SERVICING IMPULSE SEAL SYSTEM

FOR LEGACY HS SERIES MACHINES

TO REMOVE WIRES

- Tighten the knob (1) on the tension block (2) to relieve the sealing wire tension.

- Using a small screwdriver, loosen the screw (3) in the side of the tension block and pull out the sealing wire.

- Loosen the screw (4) at the other end where the wires cross and remove the sealing wire.

TO REPLACE WIRES

- Insert the new wire in the tension block and re-tighten the screw.

- With pliers in hand, tightly wrap the new wire around the screw at the other end (4) and re-tighten the screw. Then loosen the knob (1) to create tension on the new wire.

COMPLETELY LOOSEN BOTH KNOBS ON THE TENSION BLOCKS BEFORE TESTING THE SEALER. IF THE WIRES ARE LOOSE WHEN COOL, FOLLOW THE REPLACEMENT STEPS ABOVE TO RETENSION WIRES.
FOR 1ST GENERATION HS & HSE SERIES MACHINES

TO REMOVE WIRES

- Tighten the knob (1) on the tension block (2) to relieve the sealing wire tension.
- Using a small screwdriver, loosen the screw (3) in the side of the tension block and pull out the sealing wire.
- Loosen the screw (5) at the other end where the wires cross and remove the sealing wire.

TO REPLACE WIRES

- Insert the new wire in the tension block (2) and re-tighten the screw (1).
- Then, insert the other end of the wire into the hole on the tensioning screw (4) leaving the wire loose.
- Use a 1/8" Allen Key on the screw head (5), and a 3/8" wrench on the lock nut (6) to tighten the wire Counter Clockwise. The wire will wind around the screw body Counter Clockwise until the ideal tension is met.
- Wire must wrap around tension bolt 2.5-3 times to ensure proper grounding.

** Tensioning the wire Counter Clockwise around the tensioning screw will provide longevity to the sealing wires. **

COMPLETELY LOOSEN BOTH KNOBS ON THE TENSION BLOCKS BEFORE TESTING THE SEALER. IF THE WIRES ARE LOOSE WHEN COOL, FOLLOW THE REPLACEMENT STEPS ABOVE TO RETENSION WIRES.
FOR 2ND GENERATION HS & HSE SERIES MACHINES

TO REMOVE WIRES

- Tighten the knob (1) on the tension block (2) to relieve the sealing wire tension.
- Using a small screwdriver, loosen the screw (3) in the side of the tension block and pull out the sealing wire.
- Loosen the screw (5) at the other end where the wires cross and remove the sealing wire.

TO REPLACE WIRES

- Insert the new wire in the tension block (2) and re-tighten the screw (1).
- Then, insert the other end of the wire into the hole on the tensioning screw (4) leaving the wire loose.
- Use a 1/8" Allen Key on the screw head (5), and a 3/8" wrench on the lock nut (6) to tighten the wire Clockwise. The wire will wind around the screw body Clockwise until the ideal tension is met.
- Wire must wrap around tension bolt 2.5-3 times to ensure proper grounding.

**Tensioning the wire Clockwise around the tensioning screw will provide longevity to the sealing wires.**

** COMPLETELY LOOSEN BOTH KNOBS ON THE TENSION BLOCKS BEFORE TESTING THE SEALER. IF THE WIRES ARE LOOSE WHEN COOL, FOLLOW THE REPLACEMENT STEPS ABOVE TO RETENSION WIRES.**