W·SERIES

Long Foot Sealers
Model: WN-750F, WN-900F

Distributed By:

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General Information

Thank you for purchasing our W-Series Long Foot Sealers.

This owner's manual contains information relating to your sealer. The manual will provide you with basic information concerning both operation and maintenance of your new machine. Please read it carefully as failure to do so may result in bodily injury and/or damage to the equipment.

Please fill in the information below. You will find the information on the machine identification plate. You will need this information when ordering replacement parts or making technical inquiries.

WHLF EQUIPMENT INFORMATION

- Model #
- Serial #
- Purchase Date:
- Reference # (found on packing slip)
- Owner:

Safety Instructions

WARNING! *Below are general safety precautions and warnings that should be understood prior to setting up or operating your equipment. Read and fully understand all instructions and warnings prior to using this unit. Your safety is most important! Failure to comply with procedures may result in serious injury or property damage. Remember:* ***Your personal safety is your responsibility.***

Unsafe practices or unauthorized modifications could result in accidents or property damage. Failure to follow these safety rules and take necessary precautions can result in serious injury as well as damage to equipment.

- Never operate or service your sealer until you have read this manual completely and understand it fully.
- Plug the sealer into a standard 120 Volt, 60Hz wall outlet or surge protector.
- Do not use the sealer if the power cord, plug or any other parts are damaged. Be sure not to allow the power cord to drape into your work area. Check that all parts are operating properly and perform the intended functions. Check for any worn parts before starting operation. Check for all other conditions that may affect the operation.
- Reduce risk of unintentional starting. Make sure the power switch is in the "OFF" position before connecting to the power source.
- Always disconnect sealer from power source before servicing, changing accessories or cleaning the unit.
- To provide protection against the risk of electrical shock, the power connection must be properly grounded at all times.
- Do not leave the sealer unattended when in use. Disconnect the sealer from the power source before leaving the work area.
- Sealer is used solely for sealing thermoplastic materials. Using the machine for any other purpose can cause damage to the machine and operator.
- While operating machinery, wear close-fitting clothing and tie back long hair to prevent any external items from getting caught in the machine. Do not wear jewelry when operating the sealer.

- Never touch the heating elements with bare hand while the sealer is plugged into a power source, in operation or just finished operation. Touching heated areas may cause fire and/or severe burns.
- While machine is in operation, do not place fingers, tools, or other foreign objects on or into the machine. Do not place hands or fingers near pinch points. Do not touch machine while it is in operation. Perform all procedures carefully and watch where hands and fingers are at all times.
- The sealer is not water resistant or water proof. Spraying down the machine will damage machine or cause electrical shock. Do not submerge the sealer into water or liquid.
- Do not operate sealer in a corrosive or humid environment.
- Always keep the machine clean, lubricated and in good working condition. Follow any maintenance and lubrication procedures outlined in this manual. Make sure unit is disconnected from power source before cleaning.
- NEVER use any accessories or parts from other manufacturers. Machine should not be altered or modified using parts that are not genuine authorized parts. Doing so will VOID YOUR WARRANTY.
- ***When replacing the heating elements, always replace the PTFE adhesive under the heating element. A worn PTFE adhesive can cause the heating element to break.*** The PTFE adhesive works as a barrier between the body of the sealer and the element. Never allow the element to come in direct contact with the sealer body as that will damage the timer.
- Never leave the sealer unattended. Be safe, disconnect the sealer from power source before leaving work area.
- Always keep out of reach of children and pets.
- Close supervision is necessary when any machine is near persons with reduced physical, sensory or mental capabilities or lack of experience and knowledge . This sealer is NOT to be used by children or by persons with reduced physical, sensory or mental capabilities or lack of experience and knowledge.
- DO NOT use the sealer outdoors.
- DO NOT use the sealer while under the influence of drugs, medications or alcohol.

SAVE THESE INSTRUCTIONS - REFER TO THEM OFTEN AND USE THEM TO INSTRUCT OTHERS.

Introduction

Scan QR Code for Video Demo

W-Series Long Foot sealers are foot sealers ideal for high volume poly bag and other thermoplastic sealing. The sealer allows you to keep both hands free for quicker and more accurate sealing. Our W-Series long foot sealers can seal polyethylene, polypropylene, saran, nylon, static shielding bags, Mylar up to 10mil in total thickness.

Features of the W-Series Long Foot Sealers

Your foot sealer is equipped with a wide range of standard features and capabilities.

- Impulse sealing - no warm up time needed
- Plug-in electronic timer for variable control
- All metal construction
- Heavy duty
- Sits on rectangular stand for stability
- Adjustable work table height
- Optional: Taller stand and tension rod available adding 10" height
- Manufacturer spare parts kit includes: 2 heating elements

How Do W-Series Long Foot Sealers Work?

Basic Principles
Place material on lower jaw and activate footboard

Our W-Series Long Foot impulse sealers fire a short burst of electricity through a specially designed heating wire to weld thermoplastic materials together. The duration of the seal time will depend on the sealing characteristics of the bag being sealed. The sealing process is simple: The operator places the bag between the sealing jaws and presses the footboard to activate the unit. The operator retrieves the sealed bag and repeats the process. Bags are sealed repeatedly and uniformly.

Specifications

	WN-750F	WN-900F
Power	110V/60Hz	110V/60Hz
Watts	400W	600W
Seal Width	2.7mm	2.7mm
Sealing Length	29 3/4"	35 3/4"
Standing Height	33 1/2"	33 1/2"
Working Table Dimensions	27 1/2" x 6 3/4"	27 1/2" x 6 3/4"
Tray Adjustment Height	Up to 6.5"	Up to 6.5"
Throat Depth	3 1/2"	3 1/2"
Dimensions	33" x 9" x 33 1/2"	38 5/8" x 9" x 33 1/2"
Net Weight	68lbs	75lbs
Shipping Dimensions	41" x 21" x 18"	47" x 23" x 20"

Gross Weight	73lbs	77lbs

W-Series Long Foot Sealer Diagram

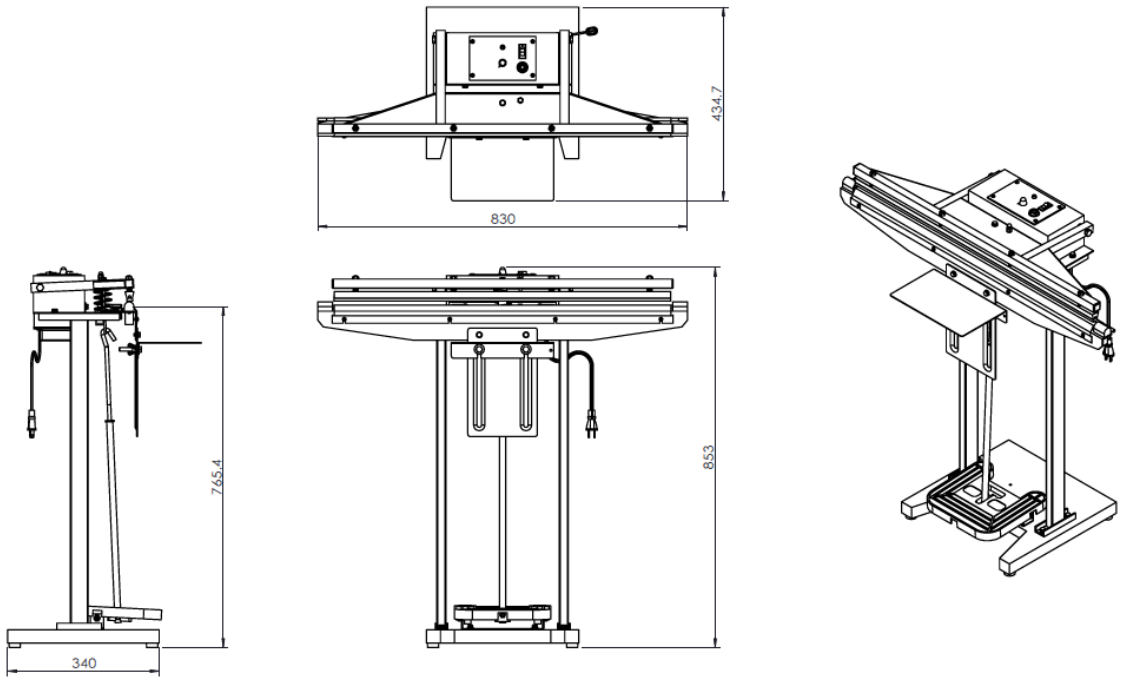

Figure 1. WN-750F Foot Sealer Dimensions - measurements are in mm

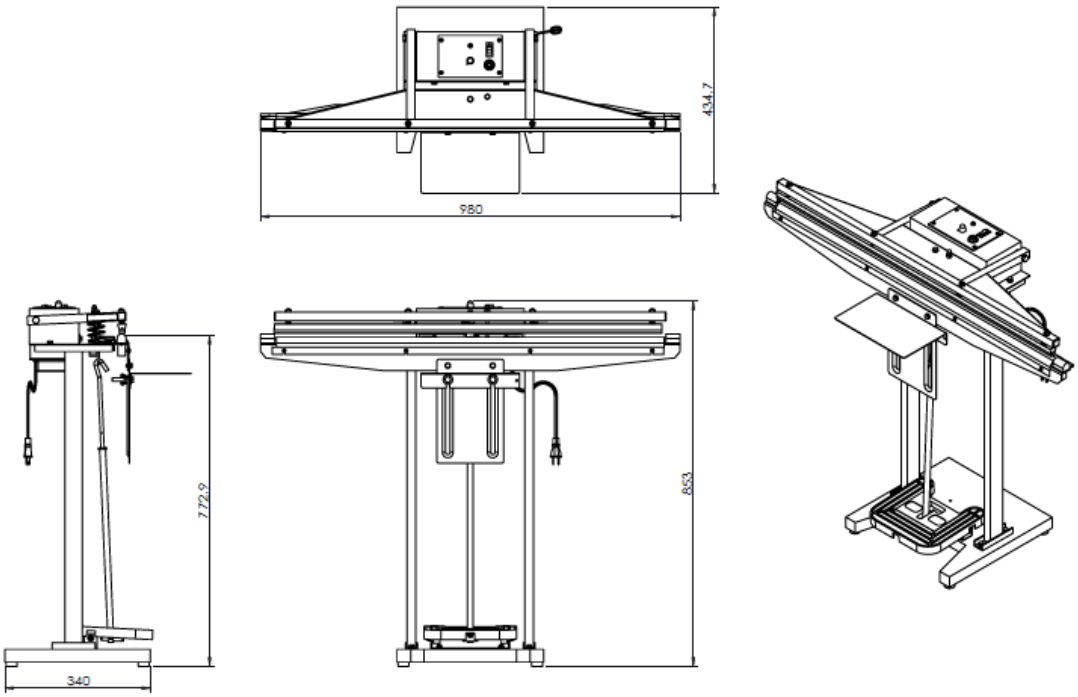

Figure 2. WN-950F Foot Sealer Dimensions - measurements are in mm

Electrical Circuit Diagram

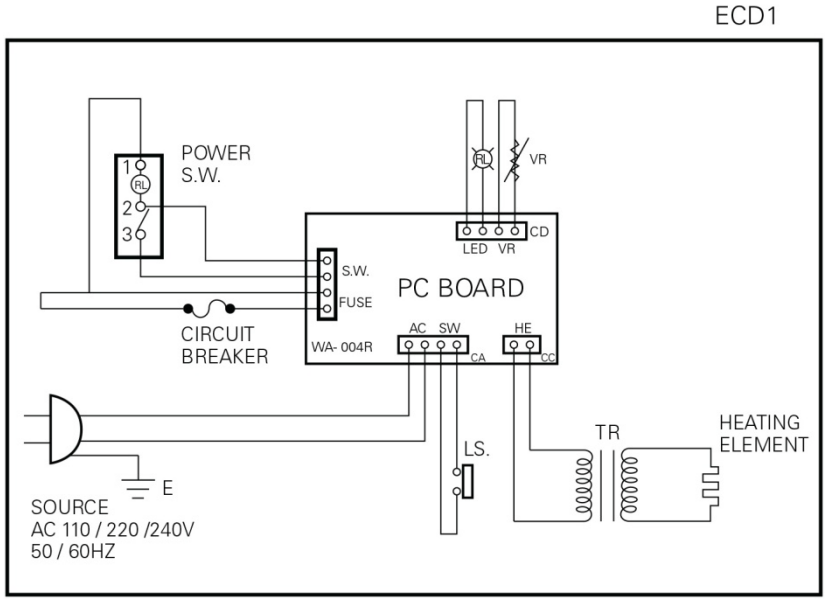

Figure 3. Electrical Circuit Diagram

Getting to Know your Foot Sealer

W-Series Long Foot Sealers are simple and efficient sealing machines.

Figure 4. W-Series Foot Sealer Overview

Operating your Sealer

Assembly Instructions

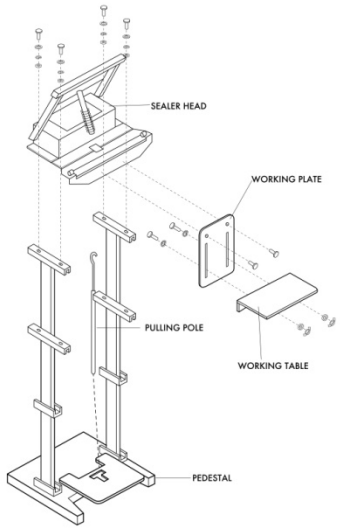

Figure 5.

1. Position the pedestal on the floor standing upright.
2. Mount the complete sealer head to the top of the pedestal and attach with four screws.
3. Bring the upper jaw down and position the small pulling pole/plate set **(Figure 11, Item #9A)** through the pressing spring **(Figure 11, Item #9)**.
4. Gently push the upper jaw to meet the lower jaw. While jaws are compressed, reach under the unit and hook the pulling pole **(Figure 11, Item #5)**. onto the small pulling pole/plate set.
5. With jaws still compressed, lift up the foot pedal to a 45° angle and slide the metal foot pedal rod onto one of the two pre-molded slots. This will create tension on the foot pedal and cause the pedal to stand upright at 45°.
6. Sealer is now ready to operate.
7. To install the optional working plate and table, remove the screws from bottom sealing jaw and install the working plate and table.

Operation

1.  Before operating, check the heating element, PTFE cover, PTFE adhesive and the silicone rubber.
2. Insert the power cord into the correct receptacle (110V).
3. Turn the power switch on.
4. Set the timer knob to the lowest setting. Always start with a low setting and increase gradually as needed.
5. Place material to be sealed under the upper jaw and press down on the foot board gently, but firmly. The red light will turn off when sealing time is complete.
6. ***When red light turns off, keep pressing the foot board for an additional 2-3 seconds. For a high quality seal, seals must cool under pressure. We usually recommend a congeal setting of at least 2x that of the heat setting but every bag will have variations. Thicker materials will require a longer cool (congealing) time.***

Tips for Successful Sealing

1. If the seal is broken or damaged, decrease the sealing time.
2. If the seal is not fully welded, increase the sealing time.
3. If the sealing material sticks to the sealing pad, decrease the congealing time.
4. If the width of the seal is not perfect or does not match the size of the element, increase the congealing time.
5. Always keep the sealer clean. Remove any residue found on the platform and PTFE cover. Silicone spray may be used for this purpose.
6.  ***When replacing the heating elements, always replace the PTFE adhesive under the heating element. A worn PTFE adhesive can cause the heating element to break.*** The PTFE adhesive works as a barrier between the body of the sealer and the element. Never allow the element to come in direct contact with the sealer body as that will damage the timer.
7. Occasionally check the condition of the silicone rubber for wear or burns. A damaged silicone rubber will affect the quality of the seal.
8.  Be sure to turn off the power or unplug the unit before replacing any parts.

Maintenance

The following maintenance procedures should be followed to ensure the longevity of your W-Series foot sealer.

Inspection and Cleaning

1. Inspect your machine daily.
2. Use a clean cloth to remove any plastic residue remaining on the PTFE cloth.
3. When replacing the elements, always check the condition of the bottom PTFE tape.
4. Check the condition of the silicone rubber for wear and burns. A damaged silicone rubber will affect the quality of the seal.

Replacement Kit Instructions

W-Series Long Foot impulse sealers will require new heating elements and PTFE from time to time. Heating elements will break through wear and tear. A good rule of thumb is to replace the PTFE adhesive every time you change your heating element. The PTFE cover prevents the plastic or other thermoplastic material you are sealing from sticking to the heating element.

Replacement kits are available from your distributor. Kits include (2) heating elements, (2) PTFE adhesives, and 1ft long roll of PTFE cover. For replacement kit part #s, refer to your model #.

	WN-750F	WN-900F
Replacement Kit	RK-30F-WN-750F	RK-35F-WN-900F
Heating Element	HE-30-2.7-WH	HE-35-2.7-WH
PTFE Adhesive	TA-30	TA-35
PTFE Cloth (1ft. roll)	TR-30-12	TR-35-12
Silicone Rubber *(not included in RK)*	SR-WN-750F	SR-WN-900F

To install your replacement kit on your sealer, turn off power and unplug sealer.

Removing Worn Parts.

Scan QR Code for Video Demo

1. Loosen the screws on the PTFE cover plate **(Figure 11, Item #11a)**.
2. Remove the heating element cover **(Figure 11, Item #23)**.

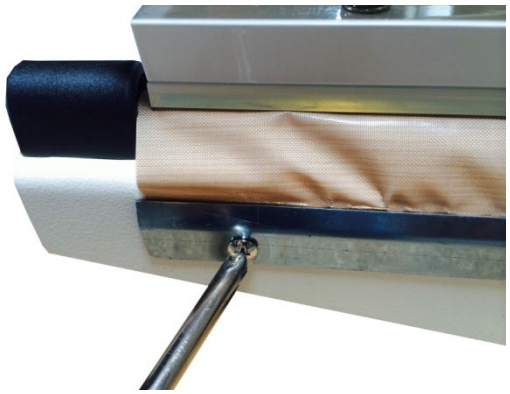

Figure 6. Loosen screws on PTFE plate.

Figure 7. Remove heating element cover

3. Lift up the PTFE cover to expose the heating element **(Figure 11, Item #12)**.
4. Remove the heating element by lifting off the eyelets of the heating element from the mounting spring on both ends **(Figure 11, Item #18)**.
5. Peel off the PTFE adhesive under the heating element.

Figure 8. Remove heating element from mounting spring

Figure 9. Remove PTFE adhesive

Installing New Replacement Parts.

1. Remove the backing of the liner found on the PTFE adhesive.
2. Apply it to the sealer's sealing platform. The PTFE adhesive must always extend past the sealing platform by approximately ¼" to ½" on both ends. Bend down the excess on both ends. (The PTFE adhesive acts a barrier between the metal body and the heating element. Never allow the heating element to come in direct contact with the sealer's body because it will damage the timer.)
3. Place a new element on top of the PTFE adhesive by fitting one eyelet of the heating element on one mounting spring followed by the other mounting spring. Using a screwdriver to flex the mounting spring inward will ease the placement of the element on the mounting spring. Check the elements to ensure it is tight and intact.
4. Cut off any worn out PTFE cover. Ease out enough footage of PTFE cover to cover the heating element and extend to the front of the PTFE cover plate.
5. Tighten the screws to affix the PTFE cover plate.
6. If a whole roll of PTFE cover needs to be replaced, loosen the multi-star knob **(Figure 11, Item #10a)** found on the plate for PTFE **(Figure 11, Item #10b)** and remove the PTFE roller **(Figure 11, Item #11)**. Tape one end of the PTFE cover to the rod and roll up the entire piece. Position the PTFE cover and rod using the plate for PTFE. Ease out enough footage of PTFE cover to cover the heating element and extend to the front of the PTFE cover plate.

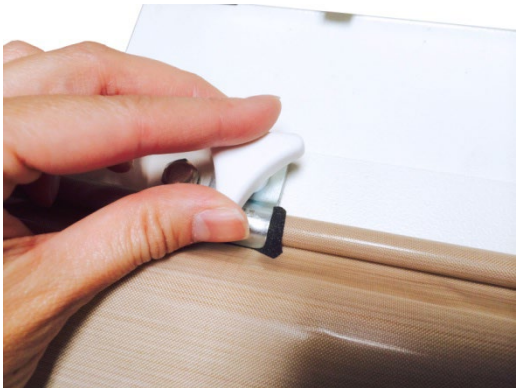

Figure 10. Loosen multi-star knob to remove the PTFE roller.

Parts Diagram

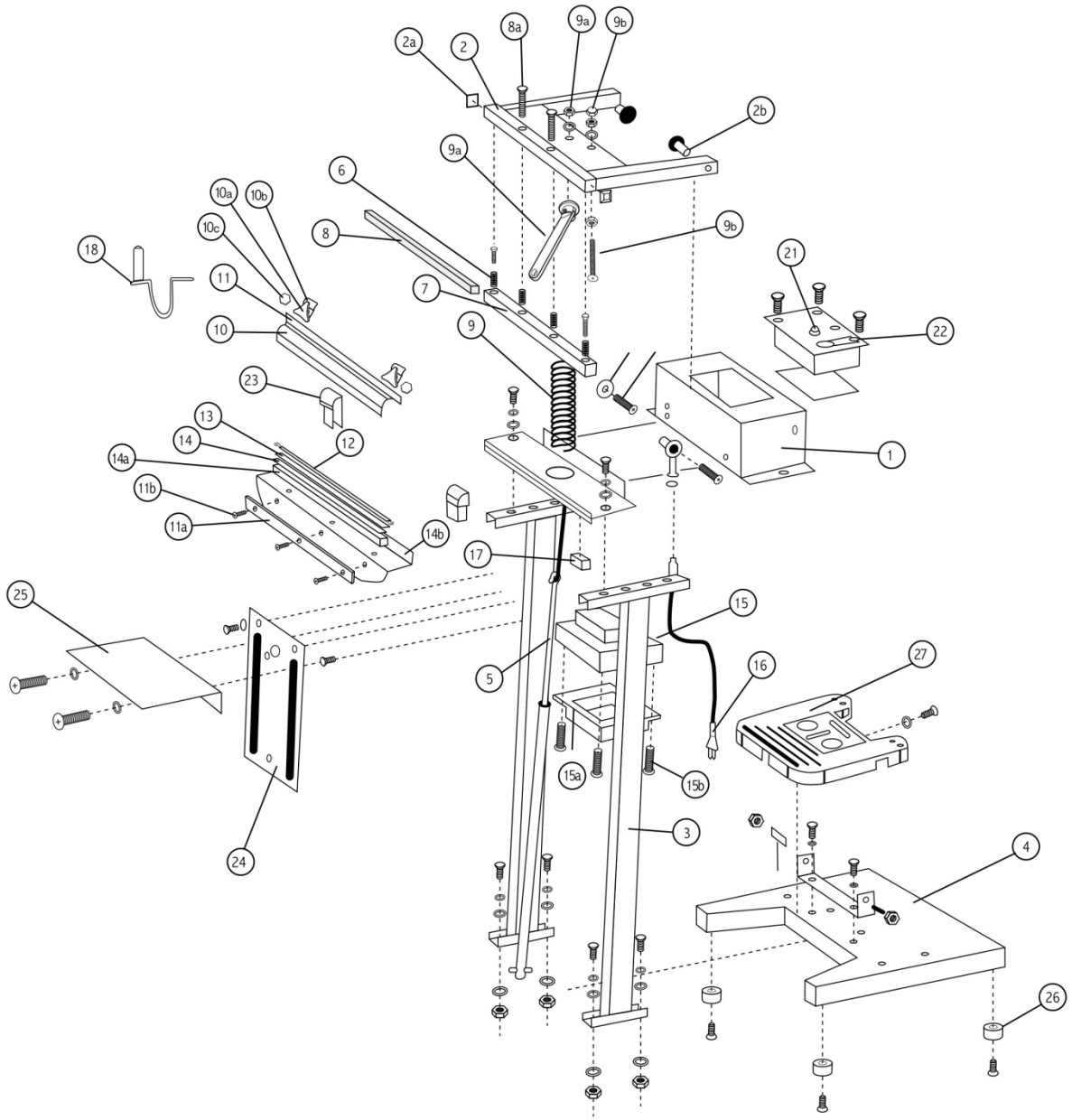

Figure 11. Spare Parts Diagram Overview

Figure 12. Spare Parts Diagram Overview

Item	Part #	Description	Comments
RKs	**RK-Model#**	**REPLACEMENT KITS Includes (2) elements, (2) PTFE adhesives, and 1ft PTFE cover**	**specify model # when ordering**
1		Control Set Bracket / Skull	
2		Upper Jaw	**specify model # when ordering**
2B	**WHLF-2B**	Hex Cap Screw 9x38	
3	**WHLF-3**	T Pedestal Stand	
3a	**WHLF-3a**	T Pedestal Stand, Extended, 36"	
4	**WHDF-4**	Pedal Base	
4A	**WHLF-4A**	Pedal Base and Bracket and Screws	
4B	**WHLF-4B**	Bracket and Screws for Pedal Base	
4C	**WHLF-4C**	Screws for the side bracket for Pedal Base (2pcs)	
5	**PPS-WHLF**	Level Set, Pulling Pole Set	
5a	**PPSE-WHLF**	Level Set, Extended 36"	
	PPE+ST+WHLF	T Pedestal Stand + Pulling Pole Set	
	PPSE+STE+WHLF	T Pedestal Stand, Extended, 36" + Pulling Pole Set	
6	**WHA-7**	Spring, Small, Silicone Bracket (WHA, WHLF)	
7		Silicone Rubber Holder	**specify model # when ordering**
8	**SR-WN-750F SR-WN-900F**	Silicone Rubber	**specify model # when ordering**
8A	**WHA-50**	Hex Cap Screw 5/16 (4 screws on sealer)	
9	**WHDF-12A**	Pressing Spring, XL, same as WHDF - 132mm	
9A	**WHLF-9A**	Short Pulling Pole and Plate Set	
9B	**WHLF-9B**	Long screw + 2 Hex washers + Head Nut	
10	**TR-30 TR-35**	PTFE Cover	
10A	**WHA-15**	Multi Star Knob (W-Series)	
10B	**WHA-14**	Plate for PTFE Sheet (Clip) (W-Series)	
10C	**WHLH-44**	Hexagon Bolt M6*16	
11		PTFE Cover Roller	**specify model # when ordering**
11A	**WHLH-5B**	Fixed Plate for PTFE Cloth	
11B	**Screw-M4x8**	M4*8 Screw	
12	**HE-30-2.7-WH HE-35-2.7-WH**	Heating Wire	**specify model # when ordering**
13	**TA-30 TA-35**	PTFE Adhesive	**specify model # when ordering**
14	**WHLH-49**	Fiber Plate - 1.2m (47") - cut to fit	
15	**TRNS-**	Transformer	**specify model # when ordering**
15A		Transformer Cover	
15B	**Screw**	Bolt - 5mmx90mm	
16	**PWC-WH**	Power Cord	
17	**MSW-WHF**	Limit/Microswitch	
18	**MS-WH**	Spring Hook, Mounting Spring	
19	**WHLF-19**	Power Switch	
20	**WHI-11c**	Circuit Breaker 15A	
21	**WHA-30**	Knob, Red for (W-Series)	
22	**T-WH**	Control Panel, Timer, 15A	
23	**WHLF-23**	Heater Element Cover	
24	**WHLF-24**	Working Adjusting Plate	
25	**WHLF-25**	Working Plate, Working Table - 27 1/2" x 6 3/4"	
26	**WHLF-26**	Rubber Foot (WH Rubber Foot except WHA)	
27	**FB-WH**	Foot Board	
28	**PPE+ST+WHLF**	Pedestal Stand and Level Set (3+5)	
29	**PPSE+STE+WHLF**	Pedestal Stand and Level Set Extended 36" (3a +5a)	

Troubleshooting

Problem	Possible Causes	Solution
No sealing Timer lights off	1. Disconnected power cord 2. Power cord is broken 3. Blown fuse 4. Transformer is broken	1. Check or change plug 2. Replace power cord 3. Replace fuse 4. Replace the transformer
No sealing Timer lights are on	1. Heating element is broken 2. Poor contact at heating terminal blocks	1. Replace the heating element 2. Clean, tighten or change the heating terminal blocks
No sealing Power light on Heat indicator off	1. Footswitch malfunction 2. Microswitch malfunction 3. Microswitch out of place	1. Replace footswitch 2. Replace microswitch 3. Adjust microswitch
Burnt PTFE cloth	1. Timer malfunction 2. Timer setting too high	1. Replace timer 2. Decrease timer setting
Broken heating element	1. Worn PTFE adhesive	1. Replace PTFE adhesive
Wrinkled seal	1. Seal time is set too high 2. Cooling (congeal) time is too short	1. Decrease 2. Increase congealing time
Imperfect seal	1. Worn PTFE cloth 2. Worn silicone rubber	1. Replace PTFE cloth 2. Replace the silicone rubber
Burnt seal	1. Seal time is set too high	1. Decrease seal time
No seal	1. Seal time is set too low	1. Increase seal time
Seal sticking to PTFE cloth	1. Worn or dirty PTFE cloth 2. Worn or dirty silicone rubber	1. Replace or clean PTFE cloth 2. Replace or clean silicone rubber