



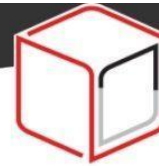
# STEP-450AI Automatic Impulse Sealer (Operation Manual)



CE

49160450 Manual UK 071122  
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## **COMPANY INTRODUCTION**

"We believe packaging solutions for our customers should be simple, easy to use, ergonomic and sustainable.

We offer a wide range of packaging products and solutions, and web design and engineer production lines specifically built to your needs.

Our motto is simple: Sal-Tech Easy Packaging makes your life simpler through engineering and good design, and your job less stressful. We Keep Things Together."

**Gunnar Salbæk**  
Owner/CEO

## **About Sal-Tech Easy Packaging**

Sal-Tech Easy Packaging offers a wide range of solutions for simple and reliable packaging of your products.

If it is a standard or a special solution that's needed for your assignment, we have a creative input to solve your needs, securing you an up-to-date packaging application.

Sal-Tech Easy Packaging is 100% owned by Gunnar Salbæk,

CVR no.: DK18429098 Salbæk Easy Packaging v/Gunnar Bjørn Salbæk.

Our team works together on a 100% virtual platform and therefore please forward all correspondence to [support@sal-tech.com](mailto:support@sal-tech.com).

Bank connection: Nordea Denmark.





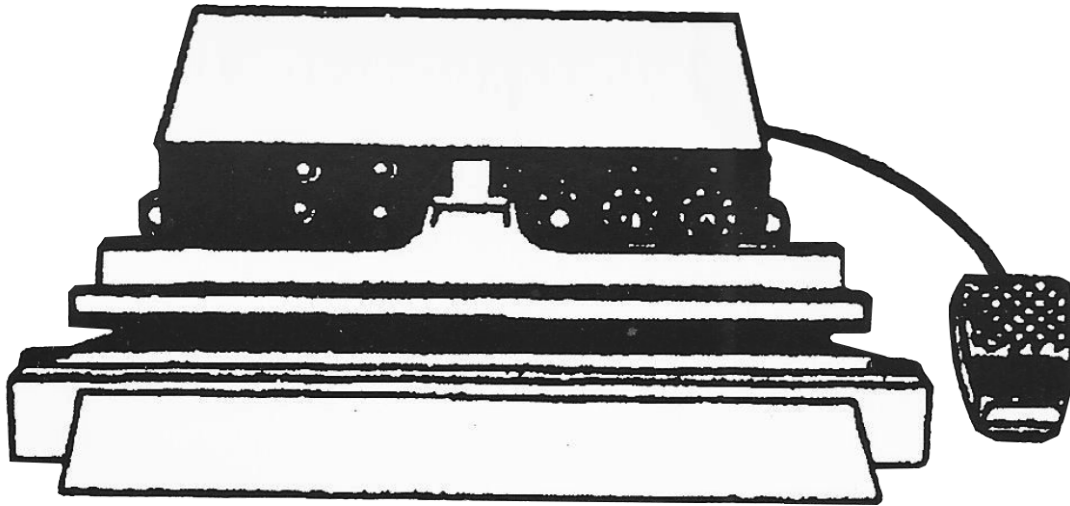
## Table of Content

|       |  |   |
|-------|--|---|
| I.    | Instruction                            | 4 |
| II.   | Operation                              | 5 |
| III.  | Specifications                         | 5 |
| IV.   | Construction Diagram                   | 6 |
| V.    | Parts List                             | 7 |
| VI.   | Connection Diagram                     | 8 |
| VII.  | Additional Information                 | 8 |
| VIII. | Spare Parts                            | 9 |
| IX.   | Methods of Exchanging Subsidiary Parts | 9 |





## I. INSTRUCTION



1. Power Indicating Lamp (YELLOW)
2. Power Main Switch
3. AUTO-Action Lamp (WHITE)
4. AUTO-MAN Action Selector
5. Re-Cycle Indicating Lamp (YELLOW)
6. Re-Cycle Timer Control Knob
7. Congealing Indicating Lamp (RED)
8. Congealing Timer Control Knob
9. Sealing Indicating Lamp (RED)
10. Sealing Timer Control Knob
11. Foot Pedal Switch
12. Fuse





## II. OPERATION

1. Set power main switch to ON position.
2. Set selector to MAN position for manual operation by pressing the foot pedal switch, or set selector to AUTO position for automatic operation.
3. Adjust the re-cycle time knob, appropriate to the frequency of continuous work.
4. Adjust the sealing time (heating time) knob, appropriate to the ness of the plastic bag.
5. Adjust the congealing time (pressing time) knob, appropriate to the thichbeauty of seal (to be cooled).

\*Sealing and Congealing time are according to the material and thickness of the plastic bags.  
Re-cycle time is according to the working speed of the operator.

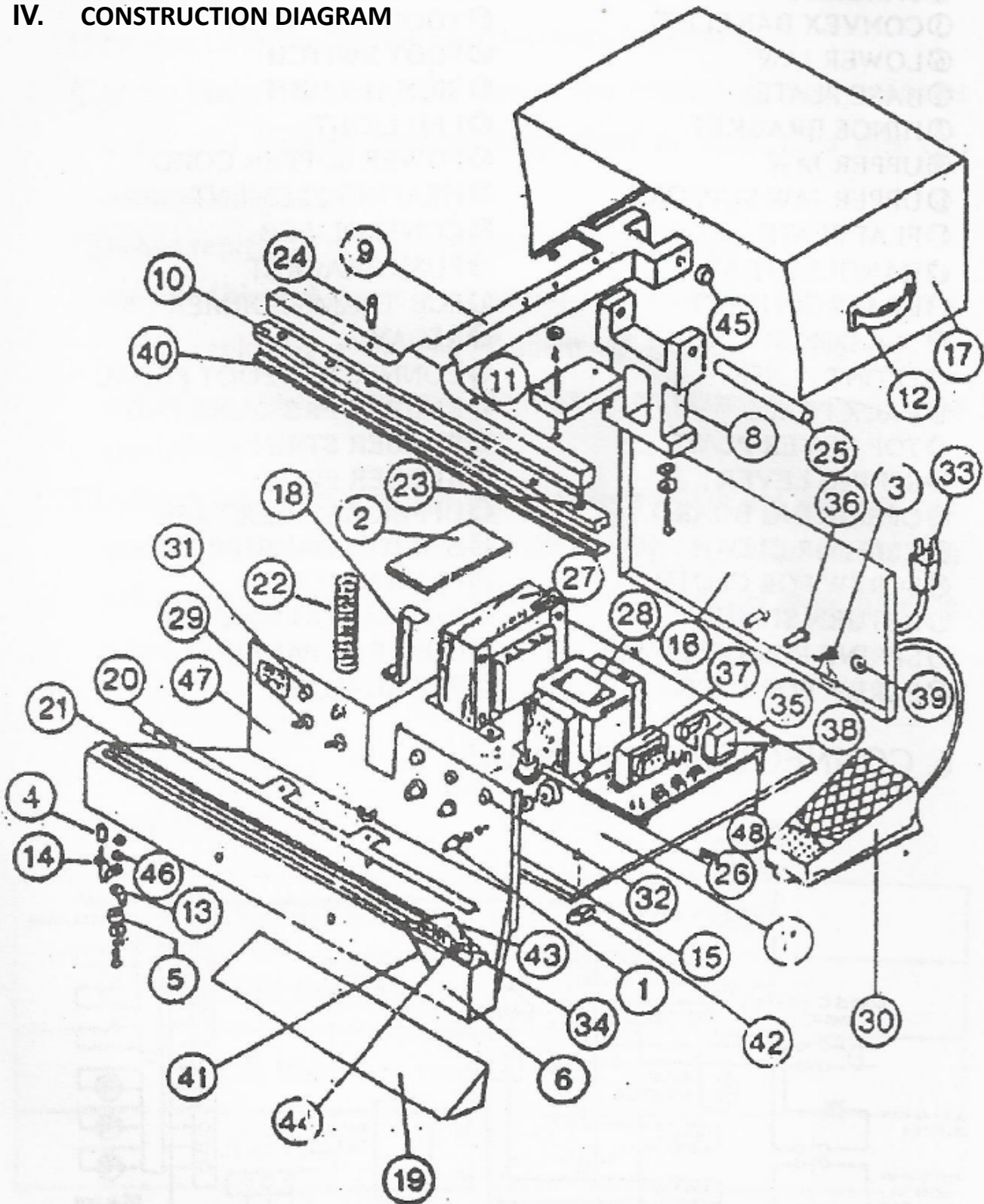
## III. SPECIFICATIONS

|                     |                                     |
|---------------------|-------------------------------------|
| Model               | STEP-450AI Automatic Impulse Sealer |
| Item Number         | 49160450                            |
| Impulse Power       | 1300W                               |
| Max.Seal Length     | 600mm                               |
| Seal Width          | 10mm                                |
| Max. Seal Thickness | 1.0mm                               |
| Heat Time           | 0.2~3.0(sec.)                       |
| Congealed Time      | 1.0~8.0(sec.)                       |
| Reset Time          | 1.0~8.0(sec.)                       |
| Weight              | 23kg                                |
| Dimensions          | 68x36x20(cm)                        |





#### IV. CONSTRUCTION DIAGRAM





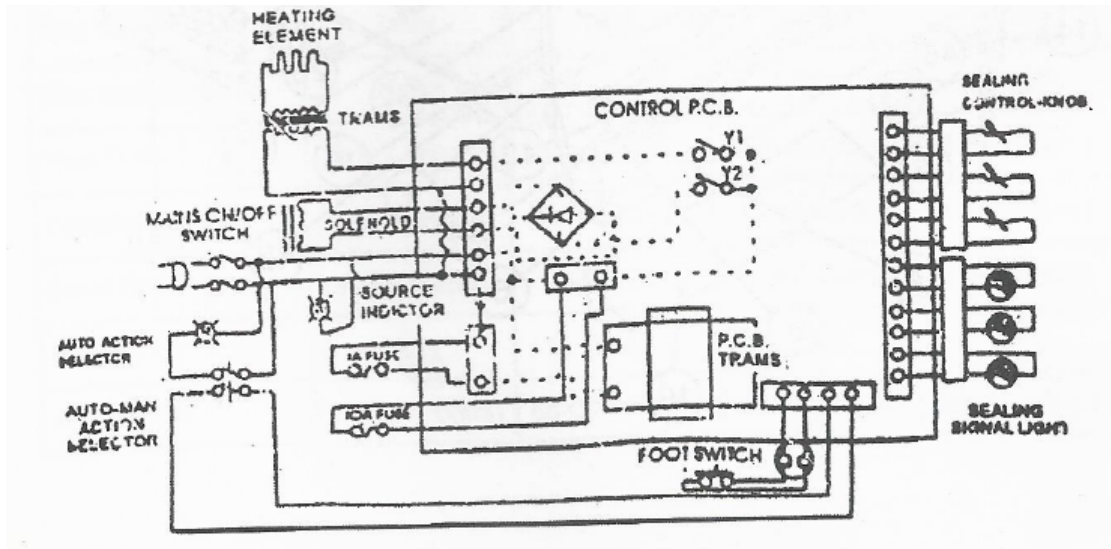
## **V. PARTS LIST**

1. TIMER KNOB
2. PLASTIC PLATE
3. BUSHING
4. BAKELITE PIPE
5. CONVEX BAKELITE
6. LOWER JAW
7. BASE PLATE
8. HINGE BRACKET
9. UPPER JAW
10. UPPER JAW SUPPORT
11. FLAT PLATE
12. HANDLE STRAP
13. BRASS CONTACT
14. TENSION SPRING
15. FRONT PLATE
16. BACK PLATE
17. TOP COVER PLATE
18. SPRING LEVER
19. OPERATING BOARD
20. CLIP FOR CLOTH
21. SCREW FOR CLOTH
22. RETURN SPRING
23. SPRING FOR UPPER JAW
24. SCREW FOR UPPER JAW
25. HINGE PIN
26. SPRING BRACKET
27. TRANSFORMER
28. SOLENOID
29. TOGGLE SWITCH
30. FOOT SWITCH
31. SIGNAL LIGHT
32. LED LIGHT
33. POWER SUPPER CORD
34. HEATING ELEMENT
35. CONTROL-PCB
36. FUSE BRACKET
37. PCB-TRANSFORMER
38. RELAY
39. CONNECTOR FOOT PEDAL
40. RUBBER PRESSURE PAD
41. RUBBER STRING
42. RUBBER FOOT
43. UPPER BARRIER TAPE
44. BOTTOM BARRIER TAPE
45. BOTTOM BARRIER TAPE
46. PIN WASHER
47. INSULATION WASHER
48. CONTROL PANEL
49. PCB SUPPORT





## VI. CONNECTION DIAGRAM



## VII. ADDITIONAL INFORMATION

- Always Keep the sealing platform clean Particular care should be taken to remove any residue from over heated plastic from the barrier tape.
- Do not clean the sealing platform with anything wet.
- If the bottom barrier tape, (under the heating element) becomes worn, the heating element may short to earth, and this can damage the element.
- When replacing a heating element always check the condition of the bottom barrier tape it is also important that, when replacing a heating element, if genuine spares are not available, only thermo-electric wire of an identical specification (resistivity)
- After a long period of use the condition of the top pressure pad should be examined for wear. Obviously, any deformation will affect the quality of the weld and replacement may become necessary.





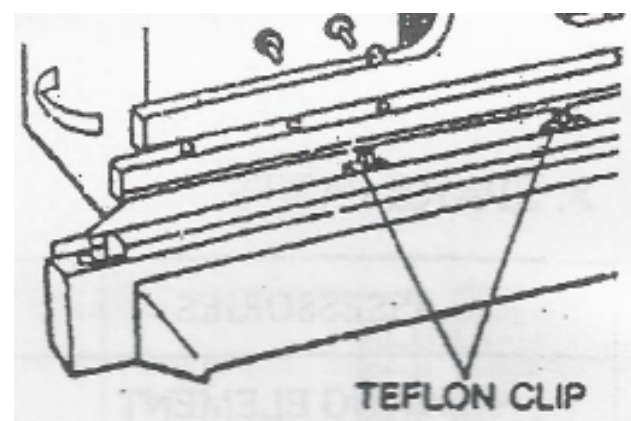
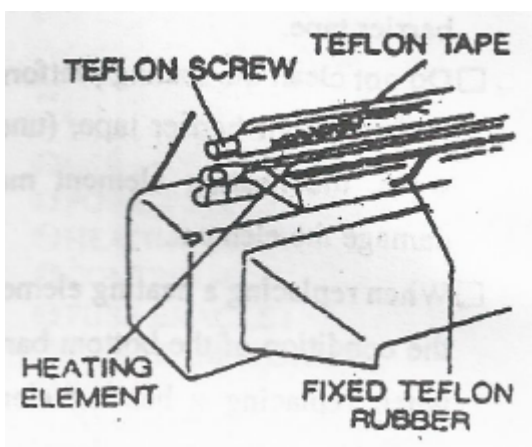
## VIII. SPARE PARTS

| Accessories     | Quantity |
|-----------------|----------|
| Heating Element | 2        |
| Fuse 10-A       | 1        |
| Fuse 1-A        | 1        |

## IX. METHODS OF EXCHANGING SUBSIDIARY PARTS

To replace the seal parts disused in case of heater consumed, please refer to followings;

1. Be sure to turn off the power before replacing.
  - Release fixed Teflon rubber, Teflon clip.
  - Pull out the Teflon tape, cut down the remainder, then, fix rubber and tape.
  - Fix Teflon screw, then it must to be rotated, pull tightly the Teflon tape and fix Teflon clip.
2. Method of replace heating element.
  - Release Teflon clip.
  - Heaters pole must be enclosed to inner side in order to release the heating element. (Heater's pole is tightened by at two end)
3. After replace the heater, please fix the teflon tape according to the previous method.





**CONTACT US FOR MORE INFORMATION**

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