



PF464-PF465 - Hand Type Impulse Sealer - Instructions

I. CAUTION

- KEEP CLEAN, ESPECIALLY THE INSULATED PTFE TAPE, PTFE SHEET AND HEATING WIRE.
- DON'T LEAVE WET OR HUMID AS IT MAY CAUSE AN ELECTRICAL MALFUNCTION. BEFORE OPERATING, CHECK THE INSULATED PTFE TAPE AND PTFE SHEET. IF THEY APPEAR UNUSUAL, REPLACE IT AT ONCE AS IT COULD CAUSE AN ELECTRIC SHORT AND DAMAGE THE HEATING WIRE.
- ENSURE THAT REPLACEMENT HEATING WIRE IS THE SAME SIZE AS ORIGINAL.

II. OPERATION

- PLACE MACHINE ON A LEVEL AND DRY WORK SURFACE
- CHECK VOLTAGE OF RECEPTACLE PRIOR TO PLUGGING IN UNIT. PRESS KNOB TO ACTIVATE UNIT AND VERIFY THAT LIGHT TURNS ON.
- ADJUST HEATING TIME ACCORDING TO MATERIAL AND THICKNESS OF BAG.
- PLACE BAG ON HEATING WIRE AND PRESS DOWN LEVER FOR 1-2 SECONDS FOR BEST SEAL.
- IF SEAL IS BROKEN OR DAMAGED, ADJUST THE TIMER KNOB TOWARDS SMALLER END AND RE-SEAL UNTIL PERFECT.
- IF SEAL IS NOT FULLY WELDED, ADJUST THE TIMER KNOB TOWARDS LARGER END AND RE-SEAL UNTIL PERFECT
- IF BAG STICKS TO SILICON, PLEASE SHORTEN THE SEALING PRESS TIME.

IMPERFECT SEALING	FRACTURED PTFE SHEET	REPLACE THE PTFE SHEET
	FRACTURED SILICON	REPLACE THE SILICON
	INADEQUATE COOLING PERIOD	KEEP AT LEAST 1-2 SECONDS COOLING TIME

III. HEATING ADJUSTMENT LIST

MATERIAL/ INDICATOR	POLYETHYLENE	POLYPROPYLENE OR HIGH-HEAT FILM
1	UNDER 0.06m/m	
2	UNDER 0.1m/m	
3	UNDER 0.14m/m	
4	UNDER 0.2m/m	UNDER 0.03m/m
5		UNDER 0.044m/m
6		UNDER 0.06m/m
7		UNDER 0.08m/m

WARNING!
To reduce the risk of shock, disconnect the unit from the supply circuit before servicing the replacement of the heating wire.

IV. REPLACEMENT INSTRUCTIONS

- REMOVE THE PTFE SHEET FROM THE FIXED PLATE. REPLACE WITH A NEW PTFE SHEET AND SECURE THE FIXED PLATE WITH SCREWS.
- WHEN CHANGING THE HEATING WIRE, REMOVE THE PTFE SHEET AND UNSCREW THE HEATING WIRE. PLACE ONE END OF THE HEATING WIRE ON THE ELECTRODE AND SECURE ANOTHER END WITH SCREWS. THEN SCREW ON THE PTFE SHEET.

V. MALFUNCTIONS

MALFUNCTIONS	CAUSES	SOLUTIONS
POWER FAILURE OF THE HEATING WIRE AND LAMP	DISCONNECTED PLUG	CHANGE THE PLUG
	SHORT OF AC CORD	REPAIR OR REPLACE
	AC CIRCUIT DISCONNECTED	REPAIR AC CIRCUIT
POWER FAILURE BUT THE LAMP REMAINS ON	HEATING WIRE BROKEN	REPLACE THE HEATING WIRE
	DISCONNECTED ELECTRODE SPRING	REPLACE THE ELECTRODE WIRE OR CHECK VOLTAGE
LAMP STILL ON & PTFE SHEET OVERHEATS	TIMER MALFUNCTION	CONTACT YOUR SUPPLIER
	PROLONGED HEATING TIME	DECREASE THE HEATING TIME
HEATING WIRE BREAKS SUDDENLY	FREQUENT OPERATION WITHOUT PROPER COOLING PERIOD	KEEP AT LEAST 1-2 SECONDS. AFTER LED LAMP IS OFF, THEN LIFT UPPER LEVER. DAILY OPERATION SHOULD NOT EXCEED 1,000 TIMES
	FRACTURED PTFE TAPE	REPLACE THE PTFE TAPE

PARTS LIST FOR PF464/PF465

NO	PARTS NO.	PARTS NAME	QTY
1	A-001	Lever Knob	1
2	A-002A	Lever PF464	1
	A-002B	Lever PF465	1
3	A-003A	Hinge Bracket PF464	1
	A-003B	Hinge Bracket PF465	1
4	A-004A	Shaft for PF464	1
	A-004B	Shaft for PF465	1
5	A-005A	Washer for PF464	1
	A-005B	Washer for PF465	1
6	A-006A	Bracket for PF464	1
	A-006B	Bracket for PF465	1
7	W-00406A	Spring PF464	2
	W-00406B	Spring PF465	2
8	W-00302A	Silicon Bracket PF464	1
	W-00302B	Silicon Bracket PF465	1
9	W-00106A	Silicon PF464	1
	W-00106B	Silicon PF465	1
10	W-00602A	Fixed Plate (PTFE Sheet) PF464	2
	W-00602B	Fixed Plate (PTFE Sheet) PF465	2
11	W-00702A	PTFE Sheet PF464	1
	W-00702B	PTFE Sheet PF465	1
12	W-00102A	Heating Wire PF464	1
	W-00102B	Heating Wire PF465	1
13	W-01101A	Insulated PTFE Tape PF464	1
	W-01101B	Insulated PTFE Tape PF465	1
14	W-01301A	Heater Cover PF464	1
	W-01301B	Heater Cover PF465	1
15	A-007A	Body PF464	1
	A-007B	Body PF465	1
16	E-00504A	Timer (110V)	1
17	W-00404A	Spring PF464	1
	W-00404B	Spring PF465	1
18	W-00801	Spring Hook	1
19	W-009	Heater Wire Connector	1
20	A-008	Microswitch Bracket	1
21	E-00702	Microswitch	1
22	E-008	Power Cord	1
23	E-013	Grommet	1
24	E-00607A	Transformer PF464 110V	1
	E-00607C	Transformer PF465 110V	1
25	A-009A	Plate for Transformer PF464	2
	A-009B	Plate for Transformer PF465	2
26	W-023A	Insulated Screw (S) PF464	2
	W-023A	Insulated Screw (S) PF465 (back)	1
27	W-023B	Insulated Screw (L) PF465 (front)	1
28	A-010A	Guard Plate PF464	1
	A-010B	Guard Plate PF465	1
29	W-01001A	Rubber Foot PF464	4
	W-01001B	Rubber Foot PF465	4
30	S-022	Screw M4x6	4
31	S-055	Spring Washer	1
32	S-025	Screw M5x25	1
33	S-057	Washer ¼"x13	1
34	S-011	Screw M6x25	1
35	S-027	Screw M4x20	1
36	S-048	Nut M4	1
37	S-039	Screw M4x10	1
38	S-001	Screw M3x8 PF464	4
	S-001	Screw M3x8 PF465	6
39	S-056	Spring Washer M6	1
40	S-034	Screw M6x10	1
41	S-002	Screw M4x6	2
42	S-021	Screw M3x15	2
43	S-031A	Screw M4x8	4
44	S-031A	Screw M4x8 PF464	4
	S-031B	Screw M4x10 PF465	4
45	S-037	Screw M3x6	3

