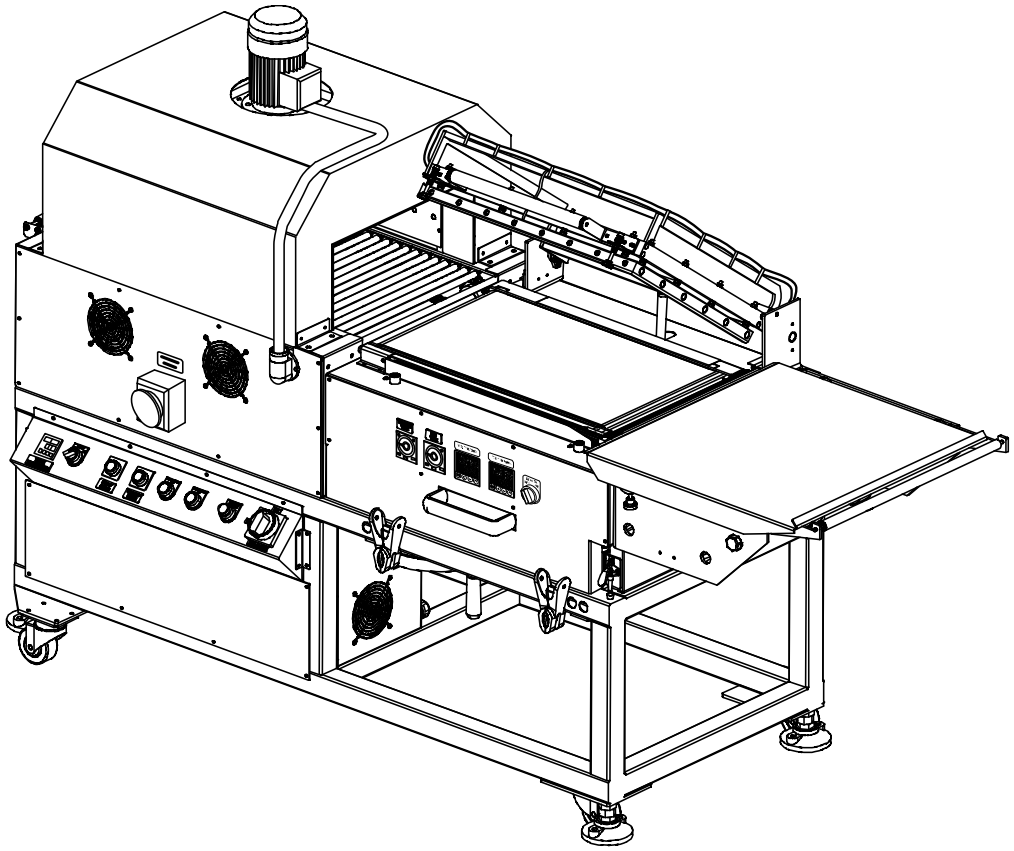
VS1620-TKV1

Hot-Knife L-Sealer & Heat Tunnel Combo
Value Series

User Guide



EASTEY®

VS1620-TKV1

Hot-Knife L-Sealer & Heat Tunnel Combo Value Series

User Guide

This User Guide is also available in digital form at:
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Check periodically for the most current revision.

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Contents

Who We Are: We Help Companies Deliver Products to the World 7
This User Guide is available online 7

Safety 8
Lockout / Tagout 8
Lockout/Tagout on the Eastey VS1620-TK Hot Knife L-Sealer and Tunnel Combo 8
Safety Precautions 10
Explanation of Symbols 11

Introduction 12
VS1620-TK Hot-Knife L-Sealer and Heat Tunnel Combo 12
System Overview 12
VS1620-TK Hot-Knife L-Sealer & Tunnel Combo Application Videos 13
Specifications 14
Dimensions 14
Machine Serial Number 15
Typical Applications 15
Eastey VS1620-TK Value Series Hot-Knife L Sealer and Tunnel Combo 15

Installation and Set Up 16
Unpacking 16
Assembly 16
Product Tray 16
Power Cord 17
Location Requirements 17
Aligning the Seal Head Limit Switch and Actuator 18
Loading the Film 18
Threading the Shrink Film 20
Aligning the Heat-Shrink Tunnel 21
Seal Head Height Adjustment 22

Operation 23
Sealer and Tunnel Operation 23
Main Power 24
Conveyor and Blower 24
Tunnel Heater 24
Tunnel Temperature 25
Blower Speed 25
Conveyor Speed 25
E-Stop or Emergency Stop 26
Sealer Operation 26
Seal Power Off / On 26
M.D. Thermo and T.D. Thermo — L-Seal Temperature Controls 26
Seal Time 28
Take Away Time 28
Sealing the Product 29
Shutting Down 29
Special Notes About the Tunnel Shutdown Sequence 30

Maintenance 31
Sealer 31
Daily 31
Shrink Tunnel 32
Daily 32
Monthly 32
Cleaning 32
Silicone Rubber Seal Pad Replacement 32
Changing Hot-Knife Inserts and Cutting Rules 33
Rollers 33

Troubleshooting 34

Parts List 36
VS1620-TK Sealer Tunnel Combo Unit 36
Main Assembly – VS1620-TKLR Live Roller VS1620-TKMB Mesh Belt 36
Base Frame with Takeaway Height Adjustment – VSSA0264 37
Takeaway Conveyor Assembly – VSSA0265 39
Heat Tunnel Assembly with Live Roller Conveyor – VSTA0069LR 41
Heat Tunnel Hood & Heaters – VSTA0070 42
Heat Tunnel Support & Conveyor with Live Rollers – VSTA0071LR 44
Heat Tunnel Assembly with Wire Mesh Belt Conveyor – VSTA0069MB 46
Heat Tunnel Hood & Heaters – VSTA0070 47
Heat Tunnel Support & Conveyor with Wire Mesh Belt– VSTA0071MB 49
L-Sealer and Support with L-Seal Controls – VSSA00266 51
L-Sealer Upper Frame – VSSA0314 52
L-Sealer Mid Frame with L-Sealer Controls – VSSA0314 54
Product Tray with Film Holder and Perforator – VSSA0267 56
Main Electrical Panel and Tunnel Control Panel – VSCP0038 58
Electrical 60
Electrical Panel Layout (Sheet 1 of 2) 60
Electrical Panel Layout (Sheet 2 of 2) 61
Electrical Parts List 62

Appendix A 63
Electrical Schematic (Sheet 1 of 3) 63
Electrical Schematic (Sheet 2 of 3) 64
Electrical Schematic (Sheet 3 of 3) 65

Warranty Statement Shrink Packaging Equipment 66

Customer Support 69

We Help Companies Deliver Products to the World

Thank you for choosing the Eastey VS1620-TK Value Series Hot Knife L-Sealer and Heat Tunnel Combo system for your packaging needs. Eastey is part of Engage Technologies, an ISO 9001-2015 certified company that has steadily built a solid reputation for quality since 1979. Engage is known for providing rugged, durable, reliable packaging equipment to help companies deliver their products to the world.

Each Engage Technologies company – Squid Ink, Eastey, and American Film & Machinery (AFM), focuses on a different part of the packaging section of the production line.

ENGAGE *technologies corporation*

Squid Ink (www.SquidInk.com)
Coding and marking equipment, inks, and fluids for product identification and traceability

Eastey (www.Eastey.com)
Automated shrink wrapping and bundling, automated case sealing, case erecting and product handling

AFM (www.AFMSleeves.com)
Automated shrink sleeve labeling equipment, tamper-evident banding equipment, shrink tunnels and shrink sleeve consumables

When you purchase your packaging equipment from the Engage Technologies family of companies, you can feel confident that you have a machine that is first in quality and built to last. Thank you for choosing us for your packaging needs.

This User Guide is available online

This User Guide is also available from the Eastey Support Website in electronic format for web browsers and e-readers. Go to Eastey.com/Support/User-Guides-Drawings to see available User Guides, or scan the QR Code at right using the camera app on your mobile device to go directly to the online version of this User Guide.

Safety

Read this manual carefully and make it available to everyone connected with the supervision, maintenance, or operation of this machine. Additional copies are available on request (Eastey.com/contact-us).

The development of a good safety program that is rigidly enforced is absolutely imperative when involved in the operation of industrial equipment. Our machinery is well designed and includes extremely important safety features. However, proper installation, regular maintenance, and safe operation procedures are of far greater importance for safety of the operator and others 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.

Lockout / Tagout

Lockout/tagout procedures are safety-related practices developed, documented, and implemented by your company. Lockout/tagout procedures require safely shutting down and disabling the energy input to the machine and any connected equipment that could result in injury or equipment damage if accidental startup were to occur during inspection, maintenance, adjustment, or repairs. Part of disabling the energy input typically involves applying physical lock(s) to the energy input(s) so that the system cannot be accidentally restarted. Typical energy inputs include electrical, air, fluid, hydraulic, gravity, heat, or steam.

Your company must have lockout/tagout procedures in place for this machine before use. To prevent injury or equipment damage due to accidental startup, all inspection, maintenance, adjustments, or repairs to the machine must be governed by your company's lockout/tagout procedures and OSHA requirements and best practices.

WARNING: Failure to follow lockout/tagout practices can result in serious injury and/or equipment damage and may void the warranty

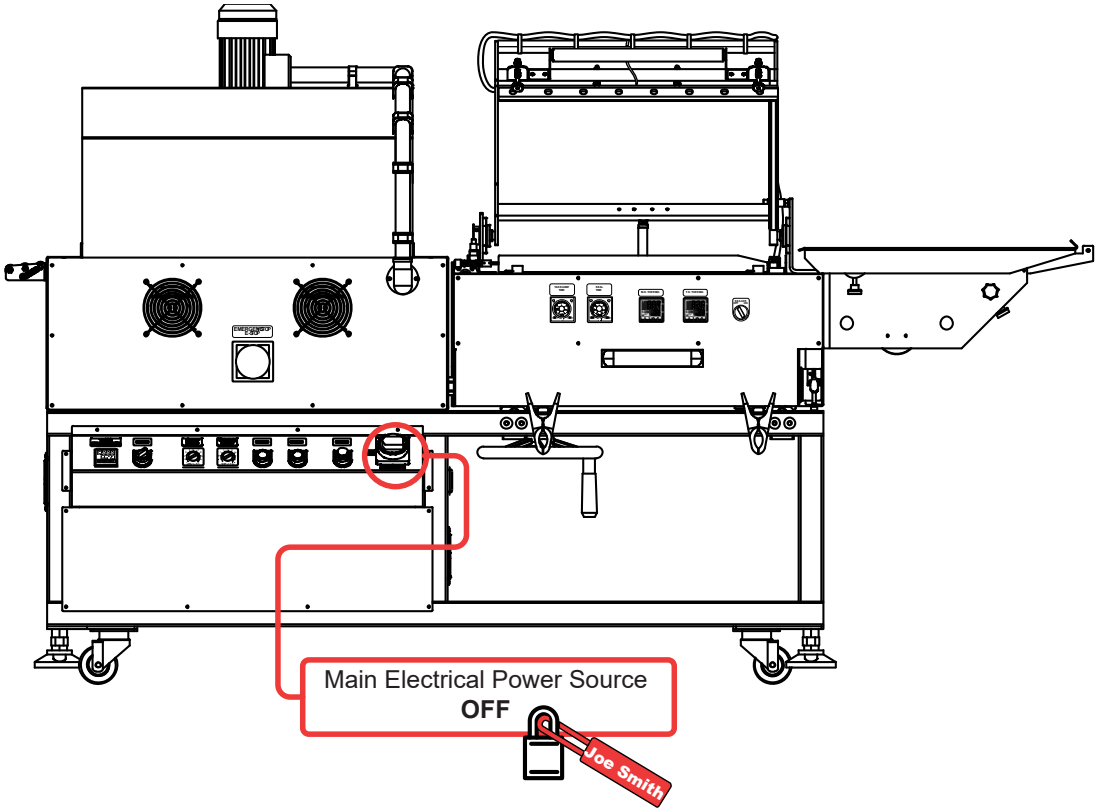
Note: OSHA provides information on lockout/tagout best practices consistent with Title 29, Code of Federal Regulations (CFR), Part 1910.147 and 1910.333, as a basis for companies to develop their own lockout/tagout procedures.

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

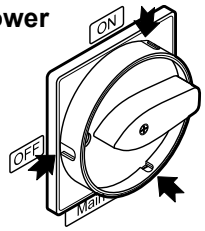
Lockout/Tagout on the Eastey VS1620-TK Hot Knife L-Sealer and Tunnel Combo

Energy input for the Eastey VS1620-TK Value Series Hot Knife L-Sealer and Heat Tunnel Combo is electrical. Power down the system prior to lockout/tagout: shut off power to the sealer and turn off heat to the tunnel, following the tunnel shutdown procedure as described in the operation section. When the tunnel has cooled down to approximately 150°F (66°C), turn the main power switch Off to turn off power to the machine.

The VS1620-TK Combo Unit Main Electrical Power Switch has the capability for lockout/tagout in that it can be secured with a padlock in the Off position.



Combo Unit
Main Electrical Power



Note: Lockout mechanism(s), padlock(s), and identification tag(s) are the responsibility of your company in accordance with your company's lockout/tagout rules and procedures, and are not provided by Eastey.

Disconnect (unplug) the power cord from electrical energy input and follow the lockout/tagout rules and procedures developed by your company.

Be sure to follow your company's lockout/tagout procedures for the Eastey VS1620 and all equipment connected to it, for example, printers or scanners or accumulation or heat shrinking equipment, in accordance with your company's lockout/tagout procedures.

Safety Precautions

Before installing, operating or servicing this equipment, please read the following precautions carefully: To minimize the potential for personal injury or damage caused by improper use, always be sure that the machine operators and others working on the machine are properly trained in the correct use of the equipment and properly instructed regarding the safety procedures for operation.

- Always disconnect electrical power and allow oven tunnel temperature to cool to ambient air temperature before attempting maintenance to any electrical or moving parts, following the Lockout / Tagout best practices as governed by your company and OSHA.
- Do not stand or climb on any part of this machine at any time. Do not place hands, head, or any part of the body inside the confines of the machine unless the mechanism is securely restrained and the electrical supply is shut off and all sources of energy for the machine have been neutralized and locked out / tagged out in accordance with your company's lockout/tagout best practices,
- Do not tamper with electrical wiring. Use only licensed electricians to check or repair electrical wiring. Use only the specified power supply cable. Do not use the power cable to pull or position the machine, as this will damage or break the cable. If the power cable appears worn or cracked, replace it immediately with a new power cable of the same rating.
- In order to prevent damage to the machinery or injury to personnel, do not increase the factory settings on either the mechanical or electrical overload devices. Do not make any modifications to either the electrical circuitry or the mechanical assemblies of this machinery. Do not operate a machine if such modifications have been made.
- Keep hands away from moving conveyors and moving parts. Never provide service or attempt to clear a jam when the machine is running. Safely shut down the machine before attempting to clear a jam. Refer to your company's lockout/tagout rules and procedures. Conveyor belts that have become worn or frayed or damaged through use 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.
- Do not attempt to operate the machine with loads that exceed the limits of use and operation in regards to weights and sizes, or with unstable loads that present a hazard of tipping or falling.
- Heat sealing and heat shrinking equipment can become very hot after a period of use. Keep hands away from hot surfaces if the machine is in operation or has been running recently.
- 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.

- Adequate ventilation should be provided at all times. The use of certain types of plastic film in sealing or shrinking equipment may result in the release of hazardous fumes due to the result of degradation of the film at high temperatures. Before using any plastic film in this equipment, the manufacturer or supplier of the film should be contacted for specific information concerning the potential release of hazardous fumes.
- 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. Caution indicates a hazardous situation which, if not avoided could result in minor or moderate injury or damage to equipment or nearby property.

Electrical hazard. Indicates caution, electrical shock hazard. Allow only a trained electrician to open the door or cover of the electrical panel or box. Shut off electrical power before attempting to open or work on the electrical box, junction boxes, or other electrical components of the unit.

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

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

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

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

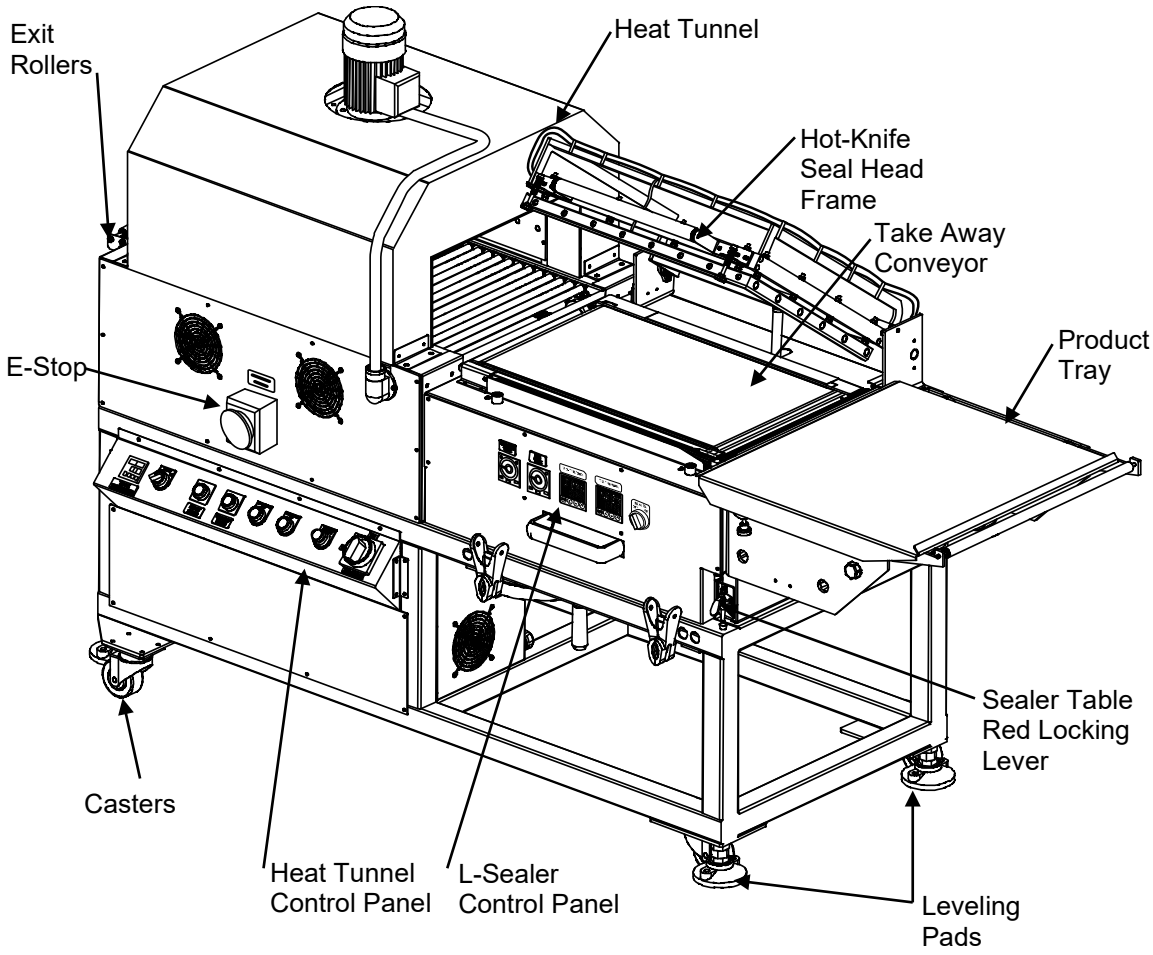
Moisture hazard. Keep the equipment dry. This equipment is designed for indoor operation in a typical clean, dry factory environment, protected from rain and moisture. Do not operate the machine in any extremely wet or oily environment that may exceed operating specifications.

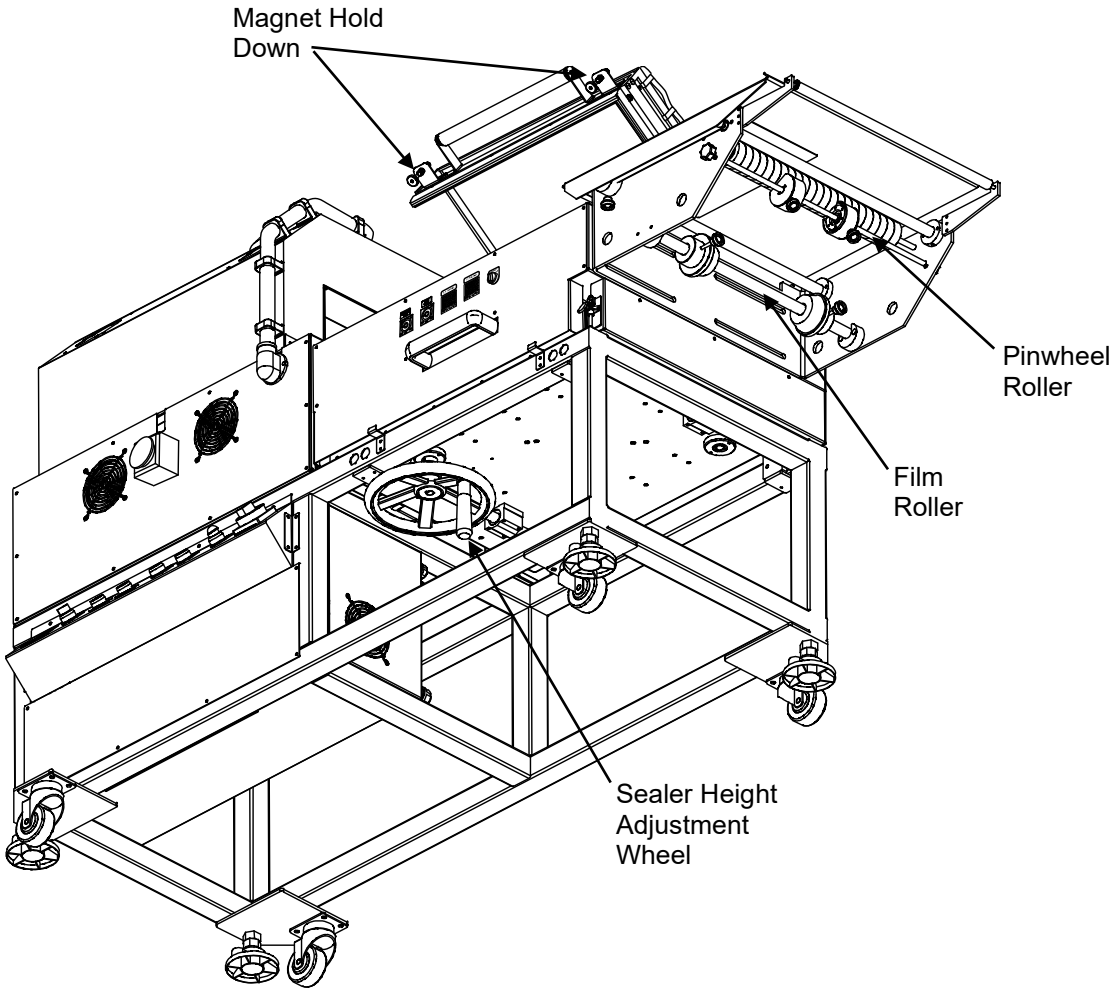
Introduction

VS1620-TK Hot-Knife L-Sealer and Heat Tunnel Combo

The Eastey VS1620-TK Value Series Hot-Knife L-Sealer and Heat Tunnel Combo will seal and shrink wrap a variety of products all on one frame. It is designed to be very easy to set up and operate.

System Overview





VS1620-TK Hot-Knife L-Sealer & Tunnel Combo Application Videos

To view an overview video of the Eastey VS1620-TK Value Series Hot-Knife L-Sealer & Tunnel in operation click the following link: https://www.youtube.com/watch?v=aeGF3g_jR40&list=PLw2fFM1Tj1XWwpWBr7H9I-NYEbpQ8fWXf&index=1&pp=iAQB or scan the QR code at right using the camera app on your mobile device.

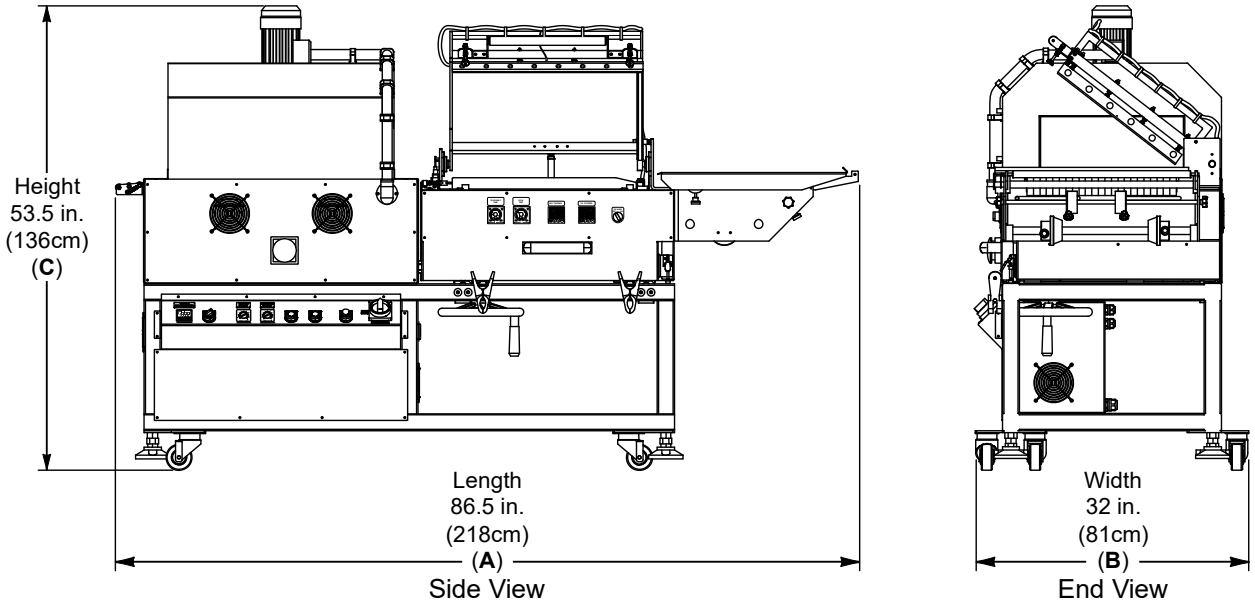
To view a video of the Eastey VS1620-TK Value Series Hot-Knife L-Sealer & Tunnel in operation sealing random-sized bars of soap click the following link: https://www.youtube.com/watch?v=dJW9vbngP9Y&list=PLw2fFM1Tj1XWwpWBr7H9I-NYEbpQ8fWXf&index=6&pp=iAQB or scan the QR code at right using the camera app on your mobile device.

Specifications

Specification	Details
Film Material	Polyolefin, or PVC Shrink Film 8 in. (20cm) – 18 in. (45cm) width
Power Requirements	220VAC 50/60Hz 30 Amps Single Phase
Machine Weight	650 lbs. (295 kg)
Shipping Weight	750 lbs. (340 kg)

Dimensions

Dimensions are shown in inches (and centimeters).

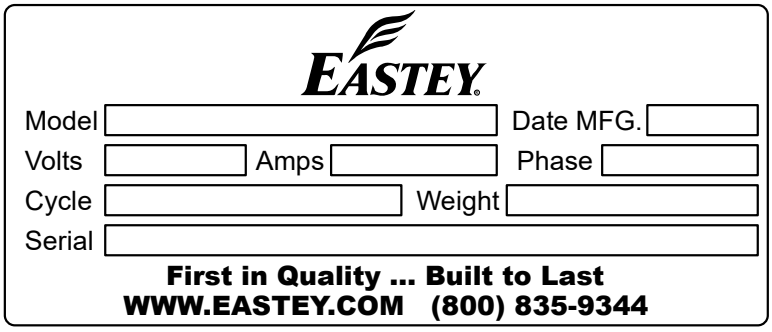


Specification	Details
Machine Dimensions	Length (**A**) = 86.5 in (218 cm) Width (**B**) = 32 in. (81 cm) Height (**C**) = 53.25 in (134 cm)
Tunnel Chamber Dimensions	Length = 26 in (66 cm) Width = 16 in. (41 cm) Height = 7 in (18 cm)
Conveyor Dimensions	Length = 24 in. (61 cm) Width = 13.5 in. (34 cm)

Machine Serial Number

The machine serial number can be found on the serial plate attached to the main electronics enclosure in the lower frame of the machine.

The serial plate displays the Model number, Date of manufacture, weight, Serial number, and electrical power requirements.



Record the serial number and date of manufacture for future reference.

Note the electrical power characteristics listed below the model number. These specify the electrical power requirements of the Eastey VS1620-TK Value Series Hot-Knife L-Sealer and Heat Tunnel Combo.

Typical Applications

Eastey VS1620-TK Value Series Hot-Knife L Sealer and Tunnel Combo

The VS1620-TK Value Series Hot-Knife L Sealer and Tunnel Combo can be used for sealing a wide range of products, limited only by package width and weight of contents. The automatic bundler is designed to seal most polyethylene shrink wrap film used for product bundling.

The VS1620-TK Value Series Hot-Knife L Sealer and Tunnel Combo is particularly suitable for packaged goods of small to moderate size and weight, and are designed and manufactured with maximum compatibility for use with Eastey's Professional Series Bundling Tunnels.

Do NOT use the VS1620-TK Value Series Hot-Knife L Sealer and Tunnel Combo for the following types of products:

- Explosive Products
- Flammable Products
- Hazardous Products
- Wet Products or Corrosives
- Products that are heavier or larger than allowed by the machine specifications.

Do not operate the Eastey VS1620-TK Value Series Hot-Knife L Sealer and Tunnel Combo in any extremely wet or oily environment that may exceed operating specifications. This equipment is designed for indoor operation in a typical clean, dry factory environment protected from rain and moisture.

Installation and Set Up

Unpacking

Carefully unpack the Eastey VS1620-TK Hot-Knife L-Sealer and Heat Tunnel Combo unit from the shipping carton.

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

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

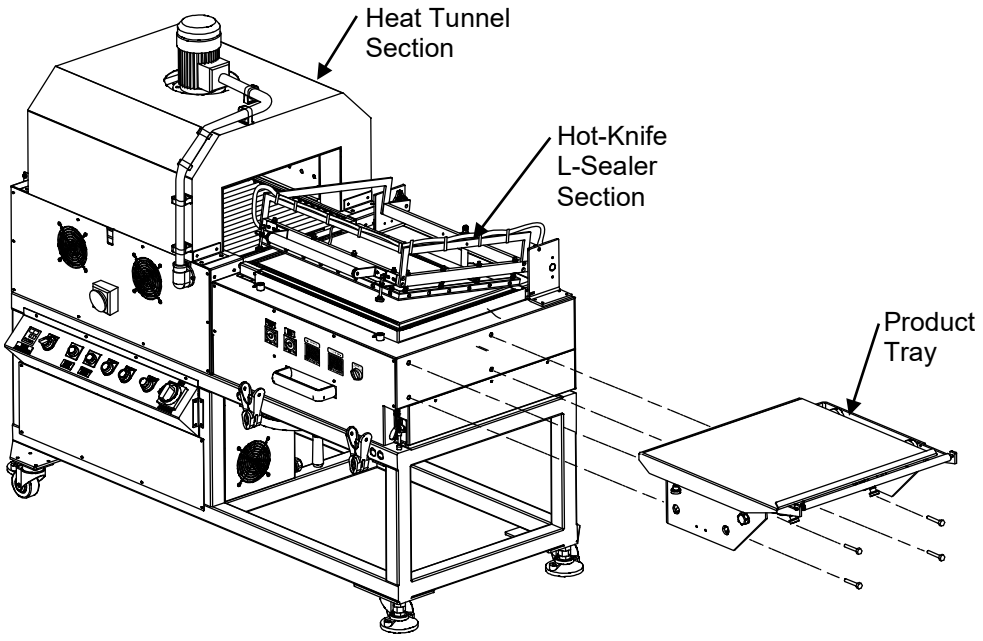
For shipping purposes, the product tray has been disassembled from the L-Sealer.

Assembly

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

Product Tray

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



Power Cord

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

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

Use only the specified power cable. Do not use the power cable to pull or position the machine, as this will damage or break the cable. If the power cable becomes worn or cracked, replace it immediately with a new power cable of the same rating.

Location Requirements

There are four casters located on the bottom of the L-sealer and heat tunnel combo unit to help in moving the machine. When the combo unit is in the operating location adjust the four leveling pads for correct height.

When installing the combo unit please be aware of the following considerations:

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

The machine should be placed on a flat, level floor so that it does not rock or move. We recommend that the machine be securely locked in place when used.

When the Eastey L-Sealer and Heat Tunnel Combo unit is positioned in the operating location, you will need access to:

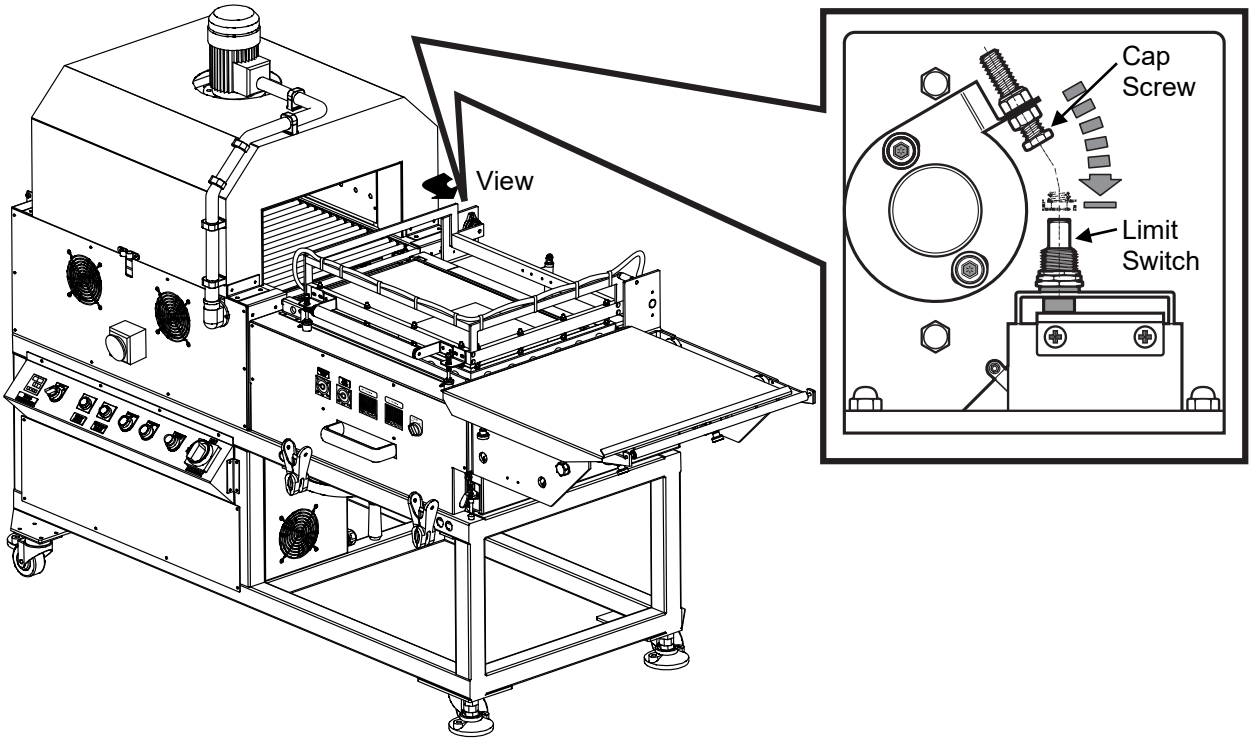
1. Both control panels: control panel for the sealer and control panel for the tunnel.
2. Seal head handle.
3. Sealer table height adjustment wheel.
4. Sealer table horizontal red locking lever.
5. Shrink film roller.
6. Pin perforation wheels.

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

Aligning the Seal Head Limit Switch and Actuator

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

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

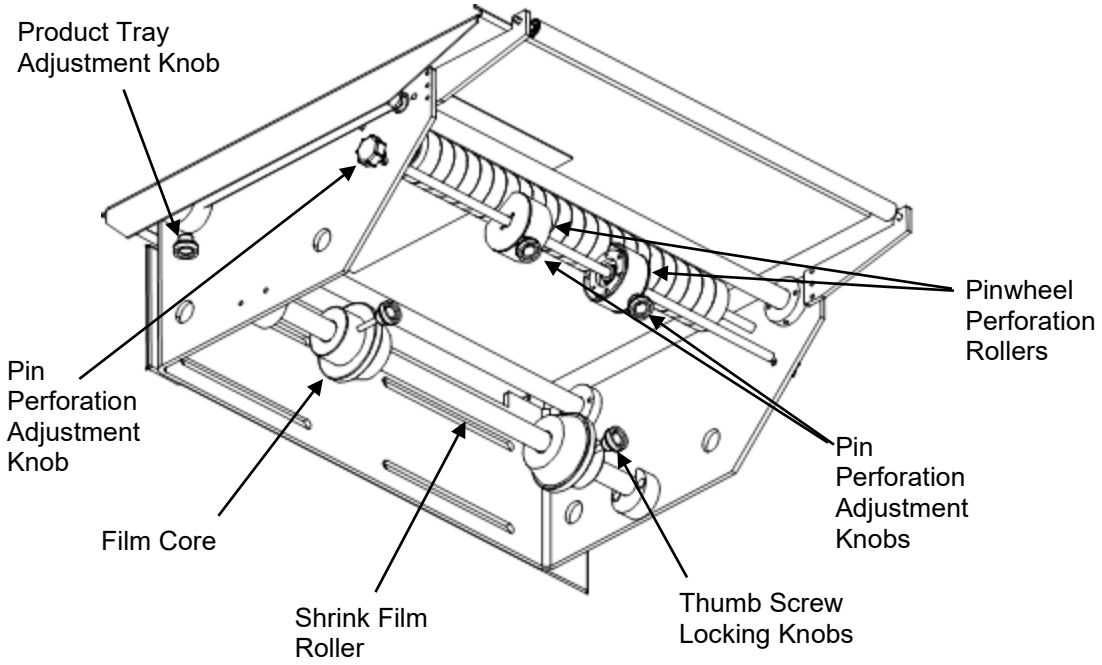


Loading the Film

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

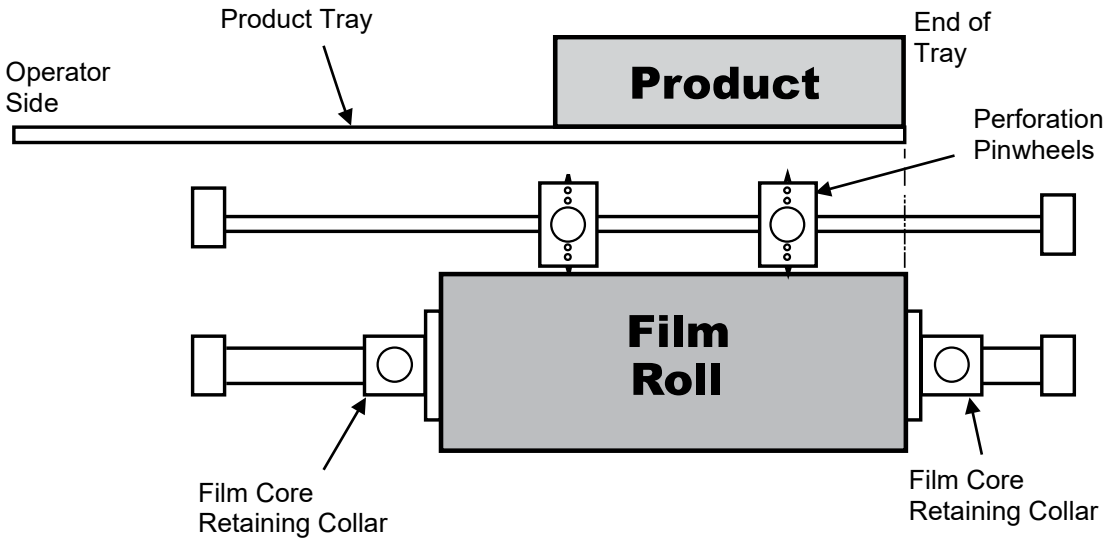
To load a roll of film:

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



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

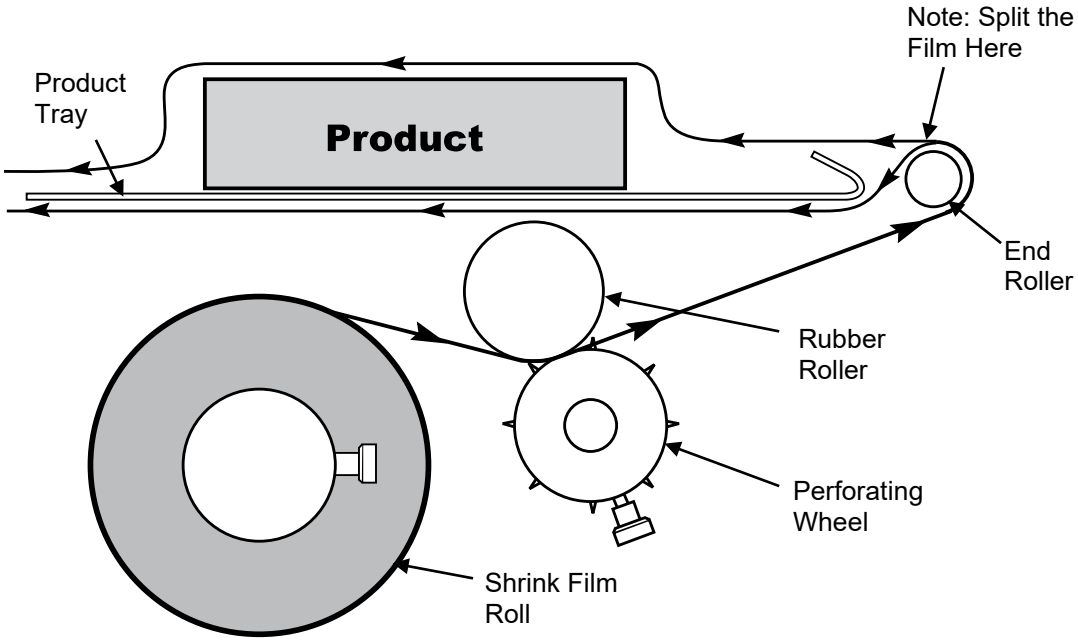
The product tray position is adjustable. Loosen the product tray adjustment knob and align the product tray with the center fold edge of the shrink film. Retighten the adjustment knob.



Film and Product Alignment Diagram

Threading the Shrink Film

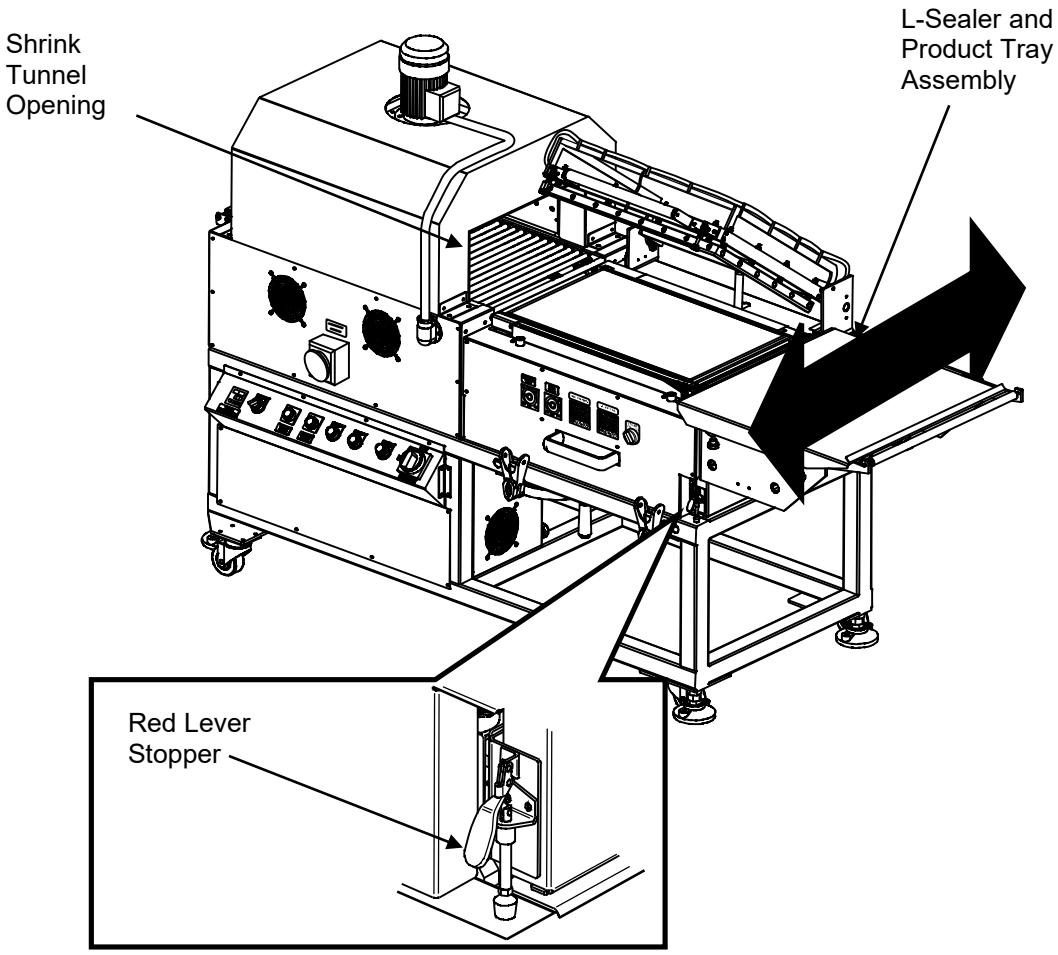
Thread the shrink film over the perforating wheel and around the end roller. Immediately after the end roller, separate the shrink film, with the top of the film traveling over the product tray and the bottom traveling underneath the product tray.



Film Threading Diagram

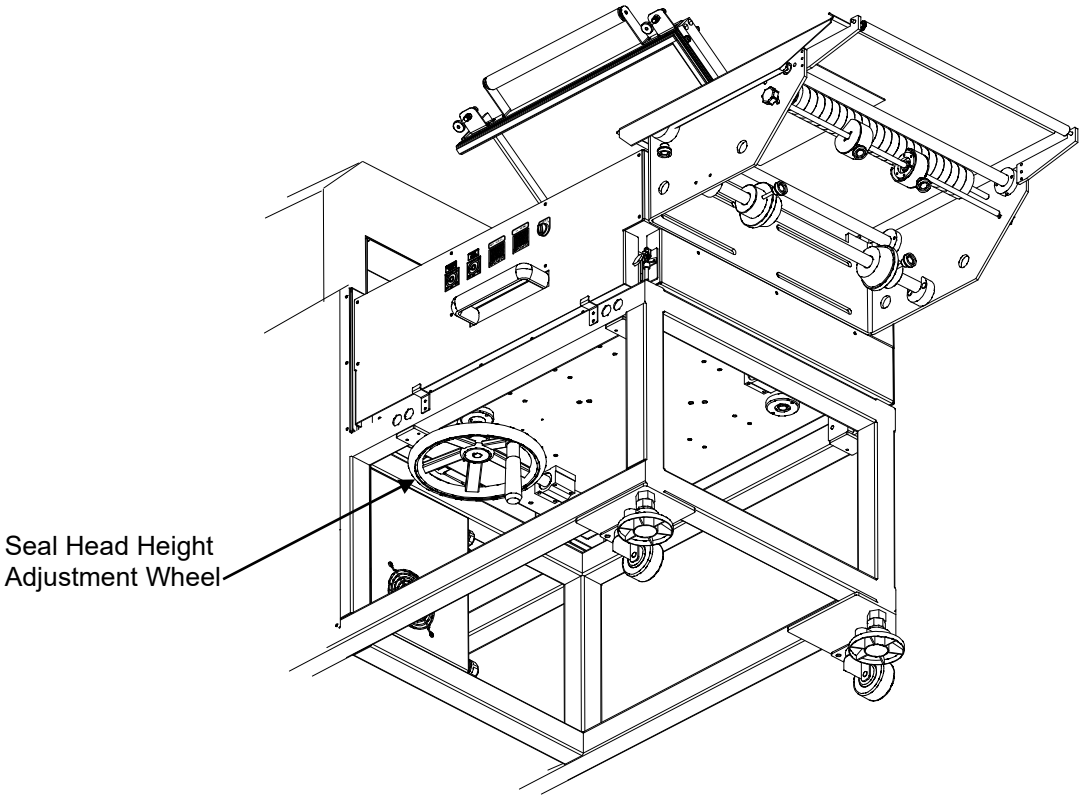
Aligning the Heat-Shrink Tunnel

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



Seal Head Height Adjustment

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

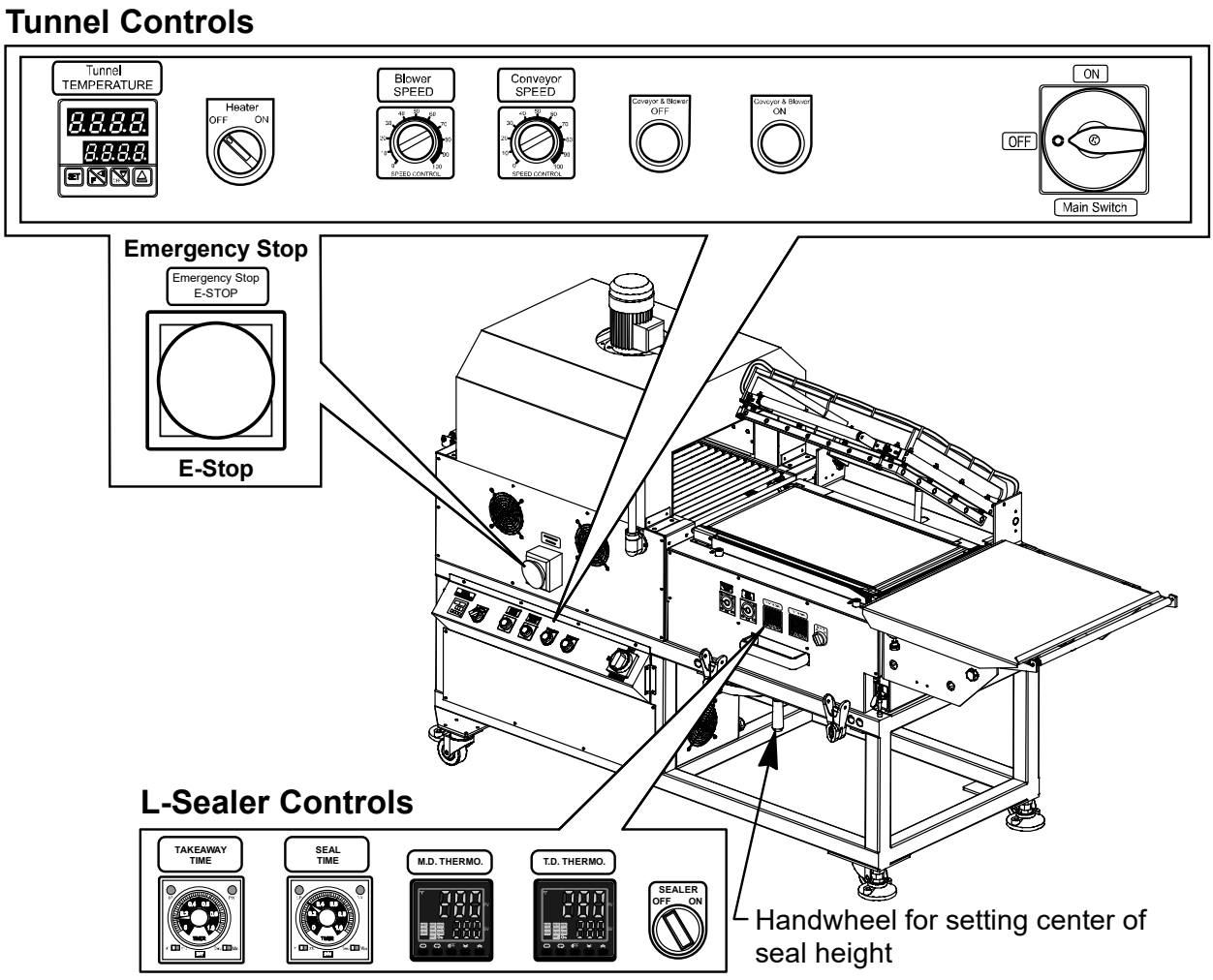


Position the center of the seal as near as possible to the center of the product to be sealed.

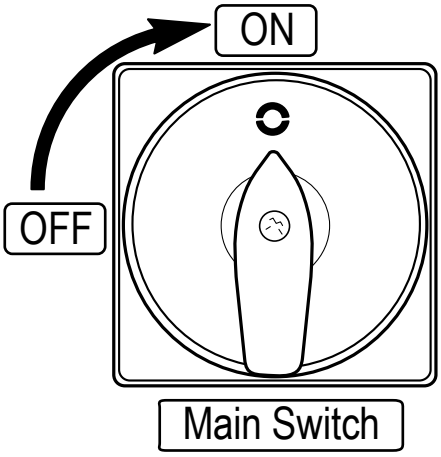
Operation

The Eastey VS1620-TK Hot-Knife L-Sealer and Heat Tunnel Combo is very easy to operate. Become familiar with the control panels for the heat tunnel and L-sealer located on the operator side of the machine.

Sealer and Tunnel Operation



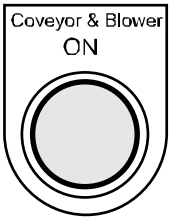
Main Power



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

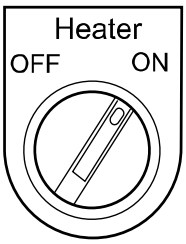
The Main Switch controls power to both the tunnel and sealer.

Conveyor and Blower



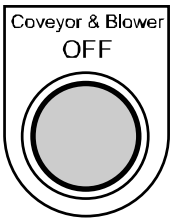
Press the Conveyor and Blower ON (green button) to start the conveyor and blower in the heat tunnel.

Tunnel Heater



Turn the tunnel Heater switch to the ON position.

At the end of a run, to turn the tunnel heater off to allow tunnel components to cool (to about 150°F or less) before turning off the conveyor and blower, switch the tunnel Heater switch to the OFF position. See information about Shutting Down later in this section.



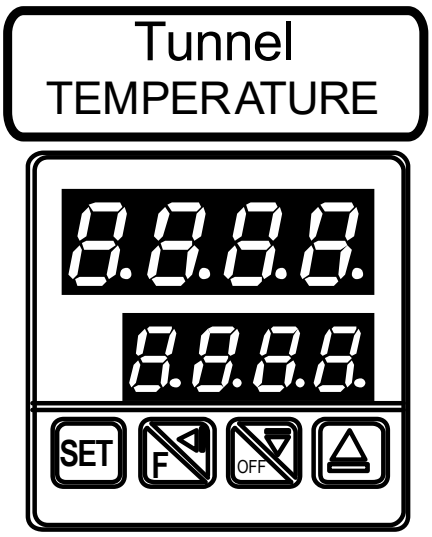
Later, after the end of a run and after the tunnel components have been allowed to cool, to turn the conveyor and blower off press the red Conveyor and Blower OFF button. Do this only at the end of a run after first turning off the Tunnel Heater and allowing the conveyor and tunnel components to cool.

See information about Shutting Down later in this section.

Tunnel Temperature

Wait for the Tunnel Temperature to heat up to the Set Value before sending any packages through the heat tunnel for shrinking. The output light will turn on while the tunnel is heating up.

Normally settings for the temperature controller are made at the initial setup of the heat tunnel for the material you will be sealing and shrinking and do not require adjustment.



The shrink tunnel temperature controller will display the current temperature inside the tunnel (top) and the temperature setting below. To change the set temperature inside the heat-shrink tunnel, follow the instructions below.

Press the SET button to set the temperature.

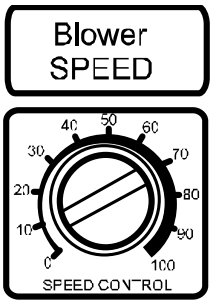
Press this button to select the digit to change. The selected digit will begin to flash.

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

Press the “SET” button to save the new values.

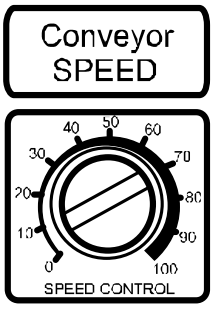
Attention! **Do Not** set the temperature higher than 350°F. Setting the temperature higher than 350°F will damage the machine and the product.

Blower Speed



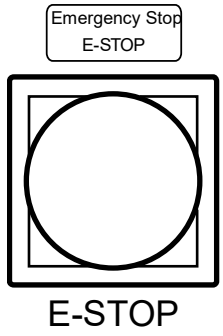
Use the Blower SPEED dial to set the air flow inside the shrink tunnel. The blower speed will vary according to the product dimensions and film properties.

Conveyor Speed



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

E-Stop or Emergency Stop



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

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

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

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

Sealer Operation

Seal Power Off / On

Turn on the power to the seal heads by turning the switch below the front seal head to the On position. This will energize the L-sealer temperature controllers and seal head hot knives / seal bars.

The two seal bars that form the L-seal are at right angles to each other. The front seal which runs parallel to the long axis of the machine is referred to as the M.D. for Machine Direction, and the side seal which runs from the front to the back of the machine and perpendicular to the long axis is referred to as the T.D. for Transverse Direction.

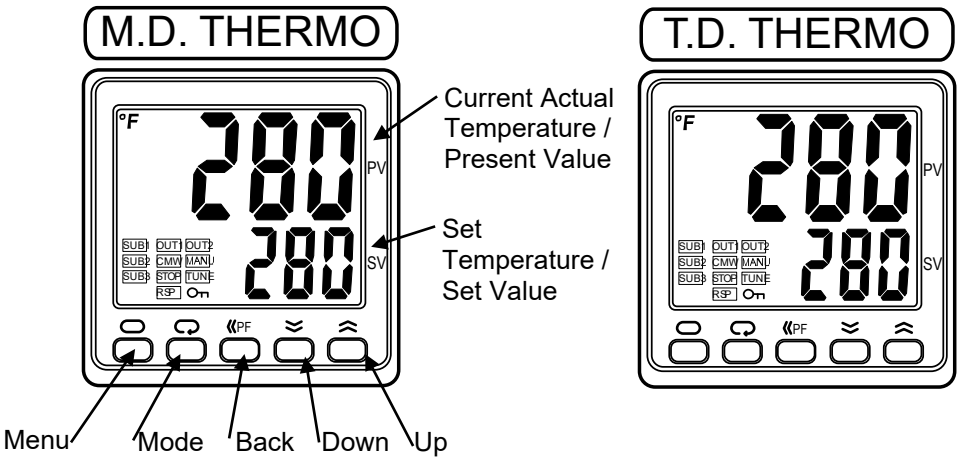
M.D. Thermo and T.D. Thermo — L-Seal Temperature Controls

Temperature controllers for the L-seal head display the Present Value (PV) temperature or current measured temperature of the hot knife seals and the Set Value (SV), which is the temperature to which the hot knife seal blades must be heated to make an effective cut and seal. Temperature controllers control the temperature of the cutting and sealing knives. There is a separate temperature controller for each of the two knives, but temperature settings for both temperature controllers should be set to the same temperature.

Wait for the PV temperature of L-sealer seal head hot knives to heat up to the Set Value setting before sealing packages.

Temperature Control Adjustment Instructions

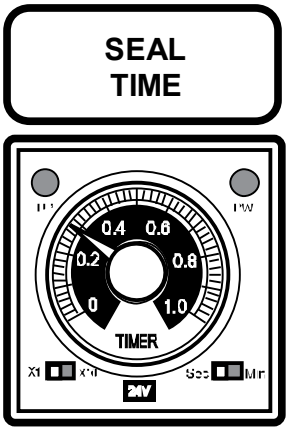
Normally the temperature controller settings are made at the initial setup of the L-sealer for the material specified for sealing and shrinking and do not require adjustment. Instructions for setting the temperature controllers are provided here for convenience in case the controllers are set out of adjustment and must be reset to correct settings.



All settings that require the Menu and Mode buttons have already been set at the factory and should only be set by a trained technician and should not require adjustment by nonprofessionals.

1. Press the left-arrow (≪) button, up-arrow (≪) button, and down-arrow (≪) button, and a digit will begin to flash. The flashing digit indicates the digit whose value can be changed by pressing the down- (≪) or up-arrow (≪) buttons.
2. If necessary, press the left-arrow (≪) button to shift to the place of the digit that needs to be changed. (The flashing digit indicates the digit that will be changed.)
3. Press up (≪) or down (≪) as required to change the flashing digit to the required value.
4. Repeat instructions 2 and 3 above as necessary until all digits have been set to the required value, and then press the MODE button. No digits will be flashing and the new value entered is applied.

Seal Time



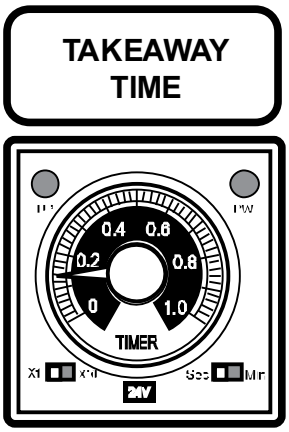
Use the “Seal Time” timer to set the seal time. The seal time is the amount of time that the magnets will hold the seal head down on the film. The seal time may vary according to the type of film in use.

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

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

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

Take Away Time



Use the “Takeaway Time” to set the amount of time the conveyor will run.

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

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

Sealing the Product

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

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

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

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

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

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

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

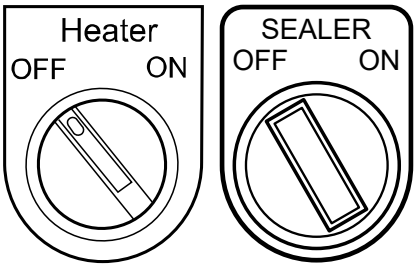
Repeat this process for the next package to be sealed.

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

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

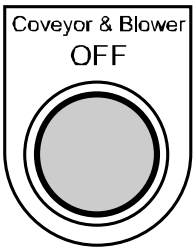
Shutting Down

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



Turn switches for the sealer and for the tunnel heater to the OFF position.

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



After the temperature in the tunnel has cooled to approximately 150°F or 66°C or cooler (this will be a considerable amount of time) turn the Conveyor and Blower off.

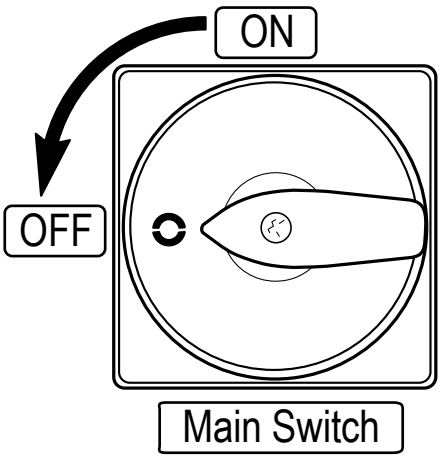
Special Notes About the Tunnel Shutdown Sequence

The sealer may be shut down at any time by switching the sealer power switch to the Off position and allow to cool to ambient room temperature.

When shutting down the tunnel, it is important to let the temperature inside it cool down before turning off the main power. See the notes below.

Shutting down the heat tunnel requires the following.

- When shutting down the tunnel, be sure to first turn the heater switch to Off.
- Once the heater switch is switched off, it will take some time (this will vary depending on heat settings) for the tunnel to cool down completely.
- When the tunnel cools down to approximately 150°F or 66°C or cooler, shut off the tunnel conveyor and blowers.
- Bringing the tunnel down this way helps prevent damage to the conveyor and internal components from excess prolonged exposure to heat inside the tunnel.
- Allow the tunnel to cool down completely to ambient room temperature before performing any servicing to avoid burn hazards. Refer to your company's lockout/tagout procedures and best practices.



Turn the Main Power switch to the OFF position when the tunnel, conveyor, and internal components have cooled.

Maintenance

Unless specifically stated otherwise, shut down the Eastey Hot-Knife and Heat Tunnel Combo and all connected equipment and disable power before performing any adjustments, maintenance, or repairs. Be sure to follow your company's lockout/tagout rules an procedures for the Eastey Hot-Knife and Heat Tunnel Combo and any equipment connected to it, for example, coding/marking equipment or printing equipment. Refer to the special notes about the tunnel shutdown sequence, earlier in this User Guide at the end of the Operation section, to allow for proper cooldown of belts and internal components for shutting down.

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

WARNING: Failure to follow lockout/tagout procedures can result in serious injury and/or equipment damage and may void the warranty.

Note: Lockout mechanism(s), padlock(s) and identification tag(s) are the responsibility of your company in accordance with your company's lockout/tagout rules and procedures and are not provided by Eastey.

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

Sealer

Daily

- ☐ Clean the hot knife seal blade. Check the upper and lower seal areas for melted or scrap film or dirt and clean as required.
- ☐ Ensure no parts are broken or missing from the upper and lower seal areas. Replace as needed.
- ☐ Check conveyor belts for wear or damage. Check the takeaway conveyor for torn belt or excessive wear; check the tunnel conveyor for worn or broken parts. Repair or replace as needed.
- ☐ Check the conveyor height adjustment wheel. Lubricate chain and screws as needed.
- ☐ Check power cord and wiring for wear and loose connections.
- ☐ Check for loose fasteners.

Shrink Tunnel

Daily

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

Monthly

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

Cleaning

The machine will require occasional cleaning.

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

Silicone Rubber Seal Pad Replacement

Occasionally it will be necessary to replace the silicone rubber seal pads. Seal pads are designed with a channel to make them easy to install and replace. Seal pads should be replaced if the following symptoms are observed.

- Gaps in the seal
- Weak seals
- Improper film cutoff
- Excessive sealing pressure required

To replace a silicone rubber seal pad, pull the old pad out of the channel and replace with the new silicone rubber seal pad, pressing it into place in the channel.

NOTE: Some silicone rubber seal pads come covered in talcum powder. If so, clean the pads with a mild solvent.

Changing Hot-Knife Inserts and Cutting Rules

1. Disconnect electrical power for the L-Sealer & Tunnel Combo unit from the electrical power source.

   CAUTION! Always be aware of the cutting edges while replacing the knife edges. Handle the knife blades carefully.

2. Remove any hardware holding the inner side film clamp outer front film clamp.

   NOTE: It may be possible to remove the film clamps without removing all hardware. Push the product tray in all the way. Swing the film clamp down and to the right over the product tray, then pull it out and rest the film clamp on the product tray.

3. Remove any hardware fastening the side-seal and front-seal bars.

4. Remove the insert and cutting rule, both at the same time.

5. Place the replacement cutting rules into the new inserts, both at the same time, ensuring that the beveled edge is in the corner.

6. Push the beveled edges together.

   NOTE: The inside beveled edges of the cutting rule need to come together. The outsides do not. Be sure the cutting rules are touching.

7. Reinstall any attaching hardware removed earlier, but do not tighten at this point.

8. Heat the seal bar up to the set point.

9. Adjust insert and cutting rule if they separate at the corner.

10. Tighten the attaching hardware while the seal bars are hot.

11. Turn off heat and allow the sealer to cool down, and then reinstall film clamps.

Rollers

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

Troubleshooting

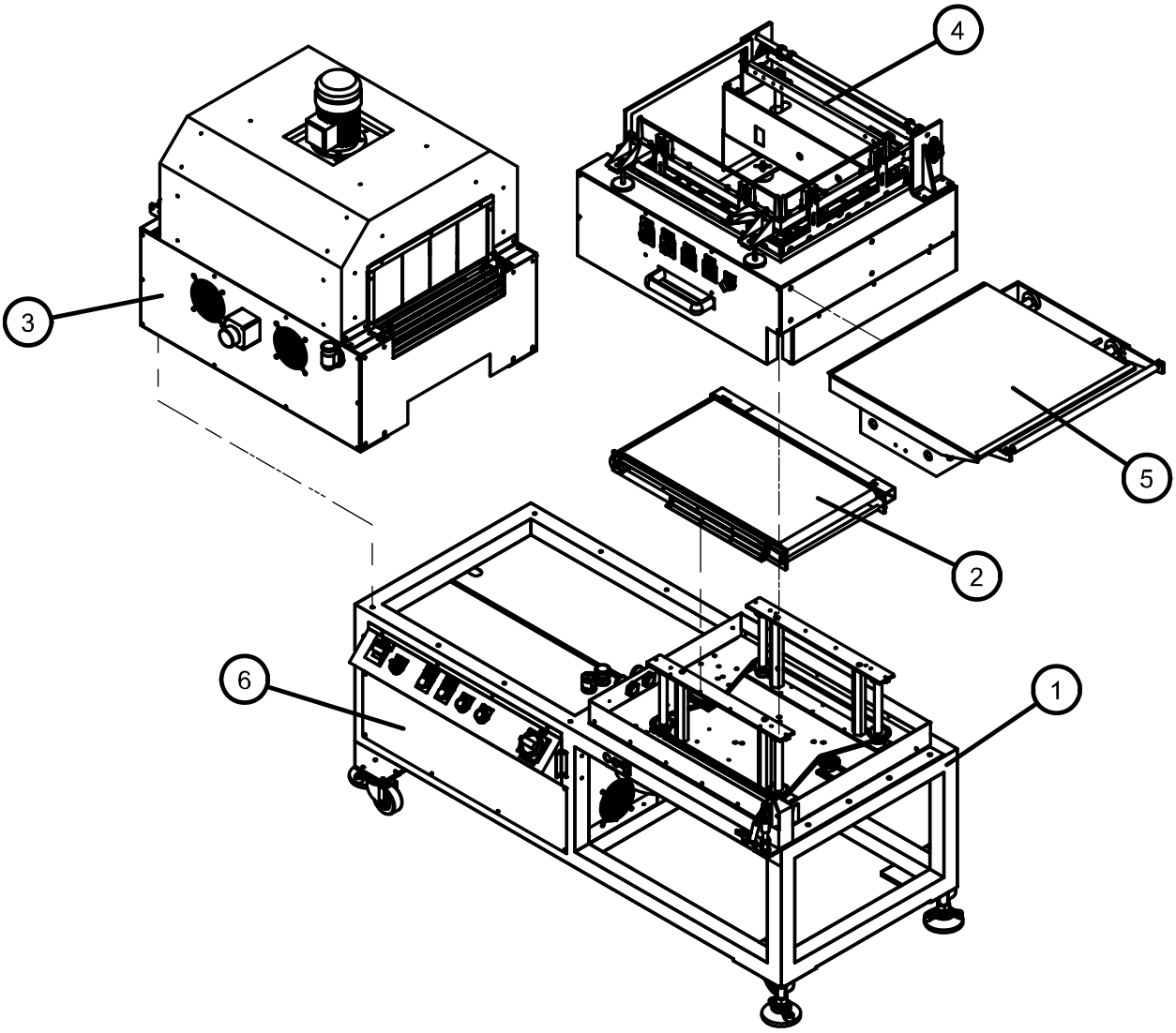
Problem	Possible Cause	Solution
Control power lamp does not light.	• Power not connected. • Fuse burned out. • Defective switch. • Disconnected wire.	• Connect power; switch on. • Replace fuse. • Replace switch. • Check wire connections.
No fuse breaker tripped.	• Poor connection. • Electrical leakage.	• Check heating wire. • Check all wiring sections.
Conveyor belt can be pushed by hand.	• Belt tension too loose.	• Adjust belt tension screw.
	• Belt tension too tight.	• Adjust belt tension screw.
Belt cannot be pushed by hand.	• Defective motor gear head.	• Replace part.
Failure under Normal Status.	• Driving chain tension too tight.	• Adjust driving chain.
	• Disconnected wire. • Defective motor. • Defective contact plug. • Defective relay unit. • Defective limit switch.	• Replace part.
Material outfeed roller failure. .	• Disconnected wire. • Defective drive motor. • Defective relay unit.	• Replace part.
Material moves	• Defective brake box.	• Replace part.
	• Wrong material setting position.	• Adjust material setting position.
Zig-zag line.	• Unbalanced material tension lever. • Wrong tension roller position. • Wrong triangle unfolder angle.	• Adjust item as required.
Material does not move.	• Film perforator does not allow film to roll out.	• Adjust spring.
Sealing arm rises too abruptly.	• Sealing time is set too short.	• Adjust time of limit switch in safety device to lengthen sealing time.

Problem	Possible Cause	Solution
Sealing heating temperature does not rise.	• Fuse burned out. • Disconnected heating wire. • Defective relay unit power of single phase.	• Replace part as required.
Unable to adjust temperature.	• Defective temperature regulator. • Defective temperature sensor.	• Replace defective part as required.
Sealer not forming an adequate seal.	• Hot knife defective. • Heating temperature too low. • Sealing time too short or air pressure too weak. • Hot knife heat is insufficient.	• Replace with new hot knife. • Adjust to correct heating temperature. • Check and correct as required. Replace seal pads, if required. • Replace hot knife.

Parts List

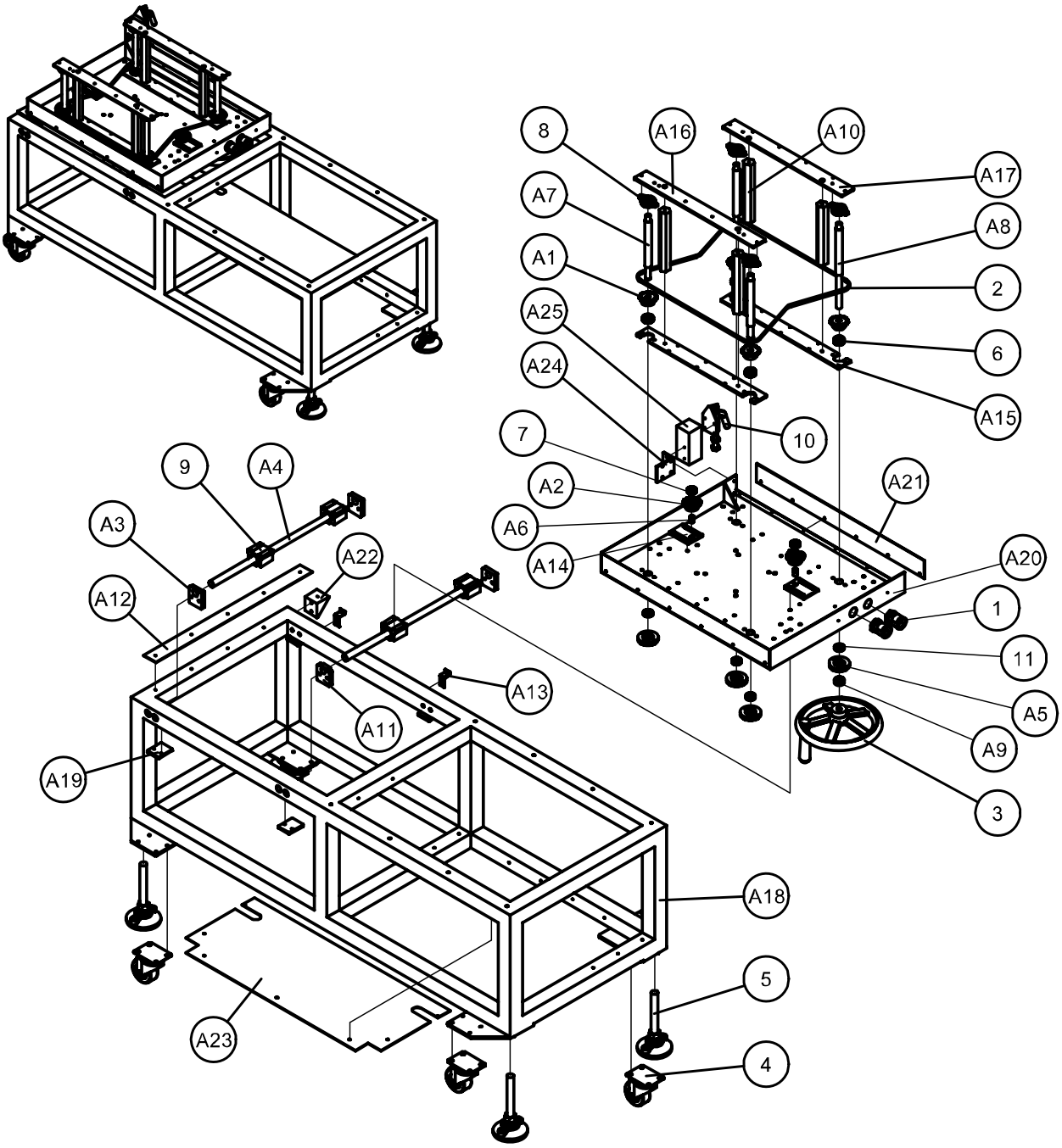
VS1620-TK Sealer Tunnel Combo Unit

Main Assembly – VS1620-TKLR Live Roller
VS1620-TKMB Mesh Belt



Item	Part Number	Description	Page
1	VSSA0264	Base Frame with Takeaway Height Adjustment	37
2	VSSA0265	L-Sealer Takeaway Conveyor Assembly	39
3(a)	VSTA0069LR	Heat Tunnel Assembly – Live Roller Conveyor	41
3(b)	VSTA0069MB	Heat Tunnel Assembly – Wire Mesh Belt Conveyor	46
4	VSSA0266	L-Sealer and Frame W/ L-Sealer Control Panel	51
5	VSSA0267	Product Tray with Film Holder and Perforator	56
6	VSCP0038	Main Electrical Panel and Tunnel Control Panel	58

Base Frame with Takeaway Height Adjustment – VSSA0264

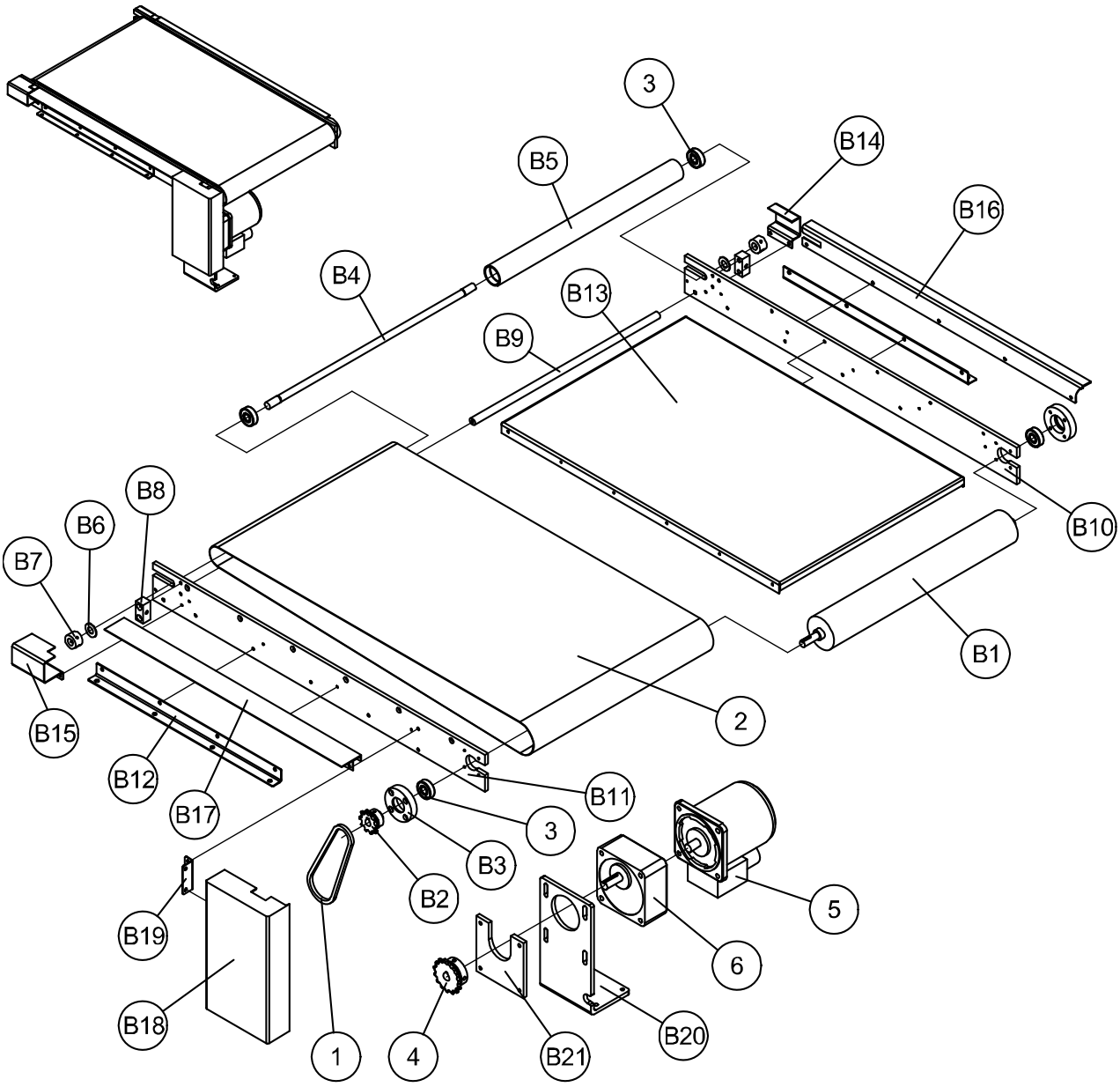


Item	Part Number	Description	Quantity
A1	VSSA0193	Sprocket	4
A2	VSSA0198	Idler	2
A3	VSSA0270	Guide Rod Fixed Seat	3
A4	VSSA0271	Guide Rod	2
A5	VSSA0272	Screw Seat	4
A6	VSSA0273	Idler Axle	2

Item	Part Number	Description	Quantity
A7	VSSA0274	Driven Lifting Screw	3
A8	VSSA0275	Lifting Screw	1
A9	VSSA0276	Screw Fixed Ring	1
A10	VSSA0277	Fixed Rod	4
A11	VSSA0278	Guide Rod Fixed Seat	1
A12	VSSA0279	Pad	1
A13	VSSA0280	Clip Bracket	2
A14	VSSA0281	Chain Adjustment Plate	2
A15	VSSA0282	Support Plate	2
A16	VSSA0283	Support Plate	1
A17	VSSA0284	Support Plate	1
A18	VSSA0285	Frame	1
A19	VSSA0286	Fixed Seat	4
A20	VSSA0287	Lifting Base	1
A21	VSSA0288	Lifting Base Cover	2
A22	VSSA0289	Fixed Seat	1
A23	VSSA0290	Cover	1
A24	VSSA0291	Clamp Fixed Seat	1
A25	VSSA0292	Clamp Fixed Seat	1

Item	Part Number	Description	Quantity
1	VSSA0268	Straight Connector	2
2	VSSA0200	Roller Chain	1
3	VSSA0194	Rotating Handwheel	1
4	VSCP0033	Wheel Caster	4
5	VSCP0034	Adjustable Foot	4
6	VSSA0192	Thrust Bearing	4
7	VSSA0199	Bearing	2
8	VSSA0205	Block Bearing	4
9	VSCP0035	Linear Bearing	4
10	VSSA0022	Clamp	1
11	VSSA0269	Bearing	4

Takeaway Conveyor Assembly – VSSA0265

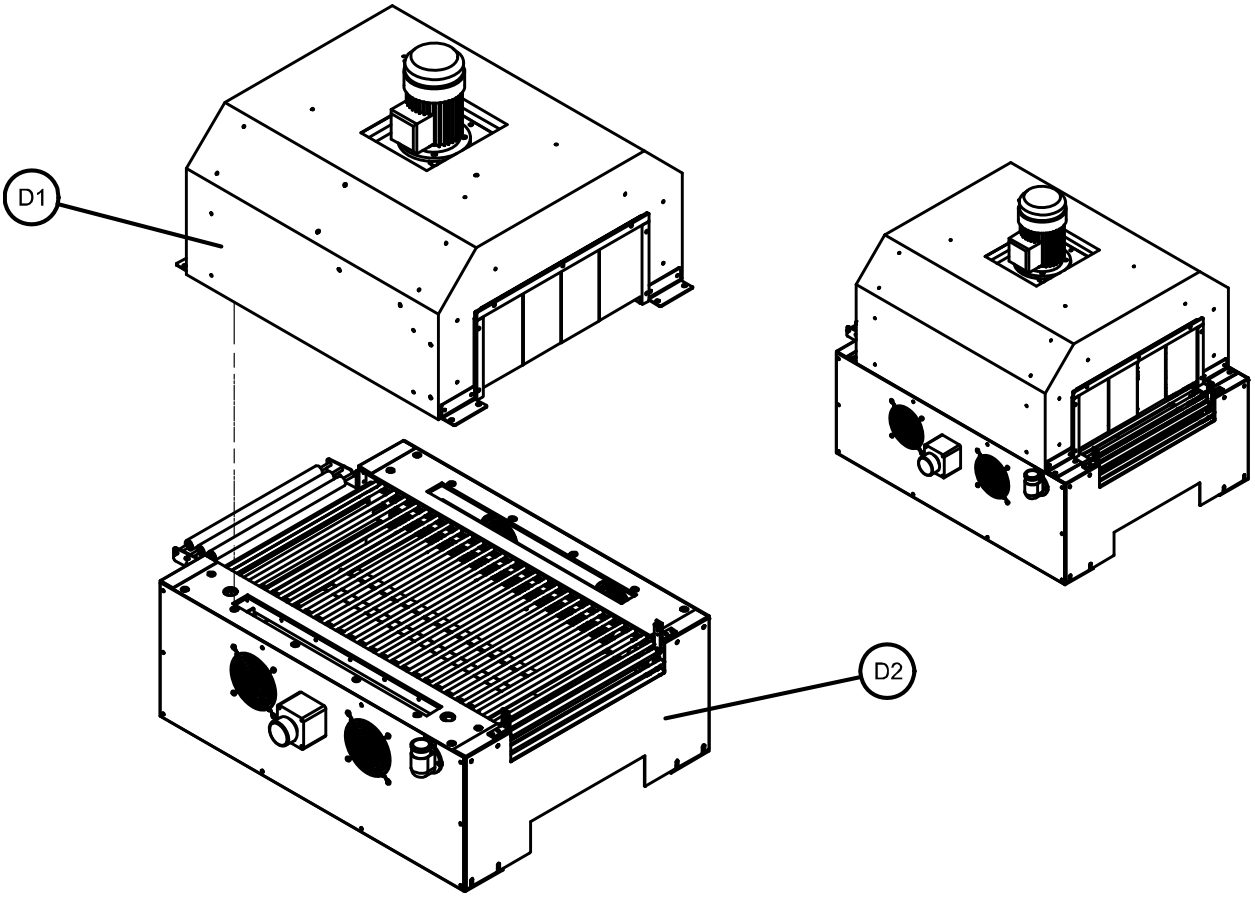


Item	Part Number	Description	Quantity
B1	VSSA0293	Drive Shaft	1
B2	VSSA0294	Sprocket	1
B3	VSSA0295	Fixed Seat	2
B4	VSSA0296	Driven Axle	1
B5	VSSA0297	Driven Roller	1
B6	VSSA0298	Washer	2
B7	VSSA0299	Fixed Ring	2
B8	VSSA0300	Adjustment Seat	2

Item	Part Number	Description	Quantity
B9	VSSA0301	Fixed Rod	1
B10	VSSA0302	Fixed Plate (Left)	1
B11	VSSA0303	Fixed Plate (Right)	1
B12	VSSA0304	Connection Plate	2
B13	VSSA0305	Support Plate	1
B14	VSSA0306	Left Cover	1
B15	VSSA0307	Right Cover	1
B16	VSSA0308	Conveyor Left Cover	1
B17	VSSA0309	Conveyor Right Cover	1
B18	VSSA0310	Chain Cover	1
B19	VSSA0311	Connection Plate	1
B20	VSSA0312	Motor Seat	2
B21	VSSA0313	Motor Adjustment Plate	1

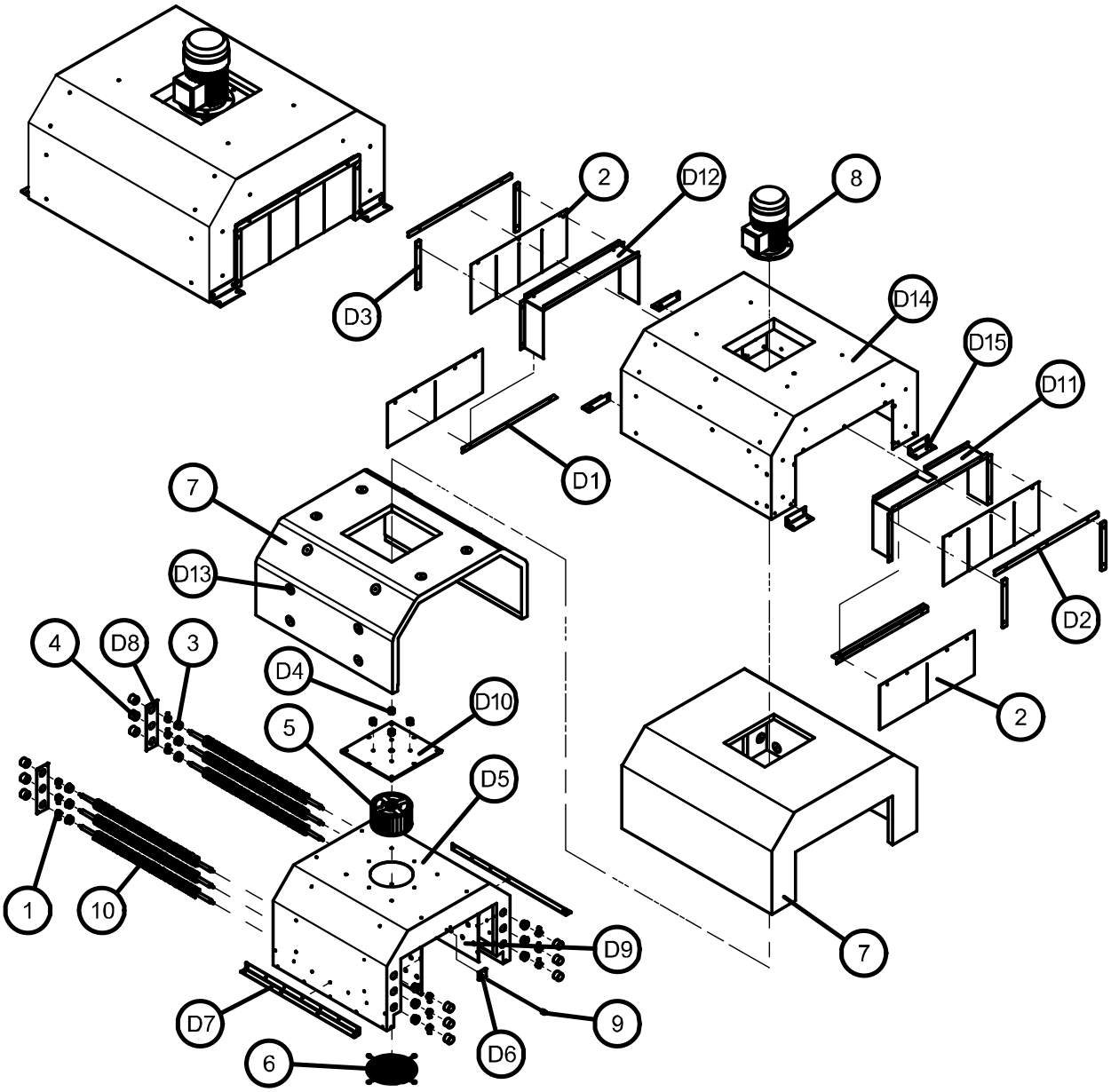
Item	Part Number	Description	Quantity
1	VSSA0229	Roller Chain	1
2	VSSA0043	Polyurethane (PU) Conveyer Belt	1
3	VSSA0226	Bearing	4
4	VSSA0201	Sprocket	1
5	VSTA0003	Induction Motor	1
6	VSTA0008	Gear Box	1

Heat Tunnel Assembly with Live Roller Conveyor – VSTA0069LR



Item	Part Number	Description	Quantity
D1	VSTA0070	Heat Tunnel Hood & Heaters	1
D2	VSTA0071LR	Heat Tunnel Conveyor & Support with Live Rollers	1

Heat Tunnel Hood & Heaters – VSTA0070

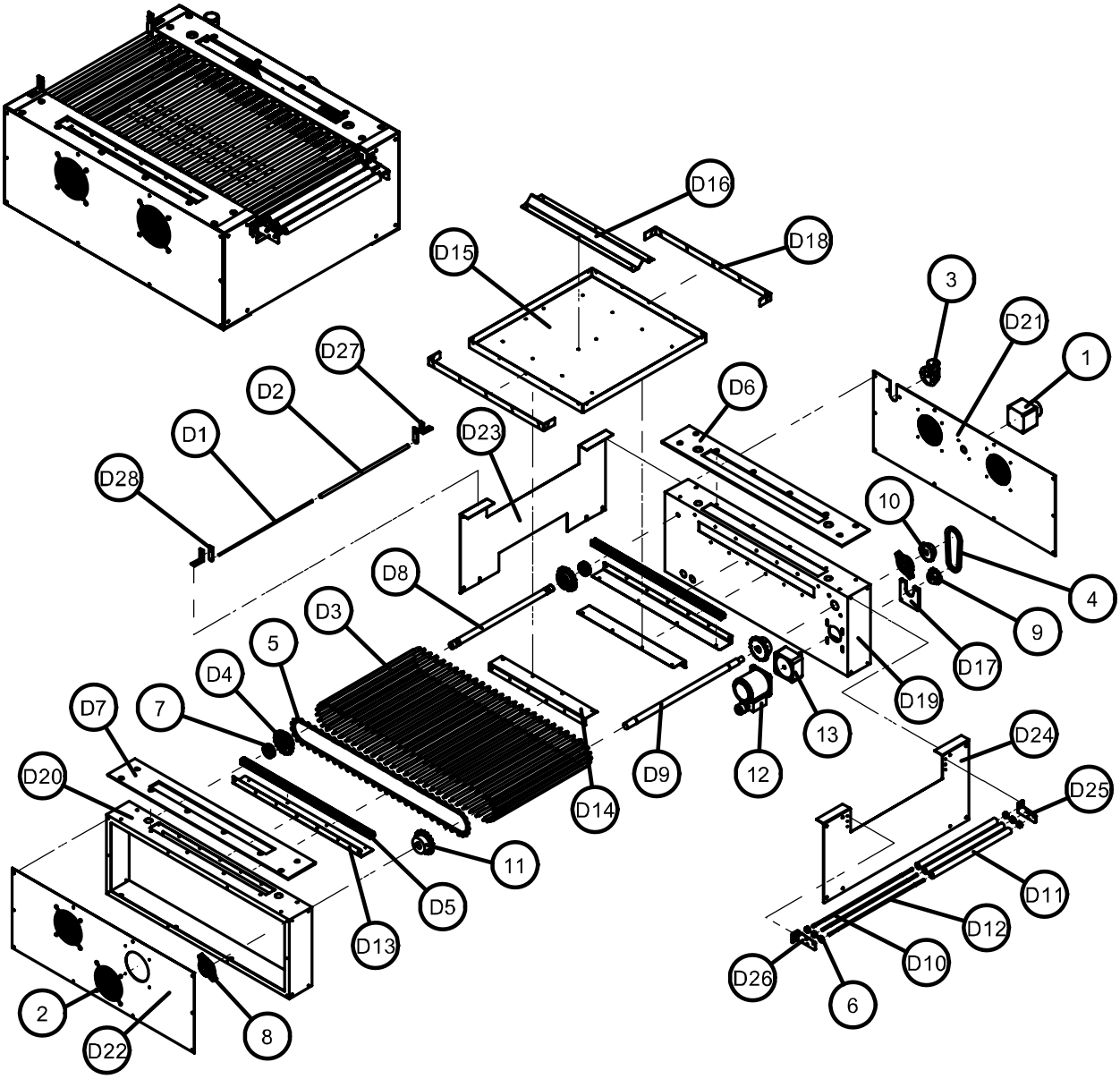


Item	Part Number	Description	Quantity
D1	VSTA0077	Fixed Plate	2
D2	VSTA0078	Bakelite A	2
D3	VSTA0079	Bakelite B	4
D4	VSTA0080	Cushion	4
D5	VSTA0081	Inner Furnace	1
D6	VSTA0082	Fixed Plate	1
D7	VSTA0083	Connection Board	2
D8	VSTA0084	Fixed Plate	2

Item	Part Number	Description	Quantity
D9	VSTA0085	Shutter	2
D10	VSTA0086	Fixed Plate	1
D11	VSTA0087	Furnace Door (Front)	1
D12	VSTA0088	Furnace Door (Rear)	1
D13	VSTA0089	Washer	48
D14	VSTA0090	Furnace Cover	1
D15	VSTA0091	Connection Board	4

Item	Part Number	Description	Quantity
1	VSTA0072	Fixed Ring	12
2	VSTA0073	Insulation Cloth	4
3	VSTA0035	Ceramic Insulator	12
4	VSTA0074	Ceramic Insulator	12
5	VSTA0036	Centrifugal Fan	1
6	VSTA0075	Fan Cover	1
7	VSTA0076	Ceramic Fiber Cotton	1
8	VSTA0034	Tunnel Hood Fan Motor	1
9	VSTA0007	Thermometer	1
10	VSTA0002	Heater	6

Heat Tunnel Support & Conveyor with Live Rollers – VSTA0071LR

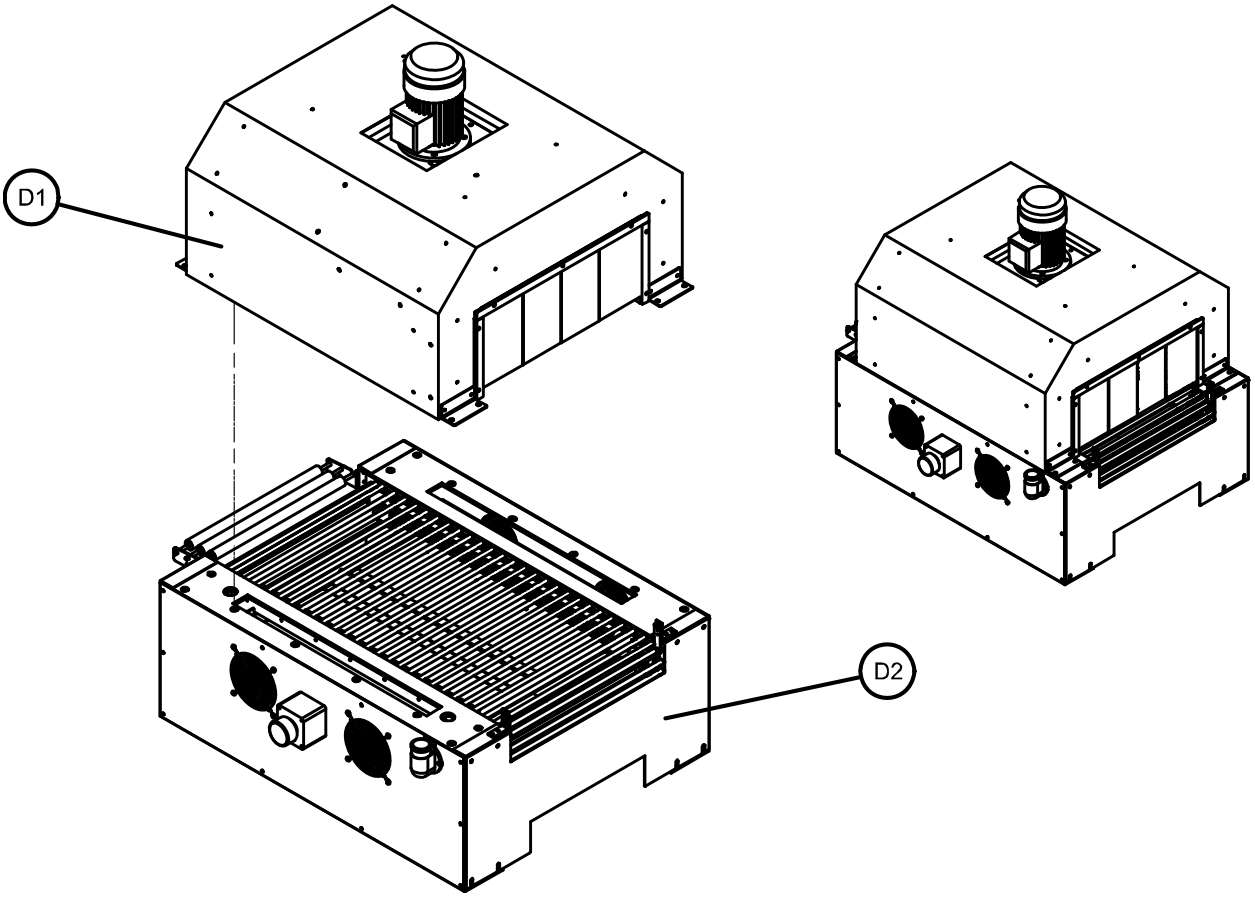


Item	Part Number	Description	Quantity
D1	VSTA0096	Connecting Axle	1
D2	VSTA0097	Connecting Roller	1
D3	VSTA0098	Output Roller	63
D4	VSTA0055	Sprocket	2
D5	VSTA0099	Track	2
D6	VSTA0100	Bakelite A	1
D7	VSTA0101	Bakelite B	1
D8	VSTA0102	Driven Shaft	1
D9	VSTA0103	Driving Shaft	1

Item	Part Number	Description	Quantity
D10	VSTA0104	Output Axle	1
D11	VSTA0105	Output Roller	3
D12	VSTA0106	Output Axle-1	2
D13	VSTA0107	Connection Board	2
D14	VSTA0108	Connection Board	2
D15	VSTA0109	Bottom Plate	1
D16	VSTA0110	Fixed Plate	1
D17	VSTA0111	Motor Fixed Plate	1
D18	VSTA0112	Connection Board	2
D19	VSTA0113	Furnace Frame (Left)	1
D20	VSTA0114	Furnace Frame (Right)	1
D21	VSTA0115	Frame Cover (Left)	1
D22	VSTA0116	Frame Cover (Right)	1
D23	VSTA0117	Frame Cover (Front)	1
D24	VSTA0118	Frame Cover (Rear)	1
D25	VSTA0119	Output Roller Support-1	1
D26	VSTA0120	Output Roller Support-2	1
D27	VSTA0121	Roller Fixed Plate	2
D28	VSTA0122	Roller Adjustment Plate	2

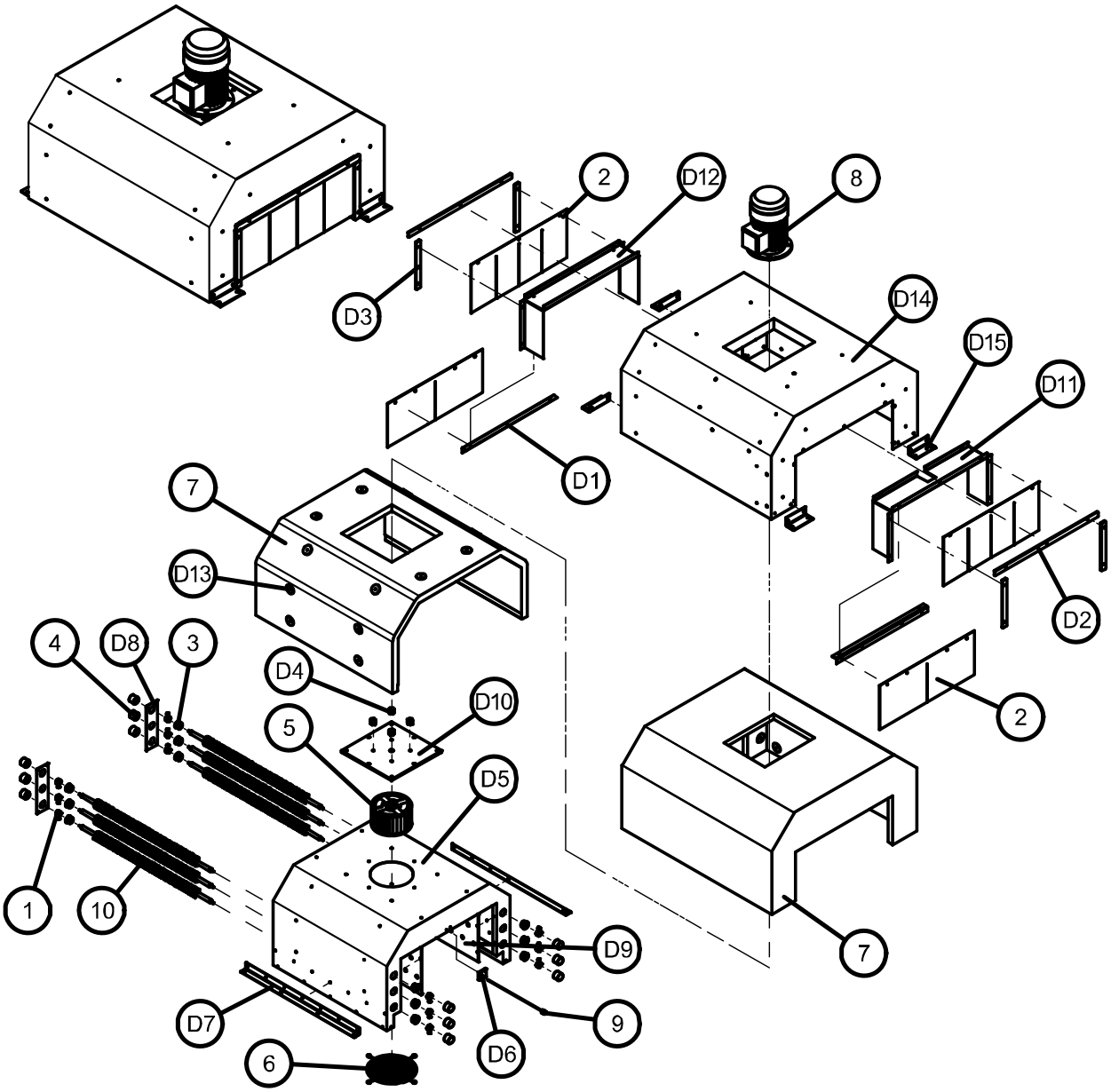
Item	Part Number	Description	Quantity
1	VSTA0092	Emergency Button	1
2	VSTA0075	Fan Cover	4
3	VSTA0094	Connector	1
4	VSTA0064	Roller Chain	1
5	VSTA0059	Chain With Attachment	2
6	VSTA0014	Bearing	6
7	VSTA0056	Bearing	2
8	VSTA0054	Block Bearing	2
9	VSA00058	Sprocket	1
10	VSTA0058	Sprocket	1
11	VSTA0057	Sprocket	2
12	VSSA0006	Induction Motor	1
13	VSTA0095	Gear Box	1

Heat Tunnel Assembly with Wire Mesh Belt Conveyor – VSTA0069MB



Item	Part Number	Description	Quantity
D1	VSTA0070	Heat Tunnel Hood & Heaters	1
D2	VSTA0071MB	Heat Tunnel Conveyor & Support with Wire Mesh Belt Conveyor	1

Heat Tunnel Hood & Heaters – VSTA0070

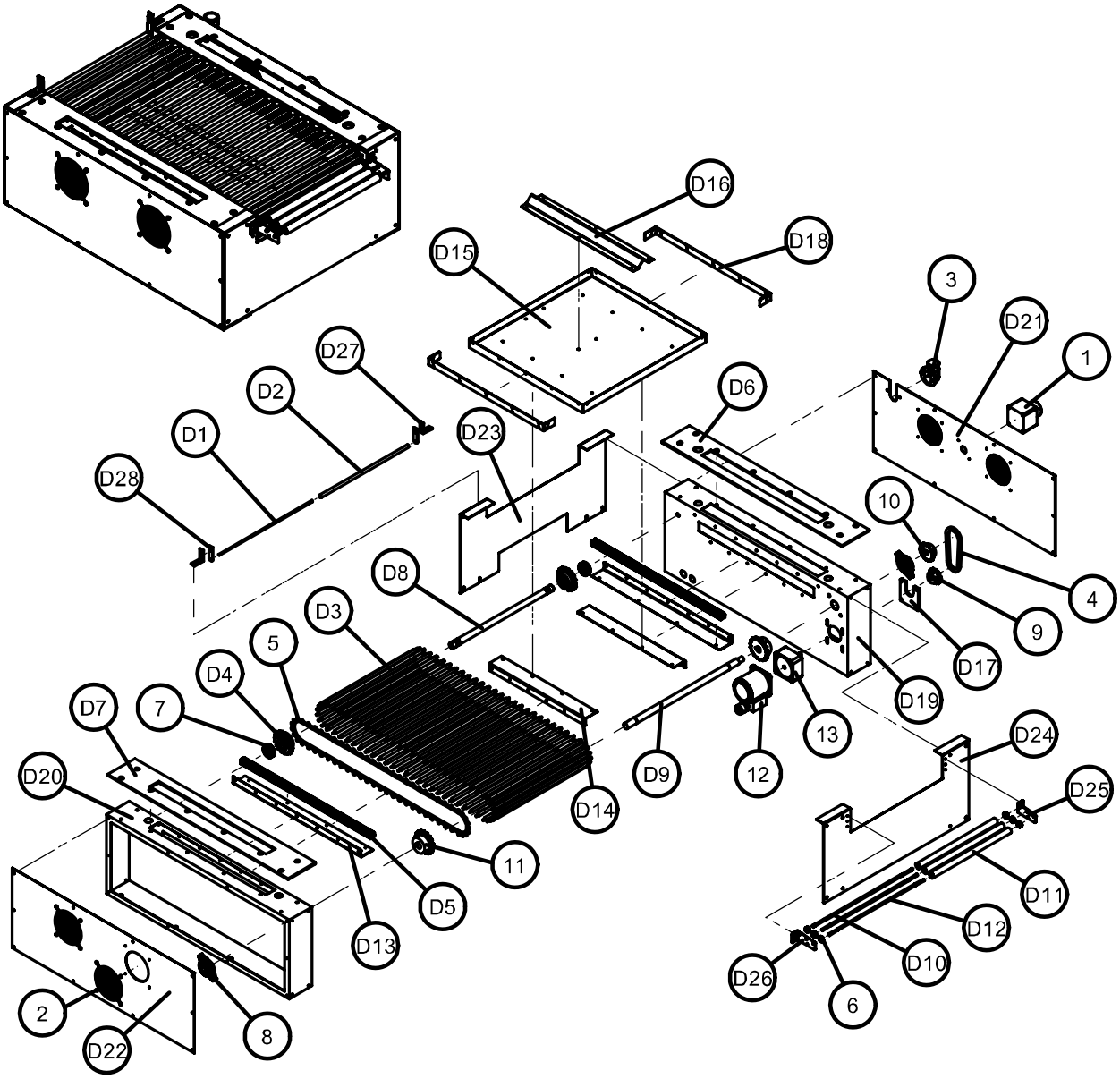


Item	Part Number	Description	Quantity
D1	VSTA0077	Fixed Plate	2
D2	VSTA0078	Bakelite A	2
D3	VSTA0079	Bakelite B	4
D4	VSTA0080	Cushion	4
D5	VSTA0081	Inner Furnace	1
D6	VSTA0082	Fixed Plate	1
D7	VSTA0083	Connection Board	2
D8	VSTA0084	Fixed Plate	2

Item	Part Number	Description	Quantity
D9	VSTA0085	Shutter	2
D10	VSTA0086	Fixed Plate	1
D11	VSTA0087	Furnace Door (Front)	1
D12	VSTA0088	Furnace Door (Rear)	1
D13	VSTA0089	Washer	48
D14	VSTA0090	Furnace Cover	1
D15	VSTA0091	Connection Board	4

Item	Part Number	Description	Quantity
1	VSTA0072	Fixed Ring	12
2	VSTA0073	Insulation Cloth	4
3	VSTA0035	Ceramic Insulator	12
4	VSTA0074	Ceramic Insulator	12
5	VSTA0036	Centrifugal Fan	1
6	VSTA0075	Fan Cover	1
7	VSTA0076	Ceramic Fiber Cotton	1
8	VSTA0034	Tunnel Hood Fan Motor	1
9	VSTA0007	Thermometer	1
10	VSTA0002	Heater	6

Heat Tunnel Support & Conveyor with Wire Mesh Belt– VSTA0071MB

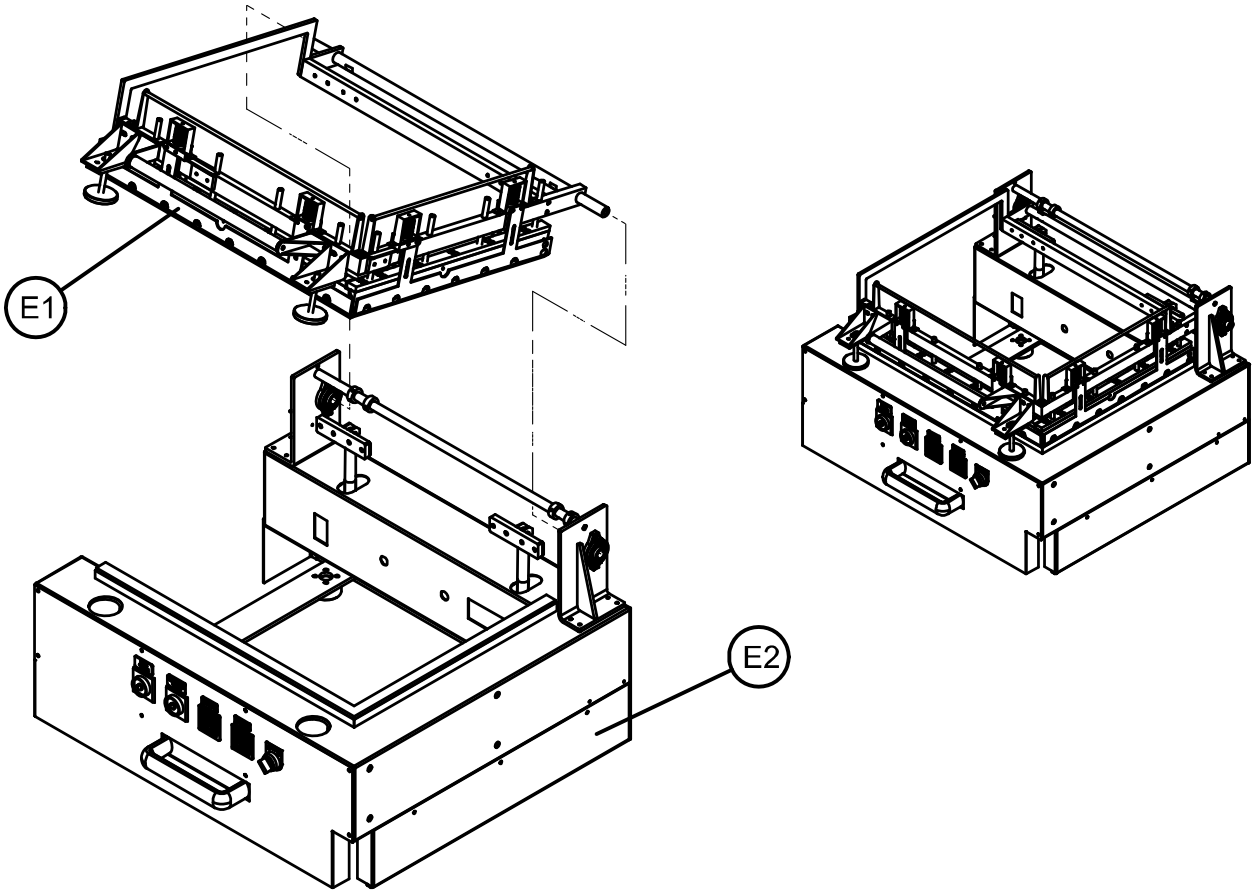


Item	Part Number	Description	Quantity
D1	VSTA0096	Connecting Axle	1
D2	VSTA0097	Connecting Roller	1
D3	VSTA0060	Output Belt Wire Mesh	1
D4	VSTA0055	Output Roller	3
D5	VSTA0099	Sprocket	2
D6	VSTA0100	Track	2
D7	VSTA0101	Bakelite A	1
D8	VSTA0102	Bakelite B	1
D9	VSTA0103	Driven Shaft	1

Item	Part Number	Description	Quantity
D10	VSTA0104	Driving Shaft	1
D11	VSTA0105	Output Axle	1
D12	VSTA0106	Output Roller	3
D13	VSTA0107	Output Axle-1	2
D14	VSTA0108	Connection Board	2
D15	VSTA0109	Connection Board	2
D16	VSTA0110	Bottom Plate	1
D17	VSTA0111	Fixed Plate	1
D18	VSTA0112	Motor Fixed Plate	1
D19	VSTA0113	Connection Board	2
D20	VSTA0114	Furnace Frame (Left)	1
D21	VSTA0115	Furnace Frame (Right)	1
D22	VSTA0116	Frame Cover (Left)	1
D23	VSTA0117	Frame Cover (Right)	1
D24	VSTA0118	Frame Cover (Front)	1
D25	VSTA0119	Frame Cover (Rear)	1
D26	VSTA0120	Output Roller Support-1	1
D27	VSTA0121	Output Roller Support-2	1
D28	VSTA0122	Roller Fixed Plate	2

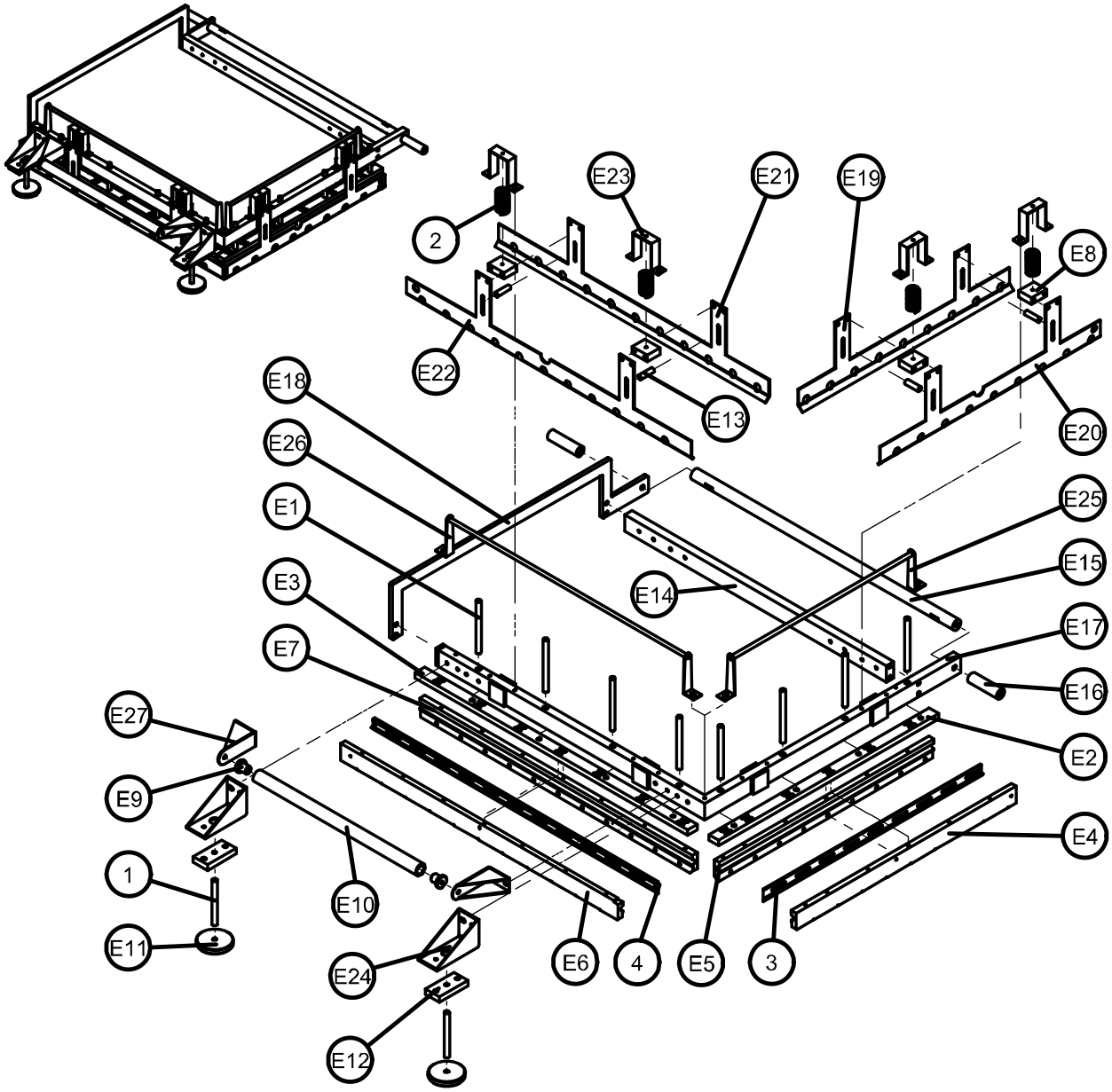
Item	Part Number	Description	Quantity
1	VSTA0092	Emergency Button	1
2	VSTA0075	Fan Cover	4
3	VSTA0094	Connector	1
4	VSTA0064	Roller Chain	1
5	VSTA0059	Chain With Attachment	2
6	VSTA0014	Bearing	6
7	VSTA0056	Bearing	2
8	VSTA0054	Block Bearing	2
9	VSA00058	Sprocket	1
10	VSTA0058	Sprocket	1
11	VSTA0057	Sprocket	2
12	VSSA0006	Induction Motor	1
13	VSTA0095	Gear Box	1

L-Sealer and Support with L-Seal Controls – VSSA00266



Item	Part Number	Description	Quantity
E1	VSSA0314	L-Sealer Upper Frame	1
E2	VSSA0315	L-Sealer Mid Frame with L-Seal Controls	1

L-Sealer Upper Frame – VSSA0314

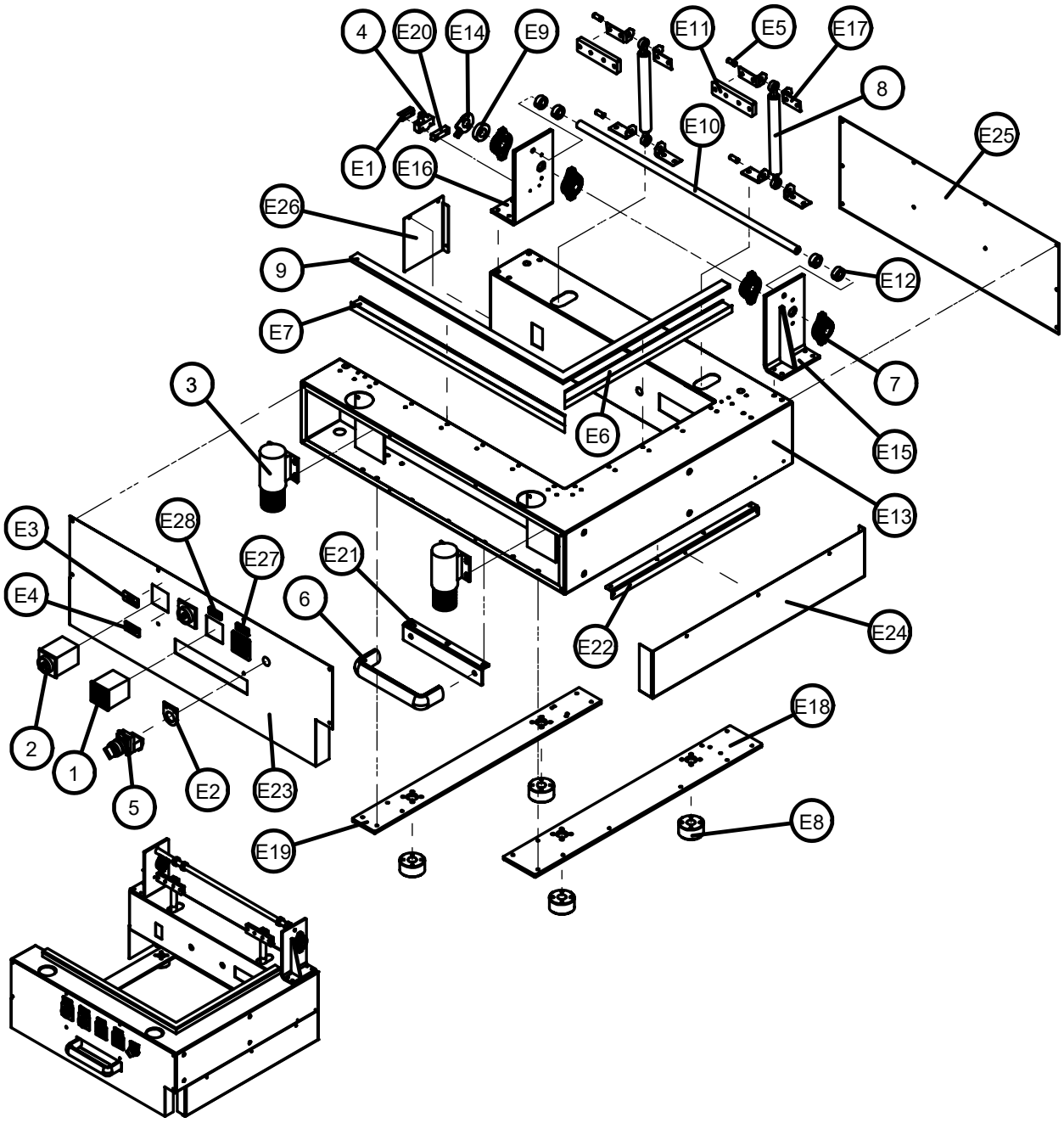


Item	Part Number	Description	Quantity
E1	VSSA0319	Screw	8
E2	VSSA0320	Horizontal Upper Board	1
E3	VSSA0321	Vertical Upper Board	1
E4	VSSA0322	Horizontal Seal Seat (Front)	1
E5	VSSA0323	Horizontal Seal Seat (Rear)	1
E6	VSSA0324	Vertical Seal Seat (Front)	1
E7	VSSA0325	Vertical Seal Seat (Rear)	1
E8	VSSA0326	Fixed Seat	4

Item	Part Number	Description	Quantity
E9	VSSA0327	Handle Shaft	2
E10	VSSA0328	Handle	1
E11	VSSA0329	Pressure Plate	2
E12	VSSA0330	Adjustment Seat	2
E13	VSSA0331	Isolation Collar	4
E14	VSSA0332	Crossbar	1
E15	VSSA0333	Axle	1
E16	VSSA0334	Axle	2
E17	VSSA0335	Upper Sealing Arm	1
E18	VSSA0336	Left Support Board	1
E19	VSSA0337	Horizontal Inner Board	1
E20	VSSA0338	Horizontal Outer Board	1
E21	VSSA0339	Vertical Inner Board	1
E22	VSSA0340	Vertical Outer Board	1
E23	VSSA0341	Limit Board	4
E24	VSSA0342	Fixed Seat	2
E25	VSSA0343	Fixed Rod-1	1
E26	VSSA0344	Fixed Rod-2	1
E27	VSSA0345	Handle Seat	2

Item	Part Number	Description	Quantity
1	VSSA0315	Hex Socket Set Screw	2
2	VSSA0316	Compression Spring (SUS)	4
3	VSSA0317	Transverse Direction (TD) Cutter	1
4	VSSA0318	Machine Direction (MD) Cutter	1

L-Sealer Mid Frame with L-Sealer Controls – VSSA0314

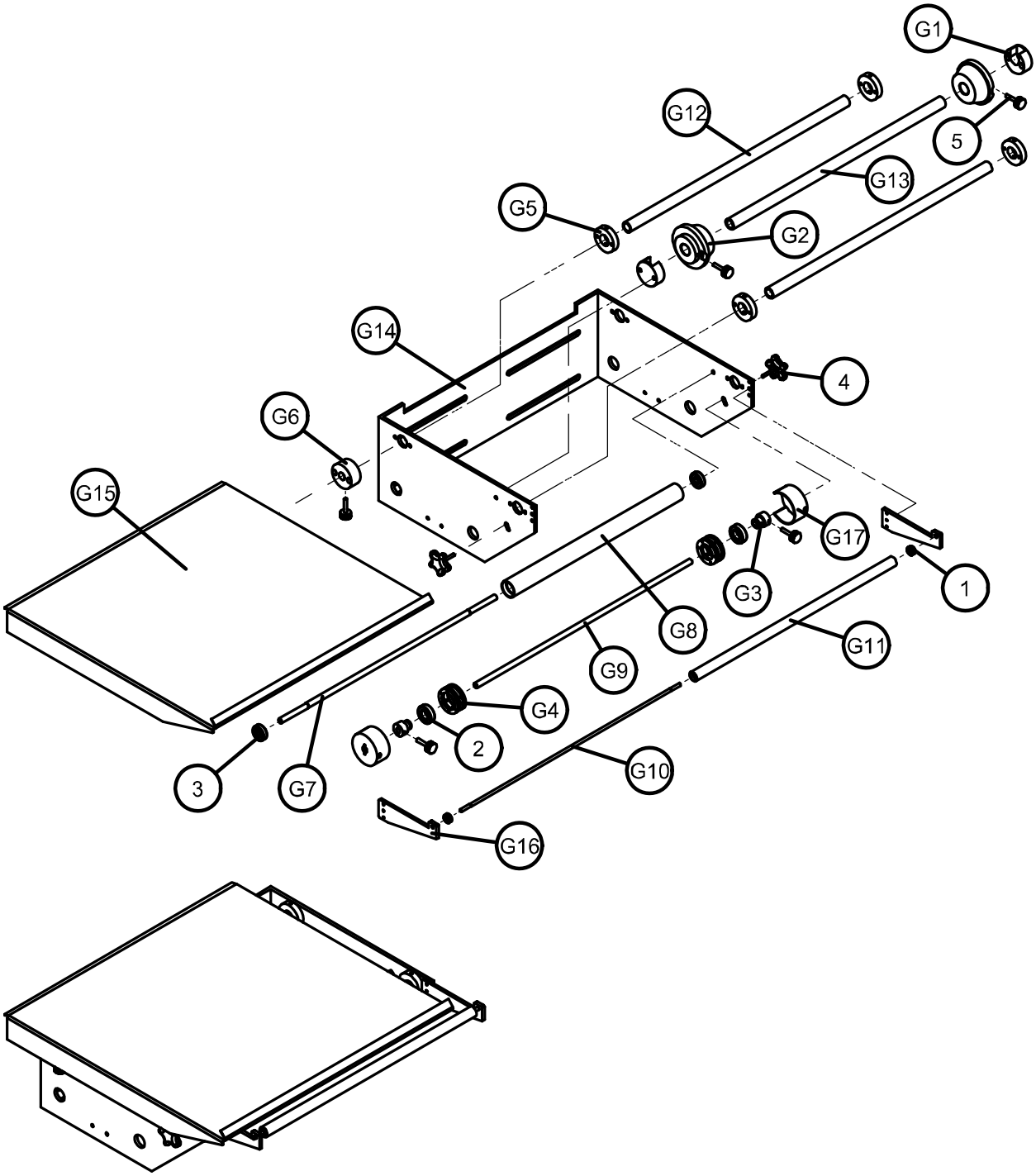


Item	Part Number	Description	Quantity
E1	VSSA0349	Fixed Plate	1
E2	VSSA0350	Indicator-5	1
E3	VSSA0351	Indicator-9	1
E4	VSSA0352	Indicator-10	1

Item	Part Number	Description	Quantity
E5	VSSA0353	Axle	4
E6	VSSA0354	Horizontal Seal Seat	1
E7	VSSA0355	Vertical Seal Seat	1
E8	VSSA0356	Screw Seat	4
E9	VSSA0357	Fixed Ring	1
E10	VSSA0358	Bar	1
E11	VSSA0359	Support Pad	2
E12	VSSA0360	Limit Ring	4
E13	VSSA0361	Sealing Body	1
E14	VSSA0362	Fretting Plate	1
E15	VSSA0363	Fixed Seat (Right)	1
E16	VSSA0364	Fixed Seat (Left)	1
E17	VSSA0365	Cylinder Seat	8
E18	VSSA0366	Upper Lifting Board 1	1
E19	VSSA0367	Upper Lifting Board 2	1
E20	VSSA0368	Cushion	1
E21	VSSA0369	Fixed Plate	1
E22	VSSA0370	Fixed Plate	1
E23	VSSA0371	Panel	1
E24	VSSA0372	Cover 1	1
E25	VSSA0373	Cover 2	1
E26	VSSA0374	Cover 3	1
E27	VSSA0375	Indicator	1
E28	VSSA0376	Indicator	1

Item	Part Number	Description	Quantity
1	VSTA0093	Temperature Controller, Hot Knife Seal, MD & TD	2
2	VSCP0003	Time Relay	2
3	VSSA0144	Solenoids	2
4	VSSA0008	Basic Switch	1
5	VSSA0346	Selector Switch	1
6	VSSA0150	Bow Type Handle	1
7	VSSA0149	Linear Bushing	4
8	VSSA0347	Cylinder	2
9	VSA00001	Sponge Rubber ¼” × 1” (25mm)	1

Product Tray with Film Holder and Perforator – VSSA0267

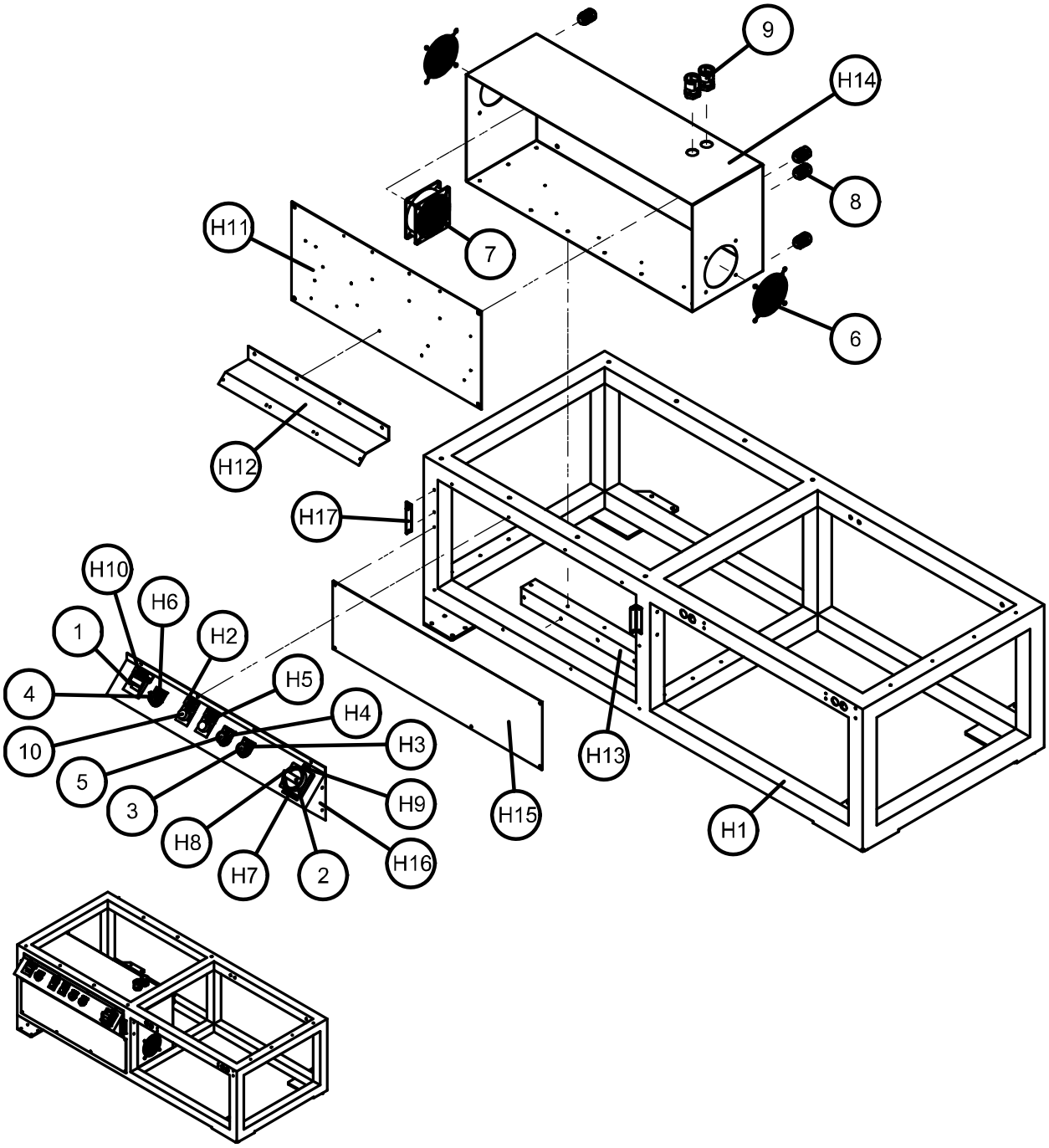


Item	Part Number	Description	Quantity
G1	VSSA0377	Fixed Seat	2
G2	VSSA0378	Shrink Wrap Fixed Block	2
G3	VSSA0379	Pin Ring Bushing	2
G4	VSSA0380	Pin Ring	2

Item	Part Number	Description	Quantity
G5	VSSA0381	Fixed Seat	4
G6	VSSA0382	Fixed Seat-1	1
G7	VSSA0383	Feed Roller Axle-1	1
G8	VSSA0384	Feed Roller-1	1
G9	VSSA0385	Pin Ring Axle	1
G10	VSSA0386	Feed Roller Axle-2	1
G11	VSSA0387	Feed Roller-2	1
G12	VSSA0388	Guide Rod-1	2
G13	VSSA0389	Guide Rod-2	1
G14	VSSA0390	Rack	1
G15	VSSA0391	Membrane Plate	1
G16	VSSA0392	Roller Support	2
G17	VSSA0393	Pin Ring Cover	2

Item	Part Number	Description	Quantity
1	VSTA0014	Bearing	2
2	VSSA0251	Bearing	2
3	VLA00034	Bearing	2
4	4502389	Plum Handle	2
5	VSSA0250	Embossing Screw	5

Main Electrical Panel and Tunnel Control Panel – VSCP0038



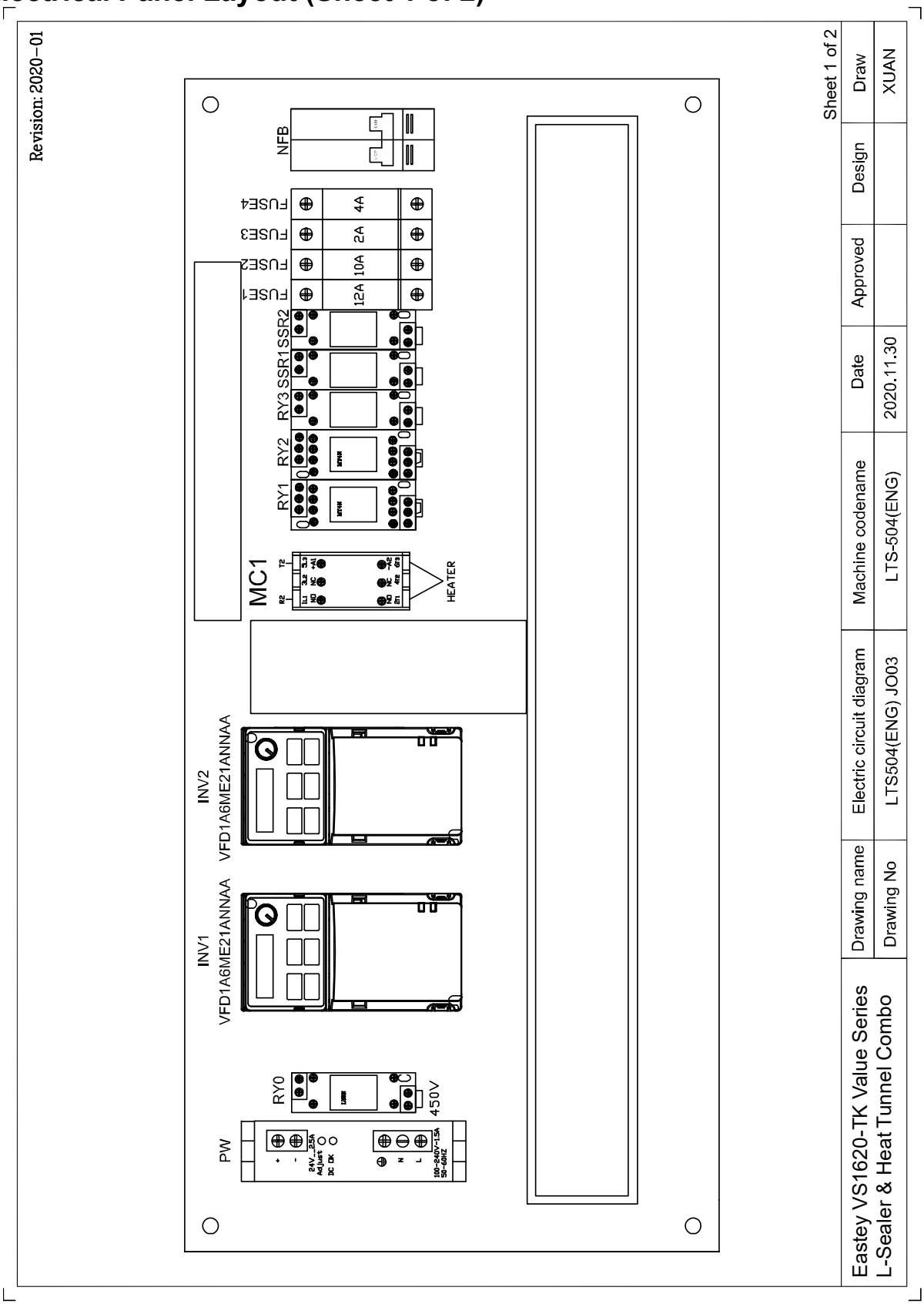
Item	Part Number	Description	Quantity
H1	VSCP0044	Main Frame	1
H2	VSCP0045	Indicator-1	1
H3	VSCP0046	Indicator-2	1
H4	VSCP0047	Indicator-3	1
H5	VSCP0048	Indicator-4	1

Item	Part Number	Description	Quantity
H6	VSCP0049	Indicator-5	1
H7	VSCP0050	Indicator-6	1
H8	VSCP0051	Indicator-7	1
H9	VSCP0052	Indicator-8	1
H10	VSCP0053	Indicator-12	1
H11	VSCP0054	Switchboard	1
H12	VSCP0055	Fixed Board	1
H13	VSCP0056	Connection Board	1
H14	VSCP0057	Electric Box	1
H15	VSCP0058	Cover	1
H16	VSCP0059	Operation Panel	1
H17	VSCP0060	Connection Board	2

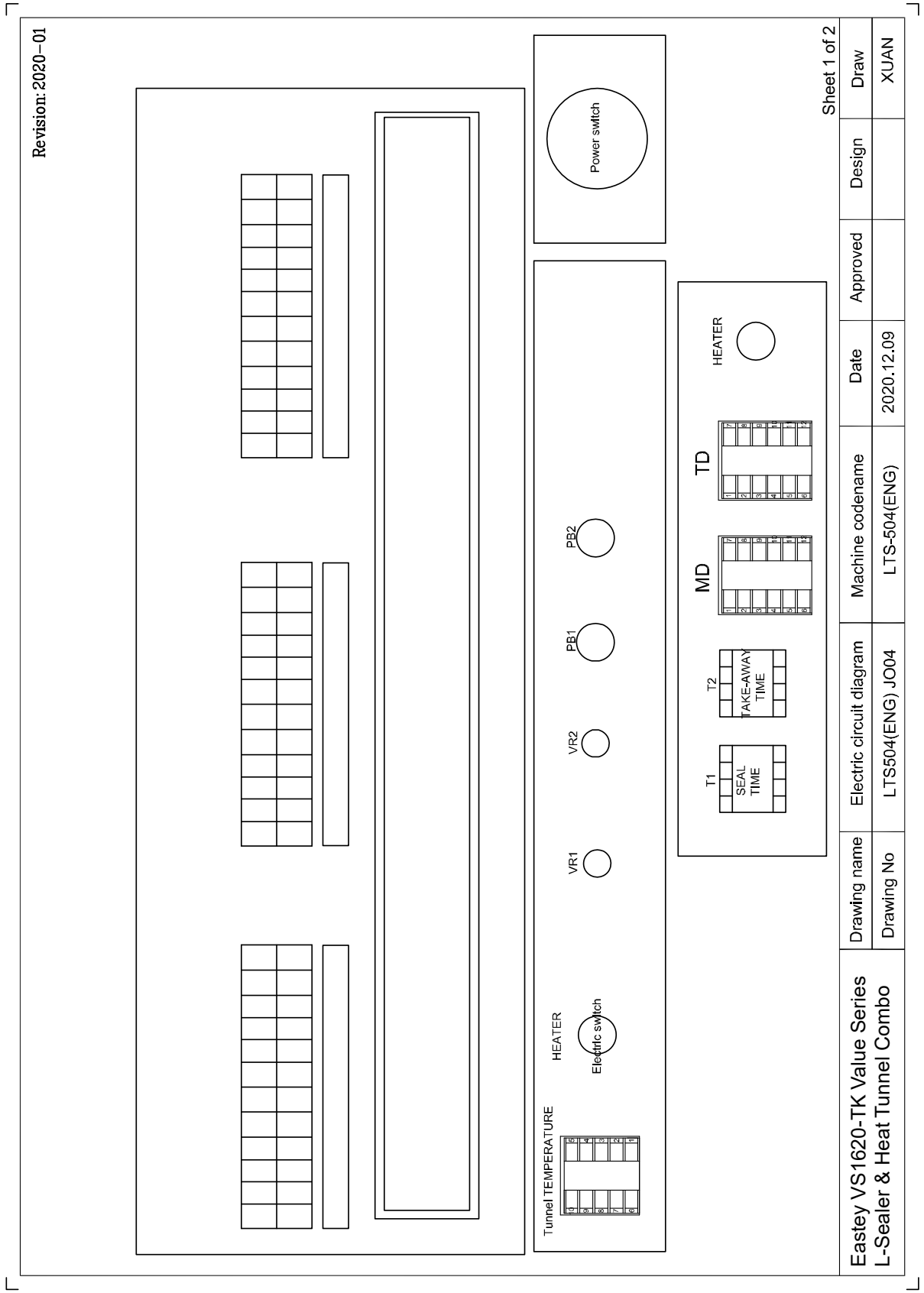
Item	Part Number	Description	Quantity
1	VSTA0001	Temperature Controller, Heat Tunnel	1
2	VSCP0018	Main Switch	1
3	VSCP0039	Push Button Switch	1
4	VSCP0040	Selector Switch	1
5	4501321	Push Button Switch	1
6	VSCP0041	Fan Cover	2
7	4502361	Fan	1
8	VSCP0042	Nylon Cable End Gland	4
9	VSCP0043	Straight Connector	2
10	VSCP0008	Potentiometer	2

Electrical

Electrical Panel Layout (Sheet 1 of 2)



Electrical Panel Layout (Sheet 2 of 2)



Electrical Parts List

DESIGNATOR	DESCRIPTION	PART NO.
POWER SUPPLY REIGNPOWER	Power Supply, 24 VDC ReignPower, DRP024V060W1AZ	VSCP0006
MC1	Contactor 1	VSCP0002
MC2	Contactor 2	VSCP0001
FUSE 1	Fuse, 12 Amp	VSCP0010
FUSE 2	Fuse, 10 Amp	VSCP0011
FUSE 3	Fuse, 2 Amp	VSCP0013
FUSE 4	Fuse, 4 Amp	VSCP0012
RY1, RY2, RY3	Relay 1, Relay 2, Relay 3; Relay 24 Volt DC	VSCP0016
RY5	Relay 220 Volt	VSCP0015
T1 – T2	Timers: Conveyor & Magnet	VSSA0004

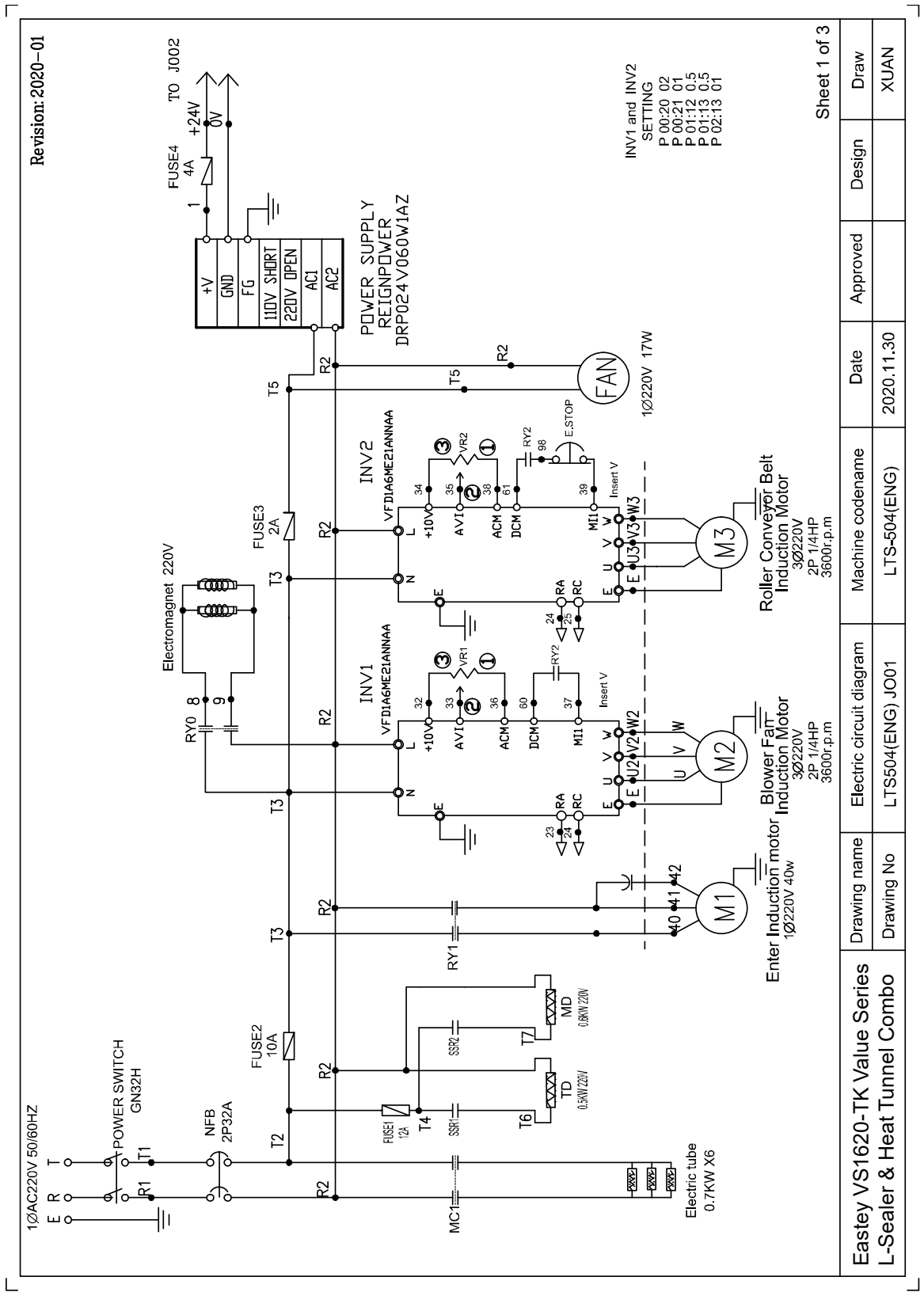
Items in the table above are shown in the Electrical Panel drawing on the previous page and the Electrical Schematics on the following pages.

DESIGNATOR	DESCRIPTION	PART NO.
HEATER 0.7 KW	Heater Rod 0.7 Kilowatt W × 6 – 220V (Tunnel)	VSTA0002
220V/45V	Transformer, 220V / 45V	VSCP0005
HOT KNIFE MD	Machine Direction (MD) Cutter / Sealer	VSSA0318
HOT KNIFE TD	Transverse Direction (TD) Cutter / Sealer	VSSA0317
M1	Take Away Conveyor Motor 1Φ 220V 40W	VSSA0006
M2	Blower Motor 3Φ 220V 2P-½ HP 3600 RPM	VSTA0005
M3	Tunnel Conveyor Motor 3Φ 220V 25W	VSTA0003
TEMP. PROBE	Temperature Probe	VSTA0007
L. S.	Limit Switch 250V 25A	VSSA0008
TEMP. CONTROLLER	Temperature Controller, Heat Tunnel	VSTA0001
E5CC TD & E5CC MD	Temperature Controllers, T.D. & M.D. Cutter / Sealer	VSTA0093

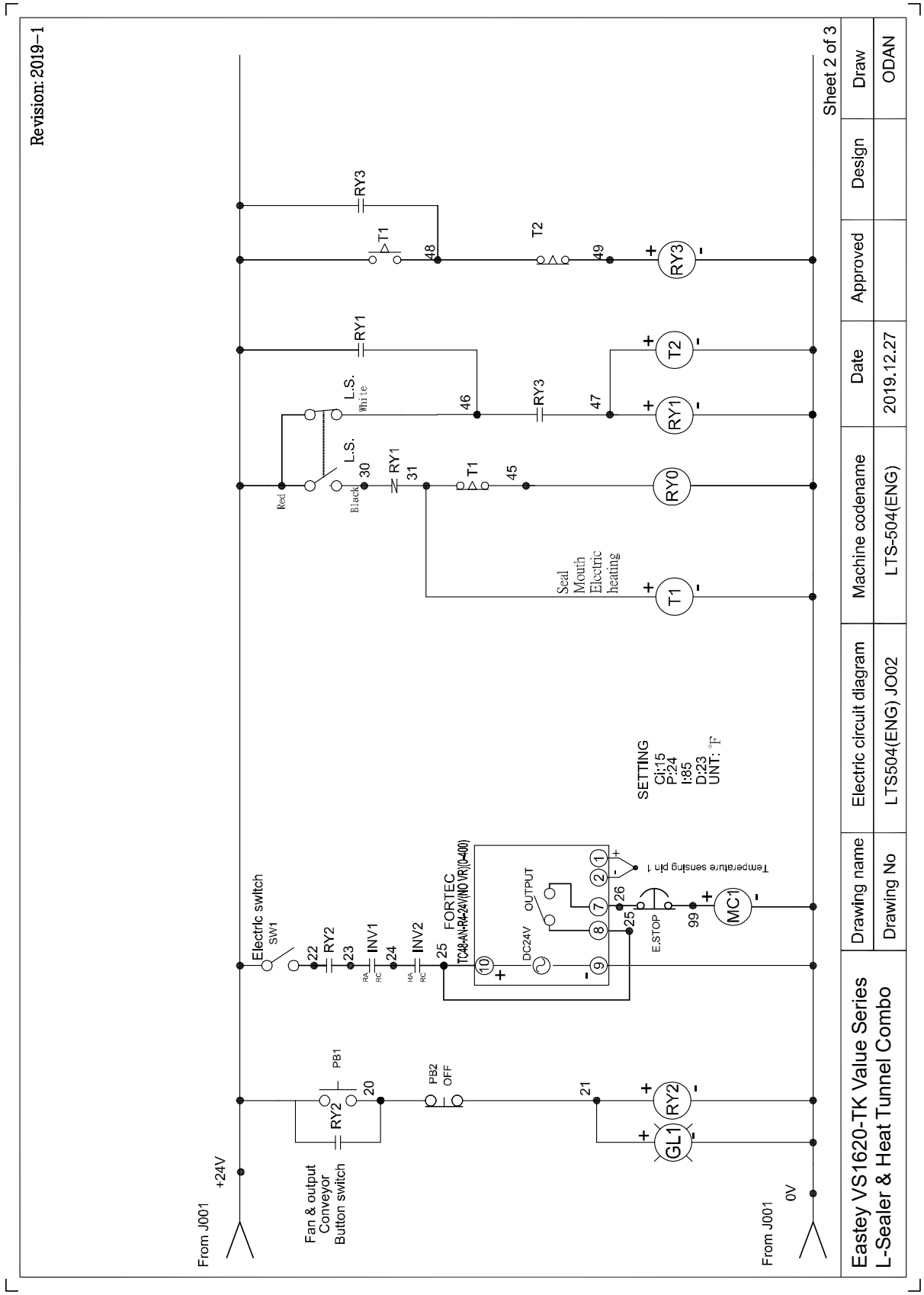
Items in the table above are shown in the Electrical Schematics on the following pages.

Appendix A

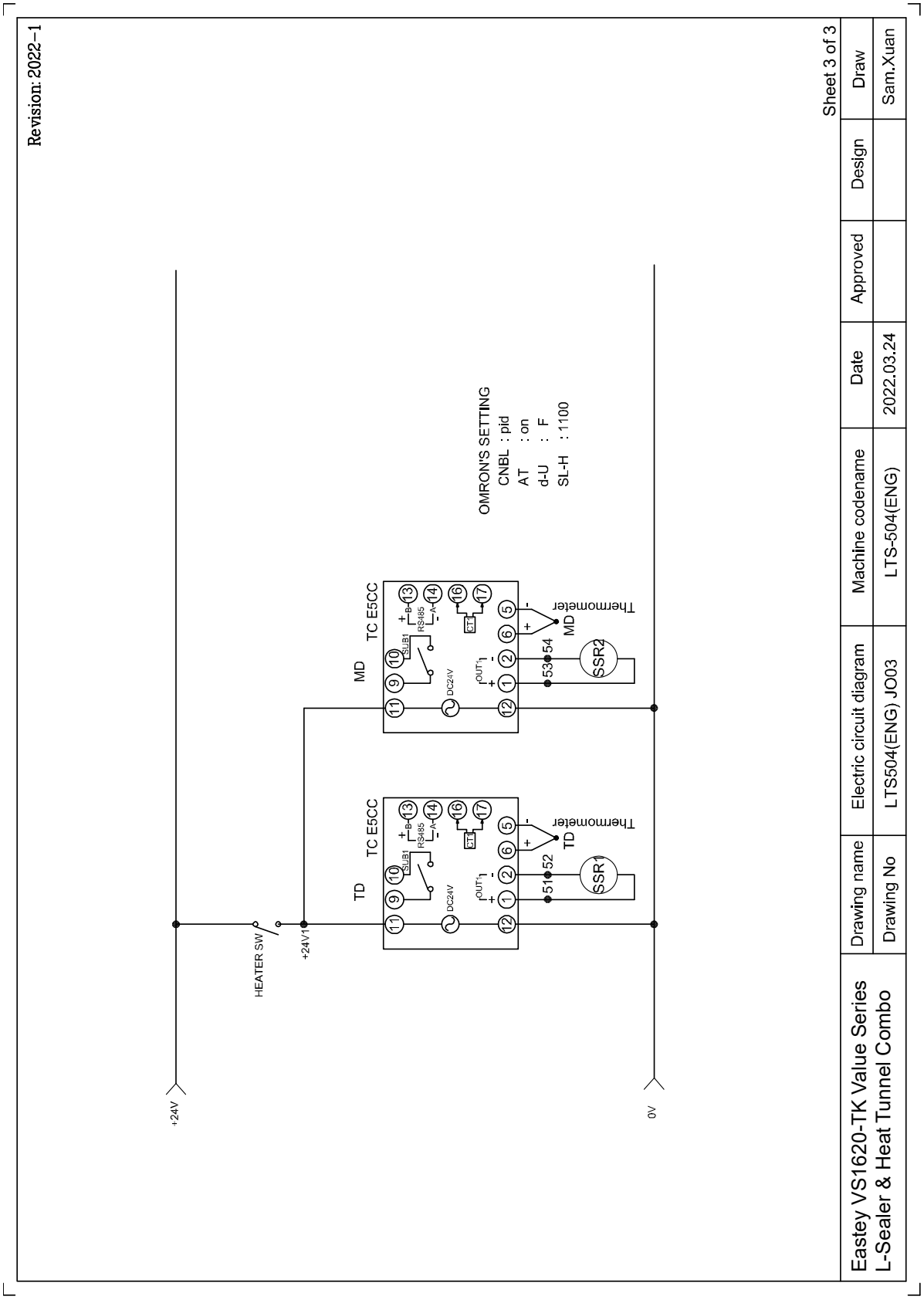
Electrical Schematic (Sheet 1 of 3)



Electrical Schematic (Sheet 2 of 3)



Electrical Schematic (Sheet 3 of 3)



Warranty Statement
Shrink Packaging Equipment

This Warranty Statement Is Available Online

This Warranty Statement is also available from the Eastey Support Website in electronic format for web browsers and e-readers. Go to Engage Technologies.net >> Eastey >> Case Sealing & Shrink Packaging Equipment >> Warranty >> Shrink Packaging Warranty or scan the QR Code at right using the camera app on your mobile device to go directly to the online version of the most current version this Warranty Statement.

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. Purchased parts will be warranted for one (1) year.

Damage caused during transport is the responsibility of the carrier and is not covered under this warranty. All damages detected upon receipt of equipment should be reported immediately to the carrier and Eastey should be notified.

Warranty Period – Specific Items

Any moving or wear parts are covered for 180 days after the date of purchase. This includes items such as conveyor belt, silicone tubing (roller covering), end curtains, felt pad, bearings, and wear rails. The seal pad and fuses are consumable items and are not covered under warranty.

Repairs

All in-house repairs are rigorously tested for optimum operation and performance and warranted to be, under normal and proper use, free from defects in materials and workmanship for a period of 90 days from the date of service.

Shrinking Quality

Shrinking quality achieved in a given application is dependent on the film, product, installation, material handling, and the maintenance provided. Eastey makes no warranty that the shrinking 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 charges for replacement components. If the item is defective and under warranty, Eastey will pay all return shipping charges via the least costly method. If expedited shipping is desired, the customer must furnish their shipping account number and shipping fees will be charged to that account.

Exclusions

Damage due to tampering, abuse, improper adjustment, electrical interference, or the use of non-approved components will void any and all warranties by Eastey and its distributors.

EASTEY
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1-800-835-9344 • (763) 795-8856 • Fax (763) 795-8867
info@eastey.com • www.eastey.com

Warranty Verification

If you believe that a product may be defective and may be covered by warranty, obtain a Return Material Authorization number by calling our technical support number (toll free at 1-800-835-9344, or 763-428-4846 or Fax: 763-795-8867) or e-mail info@eastey.com. Based on the recommendation from Eastey technical support, replacement components may be shipped out via UPS Ground or similar method. If expedited shipping is desired, customer must furnish their shipping account and shipping fees will be charged to that account.

Customer is required to return the defective component to Eastey. If after 30 days, Eastey hasn't received the defective component, the customer will be invoiced for the replacement component. If the returned component is found to not be eligible for warranty, Eastey will contact the customer and the customer will be invoiced for the replacement component.

Warranty within 60 days of invoice

For warranty questions that take place within 60 days of the original invoice, Eastey will allow cross-shipment of a replacement component to an end-user customer or Eastey distributor. The customer will be invoiced for the replacement component 60 days after it ships. Upon receipt of the returned component, Eastey will evaluate it and issue credit where necessary.

For components that have been misused or externally damaged, Eastey will not issue credit, and will contact the customer to determine whether or not they want the component repaired and/or returned.

Warranty after 60 days of invoice

For warranty questions that take place more than 60 days from the original invoice, Eastey requires the end-user or Eastey distributor to return the component to Eastey for repair. Upon receipt of the returned component, Eastey will evaluate it and repair as necessary.

Components that fall within our warranty policy will be repaired normally within 5 business days of receipt and returned to the customer via standard ground shipping at Eastey's expense. If expedited shipping is required, the customer must furnish their shipping account number and shipping fees will be charged to that account.

For components that have been misused or externally damaged, Eastey will contact the customer to determine whether or not they want the component repaired and/or returned.

Warranty Eligibility

The warranty provided by Eastey will only be covered provided that:

- Equipment usage is proper and normal
- Equipment is still owned by the original buyer
- Equipment has been operated in accordance with generally approved practice and in accordance with Eastey's specifications and instructions
- No repairs, alterations, or replacement have been made by others without Eastey's prior written approval
- Genuine Eastey repair components are used during the warranty period

Limited Warranty

THIS WARRANTY SHALL NOT APPLY IF ANY MODIFICATION, ALTERATION OR ADDITION IS MADE TO THE PRODUCT WITHOUT EASTEY'S PRIOR WRITTEN APPROVAL. FURTHERMORE, THIS WARRANTY DOES NOT APPLY TO PRODUCT DEFECTS DUE TO MISUSE, ABUSE, NEGLECT, OR FAILURE TO FOLLOW THE RECOMMENDED PROCEDURES. ANY PRODUCT REPAIRED OR ALTERED BY PERSONS OTHER THAN

AUTHORIZED EASTEY REPRESENTATIVES WILL NOT BE COVERED BY THIS WARRANTY. THIS WARRANTY DOES NOT APPLY TO CONSUMABLE ITEMS.

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Customer Support

Eastey Technical Service
For help installing or operating the Eastey Hot Knife L- Sealer and Tunnel Combo, please contact your authorized Eastey reseller or Eastey Technical Service at one of the numbers listed below.

Toll-Free Phone	800-835-9344
Phone	763-428-4846
Fax	763-795-8867
E-mail	eastey@eastey.com
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