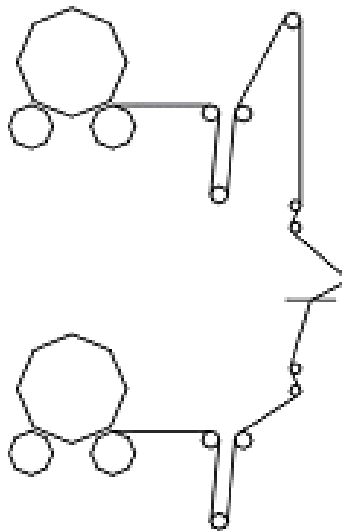
This machine is mainly used for sleeve wrapping heavy product like cartons, beverage bottle bundles, etc with heat shrinkable film usually LDPE before heat shrink wrapping. The machine consists of three main parts: body, electrical system, and pneumatic system. Sealing temperature is controlled by a digital temperature controller, and sealing time is controlled by an electronic timer. The product pushing and sealing jaw operation are achieved using pneumatic cylinders. The sealing time and sealing temperature are adjustable. The sealing timer, temperature controller, ON push button, emergency OFF push button and auto manual selector switch are located on the right side of the machine on the main frame. Product push button and the emergency off push buttons are mounted on the front cross beam of the product table.

11. OPERATION

- ❖ Switch on the electric supply and compressed air supply. The pressure gauge on the FRL unit shall indicate 6 kg/ sq.cm. If not, adjust the FRL unit. The power on indication lamp will light up. The sealing cylinder, the product push cylinder and the product hold cylinder will come to the home position. (retracted position)
- ❖ Load film rolls and lock the film guides. For the convenience of centrally locating the film roll, centre zero scales are provided in front of the film support rolls.
- ❖ Set the sealing temperature and sealing time.
- ❖ Guide the film through the appropriate rollers and film tension pendulums as shown in the diagram fitted on the right side of the machine.
- ❖ Take out the ends of both film as per the sketch and lay one above the other on the output side of the machine.
- ❖ Turn the auto manual selector switch to manual mode. Press the seal push button. Now the sealing/cutting cylinder will operate. Now both the rolls are sealed into one continuous film.
- ❖ Verify the sealing/cutting. If it is not satisfactory adjust the sealing temperature and sealing time.

- ❖ Depending upon the size of the packet to be sleeve wrapped, adjust the position of the job stopper guide on the left and the job pusher pneumatic cylinder.
- ❖ Adjust the job holder 10 mm above the job to held while seal cutting operation
- ❖ Interface the shrink tunnel and output conveyor for the smooth transfer of products from the wrapper, shrink tunnel and output conveyor.
- ❖ Sealing time and temperature are to be adjusted according to the thickness and material of film. For PE film, we recommend the temperature at 90 - 110 degree Celsius and the seal cutting time is approximately 0.5 to 1.5 seconds
- ❖ Three emergency push buttons (Red mushroom) are provided; two in front and the other on the right side to switch off the machine during emergency. This switch can be reset by turning the knob in the direction shown by the arrow. The machine should be shut down as per the following procedure.
 - Switch off the sealing heater.
 - After the heater has cooled down switch off compresses air supply and electric power.

FILM LOADING DIAGRAM:



12. MAINTENANCE

Caution: Isolate electric power and compressed air supply before doing the maintenance.

A) Daily Maintenance

1. Blow off the dust and film debris using a blower or compressed air.
2. Inspect the cutting and sealing blades for any damage. If damaged replace.
3. Clean the cutter with a clean cotton cloth. Do not use any metal or any hard object to clean the blade.

B) Weekly maintenance.

1. Grease the bearings with a grease gun.
2. Apply grease to the rack and pinion,
3. Apply grease to the linear bearings.
4. Apply oil to other moving parts.

C) Monthly maintenance.

1. Check the oil level in the FRL unit. If low, refill it.
2. Check the tightness of bolts and nuts. If loose. Tighten them properly.
3. Inspect the Teflon tape and silicone rubber pad. If worn out replace.
4. Inspect the FRL unit. Discharge the water if any collected in the regulator bowl. If the bowl has become dirty clean it.

13. TROUBLESHOOTING

Problem	Cause	Solution
Film release motor does not work	Pressed emergency switch	Reset emergency switch
	Chain slipped	Restore chain
	Contacter damaged	Replace contractor
	Micro switch isn't at right position	Adjust micro switch position
	Defective micro switch	Replace micro switch
Pushing air-cylinder doesn't work	Compressed air supply not available	Restore compressed air supply
	Pushing micro switch defective	Replace micro switch
	Push solenoid valve defective	Replace solenoid valve
Sealing air-cylinder doesn't work	Seal bar level sensors not at correct position	Set seal bar sensors to correct position
	Sealing solenoid valve defective	Replace solenoid valve
The film does not seal and cut off	Sealing temperature set low	Increase the set temperature
	Defective temperature controller	Replace temperature controller
	Defective cartridge heater	Replace cartridge heater
	Cutting blade damaged	Replace cutting blade
	The sealing blades and cutting blade are not at proper levels	Sealing blades should be 0.4-0.5 mm above the bottom level of cutting blade. Adjust properly
Bad sealing	Surface of sealer or cutter damaged	Replace sealer or cutter
	Deposit of plastic or other foreign body on the blades	Clean with dry cotton cloth

14. ELECTRICAL SCHEMATIC

1	V1	Rectifier
2	T1	Electromagnetic transformer
3	KT2	Time relay
4	FU 1	Sealing loop fuse
5	FU 2	Heater loop fuse
6	FU 3	Wind blower loop fuse
7	FU 4	Electromagnet fuse
8	KM 1	Sealing loop contactor
9	KM 2	Heater loop contactor
10	KM 3	Wind blower loop contactor
11	KM 4	Electromagnet loop contactor
12	T 1	Sealing transformer

MCB: Merlin Gerin Smart; 50Hz; 400V; 16A- 1no; 10 A & 2A – 1 no each

RELAYS: Model No: MKS 2P OMRON; AC 220V – 6 Nos; DC 24 V – 1 No

FILM ROLL MOTOR: 3phase Induction Motor, 1/4 HP, 0.18KV, Δ 220V

CONTACTOR: 220- 230 V 50 Hz; Telemecanique; Schneider Electric.

SENSORS(Ferrules):

Sealing cylinder:

Bottom Sensor – 07/05

Top Sensor – 08/05

Motor Bottom Limit Switch - 09/05

Motor Top Limit Switch - 10/05

Product Movement cylinder:

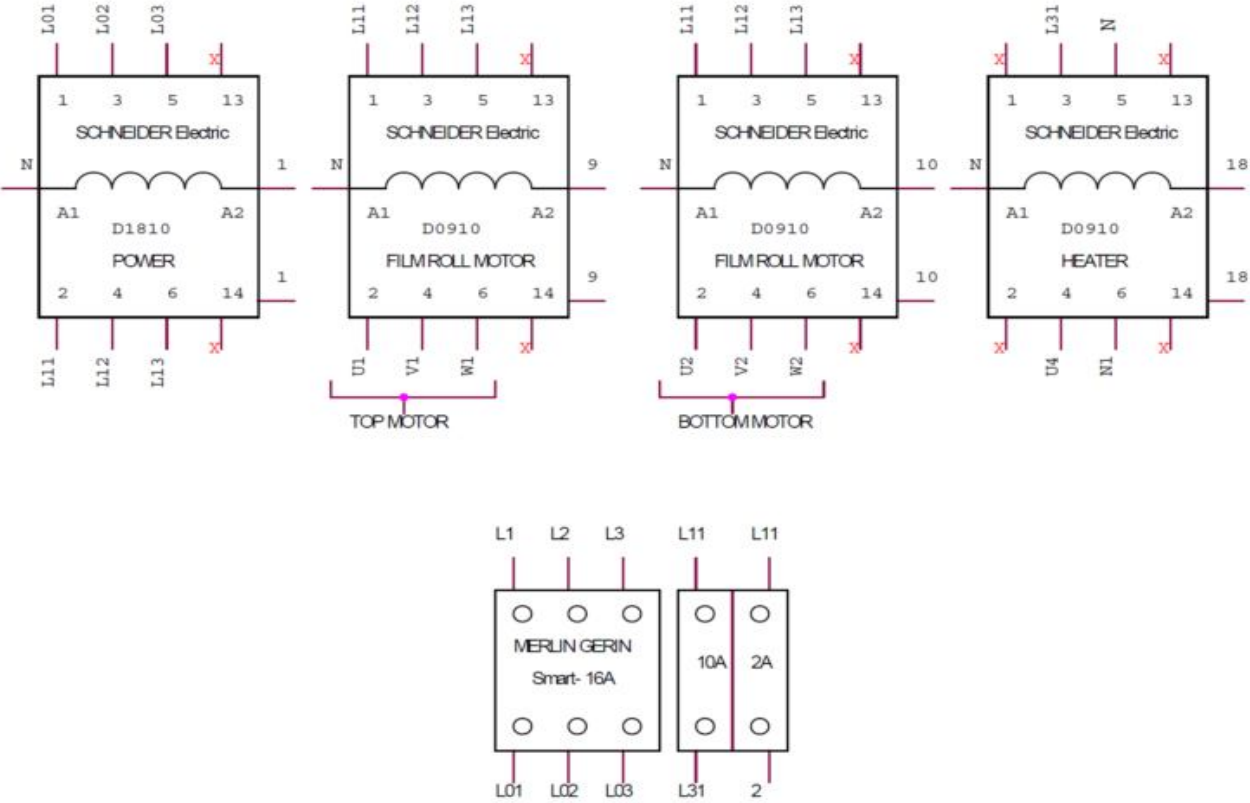
Front Side Sensor - 21/05

Back Side Sensor - 22/06

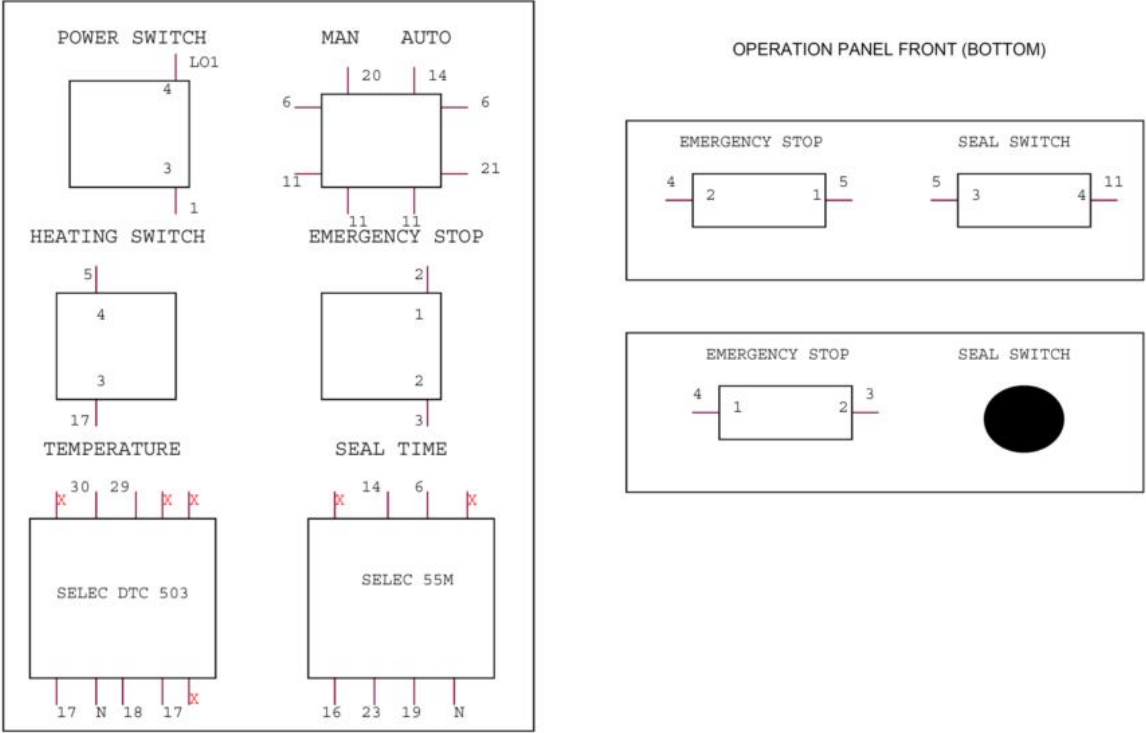
Metal Sensor For Heater - 24V (Brown)/26 (Black)/ 0V (Blue)

Temperature Probe - N1/U4 to Heater

CONTACTORS & MCB:



FRONT PANEL:



RELAYS:

