

HOW TO CARRY OUT THE ADJUSTMENTS

We have listed out the meaning of each symbol. This section shows how to use them and how to check their values.

There are also these symbols:



whose functions are only to increase or decrease the values indicated on the lighted display. To use them, press both keys at the same time.

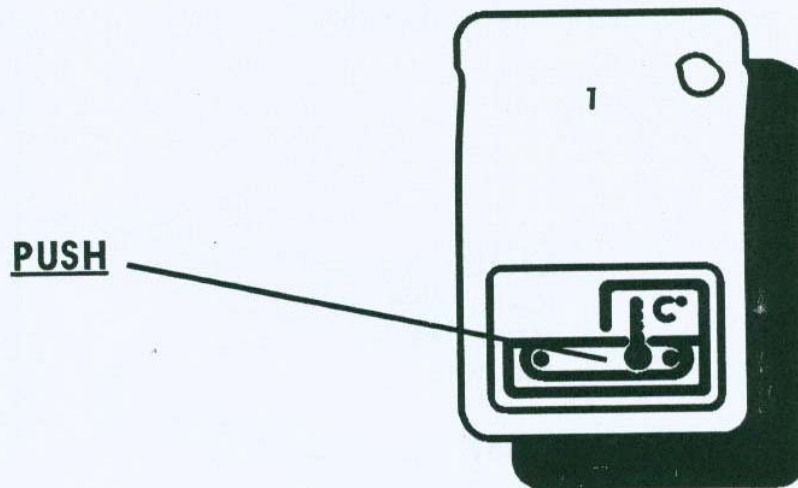


Lighted display showing the values set through the keyboard



TEMPERATURE ADJUSTMENT INSIDE TUNNEL

Push lightly on the symbol shown. The temperature in CENTIGRADE inside the tunnel will immediately be shown. The lighted signal will immediately light up.



By holding the button pressed down, the lighted signal will start to FLASH.

PUSH AT THE SAME TIME

TO INCREASE

TO DECREASE



CONTROL OF CONVEYOR SPEED

Push lightly on this symbol. The conveyor speed will immediately be shown by a number from 0 to 100. 0 indicates the minimum speed, and 100 indicates the maximum speed. The signal will immediately light up.

PUSH

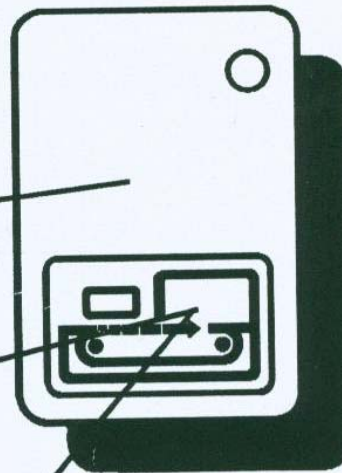
Rear conveyor twin machines only
see note

PUSH

Front conveyor twin machines only
see note

PUSH

Single conveyor machines

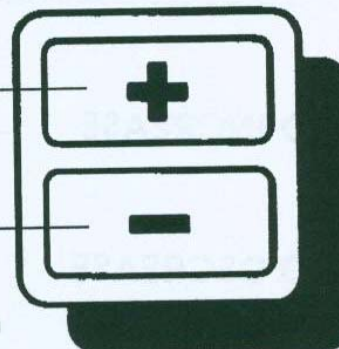


Holding the button pressed down, the lighted signal will start to FLASH.

PUSH AT THE SAME TIME

TO INCREASE

TO DECREASE



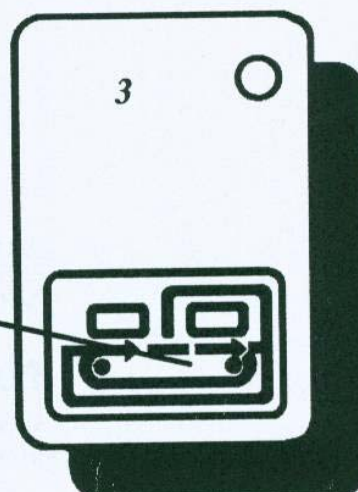
Note: Front conveyor control adjusts speed of both conveyors when working on the return cycle. Independent control will only function when the product is sent out of the rear of the tunnel.



ADJUSTMENT OF PRODUCT POSITION INSIDE THE SHRINKING TUNNEL

Push lightly on the symbol shown. A number indicating the position of the product will immediately appear. Number 20 indicates that the product is carried by the conveyor for about 200 mm; with an indication of 150, it will be transported outside the tunnel.

PUSH



Holding the button pressed down, the lighted symbol will start to FLASH.

PUSH AT THE SAME TIME

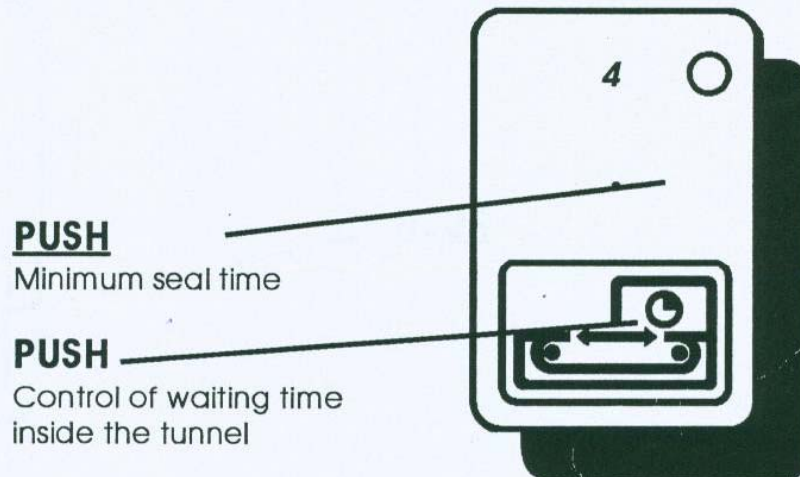
TO INCREASE

TO DECREASE



CONTROL OF WAITING TIME INSIDE TUNNEL

Press this symbol lightly. A number will immediately appear which indicates the waiting time for the product inside the tunnel before the product is moved back or leaves at the opposite end.

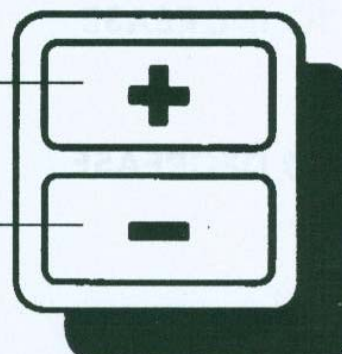


Holding the button pressed down, the lighted symbol will start to FLASH.

PUSH AT THE SAME TIME

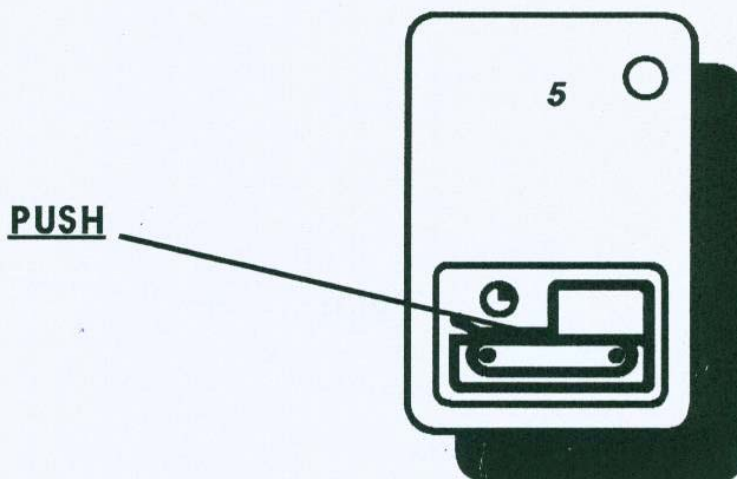
TO INCREASE

TO DECREASE



ADJUSTMENT OF SEALING TIME

Press this symbol lightly. A number will immediately appear which indicates the sealing time. THE SEALING TIME MUST NEVER BE MORE THAN 1.6 SEC.

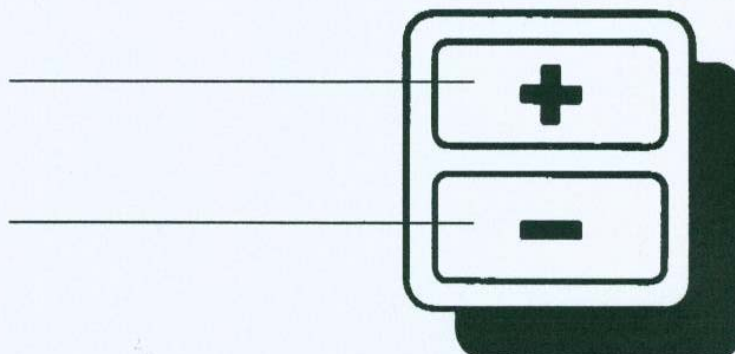


Holding the button pressed down, the lighted symbol will start to FLASH.

PUSH AT THE SAME TIME

TO INCREASE

TO DECREASE



PARTIAL PIECE COUNTER

To show the number of seals which have been made in one product lot, it is sufficient to press lightly over the arrow shown on the figure.

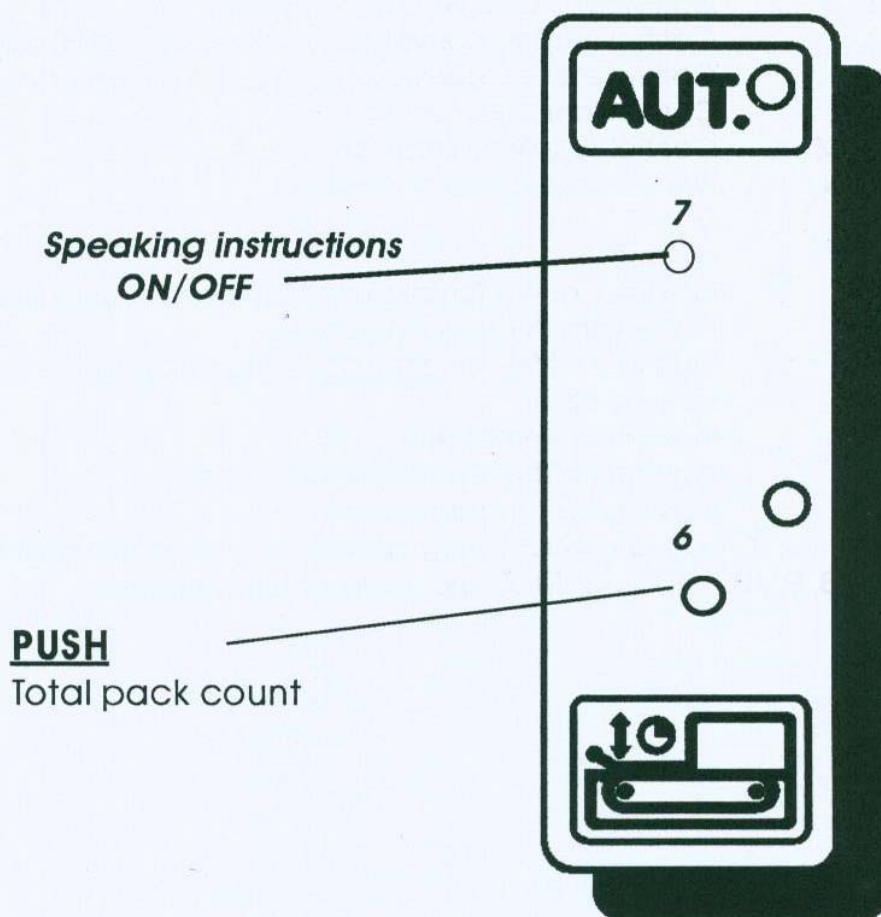
PUSH



To reset the number shown, switch off the main switch. When switched on again, after having pressed on the arrow, the number on the display will show: 0000.

TOTAL PIECE COUNTER

To show on the display the total number of sealings performed on the machine since the machine was made, it is sufficient to press lightly on the arrow shown on the figure.



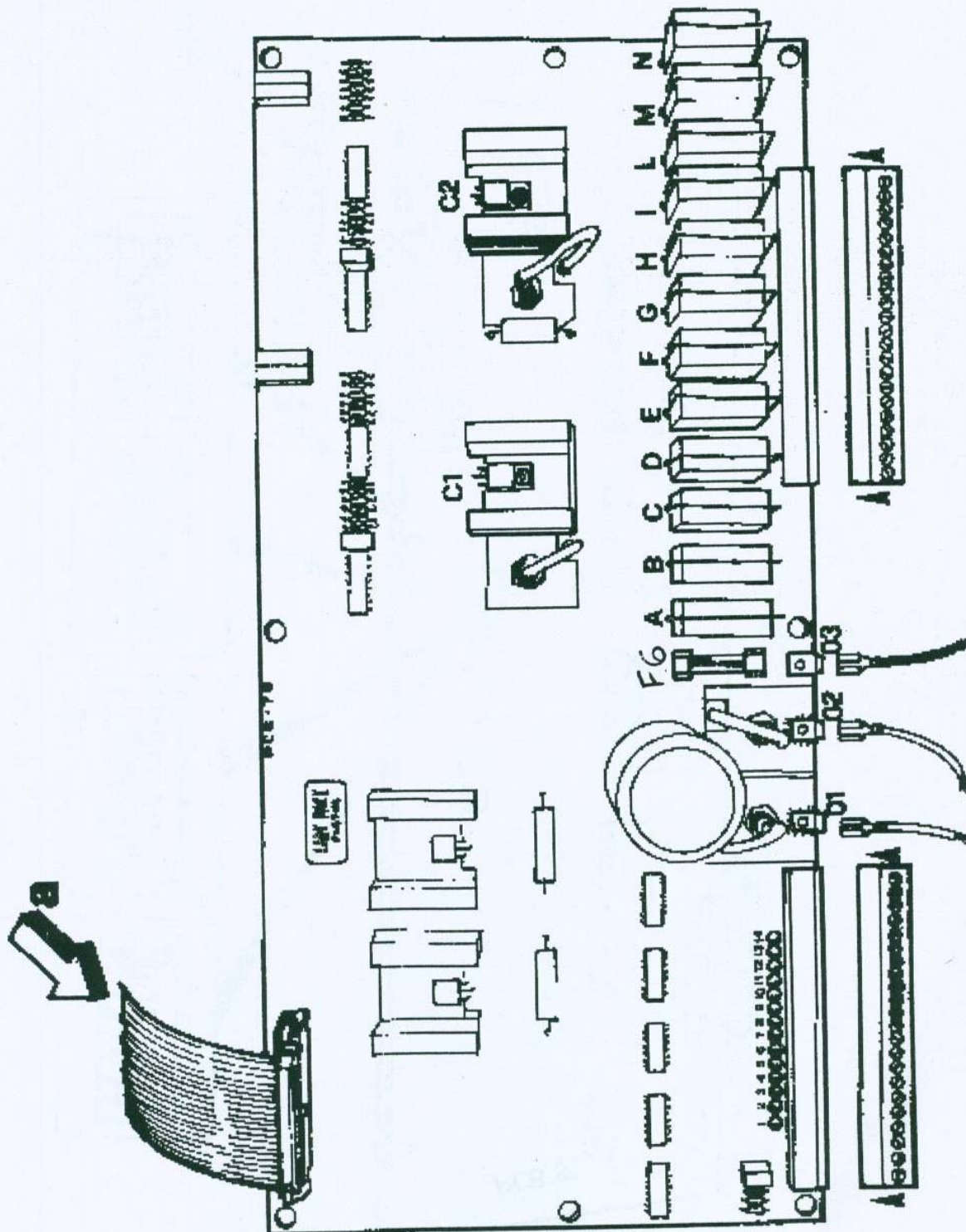
THE NUMBER SHOWN CANNOT BE RESET TO ZERO



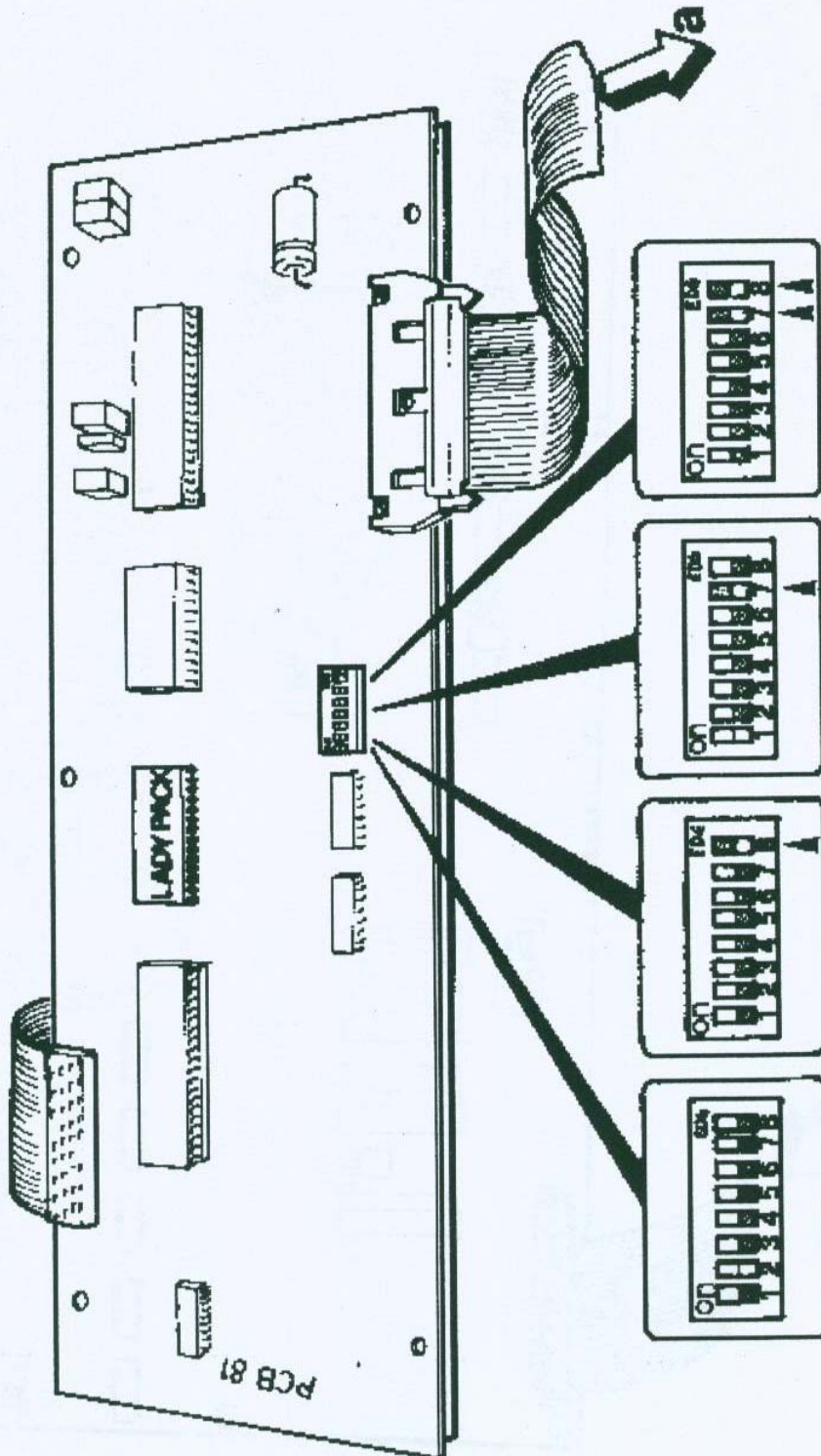
ELECTRONICAL BOTTOM PANEL PCB 79

- Relay A : Control magnet sealingbar
 - Relay B : Control sealingarm up (only on automatic machine)
 - Relay C : Control sealingarm down (only on automatic machine)
 - Relay D : Control conveyorbelt cycle forward
 - Relay E : Control conveyorbelt cycle reverse
 - Relay F : Control FIRST GROUP of heaters
 - Relay G : Control SECOND GROUP of heaters
 - Relay H : Control second conveyorbelt cycle forward (only if existing)
 - Relay I : Control second conveyorbelt cycle reverse (only if existing)
 - Relay L : Control fanmotor tunnel
 - Relay M : Control supply on sealingblade
 - Relay N : Control third group of heaters
-
- Led 1 : Indicator of the functioning of the chain sprocket of the second conveyorbelt (only if existing)
 - Led 2 : Indicator of the functioning of the chain sprocket of the first conveyorbelt
 - Led 3 : Indicator of emergency on
 - Led 4 : Indicator of the control of the pedal
 - Led 5 : Indicator sealingarm down
 - Led 6 : Indicator sealingarm up, only for automatic sealingarm
- Led 7, 8, 9, 10, 11, 12, 13, 14 are not used at the moment.

ELECTRONICAL BOTTOMPANEL PCB 79

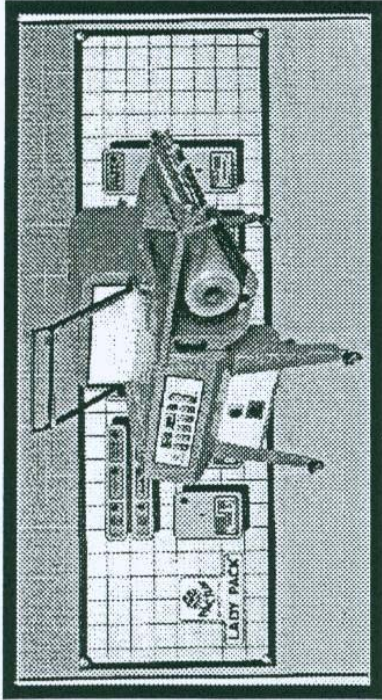


ELECTRONICAL TOPPANEL PCB 81B



LADY PACK®

Electrical board PCB 258 & PCB 263



* For Pactur's spare parts, even LESS STOCK in your warehouses!!!! Since now, the PCB are exchangeable!!!

Our experience and the high quality of our PLCs allowed us to fulfill this project:

Now in all automatic and semiautomatic models there will be :

- * one PCB 258 (keyboard) and
- * one PCB 263B (1CHP or 2CHP)

In Automatic models only, it will be also fitted:

- * a PCB 272 which will replace:

- * In SEMIAUTOMATIC models they will respectively REPLACE:

- * the PCB 78+81 (keyboard)

- * the PCB 79 (1CHP or 2 CHP)

- * In AUTOMATIC models they will respectively REPLACE:

- * a PCB 141 (keyboard)

- * the whole of ML46 + MUA4+ATR1+PCB 144

- * the EXP 16 card

