

BIRNBERG MACHINERY

4828 West Main St., Skokie, IL 60077-2512, Tel: 847-673-5242, Fax: 847-679-6600
Email: rob@bagsealers.com Web: www.birnbergmachinery.com

Pacemaker Packaging – Chicago

Parts & Service for all Pacemaker & Amsco-Pacer Machines
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“DROPSEALER”

Gravity/Slide Bag Sealer

all models 615,618,620,624,630,636 and specials

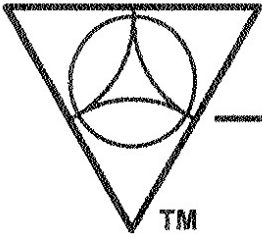
INSTRUCTION MANUAL

AND

SPARE PARTS LIST

COMMON PARTS:

- | | |
|--------------------|---|
| 21000 | Round Trimseal Element Wire .026, bulk roll (USE WITH 21003) |
| 21000.100 | Round Trimseal Element .026 with Ring |
| 21001 | Round Trimseal Element Wire .032, bulk roll (SINGLE WIRE) |
| 21001.100 | Round Trimseal Element .032 with Ring |
| 21003 | Flat Element Wire, bulk roll (DOUBLE SEAL-USE W/21000) |
| 21003.100 | Flat Element with Ring |
| 11003.025 | Lower Teflon for Shimming Flat Wire, 10 ft |
| 11000 | Lower Teflon Curtain, bulk sheet 18" x 36" |
| 11000/S | Lower Teflon Curtain, bulk 10" x 10yds |
| 11001 | Upper Teflon Cover, bulk |
| 94022/_____ | Upper Mushroom Rubber (place model number for length) |
| 94019 | Heat Control |
| 91000 | Cycle Switch |
| 95026/_____ | Lower Jaw Assembly (place model number for length) |



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After uncrating, please check for Sealer damage during shipment. If found, please contact carrier.

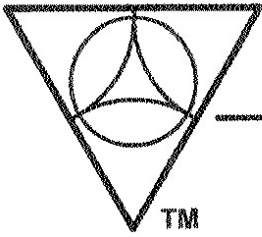
In area where Sealer is to be operated you will require a standard 115v, 15 amp, electrical line, and compressed air at 80 PSI, 3 CFM.

Each Sealer is shipped from factory with the following:

- 1 – Instruction Manual
- 1 – Spare nichrome wire
- 1 – Cycle switch (1 Impulse switch for Model 615THI-TDAF)
- 1 – ¼" pipe thread quick coupler
- 4 – Floor leveling studs
- 3 – Copies of instructions and maintenance of air regulator, water separator and lubricator – from manufacturer.

Suggested spare parts to keep on hand can be purchased from your distributor as follows:

- 1 – Cycle Switch
- 1 – Set of Teflon covers
- 1 – Nichrome Wires
- 1 – Impulse Micro Switch
- 1 – Bottle of silicone oil, for lubricator found near air regulator (#56). See NOTE on Silicone Mist Releasing – Page 4.
- 1 – Silicone Rubber Strip
- 1 – Relay PAC-1



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GENERAL DESCRIPTION AND FUNCTION OF SEALER

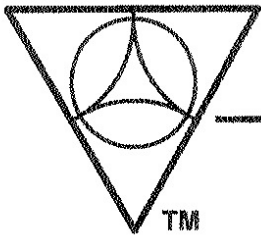
The Pacemaker Gravity-Feed Sealer (Drop Sealer) was developed to facilitate a means by which products put into a plastic bag could be sealed automatically at a fair rate of production. Your Sealer has a potential of sealing 30 units per minute, assuming it is fed at that rate.

HOW THE SEALER WORKS:

Bagged product is placed or dropped into Infeed Section (#45) of Sealer. From there it slides down and trips Cycle Switch Wire (#43) in Product Slide Table (#44), coming to a stop at the Finger Gate (#33) which is adjustable. When the Cycle Switch Wire is tripped, the following sequence occurs almost simultaneously:

- 1 – Upper Jaw (#1) closes to the “Down” or “Seal” position, clamping extended bag at point “B” between Silicone Rubber Strip (#3), which is covered by Teflon Cover (#4) in Upper Jaw and heated Nichrome Wire (#20, #20 and #21 for Double Seal), which is covered by Teflon Curtain (#7) in the lower jaw.
- 2 – Scrap Portion “C” is held against Infeed Section (#45) by Foam Rubber Strip (#2).
- 3 – Impulse is actuated and sending a 12 or 15 volt pulse into Nichrome Wire (#20, #21), which aids in making a clean seal.
- 4 – The pressure from the Upper Jaw clamping action and heated Nichrome Wire melts the plastic film to itself, making a seal.
- 5 – Approximately 1/10 of a second before the Upper Jaw opens, the Kicker Plate (#10) with a momentary vertical thrust, mechanically separates Scrap Portion “C” from the sealed film, while still hot and clamped by Upper Jaw Pressure.

Now that the sealed bag and scrap portion are separated, simultaneously the Upper Jaw opens, a flow of air from the Scrap Blow-off Tube (#46) blows Scrap Portion away, and Finger Gate (#33) lifts up, allowing sealed bag (assisted by gravity) to slide off the Sealer. As the sealed bag clears the Cycle Switch Wire, the Finger Gate returns to the “Down” position and air flow from the Scrap Blow-off Tube stops. As explained, this is one complete sealing cycle. Now the Sealer is ready for the next unit.



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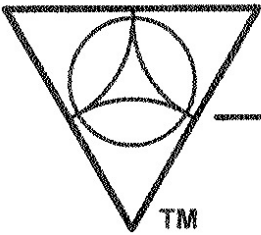
SEALER SET-UP

- 1 – Connect your compressed air supply to the Sealer. Use quick coupler furnished. Upper Jaw (#1) will rise to an open position when compressed air is connected to Sealer. Check Air Gauge (#56) and adjust for 80 PSI.

IMPORTANT NOTE: Your compressed air supply must maintain at least 80 PSI for good, consistent seals and scrap removal.

- 2 – Plug sealer line cord into proper electrical outlet. Sealer should be turned “OFF” at this time. Use On/Off Switch (#52)
- 3 – Adjust Infeed Product Guides (#45), Product Section Guides (#44) and incline angle or Sealer to allow bagged product to slide freely. All guides should be centralized on Sealer.
- 4 – Adjust Finger Gate (#33) for overall length of bagged product. Gate Assembly locks automatically when raised. To lower or increase distance from point “B”, release and hold spring-loaded length knob (#34) counter-clockwise to desired location. Now allow Length Adjustment Pawl to engage ratched gear attached to Product Length Knob, which locks Gate Assembly in position.
- 5 – Now that Sealer is adjusted for Bagged Product, proceed as follows:
 - 1: Turn Sealer On. Use ON/OFF Switch (#52). Pilot Light (#54) should light up.
 - 2: Set Upper Jaw Dwell Control (#50) between “3” and “4” on scaled index. NOTE: The higher the number, the longer the Upper Jaw stays in the “down” or “seal” Position.
 - 3: Set Heat Switch(#51) in the “desired” position (low production rate). Now the sealer is ready for sealing cycle test as described in Points 1 through 5 and paragraph following Point 5 of page 2. Sealed bagged product should exit sealer freely: if not, make necessary adjustments and proceed with your production run.

NOTE: Sealer must be turned ON at least 10 seconds to allow Nichrome Wire to reach Proper sealing temperature.



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MAINTENANCE OF SEALER

Your Sealer is a very important part of your production line and with a reasonable amount of care it will never let your production line down.

A visual check of the following items will eliminate 90% of all problems before they arise.

- 1 – Check all Teflon surfaces coming in contact with the seal area (“B”) for holes or build-up plastic residue. If holes are found, relocate Teflon covers to new section in the seal area. Gently scrape off any plastic build-up with fingernail, then use dab of silicone grease on rug and clean Teflon surfaces in seal area. Use grease very sparingly.
- 2 – Check Nichrome Wire (#20 & #21) by lifting Lower Teflon Curtain (#7) out of the way. Nichrome wire must be tight and straight across Transite Strip (#5). Transite Strip surface must be free of plastic build-up. Check Nichrome wire for good electrical contact. NOTE: Turn Sealer Off when checking Nichrome Wire.
- 3 – With Sealer turned off, check Cycle Switch by tripping Wire (#43) several times with finger. A low clicking should be heard when wire is tripped. Wire must spring back freely when released.
- 4 – Check motion of Upper Jaw and Gate Assembly. The up and down strokes should be free and easy – NO BANGING OR SLAMMING. Adjust appropriate air flow control, if necessary.
- 5 – Drain any water found in water separator bowl located on one side of Air Regulator (#56).
- 6 – Check Air Gauge for 80 PSI.

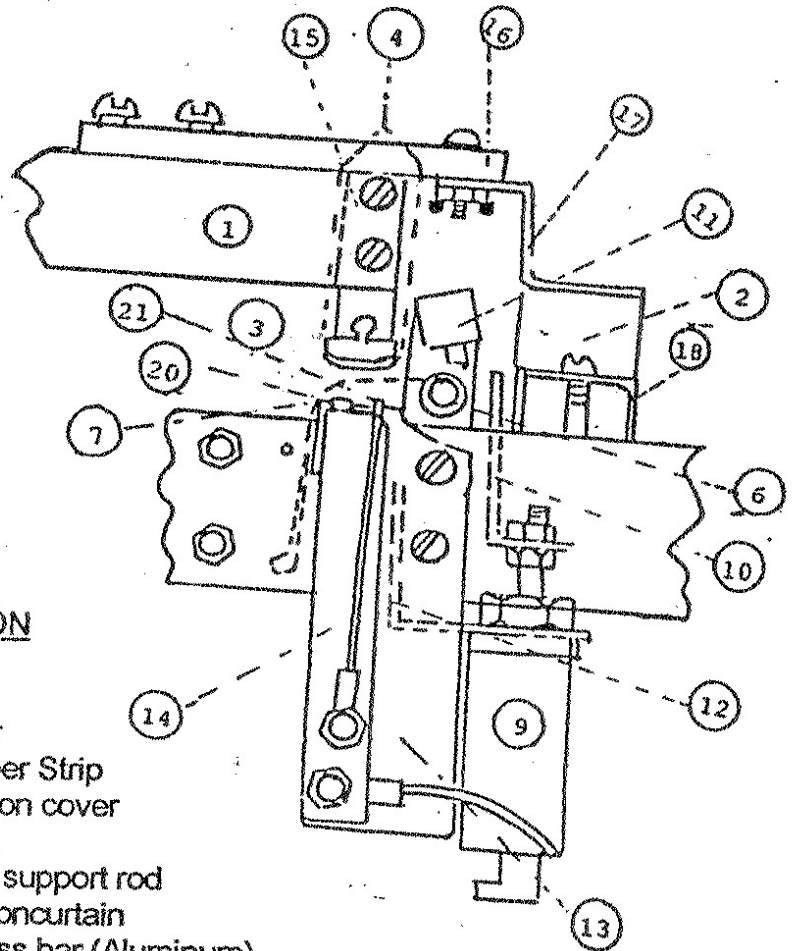
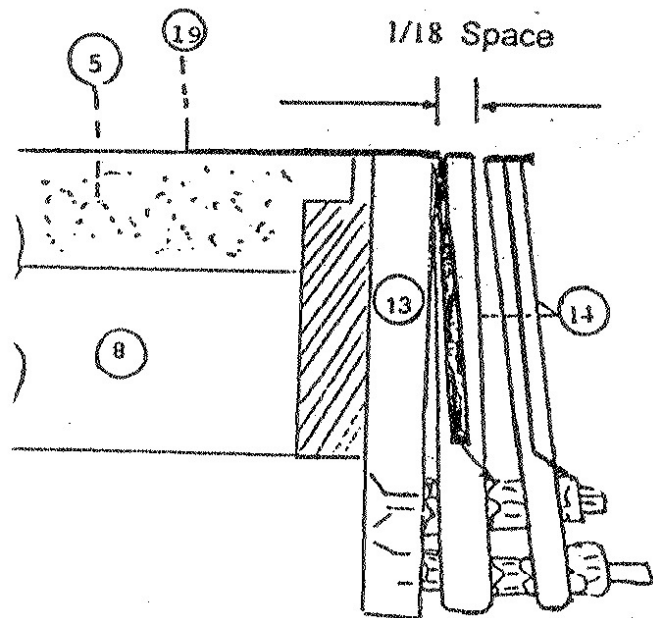
SILICONE MIST RELEASING

At the end of the sealing cycle, the sealed bag may on occasion stick to the lower teflon curtain. In most cases a check and cleaning of Teflon surfaces as indicated in Item 1 above will eliminate this. In addition to the foregoing and to further assist in releasing of the sealed bag, a fine silicone oil mist which is sprayed via Scrap Blow-off Tube (#46) can be employed as follows: Fill oiler (located on left side of Air Regulator (#56) ¾ full with silicone oil. Adjust feed rate for one drop of silicone oil for every twenty sealing cycles.

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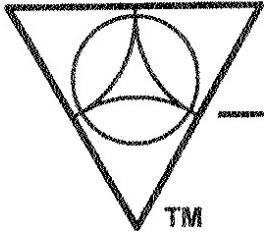


PART#

DESCRIPTION

- | | |
|----|----------------------------------|
| 1 | Upper jaw |
| 2 | Foam Rubber |
| 3 | Silicone Rubber Strip |
| 4 | Upper jaw teflon cover |
| 5 | Transite bar |
| 6 | Teflon curtain support rod |
| 7 | Lower jaw teflon curtain |
| 8 | Lower jaw cross bar (Aluminum) |
| 9 | Kicker plate cylinder |
| 10 | Kicker plate |
| 11 | Brass blow-off air fitting |
| 12 | Kicker plate cylinder bracket |
| 13 | Insulator Block |
| 14 | Flat Tension Spring |
| 15 | Upper jaw silicone holder |
| 16 | "Z" bar bracket |
| 17 | "Z" bar |
| 18 | "U" channel scrap hold-down |
| 19 | 1/2" Pressure Sensitive Teflon |
| 20 | Flat Nichrome Wire (1/16) |
| 21 | Round Nichrome Wire (.026, .032) |

PLEASE NOTE: Copper scrap blow-off tube is not shown

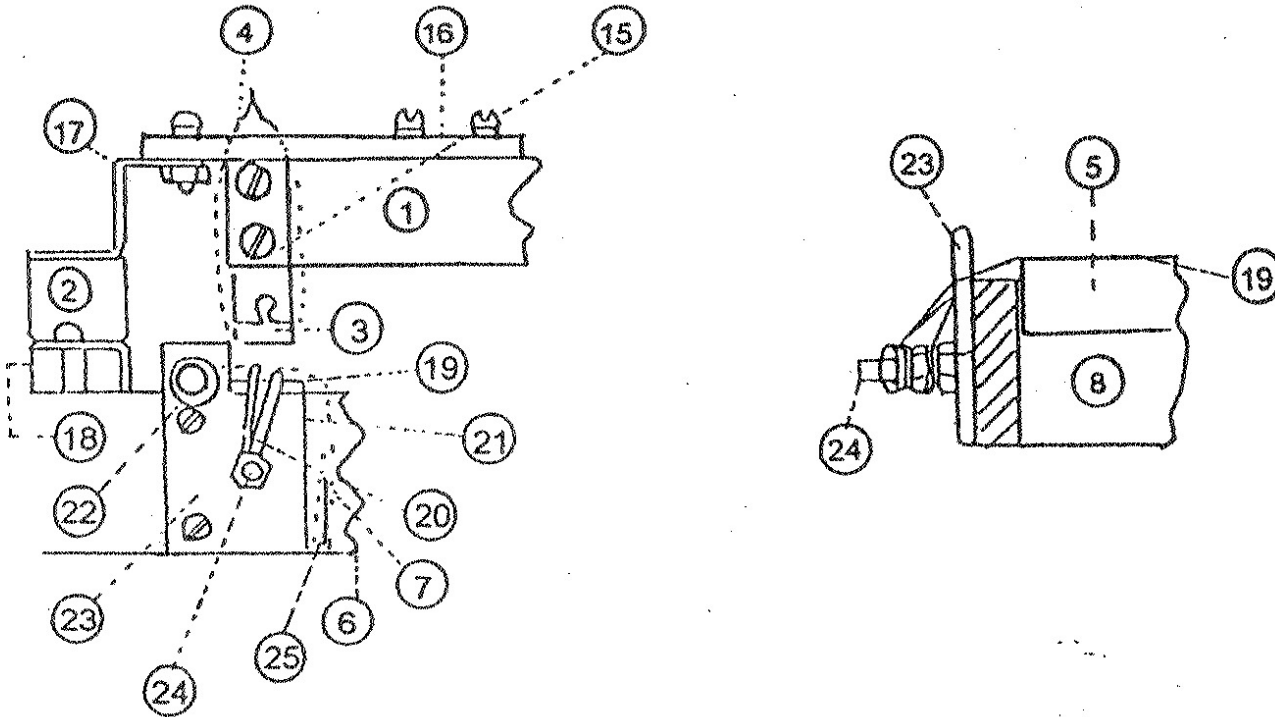


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Pacemaker Drop sealer

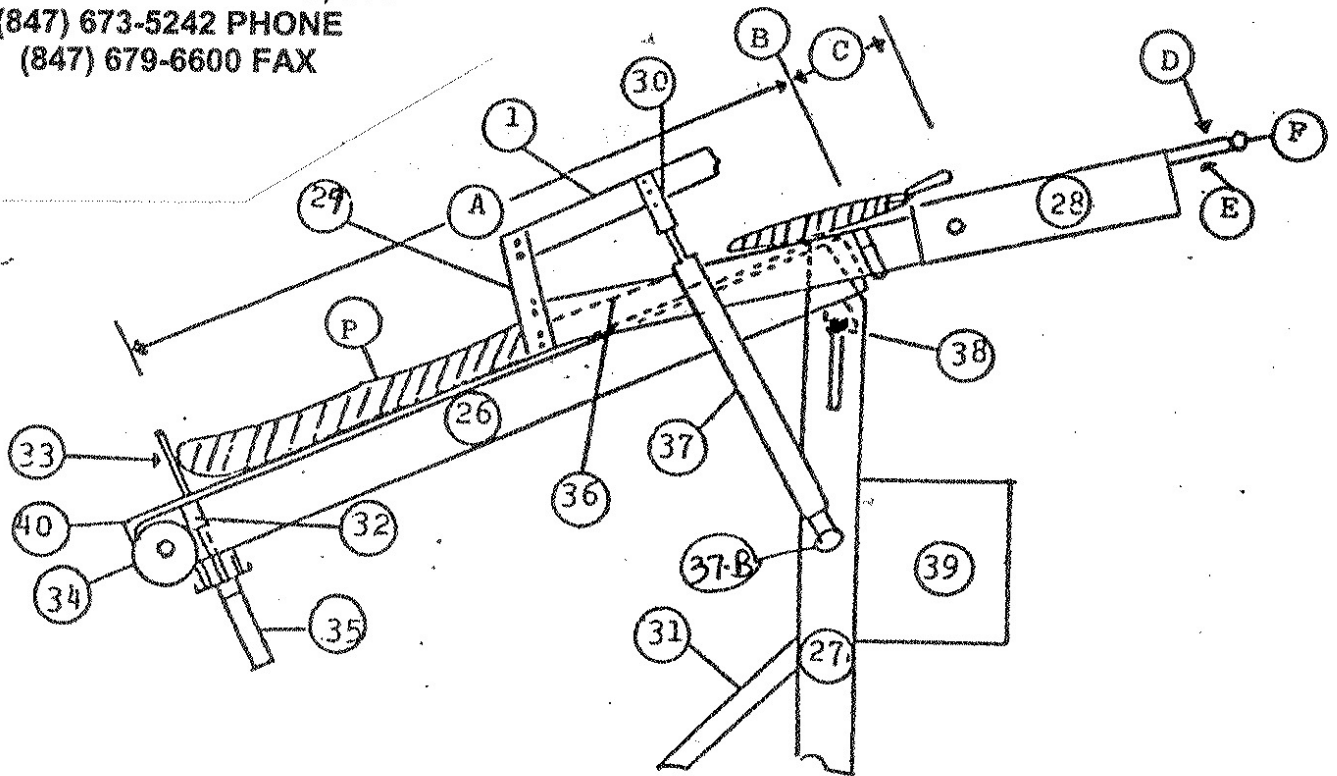


Side view

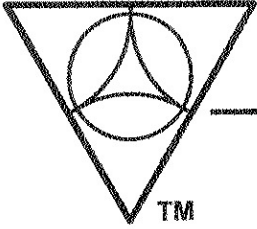
PARTS LIST

<u>Part no.</u>	<u>Description</u>
22.	1/4" Collar
23.	Teflon rod holder with 10/32 screw for nichrome wires
24.	1" 10/32 Recessed screw
25.	Teflon cover weight

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<u>PART #</u>	<u>DESCRIPTION</u>
26	Side of deck table (2)
27	Aluminum leg (2) vertical
28	Upper deck (Emergency shut-off, press down)
29	Upper arm bracket to base (2)
30	5/8 x 5/8 Aluminum bracket from upper arm to cylinder (2)
31	Aluminum leg support
32	Aluminum fingers holder
33	Fingers 2", 3", 4" in length
34	Product length adjustment knob
35	Gate cylinder 2", 3", 4" depends on length of fingers
36	Main assembly bar (left & right)
37	Jaw cylinder
37-B	Cylinder Mounting Studs
38	Adjusting table knob
39	Electrical box
40	Main product slide table



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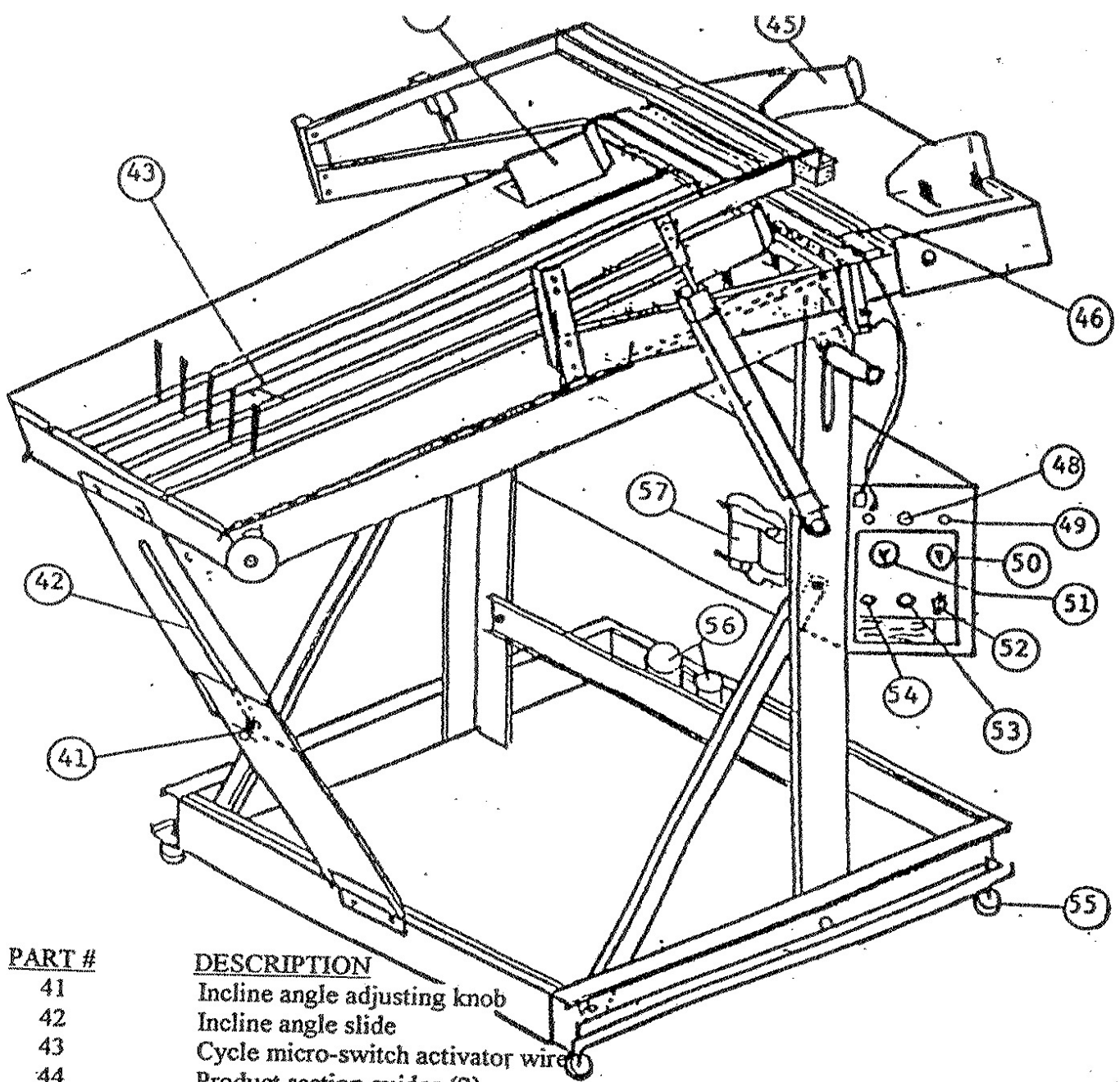
POINTS OF REFERENCE:

- A – Overall length of sealed bag.
- B – Point where seal is made over radius of preheated nichrome wire in lower jaw.
This point MUST be clear of printed copy across width of bag.
- C – Scrap portion of bagged product – removed by Kicker plate (#10) and blown away by Scrap blow-off tube. This portion should extend approx. 2-1/2" from Point "B" to allow Foam rubber (#2) to hold down Scrap Portion against Infeed Section Surface (#28)
- D – Line parallel to Infeed Section Surface (#28)
- E – Line parallel to Product Section Surface Slide Table (#40)
- F – Offset height between line "D" and "E"

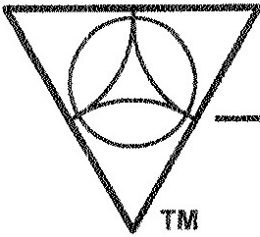
EXAMPLE: For a center seal of a 2" high product, "F" should be approx. 1" or half the bagged product's height.

NOTE: Product bottomed in bag should end no less than 1/2" from Point "B"

P – Product bottomed in bag



<u>PART #</u>	<u>DESCRIPTION</u>
41	Incline angle adjusting knob
42	Incline angle slide
43	Cycle micro-switch activator wire
44	Product section guides (2)
45	Infeed product guides
46	Scrap blow-off tube
47	Compression switch (not shown)
48	Nichrome wire fuse
49	Manual Cycle switch
50	Upper jaw dwell control
51	Heat Control
52	On/Off Switch
53	Main fuse
54	Pilot Light
55	Floor leveling studs (4)
56	Air regulator and filter (80 PSI)
57	4-way valve



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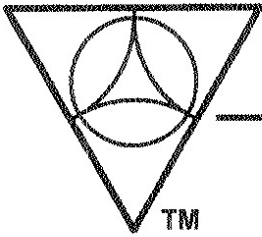
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PACEMAKER GRAVITY/SLIDE BAG SEALER PARTS LIST:

<u>PART #</u>	<u>DESCRIPTION</u>
1	Upper jaw
2	Foam Rubber
3	Silicone Rubber Strip
4	Upper jaw teflon cover
5	Transite Bar
6	Teflon curtain support rod
7	Lower jaw teflon curtain
8	Lower jaw cross bar (Aluminum)
9	Kicker plate cylinder
10	Kicker plate
11	Brass blow-off air fitting
12	Kicker plate cylinder bracket
13	Insulator block
14	Flat tension spring
15	Upper jaw silicone holder
16	"Z" bar bracket
17	"Z" bar
18	"U" channel scrap hold-down
19	½" Pressure sensitive Teflon
20	Flat nichrome wire (1/16)
21	Round nichrome wire (.026, .032)
22	¼" Collar
23	Teflon rod holder bracket with 10/32 screw for nichrome wires
24	1" 10/32 Recessed screw
25	Teflon cover weight
26	Side of deck table (2)
27	Aluminum leg (2) vertical
28	Upper deck (Emergency shut-off, press down)
29	Upper arm bracket to base (2)
30	5/8 x 5/8 Aluminum bracket from upper arm to cylinder (2)
31	Aluminum leg support
32	Aluminum fingers holder
33	Fingers, 2", 3", 4" in length
34	Product length adjustment knob



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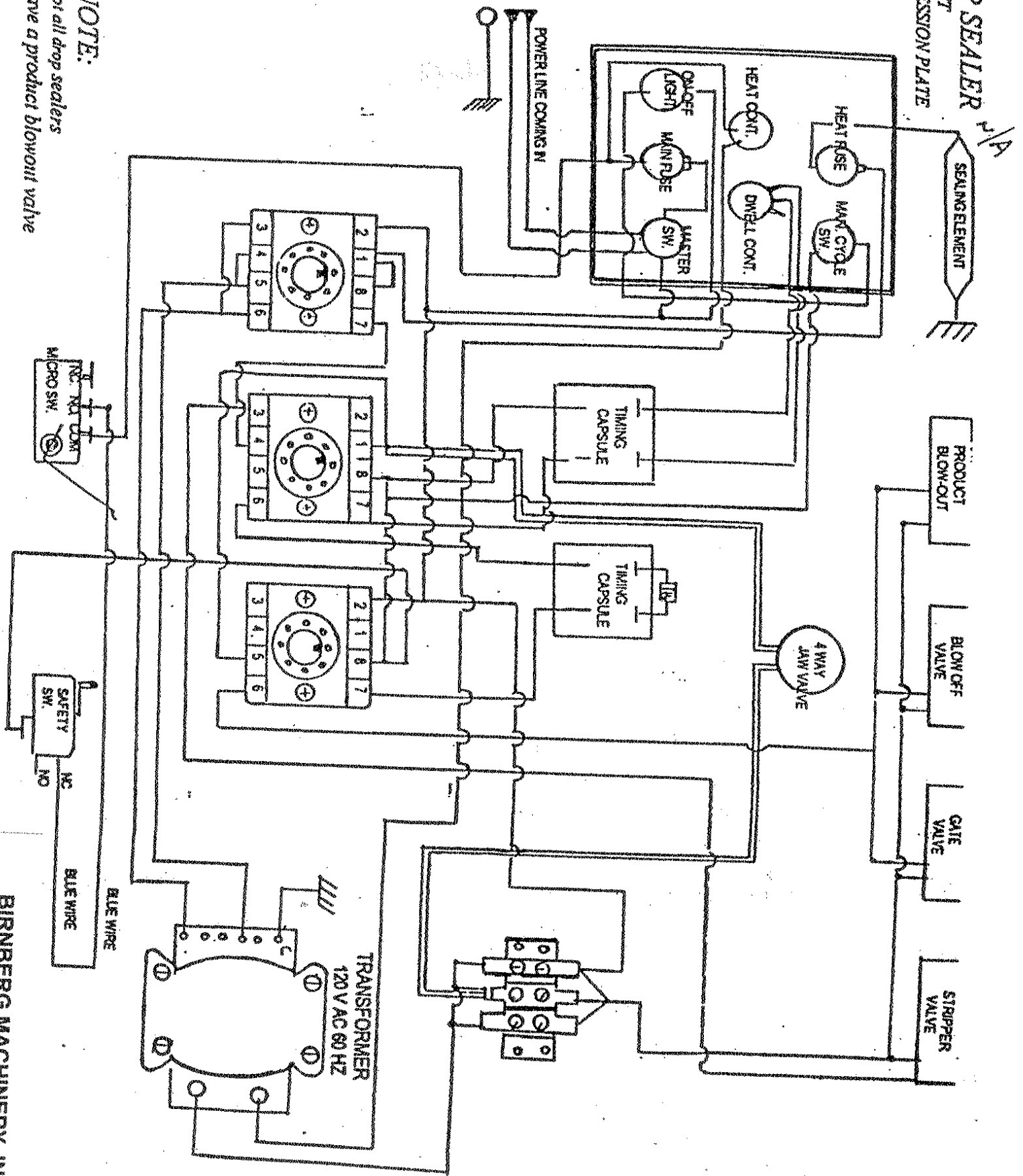
PARTS LIST CONTINUED

<u>PART #</u>	<u>DESCRIPTION</u>
35	Gate cylinder 2", 3", 4" depends on length of fingers
36	Main assembly bar (left & right)
37	Jaw cylinder
37-B	Cylinder mounting studs
38	Adjusting table knob
39	Electric box
40	Main product slide table
41	Incline angle adjusting knob
42	Incline angle slide
43	Micro switch w/ activator wire
44	Product section guides (2)
45	Infeed product guides
46	Scrap blow-off tube
47	Compression switch (not shown)
48	Nichrome wire fuse
49	Manual cycle switch
50	Upper jaw dwell control
51	Heat Control
52	On/Off Switch
53	Main fuse
54	Pilot light
55	Floor leveling studs (4)
56	Air regulator and filter (80 PSI)
57	4-Way Valve

Parts List Continued (THESE PARTS MAY NOT ON BE ON DIAGRAMS)

<u>PART#</u>	<u>DESCRIPTION</u>
58	Brass Pin for Wire
59	Transformer
60	Tw- Way Valve

ROP SEALER

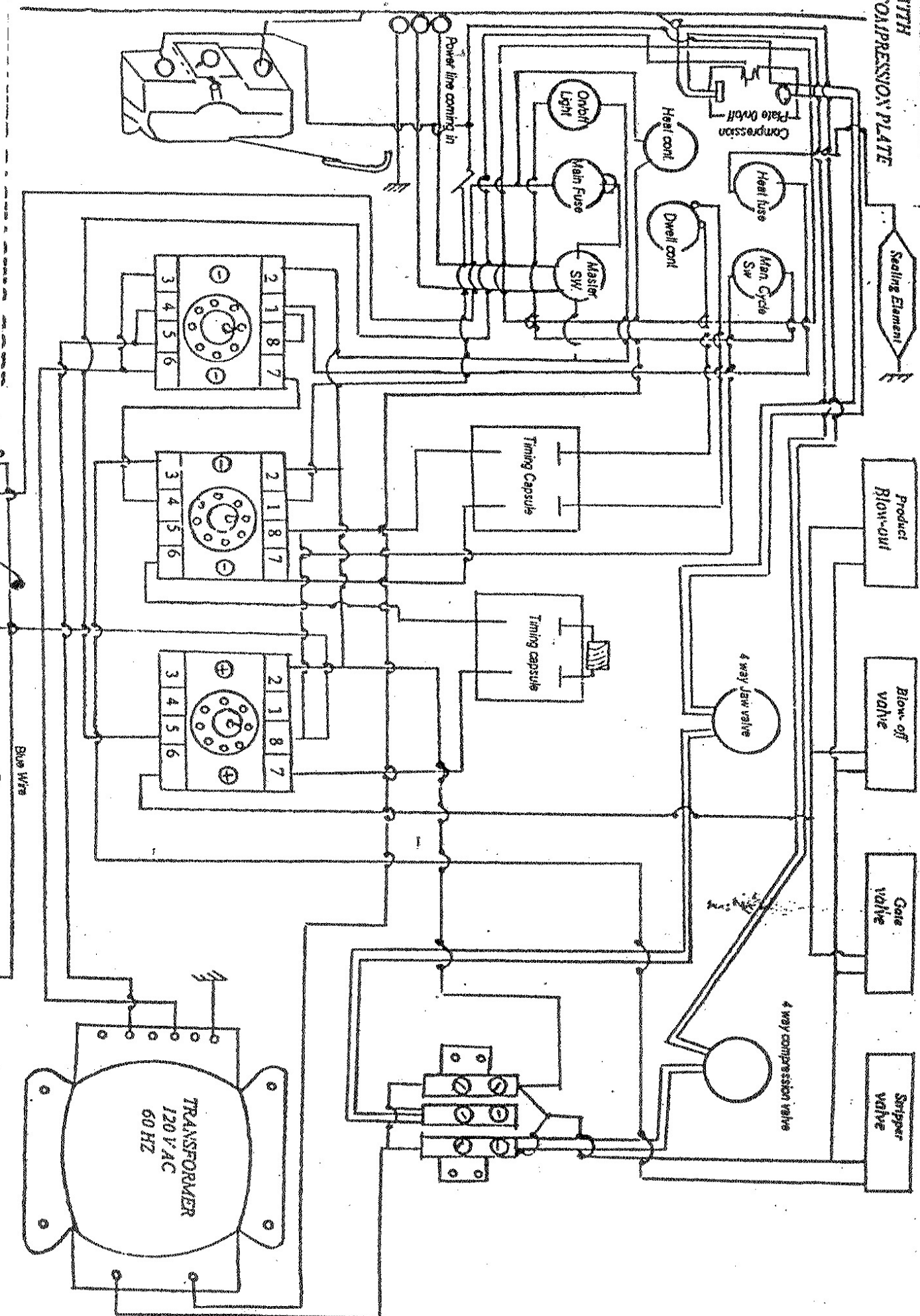


NOTE:

Not all drop sealers have a product blowout valve

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DKOP SEALER *
WITH
COMPRESSION PLATE



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NOTE:
 Not all drop sealers
 have a product blowoff valve