

## 9 Proper use of the sealer

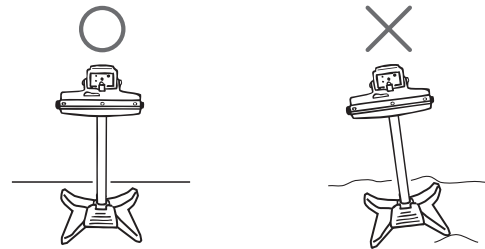
Before using the Fi/FiK series, read “8 How to assemble the sealer” thoroughly and properly assemble the sealer head, support pipe and stand base. Also use the sealer only as described in below “Proper use of the sealer”. There is a risk of danger and malfunctions if the machine is not used in accordance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

**Attention!** For the FiK series, assembling is not necessary as they are shipped after assembled.

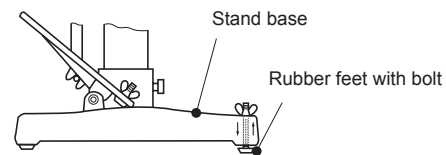
### 9-1 Setting the machine

Place a machine on a flat, horizontal surface.

**Warning** 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

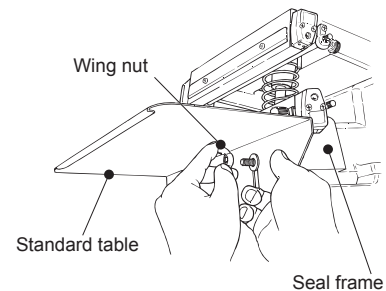
If the table is not necessary, you do not need to perform this process.

#### 1 Standard table

Secure the table with the wing nuts and bolts to the seal frame at the proper work position (height).

**Caution** The load carrying capacity for the standard table is 2kg. If the load exceeding the capacity is applied to the table, it may break the table or seal frame. Do not apply load exceeding 2kg to the standard table.

#### 1 Standard table



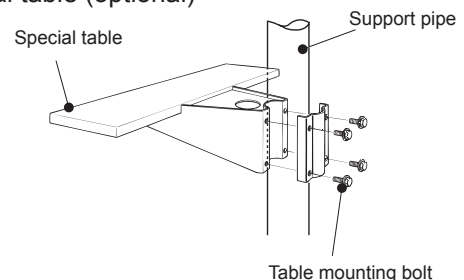
#### 2 Special table (Optional)

(This special table will be standard for Fi-600 series.)

Tighten the table mounting bolts to secure the table at the proper work position (height).


**Caution** The load carrying capacity for the special table is 20kg. The sealer may fall over by losing balance due to the overloading. Do not apply load exceeding 20kg to the special table.

#### 2 Special table (optional)



### 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.

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

### 9-4 Power switch ON

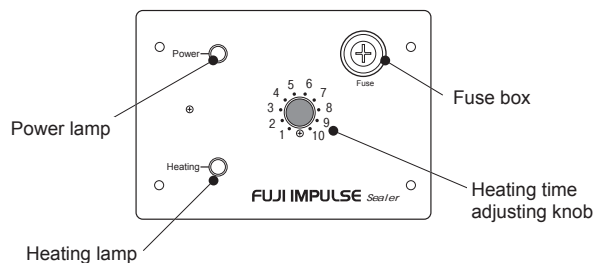
The power lamp for the timer will turn on when the power switch, located on the side of the sealer head (common frame), is pushed on.



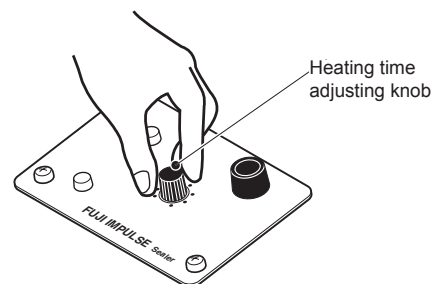
Push to turn ON the power switch


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

Set the heating time with the timer.  
 Lift up the timer cover toward you so you can adjust each setting knob.  
 The setting will differ depending on the type or thickness of your packaging material. Change the setting every time you change the packaging material.



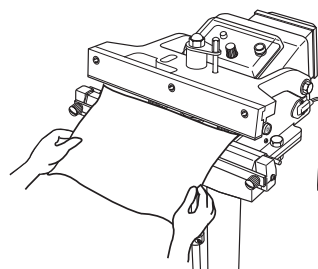
- **Set the heating time**  
 Turn the heating time adjusting knob to set the heating time. [Setting range: 0.1 - 1.6 seconds]  
 The heating time differs depending on the film/pouch.  
 Set the heating time at a minimum required to make a sufficient sealing to increase work productivity and avoid unnecessary power consumption.



 **Warning** There is a danger of fire if the proper cooling cycle is not allowed as explained in “9-7 Depress the foot pedal 3”.

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

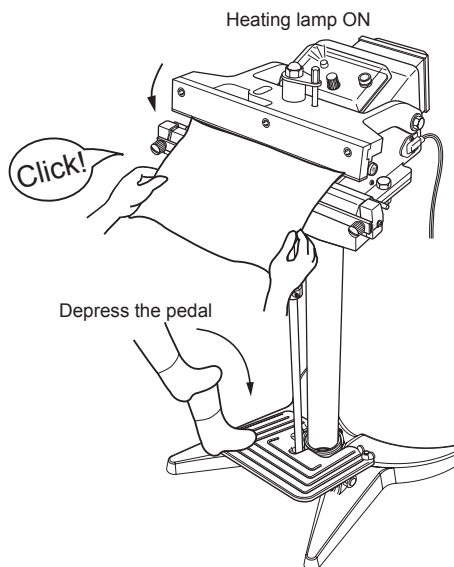
Hold a pouch with both hands and stretch it tight to avoid wrinkles to the sealing surface.



## 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.

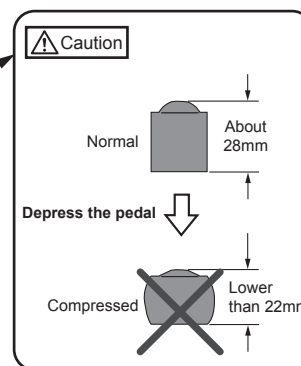


**Warning** Do not depress the pedal more than necessary as there is a danger of damaging parts such as a microswitch. Make sure not to compress the pressure rubber lower than 22mm in height.

- 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.



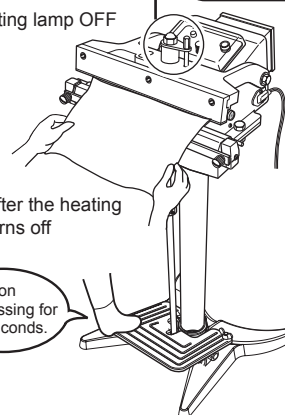
**Caution** If the cooling time is not enough, the seal will become messy and damage the parts. For the better seals, allow sufficient cool time for each cycle.



Heating lamp OFF

Even after the heating lamp turns off

Keep on depressing for 2-3 seconds.

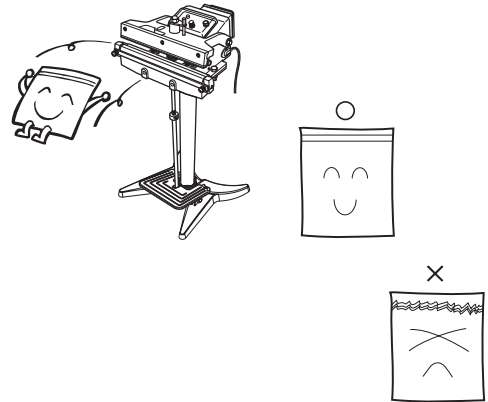


Please find the most suitable condition as you do test sealing.

## 9-8 Finishing sealing

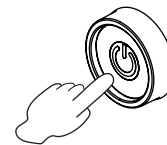
After the heating and cooling cycle has finished, release the foot pedal and the sealing is complete.

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.



Push to 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.