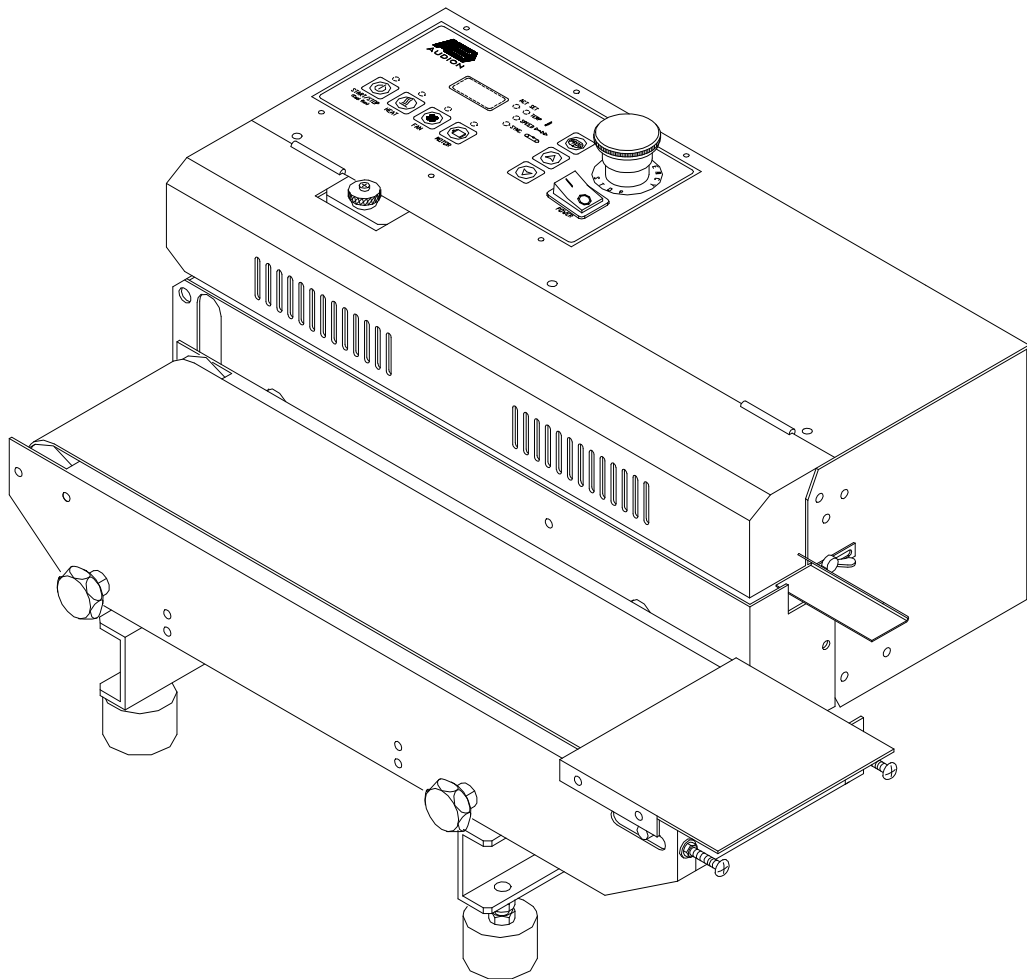




AUDION ELEKTRO®

ALL-IN-SEALER

D 555 NH



MANUAL



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1 To unpack the All-in sealer

Check during the unpacking of the All-in sealer if all parts mentioned below are present.

- ALL-IN-SEALER D 555 NH.
- Infeed guide
- Rubber feet (4x)
- Spare PTFE-belt (2x)
- Wrench 10 / 13 to mount rubber feet
- Screw driver to open front cover
- Allan key (2x) gearbox
- Manual

The D 555 NH is mounted on a wooden plate and packed in a carton box. The machine should be picked up, out of the carton box, by two persons. Place the D 555NH on a work table. Disassemble the wooden plate and mount the four rubber feet.

Check the data on the identification plate of the machine and record the information on the identification plate (fig. 1) in the figure below.

The All-in sealer has been packed in a carton box. We recommend you to retain the carton box for future transport.


	AUDION ELEKTRO® P.O.BOX 389, 1380 AJ WEESP, HOLLAND		
TYPE	<input type="text"/>	VOLT	<input type="text"/>
SERIE	<input type="text"/>	WATT	<input type="text"/>
JAAR	<input type="text"/>	HERTZ	<input type="text"/>

Fig. 1

2 Safety instructions

Read the manual carefully before any operation on the All-in!

- Check, before the All-in is put into operation, whether the data on the identification plate corresponds with the Voltage (V), Power Rating (W) and Frequency (Hz) of the local power supply.
- If the All-in is not to be used for a long period of time, disconnect the power cord from the mains supply.
- Remove the power cord from the mains supply before any maintenance takes place on the All-in. Beware of the danger of an electric shock.
- Do not use water, abrasives, chemicals or other liquids for cleaning the All-in. See Chapter 8.
- If in doubt about the correct operation of the All-in, immediately disconnect the power cord and consult maintenance personnel.
- Have repairs done by skilled maintenance personnel only.
- Should liquid or an object fall into the All-in, immediately remove the power cord from the mains supply and have the All-in checked by a skilled person before using it again.
- Only use replacements parts provided by Audion Elektro.
- Do not use the All-in to seal other materials than recommended by Audion Elektro (see chapter 3).

3 General description

The ALL-IN-SEALER is a stand-alone continuous sealing machine.

The width of the bags to be sealed is unlimited. The sealing temperature can easily be set. The automatic temperature control keeps the temperature fixed at the same level during operation.

The ALL-IN-SEALER is suitable for sealing "ready to hand" bags of Polyethylene (PE), Polypropylene (PP), thin PVC's and various laminates.

The All-in is standard supplied with a touch-panel and a digital display for the temperature and the speed.

4 Dimensions

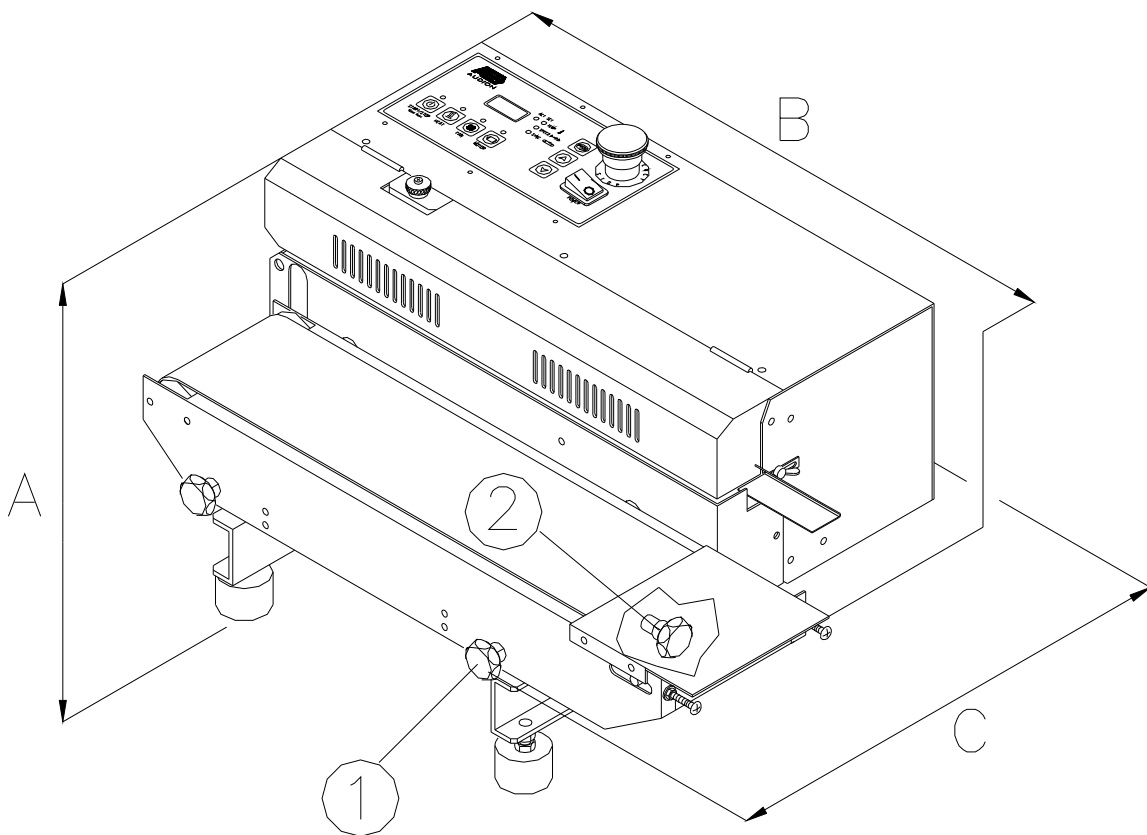


Fig. 2

MACHINE	Outer dimensions (mm)		
	A	B	C
ALL-IN-SEALER D 555 NH	270	610	460

5 Operation panel

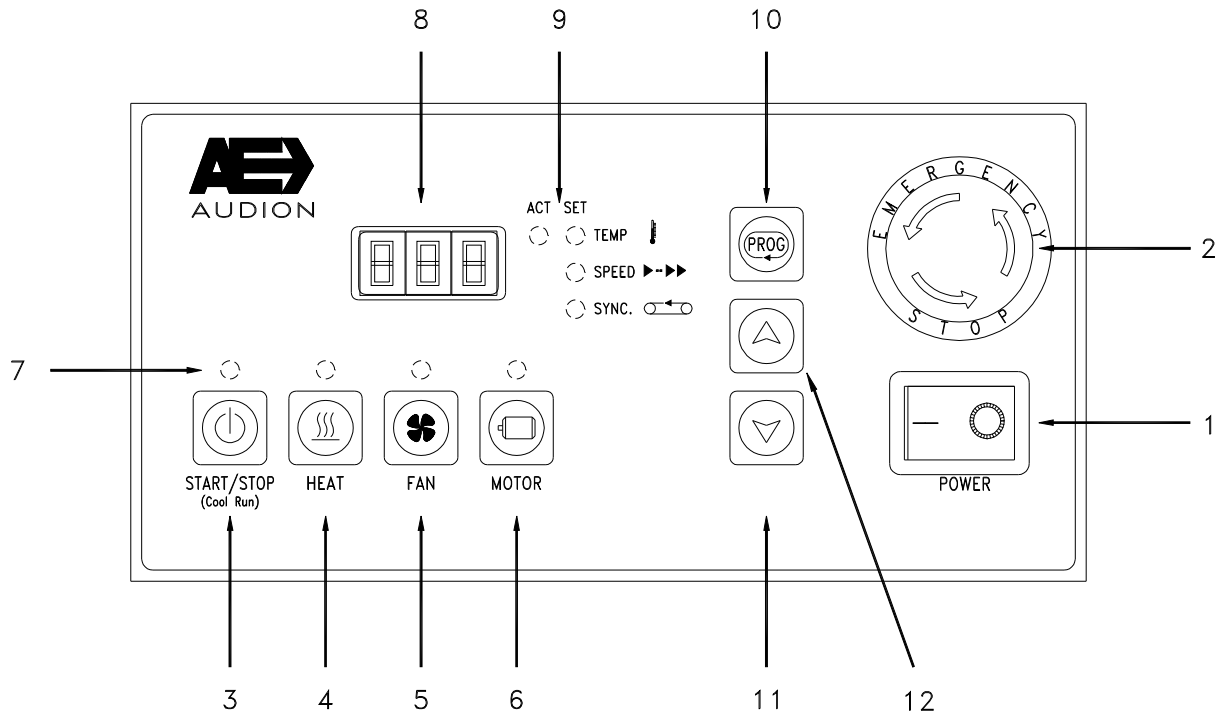


Fig. 3

The operation panel contains:

- | | | |
|----|--------------------------|--|
| 1 | POWER | Main switch, turns the power on/off. |
| 2 | Emergency stop | Stops machine immediately in case of emergency. |
| 3 | START/STOP
(Cool Run) | Button to start/stop the machine. If the machine will be stopped and the actual temperature is above the 80°C. The machine will cooldown till 80°C in the cool run mode. After the cool run mode the machine automatically switches off to the standby mode. |
| 4 | HEAT | Turns the heater on/off. |
| 5 | FAN | Turns the fan on/off. |
| 6 | MOTOR | Turns the motor on/off. |
| 7 | Leds | These leds indicate an active function. |
| 8 | Display | The display shows the temperature/speed/sync. factor/cool run/errors. |
| 9 | Leds | During the adjustment these leds indicate which adjustment is active. |
| 10 | PROG | Button to pass the temp/speed/sync. adjustments.
After 30 seconds from the last button pressure, the program returns automatically to the actual temperature. |
| 11 | Down | Button to decrease the adjusted value. |
| 12 | Up | Button to increase the adjusted value. |

6 Installation

6.1 Description of workplace

Install the ALL-IN-SEALER in a ventilated, well illuminated space. Ensure that the ALL-IN-SEALER is not exposed to direct sunlight, extreme temperatures, damp, dust or sand. The ALL-IN-SEALER is not allowed to be exposed to mechanical shocks or vibrations.

6.2 Connecting ALL-IN-SEALER

Before connecting the ALL-IN-SEALER, be sure that the power is off, the main switch (fig. 3 pos 1) must be at position O (OFF).

6.2.1 Adjusting height transport belt

Adjust the height of the conveyor in relation to the seal unit. The bag must be sealed at the half of the product height.

- Loosen the two knobs (fig. 2 pos 1).
- Adjust the height of the transport belt by raising or lowering it manually.
- If the transport belt is at the correct height, and the transport belt is horizontal, tighten the two knobs to secure the transport belt.

6.2.2 Connecting to power supply

Connect the power cord into the power supply. The main socket must have an ground connection and must be max. fused at 16 Ampere.



6.3 Adjusting seal temperature/speed

Use the PROG-button to change the adjustments. The leds indicates which adjustment is selected. After 30 seconds from the last button pressure, the program returns automatically to the actual seal temperature.

To find the ideal sealing temperature and speed. Make a couple of trial seals with different adjustments. The settings for a good seal are a combination between sealing temperature (TEMP) and on the other side the operation speed (SPEED).

Adjust the next parameters:

- The sealing temperature to 100°C.
- The operation speed "speed" to 50.

Follow the next steps to adjust the seal temperature and the operation speed:

- Press on PROG.
- Led TEMP/SET illuminates and the display shows the actual adjusted temperature.
- Press on UP/DOWN to raise or lower the adjusted temperature.
- Press on PROG.
- Led SPEED/SET illuminates and the display shows the actual adjusted operation speed.
- Press on UP/DOWN to raise or lower the adjusted operation speed.
- Press the PROG-button again to return to the actual temperature.

The led of the seal temperature TEMP/ACT flashes if the temperature deviation is more than 5 degrees from the adjusted value.

Make a couple of bags. Re-adjust if the bags are not sealed properly.

- The seals are not tight. The sealing temperature is too low and the operation speed too high.
- The seals looks melted. The sealing temperature is too high and the operation speed too low.

6.4 Cool run

Turn off the machine with the START/STOP-button. The machine will cool down to 80°C in the cool run mode. After the cool run mode the machine automatically switches off to the standby mode. During the cool run mode the motor and fan turn on and the heater turns off automatically. The cool run protects the PTFE-belts against burning. That will increase the life cycle of the belts. Below 80°C the cool run turns off the machine immediately to the standby mode.

The START/STOP led flashes during the cool run. The display shows intermittent "c-r" and the actual temperature.

6.5 Standby

Turn the machine off with the cool run. After the cool run mode the machine automatically switches off to the standby mode. The display shows "- -" and all functions are shut down. Press a button to turn the machine on again. If the All-in is not to be used for a long period of time, use the main switch (POWER) to turn off the machine. In this way the current is shut down.

6.6 Preparation for use

After the All-in is connected to the power and properly checked. The machine can be put into operation.

- Reset the emergency stop.
- Set the main switch (POWER) to on (1).
- Adjust the seal temperature (TEMP).
- Adjust the operation speed (SPEED).
- Turn on the MOTOR, FAN, and HEATER if necessary.
- Press START/STOP to turn on the machine.
- Let the machine heat up. The led TEMP/ACT stops flashing if the machine is at the set temperature.

Turn off the All-in normally with the cool run. If the All-in is not used for a longer period of time, set the main switch (POWER) off and disconnect the power cord from the mains supply.

6.7 Emergency stop

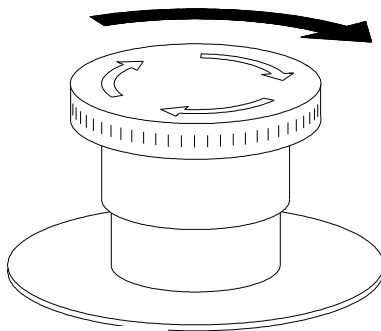


Fig. 4

In case of emergency the emergency stop (fig. 4) can be activated. This causes the power supply to be shut off and the machine to stop.

The emergency stop should only be used for emergencies and not for a temporary switch off or stop of the machine.

The emergency stop is operated by means of pushing the red button (fig. 4) on top of the machine. After each use of the emergency stop it should be resetted by turning the red button in the direction of the arrow.

After resetting the emergency stop, press the START/STOP-button and the machine starts running again.

7 Specifications

7.1 Operational specifications

- Operation speed : max. 10 meter per minute
- Ambient temperature : +5ø . . . +40ø Celsius
- Humidity : 30% . . . 95% rel. (without condensation)
- Fastening, fixing : The ALL-IN-SEALER is standing on 4 rubber feet
- Explosion safety : Not to be used in explosive surroundings
- Extraction, ventilation : To be used in ventilated spaces

7.2 Aplications not allowed

- Packing in medical, sterile environment.
- Use in an explosive surrounding.
- Packing of poisonous, corrosive, irritating substances.
- Packing of explosive materials.
- Packing of (dangerous) dusty products.



8 Maintenance

The ALL-IN-SEALER is a relatively simple machine which needs very little maintenance. There are a few repairs which could be carried out by yourself. For other repairs please contact your dealer or Audion Elektro.

- Always dissonnect the sealer from the main power supply in case of maintenance or repairs.
- Wait till the machine has cooled down before any maintenance or repairs are carried out.
- Before switching off the cooling ventilator and the motor the ALL-IN-SEALER must cool down or at least 10 minutes!
- Only use spare parts supplied by Audion Elektro.

The maintenance schedule below is for normal use. In case of intensive use or under extreme circumstances maintenance should be executed more frequently.

Daily maintenance:

PTFE-belts	Check if the PTFE-belts are clean. If necessary, clean them with a wet cloth.
Heating plates	Check if the plates are clean. If necessary, clean them with a wet cloth.

Weekly maintenance:

Driving mechanism	Check condition of driving mechanism and rotating parts. If needed, lubricate them.
V-belts	Check condition (rupture) and tension.
Conveyor belt	Check condition (rupture) and tension.
Cleaning	Clean the All-In-Sealer with a wet cloth and soft soap.

8.1 Maintenance and adjusting ALL-IN-SEALER

In order to be able to carry out maintenance or to replace spareparts easily you should:

- **Disconnect the ALL-IN-SEALER from the power supply**
- Loosen the two knobs under the transport belt, and move the transport belt as far as possible from the ALL-IN-SEALER.
- See fig. 5. - Remove the back cover (1).
 - Open the upper front cover (2).
 - Remove the lower front cover (3).

Take care! The heating plates can still be hot. Before switching off the cooling ventilator and the motor, the machine must cool down for at least 10 minutes!!

When all activities have been done, remount the rear cover and the protection covers.

DO NOT OPERATE THE MACHINE IF THE PROTECTION COVERS HAVE NOT BEEN MOUNTED.

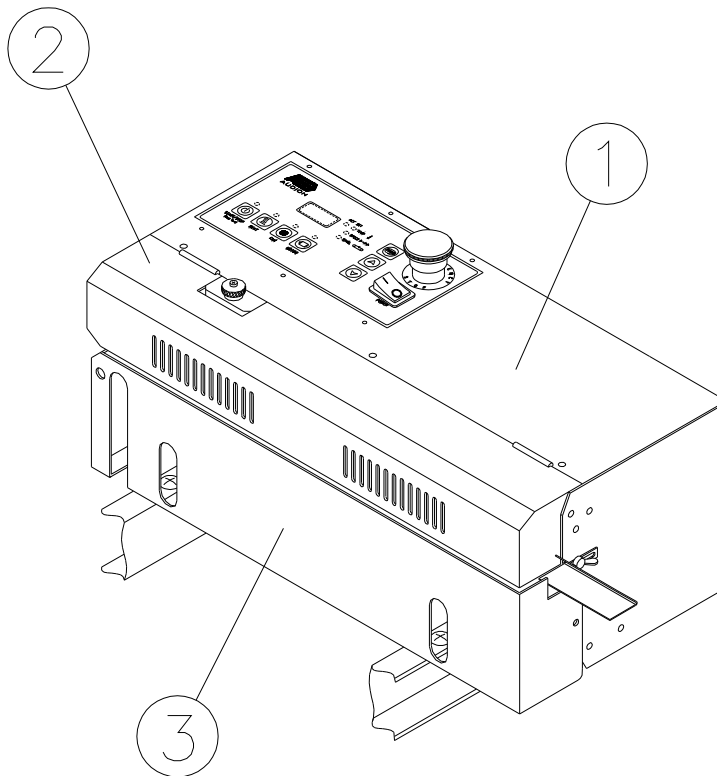


Fig. 5

8.2 Heating elements

The heating elements are mounted in the heating plates. In order to obtain a good seal correct adjustment of the heating plates is essential. Adjustment of the heating plates depends on the material properties.

8.2.1 Adjust heating plates

If very thick films need to be sealed, it may be necessary to adjust the distance between the two heating and cooling elements. If this is the case, then:

- Carry out the activities as described in § 8.1
- Turn the 4 nuts (fig. 6 pos 2) clockwise a few times to raise the elements. Counter clockwise to lower the elements.
- Close all covers.

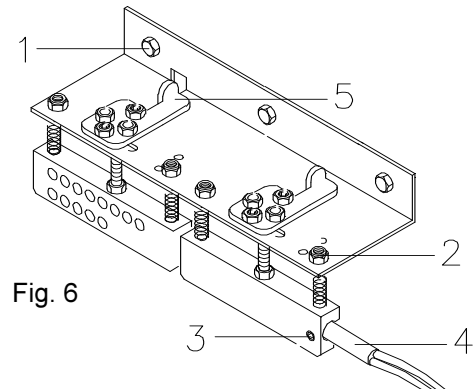


Fig. 6

8.2.2 Replace heating elements

- Remove the back cover.
- Open the upper front cover.
- Loosen the 3 screws (fig. 6 pos 1) to remove the complete mounting plate.
- Disconnect the wiring of the heating elements.
- Loosen the cup (fig. 6 pos 3) to replace the heating element (fig. 6 pos 4).
- Connect the wiring and place the mounting plate.
- Mount all covers.

8.3 PTFE-belts

The PTFE-belts prevent contact of the product to be sealed with the heating plates. The PTFE-belts should never be folded as otherwise the folded part of the bands becomes a weak point during use.

8.3.1 Adjust PTFE-belts

Note : Do not adjust the heating plates too tight to prevent unnecessary wear of the PTFE-belts.
See § 8.2.1.

The PTFE-belts are being tensioned by springs, which means that these belts do not need separate adjustments.

8.3.2 Replace PTFE-belts

Burnt or worn PTFE-belts can be replaced easily:

- Carry out the activities as described in § 8.2.1.
- Remove the V-belts as described in § 8.4.1.
- Raise the heating and cooling plates by rotating the handles above the plates clockwise (fig. 6 pos 5).
- Push the PTFE pulley on the righthand-side to the left until you hear a click. The pulley is now locked.
- Place the new PTFE belt over the pulley's.
- Press the screw above or below (depending on what pulley you are working on) the guide block to unlock the pulley.
- Lower the heating and cooling plate.
- Close the covers as described in § 8.1.

8.4 V-belts

There are 2 V-belts in the ALL-IN-SEALER. They are located at the lefthand-side of the machine.

8.4.1 Replace v-belts

- Carry out the activities as described in § 8.2.1.
- Loosen the nut (fig. 7 pos 1) and slide the shaft (pos 2) to the right.
- Replace the v-belt.
- Tension the v-belt by sliding the shaft (pos 2) to the left, and fasten the nut.
- Close all covers.

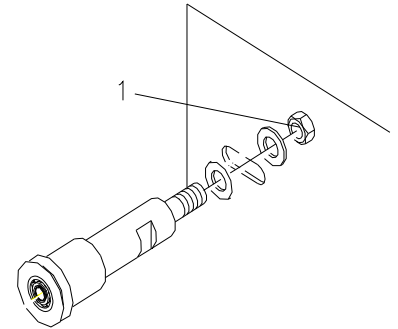


Fig. 7

8.5 Pressure roller

The pressure roller applies an extra pressure onto the cooled seal. The pressure roller can be replaced by a code roller.

In case the pressure roller is not needed, it can be disabled. By turning the ring (fig. 8 pos 1) clockwise the pressure roller is lifted upwards.

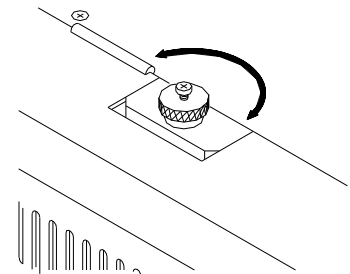


Fig. 8

8.6 Transport belt

The transport belt supports and transports the packing to be sealed. The transport belt prevents the packing from hanging on the seal.

Make sure that:

- The distance between the transport belt and the sealunit is correct. (half of the thickness of the packing that is to be sealed).
- The transport belt does not run against anything.

8.6.1 Adjust transport belt

Adjust the transport belt if:

- the belt touches the sides.
- the tension on the belt is too high or too low.

Note: Loosen the 4 locknuts (fig. 9 pos 1) before adjusting the tension.
Only adjust the tension when the belt is running slowly.

The tension can be adjusted by rotating the front or rear locknut (fig. 9 pos 1):

- Clockwise tension belt.
- Counter clockwise release belt.

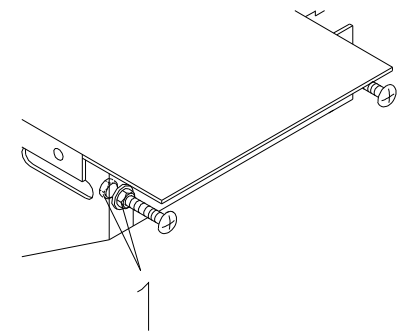


Fig. 9

If the transport belt touches one side of the frame;

- Tension the belt on the side it is touching.
- Release the belt on the other side.

If the transport belt has been incorrectly tensioned;

- Tension the belt equally by adjusting both sides.

8.7 Motor Set-up

The machine has an automatic motor set-up function. This motor set-up function must be carried out when a motor is replaced. During this set-up the motor will run at full speed for a few seconds. Be aware that the machine can run safely for a few seconds.

To perform a motor set-up follow the next steps:

- Select the 'SPEED' mode with the 'PROG' button.
- Press the 'PROG' button for 5 seconds till 'SP1' appears in the display.
- Start the set-up routine by pressing the 'PROG' button. The motor will run at maximum speed for a few seconds.
- End the function by pressing the 'PROG' button for 5 seconds till the SPEED settings appear on the display.

8.8 Correction factor

The machine has correction factors to adjust the motor if necessary. This factor (%) will affect the motor output. If set at e.g. 90 the motor will run slower and set at e.g. 110 the motor will run faster.

To perform a motor set-up follow the next steps:

- Select the 'SPEED' mode with the 'PROG' button.
- Press the 'MOTOR' and 'PROG' button simultaneous for 5 seconds till 'CF1' appears in the display.
- Set the CF1 setting with the 'UP' or 'DOWN' button.
- End the function by pressing the 'PROG' button for 5 seconds till the SPEED settings appear on the display.

8.9 Reset to factory settings

The machine has a function to reset all settings to the original factory settings. Note that if you reset the machine all settings prior made will be lost.

To perform a reset follow the next steps:

- Switch the main power OFF.
- Keep the 'START/STOP' button pressed, while the main power is switched ON, until 'rES' appears in the display.
- Perform a motor set-up. (see 8.7)
- Adjust the correction factor if necessary (see 8.8).

8.10 Print jumpers

There are two jumpers on the back of the PCB. These two jumpers will adjust:

Jumper 1: Voltage 240V-50Hz / 115V-60Hz.

Jumper 2: No application.

The display shows the current jumper adjustment. Turn the All-in on by the main switch (POWER). The first two seconds, the display shows the software version and the jumper configuration.

Code in display			Jumper 1	Jumper 2
J	1	2	50Hz	No application
J	-	2	60Hz	No application
J	1	-	50Hz	No application
J	-	-	60Hz	No application

The jumpers of the PCB are placed on the right side in the middle.

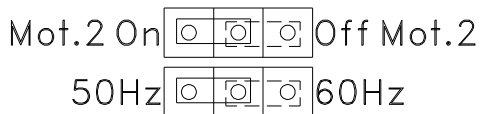


Fig. 10

The standard values are ON and 50Hz if the jumpers are removed.

9 Technical data

ALL-IN-SEALER D 555 NH	
Dimensions	See §4
Weight	29 kg.
Sealwidth	10 mm
Power rating	550 Watt
Voltage	230 V
Frequency	50 Hz
Noise	≤ 70 dB(A)

10 Problems and solutions

Problem	Cause	Solution
The All-in sealer does not work.	<ul style="list-style-type: none"> - Main switch is at "0". - The plug is not properly in the main power supply. - Emergency stop has been activated. - Internal interruption. 	<ul style="list-style-type: none"> - Set the main switch to "1" (fig. 3 pos 1) - Insert the plug properly into the main power supply. - Unlock the emergency stop § 6.7. - Contact your dealer or Audion Elektro B.V.
The All-in makes a bad seal.	<ul style="list-style-type: none"> - Temperature has not been set well. 	<ul style="list-style-type: none"> - Set the temperature § 6.3.



	<ul style="list-style-type: none"> - Speed has not been set well. - Heating plates and/or PTFE-belts are dirty. - Seal is not well cooled. - PTFE-belts are worn. 	<ul style="list-style-type: none"> - Adjust the speed § 6.3. - Clean the heating plates and/or PTFE-belts. - Switch on the cooling. - Replace the PTFE-belts.
Cooling does not work.	<ul style="list-style-type: none"> - The fan is turned off. - Internal interruption. 	<ul style="list-style-type: none"> - Switch on the fan. - Contact your dealer or Audion Elektro B.V.
Error codes in display E1	<ul style="list-style-type: none"> - Wrong frequency 50/60Hz. 	<ul style="list-style-type: none"> - Check the frequency and adjust the jumper.
E2	<ul style="list-style-type: none"> - Loose wire to PT100. 	<ul style="list-style-type: none"> - Check wiring and connections to the PT100.
E3	<ul style="list-style-type: none"> - Short circuit in PT100 	<ul style="list-style-type: none"> - Replace PT100.
Conveyor does not work.	<ul style="list-style-type: none"> - Speed is at 0. - Internal interruption. 	<ul style="list-style-type: none"> - Adjust the speed § 6.3. - Contact your dealer or Audion Elektro B.V.

11 Recommended spare parts

ARTICLE NUMBER	NAME	PER MACHINE
305-02002	V-belt	2
129-02003	PTFE belt	2
129-03000	Heating element	2

FUSE PCB	NAME	PER MACHINE
052026	Fuse F1 125mAT	1
160-1343125	Fuse F2 10AT	1
052010	Fuse F3 2AT	1
160-1343127	fuse F4 500mAT	1

12 Discard the All-in

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.

13 Conditions of guarantee

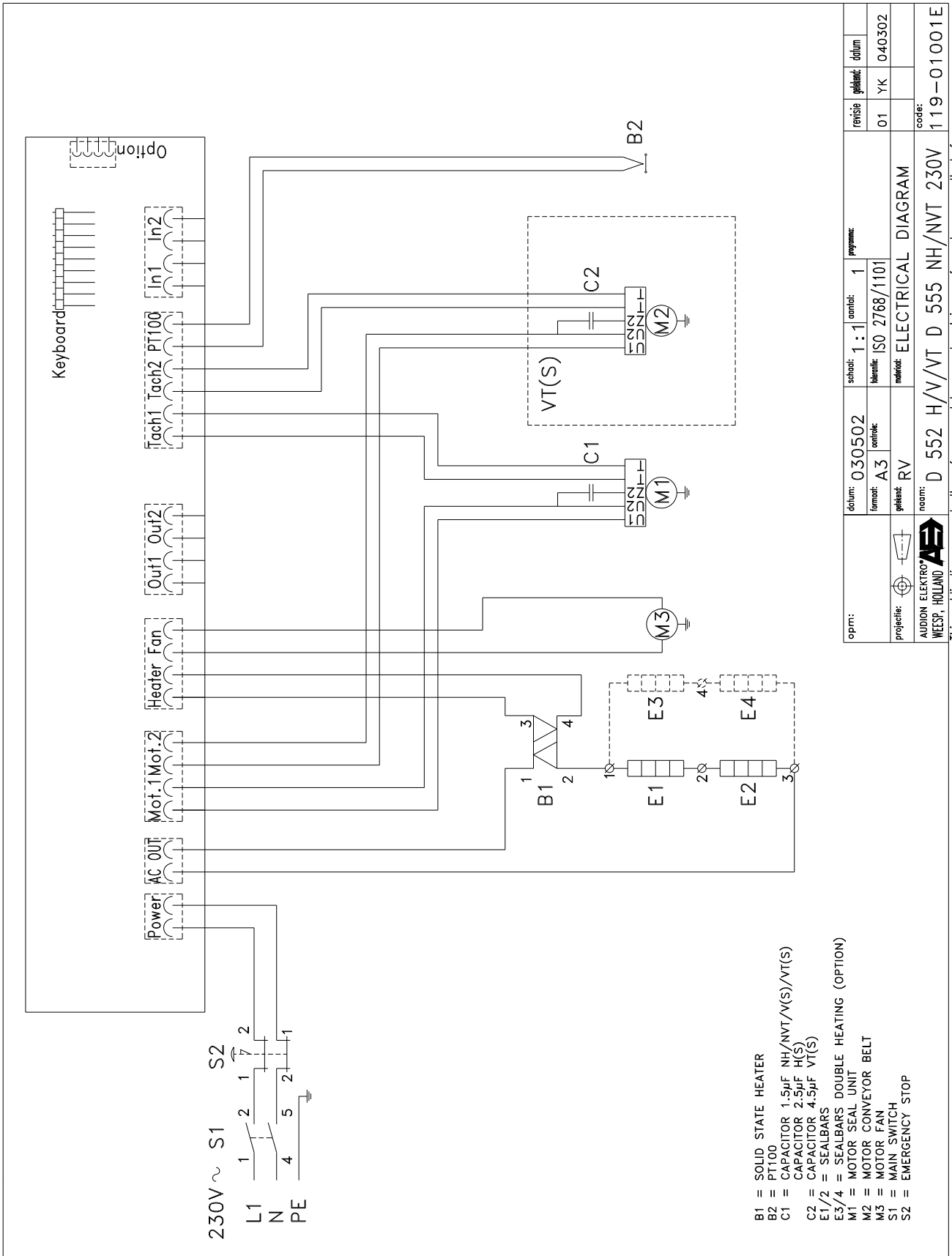
13.1 Liability

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.

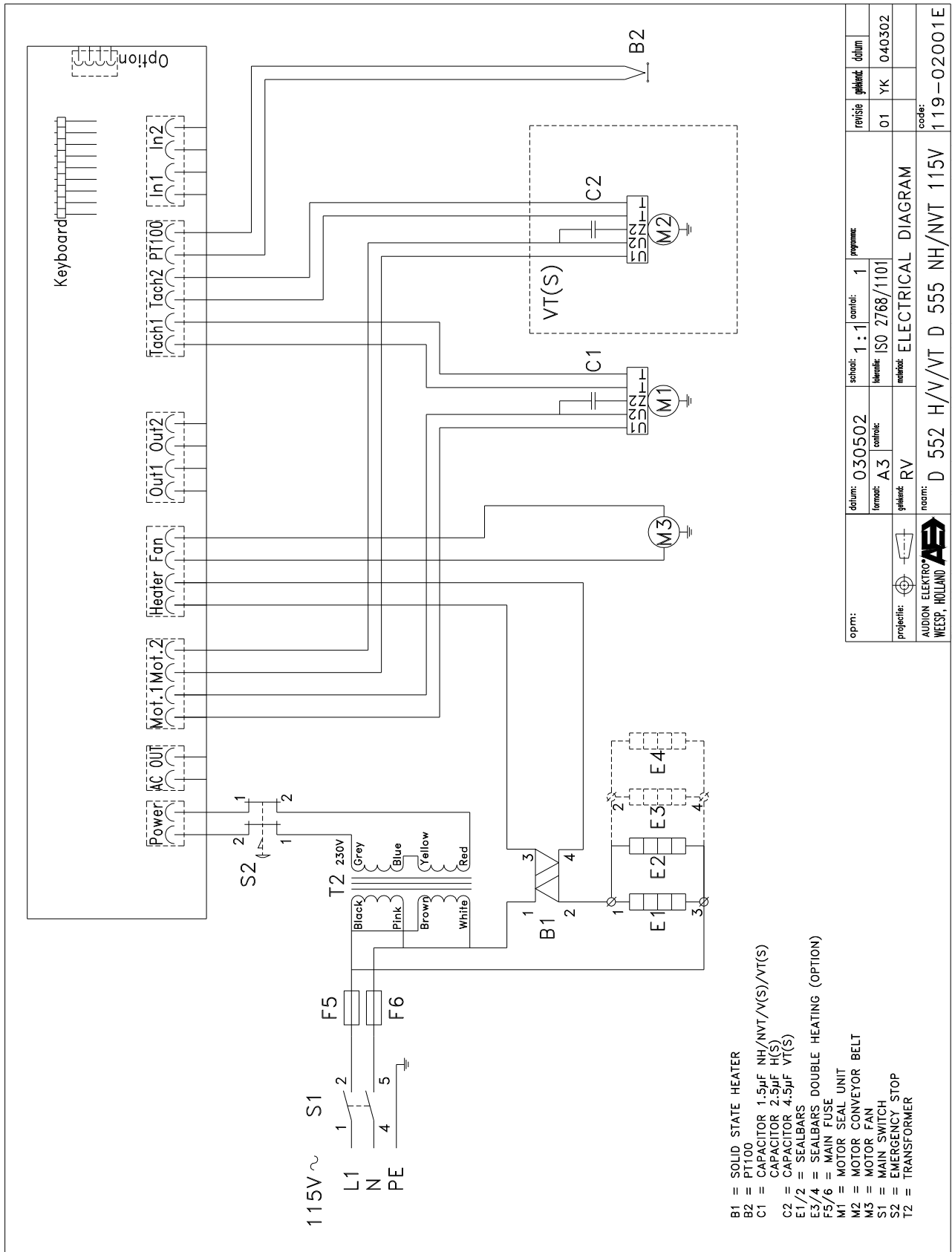
13.2 Guarantee

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.

14 Electrical circuit

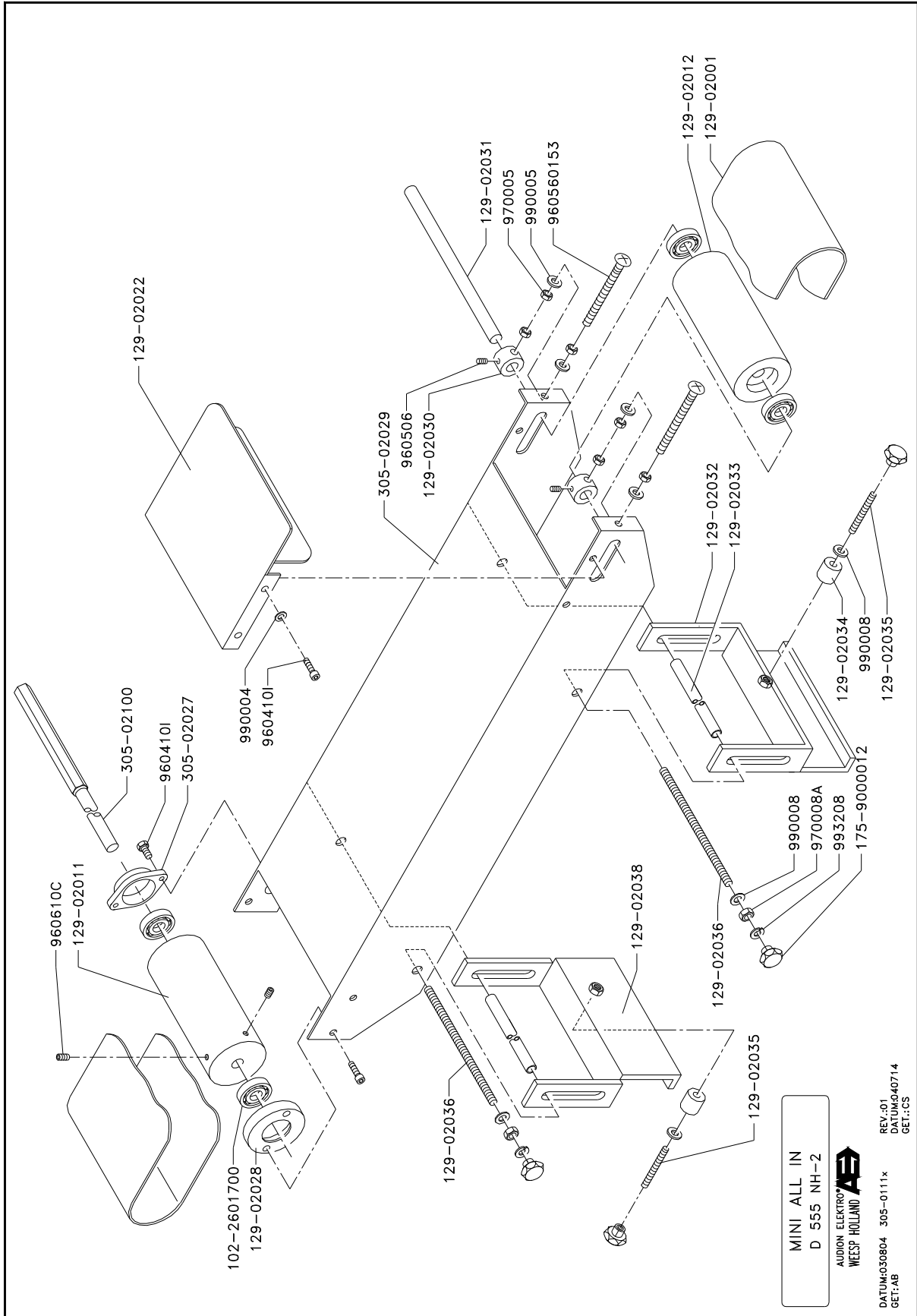


Electrical circuit



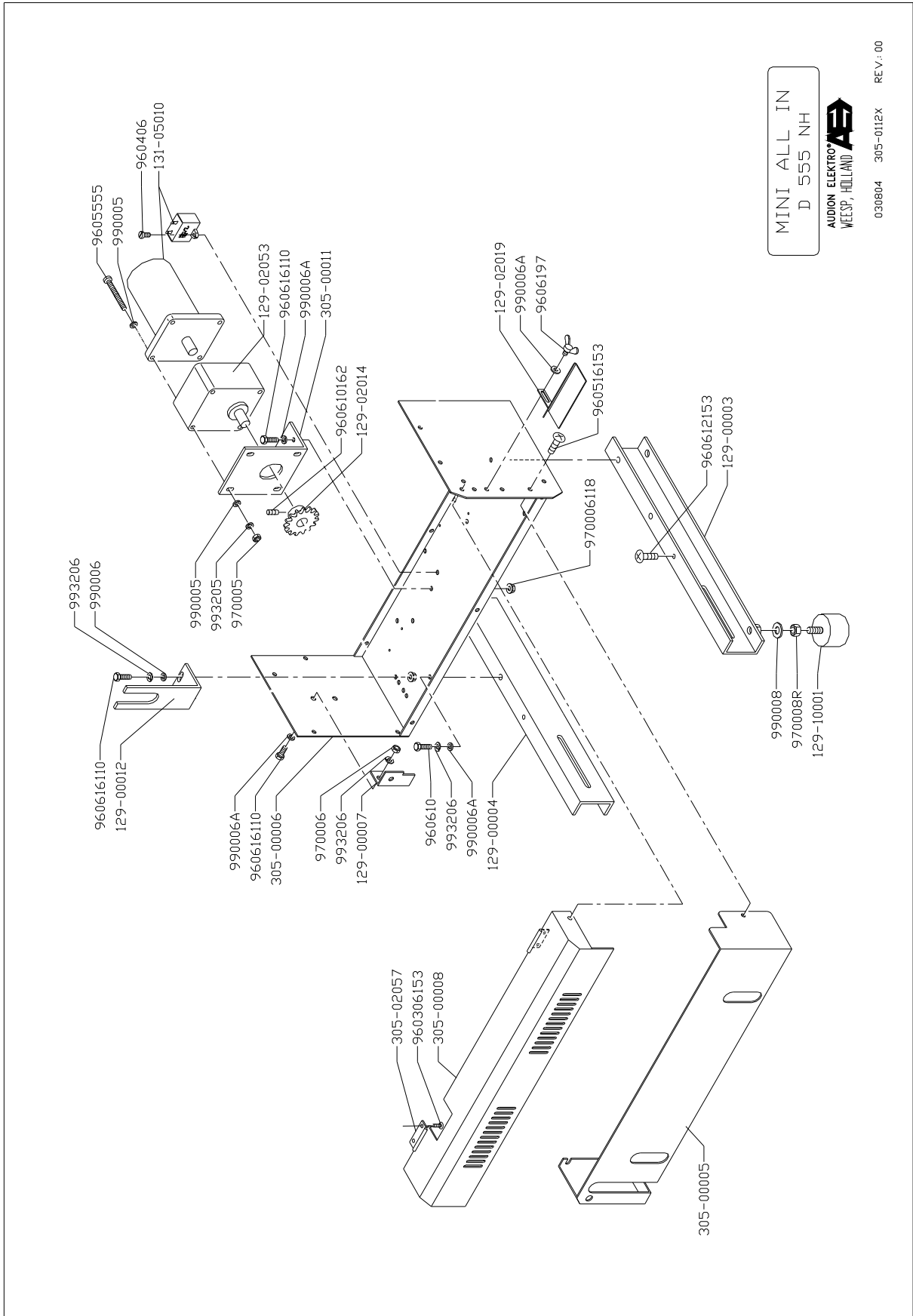


15 Exploded views



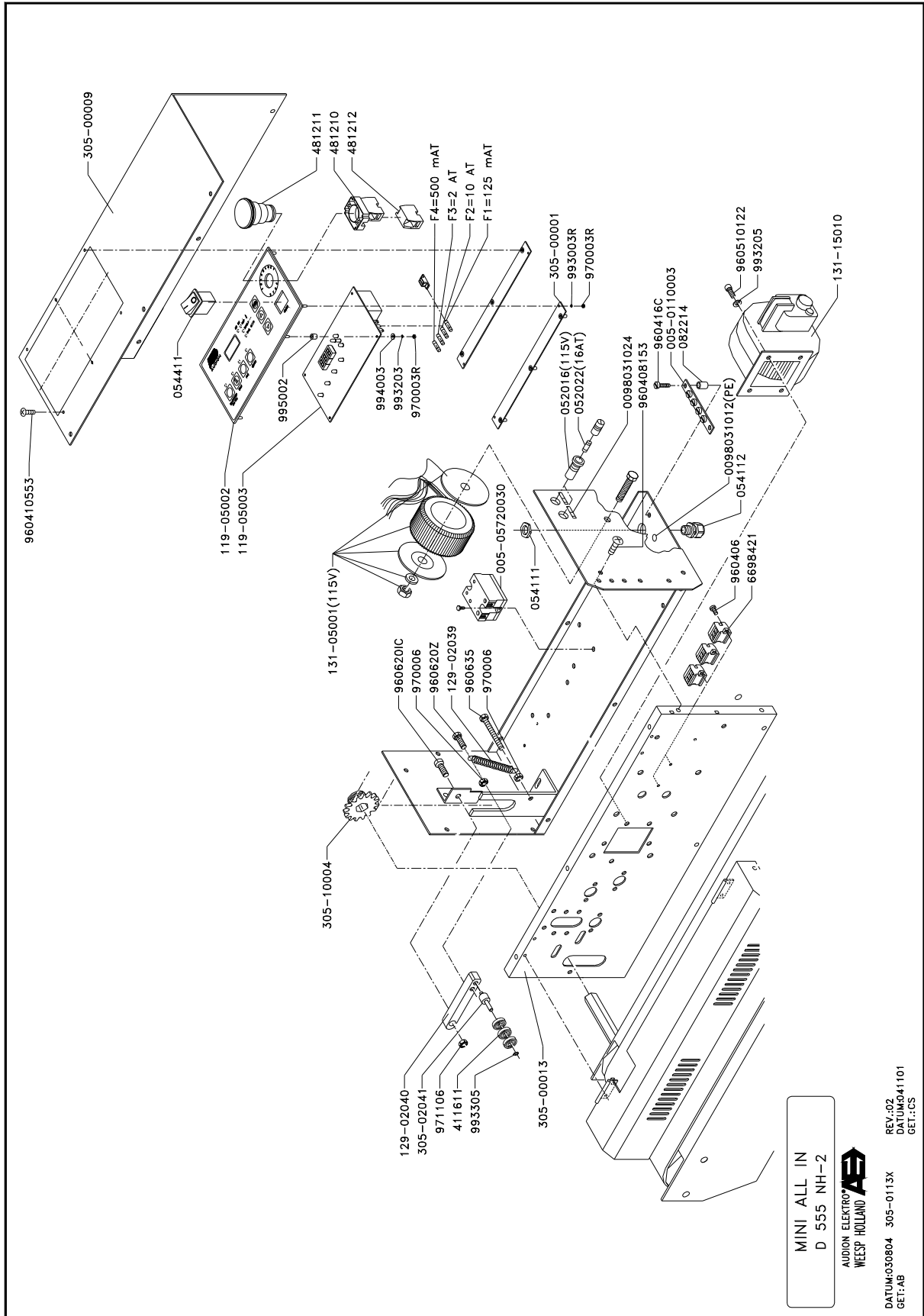


Exploded views



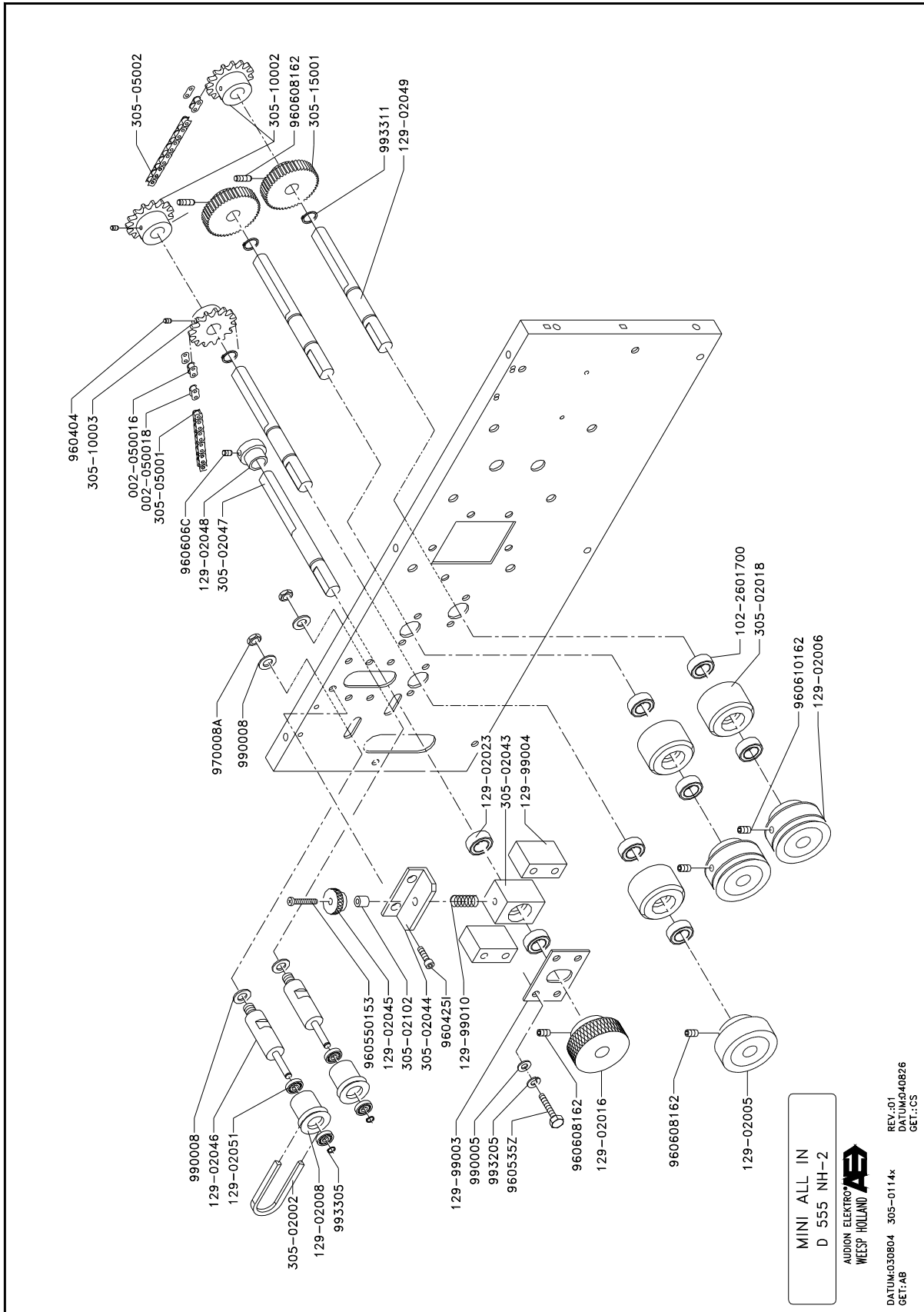


Exploded views



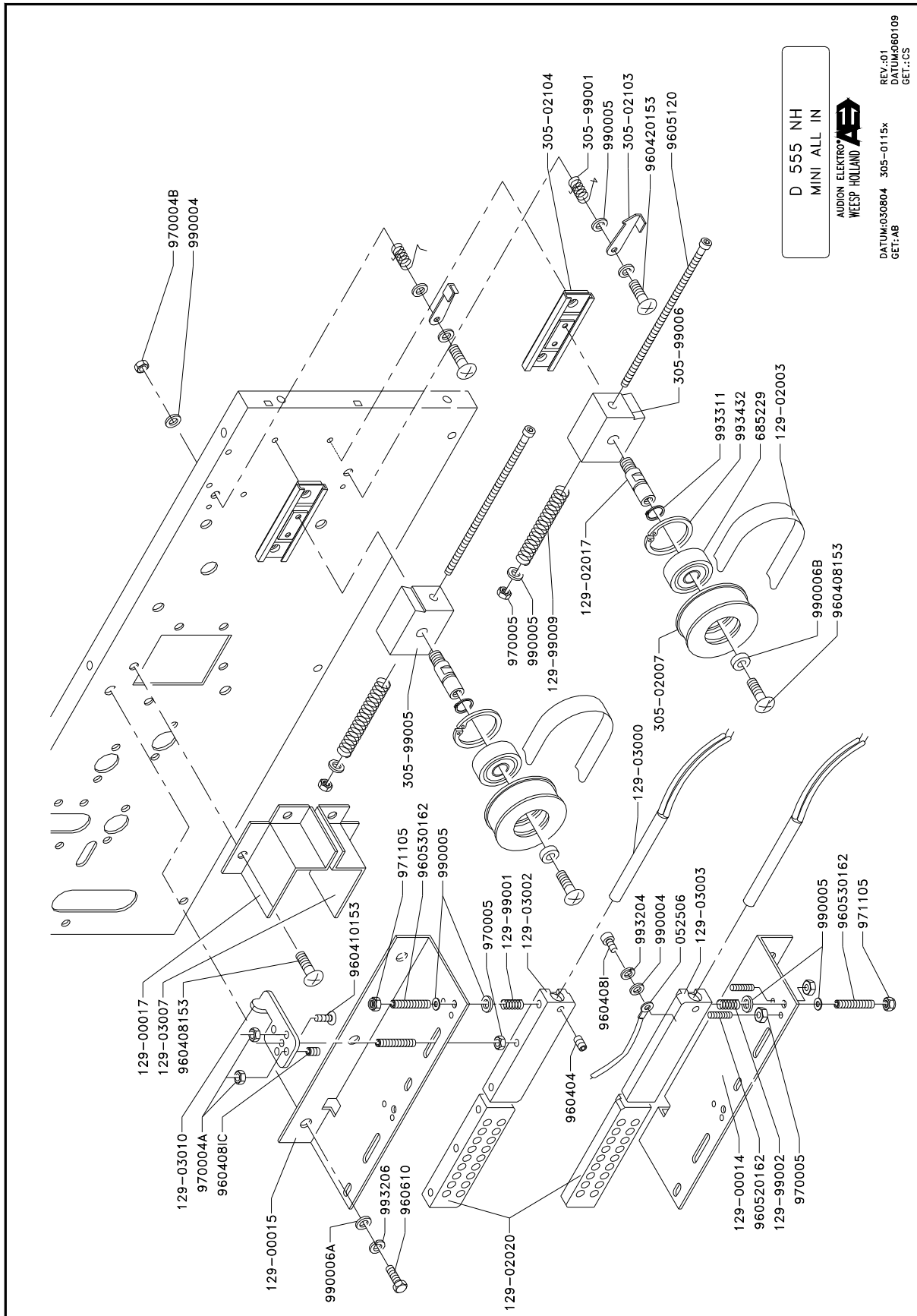


Exploded views





Exploded views



D 555 NH
MINI ALL IN



REV.:01
DATUM:030804
GET:AB
305-0115x
DATUM:030804
GET:AB



AUDION ELEKTRO®



EC-DECLARATION OF CONFORMITY

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

herewith declares that the

ALL IN SEALER 555

Type:

D 555 NH-2 ; D 555 NH-4 ; D 555 NVT-2 ; D 555 NVT-4

- is in conformity with the provisions of the following EEC directives:
2006/42/EC Machine Directive ; 2014/30/EU EMC-Directive ;

- and that the following (parts/clauses of) harmonized standards have been
applied:

EN-ISO 12100; EN-ISO 13732-1; EN-ISO 13850; EN 1037+A1; EN-IEC
60204-1;

Weesp 21-3-2017

E.Tangelder

Director

PGR139C

BANKS: Rabobank: account no. 34.31.00.045 Postbank: 108897 ABN-AMRO Bank n.v.: account no. 54.81.11.669
Trade reg. Hilversum no. 32057820. VAT no. NL803873104B01.

Our terms and conditions are deposited at the Chamber of Commerce in Hilversum.

Op alle overeenkomsten zijn van toepassing onze algemene leverings- en betalingsvoorwaarden, zoals gedeponeerd bij de Kamer van Koophandel te Hilversum

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