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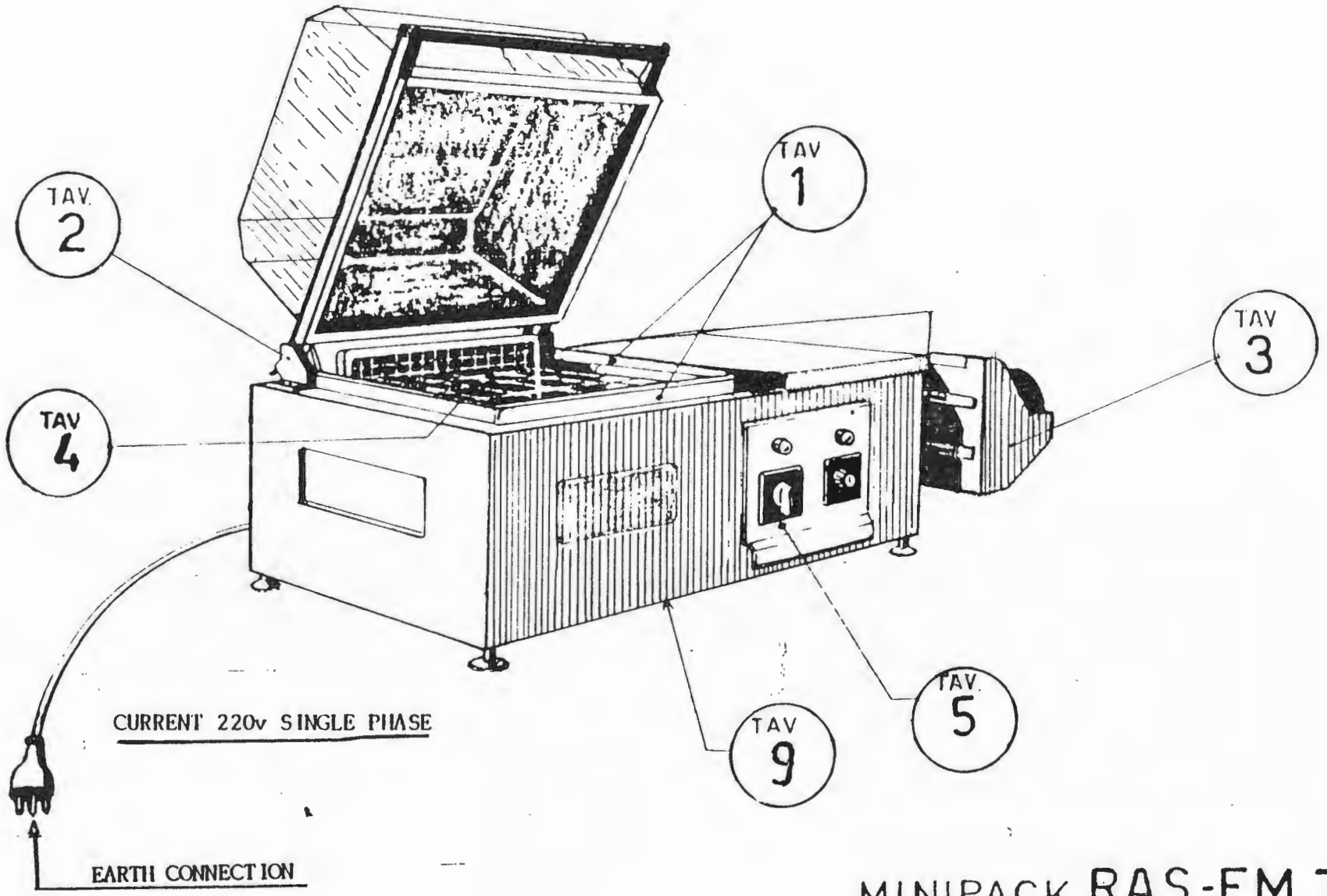
Print-Date: 26/05/20

BarTender: CASA_100x30L_Address.btw

111 kg

A

TECHNICAL PLATE



PATENTED

MINIPACK RAS-FM 76

MINIPACK

USE AND MAINTENANCE INSTRUCTIONS

1.1) assemble the trolley (refer to the leaflet of the machine or per enclosed schema). Put the machine onto the trolley and fit the roll support onto the machine inserting into the sliding bars.

1.2) MAINS CONNECTION
Make sure that the socket has a good earth. Check that the voltage (V) and power (W) available,correspond to the data indicated on the plate fitted on the back of the equipment (see also facsi mile hereunder).

Supply V. 220/240 + earth
Max. power when starting up kw.3.3 (FM 75 2.3).
Average Power Consumption kw/hour 1,9 (FM 75 1,2)

WARNING: Machines must be earthed. (Should the socket's wiring have not earth, connect the yellow/green wire to a good exterior earth.)

1.3) START-UP. When switch is in position (1), machine seals only- no start-up time is needed.Position (2) is sealing + shrink in one operation. Before using the machine on No. 2 allow it to heat up for about 5-7 minutes until thermostat light goes out

1.4) HEATING TEMPERATURE. When the machine's thermostat is visible,adjust it until it is at preset 200/250° (normally at the maximum).(When the thermostat is not visible, it has already been adjusted and it is in the optimum position).

1.5) SEALING. Set the sealing blade impulse timer on positions 7 to 10 for th first 10/20 packages.The timer should subsequently be lowered to position 3 to 5 or more in order to have a minimum temperature suitable for cutting and sealing the film adequately. The above operation enables good quality sealing and prolongs life of the sealing blades.

IMPORTANT INSTRUCTIONS

2.1) Ensure the sealing blade is cleaned with the appropriate brush provided and lubricated with the silicon spray, once work is over or during work when necessary.

2.2) The machine should always be cleaned once work is over (including the inside of the transparent chamer).

2.3) ensure that the machine and all moving parts are in good running order. If necessary, lubricate all moving parts that do not come into contact with the heat with mineral oil. When necessary,lubricate the pivot pins of the valve (See table No. 4 FM/75 0044- FM 76 0045) with a drop of oil or silicon.

2.4) Make sure that the blade contact pad and its fibre glass/P.T.F.E cover are in a good condition. The exterior P.T.F.E (the thinner one) must be removed when it begins to burn and this should be done before the thicker P.T.F.E. (attached to the pad) begins to burn. Just remove thin self-adhesive P.T.F.E. and replace it with another after having cleaned the thick P.T.F.E.

2.5) Sealing blade replacement. Follow the instructions indicated in Table No. 1.Compress the pistons (G) before locking the sealing blade with the screws (A).

2.6) The machine is equipped with two thermostats and one alarm-bell. The first thermostat can be set with the handle placed outside on the back of the working plate, and is the working one in the normal conditions.The second one (security) is placed inside of the body of the machine and it starts to work only when the first has broken. If that happened, one alarm-bell starts ringing and it will continue till the broken thermostat is replaced. This replacement must be done immediately for avoiding possible big dammages to the machine.

N.B. Clean the blade groove before introducing the new blade, taking care not to ruin the groove itself.To do this, use a piece of worn sealing blade after having cut the blade perfectly straight so that it can be used as a knife.

POSSIBLE FAULTS

3.1) - Sealing -

If the machine does not seal the film or seals it badly,the possible causes could be as folllows:

- No voltage at the terminals (G)
- Voltage or current too low.
- Sealing timer can be out of order (when set time is up a click should be heard).
- Timer socket inside electric panel might be disonnected.
- Sealing blades could have a bad contact with low tension current (Terminals (G) and screws (A): see Fig. (1).)
- The sealing blade disconnected or broken.

- Rubber and P.T.F.E. blade contact pad could be worn or have bad contact with blade. (See Table (1) Drawing FM 75 0140 FM 76 0140)
- For the other faults, check the electrical equipment inside the machine as indicated on Table (5), using the wiring diagram as a guide.

3.2) - Heating Unit -

If it does not heat up the possible causes could be as follows:

- False contacts in the heating element (check after the electricity is switched off).
- Burning of element or elements (See Table 4).
- Thermostat out of order or set too low.
- Motor fans out of order
- Voltage supply too low.

4.1) Diagrams of the machine's electrical and mechanical components are attached. They indicate the position of the various components in a clear and simple manner thus representing an accurate guide for the maintenance engineer.

4.2) If the alarm-bell starts ringing that means that the first thermostat became broken. Wether the adjustable thermostat cannot be replaced immediately, the machine can be carefully used taking care to switch out it if is not working for more than 5 minutes

4.3) Should a damaged part have to be replaced, please contact our customer service department (address is indicated on the first page of the instruction handbook). In order to assist in replacing a part the following information should be provided:

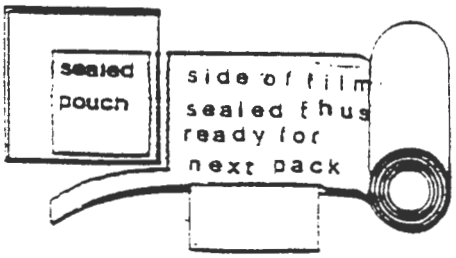
- Type of machine (i.e. RAS FM 75 or 76)
- Date of construction
- Serial No. (which is embossed on the right side of the working plate)
- Code No. of part requested.

FEATURES OF THE MINIPACK SYSTEM

5.1) The Minipack is a patented wrapping machine.It enables sealing and shrinking in one operation without the need of tunnel. The films must be of a shrinkable, centrefolded PVC.(The film thickness ranges from 15 to 40 micron. The necessary equipment for sealing and shrinking is contained in the unit,and works at the same time.
The machine can aslo be used as an L sealer (Main switch in No. 1 position) and it can seal any type of plastic sealable film when shrinking is not necessary

HOW THIS MACHINE WORKS:

5.2) Sealing is done on impulse. The film is melted by the heat of the sealing blade for a set time and when pressed between the sealing blade and the P.T.F.E. The pressure and the heat cut the film and seal the two sheets of film together.



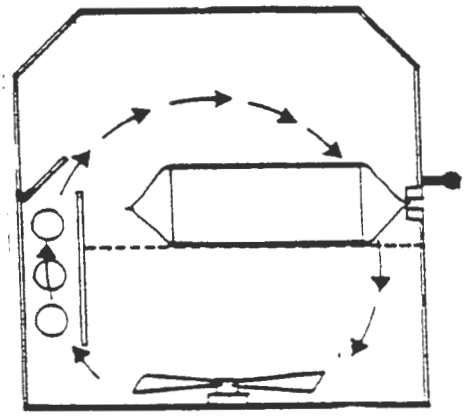
In this way we have a completly sealed pouch inside the sealing frame and the film on the working plate is sealed only vertically to allow the loading of the next products.

THE MACHINE WORKS IN 2 WAYS:

5.3) Just sealing or sealing and shrinking. For sealing only set main switch in position 1,for shrinking set main switch in position 2 and wait for 5 minutes until thermostat light goes out.(Orange light)

SHRINKING:

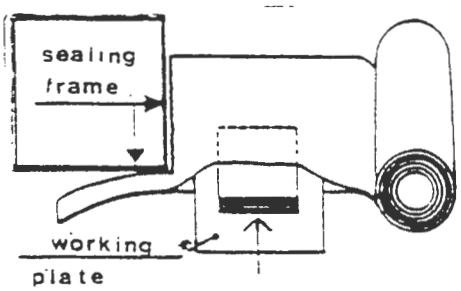
5.4) Seal has been obtained by closing the plastic chamber. This operation, if the main switch is on No.2 (for at least 5 mins) produces another complementary effect: rotates motor fans and moves a valve that opens a hot air chamber,the air circulates rapidly around the bags causing them to shrink. This operation is pratically instantaneous.



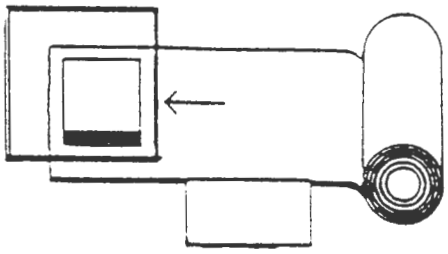
METHOD OF OPERATION

6.1) The operator inserts the roll holder into the core of the plastic film roll sliding the aluminium blocks into position and locking them. Puts the roll holder onto the roll support having the opening of the centrefolded film facing operator. Inserts film through the micro perforator (see table 3) if produsts required perforated film Operator opens film, and places it around the work table (one sheet on top, one below). Finally seals the sides of films vertically together.

6.2) Operator inserts an item or group o items into centrefolded film, pushing it or them till the end of the open film



6.3) Operator slides item and film to the lefthand side to the sealing frame Item must be positioned in the right hand bottom corner approx.1/2" to 1 inch away from the sealing blades



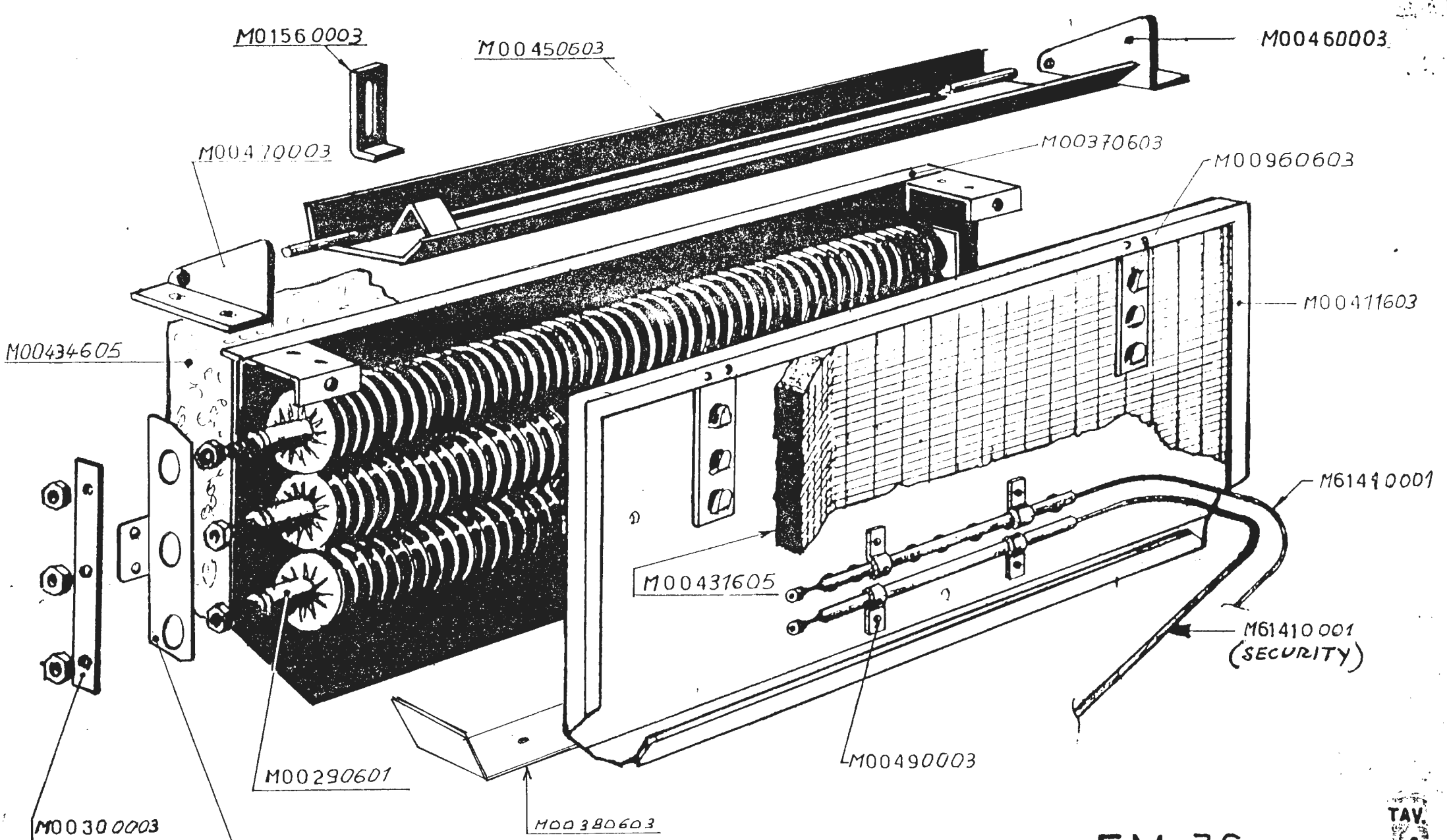
6.4) Operator then closes the plastic chamber pressing on the handle and the seal and shrink operating (or just seal) is automatically carried out and the operator can see the process through the plastic chamber. When the item is well wrapped operator relea sed the handle,and the chamber opens by itself, operation is finished. Operator removes the wrapped products and recommences operation.If the machine is fitted with electro magnetic device, the shrinking time can be set from up to 2 to 4 sec. or more according to the requirements of the products.Operator closes plastic chamber pressing on handle for one second; sealing and shrink operations are carried out automatically and chamber will lift itself when operation is over.

FILM SIZE

7.1) According with the dimensions of the products to be packed we can establish the width of the centre-folded film as follows:if the product is round we consider the diameter plus the height of the product plus 2 inches (more or less depeding on the height of the product).The total amount of these figures gives the roll size.If the product is square or rectangular, side plus height plus 2 inches.

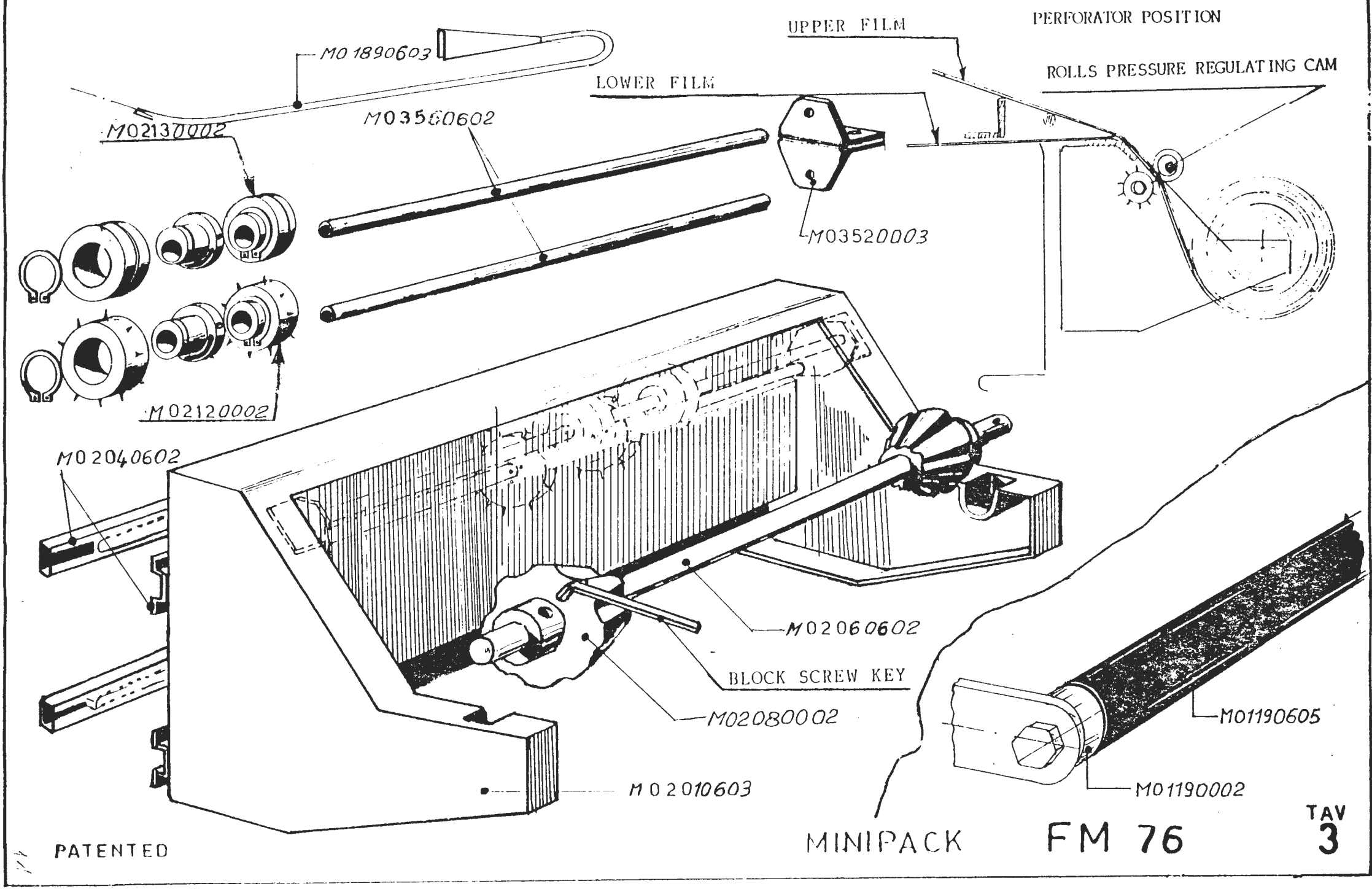
THICKNESS OF THE FILM AND COST FOR UNIT:

8.1) According to products and customers needs, cost of each overwrap ping depends on thickness of the film (total surface by weight for sq. m. of the film by price per kilo of the film gives cost per piece)
Film can be chosen in different thickness (i.e. 15-18-20-25-30 etc micron)
Weight of different type of film and technical data can be sent under request.



MINIPACK FM 76

TAV. 4



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MINIPACK FM 76

TAV 3

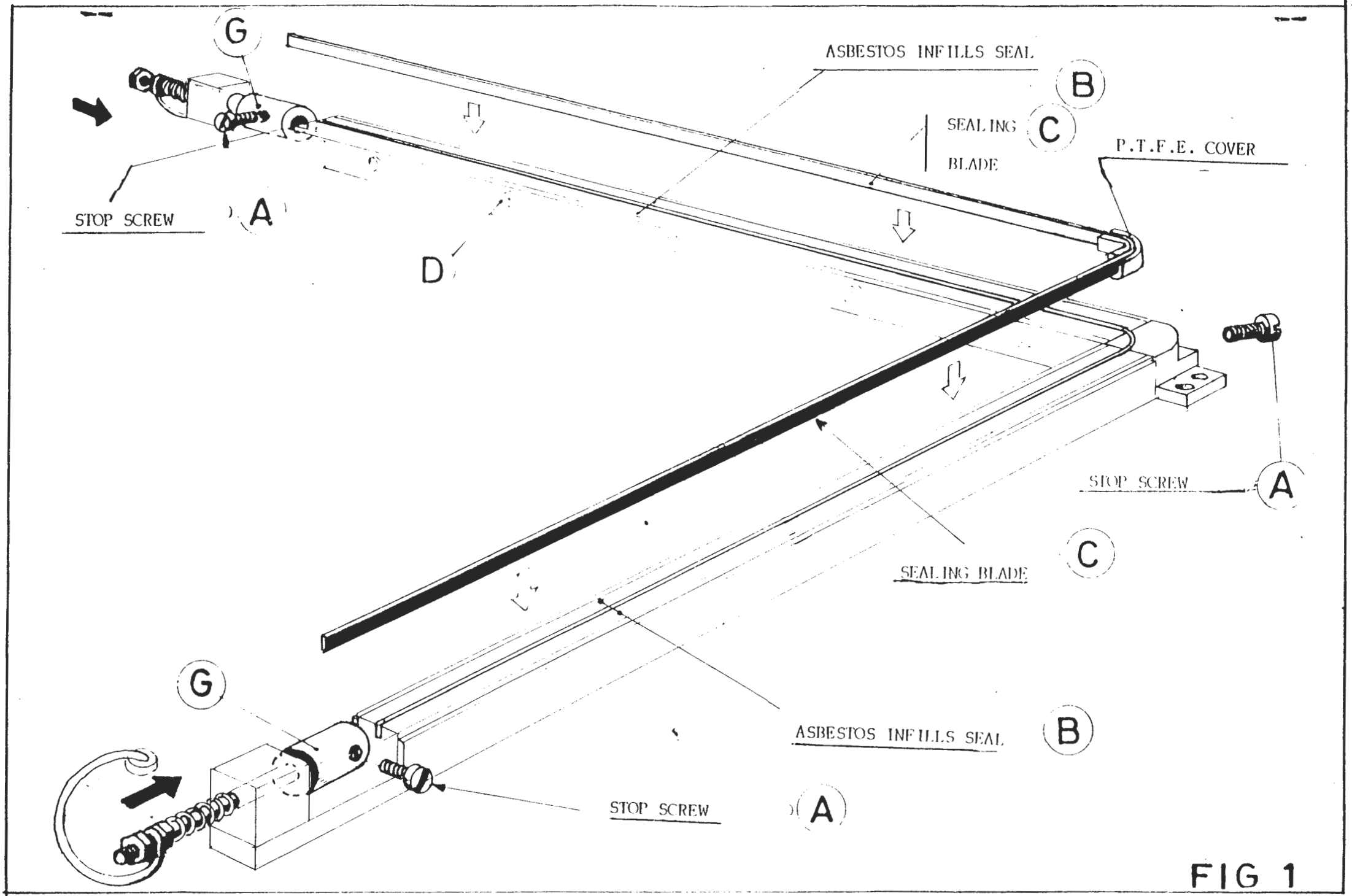
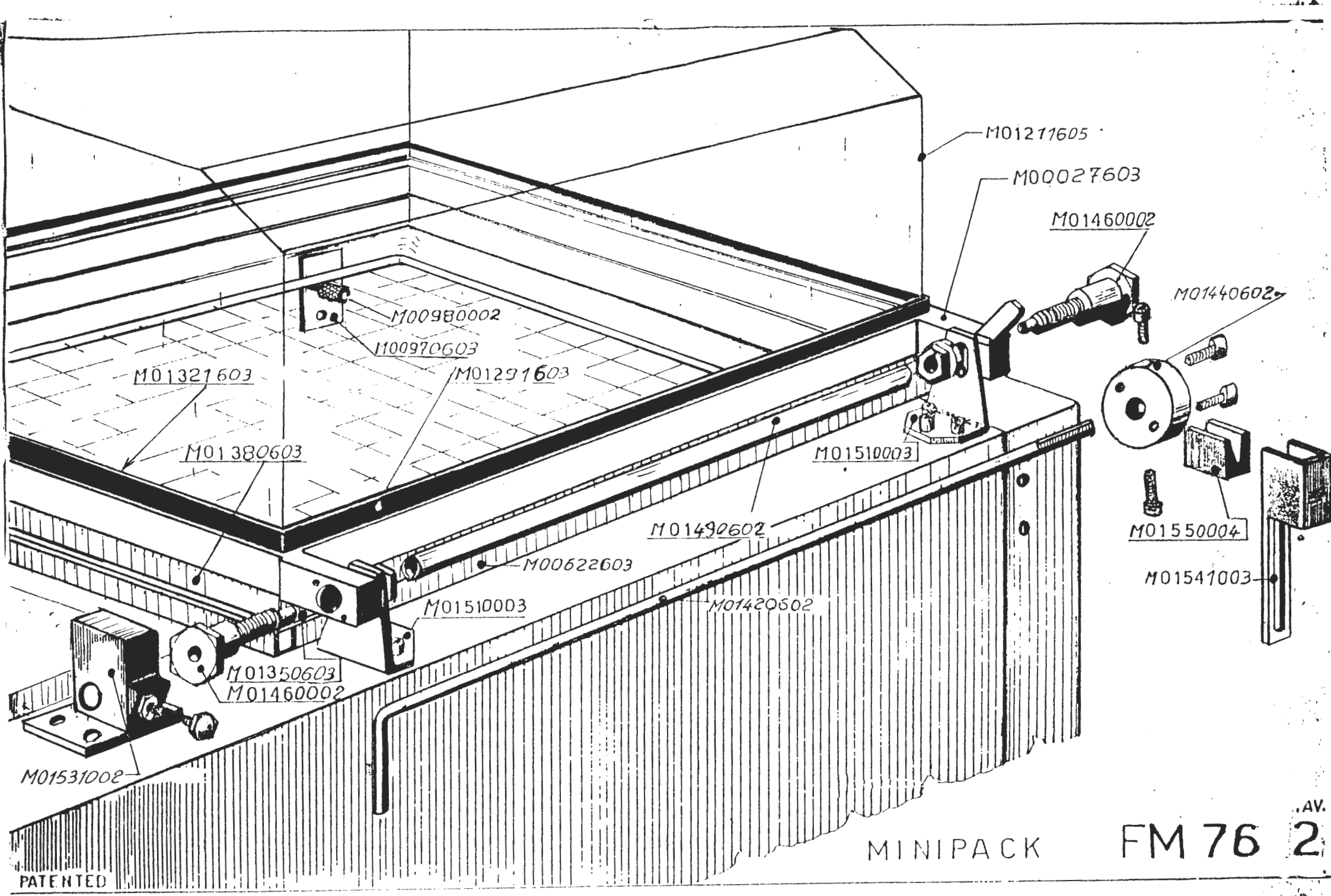

G
ASBESTOS INFILLS SEAL
B
SEALING
C
BLADE
P.T.F.E. COVER
STOP SCREW
A
D
STOP SCREW
A
C
SEALING BLADE
G
ASBESTOS INFILLS SEAL
B
STOP SCREW
A

FIG 1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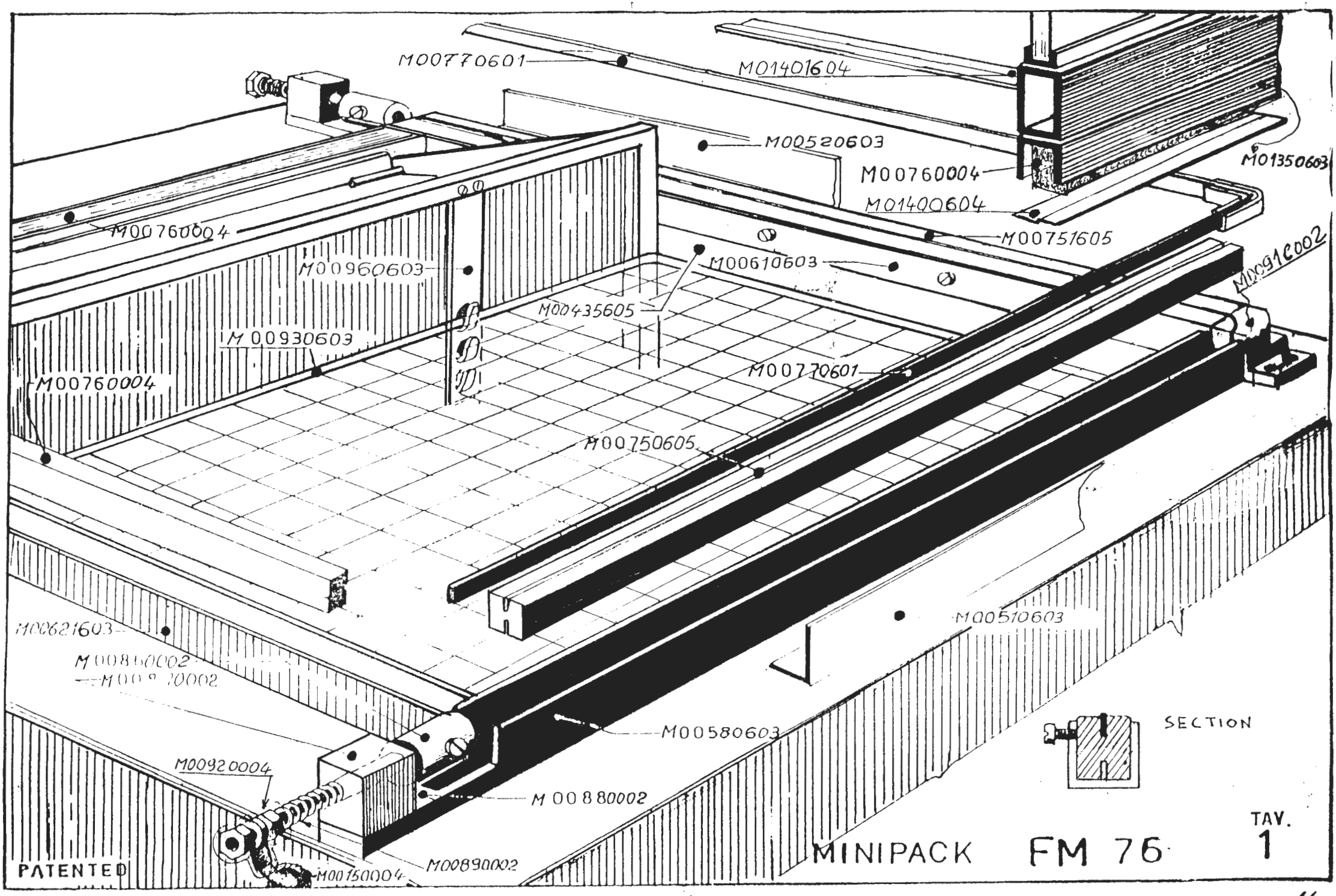
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M00930603
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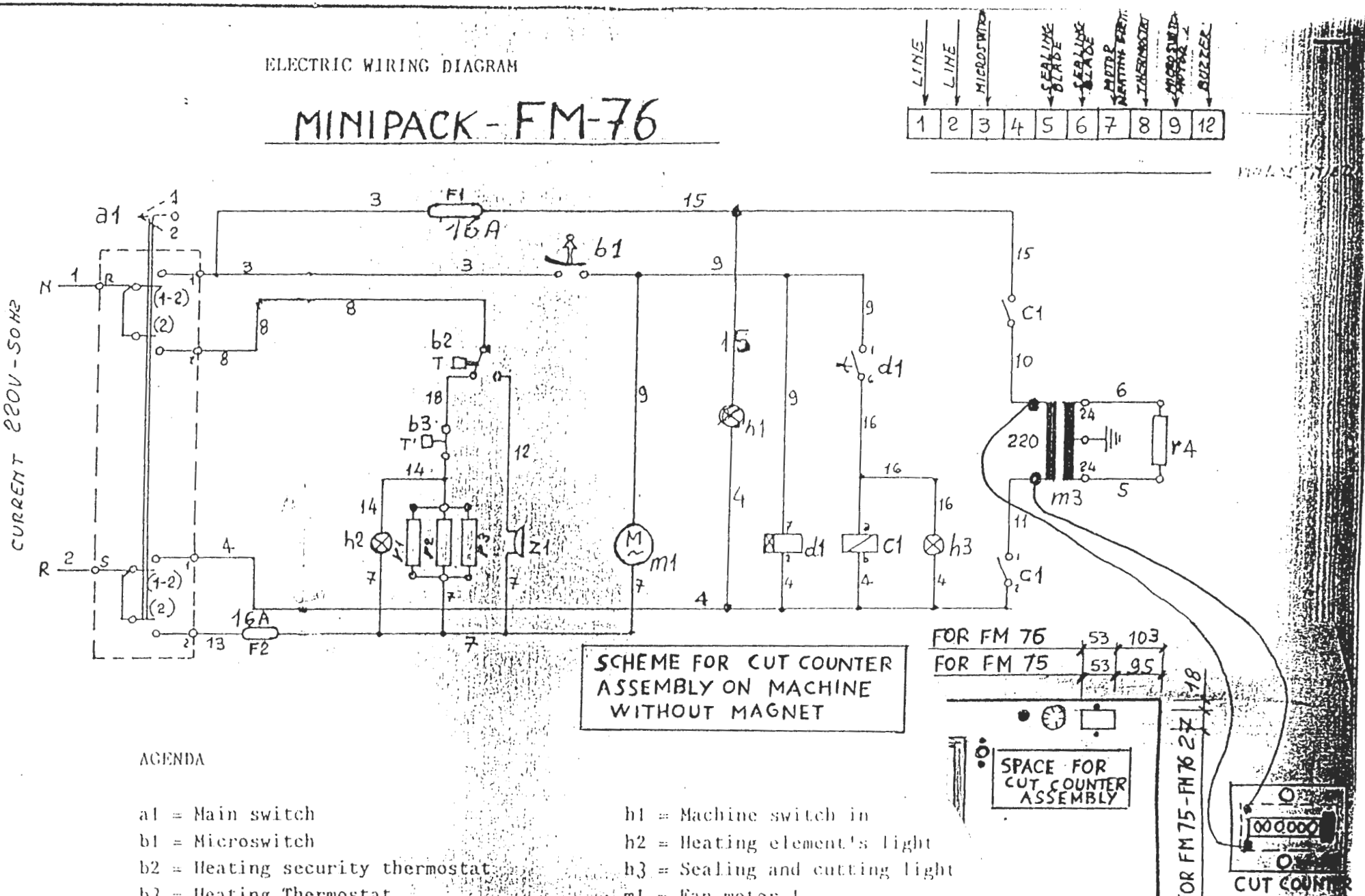
M00760004
M00750605
M00621603
M00510603
M00860002
M00880002
M00580603
M00920004
M00890002
M00750004
SECTION
PATENTED
MINIPACK FM 76
TAV. 1

ELECTRIC WIRING DIAGRAM

MINIPACK - FM-76



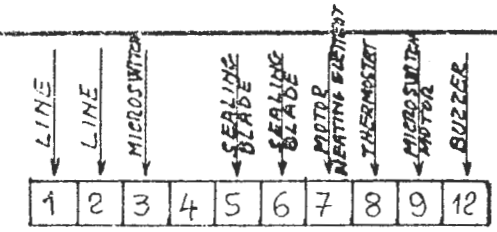
AGENDA

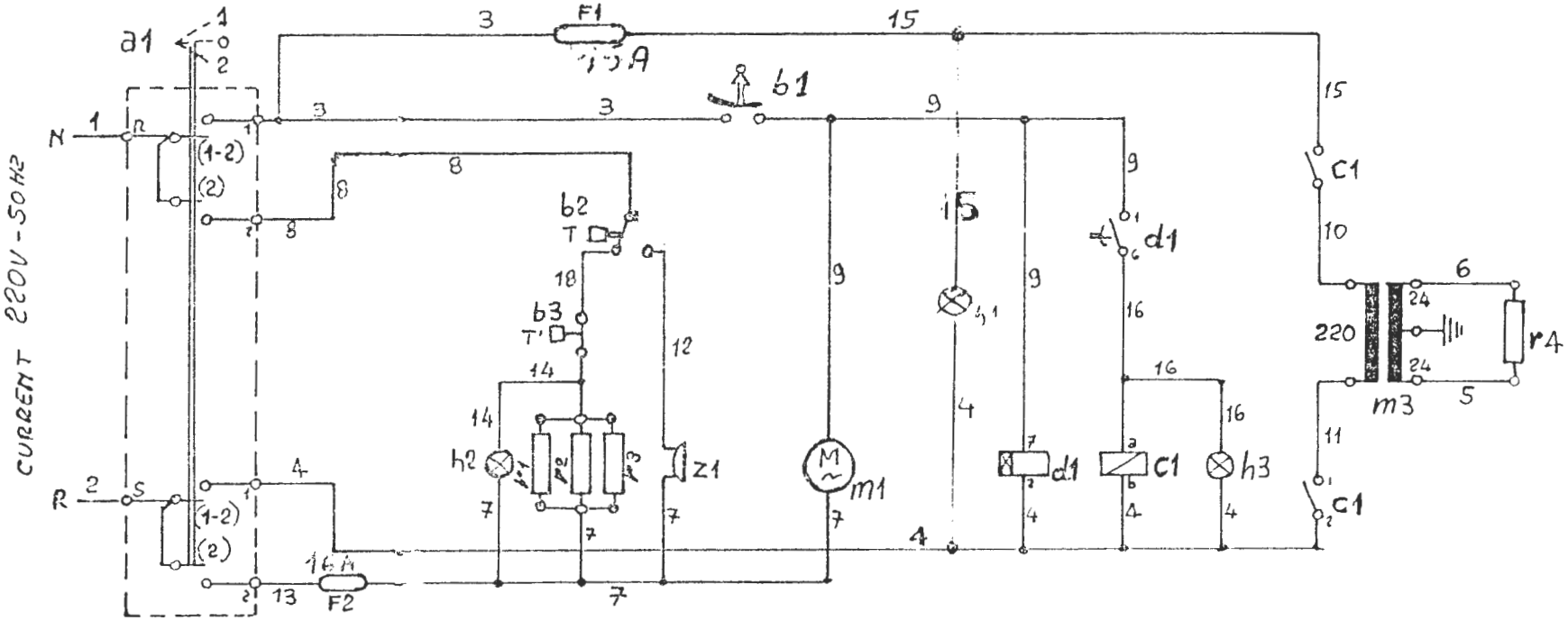
a1 = Main switch
b1 = Microswitch
b2 = Heating security thermostat
b3 = Heating Thermostat
c1 = Feeding relay m3
d1 = Sealing and cutting timer
F1 = Fuses 16A
F2 = Fuses 16A

h1 = Machine switch in
h2 = Heating element's light
h3 = Sealing and cutting light
m1 = Fan motor 1
m3 = Feeding transformer r2
r1/r2/r3 = Heating elements
r4 = Sealing and cutting blade
z1 = Buzzer

ELECTRIC WIRING DIAGRAM

MINIPACK - FM-76



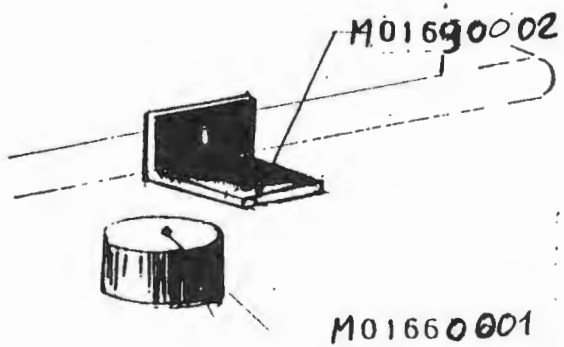


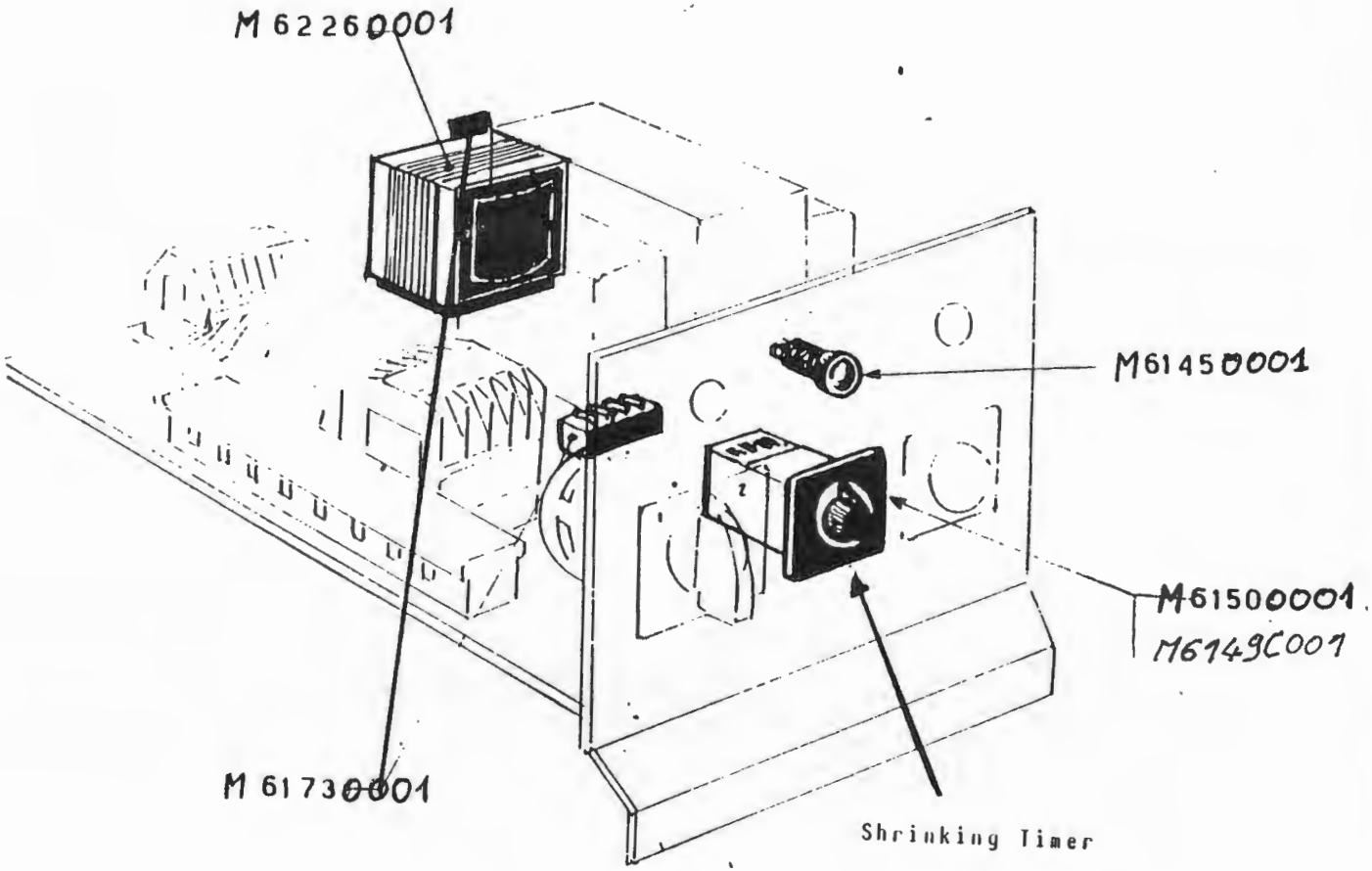
AGENDA

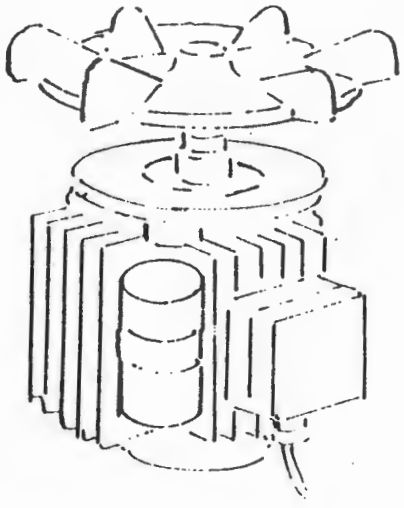
a1 - Main switch	b1 - Machine switch in
b1 - Microswitch	h2 - Heating element's light
b2 - Heating security thermostat	b3 - Sealing and cutting light
b3 - Heating Thermostat	m1 - Fan motor 1
c1 - Feeding relay m3	m3 - Feeding transformer r2
d1 - Sealing and cutting timer	r1/r2/r3 Heating elements
F1 - Fuses 16 A	r4 - Sealing and cutting blade
F2 - Fuses 16 A	z1 - Buzzer

TAV. 6

MINIPACK - FM-76







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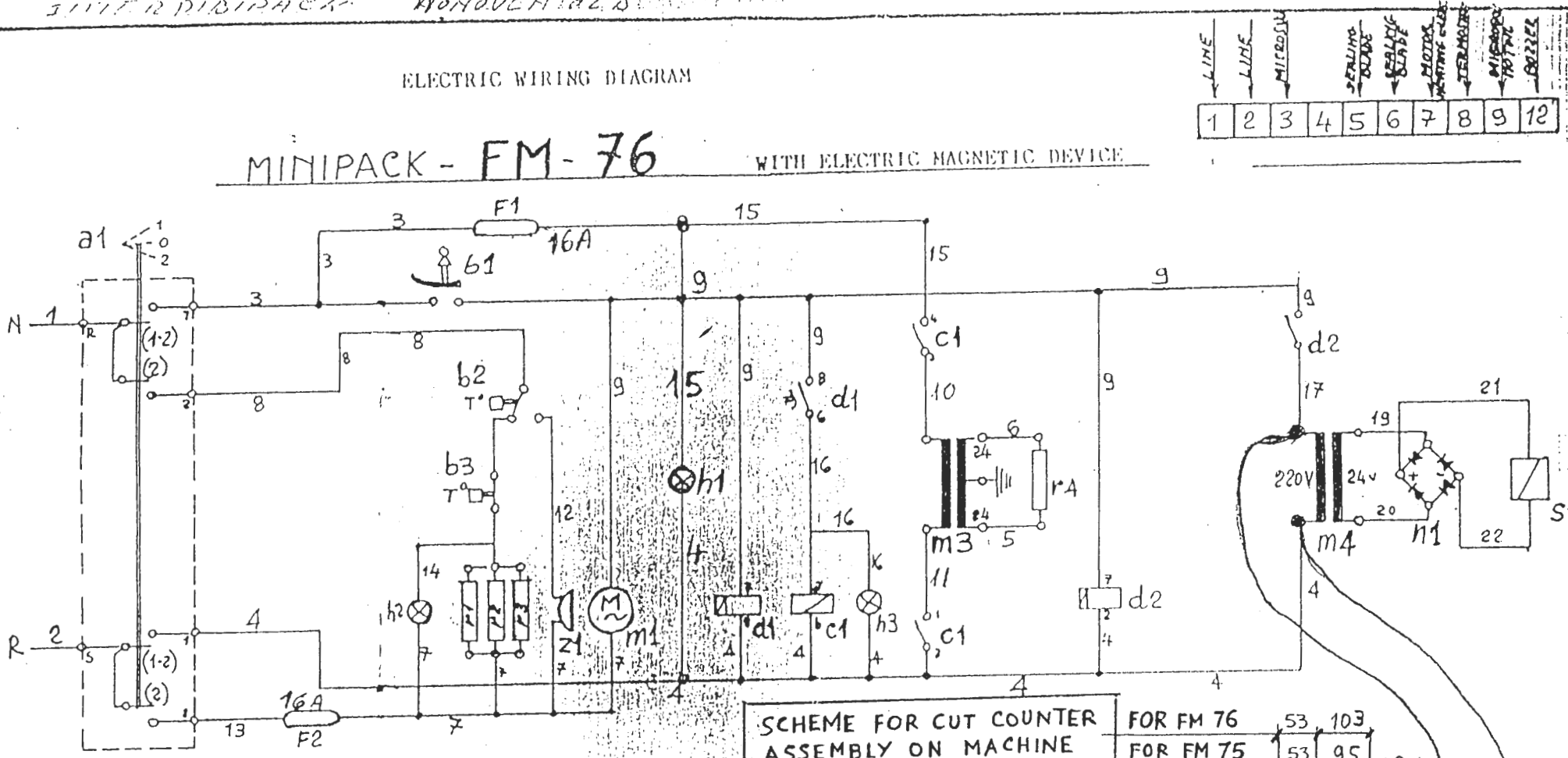
MINIPACK FM 76

TAV 7

ELECTRIC WIRING DIAGRAM

MINIPACK - FM - 76

WITH ELECTRIC MAGNETIC DEVICE



AGENDA

a1 = Main switch
b1 = Microswitch
b2 = Heating security thermostat
b3 = Heating thermostat
c1 = Feeding relay m3
d1 = Sealing and cutting timer
d2 = Shrinking timer
f1 = Fuses 16A
f2 = Fuses 16A
h1 = Machine switch in light
h2 = Heating elements light
h3 = Sealing and cutting light
m1 = Fan motor 1
m3 = Feeding transformer r2
m4 = Feeding transformer s1
n1 = Bridge for s1
r1/r2/r3 = Heating elements
r4 = Sealing and cutting blade
s1 = Magnet
z1 = Buzzer

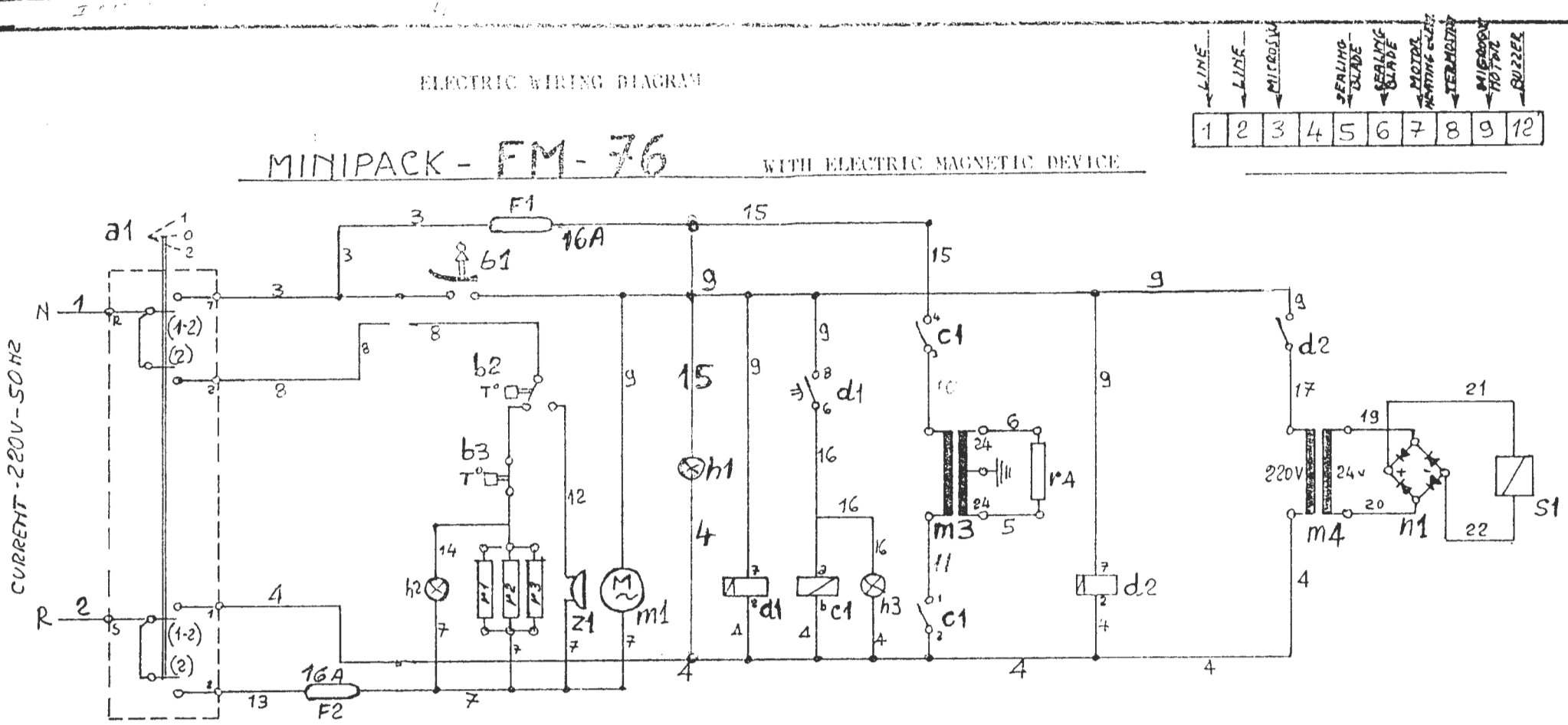
MINIPACK - FM 76

TAV. 8

ELECTRIC WIRING DIAGRAM

MINIPACK - FM - 76

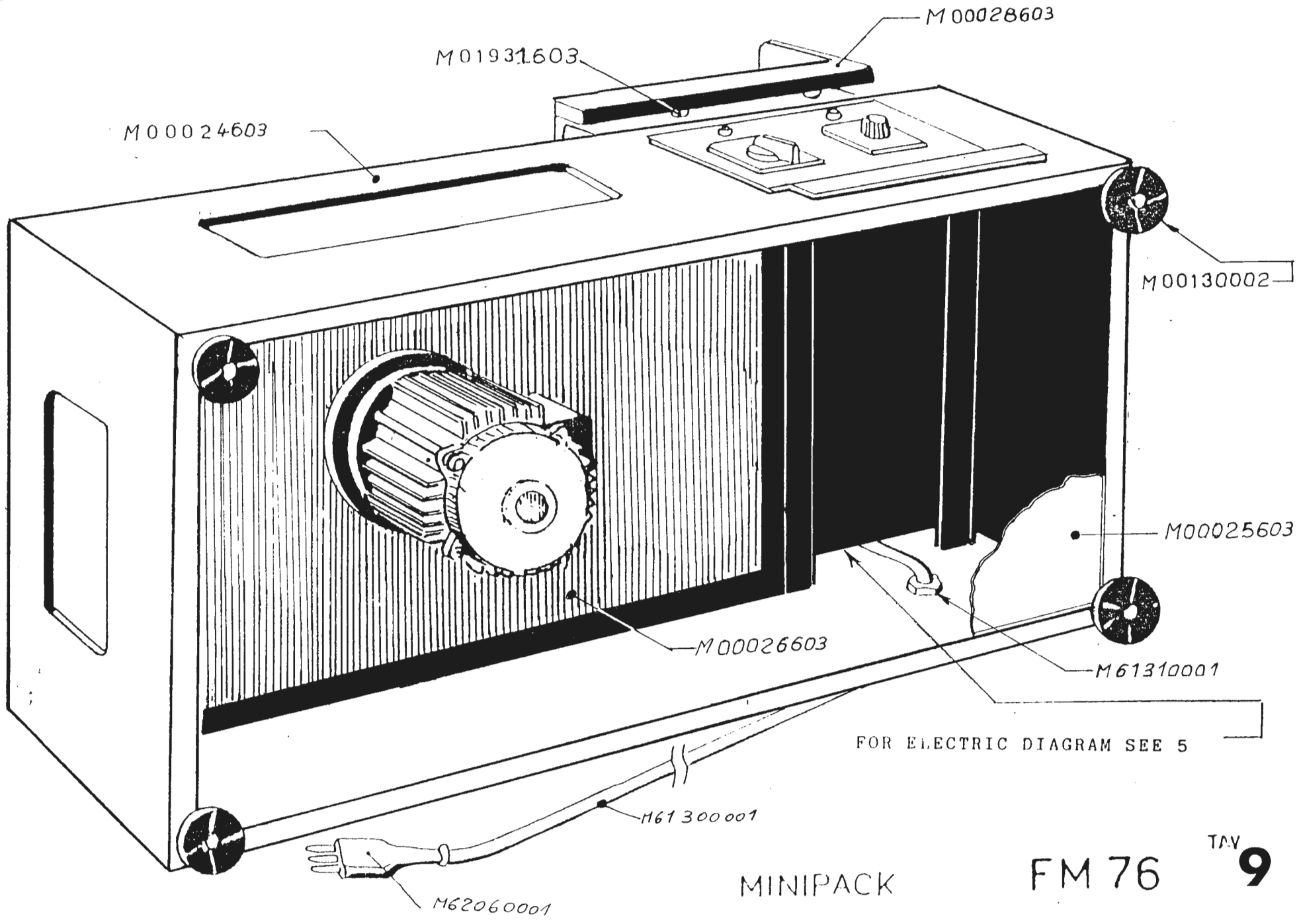
WITH ELECTRIC MAGNETIC DEVICE



AGENDA

a1 = Main switch
b1 = Microswitch
b2 = Heating security thermostat
b3 = Heating thermostat
c1 = Feeding relay m3
d1 = Sealing and cutting timer
d2 = Shrinking timer
f1 = Fuses 15A
f2 = Fuses 16 A
h1 = Machine switch in light
h2 = Heating elements light
h3 = Sealing and cutting light
m1 = Fan motor 1
m3 = Feeding transformer r2
m4 = Feeding transformer s1
n1 = Bridge for s1
r1/r2/r3 = Heating elements
r4 = Sealing and cutting blade
s1 = Magnet
z1 = Buzzer

MINIPACK - FM 76 TAV. 8



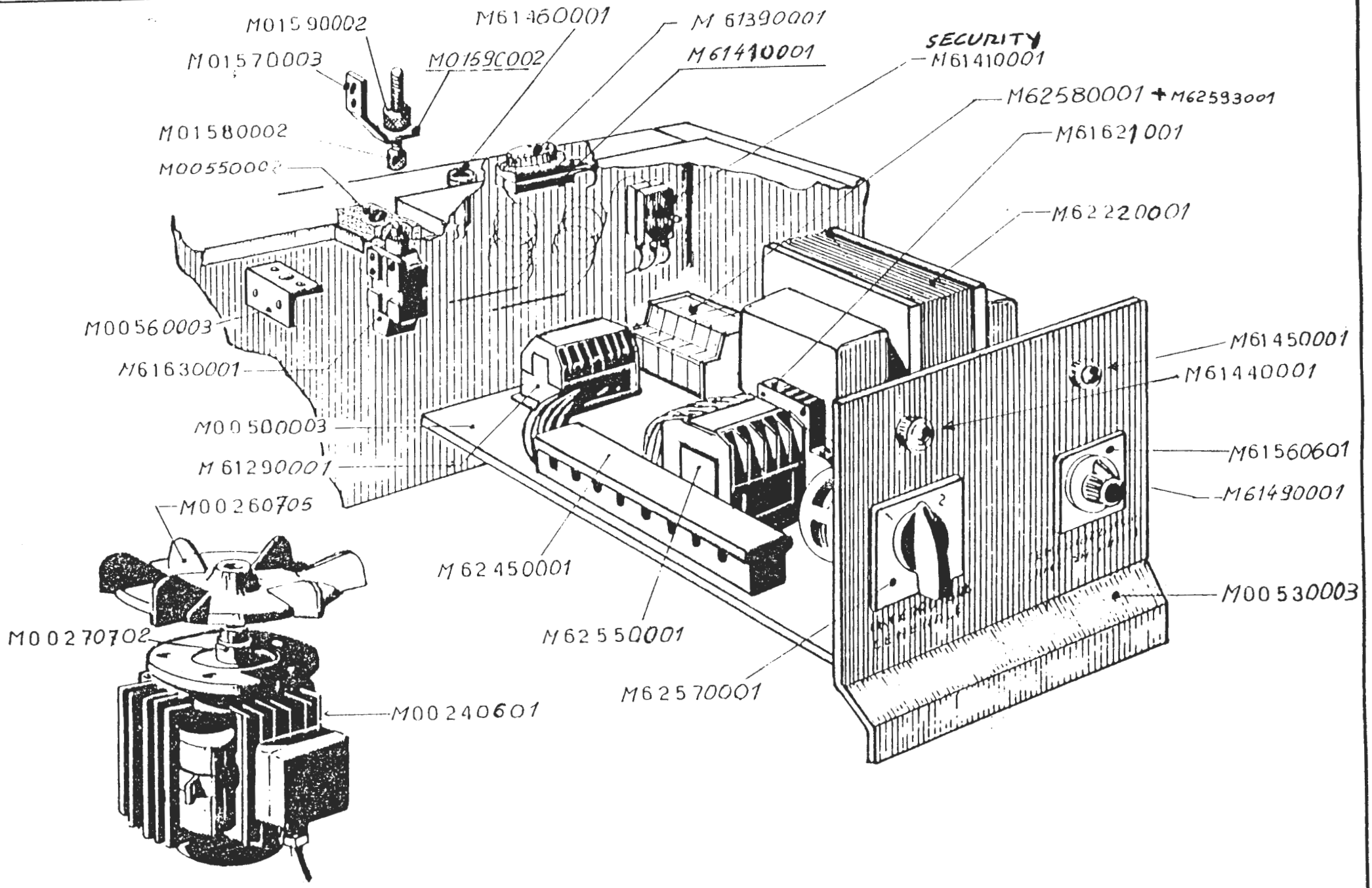
MINIPACK FM 76 TAV 9

MINIPACK RAS FM 76 I MACHINE

CODE No.	COMPONENT DESCRIPTION
- M00024603	CASING 76
- M00025603	CASING BOTTOM 76
- M00026603	CASING CHAMBER 76
- M00027603	HOOD FRAME 76
- M00028603	WORKING PLATFORM 76
- M00130002	ADJUSTABLE FEET
- M00150004	RUBBER GROMIT FOR BLADE CABLE
- M00240601	ELECTRIC MOTOR 76
- M00260705	FAN FOR MOTOR 76 A160
- M00270702	FAN BUSH 76
- M0027C602	GROUP FAN + FAN BUSH 76
- M00290601	HEATING ELEMENTS 76
- M00300003	HEAT. ELE. CONNECTING PLATE
- M00320003	HEAT. ELE. SUPPORT PLATE
- M00370603	HEAT. ELE. REAR PLATE 76
- M00380603	BOTTOM CONVEYOR VENTIL. 76
- M00411603	HEAT. ELE. FRONT PLATE 76
- M00431605	GLASS FIBRE PANEL INFILL 76
- M00434605	REAR PANEL ROCK WOOL 76
- M00435605	FELT FIBRE PANEL 76
- M00450603	ELEMENT LID 76
- M00460003	RIGHT ELE. CLAP BRACKET
- M00470003	LEFT ELE. CLAP SQUARE BRACKET
- M00490003	THERMOSTAT BULB U-BOLTS CLIP
- M00500003	COMPONENTS SLIDING BASE PLATE
- M00510603	FRONT SEALING BLADE PROTECTION 76
- M00520603	SIDE SEALING BLADE PROTECTION 76
- M00530003	FRONT BOX PLATE
- M00550002	MICRO ISOLATING BLOCK
- M00560003	BRACKET FOR MICROSWITCH
- M00580603	FRONT ALUMINIUM CHANNEL 76
- M00610603	SIDE ALUMINIUM CHANNEL 76
- M0061C603	GROUP FRONT/SIDE ALUM.CHANNEL 76
- M00621603	SIDE ALUMINIUM RUBBER CHANNEL 76
- M00622603	REAR ALUMINIUM RUBBER CHANNEL 76
- M0062C603	GROUP BOTTOM ALUMINIUM RUBBER 76
- M00750605	FRONT DOUBLE MILLING INFILL SEALING BAR 76
- M00751605	SIDE DOUBLE MILLING INFILL SEALING BAR 76
- M0075C605	GROUP DOUBLE MILLING INFILL SEALING BAR 76
- M00760004	NEOPRENE RUBBER 76
- M00770601	SEALING BLADE ELEMENT 76
- M00860002	SEALING BLADE TENSIONING SYSTEM
- M00870002	SEALING BLADE TENSIONING CLAMP
- M00880002	PISTON CLAMP ISOLATING BLOCK
- M00890002	SEALING BLADE TENSIONING SPRING
- M0089C002	GROUP TENSIONING SYSTEM
-	
-	
- M0091C002	GROUP ISOLATING BLOCK
- M00920004	TENSIONING SYSTEM RUBBER PROTECTION
- M00930603	ADJUSTABLE WORKING PLATFORM 76

- M00960603 WORKING PLATFORM REAR SUPPORT 76
- M00970603 WORKING PLATFORM FRONT SUPPORT 76
- M00980002 PLATE SUPP.KNURLED PIN
- M01190002 BUSH FOR FRAME HANDLE
- M01190605 FRAME HANDLE 76
- M01211605 PERSPEXT HOOD 76
- M01291603 FRONT/REAR METAL HOOD SEALS 76
- M01321603 SIDE METAL SEALS FOR HOOD 76
- M0132L603 GROUP METAL SEALS 76 HOOD
- M01350603 FRONT/REAR RUBBER CHANNEL 76
- M01380603 SIDE RUBBER CHANNEL SEAL 76
- M0138C603 GROUP CHANNELS FOR RUBBER 76
- M01400604 THIN P.T.F.E. TAPE 76
- M01401604 THICK P.T.F.E. TAPE 76
- M01420602 PLASTIC HOOD TORSION BAR 76
- M01440602 STOP FLANGE FOR TORSION BAR 76
- M01460002 ROTATION PLASTIC HOOD PIN
- M01490602 GUIDE PIPE FOR TORSION BAR 76
- M01510003 HINGE BRACKET FOR PLASTIC HOOD
- M01531002 TORSION BAR REGULATION HOLDER
- M0153L602 GROUP TORSION BAR 76
- M01541003 HOOD SHOCK ABSORBER BRACKET
- M01550004 HOOD SHOCK ABSORBER
- M0155L002 GROUP ABSORBER BRACKET
- M01560003 ELEMENT LID LEVER
- M01570003 BRACKET FOR MICROSWITCH SENSOR
- M01580002 MICROSWITCH SENSOR
- M01590002 SENSOR RING NUT
- M0159C002 GROUP MICROSWITCH SENSOR
- M01660001 24 V. C.C. ELECTROMAGNET
- M01690002 ELECTROMAGNET CONTACT PLATE
- M01890603 FILM OPENER 76
- M01931603 PLATFORM SLIDE ROD FRAME 76
- M0193C603 GROUP WORKING PLATFORM 76
- M02010603 FILM REEL SUPPORT CARRIAGE 76
- M02040602 SLIDING TRACK WITH BEARING 76
- M02060602 FILM REEL SUPPORT ROLLER 76
- M02080002 PAIR OF FILM ROLL CENTERING BLOCKS
- M0208C602 GROUP FILM SUPP.+ BLOCK 76
- M02120002 MICRO PERFORATOR WHEEL WITH NEEDLES + COMPASS
- M02130002 PERFORATOR WHEELS WITH GROOVE + COMPASS
- :
- M03520003 MICROPERFORATOR BRACKET
- M03560602 PERFORATOR SUPPORT ROD 76
-
- M0357C602 GROUP MICRO PERFORATOR 76
- M61290001 ELECTRIC CONNECTION CLAMP
- M61300001 ELECTRIC CABLE
- M61310001 CABLE PRESS
- M61390001 THERMOSTAT HANDLE
-
- M61410001 NORMAL AND SECURITY THERMOSTAT
- M61440001 WHITE NION SIGNAL LIGHT
- M61450001 GREEN NION SIGNAL LIGHT
- M61460001 YELLOW LAMP
- M61490001 OCTAL FOR TIMER

- M6149C001	KIT OCTAL CABLE FOR MAGNET
- M61500001	6 SEC. TIMER
- M61560601	1.6 SEC. TIMER 76
- M61621001	BUZZER FOR THERMOSTAT
- M61630001	MICROSWITCH
- M61730001	BRIDGE RECTIFIER
- M62060001	PLUG FOR 3 CORE CABLE
- M62220001	T2 TRANSFORMER 76
- M62260001	T3 TRANSFORMER (MAGNET)
- M62450001	PLASTIC RACEWAY WIRE BOX
- M62550001	SOLENOID STARTER 76
- M62570001	TWO POLE MAIN ON/OFF SWITCH
- M62580001	FUSES CHAMBER
- M62593001	16 AMP. FUSES
- M6260C001	COMPLETE CONTROL ELE. PANELS 76



MINIPACK FM 76

TAV 5

PATENTED