



OPERATING MANUAL  
**STANDARD DUTY SHRINK TUNNEL T2016**



READ ALL INSTRUCTIONS CAREFULLY BEFORE OPERATING EQUIPMENT

# OPERATOR CONTROLS



## POWER SWITCH (1)

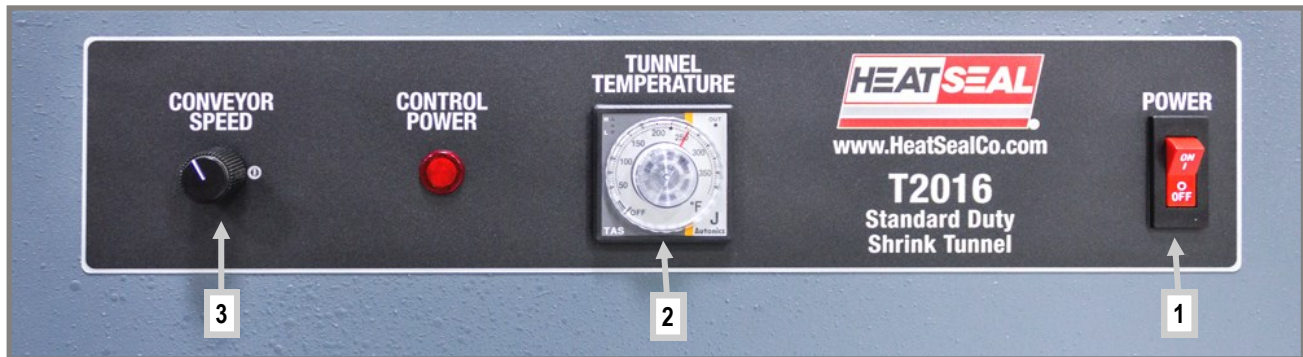
- Once the power is switched on, the tunnel can take up to 15 minutes to reach the set tunnel temperature.

## TEMPERATURE CONTROL

- The dial on the Shrink Tunnel (2) should be used as a reference point. Actual tunnel temperature may vary slightly.

## CONVEYOR SPEED CONTROL

- This dial (3) controls the speed of the conveyor. Turning the dial clockwise will increase the conveyor speed, and turning the dial counter-clockwise will decrease the conveyor speed.



## OPERATING INSTRUCTIONS

All shrink films require some experimentation with tunnel temperature, conveyor heat and speed to obtain the desired shrink for your needs. Not all shrink films shrink at the same settings. The tunnel you have purchased is a sophisticated piece of equipment that allows you to control the chamber and conveyor speed which allows the operator to turn out professional looking packages day after day.

## OPERATING THE TUNNEL

- Turn the circuit breaker switch to "ON". (1)
- Start by setting the temperature control (2) indicator to 350° on the dial.
- Allow the tunnel to run for 10 to 15 minutes.
- Adjust the conveyor belt speed (3) to attain your required packages per minute rate.
- Run some packages. If the package is getting too much heat, speed up the conveyor by turning the knob clockwise. Adjusting the conveyor speed is the most expeditious way to achieve a properly shrunk package almost immediately.

In order to achieve the most economical tunnel operation, you should use the lowest temperature setting required to obtain your desired shrink and rate of production.

You can achieve the same results by adjusting the temperature of the chamber and the conveyor belt speed, but you must remember that the chamber needs time to even out. This type of tuning can take some time and patience to achieve.

If you get to the point where the conveyor is running too slow for your production, increase the tunnel chamber temperature.

A trouble shooting guide has been included with your system. Contact your Heat Seal Authorized Distributor for further assistance with your application.

Revised 2016



**PROBLEM:** FILM SPLITS ALONG CENTER FOLD  
**SOLUTION:** CHECK FOR DAMAGE TO FILM ROLL.



**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.

