CLEVELAND
EQUIPMENT & MACHINERY COMPANY

CE-3000-HVE

Solid-ink Coding Continuous Sealer

Operation Manual

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Contents

I. Use

This sealer is suitable for sealing all kinds of plastic films, which is widely used in fields of food, medicine, chemicals, etc. It is the best sealing equipment for packing batch products from factories and shops.

II. Safety Precautions

2.1. Make sure the adopted power supply is correct.

The machine adopts AC 110V. The yellow and green wire is the ground wire and cannot be removed.

2.2. After the power is connected, do not touch any electrical parts.

2.3. .

2.4. When the machine is on, do not touch any moving parts.

2.5. When the machine is on, do not touch heating blocks or ink roller heating block.

2.6. Do not operate the machine in a corrosive environment.

2.7. Do not change any parts of the machine.

2.8. Keep the machine clean (both inside and outside), and clear of dirt from sealing belt.

2.9. Oil the gear and sprocket with semiliquid gear oil. Fill and exchange oil in worm-gear box regularly.

2.10. Turn off the power when not use. Allow the machine to run long enough to cool down.

2.11. Keep this manual near the machine, for easy reference.

III. Main Specification

Model Items	Horizontal mode	Vertical mode
Voltage	AC 110V/60	
Power	50W	
Sealing Power	300×2（W）	
Printing power	40×2（W）	
Sealing speed	0~16（m/min）	
Sealing width	8 、10（mm）	
Temperature controller	0~300（℃）（Stepless adjustable）	
Height from sealing center to conveyor	10~40 （mm）	200~320 （mm）
Film thickness (monolayer)	≤0.08 mm	
Max. single conveyor loading	≤1 Kg	
Max. overall conveyor loading	≤3 Kg	
Dimension (LXWXH)	950×400×430（mm）	950×400×640（mm）
Net Weight	45 Kg	50 Kg

IV. Performance Features

This sealer uses an electronic thermostat control unit and stepless speed-adjusting transmission mechanism. It can seal various plastic film bags in different materials and can also be used with varied packaging production lines. The machine has no limitations on sealing length with high efficiency continuous sealing, reliable sealing quality, and convenient operation.

V. Structure & Working Principle

This machine is made up of the machine frame, speed regulator, sealing temperature control system, transmission and conveyor system, and printing device (see Diagram).

The sealing and printing transmission are driven by one motor, which drives the sealing belts, guiding belts and conveyor belt to work synchronously, as well as make printing mechanism working intermittently.

5.1 Once the power is turned ON, the electrothermal elements start to produce heat, which leads to a rapid temperature rise of both upper and lower heating blocks.

5.2 Adjust the temperature control and speed control to the required temperature and speed for your application.

5.3 The plastic packing bag is transferred by the conveying belt, and its sealing part will be guided into the clearance between two sealing belts,

5.4 The bag is clamped by two sealing belts and conveyed into the heating area.

5.5 Sealing belts are pressed by two heating blocks and impressing wheels which fuse the plastic film together.

5.6 The sealed bag is conveyed into the cooling area for cooling.

5.7 The sealed bag is pressed by embossing wheel to make stripe or netted pattern.

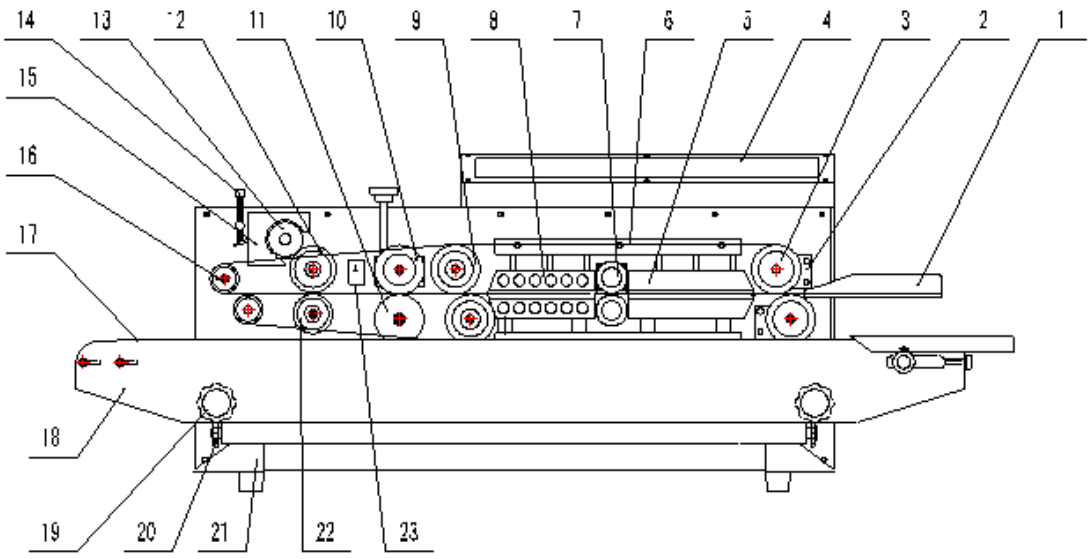


Diagram 5.1

1	101035	Guide Plate	13	911005W (white) 911005B (black)	Solid Ink Wheel
2	101023	Adjusting Block of Driven Wheel	14	101528	Ink Wheel Swing Arm Adjusting Bolt
3	101021	Driven Wheel	15	201002	Ink Wheel Heating Block
4	101502	Control Plate	16	105023	Guiding Wheel
5	930301T (top) 930301B (bottom)	Heating Block	17	910801	Conveyor Belt
6	901903	Sealing Belts (Top/Bottom)	18	101501	Conveyor Table
7	101503	Impressing Wheel	19	930111	Fastening Knob-Lifting Conveyor Table
8	930302T (top) 930302B (bottom)	Cooling Block	20	101512	Conveyor Horizontal Adjust Tightening Knob
9	105022	Driving Wheel	21	101504	Ledge
10	101018	Pattern Printing Wheel	22	105009	Silicone Wheel
11	101036	Rubber Wheel	23	940705	Sensor
12	201013	Printing Wheel			

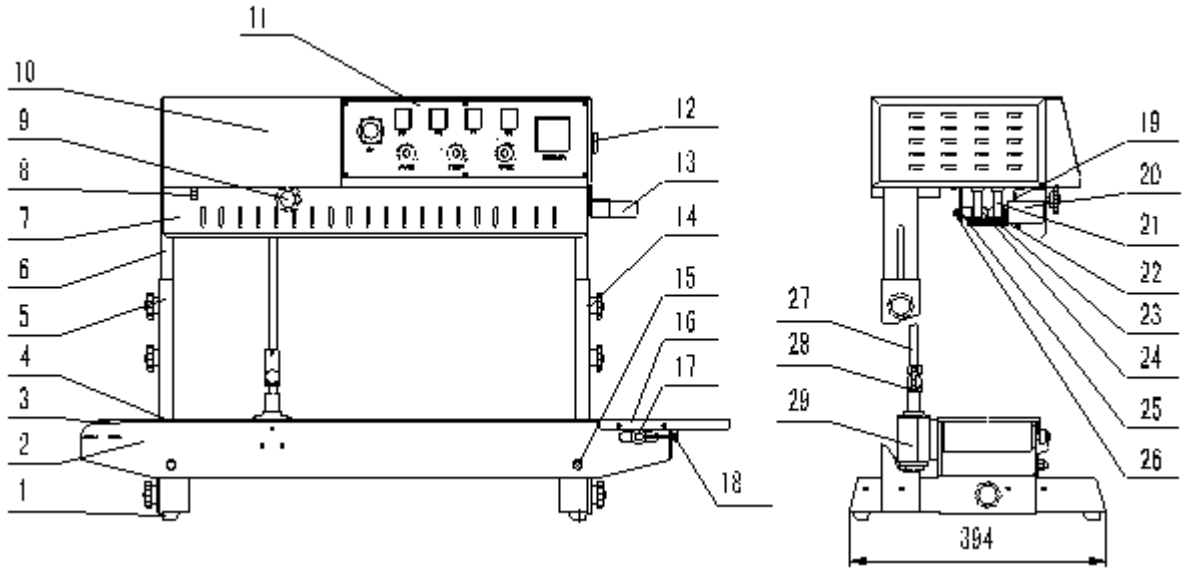


Diagram 5.2

1	101506	Base	16	101006	Working Table
2	101501	Conveyor Table	17	105026	Adjusting Block of Conveyor Belt
3	101012	Driving Roller	18	930113	Adjusting Knob of Conveyor Belt
4	101505	Conveyor Belt	19	105005	Upper Splint
5	101504	Fixed Bracket	20	201002	Ink Wheel Heating Block
6	101507	Slip Bracket	21	101513	Guiding Wheel Shaft
7	101508	Safety Guard	22	101530	Guiding Wheel
8	201016	Ink Wheel Swing Arm Adjusting Knob	23	910801	Guiding Belt
9	101509	Pattern Printing Wheel Adjusting Knob	24	930301U (upper) 930301L (lower)	Heating Block
10	101510	Machine Body	25	105005	Lower Splint
11	101502	Control Plate	26	910903	Sealing Belt
12	101511	Machine Breaker	27	101520	Vertical Shaft
13	101035	Guide Plate	28	101514	Universal Joint Assembly
14	101512	Fastening Knob	29	101515	Umbrella Gear Wheel Assembly
15	93011	Tightening Nut			

VI. Operational Use

6.1. Control Panel (See Diagram 6.1)

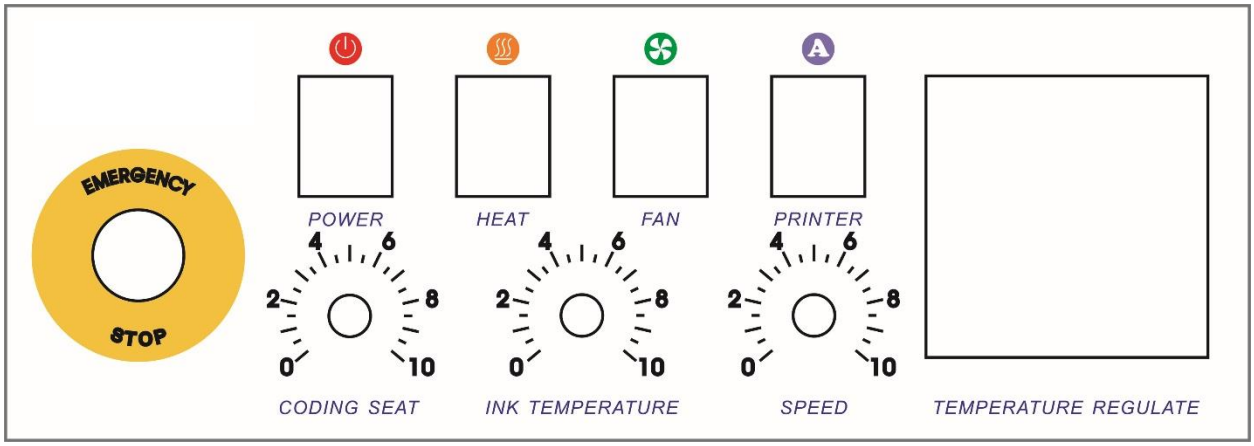


Diagram 6.1

6.2. Prepare the machine for use

6.2.1. This machine is equipped with a three-prong grounded socket. Be sure that the socket is well connected for safe operation.

6.2.2. First-time use or too long intermission will make the heating elements damp. It is necessary to preheat at lower temperature for several minutes before the normal operation.

6.2.3. Adjust the height and position of the conveyor table to get the required sealing position for your application.

6.2.4. Adjust the position of feed opening according to the external size from sealing line to bag opening.

6.2.5. According to the thickness and material that to be sealed, adjust the clearance between two heating blocks and two cooling blocks, so that both clearances are approximately equal to the thickness of packing bag in one layer. This will guarantee sealing firmness and high definition of embossing, and ensure a suitable length extended from the two ends of seal.

6.3 Sealing Belt Adjustment / Replacement

6.3.1 Remove the safety cover, after the heating blocks cool, turn stopping flakes on both upper heating block and upper cooling block by 90° to lift both, then loosen the springs on both embossing roller and pinch roller, meanwhile, remove the guiding belt, to prepare it for removing sealing belts. (see Diagram 6.2)

6.3.2 Move the driven wheel seat (adjusting block) towards heating block and remove the sealing belt.

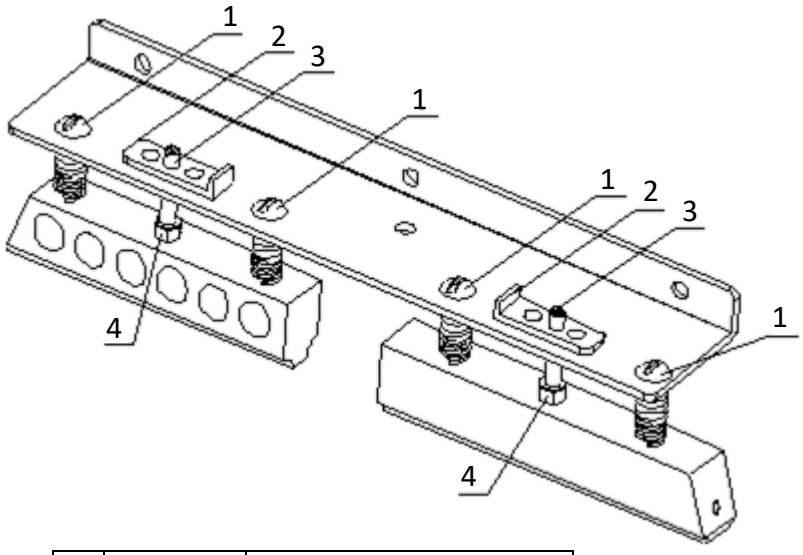
6.3.3 Replace with a new sealing belt and install the guiding belt back.

6.3.4 Put the driven wheel, heating/cooling blocks, and pinch roller to the original position.

6.3.5 Connect to the power supply to test the machine. If irregular sealing appears on the belt, make adjustment by adjusting screws on the driven wheel seat (adjusting block)(see Diagram 6.3).

6.3.6 Install the safety cover. When the temperature reaches the set temperature, the machine is ready.

Diagram 6.2



1	101516	Bolt
2	101517	Withdraw Stopping Flake
3	101518	Tightening Bolt
4	101519	Nut

6.4 Drive Wheel Block Adjustment

If the sealing belt is off tracking, adjust the screws on driven wheel seat (adjusting block), shown as Diagram 6.4.

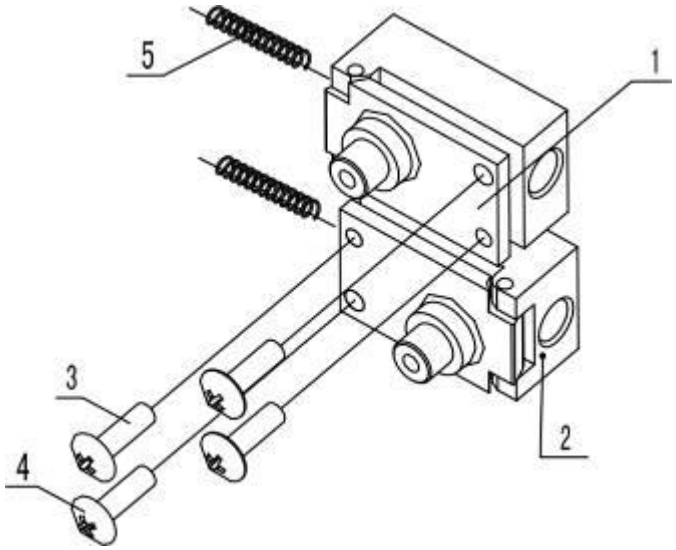


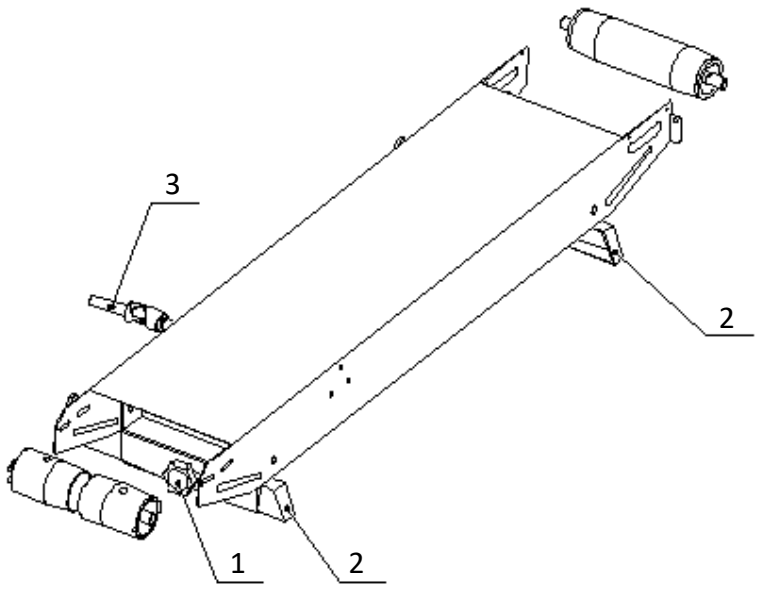
Diagram 6.3

1	driven wheel seat adjusting plate - Upper
	driven wheel seat adjusting plate - Lower
2	driven wheel seat adjusting block - Upper
	driven wheel seat adjusting block -Lower
3 / 4	adjusting screw
5	spring

6.5 Conveyor Belt Adjustment / Replacement

When making adjustments to the conveyor table, loosen two nuts (1) at the bottom of the conveyor table. There are three location holes on the housing (2), insert bolts in them as needed, then fasten the nuts. Then move the conveyor table and equip the connecting shaft (3) that would be in the spare parts into the universal joints. (see diagram 6.4).

Diagram 6.4



1	101521	Adjusting Knob
2	101522	Housing
3	105038	Universal Joint

6.6 Print Wheel Setup

This machine uses a solid-ink roller coding mechanism which is controlled by electromagnetic clutch intermittent mechanism.

6.6.1. Typeface Wheel Arrangement

The “R” Arrange typeface wheel has a horizontal / longitude text arrangement.

The “T” Arrange typeface wheel has a vertical, axial arrange text arrangement.

T arrange **R arrange**

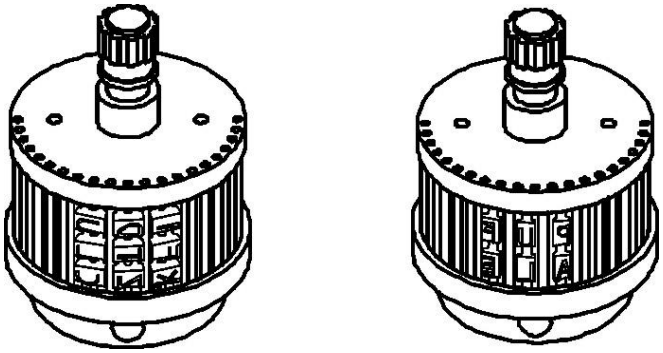


Diagram 6.6

6.7 Print Wheel Typeface Setup

Setting typeface on print wheel (see Diagram 6.7):

6.7.1. Turn the holding latch on the printing wheel cover to twist the traverse pin out of the groove, the printing wheel cover will then pop up. To remove its cover, press the silicon rubber bar. Replace the traverse pin into the groove of the cover and turn to fasten.

6.7.2. Then press the silicone bar on it and put printing wheel cover.

6.7.3. At last, insert the traverse pin back into the groove, and rotate for fastening.

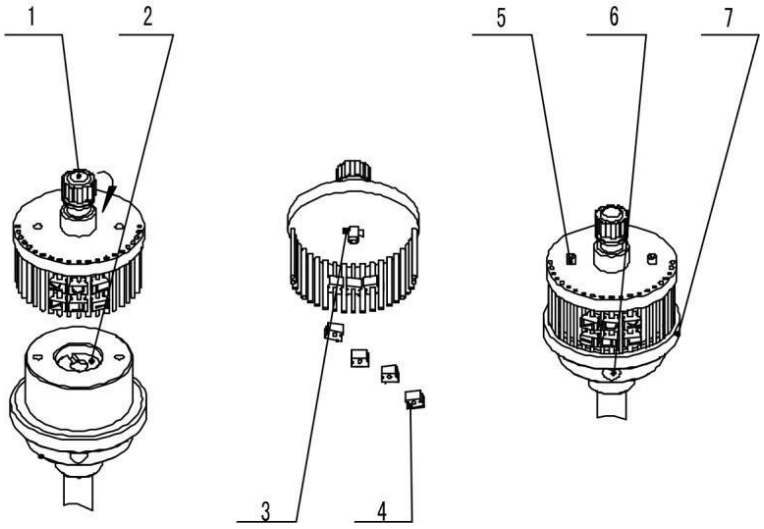


Diagram 6.7

1	201016	Holding Latch	5	101525	Fixed Pin
2	201015	Cover	6	101526	Print Wheel Holding Screw
3	101523	Traverse Pin	7	201013	Print Wheel
4	101524	Typeface Letters			

6.8. Ink Roller and Print Wheel Clearance Adjustment

Adjust the adjusting screw (5) for the ink roller's swing pole, rotate the printing wheel, and make the types' surface touch the ink roller's (1) surface slightly. If the ink roller can be easily driven by rotating the printing wheel with hand, it should be ok (see Diagram 6.8).

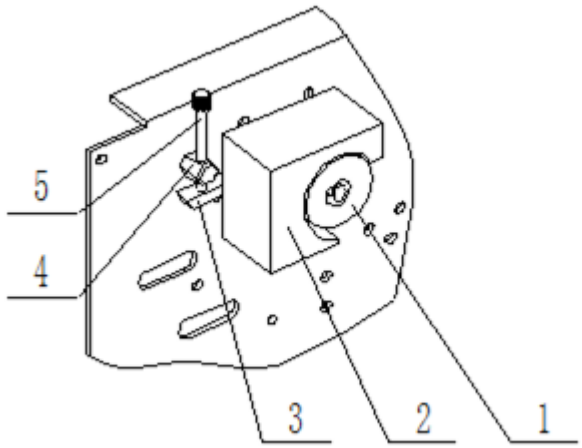


Diagram 6.8

1	911005	Ink Wheel	4	101528	Adjusting Pole
2	201002	Ink Wheel Heating Block	5	101529	Adjusting Bolt
3	101527	Swing Pole			

6.9 Print Wheel and Silicone Wheel Pressure Adjustment

The typefaces on the print wheel should not touch the silicone wheel when it is not in printing process. They only touch each other when the printing imprint is in process.

6.9.1. Loosen the screw (4) in the front of the silicone wheel, then rotate the eccentric sleeve (3), so as to make the types' surface slightly touch the silicone wheel's (2) surface.

6.9.2. If the machine is used to print relatively thicker packing bag, the screw should be loosened accordingly and the pressure may not be oversized, fasten the screw (4) after making adjustment (see Diagram 6.9).

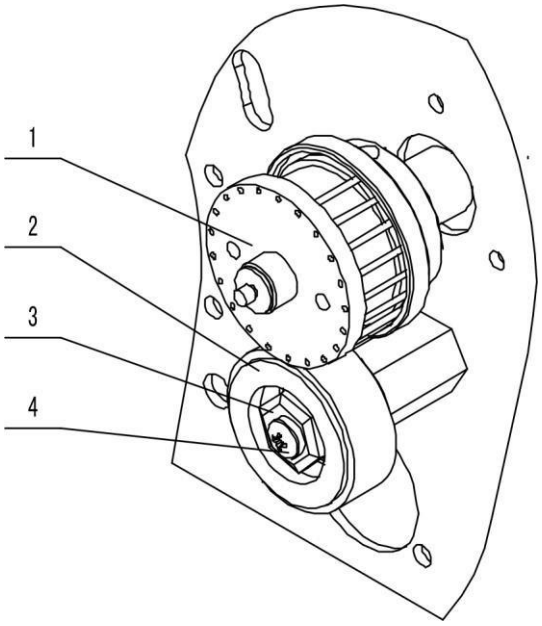


Diagram 6.9

1	201013	Print Wheel
2	101530	Silicone Wheel
3	101531	Eccentric Cover
4	101532	Bolt

6.10. Print Wheel and Ink Roller Temperature Adjustment

6.10.1. All the knobs of this machine are set to position 0 before leaving factory. Users need to make adjustments suitable to their specific application.

6.10.2. For a new ink roller or when there is extended time between previous use, the temperature should be relatively lower.

6.10.3. After a period of operation time, the temperature can be raised to higher degree, which can make the deep-seated ink ooze and prolong the ink roller's life-span.

6.10.4. When the ink roller reaches the working temperature, use a piece of white paper to touch the ink surface. As long as it can stick a little ink, it should be in position. The temperature can't be too high or too low.

6.10.5. The ink roller that is suited for this machine is specified in following table, including colors of white, yellow, red, blue, green, brown and black.

6.10.6. If the packing bag needs steam cooking after printing, you should choose the ink rollers of moderate temperature or high temperature.

Model	Outer diameter (mm)	Height (mm)
Low temperature series 120-150℃ (NO:935)	Φ36	16
	Φ36	32
	Φ36	40
Moderate temperature series 135-165℃ (NO:932)	Φ36	16
	Φ36	32
	Φ36	40
High temperature series 150-175℃ (NO:930)	Φ36	16
	Φ36	32
	Φ36	40

6.11. Adjustment of coding position

Users can set the coding position by adjusting the coding position knob according to the length of bag opening.

6.12. Adjustment of number of lines in printing label

Arrange types within stipulated range in **Section IV Performance Features**, and then use the provided silicone bar to secure the typefaces in required axial position.

6.13 Starting procedure

6.13.1 Connect to the power supply and press the Start switch, which will turn the indicator light on. You can then adjust the speed controller knob to the desired speed. All transmission parts start to run synchronously.

6.13.2 Fine tune the knob of embossing roller to make the wheel swivel and acheive the proper pressure.

6.13.3 Turn Heat Seal switch ON, the green light of the electronic temperature controller will light up. According to the material and thickness of the packing bag, adjust the temperature controller to the necessary temperature. When the heating blocks begin to preheat, the machine needs to be started and kept running at low speed.

6.13.4 According to the material and thickness that is being sealed, turn on the cooling fan if your application requires.

6.13.5 Flatten and align the bag opening, then feed the bag by aligning the bag opening with the guide plate. The bag opening is gripped by the sealing belts, which will make the bag move forward automatically. At that momento, do not push it in or pull it out by force, otherwise irregular sealing or breakdown will happen.

6.13.6 If there is dirt attached to the sealing belt or the heating block, stop the sealer and clear it. Never clear the dirt with your hand when the temperature is high.

6.13.7 Stop operation

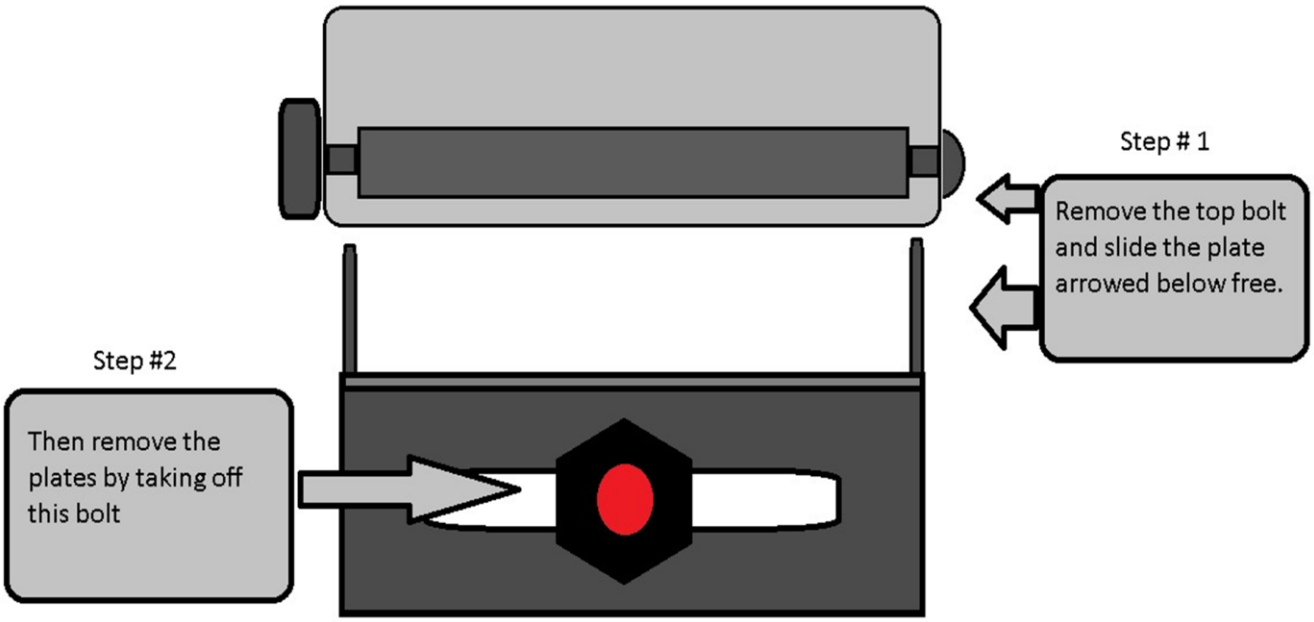
In order to prolong the service life of the sealer, before shutting down the machine, you should return the temperature setting to “0” and turn on the fan. The temperature on the indicator will begin to fall and the sealing belts should still be running. Once the temperature drops below 100℃, can you turn off the fan and main power.

6.13.8 Emergency stop switch:

At any time, the machine can be stopped immediately by pressing the emergency stop switch. The emergency stop switch is a self-locking switch, and needs to rotate clockwise 120 degrees to open after self-lock.

VII. Riser Plate Install

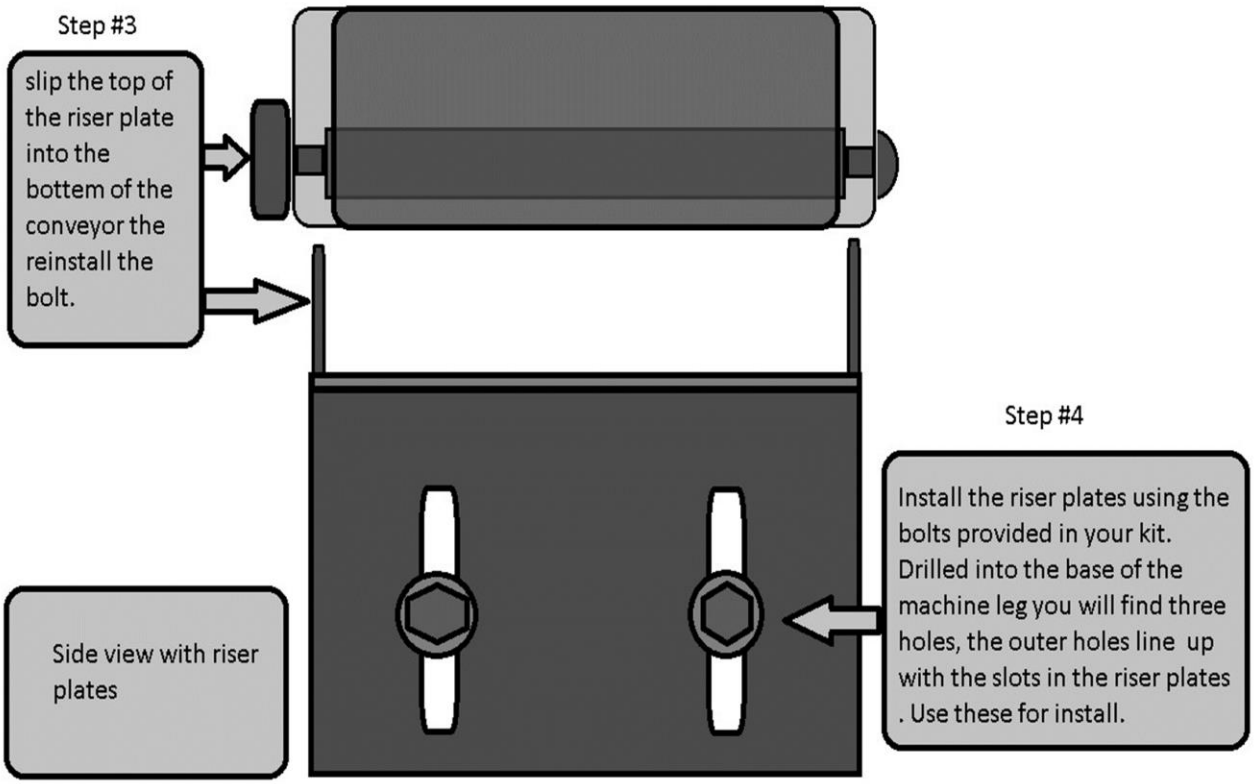
Standard front view of the conveyor table



Side view of conveyor with original plates

Step #3

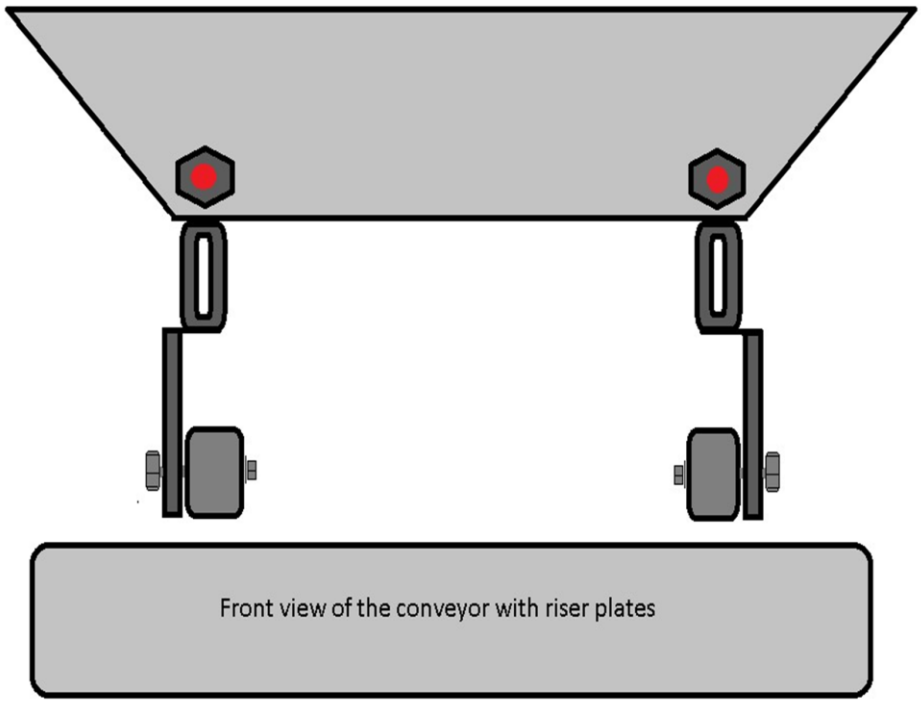
slip the top of the riser plate into the bottem of the conveyor the reinstall the bolt.



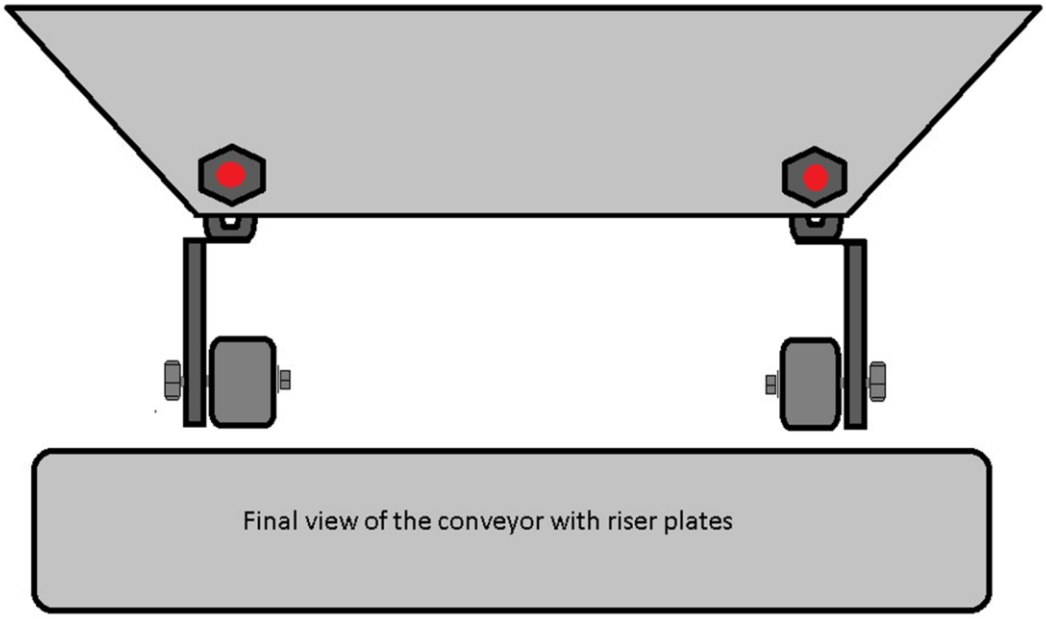
Step #4

Install the riser plates using the bolts provided in your kit. Drilled into the base of the machine leg you will find three holes, the outer holes line up with the slots in the riser plates . Use these for install.

Side view with riser plates



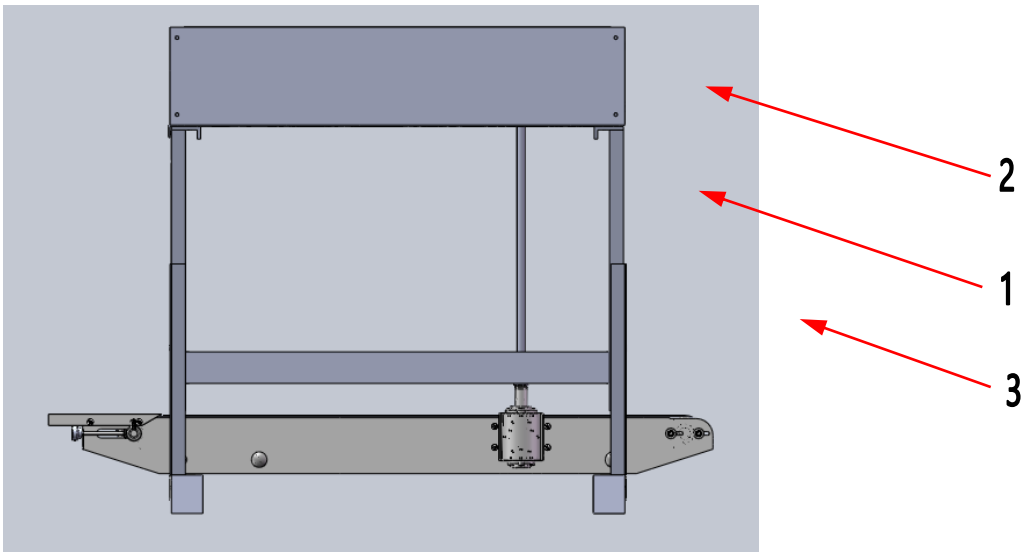
Front view of the conveyor with riser plates



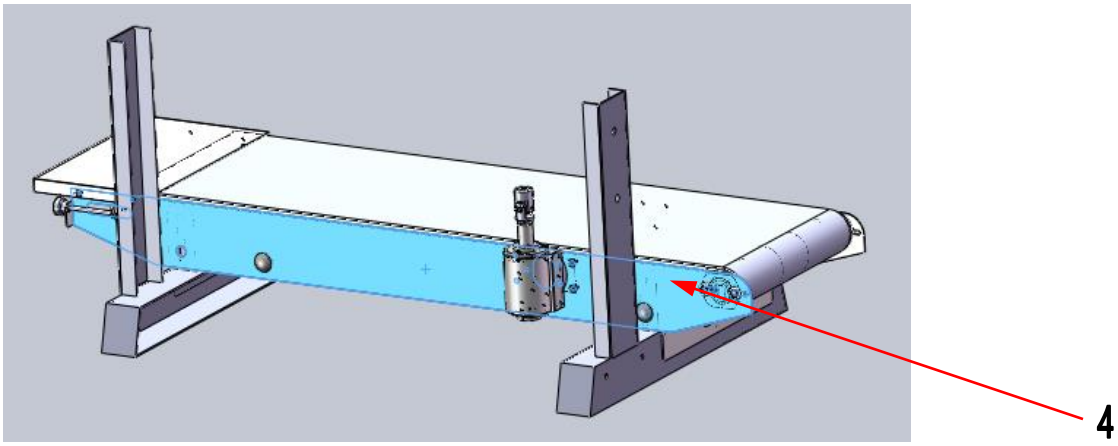
Final view of the conveyor with riser plates

VIII. CE-3000-HVE Vertical to Horizotal Guide

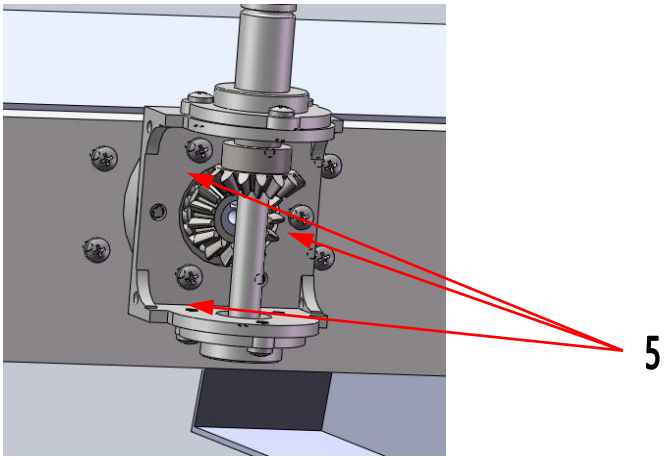
8.1 Remove the vertical shaft 1,loose the knob of fixed bracket 3,then remove the Main Unit



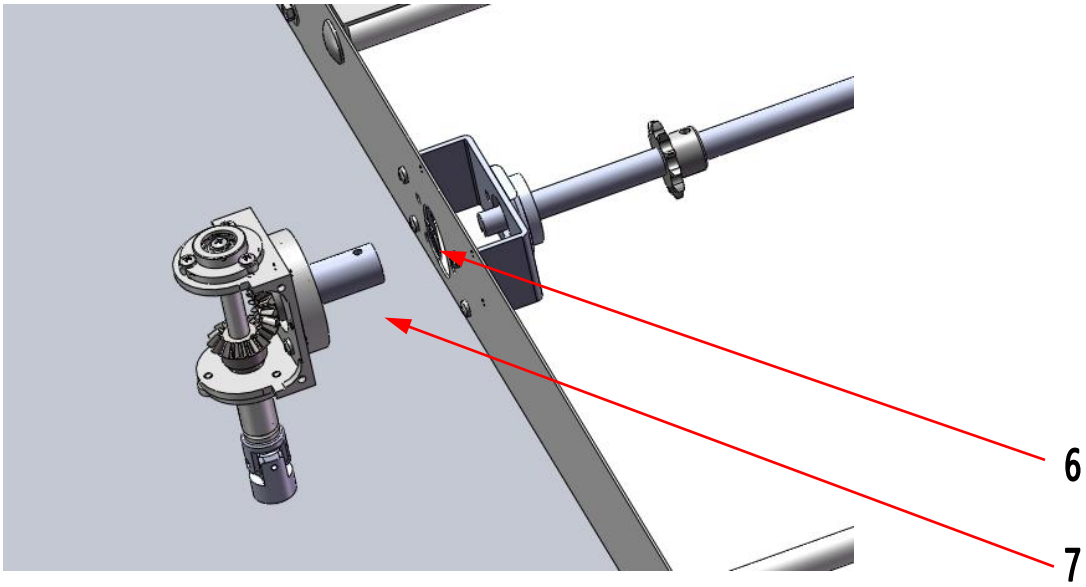
8.2 Remove the guard board 4.



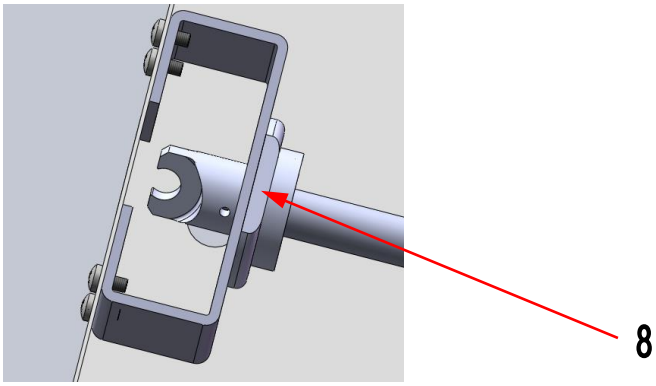
8.3 After removing the guard board, remove the three screws (5) as the photo shows below.



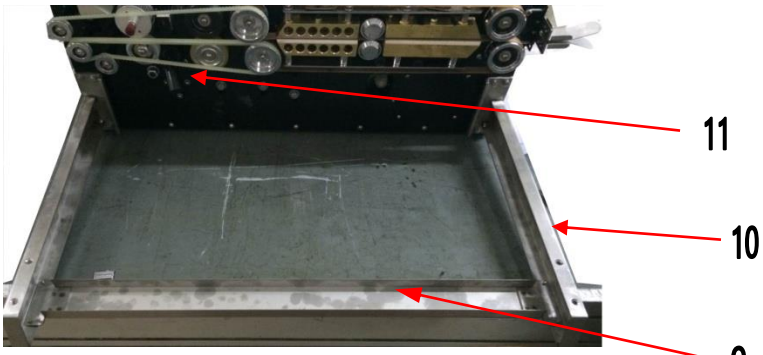
8.4 Remove the conveyor and flip backwards 180° on the platform, set off the conveyor belt. Loosen the screw (6) as the photo shows below and you can remove the whole sets of the bevel gear seat (7).

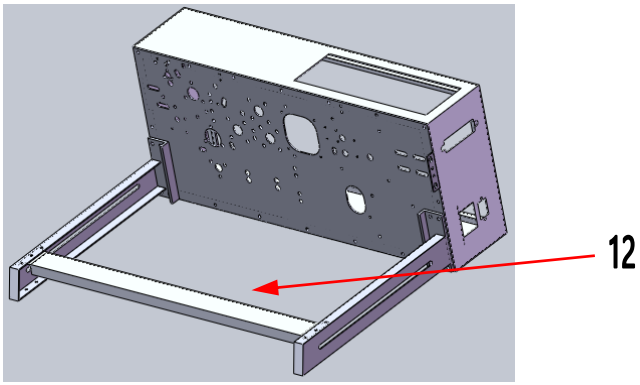


8.5 Install the joint (8) from the spare parts bag to the middle shaft of the conveyor and tighten the screw of the joint



8.6 Remove the ledge (9) and install it as the photo (12) shows. Install it on the other side of the bracket). Install the mat from the spare parts bag to the main unit and the stand.



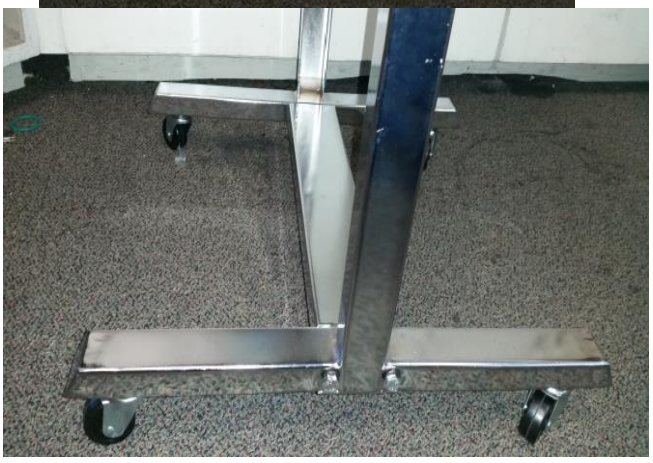


8.7 Install the gimbal to the conveyor, and install the whole conveyor to the foot of the machine hull (10), then use the gimbal connecting the conveyor to output shaft of the main unit

IX. CE-3000 Stand Assembly

Included Parts:

Assemblied Stand:



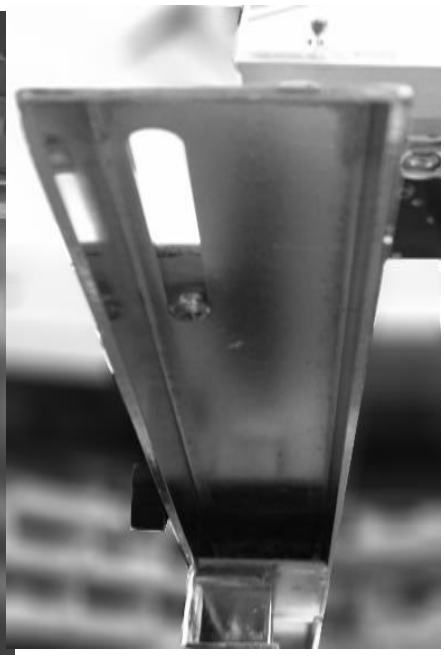
Stand Assembly

Included are
2 each - Legs
-Look like a “T” with two holes drilled into the long end.

2 each - Risers
- Look like a “T” with a slit cut into the long end.

These two pieces slide together using the long ends, the slotted T is at the top and slides into the inside of the bottom T.

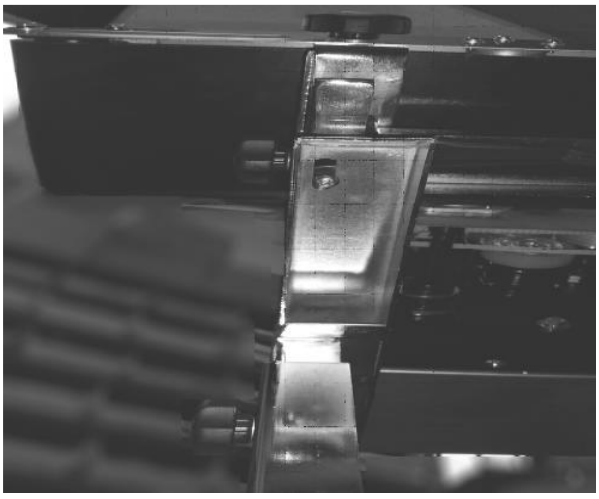
4 knobs
4 screws with round backs
4 washers



Use these together through the two holes on the risers of the “T”s and you will end up with two matching sides that look like Upper Case “I”s .

Support Bar(s) – CE-2500 (Qty 1)
CE-3000 (Qty 2)

The CE-2500-HVE has one other large piece in the kit and the CE-3000 has 2 pieces. These pieces will go between the two sides with the short end with the holes to the side. On the side pieces you will find corresponding holes 2 on each side for the CE-2500 and 4 on each side for the CE-3000, use the provided long bolts through the outside and into the threads on the middle supports.



Included are screws that screw into the bottom of the machine where the rubber feet usually are. Unscrew the feet from the machine and screw the Philips head screw through the bottom of the top of the stand and into the holes that held the feet.

X. Electrical Diagram

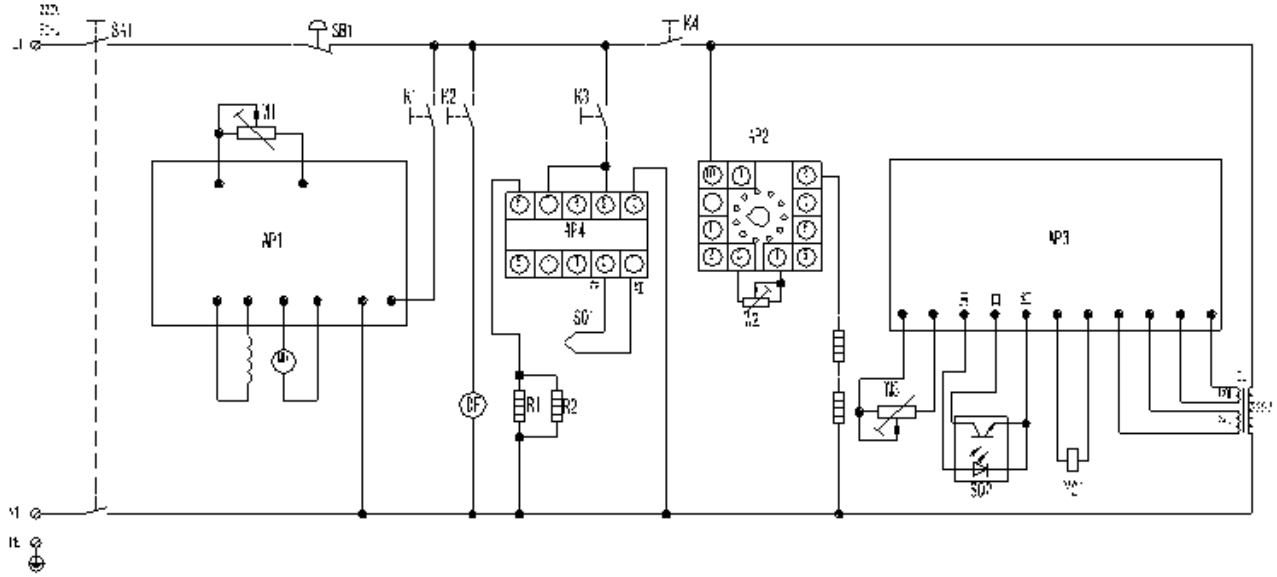
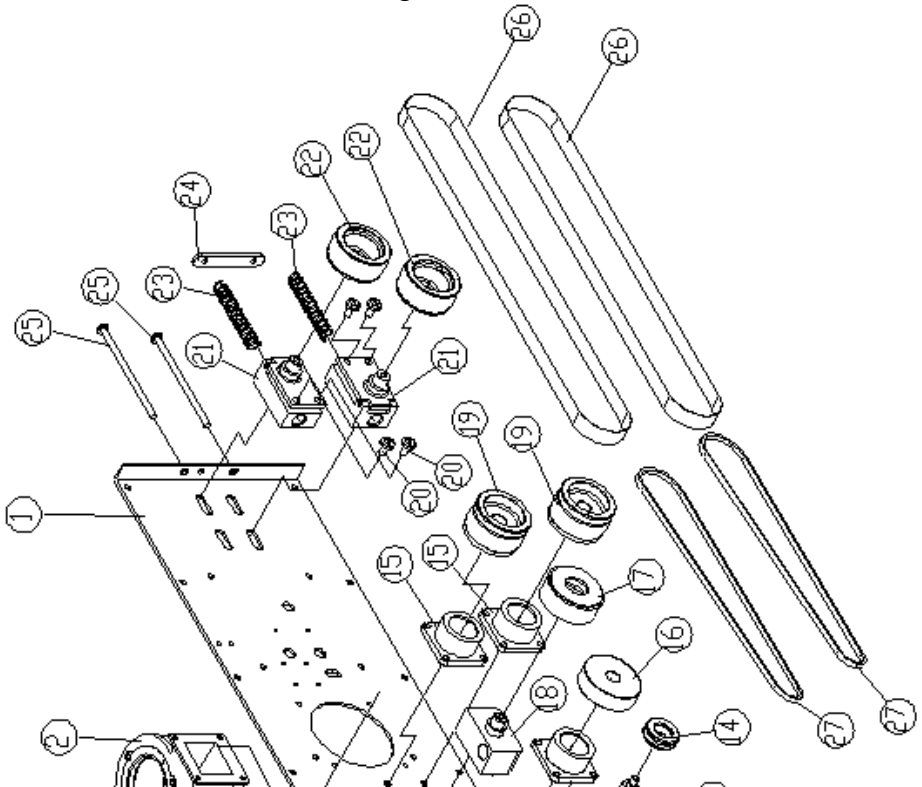


Diagram 10.1

SA1	Switch on/off	MD	Speed Adjusting Motor
SB1	Emergency Stop Switch	DF	Fan
K1	Switch/Work	AP1	Speed Adjusting Board
K2	Fan Switch	AP2	Ink Roller Temperature Board
K3	Heat Seal Switch	AP3	Main Control Board
K4	Printer Switch	AP4	Temperature Controller
W1	Heating Seal Speed Adjustment	YC1	Magnetic Clutch
W2	Ink Roller Temperature	SQ1	Thermocouple
W3	Coding Position	SQ2	TCL Control Transformer
R1 , R2	Heat Seal Heating Tube		
R3 , R4	Ink Roller Heating Tube		

XI. Sealing Unit Parts List

Diagram 11.1

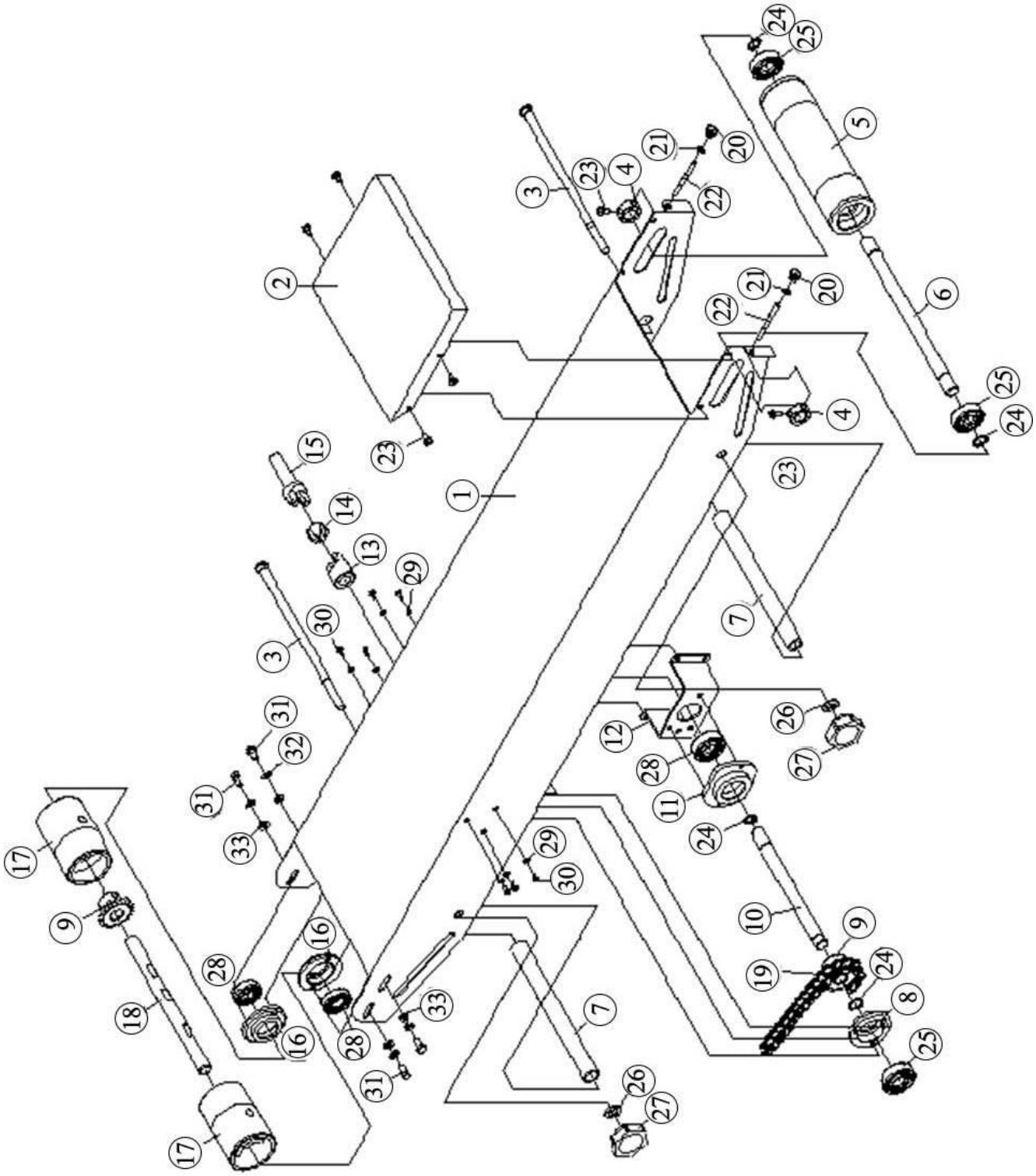


Sealing Unit Parts List

	Part number	Quantity	Name	Remark
1	105003	1	Bottom Board	
2	921102	1	Fan (Cy063)	
3	101027	2	Driving Belt Wheel Shaft	
4	101032	3	Bearing	
5	105030	1	Connecting Gear	
6	105013	1	Connecting Shaft Bearing Seat	
7	105041	1	Rubber Wheel Axle	
8	105012	1	Gear Wheel Shaft	
9	105011	1	Gear Wheel	
10	105020	1	Driving Chain Wheel	
11	A10503	1	Worm Wheel Box Assembly	
12	105038	1	Worm Wheel Output Gear Wheel	
13	101015	2	Guiding Wheel Shaft	
14	105023	2	Guiding Wheel	
15	101026	3	Square Bearing Seat	
16	101036	1	Rubber Wheel Aseembly	
17	101018	1	Pattern Printing Wheel	
18	101017	1	Embossing Wheel Seat	
19	105022	2	Driving Belt Wheel	
20	112044	4	Adjusting Bolt	
21	101023	2	Driven Wheel Seat	
22	101024	2	Driven Wheel	
23	101533	2	Driven Wheel Seat Spring	
24	101062	1	Connecting Piece	
25	101534	2	Adjusting Bolt	
26	910903	2	Sealing Belt 810×15×0.2	
27	910801	2	Guiding Belt 598×4.5×3.5	
28	101535	1	Adjusting Spring Of Pattern Printing Wheel	
29	101536	1	Embossing Wheel Adjusting Supporting Board	
30	101509	1	Adjusting Knob Of Pattern Printing Wheel	
31	101537	1	Motor	

XII. Conveyer Parts List

Diagram 12.1

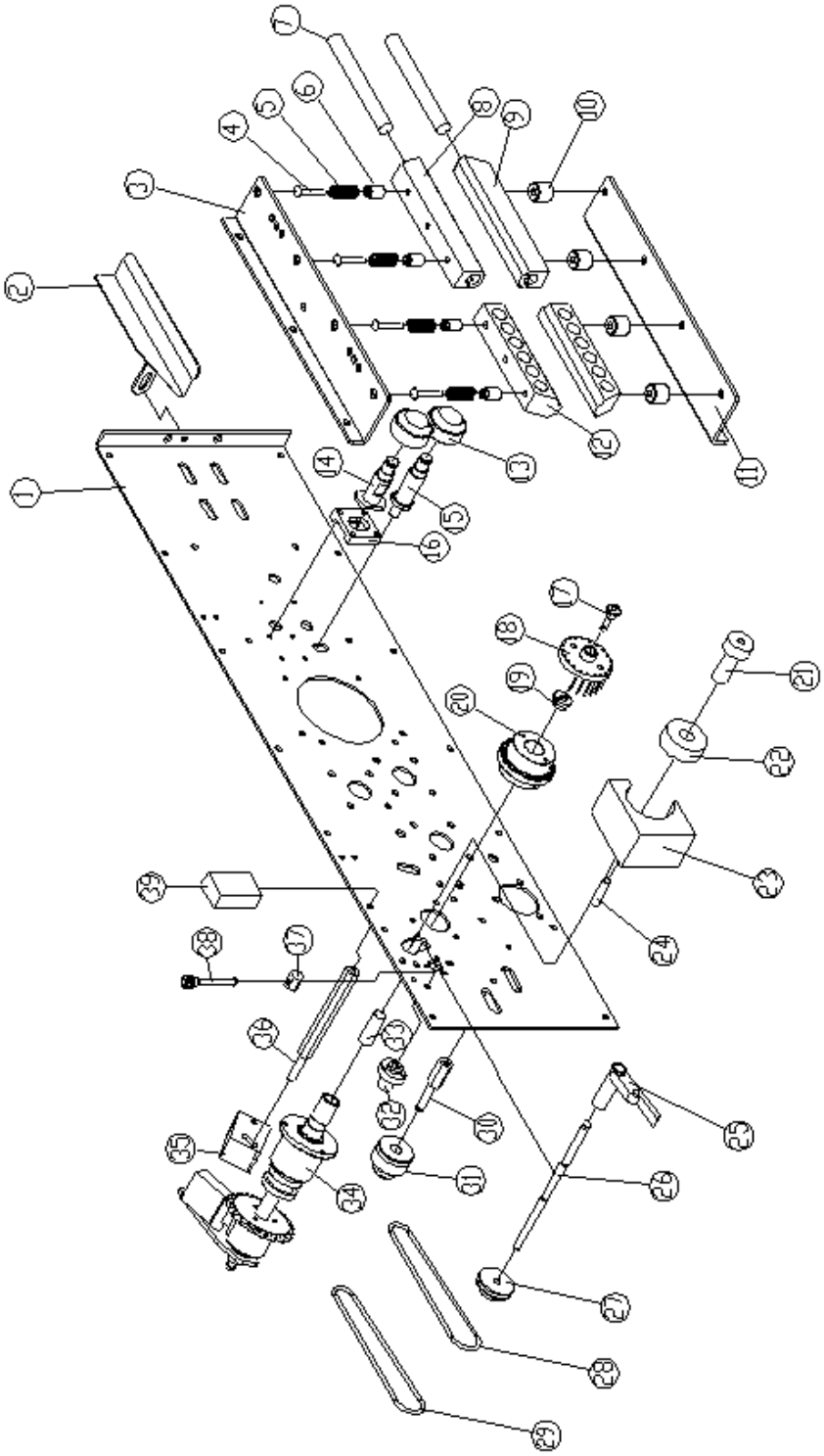


Conveyer Parts List

Code	Part number	Quantity	Name	Remark
1	10501	1	Conveyor Table	
2	101006	1	Working Table	
3	GB12-1988	2	Half Round Square Neck Bolt	
4	105026	2	Adjusting Block Of Conveyor Belt	
5	101005	1	Back Roller（Assembly Part）	
6	101008	1	Back Shaft Of Conveyor Table	
7	112071	2	Separating Tube	
8	101013	1	Conveyor Middle Shaft Bearing Seat II	
9	101010	2	Chain Wheel Of Conveyor Table	
10	105015	1	Middle Shaft Of Conveyor Table	
11	101003	1	Conveyor Middle Shaft Bearing Seat II	
12	111063	1	Middle Shaft Underlay Plate	
13	105038	1	Connector	
14	105038	1	Connecting Ball	
15	105038	1	Adjusting Shaft	
16	101013	2	Front Roller Shaft Bearing Seat	
17	101012	2	Front Roller	
18	105205	1	Front Roller Shaft	
19	930603	1	Conveyor Chain	
20	930113	2	Adjusting Nut Of Conveyor Belt	
21	GB/T818-2002	2	Small Washer	Φ4
22	GB901-1988 B grade	2	Double Head Blot	M4×40
23	GB/T818-2000	6	Blot	M4×8
24	GB/T891-1986B	4	Shaft Use Baffling Ring	Φ12
25	930512	2	Bearing180201	Φ32×Φ12×10
26	GB95-2002	2	Washer	Φ8
27	930111	2	674knob	
28	930516	4	Bearing180101	Φ28×Φ12×8
29	GB/T848-2002	7	Flat Washer	Φ3
30	GB/T818-2000	7	Blot	M3×6
31	GB/T818-2000	4	Blot	M5×10
32	GB859-1987	4	Spring Washer	Φ5
33	GB95-2002	4	Flat Washer	Φ5

XIII. Components / Printer Parts List

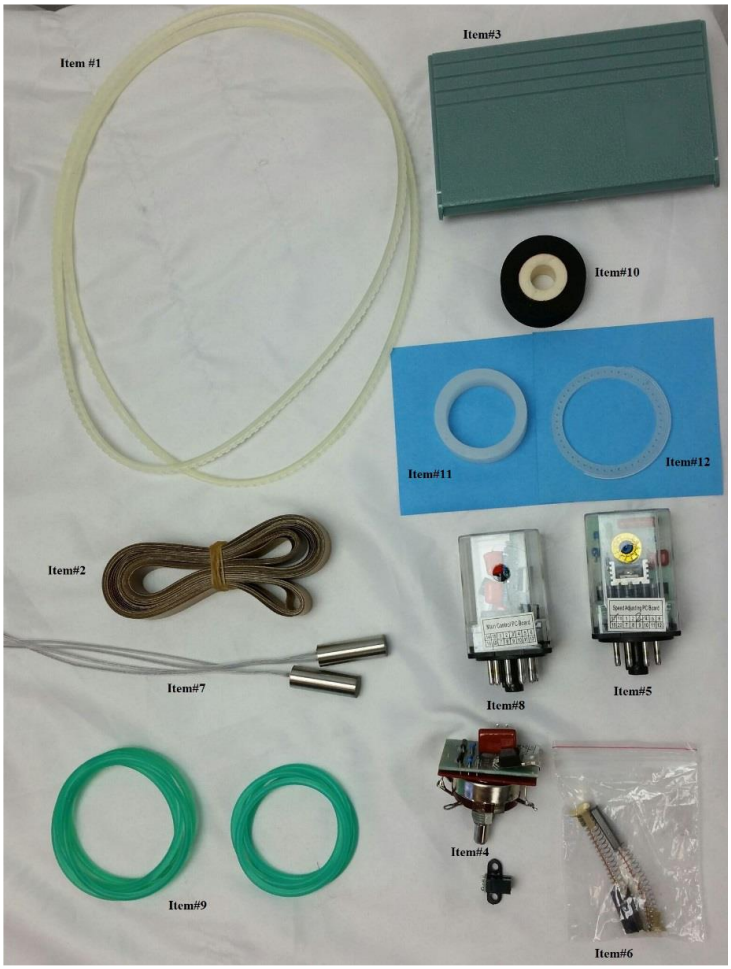
Diagram 13.1



Components / Printer Parts List

Code	Part number	Quantity	Name
1	105003	1	Bottom Board
2	101035	1	Feed Opening
3	105005	1	Upper Splint
4	101538	4	Bolt
5	101539	4	Copper Block Spring
6	101540	4	Upper Holding Plate Guiding Cover
7	921303	1	Heating Tube (Seal Heating)
8	930301U	1	Upper Heating Block
9	930301L	1	Lower Heating Block
10	101050	4	Heating Block Support
11	105005	1	Lower Splint
12	930302U 930302L	2	Upper Cooling Block Lower Cooling Block
13	105009	2	Impressing Wheel
14	105007	1	Upper Pressing Wheel Shaft
15	105008	1	Lower Pressing Wheel Shaft
16	105017	1	Slippery Seat
17	201016	1	Printing Wheel Bolt
18	201014	1	Printing Wheel Cover
19	201015	1	Printing Wheel Shaft End Cover
20	201013	1	Printing Wheel Holder Assembly
21	201008	1	Ink Wheel Cover
22	911005	1	Ink Wheel（Φ35×32)
23	201002	1	Ink Wheel Heating Block
24	921301	1	Ink Roller Heating Block Heating Tube
25	201007	1	Ink Roller Swing Pole
26	105036	1	Ink Wheel Shaft
27	105039	1	Ink Roller Shaft Belt Wheel
28	910209	1	Small Adhesive Tape　Φ3×60（O Model Ring）
29	910208	1	Small Adhesive Tape　Φ3×50（O Model Ring）
30	105035	1	Middle Belt Wheel Shaft
31	105032	1	Middle Belt Wheel
32	201006	1	Ink Roller Swing Pole Shaft Seat
33	921301	1	Electric Heating Tube Φ10 110v 40w (Print Wheel Shaft）
34	101541	1	Electromagnetic Clutch Assembly
35	101542	1	Carbon Brush Holder
36	101543	1	Brush Support
37	101544	1	Ink Wheel Swing Arm Adjusting Pole
38	101545	1	Ink Wheel Swing Arm Adjusting Knob
39	940705	1	Sensor

XIV. CE-3000 HVE Parts Kit



Included with the CE-3000 HVE Continuous Band Sealer is a parts kit with the following:

Item#	Qty.	Part#	Description
1	2	910801	Guiding Belt (Rubber Belt with teeth) - 598x4.5x3.5mm
2	2	910903	Sealing Belt (Teflon) – 880x15x0.2mm
3	1	3000-PRKit	Printing Kit
4	1	W1	Potentiometer (Speed Dial)
5	1	AP1	Speed Adjusting Board
6	2	3000-CB	Carbon Brush
7	2	3000-PHE	Printer Heating Element
8	1	AP3	Main Control Board
9	6	3000-DRB	Drive Bands for printer
10	1	911005B	Black Ink Wheel
11	1	101530	Silicone Wheel
12	1	3000-SL G	Silicone Letter Guard for Print Wheel

XV. Troubleshooting

Problem	Reason	Solution
Sealing belt is off-track.	The Driving wheel shaft is not parallel to the driven wheel shaft.	Adjust two adjusting screws on driven wheel seat.
Sealing belt is easy to break.	1.Too much tension on sealing belt. 2. Sealing belt is off track. 3. Crease on sealing belt. 4. Adhesive film or other dirt attached to sealing belt surface. 5. Sealing belt is easy to burn.	1. Adjust the vertical adjusting screw on driven wheel seat, to loosen sealing belt. 2. （see the point above） 3. No crease on sealing belt. 4. Clean sealing belt surface. 5. Clearance between two heating blocks is too small or temperature is too high.
Embossing is not clear	1. Embossing wheel is worn out. 2. Pressing spring on embossing wheel is not tightened enough.	1. Replace embossing wheel 2. Adjust the embossing wheel's tightening spring
There is resistance when the sealing belt is conveying.	The clearance between heating blocks or cooling blocks is too small, the friction is too much.	Adjust the clearance between sealing belts properly, which should be about the thickness of the packing bag in one layer, to ensure strong sealing and clear printing, and prevent sealing ends from extending too long.
There is a block or fold phenomenon when the packing bag is conveyed to the pressing wheel or embossing wheel.	Too much pressure is caused by the pressing wheel or embossing wheel.	1. Adjust the pressing wheel or embossing wheel to the proper pressure, which should be about the thickness of the packing bag in one layer, to ensure strong sealing and clear printing, and prevent sealing ends from extending too long. 2. Adjust the limiting screw after adjusting clearance.
Conveyor belt is off-track.	The driving roller shaft is not parallel to the driven roller shaft.	Adjust the two adjusting screws of the driven roller shaft (rear shaft) on conveyor.
Conveyor belt and sealing belt don't move synchronously.	Tension on conveyor belt is loose.	1. Tighten the chain of driving roller shaft (front shaft) and middle shaft properly. 2. Tighten the conveyor belt properly.
Ink roller printing mechanism doesn't work.	1. The power supply is not connected. 2. Main control PC board is not inserted in place or poor contact. 3. Main control PC board is damaged.	1. Check whether the power line is connected and indicating light is on. 2. Check whether plug for PC board is inserted in place or wire end falls off. 3. Check and replace PC board.
Printing wheel doesn't work.	1. Start sensor's touching head is blocked. 2. Start sensor is not clean, whose hole is blocked by dust. 3. Main control PC board has been damaged 4. Round pin on clutch falls off or is damaged. 5. Electromagnetic clutch's wire is broken.	1. Clean the obstacle. 2. Clean the dust on sensor's surface. 3. Check and replace PC board. 4. Repair round pin. 5. Repair clutch.
Printing wheel doesn't stop.	1. Sensor (groove sensor) is damaged, moved, or its surface covered by dust. 2. Main control PC board is damaged.	1. Replace or correct position of sensor or clean its surface. 2. Check PC board and replace it.

Problem	Reason	Solution
No heat for ink roller heating block or printing.	1. Heating pipe or wire is damaged 2. Heating PC board is damaged 3. The potentiometer on knob is damaged 4. Carbon brush seat is not in place. 5. Carbon brush is damaged	1. Replace heating pipe. 2. Replace PC board. 3. Replace potentiometer. 4. Adjust and tighten nut then. 5. Replace.
The temperature of heating block for ink roller printing mechanism is out of control.	The relay for temperature control PC board is damaged.	Check and replace temperature control PC board.
The printing position is out of control.	1. Tightening screw on printing wheel is loose. 2. Main control PC board is damaged.	1. Tighten the screw. 2.Check and replace PC board.

XVI. Helpful Links

Scan the QR code or enter the web address in your browser to view these helpful links for setup videos and more information on the CE-3000 Continuous Band Sealer.

**The information for the CE-2500-HVE is general and applicable to the CE-3000-HVE also.

	CE-3000-HVE band sealer product page on our website https://clevelandequipment.com/ce-3000-hve-continuous-band-sealer.html	
	CE-3000-HVE Demo Video https://www.youtube.com/watch?v=sFN4ZdN5POk#t=46	
	CE-3000-HVE Ink Wheel Setup https://www.youtube.com/watch?v=3V7JwwtXRt4 How to secure characters on ink wheel for CE-3000-HVE	
	CE-3000-HVE Ink Print System https://www.youtube.com/watch?v=H2ArwGTH2So How to set up ink print system for CE-3000-HVE	
	CE-3000-HVE Vertical to Horizontal Configuration https://www.youtube.com/watch?v=ZpofPMhEjWE	
	CE-3000-HVE Printer Troubleshooting https://www.youtube.com/watch?v=dYgtlXZlZAs Troubleshooting when printer stops working	

	CE-3000-HVE Troubleshooting Wiring https://www.dropbox.com/s/vlww3dab79ozv05/3000%20possible%20wiring%20issue%20check.mp4?dl=0 Another troubleshooting video to check wiring if printer stops working.	
	CE-3000-HVE-Troubleshooting Print Whee https://www.youtube.com/watch?v=1p5nWeVfDHk Troubleshooting for your print wheel spinning.	
	CE-2500 HVE General Information General Information Video for CE-2500-HVE Band Sealer https://www.youtube.com/watch?v=g0vaNhNVZGs	
	CE-2500 HVE Belt Adjustment Belt adjustment video for CE-2500-HVE Band Sealer https://www.youtube.com/watch?v=B6z8y5BBE1w	
	CE-2500 HVE Embossing Wheel This is the video for how to setup the embossing wheel. https://www.youtube.com/watch?v=C6FGyFWcCqA	
	CE-2500 HVE Roller Adjustment How to Adjust the roller for the Teflon bands. https://www.youtube.com/watch?v=zzw6p1rnYvc	
	CE-2500 HVE Emergency Stop Switch Replacement How to change the Emergency Stop Switch https://www.youtube.com/watch?v=xgRYpKASfCc	
	CE 2500 CE 3000 Band Sealer Portable Stand Assembly Assembly Instructions for the CE2500/CE3000 Band Sealer Stand https://www.youtube.com/watch?v=LqBA3V2-GDk