Operating and Maintenance Instructions





cap. 1	preface 2
1•1 1•2	symbols
cap. 2	unit description
2•1 2•2 2•3	specifications6unit objectives8unit operation9
cap. 3	safety
3•1 3•2 3•3 3•4	reference norms13valid norms for all products13noise15expected, unexpected and incorrect uses of the unit15
cap. 4	packaging & delivery
4•1 4•2 4•3	unit packing16unit transport and handling17unpacking18
cap. 5	installation
5•1 5•2	choice of location and placement
cap. 6	starting 24
6•1 6•1•1 6•1•2 6•2 6•3 6•4 6•5	preliminary checks24stability check24electric connection24control panel setting25work cycle27changing the film roll29Problems, causes and solutions31
cap. 7	maintenance
7•1 7•2	routine maintenance



cap. 8	demolition
8•1	unit demolition
cap. 9	unit spare parts
9•1 9•2 9•3	how to order spare parts38exploded views40spare parts list42
cap. 10	technical schema
10•1 10•1•1	electrical diagram
cap. 11	mold
11•1 11•2 11•3 11•4 11•5 11•6	how to order a spare parts mold.48changing the mold49mold 137x185mm expl.view52mold - Ø165 mm expl.view53mold 137x185mm spare parts list54mold Ø 165 mm spare parts list56
cap. 12	EC declaration of conformity



Fig. 1	machine assembly view 6
Fig. 2	Front and plan view7
Fig. 3	Power up
Fig. 4	Thermoregulator
Fig. 5	Timer
Fig. 6	changing the film roll 1 29
Fig. 7	changing the film roll 2 30
Fig. 8	film holder rolls
Fig. 9	front cover
Fig. 10	interior view
Fig. 11	General exploded view 40
Fig. 12	machine exploded view 41
Fig. 13	Changing the mold 1 49
Fig. 14	Changing the mold 2 49
Fig. 15	Changing the mold 3 50
Fig. 16	Changing the mold 4
Fig. 17	Changing the mold 5 51



Dear Customer,

Thank you for purchasing our Reeseal tray-sealing machine.

This model is designed to package any type of food product that requires a hermetically sealed plastic container. It ensures that the package will be attractive and hygienic.

Particular importance was given to the design of the unit so that only minor maintenance is needed with spare parts easily replaced by the user.

Before using the unit, please read this manual carefully to ensure long life and best results of the unit.

Reepack srl



All Reepack documentation uses the following symbols and words to highlight important parts of the text.

note

1•1

symbols



Text with this symbol indicates comments, additional notes or interesting information.

caution



TEXT WITH THIS SYMBOL INDICATES THAT IF WARNING INSTRUCTIONS ARE NOT FOLLOWED, THE RESULT COULD BE DAMAGE TO THE EQUIPMENT OR LOSS OF INFORMATION.

warning



Text with this symbol indicates that if warning instructions are not followed, the result could be physical injury or even death.

prohibited



Text with this symbol indicates that it is not possible to carry out that type of operation

caution electrical voltage



TEXT WITH THIS SYMBOL INDICATES THAT THERE'S DANGER OF ELECTROCUTION RESULTING IN DEATH. PROCEED WITH CAUTION TO AVOID PERSONAL HARM.



1•2 service information

Reepack guarantees for a period of one year after date of purchase that this product is free of material and manufacture defects. To see in detail our conditions of guarantee (cap.11).

In the event the unit malfunctions during the warranty period, Reepack or any Authorized Service Center will repair this product with parts free of charge, except where specified in the contractual conditions.



For service, maintenance or repair of the unit or any of its components, whether within the warranty period or not, contact only the manufacturer or an Authorized Service Center. The address and telephone number of the manufacturer are also shown on the identification plate of the unit:

Manufacture:	Reepack s.r.l.
Address:	via dell'Artigianato, 19
city:	I - 24068 Seriate (BG)
telephone:	+39 035 2924911
fax :	+39 035 2922891
E-mail commercial Dpt.:	reepack@reepack.com
E-mail technical Dpt.:	tech_automazione@reepack.com



Ask the manufacturer for an Authorized Service Center nearest you.



REEPACK DECLINES ALL RESPONSIBILITY FROM DAMAGES TO PERSONS OR THINGS DUE TO SERVICING ON THE UNIT BY NON-AUTHORIZED PERSONNEL.





2•1 specifications



Fig. 1 machine assembly view

• The unit structure is made completely of stainless steel. The film roll is on the top of the structure for ease of turning. The film roll is inserted from in front of the unit. In this way the film is inserted inside the machine automatically when the tray seat plate is inserted.

• The materials used ensure little component wear either during use or frequent cleaning.

• The unit always consists of one or more sealing tools for sealing trays of various forms and sizes.

• The ease of changing tray sealing tools makes using the unit extremely flexible especially in companies where production output is important and diversified with different tray size and forms.

• A large quantity of food products can be packaged with this machine either for immediate distribution or further thermal treatment such as freezing, pasteurization, etc.





Fig. 2 Front and plan view







dati tecnici	technical data	technische daten	donnés techniques	ReeSeal 32 SX
Dimensioni totali	Overall dimensions	Abmessung der Maschine	Dimensions de la machine	465 x 495 x 500 mm.
Peso totale	Approx. weigh	Gewicht	Poids	70 kg ca
Max dimensione vaschetta	Max tray dimensions, ext.	Max AbmessungenSchale	Dimensions maxi de la barquette	380 x 280 mm
Max diametro bobina film	Max diameter of web roll	Maximale Durchmesser Folierolle	Diamètre maxi de la bobine film	200 mm.
Max larghezza film sigillatura	Max width of top web	Durch. des Folienaufnahmedorms	Laize maxi du film d'operuculage	380 mm.
Alimentazione elettrica	Electrical supply	Elektrischer Anschluss	Raccordement èlectrique	1/N/PE 230V AC 50-60 Hz
Assorbimento	Power consumption	Stromrerbrauch	Puissance électrique	1000 W

2•2 unit objectives

The Reeseal 32 thermal sealer unit was designed to satisfy the needs of medium size cafeterias, food processing facilities and the like.

The tray sealer hermetically seals special plastic containers containing a wide range of products using a flexible film

The sealing film must be in roll form and, like the trays, must be of a material suitable for sealing. The trays and film must be compatible to each other as well.



Ask for related material specifications from the material suppliers.ai materiali al fornitore degli stessi.



2•3 unit operation

The unit is divided into two parts. The lower part contains the tray to be packaged and the upper part contains everything necessary for the sealing operation.

The packaging cycle is divided into 4 phases:

• 1. Insertion of the tray (or trays) into its seat.

The product to be packaged is placed in an appropriately sized tray, which in turn is placed in the tray seat plate.





• 2. Tray tool insertion with film

The tray seat plate is pushed inside the unit which positions it with the sealing tool and at the same time drags the film over the trays for sealing. The green light on the panel switches off.



• 3. Tray sealing

After the tray seat plate is locked in by the special stops, the sealing tool is electrical pushed against it and carries out the thermal sealing process.



• 4. End of cycle

After a predetermined time set by timer, green light switches on and the sealing tool separates from the tray seat plate. The tray seat plate is then extracted from the unit. The sealed trays may now be removed from the tray seat plate.





The Reepack products were made guaranteeing a safe operation provided that they are installed and used in conformance with the instructions in this manual and to the more general norms of safety in the workplace as described in the European Directive 2006/42/EEC.

This manual is considered an integral part of the supply and it is the responsibility of the buyer:



To keep the manual in good condition and, if possible to keep it close to the unit.



To request a copy from the manufacturer in case of loss or damage.



Λ

To ensure that specialized personnel who service the machine read the parts of the manual that apply to their field of competence.

To ensure that the manual is completely read by the operator who is to use the unit.

The manufacturer declines all responsibility for any damages caused by improper use of the machine. Further, improper use of the machine may result in personal injuries or loss of life as well as damages to the machine and the surronding premises.



3•1 reference norms

Reepack products are made in conformance with the following norms:

- 2006/42/EEC and successive modifications related to unit safety.
- CEI EN 60204-1:2006 related to unit electrical equipment.
- 2004/108/CEE related to electromagnetic phenomenon.
- UNI EN 294 related to safety distance for upper limbs.
- UNI EN 349 related to minimum space to avoid crushing body parts.
- UNI EN 563 related to exposed surface temperatures.

3•2

valid norms for all products

The following is a list of general indications of good practice not directly tied to the use of the unit, but useful to those who install and use the unit.

• Pay attention to warnings:

all warnings placed on the product or shown in the documentation must be read with care.

• Follow instructions:

it is important to follow all furnished instructions.

• Installation:

do not place the unit on an unstable surface. The product could fall and injure personnel or the unit itself.

For product location follow instructions in section 5-1.

• Water and humidity:

do not operate the unit near water or in high humid environments.

The unit is to be used in a closed environment.

• Products connected to ground (only in case of monofase connection):

some machines are equipped with 3-wire plugs for grounding. This plug can only be inserted in an adequate socket. This is a safety specification. If it is not possible to insert the plug into the socket, contact an electrician to replace the socket. The plug must be installed with the ground wire.

• Protection of the power supply cable:

the power supply cables must be placed so as not to be stepped on or bent.

Be particularly careful of plugs, sockets and the places where the cables come out of the unit.



• Extension cord:

when using an extension cord or connection socket, ensure that current strength of the products attached to the cable is not more than that rated for the extension cord.

• Cleaning:

disconnect the unit from the electrical socket before cleaning.

• Heat:

the unit must be placed away from heat sources such as radiators, regulation valves, stoves, etc.

• Maintenance:

except in described cases, avoid carrying out maintenance operations. Opening or

removing covers marked with the symbol 2 can mean exposure to high voltage and other risks. To carry out service operations in these compartments, contact an Authorized Technician.

• Spare parts:

if a spare part is necessary, check that it is one recommended by the manufacturer. Non authorized replacements can be extremely risky.

• Object insertion:

never insert objects in unit openings. Contact with high voltage parts or short circuits can cause fires or electric shocks. The same risks exist when coming into contact with mechanical parts that can cause physical injury.



3•3

noise

The noise produced by this machine was measured by the manufacturer on an identical machine and was given the following result:

Level of continuous acoustic pressure is equivalent to an A rating which is inferior to 70 dB(A).

3•4 expected, unexpected and incorrect uses of the unit • The unit was designed to operate in a horizontal position protected from air contaminants at a temperature within 5 to 40 °C.

• The workstation of the operator is in front of the unit at the control panel. From this position it is possible to insert the tray to be packaged, remove the packaged tray and change the packaging parameters.

• Machine is suitable to pack food products. Otherwise no food products can be packed after testing from the machine manufacturer.

• The packaging unit is designed for packaging products inside plastic trays suitable for maintaining vacuum and for being sealed by heat pressure.

• Machine must be operated under supervision of specialized employee.

The maximum temperature reached by the sealing plate is 200 °C. It is the responsibility of the operator to check the safety and suitability of the trays with the tray supplier. The trays must be suitable for thermosealing cannot be flammable nor can they produce toxic substances.



THE PRODUCTS TO BE PACKAGED MUST NOT HAVE SHARP PARTS THAT MAY PUNCTURE THE PACKAGING AND CAUSE THE PRODUCT TO DETERIORATE WITH TIME. THE PRODUCT CAN ALSO BE LIQUID BUT IN THIS CASE THE DEGREE OF VACUUM MUST BE CHOSEN CAREFULLY SO AS NOT TO CAUSE OVERBOILING BY THE PRODUCT.

It is not possible to package flammable or explosive products or canisters with gas under pressure because this could be detrimental to the health of the operator.

Follow safety indications for the different machine utilization phases shown in each related chapter.



4•1 unit packing

In order to transport the unit under safe conditions it must be packaged correctly. The recommended way used by the manufacturer from the factory consists of the following 4 phases:



ALWAYS KEEP THE UNIT IN A HORIZONTAL POSITION.

• **1st** Place the machine on the specially-constructed pallet provided with machine supports.

• 2nd Place the special packing carton around the unit leaving the bottom part open.

• **3th** Insert sufficiently rigid packing material between the unit and the packing carton walls to stop any movement in case of jerks or tipping over of the pallet. Place the packing material over the unit and fill the packing carton.

• 4th Close the upper part of the packing carton using adhesive tape.



4•2 unit transport and handling

After packaging the unit as described in the previous paragraph, it can be moved by forklift only. There are no attachment points to lift it from above.

The unit weight is indicated in paragraph 2.1





The air temperature during transport and any intermediate storage must be maintained between a minimum of -25 °C and a maximum of 55 °C.



Do not lift the unit by the packing bands.



4•3 Unpacking the unit is divided into the following phases: **unpacking**



ALWAYS KEEP THE UNIT IN A HORIZONTAL POSITION.

• **1st** Bring the still packaged unit as close to the place of installation as possible (see the sections 5 / 5-1 for choice of location).

- 2nd Cut the packing bands.
- 3th Open the packing carton and remove the packing material.
- 4th Slip the packing carton up and off of the unit
- **5th** Lift the unit from the transport pallet using a forklift or other lifting means adequate to the dimension and weight of the unit, and rest it on the ground.

• 6th Save the material if unit packaging will be required again. If not, dispose of the material according to local disposal laws.





5-1 choice of location and placement



The choice of unit installation location must take into account the following 4 important:

• 1st Operator safety is of prime importance in the workplace.

As regards this aspect, refer to local regulations in effect and to directive CEE 89/391 regarding the safety and health of workers on the job.

• 2nd Operator safety, specifically in the use or maintenance of the unit.

Even though the unit has been designed to respect the safety and health of the operator during the unit's use and to permit the operator to work under ergonomic conditions, keep in mind the following points:

The noise produced by the unit is kept at the lowest level possible. It is compatible with the current technology and is below the maximum values allowed by the standard. However, it is best if the unit is placed in a location with ample space and reverberating walls so as to "accumulate" the noise within the unit's

The unit does not have its own lighting. Therefore it is the responsibility of the buyer to place the unit in a location with appropriate lighting, especially with regards to maintenance operations.



• 3rd Unit operation and storage.

The unit is designed to be operated and stored in a closed environment protected from air contaminates.

The unit's supporting surface must be flat and level.

The unit has been designed to operate at ambient temperatures of +8 $^\circ\text{C}$ minimum and +40 $^\circ\text{C}$ maximum.

The unit has been designed to operate at values of relative humidity below 90% at 20 $^{\circ}C$ or 50% at 40 $^{\circ}C.$

The unit has been designed to operate in environments of average corrosiveness.



The unit has not been designed to operate in explosive or flammable environments.

While operating, the unit gives off a certain amount of heat. For this reason the unit is equipped with air vents that allow the cooling of the unit's interior. The air vents are generally located on the rear panel. Do not place the vented side of the unit too close to a wall. Do not allow heated air to blow on this side of the unit.

• 4th Recommended type of production.

Buyer production requirements and the way to attain them are completely at the discretion of the user as long as the preceding points are respected .



ALWAYS KEEP THE UNIT IN A HORIZONTAL POSITION.



After choosing the installation location according to the preceding points, position the unit using a suitable lifting device being careful to not crush fingers. The unit is equipped with anti-skid feet that ensure stability once in position.



Danger of crushing fingers. Always lift the unit whenever moving it. Never try to slide it.



5•2 electrical connections



Contact your local electric company for more information on installation norms for different products. For more information, consult the documentation furnished with the unit or contact an Authorized Reepack Retailer.



The unit comes furnished with a cable to connect to the electrical power supply.



Furnish a magnetothermic switch of adequate calibration between the unit and the power source.



A qualified electrical technician must carry out the following operations.

Make the electrical connections as follows:

A Check that the electrical data (voltage, frequency, power) shown on the unit's identification plate are compatible with the electrical power supply.

B Check that the switch placed beside the unit's electrical outlet is in the off position .

C Connect the cable furnished with the unit to the electrical power supply socket.





6•1 preliminary checks



Before switching on the machine, check the following:

- 6•1•1 stability check
- A Make sure that the anti-slip feet are resting securely on the floor.
- **B** Make sure that levelness is same for all the parts of the machine.

6•1•2 electric connection

A Ensure that the machine is connected to the electrical power supply.

B Check that the electrical data (voltage, frequency and power) on the machine identification plate correspond to those of the electrical power supply.

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MOD.	mo	del	11
S/N	seri	al n.	5
[voltage	frequency	-Year
	phases	current	Anno



6•2 control panel setting

1st Turn the unit on by turning main switch SP to position I.

Fig. 3 Power up



2nd Check that the film roll is not finished and that the film is positioned correctly, otherwise proceed as described in the following section "Changing the film roll".



Ask for information about materials and their related specifications from the material manufacturers



3rd Set the thermoregulator to the appropriate temperature following the specifications for the material used.



Fig. 4 Thermoregulator

Key "P": This is used to access the programming parameters and to confirm selection.



To set the thermoregulator and the timer see the relative run books enclosed.

4th Set the sealing time as a function of the set temperature and the material used.

Fig. 5 Timer





6∙3 work cycle	The operations described in this chapter presume that the operations in the section "Preliminary checks and setting the cycle" have already been carried out.
	 1 Turn the unit on by turning the main switch (I/0) to position I.
	• 2 Check that the film roll is not finished and that the film is positioned correctly, and then proceed as follows.
	• 3 Insert the tray (or trays) in the tray seat plate.
(!)	THE PRODUCT CONTAINED IN THE TRAY MUST NOT BE HIGHER THAN THE EDGE OF THE TRAY.
(!)	THE EDGES OF THE TRAY MUST NOT BE EXCESSIVELY DIRTY WITH LIQUIDS OR DEPOSITS BECAUSE THIS COULD AFFECT THE MAKING OF A GOOD SEAL.
V	Never insert the tray seat plate without a tray inserted in it or without film.

• **4** Push the tray seat plate all the way inside the unit until it reaches the mechanical stop. The unit will start operation and the timer indicator will light up.





• 5 When the indicator turns off, remove the tray seat by pulling on its handle. Remove the trays from the tray seat plate.



DO NOT TOUCH THE MAGNATE-CARRYING PLATE. THERE IS A DANGER OF BEING BURNED.

• 6 Bring the tray seat into contact with the magnates so that the film is locked between them and ready for the next packaging cycle. (If this operation is delayed there is a risk that the film will curl and will have to be repositioned manually over the magnates).

- •7 Repeat operations 3 to 7 for all products to be sealed.
- 8 Turn the unit off by placing switch SP in position 0.



6•4 changing the film roll

When the film roll is finished or if another type of film is needed, proceed as follows:

- •1 Completely roll up the film roll to be removed so that it is clear of the unit.
- •2 Remove the film roll.
- 3 Place the new roll on the film carrier rollers.
- 4 Position the film roll so it is well centered with the tray seat plate.



Fig. 6 changing the film roll 1





Fig. 7 changing the film roll 2

• 5 Thread the film through the film guide until it covers the magnates. Bring the tray seat plate up against the magnets.



6•5

Problems, causes and solutions

The following are common problems that can be resolved without servicing by the manufacturer or Authorized Service Center.

Problem	Cause	Solution
	The power cable is not connected	Attach the power cable to the power supply
The unit does not turn on	The power cable is damaged	Replace the power cable
	The unit's main switch is in the 0 position	Turn the main switch to position 1
	The sealing temperature is not suffi- cient	Increase the sealing temperature
There is no seal	The tray edge is dirty	Make sure the tray edge is clean
	The gasket is worn or damaged	Replace the gasket following chap. 7-1



7•1 routine maintenance



Before proceeding to maintenance operations, ensure that the unit is turned off and disconnected from the electrical power supply.

■ Daily:

• 1 Clean the tray seat plate, removing it from the guides. Any deposits on the surfaces could cause problems during the sealing phase.

• 2 Check that the gaskets located on the tray seat plate are neither worn nor broken and replace if needed. Insert the new gasket using firm pressure.



When inserting the new gasket, do not pull on it. A good seal depends on a correct positioning of the gasket.

• **3** Check the cleaning and the slide guide smoothness of the tray holder trolley. If necessary lubricate the guides using the grease for mechanical parts suitable for uses in the food packaging fields.

Every week:



WAIT UNTIL THE UNIT HAS BEEN OFF FOR A SUFFICIENT AMOUNT OF TIME IN ORDER TO COOL. THERE IS A DANGER OF BEING BURNED.



THE MAINTENANCE OPERATIONS REQUIRE WORKING AROUND A SHARP CUTTING BLADE. WEAR PROTECTIVE GLOVES.

• Clean the black sealing plate located in the inner part of the unit. To access this, remove the tray seat plate. Clean using a soft damp cloth.



Not observing the above norms could compromise correct operation of the machine.



More frequent maintenance may be necessary according to the use of the machine and to the operational environment. Correct maintenance intervals



need to be found by experience.

7•2 extra maintenance

■ Every 500 working hours:



Ask the Reepack Maintenance Service or an Authorized Dealer to check the machine.

Refer to the figure in the section "How to order a spare part" to find unit components.



Before replacing a part make sure the unit is turned off and disconnected from the power supply. Also, make sure the die is completely cool.

• 1. Remove the sealing film reel from the machine.

• 2. Remove the film reel housing rolls pressing with a screwdriver the lateral pins (see fig.8 and 9).



Fig. 8 film holder rolls





• 3. Open the front cover by removing the screws indicated in the follows figures.

Fig. 9 front cover







- 4. lift the upper cover.
- Fig. 10 interior view





Concerning the electrical connections please refer to the electrical schema included in this manual (chapter 10)



8•1 unit demolition

This unit is made of non-toxic material of low environmental impact. This does not exempt the customer from carefully carrying out the demolition and disposal of the unit following current local laws and regulations. Take particular care of the following:



Before carrying out the demolition of the unit, disconnect it from any:

• Electrical connection



Qualified workers must do the demolition operation.



Disassemble the various parts that make up the unit and separate these parts by material.





Dispose of the unit parts according to existing local regulations.





9•1 how to order spare parts

To order a spare part proceed as follows:

• 1st Identify the unit by its model name and serial number referring to the identification plate located on the unit casing.

ĒR	eepack Tel ree	lell'Artigianato, 19 - 1 - 24 +39 035.2924911 - Fax + epack@reepack.com - ww	068 Seriate (BC 39 035.292289 w.reepack.com
MOD.	mo	odel	10
S/N	seri	al n.	CC
[voltage	frequency	Year
	phases	current	Anno

• **2nd** Take the unit User's Manual that has the model name and serial number identified on the cover.

• 3th Identify the part or parts on the unit that have to be ordered

• 4th Using the exploded view in the following section, locate the part or parts and use the corresponding code numbers.

• **5th** Use the following spare parts list to find the name of the part that correspond to the code number.

Send a written order by letter or fax with the following information:

• **1st** Customer identification (Company name, address, address of spare part destination if different).

• 2nd unit identification (Model name, serial number).

■ Send the order to the manufacturer whose address is found in the manual and the identification plate of the unit. Otherwise, send the order to the nearest Authorized Service Center.

For information on the Authorized Service Center nearest you contact the manufacturer.







Fig. 11 General exploded view





Fig. 12 machine exploded view





9•3 spare parts list

cod.	descrizione	description
983000080	MACCH.CONF. RS32-SX-B 1/N/PE 230V AC 50HZ	SEMI-AUTOM. TRAY SEALING MACHINE RS32-SX-B
1002198	TESTA SNODO Ø08 M8 DESTRO F	SPHERIC JOINT Ø08 M8 RIGHT F
1004001	PIEDINO D.25 H=25 RS25_27	FOOT D.25 H=25 RS25_27
1004079	PRESSORE A SFERA E MOLLA LISCIO D.8	PRESSING SCREW D.8 SPHERIC
1006148	ROSETTA P. M08 08.4X17.0 INOX UNI6592-69	WASHER
1006309	GRANO EI 08X040 PUNTA PIANA A2#7	DOWEL
1021012	RULLO D.30 L=450 RULMECA REESEAL 32 INOX	ROLLER
1022003	CALAMITA PERMANENTE D22 SP.6 M5 MASCHIO	MAGNATE
1025025	RIDUTT.WMI30 030 060 PAM56 (B14 80-09)	REDUCTION UNIT
1027043	MOLLA DE06.9 DI5.6 L025.5 K0.76N/MM D21520	SPRING
2001176	MOTORE 0.18KW 4P T56B14R 230V 50HZ MONOFASE IP55	MOTOR
2007026	VENTOLA ASSIALE 120X120X38 230Vac	ELECTRIC BOARD FAN
5002017	CONNETTORE F 4 POLI 10A HARTING	4P CONNECTOR FEMALE
5002019	CUSTODIA CONN. 4P FISSA PASSANTE ANG 1USC DR PG11	4P CONNECTOR FIX HOUSING
5002123	MORSETTI 4 INGRES. 6mm2 450V CERAM.26X24X20.5	TERMINAL
5002133	MORSETTO ESTR. 3 poli MASCHIO Passo=7,62mm	CONNECTORS SET
5002134	MORSETTO ESTR. 6 poli MASCHIO Passo=7,62mm	CONNECTORS SET
5002135	MORSETTO ESTR. 10 poli MASCHIO Passo=3,5mm	CONNECTORS SET
5003038	RESISTENZA CERAMICA 1,8Kohm - 1watt	RESISTANCE 1,8Kohm - 1watt
5008009	PRESSACAVI PG 11 OTTONE CROMA	PRESS WIRE
5009103	POTENZIOMETRO 2MOhm	POTENTIOMETER
5009145	SPIA VERDE A LED DIAM.12mm 24V	GREEN LAMP D.12mm 24V
5009146	GUARNIZIONE x IP65 X SPIA A LED D.12mm cod.5009145	GASKET FOR LAMP D.12mm
5010090	CAVO ALIM.3x0,75 M-SCHUKO, F-VDE 90.GRADI, L=2M	CABLE SHUKO+COMPUTER 90° L=2M
5011004	MICRO INTER.MECC. 10(2)A 250Vac	MICRO SWITCH 10(2)A 250Vac
5013012	TERMOREG. 33x75 24VAC/DC+GUARN.IP65+SSR MOS- FET @	THERMOREGULATOR
5025048	SCHEDA ELET. 230Vac ctrl up/down+timer RS25/27/32	ELECTRONIC CARD 230Vac up/down+timer RS25/27/32
5026020	RELE STATICO MONOFASE 25A mod. RM1A23A25	Solid State Relays
5027014	FUSIBILE IN VETRO 5X20 10A RITARDATO	DELAY GLASS FUSE 10A
5028006	SPINA VDE+PORTA FUSIBILE+INT.UNIP. 10A-250V	ELECTRIC SOCKET+ FUSE HOLDER
100320210	"TARGHETTA ADESIVA""TIMER"" RS"	"""TIMER"" LABEL RS"
112320030	TARGHETTA MATRICOLA MACCHINA	MACHINE SERIAL NUMBER LABEL



cod.	descrizione	description
104207200	DIST.M4XDE06X08	SPACER
138209670	PIASTRINA CONNETTORE RT25B	SUPPORT BLOCK
138260101	DIST.M3XDE11X12.2 SCHEDA POTENZA	SPACER
183020040	DEFLETTORE RS32	FILM DEFLECTOR
183020071	PIASTRA PORTA CALAMITE REESEAL 32	MAGNET SUPPORT PLATE
183020380	GUIDA CONTRASTO DX RS32X-B	RIGHT GUIDE
183020390	GUIDA CONTRASTO SX RS32X-B	RIGHT GUIDE
183020400	MONTANTE PIASTRA MOTORE	MOTOR SUPPORT PLATE
183020410	GUIDA PORTA SALDANTE	KNIFE SUPPORT PLATE
183020420	PATTINO DI SCORRIMENTO	KNIFE SUPPORT PLATE
183020431	PIASTRA PORTA MOTORE	MOTOR SUPPORT PLATE
183020440	RINFORZO PER CONTRASTO LG.415	PLATE
183020450	SUPPORTO PIEDINO CON FORO SWITCH	GUIDE
183020460	SUPPORTO PIEDINO	GUIDE
183020470	TIRANTE INFERIORE RS32	SPACER
183020480	STAFFA SUPPORTO SWITCH	SWITCH SUPPORT
183020490	STAFFA SUPPORTO VENTOLA	SUPPORT FOR IMPELLER
183020500	SUPPORTO RIDUTTORE	SUPPORT REDUCER
183020510	BUSSOLA D.50 L.45	COMPAS
183020520	ALBERO D.14 L.123	SHAFT
183020530	BLOCCHETTO FIX SNODO	SUPPORT
183020541	PIASTRA PORTA STAMPO REESEAL 32	STAMP SUPPORT PLATE
183020550	GUIDA PORTA STAMPO	GUIDE SUPPORT STAMP
183020560	PERNO D.8 -FILETTO M8	SPACER
183040000	LAMIERA COPRI FORI PERFORATORE 455X50 SP.1	COVER FOR HOLE FILM CUTTING
183040010	CARTER LATERALE	COVER LATERAL
183040020	LAMIERA DI COPERTURA	RS32X-B COVER
183040030	LAMIERA FRONTALE	FRONT PANEL
183040040	DIST.DI04.2XDE08X1.5 ROTAZIONE COPERCHIO	SPACER
183040050	LAMIERA DI RECUPERO SCARTO	BASE PLATE
183100010	FRENO X RULLO	BRAKE FOR ROLL
100320240	TARGHETTA RESINATA ADESIVA LOGO REEPACK	REEPACK LABEL
184120060	ANELLO GUIDA BOBINA FILM	FILM CONE
185100010	DIST.DI08.2XDE15X05 RULLO BOBINA RS27	SPACER









DIS	TINTA MATERIALI / BASIC LIST			
ITEM	DESCRIZIONE	DESCRIPTION	CODICE / CODI	E Pag
B1	SCHEDA ELET. 230 Vac ctrl up/down+timer RS25/32	ELECTRONIC CARD 230Vac up/down+timer RS25/32	5025088	01
F1	FUSIBILE IN VETRO RAP. 5X20 10A RITARDATO	DELAY GLASS FUSE 5X20 10A	5027014	
FC1	MICRO A LEVA CORTA/ROTELLA	MICRO SWITCH	5011020	
FC2	MICRO INTER.MECC. CONTATTO DORATO 1-300mA - 5-30V	MICRO SWITCH	5011042	
FC3	MICRO INTER.MECCANICO 10A	MICRO SWITCH	5011004	
IG1	SPINA+PORTA FUSIBILE+INT. UNIP. 10A-250V	ELECTRIC SOCKET+ FUSE HOLDER	5028006	
KS1	RELE STATICO 25A PILOTA: 24-190VCC - 24-265VAC	STATIC RELAY	5026020	
LS1	SPIA VERDE A LED DIAM.12mm 24V	GREEN LAMP D.12mm 24V	5009145	
	GUARNIZIONE x IP65 X SPIA A LED D.12mm	GASKET FOR LAMP D.12mm	5009146	
M1	MOTORE 0.18KW 4P T56B14R 230V 50HZ MONOFASE IP55	MOTOR	2001176	
PT1	TERMORESISTENZA PT100 D.04X27 CAVO MT1.5	TEMPERATURE PROBE	5029006	
В1	RESISTENZA 150x200 220V 800W INOX-sez.1.5 mm2	RESISTANCE 150X200	5003018	
R2	RESISTENZA 150x200 220V 800W INOX-sez.1.5 mm2	RESISTANCE 150X200		
R3	RESISTENZA CERAMICA 1,8Kohm - 1watt	RESISTANCE 1,8Kohm - 1 watt	5003038	
RV1	POTENZIOMETRO 2MOhm	POTENTIOMETER	5009103	
TR1	TERMOREG. 33x75 24VAC/DC+GUARN.IP65+SSR MOSFET	THERMOREGULATOR	5013012	
V1	VENTOLA ASSIALE 120X120X38 230Vac	ELECTRIC BOARD FAN	2007026	
XR	CONNETTORE F 4 POLI 10A	4P CONNECTOR FEMALE	5002017	
	CONNETTORE M 4 POLI 10A	4P CONNECTOR MALE	5002018	
	CUSTODIA CONN. 4P FISSA PASSANTE ANG 1USC DR PG11	4P CONNECTOR FIX HOUSING	5002019	
	CUSTODIA CONN. 4P VOLANTE DR PG11 2PERNI+PG	4P CONNECTOR MOV. HOUSING	5002034	
Note:				
		PROGETTO: REESEAL32X-B_E_02		
				100
			-	
		uging Machinery Supplies	01	 ▲ ■ 02
REV. DA	TA FIRMA MODIFICA	DIS.: S.G. DATA: 1	8/11/2010 1	





10•1•1 electrical diagram legend

pos.	description	specifications
IG1	Main switch	
PT1	Temperature probe	PT100
TR1	Temperature regulator	12V
R1	Sealing resistance	230V
F1	Fuse	10 A
V1	Fan	230V
M1	Motor	230V
B1	Electronic card	
KS1	Static relay	
RV1	Timer	







11•1 how to order a spare parts mold

To order a spare mold proceed as follows:

■ Identify the unit by its model name and serial number referring to the identification plate located on the mold chamber.

Reepac	Via Dell'Artigianato, 19 - Tel. +39 035 2924911 -	l - 24068 Seriate (BG Fax +39 035 2922891
Stampo Vaschet Trays Tool Moule de Barqu	ta COD.	
Reepac	Via Dell'Artigianato, 19- Tel. +39 035 2924911 -	l - 24068 Seriate (BG, Fax +39 035 2922891
Stampo saldatura Sealing tool Moule de Soudure	Via Dell'Artigianato, 19- Tel. +39 035 2924911 - COD.	l - 24068 Seriate (BG Fax +39 035 2922891

■ Identify the part or parts on the tooling that have to be ordered.

■ Using the exploded view in the following section, locate the part or parts and its the corresponding position number.

■ Use the following spare parts list to find the name of the part that correspond to the position number.

Send a written order by letter or fax with the following information:

• Customer identification (Company name, address, address of spare part destination if different).

• Unit identification (Model name, serial number).

• Spare part identification (number of position on exploded view, part name, code number).

For orders & service contact your local Reepack representative.



11•2 changing the mold

- 1. Turn off the machine.
- 2. Remove the film roll.
- 3. With appropriate key, unscrew the screws indicated in the photo .

Fig. 13 Changing the mold 1





• 4. Open the front panel

Fig. 14 Changing the mold 2









Before proceeding to the removal the mold, ensure that the unit is turned off and disconnected from the electrical power.

- 5. disconnected the electric connection.
- Fig. 15 Changing the mold 3



• 6. With an appropriate key, unscrew the screws - indicated in the photo - .

Fig. 16 Changing the mold 4







• 7. Slid slightly and to remove the mold.



PAYING ATTENTION TO THE HANDS

Fig. 17 Changing the mold 5



• To insert a new mold and follow the previous instructions in the reverse order.



11•3 mold 137x185mm expl.view





8				
Tabella Distinta materiali				
F	POS CODE		Δ	
	1	189200710	~	
	2	183201480		
	3	5003039		
	1	187201120		
4 5		189200700		
5 189200700		107200700		
	0	189200720		
	/	18/200030		
	8	102/085		
	9	112200090		
	10	189200730	В	
	11	183201001		
	12	183201072		
	13	1027044		
	14	183200351		
	15	5002123		
	16	5002120		
	17	104218270		
	1/	104218360		
	18	183120101		
	19	183120120		
	20	1002038	С	
	21	5029001		
	22	1027094		
23		183201490		
	24	183200250		
	25	183020660		
	20	182020600		
	26 183020670			
	2/	183201501		
28		5008009		
29 10270		102/069		
	30	1003074	D	
	31	01003017		
	32	1006148		
	33	5002018		
	34	1003045		
	35	139200240		
	36	189200690		
	37	183200082		
	38	1004002		
	30	183200001		
	40	1002112	_	
	40	1003113	E	
41		183080052		
42 1		184200052		
43 183200072				
	44	183201011		
2				
	1:3 + - + ()			
		· · ·		
			F	
	<u>ICE:</u> 389200230			
		-		

11•4 mold - ø165 mm expl.view





8					
Tabella Distinta materiali					
POS			CODE	1	Δ
1		18	89200760	1	~
	2	18	83201480	1	
	3	ļ	5003039	1	
	4	18	87201120	1	
5		18	89200750	1	
	6	18	89200770	1	
	7	18	87200030	1	
	8		1027085	1	
	9	1	12200090	1	
	, 10	18	89200780	1	
	11	18	83201001	1	
	12	18	83201072	1	
	13		1027044	1	
	14	19	83200351	1	
	15		500200001	1	
	16	,	5002120	╢╴	
	17	10	04218240	-	
	10	10	04210300		
	10	10	<u>2120101</u>	$\left \right $	
	17		<u>53120120</u>		
	20		1002038		C
	21		1007001		
	22	1 (1027094		
23		183201490			
	24	10	83200250		
	25	10	83020601		
	26	10	83020611		
	2/	1	83201501		
	28		5008009		
	29		1027069		
	30		1003074		
31		<u> </u>	100301/		
32			1006148		
33			5002018		
	34	1	1003045		
	35	1	10206340		
	36	10	89200740		
	3/	51	83200082		
	38	1.	1004002		
39 40 41		1	<u>83200091</u>		
		1003113			E
		1	83080052		
42		1	84200052		
43		10	83200072		
	44	10	83201011	1	_
<u>o</u>	<u>Scala</u>				
	1:5		$\square \square \Psi$		
_					
CARTONE			F		
<u>DICE:</u> 389200240					
			8		

11•5 mold 137x185mm spare parts list

cod.	descrizione	description
389200230	STAMPO 137x185 S C2 CAMP.CARTONE	MOLD 137x185 S C2 CAMP.
1002038	CUSC.RAD.CON BATTUTA 006-008-06 IGLIDUR J	BEARING 006-008-06 IGLIDUR J
1003017	GUARN.D.05 SILICONE TRASLUCIDO ALIMENT.	ROUND SILICON GASKET D.05
1003045	GUARN.05X08 SILICONE ESPANSO	SILICONE GASKET 05X08
1003074	"GUARN.05""T"" 40SH XT DENTINI"	""T"" GASKET 05 40SH XT"
1003113	NASTRO TEFLON 20X1 PTFE BIANCO CEMENTATO	TEFLON TAPE 20X1 PTFE
1004002	MANIGLIA A PONTE EBP.140-8 NERA ELESA	HANDLE EBP.140-8 BLACK
1006148	ROSETTA P. M08 08.4X17.0 INOX UNI6592-69	WASHER
1027044	MOLLA DE09.25 DI6.75 L033 K4.86N/MM D22170#74	SPRING DE9.25
1027069	MOLLA DE14.1 DI10.9 L036 K5.19 INOX D22460	INOX SPRING DE19
1027085	MOLLA DE18 DI13.5 LO51.5 K2.47N/MM D22510 INOX	SPRING
1027094	MOLLA DE16 DI8 LO25 K16,5N/MM	SPRING
5002018	CONNETTORE M 4 POLI 10A HARTING Han 4A	4P CONNECTOR MALE
5002034	CUSTODIA CONN. 4P VOLANTE DR PG11 2PERNI+PG	4P CONNECTOR MOV. HOUSING
5002123	MORSETTI 4 INGRES. 6mm2 450V CERAM.26X24X20.5	TERMINAL
5003039	RESISTENZA 090x120 220V 400W INOX-sez.1.5 mm2	RESISTANCE 099x120
5008009	PRESSACAVI PG 11 OTTONE CROMA	PRESS WIRE
5029001	TERMORES.PT100 6X6X30 CAVO MT1.5	TEMPERATURE PROBE
104218360	STAFFETTA FERMACAVI	WIRE HOLDER BRACKET
112200090	RONDELLA X STELO D.15 X M6 X 4	WASHER
139200240	PIAST.ISOL.136X185 CAMP.CARTONE	INSULATION PLATE
183020660	GUIDA PORTA STAMPO LG.215.5 DX	GUIDE SUPPORT STAMP
183020670	GUIDA PORTA STAMPO LG.215.5 SX	GUIDE SUPPORT STAMP
183080052	SQUADRA FERMO CAMERA INFERIORE	STOP SQUARE
183120101	PIATTO POLIZENE 20X6 L390 X BLOCCA FILM	PLATE
183120120	BUSSOLA 04.5x08x11	BUSCHING DI4.5 DE06-12 L10
183200072	RINFORZO PER CONTRASTO LG.353	MOTOR SUPPORT PLATE
183200082	CARTER FRONTALE RS 32 E RS32B	EXTENSION PROTECTION
183200091	LAMIERA CONTRO CALAMITE RS32	PLATE
183200250	BUSSOLA 08x12x9.5	BRASS BUSH D.08
183200351	LAMA TRASVERSALE TAGLIO FILM	FILM CUTTING BLADE
183201001	BLOCCA FILM LINEARE RS32X+RT20	
183201011	RINFORZO PER CONTRASTO LG-374#10	MOTOR SUPPORT PLATE



cod.	descrizione	description
183201072	VITE DI SCORRIMENTO BLOCCAFILM	SLIDING SCERW FOR FILM HOLDING
183201480	STELO GUIDA MOLLA D.8 L35.5 M6	SPRING GUIDE ROD
183201490	TUBO GUIDA MOLLA RS32X Di.6 De.8 L25	SPRING GUIDE ROD
183201501	FERMO STAMPO RS32X	
184200052	SPINA CARTER STAMPO REESEAL 25	PIN
187200030	STELO GUIDA MOLLE BLOCCAFILM	GUIDE ROD
187201120	LAMIERA COPRI RESISTENZA 090x120 (5003039)	COVER FOR HEATING ELEMENT
189200690	PIAST.CONTR.137x185 C2 CAMP.CARTONE	TRAY SEAT PLATE
189200700	FUSTELLA 137x185 CAMP.CARTONE	FILM CUTTING BLADE
189200710	PIAST.SALDA.137x185 CAMP.CARTONE	SEALING PLATE
189200720	PIAST.FILM 137x185 C2 CAMP.CARTONE	FILM HOLDER PLATE
189200730	PIAST.FUSTE.137x185 C2 CAMP.CARTONE	FILM CUTTING BLADE ATTACHMENT PLATE



11•6 mold ø 165 mm spare parts list

cod.	descrizione	description
389200240	STAMPO D.165 S C2 CAMP.CARTONE	MOLD.165 S C2 CAMP.
1002038	CUSC.RAD.CON BATTUTA 006-008-06 IGLIDUR J	BEARING 006-008-06 IGLIDUR J
1003017	GUARN.D.05 SILICONE TRASLUCIDO ALIMENT.	ROUND SILICON GASKET D.05
1003045	GUARN.05X08 SILICONE ESPANSO	SILICONE GASKET 05X08
1003074	"GUARN.05""T"" 40SH XT DENTINI"	""T"" GASKET 05 40SH XT"
1003113	NASTRO TEFLON 20X1 PTFE BIANCO CEMENTATO	TEFLON TAPE 20X1 PTFE
1004002	MANIGLIA A PONTE EBP.140-8 NERA ELESA	HANDLE EBP.140-8 BLACK
1006148	ROSETTA P. M08 08.4X17.0 INOX UNI6592-69	WASHER
1027044	MOLLA DE09.25 DI6.75 L033 K4.86N/MM D22170#74	SPRING DE9.25
1027069	MOLLA DE14.1 DI10.9 L036 K5.19 INOX D22460	INOX SPRING DE19
1027085	MOLLA DE18 DI13.5 LO51.5 K2.47N/MM D22510 INOX	SPRING
1027094	MOLLA DE16 DI8 LO25 K16,5N/MM	SPRING
5002018	CONNETTORE M 4 POLI 10A HARTING Han 4A	4P CONNECTOR MALE
5002034	CUSTODIA CONN. 4P VOLANTE DR PG11 2PERNI+PG	4P CONNECTOR MOV. HOUSING
5002123	MORSETTI 4 INGRES. 6mm2 450V CERAM.26X24X20.5	TERMINAL
5003039	RESISTENZA 090x120 220V 400W INOX-sez.1.5 mm2	RESISTANCE 099x120
5008009	PRESSACAVI PG 11 OTTONE CROMA	PRESS WIRE
5029001	TERMORES.PT100 6X6X30 CAVO MT1.5	TEMPERATURE PROBE
104218360	STAFFETTA FERMACAVI	WIRE HOLDER BRACKET
110206340	PIAST.ISOL.D.160 FE0160-1C	INSULATION PLATE
112200090	RONDELLA X STELO D.15 X M6 X 4	WASHER
183020601	GUIDA PORTA STAMPO LG.215.5 DX	GUIDE SUPPORT STAMP
183020611	GUIDA PORTA STAMPO LG.215.5 SX	GUIDE SUPPORT STAMP
183080052	SQUADRA FERMO CAMERA INFERIORE	STOP SQUARE
183120101	PIATTO POLIZENE 20X6 L390 X BLOCCA FILM	PLATE
183120120	BUSSOLA 04.5x08x11	BUSCHING DI4.5 DE06-12 L10
183200072	RINFORZO PER CONTRASTO LG.353	MOTOR SUPPORT PLATE
183200082	CARTER FRONTALE RS 32 E RS32B	EXTENSION PROTECTION
183200091	LAMIERA CONTRO CALAMITE RS32	PLATE
183200250	BUSSOLA 08x12x9.5	BRASS BUSH D.08
183200351	LAMA TRASVERSALE TAGLIO FILM	FILM CUTTING BLADE
183201001	BLOCCA FILM LINEARE RS32X+RT20	
183201011	RINFORZO PER CONTRASTO LG-374#10	MOTOR SUPPORT PLATE



11• mold

cod.	descrizione	description
183201072	VITE DI SCORRIMENTO BLOCCAFILM	SLIDING SCERW FOR FILM HOLDING
183201480	STELO GUIDA MOLLA D.8 L35.5 M6	SPRING GUIDE ROD
183201490	TUBO GUIDA MOLLA RS32X Di.6 De.8 L25	SPRING GUIDE ROD
183201501	FERMO STAMPO RS32X	
184200052	SPINA CARTER STAMPO REESEAL 25	PIN
187200030	STELO GUIDA MOLLE BLOCCAFILM	GUIDE ROD
187201120	LAMIERA COPRI RESISTENZA 090x120 (5003039)	COVER FOR HEATING ELEMENT
189200740	PIAST.CONTR. D.165 C2 CAMP.CARTONE	TRAY SEAT PLATE
189200750	FUSTELLA D.165 CAMP.CARTONE	FILM CUTTING BLADE
189200760	PIAST.SALDA. D.165 CAMP.CARTONE	SEALING PLATE
189200770	PIAST.FILM D.165 C2 CAMP.CARTONE	FILM HOLDER PLATE
189200780	PIAST.FUSTE. D.165 C2 CAMP.CARTONE	FILM CUTTING BLADE ATTACHMENT PLATE



I - CE DICHIARAZIONE DI CONFORMITÀ	Á
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- EN CE DECLARATION OF CONFORMITY
- **D** EG KONFORMITÄTSERKLÄRUNG
- **F** CE DÉCLARATION DE CONFORMITÉ
- **ES** CE DECLARACIÓN DE CONFORMIDAD

Noi - We - Wir - Nous - Nosotros :

REEPACK srl

via dell'Artigianato, 19

I - 24068 Seriate (BG)

dichiariamo sotto la nostra esclusiva responsabilità che il prodotto declare under our sole responsibility that the product wir bestätigen, dass folgendes in dieser Erklärung genanntes Produkt déclarons sous notre seule responsabilité que le produit declaramos bajo Nuestra exclusiva responsabilidad que el producto

Tipo / Type / Typ /Type / Modelo	ReeSeal-32SX
Matricola / Serial No. / Maschinene Nr. / No. De Machine / Matricúla	8311018

è conforme a quanto prescritto dalle seguenti Direttive e successive modifiche:

complies with the provisions of the following directives and their amendments:

den Vorschriften, insbesondere den Schutzanforderungen folgender Varianten entspricht :

est conforme aux dispositions des directives suivantes et leurs modifications successives :

es conforme a cuanto previsto de las siguientes directivas y de las sucesivas modificaciones:

2006/42/EEC 2006/95/EEC 2004/108/EEC

Ed inoltre dichiariamo che sono state applicate le seguenti norme armonizzate:

And we also declare that the following harmonised standards have been applied: Es wird bestätigt, dass folgende Bestimmungen angewandt sind :

Et de plus nous déclarons que les normes suivantes ont été appliquées :

Además declaramos que han sido aplicadas las siguientes normas armonizadas:

CEI EN 60204-1:2006 EN 294

EN 349 EN 563

The person authorised to compile the *technical file* is Mr.: Livio Valli - via dell'Artigianato, 19 - Seriate (BG)

Seriate (BG), 08/07/2011.

Direttore generale General Manager Directeur général Geschäftsführer Director General

Livio Valli



