ITECO Heat Sealers

VACUTEK

Vacuum bag sealer
INSTRUCTION MANUAL
Mod. 7914.340 (manual)

Manual rel.1.4 - Dec 2024

ENGLISH

SUMMARY

1. PURPOSE OF THE MANUAL

This Instruction Manual (hereinafter the “manual”) relates to the Vacutek machine (hereinafter the “machine”) and was written by the manufacturer ITECO Trading srl to provide the information necessary to:

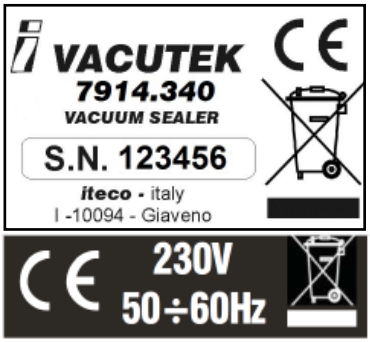
- knowledge of how it works
- its correct use in safe conditions
- carrying out maintenance operations correctly and safely

It must be used to carry out the preventive training of operators
(operators and maintenance technicians) by expert personnel.
It must always be available to operators and maintenance technicians; it must be kept with care and must accompany the Machine in the event of change of ownership; it is necessary to keep the document intact, it must be handled with care and with clean hands and always placed on clean surfaces; parts must not be removed or arbitrarily modified.

The manual relates to the configuration of the machine in the conditions in which it was manufactured; the manufacturer reserves the right to make any modifications and/or improvements that may be necessary on machines of the same model to be built in the future, for any adjustments to technical progress.
The manual refers to the technical documentation of the commercial components present inside the machine

2. DATI DI IDENTIFICAZIONE

CE PLATE
The identification CE plate is applied to the machine



Once identified and CE marked, the machine is to be considered compliant with the safety standards referred to in the Machinery Directive 2006/42/EC of 17 May 2006.

CE CONFORMITY DECLATATION

The machine is supplied with an EC Declaration, which guarantees its conformity with the provisions of the European Directives.

In particular, the machine complies with the following European Directives:

- Machinery Directive;
- “Electromagnetic Compatibility” Directive

Below is a facsimile of the declaration provided:

CE

Dichiarazione CE di Conformità — CE conformity Declaration

Direttiva 2006/42/CEE (Allegato II parte A) — 2006/42/EEC Directive (Annex II part A)

Noi — We

ITECO TRADING SRL

via paisas 1

10094 Giaveno (TO)

Dichiariamo sotto la nostra esclusiva responsabilità che la macchina — Declare under our sole responsibility responsibility That the machine:

VACUTEK

Numero di matricola — Serial Number

123456

Anno di Costruzione — Manufacturing Year

2022

E’ conforme alle seguenti Direttive Europee — Is compliant with the following European Council Directives:

2006/42/EEC

Direttiva Macchine — Machinery Directive

2014/30/CE

Direttiva Compatibilità Elettromagnetica — Electromagnetic Compatibilità Directive

Dichiariamo che il Fascicolo Tecnico di Costruzione è conservato presso — We declare that the Technical Construction File (TCF) is stored at

Iteco Trading srl

Giaveno, 10 Aprile 2022,

Il Legale Rappresentante

IMPORTANT

The CE declaration of conformity and the user and maintenance manual are part integral part of the machine and must be delivered with it in case of sale.

3. DEFINITION

- **OPERATOR:** Is the person in charge of operating, regulating and cleaning the machine.
- **MAINTENANCE WORKER:** Is the person who has followed specialization courses, training, etc. and has experience in installation, commissioning and maintenance, repair, transport, dismantling of the machine.
- **EXPOSED PERSON:** Any person who is wholly or partially in a dangerous area.
- **MANUFACTURER:** The company that made the machine and this instruction manual.
- **IMPORTER:** The company that imported the product from outside the EU and marked it with the CE mark.
- **DANGER:** A potential source of injury or damage to health.
- **DANGEROUS AREA:** Any area inside and/or near the machine where the presence of a person poses a risk to the safety and health of that person.
- **RISK:** Combination of the probability and severity of injury or damage to health that can arise in a dangerous situation.
- **RESIDUAL RISK:** Risk that persists, despite having adopted the protection measures integrated in the design of the machine and despite the protections and complementary protective measures adopted.
- **SAFETY DEVICE:** Device that reduces risk.
- **INTENDED USE:** Use of the machine in accordance with the instructions in the manual.
- **NOT PERMITTED USE:** Using the machine in a way other than that indicated in the manual.
- **REASONABLY FORESEEABLE MISUSE:** Use of the machine in a manner different from that indicated in the manual, but which may result from reasonably foreseeable human behaviour.

4. RECIPIENTS OF THE MANUAL

4.1. OPERATOR

The operator's tasks are:

- Start and stop the machine using the switch on the back of the machine.
- Setting of the working parameters through the command and control panel.
- Vacuum sealing of the bags containing the material to be packed.
- Check for regular operation. (The operator, before carrying out the activity independently, must be trained by expert personnel).

4.2. MAINTENANCE WORKER

The tasks assigned to the maintanance worker are:

- Installation and dismantling.
- Ordinary and extra-ordinary maintenance.
- Recovery interventions, adjustment of operating parameters.
- Cleaning operations, calibration, replacement of wearable parts.

The maintanance worker, before carrying out the activity independently, must be trained by expert personnel.

5. MACHINE DESCRIPTION

The machine, both in the manual version and in the motorized version, is a device mainly designed for the vacuum packaging of products intended for the electronics industry with particular attention to ESD components, sensitive to electrostatic discharges.

6. TECHNICAL DATA

Manual model:	Product code7914.340
Maximum weld length:	450mm
Welding elements:	2 resistors 6mm wide
Vacuum pump:	Dry type, suction 5 m3/h.
Welding time:	Adjustment from 0 to 8 sec (0.1 sec resolution)
Suction time:	Setting from 0 to 99 sec (1 sec resolution)
Display:	7-segment LED (6 digits)
External dimensions:	514.5 x 392 x 190(H) mm
Weight:	21 Kgs
Maximum power:	600W
Power supply:	220V/50Hz
Handling:	2 side handles

7. INTENDED USE

- The machine is intended for vacuum sealing bags containing materials to be vacuum packed.
- The machine is mainly intended for industries and research laboratories operating in the electronic and related sectors.
- The Vacutek vacuum sealer, has been designed and optimized for vacuum sealing materials sensitive to humidity and electrostatic discharges (ESD), but can be used in other sectors. For this purpose, consult the seller/distributor/manufacturer if necessary.
- The machine is designed to be used by one or more operators, provided they are duly trained.
- The training involves coaching by an expert in charge capable of illustrating the operating procedures, the residual risks present, the prevention and protection measures to be adopted: at the end of the coaching period, the operator will be able to work independently.
- This manual is the essential support for the training activity.

8. NOT PERMITTED USE

- Carrying out any activity other than that indicated as intended use.
- Carrying out of activity by an untrained operator.
- Intervention on electrical and mechanical parts without authorization and without having disconnected the energy sources.
- Failure to comply with the indications relating to the management of residual risks.
- I work with the safety guards excluded or removed and/or with the machine not in safe conditions.

9. REASONABLY FORESEEABLE MISUSE

- Use the machine when it is not in perfect condition.
- Insert even momentarily your hands between the bars once the cycle has started.
- Touch the sealing bars after a work cycle without waiting for cooling.
- Use envelopes not suitable for heat sealing for packaging.

10. MACHINE SAFETY

GENERAL CONDUCT REQUIREMENTS

- To connect to the power supply, insert the power cord first into the device and then into the socket.
- The equipment must be connected to a system having an earth connection.
- It is forbidden to operate the machine with the safety devices removed.
- It is forbidden to inhibit the safety devices installed on the machine.
- It is forbidden to modify parts of the machine.
- The adjustment, restore and cleaning operations must be carried out in compliance with the instructions provided in this manual.
- Maintenance operations must be carried out with the machine disconnected from the power supply, respecting the instructions provided in this Manual.
- Work on the electrical equipment of the machine can only be carried out by trained and trained personnel (expert person, Standard CEI 11-27).
- It is forbidden to touch the sealing bars.

USE OF PPE

The maintenance worker has to know the power supply fonts of the machine and be able to intervene on them in order to de-energize the machine before any intervention.
The maintenance and adjustment zone that where it's need opered, if dangerous marked, may be reached only after placing the machine at zero energy.
At the end of the maintenance, all devices, repairs, etc. must be relocated.
It will be the responsibility of a person trained in safety to carry out a correct analysis of the risks to which the employee may be subject in the workplace and to provide any additional PPE.

DANGEROUS ZONES

N°	ZONE	RISCK	RISCK DESCRIPTION
1	Electric socket, board, and transformers inside the machine		Presence of dangerous voltage during maintenance activities

SAFETY DEVICES/COVERS

N°	DEVICES/COVERS	PURPOSE
1	Covers of the machine	Prevent contact with moving parts and dangerous electrical parts
2	Cycle start microswitch	Start the vacuum cycle (air suction, heating of the resistances) only after closing the upper bar on the lower one
3	Machine grounding	Prevent indirect human contact with live parts

RESIDUAL RISKS

N°	ORIGINE DEL RISCHIO RESIDUO	EXPOSED PERSON IN CHARGE	PREVENTION AND PROTECTION MEASURES TO BE ADOPTED
1	 Contact with live parts maintenance of live parts	Maintenance worker	Presence of main switch Presence of safety devices to prevent indirect contact, grounding Prohibition of intervention for unauthorized personnel Risk signage

PICTOGRAMS

Visible inside the machine near the parts powered by mains voltage

On the command and control panel during maintenance activities

11. SOUND LEVEL

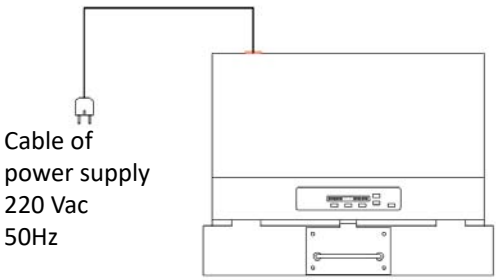
The weighted acoustic pressure level of the emission is substantially represented by the emission levels of the individual devices that make it up, i.e. the vacuum pump (which is within the permitted limits).
It will be the responsibility of the user to carry out a correct analysis of the risks to which the employee may be subject in the workplace and to provide any PPE. additional.

WARNING
Excessive noise can be caused by a fault, excessive wear or poor maintenance and must be immediately reported and eliminated in order not to jeopardize the safety of the systems and the personnel in charge.

12. INSTALLATION

After removing the packaging, check the integrity of the vacuum sealer. In particular, check that the machine is intact and without visible damage that could have been caused by transport. If in doubt, do not use the product and contact the supplier.
The Vacutek is equipped with a removable misalignment spring, with magnetic anchor (Ref. pag.13, fig1), useful for creating micro suction channels when using smooth bags.
The motorized version is equipped with a starting cycle pedal, to be connected by means of a cable to the appropriate socket on the back of the machine.
Position the machine in a place with a low percentage of humidity and away from heat sources. No preliminary adjustment is required, it can be connected to the power supplay immediately.
Connect the machine to the on-site power supply, verifying that the voltage and power parameters are correct.
An adequate area must be prepared for installation, the machine must be placed on a smooth, regular and solid surface capable of withstanding its weight and the vibrations produced.

ELECTRICAL CONNECTIONS
The connections to the electrical system that powers the machine must be made in compliance with the Laws and/or Technical Standards regarding safety in the workplace and current electrical systems. The electrical system to which the machine belongs must include an earthing system in accordance with the provisions of the user's country.
• The vacuum sealer Vacutek requires 220 VAC/50Hz for proper operation.
• The machine must be grounded for safe operation.



• Connect the machine to a standard European 3-prong grounded outlet. Verify that the voltage is correct. If an extension cord is needed, use only a 3-wire cord that provides grounding.
• For the motorized version connect the control pedal.

PRELIMINARY CHECKS AND CHECKS
Before commissioning the Machine, it is necessary to carry out a series of checks and controls in order to prevent errors or accidents during the commissioning phase, namely:
• that the machine has not been damaged during the assembly phase,
• the integrity of the electrical parts,
• the correct connection of the power supply,
• the exact connection of the cycle start/stop control pedal (only for the motorized version),
• free movement/free rotation of all moving parts.

MACHINE POWER SUPPLY
The Machine is powered by:
• main switch on the back of the machine .

TEMPORARY DECOMMISSIONING
During long periods of inactivity, it is necessary:
• disconnect the power supply,
• protect parts subject to wear.

DISMANTLING / DECOMMISSIONING DEFINITELY
In the event of definitive decommissioning, the machine must be completely deactivated and handed over to a company authorized for disposal according to the national regulations in force.

IMPORTANT
In the event of definitive decommissioning of the machine, it is advisable to recall the need to destroy the identification plate of the machine and any other document relating to it.

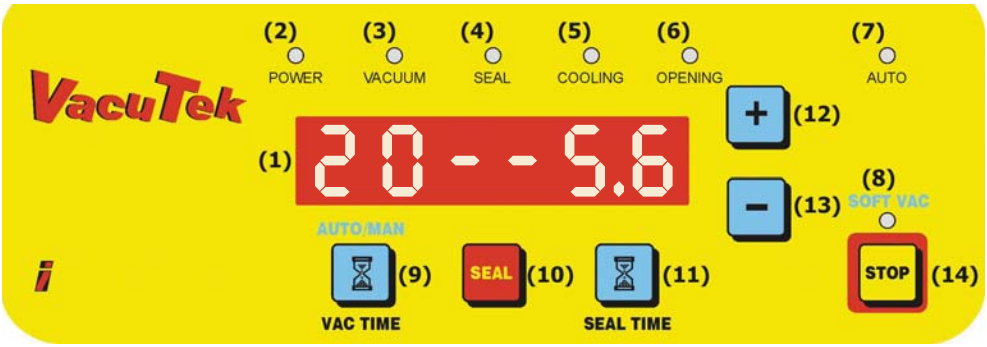
13 PROTECTING THE ENVIRONMENT

Separate collection. This product must not be disposed of with normal household waste. Should you find one day that your product needs replacement,or if it is of no further use to you,do not dispose of it with household waste. Make this product available for separate collection.
Separate collection of used products and packaging allows materials to be recycled and used again.

Re-use of recycled materials helps prevent environmental pollution and reduces the demand for raw materials.
Local regulations may provide for separate collection of electrical products from the household,at municipal waste sites or by the retailer when you purchase a new product.

CONTROL PANEL

(1) 6-DIGIT DISPLAY The machine has a large 6-digit display. The first 2 digits indicate the vacuum time the last two digits indicate the welding time
(2) "POWER" LED, indicates that the machine is powered.
(3) "VACCUM" LED, indicates that the pump is making vacuum.
(4) "SEAL" LED,indicates that the heat sealer is welding.
(5) "COOLING" LED, indicates a cooling time between the stop of the weld and the opening of the bars
(6) "OPENING" LED, indicates the open of electrovalve to let air into the vacuum chamber and allowing the opening of the welding bars.
(7) "AUTO" LED, Led on shows set **automatic cycle** mode is active, led off indicates **manual cycle** mode is active.
(8) "SOFT VAC" LED, indicates a special operating mode to get vacuum more slowly, to check and avoid excessive compression of the bag contents.



(9) "VAC-TIME" button, is a multifunction button that allows to switch between automatic cycle mode and manual cycle mode, and select the aspiration time.

MANUAL CYCLE		"AUTO" LED (7) is off and first 2 digit on the display shows 2 dashes.
AUTOMATIC CYCLE		"AUTO" LED (7) is on and the first 2 digits of the display show the last aspiration time set.

Pressing the **"Vac-Time"** key for about 2 seconds enters the "pump aspiration time" setting (The first two digits start flashing with the last value set).
Using **"+"** or **"-"** bottons a new aspiration time can be set, pressing the **"VAC-TIME"** button again stores the new value.

(10) "SEAL" button, when the cycle is started it allows you to stop aspiration and weld when you reach the desired vacuum level.
(11) "SEAL TIME" button, the sealing time will appear on the display. By pressing and holding this button for 2 sec. enter the « sealing time » and by using the +/- buttons set the time required which will appear on the display..
(12) "+" button, using this key it is possible to increase the vacuum time and the sealing time set.**(13) "-" button,** using this key it is possible to decrease the vacuum time and the sealing time set.**(14) "STOP" button** is a multifunction button.
a) During the aspiration phase it is used to immediately interrupt the cycle.
b) Pressed for about 5 seconds before starting the welding cycle, it allows you to set the SOFT-VAC mode or return to the normal mode, the word STOP will appear on the display until the mode changes. The SOFT-VAC (light vacuum) mode is useful when you want to better control the vacuum when packaging fragile objects.

DISALIGNMENT SPRING

The disalignment spring is a mechanical device specially designed to facilitate the use of the vacuum sealers with smooth barrier bags (i.e. not embossed).
The spring must be inserted in the upper side of the sealing bar as shown in figure 1, the magnetic anchor allows you to easily remove the spring when you need to replace it or weld embossed bags..
Note: if you need to seal smooth bags without the help of the spring, you have to stagger the two flaps of the bag (figure 2) to create the aspiration channels.

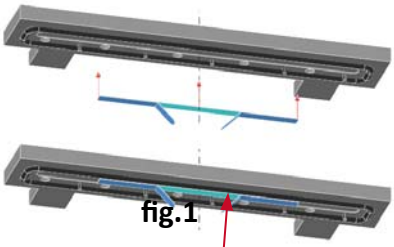


fig.1

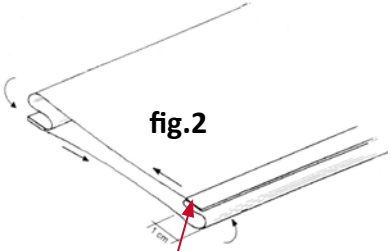


fig.2


fig.4

15. SETTING

PRELIMINARY OPERATIONS1

1) Connect the plug to the apposite current outlet 230V.

2) Press the line switch in the rear panel; at the same time the display lights up.

3) Set the optimal sealing time based on the characteristics of the bag used.

Note:
The following table shows in a very indicative way some value of the welding time by type of bags.

Material	Symbol	Min/Max Time (sec)
Embossed polyethylene envelopes	PE	1,8 - 2,4 sec.
3-state polypropylene dissipative envelopes	PP - LD	2,8 - 3,4 sec.
80 micron multilayer Shielding envelopes	PE - PET	3,5 - 4,5 sec.
150 micron multilayer Shielding envelopes	PE - PET	4,0 - 6,0 sec.
80 micron multilayer barrier bags	EMI SHIELD WATER PROOF	4,5 - 5,8 sec.
150 micron multilayer barrier bags	EMI SHIELD WATER PROOF	5,0 - 7,0 sec.

6) Set the desired type of cycle:
a) manual with interruption of suction by means of a button
b) automatic with interruption of suction after a pre-set time

MANUAL CYCLE

Vacuum time: MANUAL
Soldering time: PRESET

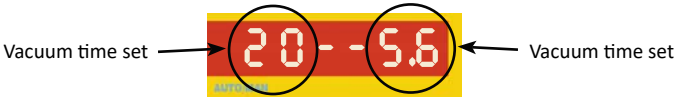
1) In this this case “AUTO” LED is off, and the first two digit on the left side does of display not show value but only two dashed.

2) Check that the sealing time has been set properly, if not press SEAL-TIME for 2 sec to enter setting mode. When digit blinking enter the correct sealing time by using the +/- buttons. To exit from setting mode and save set value press “SEAL TIME” botton again.

3) Insert the bag in which to make the vacuum between the 2 sealing bars. Always use the disalignment spring (fig. 1 page 5), but if it is not possible to use the spring, alternatively making sure that the two lateral bag borders are out of alignment (fig. 2 page 5) in order to obtain the microchannels for air suction. Remember all this is not necessary when using the apposite “EMBOSSED” type bags, which can be introduced perfectly flat and without use spring.

4) Lower the bar by pressing until it remains closed due to depression, thus allowing the beginning of the suction of the air from the bag.
5) When the bag is perfectly adherent to the piece or is reached desiderate vacuum, press the "SEAL" button to start the sealing phase and the subsequent cooling phase.
6) The mobile upper bar opens automatically at the end of the sealing/cooling cycle. The pair of springs placed between the two sealing bars push the mobile bar upwards at the end of the cycle.

AUTOMATIC CYCLE
Vacuum time: PRESET
Soldering time: PRESET)
1) If is preset "MANUAL" mode, set "AUTO" mode by pressing "VAC/TIME" button.
2) Check that the sealing time has been set properly, if not press SEAL-TIME for 2 sec to enter setting mode. When digit blinking enter the correct sealing time by using the +/- buttons. To exit from setting mode and save set value press "SEAL TIME" botton again.
3) Check that the sealing time has been set properly, if not press SEAL-TIME for 2 sec to enter setting mode. When digit blinking enter the correct sealing time by using the +/- buttons. To exit from setting mode and save set value press "SEAL TIME" botton again.



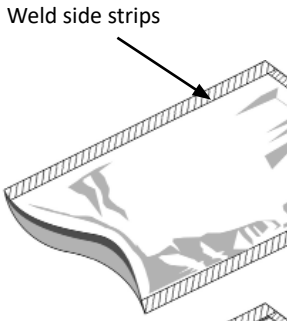
4) Insert the bag in which to make the vacuum between the 2 sealing bars. Always use the disalignment spring (fig. 1 page 5), but if it is not possible to use the spring, alternatively making sure that the two lateral bag borders are out of alignment (fig. 2 page 5) in order to obtain the air suction channels. Remember all this is not necessary when using the apposite "EMBOSSED" type bags, which can be introduced perfectly flat and without use spring.
5) lower the upper bar making an adequate force until it remains closed due to the vacuum created by the pump which is automatically activated.
6) The cycle continues with the values set for the vacuum and for the sealing time.
At the end cycle the opening of the upper bar is automatic: the pair of springs placed between the two sealing bars push the mobile bar upwards at the end of the cycle.

BAGS FOR VACUUM SEALING

NORMAL BAGS ARE NOT SUITABLE FOR VACUUM PACKAGING

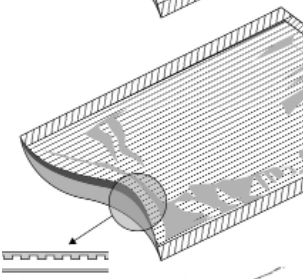
Normal polyethylene bags are not suitable for vacuum packaging, even if for some time seem to keep vacuum, passing the time the air start to come into the bag because the film is porous.Special multilayer bags have to be used. They are made in different materials and normally indicated as "BARRIER BAGS".

The "Barrier Bags", because are made from multilayer film and not from plastic extrusion, always have two lateral soldered stripes. (fig.1).



"EMBOSSED" TYPE BAGS FOR EXTERNAL ASPIRATION

In external aspiration appliances "embossed" type bags are the best solution for an easy operation. They are made with small straight rails parallel to the lateral sides that facilitate the output of the air during the aspiration job. These bags are not antistatic and mostly used in food packaging. (fig.2).

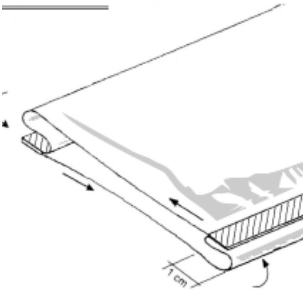


FLAT BARRIER BAGS

They are normally used with vacuum tank sealers (internal aspiration). Flat barrier bags for electronic appliances are ESD-dissipative and show good EMI/RFI shielding properties.

For their use with external aspiration, always check that the disalignment spring supplied is present, then insert the bag and start the cycle. If it is not possible to use the disalignment spring, before inserting the bag, stagger the sides as shown in fig 3, in order to create two small suction channels.

N.B. Suggested bag thickness: 2 x 80μm, max 2 x 120μm



PACKING OF ELECTRONIC COMPONENTS

BAG DIMENSION

it is suggested the use of the smaller bag according to the dimension of the product to be packed, in this way a better time will be achieved in air extraction, and above all the quantity of desiccant product will be drastically reduced.(desiccant is used to keep the relative humidity under 10%RH @ 25°C)

MBB

Moisture Barrier Bag

DESICCANT
Desiccant is a drying agent that absorbs moisture vapour (humidity) from the air left inside the barrier bag. Any moisture that penetrates the bag will also be absorbed. Desiccant is sold by “Unit” or in grams, one unit weighs about 30grams.
There are several standards for calculating the desiccant loading for bags.

HIC
Humidity Indicator Card will change color from blue to pink (or blue to brown), when the indicated relative humidity is exceeded. It is packed inside the bag, along with the dessicant, to determine the level of moisture to which the MSD shave been subjected.

IPC/JEDEC J-STD-033 is the reference standard about Handling, Packing, Shipping and Use of Moisture/Reflow Sensitive Surface Mount Devices.

MSD
(Moisture Sensitive Devices) Many electronic devices are made from plastic that absorbs moisture from the air. When the case is heated during soldering, the moisture inside turns to steam and may break the device as the steam escapes. Keeping the devices dry before soldering means that them will not be damaged.

MSL
(Moisture Sensitivity Levels) The standard JEDEC J-STD-020 has defined eight categories of moisture sensitive levels: 1 - 2 - 2a - 3 - 4 - 5 - 5a - 6 (6 is themost sensitive), which relate to the maximum allowable

FLOOR LIFE
Floor life is the time allowed between opening any dry pack and subsequent soldering operations and is defined for packages according to the standard JEDEC J-STD-033. Recommended floor life for dry packed products is usually indicated on the dry pack. Note that the safe floor life will be affected by the ambient environmental conditions.

BAKING
A bake is recommended if storage conditions exceed either 30°C/60% or the quoted floor life. The time and temperature of the bake depend on the package thickness.
The floor life clock is reset to zero following the rebake. However if the ambient conditions still do not meet those defined the product should be used immediately following the bake.

N.B. Product may be stored indefinitely once the dry pack is opened provided that the ambient humidity does not exceed 5% RH.
Humidity controlled dry-air or dry-nitrogen cabinets are recommended for this purpose.

18. MAINTENANCE

GENERAL REQUIREMENTS

Before carrying out ordinary and extraordinary maintenance, which require interaction with the machine, it is necessary to stop and completely isolate the machine; therefore it is necessary:

- disconnect the machine from the power supply.
- Report the activity using the “machine under maintenance” sign placed on the command and control panel

Maintenance must be carried out by qualified and authorized operators using the prescribed PPE (see the Table in point 11.4).

Maintenance interventions must not modify the technical and safety characteristics of the machine. Clean the machine paying particular attention to the sealing bars. Check the efficiency of the safety devices.

CLEANING

If necessary, the machine requires cleaning through the use of standard cleaning tools/ products.

ORDINARY MAINTENANCE

The VACUTEC vacuum sealer has been designed to require low maintenance, however some attention is required:

- periodically clean the Teflon placed on the heating resistors to eliminate any slag adhered to due to the heat developed
- remove liquids or particles from the vacuum chamber which could be sucked in by the vacuum pump. A filter is however inserted in the fluidic circuit to protect the pump. Ordinary maintenance is aimed at guaranteeing the required operational performance and the necessary safety levels over time; the required activities are indicated in the Scheduled Maintenance Table below.

If non-conformities or malfunctions are found following the activities, the activity must be suspended and the problem resolved.

SCHEDULED MAINTENANCE TABLE:

ACTIVITIES	PERIOD	MACHINE STATUS	INCARICATO
Teflon cleaning: lift the bar and pass a damp rag on the lower and upper Teflon	Once a month	Machine off	Operatore
Cleanliness check in the vacuum chamber: lift the mobile bar and check that there are no residues especially within the area delimited by the gasket. Remove any traces of liquid or particulate matter.	Before and after using the machine	Machine off	Operatore
Visual and functional check of the safety devices: - Integrity of moving parts - Integrity of cables - Integrity of the covers	Every 12 months	Powered machine	Manutentore
Checking the earthing of the metal parts of the machine	Every 12 months	Machine off	Manutentore
Checks required by law: Check the earthing system in the work area	According to the indications of the law		Tecnico autorizzato
Visual check for the absence of anomalies: - Damage to structures, cables, controls. - Absence or damage of the protective devices	At each resumption of production activity	Powered machine	Operatore

TROUBLESHOOTING

This information provides a point of reference for quick troubleshooting.
If any of these possible solutions do not solve the problem, contact the manufacturer.

IT CAUSES	DEFECT	SOLUTION
The heat sealer does not turn on	Defective power cord	Replace the power cord
	Broken fuses	Replace fuses
The mobile bar lowers but does not adhere to the fixed bar due to the vacuum effect	The bag has passed the delimiters or has covered the vacuum hole	Reseat the bag
	The gaskets are damaged	Replace the gaskets
	The suction hole is clogged	Disconnect the suction pipe under the machine and blow compressed air towards the bar
No vacuum is created in the smooth bag (e.g. ESD)	The micro suction channels in the bag have not been created	See page 16
The bag does not keep the vacuum	The bag was damaged by the contents	If possible, reduce the suction time or protect the edges of the contents
	The sealing time set is insufficient in relation to the thickness and type of bag	Increase the sealing time to improve the adherence between the edges of the bag
	The sealing time set is excessive in relation to the thickness and type of bag	Decrease the sealing time to avoid micro cracks along the edges of the bag near the sealing
The resistive element does not heat	The resistance is broken	Call technical assistance
	The control relay does not make contact	Call technical assistance

EXTRAORDINARY MAINTENANCE

Extraordinary maintenance concerns the repair and replacement of relevant components of the Machine.
Maintenance must be carried out in compliance with the indications in point 14.3.
Extraordinary maintenance must be carried out:

- Considering the technical documentation of the components
- Using suitable and original spare parts
- Knowing the characteristics of the parts to be replaced (dimensions, weight, fixing and handling methods)
- Any extraordinary maintenance must be carried out by personnel trained and authorized by the manufacturer.
- Verifying the effectiveness of the intervention carried out

19. REPAIR

Repairs have not been attempted by anyone other than authorized repair distributors.
Do not try to repair the unit by yourself.
ATTENTION: Dangerous voltage is present inside the unit.

20. ANNEXS

EC Declaration of Conformity

21. WARRANTY

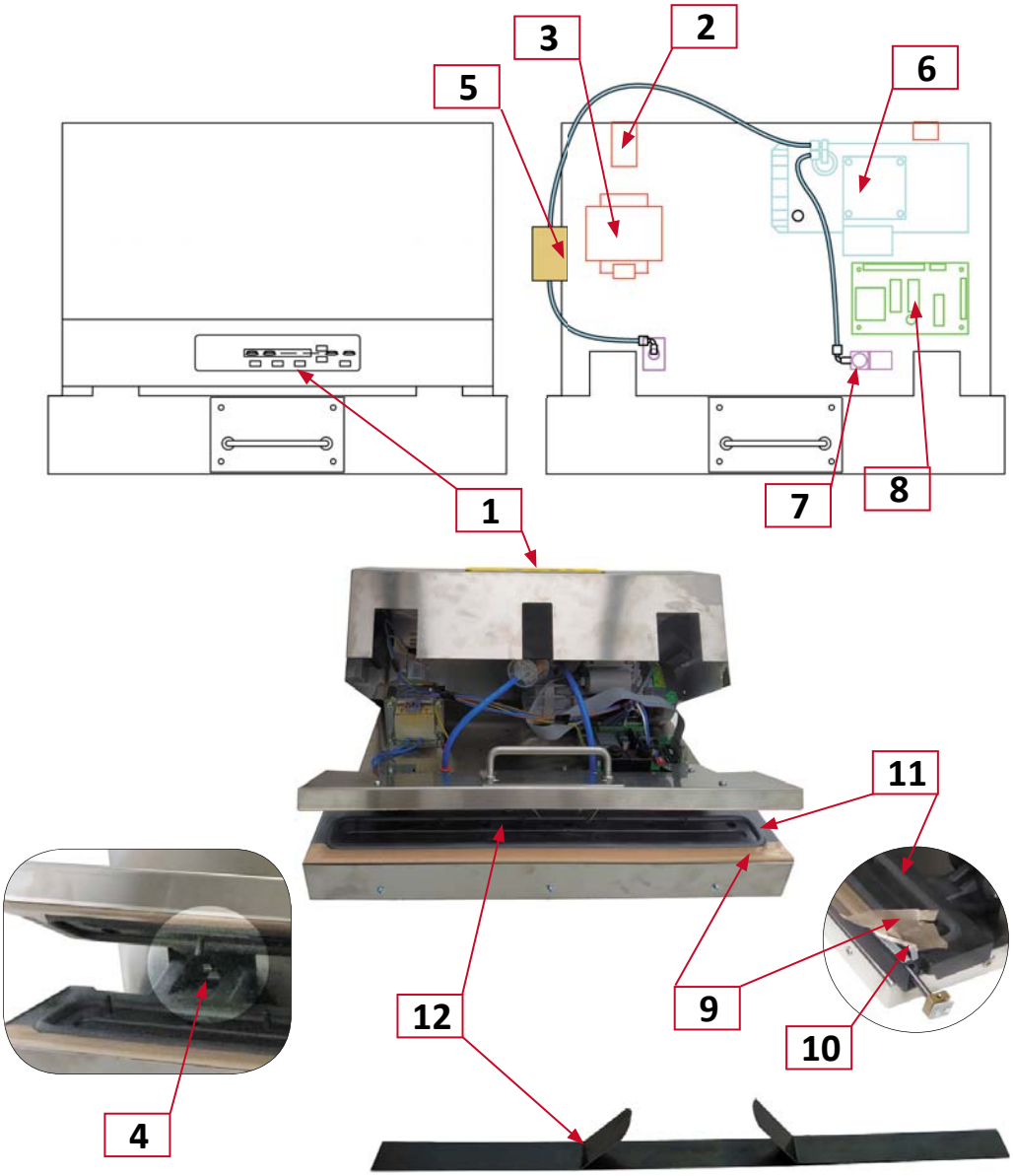
The manufacturer guarantees that the products are free from defects in construction, workmanship or materials for a period of one year from the date of purchase.
This warranty does not apply to physical and/or electrical damage caused by misuse, abuse or negligence (such as modifications made to the unit or repair service done by technicians not authorized by the manufacturer or in case of errate power supply.
Any alteration or removal of the serial number will automatically void the warranty on the unit purchased.
The manufacturer will not be liable for any loss or damage deriving, directly or indirectly, from a use for which the product was not designed or intended. In no event will the importer be liable for direct or indirect damages, unless the laws of the state in question provide otherwise. The guarantee is valid for the original purchaser and is not transferable.
No person, agent, distributor, reseller is authorized to modify or change the terms of this warranty in any way.
The information contained in this document is subject to change without notice and does not represent a commitment on the part of the importer.
No part of this manual may be reproduced or transmitted in any form or by any means, electronic or mechanical, including photocopying and recording, for purposes other than the personal use of the purchaser, without written authorization from the manufacturer.

22. ASSISTANCE AND SPARE PARTS

For any type of information relating to the use, maintenance, installation of the Machine and the need for spare parts, refer to the Manufacturer.

SPARE PARTS

9914362 - Display panel with card **[1]**
5720400 - Fuse 5 x 20 10A **[2]**
5357360 - Transformer 230/18V 625VA **[3]**
5952105 - Microswitch Honeywell **[4]**
6910231 - Leaking cartridge 3/8" **[5]**
6581600 - Dry vacuum pump **[6]**
6910130 - Complete pneumatic valve **[7]**
9914340 - CPU card **[8]**
TEF040A - Adhesive teflon band 40mm **[9]**
RES-6 - Heating strap resistance 0,2X6mm **[10]**
VAC-GASK1 - Rubber gasket ϕ10mm **[11]**
6590301 - Disalignment spring **[12]**



[12] NOTE
The disalignment spring is removable, have to insert in the specially seat in the center of the upper bar when using smooth envelopes. Do not use it with embossed bags.