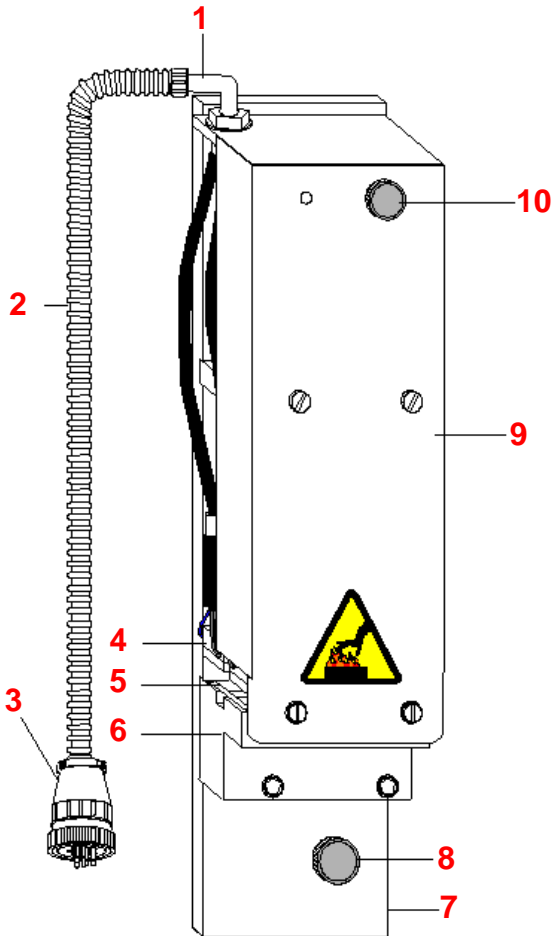


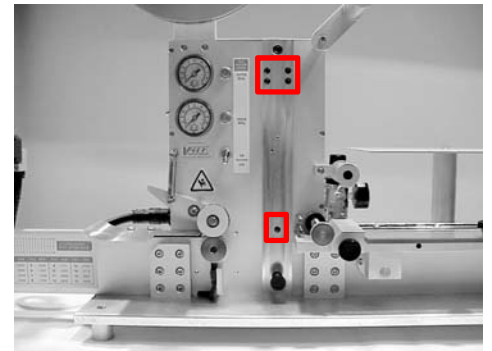
This Quick Start Guide provides operating instructions for the Heat Sealer. The intended use of the Heat Sealer is to seal parts into carrier tape. Use of this equipment in any other way is not recommended.



1. **Sealer Cord Elbow:** Used to position the sealer cord.
2. **Sealer Cord:** Connects the heat sealer to the machine. Do not pull excessively on the sealer cord or the sealer could be damaged.
3. **Sealer Connector:** Connects the Heat Sealer to the sealer receptacle on the machine.
4. **Heat Shoes:** When hot, the heat shoes seal the cover tape to the carrier tape.
5. **Anvil Covers:** Guide the tape through the sealer. Both the cover and carrier tape run underneath the two anvil covers.
6. **Anvil:** The anvil contains a groove for the cover and carrier tape to be run through. It also serves as a rest for the heat shoes.
7. **Slide Bolster:** Used to mount the heat sealer to the machine.
8. **Lower Sealer Fastener:** Used to mount the heat sealer to the machine.
9. **Sealer Cover:** Covers the sealing assembly.
10. **Upper Sealer Fastener:** Used to mount the heat sealer to the machine.

Mount Heat Sealer

1. **Check O-Rings**
Turn the power to the machine **OFF** and disconnect the incoming air supply. Inspect the (5) Sealer O-Rings on the upright plate where the sealer is to be mounted. Replace any damaged or missing O-rings.
2. **Attach Sealer**
Carefully lower the sealer into position. Do not hit the exposed corners of the loading track with the sealer or they may be damaged. Using the (2) sealer fasteners, tighten the sealer to the slide mount.

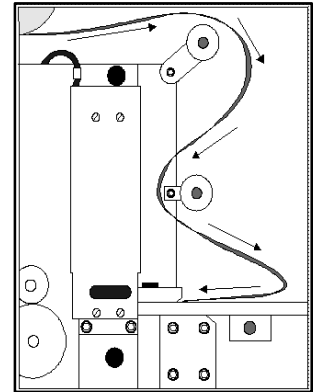


Caution: Line up the sealer connector pins with the sealer receptacle holes **before** tightening them together. If they are not lined up, serious damage could occur to the sealer.

3. **Connect Sealer**
Run the sealer connector and cord over the top of the slide mount and carefully plug the connector into the sealer receptacle on the back of the controller.
4. **Adjust Cover Tape Guide**
Remove the knurled knob from the Cover Tape Guide and pull the guide straight off. Once the sealer is in place, mount the cover tape guide, making sure its marked tape width matches that of the sealer. Replace the knurled knob when finished.

Load Tape

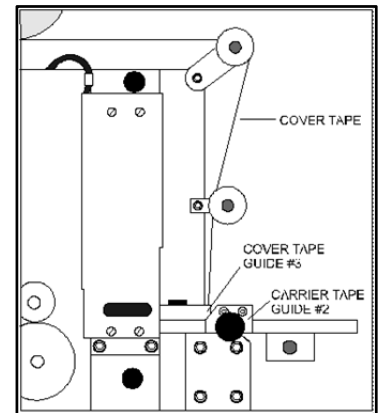
1. **Load Carrier Tape**
Guide the carrier tape under the carrier tape guide.



2. **Load Tapes in Sealer**
Pull the cover tape down through the Cover Tape Pulleys.

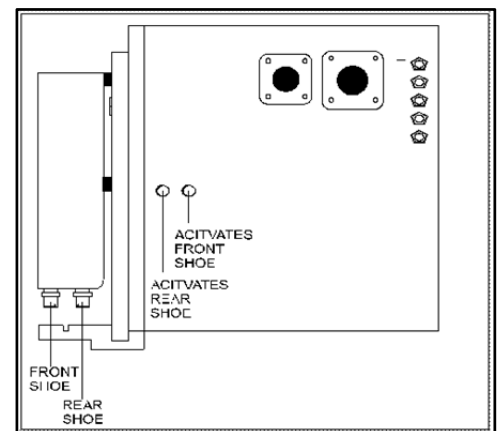
Pull about 12 inches of cover tape out and lay it over the carrier tape with the free end pointing toward the Sealer. The shiny side of the tape should be up. Allow about two inches of the free end of the cover tape to hang over the end of the carrier tape.

Push the tapes under the Cover Tape Guide and through the Sealer by pushing on the carrier tape. Keep enough slack in the cover tape so it follows the carrier tape through the Sealer.



3. **Test Seal**
Perform a manual seal test using the Manual Override Switches and a blunt object. Press the blunt object through the correct hole. Performing a manual seal makes loading the tape an easier task.

Note: The hole closest to the Sealer operates the Rear Shoe. The hole furthest from the Sealer operates the Front Shoe.



Seal Settings

CARRIER TAPE TYPE§	COVER TAPE TYPE§	TEMPERATURE IN DEGREES CELSIUS§	PRESSURE IN PSI§	DWELL TIME IN SECONDS§
3M TYPE 3000 CONDUCTIVE CARRIER§	3M TYPE 2675 STATIC DISSIPATIVE COVER§	¶ 180§	¶ 0 - 40§	¶ .40§
3M TYPE 2701/2703¶ NON-CONDUCTIVE§	3M TYPE 2675 STATIC DISSIPATIVE COVER§	¶ 140§	¶ 0 - 40§	¶ .40§
ADVANTEK¶ CONDUCTIVE§	ADVANTEK¶ TYPE AA§	¶ 150§	¶ 0 - 40§	¶ .45§
ADVANTEK¶ NON-CONDUCTIVE§	ADVANTEK¶ TYPE S§	¶ 170§	¶ 0 - 40§	¶ .45§

Note: Use this chart as a guide for setting the controls for the first time. These values may need to be altered due to variations in lot materials and customer requirements.

Seal Adjustments

The cover tape peel force is determined by three things at the time the cover tape is sealed into the carrier tape:

- Heat Shoe Temperature.** As a general rule, the temperature should be altered first when adjusting the seal properties. Start with increments of five degrees.
- Dwell Time.** The dwell time is the time the heat shoes are in contact with the tape. The dwell time should be kept as small as possible to decrease machine cycle time. Increase the dwell as an alternative to a large increase in temperature. Change the dwell time in increments of 0.05 seconds.
- Pressure Applied to Shoes.** Under normal conditions, the seal pressure should not need to be changed. It can be decreased for very small parts to minimize part movement, or increased for tapes that are extremely difficult to seal.

Detailed User's Guides, maintenance instructions and troubleshooting are available on the V-TEK, Inc. website: www.vtekusa.com.

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