



PROBLEM:

FILM SPLITS ALONG CENTER FOLD

SOLUTION:

CHECK FOR DAMAGE TO FILM ROLL.
MAKE SURE PRODUCT TRAY IS POSITIONED CORRECTLY



PROBLEM:

FILM SPLITS AT HOLE PUNCH

SOLUTION:

CHECK HOLE PUNCH FOR PROPER ALIGNMENT.
CHECK THE CONDITION OF THE PUNCHED HOLES.



PROBLEM:

FILM SPLITS AT TOP OF PACKAGE

SOLUTION:

CHECK HOLE PUNCH FOR PROPER ALIGNMENT.
CHECK THE CONDITION OF THE PUNCHED HOLES.
MAKE SURE THE TUNNEL IS FUNCTIONING PROPERLY.
SPEED UP THE TUNNEL CONVEYOR.
DECREASE THE TUNNEL TEMPERATURE.
ADJUST THE AIR FLOW.



PROBLEM:

FILM SMOKES EXCESSIVELY

SOLUTION:

CHECK AND CLEAN WIRE AND WIRE INSULATION.
CHECK AND CLEAN KNIFE BLADE.
CHECK CONDITION OF SEALING PADS.
CHECK CONDITION OF NON-STICK TAPE.
CHECK FOR EVEN ARM AND MAGNET PRESSURE.
CHECK THE MINIMUM SEALING TEMPERATURES.
INCREASE THE SEALING TEMPERATURES.
DECREASE THE DWELL TIME.



PROBLEM:

FILM BUILDUP ON SEALING WIRE

SOLUTION:

CHECK AND CLEAN WIRE, WIRE INSULATION OR KNIFE BLADES.
CHECK THE CONDITION OF THE SEALING PADS.
CHECK THE NON-STICK TAPE.
CHECK FOR EVEN ARM AND MAGNET PRESSURE.
CHECK THE MINIMUM SEALING TEMPERATURES.
INCREASE THE SEALING TEMPERATURES.
CHANGE THE NON-STICK TAPE.



PROBLEM:

CROWS FEET

SOLUTION:

SLOW DOWN TUNNEL CONVEYOR.
INCREASE THE TUNNEL CHAMBER TEMPERATURE.





PROBLEM:

FISH EYES

SOLUTION:

MAKE SURE TUNNEL IS FUNCTIONING PROPERLY.
SLOW DOWN TUNNEL CONVEYOR.
USE LESS FILM AROUND THE PACKAGE.
INCREASE THE TUNNEL TEMPERATURE.



PROBLEM:

ANGEL HAIR

SOLUTION:

CHECK AND CLEAN WIRE, WIRE INSULATION OR KNIFE BLADES.
CHECK CONDITION OF SEALING PADS AND NON-STICK TAPE.
CHECK FOR EVEN ARM AND MAGNET PRESSURE.
CHECK THE MINIMUM SEALING TEMPERATURES.
CHECK THE SEAL CYCLE IS COMPLETE.
MAKE SURE THE MAGNETS RELEASE AT THE SAME TIME.
CHECK THE CONDITION OF THE AIR RELEASE HOLES.
INCREASE THE SEALING TEMPERATURES.
CHANGE THE NON-STICK TAPE.



PROBLEM:

DOG EARS

SOLUTION:

USE LESS FILM AROUND THE PACKAGE.
SLOW DOWN THE TUNNEL CONVEYOR.
CHECK THE CONDITION OF THE AIR RELEASE HOLES.
INCREASE THE TUNNEL TEMPERATURE.



PROBLEM:

BURN HOLES (HOT SPOTS)

SOLUTION:

CHECK THE CONDITION OF THE AIR RELEASE HOLES.
SPEED UP THE TUNNEL CONVEYOR.
DECREASE THE TUNNEL CHAMBER TEMPERATURE.



PROBLEM:

ERRATIC SHRINK

SOLUTION:

MAKE SURE THE TUNNEL IS FUNCTIONING PROPERLY.
SLOW DOWN TUNNEL CONVEYOR.
ADJUST THE TUNNEL AIR FLOW.
INCREASE TUNNEL CHAMBER TEMPERATURE.



PROBLEM:

SEVERE BALLOONING

SOLUTION:

INCREASE THE TUNNEL TEMPERATURE
CHECK CONDITION OF AIR HOLES.



PROBLEM: OFF-CENTERED SEAL

SOLUTION: ADJUST THE PACKAGE PLATFORM.
LOOSEN THE KNOBS ON THE TENSION BLOCKS.



PROBLEM: FILM CAN'T SEPARATE, STATIC OR FILM COLLAPSES PACKAGE

SOLUTION: CALL YOUR FILM SUPPLIER.

- ANY OF THE PRECEDING TROUBLESHOOTING PROCEDURES DO NOT WORK, PLEASE CALL YOUR LOCAL HEAT SEAL DISTRIBUTOR SERVICE FOR FURTHER ASSISTANCE.

MAINTENANCE OF SHRINK TUNNEL BELTS AND L SEALER TAPE AND PAD

LUBRICATION OF TUNNEL BELT

- The chain and sprockets on all Heat Seal shrink tunnels must be maintained to provide for long life and smooth operation. The tunnel chain must be lubricated after every 40 hours of operation with Heat Seal Chain Gel lubricant. (Part No. 5406-006)

CHECKING THE SEAL PADS

- The L Sealer seal pad will show wear from constant use and will need replaced when problems occur or it no longer provides a constant seal for your packages. See your Heat Seal Price List for replacement part information.

