

Case Tray Shrink Machine Operations Manual

Clamco Automatic L-Sealer

Updated February 2022

Setup: Threading the roll, Advancing film/ Making a pocket

Keys to make sure when threading the roll. The shrink should be easy to pull through/ do it on its own when the machine is running. If it is tight, the film advance will not be able to move it properly and you will have seal arm jams because there is not enough slack in the shrink.

Start by pulling the tray out from the bottom right of the machine, there is a release lock on the left side. With the tray out you can place the new roll of shrink on the tray in between the guide knobs, these should prevent the roll of shrink from sliding around. Next with the open side of the shrink on your left side, thread the shrink to the fat black roller, you then need to manually bring it to the next roller that is right above the first black one. Work the shrink to the brush, this will separate the top and bottom of the shrink. Thread it then through the rollers that have sharp points, this is to poke holes in the bags so air can escape in the shrinking process. Continue to thread the shrink through the remaining rollers. At this point, you can close the tray and move around to the non wall side of the machine and thread it from there. Be sure to engage the lock to keep the tray in place. Next, there are 2 silver "arm" like levers the shrink needs to be threaded through. If you pull the first one towards you it will unwind the roll giving you more shrink to work with. You want this to be taught but easy to "get more shrink".

- Turn on the steam tunnel with the main switch. This will activate the heating elements and the belt. The shrink tunnel should be operating at 310-345 depending on the thickness of the shrink. On the wall side of the tunnel look down left and there is a small digital gage. There are 4 small buttons on the bottom of the gage. Use the far left one to enter "edit" mode for the temp. Use the < button and the ^ & v to move temp around. The speed of the tunnel track has a huge impact on the case shrink. Speed it up if you are creating holes in the bags or slow it down if it doesn't fully shrink. You can do this by knob so the left of the digital gage to change the tunnel belt speed.
- Turn L-Bar Sealer Unit on by using the power switch to the right along the white belt.

Running: Times, Temps, Speeds

Under "Timers"

Dwell Time:	4.00 seconds
Lead Time:	.02
Trail Time	.50
Auto time out (max)	30 minutes

Under Motor Speeds

- Film Speed: 47 Feet Per minute
- Conveyors: 40 Feet Per Minute

Under Temp Setup

- Cross & Side Sealer Temps: 375
- Let it warm up, check the temp through the "Actual Temp" button.
- To Start, hit Auto mode, Cycle Reset.
- To Stop, hit Setup Mode = essentially the stop button for all operations when the machine is running.

There are 3 sections of the setup: each category is the button you need to press on the panel of the machine. When you enter the number then hit the E to cycle to the next # in the section.

Let's use setting the "Times" as an example. Locate the "Timers", hit the button then enter the timing on the cheat sheet associated. When you get the number in there hit the E to "Enter" that number and it will move you to the next section of the Timers. Continue to do this till it circles you back to the original time you put in. Then do the same for the next sections of Temps, and do it again for speeds.

Once everything is set you will then be able to hit "Auto" "Cycle Reset" and the belt will begin to run. At this time you can place a case tray up against the guard on the belt and let it enter.

Seal Arm Jam Warning-

This is when the blades of the arms could not meet and properly heat + cut the shrink. Hit "Setup Mode" to disengage the auto running, you will then have to make sure there is no buildup of shrink between where the arms seal then use the "Manual Seal" to create a bag. Then check to see that it created a bag properly- hit "Auto" then "Reset" and the case tray should move to the tunnel on the belt. If a seal arm jam continues to happen each time look for reasons, the arms are very sensitive so it could be as easy as film advancing faster to clear

the shrink and keep it from bunching up. More times than not it has to do with how the shrink was loaded, if there is any resistance the arms will usually not seal. This is a "safety" feature because the arms think something such as a finger are in the way.

Tweaks- Do this if:

- The Tunnel- Tunnel Temp to 330 degrees for 150 Gage shrink.

Misc. Notes:

To net your roll width: measure $\frac{1}{2}$ way up both sides + the width and add 3". You need 2.5 to 3" of excess to let the machine feed correctly

Steve from Tompkins 847-344-0757

Shut Down Procedures:

- Steam Tunnel: Move temp down to 115, let it cool down for 15 minutes and then shut off main switch
- Turn off the L-bar sealer by suing the power switch to the right along the white belt.
- Disconnect air, power off unit.

Clamco Automatic L-Sealer

Steve from Tompkins 847-344-0757

To net your roll width: measure $\frac{1}{2}$ way up both sides + the width and add 3".
You need 2.5 to 3" of excess to let the machine feed correctly

To Power up the until

Turn Unit on

Set up:

- Dwell Time: 4.00 seconds
- Lead Time: .02
- Trail Time .50
- Auto time out (max) 30 minutes
- Motor Speeds
- Film Speed: 50 Feet Per minute
- Conveyors: 40 Feet Per Minute
- Cross & Side Sealer Temps: 375 Let it warm up, check the temp on the panel

To Start, hit Auto mode, cycle

Shut Down: Disconnect air, power off unit.

Heat Tunnel

Set Tunnel Temp to 315 degrees.

Shut Down: Move temp down to 115, let it cool down for 15 minutes and then shut off.