

# SERVICE MANUAL



**Model PP-76ST**

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INSTRUCTIONS FOR OPERATION AND REPAIR OF THE  
MODEL PP-76ST "ALL-IN-ONE" MACHINE

**IMPORTANT - PLEASE READ THIS CAREFULLY**

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. The part you the user play through proper installation and maintenance procedures is of far greater significance than our designs. Only properly trained individuals following rigidly enforced safety rules, as recommended by A.N.S.I. and O.S.H.A., should be allowed to operate these machines.

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## Safety Precautions

1. To avoid damage to the machine and injury to the operator, **Do Not** use liquids of any kind: flammable materials, explosive materials, materials under extreme pressure, pressurized gases, volatile powders, or bulk materials that could fall through holes in grate, or any materials and/or products not listed but which could cause harm to operator.
2. **Do not touch** the band ribbon soon after sealing due to residual heat that may burn.
3. **Do not touch** the heater cover plate while machine is on.
4. **Do not touch** the fan while in operation or use machine without grate in place.

## **IMPORTANT WARRANTY NOTICES**

### **OPERATING AND MAINTENANCE MANUAL**

The operating and maintenance manual has been carefully prepared to provide the user with all the information needed to properly install, operate, and maintain your Excel Packaging equipment.

Please read this manual carefully and refer to it for information on the care and use of your Excel Packaging equipment. It is recommended that additional copies be ordered for use by production, maintenance, and supervisory personnel. Although the design of this equipment incorporates safeguards to protect personnel, care should be used in operating, adjusting, and servicing.

Attention is directed to the warranty which accompanies all your Excel Packaging equipment. The terms and conditions of this warranty apply only to unmodified units. **Any unauthorized modifications to the equipment automatically voids this warranty.**

**Excel Packaging provides a one year warranty on parts, excluding shipping or freight costs for replacement parts. All warranty parts are shipped F.O.B. Ontario, California.**

# EXCEL PACKAGING

# WARRANTY

Excel Packaging, Inc. warrants each new product manufactured to be free from defects in material and workmanship for a period of (2) years from date of shipment by Excel Packaging.

This warranty is not transferable with any subsequent resale.

Defective parts under warranty must be returned to Excel Packaging freight prepaid. Excel Packaging's sole obligation and purchaser's sole remedy in the event of a warranty dispute shall be, at Excel Packaging's option, to repair or replace the part in question. Labor incurred in removing or installing the defective part is not covered by this warranty. Prior to returning any parts for any reason, contact Excel Packaging for a Return Authorization Number. This number must accompany all returns.

This warranty shall not apply if equipment has been tampered with, misused, improperly installed, altered, or has received damage due to abuse, carelessness, accident or failure to follow recommended regular maintenance procedures or has been serviced by someone other than a duly authorized factory representative without the express written consent of Excel Packaging, Inc.

This warranty is in lieu of all other warranties, expressed or implied, including but not limited to warranties of merchantability and fitness for a particular purpose, non-infringement or any other matter.

Excel Packaging shall have no liability to any person for direct, indirect, incidental or consequential damages or delay resulting from any defect negligence, or tort and customer hereby waives for itself any and all claims for punitive damages and all claims of negligence

of strict liability or both. In no event shall our liability exceed the purchase price of the product that was actually paid.

Excel Packaging reserves the right to make changes, additions, or improvements to our products with no obligation to make such changes in any previously shipped product covered by this warranty.

Excel Packaging shall not be held liable for any damages arising out of or in connection with the operation of the equipment should customer or its agent fail to maintain equipment in safe operating condition. This warranty shall become unenforceable if and to the extent the customer or its agents remove, disconnect, or otherwise render useless any safety device and/or parts designed or affixed by us or fails to maintain and service equipment in a manner as advised.

**Excel Packaging provides a one-year warranty on parts, excluding shipping or freight costs for replacement parts. All warranty parts are shipped F.O.B. Ontario, California. Service Labor to install part is not covered under warranty!**

## **WARRANTY EXCEPTIONS**

The following sealer parts are considered to be consumable and not under warranty:

1. Silicone Sponge
2. Band Ribbon
3. Teflon Tapes
4. Transite Channels/Band Holder

# WARNINGS

Every effort has been taken to ensure your safety while operating this machine; however, there still remain certain risks. Do not allow this machine to be operated before informing all personnel of the following warnings.

## **WARNING.....**

Do not tamper with the electrical wiring. Only use a licensed electrician for maintenance. Always disconnect the electrical power before attempting any maintenance to all electrical and/or moving parts.

## **WARNING.....**

In order to prevent injury to personnel and/or machinery  
DO NOT INCREASE SETTINGS OR RATINGS ON EITHER ELECTRICAL  
OR MECHANICAL OVERLOAD SAFETY DEVICES.

## **WARNING.....**

KEEP HANDS AWAY FROM MOVING CONVEYORS AND  
ASSEMBLIES. Conveyor belts that have become worn or frayed are  
capable of being hazardous. They should be replaced promptly.

## **WARNING.....**

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 inrunning nip points, many of which are capable of  
causing severe injury and/or permanent disfigurement.

**WARNING.....**

To minimize the potential for personnel injury, always be sure that 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.

**WARNING.....**

Heat sealing arms and jaws on packaging machinery can become very warm after a period of use. KEEP HANDS AWAY WHILE IN OPERATION AND USE CAUTION IF THE MACHINE HAS BEEN RUNNING RECENTLY.

**WARNING.....**

ANY MODIFICATIONS TO EITHER THE ELECTRICAL CIRCUITRY OR THE MECHANICAL ASSEMBLIES OF THE MACHINERY WILL VOID ANY WARRANTIES ASSOCIATED WITH THIS EQUIPMENT. Such modifications may introduce hazards that would not otherwise be associated with this machinery. Excel Packaging will not be responsible for any consequences resulting from such unauthorized modifications.

**WARNING.....**

The use of certain types of plastic films in sealing and/or shrinking equipment may result in the release of HAZARDOUS FUMES due to the 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 MUST BE PROVIDED AT ALL TIMES.

**WARNING.....**

It is important that the machine operator unplug the machine when he/she has finished operating the unit.

## **DESCRIPTION AND SPECIFICATIONS OF PREFERRED PACK MODEL PP-76ST**

### **DESCRIPTION**

This compact "all-in-one" unit allows the operator to seal and shrink all in one step. The operator simply places the product in the sealing area and lowers the hood to apply the seal pressure necessary to cut the film. Once the seal cycle is complete, the operator releases the handle and the shrink chamber is automatically held shut by the magnet. Once the shrink time is complete, the chamber opens and the operator removes the finished product.

The purpose of a PP-76ST is for low to medium volume packaging requiring excellent seals and minimal maintenance. It features an impulse mode for sealing of films using "Band Seal Technology."

### **SPECIFICATIONS**

Model:	PP-76ST
Seal Area:	20" 16"
Machine Size:	56" 30" 45"
Volts:	220
Phase:	1
Amperage:	25
Weight:	300

## UNPACKING

### THOROUGHLY INSPECT EQUIPMENT UPON ARRIVAL.

If goods are received short or in a damaged condition, it is important that you notify the carrier's driver **before he leaves your company** and **insist** on a notation of the loss or damage across the face of the freight bill. Unless this is done, no claim can be enforced against the transportation company.

If concealed loss or damage is discovered, notify the carrier at once and **insist** on an inspection. This is absolutely necessary! A concealed damage report must be made no later than Five (5) days from the date the shipment was delivered. Unless you do this, the carrier will not consider any claim for loss or damage. The carrier's agent will then 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 filed within Five (5) days of delivery date or carrier will not accept them.

Excel Packaging is willing to assist in every possible manner to collect claims for loss or damage; however, this does not hold Excel Packaging responsible for collection on claims or replacement of material.

Your new Preferred Pack Model PP-76ST comes bolted to a pallet and has a tri-walled corrugated box strapped to the pallet to protect it. Cut steel straps and remove corrugated box.

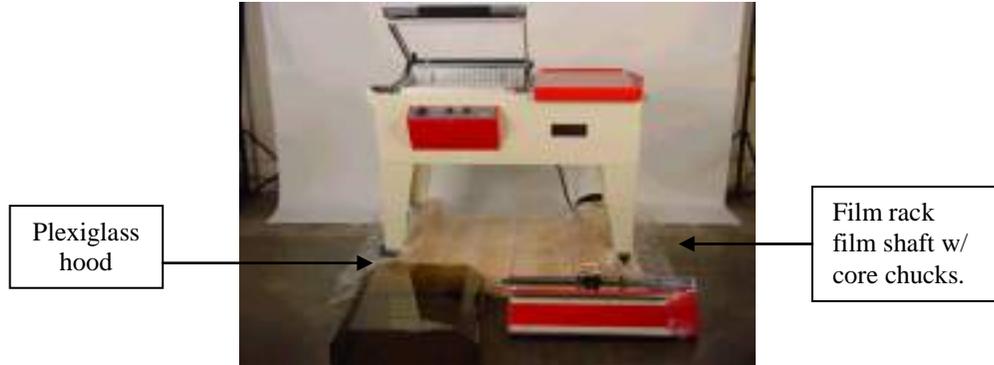


1. If your machine does not arrive in this condition, **write on shipping paperwork that outside of box is damaged. Concealed damage may have occurred.** Before you sign off on delivery paperwork, open box and inspect for damage.



2. Remove protective plastic covering from machine.

3. Check contents. You should have



- (a) (1) Film Rack
- (b) (1) Film Shaft
- (c) (2) Film Roll Core Chucks
- (d) (1) Plexiglass Hood



4. Remove bolts holding machine from pallet using 13mm wrench.

## **INSTALLATION AND BASIC SET-UP OF MACHINE**

### **IMPORTANT**

Read this manual carefully, and make it available to everyone connected with the supervision, maintenance, or production of this machine. Additional copies are available at your request. (Contact your distributor for this information.) Be very careful when operating, adjusting, or servicing this equipment. If in doubt, stop and obtain qualified help before proceeding.

### **INSTALLATION OF PP-76ST**

Place the PP-76ST in the desired location with the required electrical power source available. (See power requirements.) Make certain that proper electrical wiring is provided to guard against low voltage. If the voltage is too low, the equipment will not function properly.

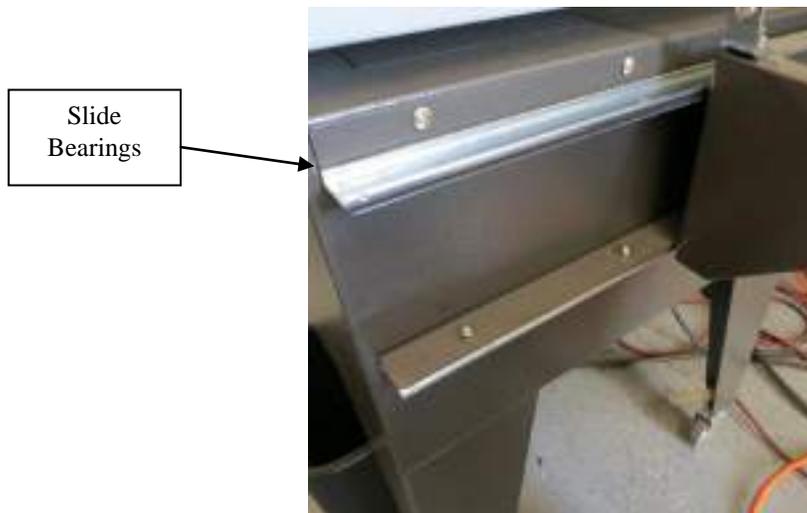
Finding the proper location is a most important function of the initial set-up. One must take several factors into consideration:

1. Adequate power source.
2. Relationship to source of product.
3. Relationship to machine.
4. Relationship to any conveyors necessary to remove finished product.
5. Convenience of operator.

**Model PP-76ST comes with power cord but no plug. It is the customer's responsibility to match plug with receptacle use. This machine is 220 Volt, 1 phase, 25 AMP.**

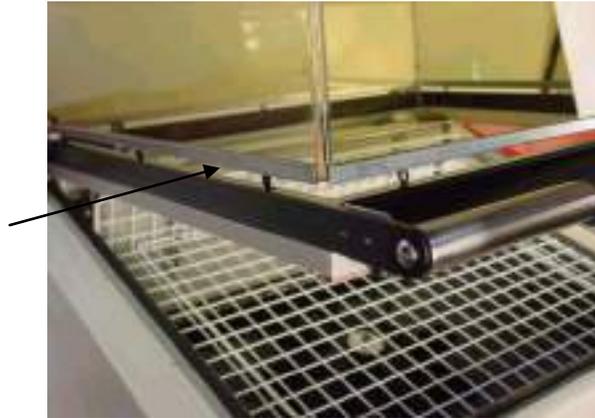
Do not attempt to install, adjust, or operate this machine without first reading the contents of this manual. Although the design of the equipment incorporates safeguards to protect operating and maintenance personnel, care should be used in operating, adjusting, and servicing.

### **INSTALLING FILM RACK**



1. Position the film rack to the right side and install the mounting screws.

## Installing Plexiglass Hood



Position plexiglass hood over frame of seal chamber- as shown. The **(self locking)** metal clips will automatically lock in position as they are pushed downward into holes on frame.

## MOUNTING FILM

Select the proper width of center-fold film for the item being packaged, allowing for width and height of package. With the package properly positioned within the film in the sealing area, allow sufficient film to overlap the sealing bars so that a seal may readily be made without any possibility of open areas due to insufficient film.



Place film roll on shaft using the two core chucks provided to locate film. Tighten core chucks. The center-fold is to be placed away from the operator, toward the rear of the machine. Position film roll on shaft and tighten film core chuck to hold film roll in position.

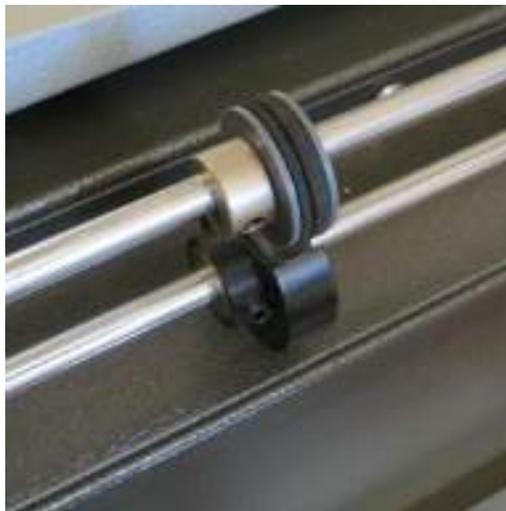
Thread film through the two Pin Perforator wheels provided. Note that the perforator wheel turns freely and is not binding.

Once threaded, separate film top from bottom and insert product tray between. Make sure that the center-fold of film is placed at the rear of the product tray. This allows the operator to insert product between the layers of film on the product tray and to prepare to move product and film into the sealing area. When threading film, make sure to pull more than sufficient film through the rollers, across the product tray, and into the sealing area to ensure sufficient film to begin operation.

Place product toward rear of film separator tray. Then move product into seal area. Be sure to leave the bag loose around the product when making the seal. This helps eliminate the seals from

blowing out in the shrink chamber. This completes threading and/or mounting film.

### **PIN PERFORATOR**

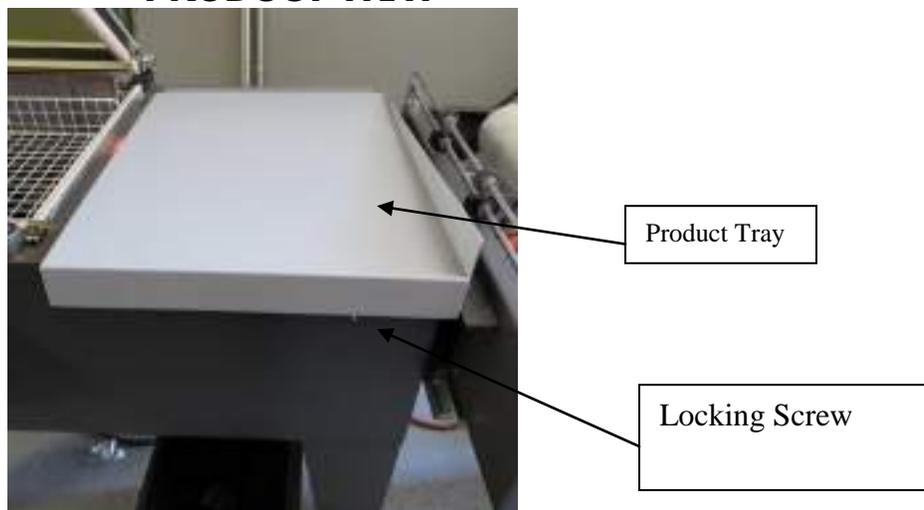


Located between the film roll and the product tray, the pin perforator creates holes for air to escape as the operator pulls on the film. This allows the air to escape as the package shrinks in the chamber.

The pin perforator is adjustable and must be properly placed in conjunction with the width of the desired package. The positioning should always be re-evaluated when setting the machine for different size product or different size film.

Adjustments to Pin Perforating wheels can be made using the Allen key provided. The Pin Perforator assembly is composed of two components: (1) wheel with pins and (2) grooved wheel without pins on a concentric cam. To adjust pin wheels depth, use Allen key provided and adjust wheel without pins using the concentric cam to turn wheel on shaft to position wheel deeper into pins. Then re-lock Allen screws.

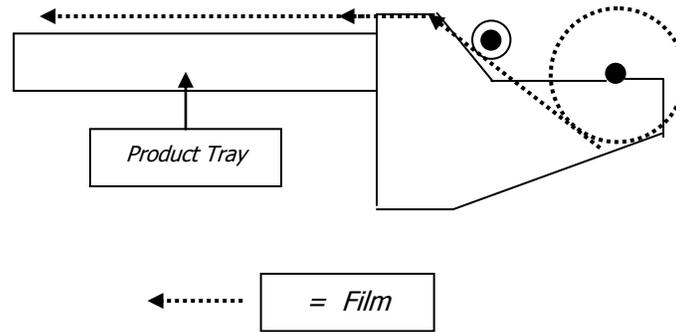
## PRODUCT TRAY



The product tray is an adjustable metal platform used to separate film and to insert product between top and bottom layers of film.

The product tray has a locking screw underneath the front side of the loading tray to keep the tray from moving during the sealing process

# FILM THREADING DIAGRAM



## Preferred Pack Model PP-76ST-Front Control Panel



- Main switch is in OFF position. Machine will not operate.



- Main switch in SEAL only position (ON1). Machine will only seal product. NOT shrink.

**NOTE:** When the switch is in the SEAL ONLY position, the heater in the chamber is off.



- Main switch in SEAL and SHRINK position, both functions are available. Machine will take approximately 10-15 minutes to warm up. You will know it is ready when chamber temperature thermostat goes off.



**Seal Time:** Amount of time band ribbon heats up.

Recommended setting for PVC: .75 to 1

Recommended setting for Polyolefin: .5 to 1

**Note:** The proper seal time is the shortest time possible to cleanly seal and cut your film. Always start with a shorter seal time where the film will **NOT** cut cleanly, then **increase** dial setting to achieve desired results.

1. **Shrink Time:** Amount of time the air will blow in chamber.

Recommended setting for PVC Film: 3-5

Recommended setting for Polyolefin Film: 4-5

**Note:** These are only a suggested starting point when setting up your machine. These settings will vary depending on the shape of your product and the film thickness used. Remember that thinner gauge films require less heat and less shrink time.

2. **Chamber Temperature:** How hot chamber will become.

Recommended settings for PVC Film: 290-310

Recommended Settings for Polyolefin Film: 300-325

**Note:** These are only a suggested starting point when setting up your machine. These settings will vary depending on the shape of your product and the film thickness used. Remember that thinner gauge films require less heat and less shrink time.

## SEQUENCE OF OPERATION

- A. Product is placed on the film separator tray.
- B. The product tray functions as a means to separate the film, allowing placement of product between upper and lower portions of the film.
- C. Move product into seal area by pushing the product to the left.
- D. Manually pull the hooded chamber down. As the chamber meets the seal band ribbon, the machine automatically activates the band ribbon to heat up when touched.\*  
**NOTE:** If too much tension is on the film while the bag is being made, the seals will, more than likely, be weak or will "blow out" in the seal area while the shrinking process is occurring. Make sure to relax the film tension prior to sealing.
- E. The operator must lower the chamber until the magnets connect to ensure a good strong seal. Once the seal time is complete, the shrink process occurs. Timer is automatically activated and the shrink process occurs  
**NOTE:** The magnet in the left hand front corner will activate only during shrink time to allow the hooded chamber to stay closed during the shrink cycle.
- F. Once the seal time is complete, the shrink timer and magnet timers are activated. At this point, the hooded chamber will stay down automatically during the shrink cycle because the magnet is activated. When the shrink timer is complete, the magnet releases the chamber and it automatically raises allowing the operator to remove the completed product.

## SEQUENCE OF OPERATION

1. After completion of basic setup as described on pages 15-25 plug the sealer's cord into the power source (220 Volt, 1 phase, 25 Amp Service).

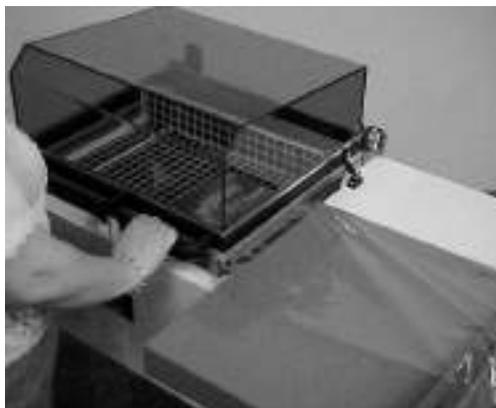


- A. With film threaded (see instructions for mounting film), place right hand on package and slide product into the upper left hand corner of the film (i.e., corner formed by folded rear edge of film and previously sealed left edge of film). Push the package toward the rear of the loading tray.



- B. Place **right hand** under top sheet of film and on front right corner of product. Place **left hand** on tail of both sheets of film. Now push the package with right hand and pull the film with left hand moving package and film into lower right corner of seal area. Allow from 1/2" to 1" of extra film around package. This will allow some slack

film between the package and the sealing bars, reducing film tension.



- C. Press hooded chamber handle down. Seal magnet will apply seal pressure and time depending on what seal time you set machine at.



- D. Shrinking chamber hood will automatically stay down during shrink cycle by use of the magnetic hold down. Magnet time will vary depending on where you set timer.



- E. Once shrink cycle time is complete, operator may remove completed product from chamber.



- F. Product will automatically transfer from chamber with **optional** powered discharge conveyor.
2. To increase cycle time and speed of operation, follow this procedure:



- A. Turn Selector switch to SEAL ONLY position.



- B. Place product into seal area and seal only, move sealed product to the left side of chamber and place another product in seal area.



- C. Turn selection switch back to the seal and shrink position (ON2).

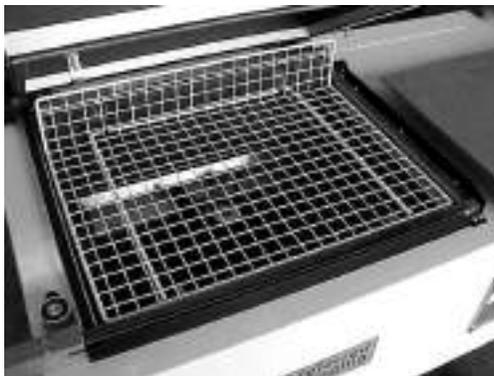


- D.** Place additional product into seal area and now seal and **shrink both products at the same time, increasing output of machine.**

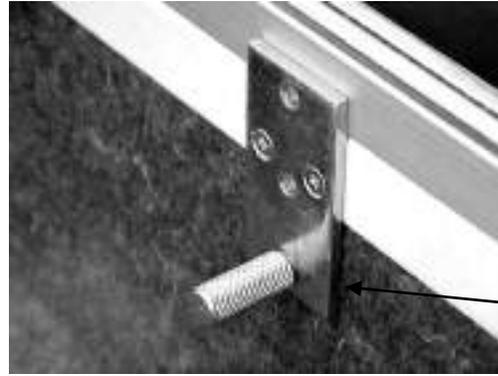
### **3. Adjusting Product Grill:**



- A.** If product is too tall, film tension is created, producing weak seals. Adjust product tray as follows:



*Remove Grill*



Lower  
Position

- B. Adjust grill lower by moving screws downward into lower threaded hole.



- C. Product now sits half way below seal pad. This will reduce film tension when sealing and place seal in center of package.



- D. With optional powered discharge conveyor, use adjustable crank handle to raise or lower conveyor height.

## TROUBLESHOOTING

The following guidelines are provided to aid in determining the source of any operation difficulties which may develop. In performing the tests and checks which follow, carefully inspect for any loose components, broken or loose wires, poor electrical connections, etc., while testing the various switches, controls, relays, transformers, etc. For checking electrical problems, use a voltage meter.

**Note:** While troubleshooting use caution to avoid danger of electrical shock. When power is not required for checking for the presence or value of voltages used, always have it disconnected.

**DISCONNECT ALL POWER BEFORE MAKING ANY REPAIRS.**

**REFER TO ELECTRICAL BOARD LAYOUT AND ELECTRICAL SCHEMATIC FOR LOCATION OF ELECTRICAL COMPONENTS**

### **NO HEAT TO BAND RIBBON**

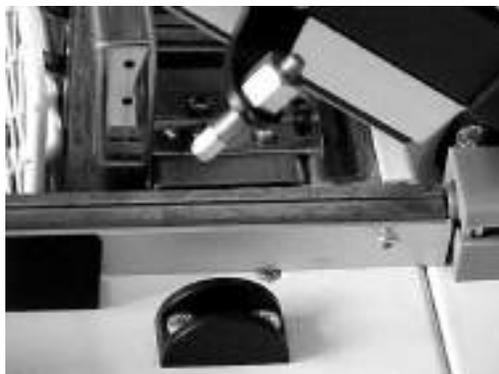


1. Check that the sealer is plugged in and that power is present at the socket. Make sure the power switch is in the **SEAL ONLY** or **SEAL AND SHRINK** position.

Seal timer not  
at zero



2. Make sure seal timer is **not** set on zero (0) on time dial.

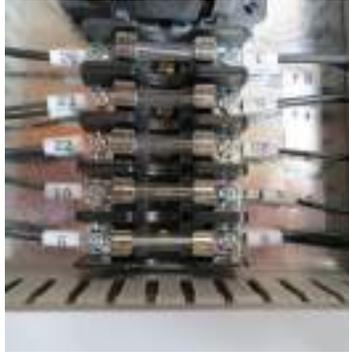


3. **Check pulse switch adjustment.**

- (a) Make sure switch is being activated when the seal bar is within  $\frac{1}{4}$ " of contact with seal pad.
- (b) Press switch by hand. If no click is heard, replace switch.

PP76ST

F1 – 20A  
 F2 – 2A  
 F3 – 2A  
 F4 – 1 A  
 F5 – 15A  
 F6- 15A



4. Check all fuses.



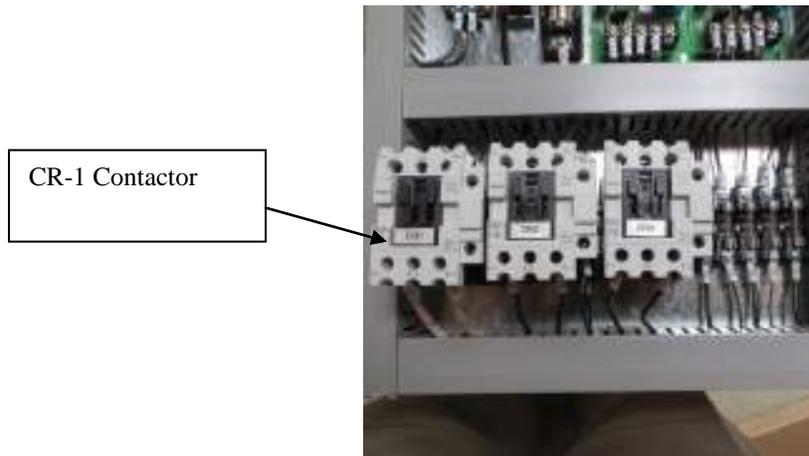
5. Check for broken band ribbon inside or outside the corner bead.



6. Check for bad connections on each end of band ribbon. Make sure wires are connected to each end of compensator.

**REPLACE if Broken!**

## No Heat to Hooded Chamber



1. Check to see CR1 contactor (For Heater) is ok and the points are not burned or no wire has come loose. When you bring hooded chamber down heater contactor should kick in, if not, replace contactor!



- 2. Close hooded chamber and check relay on heater timer board to see if relay is engaging and disengaging, if not, replace timer board.***

***Check Heaters:***



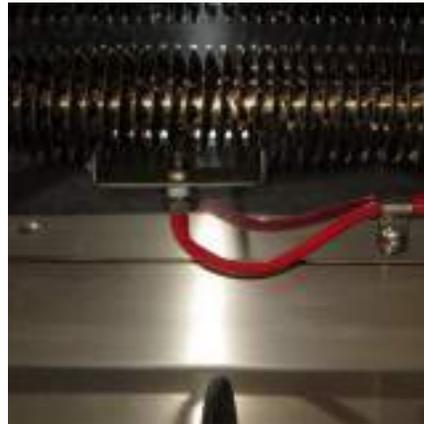
***Remove White grate***



***Remove front heater cover***



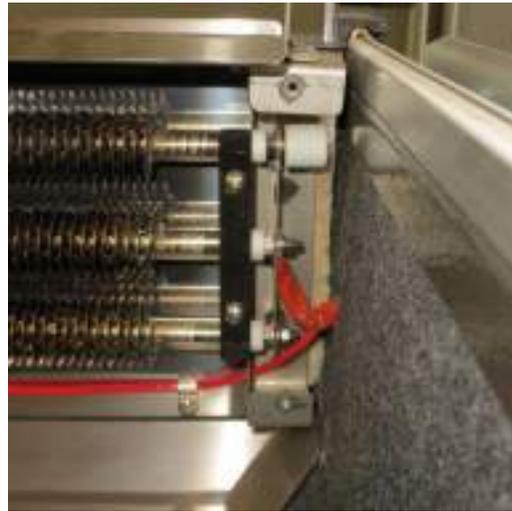
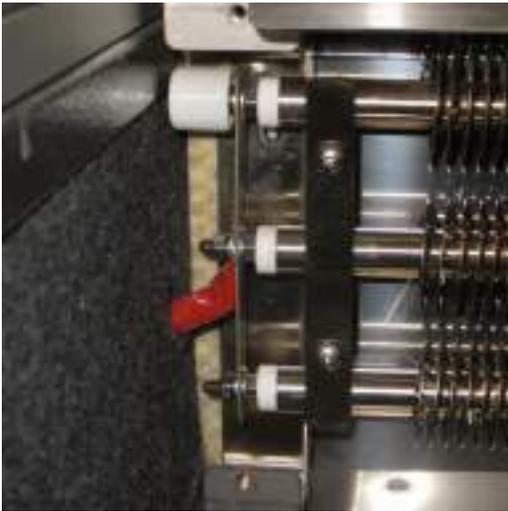
***2 Standard Heaters  
1 Heater with thermocouple***



***Check thermocouple on  
bottom heater to see if  
broken-Replace if damaged***



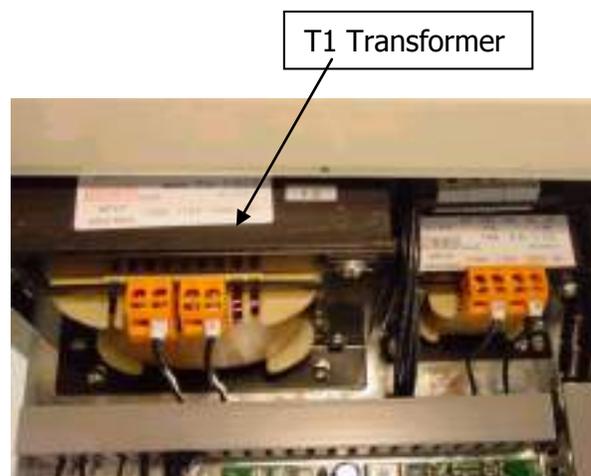
***Remove cover to access heater rods***



***Remove right and left side heater covers exposing heater wires. Check wires to see if broken or damaged. -Replace if Broken***



***Remove heater rod and test for continuity-If no continuity then replace heater rod. (Bad heater rods will usually look very dark or burned on ends)***



6. Check for voltage present at both primary T2 and secondary of transformer T2 as per values shown in the voltage specifications: PP-76ST (220 volt primary, 52 volt secondary).

## **WEAK SEALS AND/OR POOR FILM CUT OFF**



1. Improper setting of seal timer. Refer to page 24 for proper adjustment.



2. Improper operating technique. Too much film tension, make sure film is relaxed prior to sealing.

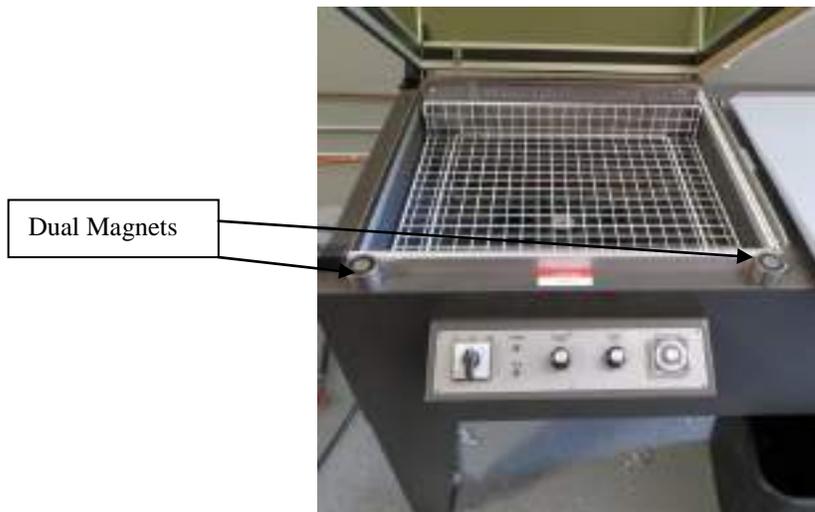


3. Check Band Ribbon to see if cleaning or replacement is necessary. **NOTE: Do not use wire brush to clean Band Ribbon, you will wear off Teflon coating. Use only soft cloth to clean.**
4. Burned Teflon tapes 1/2". If Teflon tapes become burned or worn, weak seal may occur. See page 50 for Replacement Instructions.
5. Wavy silicone rubber sealing pad. Replace. (See instructions on page 51.)



6. Seal pad pressure incorrect.

## **MAGNETIC HOLD DOWN ON SHRINK CHAMBER**



**NOTE: These magnets are only to hold the hood chamber down for duration of shrink time. It is not for seal time.**

1. Seal head will not stay down – machine operates normally otherwise.

*F1 – 20 AMP*  
*F2 – 15 AMP*  
*F3 – 1 AMP*  
*F4 – 20 AMP*  
*F5 – 1 AMP*



Fuses

- (a) Check Fuses F1 through F5. Replace if burned.

Magnet Timer Board



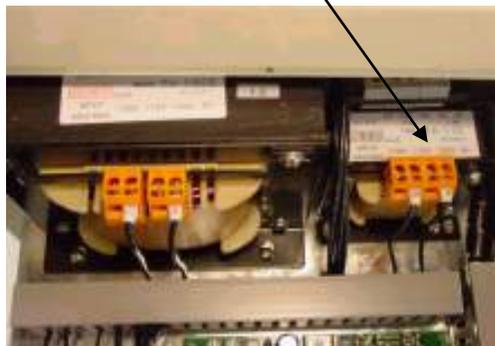
2. Check magnet timer board to see if relay kicks in when hooded chamber is lowered. If relay is not working, replace timer board.

Shrink time not at zero



3. Check shrink (Time) setting. Make sure it is not set at zero.

T2 Transformer



4. Check for 220 volts PP-76ST or primary transformer (T1).
5. If voltage is present to primary winding of transformer (T1), check for 24 (nominal) volts output from secondary of transformer.

**NO AIR FLOW**

*F1 – 20 AMP*

*F2 – 2 AMP*

*F3 – 2 AMP*

*F4 – 1 AMP*

*F5 – 15AMP*

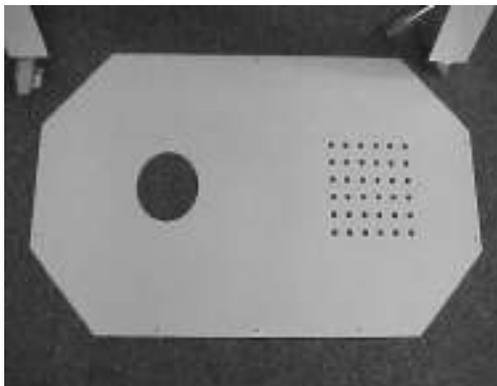
*F6 – 15AMP*



1. Check all fuses.



2. Check Blower Wheel to see if it is tight on center hub. If loose, tighten bolts holding fan blade to hub.



3. Remove bottom cover from underside on machine.



*Capacitor*

4. Check Blower motor to make sure no wires are loose.
5. Check capacitor and replace if bad.

**"Optional" DISCHARGE CONVEYOR NOT WORKING**



1. Check conveyor adjustment screw – make sure conveyor is not too tight.



2. Check conveyor motor for voltage to motor. \* Check conveyor motor first (test to see if good).

## **MAINTENANCE**

1. Before working on machine, switch machine off and disconnect power cord from wall outlet.
2. Clean Band Ribbon using soft cloth by wiping Band Ribbon when warm, as it is easier to remove any residue while Band Ribbon is warm.
3. If lower chamber requires cleaning where fan wheel is, we recommend using a vacuum cleaner to remove any particles that may have fallen into the chamber.
4. We recommend you use a glass cleaner to clean the plexiglass hood. Do not use solvents.

## **BAND RIBBON REPLACEMENT**

The band ribbon is subject to constant wear and will eventually require replacement. To replace band ribbon, proceed as described below.

### **Replacing Band Ribbon**



1. Loosen screw holding Band Ribbon in corner.



2. Loosen screw holding Band Ribbon inside rear compensator assembly.



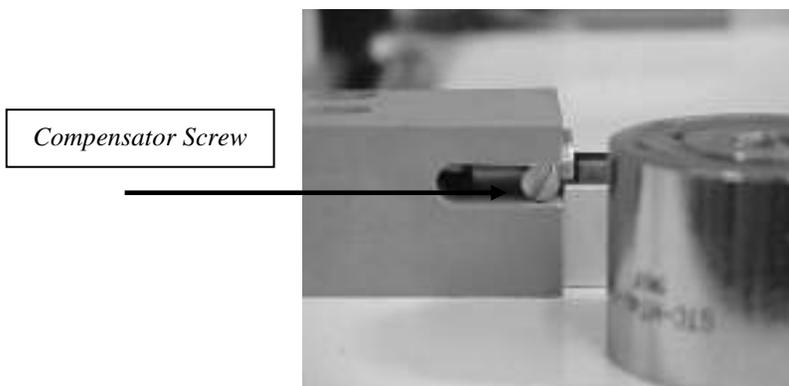
3. Loosen screw holding Band Ribbon in front compensator assembly.



4. Use pre-cut Band Ribbon and place piece of Teflon tape ( $\frac{1}{2}$ "L x  $\frac{1}{4}$ "W x 3 mill) around corner of band ribbon to insulate Band Ribbon from brass corner block. Install Band Ribbon on corner first then insert into each end of front and side compensator. **Band Ribbon may be oversized slightly, if so, cut to fit ends.**



5. Compensators are spring loaded. Use screwdriver to push in – flush to transit bars before fastening.



6. Place other end of band ribbon in slot along front seal area. With band ribbon in slot, use screwdriver to move front compensator forward until band ribbon is inside compensator and compensator is resting against the front seal bar.

## **Replacing Front and Side Transite Bars**

1. Turn power switch to **OFF** position.



*Film Support Bracket*

2. See instructions on replacing Band Ribbon on page 48.



*Transite Bar Holding Screw*

- (a) Remove film support bracket which is mounted next to transite holding channel.
- (b) Remove screws holding transite bars in channel.
- (c) Transite Bar can now be removed from channel. Reinstall new bar.
- (d) See page 49 for instructions on installing new band ribbon.

## **Tape Replacement**

The item most subject to wear on the sealer is the Teflon tape used to cover the silicone sponge rubber on the sealing bar. This ½"x 10 mill tape should never be permitted to burn through. To replace tape, proceed as follows:



1. Strip off old tape.
2. Cut off proper length of new Teflon, peel off backing, and press new tape into position.
3. Apply ½" x 10 mill Teflon tape over the top of the rubber.

## **SILICONE RUBBER SEALING PAD REPLACEMENT**

Occasionally it will be necessary to replace the silicone rubber sealing pads. This should be done if the following is noted:

- Gaps in the seal
- Weak seals
- Improper film cut-off

### **To replace rubber, proceed as follows:**



1. Remove Teflon tape from seal rubber.
2. Seal pads are designed with a channel for easy replacement. Pull silicone rubber out of the channel.
3. Replace with new silicone rubber. Press rubber back into channel using a double-sided tape to hold rubber in position.
4. Install ½" - 10 mill Teflon tape on top of rubber.

## **Adjustments:**

### **Height of Seal Bar**



1. To raise or lower chamber height, adjust hood stop assembly casting by loosening the two mounting bolts. Move assembly casting upward to increase height or downward to decrease chamber height, then tighten bolts.

## **Pulse Switch Adjustment**



The sealing cycle should not begin until the chamber hood is within 1/4" or less of the film to be sealed. If the Band Ribbon energizes before the hood is within 1/4" of the film, loosen the lock-nut and turn the screw (located at the rear end of the side seal bar) up slightly (counterclockwise when viewed from above). The correct adjustment has been obtained when the Band Ribbon energizes just as the seal bar comes into contact with Band Ribbon.

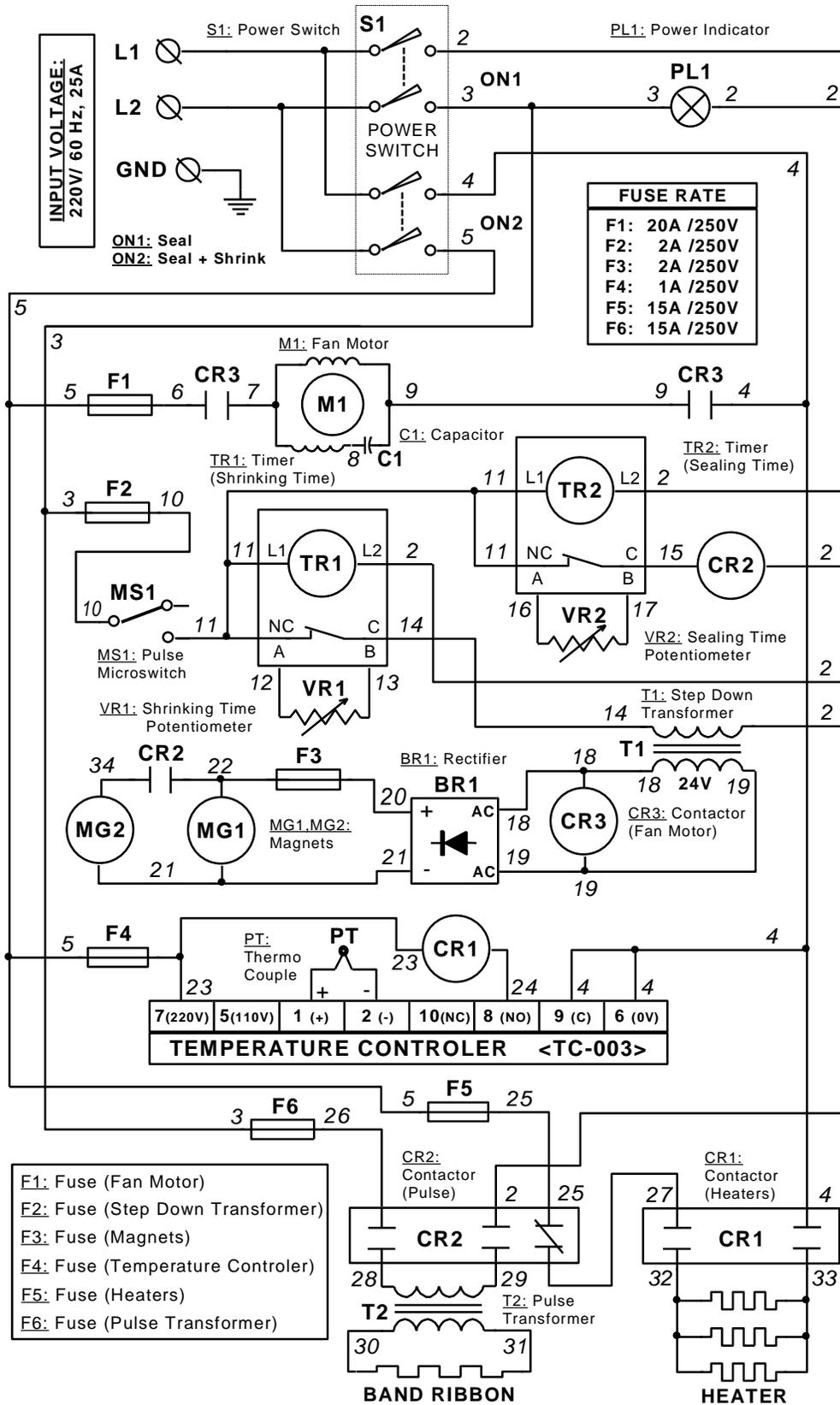
## **Adjustment of Magnets for Correct Chamber Pressure**

All magnets have been factory adjusted for equal sealing pressure throughout the length of both the front and side seal bars. However, if an adjustment is required, proceed as follows:

1. Disconnect the sealer's power source.



2. Loosen the two upper magnet bolts. Magnets settle to their lowest position in the mounting slots.
3. Lower the chamber handle fully and set the upper mounting bracket to within 1/16" from the lower magnet. Tighten the mounting bolts securely to retain the proper adjustment.



**"ALL-IN-ONE" HOOD MACHINE MODEL: PP76ST (220V)**

<b>Item</b>	<b>Part#</b>	<b>Qty</b>	<b>Parts List Nomenclature</b>
S1	76-E2060	1	Main Switch
TC1	76-E355-110	1	Temperature Control
CR1 & CR-2	76-E2015-220V	1	Contactor
CR-3	76-E2015-24V	1	Contactor
F1	76-E2040	1	Fuse – 20 Amp
F2	76-E2025	1	Fuse – 2 Amp
F3	76-E2042	1	Fuse – 2 Amp
F4	76-E2040	1	Fuse – 1 Amp
F5	76-E2042	1	Fuse – 15 Amp
F6	76-E2043	1	Fuse – 15 Amp
TR-1 & TR-2	3400-77-220	2	Timer Boards
T1	76-E2095	1	Pulse Transformer
T2	76-E2085	1	Step Down Transformer
MS1	76-E2085	1	Pulse Switch
PL1	76-E2090	1	Power Indicator Light
PL2	76-E2095	1	Sealing Indicator Light
M1	76-M3005	1	Fan Motor
MG1	76-M3010	1	Magnet – Right
MG2	76-M2040	1	Magnet – Left
HT1	76-M2035	3	Heater Rods
C1	76-E2005	1	Capacitor – Blower Motor

## PP-76ST REPLACEMENT PARTS

PP76ST	Qty	Description
76-M1000	1	Band Ribbon
76-M1005	2	Brackets – Chamber Shaft Mounting Bracket
76-E2005	1	Capacitor – Blower Motor
76-M1010	1	Chamber Height Adj. Assembly
76-M3065	1	Channel – Transite – Front Blade Holder
76-M1020	1	Channel – Transite – Side Blade Holder
76-M176	1	Compensator Assembly – Front
76-M177	1	Compensator Assembly – Side
76-E2015	1	Contactors – CR-1 and CR-2 (220 Volt)
76-E2015-24V	1	Contactors – CR-3 (24 Volt)
76-M3075	1	Corner Block - Brass
76-M1040	1	Cover – Heater Bank
76-E2020	1	Electrical Access Panel – Rear
76-M3015	1	Fan
76-M3016	1	Felt Padding – Chamber
76-M1045	1	Film Rack
76-M1050	1	Film Roll – Core Chucks
76-M1060	1	Front Plate – Control Panel
76-E2040	2	Fuse – F1 (20 Amp)
76-E2042	2	Fuses – F2 & F3 (2 Amp)
76-E2025	2	Fuses – F4 (1 Amp)
76-E2026	1	Fuse – F5 & F6 (15 Amp)
76-M3020	1	Grate
76-M1065	2	Grate – Mounting Bracket – Front
76-M3021	2	Grate – Mounting Bracket – Front – Screw
76-M1075	2	Grate – Mounting Bracket – Rear
76-E2035	2	Heater Bank
76-E2036	1	Heater Rod with Thermocouple
76-M3025	1	Hood – Plexiglass
76-M3030	1	Hub – Fan Mounting
76-M1085	4	Legs
76-M1090	1	Loading Tray
1518-015	4	Locking Casters
76-M3010	1	Magnet – Seal
76-E2040	1	Magnet – Shrink
76-M1100	1	Magnet – Upper Mounting Bracket

<b>PP76ST</b>	<b>Qty</b>	<b>Description</b>
76-M3005	1	Motor – Blower
76-M3035	1	Mounting Bracket – Pulse Switch
76-M3040	2	Pin Perforator – Ceramic Wheel Slotted
76-M3041	2	Pin Perforator – Pin Wheel
76-E2045	1	Power Cord
76-M3042	2	Screws – Corner Block-Mounting
76-M3045	1	Seal Rubber – Top/Front
76-M3050	1	Seal Rubber – Top/Side
76-M3055	1	Shaft – Roll Holder
76-M1115	1	Shaft – Film Support
76-M1120	2	Shaft – Pin Perforator Support
76-E2060	1	Switch – Main Power
76-E2085	1	Switch – Pulse
76-M1125	2	Teflon Tape ½" x 10 mill
76-E355110	1	Temperature Control
76-E2037	1	Thermocouple
76-M3060	1	Torsion Bar
3400-77-220	2	Timer Board – 220 volt (TR-1 & TR-2)
76-M1130	2	Track Bearings – Film Rack
76-E2095	1	Transformer – T1
76-E2085	1	Transformer – T2
76-M3066	1	Aluminum Channel-Front-Holds Transite
76-M3070	1	Aluminum Channel-Side-Holds Transite

## Spare Parts List

### PP-76ST

Item #	Part #	Description	Qty.	Price
1	76-E2042	Fuse – F1 20 Amp	1	\$2.50
2	76-E2040	Fuse – F2 & F3- 2 Amp	2	\$5.00
3	76-E2025	Fuse – F4 1 Amp	1	\$2.50
4	76-E2026	Fuse – F5 & F6 15 Amp	2	\$5.00
5	76-1125	½" x 10 mill x 10 yd Teflon Tape	1	\$28.00
6	76-M3045	Seal Pad Rubber – Front	1	\$15.00
7	76-M3050	Seal Pad Rubber – Side	1	\$15.00
8	76-M1000	Band Ribbon	2	\$38.00
9	76-M3075	Corner Block	1	\$38.00
10	76-M3065	Channel – Transite – Front	1	\$49.00
11	76-M1020	Channel – Transite – Side	1	\$49.00
12	3400-77-220	Timer Board – 220 volt	1	\$125.00
<b>Total Cost</b>				<b>\$372.00</b>

## Notes