

**CE IS2022**  
**Continuous Duty Air Cooled**  
**Induction Sealer**

Operation Manual



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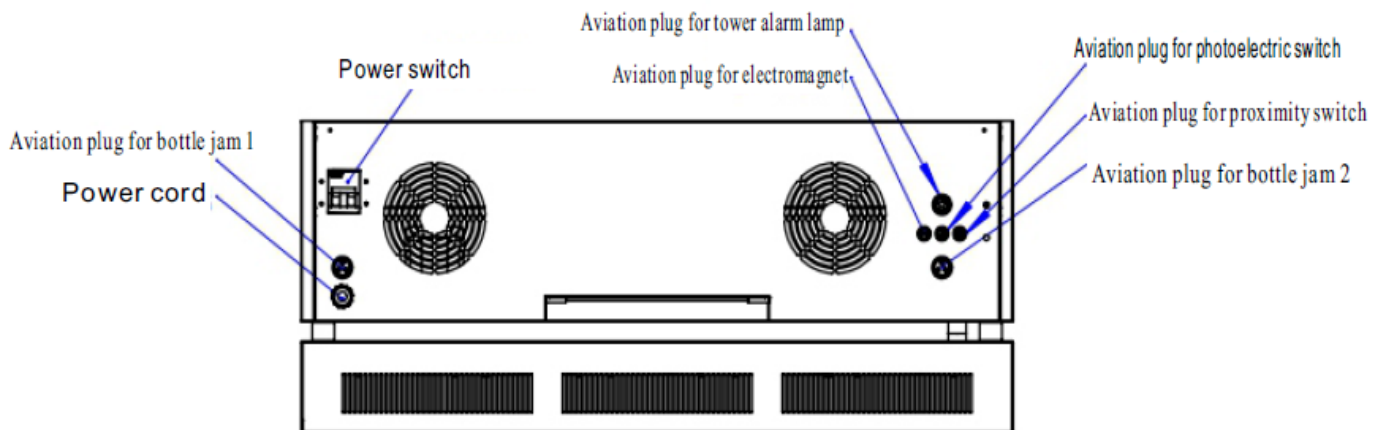
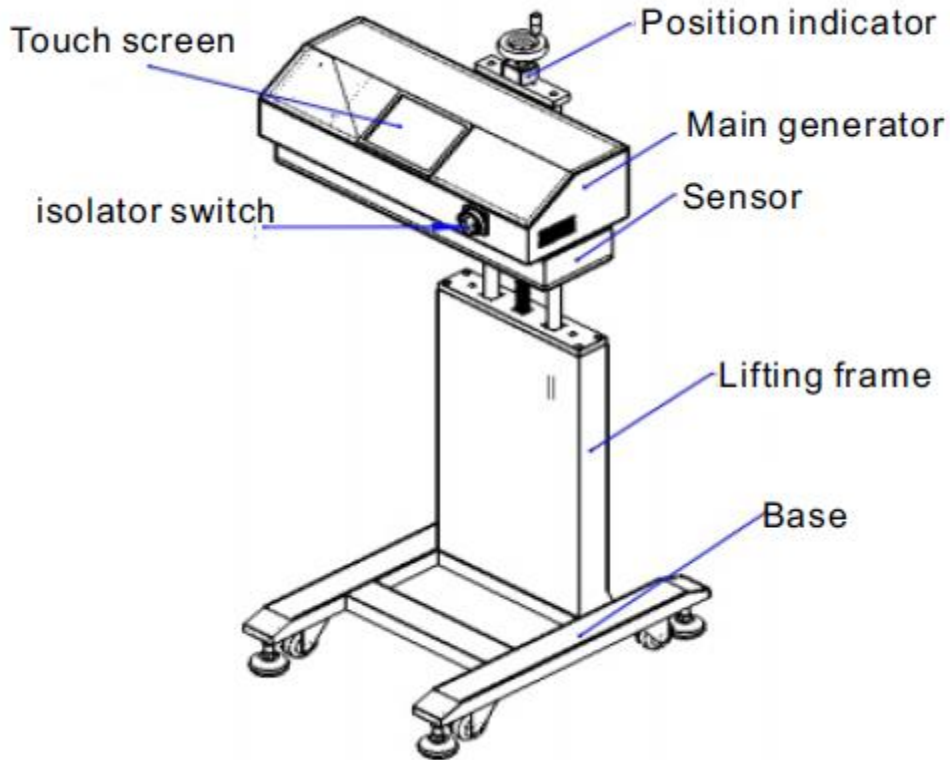


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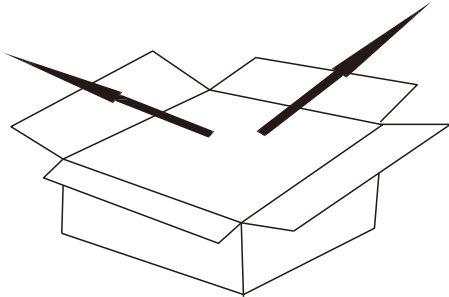
# 1. Names of components and external parts





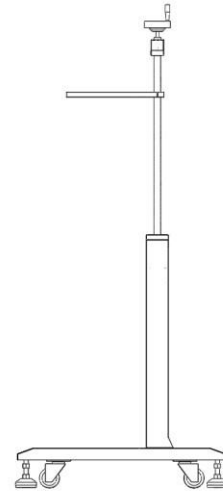
## 2 Installation instructions

1



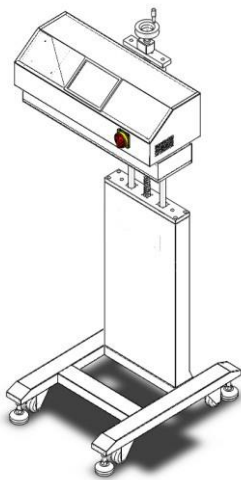
Unpack the packing box and check whether the machine and its accessories are in a good condition

2



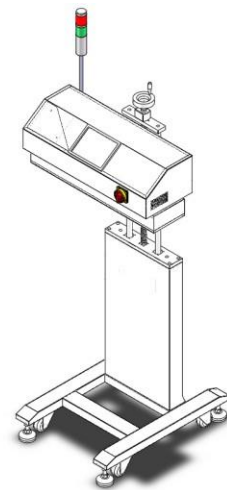
Inserting the Lifting frame into the stand base and tight it

3



Put the Main generator on Lifting fram, then screwing it tightly

4



Inserting the tower alarm lamp and connect it to main generator

**Attention: Power-on may cause the main generator to fail if not connected properly!!!**



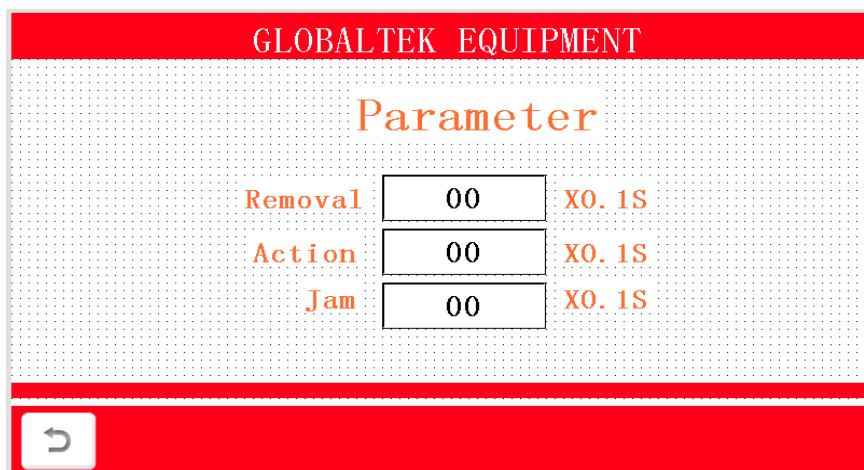
## 2.1 Interface specifications of touch screen



Press anywhere on screen with finger to enter operation interface.



Press "C" button to enter interface shown in pic.3



Removal parameter setting: this parameter is a signal time to rejector. If setting 10, it means 1 second, when the sensor detecting there is no aluminum foil liner and 1 second later, the electromagnet start to work and reject this error bottle. Generally, we suggest this parameter as "0".

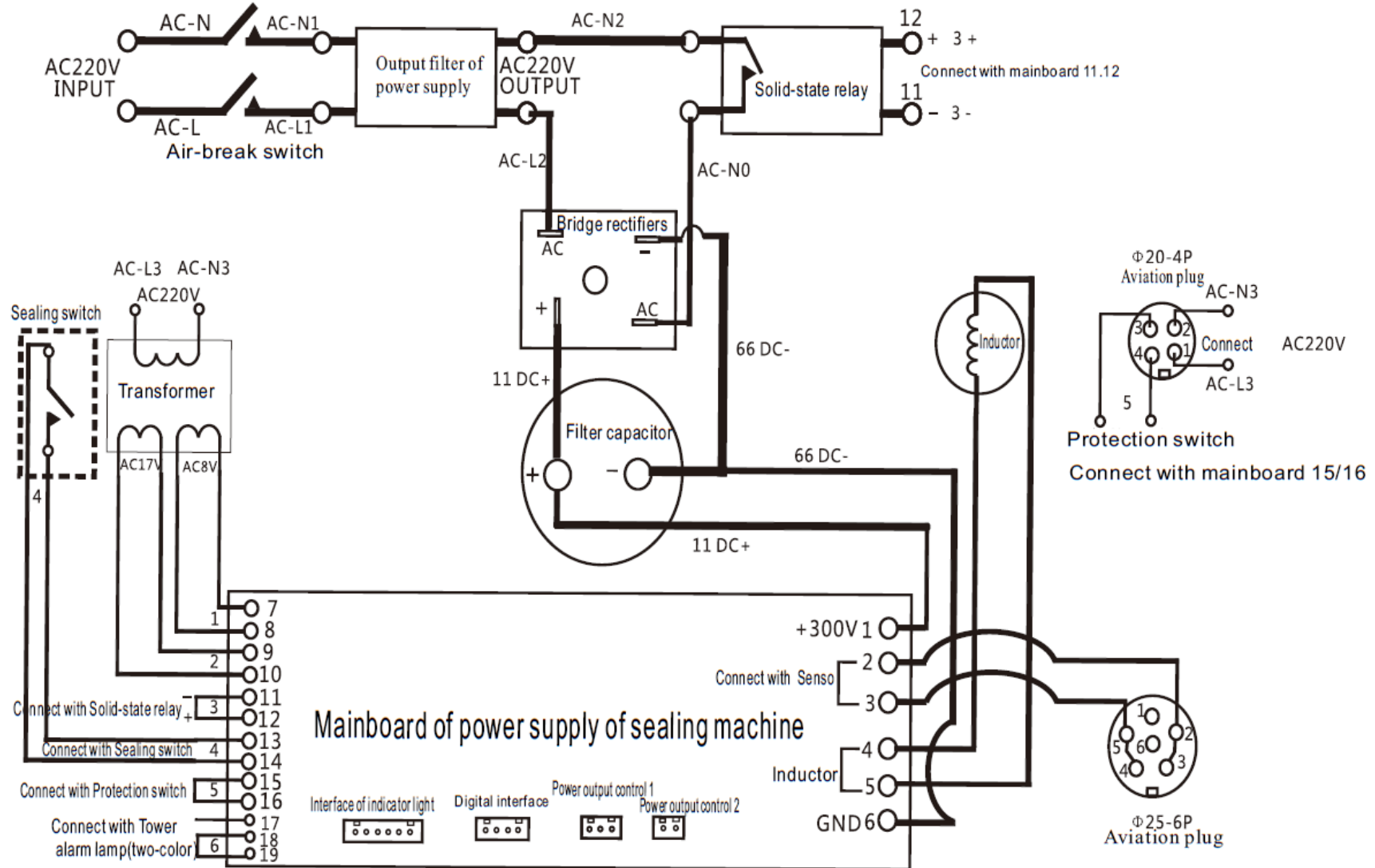
Action parameter setting: this parameter is the rejecting and keeping time of electromagnet. If setting number 5, it means electromagnet keep the rejecting action 0.5 second After 0.5 seconds, the electromagnet will come back automatically. For reject bigger bottle, we suggest it as 1 second, action parameter is 10 For reject small bottle, we suggest it as 0.5 second, action parameter is 05

Jam parameter setting: this parameter is a signal time for bottle jam If setting number 30, it means 3 seconds, when there is bottle stop under the sensor more than 3 seconds, the jamming light on screen will on. Machine sealing will stop automatic. After the bottle move on again, the sealing will come back automatic. We suggest this parameter as 30, means 3 seconds.



### 3. Wiring Diagram

#### ≡.Awiring diagram





## 4.Summary

Composite electromagnetic induction sealing technology is an internationally recognized advanced sealing and packaging method, which has been widely used in high-quality airtight sealing of medicines, foods, cosmetics, pesticides, chemical products and other bottled products.

Our sealing machine is the latest induction heating control technology and process at present. It adopts advanced high-power field effect transistor module, high-frequency switching power supply technology, PLL technology and digital technology, and has made significant improvements in miniaturization, high stability and high efficiency.

## 5.Operation principle

The working principle is that under the action of high-frequency electromagnetic field, the aluminum foil generates huge eddy current and rapidly heats up, melts the adhesive film on the lower layer of aluminum foil and bonds with the bottle mouth, so as to achieve the purpose of fast non-contact airtight sealing.

The main power components are installed on the large radiator, and forced air cooling is adopted, and the heating inductor is cooled by air fans.

## 6.Main parameter

Powersupply:  $\sim 220\text{ V} \pm 10\%$  , 50 / 60 Hz

Current supply: static state  $\leq 3.5\text{A}$ , dynamic state  $\leq 10\text{A}$

Output power : ( adjustable ) , 3 Kw max

Sealing speed: 120 - 200 bottle/min

( tested by a PE bottle, neck diameter  $\Phi 34\text{ mm}$ , bottom diameter  $\Phi 40\text{ mm}$  )

## 7.Parts list

- (1).Main generator and operation manual
- (2).One induction sensor
- (3).One set of lifting frame ( 2 connectors and 4 pcs M4\*12 Inner six screw)
- (4).One hand wheel
- (5).One supporting base of lifting frame (6).One LED tower alarm lamp
- (7).One set of tools



## 8 Operation and parameter adjustment

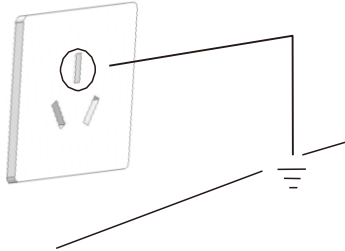
- (1) The size of power supply circuit and ground I wire for the machine should be no less than 25mm<sup>2</sup>. If the power supply voltage is not stable and affect the machine operation , it needs installing an AC voltage regulator.
- (2) Machine must be installed in a dry, clean, non-dust, non-corrosive gas and air-flowing environment. and machine should be away from all kinds of radiation and conduction heat source.
- (3) Adjust the height of the sensor according to the height of the bottle, and the center of the bottle cap should be aligned with the center of the sensor.
- (4) Specific steps:
  - A. Press the power switch and the screen with finger, then press the SEAL button, the “SEAL” on that is to say,the generator is working.
  - B. Adjust the Power output, then adjust the speed of conveyer(The speed of conveyer belt can be adjusted according to the actual situation.). Put the bottle which with aluminum foil liner on cap on conveyer center, and make sure the center of the bottle cap is aligned with the center of the sensor.
  - C. In order to achieve the best working condition, need do the sealing test to find out and record the best sealing parameter. After the machine adjusted, shall be prevented from changing the sealing parameter during normal production.
- (5) The generator and sensor will bring heat during their works. So, users needs to keep the generator fan inlet and outlet clean.
- (6) As the power output component of the machine, the sensor head has adjusted the internal circuit parameters to match those of the generator before leaving the factory, so the generator and sensor head should be used together according to the number! Don't be curious to disassemble the induction head, otherwise it may affect the output of effective power, and even burn down the components in the machine, causing the machine to fail to work.
- (7) During the machine working, the induction coil will produce a large current, so, do not separate the induction sensor and induction generator. otherwise, it will burn the components of induction generator and broken the machine.
- (8) Sealing bottles with flammable and explosive thing by our machine is forbidden!



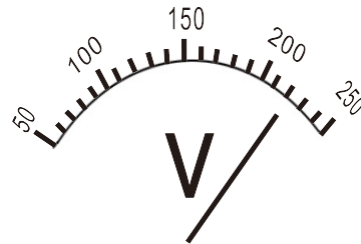
## 9. Operation noticed items

**1**

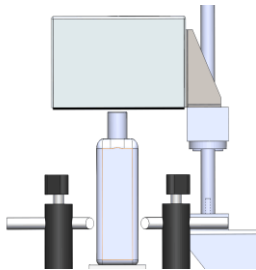
Please make sure that the power socket is in good contact and the ground wire is reliable grounding.

**2**

Please make sure that the voltage is 220V

**3**

Adjusting distance from the top of cap to the induction sensor, cap of small diameter cap keep the distance short distance, and large diameter should keep the distance long.

**4**

Bottle should be under the midpoint of induction sensor

**5**

It is forbidden to place the main generator in a humid environment, and it is forbidden to splash water or liquid into the main generator to avoid short circuit.

**6**

Non-professionals is NOT allowed to operate machine





## 10. Troubleshooting

Issues	Solution
turn on the isolator switch, there is no electricity	Check whether the internal over current protection short circuit device trips or not, and check whether there is a short circuit
Press START button, light of sealing is on and light of testing is flashing, but the machine doesn't heat up	Check whether the frequency of the motherboard and the frequency of the sensor head can be tracked, if not, one of them is damaged
Touch screen indication is abnormal or unreadable code, but the machine is heating up normally	Check whether the touch screen is normal and restart it after shutdown
the jam indicator (plugg bottle) light on	Check whether there is bottle stop under the sensor. If yes, pick up this bottle and make sure the bottles moving again

**Note:** When shutdown, please press the stop button first to make the cooling fan rotate, and then turn off the power switch after the induction sensor cools down, which can effectively prolong the service life of the machine