SEAL•A•TRON
Shrink Packaging Equipment

L-Bar Sealer Set-Up Guide

Machine Maintenance
To keep your machine in good working order, inspect all parts of the machine periodically.
Check for missing or loose parts and bolts. Clean and re-tighten seal wires. Check worn seal bed pad and burnt seal bed tape. Inspect conveyor motor brushes. After 2-3 years of operation, clean conveyor motor inside off carbon dust. Excessive carbon dust will result in motor failure and/or motor speed control failure. If the conveyor fuse blows, there is a reason for it. Inspect the conveyor before replacing the fuse. Never increase the value of the fuse.

Adjusting the L-Bar

First make sure your seal-bed pad and seal-bed tape is in good working order.
With power off, press down the L-Bar onto the seal-bed. Check if the L-Bar is pressing down on the seal-bed evenly and square on both sides. If not, loosen all bolts fastening the L-Bar to the top frame. Loosen also both bearings holding the L-Bar. Now press the L-Bar evenly down and keep level. Let a helper tighten all the bolts.

Adjusting Seal Pressure;

Loosen the big counter nut on the (round) magnet plate bolt. Turn the plate in (clock-wise) one turn at a time and press down the L-Bar (power on). Repeat this until you hear the magnet plate humming. Now back off the plate (turn CCW) until the humming stops. Tighten the counter-nut. The L-Bar is properly adjusted.

Adjusting Cycle-Start Switch

With power on, lower the L-Bar slowly until the magnet engages. Repeat that until you can estimate the height between the seal wires and seal bed at the instance the magnet engages. The distance should be about ¾” but not less than ½”. If the distance is to short, the l-bar will bounce while sealing, resulting in poor seals. Adjust the switch accordingly.

Adjusting L-Bar Rise Speed

After the seal-cycle ends the l-bar should return to high position. If it does not return or stops halfway, the spring is out of adjustment, broken or worn. Return spring is attached to the rear part of the l-bar.
If the l-bar bounces upon returning to the high position, turn the return-cylinder CW to slow down the rise speed. Turn CCW to increase l-bar rise speed.

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Installing Seal Wires

Remove broken wires. See Owners Manual for instructions.
Install the new front wire first. With the Take-Up Assembly pushed in, feed the wire through the hole, pull and fasten it with the bolt.
Next, attach the cross wire to the Take-Up Assembly. Push in the Take-Up Assembly and Arrest in place with the pin. Slide the supplied brass tube over the seal-wire free end.
IMPORTANT: Make sure the brass tube end is about ¼" away from the intersecting front wire. Bend the tube and wire over the front L-Bar and secure it with the clamp. The seal wire must rest as close to the ceramic beads as possible. Use a small hammer to bend the brass tube 90 degrees over the front L-Bar edge. Release Take-Up Assemblies.
NOTE: failing to install the tube will result in poor seals and broken wires. Replace seal-wires only with genuine Seal-A-Tron wires. Other brand seal-wires may cause machine failure, poor seals, and warranty cancellation.

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