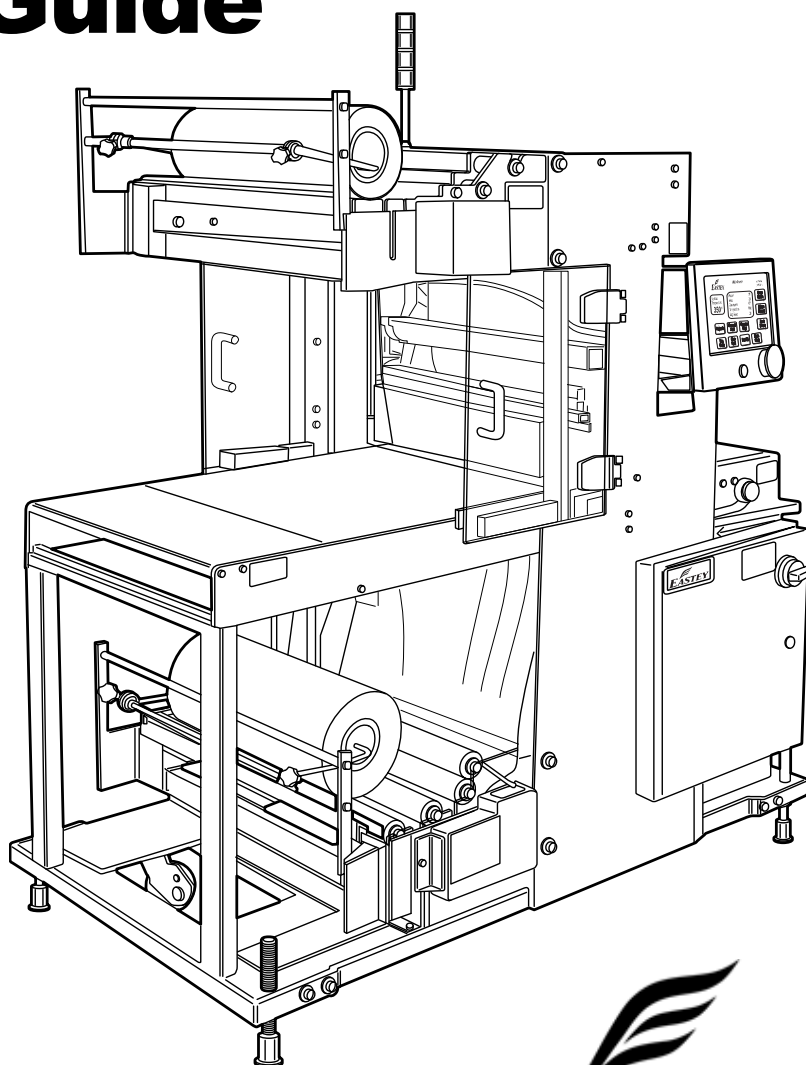


EB25F -AV1 -AV5

Automatic Bundling Professional Series

User Guide



EASTEY

EB25F -AV1/-AV5

Automatic Bundling Professional Series

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 (Eastey.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. The part you, the user, play through proper installation and maintenance procedures is of far greater importance than our design. Only properly-trained individuals following rigidly enforced safety rules, as recommended by applicable national and local safety code organizations 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.

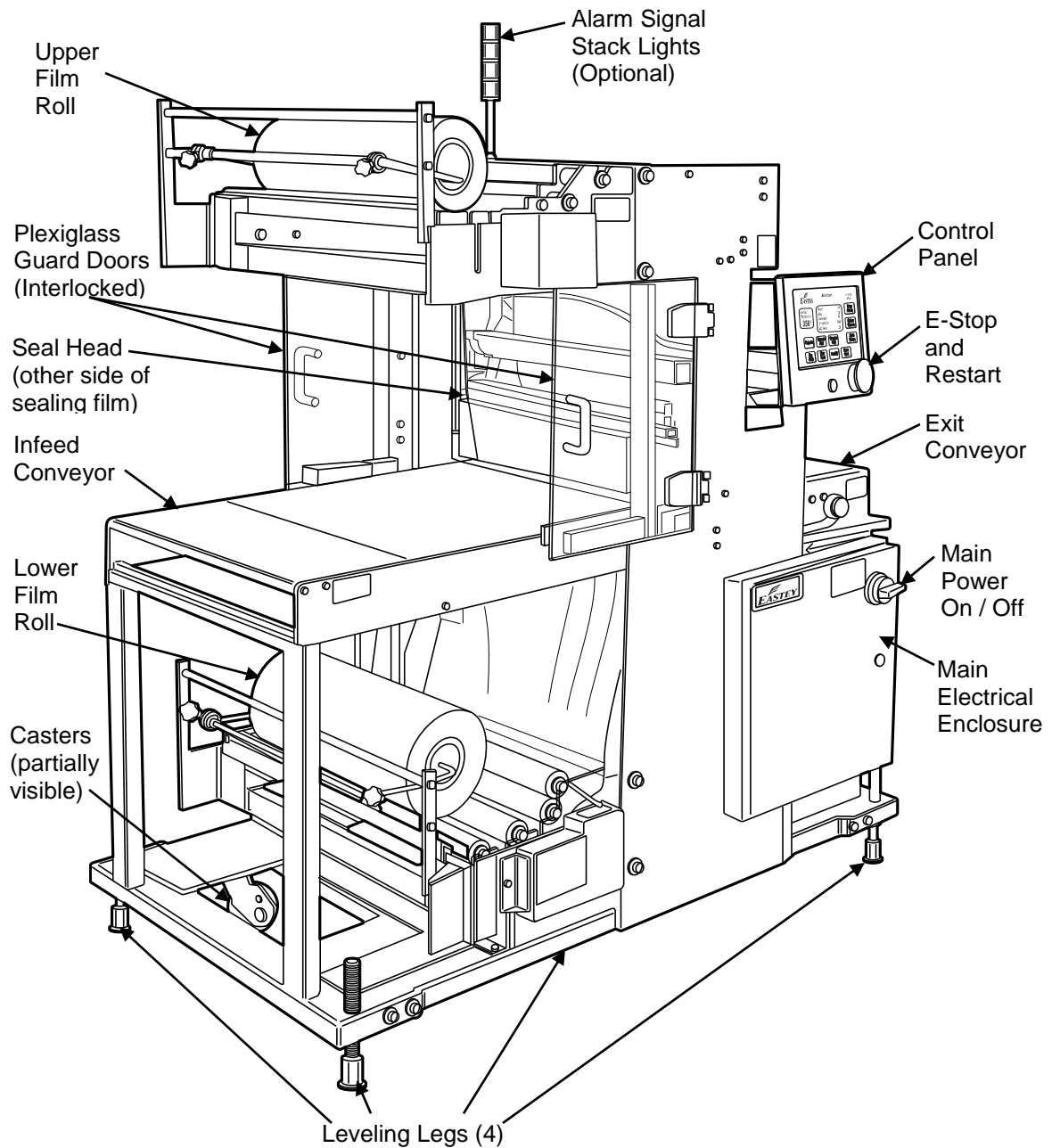
General Safety Precautions

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.
- 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 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

In the model designator EB25F-AV1 or EB25F-AV5, EB and A indicate that the machine is an Eastey Bundler and Automatic. 25 indicates the conveyor width is 25 inches. F indicates a “Fixed” or stationary lower seal seat. V1 indicates that it requires 220 volts AC, single phase power; V5 indicates that it requires 480 volts AC, single phase power.

Specifications

Table 1 Machine Dimensions

Model Number	Machine Dimensions			Seal Dimensions	
	Width (A)	Height (B)	Length (C)	Width	Height
EB25F-AV1	43 in.	80 in.	63 in.	25 in.	22 in.
EB25F-AV5	109 cm	203 cm	160 cm	64 cm	51 cm

Table 2 Air Requirements

Model Number	Minimum Air Requirements
EB25F-AV1 EB25F-AV5	1.5 CFM 60 PSI

Table 3 Power Requirements

Model Number	Standard Power		
	Volts	Amps	Phase
EB25F-AV1	220	15	1
EB25F-AV5	480	10	1

Table 4 Machine Weights

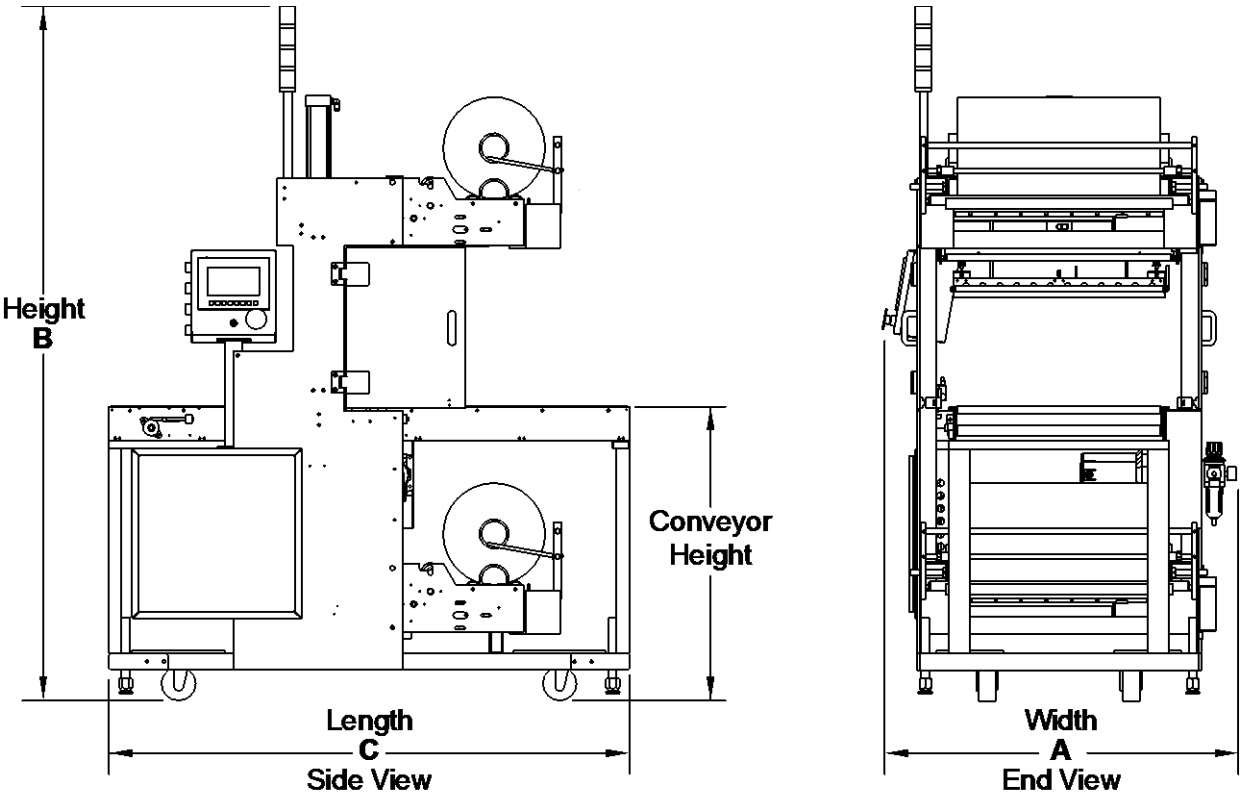
Model Number	Net Weight	Shipping Weight
EB25F-AV1	1300 lbs.	1550 lbs.
EB25F-AV5	1590 kg	1728 kg

Table 5 Voltage and Phase Designator

Voltage / Phase Designator	Volts	Phase
V1	220	1
V5	480	1

Dimensions

See the table on the previous page (Machine Dimensions in the 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 **insist** on an inspection. This is absolutely necessary. A concealed damage report must be made within **five (5)** business 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)** business days 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

- Machine will be fully crated and stretch-film wrapped.
- Metal straps will need to be removed.
- A fork-lift is required for unloading or loading the machine from the truck.
- Tie-downs must be removed from moving parts and secured for shipping purposes.

Installation

Place the bundler in the desired location with the required electrical power source and air 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 clean air and power supply nearby?
2. Where is the automatic bundler in relation to the power source? Source of air at required CFM flow and PSI pressure?
3. Where is the automatic bundler in relation to the bundling tunnel and any conveyor(s) necessary to move product? (Alignment with packaging line.)
4. Convenience for the operator.

Note: **Avoid locating the automatic bundler in a cold or drafty area, as heat may be unintentionally drawn from the sealer and reduce its efficiency.**

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

Location Requirements

When installing the automatic bundler 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 automatic bundler is positioned in the operating location you will need access to the control panel.

Provision should be made for finished exiting packages. For example, a table or bin where packages that have been sealed will be placed until they can be picked up or moved out.

Take into consideration the entrance conveyor height in relation adjacent machinery; that is, machinery feeding into it or receiving bundles from it, such as the bundling tunnel.

The machine should be located on a flat, level floor so that it does not rock or move. We recommend that the leveling feet be used to level the machine.

Set up the automatic bundler 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 floor crane, or fork lift to move it to its location.

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

When the automatic bundler has been moved to its location, block the wheels to prevent rolling while adjusting the leveling legs to raise and level the automatic bundler in its permanent location.

IMPORTANT! Leveling the machine frame before running it is important to allow moving parts to move freely and properly.

A power cord should be installed by a licensed electrician. Connect the air line to the regulator.

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.**
- 5. Air line is connected to the regulator and verify minimum supply of 60 PSI, 3.5 CFM.**

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

Operation

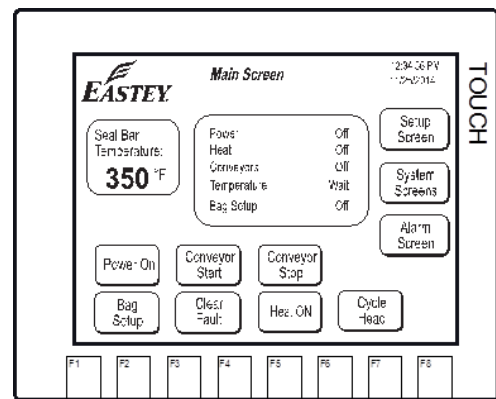
Operation of the automatic bundler is similar to as explained in the User Manual. Controls for the automatic bundler are located along the side of the machine, but layout and arrangement of the machine controls and operator’s panel may differ slightly from the illustration in the User Guide.

Control Panel

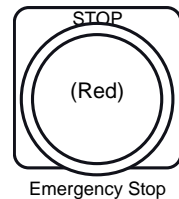
Controls for the automatic bundler are located along the side of the machine.

1. **Operator’s Panel** — The operator’s panel is a fully-functional color touch screen. It displays current status information and displays buttons for configuring and controlling the system.

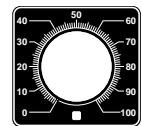
- The Main Screen of the panel interface is shown here.
- Button functions of the Main Screen and Setup Screen are shown and explained on the following pages.



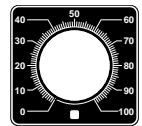
2. **E-Stop** — In the event of an emergency, press in the large, red, mushroom-shaped E-Stop button. This brings the system to a halt and illuminates the red light on the alarm signal light stack. To return the machine back to normal operation, pull the button back out and touch Power On. This starts the system.



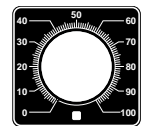
3. **Infeed Conveyor Speed** — Use the “Infeed Conveyor Speed” dial to set the speed of the conveyor that feeds product into the Automatic Bundler. The Infeed Conveyor speed will vary according to the speed of the line feeding product into the Automatic Bundler, as well as the product dimensions and film properties.



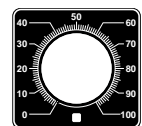
4. **Exit Conveyor Speed** — Use the “Exit Conveyor Speed” dial to set the speed of the conveyor that sends the bagged product out of the exit end. This should be set to the same



5. **Upper Power Film Unwind Speed and Lower Power Film Unwind Speed** — Use the “Upper Power Film Unwind Speed” and “Lower Power Film Unwind Speed” dials to set the speed of the upper and lower film roller unwind.

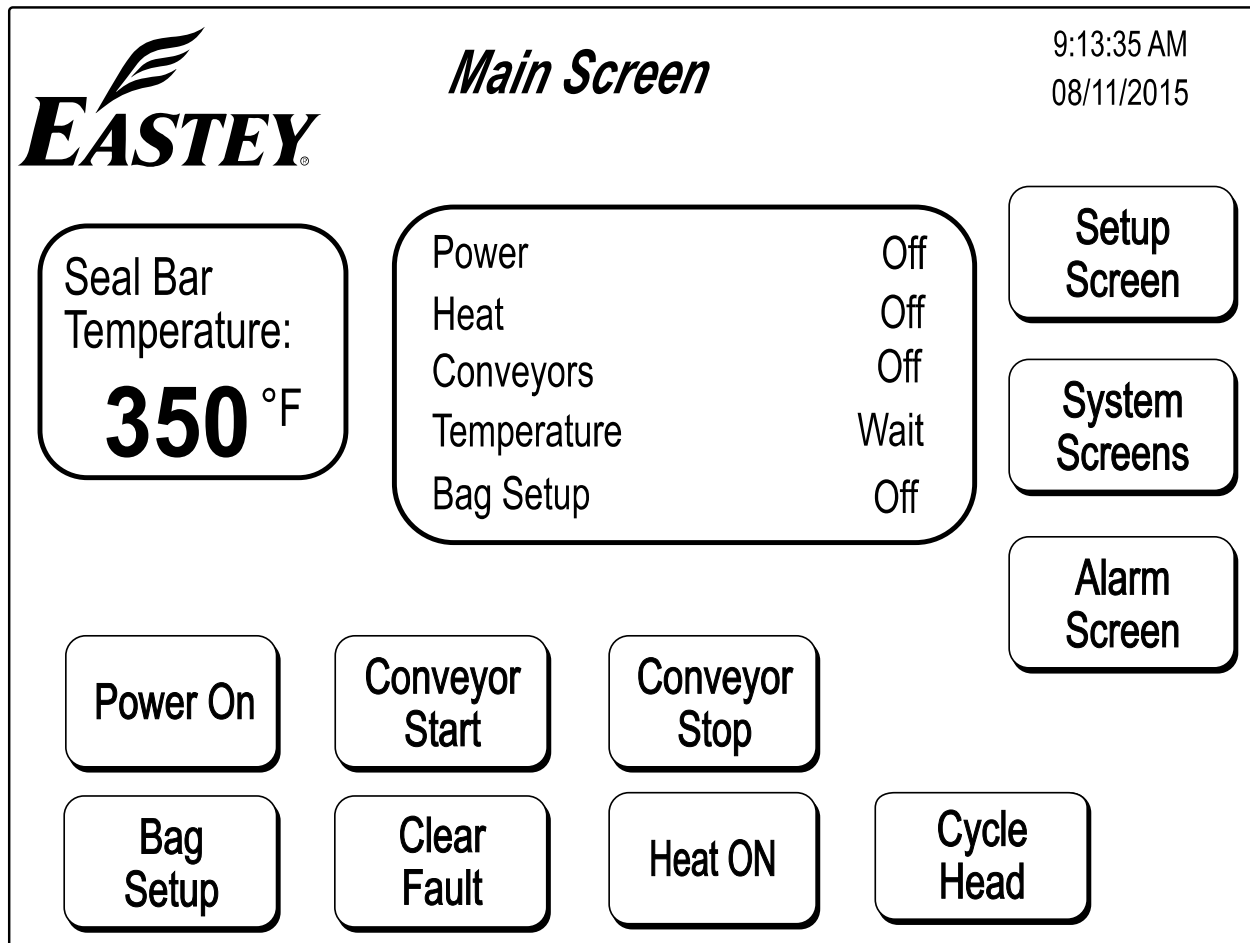


CAUTION! When the power is turned on be aware of sealer hot surfaces and moving belts and rollers.



Familiarize yourself with the automatic bundler controls on initial power up, and pay particular attention to the operator's panel. On the panel screen you can view the current seal bar temperature and status for power on or off, heat on or off, conveyors on or off, temperature ready or wait, and bag setup on or off. Buttons in the right of the screen provide access to additional screens, including the setup screen (which is shown and explained on the following pages). Buttons in the bottom of the Main Screen provide convenient control of the machine functions.

If an alarm message icon appears (a circle with an exclamation mark), touch the alarm icon to display the message. Press Esc or touch the Main Screen button in the lower-right of the Alarm Screen to return to the Main Screen.



Powering Up and Cycling the Sealer

Once the electrician has stated that all electrical work is complete and the air line is connected to the regulator and providing 60 PSI and 3.5 CFM, make sure all shipping ties are removed and all personnel are clear of the equipment, then power up the sealer and run it through a cycle by performing the following.

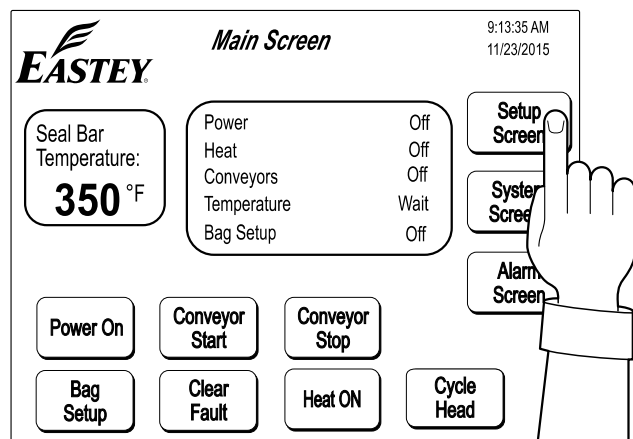
1. Turn the Main Power lever to the On position to turn electrical power on.
2. Pull out the red E-Stop button.
3. Touch the “Power On” button on the operator’s panel.
4. Touch the “Head Cycle” button. The head should complete one cycle.
5. Touch the “Conveyor Start” button. The conveyors will run and this also enables the photo eye.
6. When all of the above options function properly, touch the red “Conveyor Stop” button.

Setting Temperatures and Timers

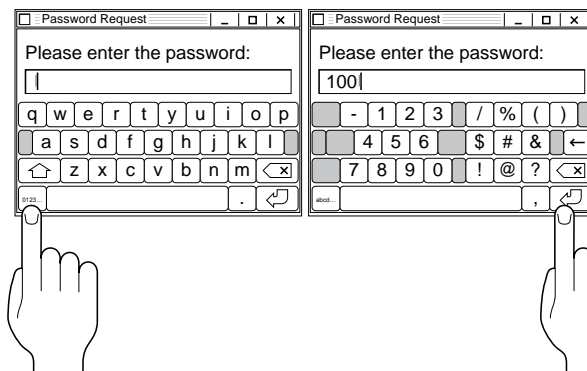
1. Touch the “Setup Screen” button to navigate to the Setup Screen.

A Log On window will appear asking for a user name and password.

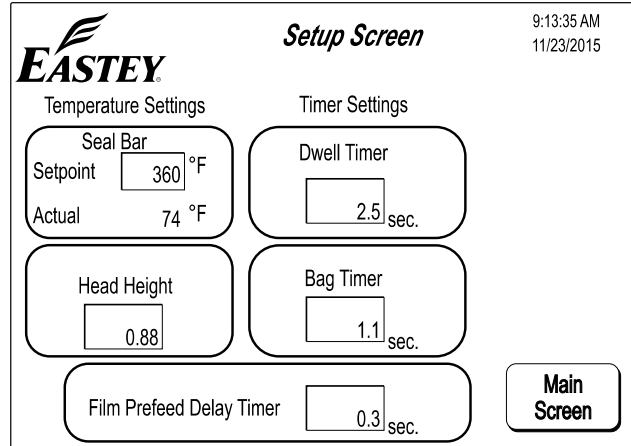
If ADMIN does not appear in the user Log On window, touch the User box. Enter ADMIN using the touchscreen keyboard as shown below, and then touch Enter (↵). Touch the Password window.



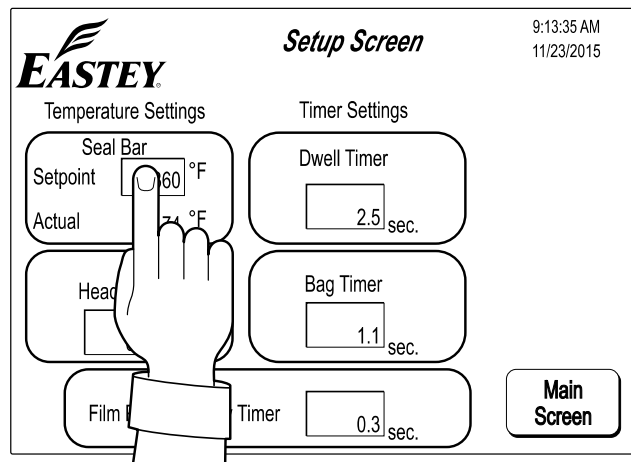
2. A window containing touch-keyboard buttons appears on the Operator’s Panel asking you to enter the Password. Touch the button labeled “1,2,3...” to access the on-screen numeric keypad and type the password (100). Touch the Enter button once you are finished typing the password.



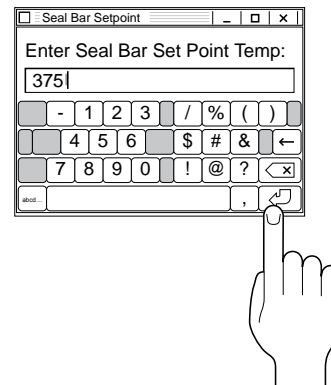
- When you have entered the password successfully, touch the Setup Screen button and the Setup Screen appears.



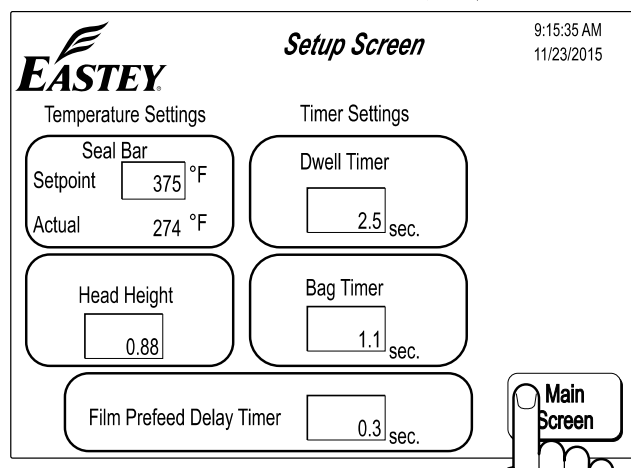
- Touch anywhere inside the rectangle containing the value for the temperature or timer you wish to change.



- The on-screen screen numeric keypad appears. Use the numeric keypad to type the number representing the seal bar temperature setting or number of seconds for timer, and then touch the Enter button to save your setting and close the numeric keypad window.



- To return to the Main Screen from which you can resume normal operation, touch the "Main Screen" button in the lower right of the Setup Screen.



Setup Screen Settings

Seal Bar

Set point — Enter the optimal temperature for sealing and cutting the type of film you are using.

Actual — The actual current temperature of the seal bar is displayed in this area.

In addition to the Seal Bar Temperature Setting, there are four timers: a Dwell Timer, Head Height, Bag Timer, and Film Prefeed Delay Timer.

Explanation of Timers

Dwell Timer — This is how long the seal head stays together. Keep in mind that the timer starts as the seal head solenoid activates and the seal head starts moving down.

Head Height — This too is a timer-based setting. It is how long the solenoid is activated to raise the seal head. Seal head opening height operates on the principle that the seal head opening will open wider if allowed more time, and open narrower if constrained by less time.

- Input a smaller number for shorter-height packages.
- Input a larger number for taller-height packages.

IMPORTANT: When transitioning the machine from a taller-height package (higher head height), to a shorter-height package (lower head height) it will be necessary to first bring the head down from its raised height. To do this, repeatedly touch the Cycle Head button. The seal head will come down gradually.

Bag Timer — This is the length of time after the trailing edge of the product has passed the photo eye before the seal head comes down. The exit conveyor and power film unwinds will continue to run until the seal head starts its downward motion.

Film Prefeed Delay Timer — This is the length of time from when the leading edge of the product blocks the photo eye until the power film unwinds are activated. Generally:

- Set this time shorter for lighter packages to get the film rolling before the package reaches the web of film so the package is not stopped by the stationary film.
- Set this time longer for heavier packages that possess more momentum.

Some experimentation will be required to arrive at the right Film Prefeed Delay, Bag Timer, and Head Height setting required to form the right sized bag for each product.

NOTE: The dwell timer must be a larger value than the head height value to work and seal correctly. Once the seal head comes down and contacts the lower seal pad, press once more to ensure that your settings are set.

Initial Settings

If you have been provided with recommended settings for your application, record these in the spaces provided below for future reference.

Head Temperature	_____	Upper Power Film Unwind	_____
Head Dwell Timer	_____	Lower Power Film Unwind	_____
Bag Length Timer	_____	Tunnel Speed	_____
Film Pre-Feed Delay Timer ...	_____	Tunnel Temperature	_____
In-Feed Conveyor	_____	Velocity Control	_____
Exit Conveyor	_____		
Package Size	_____		

Testing the Bag Length Timer

NOTE: This should be tested with no film!

1. Turn on conveyors and then touch the “Bag Setup” button.
2. Place product onto the infeed conveyor.
3. The Infeed conveyor carries product forward to the seal area.
4. The photo eye detects the edge of the product, which begins the countdown of the Film Prefeed Delay Timer. After the specified delay (or immediately if set to zero) the power film unwind starts.
5. The product moves into the seal area and the conveyor stops. The seal head will not cycle.

Note where the product stops.

- If the product is not under the seal head but fully into the seal area, touch “Bag Setup” and then thread the film.
- If the product is not fully into the seal area, increase the bag length timer and try sending the product through again.

Redo this test until you have the right settings for the product you are running.

6. The conveyor will start up again. Touch the “Conveyor Stop” button to stop the conveyor

Thread the film and run the product. Refer to the following procedure for film threading.

Loading Film

Select the proper width of film for the product being packaged, taking into account the width and height of film required. The sealer operates so both the top and bottom film meet at the bottom of the seal area. (The upper seal head opens upward and closes downward on the lower seal pad, which is stationary or “fixed.”) Minimal film width for top or bottom film can be calculated as the sum of the package width and height and are provided in the following table.

Easteey Sleeve Wrapper Film Width Estimating Table

EB25A

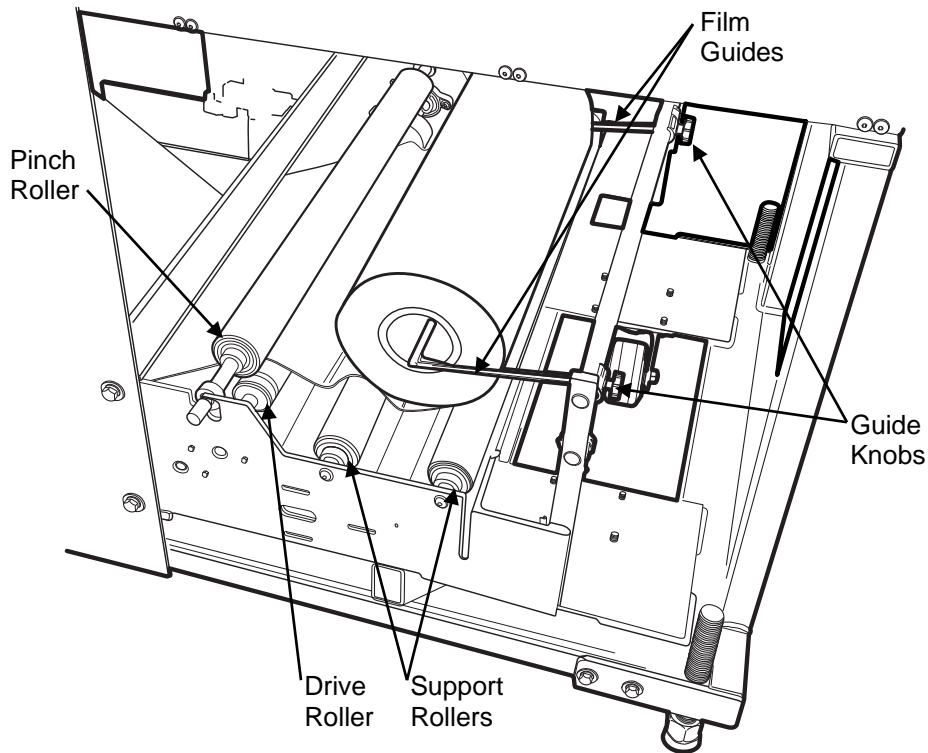
Package Height	12																			24	25					
	11																	22	23	24	25					
	10															20	21	22	23	24	25					
	9													18	19	20	21	22	23	24	25					
	8											16	17	18	19	20	21	22	23	24	25					
	7									14	15	16	17	18	19	20	21	22	23	24	25					
	6							12	13	14	15	16	17	18	19	20	21	22	23	24	25					
	5					10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25					
	4			8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25					
	3		6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25				
	2		4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25		
	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	
		Package Width (In Inches)																								

Maximum Film Width = 25 inches (64 cm).

Depending of the desired bullseye size on side of product, wider film will need to be used.

Before setting the film on the cradle, do the following.

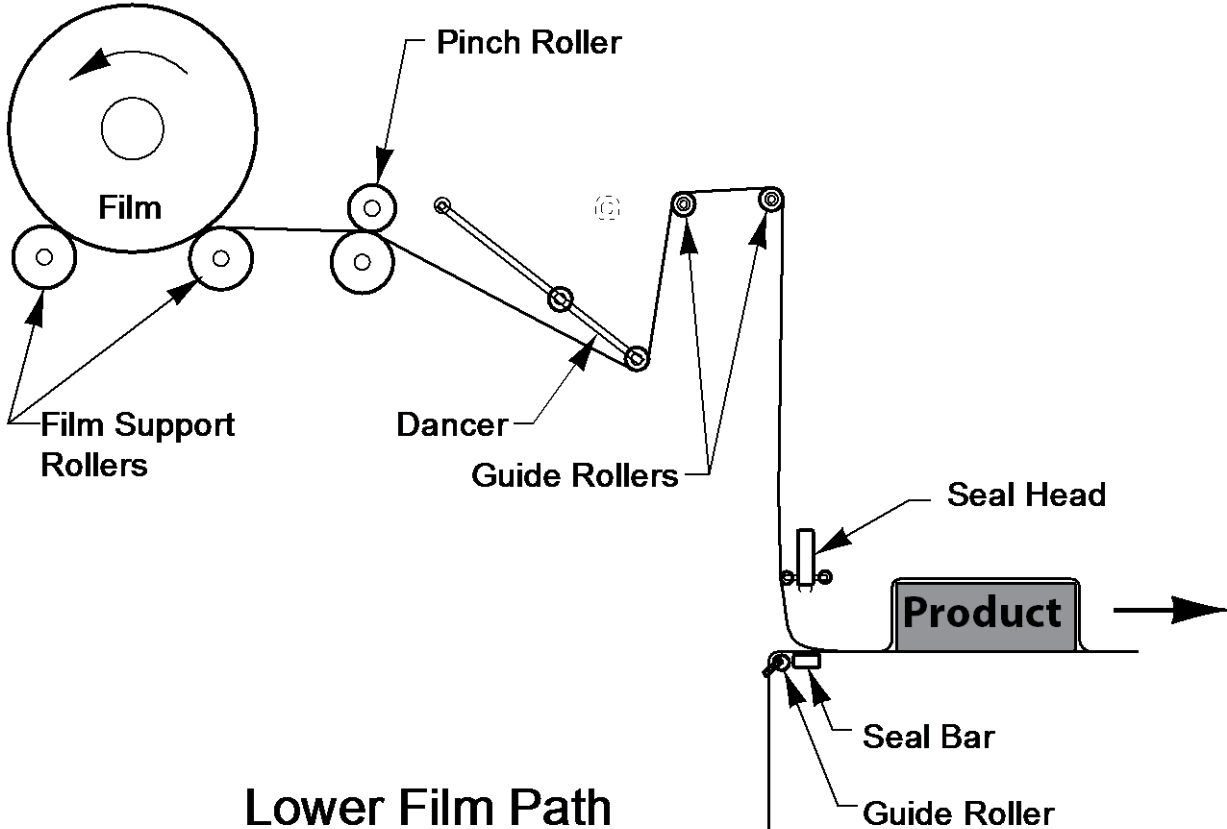
1. Loosen the left and right film guides. Move guides to the outside of the power film unwind rollers, centering the film with the conveyor and support rollers.



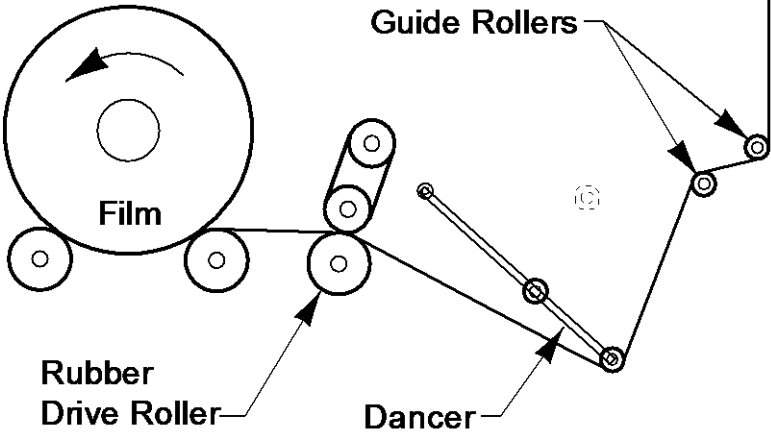
2. Place the film on the support rollers with the film coming off the bottom as shown.
3. Move film guides back into position, close against the roll of film and re-tighten the guide knob.
4. Lift up the pinch roller off of the rubber drive roller.
5. Thread the film according to the standard Film Path Diagram shown on the following page, or optionally according to the Optional Film Path diagram. Use the film path that your Eastey application engineer has specified to work best for you application.
6. Pull the lower film up through the infeed conveyor and lower seal bar areas. Pull it across the lower seal pad and onto the exit conveyor approximately two feet.
7. Pull the upper film down from the top roller to the infeed side of the upper seal head. Pull it under the seal head and onto the exit conveyor approximately two feet to match the lower film.
8. **Very important:** drop the pinch roller back into position. This is a “must do.” This will also assist with threading the film through the dancer bar.

Standard Film Path

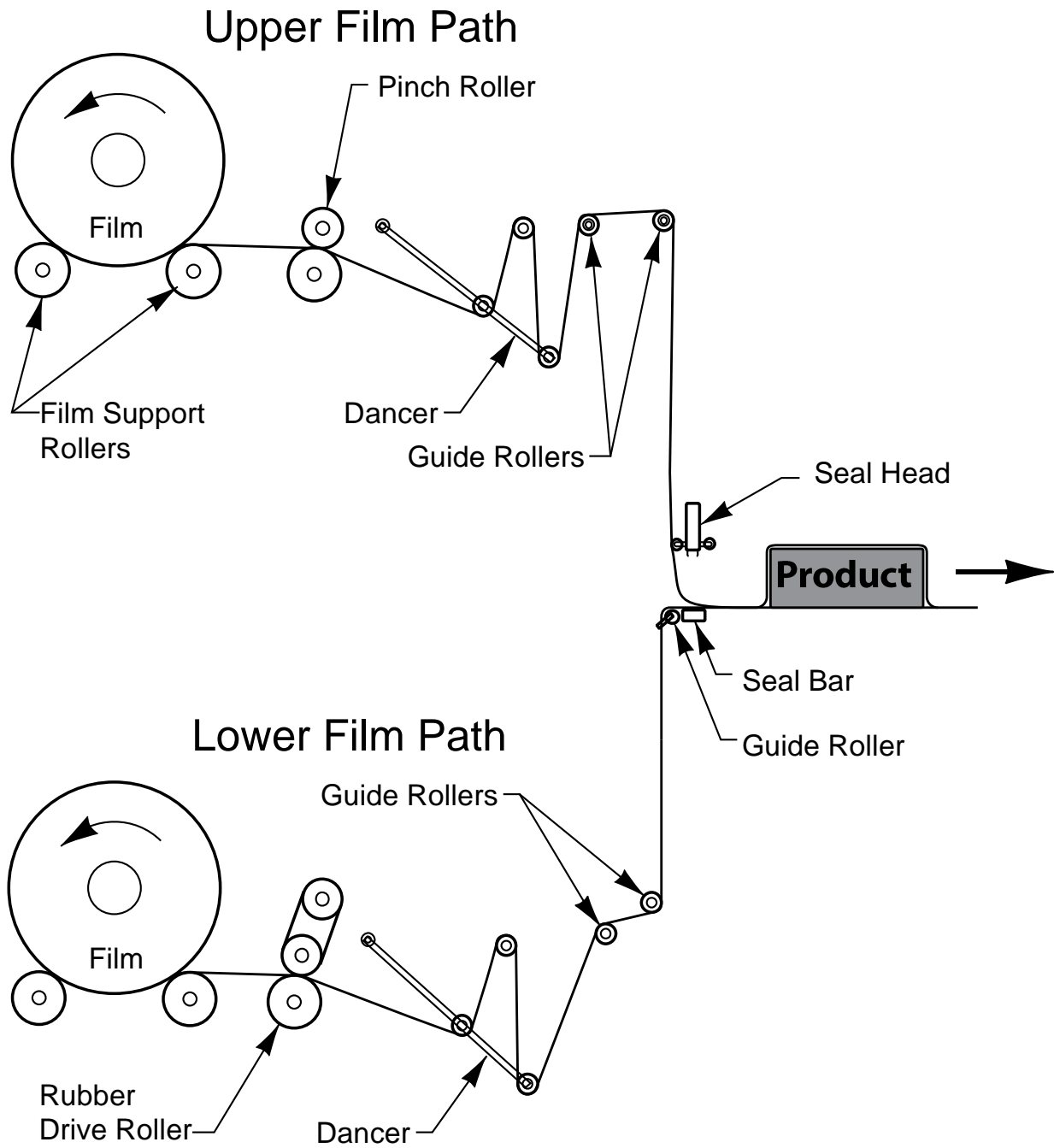
Upper Film Path



Lower Film Path



Optional Film Path



Adjustment for Package Height

Use the Head Height Adjustment setting in the Setup Screen (see Setup Screen Settings) to adjust for package height.

Running Product

1. Turn on system power and push Conveyor Start.
2. Place the product on the infeed conveyor, lining it up with the center of the film roll.
3. Carefully watch the sequence of events as the product goes through the complete cycle of operations, including sealing and shrinking in the tunnel.

NOTE: If you change conveyor speeds, the bag length timer may need to be adjusted.

Running One Product at a Time (Optional)

1. Place the product on the infeed conveyor, lining it up with the center of the film roll.
2. Push the green palm button on the infeed conveyor.
3. Carefully watch the sequence of operations as the product goes through the complete cycle of operations, including sealing.
4. After product is sealed, both conveyors will remain off until the green button is pressed again or the “Conveyor Start” button is touched on the operator’s panel.

Product Indexing

This equipment has product indexing. There must be a gap in between packages. If a package is being sealed and the photo eye senses a package, the infeed conveyor will stop. As soon as the seal head starts to open, the infeed conveyor starts. The eye is adjustable and needs to be pointed away from the seal bar to ensure the package on the infeed does not run into the seal bar while opening. Placing packages too closely, with no gap between, could result in more than one package inside a single bag.

IMPORTANT: If items are spaced too closely together, the seal head may come down prematurely and crush product as it moves across the seal bar.

Adjustments

Fine Tuning the Sealer

To achieve maximum efficiency, individual controls can be tuned to improve productivity. Here are some helpful hints.

1. Shorten dwell time as much as possible without jeopardizing the seal's integrity. This will minimize cycle time and increase products-per-minute output.
2. Lower the seal head to the point where it will clear the product only by a very minimal distance. This will reduce cycle time also and increase output.
3. Reduce the bag-length at the end of the product as much as possible without jeopardizing the integrity of the seals. To do this, decrease the time on the bag-length timer as much as possible while still clearing the product with the seal head. This will save cost of film and also reduce the amount of time that the product will need to heat in the tunnel.
4. Determine the tunnel settings necessary to get the most desirable package. The tunnel conveyor speed is at or slightly slower than the speed you should set the seal conveyors. The closer the speed of the tunnel conveyor to the speed of the sealer's exit conveyor, the smoother your operation will run.

Seal Head Speed Adjustment

1. Increasing or decreasing pressure by adjusting the pressure regulator will speed up or slow down movement of the seal head.
2. There are two mufflers on the exhaust ports of the seal head control valve. (These mufflers help decrease the air noise out of the exhaust port.) Speed of the seal head can also be increased or decreased by adjusting these exhaust port mufflers in or out to change the speed of air being discharged.

NOTE: Tighten the jam nut against each exhaust port muffler to secure it in position.

Seal Head Pressure Adjustment

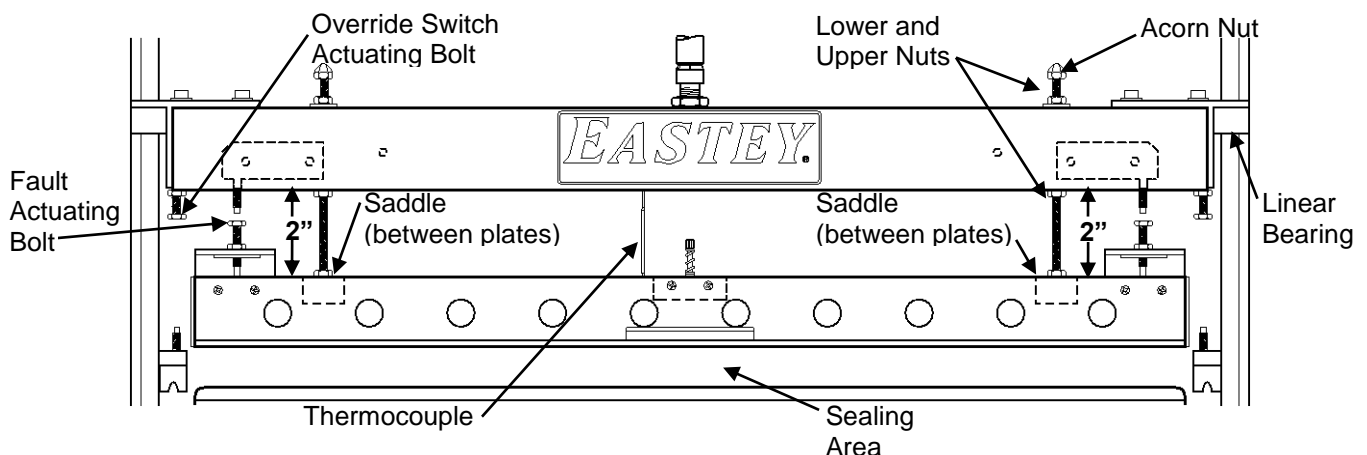
Uniform pressure between the seal head inserts and the sealing pads must always be maintained for proper sealing and uniformity, and to prevent weak seals. This adjustment should be checked periodical and should always be checked when sealing gaps occur. Proceed as follows.

1. Keep power on for this procedure.
2. Adjust the seal head pressure.

NOTE: If the machine has been in operation for some time, check lower seal pad materials and replace as necessary before making any pressure adjustments.

3. Check the air supply to ensure minimum of 60 PSI.
4. With a piece of paper between the upper seal head and stationary lower seal bars, cycle the seal head. Check with paper all the way across the seal head. Check the impression on the paper to make sure there is even pressure across the seal head.

NOTE: From the cross bar to the top of the saddle (next to the 5/16 inch nut) is approximately 2 inches in height. (This is a good starting point.)



5. If the film pressure is unequal, loosen the upper and lower nuts holding the seal bar saddle in place only in areas where pressure is unequal.

NOTE: The acorn nuts capping the ends of the adjustment bolts must be removed temporarily while making this adjustment. Re-install acorn nuts when finished.

NOTE: One full turn of a nut moves it approximately 1/16 of an inch.

NOTE: If adjustment is needed, see the procedure for **Setting the Head Fault Switches**, which follows.

CAUTION: Do not pinch any of the wires behind the guard and seal head while making adjustments.

Setting the Head Fault Switches

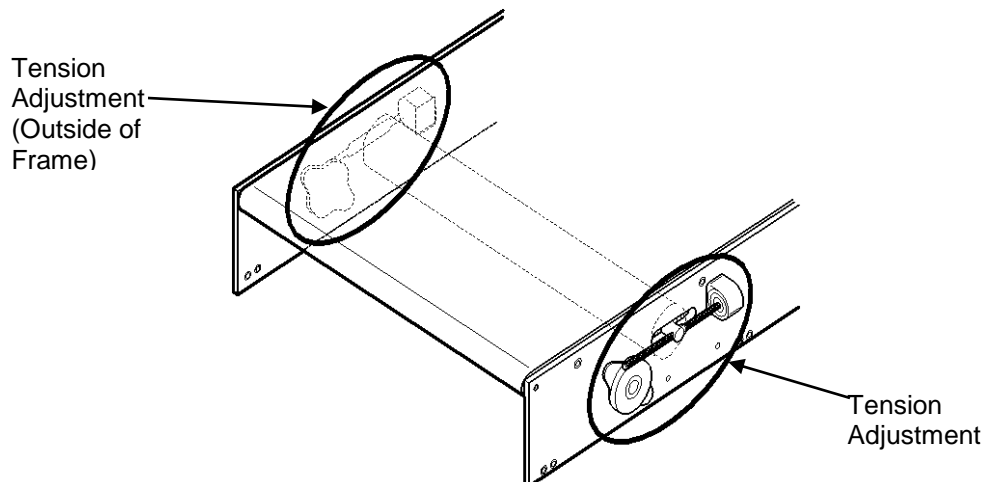
NOTE: These switches are factory set and should not be adjusted.

The head fault switches are mounted on top of the seal head crossover bar. Notice that with this model, there are also switches mounted to the left and right of the sealing area. The purpose of these and the head fault switches is to retract the seal head from its downward motion if it comes into contact with an object.

The head fault switches work in conjunction with the override switch. When the head is approximately $\frac{1}{4}$ inch from the lower seal pad, the override switch is activated. At this point, the head fault will no longer work. For this reason, the override fault limit switch must not be moved from its position preset at the factory.

Conveyor Tension Adjustment and Tracking Adjustment

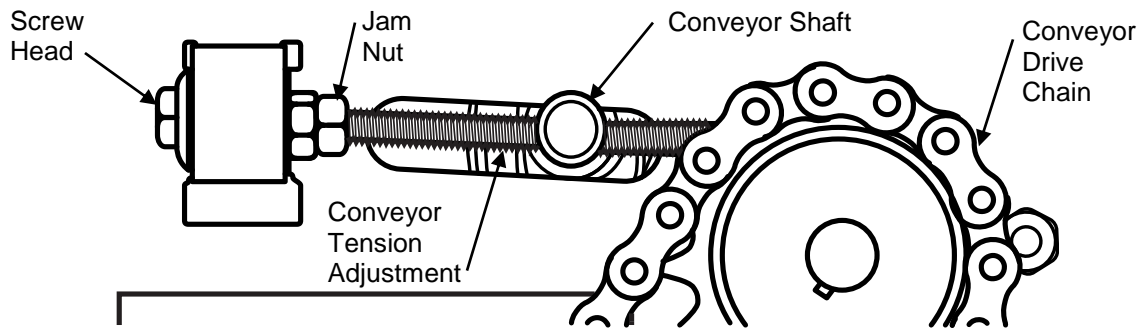
Shut off power and disconnect electrical connections before making any adjustments. Adjustment of conveyor tension is made by tightening or loosening the conveyor tension adjustment screws. There is a tension adjustment screws on each side of the conveyor at the right and left ends of the idler shaft. Jam nuts secure the tension adjustment.



Ideally the conveyor shaft should be adjusted so that when correct tension is achieved, the shaft is near the center of adjustment slot. Before beginning adjustment, measure these distances to place the conveyor shaft near the center of adjustment.

Note: It is necessary to run the conveyor to verify that it is tracking correctly and not pulling to either side and wearing against the side frame. Make small adjustments, one at a time on each side, until proper belt tension is achieved and belt is tracking properly.

1. Loosen the jam nuts on the adjustment screw near the fixed block.



2. Use a wrench on the screw head to adjust tension.
 - Turn the adjustment screw counterclockwise to loosen tension.
 - Turn the adjustment screw clockwise to increase tension.
3. When the conveyor tension is correctly adjusted, re-tighten the jam nuts.

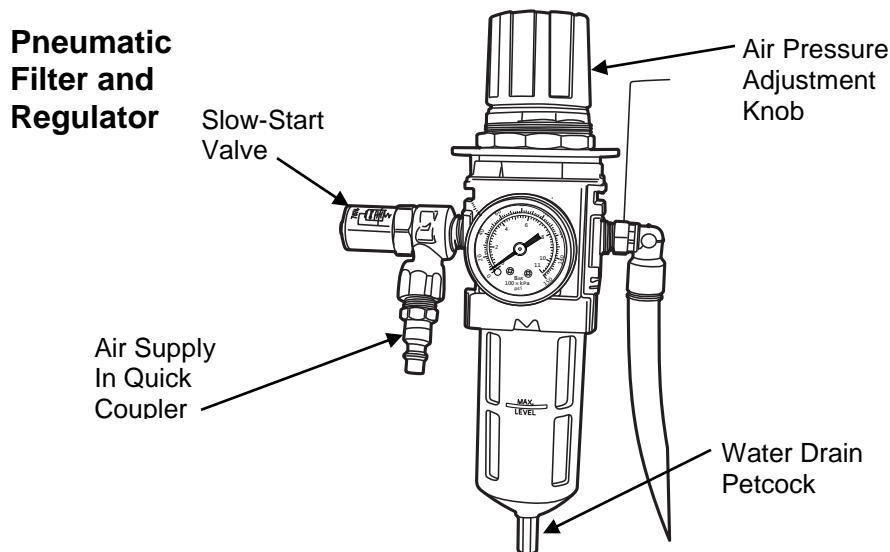
Maintenance

Weekly or Monthly Maintenance

- ❑ **Chains:** Conveyor drive chains must be oiled every month. The power film unwinds are also chain driven and these chains must be oiled monthly as well.
- ❑ **Linear Bearings:** There are two (2) linear bearings, one at each end of the seal head that slide on linear shafts. Every month apply a lightweight oil on these shafts to keep the bearings moving freely.
- ❑ **Seal Head:** After a while, film may begin to build up on the seal head. With the seal head up to temperature, remove this buildup by wiping the seal head with a clean rag. How often this needs to be done depends on how much the machine is used. Check this every shift or possibly more often if the need arises. Indications that the seal head is accumulating film buildup include poor seals with weak or unsealed spots.

CAUTION: Never clean with any abrasive. This could cause damage to the coated blade and insert.

- ❑ **Pneumatic Filter and Regulator:** Periodically drain any water accumulation in the filter and regulator. Open the petcock on the bottom of the filter to drain out all water that has accumulated in the filter bowl, and then close the petcock when finished.



- ❑ **Lower Seal Pad:** Periodically check lower seal pad integrity. Refer to page 33 for replacement.
- ❑ **Conveyor Tension:** Check the belt tension of the conveyor occasionally to ensure that it is not excessive, as this will cause unnecessary wear.

Preventative Maintenance for Conveyor Belts

Conveyor belts typically do not require day-to-day maintenance and are generally trouble-free when installed and operated properly.

Following are a few recommendations to obtain maximum life of the belt and avoid down-time.

- Check belt tension on a routine basis (weekly or monthly) to ensure proper drive. Adjust screw take-up if necessary. (Belts experience thermal expansion while hot.)
- Sprocket alignment should be checked before installing a new belt to ensure that all the teeth are aligned. (A misaligned sprocket can cause undue wear on the drive chain.) It is good practice to check the keyways and tighten keyway setscrews when required.
- Belts normally wear through daily use and at some point will need to be replaced. If the belt begins to fray or wear excessively, it is important to find the cause and correct it as soon as possible. Failure to do so could incur further damage to the belt and premature wear or breaking. If replacing a belt that wore out prematurely, try to determine and remedy the cause before restarting with a new belt.

CAUTION: Disconnect main power source before performing any procedure to replace any conveyor component(s).

Replacing Power Film Unwind Components

CAUTION: Disconnect main power source before performing any procedure to replace any conveyor component(s).

Rubber Drive Roller Replacement

1. Disconnect electrical power.
2. Lift pinch roller and move it out horizontally.

CAUTION: The Pinch roller is heavy. Be careful and do not drop it.

3. Remove the chain guard by the motor.
4. Loosen four motor bolts and slide the motor upward while removing it from the chain.

NOTE: At this point, if the motor needs replacement, disconnect electrical wires, remove the four (4) 5/16-18 bolts to remove the motor.

5. Remove the 5/16 inch bearing bolts off both ends and lift rubber drive roller from machine.
6. Loosen two (2) set screws on bearings and remove them from the shaft.
7. Loosen two (2) set screws on sprocket and remove it from the shaft.
8. Loosen the set screws on the rubber drive roller on both ends.
9. Remove shaft out of old roller and slide shaft into new replacement roller.
10. Work backwards through the above steps for reassembly.

Lower Seal Pad Replacement

Occasionally it will be necessary to replace the sponge rubber on the lower seal bar. These should be replaced if the following are noted:

- Gaps in the seal.
- Weak seals.
- Improper film cutoff.
- Visibly damaged pad

To replace pads, do the following:

1. Leave the seal head at the highest position.
2. Disconnect electrical power.
3. Seal pads are designed with a channel for easy replacement.
 - a. Pull the sponge rubber out of the channel and replace with a new replacement pad.
 - b. Press the new pad into the channel.
 - c. Trim the length of the new pad if necessary.

NOTE: If sponge-rubber is covered with talcum powder, clean the exterior with a rag.

NOTE: When replacing sponge rubber, press it in to the channel from side to side, taking care so as not to stretch the material.

Replacing Thermocouple

1. Shut the machine down and disconnect main electrical power.
2. Temporarily remove the guard from the seal head and set aside.
3. Unscrew thermocouple from the top of the seal bar.
4. Screw in the new thermocouple and thread the wires from the thermocouple through the wire harness to the terminal strip.
5. Noting the color and position of each of the wires, unscrew the two thermocouple wires from the terminal strip. Connect the new thermocouple wires to the terminal strip so wire colors are in the same locations. The thermocouple has polarity: positive (+) and negative (-). Retighten terminal strip screws to secure wires.
6. Remove the old thermocouple, carefully pulling wires from the wire harness, and reinstall the seal head guard.

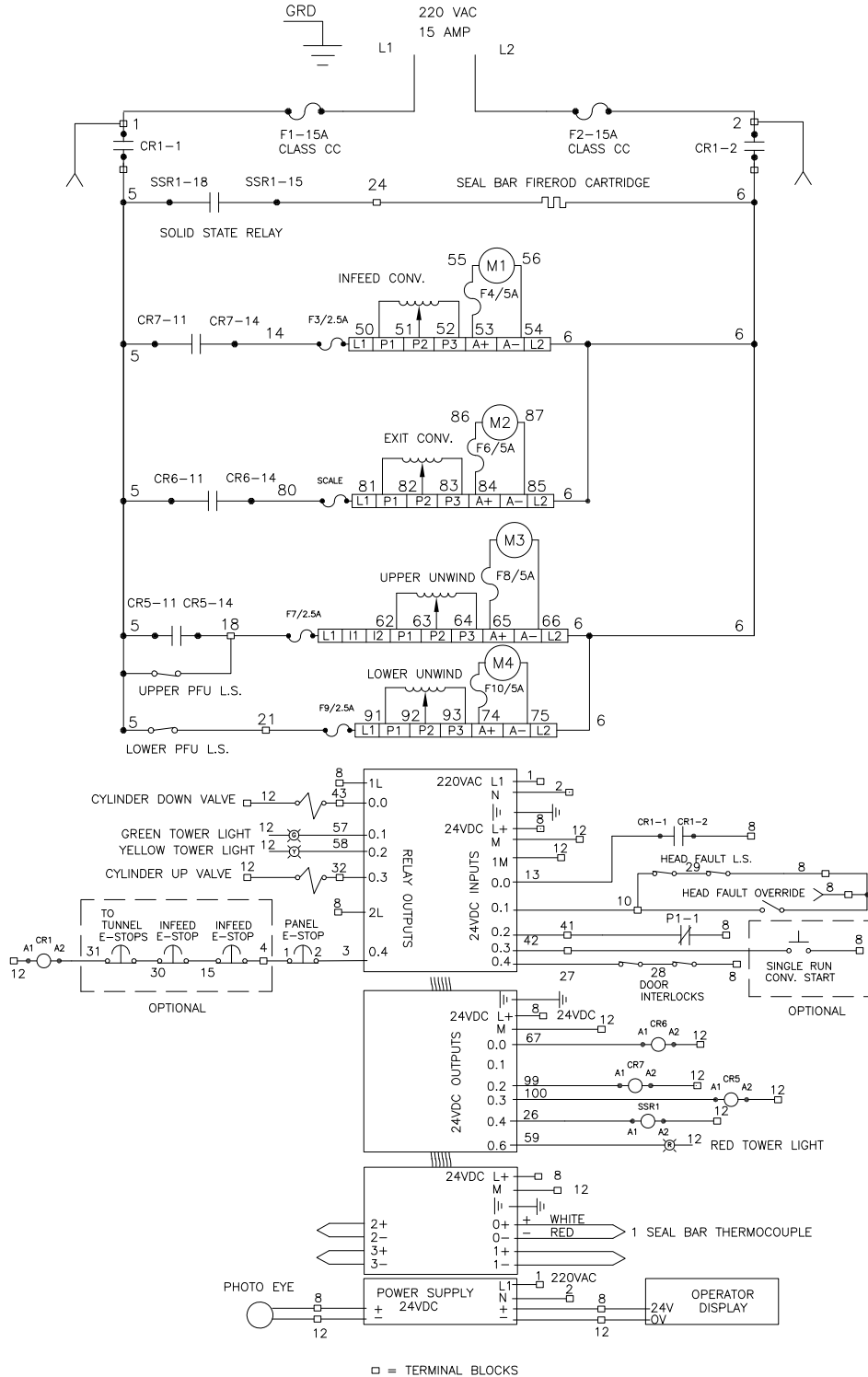
Parts List

EB25F-AV1 / EB25F-AV5 Replacement Parts Reference

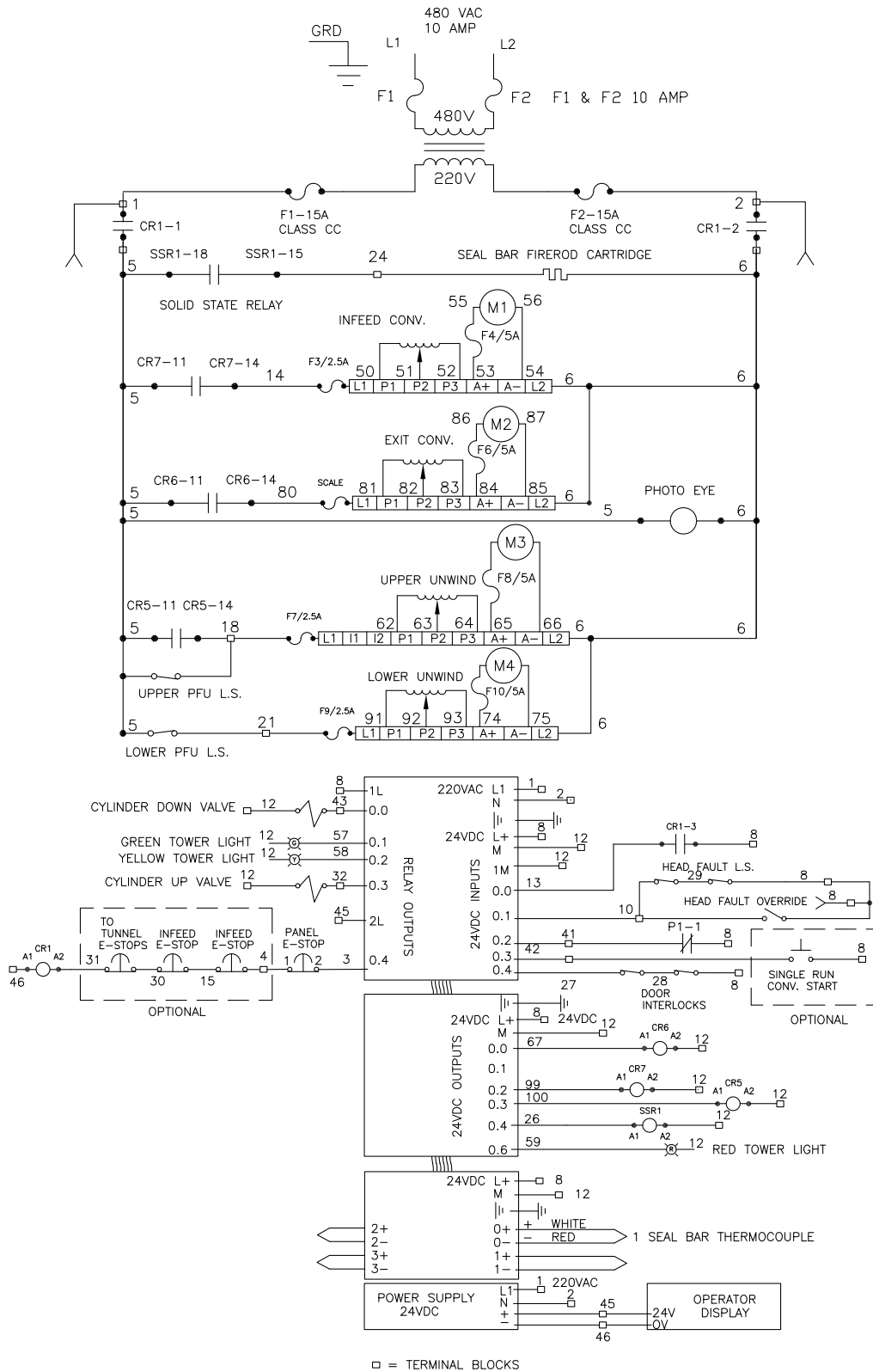
PART NO.	DESCRIPTION
EAST0209	SPONGE RUBBER 1/4" X 3/4"
EBM00520	SPEED CONTROL MUFFLER 1/8" NPT
BF000511	DOUBLE SOLENOID,3 POS. CLOSED
EBM00506	AIR CYLINDER 2 1/2 X 12 1/2"
EP000560	SWITCH/LIMIT DWELL/SAFETY
ESC00636	PHOTO SENSOR
ETC00185	MOTOR CONVEYOR DRIVE 1/8
EBM00500	INFEED CONVEYOR BELT
EBM00501	EXIT CONVEYOR BELT
EP000561	SWITCH / LIMIT PFU
EAST0029	SWITCH LIMIT (MICRO)
ES250053	MACH-HOT KNIFE MUSHROOM INSERT
ES250054	MACH-HOT KNIFE CUTTING RULE 25
EP000535	THERMOCOUPLE HOT KNIFE
ESC00578	FIREROD CART 220V 25"
SUB01055	KIT-25" HOT KNIFE SEAL BAR
EAST0315	DC BOARD W/DC DIAL SPEED CNTL
ET000185	FUSE 2.5 AMP CERAMIC
ET000186	FUSE 5 AMP CERAMIC PFU
ESC00071	DC MTR CNTRL RESISTOR .05
ET000081	DC MTR CNTRL RESISTOR .1
BF000528	MAIN DISCONNECT
BF000531	CONTACTOR
ETC00128	15 AMP 600 V MGIT FUSE
VSA00047	SWITCH-DOOR INTERLOCK SAFETY

Appendix A: Electrical Schematics

EB25F-AV1



EB25F-AV5



Warranty Statement

EB25F Automatic Bundling Professional Series

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/gear motor(s):	1 year
Photo Eye:	1 year
Conveyor Belt	30 days

The following parts are considered to be consumable items and not under warranty: fuses, ¼" x ¾" sponge rubber, seal head insert and cutting rule, 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, Eastey 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.



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