

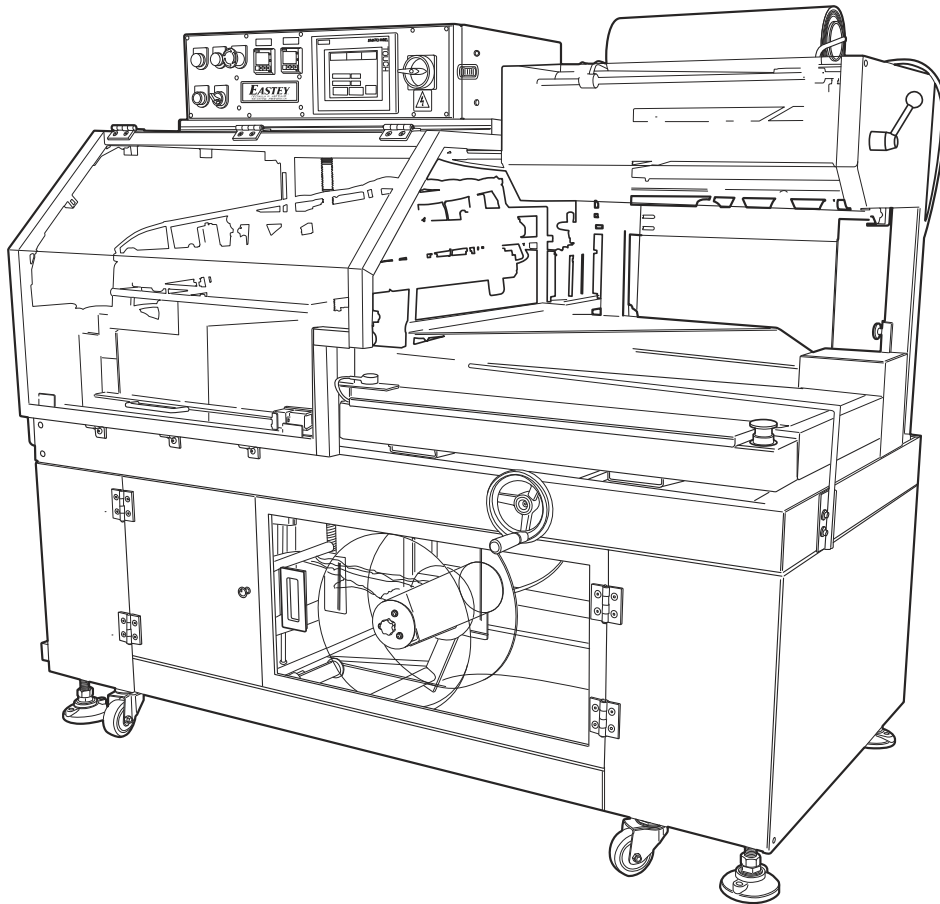
# VSA

# VSA1721TK-V1

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**Value Series  
Auto L-Sealers**

## **User Guide**



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**EASTEY**<sup>®</sup>



# VSA

# VSA1721TK-V1

## Value Series Auto L-Sealers

## User Guide

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P/N VSA01000 Rev. C1

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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](http://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. Proper installation, safe operation, and regular maintenance and upkeep are of far greater importance than our design. Only properly-trained individuals following rigidly enforced safety rules, as recommended by ANSI and OSHA should be allowed to operate these machines.

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

## General Safety Precautions

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

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

- Heat sealing arms and jaws on packaging machinery can become very hot after a period of use. Keep hands away while in operation and use caution if the machine has been running recently.
- 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.



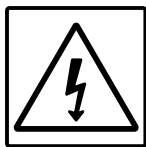
## Explanation of Symbols



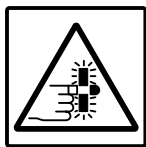
Caution sign or Safety Alert symbol. Indicates caution, be alert, Your safety is involved. Knowledge of safe operation is required.



Ground symbol. Indicates ground. Use Class-3 (lower than 1000) 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.



Cut or shear hazard. Do not place your hands or any object on the sealing or cutting zone at any time. Shut down the machine before performing maintenance, parts replacement, or troubleshooting in these zones.



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



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



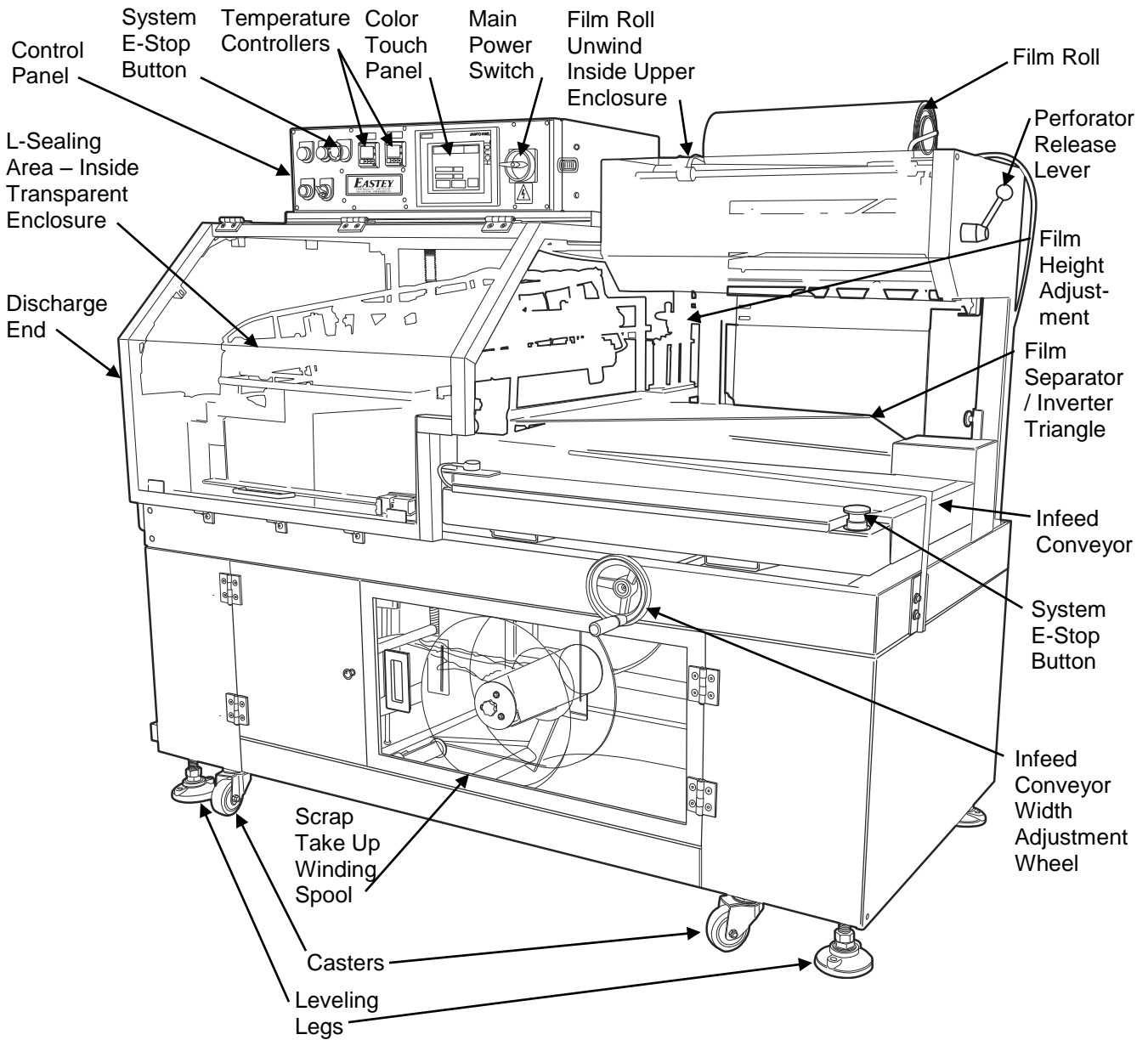
High temperature hazard. Do not touch or place hands close to the heating source to avoid burns. Proceed with any maintenance only when the temperature of the heater or other heat source has cooled down to room temperature.



Moisture hazard. Keep equipment dry. This equipment is designed for indoor operation in a typical clean, dry factory environment, protected from rain and moisture. Connect to a dry air supply (no air oiler). Do not operate the machine in any extremely wet or oily environment that may exceed operating specifications.

# Introduction

## General System Description



## Specifications

| Model Number  | Seal Dimensions |                 | Machine Dimensions |                  |                  | Standard Power |      |       | Net                  | Shipping             |
|---------------|-----------------|-----------------|--------------------|------------------|------------------|----------------|------|-------|----------------------|----------------------|
|               | Front (F)       | Side (S)        | Width (A)          | Height (B)       | Length (C)       | Volts          | Amps | Phase | Weight               | Weight               |
| VSA1721-TK-V1 | 17 in.<br>43 cm | 21 in.<br>53 cm | 45 in.<br>114 cm   | 58 in.<br>147 cm | 72 in.<br>182 cm | 220            | 10   | 1     | 1000 lbs.<br>453 kg. | 1100 lbs.<br>498 kg. |

## Explanation of Model Numbers

- VSA = Value Series Automated Eastey L-sealer.
- 17 — First two digits indicate length of sidebar or nominal maximum length of side seal in inches: 17 inches.
- 21 — Remaining two digits indicate length of front bar or nominal maximum length of front seal in inches: 21 inches.
- T = Takeaway conveyor — Value Series L-Sealers are typically equipped with a takeaway conveyor.
- K = Knife — Indicates hot knife seal bar. The hot knife seal bar is standard.
- V1 = Voltage and Phase. V1 = 220 VAC single phase. The VSA1721TK-V1 is configured for 220 VAC, single phase standard.

### Voltage and Phase Designator Meaning

| Voltage / Phase Designator | Volts | Phase |
|----------------------------|-------|-------|
| V1                         | 220   | 1     |

## Standard features

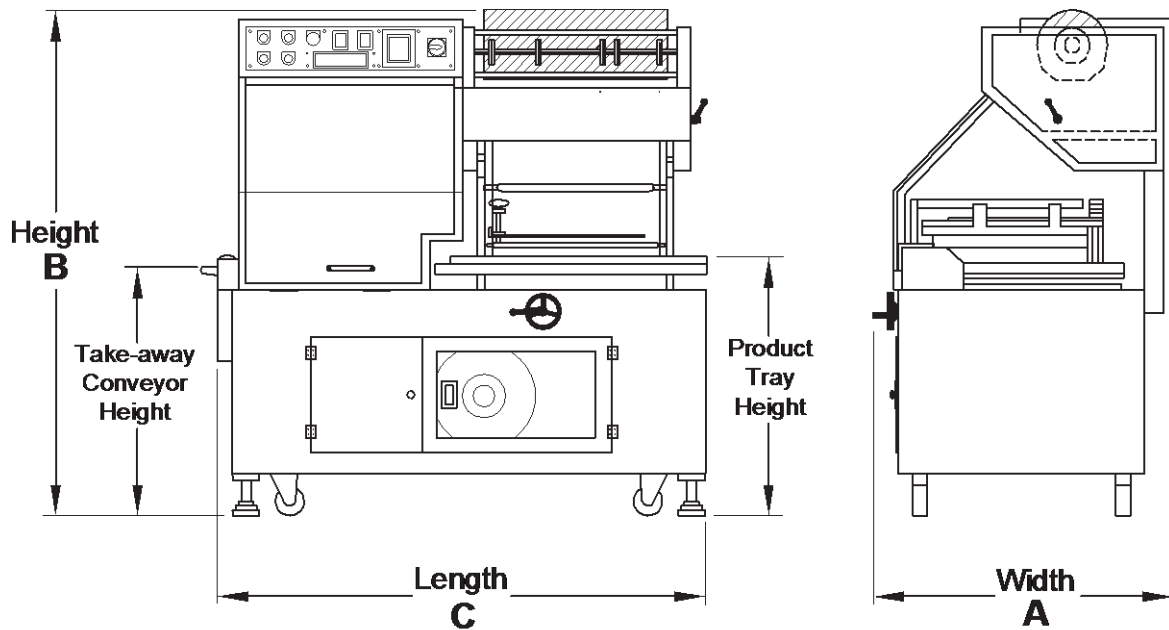
- Designed to seal most polyolefin, polyethylene, and PVC shrink films
- All-welded main frame from 12 g steel
- Normal speed infeed and outfeed conveyors
- High speed with product indexing
- Motorized seal height adjustment for various product sizes
- Seal head equipped with pneumatic air cylinder for automatic sealing
- Hot knife seal bar for consistent and clean seal
- Consistent pressure across seal bar
- Automatic cycle timing with adjustable dwell time
- HMI controller is a color touch-sensitive screen with simple menus for easy operation
- Film tracking wheels keep film in place
- Multiple pin perforator provides precise air evacuation
- Heavy duty casters for transportation within plant
- Leveling legs provide a sturdy base once in place

- 17"W x 21"L seal area
- Scrap unwind automatically wraps up the scrap film left from the sealer
- Easy to use design requires minimal training and maintenance
- Maximum film width up to 22"
- Maximum film roll O.D. up to 12"
- 80 PSI
- Available in 220 V

## Dimensions

See Machine Dimensions in Specifications table on page 10 for overall machine width, height, and length.

### VSA1721



# Unpacking

Thoroughly inspect the equipment and packaging immediately on arrival.

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

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

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

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

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

## Loading and Unloading Instructions

- The machine is fully crated on pallets.
- Use a forklift with adequate capacity to lift the machine from the pallet.  
(Forklift extensions may be required to repack equipment.)

# Installation

Lift the machine up and off of the shipping pallet.

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

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

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

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

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

## Location Requirements

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

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

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

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

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

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

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

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

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

When the L-sealer has been moved to its location, block the wheels to prevent rolling while adjusting the leveling legs to raise and level the machine in its permanent location. A power cord (with optional electrical plug) should be installed by a licensed electrician. Connect the air line to the regulator.

**CAUTION! Before operating, ensure the following.**

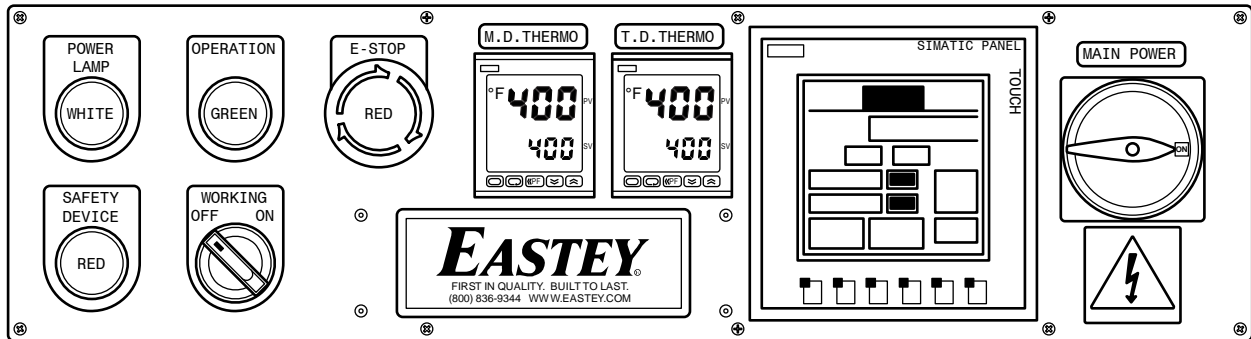
- 1. All shipping ties are removed.**
- 2. All personnel are clear of the equipment.**
- 3. Electrician has stated that all electrical work is complete.**
- 4. Adjust all controls according to the settings sheet.**

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

# Operation

Controls for the L-Sealer are located in the Control Panel box above the sealing area.

## Control Panel



Controls are arranged along the front side of the Control Panel. Controls are listed and explained below, beginning at the left and continuing to the right.

**Power Lamp** — Indicates power and is illuminated when power is on. Indicates whether machine is connected to power and the Main Power switch at far right of the panel is turned to the On position.

**Safety Device** — Indicates when any safety shield guard door or scrap takeup spool door is open or if seal head safety limit switches have been activated. This light blinks red when any of these conditions occur. To return the button to non-blinking state, remove the cause of the safety fault and then press the button to shut it off.

**Operation** — Green light indicates the machine is powered on and ready for operation or operating. Use the Working Switch as described below to start or stop automatic operation.

**Working Switch (Off / On)** — Switch is used with the green Operation button to start running automatically. To start automatic operation, turn this switch to the On position and press the green Operation button.

**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 in a way to avoid damage or excessive film waste. In addition to the E-Stop on the Control Panel, there is also an E-Stop at the outer corner of the machine at the Infeed End of the machine. To return the machine back to normal operation, turn the activated E-Stop so both E-Stops are out, and then turn the Working Switch to the On Position and press the green Operation button.



**M.D. Thermo** — Temperature controller for the L-Sealer heat element that is aligned with the Machine Direction (M.D.). More specific information about setting the M.D. temperature controller is provided in the pages following explanation of use of the Operator's Panel.

**T.D. Thermo** — Temperature controller for the L-Sealer heat element that is aligned cross-wise or **transverse to** the Machine Direction. More specific information about setting the T.D. temperature controller is provided in the pages following explanation of use of the Operator's Panel.

**Operator's Panel** — The operator's panel is a fully functional color touch screen. A technical name used for this is the Human Machine Interface (HMI). It displays current status information and displays buttons for configuring and controlling the system and obtaining system messages and status information. More detail about using the Operator's Panel is explained in the following pages.

**Main Power Switch** — Use to turn main power to the automatic L-Sealer on or off.

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

## **Other Control Features**

**Film Unwinder** — The film unwinder is inside the upper transparent enclosure located to the right of the Control Panel and above the product infeed conveyor and film separation/inversion area.

**Pin Perforator** — The pin perforator is located inside the same enclosure with the Film Unwind. The Pin Perforator is synchronized with the film during normal operation. It creates holes in the film (to allow air to escape during shrinking). The lever on the outside of the enclosure at the infeed end is the Perforator Release Lever.

**Perforator Release Lever** — The Perforator Release Lever allows the perforator to be disengaged temporarily when necessary, to allow the film to be threaded.

**Infeed Conveyor** — The infeed conveyor is used facilitate insertion of the product between the bottom and top layers of film and transport the product into the seal area.

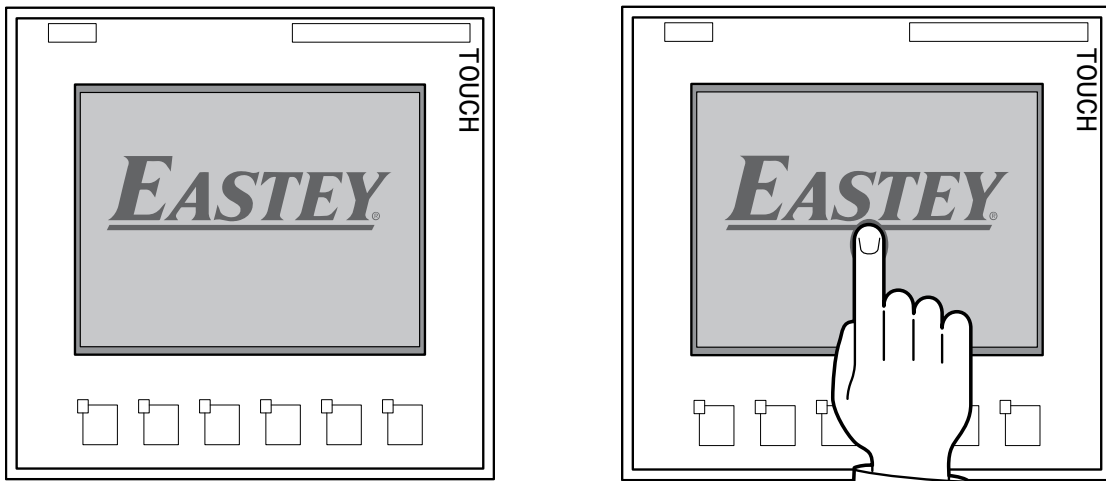
**Width and Height Adjustment** — The infeed conveyor is adjustable for width to achieve proper placement of the total width of the package, thereby allowing the product to be placed precisely in the seal area and film each time. Infeed film height adjustment allows the height of upper film inverter triangle to be changed for differing heights of product.

## Operator's Panel

As the machine starts up, it will display information on the Operator's Panel such as the current operating system version and will display a graphical progress indicator as the operating system software is loaded. The Operator's Panel screen may appear blank momentarily and then eventually display the Eastey company name.

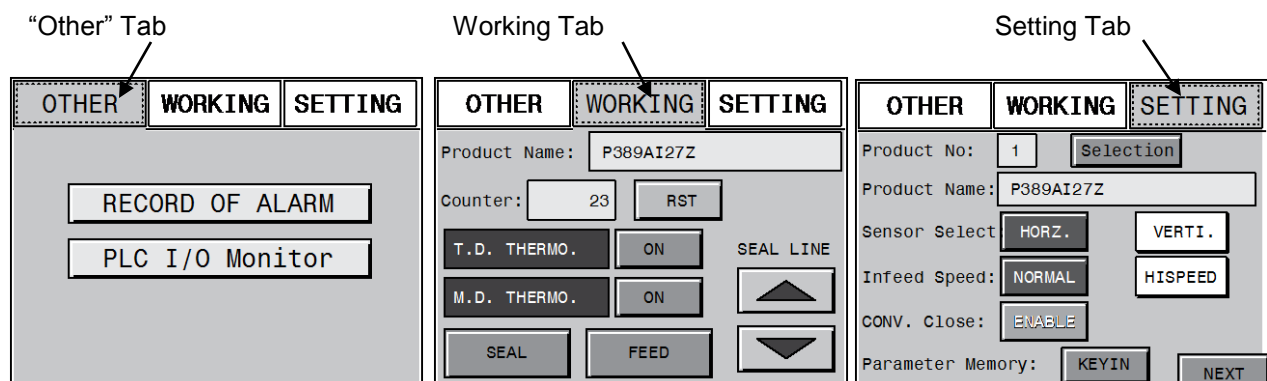
When the Operator's Panel displays the Eastey company name, touch the screen anywhere within the large rectangle with your finger.

**Note:** The sensitivity of the screen is such that your finger needs to be in contact with the screen for a fraction of a second longer than just a quick tap. If you tap the screen too quickly, the touch screen sensor may not sense or respond to it.



## Using the Touch Panel Interface

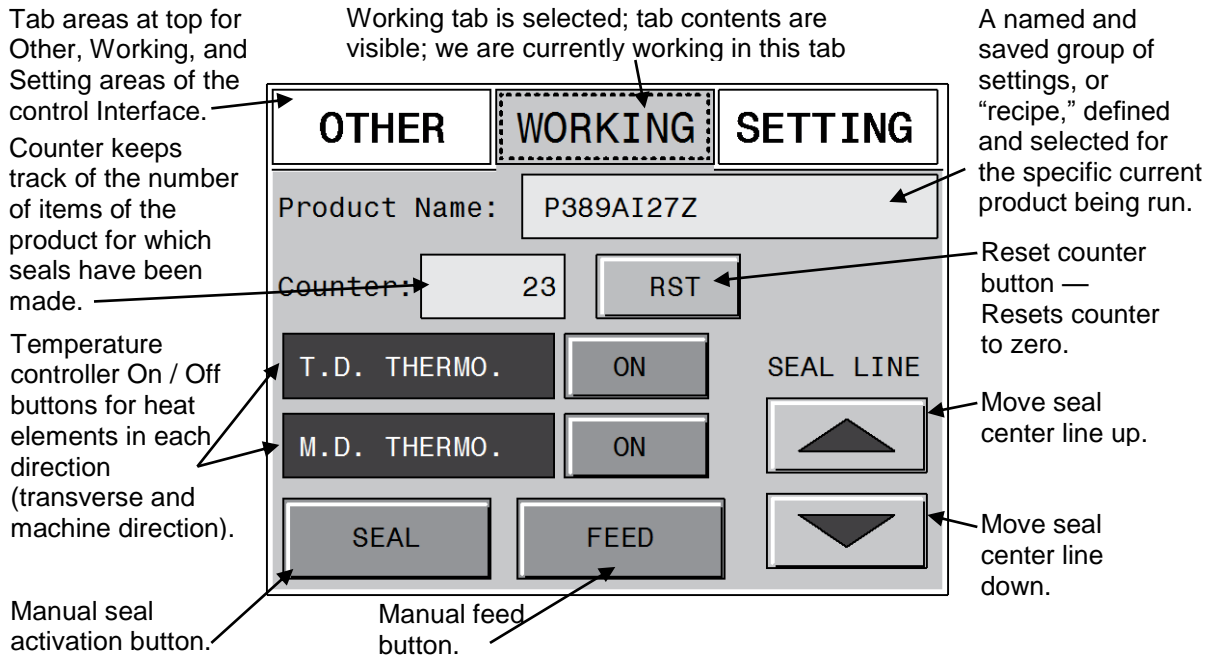
Once you have touched the Eastey screen, the touch panel will display the tabbed interface and you will be able to work with the tabbed interface of the Operator's Panel.



The touch panel interface is organized into three tabbed pages labeled: Other, Working, and Settings. To view or enter information in any of the tabs, touch the tab label area with your finger.

### Working Tab

The Working tab is normally active during normal operation. (If not, you can view it by touching the tab label, Working, on the touch screen.)



The Working tab shows the name of the product currently being run, and a running counter of the number of units that have been sealed using the current product settings or recipe. Buttons on the screen allow you immediate actions, such as to reset the counter, and override certain functions. For example, to manually feed the product and to seal it manually.

### Setting Tab

Touch the screen in the Setting tab to view and work with settings. The Setting tab allows you to view or set up parameters for products for semi-automatic operation.

Up to 10 recipes (groups of settings, each for a different product) can be saved at any time

Horizontal sensor button. See notes that follow for when to use.

Infeed conveyor speed selection

Enables or disables feature for close coordination of infeed and outfeed conveyors required for small packages.

Use to key information directly into parameter memory if required.

Setting tab is selected.

Touch Selection button to access recipe screens.

Displays the Product Name the recipe is for.

Vertical sensor button. See notes that follow for when to use.

Touch to access next page of parameter settings.

### To Create, Name, and Save a Recipe

Settings define sealing requirements determined by shape and size of a product and are called a recipe. Up to 10 recipes can be defined and saved at any time and are indexed as indicated by Product Number. A Product Name can be given to each recipe for convenience of quick reference.

1. If the content of the Setting tab is not already visible, touch the Setting tab label at the upper right of the Operator's Panel screen to access the Setting tab.
2. Touch the Selection button to access the Recipe screen. (Combined, the two pages of the Recipe screen allow you to name, define, and save up to ten recipes at a time.)

|             |           |              |
|-------------|-----------|--------------|
| Product No: | 5         | Renamed Save |
| Name:       | P389AI27Z |              |
| 1           | 219R38576 | SET          |
| 2           | 12937L    | SET          |
| 3           | 12937R    | SET          |
| 4           | 89712B    | SET          |
| 5           | P389AI27Z | SET          |
|             |           | PREV. NEXT   |

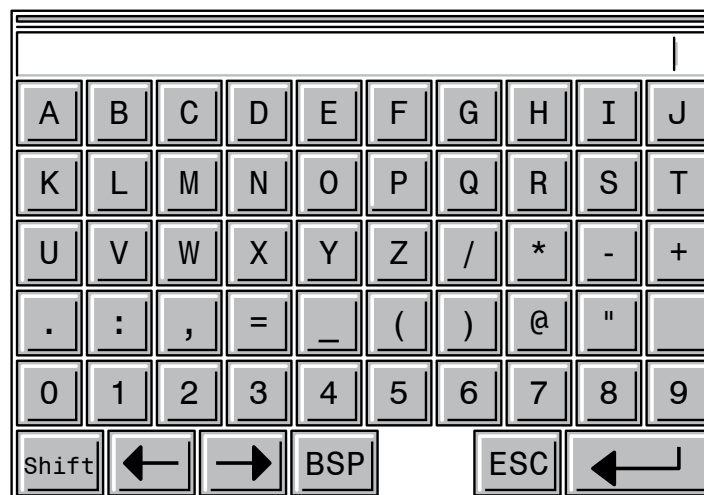
If you want to work with one of the first five recipes (Product No. 1 through 5), work in the first Recipe screen. To work with recipes six through ten (Product No. 6 through 10), touch Next at the bottom of the screen. (In each screen, touching the Prev. button allows you to return to the previous screen.)

The screenshot shows a recipe configuration screen. At the top, 'Product No:' is set to '5'. Below it, the 'Name:' field contains 'P389AI27Z'. To the right of the name field is a 'Renamed Save' button. Below the name field are five rows, each with a product number (6, 7, 8, 9, 10) in a small box on the left, an empty text input field in the middle, and a 'SET' button on the right. At the bottom of the screen are two buttons: 'PREV.' and 'EXIT'.

- Next to each rectangle for a Product Name is a Set button. Touch the Set button that is in the same Product Number row that you wish to define and name, keep your finger in contact for approximately two seconds and the Product No. at the top of the screen will display the number for the row you selected. If the Recipe has been given a name, the name appears in the Name field.

### Enter a Product Name

- Touch anywhere in the Name field, and an on-screen keypad window appears for typing in text for the Product Name.



5. Type the Product Name to give to the recipe. When you have finished typing, Press the Enter key (↵) to enter the name and close the keypad window and return to the Recipe screen.
6. Touch and hold Renamed Save for approximately two seconds to save the Product Name.

The Product Name should now display as you entered it and the Product Number should correspond to the Product Number you selected.

### Set Machine Functionality — Sensor Input, Infeed Speed, and Close Conveyor.

7. Touch the Prev. button (at the bottom of the Recipe screen) to return to the Setting tab.

| OTHER             | WORKING   | SETTING   |
|-------------------|-----------|-----------|
| Product No:       | 1         | Selection |
| Product Name:     | P389AI27Z |           |
| Sensor Select:    | HORZ.     | VERTI.    |
| Infeed Speed:     | NORMAL    | HISPEED   |
| CONV. Close:      | ENABLE    |           |
| Parameter Memory: | KEYIN     | NEXT      |

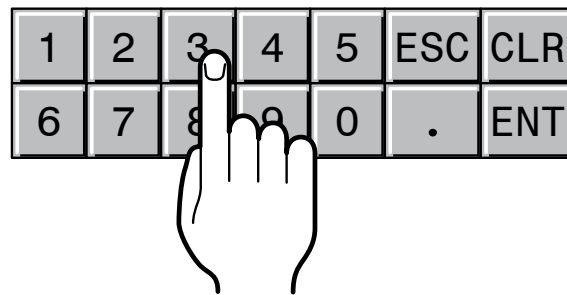
8. Select the input sensor photo eye to be used, whether Horizontal or Vertical, by touching the corresponding button in the Sensor Select row.
9. Select the Infeed Speed to be used, whether Normal or High Speed, by touching the corresponding button in the Infeed Speed row.
10. Select whether the Conveyor Close feature (for close coordination of infeed and outfeed conveyors, required for small packages) should be enabled or disabled by touching the Enable/Disable button in the Conv. Close row.

### Set Machine Timers — Seal Time, Advance, and Conveyor Stop.

11. Touch the Next button (at the bottom of the Setting tab) to access the Machine Timers settings.

| OTHER          | WORKING | SETTING        |
|----------------|---------|----------------|
| Seal Time:     | 0.6     | Sec. (0.1~5.0) |
| Advance:       | 0.6     | Sec. (0.0~5.0) |
| Conveyor Stop: | 0.6     | Sec. (0.1~5.0) |
|                |         | PREV.    NEXT  |

12. Touch the rectangle for Seal Time to enter time in seconds for the seal timer.



Because only numbers and a decimal point are acceptable input, a numerical keypad appears. Touch the buttons required to enter a decimal number for the seconds. Acceptable values are 0.1 to 5.0, in tenths of a second increments. Touch the Enter button when you have finished.

13. Touch the rectangle for Advance to enter the time in seconds for the film advance timer. Acceptable values are 0.0 to 5.0, in tenths of a second increments.
14. Touch the rectangle for Conveyor Stop to enter the time in seconds for the conveyor stop timer. Acceptable values are 0.1 to 5.0, in tenths of a second increments.

**Set Temperatures and Machine Distance Settings** — Heat Elements, Transverse Direction and Machine Direction, Infeed Conveyor Width, Film Inverter Triangle Height, and Seal Line Height.

15. Touch the Next button (at the bottom) to access the Temperatures and Machine Distance settings.

| OTHER             | WORKING                          | SETTING                              |
|-------------------|----------------------------------|--------------------------------------|
| T.D. Thermo:      | <input type="text" value="0"/>   | °C                                   |
| M.D. Thermo:      | <input type="text" value="0"/>   | °C                                   |
| Infeed Width:     | <input type="text" value="0.0"/> | mm                                   |
| Triangle Height:  | <input type="text" value="0.0"/> | mm                                   |
| Seal Line Height: | <input type="text" value="0.0"/> | mm                                   |
|                   |                                  | <input type="button" value="PREV."/> |

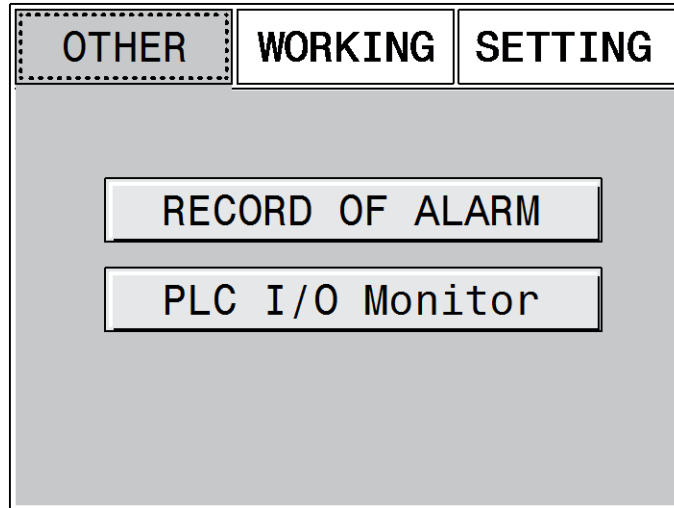
16. Touch the rectangle for T.D. Thermo to set the temperature (in Celsius) for the sealer heating element that is oriented transverse to the main axis of the machine. Enter the value using the numeric keypad that appears and touch the Enter button when finished.
17. Touch the rectangle for M.D. Thermo to set the temperature (in Celsius) for the sealer heating element that is oriented parallel to the main axis of the machine. Enter the value using the numeric keypad that appears and touch the Enter button when finished.
18. Touch the rectangle for Infeed Width to enter the width setting (in millimeters, with precision of tenths of a millimeter) for the infeed conveyor. Touch Enter on the on-screen numeric keypad when finished entering the number.
19. Touch the rectangle for Triangle Height to enter the height setting (in millimeters, with precision of tenths of a millimeter) for the inverter triangle height. Touch Enter on the on-screen numeric keypad when finished entering the number.
20. Touch the rectangle for Seal Line Height to enter the height setting (in millimeters with precision of tenths of a millimeter) for the seal centerline height. Touch Enter on the on-screen numeric keypad when finished entering the number.
21. After all values have been entered, touch the Prev. button to return to the previous screen. Touch the Prev. button at the bottom of the screen to return to the Recipes screen. Touch the Prev. button at the bottom of the screen to return to the Setting tab.
22. In the Setting tab, touch the Selection button. In the Recipe screen, with the recipe indicated by Product Number and Name at the top of the screen, touch the Renamed Save button and hold it for approximately two seconds to save the recipe settings.

**This completes the instructions to Create, Name, and Save a Recipe.**



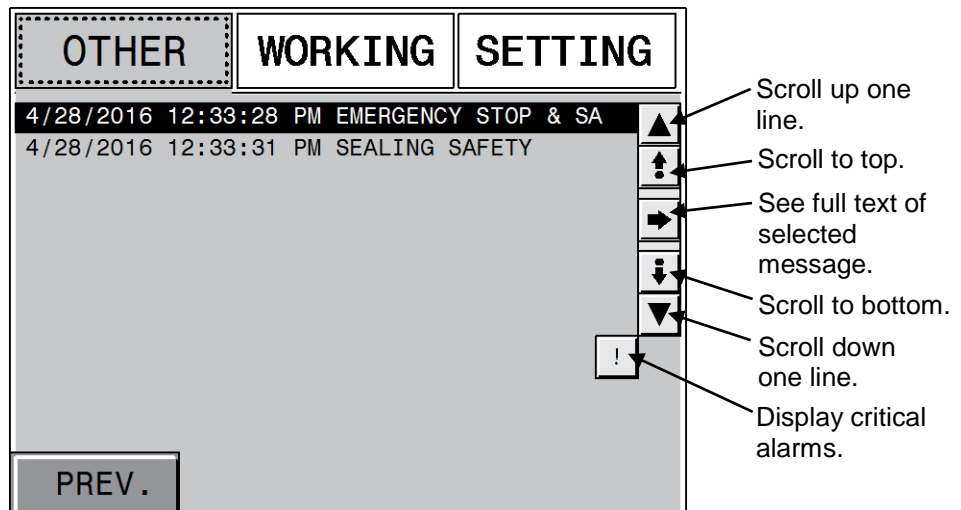
## Other Tab

The remaining tab is labeled Other. This tab contains two buttons for general monitoring and troubleshooting of the system. These buttons allow you to view a log of system alarms, or view a log of I/O messages from the system PLC.



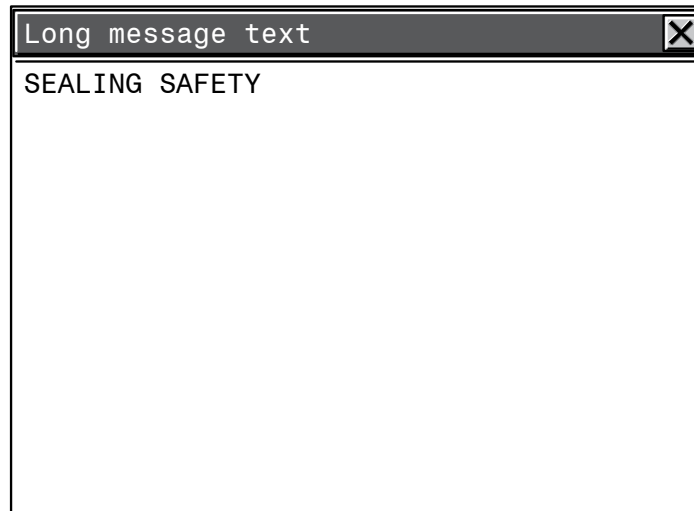
## Record of Alarm

To view the current log entries of system alarms, touch the Record of Alarm button. A screen appears listing system log entries. (Under normal conditions, this screen will be blank and contain no messages. Only tab labels and buttons shown below will display.)



Touch the control buttons at the right of the screen to scroll through the alarm messages.

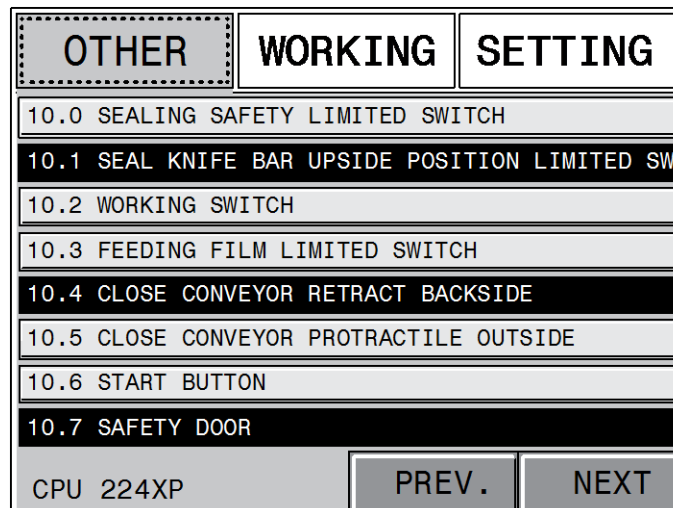
If you need to see the full text of an alarm message, scroll to the desired message and then touch the right-arrow button (→). Press the X at the upper right of the Long Message text window when you are finished.



Touch the Prev. button at the bottom of the Record of Alarm screen to return to the previous screen of the Other tab.

### PLC I/O Monitor

To view messages from PLCs for monitoring I/O conditions or for troubleshooting, touch the PLC I/O Monitor button.



Use the Prev. and Next Buttons to view additional PLC I/O messages.

## Film Setup

**CAUTION!** Turn off the working switch when setting up the film.

**Note:** You can turn the heat on to the sealer heat elements (M.D. Thermo and T.D. Thermo) to allow them to warm up to operating temperature while setting up the film.

Select the proper width of center-fold film for the product being packaged, taking into account the width and height of the package, plus six inches for scrap.

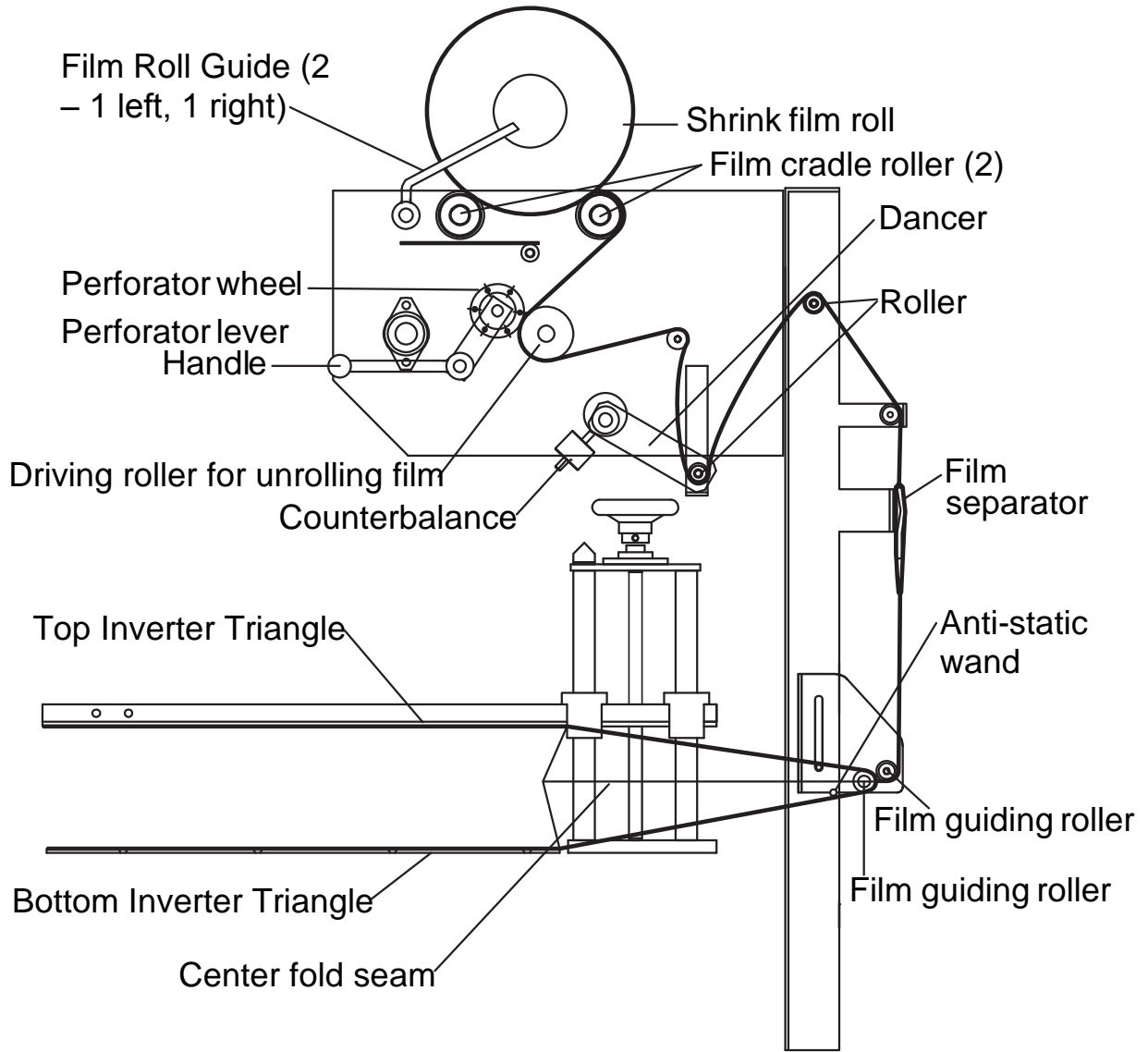
1. Place the film roll on the rollers at the top of the film unwinder. (See the following photo.)

**Note:** Place the film center-fold end of the roll toward the infeed end, away from the operator panel (unless otherwise specified).

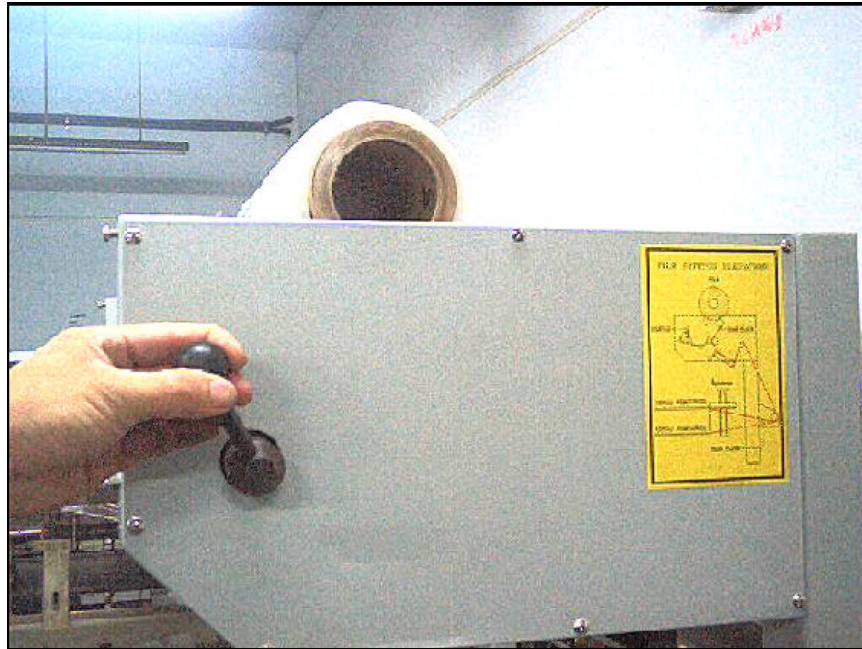


2. Position the film roll on the rollers and tighten the upright bolts on the film rack collars to hold the film roll in position.

### Film Unwind Path Diagram



3. Pull down on the film perforator handle, as shown in the following photo, to temporarily disengage the film perforator and hold the film perforator out of the way, while threading the film.



4. Thread the film through and around the idler rollers and the pin perforator as shown in the Film Unwind Path Diagram illustration on the previous page. Separate the film so one side of the film is to each side of the Film separator (shown in the following photo).



5. Separate the film and pull it through the antistatic bar and around the rollers to the inverters.



6. Pull the film out slightly more than one meter (39 inches) across the top of the upper inverter.



**Note:** Each inverter triangle (top and bottom) inverts, that is, flips the part of the film (top or bottom) with which it comes into contact upside-down. It turns the top half of the film upside-down and the bottom half upside-down, in such a way that the film exits the inverters inside-out relative to how it is stored on the roll, and in such manner that the center-fold seam approaches the outer corner of the inverter at the infeed end, and when the film is inverted, the center fold seam is then redirected behind and parallel to the infeed conveyor. (See the illustration on the next page.)

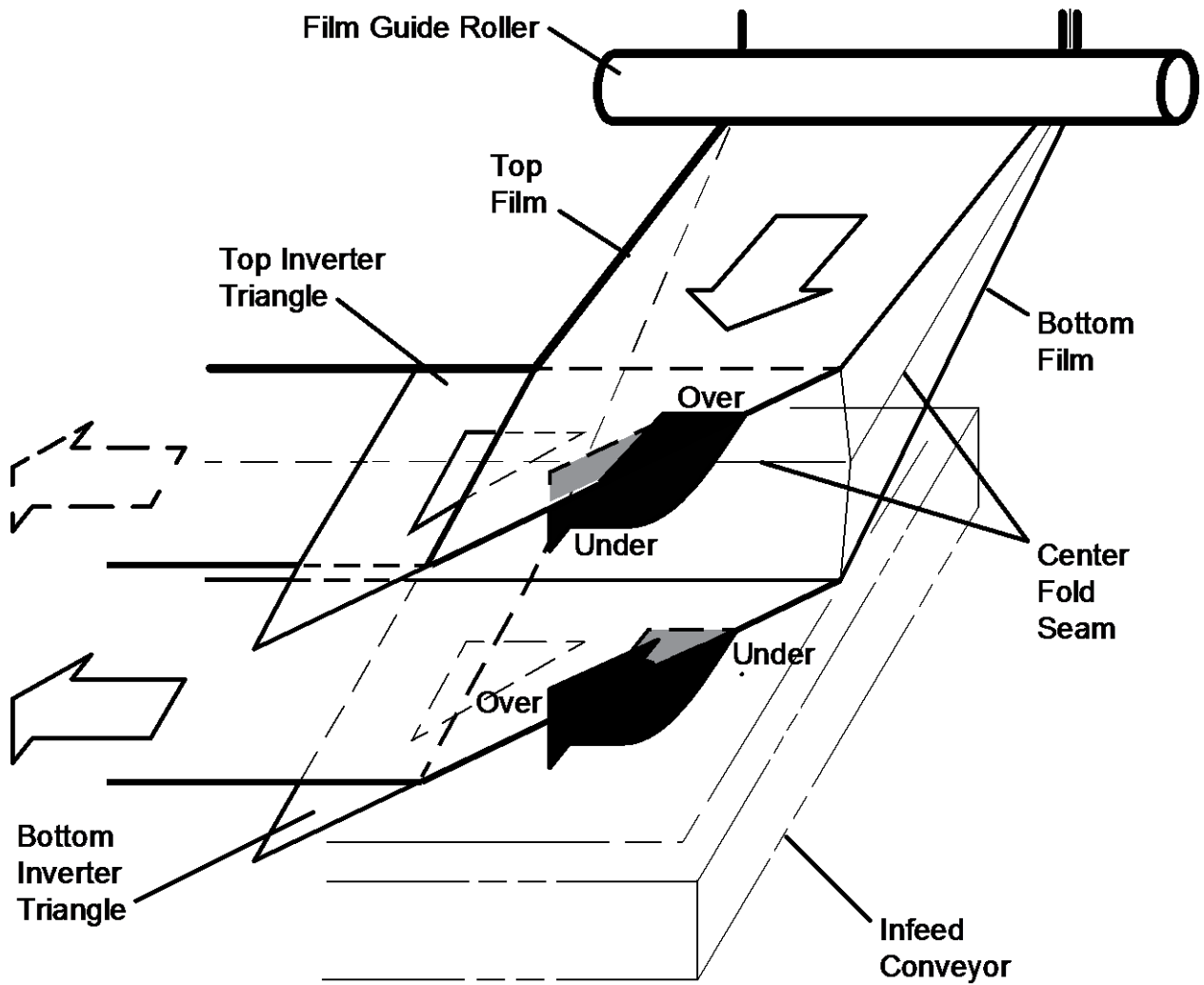
7. Carefully separate the two sides of the center-folded film.



8. Unfold and open the film, holding the top film across the top of the upper inverter triangle with your left hand, so the film enters, top film over the top to flip underneath. With your right hand, bring the bottom film underneath the infeed conveyor at the infeed end and underneath the bottom inverter so the bottom film enters under the bottom to flip over to the top side of the bottom inverter. See the following illustration on the next page.

### Film routing for Top and Bottom Inverter Triangles

Use this diagram to route the top film over, then under the top inverter triangle, and the bottom film under, then over the bottom inverter triangle.





9. The film will look something like this photo.



10. Match both the top sheet and bottom sheet of the film and guide the leading end of the film toward the sealing area.

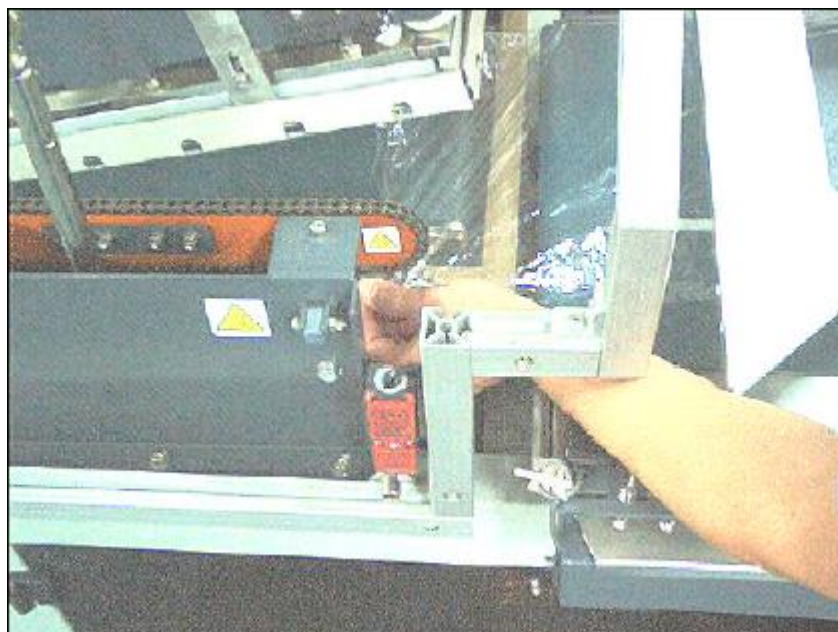


11. Pull the film to the left to the L-sealing area and lift the lever to temporarily release the pinch wheels.

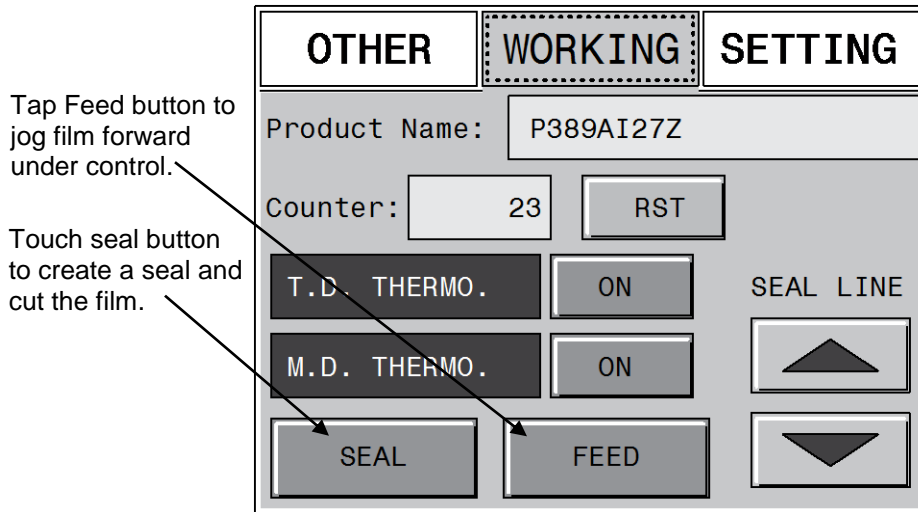


**CAUTION!** This is a pinch area. Take care to avoid pinching hands or fingers while using the pinch wheel to secure the leading film.

12. Pull the two leading edges of the film into the film drive chain so that the pinch wheel and drive chain will grab the film when lever is lowered and begin pulling the film when activated. Lower the lever to engage the pinch wheels.



13. Tap the Feed button on the touch screen to jog the film under control. Do not press and hold the button or film will begin to run and seal continuously. The film will feed into the seal area. Touch the Seal button on the touch screen to cut the film.

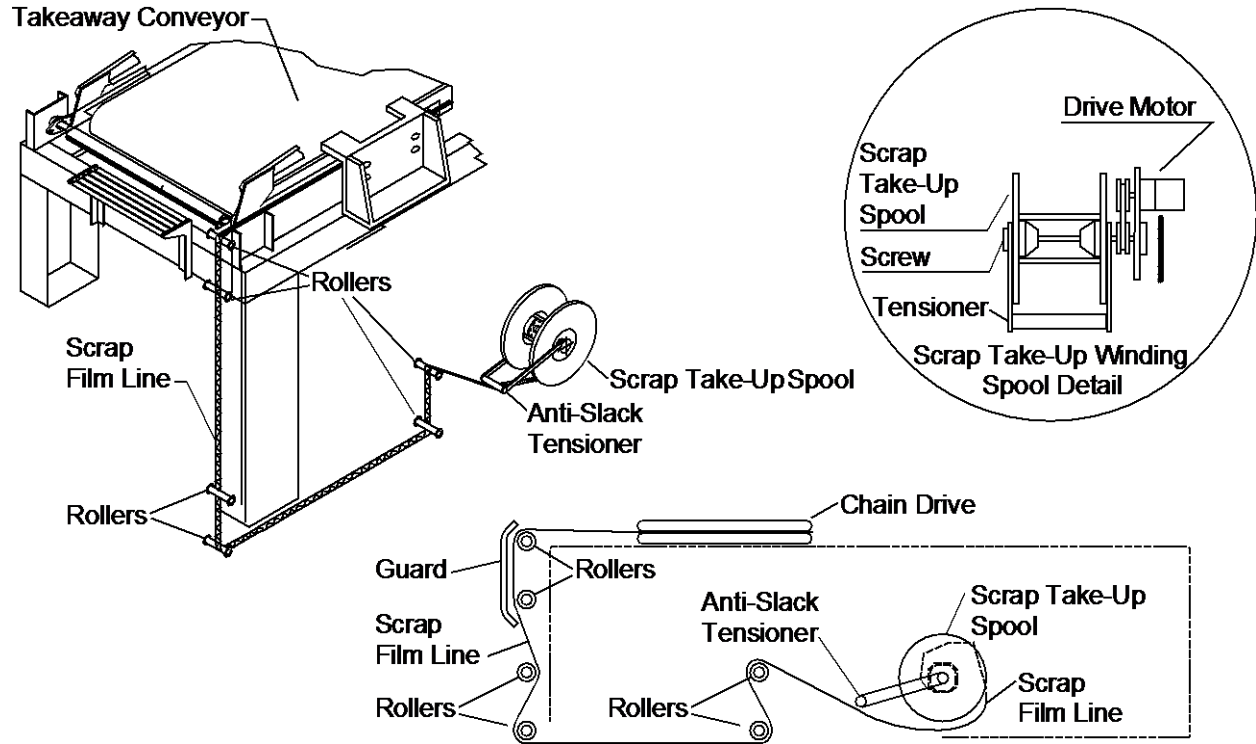


## Setup for Scrap Winding

As you run the L-Sealer, excess film will be cut off and exit the front of the chain drive near the discharge end. To avoid waste film bunching up and creating an obstruction, the scrap film is routed by rollers to the scrap take-up spool in the base of the L-Sealer. Use the following instructions and illustration at the top of the next page to guide the scrap film line around the rollers, under the anti-slack tensioner and on to the scrap take-up spool.

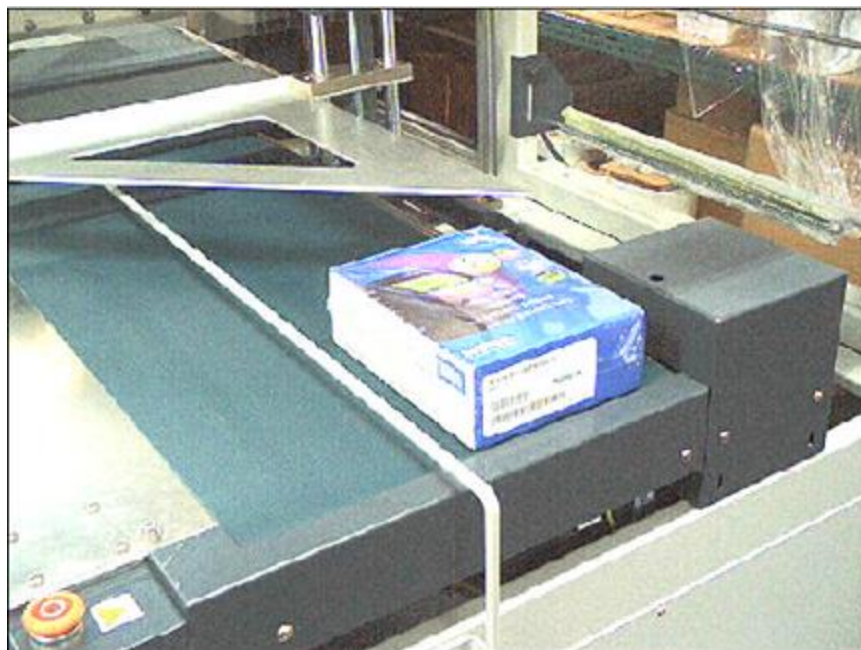
1. As scrap begins to be generated, guide the scrap film around the roller and guide at the discharge end of the L-sealer.
2. Continue to guide the scrap film around the rollers at the front, and under the machine as shown. Most of the rollers are concealed beneath a guard bracket, and others are under the machine but all are accessible and you will be able to route the scrap film line around them.
3. Continue routing the scrap film line around the final roller, under the anti-slack tensioner, as shown, and onto the scrap take-up spool. Begin winding the scrap one complete revolution around the center hub of the scrap take-up spool, so the cling of the film will keep the film on the spool as the drive motor rotates the spool.

When complete, the scrap film should follow the route to the scrap take-up spool as depicted in the following illustration at the top of the next page.



## Adjusting Conveyor Width for Size of Product

1. Temporarily turn the Working switch to Off and place a sample of the product to be sealed on the conveyor near the infeed end.



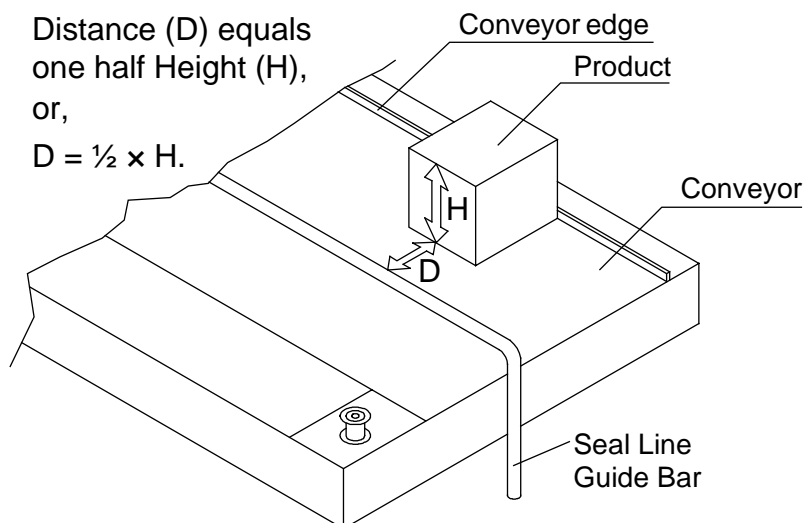
- Place the product against the rear edge of the Infeed conveyor as shown below, and measure the height



- Measure the height of the product, (H) and calculate the distance (D) as half of the height of the product ( $\frac{1}{2} \times H = D$ ).

Example 1: Product Height,  $H = 4$  inches.  
Distance from product to seal line guide bar,  $D = \frac{1}{2} H = \frac{1}{2} \times 4$  in.  
 $D = 2$  inches.

Example 2: Product Height,  $H = 7$  inches.  
Distance from product to seal line guide bar,  $D = \frac{1}{2} H = \frac{1}{2} \times 7$  in.  
 $D = 3\frac{1}{2}$  inches.



4. Move the Seal Line Guide Bar the distance (D) from the base of the product as calculated ( $D = \frac{1}{2} \times H$ ) and shown in the illustration.



5. Use the Infeed Conveyor Width Adjustment Wheel to adjust the width of the infeed conveyor to the calculated distance D.

## Adjusting Film Inverter Height and Guide Roller Height

1. Adjust the height between the Film Inverter Separator Triangles. There should be a distance of approximately 1/2 inch (13 mm) between the product package and upper inverter triangle.

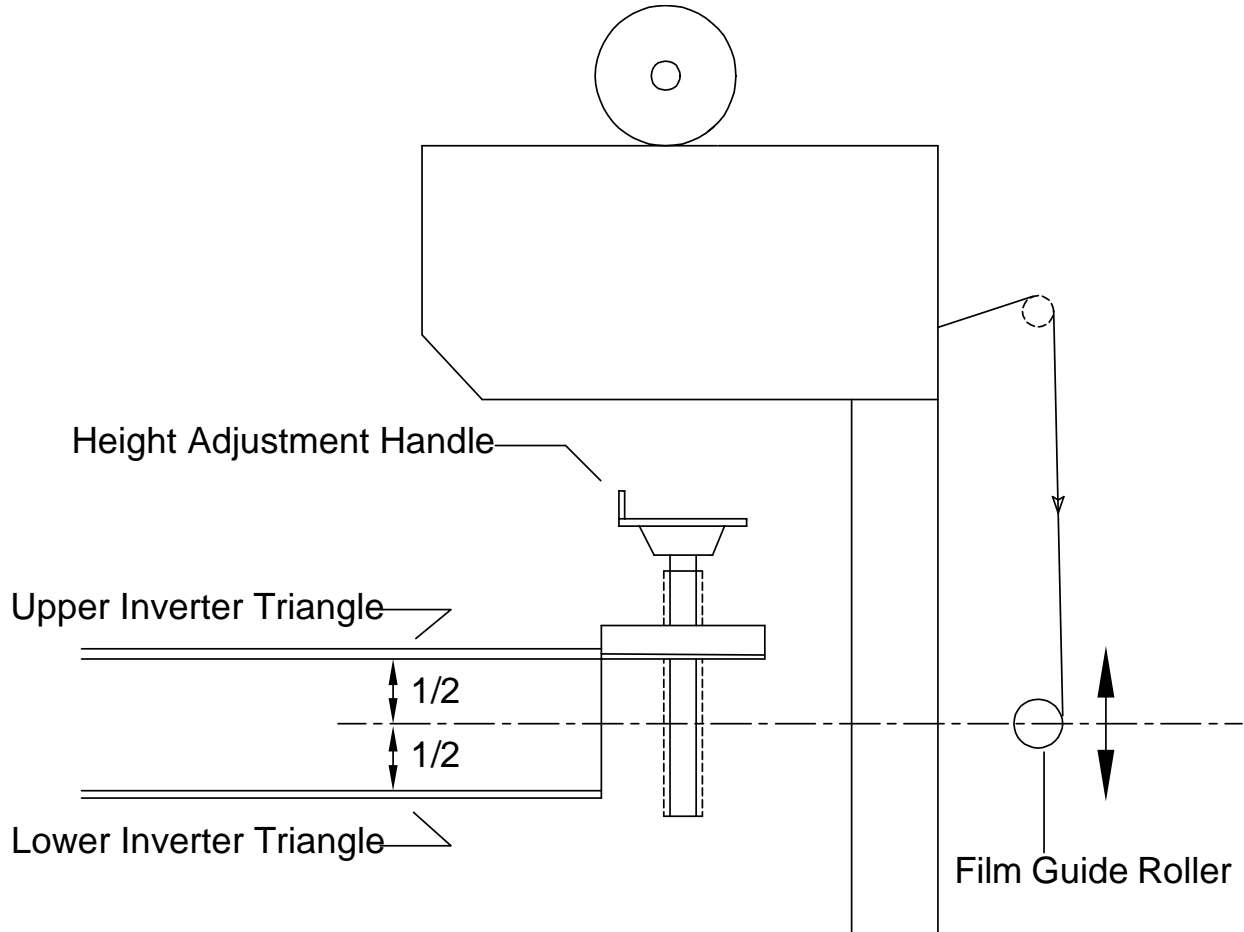


2. Adjust the height of the Film Guide Roller (shown in the photo below) to the center of the distance between the upper and lower triangles of the film inverter. Refer to the illustration on the following page.



### Height Adjustment for Upper Triangle and Film Guide Roller

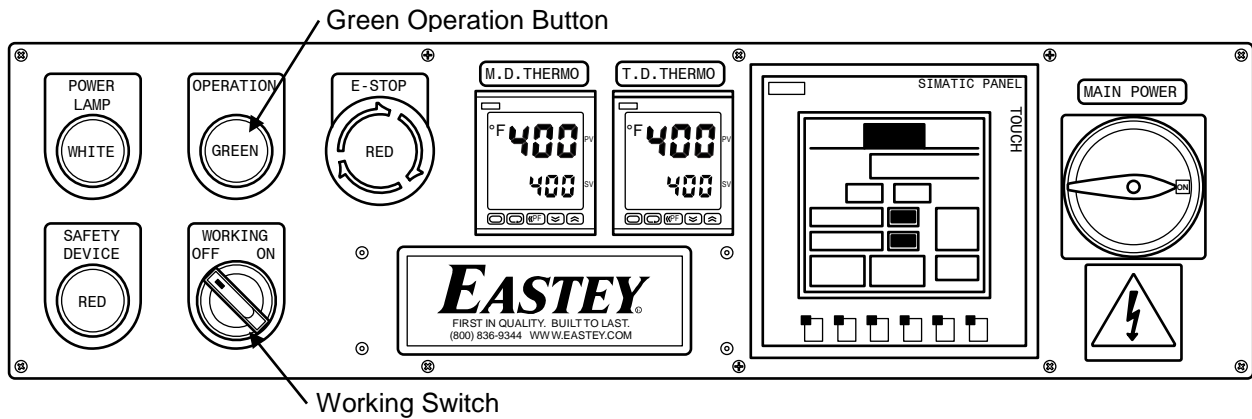
Adjust the Film Guide Roller, setting the roller center to the center distance midway between the Upper and Lower Triangle Boards.





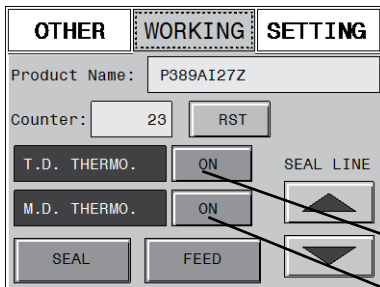
## Manual Seal Test

1. Turn the Working switch On and press the green Operation button. The conveyors should be running.

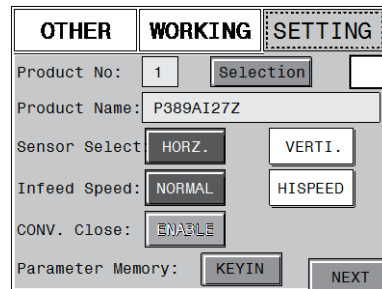


2. If the L-Sealer heat elements are not already up to operating temperature, bring them up to operating temperature by setting the temperature on the M.D. Thermo and T.D. Thermo temperature controllers.

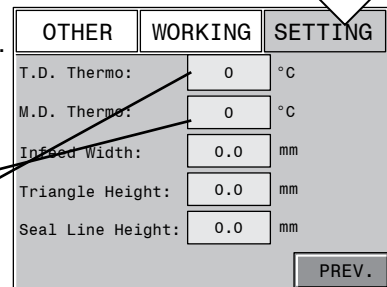
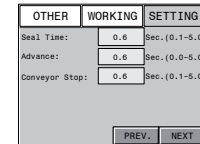
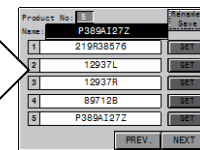
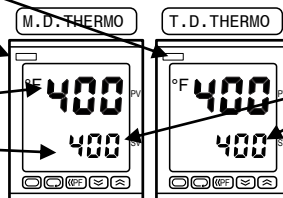
Touch the buttons for the T.D. Thermo and M.D. Thermo controls in the Working Tab to activate the controllers' displays.



Temperature controllers show current temperature and set temperature for working temperature.

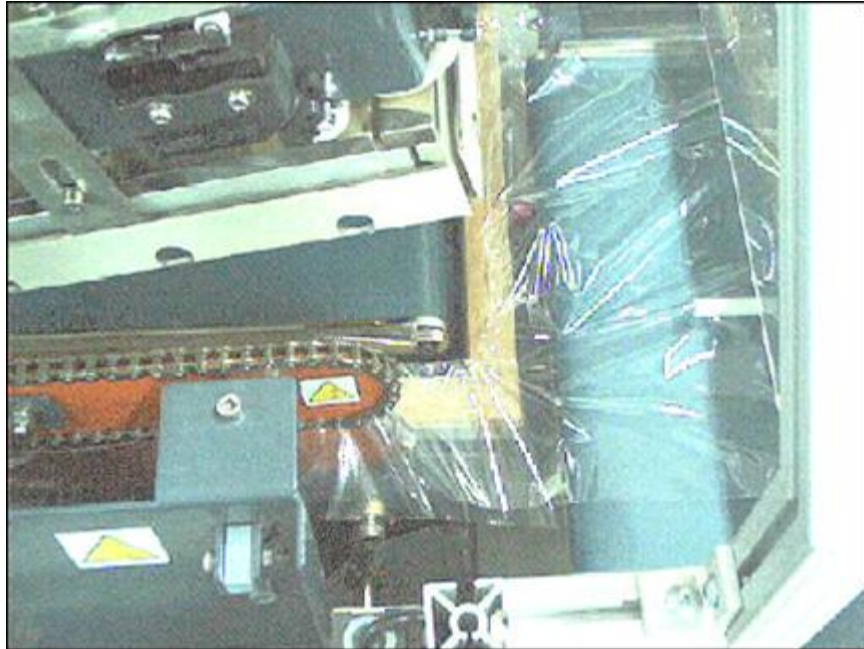


Temperature controller working temperatures are set in the recipe through the Setting tab.



3. With the heating elements at operating temperature, cover the sensor with a piece of paper or cardboard for about two (2) seconds.

4. Remove the paper or cardboard and the seal function test runs automatically. This allows you to verify settings and to verify that a proper seal is formed. If it will be necessary to go back and make or check any adjustments, it will be evident as a result of this test.



Once the machine is set up for the product, operation is automatic.

**This completes the instructions for Machine Setup and operation.**

# Adjustments

## Adjusting Film Inverter Height and Guide Roller Height

1. Adjust the height between the Film Inverter Separator Triangles. There should be a distance of approximately 1/2 inch (13 mm) between the product package and upper inverter triangle.

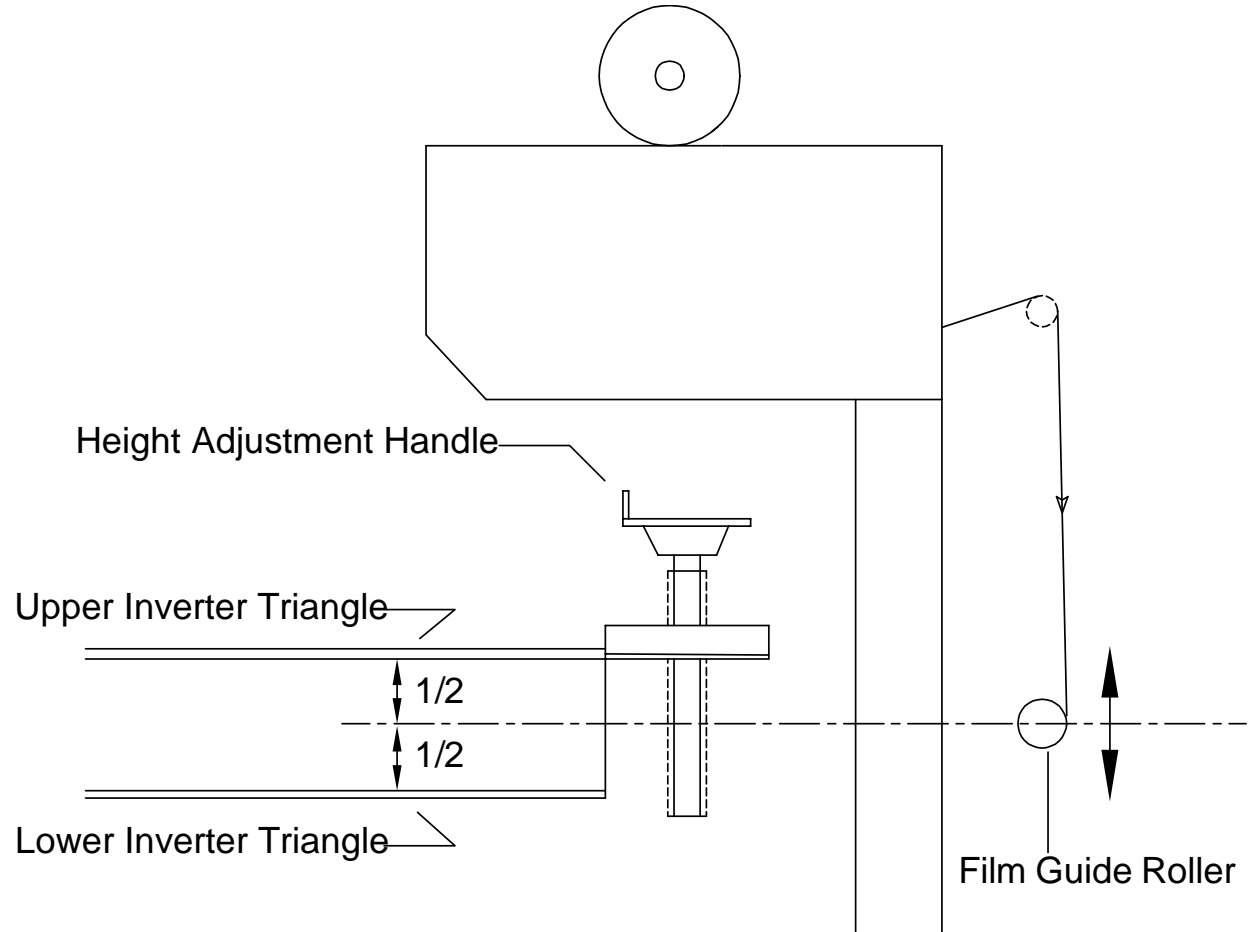


2. Adjust the height of the Film Guide Roller (shown in the photo below) to the center of the distance between the upper and lower triangles of the film inverter. Refer to the illustration on the following page.



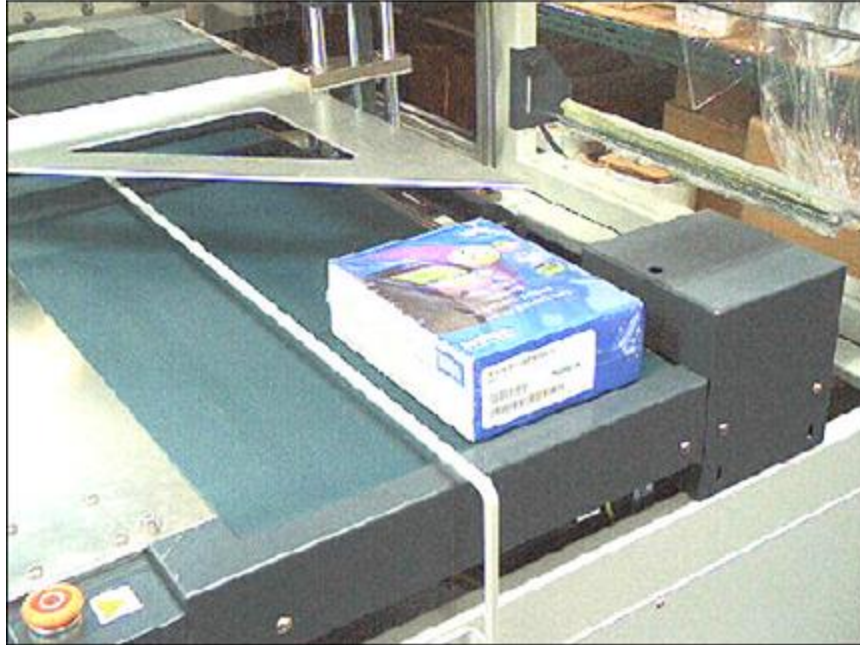
### Height Adjustment for Upper Triangle and Film Guide Roller

Adjust the Film Guide Roller, setting the roller center to the center distance midway between the Upper and Lower Triangle Boards.



## Adjusting Conveyor Width for Size of Product

1. Temporarily turn the Working switch to Off and place a sample of the product to be sealed on the conveyor near the infeed end.



2. Place the product against the rear edge of the Infeed conveyor as shown below, and measure the height



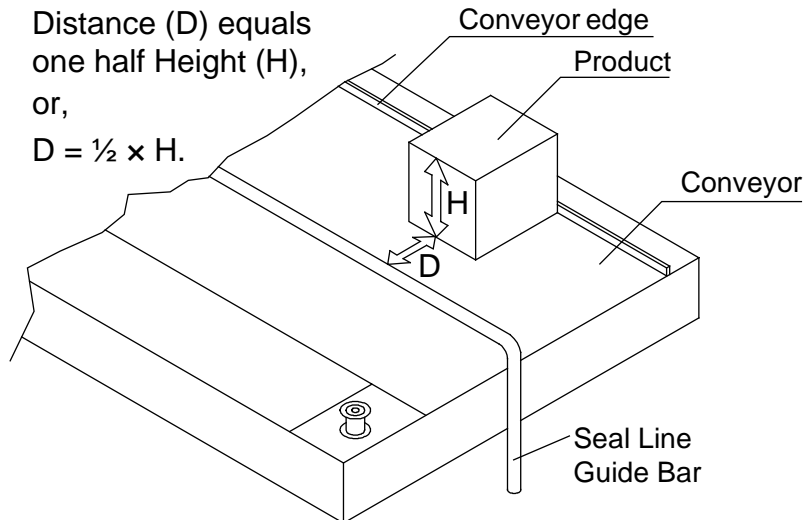
3. Measure the height of the product, (H) and calculate the distance (D) as half of the height of the product ( $\frac{1}{2} \times H = D$ ).

Example 1: Product Height, H = 4 inches.

Distance from product to seal line guide bar,  $D = \frac{1}{2} H = \frac{1}{2} \times 4$  in.  
 $D = 2$  inches.

Example 2: Product Height, H = 7 inches.

Distance from product to seal line guide bar,  $D = \frac{1}{2} H = \frac{1}{2} \times 7$  in.  
 $D = 3\frac{1}{2}$  inches.



4. Move the Seal Line Guide Bar the distance (D) from the base of the product as calculated ( $D = \frac{1}{2} \times H$ ) and shown in the illustration.



5. Use the Infeed Conveyor Width Adjustment Wheel to adjust the width of the infeed conveyor to the calculated distance D.

# Maintenance

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

## Cleaning

Cleaning of the machine is occasionally necessary.

1. After daily operation, carefully wipe the sealing cutter clean with a soft cloth.
2. The machine is not designed or built for waterproof function. When cleaning the machine, use a damp cloth. **DO NOT** splash water or other liquids on or into the machine.
3. The machine has been coated with an anti-dust finish. Avoid contact with liquid acid or gas, or other corrosives.

## Rollers

Make sure rollers stay clean and grease free. If you should have to clean the rollers, simply wipe them down with a clean lint free cloth. If a more thorough cleaning is necessary wipe the rollers down with a mild detergent and water and let dry. **DO NOT** splash water or other liquids into the machine. **Never use harsh or abrasive cleaners or chemical agents when cleaning this machine.**



# Troubleshooting

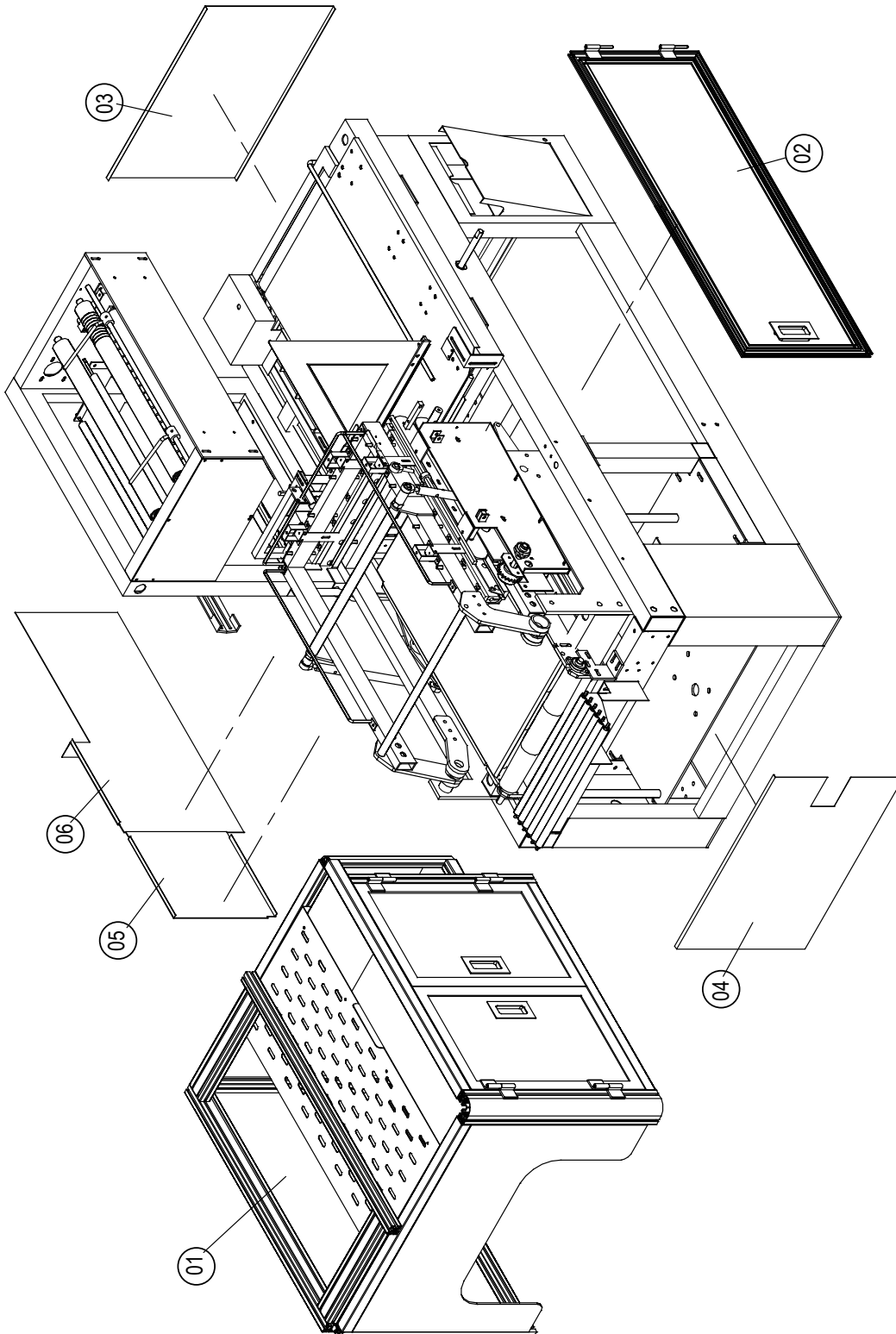
| Problem   | Possible Cause  | Solution  |
|---|---|---|
| <p>Control power lamp does not light.</p> <p>No fuse breaker tripped.</p>   | <ul style="list-style-type: none"> <li>• Power not connected.</li> <li>• Fuse burned out.</li> <li>• Defective switch.</li> <li>• Disconnected wire.</li> <li>• Poor connection.</li> <li>• Electrical leakage.</li> </ul>  | <ul style="list-style-type: none"> <li>• Replace part.</li> <li>• Switch on power.</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> <li>• Insufficient oil.</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> <li>• Fill oil as required.</li> </ul> |
| Sealing arm fails to move.                 | <ul style="list-style-type: none"> <li>• Disconnected wire.</li> <li>• Defective relay unit.</li> <li>• Defective solenoid.</li> <li>• Insufficient air pressure.</li> <li>• Defective throttle valve.</li> </ul>               | <ul style="list-style-type: none"> <li>• Replace part.</li> <li>• Replace part.</li> <li>• Check part; replace as needed.</li> <li>• Check air supply.</li> <li>• Check throttle valve.</li> </ul>                   |
| Sealing arm rises too abruptly.            | <ul style="list-style-type: none"> <li>• Throttle valve opens too quickly.</li> <li>• Sealing time is set too short.</li> </ul>   | <ul style="list-style-type: none"> <li>• Adjust flow control.</li> <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>  |

| Problem                              | Possible Cause  | Solution   |
|--------------------------------------|---|--|
| 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

## VSA1721-TK-V1 Base Panels and L-Sealer Cover



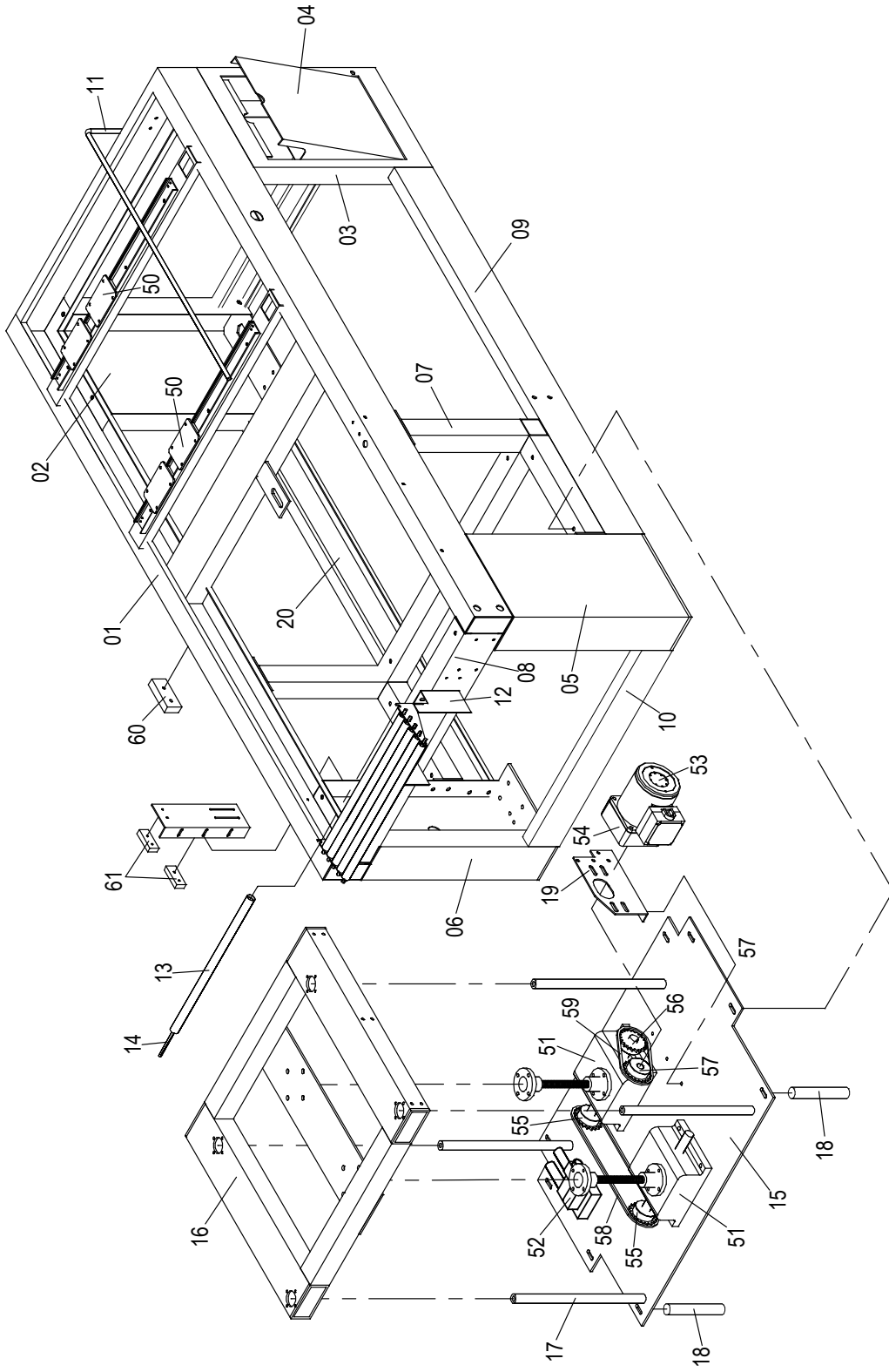
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## VSA1721-TK-V1 Base Panels and L-Sealer Cover

### Parts List – 504G (All)

| ITEM | PART NO.  | DESCRIPTION                                  | Q'TY |
|------|-----------|--|------|
| 1    | 504G      | Cover, L-Sealer Enclosure                    | 1    |
| 2    | 504G-AC01 | Door / Bin, Base Front Infeed (right) Corner | 1    |
| 3    | 504G-AP13 | Panel, Base Cover, Infeed (right)            | 1    |
| 4    | 504G-AP12 | Panel, Base Cover Exit (left)                | 1    |
| 5    | 504G-AP11 | Panel, Base Cover, Back, Exit                | 1    |
| 6    | 504G-AP14 | Panel, Base Cover, Back, Infeed              | 1    |

# VSA1721-TK-V1 Base Chassis Frame and Sealer Lift



## VSA1721-TK-V1 Base Chassis Frame and Sealer Lift

Parts List – 504G(A-1 + A-2): (A-1 = 1-20;50-59); (A-2 = 60-61)

| ITEM | PART NO.            | DESCRIPTION   | Q'TY |
|------|---------------------|---|------|
| 1    | 504G-AP01           | Frame Weldment, Top Of Base Frame                   | 1    |
| 2    | 504G-AP06           | Base Corner Panel, Intake Back (right)              | 1    |
| 3    | 504G-AP04           | Base Corner Panel, Intake Front (with door - right) | 1    |
| 4    | 504G-AP05           | Door Bin, Base Corner Panel, Intake Front (right)   | 1    |
| 5    | 504G-AP07           | Base Corner Panel, Exit, Front (left)               | 1    |
| 6    | 504G-AP08           | Base Corner Panel, Exit, Back (left)                | 1    |
| 7    | 504G-AP01-4         | Motor Cage Weldment                                 | 1    |
| 8    | 504G-AP01-3         | Exit End Member                                     | 1    |
| 9    | 504G-AP18           | Long Member, Machine Direction, Base, Front         | 1    |
| 10   | 504G-AP03           | End Cap Member, Top Of Base Frame, Intake and Exit  | 2    |
| 11   | 504G-BP09           | Seal Line Guide Bar                                 | 1    |
| 12   | 504G-DP07           | Bracket, Holder, Exit Roller Assembly               | 1    |
| 13   | 504G-DM07           | Roller, Exit  | 6    |
| 14   | 504G-DM08           | Axle, Roller  | 6    |
| 15   | 504G-EP14           | Floor, Base Motor Compartment                       | 1    |
| 16   | 504G-EP15           | Frame, L-Sealer Raise / Lower                       | 1    |
| 17   | 504G-EM27           | Guide Shaft L-Sealer Raise / Lower                  | 4    |
| 18   | 504G-AP02           | Support Shaft, Motor Compartment Base               | 2    |
| 19   | 504G-AP22           | Bracket, Motor Mounting                             | 1    |
| 20   | 504G-AP17           | Long Member, Machine Direction, Base, Rear          | 1    |
| 50   | FBW3590-600L        | Linear Bearing Assembly, Intake Conveyor Adjustment | 2    |
| 51   | TM-3T-A-T-S-1/6-250 | Linear Actuator, Spiral Gear, Raise / Lower         | 2    |
| 52   | 4V310-10,DC24V      | Valve, Electromagnetic, Air                         | 1    |
| 53   | 5IK60GU-CWTE        | Motor, Raise / Lower                                | 1    |
| 54   | 5GU15K              | Gearbox   | 1    |
| 55   | RS35,15T            | Gear Wheel  | 2    |
| 56   | RS35,15T            | Gear Wheel  | 1    |
| 57   | RS35,20T            | Gear Wheel  | 1    |
| 58   | RS35,76R            | Roller Chain  | 1    |
| 59   | RS35,44R            | Roller Chain  | 1    |

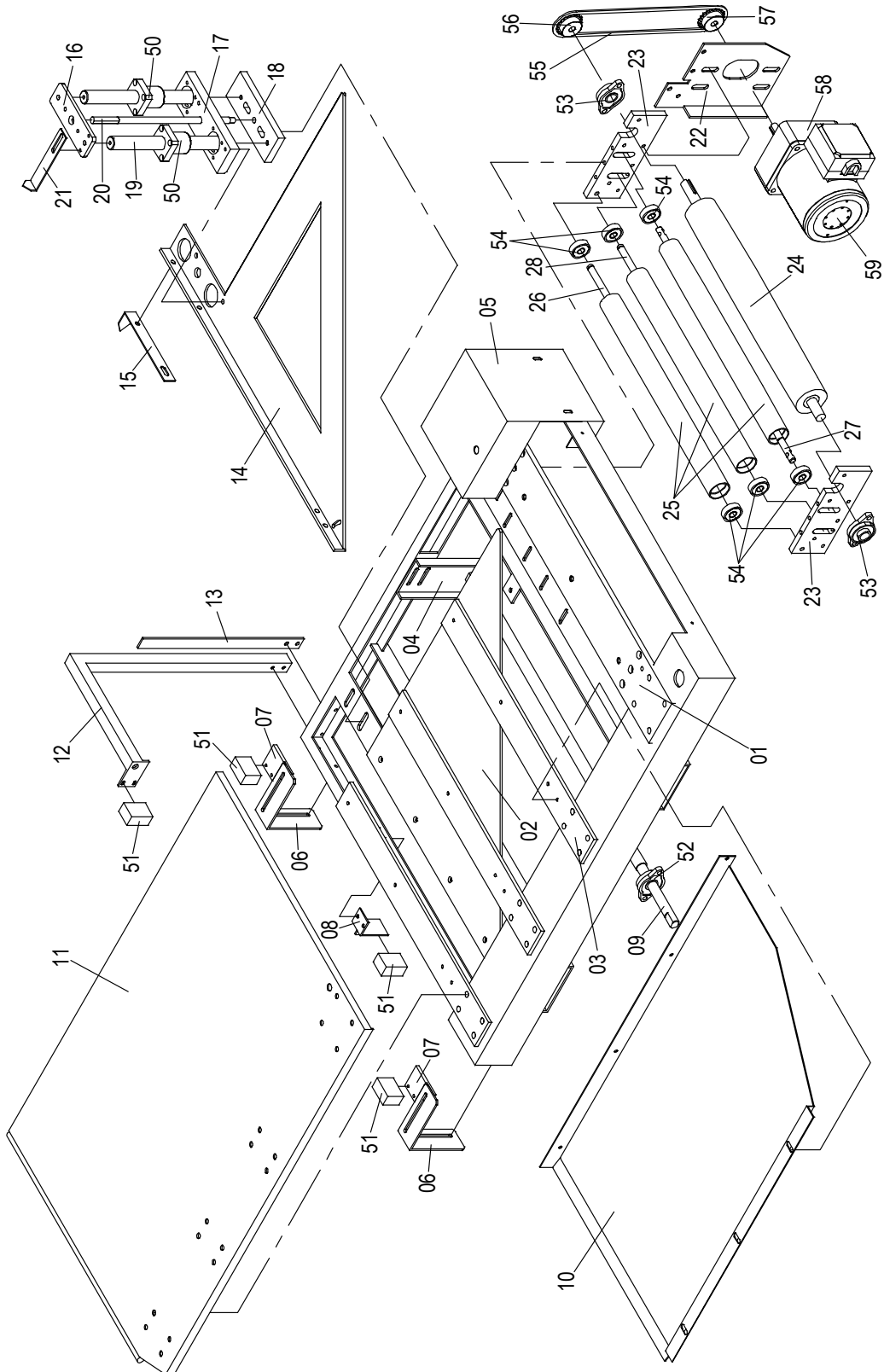
56 Parts List

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| ITEM | PART NO.   | DESCRIPTION | Q'TY |
|------|------------|-------------|------|
| 60   | Z-15GQ22-B | Switch      | 1    |
| 61   | Z-15GQ-B   | Switch      | 2    |



# VSA1721-TK-V1 Intake Conveyor and Film Inverter



## VSA1721-TK-V1 Intake Conveyor and Film Inverter

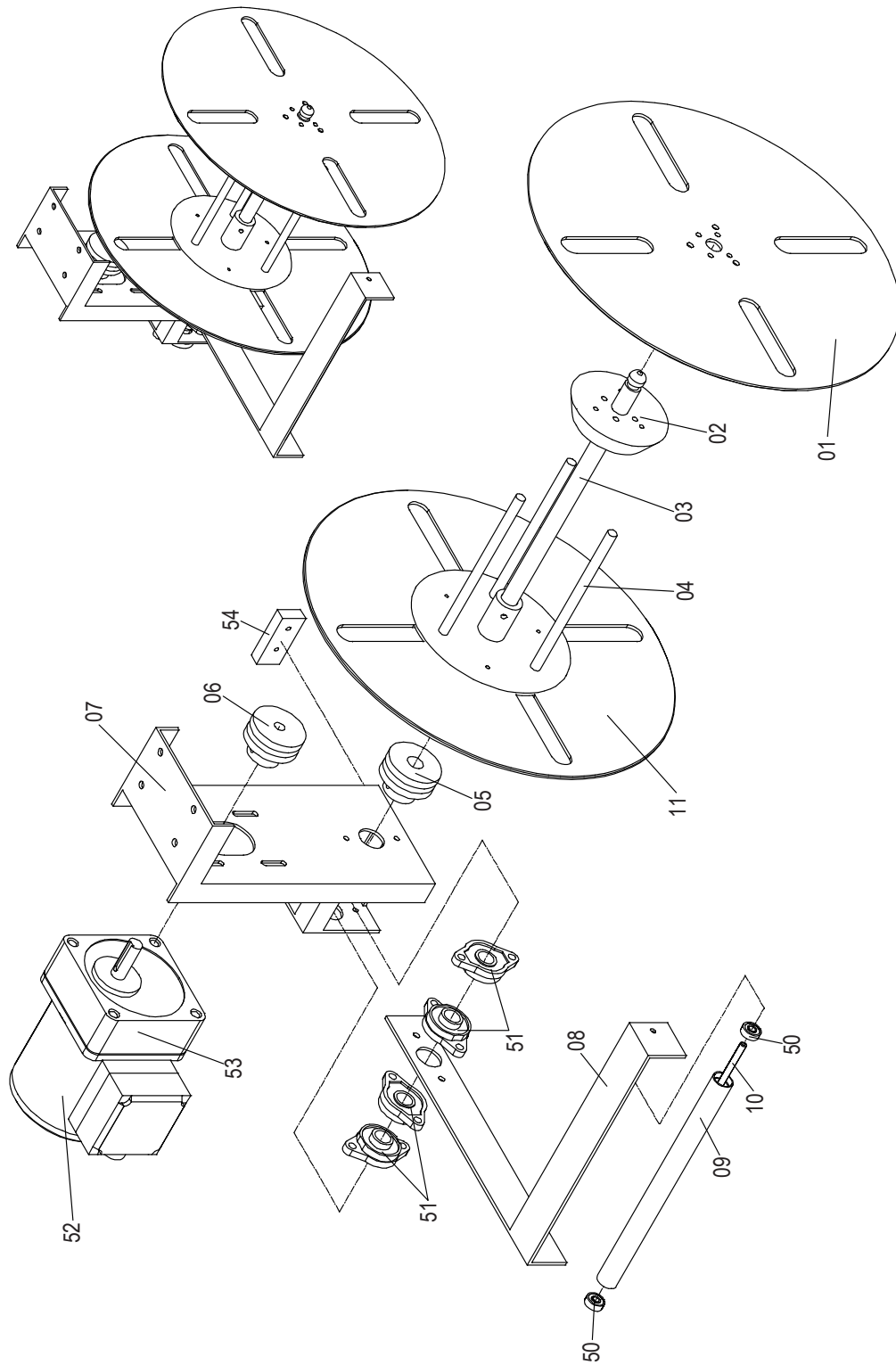
### Parts List – 504G(B-1 + B-2): (B1 = 1-28; 50-51); (B2 = 52-59)

| ITEM | PART NO.  | DESCRIPTION  | Q'TY |
|------|-----------|--|------|
| 1    | 504G-BP01 | Frame, Intake Conveyor                               | 1    |
| 2    | 504G-BP16 | Inverter Triangle, Lower                             | 1    |
| 3    | 504G-BP16 | Frame Member, Intake Conveyor, Support               | 3    |
| 4    | 504G-BP02 | Bracket, Intake Conveyor Adjustment                  | 1    |
| 5    | 504G-BP08 | Cover, Conveyor Motor / Pulley                       | 1    |
| 6    | 504G-BP13 | Bracket, Horizontal Sensor, Adjustable               | 2    |
| 7    | 504G-BP12 | Plate, Sensor Attachment                             | 2    |
| 8    | 504G-BP11 | Bracket, Vertical Sensor, Adjustable                 | 1    |
| 9    | 504G-BM01 | Screw, Intake Conveyor Width Adjustment              | 1    |
| 10   | 504G-BP05 | Pan, Conveyor Support, Bottom                        | 1    |
| 11   | 504G-BP03 | Pan, Conveyor Support Top                            | 1    |
| 12   | 504G-BP10 | Bracket, Sensor Mounting                             | 1    |
| 13   | 504G-BP18 | Bracket, Flat, Inverter Height Indicator             | 1    |
| 14   | 504G-BP15 | Inverter Triangle, Upper                             | 1    |
| 15   | 504G-BP19 | Scale, Index   | 1    |
| 16   | 504G-BP14 | Plate, Top, Triangle Height Adjustment               | 1    |
| 17   | 504G-BM08 | Plate, Raise / Lower, Inverter Height Adjustment     | 1    |
| 18   | 504G-BM10 | Plate, Base, Inverter Height Adjustment              | 1    |
| 19   | 504G-BM03 | Shaft, Linear Guide, Inverter Height Adjustment      | 2    |
| 20   | 504G-BM02 | Screw, Drive, Inverter Height Adjustment             | 1    |
| 21   | 504G-BP20 | Scale, Index   | 1    |
| 22   | 504G-BP06 | Bracket, Motor Mounting                              | 1    |
| 23   | 504G-BM11 | Plate, Intake Conveyor Side                          | 2    |
| 24   | 504G-BC01 | Roller, Drive, Intake Conveyor                       | 1    |
| 25   | 504G-BM07 | Roller, Intake Conveyor                              | 3    |
| 26   | 504G-BM05 | Axle, Intake Conveyor Roller 2                       | 2    |
| 27   | 504G-BM04 | Axle, Intake Conveyor Roller 1                       | 4    |
| 28   | 504G-BM06 | Axle, Intake Conveyor Roller 3                       | 1    |
| 50   | LMF20LUU  | Linear Bearing, Vertical, Inverter Height Adjustment | 2    |
| 51   | E3R-5E4   | Sensor, Set  | 2    |

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| ITEM | PART NO.     | DESCRIPTION  | Q'TY |
|------|--------------|--------------|------|
| 52   | UFL002       | Bearing      | 1    |
| 53   | UFL002       | Bearing      | 2    |
| 54   | 6200ZZ       | Bearing      | 6    |
| 55   | RS35,43R     | Roller Chain | 1    |
| 56   | RS35,14T     | Gear Wheel   | 1    |
| 57   | RS35,15T     | Gear Wheel   | 1    |
| 58   | 5GU15K       | Gearbox      | 1    |
| 59   | 5IK60GU-CWTE | Motor        | 1    |

# VSA1721-TK-V1 Scrap Take-Up Spool and Tensioner

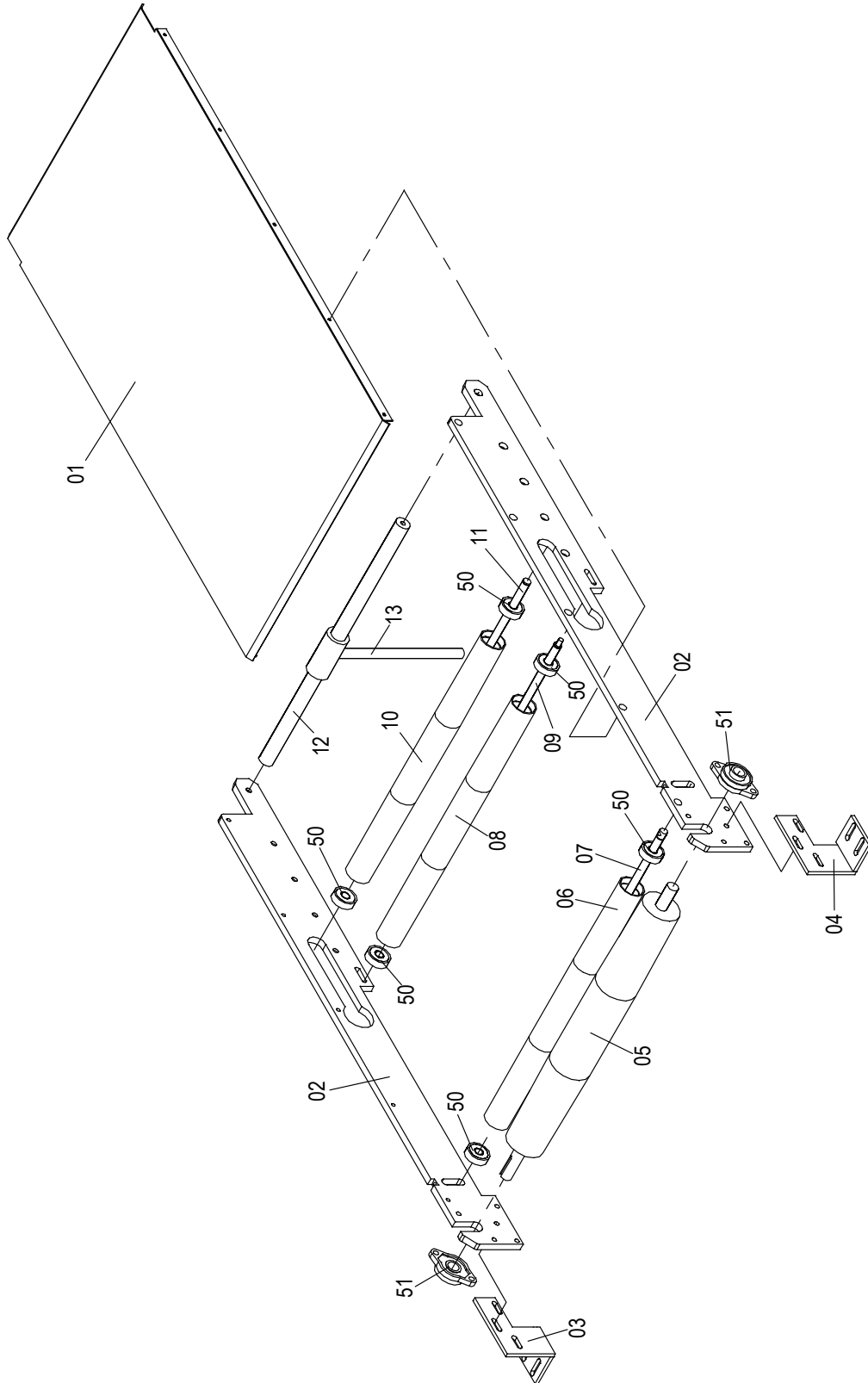


## VSA1721-TK-V1 Scrap Take-Up Spool and Tensioner

### Parts List – 504G(C-1)

| ITEM | PART NO.    | DESCRIPTION                       | Q'TY |
|------|-------------|-----------------------------------|------|
| 1    | 504G-CC01   | Spool Board, Outer Disk           | 1    |
| 2    | 504G-CM04   | Seat Disk, Outer Spool Attachment | 1    |
| 3    | 504G-CM03   | Axle, Main Spool                  | 1    |
| 4    | 504G-CP02   | Rod, Spool Draw                   | 1    |
| 5    | 504G-CM02   | Pulley, Drive, Spool              | 1    |
| 6    | 504G-CM01   | Pulley, Drive, Motor              | 1    |
| 7    | 504G-CP01   | Bracket, Spool and Motor          | 1    |
| 8    | 504G-CP03   | Bracket, Tensioner Roller         | 1    |
| 9    | 504G-CM07   | Roller, Tensioner                 | 1    |
| 10   | 504G-CM08   | Axle Shaft, Tensioner Roller      | 1    |
| 11   | 504G-CC02   | Spool Board, Inner Disk           | 1    |
| 50   | 606ZZ       | Bearing                           | 2    |
| 51   | UFL002      | Bearing                           | 4    |
| 52   | 3RK15GN-CWE | Motor                             | 1    |
| 53   | 3GN25L      | Gearbox, Drive Motor              | 1    |
| 54   | Z-15GQ-B    | Switch, Sensor                    | 1    |

# VSA1721-TK-V1 Conveyor, Take-Away

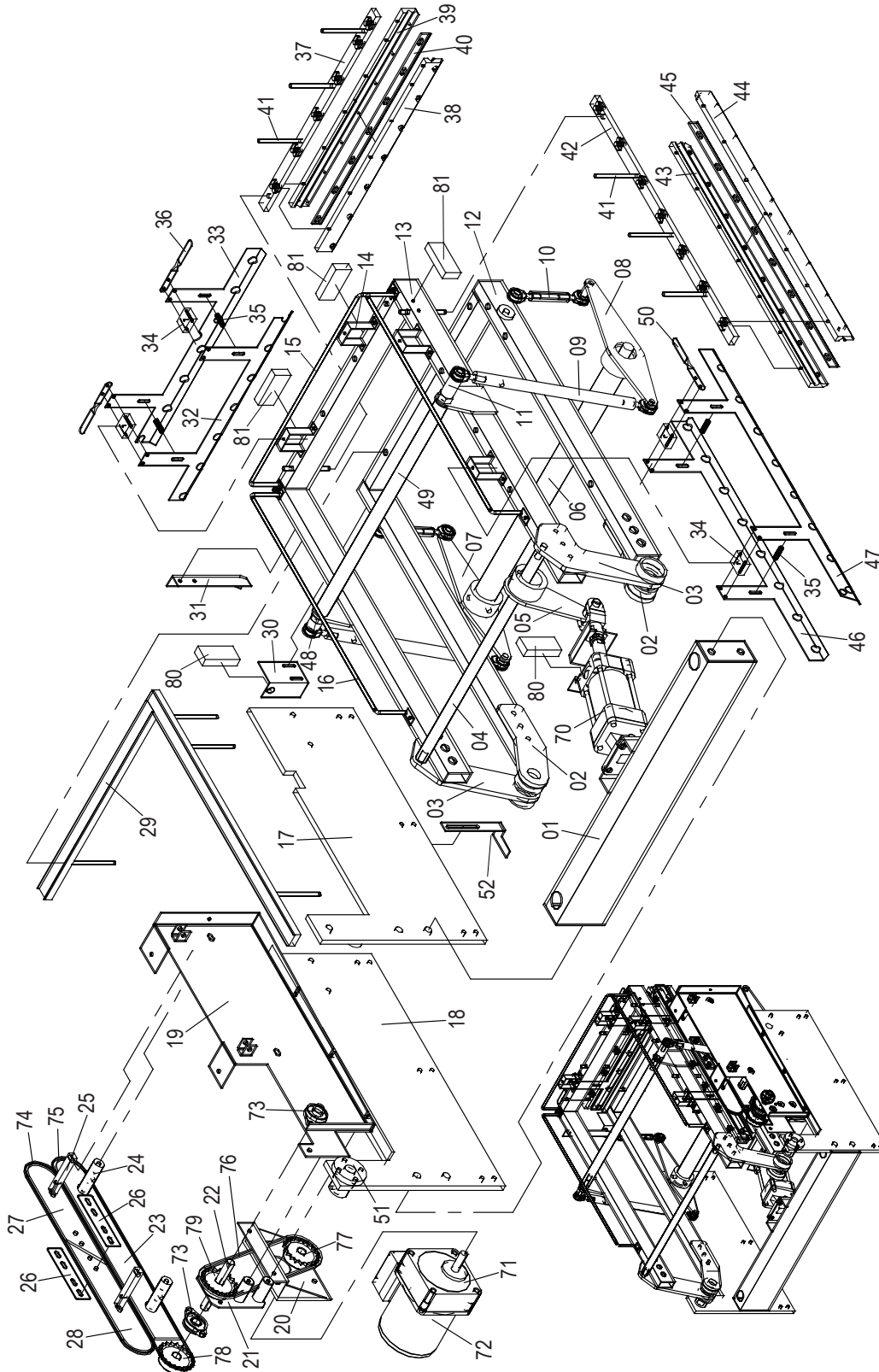


## VSA1721-TK-V1 Conveyor, Take-Away

### Parts List – 504G(D-1)

| ITEM | PART NO.  | DESCRIPTION                              | Q'TY |
|------|-----------|--|------|
| 1    | 504G-DP01 | Conveyor Support Pan, Take-Away Conveyor | 1    |
| 2    | 504G-DM12 | Conveyor Side Plate, Take-Away Conveyor  | 2    |
| 3    | 504G-DP04 | Bracket, Conveyor Mount, Right           | 1    |
| 4    | 504G-DP03 | Bracket, Conveyor Mount, Left            | 1    |
| 5    | 504G-BC01 | Drive Roller                             | 1    |
| 6    | 504G-DM02 | Roller, Conveyor                         | 1    |
| 7    | 504G-DM03 | Axle Shaft, Roller                       | 1    |
| 8    | 504G-DM02 | Roller, Conveyor 2                       | 1    |
| 9    | 504G-DM04 | Axle Shaft, Roller 2                     | 1    |
| 10   | 504G-DM02 | Roller, Conveyor, 1                      | 2    |
| 11   | 504G-DM01 | Axle Shaft, Roller 1                     | 1    |
| 12   | 504G-DM05 | Connecting Rod, Conveyor Support         | 1    |
| 13   | 504G-DM06 | Support Rod, Conveyor End                | 1    |
| 50   | 6200ZZ    | Bearing                                  | 6    |
| 51   | UFL002    | Bearing                                  | 2    |

# VSA1721-TK-V1 L-Sealer





## VSA1721-TK-V1 L-Sealer

Parts List – 504G(E+F-1, 2, 3): (F-1 = 1-30); (F-2 = 31-52;70-77); (F-3 = 78-81)

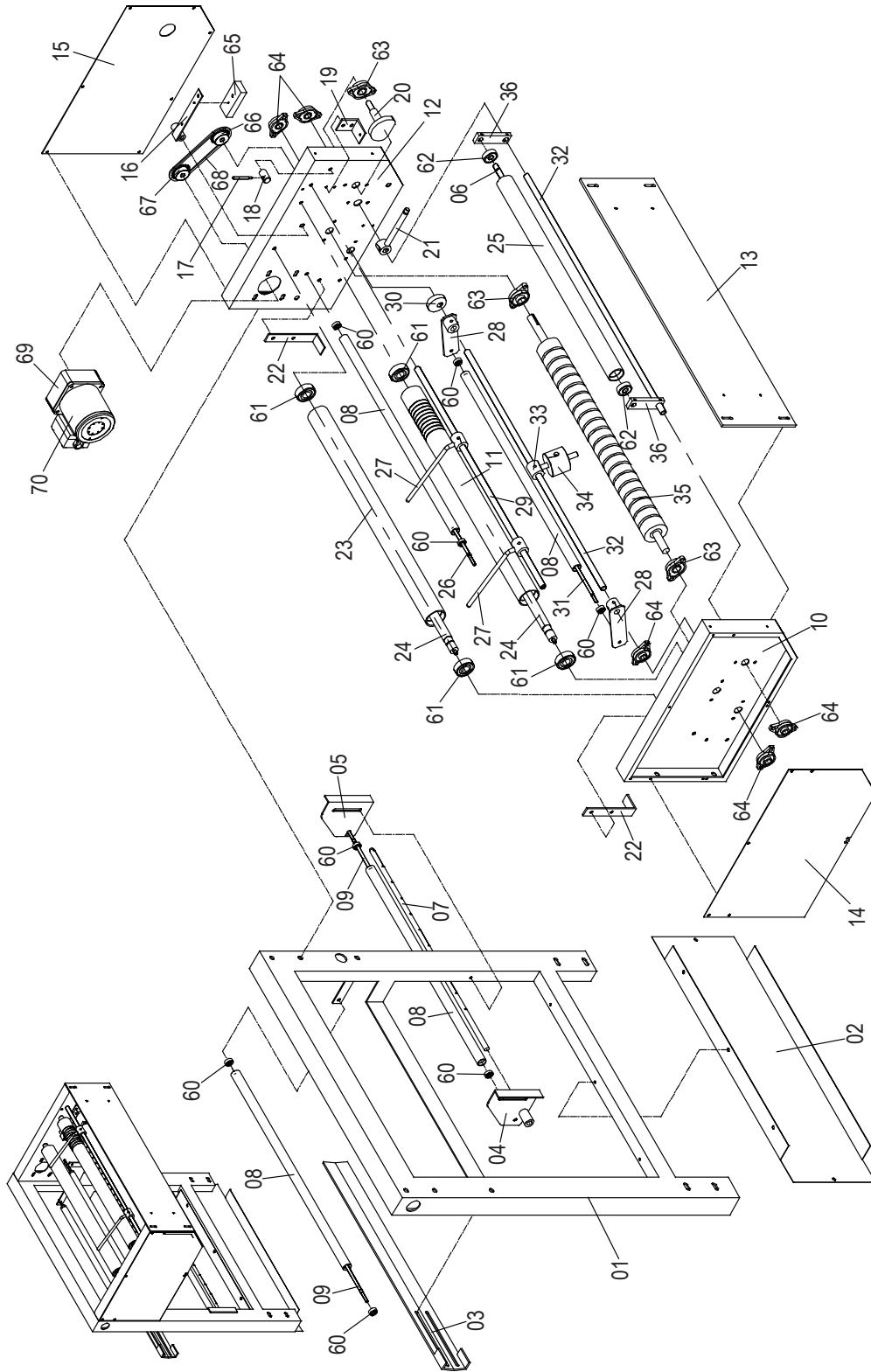
| ITEM | PART NO.  | DESCRIPTION                                     | Q'TY |
|------|-----------|---|------|
| 1    | 504G-EP18 | Bracket, Box Crossmember and Air Cylinder Mount | 1    |
| 2    | 504G-EP04 | Seal Arm Linkage Hinge Bracket, Lower           | 2    |
| 3    | 504G-EP03 | Seal Arm Linkage Hinge Bracket, Upper           | 2    |
| 4    | 504G-EM17 | Cross Shaft, Air Cylinder Actuation             | 1    |
| 5    | 504G-EM09 | Actuator Bracket, Air Cylinder Connection       | 1    |
| 6    | 504G-EM08 | Axle, Swing Arm Pivot                           | 1    |
| 7    | 504G-EM11 | Swing Arm Pivot, Rear                           | 1    |
| 8    | 504G-EM10 | Swing Arm Pivot, Front                          | 1    |
| 9    | 504G-EM12 | Seal Arm Connecting Rod, Long, Upper Linkage    | 2    |
| 10   | 504G-EM13 | Lower Jaw Connecting Rod, Short, Lower Linkage  | 2    |
| 11   | 504G-EM15 | Shaft Collar, Right Side                        | 1    |
| 12   | 504G-EP02 | Lower Seal Frame                                | 1    |
| 13   | 504G-EP01 | Upper Seal Frame                                | 1    |
| 14   | 504G-EP10 | Bracket, Limit Sensor                           | 4    |
| 15   | 504G-EP13 | Top Rail, Seal Head, End                        | 1    |
| 16   | 504G-EP12 | Top Rail, Seal Head, Side                       | 2    |
| 17   | 504G-EP17 | Plate, Side, Rear                               | 1    |
| 18   | 504G-EP16 | Plate, Side, Front                              | 1    |
| 19   | 504G-FP01 | Pan Bracket, Drive Chain Support, Front         | 1    |
| 20   | 504G-EP05 | Bracket, Motor / Drive Chain Mounting           | 1    |
| 21   | 504G-EP02 | Bracket, Drive Chain Drive Sprocket             | 1    |
| 22   | 504G-FM06 | Axle Shaft, Drive Chain Drive Sprocket          | 1    |
| 23   | 504G-FM04 | Plate, Drive Chain Support, Bottom              | 1    |
| 24   | 504G-FM05 | Tube, Cylinder, Lower Chain Plate Mounting      | 2    |
| 25   | 504G-FM01 | Tube, Square, Upper Chain Plate Mounting        | 2    |
| 26   | 504G-FP03 | Joining Plate, Split Upper Chain Plate Halves   | 2    |
| 27   | 504G-FM02 | Plate, Drive Chain Support, Top Left Half       | 1    |
| 28   | 504G-FM03 | Plate, Drive Chain Support, Top Right Half      | 1    |
| 29   | 504G-FP09 | Seal Bottom Seat                                | 1    |
| 30   | 504G-EP23 | Bracket, Sensor                                 | 1    |

| ITEM | PART NO.            | DESCRIPTION  | Q'TY |
|------|---------------------|--|------|
| 31   | 504G-EP22           | Bracket, Retainer Plate 1                              | 1    |
| 32   | 504G-EP05           | Bracket, Sealer Support, Inside, Transverse Direction  | 1    |
| 33   | 504G-EP06           | Bracket, Sealer Support, Outside, Transverse Direction | 1    |
| 34   | 504G-EM26           | Spacer Block, Sealer Brackets                          | 4    |
| 35   | 504G-EM25           | Spacer Tube, Sealer Brackets                           | 4    |
| 36   | 504G-EP11           | Actuator, Sensor                                       | 2    |
| 37   | 504G-EM01           | Bracket, Sealer Channel, Transverse Direction          | 1    |
| 38   | 504G-EM04           | Sealer Guard, Inside, Transverse Direction             | 1    |
| 39   | 504G-EM03           | Sealer Guard, Outside, Transverse Direction            | 1    |
| 40   | 504G-EM23           | Sealer Knife, Transverse Direction                     | 1    |
| 41   | 504G-EM07           | Rod, Sealer Channel Support                            | 8    |
| 42   | 504G-EM02           | Bracket, Sealer Channel, Machine Direction             | 1    |
| 43   | 504G-EM06           | Sealer Guard, Inside, Machine Direction                | 1    |
| 44   | 504G-EM05           | Sealer Guard Outside, Machine Direction                | 1    |
| 45   | 504G-EM24           | Sealer Knife, Machine Direction                        | 1    |
| 46   | 504G-EP07           | Bracket, Sealer Support, Inside, Machine Direction     | 1    |
| 47   | 504G-EP08           | Bracket, Sealer Support, Outside, Machine Direction    | 1    |
| 48   | 504G-EM14           | Shaft Collar Left Side                                 | 1    |
| 49   | 504G-EM16           | Cross Shaft, Sealer Upper Jaw, Swing Arm Connection    | 1    |
| 50   | 504G-EP11           | Actuator, Sensor                                       | 1    |
| 51   | 504G-EM28           | Flange, Motor Shaft Support                            | 1    |
| 52   | 504G-EP26           | Bracket, Limit Switch Activation                       | 1    |
| 70   | AL-CACB-63,ϕX65ST-M | Air Cylinder, Aluminum Alloy                           | 1    |
| 71   | 5GN15L              | Gearbox  | 1    |
| 72   | 5RK40GN-CWME        | Motor  | 1    |
| 73   | UFL002              | Bearing  | 1    |
| 74   | RS35,102R           | Roller Chain   | 1    |
| 75   | RS35,118R           | Roller Chain   | 1    |
| 76   | RS35,49R            | Roller Chain   | 1    |
| 77   | RS35, 11T           | Gear Wheel / Roller Chain Sprocket, 11 Tooth           | 1    |
| 78   | RS35,20T            | Gear Wheel / Roller Chain Sprocket, 20 Tooth           | 1    |
| 79   | RS35,13T            | Gear Wheel / Roller Chain Sprocket, 13 Tooth           | 1    |
| 80   | Z-15GQ22-B          | Switch   | 2    |

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| ITEM | PART NO.   | DESCRIPTION | Q'TY |
|------|------------|-------------|------|
| 81   | Z-15GW22-B | Switch      | 3    |

# VSA1721-TK-V1 Film Roll Unwinder with Perforator



## VSA1721-TK-V1 Film Roll Unwinder with Perforator

Parts List – 504G(G-1, 2): (G-1 = 1-30); (G-2 = 31-36; 60-70)

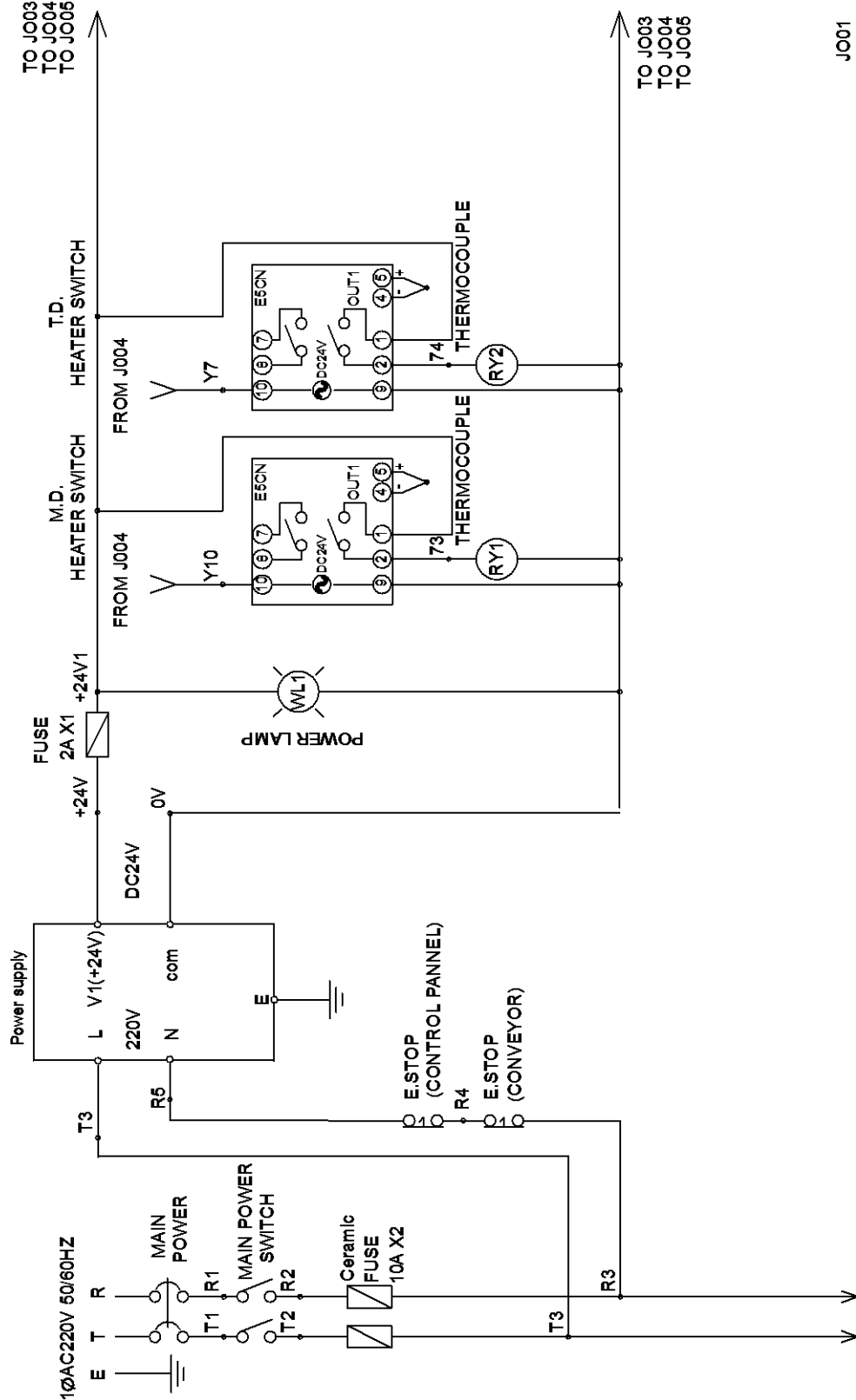
| ITEM | PART NO.      | DESCRIPTION                                     | Q'TY |
|------|---------------|---|------|
| 1    | 504G-GP01     | Frame, Weldment Main Vertical, Rear             | 1    |
| 2    | 504G-GP10     | Panel, Rear Bottom                              | 1    |
| 3    | 504G-GP07     | Film Separator                                  | 1    |
| 4    | 504G-GP09     | Bracket, Lower Rear Film Rollers, Right         | 1    |
| 5    | 504G-GP18     | Bracket, Lower Rear Film Rollers, Left          | 1    |
| 6    | 504G-GM21     | Axle, Film Roller                               | 1    |
| 7    | 504G-GM18     | Wand, Anti-Static                               | 1    |
| 8    | 504G-GM14     | Roller, Film, Dancer and Rear                   | 4    |
| 9    | 504G-GM16     | Axle, Film Roller, Rear                         | 2    |
| 10   | 504G-GP03     | Inner Panel, Film Unwind, Top Left Hand Side    | 1    |
| 11   | 504G-GM03     | Roller, Film Unwind                             | 1    |
| 12   | 504G-GP02     | Inner Panel, Film Unwind, Top Right Hand Side   | 1    |
| 13   | 504(kyo)-GP05 | Panel, Cover, Front Film Unwind                 | 1    |
| 14   | 504(kyo)-GC01 | Outer Panel Cover, Film Unwind, Left-Hand Side  | 1    |
| 15   | 504G-GP04     | Outer Panel Cover, Film Unwind, Right-Hand Side | 1    |
| 16   | 504G-GP11     | Actuator, Switch                                | 1    |
| 17   | 504G-GM13     | Screw   | 1    |
| 18   | 504G-GM 12    | Dowel / Barrel Nut                              | 1    |
| 19   | 504G-GP13     | Angle Bracket                                   | 1    |
| 20   | 504G-GM 10    | Partial Circular Cam with Shaft 2               | 1    |
| 21   | 504G-GM11     | Rod End, Dancer Shaft Support                   | 1    |
| 22   | 504G-GP05     | Bracket,  | 1    |
| 23   | 504G-GM04     | Roller  | 1    |
| 24   | 504G-GM05     | Axle Shaft, Roller                              | 2    |
| 25   | 504G-GM22     | Roller  | 1    |
| 26   | LSA504G-GM 17 | Axle Shaft, Roller                              | 1    |
| 27   | 504G-GM02     | Film Guide                                      | 2    |
| 28   | 504G-GP06     | Bracket, Dancer / Counterweight Shaft           | 2    |
| 29   | 504G-GM01     | Shaft, Film Guide Support                       | 1    |
| 30   | 504G-GM09     | Eccentric Circular Cam 1                        | 1    |

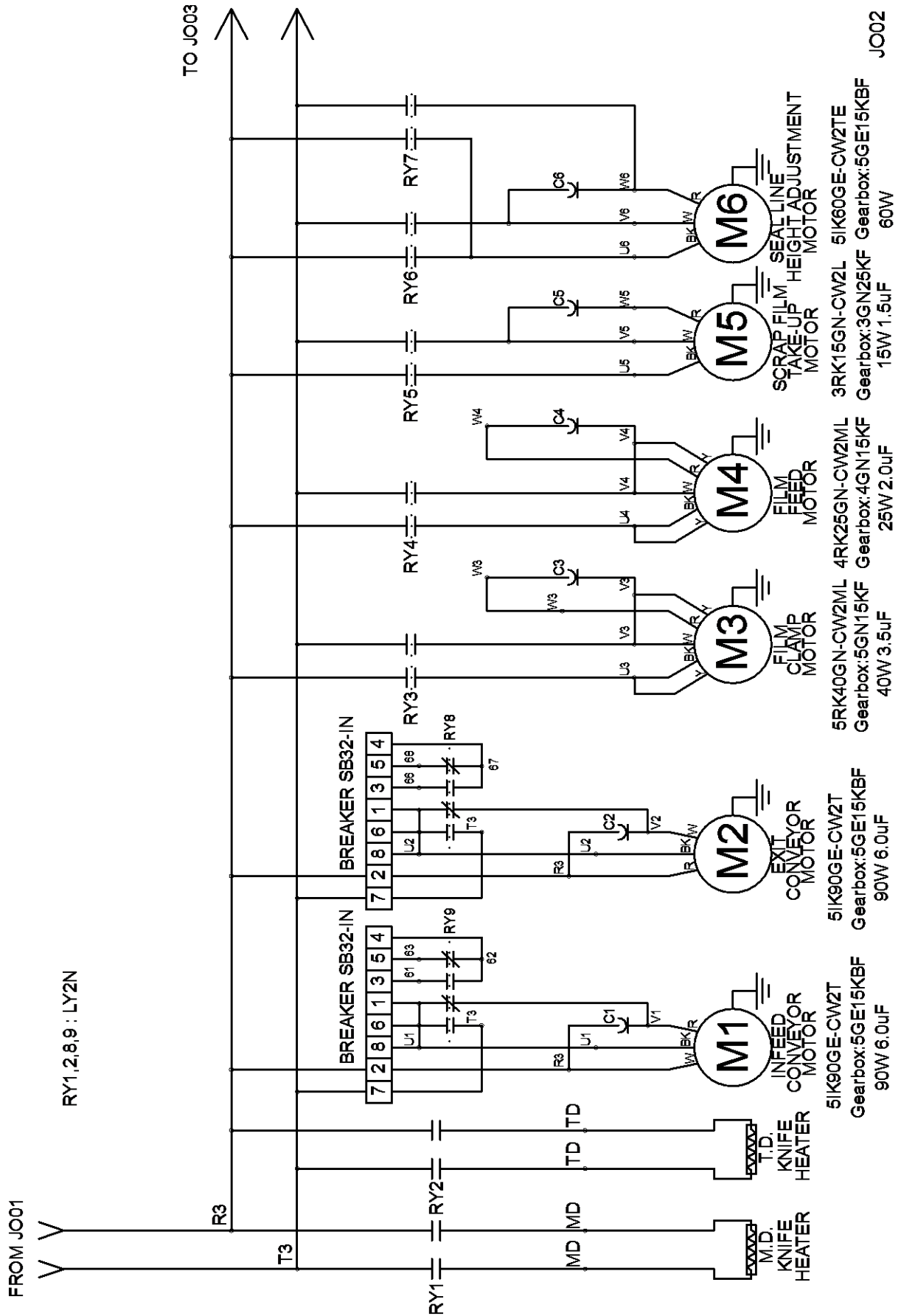
## 70 Parts List

| ITEM | PART NO.     | DESCRIPTION  | Q'TY |
|------|--------------|--|------|
| 31   | 504G-GM15    | Shaft, Dancer Roller Axle                              | 1    |
| 32   | 504G-GM06    | Rod, Roller Shaft                                      | 2    |
| 33   | 504G-GM08    | Bracket, Counterweight Attachment                      | 1    |
| 34   | 504G-GM07    | Counterweight, Dancer                                  | 1    |
| 35   | 504G-GC02    | Roller, Perforator                                     | 1    |
| 36   | 504G-GM19    | Bracket, Roller Lever                                  | 2    |
| 60   | 606ZZ        | Bearing  | 8    |
| 61   | 6203ZZ       | Bearing  | 4    |
| 62   | 6200ZZ       | Bearing  | 2    |
| 63   | UFL002       | Bearing  | 3    |
| 64   | UFL001       | Bearing  | 5    |
| 65   | Z-15GQ22-B   | Switch   | 1    |
| 66   | RS35,17T     | Gear Wheel / Roller Chain Sprocket, 35 pitch, 17 tooth | 1    |
| 67   | RS35,15T     | Gear Wheel / Roller Chain Sprocket, 35 pitch, 15 tooth | 1    |
| 68   | RS35,52R     | Roller Chain, 35 pitch, 52 roller                      | 1    |
| 69   | 4GN15L       | Gearbox  | 1    |
| 70   | 4RK25GN-CWME | Motor  | 1    |

# Appendix A: Electrical Schematics

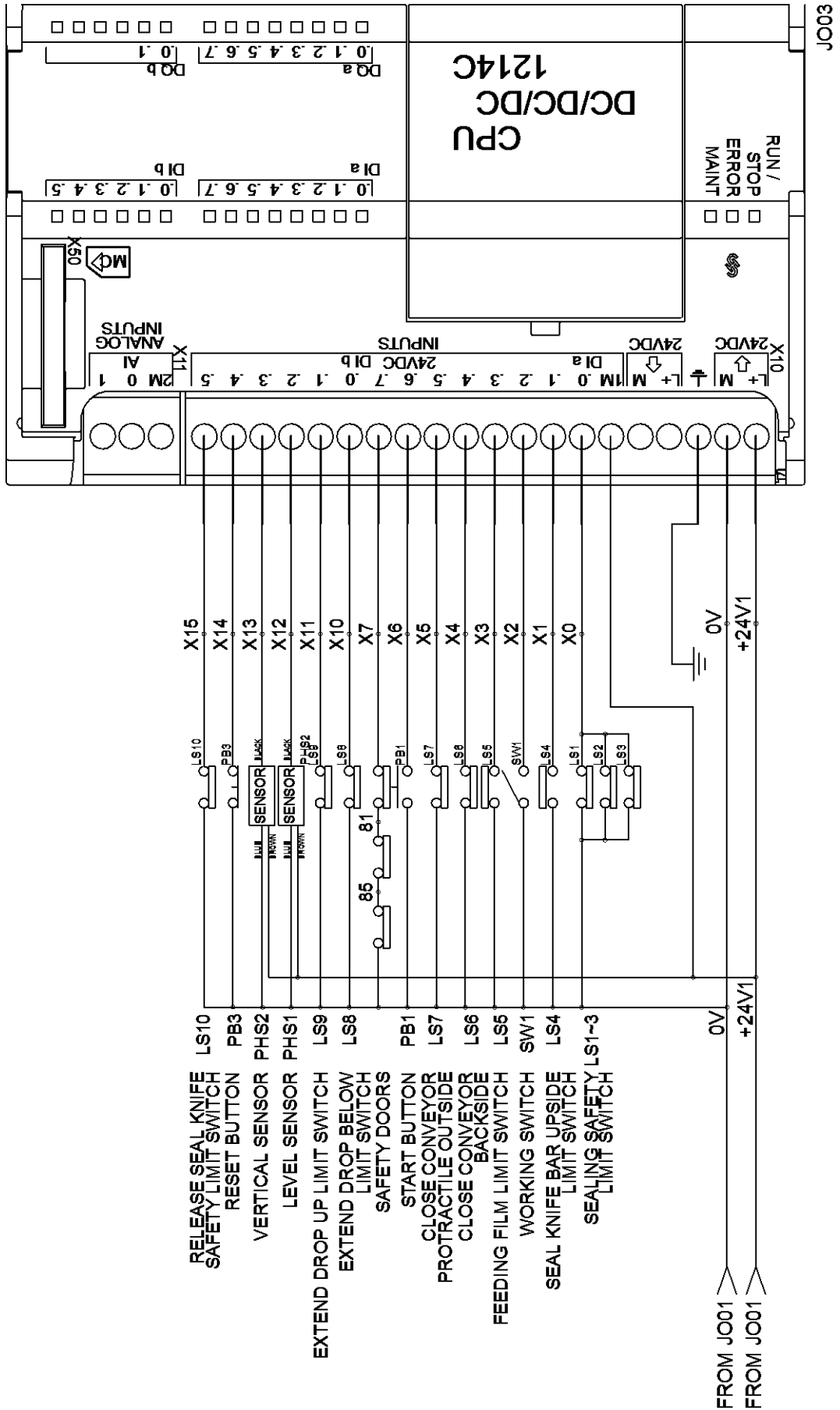
## Electrical Schematics

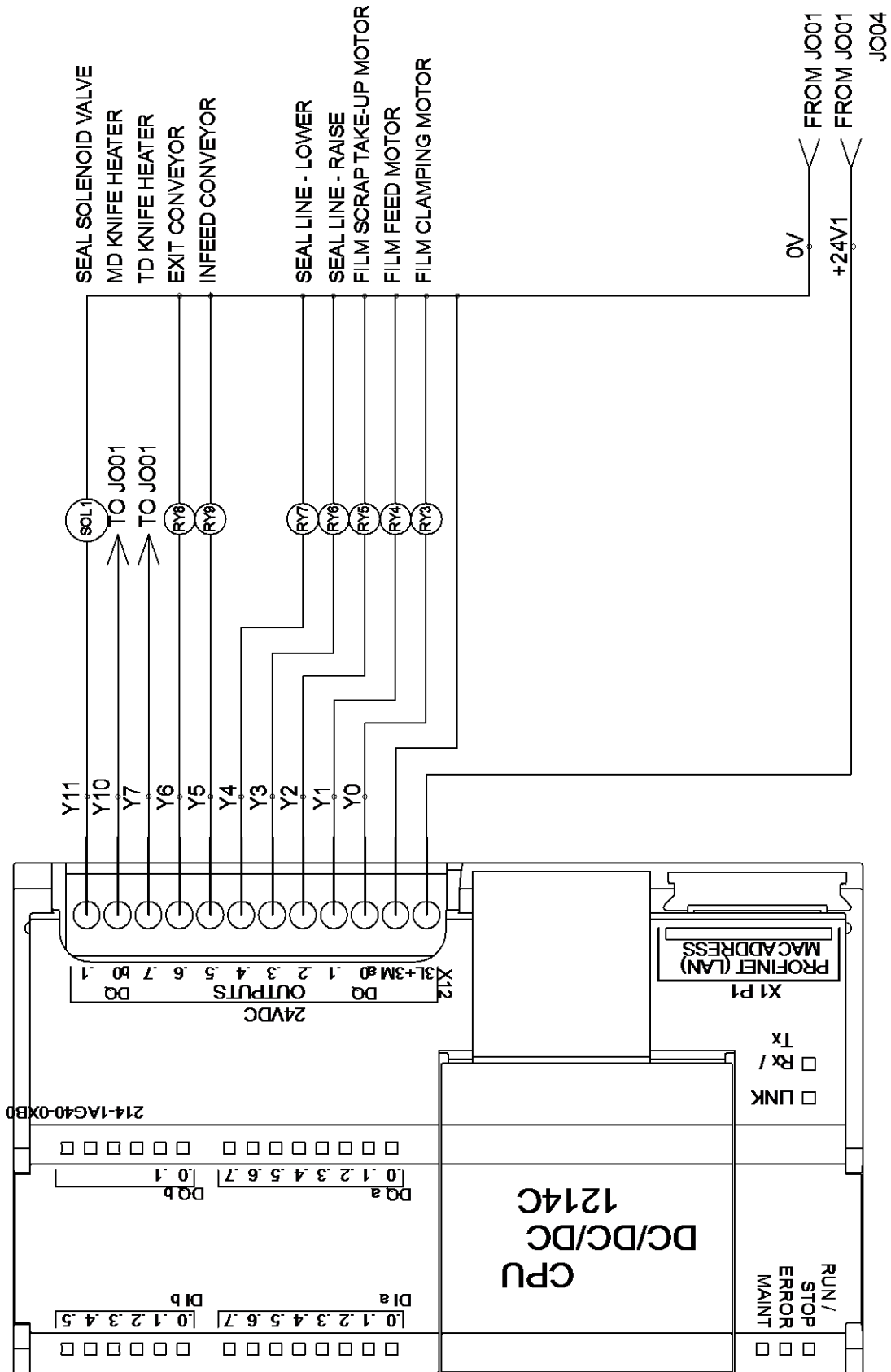


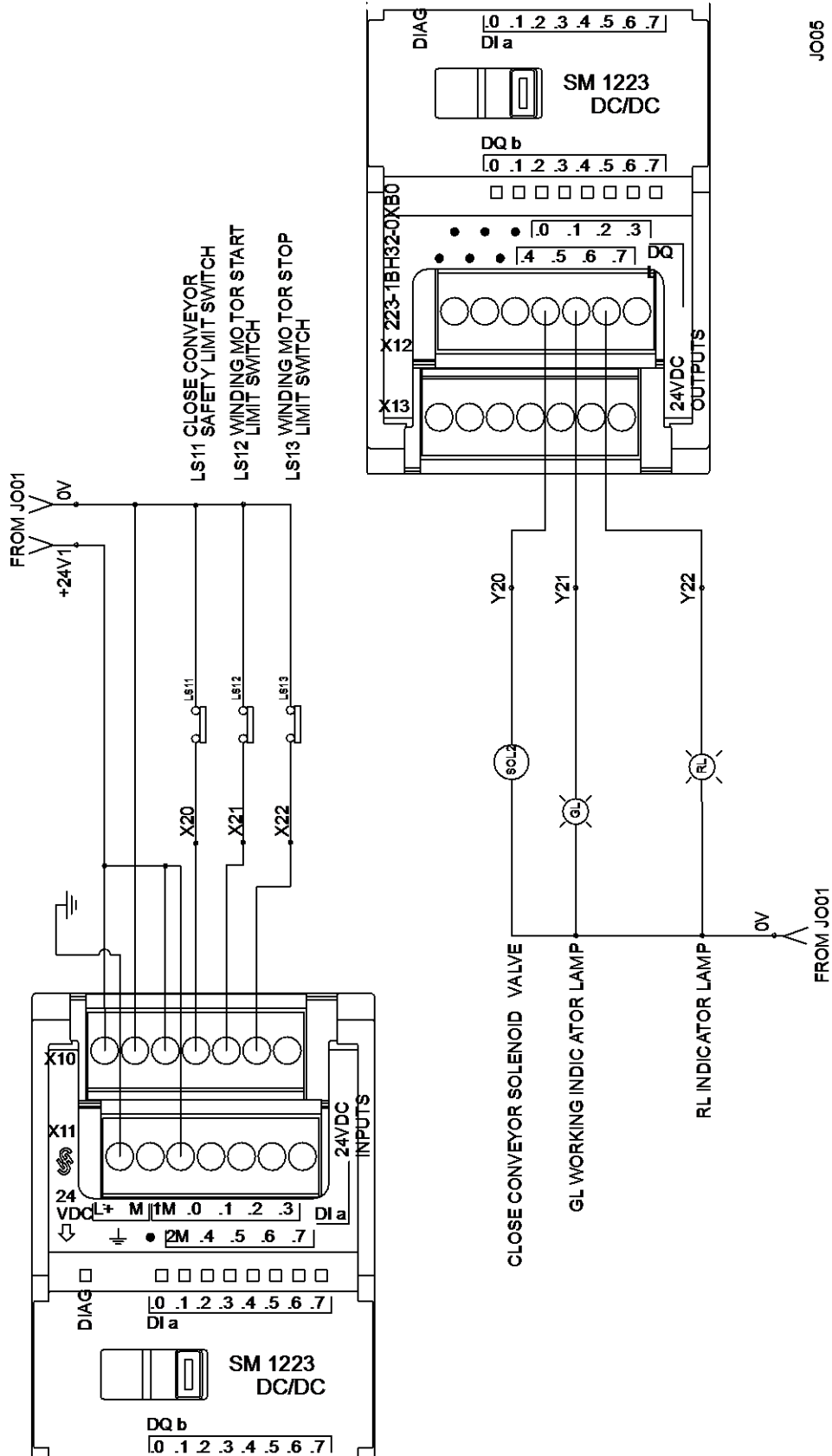


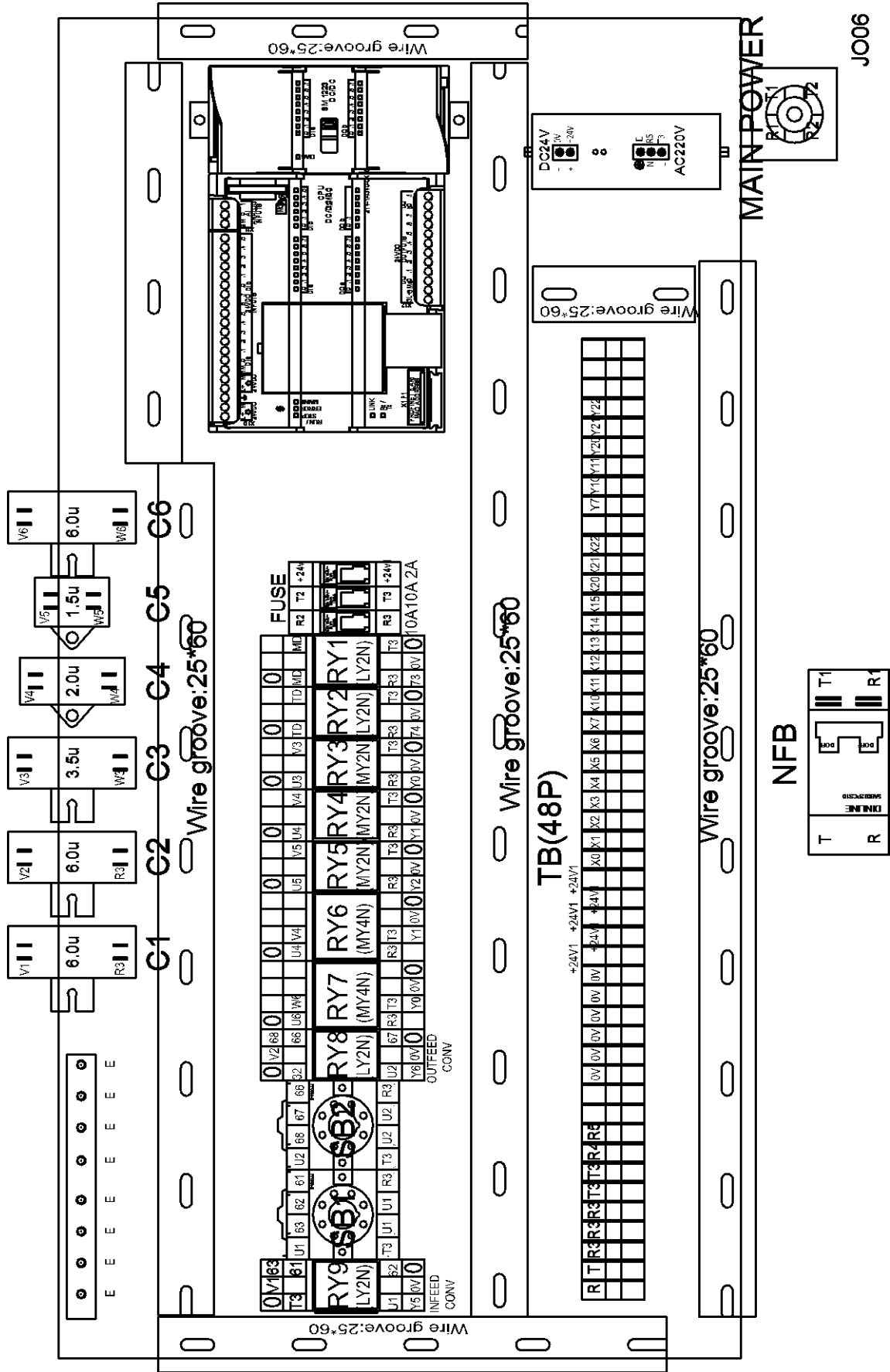
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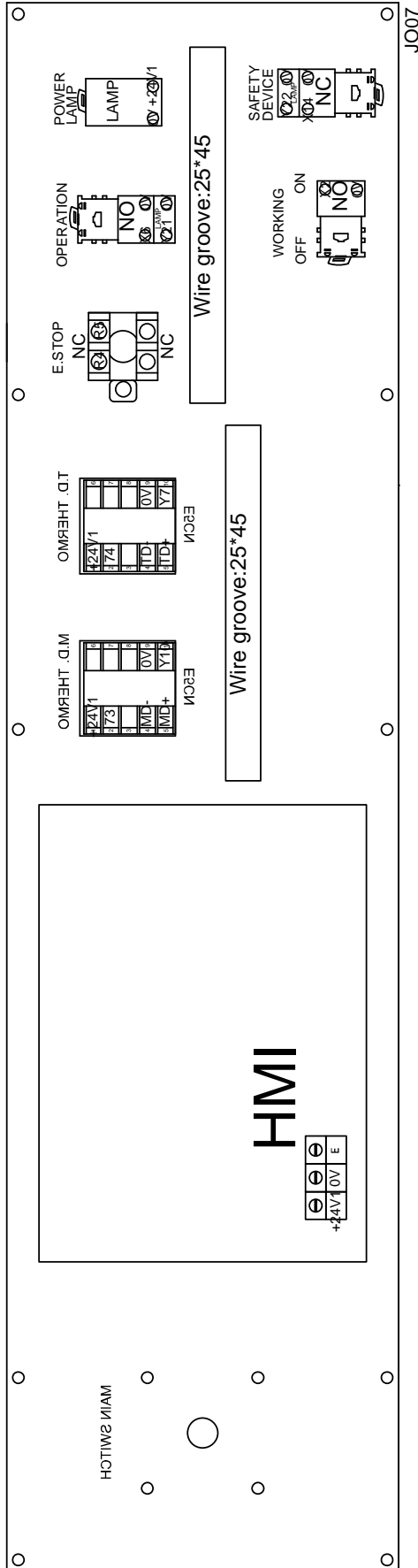


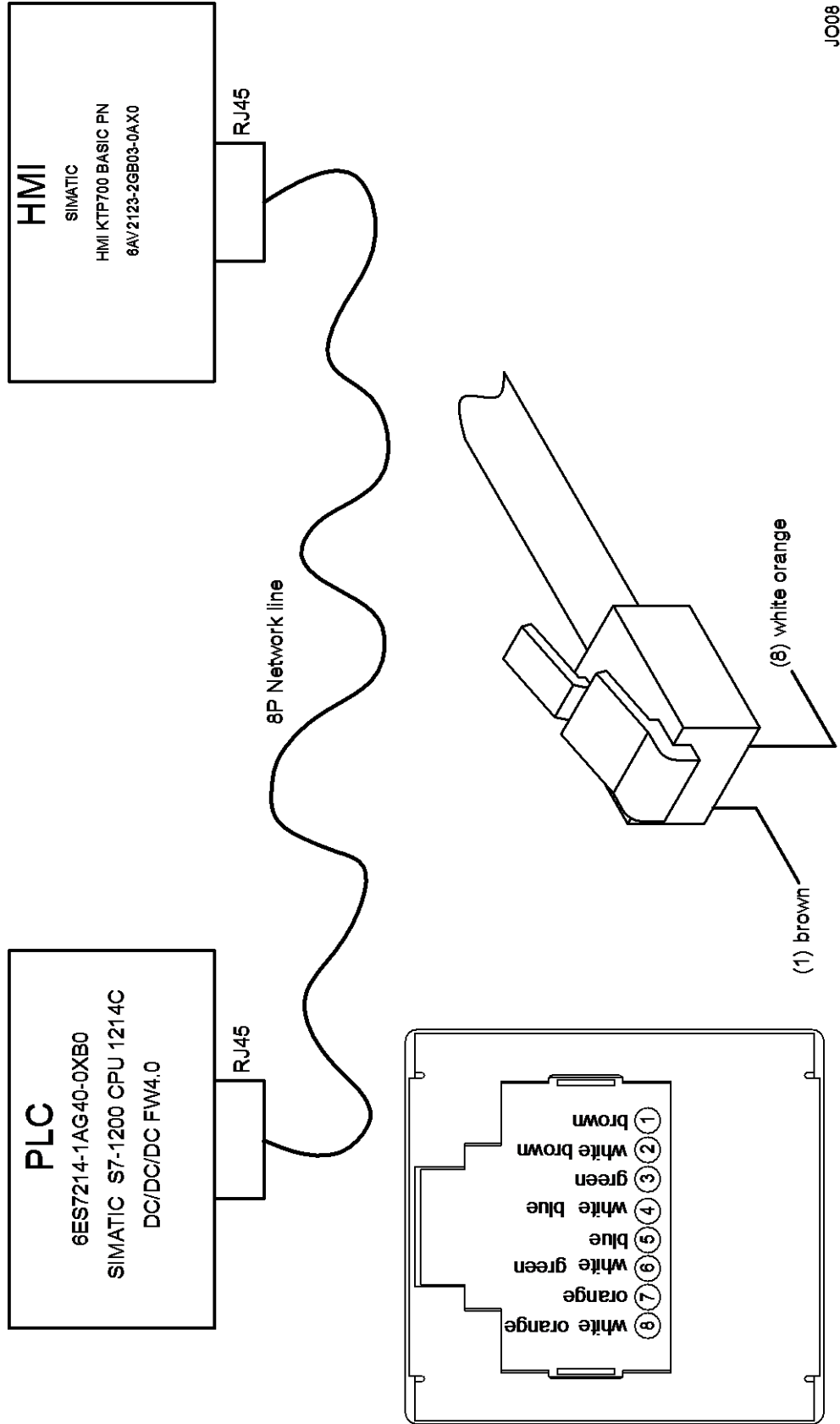




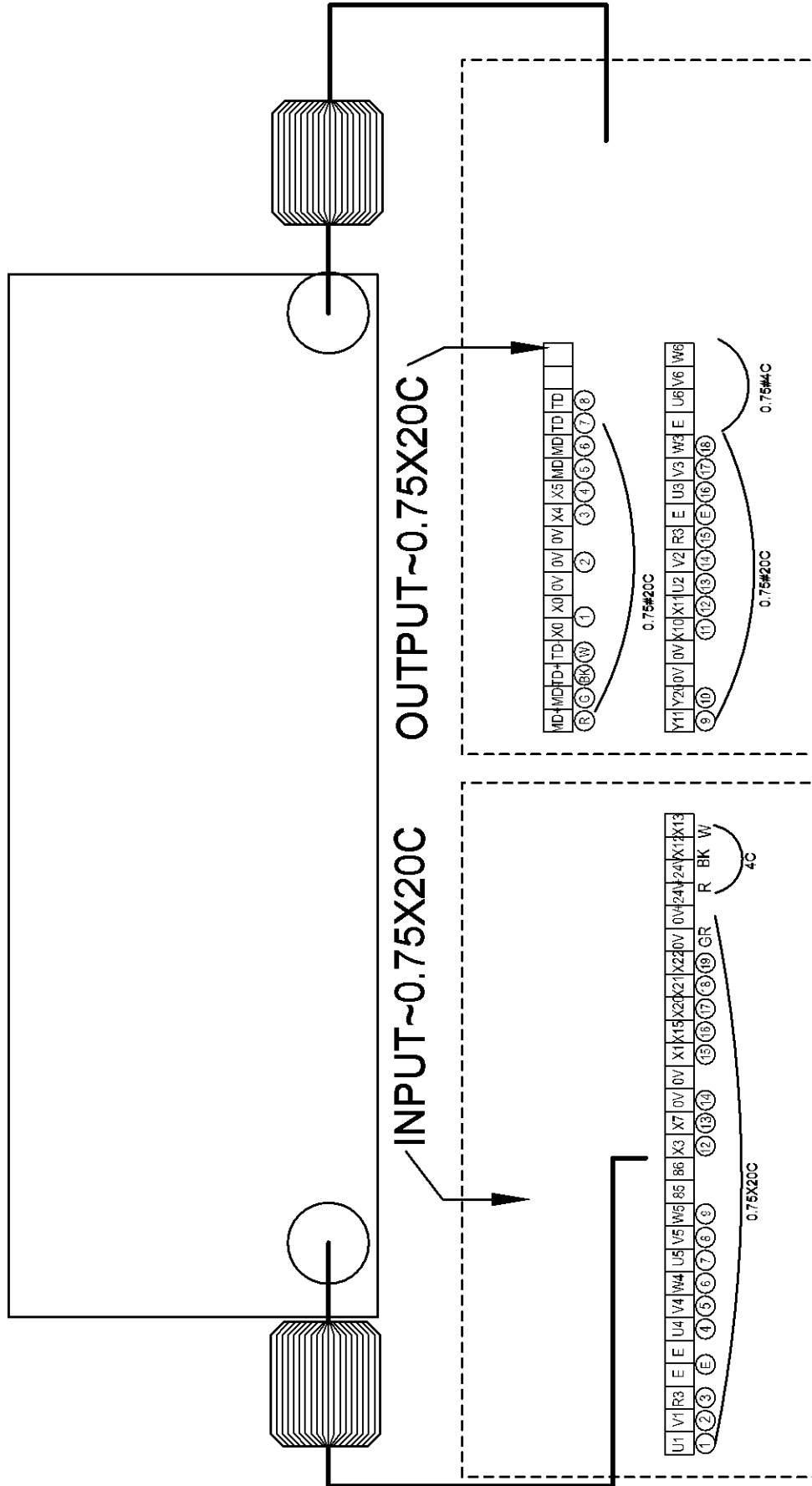






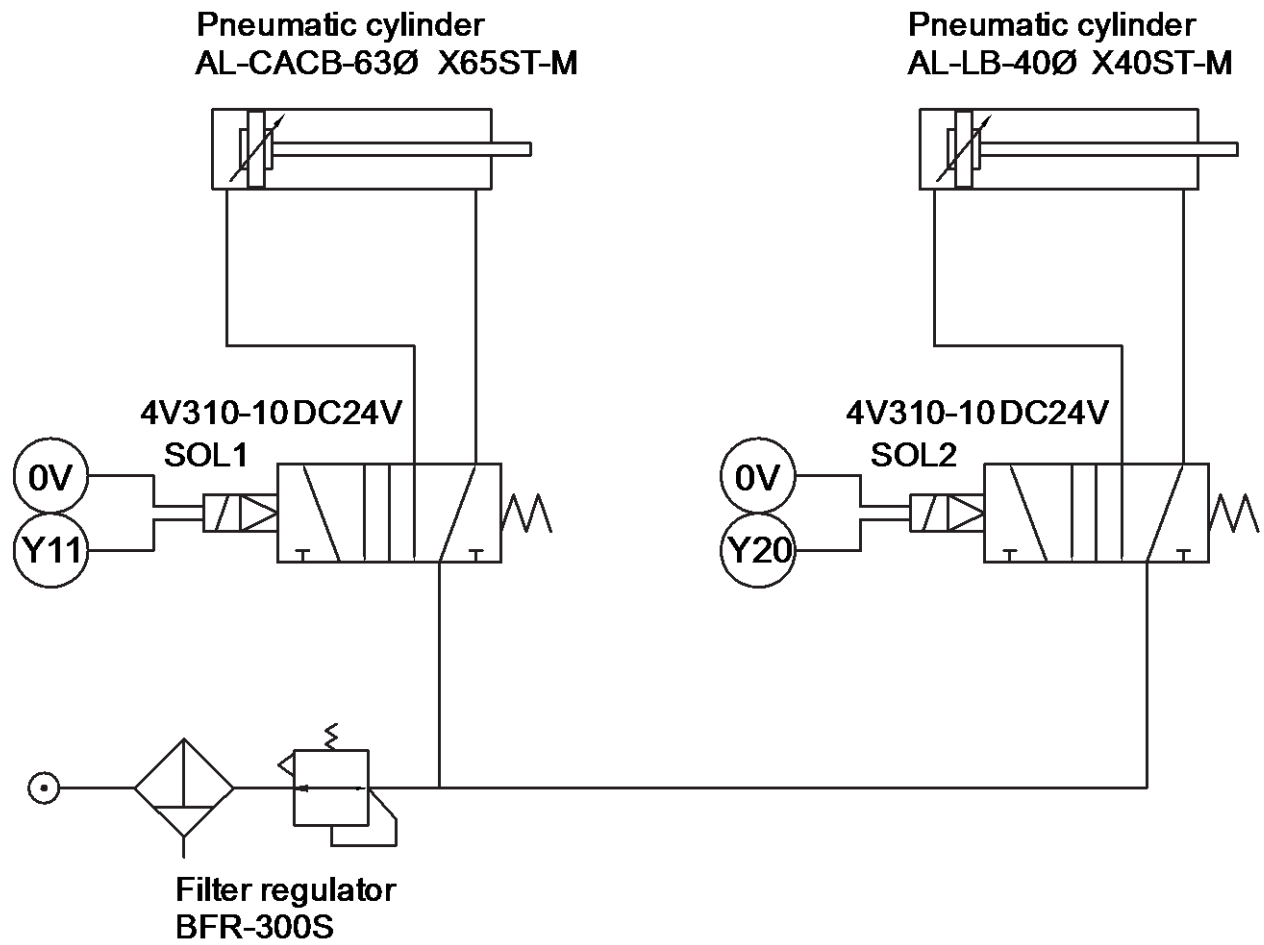


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# Appendix B: Air Diagram

## Pneumatic Schematic





## **Appendix C: Temperature Setting Specifications for Shrink-Wrap Plastics**

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

# Warranty Statement

## VSA Value Series Semi-Automatic L-Sealers

### 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 two (2) years from the date of shipment by Eastey and will conform to the published specifications for that product. Spare parts that are manufactured in house by Eastey will be warranted for two (2) years. Bought out parts will be warranted for one (1) year.

### Warranty Period – Specific Items

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

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

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

### Sealing Quality

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

### Shipping Policy

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

### Warranty Verification

If you conclude that a product may be defective and may be covered by warranty, obtain a Return Material Authorization number by calling our technical support number (toll free at 1-800-835-9344, or 763-428-4846 or Fax: 763-795-8867 or e-mail: info@eastey.com). 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 not be 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 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 HAS BEEN ADVISED OF THE POSSIBILITY OF SUCH DAMAGES.

# Customer Support

## Eastey Technical Service

For help setting up or operating the VSA Value 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          | <a href="mailto:info@eastey.com">info@eastey.com</a> |
| Web             | <a href="http://www.eastey.com">www.eastey.com</a>   |

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



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