



VALUE-PLUS EQUIPMENT

The Right Equipment at the Right Price!

Chopping Cutting Filling Grinding Mixing Packaging Slicing Stuffing

OPERATION AND MAINTENANCE

VBS-35HV

Band Sealer



**We Provide
technical support and
service for all machines
that we sell.**



VALUE-PLUS EQUIPMENT

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323-268-8514 800-421-6265

**Stainless Steel
Construction**

OPERATION AND MAINTENANCE
VBS-35HV
Band Sealer

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VALUE-PLUS EQUIPMENT

DISTRIBUTED BY: MPBS INDUSTRIES

2820 E. WASHINGTON BLVD

LOS ANGELES, CA 90023

PHONE: 323-268-8514

FAX: 323-268-6305

OVERVIEW

Development of the Value-Plus VBS-35HV Band Sealer was based on years of experience combining the most advanced technology with feedback from our customers. It sequentially convey, seal code print (production date, batch number, etc.) in one operation. Most films that can be heated can be sealed and/or code printed by the machine.

This Band Sealer can be applied in many industries, including: food, cosmetics, pharmaceuticals, beverage, chemical, electrical and hardware.

Partial Product List:

- Meat
- Poultry
- Fish
- Pie Fillings
- Produce/Vegetables
- Small Machine Parts
- Make-Up
- Pills
- Toys
- Small Objects



FEATURES AND SAFETY PRECAUTIONS

FEATURES

- Metal frame
- Belt speed control
- Temperature control
- Sealing width control
- Ink printing system



SAFETY PRECAUTIONS

FAILURE TO FOLLOW THESE INSTRUCTIONS MAY CAUSE DAMAGE
TO THE MACHINE OR BODILY INJURY

1. Do not modify wiring. Have only a qualified and certified electrician install the plug on the Value-Plus VBS-35HV Band Sealer as required. Make sure the machine is grounded; failure to do so could result in electric shock.
2. Always place the equipment on a level table.
3. The machine should be operated only by personnel who have been properly trained.
4. Do not leave the machine while running unattended.
5. Do not alter, bypass, or remove safety guards, safety interlock electrical switches, or any other safety devices.
6. Always disconnect the power supply before servicing or cleaning the machines.
7. If service or parts are needed, contact your nearest service dealer or Value-Plus Equipment for authorized parts and/or service.

TECHNICAL SPECIFICATIONS AND ACCEPTABLE FILM MATERIALS

TECHNICAL SPECIFICATIONS

VBS-35HV Band Sealer

1.	Transmission speed	1 to 12 m (3 to 40 ft) per minute
2.	Maximum printed characters	13
3.	Exterior Dimensions	850 x 420 x 320 mm (34" x 17" x 13")
4.	Electrical	110 V / 60 Hz / 1 Ø
5.	Transmission weight capacity	10 kg (22 lb)
6.	Sealing Temperature	0 to 300°C / 32 to 572°F (adjustable)
7.	Sealing Width	6 to 12 mm (¼" to ½")
8.	Sealing Length	No limit
9.	Film Thickness	.01 to .2 mm (.0004" to .008")

* All specifications are subject to change without notice.

ACCEPTABLE FILM MATERIALS

Film Composition	Sealing Temperature	Ink Temperature
Polyester/lead/polypropylene 14/16/20	220 to 260°C 428 to 500°F	230 to 250°C 446 to 482°F
Polyester/polypropylene 6/160	175 to 220°C 347 to 428°F	
Polyester/Glassine 45/30	160°C 320°F	
Polythene	130 to 150°C 266 to 302°F	

MACHINE FUNCTION AND APPLICATIONS, INSTALLATION AND SET-UP

MACHINE FUNCTION AND APPLICATIONS

1. Value-Plus model VBS-35HV Band Sealers can seal plastic and composite film materials to form packaging suitable for many products including foods, pharmaceuticals, chemicals, cosmetics, electronic components, etc.
2. Horizontal sealers are not suitable for packaging liquids.
3. The infinitely variable sealing length enables a wide variety of bag sizes and shapes.
4. The machine consists of a frame, speed regulator, sealing length regulator, temperature control, conveyor and drive motor. Electro-thermal energy raises the temperature of the upper and lower heaters. The open end of the bag is guided between the seal bars; the bag is then partially cooled, the sealed area is embossed, and then cooling is completed.
5. All operations are driven synchronously. Seal bar temperature and conveyor speed can be controlled separately to accommodate packaging film compositions and products.

INSTALLATION AND SET-UP

1. Be sure that the power supply is properly connected to a grounded outlet.
2. Heat the seal bars to a low temperature for several minutes before normal operation to evaporate any moisture that may accumulate prior to first use or during longer intervals of disuse.
3. Adjust the position of the conveyor unit (height and front/back) according to the exterior dimensions of the pouch.
4. Adjust the sealing width guide according to the desired seal.
5. Adjust the spacing between the heating bars and cooling bars according to the thickness of the film material being used.

OPERATION AND MAINTENANCE

OPERATION

1. Turn on the power; indicator lights come on motor comes on.
2. Adjust the Pattern Roller / Inker Wheel (Fig. 1 #3) to the desired pressure.
3. Turn on the heat switch (on control panel); the green temperature control meter light appears. Adjust the temperature control according to the composition and thickness of the packaging film. The table below is a guide based on an ambient temperature of 20°C (68°F).

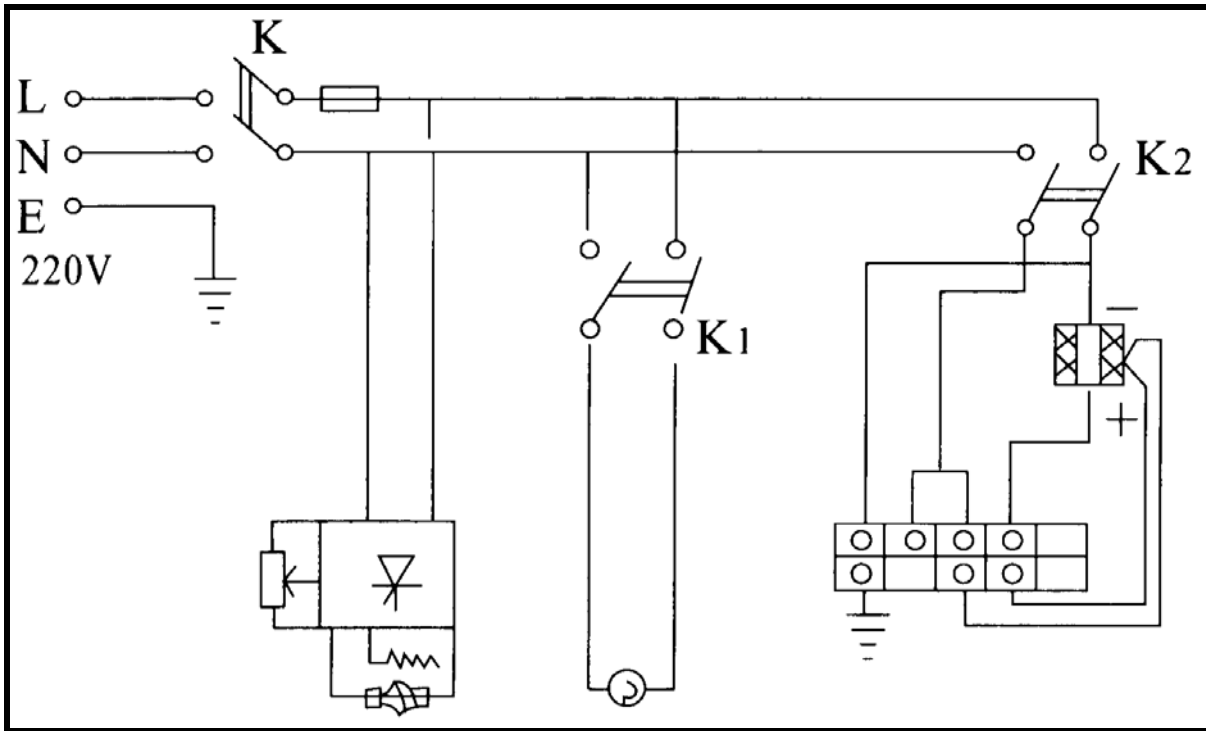
Polyethylene	150 - 160 °C	(302 - 320 °F)
Polypropylene	170 - 180 °C	(338 - 356 °F)
Polyolefine compound	180 - 190 °C	(356 - 374 °F)

4. The red light indicator comes on when the set temperature is reached. At this point you can test the settings on the film to be used and make any necessary adjustments in the heat setting, conveyor speed and/or Pattern Roller/Inker Wheel before proceeding with packaging operation.
5. Turn on the blower switch (on control panel) for cooling of polyethylene or single layer plastic films or for some other thin films that may require faster cooling.
6. Lay the sealing ends of the film flat across the seal bar.

MAINTENANCE

1. To change the seal tape:
 - a. Push on the drive wheel to remove the old sealing tape:
 - b. Install a new sealing tape and the upper and lower lead belts.
 - c. Replace the drive wheel, heater and cooler in their original positions.
 - d. the drive wheel to align the edge of the sealing tape, if necessary.
 - e. Replace the safety guard before resuming operation.
2. To maximize the life of the sealing tape:
 - a. Turn the heat setting to zero.
 - b. Keep blower running by waiting to turn off the machine until the temperature falls below 100°C (212°F).
3. To maintain the sealed turbo unit (based on normal use not exceeding 8 hours per day)
 - a. Oil monthly using 50g of 20# oil.
 - b. Clean and change the oil annually.

CONTROL BOARD SCHEMATIC



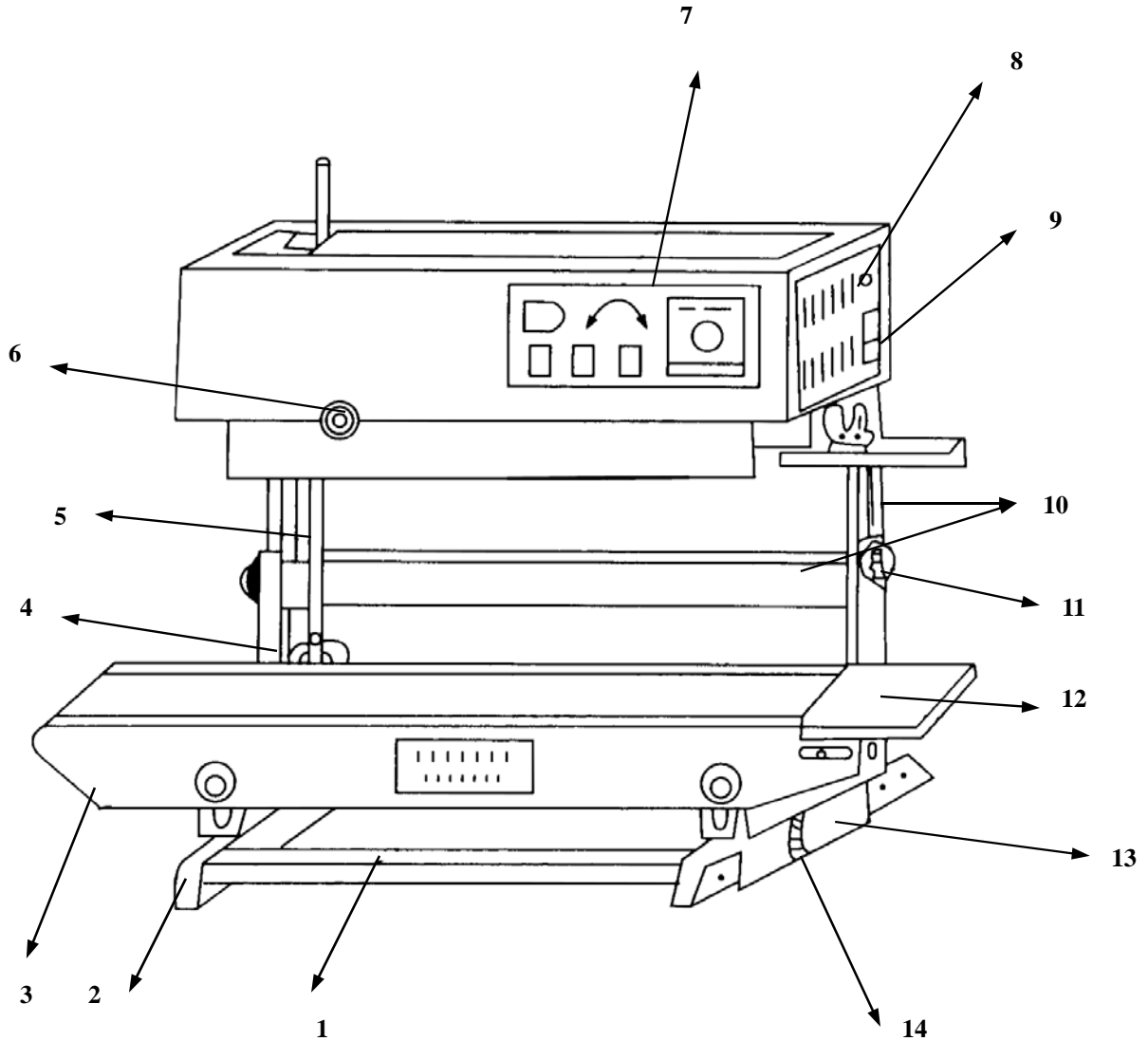
Symbol	Name	Description	Quantity
K	Power supply switch	mK321 B/N	1
BX	Insurance tube	5 X 20/3 A	1
W	Potentiometer	WH118/100K	1
SW	Speed regulating plate	HL- W	1
D1	Motor	Z 50/20-200	1
D2	Blower	75FZJ2	1
K1	Blower switch	MK321 B/N	1
K2	Electro-thermal switch	MK321 B/N	1
R	Electro-thermal tube	110 V / 220 W	2
TDA	Temperature control meter	TDA8001 or TE2001	1
E	Electro-thermal couple	EA-2	1

TROUBLESHOOTING

PROBLEM	PROBABLE CAUSE	REMEDY
Machine does not start	No power supply.	Check that machine is plugged in, fuse is tight and intact, and power switch is on and not damaged.
	Circuit broken by speed regulation plate.	Change the speed regulation plate.
Leakage	Lapse in time since last operation.	Preheat to evaporate moisture prior to sealing operation.
	Machine not properly grounded	Make sure power connection is grounded per instructions in "Installation and Set-up."
Poorly defined sealing pattern	1. Inadequate Pattern Roller pressure.	1. Turn Pattern Roller/Inker pressure knob to increase pressure.
	2. Surface of rubber wheel uneven.	2. Replace rubber wheel.
	3. Residue adhering to pattern roller surface.	3. Clean pattern print roller surface with detergent.
	4. Insufficient sealing heat.	4. Raise the heating temperature.

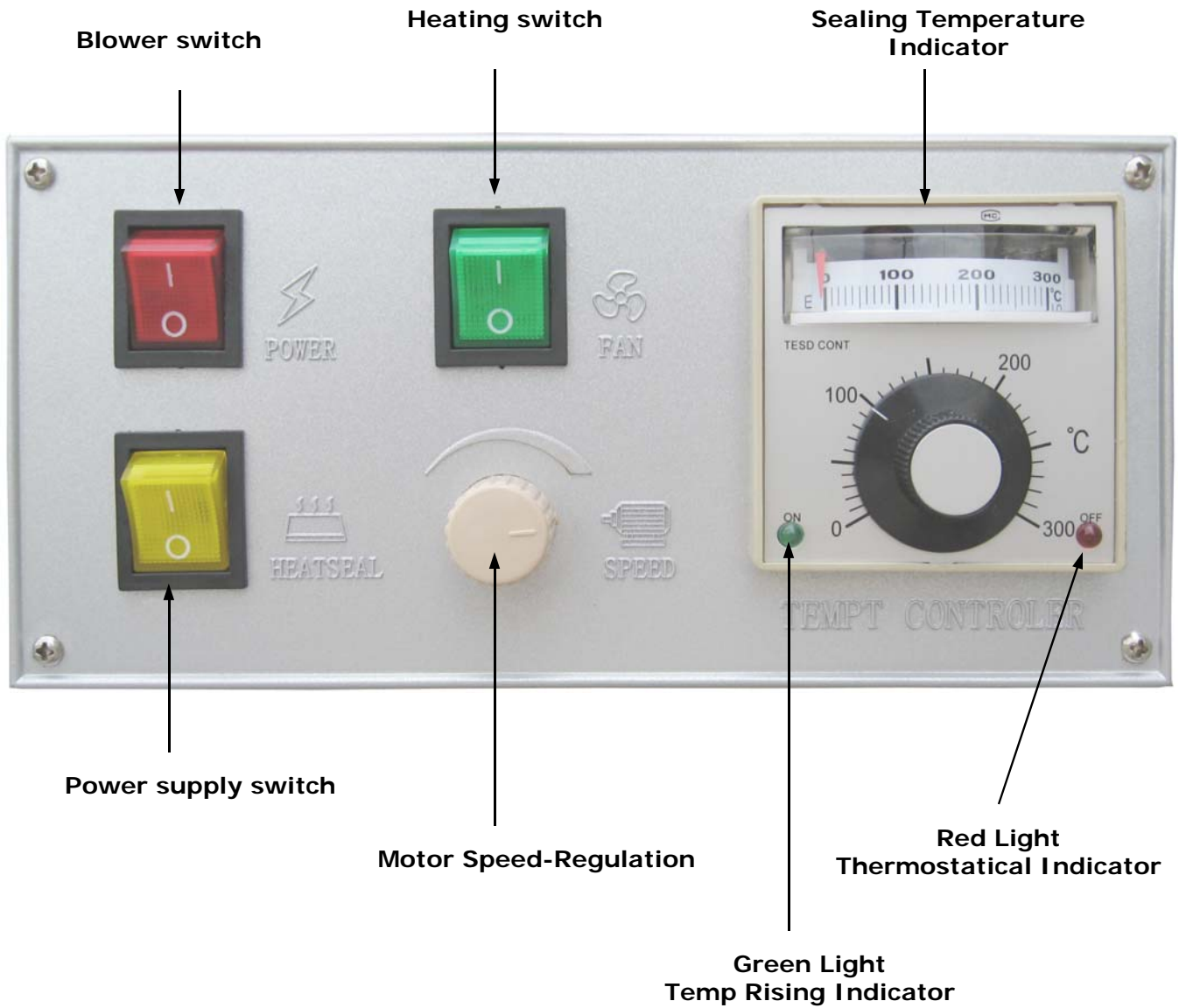


PARTS DIAGRAM



- | | |
|------------------------------------|-------------------------------------|
| 1. Horizontal beam (Vertical type) | 8. Insurance tube |
| 2. Tripod (Vertical type) | 9. Power supply socket |
| 3. Conveyor station | 10. Support (Horizontal type) |
| 4. Umbrella gear seat | 11. Height regulation knob |
| 5. Vertical long axis | 12. Fixed working table |
| 6. Pressure regulating knob | 13. Conveyor station's support |
| 7. Control box | 14. Fixing knob of conveyor station |

CONTROL PANEL



Value-Plus Equipment Limited Warranty

LIMITED STANDARD WARRANTY: Value-Plus Equipment warrants to the original purchaser that all new equipment is free from defects in non-wearable material and workmanship for six months from the date of shipment. Claims must be made during that period and are limited to the replacement or repair of non-wearable parts determined to be defective.

This Limited Warranty is valid only when the product has been properly installed and subject to normal use and recommended maintenance. This Warranty shall not extend to products that have been misused, neglected, altered, or repaired without Value-Plus Equipment's authorization during the warranty period. Operating conditions beyond our control such as improper voltage, air or water pressure, excessive ambient temperatures or moisture, or other conditions that would affect the performance or life of the product will also cause the Warranty to become void.

Permission to return parts for warranty repair must be obtained and all returns must be prepaid to Value-Plus Equipment. If, after examination, the product or part is found to be defective, it will be repaired or replaced without charge and returned, FOB Value Plus Equipment. If it is determined that the Warranty has not been breached, then the usual charges for repair or replacement will be assessed, FOB Value-Plus Equipment.

Wearable and expendable parts (including, but not limited to, bearings, seals and gaskets) are excluded from this Warranty. Periodic maintenance of equipment is not covered under this Warranty.

Value-Plus Equipment's maximum liability shall not, in any case, exceed the contract price for the product, part, or component claimed to be defective. Value-Plus Equipment assumes no liability for any special, indirect, or consequential damages arising from defective equipment, product being processed or packaged, or any packaging materials being utilized on equipment provided by Value-Plus Equipment.

THERE ARE NO WARRANTIES IMPLIED OR EXPRESSED THAT EXTEND BEYOND THOSE CONTAINED IN THIS LIMITED STANDARD WARRANTY.