

USER MANUAL

GENERAL INFORMATION

THANK YOU FOR PURCHASING OUR HAND IMPULSE SEALERS.

THIS OWNER'S MANUAL CONTAINS INFORMATION RELATING TO YOUR SEALER. THE MANUAL WILL PROVIDE YOU WITH BASIC INFORMATION CONCERNING BOTH OPERATION AND MAINTENANCE OF YOUR NEW MACHINE. PLEASE READ IT CAREFULLY AS FAILURE TO DO SO MAY RESULT IN BODILY INJURY AND/OR DAMAGE TO THE EQUIPMENT.

NO PART OF THIS MANUAL MAY BE DUPLICATED, REPRODUCED, STORED IN A RETRIEVAL SYSTEM, TRANSLATED, TRANSCRIBED, OR TRANSMITTED IN ANY FORM WITHOUT OUR EXPRESS PRIOR WRITTEN PERMISSION.

SAFETY INSTRUCTIONS



WARNING!

BELOW ARE GENERAL SAFETY PRECAUTIONS AND WARNINGS THAT SHOULD BE UNDERSTOOD PRIOR TO SETTING UP OR OPERATING YOUR EQUIPMENT.

READ AND FULLY UNDERSTAND ALL INSTRUCTIONS AND WARNINGS PRIOR TO USING THIS UNIT. YOUR SAFETY IS MOST IMPORTANT! FAILURE TO COMPLY WITH PROCEDURES MAY RESULT IN SERIOUS INJURY OR PROPERTY DAMAGE.

REMEMBER: YOUR PERSONAL SAFETY IS YOUR RESPONSIBILITY.

- Never operate or service your sealer until you have read this manual completely and understand it fully.
- Only plug the sealer into a standard 110 Volt, 60Hz wall outlet or surge protector.
- Do not use the sealer if the power cord, plug or any other parts are damaged. Do not allow the power cord to drape into your work area. Check that all parts are operating properly and perform the intended functions. Replace any worn parts before starting operation. Check for all other conditions that may affect the operation of your sealer.

- Always disconnect sealer from power source before servicing, changing accessories or cleaning the unit.
- To provide protection against the risk of electrical shock, the power connection must be properly grounded at all times.
- Do not leave the sealer unattended when in use. Disconnect the sealer from the power source before leaving the work area.
- Do not use the machine for any other purpose other than to seal thermoplastic materials. Doing so may result in damage to the machine and injury to the operator.
- Never touch the heating elements with hand while the sealer is plugged into a power source, in operation or just finished operation. Touching heated areas may cause fire and/or severe burns.
- The sealer is not water resistant or water proof. Spraying down the machine will damage machine or cause electrical shock. Do not submerge the sealer into water or liquid.
- Do not operate sealer in a corrosive or humid environment.
- Always keep the machine clean and in good working condition. Follow any maintenance procedures outlined in this manual. Make sure unit is disconnected from power source before cleaning.
- NEVER use any accessories or parts from other manufacturers. Machine should not be altered or modified using parts that are not genuine authorized parts. Doing so will VOID YOUR WARRANTY

- When replacing the heating elements, always replace the PTFE adhesive under the heating element. A worn PTFE adhesive can cause the heating element to break. The PTFE adhesive works as a barrier between the body of the sealer and the element. Never allow the element to come in direct contact with the sealer body as that will damage the timer.

**SAVE THESE INSTRUCTIONS
REFER TO THEM OFTEN AND USE THEM TO INSTRUCT OTHERS.**

INTRODUCTION

OUR HAND IMPULSE SEALERS ARE DESIGNED FOR SEALING POLYBAGS AND OTHER THERMOPLASTIC MATERIALS. THE SEALER CAN SEAL POLYETHYLENE, POLYPROPYLENE, SARAN, NYLON, STATIC SHIELDING BAGS, AND MYLAR UP TO 10MIL IN TOTAL THICKNESS.

Features

Your sealer is equipped with a wide range of standard features and capabilities.

- Impulse sealing - no warm up time needed
- Electronic timer for variable control
- Heavy duty, all metal construction
- Table top design supported with anti-slip rubber feet
- Seal width: 2mm, 2.6mm or 5mm wide flat heating element
- Option: Round heating element available for seal and cut applications
- Manufacturer spare parts kit includes: 2 heating elements, 2 PTFE covers

How Do Hand Sealers Work?

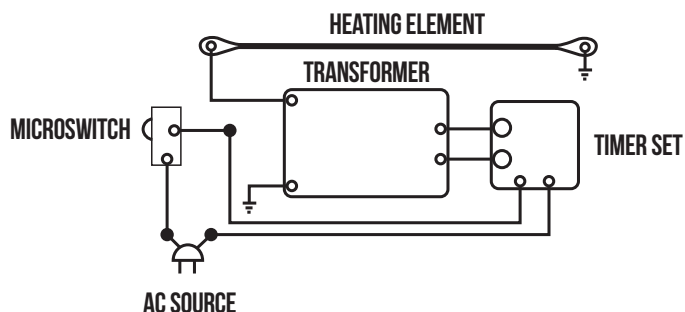
Our impulse sealers fire a short burst of electricity through a specially designed heating wire to weld thermoplastic materials together. The length of the seal time will depend on the sealing characteristics of the bag being sealed. The sealing process is simple: The operator places material on the platform of the sealer and brings the sealing arm down to seal.

Specifications

MODEL #	SEAL LENGTH	SEAL WIDTH	POWER	WEIGHT
KF-200H*	8 INCHES	2 MM	160 W	6 LBS
KF-205H	8 INCHES	5 MM	450 W	7 LBS
KF-300H*	12 INCHES	2 MM	380 W	10 LBS
KF-305H	12 INCHES	5 MM	640 W	11 LBS
KF-400H*	16 INCHES	2.6 MM	600 W	11 LBS
KF-520H*	20 INCHES	2.6 MM	730 W	13 LBS
KF-525H	20 INCHES	5 MM	900 W	15 LBS

*Denotes ETL Listed

Electrical Circuit Diagram



OPERATING YOUR SEALER

Assembly Instructions



Sealer comes assembled and ready to operate. No warm up time is required.

Operation

- ⚠ Before operating, check the heating element, PTFE cover, PTFE adhesive and the silicone rubber. The heating element should be intact.
- Insert the power cord into the correct receptacle (110V).
- Set the timer knob to the lowest setting. Always start with a low setting and increase gradually as needed.
- Place material to be sealed on the platform of the sealer and bring the sealing arm down firmly, but gently. The red light will turn off when sealing time is completed.
- When red light turns off, keep pressing the sealing arm down for an additional 2-3 seconds. For a high-quality seal, seals must cool under pressure. Thicker materials will require a longer cooling (congealing) time.

Tips for Successful Sealing

- If the seal is broken or damaged, decrease the sealing time.

- If the seal is not fully welded, increase the sealing time.
- If the sealing material sticks to the sealing pad, decrease the congealing time.
- If the width of the seal is not perfect or does not match the size of the element, increase the congealing time. When sealing/timer light turns off, keep pressing the sealing arm down for an additional 2-3 seconds. For a high quality seal, seals must cool under pressure. We usually recommend a congeal setting of at least 2x that of the heat setting but every bag will have variations. Thicker materials will require a longer cool (congealing) time.
- Always keep the sealer clean. Remove any residue found on the platform and PTFE cover. Silicone spray may be used for this purpose.
-  When replacing the heating elements, always replace the PTFE adhesive under the heating element. A worn PTFE adhesive can cause the heating element to break prematurely. The PTFE adhesive works as a barrier between the body of the sealer and the element. Never allow the element to come in direct contact with the sealer body as that will damage the timer.
- Occasionally check the condition of the silicone sponge/compression foam for wear or burns. A damaged silicone rubber will affect the quality of the seal.
-  Be sure to unplug the unit before replacing any parts.

MAINTENANCE

The following maintenance procedures should be followed to ensure the longevity of your hand sealer.

Inspection and Cleaning

Inspect your machine daily.

- Use a clean cloth to remove any plastic residue remaining on the top PTFE cloth.
- When replacing the elements, always check the condition of the bottom PTFE adhesive.
- Check the condition of the silicone rubber for wear and burns.
- A damaged silicone rubber will affect the quality of the seal.

Replacement Kit Instructions

Our hand sealers will require new heating elements and PTFE from time to time. Heating elements will break through wear and tear. A good rule of thumb is to replace the bottom PTFE adhesive every time you change your heating element. The top PTFE cover prevents the plastic or other thermoplastic material you are sealing from sticking to the heating element.

Replacement kits are available from your distributor. Kits include (2) heating elements, (2) PTFE adhesives, (2) PTFE covers. Optional round wires are available for seal and cut applications (shrink wrapping, etc).

To install your replacement kit on your sealer, turn off power and unplug sealer.

Removing Worn Parts

- Loosen the screws on the PTFE cover plate and remove the PTFE cover.
- Remove the PTFE cover to expose the heating element.
- Remove the heating element by lifting off the eyelets of the heating element from the mounting spring on both ends.
- Peel off the PTFE adhesive under the heating element.

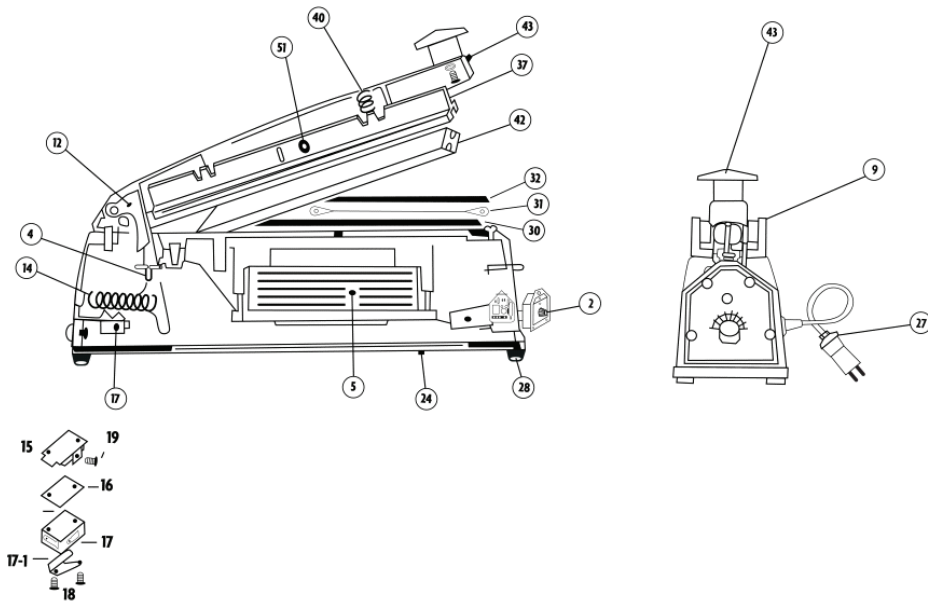
Installing New Replacement Parts

- Remove the backing of the liner on the PTFE adhesive.
- Apply it to the sealer's sealing platform. The PTFE adhesive must always extend past the sealing platform by approximately $\frac{1}{4}$ " to $\frac{1}{2}$ " on both ends. Bend down the excess on both ends. (The PTFE adhesive acts a barrier between the metal body and the heating element. Never allow the heating element to come in direct contact with the sealer's body because it will damage the timer.)

- Place a new heating element on top of the PTFE adhesive by fitting one eyelet of the heating element on one mounting spring followed by the other mounting spring. Using a screwdriver to flex the mounting spring inward will ease the placement of the element on the mounting spring. Check the element to ensure it is tight and intact.
- Place a new PTFE cover on top of the heating element.
- Tighten the screws to affix the PTFE cover plate.

PARTS DIAGRAM

100H, 200H, 300H, 400H, 520H
PARTS DIAGRAM



ITEM	PART NUMBER	DESCRIPTION
2	T-KFH	TIMER
4	MS-KFH	MOUNTING SPRING
5	TRNS	TRANSFORMER (SPECIFY MODEL)
9	KFH-9	HINGE BRACKET
12	KFH-12	MICROSWITCH LEVER / ARM OPERATING BRACKET
14	KFHC-14	MICROSWITCH LEVER SPRING
15	KFHC-15	MICROSWITCH BRACKET
16	KFHC-15	MICROSWITCH INSULATING PLATE
17	MSW-KFH	MICROSWITCH
17-1	KFHC-17-1	MICROSWITCH SPRING PLATE
18	KFHC-18	MICROSWITCH ASSEMBLED SCREW AND WASHER
19	KFHC-19	SCREW FOR MICROSWITCH
24		BOTTOM PLATE COVER (SPECIFY MODEL)
27	PWC-KF	POWER CORD
28	KFHC-28	RUBBER FOOT (SPECIFY MODEL)
30	TA-12	PTFE ADHESIVE (SPECIFY MODEL)
31	HE	HEATING ELEMENT (SPECIFY MODEL)
32	TC-12	PTFE COVER (SPECIFY MODEL)
37	8	SILICONE RUBBER HOLDER
40		SILICONE RUBBER HOLDER SPRING
42	SR	SILICONE (SPECIFY MODEL)
43	KFHC-43	HANDLE BUTTON
51		SCREW MOUNTING PIVOT

TROUBLESHOOTING

PROBLEM	POSSIBLE CAUSES	SOLUTION
NO SEALING TIMER LIGHTS OFF	1. DISCONNECT POWER CORD 2. POWER CORD IS BROKEN 3. TRANSFORMER IS BROKEN	1. CHECK OR CHANGE PLUG 2. REPLACE POWER CORD 3. REPLACE TRANSFORMER
NO SEALING TIMER LIGHTS ARE ON	1. HEATING ELEMENT IS BROKEN 2. POOR CONTACT AT HEATING TERMINAL ASSEMBLY	1. REPLACE THE HEATING ELEMENT 2. CLEAN, TIGHTEN OR CHANGE THE HEATING TERMINAL ASSEMBLY
NO SEALING POWER LIGHT ON HEATING INDICATOR OFF	1. MICROSWITCH MALFUNCTION 2. MICROSWITCH OUT OF PLACE	1. REPLACE MICROSWITCH 2. ADJUST MICROSWITCH
BURNT PTFE CLOTH	1. TIMER MALFUNCTION 2. TIMER SETTING TOO HIGH	1. REPLACE TIMER 2. DECREASE TIMER SETTING
BROKEN ELEMENT	1. WORN PTFE ADHESIVE	1. REPLACE PTFE ADHESIVE
WRINKLED SEAL	1. TIMER SET TOO HIGH 2. COOLING (CONGEAL) TIME IS TOO SHORT	1. DECREASE SEAL TIME 2. INCREASE CONGEALING TIME
IMPERFECT SEAL	1. WORN PTFE CLOTH 2. WORN SILICONE RUBBER	1. REPLACE PTFE CLOTH 2. REPLACE THE SILICONE RUBBER
BURN SEAL	1. SEAL TIME IS SET TOO HIGH	1. DECREASE SEAL TIME
NO SEAL	1. SEAL TIME SET TOO LOW	1. INCREASE SEAL TIME
SEAL STICKING TO PTFE CLOTH	1. WORN OR DIRTY PTFE CLOTH 2. WORN OR DIRTY SILICONE RUBBER	1. REPLACE OR CLEAN PTFE CLOTH 2. REPLACE OR CLEAN SILICONE RUBBER

PROBLEM	POSSIBLE CAUSES	SOLUTION
NO SEALING TIMER LIGHTS OFF	1. DISCONNECT POWER CORD 2. POWER CORD IS BROKEN 3. TRANSFORMER IS BROKEN	1. CHECK OR CHANGE PLUG 2. REPLACE POWER CORD 3. REPLACE TRANSFORMER