

## 9 Proper use of the sealer

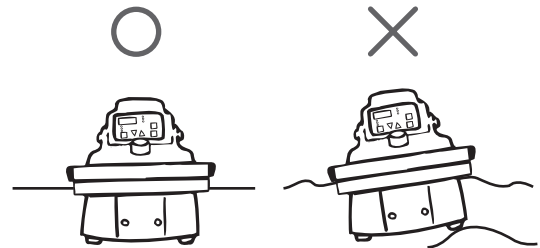
Use only as described in this manual.

There is a risk of danger and malfunctions may result if the machine is used not in accordance with this manual.

### 9-1 Setting the machine

CA series is the table-top type sealer. Place the machine on a flat, horizontal working table.

The optional CA stand is available when you cannot secure the proper working place.



### 9-2 Mounting the table

- Mount the table-switch plate [For CA-300/300-W (D) series]

Skip this procedure when using the air pedal as a foot switch.

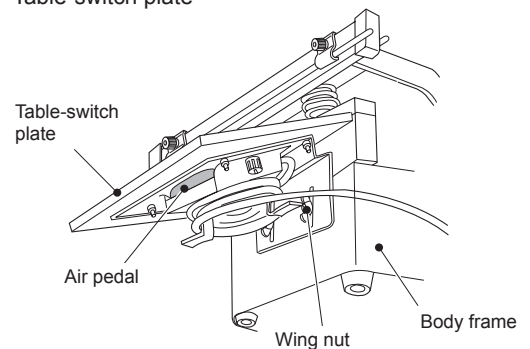
#### 1 CA-300, CA-300W (D)

Fix the table-switch plate to the body frame using the wing nut. The height can be adjusted to the optimum level depending on the application. (The wing nuts are installed to the bolts of the body frame where the table is to be installed.)

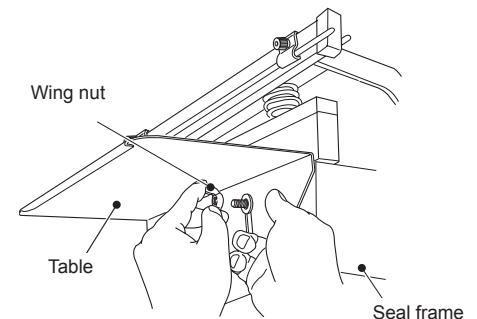
#### 2 CA-450, CA-600 Series

The table-switch plate cannot be mounted to these sealer models. (Refer to "9-7 Select the operation mode >>> How to set each operation mode.")

- Table-switch plate



- Standard table



- Mount the standard table [For CA-450-5/450-5W (D) series]

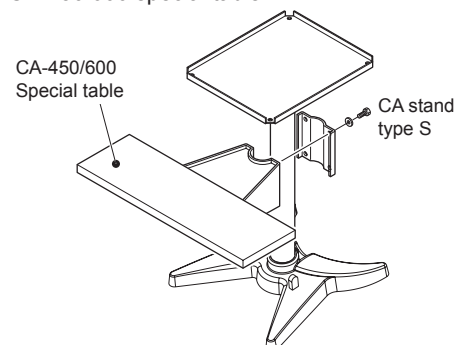
For the CA-450 series of sealers, the optional standard table can be mounted.

Fix to the seal frame using the wing nuts and bolts. The height can be adjusted to the optimum level depending on the application.

- Mount the CA-450/600 special table (Optional)

The CA-450/600 special table can be mounted to the CA stand type S. The air pedal cannot be installed to the special table.

- CA-450/600 special table

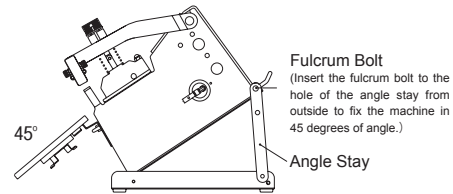


## 9-3 Changing the angle

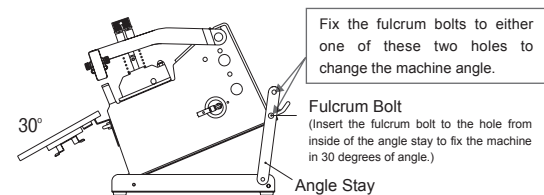
The sealer angle of the CA series can be adjusted to 30° or 45°.

At the time of factory shipment, the sealer is adjusted to the angle of 45°.

- If you would like to use the sealer with this angle, please apply the hook to the angle stay before using the sealer.

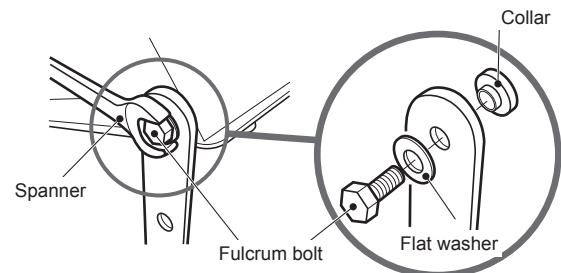


- When using the sealer with 30°, follow the below procedures to change the mounting position to the angle stay and apply hook before using.

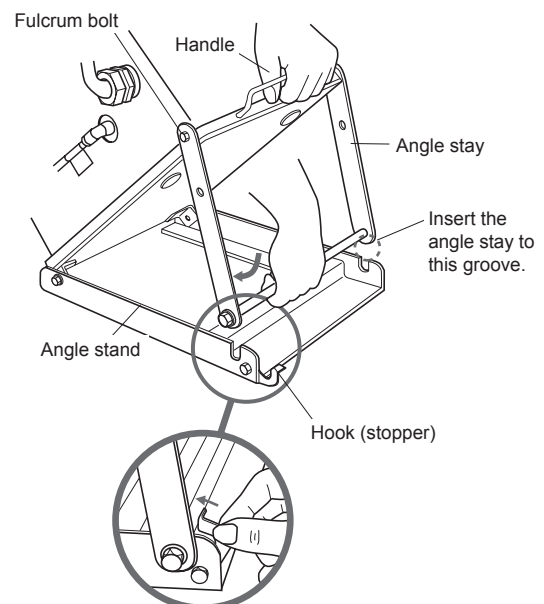


- 1 Remove the hook that fixes the angle stay, and then remove the angle stay from the groove of the angle stand. Hold the handle at the backside of the machine and lower the machine slowly.

**Caution** When removing the angle stay, please be careful not to pinch your hands between the machine and angle stand.



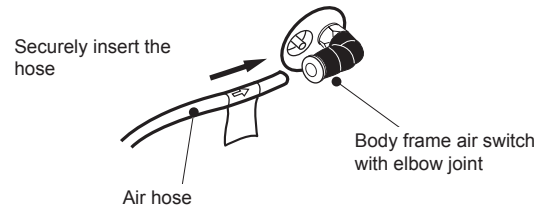
- 2 Remove the fulcrum bolts, flat washers and collars on both sides of the machine. Fix the machine to the holes of the angle stay in the order of the fulcrum bolt, flat washer, angle stay and collar.
- 3 Hold the handle and lift up the machine. Insert the angle stay to the groove of the angle stand.



- 4 Apply the hook to the angle stay to fix it.

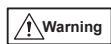
## 9-4 Insert the air hose

Insert the air pedal hose securely into the elbow of the main frame air switch.



## 9-5 Plugging in the electrical power cord.

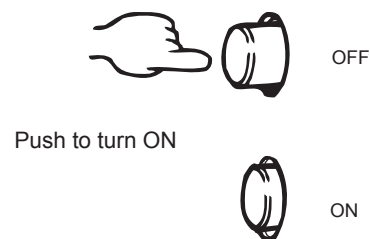
The power cord is located on the right side of the machine, when facing toward it. Make sure the electrical outlet has adequate current carrying capacity as described at "1. Specification." Insert the electric power plug fully into the wall outlet.



There is a danger of fire if the electrical power source does not meet proper specification.

## 9-6 Power switch ON

The control unit display will turn on when the power switch, located on the side of the common frame, is pushed on.



## 9-7 Select the operation mode

The "Auto cycle START/STOP" button allows you to select between manual and continuous automatic operation.

Turn ON or OFF the auto-cycle interval mode after selecting the operation mode referring to "9-8 Setting the sealing condition."

For the detail, refer to "9-7 Select the operation mode >>> How to set each operation mode."

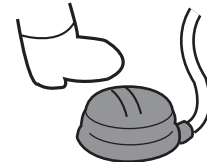
### ■ Auto-cycle interval mode OFF (Auto cycle interval lamp OFF)

- 1 Air pedal operation ..... The machine operates when the air pedal is depressed.
- 2 Table switch plate operation ..... The machine operates when the table switch plate is pushed

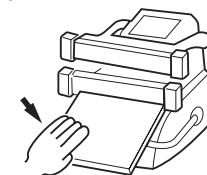
### ■ Auto-cycle interval mode ON (Auto cycle interval lamp ON)

- 3 Auto cycle mode ..... Automatic operation takes place based on the preset intervals.

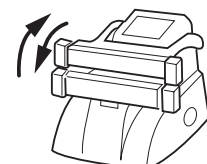
#### Air pedal operation



#### Table-switch operation



#### Auto-cycle mode



### How to set each operation mode

Operation mode	CA-300 Series	CA-450/600 Series
Air pedal operation	Push the Auto Cycle START/STOP button to turn OFF the auto cycle, and remove the air pedal set to the table-switch plate. Place the air pedal to the optimum place.	Push the Auto Cycle START/STOP button to turn OFF the auto cycle, and set the air pedal included in the accessories referring to "9-3 Insert the air hose" and use it to operate the machine.
Table-switch plate operation	Push the Auto Cycle START/STOP button to turn OFF the auto cycle, and mount the table-switch plate referring to "9-2 Mount the table" and use it to operate the machine.	This operation mode cannot be used.
Auto-cycle mode	Set the auto-cycle interval time, and turn ON the auto-cycle mode by pushing the Auto Cycle START/STOP button.	

## 9-8 Setting the sealing condition with the control unit

The heating time, cooling time and auto-cycle interval can be set with the control unit.

The setting values will vary depending on the pouch/film material, thickness, etc. Reset the seal conditions every time you change the bag.

Pushing the SET button changes the modes in the following order:

COUNTER→HEATING TIME→COOLING TIME→AUTO CYCLE INTERVAL.

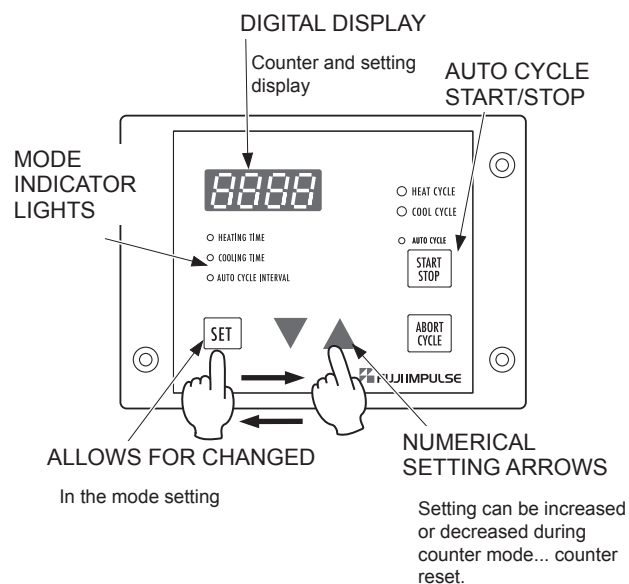
The mode indicator lights show which mode is currently displayed. If no light is lit, the machine is in the counter mode.

#### Setting the heating time

- Activate the "heating temperature" mode. Use ▲/▼ arrows to set the heating temperature. [Setting range : 0.1 - 1.6 sec.]
- The optimum heating time will differ depending on the voltage when the machine is used, and also the thickness and type of film.
- Set the heating time at minimum to make a sufficient seal. This will increase the productivity and also prevent unnecessary power consumption.

#### Setting the cooling time

- Activate the "cooling time" mode. Use ▲/▼ arrows to set the cooling time. [Setting range : (set heating time) - 5.0 sec.]
- The cooling time should be from 1.5 to 2 times that of the heating time. In order to guarantee sufficient cooling time, the FA series is designed so that the cooling time cannot be set lower than the heating time.
- Upon setting the heating time, if it is longer than the cooling time, the control unit will automatically set the cooling time to match the heating time.

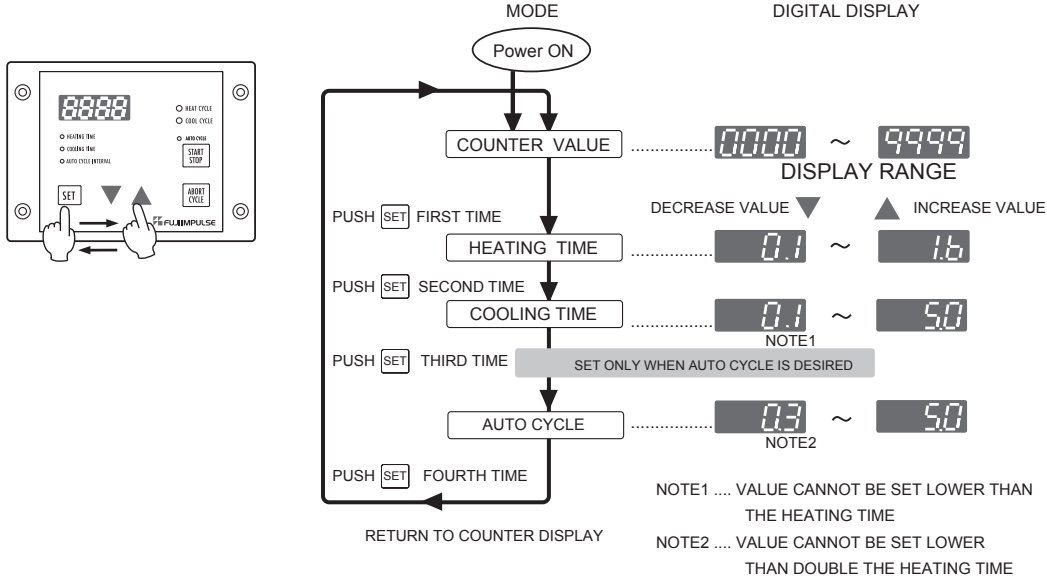


□ Setting the auto-cycle interval

- Activate the "auto-cycle interval" mode. Use ▲/▼ arrows to set the interval. [Setting range : (set heating time x 3) - 5.0 sec.]
- The interval time for the auto-cycle interval mode will be set 3 times longer than the set heating time, and cannot be set shorter than it.

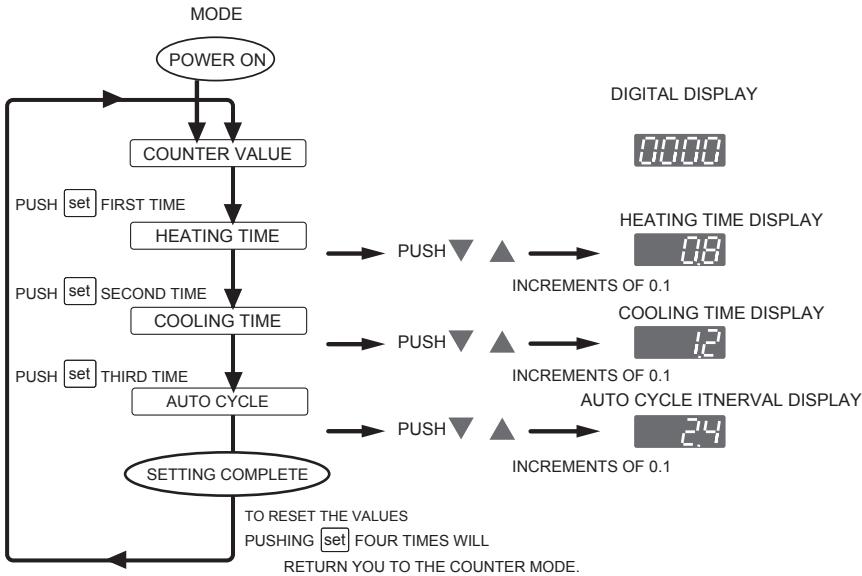
When the heating time is made longer, the control unit will automatically adjust the auto-cycle interval time if it is shorter than 3 x heating time.

Setting the different modes



Example)

Settings : Heating 0.8 sec. Cooling 1.2 sec. Auto cycle 2.4 sec.

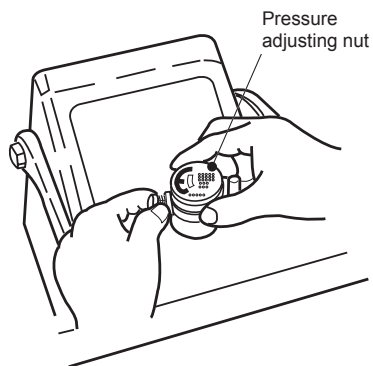


## 9-9 Adjust the seal pressure

The pressure adjusting nut is adjusted to the "NORMAL" position for the film of 0.1 to 0.2 mm thickness at the time of factory shipment.

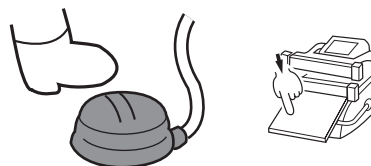
The required sealing pressure varies depending on the type and thickness of the film. Adjust the sealing pressure according to each of the film to be used.

**Attention!** Perform the pressure adjustment referring to "11-1 Adjusting the sealing pressure." Change the pressure setting every time you change the film.



## 9-10 Perform test sealing

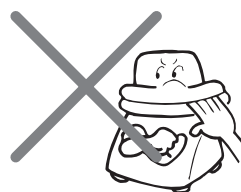
After completing the control unit and seal pressure adjustment, turn off the auto-cycle mode and manually perform the seal test to find the optimum sealing condition to your film.



## 9-11 Seal with the selected operation mode

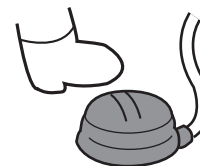
**Caution** The sealing area become hot with the prolonged use, and there is a danger of burning.

Also, it is extremely dangerous to place fingers to the sealing area where the strong pressure is applied. The machine is designed to release the pressure when the microswitch is not activated within 0.8 seconds due to the foreign objects being inserted to the sealing area. However, the strong pressure is applied especially to both ends of the sealing jaws. Please be careful as the sealer may start heating. (Especially for CA-450 and 600 series.)



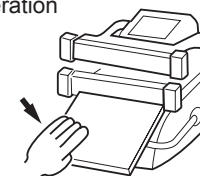
### 1 Air pedal operation

Place a pouch to the sealing area. Depressing the air pedal will lower the pressure lever to start sealing.



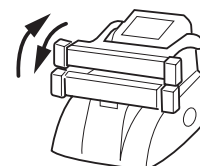
### 2 Table-switch plate operation

Place a pouch to the sealing area. Lightly press the part of the table-switch plate where indicated by the label to lower the pressure lever and start sealing.



### 3 Auto-cycle interval mode

Automatic operation takes place based on the preset intervals. Place a pouch to the sealing area according to the timing that the pressure lever descends. You can deactivate the auto-cycle mode by pushing the Auto-Cycle START/STOP button.



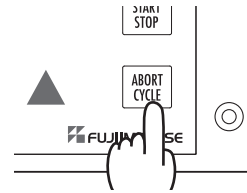
### 1 Air pedal operation

### 2 Table-switch plate operation

### 3 Auto-cycle mode

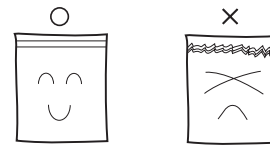
● **ABORT CYCLE button**

To stop the operation after the machine started working, push the “ABORT CYCLE” button. The lever will return to the initial position. The set value will not be erased even if the “ABORT CYCLE” button is pressed.



**9-12 Finishing sealing**

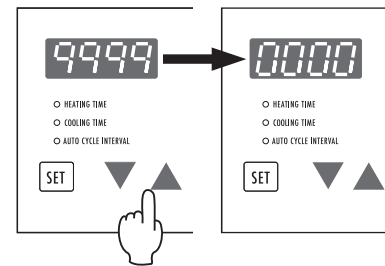
After the heating and cooling cycle has finished, the pressure lever returns to the initial position, and the sealing is complete. If a sealing is not clean enough, adjust the heating/ cooling time or sealing pressure.



**9-13 Counter reset**

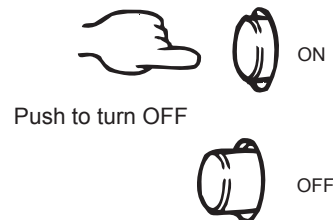
As the sealing operation proceeds, the numeric value of the counter increases one at a time from 0000 to 9999.

When you want to reset the counter to 0000, push either ▲ or ▼ arrow buttons while the machine is in the counter mode.



**9-14 Power switch OFF**

After finishing operation, always turn OFF the power switch.



As the set value and the seal count are retained by the control unit, there is no need to put the value every time after turning OFF the power switch.

Unplug the power outlet in the case of not using the machine for a while.

**9-15 Inspection after operation**

After use, please clean up the parts. Inspect parts such as Teflon and heating element to make sure that they are not damaged. If the parts appear to be damaged, replace them referring to operating instruction.