



AN ISO 9001:2015 CERTIFIED COMPANY

USER MANUAL

Shrink Tunnel

QS4025STV/QS4025STVL/
QS5040STVL/QS7545STVL



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 the 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 center kindly provide the following information for a speedier support and service.

- ❑ Model
- ❑ Serial No
- ❑ 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 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

❖ Introduction

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.

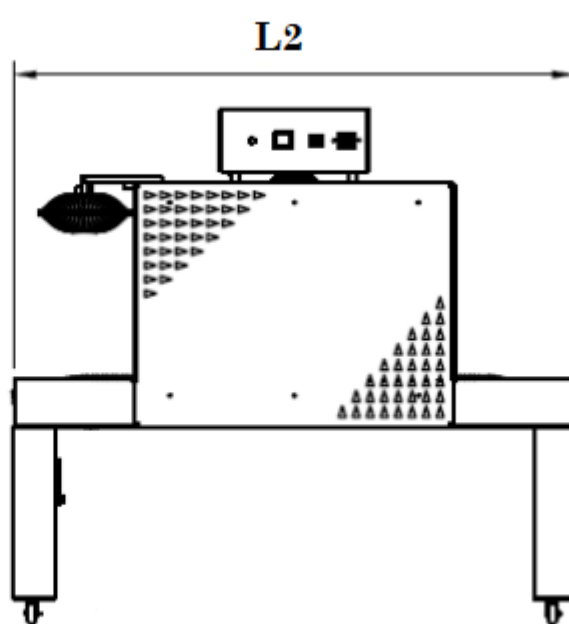
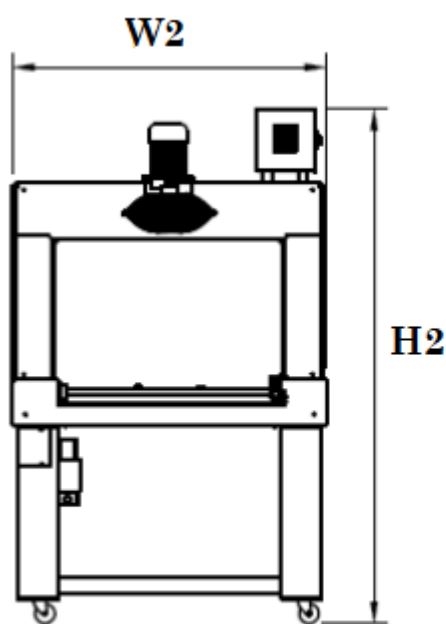
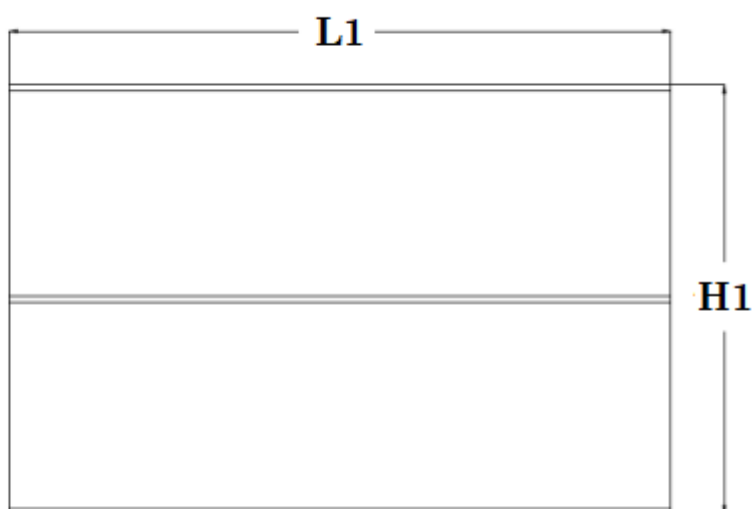
❖ Warning

A warning describes safety hazards or unsafe practices which could result in personal injury or loss of life. A warning message is accompanied by a symbol as described in the following paragraphs and is also surrounded by a box to attract your attention.

i.		This is a warning symbol indicating a hot surface.
ii.		This is a warning symbol indicating moving parts.

- ❖ The machine has to be grounded properly before using.
- ❖ Never try to shrink wrap explosive or inflammable material.
- ❖ Do not insert your hand in the chamber when the machine is in operation.
- ❖ Do not allow any liquid to go into the machine.
- ❖ Do not keep shrinkable film on the machine.

4.PACKING CASE AND MACHINE DIMENSIONS



MACHINE/DIMENSION	L1	W1	H1	L2	W2	H2
QS4025STV	1380	820	1045	1260	670	1455
QS4025STVL	1930	820	1045	1810	670	1455
QS5040STVL	1930	920	1195	1810	770	1605
QS7545STVL	1930	1170	1245	1810	1020	1655

5. 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.
- ❖ Remove all the side panels and top panel of the box.
- ❖ Lift the machine with the crate using a pallet jack..
- ❖ The legs are separately packed and kept inside the box. Assemble the leg frame .
- ❖ Place the machine on the top of the leg assembly and fasten the screws.
- ❖ The conveyor chain is tied to arrest movements during transportation. Remove the tie.

Tools required to unpack

- Pry bar/Crowbar
- Claw hammer

6. PACKING SLIP

Item	Quantity
Machine	1
User manual	1
Warranty card	1
Double open-end wrench/spanner 10-11	1
Double open-end wrench/spanner 12-13	1
Double open-end wrench/spanner 16-17	1

7. TECHNICAL SPECIFICATIONS

Model		QS4025STV	QS4025STVL	QS5040STVL	QS7545STVL
Conveyor speed(m/min)		0-7.2	0-7.2	0-7.2	0-7.2
Travel time(S)		Variable	Variable	Variable	Variable
Window size(mm)	B	400	400	500	750
	H	250	250	400	450
Max. object size	B	350	350	450	700
	H	230	230	380	430
Power(KW)		7.5	9	12	16.5
Voltage(V)		415	415	415	415
Phase		3	3	3	3
Chamber length(mm)		1000	1000	1000	1000
Conveyor height(mm)		800+50	800+50	800+50	800+50
Dimension (mm)	L	1260	1810	1810	1810
	B	670	670	770	1020
	H	1455+50	1455+50	1605+50	1655+50

8. INSTALLATION

- ❖ Secure the horizontal channel to the vertical legs using the nuts and bolts provided with the machine.
- ❖ Ensure that the leg assembly is placed on level ground.
- ❖ Attach the chain support to the bottom of the legs.
- ❖ Gently position the chassis onto the vertical leg assembly, making sure the corners are approximately aligned to facilitate assembly.
- ❖ Bolt the vertical legs to the chassis using the provided bolts.
- ❖ After securing all fasteners, cut the packing strip on the chain.
- ❖ Install the motor-side chain and assemble the chain lock.
- ❖ You can adjust the leveling screws to level the machine and slightly adjust its height.
- ❖ Before starting the machine, please ensure that:
 - The chain is aligned with and rests on the chain rails, with the chain links properly engaged with the teeth of all the sprocket wheels.
 - The conveyor tubes are perpendicular to the chains. If not, move the lagging chain slightly forward to align the conveyor rods perpendicular to both chains.

9. POWER CONNECTION

The machine is equipped with a five-core cable, and you should make the connections as follows:

1. Connect the Red wire to Phase 1.
2. Connect the Yellow wire to Phase 2.
3. Connect the Blue wire to Phase 3.
4. Connect the Black wire to Neutral.
5. Connect the Gray/Green wire to Earth.

After making these connections, switch on the MCB (Miniature Circuit Breaker). If all the phase sequences are correct, the phase error LED will not light up. However, if it does light up, it indicates that the phase sequence is incorrect. If the phase sequence is incorrect, you can correct it by interchanging any two phases. Even though the phase sequence is incorrect, the conveyor still functions.

10. CONTROL PANEL

MCB
LED
Blower on/off switch
Heater on/off switch
Temperature controller
Speed variable Knob

11. STARTING THE MACHINE

To initiate the machine's operation, follow these steps:

1. Connect the machine to the appropriate power supply and switch on the MCB (Miniature Circuit Breaker). You can find the MCB located on the right side of the machine.
2. Next, switch ON the heater by using the designated heater switch.
3. To adjust the conveyor speed, use the knob located on the panel board. Turn it as needed to set the desired speed.
4. You can set the required temperature on the temperature controller by simultaneously pressing the "set" and the "up/down" buttons. Adjust the temperature to your desired level.
5. Once the set temperature is reached, you will notice that the red indication LED on the temperature controller turns off. This indicates that the machine has reached the desired temperature and is now ready for use.

By following these steps, you can safely and effectively start and operate the machine for your intended purpose..

12. SHUT DOWN/ SWITCHING OFF THE MACHINE

To shut down the machine and allow it to cool down, follow these steps:

1. Turn the Heater switch to the OFF position. This will deactivate the heating element.
2. Keep the blower and conveyor running. These components will continue to operate to help cool down the machine.
3. Leave the machine in this state for at least 15 minutes to allow it to cool down adequately. This cooling period helps prevent any potential overheating issues.
4. After the 15-minute cooling period, you can safely switch OFF the power supply to the machine. This ensures that the machine is powered down and ready for maintenance or any other necessary tasks.

By following these steps, you can safely and effectively shut down the machine and prepare it for storage or maintenance as needed.

13. SHRINKING OPERATION

Shrink wrapping using special plastic films that shrink when heat is applied is a common packaging process. The temperature required for shrinking each type of film can vary, and this information can typically be obtained from the film manufacturers. Some commonly used shrink films include:

1. Low Density Polyethylene (LDPE)
2. Poly Vinyl Chloride (PVC)
3. Polyolefin (POF)

Here are the steps to perform shrink wrapping:

1. Insert the article into a preformed sleeve or tube of shrinkable film that is of a suitable size for the item being wrapped.
2. Seal the open ends of the film to encase the article securely. Additionally, it's a good practice to make a few holes in the film by pricking it with a pin. This helps prevent air from getting trapped inside the film during the shrinking process. You can also seal and cut off the corners of the film for a neater appearance. If open ends are desired, you can skip the step of sealing the ends.
3. To make the sealing process more efficient and productive, consider using an L-Sealer, which is a specialized machine designed for this purpose.
4. Place the wrapped article on the conveyor at the inlet of the heat tunnel or shrink tunnel. As the article moves through the tunnel, the heat will cause the film to shrink and conform tightly around the product.
5. After the article comes out of the outlet properly shrunk, inspect it to ensure that the shrinkage is sufficient and the packaging looks as desired.
6. If the shrinkage is not sufficient, you can make adjustments by either increasing the temperature setting in the shrink tunnel or by reducing the conveyor speed. This will provide more heat and time for the film to shrink properly.
7. Conversely, if the product is over-shrunk or damaged, you can reduce the temperature setting or increase the conveyor speed to lessen the heat exposure.
8. Achieving the best results and productivity often involves fine-tuning the temperature and conveyor speed to suit the specific film and product being wrapped. Make final adjustments to these settings after the temperature has reasonably stabilized to ensure consistent results.
9. If you are using POF or PVC film and want to avoid conveyor rod marks on the product, adjust the conveyor rod support so that it doesn't interfere with the conveyor rods. This will prevent friction between the film and the rods and allow the rods to rotate smoothly, reducing the risk of marking on the product.

By following these steps and making appropriate adjustments, you can effectively shrink wrap your products using the specified plastic film, achieving the desired appearance and protection for your items.

14. MAINTENANCE



CAUTION : Remove main supply before maintenance



Clean the machine daily after usage.

Remove any plastic leftover on the conveyor rods or sleeves.

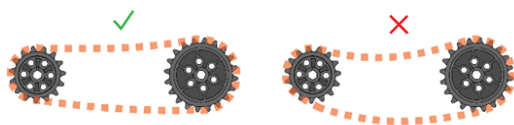


Apply high temperature grease on the chains and bearings.

Also apply grease to other moving parts.

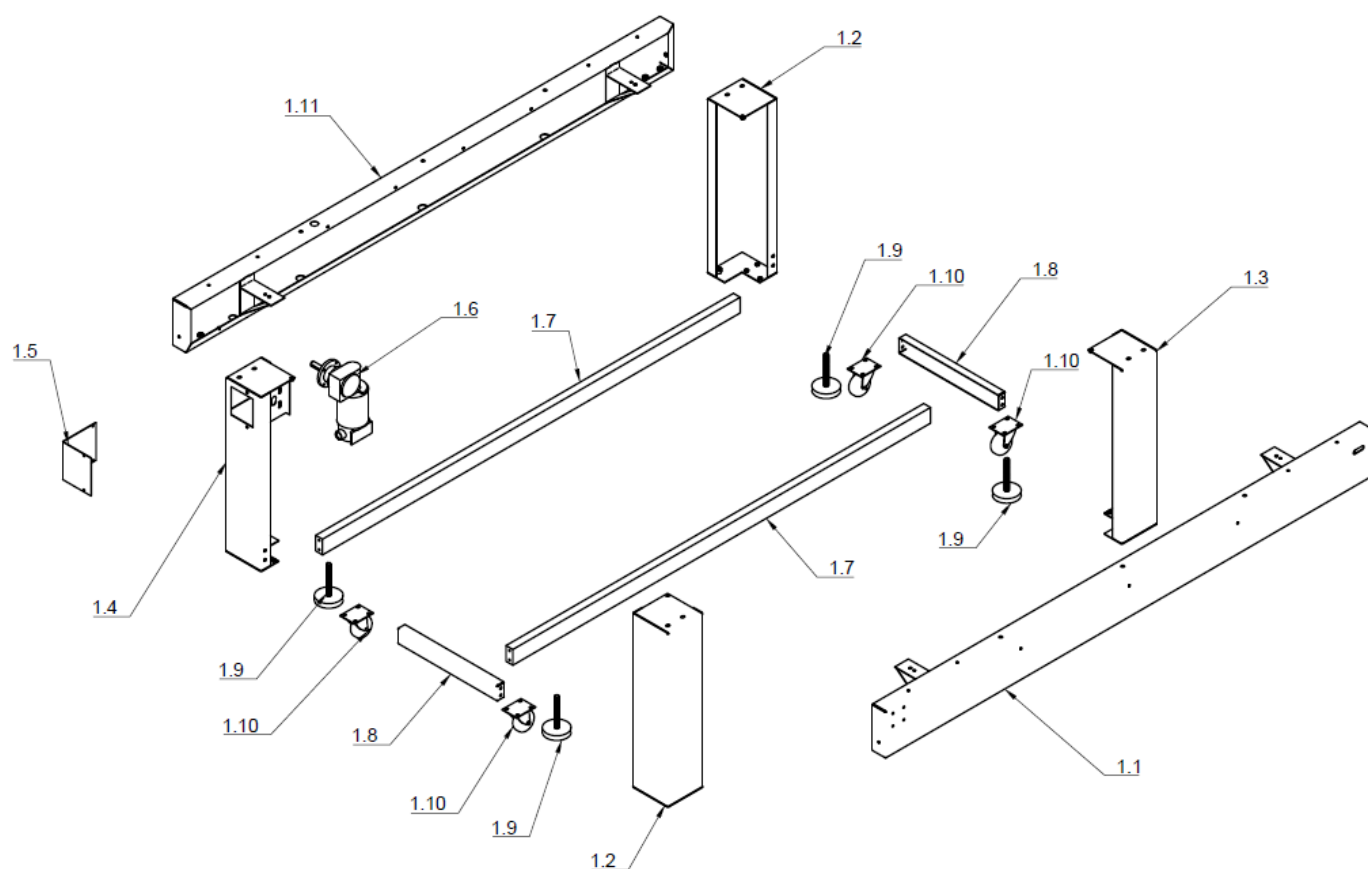


Check the conveyor chain tension. Adjust if required. If they are elongated beyond Adjustable limits remove two links from either side.



Inspect window curtains for damage.

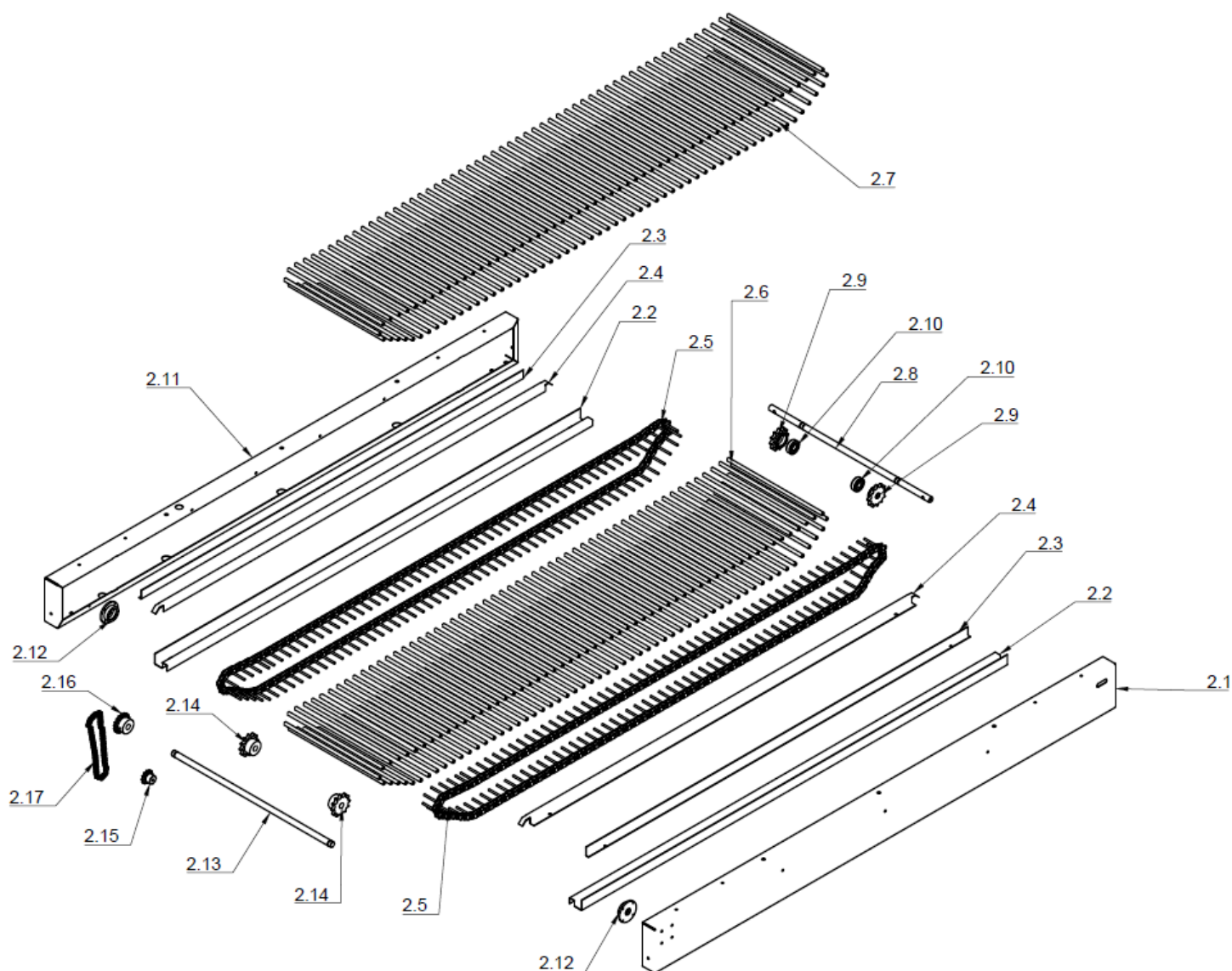
15.LIST OF ITEMS



No	Item	QS4025STV		QS4025STVL	
		ITEM NO	QNTY	ITEM NO	QNTY
1.1	CHASSIS BOX FRONT	1061057	1	1060873	1
1.2	VERTICAL LEG LH	1060888	2	1060888	2
1.3	VERTICAL LEG RH	1060887	1	1060887	1
1.4	VERTICAL LEG MOTOR END	1061043	1	1061043	1
1.5	MOTOR LID	1060884	1	1060884	1
1.6	MOTOR PMDC WITH PLANETARY GEARBOX	1060869	1	1060869	1
1.7	CROSS CHANNEL	1010887	2	1010956	2

1.8	HORIZONTAL CHANNEL BOTTOM	1061052	2	1061052	2
1.9	LEVELLING SCREW M12X100	1038009	4	1038009	4
1.10	CASTOR WHEEL)	1049133	4	1049133	4
1.11	CHASSIS BOX BACK	1061056	1	1060872	1

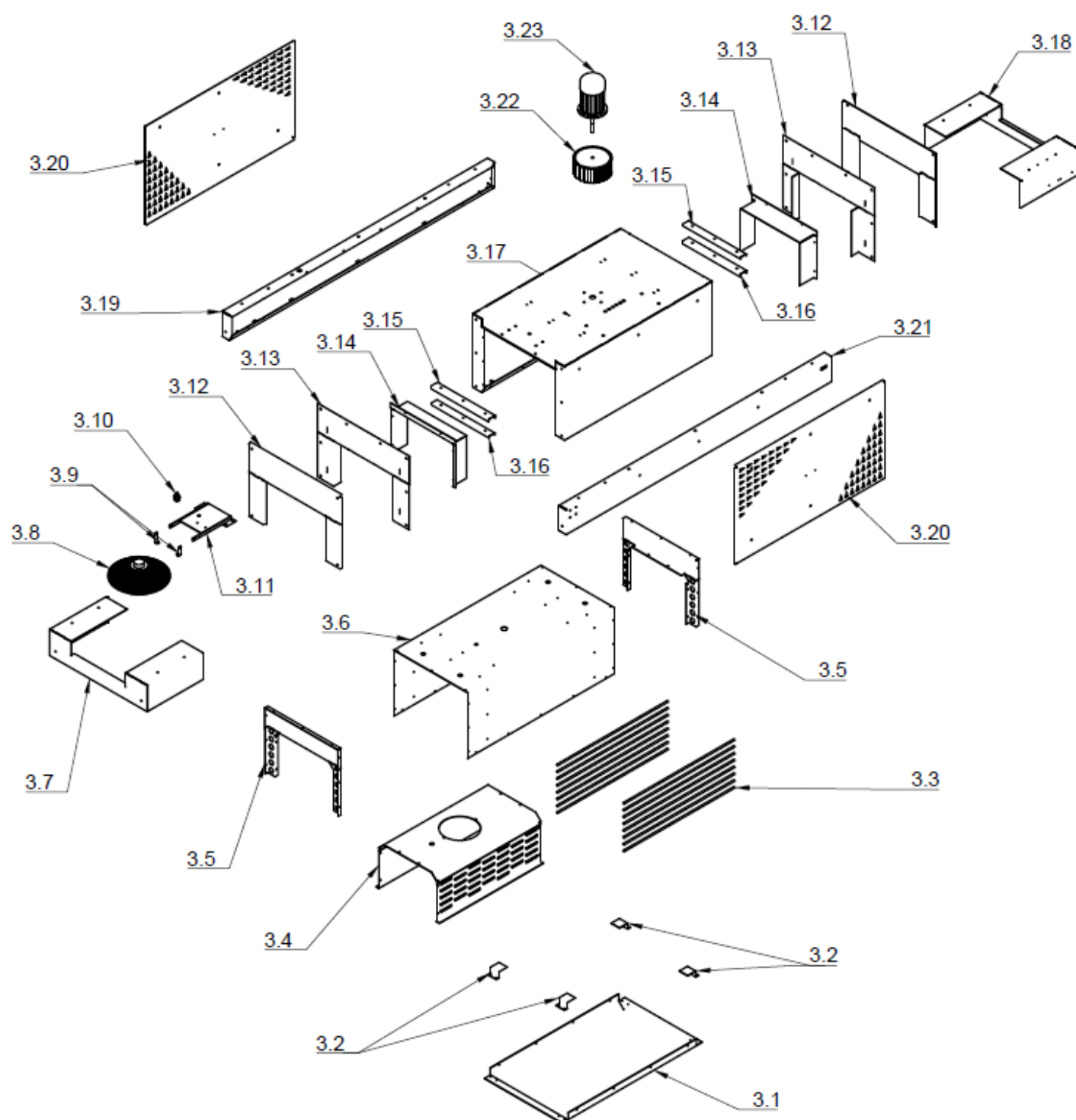
No	Item	QS5040STVL		QS7545STVL	
		ITEM NO	QNTY	ITEM NO	QNTY
1.1	CHASSIS BOX FRONT	1060873	1	1060873	1
1.2	VERTICAL LEG LH	1060888	2	1060888	2
1.3	VERTICAL LEG RH	1060887	1	1060887	1
1.4	VERTICAL LEG MOTOR END	1061043	1	1061043	1
1.5	MOTOR LID	1060884	1	1060884	1
1.6	MOTOR PMDC WITH PLANETARY GEARBOX	1060869	1	1060869	1
1.7	CROSS CHANNEL	1010956	2	1010956	2
1.8	HORIZONTAL CHANNEL BOTTOM	1061041	2	1061066	2
1.9	LEVELLING SCREW M12X100	1038009	4	1038009	4
1.10	CASTOR WHEEL	1049133	4	1049133	4
1.11	CHASSIS BOX BACK	1060872	1	1060872	1



No	Item	QS4025STV		QS4025STVL	
		ITEM NO	QNTY	ITEM NO	QNTY
2.1	CHASSIS BOX FRONT	1061057	1	1060873	1
2.2	CONVEYOR SUPPORT BOTTOM	1060977	2	1060840	2
2.3	CONVEYOR SUPPORT TOP COVER	1060979	2	1060954	2
2.4	CONVEYOR SUPPORT TOP	1060979	2	1060841	2
2.5	CHAIN 5/8 INCH ROLLER TYPE	1060684	5.2	1060684	7.2
2.6	CONVEYOR TUBE	1011365	78	1011365	114
2.7	FIBERGLASS SLEEVE 10MM ID	2000110	29	2000110	41
2.8	IDLER SHAFT	1061114	1	1061114	1

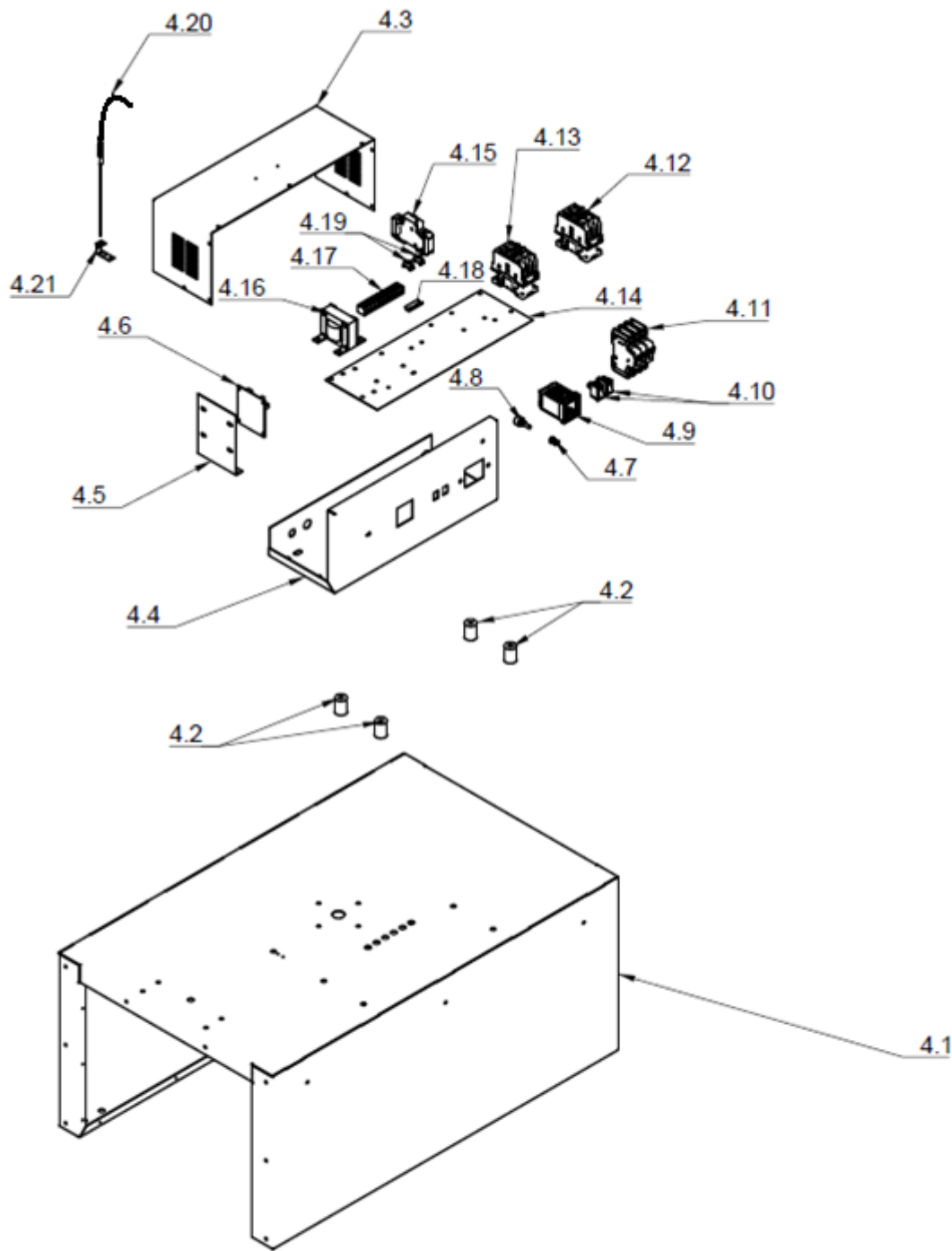
2.9	IDLER SPROCKET IDLER END	1060895	2	1060895	2
2.10	BEARING 6003 2Z SKF	1060946	4	1060946	4
2.11	CHASSIS BOX BACK	1061056	1	1060872	1
2.12	BEARING HOUSING	1061112	2	1061112	2
2.13	DRIVE SHAFT	1061113	1	1061113	1
2.14	IDLER SPROCKET WITH HUB	1060896	2	1060896	2
2.15	MOTOR END SPROCKET	1045504	1	1045504	1
2.16	DRIVE END SPROCKET	1060892	1	1060892	1
2.17	CHAIN 3/8 Inch PITCH R957	1049140	0.47	1049140	0.47

No	Item	QS5040STVL		QS7545STVL	
		ITEM NO	QNTY	ITEM NO	QNTY
2.1	CHASSIS BOX FRONT	1060873	1	1060873	1
2.2	CONVEYOR SUPPORT BOTTOM	1060840	2	1060840	2
2.3	CONVEYOR SUPPORT TOP COVER	1060954	2	1060954	2
2.4	CONVEYOR SUPPORT TOP	1060841	2	1060841	2
2.5	CHAIN 5/8 INCH ROLLER TYPE	1060684	7.2	1060684	7.2
2.6	CONVEYOR TUBE	1011366	114	1061133	114
2.7	FIBERGLASS SLEEVE 10MM ID	2000110	52.46	2000110	81
2.8	IDLER SHAFT	1060894	1	1061115	1
2.9	IDLER SPROCKET IDLER END	1060895	2	1060895	2
2.10	BEARING 6003 2Z SKF	1060946	4	1060946	4
2.11	CHASSIS BOX BACK	1060872	1	1060872	1
2.12	BEARING HOUSING	1061112	2	1061112	2
2.13	DRIVE SHAFT	1060893	1	1061116	1
2.14	IDLER SPROCKET WITH HUB	1060896	2	1060896	2
2.15	MOTOR END SPROCKET	1045504	1	1045504	1
2.16	DRIVE END SPROCKET	1060892	1	1060892	1
2.17	CHAIN 3/8 Inch PITCH R957	1049140	0.47	1049140	0.47



No	Item	QS4025STV		QS4025STVL	
		ITEM NO	QNTY	ITEM NO	QNTY
3.1	BOTTOM SHIELD	1061054	1	1061054	1
3.2	HEAT PROTECTION CLAMP	1060852	4	1060852	4
3.3	HEATER -750W, / 240V	1027030	10	1027030	12
3.4	HEATER SHIELD	1060968	1	1060968	1
3.5	HEATER SUPPORT	1060969	2	1060969	2
3.6	CHAMBER SHIELD	1060974	1	1060974	1
3.7	END PLATE LEFT	1061049	1	1061058	1
3.8	COOLING FAN	-	-	1022008	1
3.9	COOLING FAN MNTG CLAMP	-	-	1010777	2
3.10	COOLING FAN BRACKET	-	-	1010232	1
3.11	TOGGLE SWITCH	-	-	1023326	1
3.12	END COVER GUARD	1061046	2	1061046	2
3.13	END COVER	1061048	2	1061048	2
3.14	END COVER SHIELD	1060963	2	1060963	2
3.15	CURTAIN STRIP TOP	1061045	2	1061045	2
3.16	CURTAIN STRIP BOTTOM	1061044	2	1061044	2
3.17	CHAMBER	1061055	1	1061055	1
3.18	END PLATE RIGHT	1061050	1	1061059	1
3.19	CHASSIS BOX BACK	1061056	1	1060872	1
3.20	FRONT GUARD	1061051	2	1061051	2
3.21	CHASSIS BOX FRONT	1061057	1	1060873	1
3.22	BLOWER	1003005	1	1003005	1
3.23	MOTOR -FLANGE MOUNT	1030042	1	1030042	1

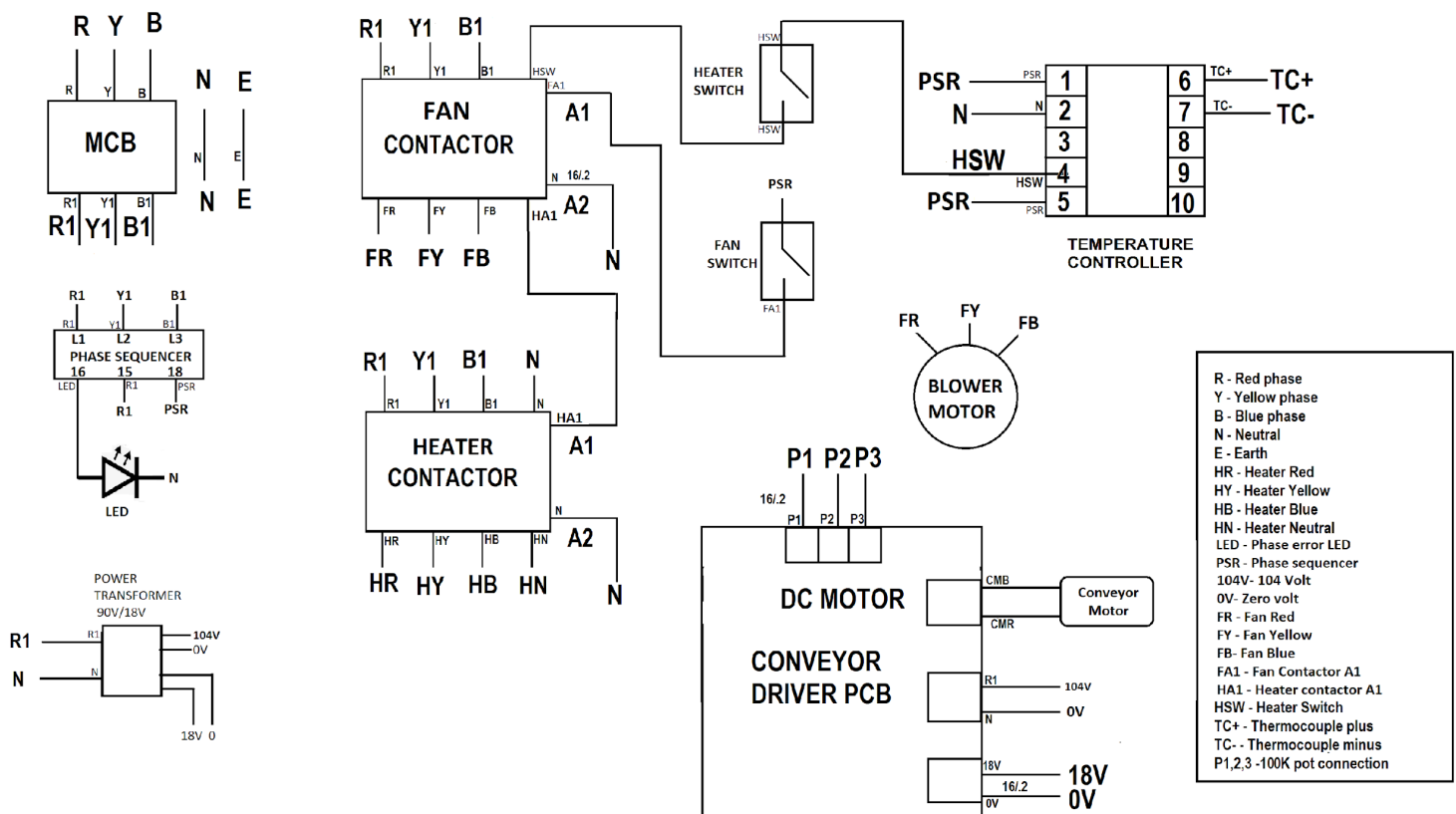
No	Item	QS5040STVL		QS7545STVL	
		ITEM NO	QNTY	ITEM NO	QNTY
3.1	BOTTOM SHIELD	1060901	1	1061068	1
3.2	HEAT PROTECTION CLAMP	1060852	4	1060852	4
3.3	HEATER -750W, / 240V	1027030	16	1027030	22
3.4	HEATER SHIELD	1060853	1	1060989	1
3.5	HEATER SUPPORT	1060854	2	1060990	2
3.6	CHAMBER SHIELD	1060864	1	1060995	1
3.7	END PLATE LEFT	1060882	1	1061063	1
3.8	COOLING FAN	1022008	1	1022008	1
3.9	COOLING FAN MNTG CLAMP	1010777	2	1010777	2
3.10	COOLING FAN BRACKET	1010232	1	1010232	1
3.11	TOGGLE SWITCH	1023326	1	1023326	1
3.12	END COVER GUARD	1060879	2	1061060	2
3.13	END COVER	1060878	2	1061062	2
3.14	END COVER SHIELD	1060846	2	1060985	2
3.15	CURTAIN STRIP TOP	1060876	2	1061071	2
3.16	CURTAIN STRIP BOTTOM	1060875	2	1061070	2
3.17	CHAMBER	1060891	1	1061069	1
3.18	END PLATE RIGHT	1060883	1	1061064	1
3.19	CHASSIS BOX BACK	1060872	1	1060872	1
3.20	FRONT GUARD	1060881	2	1061065	2
3.21	CHASSIS BOX FRONT	1060873	1	1060873	1
3.22	BLOWER	1003005	1	1003005	1
3.23	MOTOR -FLANGE MOUNT	1030042	1	1030042	1



No	Item	QS4025STV		QS4025STVL	
		ITEM NO	QNTY	ITEM NO	QNTY
4.1	CHAMBER	1061055	1	1061055	1
4.2	CONTROL CABIN MNTG ROD	1060871	4	1060871	4
4.3	CONTROL CABIN LID	1061040	1	1061040	1
4.4	CONTROL CABIN	1060874	1	1060874	1
4.5	BOARD MNTG CLAMP	1060889	1	1060889	1
4.6	CONVEYOR DRIVER PCBA	1060950	1	1060950	1
4.7	KNOB FOR POTENTIOMETER	1060915	1	1060915	1
4.8	SPEED CONTROL POTENTIOMETER	1060917	1	1060917	1
4.9	DIGITAL TEMPERATURE CONTROLLER	1023034	1	1023034	1
4.10	ROCKER SWITCH	1023200	2	1023200	2
4.11	MCB	1022019	1	1022019	1
4.12	CONTACTOR-HEATER	1020001	1	1020001	1
4.13	CONTACTOR-FAN	1020008	1	1020008	1
4.14	BRAIN PLATE	1061039	1	1061039	1
4.15	PHASE SEQUENCE RELAY	1060897	1	1060897	1
4.16	POWER TRANSFORMER 230V/104V/18V	1060926	1	1060926	1
4.17	TERMINAL BLOCK-6A/12 WAY	1022043	1.2	1022043	1.2
4.18	MCB CHANNEL (MTR)	1049646	0.15	1049646	0.15
4.19	SIDE LOCK CLAMP	1001238	2	1001238	2
4.20	TEMPERATURE SENSING PROBE-J TYPE	1023213	1	1023213	1
4.21	CLAMP FOR THERMOCOUPLE	1060886	1	1060886	1

No	Item	QS5040STVL		QS7545STVL	
		ITEM NO	QNTY	ITEM NO	QNTY
4.1	CHAMBER	1060891	1	1061069	1
4.2	CONTROL CABIN MNTG ROD	1060871	4	1060871	4
4.3	CONTROL CABIN LID	1061040	1	1061040	1
4.4	CONTROL CABIN	1060874	1	1060874	1
4.5	BOARD MNTG CLAMP	1060889	1	1060889	1
4.6	CONVEYOR DRIVER PCBA	1060950	1	1060950	1
4.7	KNOB FOR POTENTIOMETER	1060915	1	1060915	1
4.8	SPEED CONTROL POTENTIOMETER	1060917	1	1060917	1
4.9	DIGITAL TEMPERATURE CONTROLLER	1023034	1	1023034	1
4.10	ROCKER SWITCH	1023200	2	1023200	2
4.11	MCB	1060829	1	1022026	1
4.12	CONTACTOR-HEATER	1020001	1	1020004	1
4.13	CONTACTOR-FAN	1020008	1	1020008	1
4.14	BRAIN PLATE	1061039	1	1061039	1
4.15	PHASE SEQUENCE RELAY	1060897	1	1060897	1
4.16	POWER TRANSFORMER 230V/104V/18V	1060926	1	1060926	1
4.17	TERMINAL BLOCK-6A/12 WAY	1022043	1.2	1022043	1.2
4.18	MCB CHANNEL (MTR)	1049646	0.15	1049646	0.15
4.19	SIDE LOCK CLAMP	1001238	2	1001238	2
4.20	TEMPERATURE SENSING PROBE-J TYPE	1023213	1	1023213	1
4.21	CLAMP FOR THERMOCOUPLE	1060886	1	1060886	1

16.ELECTRICAL SCHEMATIC



17.TROUBLESHOOTING CHART

No.	Complaint	Reasons	Remedy
1	Machine does not start	1.No AC supply.	1.Restore AC supply.
		2.MCB tripped.	2.Check the wiring for any short circuit. If satisfactory, reset the MCB.
		3.No output from Transformer(18V)	3.Check and replace if defective.
2	Conveyor is not moving.	1.Conveyor speed set to 0.	1.Increase the conveyor speed.
		2.Conveyor motor stalling.	2.Reduce load on the conveyor. Install the machine with a slope towards the direction of the conveyor movements to increase the load carrying capacity of the conveyor. Use leveling screws to attain this.
		3.Defective conveyor motor.	3.Rectify/replace the conveyor motor.

		4.Wear & tear of carbon brush.	4.Clean & reinsert it.
		5.Conveyor chain disengaged from the sprockets.	5.Engage the conveyor chain with the sprocket.
		6. Conveyor chain breakage.	6.Replace both chains together to avoid the mismatching of chains.
		7.Defective conveyor drive sprocket.	7.Replace the conveyor drive sprockets.
		8.Defective conveyor drive board.	8.Replace the board for conveyor drive.
		9. Blown out of FUSE..	9.Replace the FUSE.
3	Conveyor chain slips from the guides.	1. Lower conveyor tension.	1.Increase the tension by adjusting the conveyor tension adjusters.
		2.Misalignment of sprockets and chain rails.	2.Align the sprockets and chain rails.
4	Air blower is not working	1.Fan switch is off.	1.Switch on the fan.
		2.Phase sequence RYB is not in sequence.	2.Interchange any of the two phases.
		3. Defective blower motor.	3.Replace the motor.
		4. No supply at motor end.	4. Check supply voltages at the motor.
		5. Defective contactor.	5. Replace the defective.
5	Blower motor works , but the air turbulence fan does not rotate freely	1.Shaft fitting Allen screw loose.	(a) Check the fan shaft assembly.
			(b) Ensure free rotation of the shaft and a little axial play.
			(c) Refit the Fan Assembly Mounting Plate.
6	Insufficient shrinking	1.Heater switch is off.	1.Switch on the heater.
		2.Low temperature setting.	2.Increase the temperature setting.
		3.Temperature is not building up.	3.Refer to complaint no. 7
7	Temperature is not building up.	1.Loose connection of heaters.	1.Make proper connections.

		2.Heater failure.	2.Replace the defective heater.
		3.Low temperature setting.	3.Increase temperature setting.
		4.Defective contactor for heaters for heaters.	4. replace the contactor.
		5.Defective thermocouple.	5.Replace it.
8	Excessive shrinking	1.High temperature setting.	1.Reduce the temperature setting.
		2.Low conveyor speed.	2.Increase the conveyor speed.
		3.Defective Temperature	3.Replace the defective part.
		Sensor.	
		4.Defective Heater Contactor due to contact welding.	4.Replace the contactor for the heater.
9	Shrinking is not uniform	1.Air turbulence fan is not working or rotating in the wrong direction.	1.Refer complaint troubleshooting Case 4.
		2.Heaters are not working.	2.Identify the defective heater and replace it.
10	Abnormal sound and vibration	1.Air turbulence fan loose.	1.Tighten the nut with which the Air Turbulence Fan is attached to the blower drive shaft.

18.SERVICE LOG

[illegible]