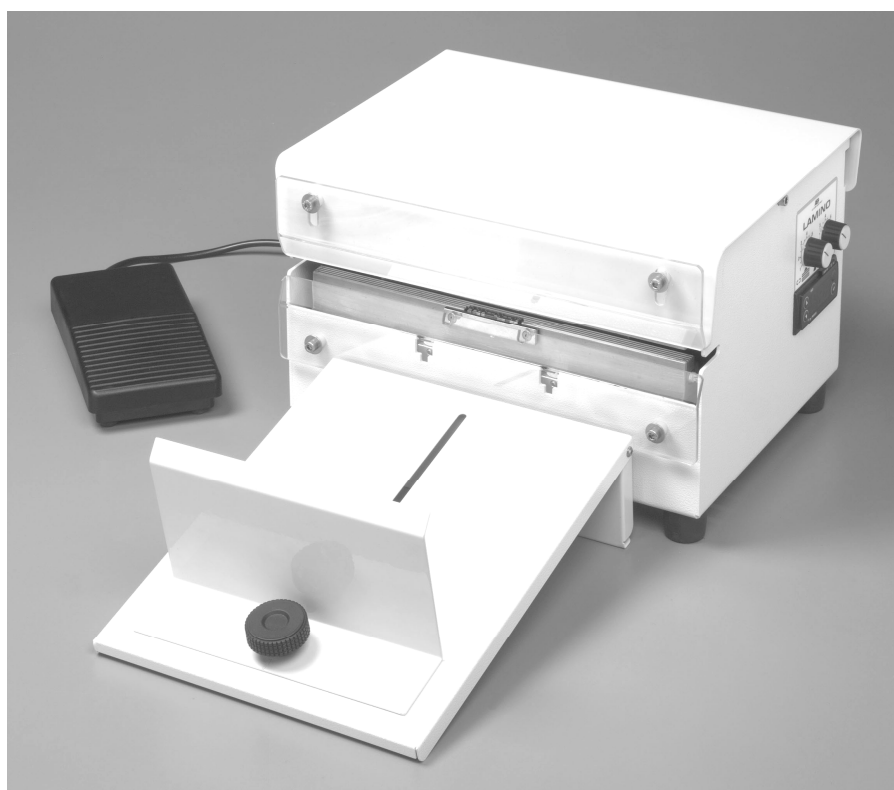


AE
AUDION ELEKTRO®

LAMINO

301 LM



MANUAL

LAMINO 301 LM ENG. Rev.03

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SYMBOLS



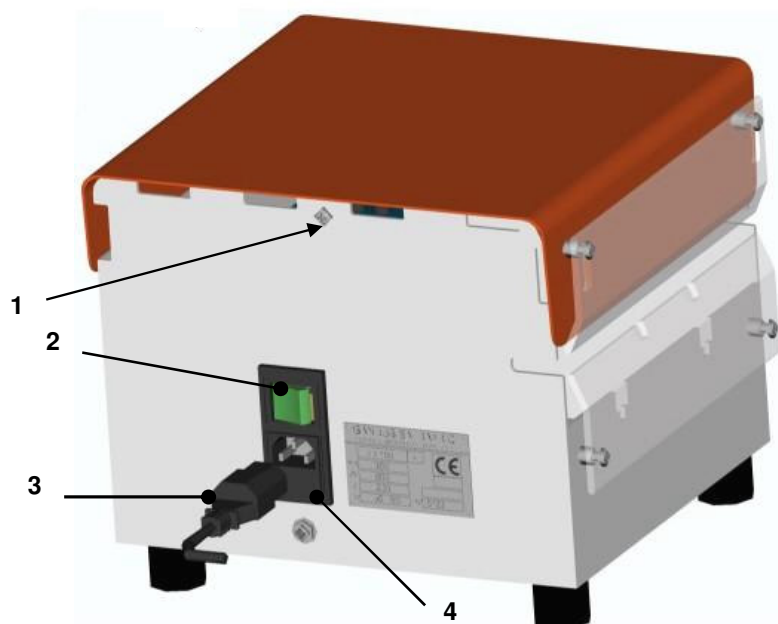
Warning meaning danger



Warning meaning particular suggestion



Warning meaning suggested maintenance



pict. a

1 General information

1.1 Use and safekeeping of the instructions manual

We thank you for the trust you put in us by buying our sealing machine Lamino.

We are sure that, following correctly the instructions in this manual, you will appreciate the quality and reliability of this product.

Would you please, then read carefully the instructions and let all the people who are going to use this machine read it as well.



WARNING

All people involved in the operation of this heat-sealer whether their task is production, maintenance or revision must read this instructions manual.

The instructions in this use and maintenance manual indicate, for this machine, the correct operations as intended in its design and technical specifications.

This booklet, provided with the heat-sealer, is to be considered part of the equipment and IT HAS TO BE SAFE KEPT FOR FUTURE NEEDS for as long as the machine is operated.

This manual must be kept always together with the heat-sealer at hand of the operator for easy consultation.

In case of loss or damage, the customer can ask for a new manual mentioning (see pict.a)

- Model.
- Serial number.
- Manufacturing date.

The manufacturer reserves the right to improve or modify its products, without updating the items issued previously or their manuals.

1.2 Expected use

The Lamino is a hot bars heat-sealer for hermetically closing bags made by CELLOPHANE – PAPER ALUMINIUM LAMINATED or other multilayered enveloped heat-sealable bags.

The machine has been fit to be used by one operator in the following ways:

- Through the foot –pedal (manual mode).
- Through automatic cycle.



WARNING

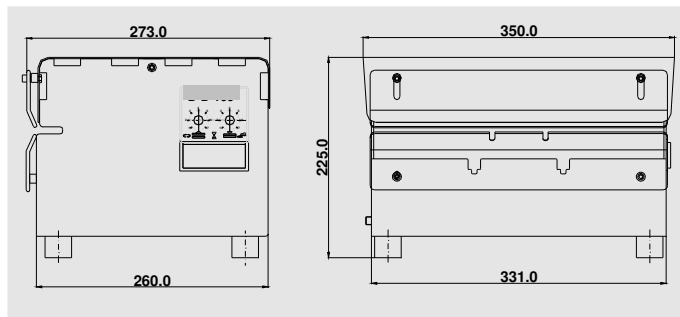
The heat-sealer has not to be employed for other uses than the one above mentioned for which the machine has been designed and built.

1.3 Technical characteristics

1.3.1 Lamino 301

As above, except:

- Max sealing length: 290 mm.
- Power absorption: 600 W.
- Dimensions without accessories (w x h x d): 350 x 225 x 273 mm (see pict. c2).
- Net weight: 15 Kg.



pict. c2

1.4 Moving and transport

We suggest to use the original packing during the transport.

We suggest to handle with care and to keep the packing machine in dry environment, following the positioning symbols.



To avoid any damage to the machine, when it is moved, is very important to keep the original packing.

Audion Elektro declines every responsibility for eventual damages occurred to the machine in case of shipments made without the original packing.

To avoid any damage when unpacking and for any other placing, bring the machine only below the basement.



WARNING

The machine could be damaged if lifted or moved using other parts such as casing, conveyors etc.

1.5 Safety rules



WARNING

THE OPERATOR MUST BE TRAINED AND HAVE FULL KNOWLEDGE OF THE CONTENTS OF THIS MANUAL.



Always unplug the power supply cable (n°3 pict. a) before any maintenance operation.



Don't operate with the heat-sealer if the safety panels are open or removed.

Here there are the most important suggestions for the safety and good maintenance of the machine:

- To guarantee good functioning, keep the machine clean.
- Before cleaning the heat-sealer, unplug the power supply cable (n° 3 pict a).
- Do not clean the heat-sealer with fluid or spray cleaners.
- Wipe the outside with a slightly moist cloth and clean the inside with compressed air.
- Never put in the sealing area anything other than the bag to seal.
- Do not introduce in any opening of the heat-sealer metallic objects, to prevent electrical shocks.
- The machine must be used only indoor and in a dampness free environment.
 - Environment temperature: 5° - 40°C.
 - Relative humidity: 30% - 95% (not condensed).
- Do not operate with the machine in environments where there are risks of fire or explosion.
- Do not use the machine in packaging of inflammable, corrosive or explosive substances or in any case with dangerous products for the operator.
- Use only original spare parts.
- We suggest to have the heat-sealer checked by a qualified technician every year.
- Do not modify the sealing parameters while the machine is working. Wait for the end the actual cycle.
- The fuses replacement must be done with new ones of the same value (current data).



BEFORE ELECTRICAL PLUGGING OF THE MACHINE, CHECK IF THE DATA OF THE IDENTIFICATION PLATE CORRESPONDS TO THE LOCAL POWER SUPPLY (pict. a).

2 Instructions for use

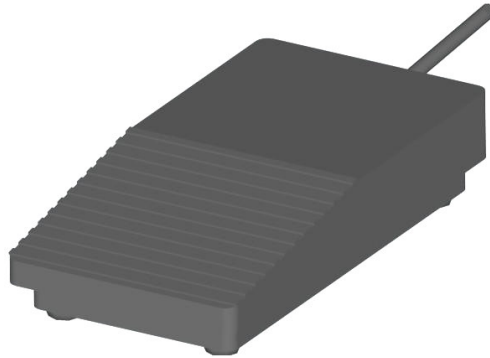
2.1 Installation

The equipment can be employed in any working environment that is dry without excessive dust.

Place the sealer on a steady work surface, leaving a large enough space in front of it for the bags to position.

Be sure, the heat sealer is at least 30 mm from the back wall in order to allow a right release of the heat produced inside and laterally it has the needed space for an easy bag infeed.

Finally, take enough space on the ground useful to act the start cycle foot pedal (see picture).



2.2 Electrical wiring

Check the main luminous switch (n°2 pict. a) is in the “O” position (OFF).

Introduce the plug (n° 3 pict. a) of the supply cable into the machine socket (n° 4 pict. a), always before connecting the supply cable into a single phase socket.

Plug the supply cable into the single phase earthed power source provided with a magneto thermal switch mounted in the circuit, in accordance to the law rules, after checking that the data on the identification plate correspond to the ones of the power net.

Plug the foot pedal JACK into the corresponding plug (n°3 pict. I) located on the side of the machine.



If the JACK plug is not connected to its socket, once switch on the machine, the automatic cycle starts.

2.3 Switching on the machine

Switch on the heat sealer through the main GREEN luminous switch (n° 2 pict. a) on position “1” (ON).

The display (n°1 pict. d) of the thermo regulator (n°2 pict. d) will light on, beginning the AUTOTEST phase that is marked out by the flashing number “1.5” (*) for a few seconds.

(*): Depending by the software release.



In case of mistake messages (see par. 3.3), don't use the machine and get in touch with Audion Elektro.

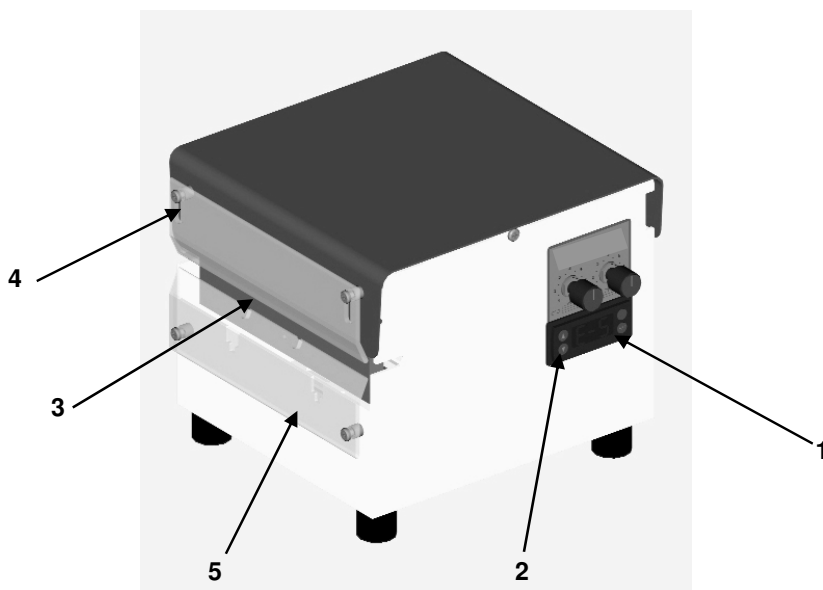
The thermo regulator display (n°1 pict. d) shows the actual temperature value of the welding jaws that are reaching the set temperature.

Set the cycle times according to the bags to be sealed (see chapter 3).

When the SET temperature will be reached, the heat sealer is ready to be used.



To get the temperature stabilization, we suggest to wait for few minutes before employing the machine.



pict. d

2.4 First employ



In order to avoid imperfect seals, the sealing area of the bags must be introduced between the jaws complete stretched.

After switching on the machine (see par. 2.3) and once reached the set welding temperature, the machine is ready to make the first seal.

Introduce the bag edge through the infeed guide (n° 3 pict d), until to meet the stop plate (n° 1 pict. e) situated on the lower sealing jaw (n° 2 pict. e).

Push the foot pedal to start the sealing set cycle.

Wait for the sealing jaws reopening before extracting the bag.



Don't employ the machine without the transparent protections (n° 4 and n° 5 pict. d) dismantled.



About the automatic machine behaviour see the chapter 3.

2.5 Switching off the machine

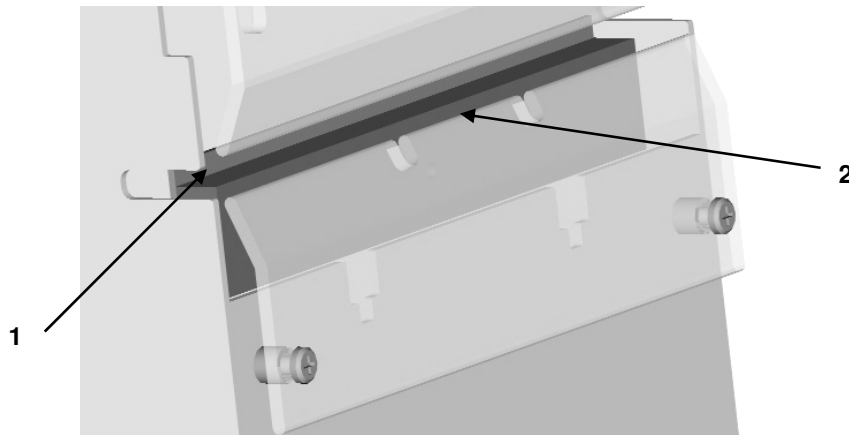
To switch off the heat sealer, switch the main GREEN luminous switch (n° 2 pict. a) on position "O" (OFF).

2.6 Emergency stop

Turning the luminous green general switch (n° 2 pict. a), the power supply and all the moving parts of the heat sealer will stop.

To restart the machine after removing the trouble, turn again the luminous green general switch on position "1" (ON).

Because the jaws temperature has decreased for the stop, wait for few minutes until it will be at the set temperature again.



pict.e

2.7 Seal with code embossing

If your Lamino is provided by coding device, on the seal of the bag will be engraved a code of alphanumeric characters, set by the operator according to the needs.

Max text lenght: n° 12 characters.

In case of code composition made by less than 12 characters, we advise you to fill completely the punch-seat with others code-punches upside-down (flat side of the punch).

2.7.1 Code composition



Execute the following operations always with the machine OFF and the power supply cable disconnected from the power source.

Be sure the sealing jaws are at the ambience temperature.

- a) Loosen the frontal screws (n° 2 pict. e2) of the upper protection (n° 4 pict .d).
- b) Lift the upper protection (n° 4 pict.d) until to get free the inlet slit (n° 3 pict. d).
- c) Loosen the block screws (n° 3 pict. e2) of the plate (n° 1 pict. e2) blocking the code-punches (n°1 pict. e1).
- d) Using the tweezers (n° 2 pict. e1), supplied with the machine, extract the code-punches to be replaced with the new ones.

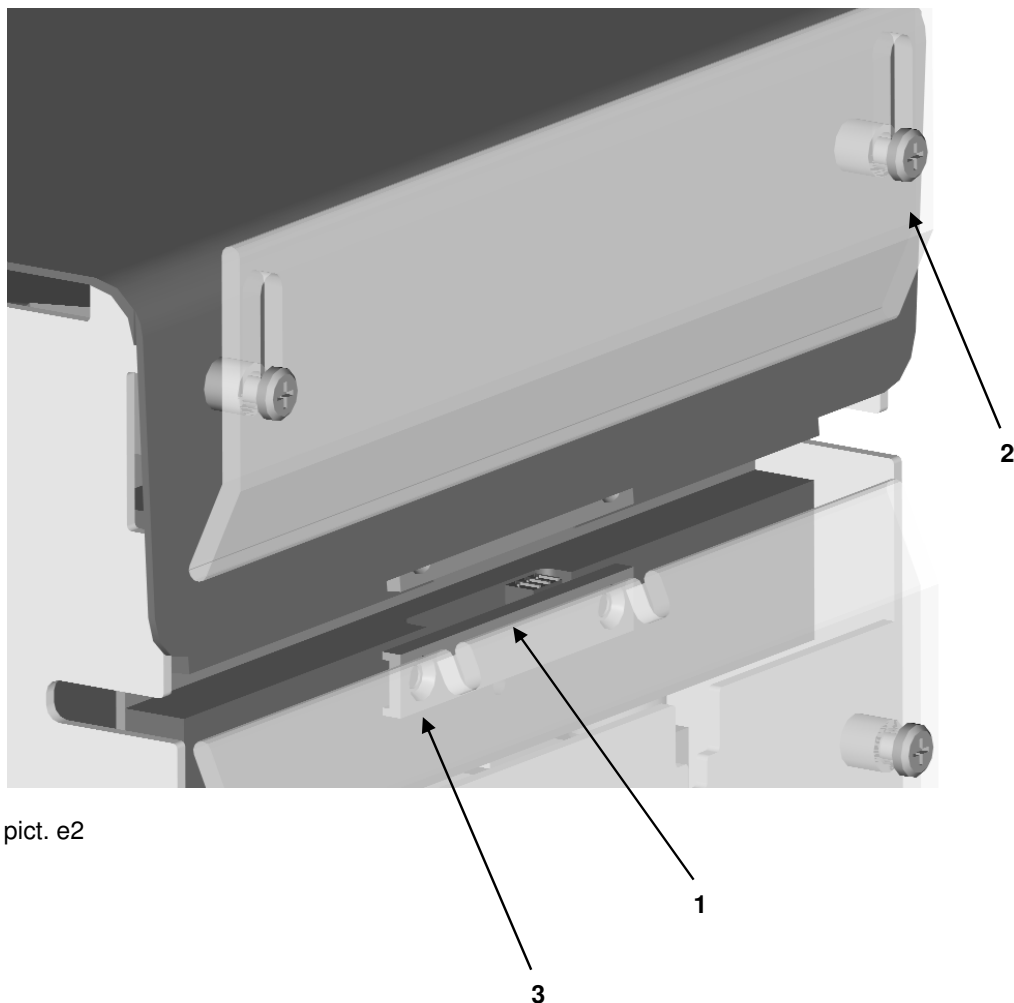
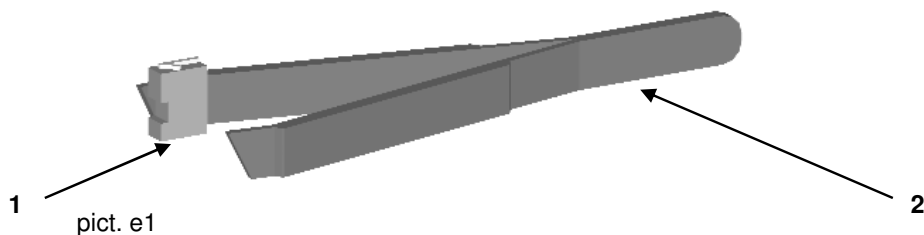


To make easier the new codes composition, we suggest to replace only one punch at the time, leaving the other ones in the punch-seat.

- e) When the new composition is done, close manually the upper jaw to get punches bedding in their seat, than tighten lightly the two screws (n° 3 pict e2) of the blocking code-punches plate (n°1 pict. e2).
- f) Put the upper protection (n°4 pict. d) in the original position and fix it tightening the screws (n° 2 pict. e2).



Employ always the machine with the upper protection completely down and fixed by its blocking screws (n° 2 pict. e2).



3 Control panel

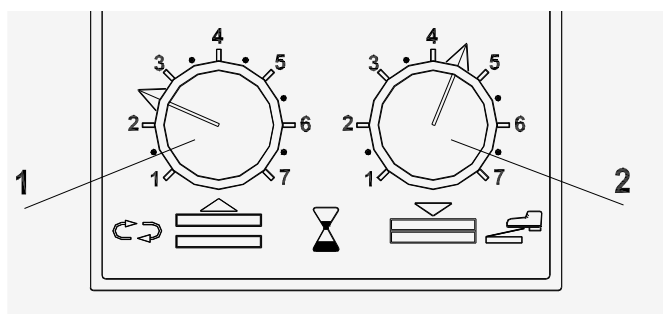
In this section, will be described the panel commands which can be done by the operator to manage the working adjustments and the desired machine configuration.

The control panel is consisting by two principal parts:

- a) Command setting of the cycle time (see pict. f).
- b) Command setting of the sealing temperature (see pict. g).

3.1 Cycle time setting

3.1.1 Symbols



pict. f



: Closing jaws duration time **0 – 6 ± 1 sec.**



: Sealing cycle pause **0 - 9 ± 1 sec.**

3.1.2 Operative cycle time setting

Referring to the picture f, we have:

Closing jaws duration: turn the knob n° 2 pict. F.

Sealing cycle pause: turn the knob n° 1 pict. f (active only in automatic mode: see chapter 3.4).



Keeping the same setting, the duration of the first sealing cycle pause can be longer about 4 sec. than the next cycle pause.

3.2 Sealing temperature setting



pict . g

3.2.1 Keys symbols

- function keys



- new set value confirmation
- visualization switching set temp. /actual temp.



- thermo regulator hide functions access.



the key is normally deactivated : to set on see par. 4.6.3.1

- setting keys



and temperature value increasing / decreasing keys

3.2.2 sealing temperature setting

To set or modify the sealing SET temperature, do as follows :

- press the key : the display shows the actual value of the sealing set temperature.

- Through the keys , set the new value

- about 2 seconds after, the display come back to visualize the actual temperature value.



WE SUGGEST, ON EVERY NEW TEMPERATURE SETTING, TO WAIT FOR A FEW BEFORE EMPLOYING THE MACHINE AGAIN. THIS PROCEDURE ALLOWS TO STABILIZE QUICKLY THE ACTUAL TEMPERATURE TO THE NEW SET ONE.

3.2.3 Set temperature visualization

To visualize the SET sealing temperature without modifications, press the key.

About 2 seconds after, the display come back to visualize the bars actual temperature.

3.2.4 Errors warning list (heating control)

In case of heating behavior failure, the alarm system activates flashing visualizations on the display (see pict. h), stopping in the meantime the thermo regulator.



Suspend immediately the sealing operations

(if the machine is working in automatic mode, the sealing jaws are executing the sealing cycle, yet)

Switch off the machine and try to solve following the help list below.



pict. h

3.2.5 alarm message list

N° ERROR	CAUSE	ACTION
E-1	EEPROM failure	contact AUDION Service Dept.
E-2	a) cool join failure b) machine temperature overheating due environmental temp.	a) replace the thermo regulator b) place the machine in an ambient where the temperature corresponds to the par. 1.4 characteristic
E-4	EEPROM wrong parameters	do new software configuration replace the thermoreg. if new data lost occurs
E-5	a) temp. probe on failure b) temp. probe disconnected	a) replace with new one b) check the probe electrical wires connection or the probe mechanical fitting in the jaws

3.3 Automatic mode

The automatic behavior allows the operator to worry only about the fitting in the sealing jaws of the bag without acting the machine at every new bags insertion.

To use the machine in automatic mode, do as follows:

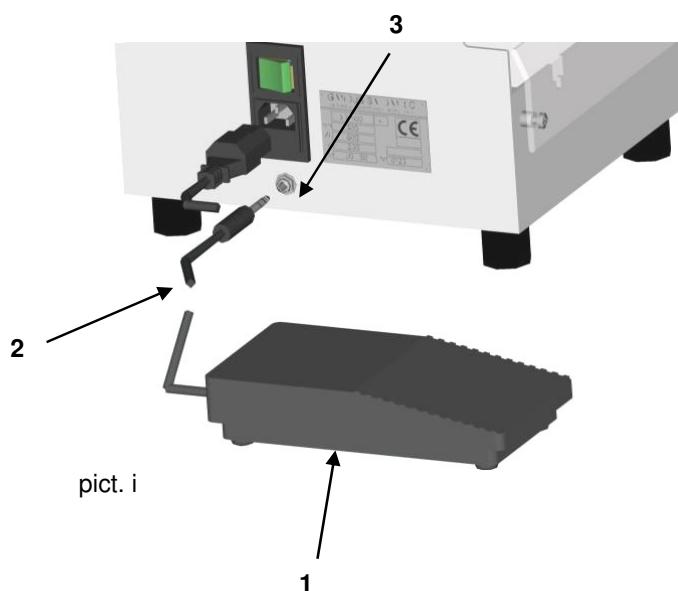
- a) Disconnect the JACK plug (n°2 pict .i) of the foot pedal (n°1 pict i) from the corresponding socket (n°3 pict. i) situated on the machine side.
- b) Set the closing jaws time (see chapter 3.1.2) suitable to the bag to be sealed.
- c) Set the sealing temperature (see chapter 3.2.2) suitable to the bag to be sealed.
- d) Set the sealing cycle pause (see chapter 3.1.2) suitable to the required production.



Keeping the same setting, the duration of the first sealing cycle pause can be longer about 4 sec. than the next cycle pause.

Carry out some samples to evaluate the chosen setting times.

To come back to the manual mode, insert the foot-pedal JACK plug into the socket.



4 Maintenance



THE HEAT-SEALER MAINTENANCE MUST BE EXECUTED BY QUALIFIED PERSONNEL ONLY, OPPORTUNELY TRAINED AND WITH A GOOD KNOWLEDGE OF THE INSTRUCTIONS IN THIS MANUAL.



Before any intervention, stop the machine and unplug it from the main power supply.

4.1 Cover machine opening

4.1.1 Cover

- Unscrew the two screws (n°1 pict. a) in the side.
- Take away the cover.

4.1.2 Front protection

a) Upper protection (n° 4 pict. d):



Generally is useless dismantling the upper protection to access inside the machine.

- Loosen the two front screws.
- Lift the protection.

b) Lower protection (n° 5 pict. d):

- Unscrew the two front screws.
- Take away the protection.

4.2 Main preventive maintenance rules

4.2.1 Sealing jaws



Check periodically the jaw is cleaned of product or bag rests.

On the contrary, clean the teeth with a soft rag helping you with a small plastic or wood stick, carrying out the cleaning with movement along the teeth direction.

If there are plastic rests, carry out the cleaning with the jaws warm, protecting your hand by suitable gloves.



Do not carry out the teeth cleaning using metallic devices, that could damage the jaws teeth.

4.3 Thermoelectric protections

The heat-sealer Lamino is provided with thermoelectric protections that avoid dangerous overheating:

4.3.1 Thermal protection by thermofuse

That intervenes in case of thermo regulator failure. Its function will avoid the machine overheating risk, stopping the heat and jaws behavior.



For the aim of the safety, before replacing the thermofuse, establish the reason of its intervention. In this case do not employ the machine and advice Audion Elektro.



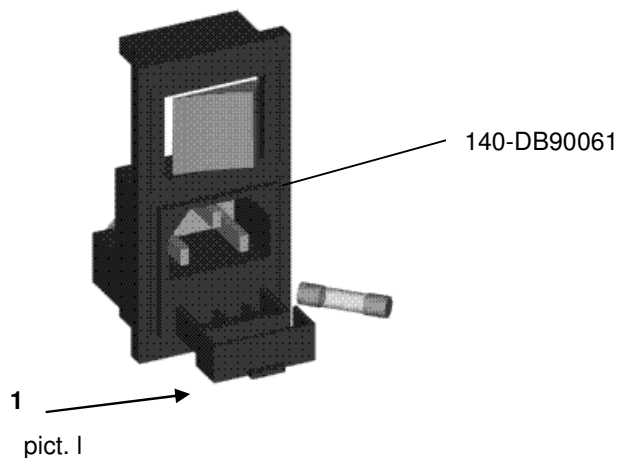
To start the machine again, it is necessary to replace the thermofuse with another one of the same kind.

4.3.2 Thermal protection by probe

That intervenes in case of cooling fan failure or if the machine is located in working place with too high temperature (chapter 3.3).

4.4 Line fuses replacement

- Fuse: 5 x 20 3.15 AF
- Quantity: 2



- Open the fuse-box (n° 1 pict. I).
- Extract the twice fuses to be replaced eventually using a suitable small screwdriver.
- Insert the new fuses and close the fuse-box pushing it to the bottom.

4.5 Temperature jaws probe replacement

PROBE MODEL: thermocouple J 142-13020.



The temperature jaws probe does not need any maintenance.

4.5.1 Probe access

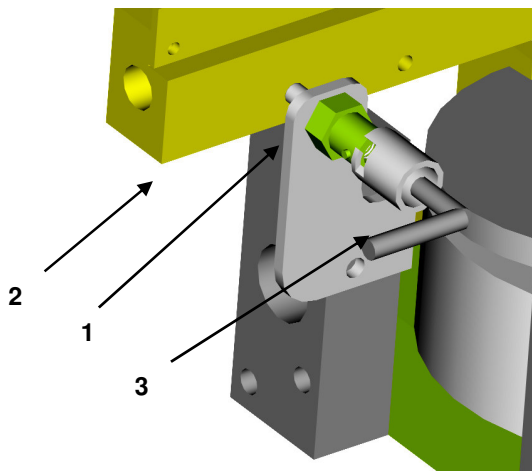
- Open the heat-sealer following the instructions 4.1.1, then locate the probe (n°1 pict. m) placed on the lower jaw (n°2 pict. m).

4.5.2 Replacement

- Disengage the probe connection turning the block metal ring (n°3 pict. m).
- Disconnect the probe cable from the thermo regulator (n°1 pict. o) must be pulled out the machine frame following the arrow direction as shown in the picture o. To proceed with the thermo regulator extraction, press the twice tongues located both on one side of the thermo regulator.
- Unthread the probe sensitive terminal (n°1 pict m) from the lower jaw (n°2 pict .m).
- Unthread the cable from the metal ring and pull the probe out the machine.
- Replace with a new one.



During the new probe fitting up strew its sensitive terminal with conductor paste.



pict. m

4.6 Heating elements replacement

HEATING ELEMENTS TYPE: cartridge; Power: 0.25 Kw l = 250 mm (Lamino 301) 309-09009



The heating elements are connected in series mode (see electrical diagram).

4.6.1 Heating elements access

- Open the heat-sealer following the instructions 4.1.1 and 4.1.2 b, then locate the heating elements placed both inside sealing jaws (n° 2 e 3 pict. o).
- Unhook the disk/electromagnet connection screw (n°1 pict. n) and turn back the mobile plate (n°2 pict. n).
- Loosen the lower jaw block screws (n°4 pict. n).

4.6.2 Heating elements replacement

- Follow the instruction 4.5.2.
- Disconnect the thermofuse cables (n° 7 pict. n) located in the lower jaw.
- Disconnect the four heating element cable terminals from the main electronic board (n° 4 pict. o) as shown in the electrical diagram.
- Loosen the heating elem. block screws (n° 5 pict. n) and (n° 6 pict. n).
- Unthread the upper heating element out the upper jaw.
- Pull the lower jaw + heating element group out the machine.
- Fit the new heating elements in the jaws checking each heating element is completely held in its jaw seat.



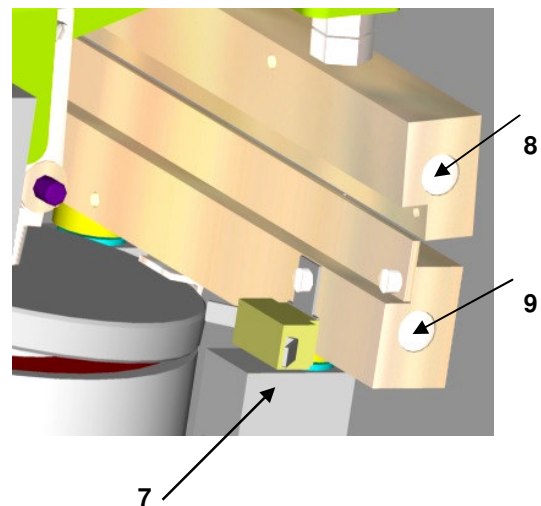
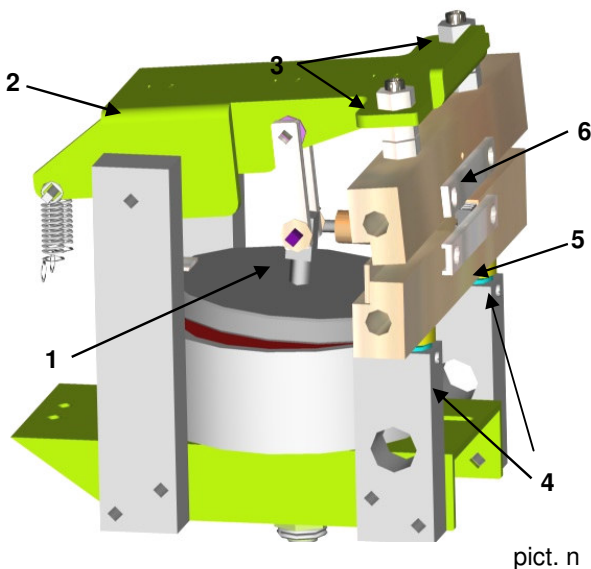
Do not loosen for any reason the adjustment nuts (n° 3 pict. n).



When the remounting is done, verify that the upper heating element cables allow a free mobile plate rotation (n°2 pict. n).



Be sure to have reconnected the protection thermofuse cables.



4.6.3 Thermoregulator calibration

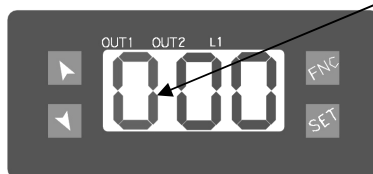
Every time the heating elements are replaced, it will be necessary to calibrate the thermo regulator through the *autotuning* procedure, that it allows its fitting to the electric characteristics of the new heating elements.



The thermo regulator calibration must be done with the sealing bars at the environmental temperature

4.6.3.1 password setting

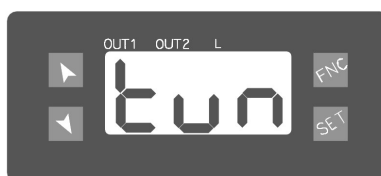
- press the  for 5 sec. the display visualizes 0 0 0 and the first left 0 will flash :



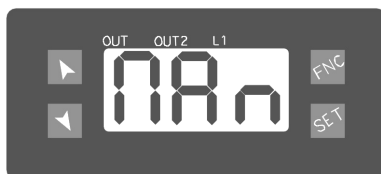
- press the key  setting the value 1
- press the key  : now the middle zero flashes
- press the key  setting the value 2
- press the key  : now the right zero flashes
- press the key  setting the value 3

4.6.3.2 AUTOTUNING function activation

Once the password is done, reach the TUN function through the key  :



- press the key  and the key  setting the MAN function :



- press the key  to exit from the menu.

4.6.3.3 AUTOTUNING start

- set up the SET temp. to an temperature close to the normal work temperature.
- press the key  visualizing :



- press the key  to start the AUTOTUNING : the display visualizes :



pict. n1



now the display will alternate the actual temp. value with the pict. n1 visualization.

According to the environmental temperature and the SET value, the automatic autotuning procedure could spend several minutes to its conclusion.

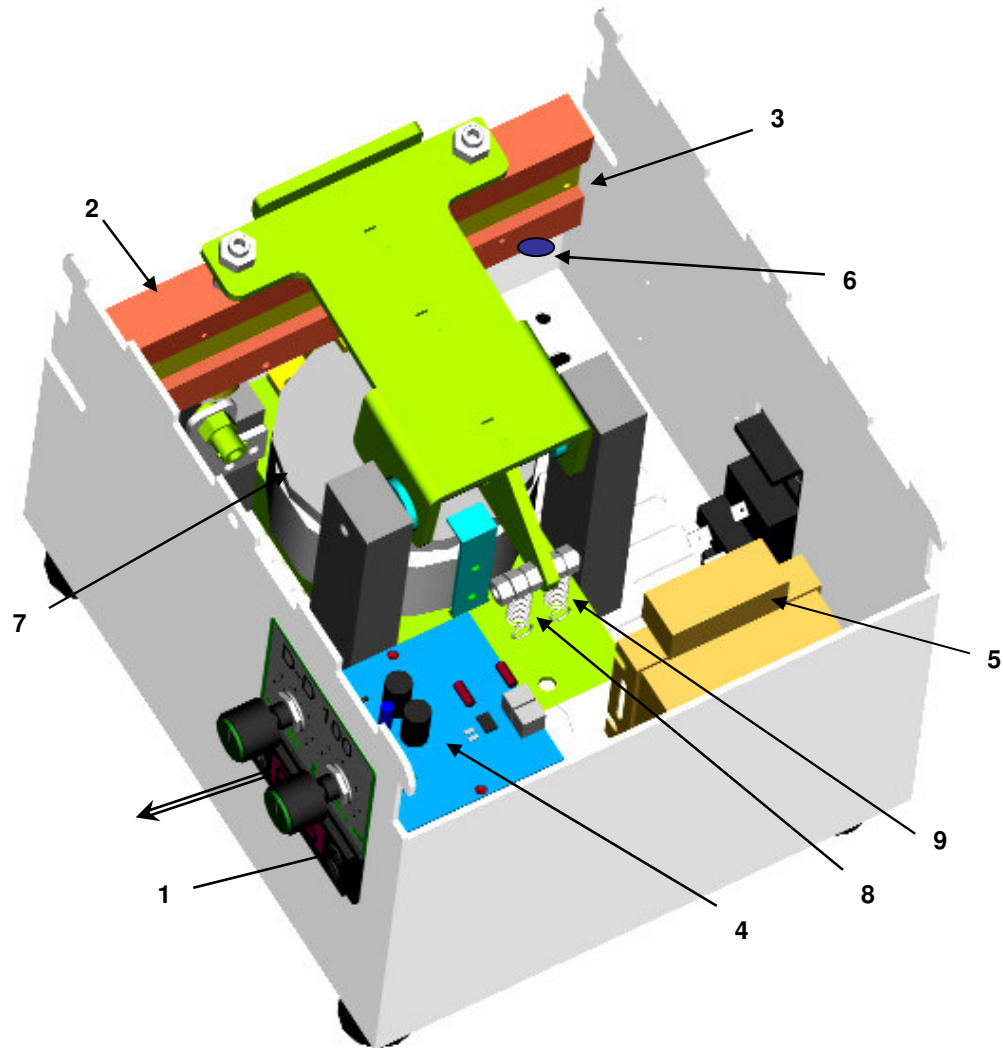
The AUTOTUNING will be complete when the actual temp. value will not alternate with the pict. n1 visualization.

4.6.3.4 autotuning deactivating

We advise to deactivate the AUTUNING function following the instructions of the par. 4.6.3.1 and 4.6.3.2 setting OFF instead of MAN (pict. n2).



pict. n2



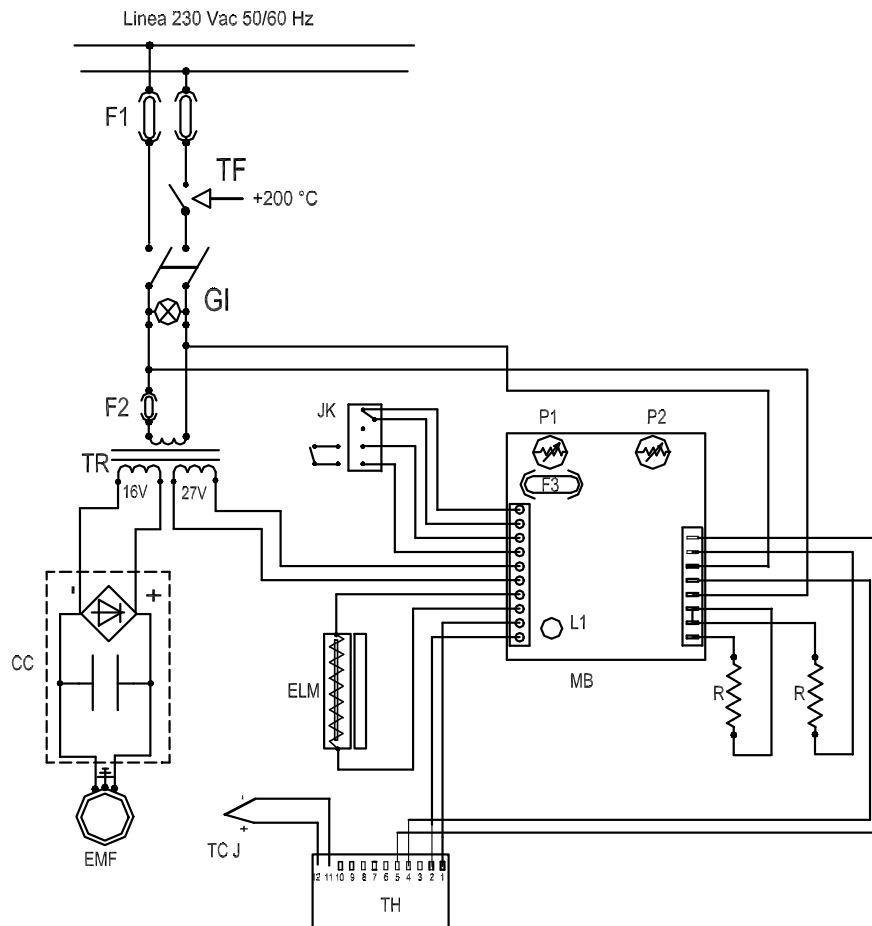
pict. o

1: Digital thermo regulator	309-27008
2: Upper sealing jaw	309-09011 (pair) (309-09009 heating element)
3: Lower sealing jaw	
4: Main electronic board	309-28001 (including potentiometers)
5: Transformer	309-90062
6: Safety thermo fuse	309-09010
7: Electromagnet	141-DB28010
8: Pre-opening spring	309-90028
9: Opening spring	309-90070

5 Recommended spare parts

ARTICLE NUMBER	NAME	PER MACHINE
142-13020	Thermo couple J	1
309-FUSE 1	Fuses 3.15A (20x5)	2
309-90005	Coding device 301 LM	1

6 Electrical diagram



CC	Fan rectifier Vac/Vcc	309-DB09004
ELM	Electromagnet	
EMF	Fan electric motor	309-09012
F1	Fuse 3.15 AF	309-FUSE1
F2	Transformer fuse T yyy mA (*)	309-FUSE2 400mA
		309-FUSE4 630 mAA
		309-FUSE3
F3	Fuse 4 AT	
GI	Main switch	
JK	Foot pedal jack	
L1	Heating control led	
MB	Main board	
P1	Sealing time potentiometer	
P2	Automatic mode potentiometer	
R	Heating element 110 Vac, zzz w (*)	
TCJ	Temperature probe J	
TF	Thermofuse 200 °C	
TH	Digital thermo regulator	
TR	Transformer 230 / 16 - 27 Vac, xxx VA (*)	

(*): xxx = 100 → Lamino 301
 yyy = 630 → Lamino 301
 zzz = 250 → Lamino 301

7 Problems & solutions

In this section you will find possible first solutions to solve eventual problems that can occur during the normal use of the heat-sealer.

In spite of the following indications you will not solve the failure, we suggest to contact the dealer or Audion Elektro.

7.1 Electric circuit

- **The heat-sealer does not work and the main luminous switch (n°2 pict. a) is off.**
 - a) The line fuses (n°4 pict. a) are burnt: replace with other ones of the same type and class (chapter 4.4).
 - b) The power cord (n°3 pict. a) is not connected or interrupted: connect it again or replace it.
 - c) The protection thermofuse (n°6 pict. k) has interrupted the power supply. In this case stop the machine and see the chapter 4.3.
- **The heat-sealer does not work and the main luminous switch (n°2 pict. a) is on.**
 - a) Check the terminal boards connections on the general electronic board (n°4 pict. o).
 - b) Check the fuse F2 (see electric diagram) of the transformer.



In spite of the fuses replacement, they burn again, please get in touch with Audion Elektro because there could be a short circuit in the on board machine electrical plant.

7.2 Sealing

- **The seal has some defects along side the edges:**
 - a) Verify the current set temperature is suitable to the particular bag.
 - b) Wait for the temperature stabilization of the sealing jaws above all has done a new temperature setting.
 - c) Follow the chapter 4.2 indications.
- **The seal, even if done at the correct temperature, is not strong:**
 - a) Follow the indications of the chapter 4.2.
 - b) The load force disk (n°7 pict. o) is not correctly adjusted. Please get in touch with Audion Elektro.
- **The sealing jaws temperature does not increase:**
 - a) Verify that the green led on the command board is on (L1 electrical diagram):
 - L1 light on :→ one or both heating elements are interrupted (chapter 4.5).
 - L1 light off :→ electronic board failure: get in touch with Audion Elektro.
 - b) Look out eventual alarm warning on the thermo regulator display.

7.3 Alarm messages

In case of alarm visualization on the machine display, see the chapter 3.3 and follow the indications according to the different alarms.

8 Discard the machine

In accordance with the directive 2002/96/CE, the logo below indicates that the equipment concerned is not to be disposed of as ordinary waste at the end of its useable life.

The equipment is to be delivered to a suitable depot that will dispose of the equipment in a proper way in accordance with the legislation on this subject, or to the supplier of new equipment in case of replacement.

The owner of the equipment is responsible for proper disposal of the equipment.

For further information we advise you to contact your local waste facility.



Appropriate disposal of Waste of Electric and Electronic Equipment prevents unnecessary pollution of the environment and negative influence on general health.

9 Conditions of guarantee

9.1 Liability

1. We exclude any liability as far as it has not been arranged by law.
2. Our liability will never exceed the amount of order.
3. Subject to the general valid regulations of the law, we are not obliged to any compensation of damage of which kind ever, directly or indirectly, under which company damage, to movables and immovables or to persons, both to the opposite party as to third persons.
4. In no way we are liable for damage arisen from or caused by the supplied or by the unsuitability of this for the purpose for which the opposite party has purchased the machine.

9.2 Guarantee

1. With due observance of the restrictions stated hereafter, we allow 12 months of guarantee to the products supplied by us. This guarantee is restricted to the occurring manufacture errors and does not imply interruptions caused by any form of wear spare parts subject to use.
2. To spare parts or enclosures obtained from third persons we do not give longer guarantee than this third supplier does.
3. Guarantee expires if the opposite party and/or third parties associated make improper use of the supplied.
4. Guarantee also expires if the opposite party and/or third parties associated execute activities and/or modifications to the supplied.
5. In case we replace spare parts to fulfill our guarantee engagement, the spare parts replaced become property of AUDION ELEKTRO B.V.
6. In case the opposite party does not come up completely, partially or does not come up in time to the obligations arisen from the closed engagement between the parties, we are not obliged to guarantee as long as the situation continues.





EC-DECLARATION OF CONFORMITY

AUDION ELEKTRO B.V., located at the Hogeweyselaan 235 in Weesp,
The Netherlands

herewith declares that the

LAMINO SEALER

Type: 301 LM-2

- is in conformity with the provisions of the following EEC directives:
73/23/EEC Low Voltage Directive
89/336/EEC EMC-Directive
98/37/EEC Machinery Directive
- and that the following (parts/clauses of) harmonized standards have
been applied:
EN-ISO 12100-1/2; EN 294; EN 60204-1; EN 55014-1/2;
EN 61000-3-2/3

Weesp, April '09

A.Fitoussi
Director



CD 051F1002: 03

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