

# TROUBLE SHOOTING GUIDE

## L- BAR SEALER:

PROBLEM	POSSIBLE CAUSE
No "Power-On" Indication	<ol style="list-style-type: none"><li>1. Not connected to power source</li><li>2. Switch/Breaker defective or switched to "off" position</li><li>3. Indicator light defective.</li></ol>
Seal Bar not held down	<ol style="list-style-type: none"><li>1. Machine turned off</li><li>2. Magnet failed</li><li>3. Bad fuse on PC board</li><li>4. Gap between magnet and plate set too wide</li><li>5. Pulse switch defective or out of adjustment</li><li>6. PC board failed</li></ol>
Seal Bar not released by magnet	<ol style="list-style-type: none"><li>1. PC board failed</li><li>2. Magnet shorted to ground</li></ol>
Seal wires do not get hot	<ol style="list-style-type: none"><li>1. Pulse switch defective or out of Adjustment</li><li>2. Bad fuse</li><li>3. Fuse on PC board failed</li><li>4. Broken seal wire</li><li>5. Pulse transformer defective</li><li>6. PC board defective</li></ol>

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Front seal wire does not heat	<ol style="list-style-type: none"> <li>1. Broken wire</li> <li>2. Pulse transformer defective</li> <li>3. Pulse switch defective</li> <li>4. Bad fuse</li> <li>5. Loose wire connection</li> </ol>
Side seal wire does not heat	<ol style="list-style-type: none"> <li>1. See "Front seal wire does not heat"</li> </ol>
Seal wires overheat	<ol style="list-style-type: none"> <li>1. Wire temperature set too high</li> <li>2. PC board failed</li> </ol>
Weak seals and/or poor cut-off	<ol style="list-style-type: none"> <li>1. Film too taut</li> <li>2. Inadequate seal pressure</li> <li>3. Build-up on wires</li> <li>4. Teflon tape worn</li> <li>5. Improper seal wire installation</li> <li>6. Incorrect wire temperature</li> <li>7. Incorrect dwell setting</li> <li>8. Worn composite bead(s) or seal bed</li> </ol>
Film sticking to seal wires	<ol style="list-style-type: none"> <li>1. Incorrect dwell setting</li> <li>2. Build-up on wires</li> <li>3. Incorrect wire temperature</li> </ol>
Excessive seal wire smoke	<ol style="list-style-type: none"> <li>1. Incorrect seal wire temperature</li> <li>2. Incorrect dwell setting</li> </ol>
Weak spot in seal	<ol style="list-style-type: none"> <li>1. Build-up on seal wires</li> <li>2. Worn beads or seal beds</li> <li>3. Inadequate seal pressure</li> <li>4. Improper seal wire installation</li> <li>5. Worn teflon tape</li> </ol>

Seal failure in tunnel

1. See "Weak Seals"
2. Inadequate or incorrect positioning of perforator

Conveyor does not run

1. Bad fuse
2. Failed fuse on PC board
3. Adjustment time set too low
4. Defective motor
5. Failed PC board
6. Conveyor jammed
7. Worn bearings
8. Broken drive chain
9. Loose wire connection

Conveyor runs continuously

1. Reset parameter #15 to 50
2. Failed PC board

## **SHRINK TUNNEL:**

<b>PROBLEM</b>	<b>POSSIBLE CAUSE</b>
No "Power-On" indicator	<ol style="list-style-type: none"><li>1. No power connected or phase missing</li><li>2. Switch/Breaker off or defective</li></ol>
No response from blower or conveyor	<ol style="list-style-type: none"><li>1. Switch/Breaker off or defective</li><li>2. Blown fuse</li><li>3. Overheat situation</li><li>4. Loose connection</li></ol>
Blower does not run	<ol style="list-style-type: none"><li>1. Switch/Breaker off or defective</li><li>2. Failed blower assembly</li><li>3. Blown fuse</li><li>4. Loose connection</li></ol>
Conveyor does not run	<ol style="list-style-type: none"><li>1. Switch/Breaker off or defective</li><li>2. Blown fuse</li><li>3. Motor failed</li><li>4. Conveyor jammed</li><li>5. Defective speed control</li><li>6. Chains too tight</li></ol>
No heat in tunnel	<ol style="list-style-type: none"><li>1. Defective solid state relay</li><li>2. Faulty thermostat (PC board)</li><li>3. Failed heating element</li><li>4. Overheat protective shutdown</li><li>5. Loose connection</li></ol>
Low heat in tunnel	<ol style="list-style-type: none"><li>1. Low source voltage</li><li>2. Air flow restricted</li></ol>

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Heat not adjustable	<ol style="list-style-type: none"><li>1. Defective solid state relay</li><li>2. Defective thermocouple</li><li>3. PC board failure</li></ol>
Low air flow	<ol style="list-style-type: none"><li>1. Air flow restricted</li><li>2. Blower assembly not tuning freely</li><li>3. Blower wheel loose</li><li>4. Lower baffle closed</li></ol>
Film burns on package bottom	<ol style="list-style-type: none"><li>1. Silicone roller covering damaged</li><li>2. Temperature too high</li><li>3. Conveyor speed too low</li><li>4. Inadequate air evacuation</li></ol>
Film burns on top or sides	<ol style="list-style-type: none"><li>1. Temperature too high</li><li>2. Conveyor speed too low</li><li>3. Inadequate air evacuation</li><li>4. Package too large</li></ol>
Improper film shrinkage	<ol style="list-style-type: none"><li>1. Temperature too low</li><li>2. Conveyor speed too fast</li><li>3. Improper air evacuation</li><li>4. Poor seal quality</li></ol>