INSTRUCTION MANUAL

05/13/03 Part #701042

TITAN Rollbag ™

MODEL 1055

AUDION AUTOMATION™

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ILLUSTRATIONS

HOW TO USE THIS MANUAL

NOTES
The users manual contains information important to the proper operation of the machine. Icons such as those shown in the margin are used to emphasize some of the most important information in the manual.

SAFETY INFORMATION:
The users manual also contains very important information to protect both the operator and the machine. Please pay special attention to safety warnings that appear in the manual.

The stop icon appearing in the margin alerts you to a safety warning on the subject it accompanies. A safety warning may affect both the operator and the machinery. A full explanation of the warning accompanies the stop sign icon when it is used.

The caution icon appearing in the margin alerts you to important precautions on the subject it accompanies. A caution warning may affect the machine and its operation. A full explanation of the safety caution accompanies the caution icon when it is used.

READ MANUAL FIRST

Your new ***TITAN*** packaging machine is safe and easy to use and maintain providing a few simple procedures are followed.

IMPORTANT: Please read this manual and familiarize yourself with the equipment before attempting to use it. The manual will serve as a valuable aid to understanding the machine, its operation, and the packaging materials used with it.

As Audion Automation's policy is one of continuous improvement and development of each line of machinery we make, this manual, though completely up to date at the time of publication, is subject to change, without notice.

model number_____ **serial number**_____

Please enter the model and serial numbers of your machine in the spaces provided above. If it becomes necessary to contact Audion Automation, please be prepared to furnish the model and serial numbers.

SAFETY INFORMATION

Follow local electrical and safety codes as well as the National Electrical Code (NEC) and Occupational Health and Safety Act (OSHA).

Check the specifications on the Machine Identification Label, then connect the machine to a properly rated, grounded outlet. The unit should be installed by a qualified electrician (except 120 volt machines). Machines which operate on 120 volts may be plugged directly into an appropriate grounded electrical supply. The use of an extension cord is not recommended. Connect the machine to a power source which matches the specifications on the machine's identification label.

All guarantees and warranties are void if the machine is used with an improper or ungrounded connection.

There are live, high voltage components in the control compartment. Always disconnect the power source before removing the top cover and servicing the machine. On 110-125 Volt machines, unplug the line cord and tag it to prevent unexpected application of power. On 220 Volt and higher voltage machines, set the disconnect box to the OFF position and lock it if possible. If no lock is available, remove the fuses using a properly insulated fuse puller only, and again, tag the disconnect to prevent the unexpected application of power.

Do not operate this unit in an explosive atmosphere. Do not subject the machine to wet or corrosive environments. Keep all flammable and caustic substances away from the machine at all times.

On pneumatic machines, stand clear of sealing jaw when connecting the air supply. It will open suddenly as compressed air is applied.

Only qualified service persons should be allowed to service the equipment. They should be equipped with proper tools and supplied with an electrical schematic of the unit.

Be careful when working on or in the machine. The transformers, heaters and motors operate at elevated temperatures, and can cause pain/injury if handled improperly.

Never install replacement fuses or other devices of a rating higher than those supplied with the machine or as indicated in the schematic. When cleaning electrical or electronic equipment, always disconnect power (as described above) and use an approved, non-flammable cleaning agent.

On pneumatic machines, do NOT connect electrical power before air supply has been connected and sealing jaws are opened or serious damage to the machine may result.

REQUIREMENTS

LOCATION

The unit must be located indoors only, and in a non-explosive atmosphere. Place the unit on as level a section of floor as possible. It is necessary to have a suitable load bearing area (sturdy floor, table, etc.).

POWER

The unit must be located at or near an appropriate electrical supply. Make certain that the power source conforms to the requirements of the machine, and that the proper gauge and type of wire is used as supply. Connections should be made with the shortest possible runs. REMEMBER: Long transmission lines are factors in reduced voltage.

UNPACKING AND INSPECTION

Remove all packing materials from the machine. Locate all hardware, manuals, etc. Carefully examine machine for any indications of damage that may have occurred in transit.

On applicable equipment, open the electrical control box cover and inspect the interior for loose wires and/or hose connections/components. Make any necessary repairs/ adjustments, close and lock the control box cover.

If there is any damage, CONTACT THE DELIVERING CARRIER IMMEDIATELY, and file a damage claim.

Remember that even minor damage on the outside of the machine can cause problems with sensitive electronic components inside the machine. Retain all packing materials pending inspection of the damage and satisfaction of your claim by the carrier.

Do NOT connect air or electrical power to the machine until inspection has been satisfactorily completed, and any necessary repairs/adjustments made.

DESCRIPTION

The ***TITAN*** model 1055 **Rollbag**tm machine is a complete, self-contained unit that fills and seals pre-made bags-on-a-roll. The simple, common sense design includes a flat, stainless steel work area to facilitate filling and sealing in one compact area on the machine. When a bag is advanced into the fill/seal area, it is automatically blown open, ready for filling. After filling, the integral Simpulsetm sealer is activated, heat sealing the filled bag with no additional movement required. The completed package, still attached to the roll of bags, is then pulled downward, moving the next bag into position for the next filling cycle as the operator separates the completed package at the perforation.

SEAL ACTIVATION

The Simpulse heat sealer is activated by an electric foot switch. The operator, while holding the filled bag near its open end, depresses the foot switch. The seal head will close, apply heat, cool, and then open. For safety, the jaw will reset to its open position if anything interferes with it closing completely, or if the foot switch is released before it is completely closed.

CAUTION: DO NOT use the standard electric foot switch if there are liquids on the floor. If the foot switch were immersed in water or other liquid a dangerous shock hazard might result. Waterproof foot switches as well as foot switch guards are available as optional accessories.

OPERATION

The roll of bags passes through the heat sealer jaws where the end bag is blown open, filled, and then heat sealed while in a stationary position. After sealing the operator pulls the completed package down which also moves the next bag into the filling position. The operator then *may* simultaneously remove the sealed bag at the perforation. This method allows for higher speeds, the ability to handle difficult products and the ability to "strip package," a method in which the filled and sealed bags remain in a continuous strip that can be separated at the perforations at any future time. This method is commonly used for inventory control and pre-counted quantity dispensing.

Additionally this machine can accept the optional ***TITAN*** printing attachment which can print dates, prices, part numbers etc., on the bags using permanent quick dry ink. Bag widths up to the 12 inch seal width can be filled and sealed. Both sealing jaws are Teflon* covered. The rolls of bags are front loaded to give you easiest access and minimize down-time.

INSTALLATION

PLACEMENT

When choosing a location, choose an area close to where the products being packaged are manufactured or stored for the greatest ease of supply. Also take into consideration whether the operator will be sitting or standing when using the machine. The 1055 is designed to be used on any table top or with ***TITAN's*** optional adjustable height console stand. Make sure the environment is clear of any excessive dust or dampness.

IMPORTANT: DO NOT USE THIS MACHINE IN WATER OR IN AN EXPLOSIVE ENVIRONMENT.

ELECTRICAL REQUIREMENTS

Check the information on the specification nameplate on the back of the machine. The standard operating voltage is 110/120 Volts, A.C. with ground. 110/120 VAC machines are rated at 5 amperes, 60 Hz, and are ready for immediate production use.

NOTE: IF A GROUNDED RECEPTACLE IS NOT AVAILABLE, YOU MAY USE A PROPER GROUNDING ADAPTOR. FOR YOUR SAFETY, AND FOR THE PROTECTION OF THE MACHINE, DO NOT OPERATE WITHOUT A PROPER AND SECURE ELECTRICAL GROUND. ALL WARRANTIES ARE VOID IF THE MACHINE IS USED WITH AN UNGROUNDED CONNECTION.

The unit is available with a *factory installed* option that will allow the unit to operate on 220/240 VAC single phase, with ground. 220/240 VAC machines (2.5 amperes, 50/60 Hz) require the installation of a proper male power plug or to a properly rated electrical disconnect. As 220 volt receptacles are different from one plant to the next, a 220 plug is *not* supplied with the machine.

NEVER CONNECT A MACHINE TO ANY POWER SOURCE THAT EXCEEDS ITS SPECIFIED RATING.

COMPRESSED AIR REQUIREMENTS

The ***TITAN*** 1055 **Rollbag**™ machine requires compressed air to operate. The air inlet is a 1/4" female pipe thread (F.P.T.) located on the upper left rear side of the machine as you face the sealing jaws. The machine requires 25 P.S.I. air pressure and uses less than 1 cubic foot of air per minute (C.F.M.).

CAUTION: BEFORE CONNECTING COMPRESSED AIR PULL THE SEALING JAW TO ITS MAXIMUM OPENING OR STAND CLEAR WHEN MAKING THE CONNECTION AS THE SEALING JAW WILL OPEN SUDDENLY.

NOTE: Do *NOT* introduce greater than 125 P.S.I., compressed air into the machine or damage *WILL* result.

If your supply air line pressure is greater than 125 P.S.I., install a separate air pressure regulator prior to the machine to reduce the supply air pressure to approximately 50 P.S.I. before allowing compressed air into the machine. The machine is supplied with a built in adjustable locking air pressure regulator (top left side of the machine) and pressure gauge (right face of the machine). Unlock the regulator adjustment knob by pulling out on its outer ring. The regulator was set to “0” pressure prior to shipment. Slowly rotate the adjustment knob so that approximately 25 P.S.I. is indicated on the gauge. After making this setting depress the locking ring on the regulator knob.

LOADING BAGS-ON-A-ROLL (see illustration on page 15)
Turn Machine *Off.* Open the front door of the machine by pulling from the *right* side of the door. The hinges are on the *left* side. Locate and remove the core-roll shaft from its holding brackets. Remove the locking collar and brake spring from one end of the core-roll shaft. Insert this end of the shaft through the core of a roll of bags (maximum width 12 inches). Replace the spring and locking collar on the core-roll shaft. *Center the roll of bags on the core shaft.* This can be easily accomplished by loosening both locking collars and making the required adjustment. The springs and locking collars hold the core of the roll-bags in place. The tension of the spring against the side plate of the roll-bags supplies brake tension. Place the assembled roll-bags and core shaft on the holding brackets and let the roll "fall" into the roll-stops. Some experimenting with the brake adjustment may be required to allow the bags to unwind with the proper resistance. *Too much tension might cause the perforations on the roll-bags to tear apart as they are advanced.*

Thread the bags through the back of the machine and into the opening on the top back of the unit. Slide the bags forward until the bottom of the first bag appears through the opening on the front. Close the front panel. Be certain that the *OPEN* side of the bags is on the front of the machine facing the operator. If the closed side of the bag is facing the operator, the bags will not open. Should this occur, roll the bags back onto the roll of bags, remove the core-roll shaft, rotate it 180 degrees, and re-thread the machine.

Note: If your machine is equipped with the optional printer, the threading of the bags will change. Refer to the operating instructions supplied with the printer.
The machine is now ready for production.

OPERATING THE MACHINE

TURN MACHINE ON

The combination Power Switch/red pilot light indicator is on the top left front of the machine. Press the switch once, firmly, and release it. The pilot light will light and the fan motor will begin to run. **(If this does not occur, refer to the TROUBLE SHOOTING section of this manual.)** With the pilot light on and the fan running, the machine is ready for use.

AIR FLOW ADJUSTMENT

The air flow from the self contained blower is adjustable. The adjustment control knob is located on the left side near the top of the machine. Rotate the knob clockwise to increase and counter-clockwise to decrease the air volume. It will require several turns to make a noticeable difference in air volume. When the heat sealer is activated the air flow is re-directed away from the filled bag. As the sealer jaw opens the air flow will start again. This helps eliminate excess air from the newly sealed bag. If trapped air is a problem, you may wish to use vented bags, bags made with a skip seal, or you may choose to install the optional air expeller.

BAG FILLING, SEALING & SEPARATION

Stage the bag to be filled so that the open top of the bag is just above the fixed sealing jaw. If the bags are threaded properly, the bag will open in the air stream. If your machine is equipped with the optional funnel assembly, adjust the funnel so that it is smaller than the open mouth of the bag. The open bag is then ready for loading product. Drop product, either into the optional funnel or directly into the open bag. When the bag is filled, activate the impulse heat sealer. For safety, the foot switch must be depressed until the jaws are completely closed. When the jaws are completely closed the machine takes over and the foot switch may be released. After the seal is made, the sealing jaw will open. Pull the filled/sealed bag down until the next bag opens and remove the filled bag from the roll at the perforations or leave it attached for "strip packaging". The next bag is now in position for filling and sealing. **Heavy products may require the use of the adjustable height product support.**

HEAT SEALER TEMPERATURE AND DWELL ADJUSTMENTS

The ***TITAN*** model 1055 **Rollbag**tm Simpulsetm heat sealer has a single control for temperature time adjustments. The control knob is located on the left front side of the machine just below the Power Switch. The pointer knob is adjustable from 0 to 100%. We recommend setting the knob at position 3 on the dial as a starting place for the first seal. Make the seal and inspect the bag. You should see the grain of the Teflon* in the seal and the seal area should have a slightly milky appearance. You should not be able to pull the two halves of the bag apart nor should the bag area above the seal have flapped over. If the bag opens turn the heat up slightly, inspecting the bag after each seal. Repeat this step until you are satisfied with the seal strength and appearance. If the area above the seal looks shrunken and/or the top of the bag flops back on itself, the temperature is set too high. Reduce the control setting until a proper seal is made.

NOTE: The sealing element expands and contracts during each heat sealing cycle. This will ultimately cause the element to fail. When the sealing element is replaced it may be necessary to slightly re-adjust the temperature control.

MAINTENANCE PROCEDURES

WARNING: TURN MACHINE OFF AND DISCONNECT POWER BEFORE DOING MAINTENANCE OR REPAIR PROCEDURES!

SAFETY FIRST

Turn machine off and disconnect power by unplugging it from electrical service at the wall before doing any maintenance or repair procedures.

Disconnect the compressed air supply.
Have only trained and experienced personnel or technicians work on machine.
Follow The Instructions

PREVENTIVE MAINTENANCE

SEALING ELEMENT

The sealing element is an expendable item and will eventually break. Keep a supply of sealing element assemblies on hand for quick in-house repair.

To replace the sealing element, turn off machine and remove power. Unroll the lower Teflon* assembly so that all of the material is on the upper roller and the two screws that fasten it to the lower shaft are exposed. Carefully remove the two screws and roll the balance of the Teflon* on to the upper roller. Look at seal area. There is a retainer nut at each end of the element holding the connectors in place. Remove retainer nuts, lift the old element assembly off of the terminals. There is a Teflon* slide base under the element, check to see that it is not burned or torn. Replace if necessary. **(Please refer to installation drawing on page 16.)**

INSTALLATION: (NOTE: There is a top and bottom to the element.) Place the left element connector of the new ribbon assembly over the post screw, and finger tighten the nut. Then compress the left side (spring loaded) terminal connection and place the right element connector over the fixed threaded stud at the right end of the sealing jaw. Replace the retainer nut. THE RETAINER NUTS MUST BOTH BE IN PLACE BEFORE OPERATING MACHINE. FINGER TIGHTEN BOTH. DO NOT USE TOOLS.

NOTE: THE NUTS HAVE BEEN TIGHTENED SECURELY AT THE FACTORY TO PREVENT LOSS DURING SHIPMENT, SO IT MAY BE NECESSARY TO USE A WRENCH OR PLIERS TO LOOSEN THE NUTS THE FIRST TIME YOU CHANGE THE SEALING ELEMENT.

TEFLON* CURTAIN ASSEMBLY

A Teflon* curtain covers the heating element assembly to prevent sticking and possible film build-up on the element itself. This curtain is attached to two rollers, each with an adjustment knob. By turning either knob the Teflon* will be re-positioned from a worn area to an unused area. The curtain should last a long time before replacement is necessary. Keep an extra Teflon* curtain on hand for quick, in-house repairs. To replace the Teflon* Curtain, *first turn the machine off and disconnect electrical power.* Then unroll the Teflon* assembly so that all of the material is on the upper roller and the two screws that fasten it to the lower shaft are exposed. Remove the two screws. Grasp the end of the old Teflon* assembly and pull it toward you while "helping" it to unwind by rotating the upper knob. When you get to the end two additional screws will be exposed. Remove them and discard the worn curtain. Installation of the new Teflon* assembly is the reverse of the preceding. After the new Teflon* assembly is installed rotate both roller knobs in opposite directions until there is about 50% of the Teflon* material on each roller. Then hold one roller knob, to prevent its rotation, while turning the other about one half a turn. This will take the slack out of the material, leaving a smooth surface in the sealing area.

CAUTION: DO *NOT* USE THE MACHINE WITHOUT THE TEFLON* CURTAIN ASSEMBLY PROPERLY MOUNTED TO THE ROLLERS.

UPPER TEFLON* ASSEMBLY

The Teflon* cover over the silicone rubber pressure pad should be replaced each time the lower Teflon* curtain assembly is replaced. It is mounted to the sealer head with the *Upper Teflon* Mounting Spring* that passes through the reinforced eyelets on both ends. Keep an extra upper Teflon* cover on hand for quick, in-house repairs.

SILICONE PRESSURE PAD

There is a silicone rubber pad under the sealing head. Eventually, it will need to be replaced. To replace the compression rubber, first follow the directions for removing the upper Teflon* assembly. The compression pad is held in place with adhesive and can be easily be removed. Make sure the area is clean and smooth before installing the new, pressure sensitive backed pad. Remove the release paper from the back of the new pad and place it in position on the lower side of the upper jaw. Replace the Teflon* cover. The machine is again ready to be used.

CAUTION: DO NOT USE THIS MACHINE UNLESS THE TEFLON* COVER AND COMPRESSION PAD ARE IN PLACE.

TROUBLE SHOOTING

You will find that your new ***TITAN*** model 1055 **Rollbag**tm machine is a rugged, trouble-free machine that will require a minimum of maintenance. Barring major repair, a list of possible emergencies is listed below along with some things to check and corrective measures to take.

REMEMBER TO TURN OFF MACHINE AND DISCONNECT POWER BEFORE PERFORMING ANY OF THE FOLLOWING PROCEDURES. ONLY QUALIFIED SERVICE PERSONNEL SHOULD PERFORM THESE PROCEDURES.

1. Sealed bag is opening
    a. Check temperature setting and increase if necessary.
    b. Check to see that you are not sealing so close to the product that you are setting up a strain on the seal.
    c. Lower limit switch(s) not making contact. Adjust or replace.
    d. Loose connection at timer or faulty timer. Adjust or replace.

2. Film sticks to sealer jaws
    a. Is the Teflon* worn? Replace or rotate the curtain.
    b. Are you sealing through printed area of the bag? DON'T*
    c. Is there a build-up of foreign matter or film residue?
    d. Is the compression pad grooved? Replace With New Pad.
    e. Check temperature setting. It might be too high.
    f. Have you applied **LUBRISLIP**tm?

3. Bags will not blow open
    a. Check to see if bags are loaded properly (open side of bags toward operator). See Bag Loading.
    b. Make sure you are using the right type of bags. (pre-opened bags-on-a-roll).
    c. Make sure blower motor is running. Check wiring or replace.
    d. Adjust air velocity control.

4. Sealer jaws do not dwell (stay closed for a measured time)
    a. Temperature setting is too low.
    b. Timer circuit has failed. Check connections. Replace if necessary.

5. Sealing head stays closed
    a. Loose connection on timer(s). Repair wiring.
    b. Faulty timer(s). Replace.

6. Sealing head will not activate
    a. Loose connection at foot switch or electric cord. Repair
    b. Loose connection to solenoid air valve. Repair
    c. Faulty air valve. Replace
    d. Faulty air cylinder. Replace

7. Machine will not turn on
    a. Check fuse for failure. Replace. (Proper amperage value *only*.)
    b. On/Off switch is faulty or has loose connection. Repair or replace.
8. Blower motor will not run
    a. Loose connection at motor.
    b. Blower motor unit is faulty, replace.

9. Blower air cut off will not function
    a. Loose air hose(s) to damper cylinder
    b.Cylinder disconnected from damper door, re-attach.

AUTHORIZED REPAIR CENTERS

Some problems can only be corrected by a qualified service technician. If you cannot immediately find the solution to your problem, call the authorized dealer who sold you this machine. They should have the personnel to repair any problems you might have. Older machines can be rebuilt through a Factory program. If you have any questions about service, installation procedures or if you have a suggestion for us, please let us hear from you. We are here to serve you.

PARTIAL REPLACEMENT PARTS LIST

Please show part number and description, or if in doubt, describe item fully, and give model number and serial number of machine. All parts shipped F.O.B. Factory.

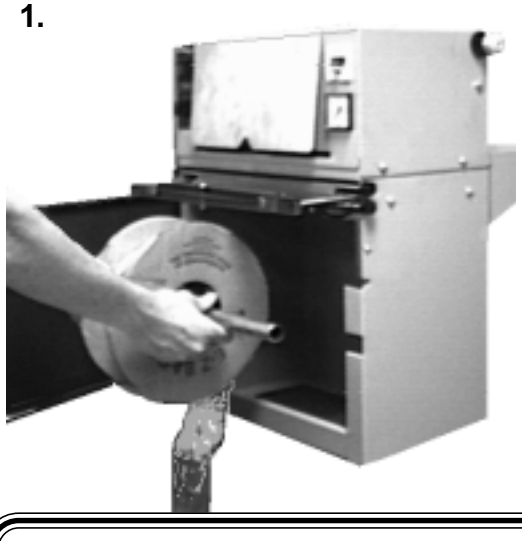
PART NO.	DESCRIPTION
T00037	Silicone Compression Pad *
T00202	Barrier Strip
T00101	Lower Teflon* Assembly *
631104	Lower Teflon* Mounting Screws *
452000	Blower Motor Assembly
470087	Simpulse™ Seal Transformer
T08160	Heating Element *
T08164	Upper Teflon* Assembly *
260105	Upper Teflon* Mounting Spring
T08010	LUBRISLIP™ 100% Pure Silicone Oil *
435060	Power (On/Off) Switch
310053	Solenoid Air Valve
432020	Limit Switch
300280	Air Cylinder, Jaw
300285	Air Cylinder, Damper
T18200	Pot Assembly for Timer
477020	Timer

* These parts are considered expendables. We recommend that you keep a small inventory on hand to prevent shut downs.

* Teflon is a registered trademark of the E. I. DuPont Corporation

LOADING AND THREADING BAGS-ON-A-ROLL

1.



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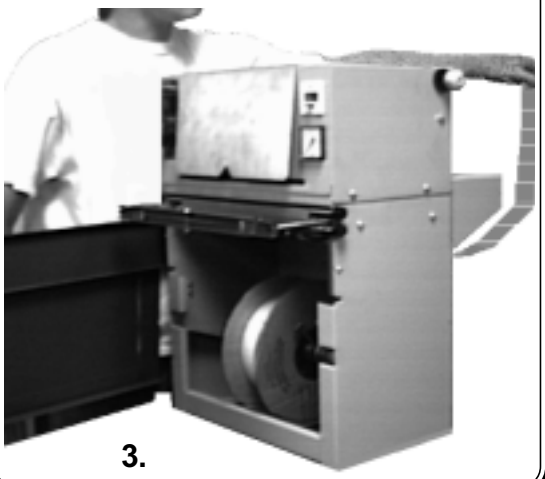

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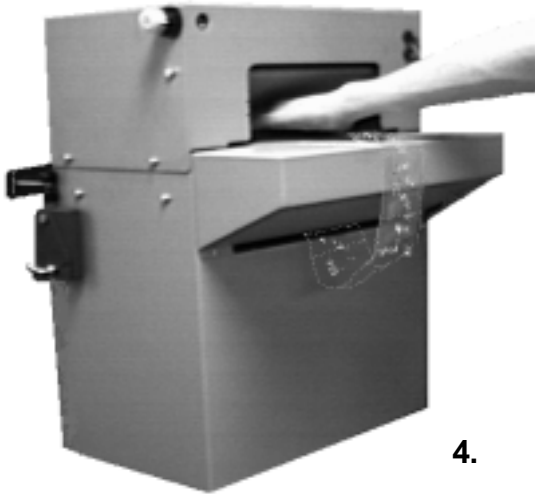
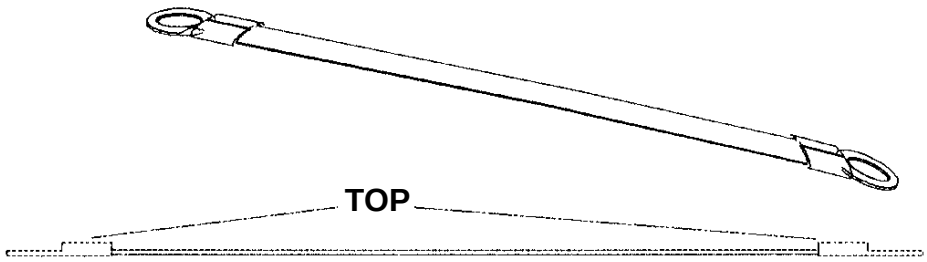


4.

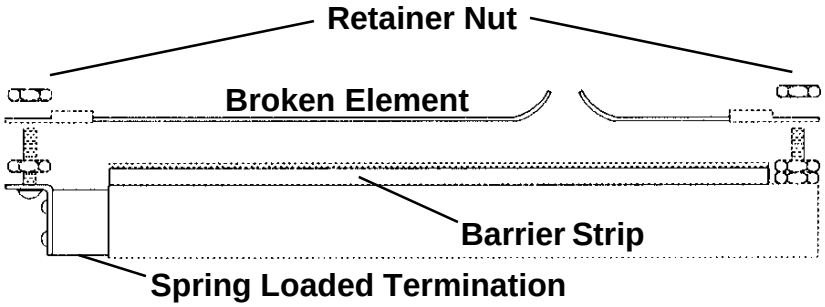
5.

HEATING ELEMENT INSTALLATION



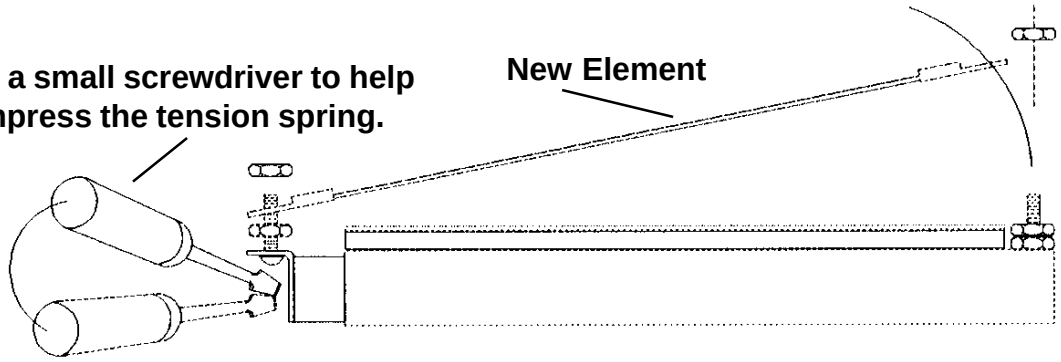
Side View - Heating Element

1.



2.

Use a small screwdriver to help compress the tension spring.



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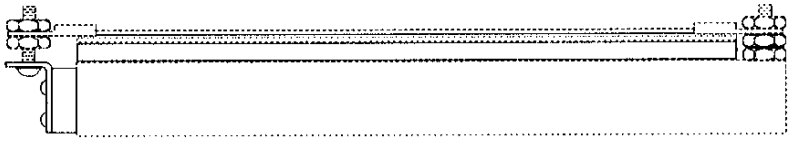
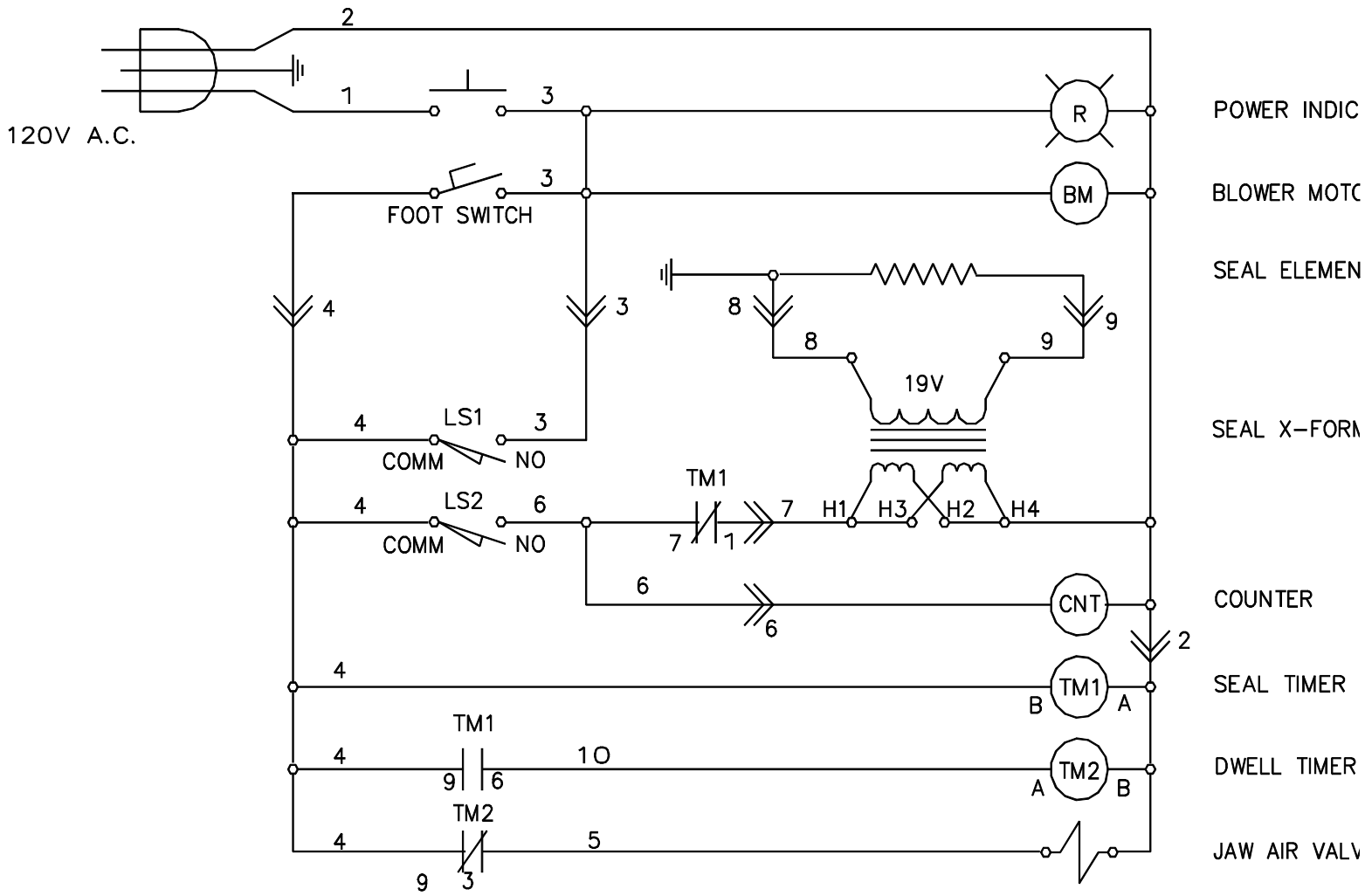


IMPORTANT:

Replace Teflon* Covers Before Use



REVISIONS			LAYER
DATE	BY	CHANGES	REV.
5/14/2003	WNS	NEW LOGO	A

AUDION AUTOMATION, Ltd.
1900 SURVEYOR BLVD. CARROLLTON, TX 75006 U.S.A.
972.389.0777 FAX 972. 389.0790
SERGEANT™ TITAN™ VACUMASTI

NAME: SCHEMATIC 1055 ROLLBAG 120 VAC

USED ON:

BY	DATE	REF
RICO	5/25/1995	T270

AUDION AUTOMATION™

LIMITED WARRANTY

Audion Automation, Ltd. warrants this product, to the original retail purchaser, against defects in material and/or workmanship, for a period of one year from the date of the original installation for use, and agrees to repair and/or replace any parts found defective by us, without charge, provided unit or parts are returned to us with transportation charges prepaid. Replacement parts supplied during the product warranty period are warranted for the balance of that period.

This warranty does not cover damage resulting from accident, misuse or abuse, lack of reasonable care, the affixing of any attachment not provided by us, improper handling and/or maintenance. Neither shall this warranty cover normally replaced expendable parts. This warranty is VOID unless the repair is made by Audion Automation, Ltd. or by one of its authorized distributors.

The obligation of Audion Automation, Ltd. under this warranty is limited to repair or replacement in accordance with the terms of this warranty. There are no warranties offered by Audion Automation, Ltd. other than those herein described. Coverage under this warranty does not include incidental consequential damages other then the coverage described above. This warranty gives you specific legal rights, and you may also have other rights that vary from state to state.