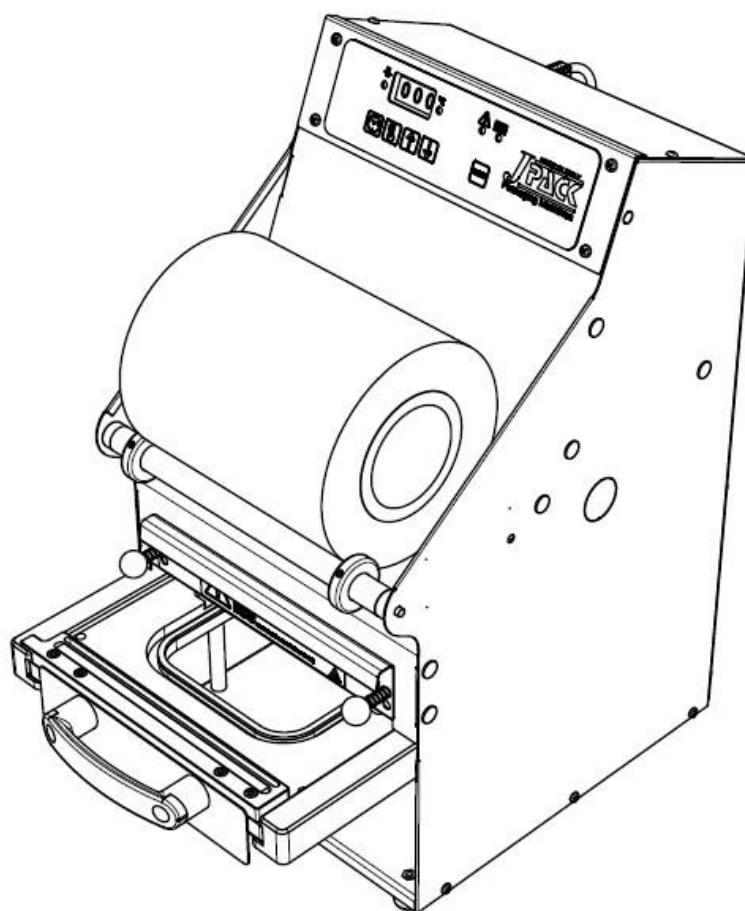


SEMI-AUTOMATIC THERMOSEALING MACHINE WITH DIE-CUT

Mod: TSS102-F



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FOREWORD

Jpack S.r.l. thanks you for your choice and welcomes you among our numerous customers, hoping that operating this machine will give you complete satisfaction.

This manual can be used for the models TSS102-F and has been designed to enable you to work on the various parts and to perform a correct maintenance and troubleshooting.

It is recommended to comply with the regulations prescribed herein, so as to achieve machine's efficiency, durability and performance.



WARNING!

READ THIS MANUAL THOROUGHLY BEFORE INSTALLING THE MACHINE.

THIS MANUAL IS AN INTEGRAL PART OF THE PRODUCT AND MUST ACCOMPANY IT UNTIL ITS DISMANTLING.

JPack S.r.l. does not assume any responsibility for direct or indirect consequences due to improper or non-conforming use of this publication and reserves the right to make technical changes to its systems and this manual without prior notice.

TABLE OF CONTENTS

FOREWORD	2
MAIN MACHINE COMPONENTS	4
1. GENERAL RULES AND WARNINGS	5
1.1 INFORMATION PROPERTY	5
1.2 HOW TO READ AND USE THIS MANUAL	5
1.2.1 STORING THE MANUAL	5
1.2.2. CONSULTING THE MANUAL	5
1.2.3. UPDATE METHODOLOGY IN CASES OF CHANGES TO THE MACHINE	5
1.3 WARRANTY TERMS AND CONDITIONS	5
1.4 SAFETY INFORMATION	6
2. INFORMATION ABOUT THE MACHINE	8
2.1 TECHNICAL SPECIFICATIONS.....	8
2.2 WARNINGS ON BOARD THE MACHINE	8
2.3 MACHINE IDENTIFICATION	9
2.4 INTENDED USE	10
2.4.1. DESCRIPTION OF THE OPERATING CYCLE.....	10
2.5 UNINTENDED USE (FORBIDDEN)	11
2.6 IMPROPER USE	12
2.7 RESIDUAL RISK MANAGEMENT	13
3. TRANSPORT AND STORAGE	14
3.1 TRANSPORT AND UNPACKING.....	14
3.2 STORAGE	15
3.3 MACHINE POSITIONING	16
4. INSTALLATION	17
4.1. ELECTRICAL CONNECTIONS	17
4.2. GAS CONNECTION FOR GAS FLUSHING (OPTIONAL-FEATURE see attached).....	17
4.3. MACHINE START TESTING	17
4.4 FILM POSITIONING.....	18
5. MACHINE OPERATION	19
5.1 START-UP.....	19
5.2 PRELIMINARY ADJUSTMENTS	19
5.3 CYCLE COUNTER.....	19
5.4 ON-SCREEN ALARMS AND WARNINGS	20
6. MOULD USAGE	21
7. MAINTENANCE AND CLEANING	22
7.1. ROUTINE CLEANING	22
7.1.1. MACHINE CLEANING	22
7.1.2. CLEANING THE THERMOSEALING UNIT.....	22
7.2 SCHEDULED MAINTENANCE	22
7.3 UNSCHEDULED MAINTENANCE	23
7.4 WIRING DIAGRAM	23
8. DISMANTLING	24
9. EC DECLARATION OF CONFORMITY	25

MAIN MACHINE COMPONENTS

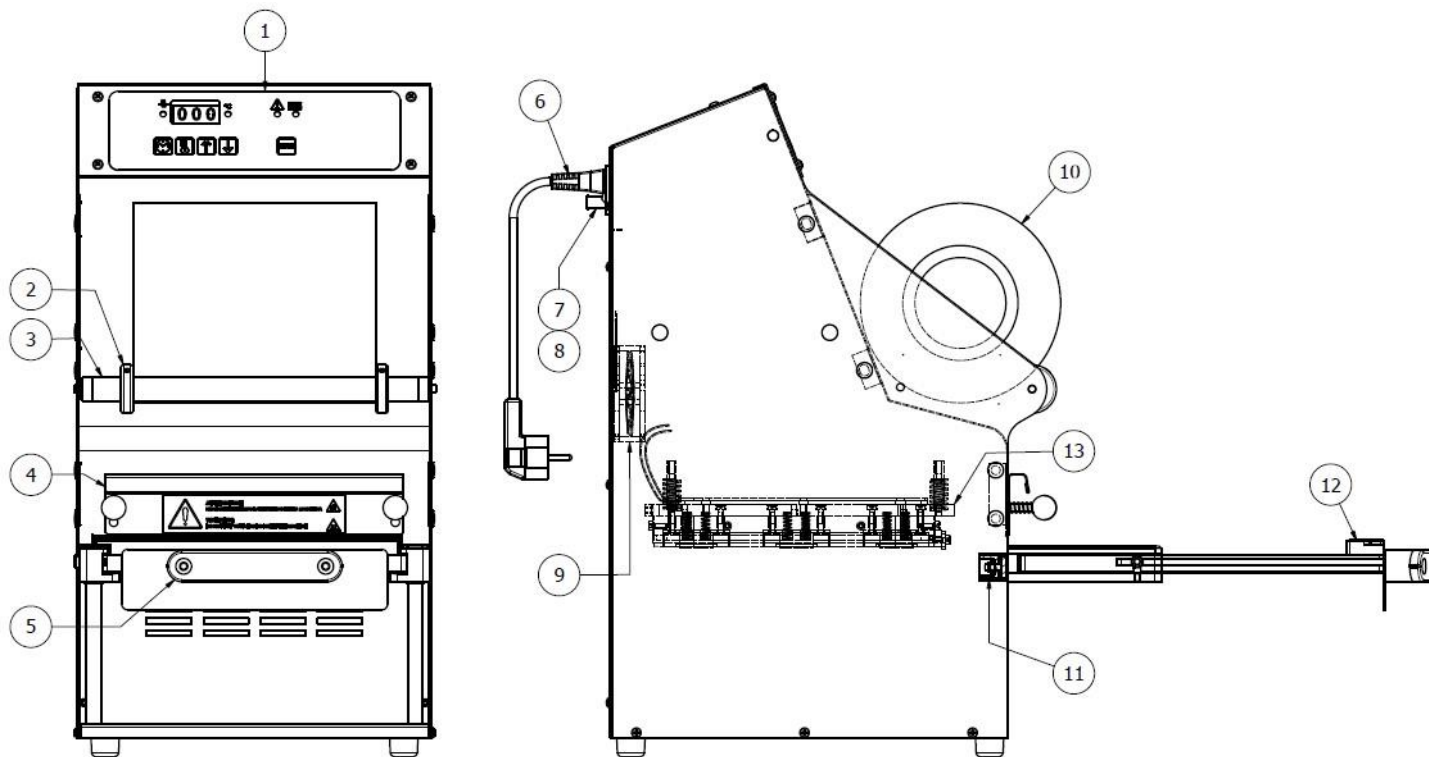


Fig. 1

1. CONTROL PANEL
2. FILM CENTRING RINGS
3. FILM REEL SUPPORT ROLLER
4. FILM PRESSER
5. MOULD OPENING HANDLE
6. POWER CORD
7. FUSE
8. POWER SUPPLY SOCKET / MAIN SWITCH 0/1
9. COOLING FAN
10. FILM REEL
11. MAGNETS' DRAG BAR
12. LOWER TRAYHOLDER MOULD (-A)
13. UPPER MOULD WITH DIE-CUT (-B)

1. GENERAL RULES AND WARNINGS

1.1 INFORMATION PROPERTY



WARNING!

THIS MANUAL CONTAINS CONFIDENTIAL PROPRIETARY INFORMATION. ALL RIGHTS RESERVED.

This manual cannot be photocopied nor reproduced, fully or partially, without the prior written consent of **Jpack S.r.l.** Only the customer - to whom this manual was provided as part of the machine kit to carry out installation, operation and maintenance of the machine it is referred to - can access this documentation.

JPack S.r.l. declares that the information herein contained comply with the technical and safety specifications of the machine referred to in this manual. The manufacturer shall not be liable for any direct or indirect damage to people, objects or pets resulting from the use of this manual or operating onto the machine in different conditions that those foreseen.

1.2 HOW TO READ AND USE THIS MANUAL

1.2.1 STORING THE MANUAL

- This manual is an integral part of the machine and therefore it is to be kept for the whole life cycle of the machine, or possibly handed over to any other user or subsequent owner.
- Use the manual so as not to damage its contents fully or partially.
- Do not remove, rewrite or tear any part out of this manual.
- Make sure that any amendments received are incorporated into the text.

1.2.2. CONSULTING THE MANUAL

For easiest reference of this manual, refer to the table of contents included in the first pages, allowing you to immediately locate the topic. The chapters are arranged following a layout that allows you to easily search for the required information.

1.2.3. UPDATE METHODOLOGY IN CASES OF CHANGES TO THE MACHINE

The descriptions and illustrations in this manual are not binding. **Jpack S.r.l.** reserves its right - without prejudice to the basic characteristics - to perform changes to the aforementioned machines at any time, for the purpose of functional, commercial and aesthetic improvement, without the obligation to update previous manuals and productions, except in exceptional cases.

Any updates or additions to the manual will be considered an integral part of the manual.

1.3 WARRANTY TERMS AND CONDITIONS

The machine is delivered to the Customer ready to be installed, after passing all the tests and inspections scheduled at the factory, in compliance with current legislation.

During the warranty period, **Jpack S.r.l.** undertakes to remove any faults and defects, provided that the machine is used correctly in compliance with the instructions referred to in its manuals.

The warranty is valid for 365 days from the date of purchase and covers all defects in materials and manufacturing found by the manufacturer.

Repairs or replacements normally take place at the manufacturer's premises. The charge for transport and labour will be borne by the purchaser.

If repairs or replacements are carried out at the purchaser's premises, the purchaser shall bear travel and labour costs. Warranty services are carried out by the manufacturer or the authorised dealer only. To be entitled to warranty services, send the defective part to the manufacturer or to its authorised dealer for repair or replacement. The return of such repaired or replaced part shall be part of the fulfilment of the warranty operations.

Warranty is void in the following cases:

- Misuse of the machine
- Incorrect installation, inadequate power supply, negligence of use and tampering
- Positioning the machine in an unsuitable environment
- Use by unauthorised personnel
- Failure to comply with maintenance instructions
- Use of spare parts or accessories not supplied or authorised by the manufacturer
- Alterations made on the machine without the written authorisation of the manufacturer
- Lack of identification plate
- Transport-related damage

Consumables, parts subject to normal wear and tear, transportation by the user to the service centre or vice versa and labour are excluded from the warranty and the purchaser will bear its costs.

A complete overhaul of the machine is recommended after one year of use. This overhaul will be carried out by the Manufacturer or authorised dealer and the Customer will bear its costs.

In case of sale to third parties, make sure that this manual is supplied with the machine and inform the Manufacturer about the new owner's data.

1.4 SAFETY INFORMATION**CAUTIONS AND SAFETY WARNINGS**

The thorough risk assessment carried out by the manufacturer allowed the elimination of most risks related to the machine operation conditions, both foreseen and reasonably foreseeable.

The complete documentation of the safety measures taken is filed at the manufacturer's premises.

Before commissioning the machine, the operator should be aware of its layout, its controls' operation and its specifications and should have read this manual thoroughly.

In any case, operators, maintenance/cleaning personnel, have to strictly comply both with accident prevention regulations and safety provisions in force in the country and factory of use. They also need to comply with all instructions, warnings and safety rules referred to in this manual.

**WARNING!**

IN CASE OF MACHINE SHUTDOWN, DURING SEALING AND FILM CUTTING OPERATIONS, PRESS THE **RESET BUTTON (Page 19 Fig. 8)** TO RESTORE IT.

OTHER PRECAUTIONS

- The user should not disassemble any parts of the machine. In case of need for extraordinary maintenance, contact JPack S.r.l.
- Do not install the machine in explosive or inflammable environments.
- Do not tamper with, remove or modify the safety devices of the machine; in such cases Jpack S.r.l. declines all liability regarding machine safety.
- Do not alter machine parts to adapt other devices without prior authorization from Jpack S.r.l.; in case of unauthorised alterations, Jpack S.r.l. will not be liable for the consequences.
- Do not operate the machine in automatic mode with the fixed and/or moving guards disassembled.
- Do not open the fuse holders with the power supply switched on.
- Do not use switches and valves without authorisation.
- Do not operate on moving parts even with objects or tools.
- Do not oil or lubricate moving parts manually.
- Before operating on the electrical system, make sure that the voltage has been disconnected.
- The maintenance technician shall have the keys of the electrical panel.
- The operator shall always switch the machine off when leaving the workplace.
- Remove the power supply plug and close the gas connection valve (optional) before any cleaning or inspection work. It is advisable to pull out the tray holder before switching off the power supply. Complete exclusion of the power supply is only ensured when the plug is disconnected.

It is absolutely forbidden to operate onto the machine without active safety guards



WARNING!

The operator, maintenance/cleaning personnel, etc. have to strictly comply both with the accident prevention regulations and the safety provisions in force in the country and in the factory of use, in addition to the instructions, warnings and safety rules contained in this manual.

During any maintenance and repairing operations, the machine stop condition is to be signalled by appropriate signs such as: “MAINTENANCE WORK IN PROGRESS”, “DO NOT RUN THE MACHINE”, etc. During these operations, make sure that switches are not reactivated by unauthorised people.

2. INFORMATION ABOUT THE MACHINE

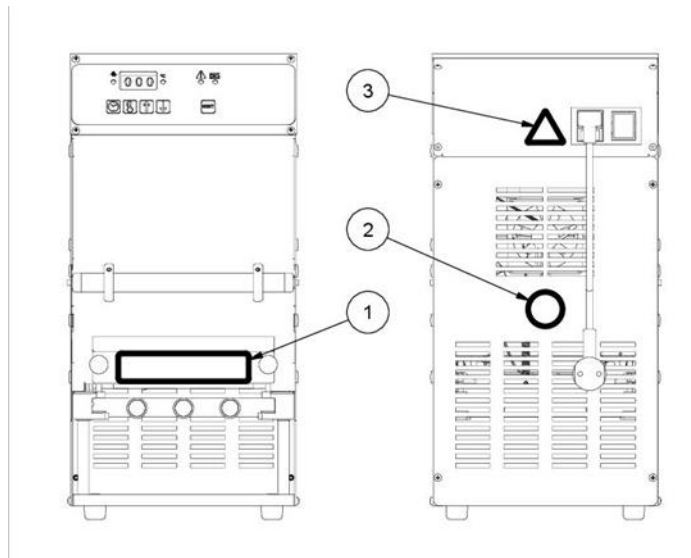
2.1 TECHNICAL SPECIFICATIONS

MACHINE, TRAYS AND REEL DIMENSIONS

Length	450mm
Width	295mm
Height	555mm
Length with tray holder removed	800mm
Overall weight	25Kg
Max. tray size	235x180 h 135 mm
Max. reel size	☛ 200mm width 210mm
Airborne machine noise	Under 70dBA.
Maximum TEMPERATURE of the sealing plate	200°
Indicative production	3-8 cycles/min, depending on packaging

Note: Productivity data are approximate only. These may vary depending on sealing parameters, product type, tray size and depth and operator skills

2.2 WARNINGS ON BOARD THE MACHINE



N°	Figura	Descrizione
1		Cumulative label 5MCTSS (304/305/323/325)
2		MANDATORY Remove electrical tension before maintenance or repair
3		CAUTION Live electrical equipment

Fig. 2

2.3 MACHINE IDENTIFICATION

On the back of each machine there is a rating plate with CE marking, main technical specifications, such as model, serial number, power, etc. All data herein are to be referred to the manufacturer if any problems arise. Make sure that the plate is always intact and attached to the machine. Otherwise contact JPack S.r.l. to request another one by paying the purchase price set by the manufacturer. The machine cannot be sold to third parties without an identification plate and this operation and maintenance manual.

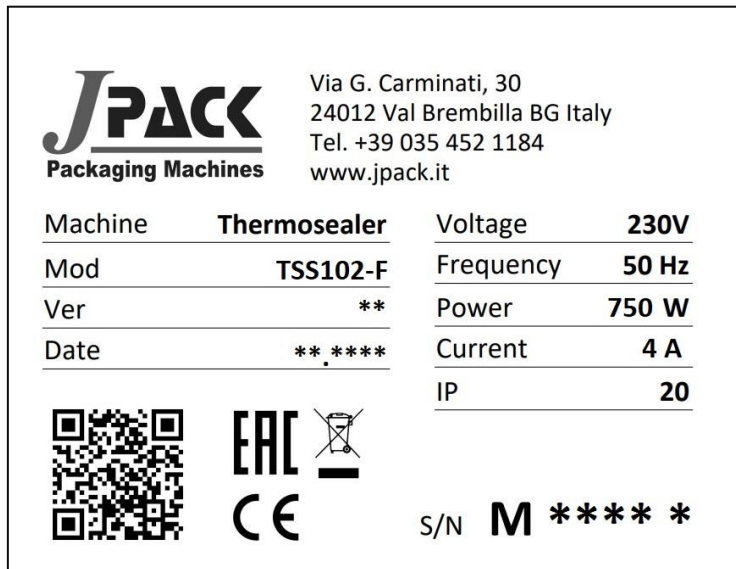


Fig. 3

2.4 INTENDED USE

The semi-automatic thermosealer TSS102-F has been designed for sealing rigid preformed plastic containers. The machine was intended to meet the needs of industries, supermarkets and shops alike and is intended for the packaging of food and non-food products, compatible with the packaging material, and does not become dangerous as a result of the machine's processing cycle. Request the technical datasheets of film and trays to the supplier

Upon request, a gas flushing system could be installed.

The TSS102-F machine allows you to operate with the following sealing modes:

- Sealing only
- Gas flushing (optional)

2.4.1. DESCRIPTION OF THE OPERATING CYCLE

The cycle follows the following stages:

1. Manual positioning of the rigid preformed trays in the tray holder.
2. Manual insertion of the lower tray holder, which, once reaching its limit position, activates the proximity detector which starts the packaging cycle.
3. Lowering the mould.
4. Gas injection (Gas flushing version - optional stage)
5. Sealing with film cutting around the tray's board.
6. Upper mould recovery phase.
7. Automatic film repositioning on magnets.
8. Manual extraction of the tray holder.
9. Removal of the film scraps.

The machine requires the presence of an operator to perform the following activities:

- Preparing the trays, filling them with the products;
- Inserting the trays in the dedicated position of the tray holder
- Closing the drawer to activate the packaging cycle
- Opening the drawer at the end of the cycle
- Removing the packed trays.

La TSS102-F is entirely made up of stainless steel and aluminium. The sealing plate and the film cutting unit are positioned inside the machine; they lower, by means of an electric motor, and sealing and film cutting around the trays' board are performed. The cutting elements then return to their up position, the film is automatically repositioned and the packaging cycle is completed. The display shows a GREEN LED (pos.5 Fig. 8) and emits the end-of-cycle sound. The operator can then open the holder, remove the sealed tray and place a new one to repeat the packaging operation. The holder with the lower tray holder slides onto anti-friction guides and is moved manually during its inlet and outlet movements.

The TSS102-F allows you to operate with single or multiple moulds. The sealing mould is fitted inside the hood, while the tray positioning one could be easily accessed.

The control panel with the electronic board is positioned in the machine upper part for convenient operation. The control is carried out by a microprocessor with nine storable programs, where the sealing plate temperature, the sealing time and the gas injection time can be set.

Optional operations: gas flushing system

It is possible to work with an additional sealing method, that can be obtained with special moulds specifically produced for this system. Instead of using the film reel, trays are sealed with pre-cut lids, which are put by hand by the operator on the open side of the trays, previously positioned in the dedicated cavities of the mould.

The lids to use can be made of either printed cardboard or semi-rigid plastic and are kept in a centered position above the trays by special references placed on the perimeter of the tray. In this case, the sealing plate presses on the lids, exerting a perimetral sealing action.

2.5 UNINTENDED USE (FORBIDDEN)

EVERY USE OTHER THAN THOSE MENTIONED IN PARAGRAPH 2.4. IS EXPRESSLY PROHIBITED.



WARNING!

EVERY USE IN AREAS OTHER THAN THOSE OF FOOD PACKAGING SHALL BE EXPLICITLY AUTHORIZED BY THE JPACK S.r.l. TECHNICAL DEPARTMENT



WARNING!

IN THE FIELD OF THE SECTOR OF EMPLOYMENT AND THE INDICATED CATEGORIES OF MATERIALS, THE USER IS LIABLE FOR THE CHOICE OF PRODUCTS TO BE PACKED, MIXTURES OF PROTECTIVE GASES, CONTAINERS AND FILMS. THE MANUFACTURER OF THE MACHINE CANNOT BE HELD LIABLE FOR FAILURE TO COMPLY WITH THE APPLICABLE LAWS AND REGULATIONS FOR THE FOOD PREPARATION OF PRODUCTS INTENDED FOR HUMAN CONSUMPTION AND SALE.



THE MACHINE USER MUST VERIFY WITH THE SUPPLIER OF TRAYS AND FILMS, THAT THEY ARE SUITABLE FOR THERMOSEALING AND THAT THEY DO NOT GIVE RISE TO HAZARDS SUCH AS FIRE OR THE PRODUCTION OF TOXIC SUBSTANCES



WARNING!

It is absolutely forbidden to pack the following types of products in order to avoid permanently damaging the machine, as well as causing injuries to the operator:

- Inflammable materials.
- Explosive materials.
- Containers with pressurised gas.
- Any unforeseen materials and products that can in any way be dangerous for the user and damage the machine

By using the specified materials, setting the correct temperatures and gas mixtures, the machine does not pose any fire risks. **In case of fire, promptly disconnect the power supply by unplugging the plug and use a “powder-type” extinguisher (NEVER USE WATER).**



WARNING!

The accident prevention devices and safety devices should not be removed or tampered with. JPack S.r.l. will not be held liable for any damage due to an incorrect use of the machine.

2.6 IMPROPER USE

Misconducts

It is forbidden to:

- introduce parts of the body inside the machine during operation;
- sit and/or lean on machines during operation (machine in operation or under electric voltage);
- use the machinery with the safety systems not working, without the protection or with protections not properly installed;
- tamper with or alter safety and protective equipment. Panels, doors, housings, photocells, micro-switches and any other devices shall not be removed;
- tamper with or remove safety labels and signs on the machine;
- change the data on the identification plate;
- modify the machine without the approval of the manufacturer;
- use the machine if it is broken or not properly working;
- throw water on motors or electrical components;
- make holes in the conduits or electrical cables;
- wear rings, watches, jewelry, torn or dangling clothing (such as ties, torn clothing, scarves, jackets unbuttoned or with open zippers) that can get caught in moving parts. The operator should also keep the hair in place to prevent it from getting caught. Use appropriate clothing and personal protective equipment such as: safety shoes, gloves, safety glasses, when operation requires it.

Events caused by negligence, but not to intended purpose, such as:

- Use of the machine without wearing the proper PPE. This behavior can cause damages to the user;
- Use of the machine without the prior check of the minimum space requirements. This behavior can lead to accidents as the user, working in limited spaces, can hurt something or stumble.

Unseemly reactions

Events due to breakdowns, accidents, ...

In case of breakdowns or anomalies in the functioning of the machine, the control panel shows alarm signals; the user shall not try to reset the alarm, but is expected to carefully read the message and understand the meaning and check the documentation provided about that specific alarm.

At this point the users shall be able to assess the seriousness of the situation to understand if they have the competences to solve the problem their selves or if they have to request the assistance of qualified personnel.

Before proceeding with eventual maintenance or repair activities the users must always disconnect the power supply and affix a clear and visible sign informing that the machine is under repair.



WARNING!

Do not tamper with, remove or modify the safety devices of the machine; in such cases Jpack S.r.l. declines all responsibility for the safety of the machine.

2.7 RESIDUAL RISK MANAGEMENT

Using thermosealing machines entails residual risks for the operator, especially when managing the moulds.

The residual risks refer to:

- Incorrect container filling methods
- Presence of hot surfaces
- Presence of tools and sharp edges
- Lowering and lifting the upper mould
- Jamming and/or faults
- Maintenance operations

The tray loading area provides access to the trays inside the machine where there are the moving parts that perform product thermosealing. This area is closed by the front guard and - when the mould is inserted - by the reference guide so as to prevent the operator from inserting his/her hands or other objects during operation of machine moving parts. The tray itself prevents the operator from accidentally or inadvertently insert his/her hands inside the work area. The tray prevents the operator from accidentally or inadvertently placing his/her hands in the work area. A sticker is applied onto the front to prevent operators from inserting his/her hands inside the machine and to avoid contact with hot parts and blades. The rear guard closes completely the machine rear. The only open areas are the small cavities to ventilate and cool the internal parts of the machine. Stickers indicating the presence of electrical voltage and the obligation to disconnect the power supply before removing the guard are applied to its rear.



WARNING!

In the event of an accident at work, the operator must immediately notify the accident to the employer or direct manager, who must assess the extent of the accident and initiate the appropriate rescue procedures.

In machine failure conditions, the parts that make up the machine are the most critical. The main criticality relates to possible problems inherent to the blocking of the thermosealing machines during the usage (preparation, equipping, production phase) during which, even with the necessary limitations, it is possible to come into contact with the working parts of the machine. To avoid unexpected movements of the machine, it is mandatory to remove the plug from the power supply before intervening!

JPACK recommends you to always check the machine condition before and constantly during operations. If the check is unsuccessful, JPACK recommends you to operate onto the machine when power supply has been disconnected, contacting a qualified maintenance technician as soon as possible.

During commissioning and/or maintenance operations, it may be necessary to operate onto moving parts, especially during maintenance phases when it is allowed to carry out operations without enabled guards.

The person carrying out this type of maintenance is to be specially trained and provided with the appropriate personal protective equipment, such as protective gloves against the risk of cuts and burns.

3. TRANSPORT AND STORAGE



WARNING!

All machine handling operations shall be carried out by qualified and authorised personnel.

3.1 TRANSPORT AND UNPACKING

The instructions in this section should be observed during machine transport phases, which may occur in the following situations:

- Storing the machine.
- First machine installation.
- Relocation of the machine.

Except in special cases, the machine is delivered completely assembled and packaged on a pallet or inside a crate. Transportation over long distances by lorry or other means is to be carried out under normal supply conditions, i.e. with the equipment packaged and stably fastened to the loading platform. The Carrier and the user are held liable for the machine's transport. In case of accident or delayed delivery the Manufacturer is not liable.

For handling over short distances, the packaged vacuum machine can be lifted and moved with a forklift or similar means.

Since the unpacked machine is not equipped with specific attachments, it can only be lifted from the lower part of its body.

When transporting and positioning the machine, it is recommended to manoeuvre it very carefully. Never turn it upside down or tilt it, to avoid damage.



WARNING!

Check its status via an internal visual inspection. Any deformations of the visible parts indicate impacts sustained during transport that could jeopardise its normal operation. In particular, check that the following parts are in good condition:

- External parts of the machine.
- Electrical cables.

The carrier shall be liable for any damage occurring during transport, that should be reported immediately to JPack S.r.l.

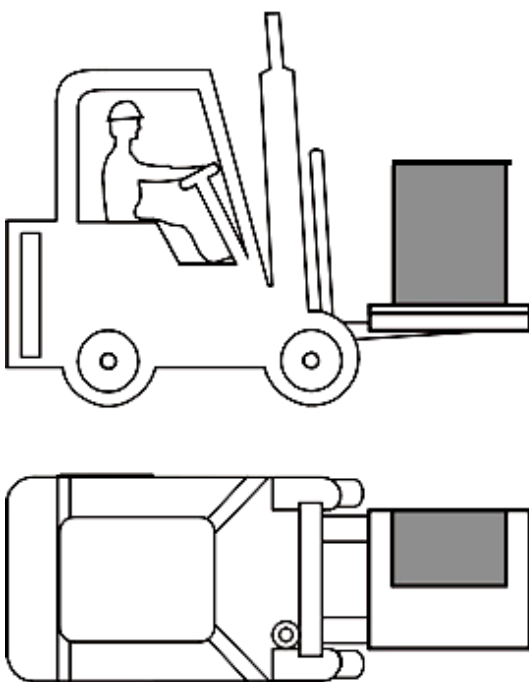


Fig. 4

3.2 STORAGE

The instructions given in this section should be observed if the machine is to be stored, even temporarily.

STORAGE SPECIFICATIONS

- Allowed temperature range: -15°C - +55°C.
- Allowed humidity range: 30 – 90%.
- Adequate natural and/or artificial lighting.
- Suitable weather protection.
- Adequate space to lift and transport the equipment in a safe and easy way.
- Horizontal bearing surface

3.3 MACHINE POSITIONING

In addition to the overall dimensions of the machine that will be shown below, the following conditions are to be met:

- The power supply sources should be arranged near the installation area, according to the machine data.
- The operator shall use the machine without hindrance. The lateral distances to ensure adequate cooling, compared to the nearest wall or the nearest object should comply with the diagram in Fig. 5.

MINIMUM INSTALLATION DISTANCES

Ensure there is adequate space for easy operation and maintenance. Place the machine in the intended space, which should be free of humidity, inflammable materials, gases and explosives.

THE WORKING POSITION IS THE ONE SHOWN IN THE FIGURE ONLY ONE PERSON FOR MACHINE.

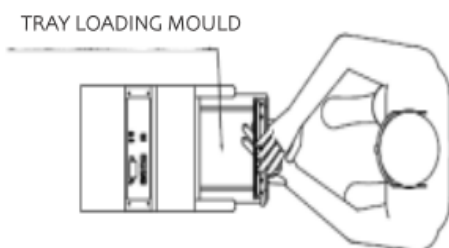
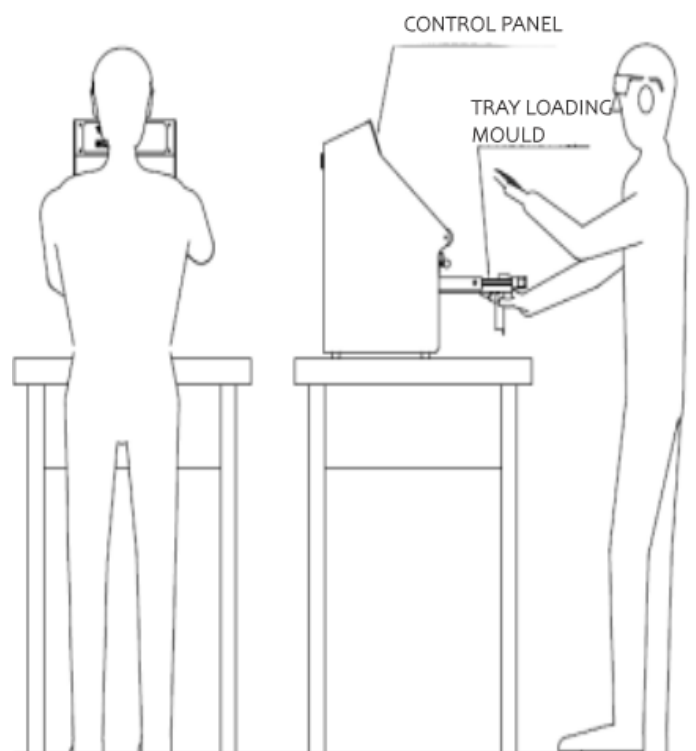
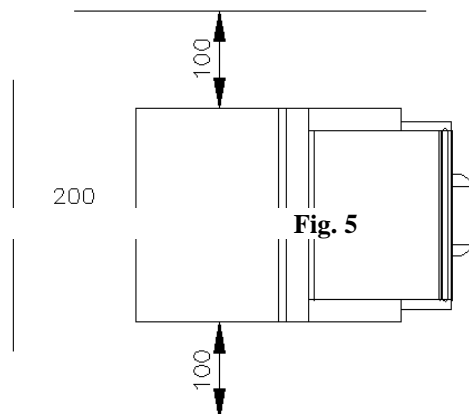


Fig. 6



WARNING!

ONLY THE OPERATOR IS IN CHARGE FOR THE LOADING / UNLOADING AND WORKING AREA (MACHINE FRONT (Fig. 6). THIS AREA IS TO BE KEPT UNDER CONTROL WITHOUT LIMITATIONS OR OBSTACLES AND USED TO PREVENT UNAUTHORISED PERSONNEL FROM APPROACHING.

4. INSTALLATION



WARNING!

All installations shall be carried out only by qualified and authorised personnel.

4.1. ELECTRICAL CONNECTIONS

Switch the machine off to carry out all main power supply connection operations.

The connection of the machine to the mains and the protective device at the power socket should be carried out in compliance with the regulations in force in the user's country. Make sure that the values of the machine power and frequency supply voltage (see plate on the electrical cabinet) correspond to the power supply net values.

1. Upstream of the machine power supply circuit, install an automatic protection device with a breaking capacity higher than the value of the maximum short circuit current I_{cc} stated in the table.
2. The phase + neutral + earth sockets are to be suitable to the recommended type and are to be protected upstream.
3. Before checking the electrical connection, be sure that the machine main switch is in the O (off) position.
4. Insert the plug into the socket.

Rated voltage	230V
Frequency	50Hz
Maximum power	750W
Fuse on socket	6.3 A delayed-type

The machine is equipped with an electric cable with a two-pole plug to be inserted into the wall power socket. Do not use multiple sockets



WARNING!

THE GROUND CONNECTION IS REQUIRED BY LAW!

4.2. GAS CONNECTION FOR GAS FLUSHING (OPTIONAL-FEATURE see attached)

4.3. MACHINE START TESTING

Before carrying out ordinary and continuous operations onto the machine, check machine performance, running at least ten packaging operation cycles.

If problems occur during the test, contact **JPack S.r.l.** Customer service immediately. In these cases whatever dismantling, fixing or set-up operations may be very dangerous.

4.4 FILM POSITIONING

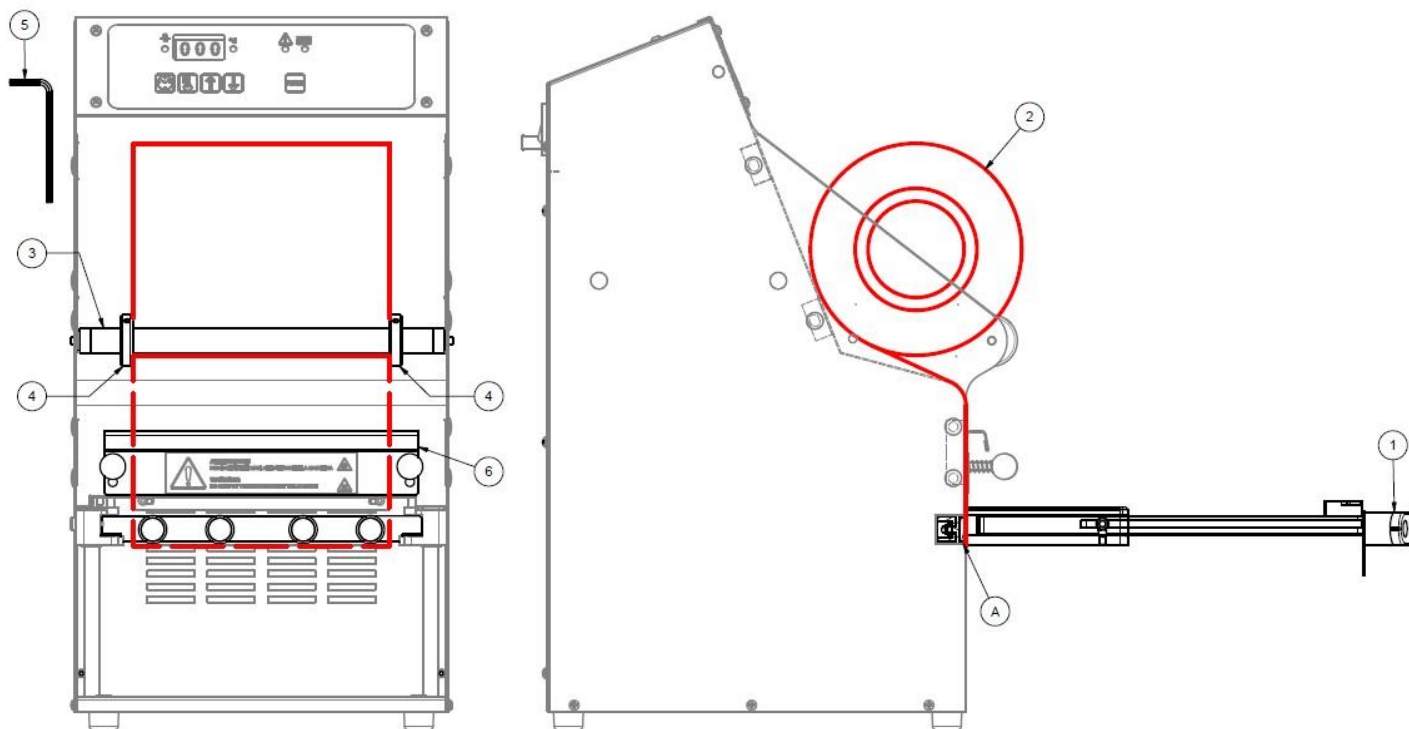


Fig. 7

When positioning the film reel, the power supply should be disconnected and the trayholder pulled out (pos.1 Fig. 7). Position the film reel (pos.2 Fig. 7) onto the roller (pos.3 Fig. 7) and centre it by means of the corresponding centering rings (pos.4 Fig. 7) (lock the rings using the 3mm hexagonal wrench (pos.5 Fig. 7)).

The film should be inserted under the film presser (pos. 6 Fig. 7) and positioned at the height of the lower profile of the magnets (pos. A Fig. 7).

Locking of the film between the magnets and the tray holder allows its automatic repositioning during the work cycle by dragging.



WARNING!

When the tray holder is in the loading or unloaded position for cleaning or mould change-over, even when the machine is off, do not put your hands inside the machine because of the risk of cut by touching the blade.

Before cleaning the inside of the machine, make sure that the electric power supply have been disconnected and that the sealing plate has completely cooled down.

5. MACHINE OPERATION

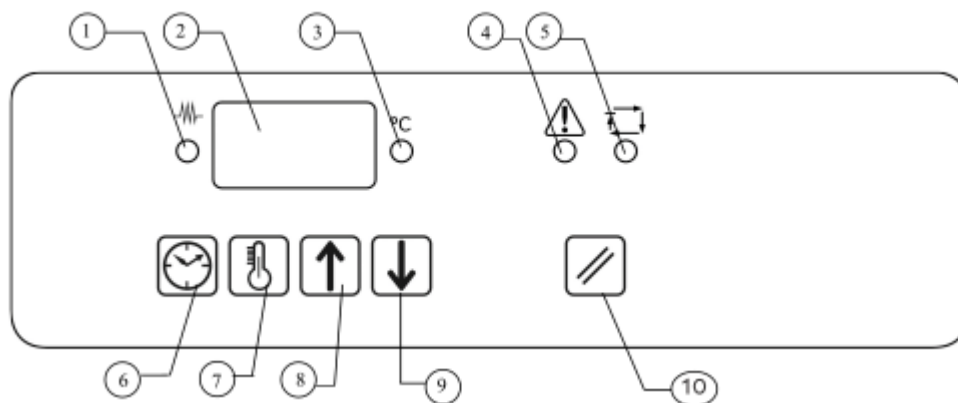


Fig. 8

1. LED RESISTOR POWER SUPPLY
2. DISPLAY
3. SEALING PLATE LED IN SET TEMPERATURE
4. ALARM LED
5. END-CYCLE LED
6. SEALING TIME DISPLAY BUTTON
7. SEALING TEMPERATURE DISPLAY BUTTON
8. INCREASE BUTTON
9. DECREASE BUTTON (partial cycles' display)
10. RESET BUTTON (program no. display)

5.1 START-UP

SWITCHING ON THE MACHINE

Turn the main switch (pos.8 Fig.1) of the electrical control panel to position 1. The number of the last stored packaging program will then appear on the control display.

5.2 PRELIMINARY ADJUSTMENTS

The following preliminary operations should be carried out before processing:

CHOICE OF PACKAGING PROGRAMS

The TSS102-F thermosealing machine can store up to nine different sealing programs. To select the program to carry out operations, press the RESET (pos. 10 Fig. 8) and the program currently operating will be displayed. Pressing the RESET button and buttons 8 or 9 simultaneously changes the program. Time and temperature values are automatically stored when the sealing program is changed.

SEALING TEMPERATURE SETTING

Press button 7 and buttons 8 or 9 simultaneously to increase or decrease the sealing temperature. The maximum adjustable temperature is +200°C.

SEALING TIME SETTING

Press button 6 and buttons 8 or 9 simultaneously to increase or decrease the sealing time. The maximum adjustable time is 5s.

5.3 CYCLE COUNTER

The TSS102-F thermosealing machine is equipped with a cycle counter. This partial counter stores the number of sealing operations carried out from the machine switching on to its switching off. When pressing button 9, the number of cycles carried out since the last start-up is displayed. The maximum number of cycles that can be displayed is 999. The cycles are automatically reset when the machine is switched off.

5.4 ON-SCREEN ALARMS AND WARNINGS



WARNING

1. The display shows **STA** = The machine has been switched on with the mould inserted, remove the mould to start processing.
2. The display shows **ALS** and the red LED is on = Thermal probe faulty or disconnected.
3. The display shows **HOT** and the red LED is on = Temperature out of control.



WARNING!

- Thermostealing operations cannot be carried out before the sealing plate has reached the set temperature (LED pos.3 Fig. 8). The machine does not perform the cycle.
- If an abnormal condition stops the cycle and the “alarm” LED is triggered (LED pos.4 Fig. 8), press the reset button (pos.10 Fig. 8) to restore the machine operations.
- Once the cycle has started, a mechanical device prevents the holder from being removed.



WARNING!

In case of malfunctions while turning the machine on, check the fuse in the “FUSE HOLDER” of the 0/1 main switch at the machine rear. Check that it is in good condition and correctly inserted into its seat.

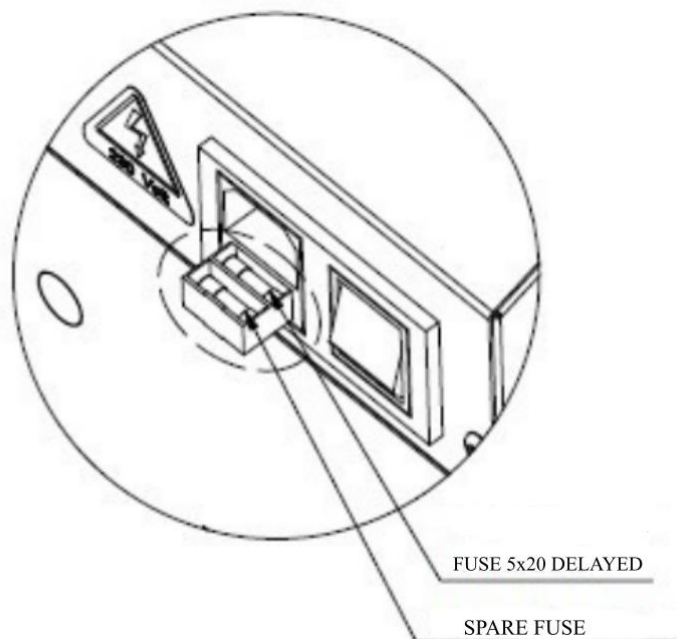


Fig. 9

6. MOULD USAGE



WARNING!

Before performing mould maintenance operations, please refer to chapter 2 “MACHINE INFORMATION”.



WARNING!

The TSS102-F thermosealing machine is equipped with a sealing plate fitted into the mould upper part. Due to the presence of heating plates and blades on the mould upper part that could damage the operator, the operations should be carried out with the utmost care.

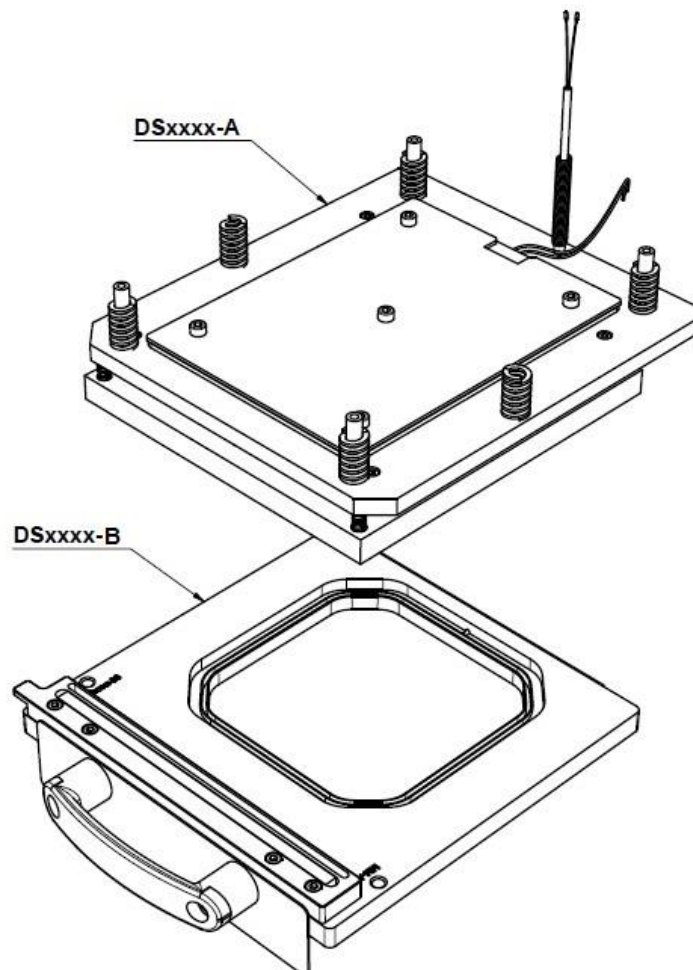
Turn off the electric power. Wear protective gloves against cuts and burns.

The thermosealer TSS102-F is equipped with a die-cut. The sealing plate and the blades on the mould upper part and the lower trayholder are shaped and suitable for the packaging of a single format of trays. The film is cut around the border.

La termosaldatrice TSS102-F è dotata di stampo fisso con fustellatura. La piastra saldante e la lama presenti nel controstampo superiore e il portavaschette inferiore sono sagomati e adatti al confezionamento di un singolo formato di vaschette, attorno al cui bordo viene tagliato il film.

Since the machine is fitted with a fixed upper mould with die-cut and a dedicated trayholder, it is not possible to operate the mould change-over.

N.B. be sure that the trays to be sealed are compatible with the employed mould, otherwise do not try to seal any other tray.



7. MAINTENANCE AND CLEANING



WARNING!

Disconnect the mains power cord before starting any maintenance operations

The following operations can be carried out after:

- Turning the main switch to the “OFF” position.
- Disconnecting the power supply plug and gas supply.
- Waiting for sufficient time to allow the machine and in particular the sealing plates inside the mould to cool.

In order to ensure the proper operation of the machine and safety conditions, perform routine maintenance operations on the machine at regular intervals.

7.1. ROUTINE CLEANING

The *TSS102-F* thermosealing machine is manufactured in full compliance with current regulations, with a degree of protection making it highly resistant to external agents.

Nonetheless, it should be used with care, as the IP20 rating provides protection against splashing, but not against great masses of water. Keep this always in mind while cleaning. At the end of the working day, perform a thorough general cleaning of the machine. Clean the machine more frequently when carrying out operations in dusty environments. It is recommended to clean also the inner parts.

7.1.1. MACHINE CLEANING

- Use soft cloth;
- Use non-abrasive or corrosive detergents suitable for food use;
- Use a vacuum cleaner to remove dusts and products' residues.

Using the tools indicated above, proceed with cleaning the external parts of the machine.

Whenever the need arises, clean the body in "stainless steel" using products dedicated to the materials indicated.



WARNING!

NEVER USE WATER OR HIGH-PRESSURE WATER JETS

In particular, avoid the use of gasoline, nitro diluent, perchloroethylene, trichloroethylene, etc.

7.1.2. CLEANING THE THERMOSEALING UNIT

To clean the **LOWER MOULD**, proceed as follows:

1. Remove the tray holder mould (pos.12 Fig.1).
2. Wash the removed part with detergent.
3. Always check that all the tray holder seals are intact and in the correct position.
4. Reinsert the tray holder mould in its correct position.

Wear safety gloves against the risk of cuts.

7.2 SCHEDULED MAINTENANCE



WARNING!

IT IS NECESSARY TO REGULARLY PERFORM THE MAINTENANCE ACTIVITIES ON MACHINE AND MOULDS TO ENSURE THAT MACHINE AND MOULDS ARE KEPT IN GOOD CONDITIONS, SUITABLE FOR A SAFETY USAGE.

7.3 UNSCHEDULED MAINTENANCE



WARNING!

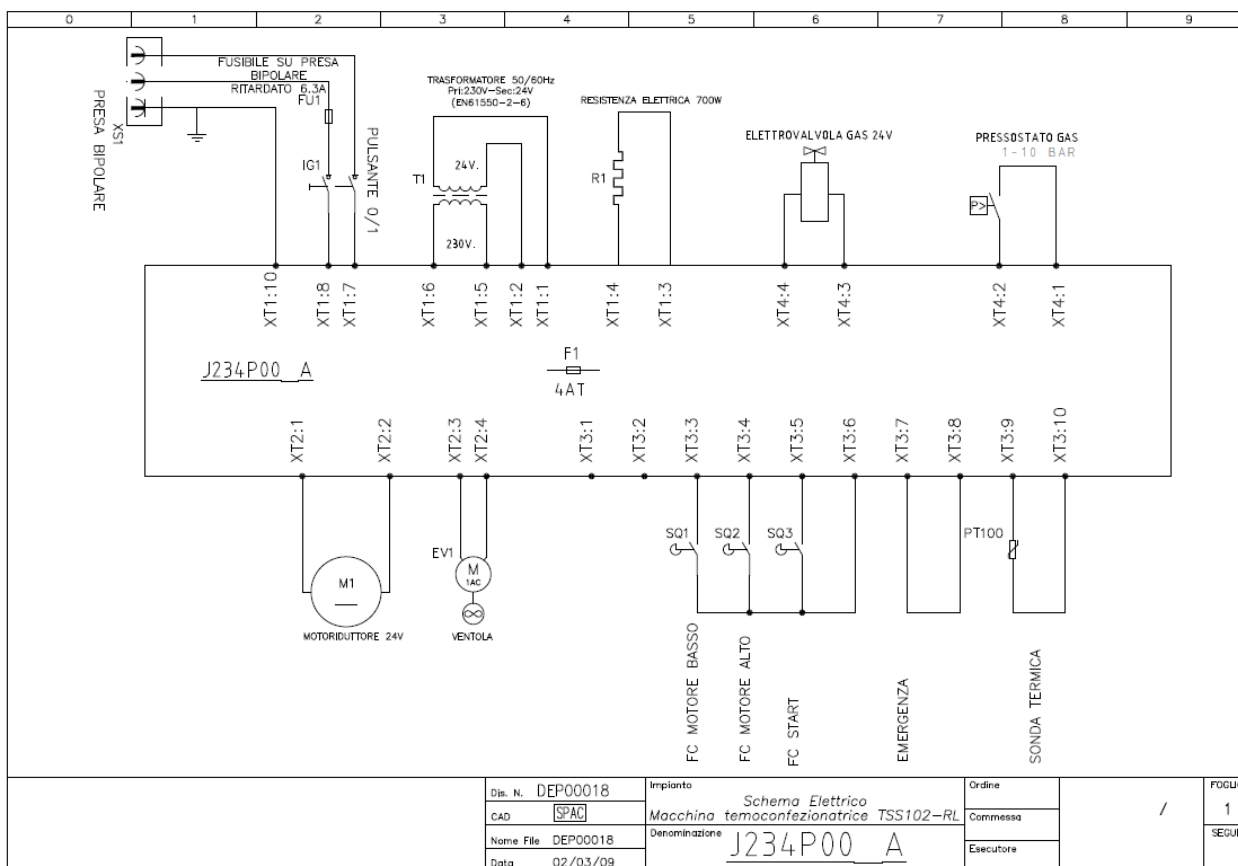
The user should never dismantle any parts of the machine. In case of need for extraordinary maintenance, contact JPack S.r.l.

In the event of a fault, unscheduled maintenance should be carried out by a specialised technician, contacting the service department.

The correct identification of the main components can be carried out by referring to the technical documentation attached to this file, the lists of materials shown in the diagrams of the command and control systems or directly on the labels of the individual components.

A complete overhaul of the machine is recommended after one year of use. This overhaul will be carried out by the Manufacturer or authorised dealer and the Customer will bear its costs.

7.4 WIRING DIAGRAM



8. DISMANTLING

**WARNING!**

All machine dismantling operations should be carried out by qualified and authorised personnel.

SCRAPPING OF THE EQUIPMENT

Once the end of the machine's technical and operational life has been reached, the machine is to be scrapped. Even when the machine is decommissioned and no longer used for the purposes for which it was designed and manufactured, reusing the raw materials making it up should be possible.

Deactivation procedure:

- Switch off the machine according to the procedures described in the "Using the machine" chapter.
- Remove the plug from the power socket.
- Disconnect the gas supply.
- Take a wire cutter and cut the power cable flush with the inlet fitting of the machine.
- Lock the front tray holder by binding it with adhesive tape.

The machine does not contain dangerous components or substances that require special removal procedures. Remove the different pieces that make up the machine and separate them according to the material they are made of. Dispose of the parts that make up the machine according to the local regulations in force.

9. EC DECLARATION OF CONFORMITY

Noi / We / Wir / Nous / Nosotros:

J PACK SRL

Via G. Carminati, 30, 24012 Val Brembilla (BG) ITALY

I. dichiariamo sotto la nostra esclusiva responsabilità che il prodotto
U.K. declare under our exclusive responsibility that the product
D. erklären unter unserer ausschließlichen Verantwortung, dass das in dieser Erklärung genannte Produkt
F. déclarations sous notre exclusive responsabilité que le produit
E. declaramos bajo nuestra exclusiva responsabilidad que el producto

I. è conforme a quanto prescritto dalle seguenti direttive e successive modifiche:
U.K. is in conformity with the requirements prescribed by the following directives and the subsequent amendments:
D. den Vorschriften der folgenden Richtlinien mit späteren Änderungen entspricht:
F. est en conformité avec les prescriptions indiquées par les directives suivantes et leurs modifications successives:
E. está conforme con lo dispuesto en las siguientes directivas y sus sucesivas modificaciones:

2006/42/CE	Machinery directive
2014/30/UE	EMC directive
1935/2004/CE	Food Contact Regulation

I. E inoltre dichiariamo che sono state applicate le seguenti norme armonizzate:
U.K. And furthermore, we declare that the following harmonised standards have been applied:
D. Und außerdem bestätigen wir, dass die folgenden harmonisierten Normen angewandt wurden:
F. Et en plus, nous déclarions que les normes harmonisées suivantes ont été appliqués :
E. Y además declaramos que han sido aplicadas las siguientes normas armonizadas:

CEI EN 60204-1 : 2018
UNI EN ISO 12100 : 2010
UNI EN 415-3 : 2010
UNI EN ISO 13857 : 2020
UNI EN ISO 14120 : 2015
UNI EN ISO 14119 : 2013

The technical manufacturing file of the machine has been designed by:

Name Salvi Pierbattista
 At JPack
 Issued in [place] Via G. Carminati 30 24012 Val Brembilla (BG) ITALY
 Date 01.09.2023
 Name and status of the signatory [Salvi Pierbattista, CEO]



Signature

To achieve **MAXIMUM RESULTS** from our machines, read
this manual carefully.



To ensure a safe and perfect performance of your machine,
always use **ORIGINAL SPARE PARTS**

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