

Salvadora  
Pedal

**PFS SERIES**

**PEDAL IMPULSE SEALER**  
**DIRECT HEAT**

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**OPERATION INSTRUCTIONS**

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## 1.USAGE AND CHARATER

There are two kinds of pedal sealers: impulse sealer and direct heatsealer, Impulse sealer is suitable for sealing polyvinyl chloride, polyethylene bags. Direct heat sealer is suitable for sealing cellophane, aluminium foil. Copper foil, tin foil and polystyrene compound bags and heat prints the production date and expiration date in the seal. The temperature is electronically controlled and is easy to be adjusted. The temperature is stably controlled. The machines are used in the area of food. medicine, daily cosmetics, local specialties, aquatic products, seeds, chemical products, garments etc. They are the best sealers for factories, stores and other areas.

## 2. MAIN DATA AND SPECIFRICATIONS

TYPE	IMPULSE SEALER			DIRECT HEAT SEALER		
MODEL	PFS-350	PFS-450	PFS-650	PFS-300DD	PFS-300DS	PFS-400DD
LENGTH(mm)	350	450	650	300	300	400
WIDTH(mm)	2~5	2~5	2~5	11	11	11
VOLTAGE	SINGLE PHASE 220 OR 110V/50~60Hz					
SEALING TIME	0~2.5	0~2.5	0~2.5	/	/	/
IMPULSE	1000	1250	1500	175~2	300	300
POWER(W)						
RANGE OF THE TEMP(°C)	/	/	/	0~200°C	0~300°C	0~300°C
DIMENSIONS(mm)	450 × 510 × 880	550 × 520 × 880	700 × 570 × 880	345 × 485 × 880	345 × 485 × 880	445 × 485 × 880
Wt.(kg)	19	21	24.5	14	13.5	16

## 3.ADJUSTMENT AND USAGE

### 3.1 ADJUSTMENT AND USAGE OF IMPULSE SEALER

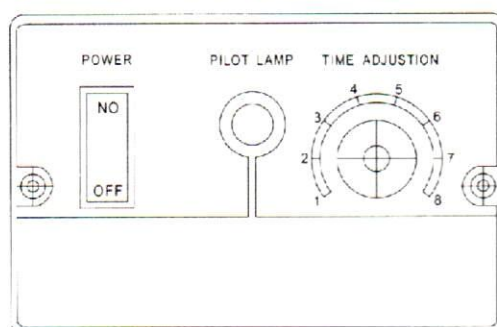


FIG.1. DIAGRAM OF THE CONTROL PANEL FOR IMPULSE SEALER

Connect to 100V/220V power source according to the indication mentioned in the machine, Switch on the power, the red light is on, Adjust the sealing time according to the materials and the thickness of the bags to be sealed. The sealing time should be adjusted



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to around grade 1 before sealing. Put the opening of the bag into between the heat sealers, step down the pedal and the yellow lamp lights. Take out the sealed bag 1-2sec. After the yellow lamp is off.

If the seal is not tight enough, lengthen the sealing time. Try the bag for several times till it is well sealed with clear figure and no wrinkles. Seal bags at this sealing time and temperature. The cooling time should not be too short, otherwise wrinkles will be caused in the seal. The longer the sealing time, the longer the cooling time.

3.2 adjustment and usage of direct heat sealer.

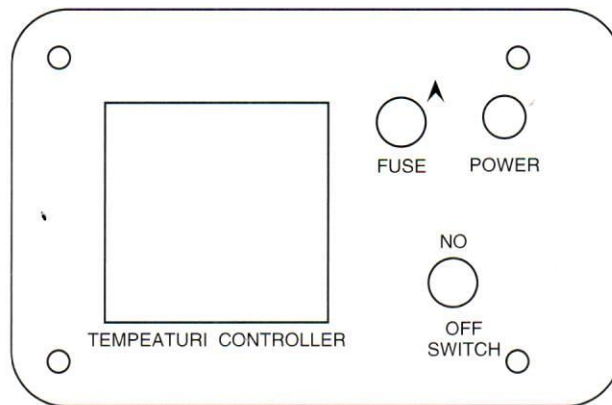


FIG.2 DIAGRAM OF THE CONTROL PANEL FOR DIRECT HEAT SEALER

3.2.1 Loosen the screws for date characters, array the characters according to the requirement and tighten the screws again.

3.2.2 Connect to 110V/230V power source according to the indications mentioned in the machine, Switch on and the red lamp lights. Adjust the temperature according to the material and the thickness of the bags to be sealed. The preset temperature is not reached when the green lamp is still on, When the red lamp is on, the required temperature is reached. It is the right time for working. Put the opening of the bag into between the heaters. Step down the pedal for about 0.2-1.5 sec. And release the pedal. The sealing operation is finished at this time.

3.2.3 If the seal is not tight enough or the date is not well heat printed. It may be because the temperature is too low or the time with the pedal being stepped down is too short. The solution is to raise the sealing temperature and (or) to lengthen the time with the pedal being stepped down.

3.2.4 If the bag is melted or the place where the date is printed is broken, for impulse sealer, the reason is too long sealing time and for direct heat sealer, the reason is too high

temperature or too long time with the pedal being stepped down. The solution is to shorten the sealing time for impulse sealer and for direct heat sealer, to lower the sealing temperature and/or to shorten the time with the pedal being stepped down.

3.2.5 Switch off the power and unplug the machine when finish working.

#### 4. MAINTENANCE

##### 4.1 Maintenance for impulse sealer.

Never try to seal without bags. Don't set the sealing time to the high grade without trials. Otherwise, the teflon cloth will be burned. If some plastics unfortunately adheres to the teflon cloth because of carelessness, never try to scrape it with something hard. Just slightly reduce the sealing time and seal the bag again. Release the pedal a little after the yellow lamp is off. It is very important to get out the bag from one side to the other. The remains of the plastics will be cleared from the teflon cloth with the bag.

##### 4.1.1 Replacement of the heater

Loosen the screws of the plate pressing the teflon cloth, roll back the cloth to let out the heater, loosen the bakelite boxes at both sides of the heater and get out the screws on the copper block, Now the heater can be removed. Replace it with a good new one. The heater should always be in tension with the function of the spring. The copper block should be tilled if it is oxidised, to ensure it has a good connection with the heater, Pay attention when fixing the heater so that the teflon cloth below is flat(no wrinkles are allowed). And the heater must have a excellent isolation. Otherwise the heater will be damaged because of the short-circuit.

##### 4.1.2 Replacement of teflon cloth

Remove the screws and the plates above the teflon cloth, loosen the shaft of the teflon cloth roll, pull cut the cloth and cut the burned part. Reassemble the plates and screws, tighten the roll shaft. No wrinkles are allowed in the teflon cloth, otherwise the seal quality will be affected.

##### 4.1.3 Replacement of the micro-switch

There is one micro-switch at the side of the machine head. It must be replaced when it is damaged. The adjustment of the pressing pole for micro-switch: Put 1mm thick carton between the upper and lower and lower pressing arms, check if the micro-switch is pressed and if there is a "click" from the switch, if it is not pressed, adjust down the pressing pole or tighten the nut c3 till the switch is pressed 1-2mm down when it works.

4.1.4 Always keep the sealing surface clean. Otherwise, the remains in the sealing surface will shorten the life of the heater and the life of the teflon cloth. When working, never try to clean the sealing surface with wet cloth.

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4.1.5 After long time usage, the rubber in the upper pressing arm must be checked if it is still flat and straight. Otherwise, the seal quality will be affected.

4.1.6 Often add lubricating oil into the moving parts.

4.1.7 All parts in the machine should not be disassembled casually.

4.2 Maintenance for direct heat sealer

4.2.1 Always keep the surface of the date character clean. Avoid any remains on the sealing surface to guarantee the quality of the seal, date printing and the life of the machine.

4.2.2 Never try to clean the sealing surface with wet cloth when the power is still connected. Never touch the heating block with hand in case of being burned.

4.2.3 The same model of the theater must be used when replacing.

4.2.4 Attention not to connect high voltage source to "+" , "-" inputs or to thermocoupling in case not to damage the temperature controller.

4.2.5 After long time usage, check if the rubber on the upper pressing arm is flat and straight. Otherwise, the quality of the seal may be affected. Check if the wire connection of the heater and the heater is in good position.

4.6 Often add lubricating oil into the moving parts.

4.7 Don't disassemble any parts in the machine casually.



5. TROUBLES & TROUBLE-SHOOTING

5.1 For impulse sealer

TROUBLES	CAUSER & SOLUTLONS
The seal is no good	To lengthen the sealing time if seal is not tight enough. To shorten the sealing time if the seal is melted. Or The melted seal is carsed by not being pressed tightly.
The seal is wrinkled	1. Overheating. Shorten the sealing time as possible on the condition that the good seal of the bag is guaranteed. 2. Insufficient time for cooling. Lengthen the cooling time.
The temperature rises when working for some time	it is normal that the tomperature of machine will rise because the machine is started at the room temperature, it absorbs some heat during the operation. Shorten the sealing time sightly to bal-ance the heat.
The power lamp doesn't light and the sealer does not work	Check if the power switch is on, if the fuse is all right.
The power lamp lights but the sealing lamp is off and the sealer doesn't work.	Step down the pedal to check if the micro-switch works well. See 4.13 for adjustment.
The sealer is always electrified when the power is switched on	Swith the power off at once. Check if the micro-swith is all right. See 4.13 for adjustment.

5.2. For direct heat sealer  
TROUBLES

CAUSE & SOLUTIONS

The seal is no good.	To lengthen the tiime with the pedal being stepped down or to raise the sealing temperature. If the seal is not tight enough. Or vice versa, if the seal is melted.
There is wrinkles in the seal	1. Overheating. Shorten the sealing time as possible on the condition that the seal of the bag is guaranted. 2. The time with the pedal being stepped down is too long. Short-edn this time.
Both power lamp and the lamp of the temp. Controller don't light.	Check if the connection of the heater is in good condition, if the heater is all riht, if the themocoupling is no problem and if the connection of the coupling is ok.
The temperature is out of control.	1. The thermo-coupling is damaged or not well connected. 2. There is a problem in the temperature controller.

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6. ELECTRICAL PRINCIPLE DIAGRAM

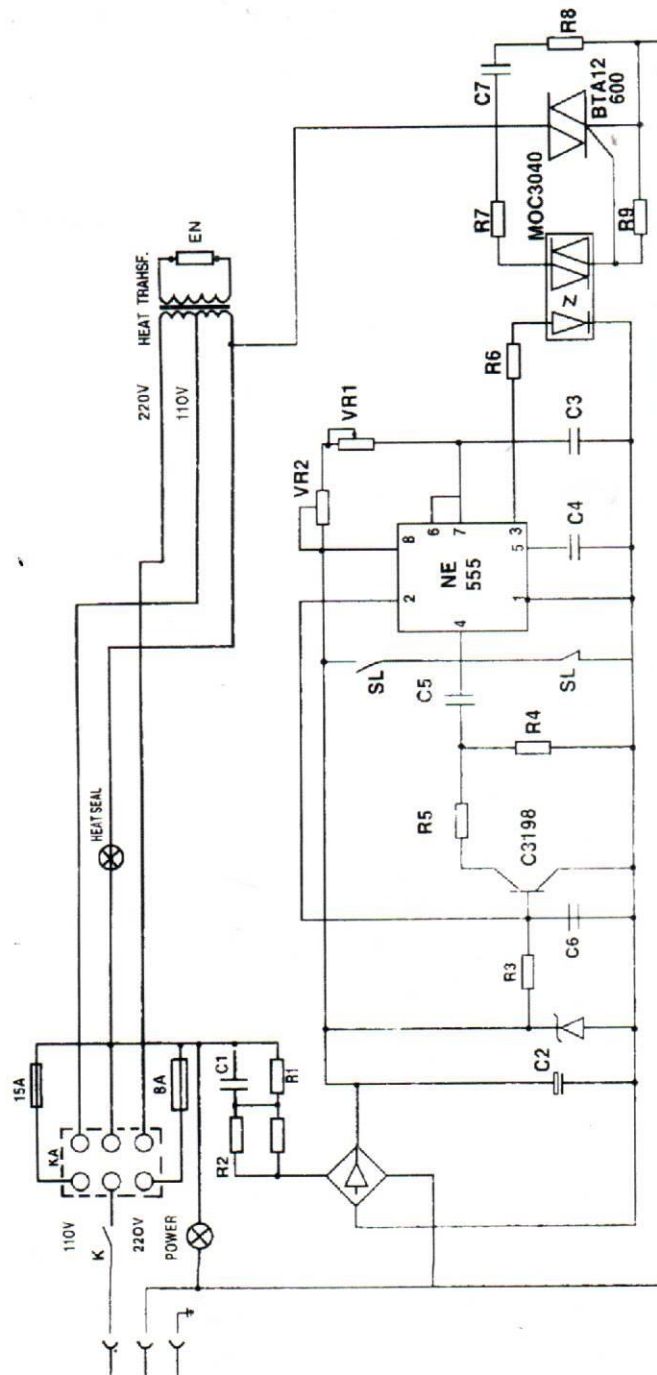


FIGURE 3. ELECTRICAL PRINCIPLE DIAGRAM FOR IMPULSE SEALER



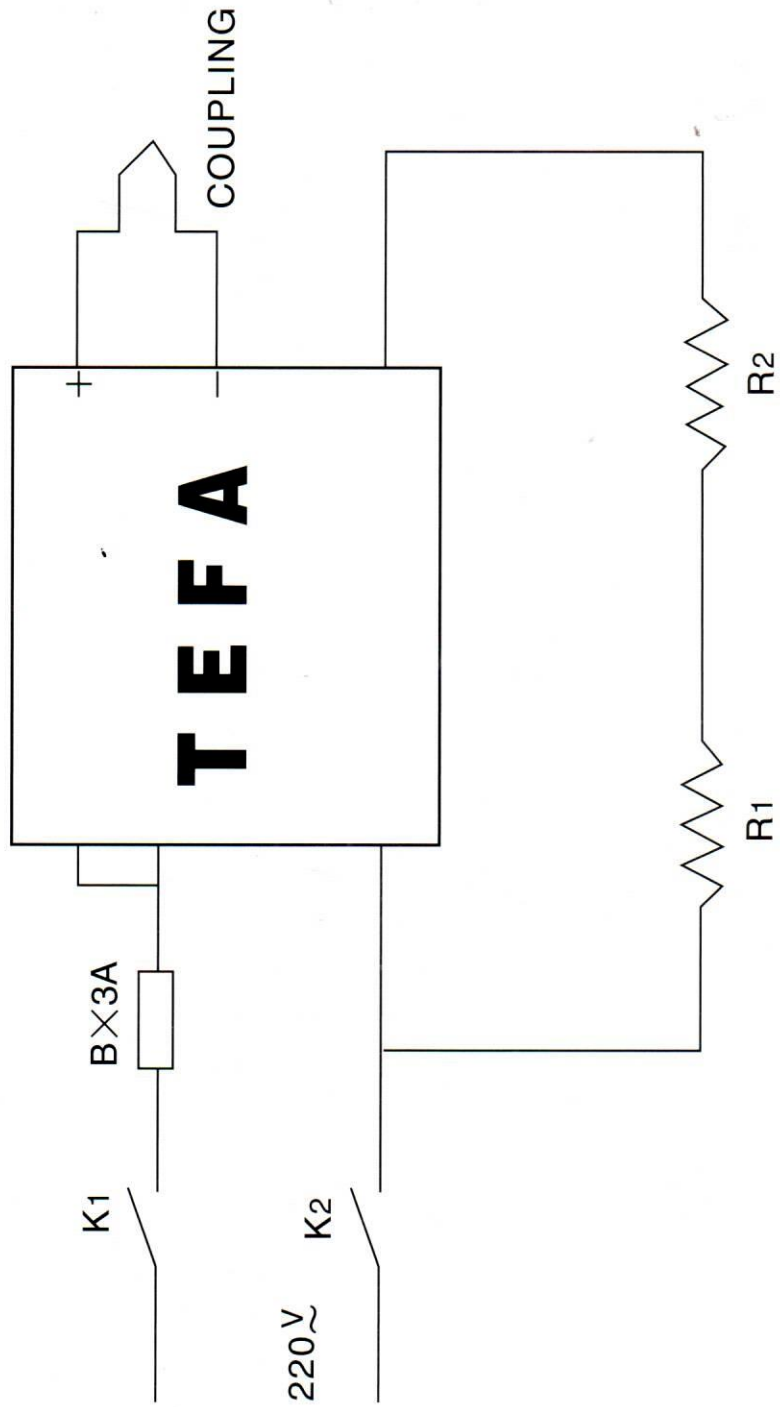


FIGURE 4.ELECTRICAL PRINCIPLE DIAGRAM FOR DIRECT HEAT SEALER

## ● OPERATION INSTRUCTIONS ●

NO.	NAME	QUAN	NO.	NAME	QUAN
C1	Heat connector	2	C2	Heat spring cushion	2
C3	Nut	1	C4	Teflon cloth sheet	1
C5	Front table	1	C6	Teflon table stand	1
C7	Teflon cloth	1	C8	Spring	1
C9	Silicon rubber stand	2	(11)		
C10	Date characters	10	D1	Panel	1
D2	Transformer	1	D3	Power wire	2
D4	Heat sealer	1	D5	Wire connector	2
D6	Micro-switch	1	D7	Pc board	1
D8	Heater	1-2	D9	Thermo-coupling	1
F1	Power wire	1	F2	Frame	1
	Protection board		F3	Pulling tube	1
F4	Pulling hook	1	F5	Pressing base for	1
F6	Pressing plate for	1		Micro-switch	
	Micro switch		F7	Teflon cloth stand base	1
F8	Pulling plate	1	F9	Short pulling pole	1
F10	Teflon roll shaft	1	F11	Teflon roll shaft	1
F12	Pc board stand	1		Stand	
F13	Pressing plate	1	F14	Adjusting Nut	1
F15	Pressing pole for	1	F16	Positioning plate for	1
	Mirco-switch			Date character	
F17	Lower sealer	1	F18	Clipper for heater	2-4
F19	Adjusting block for	1	F20	Upper sealer	1
	Date character		L1	Machine head	1
L2	Upper arm	1	L3	Lower arm	1
L4	Peck cover	1	L5	Machine base	1
L6	Pedal	1	S1	Nylon sheath	2
S2	Nylon cushion	2	S3	Bakelife cover	2

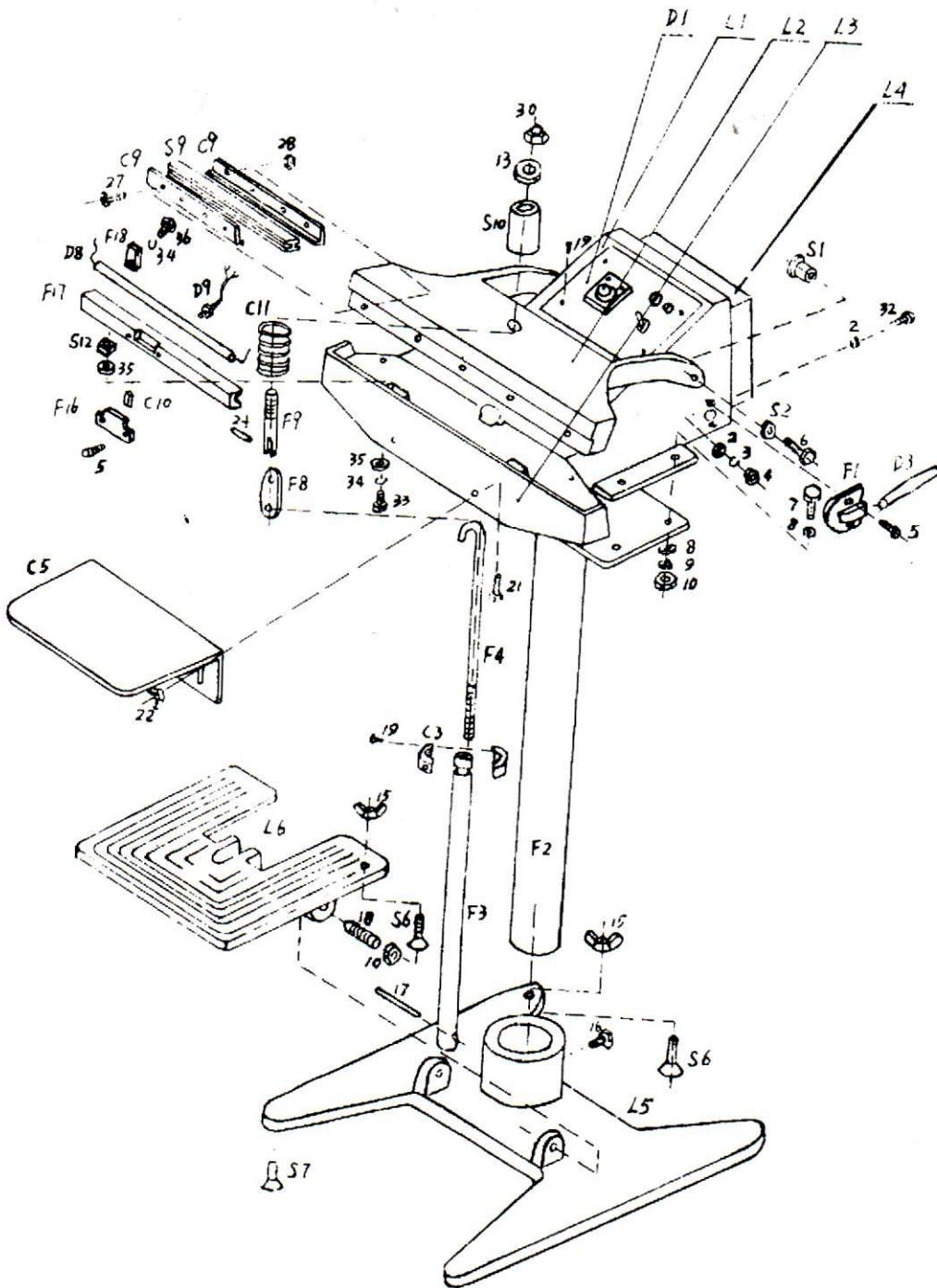
## ● OPERATION INSTRUCTIONS ●

NO.	NAME	QUAN	NO.	NAME	QUAN
S4	Isolation sheath	2	S5	Isolation cushion	2
S6	Bolt with rubber head	2	S7	Base cushion	3
S8	Bakelite nut	2	S9	Silicon rubber	1
S10	Rubber column	1	S11	Isolation screw	2
S12	Heat isolation cushion	2-4	1.	Round screw m5x10	4
2.	Cushion 5	4	3.	Spring cushion5	4
4.	Hex nut m5	4	5.	Round screw m4x10	2-4
6.	Hex bolt m4x10	2	7.	Hex bolt m4x30	2
8.	Cushion 10	8	9.	Spring cushion 10	4
10.	Hex nut m10	6	11.	Round screw m3x10	2
12.	Round screw m4x6	4	13.	Rivet 3x10	4
14.	Round screw m4x16	2	15.	Butterfly nut m10	2
16.	Hex bolt m10x20	1	17.	Elastic column peg8x40	1
18.	Position bolt m10x40	2	19.	Round screw m4x8	6
20.	Peg	1	21.	Hex screw m8x16	2
22.	Butterfly nut m8	2	23.	Sink x screw m4x8	2
24.	Elastic column peg 5x12	1	25.	Round screw m6x24	2
27.	Round screw m4x25	5	26.	Butterfly nut m6	2
29.	Hex nut m3	2	28.	Hex nut m4	5
31.	Screw m3x8	4	30.	Cover nut m12	1
33.	Hex bolt m6x25	2-4	32.	Round screw m5x20	4
35.	Spring cushion 6	4-8	34.	Hex Bolt m6x16	2-4
			36.	Cushion 6	8-16





● OPERATION INSTRUCTIONS ●



PFS-DS  
FIG.6 SHAFTS DIAGRAM FOR PFS-DD DIRECT HEAT SEALER





8. PACKING LIST

Parts of the machine	1set
Wrench 6"	1
Cross screw driver 3"	1
Straight screw driver 3"	1
Fusee 2-15a	2-4
Teflon cloth	1(for impulse sealer only)
Heat sealers	2(for impulse sealer only)
Heater	1(for direct heat sealer)
Operation manual	1