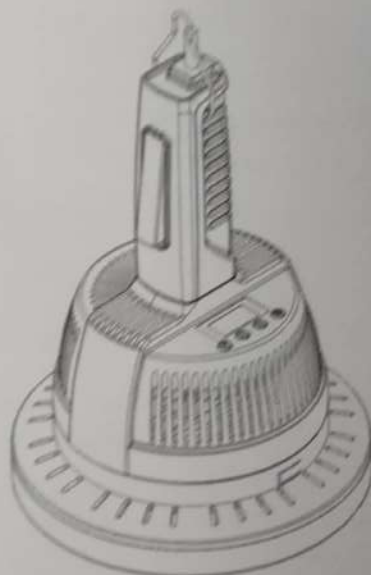
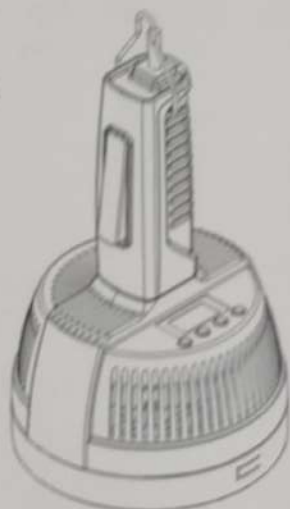


# Manual Book

## One-piece Induction Sealing Machine

DL-800A



DL-800B

Read this manual before operating the machine

DL-1809721A

## I. Brief Induction

### 1.1 Application Range

'DL-800 series' microcomputer induction sealer heats and in-touched seals the aluminum foil which is inside plastic or glass containers by electromagnetic principle. Machine is not allowed to be used for metal containers or bottles containing flammable and explosive articles.

### 1.2 Components

The previous style is composed of 2 parts: induction power and induction sealing head. Now the 800 series' unique one-piece design is combining power and induction coil in one shell which improves work efficiency and offers more convenience to the user.

### 1.3 Using Environment

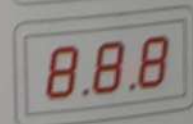
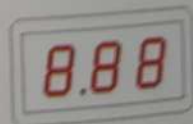
The environment temperature for this machine can not be higher than 45°C and relative humidity should be lower than 80%. Machine should be placed in ventilated environment. The cooling holes on the bottom and side of the machine should be clean and unobstructed. Over high temperature or humidity will impact the electronic parts' use life or even directly damage the device.

## II. Technical Parameter

MODEL	800A	800B
Voltage (V)	AC150 ~ 270	AC150 ~ 270
Power (Kw)	0.8 ~ 1.2	0.8 ~ 1.2
Static Current (A)	< 0.1	< 0.1
Max Allowed Current (A)	< 6	< 6
Working Frequency (KHz)	30 ± 5%	30 ± 5%
Sealing Diameter (mm)	20 ~ Φ100	Φ20 ~ Φ130
Max Environment temperature (°C)	45	45
Relative Humidity (RH)	≤ 80 %	≤ 80 %
Safe Standard	GB 4706 1 1998	GB 4706 1 1998
Shell Protection Level	Ip21	Ip21
Package Size (mm)	170 × 165 × 285	215 × 205 × 305
Machine Weight (Kg)	0.8	1
Memory function without power	available	available

## III Operational Instruction

- **Manual mode** Press the power button once and only one dot on the digital tube
- **Smart mode** Press the power button twice and there are 2 dots on the digital tube



### 3.1 Turn On

Plug in power, machine will go self-testing automatically. The digital tube shows OFF and then it shows OFF. Press the power button, the digital tube shows the last time parameter, for example 3.15. The first digit shows power, the second and third shows sealing time. For example, 3 means the power is at 3rd level, 15 mean the sealing time is 1.5 seconds.

### 3.2 Adjustment

#### 3.2.1 Power Adjustment

Press button P to adjust the power between level 1 and level 5 which is 800W, 900W, 1000W, 1100W and 1200W, for small diameter below 30mm, we shall set the power at high level to improve the sealing speed. For big diameter over 60mm, we shall set the power at low level to achieve sealing quality.

### 3.2.2 time adjustment

The left T is for adjusting the number on ones place and the right T is for adjusting the number on tenth place. The ones place cycles from 0-5 and the tenth place cycles from 0-9. So the sealing time adjusting range is 0.1-5.9 seconds.

### 3.3 Trial Sealing

Place the bottle containing foil under the middle place of the sealing head (the foil side should face the bottle mouth), press the handle button, and the digital tube shows countdown sealing time with signal sound 'di' (each time for the start and end). Digital tube showing 0 means the sealing work is done and the digital tube will show the counting number for sealed bottle quantity and the machine enters into stand by mode again.

Under smart working mode, press the sealing head center on the bottle mouth center, machine will heated sealing automatically without pressing the handle switch. Machine shows time counting down and when you hear the sound 'di', it means sealing work has finished. The machine will not heat if there's no film inside the bottle.

Take off the cap to check the sealing condition. If the foil is even, smooth and tight, and the card is already separated completely from the foil and also the foil is completely glued on the bottle mouth, then it means the sealing looks great and qualified.

If the bottle mouth is only partly sealed, maybe it is because we didn't screw the cap on tightly before the sealing work which causes the foil can not press completely on the mouth. We should put the foil in the cap and press tightly to try again.

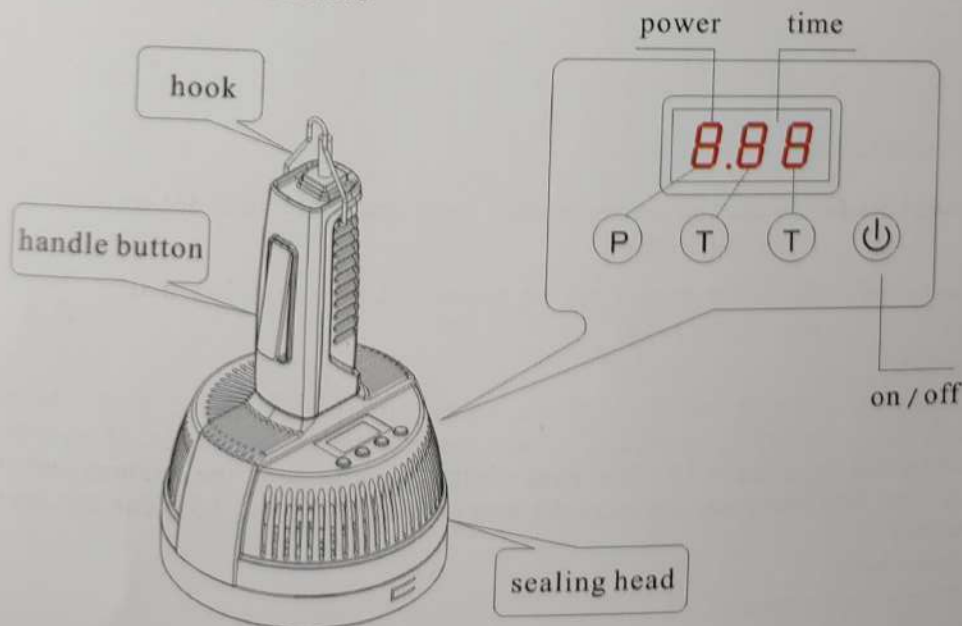
The sealing looks good, but the foil can be removed easily by hand pull or the card and foil didn't separate. This may because the sealing time is insufficient or the foil material didn't match bottle's material. The solution is to readjust the sealing time or change to different material.

If the bottle foil is wrinkled and bottle melts apparently, it means the sealing time is too long and we should shorten the time.

### 3.4 Start Working

Machine can start to seal mass quantity of bottles after all these requirements are met. We need to re-adjust the sealing time if we change to different group of bottles and foils. When the work finishes, press the power button to turn the machine off. When we need to start work again, we can press the power button again to turn it on. And the system will continue with the last time data including power and sealing time.

### 3.5 Operational Panel Photo



## IV Notice

### 4.1 Failure Code

E0: voltage too low      E1: voltage too high      E2: temperature of power tube too high  
E3: temperature transducer power off      E4: temperature transducer short circuit  
E5: induction coil off power      E6: surge protection



### 4.2 Maintenance

Unprofessional people is not allowed to open the machine. There is strong electricity existing inside the machine. Please ask the certified technician to open the machine for maintenance and strictly abide by the notice issues, otherwise we can not guarantee safe operation

### 4.3 Surge Protection

When E6 shows on the panel, it tells us that there's instant over voltage or external cusp wave disturbance. The machine will start the surge protection and the sealing work fails this time. We need to re-start the power to continue the work.

### 4.4 Position Adjustment

When the machine is working, the bottle should be placed in the center of the sealing head to ensure good sealing quality.

Adjust the distance between sealing head and foil properly to micro adjust the induction current. The smaller the distance is, the stronger the current is. For sealing larger foil, we should increase the distance properly to lower the current (we can stick a nonmetal heat shield to solve this problem, shield should be made by yourself).

### 4.5 Sealing Material

The polymer on the foil should match the bottle material and we also should screw the cap to press the foil tightly.

## V Normal Question

Sometimes there is an unsealed bottle in every ten or twenty bottles. No matter the power is high or low, the common question is: what happened to the induction sealer?

The same induction sealing effect depends on the consistency of the process. The unrelated reasons may affect the sealing effect. To achieve good sealing quality, the foil should be fully touched with the bottle mouth under the screw strength and the foil material should match the container material and should be fully exposed in the magnetic field to heat the foil and seal the bottle. Mistake made in any section will cause the sealing quality worse or not tightly.

Sealing inefficiency is usually due to insufficient pressure which makes the foil can not be touched with the bottle mouth completely. Or the exposure in the magnetic field is not enough. And material mismatching also happens sometimes, mostly because use bottles or containers from different suppliers or one supplier providing different groups.

## VI Certificate

CERTIFICATE OF QUALITY	
product name	_____
model number	DL-800
manufacturing code	_____
quality checker	_____
manufacturing date	_____
This product is qualified according to the delivery inspection	