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# MERLIN

## “L” SEALER

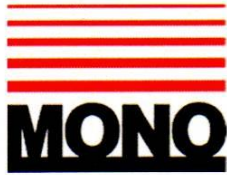
### IMPORTANT INFORMATION and INSTALLATION INSTRUCTIONS

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**COMPLETE OPERATION AND MAINTENANCE INSTRUCTIONS  
ARE AVAILABLE AT [www.monoequip.com](http://www.monoequip.com)**



## DECLARATION OF CONFORMITY

We hereby declare that this machine complies with the essential health and safety requirements of :-

- The Machinery Directive 2006 / 42 / EC
- The Low voltage Directive 2014 / 35/ EC
- The requirements of the Electromagnetic Compatibility Directive 2004 / 108EC, 91 / 263 / EEC, 92 / 31 / EEC  
Incorporating standards  
EN55014-1:2006+A1:2009+A2:2011  
EN55014-2:1997+A1:2001+A2:2008
- The General Safety of Machinery and food processing Standards applicable
- Materials and Articles intended to come into contact with food Regulation (EC) No. 1935 / 2004

<b>Signed</b>			
	G.A.Williams – Quality Manager		
<b>Date</b>			
<b>Machine FG Code.</b>		<b>Machine Serial No.</b>	

A technical construction file for this machine is retained at the following address:

**MONO EQUIPMENT**  
Queensway,  
Swansea West Industrial Park,  
Swansea  
SA5 4EB  
UK

**MONO EQUIPMENT** is a business name of **AFE GROUP Ltd**  
Registered in England No.3872673 VAT registration No.923428136

Registered office: Unit 9, Bryggen Road,  
North Lynn Industrial Estate,  
Kings Lynn,  
Norfolk,  
PE30 2HZ

## SAFETY SYMBOLS

The following safety symbols are used throughout this product documentation and manual (available at [www.monoequip.com](http://www.monoequip.com)).

Before using your new equipment, read the instruction manual carefully and pay special attention to information marked with the following symbols.



### **WARNING**

Indicates a hazardous situation which, if not avoided, will result in death or serious injury.



### **WARNING**

Indicates a hazardous situation which, if not avoided, will result in electric shock.



### **CAUTION**

Indicates a hazardous situation which, if not avoided, will result in minor or moderate injury.

## ELECTRICAL SAFETY AND ADVICE REGARDING SUPPLEMENTARY ELECTRICAL PROTECTION:

Commercial bakeries, kitchens and foodservice areas are environments where electrical appliances may be located close to liquids or operate in and around damp conditions or where restricted movement for installation and service is evident.

The installation and periodic inspection of the appliance should only be undertaken by a qualified, skilled and competent electrician, and connected to the correct supply suitable for the load as stipulated by the appliance data label.

The electrical installation and connections should meet the necessary requirements of the local electrical wiring regulations and any electrical safety guidelines.

### We Recommend:

- Supplementary electrical protection with the use of a residual current device (RCD)
- Fixed wiring appliances incorporate a locally situated switch disconnecter to connect to, which is easily accessible for switching off and safe isolation purposes. The switch disconnecter must meet the specification requirements of IEC 60947.



The supply to this machine must be protected by a **30mA RCD**

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This machine is designed for use with Polypropylene (Polyolefin) films and is **not suitable for use with PVC or Polythene.**

**Thank you for purchasing the MONO MERLIN “L” SEALER.  
A combination of clean industrial design and the latest technology.  
The following information should get your purchase running without any problems**

If you have a problem with your purchase please contact MONO EQUIPMENT at:

**MONO EQUIPMENT  
Queensway  
Swansea West Industrial Estate  
Swansea. SA5 4EB UK  
Tel. +44(0)1792 561234**

## **SAFETY**

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STATEMENT TO USERS OF  
MONO PACKAGING MACHINES PRODUCTS.  
(HEALTH & SAFETY AT WORK ACT 1974)



Under the terms of the above Act it is obligatory, rather than simply a matter of good business practice, to advise our customers on the safe use of our products.

There are no significant known hazards in the use of our products provided they are handled according to normal good safety practice and in accordance with the information in this instruction manual. We would nevertheless draw your attention to the following information which must be taken into account to ensure safe working.

### **MACHINES**

1. The sealing and cutting wire is heated by electrical impulse each time the machine is operated and therefore care should be taken to avoid touching any part of the wire when hot or within one minute of operation (due to residual heat).

Cleanliness in the vicinity of the seal wire and the use of minimum heat setting, sufficient only to seal and cut, is important to minimise any fuming that might occur.

2. Machine electrical compartments must not be opened, due to the danger of electrical shock, except by a competent person and only then after first being isolated from the mains electrical supply.

3. This machine is designed for use with Polypropylene (Polyolefin) films and is not suitable for use with PVC or Polythene.

### **MATERIALS**

#### **1. FLAMMABILITY**

Polyolefin films are combustible when exposed to ignition sources and should be stored in an area equipped with fire control safeguards. This is particularly important if large quantities of material are to be stored, in which case we recommend heat and smoke detection perhaps coupled with a water sprinkler system. In common with other combustible materials, polyolefin films burning freely in a fire will produce complex combustion products dependent upon factors such as temperature, the degree of ventilation and the fire dynamics of the situation. It is therefore not possible to specify the combustion products precisely, but typically they would include carbon monoxide, carbon dioxide, trace levels of organic compounds and water. For this reason it is recommended that all areas in the proximity of a fire should be immediately evacuated of all personnel and fire-fighters should be equipped with self-contained breathing apparatus

#### **2. HEAT SEALING & TRIMMING**

The heat sealing and cutting of plastic films inevitably gives rise to some fumes. Analysis of the fumes generated by this process and given off from Polyolefin/Polypropylene film indicates that under typical operation conditions no organic compounds are present in concentrations greater than 5% of the Occupational Exposure Limits determined by the Health & Safety Executive, with concentrations generally less than 1% of

OEL. However, even low concentrations of fumes can be irritating to sensitive persons and it is recommended that adequate ventilation should be provided to the working area to avoid a build up of fumes over a period of time. It is advisable to ensure that operatives and personnel in the working area do not have a history of respiratory or pulmonary illness and that the sealing equipment is maintained in good and clean condition. Attention to the cleanliness of the trimsealing heads is important as an accumulation of dirt or melted plastic can cause excessive fuming. Running the heat control at too high a setting can also contribute to excessive fuming and it is usually found in these circumstances that a reduction in the heat setting, combined with increased pressure on the sealing head, will give a better seal performance.

### 3. STATIC ELECTRICITY

Build up of static electricity in rolls of plastic film may cause problems when the charge earths by sparking. Where work involves potential fire or explosion hazards, steps should be taken to eliminate safely the static charge and to prevent subsequent recharging during further processing. Because of the possibility of generating and or discharging an electrostatic charge, protective wrappings should not be removed from film rolls in areas where the atmosphere conditions are such as to present a fire or explosion hazard.

### 4. SLIP

Most plastic films are high slip materials and if allowed to lie on the floor, can present a safety hazard to pedestrians. Care should therefore be exercised to ensure that scrap off-trims of film, are tidied away in appropriate disposal containers and not be allowed to litter the floor.

### 5. DISPOSAL

Disposal of scrap film should either be through the normal trade re-use outlets, burial or incineration. Incineration can be used for disposal where the incinerator is designed to cope with corrosive flue gasses.

## **NOTE!**

The Materials information set out above is based on information supplied by a manufacturer of Polyolefin Film and is correct to the best of our knowledge and belief. However, whatever film you decide to use, since the chemical composition may vary from manufacturer to manufacturer, you must satisfy yourself, by reference to the material supplier, that the material is safe to use on a heat seal and cut machine such as the MERLIN and that any fumes given off are not toxic or harmful.

Mono Equipment does not accept any liability whatsoever for any consequences arising from your choice of wrapping film.

# INSTALLATION

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- The sealer will be supplied completely assembled and ready for use, including a fitted power supply plug.
- The sealer's electrical supply must be 230/250V a.c., Single Phase, 50Hz, capable of carrying 13 amps.



The supply to this machine must be protected by a **30mA RCD**

- If a sensitive magnetic trip is used in the supply line, this must be rated at 20 amps. to allow for the peak impulse current.
- The sealer must be installed on a level floor.
- Check the sealing arm is level and adjust if necessary.



- Ventilation should be adequate to allow the small amount of fumes to be removed from the working area.



- The sealer should be installed away from areas where the atmospheric conditions are such as to present a fire or explosion hazard. (dust ,flour etc.)

# ISOLATION

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## 'ON/OFF' SWITCH / POWER NEON.

This switch provides power to the machine and incorporates a neon to indicate 'POWER ON'. Press to turn off.



## MAIN ISOLATOR

On the rear of the main body there is an isolator switch. This will turn off power to the sealer. This must be turned to "off" before the door can be opened to give access to the electrical parts.



ISOLATOR SWITCH

REAR VIEW OF SEALER



# BASIC OPERATION

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1. Place the desired type and size of centrefolded film on the film mandrel and locate and lock in position using the cones provided, the open side of the film should be towards the fixed cone.
2. Place the mandrel on the bearing carriers, with the open side of film towards the front, unreel film, passing the free end over the guide roller.  
Slide the whole film cradle backwards or forwards to the desired position (to suit the pack) and align the film fold line relative to the sealing pad.
3. Place the loading platform/film separator between the film layers pulling the free end of film under the seal arm. Ideally the platform should be positioned so that it's tip comes to within half the pack height of the film fold line. When correct, lock in position with the thumb screw to be found on the underside.
4. Switch power 'ON' and observe 'POWER ON' Neon is illuminated. (If not check that the power lead is plugged in).
5. Set 'WIRE TEMP.' to specified recommendation and with the film under the right- hand sealing arm, lower arm onto the film and hold down under moderate pressure. When the neon on the temperature controller goes out, release the arm and observe the welded film. *There should be a clean cut-off and weld with no gaps evident.*
6. Place product between the film layers, on the loading plate and move to the left and into the sealing area, having first set the seal platform to the required height.  
*The product and film should always be pulled into position rather than pushed to protect the leading seal.*
7. Close the seal arm and hold down firmly until the controller neon goes out at which point the arm can be released, as the film will have been welded and cut from the stock.



WASTE FILM IS GENERATED FROM THIS PROCESS AND, SINCE IT IS SLIPPERY AND COULD CAUSE AN ACCIDENT ,THIS SHOULD NOT BE LEFT TO PILE UP ON THE FLOOR.

## **Wire Temperature.**

Controlled as set out above. For all gauges and types of film it is recommended that a low setting is first tried, gradually increasing to find the lowest setting at which a satisfactory clean cut-off is achieved. The number (on the simulator) thus established should be noted for future reference in relation to the particular type and gauge of film in use. On no account should too high a setting be used as this will reduce the life of both sealing wire and sealing pads and might give rise to unpleasant fumes.

# CLEANING INSTRUCTIONS

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**ALL CLEANING AND MAINTENANCE OPERATIONS MUST BE MADE WITH THE MACHINE DISCONNECTED FROM THE POWER SUPPLY**



DO NOT ALLOW WATER TO ENTER THE CONTROL PANEL AREA.

DO NOT USE A SPIRIT OR SOLVENT TO CLEAN THE MACHINE.

## DAILY CLEANING

1. Brush crumbs etc off tables.
2. Wipe metalwork with a damp cloth and sanitising solution.

## WEEKLY CLEANING

1. Vacuum clean the machine.  
(Paying special attention to the underside of the sealing platform).
2. Wipe metalwork with a damp cloth and sanitising solution.
3. Check condition of sealing pads.  
(Replace if burn marks are excessive).
4. Check condition of sealing wires.  
(Clean off residual deposits with a stiff brush).