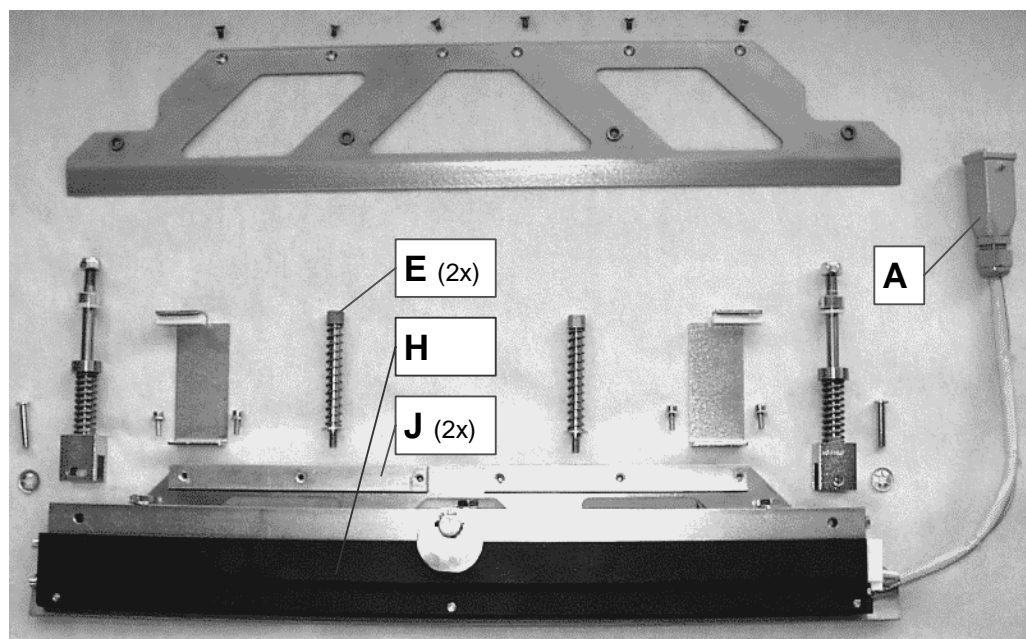
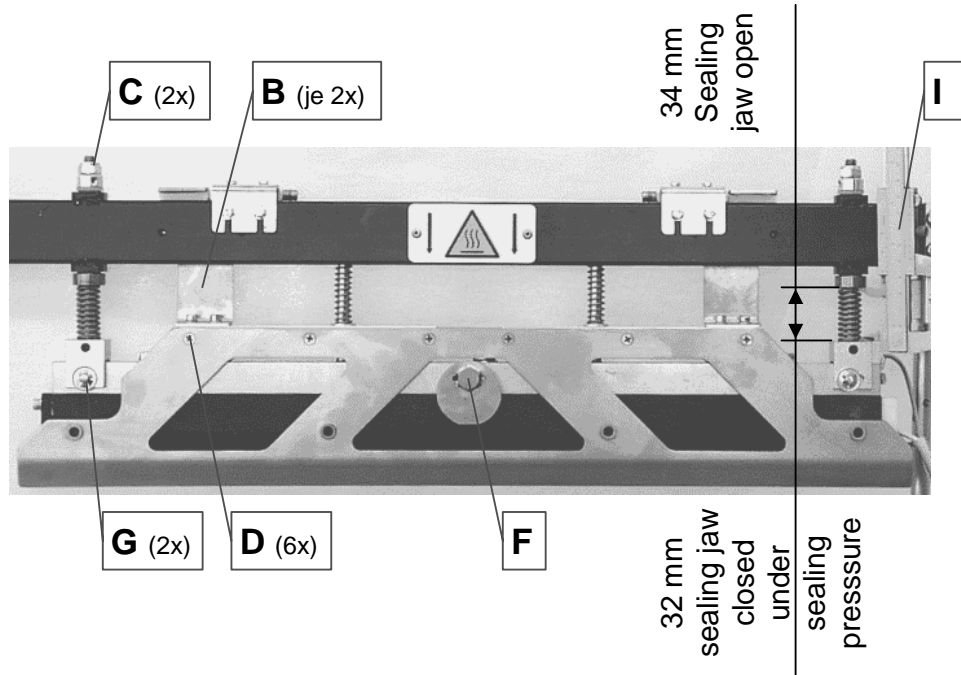


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Exchange of the sealing jaw at the cross sealing unit



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Installation process

1. Unplug the plug **(A)** of the cross sealing unit.
2. Loosen both contact plates **(B)** for the product protection from the Aluminium blocks and unscrew the screws.
3. Remove self-locking nut M8 **(C)** with distance and disk at both sides. In doing so hold the sealing jaw so that it does not fall down.
Move the sealing jaw with guide pin downwards.
4. Unscrew the downholding plate at one side by removing the M4 flat head bolt **(D)**.
5. Unscrew the collar screws out of the steel ledge **(E)**.
6. Remove the circlip of the eccentric disk on the back **(F)** with a screw driver or a similar thing. Dismantle the eccentric disk **(F)** and re-install it in the new sealing jaw in oposite order.
7. Loosen the Speedfix **(G)**, push the bolts out of the holding block and remove the old sealing jaw **(H)**.
8. Install the new sealing jaw **(H)** with bolts and Speedfix **(G)** at the holding blocks.
9. Put the sealing jaw **(H)** on the holding down plate with the aluminium blocks **(J)** and secure it with with the collar screws **(E)**.
10. Re-install the remaining downholding plate.
11. Push pre-assembled sealing jaw in the cross arm of the upper sealing jaw from the bottom and fasten it from the top with the disk, the distance and self-locking nut M8 **(C)**. – In doing so pay attention that a spring distance **(I)** of 34 mm is kept.
12. Re-install both contact plates **(B)** at the Aluminium blocks and check the function of the hownholders.
13. Pulg in the plug **(A)** of the cross sealing unit.
14. The sealing pressure has to be checked when the sealing jaw is closed.

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Adjusting of the sealing pressure at the cross sealing unit

Adjusting of the sealing pressure at the seling unit with EGS-drive

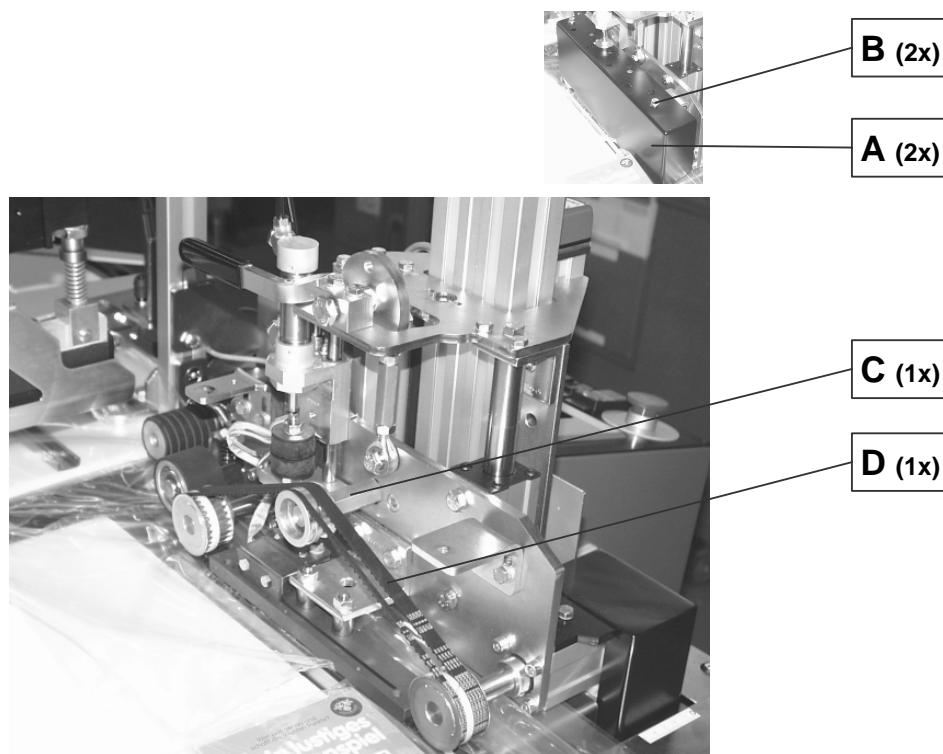
- for doing this adjust a long closing time of 2 hours (indication 200)
- take the film out of the machine
- release a manual sealing cycle in manual operation
- Press „machine off“ while the sealing jaw is in its lower position (sealing jaw stops)
- open the safety door
- measure the spring distance **(I)** between holding block and set collar. Distance has to be 32 mm when the sealing jaw is closed; when the sealing jaw is open the distance is 34 mm
- if this measure is different the distance can be adjusted at the lateral joint rods when the sealing jaw is closed; for that purpose the counternuts have to be opend, the inner part has to be turned and the counternuts have to be re-tightend
- reset the closing time

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Exchange of the toothed belts at the length sealing unit

Exchange of upper toothed belts

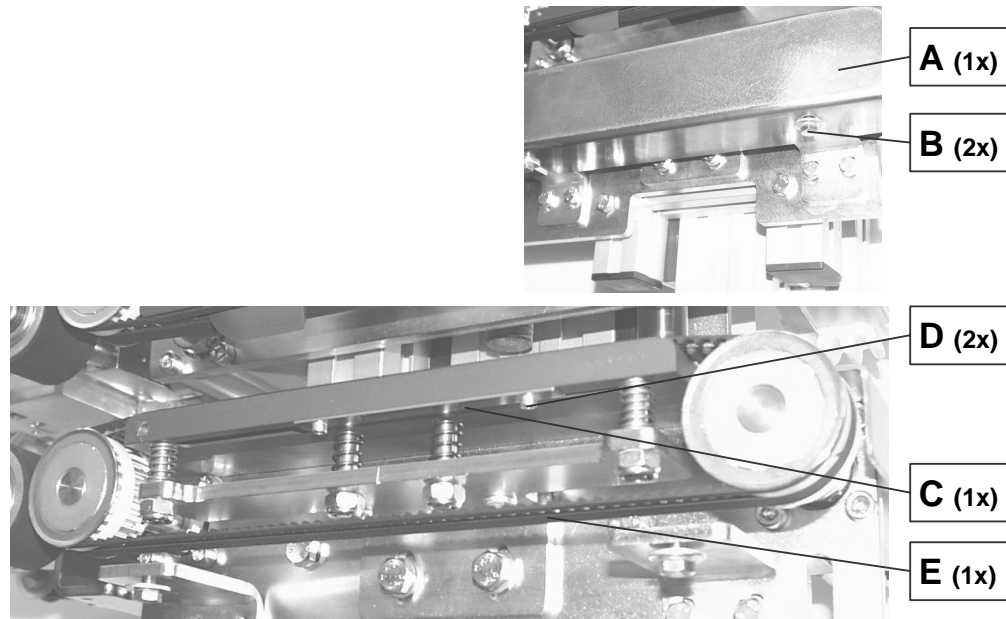


1. Dismount the protection hood **(A)** by loosening the two fastening screws **(B)**.
2. Loosen the upper tension roll **(C)** with two fork wrenches (SW13 and SW17) from the back side and push them down till the belts can be drawn off from the pulleys.
3. Install the new toothed belts of the same type on the pulleys
4. Move the tension roll **(C)** upwards and re-tighten it under tension.
5. Check the correct position of the toothed belts **(D)** by turning them several times.
6. Fasten the protection hood **(A)** with the two fastening screws **(B)**.

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Exchange of lower toothed belts

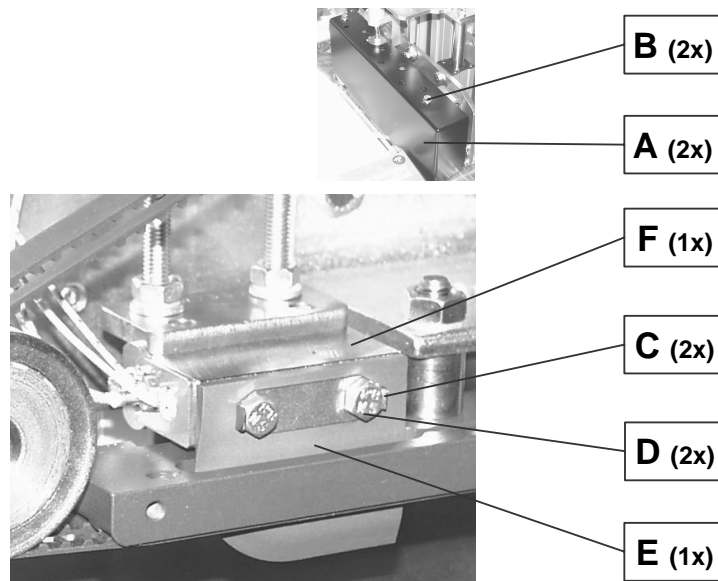


1. Dismount the protection plate **(A)** by loosening the two fastening screws **(B)**.
2. Remove the separation plate **(C)** by taking off the two fastening screws **(D)**
3. Draw the toothed belts **(E)** from the pulleys by turning the pulley and drawing the belt to the side at the same time
4. Draw the new toothed belt of the same type on the pulleys in opposite order and have them run into guiding grooves.
5. Check the correct position of the toothed belts **(B)** by turning them several times.
6. Re-install the separation plate **(C)** with the two fastening screws **(D)**
7. Re-mount the protection plate **(A)** with the two fastening screws.

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Exchange of the sealing key at the length sealing unit



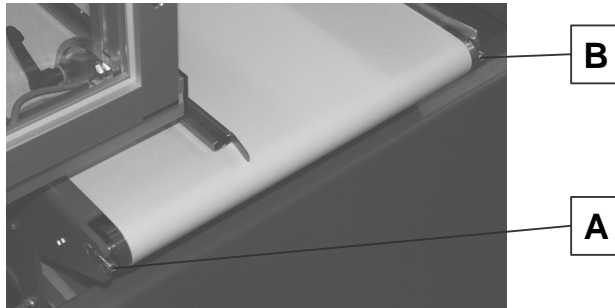
1. Have the length sealing device cooled down and push it upwards in its highest position.
2. Dismount the protection hood **(A)** by removing the two fastening screws **(B)**
3. Unbend the brackets **(C)** of the safety plate at the two M5-hexagon bolts **(D)** with a slotted screw driver.
4. Unscrew the hexagon bolts **(D)** and remove the safety plate **(C)** with the sealing key **(E)** from the sealing element **(F)**.
5. Clean the heating element **(F)**.
6. Fit the new sealing key **(E)** and the safety plate **(C)** again. In doing so it has to be observed that the key sides are right-angled to the safety plate **(C)**.
7. Re-place the brackets **(C)** of the safety plate at both sides of the hexagon bolts. They should be replaced after repeated use due to danger of break.
8. Check correct position of the sealing key. It should be centric and parallel to the split in which it emerges between the belt pair.
9. Re-mount the protection hood **(A)** with the two fastening screws **(B)**.
10. Put the length sealing unit back in the sealing position.

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Adjust the belt course at the transport conveyors

Infeed conveyor



Belt runs off centre e. g. to the right-hand side in passing direction:
Tension the belt at the left-hand side.

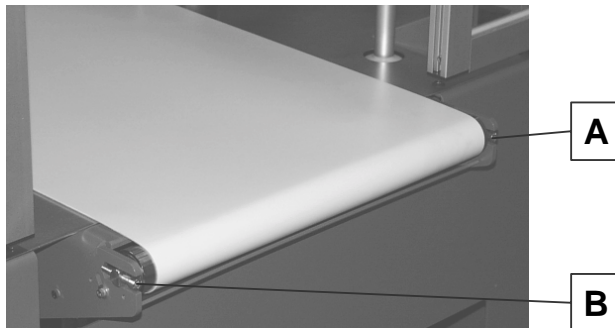
Turn the inner hexagon screw at the left-hand side **(A)** at the infeed conveyor by a quarter of a rotation in clockwise and wait 60 seconds till the belt is in its new position.

This process has to be repeated till the belt is in the centre.

Belt runs off centre e. g. to the left-hand side in passing direction:

Same procedure as above at the inner hexagon screw at the right-hand side **(B)**.

Outfeed conveyor



Belt runs off centre e. g. to the right-hand side against the passing direction:
Tension the belt at the right-hand side.

Turn the inner hexagon screw at the right-hand side **(A)** at the outfeed conveyor by a quarter of a rotation in clockwise and wait 15 seconds till the belt is in its new position.

This process has to be repeated till the belt is in the centre.

Belt runs off centre e. g. to the left-hand side against the passing direction:

Same procedure as above at the inner hexagon screw at the left-hand side **(B)**.

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Compacta Silicon ledge at the cross sealing unit

The standard sealing ledge is prepared for the use of Polyethylene and Polyolefin film (Copolymer film).

If, in case of use of Polyolefin film, traces of squeezing are appearing resp. the sealing seams are squeezed off or open the attached small support plates, thickness 0,5 mm, have to be put under the two hard rubber blocks (see photos).

Per side 1 or 2 of the small support plates can be placed under the hard rubber blocks. Thus the film tension caused by the holding-down plates can be reduced during the sealing process itself.

You can find the small support plates in the control cabinet of the Compacta together with the standard spare parts which are delivered together with the machine.

