

## 9 Proper use of the sealer

Before using the Fi/FiK series, read “8 How to assemble the sealer” thoroughly and properly assemble the sealer head, support pipe and stand base. Also use the sealer only as described in below “Proper use of the sealer”. There is a risk of danger and malfunctions if the machine is not used in accordance with this manual.

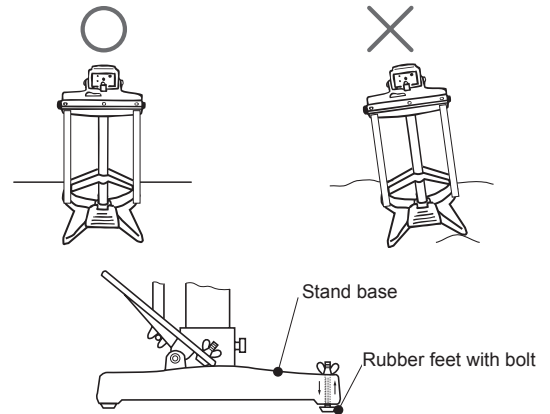
### 9-1 Setting the machine

Place a machine on a flat, horizontal surface.



Installing the machine on an unstable or inclined surface may cause the overturn of the sealer.

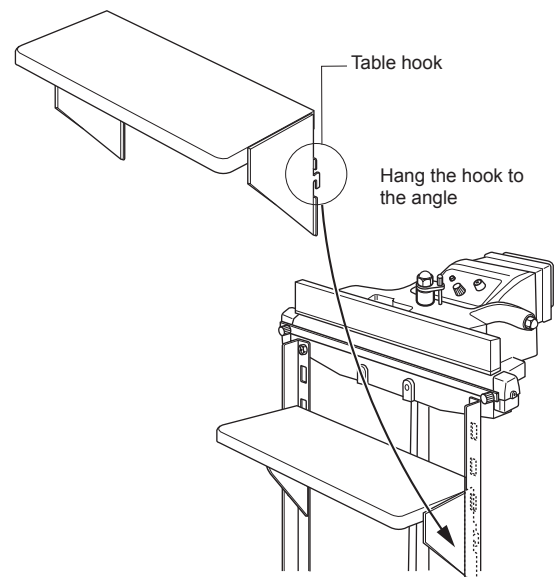
Loosen the wing nut fixed to the rubber feet with bolt to adjust the height of rubber feet to accommodate to some uneven surface.



### 9-2 Mounting the table

If the table is not necessary, you do not need to perform this process.

Secure the special table for FR-450 series by inserting the hook of the table to the holes of the angle at the optimum position depending on the application of use.



### 9-3 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.

### 9-4 Power switch ON

The power lamp for the timer will turn on when the power switch, located on the side of the common frame is pushed on.



Turning ON the power switch



### 9-5 Setting a sealing condition with the timer

Set the heating time with the timer.

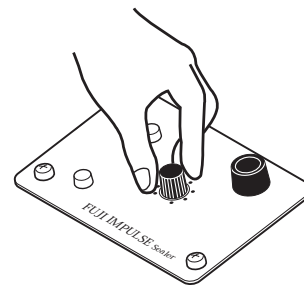
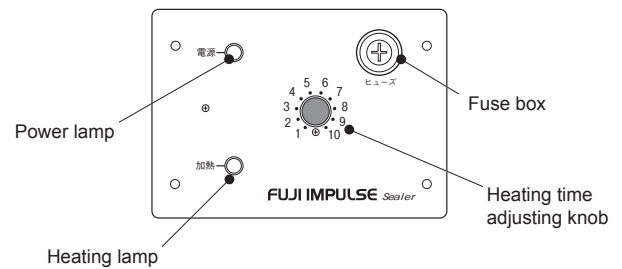
The setting will differ depending on the type or thickness of your packaging material. Change the setting every time you change the packaging material.

- Set the heating time

Turn the heating time adjusting knob to set the heating time. [Setting range: 0.1 - 1.6 seconds]

The heating time differs depending on the film/pouch.

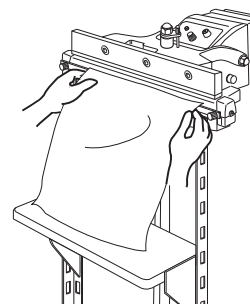
Set the heating time at a minimum required to make a sufficient sealing to increase work productivity and avoid unnecessary power consumption.



**Warning** There is a danger of fire if the sufficient cooling time explained in “9-7 >>3” is not allowed when using the sealer for an extended period of time.

### 9-6 Place a pouch to the sealing area

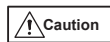
Hold a pouch with both hands and stretch it tight to avoid wrinkles to the sealing surface.



## 9-7 Depress the foot pedal

Cooling time is important when using an impulse sealer. After the film is heated, the film must cool with the frame and pressure lever in the closed position. After the heating lamp turns off, keep on depressing the pedal for 2 - 3 seconds to let the film be cooled off.

- 1 Depress the foot pedal until you hear the click sound of the microswitch being activated. Heating lamp will turn on and the heating process begins.



Do not depress the pedal more than necessary as there is a danger of damaging parts such as a microswitch. Make sure not to compress the pressure rubber lower than 22mm in height.

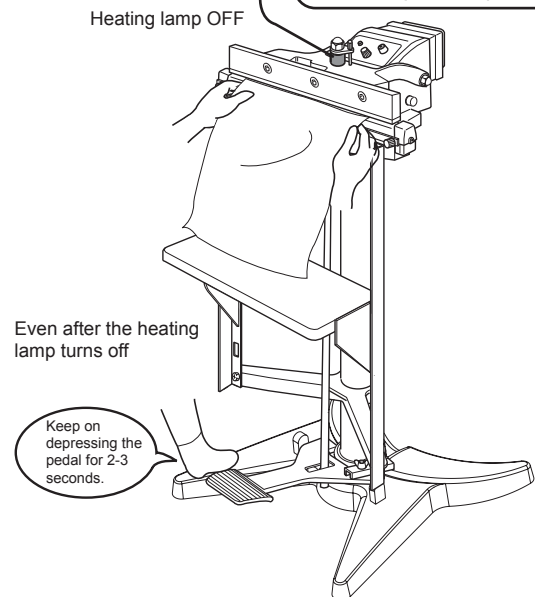
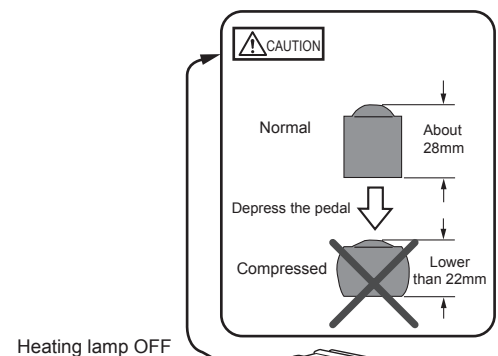
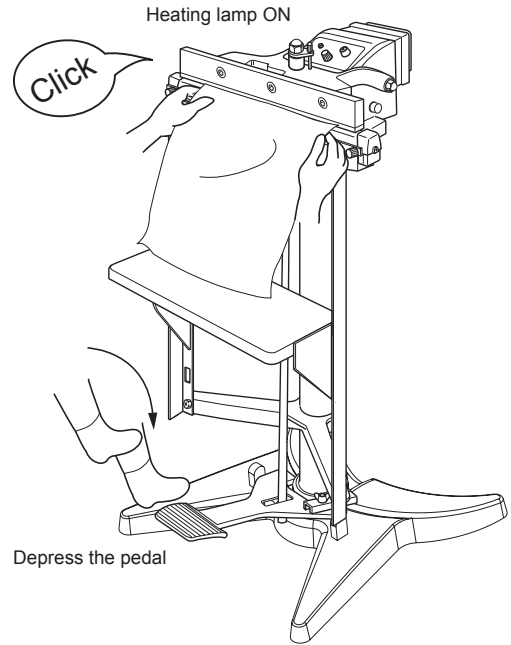
- 2 After passing the heating time, the heating lamp will be turned off.

- 3 Keep on depressing the pedal for 2 - 3 seconds after the heating lamp turned off to allow sufficient cooling time.



If the cooling time is not enough, the seal will become messy and damage the parts. For the better seals, allow sufficient cool time for each cycle.

Please find the most suitable conditions as you do test sealing.



## 9-8 Finishing sealing

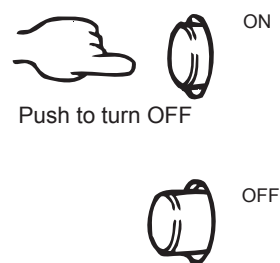
After the heating and cooling cycle has finished, release the foot pedal and the sealing is complete.

If a sealing is not clean enough, adjust the heating time or change the strength to depress the foot pedal.



## 9-9 Power switch OFF

After finishing operation, always turn OFF the power switch.



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

## 9-10 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 instructions.