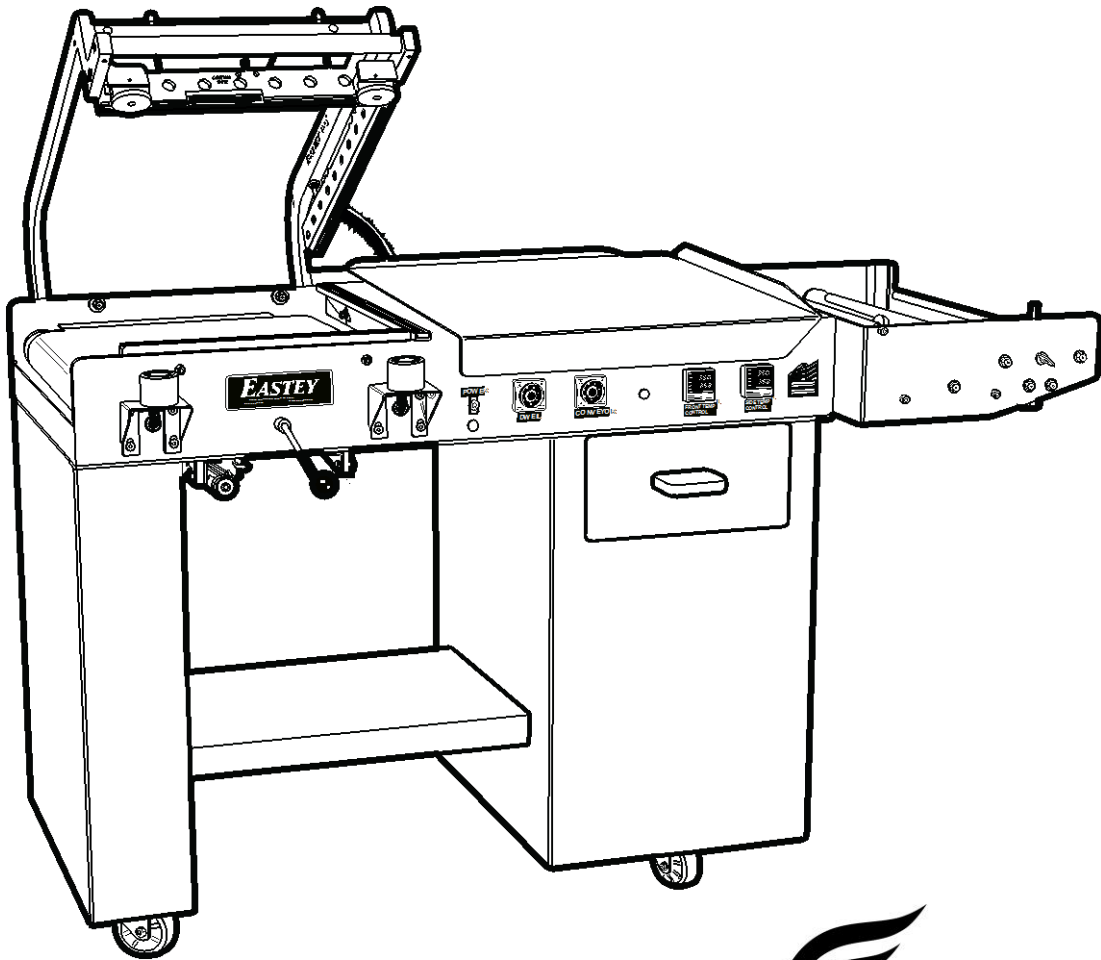


EM

EM2016TK, EM2028TK, EM2040TK, EM2050TK, EM2070TK, EM2080TK,
EM20100TK, EM3040TK, EM3050TK, EM3070TK, EM3080TK EM30100TK,
EM4040TK, EM4050TK, EM4070TK, EM4080TK, EM40100TK, EM5050TK,
EM5070TK, EM5080TK, and EM50100TK

Professional Series Semi-Automatic L-Sealers

User Guide



EASTEY[®]

EM

EM2016TK, EM2028TK, EM2040TK, EM2050TK, EM2070TK, EM2080TK,
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Professional Series Semi-Automatic L-Sealers

User Guide

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Safety

Read this manual carefully and make it available to everyone connected with the supervision, maintenance, or operation of this machine. Additional copies are available on request (Easteys.com/contact-us).

The development of a good safety program that is rigidly enforced is absolutely imperative when involved in the operation of industrial equipment. Our machinery is well designed and includes extremely important safety features. Proper installation, safe operation, and regular maintenance and upkeep are of far greater importance than our design. Only properly-trained individuals following rigidly enforced safety rules, as recommended by ANSI and OSHA should be allowed to operate these machines.

Be very careful when operating, adjusting, or servicing this equipment. If in doubt, stop and obtain qualified help before proceeding.

General Safety Precautions

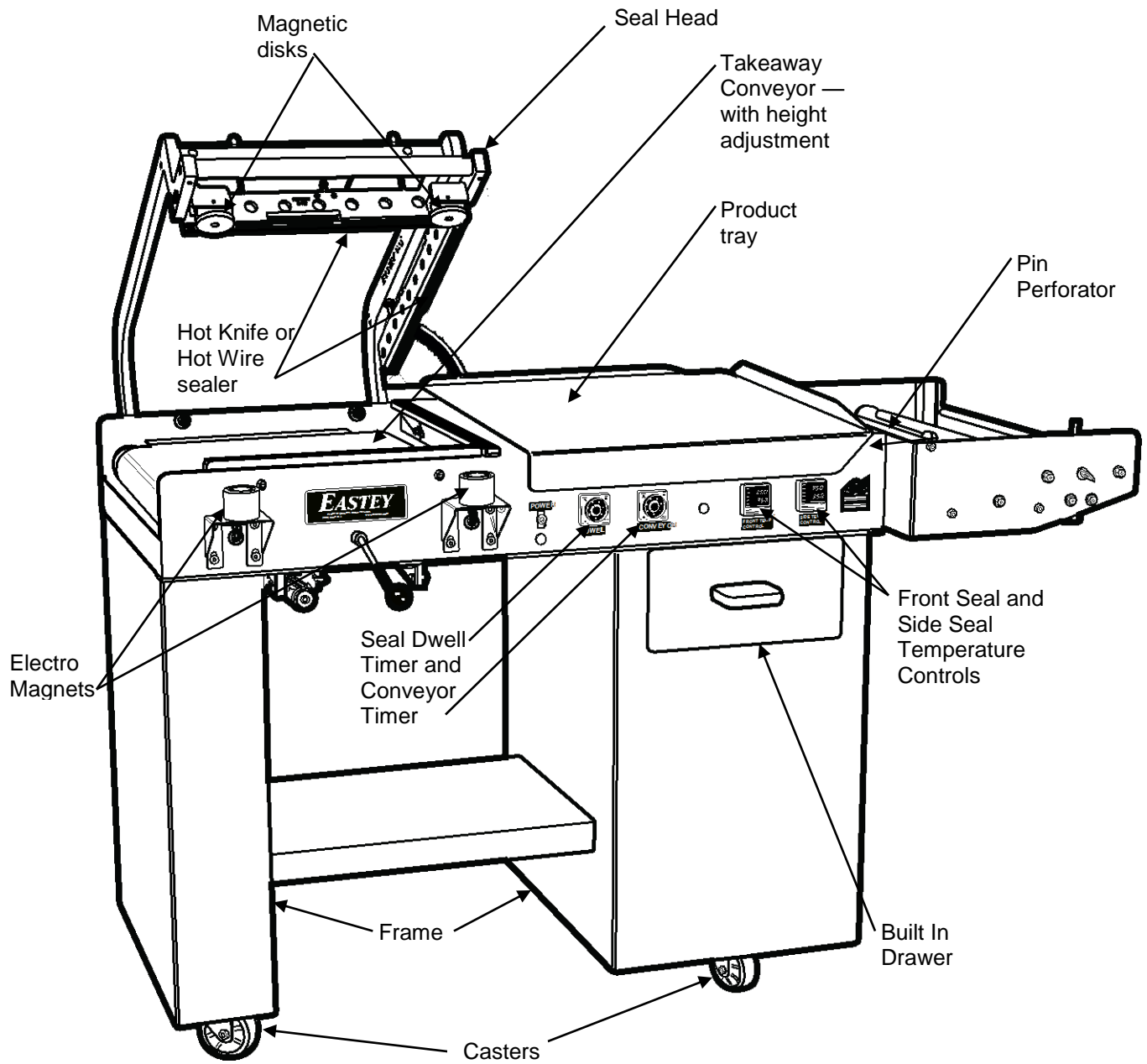
Before installing, operating or servicing this equipment, please read the following precautions carefully:

- Always disconnect electrical power before attempting maintenance for any electrical or moving parts. Do not place hands, head, or any part of the body inside the confines of the machine unless the mechanism is securely fastened and the electrical supply is shut off.
- Do not tamper with electrical wiring. Use only the specified power-supply cable. Use only licensed electricians to check or repair electrical wiring.
- In order to prevent damage to the machinery or injury to personnel, do not increase the factory settings on either the electrical or mechanical overload safety devices. Do not operate a machine if such modifications have been made.
- Keep hands away from moving conveyors and moving parts. Conveyor belts that have become worn or frayed can be hazardous and should be replaced promptly.
- Never operate this or any moving equipment without all covers and guards in place. The internal mechanism of most packaging machinery contains numerous shear, pinch, and in-running nip points, many of which are capable of causing severe injury and permanent disfiguration.
- To minimize the potential for personal injury, always be sure that the machine operators and others working on the machinery are properly trained in the correct usage of the equipment and properly instructed regarding the safety procedures for operation.

- Heat sealing arms and jaws on packaging machinery can become very hot after a period of use. Keep hands away while in operation and use caution if the machine has been running recently. If optional cutting blades have been installed, these can be very sharp. Exercise caution.
- Do not make any modifications to either the electrical circuitry or the mechanical assemblies of this machinery. Such modifications may introduce hazards that would not otherwise be associated with this machinery. Eastey Corporation will not be responsible for any consequences resulting from such unauthorized modification. Do not operate a machine if any modification has been made
- This equipment is designed for indoor operation in a typical clean, dry factory environment. Do not operate the machine in any extremely wet or oily environment that may exceed operating specifications.
- The use of certain types of plastic films in sealing and/or shrink-wrapping equipment may result in the release of hazardous fumes due to degradation of the film at high temperatures. Before using any plastic film in this equipment, the manufacturer or supplier of the film should be contacted for specific information concerning the potential release of hazardous fumes. Adequate ventilation should be provided at all times.
- Keep combustible materials away from this equipment. The equipment may be a source of ignition.
- Do not wear loose clothing such as ties, scarves, jewelry, etc. Long hair should be pulled back and/or covered while operating this machine.

Introduction

General System Description



Specifications

Model Number	Seal Dimensions		Machine Dimensions			Standard Power			Net	Shipping
	Front (F)	Side (S)	Width (A)	Height (B)	Length (C)	Volts	Amps	Phase	Weight	Weight
EM2016T(K)	16 in. 41 cm	20 in. 51 cm	34 in. 86 cm	44 in. 112 cm	63 in. 160 cm	220/110	10/20	1	600 lbs. 272 kg	700 lbs. 317 kg
EM2028T(K)	28 in. 71 cm	20 in. 51 cm	34 in. 86 cm	44 in. 112 cm	84 in. 213 cm	220/110	10/20	1	700 lbs. 317 kg	800 lbs. 362 kg
EM2040T(K)	40 in. 102 cm	20 in. 51 cm	34 in. 86 cm	44 in. 112 cm	106 in. 269 cm	220	15	1	800 lbs. 362 kg	900 lbs. 408 kg
EM2050T(K)	50 in. 127 cm	20 in. 51 cm	34 in. 86 cm	44 in. 112 cm	126 in. 320 cm	220	20	1	900 lbs. 408 kg	1000 lbs. 453 kg
EM2070TK	70 in. 178 cm	20 in. 51 cm	34 in. 86 cm	44 in. 112 cm	167 in. 424 cm	220	25	1	1300 lbs. 589 kg	1400 lbs. 635 kg
EM2080TK	80 in. 203 cm	20 in. 51 cm	34 in. 86 cm	44 in. 112 cm	187 in. 474 cm	220	20	1	1500 lbs. 680 kg	1600 lbs. 725 kg
EM20100TK	100 in. 254 cm	20 in. 51 cm	34 in. 86 cm	44 in. 112 cm	227 in. 577 cm	220	20	1	1900 lbs. 861 kg	2000 lbs. 907 kg
EM3040T(K)	40 in. 102 cm	30 in. 76 cm	43 in. 109 cm	44 in. 112 cm	106 in. 269 cm	220	20	1	1200 lbs. 544 kg	1300 lbs. 591 kg
EM3050T(K)	50 in. 127 cm	30 in. 76 cm	43 in. 109 cm	44 in. 112 cm	126 in. 320 cm	220	20	1	1300 lbs. 591 kg	1400 lbs. 637 kg
EM3070TK	70 in. 177 cm	30 in. 76 cm	43 in. 109 cm	44 in. 112 cm	167 in. 424 cm	220	25	1	1600 lbs. 728 kg	1700 lbs. 774 kg
EM3080TK	80 in. 203 cm	30 in. 76 cm	43 in. 109 cm	44 in. 112 cm	187 in. 474 cm	220	25	1	1800 lbs. 819 kg	1900 lbs. 861 kg
EM30100TK	100 in. 254 cm	30 in. 76 cm	43 in. 109 cm	44 in. 112 cm	227 in. 577 cm	220	25	1	2100 lbs. 956 kg	2200 lbs. 997 kg
EM4040T(K)*	40 in. 101 cm	40 in. 101 cm	53 in. 135 cm	44 in. 112 cm	106 in. 269 cm	220	20	1	1700 lbs. 774 kg	1800 lbs. 819 kg
EM4050T(K)*	50 in. 127 cm	40 in. 101 cm	53 in. 135 cm	44 in. 112 cm	126 in. 320 cm	220	20	1	1900 lbs. 861 kg	2000 lbs. 907 kg
EM4070TK*	70 in. 177 cm	40 in. 101 cm	53 in. 135 cm	44 in. 112 cm	167 in. 424 cm	220	25	1	2100 lbs. 956 kg	2200 lbs. 997 kg
EM4080TK*	80 in. 203 cm	40 in. 101 cm	53 in. 135 cm	44 in. 112 cm	187 in. 474 cm	220	25	1	2300 lbs. 1043 kg	2400 lbs. 1092 kg
EM40100TK*	100 in. 254 cm	40 in. 101 cm	53 in. 135 cm	44 in. 112 cm	227 in. 577 cm	220	25	1	2600 lbs. 1179 kg	2700 lbs. 1229 kg
EM5050TK*	50 in. 127 cm	50 in. 127 cm	63 in. 160 cm	44 in. 112 cm	126 in. 320 cm	220	20	1	1900 lbs. 861 kg	2000 lbs. 907 kg
EM5070TK*	70 in. 177 cm	50 in. 127 cm	63 in. 160 cm	44 in. 112 cm	167 in. 424 cm	220	25	1	2100 lbs. 956 kg	2200 lbs. 997 kg
EM5080TK*	80 in. 203 cm	50 in. 127 cm	63 in. 160 cm	44 in. 112 cm	187 in. 474 cm	220	25	1	2300 lbs. 1043 kg	2400 lbs. 1092 kg
EM50100TK*	100 in. 254 cm	50 in. 127 cm	63 in. 160 cm	44 in. 112 cm	227 in. 577 cm	220	25	1	2600 lbs. 1179 kg	2700 lbs. 1229 kg

Explanation of Model Numbers

- E = Manufactured by Eastey Enterprises Inc., division of Engage Technologies.
- M = Manual (Semi-Automated) L-sealer operation. EM model Professional Series L-sealers incorporate an electromagnetic hold-down system that allows the operator to load the next package while the preceding package is being sealed, assuring uniform sealing pressure over the entire length of the seal bars to provide consistent sealing results.
- __ = 20, 30, 40, or 50 — First two digits indicate length of sidebar or nominal maximum length of side seal in inches: 20, 30, 40, or 50-inch sidebars lengths are available.
- __ or ___ = 16, 28, 40, 50, 70, 80, or 100 — Remaining two to three digits indicate length of front bar or nominal maximum length of front seal in inches: 16, 28, 40, 50, 70, 80, or 100-inch front bar lengths are available.
- T = Takeaway conveyor — Professional Series L-Sealers are typically equipped with a takeaway conveyor.
M = Manual takeaway is an option.
- K = Knife — Indicates hot knife seal bar. For smaller units, where (K) is indicated in parentheses, the hot knife seal bar is an option and the unit can be ordered with or without it. For larger units, the hot knife seal bar is standard.
- V _ = Voltage and Phase. V1 = 220V AC single Phase. All models are available configured for 220 VAC single phase. The smallest models (EM2016T or EM2016TK and EM2028T or EM2028TK) are also available configured for V0 = 110 VAC single phase. See the following table for available AC voltages. Only single phase is offered.

Voltage and Phase Designator Meaning

Voltage / Phase Designator	Volts	Phase
V0	110	1
V1	220	1

Voltage / Phase Designator	Volts	Phase
V3	380	1
V5	480	1

- For units indicated with an asterisk (*), powered film unwind is included.

Standard features

- Designed to seal most polyolefin, polyethylene, and PVC shrink films
- All-welded main frame from ¼-inch cold-rolled steel
- Built in drawer for tools or spare parts

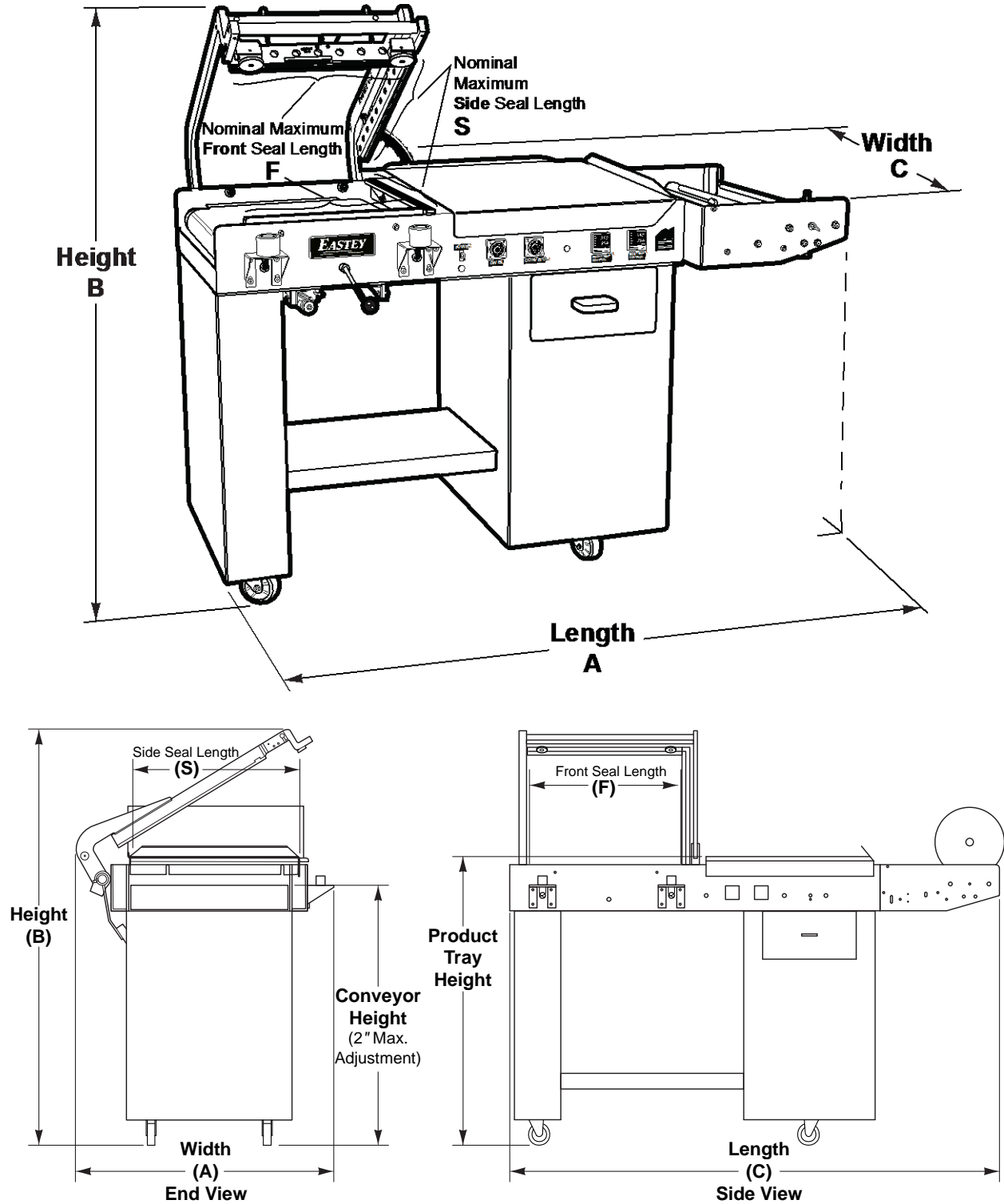
- Seal head casting equipped with head return cylinder
- Stainless steel film clamps hold film in place while sealing
- Available with hot wire or hot knife seal systems
- Hot knife seal systems available with mushroom (standard), pancake, or arrow inserts
- Dual locking magnet clamps apply even pressure across the seal-bar
- Adjustable dwell time for better seal control
- Solid state temperature control adjustable for a variety of films*
- Adjustable product tray accommodates wide variety of product sizes
- Takeaway conveyor can be raised or lowered to center the seal with the product
- Automatic takeaway conveyor
- Heavy duty film cradle allows for easy changeovers and adjustments
- Adjustable pin perforator provides air evacuation
- Side seal size from 20 in. to 50 in.; front seal size from 16 in. to 100 in.
- Maximum film width up to 44 inches
- Maximum film roll O.D. up to 12 inches; 10 inches with power unwind
- Custom two-part epoxy finish resists scratching
- Heavy duty casters for transportation within plant
- Available in 110V, 220V, or optional 480V
- Easy to use design requires minimal training and maintenance
- Made in the USA

Options

- Power film unwind
- Film inverter
- Hot knife inserts
- Stainless steel and left-hand models available
- Lower conveyor (2" maximum)
- Custom product guides or product tray

Dimensions

See Machine Dimensions in Specifications table for overall machine width, height, and length.



Unpacking

Thoroughly inspect the equipment and packaging immediately on arrival.

Carefully remove the outer protective shipping wrapper. Inspect the machine for any damage that may have occurred during transit. If goods are received short or in damaged condition, it is important that you notify the carrier's driver before they leave your company and insist on a notation of the loss or damage across the bill of lading. Otherwise no claim can be enforced against the transportation company. Please note that a copy of this document is attached to the outside of every crate.

If concealed loss or damage is discovered, notify your carrier at once and request, **insist**, on an inspection. This is absolutely necessary. A concealed damage report must be made within ten (10) days of delivery of shipment.

Unless you do this, the carrier will not entertain any claim for loss or damage. The agent will make an inspection and grant a concealed damage notation. If you give the transportation company a clear receipt for the goods that have been damaged or lost in transit, you do so at your own risk and expense.

All claims must be filled within **five (5)** months of the delivery date or the carrier will not accept them.

We are willing to assist you in every reasonable manner to help you collect claims for loss or damage. However, this willingness on Eastey's part does not make Eastey or its parent or related companies responsible for collections or claims or replacement of equipment damaged or lost in transit.

Loading and Unloading Instructions

- Air-Ride suspension and shipping straps are required for transportation of sealers.
- When transporting the sealer, roll the machine into the truck or trailer, and then when the machine is in position for shipping, lock the locking casters.
- Use shipping straps to restrain the sealer securely so it will not shift in transit.

Installation

Lift the machine up and off of the shipping pallet.

CAUTION! The EM series L-sealer is heavy and will require a forklift, floor crane, or several people to move safely off the shipping pallet. Use proper equipment when lifting the L-sealer and ensure it is secure and will not shift while being moved off the shipping pallet.

Place the sealer in the desired location with the required electrical power source available. (See power requirements for the specific model in the Specifications table.) Make sure the electrical wiring is adequate to provide the required voltage. If the voltage provided is too low, the equipment will not operate correctly.

Selecting the proper location is one of the most important considerations for initial setup. When selecting the location, take into consideration the following factors.

1. Adequate power supply nearby?
2. Where is the sealer in relation to the power source?
3. Where is the sealer in relation to the tunnel and any conveyor(s) necessary to move the wrapped product? (Alignment with packaging line.)
4. Convenience for the operator.

If there is any doubt, get qualified assistance with your initial installation.

Location Requirements

When installing the L-sealer please be aware of the following considerations:

1. The surface on which it is located is flat and level.
2. Conveyor or packing table height.
3. Alignment with packaging line.

When the L-sealer is positioned in the operating location you will need access to:

1. Control panel switches: On/Off switch, dwell timer, conveyor timer.
2. Height and width adjustments.
3. Film unwinder.

For units equipped with a takeaway conveyor at the exit of the L-sealer, provision should be made for exiting packages. For example, a table or bin where packages that have been sealed will be placed until they can be picked up, or a conveyor that will move them to the tunnel.

If the L-sealer is part of a longer packaging line, take into consideration the table and conveyor height in relation to adjacent machinery.

The machine should be placed on a flat, level floor so that it does not rock or move. We recommend that the machine be securely locked in place when used.

Set up the L-sealer and move it to its location. The casters allow easy movement over smooth flat surfaces. If you need to lift the unit to move it, you will need to use a pallet jack, floor crane, or fork lift to move it to its location.

CAUTION! If the L-sealer must be lifted for moving, use proper equipment when lifting and moving it to ensure it is secure and will not shift.

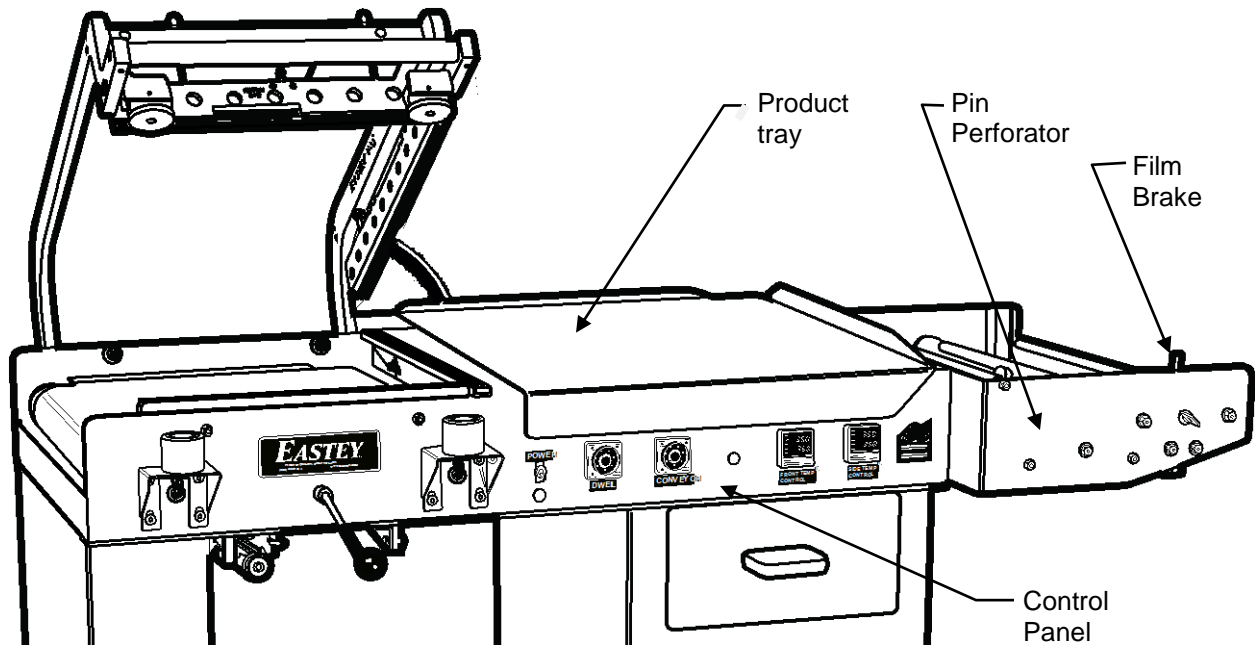
When the L-sealer has been moved to its location, use the levers on the casters to lock the wheels to prevent rolling and keep the unit in place. A power cord (with optional electrical plug) should be installed by a licensed electrician.

CAUTION! Before operating, ensure the following.

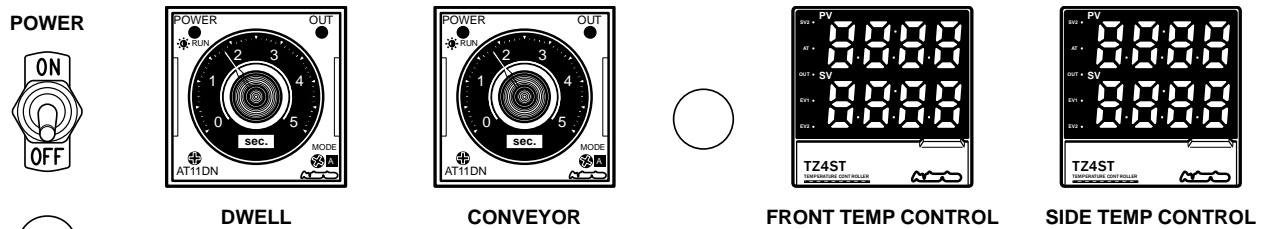
- 1. All shipping ties are removed.**
- 2. All personnel are clear of the equipment.**
- 3. Electrician has stated that all electrical work is complete.**
- 4. Adjust all controls according to the settings sheet.**

Refer to instructions in the Operation section for instructions to power up or shut down the machine.

Operation



Control Panel



Controls for the L-sealer are located along the front side of the frame under the product tray. Controls from left to right are listed below.

Power — Toggle switch to toggle L-Sealer power on or off.

Dwell — Timer setting for seal. (Duration of activation of seal arm electromagnets).

Conveyor — Timer setting for conveyor. (Length of time the conveyor will run for each item.)

Front Temp Control — Setting and current temperature display for front seal.

Side Temp Control — Setting and current temperature display for side seal.

CAUTION! When the power is turned on be aware of sealer hot surfaces and moving belts and rollers.

Film Unwinder

Product Tray

The product tray is the adjustable metal platform used to separate the film and to facilitate insertion of the product between the bottom and top layers of film.

The product tray is adjustable to achieve proper depth equal to the total width of the package, thereby allowing the product to be placed precisely at the center-fold of the film each time.

Pin Perforator

The pin perforator is located between the lower idler rollers and is completely synchronized with the seal arm. It creates holes in the film (to allow air to escape during shrinking). The pin perforator is adjustable and must be properly placed in relation to the depth of the desired package. The positioning of the pin perforator should always be reviewed when changing the machine for a different size product or different size film. It is adjusted by the adjustment knob attached to the bottom of the film rack. The pin perforator is mounted inside the film rack of the machine to avoid dropping or damaging and so it is mounted out of the way.

Film Brake

The film brake is positioned at the front end of the cradle rollers and creates a drag that maintains tension on the film as the film is dispensed. The operator should from time to time re-check the setting of the film brake for proper tension. The film brake's purpose is to reduce overruns or slack in the film.

Mounting Film

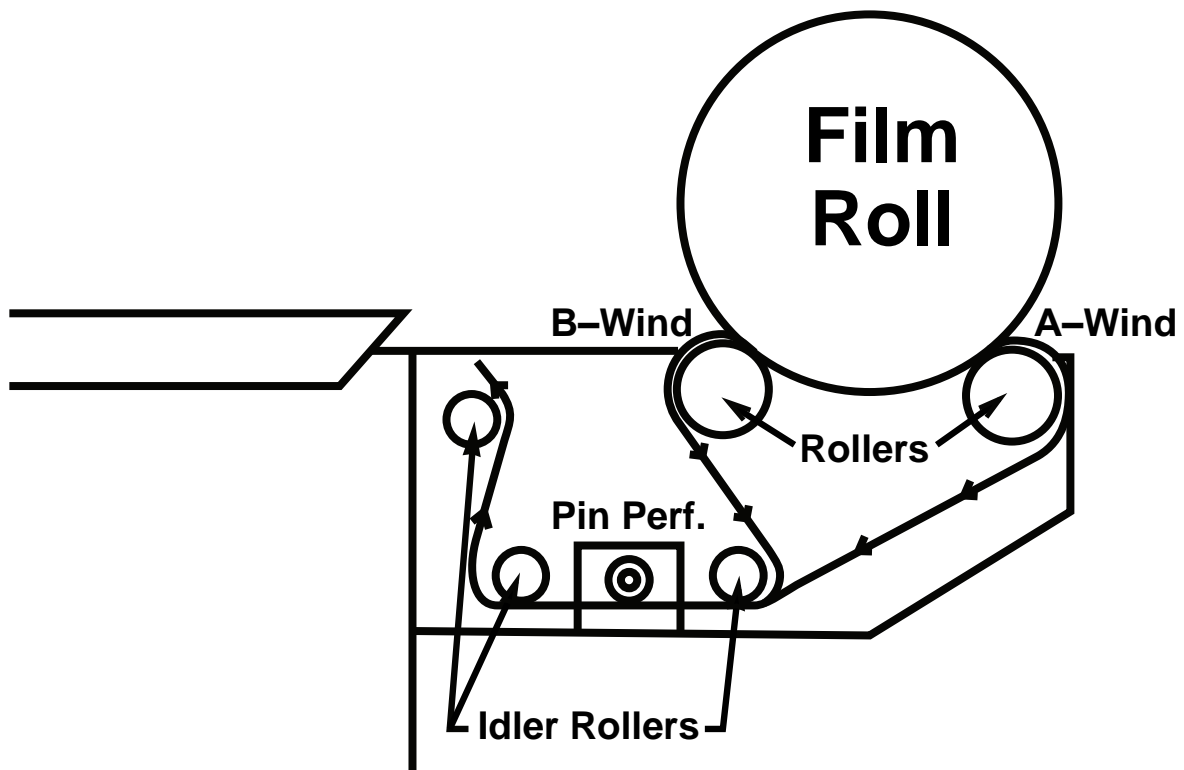
Standard Cradle-Mount (Unpowered) Film Unwinder

Select the proper width of center-fold film for the product being packaged, taking into account the width and height of the package. With the package properly positioned within the film in the sealing area, allow sufficient film to overlap the sealing bars so that a seal can easily be made without possibility of openings due to insufficient film coverage.

Place the film roll on the rollers of the cradle-mount film unwinder. (See the illustration on the following page.) Place the center-fold away from the operator, to the back of the machine. Position the film roll on the rollers and tighten the upright bolts on the film rack collars to hold the film roll in position.

Decide whether the film is an A or B wind, and then thread it through and around the idler rollers and the pin perforator. (See the following illustration.) When threading the film, make sure to pull excess film through the rollers, across the product tray and into the sealing area to ensure sufficient film to begin. When you have threaded the film, separate the top film from the bottom and insert the product tray between the film top and bottom. Make sure that the center-fold of the film is at the back of the product tray. This allows the operator to insert product on the product tray between the top and bottom layers of film to prepare to move the product and film into the sealing area. Do not place product in the first few bags formed by the sealer: they will not have any perforation holes in them (because the sealer and pin perforator work together). Perforation is required to allow air to vacate when the product passes through the shrink tunnel.

Standard Cradle-Mount (Unpowered) Film Unwinder



Begin inserting product into the film as soon as the film reaching the seal area has perforations in it. Place the product against the back of the film separator tray and then move product into the seal area. Be sure to leave the bag loose around the product when making the seal. This helps keep the seals from blowing out in the shrink tunnel. See Sequence of Operation, which follows, for more detailed instructions for operating the L-sealer.

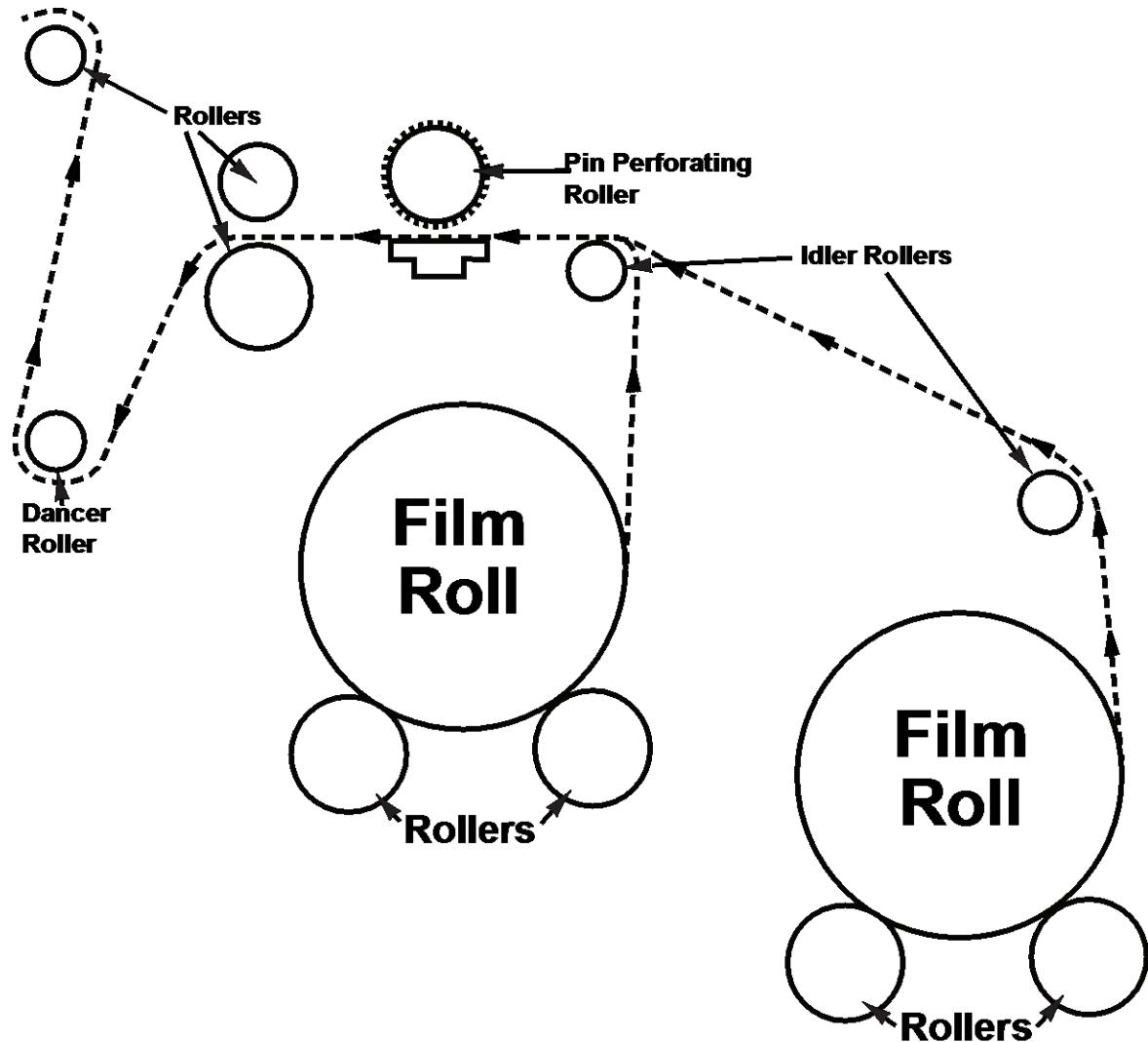
Optional Powered Film Unwinder

(With Double Film Rack for use with Inverting Head)

Use the following steps when using the optional Eastey power film unwinder and inverting plow. These steps must be taken to ensure proper tracking of the film.

1. Set the inverting head to desired opening one-half inch (1/2") taller than the package. See the illustration on the following page. The final roller and film separator rod should automatically adjust the film direction toward the center of the inverting plow. For example, if the package is six inches (6") high, the film should be directed three inches (3") above the loading tray coming off the power film unwind.
2. Invert film around the inverting head. Standing in front, facing the machine, move the loading tray out of the way. Pull film toward you, feeding it off the unwinder with the folded edge on the right. (Put the bottom layer of film under lower inverting plate. Put top layer of film on top of upper inverting plate.) With your right hand, push film between inverting head plate and loading tray as it enters the seal area.
3. Adjust takeaway conveyor height so that the seal is in the center of the package top to bottom. The objective is to use equal amounts of film for the top and bottom. If the package is six inches (6") high, the takeaway conveyor should be three inches (3") below the lower seal pads.

Optional Powered Film Unwinder



Sequence of Operation

1. Place the product on the product tray.
 - The product tray separates the film, allowing you to place the product between the upper and lower layers of film.
2. Move the product into the seal head area, pushing it to the left.
3. Move hands out of the seal head area and pull the seal head down. Let go of the handle as soon as the magnets activate.
 - The magnets hold the seal head down for the amount of time required to make the seal. The amount of time is adjustable from one (1) to five (5)

- seconds and is indicated on the Dwell timer indicator, which is located closest to the Power switch under the product tray.
- While the magnets are holding the seal head down, it is not necessary to wait. Prepare the next item to be sealed, placing it on the product tray between upper and lower layers of film.
4. Once the seal is formed completely, the seal head automatically releases. The sealed product is removed by the takeaway conveyor, and the next Item can be moved into position for sealing.
- The takeaway conveyor runs for the specified amount of time required to move the sealed product onward out of the sealing area. The amount of time the conveyor runs is adjustable from one (1) to five (5) seconds and is indicated on the Conveyor timer indicator, located next to the dwell timer indicator under the product tray.

NOTE: If there is too much tension on the film while the bag is being sealed, the seals will be more likely to be weak or blow out in the seal area while moving through the shrink tunnel.

Adjustments

Element Pulse Switch Adjustment

The sealing cycle should not begin until the seal head is within one-quarter-inch ($\frac{1}{4}$ ") or less of the film to be sealed. If the magnets energize before the head is within one-quarter-inch of the film, loosen the locknut and turn the screw (located at the rear of the side seal bar) up slightly (counter-clockwise as viewed from above). Adjustment has been set correctly when the magnets are energizing just as the seal bar comes into contact with the lower magnet pads.

Electromagnet Position Adjustment

All magnets have been factory adjusted for equal sealing pressure throughout the length of both the front and the side seal bars. If an adjustment is required, however, use the following procedure.

1. Disconnect the L-sealer power plug from the electrical power source.
2. Loosen the lower magnet screws on all of the lower magnets so the magnets settle to the lowest position in the mounting slots.
3. Lower the L-sealer operating handle fully and lift the lower magnets to within the thickness of a dime from the holders.
4. Re-tighten the mounting screws securely to retain the proper adjustment.

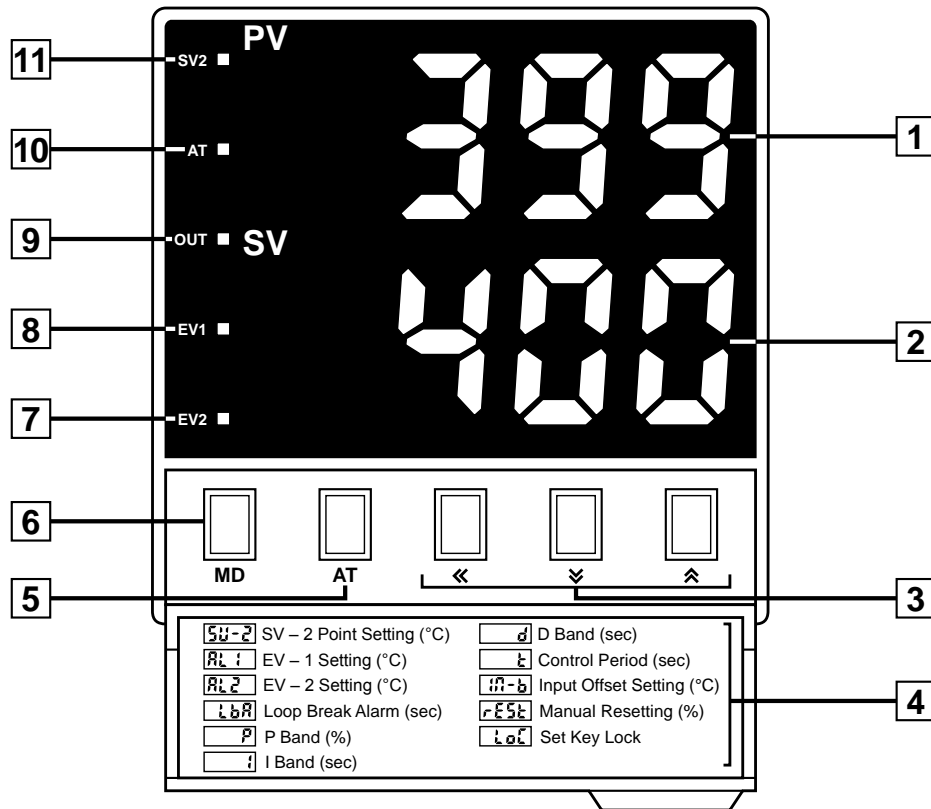
Seal Pad Pressure Adjustment for Head Return Cylinder

Uniform pressure between the sealing elements and the sealing pads must always be maintained in order to obtain an even seal and to prevent heating-element hotspots and premature burnout. The adjustment should be checked periodically and should always be checked when sealing gaps occur.

1. Disconnect the sealer power plug from the electrical power source.
2. Supporting the seal head in the up position, loosen the four set screws for the head return cylinder. Gently lower the seal head to rest on the lower seal pads.
3. With the seal head resting on the lower pads, shim up the film clamps so that the inserts are resting on the lower pads. Make sure there are no air gaps, and then tighten the head casting bolts.

4. Adjust magnets. (See Electromagnet Position Adjustment on page 23.)
5. Go to the rear of the L-sealer. Make sure the head cylinder is straight from front to back. Pull the air cylinder bracket the full length of the air cylinder. Tighten the $\frac{5}{16}$ -inch set screws.
6. Cycle the seal head up and down. Adjust set screws on head return cylinders for proper head speed and cushion.

Temperature Controller



1. PV = Processing value (red in color).
2. SV = Setting value (green in color).
3. Back (←, shift display key), down (⇩), and up (⇧) keys.
4. Programming key access door — Open to access programming keys.
5. AT key: the mode key to execute Auto Tuning function.
6. MD key: the mode key to change items to be set, such as set value, etc.
7. EV2: Event 2 output signal lamp.
8. EV1: Event 1 output signal lamp.
9. OUT: Output signal lamp.
10. AT: Signal lamp flashes while unit is auto-tuning.
11. SV2: Signal lamp for SV2 set value.

To Change the Set Value

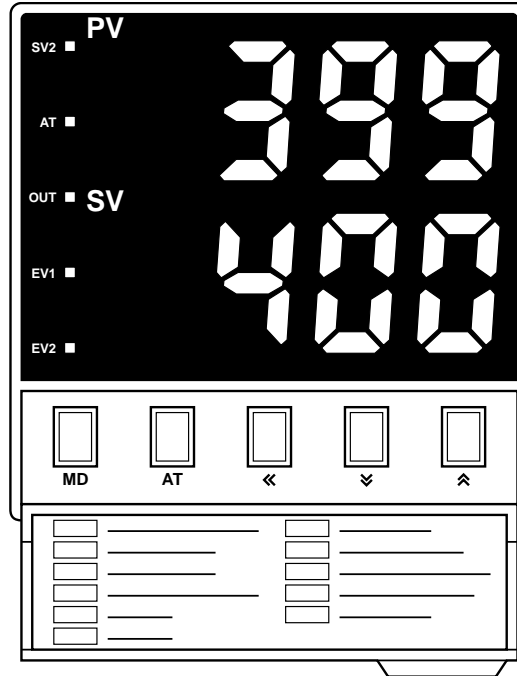
1. Press the left-arrow (◀) button and a digit will begin to flash. The flashing digit indicates the digit whose value can be changed by pressing the down- (▼) or up-arrow (▲) buttons.
2. If necessary, press the left- (◀) or right-arrow (▶) to shift to the place of the digit that needs to be changed. (The digit to the left or right will begin flashing.)
3. Press up (▲) or down (▼), as required to change the flashing digit to the required value.
4. Repeat instructions 2 and 3 above as necessary until all digits have been set to the required value, and then press the MD button. No digits will be flashing, the new value entered is applied.

To Change the Set Value for Over Temperature

Over temperature is factory set to 500° F, but can be adjusted if required for your sealing application.

PV, the Process Value is the actual temperature reading at the sealing elements. PV and SV are mentioned in this procedure, but they are only displayed at the beginning of the procedure.

1. Press and hold the MD button until SV-2 is displayed.
2. Press the MD button (do not hold it down) repeatedly to scroll through the menu until LOC is displayed.
3. Press the left-arrow (◀) button. (ON will begin flashing.)
4. Press the down-arrow button (▼). (ON will turn to OFF and OFF will be flashing.)
5. Press the MD button. (OFF will stop flashing.)
6. Press MD again. (This will bring you back to SV-2.)
7. Press MD again until AL-1 is displayed.
8. AL-1 is set to 500°.



Over Temperature Alarm Setting

1. Press and hold the MD button for approximately three (3) seconds.
 - IN-T is displayed.
2. Press and hold the MD button and up-arrow (^) buttons at the same time for three (3) seconds to activate the menu. Scroll to LOC and press the left-arrow (<<) button. On will begin flashing. Press the down-arrow (v) button. On will turn to Off and press the MD button until LOC appears, indicating that the Off setting is locked.
3. Press the MD button until EU-1 appears (Event 1). Below EU-1, AL-6 should appear. If not, use the up and down buttons to select AL-6.
4. Now return to LOC and change it to On.
5. Press and hold both the MD and up-arrow (^) buttons at the same time for three (3) seconds to access the other menu.
6. Scroll through the menu using just the MD button and turn LOC Off.
7. Scroll through the menu until AL-1 appears. This is your high alarm. The normal factory setting is 500°.
8. Return to LOC and change it to On.

Maintenance

The Eastey EM Professional Series Semi-Automatic L-Sealer will provide many hours of maintenance-free operation. There are a few items that may require attention from time to time.

Silicone Rubber and Felt Seal Pad Replacement

Occasionally it will be necessary to replace the silicone rubber or felt sealing pads. Seal pads are designed with a channel to make them easy to install and replace. Seal pads should be replaced if the following symptoms are observed.

- Gaps in the seal
- Weak seals
- Improper film cutoff
- Excessive sealing pressure required

To replace a silicone rubber or felt pad, pull the old pad out of the channel and replace with the new silicone rubber or felt pad, pressing it into place in the channel.

NOTE: Some silicone rubber pads come covered in talcum powder. If so, clean the pads with a mild solvent.

Changing Hot Knife Inserts and Cutting Rules

1. Disconnect the L-sealer power plug from the electrical power source.

CAUTION! Always be aware of the cutting edges while replacing the knife edges. Handle the knife blades carefully.

2. Remove the #10-32 screws holding the inner side film clamp and remove the #10-32 screws holding the outer front film clamp.

NOTE: One #10-32 screw is behind the aluminum arm casting. This does not need to be removed. Push the product tray in all the way. Swing the film clamp down and to the right over the product tray, then pull it out and rest the film clamp on the product tray.

3. Remove the #8-32 flat head screw on both side-seal and front-seal bars.
4. Remove the insert and cutting rule, both at the same time.

5. Place the replacement cutting rules into the new inserts, both at the same time, ensuring that the beveled edge is in the corner.
6. Push the beveled edges together.

NOTE: The inside beveled edges of the cutting rule need to come together. The outsides do not. Be sure the cutting rules are touching.

7. Install the #8-32 flat head screws, but do not tighten them at this point.
8. Heat the seal bar up to the set point.
9. Adjust insert and cutting rule if they separate at the corner.
10. Tighten the #8-32 flat head screws while the seal bars are hot.
11. Turn off heat and allow the sealer to cool down, and then reinstall film clamps.

Takeaway Conveyor Maintenance and Replacement

From time to time it will be necessary to disassemble the conveyor when it requires an adjustment for a different product size or if worn parts need to be replaced or for general maintenance. Instructions provided in this user guide are very general. If these generalized instructions do not address your specific conveyor issue, contact a certified representative of Eastey or contact Eastey Enterprises directly (Eastey.com/contact-us).

Replacing the Takeaway Conveyor Motor

NOTE: This procedure requires an Allen or hex wrench, and a 7/16-inch box-end wrench.

1. Disconnect the L-sealer power plug from the electrical power source.
2. Disconnect wires # 14 and # 16 from inside the panel and pull them out. Note the color of wires and where they are connected.

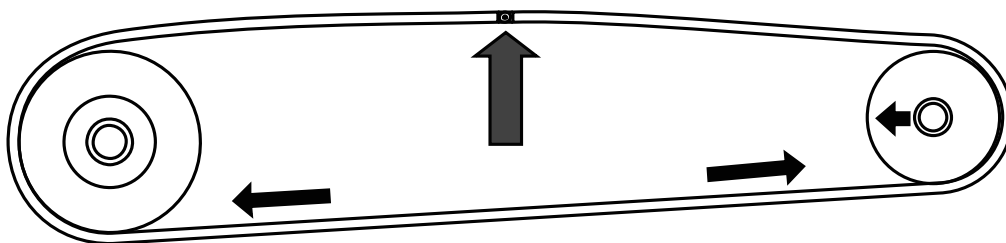
NOTE: Wiring color connections to the conveyor motor.

- Red and yellow are together and capped.
- Brown, purple, and orange are together and capped.
- Black is connected to black for power.
- White is connected to white for power.
- Green is connected to green to ground or motor ground.

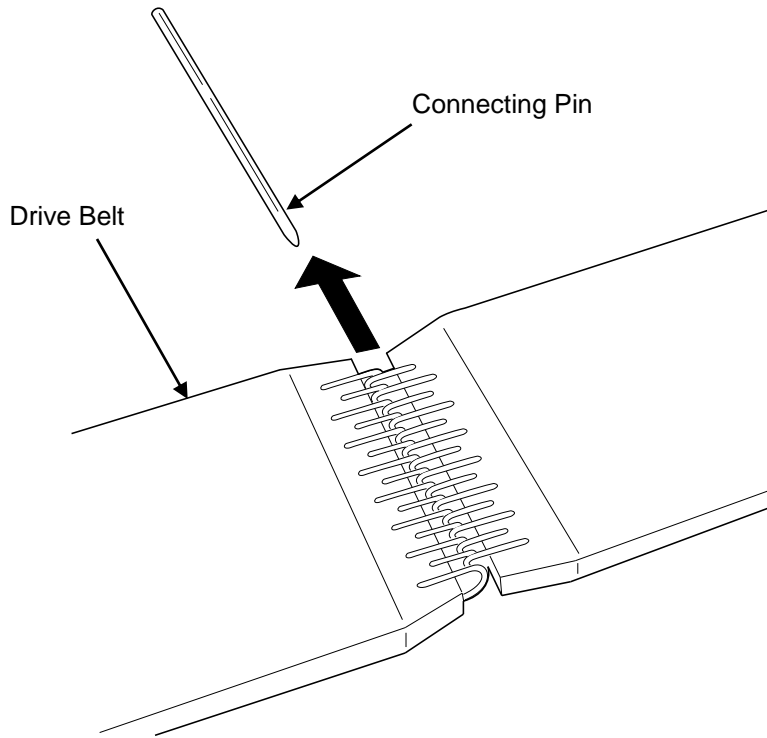
3. Loosen the $\frac{1}{4}$ -20 drive roller adjustment bolts and remove the timing belt. Remove the timing pulley from the motor (requires an Allen or hex wrench).
4. Remove the three $\frac{1}{4}$ -20 bolts. These hold the motor in place. As the last bolt is removed, hold onto the motor so it does not fall. (Bolt removal requires $\frac{7}{16}$ -inch box end wrench.)
5. Place the new conveyor motor in place of the conveyor motor removed, and install the $\frac{1}{4}$ -20 bolts.
6. Re-install the timing pulley. Make sure it is not rubbing against the conveyor frame, and then tighten both set screws.
7. Reinstall the timing belt. Tighten the $\frac{1}{4}$ -20 drive roller adjustment bolts. Reconnect the power wires #14 and # 16. Refer to the wiring color connections note on the preceding page to complete motor wiring connections.
8. Refer to the instructions for Tracking the Takeaway Conveyor Belt that follow.

Replacing the Takeaway Conveyor Belt

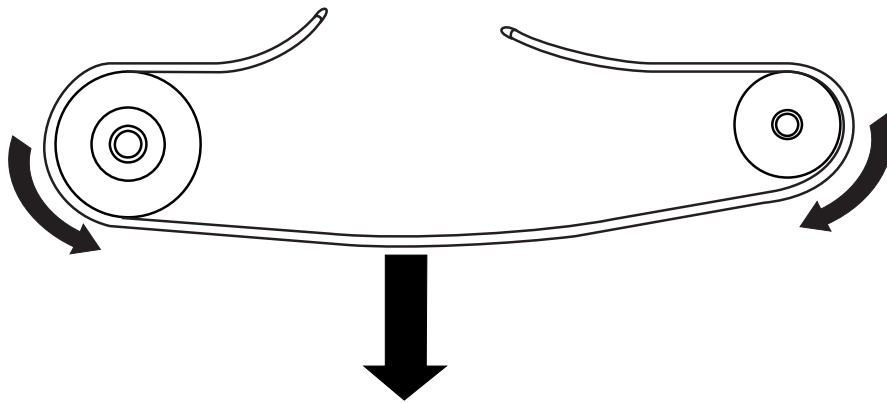
1. Disconnect the L-sealer power plug from the electrical power source.
2. Loosen the idler roller to release tension until the belt is loose.
3. Turn the conveyor belt to move the belt splice to the center of the conveyor.



4. With the belt loose, remove the connecting pin that holds the belt together.

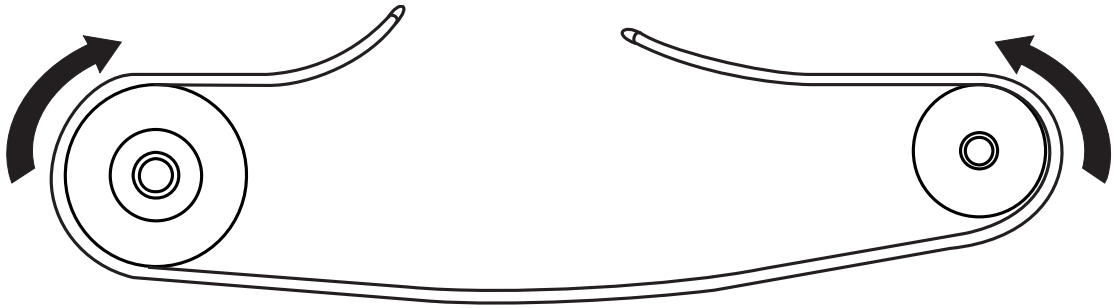


5. Take the belt off the conveyor rollers.

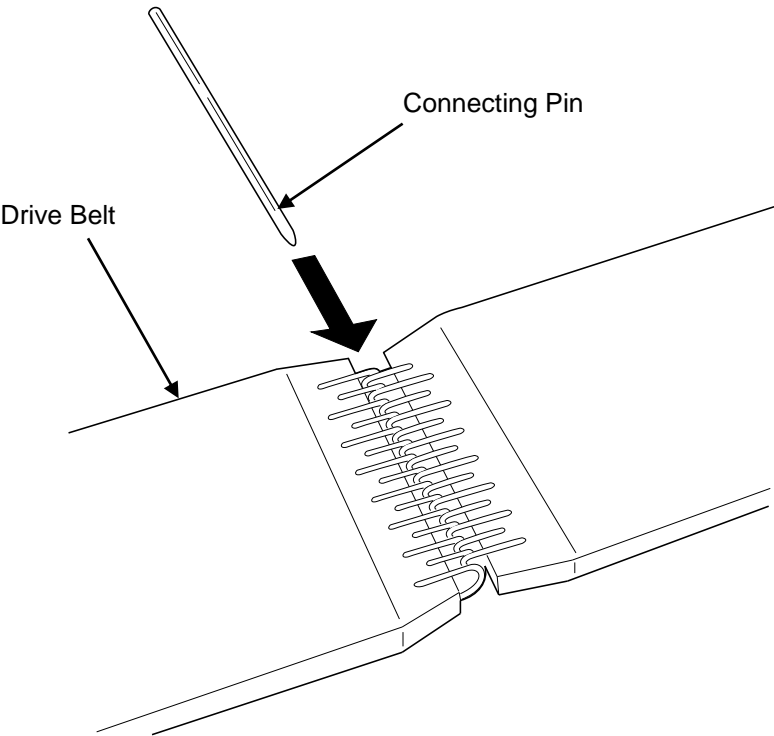


NOTE: At this point, you have completed the procedure for removing the belt. Instructions from here on explain how to install the new belt or reinstall the belt if still usable. If the conveyor support plate requires replacement, replace it before installing or reinstalling the belt.

6. Install the replacement belt around the drive and idler pulleys.



- 7. While the belt is still loose, start connecting the ends by lining up the edges of the belt. From the side of the belt, replace the connecting pin.

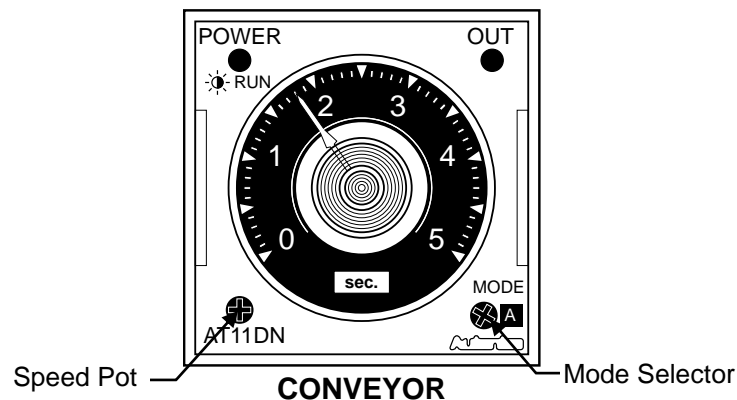


- 8. Re-tension the conveyor belt as required. Refer to the instructions for Tracking the Conveyor Belt that follow.

Tracking the Takeaway Conveyor Belt

From time to time or whenever the takeaway conveyor belt has been replaced, it will be necessary to track or align the belt so that it stays in place on the rollers while moving and delivering the product. The procedure is simple, but can be time-consuming.

1. Identify the drive roller and the idler roller. The drive roller is the larger roller. The idler is smaller and has a crown (rounded surface that is higher at the middle and tapers outward to give the idler a slight “barrel” shape).
2. Place the belt on the rollers in the center and tighten each adjustment screw as evenly as possible.
3. Adjust the speed potentiometer on the conveyor timer (adjustment screw for speed pot is at lower left; see illustration below) to increase the conveyor speed.

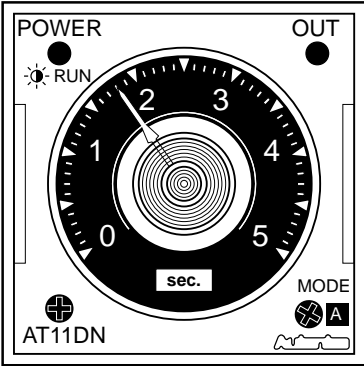


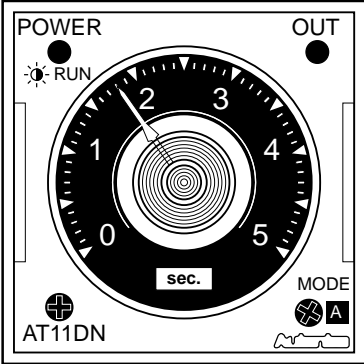
4. Start the conveyor and observe the belt.
5. If the belt stays centered on the rollers during operation, no further adjustment is required. If the belt begins to pull towards the front or back, adjust it by turning the left-hand adjustment screw only. Turn the adjustment screw no more than one quarter turn at a time — attempting to make larger adjustments will only prolong the adjustment effort. Return the conveyor to normal operating speed when finished.

Rollers

Make sure rollers stay clean and grease free. If you should have to clean the rollers, simply wipe them down with a clean lint free cloth. If a more thorough cleaning is necessary wipe the rollers down with a mild detergent and water and let dry. **Never use harsh or abrasive cleaners or chemical agents when cleaning the rollers.**

Troubleshooting

Problem	Solution
<p>No Element Heat</p>	<ul style="list-style-type: none"> • Check to be sure sealer is plugged in and electrical power is present at the outlet. • Is the display for temperature on? If not, check main fuses. • Is the Out light on when the SV is lower than the PV setting? The temperature controller will read Open. • Is the green light on the solid state relay on when the Out light on the temperature controller is on?
<p>Conveyor Does Not Run</p>  <p>The diagram shows a circular speed dial for a conveyor. It has a central needle pointing to a scale from 0 to 5. The dial is labeled 'CONVEYOR' at the bottom. There are several indicators and controls around the dial: 'POWER' and 'RUN' (with a light icon) at the top left; 'OUT' at the top right; 'AT11DN' at the bottom left; 'MODE' and 'A' (with a light icon) at the bottom right. The word 'sec.' is printed at the bottom center of the dial.</p>	<ul style="list-style-type: none"> • With the seal head up the light in the left hand corner of the temperature timer stays lit all the time. <ul style="list-style-type: none"> - If the light is on, bring the seal head down. The light should start flashing. • Is the timer in "A" mode? <ul style="list-style-type: none"> - Mode selector is to the lower right corner of the dial. • Inside the conveyor speed dial, is the setting between 0 and 5? <ul style="list-style-type: none"> - Timer speed pot adjustment is to the lower left corner of the dial. • At the bottom of the speed dial, is "sec" displayed? <ul style="list-style-type: none"> - Units of time selected is displayed at center near the bottom of the dial. • Is the limit switch on the back of the machine being fully actuated (pressed in)? <ul style="list-style-type: none"> - Press the limit switch in by hand, and then let it go. - Refer to Magnet Hold Down Not Operating on Magnet Sealers, on next page.

Problem	Solution
<p>Magnet Hold Down Magnets Not Operating on Magnet Sealers (Sealing head will not stay down, but sealer operates normally otherwise.)</p>  <p style="text-align: center;">DWELL</p>	<ul style="list-style-type: none"> • Is timer working properly? <ul style="list-style-type: none"> - The timer is identical to the timer used for the Conveyor. See items to check on the conveyor timer for Conveyor Does Not Run troubleshooting on previous page. • Turn off power and put the seal head down. With power off and the seal head down, there should be about a dime's-thickness of space between the upper and lower magnets. <ul style="list-style-type: none"> - Is there dime-sized space between upper and lower magnets? • Press the limit switch to activate it by hand. <ul style="list-style-type: none"> - Does the limit switch work properly when operated by hand?
<p>Weak or Poor Seals</p>	<ul style="list-style-type: none"> • Improper setting of temperature film cutoff controller. (Heat set too low.) • Improper operating technique. (See Sequence of Operation on page 21.) • Check the sealing heating element to see if it needs cleaning. • If the silicone-rubber seal pad is wavy, replace it. (See instructions on page 29.) • Seal pad pressure is incorrect. (See page 23.) • Hold-down pressure is uneven or incorrect on magnets.

Problem	
Magnet Hold-Downs Stay Engaged When They Should Release	
Solution	
<ul style="list-style-type: none"> When you turn the power off, do the magnets release? <ul style="list-style-type: none"> If they do not, replace the magnets. 	
<p>The diagram shows two identical speed control timer units. The left unit is labeled 'DWELL' and the right unit is labeled 'CONVEYOR'. Each unit features a circular dial with numbers 0 through 5 and a 'sec.' label. Above the dial are 'POWER' and 'OUT' indicators, and a 'RUN' light. Below the dial is a 'MODE' selector with an 'A' mode. To the left of the dial is a 'Speed Pot' (potentiometer) with a '+' sign and 'AT11DN' label. To the right is a 'Mode Selector' with a '-' sign and 'A' mode label. A vertical scale on the left side of the units is labeled 'VER' with 'N' and 'F' markings.</p>	
<ul style="list-style-type: none"> Each of the speed control timers for the dwell and conveyor have an adjustable pot in the lower-left corner and a mode selector in the lower-right corner. (See the illustration above.) Use a small screwdriver to turn pots either direction. <ul style="list-style-type: none"> Turning the pot on the lower-left, you will see the numbers change inside the dial. Keep turning it until you adjust to 5 seconds. While turning this pot you will see the sec turn to min, hour, and 10hr. Factory setting is 5 seconds. Turning the selector at the lower-right, you see the modes change. Keep turning until you return to mode A, which is the factory setting. Turning these two pots cleans the wipers inside the timer. When bringing the seal down, a light on the top left should come on and the light on the top right should flash. If this is not happening, switch the conveyor timer and the dwell timer. If the magnets start working, replace the timer. 	

Problem	Solution
Excessive Film Drag	<ul style="list-style-type: none"> Check for proper film threading. (See Film Winding diagram on page 19 or 21.) Loosen film roll brake. (See Film Winding diagram on page 19 or 21.) Tighten film roll brake.
Excessive Film Winding or “Spill”	<ul style="list-style-type: none"> Tighten film roll brake.

Problem	Solution
Charring of Film	<ul style="list-style-type: none"><li data-bbox="716 275 1390 382">• Improper setting of temperature film cutoff controller. (Too much heat.) Adjust temperature down.

Parts List

Electrical

DESIGNATOR	PART NO.	DESCRIPTION	Q'TY.
	EAST0421-1	25 Amp, 220 V, 2 pole contactor, GE	
	EAST0421	25 Amp, 220 V, 2 pole contactor, S&S	
F1 & F2	ET000301 ETL00240	10 Amp Fuse (16T) 15 Amp Fuse (28T)	1
	ETC00309	Power On/Off	1
CR3	EAST0031	Main Contactor	1
TMR-1	EAST1030	Timer, Dwell	1
TMR-2	EAST1030	Timer, Conveyor	1
LS-2	EAST0029	Magnet Limit Switch	1
LS-3	EAST0029	Conveyor Limit Switch	1
M1	EAST0063	Conveyor Motor	1
T-3	EAST0036	Magnet Transformer	1
	EAST0038	AC To DC Bridge Rectifier	1
Mag 1 & 2	ECOS0057	Electric Magnetic Hold Down	2
	EAST0663	Increased Pressure Magnet Transformer	
	EAST0031-1	40 Amp, 2 pole, 220 V GE contactor	

40 Parts List

DESIGNATOR	PART NO.	DESCRIPTION	Q'TY.
TT1	EAST0494	Temperature Controller (Watlow)	1
TT2	EAST0494	Temperature Controller (Watlow)	1
Heater, Side, 20"	EAST0496	Cartridge, Heater 20", 220 V	1
Heater, Side, 30"	EAST0630	Cartridge, Heater 30", 220 V	1
Heater, Side, 35"	ESC00580	Cartridge, Heater, 35", 220 V	
Heater, Side, 40"	EAST0629	Cartridge, Heater, 40" 220 V	1
Heater, Side, 50"	EAST0678	Cartridge, Heater, 50"	1
Heater, Front, 16"	EAST0497	Cartridge, Heater, 16"	1
Heater, Front, 28"	EAST0555	Cartridge, Heater, 28"	1
Heater, Front, 40"	EAST0629	Cartridge, Heater, 40"	1
Heater, Front. 50"	EAST0678	Cartridge, Heater, 50"	1
Heater, Front, 70"	N/A	Use 2 x Cartridge, Heater, 35", 220V, ESC00580	1
Heater, Front, 80"	N/A	Use 2 x Cartridge, Heater, 40", 220V, EAST0629	1
Heater, Front, 100"	N/A	Use 2 x Cartridge, Heater, 50", 220V, EAST0678	1
SSR-1 Front	EAST0495	Solid State Relay	
SSR-2 Side	EAST0495	Solid State Relay	
EP000535	EAST0493	Thermocouple Front & Side	
M1	EAST0063	Conveyor Motor 20" x 16"	
M1	EAST0063	Conveyor Motor 20" x 28"	
M1	EAST0063	Conveyor Motor 20" x 40"	
M1	EAST0484	Conveyor Motor 30" x 40"	
M1	EAST0484	Conveyor Motor 40" x 40"	
M1	EAST0484	Conveyor Motor 50" x 40"	
	EAST0038	Bridge Rectifier	
	EAST0078	Capacitor, Mallory	
	EAST0421-1	Contacto – 2-Pole, 25 Amp, 220 Volt, GE	
	EAST0421	Contacto – 2-Pole, 25 Amp, 220 Volt, S & S	
	ET000134	Disconnect Box – 60 Amp, 2-Pole (Combo Unit)	
	ECOS515	Fuse, 0.5 Amp, Ceramic, Slo-Blo (for Conveyor)	
	EAST0210	Fuse 1 Amp, 250 Volt	
	ET000301	Fuse, 10 Amp, 250 Volt	

DESIGNATOR	PART NO.	DESCRIPTION	Q'TY.
	EAST0674	Firerod Cartridge Heater, 16", 110 V	
	EAST0675	Firerod Cartridge Heater, 28", 110 V	
	EAST0676	Firerod Cartridge Heater, 20", 110 V	
	EAST0629V	Firerod Cartridge Heater, 40", 110 V	
	ETL00200	Fuse, 15 Amp, 250 Volt	
	ET000186	Fuse, 5 Amp, 250 Volt (for Powered Film Unwinder)	
	ETC00125	Fuse Block, 30 Amp, 2 Pole, 250 Volt	
	EAST0077	Fuse Holder	

Mechanical

PART NO.	DESCRIPTION
I0000007	Actuator, Inverted
EAST0512	Actuator, Non-Inverted
EAST0508	Arm Casting, Infeed – 20"
EAST0631	Arm Casting, Infeed – 30"
EAST0782	Arm Casting, Infeed – 40"
EAST0967	Arm Casting, Infeed – 50"
EAST0507	Arm Casting, Outfeed – 20"
EAST0632	Arm Casting, Outfeed – 30"
EAST0781	Arm Casting, Outfeed – 40"
EAST0966	Arm Casting, Outfeed – 50"
EAST0061	Barrel Nut, Conveyor
EAST0052	Bearing, Conveyor Guide / Idler Roller
EAST0378	Bearing, Film Rack Roller - Large
EAST0380	Bearing, Film Rack Roller - Small

PART NO.	DESCRIPTION
EAST0254	Bearing, Steel, Drive Roller (1616Z-KYK)
XH360	Bolt, ¼ × 1-¼ Shoulder
EAST0462	Bolt, Film Rack Guide
EAST0379	Bolt, Film Rack Roller - Large
EAST0381	Bolt, Film Rack Roller - Small
EAST0044	Caster, 3" × 1-¾"
EAST1018	Collar, 1" Rear Shaft
EAST1020	Collar, ¼" Power Film Unwind
EAST0043	Conduit
EAST0597	Conduit - Bracket
EAST0101	Conduit Connector, ½", 90-degree
EAST0102	Conduit Connector, ½" straight with nut
EAST0214	Conveyor Adjusting Bracket
EAST0057B	Conveyor Belt, EM2016, Black
EAST0057W	Conveyor Belt, EM2016, White
EAST0058B	Conveyor Belt, EM2028, Black
EAST0058W	Conveyor Belt, EM2028, White
EAST0059B	Conveyor Belt, EM2040, Black
EAST0059W	Conveyor Belt, EM2040, White
EAST0359	Conveyor Belt, EM2050, Black
EAST0359W	Conveyor Belt, EM2050, White
EAST0527	Conveyor Belt, EM2070, Black
EAST0527W	Conveyor Belt, EM2070, White
EAST0601	Conveyor Belt, EM2080, Black
EAST0601W	Conveyor Belt, EM2080, White
EAST1107	Conveyor Belt, EM20100, Black
EAST1107W	Conveyor Belt, EM20100, White
EAST0331B	Conveyor Belt, EM3040, Black
EAST0331W	Conveyor Belt, EM3040, White
EAST1027B	Conveyor Belt, EM3050, Black
EAST1027W	Conveyor Belt, EM3050, White

PART NO.	DESCRIPTION
EAST0578B	Conveyor Belt, EM3070, Black
EAST0578W	Conveyor Belt, EM3070, White
EAST0698	Conveyor Belt, EM3080, Black
EAST0698W	Conveyor Belt, EM3080, White
EAST0691	Conveyor Belt, EM30100, Black
EAST0691W	Conveyor Belt, EM30100, White
EAST0231	Conveyor Belt, EM4040, Black
EAST0231W	Conveyor Belt, EM4040, White
EAST0613	Conveyor Belt, EM4050, Black
EAST0613W	Conveyor Belt, EM4050, White
EAST1050	Conveyor Belt, EM4070, Black
EAST1050W	Conveyor Belt, EM4070, White
EAST0692	Conveyor Belt, EM40100, Black
EAST0692W	Conveyor Belt, EM40100, White
EAST0947	Conveyor Belt, EM5050, Black
EAST0947W	Conveyor Belt, EM5050, White
	Conveyor Belt, EM5070, Black
	Conveyor Belt, EM5070, White
EAST1063	Conveyor Belt, EM5080, Black
EAST1063W	Conveyor Belt, EM5080, White
	Conveyor Belt, EM50100, Black
	Conveyor Belt, EM50100, White
SUB00079	Conveyor Crank Handle Assembly
EAST0333	Conveyor Guide Roller Tube, 30" – Side Seal
SUB00165	Conveyor Guide Roller, 20" – Side Seal (complete)
SUB00166	Conveyor Guide Roller, 30" – Side Seal (complete)
SUBA0192	Conveyor Guide Roller, 40" – Side Seal (complete)
	Conveyor Guide Roller, 50" – Side Seal (complete)
EAST0465	Counterweight, 30 x 40
EAST0526	Counterweight

PART NO.	DESCRIPTION
EAST0640	Crank Handle, Conveyor (threaded)
EAST0513	Crossover Bar – 16" (EM2016)
EAST0550	Crossover Bar – 28" (EM2028)
EAST0621	Crossover Bar – 40" (EM2040, 3040, 4040)
EAST0790	Crossover Bar – 50" (EM2050, 3050, 4050, 5050)
EAST0767	Crossover Bar – 70" (EM2070, 3070, 4070, 5070)
EAST0857	Crossover Bar – 80" (EM2080, 3080, 4080, 5080)
EAST0659	Crossover Bar – 100" (EM20100, — 50100)
EAST0816	Cutting Rule, 16-inch – Front (Supra Silverstone)
EAST0817	Cutting Rule, 28-inch – Front (Supra Silverstone)
EAST0818	Cutting Rule, 40-inch – Front (Supra Silverstone)
EAST0837	Cutting Rule, 50-inch – Front (Supra Silverstone)
EAST0820	Cutting Rule, 70-inch – Front (Supra Silverstone)
EAST0824	Cutting Rule, 80-inch – Front (Supra Silverstone)
EAST0839	Cutting Rule, 100-inch – Front (Supra Silverstone)
EAST0815	Cutting Rule, 20-inch – Side (Supra Silverstone)
EAST0819	Cutting Rule, 30-inch – Side (Supra Silverstone)
EAST0777	Cutting Rule, 40-inch – Side (Supra Silverstone)
EAST0867	Cutting Rule, 40-inch – Side (Supra Silverstone)
EAST0868	Cutting Rule, 50-inch – Side (Supra Silverstone)
EAST0134-8	Drawer – Small Sealers: EM2016, EM2028, & EM2040
EAST0045	Drawer – Large Sealers: EM2050 and up to EM50100
EAST0928	Duo Seal Arrow Insert, 16-inch Front Bar – Supra Silverstone
EAST0926	Duo Seal Arrow Insert, 28-inch Front Bar – Supra Silverstone
EAST0924	Duo Seal Arrow Insert, 40-inch Front Bar – Supra Silverstone
EAST0936	Duo Seal Arrow Insert, 50-inch Front Bar – Supra Silverstone
EAST0765	Duo Seal Arrow Insert, 70-inch Front Bar – Supra Silverstone
	For 80" Duo Seal Arrow Insert, Use 2 × 40", EAST0924
	For 100" Duo Seal Arrow Insert, Use 2 × 50", EAST0936

PART NO.	DESCRIPTION
EAST0918	Duo Seal Arrow Insert, 20-inch Side Bar – Supra Silverstone
EAST0925	Duo Seal Arrow Insert, 30-inch Side Bar – Supra Silverstone
EAST0776	Duo Seal Arrow Insert, 40-inch Side Bar – Supra Silverstone
EAST0936L	Duo Seal Arrow Insert, 50-inch Side Bar – Supra Silverstone
EAST0919	Duo Seal Mushroom Insert, 16-inch Front Bar – Supra Silverstone
EAST0920	Duo Seal Mushroom Insert, 28-inch Front Bar – Supra Silverstone
EAST0916	Duo Seal Mushroom Insert, 40-inch Front Bar – Supra Silverstone
EAST0786	Duo Seal Mushroom Insert, 50-inch Front Bar – Supra Silverstone
EAST0763	Duo Seal Mushroom Insert, 70-inch Front Bar – Supra Silverstone
	For 80" Duo Seal Mushroom Insert, Use 2 × 40", EAST0916
	For 100" Duo Seal Mushroom Insert, Use 2 × 50", EAST0786
EAST0918	Duo Seal Mushroom Insert 20-inch Side Bar – Supra Silverstone
EAST0917	Duo Seal Mushroom Insert 30-inch Side Bar – Supra Silverstone
EAST0776	Duo Seal Mushroom Insert 40-inch Side Bar – Supra Silverstone
EAST0517	Duo Seal Poly Insert 16-inch Front Bar – Supra Silverstone
EAST0549	Duo Seal Poly Insert 28-inch Front Bar – Supra Silverstone
EAST0616	Duo Seal Poly Insert 40-inch Front Bar – Supra Silverstone
EAST0785	Duo Seal Poly Insert 50-inch Front Bar – Supra Silverstone
EAST0762	Duo Seal Poly Insert 70-inch Front Bar – Supra Silverstone
	For 80" Duo Seal Poly Insert Front Bars, Use 2 × 40", EAST0616
	For 100" Duo Seal Poly Insert Front Bars, Use 2 × 50", EAST0785
EAST0516	Duo Seal Poly Insert 20-inch Side Bar – Supra Silverstone
EAST0615	Duo Seal Poly Insert 30-inch Side Bar – Supra Silverstone
EAST0775	Duo Seal Poly Insert 40-inch Side Bar – Supra Silverstone
EAST0785L	Duo Seal Poly Insert 50-inch Side Bar – Supra Silverstone
EAST0509	Felt Pad
SUB00123	Film Rack Guide Assembly

PART NO.	DESCRIPTION
EAST0674	Firerod Cartridge Heater, 16-inch – 110 Volt
EAST0497	Firerod Cartridge Heater, 16-inch – 220 Volt
EAST0675	Firerod Cartridge Heater, 28-inch – 110 Volt
EAST0555	Firerod Cartridge Heater, 28-inch – 220 Volt
ESC00580	Firerod Cartridge Heater, 35-inch – 220 Volt
EAST0629	Firerod Cartridge Heater, 40-inch – 220 Volt
EAST0678	Firerod Cartridge Heater, 50-inch – 220 Volt
	For 70" Firerod Cartridge Heater – 220 Volt, Use 2 × 35" ESC00580
	For 80" Firerod Cartridge Heater – 220 Volt, Use 2 × 40" EAST0629
	For 100" Firerod Cartridge Heater – 220 Volt, Use 2 × 50" EAST0678
EAST0676	Firerod Cartridge Heater, 20-inch – 110 Volt
EAST0496	Firerod Cartridge Heater, 20-inch – 220 Volt
EAST0630	Firerod Cartridge Heater, 30-inch – 220 Volt
EAST0629	Firerod Cartridge Heater, 40-inch – 220 Volt
EAST0678	Firerod Cartridge Heater, 50-inch – 220 Volt
EAST0165	Handle Grip Material
EAST0148	Handle, Metal, For Sealer with 16-inch Front Bar
EAST0246	Handle, Metal, For Sealer with 28-inch Front Bar
EAST0247	Handle, Metal, For Sealer with 40-inch Front Bar
EAST0745	Handle, Metal, For Sealer with 50-inch Front Bar
EAST0747	Handle, Metal, For Sealer with 70-inch Front Bar
EAST0748	Handle, Metal, For Sealer with 80-inch Front Bar
EAST0177	Handle, Metal, For Sealer with 100-inch Front Bar
EAST0456	Head Return Arm
EAST0461	Head Return Cylinder, Complete
SUB00047	Head Return Cylinder – Retro Fit Kit (EM2016 & 2018)
SUB00049	Head Return Cylinder – Retro Fit Kit (EM2030 & 2040)
N/A	Head Return Cylinder – Retro Fit Kit (EM2050)

48 Parts List

PART NO.	DESCRIPTION
EAST0084	Hole Punch Ball
EAST0085	Hole Punch Casting
EAST0083	Hole Punch Die
EAST0268	Hole Punch Knob
EAST0086	Hole Punch Solenoid, Electric
EAST0087	Hole Punch Strain Relief Connector
EAST0511	Hot Knife Saddle With Slot
EAST0514	Hot Knife Spacer Block
EINVT116	Inverting Rod, 16" Upper or Lower
EINVT120	Inverting Rod, 20" Upper or Lower
EINVT124	Inverting Rod, 24" Upper or Lower
EAST0441	Knob, Film Rack Guide
ETC00210	Knob, Pin Perforator
ETC00002	Knob, S-Handle, Conveyor
EAST0900	Magnet Holder – Upper Center Block
EAST0901	Magnet Holder – Upper Pad Block
EAST0741	Magnet Holder, Lower
EAST0338	Magnet Holder, Upper
SUB00065	Magnet, Upper
EAST0029	Micro Limit Switch – Safety Override – Pulse – Conveyor
ETC00310	Micro Switch On/Off Face Plate
EAST0107	Micro Switch, Power Film Unwind
ETL00205	Motor, 118 HP – 160 RPM (Power Film Unwind)
EAST0063	Motor, Conveyor – 139 RPM
EAST0484	Motor, Conveyor Takeaway – Heavy Duty
65000085AP	Paint, Black Epoxy Part A - Pint
65000085BP	Paint, Black Epoxy Part B - Pint
EAST0022	Pillow Block, 1-inch

PART NO.	DESCRIPTION
EAST0367	Pin Perforator Guard
EAST0368	Pin Perforator Lower Pad
EAST0366	Pin Perforator Wheels – For 5/8" Shaft
EAST0156	Product Separator Tray and Tubes on Frame - ¾ Snap ring, Heavy Duty
EAST0142L	Product Separator Tray, 20" × 16" - Left
EAST0142R	Product Separator Tray, 20" × 16" - Right
EAST0261L	Product Separator Tray, 20" × 28" - Left
EAST0261R	Product Separator Tray, 20" × 28" - Right
EAST0262L	Product Separator Tray, 20" × 40" - Left
EAST0262R	Product Separator Tray, 20" × 40" - Right
EAST0332L	Product Separator Tray, 30" × 40" - Left
EAST0332R	Product Separator Tray, 30" × 40" - Right
EAST0482L	Product Separator Tray, 30" × 50" - Left
EAST0482R	Product Separator Tray, 30" × 50" - Right
SEAST0142L	Product Separator Tray, Stainless Steel, EM2016 - Left
SEAST0142R	Product Separator Tray, Stainless Steel, EM2016 - Right
	Product Separator Tray, Stainless Steel, EM2028 - Left
EAST0317R	Product Separator Tray, Stainless Steel, EM2028 - Right
SEAST0262L	Product Separator Tray, Stainless Steel, EM2040 - Left
SEAST0262R	Product Separator Tray, Stainless Steel, EM2040 - Right
SEAST0360L	Product Separator Tray, Stainless Steel, EM2050 - Left
SEAST0360R	Product Separator Tray, Stainless Steel, EM2050 - Right
SEAST0535L	Product Separator Tray, Stainless Steel, EM2070 - Left
SEAST0535R	Product Separator Tray, Stainless Steel, EM2070 - Right
	Product Separator Tray, Stainless Steel, EM2080 - Left
	Product Separator Tray, Stainless Steel, EM2080 - Right
SEAST0322L	Product Separator Tray, Stainless Steel, EM3040 – Left (Complete)
SEAST0322R	Product Separator Tray, Stainless Steel, EM3040 - Right (Complete)
SEAST0482L	Product Separator Tray, Stainless Steel, EM3050 - Left (Complete)
SEAST0482R	Product Separator Tray, Stainless Steel, EM3050 - Right (Complete)

PART NO.	DESCRIPTION
SEAST0486L	Product Separator Tray, Stainless Steel, EM3070 - Left (Complete)
SEAST0486R	Product Separator Tray, Stainless Steel, EM3070 - Right (Complete)
SEAST0875L	Product Separator Tray, Stainless Steel, EM3080 - Left (Complete)
SEAST0875R	Product Separator Tray, Stainless Steel, EM3080 - Right (Complete)
SEAST0911L	Product Separator Tray, Stainless Steel, EM30100 - Left (Complete)
SEAST0911R	Product Separator Tray, Stainless Steel, EM30100 - Right (Complete)
SEAST0569L	Product Separator Tray, Stainless Steel, EM4040 - Left (Complete)
SEAST0569R	Product Separator Tray, Stainless Steel, EM4040 - Right (Complete)
SEAST0570L	Product Separator Tray, Stainless Steel, EM4050 - Left (Complete)
SEAST0570R	Product Separator Tray, Stainless Steel, EM4050 - Right (Complete)
SEAST0669L	Product Separator Tray, Stainless Steel, EM4070 - Left (Complete)
SEAST0669R	Product Separator Tray, Stainless Steel, EM4070 - Right (Complete)
	Product Separator Tray, Stainless Steel, EM4080 - Left (Complete)
	Product Separator Tray, Stainless Steel, EM4080 - Right (Complete)
	Product Separator Tray, Stainless Steel, EM40100 - Left (Complete)
	Product Separator Tray, Stainless Steel, EM40100 - Right (Complete)
	Product Separator Tray, Stainless Steel, EM5050 - Left (Complete)
	Product Separator Tray, Stainless Steel, EM5050 - Right (Complete)
	Product Separator Tray, Stainless Steel, EM5070 - Left (Complete)
	Product Separator Tray, Stainless Steel, EM5070 - Right (Complete)
SEAST0186L	Product Separator Tray, Stainless Steel, EM5080 - Left (Complete)
SEAST0186R	Product Separator Tray, Stainless Steel, EM5080 - Right (Complete)
	Product Separator Tray, Stainless Steel, EM50100 - Left (Complete)
	Product Separator Tray, Stainless Steel, EM50100 - Right (Complete)
ESC00542	Relay Base for 220 Volt Signaline Timer
EAST0495	Relay, Solid State
EAST0079	Resistor, Hole Punch
EAST0053	Roller With Sprocket, 20-inch Conveyor Drive
EAST0328	Roller With Sprocket, 30-inch Conveyor Drive
	Roller With Sprocket, 40-inch Conveyor Drive
	Roller With Sprocket, 50-inch Conveyor Drive

PART NO.	DESCRIPTION
SUB00126	Roller, 26" Film Rack – Large (Complete)
SUB00085	Roller, 26" Film Rack – Small (Complete)
EAST0198	Roller, Idler (Complete – For 20" Side Seal Sealers)
EAST0329	Roller, Idler (Complete – For 30" Side Seal Sealers)
EAST0729	Roller, Idler (Complete – For 40" Side Seal Sealers)
EAST0970	Roller, Idler (Complete – For 50" Side Seal Sealers)
EAST0385	Roller, PFU Drive
ESC00037	Saddle Center
EAST0520	Safety Shield, Front – Inner EM2016, 16"
EAST0552	Safety Shield, Front – Inner EM2028, 18"
EAST0622	Safety Shield, Front – Inner EM2040, 3040, and 4040, 40"
EAST0788	Safety Shield, Front – Inner EM2050, 3050, 4050, and 5050, 50"
EAST0793	Safety Shield, Front – Inner EM2070, 3070, 4070, and 5070, 70"
EAST0859	Safety Shield, Front – Inner EM2080, 3080, 4080, and 5080, 80"
EAST0658	Safety Shield, Front – Inner EM20100, 30100, 40100, and 50100, 100"
EAST0521	Safety Shield, Front – Outer EM2016, 17"
EAST0553	Safety Shield, Front – Outer EM2028, 28"
EAST0623	Safety Shield, Front – Outer EM2040, 3040, and 4040, 40"
EAST0789	Safety Shield, Front – Outer EM2050, 3050, 4050, and 5050, 50"
EAST0794	Safety Shield, Front – Outer EM2070, 3070, 4070, and 5070, 70"
EAST0860	Safety Shield, Front – Outer EM2080, 3080, 4080, and 5080, 80"
EAST0657	Safety Shield, Front – Outer EM20100, 30100, 40100, and 50100, 100"
EAST0522	Safety Shield, Side – Inner EM2016, 2028, 2040, 2050, 2070, 2080, 20100
EAST0624	Safety Shield, Side – Inner EM3040, 3050, 3070, 3080, and 30100
EAST0778	Safety Shield, Side – Inner EM4040, 4050, 4070, 4080, and 40100
EAST0963	Safety Shield, Side – Inner EM5050, 5070, 5080, and 50100
EAST0523	Safety Shield, Side – Outer EM2016, 2028, 2040, 2050, 2070, 2080, 20100
EAST0625	Safety Shield, Side – Outer EM3040, 3050, 3070, 3080, and 30100

PART NO.	DESCRIPTION
EAST0779	Safety Shield, Side – Outer EM4040, 4050, 4070, 4080, and 40100
EAST0964	Safety Shield, Side – Outer EM5050, 5070, 5080, and 50100
EAST0008	Seal Bar, 16-inch Front-Lower
EAST0245	Seal Bar, 28-inch Front Lower
EAST0255	Seal Bar, 40-inch Front Lower
EAST0252	Seal Bar, 50-inch Front Lower
EAST0529	Seal Bar, 70-inch Front Lower
EAST0892	Seal Bar, 80-inch Front Lower
EAST0861	Seal Bar, 100-inch Front Lower
EAST0007	Seal Bar, 20-inch Side Lower
EAST0330	Seal Bar, 30-inch Side Lower
EAST0572	Seal Bar, 40-inch Side Lower
EAST0965	Seal Bar, 50-inch Side Lower
EAST0310	Separator Rod, Power Film Unwind
EAST0047	Shaft, 21-inch Rear Head Return For EM2016
EAST0048	Shaft, 33-inch Rear Head Return For EM2028
EAST0049	Shaft, 44-inch Rear Head Return For EM2040, 3040, and 4040
EAST0046	Shaft, 54-inch Rear Head Return For EM2050, 3050, 4050, and 5050
EAST0532	Shaft, 74-inch Rear Head Return For EM2070, 3070, 4070, and 5070
EAST0890	Shaft, 84-inch Rear Head Return For EM2080, 3080, 4080, and 5080
EAST0176	Shaft, 104" Rear Head Return For EM20100, 30100, 40100, and 50100
EAST0369	Shaft, Pin Perforator
EAST0515	Spacer Block, Corner
EAST0315	Speed Control – Without Dial Kit – DC Control
EAST0315A	Speed Control Dial Kit
EAST0209	Sponge, Rubber, 1/4" x 3/4", 20 Ft. Roll

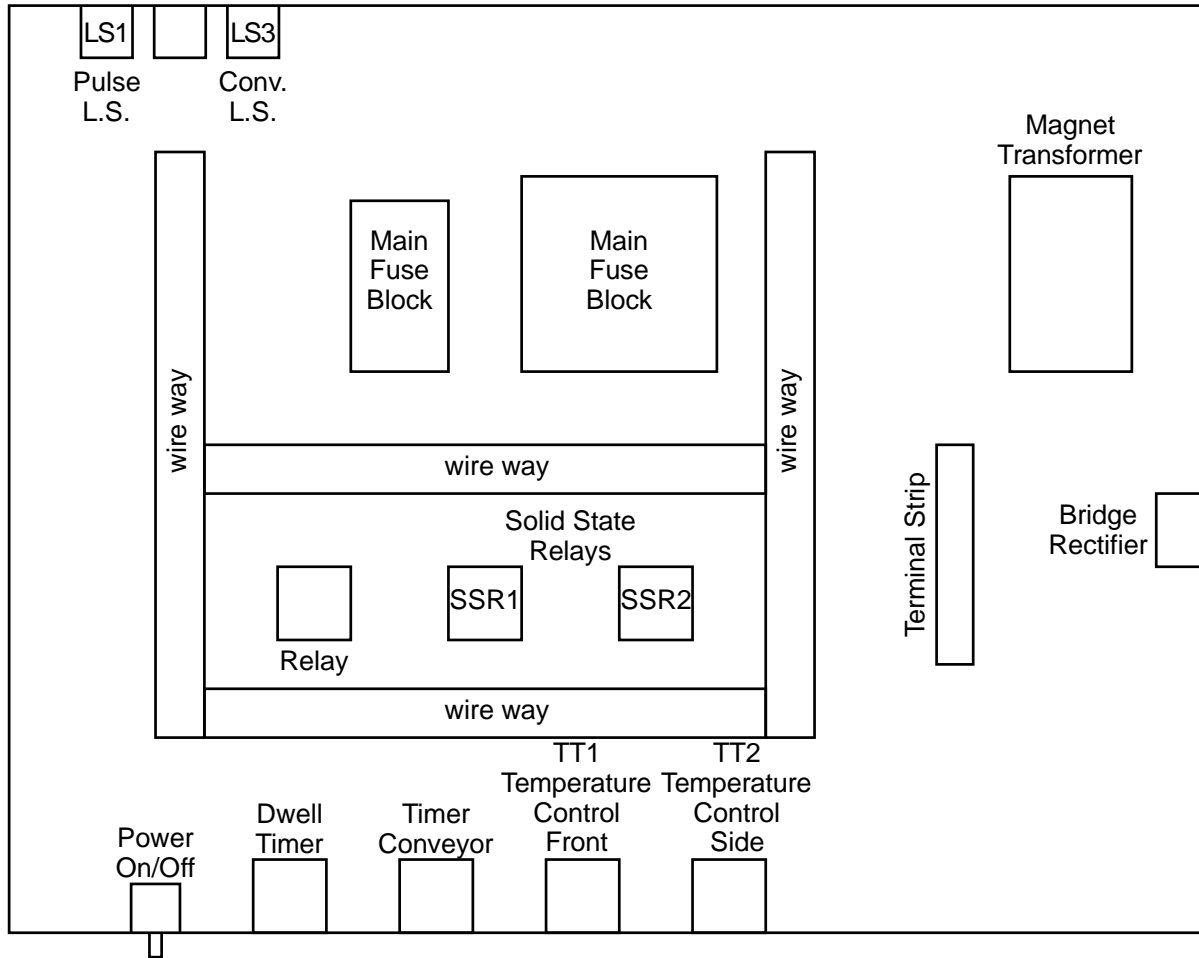
PART NO.	DESCRIPTION
EAST1007	Spring, Safety Shield Return
EAST0199	Sprocket, Conveyor Motor
EAST0051	Sprocket, Drive Roller, 5/8-inch Bore
EAST0305	Sprocket, Power Film Unwind
ETC00309	Switch, On/Off Power
EAST0202	PTFE Tape, ½-inch – 10 Mil x 10 yards
EAST1006	PTFE Tape, ½-inch – 10 Mil x 36 yards
EAST0201	PTFE Tape, ¾-inch – 10 Mil x 10 yards
EAST1005	PTFE Tape, ¾-inch – 10 Mil x 36 yards
EAST0494	Temperature Controller
EP000535	Thermocouple
ESC00537	Timer, Signaline – 220 Volts (Current Style, 1998 to present)
EAST0030	Timer, Small – 220 Volts (Old Style, used 1992 – 1998)
EAST1030	Timer, Tenor – 220 Volts
EAST0054	Timing Belt, Drive, EM2016
EAST0055	Timing Belt, Drive, EM2028, 2040, 2050, 2070, and 2080,
EAST1000	Timing Belt, Power Film Unwind (Old Style)
EAST0050	Transformer, Stepdown – 220 Volts to 110 Volts For Hole Punch
EAST0036	Transformer, Stepdown – 220 Volts to 30 Volts
SUB00488	Transition Chute – Transfer Between Sealer and Tunnel
SUB00300	Transition Roller – Between Sealer and Tunnel – Combo
SUB00301	Transition Roller Kit, Infeed, ET1610-36 and ET1610-48
EAST0143	Tube, Product Tray

54 Parts List

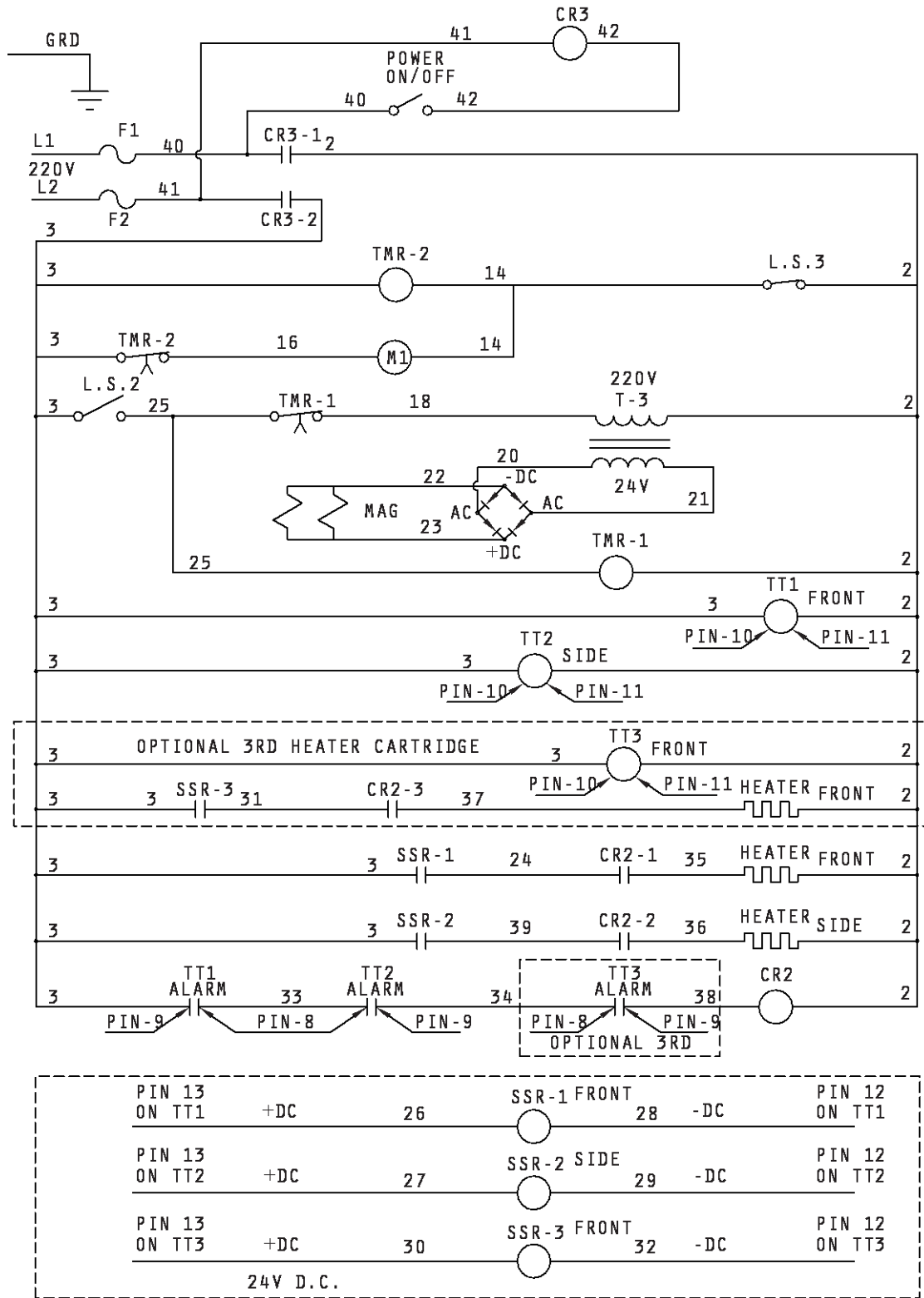
PART NO.	DESCRIPTION
EAST0525	Wire Guard, 16-inch – Front
EAST0554	Wire Guard, 28-inch – Front
EAST0627	Wire Guard 40-inch – Front
EAST0791	Wire Guard, 50-inch – Front
EAST0792SP	Wire Guard, 70-inch – Front
EAST0627E	Wire Guard, 80-inch – Front
	Wire Guard, 100-inch – Front
EAST0524	Wire Guard, 20-inch – Side
EAST0626	Wire Guard, 30-inch – Side
EAST0780	Wire Guard, 40-inch – Side
EAST0962	Wire Guard, 50-inch – Side

Appendix A: Electrical Schematics

Panel Layout



Electrical Schematic



PIN-3 +
 PIN-2 - THERMOCOUPLE TO TTI, TT2, TT3

Appendix B: Temperature Setting Specifications for Shrink-Wrap Plastics

Mushroom Insert

PVC (Poly-Vinyl Chloride)	Temperature settings: Pad type: Dwell Time:	325° F front bar; 325° F side bar Felt Approximately 1 second
Polyolefin	Temperature settings: Pad type: Dwell Time:	335° F front bar; 335° F side bar Sponge rubber Approximately 1 second
Polyethylene	Temperature settings: Pad type: Dwell Time:	360° F front bar; 360° F side bar Sponge rubber Approximately 1.5 second

Appendix C: L-Sealer Size Estimating

L-Sealer Center-Folded Film Size Estimating Table

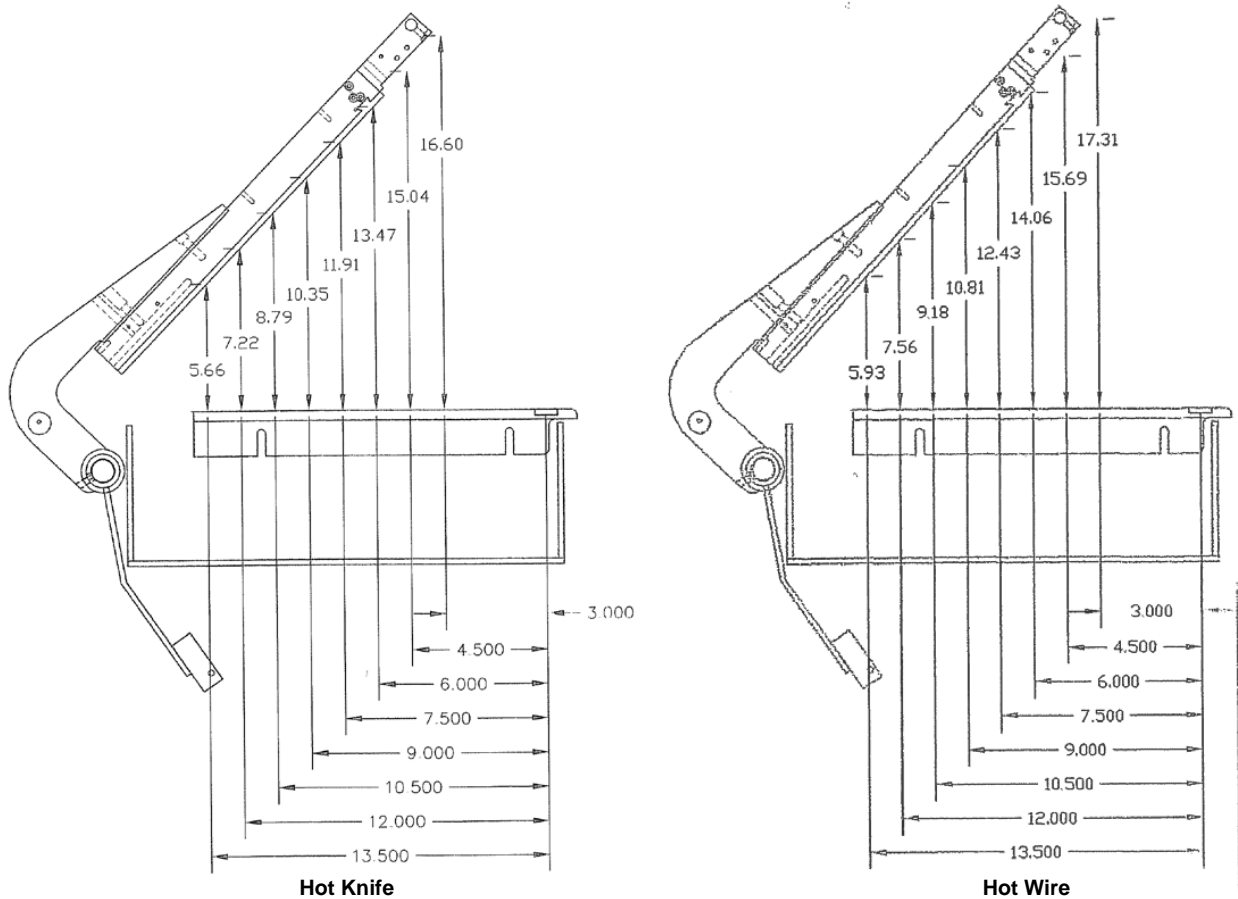
Package Height	*** Roll Width Sizes																														Maximum Film Widths:	
	0	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	Econo L-Sealers
8"	Are Rounded																														19"	24"
7.5"	Up To The Next																														20"	24"
7"	Inch Where																														30"	34"
6.5"	Necessary																														40"	44"
6"	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34												
5.5"	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34												
5"	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34										
4.5"	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34									
4"	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34								
3.5"	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34							
3"	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34						
2.5"	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34					
2"	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34			
1.5"	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34			
1"	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33			

To calculate estimated per-package cost for manual and semi-automatic L-sealers, use the following formulas.

- 1) Center-Folded film – width of roll of film =
- 2) Cutoff Film length – film going across front seal bar =
- 3) Film usage – to calculate the amount of film used per package =
- 4) Per package cost

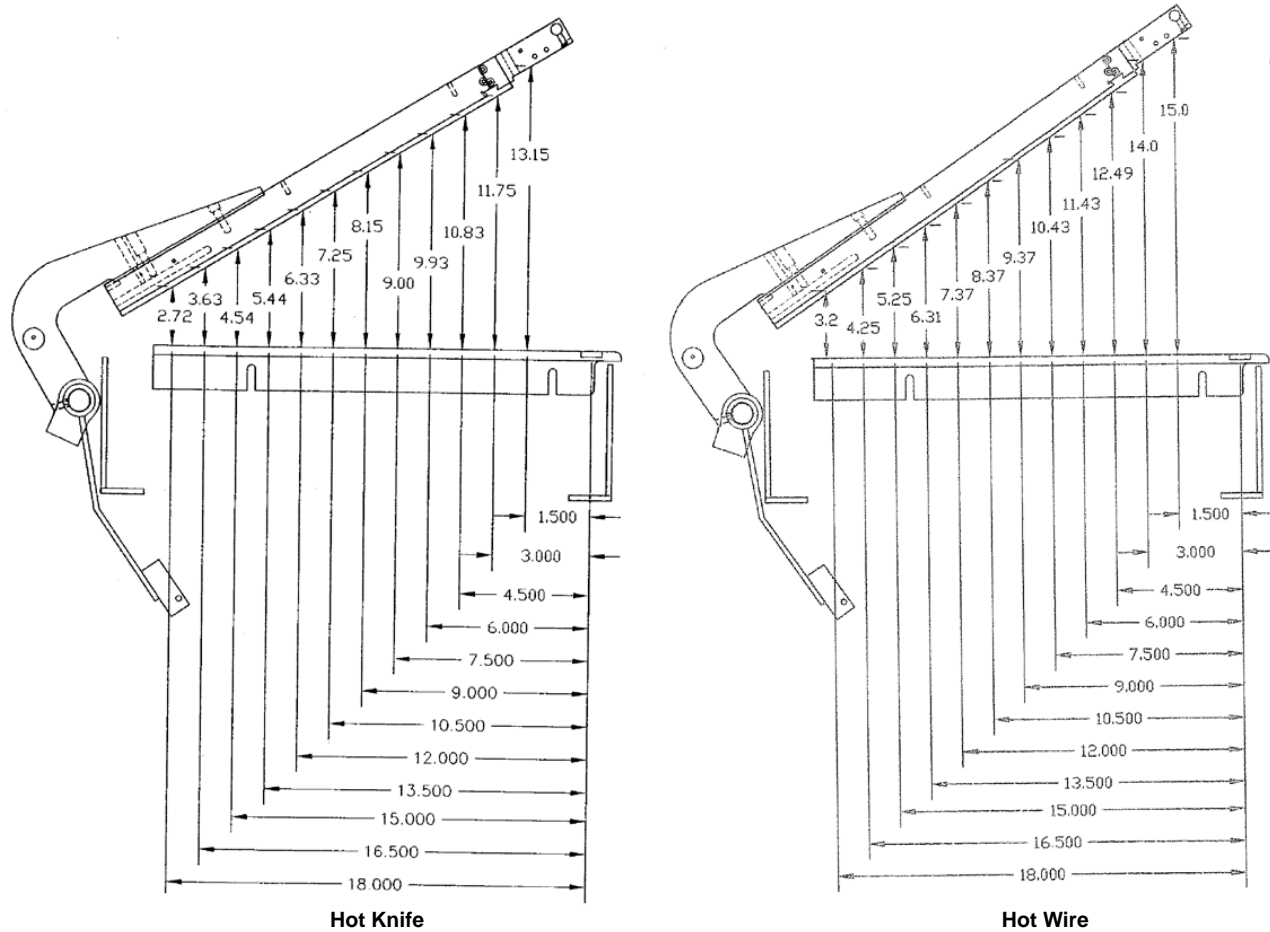
16-inch Side Seal Package Size Estimation

The following Eastey Enterprises side seal bar size dimensions are provided to make sure your product will fit under the side seal bar. You will need to know your product height and width to use these figures effectively.



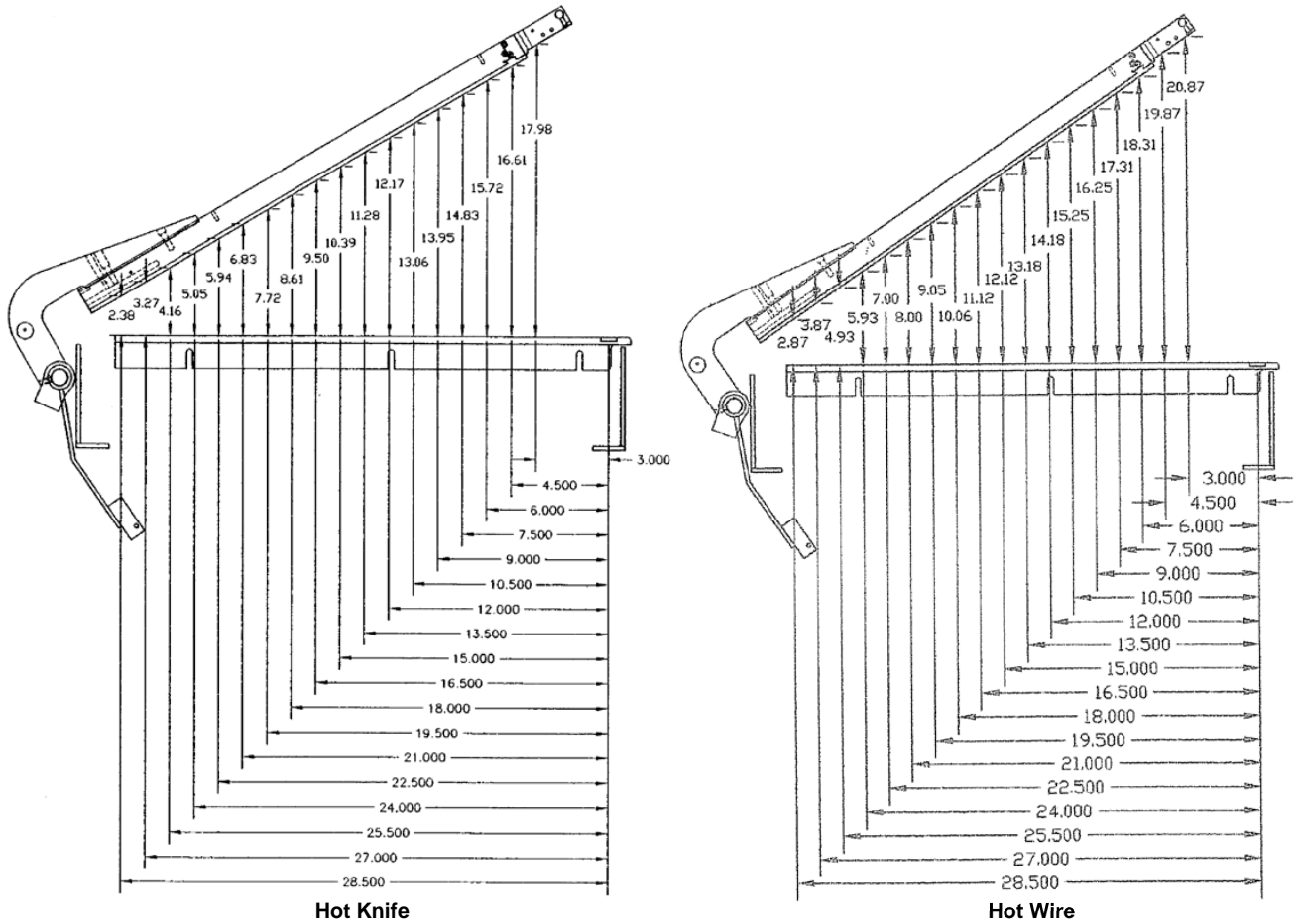
20-inch Side Seal Package Size Estimation

The following Eastey Enterprises side seal bar size dimensions are provided to make sure your product will fit under the side seal bar. You will need to know your product height and width to use these figures effectively.



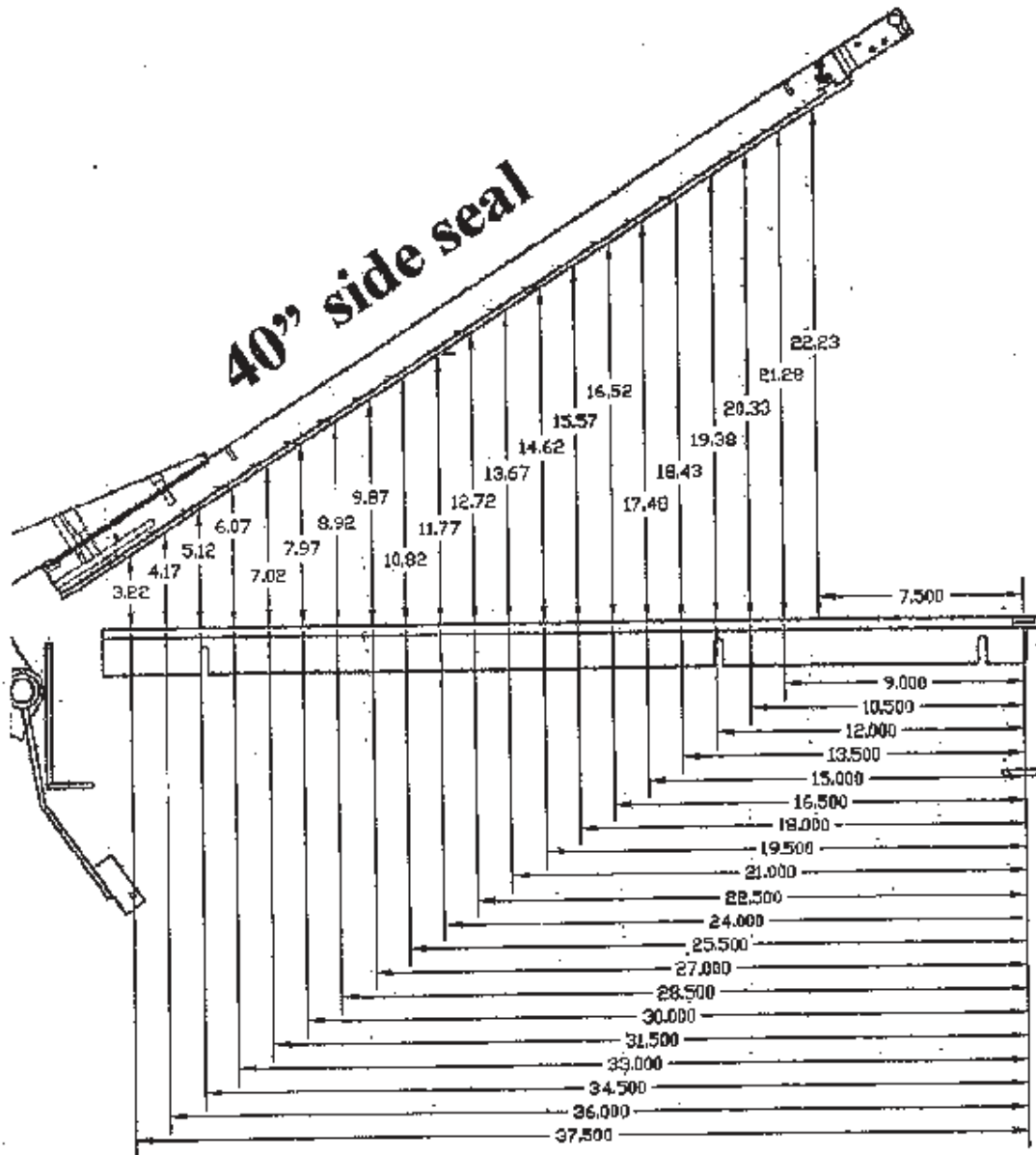
30-inch Side Seal Package Size Estimation

The following Eastey Enterprises side seal bar size dimensions are provided to make sure your product will fit under the side seal bar. You will need to know your product height and width to use these figures effectively.



40-inch Side Seal Package Size Estimation

The following Eastey Enterprises side seal bar size dimensions are provided to make sure your product will fit under the side seal bar. You will need to know your product height and width to use these figures effectively.



Warranty Statement

EM Professional Series Semi-Automatic L-Sealers

Warranty Statement

Eastey Enterprises warrants that all of the products it ships will be in good working order and free from defects in material and workmanship for a period of two (2) years from the date of shipment by Eastey and will conform to the published specifications for that product. Spare parts that are manufactured in house by Eastey will be warranted for two (2) years. Bought out parts will be warranted for one (1) year.

Warranty Period – Specific Items

Drive motor(s):	1 year
Gear reducer:	1 year
Termination Post	30 days
Conveyor Belt	30 days
Hole Punches	30 days (ball and die)
Knurled Nut	30 days

The following parts are considered to be consumable items and not under warranty: fuses, ¼" x ¾" sponge rubber, copper heat sinks, 036 Nichrome wire, ¾" PTFE tape, and ½" PTFE tape.

All other parts: 1 year (Except for moving parts which are subject to normal wear, tear and replacement which are warranted to be free from defects in material and workmanship.)

Sealing Quality

Sealing quality achieved in a given application is dependent on the installation, the material handling, and the maintenance provided. Eastey makes no warranty that the sealing quality achieved in an application will be the same as that achieved on a test piece in our demo facility.

Shipping Policy

Customer pays all incoming shipping. If the item is defective and under warranty, Eastey pays return shipping charges for least costly method. If expedited shipping is desired, customer must furnish his shipping account and shipping fees will be charged to that account.

Warranty Verification

If you conclude that a product may be defective and may be covered by warranty, obtain a Return Material Authorization number by calling our technical support number (toll free at 1-800-835-9344, or 763-428-4846 or Fax: 763-795-8867) or e-mail: info@eastey.com. Based on the recommendation from Eastey technical support, replacement components may be shipped out via UPS Ground or similar method. If expedited shipping is desired, customer must furnish their shipping account and shipping fees will be charged to that account. Customer is required to return the

defective component to Eastey. If, after 30 days, Eastey hasn't received the defective component, the customer will be invoiced for the replacement component. If the returned component is found to not be eligible for warranty, Easty will contact the customer and the customer will be invoiced for the replacement component.

Warranty Eligibility

The warranty provided by Eastey Enterprises, Inc. is only to the original buyer.

Limited Warranty

THE ABOVE WARRANTY IS EXCLUSIVE AND IN LIEU OF ALL OTHER WARRANTIES, WHETHER EXPRESSED OR IMPLIED, INCLUDING THE IMPLIED WARRANTIES OF MERCHANTABILITY, FITNESS FOR A PARTICULAR PURPOSE AND NONINFRINGEMENT.

Disclaimer of Damages

REGARDLESS OF WHETHER ANY REMEDY SET FORTH HEREIN FAILS OF ITS ESSENTIAL PURPOSE, IN NO EVENT WILL EASTEY ENTERPRISES, INC. BE LIABLE FOR ANY SPECIAL, CONSEQUENTIAL, INDIRECT OR SIMILAR DAMAGES, INCLUDING LOST PROFIT OR LOST OPPORTUNITIES OF ANY TYPE ARISING OUT OF THE USE OR INABILITY TO USE THESE PRODUCTS EVEN IF EASTEY ENTERPRISES, INC. HAS BEEN ADVISED OF THE POSSIBILITY OF SUCH DAMAGES.

Customer Support

Eastey Technical Service

For help setting up or operating the EM Professional Series L-Sealer, please contact Eastey Technical Service at one of the numbers listed below.

Toll-Free Phone	800-835-9344
Phone	763-428-4846
Fax	763-795-8867
E-mail	info@eastey.com
Web	www.eastey.com

Thank you again for your purchase of Eastey products. We are pleased to be a part of your packaging needs.



EASTEY®