W·SERIES

I-Bar Sealer

Models: W-350I/C, W-500I/C, W-650I/C, W-750I/C, W-900I/C

Distributed By:

Version 1.1

Sealer Sales, Inc.
8820 Baird Avenue
Northridge, Ca 91324
www.sealersales.com

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General Information

Thank you for purchasing our W-Series I-Bar Sealers.

This owner's manual contains information relating to your sealer. The manual will provide you with basic information concerning both operation and maintenance of your new machine. Please read it carefully as failure to do so may result in bodily injury and/or damage to the equipment.

Please fill in the information below. You will find the information on the machine identification plate. You will need this information when ordering replacement parts or making technical inquiries.

WHI EQUIPMENT INFORMATION

- Model #
- Serial #
- Purchase Date:
- Reference # (found on packing slip)
- Owner:

Safety Instructions

WARNING! *Below are general safety precautions and warnings that should be understood prior to setting up or operating your equipment. Read and fully understand all instructions and warnings prior to using this unit. Your safety is most important! Failure to comply with procedures may result in serious injury or property damage. Remember:* ***Your personal safety is your responsibility.***

Unsafe practices or unauthorized modifications could result in accidents or property damage. Failure to follow these safety rules and take necessary precautions can result in serious injury as well as damage to equipment.

- Never operate or service your sealer until you have read this manual completely and understand it fully.
- Plug the sealer into a standard 120 Volt, 60Hz wall outlet or surge protector.
- Do not use the sealer if the power cord, plug or any other parts are damaged. Do not to allow the power cord to drape into your work area. Check that all parts are operating properly and perform the intended functions. Check for any worn parts before starting operation. Check for all other conditions that may affect the operation of your sealer.
- Reduce risk of unintentional starting. Make sure the power switch is in the "OFF" position before connecting to the power source.
- Always disconnect sealer from power source before servicing, changing accessories or cleaning the unit.
- To provide protection against the risk of electrical shock, the power connection must be properly grounded at all times.
- Do not leave the sealer unattended when in use. Disconnect the sealer from the power source before leaving the work area.
- Do NOT use the machine for any other purpose other than to seal thermoplastic materials. Doing so may result in damage to the machine and injury to the operator.
- While operating machinery, wear close-fitting clothing and tie back long hair to prevent any external items from getting caught in the machine. Do not wear jewelry when operating the sealer.

- Never touch the heating elements with bare hand while the sealer is plugged into a power source, in operation or just finished operation. Touching heated areas may cause fire and/or severe burns.

- The blade found on the I-Bar Sealer w/ Cutter is very sharp. Use extreme caution when handling or changing the blade.
- While machine is in operation, do not place fingers, tools, or other foreign objects on or into the machine. Do not place hands or fingers near pinch points. Do not touch machine while it is in operation. Perform all procedures carefully and watch where hands and fingers are at all times.
- The sealer is not water resistant or water proof. Spraying down the machine will damage machine or cause electrical shock. Do not submerge the sealer into water or liquid.
- Do not operate sealer in a corrosive or humid environment.
- Always keep the machine clean, lubricated and in good working condition. Follow any maintenance and lubrication procedures outlined in this manual. Make sure unit is disconnected from power source before cleaning.
- NEVER use any accessories or parts from other manufacturers. Machine should not be altered or modified using parts that are not genuine authorized parts. Doing so will VOID YOUR WARRANTY.
- ***When replacing the heating elements, always replace the PTFE adhesive under the heating element. A worn PTFE adhesive can cause the heating element to break.*** The PTFE adhesive works as a barrier between the body of the sealer and the element. Never allow the element to come in direct contact with the sealer body as that will damage the timer.
- Never leave the sealer unattended. Be safe, disconnect the sealer from power source before leaving work area.
- Always keep out of reach of children and pets.
- Close supervision is necessary when any appliance is near persons with reduced physical, sensory or mental capabilities or lack of experience and knowledge . This sealer is NOT to be used by children or by persons with reduced physical, sensory or mental capabilities or lack of experience and knowledge.
- Do NOT use the sealer outdoors.
- Do NOT use the sealer while under the influence of drugs, medications or alcohol.

SAVE THESE INSTRUCTIONS - REFER TO THEM OFTEN AND USE THEM TO INSTRUCT OTHERS.

Introduction

W-Series I-Bar sealers are designed for shrink film packaging, but can also be used for creating and/or sealing poly bags. Our W-Series I-Bar sealers w/ cutters are accompanied with a sliding cutter ideal for sealing or making bags from poly tubing. Our W-Series I-Bar sealers can seal polyethylene, polypropylene, saran, nylon, static shielding bags, and mylar up to 10mil in total thickness.

Features of the W-Series I-Bar Sealers

Your I-Bar sealer is equipped with a wide range of standard features and capabilities.

- Impulse sealing - no warm up time needed
- Plug-in electronic timer for variable control
- Heavy duty all metal construction
- Table top design supported with anti-slip rubber feet
- Equipped with film roller, film separator
- Equipped with heat gun holder and power outlet for heat gun (not included)
- Distance from center of film to seal: 10.5"
- I-Bar: round heating element
- I-Bar w/ Cutter: 2.7mm wide flat heating element
- Manufacturer spare parts kit includes: 3 heating elements and blade (cutter version only)

How Do W-Series I-Bar Sealers Work?

Basic Principles
Place material on lower jaw and bring sealing arm to activate sealing process

Our W-Series impulse sealers fire a short burst of electricity through a specially designed heating wire to weld thermoplastic materials together. The length of the seal time will depend on the sealing characteristics of the bag being sealed. The sealing process is simple: The operator places material on the base of the sealer and brings the sealing arm down to seal.

Specifications

	W-350I W-350IC	W-500I W-500IC	W-650I W-650IC	W-750I W-750IC	W-900I W-900IC
Power	110V/60Hz	110V/60Hz	110V/60Hz	110V/60Hz	110V/60Hz
Watts	450W	600W	800W	1000W	1200W
Seal Width	Round - I 2.7mm - IC	Round - I 2.7mm - IC	Round - I 2.7mm - IC	Round - I 2.7mm - IC	Round - I 2.7mm - IC
Sealing Length	14"	20"	26"	30"	35"
Cutting Length (IC)	13"	19"	24 1/2"	28 3/4"	33 3/4"
Dimensions	23.5" x 16" x 5.5"	29.5" x 16" x 5.5"	35" x 16" x 5.5"	37.5" x 16" x 5.5"	45" x 16" x 5.5"
Shipping Dimensions	28" x 21" x 12"	33" x 21" x 12"	40" x 21" x 12"	45" x 21" x 12"	49" x 21" x 12"
Net Weight	28lbs	34lbs	40lbs	42lbs	51lbs
Gross Weight	35lbs	43lbs	49lbs	51lbs	60lbs

Getting to Know your I-Bar Sealer

W-Series I-Bar Sealers are simple and efficient sealing machines.

Figure 1. W-Series I-Bar Sealer Overview

Electrical Circuit Diagram

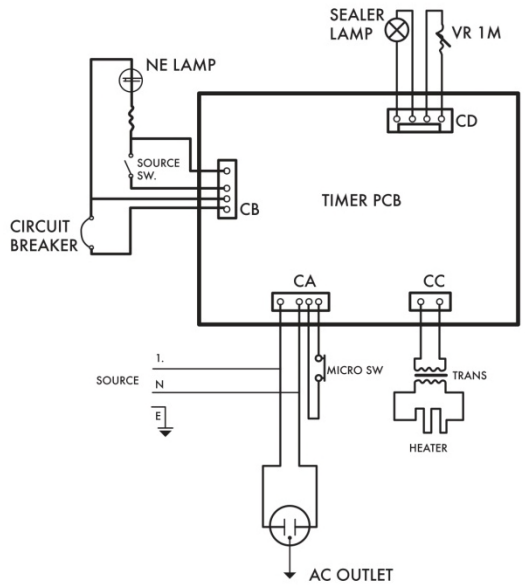


Figure 2. Electrical Circuit Diagram for W-Series I-Bar Sealers

Operating your Sealer

Assembly Instructions

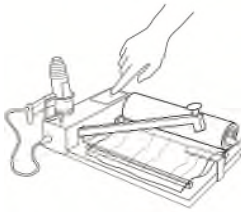
1. Sealer comes assembled and ready to operate.

2. Insert the heat gun holder in the holder receptacle found on the control box. Place heat gun (not included) in the heat gun holder. Always place heat gun with the nozzle facing upwards for proper cooling. Laying it flat on the table will cause the heat to be left in the mechanics of the heat gun and damage the heat gun.

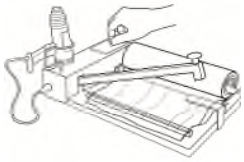
Operation

1. Before operating, check the heating element, PTFE cover, PTFE adhesive and the silicone rubber.

2. Insert the power cord into the correct receptacle (110V).

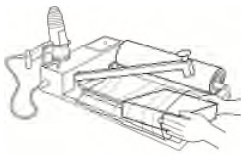


3. Turn the power switch on.

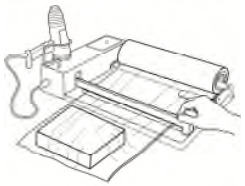


4. Set the timer knob to the lowest setting. Always start with a low setting and increase gradually as needed.

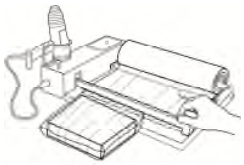
I-Bar Sealers w/ no cutter



1. Put a roll of centerfold shrink film on the film roller and feed the open part of the film through the film separator.
2. Place product to be sealed in the film pocket.



3. Press sealing bar down and seal. This will cut and seal the film.



4. Tear the resulting bag from the rest of the film. Place the open side between seal bars and seal the opening.

5. Use a heat gun to shrink the film evenly.

I-Bar Sealers w/ Sliding Cutter

1. Place poly tubing on the film roller and feed the open part of the film through the film separator.
2. Bring sealing arm down to seal one end of the tubing. Slide the cutting bracket across the poly bag to cut material above the seal creating a bag.
3. Fill your bag with your material and seal the bag opening closed.

Tips for Successful Sealing

1. If the seal is broken or damaged, decrease the sealing time.
2. If the seal is not fully welded, increase the sealing time.
3. If the sealing material sticks to the sealing pad, decrease the congealing time.
4. If the width of the seal is not perfect or does not match the size of the element, increase the congealing time. ***When sealing/timer light turns off, keep pressing the sealing arm down for an additional 2-3 seconds. For a high quality seal, seals must be able to cool under pressure. We usually recommend a congeal setting of at least 2x that of the heat setting but every bag will have variations. Thicker materials will require a longer cool (congealing) time.***

5. Always keep the sealer clean. Remove any residue found on the platform and PTFE cover. Silicone spray may be used for this purpose.

6.  ***When replacing the heating elements, always replace the PTFE adhesive under the heating element. A worn PTFE adhesive can cause the heating element to break.*** The PTFE adhesive works as a barrier between the body of the sealer and the element. Never allow the element to come in direct contact with the sealer body as that will damage the timer.

7. Occasionally check the condition of the silicone rubber for wear or burns. A damaged silicone rubber will affect the quality of the seal.

8.  Be sure to turn off the power or unplug the unit before replacing any parts.

Maintenance

The following maintenance procedures should be followed to ensure the longevity of your W-Series I-Bar sealer.

Inspection and Cleaning

1. Inspect your machine daily.
2. Use a clean cloth to remove any plastic residue remaining on the top PTFE adhesive.
3. When replacing the elements, always check the condition of the bottom PTFE adhesive.
4. Check the condition of the silicone rubber for wear and burns. A damaged silicone rubber will affect the quality of the seal.

Replacement Kit Instructions

Our W-Series I-Bar sealers will require new heating elements and PTFE from time to time. Heating elements will break through wear and tear. ***A good rule of thumb is to replace the bottom PTFE adhesive every time you change your heating element.*** The top PTFE adhesive prevents the plastic or other thermoplastic material you are sealing from sticking to the heating element.

Replacement kits are available from your distributor. Kits include (2) heating elements, (4) PTFE adhesives, and (1) blade for cutter units. For replacement kit part #s, refer to your model #.

	W-350I W-350IC	**W-500I W-500IC**	**W-650I W-650IC**	**W-750I W-750IC**	**W-900I W-900IC**
Replacement Kit (I)	RK-14B-W-350I	RK-20B-W-500I	RK-26B-W-650I	RK-30B-W-750I	RK-35B-W-900I
Replacement Kit (IC)	RK-14BC-W-350IC	RK-20BC-W-500IC	RK-26BC-W-650IC	RK-30BC-W-750IC	RK-35BC-W-900IC
Heating Element (I)	HE-14-0-WHI	HE-20-0-WHI	HE-26-0-WHI	HE-30-0-WHI	HE-35-0-WHI
Heating Element (IC)	HE-14-2.7-WHI	HE-20-2.7-WHI	HE-26-2.7-WHI	HE-30-2.7-WHI	HE-35-2.7-WHI
PTFE Adhesive	TA-14	TA-20	TA-26	TA-30	TA-35
Blade *(only for IC units)*	B-WH	B-WH	B-WH	B-WH	B-WH
Spring Hook Assembly *(not included in RK)*	SHA-WHI	SHA-WHI	SHA-WHI	SHA-WHI	SHA-WHI

To install your replacement kit on your sealer, turn off power and unplug sealer.

Removing Worn Parts

1. Remove the top PTFE adhesive that covers the heating element.
2. Remove the heating element by pulling the spring hook assembly down at the front of the sealer to loosen the element from the hinge. We have found that using a screwdriver to pull the spring hook assembly down is helpful. Release the other end of the element from the base of the sealer.

Figure 3. Using a screwdriver pull down spring hook assembly

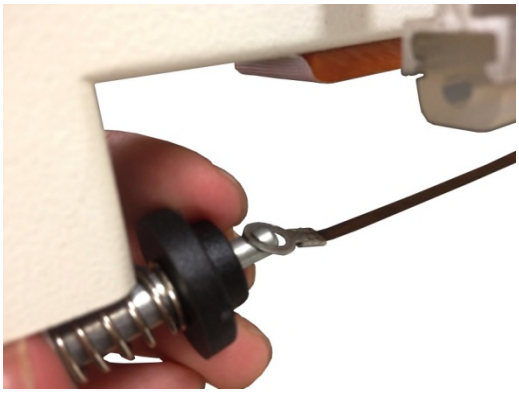


Figure 4. Remove heating element from spring hook assembly groove

3. Remove the bottom PTFE adhesive from the sealer's arm.

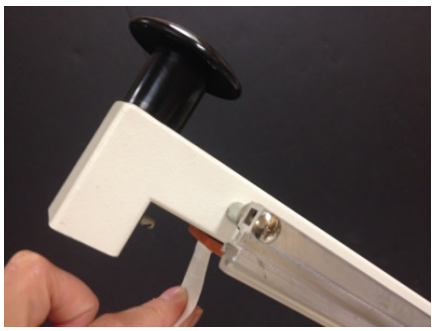


Figure 5. Peel the bottom PTFE adhesive from the sealer's arm.

Installing New Replacement Parts

1. Remove the backing of the liner found on the PTFE adhesive.
2. Apply the new PTFE to the sealer's sealing arm, making sure the adhesive extends past the red/orange acrylic plate on the metal sealing arm. (The PTFE adhesive acts a barrier between the metal body and the heating element. Never allow the heating element to come in direct contact with the sealer's body because it will damage the timer.) ***A good rule of thumb is the replace the bottom PTFE adhesive every time you change the element.***
3. Attach the element to the hinge on the spring hook assembly at the base of the sealer. Attach the other end of the element to the hinge of the spring hook assembly at the front of the sealer. Push the spring hook assembly back into the arm of the sealer.

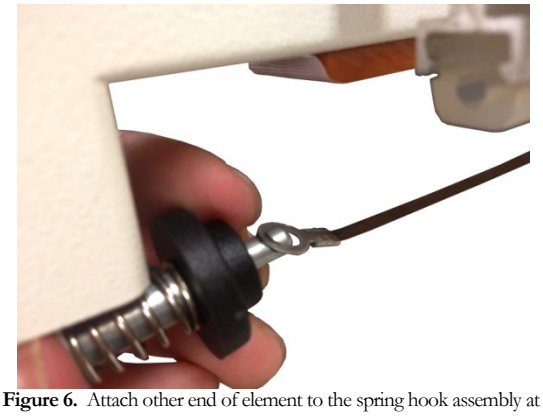


Figure 6. Attach other end of element to the spring hook assembly at the front of the sealing arm.

4. Place another piece of PTFE adhesive over the heating element. This adhesive will prevent any thermoplastic from sticking to the heating element.

Removing and Replacing Cutter Blades (IC models only)

1. Remove the cutting blade bracket from the silicone bracket. Remove the screw, washers and spacer from the silicone bracket. Slide the cutting bracket out.

Figure 7. Unscrew the silicone bracket and remove screw, washer and spacers.

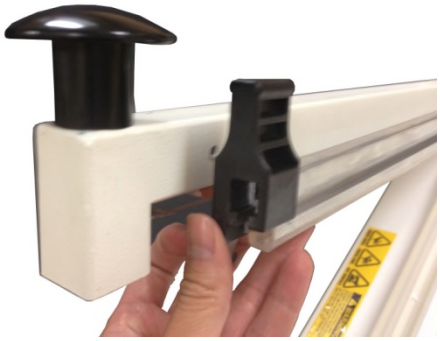


Figure 8. Slide the cutting bracket out.

2. Remove the cutter protector and carefully remove the old blade. ***The blade found on the I-Bar sealer with cutter is very sharp. Use extreme caution when handling or changing the blade.***

Figure 9. Remove cutter protector.

Figure 10. Carefully remove the old blade.

3. Replace the old blade with a new blade. Replace cutter protector and screw back into place.

4. Slide the cutting bracket back on the silicone bracket. Install the spacer, washer and screw to hold the silicone bracket in place.

Parts Diagram

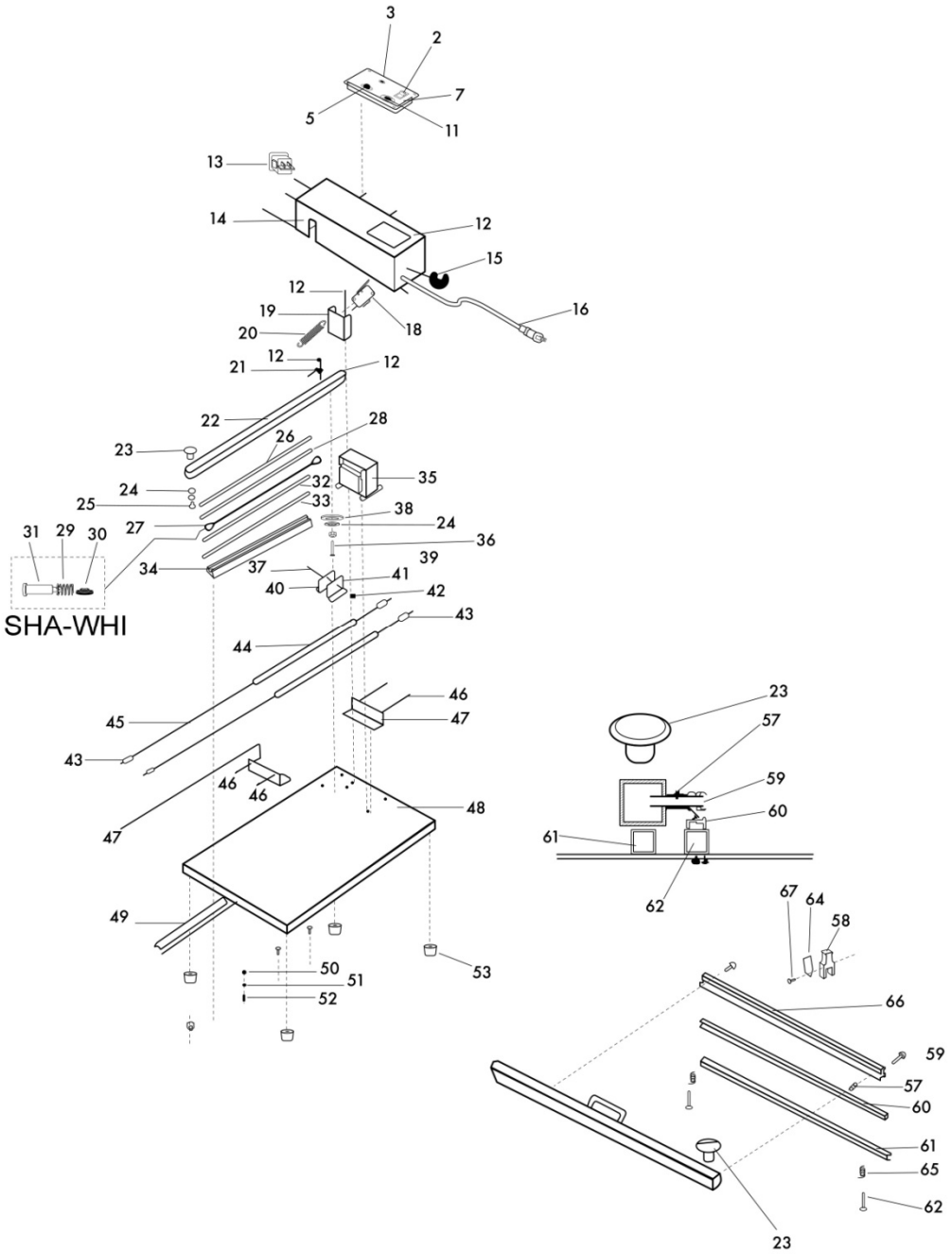
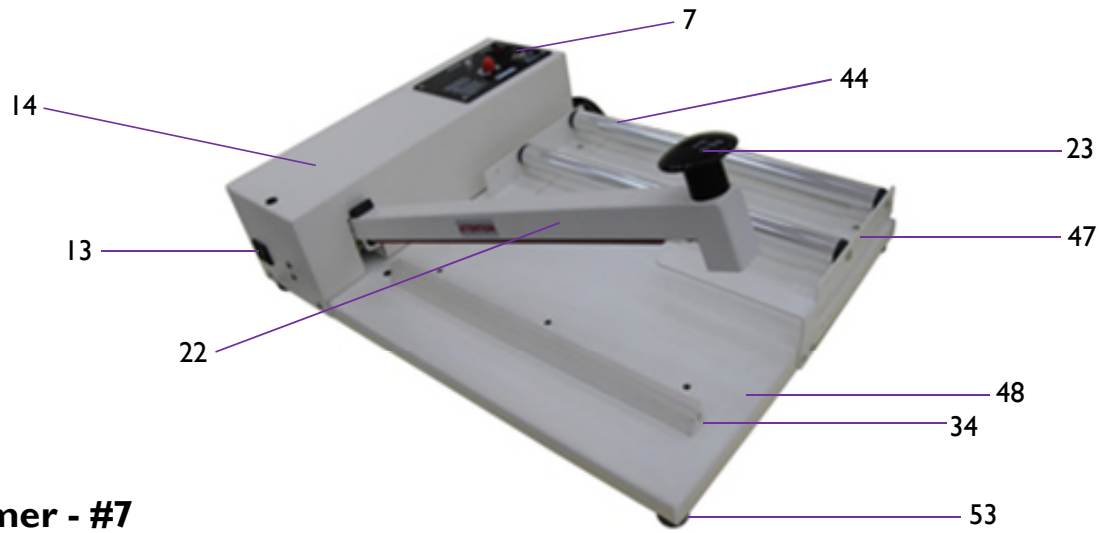


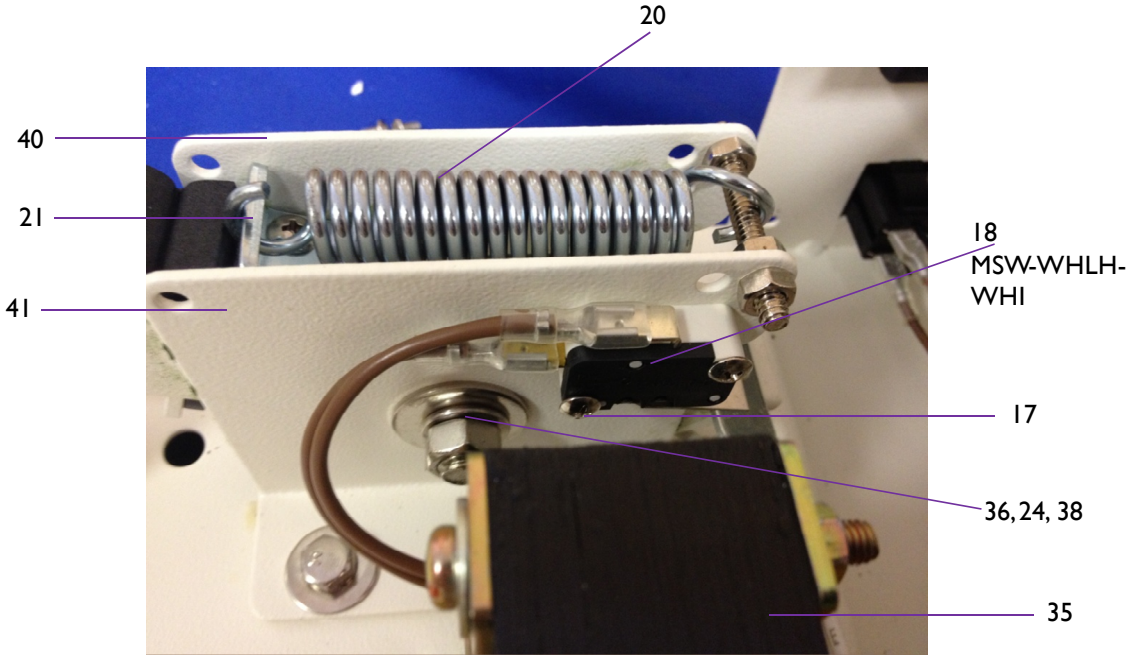
Figure 11. Spare Parts Diagram Overview

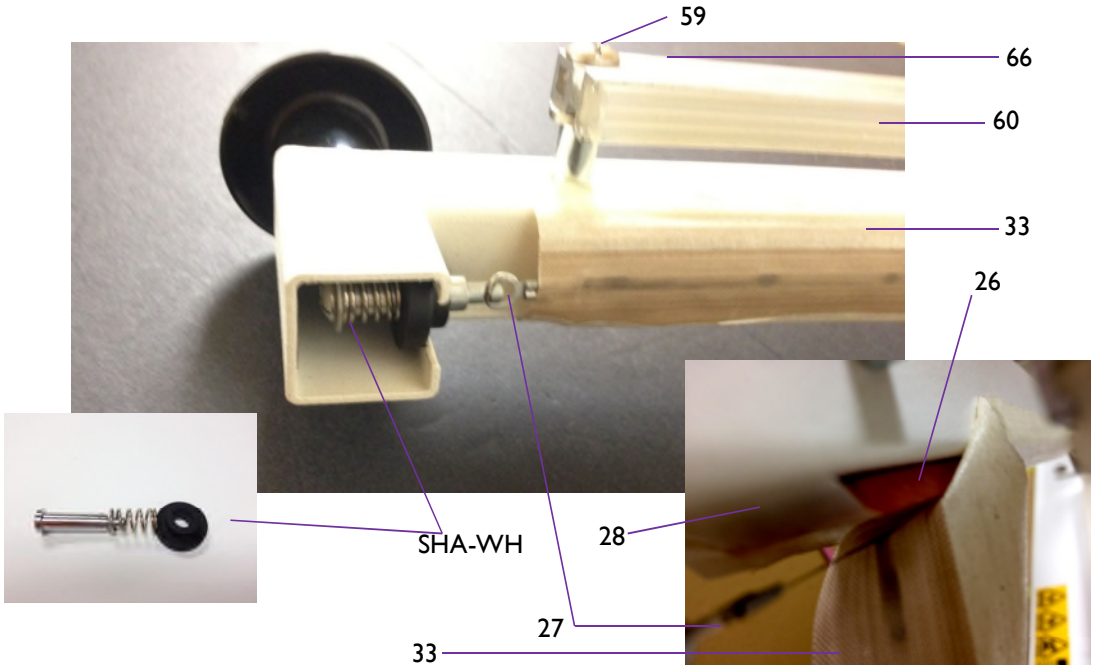
Figure 12. Spare Parts Diagram Overview



Timer - #7

Figure 13. Spare Parts Diagram Overview





Item	Part #	Description	Comments
RKs	**RK-Model#**	**REPLACEMENT KITS Includes (2) elements, (4) PTFE adhesives, and (1) blade if cutter unit (IC)**	**specify model # when ordering**
1	**Screw-M4x8**	M4*8 Screw	
2	**WHLH-7**	Power Switch, 3P, 15A/125V (W-Series)	
3	**WHA-33**	Lamp (R), LED for E.G.O. E-00302 for (W-Series)	
4		Nut for Circuit Breaker	
5	**WHA-30**	Knob, Red for (W-Series)	
6	**WHI-6**	Nut for (Variable Resistor)	
7		Control Panel,Timer, PCB the Same,consists(2-11)	
7a	**T-W-350I/350IC**	Control Panel, Timer, 12", Circuit Breaker (7A)	**for W-350I/IC**
7b	**T-W-500I/500IC**	Control Panel, Timer, 20", Circuit Breaker (10A)	**for W-500I/IC**
7c	**T-WH**	Control Panel, Timer, (26", 30", 35"), CB (15A)	**for W-650I/IC, W-750I/IC, 900I/IC**
7d	**PCB-WHI**	PCB for the Control Panel - 10A	
8		Spring Washer	
9		Nut	
10	**WHA-36**	Variable Resistor - 1M (W-Series)	
11a	**WHI-11a**	Circuit Breaker, 7A	**for W-350I/IC**
11b	**WHI-11b**	Circuit Breaker, 10A	**for W-500I/IC**
11c	**WHI-11c**	Circuit Breaker, 15A	**for W-650I/IC, W-750I/IC, 900I/IC**
12	**Screw-M4x8**	M4*8 Screw	
13	**WHI-13**	Power Receptacle 3P	
14	**WHI-14**	Control Box	
15	**WHA-43**	Grommet (W-Series)	
16	**PC-WH**	Power Cord	
17		Screw 3* 15 for #18	
18	**MSW-WHLH-WHI**	Microswitch w/Long Arm for WHLH and WHI	
19	**WHI-19**	Limit Switch Holder	
20a	**WHLH-67a**	Spring Arm, 2.6 for WHI and WHLH	**for W-350I/IC, W-500I/IC**
20b	**WHLH-67b**	Spring Arm, 3.0 for WHI and WHLH	**for W-650I/IC, W-750I/IC**
20c	**WHLH-67c**	Spring Arm, 3.5 for WHI and WHLH	**for W-900I/IC**
21	**WHI-21**	Spring Holder, L-Bracket	
22		Upper Lever Arm	**specify model # when ordering**
23	**WHLH-54**	Lever Knob, Round (WHI and WHLH)	
24	**WHI-24**	Spring Washer M6 for# 23	
25	**WHI-25**	Screw M6*20 for #23	
26		Acrylic Plate - 3/4" Orange Plastic	**specify model # when ordering**
27	**HE-specifymodel#**	Heating Wire 0.8mm, 2.7mm	**specify model # when ordering**
28	**TA-specifymodel#**	PTFE Adhesive (Insulated Tape) 3/4" TA, 3mil	**specify model # when ordering**
29	**WHI-29**	Spring, for Hook Assembly	
30	**WHI-30**	Plastic Washer for Hook Assembly	
31	**WHI-31**	Spring Hook, for Hook Assembly	
31a	**SHA-WHI**	Spring Hook Assembly SHA-WHI includes (29-31)	

Figure 14. Spare Parts Diagram List (Table 1 of 2)

Item	Part #	Description	Comments
32	**TA-specifymodel#**	PTFE Adhesive (Insulated Tape) 3/4" TA, 3mil	**specify model # when ordering**
33	**SR-specifymodel#**	Silicone Rubber SR-	**specify model # when ordering**
34		Silicone Bracket	**specify model # when ordering**
35a	**TRNS-W-350I/IC**	Transformer (14")	**for W-350I/IC**
35b	**TRNS-W-500**	Transformer (20") #1035	**for W-500I/IC**
35c	**TRNS-W-650/750**	Transformer (26", 30") #1037	**for W-650I/IC, W-750I/IC**
35d	**TRNS-W-900**	Transformer (35", 40") #1039	**for W-900I/IC**
36		Screw M6*16	
37		Screw 3/8* 1 1/2	
38		Washer M6*16	
39	**WHLH-40**	Bushing - old gen	
40		Upper Lever Bracket (Left)	
41		Upper lever Bracket (Right)	
	WHLH-30a	Support Bracket Set	
42		Screw 3/8	
43	**WHI-43**	Bearing w/ Screw for Rollers	
44		Film Roller/each	
45		Shaft	
46		Screw M5*8	
47		Roller Fixed Plate	
48		Base Plate	
49		Bags Support/Film Separator	
50		Washer 5/16*23	
51		Screw 5/16	
52		Screw 5/16* 5/8	
53	**WHLH-38**	Rubber Foot (WHLH / WHI)	
54		Adhesive PTFE Tape 19mm	
56		PC Support	
		#57-68 for Sealers with Cutter	
57	**WHLH-75**	Bushing for Cutter Unit, Rubber Spacer for WHLH and WHI-C	
58	**CB-WH**	Cutting Blade Bracket	
58a	**CBB-WH**	Cutting Blade Braket with Blade	
	CBB-WH-HD	Cutting Blade Bracket w/ Blade - Heavy Duty	
59	**WHLH-76**	Screw M5*30, Cutter Unit Bracket	
60	**SRC-model#**	Silicone for Cutter Unit for WHI and WHLH	**specify model # when ordering**
61	**refer to WHLH #2**	Square Tube for WHLH and WHI	
62	**WHI-62**	Screw - M4*25 for Square Tube for WHLH and WHI	
64	**B-WH**	Blade	
65	**WHI-65**	Spring for Square Tube for WHLH and WHI	
66	**refer to WHLH #69**	Silicone Bracket for Cutter Unit	
67	**WHLH-73**	Screw M3*8 for Blade	
68		Complete Cutter Unit	
69	**WHI-69**	Heat Gun Holder	
69a	**WHI-69a**	Fixed Plate for Heat Gun Holder	

Figure 15. Spare Parts Diagram List (Table 1 of 2)

Troubleshooting

Problem	Possible Causes	Solution
No sealing Timer light is off	1. Disconnected power cord 2. Power cord is broken 3. Blown fuse 4. Transformer is broken	1. Check or change plug 2. Replace power cord 3. Replace fuse 4. Replace the transformer
No sealing Timer light is on	1. Heating element is broken 2. Poor contact at heating terminal blocks 3. Microswitch malfunction 4. Microswitch out of place	1. Replace the heating element 2. Clean, tighten or change the heating terminal blocks 3. Replace microswitch 4. Adjust microswitch
Burnt PTFE cloth	1. Timer malfunction 2. Timer setting too high	1. Replace timer 2. Decrease timer setting
Broken heating element	1. Worn bottom PTFE adhesive	1. Replace bottom PTFE adhesive
Wrinkled seal	1. Seal time is set too high 2. Cooling (congeal) time is too	1. Decrease 2. Increase congealing time
Imperfect seal	1. Worn top PTFE adhesive 2. Worn silicone rubber	1. Replace top PTFE adhesive 2. Replace the silicone rubber
Burnt seal	1. Seal time is set too high	1. Decrease seal time
No seal	1. Seal time is set too low	1. Increase seal time
Seal sticking to PTFE adhesive	1. Worn or dirty top PTFE adhesive 2. Worn or dirty silicone rubber	1. Replace or clean top PTFE adhesive 2. Replace or clean silicone rubber