

## CATALOGUE

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## **GUARANTEE**

The guarantee is valid for a period of 12 twelve months from the date of delivery of the wrapping machine.

Any work carried out under warranty must be performed by us or our authorized distributors.

During the guarantee period, we will replace, free of charge, any parts found to be faulty due to hidden defects in the materials or defects due to the construction, working and assembly carried out in its factory, where the pieces to be replaced or the machine must be returned carriage paid.

In the case in which the replacement or repair must be carried out at the customer's premises, the labour, travelling expenses and accommodation of the technicians or installers will be at the total expense of the customer.

The guarantee explicitly excludes all those pieces subject to normal wear (such as sealing blades, Teflon tape, rubbers, seals, etc.) and electrical parts.

The supplier is liable for faults deriving from the normal use of the machine, and not for those deriving from:

- incorrect installation;**
- lack of maintenance;**
- incorrect machine use;**
- tampering or repairs carried out by the customer;**
- unauthorized modifications;**
- connection to incorrect power supply;**
- in the case in which the machines is no longer the property of the original purchaser;**
- use in a different manner than that described in the instructions.**

Furthermore, we will not be liable for any damage to people or property distinct from the machine covered by the guarantee, nor for any loss of production.

**We refuses all liability for damage caused to people or property in the case in which the machine is not earthed.**

## **SAFETY INFORMATION**

Read all the instructions carefully before use. In the case of uncertainty, contact the Technical Service for explanation, quoting the number of the page and the paragraph with the operating procedure in question...

### **Keep this instruction manual.**

The information that it contains will help you to keep your machine fully efficient and to work in perfect safety.

Only connect the machine to a power supply equipped with earth and protected by a differential switch with an intervention limit of 0.03A. In the case in which problems should occur, do not intervene directly, but contact the technical service or the authorized dealer. We refuse all liability for damage caused to people or property as a result of the direct intervention of the purchaser.

Before carrying out any operation, make sure that the general switch is on the "OFF" position, and remove the plug from the socket.

## **LIMITS OF USE**

**The machine must not be used in the following locations; open-air environments and/or those exposed to the elements, environments containing steam, fumes corrosive and/or abrasive dusts, environments with fire or explosion hazards, and in any case wherever the use of fireproof components is required.**

**The electrical equipment operates correctly within an ambient temperature range of +5 °C to +40°C and with relative humidity limits of less than 50% at 40°C and less than 90% at 20°C.**

**The machine is not suitable for operation in the presence of ionizing and other kinds of radiations (X-rays, lasers, microwaves, ultraviolet rays). The machine must be stored at a temperature between -5 °C and +55 °C.**

## **QUALIFICATIONS OF THE OPERATORS**

Only workers possessing the following qualifications may be allowed to use the machine:

### **Machine operator**

An operator trained and qualified to operate the machine during functioning, comprising the use of the general switch and all the various controls present on the machine itself, assembly of the roll of plastic film, various adjustments depending on the format of the goods to be packaged, stopping and resetting of the machine.

### **Mechanical maintenance man**

A qualified technician capable of running the machine like the machine operator and also to enable it to operate without the protective devices in the case of work on the mechanical parts for adjustments, maintenance or repairs.

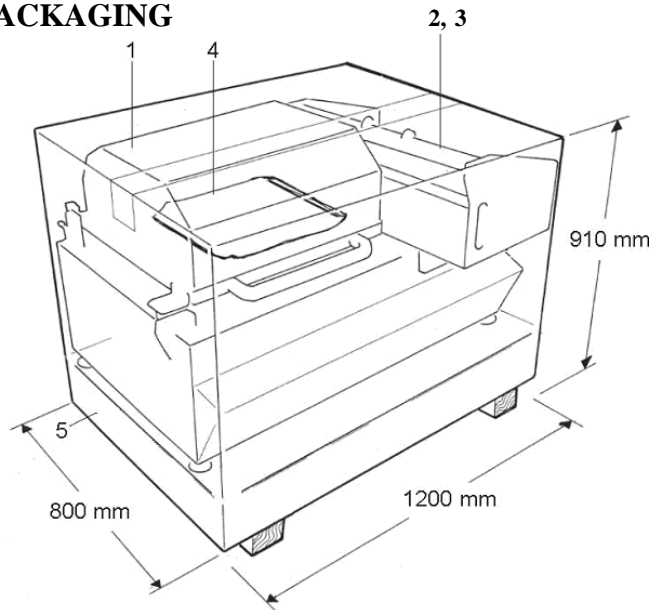
He is not qualified to operate on the live electrical systems.

### **Electrical maintenance man**

A qualified technician capable of running the machine like the machine operator and also to enable it to operate without the protective devices in the case of work on the electrical systems for adjustments, maintenance or repairs.

**It is the responsibility of the user to define the qualified workers at the various levels of operation and to provide them with the appropriate training and operating instructions.**

## PACKAGING



1. Machine body
2. Film holder carrier
3. Film holder shaft with cones
4. spare parts and use and main-tenance manual
5. Box with machine support

The 4255ST sealing machine is generally dispatched fully assembled in a cardboard box, mounted on a pallet that, in addition to acting as a base, also makes handling easier.

**Particular care must be taken when unpacking, as the machine also comprises some plastic parts that require gentle handling.**

**Pick up the machine as described in the following paragraph-**

The cardboard box contains:

- the film holder unit (disassembled and resting on top of the machine);
- the film holder shaft with cones for assembling the reel.

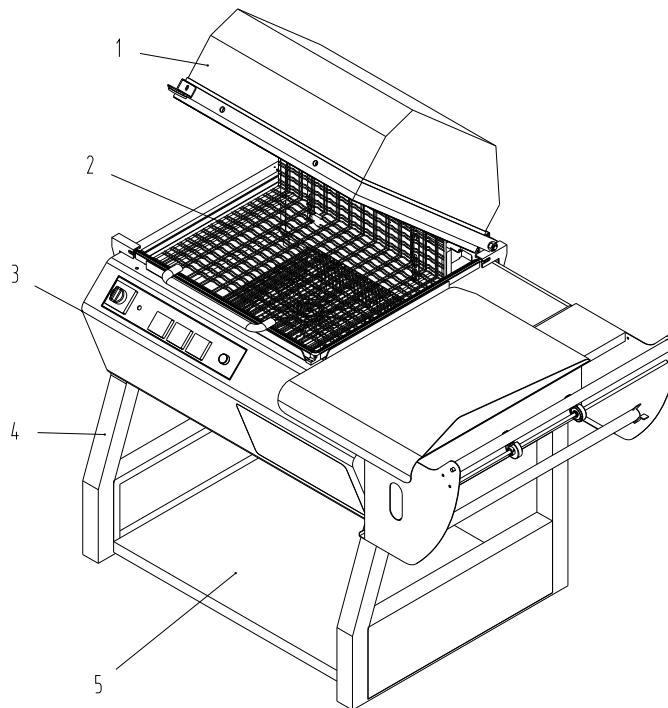
Beneath the transparent hood is a bag containing:

- 1 spare sealing blade;
- 1 spare roll of Teflon tape;
- 1 spray can of detaching product;
- Manual for installation, use and maintenance.

The cardboard box with the "machine stand" (optional), supplied fully disassembled, contains:

- 1 lower platform;
- 2 angled uprights;
- 2 panels;
- 1 transparent bag containing casters and nuts and bolts.

## UNPACKING AND INSTALLATION



1. Transparent hood
2. Grille
3. Machine body
4. Supporting foot
5. Lower platform

### Assembly of the machine stand (optional)

-Screw the casters onto the lowerplatform and tighten well; assembly the two angled on the lower platform and insert the doors in the open space of the two angled.

### 4255ST Wrapping Machine

-Remove the machine from the packaging, holding it by the front and back sides; **do not hold it by the handle of the hood or the film holder unit (this operation must be performed by two people).**

-Rest it on the the stand, checking that the feet of the latter are correctly positioned in the appropriate spaces. -Insert and fasten the locking screw (7) in place, but not too tightly.

-If a support stand is not available, rest the machine on suitably sized work top with a level minimal height 60 cm /23.6 in., smooth and dry surface capable of supporting the weight of the machine ( 60~90kg/132.4~198.6 lb.).

-Release the transparent hoodby removing the sticky tape or the support; remove the bag containing the spare parts and the manual and check that the grille is correctly positioned.

-The transparent hood must be left open!

## DESCRIPTION AND TECHNICAL CHARACTERISTICS

### **4255ST Wrapping machine**

Machine for the packaging of products with single-fold sealing film, with dimensions contained in the range indicated in the following paragraphs, with angular sealing of the film and featuring simultaneous cutting or sealing-cutting and shrink-wrapping.

Each time that the operator lowers the transparent hood the heat of the sealing wire and its pressure against the bottom Teflon-coated edge on the machine body cause the film to melt and the edges to separate, thus creating the packaging.

The shrinking of the film can be carried out at the same time as the cutting and is achieved by the circulation of hot air forced around the package.

### **THE FOLLOWING ITEMS MUST NOT BE PACKAGED:**

- loose granular products;
- wet products;
- liquid and/or gelatinous products if not contained in another package;
- highly flammable products;
- explosive products;
- aerosol cans with pressurized gas, etc.;
- anything that could damage the machine or constitute a danger to the health of the operator (for example, acids, corrosive substances, salt).

In the case of use with food products, it is advisable to use plastic sealing film suitable for contact with food. In any case, we remind you that the machine is not suitable for contact with food products.

### **PLATES (warning signs and CE mark)**

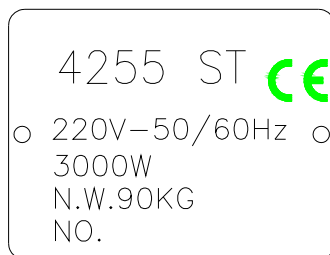
The machines are manufactured in conformity with the EC Machines Directive EEC 98/37, the Low Voltage Directive (DBT) EEC 73/23 and the successive amendments, the Electromagnetic Compatibility Directive (EMC) EEC 89/336 and the successive amendments. All the components of the machine satisfy the requirements of the Directives and the **CE mark** testifies to its conformity.

### **Legibility and conservation of the plates**

In the case in which a plate should deteriorate and/or even one of the pieces of information shown should no longer be legible, request a new one from the manufacturer and see to its compulsory replacement.

## PLATES

### A) Technical information and CE Mark



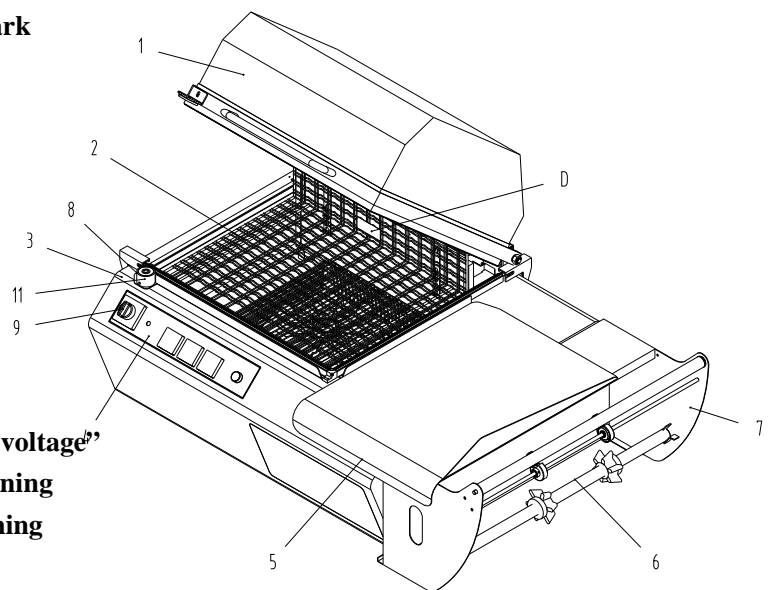
A

### VARIOUS HAZARDS

B) General warning of "presence of voltage"

C) "Danger!High temperature" warning

D) "Danger High temperature"warning



B

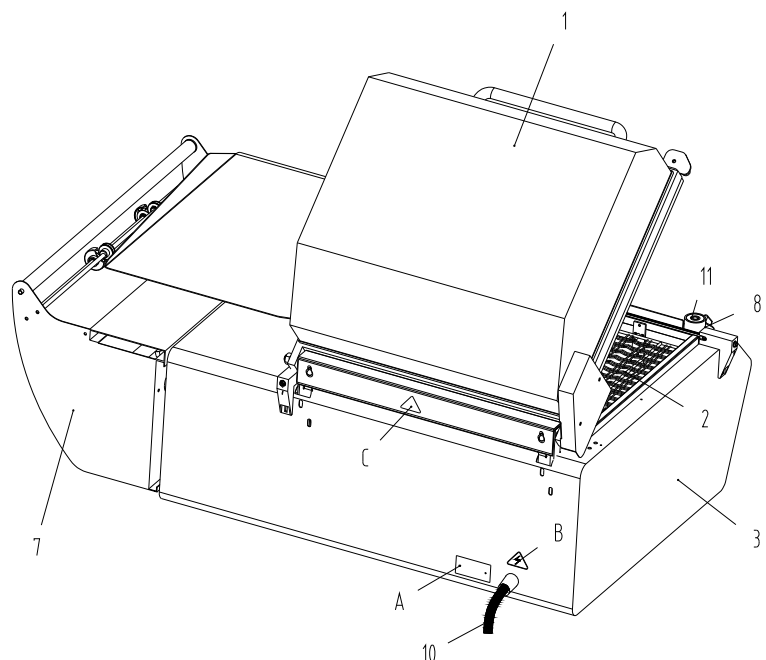


C



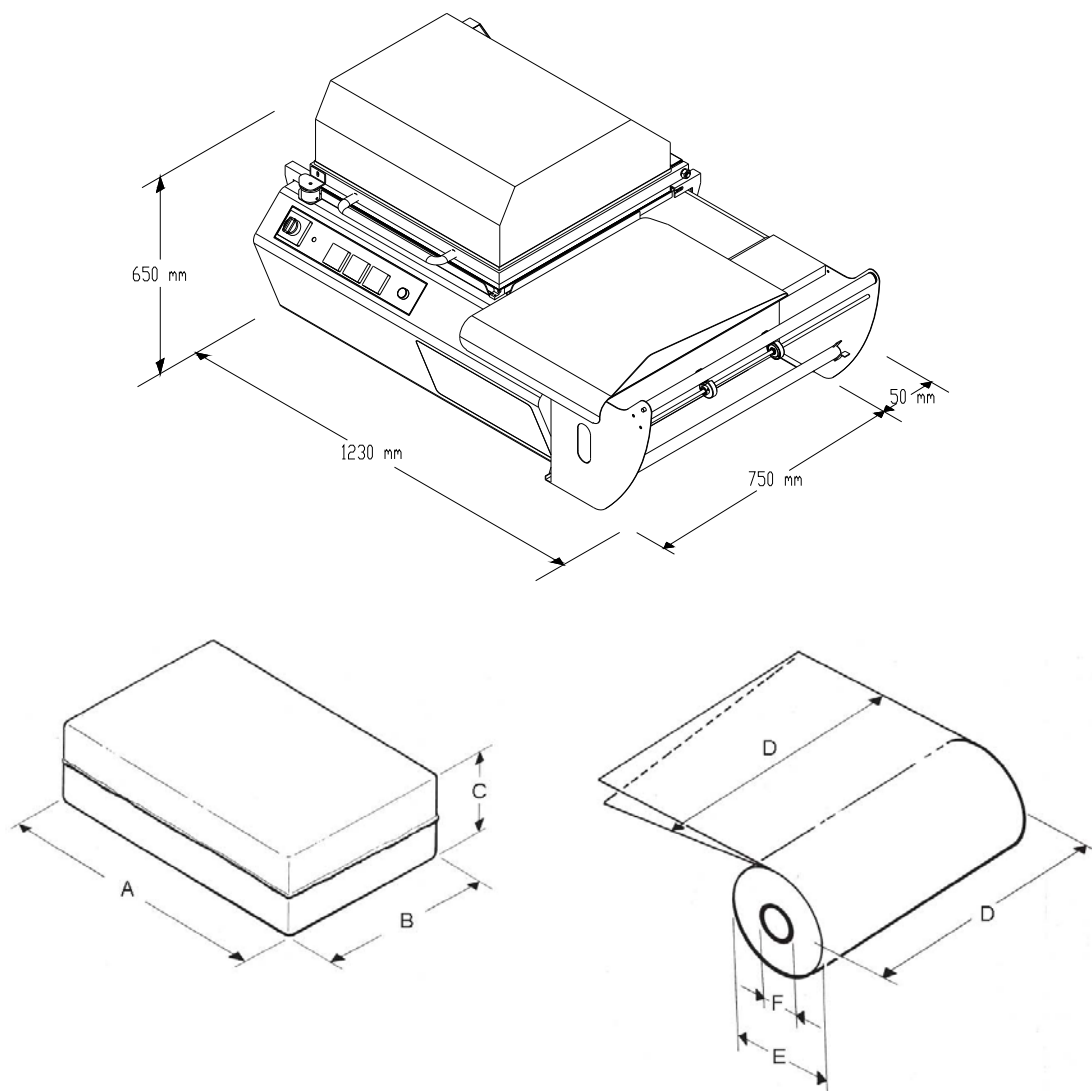
D

1. Transparent hood
2. Grille
3. Machine body
4. Control panel
5. Working table
6. Film holder shaft with cones
7. Film holder with piercing wheels
8. Start cycle device
9. General switch
10. Power lead (with plug)
11. Magneto



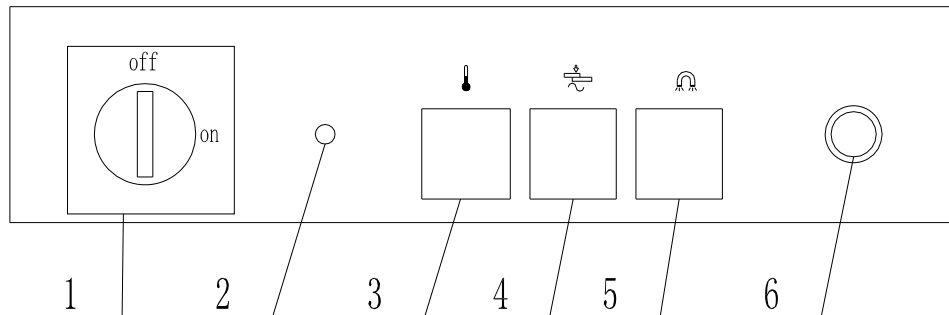


## PERFORMANCE PARAMETER



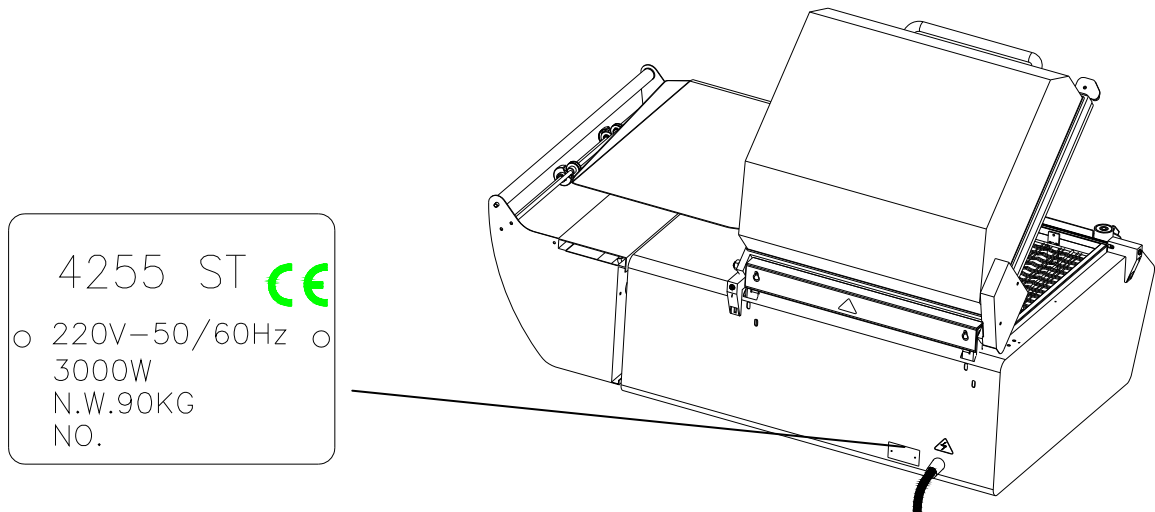
- Weight of machine:..... 90kg.
- Weight of stand:..... 18kg
- Height of working table (on stand):..... 920mm
- Dimensions of sealing:..... 420 x 550 mm
- Power:..... 3.5 kW
- Power supply voltage: ..... 220V singlephasic (see “Technical information plate”)
- Level of acoustic pressure emitted: ..... 71 dB (A)
- Electrical input: ..... 16 A at220 V
- Packaging capacity:
  - Min. (A x B X C) 50 x 50x1mm.
  - Max. (A x B x C) 550 x 420x200mm
- Notes: B + C must never exceed 520mm.; It is not possible to create packages with the maximum dimensions A x B x C.
- Film to be used for packaging: Single-fold sealing film, thickness 0.015~0.050mm. Dimensions (D x E x F) 570 x250x 75mm.

## CONTROLS



1. MAIN SWITCH  
-“OFF”  
-“ON” SEALING ONLY
2. POWER LIGHT
3. THERMOREGULATOR
4. SEALING TIMER
5. MAGNET TIMER
6. SWITCH (SEALING+SHRINK-WRAPPING)

## CONNECTION TO THE POWER SUPPLY



**It is the responsibility of the user to provide a suitable electrical distribution system (control panel, socket, earth system, etc.) in compliance with the current regulations. In particular, it is advisable to use a differential switch with an intervention limit of 0.03 A.**

The power supply must be appropriate for the machine and must comply with the margins set out in the relevant standards. The CEI-EN 60204-1 standards apply in the case of the electrical apparatus of the 4255ST machines, and consequently the power supply must have a maximum margin of 10% over the voltage value and a maximum margin of 1% in a continuous manner and 2% for a brief period of time over the value of the frequency.

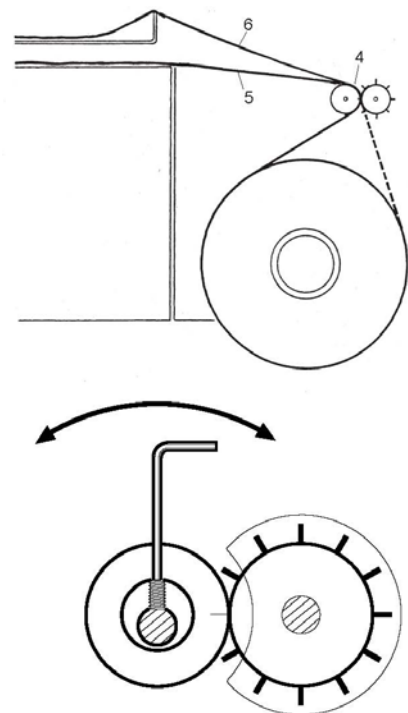
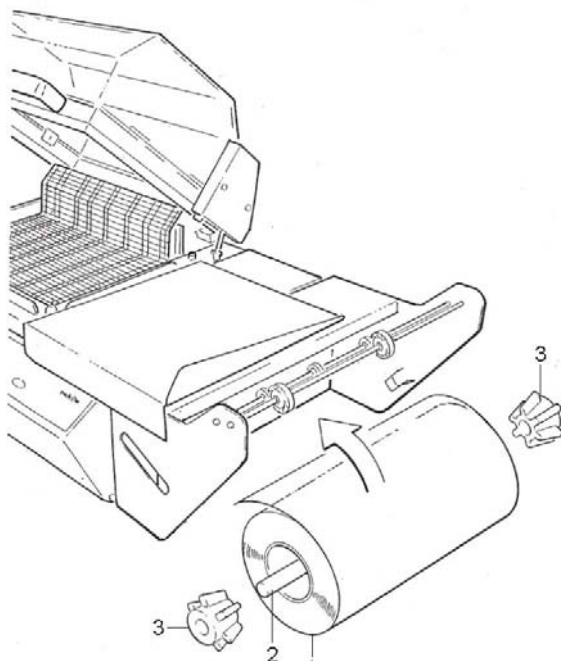
**The system must be equipped with an automatic release system with a differential automatic magnetothermic switch and an earth system that guarantees the minimum parameters required by the standards, observing in any case the specific requirements of the current laws in the country in which the machine is installed.**

**Before connection, check that the characteristics of the mains power supply match those indicated on the information plate on the machine. Check** that the general switch is in the “0” position. **Do not make** any “mobile” type connections using extension leads and/or temporary cables, if necessary request the intervention of trained and qualified staff. **Mark** the presence of the power cable(s) on the ground if a connection of another type is not possible and the passage of people is expected in the area of installation. **Do not leave** cables on the ground in the area of vehicle transit.

### **Illumination**

The machine is equipped with a lighting system. The level of illumination of the room must always be sufficient to avoid areas of shade and to guarantee operation in maximum safety in relation to the type of activity (use, cleaning, maintenance, etc.).

## ASSEMBLING THE REEL AND THREADING THE FILM



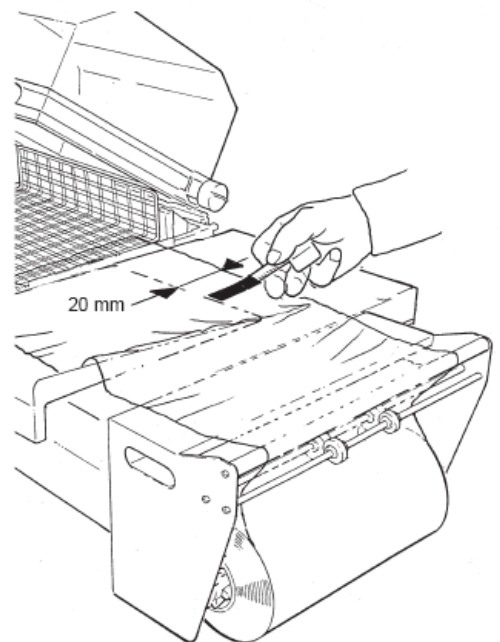
-Place the reel of plastic film (1), with the fold on the right, on the shaft (2) positioned to the far left, locking it in place with the centering cones. The reel may be unwound in a clockwise or anticlockwise direction.

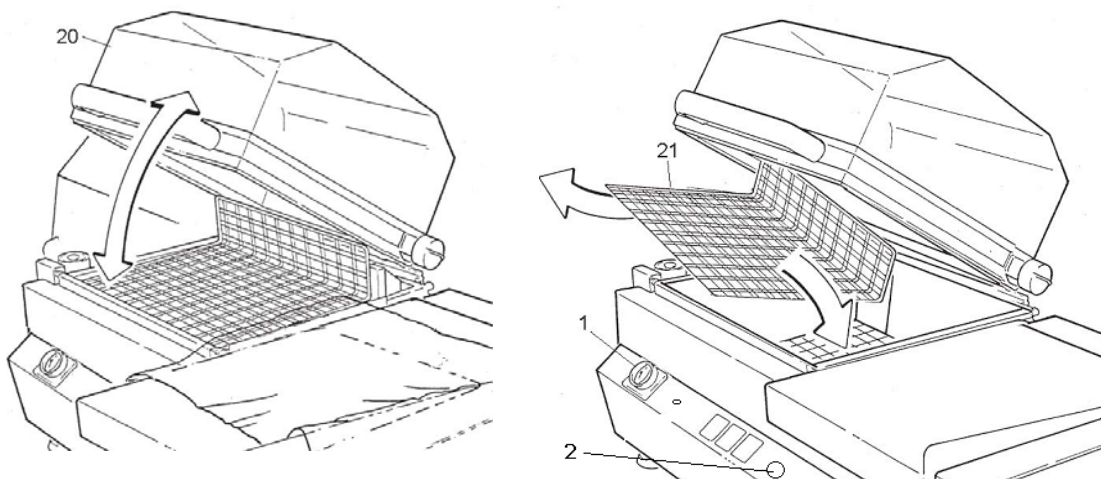
-Insert the end of the shaft in the special spaces on the film holder, making sure that the open side of the film is turned towards the front side of the machine, i.e. the operator.

-Unroll the film and pass it between the piercing wheels (4);

-Pass the lower (5) and upper edge (6) of the film under and over the working table respectively.

-Check that the perforating wheels perforate the film and adjust them if necessary, using a 2 mm hexagonal key on the cam. If the film is thin, the wheels must skim the body of the wheels with the needles, whilst in the case of thick film they must exert greater pressure.





## PRELIMINARY OPERATIONS

- Activate the general switch;
- Select the desired operating mode by turning the (1) for “sealing only” or (2) “sealing and shrink-wrapping”;
- Check that the temperature display comes on, according to the operating mode selected;
- Set the sealing time rotating the wheels;

**CAUTION: A sealing time of 50 has been set during testing and calibration. It is advisable to maintain this setting the first time the machine is started.**

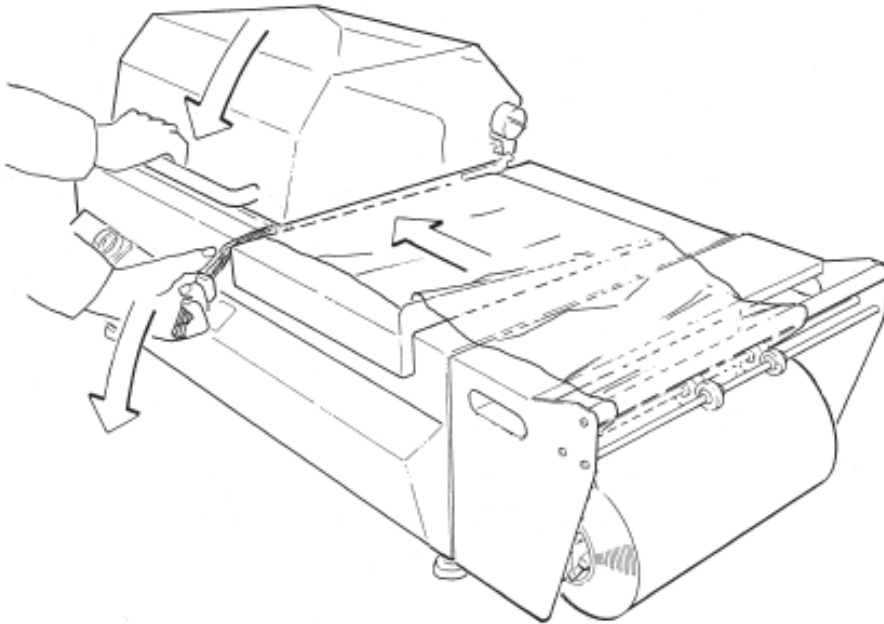
- Set the value of the desired temperature on the thermo regulator no higher than 145.

**CAUTION: The temperature has been set to 135 during testing and calibration. It is advisable to maintain this setting the first time the machine is started.**

- Wait approximately 7-8 minutes to reach the temperature set, which is indicated by the signal light (led) going off.
- Preheat the machine by lowering and raising the transparent hood (20) 2-3 times (applying light pressure during closure); wait approximately 5 seconds between repeats;
- Check the position of the grille (21) according to the product to be packaged, so that the sealing is carried out at **approximately half its height**;

In order to perform this operation, remove the grille, unscrew the supporting feet located in the front part of the basin and screw them back in position in the holes provided at the desired height, then reassemble the grille, resting it first on one of the rear hooks corresponding to the chosen height.

## PERFORMING THE FIRST SEALING OPERATION



- To carry out the first sealing operation, pull the film forward on the left side, as required, onto the lower edge of the sealing bar (basin perimeter).
- Lower the hood with the right hand and maintain a light pressure, thus obtaining the automatic activation of the machine and the first sealing operation. Use the left hand to help detach the film from the sealing bar.
- The film is thus ready for the successive product packaging operations.

## METHOD OF USE

Grasp the film in the left hand and pull it in the same direction for a few centimeters in order to permit the product to be packaged to be introduced easily.

Lift the upper edge of the film with the left hand.

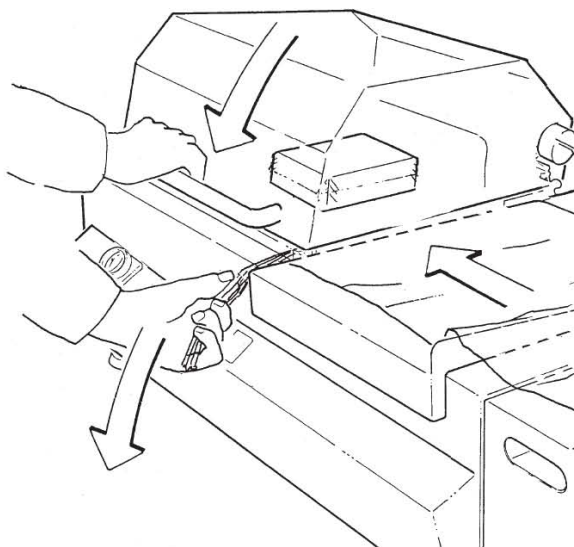
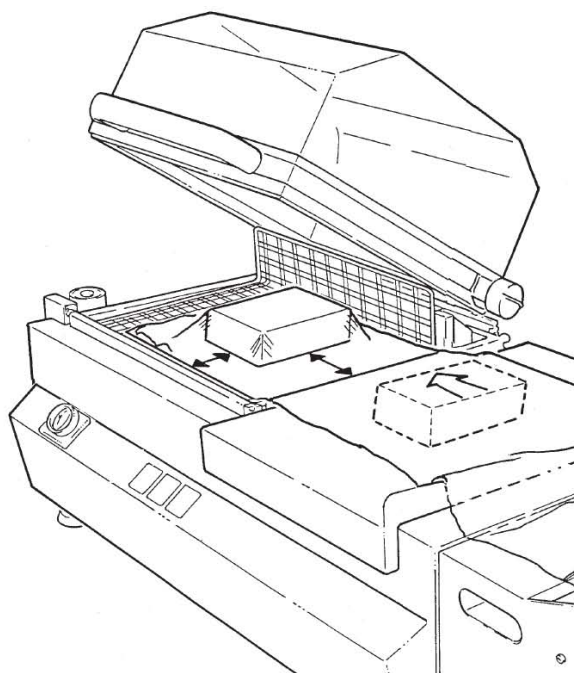
Place the product to be packaged on the loading platform with the right hand, so that it is positioned against the sealing and the folded part.

Without letting go of the product held in the right hand, move it to the left, using the left hand to pull the film, holding it by the waste film, place it on the grille at a distance equal to approximately half its height.

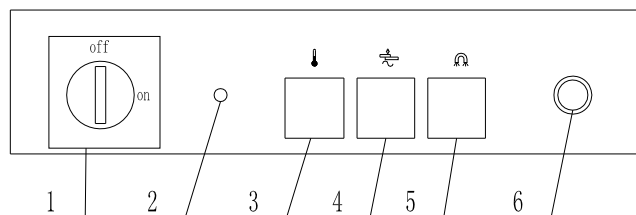
Lower the hood with the right hand, using the special handle, until it is perfectly closed. The magneto will keep the hood closed for the entire duration of the cycle.

In both SEALING ONLY and SEALING + SHRINK-WRAP-PING operating modes, the hood can only be opened after the end of the magneto closure time.

Remove the wrapped product.



## ADJUSTMENTS



### Sealing time (4)

Optimal sealing is obtained with the shortest possible sealing time.

The parameters that influence the adjustment of the sealing time are:

- the production rhythm
- the thickness of the material
- the type of material.

The machine is preset to value 50.

Before starting work, or after a period of stopping, perform 2 or 3 empty cycles (without inserting the film or the product) at intervals of approximately 5 seconds.

To find the correct time, proceed as follows:

1. Adjust the sealing value to 40
2. Perform 2/3 empty cycles as described above
3. Position the edge of the film on the sealing bar
4. Perform a cycle
5. Has the machine performed the sealing and cutting correctly?  
YES – the time is correct  
NO – the time set is too short
6. Return to step 1, increasing the value by 5 unit
7. Repeat the operation until the machine seals and cuts correctly.

### Hot air temperature (3)

It is possible to adjust the temperature of the hot air on the machine.

The machine is preset to value 135, any increases in this value must only be made when the machine has reached the operating temperature (signal light goes off), and must always be set back to value 135 before switching the machine off.

During switching on and heating, or when the machine is not in use, the thermo regulator functions as a safety thermostat, i.e. it does not allow the heating elements to reach excessive temperatures which would shorten their life.



## **PROHIBITED USES**

Using the machine for operations that are not permitted, its improper use and lack of maintenance may cause dangerous situations for personal safety as well as jeopardize the intrinsic functionality and safety of the machine.

**The actions described below, which cannot obviously cover the entire range of potential “improper uses” of the machine, constitute those most “reasonably” foreseeable and are strictly prohibited, therefore:**

**NEVER** permit operation of the machine by psychophysically unfit people or those who have not carefully read the contents of this manual.

**NEVER** use the machine in unsuitable environmental conditions.

**NEVER** use the machine with “mobile” type electrical connections using temporary or non-insulated cables or extension leads.

**NEVER** leave the machine unattended when it has been enabled for operation.

**NEVER** use the machine for purposes other than those for which it is designed.

**NEVER** modify the components of the machine with the aim of increasing productivity.

**NEVER** use the machine whilst wearing flowing or wide-sleeved garments.

**NEVER** use the machine if the contents of this manual have not been fully understood.

**NEVER** carry out cleaning or extraordinary maintenance operations without having first deactivated the machine and removed the plug from the power socket.

**NEVER** carry out temporary or emergency repairs: call the service centre.

**NEVER** use the machine as a resting surface and do not place any object on it that is not used for normal packaging operations.

**NEVER** touch the sealing bar when opening the hood after a packaging operation.

**NEVER** carry out packaging operations with a broken sealing element: replace it immediately.

## MAINTENANCE

Before carrying out any operation, deactivate the machine and remove the plug from the power supply, positioning it so that it is immediately visible.

### Operations to be carried out by the machine operator

#### Cleaning the sealing bar:

The machine functions with plastic films and consequently deposits may form on the sealing blade that then cause imperfect sealing.

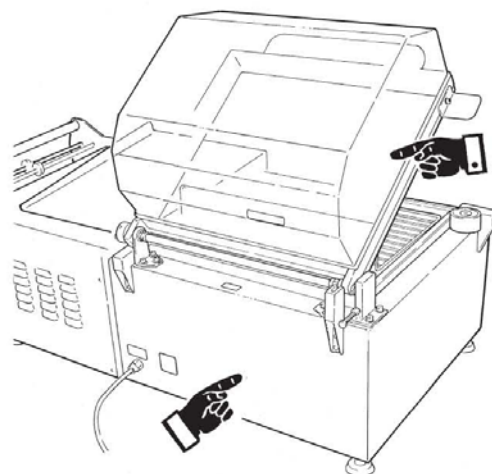
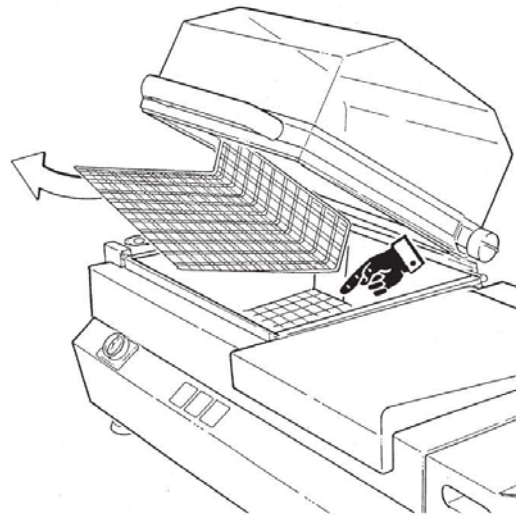
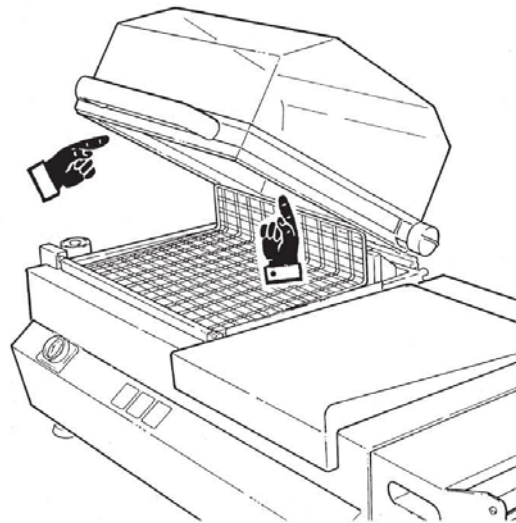
When necessary, remove the residues of film with a dry cloth (made from cotton); carry out this operation immediately after sealing so that the residues can be easily removed whilst still hot.

#### Waste film in the shrink-wrapping basin:

Wait until the machine has cooled down sufficiently. If necessary, remove the grille and use a normal vacuum cleaner to eliminate any deposits.

#### Transparent hood and machine body:

For the cleaning of the transparent hood and machine body, use a cloth (made from cotton or a synthetic material) dampened with water or a product of the type normally used for cleaning glass.



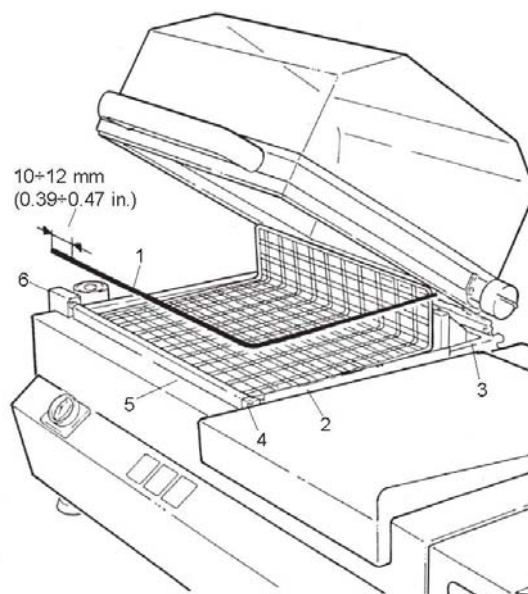
**Operations to be carried out by the  
mechanical or electrical maintenance staff**

**Replacement of the sealing blade**

Loosen the screws that hold the sealing element in place, the wire tensioner clamps and the screw of the central clamp; remove the broken blade.

Take the replacement blade (1) and insert it in the slot of the crossbar (2) and in the clamp (3), then in the central clamp (4) and the longitudinal bar (5).

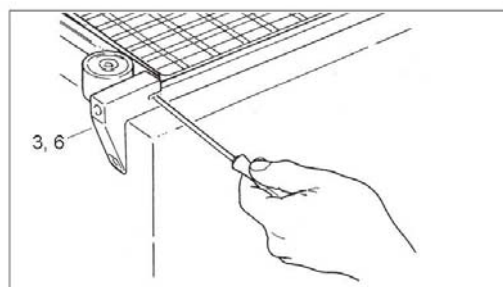
Cut it at a distance of approximately 10-12 mm beyond the bar, and then insert it in the clamp (6).



**Replacement of the rubber seal around  
the edge of the basin**

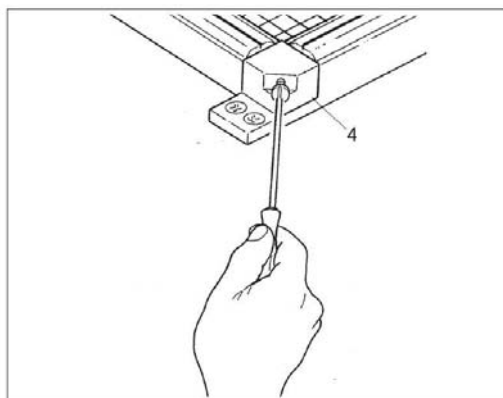
Remove the worn seal. Clean its housing, removing all residues of rubber and glue.

Cut the new rubber to size and glue it in the housing, starting from the corner of the joint, using a thin layer of silicon glue.



**Replacement of the Teflon tape around  
the edge of the basin**

Remove the worn band and all glue residues. Carefully reposition the new tape using a thin layer of silicon glue. Wait for the silicon to glue the tape before reusing the machine.



## TROUBLE SHOOTING

PROBLEM	PROBABLE CAUSE	SOLUTION
THE HOOD DOES NOT OPEN	Broken torsion bar.	Call the Service Centre.
THE HOOD DOES NOT OPEN COMPLETELY	Torsion bar not sufficiently loaded.	Tighten the special screw.
THE WIRE GIVES OFF SMOKE DURING SEALING	Sealing time too long for the type of film used.	Reduce the value of the sealing time, adapting it to the type of film used.
	Plastic residue on wire.	Clean.
THE SET TEMPERATURE IS NOT REACHED	Heating element broken.	Replace.
	Probe broken (interrupted).	Replace.  Note: in both cases the signal light will flash after 10 minutes.
THE MACHINE SEALS BUT DOES NOT SHRINK-WRAP THE FILM	Shrink-wrapping not selected.	Check that the function has been activated.
	The signal lights are on but the fan does not rotate.	Malfunctioning of the control card or broken fan motor. Call the Service Centre.
	The heater door does not open	The screws that hold the opening plate in Position has become loose.
SHRINK-WRAPPING IS PERFORMED BUT IT IS IRREGULAR AND INCOMPLETE	Unsuitable or low-quality film.	The film used must be the shrink-wrapping type.
	The product to be packaged is too large and takes up the entire resting surface.	The dimensions of the product must always be less than those of the resting surface.
SHRINK-WRAPPING	The film used is not micro-perforated.	Make the film pass through the micro-piercing device of the machine
THE SEALING OPENS DURING SHRINK- WRAPPING	Sealing blade dirty or damaged.	Clean the sealing blade; check that it is resting correctly in its position and change if necessary.
	Rubber and/or Teflon worn out.	
	Sealing time incorrectly adjusted.	Adjust.
	Insufficient pressure on the handle of the hood.	Slightly increase the pressure on the handle of the hood during sealing.
IRREGULAR SEALING	The film used has good shrink-wrapping characteristics but bad sealing characteristics.	Replace the film.
SEALING IS NOT PERFORMED	Sealing time set too low.	Adjust according to the type of film.
	The sealing wire is broken or not connected to the clamps.	Check the clamps of the sealing wire and make sure that the latter is not broken; replace if interrupted.

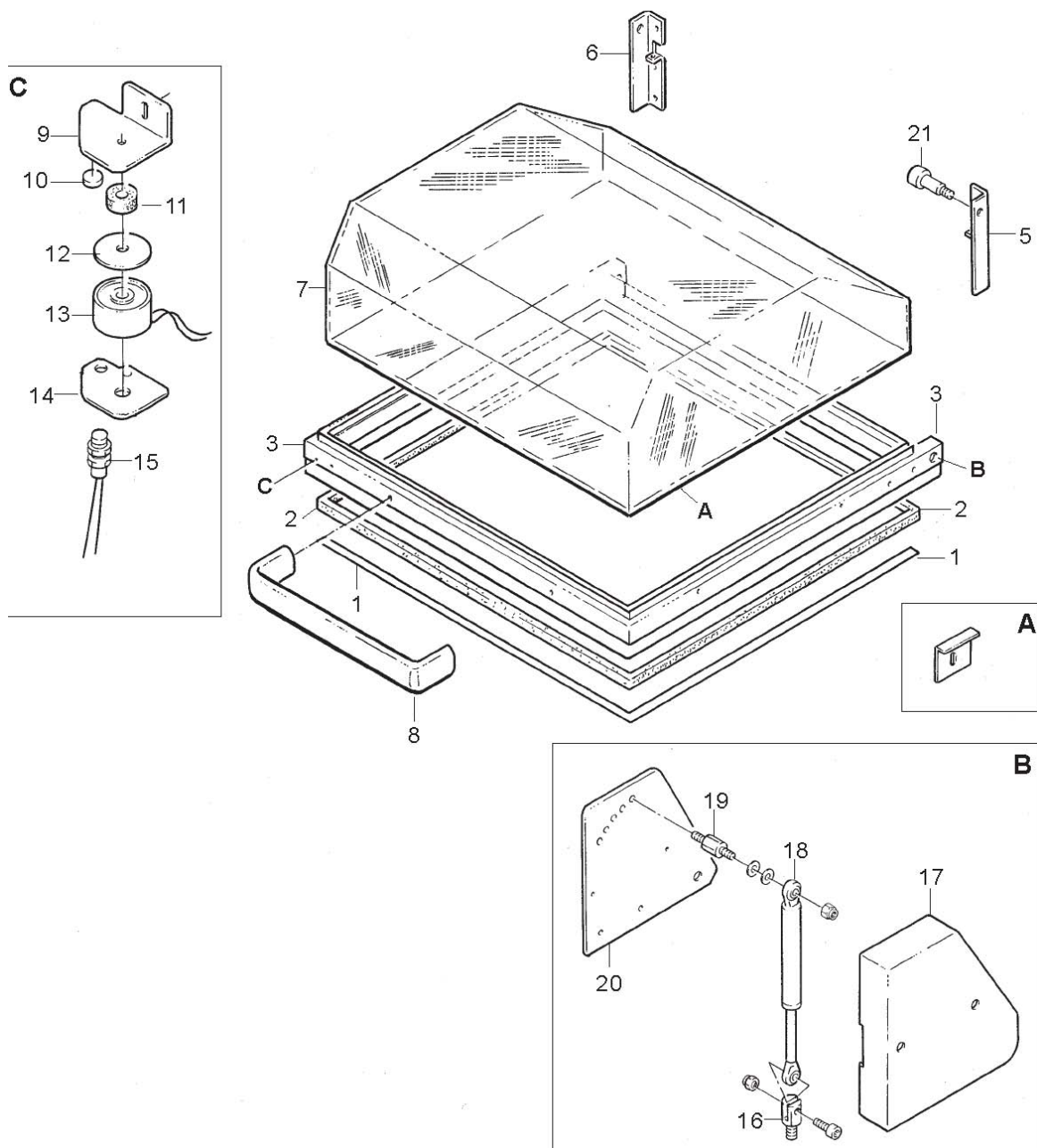
**Note:** If the machine still does not function perfectly after having carried out the aforementioned checks, contact the Service Centre with an exact description of the fault encountered.

## **SCRAPPING AND DISPOSAL**

Should the machine be scrapped, provide for the diggerential disposal of its components (i.e.: metal,oils,greases,plasticandrubber,etc.),preferably turning it to authorized specialized companies and in any case in compliance with regulations in force in terms of industrial and solid waste disposal at the installation site.

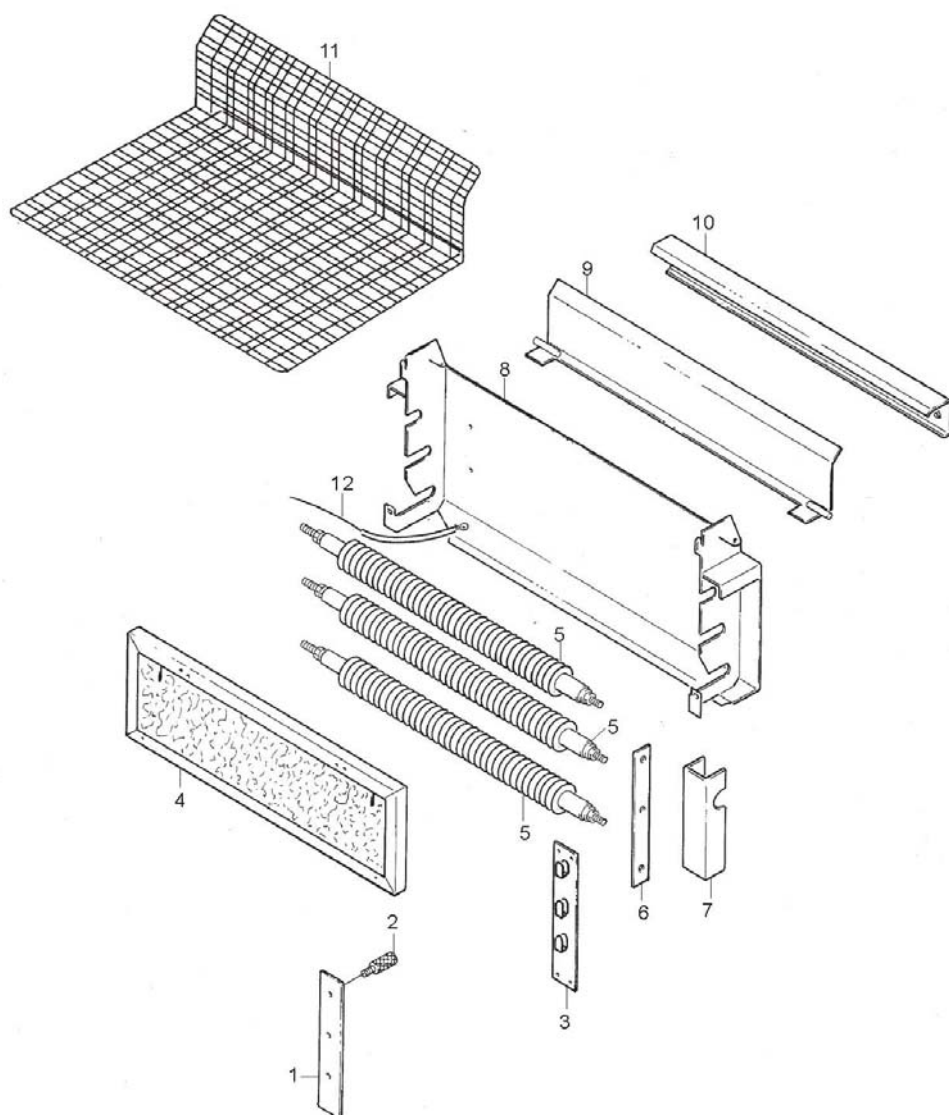
**WARNING: Never place the machine within working areas: it might become a serious danger for people, specifically children, and animals. The machine owner shall be liable for damages.**

# SPARE PARTS CATALOGUE



### ASSEMBLY OF THE STAND

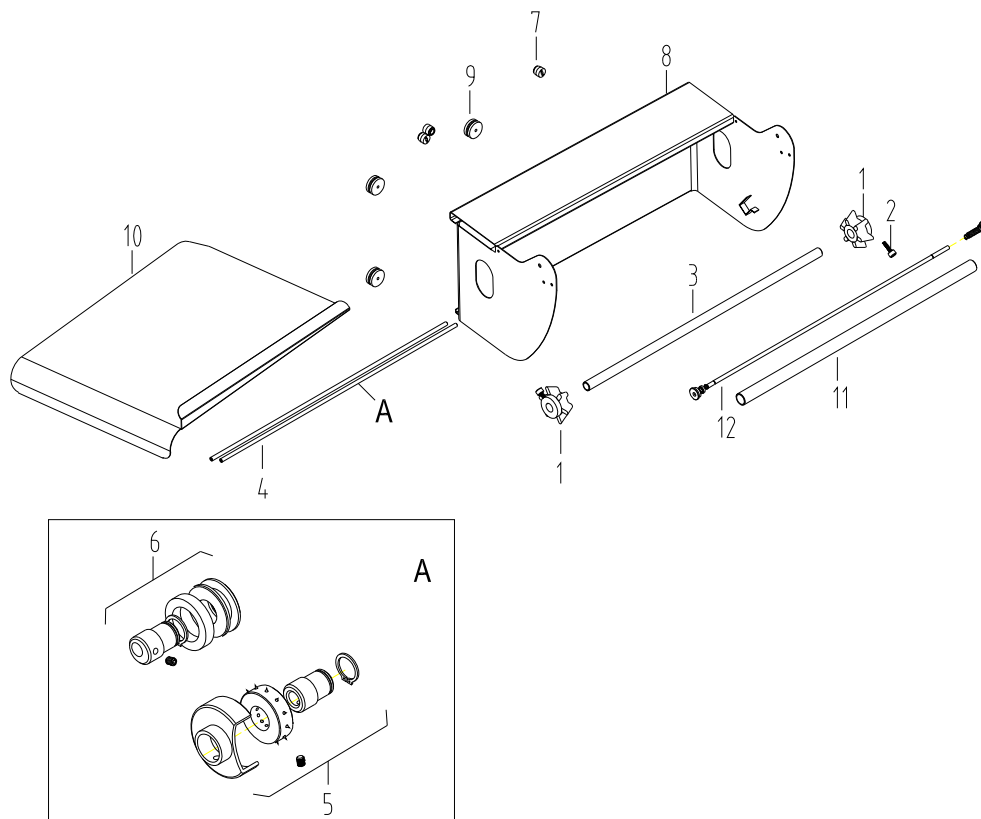
NO.	Code	Description	Quantity
1	28.100.003	Teflon	1m
2	69.400.110	White rubber	0.16kg
3	15.310.103	Bar frame	1
4	69.100.009	Hood bracket	4
5	69.100.011	Right angle plate	1
6	69.100.010	Left right plate	1
7	15.300.203	Hood	1
8	69.400.054	Handle	1
9	69.100.017	Angle plate magnet	1
10	69.400.019	Magnet	1
11	69.200.003	Black rubber	1
12	69.100.015	Disk	1
13	80.700.152	Electromagnet	1
14	69.100.016	Plate	1
15	69.400.066	Sensor	1
16	69.200.010	Fork	1
17	69.100.012	Cover	1
18	69.400.013	Gas spring	1
19	69.200.011	Upper pin	1
20	15.310.113	Support	1
21	69.400.007	Screw	2



## RESISTOR UNIT

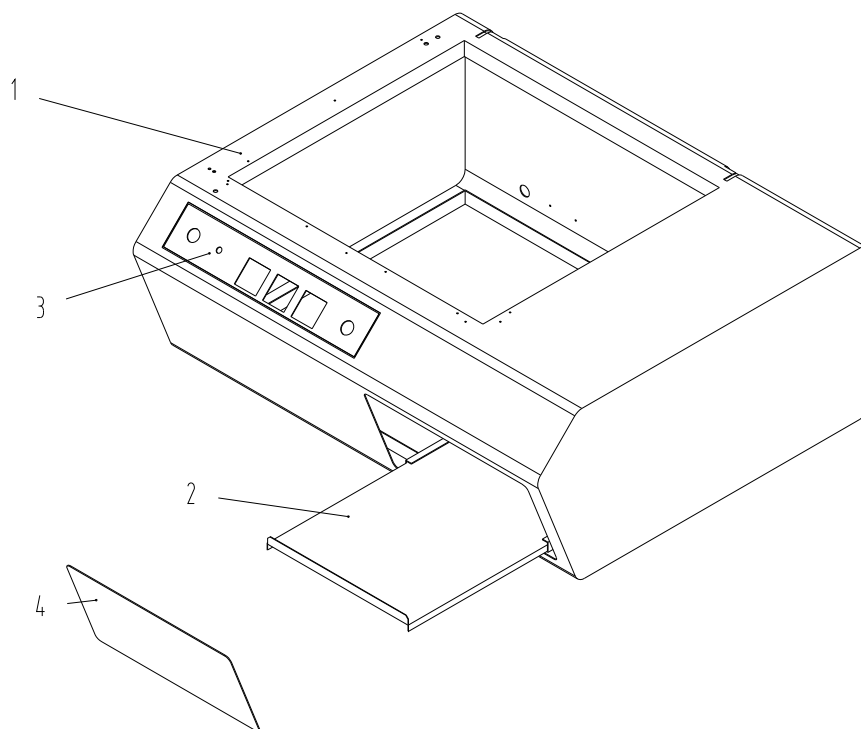
NO.	Code	Description	Quantity
1	69.100.081	Pawl plate	2
2	69.300.011	Pawl	2
3	69.300.069	Protection device Support	2
4	154.310.112	Panel	1
5	69.400.020	Resistor	3
6	69.100.251	Plate	2
7	69.100.013	Resistor lock	2
8	15.310.109	Resistor holder	1
9	15.310.111	Shutter	1
10	15.310.110	Back guard	1
11	51.200.003	Grille	1
12	69.400.166	Thermocouple	1





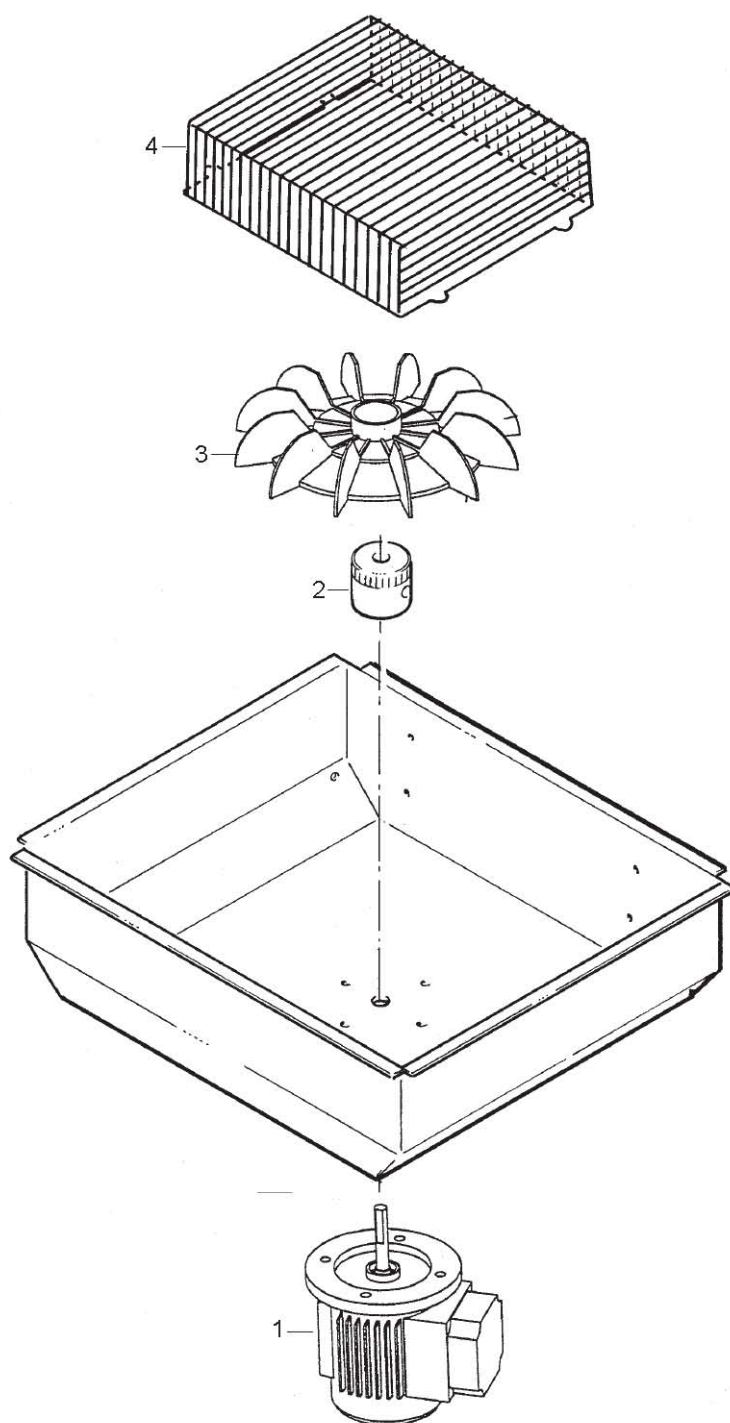
## REEL CARRIER GROUP

NO.	Code	Description	Quantity
1	69.300.036	Blocking film wheel	2
2	69.100.320	Screw	2
3	51.100.107	Shaft of film support	1
4	51.100.047	Needle roller shaft	2
5	69.900.002	Needle roller wheel	2
6	69.900.121	Foam wheel	2
7	DB09	Baffle plate	3
8	15.310.102B	Film support	1
9	69.400.034	Pulley	4
10	15.310.123B	Film separate plate	1
11	15.310.685	Transition roller	1
12	15.100.050	Transition roller shaft	1



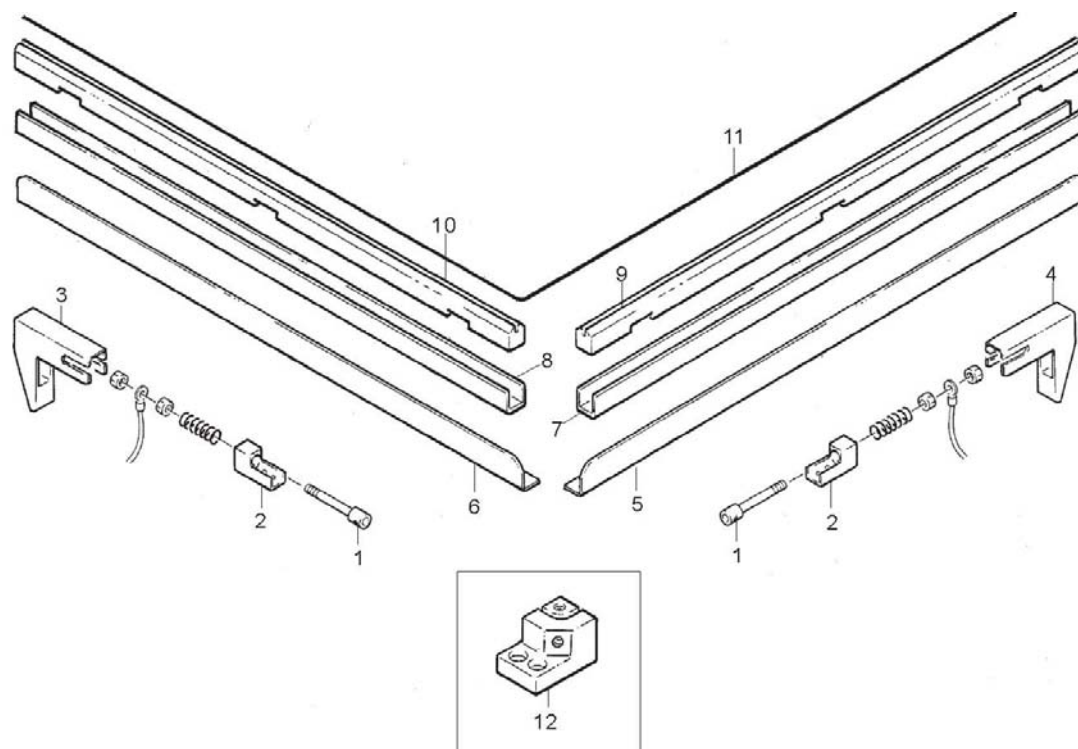
# **STRUCTURE UNIT**

NO.	Code	Description	Quantity
1	15.310.101B	Body	1
2	21551	Electrical panel	1
3	15.310.101B-B1	Panel	1
4	15.310.101B-B2	Cover plate	2



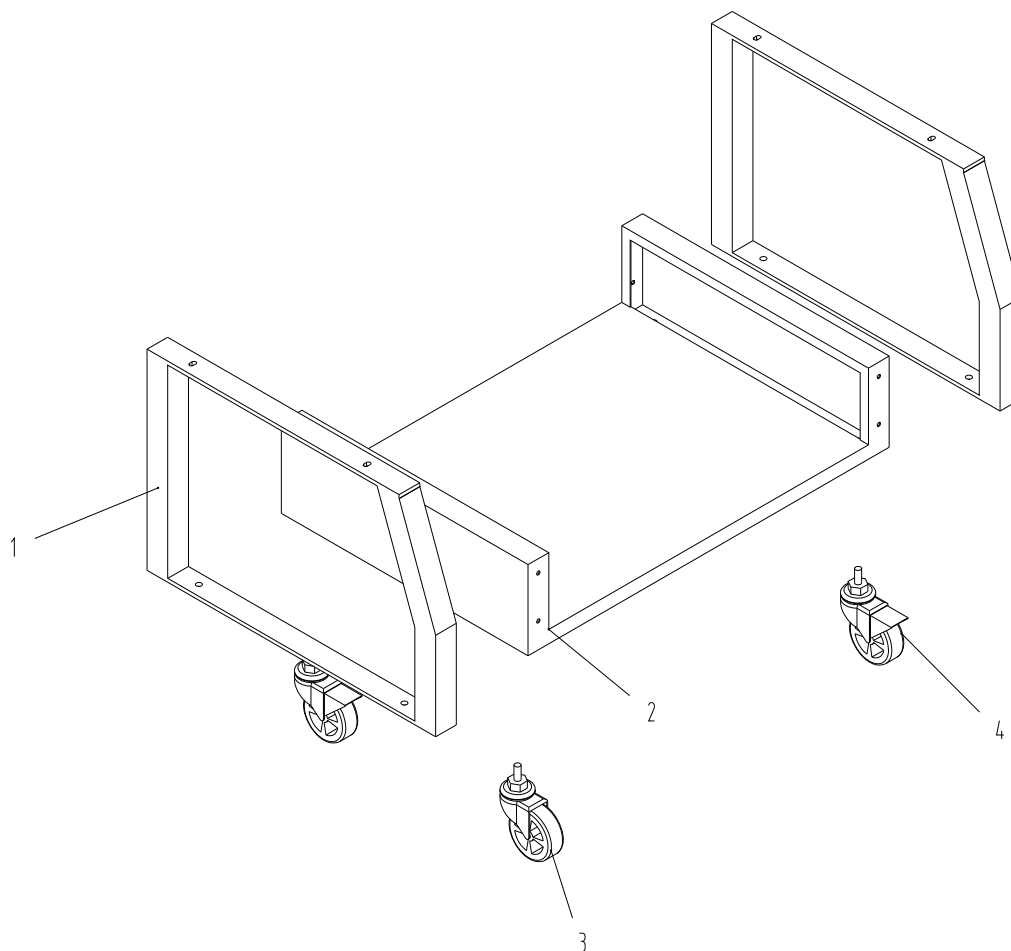
# **FAN GROUP**

NO.	Code	Description	Quantity
1	51.400.111	Fan motor	1
2	69.300.052	Hub	1
3	69.400.016	Fan	1
4	51.300.006	Protective device	1



#### LOWER SEALING GROUP

NO.	Code	Description	Quantity
1	69.300.001	Tensin blade	2
2	69.300.045	Support	2
3	69.300.038	Longit. protection	1
4	69.300.037	Transv. protection	1
5	51.100.023	Transv. film raiser	1
6	15.310.204	Longit. film raiser	1
7	51.100.024	Transv. bar holder	1
8	51.100.028	Longit. bar holder	1
9	15.310.201	Insulating bar	1
10	15.300.202	Insulating bar	1
11	69.300.080	Sealing blade	1
12	69.200.002	Central holdfast	1



### CARRIAGE GROUP

NO.	Code	Description	Quantity
1	4255-01	Base	2
2	4255-02	Connection frame	1
3	52.400.001	Wheel	2
4	52.400.002	Locking wheel	2

