

## L-Bar Sealer Troubleshooting Guide

Models: All with 5570-Tru-Temp Control Board

**CASE:** Power is on but does not seal.

Possible cause: no power supply to the PCB. Check voltage on terminal 2 & 3 (120VAC)

No cycle-start pulse. Check pulse-switch, wires and plug.

Check on board indicator lights (Red LED). Do they come on when pulsing the sealer?

If not, pull the pulse-switch connector and short-out the two pins (31 & 32) with a screwdriver. MAG & SEAL LED's should come on. If they do, pulse switch is bad.

Dwell-Time and/or Seal-Temp. control-pots bad or no connection. Check pots resistance: Dwell= 90-100 kOhms, Seal-Temp= 9-10 kOhms. Otherwise board needs repair.

**CASE:** L-Bar clamps-down but not sealing.

Possible cause: on board seal-fuse (15A AGC) bad. Replace with same or 5- 7A MDL Secondary seal fuses bad.(on front or side of the machine) 15A MDL (slow blow only) Pulse transformer bad (rare). Control board needs to be repaired.

**CASE:** Poor sealing. Wires do not cut trough film or sticking.

Possible cause: Seal-Temp. too low, dwell time too short, not enough clamp force or all of the above combined.

Start with checking the clamp force. Clamp down on a letter-size piece of paper. While the magnets pull the l-bar, try to pullout the paper. You should not be able to pull out the paper easy. Otherwise adjust the clampdown force. Read "Adjusting L-Bar Sealers" document for instructions. Make sure you have the seal-wires installed correctly, the seal-bed pad and tape are not worn. Seal-Bed pad and tape must be replaced periodically. See your manual for info.

**CASE:** Poor Sealing. Film sticking in corner.

Possible cause: seal-wires installed incorrectly. Read "Sealer Set-Up"  
Also see above "Poor Sealing".

**CASE:** Seal-Wires break often.

Possible cause:

- 1) seal-temp set to high due to wrong film
- 2) l-bar out of adjustment
- 3) seal wires loose, installed incorrectly or incompatible

See above. Read "Sealer Set-Up" document for instructions.

# SEAL•A•TRON

## Shrink Packaging Equipment

### CASE: Magnets do not engage

Possible cause: on board fuse (5A AGC) bad due to shorted or burned-out magnets. Check magnet resistance (terminals 11 & 12), about 80 Ohms (300 Ohms for 240V machine). Check continuity to ground. One terminal, 11 or 12 to chassis. No continuity to ground should be present. Replace Magnet if open or shorted. Otherwise send PCB for repair if test is OK.

### CASE: Magnets do not release or stick

Possible cause: L-bar return spring broken, out of adjustment or worn. Return spring is attached to the rear part of the I-bar. See also "Sealer Set-Up" guide.

Clamp down magnet-plate out-off adjustment and/or seal-bed pad is worn.

Read "Sealer Set-Up" document for instructions.

Magnet won't release even by force.

Turn off power switch. If the magnet releases, the magnet-control circuit is broken. Send PCB for repair.

### CASE: Sealer Conveyor does not run.

Possible cause: worn motor (brushes), shorted-out motor due to carbon dust, blown fuse. Use 1 to 2A max. fast blow fuse only. In addition to above, bad speed-control module if over-fused.

Run-Time control pot (front panel) bad or no connection.

Check pot resistance = 200 – 250 kOhms.

Bad main control PCB. Send main control PCB and/or Speed Control PCB for repair.