

# SERVICE MANUAL



**Model 4-PP76ST**

**Get Packed Pty Ltd  
P.O. Box 898  
Artarmom NSW 1570  
(02) 9452 3566  
[www.getpacked.com.au](http://www.getpacked.com.au)**

---

INSTRUCTIONS FOR OPERATION AND REPAIR OF THE  
PREFERRED PACK 4-PP76ST SEALER

## 4-PP76ST Sealer Service Manual

---

### **IMPORTANT - PLEASE READ THIS CAREFULLY**

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 significance than our designs. Only properly trained individuals following rigidly enforced safety rules, as recommended by A.N.S.I. and O.S.H.A., should be allowed to operate these machines.

## 4-PP76ST Sealer Service Manual

---

### **SAFETY PRECAUTIONS**

1. To avoid damage to the machine and injury to the operator, DO NOT use liquids of any kind: flammable materials, explosive materials, materials under extreme pressure, pressurized gases, volatile powders, or bulk materials that could fall through holes in grate, or any materials and or products not listed but which could cause harm to operator.
2. Do not touch the band ribbon soon after sealing due to residual heat that may burn.
3. Do not touch the heater cover plate while machine is on.
4. Do not touch the fan while in operation or use machine without grate in place.

**4-PP76ST Sealer Service Manual**

---

---

**TABLE OF CONTENTS**

---

**Preface**

Unpacking	5 - 8
Warranty Notice	9
Warranty	10-11
Warranty Exceptions	12
Warnings	13-15

**Chamber Machine Section**

Description and Specifications	16
Installation and Basic Set-Up	17-23
Film Threading Diagram	24
Front Panel Diagram	25-27
Sequence of Operation	28-34
Troubleshooting Chart	35-47
Maintenance	48-57
Electrical Schematic	58
Parts List	59-62

## 4-PP76ST Sealer Service Manual

---

### UNPACKING

#### THOROUGHLY INSPECT EQUIPMENT UPON ARRIVAL.

If goods are received short or in a damaged condition, it is important that you notify the carrier's driver **before he leaves your company** and **insist** on a notation of the loss or damage across the face of the freight bill. Unless this is done, no claim can be enforced against the transportation company.

If concealed loss or damage is discovered, notify the carrier at once and **insist** on an inspection. This is absolutely necessary! A concealed damage report must be made no later than ten (10) days from the date the shipment was delivered. Unless you do this, the carrier will not consider any claim for loss or damage. The carrier's agent will then 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.

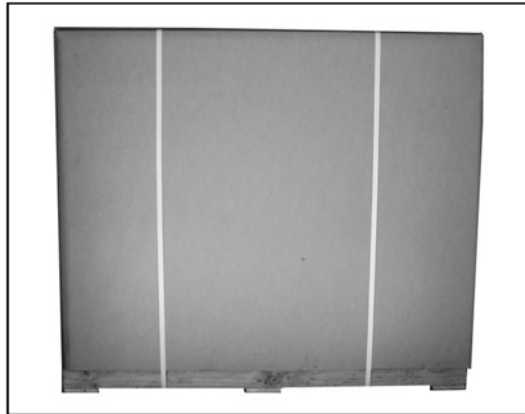
All claims must be filed within six (6) months of delivery date or carrier will not accept them.

Preferred Packaging is willing to assist in every possible manner to collect claims for loss or damage; however, this does not hold Preferred Packaging responsible for collection on claims or replacement of material.

## 4-PP76ST Sealer Service Manual

---

Your new Preferred Pack Model PP76ST comes bolted to a pallet and has a tri-walled corrugated box strapped to the pallet to protect it. Cut steel straps and remove corrugated box.



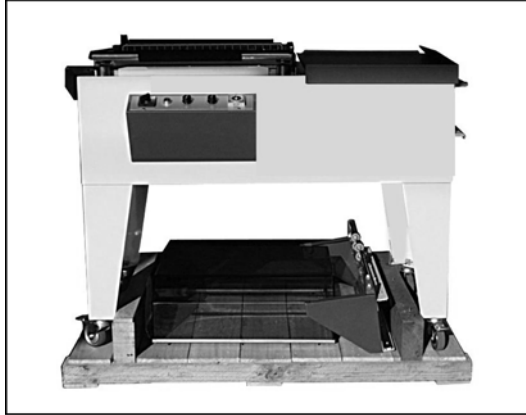
1. If your machine does not arrive in this condition, **write on shipping paperwork that outside of box is damaged. hidden damage may have occurred.**



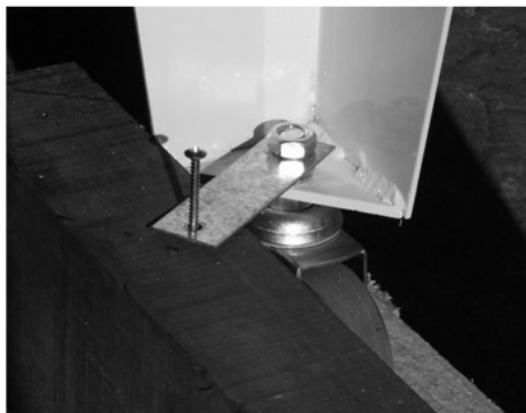
2. Remove protective plastic covering from hooked chamber and film rack.

## 4-PP76ST Sealer Service Manual

---



3. Check contents. You should have
  - (a) (1) Film Rack
  - (b) (1) Film Shaft
  - (c) (2) Film Roll Core Chucks
  - (d) (1) Hooded Chamber
  - (e) (1) Spare Band Ribbon



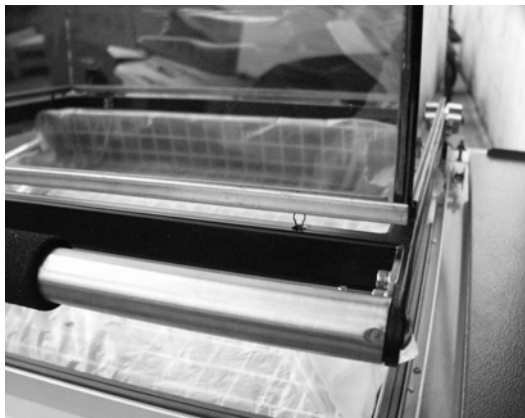
4. Remove Bolts holding machine to pallet using 13mm wrench.

## 4-PP76ST Sealer Service Manual

---



5. Install plexiglass hood on top of upper seal frame.



6. Insert steel locking clip into hole in upper seal frame. Push straight down on clip into hole, clip will automatically lock into position.



4-PP76ST Sealer Service Manual

---

**IMPORTANT WARRANTY NOTICES**

**OPERATING AND MAINTENANCE MANUAL**

The operating and maintenance manual has been carefully prepared to provide the user with all the information needed to properly install, operate, and maintain your Preferred Packaging equipment.

Please read this manual carefully and refer to it for information on the care and use of your Preferred Packaging equipment. It is recommended that additional copies be ordered for use by production, maintenance, and supervisory personnel. Although the design of this equipment incorporates safeguards to protect personnel, care should be used in operating, adjusting, and servicing.

Attention is directed to the warranty which accompanies all your Preferred Packaging equipment. The terms and conditions of this warranty apply only to unmodified units. Any unauthorized modifications to the equipment automatically voids this warranty.

**Preferred Packaging provides a one year warranty on parts, excluding shipping or freight costs for replacement parts. All warranty parts are shipped F.O.R. San Dimas, California.**

4-PP76ST Sealer Service Manual

---

## PREFERRED PACKAGING SYSTEMS

# WARRANTY

Preferred packaging systems, Inc. warrants each new product manufactured to be free from defects in material and workmanship for a period of (1) year from date of shipment by Preferred Packaging.

This warranty is not transferable with any subsequent resale.

Defective parts under warranty must be returned to Preferred Packaging freight prepaid. Preferred's sole obligation and purchaser's sole remedy in the event of a warranty dispute shall be, at Preferred's option, to repair or replace the part in question. Labor incurred in removing or installing the defective part is not covered by this warranty. Prior to returning any parts for any reason, contact Preferred Packaging for a Return Authorization Number. This number must accompany all returns.

This warranty shall not apply if equipment has been tampered with, misused, improperly installed, altered, or has received damage due to abuse, carelessness, accident or failure to follow recommended regular maintenance procedures or has been serviced by someone other than a duly authorized factory representative without the express written consent of Preferred Packaging Systems, Inc.

This warranty is in lieu of all other warranties, expressed or implied, including but not limited to warranties of merchantability and fitness for a particular purpose, non-infringement or any other matter.

#### 4-PP76ST Sealer Service Manual

---

---

Preferred Packaging shall have no liability to any person for direct, indirect, incidental or consequential damages or delay resulting from any defect negligence, or tort and customer hereby waives for itself any and all claims for punitive damages and all claims of negligence of strict liability or both. In no event shall our liability exceed the purchase price of the product which was actually paid.

Preferred Packaging reserves the right to make changes, additions, or improvements to our products with no obligation to make such changes in any previously shipped product covered by this warranty.

Preferred Packaging shall not be held liable for any damages arising out of or in connection with the operation of the equipment should customer or its agent fail to maintain equipment in safe operating condition. This warranty shall become unenforceable if and to the extent the customer or its agents remove, disconnect, or otherwise render useless any safety device and or parts designed or affixed by us or fails to maintain and service equipment in a manner as advised.

## 4-PP76ST Sealer Service Manual

---

### WARRANTY EXCEPTIONS

The following sealer parts are considered to be consumable and not under warranty:

1. Silicone Sponge
2. Band Ribbon
3. Teflon Tapes
4. Transit Channel

4-PP76ST Sealer Service Manual

---

## WARNINGS

Every effort has been taken to ensure your safety while operating this machine; however, there still remain certain risks. Do not allow this machine to be operated before informing all personnel of the following warnings.

### **WARNING.....**

Do not tamper with the electrical wiring. Only use a licensed electrician for maintenance. Always disconnect the electrical power before attempting any maintenance to all electrical and/or moving parts.

### **WARNING.....**

In order to prevent injury to personnel and/or machinery  
**DO NOT INCREASE SETTINGS OR RATINGS ON EITHER ELECTRICAL OR MECHANICAL OVERLOAD SAFETY DEVICES.**

### **WARNING.....**

**KEEP HANDS AWAY FROM MOVING CONVEYORS AND ASSEMBLIES.** Conveyor belts that have become worn or frayed are capable of being hazardous. They should be replaced promptly.

### **WARNING.....**

**NEVER OPERATE THIS OR ANY MOVING EQUIPMENT WITHOUT ALL COVERS AND GUARDS IN PLACE.** The internal mechanism of most packaging machinery contains numerous shear,

## 4-PP76ST Sealer Service Manual

---

pinch, and in running nip points, many of which are capable of causing severe injury and/or permanent disfigurement.

### **WARNING.....**

To minimize the potential for personnel injury, always be sure that 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.

### **WARNING.....**

Heat sealing arms and jaws on packaging machinery can become very warm after a period of use. KEEP HANDS AWAY WHILE IN OPERATION AND USE CAUTION IF THE MACHINE HAS BEEN RUNNING RECENTLY.

### **WARNING.....**

ANY MODIFICATIONS TO EITHER THE ELECTRICAL CIRCUITRY OR THE MECHANICAL ASSEMBLIES OF THE MACHINERY WILL VOID ANY WARRANTIES ASSOCIATED WITH THIS EQUIPMENT. Such modifications may introduce hazards that would not otherwise be associated with this machinery. Preferred Packaging will not be responsible for any consequences resulting from such unauthorized modifications.

### **WARNING.....**

The use of certain types of plastic films in sealing and/or shrinking equipment may result in the release of HAZARDOUS FUMES due to the 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

## 4-PP76ST Sealer Service Manual

---

the potential release of hazardous fumes. ADEQUATE VENTILATION MUST BE PROVIDED AT ALL TIMES.

### **WARNING.....**

It is important that the machine operator unplug the machine when he/she has finished operating the unit.

**4-PP76ST Sealer Service Manual**

---

---

**DESCRIPTION AND SPECIFICATIONS OF  
PREFERRED PACK MODEL PP76ST****DESCRIPTION**

This compact “all-in-one” unit allows the operator to seal and shrink all in one step. The operator simply places the product in the sealing area and lowers the hood to apply the seal pressure necessary to cut the film. Once the seal cycle is complete, the operator releases the handle and the shrink chamber is automatically held shut by the magnets. Once the shrink time is complete, the chamber opens and the operator removes the finished product.

The purpose of a PP76ST is for medium volume packaging requiring excellent seals and minimal maintenance. It features an impulse mode for sealing of films.

**SPECIFICATIONS**

Model:	PP76ST
Seal Area:	Length: 22” (550 mm) Width: 16” (420 mm)
Machine Size:	Length: 56” (1,420 mm) Width: 30” (760 mm) Height: 45” (1,140 mm)
Volts:	AC 220V
Amperage:	Max. 20A
Weight:	300 lbs. (135 Kgs)



## 4-PP76ST Sealer Service Manual

---

### INSTALLATION AND BASIC SET-UP OF L'SEALER PORTION OF MACHINE

#### **IMPORTANT**

Read this manual carefully, and make it available to everyone connected with the supervision, maintenance, or production of this machine. Additional copies are available at your request. (Contact your distributor for this information.) Be very careful when operating, adjusting, or servicing this equipment. If in doubt, stop and obtain qualified help before proceeding.

#### **INSTALLATION OF PP76ST**

Place the PP76ST in the desired location with the required electrical power source available. (See power requirements.) Make certain that proper electrical wiring is provided to guard against low voltage. If the voltage is too low, the equipment will not function properly.

Finding the proper location is a most important function of the initial set-up. One must take several factors into consideration:

1. Adequate power source.
2. Relationship to source of product.
3. Relationship to machine.
4. Relationship to any conveyors necessary to remove finished product.
5. Convenience of operator.

This machine comes complete with power cord. Simply connect machine into 220 volt power source. **Make sure you have no other machine connected to this power source.** If there is

## 4-PP76ST Sealer Service Manual

---

any doubt, get qualified assistance to do the initial installation. **Do not take any chances!**

Do not attempt to install, adjust, or operate this machine without first reading the contents of this manual. Although the design of the equipment incorporates safeguards to protect operating and maintenance personnel, care should be used in operating, adjusting, and servicing.

### ***INSTALLING FILM RACK***



1. Make sure slider bearings are positioned to the left side of track toward front of machine.



## 4-PP76ST Sealer Service Manual

---

2. Start from the right side (back) of machine to slide film rack onto tracks.



3. Continue to slide film rack from right to left toward front of machine.

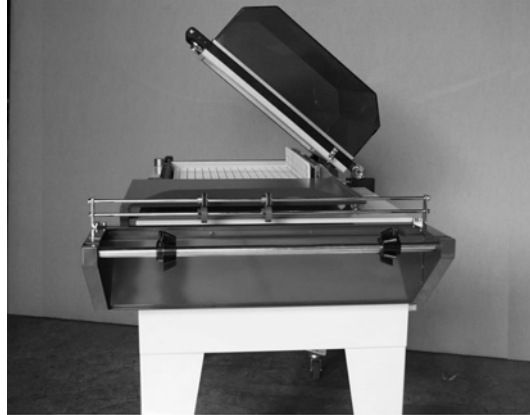
**NOTE:** At this point, film rack will be difficult to move as the film rack is now in contact with slider bearings. **Firmly** push film rack to the left toward front of machine.



4. Continue pushing film rack until ½ of the film rack has passed the front of the machine.

## 4-PP76ST Sealer Service Manual

---



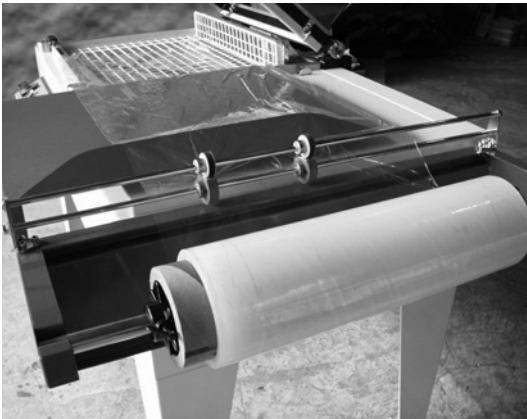
5. Now move film rack back to the right. Rack will now only move forward toward operator or front of machine. It will not be able to slide off from the back side.

## 4-PP76ST Sealer Service Manual

---

### MOUNTING FILM

Select the proper width of center-fold film for the item being packaged, allowing for width and height of package. With the package properly positioned within the film in the sealing area, allow sufficient film to overlap the sealing bars so that a seal may readily be made without any possibility of open areas due to insufficient film.



Place film roll on shaft using the two core chucks provided to locate film. Tighten core chucks. The center-fold is to be placed away from the operator, toward the rear of the machine. Position film roll on shaft and tighten film core chuck to hold film roll in position.

Thread film through the two Pin Perforator wheels provided. Note that the perforator wheel turns freely and are not binding.

Once threaded, separate film top from bottom and insert product tray between. Make sure that the center-fold of film is placed at the rear of the product tray. This allows the operator to insert product between the layers of film on the product tray and to prepare to move product and film into the sealing area. When threading film, make sure to pull more than sufficient film through

## 4-PP76ST Sealer Service Manual

---

the rollers, across the product tray, and into the sealing area to ensure sufficient film to begin operation.

Place product toward rear of film separator tray. Then move product into seal area. Be sure to leave the bag loose around the product when making the seal. This helps eliminate the seals from blowing out in the shrink chamber. This completes threading and/or mounting film.

### **PIN PERFORATOR**



Located between the film roll and the product tray, the pin perforator creates holes for air escape as the operator pulls on the film. This allows the air to escape as the package shrinks in the chamber.

The pin perforator is adjustable and must be properly placed in conjunction with the width of the desired package. The positioning should always be re-evaluated when setting the machine for different size product or different size film.

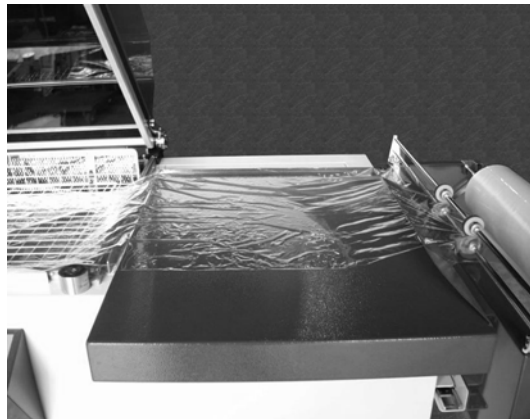
Adjustments to Pin Perforating wheels can be made using the Allen key provided. The Pin Perforator assembly is composed of two components (1) wheel with Pins and (2) grooved wheel without pins

## 4-PP76ST Sealer Service Manual

---

on a concentric cam. To adjust pin wheels depth, use Allen key provided and adjust wheel without pins using the concentric cam to turn wheel on shaft to position wheel deeper into pins. Then re-lock Allen screws.

### PRODUCT TRAY

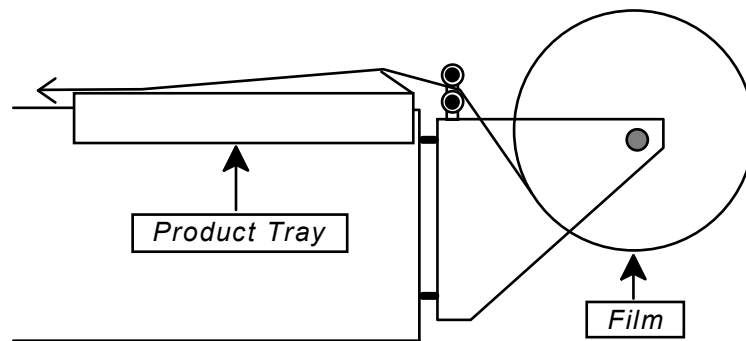


The product tray is an adjustable metal platform used to separate film and to insert product between top and bottom layers of film.

4-PP76ST Sealer Service Manual

---

# FILM THREADING DIAGRAM

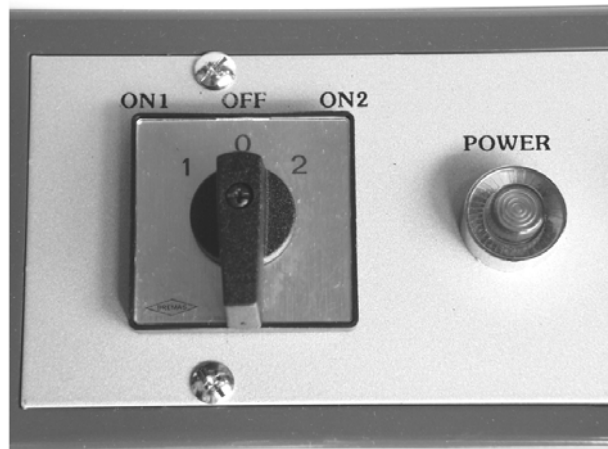




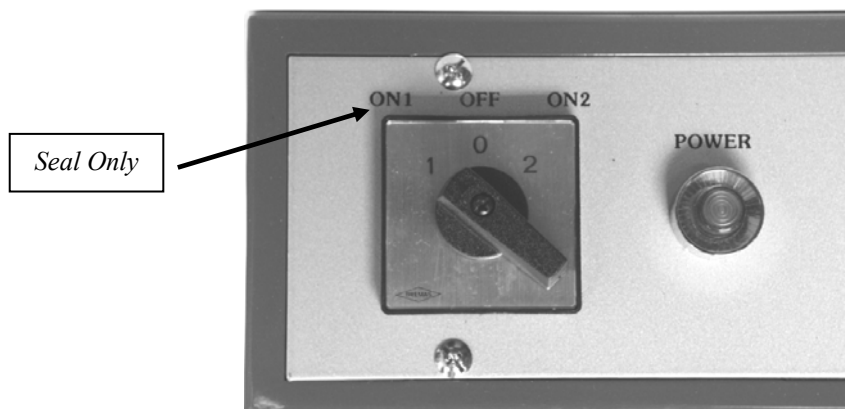
## 4-PP76ST Sealer Service Manual

---

### PREFERRED PACK -- Front Panel Diagram



- Main switch is in OFF position. Machine will not operate.

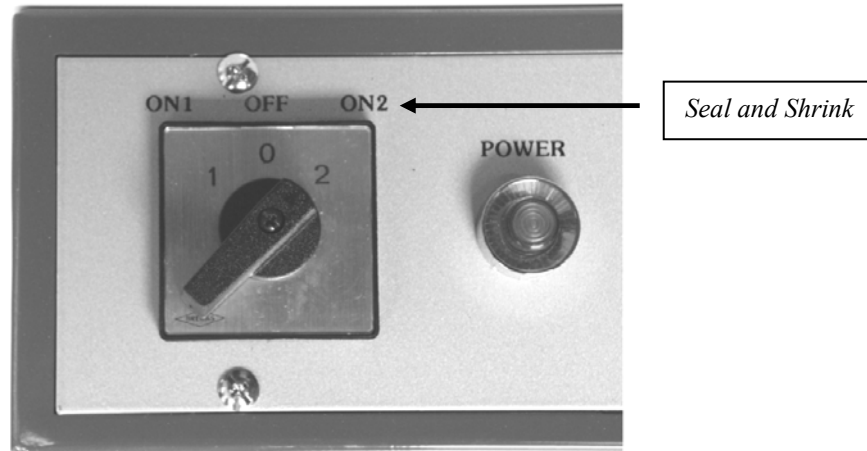


- Main switch in SEAL only position (ON1). Machine will only seal product NOT shrink.

**NOTE:** When the switch is in the SEAL ONLY position, the heater in the chamber is off.

### 4-PP76ST Sealer Service Manual

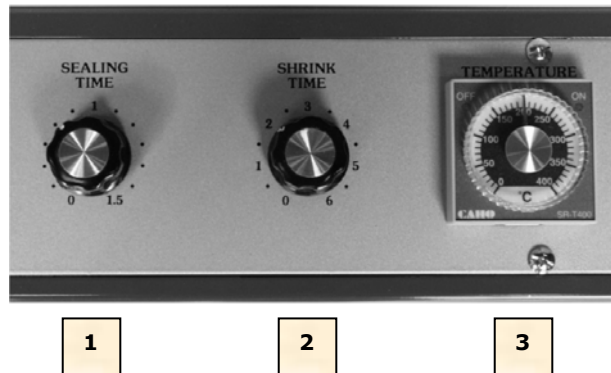
---



- Main switch in SEAL and SHRINK position (ON2), both functions are available. Machine will take approximately 10-15 minutes to warm up. You will know it is ready when chamber temperature thermostat light goes off.

#### 4-PP76ST Sealer Service Manual

---



- 1. Seal Time:** Amount of time band ribbon heats up.  
Recommended setting for PVC: 0.8 Sec.  
Recommended setting for Polyolefin: 0.8 ~ 1.2 Sec.  
**Note:** The proper seal time is the shortest time possible to cleanly seal and cut your film. Always start with a shorter seal time where the film will NOT cut cleanly, then increase dial setting to achieve desired results.
- 2. Shrink Time:** Amount of time the air will blow in chamber.  
Recommended setting for PVC Film: 2 ~ 3 Sec.  
Recommended setting for Polyolefin Film: 3 ~ 4 Sec.  
**Note:** These are only a suggested starting point when setting up your machine. These settings will vary depending on the shape of your product and the film thickness used. Remember that thinner gauge films require less heat and less shrink time.
- 3. Chamber Temperature:** How hot chamber will become.  
Recommended settings for PVC Film: 300 °F (150 °C)  
Recommended settings for Polyolefin Film: 350 °F (180 °C)  
**Note:** These are only a suggested starting point when setting up your machine. These settings will vary depending on the shape of your product and the film thickness

## 4-PP76ST Sealer Service Manual

---

used. Remember that thinner gauge films require less heat and less shrink time.

## 4-PP76ST Sealer Service Manual

---

### SEQUENCE OF OPERATION

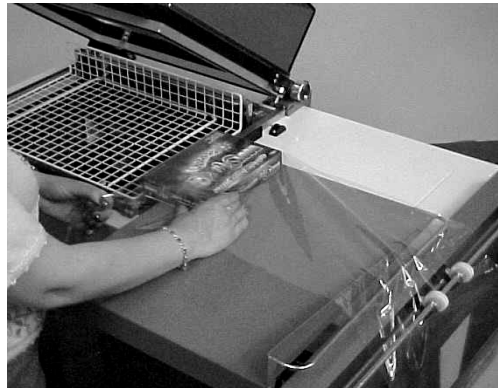
- A. Product is placed on the film separator tray.
- B. The product tray functions as a means to separate the film, allowing placement of product between upper and lower portions of the film.
- C. Move product into seal area by pushing the product to the left.
- D. Manually pull the hooded chamber down. As the chamber meets the lower switch seal band ribbon, the machine automatically activates the band ribbon. \*  
**NOTE:** If too much tension is on the film while the bag is being made, the seals will, more than likely, be weak or will “blow out” in the seal area while the shrinking process is occurring. Make sure to relax the film tension prior to sealing.
- E. The operator must apply seal pressure at this point to ensure a good strong seal. Once the seal time is complete, the operator may release the hood.  
**NOTE:** The magnet in the left hand front corner will activate only during shrink time to allow the hooded chamber to stay closed during the shrink cycle.  
**\*NOTE:** The operator needs to hold the hood chamber down at least for one second to complete the seal cycle.
- F. Once the seal time is complete, the shrink timer and magnet timers are activated. At this point, the hooded chamber will stay down automatically during the shrink cycle because the magnet is activated. When the shrink timer is complete, the magnet releases the chamber and it automatically raises allowing the operator to remove the completed product.

## 4-PP76ST Sealer Service Manual

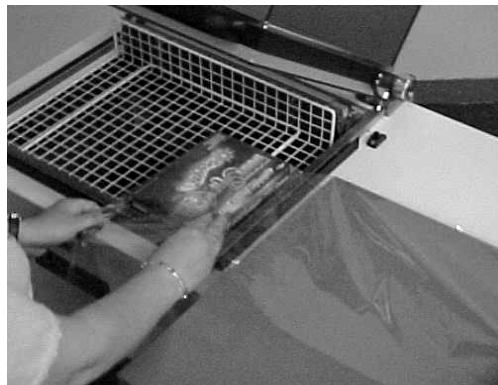
---

### SEQUENCE OF OPERATION

1. After completion of basic setup as described on pages 18-27 plug the sealer's cord into the power source.



- A. With film threaded (see instructions for mounting film), place right hand on package and slide product into the upper left hand corner of the film (i.e., corner formed by folded rear edge of film and previously sealed left edge of film). Push the package toward the rear of the loading tray.

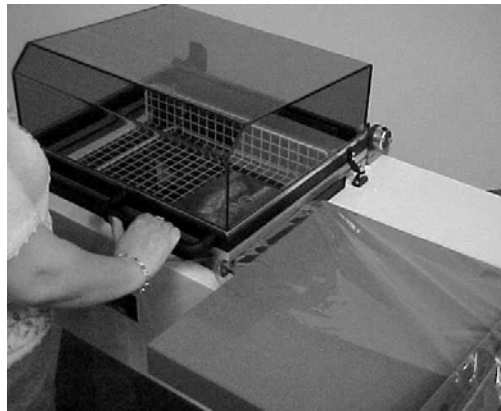


- B. Place right hand under top sheet of film and on front right corner of product. Place left hand on tail of both sheets of film. Now push the package with right hand and pull

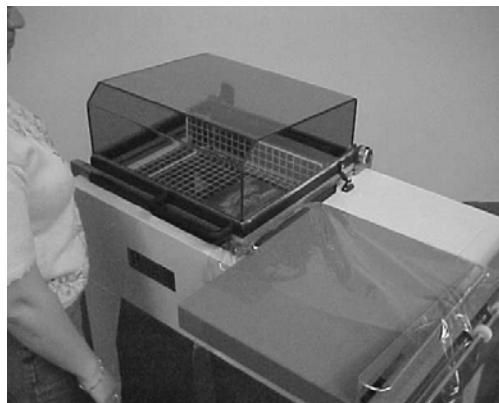
#### 4-PP76ST Sealer Service Manual

---

the film with left hand moving package and film into lower right corner of seal area. Allow from ½” to 1” of extra film around package. This will allow some slack film between the package and the sealing bars, reducing film tension.



- C. Press hooded chamber handle down. **Firmly** apply seal pressure for duration of set seal time (one second).



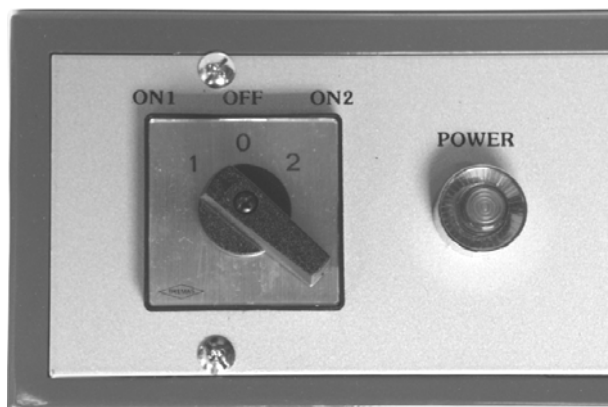
- D. Shrinking chamber hood will automatically stay down during shrink cycle by use of the magnetic hold down.

## 4-PP76ST Sealer Service Manual

---



- E. Once shrink cycle time is complete, operator may remove completed product from chamber.
2. To increase cycle time and speed of operation, follow this procedure:

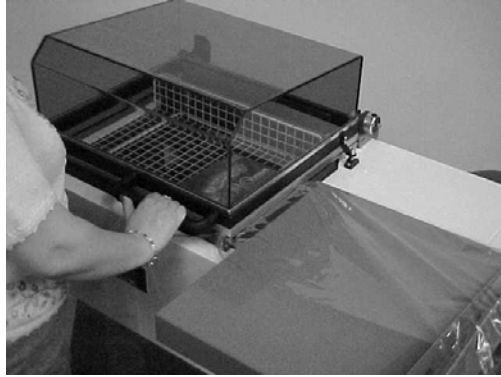


- A. Turn Selector switch to SEAL ONLY position (ON1).

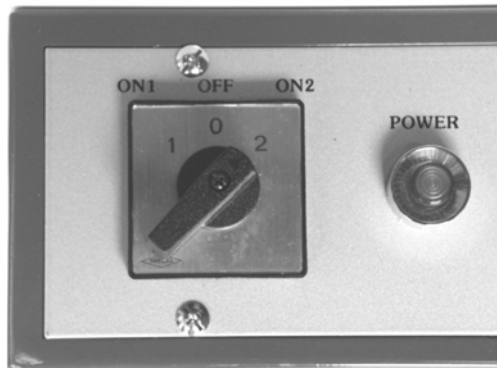


## 4-PP76ST Sealer Service Manual

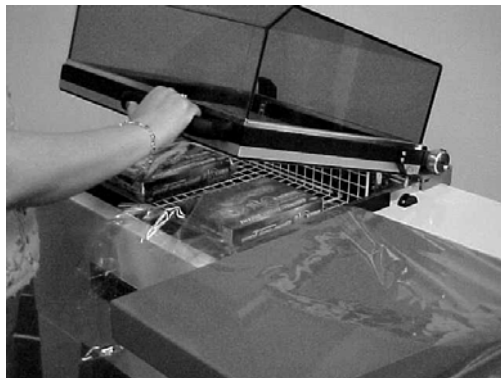
---



- B. Place product into seal area and seal only.



- C. Turn selection switch to seal and shrink (ON2).

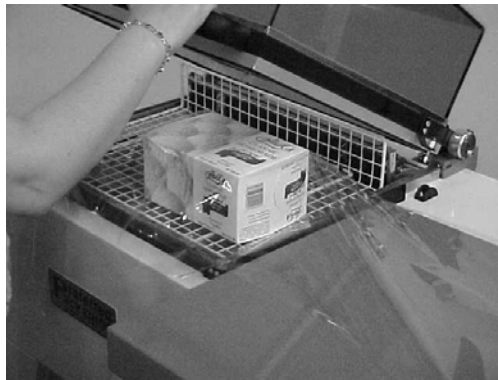


### 4-PP76ST Sealer Service Manual

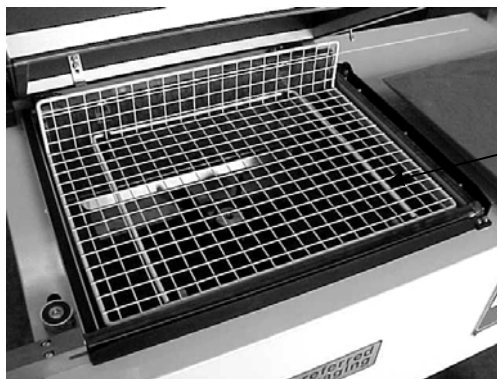
---

- D. Place additional product into seal area and now seal and shrink both products at the same time, increasing output of machine.

### 3. Adjusting Product Grill:



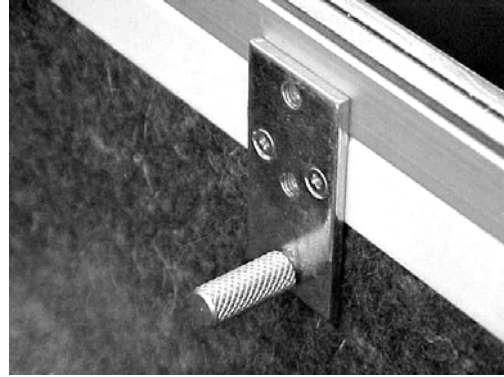
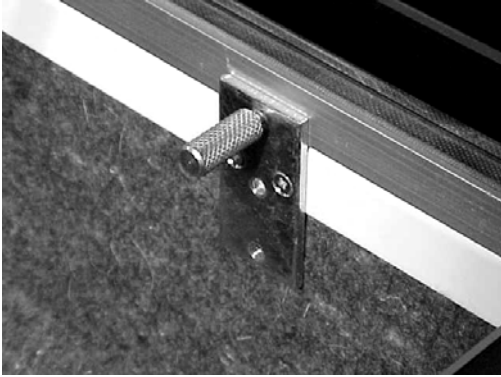
- A. If product is too tall, film tension is created, producing weak seals. Adjust product tray as follows:



*Remove Grill*

### 4-PP76ST Sealer Service Manual

---



- B. Adjust grill, holding screws downward into lower threaded hole.



- C. Product now sits half way below seal area, reducing film tension when sealing and place seal in center of package.

## 4-PP76ST Sealer Service Manual

---

### TROUBLESHOOTING

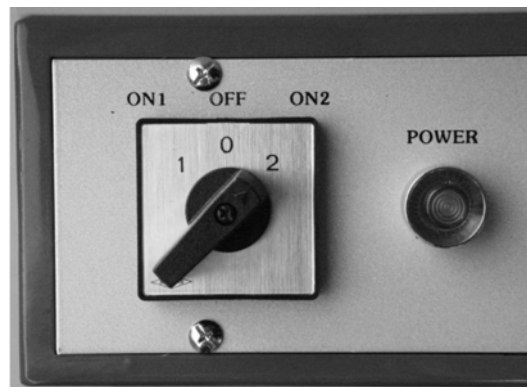
The following guidelines are provided to aid in determining the source of any operation difficulties which may develop. In performing the tests and checks which follow, carefully inspect for any loose components, broken or loose wires, poor electrical connections, etc., while testing the various switches, controls, relays, transformers, etc. For checking electrical problems, use a voltage meter.

**Note:** While troubleshooting use caution to avoid danger of electrical shock. When power is not required for checking for the presence or value of voltages used, always have it disconnected.

**DISCONNECT ALL POWER BEFORE MAKING ANY REPAIRS.**

**REFER TO ELECTRICAL BOARD LAYOUT AND ELECTRICAL SCHEMATIC FOR LOCATION OF ELECTRICAL COMPONENTS**

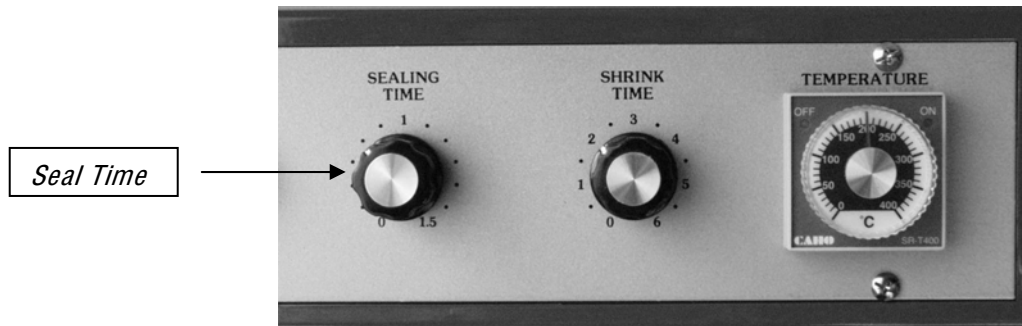
#### **NO HEAT TO BAND RIBBON**



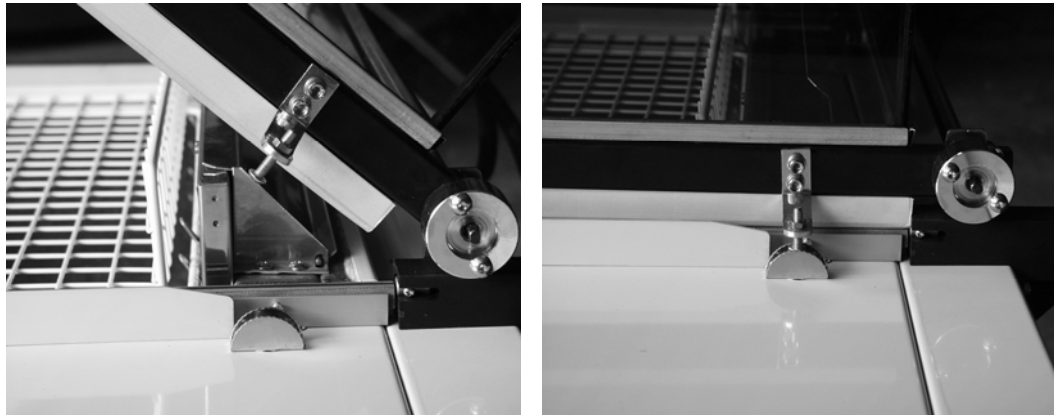
1. Check that the sealer is plugged in and that power is present at the socket. Make sure the power switch is in the **SEAL ONLY** or **SEAL AND SHRINK** position.

## 4-PP76ST Sealer Service Manual

---



2. Make sure seal timer is **not** set on zero (0) on time dial.



3. **Check pulse switch adjustment.**

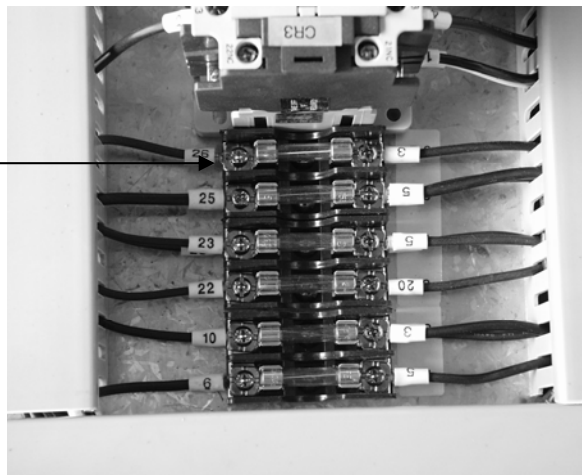
- (a) Make sure switch is being activated when the seal bar is within  $\frac{1}{4}$ " of contact with seal pad.
- (b) Press switch by hand. If no click is heard, replace switch.

### 4-PP76ST Sealer Service Manual

---



*FUSE (F6):  
Pulse  
Transformer  
Protection*



*F6 – 15AMP  
F5 – 15 AMP  
F4 – 1 AMP  
F3 – 5 AMP  
F2 – 2 AMP  
F1 – 20 AMP*

4. Check all fuses.

## 4-PP76ST Sealer Service Manual

---



CR2: Magnetic Contactor

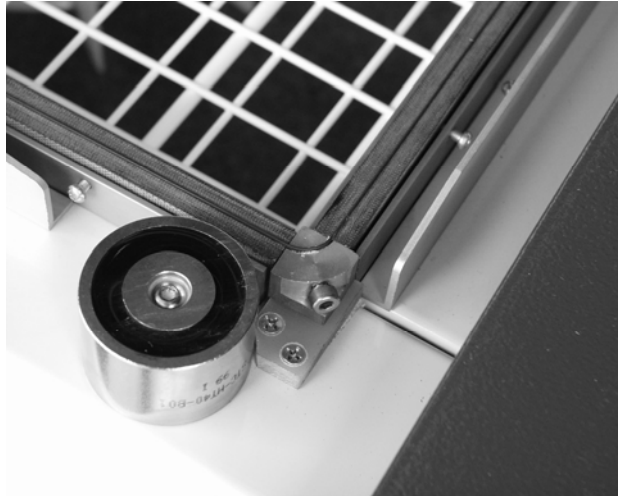
5. Check to see CR2 contactor is ok and the points are not burned or no wire has come loose.



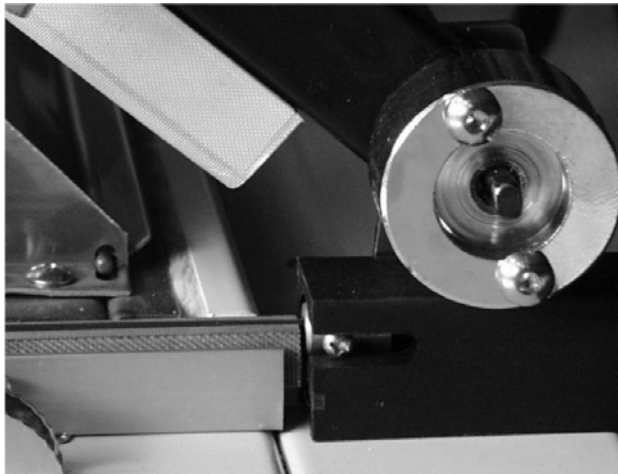
6. Check for voltage present at both primary T2 and secondary of transformer T2 as per values shown in the voltage specifications (220 volt primary, 66 volt secondary).

## 4-PP76ST Sealer Service Manual

---



7. Check for broken band ribbon inside or outside the corner bead.

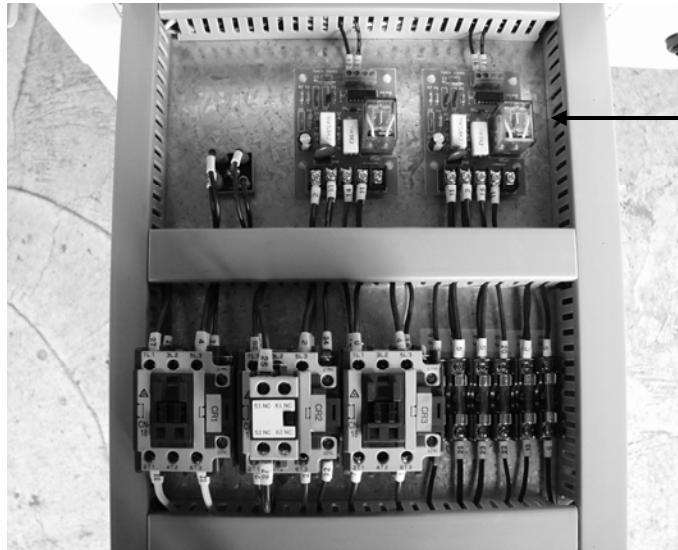


8. Check for bad connections on each end of band ribbon. Make sure wires are connected to each end of compensator.



## 4-PP76ST Sealer Service Manual

---

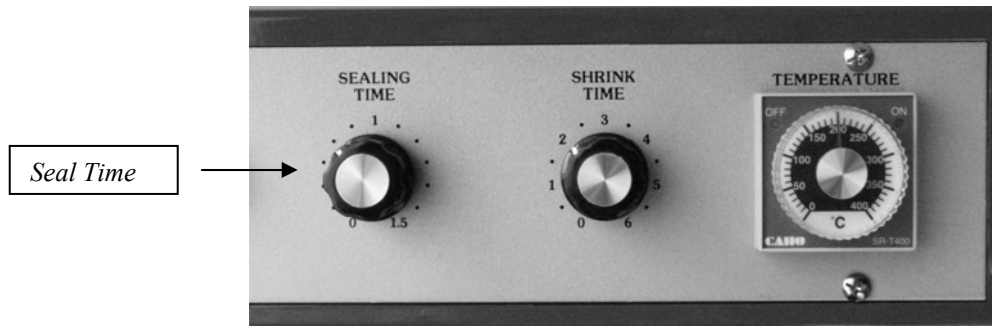


*TR2:  
Timer Board*

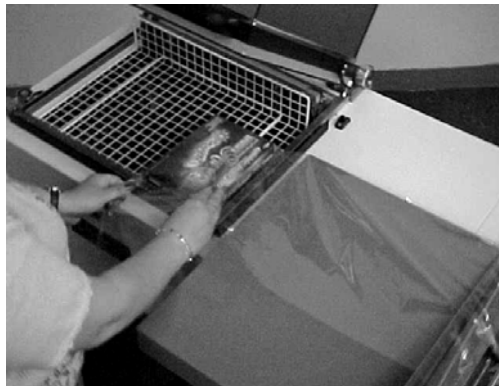
9. Check TR2 Timer Board to make sure no wire has come loose, the contactor of the Relay on the board is ok.

## 4-PP76ST Sealer Service Manual

---



1. Improper setting of seal time compensator. Refer to page 27 for proper adjustment.

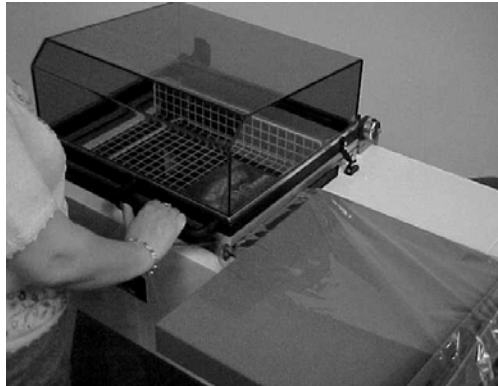


2. Improper operating technique. Too much film tension, make sure film is relaxed prior to sealing.
3. Check band ribbon to see if cleaning or replacement is necessary.
4. Burned teflon tapes 1/2". If teflon tapes become burned or worn, weak seal may occur. See page 52 for Replacement Instructions.

## 4-PP76ST Sealer Service Manual

---

5. Wavy silicone rubber sealing pad. Replace. (See instructions on page 53.)

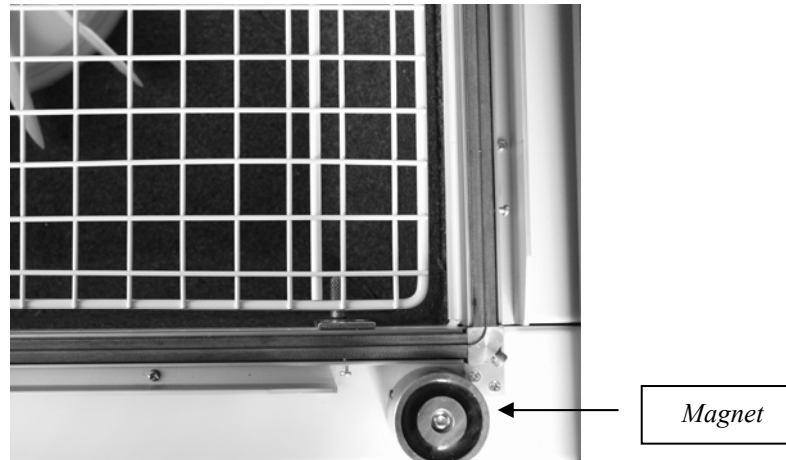


6. Seal pad pressure incorrect.

4-PP76ST Sealer Service Manual

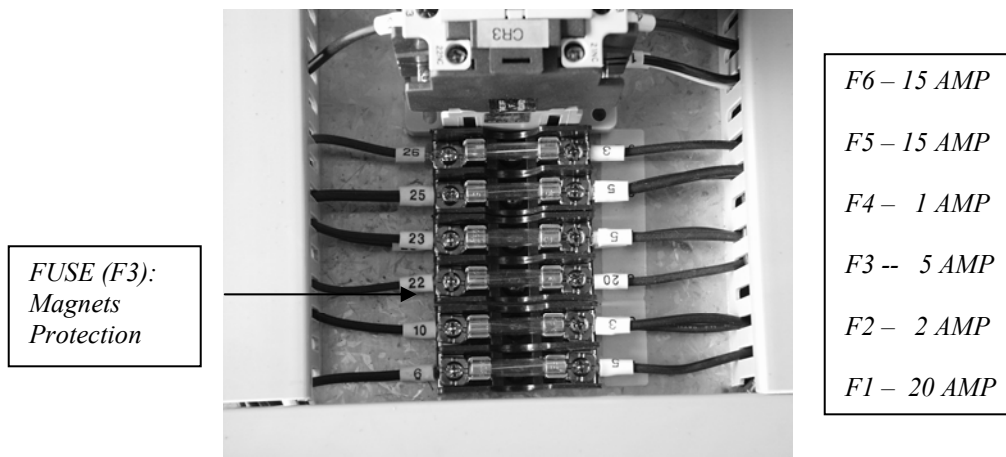
---

**MAGNETIC HOLD DOWN ON SHRINK CHAMBER**



**NOTE:** There are two magnets on the machine, one to hold the hood chamber down for duration of shrink time, the other is for seal time.

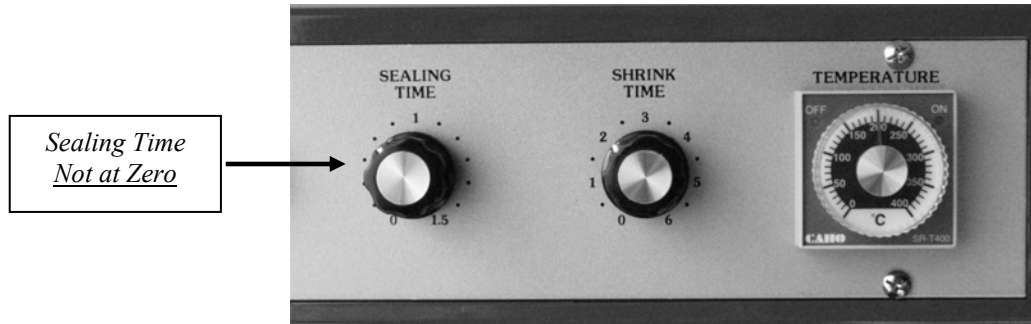
1. Seal head will not stay down – machine operates normally otherwise.



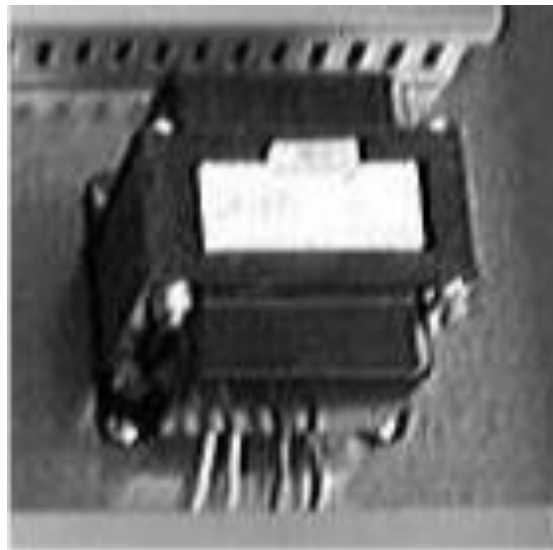
- (a) Check Fuses F2 through F3. Replace if burned.

## 4-PP76ST Sealer Service Manual

---



2. Check seal timer (TR2) setting. Make sure it is not set at zero. Also, check to see if burned or damaged.



3. Check for 220 volts (nominal) to primary transformer (T1).
4. If voltage is present to primary winding of transformer (T1), check for 24 (nominal) volts output from secondary of transformer.

## 4-PP76ST Sealer Service Manual

---

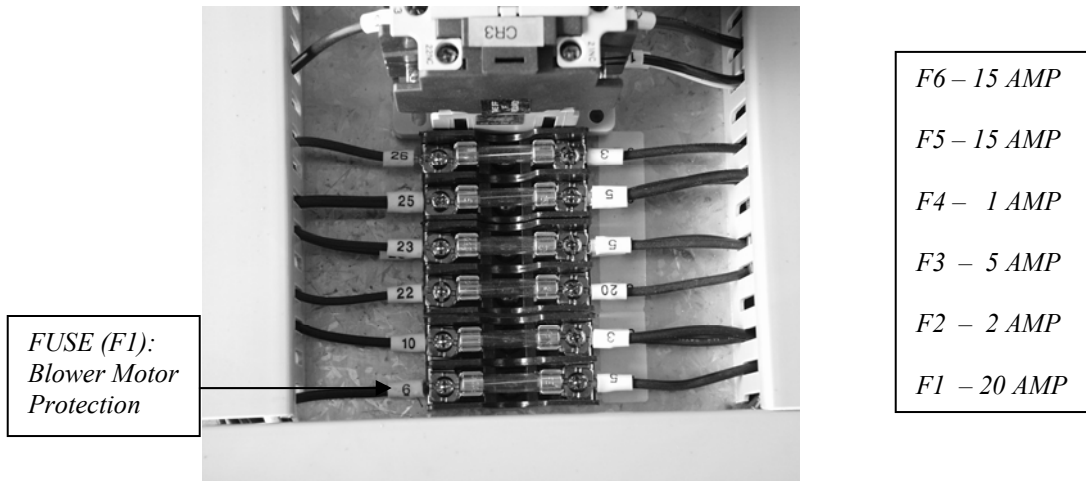


5. Check for 24 (nominal) volts DC output from + (positive) and – (negative) wires number 20 (+) and 21 (-) on terminals of rectifier. If no DC 24 voltage, replace rectifier.

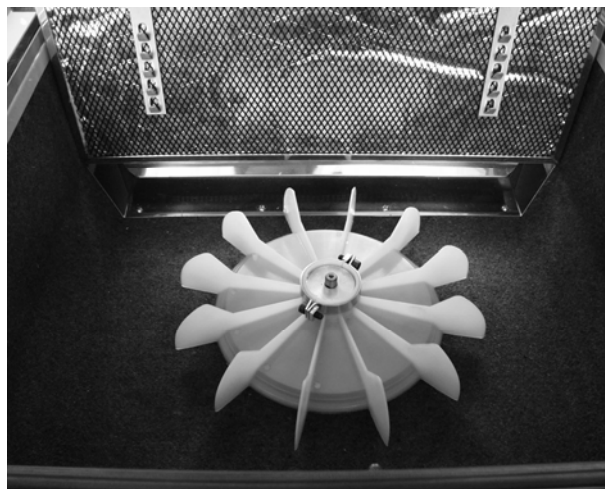
### 4-PP76ST Sealer Service Manual

---

## **NO AIR FLOW**



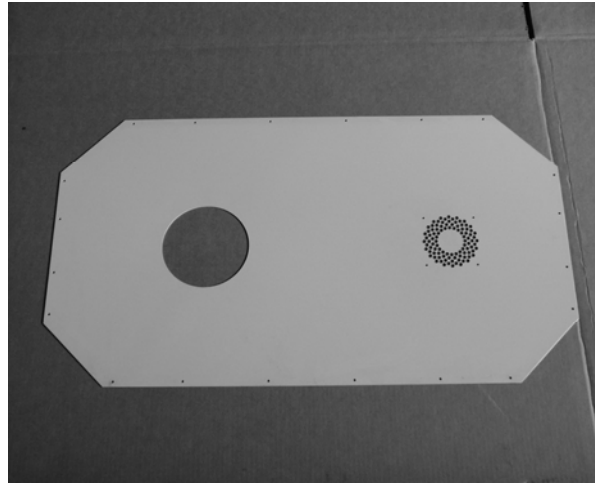
1. Check all fuses.



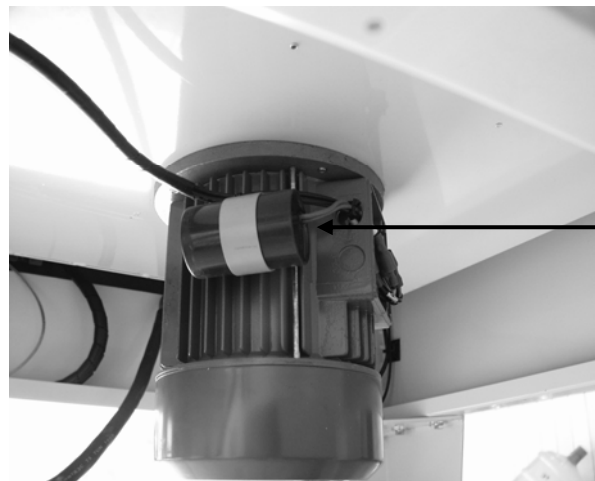
2. Check Blower Wheel to see if it is tight on center hub. If loose, tighten bolts holding fan blade to hub.

## 4-PP76ST Sealer Service Manual

---



3. Remove bottom cover from underside on machine.



4. Check Blower motor to make sure no wires are loose.
5. Replace capacitor and replace if bad.



**4-PP76ST Sealer Service Manual**

---

**BAND RIBBON REPLACEMENT**

The band ribbon is subject to constant wear and will eventually require replacement. To replace band ribbon, proceed as described below.

1. Before working on machine, switch machine off and disconnect power cord from wall outlet.
2. Clean Band Ribbon using soft cloth by wiping Band Ribbon when warm, as it is easier to remove any residue while Band Ribbon is warm.
3. If lower chamber requires cleaning where fan wheel is, we recommend using a vacuum cleaner to remove any particles that may have fallen into the chamber.
4. We recommend you use a glass cleaner to clean the plexiglass hood. Do not use solvents.

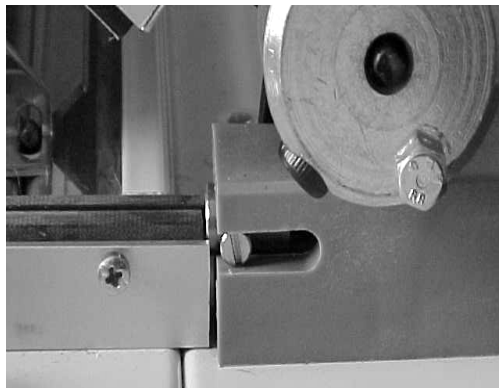
## 4-PP76ST Sealer Service Manual

---

### Replacing Band Ribbon



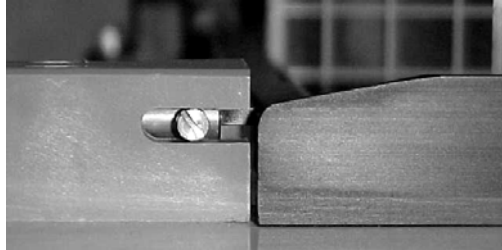
1. Loosen screw holding Band Ribbon in corner.



2. Loosen screw holding Band Ribbon inside rear compensator assembly.

**4-PP76ST Sealer Service Manual**

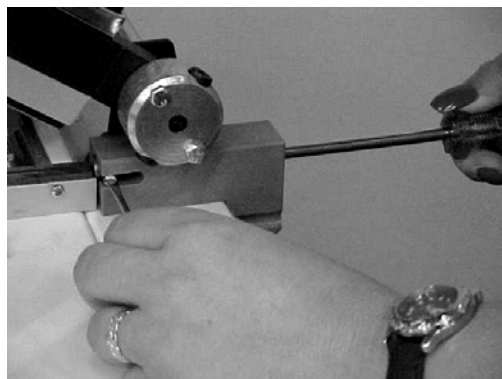
---



3. Loosen screw holding Band Ribbon in front compensator assembly.



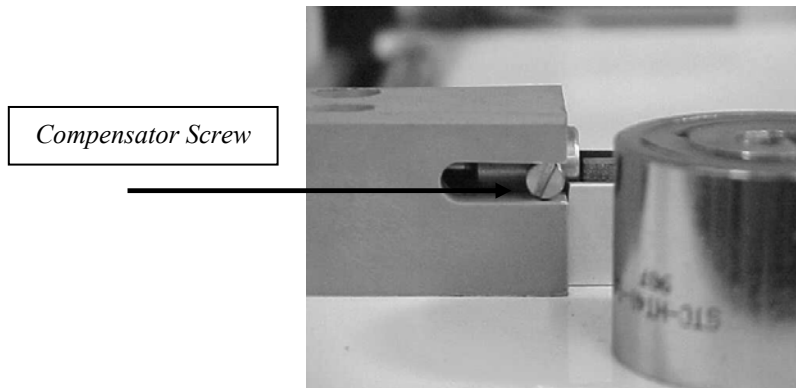
4. Use pre-cut Band Ribbon and place piece of teflon tape around corner of band ribbon  $\frac{1}{2}$ "L x  $\frac{1}{4}$ "W x 3 mill. Install Band Ribbon on corner first then insert into each end of front and side compensator. Band Ribbon may be oversized slightly, if so cut to fit ends.



5. Compensators are spring loaded. Use screwdriver to push in – flush to transit bars before fastening.

## 4-PP76ST Sealer Service Manual

---



6. Place other end of band ribbon in slot along front seal area. With band ribbon in slot, use screwdriver to move front compensator forward until band ribbon is inside compensator and compensator is resting against the front seal bar.

## 4-PP76ST Sealer Service Manual

---

### **Tape Replacement**

The item most subject to wear on the sealer is the teflon tape used to cover the silicone sponge rubber on the sealing bar. This ½" x 10 mill tape should never be permitted to burn through. To replace tape, proceed as follows:



1. Strip off old tape.
2. Cut off proper length of new teflon, peel off backing, and press new tape into position.
3. Apply ½" x 10 mill Teflon tape over the top of the rubber.

## 4-PP76ST Sealer Service Manual

---

### **SILICONE RUBBER SEALING PAD REPLACEMENT**

Occasionally it will be necessary to replace the silicone rubber sealing pads. This should be done if the following is noted:

- Gaps in the seal
- Weak seals
- Improper film cut-off

#### **To replace rubber, proceed as follows:**



1. Remove teflon tape from seal rubber.
2. Seal pads are designed with a channel for easy replacement. Pull silicone rubber out of the channel.
3. Replace with new silicone rubber. Press rubber back into channel using a double-sided tape to hold rubber in position.
4. Install ½" - 10 mill teflon tape on top of rubber.

## 4-PP76ST Sealer Service Manual

---

### **Sealing Pad Pressure Adjustment for Head Return Cylinder**

Uniform pressure between the Band Ribbon and the sealing pads must always be maintained for proper sealing uniformity, and to prevent Band Ribbon hot-spots and premature burnout. This adjustment should be checked periodically and should always be checked when sealing gaps occur. Proceed as follows:

1. Loosen all five bolts on lower pads just enough to maintain a moderate sliding pressure.
2. With sealing head resting on lower pads, make sure there are no air gaps, then tighten the five bolts on the lower pad.
3. Adjust magnets (see page 57 for magnet adjustment).

### **Height of Seal Bar**



4. To raise or lower chamber height, adjust hood stop assembly casting by loosening the two mounting bolts. Move assembly casting upward to increase height or downward to decrease chamber height, then tighten bolts.

## 4-PP76ST Sealer Service Manual

---

### Pulse Switch Adjustment



The sealing cycle should not begin until the chamber hood is within 1/4" or less of the film to be sealed. If the Band Ribbon energizes before the hood is within 1/4" of the film, loosen the lock-nut and turn the screw (located at the rear end of the side seal bar) up slightly (counterclockwise when viewed from above). The correct adjustment has been obtained when the Band Ribbon energizes just as the seal bar comes into contact with Band Ribbon.



## 4-PP76ST Sealer Service Manual

---

### **Adjustment of Magnets for Correct Chamber Pressure**

All magnets have been factory adjusted for equal sealing pressure throughout the length of both the front and side seal bars. However, if an adjustment is required, proceed as follows:

1. Disconnect the sealer's power source.



2. Loosen the two upper magnet bolts. Magnets settle to their lowest position in the mounting slots.
3. Lower the chamber handle fully and set the upper mounting bracket to within 1/16" from the lower magnet. Tighten the mounting bolts securely to retain the proper adjustment.

## 4-PP76ST Sealer Service Manual

---

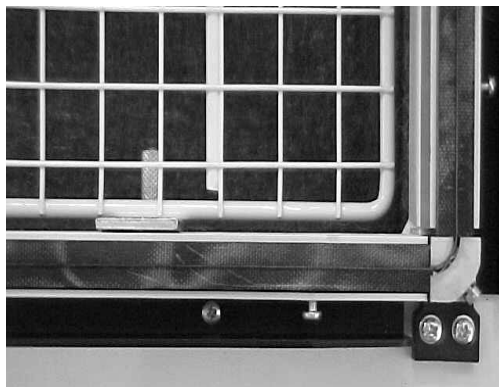
### Replacing Front and Side Transite Bars

1. Turn power switch to **OFF** position.



*Film Support Bracket*

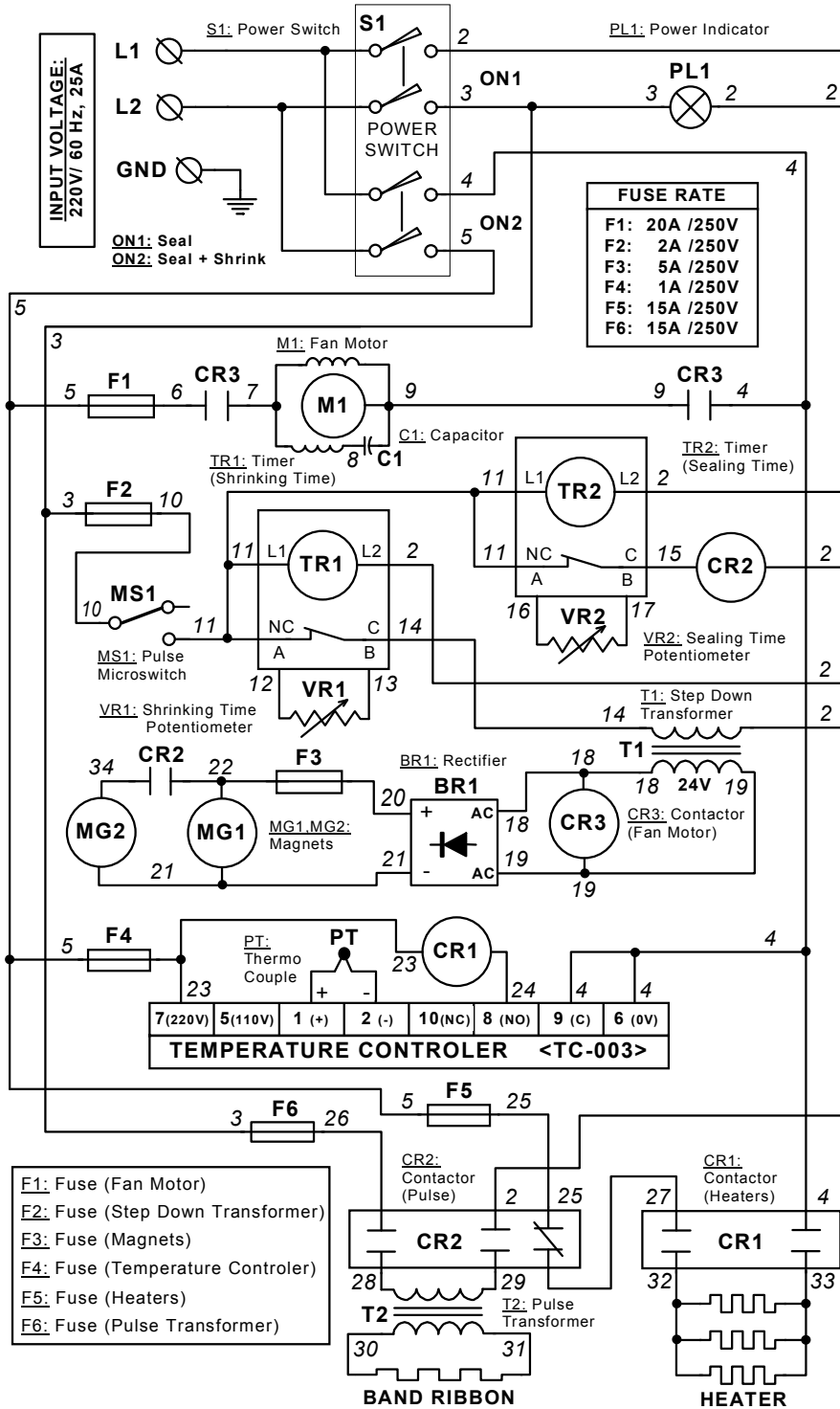
2. See instructions on replacing Band Ribbon on page 47.



*Transite Bar Holding Screw*

- (a) Remove film support bracket which is mounted next to transite holding channel.
- (b) Remove screws holding transite bars in channel.
- (c) Transite Bar can now be removed from channel. Reinstall new bar.

4-PP76ST Sealer Service Manual



"ALL-IN-ONE" HOOD MACHINE MODEL: PP76ST (220V)

## 4-PP76ST Sealer Service Manual

**PREFERRED PACK MODEL PP76ST**

<b>Item</b>	<b>Part #</b>	<b>Qty</b>	<b>Parts List Nomenclature</b>
S1	10100A	1	Main Switch
TC003		1	Temperature Control
TR1		1	Shrink Timer
TR2		1	Seal Timer
F1		1	Fuse – 20 AMP
F2		1	Fuse – 2 AMP
F3		1	Fuse – 5 AMP
F4		1	Fuse – 1 AMP
F5		1	Fuse – 15 AMP
F6		1	Fuse – 15 AMP
CR1		1	Contactoer CN
CR2		1	Contactoer
CR3		1	Relay
BR1		1	Rectifier
T1		1	Step Down Transformer
T2		1	Pulse Transformer
M1		1	Blower Motor, 220V
MG1		1	Magnet
MG2		1	Magnet
MS1		1	Pulse Microswitch
PL1		1	Power Indicator
PT		1	Thermo-Couple
VR1		1	Potentiometer, Shrink Time
VR2		1	Potentiometer, Seal Time

## 4-PP76ST Sealer Service Manual

### PP76ST REPLACEMENT PARTS

Part #	Qty	Description
YFE385602	1	Band Ribbon
76-M1006	2	Brackets – Chamber Shaft Mounting Bracket
76-E2006	1	Capacitor – Blower Motor
76-M1011	1	Chamber Height Adj. Assembly
76-M1016	1	Channel – Transite – Front Mounting
76-M1021	1	Channel – Transite – Side Mounting
YMF203001	1	Compensator Assembly – Front
YMF303002	1	Compensator Assembly – Side
76-E2011	1	Contacto – KM2
76-E2016	1	Contacto – KM1
YMF205005	1	Corner Block – Brass
76-M1041	1	Cover – Heater Bank
76-E2021	1	Electrical Access Panel – Rear
YFM130002	1	Fan
YFM195012	1	Felt Padding – Chamber
76-M1046	1	Film Rack
76-M1051	2	Film Roll – Core Chucks
76-M1056	1	Film Separating Bar
76-M1061	1	Front Plate – Control Panel
76-E2026	2	Fuses – FU1 and FU2
YFE260060	2	Fuses (F3, F5)
YFE255055	1	Fuses – F4
YFE265065	1	Fuses – F6
YFM130002	1	Grate
76-M1066	2	Grate – Mounting Bracket – Front
YFM210010	2	Grate – Mounting Bracket – Front – Screw
76-M1076	2	Grate – Mounting Bracket – Rear
76-E2036	1	Heater Bank
YFM080005	1	Hood – Plexiglass

## 4-PP76ST Sealer Service Manual

Part #	Qty	Description
YFM215015	1	Hub – Fan Mounting
76-M1086	4	Legs
76-M1091	1	Loading Tray
YFM22020	4	Locking Casters
76-E2041	1	Magnet
76-M1101	1	Magnet – Upper Mounting Bracket
YFE240001	1	Motor – Blower
YFM225025	1	Mounting Bracket – Pulse Switch
YSOK00604	2	Pin Perforator – Ceramic Wheel Slotted
YSOK00605	2	Pin Perforator – Pin Wheel
76-E2046	1	Power Cord
76-E2051	1	Rectifier
YFE380002	1	Resistor
YFE230030	1	Relay – KM3
YFM235035	2	Screws – Corner Block-Mounting
YFM350009	1	Seal Rubber – Top/Front
YFM350006	1	Seal Rubber – Top/Side
YSO2A602	1	Shaft – Roll Holder
76-M1116	1	Shaft – Film Support
76-M1121	2	Shaft – Pin Perforator Support
76-M2061	1	Switch – Main Power
YFE240040	1	Switch – Pulse
76-M1126	2	Teflon Tape ½” x 10 mill
YFE245045	1	Temperature Control
YFE250050	1	Timer – Heater and Seal
YFM170005	1	Torsion Bar
76-M1131	2	Track Bearings – Film Rack
YFE440612	1	Transformer – T1
76-E2086	1	Transformer – T2
YSO2A0305	1	Transite Bar – Front/Side Blade Holder

---



---

### 4-PP76ST Sealer Service Manual

#### Spare Parts List – PP76ST

Item #	Part #	Description	Qty.	Price
1	YFE260060	Fuse – F3, F5 4AMP	2	
2	YFE260055	Fuse – F4, 1AMP	1	
3	YFE265065	Fuse FU6, .5 AMP	1	
4	76-E2026	Fuse – FU, FU2, 16 AMP	2	
5	43-1125	½" x 10 mill x 10 yrd. Teflon tape	1 R1	
6	YFM350009	Seal Pad Rubber – Front	1	
7	YFM350006	Seal Pad Rubber – Side	1	
8	YFE385602	Band Ribbon	2	
9	YFM250005	Corner Block	1	
<b>Total Cost</b>				