

TROUBLESHOOTING:

Why Does the Heating Element Break? Or Break Frequently?

REASONS THE HEATING ELEMENT BREAKS:

- After using the sealer for 1000 to 5000 seals, it is normal for the heating element to break. The number is dependent on the timer setting. Thicker material requires a higher timer setting, which will thereby decrease the number of seals.
- The sealer's PTFE adhesive serves as a barrier between the heating element and the sealer's body. When the sealer's heating element has burned through the bottom PTFE adhesive and arced on the sealer's body, the heating element will break. Once the heating element comes in contact with the sealer's body, the heating element will break and can also destroy the timer.
- When replacing the heating element, you must also replace the bottom PTFE adhesive. When a user does not do this, the heating element will break earlier than usual. (When replacing the PTFE adhesive, it is very important that the PTFE adhesive should extend $\frac{1}{4}$ " to $\frac{1}{2}$ " past the machine on both ends. Bend down the excess adhesive. This is to prevent the heating element from coming in contact with the sealer's body.)

Note:

**If the top PTFE cover is worn, it should be replaced. The top PTFE cover is used to prevent the thermoplastic material being sealed from sticking to the heating element.*

**The silicone rubber in the upper handle is the pressing lip which applies pressure to the bag to give a nice smooth seal. If the silicone rubber has any burned marks, is worn out, or has an uneven surface, the appearance of the seal will be affected. If this case, it is advisable to replace the silicone rubber.*

Important questions to ask the operator if the heating element has to be changed too frequently.

1. Is the operator changing out the heating element and the bottom PTFE adhesive after the heating element breaks each time?

If the operator is only changing the element, then the new element will break immediately or shortly thereafter. Always replace the element and bottom PTFE adhesive.

2. What is the timer setting on the sealer?

If the timer is set higher than is needed to seal the bag, then the heating element will break and the PTFE adhesive will be damaged as well. Always start with the lowest setting on the time and then gradually increase the heat. Use trial and error until you find the lowest setting that will seal the bag.

3. Is the operator of the sealer using the flat ribbon heating element to seal and cut through the thermoplastic material (cut and seal), thereby using a high timer setting?

A round element is advisable for this application and it is available.

We recommend the purchase of a Replacement Parts Kit for all sealers. The kit includes all the necessary parts for the maintenance of your sealers. It is the most economical way to maintain your sealer. We sell the kit at a tremendous discount.

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