



TABLE TOP TRAY SEALER
Indokor IX



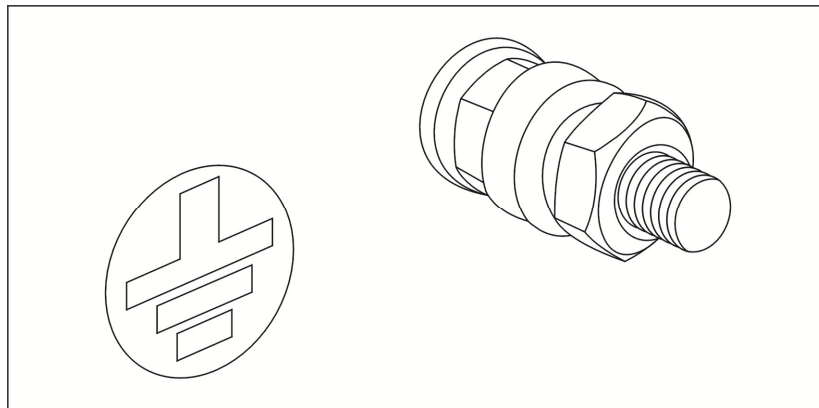
Thanks for buying model IX-1 tray sealing machine independently produced and developed by our company. Prior to use, please read this operation manual to clearly understand characteristics of this product and strictly comply with security notice related to equipments described in the instruction. Correct operation could reduce personal injury caused by use of this machine to minimum as well as keep this machine work in optimal state and prolong lifespan.

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1. Function and Safety Use of Machine

- 1.1. This machine applies 220V-50HZ single-phase power source. The consume power is 1.5KW. It is strictly forbidden to use temporary line or jointly use the same power supply with other machines. Power supply should be designed and supplied by qualified electrical technician. **Notice:** (Electrical damage caused by improper connection of power supply is not listed into repair guarantee.)
- 1.2. Safe disposal of leakage: Leakage circuit breaker should be installed on power cord for this machine. When damages happen on electrical parts in any device, it may lead to personal injury accident for electrical leakage. To avoid this, security measures to be taken prior to this machine is of great necessity. When electrical power is provided in this machine, operator must pay attention that earth terminal is solidly grounded. Also, earth terminal in shell of this machine should be connected with grounding wire with cross section no less than 4 m2, linked to ground pole shared by the workshop.



Earth Wire Connection Diagram

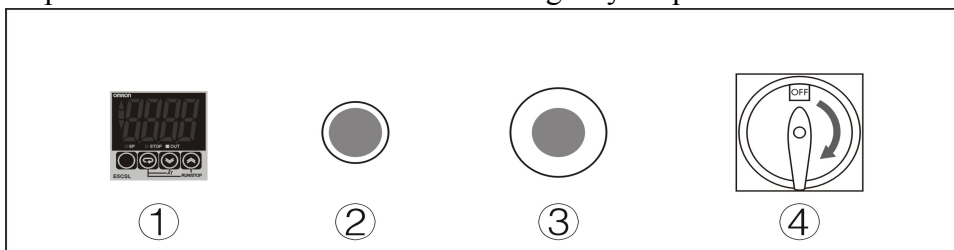
2. Machine Arrival

- 2.1. Check completeness of machine and spare parts listed in packaging list as well as accessories and damages of machine during transportation. (Any incompleteness or damages, please contact with carrier or consigner.)
- 2.2 Check machine complies with requirements in your order.
- 2.3 Clearly read this manual for installation, debugging and use.

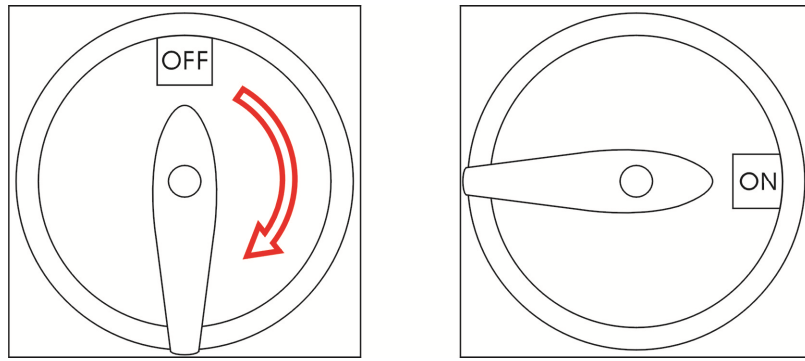
3. Start the Machine and Debugging

3.1 The components name description on control panel (check below picture).





1. Temperature Controller 2. Start 3. Emergency Stop 4. Power Switch



- 3.2 Connecting the power supply, turn on the machine power switch---twist the knob clockwise from OFF to ON (check below picture).



Power Switch

3.3 Temperature adjustment: press  button, “SP” light on, the display showing the setting temperature. Please increase or decrease the temperature by pressing the button  and . Pressing  again, “SP” light off, the display showing the actual temperature (check below picture).



Note: Please do not put your hand into the place between upper and down mould when the machine is power on, to avoid any hurts. The left temperature is used to control left heating mould, the right temperature for right heating mould, if has just one heating mould, controlled by left temperature controller. Too high temperature will damage the heating system. Normally tray sealing temperature is from 120 degree to 140 degree which subject to the film thickness.

4. Working Procedure

4.1 When the machine is powered on, it is in ready state. Operator fill temperature parameter on the temperature controller, then puts box to be packed on working platform (down mould). Press green button to start the machine when temperature reach the default settings. Push forward the working platform, the upper mould begin to go down to meet with the down mould to finish sealing and cutting. Then upper mould go up and separate from the down mould,

recycling waste film motor begin to roll the waste film onto roller. At last pull the working platform out and take out the packed product. (Attention: the second time operation no need to press the start button again, only for the first time need to do that).

5. Wearing Parts Replacement

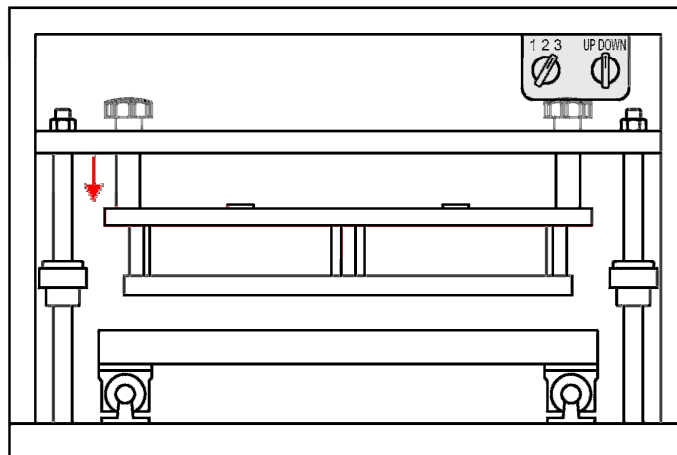
5.1 Heating elements replacement

5.1.1 Turn off the power, stop the working about 15-20 minutes let the mould cool down, then remove the film roller.

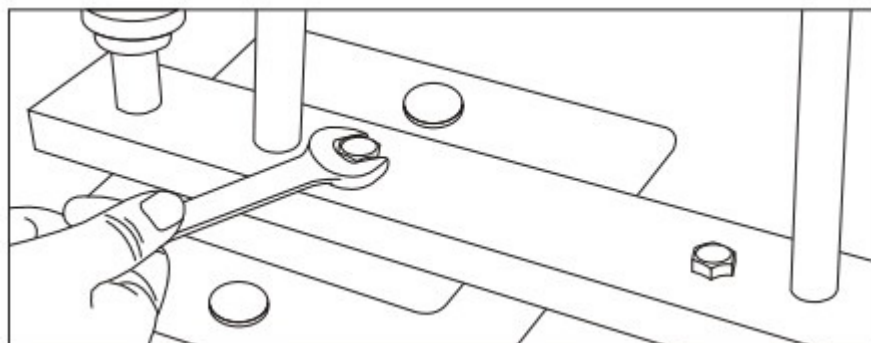
5.1.2 Remove the front metal board.

5.1.3 Turn on the power again.

5.1.4 Push the down mould to working place and twist the knob to let the upper mould go down (check below picture).

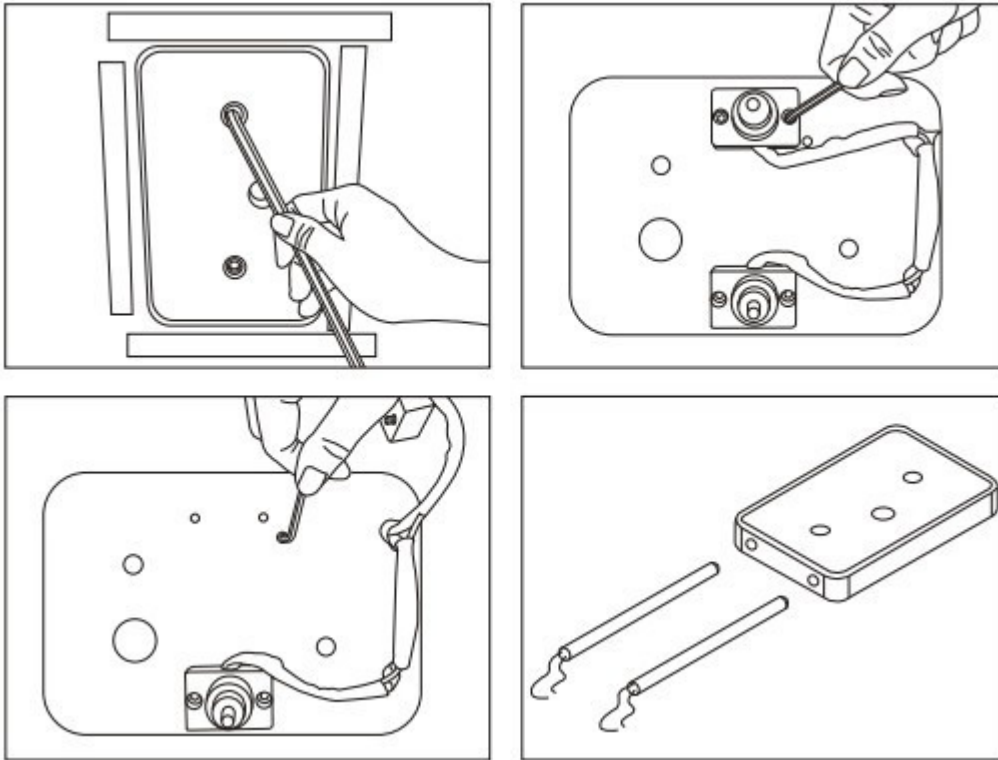


5.1.5 Remove the two screws, then twist the knob to let the upper mould connecting parts go up and divide with the upper mould (check below picture).



5.1.6 Take out the down mould with upper mould together.

5.1.7 Replace the heating elements as below picture.



6. Machine Maintenance

- 6.1 Observe the machine runs normally and no abnormal sound occurs in the process of running. If such phenomenon occurs, it should immediately stop the machine and make a check or consult machine manufacturer for reasons possibly leading to abnormal noises.
- 6.2 Regularly check mechanical fixings, including whether screws are loose or not.
- 6.3 Regularly clean dust in electrical PCB and motor, prevent heat dissipation in electrical apparatus being affected by excess dusts, leading to excess partial temperature and early damages in electrical parts.
- 6.4 Regularly check damages on electrical wires and grounding wire is in good contact. Because grounding wire is vital for protecting operators effectively in the event of electrical leakage in the machine, careful attention must be paid to this check.
- 6.5 Upper mould may be adhered with scale during long work, it should be often cleaned.
- 6.8 Please do not wash the machine by flushing water. It will damage the electrical system. The right cleaning way is wipe the dirty place by a rag with a little detergent.

7. Common Troubleshooting

- 7.1 Sealing is not good or fails to seal.
 - 7.1.1 It has oil dirt or unevenness on the surface of packing material. Please clean oil

dirt and keep packing material surface flat.

7.1.2 Mould sealing silicon bar is damaged. Please replace it.

7.1.3 Heat sealing temperature is wrong. Please adjust the temperature according to the packing material.

7.1.4 Heating is off. Please turn on the heating.

7.1.5 The film material does not match the tray material. Please check the material, ensure use the same material.

7.2 Upper mould sticks to the trays.

7.2.1 Upper mould has dirt. Please stop the machine and let it cool down, than clean the dirt.

7.2.2 There is something on the surface of film. Please clean it.

7.2.3 Heating temperature is too high. Please adjust the temperature.

7.3 recycling waste film motor works incessantly.

7.3.1 Photoswitch is unworking. Please stop the machine, ensure it is in the right position for photoswitch; adjust the distance between film cursor and photoswitch or replace the photoswitch.

8. Security Notices in Operation

8.1 Do not put your hand into the place between upper and down moulds when the machine is working.

9. Film Fixing Indicating Diagram

