

STAR

UNIVERSAL

INSTRUCTION MANUAL



**STAR 61 MkV DIGITAL
IMPULSE/SOLENOID
SERIAL NUMBER 011101/61**

STAR UNIVERSAL (GOSPORT) LIMITED
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SAFETY INSTRUCTIONS FOR HEAT SEALER OPERATION



WARNING

All users of this product are requested to follow all warnings and instructions contained in this manual. In addition all warnings and instructions affixed to the machine should be followed.

This heat sealer is supplied with a 3 wire power cable and a 13 amp fused plug for the user's safety. Increased user safety can be achieved by the provision of a residual current device (RCD) being used on the supply circuit to the machine, especially when used in a potentially wet or damp environment. The machine is not rated for direct water contact.

The sealer is designed to be installed on a flat level surface to ensure stability during operation.

Heat sealers are not designed to be used for the packing of flammable or explosive materials.

When operating the machine keep hands clear of the sealing jaws.

Always use heat sealers in a ventilated environment as sealing certain plastics may create fumes. Check with your bag manufacturer.

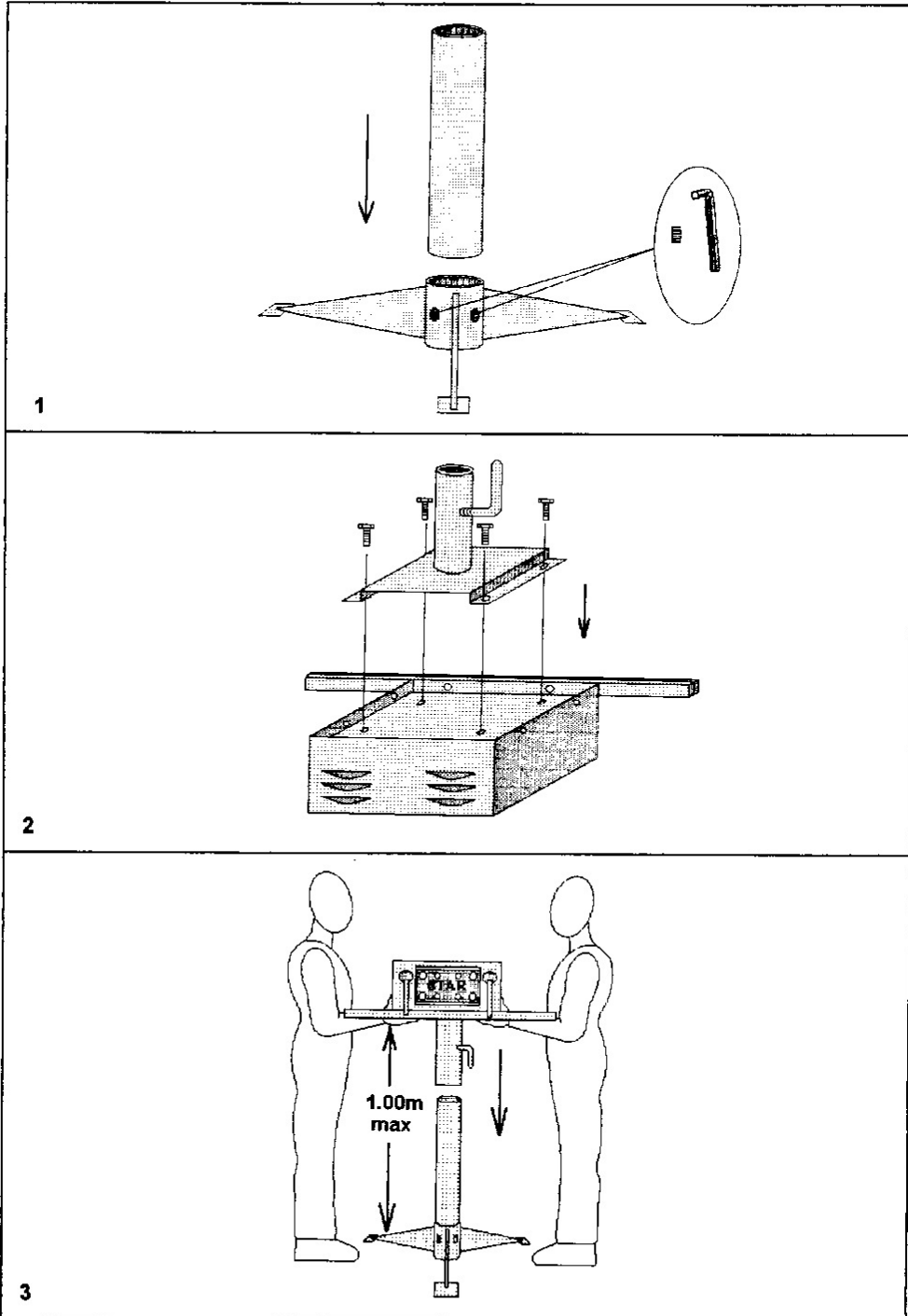
Ensure the power is switched off and the plug removed from the power supply prior to carrying out any service work

Note:

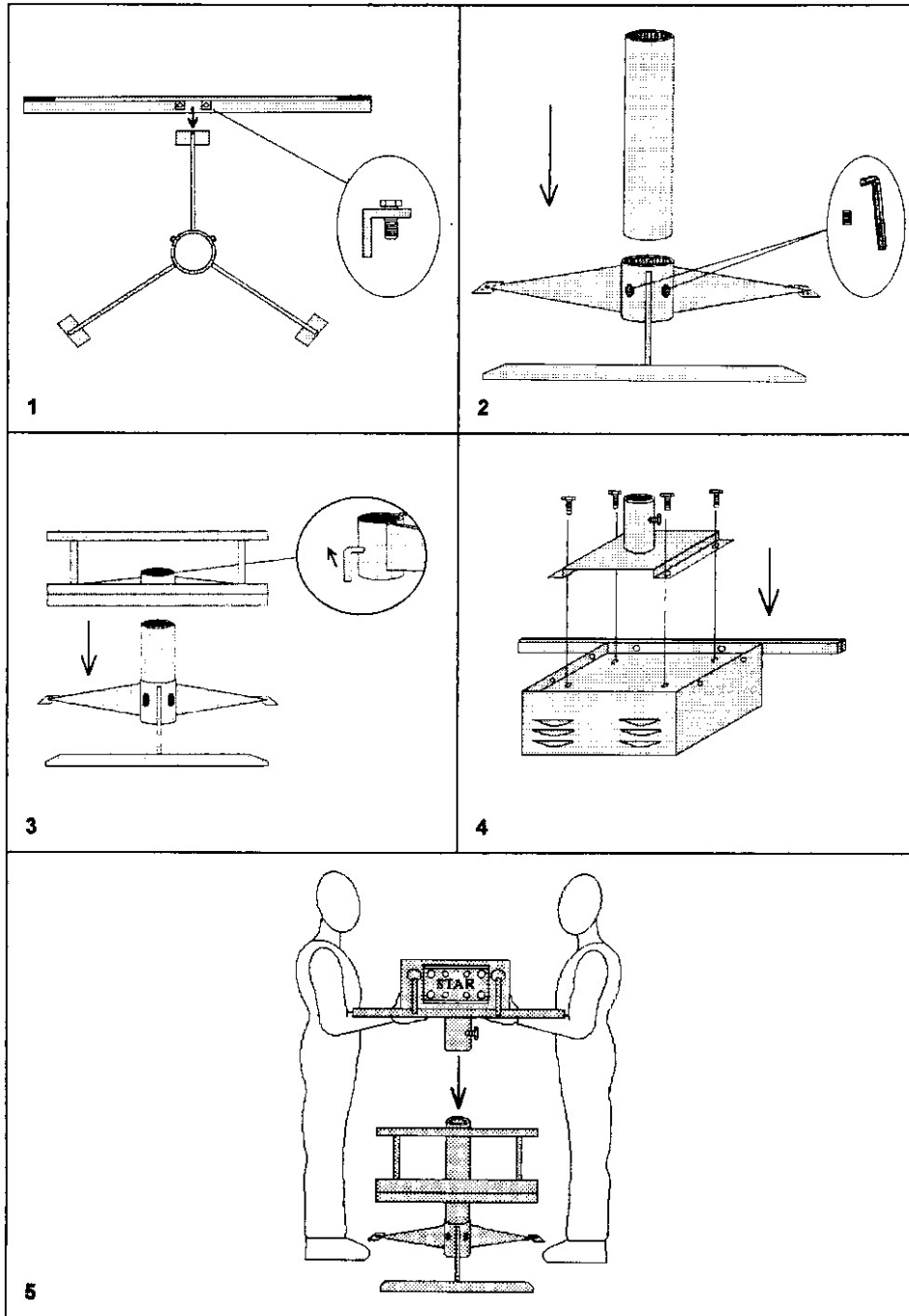
Star Heat Sealers meet the health and safety requirements of The Supply of Machinery (Safety) Regulations 1992 No. 3073 and The Machinery Directive 89/392/EEC. The CE mark will be affixed to the product where applicable.

A request is made that any known incidents that result in injury to an operator from the legitimate use of this heat sealer is reported to Star Universal Technical Department. Tel: 02392 582857.

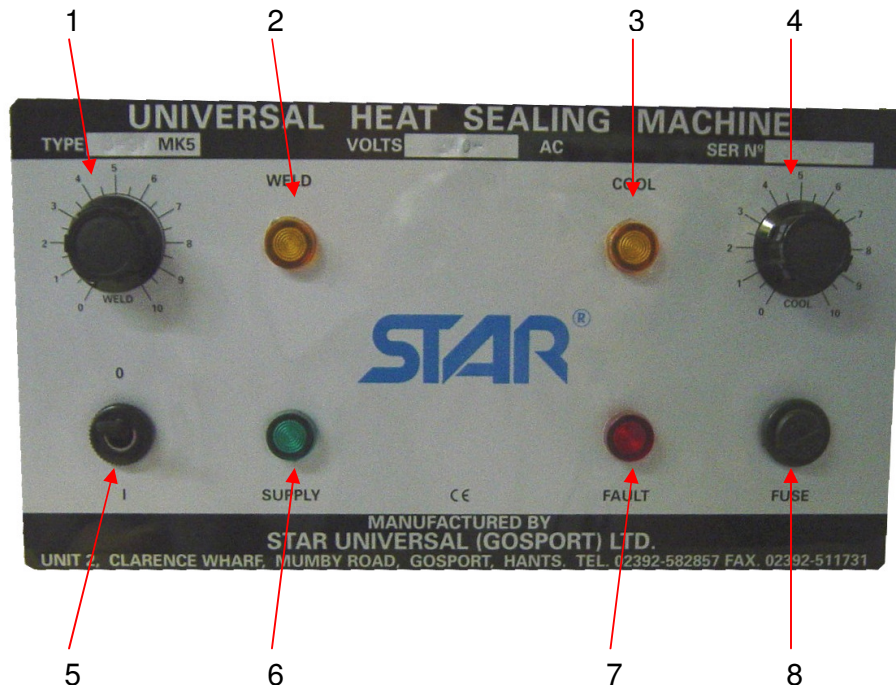
NORMAL TRIPOD STAND



SACK SUPPORT PLATFORM STAND



MACHINE CONTROLS



- | | | | |
|------------------|--------------------|--------------------|---------------|
| 1) Weld Timer | 2) Weld Indicator | 3) Cool Indicator | 4) Cool Timer |
| 5) On/Off Switch | 6) Power Indicator | 7) Fault Indicator | 8) Fuse |

INITIAL INSTALLATION INSTRUCTIONS



Please ensure that the operating instructions in this manual have been read before connecting the machine to the power supply and switching the machine on.

Remove any packing material from the machine ensuring any cable ties holding the jaws closed are removed. Assemble the stand and attach the sealing head as shown on the following pages.

Plug the machine into the power outlet and turn the supply on.

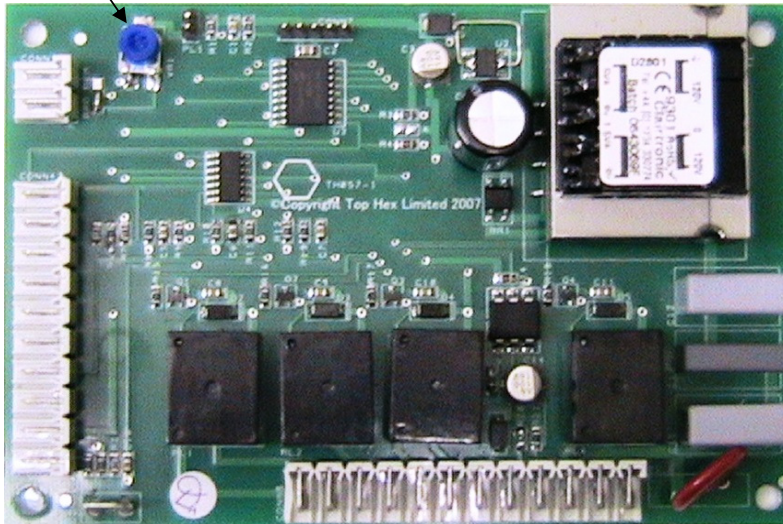
Set the weld and cool timers to number 3. Take one of your bags and place between the jaws and press the foot switch. When the jaws open after the cycle is complete examine the seal that has been produced.

1. If the seal is too hot (the seal will appear molten and wavy) reduce the heat and cool settings by 0.5, allow the sealing wires to cool fully. Repeat the process until you have a flat solid seal.
2. If there is no seal in the material increase the heat and cool settings by 0.5, allow the sealing wires to cool fully. Repeat the process until you have a flat solid seal.

SETTING THE TRIM

The purpose of the trim is to compensate for residual heat in the sealing wires when in constant use. This should be set for the speed operators will be using the machine to allow consistent seal quality.

Trim Pot



Once the seal cycle has been set from a cold start (See above) the trim can be set for the cycle speed you will be operating the machine. Cycle the machine 5 or 6 times at the rate you will do in production. If the seal becomes molten turn the trim pot anti clockwise until you get consistent seals.

OPERATING INSTRUCTIONS

Once the correct temperature, time and trim have been set the same seal quality should be achieved every cycle.

The machine operation involves placing the open end of the bag to be sealed between the jaws, pressing the foot switch to close the jaws and removing the bag once the jaws have opened.



- Never operate the machine with any covers removed.
- Never operate the machine in an unstable position.
- Never operate the machine if it is wet.
- Keep hands clear of the sealing jaws.

SERVICE REPLACEMENTS

Under normal operating conditions it will be necessary to replace certain expendable items that are readily available from our spares department.

Before replacing any sealing jaw items ensure the machine is switched off and unplugged.

Replacing consumable items

Barrier Tape: The barrier tape is a Teflon coated cloth designed to prevent plastic sticking to the element ribbon. If this becomes burnt or damaged peel the old tape off, removing any excess adhesive from the jaws. Take a length of new tape, remove one of the adhesive strips and stick it to the front of the jaw, remove the other adhesive strip and stick to the back of the jaw. The tape should be applied loosely so it is not in contact with the element ribbon.

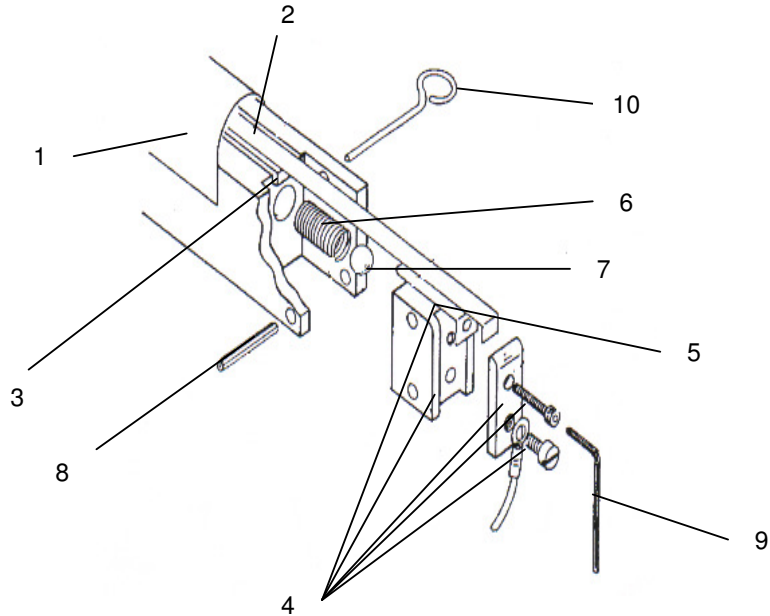
Element Ribbon: Remove the barrier tape as above. Place the loading pins through the expansion blocks at either end of the jaw so it is held under pressure and loosen the allen key bolt. Remove the old ribbon. Cut a length of new element ribbon slightly longer than the jaw and fold one end back on itself by about 5mm. Place this end in one of the expansion blocks and tighten the allen bolt. Measure the length of ribbon required to fit into the other expansion block, cut to length and fold the end back 5mm. Fit in the other expansion block and tighten. Remove the loading pins and re cover with barrier tape. **IMPORTANT, ON DOUBLE HEAT MACHINES THE TWO WIRES MUST LINE UP TO PRODUCE A GOOD SEAL.**

Brass Shim: Remove barrier tape and element ribbon as above. Remove the brass clamp by fully unscrewing the allen bolt. Replace the brass shim, attach the brass clamp and re fit the ribbon and tape as above.

Silicone Rubber/Sponge – Heated Jaw: Remove the barrier tape and element ribbon as above. Peel the silicone rubber away from the aluminium sealing jaw and clean any residual adhesive left behind. Apply a **NARROW** bead of silicone adhesive to the channel, cut a piece of silicone rubber to length and press into the channel ensuring a smooth surface. Replace the sealing ribbon and barrier tape as above.

Silicone Rubber/Sponge – Unheated Jaw: Remove the barrier tape as above. Peel the silicone rubber away from the aluminium sealing jaw and clean any residual adhesive left behind. Apply a **NARROW** bead of silicone adhesive to the channel, cut a piece of silicone rubber to length and press into the channel ensuring a smooth surface. Replace the barrier tape as above.

HEATED JAW TENSION ASSEMBLY

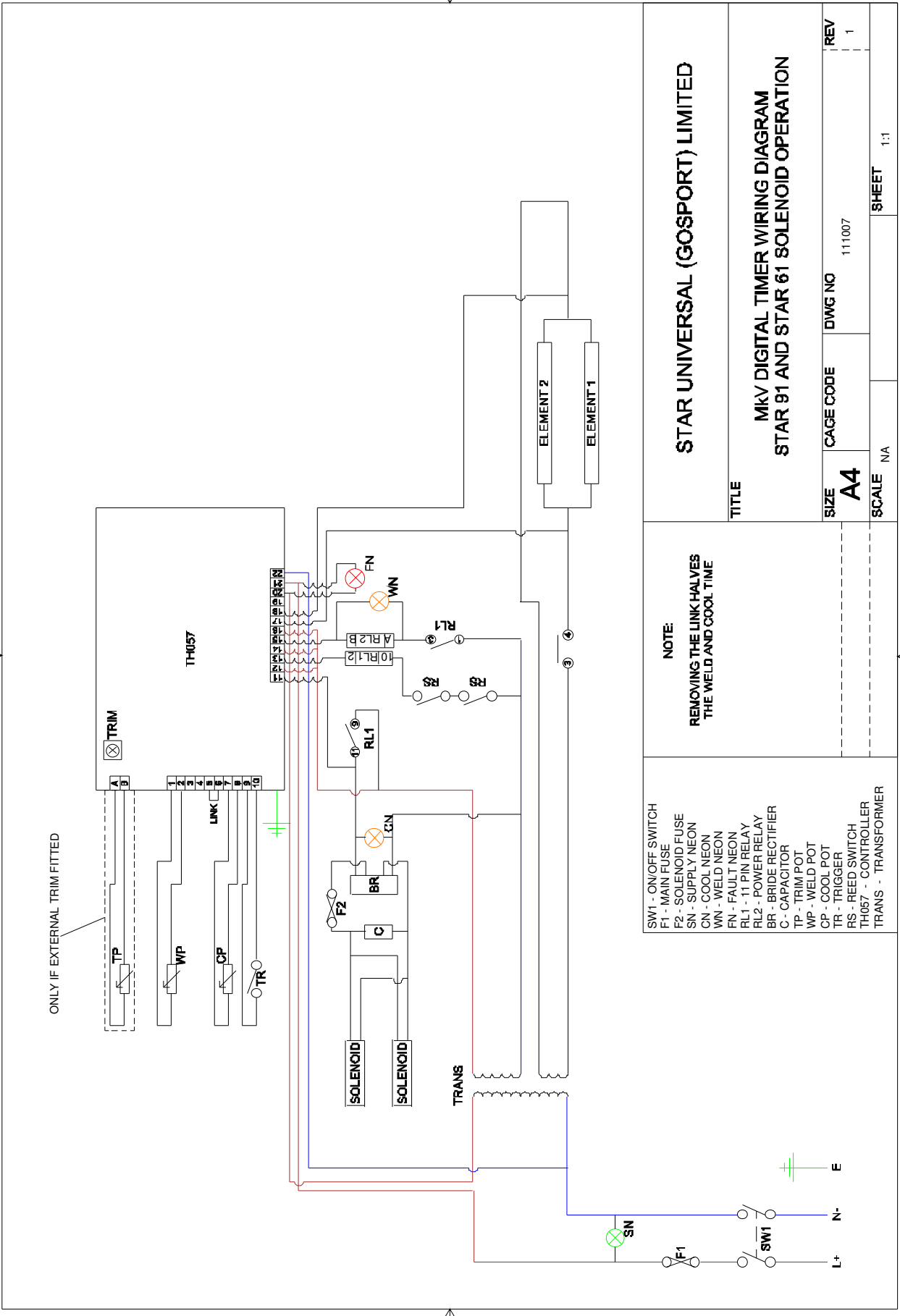


Part No	Diag No	Description	Price
B018003	1	10m roll 50mm barrier tape	£25.30
		1m 50mm barrier tape	£2.90
E024002	2	10m roll 6mm element ribbon	£22.16
		1m 6mm element ribbon	£2.46
B017002	3	10m 9.5mm silicone rubber	£102.60
		1m 9.5mm silicone rubber	£10.83
M202005	4	Expansion block (Pair)	£26.45
M202004	5	Brass Shim	£1.04
B021005	6	Compression spring	£2.11
B022002	7	Ball bearing	£0.90
B031002	8	Roll Pin	£1.97
B029002	9	Allen key	£0.90
M202009	10	Loading pin	£0.95
S001001	NA	Spares Kit inc P&P Comprises of 10m element ribbon, 10m barrier tape & 3m silicone rubber, 1 tube silicone rubber compound	£69.95 Saving up to £48.87

ELECTRICAL PARTS AND WIRING DIAGRAM

Part No	Diag No	Description	Price
E010002	SW1	On/Off Switch	£11.25
E016001 E017001	F1	Fuse Holder Mains Fuse	£6.84 £1.15
E016003 E016004 E017008	F2	Solenoid Fuse Holder Solenoid Fuse Cover Solenoid Fuse	£1.96 £1.86 £0.90
E012003	SN	Power On LED	£3.07
E012001	CN&WN	Weld/Cool LED	£3.07
E012002	FN	Fault LED	£3.07
E003002 E004001	RL1	11 pin Relay 230V Relay Base	£19.56 £10.20
E003008	RL2	Weld Relay	£26.08
E022001	BR	Rectifier	£8.10
E021004	C	Solenoid Capacitor incl. Resistor	£7.20
E020005 B015001	WP&CP	Potentiometer Control Knob	£6.15 £2.68
E010005	TR	Foot Switch	£35.79
E010011	RS	Safety Micro Switch incl. Bracket	£10.49
E005004	TH057	MkV Digital Timer Board	£120.84
E001001	TRANS	Transformer (230V)	£110.88
E002001	SOLENOID	Solenoid Complete	£92.08
E013016		Mains Lead & Plug	£9.90
E014001		Terminal Block (12 way)	£1.62
B021006		Solenoid Return Spring	£7.28
M202007		Solenoid Pin	£2.31
M103040		Brass Link	£13.58

**ALL PRICES QUOTED IN THIS MANUAL ARE CORRECT
 AT THE TIME OF PUBLICATION
 STAR UNIVERSAL RESERVE THE RIGHT TO REVIEW
 AND ALTER THE PRICES AS NECESSARY
 COMPONENTS AND LAYOUT MAY VARY FROM THOSE PICTURED**



ONLY IF EXTERNAL TRIM FITTED

- SW1 - ON/OFF SWITCH
- F1 - MAIN FUSE
- F2 - SOLENOID FUSE
- SN - SUPPLY NEON
- CN - COOL NEON
- WN - WELD NEON
- FN - FAULT NEON
- RL1 - 11 PIN RELAY
- RL2 - POWER RELAY
- BR - BRIDGE RECTIFIER
- C - CAPACITOR
- TP - TRIM POT
- WP - WELD POT
- CP - COOL POT
- TR - TRIGGER
- RS - REED SWITCH
- TH057 - CONTROLLER
- TRANS - TRANSFORMER

NOTE:
REMOVING THE LINK HALVES
THE WELD AND COOL TIME

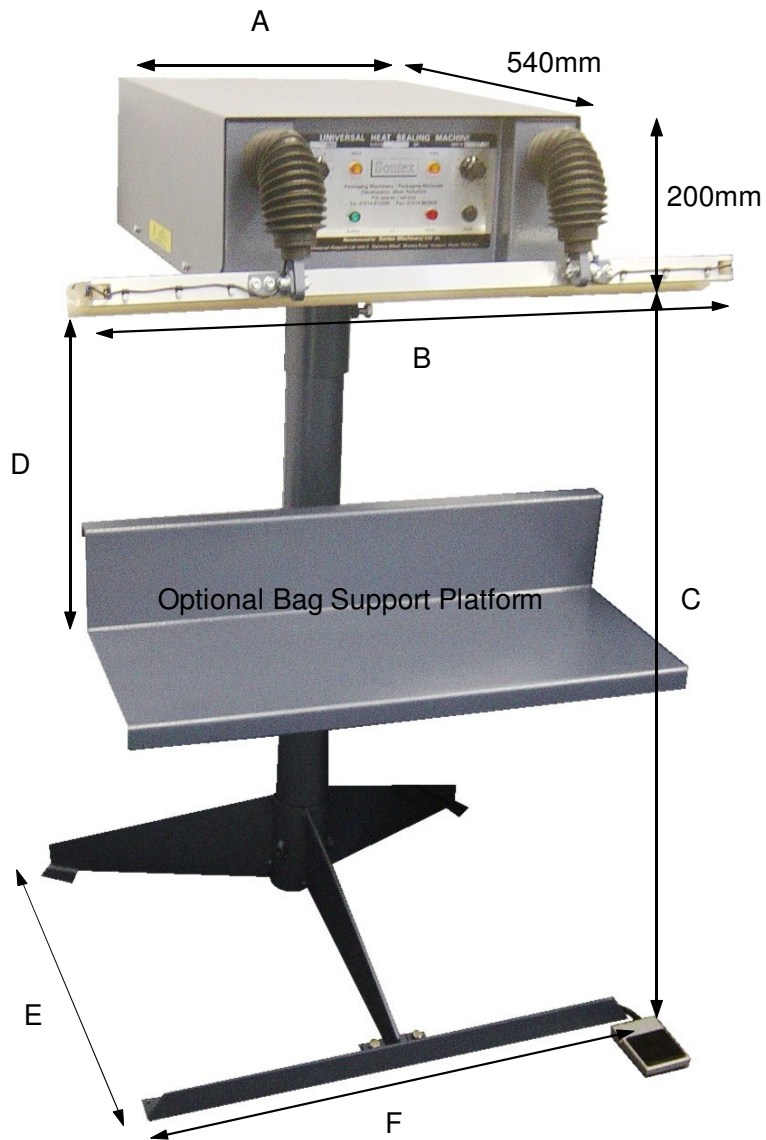
STAR UNIVERSAL (GOSPORT) LIMITED

TITLE
MKV DIGITAL TIMER WIRING DIAGRAM
STAR 91 AND STAR 61 SOLENOID OPERATION

SIZE A4	CAGE CODE	DWG NO 111007	REV 1
SCALE NA	SHEET NA	1:1	

STAR 61 DIMENSIONS

	A	B	C	D	E	F
650mm Jaws	410mm	725mm	760mm-1000mm	NA	720mm	720mm
900mm Jaws	410mm	980mm	760mm-1000mm	NA	720mm	720mm
1200mm Jaws	610mm	1285mm	760mm-1000mm	NA	720mm	720mm
Optional Bag Support Platform	NA	NA	965mm	160mm-650mm	720mm	720mm
Stainless Steel H Frame Stand	NA	NA	760mm-1000mm	NA	680mm	680mm



ALL THE ABOVE DIMENSIONS ARE APPROXIMATE
THEY WILL VARY DEPENDANT ON FINAL SPECIFICATION OF THE MACHINE

EC DECLARATION OF CONFORMITY

We, Star Universal (Gosport) Limited,
Unit 2 Clarence Wharf, Mumby Road, Gosport, Hampshire, PO12 1AJ,

Declare our sole responsibility that the following products:

Star 61 Impulse Sealer

Serial Number: 011101/61

We hereby declare that the above machinery complies with the essential health and safety requirements of the Machinery Directive 2006/42/EC, the Low Voltage Directive 73/23/EEC and the requirements of the Electromagnetic Compatibility Directive 89/336/EEC.



Mark Robinson
Director

Star Universal (Gosport) Limited

Date: 20/01/2011

STAR UNIVERSAL WARRANTY POLICY

The Company provides a 1 year warranty from the date of delivery on all Star Heat Sealing machines. If any part is found defective due to faulty manufacture, Star Universal will effect the repair or replacement to the customer free of charge providing:

- a) The fault is reported directly to the Service Department.
- b) The fault is not caused by misuse, neglect or faulty adjustments by the operator.
- c) The machine failure has not occurred through normal wear and application usage.
- d) The machine has not been serviced or repaired by any person not authorised by Star Universal during the warranty period.
- e) The machine is returned to Star Universal at the address below.

Expendable items like the jaw barrier tape and heating elements are not covered by the warranty but are readily available at a charge from the Service Department.

Travel time to attend a machine on site may be charged at the current applicable rates.

This warranty is additional to the normal customer statutory rights.

**Star Universal Service Department
Unit 2 Clarence Wharf
Mumby Road
Gosport
Hampshire
PO12 1AJ**

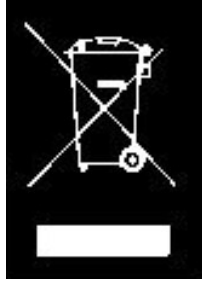
Tel: 02392 582857

Fax: 02392 511731

E mail: service@staruniversal.com

ENVIRONMENTAL RESPONSIBILITY

MACHINE RECYCLING



As this machine contains electrical and electronic components it must be disposed of correctly and not in general land fill.

As Star Universal only build industrial equipment to individual customer requirements the responsibility for the disposal lies with the end user.

Star Universal will offer a collection service for machines we have built at the end of their useful life for recycling.

Please contact us for prices stating the machine model and serial number.

Our contact details are as below:

Star Universal (Gosport) Limited
Unit 2 Clarence Wharf
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