AUDION

Packaging machines

User Manual

www.audion.com

All-In Sealer

D 545 AH-2

D 545 AH-2 ENG Rev.01

Please read this operating manual carefully before using the sealer or carrying out maintenance on it.

The sealer is part of the Audion product range. We also provide:

- Impulse sealers.
- Heat sealers.
- Continuous sealers.
- Vacuum sealers.
- Vacuum chambers.
- Shrink machines.
- Validatable sealers.
- Form, fill and seal machines.

Since its inception in 1947, Audion has gained a lot of experience and expertise with a wide variety of sealing and packaging machines. Our solutions for packaging problems are unique. Our many years of experience together with our modern production, assembly and testing methods ensure that our packaging machines meet the highest quality standards. We can also customise the machines according to your specific requirements.

Audion is the right supplier for a packaging machine that is geared to your requirements.

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1 Introduction

1.1 Manufacturer

The sealer was manufactured by:

Audion Packaging Machines BV
Hogeweyselaan 235
1382 JL Weesp
The Netherlands

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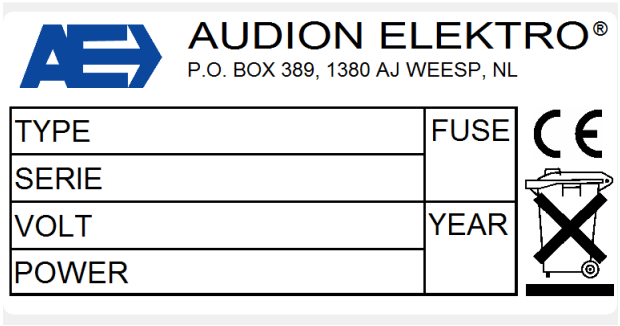
Fax:	+31 (0)294 491761

Email:	Export@audion.nl
Web:	www.audion.com

1.2 Machine Type Plate



The sealer has a CE marking. This means that the sealer meets the fundamental health and safety requirements of the European Communities.

1.3 Warranty Conditions and Liability

Subject to the limitations stated below, we provide a 12-month warranty for the products we deliver. This warranty is limited to manufacturing defects and therefore does not cover any malfunctions caused by any form of wear, or any part of the delivered product that is subject to wear.

- The warranty we provide for parts or accessories purchased from third parties is limited to the warranty the third-party provided to us.
- The warranty is void if the other party and/or any third parties engaged by them use the product in a way it is not intended for.
- The warranty is also void if the other party, and/or any third parties engaged by them carries out work and/or modifications on the delivered product.
- Any parts we replace in order to meet our warranty obligations become our property.
- Should the other party not meet obligation resulting from the agreement entered into between the parties in whole or in part or in a timely manner, we are not obliged to provide warranty for as long as that situation continues.

We exclude all liability to the extent that the liability is not regulated by law. Our liability will never exceed the total amount of the order in question.

Subject to the generally applicable legal rules of public order and good faith, we are not obliged to pay compensation to the other party or any third party for damages of any nature whatsoever, incurred directly or indirectly, including trading loss and damage to movable or immovable property or persons.

In no case are we liable for any damage resulting from or caused by using the delivered product or its unsuitability for the purpose for which the other party purchased it.

2 Safety

2.1 Symbols Used in This Manual

The following symbols are used in this user manual:

A tip on how a task can be carried out more efficiently.

Instructions for carrying out a task in the correct manner.

Danger of injury to the user or damage to the sealer if the instructions are not observed.

2.2 User

The sealer should only be operated by authorised personnel.

Improper use of the sealer may lead to serious personal injury and considerable material damage.

Keep bystanders at a distance. Do NOT allow unauthorised personnel to operate the sealer.

2.2.1 Operating Personnel

The company using the machine has organised a training session to inform its operating personnel of the potential risks of unprofessional behaviour while carrying out their tasks.

Installation, maintenance and repair require specialised knowledge, which is why these tasks should only be performed by maintenance personnel.

Observe the safety instructions in this user manual. Failure to observe the safety instructions may cause unacceptable risks.

The operating personnel must be familiar with all chapters of this user manual with the exception of ‘Installation’ and ‘Maintenance’. Always observe the following safety instructions before using the sealer or carrying out any maintenance work.

2.2.2 Maintenance Personnel

These personnel’s professional training, knowledge and experience, and knowledge of the manufacturer’s terms enable them to carry out the assigned work and immediately recognise any risks that may arise.

Observe the safety instructions in this user manual. Failure to observe the safety instructions may cause unacceptable risks.

The maintenance personnel must be familiar with all chapters of this user manual. Always observe the following safety instructions before using the sealer or carrying out any maintenance work.

2.3 Safety Instructions

The sealer meets the fundamental health and safety requirements of the European Community. This means that the sealer can be operated and maintained safely if all safety instructions are carefully observed. However, improper or careless use can create dangerous situations.

Observe the safety instructions in this user manual. Always remain alert to dangerous situations and avoid any improper or careless use.

2.3.1 General Safety Instructions

Observe the following general safety instructions:

- Tie back long hair.
- Do not wear loose clothing or jewellery.

- Always wear the personal protective equipment (PPE) prescribed by the company, such as safety shoes, gloves and goggles.

Use the PPE required on the shop floor, such as safety shoes, gloves and goggles and/or hearing protection, in particular when carrying out maintenance work.

- Check the operation of the sealer every day.
- Keep your hands away from dangerous parts of the sealer.
- Always leave protective covers in place during production.
- Never bypass or deactivate any safety provisions.
- The sealer should never be operated or maintained by people who are under the influence of alcohol, medication and/or drugs.
- Only use sealable material that is suitable for the sealer.
- The user is obliged to observe the normally applicable hygienic measures.
- If you are not sure whether the sealer is working properly, switch it off immediately and consult the maintenance personnel.
- Both the user and the sealer must be supervised while the sealer is in use.
- Do not switch the sealer back on until the malfunction has been repaired.
- Should any liquid or foreign object enter the machine, switch off the sealer and immediately remove the plug from the wall socket and have the sealer checked by maintenance personnel before using it again.
- Should an unusual event occur, such as the development of smoke, remove the plug from the socket immediately and have the sealer checked by maintenance personnel before using it again.

- Remove the plug from the socket before carrying out any maintenance work.
- Never open the sealer's housing while it is connected to the mains power.
- Do not use any water, abrasive cleaning agents, chemical solvents or other liquids when cleaning the sealer.

2.3.2 What to do in case of Fire

NEVER use water to extinguish a fire. This may result in life-threatening situations because the sealer may be electrically live.

Should the sealer catch fire, never use water to extinguish the fire. Because the machine is live, this may result in life-threatening situations. A fire extinguisher must be within reach when the sealer is in use. The following types of fire extinguishers are suitable to extinguish a burning sealer.

- Powder extinguisher.
- Foam extinguisher.

2.3.3 Use for Special Applications

If the machine is used in a special environment, the company using the machine must ensure that any instructions specific to that environment are observed.

- If the machine is used in a sterile environment or cleanroom, the company using the machine must ensure that any instructions specific to that environment are observed.
- If the machine is used for the packaging of medical instruments, the company using the machine must ensure that any instructions specific to that environment are observed.
- If the machine is used for the packaging of food, the company using the machine must ensure that any instructions specific to that environment are observed.

2.4 Safety Provisions

The sealer has the following safety provisions:

1. Safety covers.
   - Electrical and mechanical parts in the housing are protected. The safety covers are equipped with a microswitch that switches off the sealer if the cover is opened.
2. Metal parts are earthed.
   - No dangerous voltage can develop between (external) metal parts and the earth.
3. Fuse in 230 V circuit.
   - If the maximum current is exceeded, the fuse will blow, cutting off the power supply.
4. Emergency stop button
   - In the event of a hazard, this can be used for switching off the sealer immediately and completely.

2.5 Safety symbols

The following safety symbols have been applied on the All-In Sealer:

Hot surfaces
On the front of the All-In Sealer on the cover. There are heating elements and it may therefore get hot.

3 Installation

3.1 Unpacking the Sealer

Check the following when unpacking the sealer:

1. Have all parts and accessories been delivered?
   - Sealer
   - User manual
   - Power cord

The sealer is packaged in environmentally friendly material that may be disposed of as ordinary household waste.

Keep the crate and the packaging material so that the sealer can be transported safely again if necessary.

3.2 Connecting the Sealer

1. Check that the main switch is in the ’0’ position.

2. Insert the plug in the wall socket.

3.3 Adjusting the Sealer

The following adjustments can be made:

- The height of the conveyor belt with respect to the sealing unit; to adjust for the height of the bags.
- The horizontal distance between conveyor belt and sealing unit; to adjust for the positioning of the bags on the conveyor belt.

3.3.1 Adjusting the Conveyor Belt Height

The conveyor belt height can be adjusted with respect to the sealing unit as follows:

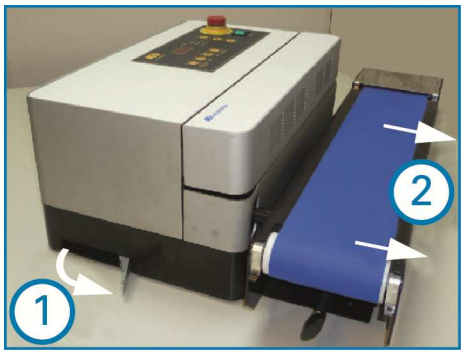
1. Set the height of the conveyor belt using the turning knob.

The conveyor belt height must be set to roughly half the thickness of the packages that are to be sealed.

3.3.2 Adjusting the Horizontal Distance for the Conveyor Belt

The horizontal distance of the conveyor belt with respect to the sealing unit is adjusted as follows:

1. Loosen the leaver.
2. Adjust the horizontal position of the conveyor belt by shifting the conveyor belt.
3. Tighten the leaver.



The positions of the sealing unit and conveyor belt must be set so that the bags that are to be sealed are in the middle of the conveyor belt.

3.3.3 Adjusting the Infeed Guide

To adjust the position of the seal, the infeed guide can be adjusted with respect to the sealing unit as follows:

1. Loosen the screw with the black knob.
2. Adjust the horizontal position of the infeed guide.
3. Fasten the screw.

4 Description of the Sealer

4.1 Function

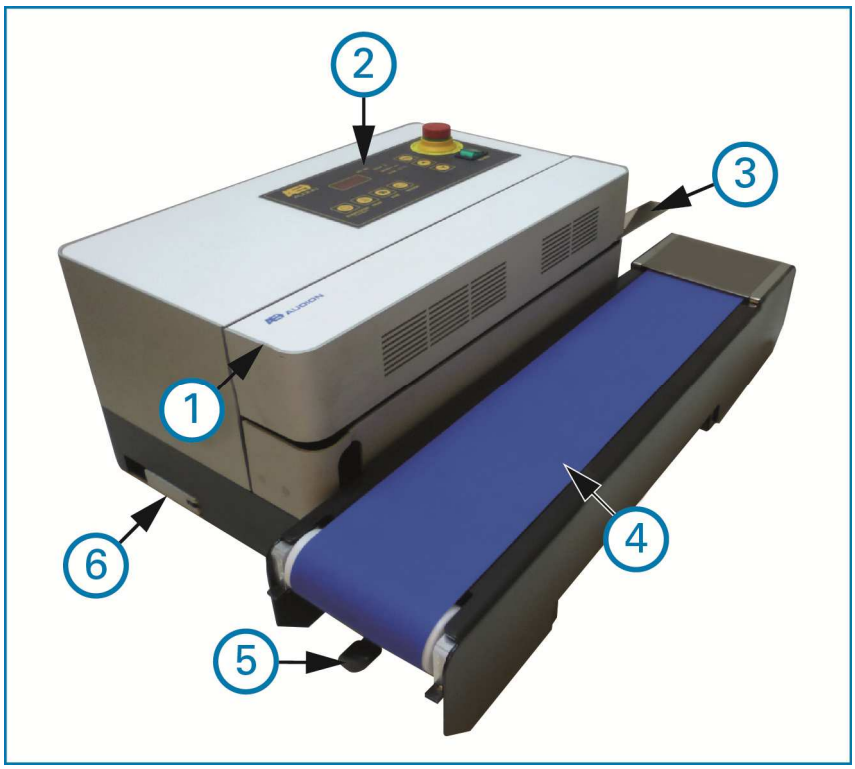
The All-In Sealer is a band sealer for packaging a wide variety of products in large quantities. The products are packaged in ready-to-use bags and then sealed. The sealer can be used for sealing ready-made bags made of polyethylene (PE), polypropylene (PP), thin PVC and various laminates with thicknesses of between 20µm and 150µm.

Never use the All-In Sealer for any other purpose.

The sealer is not suitable for the following applications:

- use in cleanroom environments
- use in medical or sterile environments
- use in explosive environments
- use with toxic, suffocating or irritant gases
- use in dusty environments

4.2 Overview of the Sealer



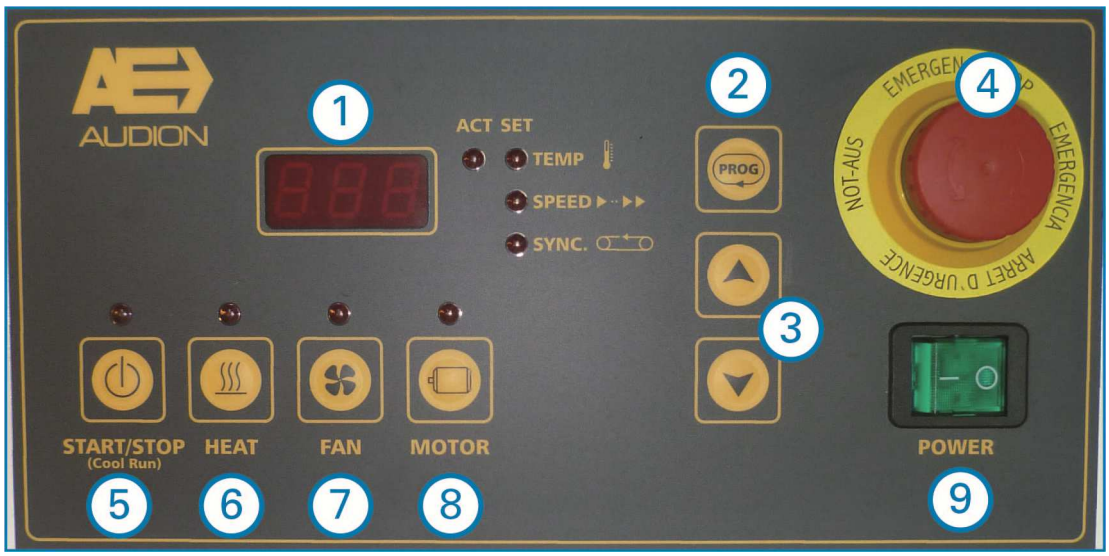
1. Protective cover
2. Control panel
3. Infeed guide with locking screw for adjustment
4. Conveyor belt
5. Height adjustment conveyor belt
6. Setting the distance of the conveyor belt with respect to the sealing unit

The sealer is a table top model with a conveyor belt attached to the housing. The housing comprises the electrical and drive components; the operating panel is mounted in the top of the housing.

The conveyor belt transports the bags that are to be sealed past the heating blocks, the cooling plates and the after-press rollers that are located inside the housing.

The vertical distance between the conveyor belt and the housing can be adjusted so that bags of various different heights can be sealed. The horizontal position of the conveyor belt with respect to the sealing unit can be adjusted to position the bags as centrally as possible on the conveyor belt.

4.3 Control Panel



1. Display — Gives the current sealing temperature, speed or an error message. The setpoint value will be shown while the settings are being adjusted.
2. Prog — Press this to change the settings menu of the sealer. A LED next to the button will show which setting is being adjusted:
   Temp, the sealing temperature.
   Speed, the conveyor belt speed.
3. Up/Down — Press these to increase or reduce a setting.
4. Emergency stop button — If a dangerous situation occurs, this will switch off the sealer immediately and completely.
5. Start/Stop — Press to start or stop the sealer. A LED above the button shows whether the sealer is switched on or off. If the current sealing temperature is above 80°C when the sealer is switched off, it will first switch to ‘cool run’ mode.
6. Heat — Press this to switch the heating on or off. A LED above the button indicates whether the function is switched on or off.
7. Fan — Press this to switch the fan on or off. A LED above the button indicates whether the function is switched on or off.
8. Motor — Press this to switch the motor on or off. A LED above the button shows whether the function is switched on or off.
9. Main switch — Switch for turning the sealer on or off.

4.3.1 Cool Run mode

The ‘cool run’ mode avoids burnt spots on the PTFE belts. After the machine has been stopped, the heater is switched off; however, the fan and the motor will continue to run. When the sealing temperature has dropped below 80°C, the sealer is switched to standby mode. The fan and the motor will then also be switched off.

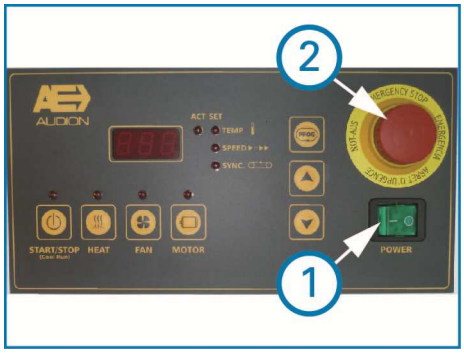
5 Operation

5.1 Preparing the Sealer for Production

5.1.1 Switching on the Sealer

Switch the sealer on as follows:

1. Set the MAIN SWITCH to ’1’.
2. Turn the EMERGENCY STOP BUTTON clockwise if necessary to reset it.



Put the plug in the socket first if necessary.

5.1.2 Setting the Sealing Temperature and the Conveyor Belt Speed

The sealing temperature and conveyor speed can be adjusted as follows:

1. Press the PROG button until the TEMP LED is lit.
2. Press the ARROW keys to raise or lower the sealing temperature.

The guideline sealing temperature is 100°C

3. Press the PROG button until the SPEED LED is lit.
4. Press the ARROW button to increase or reduce the speed of the conveyor belt.

The guideline value for the conveyor belt speed is 50.

5. Press the PROG button until the current sealing temperature is shown in the display again.

The TEMP LED will blink if the setpoint temperature differs from the current sealing temperature by more than 5°C.

5.1.3 Switching on the Heating, the Motor and the Fan

Switch on the heating, the motor and the fan as follows:

1. Press the HEAT button.
2. Press the MOTOR button.

The heating and the transport motor must always be switched on before use.

When the heating element is warming up the transport mechanism (Motor) must be running to prevent burnt spots on the PTFE belts.

3. Press the FAN button if necessary.

If a paper or aluminium laminate film is being used, the FAN does not have to be switched on.
Do be sure to switch on the fan when using PE films.

5.1.4 Starting the Sealer

Start the sealer as follows:

1. Press the START/STOP button.
2. Wait until the TEMP LED has stopped blinking.

The sealer has now reached the set temperature and is ready for sealing.

Make a number of trial seals and readjust the sealing temperature and speed as necessary.

5.2 Sealing

Bags are sealed as follows:

1. Place the bags on the conveyor belt and guide the bag into the infeed guide.

Make a number of trial seals first to check that the settings are correct. Adjust the sealing temperature and conveyor belt speed as necessary.

5.3 Stopping the Sealer (STANDBY mode)

The sealer can be stopped and put in Standby mode after use as follows:

1. Press the START/STOP button.

The sealer now switches to Standby mode and the display shows "---".
If the sealing temperature is above 80°C, the sealer will first switch to COOL RUN mode. The heating is switched off and the fan and motor continue to run until the sealing temperature has dropped to below 80°C. The display will alternate between "c-r" and the current sealing temperature.
The sealer is then switched to STANDBY mode.

If the sealer is not going to be used for a lengthy period, it is better to turn it off completely using the MAIN SWITCH.

5.4 Emergency stop

In the event of an emergency, switch the sealer off completely as follows:

1. Press the EMERGENCY STOP BUTTON.

In emergency situations, always use the emergency stop button immediately. Do not use the emergency stop button to switch off the sealer under normal circumstances.

5.4.1 Restarting After an Emergency Stop

The sealer can be restarted after an emergency stop as follows:

Make sure that whatever caused the emergency stop has been corrected before restarting the sealer.

1. Turn the EMERGENCY STOP BUTTON clockwise to reset it.
2. Press the START/STOP button.

The sealer is now ready to be used again. The 'TEMP' LED may possibly be blinking; in that case, the sealer has to heat up again first.

5.5 Switching Off the Sealer Completely

The sealer can be switched off completely as follows:

1. Set the MAIN SWITCH to '0'.

Make sure that the sealer is in Standby mode before it is switched off completely (see 'Stopping the Sealer (STANDBY mode)').

6 Troubleshooting

Troubleshooting may only be performed by authorised maintenance personnel.

In the event of a malfunction, always remove the plug from the socket before attempting to solve the problem.

If the problem cannot be solved using the following troubleshooting table, please contact your dealer or Audion.

Problem	Cause	Solution
The sealer does not do anything.	The main switch is set to '0'.	Switch the sealer on.
	The plug is not inserted into the wall socket or has not been inserted properly.	Put the plug in the socket properly.
	The power has been cut.	Check the power supply.
	The emergency stop button has been pressed.	Reset the emergency stop button.
	Internal fault.	Contact your dealer or Audion.
The seal is not neat and tidy.	The sealing temperature is not set correctly.	Readjust the sealing temperature.
	The conveyor belt speed is not set correctly.	Readjust the conveyor belt speed.
	The heating blocks and/or the PTFE belts are dirty.	Clean the heating blocks and/or the PTFE belts.
	The seal is not being cooled properly.	Switch the cooling on.
	The heating block, the cooling plate and/or the press rollers are still raised.	Put the heating block, cooling plate and/or press rollers back in the lowest position.
	The PTFE belts are worn.	Replace the PTFE belts.
The cooling is not working	The fan is not on.	Switch the fan on.
	The cooling plate position is too high.	Adjust the cooling plate correctly.
	Internal fault	Contact your dealer or Audion.
Error code E1	Incorrect frequency setting (50 Hz or 60 Hz - PCB jumpers.	Check the main frequency and set the PCB jumpers correctly.
Error code E2	Loose wire to the temperature sensor (Pt100).	Check the connections in the temperature sensor wiring (Pt100).
Error code E3	Short circuit in the temperature sensor (Pt100).	Replace the temperature sensor (Pt100).
Error code E13	The protective cover is open, or has been open.	Close the protective cover and press start / stop.
The conveyor belt is not moving.	The speed is set to '0'.	Set the speed higher.
	Internal fault.	Contact your dealer or Audion.

7 Maintenance

Maintenance should only be performed by authorised maintenance personnel.

Always remove the plug from the socket before carrying out any maintenance work.

Do not use any water, abrasive cleaning agents, chemical solvents or other liquids when cleaning the machine.

The maintenance schedule is based on normal use. The frequency of maintenance must be increased if the machine is used intensively, or under extreme conditions.

Always keep a log of all maintenance work. An example is provided as an annex.

7.1 Maintenance Schedule

7.1.1 Daily maintenance

Daily maintenance should be carried out by the operating personnel (see Foreword)

Part	Work
PTFE belts	Check that the PTFE belts are clean. Clean with a damp cloth if necessary.
Heating blocks	Check that the heating blocks are clean. Clean with a damp cloth if necessary.

7.1.2 Weekly maintenance

Weekly maintenance should be carried out by authorised maintenance staff (see Foreword).

Part	Work
Drive	Check the rotating parts and chains. Lubricate as necessary.
V-belts	Check the V-belts for cracks and check the tension.
Conveyor belt	Check the conveyor belt for cracks and check its tension.
Cleaning	Clean the sealer with a damp cloth and mild soap (for example, all-purpose cleaner).

7.1.3 Annual maintenance

Annual maintenance should be carried out by authorised maintenance staff (see Foreword).

Part	Work
Earthing system	Check that the earthing complies with NEN 3140 or EN 50110-1.

7.2 Switching Off the Sealer and Opening the Protective Cover

Open the protective cover as follows:

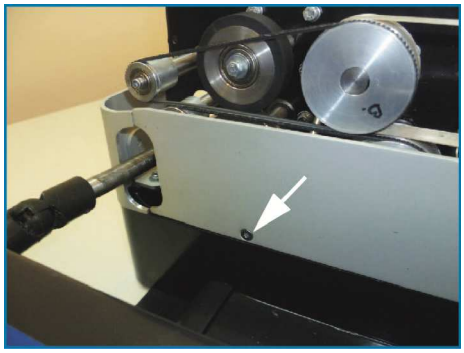
1. Set the main switch to ’0’.
2. Remove the plug from the socket.

Never carry out maintenance on the All-In Sealer while it is live.

3. Remove the screw with the black knob and the infeed guide.
4. Remove the two screws at the back.
5. Slide the protective cover to the rear.
6. Adjust the horizontal position of the conveyor belt, so that it is as far away from the sealer as possible.

7. Remove the two screws and the exit guide plates.

8. Remove the screw at the front.



9. Remove the two screws on the inside.
10. Carefully remove the larger cover.

11. Remove the two screws on the inside.
12. Carefully remove the smaller cover.

Warning! The heating blocks may still be hot, even if the sealer has been switched off for a while.

7.3 Replacing the PTFE Belts

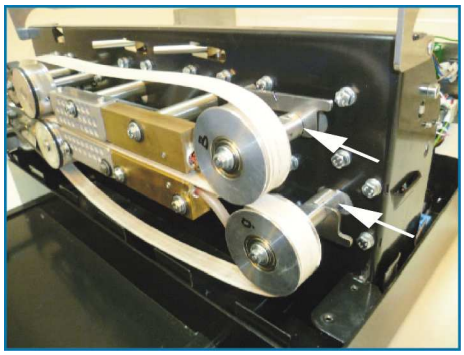
Warning! The heating blocks may still be hot, even if the sealer has been switched off for a while.

Replace the PTFE belts as follows:

1. Move the cooling plate and the heating block to their uppermost position.

Pull the lifting pin up and turn the lifting plate in such a way that it protrudes above the edge of the protective cover.

2. Push the two tension rollers inwards until they lock in place.



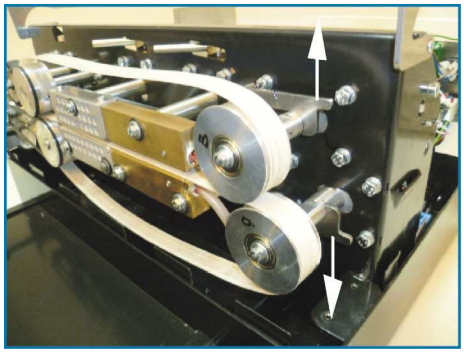
When a tension roller is pushed inwards, the locking pin falls into a recess, which prevents the tension roller from springing back.

3. Loosen the two axes of the V-belts.
4. Remove the V-belts by pushing them off the pulleys with a rotating motion.

5. Remove the old PTFE belts and put the new ones in place.

Make sure there are no creases or folds in the PTFE belts. This can make them break during use.

6. Pull the tension roller locking pins upwards and let the tension rollers spring back gently.



Make sure that the PTFE belts run smoothly over the rollers.

7. Place the V-belts back over the pulleys.
8. Fasten the two axes of the V-belts.

Make sure that the V-belts run smoothly over the rollers, with the serrated side facing outwards.

9. Move the cooling plates and the heating block back to their lowest position.

Pull the lifting pin up and turn the lifting plate so that the lifting pin can go back down all the way again.

7.4 Replacing V-belts

Replace the V-belts as follows:

1. Loosen the two axes of the V-belts.
2. Remove the V-belts by pushing them off the pulleys with a rotating motion.
3. Put the new V-belts back over the pulleys.
4. Apply tension to the V-belts and fasten the axes.

Make sure that the V-belts run smoothly over the rollers, with the serrated side facing outwards.

7.5 Adjusting the V-belts

The V-belts can be adjusted as follows:

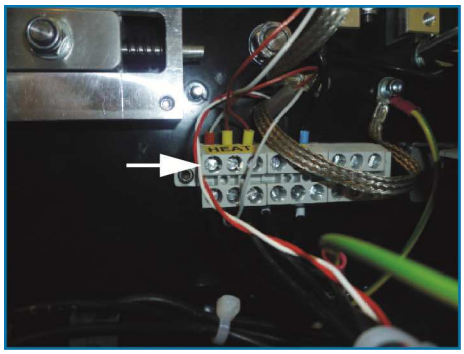
1. Loosen the two axes of the V-belts.
2. Slide the axes to the left or right to increase or decrease the V-belt tension respectively.
3. Fasten the axes.

A V-belt that has to be tensioned frequently is worn and should be replaced.

7.6 Replacing the heating elements

Replace the heating elements as follows:

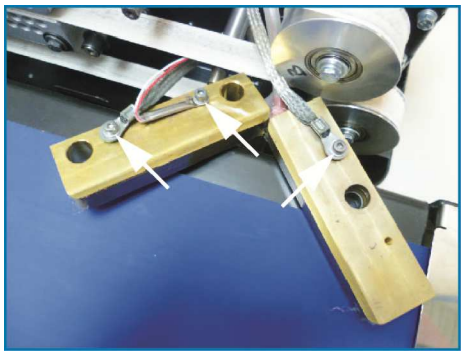
1. Loosen the clamping screws in the terminal block.
2. Pull the wires out of the terminal block.
3. Cut the tie-wraps away.



4. Move the heating block to its uppermost position.

5. Loosen the mounting bolts.
6. Remove the heating block from the machine.

7. Loosen the hex socket bolt at the back of the heating block.
8. Take the new heating blocks and carefully tighten the hex socket bolts at the back of the heating blocks.

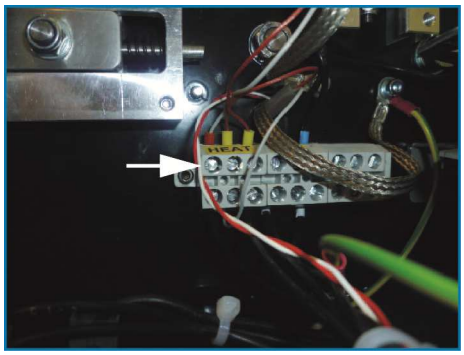


Do not tighten the hex socket bolt too far, or the heating element may get damaged.

9. Push the connecting wires through the opening.
10. Put back the heating blocks.
11. Tighten the mounting bolts again.

Note that the upper heating block should still be able to move up and down a little bit after the mounting bolts are tightened.

12. Insert the connecting wires back in the terminal block.
13. Tighten the terminal block screws again.
14. Fix the connecting wires in place again with tie-wraps.



Take care to connect the wires in the correct positions.

15. Move the heating block back to its lowest position.

7.7 Adjusting the Contact Force of the Heating Blocks

The heating blocks can be adjusted as follows:

1. Turn the adjuster nut to alter the contact force.

Try to keep the contact force as low as possible in order to minimise wear and tear on the PTFE belts.
If necessary, the contact force can be increased for materials that are difficult to seal. Always check that the bag does not get blocked or stuck during sealing.

Turn anticlockwise to increase the contact force and clockwise to reduce it.

Adjust both nuts equally.

7.8 Adjusting the Contact Force for the Cooling Plates

The cooling plates can be adjusted as follows:

1. Turn the adjuster nut to alter the contact force

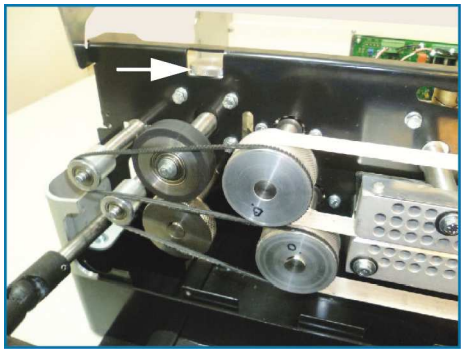
Try to keep the contact force as low as possible in order to minimise wear and tear on the PTFE belts.
If necessary, the contact force can be increased for materials that are difficult to seal. Always check that the bag does not get blocked or stuck during sealing.

Turn anticlockwise to increase the contact force and clockwise to reduce it.

7.9 Adjusting the Contact Force of the After-press Rollers

The after-press rollers can be adjusted as follows:

1. Turn the adjuster wheel to alter the contact force.



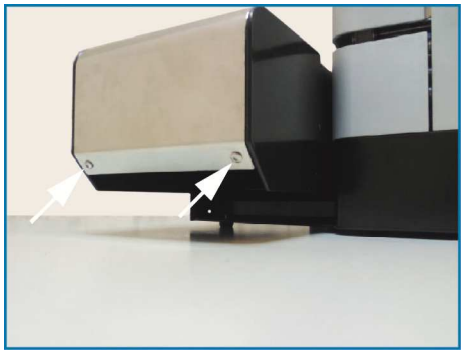
If necessary, the contact force can be increased for materials that are difficult to seal. Always check that the bag does not get blocked or stuck during sealing.

Turn anticlockwise to increase the contact force and clockwise to reduce it.

7.10 Adjusting the Conveyor Belt Tension

The conveyor belt can be adjusted as follows:

1. Remove the cover of the conveyor belt.



2. Turn the tension bolts to adjust the tension.
3. Mount the cover of the conveyor belt.

Turn clockwise to increase the conveyor belt tension and anticlockwise to reduce it.

Make sure the tension is the same on both sides so that the conveyor belt is not pulled out of line.

7.11 Motor Set-up

The machine has an automatic motor set-up function. This motor set-up function must be carried out when a motor is replaced. During this set-up the motor will run at full speed for a few seconds. Be aware that the machine can run safely for a few seconds.

To perform a motor set-up follow the next steps:

- Select the ‘SPEED’ mode with the ‘PROG’ button.
- Press the ‘PROG’ button for 5 seconds till ‘SP1’ appears in the display.
- Start the set-up routine by pressing the ‘PROG’ button. The motor will run at maximum speed for a few seconds.
- End the function by pressing the ‘PROG’ button for 5 seconds till the SPEED settings appear on the display.

7.12 Correction factor

The machine has correction factors to adjust the motor if necessary. This factor (%) will affect the motor output. If set at e.g. 90 the motor will run slower and set at e.g. 110 the motor will run faster.

To perform a motor set-up follow the next steps:

- Select the ‘SPEED’ mode with the ‘PROG’ button.
- Press the ‘MOTOR’ and ‘PROG’ button simultaneous for 5 seconds till ‘CF1’ appears in the display.
- Press the ‘PROG’ button.
- Set the CF1 setting with the ‘UP’ or ‘DOWN’ button. (Minimum 85 and maximum 115).
- Press the ‘PROG’ button to return to ‘CF1’.
- End the function by pressing the ‘PROG’ button for 5 seconds till the SPEED settings appear on the display.

7.13 Reset to factory settings

The machine has a function to reset all settings to the original factory settings.

Note that if you reset the machine all settings prior made will be lost.

To perform a reset follow the next steps:

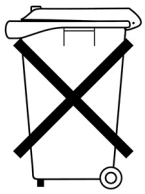
- Switch the main power OFF.
- Keep the ‘START/STOP’- and the ‘PROG’ button pressed, while the main power is switched ON, until ‘rES’ appears in the display.
- Perform a motor set-up.
- Adjust the correction factor if necessary.

8 Disposing of the Sealer

Correct disposal of machines and equipment helps protect the environment and public health.

8.1 WEEE Directive

In accordance with the European Directive on waste electrical and electronic equipment (WEEE), the pictogram shown here indicates that the machine or piece of equipment to which it has been applied is to be collected separately from other waste and may not be disposed of together with other waste.



8.2 Correct Disposal for Reuse

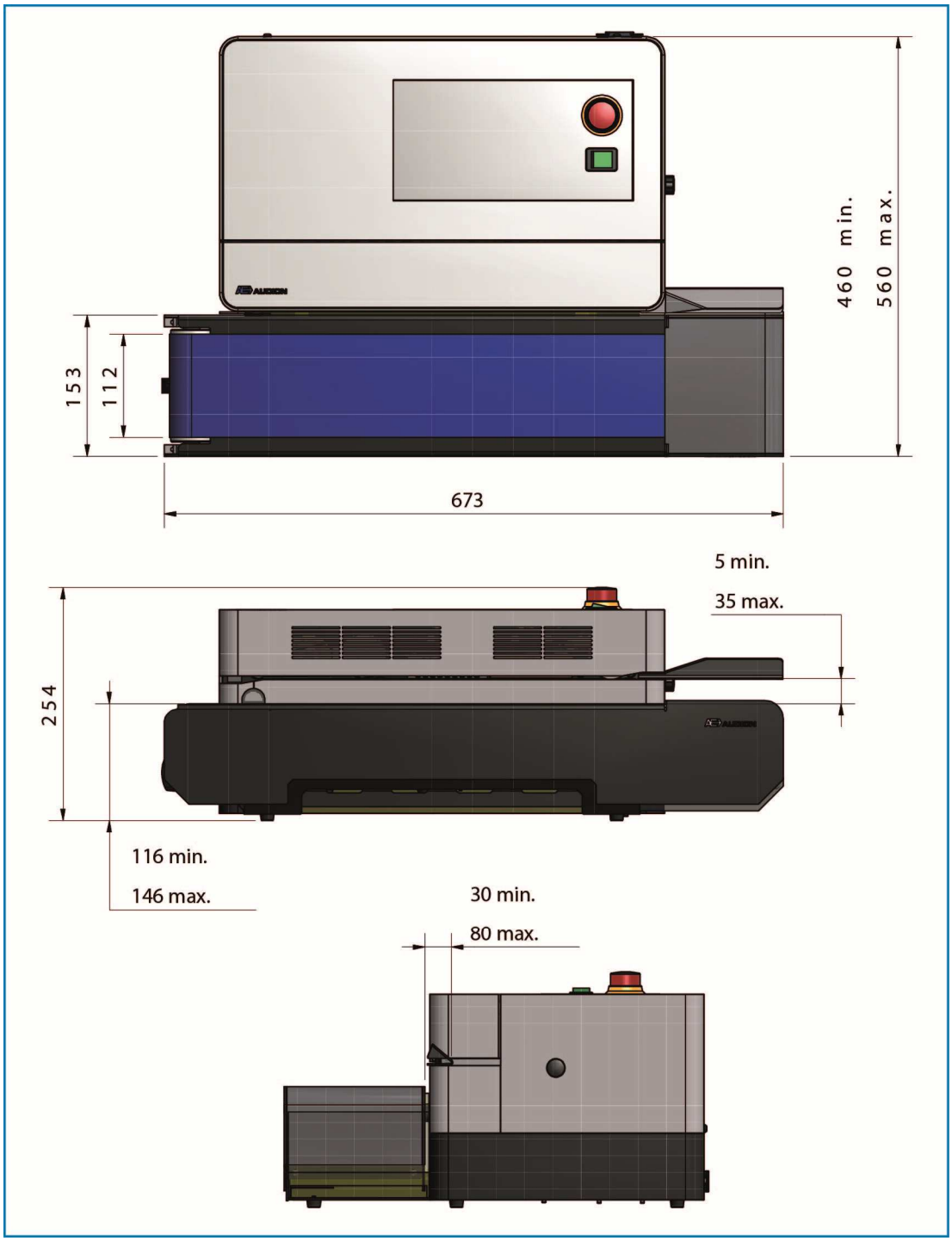
The machine or piece of equipment is to be presented to a disposal station or, in case of replacement, to the supplier of the replacement machine or piece of equipment.

For more information, please contact the local agency responsible for the collection of waste and the like, or the municipal waste depot.

The owner of the machine or piece of equipment is responsible for the correct disposal of the machine.

A Technical Information

A.1. Dimension drawing



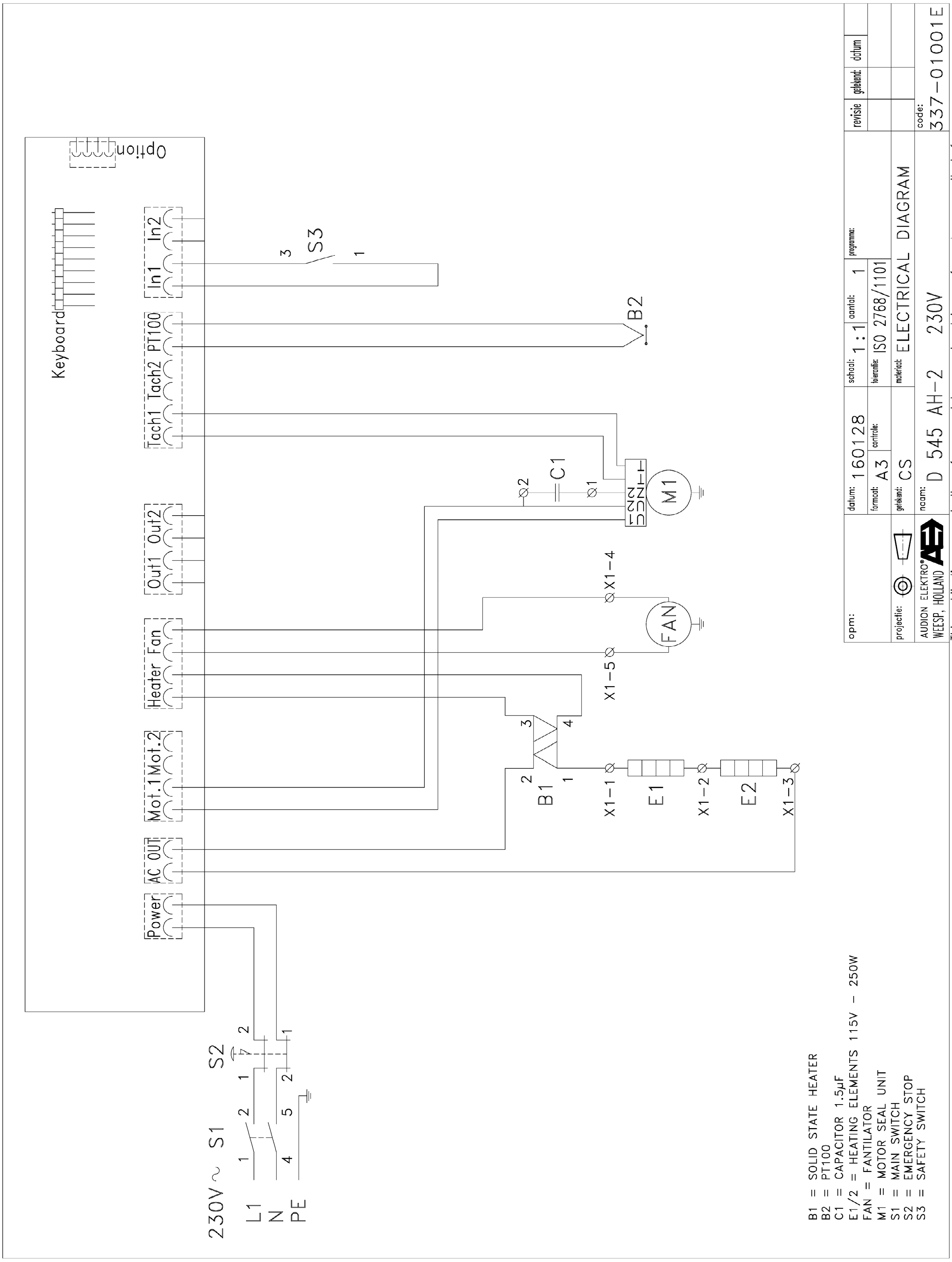
A.2. Technical Data

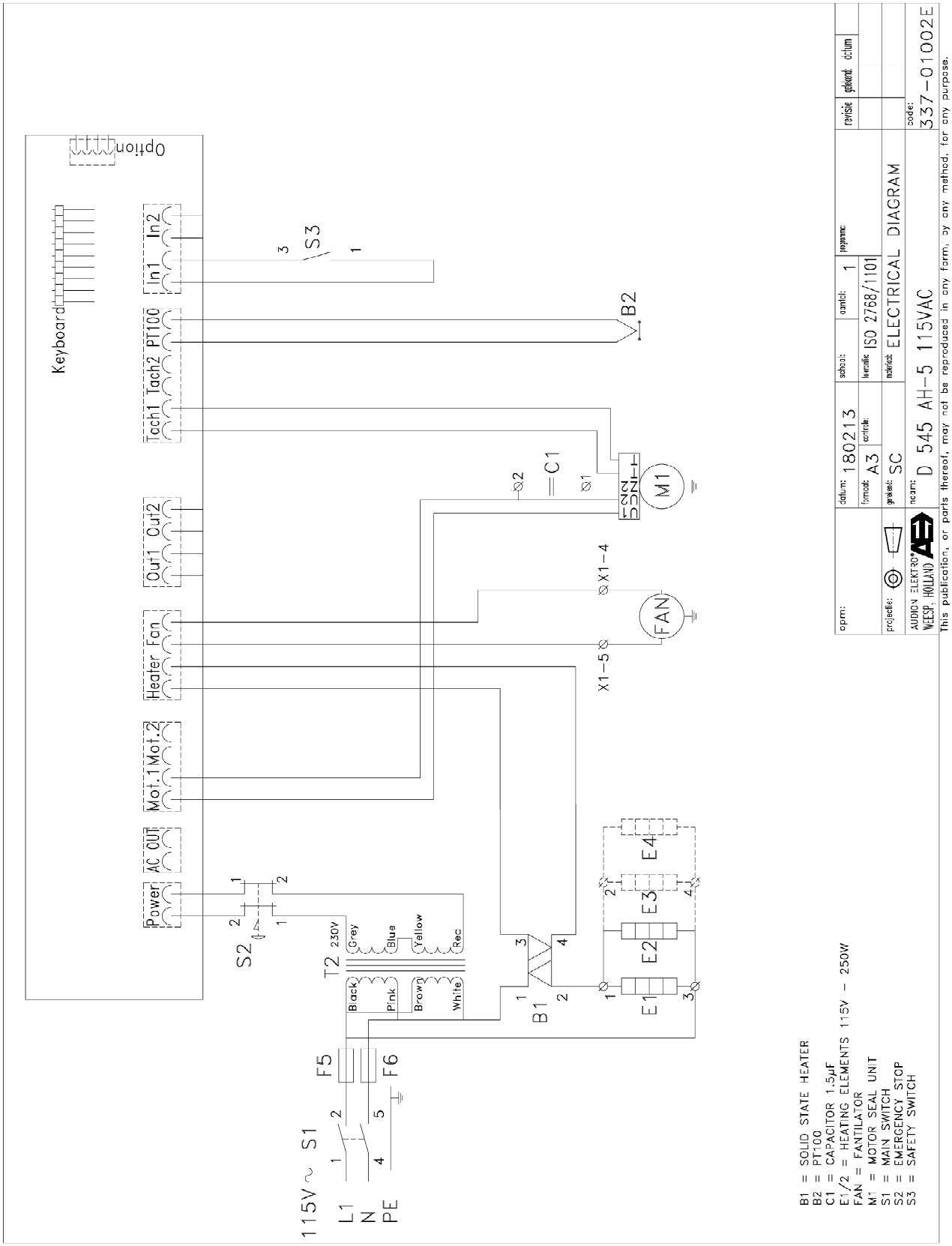
General	
Dimensions	See the dimensional drawing
Weight	29 kg
Ambient temperature	5ºC to 40ºC
Humidity	30% to 95% RH, non-condensing
Seal length	unlimited
Seal width	10 mm
Sealing speed	Max. 10 meters per minute
IP value	IP20
Electrical	
Voltage	230 V - 16 A
Frequency	50-60 Hz
Earthing	earthed
Power	550 W
Mains power tolerance	< 10%
Length of power cable	± 1.8 m
Film	
Min. film thickness	25 µm
Max. film thickness	200 µm
Max. film insert	45 mm
Max. film width	unlimited
Bag dimensions	
Max. weight (on conveyor belt)	5 kg
Max. bag length	250 mm
Max. flap length	45 mm
Emissions	
Noise	< 70 dB(A)
Hand/arm vibration	<2.5 m/s^2

B Electrical Diagram

Maintenance to the electrical installation should only be performed by authorised maintenance personnel.

Always remove the plug from the socket before carrying out any maintenance work.


Keyboard
Option
In1 In2
Tach1 Tach2 PT100
Out1 Out2
Heater Fan
Mot.1 Mot.2
AC OUT
Power
S3
B2
C1
M1
FAN
X1-4
X1-5
B1
X1-1
E1
X1-2
E2
X1-3
S2
S1
230V ~
L1
N
PE
B1 = SOLID STATE HEATER
B2 = PT100
C1 = CAPACITOR 1.5µF
E1/2 = HEATING ELEMENTS 115V - 250W
FAN = FANTILATOR
M1 = MOTOR SEAL UNIT
S1 = MAIN SWITCH
S2 = EMERGENCY STOP
S3 = SAFETY SWITCH
opm:
datum: 160128
schaal: 1 : 1
aantal: 1
formaat: A3
controle:
toleranties: ISO 2768/1101
projectie:
getekend: CS
materiaal: ELECTRICAL DIAGRAM
AUDION ELEKTRO
WEESP, HOLLAND
ncam: D 545 AH-2 230V
code: 337-01001E
revisie
getekend
datum
This publication, or parts thereof, may not be reproduced in any form, by any method, for any purpose.


Option
Keyboard
In1 In2
Tach1 Tach2 PT100
Out1 Out2
Heater Fan
Mot.1 Mot.2
AC OUT
Power
S3
B2
C1
M1
FAN
X1-4
X1-5
S2
T2 230V
Grey
Blue
Yellow
Red
Black
Pink
Brown
White
B1
E1
E2
E3
E4
F5
F6
S1
115V~
L1
N
PE
B1 = SOLID STATE HEATER
B2 = PT100
C1 = CAPACITOR 1.5µF
E1/2 = HEATING ELEMENTS 115V - 250W
FAN = FANTILATOR
M1 = MOTOR SEAL UNIT
S1 = MAIN SWITCH
S2 = EMERGENCY STOP
S3 = SAFETY SWITCH
opm:
datum: 180213
schaal:
aantal: 1
wijzigingen:
revisie
getekend: datum
formaat: A3
controle:
leverancier: ISO 2768/1101
projectleider:
getekend: SC
materiaal: ELECTRICAL DIAGRAM
AUDION ELEKTRO
WEESP, HOLLAND
naam: D 545 AH-5 115VAC
code: 337-01002E
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C Spare Parts

Only use original Audion parts for repairs and maintenance.

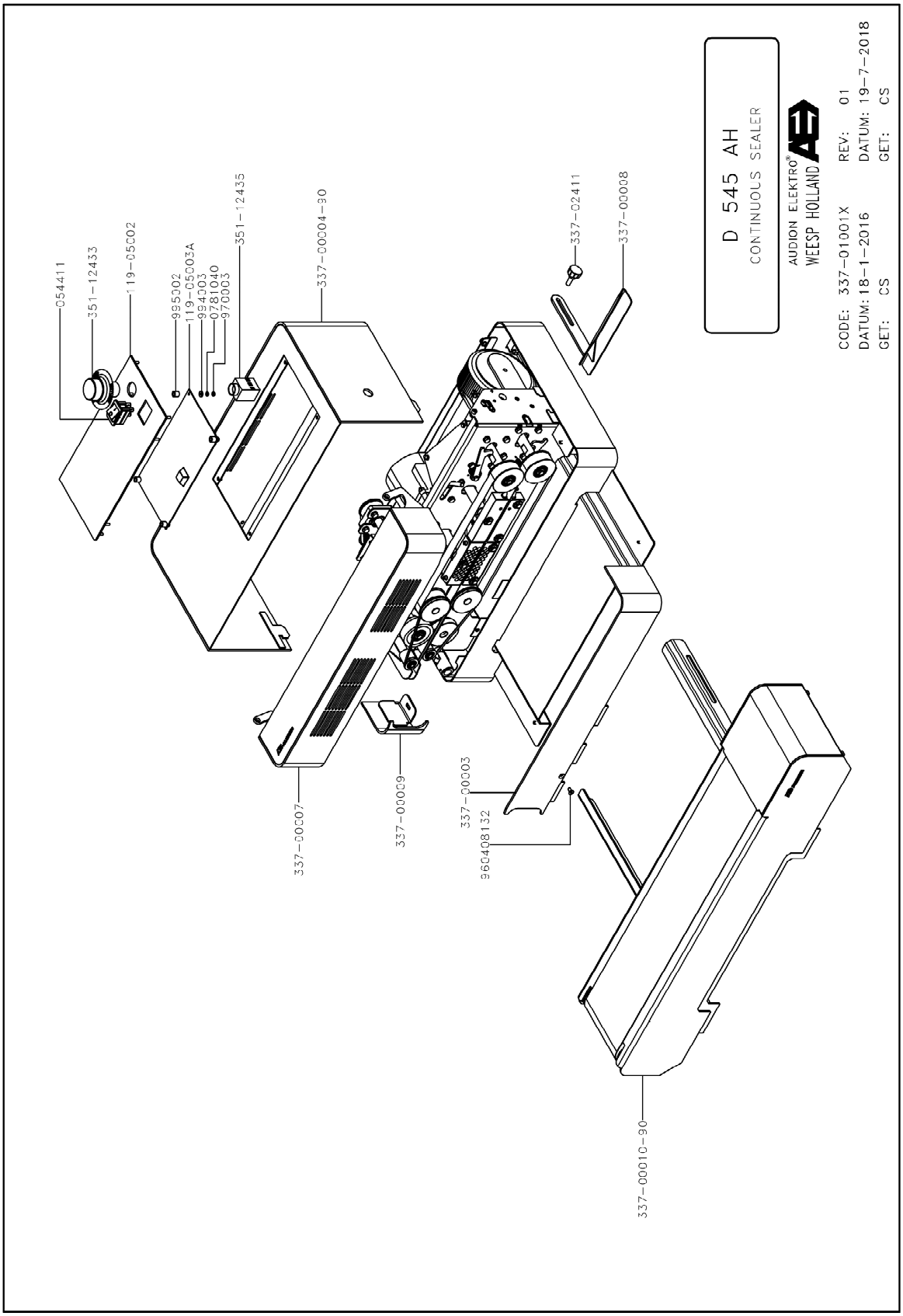
Repairs and maintenance should only be performed by authorised maintenance personnel.

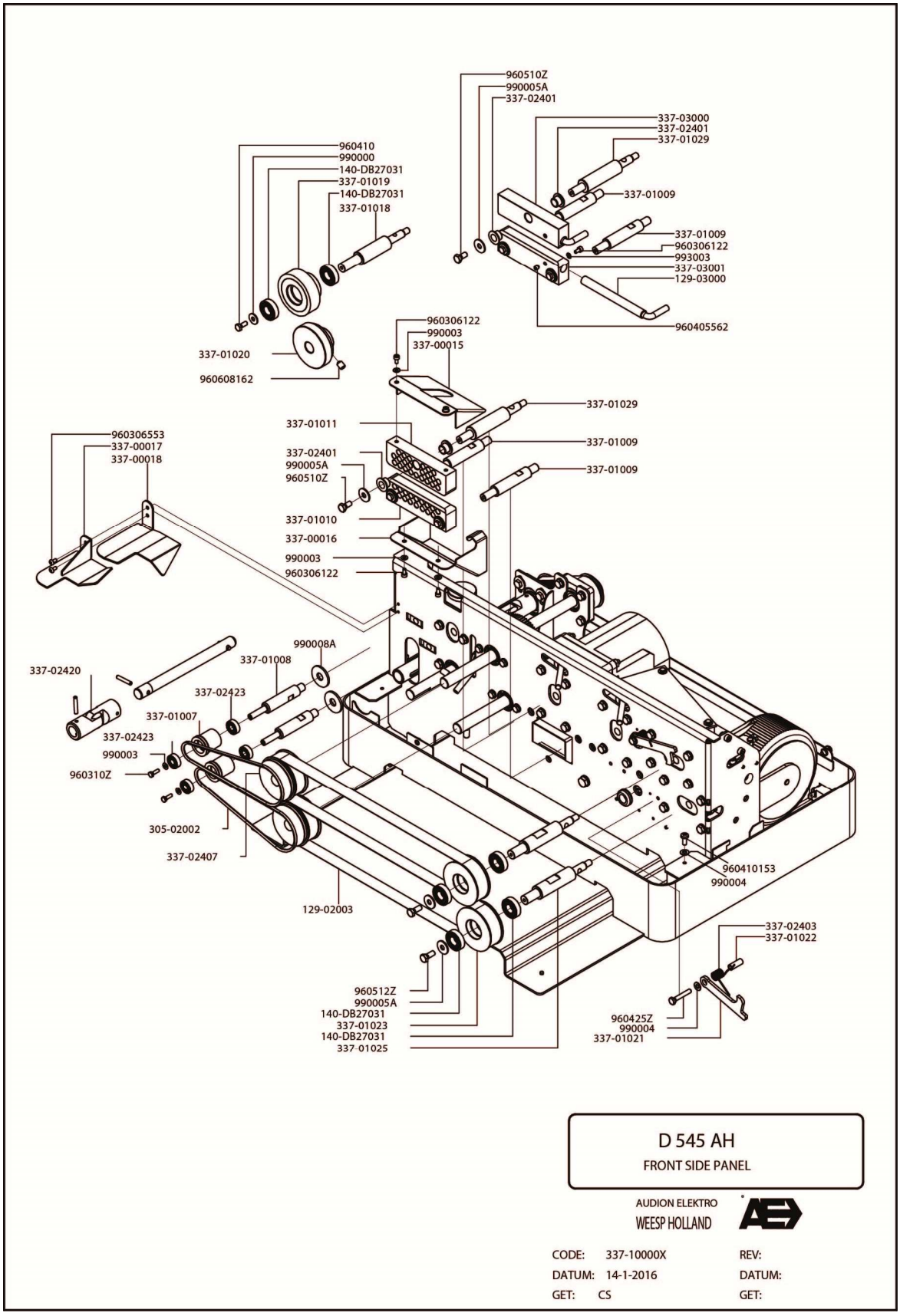
Always keep a set of recommended wear parts in stock so that a defective part can be replaced quickly and the production process resumed without delay.

C.1. Wearing parts

Part	Qty per machine	Item number
Conveyor belt	1	129-02001
V-belt, small	2	305-02002
PTFE belt, width 15 mm	2	129-02003
Heating element	2	129-03000

C.2. Exploded views

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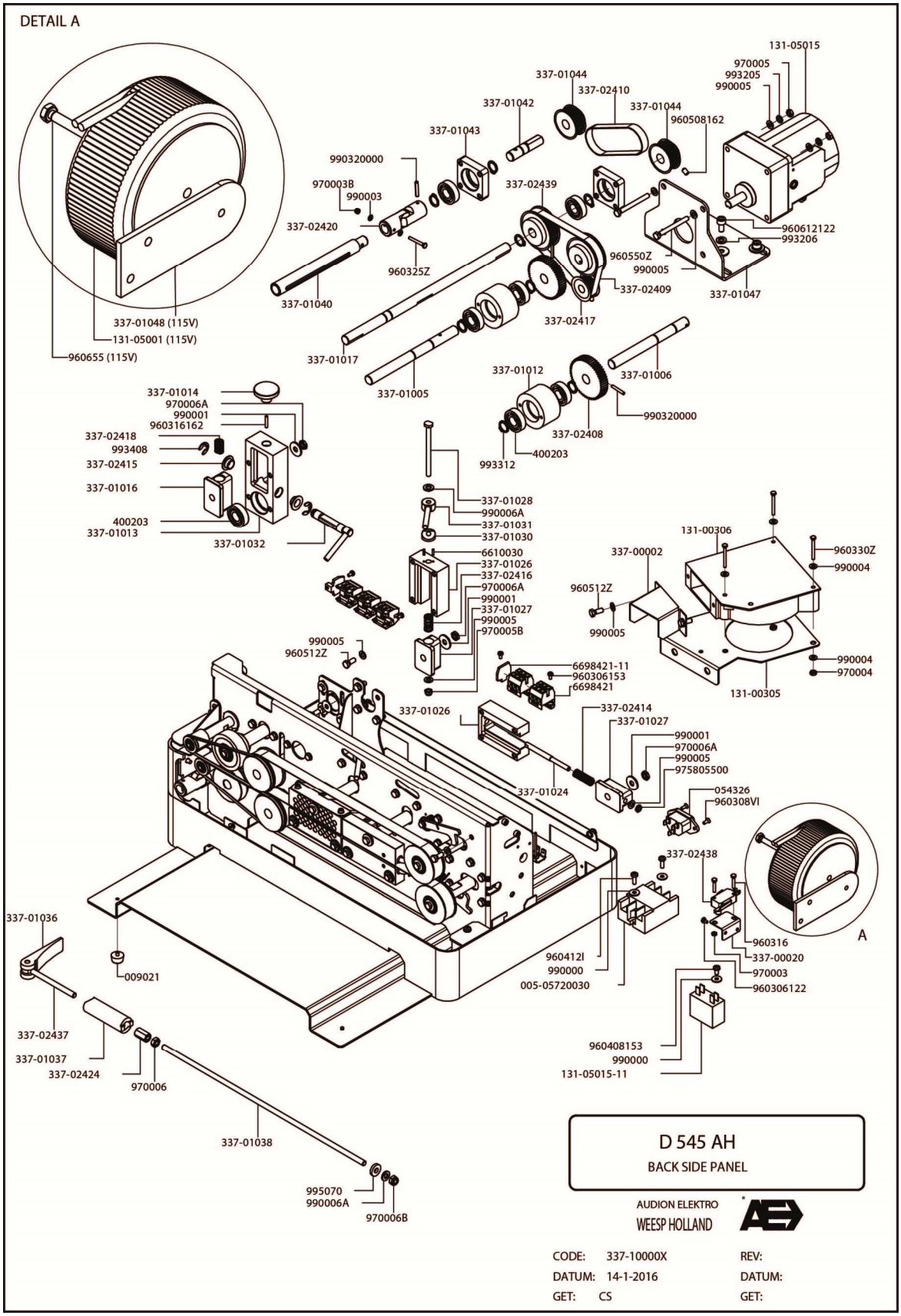
990005A
337-02401
337-03000
337-02401
337-01029
960410
990000
140-DB27031
337-01019
140-DB27031
337-01018
337-01009
337-01009
960306122
993003
337-03001
129-03000
960405562
960306122
990003
337-00015
337-01020
960608162
337-01029
337-01011
337-01009
960306553
337-00017
337-00018
337-02401
990005A
960510Z
337-01009
337-01010
337-00016
990003
960306122
990008A
337-01008
337-02420
337-02423
337-01007
337-02423
990003
960310Z
305-02002
337-02407
129-02003
960410153
990004
337-02403
337-01022
960512Z
990005A
140-DB27031
337-01023
140-DB27031
337-01025
960425Z
990004
337-01021
D 545 AH
FRONT SIDE PANEL
AUDION ELEKTRO
WEESP HOLLAND
CODE: 337-10000X
DATUM: 14-1-2016
GET: CS
REV:
DATUM:
GET:


DETAIL A
131-05015
970005
993205
990005
337-01044
337-02410
337-01044
960508162
337-01042
337-01043
990320000
970003B
990003
337-02439
337-02420
960325Z
960612122
993206
960550Z
990005
337-02409
337-01047
337-01040
337-02417
337-01048 (115V)
131-05001 (115V)
960655 (115V)
337-01017
337-01005
337-01012
337-01006
990320000
337-02408
400203
993312
337-01014
970006A
990001
960316162
337-02418
993408
337-02415
337-01016
400203
337-01013
337-01032
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990006A
337-01031
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6610030
337-01026
337-02416
970006A
990001
337-01027
990005
970005B
990005
960512Z
131-00306
337-00002
960330Z
990004
960512Z
990005
990004
970004
131-00305
6698421-11
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970006B
D 545 AH
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WEESP HOLLAND
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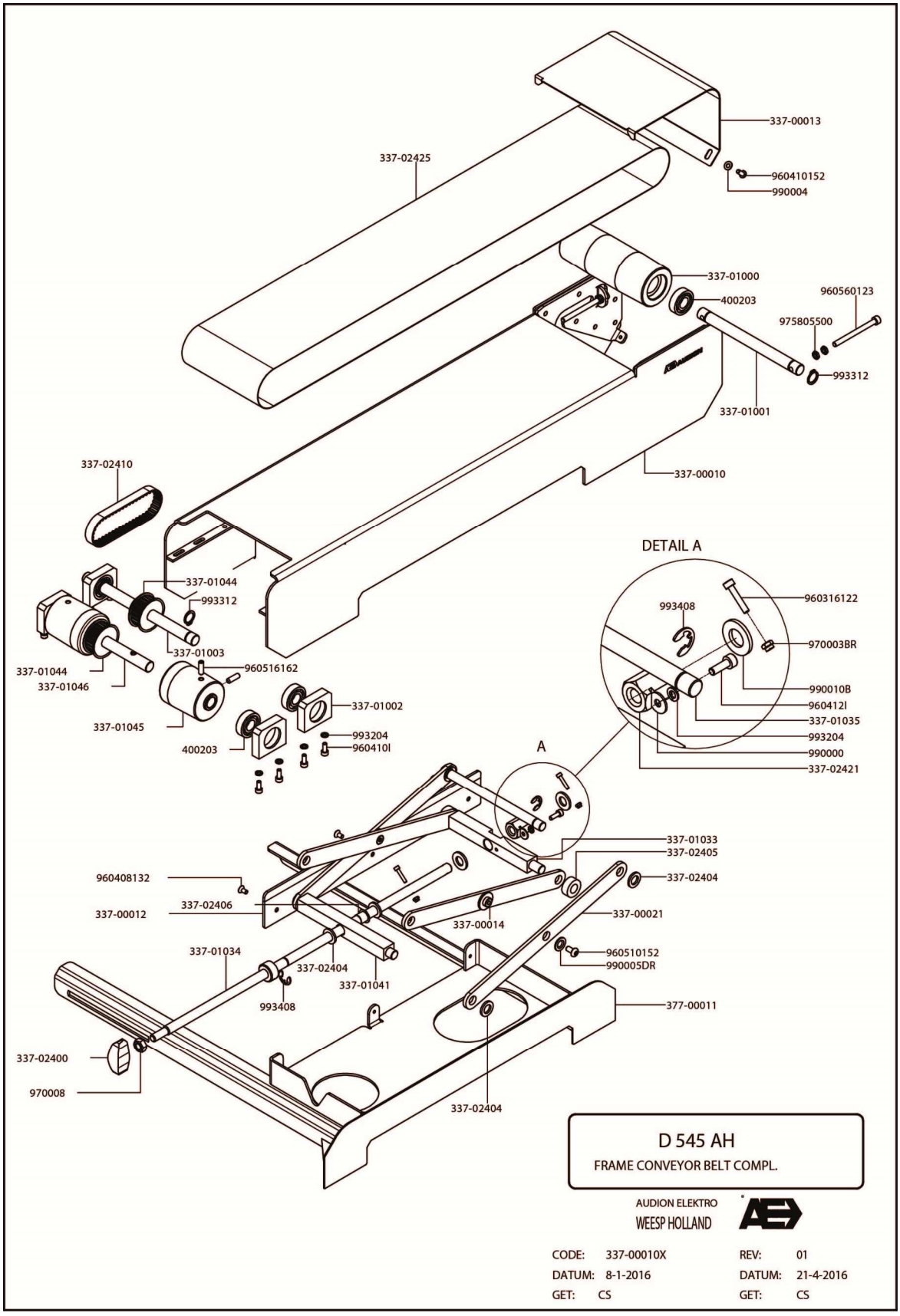
REV:
DATUM:
GET: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337-02425
960410152
990004
337-01000
400203
960560123
975805500
993312
337-01001
337-00010
337-02410
337-01044
993312
337-01003
960516162
337-01044
337-01046
337-01045
337-01002
400203
993204
960410I
DETAIL A
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A
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337-02405
337-02404
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337-01041
960510152
990005DR
993408
377-00011
337-02400
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337-02404
D 545 AH
FRAME CONVEYOR BELT COMPL.
AUDION ELEKTRO
WEESP HOLLAND
CODE: 337-00010X
DATUM: 8-1-2016
GET: CS
REV: 01
DATUM: 21-4-2016
GET: CS

D Log

Always keep a log of all maintenance work.

Refer to the 'Maintenance' chapter for an overview of the maintenance work to be carried out.

Make a copy of the log and use it to sign off the maintenance work.

D.1. Maintenance Log

Maintenance*	Remarks/parts replaced	Date	Performed by	Initials
Weekly/ Monthly				
Weekly/ Monthly				
Weekly/ Monthly				
Weekly/ Monthly				
Weekly/ Monthly				
Weekly/ Monthly				
Weekly/ Monthly				
Weekly/ Monthly				
*Strike out that which does not apply.				

E EC Declaration

EC-DECLARATION OF CONFORMITY

AUDION ELEKTRO B.V., located at the Hogeweyselaan 235 in Weesp, The Netherlands

herewith declares that the

ALL IN SEALER 545

Type:

D 545 AH-2; D 545 AH-5

- is in conformity with the provisions of the following EEC directives: 2014/35/EU Low Voltage Directive ; 2014/30/EU EMC-Directive ; RoHS 2011/65/EU Directive ;

- and that the following (parts/clauses of) harmonized standards have been applied:

EN-ISO 12100; EN-ISO 13732-1; EN-ISO 13850; EN 1037+A1; EN-IEC 60204-1;

Weesp, 19-2-2018

E.Tangelder
Director

PGR337A

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www.audion.com

Represented by: