

SEAL•A•TRON

Shrink Packaging Equipment

Shrink Tunnel Troubleshooting Guide

VARILOCETY WITH DIGITAL DISPL. & TOUCHPAD

Models: T-2008, 2011, 2408, 2413, 2414, 2416, 2418, 3008, 3014, 3610, 3616
(also INTERTAPE Tunnels)

WARNING: Never work on any tunnel parts with POWER ON. Machine may start running at any moment and serious injury or death may occur.

CASE: Machine works intermittently, cuts-out after heaters turn on. Display is flashing on off.

Possible cause:

- 1) supply voltage too low. Must be at least 195VAC under load.
- 2) Power cord is too long or wrong gauge.
- 3) Dust and dirt inside the control compartment. Blow off dust and clean all PCB contacts.

CASE: Machine is working but no heat.

Possible cause: machine previously overheated and overheating protection was triggered.

Diagnostic Parameter must be re-set to default value. Check your programming manual for instructions. Check possible Solid State Relay failure.

CASE: Display shows temperature instead of >COOL< when cold. In run position, it doesn't heat.

Possible cause: EPROM battery low or dead. Replace battery.

Machine Parameters must be re-set to factory settings. Check your programming manual for instructions. Request manual from Seal-A-Tron if missing.

CASE: Tunnel conveyor not running.

Possible cause: conveyor motor failure. Check motor brushes, clean-out carbon dust, check for shorts.

DO NOT increase the fuse value. That will damage the speed-control module. If the fuse was blown, unplug the motor and replace the fuse with a 2A AGC fuse (fast blow). If the fuse blows again (motor unplugged), motor and speed control module are bad.

CASE: Tunnel Conveyor runs at high speed, no control

Possible cause: Speed Control Plug-In board failure due to bad motor and over-fusing.

CASE: Tunnel overheating.

One or more heater lights are constantly on, do not flash when temperature is reached.

Possible cause: one or more Solid State Relays are shot.

CASE: Tunnel temperature seems to be higher than the display reading

Possible cause:

- 1) Temp. Sensor (thermocouple) fouled. Thermocouple tip may be covered with molten plastic or other debris. Make sure the sensor tip protrudes about ¼" into the upper heat chamber and is not obstructed.
- 2) not enough air movement in the chamber. Check for blower speed, obstructed chamber holes, plastic debris in the chamber.

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CASE: Tunnel temperature seems to be lower than the display reading.

Possible cause: blower motor is not running or running in reverse. Blower should run CW when looking from top. Not enough air movement in heat chamber, air holes plugged with molten plastic.

CASE: Tunnel does not reach set temperature.

Possible cause:

- 1) one or more SSR's not functioning. Check heater lights in the front if all come on (two on single phase machines).
- 2) Missing one phase (three phase machines only).
- 3) Blower motor not running.
- 4) Burnt out heater (rare).

CASE: Blower Motor not running.

Possible cause: blown fuses or Frequency Drive tripped due to binding. Check if motor is spinning free.

Missing one phase (three phase machines only). Check diagnostic lights or display on Frequency Drive for possible error codes.

CASE: Tunnel turns-on by itself when in cool-down.

Possible cause:

- 1) wrong programming parameters. Set parameters to factory settings.
- 2) air movement restriction, thermocouple obstructed, dirty chamber, holes plugged etc.
- 3) tunnel was turned off before cool-down cycle was completed.