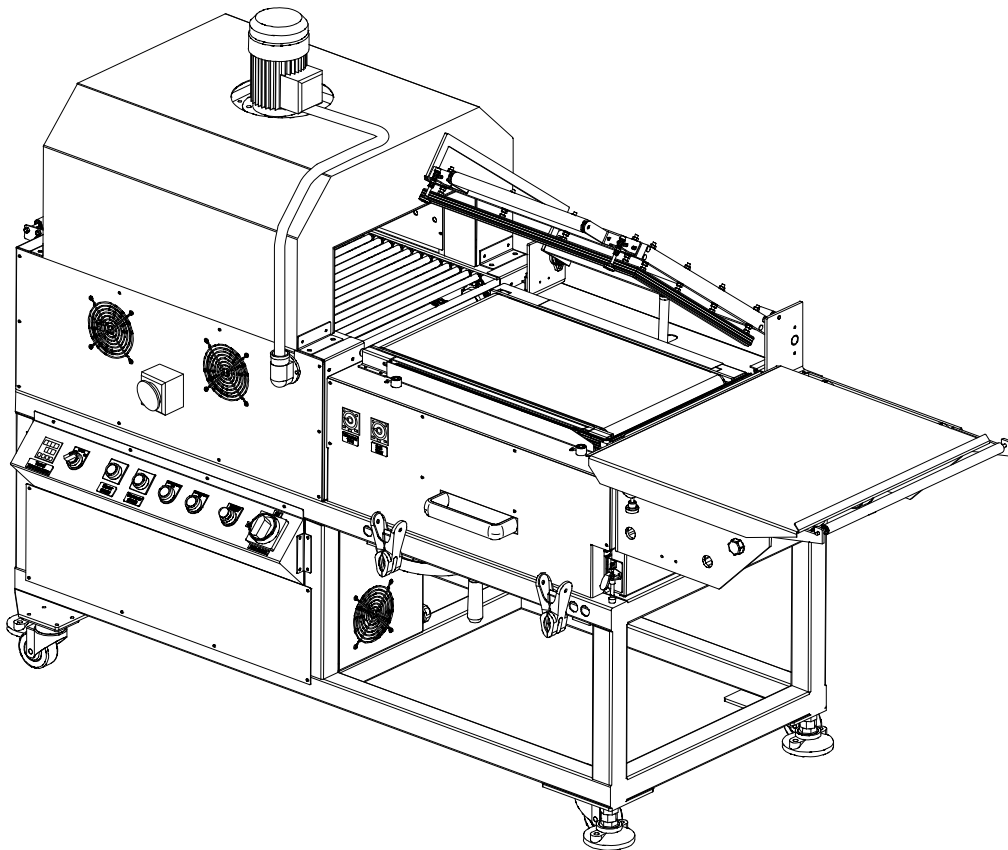


# VS1620T

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## Hot-Band L-Sealer & Tunnel Combo Value Series

### User Guide



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**EASTEY**<sup>®</sup>



# **VS1620T**

## **Hot-Band L-Sealer & Heat Tunnel Combo Unit Value Series**

### **User Guide**

Revised 03/01/2022

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# Safety

Always disconnect electrical power before attempting maintenance to any electrical or moving parts. Do not tamper with electrical wiring.

Keep hands away from moving conveyors and assemblies.

Never operate this or any moving equipment without all covers and guards in place.

Do not increase the factory settings on either the mechanical or electrical overload devices.

Do not make any modifications to either the electrical circuitry or the mechanical assemblies of this machinery.

Heat sealing equipment can become very hot after a period of use. Keep hands away from hot surfaces if the machine is in operation or has been running recently.

Adequate ventilation should be provided at all times. The use of certain types of plastic film in sealing or shrinking equipment may result in the release of hazardous fumes due to the result of 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.

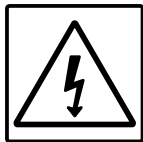
## Explanation of Symbols



Caution sign or Safety Alert symbol. Indicates caution, be alert, Your safety is involved. Knowledge of safe operation is required.



Ground symbol. Indicates ground. Use Class-3 (lower than 1000hms) cable to ground to earth. Incomplete grounding may lead to electrical shock.



Electrical hazard. Indicates electrical danger. Only a trained electrician can uncover the electrical panel or box.



Pinch hazard. Do not put your hands or any object on the moving mechanism. Shut down the machine before doing any maintenance, repair, or adjustment.



Crush hazard. Do not put your hands or any object on the moving mechanism. Shut down the machine before performing maintenance, repair, or adjustment.



High temperature hazard. Do not touch or place hands close to the heating source to avoid burns. Proceed with any maintenance only when the temperature of the heater or other heat source has cooled down to room temperature.



Moisture hazard. Keep equipment dry. This equipment is designed for indoor operation in a typical clean, dry factory environment, protected from rain and moisture. Do not operate the machine in any extremely wet or oily environment that may exceed operating specifications.

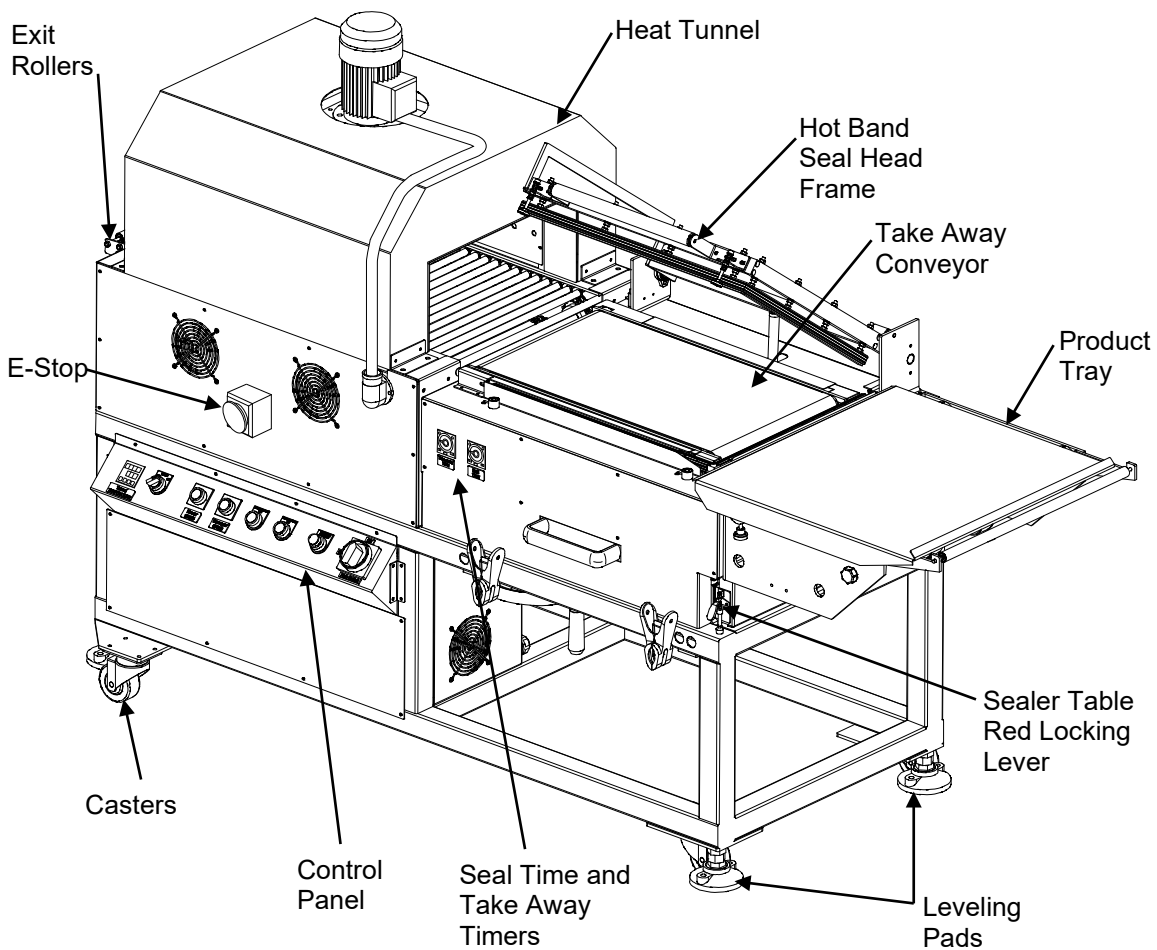


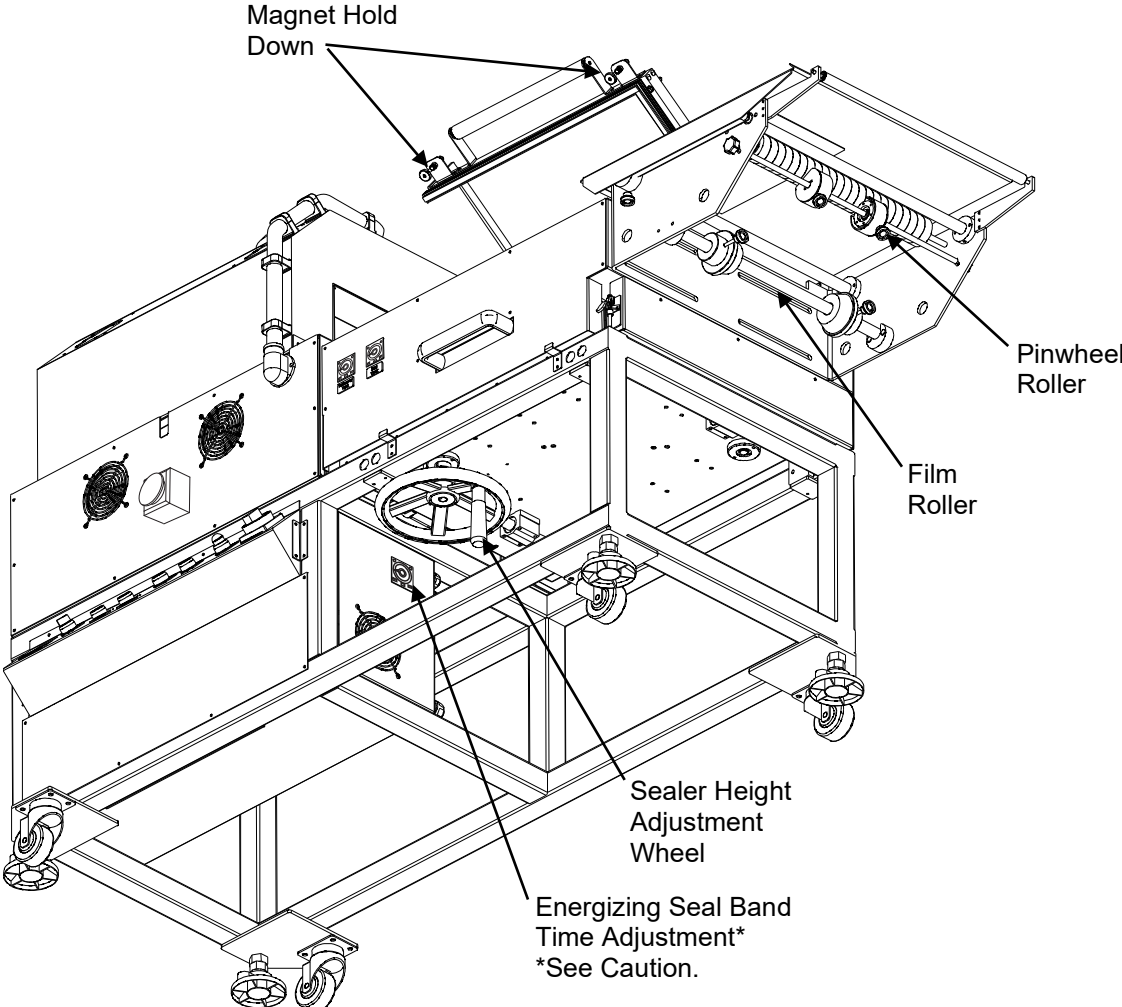
# Introduction

## VS1620T Hot-Band L-Sealer and Heat Tunnel Combo

The Easteys VS1620T Hot-Band L-Sealer and Heat Tunnel Combo will seal and shrink wrap a variety of products all on one frame. It is designed to be very easy to set up and operate.

### System Overview



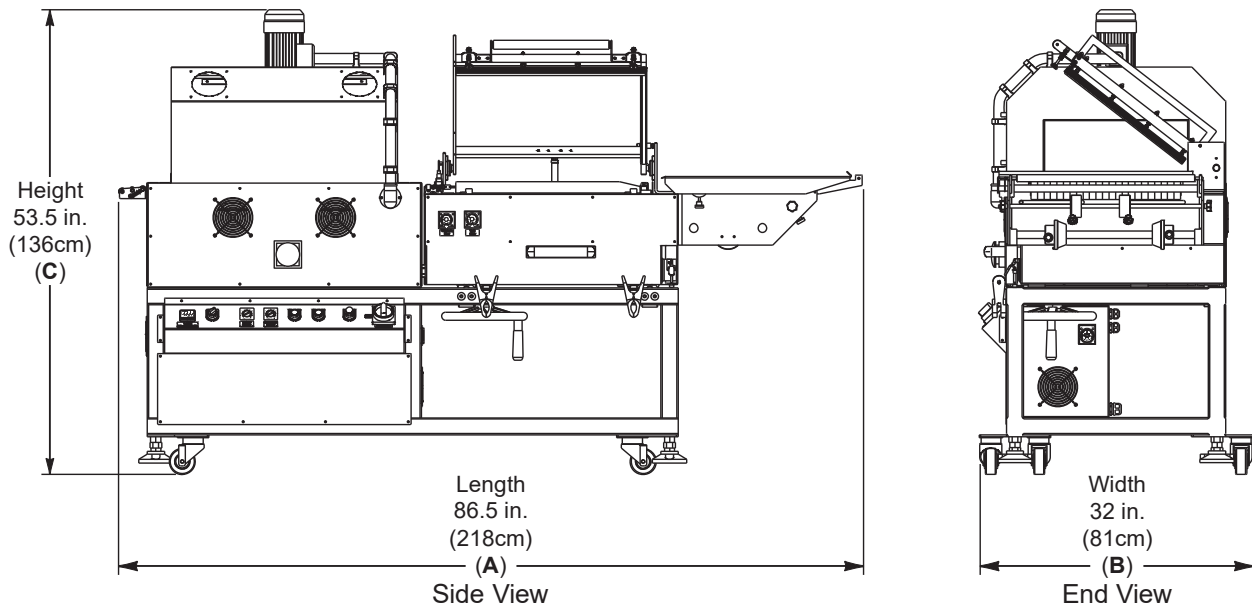


### Specifications

Model	L-Bar Sealing Machine
Film Material	Polyolefin Shrink Film 8in (20cm) – 18in (45cm) width
Voltage	220VAC 50/60Hz 30 Amps Single Phase
Machine Weight	650 lbs. (295kg)
Shipping Weight	750 lbs. (340kg)

## Dimensions

Dimensions are shown in inches (and centimeters).



Specification	Details
Machine Dimensions	Length (A) = 86.5 in (218cm) Width (B) = 32 in. (81cm) Height (C) = 53.25 in (134cm)
Tunnel Chamber Dimensions	Length = 26 in (66cm) Width = 16 in. (41cm) Height = 7 in (18cm)
Conveyor Dimensions	Length = 24 in. (61cm) Width = 13.5 in. (34cm)

# Installation and Set Up

## Unpacking

Carefully unpack the Easteys Hot-Band L-Sealer and Heat Tunnel Combo unit from the shipping carton.

Remove the shipping bolts and straps that secure the L-Sealer and Heat Tunnel Combo unit to the shipping pallet. Remove the product tray and lift the L-Sealer and Heat Tunnel Combo unit off the pallet.

**Attention!** The Easteys L-Sealer and Tunnel Combo is a very heavy piece of equipment and will require a forklift or several people to move safely off the shipping pallet.

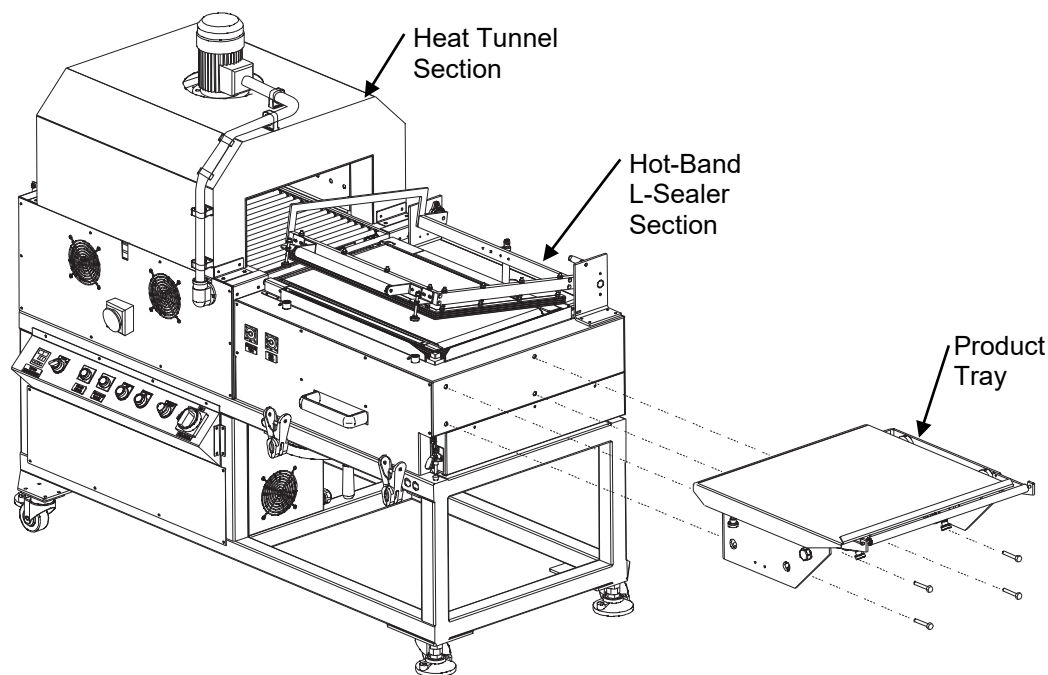
For shipping purposes, the product tray has been disassembled from the L-Sealer.

## Assembly

The Easteys VS1620 Hot-Band L-Sealer and Heat Tunnel unit has been assembled at the factory and requires very little assembly.

## Product Tray

The product tray contains both the film roller and the perforating pinwheel. The product tray has been disassembled from the sealer for shipping. There are four (4) bolts that are used to mount the product tray. Use the provided hardware to attach the product tray to the infeed end of the L-Bar sealer.



## Power Cord

The Eastey L-Sealer and Heat Tunnel Combo can be used in a variety of locations. To allow the option of hard wiring the power cord into an existing electrical panel the Eastey L-Bar Sealer is shipped without a three pronged plug attached to the power cord. If the L-Bar sealer is going to be used with a typical three pronged outlet attach a certified and approved three pronged plug to the power cord.

**Attention!** Ensure that any wiring complies with all electrical wiring codes and specifications that apply to the installation location.

## Location Requirements

There are four casters located on the bottom of the L-Bar Sealer to help in moving the machine. When the sealing machine is in the operating location adjust the four leveling pads for correct height.

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

1. The mounting surface is flat and level.
2. Alignment with any existing packaging lines or conveyors.

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.

When the Eastey L-Bar Sealer Tunnel Combo is positioned in the operating location you will need access to:

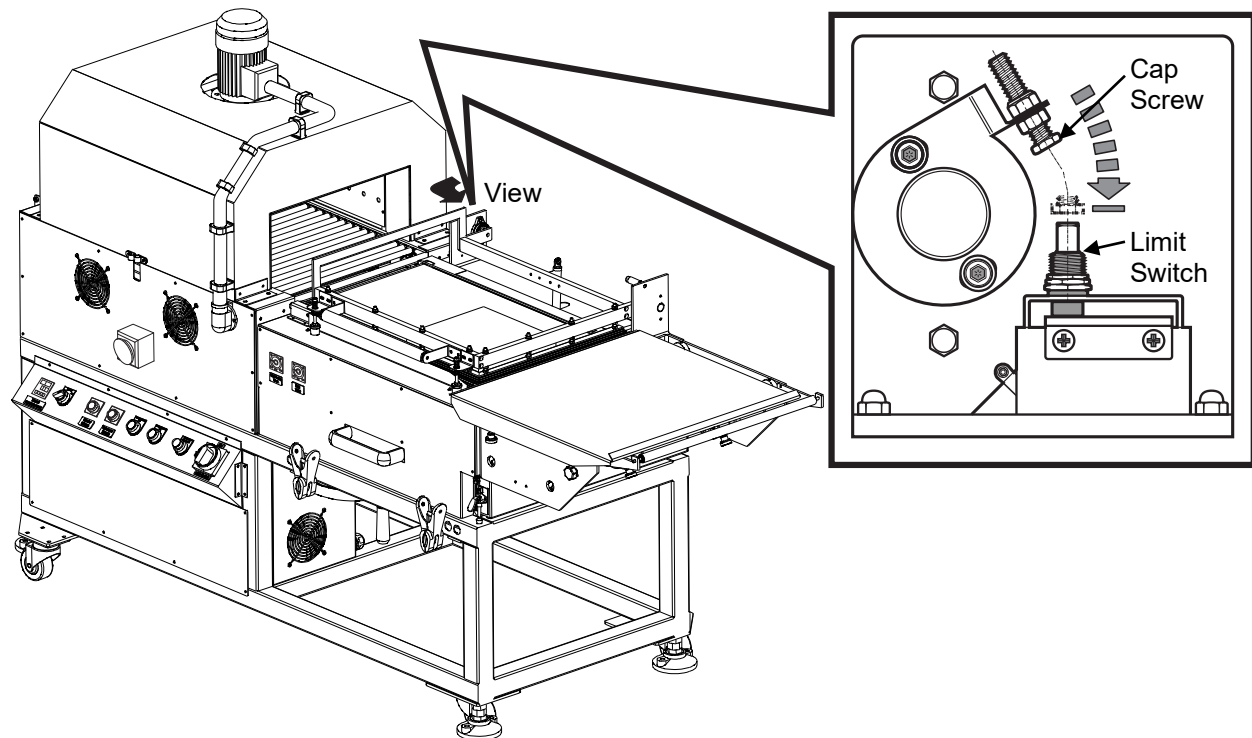
1. The control panel for the heat tunnel and the timers for the L-sealer.
2. Seal head handle.
3. Sealer table height adjustment wheel.
4. Sealer table horizontal red locking lever.
5. Shrink film roller.
6. Pin perforation wheels.

These locations are generally accessible from the operator side of the machine. The film and pinwheel rollers are located under the product tray.

## Aligning the Seal Head Limit Switch and Actuator

The seal head limit switch and limit switch actuator are located on the hinge upright angle closest to the heat tunnel.

**Attention!** Ensure the limit switch and cap screw that activates it are aligned and the cap screw adjusted so that the head will activate the limit switch when the front seal bar is approximately one-eighth to one-quarter inch from the lower seal band.

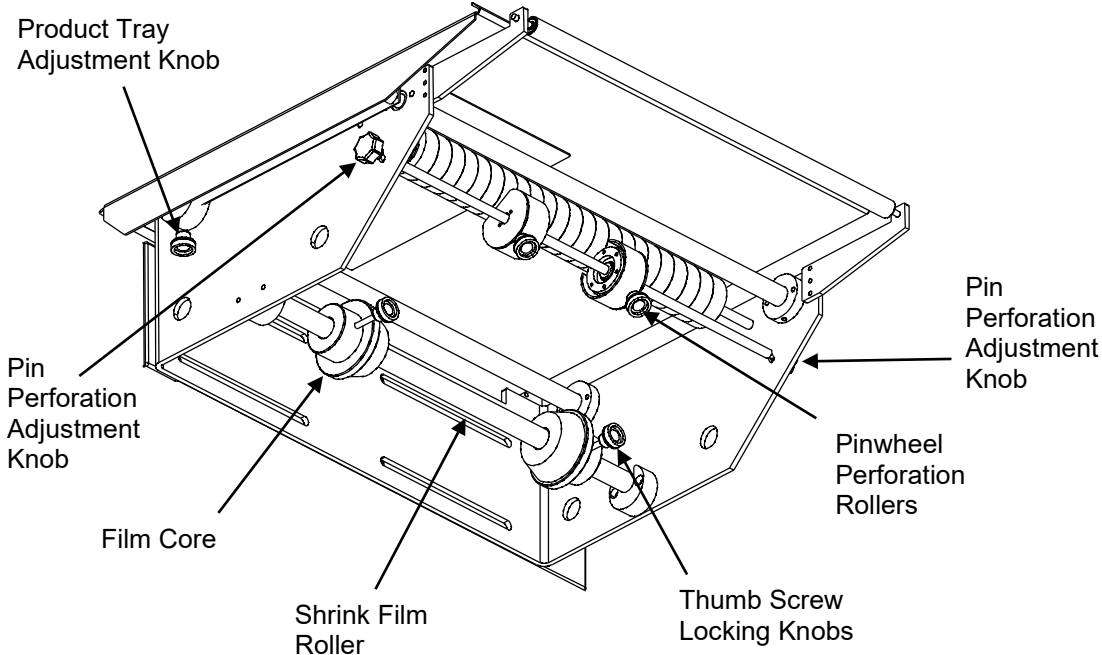


## Loading the Film

Load the new roll of polyolefin shrink film onto the film roller under the product tray. Install the film roll so the center fold is at the back of the machine (the operator side is considered the "Front" of the machine).

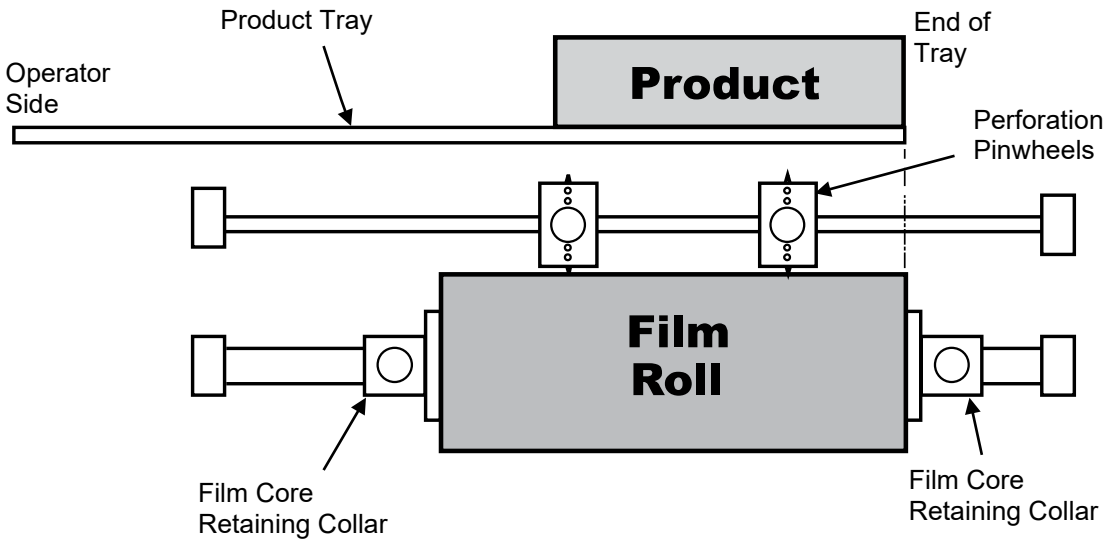
To load a roll of film:

- Lift the shrink film roller off the roller mounts located beneath the product tray.
- Loosen the locking knob on one of the film cores and slide it off the roller.
- Install the new roll of shrink film onto the film roller.
- Reinstall the film core.
- The film position is adjustable. Loosen the film core retaining collar lock knobs and position the shrink film roll according to the product size. Retighten the retaining collar locking knobs.



The pin perforation wheel punches small holes in the shrink wrap to allow air to evacuate while in the shrink tunnel. Loosen the pin perforation adjustment knobs at each end of the perforating wheel roller and move the perforation rollers away from the rubber roller. Position the pin perforation rollers according to the product size. After threading the film move the perforating wheels back to the operating position (against the rubber roller) and retighten the pin perforation adjustment knobs.

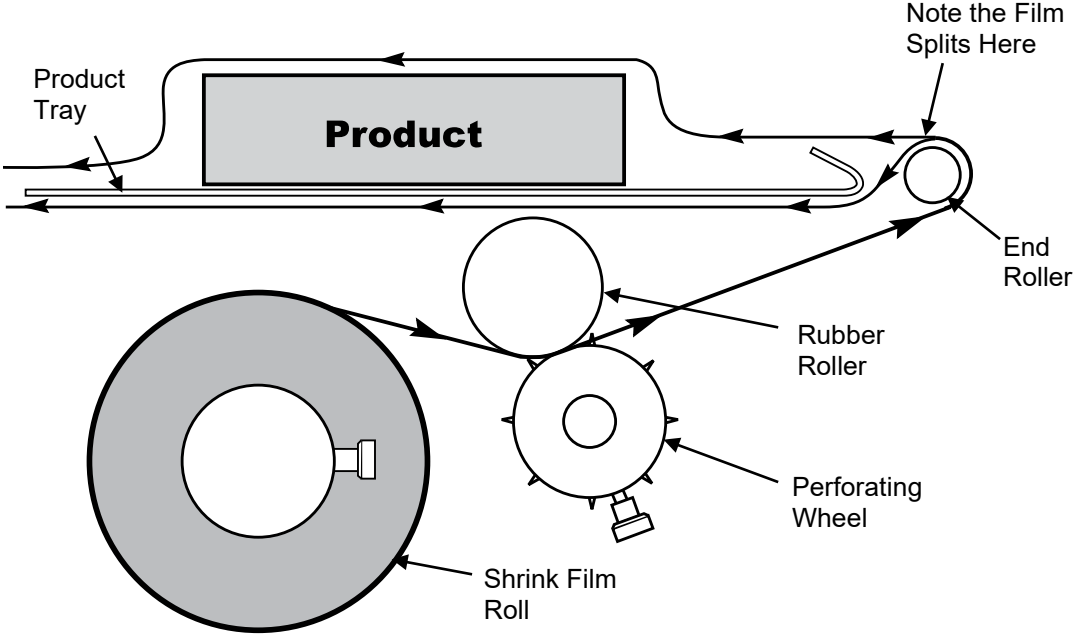
The product tray position is adjustable. Loosen the product tray adjustment knob and align the product tray with the center fold edge of the shrink film. Retighten the adjustment knob.



**Film and Product Alignment Diagram**

### Threading the Shrink Film

Thread the shrink film over the perforating wheel and around the end roller. Immediately after the end roller the shrink film will split, with the top of the film traveling over the product tray and the bottom traveling underneath the product tray.

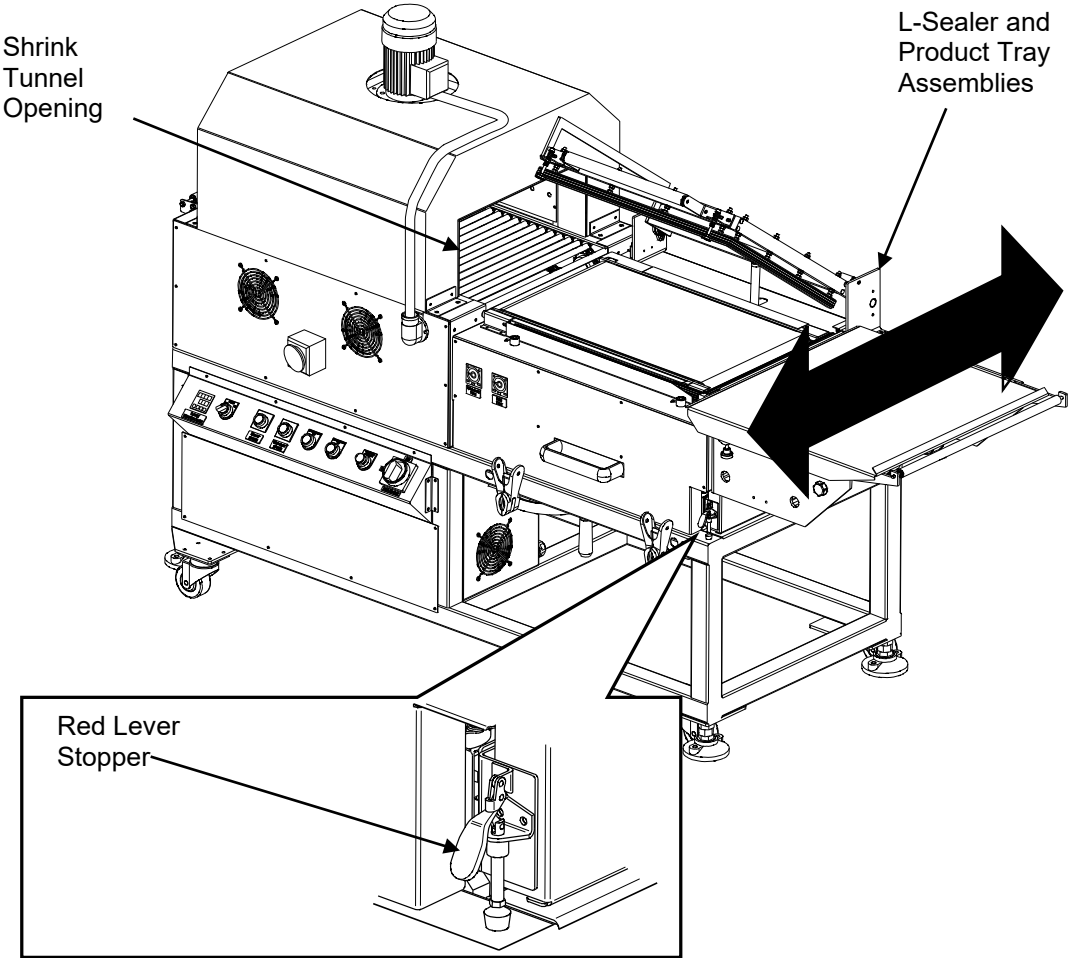


Film Threading Diagram



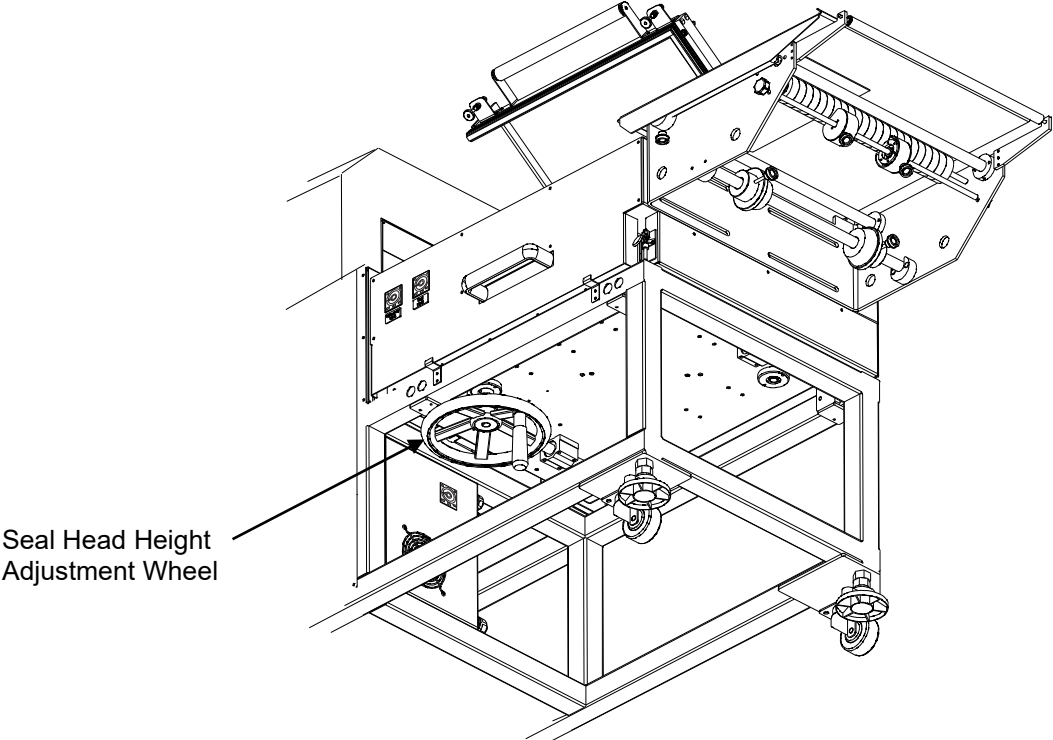
## Aligning the Shrink Tunnel

When the film, product tray and product are correctly aligned, release the red lever stopper and position the entire sealer and product tray assemblies in line with the shrink tunnel opening centering the product down the center of the tunnel. Reset the red lever stopper to lock the sealer assembly in position.



## Seal Head Height Adjustment

To adjust the vertical height of the sealing band, use the height adjustment wheel located under the sealing assembly. Turn the wheel to move the seal band position up or down.



Position the sealing band as near as possible to the center of the product to be sealed.

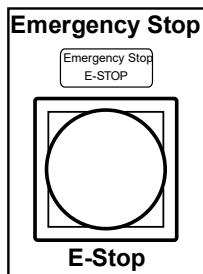
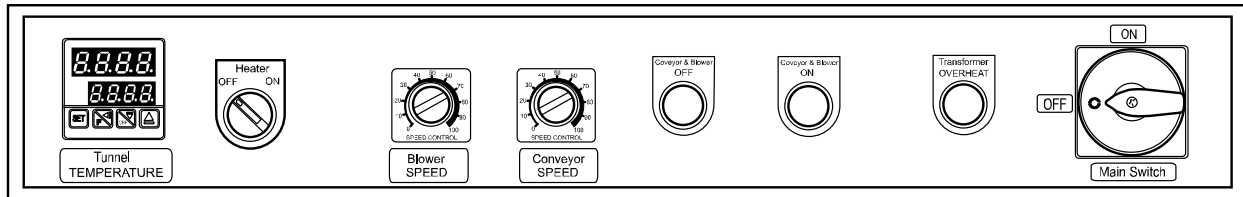


# Operation

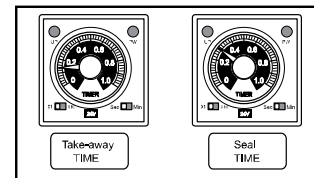
The Eastey VS1620T Hot-Band L-Sealer and Heat Tunnel Combo is very easy to operate. Become familiar with the control panel for the heat tunnel and timers for the L-sealer located on the operator side of the machine.

## Sealer and Tunnel Operation

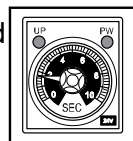
### Tunnel Controls



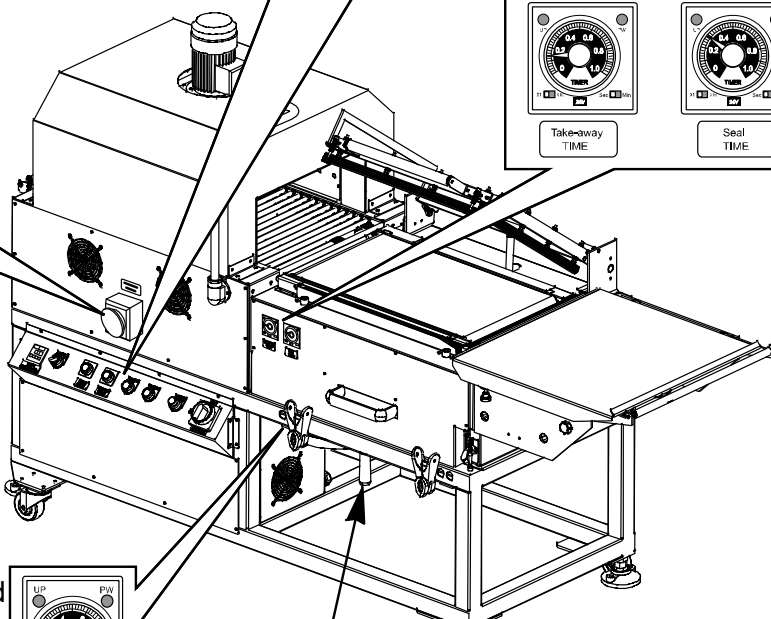
### L-Sealer Timers



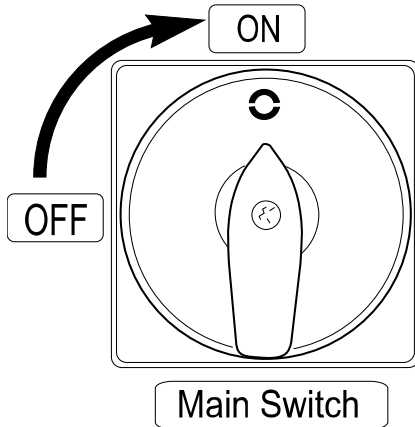
Energizing Seal Band  
Time Adjustment  
\*See Caution.



Handwheel for setting seal  
band height



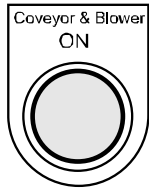
### Main Power



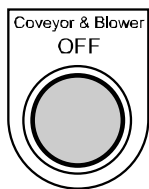
To begin operation turn, the Main Switch to the ON position.

The Main Switch controls power for both the tunnel and sealer.

### Conveyor and Blower



Press the Conveyor and Blower ON (green button) to start the conveyor and blower in the heat tunnel.



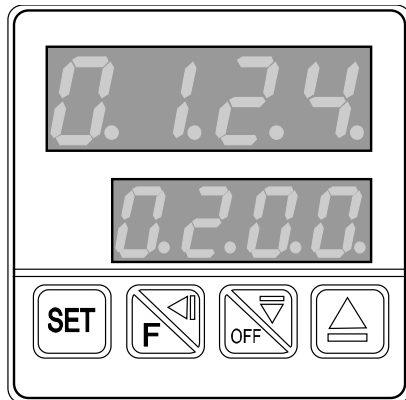
To turn the conveyor and blower off press the red Conveyor and Blower OFF button.

### Tunnel Heater



Turn the tunnel Heater Switch to the ON position.

## Setting the Tunnel Temperature



Use the programmable switch to set the temperature inside the shrink tunnel. The programmable switch will display the current temperature inside the heat tunnel (top) and the temperature setting.



Press the SET button to set the temperature.



Press this button to select the digit to change. The selected digit will begin to flash.



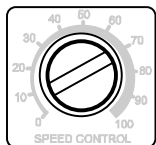
Press the Up or Down arrows to change the value of the selected digit.

Press the "SET" button to save the new values.

**Attention!** Do Not set the temperature higher than 350°. Setting the temperature higher than 350° will damage the machine and the product.

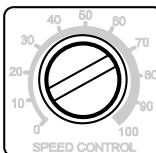
The output light will turn on while the tunnel is heating up.

## Blower Speed



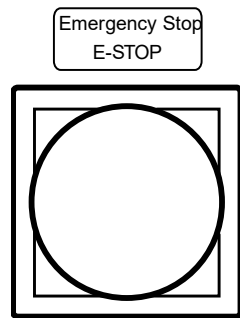
Use the Blower SPEED dial to set the air flow inside the shrink tunnel. The blower speed will vary according to the product dimensions and film properties.

## Conveyor Speed



Use the Conveyor SPEED dial to set the conveyor speed through the shrink tunnel. The conveyor speed will vary according to the product dimensions and film properties.

## E-Stop or Emergency Stop



A red E-Stop button is placed centrally above the heat tunnel control panel. In the event of an emergency, press the E-Stop button in. This brings the heat tunnel to a halt in a way to avoid damage or excessive film waste.

**CAUTION!** When the Heat Tunnel unit is stopped or turned off it will require some time to cool to ambient room temperature. Be aware of heat inside of the tunnel and hot surfaces, belts, or rollers.

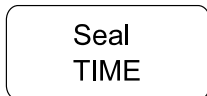
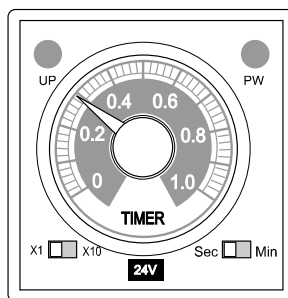
When the E-Stop is pressed, the heat tunnel conveyor motor and heaters are turned off, but blower motors are allowed to continue to blow to allow the tunnel to cool down in a way to prevent damaging heat concentrations. Depending on heat settings, the time required for the system to cool down completely may vary.

To return the machine back to normal operation once the E-Stop has been pressed, verify the emergency condition has been cleared, then press and turn the E-Stop button a quarter-turn so it pops out to normal operating position.

## Sealer Operation

### Seal Time

Use the “Seal TIME” timer to set the seal time. The seal time is the amount of time that the magnets will hold the seal head down on the film. The seal time may vary according to the type of film in use.



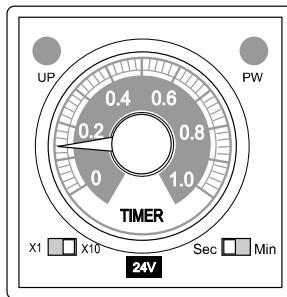
When the seal bar frame is pressed down onto the film, it will remain in position for the set time then automatically release. Do not hold the seal bar down onto the film.

Ensure that the timer sliding switches are in the times one (X1) and the second (Sec) positions. If the timing switches are in the X10 and or the minute positions it will result in a ridiculous value that is way out of operating range.

**Attention!** Move the “Seal TIME” switch in very small increments.

## Take Away Time

Use the “Take-away TIME” to set the amount of time the conveyor will run.



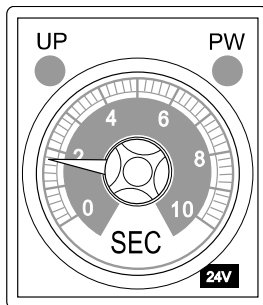
Take-away  
TIME

When the seal bar is released the conveyor will automatically move the product into the shrink tunnel according to the set time. The takeaway time will vary according to the product being sealed and the operator’s ability.

Ensure that the timer sliding switches are in the times ten (X10) and the second (Sec) positions. If the timing switches are in the X1 and or the minute positions it will result in a value that is far outside of operating range.

## Energizing Seal Band Time Adjustment

**Note:** The Energizing Seal Band Time Adjustment has been set at the Eastey facility and should not have to be changed. See the information below for adjustment if needed.



The Energizing Seal Band Time is the amount of time that the seal band will be energized when in the cutting position. The energizing time is set by a small timer located on the surface of the shrink tunnel base under the sealer above the lower fan grille. The “Energizing Time” timer should be set to a value less than the seal time. Depending on film properties, such as material, thickness, and run rate, the energizing timer may need to be adjusted in small increments to attain optimal seal.

**Caution!** Make very small changes to the energizing time value. High energizing times may overstress and burn out the seal band.

## Sealing the Product

Advance the film across the product tray. Remember the film is split with the bottom half going beneath the product tray and to top going over the product tray.

**Note:** For best results, the seal head should be cycled three to four times initially before sealing to warm up the upper seal head.

Pull a short length of film into the seal area and pull the seal bar down to create a leading seal.

Lift the top film and place the product to be sealed on the product table under the top layer of film.

Advance the product and film to the seal area on the takeaway conveyor.

Close the sealing bar using slight pressure and let go. The sealing bar will seal the product and release automatically according to the sealing time setting.

After the seal head has been released the takeaway conveyor will move the product into the heat shrink tunnel.

Repeat this process for the next package to be sealed.

As products are moved through the L-sealer a long tail of scrap will accumulate on the operator side of the machine. Wind the scrap material around the two fixed holders.

**Note:** During the normal course of operation of the sealer, the seal heads will require cleaning from time to time. For best results, form a ball of accumulated scrap sealing film and keep this handy to use to wipe the sealer when needed.

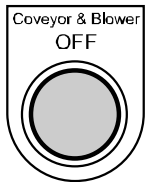
## Shutting Down

When shutting down it is important to let the temperature inside the shrink tunnel cool down before turning off the main power. See the special notes about the tunnel shutdown sequence at the end of this section.



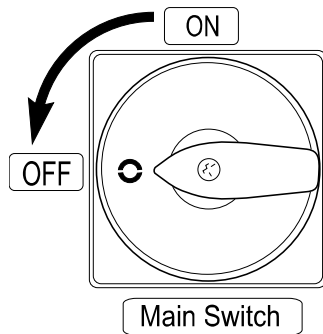
Turn the Heater switch to the OFF position.

**Attention!** Do not turn the conveyor and blower off until the shrink tunnel has cooled down considerably.



After the temperature in the tunnel has cooled (this will be a considerable amount of time) turn the Conveyor and Blower off.





Turn Main Power switch to the OFF position.

### Special Notes About the Tunnel Shutdown Sequence

- ▶ The sealer may be shut down at any time by switching the sealer power switch to the Off position and allow to cool to ambient room temperature. Shutting down the heat tunnel requires the following.
- ▶ When shutting down the tunnel, be sure to first turn the heater switch to Off.
- ▶ Once the heater switch is switched off, it will take some time (this will vary depending on heat settings) for the tunnel to cool down completely.
- ▶ When the tunnel cools down to approximately 150°F or 66°C or cooler, shut off the tunnel conveyor and blowers.
- ▶ Bringing the tunnel down this way helps prevent damage to the conveyor and internal components from excess prolonged exposure to heat inside the tunnel. Allow the tunnel to cool down completely to ambient room temperature before performing any servicing to avoid burn hazards.

# Maintenance

The Eastey Hot-Band L-Sealer Heat Tunnel Combo will provide many hours of maintenance-free operation and requires very little maintenance for normal operation. There are a few items that may require attention from time to time.

**Attention!** Any maintenance beyond normal cleaning and lubrication should only be performed by trained and qualified personnel.

## Sealer

### Daily

- Clean the seal band. Check the upper and lower seal areas for melted or scrap film or dirt and clean as required.
- Ensure the PTFE tape is not torn or missing on upper and lower seal areas. Replace as needed.
- Check conveyor belts for wear or damage. Check the takeaway conveyor for torn belt or excessive wear; check the tunnel conveyor for worn or broken parts. Repair or replace as needed.
- Check the conveyor height adjustment wheel. Lubricate chain and screws as needed.
- Check power cord and wiring for wear and loose connections.
- Check for loose fasteners.

## Shrink Tunnel

### Daily

- Inspect the silicone rollers. Repair or replace as needed.
- Check mesh belt for material stuck on or in belt. Clean if necessary.

### Monthly

- Check and clean the air intake screens.
- Check the airflow holes inside the tunnel for debris and clean if necessary.
- Check and adjust the conveyor tension.
- Lubricate the drive chains.

## Cleaning

The machine will require occasional cleaning.

1. After daily operation, carefully wipe the sealing cutter clean with a ball of accumulated scrap sealing film.
2. The machine is not designed or built for waterproof function. When cleaning the machine, use only a clean cloth, lightly dampened if necessary, to clean exterior surfaces. Use a ball of accumulated scrap sealing film to clean the seal heads occasionally as required. DO NOT splash water or other fluids on or into the machine.
3. Avoid contact with liquid acid or gas, or other corrosives.

## Rollers

Make sure the 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. DO NOT splash water or other liquids into the machine. **Never use harsh or abrasive cleaners or chemical agents when cleaning this machine.**

## Replacing the Seal Band, PTFE Tape, or Seal Pads

The seal band, PTFE tape, silicone pads, and ceramic beads wear through normal use, and occasionally it will be necessary to replace them.

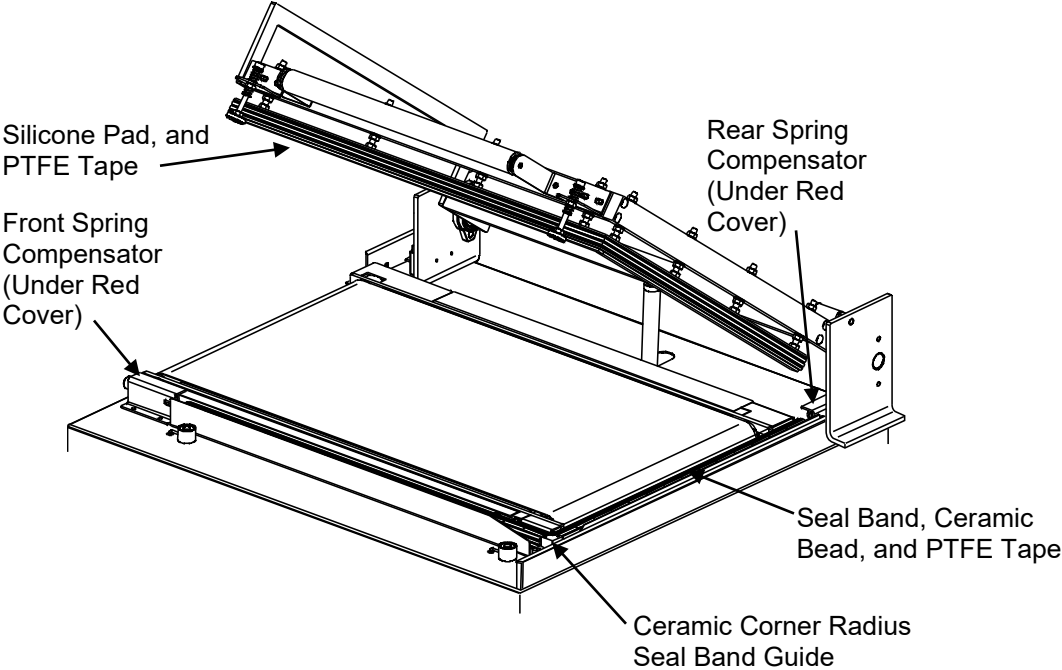
Making a good seal depends on three factors:

1. Heat: the temperature of the seal band when energized.
2. Time: how long the seal band is energized.
3. Pressure: how much pressure is applied between the upper and lower seal pad.

If after verifying the factors that affect heat and cycle timing (**Aligning the Seal Head Limit Switch and Actuator** and Seal Time, Take Away Time, and Energizing Seal Band Time settings), and the following symptoms are observed:

- Gaps in the seal
- Weak Seals
- Improper film cutoff
- Excessive sealing pressure required to make the seal

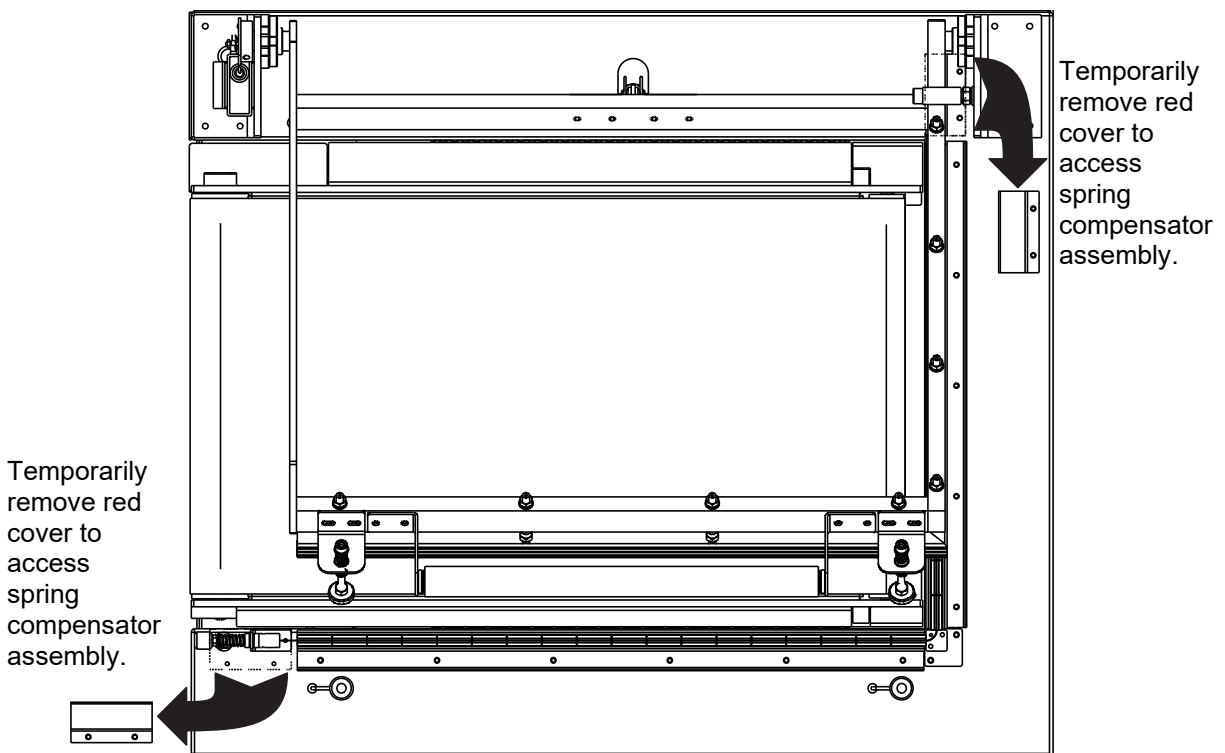
The seal band, PTFE tape, and silicone pad or ceramic bead should be inspected and replaced as necessary.



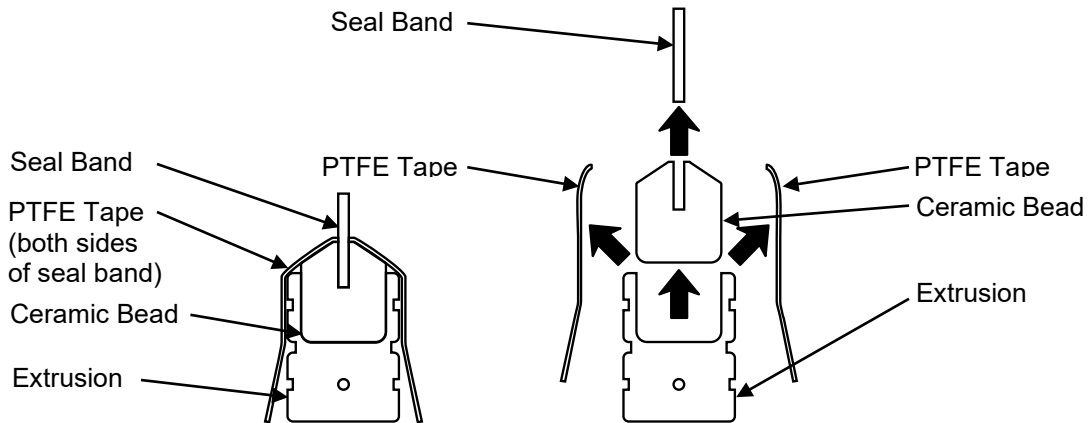
## Lower Seal Band and Bead Disassembly

To remove and replace the lower seal band, PTFE tape, and bead, do the following.

1. Disconnect the VS1620 L-Bar Sealer Tunnel Combo Unit power plug from the electrical power source.
2. Examine the L-seal area for dirt and debris and for worn parts or torn tape.
3. Temporarily remove the red covers to access the spring compensator assembly at each end of the seal band.



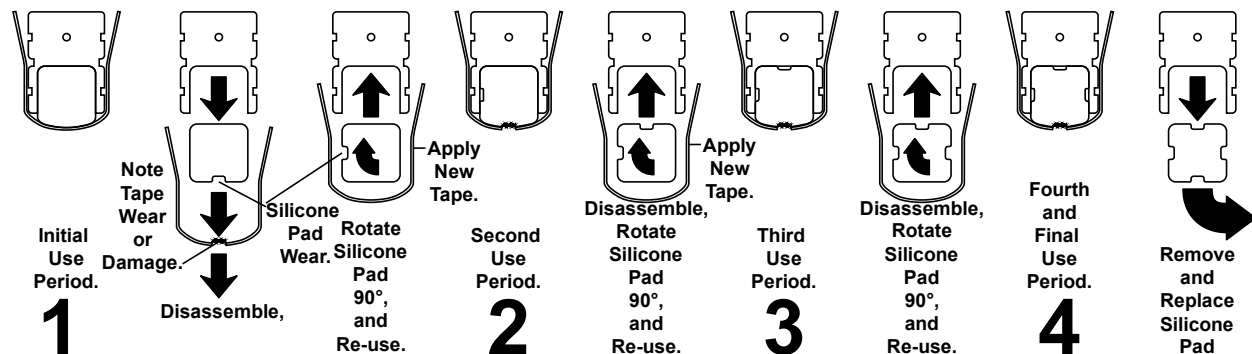
4. Loosen the spring compensator set screws to unclamp the seal band and free it at each end.
5. Remove the PTFE tape from the ceramic bead on each side of the seal band. Discard the PTFE tape, as it cannot be re-used. Place the seal band aside and pull the ceramic bead out of the channel extrusion. In cross-section, the arrangement of the seal band, PTFE tape, ceramic bead, and extrusion look similar to the following illustration and can be disassembled as shown at right.



6. With the parts disassembled, clean the parts as required or determine which parts need to be replaced.

## Upper Seal Bar Pad

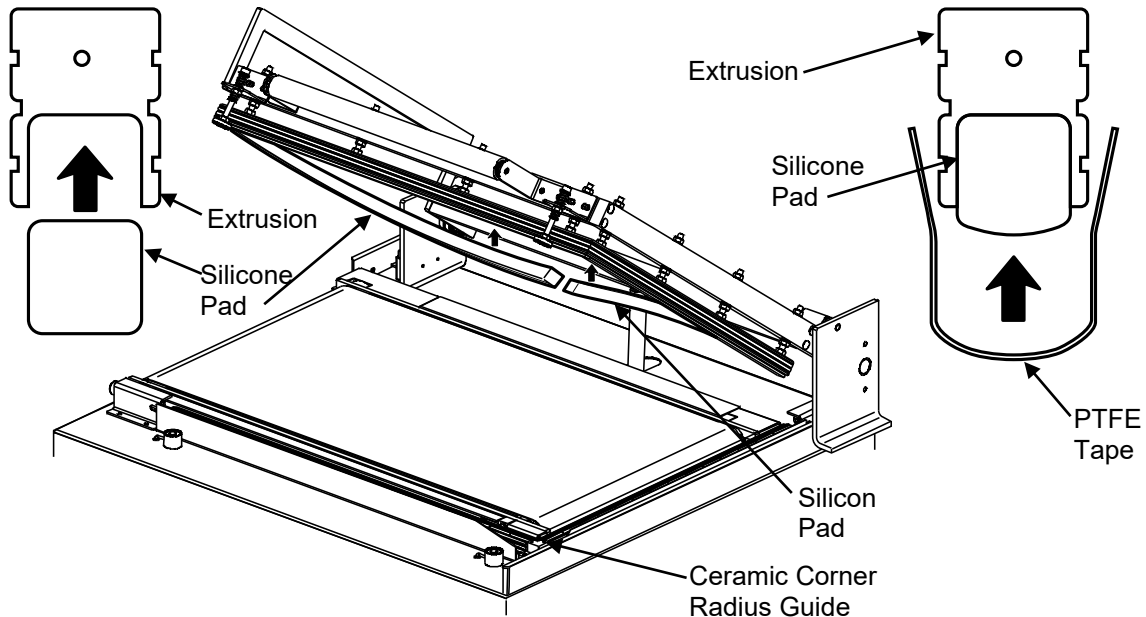
Seal pads are designed to be easy to install and replace. They are square and inserted into the channel extrusion so that if one side is worn, the pad can be repositioned rotated to use a new side. This way it can be re-used until all sides have been used.



## Upper Seal Bar Pad Re-assembly

Reassemble the seal pads, tape, and bands in reverse order of disassembly.

1. Carefully press the silicone pads into the sealer channels. The silicone pads should be the same length as the channel extrusions into which they are applied and should meet up with the ceramic corner radius seal band guide.



2. Apply PTFE tape close up to the seal band over the silicone pads for the entire length and apply the tape around the outside of the channel flanges to cover the seal pad completely.

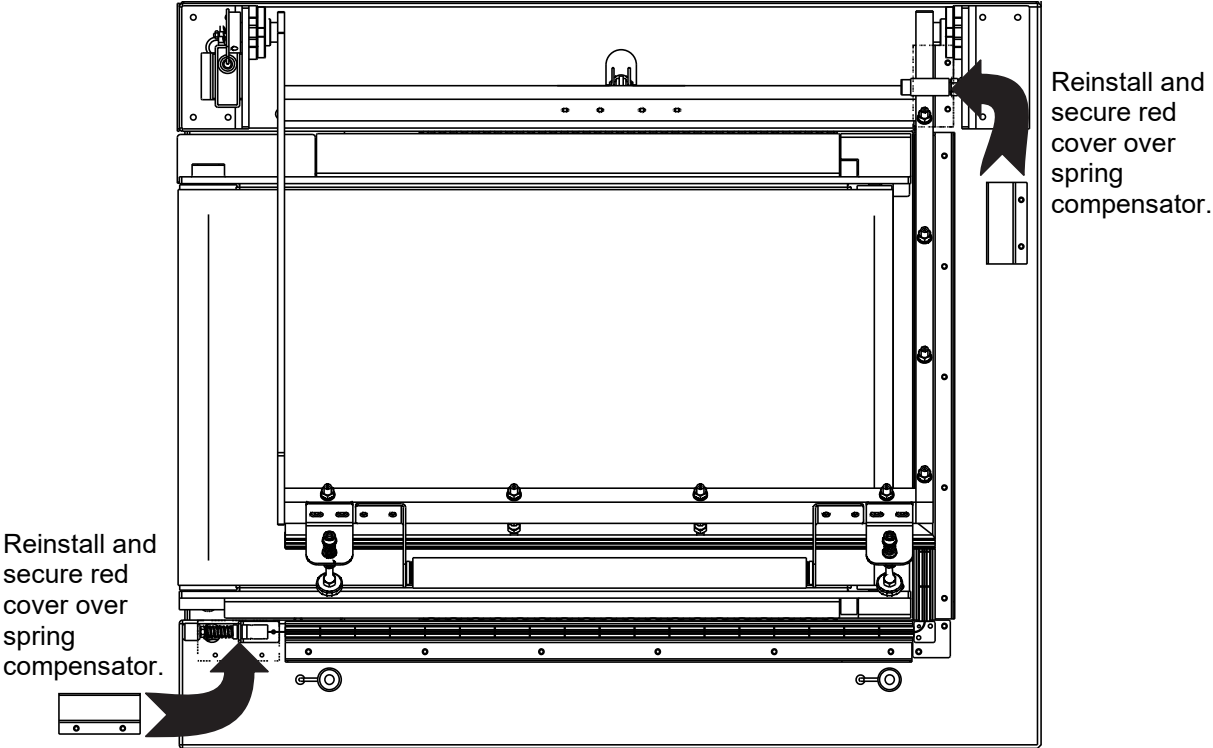
## Lower Seal Bar Assembly

1. Route the seal band centered along the top of the silicone pads and through the groove in the ceramic corner radius guide. Insert each end of the seal band into each of the spring collets. Keep the band and compensators straight and level and make sure the band and compensators move freely.

**Important:** The seal band must be straight and level and must be able to move freely with minimal friction between the spring compensators and ceramic corner radius with no sticking or binding at any point along the band.

The spring compensators secure each end of the seal band and maintain uniform tension as the seal band heats up and expands or cools down and retracts. If the seal band is not allowed to expand smoothly and uniformly, it can develop hot spots. Care must be taken when replacing parts to avoid premature wear leading to failure, such as, cuts or tears in the PTFE tape, excessive pad wear, and hot spots in the blade that can lead to premature blade failure.

2. When the seal band is working satisfactorily, reinstall the red compensator cover over each of the spring compensators, re-using the original hardware.





# Troubleshooting

Problem	Possible Cause	Solution
<p>Control power lamp does not light.</p> <p>No fuse breaker tripped.</p>	<ul style="list-style-type: none"> <li>• Power not connected.</li> <li>• Fuse burned out.</li> <li>• Defective switch.</li> <li>• Disconnected wire.</li> <li>• Poor connection.</li> <li>• Electrical leakage.</li> </ul>	<ul style="list-style-type: none"> <li>• Connect power; switch on.</li> <li>• Replace fuse.</li> <li>• Replace switch.</li> <li>• Check wire connections.</li> <li>• Check heating wire.</li> <li>• Check all wiring sections.</li> </ul>
<p>Conveyor belt can be pushed by hand.</p> <p>Belt cannot be pushed by hand.</p> <p>Failure under Normal Status.</p>	<ul style="list-style-type: none"> <li>• Belt tension too loose.</li> <li>• Belt tension too tight.</li> <li>• Defective motor gear head.</li> <li>• Driving chain tension too tight.</li> <li>• Disconnected wire.</li> <li>• Defective motor.</li> <li>• Defective contact plug.</li> <li>• Defective relay unit.</li> <li>• Defective limit switch.</li> </ul>	<ul style="list-style-type: none"> <li>• Adjust belt tension screw.</li> <li>• Adjust belt tension screw.</li> <li>• Replace part.</li> <li>• Adjust driving chain.</li> <li>• Replace part.</li> </ul>
<p>Material outfeed roller failure.</p> <p>Material moves</p>	<ul style="list-style-type: none"> <li>• Disconnected wire.</li> <li>• Defective drive motor.</li> <li>• Defective relay unit.</li> <li>• Defective brake box.</li> <li>• Wrong material setting position.</li> </ul>	<ul style="list-style-type: none"> <li>• Replace part.</li> <li>• Replace part.</li> <li>• Adjust material setting position.</li> </ul>
<p>Zig-zag line.</p>	<ul style="list-style-type: none"> <li>• Unbalanced material tension lever.</li> <li>• Wrong tension roller position.</li> <li>• Wrong triangle unfold angle.</li> </ul>	<ul style="list-style-type: none"> <li>• Adjust item as required.</li> </ul>
<p>Material does not move.</p>	<ul style="list-style-type: none"> <li>• Film perforator does not allow film to roll out.</li> </ul>	<ul style="list-style-type: none"> <li>• Adjust spring.</li> </ul>

Problem	Possible Cause	Solution
Material does not move.	<ul style="list-style-type: none"> <li>• Wrong RPM of material mounting roller.</li> <li>• Chain tension clamping is set too tight.</li> <li>• Chain tension clamping is set too loose.</li> </ul>	<ul style="list-style-type: none"> <li>• Adjust to correct RPM.</li> <li>• Adjust chain clamping to correct tension.</li> <li>• Adjust chain clamping to correct tension</li> </ul>
Sealing arm fails to move.	<ul style="list-style-type: none"> <li>• Disconnected wire.</li> <li>• Defective relay unit.</li> </ul>	<ul style="list-style-type: none"> <li>• Replace part.</li> <li>• Replace part.</li> </ul>
Sealing arm rises too abruptly.	<ul style="list-style-type: none"> <li>• Sealing time is set too short.</li> </ul>	<ul style="list-style-type: none"> <li>• Adjust time of limit switch in safety device to lengthen sealing time.</li> </ul>
Sealing arm lowers too abruptly	<ul style="list-style-type: none"> <li>• Electronic sensors not aligned horizontally or vertically, or dirty.</li> </ul>	<ul style="list-style-type: none"> <li>• Check alignment and adjust and clean as necessary.</li> </ul>
Sealing heating temperature does not rise.	<ul style="list-style-type: none"> <li>• Fuse burned out.</li> <li>• Disconnected heating wire.</li> <li>• Defective relay unit power of single phase.</li> </ul>	<ul style="list-style-type: none"> <li>• Replace part as required.</li> </ul>
Unable to adjust temperature.	<ul style="list-style-type: none"> <li>• Defective temperature regulator.</li> <li>• Defective temperature sensor.</li> </ul>	<ul style="list-style-type: none"> <li>• Replace defective part as required.</li> </ul>
Safety device failure.	<ul style="list-style-type: none"> <li>• Disconnected wire.</li> <li>• Defective limit switch.</li> <li>• Defective relay unit.</li> <li>• Insufficient air pressure.</li> </ul>	<ul style="list-style-type: none"> <li>• Reconnect or replace wire.</li> <li>• Adjust or replace limit switch.</li> <li>• Replace part as required.</li> <li>• Check air pressure. Air pressure must meet specifications.</li> </ul>
Sealer not forming an adequate seal.	<ul style="list-style-type: none"> <li>• Sealing cutter defective.</li> <li>• Heating temperature too low.</li> <li>• Sealing time too short or air pressure too weak.</li> <li>• Sealing cutter heat is insufficient.</li> </ul>	<ul style="list-style-type: none"> <li>• Replace with new cutter.</li> <li>• Adjust to correct heating temperature.</li> <li>• Check and correct as required.</li> <li>• Replace sealing cutter.</li> </ul>

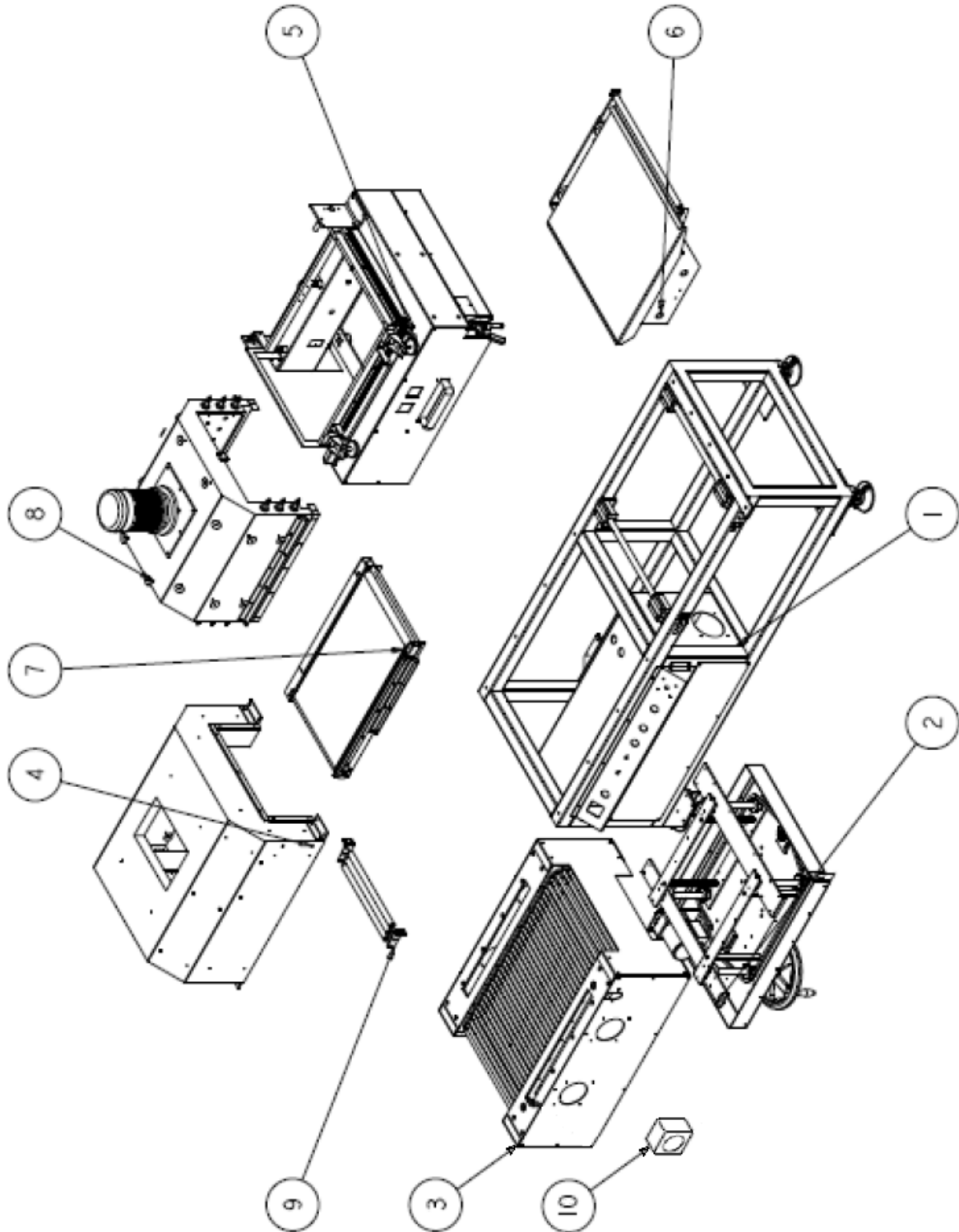
# Parts List

## VS1620T Spare Parts List

PART NO.	DESCRIPTION	REFERENCE	Q'TY
VSSA0001	HOT BAND HEATER STRIP	SEAL BAND	1
VSSA0002	SILICONE RUBBER UPPER SEAL PAD	5FB0110X10X0980	3 ft.
EAST0200	2 INCH 3 MIL PTFE TAPE, 36 YARDS	PTFE TAPE 2" X 36 YDS 3MIL	1
VSSA0009	SPRING COMPRESSION COMPENSATOR	5EH1410X7.8X32X12N	2
VSSA0012	MACH-COMPENSATOR BUSHING	LTM504(ENG)EM04	2
VSSA0013	RED COMPENSATOR COVER	VSSA0013L OR VSSA0013R	2
VSSA0015	COMPENSATOR ROD	LTM504(ENG)EM04	1
VSSA0016	COMPENSATOR SHAFT COLLAR	LTM504(ENG)EM05	1
VSSA0027	CERAMIC BEAD-VS1620		32
VSSA0032	CORNER BEAD, VS1620		1
VSCP0010	FUSE TIME DELAY CC 600V 12 AMP	Fuse 1	2
VSCP0011	FUSE TIME DELAY CC 600V 10 AMP	Fuse 2	2
VSCP0012	FUSE TIME DELAY CC 600V 4 AMP	Fuse 4	2
VSCP0013	FUSE TIME DELAY CC 600V 2 AMP	Fuse 3	2

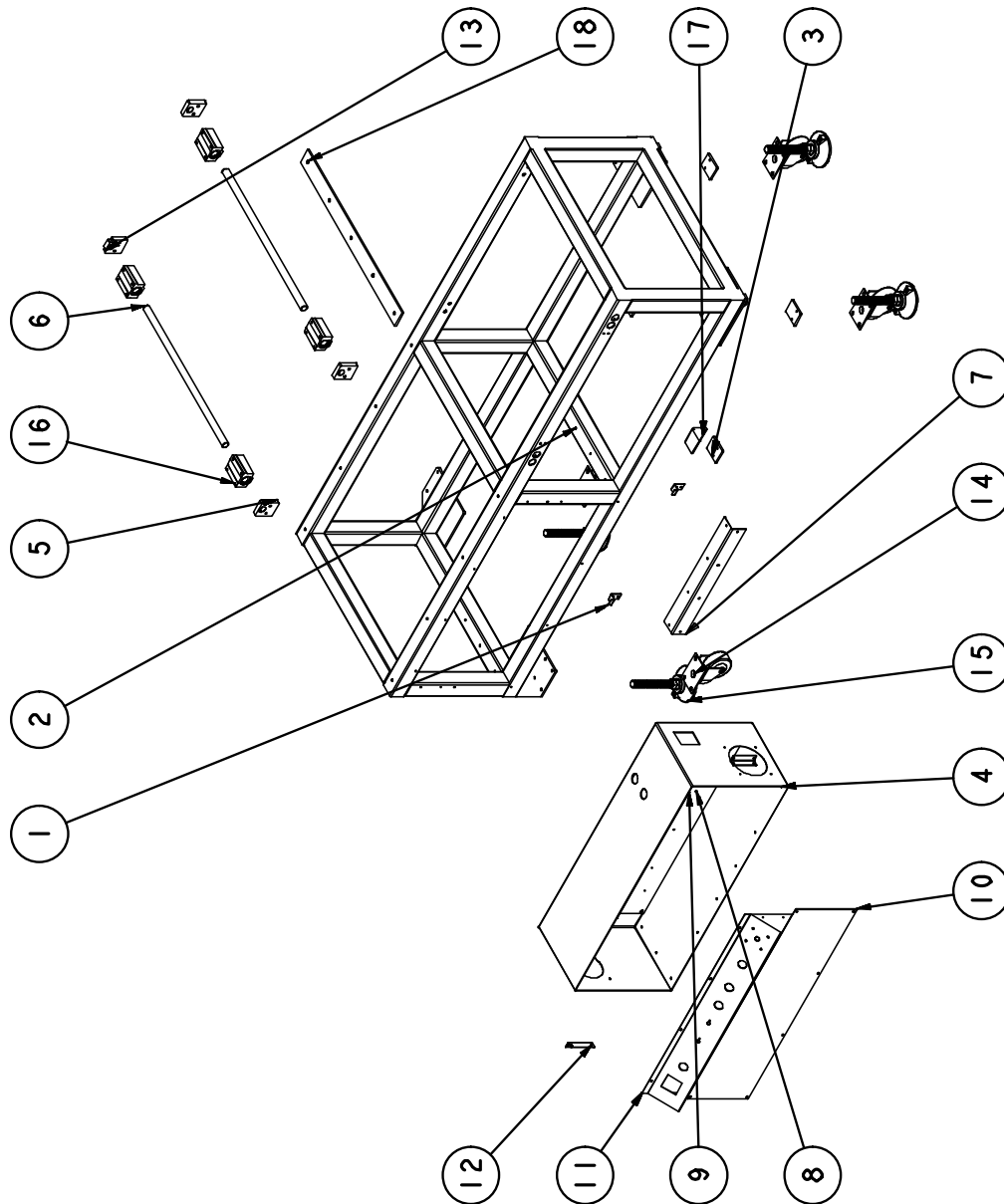
## VS1620T L-Sealer Tunnel Combo Unit

Main Assembly – VS1620-TLR Live Roller or (VS-1620-LR)  
VS1620-TMB Mesh Belt or (VS-1620-MB)



ITEM	ASSEMBLY	DESCRIPTION	REFERENCE	PAGE
1	VSCP0019	BASE FRAME WITH MAIN CONTROL PANEL	VS1620AA	38
2	VSSA0258	INFEED HEIGHT ADJUSTMENT SYSTEM	VS1620AB	40
3(a)	VSTA0065LR	HEAT TUNNEL SUPPORT WITH LIVE ROLLER CONVEYOR	VS1620DA	42
3(b)	VSTA0065MB	HEAT TUNNEL SUPPORT WITH WIRE MESH BELT CONVEYOR	VS1620DA-1	44
4	VSTA0066	HEAT TUNNEL HOOD ASSEMBLY	VS1620DC	46
5	VSTA0259	L-SEALER AND FRAME FOR HOT BAND VS1620	VS1620E	48
6	VSSA0260	PRODUCT TRAY WITH FILM HOLDER AND PERFORATOR	VS1620G	49
7	VSSA0261	L-SEALER TAKEAWAY CONVEYOR	LTS504(ENG)P-B	51
8	VSTA0067	TUNNEL HEATING ASSEMBLY	LTS504(ENG)P-DB	55
9	VSSA0262	EXIT ROLLER ASSEMBLY	VS1620DB	57
10	VSAK0002	SWITCH PUSH BUTTON E-STOP	FCH-HY57B-02-1-3	—

## Base Frame with Main Control Panel – VSCP0019 (VS1620AA)

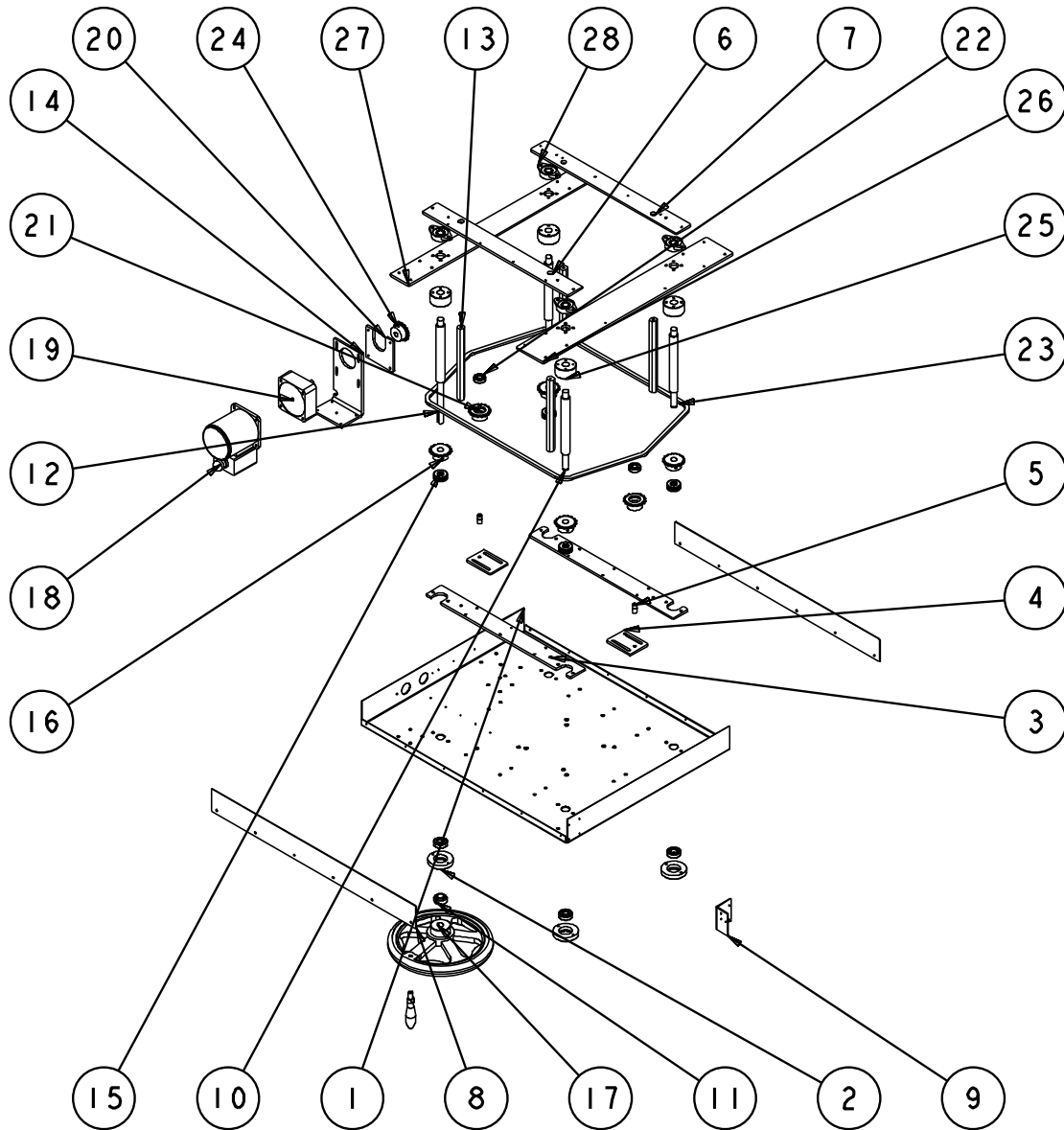


ITEM	PART NO.	DESCRIPTION	RERERENCE	Q'TY
1	VSCP0020	L BRACKET	LTM504(ENG)-AP11	2
2	VSCP0021	BASE FRAME WELDMENT	LTS504(ENG)X2-AP08	1
3	VSCP0022	RECTANGLE BRACKETS	VS1620-AP02	4
4	VSCP0023	ELECTRICAL BOX SWITCHBOARD	VS1620-HP01	1
5	VSCP0024	GUIDE ROD FIXED SEAT	LTS504(ENG)P-AM01	3
6	VSCP0025	GUIDE ROD	LTS504(ENG)P-AM02	2
7	VSCP0026	ELECTRICAL BOX ANGLE BRACKET	LTS504(ENG)X2-HP07	1
8	VSCP0027	ELECTRICAL BOX SIDE COVER	LTS504(ENG)P-HP05	1

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ITEM	PART NO.	DESCRIPTION	RERERENCE	Q'TY
9	VSCP0028	CONTROL PANEL HOUSING TOP COVER	LTS504(ENG)P-HP06	1
10	VSCP0029	CONTROL PANEL HOUSING FRONT PLATE	VS1620-HP02	1
11	VSCP0030	CONNECTION BOARD	VS1620-HP03	1
12	VSCP0031	ELECTRICAL BOX CORNER BRACKET	VS1620-HP04	2
13	VSCP0032	GUIDE ROD FIXED SHELF	LTS504(ENG)P-AM09	1
14	VSCP0033	WHEEL CASTER	5BD01075X25	4
15	VSCP0034	ADJUSTABLE FOOT	5BD31M20X180	4
16	VSCP0035	LINEAR BEARING	5BE06SC20UU	4
17	VSCP0036	FRAME ANGLE BRACKET	VS1620-OP03	1
18	VSCP0037	PAD	VS1620-EM10	1

### Takeaway Height Adjustment Mechanism – VSSA0258 (VS1620AB)

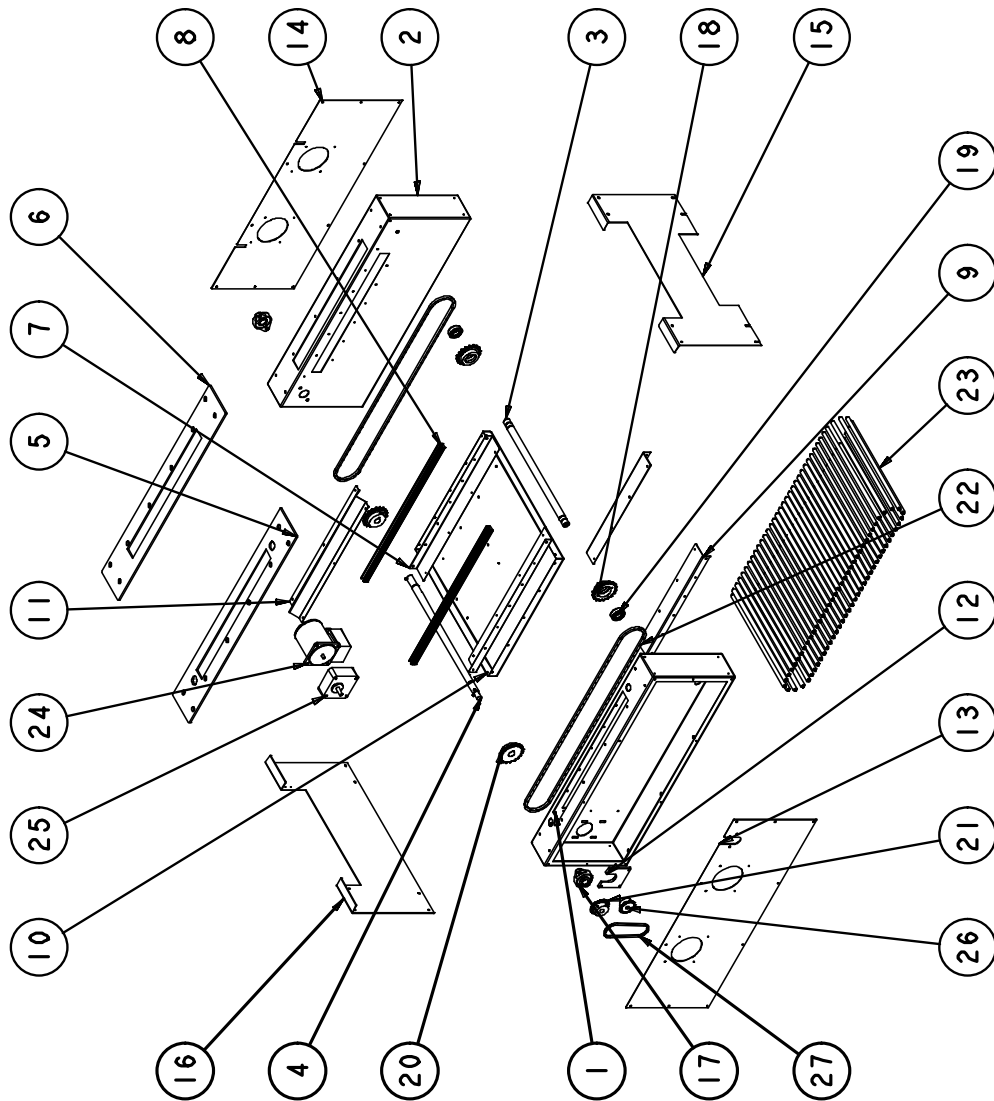


ITEM	PART NO.	DESCRIPTION	RERERENCE	Q'TY
1	VSSA0178	LIFTING BASE	VS1620-AP03	1
2	VSSA0179	SCREW SEAT	LTS504(ENG)P-AM03	4
3	VSSA0180	SUPPORT PLATE	LTS504(ENG)P-AP07	2
4	VSSA0181	CHAIN ADJUSTMENT PLATE	LTS504(ENG)P-AP06	2
5	VSSA0182	THRUST BEARING	LTS504(ENG)P-AM04	2
6	VSSA0183	SUPPORT PLATE	LTS504(ENG)P-AP08	1
7	VSSA0184	CHAIN ADJUSTMENT PLATE	LTS504(ENG)P-AP09	1
8	VSSA0185	LIFTING BASE COVER	VS1620-AP04	2



ITEM	PART NO.	DESCRIPTION	RERERENCE	Q'TY
9	VSSA0186	CLAMP FIXED SEAT	VS1620-AP05	1
10	VSSA0187	DRIVEN LIFTING SCREW	LTS504(ENG)P-AM05	3
11	VSSA0188	SCREW FIXED RING	LTS504(ENG)P-AM07	1
12	VSSA0189	LIFTING SCREW	LTS504(ENG)P-AM06	1
13	VSSA0190	FIXED ROD	LTS504(ENG)P-AM08	4
14	VSSA0191	MOTOR SEAT	LTS504(ENG)P	1
15	VSSA0192	THRUST BEARING	5BE0151202	4
16	VSSA0193	SPROCKET	5BF01LTS504PAC01	4
17	VSSA0194	ROTATING HANDWHEEL	5BC01KRN250X1+FR90	1
18	VSSA0195	INDUCTION MOTOR	5CH0151K40GNCT	1
19	VSSA0196	GEAR BOX	5CH615GN18K	1
20	VSSA0197	MOTOR ADJUSTMENT PLATE	LTS504(ENG)P-BP12	1
21	VSSA0198	IDLER	5B01LTS504PACO2	2
22	VSSA0199	BEARING	5BE016001ZZ	6
23	VSSA0200	ROLLER CHAIN	5BA0113X180	1
24	VSSA0201	SPROCKET	5BF011B3X15T12M64	1
25	VSSA0202	SCREW SEAT	LTS504(ENG)P-EM01	4
26	VSSA0203	UPPER LIFTING BOARD 2	LTS504(ENG)P-EP18	1
27	VSSA0204	UPPER LIFTING BOARD 1	LTS504(ENG)P-EP19	1
28	VSSA0205	BLOCK BEARING	3BE03UFL002	4

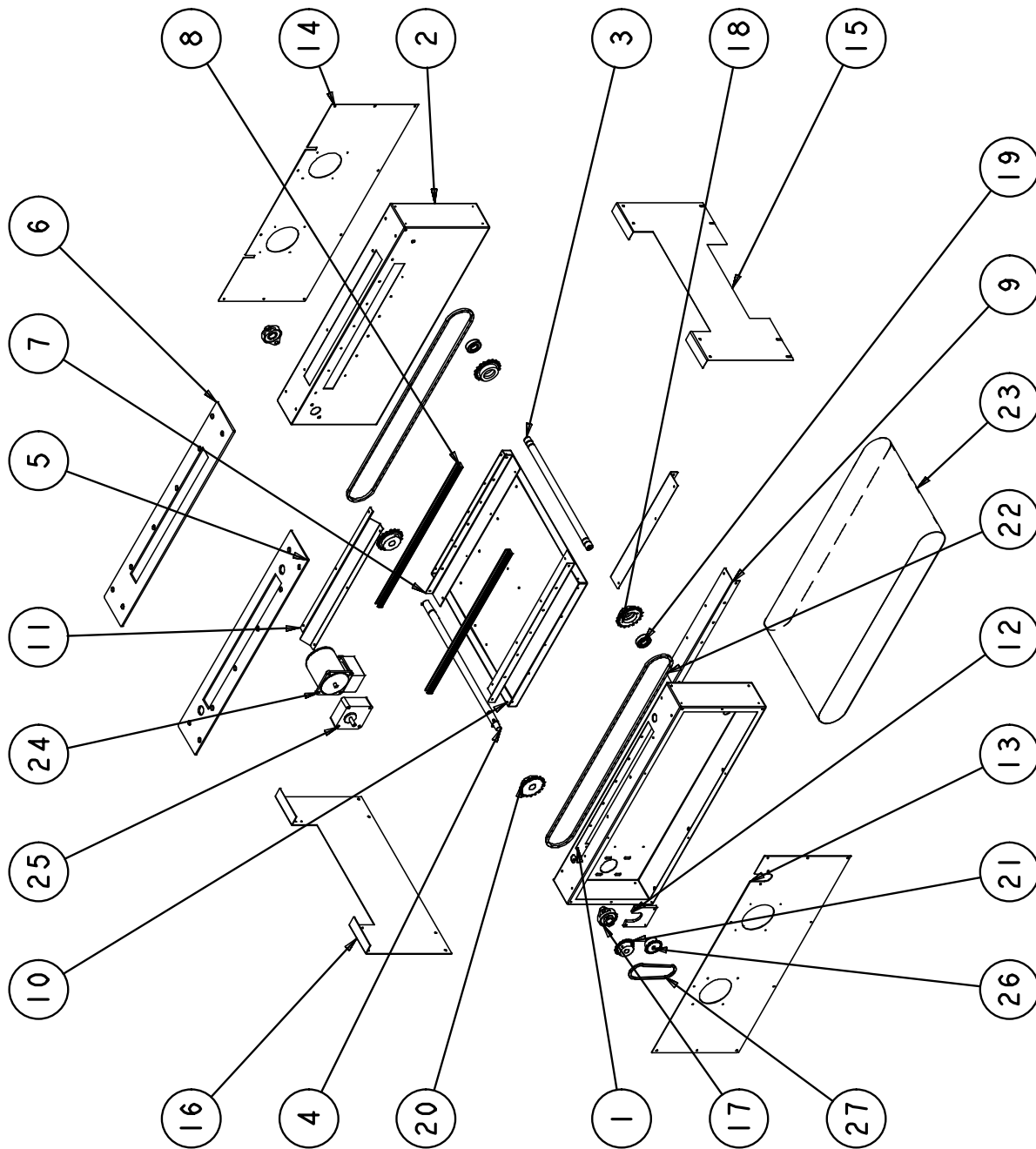
## Heat Tunnel Support with Live Rollers – VSTA0065LR (VS1620DA-LR)



ITEM	PART NO.	DESCRIPTION	REFERENCE	Q'TY
1	VSTA0038	FURNACE FRAME LEFT	VS1620-DP01	1
2	VSTA0039	FURNACE FRAME RIGHT	VS1620-DP02	1
3	VSTA0040	DRIVEN SHAFT	LTS504(ENG)P-DM01	1
4	VSTA0041	DRIVING SHAFT	LTS504(ENG)P-DM02	1
5	VSTA0042	BAKELITE A	LTS504(ENG)P-DC03	1
6	VSTA0043	BAKELITE B	LTS504(ENG)P-DC04	1
7	VSTA0044	CONNECTION BOARD	LTS504(ENG)P-DP09	2
8	VSTA0045	TRACK	LTS504(ENG)P-DC02	2
9	VSTA0046	CONNECTION BOARD	LTS504(ENG)P-DP10	2

ITEM	PART NO.	DESCRIPTION	REFERENCE	Q'TY
10	VSTA0047	BOTTOM PLATE	LTS504(ENG)P-DP11	1
11	VSTA0048	FIXED PLATE	LTS504(ENG)P-DP12	1
12	VSTA0049	MOTOR FIXED PLATE	LTS504(ENG)P-DP13	1
13	VSTA0050	FRAME COVER (LEFT)	VS1620-DP03	1
14	VSTA0051	FRAME COVER (RIGHT)	VS1620-DP04	1
15	VSTA0052	FRAME COVER (FRONT)	VS1620-DP05	1
16	VSTA0053	FRAME COVER (REAR)	VS1620-DP06	1
17	VSTA0054	BLOCK BEARING	5BE03UFL004	2
18	VSTA0055	SPROCKET	5BF01LTS504PDC01	2
19	VSTA0056	BEARING	5BE016004ZZ	2
20	VSTA0057	SPROCKET	5BF011B4X18T20M66	2
21	VSTA0058	SPROCKET	5BF011B3X18T15M65	1
22	VSTA0059	CHAIN WITH ATTACHMENT	5BA02A4X063126	2
23	VSTA0060	OUTPUT ROLLER	5BB06S0395X1626	63
24	VSTA0061	INDUCTION MOTOR	5CH0151K40GNCT	1
25	VSTA0062	GEAR BOX	5CH615GN18K	1
26	VSTA0063	SPROCKET	5BF011B3X15T10M64	1
27	VSTA0064	ROLLER CHAIN	5BA0113X038	1

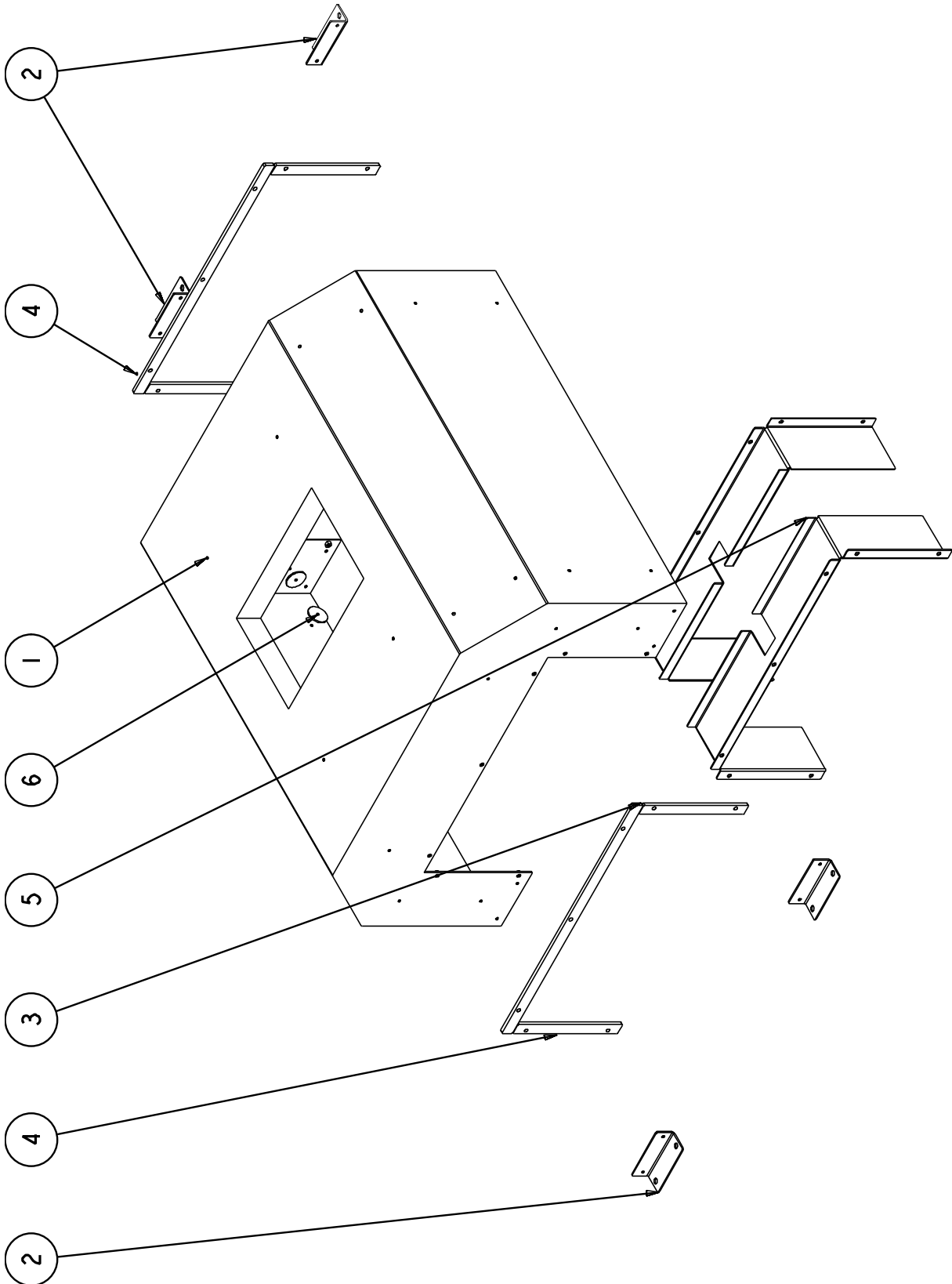
### Heat Tunnel Support with Wire Mesh Belt Conveyor – VSTA0065MB (VS1620DA-MB)



ITEM	PART NO.	DESCRIPTION	REFERENCE	Q'TY
1	VSTA0038	FURNACE FRAME LEFT	VS1620-DP01	1
2	VSTA0039	FURNACE FRAME RIGHT	VS1620-DP02	1
3	VSTA0040	DRIVEN SHAFT	LTS504(ENG)P-DM01	1
4	VSTA0041	DRIVING SHAFT	LTS504(ENG)P-DM02	1

ITEM	PART NO.	DESCRIPTION	REFERENCE	Q'TY
5	VSTA0042	BAKELITE A	LTS504(ENG)P-DC03	1
6	VSTA0043	BAKELITE B	LTS504(ENG)P-DC04	1
7	VSTA0044	CONNECTION BOARD	LTS504(ENG)P-DP09	2
8	VSTA0045	TRACK	LTS504(ENG)P-DC02	2
9	VSTA0046	CONNECTION BOARD	LTS504(ENG)P-DP10	2
10	VSTA0047	BOTTOM PLATE	LTS504(ENG)P-DP11	1
11	VSTA0048	FIXED PLATE	LTS504(ENG)P-DP12	1
12	VSTA0049	MOTOR FIXED PLATE	LTS504(ENG)P-DP13	1
13	VSTA0050	FRAME COVER (LEFT)	VS1620-DP03	1
14	VSTA0051	FRAME COVER (RIGHT)	VS1620-DP04	1
15	VSTA0052	FRAME COVER (FRONT)	VS1620-DP05	1
16	VSTA0053	FRAME COVER (REAR)	VS1620-DP06	1
17	VSTA0054	BLOCK BEARING	5BE03UFL004	2
18	VSTA0055	SPROCKET	5BF01LTS504PDC01	2
19	VSTA0056	BEARING	5BE016004ZZ	2
20	VSTA0057	SPROCKET	5BF011B4X18T20M66	2
21	VSTA0058	SPROCKET	5BF011B3X18T15M65	1
22	VSTA0059	CHAIN WITH ATTACHMENT	5BA02A4X063126	2
23	VSTA0060	OUTPUT BELT WIRE MESH	5BB06S0395X1626	1
24	VSTA0061	INDUCTION MOTOR	5CH0151K40GNCT	1
25	VSTA0062	GEAR BOX	5CH615GN18K	1
26	VSTA0063	SPROCKET	5BF011B3X15T10M64	1
27	VSTA1064	ROLLER CHAIN	5BA0113X038	1

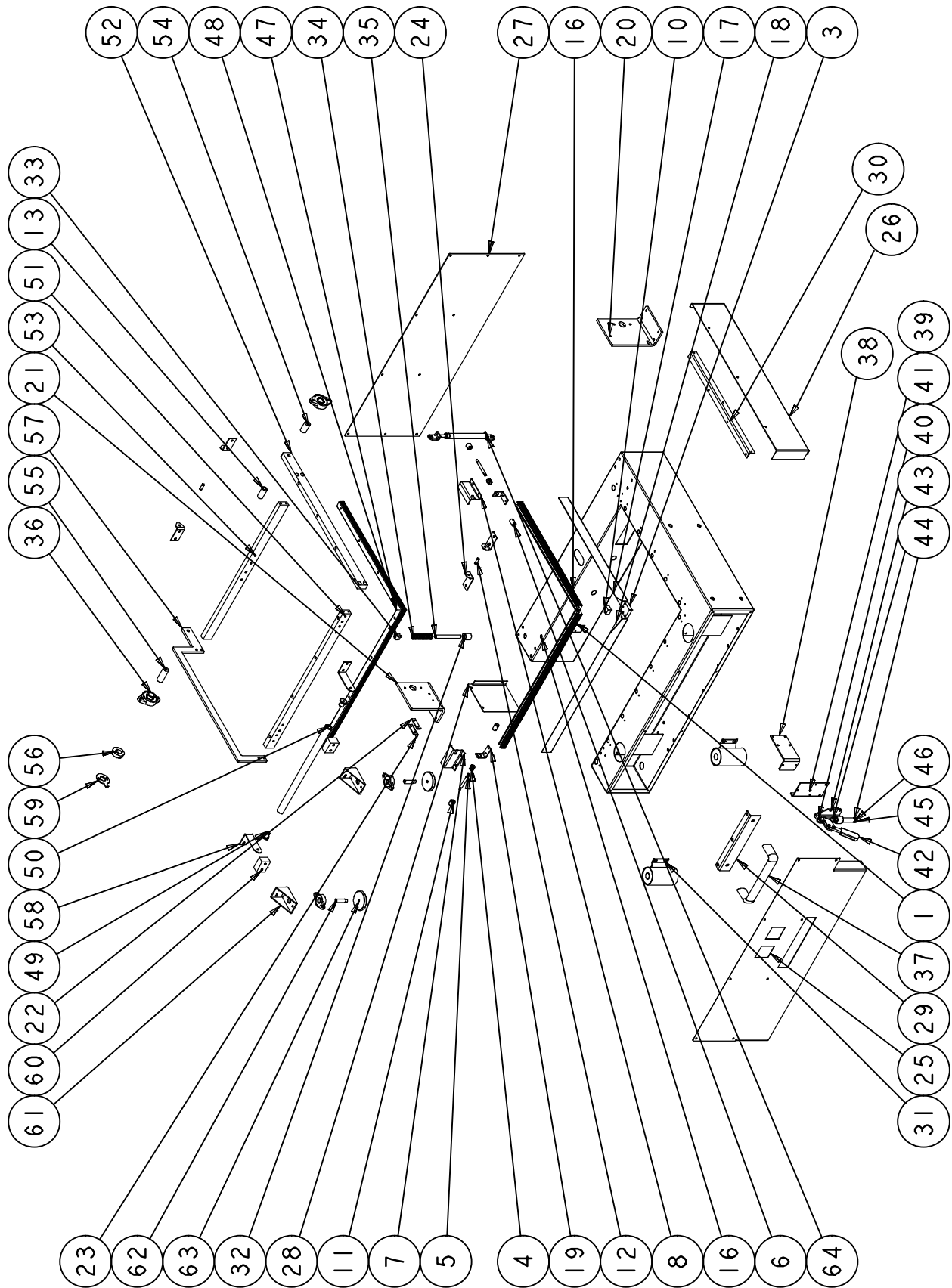
### Heat Tunnel Hood Assembly – VSTA0066 (VS1620DC)



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ITEM	PART NO.	DESCRIPTION	REFERENCE	Q'TY
1	VSTA0020	FURNACE COVER	VS1620-DP07	1
2	VSTA0021	CONNECTION BOARD	VS1620-DP08	4
3	VSTA0022	BAKELITE A	LTS504(ENG)P-DC05	2
4	VSTA0023	BAKELITE B	LTS504(ENG)P-DC06	4
5	VSTA0024	FURNACE DOOR	LTS504(ENG)P-DP15	2
6	VSTA0025	FURNACE COVER WASHER	LTS504(ENG)P-DP23	32

### L-Sealer and Frame for Hot Band – VSTA0259 (VS1620E)



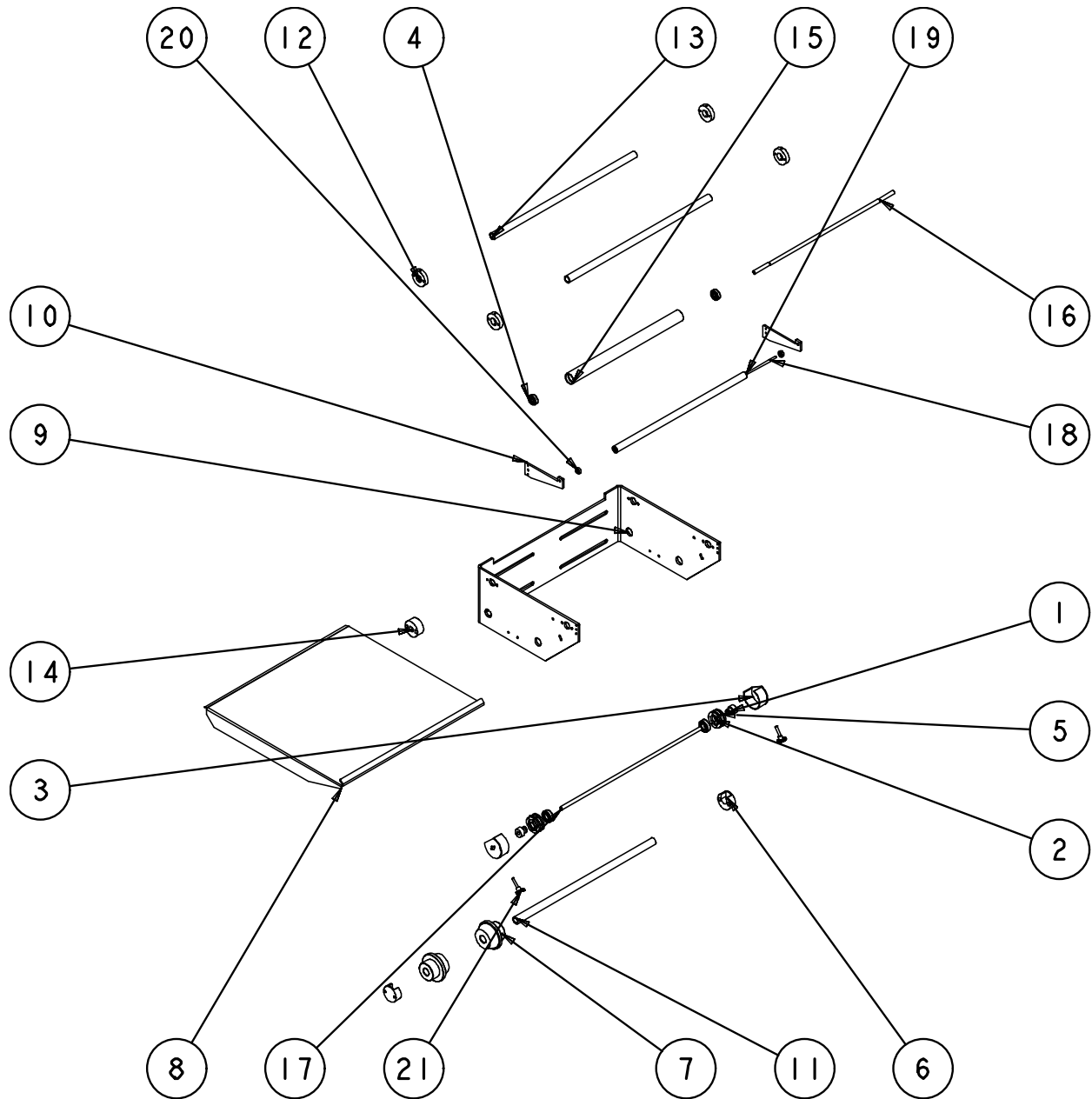


ITEM	PART NO.	DESCRIPTION	REFERENCE	Q'TY
1	VSSA0114	LOWER SEAL BEAD SEAT	LTM504(ENG)-EC01	1
2	VSSA0115	SEALING AREA LONG BAR	LTS504(ENG)P-EC01	1
3	VSSA0116	CORNER RADIUS GUIDE	LTM504(ENG)-EM01	1
4	VSSA0117	SEAL BAND COMPENSATOR SPRING	LTM504(ENG)-EM03	2
5	VSSA0118	SEAL BAND COMPENSATOR COLLAR	LTM504(ENG)-EM04	2
6	VSSA0119	SEAL BAND BEAD	LTM504(ENG)-EM05	2
7	VSSA0120	COMPENSATOR COVER MD	LTM504(ENG)P-EC02	1
8	VSSA0121	COMPENSATOR COVER TD	LTM504(ENG)-EC05	1
9	VSSA0122	SEALING AREA PIECE	LTM504(ENG)P-EM01	4
10	VSSA0123	SEAL BAND CORNER RADIUS GUIDE	LTM504(ENG)-EM02	1
11	VSSA0124	SEAL BAND COMPENSATOR PIECE	LM504(ENG)-EM16	2
12	VSSA0125	CYLINDER PIVOT SHAFT	VS1620-EM04	2
13	VSSA0126	AXLE	VS1620-EM05	1
14	VSSA0127	SEAL AREA PIECE	LTS504(ENG)P-EP18	1
15	VSSA0128	SEAL AREA PIECE	LTS504(ENG)P-EP19	1
16	VSSA0129	SEAL AREA MAIN BODY	VS1620-EP01	1
	VSSA0001	HOT BAND HEATER STRIP	SEAL BAND (Not Shown)	1
17	VSSA0130	SEALER LOWER BEAD SEAL L-BRACKET TD	VS1620-EP02	1
18	VSSA0131	SEALER LOWER BEAD SEAL L-BRACKET MD	VS1620-EP03	1
19	VSSA0132	SEAL BAND COMPENSATOR SEAT	LTM504(ENG)-EP03	2
20	VSSA0133	FIXED SEAT (RIGHT)	VS1620-EP04	1
21	VSSA0134	FIXED SEAT (LEFT)	VS1620-EP05	1
22	VSSA0135	STRAP PLATE	LTM504(ENG)-AP06	1
23	VSSA0136	ANGLE BRACKET	LTM504(ENG)-AP07	1
24	VSSA0137	CYLINDER SEAT	VS1620-EP08	4
25	VSSA0138	PANEL	VS1620-EP11	1
26	VSSA0139	COVER 1	VS1620-EP12	1
27	VSSA0140	COVER 2	VS1620-EP13	1
28	VSSA0141	COVER 3	VS1620-EP14	1
29	VSSA0142	SEALING BASE HANDLE ANGLE	LTS504(ENG)-EP20	1
30	VSSA0143	FIXED PLATE	LTS504(ENG)-EP21	1
31	VSSA0144	SOLENOID	5AA14CS40923B	2
32	VSSA0145	SPRING ROD SPOOL	VS1620-EM12	1

## 50 Parts List

ITEM	PART NO.	DESCRIPTION	REFERENCE	Q'TY
33	VSSA0146	HEX SOCKET SET SCREW	5EE91M6X18X12	1
34	VSSA0147	COMPRESSION SPRING	5EH1418X13.8X65X11.5N	1
35	VSSA0148	SPRING ROD, VERTICAL	VS1620-EM11	1
36	VSSA0149	LINEAR BUSHING	5BE03UFL003	2
37	VSSA0150	SEALING BASE HANDLE	5BC03AGS200	1
38	VSSA0151	ANGLE BRACKET INNER FOR CLAMP	VS1620-OP01	1
39	VSSA0152	ANGLE BRACKET OUTER FOR CLAMP	VS1620-OP02	1
40	VSSA0153	TOGGLE CLAMP (Includes Items 40 Thru 46)	5E107CH36092M	1
40	VSSA0153	TOGGLE CLAMP MOUNTING FLANGE	5E107CH36092M	1
41	VSSA0160	TOGGLE CLAMP BODY	5E107CH36092M	1
42	VSSA0161	TOGGLE CLAMP HANDLE LEVER RED	5E107CH36092M	1
43	VSSA0162	TOGGLE CLAMP PIVOT PIN	5E107CH36092M	1
44	VSSA0163	TOGGLE CLAMP SPRING	5E107CH36092M	1
45	VSSA0164	TOGGLE CLAMP ROD	5E107CH36092M	1
46	VSSA0165	TOGGLE CLAMP CLIP RING	5E107CH36092M	1
47	VSSA0166	HB SEAL BAND UPPER CUSHION MD	VS1620-EC01	1
48	VSSA0167	HB SEAL BAND UPPER CUSHION TD	VS1620-EC02	1
49	VSSA0168	HANDLE SHAFT	LTM504(ENG)-EM09	2
50	VSSA0169	HANDLE	LTM504(ENG)-EM10	1
51	VSSA0170	VERTICAL SEAL SEAT	VS1620-EM01	1
52	VSSA0171	HORIZONTAL SEAL SEAT	VS1620-EM02	1
53	VSSA0172	CROSSBAR	VS1620-EM03	1
54	VSSA0173	AXLE	VS1620-EM06	1
55	VSSA0174	AXLE	VS1620-EM07	1
56	VSSA0175	FIXED RING	LTM504(ENG)-EM08	1
57	VSSA0176	LEFT SUPPORT BRACKET	VS1620-EP06	1
58	VSSA0177	HANDLE SEAT	VS1620-EP07	2
59	VSSA0114	FRETTING PLATE	LTM504(ENG)-EP05	1
60	VSSA0115	SPACER BLOCK	VS1620-EM08	2
61	VSSA0116	FIXED SEAT	VS1620-EP09	2
62	VSSA0117	HEX SOCKET SET SCREW	VS1620-EM09	2
63	VSSA0118	PRESSURE PLATE	VS1620-EP10	2
64	VSSA0119	CYLINDER	FGSS15090A	1

**Product Tray with Film Holder and Perforator – VSSA0260 (VS1620G)**

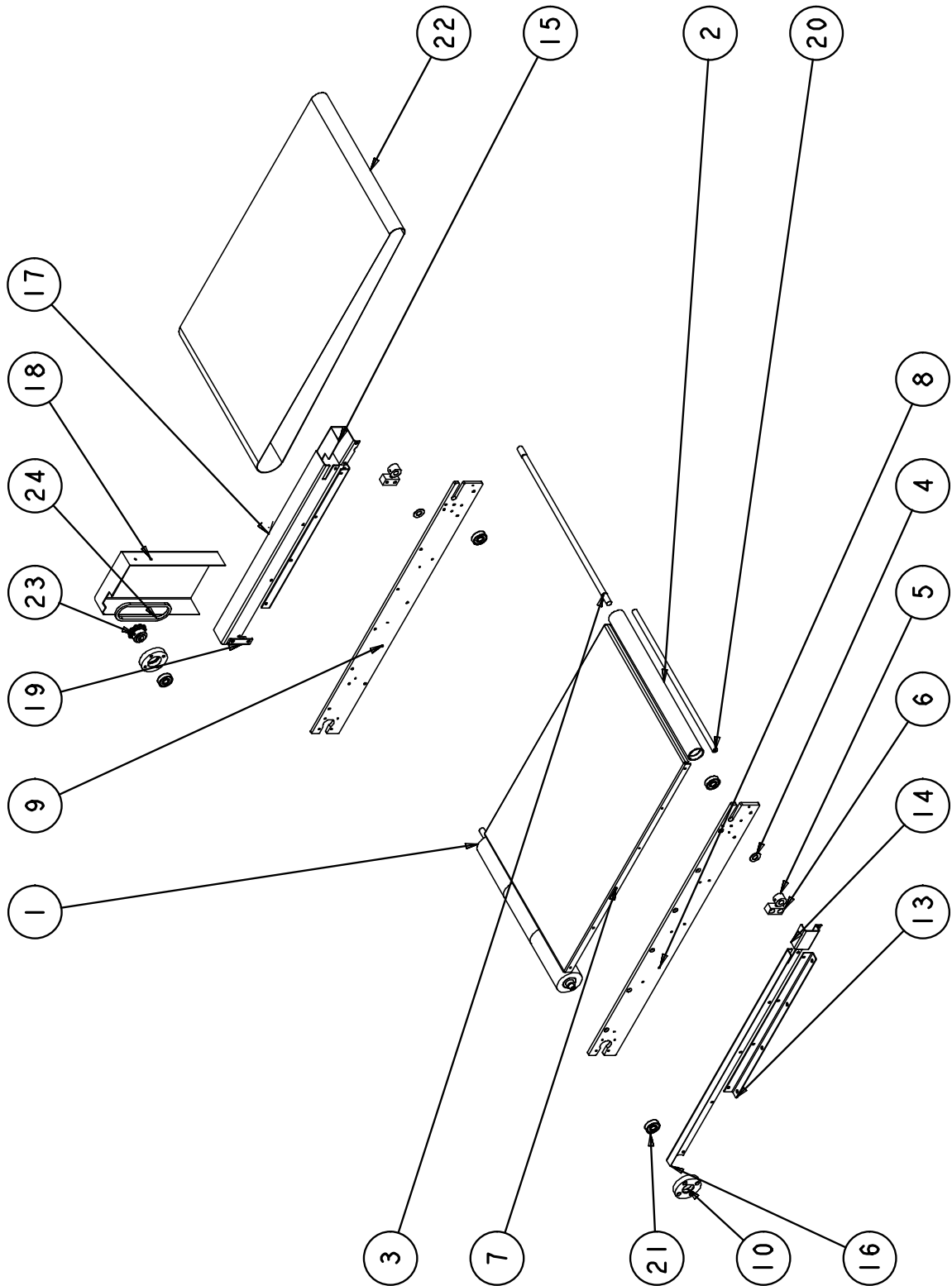


ITEM	PART NO.	DESCRIPTION	REFERENCE	Q'TY
1	VSSA0230	PIN RING	LTM504(ENG)-GM06	2
2	VSSA0231	FEED ROLLER AXLE-1	LTM504(ENG)-GM07	2
3	VSSA0232	PIN RING COVER	LTM504(ENG)-GC01	2
4	VSSA0233	BEARING	5BE016200ZZ	2
5	VSSA0234	PIN RING	5HFLSA504CGM17X2	12
6	VSSA0235	FIXED SEAT	LTM504-GM01	2

## 52 Parts List

ITEM	PART NO.	DESCRIPTION	REFERENCE	Q'TY
7	VSSA0236	SHRINK WRAP FIXED BLOCK	LTM504(ENG)-GM02	2
8	VSSA0237	MEMBRANE PLATE	VS1620-GP02	1
9	VSSA0238	RACK	VS1620-GP01	1
10	VSSA0239	ROLLER SUPPORT	VS1620-GP03	2
11	VSSA0240	GUIDE ROD-2	VS1620-GM09	1
12	VSSA0241	FIXED SEAT	VS1620-GM01	4
13	VSSA0242	GUIDE ROD-1	VS1620-GM08	2
14	VSSA0243	SHRINK WRAP FIXED BLOCK	VS1620-GM02	1
15	VSSA0244	PIN RING	VS1620-GM04	1
16	VSSA0245	PIN RING AXLE	VS1620-GM03	1
17	VSSA0246	FIXED SEAT	VS1620-GM05	1
18	VSSA0247	FEED ROLLER-2	VS1620-GM06	1
19	VSSA0248	FEED ROLLER AXLE 1	VS1620-GM07	1
20	VSSA0249	BEARING	5BE010606ZZ	2
21	VSSA0250	EMBOSSING SCREW	5BC04801025M630	2
22	VSSA0251	BEARING	5BE016003ZZ	2
23	4502389	PLUM HANDLE	5BC04GN01ST32M06X16	2

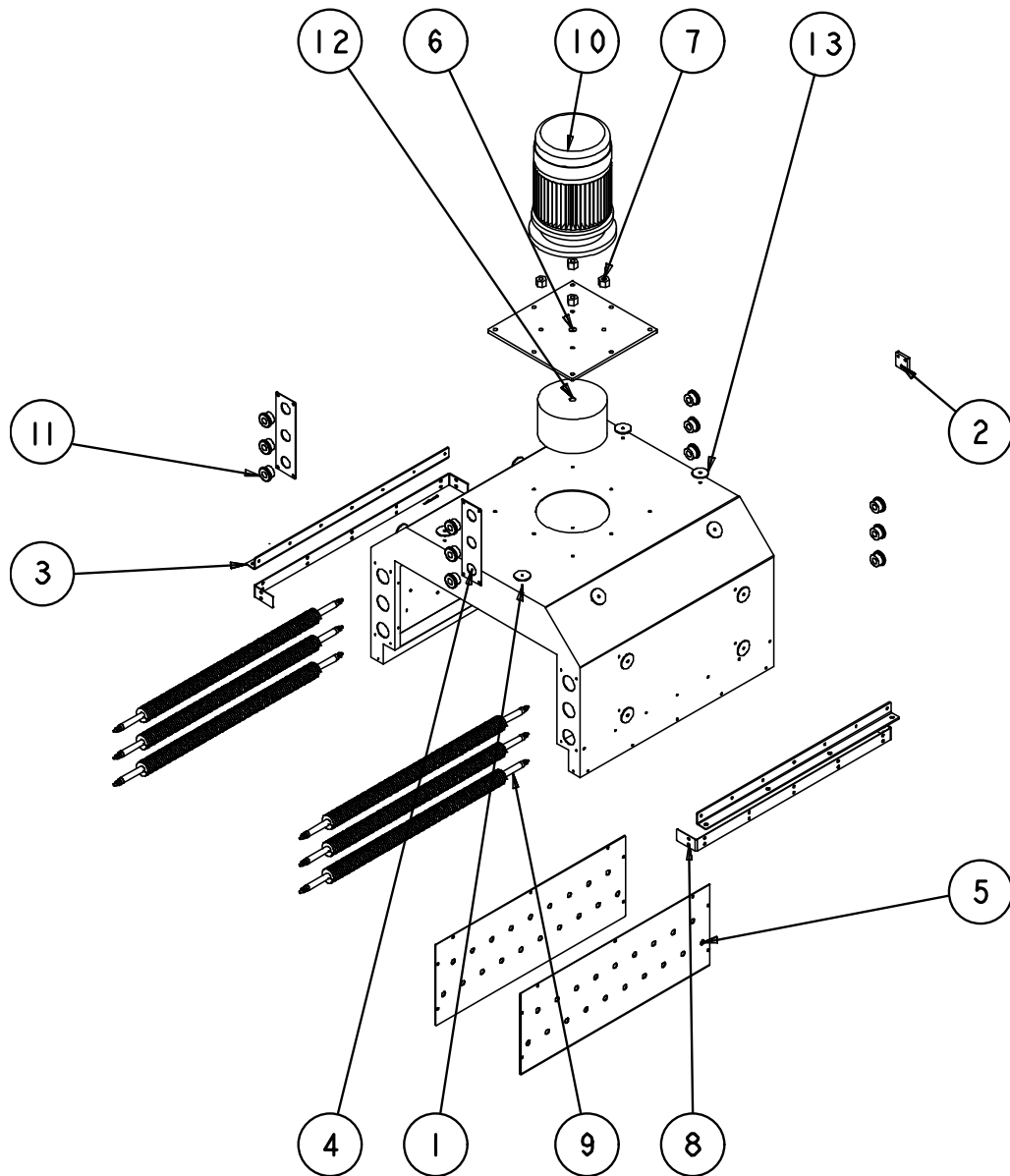
### L-Sealer Takeaway Conveyor – VSSA0261 (LTS504P-B)



## 54 Parts List

ITEM	PART NO.	DESCRIPTION	REFERENCE	Q'TY
1	VSSA0206	DRIVE SHAFT	LTS504(ENG)P-BC01	1
2	VSSA0207	DRIVEN ROLLER	LTS504(ENG)P-BM03	1
3	VSSA0208	DRIVEN AXLE	LTS504(ENG)P-BM02	1
4	VSSA0209	WASHER	LTS504(ENG)P-BM04	2
5	VSSA0210	FIXED RING	LTS504(ENG)P-BM05	2
6	VSSA0211	ADJUSTMENT SEAT	LTS504(ENG)P-BM06	2
7	VSSA0212	SUPPORT PLATE	LTS504(ENG)P-BP04	1
8	VSSA0213	FIXED PLATE (LEFT)	LTS504(ENG)P-BP01	1
9	VSSA0214	FIXED PLATE (RIGHT)	LTS504(ENG)P-BP02	1
10	VSSA0215	FIXED SEAT	LTS504(ENG)P-BM01	2
11	VSSA0216	MOTOR ADJUSTMENT PLATE	LTS504(ENG)P-BP12	1
12	VSSA0217	MOTOR SEAT	LTS504(ENG)P-BP11	1
13	VSSA0218	CONNECTION PLATE	LTS504(ENG)P-BP03	2
14	VSSA0219	LEFT COVER	LTS504(ENG)P-BP05	1
15	VSSA0220	RIGHT COVER	LTS504(ENG)P-BP06	1
16	VSSA0221	CONVEYOR LEFT COVER	LTS504(ENG)P-BP07	1
17	VSSA0222	CONVEYOR RIGHT COVER	LTS504(ENG)P-BP08	1
18	VSSA0223	CHAIN COVER	LTS504(ENG)P-BP09	1
19	VSSA0224	CONNECTION PLATE	LTS504(ENG)P-BP10	1
20	VSSA0225	FIXED ROD	LTS504(ENG)P-BM07	1
21	VSSA0226	BEARING	5BE016000ZZ	4
22	VSSA0043	POLYURETHANE CONVEYOR BELT	5BB01SL01X340X1275	1
23	VSSA0228	SPROCKET	5BE01LTS504PBC02	1
24	VSSA0229	ROLLER CHAIN	5BA0113X036	1

### Tunnel Furnace Assembly – VSTA0067 (LTS504P-DB)



ITEM	PART NO.	DESCRIPTION	REFERENCE	Q'TY
1	VSTA0025	INNER FURNACE	LTS504(ENG)P-DP14	1
2	VSTA0027	FIXED PLATE	LTS504(ENG)P-DP15	1
3	VSTA0028	CONNECTION BOARD	LTS504(ENG)P-DP16	2
4	VSTA0029	FIXED PLATE	LTS504(ENG)P-DP17	2
5	VSTA0030	CONNECTION BOARD	LTS504(ENG)P-DP18	2
6	VSTA0031	FIXED PLATE	LTS504(ENG)P-DP19	1
7	VSTA0032	CUSHION	LTS504(ENG)-DM03	4
8	VSTA0033	CONNECTION BOARD (LEFT & RIGHT)	LTS504(ENG)P-DP20	2

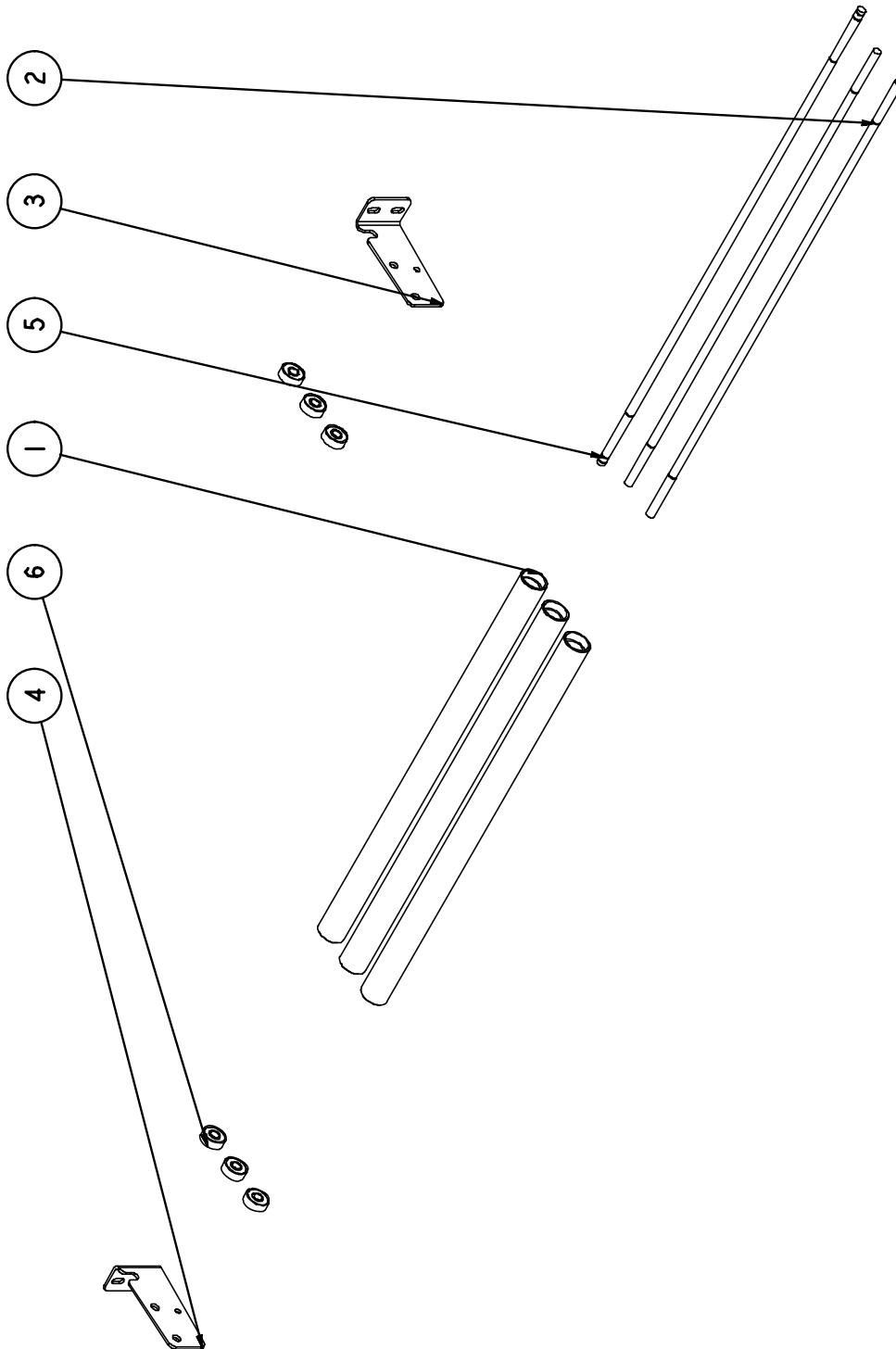
56 Parts List

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ITEM	PART NO.	DESCRIPTION	REFERENCE	Q'TY
9	VSTA0034	HEATER	5AF02A40550X207	6
10	VSTA0035	MOTOR	5Y2851	1
11	VSTA0036	CERAMIC INSULATOR	5AF9112	12
12	VSTA0037	CENTRIFUGAL FAN	5AG025X76X3	1
13	VSTA0026	TUNNEL HOOD WASHER	LTS504(ENG)P-DP23	18



**Exit Roller Assembly – VSSA0262 (VS1620DB)**



ITEM		DESCRIPTION	REFERENCE	Q'TY
1	VSSA0252	OUTPUT ROLLER	VS1620-DM02	3
2	VSSA0253	OUTPUT AXLE	VS1620-DM03	2
3	VSSA0254	OUTPUT ROLLER SUPPORT-1	VS1620-DP09	1

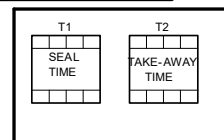
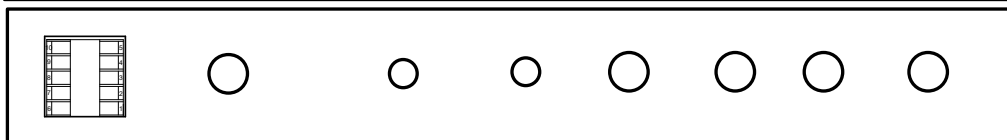
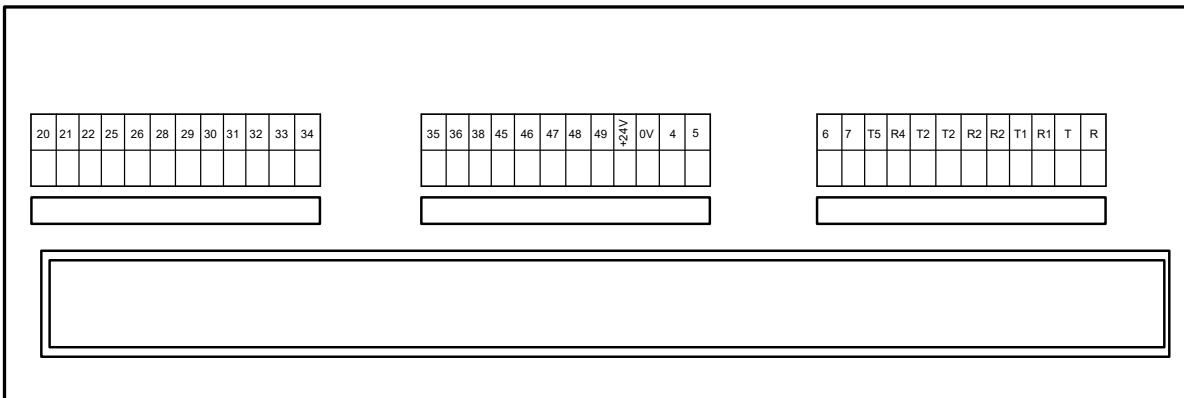
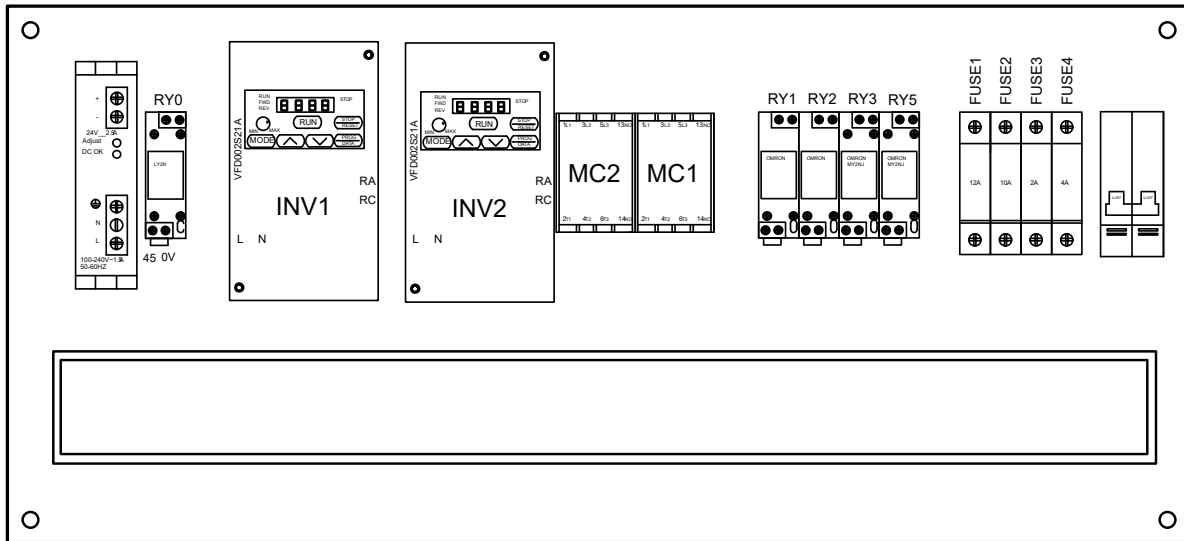
58 Parts List

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ITEM		DESCRIPTION	REFERENCE	Q'TY
4	VSSA0255	OUTPUT ROLLER SUPPORT-2	VS1620-DP10	1
5	VSSA0256	OUTPUT AXLE-1	VS1620-DM01	1
6	VSSA0257	OUTPUT ROLLER	5BE010606ZZ	6

# Electrical

## Electrical Panel



## Electrical Parts List

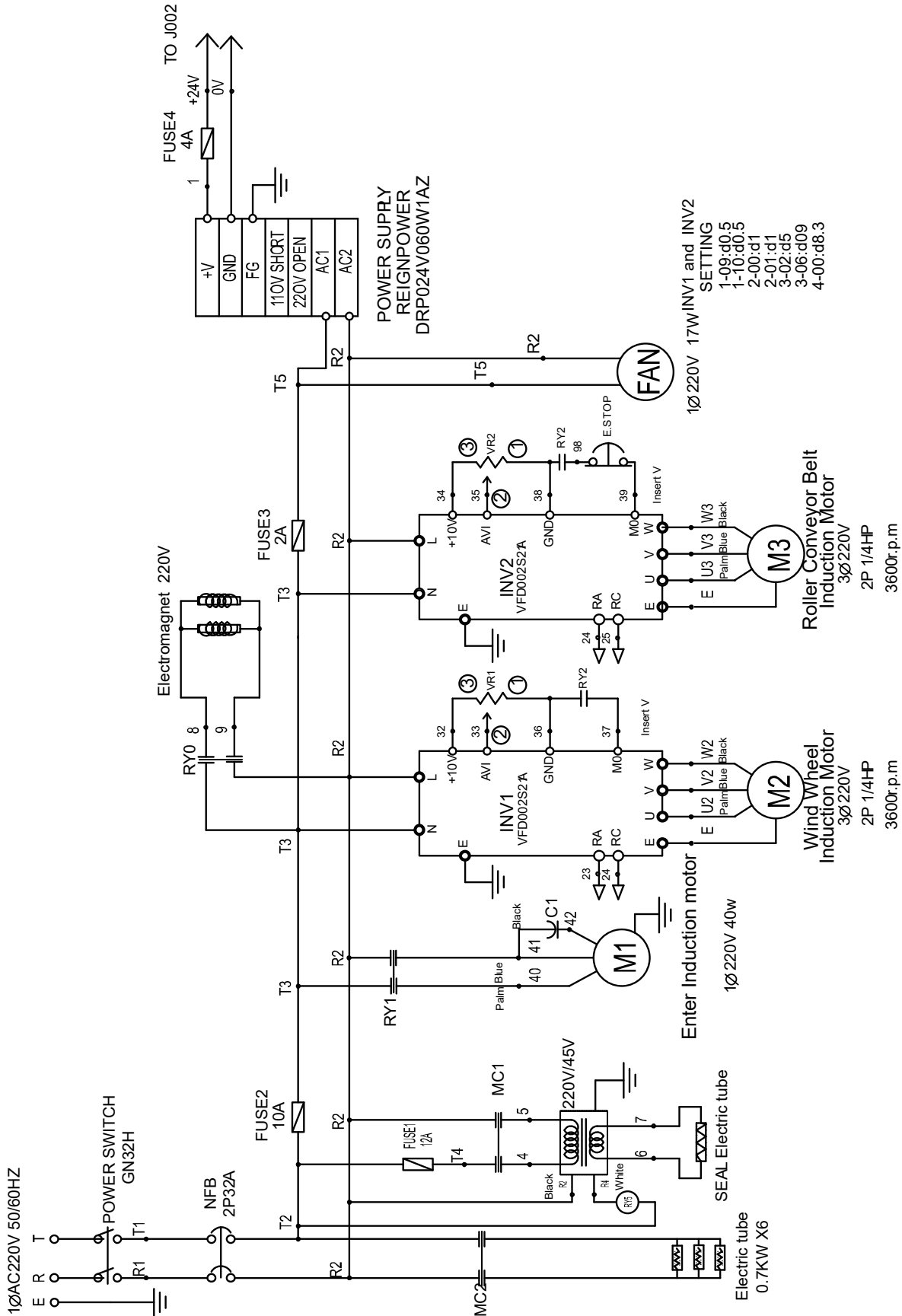
DESIGNATOR	DESCRIPTION	PART NO.
POWER SUPPLY REIGNPOWER	POWER SUPPLY, 24 VDC REIGNPOWER, DRP024V060W1AZ	VSCP0006
MC1	CONTACTOR 1	VSCP0002
MC2	CONTACTOR 2	VSCP0001
FUSE 1	FUSE, 12 AMP	VSCP0010
FUSE 2	FUSE, 10 AMP	VSCP0011
FUSE 3	FUSE, 2 AMP	VSCP0013
FUSE 4	FUSE, 4 AMP	VSCP0012
RY1, RY2, RY3	RELAY 1, RELAY 2, RELAY 3; RELAY 24 VOLT DC	VSCP0016
RY5	RELAY 220 VOLT	VSCP0016
T1 – T2	TIMERS: CONVEYOR & MAGNET	VSSA0004

Items in the table above are shown in the Electrical Panel drawing on the previous page and the Electrical Schematics on the following pages.

DESIGNATOR	DESCRIPTION	PART NO.
HEATER 0.7 KW	HEATER 0.7 KILOWATT W × 6 – 220V (TUNNEL)	VSTA0002
220V/45V	TRANSFORMER, 220V / 45V	VSCP0005
SEAL BAND	HOT BAND HEATER STRIP CUTTER / SEALER	VSSA0001
M1	TAKE AWAY CONVEYOR MOTOR 1φ 220V 40W	VSSA0006
M2	BLOWER MOTOR 3φ 220V 2P-½ HP 3600 RPM	VSTA0005
M3	TUNNEL CONVEYOR MOTOR 3φ 220V 25W	VSTA0003
TEMP. PROBE	TEMPERATURE PROBE	VSTA0007
L. S.	LIMIT SWITCH 250V 25A	VSSA0008
TEMP. CONTROLLER	TEMPERATURE CONTROLLER	VSTA0001

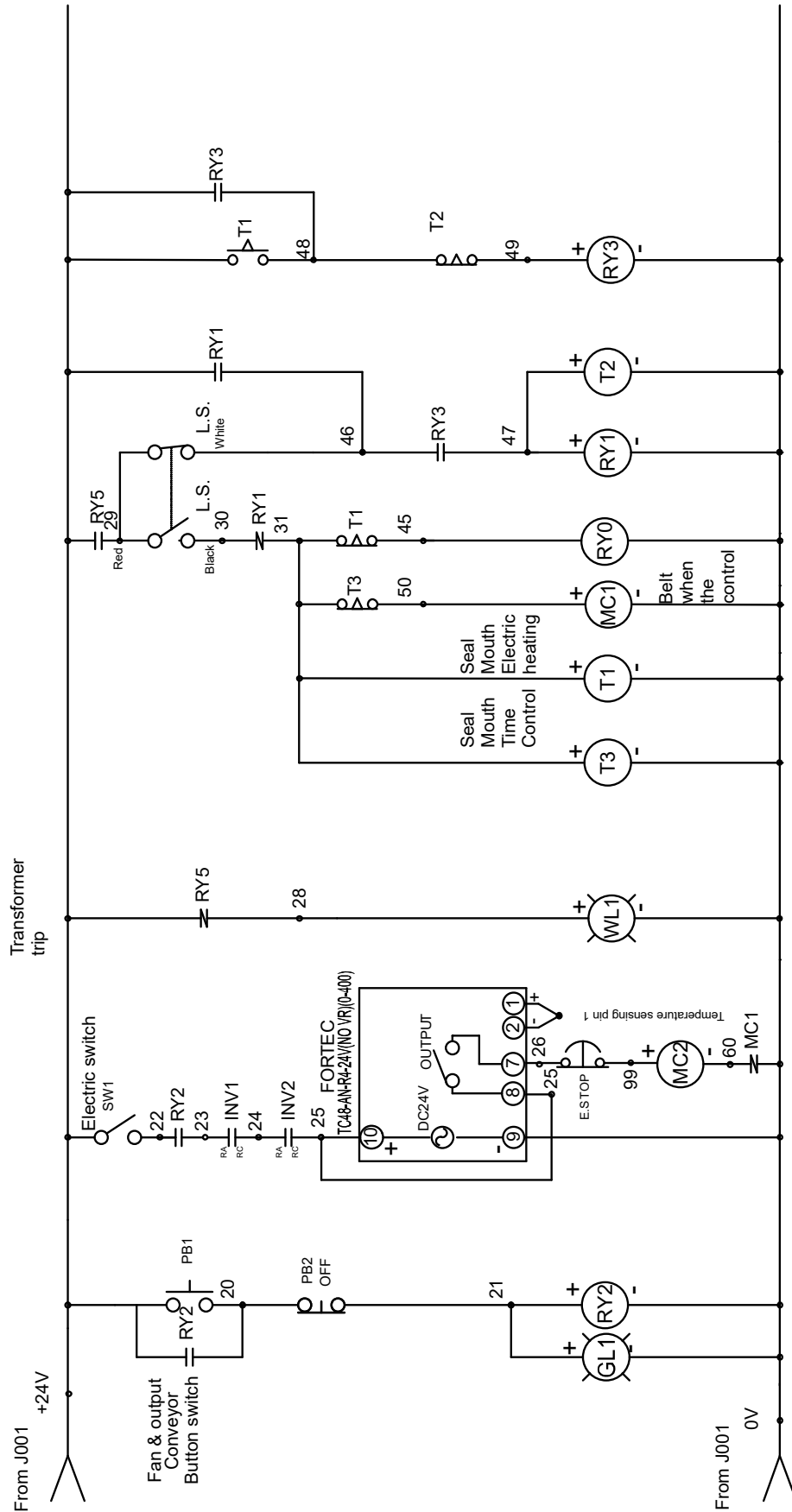
Items in the table above are shown in the Electrical Schematics on the following pages.

Electrical Schematic (Sheet 1 of 2)



# Electrical Schematic (Sheet 2 of 2)

MT48 SETTING:  
 CT:15  
 P:26  
 I:85  
 D:23



# Warranty Statement

## Eastey L-Sealer and Tunnel Combo

### Warranty Statement

Eastey 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 one (1) year from the date of shipment by Eastey and will conform to the published specifications for that product.

### Warranty Period — Specific Items

Drive motor(s): 1 year

End Curtains 30 days

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.)

### 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). Once an RMA number has been obtained, return the defective item to Eastey. Eastey will analyze the product and, if found to be defective, we will at our option, replace or repair the item. If the item is found to be not eligible for warranty, you will be notified and may decide on disposition. Defective products will be replaced or repaired as promptly as possible.

### Warranty Eligibility

The warranty provided by Eastey 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 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 HAS BEEN ADVISED OF THE POSSIBILITY OF SUCH DAMAGES.

# Customer Support

## **Eastey Technical Service**

For help installing or operating the Eastey L-Bar Sealer Tunnel Combo, please contact your authorized Eastey reseller or 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 [eastey@eastey.com](mailto:eastey@eastey.com)

Web [www.eastey.com](http://www.eastey.com)

Thanks again for your purchase of Eastey products. We are pleased to be a part of your package sealing needs.







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