<table>
<thead>
<tr>
<th>Symptom</th>
<th>Possible Solution</th>
</tr>
</thead>
<tbody>
<tr>
<td>No power to the unit.</td>
<td>Verify the unit is plugged into a 20 Amp, GFCI circuit and the Power Switch is set to the “ON” position.</td>
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<tr>
<td></td>
<td>Is the GFCI circuit breaker tripped?</td>
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<td></td>
<td>1) Remove “Non-Stick” Cover and inspect the Seal Plate for the following defects***:</td>
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<tr>
<td></td>
<td>Punctures or cuts.</td>
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<tr>
<td></td>
<td>Burn marks.</td>
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<tr>
<td></td>
<td>Extreme discoloration (blue/black or gold).</td>
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<td></td>
<td>2) Ensure the GFCI circuit being utilized is not overloaded with other devices.</td>
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<tr>
<td></td>
<td><strong>If a surface defect is present, discontinue use of product and contact Troy Roberts at: 800-342-6329 ext 276 or <a href="mailto:troberts@heatsealco.com">troberts@heatsealco.com</a></strong></td>
</tr>
<tr>
<td>Seal Plate is working but the Red Indicator Light is not working properly.</td>
<td>If the Red Indicator Light does not turn ON or OFF as expected, verify that the Red Indicator Light Timer is functioning properly. Replace Timer Board Assembly as required (Part #1818-026).</td>
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<tr>
<td></td>
<td>Verify 120V is being supplied to the light when the Seal Plate is actuated. If voltage is present, replace the Rocker Arm Assembly Kit (Part #6340-076)</td>
</tr>
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<td>Symptom</td>
<td>Possible Solution</td>
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</table>
| Unit has power but the Seal Plate does not work                        | Does the Red Indicator Light turn ON when the unit is cycled?  
1) If neither the Light nor Seal Plate work, verify that the 25 Amp fuse is good.  
2) If the fuse is blown, verify there are no shorts to ground in the unit by checking wiring and connections (see Figure 1).  
3) Replace fuse as required (Part #1821-037). |
| Verify the Switch located in the Rocker Arm Assembly is functional.    | 1) Listen for an audible “click” of the Switch as the Seal Plate is pressed down.  
Verify that the Pivot Bolts on the Rocker Housing are not too tight and that the Rocker Housing rotates freely.  
**NOTE:** The Pivot Bolts are installed with thread lock compound and tightened to leave a 0.015” gap between the bolt head and the Rocker Housing. If the bolts are removed this process must be duplicated.  
Verify that the bolts on the rear of the Rocker Housing that mount the switch are tight and that the Switch is contacting the metal Base appropriately.  
2) Verify switch wiring is intact by isolating the unit from power and using volt-ohm meter set to measure resistance, measure between points A and B while cycling the Seal Plate. You should see the circuit open and close as the Seal Plate is cycled up and down. (see Figure 1)  
3) Replace Seal Plate & Rocker Arm Assembly or make repairs as required (Seal Plate & Rocker Arm Kit - 625ES Part #6340-078; 107ES Part #6135-038; Rocker Arm Assembly Part #6340-076). |
| Verify the Timer Board is working properly. Upon actuation of the Seal Plate the sequence of events should be as follows: | 1) The Red Indicator Light should illuminate at the same time that the Seal Plate begins to get hot.  
2) The Seal Plate Timer should make an audible “click” and remove power from the Seal Plate in 4 seconds or less (depending on the latent temperature of the Seal Plate).  
3) The Red Indicator Light Timer should remove power from the Red Indicator Light after a fixed time of either 3 or 4 seconds (depending on the Time Selection Switch setting).  
If any of the previous steps do not occur, verify that the individual timers are seated properly to the board. If the problem persists, replace the Timer Board Assembly (Part #1818-026). |
| Inspect and verify all wiring connections and condition of wires. (see Figure 1) Repair as required. | If the plate does not heat at all or is only slightly warm to the touch, replace the Seal Plate & Rocker Arm Assembly (Seal Plate & Rocker Arm Kit - 625ES Part #6340-078; 107ES Part #6135-038). |
| Film Cut-off Rod does not work at all.                                 | Verify the unit is plugged into a 20 Amp, GFCI circuit and the Power Switch is set to the “ON” position.  
Verify that the 1 Amp fuse is good. If the fuse is blown, verify there are no shorts to ground in the unit by checking wiring and connections. Replace fuse as required (Part #1821-034). |
| Film cuts too slowly                                                    | Clean Cut-off Rod surface and verify it is not bent. See “Cut-Off Rod” Maintenance.  
Replace Cut-off Rod Control Board (Part #1818-001)  
Replace Cut-off Rod (Part #6340-062) |
HOT ROD CIRCUIT BOARD TEST

ELECTRICAL REQUIREMENTS

- The Model 625-ES requires 115 volts, 19 amps.
  (20A breaker, GFCI protected circuit)

HOT ROD CIRCUIT BOARD TEST

- A standard 115 volt neon circuit tester can be used for these tests.

CHECKING 1 AMP FUSES

(The 1 Amp fuse is for the hot rod, while the 25 Amp fuse is for the seal plate)

- Remove the fuses from their housing units located on the front of the electrical box. If a visual inspection does not verify a blown fuse check for continuity by using the meter to read across the two terminals of the fuse.

- If the meter reading does not show continuity, replace the fuse.

CHECKING THE HOT ROD

- With the power turned OFF, remove the hot rod red wires from Terminals 1 and 2. Using the meter, measure the resistance of the rod by connecting the leads of the meter to the red wires.

- The meter should read between 130-136 ohms. If the reading is out of this range, replace the hot rod.

CHECKING THE THERMISTOR OF THE HOT ROD

- With the power turned OFF, remove the hot rod black wires from Terminals 5 and 6. Using the meter, measure the resistance of the thermistor by connecting the leads of the meter to the black wires.

- The resistance of the thermistor is heavily dependent on the temperature (higher temperature, lower resistance). At a room temperature of 70˚ F, the reading should be in the range of 260-270 kΩ, 90˚ F yields about 230 kΩ, and 40˚ F yields about 340 kΩ.

- If the reading at a given temperature is off by more than 50 kΩ or if an infinite resistance is recorded (an open circuit) the thermistor is bad and the rod needs to be replaced.

CHECKING THE HOT ROD CIRCUIT BOARD

- After the hot rod and both the fuses have passed the above testing procedures, the circuit board can be tested.

- With all the wires shown in the example circuit board (above) properly connected and the power ON, use the meter to test the voltage across Terminals 1 and 2. If there is no voltage being read, the board needs to be replaced.
Disassembling the Unit:

1. Turn off power and remove all power from machine and follow all local safety procedures.

2. On the 107ES, remove rod that attaches the ES conversion kit from the console legs, and two self tapping screws. Remove 4 pan head Phillips screws that attached the electrical box. On 625ES, loosen all four pan head Phillips screws, located at the top of the electrical box - two in front, two in back, and remove the cover.

3. Unplug wires and remove wires from connections:
   - Remove the back six wires (labeled THERM 1 & 2, PEPI 1 & 2, and LIGHT - & + on the board) from the green terminal connector block (A) on the large circuit board with a flat head screw driver.
   - Remove all four screws holding the large circuit board (B).
   - Locate the three shiny black wires (C) coming from the rocker arm and remove the wires from their connections. One connects to the bottom of the large circuit board and the other two to slip on terminals for - all marked in picture 3.2 with blue stickers.
   - Unscrew the green grounding wire (D) from the inside the box.
   - Separate the two wires being held by the wire nut (E).

4. Located under the machine, unscrew two hex head machine screws (F) which connects the base stainless steel plate and rocker arm.

5. Pull the rocker arm assembly with wires out from the electrical box.

(Rewiring and Reassembling the Unit:)

Reinstall rocker arm assembly in reverse order as on page 1.
Reconnect the wires (See page 3 for Timer Board close up):
   - Wire #7 should be matched with wire #7 from fuseholder and wire nut together.
   - Wire #190 terminates to the top slot on front terminal board.
   - The two high luster wires—one goes to the neutral terminal board in back and the other terminates under the large circuit board.
   - Non-terminal wires should be terminated into the green terminal connector block (page 1 A) as follows:
     - Thin black wire into “THERM 1 & 2”
     - 22 gauge white wires into “PEPI 1 & 2”
     - Wires #10 & #15 go into “LIGHT - & +”
Following Disassembly of the Unit
To Replace the Red Rocker Arm, Switch, Light or Spring:

6. Press the plug (G) (Floor model ES) or grommet (H) (625ES) into hole in the back of red rocker arm.

7. Assemble the Switch (I)
   - Attach the wires to the OUTSIDE terms and thread lock the wire screws
   - Attach the switch assembly to the back of the red rocker arm with the nuts on the inside and the switch toward bottom of the rocker arm.

8. Attach the light wires to the light.

9. Mount the Seal Plate to the Rocker Arm
   - Using the (4) screws and star washers (J), thread lock the screws to the plate.
   - DO NOT OVER TIGHTEN SCREWS

10. Route the Seal Plate wires through the grommet (625ES) or towards the electrical box (floor model ES).

11. Assemble Rocker Arm and Spring (K)
   - Position the spring under the red rocker arm, between base plate (M) and attach the shoulder bolts (L).
   - Tighten the shoulder bolts and the BACK OFF HALF TURN.
   - Housing MUST PIVOT FREELY.

Rewiring and Reassembling the Unit:

12. Reinstall rocker arm assembly in reverse order as on page 1. Reconnect the wires (See page 3 for Timer Board close up):
   - Wire #7 should be matched with wire #7 from fuseholder and wire nut together.
   - Wire #190 terminates to the top slot on front terminal board.
   - The two high luster wires—one goes to the neutral terminal board in back and the other terminates under the large circuit board.
   - Non-terminal wires should be terminated into the green terminal connector block (page 1 A) as follows:
     - Thin black wire into “THERM 1 & 2”
     - 22 gauge white wires into “PEPI 1 & 2”
     - Wires #10 & #15 go into “LIGHT - & +”