



IMPULSE AUTOSEALER

FOR PE & PP BAGS ONLY

TISA-452.602.455.605

OPERATING INSTRUCTION

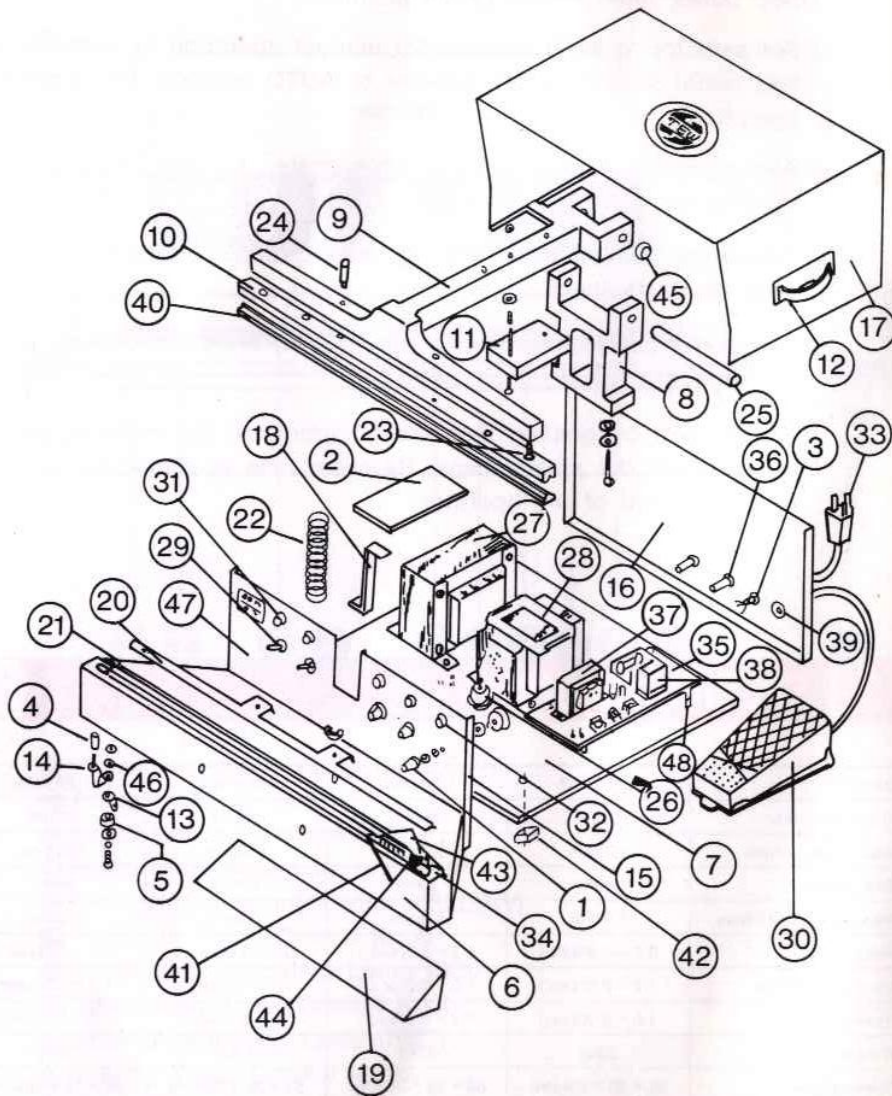
THANK YOU VERY MUCH FOR YOUR PURCHASE OF **TEW** IMPULSE AUTOSEALER. THIS PRODUCT WAS DESIGNED FOR CONVENIENCE AND PERFORMANCE. PLEASE READ THE FOLLOWING INFORMATION BEFORE USE.



TEW ELECTRIC HEATING EQUIPMENT CO., LTD.



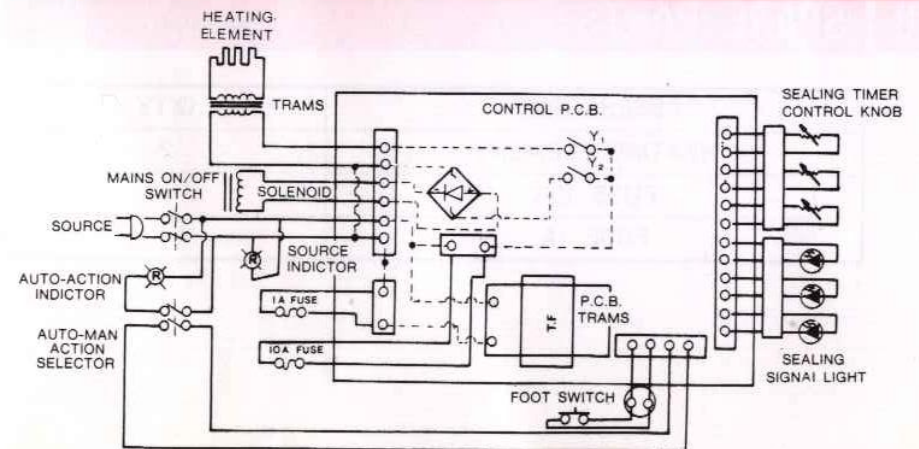
4 CONSTRUCTION DIAGRAM



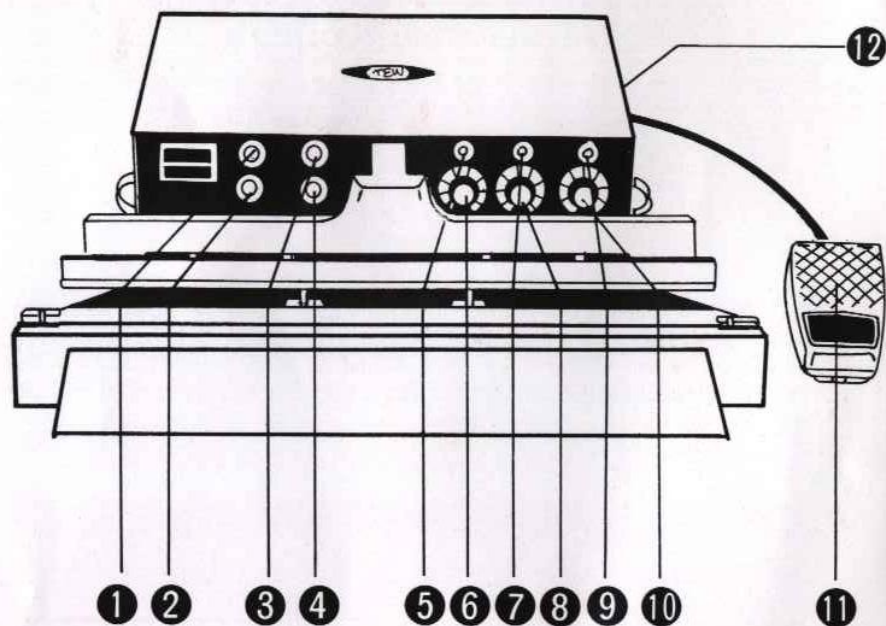
5 PARTS LIST

- | | |
|-----------------------|------------------------|
| ① TIMER KNOB | ⑲ OPERATING BOARD |
| ② PLASTIC PLATE | ⑳ CLIP FOR CLOTH |
| ③ BUSHING | ㉑ SCREW FOR CLOTH |
| ④ BAKELITE PIPE | ㉒ RETURN SPRING |
| ⑤ CONVEX BAKELITE | ㉓ SPRING FOR UPPER JAW |
| ⑥ LOWER JAW | ㉔ SCREW FOR UPPER JAW |
| ⑦ BASE PLATE | |
| ⑧ HINGE BRACKET | ㉕ HINGE PIN |
| ⑨ UPPER JAW | ㉖ SPRING BRACKET |
| ⑩ UPPER JAW SUPPORT | ㉗ TRAMS FORMER |
| ⑪ FLAT PLATE | ㉘ SOLENOID |
| ⑫ HANDLE STRAP | ㉙ TOGGLE SWITCH |
| ⑬ BRASS CONTACT | ㉚ FOOT SWITCH |
| ⑭ TENSION SPRING | ㉛ SIGNAL LIGHT |
| ⑮ FRONT PLATE | ㉜ LED LIGHT |
| ⑯ BACK PLATE | ㉝ POWER SUPPLY CORD |
| ⑰ TOP COVER PLATE | ㉞ HEATING ELEMENT |
| ⑱ SPRING LEVER | ㉟ CONTROL-PCB |
| ⑳ OPERATING BOARD | ㊱ FUSE BRACKET |
| ㉑ CLIP FOR CLOTH | ㊲ PCB- TRAMS FORMER |
| ㉒ SCREW FOR CLOTH | ㊳ RELAY |
| ㉓ RETURN SPRING | ㊴ CONNECTOR FOOT PEDAL |
| ㉔ SCREW FOR UPPER JAW | ㊵ RUBBER PRESSURE PAD |
| | ㊶ RUBBER STRING |
| | ㊷ RUBBER FOOT |
| | ㊸ UPPER BARRIER TAPE |
| | ㊹ BOTTOM BARRIER TAPE |
| | ㊺ PIN WASHER |
| | ㊻ INSULATION WASHER |
| | ㊼ CONTROL PANEL |
| | ㊽ PCB SUPPORT |

6 CONNECTION DIAGRAM



1 INSTRUCTION BOOKLET



- ① Power Indicating Lamp (YELLOW)
- ② Power Main Switch
- ③ AUTO-Action Lamp (WHITE)
- ④ AUTO-MAN Action Selector
- ⑤ Re-Cycle Indicating Lamp (YELLOW)
- ⑥ Re-Cycle Timer Control Knob
- ⑦ Congealing Indicating Lamp (RED)
- ⑧ Congealing Timer Control Knob
- ⑨ Sealing Indicating Lamp (RED)
- ⑩ Sealing Timer Control Knob
- ⑪ Foot Pedal Switch
- ⑫ Fuse

2 OPERATING INSTRUCTION

- ① Set power main switch to ON position.
- ② Set selector to MAN position for manual operation by pressing the foot pedal switch, or set selector to AUTO position for automatic operation.
- ③ Adjust the re-cycle time knob, appropriate to the frequency of continuous work.
- ④ Adjust the sealing time (heating time) knob, appropriate to the thickness of plastic bag.
- ⑤ Adjust the congealing time (pressing time) knob, appropriate to the thickness of seal (to be cooled).

* Sealing and congealing time are according to the material and thickness of the plastic bags. Re-cycle time is according to the working speed of the operator.

3 SPECIFICATIONS:

Model	TISA-452	TISA-602	TISA-455	TISA-605
Impulse Power	600W	800W	1000W	1300W
Max. Seal Length	450mm	600mm	450mm	600mm
Seal Width	2mm	2mm	5mm	5mm
Max. Seal Thickness	1.0mm	1.0mm	1.0mm	1.0mm
Heat Time	0.2~3.0(sec.)	0.2~3.0(sec.)	0.2~3.0(sec.)	0.2~3.0(sec.)
congealed Time	1.0~8.0(sec.)	1.0~8.0(sec.)	1.0~8.0(sec.)	1.0~8.0(sec.)
Reset Time	1.0~8.0(sec.)	1.0~8.0(sec.)	1.0~8.0(sec.)	1.0~8.0(sec.)
Weight	20kg	22kg	21kg	23kg
Dimensions	53 × 36 × 20(cm)	68 × 36 × 20(cm)	53 × 36 × 20(cm)	68 × 36 × 20(cm)

7 ADDITIONAL INFORMATION

- Always keep the sealing platform clean. Particular care should be taken to remove any residue from overheated plastic from the barrier tape.
- Do not clean the sealing platform with anything wet.
- If the bottom barrier tape, (under the heating element) becomes worn, the heating element may short to earth, and this can damage the element.
- When replacing a heating element always check the condition of the bottom barrier tape. It is also important that, when replacing a heating element, if genuine spares are not available, only thermo-electric wire of an identical specification (resistivity)
- After a long period of use the condition of the top pressure pad should be examined for wear. Obviously any deformation will affect the quality of the weld and replacement may become necessary.

8 SPARE PARTS

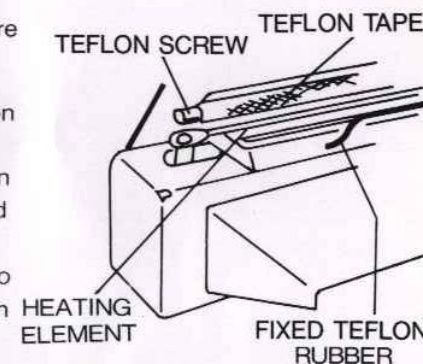
ASSESSORIES	Q'TY
HEATING ELEMENT	2
FUSE 10A	1
FUSE 1A	1

9 METHOD OF EXCHANGING SUBSIDIARY PARTS

To replace the seal parts disused in case of heater consumed, please refer to followings:

1. Be sure to turn off the power before replacing.

- ① Release fixed teflon rubber, teflon clip.
- ② Pull out the teflon tape, cut down the remainder, then, fix rubber and tape.
- ③ Fix teflon screw, then, it must to be rotated, pull tightly the teflon tape and fix teflon clip.



2. Method of replace heating element

- ① Release teflon clip.
- ② Heater's pole must be enclosed to inner side in order to release the heating element.
(Heater's pole is tightened by at two end)
- ③ After replace the heater, please fix the teflon tape according to the previous method.

