

AN ISO 9001:2015 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 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.



This is a warning symbol indicating a hot surface.

1. The machine has to be grounded properly before using.
2. Never try to shrink wrap explosive or inflammable material.
3. Do not insert your hand in the chamber when the machine is in operation.
4. Do not allow any liquid to go into the machine.

4. PACKING SLIP

ITEM	QUANTITY
Machine	1
User manual	1
Warranty card	1
Heating element	1 mtr
Teflon tape 60 mm	1 mtr
Screwdriver multi type	1
Allen key(5mm)	1
Allen key(4mm)	1

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.
- ❖ Place the packet with the “TOP” marked to the top
- ❖ Cut the packing straps.
- ❖ Remove the top panel of the wooden box and the four side panels
- ❖ Remove all packing materials.

6. TECHNICAL SPECIFICATIONS

Model	QS 4030SL
Sealing Length (mm)	400X300
Voltage (V/Hz)	240/50
Power (KW)	3.8
Machine length (mm)	1250
Machine width (mm)	1100
Machine height (mm)	1250

7. INSTALLATION

1. Fix the acrylic dome and the film holding tray.
2. Confirm that there is no leakage of electricity from the live parts and the external body of the machine either with a multimeter or continuity tester.
3. Measure the insulation resistance of the wiring to the body. It shall be better than one mega ohm at 500V DC.
4. If OK you can connect the machine to the electric mains.

8. CONTROL PANEL



MCB
Temperature Controller
Sealing time
Cooling time
Shrinking time

9. STARTING THE MACHINE

To start the machine, connect the machine to the appropriate power supply and switch on the MCB. The Sealing time, Cooling time and Shrinking time is adjusted using the knob present on the panel board. The temperature required can be set on the temperature controller by pressing the set and up/down button simultaneously. When the required temperature is reached, the red indication LED on the temperature controller turns off. Now the machine is ready for use.

Temperature Controller: The temperature controller is used to set the temperature inside the heating chamber. The desired temperature can be set on the temperature controller by pressing the "Set" button and adjusting with the up/down buttons simultaneously. When the required temperature is reached, the red indicator LED on the temperature controller turns off.

Sealing Time: The sealing time sets how long the heating element will remain active. The duration should depend on the thickness of the film. The sealing time can be adjusted using the knob on the sealing time module.

Cooling Time: The cooling time sets how long the film is allowed to cool. This helps to improve sealing strength. The cooling time can be adjusted using the knob on the cooling time module.

Shrinking Time: The shrinking time sets how long the shrinking process will take. This time depends entirely on the size of the product and the type of film. The shrinking time can be adjusted using the knob on the shrinking time module.

Parameter	Min value	Max value
Temperature	30°C	250°C
Sealing time	0.1 sec	3 sec
Cooling time	0.1 sec	10 sec
Shrinking time	0.1 sec	10 sec

10. SHRINKING OPERATION

- a. Special plastic films which shrink on application of heat are used for shrink wrapping. The temperature required for shrinking each variety of film varies. This information can be obtained from the film manufacturer. Shrink films commonly available are,
 - ☐ Poly Olefin (POF)
- b. Insert the article in a preformed sleeve or tube of shrinkable film of suitable size. Seal the open ends
- c. The article will come out of the chamber properly shrunk. Inspect the article.
- d. If shrinking is not sufficient, increase the temperature setting or shrink time. If over shrunk, reduce the temperature setting or shrink time. By adjusting the temperature and shrink time it is possible to get the best result and productivity. Make final adjustments of temperature after the temperature has reasonably stabilized.

2	Perfect Sealing, but Imperfect shrinking	Shrink temperature setting is low.	Increase the shrinking temperature.
		Temperature is not building up.	Check the heaters & replace it if defective.
		Defective temperature sensor.	Replace the temperature sensor.
		Defective temperature controller.	Replace the defect.
3	Perfect sealing, but over shrinking	Shrink temperature setting is high.	decrease the shrinking temperature.
		Temperature sensor damage.	Replace the temperature sensor.
		Defective temperature controller.	Replace the defect.
		Defective heater contactor.	Replace it.
4	Blower motor does not work	Blower motor damage.	Replace the defect.
5	Magnetic hold down not working	Defective electromagnet	Replace the defective
		Defective transformer	Replace the defective

13. SERVICE LOG

[illegible]