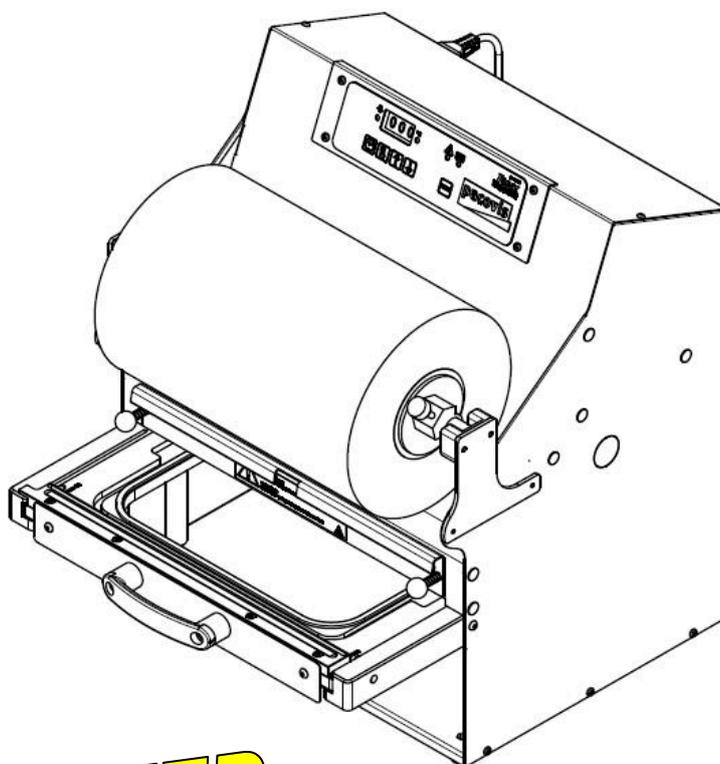
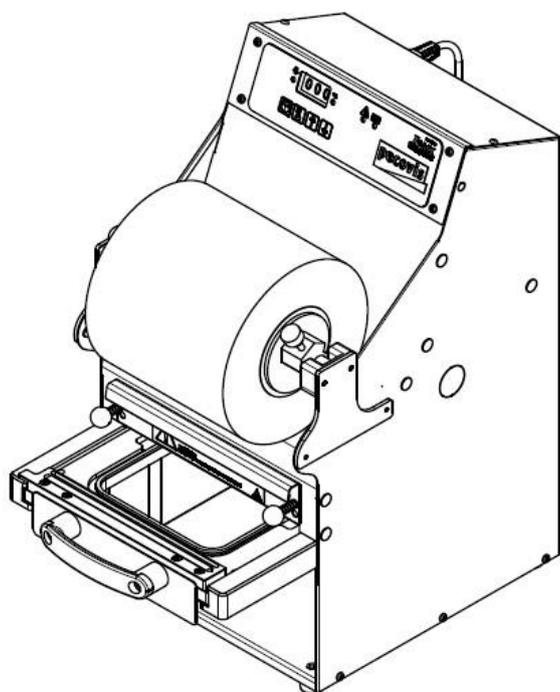


SEMI-AUTOMATIC THERMOSEALING MACHINES

Mod. TSS102-R
Item number: 18360

Mod. TSS105-R
Item number: 21379



PATENTED

MADE IN ITALY
JPACK
Packaging Machines

pacovis

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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-R / TSS105-R 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.

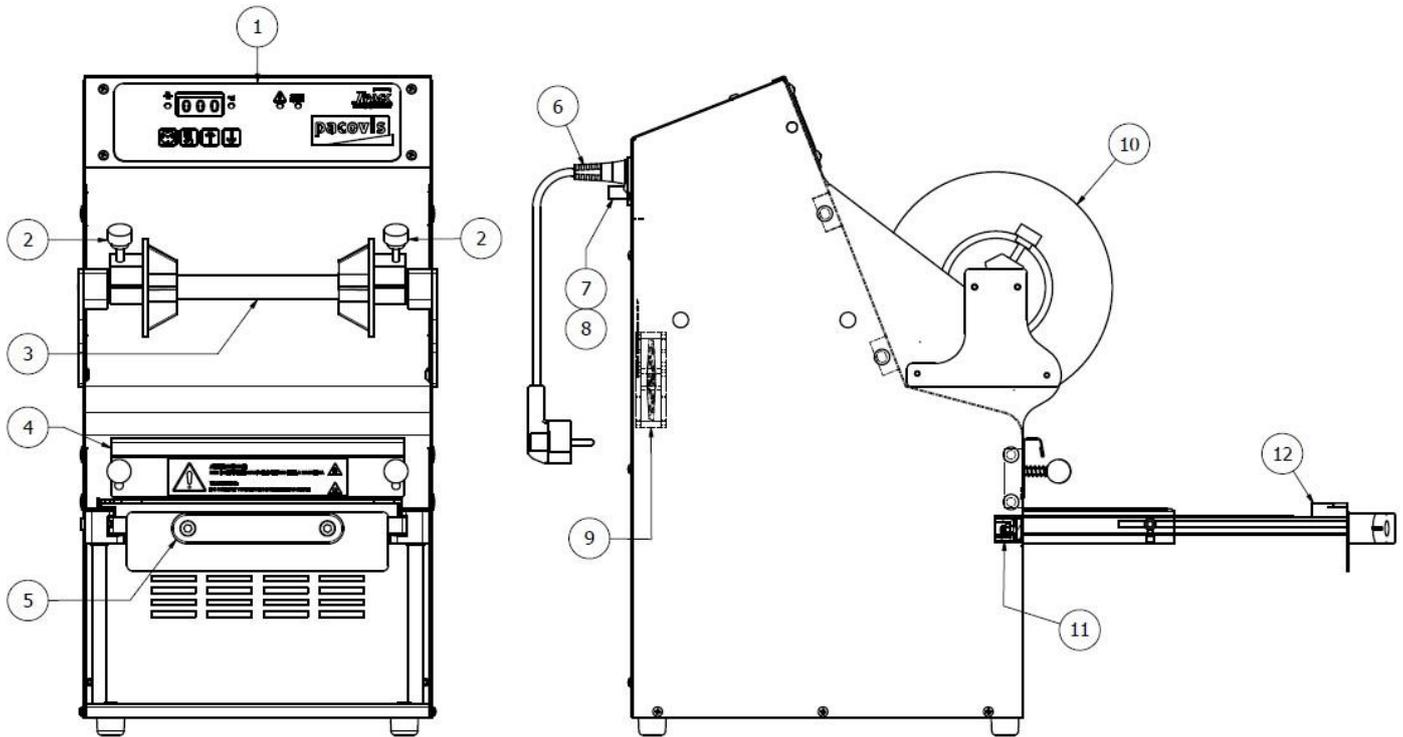
THIS MANUAL IS AN INTEGRAL PART OF THE PRODUCT AND MUST ACCOMPANY IT UNTIL ITS DISMANTLING.

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.

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MAIN MACHINE COMPONENTS

**Fig. 1**

1. CONTROL PANEL
2. CONES FOR FILM BALANCING
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. TRAY HOLDER MOULD

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 17 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

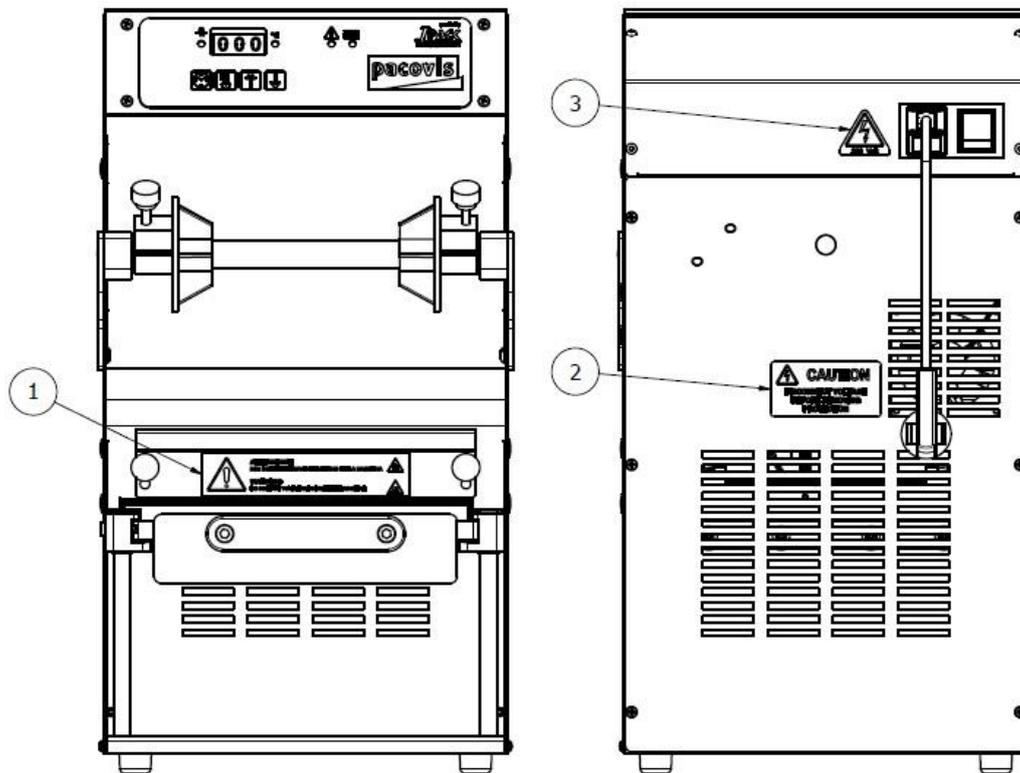
2.1. TECHNICAL SPECIFICATIONS

MACHINE, TRAYS AND REEL DIMENSIONS

	TSS102-R ITEM N. 18360	TSS105-R ITEM N. 21379
Length	450 mm	490mm
Width	295 mm	460mm
Height	555 mm	540mm
Length with tray holder removed	800 mm	600mm
Overall weight	25Kg	40Kg
Max. tray size	195x260 h155 mm	370x280 h 155 mm
Max. reel size	Ø200mm width 210mm	Ø200mm width 380mm
Airborne machine noise	Under 70dBA.	Under 70dBA.
Maximum TEMPERATURE of the sealing plate	200°	200°
Indicative production	3-8 cycles/min, depending on packaging	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



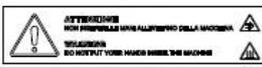
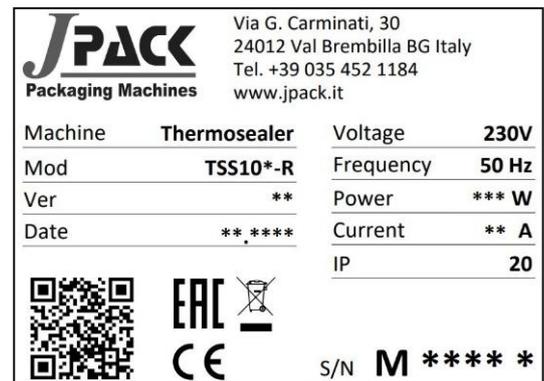
N°	Figura	Descrizione	Posizione
1		PERICOLI NON INTRODURRE LE MANI ALL'INTERNO DELLA MACCHINA	ALL'ESTERNO: LATO DI INGRESSO VASCHETTA E LATO D'USCITA VASCHETTA
2		DISCONNETTERE L'ALIMENTAZIONE ELETTRICA PRIMA DI RIMUOVERE IL CARTER DI PROTEZIONE	ALL'ESTERNO: LATO POSTERIORE DELLA MACCHINA
3		PRESENZA DI TENSIONE ELETTRICA, CAVI E CONNESSIONI IN TENSIONE	ALL'ESTERNO: IN PROSSIMITA' DEI CAVI DI ALIMENTAZIONE MACCHINA

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 (**Fig. 3**). 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 TSS thermosealing machines were designed for sealing rigid preformed plastic containers. The machines were designed 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. Upon request, a gas flushing system could be installed.

TSS machines allow 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.
6. Upper mould recovery phase.
7. Automatic film repositioning on magnets.
8. Manual extraction of the tray holder.

TSS machines are 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 operations 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.

TSS machines' allow 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: mould change-over, gas flushing system.

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 AND CONTAINERS. 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.



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. 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.

In machine failure conditions, the parts and the equipment that make up the machine are the most critical ones. The main critical aspect relates to possible problems due to the thermosealing machine locking, during which, even with the necessary limitations, it is possible to come into contact with the machine processing components.

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 (Fig. 4).

Since the unpacked machine is not equipped with specific attachments, it can only be lifted from the lower part of its body (Fig. 4).

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.

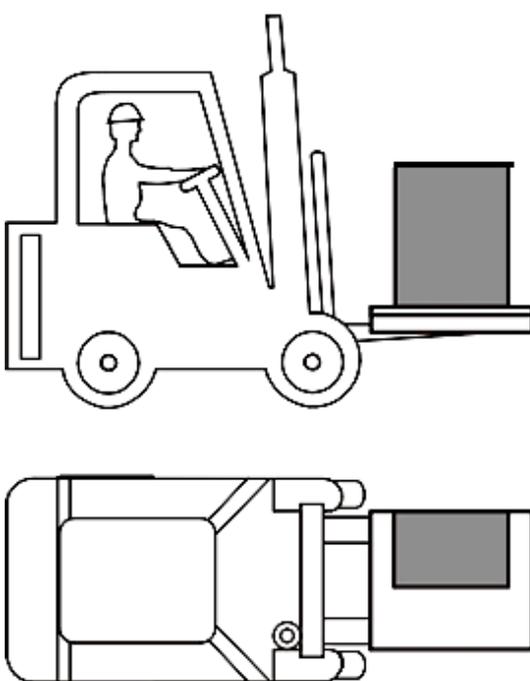


Fig. 4

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 with a load capacity exceeding the machine's weight.

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.

LA POSIZIONE DI LAVORO È QUELLA INDICATA IN FIGURA
ALLA MACCHINA DEVE ESSERE ADDETTO UN SOLO OPERATORE

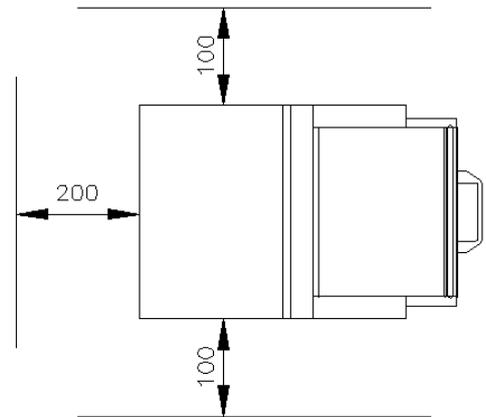
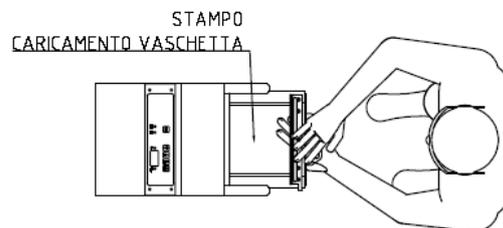
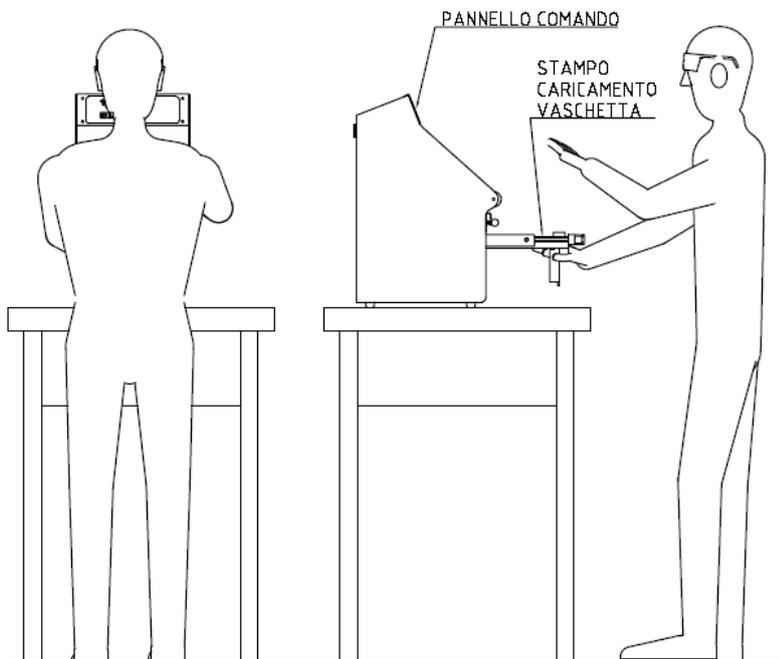


Fig. 5

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.

	TSS102-R ITEM N. 18360	TSS105-R ITEM N. 21379
Rated voltage	230V	230V
Frequency	50Hz	50Hz
Maximum power	750 W	1500W
Fuse on socket	6.3 A delayed-type	10 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!

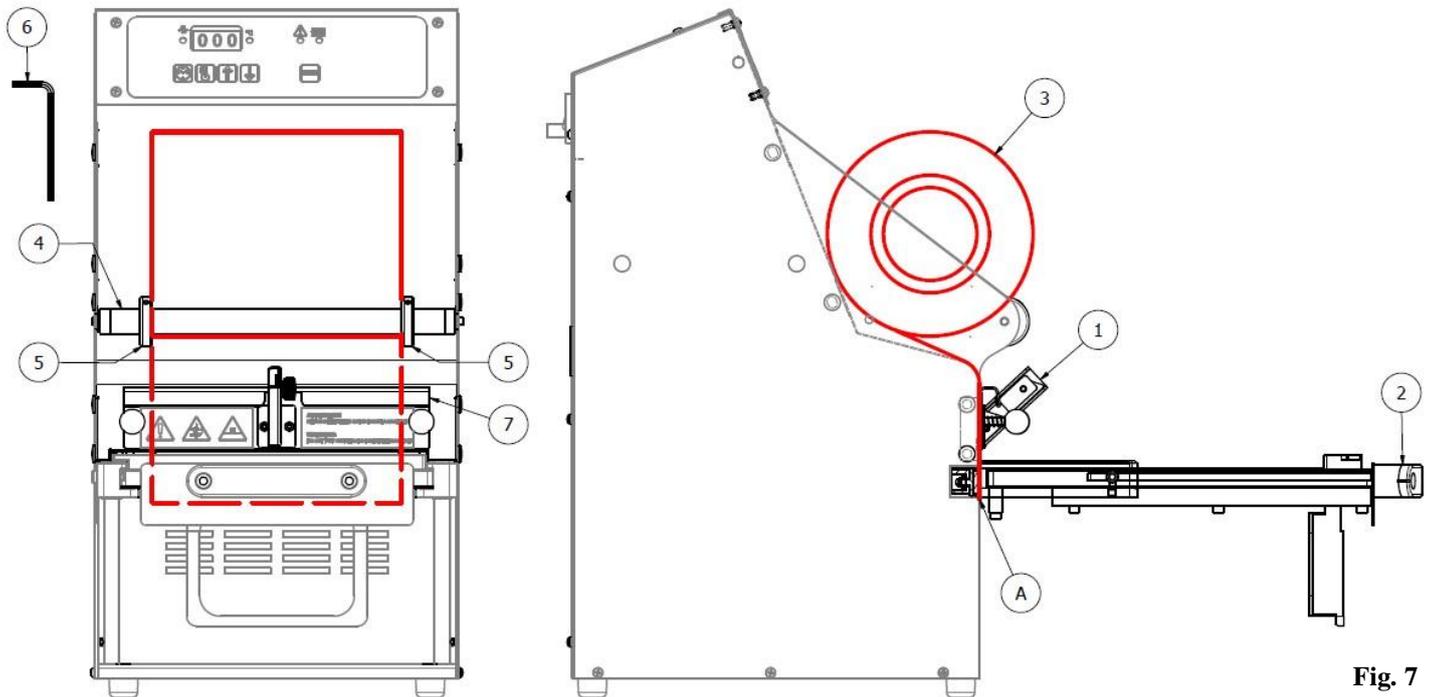
4.2. GAS CONNECTION FOR GAS FLUSHING (OPTIONAL-FEATURE see attached)

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, the cutter pulled out, (pos.1 Fig. 7) as well as the tray holder (pos.2 Fig. 7). Position the film reel (pos.3 Fig. 7) onto the roller (pos.4 Fig. 7) and centre it by means of the corresponding centering rings (pos.5 Fig. 7) (lock the rings using the 3mm hexagonal wrench (pos.6 Fig. 7)).

The film should be inserted under the film presser (pos. 7 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 has been disconnected and that the sealing plate has completely cooled down.

5. MACHINE OPERATION

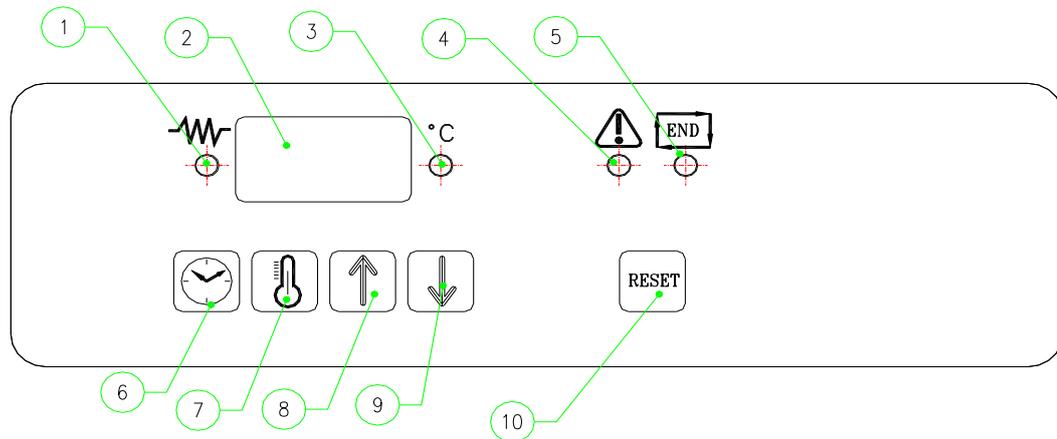


Fig. 8

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

Semi-automatic thermosealing machines 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

Semi-automatic thermosealing machines are 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!

- Thermosealing 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.

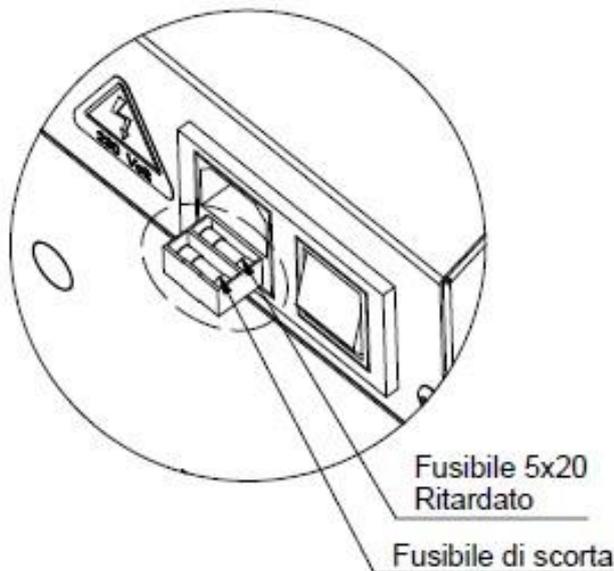


Fig. 9

6. MOULD CHANGE-OVER



WARNING!

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



WARNING!

Semi-automatic thermosealing machines are equipped with a sealing plate fitted into the mould upper part.

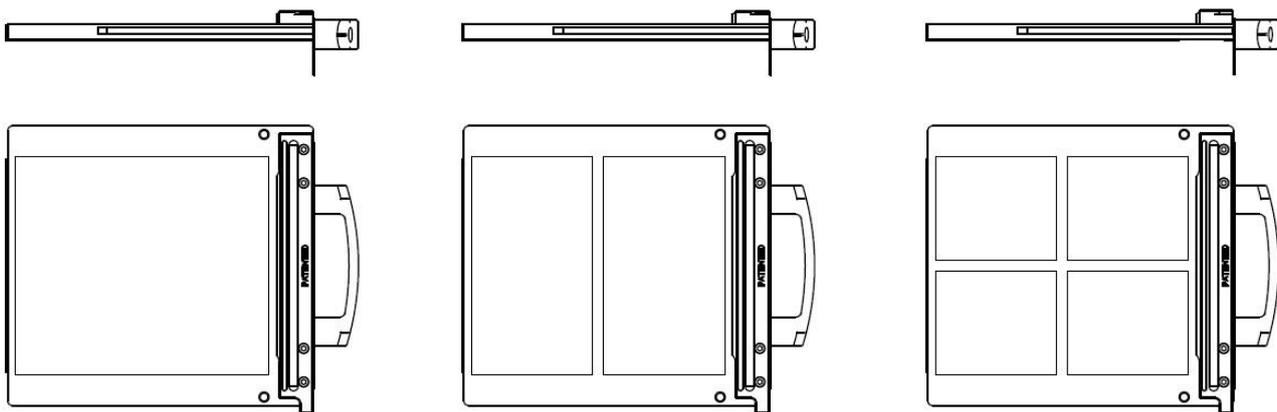
Due to the presence of heating plates and blades on the mould upper part that could damage the operator, the operations should be carried out with the utmost care.

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

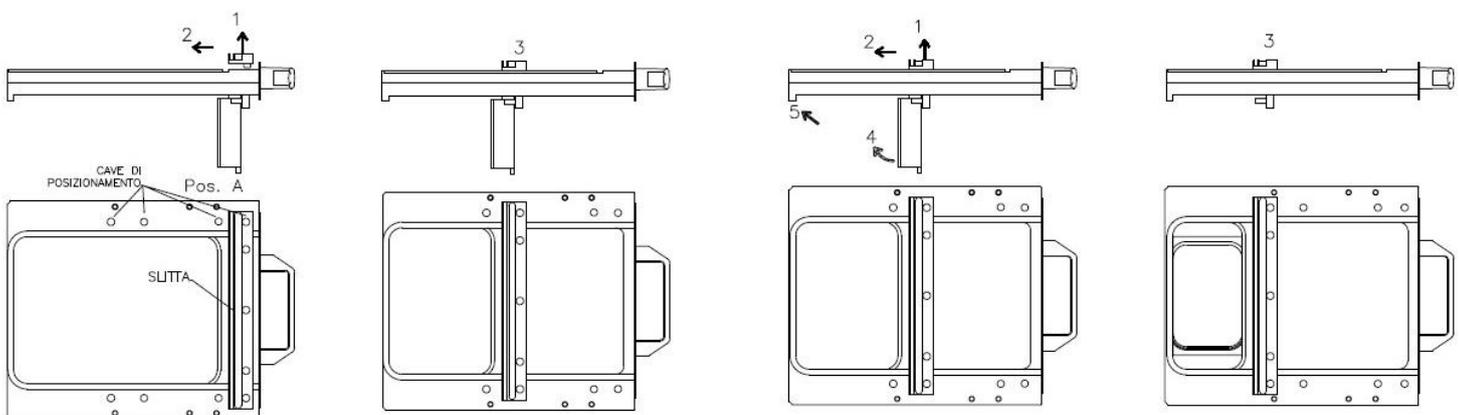
To change the LOWER MOULD, proceed as follows:

1. Place the lower holder outside (loading position).
2. Remove the machine mould by sliding it along the guides, and keeping it firmly.
3. Insert the new mould by sliding it along the guides, until it reaches the loading position.

6.1.USING THE FIXED MOULD



6.2.USING THE MODULAR MOULD



WARNING

Please follow the instructions here below for using the adjustable mould properly:

N.B make sure that the trays to be sealed are compatible with the adjustable mould supplied.

- LIFT THE SLIDE, DISENGAGING IT FROM THE POSITIONING SLOTS (1)
- MOVE THE SLIDE TO THE POSITION DESIRED (2)
- POSITION THE SLIDE, MAKING SURE THAT IT IS INSERTED INTO ITS APPROPRIATE SLOTS (3)
- REPEAT OPERATIONS 1 AND 2, TURN THE SINGLE-DOSE MOULD INSERT AND INSERT IT INTO THE LOCK (4;5)
- POSITION THE SLIDE, MAKING SURE THAT IT IS INSERTED INTO ITS APPROPRIATE SLOTS (3)

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

Semi-automatic thermosealing machines are manufactured in full compliance with current regulations, with a degree of protection making them highly resistant to external agents.

Nonetheless, they 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. Use a soft cloth dampened with detergent, avoid using solvent that can damage the machine and its synthetic materials. Clean the machine more frequently when carrying out operations in dusty environments. Before connecting the machine to the power supply, remove, sanitize the external dust and dirt accumulated during transport. It is recommended to clean also the inner parts. During this operation it is important to use soft cloths moistened with non-abrasive or corrosive detergents suitable for food use. In particular, avoid the use of gasoline, nitro diluent, perchloroethylene, trichloroethylene, etc.

**WARNING!**

NEVER USE WATER OR HIGH-PRESSURE WATER JETS

- Whenever necessary, clean the “Stainless Steel” body using dedicated products for the indicated materials

7.1.1. CLEANING THE THERMOSEALING UNIT

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

1. Remove the tray holder mould (pos.12 Fig.1 **Errore. L'origine riferimento non è stata trovata.**).
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.

To clean the **UPPER MOULD** proceed as follows:

1. Switch off the machine with the main switch and move it to the OFF position.
2. Remove the tray holder mould and the magnets' dragging device.
3. Wait until the sealing plate has cooled down before proceeding.
4. Take a damp cloth and wipe off any processing residues, paying attention to the sharp blades inside the mould.

Wear safety gloves against the risk of cuts.

7.2. UNSCHEDULED MAINTENANCE



WARNING!

The user should never dismantle any parts of the machine, with the only exception of those described in chapter 6 “Mould Change-over” of this manual. In case of need for extraordinary maintenance, contact JPack S.r.l.

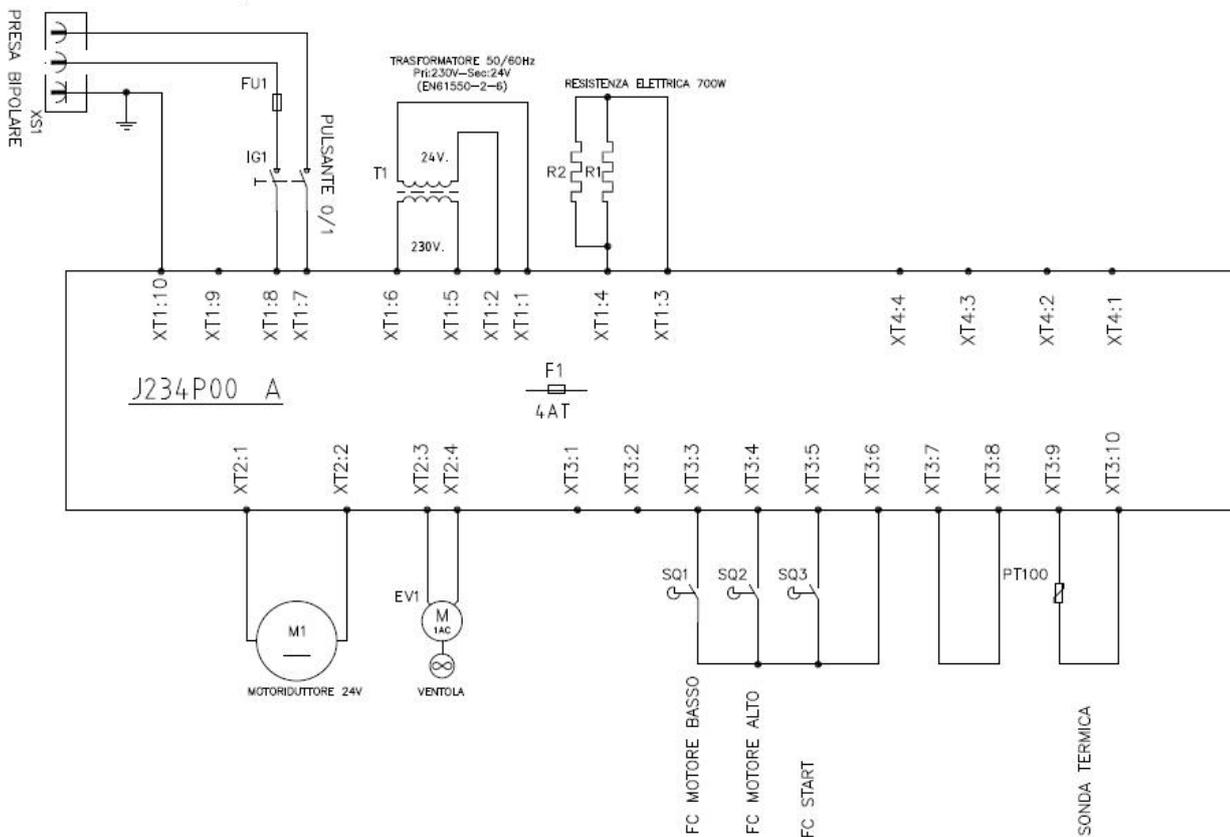
In the event of a fault, unscheduled maintenance should be carried out by a specialised technician, contacting the service department.

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.

7.3. WIRING DIAGRAM

FU1: FUSIBILE RITARDATO SU PRESA BIPOLARE:
-TSS101-102: 6.3A / TSS105: 8A



DEP00014

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 – via G. Carminati, 30 – Località Brembilla, 24012 Val Brembilla (BG) ITALY

- I.** dichiariamo sotto la nostra esclusiva responsabilità che il prodotto è conforme a quanto prescritto dalle seguenti direttive e successive modifiche:
- U.K.** declare under our exclusive responsibility that the product complies with the requirements prescribed by the following directives and their subsequent amendments:
- D.** erklären unserer ausschließlichen Verantwortung, dass das in dieser Erklärung genannte Produkt den Vorschriften der folgenden Richtlinien mit späteren Änderungen entspricht:
- F.** déclarions sous notre exclusive responsabilité que le produit est en conformité avec les prescriptions indiquées par les directives suivantes et leurs modifications successives:
- E.** declaramos bajo nuestra exclusiva responsabilidad que el producto está conforme con lo dispuesto en las siguientes directivas y sus sucesivas modificaciones:

2006/42/EC	Machinery directive
2014/35/EU	Low voltage directive
2014/30/EU	EMC directive

- 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:

EN 60204-1 : 2018
EN 61000-3-2 : 2014
EN 61000-3-3: 2016

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 10/03/2017
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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