HEAT SEALER MAINTENANCE SCHEDULE		LIGHT DUTY				EXTREME DUTY			
	FREQUENCY IN HOURS					FREQUENCY IN HOURS			
OPERATION	8	40	160	1040		8	40	80	520
Remove and inspect sealing belts (replace if torn/damaged)	X					X			
Clean front sealing belt rollers (use 70-91% isopropyl alcohol and a clean, lint-free cloth)	X					X			
Clean orange silicone rollers (use 70-91% isopropyl alcohol and a clean, lint-free cloth)	X					X			
Clean sealing belt drive rollers (use 70-91% isopropyl alcohol and a clean, lint-free cloth)	X					X			
Clean drive rollers help extend seal belt life									
3M Scotchbrite may be used to remove stubborn deposits from									
Do not use a sharp blade or instrument to scrape roller surface									
Clean the belt contact surfaces of the heating and cooling bars (use 70-91% alcohol and a clean, lint-free cloth)	X					X			
3M Scotchbrite may be used to remove stubborn deposits from heating and cooling bars									
Never use blades or sharp instruments on heating or cooling bar surfaces									
Clean the top contact surfaces (bar to bar contact point) of the heating and cooling bars (use 70-91% alcohol and a clean, lint-free cloth)	X					X			
3M Scotchbrite may be used to remove stubborn deposits from heating and cooling bars									
Never use blades or sharp instruments on heating or cooling bar surfaces									
Check for and remove any debris in timing belts and pulleys.	X					X			
Debris caught in belts and/or pulleys will stretch the timing belt, resulting in failure									
With sealer operating, check cooling fan is operational. Repair or replace as needed		X					X		
Clean the windows of all optical sensors used on the sealer.		X					X		
Use a soft dry cloth only									
Check seal belts are centered on the width of the idler and drive pulleys (with sealer operating)		X					X		
Adjust idler roller pivots to center belt on pulleys and restore proper belt tracking									
(Adjust slowly. A small change in roller pivot can greatly affect belt tracking)									

HEAT SEALER MAINTENANCE SCHEDULE		LIGHT DUTY				EXTREME DUTY		
	FREQUENCY IN HOURS				FREQUENCY IN HOURS			
OPERATION	8	40	160	1040	8	40	80	520
Clean belt cleaning brushes (if equipped)		X				X		
Use a vacuum in cleanroom operations								
Compressed air may be used if sealer is not in a cleanroom environment								
Check sealer cover plug and socket for damage. Replace as needed		X				X		
Check sealer drive timing belts for proper tension.		X				X		
Proper tension is 0.5” total deflection at mid-point betweenthe longest span between pulleys with moderate force applied to belts								
Check orange silicone roller bearings rotate freely. Do not lubricate, replace if bearings are not rotating freely.		X				X		
Check motor speed proximity sensor (if equipped) at motor drive assembly			X				X	
Check all raised screws on the driven gear are tightened firmly			X				X	
Check the gap between the raised screws and motor speed sensor head (if equipped) is approximately 1/16”.			X				X	
Check motor speed sensor locknuts (if equipped) are tight			X				X	
Check front heating bar pivots operate smoothly.			X				X	
Do not lubricate.								
Disassemble and clean pivot studs and bushings with green 3M Scotchbrite if needed								
Check front cooling bar pivots operate smoothly			X				X	
Do not lubricate.								
Disassemble and clean pivot studs and bushings with green 3M Scotchbrite if needed								
Check the white plastic timing belt tensioning pulley bolts are hand tight			X				X	
Check the white plastic timing belt tensioning pulleys rotate freely.			X				X	
Disassemble and lubricate with a small amount of white lithium grease if needed.								
Check rear seal belt idler pulley pivots.			X				X	
Pivot moves only 0.250” total travel								
Repair or replace components as needed to ensure smooth pivot operation								

HEAT SEALER MAINTENANCE SCHEDULE		LIGHT DUTY				EXTREME DUTY			
	FREQUENCY IN HOURS					FREQUENCY IN HOURS			
OPERATION	8	40	160	1040		8	40	80	520
Check all fasteners, bolts, nuts, screws are tight				X					X
Check the seal height mechanism operates freely.				X					X
A small amount of white lithium grease may be used to lubricate lift mechanism if needed.									
Replace orange silicone rollers and bearings.				X					X
Do not reuse old bearings									
Remove white plastic timing belt tensioners and check bottom flange for wear.				X					X
When roller wears out, the bottom surface will contact bottom plate of sealer. If the plating is worn beneath roller, replace roller and lubricate tensioner with greater frequency.									