

SH1000

HOT AIR CONTINUOUS HEAT SEALER

**INSTRUCTION
AND
MAINTENANCE
MANUAL**

FISCHBEIN-SAXON LTD

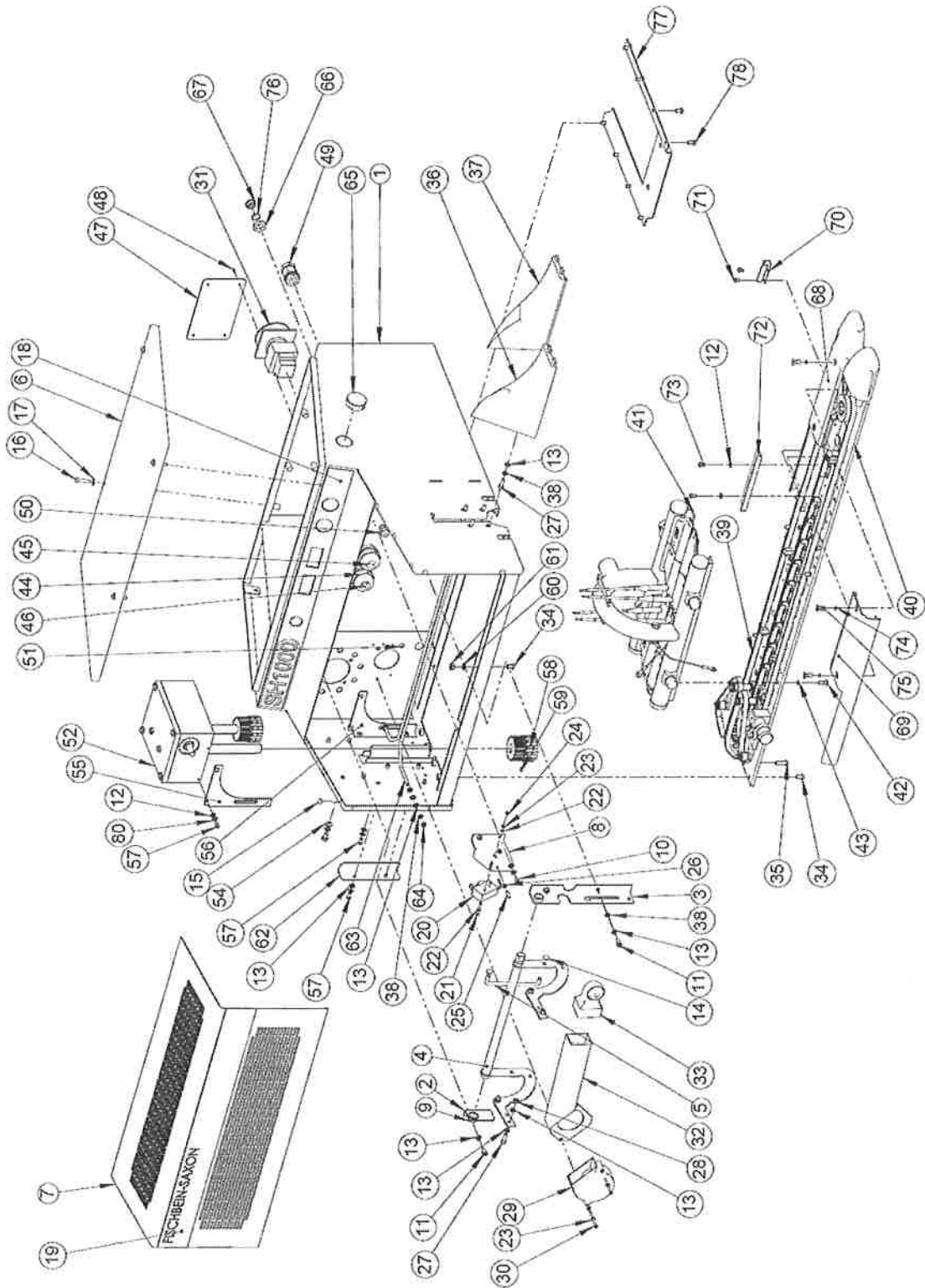
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9 PARTS / SPARES

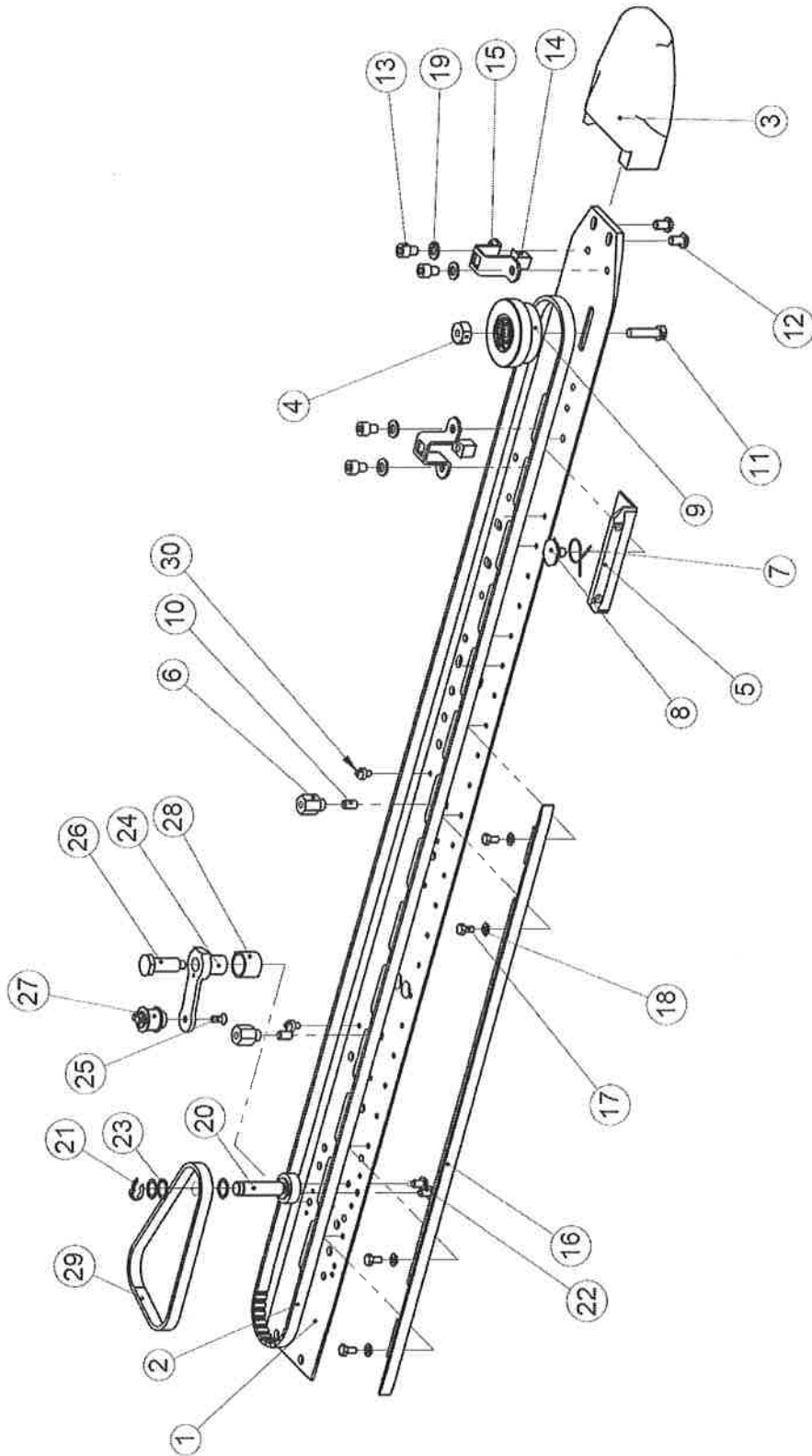
9.1 MAINFRAME



MAINFRAME ASSEMBLY PARTS LIST

ITEM	PART NO.	ISSUE	DESCRIPTION	QTY.	ITEM	PART NO.	ISSUE	DESCRIPTION	QTY.	ITEM	PART NO.	ISSUE	DESCRIPTION	QTY.
1	71.002	7	1000 SERIES MAINFRAME	1	36	67.321BL	1	INFEED PLOUGH LH	1	71	65.1.440	N/A	M4 x 6 HEX BOLT	6
2	71.026	1C	HINGE BRACKET	1	37	67.322BL	1	INFEED PLOUGH LH	1	72	71.094	5	PRESSURE PLATE SHORT, 1000 SERIES	1
3	71.087	1C	HINGE & STAY BRACKET	1	38	65.2.206	N/A	M5. SPRING WASHER	7	73	65.1.355	N/A	M4 x 8 HEX BOLT	2
4	71.103	3	HINGE ASSY RH	1	39	ZH1M60003	5	SH 1000 BOTTOM PLATE RH (R-L)	1	74	67.332	N/A	DZUS RETAINING RING	4
5	71.045	2	STAY	1	40	ZH1M60004	5	SH 1000 BOTTOM PLATE LH (R-L)	1	75	67.331	N/A	DZUS F.14-50 KFC	4
6	71.024	2	REAR COVER, 1000 SERIES	1	41	ZH1M60005	4	DUCT & CAPSULE ASSY 240v	1	76	71.168	N/A	O RING, 15 ID	1
7	71.025	2	FRONT COVER	1	42	13.11.11	N/A	DZUS STUD	4	77	71.096	1	COLUMN MOUNTING	1
8	71.086	1B	SWITCH BRACKET	1	43	67.334	N/A	DZUS STUD RETAINER	4	78	65.1.332	1	M5 x 10 SCREW, HEX HEAD	8
9	71.093	N/A	BEARING	2	44	75.513	N/A	CABLE GLAND M25	2	79	65.2.242	N/A	M6 WASHER, SPRING	4
10	65.1.258	N/A	M4 x 8. SKT CAP	2	45	71.088	1	GLAND SEAL, HEATERS	1	80	65.2.249	N/A	M4 WASHER, SPRING	14
11	65.1.270	N/A	M5x10 SKT CAP	4	46	71.089	1	GLAND SEAL, HEATER/TC	1					
12	65.2.159	N/A	M4 WASHER	8	47	64.18	N/A	RATING PLATE	1					
13	65.2.281	N/A	WASHER, PLAIN M5	28	48	67.238	N/A	RIVET	4					
14	65.5.422	N/A	STARLOCK FASTENER 6mm	2	49	75.94	N/A	GLAND	1					
15	71.098	N/A	RIVET BUTTON	10	50	75.20.2	N/A	CABLE GLAND PG7 IP68	1					
16	65.1.417	N/A	M5 x 25 SECURITY SCREW	4	51	75.109	N/A	GROMMET	1					
17	65.2.328	N/A	PLASTIC WASHER	4	52	71.101.22	6	GEARBOX ASSY (22:1)	1					
18	64.33	N/A	Contact FSL	1	53	65.1.334	N/A	M6 HEX HEAD SCREW	4					
19	64.31	N/A	Contact FSL	1	54	65.2-160	N/A	M6 PLAIN WASHER	4					
20	27.700	N/A	SAFETY SWITCH	1	55	71.027	2	BRACE LH	1					
21	65.1.167	N/A	M3 x 25 CHEESEHD	2	56	71.028	2	BRACE RH	1					
22	65.2.158	N/A	M3 WASHER	6	57	66.1.163	N/A	M4 x 10 BUTTON	12					
23	65.2.149	N/A	M3 WASHER, SPRING	4	58	71.012	5	MAIN DRIVE PULLEY	2					
24	65.3.156	N/A	M3 NUT	2	59	65.1.205	N/A	M4 x 8 SET SCREW	4					
25	65.1.398	N/A	M4 x 16 GRUB SCREW	1	60	65.2-202	N/A	M6 EXT FAN WASHER	1					
26	65.3.179	N/A	M4 NUT	1	61	65.3.157	N/A	M6 NUT, FULL	1					
27	65.1.271	N/A	M5x12 SKT CAP	8	62	67101016	5	OUTPUT GUIDE	2					
28	65.3.94	N/A	M5 NYLOCK NUT	4	63	71.030	2	BAG GUIDE (STD)	2					
29	75.292	N/A	FAN	1	64	65.1.216	N/A	M5 NUT	4					
30	65.1.338	N/A	M3 x 40 CHEESEHD	2	65	27.811	N/A	BLANKING PLUG, 30mm	1					
31	27.703	N/A	ISOLATOR SWITCH	1	66	75.123	N/A	NUT, PG9	1					
32	71.032	1	FAN DUCT R-L	1	67	75.122	N/A	HOLE PLUG, PG9	1					
33	71.003	1A	AIR DUCT CONNECTOR	1	68	67.319BL	5	BELT GUARD RH	1					
34	65.1.272	N/A	M6 x 10. BUTTON HEAD SCREW	9	69	67.320	6	BELT GUARD LH	1					
35	65.1.336	N/A	M6 x 20. BUTTON HEAD SCREW	1	70	71.084.3	1	PRESSURE SPRING, R-L	3					

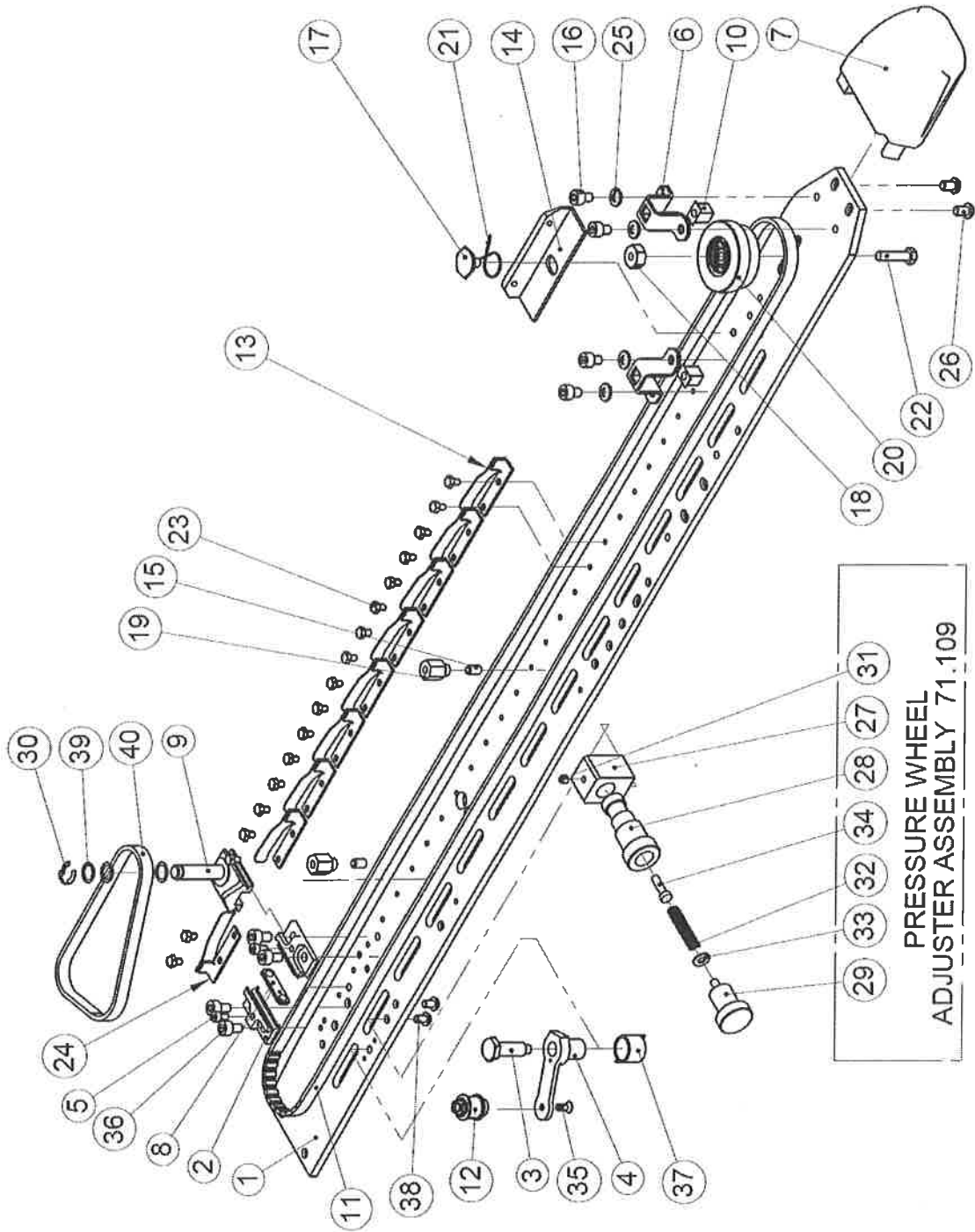
9.2 BOTTOM PLATE RH



BOTTOM PLATE RH PARTS LIST

ITEM	PART NO.	ISSUE	DESCRIPTION	QTY.	ITEM	PART NO.	ISSUE	DESCRIPTION	QTY.
1	71.080	6	BOTTOM PLATE, SAXON 1000 RH	1	28	66.177	1	SPRING LH	1
2	50.21	N/A	BELT, CARRYING	1	29	50.93	N/A	DRIVE BELT (140XL)	1
3	67.317BL	7	INFEED VEE MOULDING - RH SIDE	1	30	72.038	1	LOCATING DOWEL PIN	2
4	67.324	3	NUT, SPECIAL FOR TENSION PULLEYS	1					
5	71.091.1	1	INFEED PRESSURE PLATE (CS)	1					
6	67.361	3	ADJUSTER BODY	2					
7	67.382	N/A	TORSION SPRING	1					
8	67.2310	4	COLLAR STUD, SPRING MOUNT	1					
9	67.363	5	PLAIN PULLEY	1					
10	65.1.144	N/A	M6 x 10 GRUB SCREW	2					
11	65.1.168	N/A	M6 x 25 HEX HEAD SCREW	1					
12	65.1.272	N/A	M6 x 10, BUTTON HEAD SCREW	2					
13	65.1.241	N/A	M6 x 8 CAP HEAD SCREW	4					
14	67.330	N/A	DZUS RECEPTACLE	2					
15	67.316	3	BRACKET, BELT GUARD FASTENER	2					
16	71.085	4	REAR PRESSURE PLATE	1					
17	65.1.355	N/A	M4 x 8 HEX BOLT	4					
18	65.2.159	N/A	M4 WASHER	4					
19	65-2-160	N/A	M6 PLAIN WASHER	4					
20	71.067	2	PRESSURE WHEEL SHAFT FIXED (CS)	1					
21	65.5.229	1	10mm CIRCLIP	1					
22	65.1.381	N/A	M5x8, SKT BUTTON	2					
23	67830175	2	SHIM WASHER	3					
24	66.112	7	ARM, IDLER PULLEY	1					
25	65.1.265	N/A	SCREW, SKT CSK M4x8	1					
26	66.115	9	HINGE BOLT (Idler Pulley)	1					
27	66.116	8	TENSION PULLEY ASSEMBLY	1					

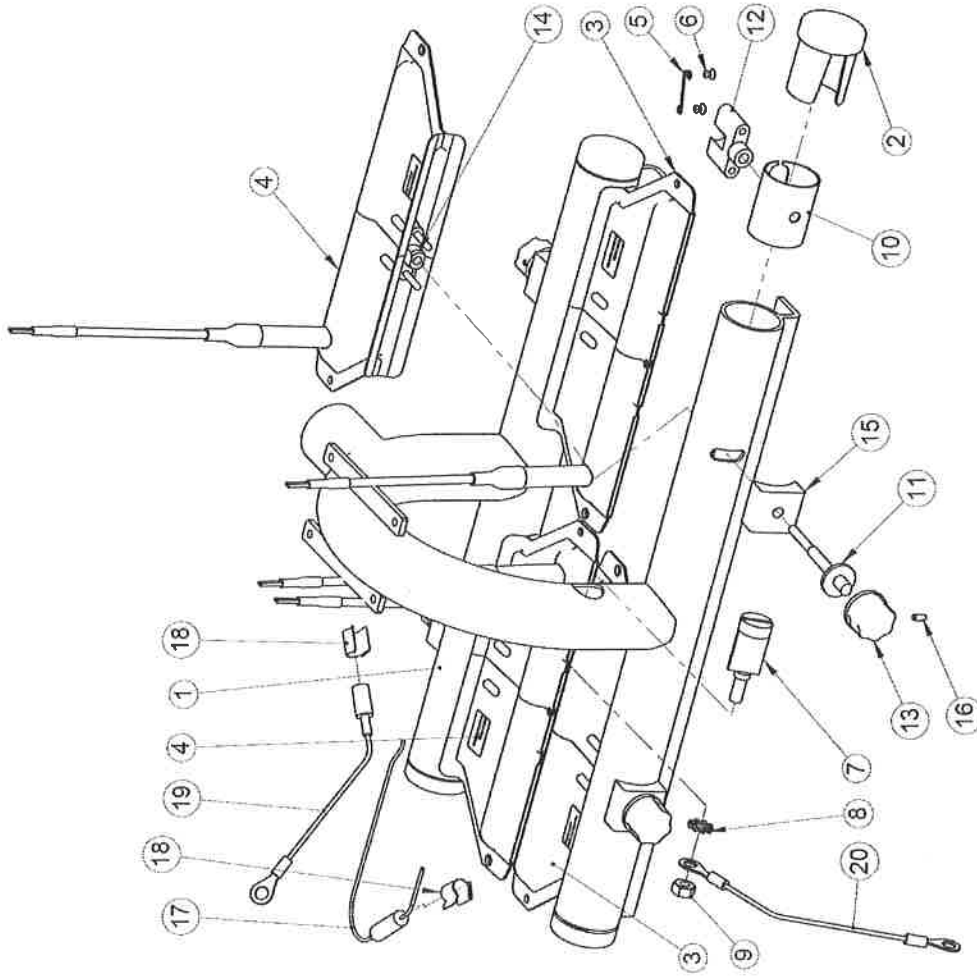
9.3 BOTTOM PLATE LH



BOTTOM PLATE LH PARTS LIST

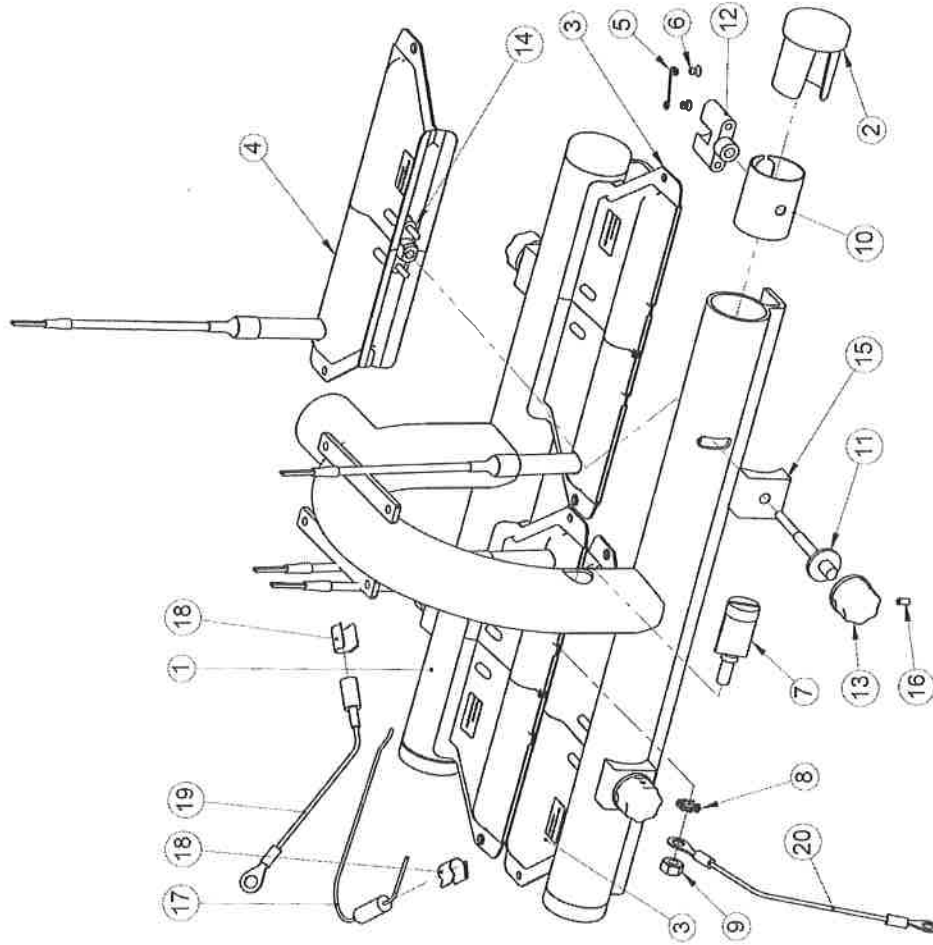
ITEM	PART NO.	ISSUE	DESCRIPTION	QTY.	ITEM	PART NO.	ISSUE	DESCRIPTION	QTY.
1	71.081	6	BOTTOM PLATE, SAXON 1000 LH	1	28	71.037	1A	ADJUSTER BODY	1
2	67.365	10	GUIDE BLOCK	2	29	71.036	1	ADJUSTER	1
3	66.115	9	HINGE BOLT (Idler Pulley)	1	30	65.5.229	1	10mm CIRCLIP	1
4	66.112	7	ARM, IDLER PULLEY	1	31	65.1.58	N/A	M5x5 ALLEN GRUB SCREW	1
5	65.1.258	N/A	M4 x 8, SKT CAP	2	32	71.041.2	1	SPRING, COMPRESSION	1
6	67.316	3	BRACKET, BELT GUARD FASTENER	2	33	71.040	1	ADJUSTER WASHER	1
7	67.318BL	7	INFEED VEE MOULDING - LH SIDE	1	34	71.039	1	ADJUSTER PIN	1
8	67.366	N/A	BALL CAGE	2	35	65.1.265	N/A	SCREW, SKT CSK M4x8	1
9	67.364	2	SHAFT & BLOCK ASSY SS CS	1	36	65.1.276	N/A	M6x10, SKT CAP	4
10	67.330	N/A	DZUS RECEPTACLE	2	37	67.325	1	SPRING RH	1
11	50.21	N/A	BELT, CARRYING	1	38	65.1.381	N/A	M5x8, SKT BUTTON	2
12	66.116	8	TENSION PULLEY ASSEMBLY	1	39	67830175	2	SHIM WASHER	3
13	71.084.3	1	PRESSURE SPRING, R-L	8	40	50.93	N/A	DRIVE BELT (140XL)	1
14	71.091.1	1	INFEED PRESSURE PLATE (CS)	1					
15	65.1.144	N/A	M6 x 10 GRUB SCREW	2					
16	65.1.241	N/A	M6 x 8 CAP HEAD SCREW	4					
17	67.2310	4	COLLAR STUD, SPRING MOUNT	1					
18	67.324	3	NUT, SPECIAL FOR TENSION PULLEYS	1					
19	67.361	3	ADJUSTER BODY	2					
20	67.363	5	PLAIN PULLEY	1					
21	67.382	N/A	TORSION SPRING	1					
22	65.1.168	N/A	M6 x 25 HEX HEAD SCREW	1					
23	65.1.440	N/A	M4 x 6 HEX BOLT	18					
24	71.284.3	1	PRESSURE SPRING, L-R	1					
25	65-2-160	N/A	M6 PLAIN WASHER	4					
26	65.1.272	N/A	M6 x 10, BUTTON HEAD SCREW	2					
27	71.038	1A	ADJUSTER BLOCK	1					

9.4 HEATER ASSEMBLY 240V



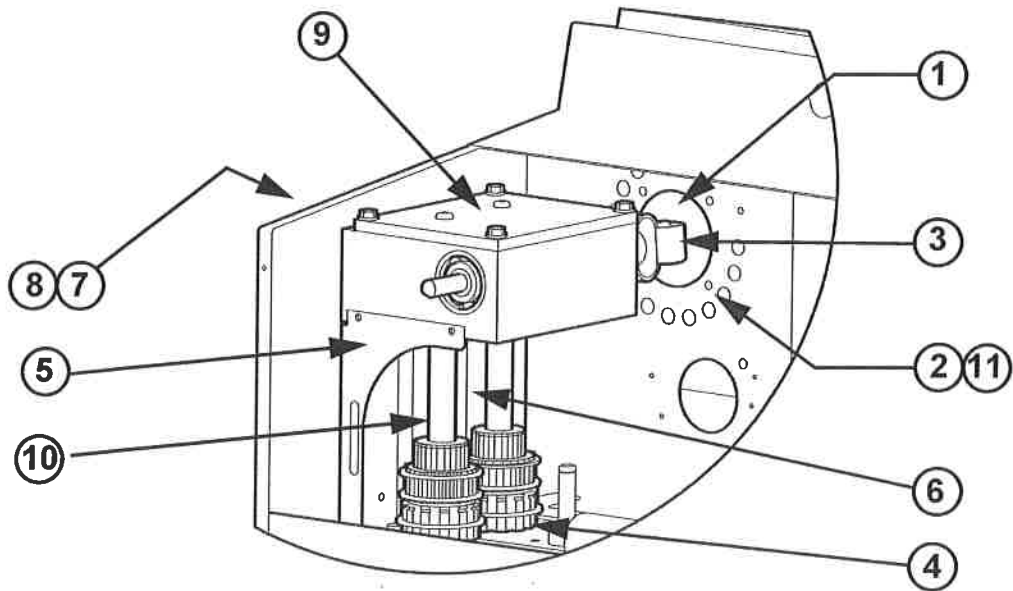
ITEM	PART NO.	ISSUE	DESCRIPTION	QTY.
1	71.105	4	AIR DUCT (2004)	1
2	67.405	1	MANIFOLD END CAP	4
3	71.108.1	1	HEATER CAPSULE RH, 240V	2
4	71.108.2	1	HEATER CAPSULE LH, 240V	2
5	67.408	N/A	DZUS SPRING	4
6	67.410	N/A	Rivet	8
7	67.415	7	VALVE, AIR DUCT	1
8	65-2-202	N/A	M6 EXT FAN WASHER	1
9	65.3.157	N/A	M6 NUT, FULL	1
10	67.401	8	INSULATING SLEEVE, AIR DUCT	4
11	67.402	10	SPINDLE CLAMP, HEATER CAP	4
12	67.406	8	CONNECTOR BODY (AIR DUCT)	4
13	67.403	N/A	KNOB	4
14	67.413	8	CONNECTOR BODY (CAPSULE)	4
15	67.404	9	SADDLE FOR CLAMPING SPINDLE	4
16	65.1.155	N/A	M3 x 6 GRUB SCREW	4
17	67.421.1	4	THERMOCOUPLE "K" TYPE PROBE 2.2Mtr	1
18	67.422	N/A	CABLE CLIP 8mm	2
19	67.115.1	N/A	EARTH STRAP	1
20	67.115.2	N/A	EARTH STRAP	1

9.5 HEATER ASSEMBLY 115V



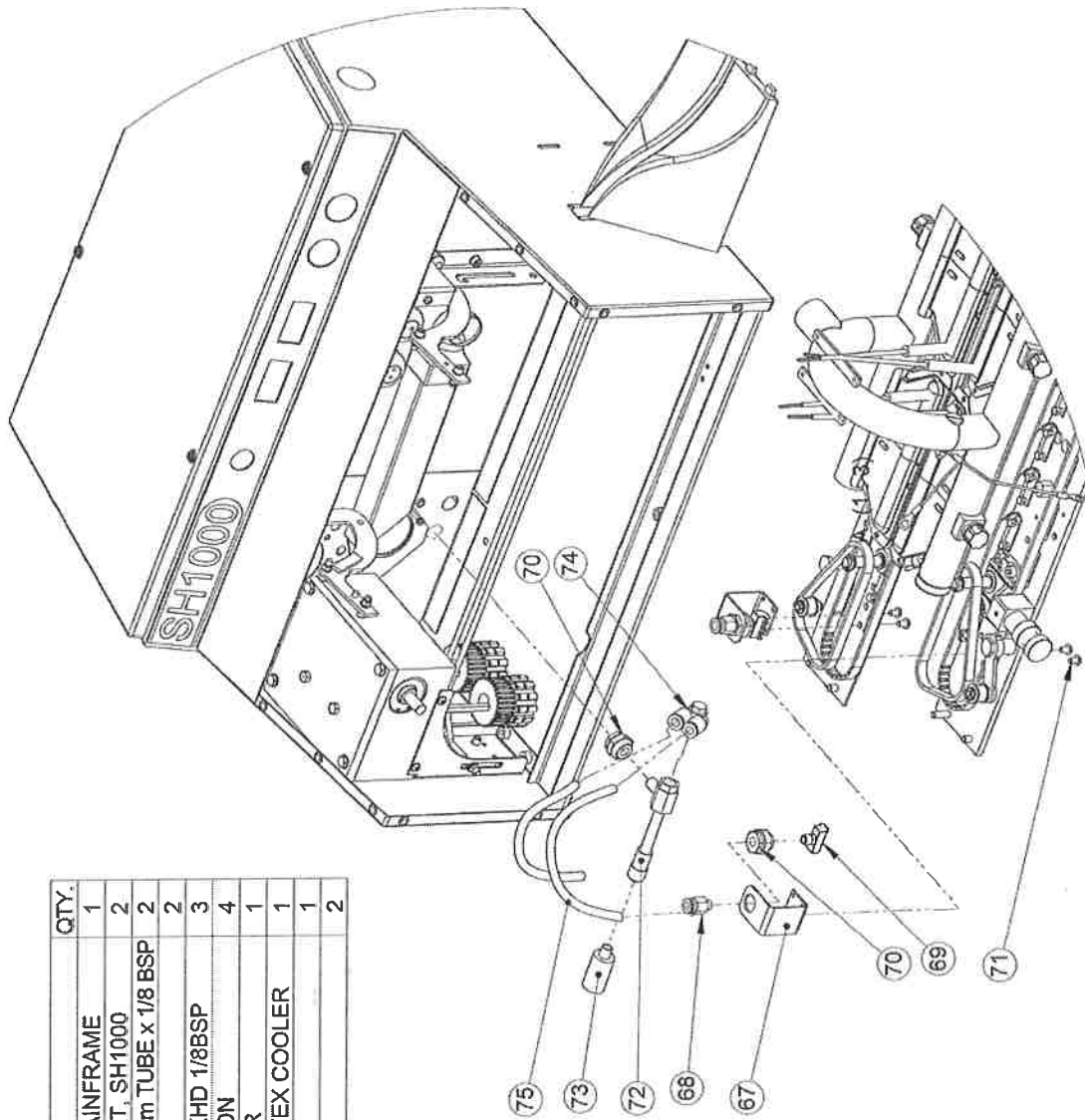
ITEM	PART NO.	ISSUE	DESCRIPTION	QTY.
1	71.105	4	AIR DUCT (2004)	1
2	67.405	1	MANIFOLD END CAP	4
3	71.107.1	2	HEATER CAPSULE RH, 115V	2
4	71.107.2	2	HEATER CAPSULE LH, 115V	2
5	67.409	N/A	DZUS SPRING	4
6	67.410	N/A	Rivet	8
7	67.415	7	VALVE, AIR DUCT	1
8	65-2-202	N/A	M6 EXT FAN WASHER	1
9	65.3.157	N/A	M6 NUT, FULL	1
10	67.401	8	INSULATING SLEEVE, AIR DUCT	4
11	67.402	10	SPINDLE CLAMP, HEATER CAP	4
12	67.406	8	CONNECTOR BODY (AIR DUCT)	4
13	67.403	N/A	KNOB	4
14	67.413	8	CONNECTOR BODY (CAPSULE)	4
15	67.404	9	SADDLE FOR CLAMPING SPINDLE	4
16	65.1.155	N/A	M3 x 6 GRUB SCREW	4
17	67.421.1	4	THERMOCOUPLE "K" TYPE PROBE 2.2Mtr	1
18	67.422	N/A	CABLE CLIP 8mm	2
19	67.115.1	N/A	EARTH STRAP	1
20	67.115.2	N/A	EARTH STRAP	1

9.6 MAIN DRIVE



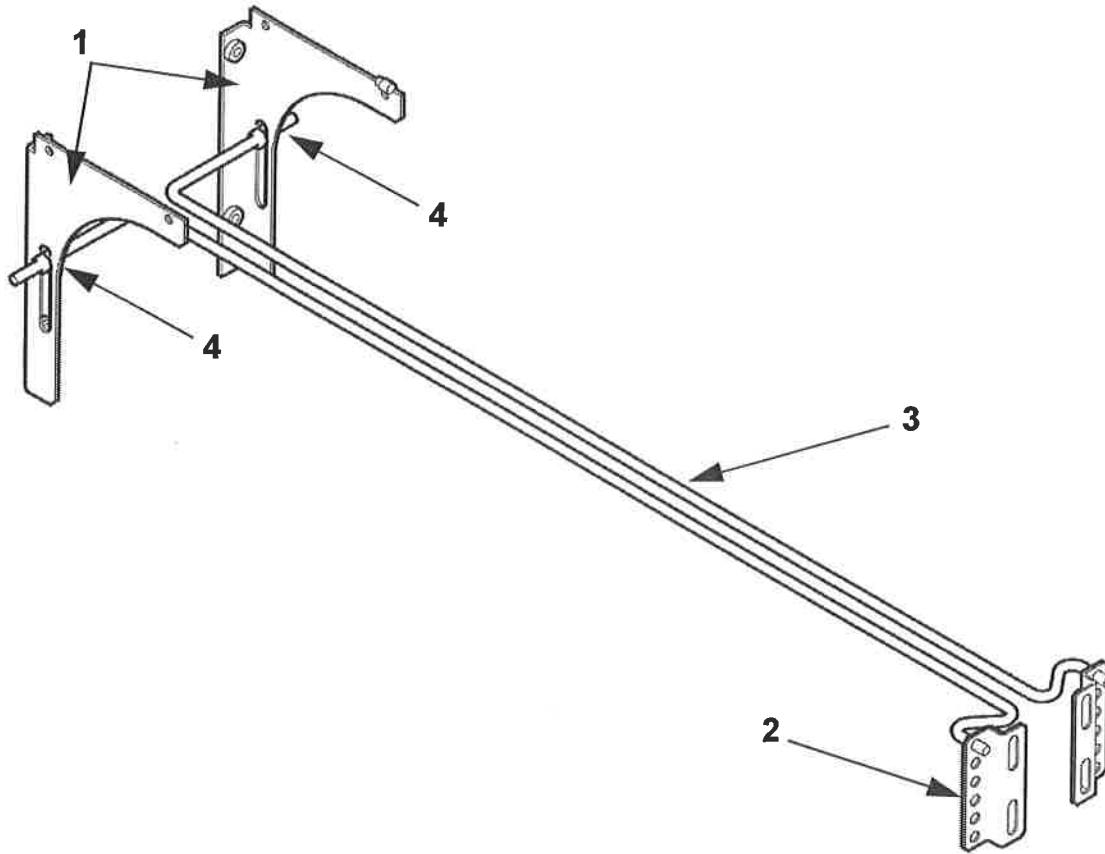
Item	Part No	Description	Quantity
1	12.200	Motor	1
2	65.1.296	M5X20 Skt Cap	4
3	71.023	Coupling	1
4	71.012	Drive Pulley	2
5	71.027	Gearbox Bracket LH	1
6	71.028	Gearbox Bracket RH	1
7	65.1.95	M6X15 Button	4
8	65.1.163	M4X10 Button	4
9	71.101	Gearbox	1
10	71.063	Key	2
11	65.2.251	M5 Washer	4

9.7 MAINFRAME ASSEMBLY WITH VORTEX



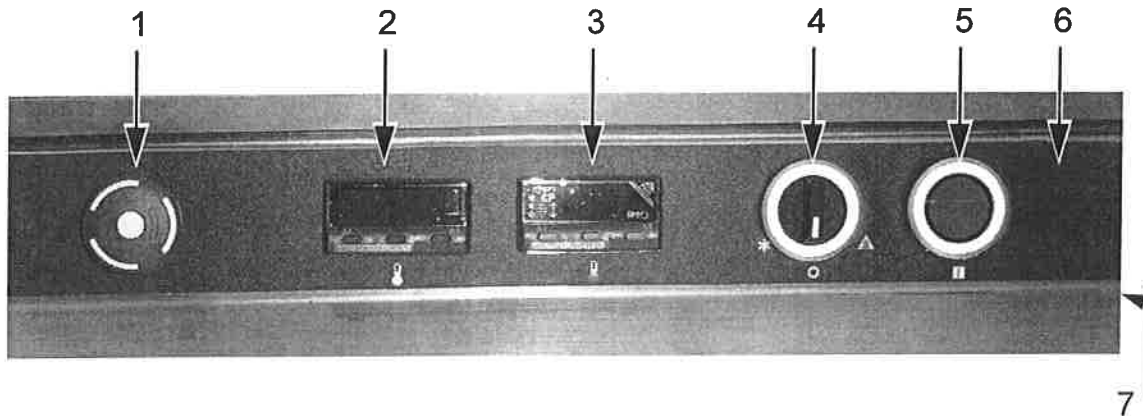
ITEM	PART NO.	ISSUE	DESCRIPTION	QTY.
2	71.002.5	1	SB1000 PLUS, MAINFRAME	1
67	71.159	2	NOZZLE BRACKET, SH1000	2
68	23.59		FITTING STUD, 8mm TUBE x 1/8 BSP	2
69	23.173	N/A	NOZZLE, 90 Deg	2
70	23.17	N/A	COUPLING, BULKHD 1/8BSP	3
71	65.1.381	N/A	M5x8, SKT BUTTON	4
72	23.171	N/A	VORTEX COOLER	1
73	23.172	N/A	SILENCER, VORTEX COOLER	1
74	23.501	N/A	TWIN BANJO	1
75	23.62	N/A	8mm TUBE	2

9.8 BAG GUIDE



Item	Part No	Description	Quantity
1	—	Gearbox Bracket	—
2	—	Bracket inside Mainframe	—
3	71.030	Bag Guide	2
4	65.3.157	M6 Nuts	4

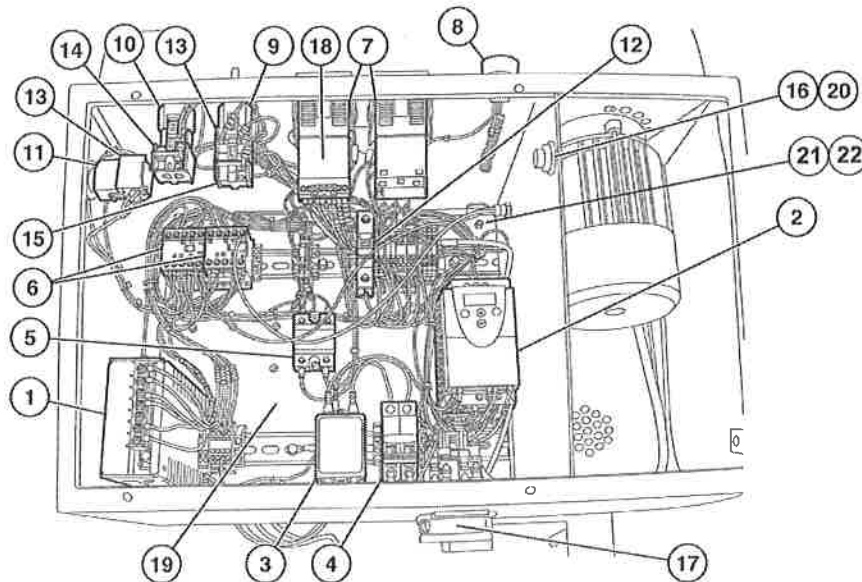
9.9 CONTROL PANEL



Item	Part No	Description
1	27.809	E Stop
2	27.913.3	PID Controller
3	27.913.3	PID Controller (<i>SEE NOTE</i>)
4	27.801	Cool/Off/Seal
5	27.800	On switch
6	27.315.4	Speed (if fitted externally)
7	27.802	Column Switch (if fitted)

NOTE If only one Thermocouple is fitted, PID 'C' will be a dummy (27.91.3.1) and will not show any display.

9.10 REAR HOUSING



Item	Part No	Description	Quantity
1	27.701	Power Supply	1
2	27.706	Inverter – Altival II (240v)	1
	27.707	Inverter – Lenze (230v)	1
	27.708	Inverter – Lenze (115v)	1
3	27.914	Filter 20A	1
4	27.705	MCB 10A	1
5	67.908.3	SSR	Quantity dependant on M/C type
6	27.199	Contactor	
7	27.913.3	PID	
8	27.809	E Stop	1
9	27.801	Cool – Off Seal	1
10	27.800	On Button	1
11	27.802	Column Switch	1
		(only when sealer is mounted on the column)	
12	27.704	MCB1A	1
13	27.805	N/o Contact Block	2
14	27.803	N/o Contact Block	1
15	27.804	N.c Contact Block	1
16	27.315.4	Potentiometer Mounting (when fitted internally)	1
17	27.703	Isolator Switch	1
18	27.913.1	PID Blank	1
19	71.035	Chassis Plate	1
20	27.315.3	Potentiometer, Speed Control (when fitted internally)	1
21	65.1.270	M5X10 Skt Screw	4
22	65.2.251	M5 Washer	4

9.11 RECOMMENDED SPARES LIST

9.11.1 6-12 Months Routine Maintenance

Part No	Description	Quantity
50.7	Belt Drive	2
67.421	Thermocouple	1
71.106.1	Heating Capsule RH	1
71.106.2	Heating Capsule LH	1
67.908.3	Solid State Relay	1
27.913.2	PID Controller	1
67.355	Pressure Plate	2
50.21	Belt Carrying	2
71.012	Drive Pulley	2

9.11.2 12 Months + Routine Maintenance

As for 6-12 months plus the following:

Part No	Description	Quantity
71.084.1	Pressure Spring	10
71.090	Rear Pressure Plate	1
75.292	Fan	1
27.701	Power Supply	1
71.023	Coupling	1
67.366	Ball Cage	2
65.5.229	Clip	2
67.363	In Feed Pulley	2
27.808	Bulb	1
12.200	Motor	1
27.700	Safety Switch	1
27.704	1A MCB	1
27.705	10A MCB	1
71.063	Drive Shaft Key	2

NOTE: This spares list is a recommendation only, and not all spares would be required by the customer. It would depend upon the usage and operating condition of the machines.

9.12 ELECTRICAL SCHEMATIC

For wiring diagram use K2K1M000.

9.13 SAFELY DISPOSING OF AN FSL SEALER

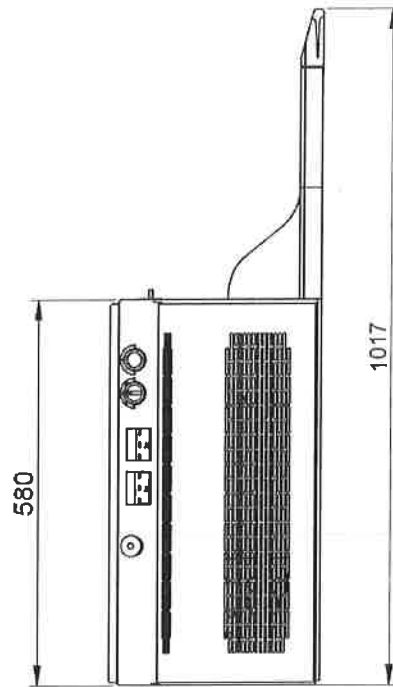
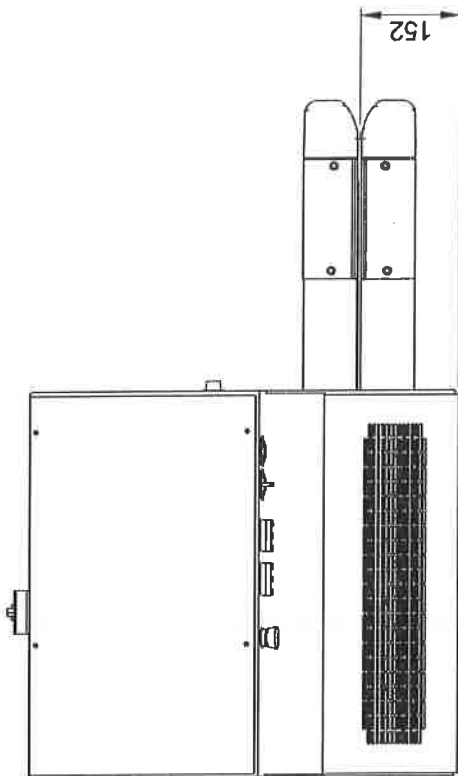
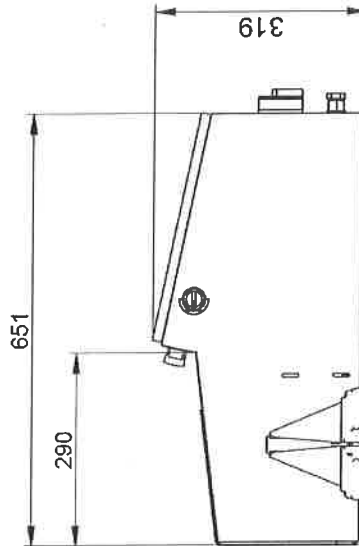
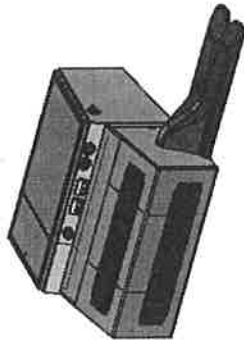
If the SEALER becomes damaged beyond repair, or simply worn to a non-functional state after years of service, it should be put out of service only after it is safe to dispose of it.

First, remove all lubricants from the machine. Dispose of the lubricants according to your appropriate local environmental regulations.

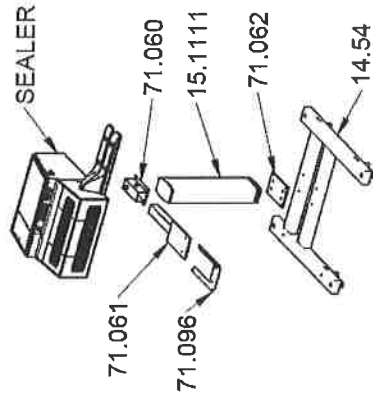
After the lubricants and belts have been properly disposed of, take the system to an appropriate recycling centre or scrap metal facility.

10 MACHINE LAYOUTS

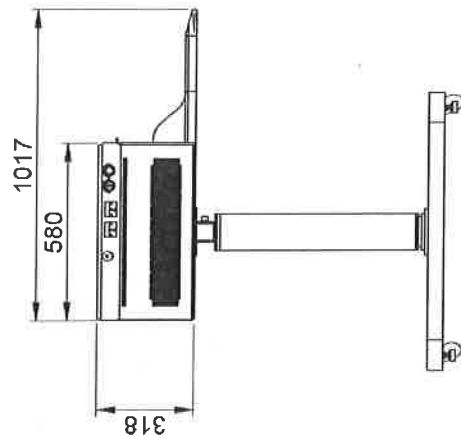
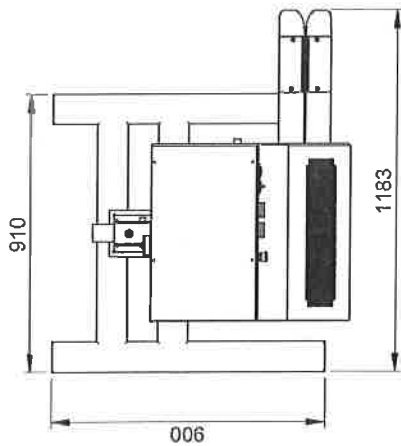
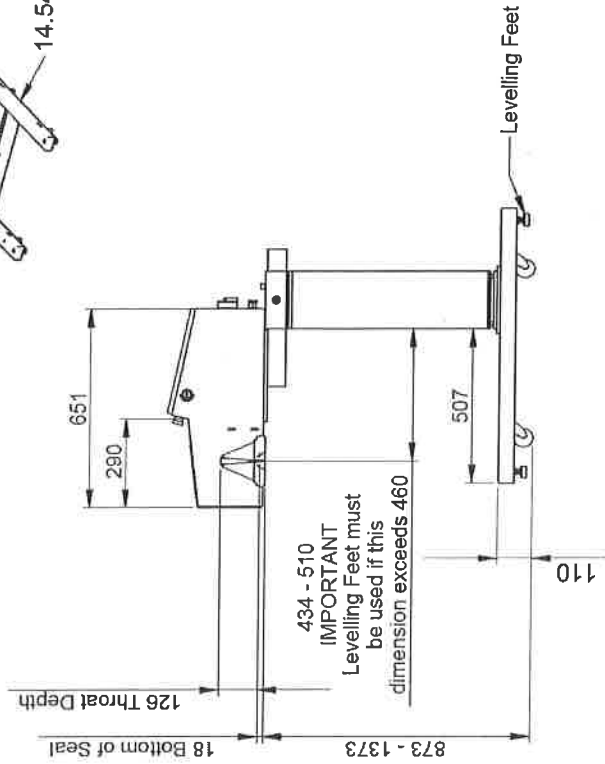
10.1 HEAD UNIT - RIGHT TO LEFT FEED



10.2 PEDESTAL UNIT - WITH EXTENSION ARM, RIGHT TO LEFT FEED



IMPORTANT SAFETY NOTE:
 When moving the Sealer on its Trolley, the Extension Arm (71.061) must be fully closed into Mounting Plate (71.060). Also, the Column (15.1111) should be fully closed down.



10.3 1000 SERIES TROLLEY UNIT

