Calibrating Main Control Boards Seal Wires

Tools Needed:
Small Plastic Screwdriver
Large Flat Head Screwdriver Metal

(Caution these POT adjustments are very sensitive, make very small 1/16 turns of the POT)

1. Install New Board
2. On the Main Control Panel Set Dwell Time to 3 and Wire Temp to 5
3. With the seal bar UP trigger the Proximity Sensor with Flat Head Metal Screwdriver and as you trigger the sensor watch the seal wires on the L-Bar to make sure they are not glowing red hot. If they are glowing Red; Reduce the Seal Wire Temp TRIM POT on the main board by rotating in counter clockwise.
4. If the Seal Wires do not glow red increase the Wire Temp on the front panel to 7 and repeat the triggering of the proximity sensor, watching so that the seal wires do not glow red. If they do glow red again reduce the Seal Wire Temp TRIM POT on main board.
5. Now increase the Wire Temp to 10 on Main Control Panel. Repeating the triggering of the proximity sensor and watching the seal wire. You want to see the seal wire just start to turn a DULL ORANGE. If the wire does not turn a Dull Orange you need to increase the Seal Wire Temp TRIM POT clockwise. Remember small adjustments, as you increase the POT re-trigger the Proximity Sensor to look for the DULL ORANGE glow.
6. When the Dull Orange glow is achieved the Seal Wire Temp TRIM POT is now calibrated.
7. The Second TRIM POT on the main board is "Thickness". This TRIM POT controls the repeatability of the seal wire temperature after multiple usage.
8. To calibrate this TRIM POT, keeping the Wire Temp set to 10 on the front panel. Watch the seal wires and trigger the Proximity Sensor 10 to 15 cycles consecutively (1 every 7-10 seconds). The seal wires should maintain the Dull Orange Glow. If the seal wires gradually glow hotter while multiple cycles are being performed, reduce the Thickness TRIM POT counter clockwise and repeat the multiple cycles. What you are trying to achieve is consistent Dull Orange Glow during multiple cycles. When that is achieved you have completed the Seal Wire Calibration.
9. You should be able to reduce your Seal Wire Temp back between 5-7 and seal and cut film consistently without burning out seal wires.

Trip Sensor

Seal Wire Temp

Thickness / Repeatability