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S440-S560-S560N-S560NA-S870

USE AND MAINTENANCE MANUAL



USE AND MAINTENANCE MANUAL

Manual or semi-automatic L-sealer

S440-S560-S560N-S560NA-S870

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PREFACE

While thanking you for choosing us, SMIPACK S.p.A. is pleased to welcome you among its large range of customers, hoping that the use of this machine will fully satisfy you.

This manual can be used for the model **S440 - S560 - S560N - S560NA - S870**. It has been drawn up to put you in conditions to be able to intervene on the various parts, and to understand the various maintenance and intervention operations.

We recommend strictly keeping to the standards prescribed herein in order to guarantee efficiency, duration and performance.



READ THIS MANUAL CAREFULLY AND FULLY BEFORE INSTALLING THE MACHINE.

THIS MANUAL IS AN INTEGRAL PART OF THE MACHINE AND MUST THEREFORE ACCOMPANY IT UNTIL ITS FINAL DISMANTLING.

SMIPACK S.p.A. will not be held liable for direct or indirect consequences due to a proper or improper use of this publication. We reserve the right to perform technical modifications on our systems and on this manual without prior notice.

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CE DECLARATION OF CONFORMITY

(Directive 2006/42/EC - Annex IIA)

Company name and address of manufacturer of the machine :

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Name and address of the company authorized to compile the technical documentation :

S.L.M. S.r.l. - Via S. Ambrogio, 51 - 22040 Alzate Brianza - CO (Italy) - Tel : +39 031 630925 - in the person of Giorgio Livio.

We hereby declare that the machine :

► **Model :**

☐ S440 ☐ S560 ☐ S560N ☐ S560NA ☐ S870

► **Serial number :**

with the function of :

☐ Manual or semi-automatic L-sealer

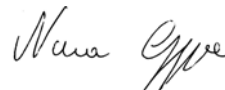
complies with Directive 2006/42/EC and to provisions of law which transpose Directives 2004/108/EC (Electromagnetic compatibility) and 2006/95/EC (Low-voltage)

It also complies with the following harmonised standards:

- EN ISO 12100: 2010
- EN ISO 13849-1:2008 + AC:2009
- IEC EN 60204-1:2006

Giuseppe Nava
(Legal Representative)

San Giovanni Bianco,



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CHAPTER 1 - GENERAL STANDARDS AND RECOMMENDATIONS

1.1 HOW TO READ AND USE THE MANUAL

This manual constitutes an integral part of the machine and therefore it must be preserved during its entire lifetime and must be handed on to eventual future owners.

Purpose of use and maintenance manual

Before carrying out any type of operation on the machine, you must carefully read this manual and any attached documentation in order to avoid possible damage to the machine, to persons or to objects.

The manual and all attached documents must be kept in a place which can be easily accessed, close to the machine and known to the users (operators and maintenance personnel) so that they may be consulted promptly when circumstances require it.

SMIPACK S.p.A. will not be held liable for possible faults, accidents or problems due to failure to comply with the provisions contained in this user manual or caused by unauthorised modifications and installations of accessories.

Preservation of use and maintenance manual

- Keep the use and maintenance manual with care.
- Do not remove, tear or rewrite parts of the use and maintenance manual.
- Make sure that any amendment implemented is incorporated in the text.

Consulting use and maintenance manual

Consultation of this manual is facilitated by the insertion, in the first pages, of a summary which allows you to quickly locate the topics described.

Method for updating manual in the event of modifications to the machine

The descriptions and illustrations of this manual cannot be contested. SMIPACK S.p.A. reserves the right (while maintaining the essential features) to modify these machines at any time for their functional, commercial and aesthetic improvement without being obliged to update previous manuals and production except for exceptional situations.

Any updates or integrations of the manual will be considered an integral part of it. We would like to thank you in advance for any suggestions which you would like to point out to us in order to implement further improvement.

1.2 WARRANTY AND EXCLUSION OF LIABILITY

SMIPACK declines all liability deriving from:

- electrical and pneumatic supply defects;
- lack of maintenance;
- pollution external to the machine;
- unauthorised modifications and repairs;
- use of non-original spare parts;
- acts of God such as earthquakes, floods or fires.

The machine is shipped to the Customer ready to be installed, after it has passed all of the foreseen tests and inspections in the factory, in compliance with legislation in force. The warranty has a 365 day validity starting from the date of purchase. During the period covered by warranty, SMIPACK commits itself to remove any faults or defects as long as periodical maintenance is performed and original parts are always used. Expendable materials, parts subject to normal wear or breakage, faults caused by atmospheric agents, transporting the machine to an assistance centre and labour charges are excluded from the warranty. The warranty is only valid for the original purchaser and only if the warranty certificate is properly filled out in every part and sent within 20 days from the date of purchase. Repairs carried out covered by the warranty do not interrupt or extend the warranty period.

The warranty will become void and invalid immediately in the following cases:

- > improper use of the machine
- > variation of process conditions
- > unauthorised tampering by third parties
- > failure to comply with that indicated in the instruction manual
- > failure to use the manufacturer's original spare parts

1.3 REFERENTIAL STANDARDS

The machine models contained in this manual comply with Legislative Provisions which transpose the following Directives.

European Directives applied to the equipment and/or the assembly:

- 2006/42/EC - Directive concerning the approximation of the laws of Member states relating to machinery.
- 2006/95/EC - Directive concerning low voltage.
- 2004/108/EC - Directive concerning electromagnetic compatibility.

Technical standards applied to the equipment and/or the assembly:

- EN ISO 12100: 2010 - Safety of machinery - General design principles - Risk assessment and risk reduction.
- EN ISO 13849-1:2008 + AC:2009 - Safety of machinery - Safety-related parts of control systems - Part 1: general principles for design.
- IEC EN 60204-1:2006-06 - Safety of machinery - Electrical equipment of machines - Part 1: general rules.

1.4 SYMBOLS KEY

All of the instructions and information contained in this manual are often associated with certain simple. Their meaning is explained in the following table.

	N.B.! This indicates useful information for consultation of the manual and proper operation of the machine.
	WARNING! This indicates situations of risk for the machine and/or for the product being processed.
	ATTENTION! This indicates personal hazardous situations and suggests standards of conduct.
	HIGH-VOLTAGE ZONE! Electrocution danger inside electrical panel.
	EARTHING The earthing connection of the system is compulsory!
	CUTTING DANGER! Be careful of the upper limbs.
	BURNING DANGER! Be careful not to enter into contact with elevated temperature surfaces.
	CRUSHING DANGER! Be careful not to crush parts of the body, especially the upper limbs.
	MOVING PARTS DANGER! Be careful not to intervene on gears or mechanical systems while in movement.
	ELECTROCUTION DANGER - CUT POWER BEFORE OPERATING! Make sure to have disconnected voltage before carrying out the indicated operations.
	CHECK MACHINE MODEL PURCHASED Before operating make sure the indications refer to the machine model you have purchased.

	MECHANICAL MAINTENANCE TECHNICIAN
	ELECTRICAL MAINTENANCE TECHNICIAN
	USE OF SAFETY FOOTWEAR COMPULSORY
	USE OF HEARING PROTECTION COMPULSORY
	USE OF GLOVES COMPULSORY
	CLOTHING COMPULSORY
	GOGGLES COMPULSORY

CHAPTER 2 - MACHINE INSTALLATION

2.1 DESCRIPTION OF THE MACHINE COMPONENTS



A) MODEL S440-S560-S870

1	REEL HOLDER	7	ELECTRICAL PANEL
2	FILM PERFORATORS	8	MASTER SWITCH
3	INFEED PRODUCT-HOLDING PLATE	9	OPERATOR PANEL
4	PLEXIGLAS HOOD	10	ELECTROMAGNET
5	SEALING BLADE	11	CYCLE START MICROSWITCH
6	THERMORESISTORS (OVEN)	12	MACHINE FORKLIFT

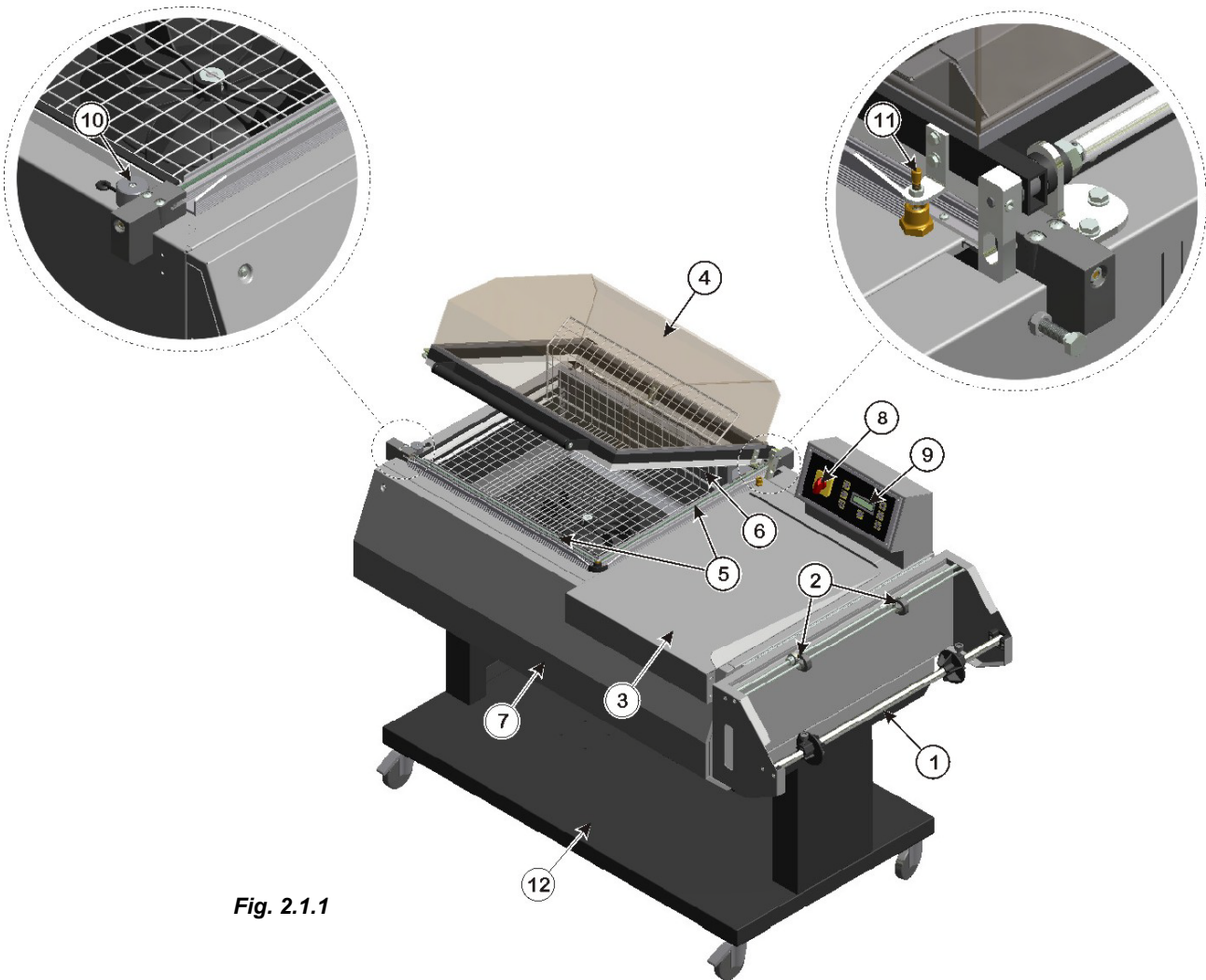


Fig. 2.1.1



B) MODEL S560N

1	REEL HOLDER
2	FILM PERFORATORS
3	INFEED PRODUCT-HOLDING PLATE
4	PLEXIGLAS HOOD
5	SEALING BLADE
6	THERMORESISTORS (OVEN)
7	ELECTRICAL PANEL
8	MASTER SWITCH

9	OPERATOR PANEL
10	ELECTROMAGNET
11	CYCLE START MICROSWITCH
12	COOLING UNIT
13	OUTFEED CONVEYOR BELT
14	ROLLER UNIT
15	MACHINE FORKLIFT

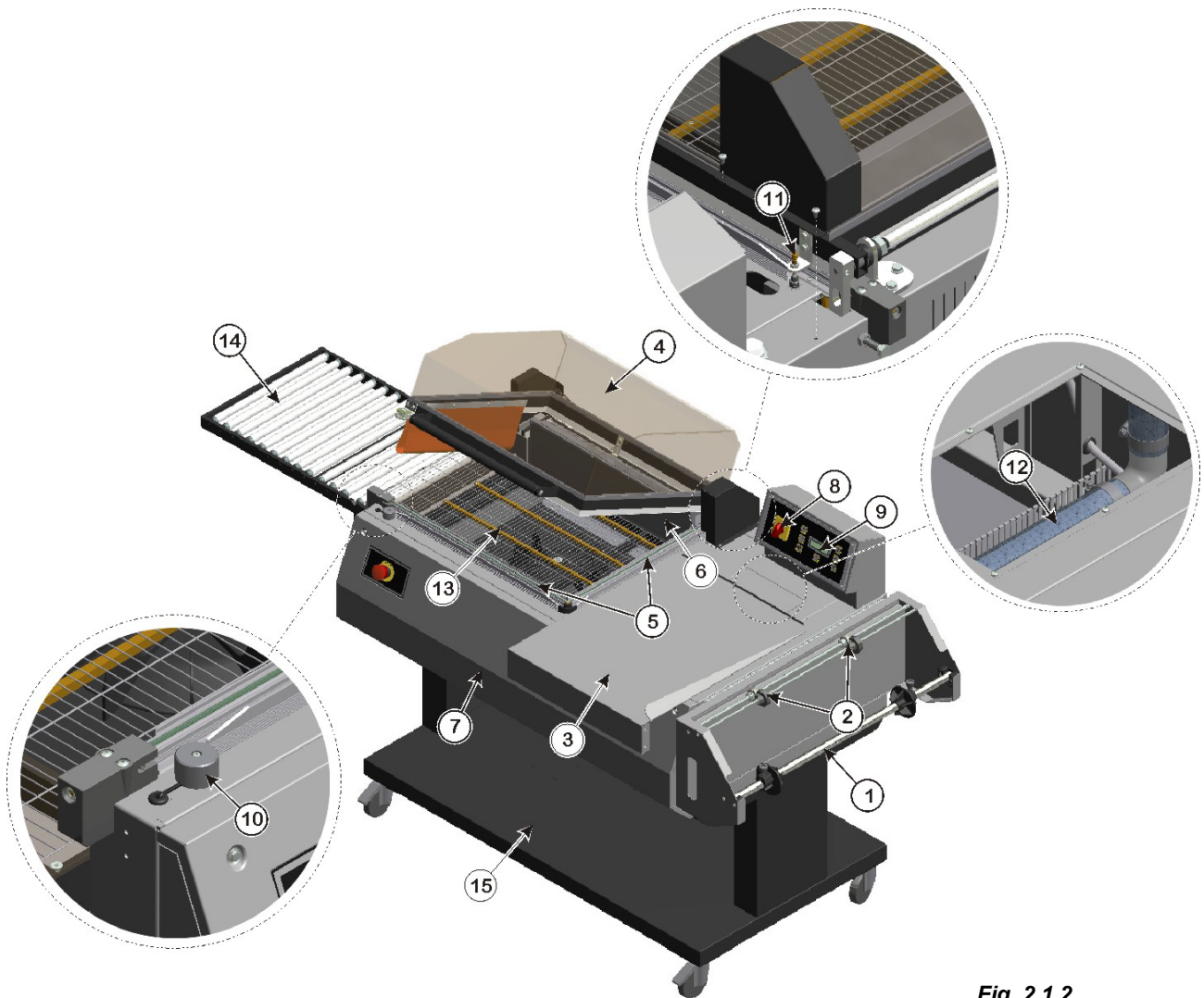
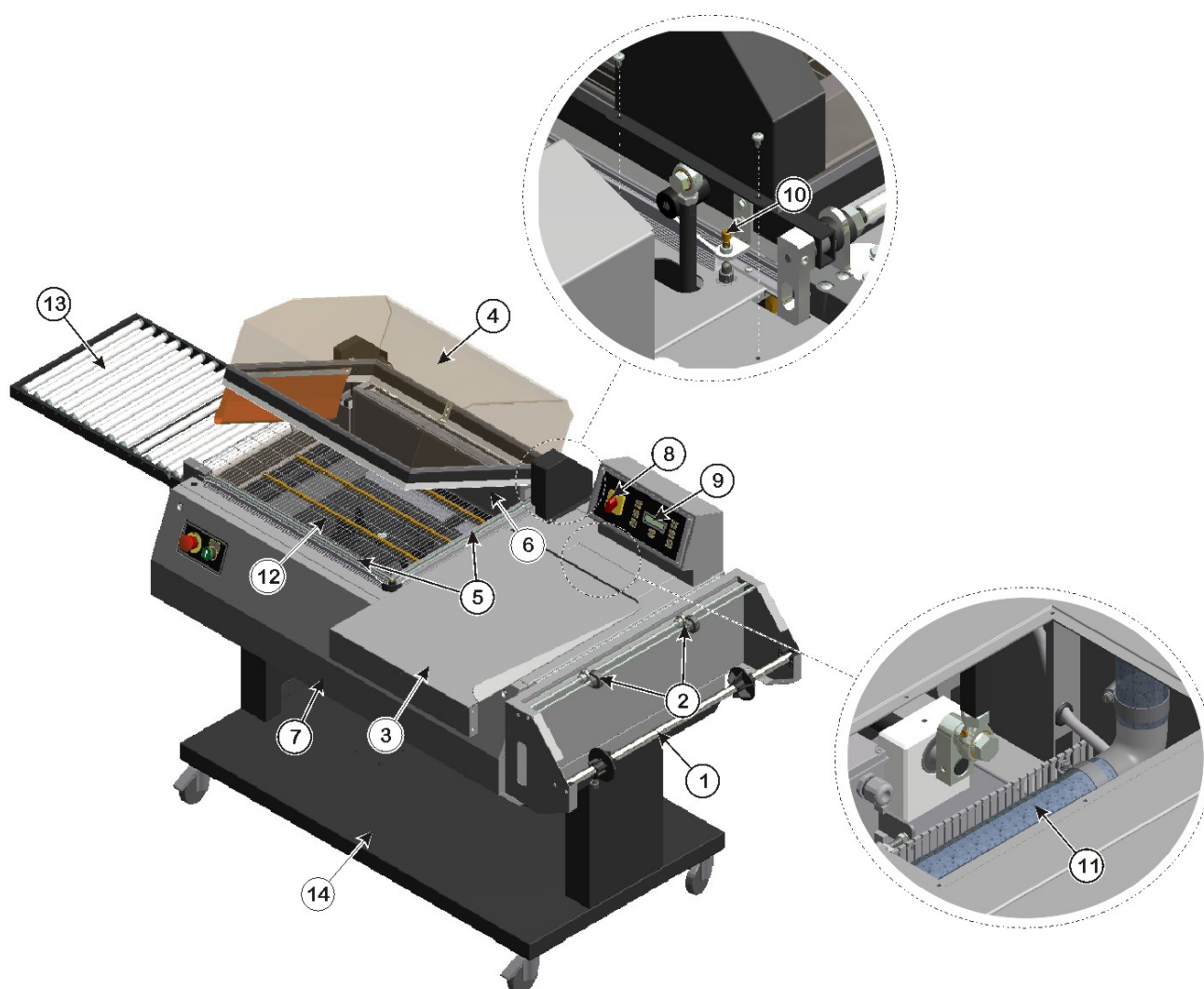


Fig. 2.1.2

**C) MODEL S560NA**

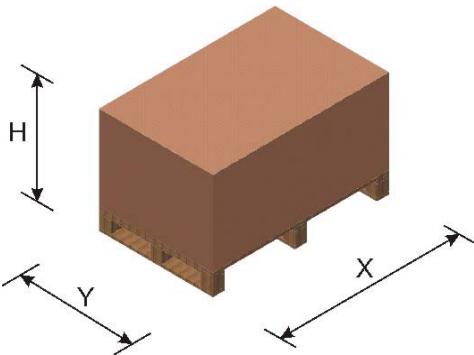
1	REEL HOLDER
2	FILM PERFORATORS
3	INFEED PRODUCT-HOLDING PLATE
4	PLEXIGLAS HOOD
5	SEALING BLADE
6	THERMORESISTORS (OVEN)
7	ELECTRICAL PANEL

8	MASTER SWITCH
9	OPERATOR PANEL
10	CYCLE START MICROSWITCH
11	COOLING UNIT
12	OUTFEED CONVEYOR BELT
13	ROLLER UNIT
14	MACHINE FORKLIFT

**Fig. 2.1.3**

2.2 WEIGHT AND DIMENSIONS OF PACKED MACHINE

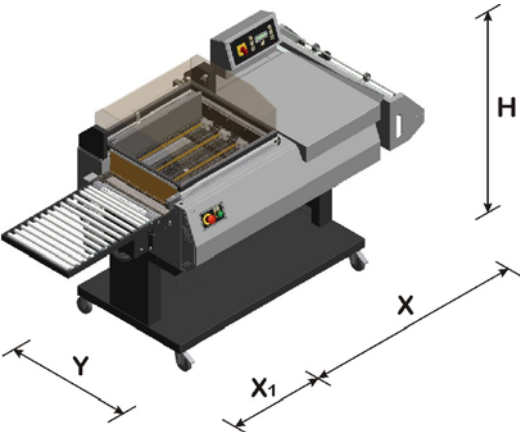
Fig. 2.2.1



	S440	S560	S560N	S560NA	S870
X (mm)	1170	1500	1500	1500	2115
Y (mm)	870	1000	1000	1000	1110
H (mm)	725	850	850	850	1295
WEIGHT (kg)	114	150	170	187	244

2.3 MACHINE WEIGHT AND DIMENSIONS

Fig. 2.3.1



	S440	S560	S560N	S560NA	S870
X (mm)	1230	1420	1520	1520	1895
X1 (mm)	-	-	490	490	-
Y (mm)	680	790	790	790	1055
H (mm)	1060	1115	1115	1115	1190
WEIGHT (kg)	95	121	140	156	191

2.4 TRANSPORTATION AND UNPACKING

SMIPACK S.p.A., depending on the type of transportation and products to be delivered, uses adequate packaging to guarantee integrity and preservation during transportation.

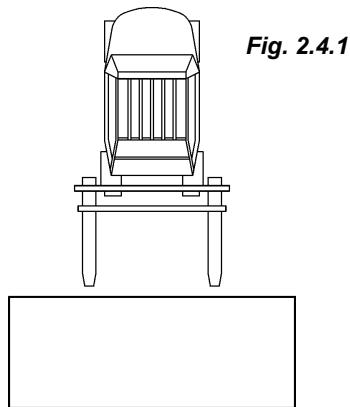


Fig. 2.4.1

Handle with care when transporting and positioning the machine. The carrier is liable for damage sustained during transportation. Be careful not to damage the exposed parts when unpacking the unit. The machine module must be handled from beneath. Due to the type of packaging, systems that work from above cannot be used.

Lift the machine in the middle from the longest side and adjust the position of the fork-lift truck at the greatest centred position possible.

Remove the machine from its packaging as described below.

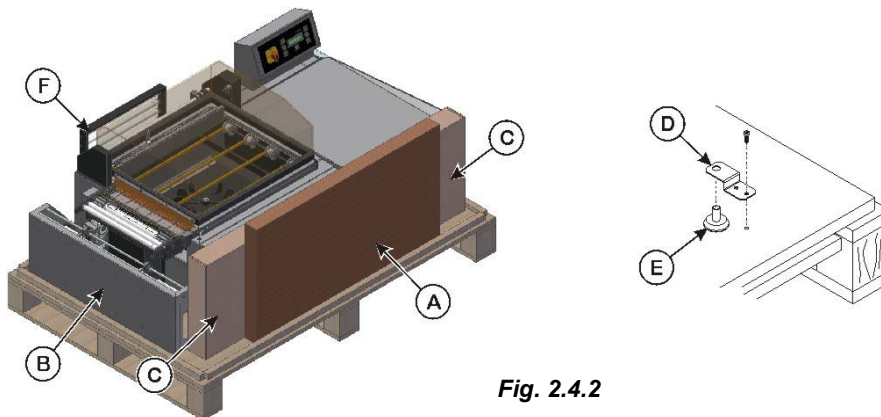


Fig. 2.4.2

(S440-S560)

- Remove box A containing the forklift base.
- Remove the reel B holder support.
- Remove the two boxes C containing the legs of the forklift and the wheels.
- Loosen the screws that fasten the machine to the pallet by removing supports D and the supporting feet E.
- Tighten the machine holder feet E.

(S560N-S560NA)

- Remove box A containing the forklift base.
- Remove the reel B holder support.
- Remove the two boxes C containing the legs of the forklift and the wheels.
- Remove roller conveyor F.
- Loosen the screws that fasten the machine to the pallet by removing supports D and the supporting feet E.
- Tighten the machine holder feet E.

(S870)

- Remove the box containing the wheels.
- Loosen the screws that fasten the machine to the pallet by removing supports D.



ATTENTION!

Before handling, always make sure that the lifting device is suitable to lift the load.

For prolonged storage, place the machine in a covered area at a temperature ranging from -15 °C to +55 °C, with a humidity degree between 30% and 90% without condensation.

2.5 ASSEMBLY BY USER

This section describes the assembly processes which must be carried out by the user according to the user's own requirements.



1) ASSEMBLING THE FORKLIFT (S440-S560-S560N-S560NA)

- Assemble the machine holder forklift as illustrated in the figure, making sure the wheels equipped with the brake are positioned at the front.
- Position the machine on the forklift for the feet (1) to engage with the relative holes (2) and then fasten the forklift to the machine using the screws (3).

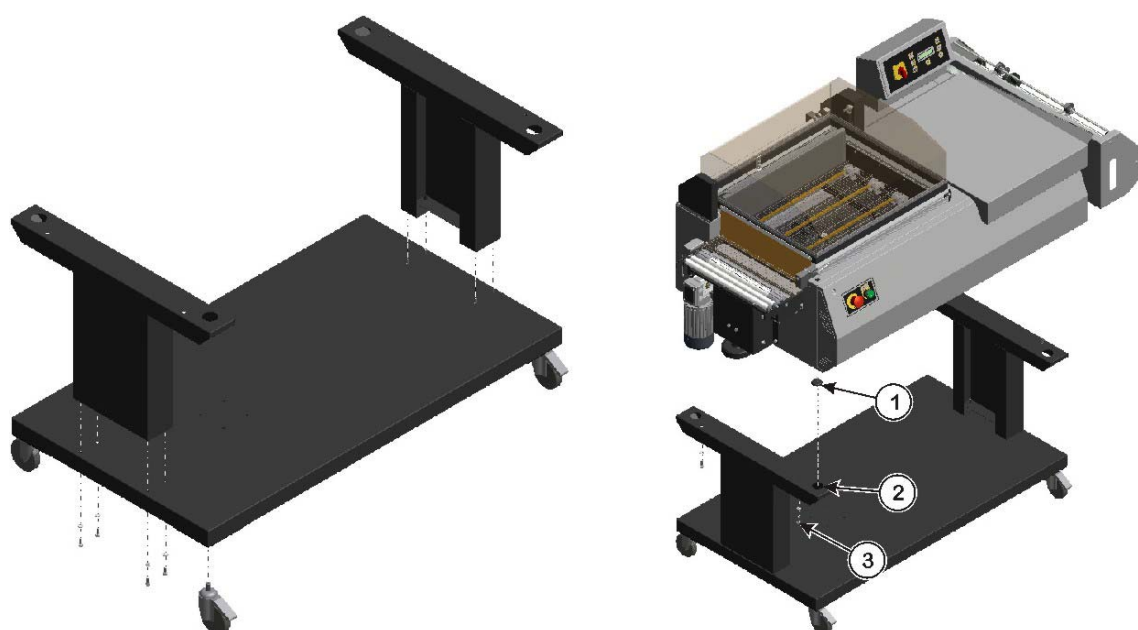


Fig. 2.5.1



2) ASSEMBLY OF THE WHELLS (S870)

- Remove the supports 1 of the machine attached to the pallet.
- Keeping up the machine using a fork-lift truck mount the wheels as shown in the figure.

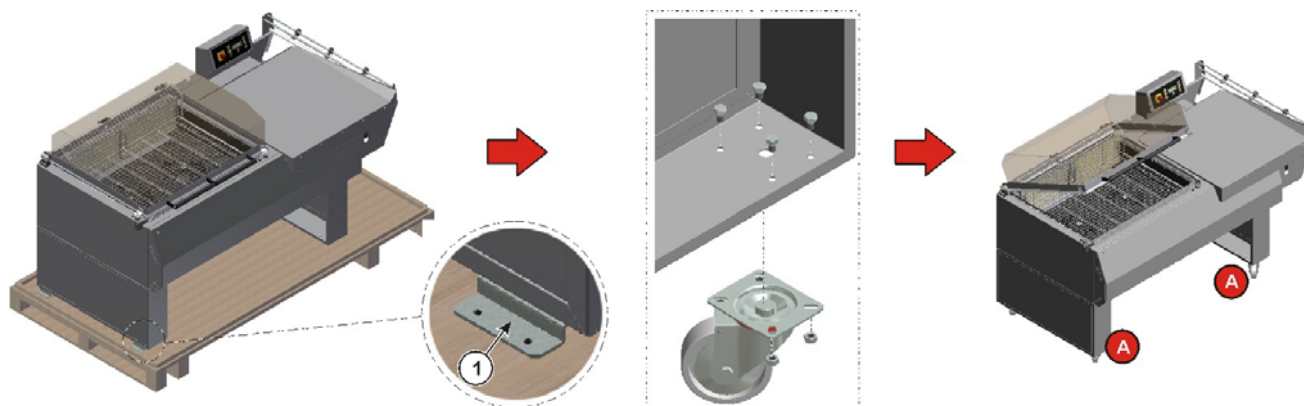


Fig. 2.5.2



Attention! Mount the two wheels A equipped with brakes at the front of the machine.

2) ASSEMBLY OF THE REEL HOLDER

- Put the reel holder support (1) in the relative guides.
- Use a screwdriver at point 2.

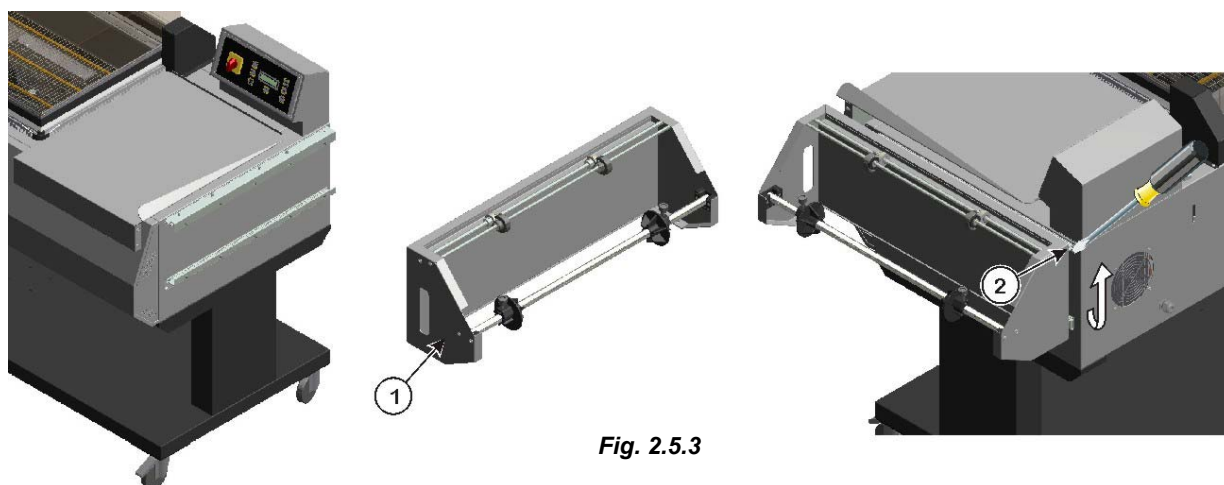


Fig. 2.5.3



3) INSTALLATION OF THE ROLLER CONVEYOR (S560N-S560NA)

- Insert the roller conveyor in the couplings 1 of the conveyor belt, securing it with the roller 2 in the relevant holes 3.
- During assembly and disassembly avoid pushing the roller conveyor sideways in order not to damage its couplings.

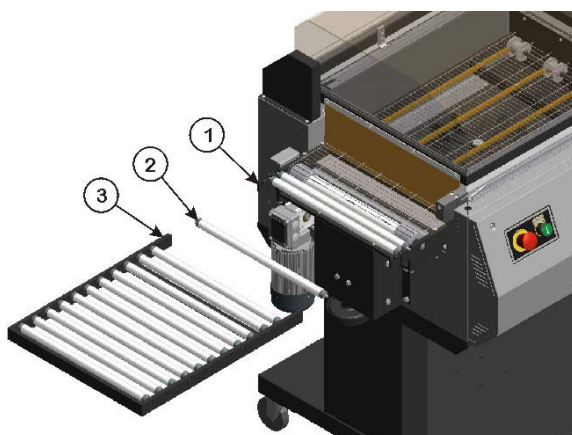


Fig. 2.5.4

4) POSITIONING THE SCRAP COLLECTION DEVICE (OPTIONAL)

a) FITTING THE FILM SCRAP COLLECTION DEVICE

- Tighten the screws (1) to the base of the forklift without fastening excessively so as to facilitate positioning the device. (Keep about 5 mm from the stop).
- Remove the protection guard (2) by loosening the screws (3).
- Position the device so that the lower side of support A comes into contact with the base of the forklift, surpassing the previously fitted screws by means of the wider holes. Then move the device sideways in order to reach the final conditions shown in the figure and then fully tighten the screws (1).
- Lastly, reassemble the protective casing (2).

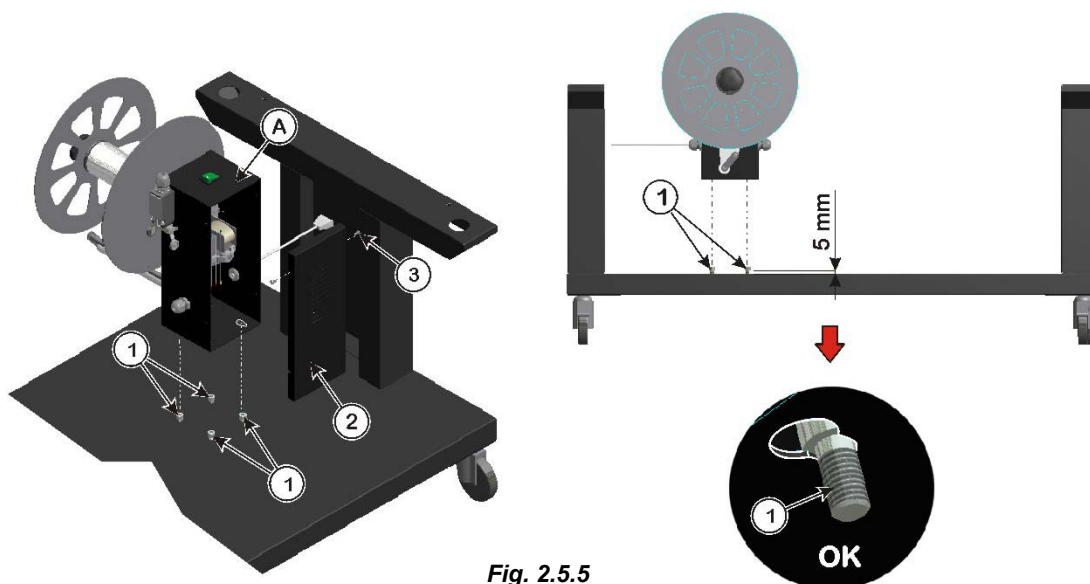
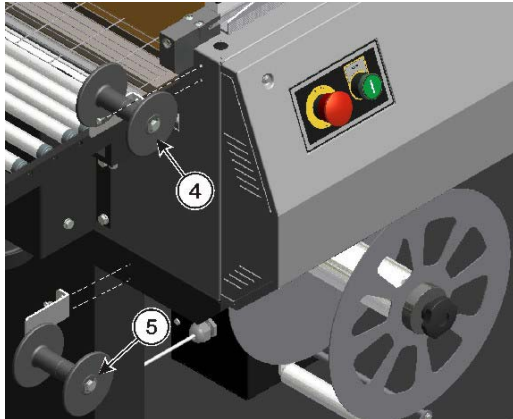


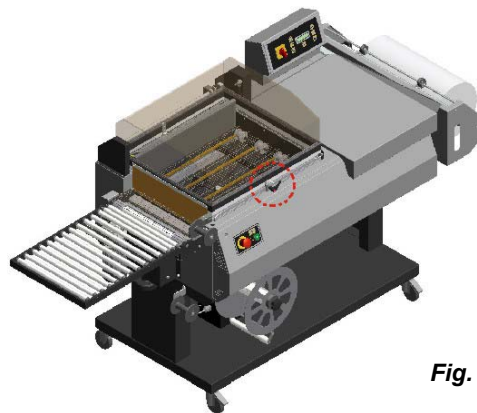
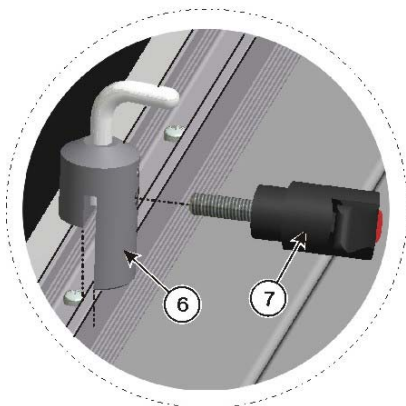
Fig. 2.5.5

b) MOUNTING THE FILM SCRAP TRANSMISSION ROLLERS

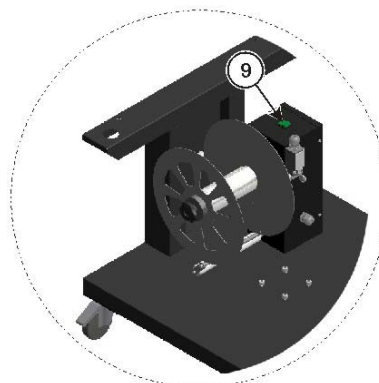
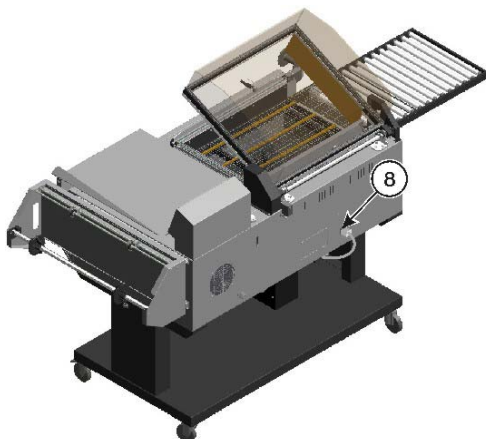
Mount the two film scrap tensioning rollers 4 and 5 in the relevant pre-drilled holes on the machine as indicated in the figure.

*Fig. 2.5.6***c) MOUNTING THE SCRAP GUIDE DEVICE**

Fit the device 6 which allows to guide the film scrap in the position shown in the figure and secure it by tightening the knob 7.

*Fig. 2.5.7***d) ACTIVATING THE SCRAP COLLECTION DEVICE**

Connect the device electrically to the relevant socket 8 on the back of the machine. Press the relative switch (9) to activate device operation.

*Fig. 2.5.8*

2.6 ELECTRICAL CONNECTION



Power must be cut from the machine for all operations involving connection to the electrical network.



ATTENTION!

Whenever accessing the electrical system, remember to cut the power and to wait at least five minutes before operating.



THE EARTH CONNECTION IS COMPULSORY!

Connecting the machine to the mains must be carried out in compliance with standards in force in the user's country.

Check to make sure that the machine's power supply frequency and voltage (see plate applied on the machine) correspond to the power supply network.



Verify that the direction of the shrinking fans in the S560-S560N-S560NA-S870 models is that indicated in the figure, otherwise, invert the supply phase.

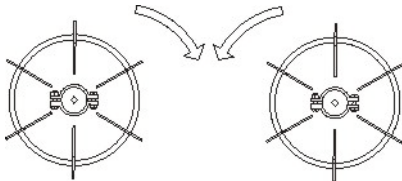


Fig. 2.6.1

2.7 ELECTRICAL INSTALLATION DATA

Install a circuit breaker on the machine power supply line which supports the values indicated in the table.

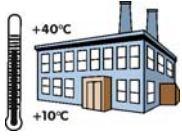
	S440	S560	S560N	S560NA	S870	
Nominal voltage	220÷240 V (1PH+N+PE)	220÷240 V (1PH+N+PE)	220÷240 V (1PH+N+PE)	220÷240 V (1PH+N+PE)	220÷240 V (3PH+PE)	380÷415 V (3PH+N+PE)
Nominal frequency	50÷60 Hz	50÷60 Hz	50÷60 Hz	50÷60 Hz	50÷60 Hz	50÷60 Hz
Nominal power	2300 W	3690 W	3690 W	3740 W	5100 W	5100 W
Nominal current	12 A	17 A	17 A	17,5 A	17 A	8 A

2.8 CONDITIONS FOR USE

Make sure there is room for easy application and maintenance.

The machine must be installed in a closed, well-ventilated area where there are no explosion or fire hazards.

The minimum lighting must be 300 lux.



Position the machine in a place free of humidity, flammable materials, gas or explosives. Make sure that it is level. Operating temperatures ranging from +10°C to +40°C are recommended, with a relative humidity from 30% to 80% without condensation.

DECLARED NOISE EMISSION VALUES IN COMPLIANCE WITH THE STANDARD ISO 4871 ARE:

THE A-WEIGHTED EMISSION SOUND PRESSURE LEVEL (AT OPERATOR POSITION) DOES NOT EXCEED 70 dB.

Machine protection degree = IP30

ATTENTION!



Noise pressure and power on the machinery plate can vary depending on the material of the containers to be packed. The user must therefore evaluate the noise exposure of one's personnel depending on the type of packaging processed, so that the operators can be provided with adequate personal protection equipment.

2.9 DEMOLITION AND WASTE DISPOSAL



The machine does not contain dangerous components or substances which require special disposal procedures. For that which concerns material elimination, comply with the Standards in the country where the machine has been disassembled.



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CHAPTER 3 - INFORMATION ON THE MACHINE

3.1 DESCRIPTION OF THE MACHINE

The range of S-series angular packaging machines allows simultaneous sealing and shrinking operations. The maximum packages that can be reached by each model are indicated in the following table.

MODEL	PACKS / HOUR
S440	up to 300
S560	up to 300
S560N	up to 600
S560NA	up to 900
S870	up to 300

3.2 DESCRIPTION OF DANGER ZONESE

Near some zones of the machine, some pictograms were placed in order to recall the attention of the operator concerning the precautions required to avoid dangers. In order to have greater understanding of the symbols used, the main ones are described hereafter.

	DANGER DUE TO THE HIGH VOLTAGE ZONE WITH RISK OF ELECTROCUTION INSIDE ELECTRICAL PANEL
	BURNING DANGER DUE TO CONTACT WITH HIGH TEMPERATURE SURFACES
	ATTENTION! DO NOT TOUCH
	CRUSHING DANGER
	CUTTING DANGER - PAY ATTENTION TO YOUR HANDS



The table below describes the areas of the machine to which the operator must pay attention in order to avoid possible dangers, according to the model of the machine.

S440-S560-S870	
ZONE A	Possibility of crushing upper limbs during manual closure of hood.
	Possibility of burns by touching the sealing blade just after a packaging cycle.
ZONE B	Burns due to contact with very hot elements (tunnel zone with temperature controlled heating elements).
ZONE C	Possibility of burns by touching the product support mesh.
ZONE D	Possibility of entering into contact with fans used for heat-shrinking process by inserting hands underneath the product support mesh.
ZONE E	Small pricks caused by perforators on reel holder.
ZONE F	Risk of burns if the plexiglas hood is touched during the packaging phase.

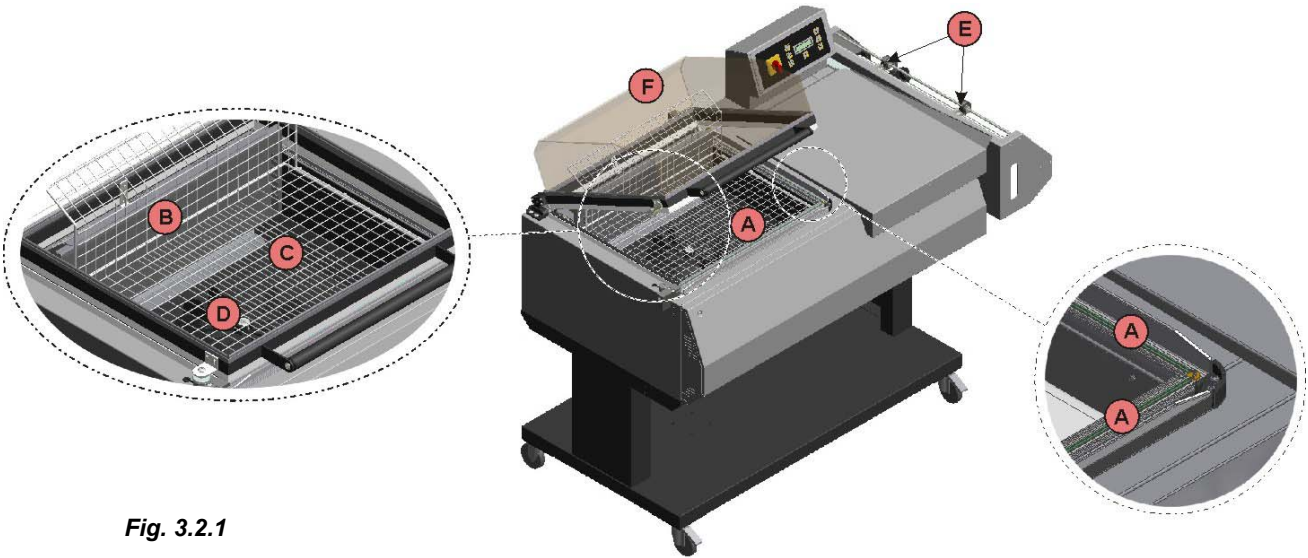


Fig. 3.2.1



ATTENTION!
Leave the hood open when the machine is switched off to allow it to cool down.

S560N	
ZONE A	Possibility of crushing upper limbs during manual closure of hood.
	Possibility of burns by touching the sealing blade just after a packaging cycle.
ZONE B	Burns due to contact with very hot elements (tunnel zone with temperature controlled heating elements).
ZONE C	Risk of crushing the upper limbs and/or clothing being entangled in the metal net or in the gears while the conveyor belt is operating. Do not insert your hands in the area between the conveyor belt and the roller conveyor.
	Risk of burns if the metal net of the conveyor belt is touched as this becomes very hot when the "shrinking" mode is activated.
ZONE D	Small pricks caused by perforators on reel holder.
ZONE E	Risk of burns if the plexiglas hood is touched during the packaging phase.

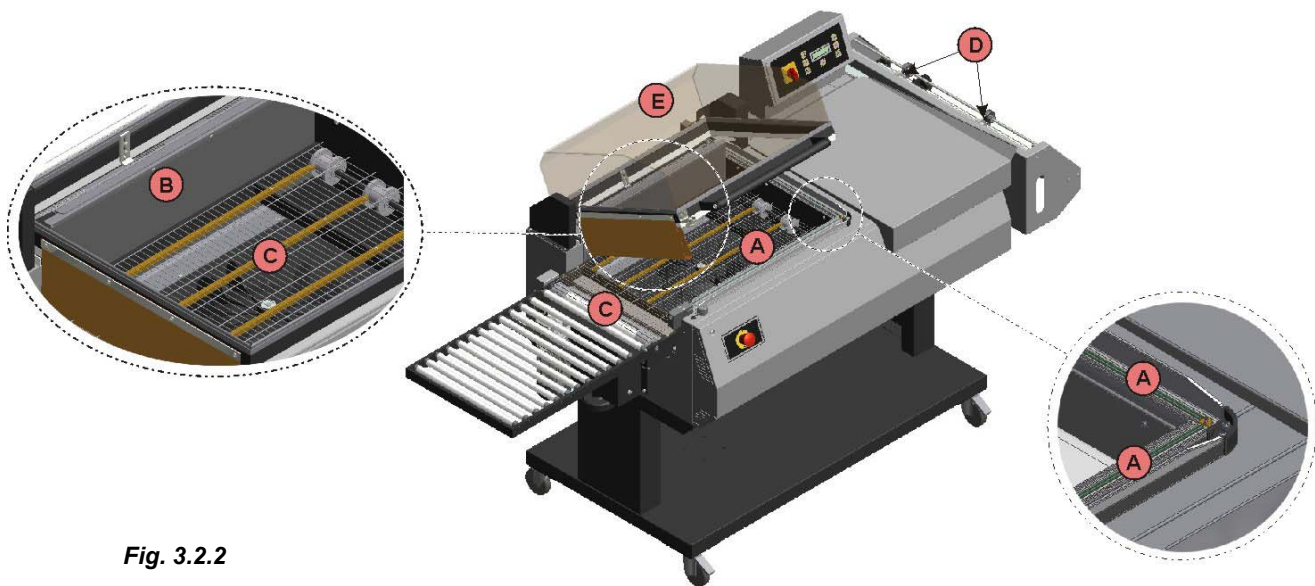


Fig. 3.2.2

**ATTENTION!**

Leave the hood open when the machine is switched off to allow it to cool down.

S560NA	
ZONE A	Possibility of burns by touching the sealing blade just after a packaging cycle.
	Possibility of slight bruising/crushing of the upper limbs while the hood descends. A safety device instantly stops the closing process of the hood when an obstacle is detected (such as an object or the hands of the operator).
ZONE B	Burns due to contact with very hot elements (tunnel zone with temperature controlled heating elements).
ZONE C	Risk of crushing the upper limbs and/or clothing being entangled in the metal net or in the gears while the conveyor belt is operating. Do not insert your hands in the area between the conveyor belt and the roller conveyor. Risk of burns if the metal net of the conveyor belt is touched as this becomes very hot when the "shrinking" mode is activated.
ZONE D	Small pricks caused by perforators on reel holder.
ZONE E	Risk of burns if the plexiglas hood is touched during the packaging phase.

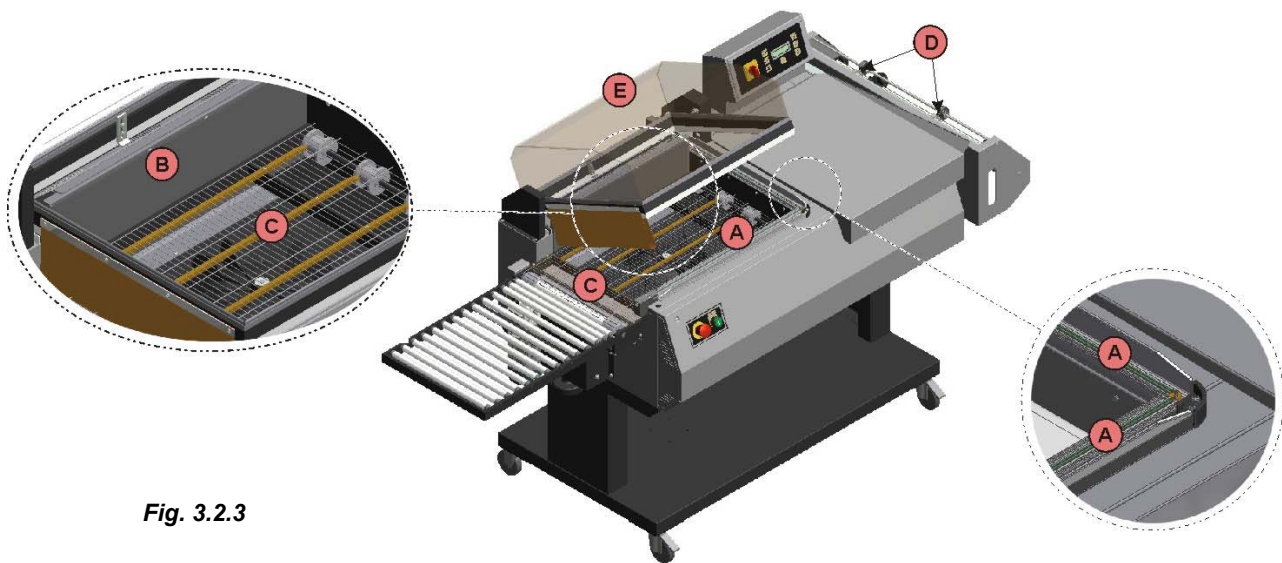


Fig. 3.2.3



ATTENTION!
Leave the hood open when the machine is switched off to allow it to cool down.

USING THE MACHINE WITH THE OPTIONAL FILM SCRAP COLLECTION DEVICE (S560-S560N-S560NA-S870)

Do not intervene when the machine is in operation so as to avoid risks caused by the rotation of the film scrap collection device (crushing of the limbs and/or clothing being entangled with the consequent hazard of being dragged).

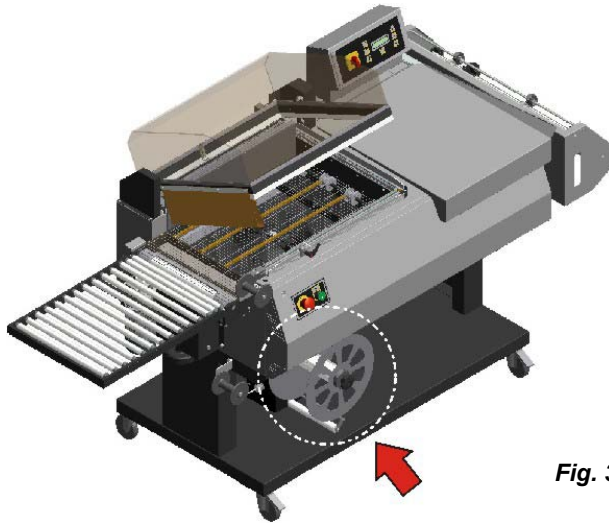


Fig. 3.2.4

3.3 AUTOMATED MACHINE OPERATION

The S560NA model is the only one equipped with an automatic mechanism that allows the hood closing movement to be activated by pressing START. At the end of the welding or shrinking cycle the hood automatically and independently returns to the initial position whereas the product is transported out of the packaging area.

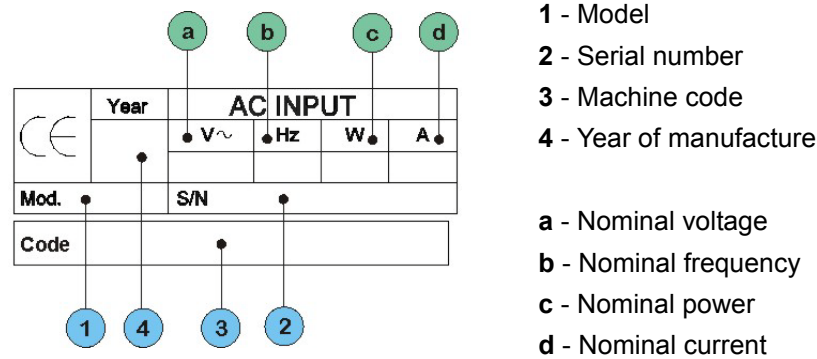
The initial work phase consists of a motor that controls the descent and ascent of the hood. Press any button on the operator panel to stop the packaging cycle.

The hood handling times are controlled electronically by software that also allows the sealing pressure to be varied. The final “product evacuation” phase consists of a conveyor belt that does not require the intervention of the operator. These automatic mechanisms reduce the packaging cycle time, thereby increasing the hourly production.

3.4 IDENTIFICATION DATA AND TECHNICAL DATA OF THE MACHINE

Each machine is provided with a plate where it is easy to recover data which must be communicated to the manufacturer in case of problems or when requesting spare parts etc. (ref. 1-2-3-4). This plate also carries electrical technical data for installation of the machine (ref. a-b-c-d).

Fig. 3.4.1



ATTENTION! Before performing connections to the electrical mains, make sure that the power supply voltage is compatible with that shown on the plate.

3.5 TECHNICAL SPECIFICATIONS OF THE PRODUCT

The table below indicates the maximum dimensions and limit weights (minimum and maximum) of the products which can be packed.

[mm]	S440	S560-S560N S560NA	S870
X	410	520	830
Y	250	390	600
H	210	260	310
WEIGHT	> 50 g < 15 kg	> 50 g < 15 kg	> 100 g < 18 kg

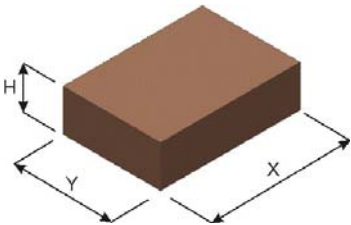


Fig. 3.5.1

PACKAGING LIMITATIONS

It is not possible to pack:

- Products larger or heavier than that allowed
- Bulk products smaller than the openings in the grid product support mesh
- Wet products
- Flammable products
- Explosive products
- Products in bulk or volatile powders
- Any type of liquid products in fragile containers

It is also prohibited to:

- It is also prohibited to

- Replace with non-original spare parts
- Modify electrical connections in order to be able to by-pass internal safety devices
- Remove installed guards

ATTENTION!

Do not wrap anything which is not intended or which can in any way be dangerous for the user and damage the machine.



Before performing any modification, you must contact SMIPACK S.p.A for their consent.

3.6 FEATURES OF THE FILM

The machine has been designed to wrap a variety of products using PVC and Polyolefin film up to 30 µm thick. The film, used in single fold execution, can be micro-perforated by specific perforators mounted on the machine's reel holder.

[mm]	S440	S560-S560N S560NA	S870
L	500	600	800
B	Ø300	Ø300	Ø300
C	Ø77	Ø77	Ø77

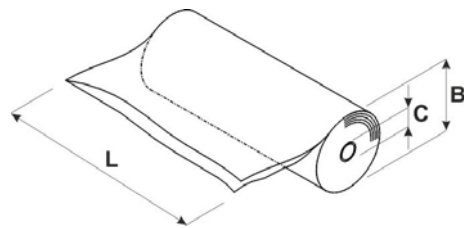


Fig. 3.6.1

3.7 DETERMINATION OF FILM WIDTH

To determine the width L of the film reel used for packaging, follow this formula:

$$L_{\text{reel}} = Y_{\text{product}} + H_{\text{product}} + 50 \text{ mm}$$

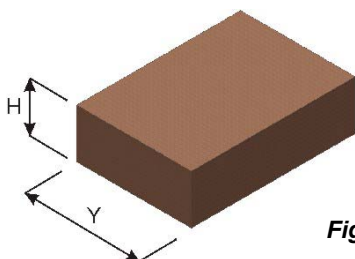


Fig. 3.7.1

3.8 FILM SEALING OPERATION

Sealing and cutting of film is pulse-operated, adjusted automatically by the circuit board. The sealing blade A is brought to a temperature which melts the film. The pressure achieved between the sealing blade and the upper contest, coated in PTFE, separates the two edges of the film.

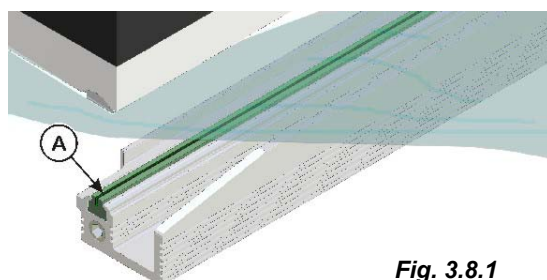


Fig. 3.8.1

3.9 FILM HEAT-SHRINKING OPERATION

Film is shrunk the same time as it is sealed. This is produced by the forced circulation of hot air around the package. The air is heated by means of a group of temperature controlled heating elements.

Should the sealing break due to heat shrinking, some parameters can be adjusted on the operator panel to delay execution of this process.

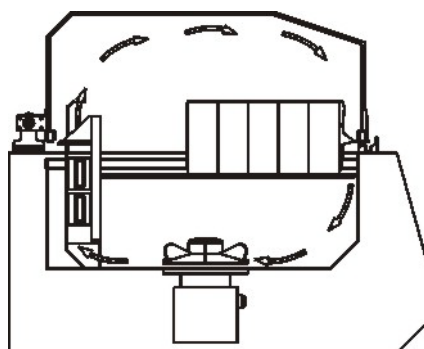


Fig. 3.9.1



CHAPTER 4 - PREPARING THE MACHINE FOR USE

4.1 POSITIONING REEL AND FILM PASSAGE

- Insert the film reel in the reel holder 1 blocking it with the self-centring tapered supports 2.
- Pass the film through the perforators 3.
- Pass the lower edge of the film below the packaging plate 4 and the upper edge above at.

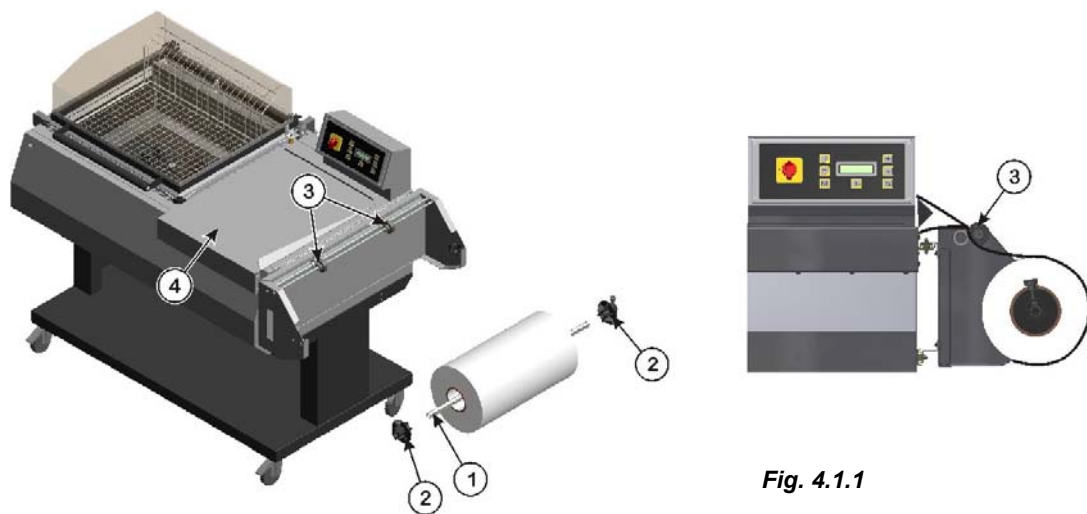


Fig. 4.1.1

4.2 ADJUSTING FILM PERFORATORS

The number of punches required varies according to the width of the packs to be sealed. A single punch is sufficient for small packs. On the series S440-S560-S560N-S560NA machines there are two punches available while there are three for model S870.

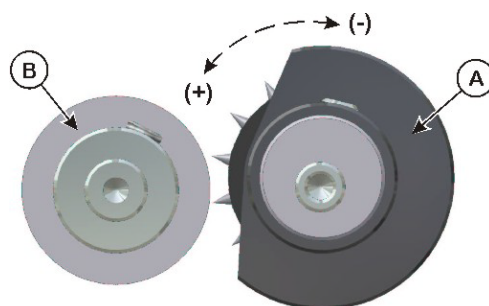


Fig. 4.2.1

Turning the perforators manually A you can move them closer or farther from the contrast B to obtain a larger or smaller perforation thus guaranteeing ideal heat shrinking for any type of product without breaking the film along the sealing.



4.3 ADJUSTING THE PACKAGING PLANE (S560N-S560NA)

The product carrier motor-driven belt 1 must be adjusted using the handwheel 2 according to the height of the product to be packaged.

For a good packaging, film sealing 3 must take place at half the product height 4.

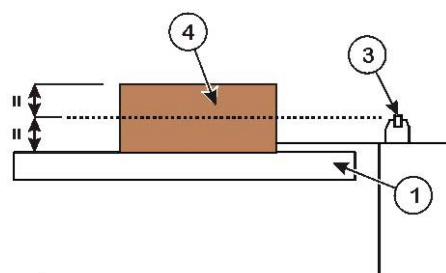


Fig. 4.3.1

4.4 ADJUSTING HEIGHT OF PRODUCT SUPPORT MESH

Adjust the height of the product support mesh 1 by means of the striker plates 2 and 3 according to the height of the pack.

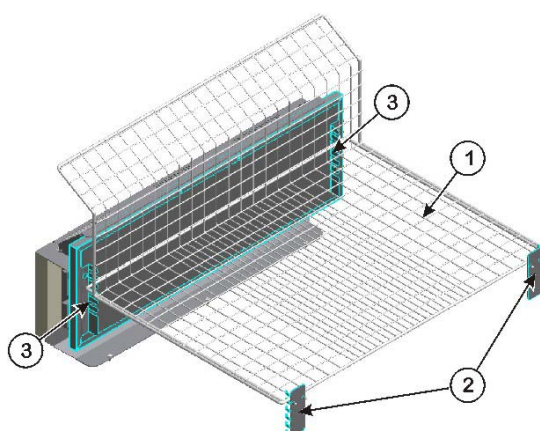


Fig. 4.4.1

4.5 ADJUSTING THE OPENING OF THE HOOD



Act on the retainer (1), making it slide along the relative guide, to adjust the opening width of the hood on the S440-S560-S560N-S870 models.

Adjust the opening force of the hood by turning the screw (2) clockwise to increase it or anti-clockwise to decrease it.



Fig. 4.5.1

S440-S560-S560N



Fig. 4.5.2

S870



4.6 POSITIONING THE REEL HOLDER SUPPORT AND THE PRODUCT HOLDER PLATE

The reel holder support (1) and product holder (2) must be adjusted according to the width (L) of the product that is to be packaged. Leave a gap of about 1-2 cm between the product and the sealing edge, as shown in the figure.

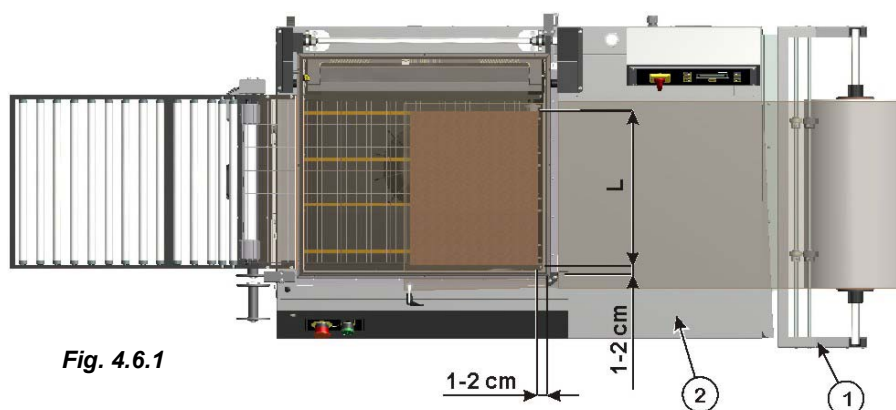


Fig. 4.6.1



4.7 USING THE SCRAP COLLECTION DEVICE (OPTIONAL)

For some models there is a device which one can collect the film scrap resulting from the packaging process. When the film scrap reaches a few metres in length, feed it onto rollers A and B as shown in the figure and subsequently fasten it to flap C. This way th film scrap will automatically be wound by the device.

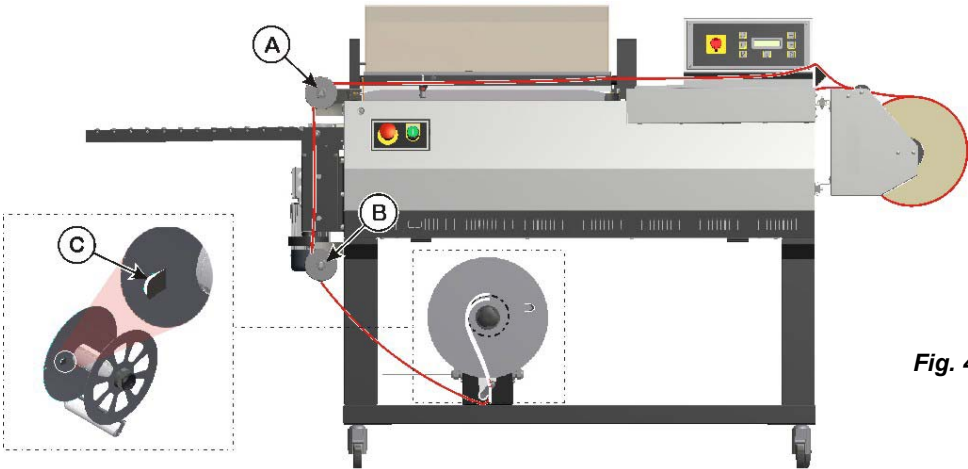


Fig. 4.7.1

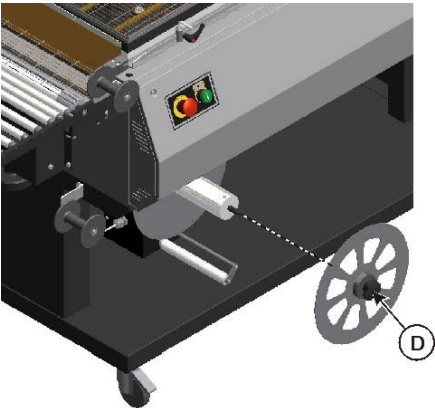


Fig. 4.7.2

When the device has reached maximum film scrap capacity, remove it by unscrewing knob D shown in the figure.

The position of device E that guides the film scrap must be adjusted according to the size X of the bag with which one intends to package the product.

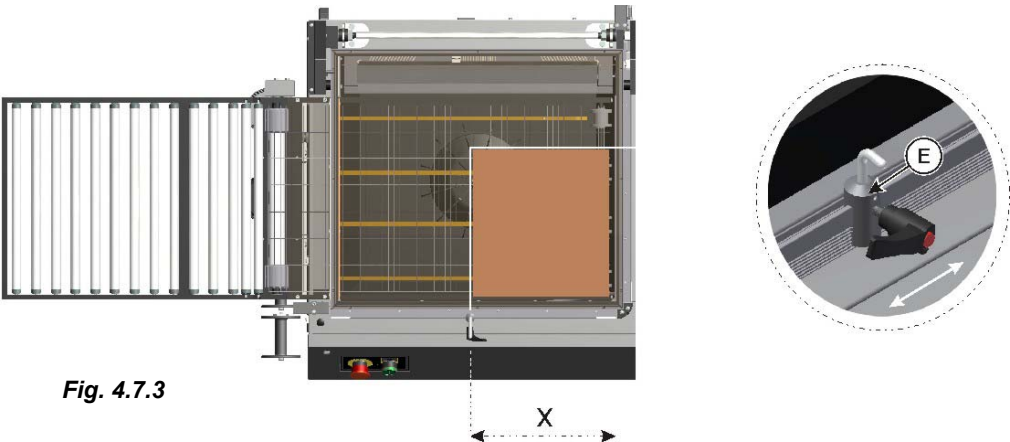


Fig. 4.7.3

4.8 FIRTS FILM SEALING

The first operation to be carried out, on all models, consists in inserting about 10 cm of film in packaging area A and then sealing the film for the first time, with the sealing on the left side of the bag. (Set the "sealing" mode in this phase)



Fig. 4.8.1



a) S440-S560-S560N-S870

To perform the first film seal, lower the hood (1) manually and apply a pressure of about 10-15 kg as soon as it comes into contact with the sealing blade. (See the following paragraph too)

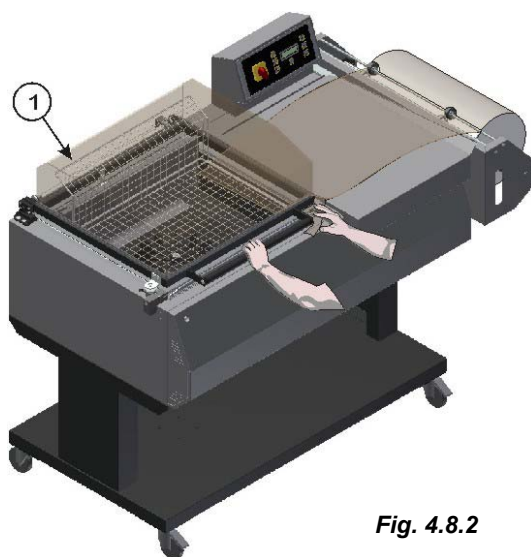


Fig. 4.8.2



b) S560NA

Perform the first film seal by pressing the START button in order to activate the closure and subsequent automatic opening of the hood. (See the following paragraph too)

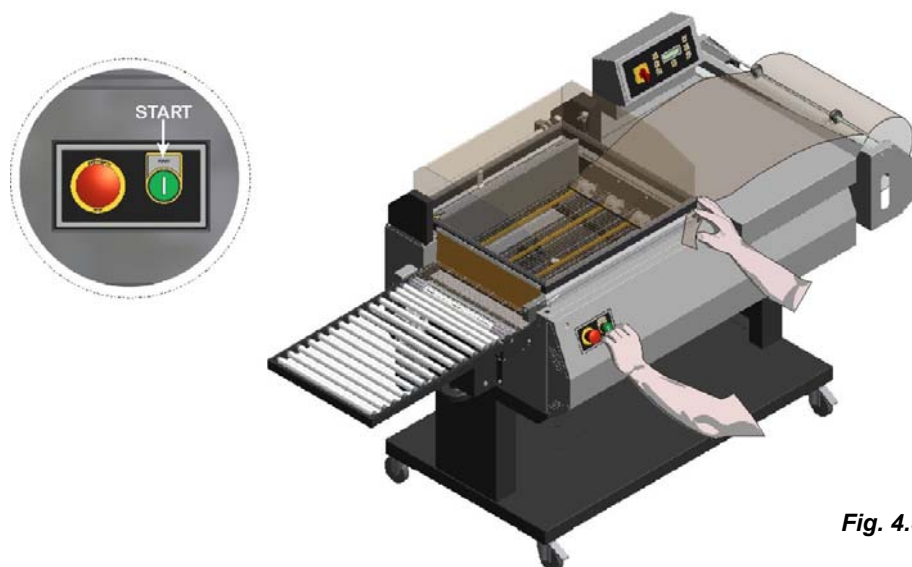


Fig. 4.8.3

4.9 PACKAGING PRODUCTS

After having performed the first film sealing operation, introduce the product to be packaged in the bag, placing it on the specific product support.

Use your left hand to feed through the film and your right hand to move the product into the packaging area up to about 1-2 cm from the sealing blade, as shown in the figure 4.6.1.

To carry out the packaging operation proceed as described according to the machine model.

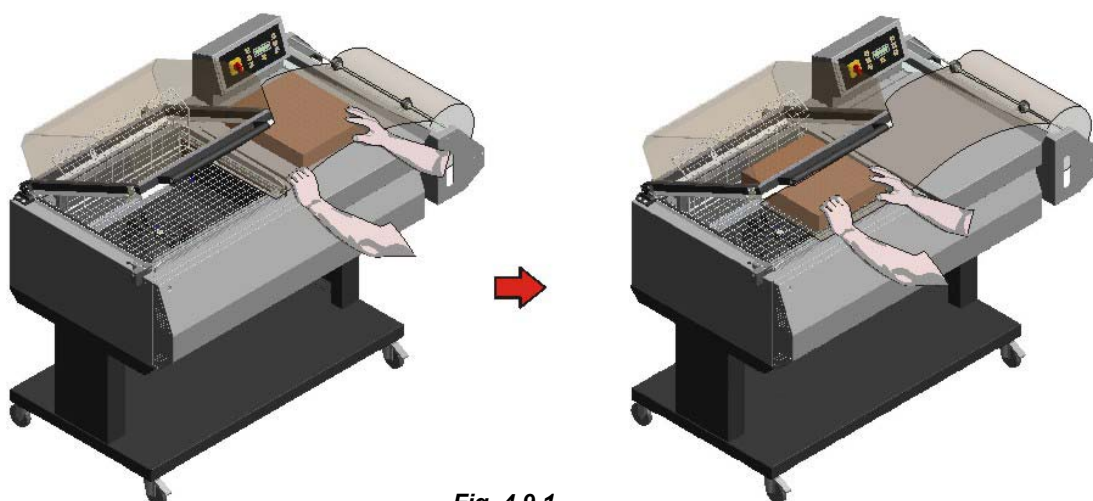


Fig. 4.9.1



a) S440-S560-S560N-S870

To perform the film seal, lower the hood (1) manually and apply a pressure of about 10-15 kg as soon as it comes into contact with the sealing blade. Keep the hood pressed until the buzzer is heard indicating the seal is complete, then release it and wait for the shrinking process to be completed and it will open automatically.

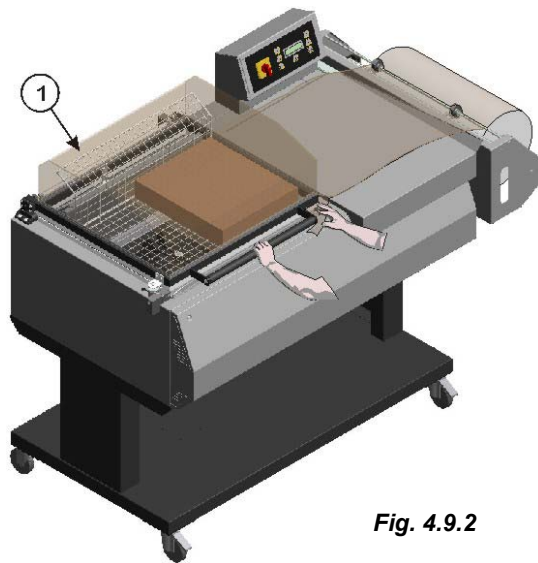


Fig. 4.9.2

Help detach the film with your right hand after the sealing process is complete so as to prevent it from adhering to the sealing blade as it cools. (If you do not have the optional film scrap collection device)

The packaged product on the S560N model will then be evacuated via the conveyor belt.



b) S560NA

The packaging process is implemented by pressing the START button for the closing movement of the hood to be activated, then pressing on the sealing blade and then automatically opening once the set packaging process is complete. (Only sealing or sealing+shrinking)

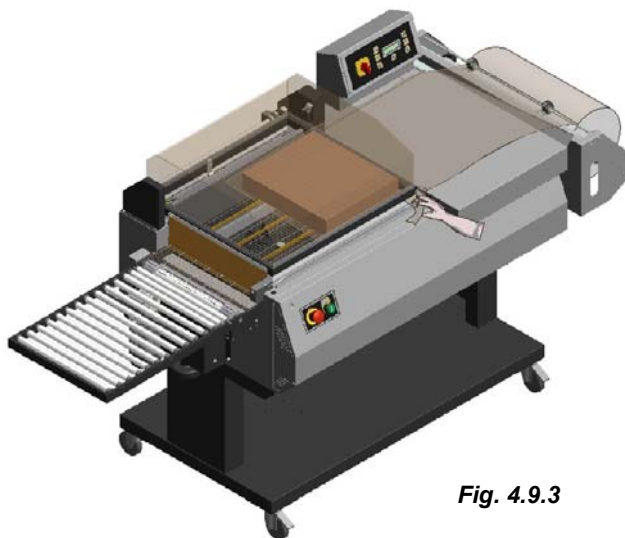


Fig. 4.9.3

Help detach the film with your right hand after the sealing process is complete so as to prevent it from adhering to the sealing blade as it cools. (If you do not have the optional film scrap collection device)

At the end of the sealing process the packaged product will be evacuated via the conveyor belt which the machine is fitted with. Brief sound signals will indicate the completion of the various packaging stages.



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CHAPTER 5 - OPERATION AND USE

5.1 OPERATOR PANEL INTERFACE



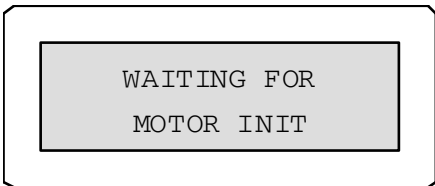
	Switches the machine on and off.
	Connects power once the machine is started on the S560N-S560NA models. Signals correct machine power supply by turning the indicator on.
	Selects the sealing program. (in this operating mode the product will be packaged in a slack bag).
	Selects the heat shrinking program so packaging will be implemented with the film sticking to the product.
	Displays the parameters in the active program. (memory M.. selected).
	Allows selecting the programmable memories available (M1-M2-M3-M4-M5-M6-M7-M8-M9-M10); Memorises modified data concerning the parameters of the active memory.
	Increases the value of the selected parameter.
	Decreases the value of the selected parameter.

5.2 STARTING THE MACHINE

Turn the main switch on the control panel to the ON position.

In the case of the S560N and S560NA models, press the  button to connect the power.

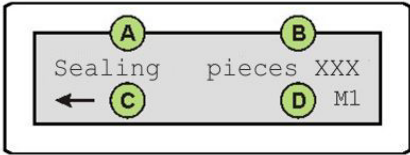
In the semi-automatic S560NA model, press this button for the machine to start initialisation diagnostic tests. The following stand-by message appears on the display of the operator panel during this process:



(automatic mechanism motor hood opening and closing)

The display then shows the machine model with the current software version and the main menu in the picture.

A	Indicates the current operating mode (sealing or heat shrinking).
B	Indicates the number of pieces packaged.
C	The “arrow” symbol indicates that the machine is ready for packaging.
D	Indicates the active programmable memory.

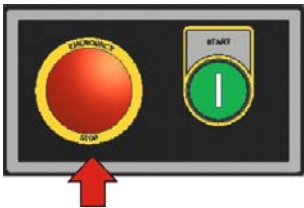


5.3 START AND STOP OF THE PACKAGING CYCLE FOR THE S560NA MODEL

Press the START button to start the packaging cycle. Press any button on the operator panel to stop the packaging cycle.



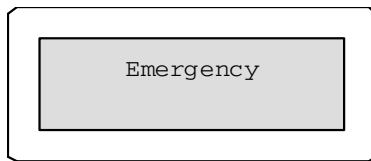
5.4 STOPPING THE MACHINE IN AN EMERGENCY (S560N-S560NA)



There is a red button against a yellow background for stopping the machine in the event of an emergency. Pressing this button stops the machine instantly.

ATTENTION! Press this button only in the event of an imminent danger or mechanical accident.

EMERGENCY appears on the electronic display and the operator panel might emit a noise.

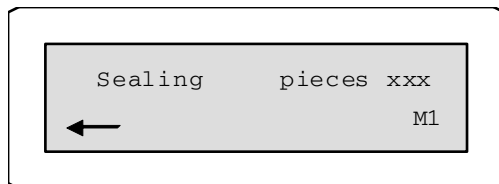


Release the emergency button for the packaging cycle to resume. In the case of the S560NA model, then press the  button to connect the power.

1) Sealing mode

Sealing mode packages products in slack bags.

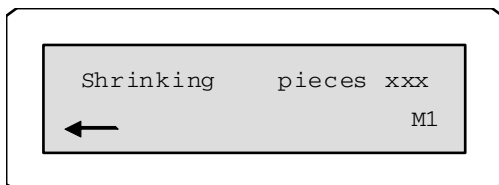
To access this mode, press  .



2) Heat-shrinking mode

Heat shrinking mode packages products with the bag sticking to the product.

To access this mode, press  .



When in heat shrinking mode the message "heating" appears on the operator panel display and the LED of the  key flashes, only the sealing process can be performed. This machine status will be maintained until the heating elements reach the temperature set in the "parameters menu". The AUTOMATIC mode cannot be activated during this phase in the case of the S560NA model.

5.5 SAVING A PROGRAM

Depending on the size of the product and the type of film you wish to use, some operating parameters must be set in order to guarantee quality packaging. The operator can save up to 10 sealing programs (M1,.....M10).

The active memory number is visualised in the second row of the display (e.g. M1) and can be changed by selecting **M** followed by **+** and **-**.

Procedure for saving a program (memory M....)

- Select the programmable memory you wish to adjust (e.g. M2)
- Access the “parameters menu” of the active memory by pressing **S**.
- Press **S** several times to view all the parameters.
- Adjust the parameter values using the **+** and **-** keys.

Memorise the values set in the menu by pressing **M**. If the operator does not press any key for more than 5-6 seconds, the modified data will be saved automatically. When it has been saved, the text “Wait.....” will appear on the display for a few seconds.

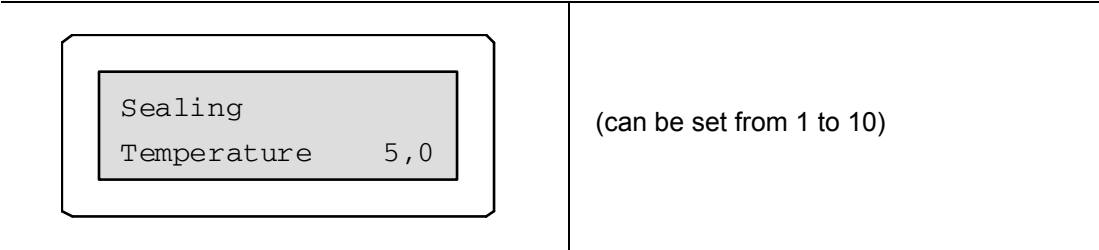
5.6 PARAMETERS MENU

After having chosen the programmable memory to be used (e.g. M1), press **S** pto access the machine operating parameters. Press **S** pseveral times to view in succession the parameters we will describe hereafter and use the **+** and **-** keys to modify the data.

1 • Sealing temperature

Menu for adjusting sealing temperature.

Fig. 5.6.1



2 • Tunnel temperature

Menu for adjusting tunnel temperature.

Fig. 5.6.2

Tunnel Temperature 5,0	(can be set from 1 to 10)
--	---------------------------

3 • Shrinking Timer

Menu for adjusting heat shrinking time.

Fig. 5.6.3

Shrinking Time 4,5	(valore impostabile da 1 a 10)
--	--------------------------------

4 • Wait before start of heat shrinking process

Menu for adjusting the stand by time between the end of sealing and the start of heat shrinking.

Fig. 5.6.4

Wait for Shrinking 0,2	(can be set from 0 to 1)
--	--------------------------

5 • Hood opening delay

Delays the opening of the hood, after the end of the heat shrinking process.

Fig. 5.6.5

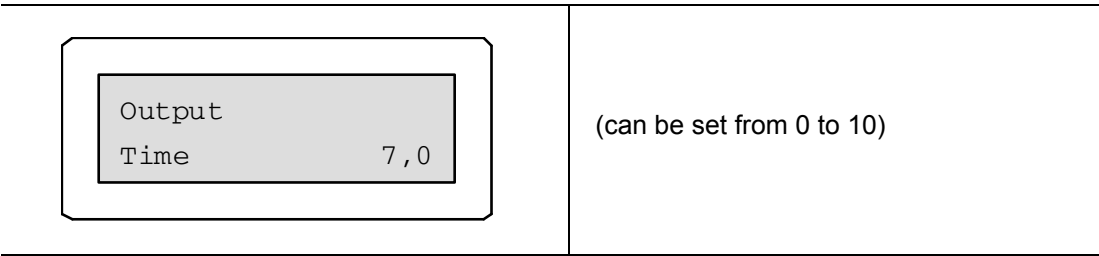
Opening Delay 2,0	(can be set from 0 to 10)
---	---------------------------



6 • Time for ejection of product from packaging area (only S560N-S560NA)

This determines the time for ejection of the packed product from the packaging area.

Fig. 5.6.6



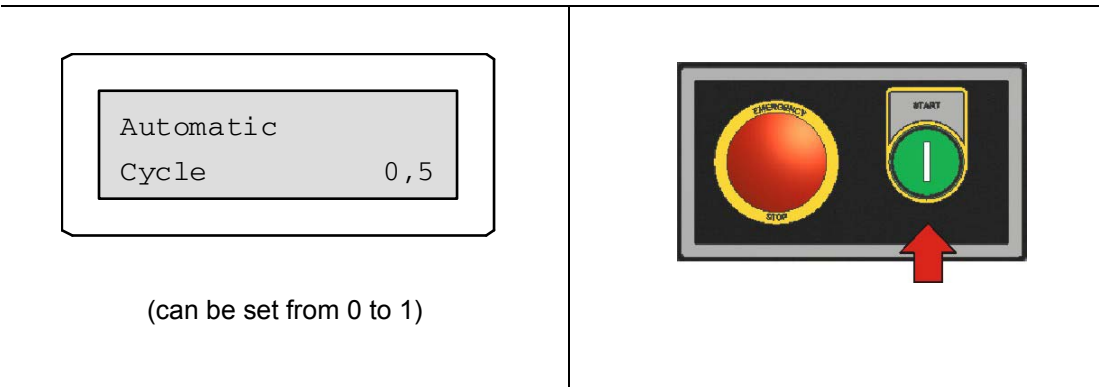
Start-up of the conveyor belt is delayed only when this value is set at 10. This can be done when the products to be packaged are particularly tall.



7 • Automatic cycle of sealing process (only S560NA)

By setting the parameter at ≠0, the machine carries out the sealing process automatically without need for the operator to keep pressing the START button. Set the parameter at "0" to disable it.

Fig. 5.6.7

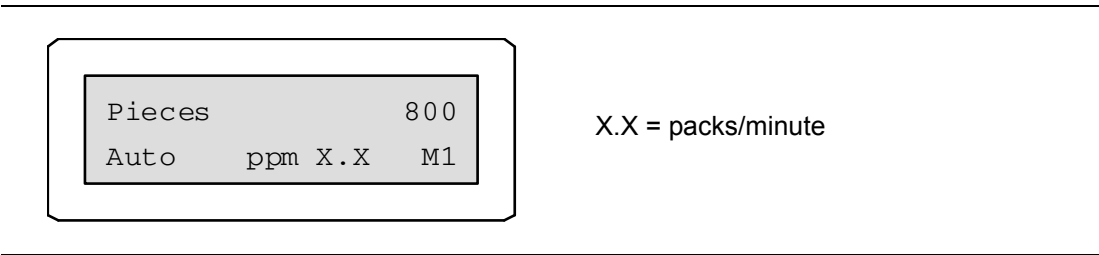


If the parameter is enabled (value ≠0):

- the hood drops descends as soon as the conveyor belt stops when set to 0.5.
- the hood descent time is delayed from when the conveyor belt stops when set to >0.5.

Increase the set value to decrease the opening and closing speed of the hood. The packs/minute that can be packaged will appear on the operator panel display together with the configured settings.

Fig. 5.6.8

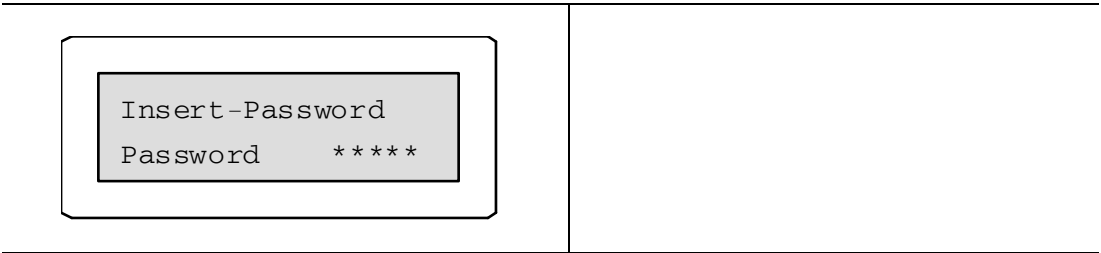


Press any button on the operator panel to stop the packaging cycle.

5.7 ACCESS TO RESERVED MENU

Press  and  simultaneously to access the reserved menu with the adjustment parameters calibrated when the machine was test inspected.

Fig. 5.7.1



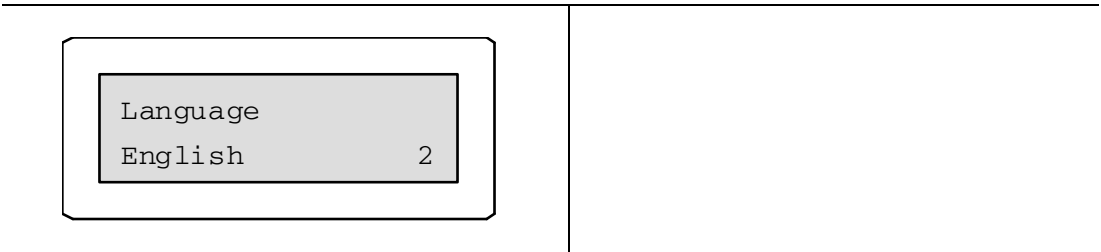
Use the password PROGR to access the selection of parameters normally adjusted at machine inspection.

To enter the password, select the letters of the alphabet with the  and  ; keys; the introduction of each character must be confirmed by pressing .

1 • Choosing display language

Menu for adjusting display language.

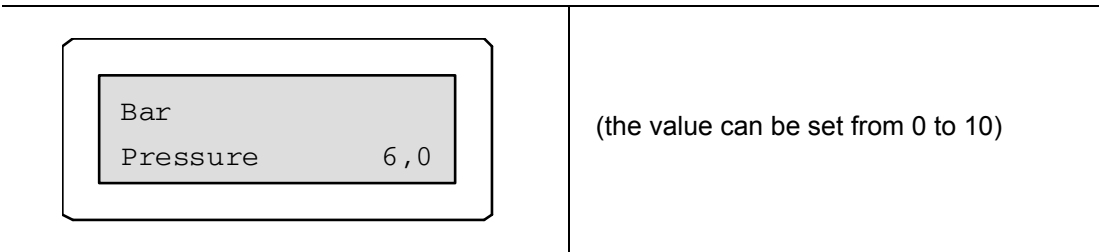
Fig. 5.7.2



2 • Pressure exerted by the sealing bar (only S560NA)

This parameter increases or decreases the sealing pressure.

Fig. 5.7.3

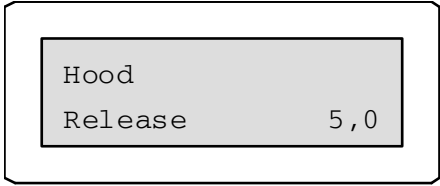




3 • Hood detachment (only S560NA)

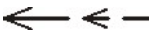
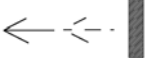
Sets when the hood must be "detached" during the shrinking phase; it prevents the film from being caught between the hood and the sealing blade, which could hinder perfect shrinkage. The parameter is only enabled when the machine runs the shrinking process.

Fig. 5.7.4

	(the value can be set from 0 to 10)
---	-------------------------------------

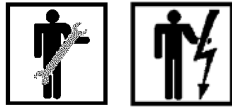
5.8 DESCRIPTION OF SYMBOLS ON DISPLAY

The following table provides an explanation of the symbols which appear on the machine operator panel display.

	Tells the operator to introduce the product to be packaged.
	Indicates a sealing process in progress.
	Indicates a shrinking process in progress.
	Indicates that the fans set for the shrinking process are active.
	Outfeed of the current pack.
	Hood closing movement.
	Hood opening movement.

CHAPTER 6 - CLEANING AND MAINTENANCE

6.1 GENERAL WARNINGS AND PRECAUTIONS



All the operations indicated in this chapter must be carried out by **qualified personnel** and with adequate personal protective equipment for the operations being performed.

Cleaning and maintenance operations must be entrusted to expert personnel who know the machine (mechanical maintenance technician and electrical maintenance technician, each according to his own field of skills).

It is recommended to:

- Use only original spare parts
- **It is prohibited to carry out maintenance, lubrication or repairs when the machine is running or powered electrically.**
- After each intervention, put back any guards which were removed, placing the machine in its initial status.
- It is forbidden to use matches, torches or open flames for lighting.
- Unauthorised personnel must remain at an appropriate distance from the machine.
- Always keep the area where maintenance is performed clean and dry. Always eliminate oil stains.
- Before any type of intervention on electrical components, make sure the power supply line has been disconnected.
- After all interventions on the electrical control board, put the guard back, securing it properly with screws before restoring power and starting machine.

Information concerning general cleaning of the machine

To optimise machine performance, it should be kept clean. In fact only when the machine is well accessible and clean is it possible to pinpoint and repair failures, to prevent malfunctioning and to work in safe conditions.

To clean the machine, use a soft cloth soaked in water. Do not use detergents or solvents that could damage the transparency of the plexiglas hood. Do not get the machine wet. Should it get wet by accident, carefully dry the machine before reconnecting it to the electric mains and resuming packaging.

ATTENTION! Wait for the machine to cool off before removing film residue and filth deposited on the hot parts.

Clean the machine more frequently when used in dusty environments, also vacuuming the dust deposited on the electronic modules inside the electrical panel.

In order to maintain ideal machine performance in time, a series of controls, checks and maintenance interventions must be carried out.

Tab. 6.1.1 - Interventions on mechanical components

Machine device	Symbol used	Operations to be carried out	Frequency of intervention
Sealing unit		Remove the film residue from the sealing blade. Clean the sealing blade with a cloth dampened with hot water, using protection gloves in order to prevent cuts and/or burns. Also use the spray supplied.	12 hours
		Make sure the cutting blade is not worn.	60 hours
		Check the state of wear of the PTFE underneath the sealing bar and replace it if necessary.	240 hours
		Check that the sealing rubber is intact.	
		Make sure the cutting blade is not worn; replace the blade if necessary.	1500 hours
		Check the tensioning of the spring.	
Tank unit		Use compressed air to remove film residue.	12 hours
Hood unit		Clean the external hood with a soft moist cloth. To clean the inside, first take off the product support mesh, removing larger residue by hand and then using the vacuum cleaner.	16 hours
Conveyor belt unit (only S560N-S560NA)		Remove any film residue with compressed air.	12 hours
		Check that all the transmission components work perfectly.	1500 hours
		Check for unwanted noise.	1500 hours
		Replace any parts that are damaged. Check the transmission belt for signs of wear.	1500 hours
Automatism unit (only S560NA)		Check the transmission belt for signs of wear.	1500 hours

Tab. 6.1.1 - Interventions on mechanical components

Cooling unit		Check the level of coolant and top up if necessary.	60 hours
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PERIODICAL CHECK OF SAFETY COMPONENTS

Some components are fundamental due to their contribution to safety and therefore they require periodical checks. These components are listed hereafter with the relative control frequency.

- | | |
|--|-----------|
| • General electric isolator | 24 months |
| • Emergency button | 12 months |
| • Indirect contact guard (equipotential protection system) | 36 months |
| • Safety contactors | 12 months |
| • Eye check of overall status of safety guards located on the machine which impair the operator from reaching moving parts | 12 months |
| • Safety micro-switches. | 12 months |
| • Hinges | 5 years |

6.2 NATURE AND FREQUENCY OF MAINTENANCE CHECKS AND INTERVENTIONS

In the manual, the description of the various maintenance operations is often associated to the symbols described below.

	Identifies an eye check on the state of wear or proper operation of a component.
	Identifies an operation for cleaning a component.
	Identifies a mechanical intervention (regulations, repairs, replacements) to be carried out on the component.
	Identifies a mechanical tensioning intervention to be carried out on the component.
	Identifies a lubrication intervention with synthetic oil.
	Identifies a lubrication intervention with grease.

6.3 REPLACING SEALING BLADE

In order to replace the sealing blade, turn off and unplug the machine and follow the instructions below:

- Unscrew the three screws 1 blocking the blade.
- Remove the worn or damaged sealing blade 2.
- Thoroughly clean the seat in which the sealing blade is positioned.
- Insert the insulating PTFE 3 inside the central clamp 4.
- Insert the new sealing blade, properly blocking it in the middle of its seat.
- Trim of the sealing blade flush with the slot of the pistons 5 and 6.
- Complete insertion of the sealing blade along the whole seat.
- Use a screwdriver to push the piston 5 all the way down towards the head of the blade so that it enters into the specific slot and then block it with the screw 1.
- Trim the PTFE protruding from the central clamp to keep it from altering sealing.
- Make sure that the sealing blade is tensioned and positioned correctly the entire length.

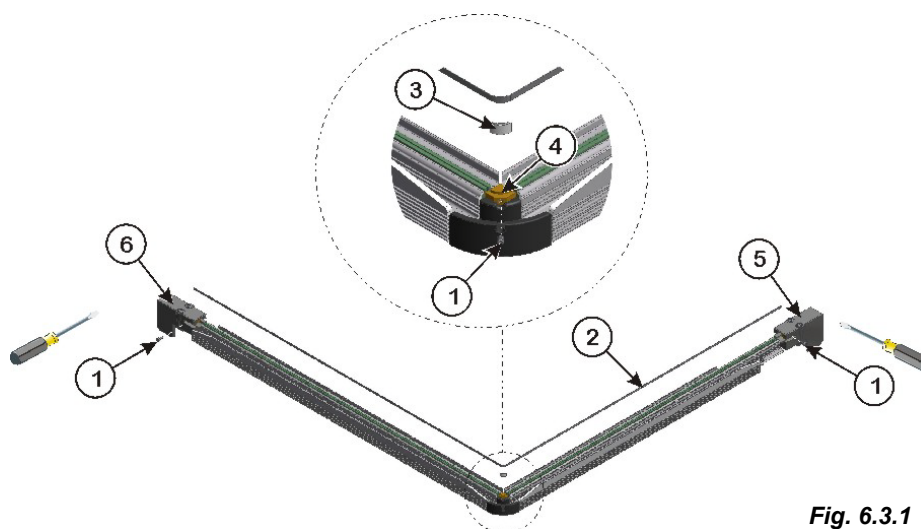


Fig. 6.3.1

6.4 REPLACING PTFE AND SILICON RUBBER

If only the PTFE needs to be replaced, proceed as follows:

- Remove the worn PTFE 1.
- Thoroughly clean the silicon rubber with detergent.
- Apply new PTFE strips above the silicon rubber making sure that the edges match.



Make sure not to touch or dirty the adhesive part of the PTFE strips while applying them.



Fig. 6.4.1

Replacing silicon rubber

- Remove the worn silicon rubber 2.
- Thoroughly clean the housing seat of the silicon rubber.
- Apply a few drops of glue or else two-sided adhesive tape on the side of the silicon rubber to be glued at the bottom of the conduit.
- Insert the new silicon rubber in line without pressing or pulling it.
- Apply the PTFE strip as indicated previously.

6.5 CHECKING THE LEVEL OF COOLANT

Periodically check that the level of coolant is between the minimum and maximum limits. If it is too low, undo the cap (1) and top up with anti-freeze liquid.

Turn off the machine and wait for it to cool down beforehand.

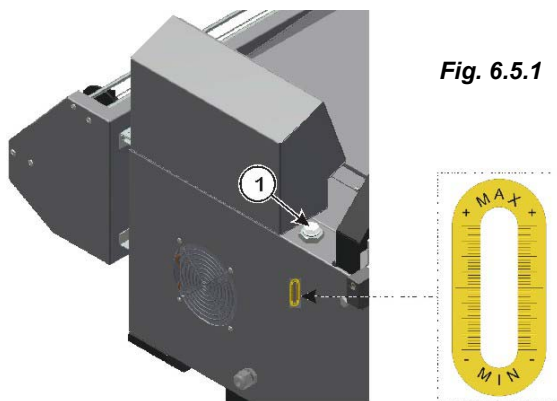


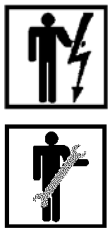
Fig. 6.5.1



6.6 ACCESS TO ELECTRICAL PANEL

If it is necessary to open the electrical panel of the machine, turn off and unplug the machine and wait at least 5 minutes before doing the following:

- Move outwards the holding plate 1 without removing it to be able to easily unscrew the screws 2 to open the protective support 3 of the electrical panel as shown in the figure.



6.7 MACHINE ACCESS AREAS FOR INSPECTIONS

To facilitate the control operations in the main components of the machine have been prepared special access areas that are described below.

- A Inspection of the keypad.
- B Inspection of the automatic mechanism that opens and closes the hood. (only S560NA)
- C Inspection of the cooling system.

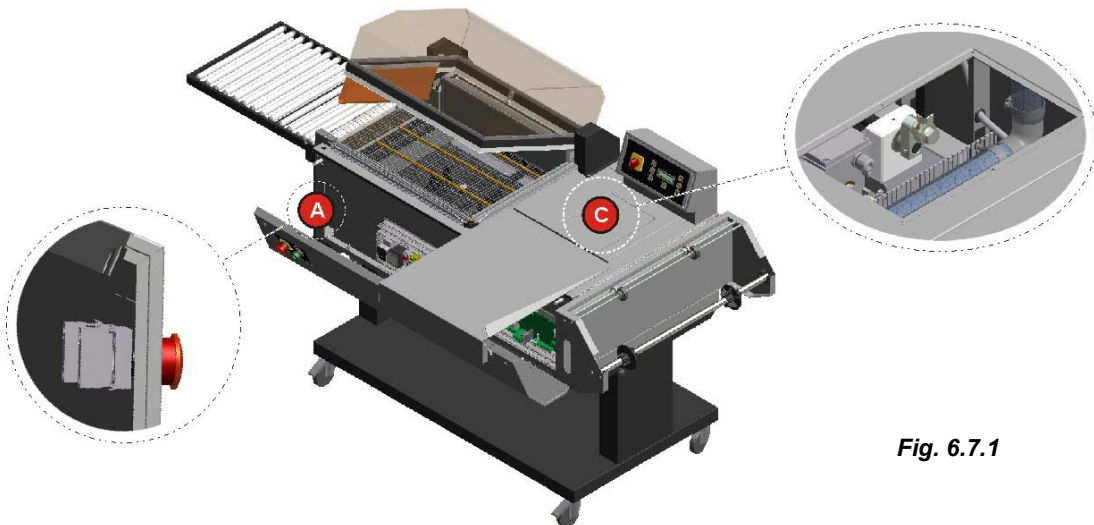
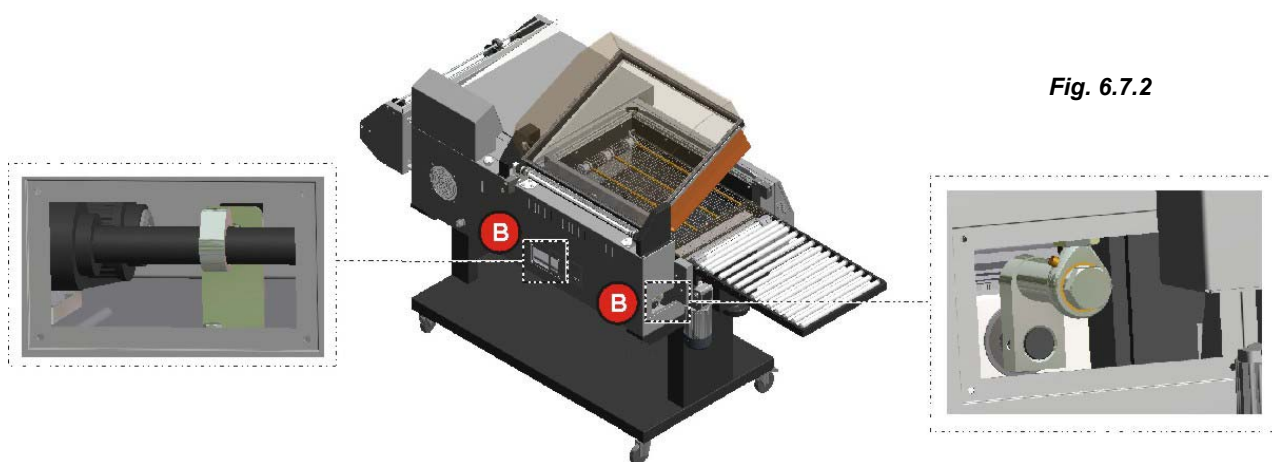


Fig. 6.7.2



CHAPTER 7 - ANOMALIES AND FAULTS - HOW TO RESOLVE

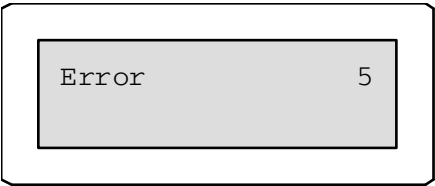
7.1 SOLUTIONS TO OPERATING PROBLEMS

The following table describes the solutions to the most common problems which can occur while the machine is operating.

PROBLEM	CAUSE	SOLUTION
PRESENCE OF SMOKE DURING SEALING	The sealing temperature is set too high.	Lower the sealing temperature.
THE MACHINE PERFORMS SEALING BUT NOT HEAT SHRINKING	Heat shrinking mode has not been selected.	Make sure that the symbol indicating that shrinking is active appears on the display
	The heat shrinking temperature is too low.	Check the temperature level on the circuit board display.
	The heating elements are in the heating up phase.	Wait for the heating elements to reach the set operating temperature.
	The fan does not work.	Probable fan motor fault.
HEAT SHRINKING IS IMPLEMENTED BUT IS NOT EVEN AND COMPLETE	The film used is unsuitable or poor quality.	Replace the film used for packaging.
	The product is too big.	See chapter 3 section "technical specifications of the product" ..
BUBBLES REMAIN AFTER HEAT SHRINKING	The film has no micro perforations.	Pass the film through the machine micro perforators.
SEALING OPENS DURING HEAT SHRINKING	The sealing blade is dirty or damaged.	Clean the sealing blade or replace it if damaged.
	The sealing value set in the "parameters menu" is incorrect.	Adjust the sealing parameter more accurately.
	Insufficient pressure is applied on the hood.	Slightly increase pressure on the hood handle during the sealing phase.
IRREGULAR SEALING	Low-quality film has been used.	Replace the film.
THE FILM IS NOT SEALED	The sealing temperature is set too low.	Increase the sealing temperature.
	The sealing blade does not receive properly.	Repair the power circuit of the sealing blade.
	The PTFE and/or silicon rubber are worn.	Replace the PTFE and/or silicon rubber
	The sealing blade is damaged.	Replace sealing blade.

7.2 ERROR AND MESSAGE DISPLAYS

This paragraph describes the messages and errors that can be viewed on the display of the operator panel with the relative solutions. These messages can be accompanied by an acoustic signal.



After the cause has been removed, the error viewed on the display can be cancelled by pressing .

PROBLEM	CAUSE	SOLUTION
ERROR 1	The thermocouple temperature is too high.	Disconnect the power cable and perform the following controls and operations: - check the connection of the thermocouple; - check operation of the thermocouple reading stage by using a type "J" operating thermocouple; - replace the heating element equipped with thermocouple if needed. If the problem continues, interrupt sealing or heat shrinking operations, disconnect the power cable and contact the assistance centre.
ERROR 2	The tunnel temperature varies abnormally.	- Make sure that the heating elements are connected correctly; - make sure that the thermocouple terminals are well tightened; - replace the heating element equipped with thermocouple. - machines equipped with a remote control switch must be verified that it works properly. If the problem continues, interrupt sealing or heat shrinking operations, disconnect the power cable and contact the assistance centre.
ERROR 3	The thermocouple temperature is unstable.	- Remove the power cable and check the thermocouple connection; - replace the heating element equipped with thermocouple; - check the earth connection. If the problem continues, interrupt sealing or heat shrinking operations, disconnect the power cable and contact the assistance centre.

PROBLEM	CAUSE	SOLUTION
ERROR 4	The heat shrinking temperature increases in sealing mode.	Disconnect the power cable and perform the following controls: - check the proper connection of the heating elements to the circuit board; - check functioning of the circuit court Attention - at times the error can be displayed while passing from the heat shrinking mode to the sealing mode. If the problem continues, interrupt sealing or heat shrinking operations, disconnect the power cable and contact the assistance center.
ERROR 5	The PCB temperature detected by the "FLEXTRON POWER BASE" module is too high.	Disconnect the power cable and perform the following controls: - Check that the air vents are obstructed; - check that the cooling fan of the "FLEXTRON POWER BASE" is working correctly. If the problem continues, disconnect the power cable and contact the assistance center.
ERROR 6	The NTC temperature of the radiator of the "FLEXTRON POWER BASE" module is too high.	Disconnect the power cable and perform the following controls: - Check that the air vents are obstructed; - check that the cooling fan of the "FLEXTRON POWER BASE" is working correctly. If the problem continues, disconnect the power cable and contact the assistance center.
ERROR 7	The NTC temperature of the inverter radiator is out of the norm.	- Make sure the cooling fan of the "FLEXTRON INVERTER" module works properly; - make sure the room temperature is < 40° C. If the problem continues, disconnect the power cable and contact the assistance center.
ERROR 8	Error in the saved data.	Turn the machine off and then on again. If this does not work, try resetting the EEPROM before contacting the assistance centre. (Warning: all saved data is lost in the event of a RESET).
ERROR 9	Error with the EEPROM. An error occurred during the saving process.	Press the "+" button and reconfigure the correct machine model. If the problem continues, disconnect the power cable and contact the assistance center.
ERROR 10	24V outputs overcurrent error.	Disconnect the power cable and check the electromagnet and make sure the connection cables are intact.

PROBLEM	CAUSE	SOLUTION
ERROR 13	Error caused by the "closed hood" micro-switch. The maximum closing time of the hood has been exceeded or the hood has not closed correctly and the micro-switch has not been pressed sufficiently.	- Check that the "closed hood" micro-switch works correctly. - Verify that the motor of the automatic opening and closing hood mechanism is connected and works correctly. - Check that the mechanical parts that lower the hood move without friction. If the problem continues, disconnect the power cable and contact the assistance center.
ERROR 14	Error caused by the "open hood" micro-switch. Error in the hood opening time.	- Check the reset switch; - check the supply of power to the "FLEXTRON POWER BASE" module; - check that the 3 LEDs on the FLEXTRON INVERTER module are turned on; - If the problem persists, replace the FLEXTRON INVERTER module or call the assistance centre.
ERROR 16	Error caused by the relay-switch.	- Check the correct connection of the emergency button and the working order of the relay-switch. If the problem continues, disconnect the power cable and contact the assistance center.
ERROR 18	1) The "open hood" and "closed hood" micro-switches have both been pressed simultaneously. 2) The start cycle micro-switch is detected to have been pressed during the descent of the hood.	- Verify that the hood opening and closing micro-switches work properly.
ERROR 80	No communication.	- Check the cable connecting the FLEXTRON MASTER board to the FLEXTRON POWER BASE module.
ERROR 97 ERROR 98 ERROR 99	One of the modules is not responding correctly.	- Check the cable connecting the FLEXTRON MASTER board to the FLEXTRON POWER BASE module; - check the "FLAT" connector of the cable connecting the "FLEXTRON INVERTER" module to the "FLEXTRON POWER BASE" module.
ERROR 100 ERROR 101 ERROR 110 ERROR 111	Error caused by the "FLEXTRON POWER BASE".	- Check the working order of the "FLEXTRON POWER BASE" module; - check the connecting cable and the connectors in particular; - replace the "FLEXTRON POWER BASE" module. If the error persists after replacing the FLEXTRON POWER BASE module, it is probable that the error was caused by the transmitter of the CPU board.
ERROR 200 ERROR 201 ERROR 210 ERROR 211	Error caused by the connection between the FLEXTRON POWER BASE and the FLEXTRON INVERTER.	- Check the connecting cable and the connectors in particular.



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