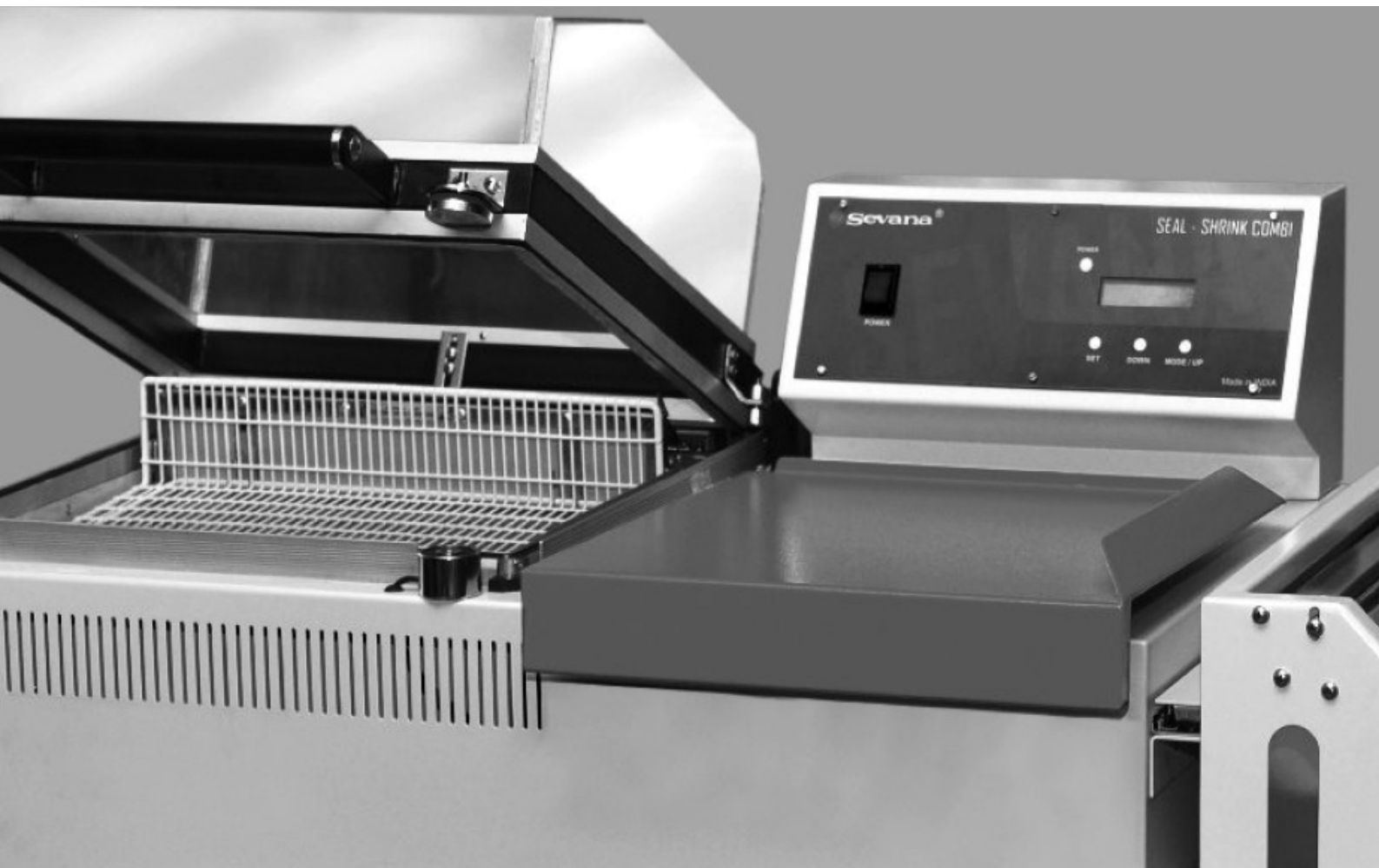




AN ISO 9001:2008 CERTIFIED COMPANY

USER MANUAL

Seal Shrink Combi

QS4030SL



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.

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.

- ❖ Do not start the machine before reading these instructions full and making the preliminary settings.
- ❖ Do not plug the machine to any two pin socket or ungrounded three pin socket.
- ❖ If the plug pin has to be changed, follow the color code

Phase	-	Red
Neutral	-	Black
Ground	-	Green

4. TECHNICAL SPECIFICATIONS

Model	QS 4030 SL	QS 5540 SL
Machine size (L x W x H)	1215 x 590 x 1020	1380 x 690 x 1065
Maximum packing size (L x W x H)	350 x 250 x 150	450 x 300 x 200
Sealing dimensions	400 x 300	550 x 400
Maximum production	500-800p/hour	500-800p/hour
Max. real width	300	400
Max. pack height	150	200
Max. pack weight	10	10
Temperature indication	Celsius	Celsius
Power supply	230V/1 ϕ /50 HZ	230V/1 ϕ /50 HZ
Power consumption	3800W	4000W
Film used	POF, PVC, LDPE	POF, PVC, LDPE

5. UNPACKING

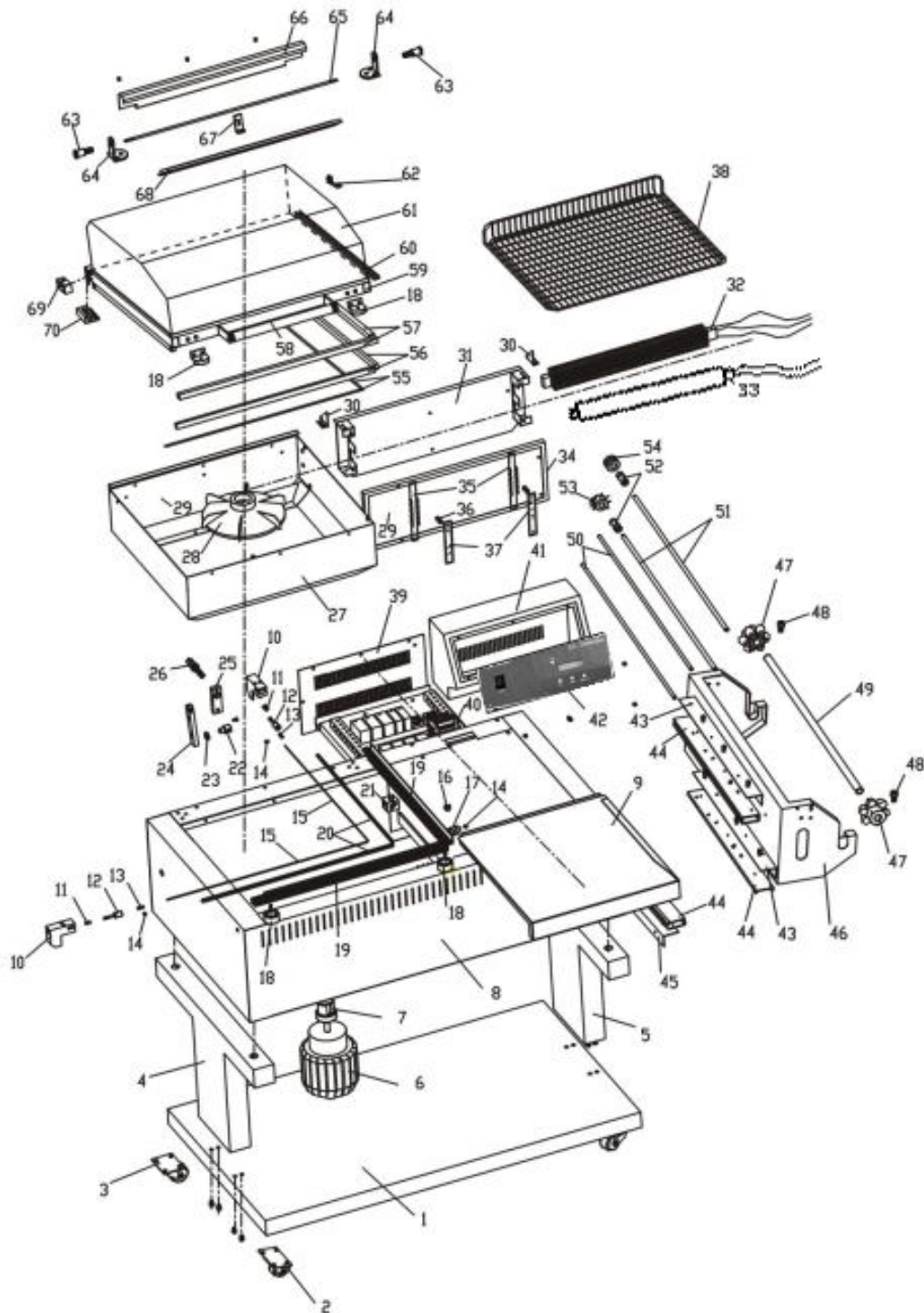
Note: Please verify the items with the packing slip.

- ❖ The machine is shipped well packed in wooden box
- ❖ Place the packet with the “TOP” marked to the top
- ❖ Remove the top cover and the four side panels
- ❖ The machine comes with the pedestal disassembled.
- ❖ Remove the stretch wrapping from the pedestal members and assemble them together.
- ❖ Mount the machine on to the pedestal.
- ❖ The pedestal is provided with castor wheels. Move the machine to its location and arrest the castor wheels to avoid further movements.
- ❖ Inspect for any transit damages. If there are any, notify your dealer/ Transporter/ Insurance company or the Company immediately.

6. INSTALLATION

- ❖ Assemble the castor wheels to the base plate of the pedestal. The lockable ones are to be in the front.
- ❖ Assemble the left and right pillars to the pedestal
- ❖ Mount the machine to the pedestal.
- ❖ Confirm that there is no leakage of electricity from the live parts and the external body of the machine either with a multi meter or continuity tester.
- ❖ Measure the insulation resistance of the wiring to the body. It shall be better than one mega ohm at 500V DC.
- ❖ If OK you can connect the machine to the electric mains.

7. LIST OF PARTS



No	Name of component	Item code
1	Pedestal base plate	1060145
2	Castor wheel with lock	1049134
3	Castor wheel without lock	1049133
4	Pedestal pillar left	1060146
5	Pedestal pillar right	1060147
6	Blower fan motor	1060148
7	Blower fan shaft cover	1060149
8	Chassis	1060150
9	Film separator	1060151
10	Element fixing block support	1060152
11	Element tension spring	1060108
12	Element fixing block	1049323
13	Element fixing block	-
14	Element fixing block	-
15	Seal-cutting blade	1028034
16	Corner clamp – blade	1049326
17	Corner pad- blade clamp	1049325
18	Hold down magnets	1022013
19	Sindanyo blade base front/ Sindanyo blade base RH	1050111/ 1050112
20	Aluminum slotted channel for sindanyo	1050251
21	Micro switch, push button type	1023112
22	Torsion bar swing angle adjusting nut	-
23	Torsion bar swing angle adjusting retaining ring	-
24	Torsion bar adjusting pendulum	-

25	Torsion bar swing angle adjusting base	-
26	Torsion bar swing angle adjusting bar	-
27	Shrink chamber	1060153
28	Blower	1003009
29	Insulated barrier	-
30	Support of the left and right corners of the upper sealing frame	-
31	Heater mounting bracket	1060154
32	Finned cartridge heaters	1027001
33	Temperature sensing probe	1023212
34	Thermal insulation	-
35	Net support rear	1060155
36	Net support screw front	1060156
37	Fixed board of net	1060157
38	Net for shrink chamber	1060158
39	Rear cover of control box	1060159
40	Power distribution board (db)	1060160
41	Control cabin	1060161
42	Control panel- acrylic, sticker	1032002, 1050092
43	Slide rail – film support	1060162
44	Slide rail base	1060163
45	Slide rail base support angle	1060164
46	Film support	1060165
47	Film reel arrester	1060144
48	Film reel arrester fixing screws	1060166
49	Film reel shaft	1060167

50	Shaft for film stretching	1060168
51	Shaft for film perforator	1060169
52	Safety cover for perforator	1060170
53	Pin wheel perforator	1060171
54	Slot wheel perforator	1060172
55	Teflon tape	1050127
56	Gasket	1026001
57	Pad housing	1060173
58	Handle	1060174
59	Upper sealing frame	-
60	Hood frame	-
61	Acrylic chamber top	1049028
62	Micro switch actuator	1060175
63	Hood mounting journals	-
64	Support plate torsion bar	1022014
65	Torsion bar	-
66	Torsion bar cover	-
67	Actuator for heater box cover	-
68	Heater box cover	-
69	Torsion bar fixing bracket - hood	-
70	Hood close aligner	-
71	Rocker switch	1023199
72	LCD display	1033028
73	Tact switches(set,down,mode/up)	1023210
74	Contactors for blower, sealing blade, hold on magnets	-
75	Micro controller board	1033003

76	Fuse cluster	-
77	Power on/off switch	1023199
78	LED	1023098

8. STARTING THE MACHINE

To start the machine connects the machine to a single phase power outlet. Turn on the power by pressing the power switch on the control panel. The power indicating LED will light up and the LCD display shows as sequentially.

- ❖ Mode 1 : PVC
- ❖ Mode 2 : POF
- ❖ Mode 3 : LDPE
- ❖ Mode 4 : Any other shrinkable film

STARTING THE MACHINE:

When power is switched on, message “Booting.....” can see. Wait for a few seconds till machine initialize. When the machine is ready, a message “Sevana LS COMBI” is displayed, after displayed as “Sevana Temp:XXX”.

BOOTING.....

SEVANA
LS COMBI

SEVANA
TEMP: 26

Four preset programs/modes are stored in the processor. Modes can be selected by pressing UP/MODE button.

To edit a mode (E.g. edit MODE 1)

Select the mode, press “SET” button, then edit setting will be displayed.

EDIT SETTINGS
TEMP: 26

Set the parameter to desired value by pressing UP or DOWN button. For example, to set temperature 110, press the “UP” button till reaches 110.

EDIT SETTINGS
TEMP: 110

Now press the “SET” button to save the “TEMPERATURE”. If “SET” button is pressed again, “SEAL TIME” is displayed. Press the “UP/MODE” or “DOWN” button to set the required value.

EDIT SETTINGS SEALTIME: 1.4

Now press the “SET” button to save the “SEAL TIME”. If again “SET” button is pressed, “COOL TIME” is displayed. Press the “UP/MODE” or “DOWN” button to set the required value.

EDIT SETTINGS COOL TIME: 2

Now press the “SET” button to save the “COOL TIME”. When the “SET” button is pressed once again “SHRINK TIME” is displayed. Press the “UP/MODE” or “DOWN” button to set the required value.

EDIT SETTINGS SHRINK TIME: 2

Now press the “SET” button to save the “SHRINK TIME”. When the “SET” button is pressed again “MODE: X” is displayed.

MODE: 1 TEMP: 67

Sevana's SEAL-SHRINK Combi machines have 4 preset programs/modes. Each Mode/preset has 4 parameters that can be varied.

- ❖ Temperature
- ❖ Sealing Time
- ❖ Cooling Time
- ❖ Shrinking Time

PRESET PARAMETERS:

Parameter	Min value	Max value
Temperature	40°C	300°C
Sealing time	0.1 sec	3 sec
Cooling time	0.1 sec	6 sec
Shrinking time	0.1 sec	6 sec

* Machine will not work in EDIT SETTINGS state

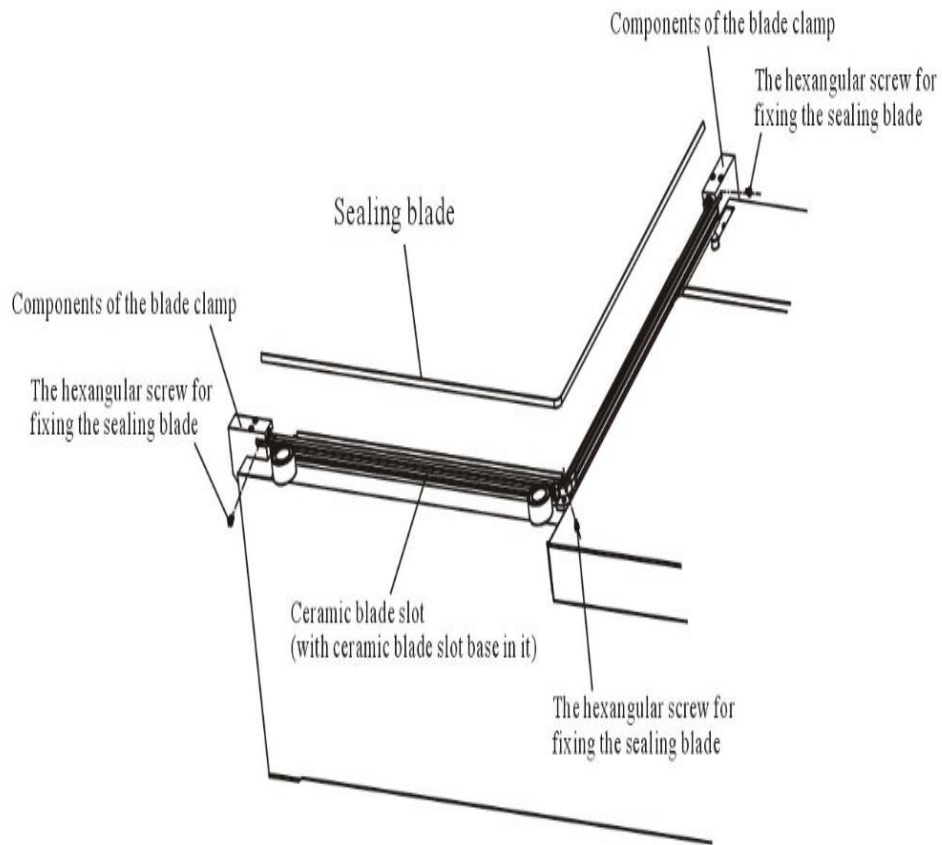
9. OPERATION

- ❖ Having made the initial settings the machine is ready for operation.
- ❖ Select the Mode depending upon the film you are using. The film must have been already loaded in film support and should have been kept ready after the initial sealing.
- ❖ Let us assume that the film is POF which is the most frequently used film with the COMBI machine. So let us load the Mode 2.
- ❖ Insert the object to be packed on to the work table.
- ❖ Push the object with the film to the Shrink chamber.
- ❖ Close the hood. The hood will be held closed by the magnet. The seal cutting will take place initially; and then the shrinking.
- ❖ Take out the object and inspect.
- ❖ If required readjust the settings.
- ❖ Improve settings till you get perfect sealing and shrinking.
- ❖ If machine shows any error messages then restart the machine.

10. MAINTENANCE

1. Daily Maintenance
 - a. Blow off dust and debris of plastic film by dry compressed air.
 - b. Film residues sticking on the blade may be cleaned off to avoid melting and producing foul smell.
2. Monthly Maintenance
 - a. Smear little oil to the hinge of the hood.
 - b. Smear little oil to the ends perforator shaft, film stretch shaft.
3. Annual Maintenance
 - a. Remove dry grease of the slide rails and re grease the slide rails
 - b. Lubricate all moving parts

REPLACEMENT OF SEALING BLADE:



The illustration for replacing the sealing blade

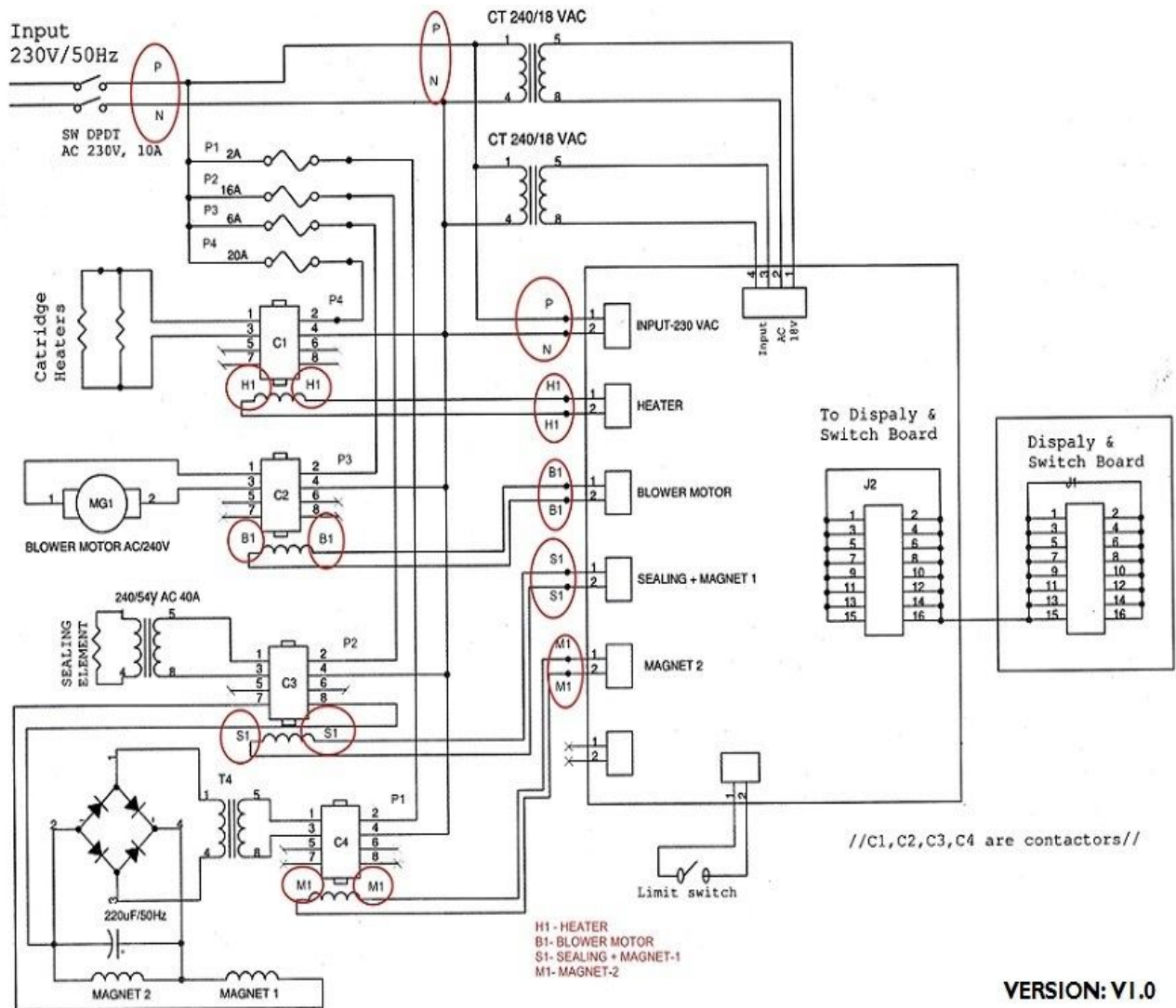
The sealing blade normally does not fail. In case of replacement, it may do as follows.

- a. Loosen the screws on the blade clamps and the corner clamp to take out the old blade
- b. Insert one end of the new blade into the slot of end blade clamp and tighten the screw well.
- c. Insert the blade without kinks through the syndanium slot to the corner clamp and tighten the screw in the corner clamp.
- d. Insert the loose end of the blade in the slot of the other end blade clamp and tighten the screw.

DO'S AND DONT'S:-

1. Do not use any corrosive chemicals to clean the machine. Blowing the dust by dry compressed air will be sufficient. In case of cleaning external parts, use cloth soaked with mild detergent in water. Immediately wipe dry with a dry cloth. Do not allow the water to go inside where the electrical components are kept.
2. Do not keep heavy articles on top of the hood.

11. ELECTRICAL SCHEMATIC



12. TROUBLE SHOOTING

No	Problem	Cause	Remedy
1	The machine doesn't seal	Low sealing time set.	Increase sealing time
		Sealing blade is damaged.	Replace the sealing blade.
		Small gap between trip screw and blade clamp.	Increase the gap.
		Sealing blade transformer fuse blown.	Replace the fuse
		Defective transformer.	Replace it.
		Defective microcontroller board	Replace it.
2	Perfect Sealing, but Imperfect shrinking	Shrink temperature setting is low.	Increase the shrinking temperature.
		Temperature is not building up.	Check the cartridge heaters & replace it if defective.
		Defective temperature sensor.	Replace the temperature sensor.
		Defective microcontroller Board.	Replace the microcontroller Board.
3	Perfect sealing, but over shrinking	Temperature sensor wires shorted.	Replace the temperature sensor.
		Defective Microcontroller board.	Replace microcontroller Board
		Defective heater contactor.	Replace it.
4	Blower motor does not work	Blower motor fuse blown.	Replace the fuse.
		Defective Microcontroller board.	Replace microcontroller Board

13. SERVICE LOG

[illegible]