

# ES – 40

## Heat Seal Machine



Texas Automation Products, Inc.

300 Nichols Drive

Hutchins, TX 75141

## **About This Manual**

This manual contains information on how to install and operate the ES-40 pneumatic heat seal machine. It provides an overview of the machine, conversion charts to calculate the correct air pressure and electrical requirements, and step-by-step instructions to operate the ES-40.

## **Replacement Parts and Technical Assistance**

For replacement parts or technical assistance, please contact:

**Texas Automation Products, Inc.**  
**300 Nichols Drive**  
**Hutchins, TX 75141**  
**972-288-5000**  
**800-872-1960**  
**Fax 972-288-6022**  
**[info@texasautomationproducts.com](mailto:info@texasautomationproducts.com)**

Please have your model and serial number when calling for service.

## **Warranty**

This machine is fully warranted against defects in workmanship and material for 1 year from the date of purchase. Platen covers are excluded from warranty.

## Requirements

1. Air – 25 PSI minimum / 120 PSI maximum
2. Electrical Requirements – 240v A.C. / 60 Cycle

POWER CONSUMPTION		
PLATEN SIZE	WATTS	AMPS
2" x 4"	900	4
3" x 5"	1200	5
4" x 6"	1320	5.5
5" x 6"	1800	7.5
3 ¼" x 5" Extended Anvil	660	3

## Installation

1. Bolt base of machine securely in desired place and position.
2. Connect air supply to 1/8" Female NPT fitting located in the back at the base of the machine.
3. Plug in electrical cord to properly fused and grounded receptacle.

## Operation

1. Set the Air Regulator located on the right side of the swivel head at the required gauge pressure: 25 PSI minimum / 120 PSI maximum. To adjust regulator, pull up and turn black knob. Clockwise increases pressure, counter-clockwise decreases pressure. When pressure is set, push down black knob to lock. See *table A-1* to convert gauge pressure to total interplaten pressure and pounds of pressure per square inch on platen surface.
2. Check Air Filter Bowl located beneath Air Regulator and Gauge. If water is visible in bowl, drain moisture by turning shaft, located on the bottom of the bowl, counter-clockwise.
3. Flip power switch located on the lower left side of the swivel head to "ON". Green light on control panel indicates the power is "ON".
4. Set individual platen temperature with the corresponding control knobs located on the control panel to desired temperature setting. Allow 10 minutes for platens to heat up. While platens are heating their corresponding red light on the control panel will remain on. When platens reach desired temperature the red light will turn off momentarily. As the temperature controllers phase on and off to maintain desired platen temperature, the red lights will phase on and off also. Platen heat can be turned off individually by turning knob counter-clockwise until it clicks.
5. Set Timer Control located on upper left of control panel to desired cycle dwell time. This time setting will repeat each press cycle until changed.

6. To actuate press, position top platen over one of the bottom platens and depress the black pushbutton labeled “Start Cycle” located on the handle simultaneously with one of the black pushbuttons labeled “Start Cycle” located on either side of the swivel head. Machine will cycle ONLY when the top platen is in position directly over a bottom platen. When press cycle is in progress, the amber light on the control panel will turn on and remain on for all but the last two seconds of the timing cycle. At that time, the amber light will go into a blinking mode to alert the operator that the press cycle is nearly complete.
7. To immediately open the press, push one of the red “Emergency Release” pushbuttons located on either side of the swivel head. This safety feature bypasses the timer and immediately opens the press in case of an emergency. Only one red pushbutton need be depressed to interrupt cycle. Also, the press should open immediately if the power switch is turned “OFF” or if the machine power cord is unplugged.

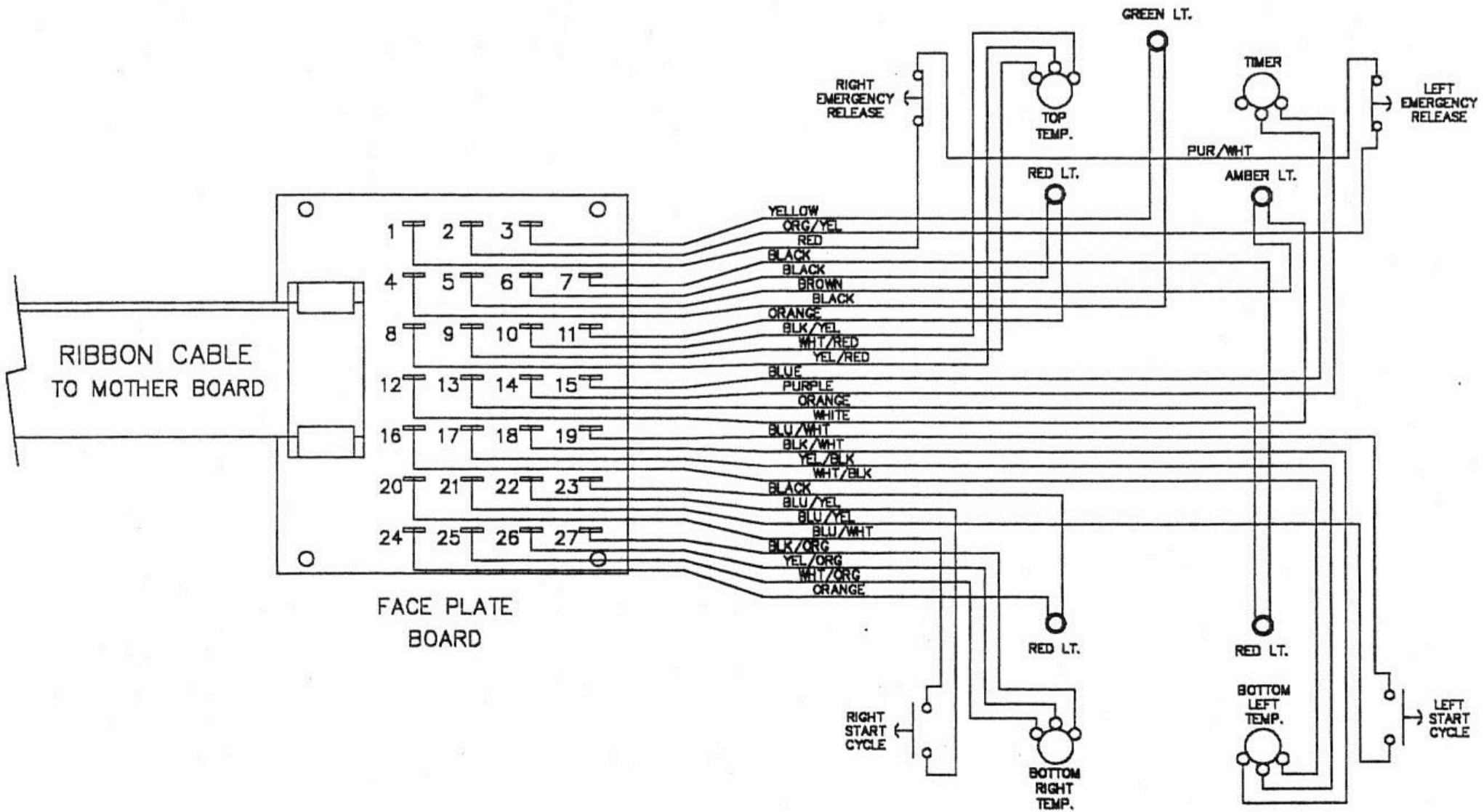
CONVERSION TABLE						
GAUGE PRESSURE	TOTAL INTER-PLATEN PRESSURE	LBS. PSI 2" x 4" PLATEN	LBS. PSI 3" x 5" PLATEN	LBS. PSI 4" x 6" PLATEN	LBS. PSI 5" x 6" PLATEN	LBS. PSI 3 ¼" x 5" EXTENDED ANVIL PLATEN
25	177	22.1	11.8	7.4	5.9	10.9
30	212	26.5	14.1	8.8	7.1	13.0
35	247	30.9	16.5	10.3	8.2	15.2
40	283	35.4	18.9	11.8	9.4	17.4
45	318	39.8	21.2	13.2	10.6	19.6
50	353	44.1	23.5	14.7	11.8	21.7
55	389	48.6	25.9	16.2	13.0	23.9
60	424	53.0	28.3	17.7	14.1	26.1
65	459	57.4	30.6	19.1	15.3	28.2
70	495	61.9	33.0	20.6	16.5	30.5
75	530	66.2	35.3	22.1	17.7	32.6
80	565	70.6	37.7	23.5	18.8	34.8
85	601	75.1	40.1	25.0	20.0	37.0
90	636	79.5	42.4	26.5	21.2	39.1
95	672	84.0	44.8	28.0	22.4	41.4
100	707	88.4	47.1	29.5	23.6	43.5
105	742	92.7	49.5	30.9	24.7	45.7
110	778	97.2	51.9	32.4	25.9	47.9
115	813	101.6	54.2	33.9	27.1	50.0
120	848	106.0	56.5	35.3	28.3	52.2

Table A-1

## Maintenance

- Drain moisture trap on Air Filter / Regulator as often as necessary.
- Check sponge and teflon. Replace if needed.

# MODEL ES-40 and MODEL ES-42 FACEPLATE SCHEMATIC



# MODEL ES-40 and MODEL ES-42 (with 2"x4" PLATENS) MACHINE BASE SCHEMATIC

