

# Vacuum Packaging Machine

## User Manual



Contact detail:

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Address:16300 Shoemaker Ave.Cerritos.CA90703

Model : HVAC265,305,405,510 , HVAC510/2,610/2

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# ***General Information***

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**Our company is not responsible for any harm or injury caused due to any person's improper or negligent use of this equipment. The product shall only be operated by someone over the age of 18, of sound mind, and not under the influence of any drugs or alcohol, who has been trained in the correct operation of this machine, and is wearing authorized, proper safety clothing. Any modification to the machine voids any warranty and may cause harm to individuals using the machine or near the machine while in operation.**

## **CHECK PACKAGE UPON ARRIVAL**

Upon receipt of the product, inspect for external damage. If no damage is evident on the external packaging, open carton to ensure all ordered items are within the box, and there is no concealed damage to the machine. If the package has suffered rough handling, bumps or damage (visible or concealed), note it on the bill of lading before accepting the delivery and contact sales platform within 24 hours, so we may initiate a claim with the carrier. A detailed report on the extent of the damage caused to the machine must be filled out within three days, from the delivery date shown in the shipping documents.

**Before operating any equipment, always read and familiarize yourself with all operation and safety instructions.**

**Thank you for purchasing this machine. It's of the utmost importance to save these instructions for future reference. Also save the original box and packaging for shipping the equipment if servicing or returning of the machine is required.**

# ***Safety and Warranty***

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## **GENERAL SAFETY REGULATIONS**

These vacuum packaging machines are capable of: easy operation, easy maintenance, user friendly and to cope with wide range application. Especially suitable for soft packing material such as complex film, aluminum-foil complex film etc. It can also pack products in vacuum form or inserting gas after vacuum form to solid, powder and even liquid, paste, seed, fragrant article, medicine, chemical, electronic, precision instrument, meter and rare expensive metal etc.

The machine must be used only by suitably trained personnel. Furthermore, these personnel must have read this manual carefully. Please comply to the following instructions:

- This machine is user friendly. Close the machine cover, air exhaustion (vacuum), gas filling, heating, sealing, label printing, cooling, return-air, to the re-opening of cover, the whole processing is done automatically.
- The sealing temperature and sealing time can be set flexibly with a wide adjustable range to suit various packing bags with different materials and specifications.
- This machine is equipped with safe grounding protection and E-Stop Button protection to deal with sudden accident. The E-Stop Button can be pressed to stop packing procedure immediately if there is any emergency arise during processing.
- The articles packed in vacuum condition ensure to the quality and freshness for a longer period as it can prevent oxidation, mildew, moth, rotten and damp, vacuum machine have different working environment.

# ***Safety and Warranty***

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## **WARRANTY:**

Within the one-year warranty period, contact local wholesaler or retailer to authorized service depot in the area.

Unauthorized maintenance will void the warranty. Warranty covers electrical and part failures, not improper use.

## **WARNING:**

The packaging components are classified as normal solid urban waste and can therefore be disposed of without difficulty.

In any case, for suitable recycling, we suggest disposing of the products separately (differentiated waste) according to the current norms.

**DO NOT DISCARD ANY PACKAGING MATERIALS IN THE ENVIRONMENT**

# Technical Specifications

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Model	HVAC265D	HVAC305D	HVAC405D	HVAC405D2
Shell detail (materials)	Stainless steel	Stainless steel	Stainless steel	Stainless steel
Chamber size (mm)	380*305*75	380*345*75	445*440*75	445*440*75
Voltage (V/Hz)	110/60	110/60	110/60	110/60
Power (W)	370	370	370	370
Sealing length & width (mm)	(265*8)x1	(305*8)x1	(405*10)x1	(405*10)x2
Max seal thickness(mm)	0.1-0.5	0.1-0.5	0.1-0.5	0.1-0.5
Open cover high(cm)	63	65	71	71
Machine dimension (cm)	48*37*44	48*39*40	56*49*53	55*50*46
Package dimension (cm)	55*42*52	54*56*53	53*56*64	63*56*64
Gross weight (kg)	42	45	71	71
Net weight(kg)	32	35	59	59
Sealing power(W)	300-600	400-900	1200-1700	1900-2300
Sealing time(s)	1-9.9	1-9.9	1-9.9	1-9.9
Pump capacity(m <sup>3</sup> /h)	8	10	20	20

# ***Technical Specifications***

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Model	HAVC405M	HAVC510M
Shell detail (materials)	Stainless steel	Stainless steel
Chamber size (mm)	445*440*75	550*525*75
Voltage (V/Hz)	110/60	110/60
Power (W)	750	750
Sealing length & width (mm)	(405*10) x2	(510*10) x2
Max seal thickness (mm)	0.1-0.5	0.1-0.5
Vacuum time range (Sec)	10-30	10-30
Open cover high (cm)	117	125
Machine dimension (cm)	56*51*94	68*59*97
Package dimension (cm)	62*56*103	740*65*112
Gross weight (kg)	117	105
Net weight (kg)	104	92
Sealing power (W)	1700-2000	1900-2200
Sealing time (s)	1-9.9	1-9.9
Pump capacity (m <sup>3</sup> /h)	20	20

# ***Technical Specifications***

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Model	HVAC500/2C	HVCAC600/2C
Shell detail (materials)	Stainless steel	Stainless steel
Chamber size (mm)	565*515*40	665*515*40
Voltage (V/Hz)	110/60	110/60
Power (W)	1500	1500
Sealing length&width (mm)	(500*10)x2	(600*10)x2
Max seal thickness(mm)	0.1-0.5	0.1-0.5
Vacuum time range (Sec)	10-30	10-30
Open cover high(cm)	118	123
Machine dimension (cm)	125*68*95	145*68*98
Package dimension (cm)	136*76*112	155*76*113
Gross weight (kg)	200	260
Net weight (kg)	180	240
Sealing power(W)	1800-2300	2200-2800
Sealing time(S)	1-9.9	1-9.9
Pump capacity(m <sup>3</sup> /h)	40	40



# ***Installation***

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## **PREPARATION BEFORE USE**

1. Before operation, please read through the user guide about each operation rule and safety precaution.
2. You must fill the vacuum pump with pump oil before use (when the machine is placed at a horizontal position, the oil should be kept at 1/2-3/4 in the oil window). When running, the oil level should not be lower than 1/3 in the oil window. Do not fill with too much oil to avoid overflow.
3. The machine should be placed horizontally in a well ventilated and it space, free from corrosive gas and heavy dust.
4. Make sure that the machine is properly grounded before use.
5. Always ensure top cover is open before turning the power on. Start the machine by closing the top cover and the process will start automatically.
6. Preheat of vacuum pump must be done in low temperature working area. Turn off the heater selection switch at the control panel to off position. This is to prevent heating process and cut down wear and tear on the unit.

**Tip: To quickly process a small item or product using a bigger chamber is to place a solid block into the chamber in order to occupy the chamber space so as to allow less vacuum time needed.**

**Note: Do not block the air hole in the chamber.**

## **SETTING**

Please set every parameter first before starting the machine.

1. Turn on the power supply, check through the setting shows on the panel and make sure "----" must be shown after setting is done. Otherwise, operation of this machine cannot be function if the setting is not on this mode.

# ***Installation***

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2. Press the setting button, the indicator lamp if vacuum lights to enter the setting state of vacuum timing. Press the upward or downward key to increase or decrease vacuum time in the range of 0-99 seconds.

3. After the vacuum time is set, press the set key and the nitrogen filling indicator lamp lights to enter the setting state of nitrogen filling. Press the upward or downward key to increase or decrease nitrogen filling time in the range of 0-99 seconds.

Note: Some models of our machine do not have nitrogen filling function, so after setting the vacuum time, it enters sealing time directly.

4. Press the setting button, heating indicator lamp lights to enter heating setting state. Press the upward or downward key to increase or decrease the heating sealing time in the range of 0-9.9 seconds. The time setting should be from low timing and gradually to higher timings.

# ***Operation***

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1. Turn on the power supply and select a suitable vacuum packing bag for the product.

2. Set the processing parameter and select the sealing temperature. Please refer to the installation section.

3. Place the vacuum bag at the chamber with the opening end on top of the sealing bar. Clamp it with the hook provide.

4. Close the acrylic cover and the machine will complete the processing procedure automatically.

5. During processing, the vacuum chamber will form a vacuum self-lock state, the whole heating and sealing procedure are completed in a vacuum environment, and the LED display on panel shows the flow process.

6. When the vacuum indicator on panel lights, the equipment is under filling state, the LED display shows the reverse timing of filling time, and it will enter the next work state automatically after the reverse timing finished.

7. When the nitrogen filling indicator on panel lights, the equipment is under filling state, the LED display shows the reverse timing of filling time, and it will enter the next work state automatically after the reverse timing is finished.

# Operation

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8. When heating indicator lights, the equipment enters heating work state, and the panel shows the reverse timing of heating. It will enter cooling state automatically after the timing is finished.

9. According to time setting, the machine doesn't act when cooling, the panel shows "□□" till the reverse timing is finished, air is returned, the cover opens automatically, and the whole processing is finished. Then prepare the next cycle.

10. Press the Stop Button for a sudden condition under processing state, the machine will go to return-air action automatically, the cover opens automatically after return-air action, so the processing ends.

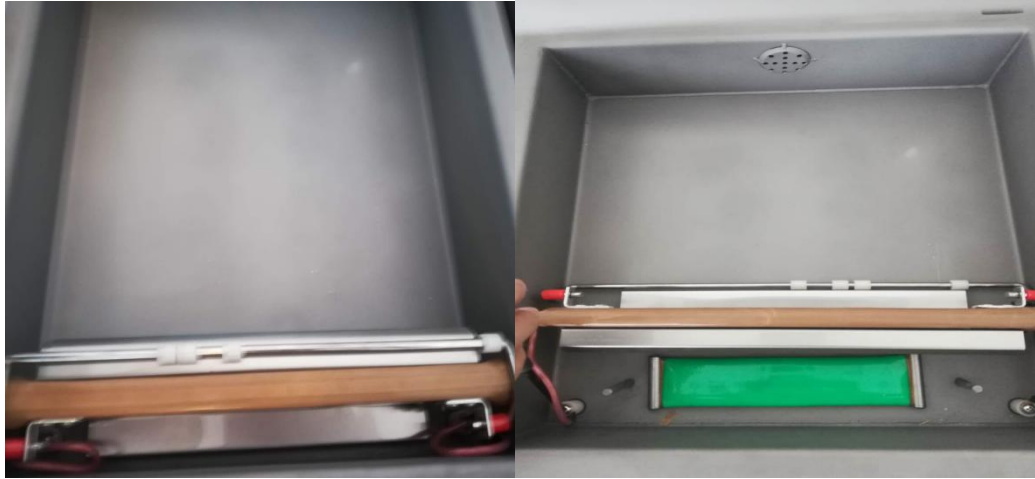
## NOTES:

- Silicone rubber strip come with one side nerving and the other for letter and number inserting. It will have embossed effect on sealing surface.
- Please do not run the machine without any vacuum bag attach. Otherwise, the heating element will have higher wear and tear.
- Cut off the power supply and pull out external plug when no use.
- The vacuum gauge/meter reading may be different due to different area. At high altitudes, the data in vacuum meter goes down.
- Please adopt suitable cooling measure when processing is done in a high temperature occasion.
- Please use the vacuum bag whose material does not bring any poisonous gas in the sealing.
- The machine should be placed horizontally in the transportation; the inversion is not allowed. The transportation must be proceeded strictly according to the instructing marks on the shipping case.
- The machine should be stored in dry, ventilated, normal temperature place.
- Mind your head when the lid open, and avoid the lid striking your head.
- Please ask a professional to solve the problem. Do not do some repair works by yourself.
- The spare parts should match our machine in the replacement.

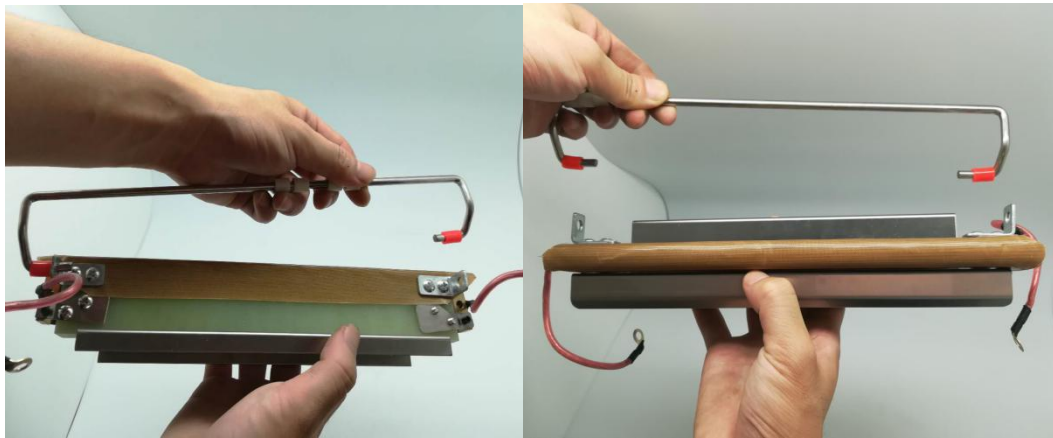
# Maintenance

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## SEALING TAPE AND HEATING WIRE REPLACEMENT



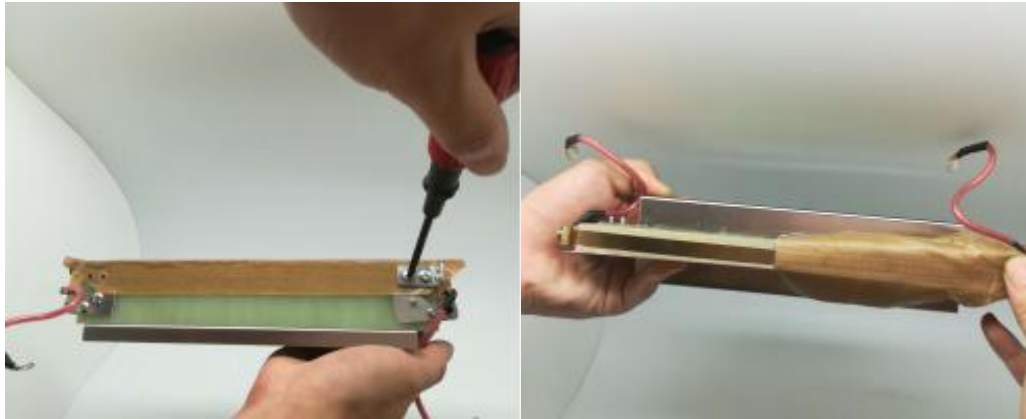
1. Disconnect the cable from the pin, then pick the complete sealing bar up from the vacuum chamber.



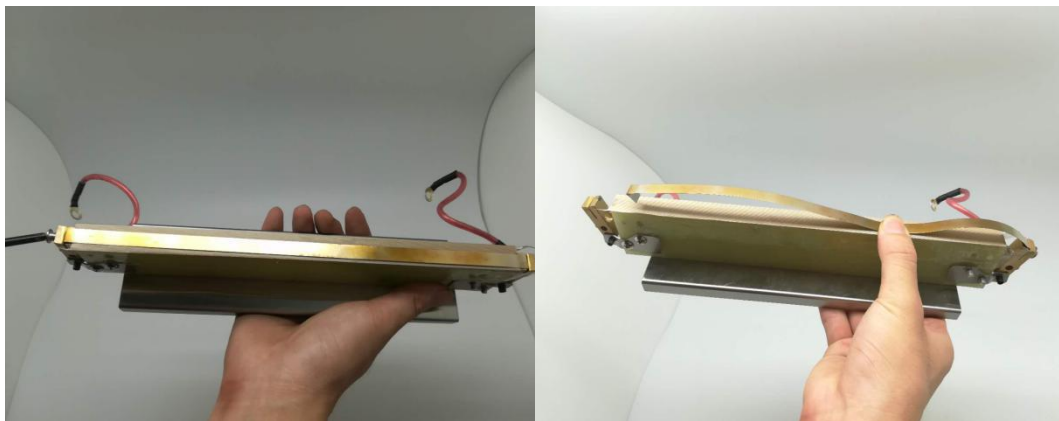
2. Remove the pressing bar from the complete sealing bar by cross screwdriver.

# ***Maintenance***

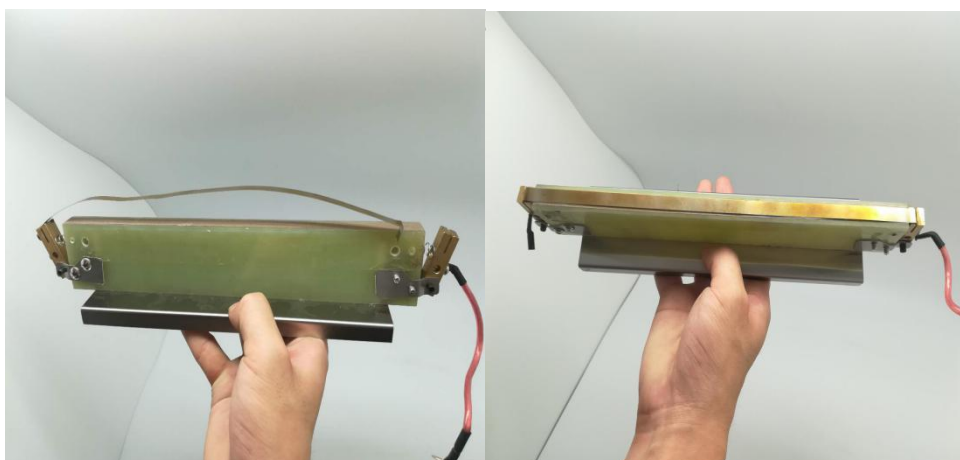
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3. Unscrew the screw with a cross screwdriver, and then tear off the Teflon tape.

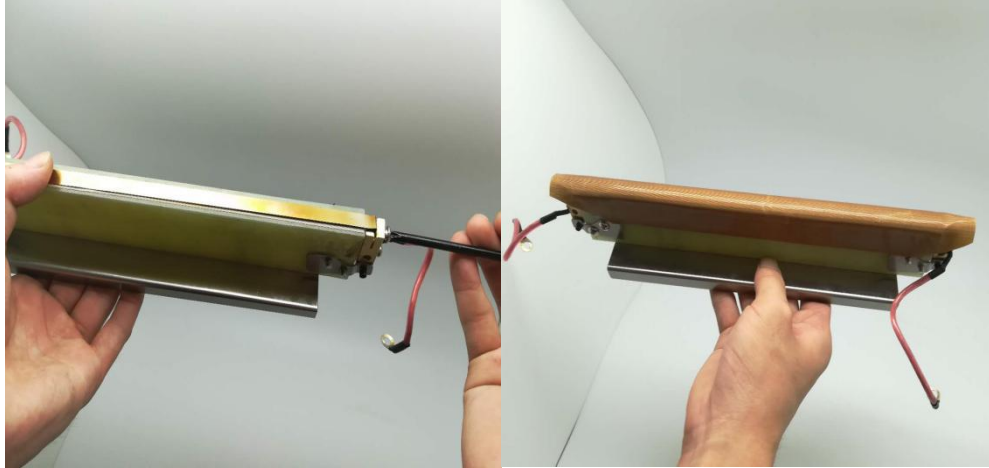


4. Remove the m5 screws from the two sides of sealing bar by cross screwdriver, then take out the heating wire.

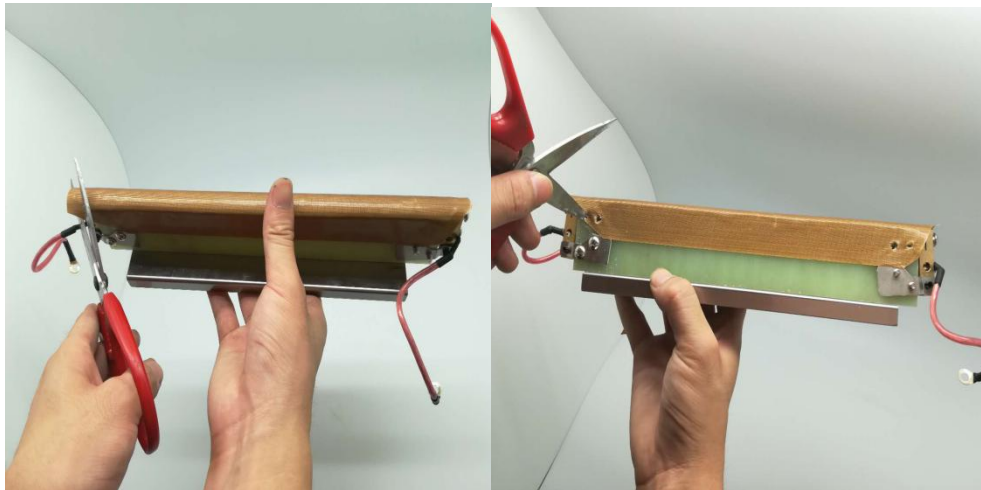


# ***Maintenance***

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5. Install the springs on both sides, then Insert the heating wire into the grooves on both sides.



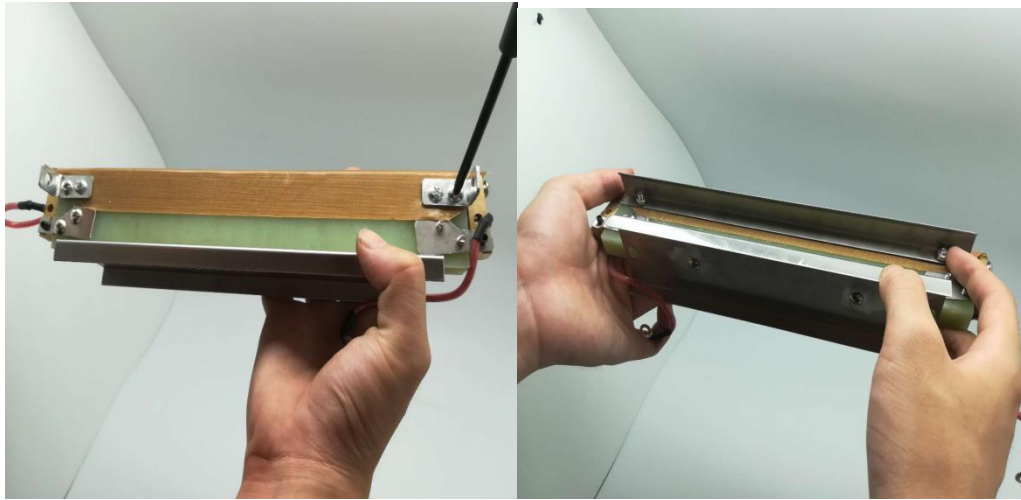
6. Use a cross screwdriver to tighten the screws, then stick Teflon tape on the heating wire.



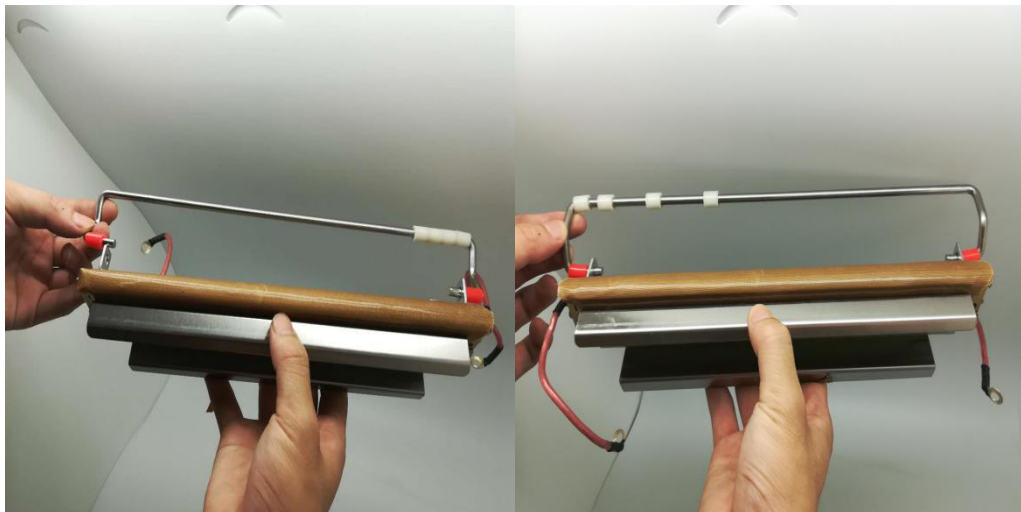
7. Cut the remaining Teflon tape on the two sides and draw 4 holes for follow-up work.

# Maintenance

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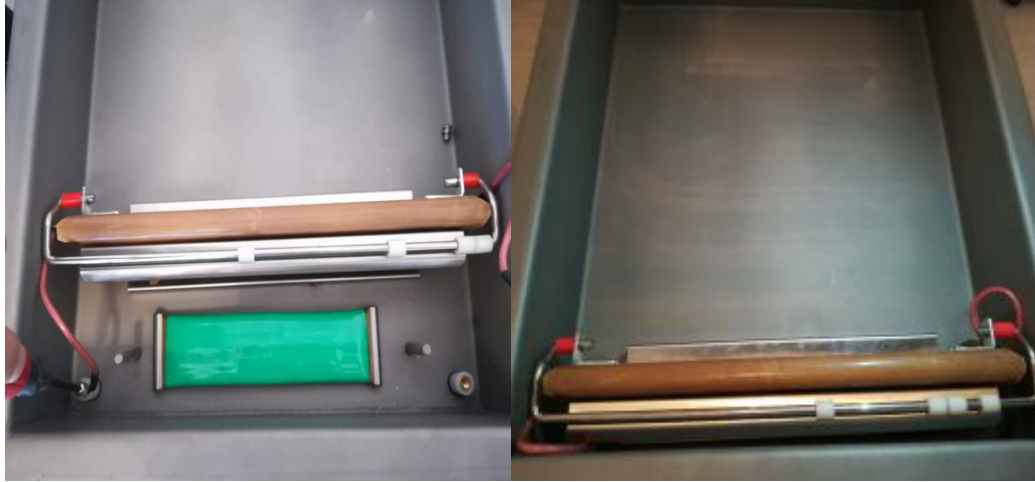
8. Use a cross screwdriver to tighten the screws to fix varnished cloth and then install the stainless-steel base.



9. Install presser bar.

# ***Maintenance***

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10. Connect the cable of complete sealing bar to the pin, then put the sealing bar back to vacuum chamber to finish the installation.

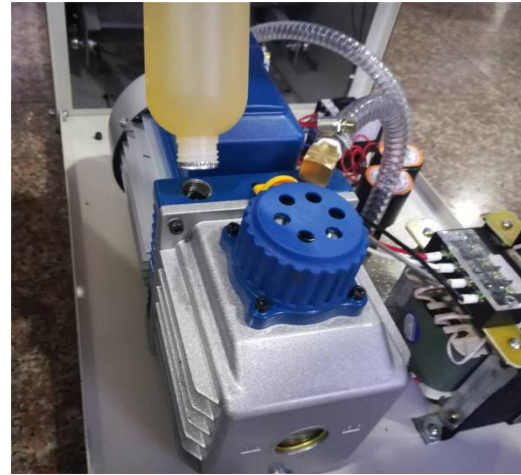


# Maintenance

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## FILLING THE OIL

Unpack front cover packaging, remove the screw under the bottom board and drain the old oil(screw it again after oil drain), remove the screw for oil filling, then fill the oil bottle(screw it again after oil filling).



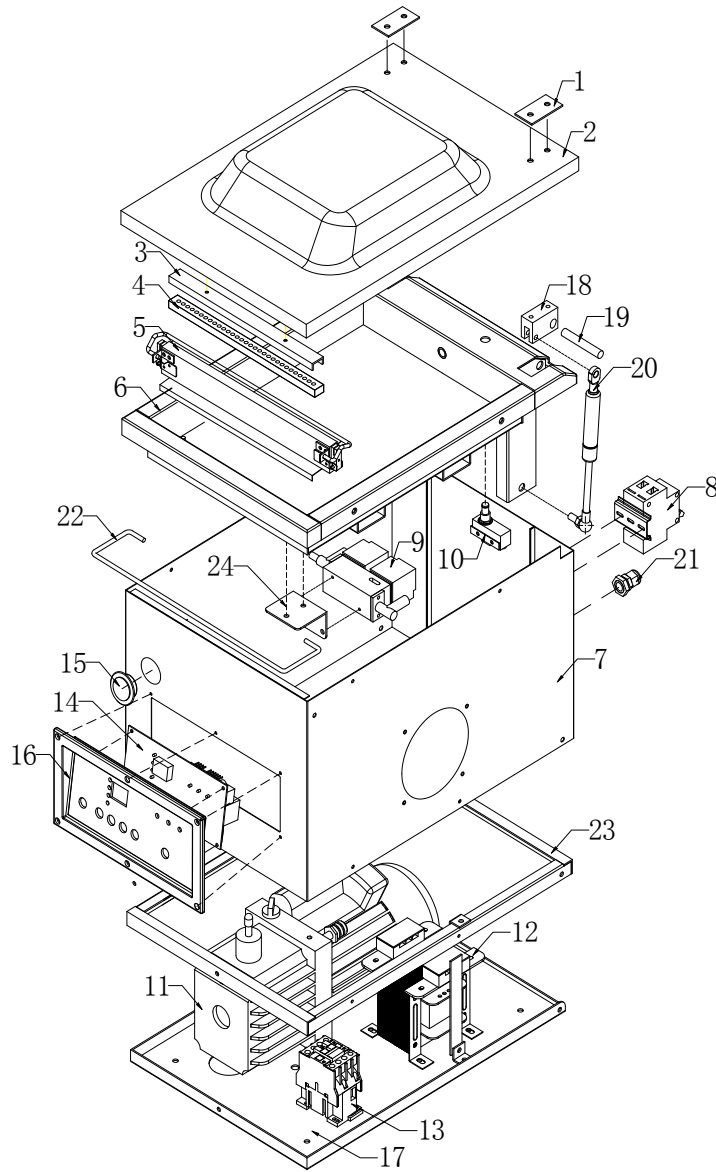
# Troubleshooting

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Problem	Possible Solutions
Vacuum pump does not work.	Limit switch is not passed on, close the machine cover and adjust the limit switch.
	Limit switch is broken, replace it.
	Contactor is broken, replace it.
	Pump motor is broke, replace it.
Vacuum chamber cannot reach the vacuum degree.	The vacuum pump is worn or damaged.
	Loose air pipe joint, broken pip, damaged sealing ring of vacuum chamber or damaged valve cause the entry of air into vacuum chamber.
	Insufficient oil in vacuum pump.
	Vacuum time is not enough.
Cover cannot be opened.	Air release valve is not turned on.
Air remains in bag after processing is finished.	Wrong position resting on seal bar.
	Pressing stick press the bag opening side cause the air cannot be sucked.
Abnormal sound or tripping when running, black smoke or oil drop	Abnormal sound of fan of pump motor, it should be repaired.
	Blockage may be seen in air intake and/or pip.
	Insufficient oil of vacuum pump or the use of non-standard oil.
	Long time running of pump or overheat running under high temperature.
	Faulty vacuum pump motor or valve of vacuum or wear and tear due to usage.

# Parts Breakdown

## HVAC265D/305D/405D exploded view

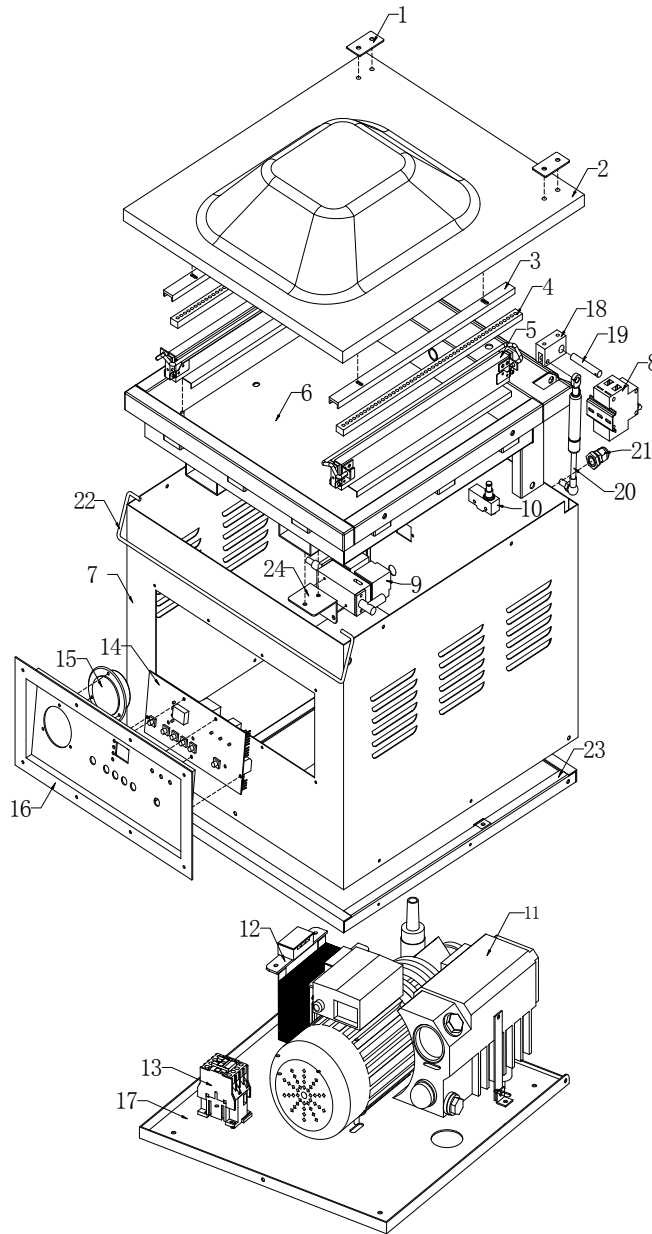


Outlook and control panel

vacuum packing machine parts list		
Number	Name	USE Quantity
1	Cover's Platen	2
2	Plexiglass cover	1
3	Silicone seat	1
4	Silicone	1
5	Heating block	1
6	Vacuum chamber	1
7	Chassis	1
8	Breaker	1
9	Solenoid valve	1
10	Micro Switch	1
11	Vacuum pump	1
12	Sealing transformer	1
13	AC contactor	1
14	Control Panel	1
15	Vacuum Meter	1
16	Panel frame	1
17	Chassis's Bottom plate	1
18	Gas spring bracket	2
19	Gas spring pin	2
20	Gas spring	2
21	Power line waterproof connector	1
22	Gland bars	1
23	Bottom side box	1
24	seatSolenoid valve seat	1

# Parts Breakdown

## HVAC405D2 and HVAC510D exploded view

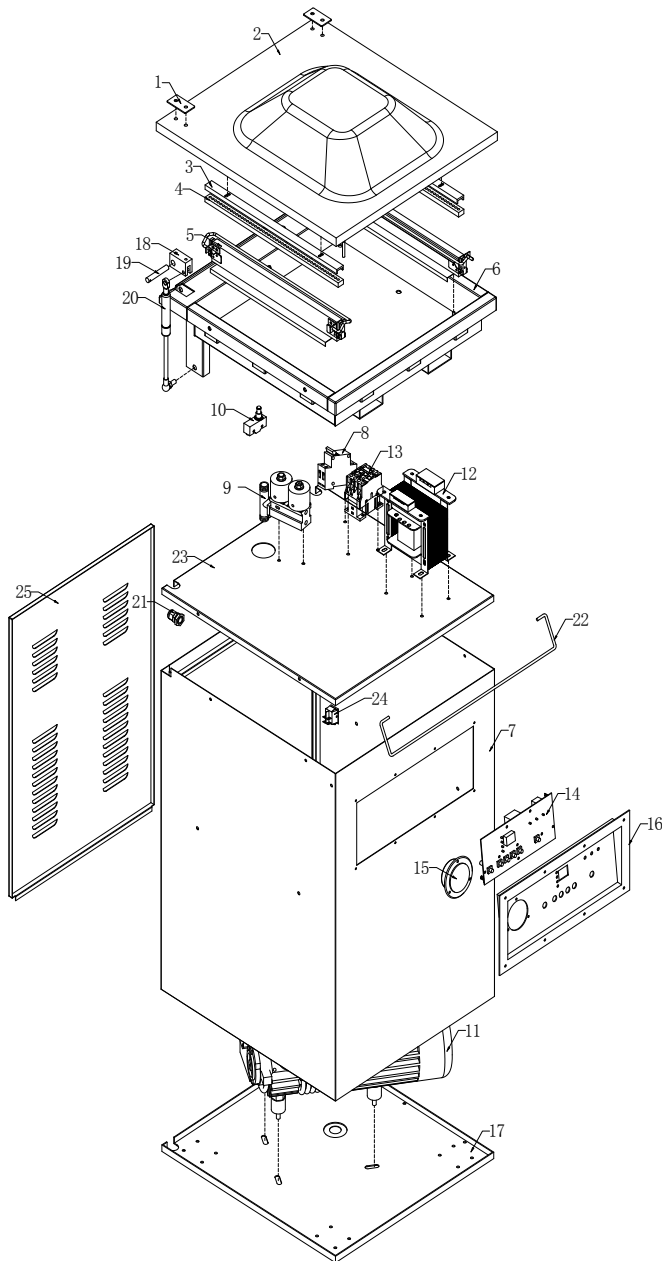


Outlook and control panel

vacuum packing machine parts list		
Number	Name	USE Quantity
1	Cover's Platen	2
2	Plexiglass cover	1
3	Silicone seat	2
4	Silicone	2
5	Heating block	2
6	Vacuum chamber	1
7	Chassis	1
8	Breaker	1
9	Solenoid valve	1
10	Micro Switch	1
11	Vacuum pump	1
12	Sealing transformer	1
13	AC contactor	1
14	Control Panel	1
15	Vacuum Meter	1
16	Panel frame	1
17	Chassis's Bottom plate	1
18	Gas spring bracket	2
19	Gas spring pin	2
20	Gas spring	2
21	Power line waterproof connector	1
22	Gland bars	1
23	Bottom side box	1
24	Solenoid valve seat	1

# Parts Breakdown

## HVAC405M and HVAC510M exploded view



Outlook and control panel

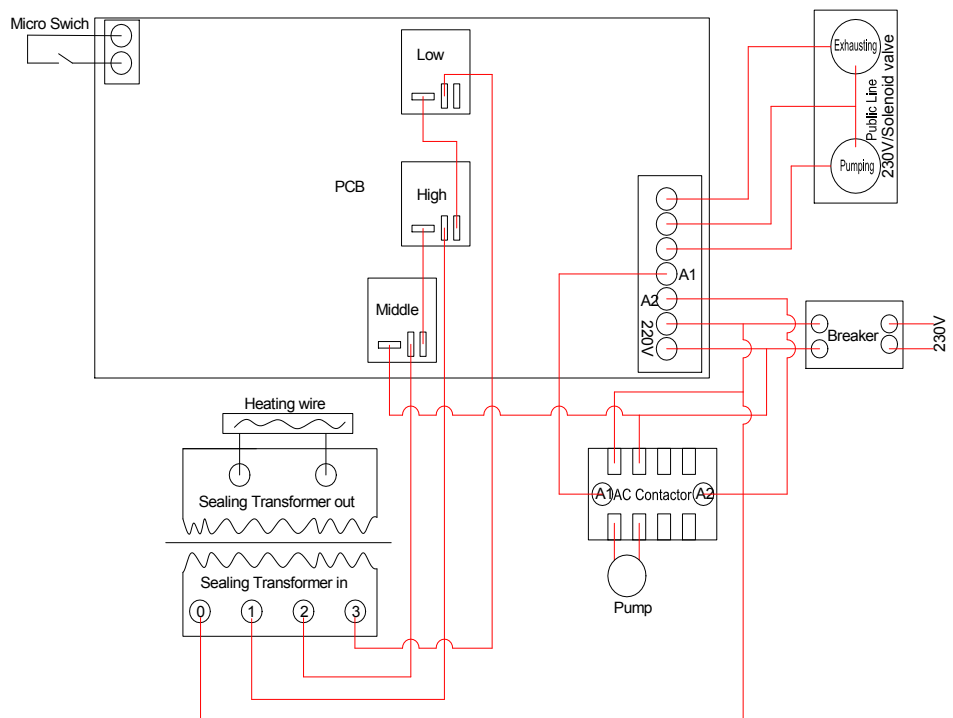
vacuum packing machine parts list

Number	Name	USE Quantity
1	Cover's Platen	2
2	Plexiglass cover	1
3	Silicone seat	2
4	Silicone	2
5	Heating block	2
6	Vacuum chamber	1
7	Chassis	1
8	Breaker	1
9	Solenoid valve	1
10	Micro Switch	1
11	Vacuum pump	1
12	Sealing transformer	1
13	AC contactor	1
14	Control Panel	1
15	Vacuum Meter	1
16	Panel frame	1
17	Chassis's Bottom plate	1
18	Gas spring bracket	2
19	Gas spring pin	2
20	Gas spring	2
21	Power line waterproof connector	1
22	Gland bars	1
23	Middle layer plate	1
24	Switch	1
25	Rear cover	1

# Electrical Schematics

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Working circuit diagram



# ***Packing list***

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<b>Items</b>	<b>Qty.</b>
Vacuum Packing Machine	1 SET
Hydraulic Oil	Small unit: 1 Bottle Big unit: 2 Bottles
Heating Wire	2 PCS
Teflon Tape	Machine of single seal bar: 1 PCS Machine of two seal bars: 2 PCS
User's Manual	1 PCS
Allen Wrench	1 PCS
Screwdriver	1 PCS
Silicone Article	1 PCS

