

STARVIEW PACKAGING MACHINERY INC.

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ASP Series
With Impulse Heater
OPERATOR MANUAL

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SAFETY INSTRUCTIONS

WARNING

- * **Use emergency stop only for emergencies**
 - ** **Do not tamper with switches and other safety features**
 - *** **Pressing the emergency stop button does not cut electrical power source to the machine**
-
- **Prior to use of machine, operator should thoroughly read this manual**
 - All electrical connections should be performed by a qualified technician
 - Connect power supply using case grounded services only
 - Provide access to all controls on panel for operator maneuvering
 - Before attempting any maintenance on machine:
 - Turn main power to the OFF position
 - Disconnect power from power source
 - Disconnect air supply
 - Allow machine sufficient time to cool down
 - Always turn main power to the OFF position when machine is not in use
 - Keep hands away from all moving parts
 - Keep away from heater and hotwire at all times

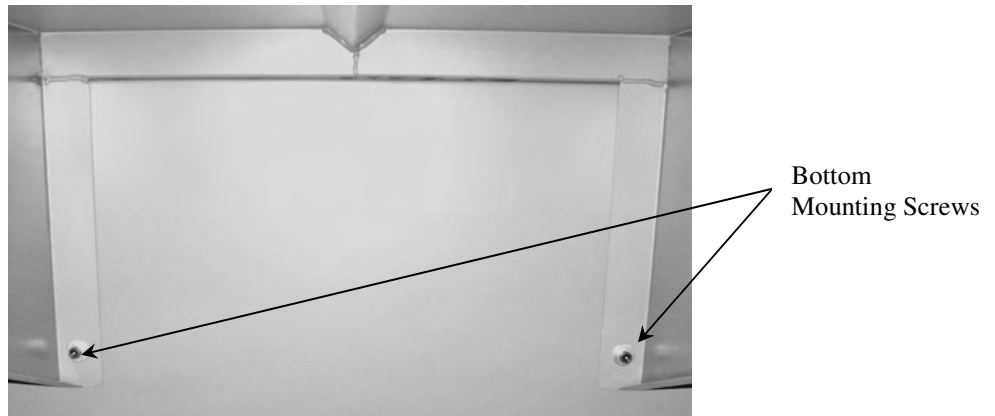
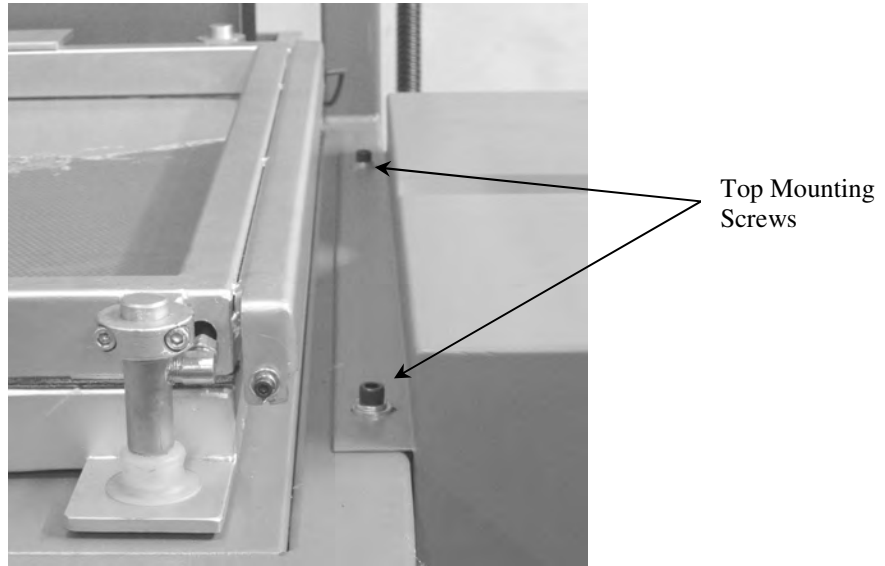
INSTALLATION INSTRUCTIONS

WARNING

- * All electrical works should be performed by a qualified electrician**
 - ** Prior to connecting main power supply to the machine, verify voltage and amperage requirements on the serial number plate**
 - *** Keep hands away from machine when air supply is being connected**
-
- Unpack machine. Carefully remove straps and attachments
 - Place the machine in its proper location. Verify that the machine is level
 - Remove conveyor table from the sealing area
 - Install conveyor table (see instructions on page 2_A)
 - Connect main power supply to the machine
 - Connect air supply to the air filter regulator
 - Required minimal pressure is 80 PSI

- Install conveyor table as shown below:

Top View



Bottom View

OPERATOR INTERFACE SETTINGS

WARNING

- * **Do not use any objects on Operator Interface as it may cause damage to the display screen**
- ** **Always use clean hands when operating the display screen**

- Switch main power to the ON position
- **STARVIEW** will appear on the screen
- Touch anywhere on screen to activate main menu

- Main Menu will display the following options:
 - **Manual Mode**
 - **Run/Stop**
 - **Timers**
 - **Counter**
 - **Diagnostic**
 - **Parts List**

- Select any of these options to proceed

Timers

- **Hotwire**
 - Time required to cut the excess plastic
- **Frame Up Delay**
 - Delay before the clamping frame returns up towards the heater
 - This delay will begin after the hotwire has ended its cycle
- **Heater Override**
 - Press this **Reset** button to stop heater and begin vacuum cycle
 - This feature is useful when too much heat is being applied to the plastic
- **Heater**
 - Time required to heat plastic
- **Heater Hold**
 - Heater will remain on while frame is descending
 - This feature will ensure that film remains warm while frame descends
- **Heater Delay**
 - Delay before heater begins. Once Template begins moving this delay will commence
 - This feature allows added time for the template to feed if necessary
- **Template Up Delay**
 - Delay before the template moves up, after sliding the skin board onto sealing area
 - This feature will ensure that skin board and products are properly placed onto the sealing area
- **Template Return Delay**
 - Delay before template moves back onto the loading area
 - This feature will ensure that template will not obstruct the products when returning to loading area
- **Vacuum**
 - Vacuum will remain on for the preset time to seal the plastic to the skin board
- **Impulse Heater**
 - Heater will turn On/Off according to the preset times. This will keep the heater warm and reduce heating time
 - Suggested setting: Heater On for 1-2 seconds, and Off for 20-seconds
- **Auto Cycle Delay**
 - Cycle will begin automatically as per set time

Counter

- **Pre-Set Production Counter**
 - Enter desired value using the thumbwheel
 - Use the “ + ” or “ - ” to increase or decrease production counter
 - Once desired value has been entered press reset to activate new count

- **Batch Counter**
 - Once pre-set cycles have been attained, machine will no longer cycle until the counter is either reset or turned off in the Run/Stop menu

- **Total Counter**
 - Will accumulate all machine cycles progressively throughout the life of the machine
 - Modification is not possible

- **Reset Counter**
 - Pressing the reset button will clear and reset the **Batch Counter**

Manual Mode

- Press the **Manual** button to activate the Manual Mode features

- Once in Manual Mode, activate features individually

- To terminate Manual Mode Press the **Auto** button

WARNING

- * **If Emergency Stop is activated, machine will automatically return to Auto mode. Remove Emergency Stop and press the Manual button to return into Manual Mode**

Diagnostic

- Diagnostic page will display status of all features
- Highlighted features are activated/detected
- Non-highlighted features are not activated/detected

Run/Stop

- Features can be individually activated/deactivated by selecting Run/Stop

Parts List

- A list of all components
(see pages 7 through 7_B)

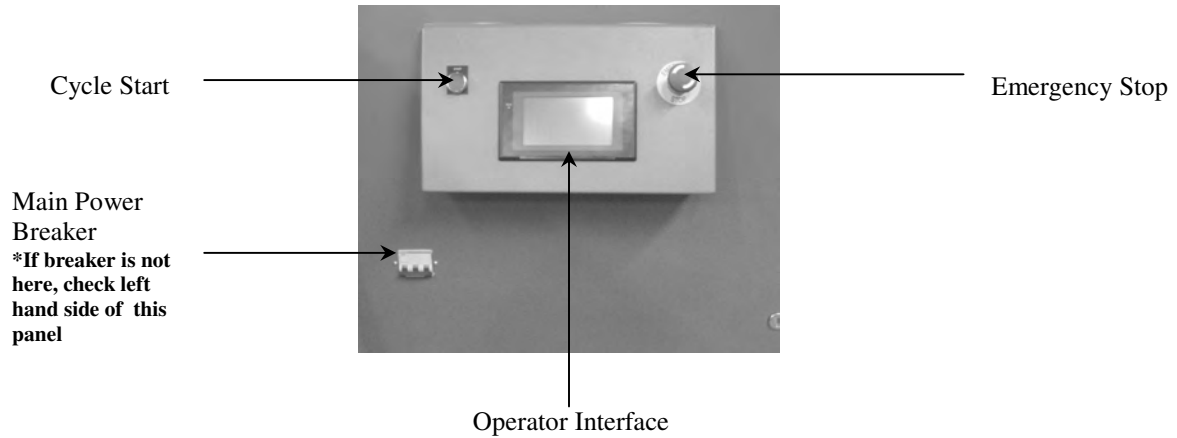
START - UP

WARNING

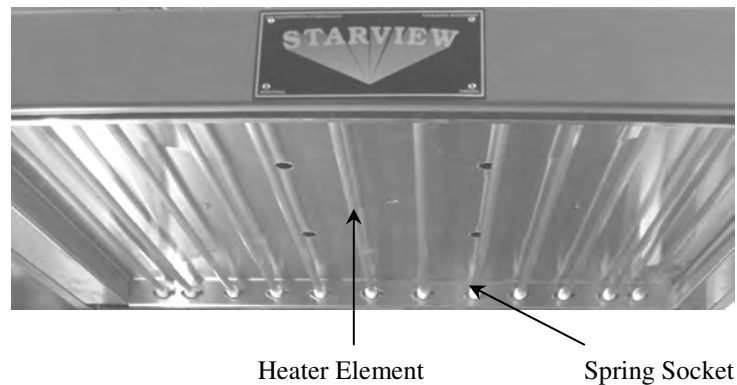
- * **Press the Emergency Stop button only for emergencies**
- ** **Keep hands and any loose clothing away from all moving parts**

- Turn ON the main power breaker
- Connect air to the filter regulator
 - Air filter regulator should be set to 80 PSI
- Set up the Timers
- Set up features in the Run/Stop menu
- Set up the Counter
- Thread the film (see instructions page 4_C)
- Press the **Cycle Start** button to start the machine
 - Clamping frame will close, hotwire will be activated and then the frame will move up towards the heater
 - Once products have been loaded onto the skin board, press the start button to activate the template and heater
 - Once the first cycle is finished, the clamping frame will automatically open
 - Slide the sealed skin board out onto the conveyor table
 - Repeat above steps to start next cycle

Control Panel



Heater



- **To Remove Heater Elements:**
 - Turn power off and allow machine to cool
 - Push and hold the spring socket at either end
 - Pull element downward and out

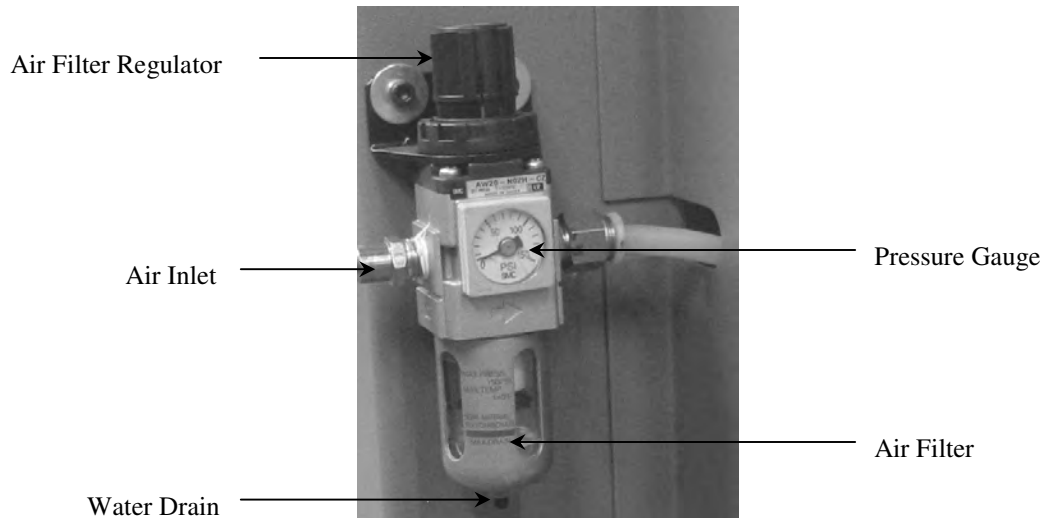
- **To Insert Heater Elements:**
 - Insert heater element into spring socket at either end
 - Push and hold the spring socket to insert the second end
 - Slide element into the spring socket and release

WARNING

- * **Keep away from heater at all times**

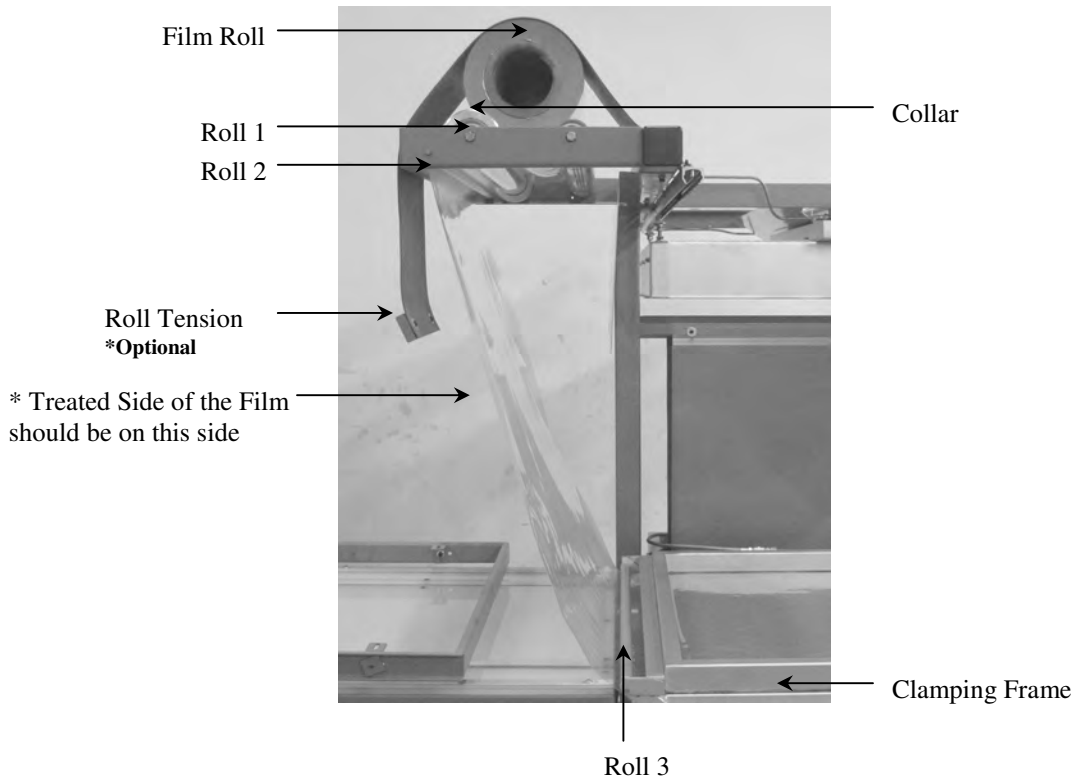
- ** **Allow heater to cool before attempting any maintenance**

Air Filter Regulator



- Connect Air supply to **Air Inlet**
- Air flow to the machine can be controlled through the **Air Filter Regulator**
 - **Air Filter Regulator** should be set to **80 PSI**
 - Turn clockwise to increase air flow
 - Turn counter clockwise to decrease air flow
- Drain the **Air Filter** daily or as needed
 - Loosen the **Water Drain** to clean out filter
 - Tighten Water Drain once water has been drained

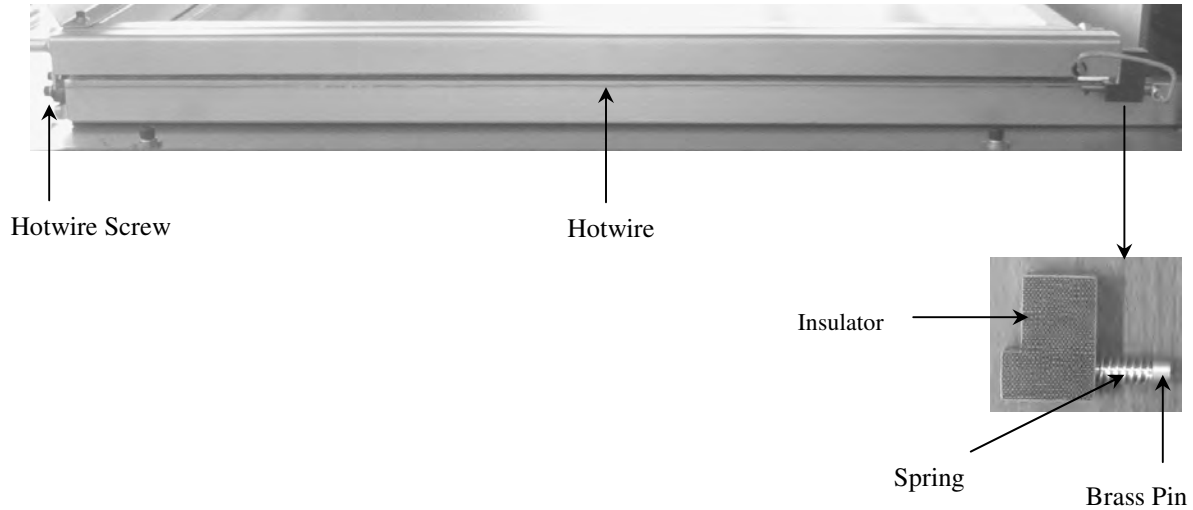
Threading The Film



- **Threading the Film**
 - Load **Film** onto the top rolls (as seen above)
 - Pull **Film** over, and then under **Roll 1** (right side of Roll 1)
 - Pull **Film** to the outside of **Roll 2** (left side of Roll 2)
 - Pull **Film** under **Roll 3**
 - Pull **Film** between **Clamping Frame** opening, and into the **Clamping Frame**

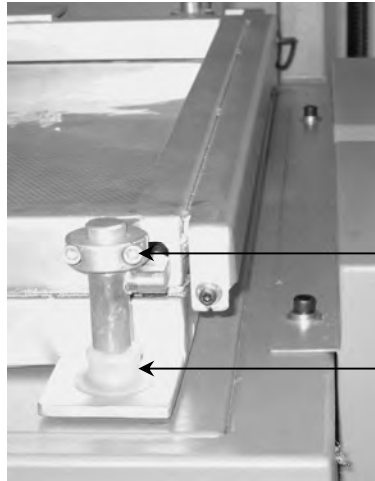
- **Centering the Film**
 - Loosen the **Collars** located on **Roll 1**
 - Center the **Film** according to the **Clamping Frame**
 - Once Film has been centered, tighten the **Collars** to secure position

Clamping Frame Adjustments



- **To Tighten Hotwire:**
 - Push the **Brass Pin** in and hold
 - Loosen the **Hotwire Screw**
 - Pull the **Hotwire** and tighten the **Hotwire Screw**
 - Release the **Brass Pin**

- **To Replace Hotwire:**
 - Loosen **Hotwire Screw** and remove **Hotwire**
 - Push and hold the **Brass Pin**
 - Loosen the set screw located on the **Brass Pin** and remove **Hotwire**
 - Insert new **Hotwire** into the **Brass Pin** and tighten the set screw
 - Pull **Hotwire** towards the **Hotwire Screw**
 - Wrap **Hotwire** around the **Hotwire Screw** and tighten



Collar

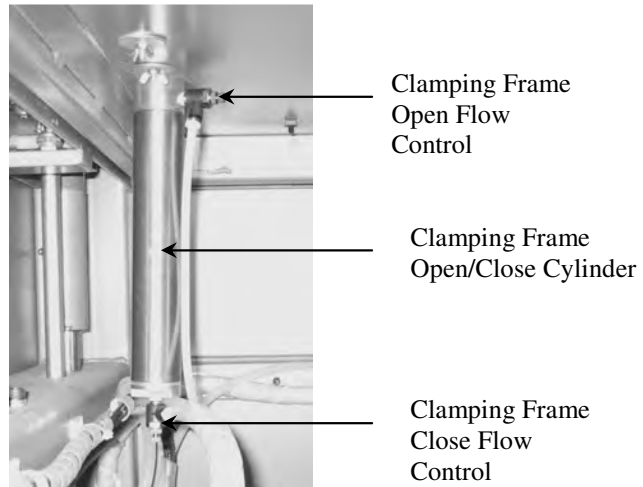
Vacuum Cup

*Vacuum Cups are located on both sides of the Clamping Frame

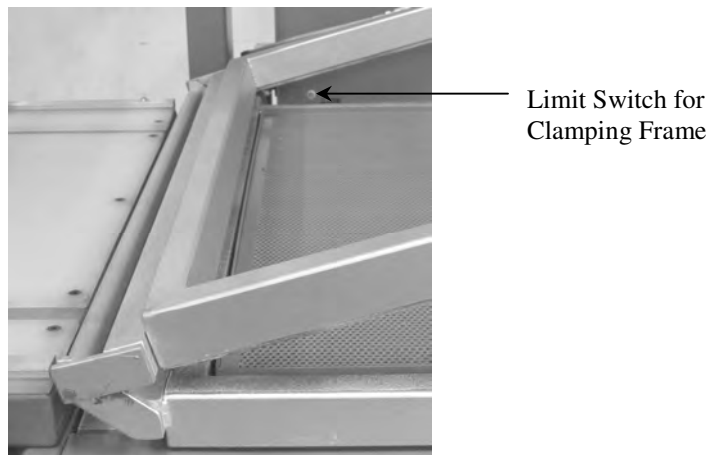


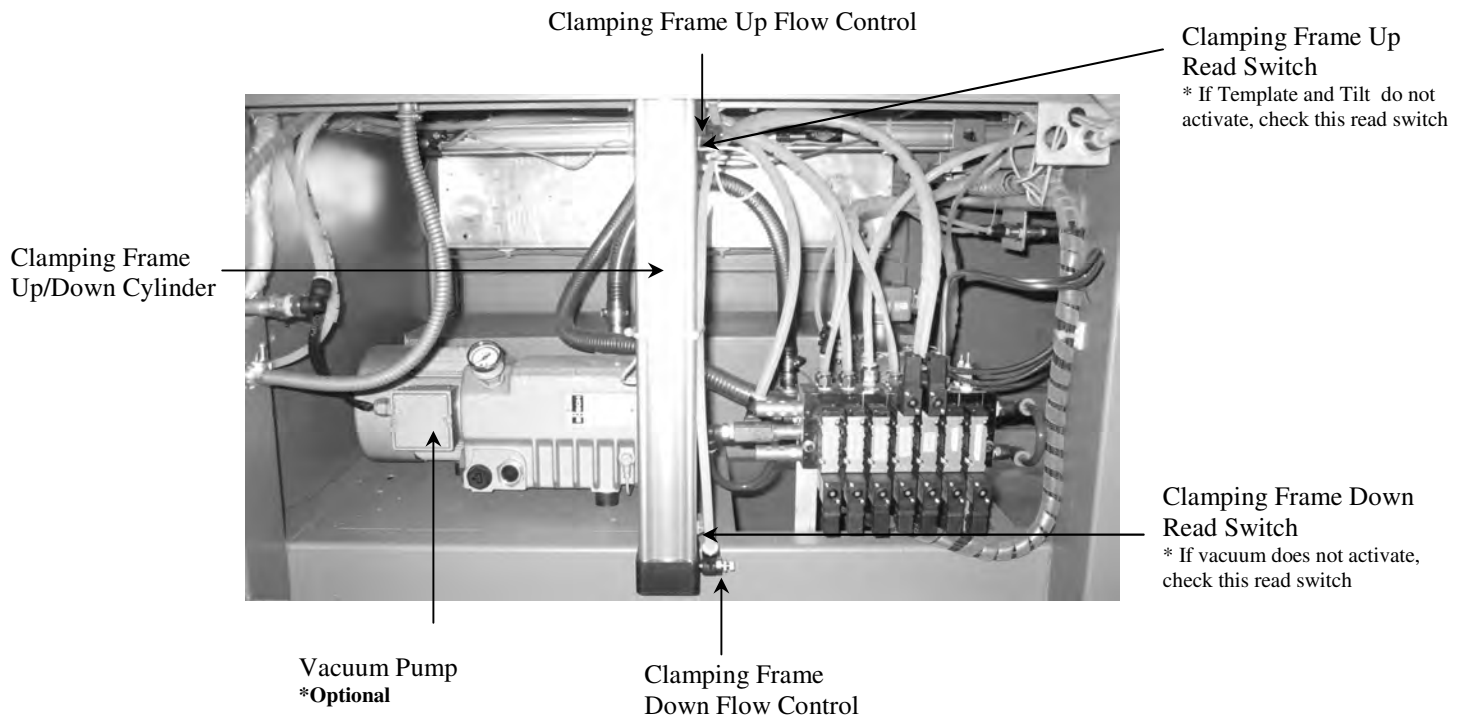
Screws

- **To Adjust The Clamping Frame Tension:**
 - Loosen the **Collars** on both sides of the **Clamping Frame**
 - Slide **Vacuum Cups** upwards and tighten for more tension
 - Slide **Vacuum Cups** downwards and tighten for less tension
 - Loosen **Screws** located where the **Film** is inserted
 - Slide the **Clamping Frame** upwards and tighten for less tension
 - Slide the **Clamping Frame** downwards and tighten for more tension



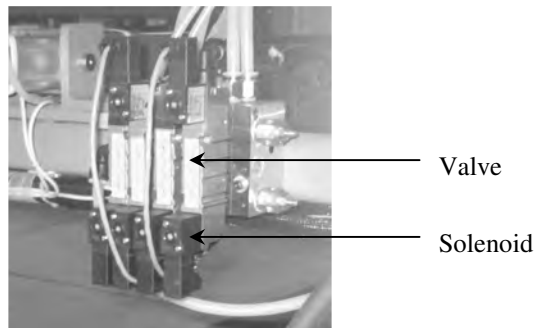
- **To Adjust The Clamping Frame Open/Close Speed:**
 - Adjust the **Clamping Frame Open** and **Clamping Frame Close Flow Controls**





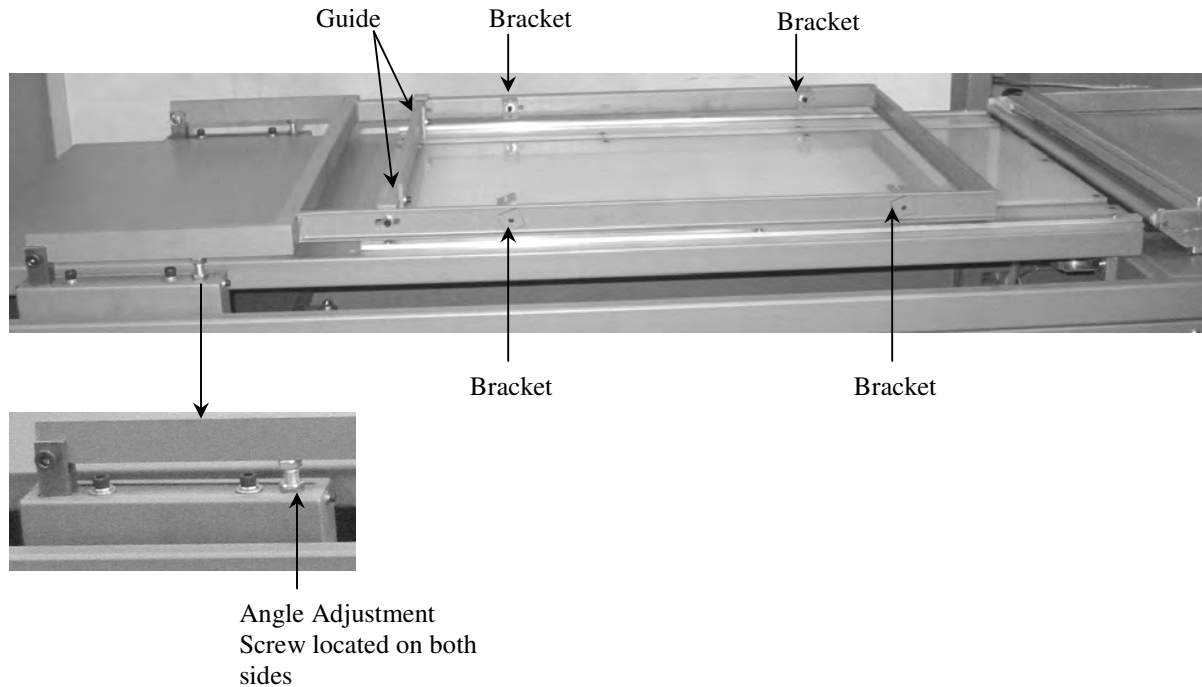
- **To Adjust The Clamping Frame Up/Down Speed:**
 - Adjust the **Clamping Frame Up/Down Flow Controls** located on the cylinder

Valves



- Valves can be activated manually using the **Solenoid**. Push in and hold the solenoid button to activate the desired function

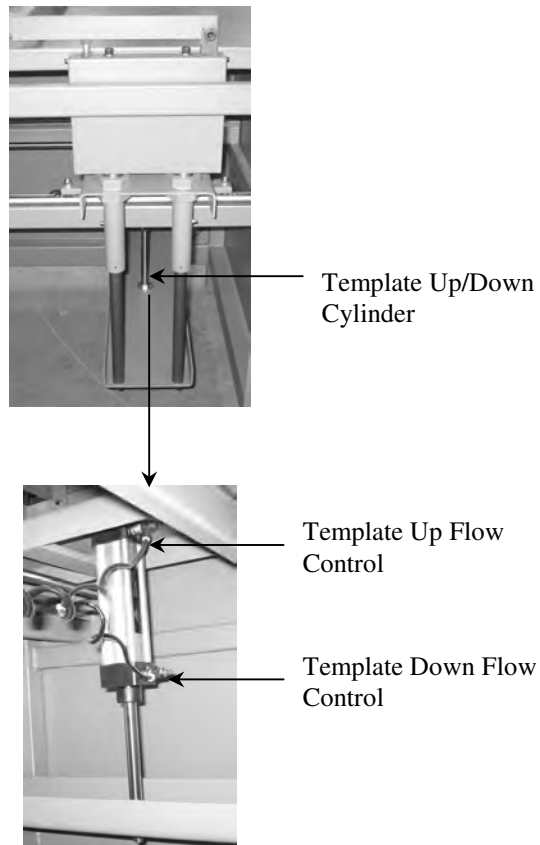
Template



- **To Mount Product Template Onto Machine:**
 - Mount the product template using the 4 **Brackets**
- **To Adjust the Template Height:**
 - Loosen the screws located on the **Brackets**
 - Move template up or down as required
 - Once position has been set tighten all screws
- **To Adjust The Skin Board Feeder:**
 - The **Guides** will push and feed the skin board onto the sealing area
 - Loosen the screws located on the **Guide** and adjust height as required
 - Once position has been set tighten all screws
 - Verify that the **Guides** height is sufficient to move freely
- **To Adjust The Template Angle:**
 - Turn the **Angle Adjustment Screw** clockwise to decrease the template angle
 - Turn the **Angle Adjustment Screw** counter clockwise to increase the template angle



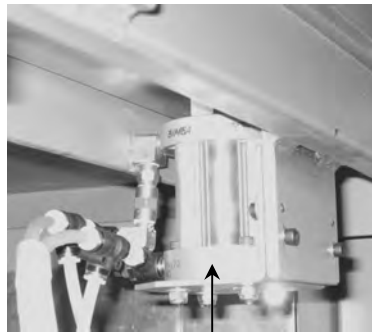
- **To Adjust The Template In/Out Speed:**
 - Adjust the **Template In/Out Flow Controls**



- **To Adjust The Template Up/Down Speed:**
 - Adjust the **Template Up/Down Flow Controls**



Template Support



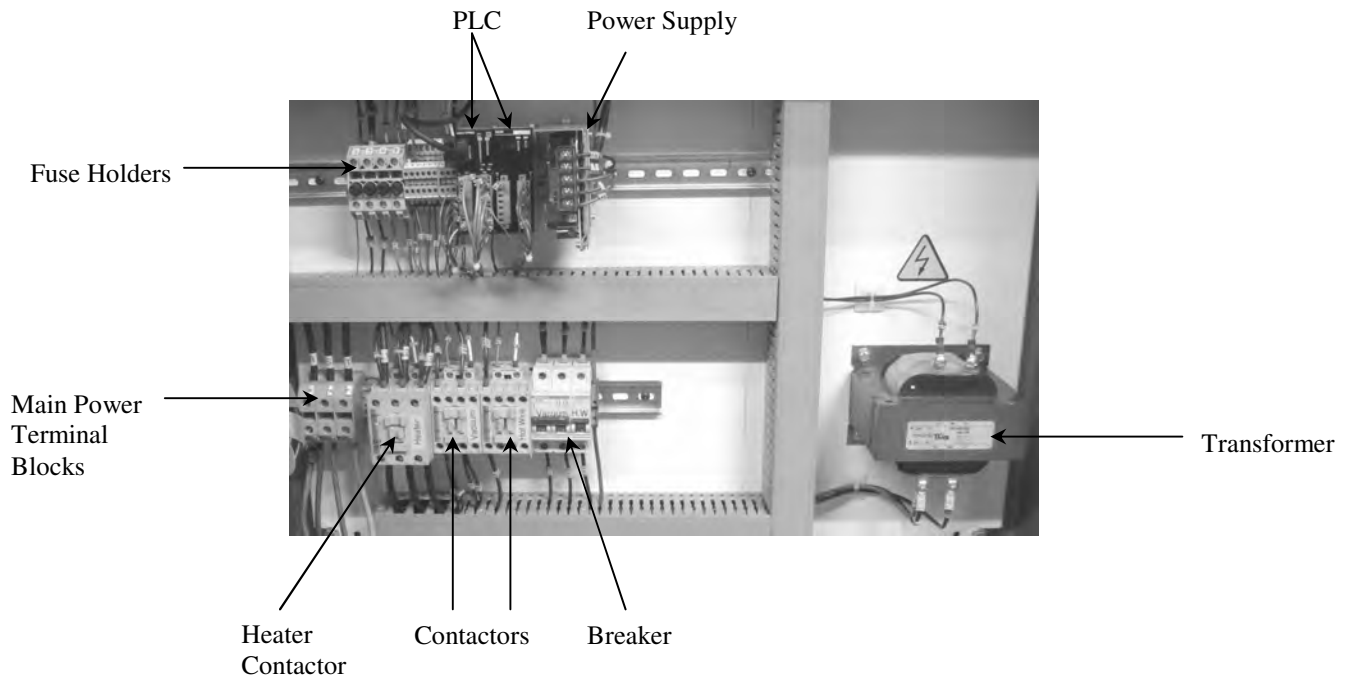
Template Support
Cylinder

MAINTENANCE

WARNING

- * Pressing the emergency stop button does not cut power source to the machine**
 - ** If machine has been operating, allow unit to cool before attempting any maintenance**
 - *** Disconnect air supply to machine before attempting any maintenance**
 - **** Do not touch or get any grease on any electrical components or connections**
-
- Drain water from the **Air Filter Regulator** Daily or as needed
 - Clean **Filter** bowl as necessary
 - Wash bowl using warm water with mild soap
 - Do not cleans bowl using solvents as they may weaken the bowls material and cause the bowls to fail when pressurized
 - Clean and Grease all sliding and rotating parts every 2 months or 500,000 cycles

ELECTRICAL



WARNING

- * All electrical works should be performed by a qualified electrician
- ** Prior to connecting main power supply to the machine, verify voltage and amperage requirements on the serial number plate

SPARE PARTS

ASP-2430

Pneumatic

Product Name	Description	Serial Number
Template Up/Down Cylinder		Code #148
Clamp Frame Cylinder		Code #149
Template In/Out Cylinder		Code #150
Bimba Cylinder		FT-172.000
Bimba Cylinder		177.50-DB
Valve		400-SERIES-SKIN4-STNS
Air Filter Regulator		AW2001-N02P-N
Flow Control		JSC1/4-N1AHU
Vacuum Cup		VP40AS
Vacuum generator		VHH15-3/8N2U

Mechanical

Product Name	Description	Serial Number
Vacuum Turbine	220v	MKM3401-6
Neoprene Strips		R#200.1/8
Bearing	Ball bearing w/thread	5C14
Roll		2" x 27-3/8"
Roll		27-3/8" x 3/4"
Roll		20-5/8" x 3/4"
Lock		B5803-KZ-14
Hot wire Kit	Insulator/Pin/Wire/Spring	SP-Hot Wire Kit

Electrical

Product Name	Description	Serial Number
Screen	Omron touch screen	NT21-ST121B-E
PLC		CPM2C-20CDR-D
PLC Expansion Unit		CPM2C-10EDR
Power Supply		S82J-02524AD
Cable	for NT21 and CPM2C	CPM2C-NT-CN224-6-R
Contactora		CA7-43-10-24v
Contactora		CA7-12-10-24v
Transformer		DO8810SB
Breaker	Bracket	MG26985
Breaker	32amp-3pole	MG24474
Breaker	25amp-1 pole	MG24436
Fuse	5a-250v	GDL5
Fuse	3a-250v	GDL3
Fuse	10a-250v	GDL10
Fuse Holder		AB1FU10435U
Heater Element	27-7/16"-1550w-200v	ASB22024
Heater Spring Socket		Spring Socket
Button	E.Stop-lock type	D5M-MT4
Button	Green button	D5M-F3
Button	Mounting Latch	D5-A3L-SP
Button	N.O. contact	D5-3X10
Button	N.C. contact	D5-3X01

LIMITED WARRANTY

STARVIEW provides a Ninety (90) Days warranty on its equipment (without limitations as to number of cycles), if properly installed and used in accordance with instructions. Warranty for components are divided into two categories, as follows;

Components

Components are warranted to be free from defects in materials and workmanship for a period of 1 year from the date of delivery of machine. During this 1 year period, **STARVIEW** will (at its' option) either repair or replace any failed component of its' equipment.

Wear Parts

Parts designed to wear in normal operation and be replaced periodically are warranted to be free from defects for a period of ninety (90) days from date of delivery of machine. Warranty does not extend to parts where damage was caused by normal wear, negligence, accident, abuse, or improper installation or operation.

**** Except as stated herein, STARVIEW makes no other warranty, expressed or implied. This warranty does not apply to equipment which has been, in the judgment of STARVIEW, subjected to misuse, neglect, abuse, and/or repaired or altered by unauthorized personnel. Defective parts must be returned to STARVIEW, freight prepaid, within 14 days of shipment of the replacement part. Defective parts must be returned in their original state. Defective parts that have been disassembled, damaged during removal, or otherwise tampered with, will not be covered under warranty. Unless otherwise stated in writing, STARVIEW makes no other warranty as to suitability of equipment for particular purposes. STARVIEW's sole obligation under this warranty will be to provide repairs, or replacement parts, F.O.B. STARVIEW's point of shipment. ****

**** STARVIEW assumes no responsibility for the quality and performance of films, boards, or any other materials used with its equipment. ****