



H-4012

Vacuum Sealer

Operating Instructions

ULINE H-4012 VACUUM SEALER

WARRANTY

Thank you for choosing a Uline Vacuum Sealer, manufactured in the U.S.A. by one of the country's leading manufacturers of plastic sealing machinery.

All Uline sealers are designed, built and tested to give years of reliable, trouble-free service. Uline machines have a 1 year limited warranty from date of delivery against any electrical or mechanical defects, excluding elements of Teflon®. This warranty is automatically void if a machine is damaged through improper use or unauthorized repairs.

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ULINE 20" VACUUM SEALER

OPERATING INFORMATION

*** IMPORTANT: READ INSTRUCTIONS COMPLETELY PRIOR TO OPERATION**

Introduction

This chapter is organized in five sections. The first section is a safety section that describes the general safety precautions you should take when you operate the Vacuum Sealer. The second section provides an overview of the equipment and describes how the sealer works. All of the major components you are concerned with are addressed.

The third section lists all of the controls that you use to operate the Vacuum Sealer. It shows their locations and describes the function of each control. The fourth section includes procedures you should follow when you start up, operate and shut down the machine.

The fifth section provides instructions for completing basic maintenance and troubleshooting the sealer. Maintenance procedures include visual inspections and operating maintenance.

Throughout this chapter you will find three safety icons:

⚠ **CAUTION:** Represents possible dangers

* **IMPORTANT:** Represents important information to be aware of

📖 **NOTES:** Represents notes and special instructions. You should pay particular attention to these icons because they signal information that is important to your safety and to the correct operation of the equipment.

DISCLAIMERS:

Satisfactory operation of the sealer depends on proper application, correct installation and adequate maintenance. In addition, modifications to the sealer may result in less than satisfactory performance and could void the warranty.

AUDIENCE:

This chapter is designed for operators who have baseline knowledge of typical mechanical operations and who have basic reading and math skills.

CONTACT INFORMATION:

If any additional information is needed contact Uline at (800) 295-5510.

Safety

PRECAUTIONS:

To insure safe operation of the sealer, the operator should be aware of pinch points and possible burn hazard near the Seal Jaw Area. Uline has provided warning stickers to alert operator to this hazard.

Do not wear neckties, jewelry, loose clothing or other items that can become caught in moving parts or mechanisms in the vicinity of the machine. Wear all company-specified personal protective equipment while operating the machine.

Do not operate, troubleshoot, or maintain the sealer while under the influence of any type of drug or alcohol.

Always observe all safety warnings and notices on the machine and in this manual.

Do not use flammable or toxic cleaning fluids such as gasoline, benzene, or ether when cleaning or maintaining the sealer.

⚠ CAUTION:

Keep hands, fingers or flammable objects out of Vac/Seal Jaw Area. To prevent burns should an unauthorized object get caught between the jaws, turn off the Main Power Switch.

Physical Layout

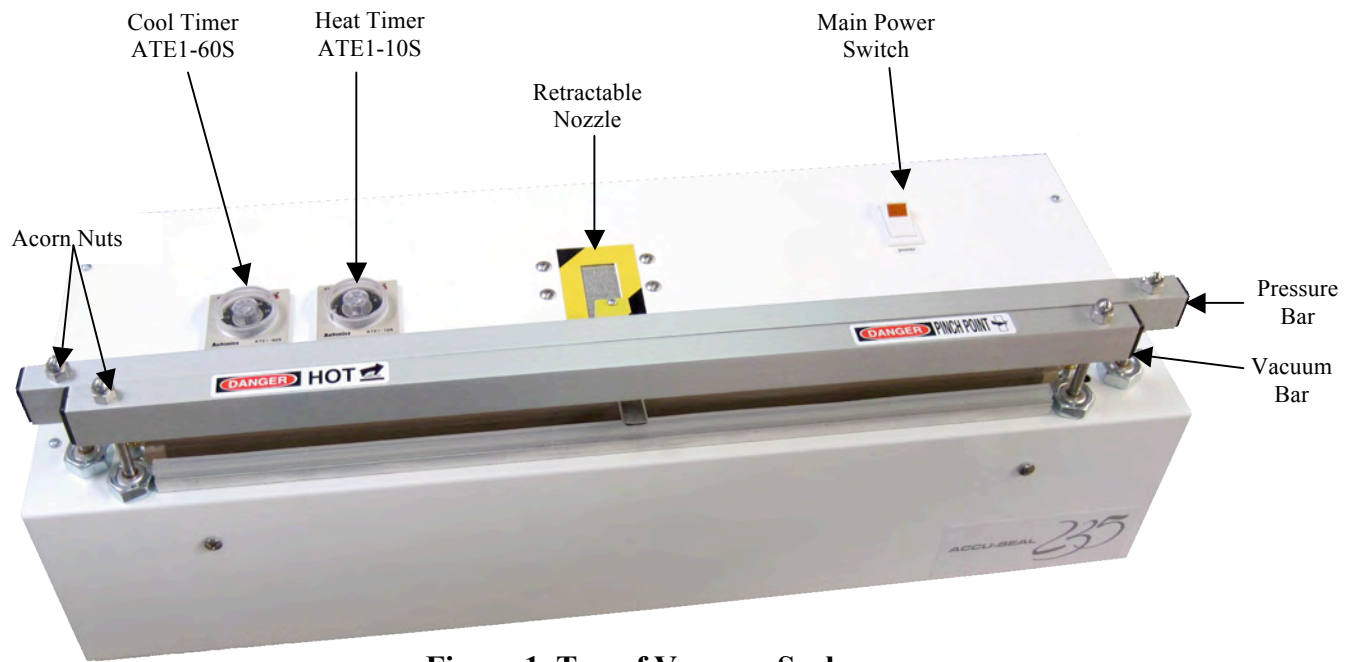


Figure 1, Top of Vacuum Sealer

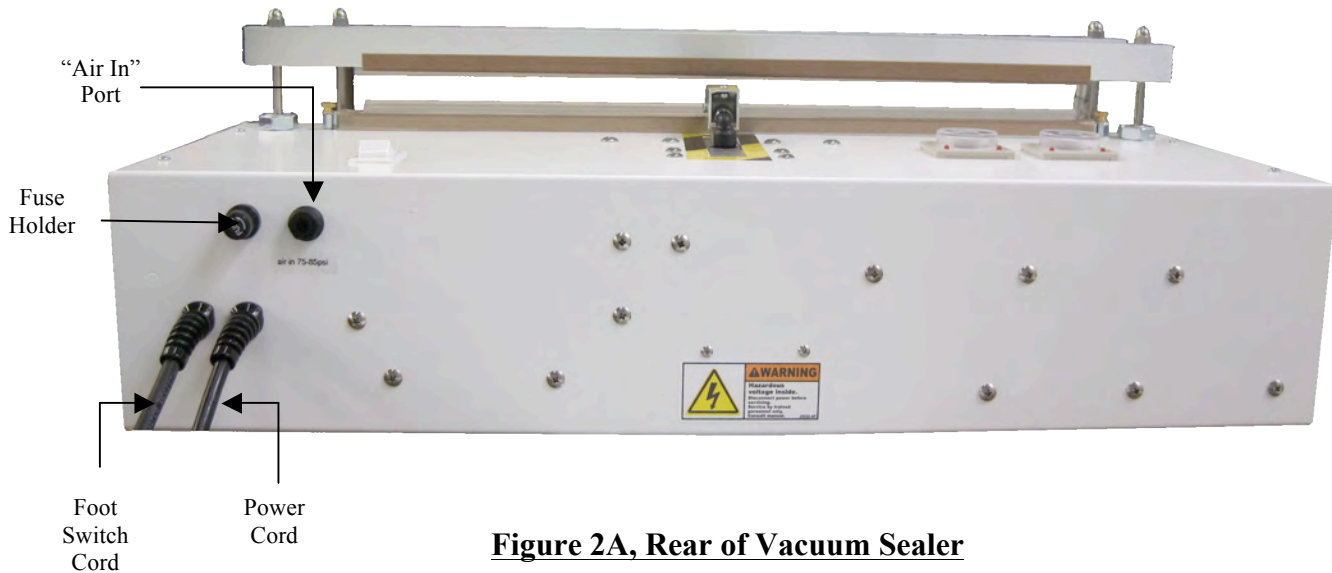


Figure 2A, Rear of Vacuum Sealer

Overview

SEQUENCE OF OPERATION

DESCRIPTION:

The Uline Vacuum Sealer is a pneumatic vacuum impulse heat sealer, controlled by analog Heat and Cool Timers while the vacuum time is controlled manually by depression of the Foot Switch.

The operator sets the heat and cool times by turning the Heat Timer control knob and the Cool Timer control knob on the sealing unit to obtain the desired seal. The operator loads the product into the bag, brings the bag up to the machine and places the bag around the nozzle, between the sealing jaws. The operator then presses and holds the Foot Switch until desired vacuum level is attained, then releases the Foot Switch. The machine will then go into the preset heat and cool cycle.

The sealer comes standard with 1/4" seal width and 20" seal length.

PROCESS:

For more information see Figure 3, Operational Flowchart on Page 5.

1. - Bring pouch up to the jaws.
2. - Place bag around nozzle.
3. - Pull bag so that seal area is straight and crease free.
4. - Depress and hold foot switch until desired vacuum level is reached.
5. - Release foot switch to begin sealing cycle.
6. - Jaws will automatically release when seal cycle (Heat & Cool) is complete.

OPERATIONAL FLOWCHART:

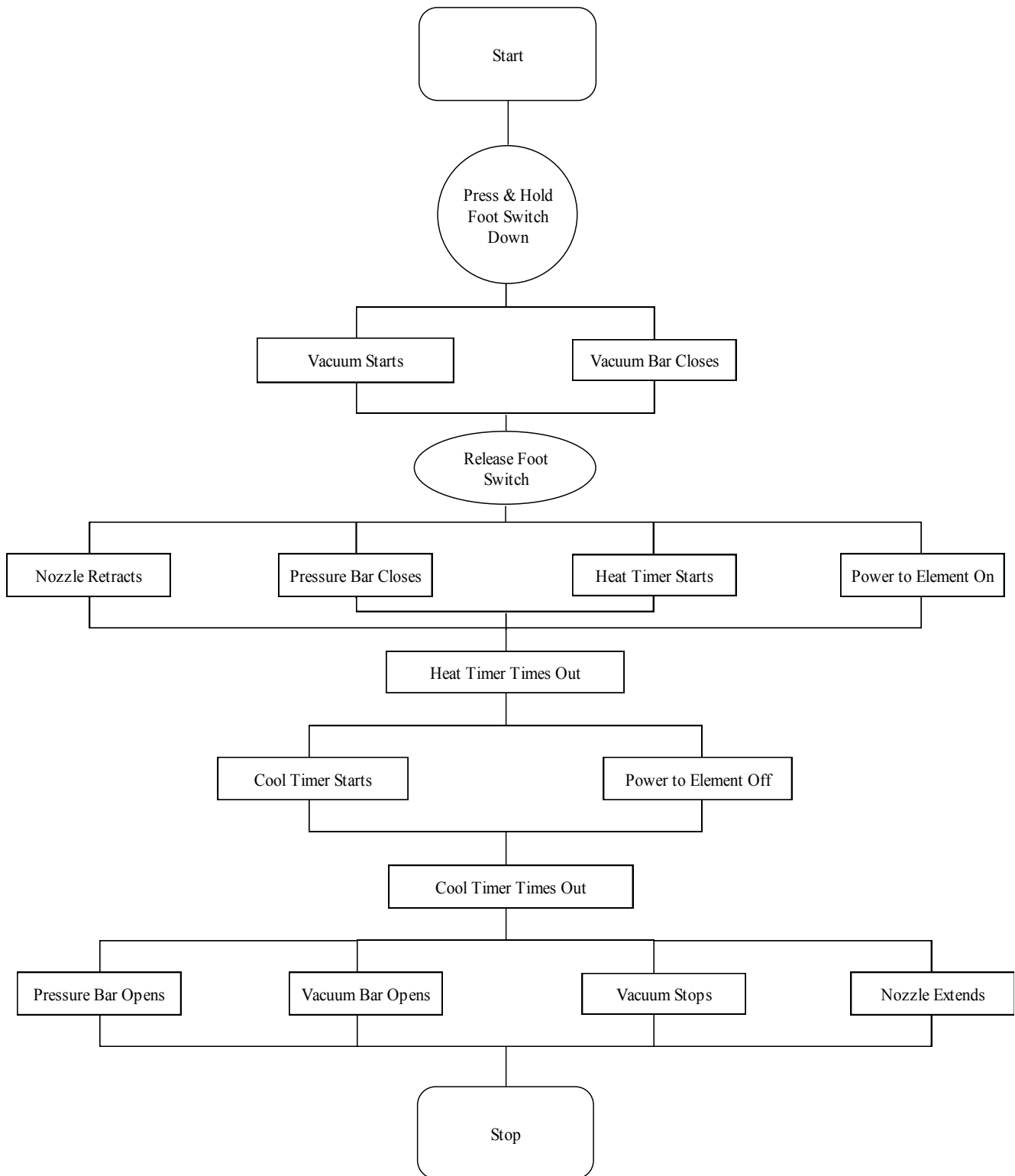


Figure 2, Flowchart of Operational Process

Controls

OVERVIEW:

The combination of the Foot Switch, Heat Timer and Cool Timer allows the operator to remove the air from a bag and seal virtually any heat sealable pouch.

CONTROL DESCRIPTIONS & FUNCTIONS:

MAIN POWER SWITCH:

Turns the power to the machine ON and OFF.

FOOT SWITCH:

Controls the vacuum cycle and start of the seal cycle. To activate the vacuum cycle, press and hold the Foot Switch. To end the vacuum cycle, release the Foot Switch. Ending the vacuum cycle will begin the heat and cool cycle.

* **IMPORTANT:** When Setting the Heat Timer always begin with a setting of 2 seconds or less. Gradually increase the Heat time until desired seal is achieved. Cool Time is usually two times heat time. Ex: heat=2, Cool =4- 6

HEAT TIMER:

Controls the amount of time the element is heated. To increase the heat time, turn the Heat Timer knob clockwise. To decrease the heat time, turn the Heat Timer knob counterclockwise. Timer adjustments are set in seconds, up to 10 sec.

COOL TIMER:

Controls the amount of time the Pressure Bar remains closed for cooling. To increase the cool time, turn the Cool Timer knob clockwise. To decrease the cool time, turn the Cool Timer knob counterclockwise. Timer is set in Seconds, up to 60sec.

LED FUNCTIONS ON HEAT/COOL TIMERS:

- “PWR” indicates time is ACTIVE.
- “UP” indicates timer has timed-out.
- “UNLIT” indicates a timer not active.

NOTE:

If the Heat timer is set below 1, it will not work and the bars will not come down.

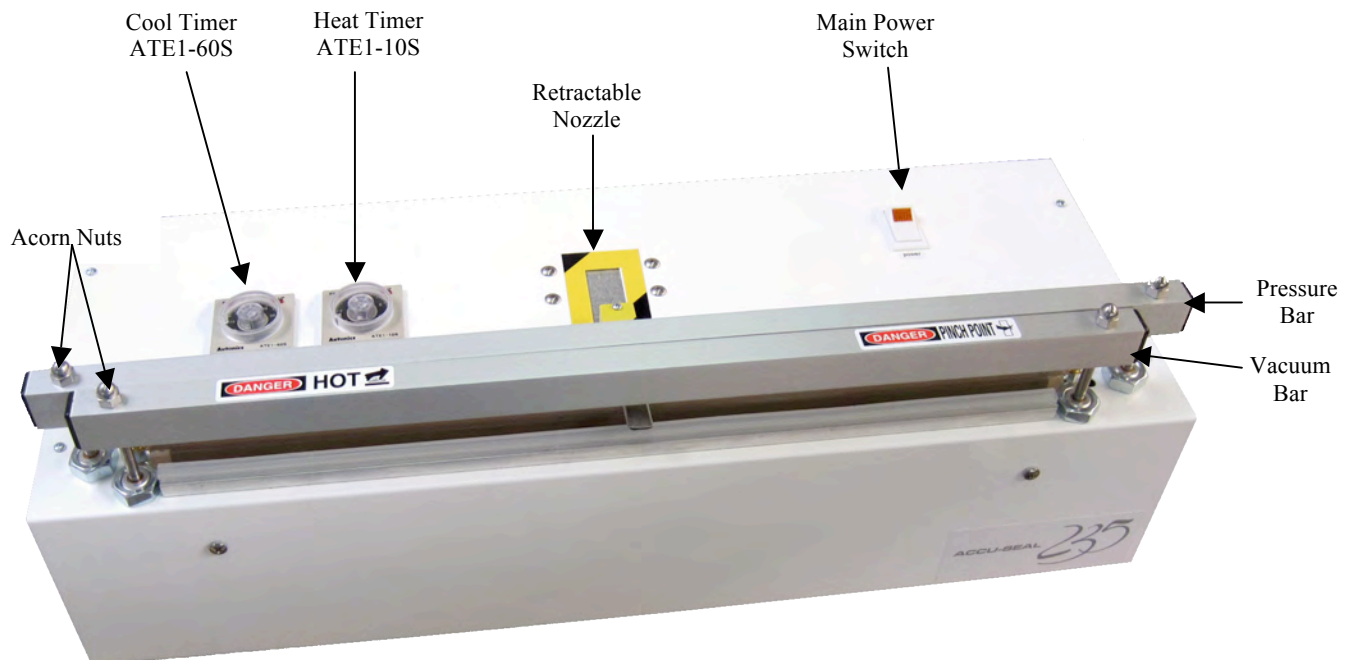


Figure 1, Top of Vacuum Sealer

* IMPORTANT: READ INSTRUCTIONS COMPLETELY PRIOR TO OPERATION

Operating Procedures

SET UP:

1. Place your SEALER on the surface where it is to be used. On the rear of the machine locate the "Air In" (75-85psi) port. DO NOT EXCEED 85 PSI.
2. Attach clean, dry air supply using 1/4" OD plastic tubing supplied with your sealer. **Figure 2A on page 5.**

⚡ CAUTION: DO NOT exceed 85 psi.
Verify air pressure.

3. Insert plug into wall outlet. A dedicated outlet is recommended. See Serial Tag on back of unit for power requirements.
4. Turn sealer "ON" by pressing the Main Power Switch. Set the Heat Timer to #2 (2 seconds) position and the Cool Timer at #1 (6 seconds).

START UP:

5. KEEPING FINGERS AWAY FROM SEAL JAW AREA, Press and release the Foot Switch. Sealing Jaws close and the Heat Timer Lamp lights. The Cool Timer Lamp comes on after the preset heat time. Jaw will reopen upon completion of the cooling cycle.

📖 NOTE:
Sealing cycle may be aborted at any time by turning "OFF" the Main Power Switch.

6. Repeat step # 4 twice to warm up sealer.

OPERATION:

1. Place the bag between the Seal Jaws and around the nozzle and simply press and hold the Foot Switch until the desired vacuum level is achieved. The sealing cycle will commence as soon as Foot Switch is released.
2. Remove the bag and inspect the seal. If the seal is weak, turn the Heat Timer to a slightly higher setting. Adjust Cool Time so plastic has time to set before the Pressure Bar reopens.

📖 NOTE:

To avoid over heating and to extend the life of the element set the Heat Timer at lowest number that will give the required seal. Slight adjustments may significantly change results.

3. At the end of each shift or production run turn the Sealer "OFF" by pressing the Main Power Switch.

MONITOR:

Continuously monitor the Seal Area. If the Seal Area overheats lower the heat time or increase the cool time.

VACUUM TIPS:

1. Set up: Attach the optional support tray, if available. It aligns the product with the nozzle. It also leaves the operator's hands free to work with the bag.
2. Height of worktable: Standard table height. Comfortable for operator at about waist level. Otherwise the bag may be out of alignment with the nozzle affecting the evacuation flow.
3. Move the product as close to the nozzle as possible without interfering with the front Vacuum Bar. The thickness of the product helps prevent the bag from collapsing in front of the nozzle. If your product is thick or bulky, position it somewhat further away from the vacuum jaw to prevent creases in the seal area.
4. Simultaneously as the vacuum jaw closes, gently pull the bag back and up away from the nozzle. Otherwise the bag can collapse in front of the nozzle, preventing further evacuation.
5. Practice the above processes by leaving the Heat Timer on 0 seconds and operating the machine's vacuum mode. This allows the operator to become familiar with the vacuum process without wasting bags.

Operator Maintenance

INSPECTIONS:

1. At the start of each shift or production run, inspect the Seal Jaw Area.
2. Visually and manually check the PTFE Fabric Zone Tape covering the element for wrinkles, bumps or burn marks. If any are present, the covering can be removed and reapplied to smooth them out. For burn marks replace with new PTFE Fabric Tape[®] covers.
3. If burn marks show in the PTFE Fabric Tape, also inspect the element for kinks or signs of overheating. If any exist, replace the element with the same length and width of element. Also check the Pressure Bar for burns and replace as necessary.
4. When replacing the element, check the PTFE Fabric Zone Tape and insulating backing of the EPA beneath the element. Replace if burns, bubbles or any other surface defects are apparent.

Cleaning

⚡ CAUTION:

Prior to any procedure, always unplug the machine. Do NOT immerse or hose down your Sealer. Use only wipe down cleaning procedures. Failure to follow these cleaning instructions can lead to premature machine failure, shock or fire hazard.

Use only denatured alcohol or soap and water to clean your Sealer.

Contact Uline technical service if your requirements call for other cleaning methods or solutions.

Troubleshooting

Problem	Action	Solution
No Green Power Light?	<ul style="list-style-type: none"> ◆ Check switch ◆ Check plug ◆ Check fuse ◆ Is machine operating? ◆ Has production increased? 	<ul style="list-style-type: none"> ◆ Make sure Power Switch is in the ON position ◆ Make sure power cord is plugged into 120VAC, 60 Hz outlet ◆ If burnt out replace fuse ◆ If yes, green lamp is out on the Main Power Switch. Replace the power switch. ◆ Machine has shutdown to prevent overheating. Turn off power & wait to allow machine to cool for ½ hour. Turn on Main Power. Call Uline if problem persists. ◆ Thermal cut-off protection is normal. Call Uline for options.
No/Poor Vacuum	<ul style="list-style-type: none"> ◆ Check incoming air pressure ◆ Check bag 	<ul style="list-style-type: none"> ◆ Incoming air pressure set to 75-85psi. ◆ Make sure bag is flat & crease free between vac seal jaws. Use both hands to support bag – note optional support tray may help when vacuuming larger/bulkier packages.
No Heat Poor seal/Weak seal	<ul style="list-style-type: none"> ◆ Increase heat time settings ◆ Check main power light ◆ Check element for hot spots, or burn through, right side of element extended all the way to the right 	<ul style="list-style-type: none"> ◆ See above ◆ Replace element.
No Heat	<ul style="list-style-type: none"> ◆ Check element finger nuts ◆ Check contact surfaces ◆ Check fuse, ◆ Was knob replaced recently? 	<ul style="list-style-type: none"> ◆ Make sure they are tight with no gaps ◆ Make sure all contact surfaces are clean ◆ If burnt out, replace fuse ◆ If yes, call Uline Corporation
No Cool/Bag sticks to seal jaw	<ul style="list-style-type: none"> ◆ Increase cool time ◆ Check the Pressure Bar & PTFE Fabric Zone Tape 	<ul style="list-style-type: none"> ◆ Replace if necessary
Gaps/Creases in the seal	<ul style="list-style-type: none"> ◆ Check bag ◆ Check element/ PTFE Fabric Zone Tape for bumps, hot spots, burns or creases 	<ul style="list-style-type: none"> ◆ Make sure bag is flat when vac jaw closes. ◆ Increase heat and cool times ◆ Reinstall or replace as necessary
Nozzle does not retract or extends too slow/fast	<ul style="list-style-type: none"> ◆ Check incoming air pressure ◆ Adjust Nozzle Extend Flow Control 	<ul style="list-style-type: none"> ◆ Incoming air pressure set at 75-85 psi ◆ Reduce/increase opening in Nozzle Extend Flow Control (Figure 23-1) to slow down/speed up nozzle extend.
The Pressure Bar does not close/ one side sticks open	<ul style="list-style-type: none"> ◆ Realign the Pressure Bar pistons 	<ul style="list-style-type: none"> ◆ Disconnect air pressure, close jaw by hand, loosen then retighten the Pressure Bar piston nuts to realign.
Premature element burn out/ Element is sparking	<ul style="list-style-type: none"> ◆ Check procedure for proper element replacement 	<ul style="list-style-type: none"> ◆ When replacing element be sure flaps are facing UP. Make sure nuts are tight & there are no gaps.
Jaws do not close/	<ul style="list-style-type: none"> ◆ Check incoming air pressure 	<ul style="list-style-type: none"> ◆ Incoming air pressure set to 75-85 psi
Internal Hissing Sound	<ul style="list-style-type: none"> ◆ Normal during vacuum & seal cycle 	
Element Post turning black	<ul style="list-style-type: none"> ◆ Carbon build up 	<ul style="list-style-type: none"> ◆ Use emery cloth on finger nuts, posts and element ends to remove. Make sure nuts are tight and there are no gaps.

Maintenance Information

This section is for maintenance personnel only.

MAINTENANCE INFORMATION

* **IMPORTANT:** READ INSTRUCTIONS COMPLETELY PRIOR TO OPERATION

Introduction

This chapter is organized in four sections. The first section is a safety section that describes the general safety precautions you should take while you maintain the equipment. The second section provides a detailed description of the equipment.

The third section has all of the maintenance procedures you need to set up, adjust, maintain and inspect the equipment. The fourth section lists all consumables and wear parts that you need to maintain the equipment.

Throughout this chapter you will find three safety icons:

⚡ **CAUTION:** Represents possible dangers

* **IMPORTANT:** Represents important information to be aware of

📖 **NOTES:** Represents notes and special instructions. You should pay particular attention to these icons because they signal information that is important to your safety and to the correct operation of the equipment.

DISCLAIMERS:

Failure to follow the replacement procedures described in this chapter may result in shortening the operating life of the sealer. Using replacement parts other than those purchased through Uline could result in increased downtime, poor equipment performance and could void the warranty.

AUDIENCE:


This chapter is written for maintenance technicians who have successfully completed a certified mechanical apprentice program or who have equivalent maintenance experience.

CONTACT INFORMATION:

If any additional information is needed, contact Uline at (800) 295-5510.

Safety

⚡ CAUTION:
PRIOR TO PERFORMING ANY MAINTENANCE PROCEDURE, ALWAYS TURN THE MAIN POWER OFF, UNPLUG THE MACHINE AND DISCONNECT THE AIR SUPPLY. FAILURE TO DO SO CAN LEAD TO SERIOUS INJURY.

 On the Vacuum Sealer disconnect air at the source and operate the machine to make sure all remaining pressure is removed from the lines.

PRECAUTIONS:

To insure safe maintenance of the sealer, never leave machine unattended. Maintenance personnel should also be aware of pinch points and possible burn hazard near the Seal Jaw Area. Uline has provided warning stickers to alert maintenance personnel to this hazard.

Do not use flammable or toxic fluids such as gasoline, benzene or ether to clean the equipment.

Do not use lubricants when performing maintenance on the equipment.

Always use tools specified to perform maintenance on the equipment.

Do not bypass any warnings when performing maintenance on the equipment.

⚡ CAUTION:
Keep hands, fingers or flammable objects out of the Vacuum/Seal Jaw Area.

Equipment Description

The Vacuum Sealer is a pneumatic vacuum impulse heat sealer, controlled by analog Heat and Cool Timers while the vacuum time is controlled manually by depression of the Foot Switch. With tap to seal capability. The sealer comes standard with 1/4" seal width and 20" seal length.

Maintenance Schedule:

Inspection of PTFE Fabric Tape, element and overall machine operation should occur prior to each shift or production run. (See operator maintenance, page 8) Replace PTFE Fabric Tape covers and element as needed.

Maintenance Parts List

Consumables:

Uline recommends the following parts be maintained with a minimum quantity of two (2) each, to reduce production downtime.

1. 1/4" Standard Element
2. PTFE Fabric Tape Set
3. Element Pad Assembly
4. Pressure Bar PTFE Fabric Tape

When ordering parts you should have the full model number and serial number to assure the correct components are sent

Troubleshooting

Problem	Action	Solution
No Green Power Light?	<ul style="list-style-type: none"> ◆ Check switch ◆ Check plug ◆ Check fuse ◆ Is machine operating? ◆ Has production increased? 	<ul style="list-style-type: none"> ◆ Make sure Power Switch is in the ON position ◆ Make sure power cord is plugged into 120VAC, 60 Hz outlet ◆ If burnt out replace fuse ◆ If yes, green lamp is out on the Main Power Switch, replace the power switch. ◆ Machine has shutdown to prevent overheating. Turn off power & wait to allow machine to cool for ½ hour. Turn on Main Power. Call Uline if problem persists. ◆ Thermal cut-off protection is normal, Call Uline for options.
No/Poor Vacuum	<ul style="list-style-type: none"> ◆ Check incoming air pressure ◆ Check bag 	<ul style="list-style-type: none"> ◆ Incoming air pressure set to 75-85psi. ◆ Make sure bag is flat & crease free between vac seal jaws. Use both hands to support bag – note optional support tray may help when vacuuming larger/bulkier packages.
No Heat Poor seal/Weak seal	<ul style="list-style-type: none"> ◆ Increase heat time settings ◆ Check main power light ◆ Check element for hot spots, or burn through, right side of element extended all the way to the right 	<ul style="list-style-type: none"> ◆ See above ◆ Replace element.
No Heat	<ul style="list-style-type: none"> ◆ Check element finger nuts ◆ Check contact surfaces ◆ Check fuse, ◆ Was knob replaced recently? 	<ul style="list-style-type: none"> ◆ Make sure they are tight with no gaps ◆ Make sure all contact surfaces are clean ◆ If burnt out, replace fuse ◆ If yes, call Uline Corporation
No Cool/Bag sticks to seal jaw	<ul style="list-style-type: none"> ◆ Increase cool time ◆ Check the Pressure Bar & PTFE Fabric Zone Tape 	<ul style="list-style-type: none"> ◆ Replace if necessary
Gaps/Creases in the seal	<ul style="list-style-type: none"> ◆ Check bag ◆ Check element/ PTFE Fabric Tape for bumps, hot spots, burns or creases 	<ul style="list-style-type: none"> ◆ Make sure bag is flat when vac jaw closes. ◆ Increase heat and cool times ◆ Reinstall or replace as necessary
Nozzle does not retract or extends too slow/fast	<ul style="list-style-type: none"> ◆ Check incoming air pressure ◆ Adjust Nozzle Extend Flow Control 	<ul style="list-style-type: none"> ◆ Incoming air pressure set at 75-85 psi ◆ Reduce/increase opening in Nozzle Extend Flow Control (Figure 23-1) to slow down/speed up nozzle extend.
The Pressure Bar does not close/ one side sticks open	<ul style="list-style-type: none"> ◆ Realign the Pressure Bar pistons 	<ul style="list-style-type: none"> ◆ Disconnect air pressure, close jaw by hand, loosen then retighten the Pressure Bar piston nuts to realign.
Premature element burn out/ Element is sparking	<ul style="list-style-type: none"> ◆ Check procedure for proper element replacement 	<ul style="list-style-type: none"> ◆ When replacing element be sure flaps are facing UP. Make sure nuts are tight & there are no gaps.
Jaws do not close/	<ul style="list-style-type: none"> ◆ Check incoming air pressure 	<ul style="list-style-type: none"> ◆ Incoming air pressure set to 75-85 psi
Internal Hissing Sound	<ul style="list-style-type: none"> ◆ Normal during vacuum & seal cycle 	
Element Post turning black	<ul style="list-style-type: none"> ◆ Carbon build up 	<ul style="list-style-type: none"> ◆ Use emery cloth on finger nuts, posts and element ends to remove. Make sure nuts are tight and there are no gaps.

Maintenance Procedures

⚡ CAUTION:
PRIOR TO PERFORMING ANY MAINTENANCE PROCEDURE, ALWAYS TURN THE MAIN POWER OFF, UNPLUG THE MACHINE AND DISCONNECT THE AIR SUPPLY. FAILURE TO DO SO CAN LEAD TO SERIOUS INJURY.

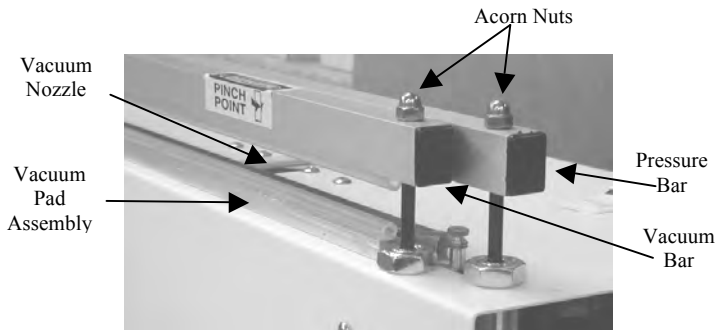


Figure 4A, Element Placement

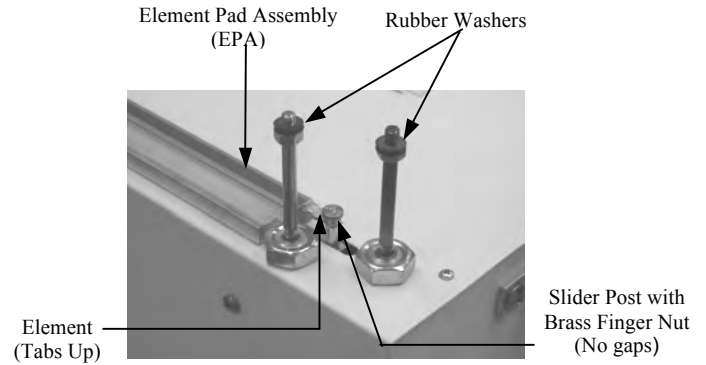


Figure 4B, Element Placement

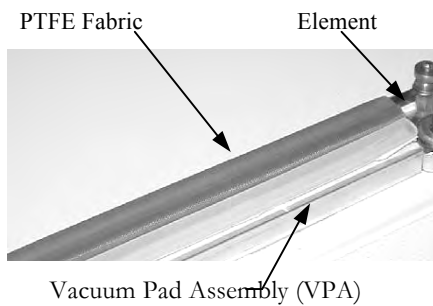


Figure 5, Element PTFE Tape

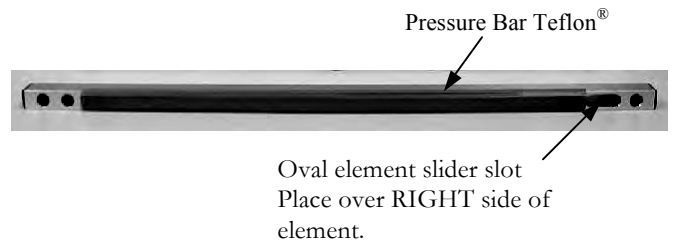


Figure 6, Pressure Bar

REPLACEMENT OF ELEMENT:

Items Required:
7/16" Wrench
PTFE Fabric Tape
Heating Element

Refer to figures 4-6 above.

1. Remove the Acorn Nuts on the Pressure Bar and the Vacuum Bar to give better access to the Element. (Requires 7/16" wrench, not included) **Figure 4A**
2. Remove the Pressure Bar and the Vacuum Bar. **Figure 4A**
3. Push the Vacuum Nozzle back. **Figure 4A**
4. Carefully remove the PTFE Fabric Zone Tape covering the element. **Figure 5**
5. Unscrew the brass finger nut on the stationary post on the left side of the element.
6. Located on the right side of the element is the Slider Assembly Post. Use the attached brass finger nut to push the slider to the left to ease tension on the element and remove the element from the stationary post on the left side. Then remove the brass finger nut and the element from the Slider Assembly Post. **Figure 4B.**
7. Examine the stack of washers on the element posts. Do not discard the stainless steel washers above and below the element.

REPLACEMENT OF ELEMENT (CONT'D):

8. Inspect the ½" ® Cover beneath the element for burns or wear and replace as needed.
Figure 4B
9. Place the new element on the Slider Post with the tabs facing UP. **Figure 4B**

CAUTION:

Placing tabs down can short out the machine.

10. Replace the brass finger nut on the Slider Assembly Post insuring there are no gaps between the nut, the element and the base of the post.
11. Push the Slider Assembly Post and the element to the left and install the element on the stationary post side.
12. Remove both adhesive backing strips from the PTFE Fabric Zone Tape and center the non-adhesive zone over the element. Make sure the PTFE Fabric Tape is under the nozzle.
13. Starting from the center of the element, smooth the PTFE Fabric Zone Tape toward each end to prevent unwanted creases and channels in the Seal Area.
14. Press the PTFE Fabric Tape firmly on both sides of the EPA to insure proper adhesion.
15. Inspect the Pressure Bar PTFE Fabric Tape for burns or wear. Replace as needed. **Figure 6.**
16. Reconnect 75-85psi air supply and replace the Pressure Bar with the oval element slider slot on the right side. **Figure 6.** Then replace the Vacuum Bar. Be sure to tighten the nuts until snug. DO NOT OVERTIGHTEN.

CAUTION:

Failure to place the oval slider slot on the right side can cause arcing, and may short out the machine.

* IMPORTANT:

Make sure to replace the rubber washer between the lower cylinder jam nut and the inside of the Pressure Bar. Failure to do so may cause the Pressure Bar to jam preventing jaw closure.

NOTE:

After repair is completed plug the machine in, and turn the machine "ON" by pressing the Main Power Switch.

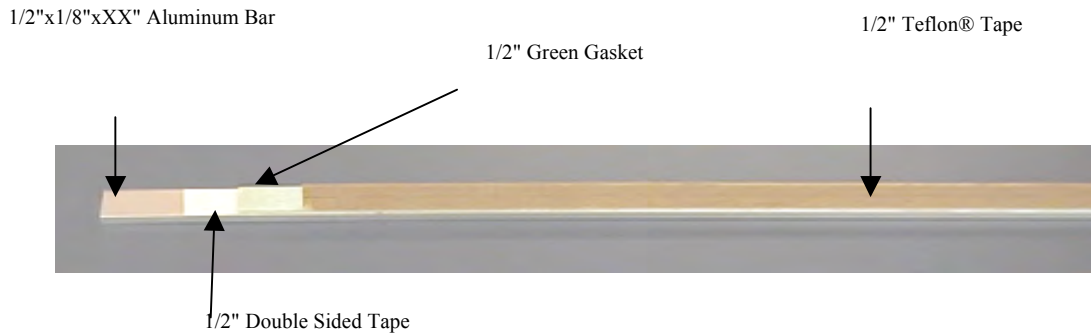


Figure 7, Element Pad Assembly (EPA)

REPLACEMENT OF ELEMENT PAD ASSEMBLY (EPA):

Items Required:

- 7/16" Wrench
- PTFE Fabric Zone Tape
- Element Pad Assembly
- Denatured Alcohol
- Cloth or Rag

Refer to figures 4-6 on page 14 and figure 7 above.

1. Follow steps 1-7 for replacing the element as described under "Replacement of Element".
2. Pull firmly on the Element Pad Assembly (EPA) until it is worked loose from the case. **Figure 7**
3. After the old EPA is loose, pull back the nozzle and remove the EPA. **Figure 7**

4. Remove any residual adhesive left on the machine.
5. Wipe down the EPA area with denatured alcohol.
6. Remove adhesive backing from the new EPA.
7. Center the EPA between the element posts and press lightly.
8. Follow steps 8-16 for replacing the element as described under "Replacement of Element".



NOTE:

After repair is completed plug machine in, and turn the machine "ON" by pressing the Power Switch.

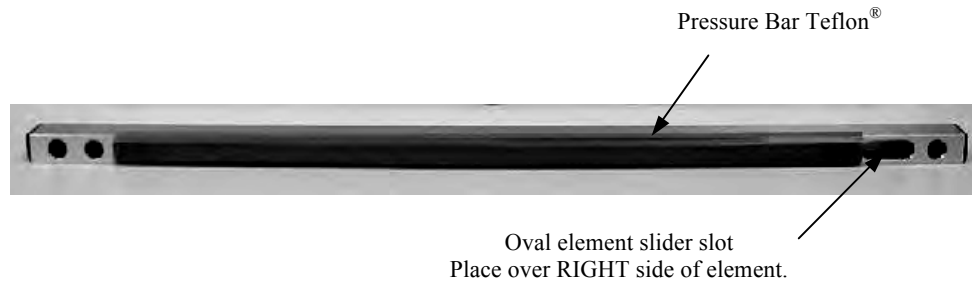


Figure 6, Pressure Bar

REPLACEMENT OF PRESSURE BAR COVER SET:

Items Required:

7/16" Wrench
 Pressure Bar Cover Set
 Cloth or Rag
 Denatured Alcohol

Refer to Figures 4-6 on page 14.

1. Remove the two (2) Acorn Nuts on the Pressure Bar. **Figure 4A**
2. Remove the Pressure Bar. **Figure 4A**
3. Remove the old Pressure Bar PTFE Fabric Tape and Red Rubber.
4. Remove all remaining adhesive.
5. Wipe down the Pressure Bar with denatured alcohol.
6. Remove adhesive backing from the new Red Rubber and apply to the Pressure Bar.
7. Remove adhesive backing from the 1 ½" Pressure Bar PTFE Fabric Tape.
8. Center the Pressure Bar PTFE Fabric Tape over the Red Rubber, press firmly from the center toward each end to remove all air bubbles.
9. When air bubbles are removed press sides of the Pressure Bar PTFE Fabric Zone Tape to adhere to the sides of the Pressure Bar. **Figure 6**
10. Reconnect 75-85psi air supply and replace the Pressure Bar with the oval element slider slot on the right side of the machine. Be sure to tighten nuts until snug. **DO NOT OVERTIGHTEN.**

⚡ CAUTION:

Failure to place the oval slider slot on the right side can cause arcing, and may short out the machine.

* IMPORTANT:

Make sure to replace the rubber washer between the lower cylinder jam nut and inside of the Pressure Bar. Failure to do so may cause the Pressure Bar to jam preventing jaw closure.

📖 NOTE:

After repair is completed plug machine in and turn the machine "ON" by pressing the Power Switch.

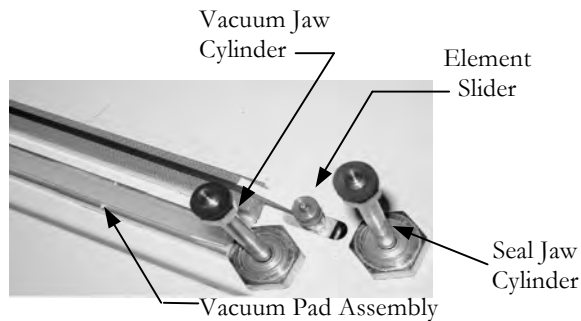


Figure 8, Vacuum Pad Assembly (VPA)

REPLACEMENT OF VACUUM BAR OR VACUUM PAD ASSEMBLY (VPA):

Items Required:

- 7/16" Wrench
- Cloth or Rag
- Denatured Alcohol
- Vacuum Pad Assembly

Refer to figures 4-6 on page 14 and figure 8 above.

This is only necessary when silicone tubing has come loose.

IMPORTANT:

Do not proceed until all required parts are in stock.

1. Remove the Acorn nuts on the Vacuum Bar. **Figure 4A**
2. Remove the Vacuum Bar. **Figure 4A**
3. Remove the silicone tubing and all the caulk material from the Vacuum Pad.
4. Clean the Vacuum Pad Assembly (VPA) surface with denatured alcohol. **Figure 8, above.**
5. Remove adhesive backing from the new VPA cover
6. Center the VPA cover over the old VPA.
7. Lightly press the VPA cover into place.
8. Inspect silicone tubing on upper Vacuum Bar.
9. Reconnect 75-85psi air supply and then replace the Pressure Bar with the oval element slider slot on the right side of the machine. Be sure to tighten nuts until snug. **DO NOT OVERTIGHTEN.**
10. Replace the Vacuum Bar. Be sure to tighten Acorn Nuts until snug. **DO NOT OVERTIGHTEN.**

*** IMPORTANT:**

Make sure to replace rubber washer between lower cylinder jam nut and inside of the Pressure Bar. Failure to do so may cause the Pressure Bar to jam preventing jaw closure.

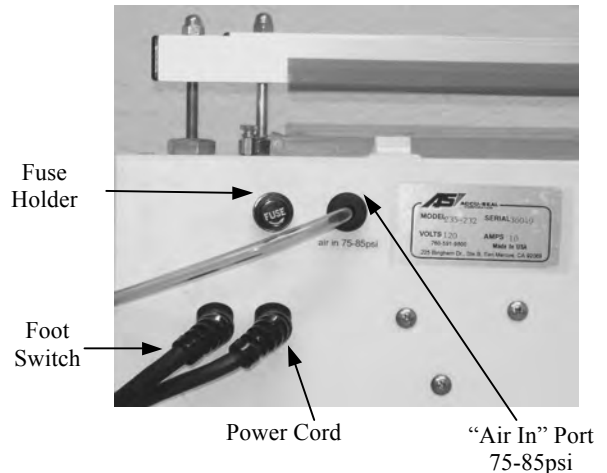


Figure 2B, Back of Vacuum Sealer (Close-up View)

REPLACEMENT OF FUSE:

CAUTION:

For continued protection against risk of fire, replace with same type and rating of fuse listed on the serial tag. Unplug the machine prior to performing any procedure.

1. Locate the fuse holder on back of the machine. **Figure 2B.**
2. Twist and remove the cap.
3. Remove the fuse.
4. Replace the fuse with the same type and rating.
5. Twist and secure the cap.

NOTE:

After maintenance is completed plug in the machine and turn "ON" by pressing the Main Power Switch.

Repair Information

This section is for repair personnel only.

REPAIR INFORMATION

Introduction

This chapter is organized in five sections. The first section is a safety section that describes the general safety precautions you should take when you repair the equipment. The second section provides a detailed description of the equipment. In addition the theory of operation is described.

The third section is the troubleshooting section. This table references you to specific repair procedures found in section four.

The fourth section includes repair procedures. These procedures are organized by equipment component. The fifth section lists all repair parts you will need to repair the equipment.

Throughout this chapter you will find three safety icons:

⚡ **CAUTION:** Represents possible dangers

* **IMPORTANT:** Represents important information to be aware of

📖 **NOTES:** Represents notes and special instructions. You should pay particular attention to these icons because they signal information that is important to your safety and to the correct operation of the equipment.

DISCLAIMERS:

Failure to follow the replacement procedures described in this chapter may result in shortening the operating life of the Vacuum Sealer. Using replacement parts other than those purchased through Uline could result in increased downtime, poor equipment performance and could void the warranty. This chapter should not be considered all-inclusive regarding repair procedures.

AUDIENCE:

This chapter is designed for use by qualified repair technicians. No other personnel should be permitted to work on this equipment.

CONTACT INFORMATION:

If any additional information is needed contact Uline at (800) 295-5510.

Safety

To insure safe repair of the Vacuum Sealer, never leave machine unattended. Repair personnel should also be aware of pinch points and possible burn hazard near Seal Jaw Area. Uline has provided warning stickers to alert repair personnel to this hazard.

⚡ CAUTION:

Prior to any repair procedure, always unplug the machine and disconnect the air supply. Failure to do so could result in electrical shock, severe injury or equipment damage.

Do not use the Main Power Switch as the sole means of isolating power to the machine. Unplug machine before undertaking repairs.

⚡ CAUTION:

Keep hands, fingers or flammable objects out of Vac/Seal Jaw Area.

Theory of Operation:

When the Main Power Switch is on, power is provided to the Foot Switch's normally open and normally closed contacts and the Latching Relay's normally open contacts.

When the Foot Switch is depressed, power is provided to the Latching Relay Coil. When Latching Relay is energized the relay's normally open contacts close providing power to the vac valve. When the vacuum valve is activated, vac jaw closes and vacuum is drawn through the nozzle.

When the Foot Switch is released the nozzle retracts, the vacuum valve and relay latching remain activated through the Cool Timer's normally closed contacts. The main valve is activated; this closes the Seal Jaw. Power is provided to the transformers and sent through the element. When Heat Timer times out the Heat Timer relay opens, power is removed from the transformers and element. The Cool Timer is activated.

When the Cool Timer times out, the Cool Timer's normally closed contacts open, the relay is deactivated, and the vacuum valve and main valve are deactivated. The Pressure Bar and the Vacuum Bar opens, and the Nozzle extends.

Parts and their Function

Cool Timer:

Controls the amount of time before the Seal Jaw is released, completing the cycle.

Element:

Metal (nicrome) strip attached between two posts by washers. When current is applied it generates an impulse of heat.

Foot Switch:

While the Foot Switch is depressed the sealer will evacuate air from the bag through the nozzle. When released the nozzle will retract and the Seal Jaws will close to begin the seal cycle.

Heat Timer:

Controls the amount time current is applied to the element.

Nozzle:

Stainless Steel construction maintains open passageway for air to be evacuated from the bag.

Main Power Switch:

Power indicator.

Pressure Bar:

Applies pressure to the bag over the element.

PTFE Fabric Tape:

Prevents bag material from adhering to the Element or Pressure Bar. Heat resistant up to 550°F. Also called PTFE Fabric Tape

Vacuum Bar:

Holds bag in place creating a temporary airtight seal around the nozzle while inserted in the bag.

Troubleshooting

Problem	Action	Solution
No Green Power Light?	<ul style="list-style-type: none"> ◆ Check switch ◆ Check plug ◆ Check fuse ◆ Is machine operating? ◆ Has production increased? 	<ul style="list-style-type: none"> ◆ Make sure Power Switch is in the ON position ◆ Make sure power cord is plugged into 120VAC, 60 Hz outlet ◆ If burnt out replace fuse ◆ If yes, green lamp is out on the Main Power Switch, replace the power switch. ◆ Machine has shutdown to prevent overheating. Turn off power & wait to allow machine to cool for ½ hour. Turn on Main Power. Call Uline if problem persists. ◆ Thermal cut-off protection is normal, Call Uline for options.
No/Poor Vacuum	<ul style="list-style-type: none"> ◆ Check incoming air pressure ◆ Check bag 	<ul style="list-style-type: none"> ◆ Incoming air pressure set to 75-85psi. ◆ Make sure bag is flat & crease free between vac seal jaws. Use both hands to support bag – note optional support tray may help when vacuuming larger/bulkier packages.
No Heat Poor seal/Weak seal	<ul style="list-style-type: none"> ◆ Increase heat time settings ◆ Check main power light ◆ Check element for hot spots, or burn through, right side of element extended all the way to the right 	<ul style="list-style-type: none"> ◆ See above ◆ Replace element.
No Heat	<ul style="list-style-type: none"> ◆ Check element finger nuts ◆ Check contact surfaces ◆ Check fuse, ◆ Was knob replace recently? 	<ul style="list-style-type: none"> ◆ Make sure they are tight with no gaps ◆ Make sure all contact surfaces are clean ◆ If burnt out, replace fuse ◆ If yes, call Uline Corporation
No Cool/Bag sticks to seal jaw	<ul style="list-style-type: none"> ◆ Increase cool time ◆ Check the Pressure Bar & PTFE Fabric Zone Tape 	<ul style="list-style-type: none"> ◆ Replace if necessary
Gaps/Creases in the seal	<ul style="list-style-type: none"> ◆ Check bag ◆ Check element/ PTFE Fabric Tape for bumps, hot spots, burns or creases 	<ul style="list-style-type: none"> ◆ Make sure bag is flat when vac jaw closes. ◆ Increase heat and cool times ◆ Reinstall or replace as necessary
Nozzle does not retract or extends too slow/fast	<ul style="list-style-type: none"> ◆ Check incoming air pressure ◆ Adjust Nozzle Extend Flow Control 	<ul style="list-style-type: none"> ◆ Incoming air pressure set at 75-85 psi ◆ Reduce/increase opening in Nozzle Extend Flow Control (Figure 23-1) to slow down/speed up nozzle extend.
The Pressure Bar does not close/ one side sticks open	<ul style="list-style-type: none"> ◆ Realign the Pressure Bar pistons 	<ul style="list-style-type: none"> ◆ Disconnect air pressure, close jaw by hand, loosen then retighten the Pressure Bar piston nuts to realign.
Premature element burn out/ Element is sparking	<ul style="list-style-type: none"> ◆ Check procedure for proper element replacement 	<ul style="list-style-type: none"> ◆ When replacing element be sure flaps are facing UP. Make sure nuts are tight & there are no gaps.
Jaws do not close/	<ul style="list-style-type: none"> ◆ Check incoming air pressure 	<ul style="list-style-type: none"> ◆ Incoming air pressure set to 75-85 psi
Internal Hissing Sound	<ul style="list-style-type: none"> ◆ Normal during vacuum & seal cycle 	
Element Post turning black	<ul style="list-style-type: none"> ◆ Carbon build up 	<ul style="list-style-type: none"> ◆ Use emery cloth on finger nuts, posts and element ends to remove. Make sure nuts are tight and there are no gaps.

Repair Procedures

CAUTION:
PRIOR TO PERFORMING ANY REPAIR PROCEDURES, ALWAYS TURN THE MAIN POWER OFF, UNPLUG THE MACHINE AND DISCONNECT THE AIR SUPPLY. FAILURE TO DO SO CAN LEAD TO SERIOUS INJURY.

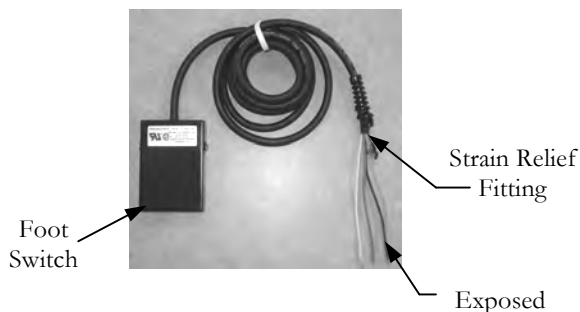


Figure 9, Foot Switch with Strain Relief



Figure 10, End Cap



Figure 11, Ring Cap

REPLACEMENT OF FOOT SWITCH:

Items Required:

Phillips Head Screwdriver
Strain Relief Pliers
Wire Cutters
Solder Iron & Solder
Crimping Tool
Foot Switch
End Caps (3) - **Figure 10**
Ring Cap - **Figure 11**
Strain Relief

1. Remove the 4 screws on top of unit.
2. Remove the 6 footed screws from the base of the unit.
3. Prepare the new Foot Switch by removing the outer insulation and fibrous cords (5-6") Exposing 4 insulated wires. Red, Black, White and Green.
4. Put wires through the Strain Relief. **Figure 9**

5. Prepare wires by removing ¼" of insulation.
6. Locate the old Foot Switch Cord and remove the Strain Relief from the case. Pay close attention to the color and location of each wire. Refer to figures 25 & 26 in back of this chapter for Foot Switch operation and wiring details.
7. Using wire cutters cut the red, black and white wires from the old Foot Switch inside the case at the terminal ends.
8. Remove the nut holding the green wire to the case ground stud.
9. Pull the old Foot Switch through the case.
10. Prepare wires in step #7 by removing ¼" of insulation.
11. Push the new Foot Switch cord through the case.
12. Place the Strain Relief at the edge of the stripped outer casing and mount to the case.
13. Crimp the Ring Cap on the end of the green wire. Reattach to case. Put both green wires under the nut.
14. Solder the new Foot Switch red wire to the black wire that was attached to the old red wire. Crimp the End Cap over the soldered junction. Repeat until all wires are connected properly. Refer to figures 25 & 26 in back of this chapter.
15. Plug the machine in and reconnect 75-85psi air supply to test operation. If operation is successful, disconnect air and power and reassemble the case.

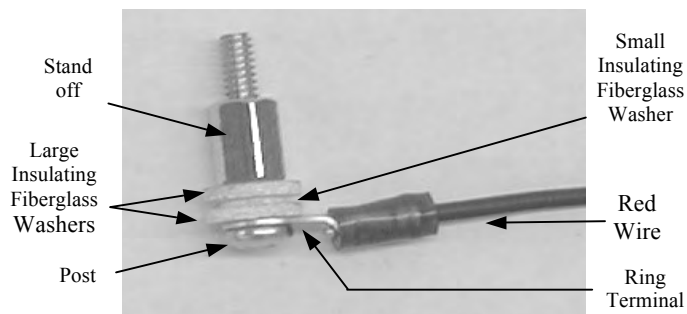


Figure 12A, Insulated Stud Assembly

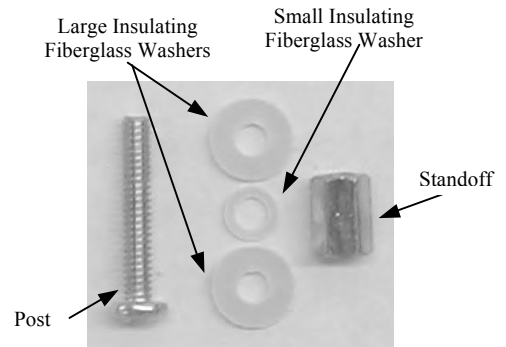


Figure 12B, Insulated Stud Assembly Components

REPLACEMENT OF INSULATED STUD ASSEMBLY:

Items Required:

- Phillips Head Screwdriver
- 1/4" Nut Driver
- Wire Cutters
- Solder Iron & Solder
- Element Post
- Large Insulating Fiberglass Washers (2)
- Small Insulating Fiberglass Washer - **Figure 12B**
- Red Lead with Crimp Fitting
- Wires Ties (5)
- Peanut - **Figure 14**

1. Remove the 4 screws on top of the unit.
2. Remove the 6 footed screws from the base of the unit and remove the top of the case.
3. Remove the element, set aside & save if in good condition.
4. Inside the case, locate the Insulated Stud Assembly. It will have a red lead wire to it. Trace this red wire to the orange peanut at the transformers.
Figure 23, Page 33
5. Cut off the orange peanut with the red wire in it.
6. Trim 1/4" of insulation, tin with solder and insert into new peanut.
7. Using 1/4" nut driver and Phillips head screwdriver, remove and discard the stationary post and red lead wire.

CAUTION:

To avoid shock hazard make sure the Insulated Stud Assembly is electrically insulated from case by using the three fiberglass (2 large, 1 small) washers to separate the stud from the case. **Figure 12A**

8. Pass screw through the red wire crimp fitting, then place a fiberglass insulated washer on.
9. Place screw with large insulating fiberglass washer through case. (Fiber washer will be flush to the case).
10. Keeping pressure on the element post and large insulating fiberglass washer while through the case, add small fiberglass washer. This will fit over the Stud Assembly through the case and lay flush between the first large fiberglass washer and the top of the case.
11. Install the 2nd large insulating fiberglass washer and the standoff. Tighten so that the large fiber washers are flush to the case.
12. Re-route the red wire to the transformer and trim excess wire. Refer to figures 23 & 26 in back of this chapter.
13. Remove 1/4" insulation from end, tin with solder and insert in orange peanut, at the transformers with other red wires.
14. Re-secure with wire ties provided.
15. Re-install the element and the PTFE Fabric Tape[®] Cover as described on page 14.
16. Plug the machine in and reconnect 75-85psi air supply to test operation. If operation is successful, disconnect air and power and reassemble the case.

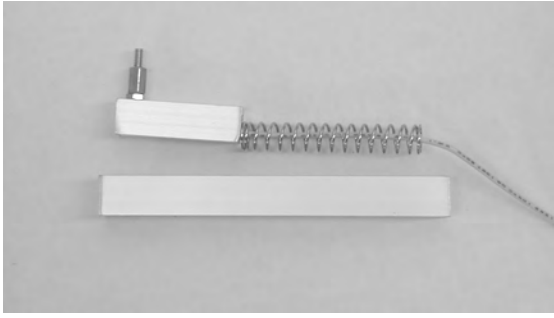


Figure 13, Slider Assembly



Figure 14, Peanut

REPLACEMENT OF ELEMENT SLIDER ASSEMBLY:

Items Required:

- Phillips Head Screwdriver
- 5/16" Nut Driver
- Wire Cutters
- Solder Iron & Solder
- Slider Assembly - **Figure 13**
- Peanut - **Figure 14**
- Wire Ties (4)

1. Remove the screws on the top of the unit.
2. Remove the 6 footed screws from the base of the unit and remove the top of the case.
3. Remove the PTFE Fabric Tape and the element. Set both aside & save if in good condition.
4. Inside the case, locate the Element Slider Assembly. It will have a yellow lead wire to it. Trace this yellow wire to the orange peanut at the transformers. **Figure 23, Page 33**
5. Cut off the orange peanut with the yellow wire in it. Strip ¼" of insulation off the transformer wires and tin them with solder.
6. Using the new peanut provided, re-insert the tinned ends of wire into the peanut.
7. Using 5/16" nut driver, remove the nut on the old element slider.
8. Remove the element slider from the case.
9. To re-install the new slider, ensure the spring is compressed against the post in the case that the nut to secure it is on and that the post of the slider is through the slotted hole in the case.
10. Re-secure the slider with the nut and 5/16" nut driver.
11. Re-route the yellow wire to the transformers and peanut with yellow transformer wires. Refer to figure 26 in back of this chapter.
12. Trim excess yellow wire and remove ¼" of the insulation, tin with solder and insert in the peanut with the other yellow wires.
13. Re-secure with wire ties provided.
14. Re-install the element and the PTFE Fabric Zone Tape as described on page 14.
15. Plug the machine in and reconnect 75-85psi air supply to test operation. If operation is successful, disconnect air and power and reassemble the case.

*** IMPORTANT:**

Prior to removing the element slider, note the original installation.



Figure 15, Time



Figure 16, 8-pin Black Socket

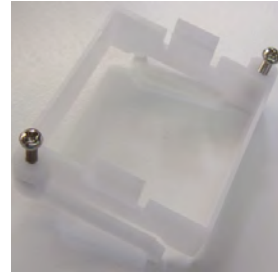


Figure 17, Timer Bracket

REPLACEMENT OF HEAT OR COOL TIMER:

Items Required:

- Phillips Head Screwdriver
- Two Flat Head Screwdrivers
- Timer
- Bracket (Recommended) - **Figure 17**

1. Remove the 4 screws on top of the unit.
2. Remove the 6 footed screws from the base of the unit and remove top of the case.
3. Locate the Timer to be changed. **Figure 15**
4. By hand carefully pry the 8-pin black socket from the Timer. **Figure 16**. Be careful not to break the soldered connections.
5. Using two flat head screwdrivers, wedge a screwdriver between the Timer body and bracket clip on both sides. Then push the Timer from the case.
6. Insure that new timer range window coincides with timer being replaced. (i.e. 10 sec heat time, 60 sec. cool time, etc.)
7. Orient timer in slot so that timer is upright and readable when machine is in operating position. **Figure 15**
8. Slide bracket over timer with the square side facing the inside of the case.
9. Push the bracket against the case and the timer into the case until the timer is locked against the case. Tighten Phillips screws
10. Align and press firmly until 8-pin black socket is fully seated.
11. Plug the machine in and reconnect 75-85psi air supply to test operation. If operation is successful, disconnect air and power and reassemble the case.



NOTE:

Timers are held in place with a plastic bracket. Locking clips are on opposite sides of the Timer. Loosen two Phillips screws.

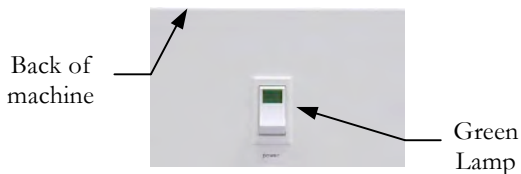


Figure 18, Main Power Switch



Figure 19, Latching Relay

**REPLACEMENT OF
MAIN POWER SWITCH:**

Items Required:

Phillips Head Screwdriver
Solder Iron & Solder
Solder Wick
Razor Knife
Silicon Adhesive
Main Power Switch

1. Remove 4 screws on top of unit.
2. Remove 6 footed screws from base of unit and remove top of case.
3. Locate the Main Power Switch. **Figure 23, Page 33**
4. Take note and mark locations of wires.
5. Desolder all wires with solder wick and remove from posts.
6. Cut silicon adhesive and remove the failed power switch.
7. Install the new power switch. Check orientation of green lamp, it should be toward the back of the machine. **Figure 18**
8. Apply silicon adhesive between inner case and switch body and allow to dry for approximately 24 hours.
9. Re-solder correct leads to their respective posts. Refer to notes taken in step 4. See wiring diagram in the back of this chapter.
10. Plug machine in and reattach air supply to test operation. If operation is successful, disconnect the air and power and reassemble case.

REPLACEMENT OF LATCHING RELAY:

Items Required:

Phillips Head Screwdriver
Solder Iron & Solder
Solder Wick
Super Glue or Quick Set Epoxy
Latching Relay

1. Remove 4 screws on top of unit.
2. Remove 6 footed screws from base of unit and remove top of case.
3. Locate the Latching Relay. **Figure 23, Page 33.**
4. Take note of wire locations. Tape off wires to designate positions of each wire on the relay. Refer to figures 25 & 26 in back of this chapter for wiring details.
5. Use solder wick to remove solder from posts on bottom of relay.
- * **IMPORTANT:**
Do not cut wires from posts. There will not be sufficient wire to reattach new latching relay.
6. Note orientation of relay for proper installation of new relay. Remove relay from case.
7. Use super glue or quick dry epoxy to adhere new relay to case.
8. Re-solder wire connections to the proper post on the relay. Refer to notes in step #4.
9. Plug the machine in and reconnect 75-85psi air supply to test operation. If operation is successful, disconnect air and power and reassemble the case.



**Figure 20, Seal Jaw/Nozzle
Retract Valve**

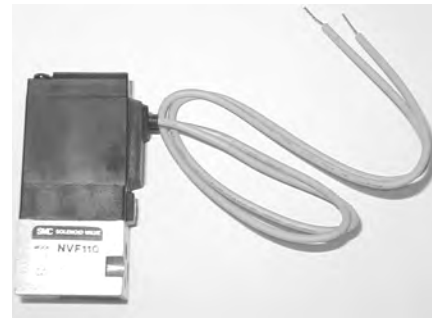


Figure 21, Vac/Vac Jaw Valve

**REPLACEMENT OF SEAL JAW/NOZZLE
RETRACT VALVE OR VAC/VAC JAW VALVE:**

Items Required:

Phillips head screwdriver
Wire cutters
Solder iron & solder
11/32" Nut driver
Crimping tool
Heat gun
Razor knife or Exacto knife
Valve w/fittings & tubing - **Figure 20 or 21**
End caps (2)
Wire ties (5)

1. Remove 4 screws on top of unit.
2. Remove 6 footed screws from base of unit and remove top of case.
3. Locate valve that needs to be replaced. Follow the leads to the white plastic end caps. **Figure 20 or 21**. Also refer to figure 26 for tubing routing.
4. Cut the end caps off keeping wire bundles together. Bundle one will have 2 gray leads and two white leads. Bundle two will have one black and one gray lead.
5. Pull wires which go to the valve out and strip ¼" insulation on remaining wires.
6. Cut tubing away from bayonet fittings but as close to fittings as possible.
7. Remove the nuts securing the valve to the case with the 11/32" nut driver. Retain the securing screws and nuts.
8. Remove old valve and discard or if under warranty, return to Uline for proper credit.
9. Using screws and nuts from old valve, mount the new valve to the case.
10. Refer to Figure 26 in the back of this chapter. Route the leads to the location of the old end caps. Remove ¼" insulation and solder one (1) lead to each of the wire bundles. Bundle one will have 2 gray leads and two white leads. Bundle two will have one black and one gray lead.
11. After connections are soldered, use end cap to insulate and cover the soldered joints and crimp in place.
12. Use wire ties to secure leads to the case.
13. Reconnect pneumatic tubing as follows. Refer to figure 24. Using heat gun, warm tubing ends until warm to the touch (115° F), then slide over fitting(s).
 - ☛ DO NOT OVERHEAT TUBING.
14. Plug the machine in and reconnect 75-85psi air supply to test operation. If operation is successful, disconnect air and power and reassemble the case.



Figure 22, Thermal Cut-off Transformer

REPLACEMENT OF THERMAL CUT-OFF TRANSFORMER:

Items Required:

Phillips Head Screwdriver
11/32" Nut Driver
Wire Cutters
Solder Iron & Solder
Thermal Cut-off Transformer - **Figure 22**
Peanuts (5)
Wire Ties (8)
End Caps (2)

1. Remove 4 screws on top of unit.
2. Remove 6 footed screws from base of unit and remove top of case.
3. Locate the TC transformer. The TC transformer will have 2 additional wires, black with a white stripe. **Figure 23, Page 33.**
4. Refer to figure 28 in back of this chapter. Trace the black and white striped wires to the white crimped end caps. Cut the solid black wires as close to the end caps as possible. Strip 1/4" insulation from the cut black wires. See wiring diagram in the back of this chapter.
5. Cut off peanuts.
6. Trim 1/4" of insulation, tin with solder and insert into new peanut.
7. Using 11/32" nut driver and Phillips screwdriver remove mounting screws and discard faulty transformer.
8. To install new transformer remove 1/4" insulation and tin ends of transformer wires.
9. Mount transformers to case using old screws and nuts.
10. Gather all like colored wires and insert them in orange peanuts. (All reds in one peanut, all yellows in another peanut, etc.)
11. Take black and white leads from the TC transformer and run to the black bare leads from step #5, wrap together, solder, place end cap on and crimp.
12. Use wire ties to secure leads to the case.
13. Plug the machine in and reconnect 75-85psi air supply to test operation. If operation is successful, disconnect air and power and reassemble the case.

DESCRIPTION OF REPLACEMENT PARTS

➤ **Prior to ordering replacement parts please have full model and serial number for your machine. These are located on the silver and black tag on the back of your machine.**

Element Pad Assembly (EPA):

The Element Pad Assembly is located under the Heating Element. It is a piece of aluminum covered with green gasket material and 1/2" wide PTFE Fabric Tape.

VPA (Vacuum Pad Assembly):

The vacuum pad assembly is the pad in front of the element. It is an aluminum strip with clear silicone tubing to hold the bag in place during the vacuum cycle. Available for machines with vacuum capability only.

Brass Finger Nuts:

Round nuts for securing the element to the element post.

Heating Element:

Nicrome strip or wire which current passes through. Needs to be covered with a 1 1/2" wide strip of PTFE Fabric Zone Tape w/non-adhesive down the center.

Description of Heating Element:

Standard 1/4" wide nicrome heat strip with end lugs attached. **IMPORTANT** overlap of element must be facing **upward**.

DESCRIPTION OF REPLACEMENT PARTS (CONT'D)

- Prior to ordering replacement parts please have full model and serial number for your machine. These are located on the silver and black tag on the back of your machine.

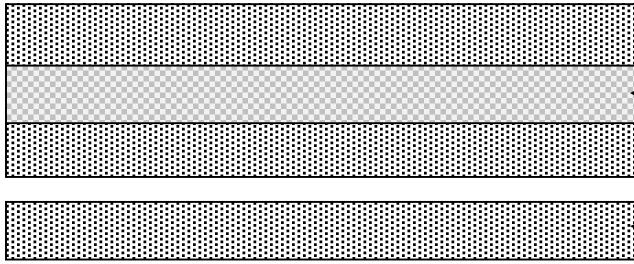
PTFE Fabric Tape Set:

Includes 2 strips of PTFE Fabric Tape:

1 ½" strip PTFE Fabric Zone Tape with
½"NON

Adhesive center for **OVER** the element.

½" strip PTFE Fabric Tape for **UNDER** the



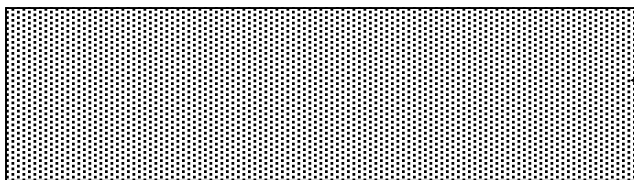
element.

1 ½" PTFE Fabric Zone Tape with ½" **NON-Adhesive** center for **OVER** the element. This tape has a non-adhesive center to prevent premature element failure.

½" strip of PTFE Fabric Tape for **UNDER** the element.

Pressure Bar PTFE Fabric Tape:

1 ½" fully adhesive strip of PTFE Fabric Tape to cover the Pressure Bar



1 ½" fully adhesive PTFE Fabric Tape for over the Pressure Bar

PTFE Fabric Tape by the Roll:

½" PTFE Fabric for **UNDER** the element.

1 ½" PTFE Fabric Zone Tape with non-adhesive center for **OVER** the element

1 ½" full adhesive Pressure Bar PTFE Fabric Tape to cover the Pressure Bar

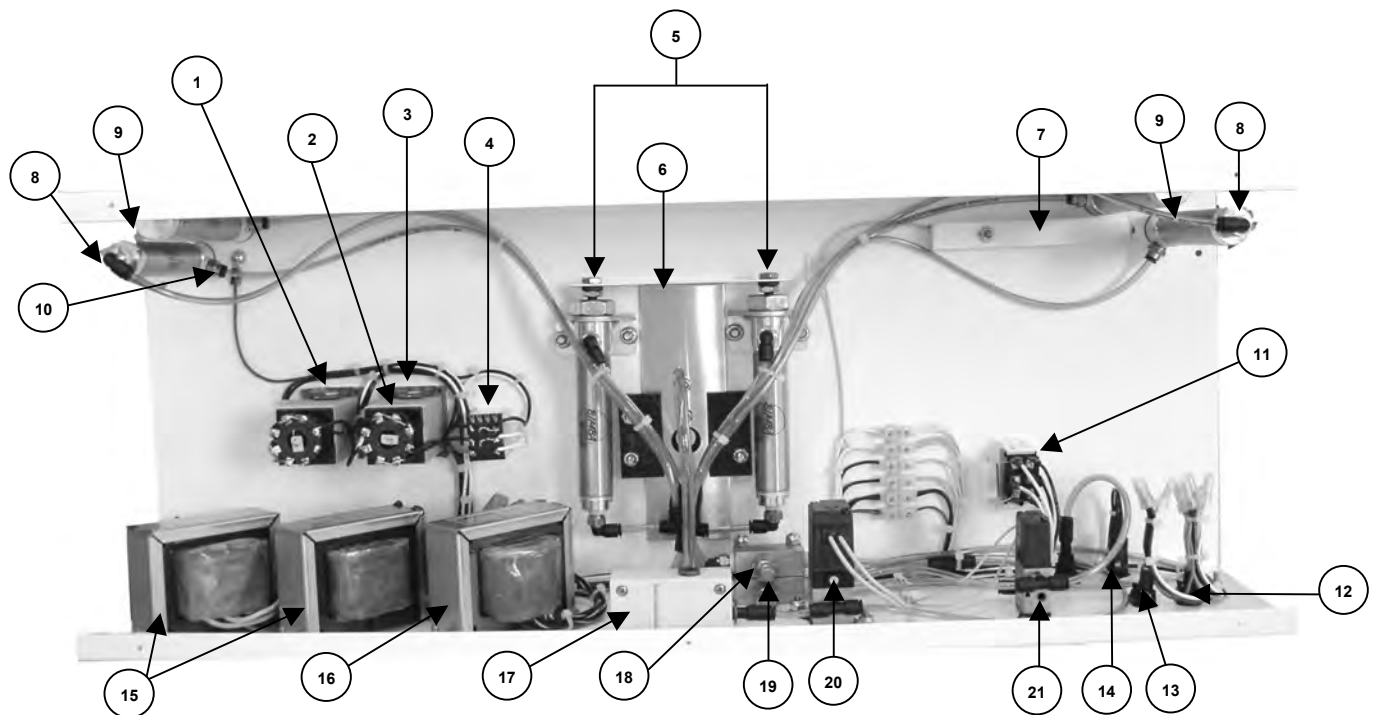
SJSK (Seal Jaw Service Kit):

2 Brass Finger Nuts
1 Element
1 PTFE Fabric TapeSet
1 EPA
1 Pressure Bar Insert

VJSK (Vacuum Jaw Service Kit):

1 Vacuum Bar Assembly
1 VPA
2 Acorn Nuts

Appendix



ITEM NO.	QTY.	DESCRIPTION
1	1	Cool Timer
2	1	Heat Timer
3	2	Timer Bracket
4	1	Latching Relay
5	2	Nozzle Retract Cylinders
6	1	Nozzle Carrier
7	1	Slider Assembly
8	2	Seal Jaw Cylinder
9	2	Vacuum Jaw Cylinder
10	1	Insulated Stud Assembly
11	1	Main Power Switch
12	1	Foot Switch
13	1	Power Cord
14	1	Fuse
15	2	Power Transformers (Varies by Element)
16	1	Thermal Cut-Off Transformer
17	1	Vacuum Ejector
18	1	Seal Jaw Close Flow Control (Should be open approx. 1-1/2 turns)
19	1	Nozzle Extend Flow Control (Should be open approx. 1-1/2 turns)
20	1	Vacuum Pump/Vac-Jaws Valve
21	1	Seal Jaw/Nozzle Retract Valve

Figure 23, Interior of Vacuum Sealer & Component Parts List

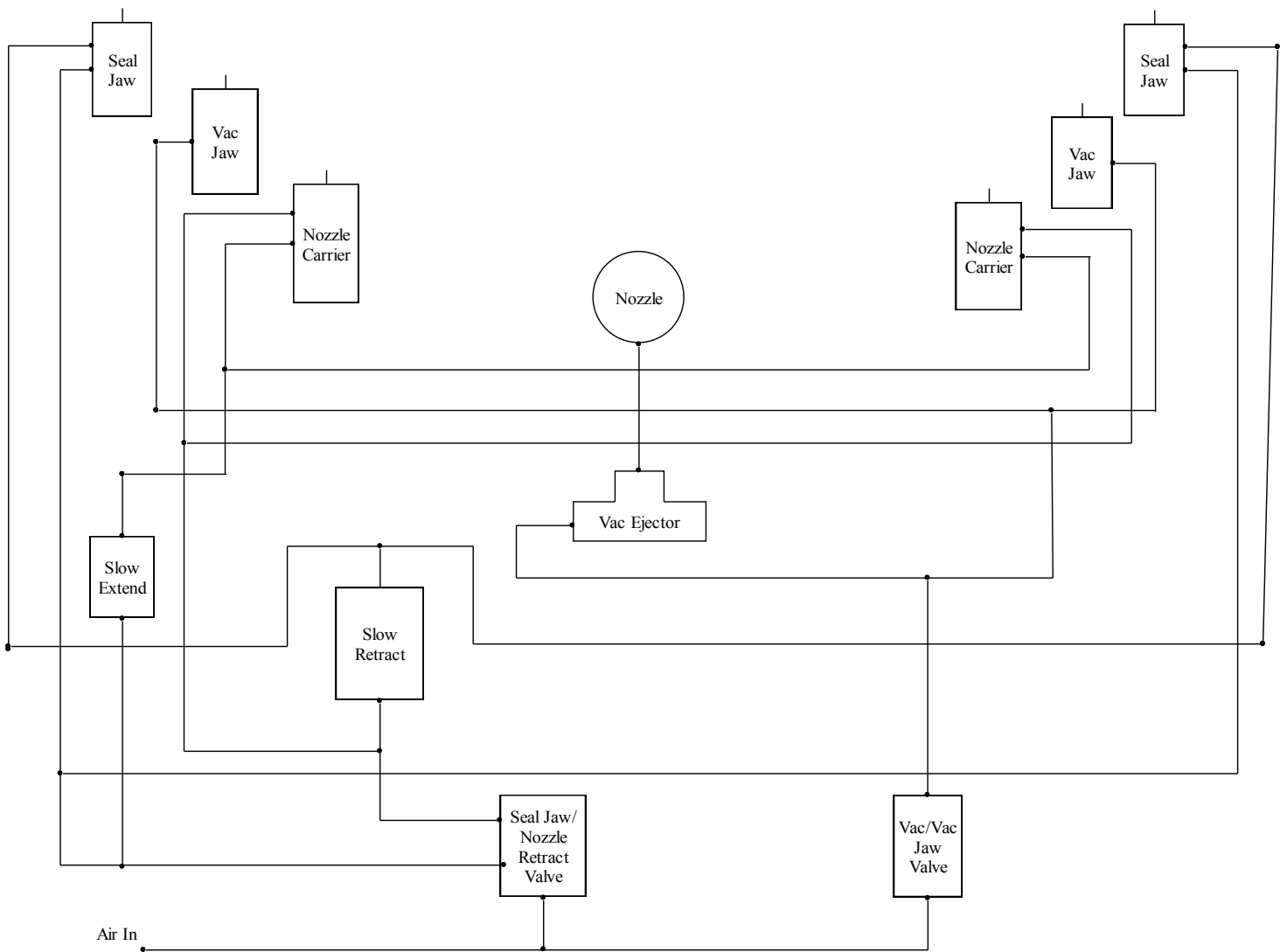


Figure 24, Vacuum Sealer Pneumatic Diagram

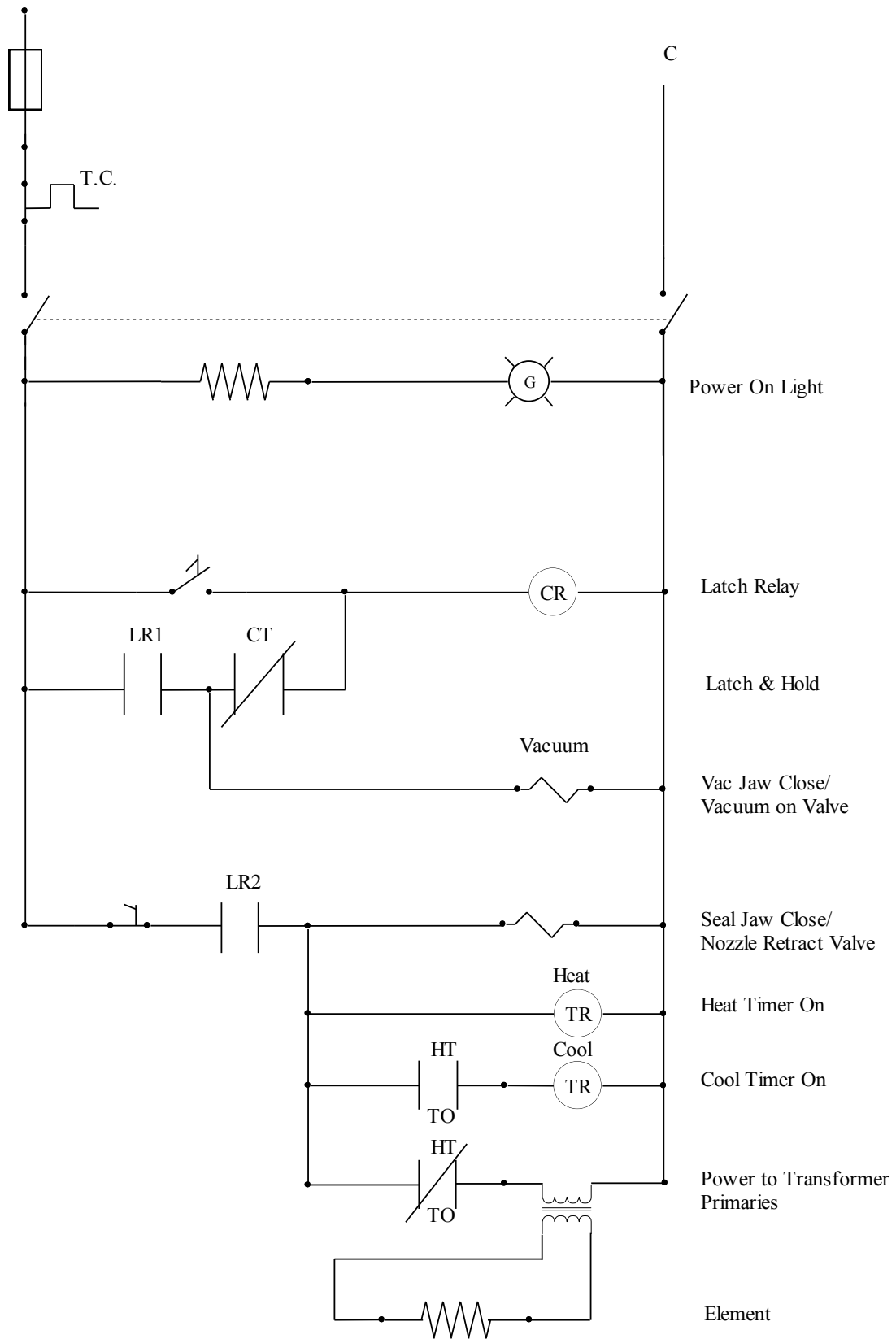


Figure 25, Vacuum Sealer Electric Ladder Drawing

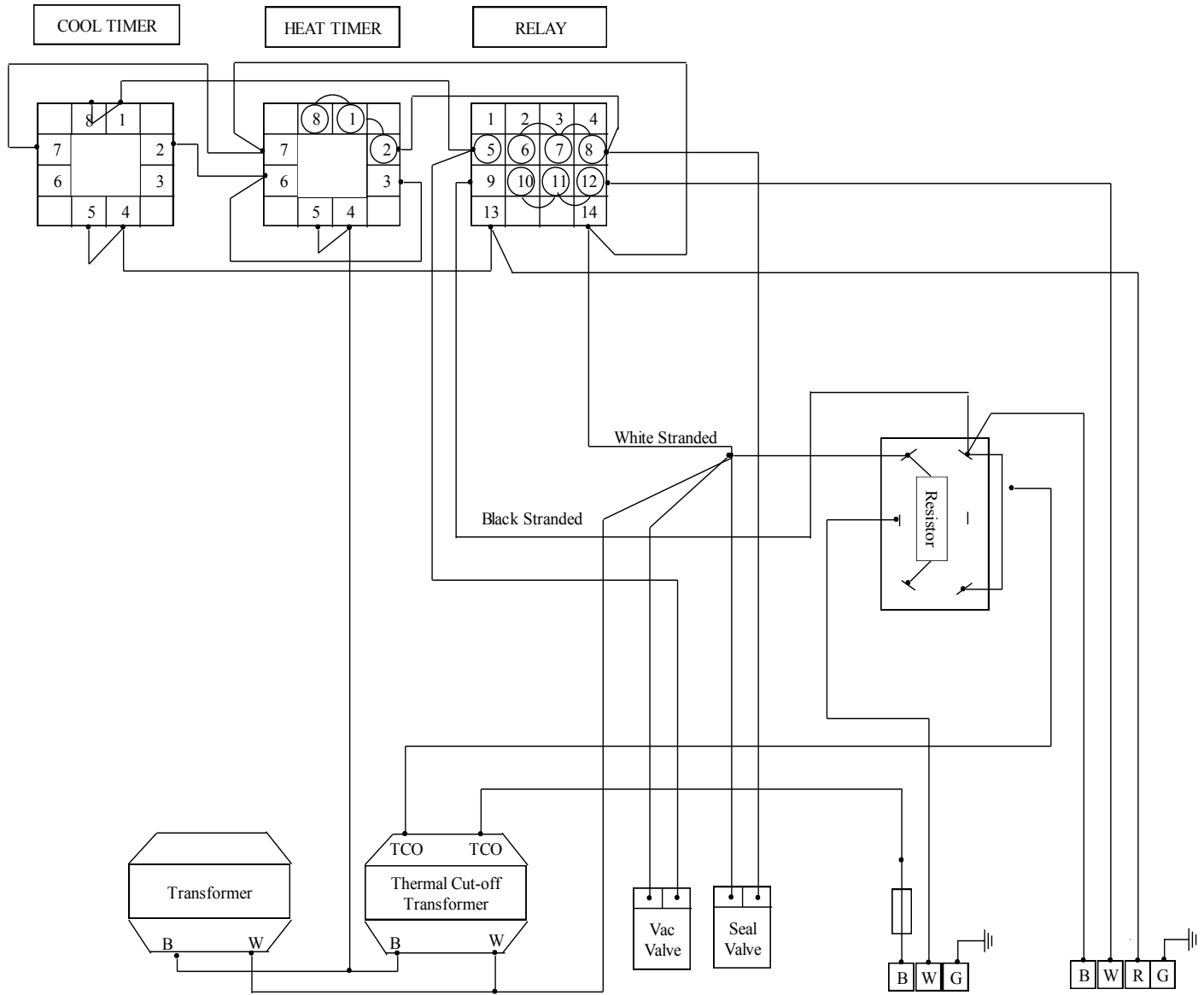


Figure 26, Vacuum Sealer Wiring Diagram

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REPLACEMENT PART ORDERING INFORMATION

Repair Parts List

In addition to the parts listed for any specific repair Uline recommends keeping the following parts on hand.

Consumables:

Uline recommends the following parts be maintained with a minimum quantity of two (2) each to reduce production downtime.

PARTS LIST

Seal Bar Length	1/4" Heating Element	Element Pad Assembly	PTFE Fabric Tape Set	Pressure Bar PTFE Fabric Tape
	#	#	#	#
20"	H-1075-0026	H-1075-6083	H-1075-0010	H-1075-0035
Miscellaneous Parts			Part #	
Fuse 10 amp			H-1075-0002	
Silicon Rubber			H-1075-3-20	