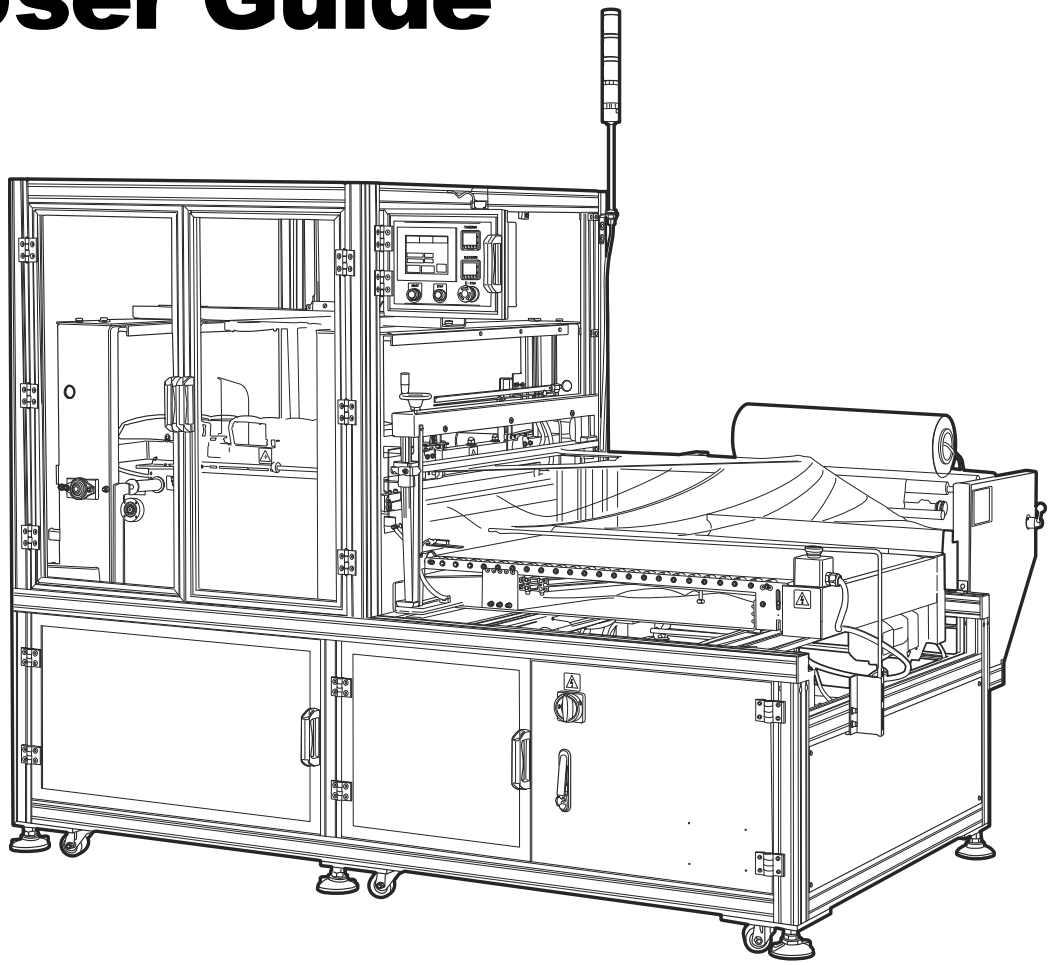
VSA

VSA2530TK-V1

Value Series
Auto L-Sealers

User Guide



EASTEY®

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User Guide

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Contents

Safety

Read this manual carefully and make it available to everyone connected with the supervision, maintenance, or operation of this machine. Additional copies are available on request (Eastey.com/contact-us).

The development of a good safety program that is rigidly enforced is absolutely imperative when involved in the operation of industrial equipment. Our machinery is well designed and includes extremely important safety features. Proper installation, safe operation, and regular maintenance and upkeep are of far greater importance than our design. Only properly-trained individuals following rigidly enforced safety rules, as recommended by ANSI and OSHA should be allowed to operate these machines.

Be very careful when operating, adjusting, or servicing this equipment. If in doubt, stop and obtain qualified help before proceeding.

General Safety Precautions

Before installing, operating or servicing this equipment, please read the following precautions carefully:

- Always disconnect electrical power before attempting maintenance for any electrical or moving parts. Do not place hands, head, or any part of the body inside the confines of the machine unless the mechanism is securely fastened and the electrical supply is shut off.

- Do not tamper with electrical wiring. Use only the specified power-supply cable. Use only licensed electricians to check or repair electrical wiring.

- In order to prevent damage to the machinery or injury to personnel, do not increase the factory settings on either the electrical or mechanical overload safety devices. Do not operate a machine if such modifications have been made.

- Keep hands away from moving conveyors and moving parts. Conveyor belts that have become worn or frayed can be hazardous and should be replaced promptly.

- Never operate this or any moving equipment without all covers and guards in place. The internal mechanism of most packaging machinery contains numerous shear, pinch, and in-running nip points, many of which are capable of causing severe injury and permanent disfiguration.

- To minimize the potential for personal injury, always be sure that the machine operators and others working on the machinery are properly trained in the correct

usage of the equipment and properly instructed regarding the safety procedures for operation.

- Heat sealing arms and jaws on packaging machinery can become very hot after a period of use. Keep hands away while in operation and use caution if the machine has been running recently. If optional cutting blades have been installed, these can be very sharp. Exercise caution.

- Do not make any modifications to either the electrical circuitry or the mechanical assemblies of this machinery. Such modifications may introduce hazards that would not otherwise be associated with this machinery. Eastey will not be responsible for any consequences resulting from such unauthorized modification. Do not operate a machine if any modification has been made

- This equipment is designed for indoor operation in a typical clean, dry factory environment. Do not operate the machine in any extremely wet or oily environment that may exceed operating specifications.

- The use of certain types of plastic films in sealing and/or shrink-wrapping equipment may result in the release of hazardous fumes due to degradation of the film at high temperatures. Before using any plastic film in this equipment, the manufacturer or supplier of the film should be contacted for specific information concerning the potential release of hazardous fumes. Adequate ventilation should be provided at all times.

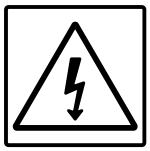
- Keep combustible materials away from this equipment. The equipment may be a source of ignition.

- Do not wear loose clothing such as ties, scarves, jewelry, etc. Long hair should be pulled back and/or covered while operating this machine.

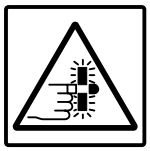
Explanation of Symbols

Caution sign or Safety Alert symbol. Indicates caution, be alert, Your safety is involved. Knowledge of safe operation is required.

Ground symbol. Indicates ground. Use Class-3 (lower than 1000) cable to ground to earth. Incomplete grounding may lead to electrical shock.



Electrical hazard. Indicates electrical danger. Only a trained electrician can uncover the electrical panel or box.



Cut or shear hazard. Do not place your hands or any object on the sealing or cutting zone at any time. Shut down the machine before performing maintenance, parts replacement, or troubleshooting in these zones.

Pinch hazard. Do not place your hands or any object on the moving mechanism. Shut down the machine before performing maintenance, repair, or adjustment.

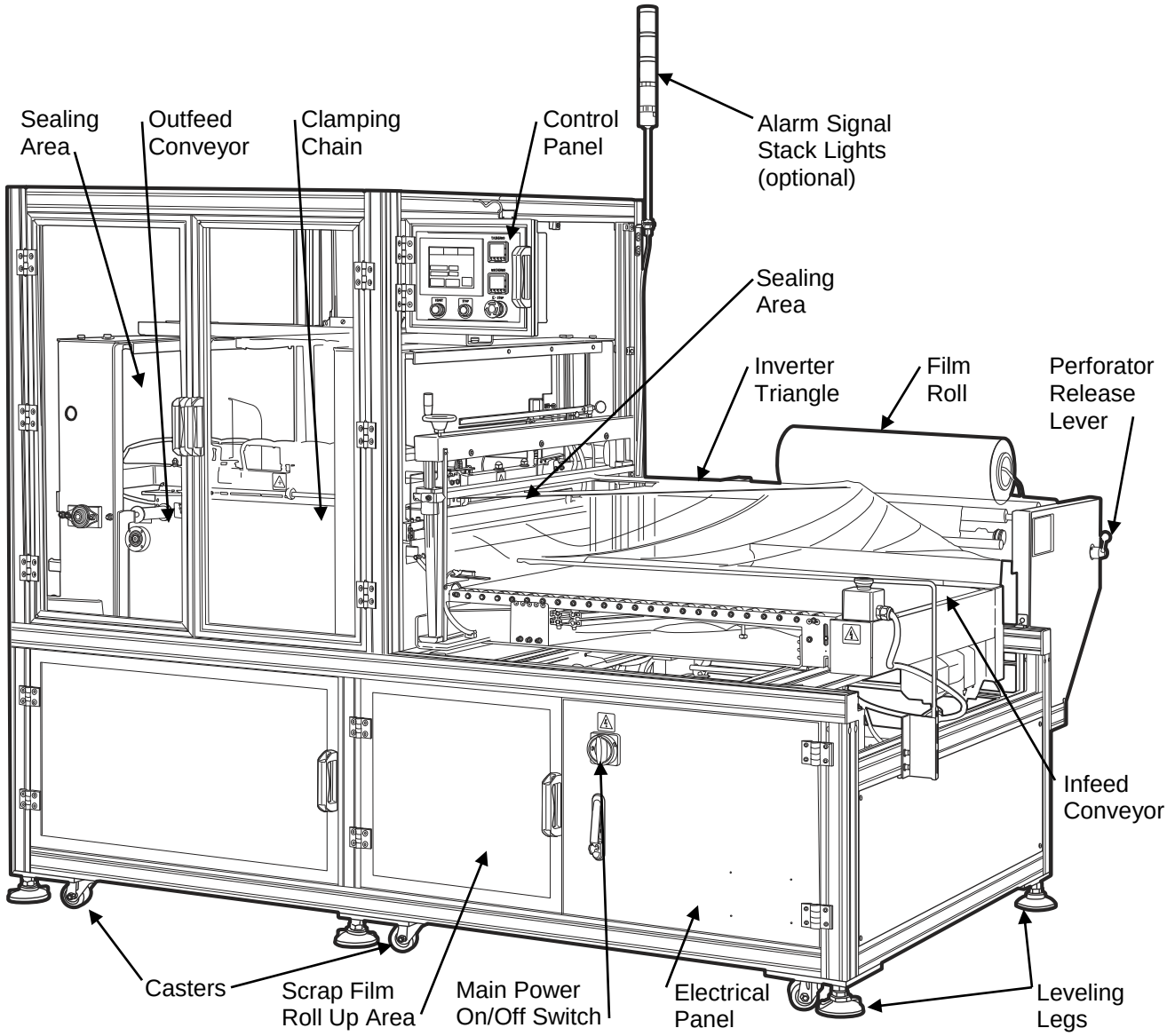
Crush hazard. Do not place your hands or any object on the moving mechanism. Shut down the machine before doing any maintenance, repair, or adjustment.

High temperature hazard. Do not touch or place hands close to the heating source to avoid burns. Proceed with any maintenance only when the temperature of the heater or other heat source has cooled down to room temperature.

Moisture hazard. Keep equipment dry. This equipment is designed for indoor operation in a typical clean, dry factory environment, protected from rain and moisture. Do not operate the machine in any extremely wet or oily environment that may exceed operating specifications.

Introduction

General System Description



Specifications

Model Number	Seal Dimensions		Machine Dimensions			Standard Power			Net	Shipping
	Front (F)	Side (S)	Width (A)	Height (B)	Length (C)	Volts	Amps	Phase	Weight	Weight
VSA2530-TKV1	25 in. 63.5 cm	30 in. 76 cm	71 in. 181 cm	69 in. 175 cm	95 in. 242 cm	220	20	1	1100 lbs. 498 kg.	1200 lbs. 544 kg

Explanation of Model Numbers

- VSA = Value Series Automated Eastey L-sealer.
- 25 — First two digits indicate length of sidebar or nominal maximum length of side seal in inches: 25 inches.
- 30 — Remaining two digits indicate length of front bar or nominal maximum length of front seal in inches: 30 inches.
- T = Takeaway conveyor — Value Series L-Sealers are typically equipped with a takeaway conveyor.
- K = Knife — Indicates hot knife seal bar. The hot knife seal bar is standard.
- V1, V5 = Voltage and Phase. V1 = 220VAC single phase is standard; V5 = 480VAC single phase is optional.

Voltage and Phase Designator Meaning

Standard

Voltage / Phase Designator	Volts	Phase
V1	220	1

Optional

Voltage / Phase Designator	Volts	Phase
V5	480	1

Standard features

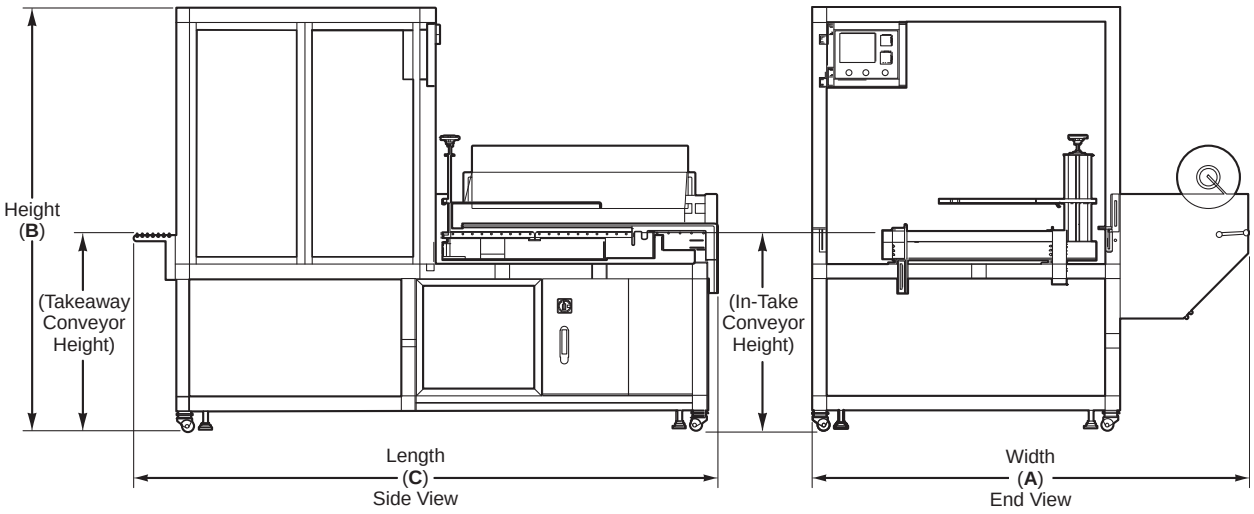
- Designed to seal most polyolefin, polyethylene, and PVC shrink films
- All aluminum extrusion main frame
- Normal speed infeed and outfeed conveyors
- High speed with product indexing
- Motorized seal height adjustment for various product sizes
- Seal head equipped with pneumatic air cylinder for automatic sealing
- Hot knife seal bar for consistent and clean seal
- Consistent pressure across seal bar
- Automatic cycle timing with adjustable dwell time
- HMI controller is a color touch-sensitive screen with simple menus for easy operation
- Film tracking wheels keep film in place
- Multiple pin perforator provides precise air evacuation
- Heavy duty casters for transportation within plant
- Leveling legs provide a sturdy base once in place

- VSA2530 features a 25"W × 30"L seal area
- Scrap unwind automatically wraps up the scrap film left from the sealer
- Easy to use design requires minimal training and maintenance
- VSA2530 maximum film width up to 25"
- Maximum film roll O.D. up to 12"
- 80 PSI
- 220V Single Phase is Standard; 480V Single Phase Option is Available

Dimensions

See Machine Dimensions in Specifications table for overall machine width, height, and length.

VSA2530



Unpacking

Thoroughly inspect the equipment and packaging immediately on arrival.

Carefully remove the outer protective shipping wrapper. Inspect the machine for any damage that may have occurred during transit. If goods are received short or in damaged condition, it is important that you notify the carrier's driver before they leave your company and insist on a notation of the loss or damage across the bill of lading. Otherwise no claim can be enforced against the transportation company. Please note that a copy of this document is attached to the outside of every crate.

If concealed loss or damage is discovered, notify your carrier at once and request, **insist**, on an inspection. This is absolutely necessary. A concealed damage report must be made within ten (10) days of delivery of shipment.

Unless you do this, the carrier will not entertain any claim for loss or damage. The agent will make an inspection and grant a concealed damage notation. If you give the transportation company a clear receipt for the goods that have been damaged or lost in transit, you do so at your own risk and expense.

All claims must be filled within **five** (**5**) months of the delivery date or the carrier will not accept them.

We are willing to assist you in every reasonable manner to help you collect claims for loss or damage. However, this willingness on Eastey's part does not make Eastey or its parent or related companies responsible for collections or claims or replacement of equipment damaged or lost in transit.

Loading and Unloading Instructions

- ☐ The machine is fully crated on pallets.
- ☐ Use a forklift with adequate capacity to lift the machine from the pallet. (Forklift extensions may be required to repack equipment.)

Installation

Lift the machine up and off of the shipping pallet.

CAUTION! **The VSA series L-sealer is heavy and will require a forklift, floor crane, or several people to move safely off the shipping pallet. Use proper equipment when lifting the L-sealer and ensure it is secure and will not shift while being moved off the shipping pallet.**

Place the sealer in the desired location with the required electrical power source available. (See power requirements for the specific model in the Specifications table.) Make sure the electrical wiring is adequate to provide the required voltage. If the voltage provided is too low, the equipment will not operate correctly.
Selecting the proper location is one of the most important considerations for initial setup. When selecting the location, take into consideration the following factors.

1. Adequate power supply nearby?
2. Where is the sealer in relation to the power source?
3. Where is the sealer in relation to the tunnel and any conveyor(s) necessary to move the wrapped product? (Alignment with packaging line.)
4. Convenience for the operator.

If there is any doubt, get qualified assistance with your initial installation.

Location Requirements

When installing the L-sealer please be aware of the following considerations:

1. The surface on which it is located is flat and level.
2. Conveyor or packing table height.
3. Alignment with packaging line.

When the L-sealer is positioned in the operating location you will need access to:

1. Control panel switches: On/Off switch, dwell timer, conveyor timer.
2. Height and width adjustments.
3. Film unwinder.

For units equipped with a takeaway conveyor at the exit of the L-sealer, provision should be made for exiting packages. For example, a table or bin where packages that have been sealed will be placed until they can be picked up, or a conveyor that will move them to the tunnel.

If the L-sealer is part of a longer packaging line, take into consideration the table and conveyor height in relation to adjacent machinery.

The machine should be placed on a flat, level floor so that it does not rock or move. We recommend that the machine be securely locked in place when used.

Set up the L-sealer and move it to its location. The casters allow easy movement over smooth flat surfaces. If you need to lift the unit to move it, you will need to use a pallet jack, floor crane, or fork lift to move it to its location.

CAUTION! If the L-sealer must be lifted for moving, use proper equipment when lifting and moving it to ensure it is secure and will not shift.

When the L-sealer has been moved to its location, use the levers on the casters to lock the wheels to prevent rolling and keep the unit in place. A power cord (with optional electrical plug) should be installed by a licensed electrician.

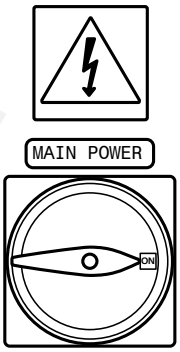
CAUTION! Before operating, ensure the following.

1. **All shipping ties are removed.**
2. **All personnel are clear of the equipment.**
3. **Electrician has stated that all electrical work is complete.**
4. **Adjust all controls according to the settings sheet.**

Refer to instructions in the Operation section for instructions to power up or shut down the machine.

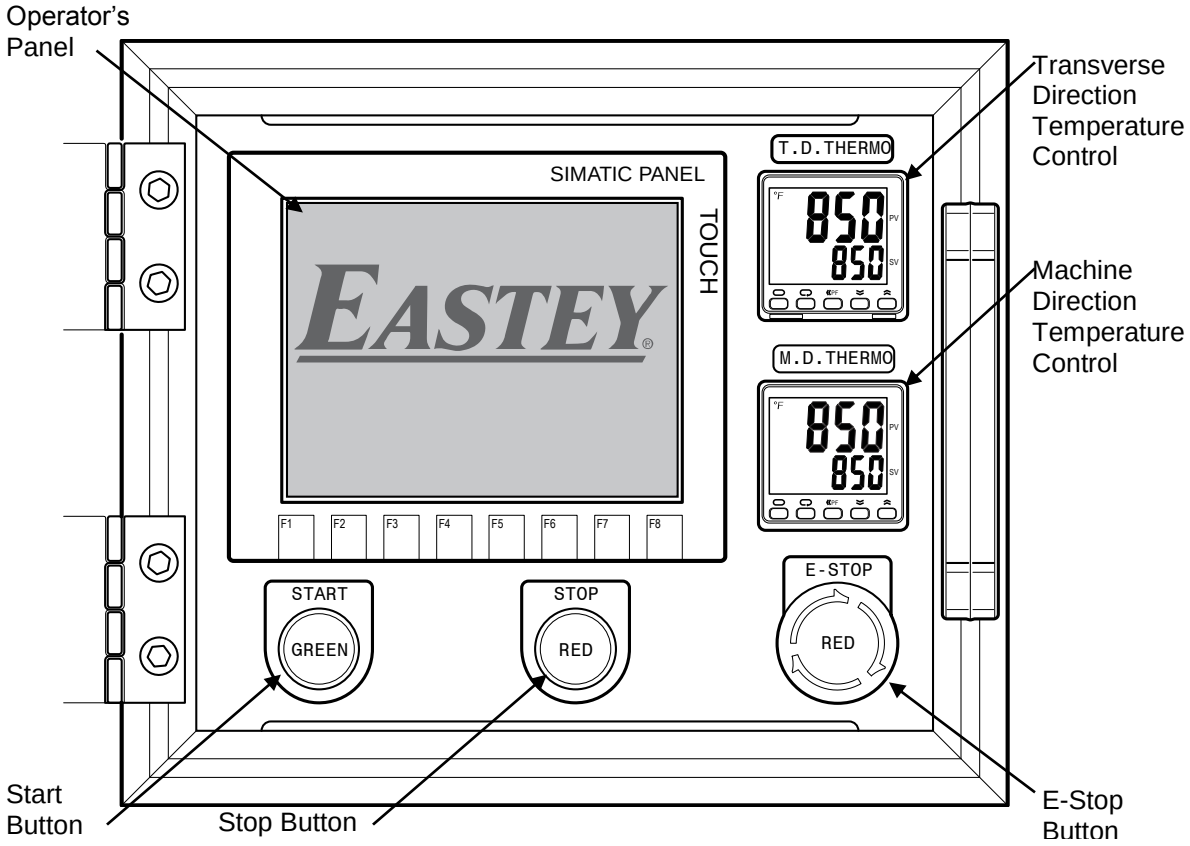
Operation

The main power switch is located on the door to the electrical panel, which is under the product intake conveyor and film inverter.



Control Panel

Controls other than the main power switch for the L-Sealer are located on the hinged control panel attached to the sealing area enclosure, near the top and center of the machine.



Operator's Panel — The operator's panel is a fully functional color touch screen. A technical name used for this is the Human Machine Interface (HMI) It displays current status information and displays buttons for configuring and controlling the system and obtaining system messages and status information. More detail about using the Operator's Panel is explained in the following pages.

T.D. Thermo — Temperature controller for the L-Sealer heat element that is aligned cross-wise or **transverse** to the Machine Direction. More specific information about setting the T.D. temperature controller is provided in the pages following explanation of use of the Operator's Panel.

M.D. Thermo — Temperature controller for the L-Sealer heat element that is aligned with the Machine Direction (M.D.). More specific information about setting the M.D. temperature controller is provided in the pages following explanation of use of the Operator's Panel.

Start — Green light indicates the machine is powered on and ready for operation or operating. Press to start automatic operation once operating parameters have been defined using the Operator's Panel.

Stop — Press the Red button to stop automatic sealing in a normal non-emergency situation. The Red Stop button illuminates red indicates automatic sealing has been stopped.

E-Stop Button — In the event of an emergency, press in the large red mushroom shaped E-Stop button. This brings the system to a halt in a way to avoid damage or excessive film waste. In addition to the E-Stop on the Control Panel, there is also an E-Stop at the outer corner of the machine at the Infeed end of the machine. To return the machine back to normal operation, turn the activated E-Stop button so both E-Stops are out, and then press the green Start button.

Main Power Switch — Use to turn main power to the automatic L-sealer on or off.

CAUTION! When the power is turned on be aware of sealer hot surfaces and moving belts and rollers.

Other Features

Film Unwinder — The film unwinder is located behind the product infeed conveyor and film separator/inverter area, behind and to the right of the L-sealer enclosure.

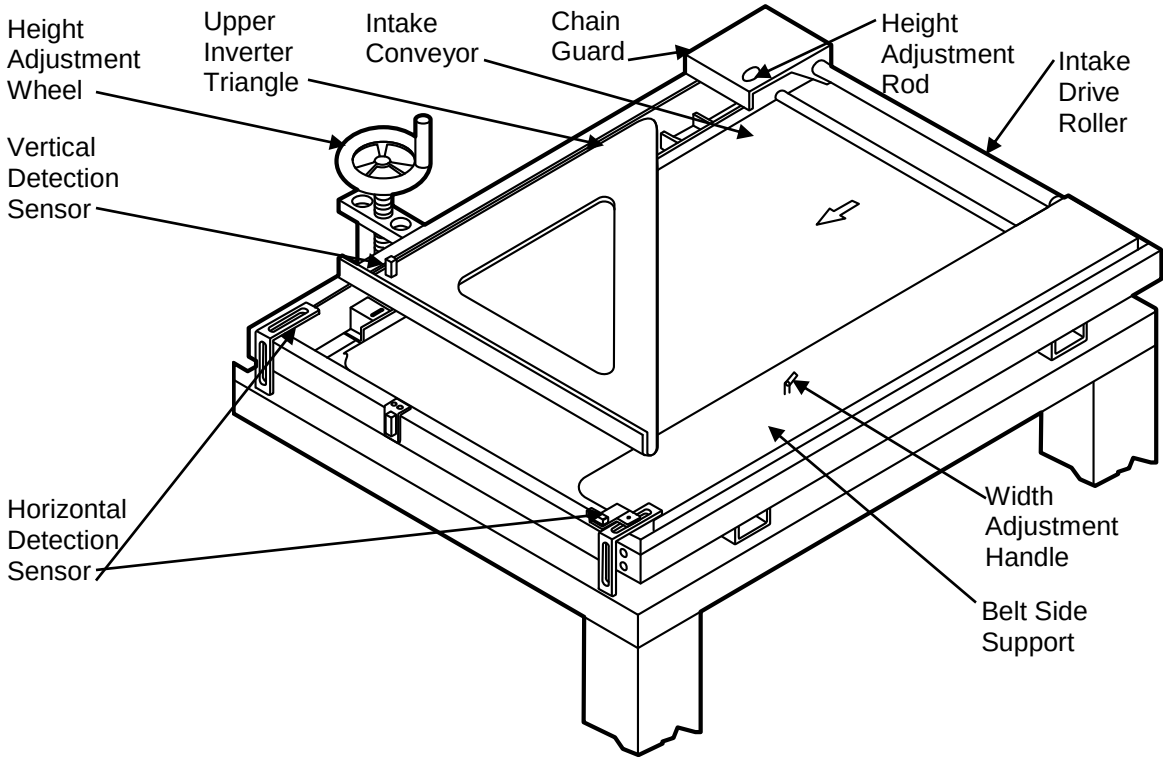
Pin Perforator — The pin perforator is inside the film unwinder. The Pin Perforator is synchronized with the film during normal operation. It creates holes in the film (To allow air to escape during shrinking). The lever on the outside of the Film Unwind at the rear of the infeed end is the Perforator Release Lever.

Perforator Release Lever — The Perforator Release Lever allows the perforator to be disengaged temporarily when necessary to allow the film to be threaded.

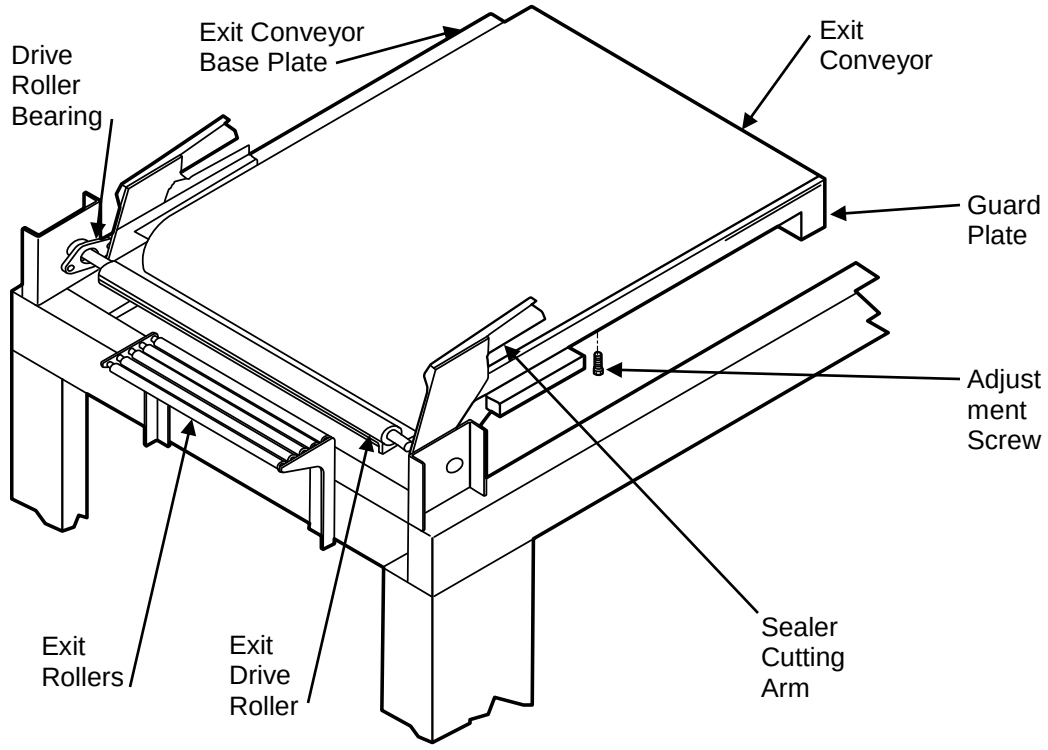
Infeed Conveyor — The infeed conveyor is used to facilitate insertion of the product between the bottom and top layers of film and transport the product into the seal area.

Width and Height Adjustment — The infeed conveyor is adjustable for width to achieve proper placement of the total width of the package, thereby allowing the product to be placed precisely in the seal area and film each time. Infeed film height adjustment allows the height of the upper film inverter triangle to be changed for differing heights of product.

Intake Area Components



Sealing Area and Exit Conveyor Components

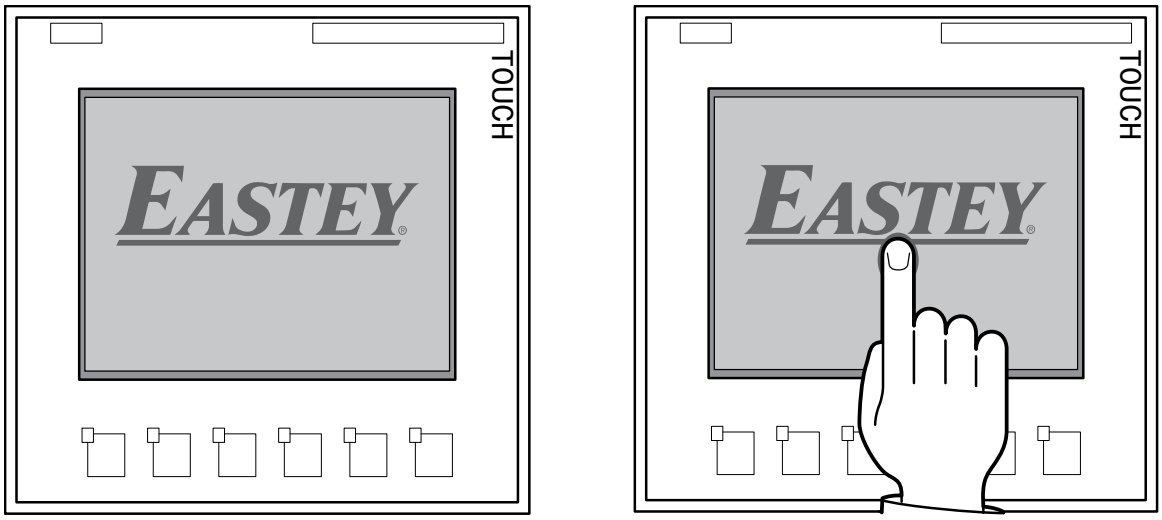


Operator's Panel

As the machine starts up, it will display information on the Operator's Panel such as the current operating system version and will display a graphical progress indicator as the operating system loads. The Operator's Panel screen may appear blank momentarily and then eventually display the Eastey company name.

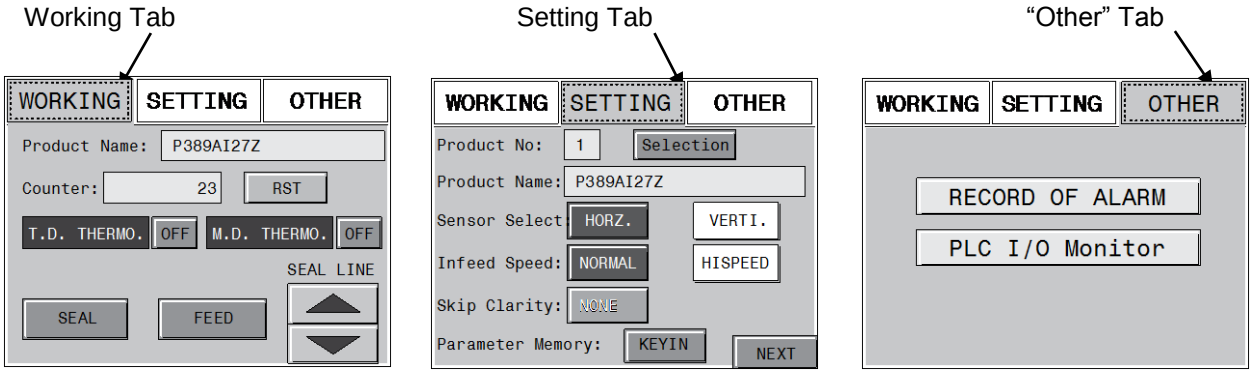
When the Operator's Panel displays the Eastey company name, touch the screen anywhere within the large rectangle with your finger.

Note: **The sensitivity of the screen is such that your finger needs to be in contact with the screen for a fraction of a second longer than just a quick tap. If you tap the screen too quickly, the touch screen sensor may not sense or respond to it.**



Using the Touch Panel Interface

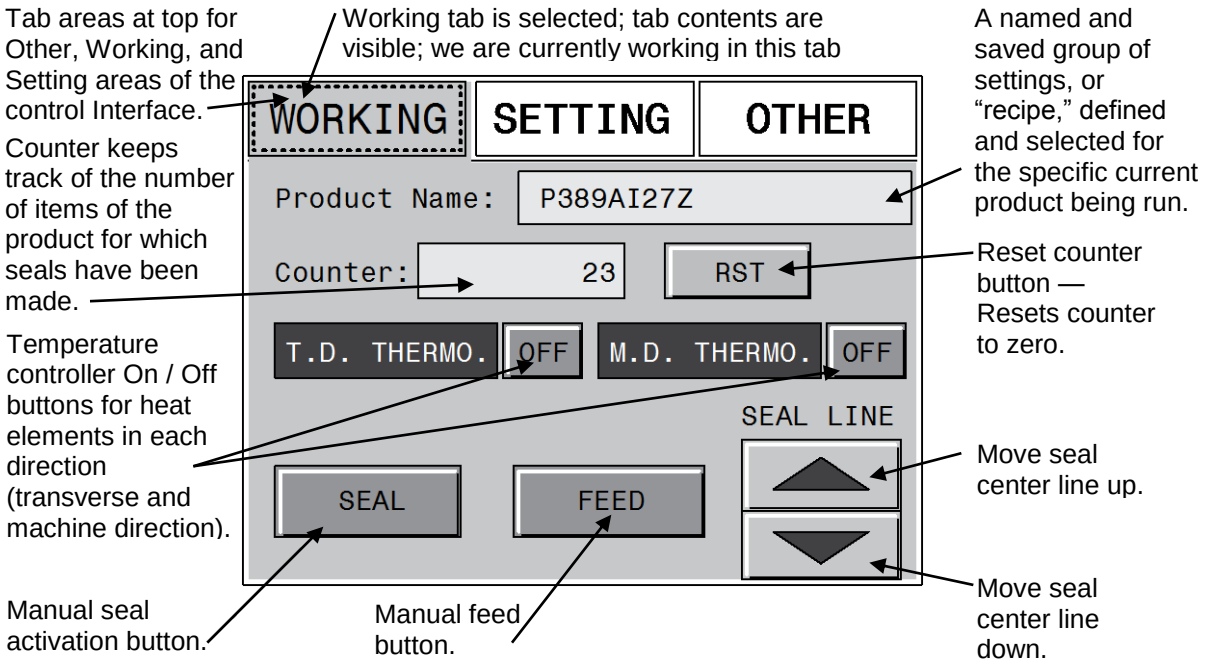
Once you have touched the Eastey screen, the touch panel will display the tabbed interface and you will be able to work with the tabbed interface of the Operator's Panel.



The touch panel interface is organized into three tabbed pages labeled: Other, Working, and Settings. To view or enter information in any of the tabs, touch the tab label area with your finger.

Working Tab

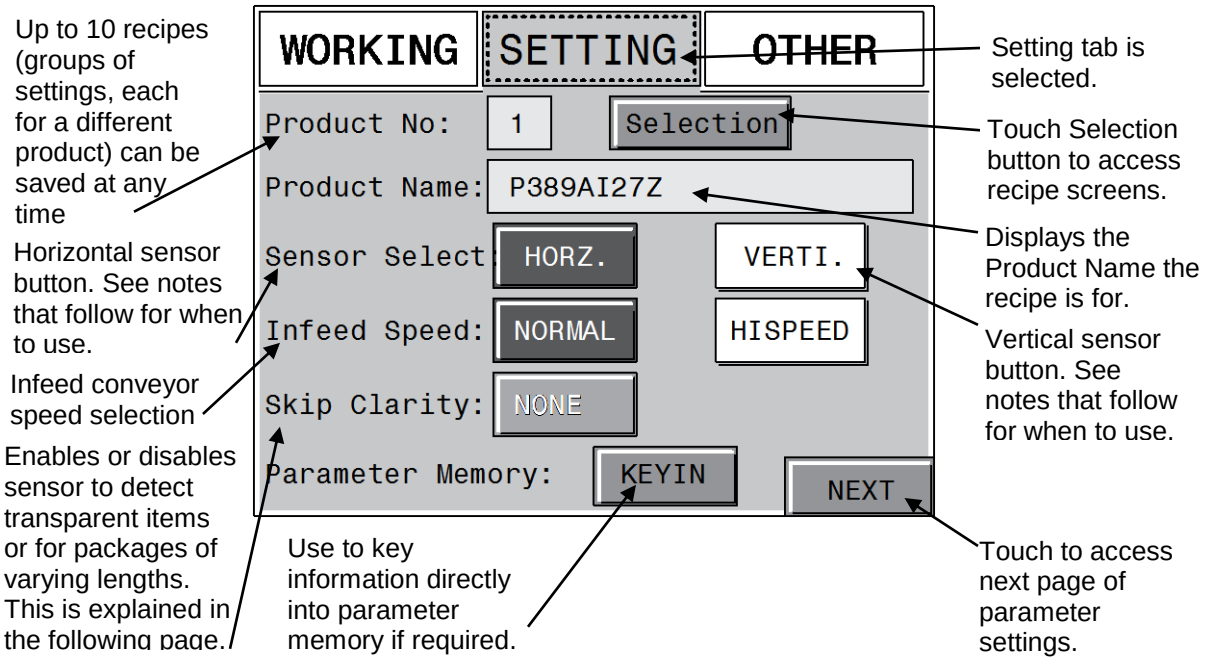
The Working tab is normally active during normal operation. (If not, you can view it by touching the tab label, Working, on the touch screen.)



The Working tab shows the name of the product currently being run, and a running counter of the number of units that have been sealed using the current product settings or recipe. Buttons on the screen allow you immediate actions, such as to reset the counter, and override certain functions. For example, to manually feed the product and to seal it manually.

Setting Tab

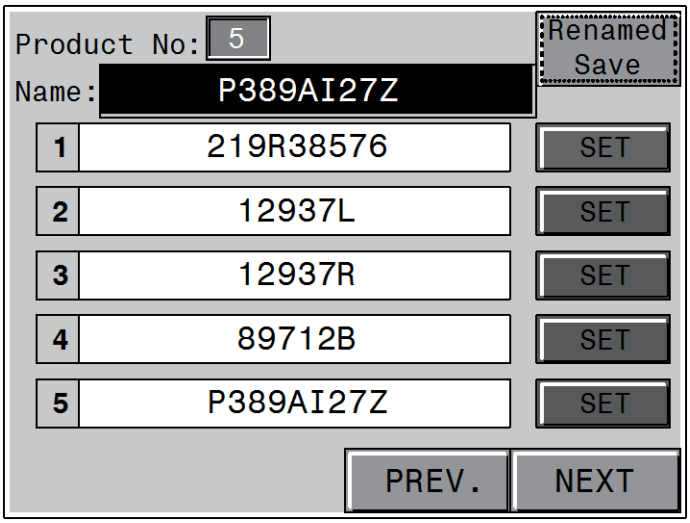
Touch the screen in the Setting tab to view and work with settings. The Setting tab allows you to view or set up parameters for products for semi-automatic operation.



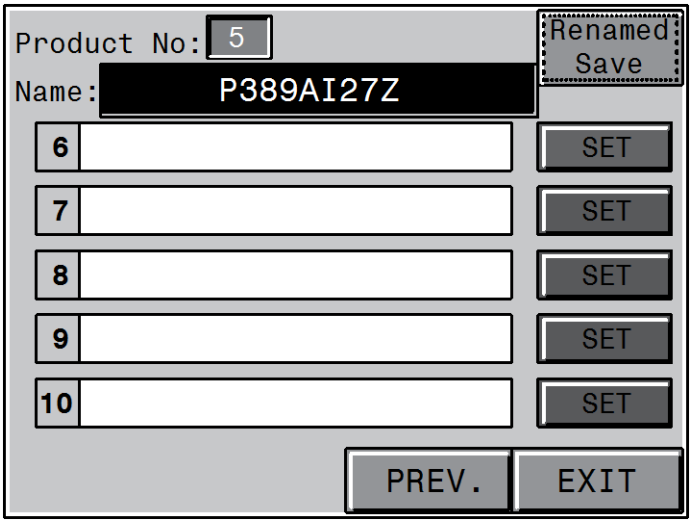
To Create, Name, and Save a Recipe

Settings define sealing requirements determined by shape and size of a product and are called a recipe. Up to 10 recipes can be defined and saved at any time and are indexed as indicated by Product Number. A Product Name can be given to each recipe for convenience of quick reference.

1. If the content of the Setting tab is not already visible, touch the Setting tab label at the upper right of the Operator's Panel screen to access the Setting tab.
2. Touch the Selection button to access the Recipe screen. (Combined, the two pages of the Recipe screen allow you to name, define, and save up to ten recipes at a time.)



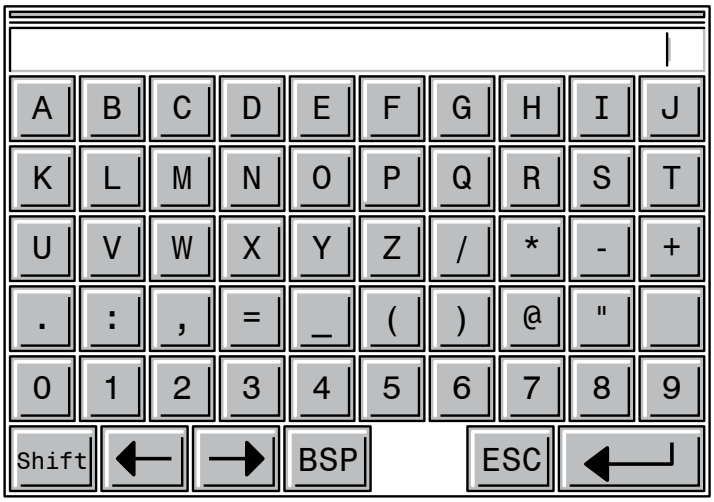
If you want to work with one of the first five recipes (Product No. 1 through 5), work in the first Recipe screen. To work with recipes six through ten (Product No. 6 through 10), touch Next at the bottom of the screen. (In each screen, touching the Prev. button allows you to return to the previous screen.)



3. Next to each rectangle for a Product Name is a Set button. Touch the Set button that is in the same Product Number row that you wish to define and name, keep your finger in contact for approximately two seconds and the Product No. at the top of the screen will display the number for the row you selected. If the Recipe has been given a name, the name appears in the Name field.

Enter a Product Name

4. Touch anywhere in the Name field, and an on-screen keypad window appears for typing in text for the Product Name.

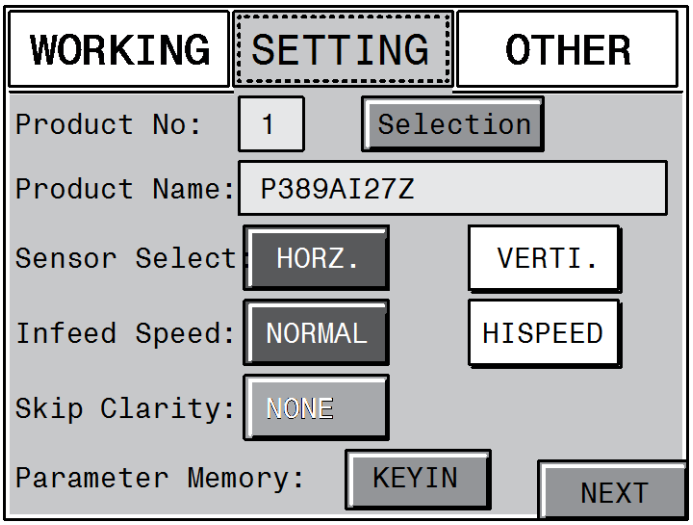


5. Type the Product Name to give to the recipe. When you have finished typing, Press the Enter key (⏎) to enter the name and close the keypad window and return to the Recipe screen.
6. Touch and hold Renamed Save for approximately two seconds to save the Product Name.

   The Product Name should now display as you entered it and the Product Number should correspond to the Product Number you selected.

Set Machine Functionality — Sensor Input, Infeed Speed, and Skip Clarity.

7. Touch the Prev. button (at the bottom of the Recipe screen) to return to the Setting tab.



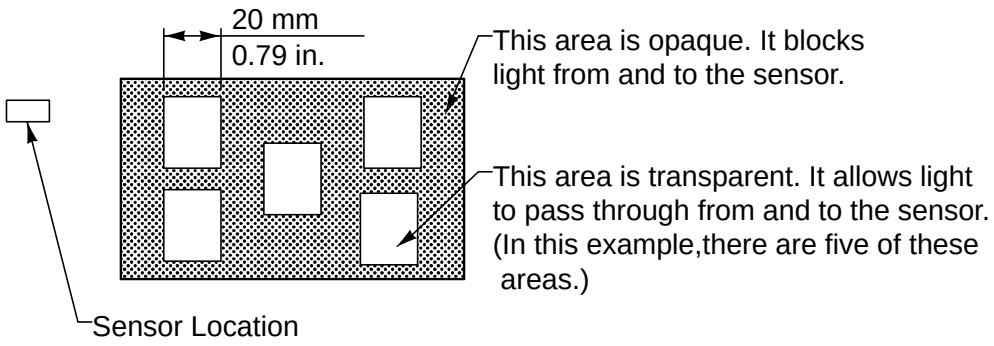
8. Select the input sensor photo eye to be used, whether Horizontal or Vertical, by touching the corresponding button in the Sensor Select row.
9. Select the Infeed Speed to be used, whether Normal or High Speed, by touching the corresponding button in the Infeed Speed row.
10. Touch the Skip Clarity button (for detection of transparent items, items with holes through, or items with varying sizes or shapes) to access the Machine Timer settings for Skip Clarity: Seal Time, Conveyor Advance, Conveyor Stop, and Skip Timer.

Skip Clarity

Skip Clarity applies in special conditions for:

1. Package items with holes or transparent items that will not be detected by the sensor.
2. Package items with varying sizes or irregular shapes.

Example 1: Consider a package item that has holes or transparent areas where light from the sensor can shine through like the following illustration.



Considering a conveyor speed of forty centimeters per second (40 cm/sec.) the following table shows the distance the item will travel in one second, a tenth of a second, and a hundredth of a second.

Time	1 sec.	0.1 sec.	0.01 sec.
Travel Distance	400 mm	40 mm	4 mm

For the item shown above, to ignore the 20 mm space will require 0.05 sec (half of the 0.1 sec. 40 mm distance, or five times the 0.01 sec. 4 mm distance).

Note: **The above calculation is based on conveyor speed with no load. Weight of actual items will place a load on the conveyor that will likely slow the conveyor. Some trial-and-adjustment will likely be required to obtain the required conveyor speed.**

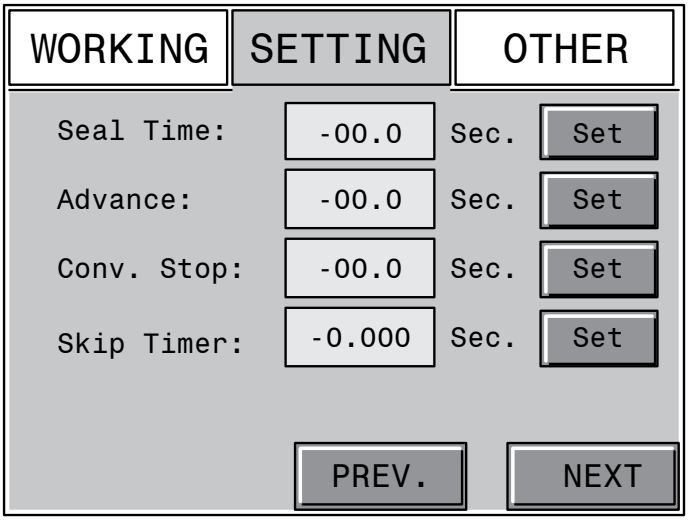
Example 2: Irregular shape package items such as for meats or vegetables, etc., result from varying shapes and sizes of items and in some cases random orientation of the items they contain. These packages present a challenge because the sensor may have difficulty detecting them.

For these items, observe the required timing for the space before and after an item. The space between consecutive items must be longer than the transparent space within any item (see the previous example). Enter required values for Advance Time, Conveyor Time, and if applicable, the Skip Time in the fields provided.

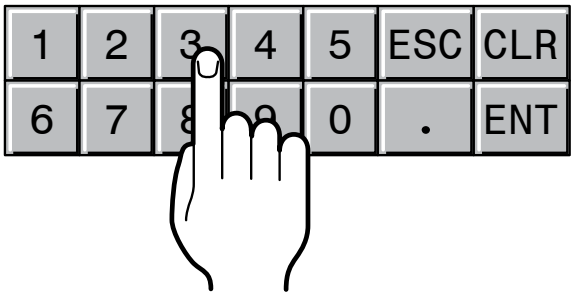
Advance Time + Conveyor Stop > Skip Timer.
Set Skip Timer = 0 when the Skip Clarity function is not used.

The timing of space between to items must be longer than the Skip timing or the sensor will detect items wrong.

Set Machine Timers — Seal Time, Advance, Conveyor Stop, and Skip Timer.



11. Touch the rectangle for Seal Time to enter time in seconds for the seal timer.



Because only numbers and a decimal point are acceptable input, a numerical keypad appears. Touch the buttons required to enter a decimal number for the seconds. Acceptable values are 0.1 to 5.0, in tenths of a second increments. Touch the Enter button when you have finished.

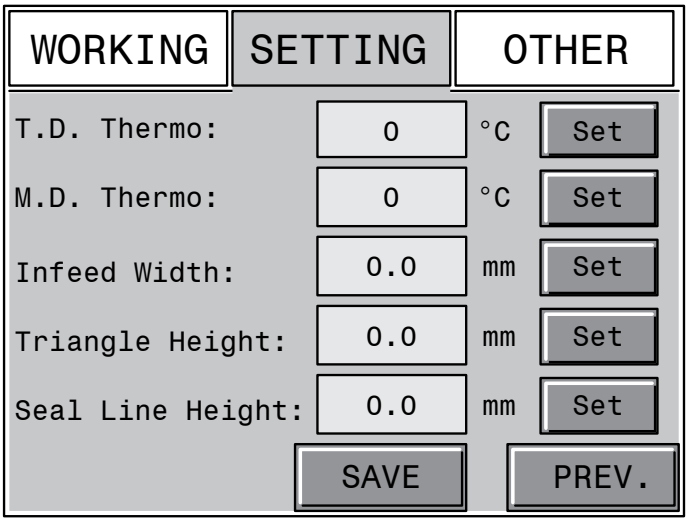
12. Touch the rectangle for Advance to enter the time in seconds for the film advance timer. Acceptable values are 0.0 to 5.0, in tenths of a second increments.

13. Touch the rectangle for Conveyor Stop to enter the time in seconds for the conveyor stop timer. Acceptable values are 0.1 to 5.0, in tenths of a second increments.

14. Touch the rectangle for Skip Timer to enter the time in seconds for the sensor skip timer. Acceptable values are 0.1 to 5.0, in tenths of a second increments.

Set Temperatures and Machine Distance Settings — Heat Elements, Transverse Direction and Machine Direction, Infeed Conveyor Width, Film Inverter Triangle Height, and Seal Line Height.

15. Touch the Next button (at the bottom) to access the Temperatures and Machine Distance settings.



16. Touch the rectangle for T.D. Thermo to set the temperature (in Celsius) for the sealer heating element that is oriented transverse to the main axis of the machine. Enter the value using the numeric keypad that appears and touch the Enter button when finished.

17. Touch the rectangle for M.D. Thermo to set the temperature (in Celsius) for the sealer heating element that is oriented parallel to the main axis of the machine. Enter the value using the numeric keypad that appears and touch the Enter button when finished.

18. Touch the rectangle for Infeed Width to enter the width setting (in millimeters, with precision of tenths of a millimeter) for the infeed conveyor. Touch Enter on the on-screen numeric keypad when finished entering the number.

19. Touch the rectangle for Triangle Height to enter the height setting (in millimeters, with precision of tenths of a millimeter) for the inverter triangle height. Touch Enter on the on-screen numeric keypad when finished entering the number.

20. Touch the rectangle for Seal Line Height to enter the height setting (in millimeters with precision of tenths of a millimeter) for the seal centerline height. Touch Enter on the on-screen numeric keypad when finished entering the number.

21. After all values have been entered, touch the Prev. button to return to the previous screen. Touch the Prev. button at the bottom of the screen to return to the Recipes screen. Touch the Prev. button at the bottom of the screen to return to the Setting tab.

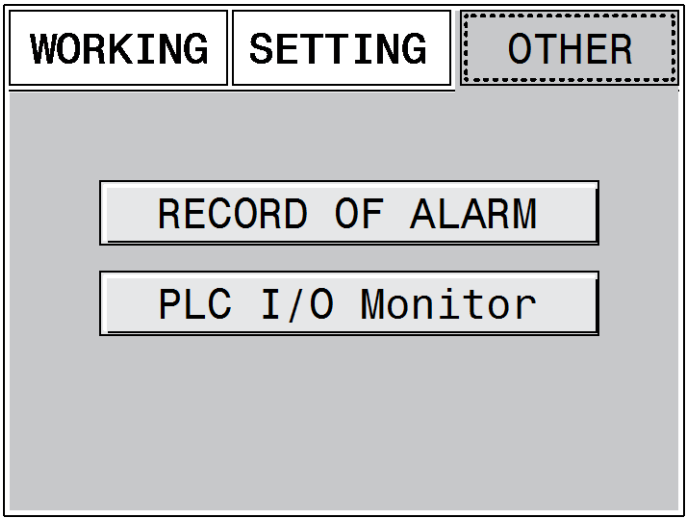
22. In the Setting tab, touch the Selection button. In the Recipe screen, with the recipe indicated by Product Number and Name at the top of the screen, touch the Renamed Save button and hold it for approximately two seconds to save the recipe settings.

This completes the instructions to Create, Name, and Save a Recipe.

Note: **A possible limitation of the PLC is that it may reliably save groups of memory up to 10,000 times. After saving memory more than 10,000 times, the PLC memory may become unreliable. Use care when saving information.**

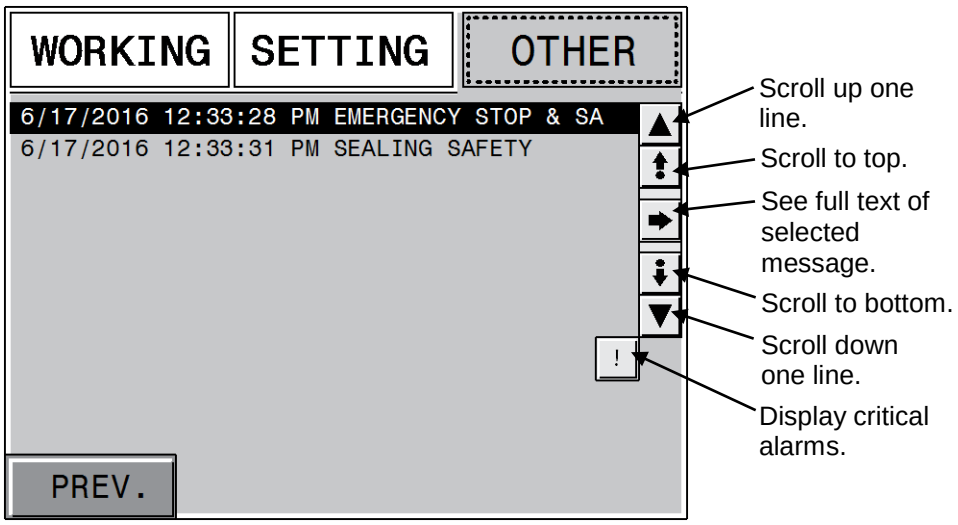
Other Tab

The remaining tab is labeled Other. This tab contains two buttons for general monitoring and troubleshooting of the system. These buttons allow you to view a log of system alarms, or view a log of I/O messages from the system PLC.



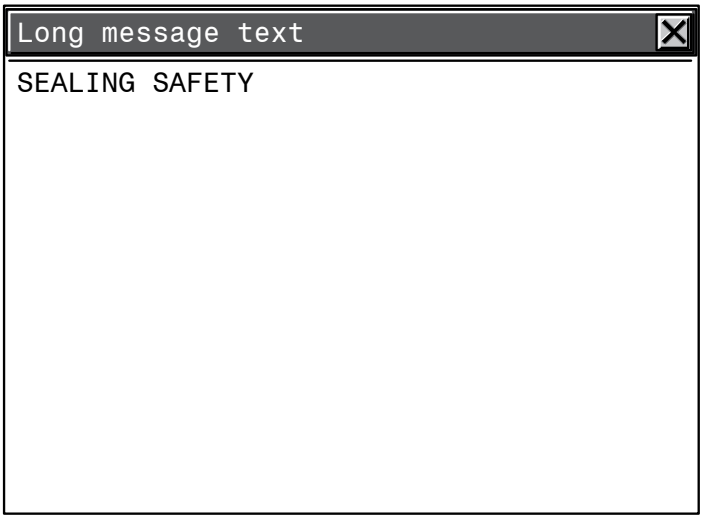
Record of Alarm

To view the current log entries of system alarms, touch the Record of Alarm button. A screen appears listing system log entries. (Under normal conditions, this screen will be blank and contain no messages. Only tab labels and buttons shown below will display.)



Touch the control buttons at the right of the screen to scroll through the alarm messages.

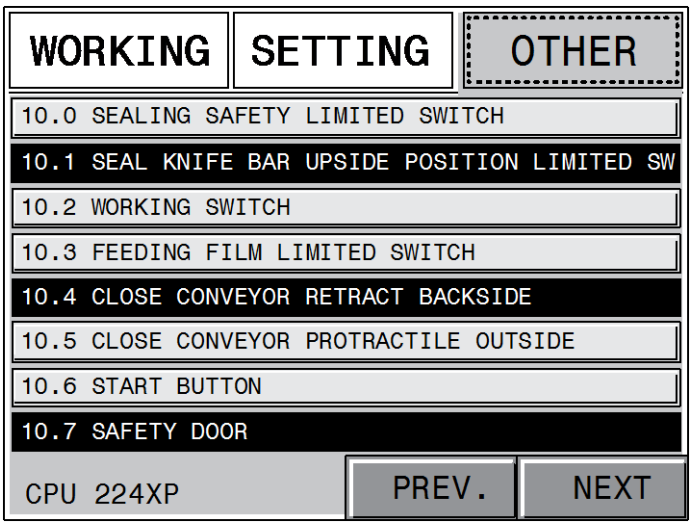
If you need to see the full text of an alarm message, scroll to the desired message and then touch the right-arrow button (➡). Press the X at the upper right of the Long Message text window when you are finished.



Touch the Prev. button at the bottom of the Record of Alarm screen to return to the previous screen of the Other tab.

PLC I/O Monitor

To view messages from PLCs for monitoring I/O conditions or for troubleshooting, touch the PLC I/O Monitor button.



Use the Prev. and Next Buttons to view additional PLC I/O messages.

When an alarm condition exists during running operation, the PLC will display an alarm pictorial on the screen. Alarm pictorials with explanations of what they mean are listed in the troubleshooting section of this User Guide.

Film Setup

CAUTION! **Turn off the working switch when setting up the film.**

Note: **You can turn the heat on to the sealer heat elements (M.D. Thermo and T.D. Thermo) to allow them to warm up to operating temperature while setting up the film.**

Select the proper width of center-fold film for the product being packaged, taking into account the width and height of the package, plus six inches for scrap.

1. Place the film roll on the support rollers of the film unwinder. (See the illustration on the following page.)

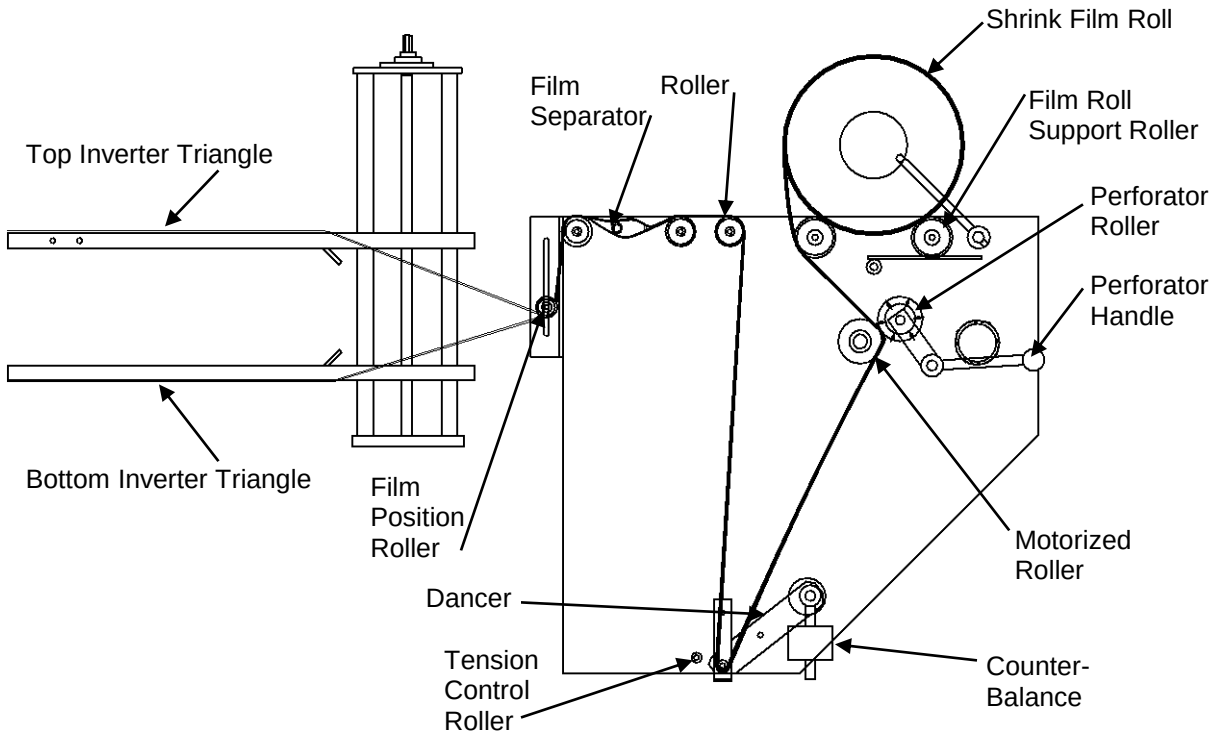
   Note: **Place the film center-fold end of the roll toward the infeed end, away from the operator panel (unless otherwise specified).**

2. Position the film roll on the rollers and tighten the upright bolts on the film rack collars to hold the film roll in position.

3. Pull down on the film perforator handle approximately 90° to temporarily disengage the film perforator and hold the film perforator out of the way while threading the film.

4. Thread the film through and around the idler rollers and the pin perforator as shown in the Film Unwind Path Diagram Illustration on the following page. Separate the film so one side of the film is to each side of the film separator.

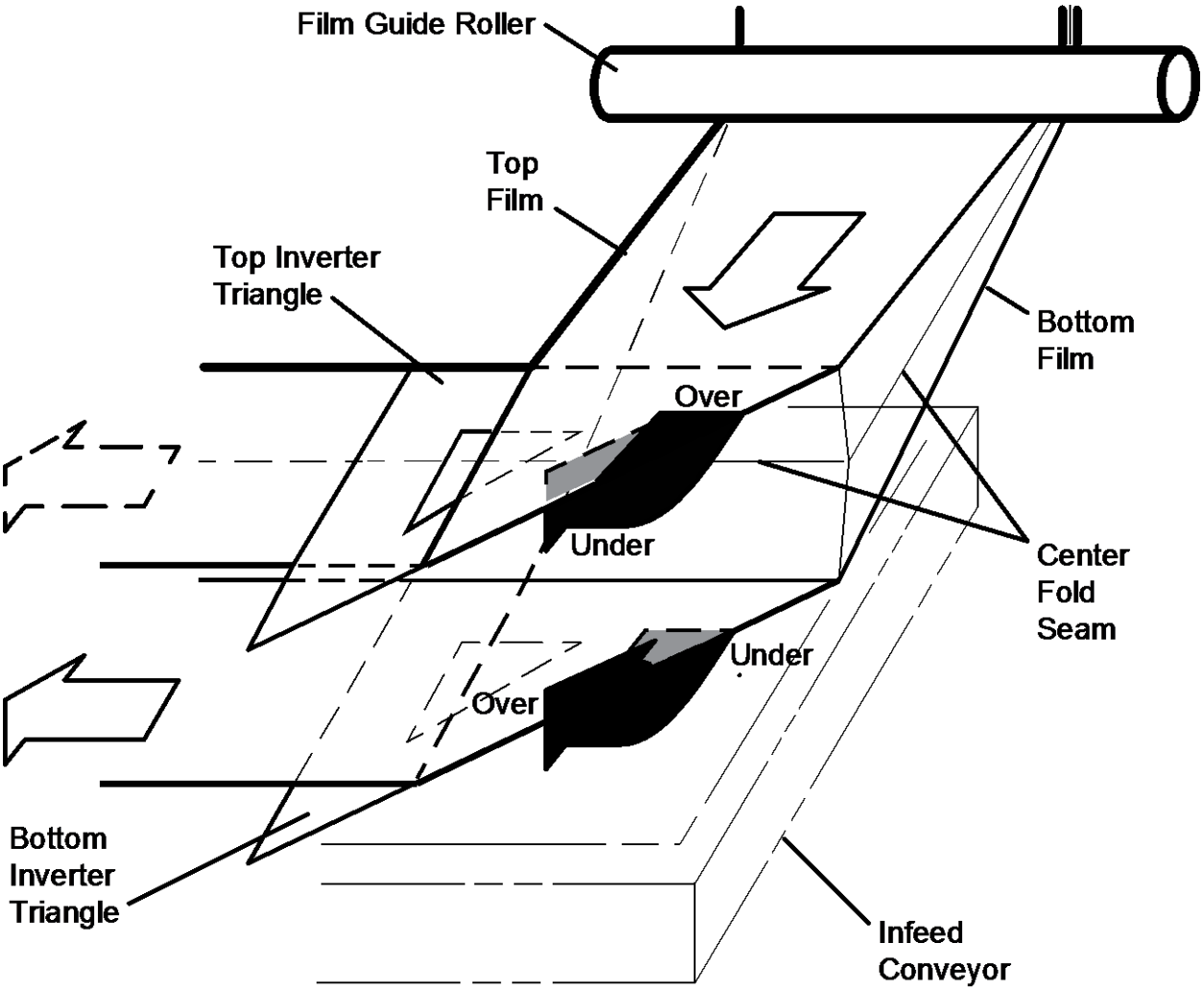
Film Unwind Path Diagram



5. Release the film perforator handle once the film is past the sixth roller. Perforation is required to allow air to vacate when the product passes through the shrink tunnel.
6. After passing the sixth roller, pull the film out about forty inches or one meter, and pass the film from the unwinder over the inverter triangles.
7. Adjust the height of the Upper Inverter Triangle approximately ½ inch or 13 mm above the height of the package.

Film routing for Top and Bottom Inverter Triangles

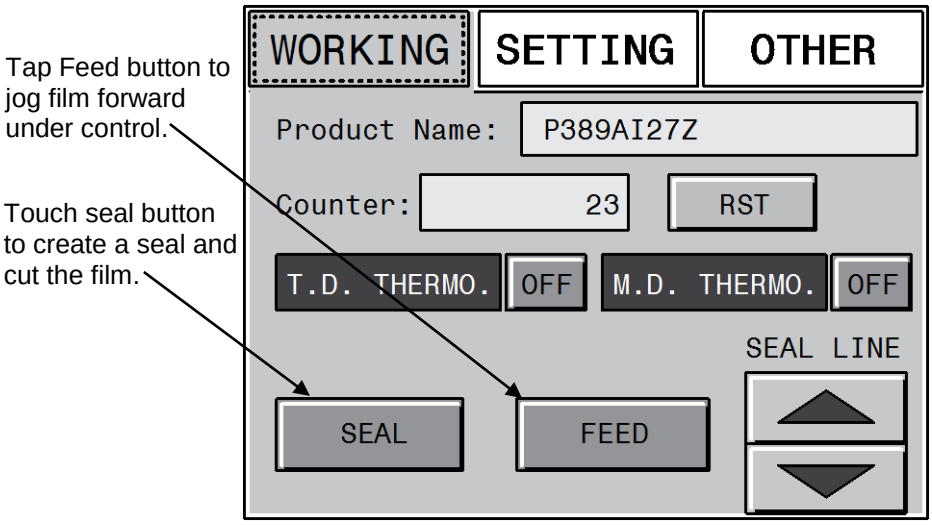
Use this diagram to route the top film over, then under the top inverter triangle, and the bottom film under, then over the bottom inverter triangle.



8. Adjust the film position roller to the center of the distance between the two Inverter Triangles.
9. Match both the top sheet and bottom sheet of the film and guide the leading end of the film toward the sealing area.
10. Pull the film to the left to the L-sealing area and lift the lever to release the pinch wheels.

Note: **This is a pinch area. Take care to avoid pinching hands or fingers while using the pinch wheel to secure the leading film.**

11. Pull the two leading edges of the film into the film drive chain so that the pinch wheel and drive chain will grab the film when the lever is lowered and begin pulling the film when activated. Lower the lever to engage the pinch wheels.
12. Tap the Feed button on the touch screen to jog the film under control. Do not press and hold the button or film will begin to run and seal continuously. The film will feed into the seal area. Touch the Seal button on the touch screen to cut the film.

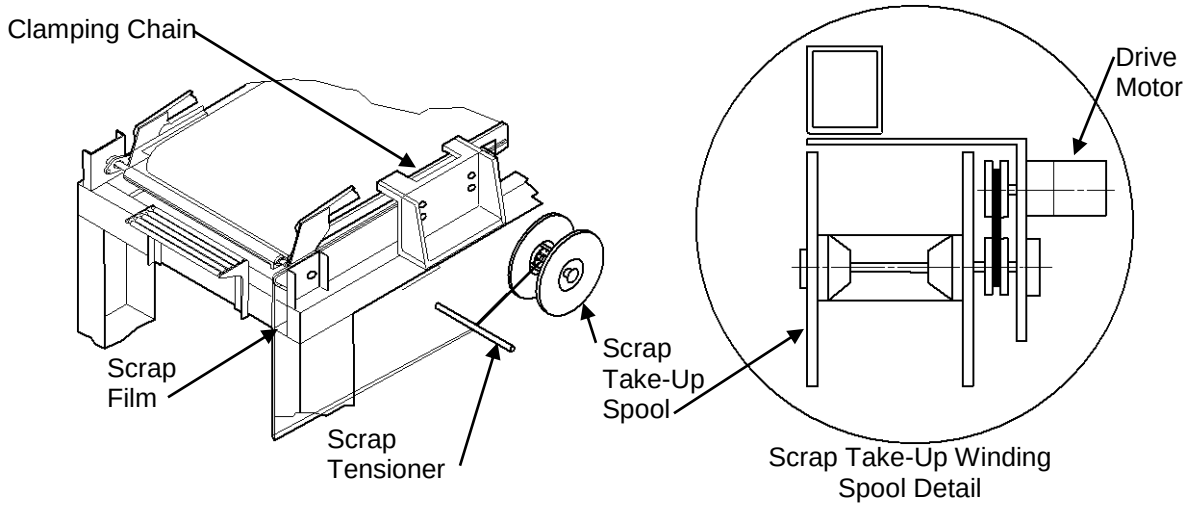


Setup for Scrap Winding

As you run the L-Sealer, excess film will be cut off and exit the front of the chain drive near the discharge end. To avoid waste film bunching up and creating an obstruction, the scrap film is routed by rollers to the scrap take-up spool in the base of the L-sealer. Use the following instructions and illustration at the top of the next page to guide the scrap film line around the rollers, under the anti-slack tensioner and on to the scrap take-up spool.

1. As scrap begins to be generated, guide the scrap film around the roller and guide at the exit end of the L-sealer.
2. Continue to guide the scrap film around the rollers at the front, and under the machine as shown. Most of the rollers are concealed beneath a guard bracket, and others are under the machine, but all are accessible and you will be able to route the scrap film around them.
3. Continue routing the scrap film line around the final roller, under the anti-slack tensioner, as shown, and onto the scrap take-up spool. Begin winding the scrap one complete revolution around the center hub of the scrap take-up spool, so the cling of the film will keep the film on the spool as the drive motor rotates the spool.

When complete, the scrap film should follow the route to the scrap take-up spool as shown.

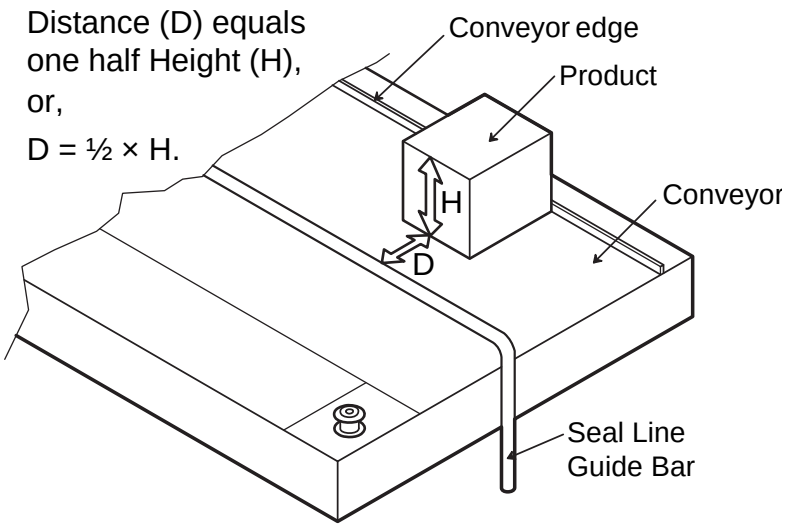


Adjusting Conveyor Width for Size of Product

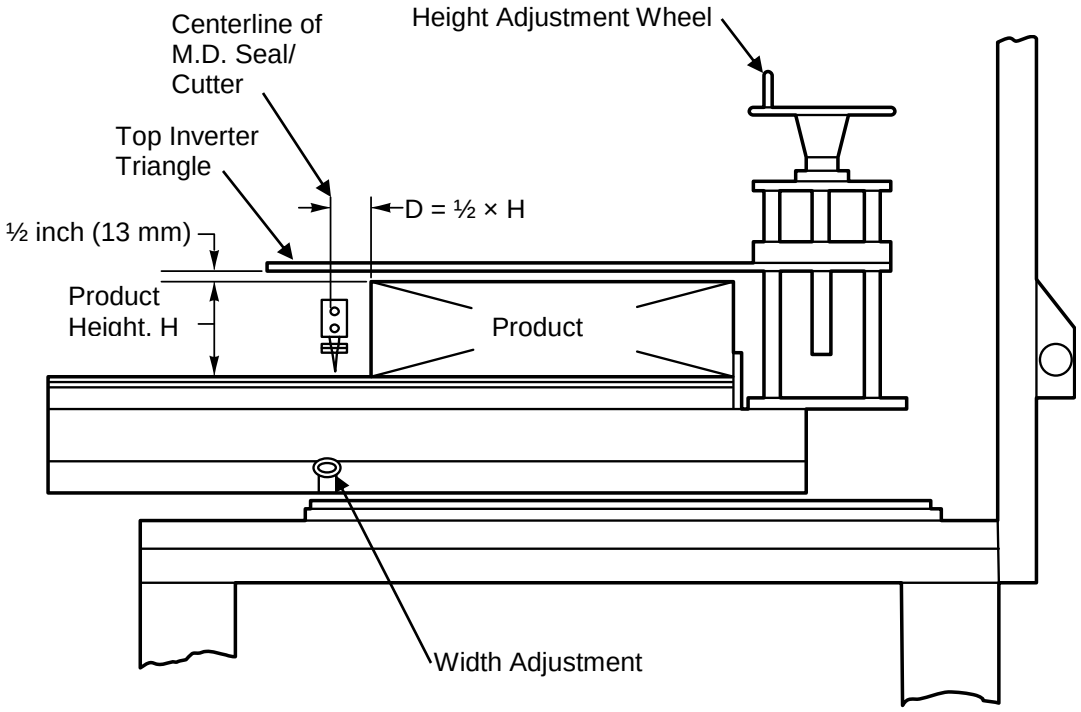
1. Temporarily stop the system and place a sample of the product to be sealed on the conveyor near the infeed end.
   - Place the product against the rear edge of the infeed conveyor as shown below and measure the height.
2. Measure the height of the product (H) and calculate the distance (D) as half of the height of the product (½ × H = D).

   Example 1: Product Height, H = 4 inches.
   Distance from product to seal line guide bar, D = ½ H = ½ × 4 in.
   D = 2 inches.

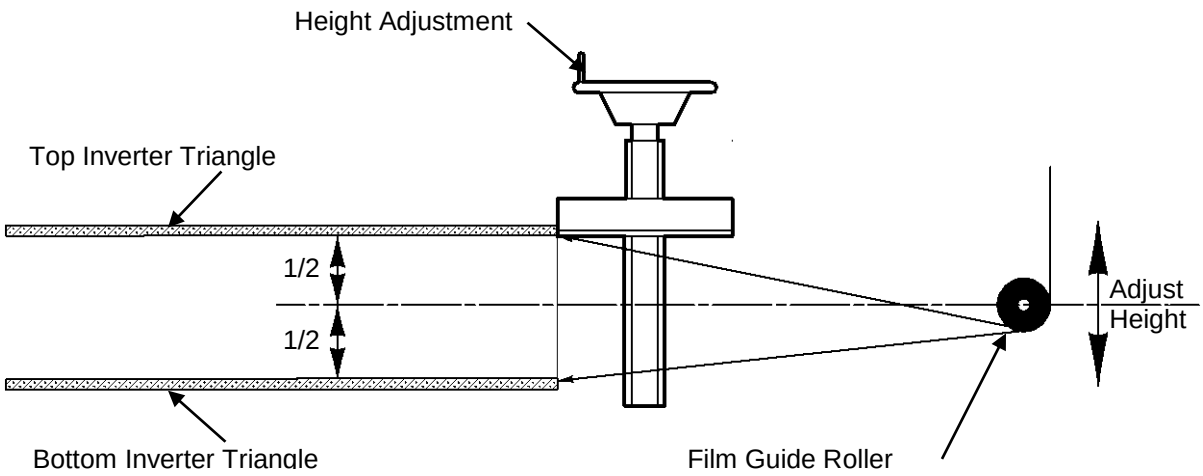
   Example 2: Product Height, H = 7 inches.
   Distance from product to seal line guide bar, D = ½ H = ½ × 7 in.
   D = 3½ inches.



3. Move the Seal Line Guide Bar the distance D from the base of the product as calculated (D = ½ × H) and as shown in the illustration.
4. Use the Infeed Conveyor Width Adjustment to adjust the width of the infeed conveyor to the calculated distance D.

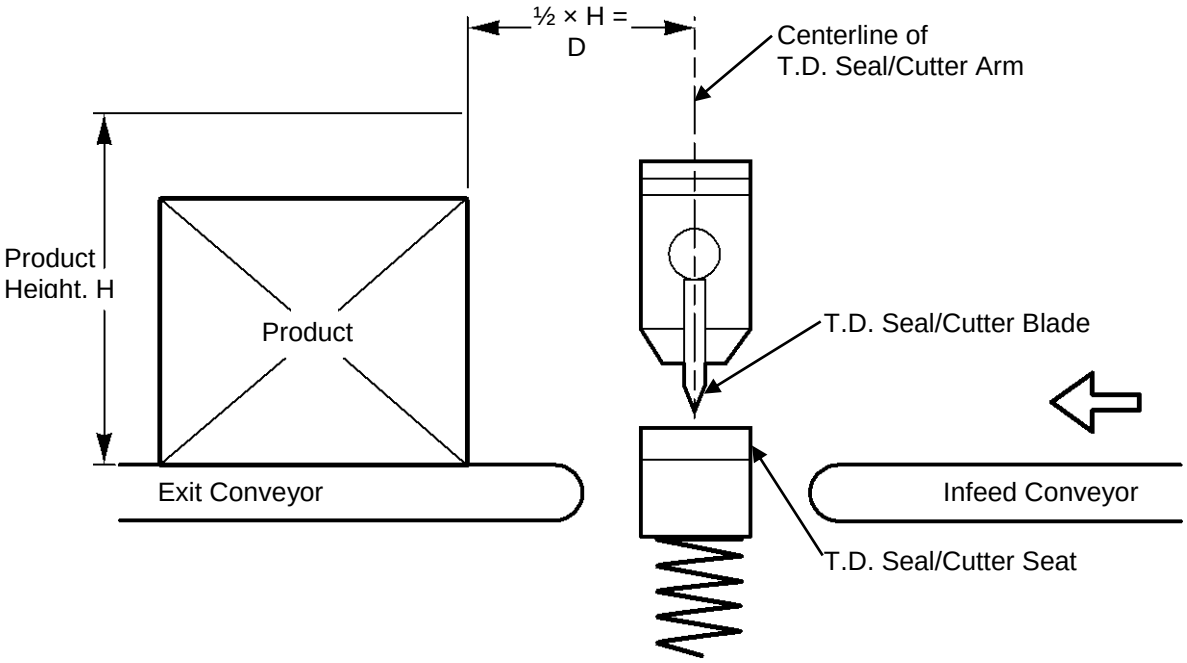


5. Adjust the film guide roller to the center of the distance between the two Inverter Triangles. See the illustration at the top of the following page.



Setting Conveyor Belt Run and Stop Times

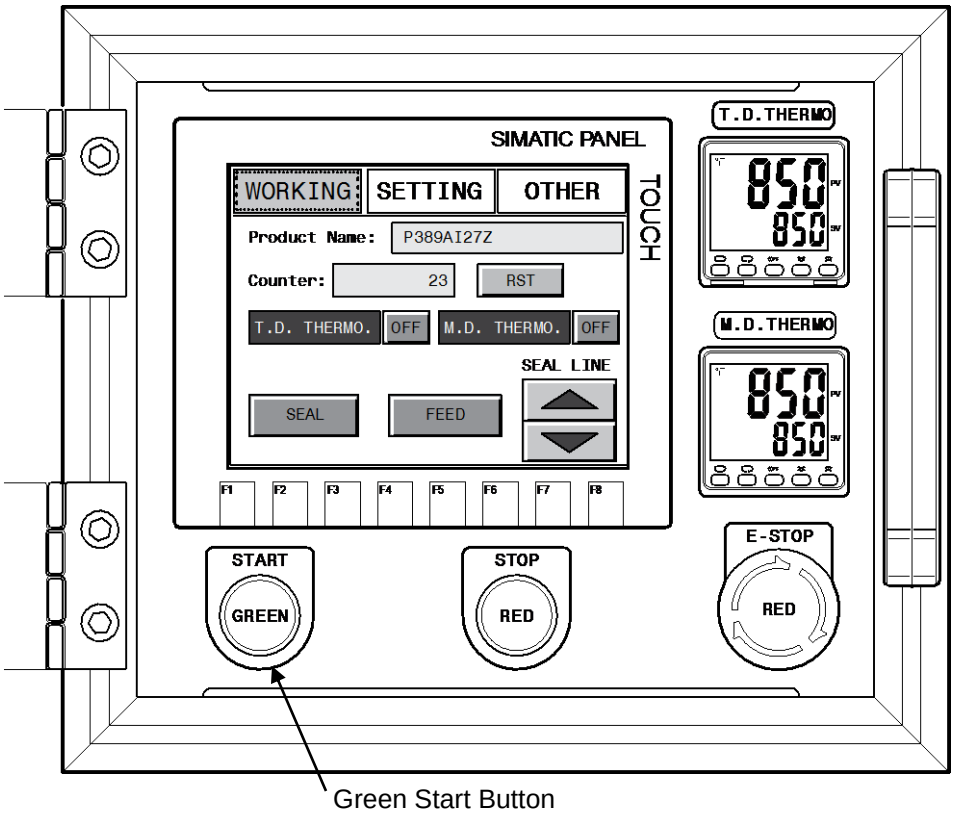
When the sealer is running and sealing product, the beginning transverse seal should be made at a distance approximately ½ the product height ahead of the product traveling on the Infeed Conveyor, then move to the Exit Conveyor and pause so that the ending transverse seal is made ½ the product height behind the product, as shown in the following illustration..



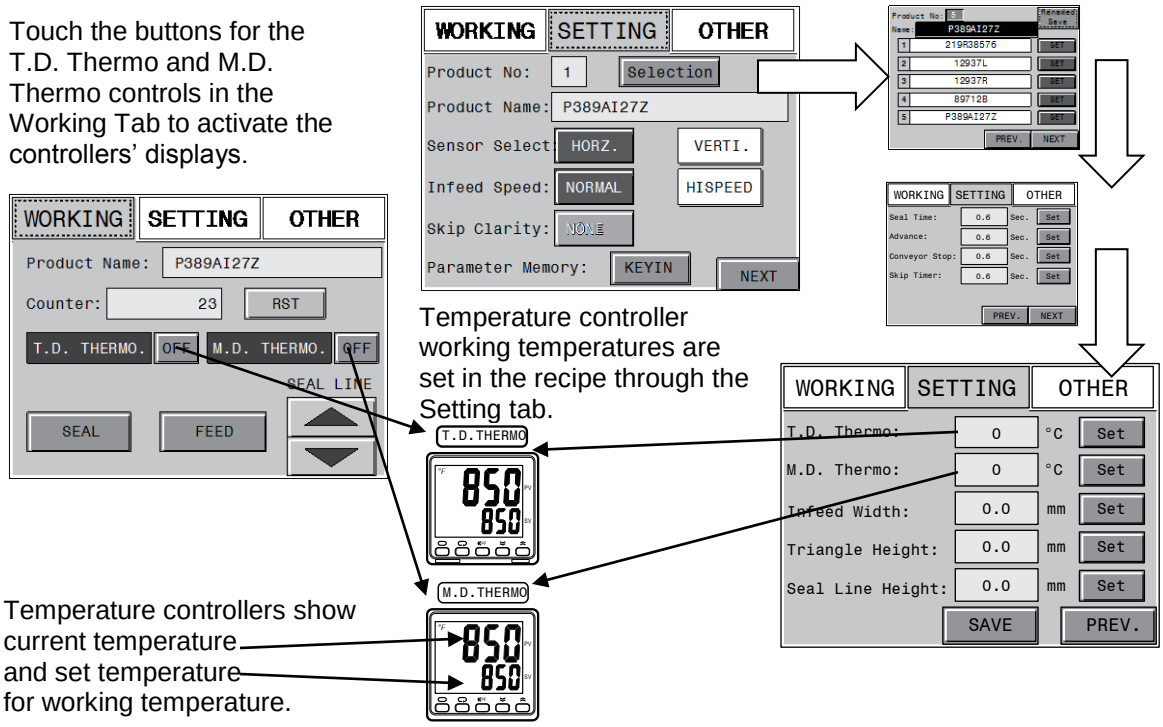
Seal Time, Advance, Stop, and Skip timers are set when creating a recipe for the product and this information is provided in the Set Machine Timers section of the instructions To Create, Name, and Save a Recipe section, earlier in this User Guide.

Manual Seal Test

1. Press the green Start button. The conveyors should be running.



2. If the L-sealer heat elements are not already up to operating temperature, bring them up to operating temperature by setting the temperature on the M.D. Thermo and T.D. Thermo temperature controllers.



3. With the heating elements at operating temperature, cover the sensor with a piece of paper or cardboard for about two (2) seconds.

4. Remove the paper or cardboard and the seal function test runs automatically. This allows you to verify settings and to verify that a proper seal is formed. If it will be necessary to go back and make or check any adjustments, it will be evident as a result of this test.

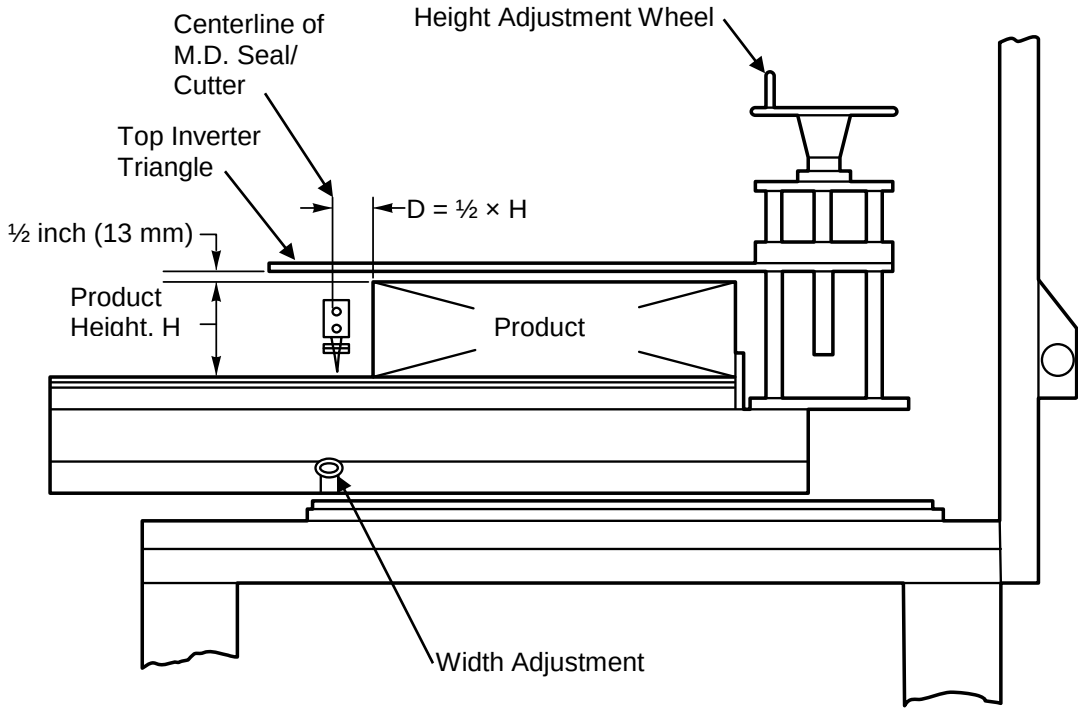
Once the machine is set up for the product, operation is automatic.

This completes the instructions for Machine Setup and Operation.

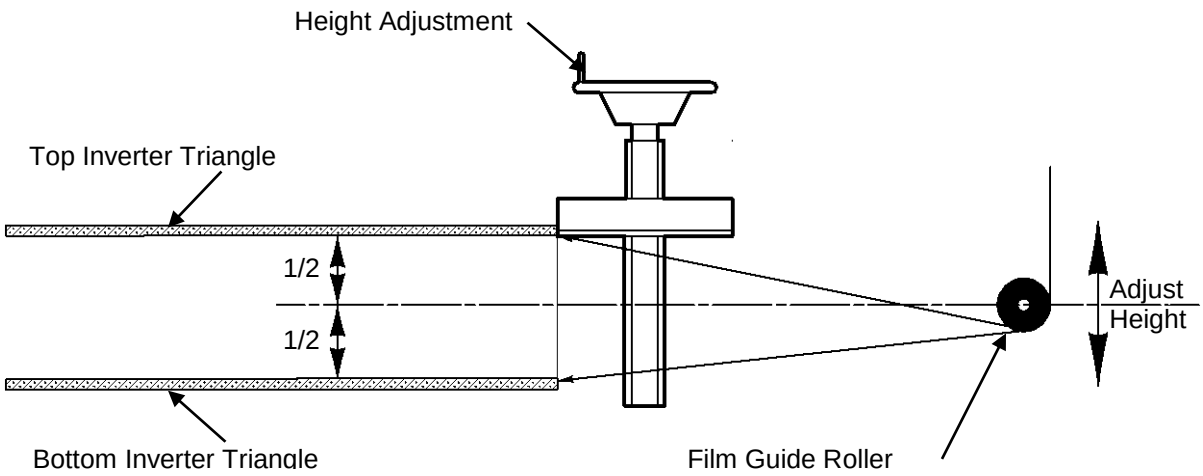
Adjustments

Adjusting the Film Inverter Height and Guide Roller Height

1. Temporarily stop the system and place a sample of product to be sealed on the conveyor near the infeed end.
   - Place the product against the rear edge of the infeed conveyor as shown below and measure the height.

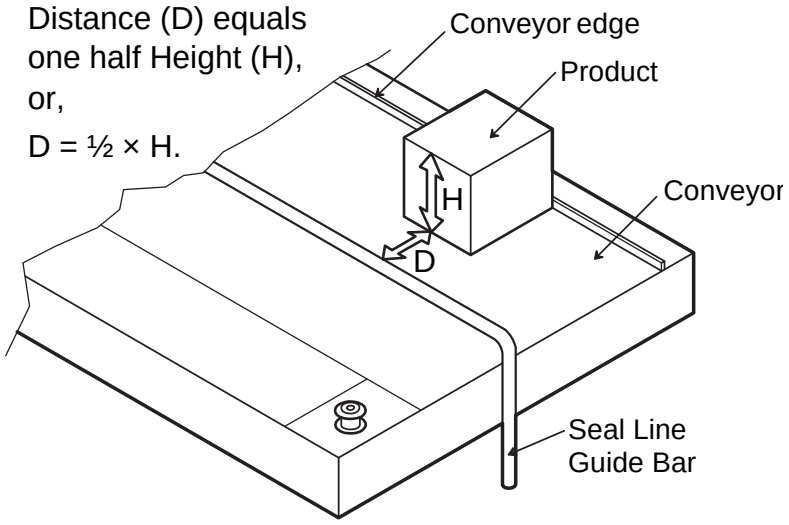


2. Use the Height Adjustment Wheel to adjust the distance between the two inverter triangles (top and bottom) so that the Top Inverter Triangle clears the top of the product sample by approximately ½ inch or 13 mm.
3. Adjust the film guide roller to the center of the distance between the two Inverter Triangles. See the following illustration.



Adjusting Conveyor Width for Size of Product

1. Temporarily stop the system and place a sample of product to be sealed on the conveyor near the infeed end.
   - Place the product against the rear edge of the infeed conveyor as shown below and measure the height.
2. Place the product against the rear edge of the infeed conveyor as shown below and measure the height.

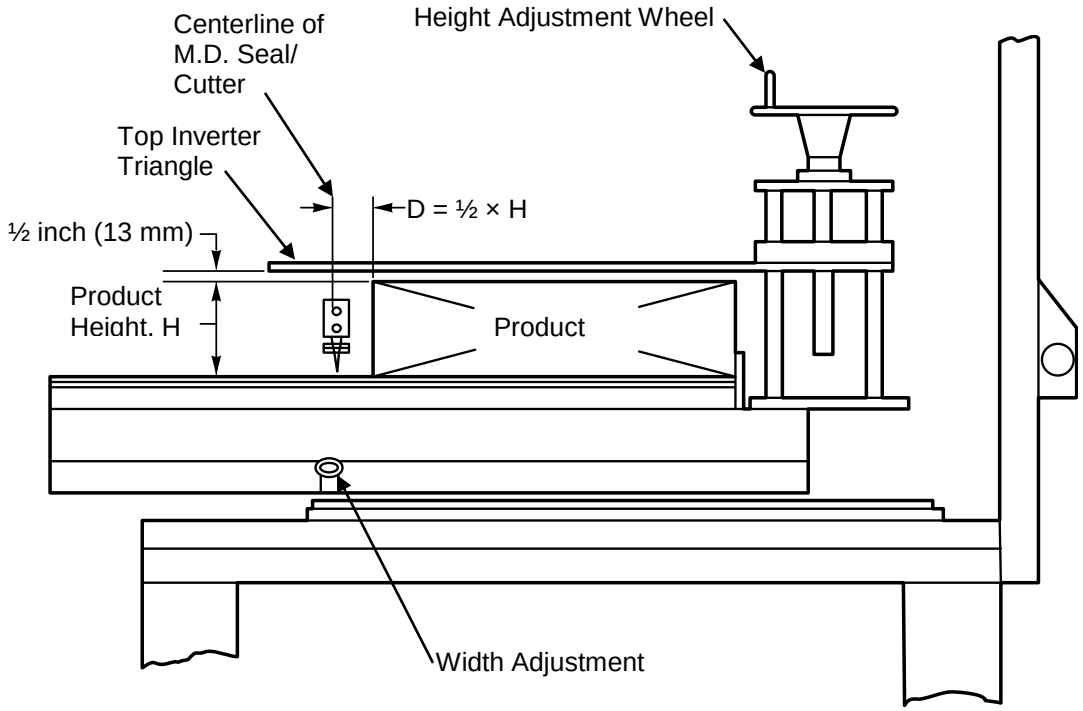


3. Measure the height of the product (H) and calculate the distance (D) as half of the height of the product (½ × H = D).

   Example 1: Product Height, H = 4 inches.
   Distance from product to seal line guide bar, D = ½ H = ½ × 4 in.
   D = 2 inches.

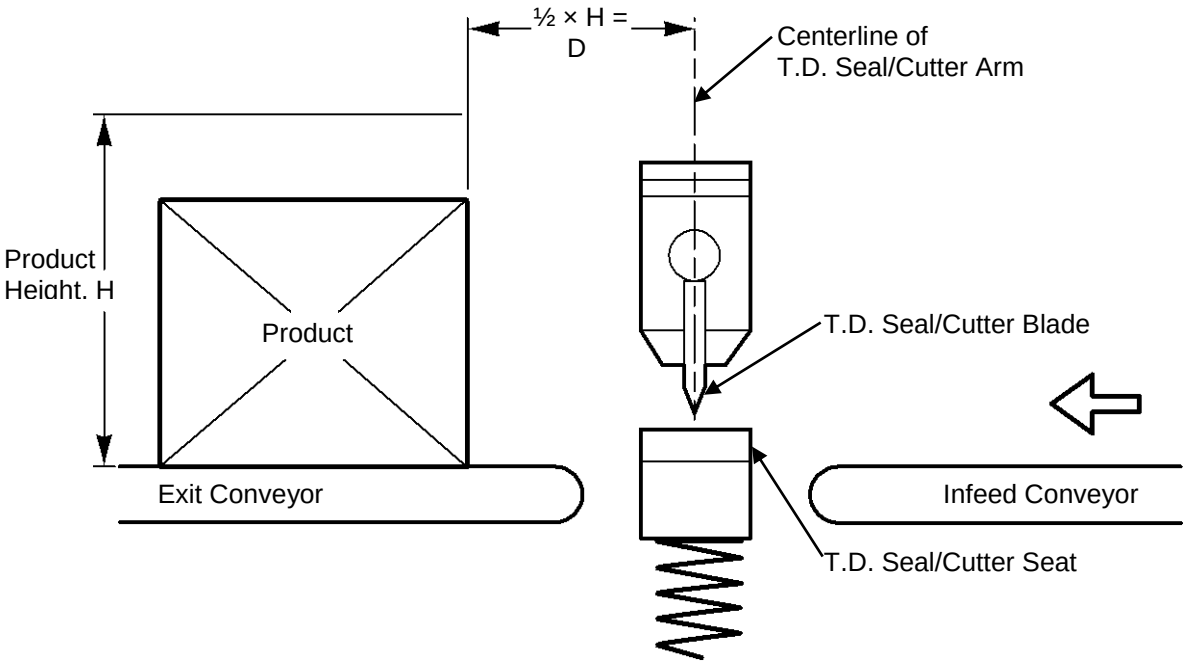
Example 2: Product Height, H = 7 inches.
Distance from product to seal line guide bar, D = ½ H = ½ × 7 in.
D = 3½ inches.

4. Use the Infeed Conveyor Width Adjustment to adjust the width of the infeed conveyor to the calculated distance D.



Setting Conveyor Belt Run and Stop Times

When the sealer is running and sealing product, the beginning transverse seal should be made at a distance approximately ½ the product height ahead of the product traveling on the Infeed Conveyor, then move to the Exit Conveyor and pause so that the ending transverse seal is made ½ the product height behind the product, as shown in the following illustration..



Seal Time, Advance, Stop, and Skip timers are set when creating a recipe for the product and this information is provided in the Set Machine Timers section of the instructions To Create, Name, and Save a Recipe section, earlier in this User Guide.

Maintenance

The Eastey VSA Value Series Semi-automatic L-Sealer will provide many hours of maintenance-free operation. There are a few items that may require attention from time to time.

Cleaning

Cleaning of the machine is occasionally necessary. Make a point of checking the machine and cleaning, if necessary when finishing the work-day or changing shifts.

1. After daily operation, carefully wipe the sealing cutter clean with a soft cloth.

2. The machine is not designed or built for waterproof function. When cleaning the machine, use a damp cloth. If necessary, use a mild detergent in small amounts. DO NOT splash water or other liquids on or into the machine. DO NOT “hose” clean the machine with water.

3. The machine has been coated with an anti-corrosion finish. Avoid contact with liquid acid or gas, or other corrosives.

4. After cleaning the machine, lubricate any moving parts as required.

5. Check the air filter and regulator daily. If water has accumulated, empty the water.

Rollers

Make sure rollers stay clean and grease free. If you should have to clean the rollers, simply wipe them down with a clean lint free cloth. If a more thorough cleaning is necessary wipe the rollers down with a mild detergent and water and let dry. DO NOT splash water or other liquids into the machine. **Never use harsh or abrasive cleaners or chemical agents when cleaning the rollers.**

Troubleshooting

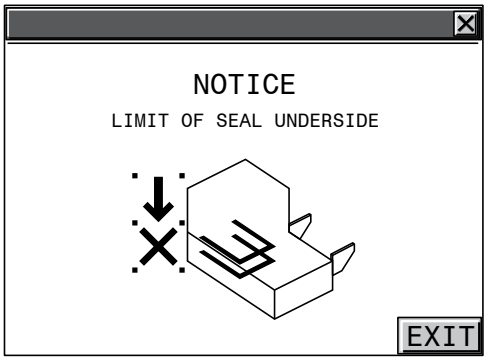
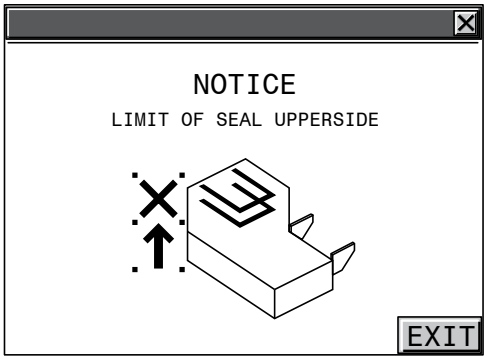
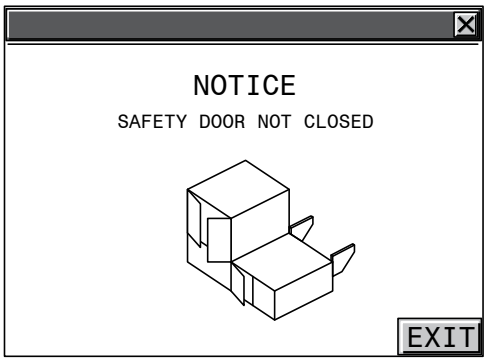
Problem	Possible Cause	Solution
Control power lamp does not light.	• Power not connected. • Fuse burned out. • Defective switch. • Disconnected wire.	• Replace part. • Switch on power.
No fuse breaker tripped.	• Poor connection. • Electrical leakage.	• Check heating wire. • Check all wiring sections.
Conveyor belt can be pushed by hand.	• Belt tension too loose.	• Adjust belt tension screw.
	• Belt tension too tight.	• Adjust belt tension screw.
Belt cannot be pushed by hand.	• Defective motor gear head.	• Replace part.
Failure under Normal Status.	• Driving chain tension too tight.	• Adjust driving chain.
	• Disconnected wire.	• Replace part.
	• Defective motor.	
	• Defective contact plug.	
	• Defective relay unit.	
	• Defective limit switch.	
Material outfeed roller failure.	• Disconnected wire. • Defective drive motor. • Defective relay unit.	• Replace part.
.		
Material moves	• Defective brake box. • Wrong material setting position.	• Replace part. • Adjust material setting positon.
Zig-zag line.	• Unbalanced material tension lever. • Wrong tension roller position. • Wrong triangle unfolder angle.	• Adjust item as required.
Material does not move.	• Film perforator does not allow film to roll out.	• Adjust spring.

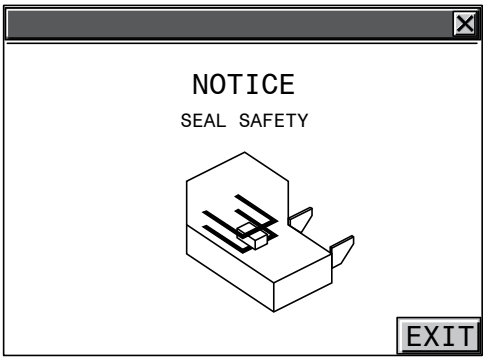
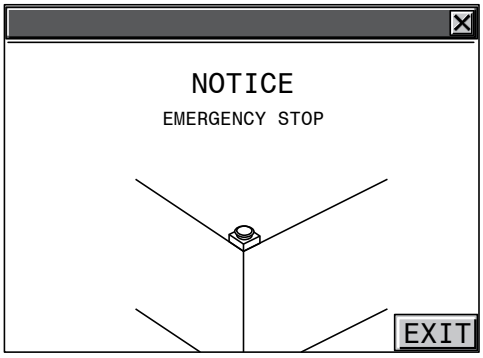
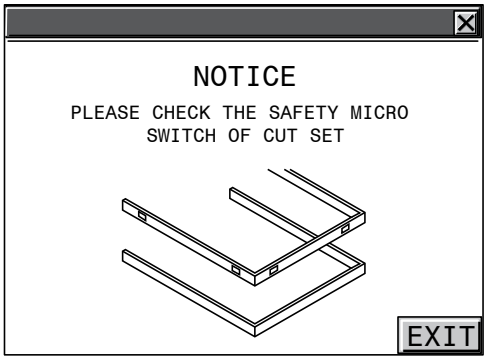
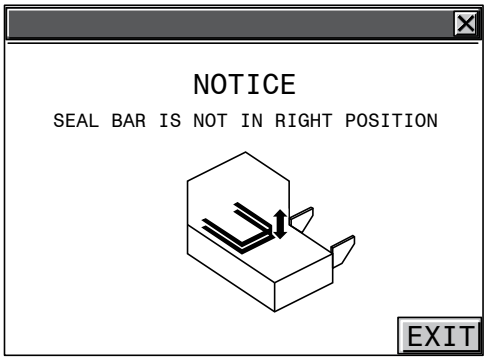
Problem	Possible Cause	Solution
Material does not move.	• Wrong RPM of material mounting roller. • Chain tension clamping is set too tight. • Chain tension clamping is set too loose. • Insufficient oil.	• Adjust to correct RPM. • Adjust chain clamping to correct tension. • Adjust chain clamping to correct tension • Fill oil as required.
Sealing arm fails to move.	• Disconnected wire. • Defective relay unit. • Defective solenoid. • Insufficient air pressure. • Defective throttle valve.	• Replace part. • Replace part. • Check part; replace as needed. • Check air supply. • Check throttle valve.
Sealing arm rises too abruptly.	• Throttle valve opens too quickly. • Sealing time is set too short.	• Adjust flow control. • Adjust time of limit switch in safety device to lengthen sealing time.
Sealing arm lowers too abruptly	• Electronic sensors not aligned horizontally or vertically, or dirty.	• Check alignment and adjust and clean as necessary.
Sealing heating temperature does not rise.	• Fuse burned out. • Disconnected heating wire. • Defective relay unit power of single phase.	• Replace part as required.
Unable to adjust temperature.	• Defective temperature regulator. • Defective temperature sensor.	• Replace defective part as required.

Problem	Possible Cause	Solution
Safety device failure.	• Disconnected wire. • Defective limit switch. • Defective relay unit. • Insufficient air pressure.	• Reconnect or replace wire. • Adjust or replace limit switch. • Replace part as required. • Check air pressure. Air pressure must meet specifications.
Sealer not forming an adequate seal.	• Sealing cutter defective. • Heating temperature too low. • Sealing time too short or air pressure too weak. • Sealing cutter heat is insufficient.	• Replace with new cutter. • Adjust to correct heating temperature. • Check and correct as required. • Replace sealing cutter.

Alarm Windows

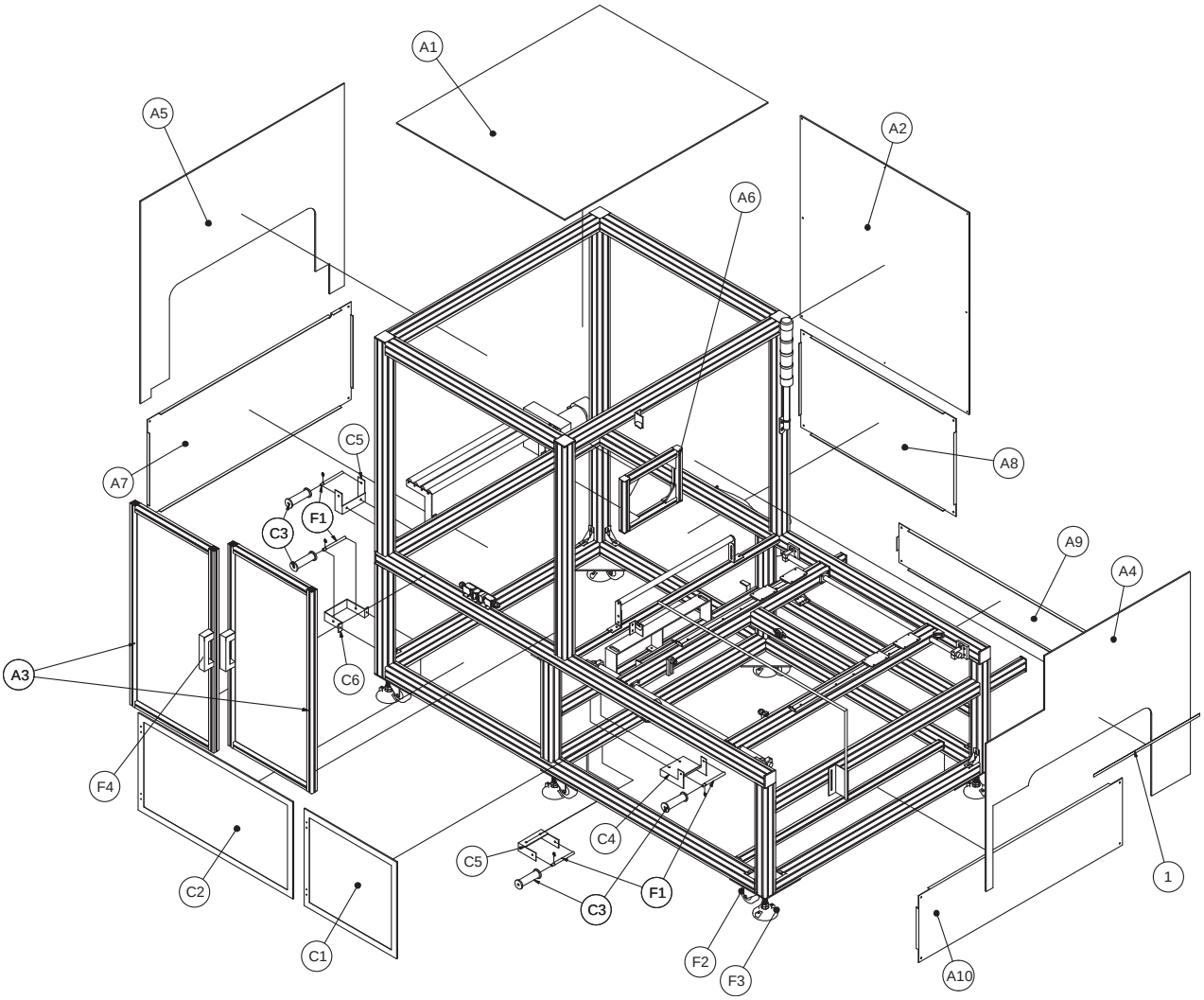
When an error condition occurs or when the L-sealer senses a condition that could affect safety or operation, the L-sealer stops operation and displays a Notice window on the Control Panel screen. The following table shows the notice windows and explains the meaning of each.

Window Pictorial	Meaning
	**Seal at lowest limit.** This is to alert the operator that the seal line has reached the lowest limit. Raise the seal line to clear the condition. Touch Exit to return to the working page.
	**Seal at highest limit.** This is to alert the operator that the seal line has reached the highest limit. Lower the seal line to clear the condition. Touch Exit to return to the working page.
	**Safety door open.** A safety door is open. Find the safety door that is open and close it to clear the condition. Touch Exit to return to the working page.

Window Pictorial	Meaning
	**Seal safety switch on.** This is to alert the operator that a sealing action has failed. Clear the package item from the seal area to clear the condition. Touch Exit to return to the working page.
	**Emergency Stop (E-Stop) is pressed.** This is to alert the operator that the Emergency Stop (E-Stop) is pressed. Clear the emergency condition, then re-arm the E-Stop. Touch Exit to return to the working page.
	**Seal safety micro-movement switch.** This is to alert the operator that the seal line safety micro-movement switch may be broken. Check the switch and replace it if necessary to clear the condition. Touch Exit to return to the working page.
	**Seal bar is not rising.** This is to alert the operator that the seal line has not reached the set position. Check the air pressure to verify it meets specified requirements and adjust if necessary to clear the condition. Touch Exit to return to the working page.

Parts List

Covers, Doors & Shutters



ITEM	PART NUMBER	DESCRIPTION	SPECIFICATION	Q'TY
A1	5HMLSA706AXA4	Acrylic Upper Cover	LSA706A-AC02	1
A2	5HMLSA706AXA4	Acrylic Rear Panel	LSA706A-AC03	1
A3	5HMLSA706AXA4	Main Entrance (Left and Right, 1 each)	LSA706A-AC04	2
A4	5HMLSA706AXA4	Right Acrylic Cover	LSA706A-AC05	1
A5	5HMLSA706AXA4	Left Acrylic Cover	LSA706A-AC06	1
A6	5HMLSA706AXA4	Control Panel Frame	LSA706A-AC07	1
A7		Left and Right Shutters	LSA706A-AP01	1
A8		Rear Cover	LSA706A-AP02	1
A9		Under Cover Plate	LSA706A-AP03	1
A10		Right Shutter	LSA706A-AP07	1

Scrap Film Guide Rollers & Brackets

ITEM	PART NUMBER	DESCRIPTION	SPECIFICATION	Q'TY
C1	5HMLSA706AXA4	Roll Material Door	LSA706A-CC03	1
C2	5HMLSA706AXA4	Collector Door (Left Side)	LSA706A-CC04	1
C3		Guide Wheel	LSA706A-CM05	4
C4		Collector Guide Seat	LSA706A-CP05	1
C5		Collector Guide Seat	LSA706A-CP06	2
C6		Collector Guide Seat	LSA706A-CP03	1

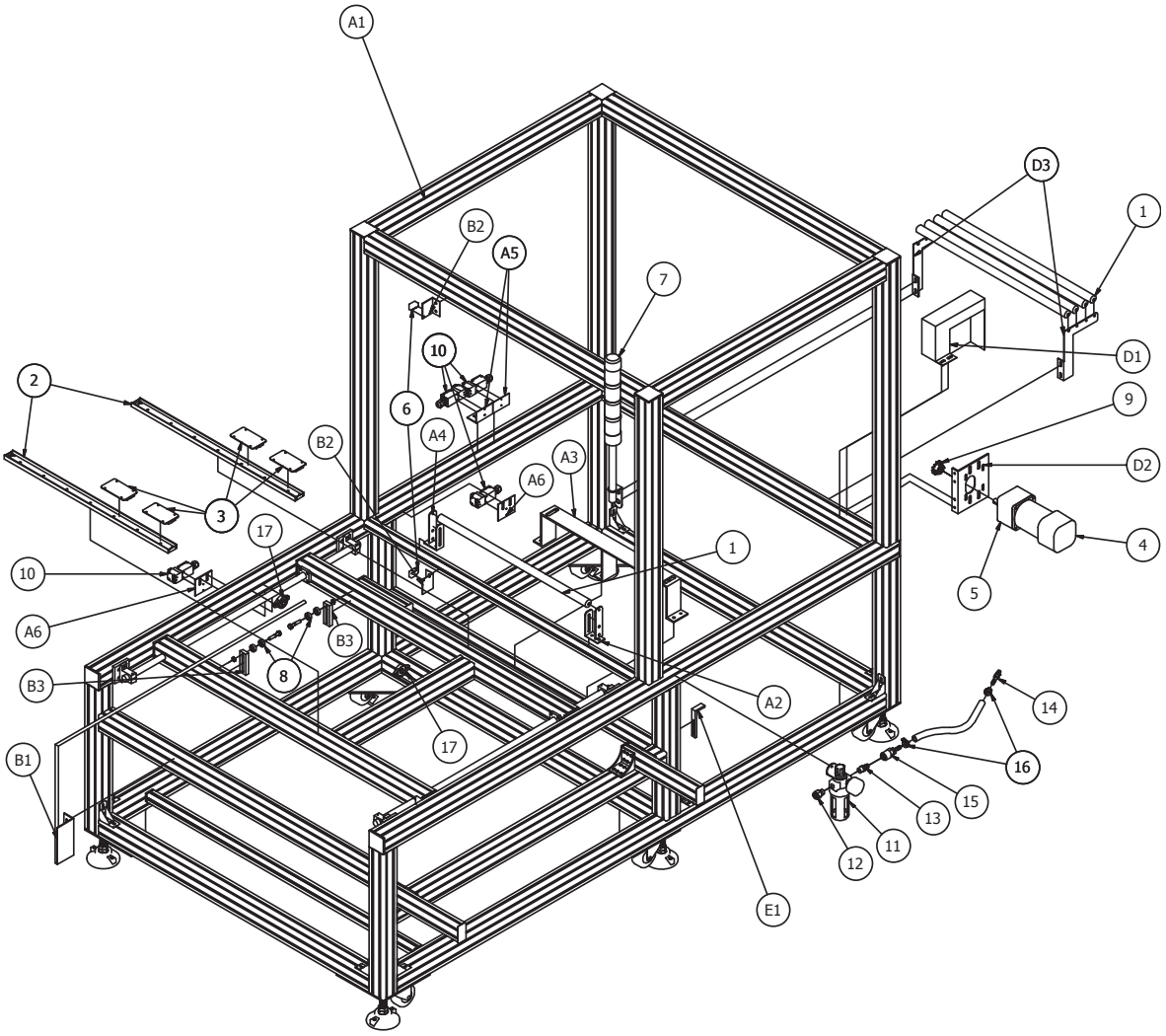
Guide Roller Shafts, Leveling Feet & Casters

ITEM	PART NUMBER	DESCRIPTION	SPECIFICATION	Q'TY
F1		Idler Shaft	LSA706A-FM09	4
F2		Wheel		6
F3		Tripod		6
F4		Handle		2

Mechanical Ruler

ITEM	PART NUMBER	DESCRIPTION	SPECIFICATION	Q'TY
1	5EL0406013600	Mechanical Ruler	0.8TX13X600MM	1

Motor, Air, Connectors, Bearings & Switches



ITEM	PART NUMBER	DESCRIPTION	SPECIFICATION	Q'TY
1	SBB1725X64OS	White Iron-Free Roller	25 Ø X640EL Axis 8 M5X0.8	5
2	5BE10A700	Slide Rails	FBW3590-700L	2
3	5BE11A	Slider	FBW2590-RUU	4
4	5CB025RK90GECW2ML2	Reversible Motor	5RK90GE-CW2ML2	1
5	5CB615GE12.5KBF	Gearbox	5GE12.5KBF	1
6	5AB04HP7T11S	Photoelectric Switch	HP7-T11	1
7	5AE05TRT244ROGW	Warning Light	TPTL5-74-4 24V	1
8	5BE010608ZZ	Bearings	608ZZ KSK	4
9	5BF011B3X13T15 M65	Sprockets	RS35 13T D=15 M6-2 5X2.5	1
10	5AB17QKS8	Safety Switch	QKS-8 AC400V2A	4
11	5DB13BFR300H	Pressure Regulator	BFR-300S	1
12	5DC02SPC1203	Quick Connector	PC12-03T PISCO	1

ITEM	PART NUMBER	DESCRIPTION	SPECIFICATION	Q'TY
13	5DC01PM30	C-Type Quick Connector	PM-30 (3/8PT)	1
14	5DC01PH20	C-Type Quick Connector	PH-20 (5/16PT)	1
15	5DC01SH30	C-Type Quick Connector	SH-20 (5/16PT)	1
16	5EH10A6	Stainless Steel Tube Bundle	3/4	2
17	5BE03UFL001	Bearing Units	UFL001JWT	2

Gaskets

ITEM	PART NUMBER	DESCRIPTION	SPECIFICATION	Q'TY
E1		Gaskets	LSA706A-EP20	1

Outfeed Motor Cover & Brackets

ITEM	PART NUMBER	DESCRIPTION	SPECIFICATION	Q'TY
D1		Motor Cover	LSA706A-DP01	1
D2		Outfeed Motor Seat	LSA706A-DP03	1
D3		Outfeed Rack	LSA706A-DP04	2

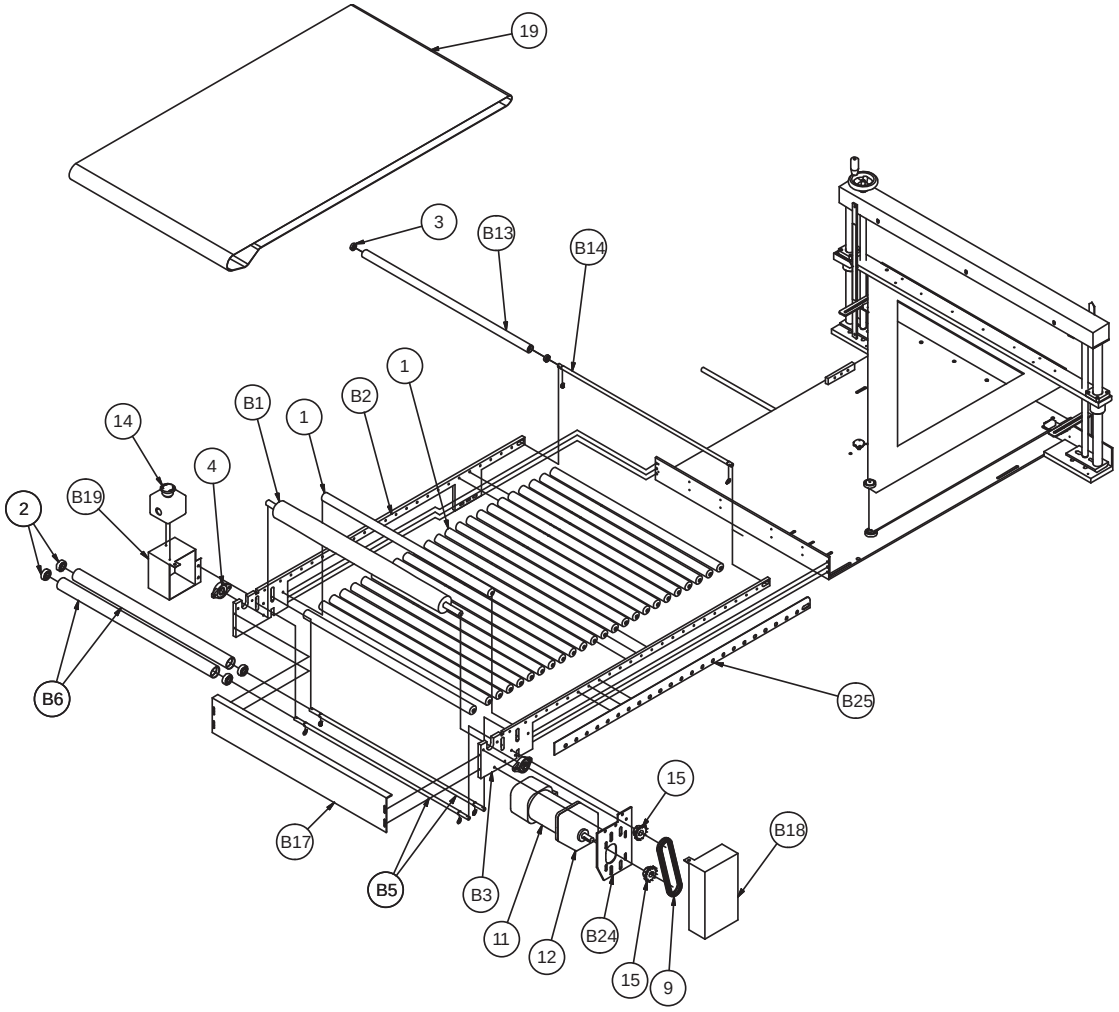
Infeed Slide & Electric Eye

ITEM	PART NUMBER	DESCRIPTION	SPECIFICATION	Q'TY
B1		Guide Rod	LSA706A-BP11	1
B2		Electric Eye Seat	LSA706A-BP17	2
B3		Input Section Slide	LSA706A-BP15	2

Safety Switch Seats, Roller / Conveyor Parts

ITEM	PART NUMBER	DESCRIPTION	SPECIFICATION	Q'TY
A1	5HMLSA706AXA4	706A Main Frame	LSA706A-AC01	1
A2		Intermediate Roller Frame(A)	LSA706A-AP05	2
A3		Output Conveyor Support	LSA706A-AP06	1
A4		Intermediate Roller Frame (B)	LSA706A-AP08	2
A5		Safety Switch Seat	LSA706A-AP09	2
A6		Safety Switch Seat	LSA706A-AP10	2

Pickup Conveyor with Motor & Gearbox

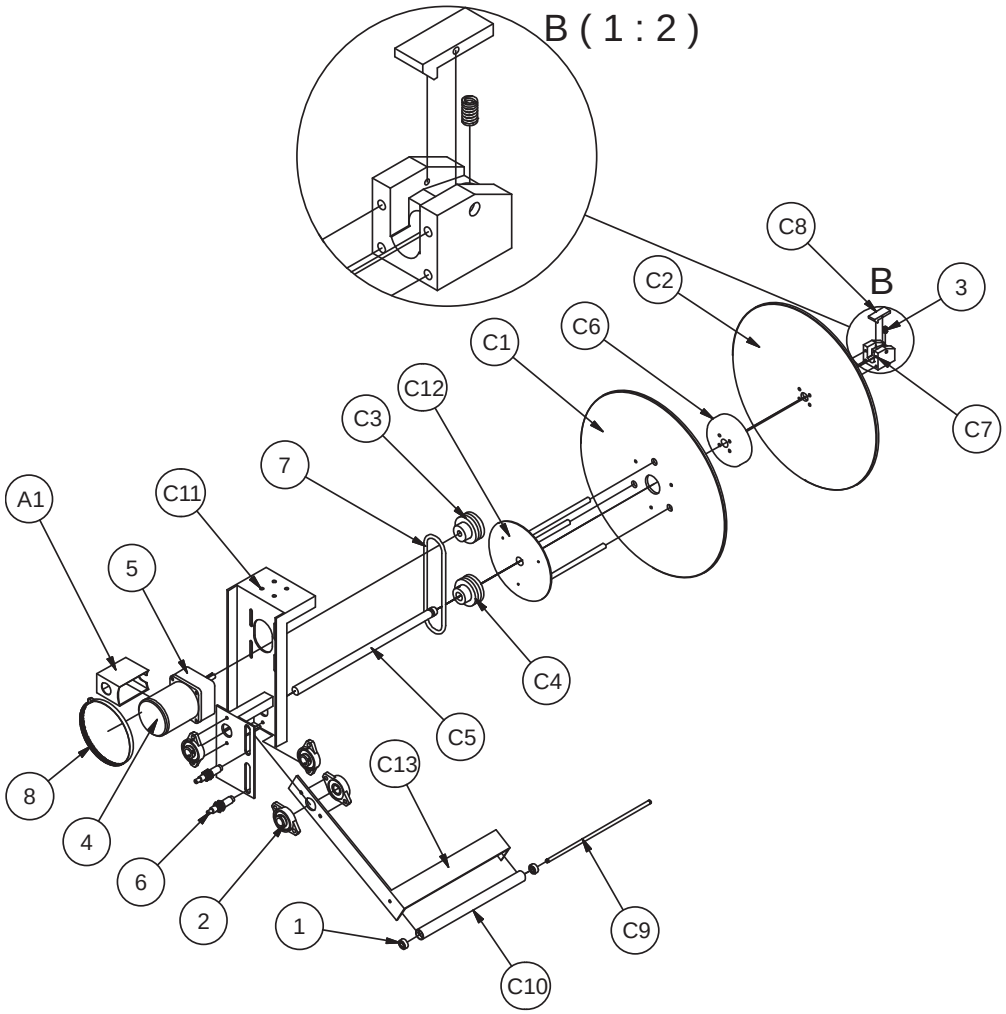


ITEM	PART NUMBER	DESCRIPTION	SPECIFICATION	Q'TY
1	5BB1725X640S	White Iron-Free Roller	25 Ø X640EL Axis 8 M5X0.8	25
2	5BE016200ZZ	Bearings	FBW3590-700L	4
3	5BE016800ZZ	Bearings	FBW2590-RUU	2
4	5BE03UFL002	Bearing Units	UFL002-M4 JWT	2
9	5BA0113X048	Roller Chain	RS35 48	1
11	5CB025RK90GECW2ML2	Reversible Motor	5RK90GE-CW2ML2	1
12	5CB615GE12.5KBF	Gearbox	5GE12.5KBF	1
14	5AB13HY57B0213	Red E-Stop Button Switch Box	FCH-HY57B-02-1-3	1
15	5BF011B3X13T15 M65	Sprockets	RS35 13T D=15 M6-2 5X2.5	2
19	5AB17QKS8	Pickup Belt	QKS-8 AC400V2A	1

Pickup Conveyor Side & End Panels, Motor Mount & Cover

ITEM	PART NUMBER	DESCRIPTION	SPECIFICATION	Q'TY
B1	5HFQLSA706ABC01	Output/Entry Zone Master Axis	54X734X630X15LSA 706A1-BC01	2
B2		Left Side Panel	LSA706A-BM01	1
B3		Right Side Panel	LSA706A-BM02	1
B5		Tension Rod Axis	LSA706A-BM05	2
B6		Tension Rod Roller	LSA706A-BM06	1
B13		Transmission Roller	LSA706A-BM13	1
B14		Axis	LSA706A-BM14	1
B17		Shutter	LSA706A-BP03	1
B18		Motor Cover	LSA706A-BP04	1
B19		Shield	LSA706A-BP05	1
B24		Motor Seat	LSA706A-BP10	1
B25		Cover Plate	LSA706A-BP12	1

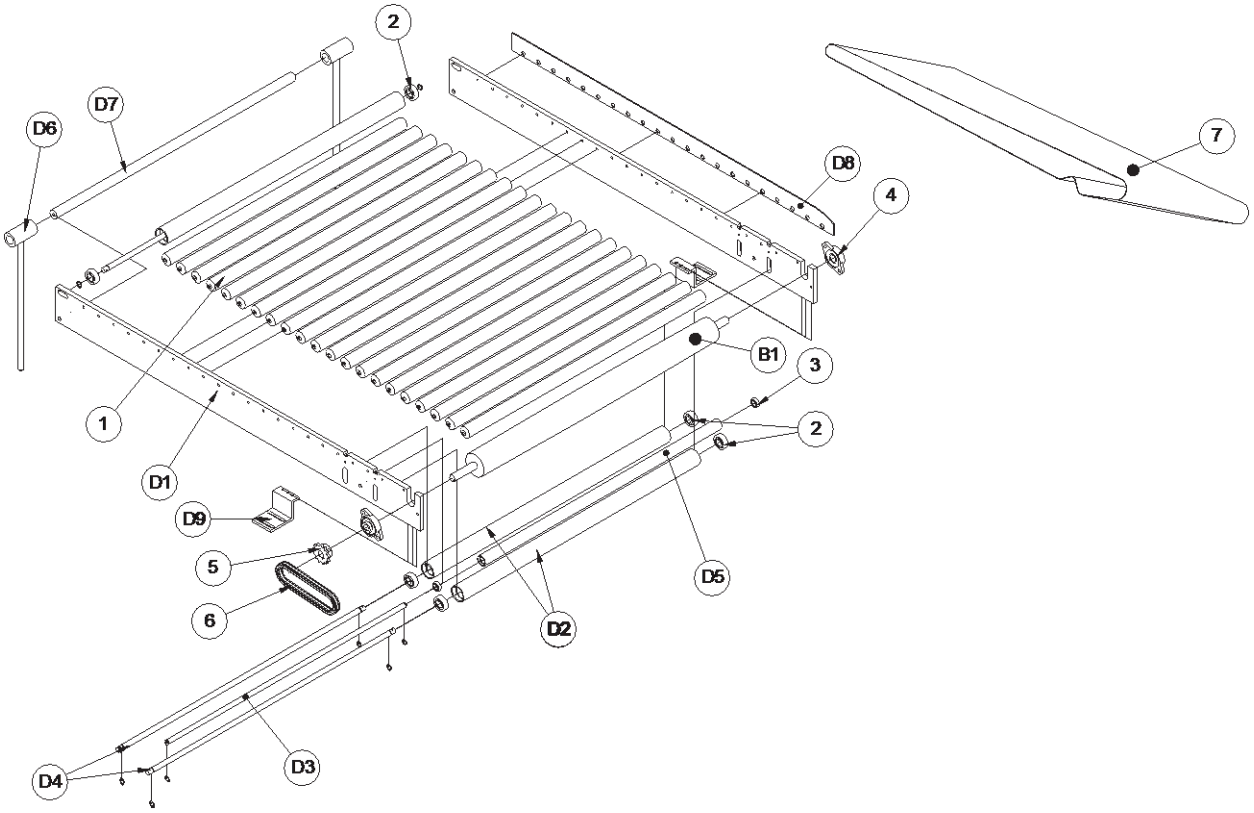
Scrap Take-Up Spool



ITEM	PART NUMBER	DESCRIPTION	SPECIFICATION	Q'TY
1	5BE010606ZZ	Bearings	606ZZ	2
2	5BE03UFL002	With Bearings	UFL002-M4	4
3	5EH1410X5X12X6N	Compression Spring (SUS)	1.0TX5X12X6N	1
4	5CB023RK15GNCW2L2	Reversible Motor	3RK15GN-CW2L2	1
5	5CB613GN18KF	Gearbox	3GN18KF	1
6	5AB05IM1204NNSZW1	Proximity Switch	IM12-04NNS-ZW1	2
7	5BB036X428	Round Belt	6 Ø X428LLSA504,605(C)	1
8	5EH1005	Stainless Steel Tube Bundle	5"	1
ITEM	**PART NUMBER**	**DESCRIPTION**	**SPECIFICATION**	**Q'TY**
A1		Line Box	LSA706!-AP04	1
ITEM	**PART NUMBER**	**DESCRIPTION**	**SPECIFICATION**	**Q'TY**
C1	5FDLSA706A1CC01	Inner Containment Disc	4.5TX350LSA706A1-CC01	1

ITEM	PART NUMBER	DESCRIPTION	SPECIFICATION	Q'TY
C2	5FDLSA706A1CC02	Outer Containment Disc	4.5TX350LSA706A1-CC02	1
C3		Driving Wheel	LSA706A-CM01	1
C4		Passive Wheel	LSA706A-CM02	1
C5		Spool Axle Rod	LSA706A-CM03	1
C6		Coil Holder	LSA706A-CM04	2
C7		Scrap Disk Holder	LSA706A-CM06	1
C8		Scrap Disk Retention Pawl	LSA706A-CM07	1
C9		Tension Roller Axis	LSA706A-CM08	1
C10		Material Tension Roller	LSA706A-CM09	1
C11	1	Coil Holder	LSA706A-CP01	1
C12		Scrap Winding Claw	LSA706A-CP02	1
C13		Roll Waste Guide Rod	LSA706A-CP04	1

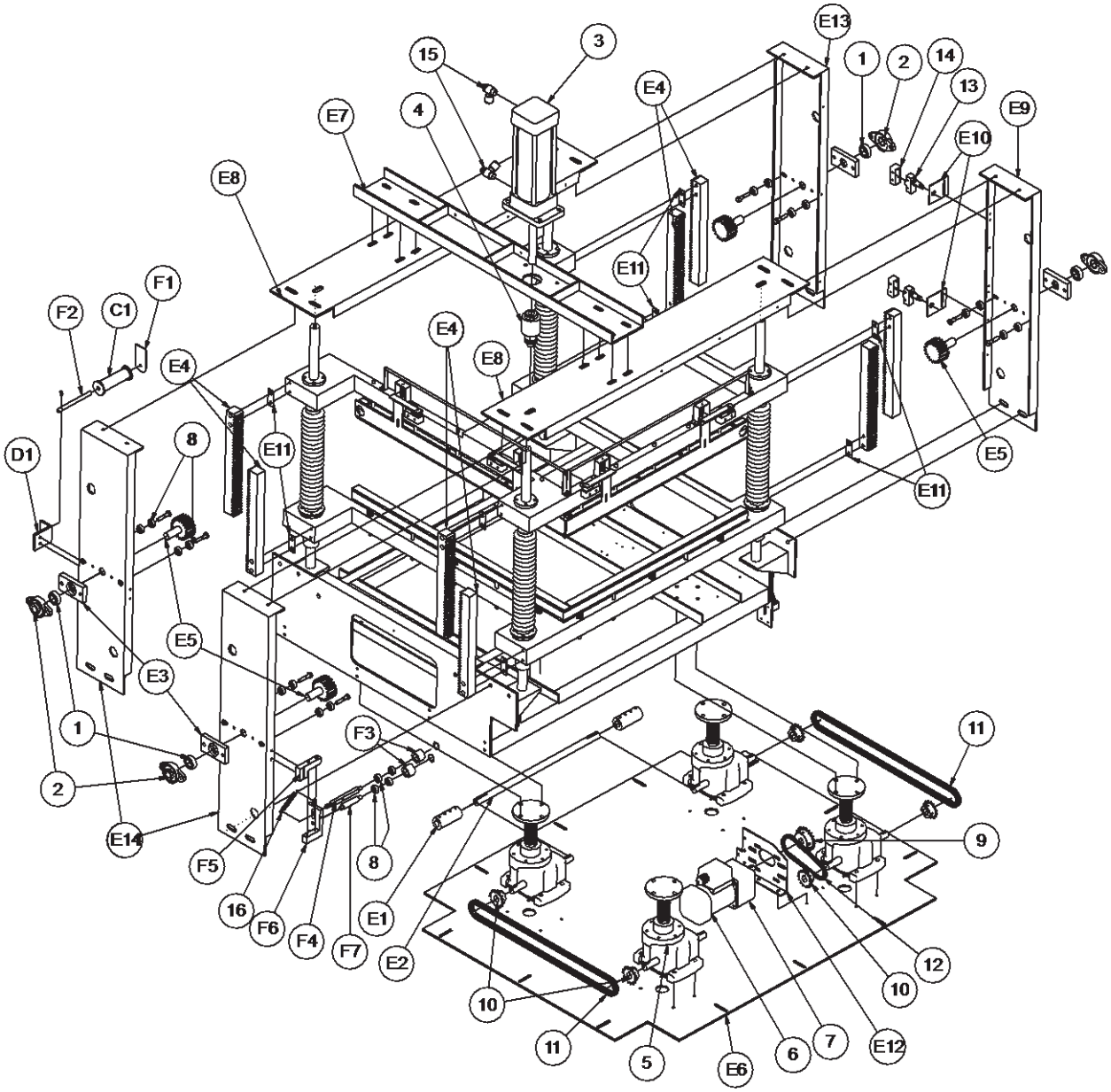
Output Conveyor



ITEM	PART NUMBER	DESCRIPTION	SPECIFICATION	Q'TY
1	5BB1725X640S	White Iron Free Roller	25 Ø X640EL Axis 8M5X0.8	21
2	5BE016200ZZ	Bearings	6200ZZ ISK	6
3	5BE016800ZZ	Bearings	6800ZZ ISK	2
4	5BE016800ZZ	Connecting Seat Bearing	UFL002-M4 JWT	2
5	5BF011B3X13T15M65	Sprockets	RS35 13T D=15 M6-2 Hole groove 5X2.5	1
6	5BA0113X037	Roller Chain	RS35 37	1
7	5BB01SL01X600X2010	Pick Up Belt (Out)	SL-4DU(G)ENS 600X2010 LSA-706A	1
ITEM	**PART NUMBER**	**DESCRIPTION**	**SPECIFICATION**	**Q'TY**
B1	5HFQLSA706ABC01	Output / Entry Zone Master Axis	54X734X630X15LSA706A1 -BC01	1
ITEM	**PART NUMBER**	**DESCRIPTION**	**SPECIFICATION**	**Q'TY**
D1		Conveyor Belt Seat	LSA706A-DM01	2
D2		Roller	LSA706A-DM02	3
D3		Axis	LSA706A-DM03	1
D4		Axis	LSA706A-DM04	3

ITEM	PART NUMBER	DESCRIPTION	SPECIFICATION	Q'TY
D5		Transmission Roller	LSA706A-DM05	1
D6		Conveyor Belt Support	LSA706A-DM06	2
D7		Link	LSA706A-DM07	1
D8		Guides	LSA706A-DP02	1
D9		Output Holder	LSA706A-DP05	2

Sealing Area (Part 1 of 2)

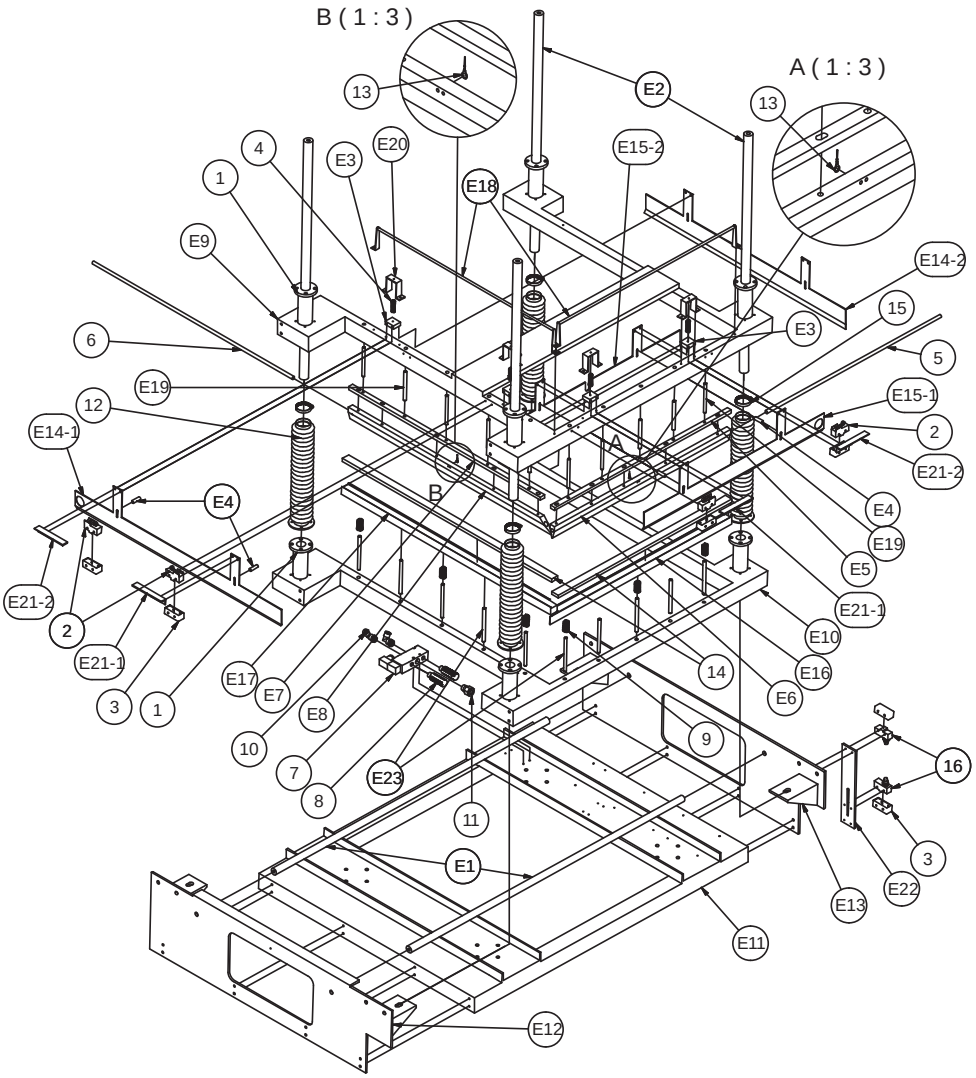


ITEM	PART NUMBER	DESCRIPTION	SPECIFICATION	Q'TY
1	5BE016904ZZ	Bearings	6904ZZ ISK	4
2	5BE03UFL004	Bearing Units	UFL004 JWT	4
3	5DA01ALXFA80X200	Pneumatic Cylinder	AL-FA-80 ØX200ST-M	1
4	5BE07CJM20X1.5	Floating Joint	CJ-M20X1.5	1
5	5CF08TM03TATS06X250	Screw Lifts	TM-3T-A-T-S-1/6-250	4
6	5CB015IK90GECW2TE	Induction Motor	5IK90GE-CW2TE	1
7	5CB615GE12.5KBF	Gearbox	5GE12.5KBF	1

ITEM	PART NUMBER	DESCRIPTION	SPECIFICATION	Q'TY
8	5BE010608ZZ	Bearings	608ZZ KSK	20
9	5BF011B3X20T15M65	Sprockets	RS35 20T D=15M6-2 5X2.5	1
10	5BF011B3X15T18M65	Sprockets	RS35 15T D=18M6-2 5X2.5	5
11	5BA0113X120	Roller Chain	RS35 120	2
12	5BA0113X042	Roller Chain	RS35 42	1
13	5AB06Z15GQ22B	Micro Switch	Z-15GQ22-B	2
14	5AC15CB2	Micro Switch Protective Cover	KSS CB-2	2
15	5DC03JSC1203A	Speed Control Connector	JSC12-03A	2
16	5EH1310X9X31X29N	Extension Spring (SUS)	1.0TX9X31X29N	1
ITEM	**PART NUMBER**	**DESCRIPTION**	**SPECIFICATION**	**Q'TY**
C1		Guide Wheel	LSA706A-CM05	Q'TY
ITEM	**PART NUMBER**	**DESCRIPTION**	**SPECIFICATION**	**Q'TY**
D1		Nylon Fixed Plate	LSA706A-DP06	1
ITEM	**PART NUMBER**	**DESCRIPTION**	**SPECIFICATION**	**Q'TY**
E1		Shaft Sleeve	LSA706A-EM01	2
E2		Axis	LSA706A-EM02	1
E3		Spur Gear Holder	LSA706A-EM04	4
E4		Rack	LSA706A-EM05	8
E5		Spur Gears	LSA706A-EM06	4
E6		Main Floor	LSA706A-EP03	1
E7		Pneumatic Cylinder Fixed Plate	LSA706A-EP07	1
E8		Upper Cover	LSA706A-EP08	2
E9		Side Panels (1)	LSA706A-EP09	1
E10		Micro Switch Seat	LSA706A-EP18	2
E11		Gaskets	LSA706A-EP21	8
E12		Motor Seat	LSA706A-EP25	1
E13		Side Panels (2)	LSA706A-EP26	1
E14		Side Panels (3)	LSA706A-EP27	2
ITEM	**PART NUMBER**	**DESCRIPTION**	**SPECIFICATION**	**Q'TY**
F1		Gaskets	LSA706A-FP03	2
F2		Idler Shaft	LSA706A-FM09	3
F3	5HFQLSA605CFC02	Clip Material Wheel	30 Ø X22 LSA605C-FC02	1
F4		Clip Material Wheel Axis	LSA706A-FM11	3

ITEM	PART NUMBER	DESCRIPTION	SPECIFICATION	Q'TY
F5		Loaded Material Wheel Seat	LSA706A-FM12	1
F6		Clamping Wheel Base	LSA706A-FM13	2
F7		Clip Material Wheel Axis (Under)	LSA706A-FM16	1

Sealing Area (Part 2 of 2)

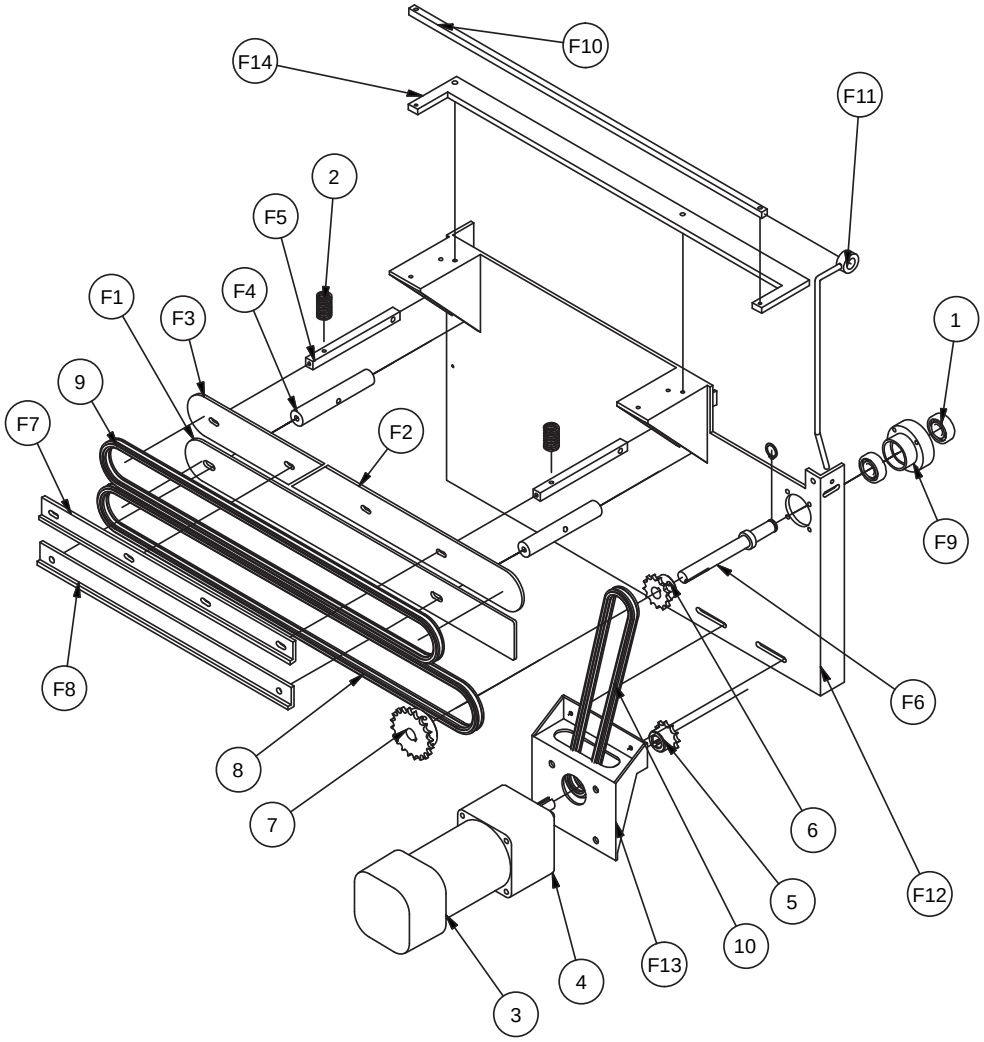


ITEM	PART NUMBER	DESCRIPTION	SPECIFICATION	Q'TY
1	5BE06LMF25LUU	Linear Bearings	LMF25LUU	8
2	5AB06Z15GW22B	Micro Switch	Z-15GW22-B	4
3	5AC15CB2	Micro Switch Cover	KSS CB-2	6
4	5EH1414X10X50X12N	Compression Spring (SUS)	1.4TX10X50X12N	4
5	5AF049.50670X207	Cartridge Heaters	9.5 Ø X 670M/MX220VX0.7KW	1
6	5AF049.50770X210	Cartridge Heaters	9.5 Ø X 770M/MX220VX1.0KW	1
7	5DB014V31010X1X24D	Solenoid Valve	4V310-10 DC24V(NVA-7521-D2	1
8	5DB36PS02	Plastic Muffler	PS-02 1/4PT	2
9	5EH1428X14X30X6N	Compression Spring (Nickel)	2.8TX14X30X6N	6

ITEM	PART NUMBER	DESCRIPTION	SPECIFICATION	Q'TY
10	5DC02SPL1203	Quick Connector	PL12-03T PISCO	2
11	5DC02SPC1203	Quick Connector	PC12-03T PISCO	1
12	5BC50XQ41X480	Telescopic Cover	Q41X480(40)XN02	4
13	5AA915M	Temperature Line	5M	2
14	5FB0110X25XCM	Silicone Strips	10TX24.8	150 (cm)
15	5EH1002	Stainless Steel Tube Bundle	2"	4
16	5AB06Z15GQB	Micro Switch	Z-15GQ-B	2
ITEM	**PART NUMBER**	**DESCRIPTION**	**SPECIFICATION**	**Q'TY**
E1		Strut	LSA706A-EM03	2
E2		Strut	LSA706A-EM07	4
E3		Compression Spring Holder	LSA706A-EM08	4
E4		Isolation Collar	LSA706A-EM09	4
E5		Horizontal Sealing Knife Upper Plate	LSA706A-EM10	1
E6		Horizontal Sealing Knife	LSA706A-EM11	1
E7		Vertical Seal Upper Plate	LSA706A-EM12	1
E8		Vertical Sealing Knife	LSA706A-EM13	1
E9		Upper Sealing Arm	LSA706A-EP01	1
E10		Lower Sealing Arm	LSA706A-EP02	1
E11		Lifting Plate	LSA706A-EP04	1
E12		Medial Plate - 1	LSA706A-EP05	1
E13		Medial Plate - 2	LSA706A-EP06	1
E14-1		Longitudinal Inside Outside Lamination Plate	LSA706A-EP10-1	1
E14-2		Longitudinal Inside Outside Lamination Plate	LSA706A-EP10-2	1
E15-1		Transverse Inside Outside Lamination Plate	LSA706A-EP11-1	1
E15-2		Transverse Inside Outside Lamination Plate	LSA706A-EP11-2	1
E16		Horizontal Lower Sealing Seat	LSA706A-EP12	1
E17		Longitudinal Lower Sealing Seal	LSA706A-EP13	1
E18		Wiring /Fixing Rod - 1	LSA706A-EP14	2
E19		Bolt	LSA706A-EP15	10
E20		Limiting Plate	LSA706A-EP16	4

ITEM	PART NUMBER	DESCRIPTION	SPECIFICATION	Q'TY
E21-1		Left and Right Contacts	LSA706A-EP17-1	2
E21-2		Left and Right Contacts	LSA706A-EP17-2	2
E22		Micro-Fixed Seat	LSA706A-EP19	1
E23		Bolt	LSA706A-EP22	10

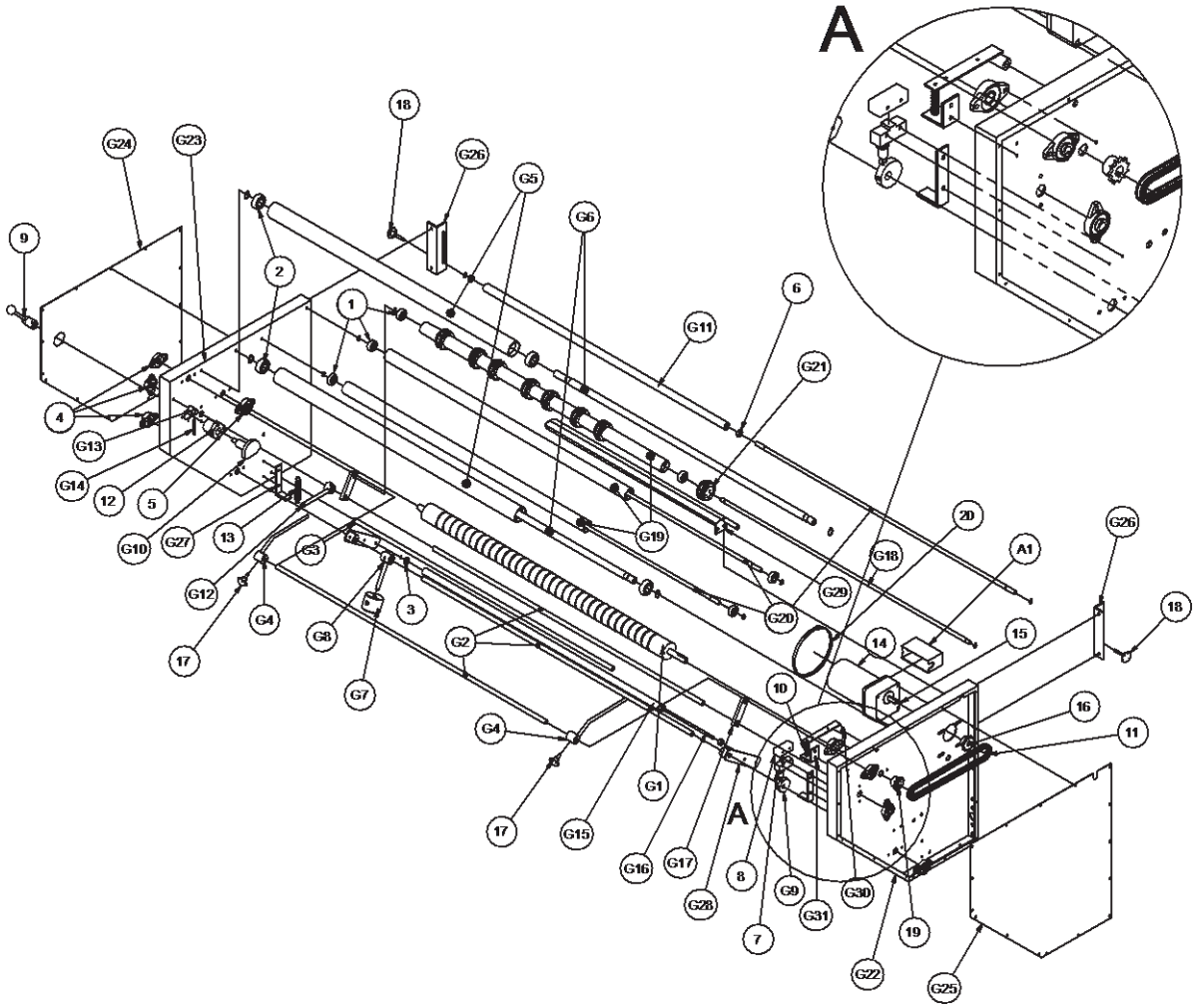
Scrap Chain, Motor, Gearbox, and Support Brackets



ITEM	PART NUMBER	DESCRIPTION	SPECIFICATION	Q'TY
1		Bearings	6202ZZ ISK	2
2		Compression Spring (Nickel)	2.0TX14X40X7N	2
3		Reversible Motor	5RK60GE-CW2ML2	1
4		Gearbox	5GE12.5KBF	1
5		Sprockets	RS35 11T D=15 M6-2 Hole Groove 5X2.5	1
6		Sprockets	RS35 13T D=15 M6-2 Hole Groove 5X2.5	1
7		Sprockets	RS35 20T D=15 M6-2 Hole Groove 5X2.5	1
8		Roller Chain	RS35 139 Eye	1
9		Roller Chain	RS35 125 Eye	1
10		Roller Chain	RS35 75 Eye	1

ITEM	PART NUMBER	DESCRIPTION	SPECIFICATION	Q'TY
F1		Clip Guide Plate	LSA706A-FM01	1
F2		Left Guide Plate	LSA706A-FM02	1
F3		Right Guide Plate	LSA706A-FM03	1
F4		Fixed Seat	LSA706A-FM04	2
F5		Support Pole	LSA706A-FM05	2
F6		Axis of Folded Material	LSA706A-FM06	1
F7		Upper Fixed Plate	LSA706A-FM07	1
F8		Lower Fixed Plate	LSA706A-FM08	1
F9		Bearing Collar	LSA706A-FM10	1
F10		Tailing Device C	LSA706A-FM14	1
F11		Tailing Device B	LSA706A-FM15	1
F12		Clip Holder	LSA706A-FP01	1
F13		Motor Mounting Plate	LSA706A-FM02	1
F14		Tailing Device A	LSA706A-FM04	1

Film Roll Support, Unwinder, and Perforator Unit

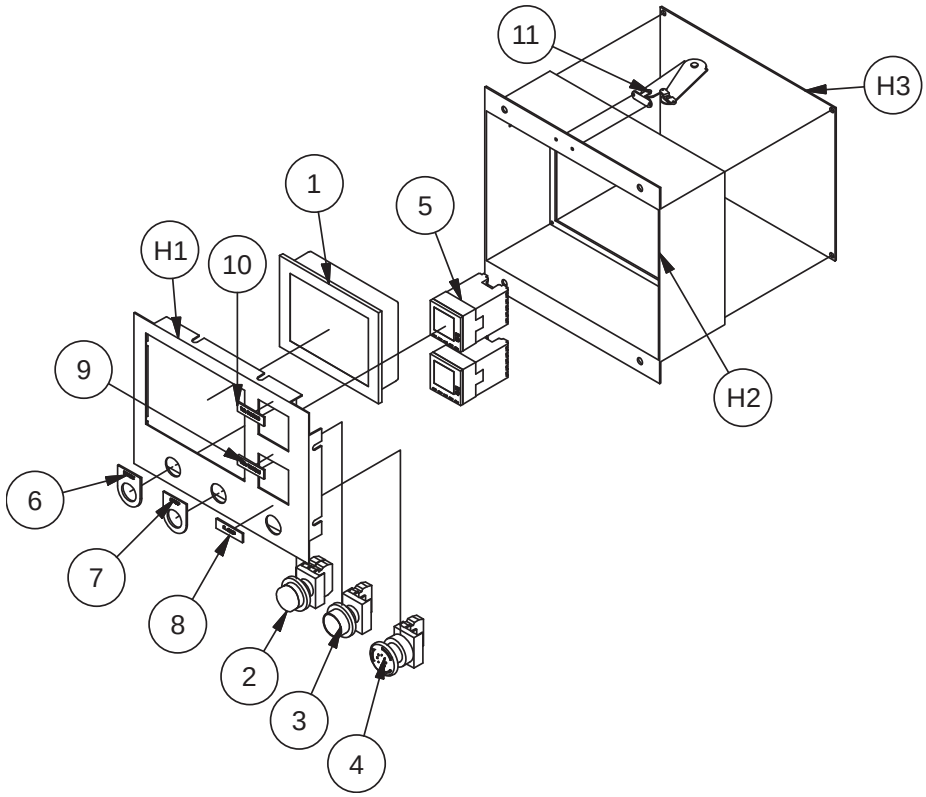


ITEM	PART NUMBER	DESCRIPTION	SPECIFICATION	Q'TY
1	5BE016200ZZ	Bearings	6200ZZ ISK	6
2	5BE016203ZZ	Bearings	6203ZZ TPI	4
3	5BE010606ZZ	Bearings	606ZZ	2
4	5BE03UFL001	Bearing Units	UFL001 JWT	6
5	5BE03UFL002	Bearing Units	UFL002-M4 JWT	2
6	5BE016800ZZ	Bearings	6800ZZ ISK	2
7	5AB06Z15GQ22B	Micro Switch	Z-15GQ22-B	1
8	5AC15CB2	Microswitch Protective Cover	KSS CB-2	1
9	5BC07BR75R	Crank Handle	BS75R D=10 Ø M6X2	1
10	5EH1416X9X30X8N	Compression Spring (Nickel)	1.6TX9X30X8N	1
11	5BA0113X066	Roller Chain	RS35 66	1
12	5BE06SFPJ20	Self-Lubricating Bearings	SFPJ20 CLIPPER	1

ITEM	PART NUMBER	DESCRIPTION	SPECIFICATION	Q'TY
13	5EH1318X18X34X18N	Extension Spring (Nickel)	1.8TX18X34X18N	1
14	5CB025RK40GNCW2ML2	Reversible Motor	5RK40GN-CW2ML2	1
15	5CB615GN15KF	Gearbox	5GN15KF	1
16	5BF011B3X13T12M64	Sprockets	RS35 13T D=12 M6-2 4X2	1
17	5BC04GN01ST32M06X16	Plum Handle	6050 32-M6X15	2
18	5BC04GN01ST32M06X35	Plum Handle	GN6336.4 ST32-06X35	2
19	5BF011B3X11T15M64	Sprockets	RS35 11T D=15 M6-2 4X2	1
20	5EH1005	Stainless Steel Tube Bundle	5"	1
ITEM	**PART NUMBER**	**DESCRIPTION**	**SPECIFICATION**	**Q'TY**
A1		Line Box	LSA706A-AP13	1
ITEM	**PART NUMBER**	**DESCRIPTION**	**SPECIFICATION**	**Q'TY**
G1	5HFQLSA807AGC01	Pull film drive shaft	50 Ø X1010X912X15 LSA706AGC01	1
G2		Support Pole	LSA706A-GM01	3
G3		Support Pole	LSA706A-GM02	1
G4		Film Material Positioning Rod	LSA706A-GM03	2
G5		Rear Material Roller	LSA706A-GM05	2
G6		Rear Material Roller Axis	LSA706A-GM06	2
G7		Counterweight	LSA706A-GM07	1
G8		Counterweight Fixed Rod	LSA706A-GM08	1
G9		Eccentric Wheel	LSA706A-GM09	1
G10		Eccentric Wheel-1	LSA706A-GM10	1
G11		Tension Roller	LSA706A-GM11	1
G12		Tightening Lever	LSA706A-GM12	1
G13		Pull-Ring Fixed Pedestal	LSA706A-GM13	1
G14		Screw	LSA706A-GM14	1
G15		Roller	LSA706A-GM15	1
G16		Touch Rod Center Axle	LSA706A-GM16	1
G17		Fixed Plate	LSA706A-GM17	2
G18		Axle	LSA706A-GM18	1
G19		Roller	LSA706A-GM19	3
G20		Axle	LSA706A-GM20	3
G21	HHMLSA504CXG01	Pinhole Ring	LSA504	8
G22		Fixed Pedestal	LSA706A-GP01	1

ITEM	PART NUMBER	DESCRIPTION	SPECIFICATION	Q'TY
G23		Fixed Pedestal	LSA706A-GP02	1
G24		Left Shutter	LSA706A-GP03	1
G25		Right Shutter	LSA706A-GP04	1
G26		Tension Adjustment Plate	LSA706A-GP05	2
G27		Linkage for Rod Holder	LSA706A-GP06	2
G28		Linkage for Lever Stopper	LSA706A-GP07	2
G29		Blown Film Separation Board	LSA706A-GP088	1
G30		Fixed Pedestal - 1	LSA706A-GP099	1
G31		Fixed Pedestal - 2	LSA706A-GP10	1

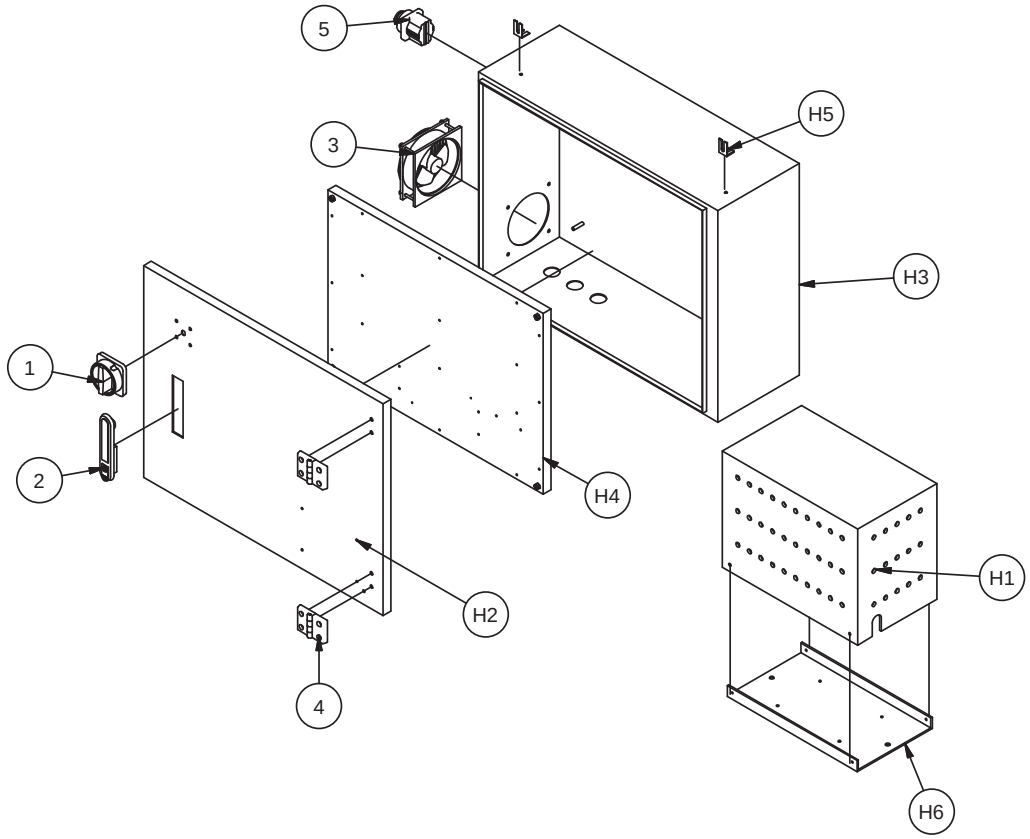
Control Box, Control Panel (Human Interface Display [HID]), Button Switches, and Labels



ITEM	PART NUMBER	DESCRIPTION	SPECIFICATION	Q'TY
1	5CE11AIG32MQ02D	Monochrome HID	AIG32MQ02DR	1
2	5AB66ABLFS22NA8G	Flat Head Illuminated Pushbutton	FHD-NLB22-F11GA 1A1B AC24V green	1
3	5AB31ABF221B2R	Flat Head Pushbutton Switch	FHD-NPB22-F01R 220V red	1
4	5AB33SHAF2212B2R	Chain Button Switch	FHD-NPB22-R02 2B220V arrow	1
5	5AA01E5CCRX2DSM802	Temperature Controller	E5CC-RX2DSM-802 AC/DC24	1
6	5FD0133X25X45	Acrylic Signs	NP-22 2TX35X45 START	2
7	5FD0132X25X45	Acrylic Signs	NP-22 2TX45 STOP	1
8	5FD0106X40X12	Acrylic Signs	2TX40X12 E-STOP	1
9	5FD0160X40X12	Acrylic Signs	2TX40X12 M.D. THERMO	1
10	5FD0161X40X12	Acrylic Signs	2TX40X12 M.D. THERMO.	1
11	5E102H24B	Open and Close	H-24-B	1
ITEM	**PART NUMBER**	**DESCRIPTION**	**SPECIFICATION**	**Q'TY**
H1		Control Panel	LSA706A-HP04	1

ITEM	PART NUMBER	DESCRIPTION	SPECIFICATION	Q'TY
H2		Human Interface Distribution Box	LSA706A-HP05	1
H3		Control Box Cover	LSA706A-HP07	1

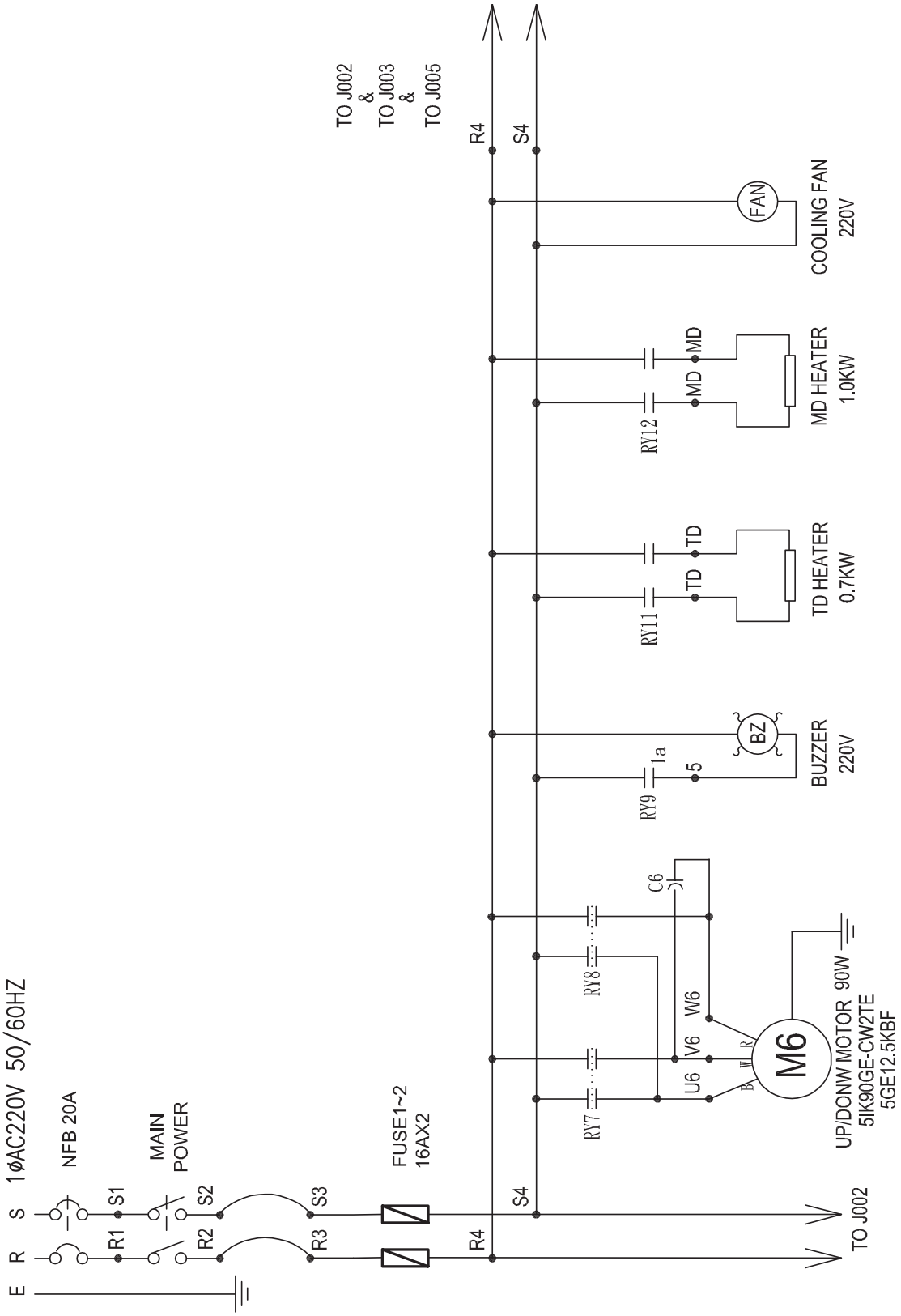
Main Power Box with Latch Switch, Cooling Fan & Transformer Guard



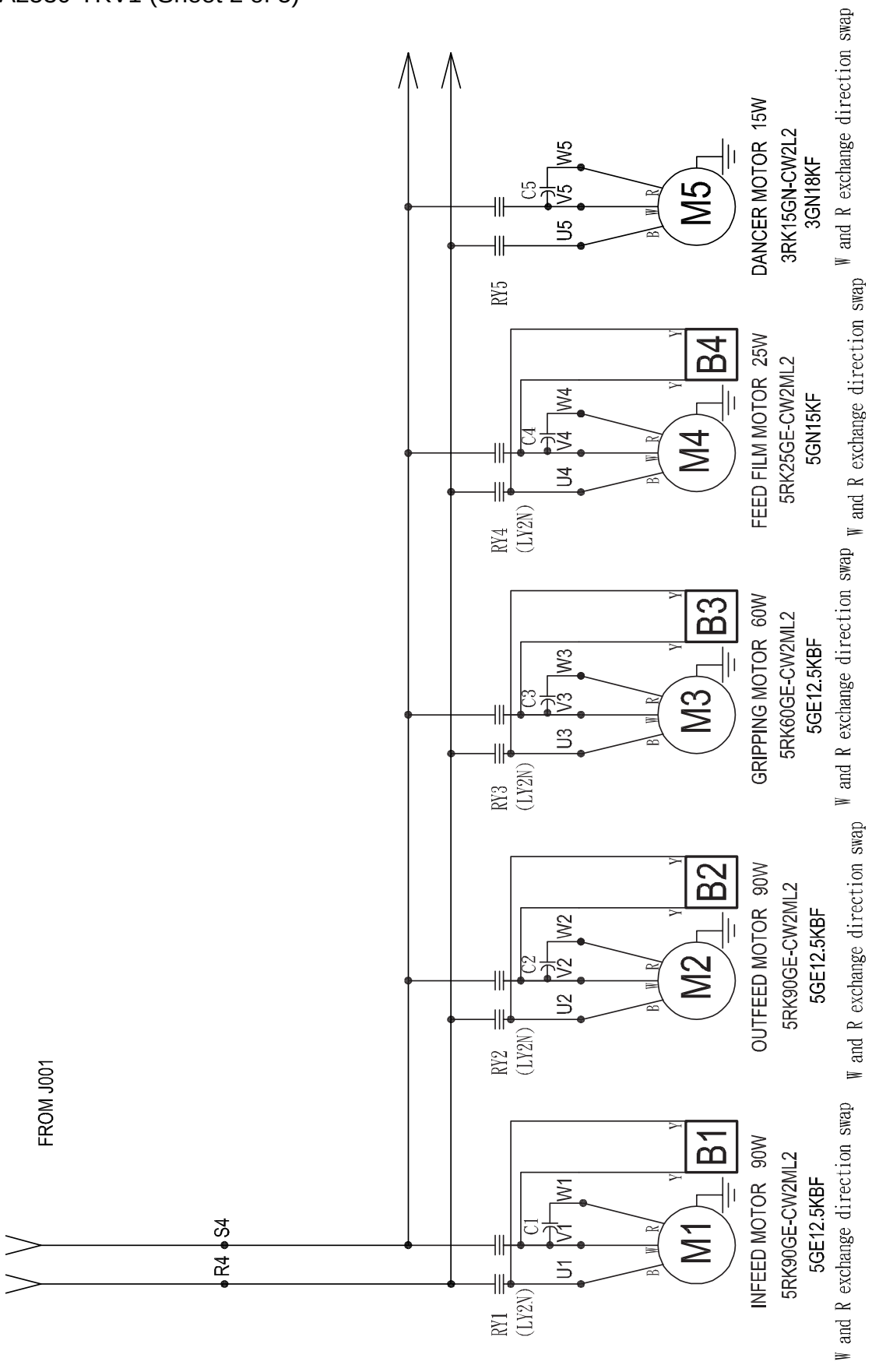
ITEM	PART NUMBER	DESCRIPTION	SPECIFICATION	Q'TY
1	5AB16ZHC316	Power Switch	FCH-ZH-C316 3B16A Separate	1
2	5E102RV2201	Telescopic Handle	RV-220-1	1
3	5AG1312X12X2	Cooling Fan with Net	12XCN 220V ACIUF120B2-FG120	1
4	5BC4514104	Door Hinge	14104	2
5	5AA18TBY302	Buzzer	TBY-302-220V	1
ITEM	**PART NUMBER**	**DESCRIPTION**	**SPECIFICATION**	**Q'TY**
H1		Transformer Guard	LSA706A-HC01	1
H2		Distribution Box Door	LSA706A-HP01	1
H3		Distribution Box	LSA706A-HP02	1
H4		Switchboard	LSA706A-HP03	1
H5		Distribution Box Fixed Seat	LSA706A-HP06	2
H6		Transformer Base	LSA706A-HP08	1

Appendix A: Electrical Schematics

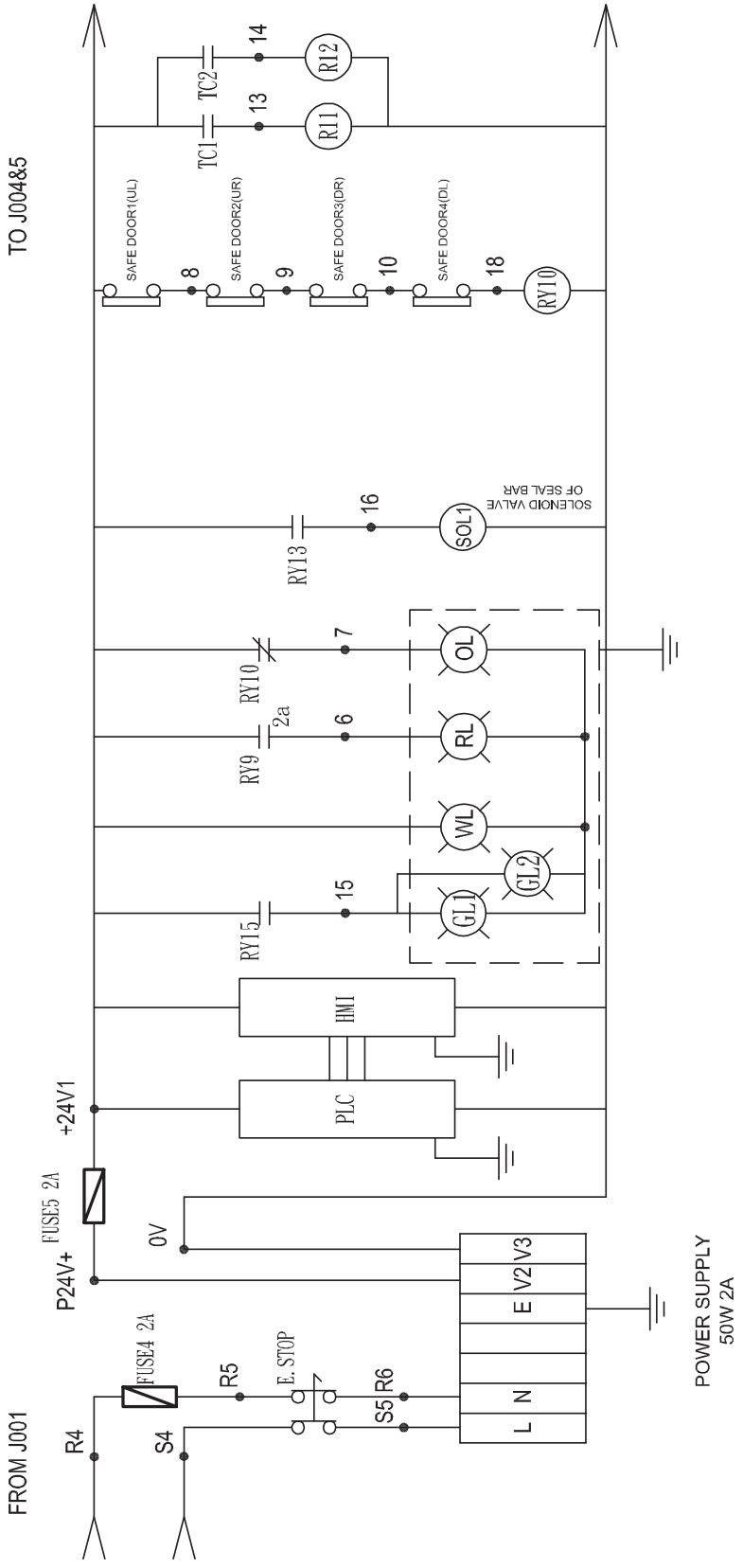
Electrical Schematics — VSA2530-TKV1



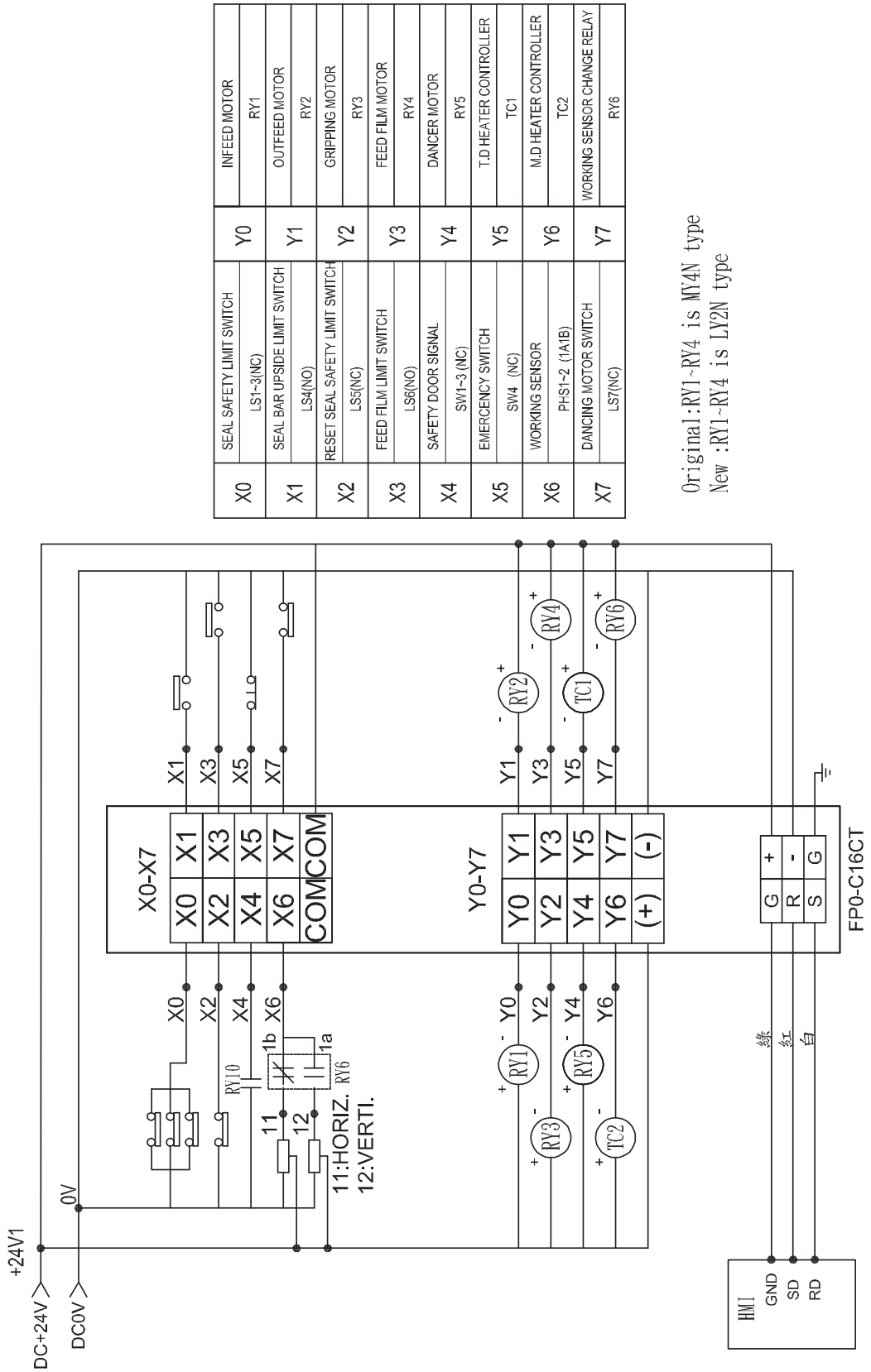
VSA2530-TKV1 (Sheet 2 of 5)



VSA2530-TKV1 (Sheet 3 of 5)

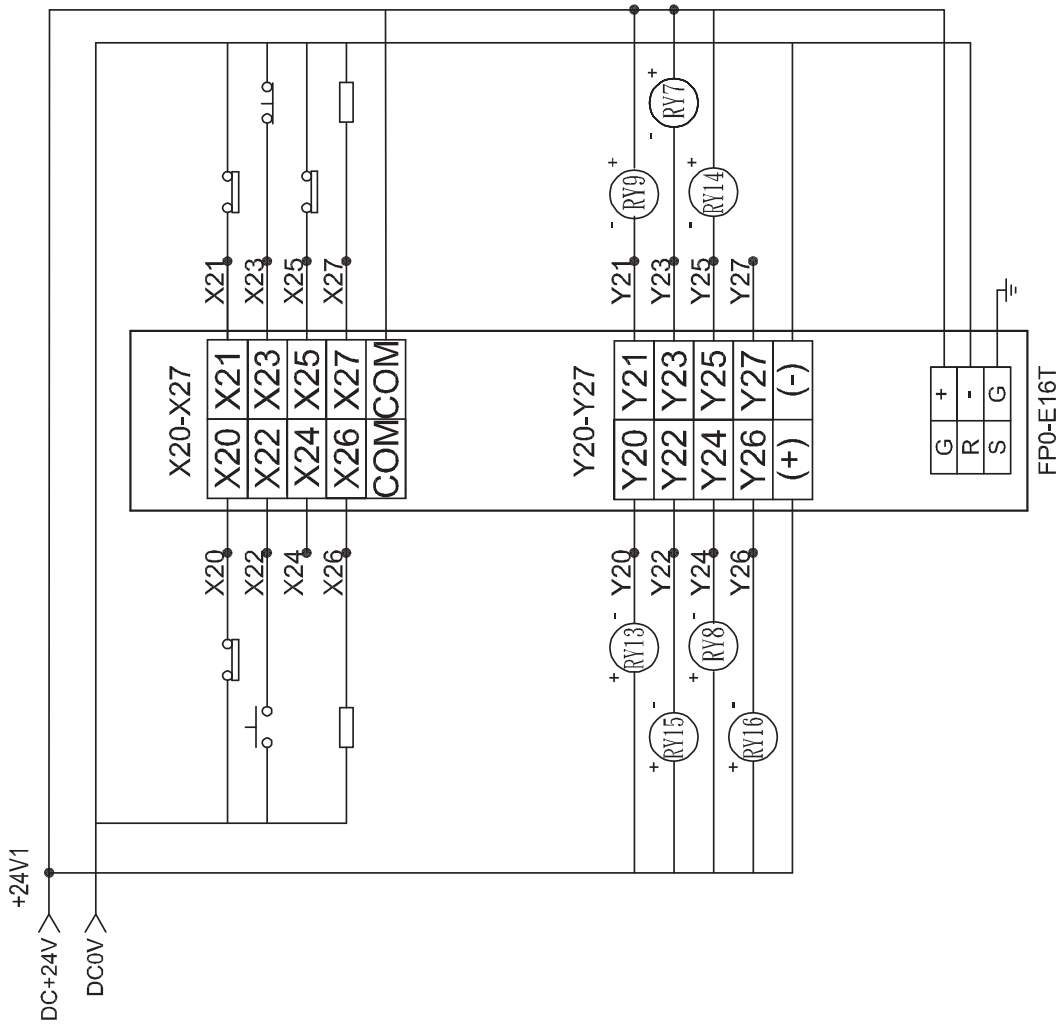


VSA2530-TKV1 (Sheet 4 of 5)



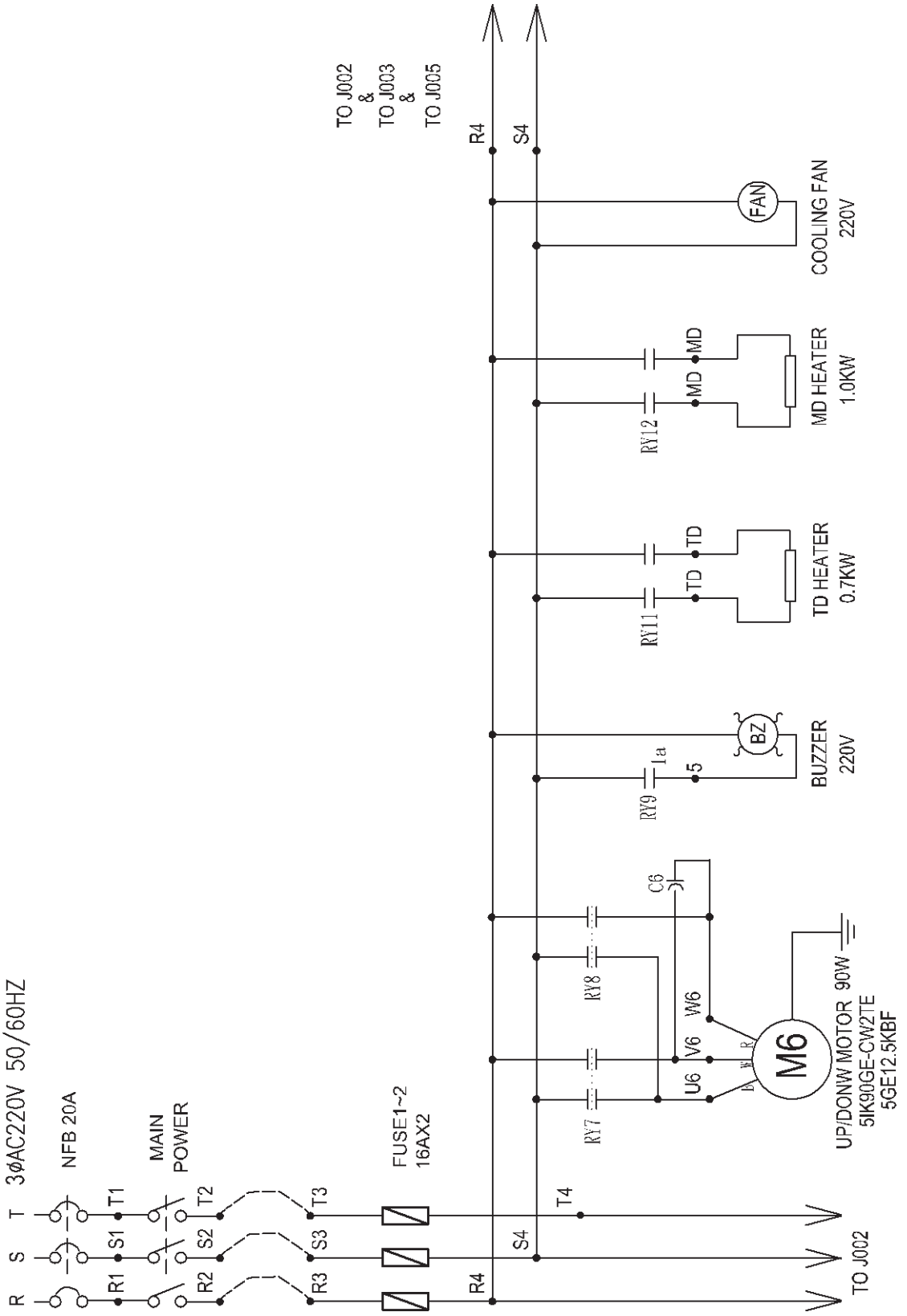
VSA2530-TKV1 (Sheet 5 of 5)

X20	SEAL BAR TOP LIMIT LS8(NC)	Y20	SOLENOID VALVE OF SEAL BAR RY13		
X21	SEAL BAR BOTTOM LIMIT LS9(NC)	Y21	BUZZER RY9		
X22	WORKING (ON) SW5(NO)	Y22	TOWER LAMP (GREEN LAMP) RY14		
X23	WORKING (OFF) SW6(NC)	Y23	SEAL BAR UP RELAY RY7		
X24	SPARE	Y24	SEAL BAR DOWN RELAY RY8		
X25	SPARE	Y25	SPARE		
X26	SPARE	Y26	SPARE		
X27	SPARE	Y27	SPARE		

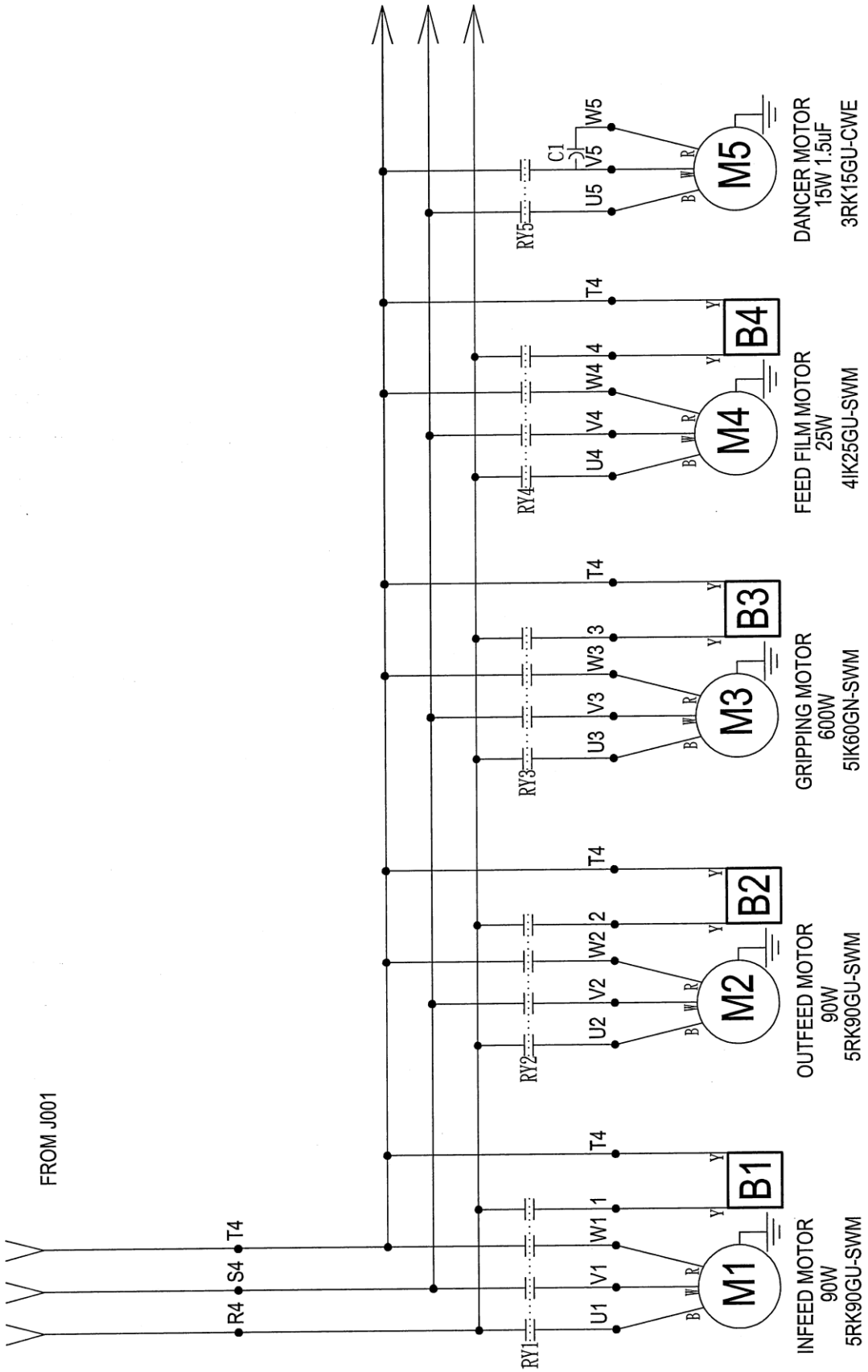


Electrical Schematics — VSA2530-TKV2

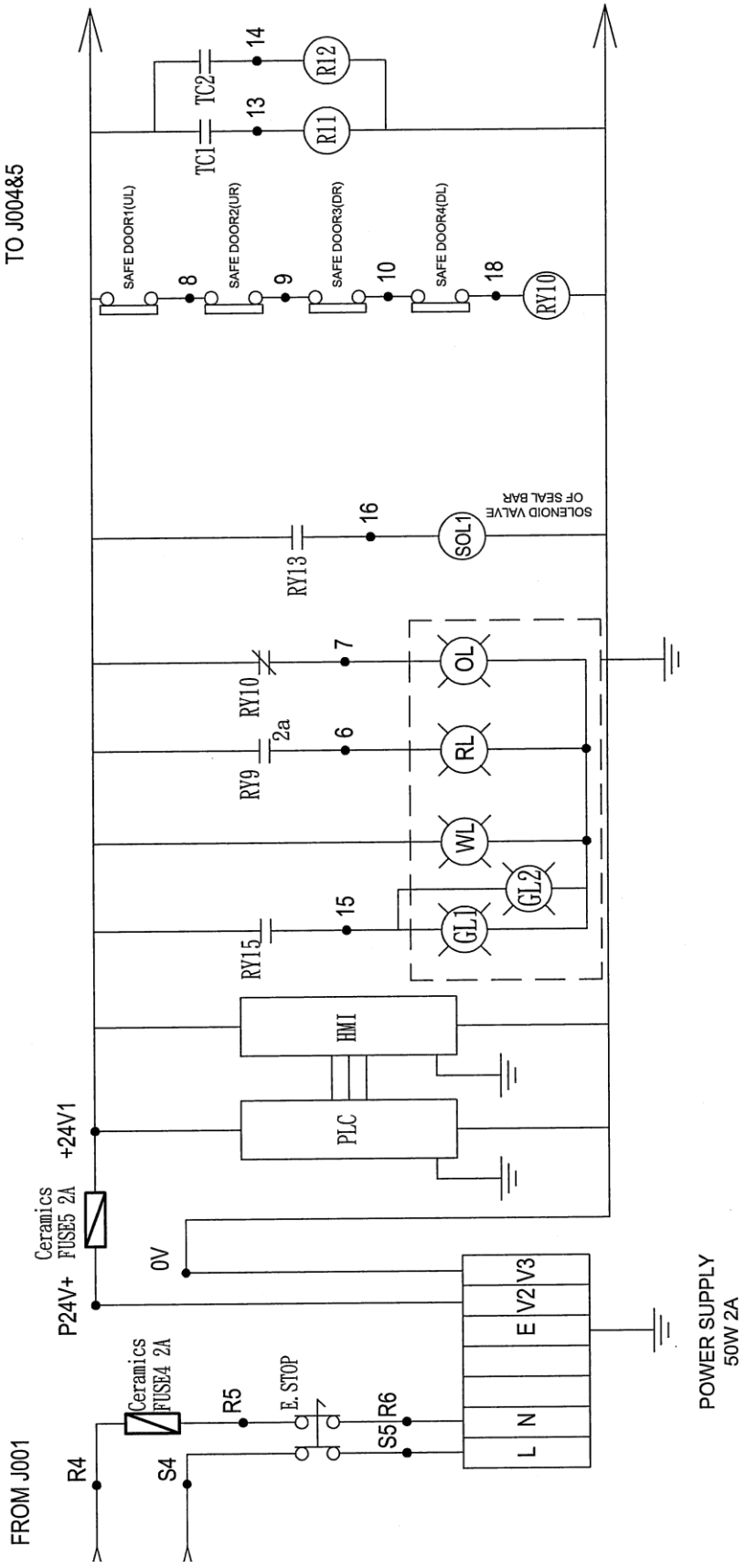
VSA2530-TKV2 (Sheet 1 of 6)



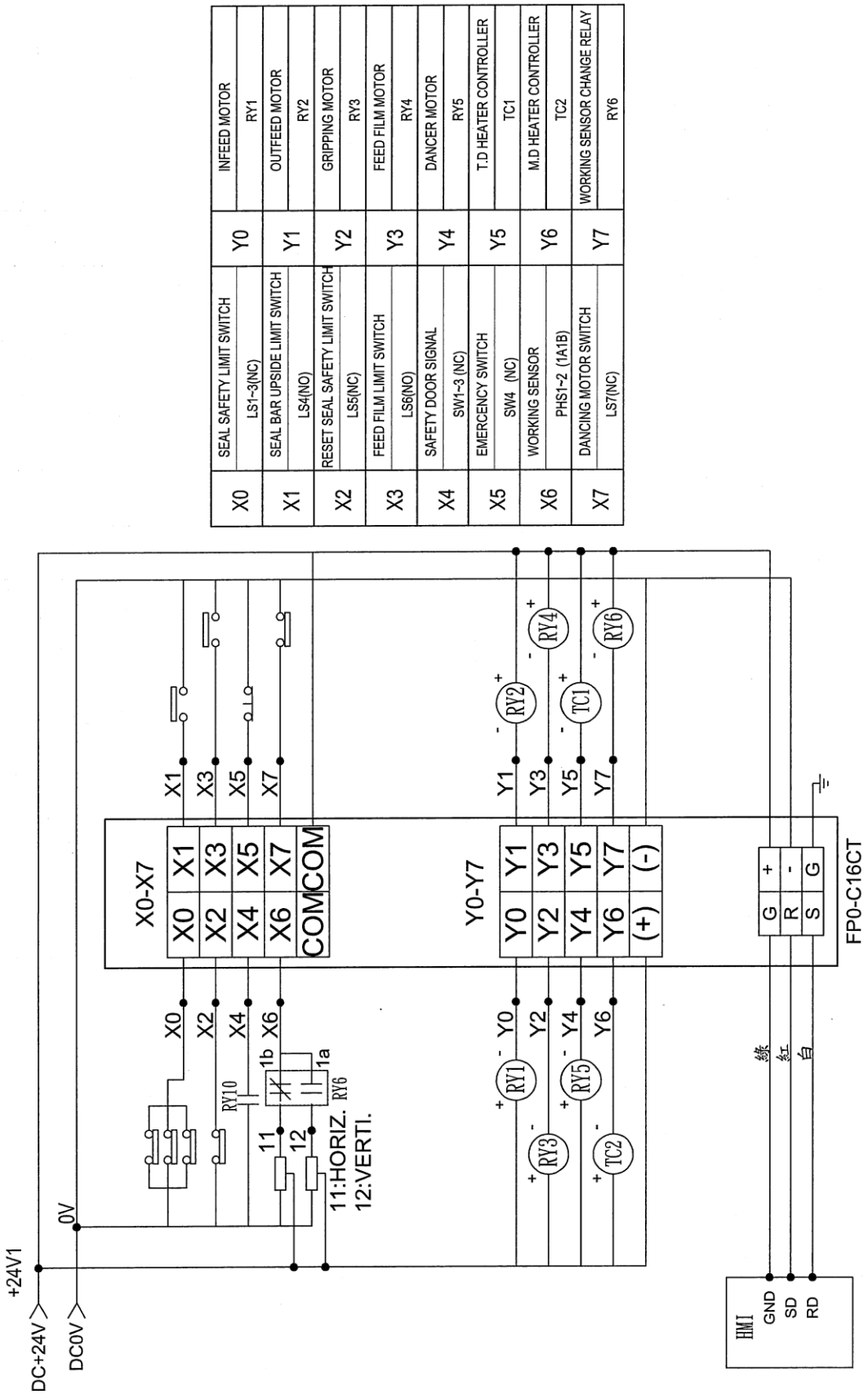
VSA2530-TKV2 (Sheet 2 of 6)



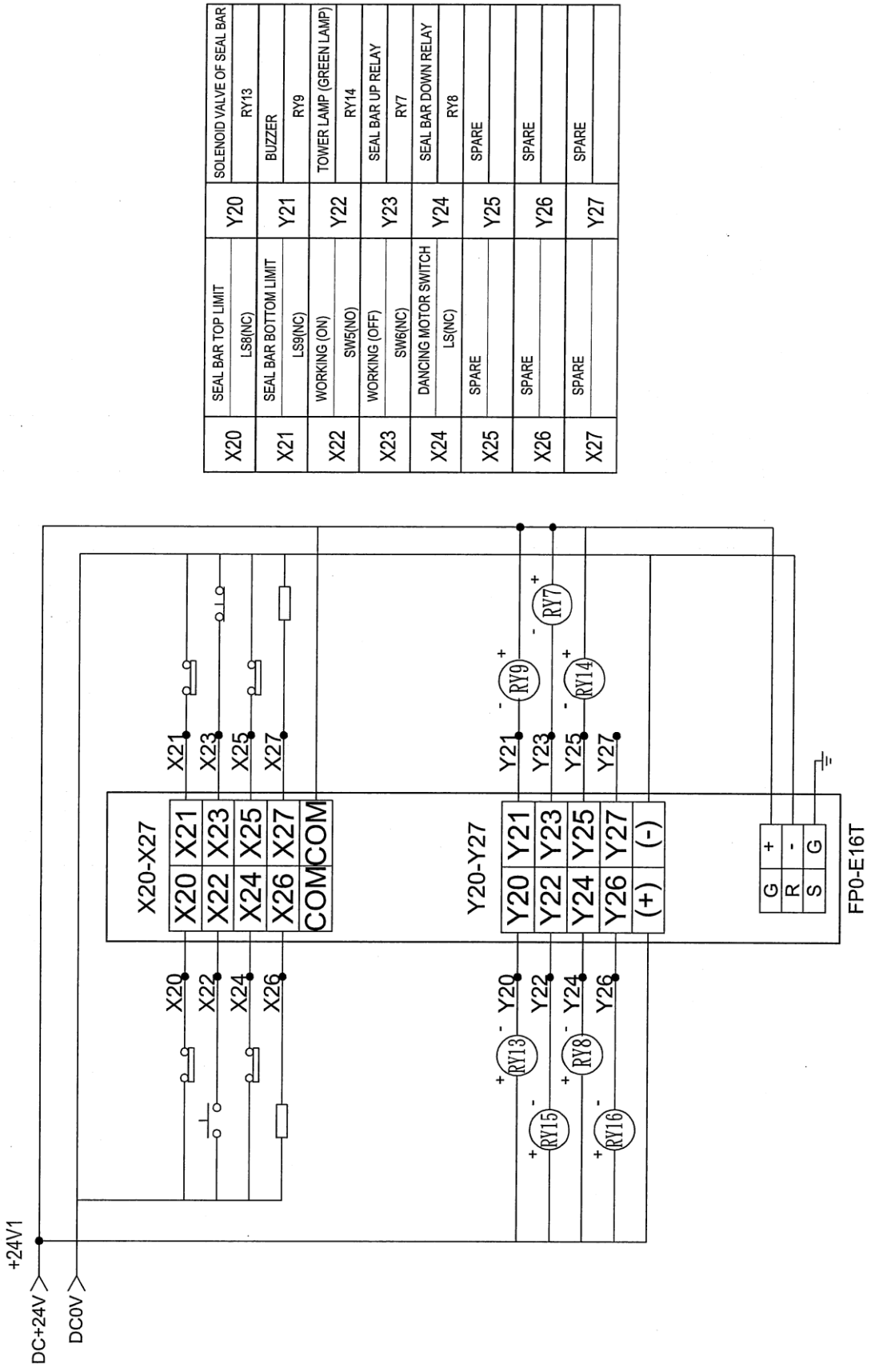
VSA2530-TKV2 (Sheet 3 of 6)



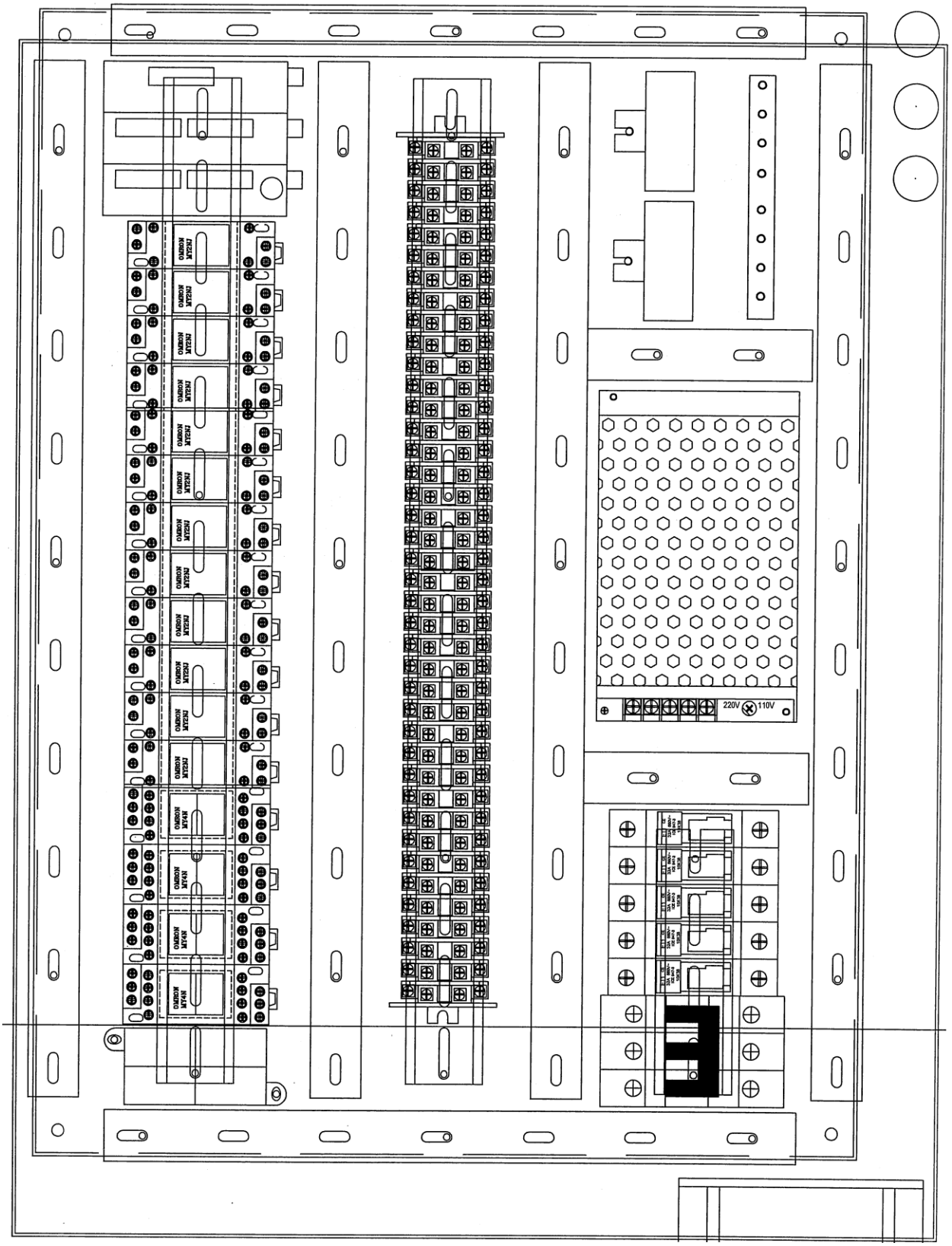
VSA2530-TKV2 (Sheet 4 of 6)



VSA2530-TKV2 (Sheet 5 of 6)

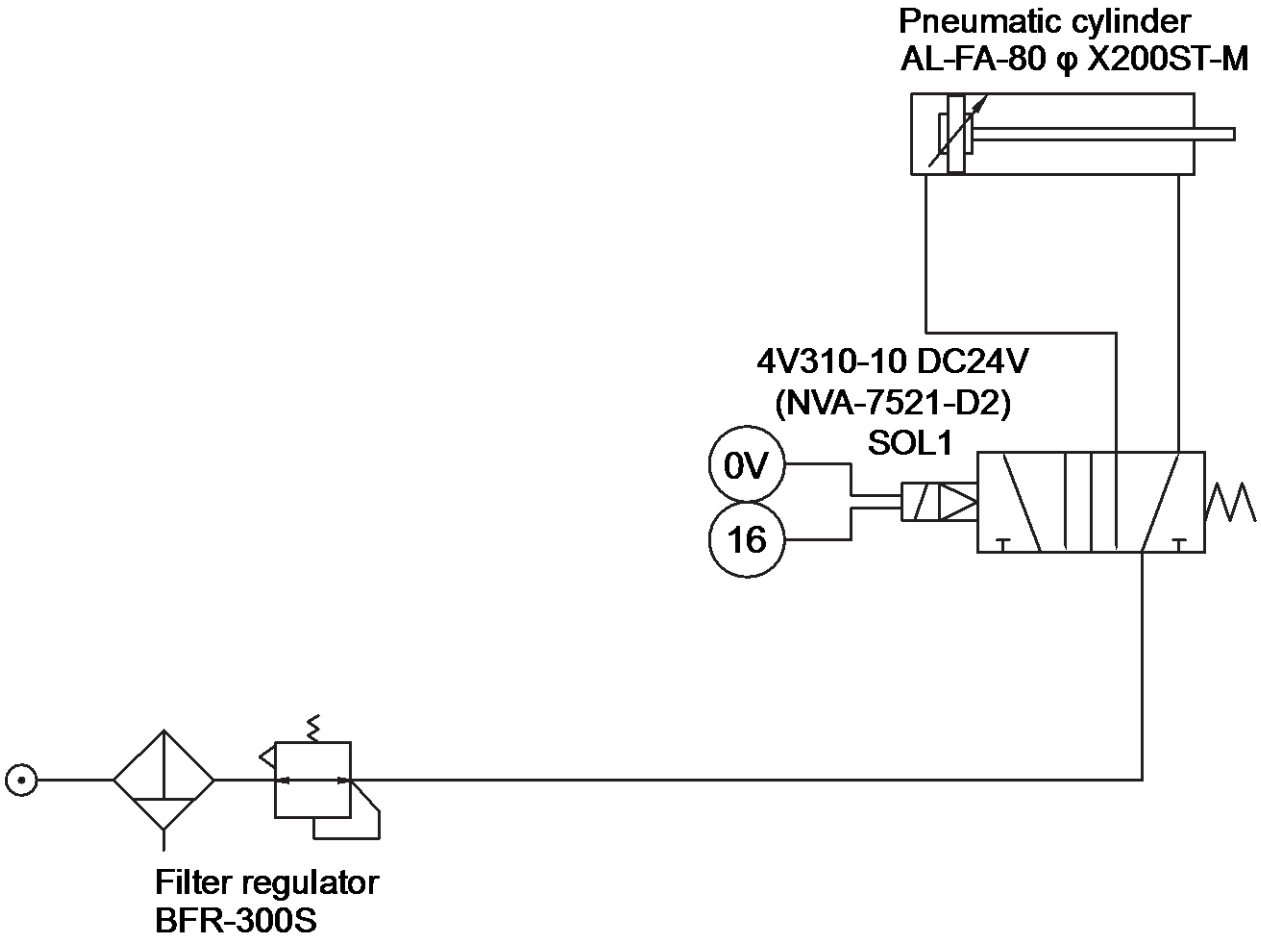


VSA2530-TKV2 (Sheet 6 of 6)



Appendix B: Air Diagram

Pneumatic Schematic



Appendix C: Temperature Setting Specifications for Shrink-Wrap Plastics

Mushroom Insert

PVC (Poly-Vinyl Chloride)	Temperature settings:	325° F front bar; 325° F side bar
	Pad type:	Felt
	Dwell Time:	Approximately 1 second
Polyolefin	Temperature settings:	335° F front bar; 335° F side bar
	Pad type:	Sponge rubber
	Dwell Time:	Approximately 1 second
Polyethylene	Temperature settings:	360° F front bar; 360° F side bar
	Pad type:	Sponge rubber
	Dwell Time:	Approximately 1.5 second

Warranty Statement

VSA Value Series Semi-Automatic L-Sealers

Warranty Statement
Eastey warrants that all of the products it ships will be in good working order and free from defects in material and workmanship for a period of two (2) years from the date of shipment by Eastey and will conform to the published specifications for that product. Spare parts that are manufactured in house by Eastey will be warranted for two (2) years. Bought out parts will be warranted for one (1) year.

Warranty Period – Specific Items

Drive motor(s):	1 year
Gear reducer:	1 year
Termination Post	30 days
Conveyor Belt	30 days
Hole Punches	30 days (ball and die)
Knurled Nut	30 days

The following parts are considered to be consumable items and not under warranty: fuses, ¼" × ¾" sponge rubber, copper heat sinks, 036 nickel-chrome alloy heating wire, ¾" PTFE tape, and ½" PTFE tape.

All other parts: 1 year (Except for moving parts which are subject to normal wear, tear and replacement which are warranted to be free from defects in material and workmanship.)

Sealing Quality
Sealing quality achieved in a given application is dependent on the installation, the material handling, and the maintenance provided. Eastey makes no warranty that the sealing quality achieved in an application will be the same as that achieved on a test piece in our demo facility.

Shipping Policy
Customer pays all incoming shipping. If the item is defective and under warranty, Eastey pays return shipping charges for least costly method. If expedited shipping is desired, customer must furnish his shipping account and shipping fees will be charged to that account.

Warranty Verification
If you conclude that a product may be defective and may be covered by warranty, obtain a Return Material Authorization number by calling our technical support number (toll free at 1-800-835-9344, or 763-428-4846 or Fax: 763-795-8867 or e-mail: info@eastey.com). Once an RMA has been obtained, return the defective item to Eastey. Eastey will analyze the product and, if found to be defective, we will at our

opion, replace or repair the item. If the item is found to be defective, we will, at our option, replace or repair the item. If the item is found to not be eligible for warranty, you will be notified and may decide on disposition. Defective products will be replaced or repaired as promptly as possible.

Warranty Eligibility
The warranty provided by Eastey is only to the original buyer.

Limited Warranty
THE ABOVE WARRANTY IS EXCLUSIVE AND IN LIEU OF ALL OTHER WARRANTIES, WHETHER EXPRESSED OR IMPLIED, INCLUDING THE IMPLIED WARRANTIES OF MERCHANTABILITY, FITNESS FOR A PARTICULAR PURPOSE AND NONINFRINGEMENT.

Disclaimer of Damages
REGARDLESS OF WHETHER ANY REMEDY SET FORTH HEREIN FAILS OF ITS ESSENTIAL PURPOSE, IN NO EVENT WILL EASTEY BE LIABLE FOR ANY SPECIAL, CONSEQUENTIAL, INDIRECT OR SIMILAR DAMAGES, INCLUDING LOST PROFIT OR LOST OPPORTUNITIES OF ANY TYPE ARISING OUT OF THE USE OR INABILITY TO USE THESE PRODUCTS EVEN IF EASTEY HAS BEEN ADVISED OF THE POSSIBILITY OF SUCH DAMAGES.

Customer Support

Eastey Technical Service

For help setting up or operating the VSA Value Series L-Sealer, please contact Eastey Technical Service at one of the numbers listed below.

Toll-Free Phone	800-835-9344
Phone	763-428-4846
Fax	763-795-8867
E-mail	info@eastey.com
Web	www.eastey.com

Thank you again for your purchase of Eastey products. We are pleased to be a part of your packaging needs.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