



## HEAT SEALER MODEL C1HS



### OPERATION AND MAINTENANCE MANUAL

*This manual is an integral part of the machine and must accompany it whenever ownership changes or whenever it is moved within the company.*

*This manual must be carefully looked after, circulated and made available to the persons interested.*



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## **CHAP. 1 – GENERAL INFORMATION**

Before using the machine, operators must be educated on the contents of this manual.

The operation and maintenance instructions in this manual must be carefully read and followed so the machine to which they refer can be used in a correct and safe manner. If the maintenance instructions contained in this manual are carefully followed, machine life will be extended and running will be extremely cost effective.

### **1.1 MANUFACTURER'S LIABILITY**

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The manufacturer, COMPAC S.r.l., cannot accept liability for problems, breakages, accidents, etc. resulting from non-awareness (or non-application) of the instructions contained in this manual. The same applies to the execution of changes, variations and/or installation of accessories not authorized in advance.

COMPAC S.r.l. especially declines all liability for damages caused by:

- Natural events
- Incorrect operation
- Lack of maintenance

The manufacturer cannot accept liability for damage (of any type) caused by jobs done on the machine (for maintenance, repairs, etc.) unless such jobs have been performed by skilled personnel with the prior authorization of COMPAC S.r.l.

### **1.2 WARRANTY CONDITIONS**

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The machine is covered by a 12 month warranty, which runs from the date of delivery of the Machine to the Customer user. The conditions necessary to qualify for the warranty varies depending on the type of service required as described below.

#### **1- Warranty for italian customers**

**1.1- Warranty at the headquarter of the Customer by Compac Srl or a service center indicated by Compac Srl on machines sold by dealers.**

In this case it is necessary that the Customer is in possession of "Certified Warranty" delivered with the machine and the transport document (Delivery Note) of the dealer that certifies the date of delivery of the machine.

**1.2- Warranty at the headquarter of Compac Srl or the service center indicated by Compac Srl on machines sold by dealers.**

In this case it must have been sent the "Validate Coupon Warranty" in the time provided on the coupon itself. In the event that has not been sent this document, Compac Srl reserves the right to verify the date of the actual effect of the terms of warranty.

**1.3- Warranty for direct Compac Srl. Customers**

The warranty is given on the date indicated on the transport document (Delivery Note) that certifies the date of delivery of the machine from Compac, and replaces in all respects the "Certificate of Warranty"

**2- Warranty for non-Italian Customers**

The warranty is provided by the retailer or dealer or a company affiliated to Compac Srl in the country of residence of the customer, and is responsible to verify independently and with autonomy the effect of terms of warranty.

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The Machine warranty only covers the free-of-charge replacement or repair on the Customer's behalf of those Machine parts which present manufacturing defects. The warranty shall, under no circumstances, cover parts subject to normal wear (trays, film) and shall not include Machine replacement.

The warranty shall not include the repair or replacement of Machine component parts which might become necessary as a result of incorrect use or bad maintenance by the Customer or its employees or any other person, or the bad operation of parts, connections or accessories and materials not supplied by COMPAC S.r.l., or of faults occurring as a result of installation and/or work on the machine performed by unauthorized persons or due to damage during transport or any other circumstances whatsoever not related to manufacturing defects.

The Customer shall be the only person responsible for selecting and using the Machine for the purpose of achieving the results desired by the Customer, as well as for the results themselves. Within the mandatory limits set down by the law, the Customer shall under no circumstances be entitled to the payment of direct or indirect damages, including missed profit involving persons or things resulting from Machine defects or Machine use, as well as to any damages claimed by third parties.

In the case of requests calling for work to be carried out on the customer's headquarter, travel costs shall be charged according to costs and rates in effect at the time of the work being performed. In the event of the Machine being repaired on the manufacturer's premises, or at an after-sales centre indicated by the manufacturer, all relating transport costs and risks shall be borne by the customer. No servicing under Warranty shall be provided to customers not up to date with payments.

### **1.3 AFTER-SALES SERVICE**

The Manufacturer shall place at the customer's disposal its after-sales service to solve any problems relating to machine operation and maintenance.

All servicing requests shall only be made after carefully analyzing the problems and their causes.

All requests must be sent to:

**COMPAC s.r.l.**

**via Spallanzani, 8/A - 42024 Castelnovo di Sotto (RE)**

**tel. +39.0522.688509 - fax. +39.0522.688552 e-mail: [info@compac.it](mailto:info@compac.it)**

When making requests, always quote the marking details that are on the plate fitted to the

**COMPAC s.r.l.**  
Via L. Spallanzani, 8/A - 42024 Castelnovo di Sotto (RE) - Italia

NAME:   
MODEL:   
REGISTER N°:   
YEAR:

**CE**

220V - 50Hz  A  kW

rear machine cover and reproduced in the illustration below.

## 1.4 TERMINOLOGY

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The terms FRONT, REAR, RIGHT, LEFT, LOWER, UPPER indicated in this publication always refer to the machine looked at from the front, as represented by the control panel.

## 1.5 USE OF MACHINE IN EXPLOSIVE ENVIRONMENTS

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**CAUTION:** *the heat sealer model C1HS has not been designed to work in environments containing possible explosive gases or vapors.*

## 1.6 DEMOLITION OF THE MACHINE (see EEC directives)

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This product complies with RAEE 2012/19/EC. The crossed bin symbol found on the apparatus indicates that the product, at the end of its useful life, should be treated separately from household waste, must be disposed in a recycling center for electrical and electronic equipment, or returned to the seller when buying a new equivalent machine. The user is responsible to bring the machine at the end of useful life in the appropriate collection point.

The separate collection of the discarded equipment for the recycling and the treatment environmentally compatible, contributes to avoiding possible negative effects on the environment and human health and promotes recycling of the materials that compose the product.

For further information regarding the collection systems available, contact the reference entities in the country where the machine is installed.

In the design of the machine recyclable materials have been chosen in order to minimize the environmental impact during the phase of disposal.

In particular, the sliding blocks of the drawer are in PET , the frame is made of stainless steel

AISI 304 or painted FE 360 (depending on the version), the sealing frame and the holder-tray

frame are made of aluminium alloy Al 6082.

All the electronic components are suitable to 2011/65/CE directive– RoHS Directive.





## **CHAP. 2 – SAFETY STANDARDS**

### **2.1 GENERAL STANDARDS**

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The person responsible for the machine shall be obliged to comply with EEC community directives and local regulations relating to work environments, for purposes of operator safety and health and to observe applicable accident-prevention laws. Before starting the machine, always carry out all preliminary inspections.

The person responsible for the machine shall be obliged to become acquainted with all installed safety devices and learn how to use these properly.

The person responsible for the machine shall appoint the operators authorized to run it and establish the relevant duties and operating restrictions.

The person responsible for the machine shall furthermore instruct the operators in relation to:

- Safety and accident-prevention regulations
- Specific regulations relating to the machines
- Position of the various controls on the machine



**CAUTION:** *the fixed guards or mobile protection devices must always remain in their housing, correctly secured and fully operative during normal machine operation.*

*If the guards are removed and the protection devices are disengaged for any reason whatsoever, these must be refitted and made operative before the machine is started again.*

### **2.2 SAFETY DEVICES INSTALLED ON MACHINE**

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The following safety devices are fitted to the machine in question. The position of these devices is shown in figures 3-2 and 3-3:

- Front area guard (representing the drawer handle).
- Cooling fan protection grid.
- Electrical system cut out fuse.



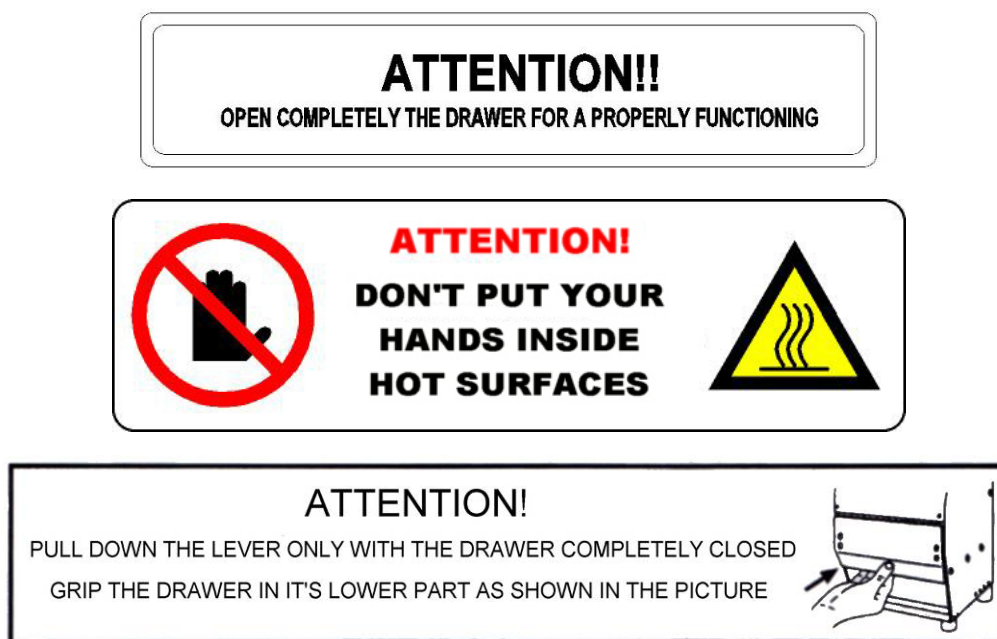
## 2.3 OUTSTANDING RISKS

Despite the safety devices mentioned in the previous paragraph, the machine features an outstanding risk:

- **Burns in correspondence of the sealing plate (figure 9.1 position 11) reached by the drawer open;**
- **Impact of parts of the body against the lever at the end of the sealing cycle**

For technical reasons, it has not been possible to eliminate this risk and consequently a warning notice has been applied to the machine and, in the section of this manual regarding the use of the machine, it is reported the danger and are explained the procedures to operate in conditions of safety.

Below are reproduced alerts that explain the proper way to grip and use of the machine drawer and highlight the risk of crushing if the drawer was challenged unfairly.



## 2.4 INTENDED AND FORBIDDEN USE

This machine is designed to heat-seal trays using film reels, both made from materials suitable for food contact, with the dimensions and shapes specified in chapter 8; the above trays must only ever contain food products.

Any other use is forbidden.

In particular, the machine must not be used for packaging powders, liquids or inflammable,

aggressive or explosive gases, nor for packaging sharp, pointed or heated objects.

## 2.5 STANDARDS FOR THE USE OF THE MACHINE

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**IMPORTANT:** *the machine must only be used and serviced by operators authorized by the person in charge of the machine and who have read this Manual.*

*Such operators must be physically and mentally fit and not under the influence of drink or drugs.*



**IMPORTANT:**

- *Do not start-up the machine if this has been stopped to perform special jobs (adjustments, maintenance, lubrication, etc.)*
- *Do not spray or throw water on the machine.*
- *Do not place tools or any other objects in the cover slots for any reason.*
- *Never use the machine with bare feet or wet hands.*

At the start of each shift, **MAKE SURE:**

- The power line, plug, main switch, the key 'ON / OFF' and the front panel that protects the buttons and the display are in good working condition; in the case of damage, do not switch the machine on and contact professional personnel to make the necessary repairs.
- During operation, the machine should not make any strange noises. If it does, stop it immediately and find the cause.
- All doors are properly closed and that protection devices are correctly fitted.
- It is recommended to keep clean the environment in which the machine is installed as dusts or greases may settle on the components and on the materials used for the packaging.

### CHAP. 3 – DESCRIPTION OF THE MACHINE

Below are some pictures of the machine with the indication of the most important features:



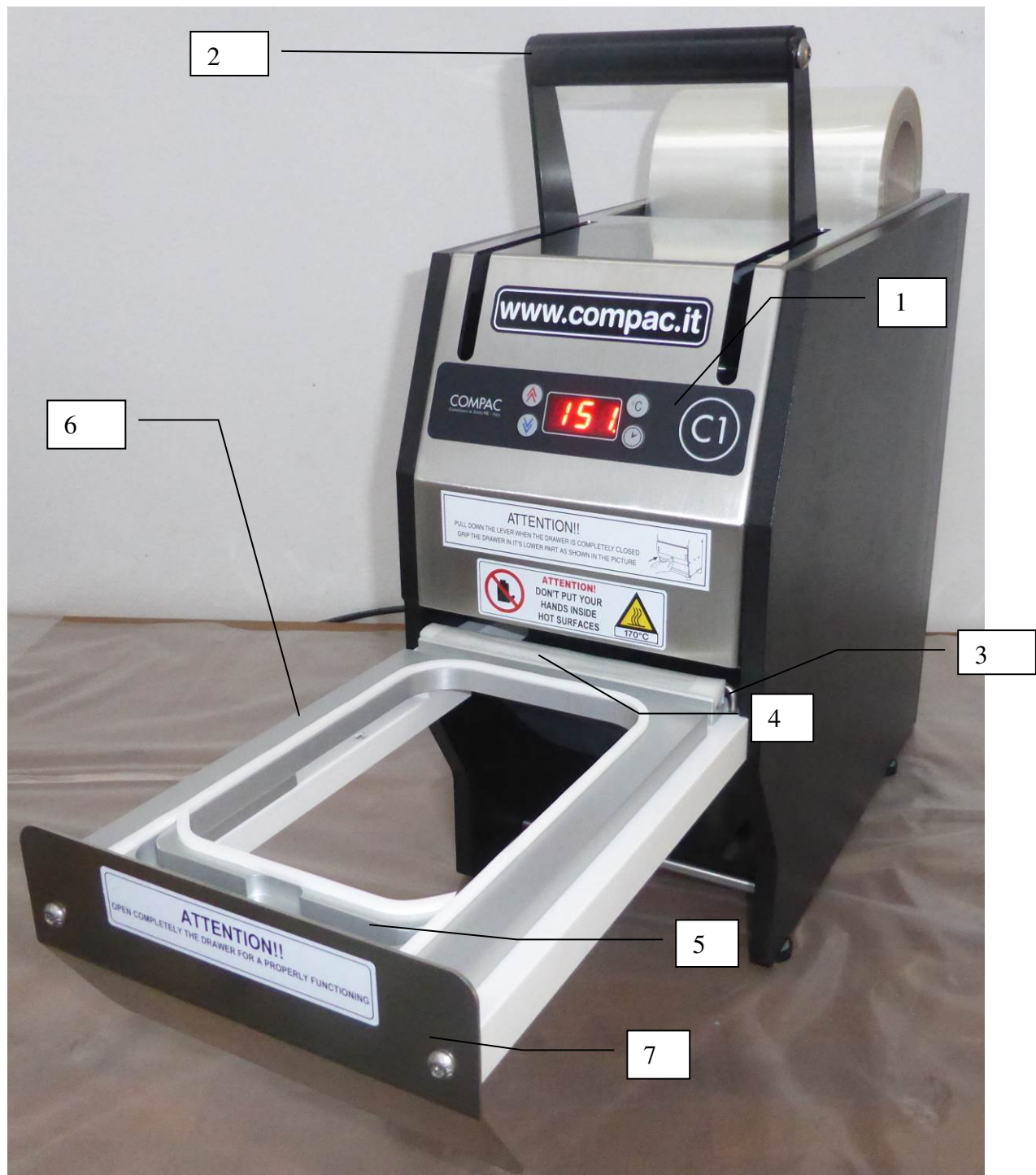
*fig. 3.1: control panel*

A: temperature setting and on / off heating

B: setting sealing time

C: values increase

D: values decrease



*Fig. 3.2: front view*

- |                                 |                                   |
|---------------------------------|-----------------------------------|
| 1- Switch panel                 | 5- Mobile selector                |
| 2- Plate control lever          | 6- Pull-out drawer                |
| 3- Film retention rod           | 7- Drawer handle/front area guard |
| 4- Film retention rubber gasket |                                   |



*Fig. 3.3: rear view*

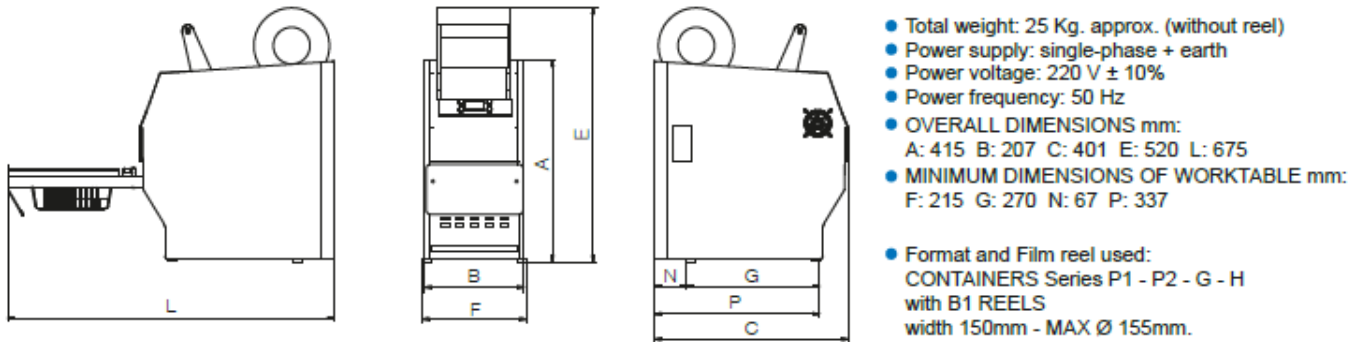
11- Fan with protection grid

12- Main switch

13- Power socket

15- Serial number – CE plate

16- Warning label

**CHAP. 4 – TECHNICAL DATA SHEET*****HEAT SEALER MODEL C1HS***

Equivalent continuous acoustic radiation pressure level in normal working conditions at 1 m is:

$L_{eq}(A) < 70 \text{ dB(A)}$

The machine is designed to work properly in an electromagnetic environment of type B according to the norm CEI EN 61439-1 (civilian environment, residential, commercial and light industry).



## **CHAP. 5 – HANDLING AND TRANSPORT**

The machine is delivered in a container (cardboard box) containing specific protection devices to prevent damaging the machine during transport.

This container can be handled manually inasmuch as its weight does not exceed 25 kg and overall dimensions are small (overall dimensions and weights are shown on the technical sheet).

The procedure to unpack the machine is as follows.

- Open the top of the cardboard box.
- Extract from the box the electric cable and the four corners of polystyrene that are located in the corners.
- Then lift the machine by grabbing the handle of the control lever plate (2 of Fig.3.2) and place it on a plane sufficiently stable and resistant to withstand the weight of the machine.



**CAUTION:** *workers for transport and positioning should wear gloves and safety shoes.*

During transport, avoid knocking or dropping the machine as this could cause damage.

If the machine is not used for long periods (over two months) store it away in covered, dry and clean premises and protect it with original or equivalent packaging.

## **CHAP. 6 - INSTALLATION AND POSITIONING**

After removing the machine from the packaging, proceed as follows:

- Make sure the machine is in good condition and, in case of doubt, do not use it and contact an authorized after-sales service.
- Place the machine in the chosen position and make sure this rests on a large enough, flat surface, able to withstand the weight of the machine as shown on the technical sheet.
- For optimum use of the machine it is recommended height of the support surface between 800 and 900 mm.
- Keep a distance of at least 5cm from any rear wall to allow proper machine cooling.

**IMPORTANT:** because the machine gives off hot air from the fan fitted at the rear, it is best to avoid such air coming into contact with refrigerated areas.

It is best to keep packaging components so these can be used again in the event of the machine having to be moved.



**CAUTION:** *do not leave packaging components within reach of children as these are a potential danger source.*

### **6.1 POWER CONNECTIONS**

The customer is responsible for providing a power supply.

The power line to which the machine is to be connected must be able to withstand maximum machine absorbed current according to the specifications indicated on the technical sheet included in this manual.



**IMPORTANT:** *the electrical system in the premises where the machine is to be installed must feature an earth lead and must conform to laws applicable in the country of installation; in all cases, a high-sensitivity residual current circuit breaker (RCCB) is best fitted.*



**IMPORTANT:** *Before inserting the plug, make sure the power voltage of the electrical system is 220V - 50Hz.*



**NOTE:** *the machine is equipped with an injection molded electric cable, is **forbidden to tamper with the cable**, otherwise Compac S.r.l. cannot accept liability for problems, breakages, accidents, etc. to things or persons resulting from cable tampering.*

To ensure correct operation of the electrical and electronic equipment, the environmental conditions in the premises where the machine is installed must be the following:

- Ambient temperature between 0 - 30°C.
- No sudden temperature changes or condensation.
- No vibrations
- Max relative humidity: by 90% at 20°C to 50% at 40°C (CEI EN 60204-1) with no condensation.
- No corrosive gases.
- No magnetic fields.
- No water, oil or other chemical substance spray.

## **CHAP. 7 – USING THE MACHINE**

### **7.1 START-UP**

(see fig. 3.1, fig. 3.2 and fig.7.1)

After making sure the main switch (12) on the back of the unit is disengaged ('OFF' position), fit the plug in the power socket, and turn the main switch (12) to 'ON':



**Fig.7.1**

The display of the machine will light up with the sign OFF showing the machine is powered. Press switch “1” (°C) on the front: display will show the plate temperature and the machine starts to warm up to reach the temperature set.

#### **7.1.1 Temperature setting.**

To display temperature setting press switch “2” (^). The display shows temperature set also pressing switch “1” (°C) but when released the display shows OFF and the machine stops heating the plate, (press switch “1” again to resume heating).

To change temperature setting press and hold down switch “1” (°C) and at the same time press switch “2” to increase set point or switch “3” to decrease. Releasing all switches new set point is memorized; (during this phase a flashing dot appears on display to indicate that the machine is in programming mode).

#### **7.1.2 Timer setting.**

The sealing cycle length is adjusted by a timer set to 3 seconds during factory test. To display this value press switch “3” (v).

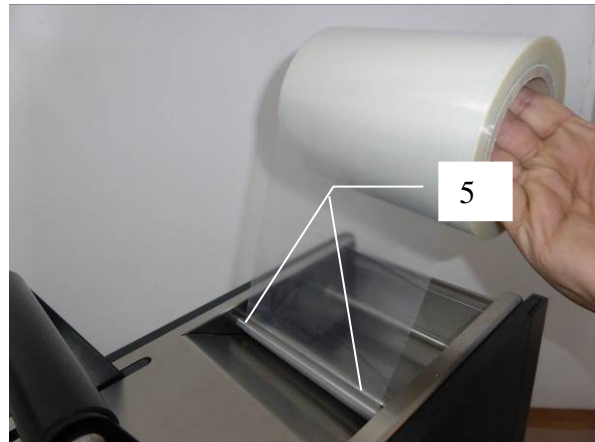
To change sealing cycle length, press and hold down switch “4” and at the same time press switch “2” to increase length or switch “3” to decrease. Increasing or decreasing take place for quarters of second (0,25sec). Releasing all switches new set point is memorized; (during this phase two flashing dots appear on display to indicate that the machine is in programming mode).

## 7.2 FITTING AND REPLACING THE FILM ROLL

- Place the film reel on the centering round (5) with the flap of the film in the front pointing downwards as shown in fig. 7.2;

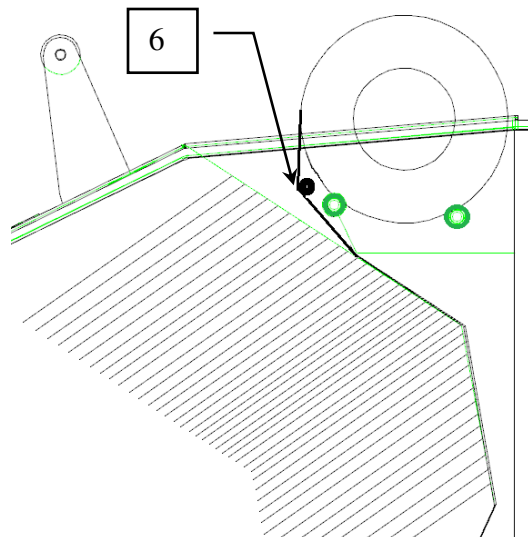


**CAUTION:** *danger of burns against the sealing plate, if the machine is hot use of heat resistant gloves.*



*Fig.7.2*

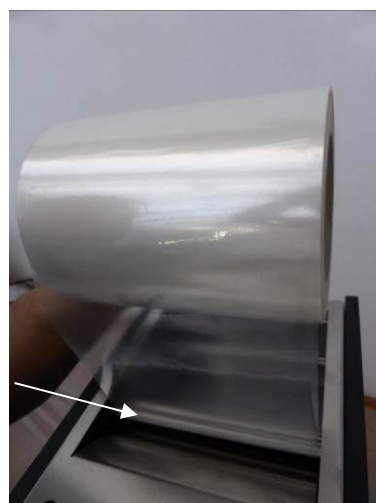
- The free edge of the film must take place from the front of the reel and is pushed inside the slot 6 present under the reel.



*fig. 7.3*

- Helping in the operation by sliding the film against the front metal sheet 7.

7



*fig. 7.4*

- Pull out the drawer and verify that the flap of the film has dropped along the back wall of the machine as shown, so that you can take it with one hand. Once taken the film, you must pass it under the rod sliding 8

*fig. 7.5*

- Raise the film retention rod (9) as shown in fig. 7.6 by pulling upwards;
- Thread the film through the space between the rod and the stop;
- Release the rod and make sure the film is well extended and pressed by the rod along its entire length.

*fig.7.6*

### 7.3 HEAT-SEALING CYCLE

After performing the above operations, it is possible to pass on to the heat sealing of trays, proceeding as follows:

- - Check that the temperature shown on the display is suitable for the material to be used (see chap.8); if you have to change the temperature set follow the indications of paragraph 7.1 and wait a few minutes to leave the machine reach the new temperature.

*fig.7.7*

- Pull out the drawer *as far as it will go*\*;
- Select the desired size by moving the mobile drawer selector (5 of fig.3.2);
- Grip the film with both hands and pull it towards you until the tray to be closed is completely covered. (fig. 7.7);
- In machines equipped with a film stop device, the film must be pulled up to the "AF" film stopper (fig. 7.7). Press the flap down until you hear the locking click. In this way it is possible to avoid that some types of films that tend to roll up due to "curling" or heat can move when sealing.
- Push the drawer as far as it will go, gripping it properly as shown in figure 7.8;

*fig.7.8*

- Lower the plate control lever (10) to the end of its stroke (fig.7.9) leaving free to permit automatic timed elevation, which will occur within a few seconds (after sealing);
- Pull out the drawer;
- Remove the tray from its housing by pushing slightly from below.

*fig.7.9*

**\*NOTE:** *if the drawer is not completely pull out it may happen that during the next extraction of the drawer the film slip off from film retention rod.*



**IMPORTANT:** *only lower the plate control lever if the drawer has been fully pushed in. In this position, the drawer handle represents a safety protection and prevents your fingers from going underneath the plate; this also prevents damaging the machine.*



**CAUTION:** *never put your fingers inside the machine when this is running. Risk of burns!*



**CAUTION:** *keep your face away from the machine while this is sealing; lever recovery at the end of cycle is very fast.*

## **CHAP. 8 – PACKAGING MATERIALS**

### **8.1 TRAYS, VESSELS AND REELS – REQUEST THE TECHNICAL DATA SHEETS**

The machine can use all trays from the series indicated in the following table, produced and sold by Compac srl:

SERIES	EXTERNAL DIMENSIONS mm	Max. Height mm
P1	137 x 95	63
P2	136 x 120	82
G	190 x 136	85
H	208 x 136	75

The indicated trays and vessels from the Series are present in the following types of materials:

PP – CA+PET – APET – CPET - PLA - CA+PLA – CELLULOSE PULP —ALc / ALbn  
(Smooth Wall Aluminium)

The Term "Series" is a family of trays with the same external dimensions (indicated in the "External dimensions" column) but with greater depth (up to a maximum indicated in the "Max Height").

### **8.2 SEALING TEMPERATURES**

The following tables indicate the types of reel film, the possible combinations between film and trays and corresponding sealing temperatures:

#### **IN COMBINATION WITH P1 – P2 – G - H SERIES TRAYS AND VESSELS**

Item	Band mm	Max. External Diameter mm
B1	150	155

	WIDTH				CONTAINERS / TEMPERATURE °C - Sealing time 2,75 sec.							
	B1	B2	meters		PP	CA+PET	APET	CPET	ALbn	ALc	PLA	CA+PLA
<b>FILM CATEGORY</b>												
T	x	x	300	sealing	150							
TNAF	x	x	300	sealing	150							
TMF	x	x	200	sealing	150							
TSB	x	x	250	sealing		150/155	150/155	150/155				
TSBAF	x	x	250	sealing		150/155	150/155	150/155				
TSBMF		x	250	sealing		150/155	150/155	150/155				
TSPBAF	x	x	250	sealing / peelable		150/155	150/155	150/155				
TPBHAF	x	x	250	peelable		150/155	150/155	150/155				
TA	x	x	200	sealing	160/170				160/170			
TAAF	x	x	200	sealing	160/170				160/170			
TPU (UN)	x	x	200	peelable	135/145	135/145	135/145	135/145	145/155	145/155		
TPUMAF (UN)	x	x	200	peelable	145/155	145/155	145/155	145/155	145/155	145/155		
TBFN (BioCom)	x	x	200	sealing							85/90	105/115
TADFN (BioCom)	x	x	200	peelable							85/115	115/145
TADFN (BioCom)	x	x	200	sealing					145/155			

Technological suitability: the product must always be verified by the user as regards the technological suitability referring to the production process, the packaging environment and the food to be packaged.

The machine can use:

### **POLYPROPYLENE (PP) TRAYS / VESSELS**

SERIES	ITEM	EXTERNAL DIMENSIONS mm	CAPACITY ml
<b>TRAYS</b>			
<b>P1</b>	<b>APR30T</b>	<b>137 x 95 x 30</b>	<b>250</b>
	<b>APR45T</b>	<b>137 x 95 x 45</b>	<b>400</b>
	<b>APR63T</b>	<b>137 x 95 x 63</b>	<b>500</b>
<b>P2</b>	<b>APN45T</b>	<b>137 x 120 x 45</b>	<b>500</b>
	<b>APN65T</b>	<b>137 x 120 x 65</b>	<b>700</b>
	<b>APN82T</b>	<b>137 x 120 x 82</b>	<b>900</b>
<b>G</b>	<b>AG38T</b>	<b>190 x 137 x 38</b>	<b>750</b>
	<b>AG50T</b>	<b>190 x 137 x 50</b>	<b>1.000</b>
	<b>AG70T</b>	<b>190 x 137 x 70</b>	<b>1.250</b>
	<b>AG85T</b>	<b>190 x 137 x 85</b>	<b>1.500</b>
<b>VESSELS</b>			
<b>G</b>	<b>AG25T</b>	<b>190 x 137 x 25</b>	<b>/</b>

#### **Technical properties of the containers:**

- High elasticity which make them safe from breakage during handling and transport;
- Strong seal and leak-proof;
- Excellent resistance to aggressive chemical agents, to organic and inorganic substances (including oil, fat, etc...) and an excellent physiological behaviour (odourless, flavourless);
- Suitable for heating in the microwave at +110°C;
- Suitable for storage in the refrigerator but we advise to avoid the freezer for risk of breakage during impacts or handling.



**CARDBOARD (CA+PET) TRAYS / VESSELS**

SERIES	ITEM	EXTERNAL DIMENSIONS mm	CAPACITY ml
<b>TRAYS</b>			
<b>P2</b>	<b>V45PC</b>	<b>137 x 122 x 45</b>	<b>500</b>
<b>G</b>	<b>V33GC</b>	<b>190 x 140 x 33</b>	<b>500</b>
	<b>VR45GC</b>	<b>190 x 140 x 45</b>	<b>750</b>
	<b>V75GC</b>	<b>190 x 140 x 75</b>	<b>1.250</b>
<b>H</b>	<b>V45HC</b>	<b>210 x 140 x 45</b>	<b>950</b>

**Technical properties of the containers:**

- good mechanical properties (abrasion resistance, flexural strength, etc ... );
- high elasticity which make them safe from breakage during handling and transport;
- excellent resistance to aggressive chemical agents, to organic and inorganic substances (including oil, fat, etc...) and an excellent physiological behaviour (odourless, flavourless);
- suitable for reheating in microwave ovens or traditional ovens up to +200° C for 60 minutes;
- suitable for frozen food down to a minimum temperature of -40° C.

**TRANSPARENT POLYETHYLENE TEREPHTHALATE AMORPHOUS (APET)****TRAYS / VESSELS**

SERIES	ITEM	EXTERNAL DIMENSIONS mm	CAPACITY ml
<b>TRAYS</b>			
<b>P1</b>	<b>GB30PT</b>	<b>137 x 95 x 30</b>	<b>250</b>
	<b>GB45PT</b>	<b>137 x 95 x 45</b>	<b>400</b>
	<b>GB63PT</b>	<b>137 x 95 x 63</b>	<b>500</b>
<b>P2</b>	<b>GB45PNT</b>	<b>137 x 120 x 45</b>	<b>500</b>
	<b>GB65PNT</b>	<b>137 x 120 x 65</b>	<b>700</b>
	<b>GB82PNT</b>	<b>137 x 120 x 82</b>	<b>900</b>
<b>G</b>	<b>GB38GT</b>	<b>190 x 137 x 38</b>	<b>750</b>
	<b>GB50GT</b>	<b>190 x 137 x 50</b>	<b>1.000</b>
	<b>GB70GT</b>	<b>190 x 137 x 70</b>	<b>1.250</b>
	<b>GB85GT</b>	<b>190 x 137 x 85</b>	<b>1.500</b>
<b>VESSELS</b>			
<b>G</b>	<b>GB25GT</b>	<b>190 x 137 x 25</b>	<b>/</b>

**Technical properties of the containers:**

- excellent clarity;
- high elasticity which make them safe from breakage during handling and transport;
- excellent resistance to aggressive chemical agents, to organic and inorganic substances (including oil, fat, etc...) and an excellent physiological behaviour (odourless, flavourless);
- high barrier to food grade gases;
- suitable for frozen food down to a minimum temperature of -40° C.

**WHITE / BLACK POLYETHYLENE TEREPHTHALATE CRYSTALLIZED (CPET)**  
**TRAYS / VESSELS**

<b>SERIES</b>	<b>ITEM</b>	<b>EXTERNAL DIMENSIONS mm</b>	<b>CAPACITY ml</b>
<b>WHITE TRAYS</b>			
<b>P2</b>	<b>D45PB</b>	<b>137 x 120 x 45</b>	<b>500</b>
<b>G</b>	<b>D38GB</b>	<b>190 x 136 x 38</b>	<b>750</b>
	<b>D50GB</b>	<b>190 x 136 x 50</b>	<b>1.000</b>
	<b>D70GB</b>	<b>190 x 136 x 70</b>	<b>1.500</b>
<b>BLACK TRAYS</b>			
<b>P2</b>	<b>D45PN</b>	<b>137 x 120 x 45</b>	<b>500</b>
	<b>D65PN</b>	<b>137 x 120 x 65</b>	<b>750</b>
<b>G</b>	<b>D38GN</b>	<b>190 x 136 x 38</b>	<b>750</b>
	<b>D50GN</b>	<b>190 x 136 x 50</b>	<b>1.000</b>
	<b>DTG0GN</b>	<b>190 x 136 x 50</b>	<b>400 / 400</b>
	<b>D70GN</b>	<b>190 x 136 x 70</b>	<b>1.500</b>

**Technical properties of the containers:**

- suitable for hot-filling or pasteurisation;
- excellent resistance to aggressive chemical agents, to organic and inorganic substances (including oil, fat, etc...) and an excellent physiological behaviour (odourless, flavourless);
- high elasticity which make them safe from breakage during handling and transport;
- high barrier to food grade gases;
- suitable for reheating in microwave ovens or traditional ovens up to +180° C for 30minutes;
- suitable for frozen food down to a minimum temperature of -40° C.
- can go straight away from freezer to oven.

**SMOOTH WALL ALUMINIUM (ALc) TRAYS**

<b>SERIES</b>	<b>ITEM</b>	<b>EXTERNAL DIMENSIONS mm</b>	<b>CAPACITY ml</b>
<b>TRAYS</b>			
<b>P2</b>	<b>VA45Pc</b>	<b>142 x 126 x 45</b>	<b>500</b>
<b>G</b>	<b>VA45Gc</b>	<b>196 x 142 x 45</b>	<b>750</b>
<b>H</b>	<b>VA45Hc</b>	<b>214 x 142 x 45</b>	<b>1.000</b>
	<b>VA75Hc</b>	<b>214 x 142 x 75</b>	<b>1.250</b>

**Technical properties of the containers:**

- suitable for pasteurisation and sterilization;
- excellent resistance to aggressive chemical agents, to organic and inorganic substances (including oil, fat, high salt or acid content etc...) and an excellent physiological behaviour (odourless, flavourless);
- providing the best possible barrier to gas for food with a long shelf life;
- ideal for ready to cook products and for reheating in microwave oven and traditional oven up to +200° C for 60 minutes;

- a sealable roasting pan: suitable for cooking food at a maximum temperature of 200°C for 60 minutes, the container can be sealed straight after;
- suitable for frozen food;
- our ALc containers can go directly from the freezer to the oven.

### **SMOOTH WALL ALUMINIUM (ALbn) TRAYS**

<b>SERIES</b>	<b>ITEM</b>	<b>EXTERNAL DIMENSIONS mm</b>	<b>CAPACITY ml</b>
<b>TRAYS</b>			
<b>P2</b>	<b>VA45Pabn</b>	<b>142 x 126 x 45</b>	<b>500</b>
<b>G</b>	<b>VA45Gabn</b>	<b>196 x 142 x 45</b>	<b>750</b>
<b>H</b>	<b>VA45Habn</b>	<b>214 x 142 x 45</b>	<b>1.000</b>
	<b>VA75Habn</b>	<b>214 x 142 x 75</b>	<b>1.250</b>

#### **Technical properties of the containers:**

- suitable for pasteurisation and sterilization;
- excellent resistance to aggressive chemical agents, to organic and inorganic substances (including oil, fat, high salt or acid content etc...) and an excellent physiological behaviour (odourless, flavourless);
- providing the best possible barrier to gas for food with a long shelf life;
- ideal for ready to cook products and for reheating in microwave oven and traditional oven up to +200° C for 40 minutes;
- a sealable roasting pan: suitable for cooking food at a maximum temperature of 200°C for 40 minutes, the container can be sealed straight after;
- suitable for frozen food;
- our ALc containers can go directly from the freezer to the oven.

There are **reels of film** available for closing the packages with the following characteristics:

#### **Transparent Film Reels (neutral / printed)**

Made of different types of materials, cut into reels of different bundles and lengths and with various characteristics (Mono and Coupled, Antifog, Microperforated, Peeling off, Sealing, Sealing-Peeling off). They are suitable for packaging food products combined with the related trays and vessels. The composition, high mechanical resistance and seals guarantee the declared features.

In particular COMPAC, using film and tray properties, offers concrete advantages that satisfy the various consumer needs.

**Microperforated film (MF)**

They are ideal for packaging fried foods, allowing vapour to exit the package while keeping product fragrance, and also ideal for packaging fruit and vegetables, allowing fermentation gasses to exit while avoiding package swelling.

**Antifog film (AF)**

This treatment makes it possible to see the product inside the package, avoiding the unattractive "fog" effect of scattered drips. The antifog effect is particularly appreciated for the presentation and image of the content. It is used in particular on cardboard and APET trays for presenting food in refrigerator sections.

**Multilayer film**

The multi-layer materials are produced, essentially with the purpose of combining the different properties of the individual materials.

**Peeling off film**

The advantage to the final user is its easy package opening ("easy open").

**BIO-DEGRADABLE AND COMPOSTABLE****TRANSPARENT POLYLACTIC ACID (PLA) TRAYS / VESSELS**

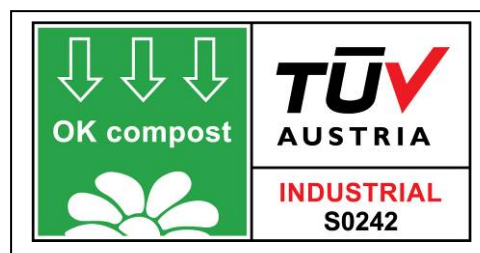
SERIES	ITEM	EXTERNAL DIMENSIONS mm	CAPACITY ml
<b>TRAYS</b>			
<b>P1</b>	<b>GD30PT</b>	<b>137 x 95 x 30</b>	<b>200</b>
	<b>GD45PT</b>	<b>137 x 95 x 45</b>	<b>300</b>
	<b>GD63PT</b>	<b>137 x 95 x 63</b>	<b>600</b>
<b>P2</b>	<b>GD45PNT</b>	<b>137 x 120 x 45</b>	<b>500</b>
	<b>GD65PNT</b>	<b>137 x 120 x 65</b>	<b>700</b>
	<b>GD82PNT</b>	<b>137 x 120 x 82</b>	<b>900</b>
<b>G</b>	<b>GD38GT</b>	<b>190 x 137 x 38</b>	<b>750</b>
	<b>GD50GT</b>	<b>190 x 137 x 50</b>	<b>1.000</b>
	<b>GD70GT</b>	<b>190 x 137 x 70</b>	<b>1.500</b>
	<b>GD85GT</b>	<b>190 x 137 x 85</b>	<b>1.750</b>
	<b>GD85MT</b>	<b>260 x 190 x 85</b>	<b>3.000</b>
<b>VESSELS</b>			
<b>G</b>	<b>GD25GT</b>	<b>190 x 137 x 25</b>	<b>/</b>

Technical properties of the containers:

- excellent clarity;

- excellent resistance to aggressive chemical agents, to organic and inorganic substances (including oil, fat, etc...) and an excellent physiological behaviour (odourless, flavourless);
- high elasticity which make them safe from breakage during handling and transport.

The containers in PLA, BIODEGRADABLE and COMPOSTABLE, are complying with the certification standards from TÜV AUSTRIA in reference to the European norm UNI EN13432.



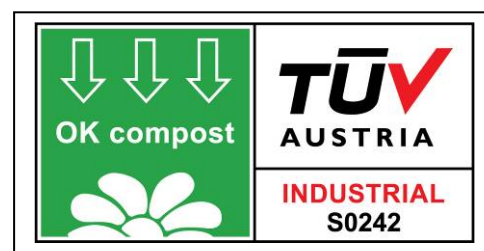
### **TRAYS IN CARDBOARD + PLA (CA+PLA)**

SERIES	ITEM	EXTERNAL DIMENSIONS mm	CAPACITY ml
<b>TRAYS</b>			
<b>P2</b>	<b>V45PCD</b>	<b>137 x 122 x 45</b>	<b>500</b>
<b>G</b>	<b>V45GCD</b>	<b>190 x 140 x 45</b>	<b>750</b>
<b>H</b>	<b>V45HCD</b>	<b>210 x 140 x 45</b>	<b>950</b>

#### **Technical properties of the containers:**

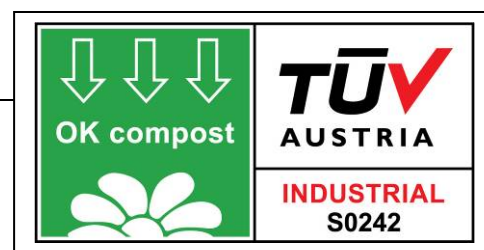
- high elasticity which make them safe from breakage during handling and transport;
- excellent resistance to aggressive chemical agents, to organic and inorganic substances (including oil, fat, etc...) and an excellent physiological behaviour (odourless, flavourless);
- suitable for reheating in microwave ovens or traditional ovens up to +200° C for 30 minutes;
- suitable for frozen food down to a minimum temperature of -40° C.

The containers in CA+PLA, BIODEGRADABLE and COMPOSTABLE, are complying with the certification standards from TÜV AUSTRIA in reference to the European norm UNI EN13432.



### **Transparent Film Reels (neutral / printed)**

Made in PLA and Compostable Material, cut in reels of different bundles and lengths, have various characteristics (Mono, Sealing). They are suitable for packaging food products combined with the related trays and vessels. The composition, high mechanical resistance and seals guarantee the declared features. In particular, both sides can be sealed.



The film reels, BIODEGRADABLE and COMPOSTABLE, are complying with the certification standards from TÜV AUSTRIA in reference to the European norm UNI EN13432.

### **TRAYS IN CARDBOARD + PURE CELLULOSE PULP (PULP)**

<b>SERIES</b>	<b>ITEM</b>	<b>EXTERNAL DIMENSIONS mm</b>	<b>CAPACITY ml</b>
<b>TRAYS</b>			
<b>P2</b>	<b>VP45PU</b>	<b>140 x 124 x 45</b>	<b>500</b>
<b>G</b>	<b>VP45GU</b>	<b>194 x 140 x 45</b>	<b>750</b>
<b>H</b>	<b>VP45HU</b>	<b>212 x 140 x 45</b>	<b>1.500</b>

#### **Technical properties of the containers:**

- of High Quality, our containers have a good rigidity and compressive strength which make them safe from breakage during handling and transport;
- excellent resistance to aggressive chemical agents, to organic and inorganic substances (including oil, fat, etc...) and an excellent physiological behaviour (odourless, flavourless);
- suitable for reheating food in microwave oven up to 800 Watt for 3 minutes, and in traditional oven up to +175 °C for 30 minutes;
- suitable to pack frozen food down to a minimum temperature of -25 °C;
- our containers are able to go directly from the freezer to the oven.

## **CHAP. 9 - MAINTENANCE**

### **9.1 GENERAL INFORMATION**

To achieve best machine operation, regular maintenance must be performed.

**All maintenance operations must be performed when the machine is cold with the main switch disengaged and the power cable disconnected.**

If the metal covers have to be taken off the machine, first of all turn off the main switch and disconnect the power cable.

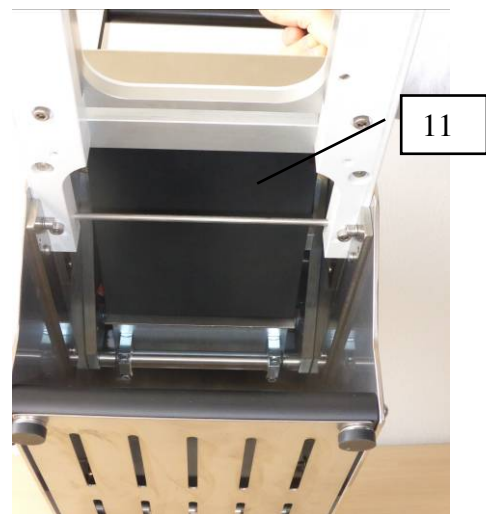
Maintenance operations must only be performed by expert, professional and authorized staff.

Protect the control panel and other electrical parts from coming into contact with water, oils or other chemical substances and avoid these penetrating inside the machine: **danger of short circuits.**

If detergents are used, keep to the manufacturer's instructions.

### **9.2 ROUTINE MAINTENANCE**

- Periodically (whenever necessary) clean the outside of the machine with a damp cloth which is not frayed; dampen this in a solution of water and neutral detergent and wring it before wiping down the machine.
- Make sure daily that the rear hot-air extraction fan is not blocked or jammed by foreign bodies.
- Make sure weekly that there are no deposits on the lower surface of the sealing plate (11). In the event of deposits, proceed as follows:



*fig.9.1*

- 1) Remove the film roll
- 2) Completely loosen the two screws 12 in figure 9.2 using a 4 mm Allen wrench and remove them.
- 3) Completely pull out the drawer and grip this tightly with both hands to prevent it falling after it comes off the guides.



*fig.9.2*

- 4) Clean the underside of the sealing plate with a cloth which is not frayed, dampened in a solution of water and washing-up liquid.
- 5) Clean the moving parts of the drawer, the film retention area and the drawer guides with a cloth which is not frayed, dampened in washing-up liquid.

To reset machine operation repeat the operations in the reverse sequence from 3 to 1.



**IMPORTANT:**

*Don't use metal scrapers or similar objects to clean the plate because they could damage Teflon coating of the plate.*

*Don't drip water inside the machine because it could cause short circuits on electronic cards.*

### 9.3 OPERATING PROBLEMS

The C1 heat sealer is a very simple and sturdy unit and operating faults are unlikely to arise as long as the instructions in this manual are followed; in any case, the following is a brief troubleshooting guide; in case of difficulty we suggest you contact the after-sales service.

a) **PROBLEM:** the machine fails to start when the main switch (12) is engaged

CAUSE 1: power cable badly connected

CAUSE 2: mains fuse burnt out

REMEDY 1: make sure the leads of the power cable are connected properly



REMEDY 2: replace the fuse (14) with another with identical amperes

b) PROBLEM: film sealing is not uniform

CAUSE 1: sealing plate dirty or covered with deposits

CAUSE 2: rubber gasket of the drawer damaged.

CAUSE 3: plate temperature not suitable with film or tray used.

REMEDY 1: clean the plate as indicated in the “MAINTENANCE” chapter

REMEDY 2: change damaged gasket

REMEDY 3: adjust temperature following the procedure decrypted in par.7.1.

c) PROBLEM: film cutting is uneven

CAUSE 1: film retention gasket (4) dirty or damaged

CAUSE 2: rubber profile crashes movie (4) dirty or damaged

CAUSE 3: cutting blade damaged

REMEDY 1: check the film retention gasket; if it is dirty, clean it; if it is damaged replace it.

REMEDY 2: check the rubber profile, if dirty clean it, if damaged replace it.

REMEDY 3: remove the drawer as indicated in the maintenance chapter and make sure, by observing from below, that the teeth of the blade are not bent or broken. If they are, call the after-sales service (to see the teeth of the blade is necessary to pull down the plate control lever).

d) PROBLEM: the display show the sign “Er1”

CAUSE: problem of an electronic nature

REMEDY: switch off the machine and contact the after-sales service.