



GIMA

D 500

**ROTARY SEALER
WITH DOT MATRIX PRINTER**

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**WARNING**

BEFORE USING THE MACHINE, READ CAREFULLY THIS MANUAL FOR A CORRECT USE IN ACCORDANCE WITH THE SAFE RULES.

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CE DECLARATION OF CONFORMITY**SYMBOLS:**

warning meaning danger



warning meaning particular suggestion



warning meaning suggested maintenance

1. INTRODUCTION

1.1 Use and safekeeping of this manual

We thank you for the trust you put in us by buying our heat-sealer serie GIMA D 500.

We are certain that, following correctly the instructions in this manual, you will find the quality of this product worth of appreciation.

For this reason, please give noted the present instructions to all people who are likely to use this machine.



WARNING

All people involved in the operation of this heat-sealer whether their task is production, maintenance or revision must read this instruction manual.

The instructions in this use and maintenance manual indicate, for this machine, the correct operations as intended in its design and technical specifications.

This booklet, provided with each heat-sealer, is to be considered indispensable part of the equipment.

It must be safekept for continuos consultation for as long as the machine is operating.

This manual must be kept always close to the heat-sealer available to the operator for easy consultation.

In case of loss or damage, the customer can ask for a new manual of instructions, mentioning:

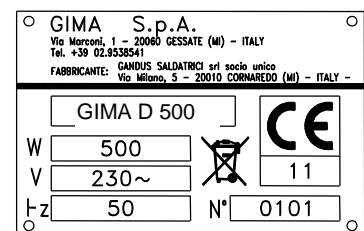
- model
- serial number
- manufacturing date

This information are written on the identification plate (pict.1.2), situated on the rear of the machine (pict.1.1).

The manufacturer reserves the right to improve or modify its products, without updating the items issued previously on their manuals.



pict.1.1



pict.1.2 (plate n.1-pict.1.1)

- 1 Identification plate
- 2 Main power supply
- 3 Green main luminous switch

1.2 Manufacturer's responsibility limits

The manufacturer is not responsible for direct or indirect damages caused by an incorrect use of the heat-sealer, specifically:

- employing this heat-sealer for other use than the one specified in this manual
- failure in the scheduled maintenance
- modification of the heat sealer without the authorisation of *The manufacturer*
- use of non original spare parts and not suitable for the model
- partial or total non compliance with the instructions
- exceptional events

1.3 Expected use

The *GIMA D 500* is a rotary heat-sealer for closing hermetically sterilization pouches with surgical instruments and disposables made with multilayered envelopes like polyester / polyethylene, or other multilayered envelopes bags like paper/polyethylene, aluminium/polyethylene, etc.

The machine has been studied to be used only by an operator.



WARNING

The machine must not be used for other use than the one above mentioned, for which the machine has been designed and built.



WARNING

THE HEAT SEALER MUST NOT TO BE USED FOR SEALING SINGLE PLASTICS FILMS LIKE POLYETHYLENE, POLYPROPYLENE, PVC, AND SO ON.

1.4 Technical characteristics

- Sealing speed 6 m/min
- Electronic temperature control with 20°C - 200°C ($\pm 1\%$)
- Automatic stop of the heat-sealer if the temperature has fallen down from setting value in a range $\pm 5^\circ\text{C}$.
- Autotest function
- LC display with 2 lines for 8 characters
- Clock and calendar with automatic update
- Membrane keyboard
- Sealing width 12,5 mm multilines
- Free edge over the seal 0 - 30 mm
- Preadjusted sealing pressure
- Built-in 9 dots matrix printer
- Power supply: 230V 50 / 60 Hz or 115V 50 / 60 Hz
- Max power absorption 500 W
- Acoustic emission level 70 dB(A)
- Dimensions without accessories:
Width = 473 mm - Depth = 235 mm - Height = 181 mm
- Net weight 13,6 Kg
- As for DIN 58953 P. 7 specifications
- Built in accordance to the CE rules
- Environmental working conditions:
Temperature: from 5°C to 40°C (from 41°F to 104°F)
Humidity relative: 30% - 95% (without condensation)

The manufacturer reserves the right to modify the machines they manufacture without any obligation respect to those previously supplied

1.5 Transport and moving

We suggest to use the original packing during the transport.

We suggest to handle with care and keep the packing, in dry environment, follow the positioning symbols.



TO AVOID DAMAGE TO THE MACHINE, WHEN IT IS MOVED, IS FUNDAMENTAL TO PRESERVE THE ORIGINAL PACKING.

The manufacturer declines every responsibility for eventual damages to the machine, in case of shipments made without the original packing

To avoid damage when unpacking and for subsequent movements, act only below the basement.



The heat-sealer can be damaged if lifted or moved using other parts such as casing, conveyors, etc.

1.6 Safety rules



WARNING

THE OPERATOR MUST BE PROPERLY TRAINED AND HAVE FULL KNOWLEDGE OF THE CONTENTS OF THIS MANUAL



Before electrical wiring, check if the data on the identification plate (pict.1.2) corresponds to the local power supply



WARNING

CONNECT THE MACHINE ONLY TO A POWER SUPPLY WITH A PROTECTIVE DEVICE AGAINST OVERVOLTAGE AND DISPERSION TO EARTH, IN ACCORDANCE WITH THE SAFETY RULES AND CORRECTLY SIZED.



WARNING

UNPLUG THE MACHINE FROM THE MAIN POWER SUPPLY (N.2-PICT.1.1) BEFORE ANY MAINTENANCE OPERATION.



Do not operate with the heat-sealer if the safety panels are open or removed.

Here there are the most important suggestions for the security and good maintenance of the machine:

- To ensure its good function, keep the heat-sealer clean.
- Before cleaning procedures on the heat-sealer machine unplug it (n.2-pict.1.1) from the main supply.
- Do not clean the heat-sealer with fluid or spray cleaners. Wipe the outside with a slightly moist cloth and clean the inside with compressed air.
- Never introduce in the sealing area anything else than the bags to be sealed.
- Do not introduce in any opening of the heat-sealer any metallic objects, to avoid electrical shocks.
- The heat-sealer must be used only indoor and in a dampness free environment.
Temperature: from 5°C to 40°C (from 41°F to 104°F)
Humidity relative: 30% - 95% (without condensation)
- Do not operate with the heat sealer in environments with risk of fire or explosion.
- Do not use the heat-sealer to pack inflammable, corrosive or explosive substances or in any case with dangerous products.
- Use only original spare parts.
- It is advisable to have the heat-sealer checked by a qualified technician every year.
- Do not change the set parameters while the heat-sealer is working.
- In case of replacement of the fuses check that they are of the same value

1.7 To discard the machine



According to the DIRECTIVE 2002/96/CE rules this symbol indicates that the device, when its work-life is ended, **must not be discarded as a urban waste.**

It can be given to a suitable discharging centers of the electronics and electric equipments or delivered to the dealer if you purchase an equivalent device.

The device owner is responsible for the delivery in to the discharging centers.

To get more informations about the discharging system, we suggest you to contact your local discharging waste service.

The right discharging of the disuse devices avoids such a negative consequences to the ambience and the human health.

2. INSTRUCTIONS FOR USE

2.1 Installation

The equipment can be used in any working environment that is dry and without excessive dust, according to the chap.1.6

Place the sealer on a work surface, leaving an enough large space in front of it for the bags to run over and on the sides the space for the introduction and exit of the bags from the machine.

Be sure that the heat sealer is at least 30 mm from the back wall in order to allow a perfect release of the heat produced inside and that on the sides there is the necessary space to allow a an easy loading and unloading of the bag that are being sealed.

2.2 Pouches introduction adjustment

To easily open the sealed medical pouches, it is necessary to leave a free edge over the seal.

According to the specific needs, it is possible to obtain a free edge from 0 to 30 mm. doing as follows:

- loosen the locking knob (n.1-pict.2.1) and move it:
 - on the right to reduce the free edge over the seal (min. 0 mm)
 - on the left to increase the free edge over the seal (max to 30 mm)
- at the end of this operation, lock the knob (n.1-pict.2.1)



pict.2.1

- 1 Knob to infeed guide
- 2 Infeed guide



pict.2.2

- 1 General luminous switch
- 2 Plug of the general switch
- 3 Socket of the supply cable
- 4 Power supply cable

2.3 Electrical wiring

Check that the main luminous switch (n1-pict.2.2) is switch off, in the " 0 " position (OFF).

Introduce the socket (n.3-pict.2.2) of the main power supply cable (n.4-pict.2.2) into the plug of the general switch (n.2-pict.2.2) before inserting the plug of the supply cable (n.4-pict.2.2) into the single phase socket.

Respecting the chapter 1.6, insert the plug of the main power supply (n.4-pict.2.2) into the single phase socket with protected earth from a magnetothermic switch, after checking that the data of the plate are the same of the power supply net.

2.4 Switch on the machine

Switch on the machine through the main GREEN luminous switch (n.1-pict.2.2) on position “I” (ON).
The display lightens and the sealer does an autodiagnostic on the main components of the machine:

**TEST
IN PROGR**

After the display shows:

- on the first line, the result of the temperature probe control (**PROBE OK**),
- on the second line the firmware version (**Ve . 018 _P**)

**PROBE OK
Ve . 018 _P**

After the display shows the sealing bars real temperature (fist line of the display) and the set temperature (second line of the display):

**21 . 0 °C
165 !**

pict.2.3

After display shows switching on the machine, the sealing bars begin their heating; *when the current and set temperature are at the same value, the sealers is ready to be used.*



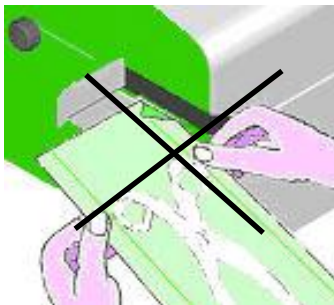
The temperature stabilization takes some minutes.

2.5 First employ



WARNING:

- In order to avoid imperfect seals, bad functioning and/or machine stops, the operator always must introduce into the machine the pouch well stretched as shown on the pict.2.4.



pict.2.4

- The DIN 58953 P7 rules requires the pouches can be filled up max until $\frac{3}{4}$ of their length
- Do not apply any kind of label and/or adhesive on the pouches near the sealing area
- For proper operation of the sealing machine, avoiding alarms, it is important that the pouches are introduced with a relative distance not less than 50 mm.

After switching on the machine (see par.2.4) and reaching the set sealing temperature, the machine is ready to do the first seal.

When introducing the first pouch into the sealing machine through the infeed guide the motor will automatically start running and the pouch will be feeded into the machine.

If the operator does not introduce any pouches into the sealing machine for approx. 10 sec, the gearmotor will stop automatically, in order to avoid useless consumes; it will start again running automatically when a new pouch is introduced.

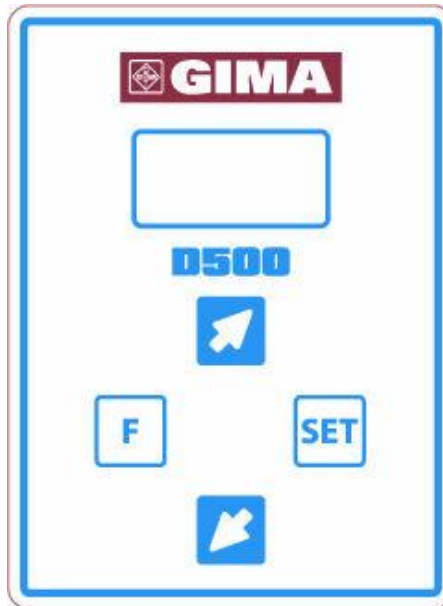
3. CONTROL PANEL

In this section will be described the panel commands, which can be done by the operator to manage the working adjustments and the desired machine configuration:

- Working adjustment
- Machine configuration

The control panel (pict.3.1) allows the operator to visualize, set and/or modify the sealing temperature parameters and the printing parameters.

3.1 Keys symbols



pict.3.1 (comand panel)

The keyboard keys show the following functions:

- F** - service key
- Set** - setting function key
- Up** - key to
 - increase the selected date (number or character)
 - display the next screen
- Down** - key to
 - decrease the selected date (number or character)
 - display the previous screen

3.2 Operative settings

This section describes the operative settings of the machine.

3.2.1 Sealing temperature

To set or modify the SET value of sealing temperature proceed as follows:

1. press **SET**;
2. through the keys **UP** and/or **DOWN** choose the function

Set TEMP
160 °C

3. press **SET**; the display shows:



4. through the keys **UP** and/or **DOWN** choose the new SET value

- 5a press **F** to confirm and go out from the menu

or

- 5b press **SET** to confirm and remain into the function

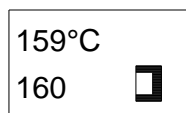


WE ADVISE, AFTER EVERY VARIATION OF SEALING TEMPERATURE VALUE, TO WAIT FOR SOME MINUTES BEFORE BEGINNING TO SEAL, TO LET THE TEMPERATURE STABILIZE AT THE NEW VALUE

3.2.2 Printer activation

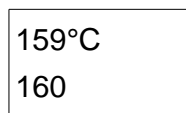
The key allows the operator to activate or deactivate the printer

- press **F**; the display shows:



→ printer activated

- press **F** ; the display shows:



→ printer inactive

3.2.3 Pouch expulsion

When some pouches stop into the sealing tunnel, because of the temperature alarm function, the control system allows to take out the pouches from the machine. To make this do as follows:

- press for about 2 sec the key **UP**
- keep the key pressed until all the pouches are out of the machine



Releasing the key, the gear will keep running for about 5 seconds.

3.3 Machine configuration setting

This paragraph is concerned with the “machine configuration” and it consists of the following list of functions:

- SET OUTPUT PRINTING DATE FORMAT: **mmddyy**, **yyymmdd**, **mmyy**
- SET OUTPUT PRINTING SYMBOLS: **Clear**, **EN**
- SET OUTPUT PRINTING EXPIRY PERIOD:

month	(from 1 up to 60)	i.e. 5
days	(from 1 up to 365)	i.e. 48
complete date	(direct : dd/mm/yyyy)	i.e. 14-05-2011 (or 05-14-2011)

- SET ACTUAL DATE/HOUR:

year (2000-2099)
month (1 – 12)
day (1 – 31)
hour (0 – 24)
minute (0 - 60)
second (0 – 60)

To come to the functions do as follows:

- press **SET** ; through the keys **UP** and/or **DOWN** choose the desired function.

3.3.1 Output printing date format:

The function allows the operator to set the printing date format on the sealed pouches.

- the display shows

F . DATA
DDMMYY

- press **SET**
- through the keys **UP** and/or **DOWN** choose the new format
- press **F** to confirm and go out from the menu
or
- press **SET** to confirm and remain into the function

3.3.2 Output printing symbols

The function allows the operator to set the output of the symbols printed on the sealed pouches.

- the display shows

SYMBOLS
CLEAR

- press **SET** : the two arrows appear
- through the keys **UP** and/or **DOWN** choose the new format
- press **F** to confirm and go out from the menu
or
- press **SET** to confirm and remain into the function

3.3.3 Expiry periods

The function allows the operator to set the expiry date period choosing among three options :

a) option choosing

- the display shows (last option set) :

EXPIRY T
Months

- press **SET** : the two arrows appear
- through the keys **UP** and/or **DOWN** select from the following views

EXPIRY T
Months

EXPIRY T
Days

EXPIRY T
Directly

- press **F** to confirm and go out from the menu
- or
- press **SET** to confirm and remain into the function

b) Expiry date duration

Press keys **UP** ; the display shows according to the expiry date format

- press **SET** : the two arrows appear
- press keys **UP** and/or **DOWN** ; the display shows according to the expiry date format :

EXPIRY
Month 1

EXPIRY
day 3

YY expir
2011

- press **F** to confirm and go out from the menu
- or
- press **SET** to confirm and remain into the function

NOTE :

In case of **DIRECT EXPIRY** date choosing, you have to set the month and the day of the expiry date too.
 Do as follows:

- after the year value setting, press **UP** and the display shows (month)

MM expir
10

- press **SET** : the two arrows appear and through the keys **UP** and/or **DOWN** set the new value
- press **SET** to confirm
- press **UP** and the display shows (days)

DD expir
15

- press **SET** : the two arrows appear and through the keys **UP** and/or **DOWN** set the new value
- press **SET** to confirm or **F** to confirm and go out of the menu

The system does not accept expiry date preceding the actual production date.

3.3.4 Actual date/hour adjustment

The function allows the operator to set the clock parameters of the machine to synchronise the printed dates on the pouches with the actual date and hour.

- press **SET**; through the keys **UP** and/or **DOWN** choose the desired function:

YEAR
2011

MONTH
3

DAY
25

HOURL
13

MINUT
36

SECOND
45

For each function do as follows:

- press **SET** : the two arrows appear
- through the keys **UP** and/or **DOWN** choose the new value for the months
- press **F** to confirm and go out of the menu
- or
- press **SET** to confirm and remain into the function

3.4 Alarm messages

In case of some functioning problem, the alarm system shows lighting messages on the display, stopping the thermoregulator functioning.



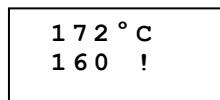
Stop immediately the pouches infeed (the pouches transport is still activated)



When an alarm occurs, the system stops immediately the pouches transport; so, if some pouches are blocked into the machine, to avoid possible rests of melt material, do the expulsion command (par. 3.2.3)

3.4.1 Sealing bars temperature control message

Display visualization:



The message origins every time the actual bars temperature is higher or lower than the allowed range of functioning.

Action: the machine stops the pouches transport until the temperature re-enter the allowed range of functioning (± 5° than the SET)

RESET Procedure: wait



The appearance of the message is normal every new change of the SET temperature

3.4.2 Message control battery data maintenance

display visualization : - - - - -

Action : the machine doesn't do corrective actions

RESET Procedure: change battery data maintenance (see electric diagram).



When the battery is discharged you loose the following data:

- current hour
- current data

which must be inserted every new switch on of the machine.

3.4.3 Message temperature probe out of order

Display visualization:

5 0 0 ° C E R R O R

The message appears when the starting AUTOTEST of the integrity of the probe and/or its connections is not passed.

Action : the machine remain blocked

RESET procedure: change the temperature probe.

4. CORRECT FUNCTIONING

4.1 Sealing temperature

The sealing temperature value has to be set according to the thickness, the kind and the condition of the material to be sealed.

Check that the set temperature corresponds to the one , suggested by the bags manufacturer.

Should this value be unknown, following the table here below containing indicative adjustment values of the heat sealer, according with the used material.

STANDARD STERILIZATION BAGS (*)

MATERIALS	PAPER/POLYPROPYLENE-POLYESTER	HEAT SEALABLE PAPER	TYVEK
FLAT POUCH	150°C - 160°C	150°C - 170°C	120°-130° C
GUSSETED POUCH	160°C - 170°C	155°C - 175°C	- - - - -

(*)Gima S.p.a. takes no responsibility for the given data reliability.

For other materials or in case of troubles in finding the correct temperature, please send Gima S.p.a. a sampling of bags to allow comparative tests and calculate the relevant adjustment values.

To set a new sealing temperature value see par. 3.2.1.

Make some tests to check the correctness of the new temperature value.

4.2 Sealing pressure

The sealing pressure is already set by the manufacturer according with all materials in normal use.

In case you should need a pressure increase/decrease for special purposes see par.5.5.

4.3 Sealing quality

Aiming to obtain steady high quality seals, please follow these guidelines:

- during the sealing cycle the bag should not be submitted to any traction or moves;
- make sure that the part of the bag to be sealed is clean and dry;
- place carefully the mouth of the bag to be sealed inside the in-feed guide; during this operation, remove the air in excess;
- keep the mouth of the bag spread out until it is fully introduced in the sealing area of the machine; this will prevent from any damage to the sealing (see par. 2.5);
- never feed the pouches into the in-feed guide using a feeding speed higher than the machine transport speed;
- pouches feeding too much fast, can interfere with the in-feed photocell characteristic that might cause a transport stop;
- do not stop the sealer during the sealing, with the exception of emergency situations;
- should the bags be of small/medium size or with a light and not bulky contents, they can be conveyed by the machine over the support surface; should the bags be heavier and larger, the entrainment will be easier by using the slip rolls during the sealing (see par.9.1). The operator should in any case drive the bag during the sealing process.



Never introduce into the machine bags on which labels or adhesive tapes are applicated; this origins rests of material into the sealing tunnel, which causes the bags jam into the machine.



To obtain perfect seals and to make the work easier, the DIN 58953 rules state that the pouches must not to be filled more than the 3/4 of their length, letting always not less than 30 mm between the content and the internal edge of the seal.

4.4 Normal stop of the heat sealer

To switch off the heat sealer press the main GREEN luminous switch to the position " O " (off).



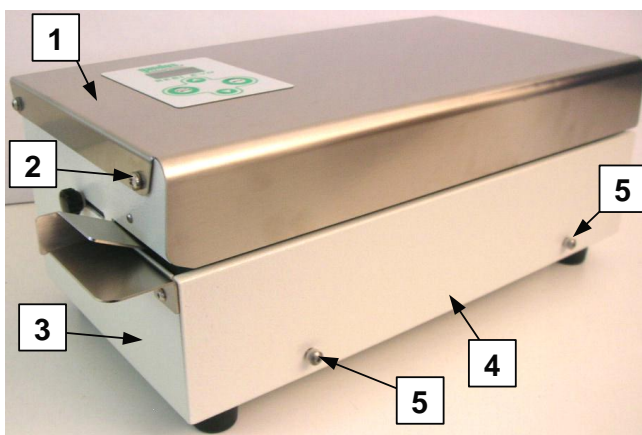
With the exception of emergency situations, do not stop the machine during the running of one or more pouches in the sealing area. This will avoid the overheating of the bags and the burning of material.

4.5 Emergency stop

In case of emergency, unplug the power cord (n.2-pict.1.1) from the machine. This action causes the complete disruption of power supply and the consequent immediate stop of moving parts.

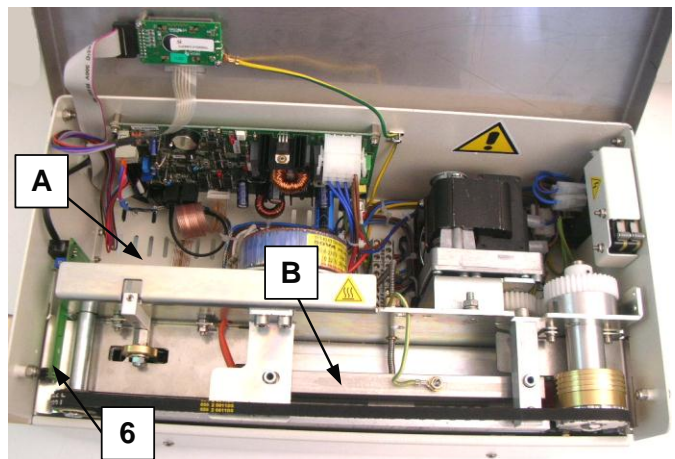
After resolving any issue, restart the welder needs to bring the first light switch GREEN (n.3-pict.1.1) on " O " (off), reconnect the power cable and then run as described to par.2.5.

Since the temperature during the stop will come down, you will have to wait several minutes before the welder is put in motion and the set temperature is reached.



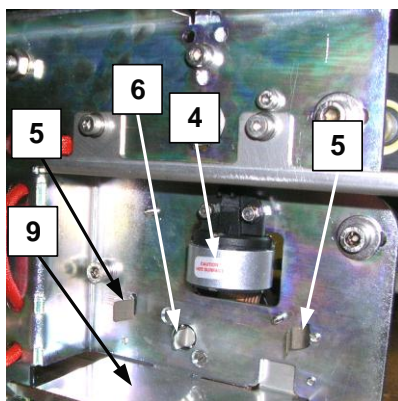
pict.4.1

- 1 Upper cover
- 2 Screw upper cover
- 3 Frame
- 4 Frontal cover
- 5 Screw frontal cover



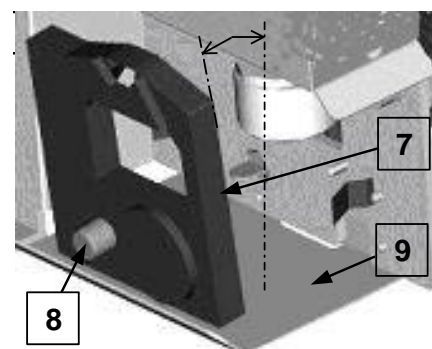
pict.4.2

- 6 Infeed photocell
- A Space for insertion ink cartridge
- B Sealing bar



pict.4.3

- 4 Printing head
- 5 Spring for fixing ink cartridge
- 6 Pallet-shaft transport rotor ink cartridge



pict.4.4

- 7 Ink cartridge
- 8 Ink cartridge rotor
- 9 Guide sheet for ink cartridge

4.6 Printer

The sealer has a built-in dot matrix printer (n.4-pict.4.3) with ink ribbon (n.7-pict.4.4).


The printing function is electronically controlled by the infeed photocell (n.6-pict.4.2), which activates the print when the pouch is completely transited out of the reading range of the photocell. If you choose the printing function from the control panel (see par.3.2.5) the printer will print the data set by the operator on the pouches before it goes out of the machine.

The printer works correctly if the print quality is neither too soft or too strong.

The photocell works correctly if the printing phase stops automatically after the pouch is out of the reading range of the photocell.

4.6.1 Insert of the ink ribbon case

To insert the case, follow these guidelines:

-  **Switch off the sealer acting on the main switch (n.3-pict.1.1) and disconnect the power cable (n.2-pict.1.1).**
- Loosen the 2 screws (n.2-pict.4.1) and turn the upper cover (n.1-pict.4.1) until its total openness: the screws (n.2-pict.4.1) will be screwed to the frame machine (n.3-pict.4.1).



IF THE SEALER IS OFF FROM FEW TIME, TO AVOID BURNS NOT TOUCH SEALBARS (pos. B-pict.4.2).

- Insert the ink cartridge (n.7-pict.4.4) inside the print area (pos.A-pict.4.2)
- Position the ink cartridge on the guide (n.9-pict.4.4): keep it tilted slightly to the rear of the machine (see pict.4.4)
- Having identified the two coupling springs (n.5-pict.4.4), slightly rotate the cartridge and insert it into the inner spring
- Without pushing, carrying the ink cartridge at the outer clip and insert until you hear a "click" into place.



This last operation has to be done without exercising any stress on the ink cartridge vanes (n.6-pict.4.3): if there were any blocks to its placing, turn the rotor slightly and retry the input.

Warning: To avoid breaking of the ink cartridge, its rotor (n.7-pict.4.4) should be rotated only in the direction of the arrow on the cassette tape itself.

- Close the cover of the machine (n.1-pict.4.1) and completely screw the two screws (n.2-pict.4.1)
- Turn on the machine (see par.2.4) and run a test print



When the machine is on and the engine in motion, should not feel bad dragging noises that indicate the ink cartridge is not running properly.




General note :

- Before introducing the ink cartridge, always check that the ink cartridge has no curlings.
- To avoid damages to the printing head dots (see pict. 5.15), do not print without the ink cartridge inside.
- In case you do not employ the sealer for some days, we suggest you to check the cleaning status of the printing area (see par. 5.9).
- In cases of high environmental temperature, we suggest you to remove the ink cartridge, if the sealer has not to be used for long time.

4.6.2 Extraction of the ink ribbon case

To take out the ink cartridge, follow the instructions here below:

-  **Switch off the sealer acting on the main switch (n.3-pict.1.1) and disconnect the power cable (n.2-pict.1.1).**

- Loosen the 2 screws (n.2-pict.4.1) and turn the upper cover (n.1-pict.4.1) until its total openness: the screws (n.2-pict.4.1) will be screwed to the machine frame (n.3-pict.4.1).



IF THE SEALER HAD BEEN OFF FROM FEW TIME, TO AVOID BURNS DO NOT TOUCH THE SEALBARS (pos. B-pict.4.2).

- Grab the cassette tape and remove the two coupling springs (n.5-pict.4.4)
- Replace with a new ink cartridge (see par.4.6.1)
- Close the upper cover (n.1-pict.4.1) and completely screw the two screws (n.2-pict.4.1)

4.7 Bag jamming

In case of a bag jamming into the machine, do as follows:



- **Switch off the sealer acting on the main switch (n.3-pict.1.1) and disconnect the power cable (n.2-pict.1.1).**
- **Do not rip the bag towards the external of the machine to avoid:**
 1. irremediable damages to the printing head needles
 2. creation of bag residuals, which could block the sealing tunnel and/or the printing area, with a consequent jam of the following bag.



To avoid jamming follow the instructions of par.2.5 and par. 4.3

4.7.1 Bag jamming in the pressure and/or printing zone

A) SIMPLE BAG JAMMING

Do as follows



- **Switch off the sealer acting on the main switch (n.3-pict.1.1) and disconnect the power cable (n.2-pict.1.1).**
- Loosen the 2 screws (n.2-pict.4.1) and turn the upper cover (n.1-pict.4.1) until his total openness: the screws (n.2-pict.4.1) will be screwed to the frame machine (n.3-pict.4.1).



IF THE SEALER IS OFF FROM FEW TIME, TO AVOID BURNS DO NOT TOUCH SEALBARS (pos. B-pict.4.2).


- Extract the ink ribbon case (see par.4.6.2)
- Insert the reverse lever (n. 2-pict.4.7), supplied together with the sealer, into its holes on the upper motor pulley (n.1-pict.4.7): see pict.4.7.
- **Rotate the reverse lever (n. 2-pict.4.7) anticlockwise manually, slowly and carefully, up to the pouch is completely removed by the pressure wheel.**

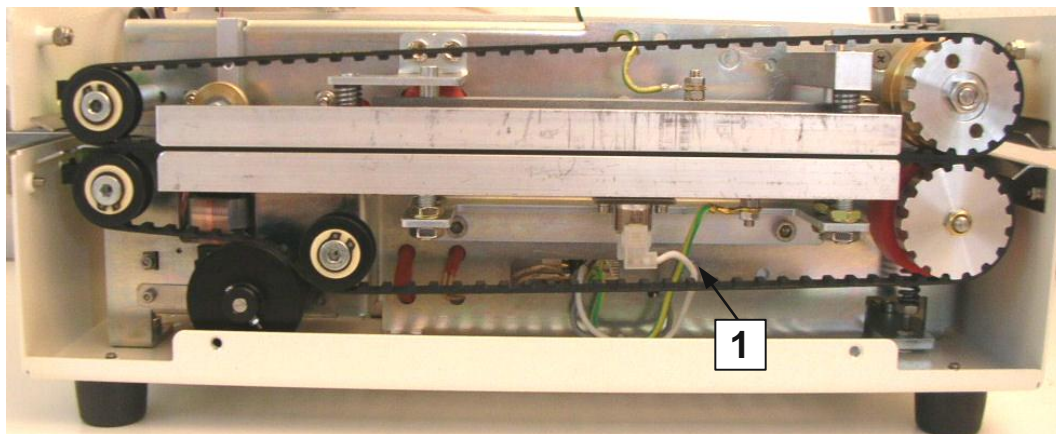


Pay attention to this operation because it should cause irreparable damage to the motor: if the movement of the belt was not prevented stress and go to step B).

B) HARD BAG JAMMING

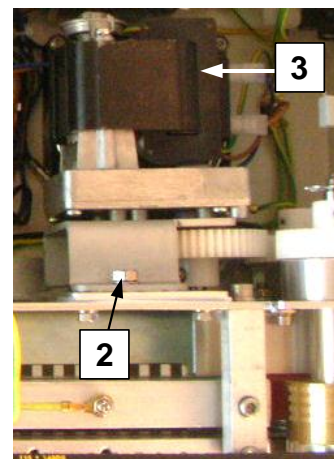
Do as follows:

-  **Switch off the sealer acting on the main switch (n.3-pict.1.1) and disconnect the power cable (n.2-pict.1.1).**
- Loosen the 2 screws (n.2-pict.4.1) and turn the upper cover (n.1-pict.4.1) until its total openness: the screws (n.2-pict.4.1) will be screwed to the machine frame (n.3-pict.4.1).
- Extract the ink ribbon case, (see par. 4.6.2)
- Disconnect the motor group (3-pict.4.6): turning clockwise it after loosening the upper locking screw (n.2-pict.4.8) and the rotation screw (n.1-pict.4.5)
- Only if necessary, reduce sealing pressure (see par.4.2)
- Insert the reverse lever (n. 2-pict.4.7), supplied together with the sealer, into its holes on the upper motor pulley (n.1-pict.4.7): see pict.4.7.
- **Rotate the reverse lever (n. 2-pict.4.7) anticlockwise manually, slowly and carefully, up to the pouch is completely removed by the pressure wheel.**
- At this point, slowly and smoothly pull the jammed envelope



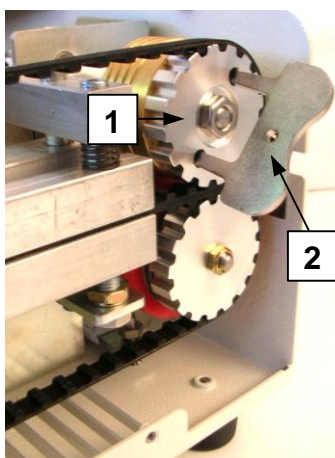
pict.4.5

1 Rotation screw motor reducer



pict.4.6

2 Motor reducer
3 Upper locking screw motor reducer



1 Upper motor pulley
2 Reverse Lever

pict.4.7

4.7.2 Machine Restore to the correct functioning

After leaving free the bag, before restarting the machine, do as follows:

- Be sure that there are no bag pieces into the sealing area
- Restore the sealing pressure if modified (see par. 5.5) and reconnect the motor to the transmission
- Remount the ink ribbon case
- Close the upper cover (n.1-pict.4.1) and screw the two screws (n.2-pict.4.1)
- Close the front cover (n.4-pict.4.1) and tighten fully grasped the 2 screws (n.5-pict.4.1)
- Plug the power cord (n.3-pict.1.1)

Now the machine is ready to restart.

5. MAINTENANCE



THE MAINTENANCE OF THE SEALER MUST BE MADE ONLY BY QUALIFIED TECHNICIANS, WHO MUST HAVE READ THE INSTRUCTIONS IN THIS MANUAL.



BEFORE ANY OPERATION, TURN OFF THE MACHINES WILL TAKE THE SWITCH (NO.3-PICT.1.1) BY POSITION (OFF) AND DISCONNECT THE POWER CORD (n.2-pict.1.1).



IF THE SEALER HAD BEEN OFF TO LITTLE TIME, TO AVOID BURNS NOT TOUCH SEALBARS (pos. B-pict.4.2).

5.1 Opening the machine



Turning off the luminous green general switch (n.3-pict.1.1) in position “O” (switch off) and unplug the power cord form the main supply (n.2-pict.1.1)

5.1.1 Upper cover

To access the internal components need to open the cover (n.1-pict.4.1):

- Loosen the 2 screws (n.2-pict.4.1) screws (n.2-pict.4.1) will be bolted to the machine frame (n.3-pict.4.1).
- Slowly turn the machine cover (n..1-pict.4.1) to its full opening

5.1.2 Front cover

To remove the front cover (n.4-pict.4.1) you have to unscrew the 2 screws (n.5-pict.4.1) from the machine frame

5.2 Main previous maintenance rules

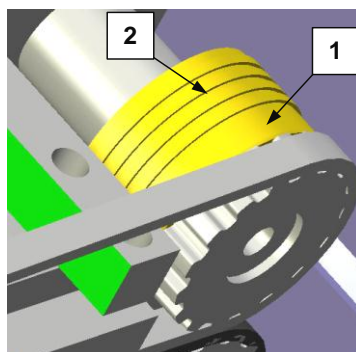
PRESSURE WHEEL



Check periodically the pressure wheel (n.1-pict.5.2) grooves (n.2-pict.5.2) in order to make sure that they are clean without any rest of pouches; on the contrary, clean them with a soft band or with a small plastic or wooden stick.



Do not use any metal objects, which could damage irreparably it.



- 1 Pressure wheel
- 2 Pressure wheel grooves

pict.5.2

SEALING JAWS



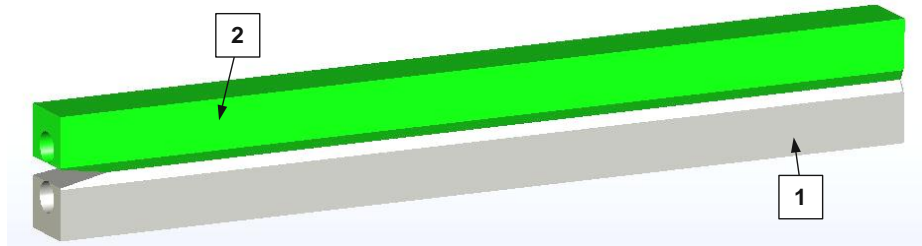
Check periodically that the surfaces (in PTFE made) of the sealing jaws (n.1 and n.2-pict.5.3) in contact with the pouches are clean without any rest of pouches; on the contrary, clean them with a soft band or with a small plastic or wooden stick.



Do not use any metal objects, which could damage irreparably them



To access to the sealing jaws see par.5.8



pict.5.3

- 1 Lower sealing jaws
- 2 Upper sealing jaws

PRINTING UNIT



Keep clean the wire print head (n.2-pict.5.16) and the surface of the counter print roller (n.2-pict.5.15), to avoid the rest of ink.



TO AVOID ANY DAMAGE ON THE WIRE PRINT HEAD, DO NOT USE THE MACHINE WITHOUT INSERTING THE INK CARTRIDGE.

CONVEYOR BELTS



We suggest to put some time a thin layer of silicone grease on the conveyor belts in order to keep them lubricated and facilitate the sliding in the guide rails and pulleys.
Keep the straps "dry" or non-lubricated, as it should cause friction during the machine operation.



WARNING: Do not use too much grease on the toothed belt . It is enough a quantity equivalent to a "grain of rice."

5.3 Electrical and thermoelectrical protections

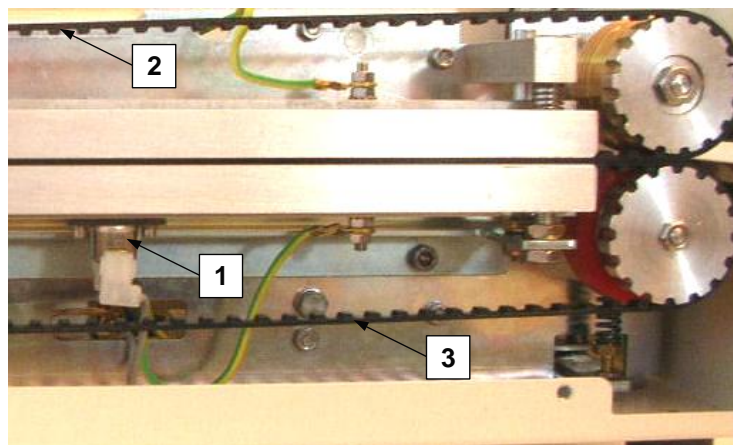
5.3.1 Thermic protection through thermostat (n.1-pict.5.4), which intervenes if there is a lack on the PLC temperature electronic control.

Its intervention will prevent from any danger of overheating, by stopping the machine.



If you do not switch off the machine through the main green luminous switch (n.3-pict.1.1), after the stopping of the machine through the thermostat (n.1-pict.5.4), the sealer will restart as soon as the temperature lowers till a value under the intervention one.

In this case, stop the machine and contact the Manufacturer.



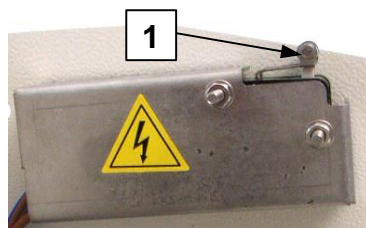
- 1 Safety thermostat
- 2 Upper transport belt
- 3 Lower transport belt

pict.5.4

5.3.2 Electrical protection by microswitches (n.1-pict.5.5), which interrupt the electrical circuit of the machine when you open the upper cover.

In the electrical diagram of the machine, the microswitches are placed immediately downstream of the line fuses. With the machine switched on (see par.2.4), where careless the upper cover was open, the microswitches operate causing the shutdown of the machine and of the general green main switch (n.3-pict.1.1). Closing the cover, the microswitches will be actuated and the machine restarts.

The microswitches are a further protection for the operator in replacing the ink cartridge (see par.4.6), this operation should always be done off the machine and unplugging the power cord.



pict.5.5

- 1 Safety microswitches

5.3.2 Line fuses and main board fuse

The machine has 2 line fuses (see pict.5.17)

The board of the machine is equipped with a fuse

5.4 Replacement of the sealing jaws temperature probe



The probe measuring the sealing jaws temperature is a thermocouple type J and does not need any maintenance

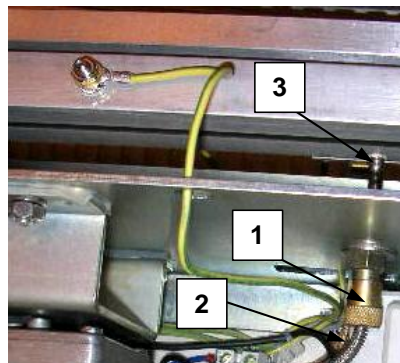
For the replacement:

1. open the upper cover of the machine, following the instructions par.5.1.
2. disconnect the cable of the probe (see cap.6-electrical diagram) from the main board
3. disengage the probe mount, turning the locknut (n.1-pict.5.6)
4. take out the sensible terminal of the probe (n.3-pict.5.6) from the lower sealing jaw
5. take out the cable (n.2-pict.5.6) from the locknut and remove the probe from the machine
6. replace it with a new one



during the mounting operation of the new probe strew the sensible terminal with conductor paste

7. close upper cover of the machine



pict.5.6

- 1 Ring temperature probe
- 2 Wire temperature probe
- 3 Terminal temperature probe

5.5 Sealing pressure

5.5.1 Sealing pressure adjustment

The sealing pressure is already set by the manufacturer according with all materials in normal use.

Should you need a pressure increase/decrease for special purposes, turn the regulation nut do as follows:

1. open the frontal cover as described in par.5.1.
2. using a key, turn anticlockwise the nut (n.3-pict.5.7) in order to make it free to rotate.
3. using a key, turn the screw head pressure (n.2-pict.5.7):
 - Rotating clockwise pressure decrease
 - Rotating clockwise pressure increase
4. Keep the head screw (n.2-pict.5.7) stop, turn clockwise the nut (n.3-pict.5.7) and lock it
5. Close the frontal cover of the machine

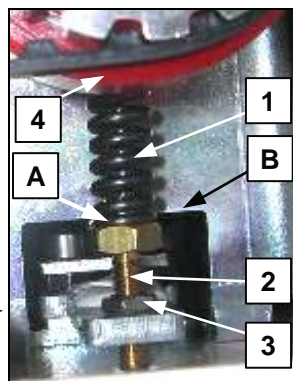


Any pressure increase must be limited to not damage the counter wheel ring (n.3-pict.5.6A) and the motor .

5.5.2 Replacement pressure spring and restore the sealing pressure

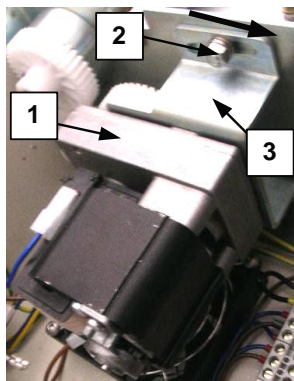
If you need to replace the pressure spring (n.1-pict.5.7), do as follows:

- 1) open the frontal cover as described in par.5.1.
- 2) using a key, turn anticlockwise the nut (n.2-pict.5.7) in order to make it free to rotate.
- 3) using a key, rotate clockwise the screw head pressure (n.3-pict.5.7) in order to make it free the spring pressure (n.1-pict.5.7)
- 4) remove the spring pressure and replace it by new.
- 5) using a key, turn the screw pressure (n.2-pict.5.7) to align the ground plane of the spring pressure (pos.A-pict.5.7) with the traverse cut line (pos. B -pict.5.7)
- 6) lock nut (n.3-pict.5.7) and close the frontal cover.



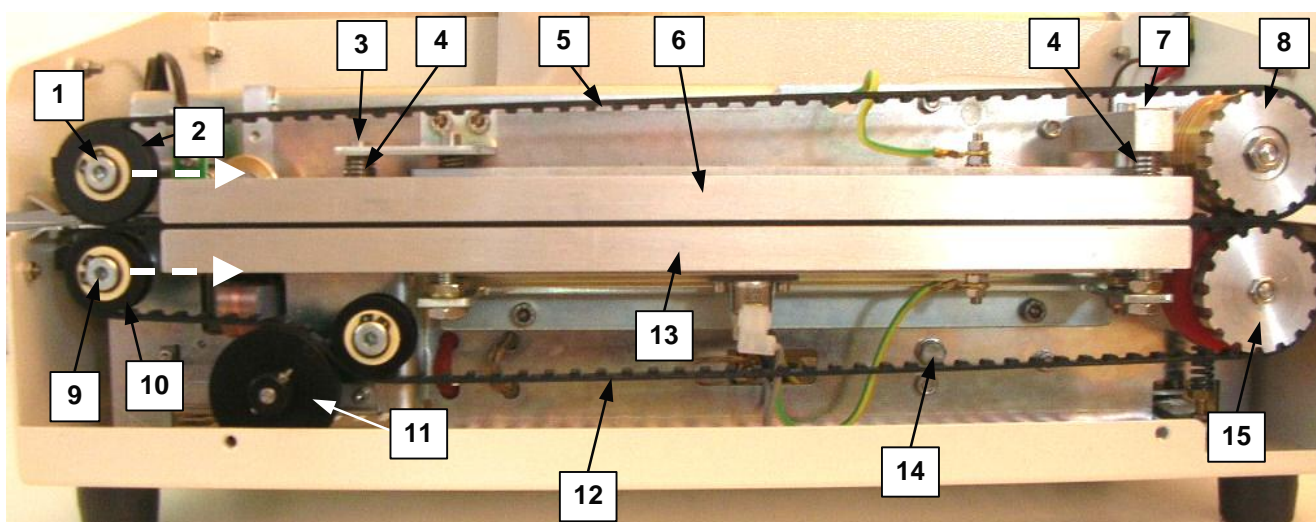
- 1 Pressure spring
- 2 Screw pressure
- 3 Nut
- 4 Counter wheel

pict.5.7



pict.5.8

- 1 Motoreducer
- 2 Upper screw Locking motoreducer
- 3 Support motoreducer



pict.5.9

- | | | |
|------------------------|-----------------------|------------------------------------|
| 1 Pin upper pulley | 6 Upper transport bar | 11 Print pulley |
| 2 Upper pulley | 7 Pin upper pulley | 12 Lower transport belt |
| 3 Plug upper bar | 8 Upper motor pulley | 13 Lower transport bar |
| 4 Transport bar spring | 9 Pin lower pulley | 14 Lower screw locking motoreducer |
| 5 Upper transport belt | 10 Lower pulley | 15 Lower motor pulley |

5.6 Replacement of the transport belts



*The transport belts do not need any previous maintenance.
Their replacement is suggested only in case the teeth or the cover, which are in contact with the pouches, are worn out.*



Extract the ink ribbon case

Act as follows:

- open the upper cover and the frontal cover following the instructions to the par.5.1
- discharge the sealing pressure (see par.5.5)
- After loosening the upper screw lock (n.2-pict.5.8) and the screw rotation (n.14-pict.5.9), disconnect the motoreducer unit (n.1-pict.5.8) by rotating in the direction of the arrow the arrow pict.5.8
- disengage the motor reducer (n.1-pict.5.9) turning it anticlockwise (see arrow in pict.5.7)

A. TAKE OUT THE UPPER BELT TRASPORT

- remove the upper transport jaw (n.6-pict.5.9) unscrewing the two guide pins (n.3-pict.5.9 and n.7-pict.5.9)



Be careful not to loose the spring pressure (n.4-pict.5.9)

- unscrewing the lock screw (n.1-pict.5.9) of the *upper pulley pivot*.
- move the upper conduct pulley (n.2-pict.5.9), according to the arrow direction of pict.5.9
- take out the upper transport belt (n.5-pict.5.9) from the upper motor pulley (n.8-pict.5.9) with a low pressure towards the outside

B. TAKE OUT THE LOWER BELT TRASPORT

- unscrewing the lock screw (n.9-pict.5.9) of the upper conduct pulley (n.10-pict.5.9)
- move the conduct motor pulley (n.10-pict.5.9), according to the arrow direction of pict.5.9
- take out the lower transport belt (n.12-pict.5.9) from the lower motor pulley (n.15-pict.5.9) with a low pressure towards outside

C. How to mount the lower trasport belt

- Insert the lower transport belt (n.12-pict.5.9) first of all on the lower motor pulley than on the lower conduct pulley (n.10-pict.5.9) and finally on the print pulley (n.11-pict.5.9)
- Stretch the lower transport belt (n.10-pict.5.9) and fixing the pivot lower conduct pulley (n.9-pict.5.9) with the relative screw



Verify the correct insertion of the lower belt in the pulley by turning slowly in the lower motor pulley



Correct tensioning when:

- the belt has small vertical oscillations during the transport
- the ink cartridge is inserted, the belt does not shift on the print pulley (n.11-pict.5.9)

D. How to mount the upper trasport belt

- Insert the upper transport belt (n.5-pict.5.9) first of all on the upper motor pulley (n.2-pict.5.9), then on the upper conduct pulley (n.2-pict.5.9)
- Stretch the upper trasport belt and fixing the lower pivot lower conduct pulley (n.1-pict.5.9) with the relative screw



Correct tensioning when the belt has small vertical oscillations during the transport



Verify the correct upper belt fitting up on the pulleys, turning the upper motor pulley

E. RESTORE THE MACHINE

- remount the upper transport jaw (n.6-pict.5.9) screwing the two guide pins (n.3 and n.7-pict.5.9)
- restore the correct sealing pressure (see par.5.5)
- reposition in its correct way the motoreducer (n.1-pict.5.8)
- remount the front cover and the upper cover.

5.7 Replacement of the heating element

Act as follows:

- open the upper cover and the frontal cover following the instructions as described in par.5.1

1. EXTRACTION OF THE UPPER SEALING JAW

- remove the upper transport jaw (n.6-pict.5.9) unscrewing the two guide pins (n.3-pict.5.9 and n.7-pict.5.9)



Be careful not to loose the two pressure springs (n.4-pict.5.9)

- disconnect the two cable edges of the upper heating element from their terminal bloc (see electric scheme cap.6)
- unscrew the locknut of the ground cable (n.2-pict.5.12)
- unscrew the nut n.3-pict.5.12)
- unscrew the no-head screw (n.1-pict.5.12) of the heating element
- unscrew the two guide pins (n.1 and n.4-pict.5.14)
- remove from the machine the assembly jaws+heating element (n.2-pict.5.14)

2. REPLACEMENT OF THE UPPER HEATING ELEMENT

- insert the new heating element in the upper sealing jaw in such a way that it is completely contained into the jaw seat.



During the remounting operations do not exceed with the tightening, especially in the lock no-head screw of the heating element

- remount everything by following the reverse procedure

3. REPLACEMENT OF THE LOWER HEATING ELEMENT

- Extract the upper sealing jaw (see point 1)
- disengage the probe mount, turning the locknut (n.3-pict.5.14), and remove the probe
- disconnect the cable edges of the heating elements from their terminal bloc
- disconnect the two terminal (n.3-pict.5.113) edge of the safety thermostat (n.4-pict.5.10)
- unscrew the locknut (n.2-pict.5.13) of the lower ground cable (n.4-pict.5.13)
- unscrew the nut n.1-pict.5.13
- unscrew the no-head screw (n.3-pict.5.13) of the heating element
- unscrew the lower locknuts (n.2-pict.5.10) securing the lower sealing jaw the traverse of the machine and remove the assembly heating element+jaw



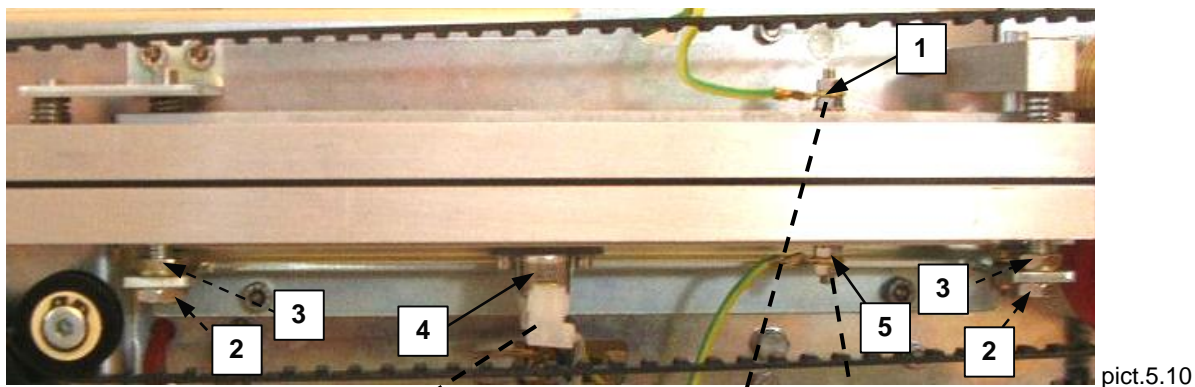
Never loosen the register nuts (n.3-pict.5.10)

- insert the new heating element in the sealing jaw in such a way that it is completely contained into the jaw seat and lock it with the the no-head screw (n.3-pict.5.12)



During the remounting operations do not exceed with the tightening, especially in the lock no-head screw of the heating element

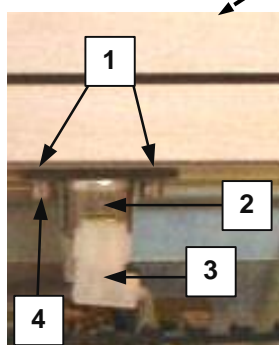
- remount everything by following the reverse procedure



pict.5.10

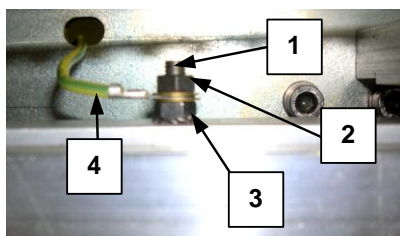
- 1 Screw of the upper ground cable
- 2 Lower locknut
- 3 Upper adjusting nut

- 4 Safety thermostat
- 5 Screw of the lower ground cable



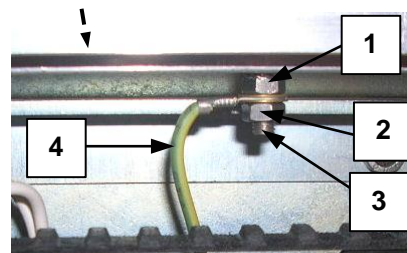
pict.5.11 (pos.4-pict.5.10)

- 1 Spacer washers
- 2 Safety thermostat
- 3 Terminals thermostat cable
- 4 Screw lock thermostat



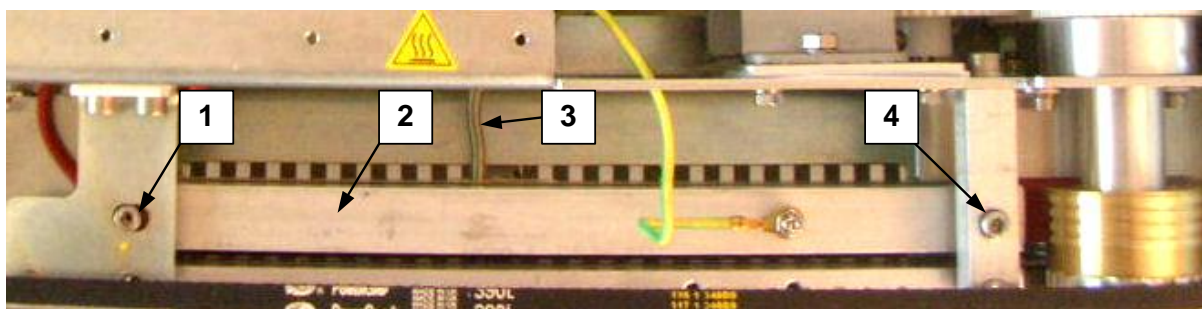
pict.5.12 (pos.1-pict.5.10)

- 1 No-head screw
- 2 Nut
- 3 Nut
- 4 Upper ground cable



pict.5.13 (pos.5-fpict.5.10)

- 1 Nut
- 2 Nut
- 3 No-head
- 4 Lower ground cable



pict.5.14

- 1 Pin of the upper sealing jaw
- 2 upper sealing jaw

- 3 Cable of the temperature probe
- 4 Pin of the upper sealing jaw

5.8 Replacement of the sealing jaws



The replacement of the sealing jaws is necessary only in case of worn out of the surface coating.



Before replacing the sealing jaws remove the ink cartridge as described in par.4.6.2

For the replacement procedure act as described in the par.5.7

- do the same operations described in paragraph 5.7 without disconnecting the cables of the the terminal heating element.
- remove the protection thermostat (n.4-pict.5.10) from the lower sealing jaw.



When you remount the thermostat, be sure to remount the spacer washers (n.1-pict.5.1) placed between the plate and the lower sealing jaw.

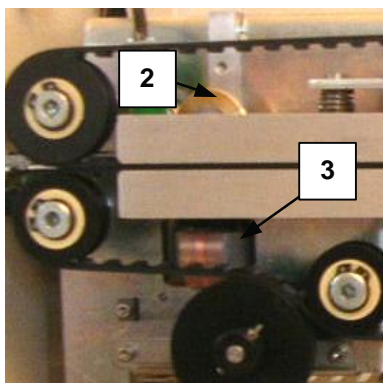
5.9 Printing unit



The on board printer needs some simple but necessary maintenance operations.

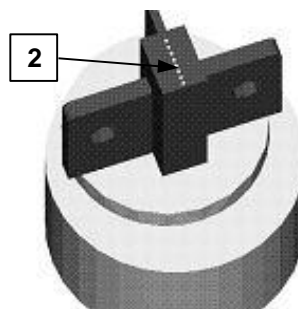
It is composed by the following components :

- printer head (n.1-pict.5.15)
- ink-cartridge (n.7-pict.4.4)



pict.5.15

- 2 Counter print roller
- 3 Printing head



pict.5.16

- 2 Print wire zone

PRINTING HEAD

Keep clean the print wire zone (n.2-pict.5.16) and the surface of the counter print roller (n.2-pict.5.16), to avoid the rest of ink.

Do as follows:

- open the upper cover and the front cover following as described in par.5.1
- extraction of the ink ribbon case (see par.4.6.2)
- use a cotton wad with alcohol and clean the print wire zone (n.1-pict.5.16) and the surface of the counter print roller (n.2-pict.5.15)
- check the counterroll check the counter print roller rotate freely on its pivot



Do not change the gap between the printing wheel and the printing head, just pre-adjusted for the normal used pouches



TO AVOID ANY DAMAGE ON THE WIRE PRINT HEAD, DO NOT USE THE MACHINE WITHOUT INSERTING THE INK CARTRIDGE.



If the cleaning operation is done after an intensive use of the machine, be sure that the printing head is not too hot, to avoid any problems in case of contact.

INK CARTRIDGE

If the use of the sealer is intensive, periodically verify :

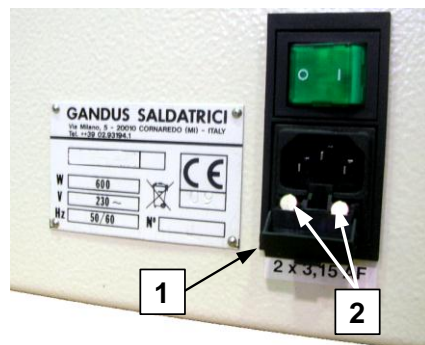
- there is not a ink surplus accumulation on the ink-ribbon visibile part
- the ink-ribbon is not worn out (tear and/or fringe)
- the ink-ribbon is correctly driven by the machine transmission

5.10 Replacement of the line fuses



Turning off the luminous green general switch (n.3-pict.1.1) and unplug it from the main supply (n.2-pict.1.1)

- open the fuse box drawer (n.1-pict.5.17) as shown
- pull out the fuses to be replaced, eventually helping you with a suitable screw-driver
- insert the new fuses and close the fuse box pushing the drawer



- 1 Line fuses
- 2 Fuse box drawer

pict.5.17

5.11 Replacement of the battery

When the display shows the relative message at the end of the BATTERY TEST, it is necessary to replace it.

The battery (MBB in the electric scheme cap.6 and pos.1-pict.5.18) is placed on the mainboard and must be replaced when the sealer loses the memory of its data.



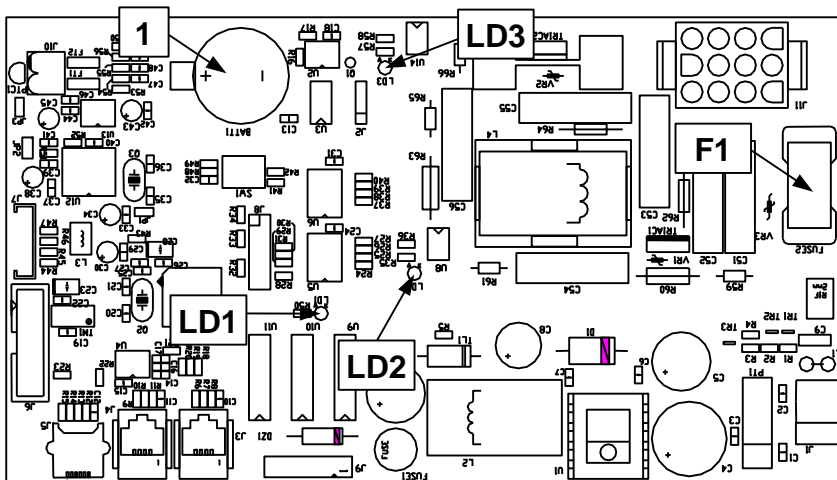
The keeping data battery has to be replaced with the machine switched off. This is important in order to avoid any damages on the main board (pict. 5.18)

Do as follows:

- open the upper cover and the front cover following as described in par.5.1
- paying attention, push to the left the lever that allows to lock the battery and its contact: the battery will rise and may be removed.
- insert the new battery keeping the symbol "+" upwards
- switch on the machine and wait for the positive result of the BATTERY TEST
- Set current date and time (see par. 3.3.7)

5.12 Mainboard

For the purposes of diagnostics, the leds are shown in pict.5.18.



- 1 battery
- F1 fuses power line 3.15AT
- LD1 Infeed photocell led
- LD2 Motoreducer led
- LD3 Heating element led

pict. 5.18

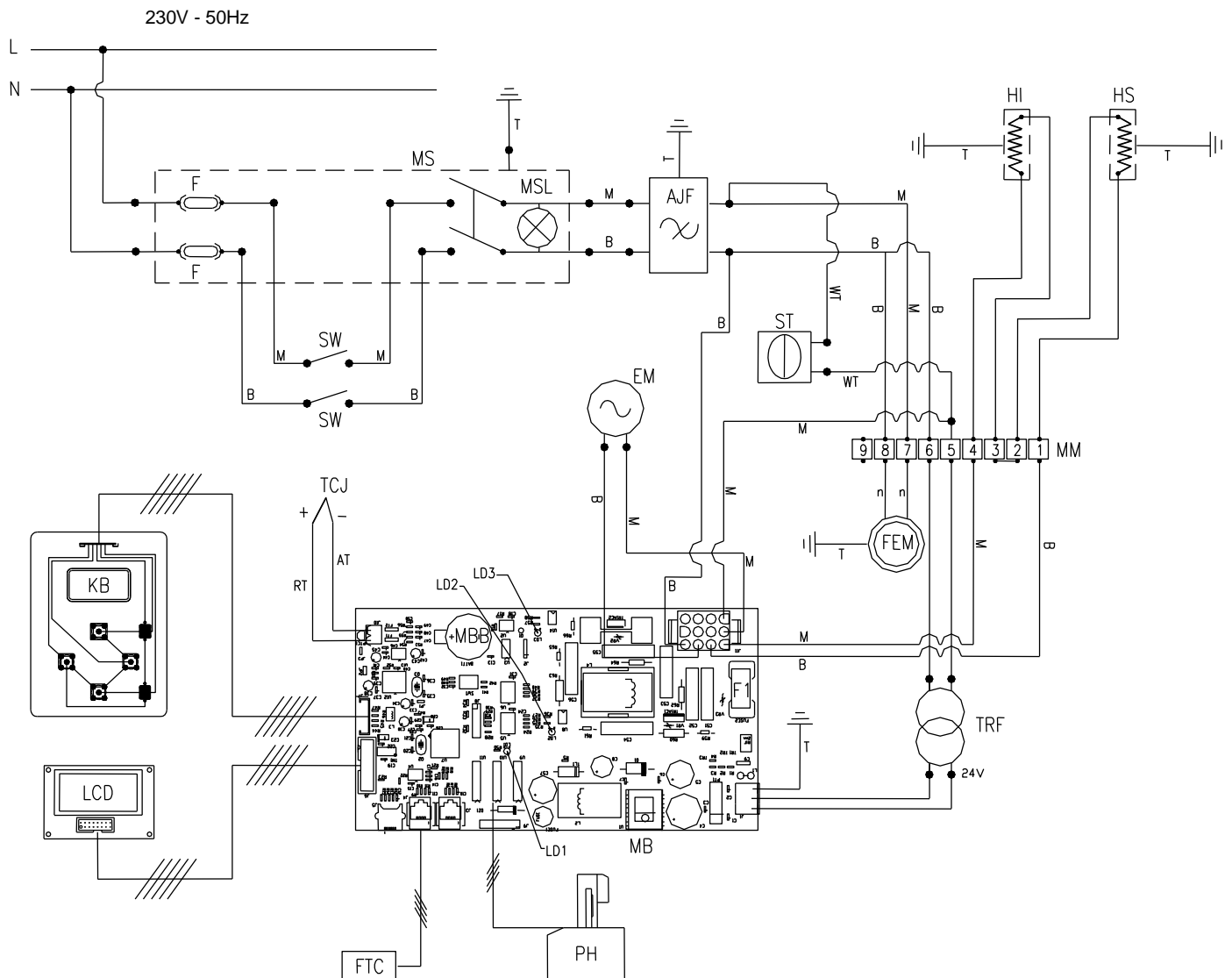
5.13 Replacement of the motoreducer

If you need to replace the motoreducer (n.1-pict.5.8) do as follows:

- open the upper cover and the frontal cover of the machine as described in par.5.1
- disconnect the 2 motor power cable terminals and the motor ground cable terminal
- Unscrew the lower screw (n.14-pict.5.9) and the upper screw (n.2-pict.5.8) blocking the motor
- Remove the motor unit (n.1-pict.5.8) with its support (n.3-pict.5.8) from the machine and replace everything with a new
- Put the new motor unit with its support paying attention to the engaging between the teeth of gears
- Connect the terminals of the motor power cables and those of the ground cable
- Close the upper cover and the frontal cover of the machine

6. ELECTRICAL DIAGRAMS

6.1 Electrical diagram at 230V - 50Hz



Legend

AJF	anti jamming filter	LD3	heating modulation led
AT	blue color thermocouple cable	M	brown color cable
B	blue color cable	MB	main board
EM	motoreducer 230Vac	MBB	battery main board
F	line fuses 3.15AF	MM	terminal board
FEM	fan	MS	main switch
FER	ferrite	MSL	main switch lamp
F1	fuses power line 3.15AT	N	black color cable
FTC	infeed photocell	PH	printing head - 9 dots
HI	lower heating element 200W 110Vac	RT	Red color thermocouple cable
HS	upper heating element 200W 110Vac	ST	safety thermostat
KB	command keyboard	T	ground cable
LCD	LCD display board	TCJ	thermocouple J
LD1	photocell led	TRF	transformer 230Vac / 24Vac
LD2	motor reducer led	WT	white color cable

7. WARRANTY TERMS AND SPARE PARTS

7.1 Warranty terms

The heat-sealer are built to perform and they are guaranteed for 12 months after delivery. For the duration of the warranty, the manufacturer will replace parts or elements that, under his examination, should result defective for factory construction, error or faulty materials, but not the parts presenting normal wear, demonstrating incorrect use of the equipments or tampering.

Are excluded from this warranty the materials subject to normal wear, such as protective cloths, belts, straps rubber, resistors, etc.

This warranty is accepted in our offices, for equipment delivered to us free of charges, that shall be returned on ex-factory basis.

This warranty is void if the heat-sealer has been altered or has been fitted with unauthorized spare parts.

The warranty is also void if the customer does not comply with the form of payment established even once.

For the parts not manufactured by *Gima S.p.a.*, the warranty is conditioned by the one provided by the supplier.

For the duration of the warranty too, if the heat-sealer is subject to any intervention by our personnel outside our seat, the manufacturer will charge work-hour and transportation fee.

Gima S.p.a. declines every responsibility for eventual damages to the machine, in case of deliveries made without the original packing

7.2 Spare parts ordering

Always mention:


1. Serial number of the sealing machine
2. Quantity of the spare part you need
3. Position and table number identifying the requested spare part

8. PROBLEMS & SOLUTIONS

Here below you will find the possible troubles that can occur during the normal functioning of the sealer and for each one the possible solution.

In case you cannot solve the troubles with these instructions, put in contact with our dealer or with us directly.

8.1 Power supply

- The sealer does not function and the main green luminous switch (n.3-pict.1.1) does not light.
 - a) The fuses (n.2-pict.5.17) are burnt out: replace them with new one of the same type and class
 *If they burn out again after the replacement, put in contact with the seller or manufacturer because it could be a short circuit of the electrical system in the machine*
 - b) The power cord (n.2-pict.1.1) is not connected or interrupted: connect it again or replace it
 - c) The microswitches SW (n.1-fig.5.5) is faulty or the cover is not closed properly and that the microswitch does not works
- The sealer does not function and the main green luminous switch (n°1 pict. 1.1) lights.
 - a) Verify that the main board is correctly powered: the led has to be lighted. If it not happens, Verify the presence of tension from the transformer TRF (see electrical diagram)
 - b) The safety thermostat has intervened: turning the luminous green general switch (n.3-pict.1.1) and unplug it from the main supply (n.2-pict.1.1)

8.2 Sealing

- The seal has some defects alongside the edges:
 - a) verify if the set sealing temperature value is suitable for the pouches to be sealed (see table par 4.1)
 - b) wait for the stabilization of the sealing jaws temperature especially if you made a new temperature adjustment
- The seal, even if done at the correct temperature, is not strong:
follow the instructions par. 4.3
- The sealing jaws temperature remains at the ambience temperature:
 - a) Verify the red LED on the electronic control unit (see para. 5.12):
 - LD3 on: outage of one or both elements (see par.5.7)
 - LD3 off: failure control electronics, please contact the service
- The seal, at the beginning, shows a shrink of the plastic material:
 - a) check that the sealing path is free and clean. Verify that the pouch, if it is heavy or voluminous, does not find any obstacle in its in-feed
 - b) verify that the internal or external pouch edges are clean and dry, before doing the seal
 - c) check the sealing jaws and the a counter pressure are clean (see par.5.2)
 - d) check if the sealing jaws are clean

8.3 Transport

- The in-feed motor does not stop automatically after 10 sec. from the last sealed pouch:
 - a) check the vertical alignment between the in-feed photocell transmitters (n.6-pict.4.2) and if they are clean. The alignment is correct if the led lights only when a pouch is inserted
 - b) check that the linking phone cord is correctly inserted into the in-feed photocell plug and in the main board
 - c) the in-feed area of the machine is exposed to excessive brightness of the environment; calibrate the

in-feed photocell.

- The in-feed motor does not transport:
 - a) the motor gears are worn out: replace the motor reducer
 - b) check that the power linking “ faston ” to the motor reducer are correctly inserted
 - c) verify that the led switches on (par.5.12) when a pouch is in-fedded; on the contrary put in contact with your dealer or directly with Gima S.p.a.
- Pouches jam. at the exit:
 - a) Follows the instructions into the par. 2.5, 4.7.

8.4 Printer

- The printing characters are not too clear on the pouch:
 - a) verify the ink cartridge: if necessary, replace it
 - b) check if there is too much ink deposit on the printing head area and on the counter wheel (see par. 5.9)
- The printing characters are too marked on the pouch:
 - a) the ink ribbon could be too inked. Replace it and do some printing test.
 - b) check the situation of the printing area (see par. 5.9)
- The built-in wire print head does not print on the pouch:
 - a) the printer has disabled, see par. 3.2.2
 - b) the infeed area of the machine is exposed to excessive ambient light; reposition the sealer or to protect the entrance area from light.
 - c) the wire of the print head can be locked in their seats by an excess of ink or dust. Perform cleaning (see par. 5.9).
 - d) the print head is electrically interrupted. Make sure the flat cable connector is properly inserted in its place of main board (see electric diagram)

8.5 Alarms

If an alarm message appears on the display of the machine, go to the paragraph 3.4 and follow the instructions about how to solve it.

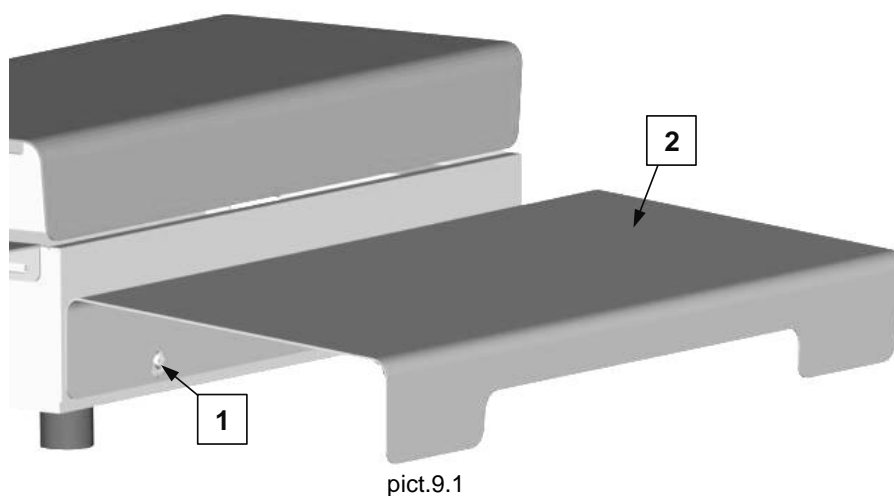
9. ACCESSORIES

9.1 Working plane

The working plane is an accessory, which makes easier the pouches sliding during sealing operation.

APPLICATION OF WORKING PLANE TO THE SEALER

To applicate the working plane to the sealing machine, it is necessary to introduce the cavity (n.1-pict.9.1) on the backside of the plane into the two screws on the front cover n.5-pict.4.1 of the sealing machine



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