READ ALL INSTRUCTIONS CAREFULLY BEFORE OPERATING EQUIPMENT
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RS-5 PLUS FEATURES & START UP

The RS-5 Plus is a programmable digital controller designed to control adjustable machine settings with the easy to use control pad. The digital controller is configured to control impulse or hot knife L Sealers equipped with or without a shrink tunnel as well as the Heat Seal sleeve wrapper.

**MENU SCREEN (1)**
The Menu Screen displays the programmed machine settings.

**NEXT (2)**
The ‘NEXT’ button navigates through menu options.

**DOWN/UP (3/4)**
Both the ▼ & ▲ keys are used to make changes to individual variables within the menu options. By pressing the ▲ key, the value of the menu option will increase, and pressing the ▼ key will decrease the value.

**ESC (5)**
The ‘ESC’ key gives the operator access to the parameters. When in the ‘RUN’, or home menu screen, the ‘ESC’ key is used to access the parameters. To exit the parameter screen, the ‘ESC’ key is used to return back to the ‘RUN’ screen. After 10 seconds of inactivity the display will automatically revert to the ‘RUN’ or home screen.

**POWERING ON AND WARM UP**
If the machine is connected to service power, and the ON/OFF switch is OFF, the menu screen will read OFF.

When the ON/OFF switch is ON, the machine is beginning the warming up process. These are the screens that will show in the warm up mode:

- For L Sealer Impulse Wire Machines — the menu screen will change from ‘OFF’ to ‘RUN’, and is ready to begin the packaging process.
- For L Sealer Hot Knife Machines — the menu screen will read ‘MACHINE ELEMENTS WARMING UP, PLEASE WAIT’.
- For L Sealer Shrink Tunnel Combination Systems with Impulse Wire — the menu screen will read ‘MACHINE ELEMENTS WARMING UP, PLEASE WAIT’ until the Tunnel Temp reaches the factory default or set point.
- For L Sealer Shrink Tunnel Combination Systems with Hot Knife — the menu screen will read ‘MACHINE ELEMENTS WARMING UP, PLEASE WAIT’.
- For Sleeve Wrapping Machines — the menu screen read ‘MACHINE ELEMENTS WARMING UP, PLEASE WAIT’.

Upon reaching the temperature set points, the home screen will read ‘RUN’. The operator may now begin the packaging process.
BELOW DESCRIBES MENU SETTINGS FOR COMBINATION HOT KNIFE MACHINES

SEAL TIME
‘SEAL TIME’ is the amount of time the magnets hold the seal bars in the sealing position. This setting ranges from 0 (Off) to 2 (Max) seconds. The factory default setting is 1 second. Press the ‘▼’ or ‘▲’ keys to decrease or increase the value of the menu option.

TUNNEL TEMPERATURE
This menu option shows two temperature readings. The first temperature reading is the Set Point (SET), the second temperature reading is the Actual temperature (ACT) in the tunnel. The factory default setting for the Set Point is 300°F. The ‘TUNNEL TEMPERATURE’ has a Max setting of 350°F. Press the ‘▼’ or ‘▲’ keys to decrease or increase the value of the menu option.

SEAL CONVEYOR RUN TIME
The ‘SEAL CONVEYOR RUN TIME’ is the time the sealing conveyor runs after the seal has been made to transfer the product away from the seal area and/or into the Shrink Tunnel. The factory default setting is 2 seconds on a scale from 0 (Off) to 10 (Max) seconds. Press the ‘▼’ or ‘▲’ keys to decrease or increase the value of the menu option.

TUNNEL CONVEYOR SPEED
The factory default setting is set at 5 on a range from 0 (Off) to 10 (Fast). Press the ‘▼’ or ‘▲’ keys to decrease or increase the value of the menu option. **On retrofit kits, the Conveyor Speed is controlled by a knob on the control panel.**

SEAL CONVEYOR SPEED
The factory default setting is set at 5 on a range from 1 (Very Slow) to 10 (Fast). Press the ‘▼’ or ‘▲’ keys to decrease or increase the value of the menu option. **On retrofit kits, the Conveyor Speed is controlled by a knob on the control panel.**

FRONT KNIFE TEMPERATURE
This menu option shows two temperature readings for the hot knife running parallel to the seal conveyor. The first temperature reading is the Set Point (SET), the second temperature reading is the Actual temperature (ACT). The factory default setting for the Set Point is 315°F, and the Max setting is 425°F. Press the ‘▼’ or ‘▲’ keys to decrease or increase the value of the menu option.

SIDE KNIFE TEMPERATURE
This menu option shows two temperature readings for the hot knife crossing the path of the seal conveyor. The first temperature reading is the Set Point (SET), the second temperature reading is the Actual temperature (ACT). The factory default setting for the Set Point is 315°F, and the Max setting is 425°F. Press the ‘▼’ or ‘▲’ keys to decrease or increase the value of the menu option.

CYCLE COUNTER
This menu option counts the number of times the Seal Bar is pulled down to make a seal and actuates the Cycle Start Button at the back of the machine. To reset the count access the ‘CYCLE COUNTER’ menu screen and hold the ‘▲’ key until the counter resets to 0. The current cycle count is visible from the Home or ‘RUN’ Screen.

HOT HOLE PUNCH
This menu option is only visible if the optional Heated Hole Punch is purchased with the original machine. This setting ranges from 0 (Off) to 10 (Very Hot). Press the ‘▼’ or ‘▲’ keys to decrease or increase the value of the menu option.
OPERATING THE CONTROLLER

BELOW DESCRIBES MENU SETTINGS
FOR L BAR SEALER HOT KNIFE MACHINES

SEAL TIME
‘SEAL TIME’ is the amount of time the magnets hold the seal bars in the sealing position. This setting ranges from 0 (Off) to 2 (Max) seconds. The factory default setting is 1 second. Press the ‘▼’ or ‘▲’ keys to decrease or increase the value of the menu option.

SEAL CONVEYOR RUN TIME
The ‘SEAL CONVEYOR RUN TIME’ is the time the sealing conveyor runs after the seal has been made to transfer the product away from the seal area and/or into the Shrink Tunnel. The factory default setting is 2 seconds on a scale from 0 (Off) to 10 (Max) seconds. Press the ‘▼’ or ‘▲’ keys to decrease or increase the value of the menu option.

SEAL CONVEYOR SPEED
The factory default setting is set at 5 on a range from 1 (Very Slow) to 10 (Fast). Press the ‘▼’ or ‘▲’ keys to decrease or increase the value of the menu option. **On retrofit kits, the Conveyor Speed is controlled by a knob on the control panel.**

FRONT KNIFE TEMPERATURE
This menu option shows two temperature readings for the hot knife running parallel to the seal conveyor. The first temperature reading is the Set Point (SET), the second temperature reading is the Actual temperature (ACT). The factory default setting for the Set Point is 315°F, and the Max setting is 425°F. Press the ‘▼’ or ‘▲’ keys to decrease or increase the value of the menu option.

SIDE KNIFE TEMPERATURE
This menu option shows two temperature readings for the hot knife crossing the path of the seal conveyor. The first temperature reading is the Set Point (SET), the second temperature reading is the Actual temperature (ACT). The factory default setting for the Set Point is 315°F, and the Max setting is 425°F. Press the ‘▼’ or ‘▲’ keys to decrease or increase the value of the menu option.

CYCLE COUNTER
This menu option counts the number of times the Seal Bar is pulled down to make a seal and actuates the Cycle Start Button at the back of the machine. To reset the count access the ‘CYCLE COUNTER’ menu screen and hold the ‘▲’ key until the counter resets to 0. The current cycle count is visible from the Home or ‘RUN’ Screen.

HOT HOLE PUNCH
This menu option is only visible if the optional Heated Hole Punch is purchased with the original machine. This setting ranges from 0 (Off) to 10 (Very Hot). Press the ‘▼’ or ‘▲’ keys to decrease or increase the value of the menu option.
SEAL TIME
‘SEAL TIME’ is the amount of time the magnets hold the seal bars in the sealing position. This setting ranges from 0 (Off) to 2 (Max) seconds. The factory default setting is 1 second. Press the ‘▼ or ▲ ’ keys to decrease or increase the value of the menu option.

CONVEYOR RUN TIME
The ‘CONVEYOR RUN TIME’ is the time the sealing conveyor runs after the seal has been made to transfer the product away from the seal area and/or into the Shrink Tunnel. The factory default setting is 2 seconds on a scale from 0 (Off) to 10 (Max) seconds. Press the ‘▼ or ▲ ’ keys to decrease or increase the value of the menu option.

CONVEYOR SPEED
The factory default setting is set at 5 on a range from 0 (Off) to 10 (Fast). Press the ‘▼ or ▲ ’ keys to decrease or increase the value of the menu option.

KNIFE TEMPERATURE
This menu option shows two temperature readings for the hot knife. The first temperature reading is the Set Point (SET), the second temperature reading is the Actual temperature (ACT). The factory default setting for the Set Point is 315°F, and the Max setting is 375°F. Press the ‘▼ or ▲ ’ keys to decrease or increase the value of the menu option.

OFF DELAY FOR LOWER PFU (POWER FILM UNWIND)
This menu option is to reduce film tension on the top film roll when the seal arm cycles. For a taller package use a higher setting and use a lower setting for a shorter package. The factory default setting is set at 0 on a range from 0 (Off) to 5 (Max) seconds. Press the ‘▼ or ▲ ’ keys to decrease or increase the value of the menu option.

OFF DELAY FOR UPPER PFU (POWER FILM UNWIND)
This menu option is to reduce film tension on the bottom film roll when the seal arm cycles. For a taller package use a higher setting and use a lower setting for a shorter package. The factory default setting is set at 0 on a range from 0 (Off) to 5 (Max) seconds. Press the ‘▼ or ▲ ’ keys to decrease or increase the value of the menu option.
There are four (4) alarms that can occur anytime the controller is powered. The L Sealer will not operate during any of these alarm conditions. The alarms will show on the screen until the solution is fixed.

1. ‘FRONT KNIFE HEAT SIGNAL LOST, CHECK RTD’
   - This alarm signals when the RTD for the front hot knife is disconnected or malfunctioning. The front knife is the knife closest to the operator running parallel to the face of the machine. Call a local Heat Seal distributor to properly diagnose and fix this issue.

2. ‘SIDE KNIFE HEAT SIGNAL LOST, CHECK RTD’
   - This alarm signals when the RTD for the side hot knife is disconnected or malfunctioning. The side knife is the knife running across the seal conveyor and parallel to the side of the machine. Call a local Heat Seal distributor to properly diagnose and fix this issue.

3. ‘TUNNEL HEAT SIGNAL LOST, CHECK RTD’
   - This alarm signals when the RTD for the tunnel is disconnected is malfunctioning. Call a local Heat Seal distributor to properly diagnose and fix this issue.

4. ‘MACHINE ELEMENT TEMPERATURE OUT OF SPEC, PLEASE WAIT’
   - This alarm will signal when either the front knife, side knife, or tunnel temperatures are out of spec. ‘OUT OF SPEC’ refers to the temperature being more than 10-15 °F above or below the set point. Press ‘ESC’ on the RS-5 Plus digital controller to diagnose whether the front knife, side knife, or tunnel temperature is causing the alarm. Then, call a local Heat Seal distributor to properly diagnose and fix this issue.
There are four (4) alarms that can occur anytime the controller is powered. The L Sealer will not operate during any of these alarm conditions. The alarms will show on the screen until the solution is fixed.

1. ‘KNIFE HEAT SIGNAL LOST, CHECK RTD’
   - This alarm signals when the RTD for the hot knife is disconnected or malfunctioning. Call a local Heat Seal distributor to properly diagnose and fix this issue.

2. ‘OBSTRUCTION IN SEAL BAR PATH, PRESS UP TO RESET’
   - This alarm signals when an object interferes with the film clamps before the film clamps hit the seal pad. Call a local Heat Seal distributor to properly diagnose and fix this issue.

3. ‘MACHINE ELEMENT TEMPERATURE OUT OF SPEC, PLEASE WAIT’
   - This alarm will signal when the hot knife is out of spec. ‘OUT OF SPEC’ refers to the temperature being more than 15 °F above or below the set point. This could mean the heating element is still warming to temperature, or there may be an issue with the RTD or heating element. Call a local Heat Seal distributor to properly diagnose and fix this issue.