

## Preventative Maintenance (Mechanic schedule)

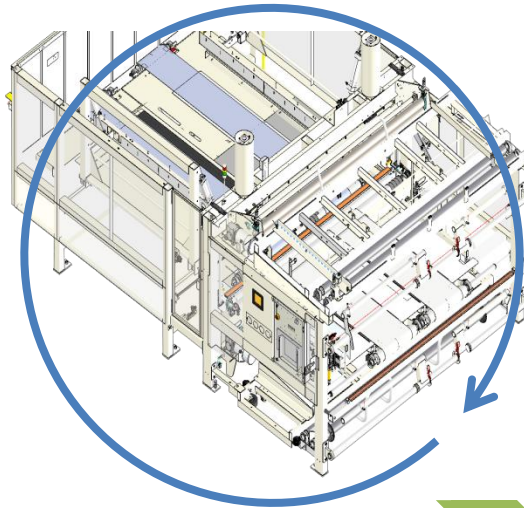


1. POWER DOWN AND LOCK-OUT THE ELECTRICAL AND THE PNEUMATIC POWER SOURCES ON THE MACHINE.
2. WAIT UNTIL SEAL BARS COOL OFF SUFFICIENTLY (APROX. 3 HOURS) BEFORE SERVICING THE SEAL BARS OR THE NEARBY AREAS OF THE MACHINE.



Safety is First Priority! Follow all Lockout/tagout procedures, before working on machine

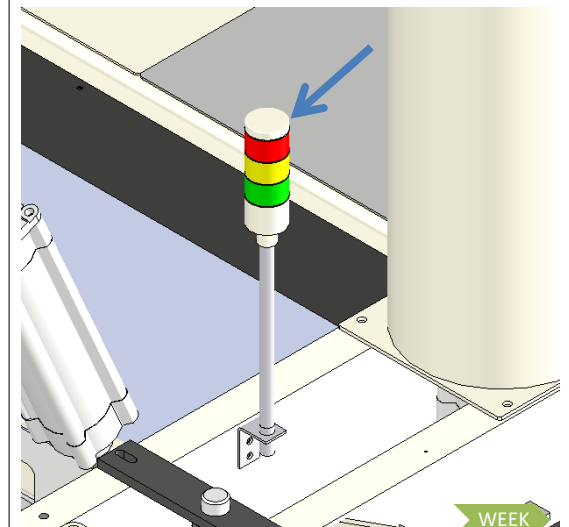
## 1390HCE Auto Pack



WEEK

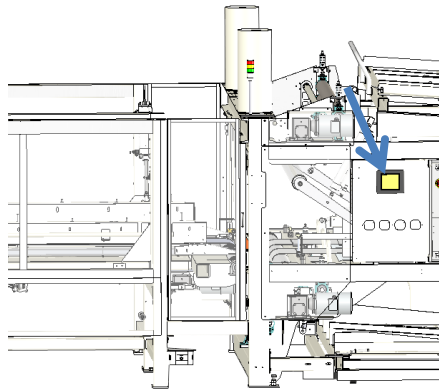
1. Check for unusual noises and or air leaks.
2. Proceed with general cleaning of machine

## Frequency



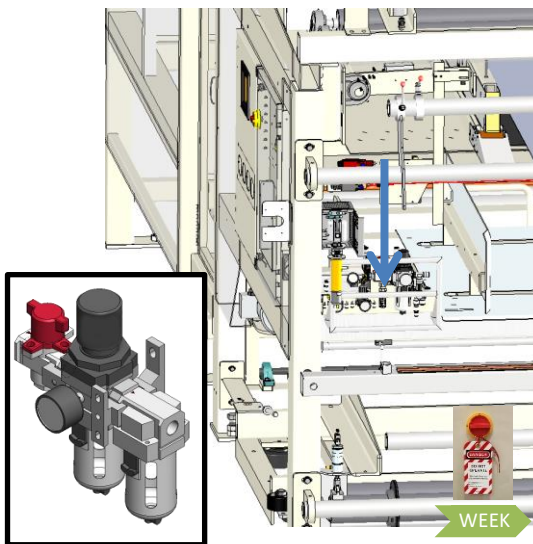
WEEK

3. Check to see that Light tower functions properly.



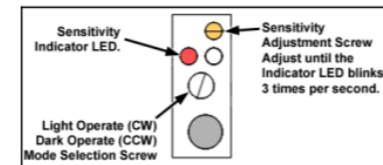
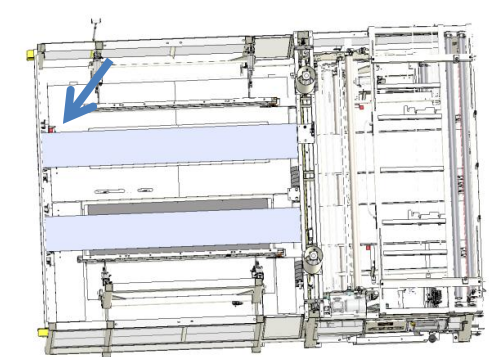
WEEK

4. Check screen operation, Recalibrate only if having issues . Procedure in operator's manual .



WEEK

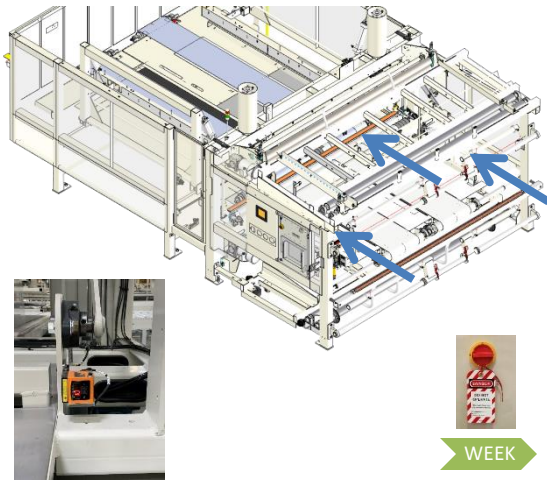
5. Check air filter and replace as needed.



WEEK

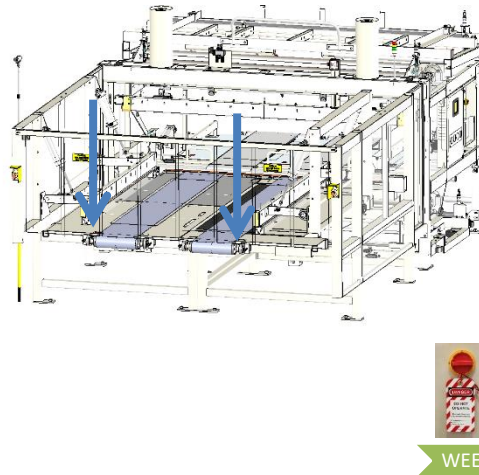
6. Check and clean photo eyes and reflective tape in out-feed area. Replace tape if damaged.

## Preventative Maintenance (Mechanic schedule)



6.a. Check and clean Sizing Laser eyes on both sides and center top of in-feed.

## 1390HCE Auto Pack



7. Clean area around conveyor belts and roller bearing on in-feed and out-feed assemblies.

Frequency

DAY

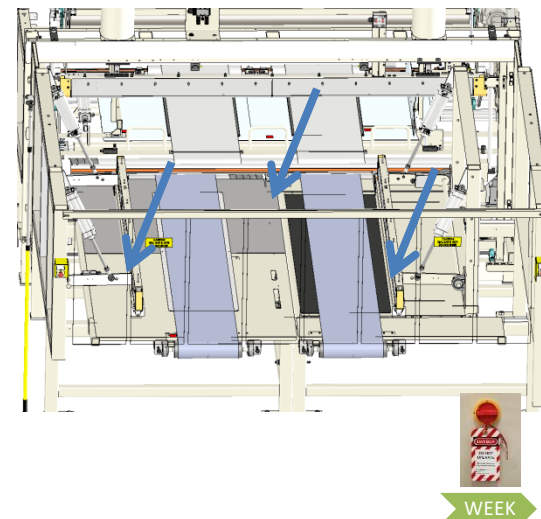
WEEK

MONTH

## VERY Important Message:

Upper seal bars have a coating and the Lower Seal bars are made of PTFE which is a non-stick material. Use extreme caution when inspecting seal bars . If everything looks perfect DO NOTHING. If this Teflon material is scratched or torn in some areas, it will cause buildup on the seal bar. If this happens, a clean thick rag with WD-40 sprayed on it, should be used to wipe the seal bar to keep it clean. By doing this it will prevent buildup and burn through.

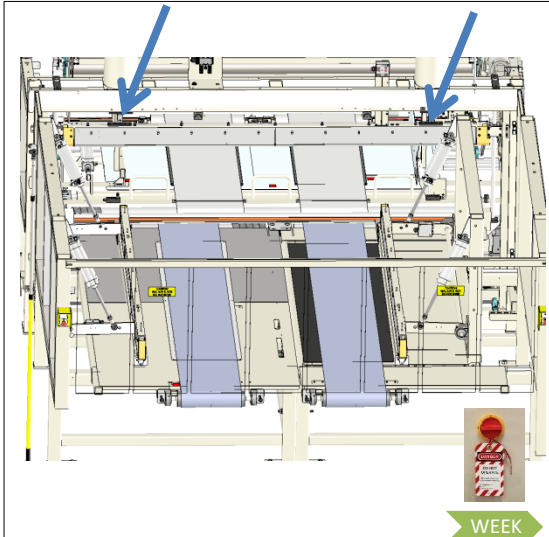
Never reuse cleaning rags in this procedure.  
Always discard after cleaning!



8. Check PTFE tape on lower seal bars. Tape should be smooth w/ o tears or cracks.

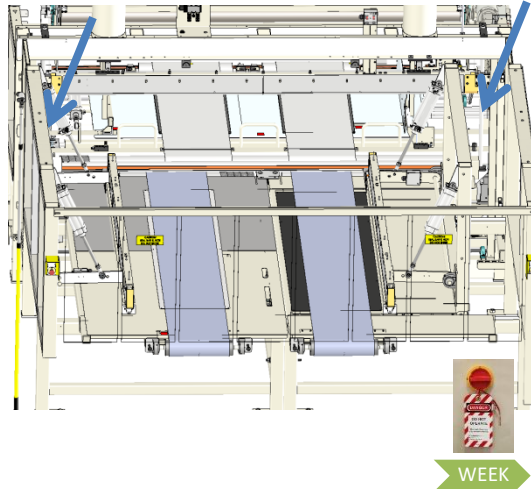
## VERY Important Message:

Check area of tape where the seal bar knife presses down on the PTFE tape. If the tape is cut , check the silicone rubber cushion underneath the tape for cuts or damage. If damaged it is possible to flip over the cushion and use the bottom side. If damage is too severe , switch the top cushion with the bottom one or replace with new cushion.



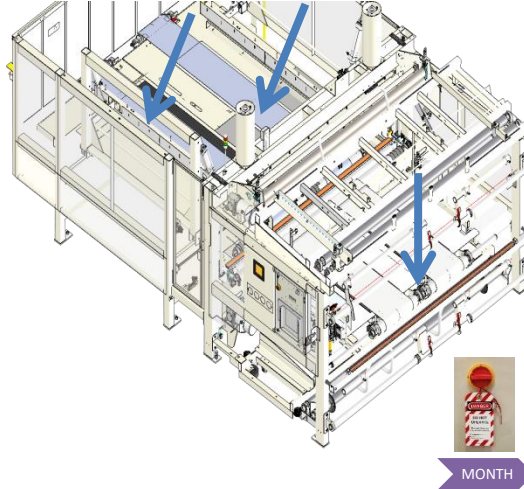
9. Clean cross seal bar cylinders and lubricate.  
Do not touch cylinders shafts with bare hands.

## Preventative Maintenance (Mechanic schedule)



10. Clean seal bar guides and lubricate. Do not touch with bare hands.

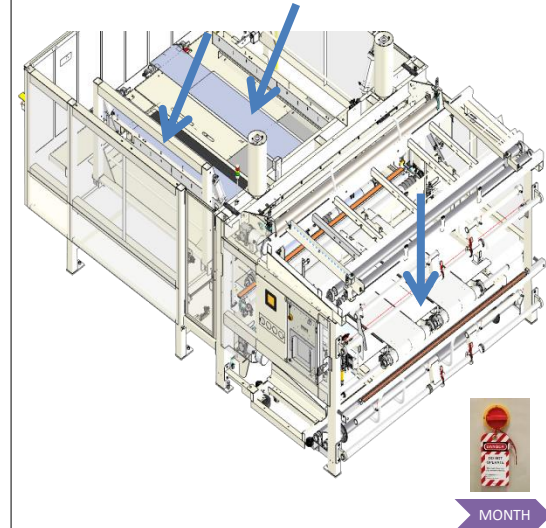
## 1390HCE Auto Pack



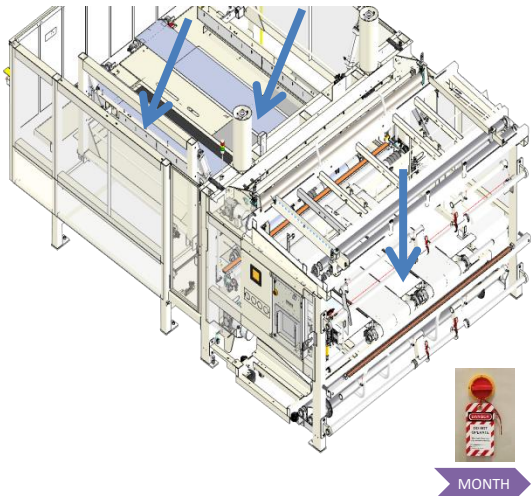
11. Check all conveyor belts for cracks, tears, rips, check seams and tension.

## Frequency

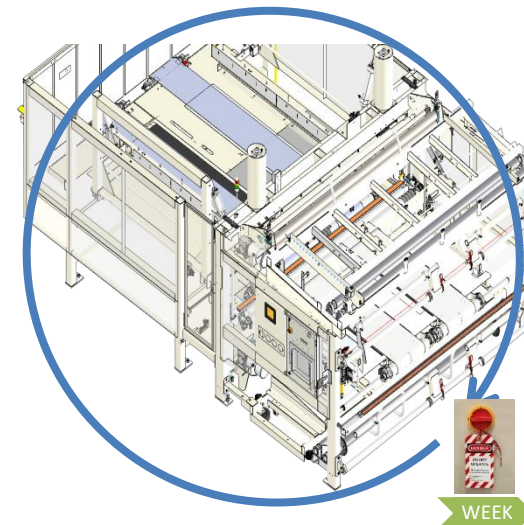
DAY WEEK MONTH



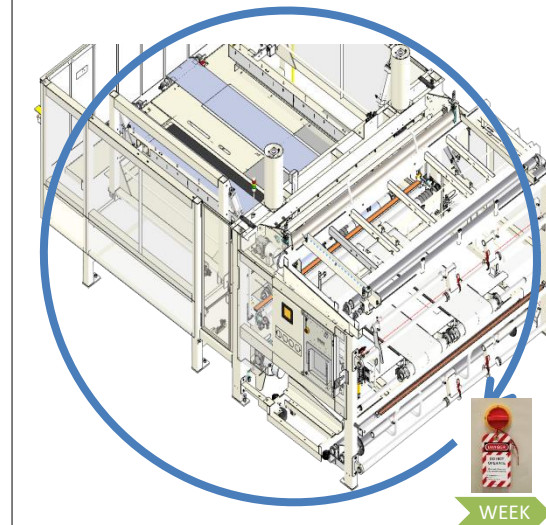
11. a. Check the alignment of the belts. Make sure all three(3) are tracking properly.



11. b. Check tension on single infeed and both outfeed belts. Adjust as needed.



12. Check all conveyor roller bearings and lubricate w/ PTFE based grease.



13. Check all other bearings and lubricate.

Preventative Maintenance (Mechanic schedule)

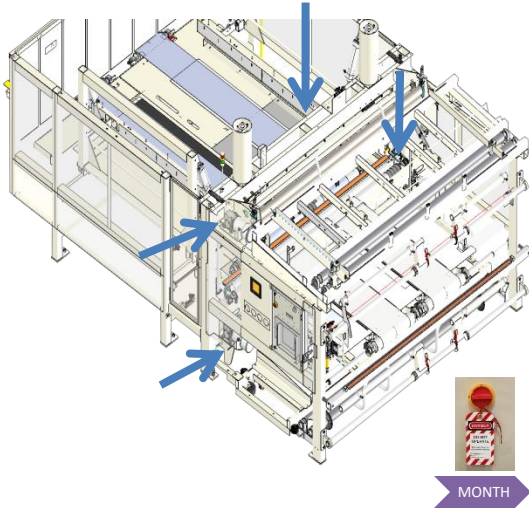
1390HCE Auto Pack

Frequency

DAY

WEEK

MONTH



14. Check chain tension on drive motors. 3 in infeed section and 1 in the outfeed.

Additional Maintenance List or Notes:

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**\*\* Warning \*\***  
**Never for any reason**

- Enter Inside the machine
- Crawl under the machine
- Climb on top of the machine
- Reach inside the machine
- Place any body parts inside the machine

After pressing the start button, the infeed belts will run continuously and will automatically process materials or products

**\*\* Warning \*\***  
**Never for any reason**

Perform any machine maintenance unless the machine is properly powered down and cool.

Lockout/tagout procedures must be followed.

In manual mode, machine may be prompted to execute any of its functions. Only a properly trained operator or technician should work on or use the machine in manual mode of operation to prevent injury or machine damage.