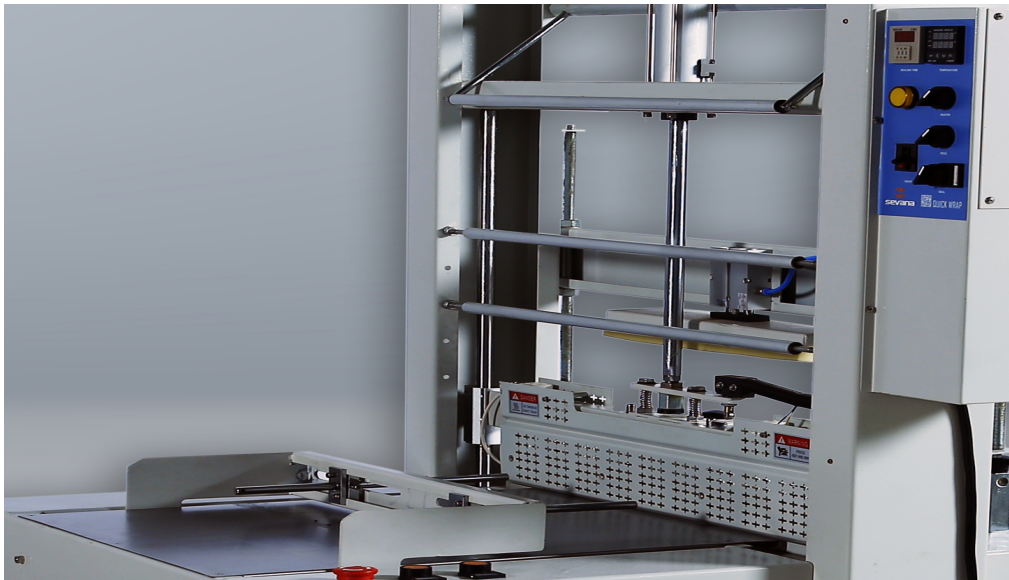
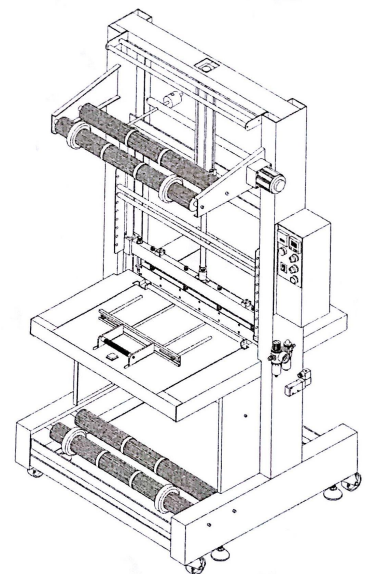




AN ISO 9001:2015 CERTIFIED COMPANY

USER MANUAL

QW6540SW



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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

Toll Free	:	18004250780	
Email	:	customercare@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 , 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

- ❖ The machine should be properly earthed before use.
- ❖ The machine should be fed from MCB or fuse switch of sufficient rating.
- ❖ Avoid spillage of liquid onto 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 230 V, 50 Hz single phase AC. The compressed air supply shall be dust and humidity free air at 6-8 bar
- ❖ Set sealing time and temperature according to material and thickness of the film, generally sealing time is 1-2 sec. and sealing temperature is 150 – 180 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/authorized 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
QW6540SW	1040mm	930mm	1920mm	1000mm	880mm	1800mm	740mm

5. PACKING SLIP

No.	Name	Quantity
1	Machine	1
2	Warranty Card	1
3	FOC Kit	1

6. UNPACKING

- ❖ The machine is shipped well packed in wooden box
- ❖ Place the packet with the “top” marked to the top
- ❖ Remove the 4 sides and the top cover
- ❖ The machine comes with 4 castor wheels; push the machine to the level of ground
- ❖ Remove the stretch wrapping film wrapped around the machine.
- ❖ Inspect for any transit damages. If any damages are found, notify the dealer or company immediately.

7. TECHNICAL SPECIFICATIONS

Model	QW 6540SW
Power supply	1P/ 230V 50 Hz
Max packing size	650X300X380 (mm)

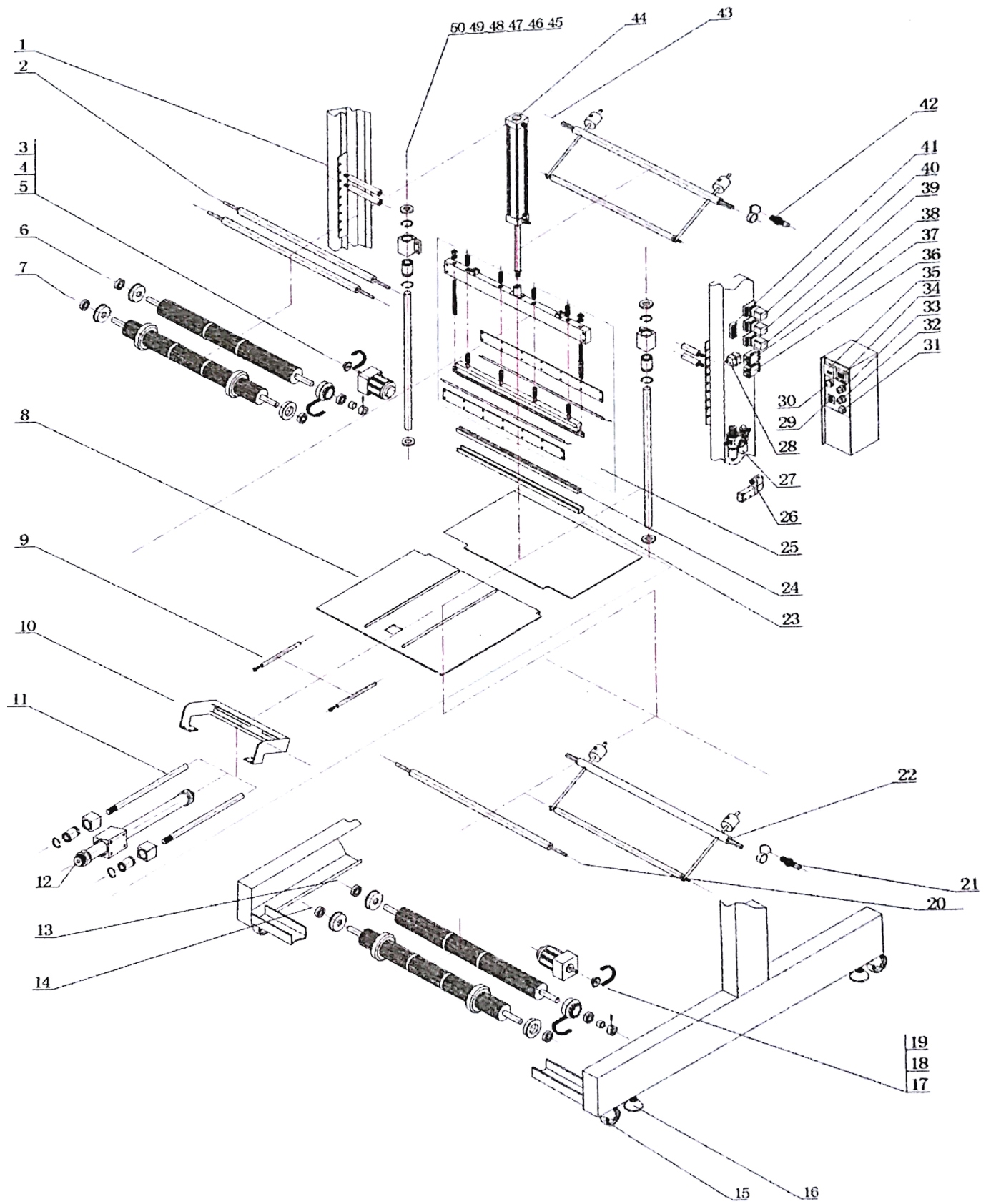
Power	1.5 k W
Compressed air supply	6-8 bar
Machine dimension	875 x 1040 x 1925
Net weight	300 kg

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.
- ❖ Earth the machine properly and connect the power line.
- ❖ Connect the compressed air connection to the FR unit. The compressed air supply should be at 6-8 bar.
- ❖ Adjust the product guide according to the product.

9. LIST OF PARTS



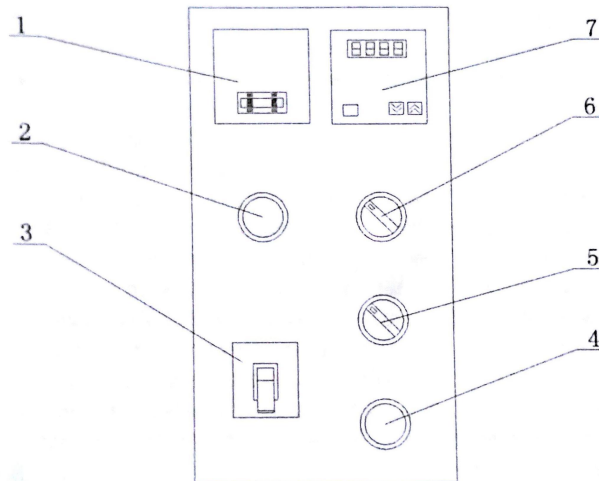
S.No.	Name
1	Up film guiding roller
2	Film hang roller assembly
3	Up film motor drive assembly
6	Up film roller assembly
8	Conveyor assembly
9	Adjusting pole
10	Pushing frame
11	Cylinder assembly
13	Down film roller assembly
15	Truckle
16	Height adjusting bolt (M16)
17	Down film motor assembly
20	Down film guide roller
21	Film hang roller assembly
23	Blade seat blocking slot
24	Blade seat
25	Blade assembly
26	Electronic valve
27	Pressure regulator valve
29	Control panel
30	Control cabin

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. CONTROL PANEL

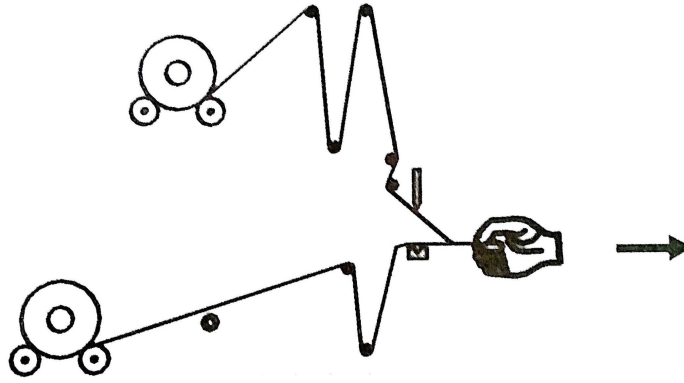
1. Sealing Time
2. Led Indicator
3. Power Switch
4. Seal Switch
5. Feed Switch
6. Heater Switch
7. Temperature Controller



12. 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, center 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
- ❖ Emergency push buttons (Red mushroom) is provided 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 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	Reason	Solution
Film release motor does not work	Pressed emergency switch	Reset emergency switch
	Chain slipped	Restore chain
	Relay damaged	Replace relay
	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

[illegible]