

# 8362i

## INSTRUCTION MANUAL

This instruction manual applies to machines from the serial number **2 819 660** and software version **0450/001** onwards.



This instruction manual applies to all models and subclasses listed in **chapter 3 Technical Data**.

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## 1 Safety

### 1.01 Directives

The machine was built in compliance with the European regulations specified in the declaration of conformity.

As a supplement to this instruction manual, please also observe the generally applicable, legal and other regulations and legislation – also in the country of use – and the valid environmental protection regulations! Always comply with the locally applicable regulations of the professional associations and other supervisory authorities!

### 1.02 General safety instructions

- The machine may only be operated after you have become acquainted with the associated instruction manual and only by operating personnel who have received appropriate training!
- Always follow the hazard and safety instructions attached to the machine!
- The machine may only be operated for its intended purpose and only with the associated safety covers, while adhering to all the relevant safety requirements.
- Isolate the machine by pulling out the mains plug from the power supply when replacing the feed rollers or hot wedge, when leaving the work station and for maintenance and adjustment work!
- The daily maintenance work may only be carried out by suitably qualified personnel!
- Repairs and special maintenance work may only be carried out by technical staff or people with appropriate training!
- Work on electrical equipment may only be carried out by qualified technical staff!
- Work on parts and equipment under voltage is not permitted!  
Exceptions are regulated by the EN 50110 standards.
- Modifications and changes to the machine may only be made in compliance with all of the relevant safety requirements!
- Only the replacement parts approved by us for usage may be used for repairs! We warn you expressly that spare parts and accessories that are not supplied by us are also not tested and approved by us. Fitting and/or using these products may therefore have negative effects on features which depend on the machine design. We are not liable for any damage caused by the use of non-Pfaff parts.

## 1.03 Safety symbols



Hazard point!  
Special points of attention



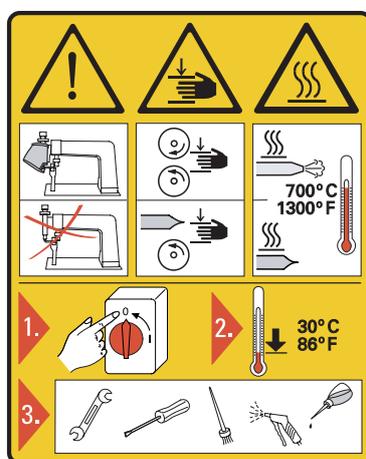
Danger of hands being crushed!



Danger of burns from hot surface!



Fatal danger from electric voltage.



### Caution!

Do not operate without finger guard and safety covers!  
Turn off the mains switch and let the machine cool down before any set-up, maintenance and cleaning work!

## 1.04 Special points of attention for the owner-operator

- This instruction manual is a part of the machine and must be made available to the operating personnel at all times.
- The instruction manual must have been read before the initial start-up.
- The operating personnel and technical staff must be instructed about the machine's safety covers and about safe working methods.
- The owner-operator may only operate the machine in a flawless condition.
- The owner-operator must ensure that no safety covers are removed or disabled.
- The owner-operator must ensure that only authorised persons work on the machine.
- The owner-operator must make sure there is no high-frequency sealing equipment being operated in direct proximity to the machine that exceeds the EMC limit values for the machine according to EN 60204-31.

Additional information can be requested from the responsible sales centre.

## 1.05 Operating personnel and technical staff

### 1.05.01 Operating personnel

Operating personnel are persons responsible for setting up, operating and cleaning the machine and for clearing faults in the sealing section.

The operating personnel are obligated to comply with the following points:

- The safety instructions provided in the instruction manual must be followed for all work!
- Any work method jeopardising machine safety must be refrained from!
- Tight-fitting clothing must be worn. The wearing of jewellery such as chains and rings is prohibited!
- Care must be taken to ensure that no unauthorised persons are located in the machine's hazard zone!
- Any changes occurring on the machine which impair its safety must be reported to the owner-operator immediately!

### 1.05.02 Technical staff

Technical staff are persons with technical training in electricity/electronics and mechanics. They are responsible for lubricating, servicing, repairing and adjusting the machine.

The technical staff are obligated to comply with the following points:

- The safety instructions provided in the instruction manual must be followed for all work!
- Isolate the machine by pulling out the mains plug from the power supply before starting any adjustment and repair work!
- Never work on live parts and equipment! Exceptions are regulated by the EN 50110 standards.
- Reattach the safety covers following repair and maintenance work!

1.06 Danger warnings



Carry out work on the sealing apparatus only after an appropriate cool down!  
 Danger of burning!

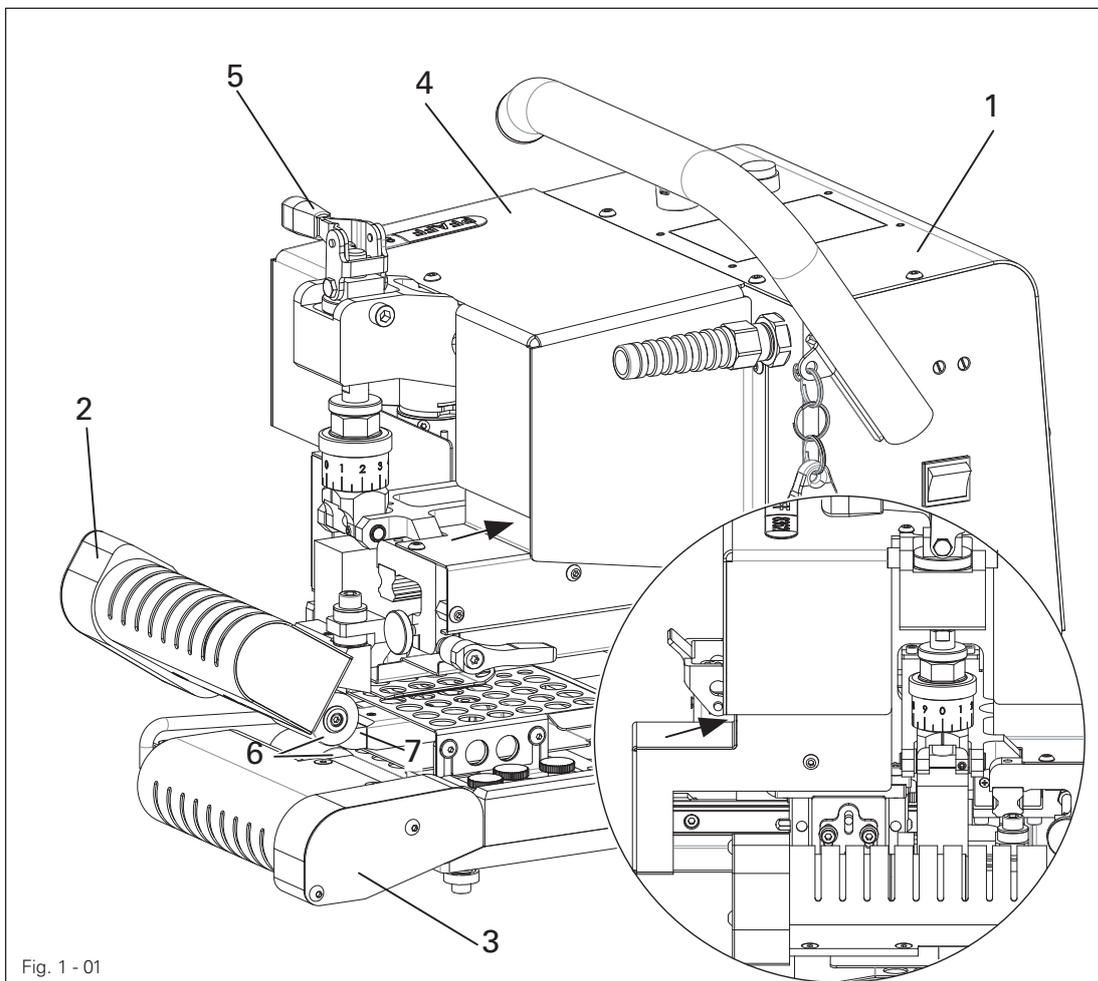


Fig. 1 - 01



Always pull out the mains plug before opening the cover 1!  
 Risk of injury from electric voltage!



Do not operate the machine without the safety covers 2 and 3!  
 Risk of injury due to the rotating belt!



Do not reach into the area between the protective cover 4 and the swivel unit 5 (see arrow)! Risk of crushing when lifting the swivel unit 5!



Do not reach into the range of the feed rollers 6 during operation!  
 Risk of crushing fingers!



After use, always let the machine cool down!  
 Risk of burns when touching the heating element 7!

2

### Proper Use

The PFAFF 8362i is a mobile hot wedge sealing machine.

The machine is used for sealing overlapping seams, hem seams and welt seams on suitable synthetic materials (thermoplastics) such as truck tarpaulins, pond liners, roof and building insulation etc. using modern smart functions.



The machine must not be used outdoors!



Any usage not approved by the manufacturer is deemed misuse! The manufacturer shall assume no liability for damage caused by misuse! Proper use also includes compliance with the operating, maintenance, adjustment and repair measures specified by the manufacturer!

**3 Technical Data<sup>▲</sup>**

**3.01 PFAFF 8362i**

Versions:

8362i-126; -140 ..... Standard version

8362i-240; -250 ..... Higher sealing power compared to the standard version

Dimensions and weights

Length: ..... approx. 400 mm

Width: ..... approx. 320 mm

Height: ..... approx. 330 mm

Weight: ..... 14 kg

Mains voltage:

Set for: ..... 230 V ± 10 %, 50/60 Hz, 1 phase

Optionally switchable at: ..... 115 AC, L/N/PE

Power consumption ..... 1 kVA

Sealing force ..... adjustable, max 500 N

Sealing temperature: ..... max. 450°C, infinitely adjustable

Sealing speed: ..... max. 10 m/min

Seam widths: ..... 26, 40 and 50 mm

Overlapping of the workpieces: ..... max. 80 mm

Sealable foil materials: ..... PVC, PE-HD, PE-LD, EVA and others

Foil quality ..... thermally sealable, flexible

Sealable foil thickness <sup>▲</sup>

8362i (silver hot wedge): ..... 0.2 - 2.0 mm

8362i (aluminium hot wedge): ..... 0.8 - 3.0 mm

<sup>▲</sup> depending on the material

### 4 Disposal of the Machine

- It is up to the manufacturer to dispose of the machine properly.
- The materials used for the machine include steel, aluminium, brass and various plastics. The electrical equipment consists of plastics and copper.
- Electrical and electronic equipment is collected separately in accordance with "Elektro G", the Electrical and Electronic Equipment Act.
- The machine must be disposed of in accordance with the locally valid environmental protection regulations, with a specialised company being contracted if necessary.



Please ensure that parts coated with lubricants are disposed of separately in accordance with the locally valid environmental protection regulations!



**Risk of environmental damage due to incorrect disposal!**

The machine must not be disposed of in normal household waste!  
Always follow the statutory waste disposal regulations!

### **5 Transport, Packaging and Storage**

#### **5.01 Transport to the customer's premises**

All machines are completely packed for delivery.

#### **5.02 Transport within the customer's premises**

The manufacturer assumes no liability for transport within the customer's premises or to the individual usage sites. Please ensure that the machines are only transported in a vertical position.

#### **5.03 Disposal of the packaging materials**

The packaging materials of these machines consist of paper, cardboard and VCI fleece. It is up to the customer to dispose of the packaging properly.

#### **5.04 Storage**

The machine can be stored for up to **6** months when not in use. It must then be protected from dirt and moisture. For longer storage periods, the machine's single components, especially its sliding surfaces, must be protected against corrosion, e.g. by an oil film.

## 6 Work Symbols

Activities to be performed or important information in this instruction manual are emphasised by symbols. The symbols used have the following meaning:



Note, information



Cleaning, care



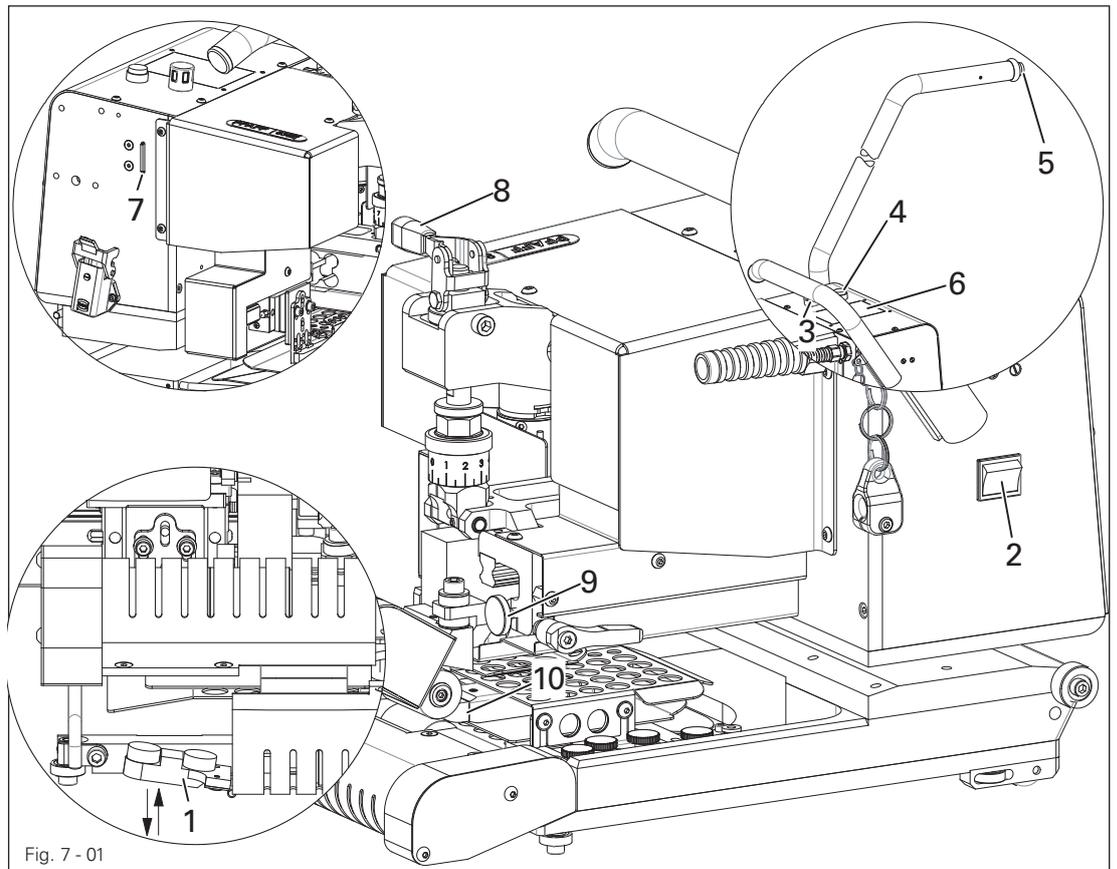
Lubrication



Maintenance, repairs, adjustment, service work (only to be carried out by technical staff)

## 7 Operating Controls

### 7.01 Overview of the operating controls



↓ Feet 1 folded up (stationary operation).

↑ Feet 1 folded down (mobile operation).

Mains switch 2, see chapter 7.02.

Rotary push-button 3, see chapter 7.03.

Start push-button 4 and push-button of the handlebar 5, see chapter 7.04.

Display 6, see chapter 7.05.

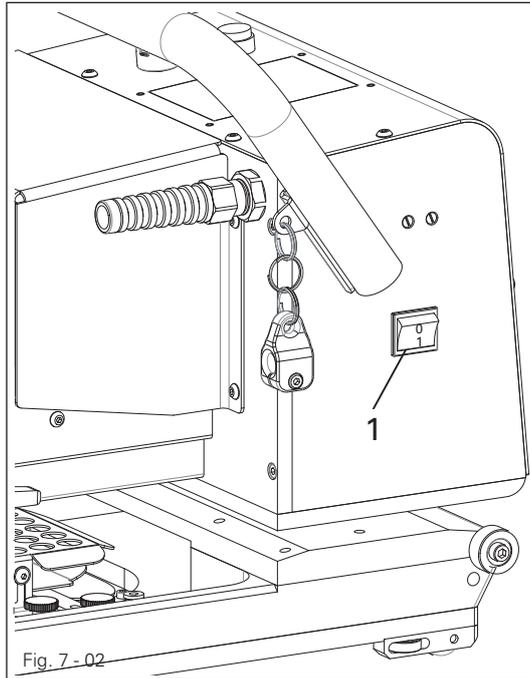
SD card reader 7, see chapter 7.06.

Roller lever 8 and roller force 9, see chapter 7.07.

Wedge position 10, see chapter 7.08.

## 7.02

### Mains switch



- Pressing the mains switch 1 switches the machine on and off.

Position "0"= machine is switched off.

Position "1"= machine is switched on.



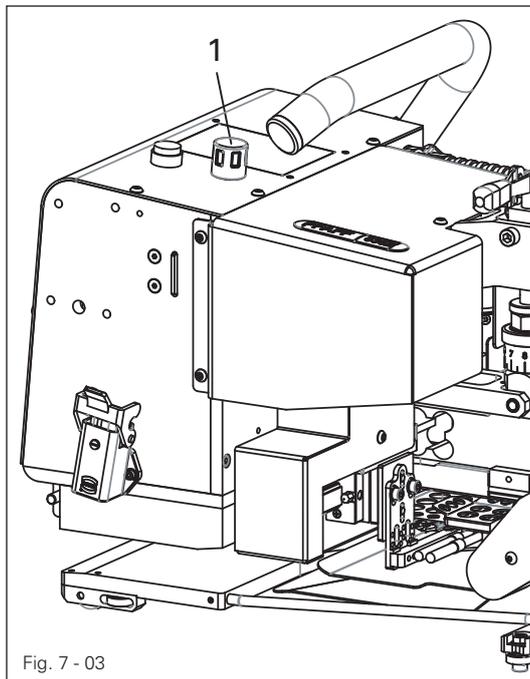
One of the three push-buttons (rotary push-button, start push-button or push-button of the handlebar) must be pressed after switching on the machine to protect it against unintentional start-up.



When switching the machine off, please observe the notes in **chapter 8.02 Switching the machine on / off!**

## 7.03

### Rotary push-button



- The rotary push-button 1 is used for navigating and entering information in the display and setting menus.

The rotary push-button 1 has the following adjustment options:



Turn slowly in a clockwise direction.

Turn faster in a clockwise direction.

Turn very quickly in a clockwise direction.



Turn slowly in an anti-clockwise direction.

Turn faster in an anti-clockwise direction.

Turn very quickly in an anti-clockwise direction.



Press the rotary push-button 1 once briefly (ENTER).

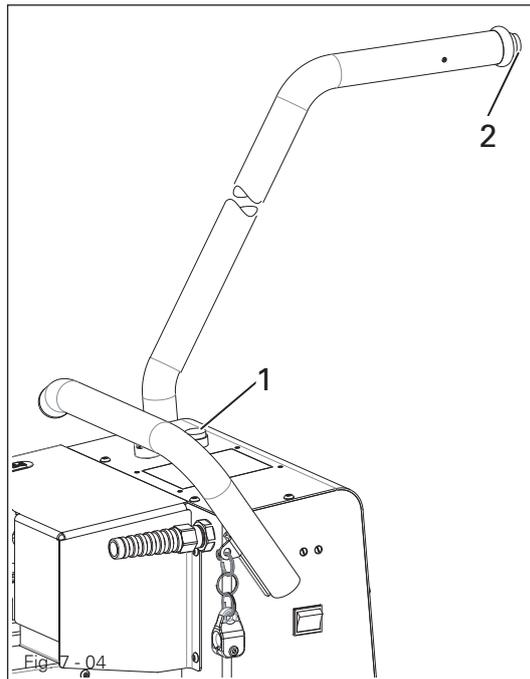


Press the rotary push-button 1 twice briefly (ESC).



Press and hold the rotary push-button 1 once (CLEAR).

## 7.04 Start push-button and push-button of the handlebar



- The start push-button 1 and the optional push-button of the handlebar 2 are treated as a single push-button by the process.
- The push-button is used to start or stop the sealing process.

The start push-button or push-button of the handlebar has the following adjustment options:



Press the start push-button 1 or push-button of the handlebar 2 once briefly.

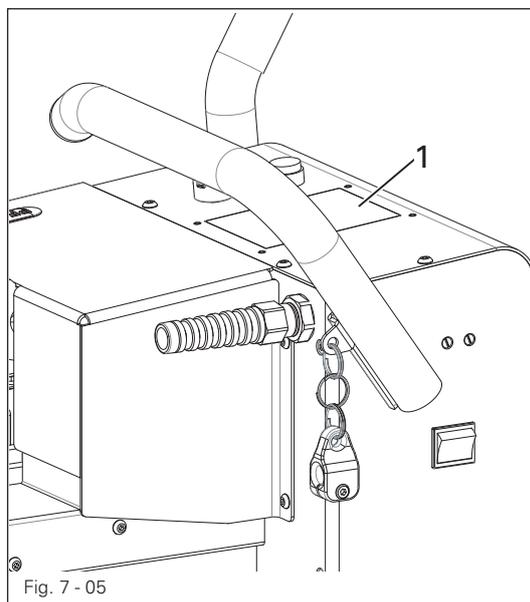


Press the start push-button 1 or push-button of the handlebar 2 twice briefly.



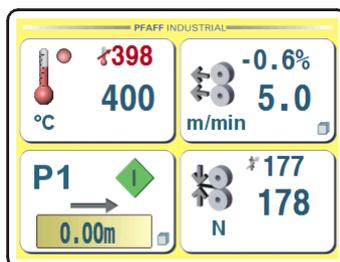
Press the start push-button 1 or push-button of the handlebar 2 once.

## 7.05 Display



- The LCD display 1 is used as the main means of communication between the user and the machine. The current operating statuses are indicated and the machine is operated with constant dialogue. Different pictograms and/or texts or sealing parameters are displayed for this purpose.

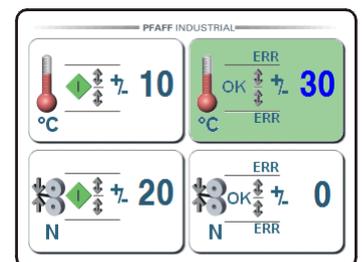
The information is displayed in the usual way for the latest generations of PFAFF sealing machines.



Production



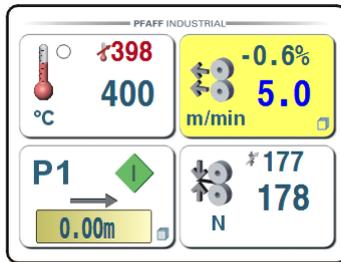
Input



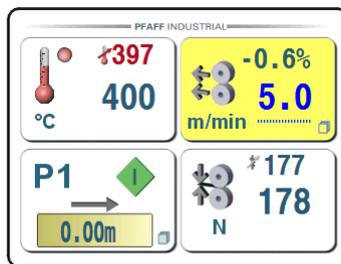
Settings

## 7.05.01 Displaying parameters / parameter selection / accepting parameters

The selection of a parameter is displayed with a coloured background. The selected parameter is highlighted in a light blue colour if several parameters are visible in the field:



Press the rotary push-button once briefly to accept the selection (ENTER). The selected parameter is underlined.



Now the rotary push-button can be used to increase the parameter (turning in a clockwise direction) or to reduce it (turning in an anti-clockwise direction).



Pressing and holding the rotary push-button once (CLEAR) sets the parameter to its minimum value.

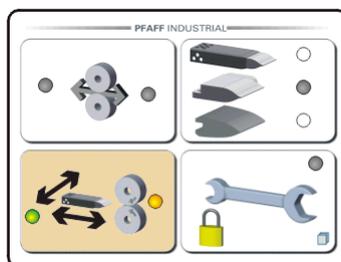


Pressing the rotary push-button twice briefly (ESC) sets different parameters to their minimum value.



The modified parameter is accepted by again pressing the rotary push-button once briefly (ENTER). The modified parameter is no longer underlined; now the parameter is not modified by turning the rotary push-button but instead a new parameter selection is performed.

The selection of switching states is displayed with different coloured LED symbols.



at this function cannot be performed easily. This requires authorisation. For the time being this authorisation is granted by simply opening the lock using the rotary push-button. However, it is possible that the input of a PIN may be required in future software releases.

## 7.06 SD card reader and writer

The SD card reader and writer 1 allows the sealing parameter sets to be stored on the SD card and read back from there.

The PFAFF 8362i can save a protocol file from every sealing process on the SD card. In addition, the machine software can be updated with an SD card.

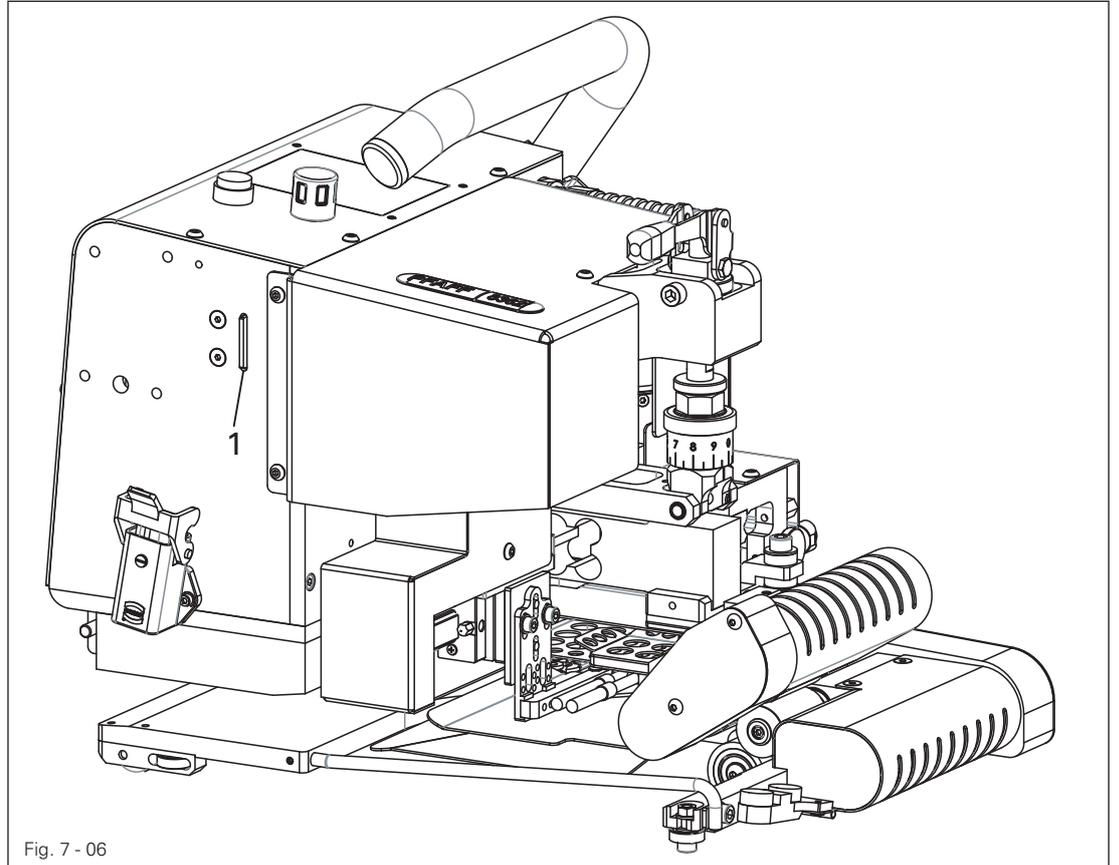


Fig. 7 - 06

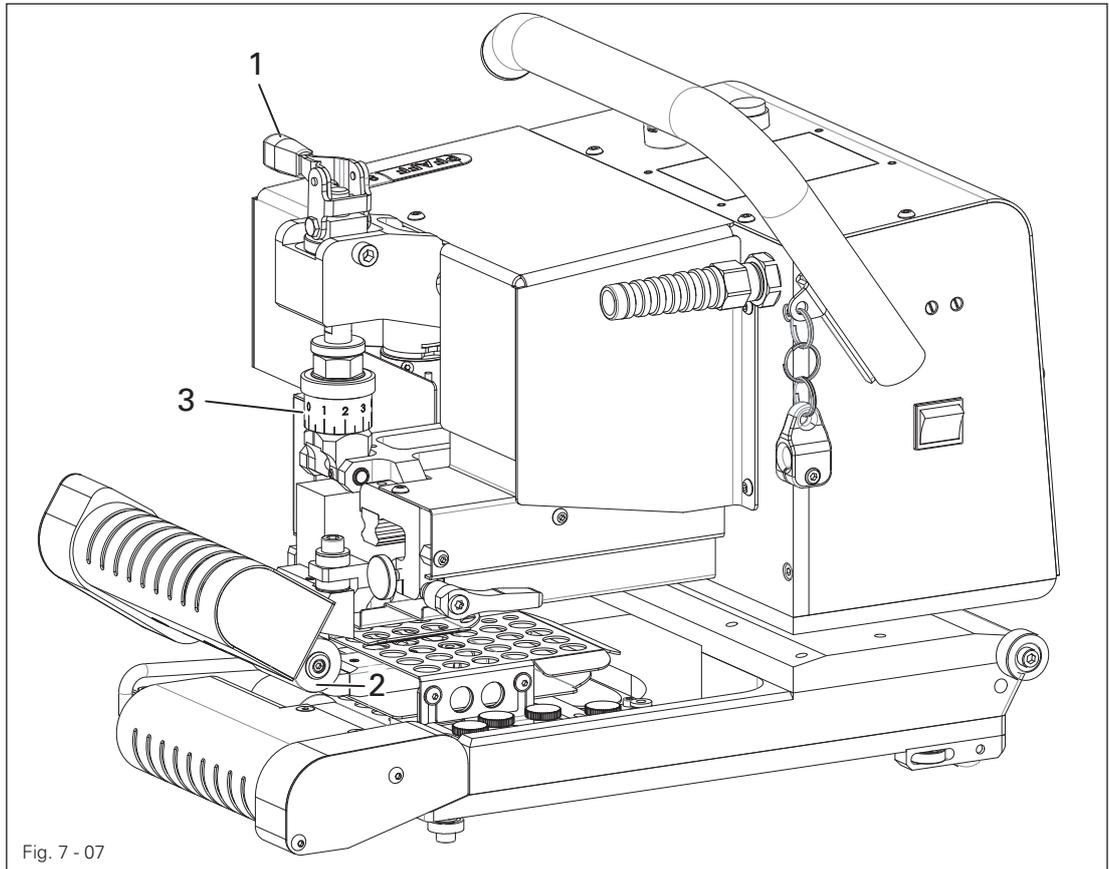


**Note!**  
The SD card must be formatted for FAT32.

## 7.07 Roller lever / roller force

The roller lever **1** is used to raise and lower the top feed roller **2**.

The force of the closed rollers is set with the roller force adjusting screw **3** and can be read on the display. It is continuously measured by the system and can be used as a criterion for the sealing start, sealing stop or sealing quality.

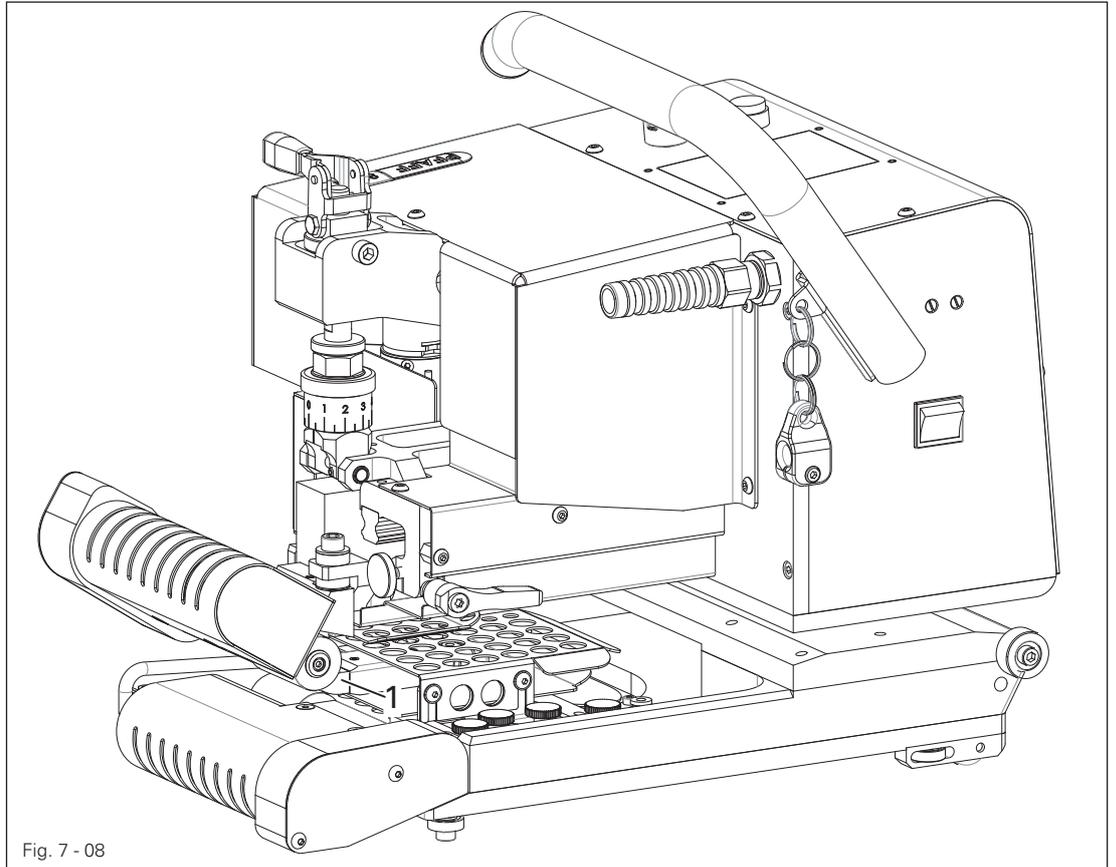


### Note!

The machine software prevents the sealing process starting when the rollers are open. Opening of the rollers in sealing mode (with the wedge engaged) is not permitted and can damage the machine.

## 7.07 Wedge position

The hot wedge 1 of the 8362i is moved to the sealing position and standby position by two electric motors. The sealing positions are determined by adjustable mechanical stops. The motors hold the hot wedge in the end positions with a defined force.



## 8 Initial Commissioning

Check the machine for transport damage after unpacking it. Please notify the carrier and the relevant PFAFF agency in the event of any damage.



The machine may only be started up by qualified personnel! All of the relevant safety regulations must always be complied with in this process!

### 8.01 Connecting the machine

- Clean the machine thoroughly before the initial commissioning, see also **chapter 13 Maintenance and Care**.
- Inspect the machine, particularly the electric cable, for any damage.
- Arrange for technical staff to check whether the machine may be operated at the existing mains voltage, see **chapter 3 Technical Data**.



Do **not** operate the machine if there are any differences!



The machine must only be connected to a grounded socket!

The socket must be fused with a residual current circuit breaker (RCD)

- Connect the mains plug of the connection cable to the electricity mains.

### 8.02 Switching the machine on / off

- Switch on the machine, see **chapter 7.02 Mains switch**.



One of the three push-buttons (rotary push-button, start push-button or push-button of the handlebar) must be pressed after switching on the machine to protect it against unintentional start-up



Danger of burns from the hot wedge!

The hot wedge is still hot immediately after the machine is switched off!

9

Set-up



Observe and comply with all regulations and instructions in this instruction manual. Pay particular attention to all safety regulations!



All set-up work may only be carried out by appropriately instructed personnel! Disconnect the machine from the electricity mains for all set-up work by removing the mains plug!



Always let the machine cool down before all set-up work!  
Danger of burning!

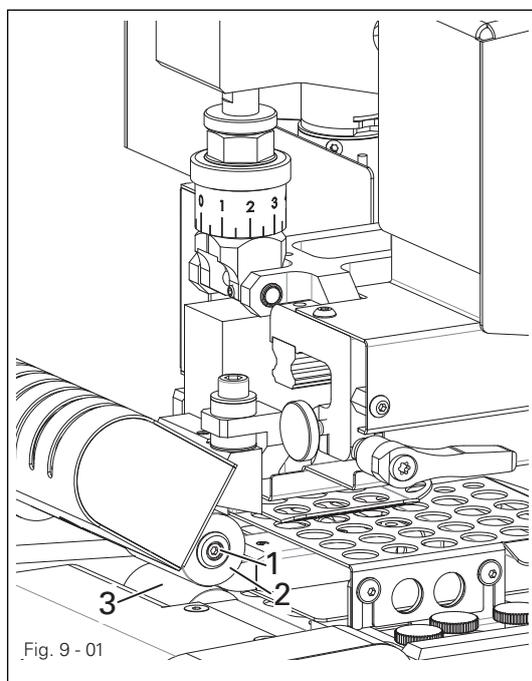
9.01

Replacing the feed rollers

The feed rollers must be replaced depending on the material and the thickness of the foil and the desired seam type.

The following table serves as a guide:

Foil material	Foil thickness	Bottom feed roller	Top feed roller
PVC (soft)	> 0.8 mm	Cross-knurled steel	Silicone
PE-LD	< 0.8 mm	Cross-knurled steel	Silicone
PE-LD	> 0.8 mm	Cross-knurled steel	Cross-knurled steel
PE-HD	< 0.8 mm	Cross-knurled steel	Silicone
PE-HD	> 0.8 mm	Cross-knurled steel	Cross-knurled steel



If necessary:

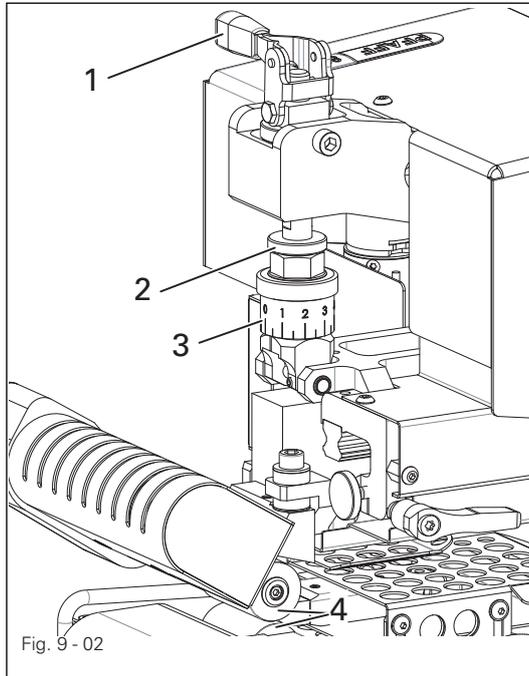
- Unscrew the screw 1.
- Replace the top feed roller 2 according to the seam type and the table above.
- Tighten the screw 1.

If necessary:

- Unscrew the retaining screw of the bottom feed roller 3.
- Replace the bottom feed roller 3 according to the seam type.
- Tighten the retaining screw.

## 9.02 Adjusting the roller pressure

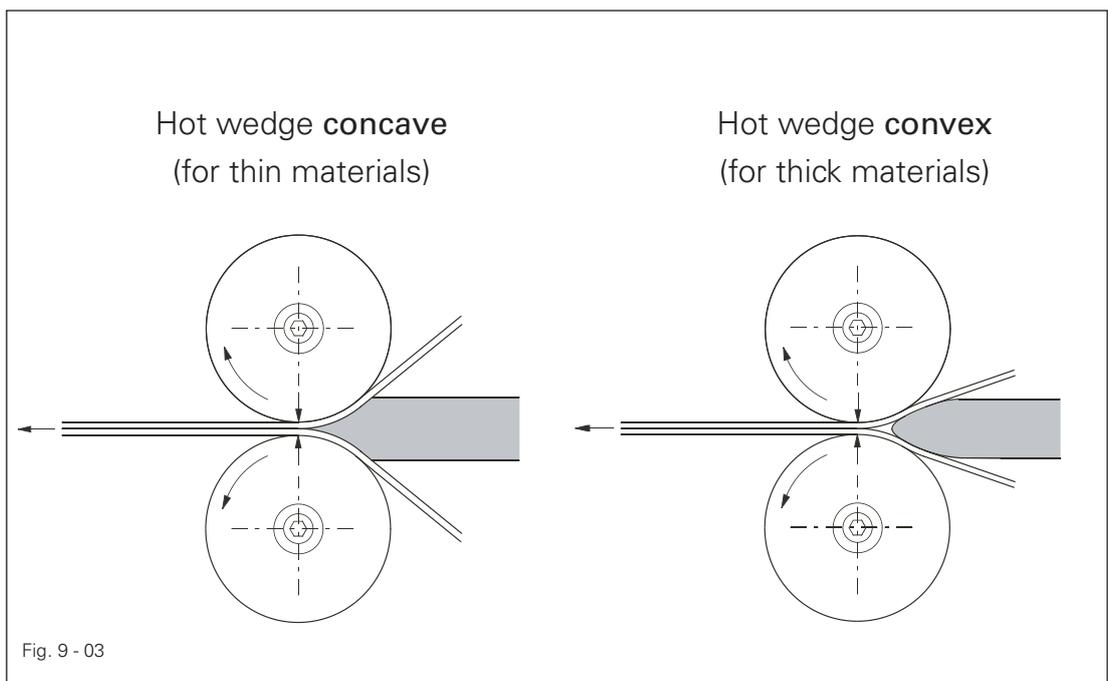
The mechanically adjusted roller force is constantly measured with a measuring device and compared with an adjustable setpoint. Two programmable thresholds can be used to prevent the start of the sealing or generate an error message in the event of a deviation.



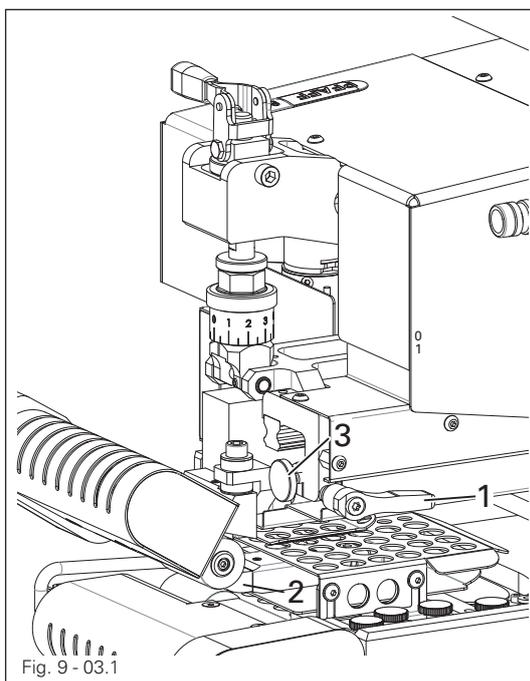
- Raise the roller lever 1.
- Loosen the knurled nut 2.
- Set the desired roller pressure by turning the scale 3.
- Place the material to be sealed between the feed rollers 4.
- Lower the roller lever 1.
- The desired roller force is shown on the display, see [chapter 10.01.02.03 Adjusting the target force](#) and, if necessary, adjusted by turning the scale 3.
- Tighten the knurled nut 1.

## 9.03 Adjusting the clearance between the hot wedge and the feed rollers

There should be a gap according to the material thickness between the hot wedge and the feed rollers when the hot wedge is engaged and the feed roller is lowered.



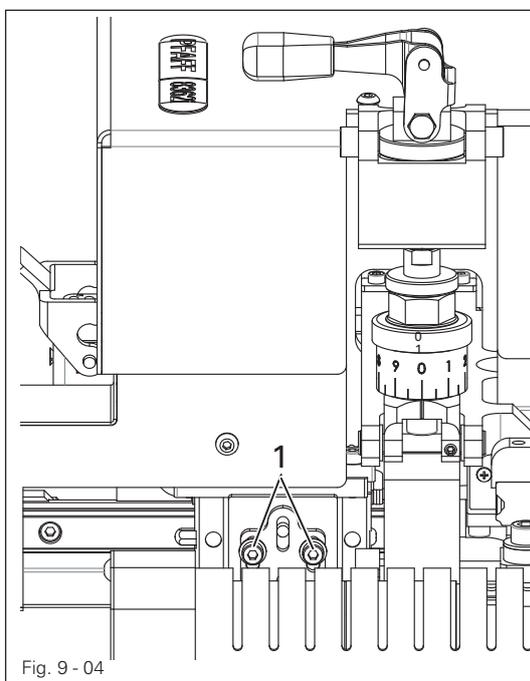
## 9.03.01 Adjusting the hot wedge clearance



Switch off the machine!  
 Wait until the hot wedge has cooled down!  
 Danger of burning!

- Loosen the clamp lever 1.
- Adjust the hot wedge 2 on the knurled thumb screw 3 according to the material thickness.
- Tighten the clamp lever 1.

## 9.04 Adjusting the height of the hot wedge



Switch off the machine!  
 Wait until the hot wedge has cooled down!  
 Danger of burning!

- Loosen the screws 1.
- Move the hot wedge centrally between the feed rollers.
- Tighten the screws 1.

## 9.05 Adjusting the workpiece guides



The workpiece guides are used to how far the workpieces should overlap in the seam zone.

The overlap width can be equal to or greater than the seam width.

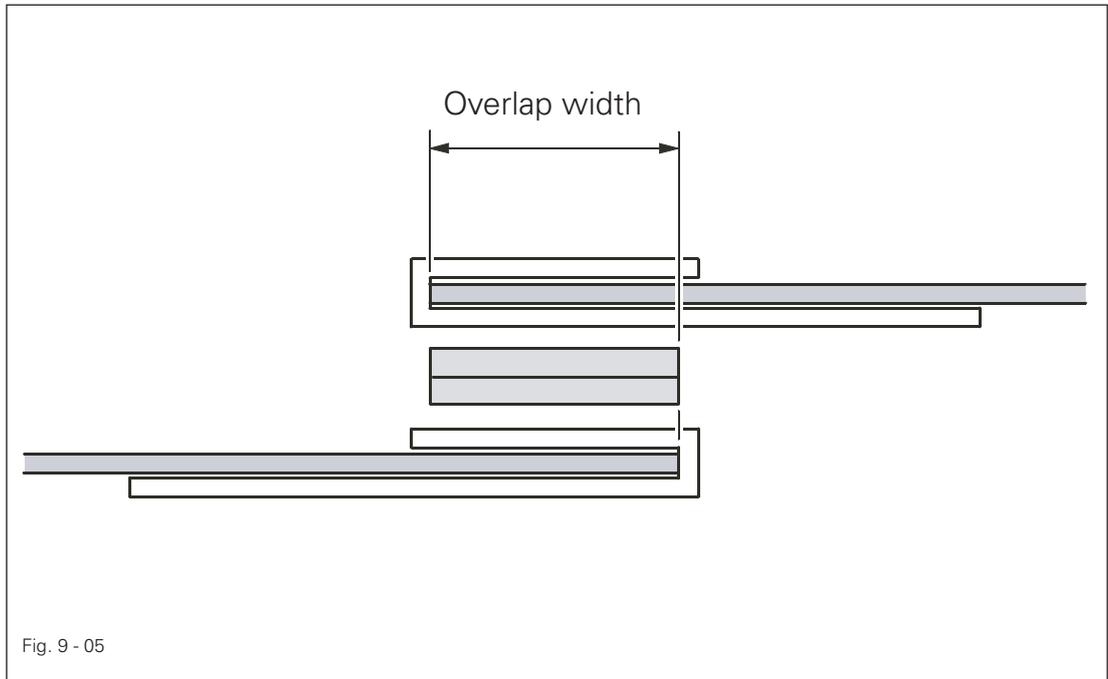


Fig. 9 - 05

### 9.05.01 Adjusting the top rear workpiece guide

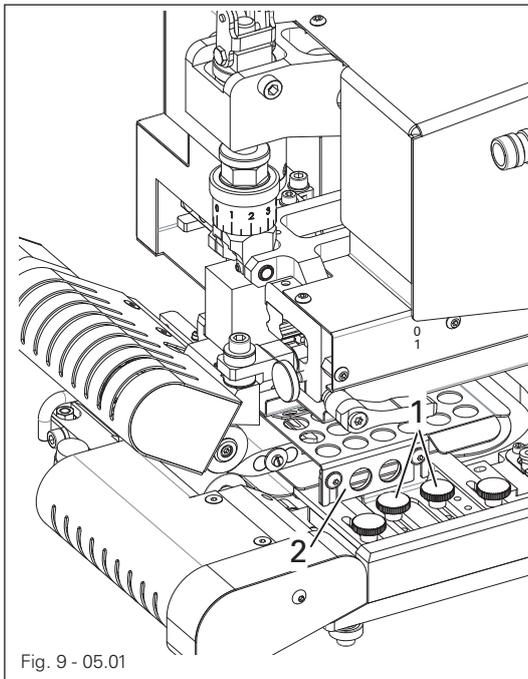


Fig. 9 - 05.01



Switch off the machine!

Wait until the hot wedge has cooled down!

Danger of burning!

- Loosen the knurled thumb screws 1.
- Adjust the workpiece guide 2 parallel to the sealing direction.
- Tighten the screws 1

## 9.05.02 Adjusting the top rear workpiece guide

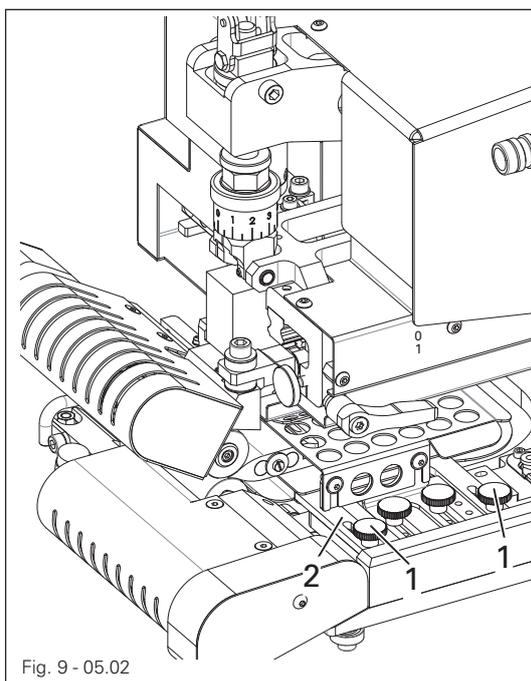


Fig. 9 - 05.02



Switch off the machine!  
 Wait until the hot wedge has cooled down!  
 Danger of burning!

- Loosen the knurled thumb screws 1.
- Adjust the workpiece guide 2 parallel to the sealing direction.
- Tighten the screws 1

## 9.05.03 Adjusting the front workpiece guides

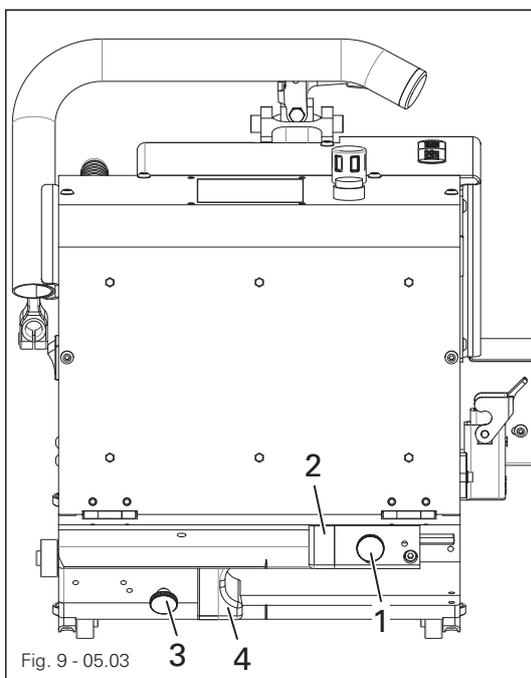


Fig. 9 - 05.03



Switch off the machine!

- Loosen the knurled thumb screw 1.
- Adjust the guide 2 so that it aligns with the top rear workpiece guide.
- Tighten the knurled thumb screw 1.
- Loosen the knurled thumb screw 3.
- Adjust the guide 4 so that it aligns with the top rear workpiece guide.
- Tighten the knurled thumb screw 3.

## 9.06 Adjusting the sealing temperature and sealing speed



All setting on the machine are always dependent on the workpiece being processed. The optimum sealing temperature and speed settings are determined by a test seam.

### 9.06.01 Adjusting the sealing temperature

See chapter 10.06.02.01 Temperature input.

### 9.06.02 Adjusting the sealing speed

See chapter 10.06.02.02 Roller speed / differential.

## Sealing



The machine may only be operated by properly instructed personnel!  
The operating personnel must make sure that only authorised persons are in the danger zone of the machine!

The 8362i has two separate speed-controlled drive rollers, an electronic force measuring device to determine the roller force and a motorised wedge positioning arm. 9 sealing parameter sets for different materials and different sealing processes can be defined and called up in the control unit. They are stored in a memory with power loss protection and can also be saved on an inserted SD card and read back from an SD card.

An adjustable protocol function can be used to save the relevant parameters of each seam on an inserted SD card for analysis at a later stage.

The standard sealing modes are as follows:

- Sealing start and sealing stop with start push-button or push-button of the handlebar.
- Sealing of a programmable distance ((with an adjustable follow-up movement).
- Sealing with recognition of the material edge through the roller force (with an adjustable follow-up movement).
- Automatic return to the starting point of the last seam

### 10.01

## Sealing principle

The two webs to be connected to each other are turned into a viscous state by applying heat in the seam zone. This is done when the material comes into mechanical contact with an electrically heated hot wedge. The heated viscous material is pressed together in the seam zone and thus sealed. The webs are pressed together and transported by feed rollers to form the seam.

Certain conditions relating to the material and machine settings have to be fulfilled to achieve an optimum seam:

The material to be processed must be

- Sealable (thermoplastic),
- Suitable for processing with the machine in terms of thickness and properties and
- Clean in the seam zone.

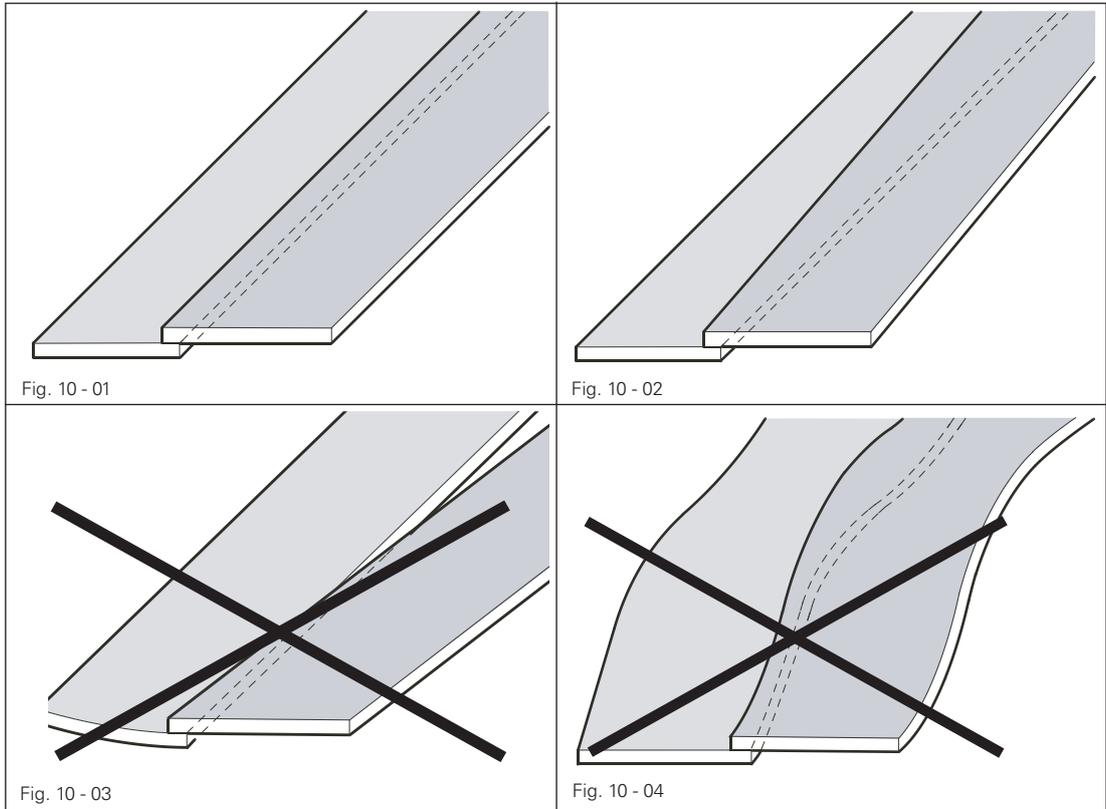
The following basic conditions apply depending on the sealing machine:

- Shape and position of the hot wedge,
- Correct working temperature of the workpiece,
- Selection of the suitable feed rollers,
- Optimum feed roller pressure on the workpiece,
- Correct spacing of the feed rollers from one another (penetration depth) and
- Correct sealing speed.



All settings on the sealing machine are always dependent on the type of material being sealed. The optimum settings must be determined by sealing tests. All settings required for the sealing process are shown on the display.

## 10.02 Aligning the webs

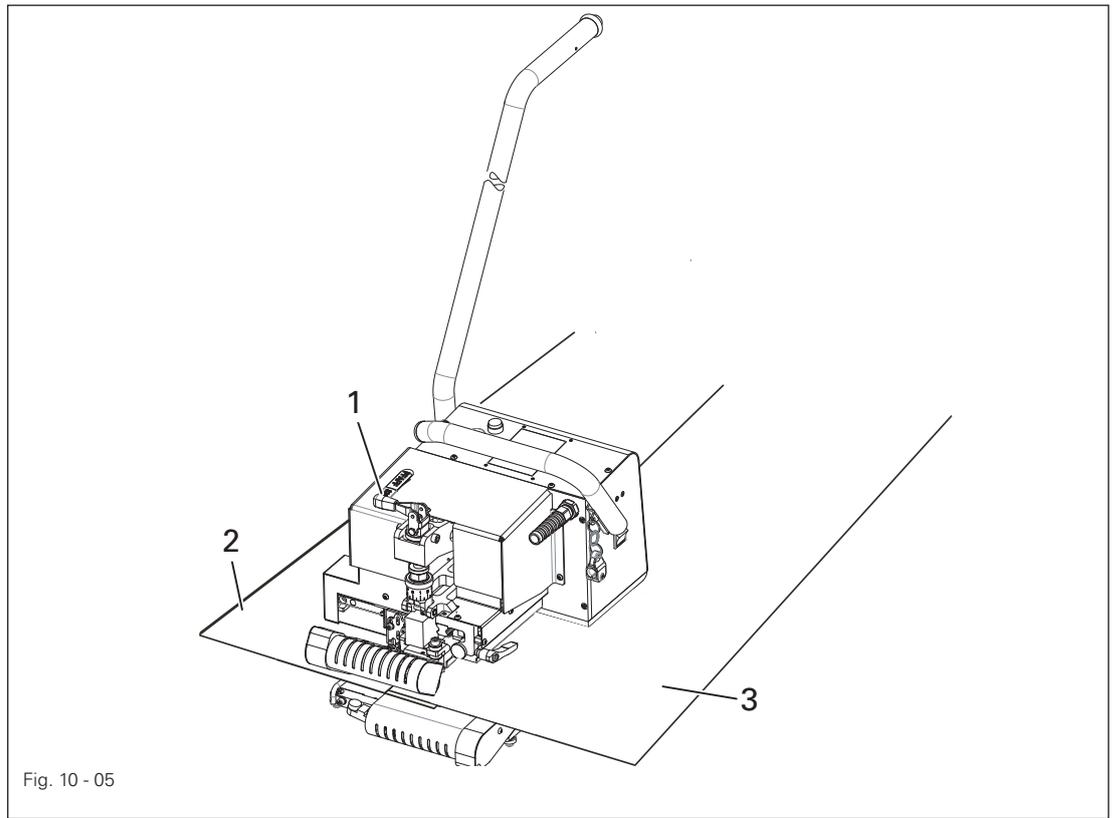


When aligning the webs on the working platform it is important to note that they should overlap each other slightly more than the set overlap value (see Fig. 10-01 and Fig. 10-02). When the webs enter the sealing machine, the workpiece guides place them at the right distance.



Webs that are too far apart or too uneven (see Fig. 10-03 and Fig. 10-04) cannot be joined properly by the workpiece guides and therefore not correctly sealed.

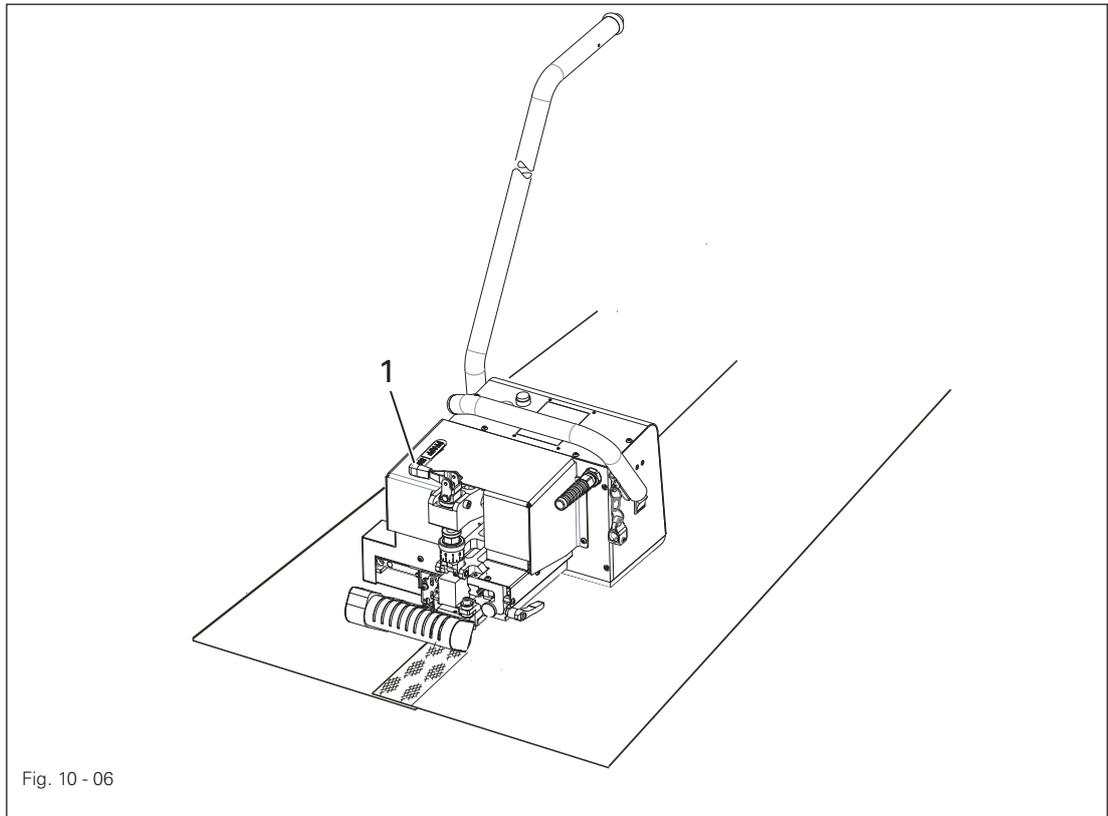
## 10.03 Inserting the webs



- Raise the top feed roller with the lever 1.
- Slide the bottom workpiece 2 into the bottom workpiece guide until it stops.
- Slide the top workpiece 3 into the top workpiece guide until it stops.
- Guide the start of the workpiece being sealed between the feed rollers.

## 10.04 Sealing the webs

### 10.04.01 Guiding the machine by hand or with the handlebar



- Switch the machine on, see **chapter 8.01 Connecting the machine.**
- Switch the machine on, see **chapter 7.02 Mains switch.**



One of the three push-buttons (rotary push-button, start push-button or push-button of the handlebar) must be pressed after switching on the machine to protect it against unintentional start-up

- 
- Adjust the sealing temperature, see **chapter 10.06.02.01 Temperature input**
- Adjust the sealing speed, see **chapter 10.06.02.02 Roller speed / differential.**

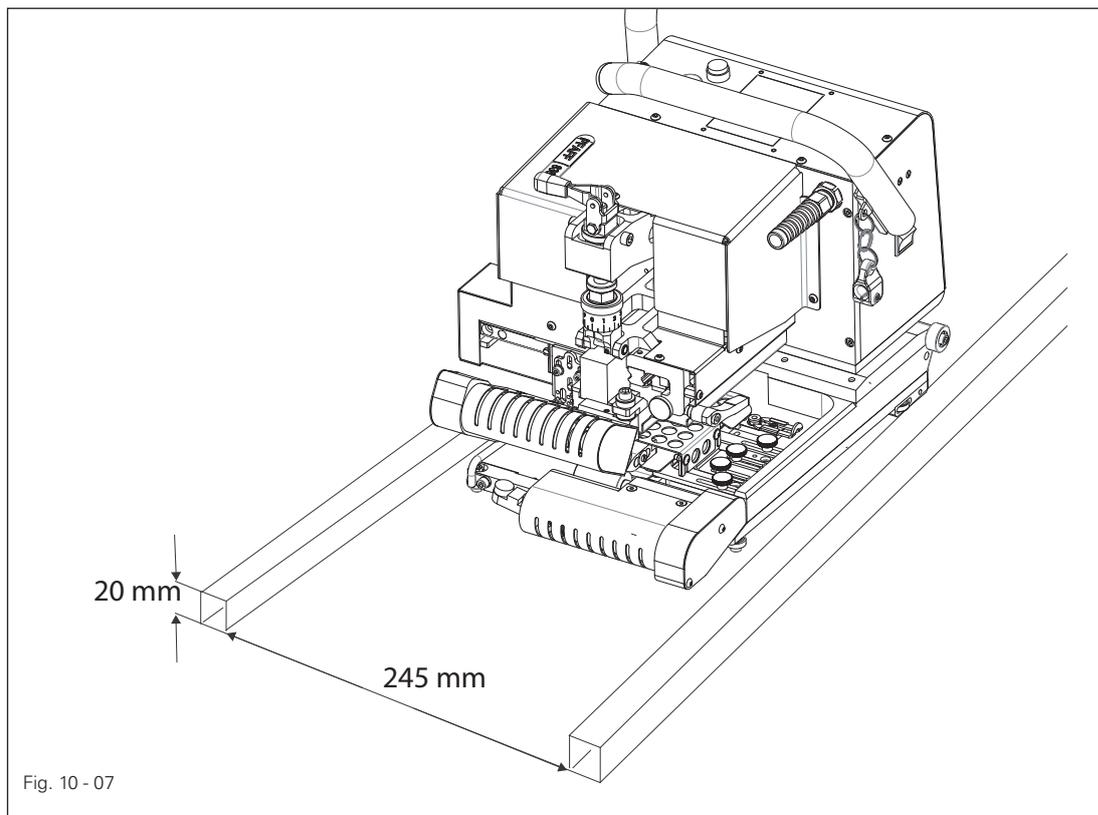


The following steps should be performed in quick succession after reaching the pre-set sealing temperature in order to avoid damage to the workpiece.

- Align and insert the webs according to the preceding chapters.
- Lower the feed roller with the lever 1.
- Start the sealing process with the start push-button or push-button of the handlebar, see **chapter 10.01.02.01 Starting / stopping the sealing process.**

## 10.04.02 Sealing in a guide

Battens, square tubes etc. can be used to make a guide.



## 10.05 Stopping the machine

- End the sealing process with the start push-button or push-button of the handlebar, see chapter 10.06.02.08 Starting the sealing process.
- Raise the feed roller, see chapter 7.07 Roller lever / roller force.
- Switch the machine off at the mains switch, see chapter 7.02 Mains switch.
- Pull out the mains plug and let the machine cool down.

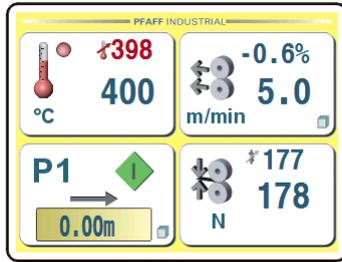


Danger of burns from the hot wedge!

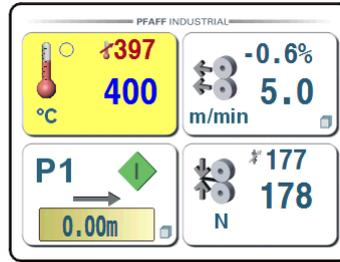
The hot wedge is still hot immediately after the machine is switched off!

## 10.06 Production

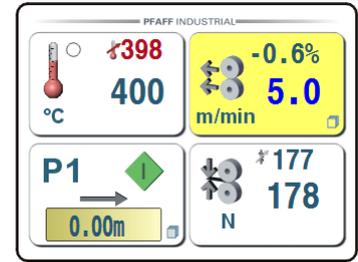
### 10.06.01 Overview



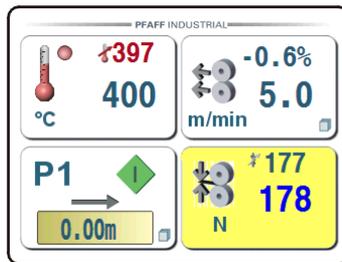
Production



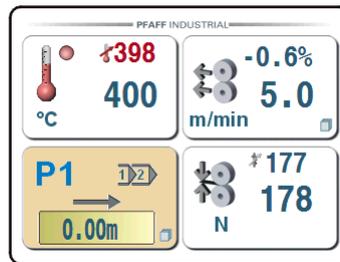
Selection of temperature



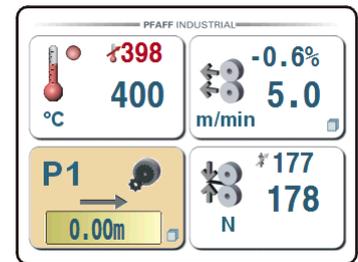
Selection of roller speed



Selection of target force



Selection of P1..P9



Selection of input



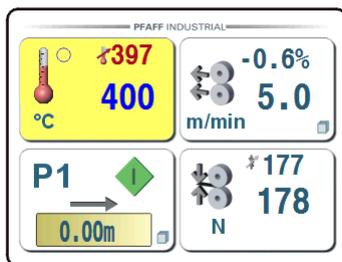
Turning the rotary push-button in a clockwise direction selects the functions in the top sequence.



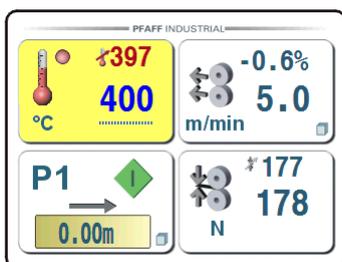
Turning the rotary push-button in an anti-clockwise direction selects the functions in the reverse order.

### 10.06.02 Functions in production

#### 10.06.02.01 Temperature input:



Press the rotary push-button once briefly to accept the selection (ENTER). The selected parameter is underlined.





Target temperature input: e.g. 400 °C.



Now the parameter can be increased by turning the rotary push-button. (Increase the target temperature up to 500 °C).



Now the parameter can be decreased by turning the rotary push-button. (Reduce the target temperature to 20 °C).



Pressing and holding the rotary push-button once (CLEAR) sets the parameter to its minimum value. (Target temperature of 20 °C).



Pressing the rotary push-button twice briefly (ESC) sets the parameter to its maximum value. (Target temperature of 500 °C)



The modified parameter is accepted by again pressing the rotary push-button once briefly (ENTER). The modified parameter is no longer underlined; now the parameter is not modified by turning the rotary push-button but instead a new parameter selection is performed.



Display of the current actual temperature.



Heating regulator indicator ON/OFF/SWITCHED OFF



A flashing thermometer symbol shows that the actual hot wedge temperature is still outside the adjustable start window (usually the setpoint +/- 10°) and therefore the sealing start is locked.

### Note!

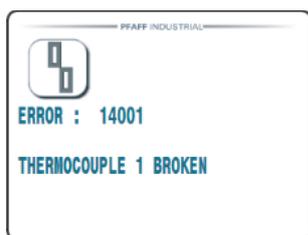


After accepting the selection, press the rotary push-button once briefly (ENTER) to switch off the heating regulator at a target temperature of 20 °C and to switch on the heating regulator at a target temperature of 21 °C .. 500°C.

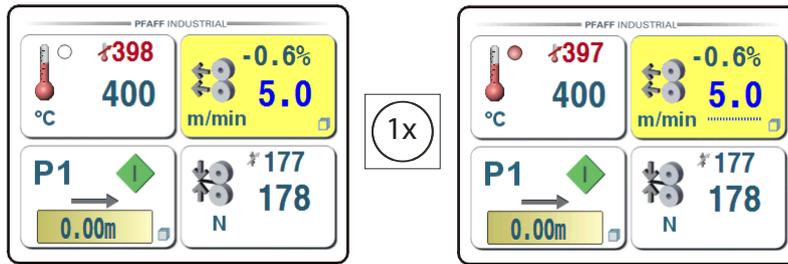


A defective temperature sensor is indicated with an actual temperature of 999 °C.

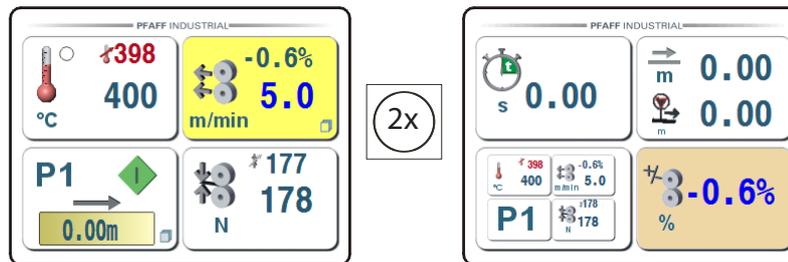
The following error message appears if the heating regulator is switched on:



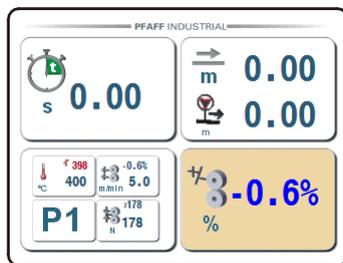
## 10.06.02.02 Roller speed / differential input



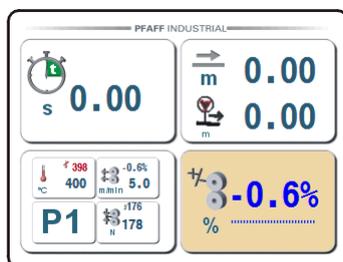
1x Press the rotary push-button once briefly to accept the selection (ENTER).  
The selected parameter "Roller speed" is underlined.



2x Press the rotary push-button twice briefly (ESC) to accept the selection.  
The selected parameter "Roller differential" is displayed.



1x Press the rotary push-button once briefly to accept the selection (ENTER).  
The selected parameter "Roller differential" is underlined.



Roller speed input: e.g. 5.0 m/min

**5.0**



Now the parameter can be increased by turning the rotary push-button. (Increase the speed to 10.0 m/min).



Now the parameter can be decreased by turning the rotary push-button. (Reduce the speed to **0.5 m/min**).



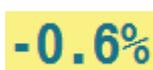
Pressing and holding the rotary push-button once (CLEAR) sets the parameter to its minimum value (speed **0.5 m/min**).



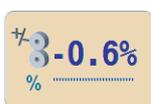
Pressing the rotary push-button twice briefly (ESC) sets the parameter to its maximum value (speed **10.0 m/min**).



The modified parameter is accepted by again pressing the rotary push-button once briefly (ENTER). The modified parameter is no longer underlined; now the parameter is not modified by turning the rotary push-button but instead a new parameter selection is performed.



Display of the current roller differential set



Roller differential input: e.g. **0.6%**.



Now the parameter can be increased by turning the rotary push-button. (Increase the differential up to **+9.9%**).



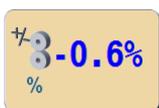
Now the parameter can be decreased by turning the rotary push-button. (Reduce the differential to **-9.9%**).



or



Pressing and holding the rotary push-button once (CLEAR) or pressing the rotary push-button twice briefly (ESC) sets the parameter to its minimum value. (Differential **0.0%**).

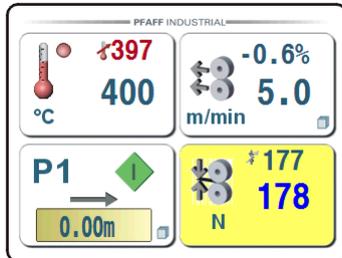


The modified parameter is accepted by again pressing the rotary push-button once briefly (ENTER). The modified parameter is no longer underlined; now the parameter is not modified by turning the rotary push-button but instead a new parameter selection is performed.

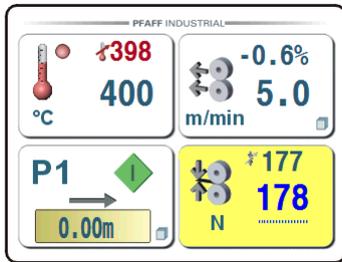
## 10.06.02.03 Adjusting the target force

The mechanically adjusted roller force is constantly measured with a measuring device and compared with an adjustable setpoint. Two programmable thresholds can be used to prevent the start of the sealing or generate an error message in the event of a deviation.

The force profile can subsequently be analysed using a protocol file when an SD card is inserted.



Press the rotary push-button once briefly to accept the selection (ENTER). The selected parameter "Target force" is underlined.



Target force input: e.g. 178 N.



Now the parameter can be increased by turning the rotary push-button. (Increase the target force to 500 N).



Now the parameter can be decreased by turning the rotary push-button. (Reduce the target force to 0 N).



Pressing and holding the rotary push-button once (CLEAR) sets the parameter to its minimum value (target force 0 N).



Pressing the rotary push-button twice briefly (ESC) sets the parameter to its maximum value. (Target force of 500 N).



The modified parameter is accepted by again pressing the rotary push-button once briefly (ENTER). The modified parameter is no longer underlined; now the parameter is not modified by turning the rotary push-button but instead a new parameter selection is performed.



Display of the current roller force.



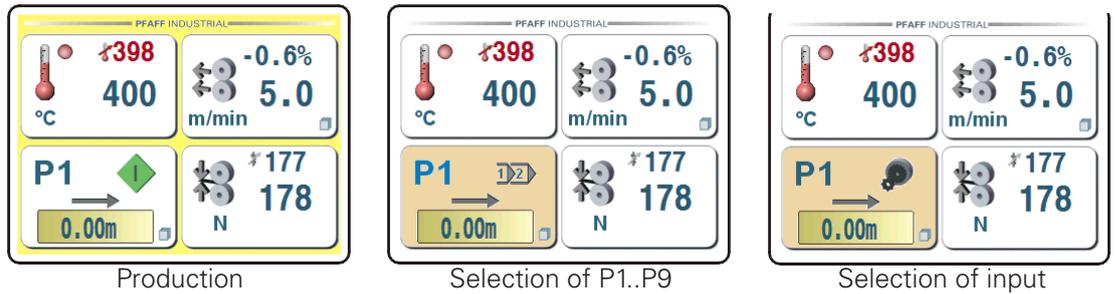
A flashing roller symbol shows that the roller force is outside the adjustable start window (usually the setpoint +/- 20 N) and therefore the sealing start is locked.

When the start window is set to +/- 0 N (see Settings/adjusting the roller force start window), the start window function of the roller force measurement is switched off.



If the zero point of the roller force measurement has not yet been set (e.g. after the initial power up of the machine or after a reset to the factory settings), a roller force of 999 N is displayed. This means that sealing is prohibited.

10.06.02.04 Combination field to display the operating status, selection of P1..P9 and selection of input



10.06.02.05 Displays during the sealing process

The operating status of the 8362i is displayed in the field at the bottom left. Indicators for the various operating statuses are:

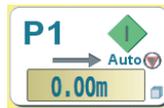
**At the seam start:**

Distance 0.00 m,  
Distance arrow is on the left-hand side,

Start symbol



Start /stop with push-button



Start with push-button  
Stop with force analysis (or push-button)



Start with push-button  
Stop after distance (or push-button)



Start with push-button  
Stop after distance or force analysis (or push-button)

**During the sealing process:**

Distance continues to be counted, distance arrow moves to the right,

Stop symbol



Stop with push-button



Stop with force analysis (or push-button)



Stop after distance (or push-button)

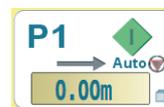


Stop after distance or force analysis (or push-button)

**After stopping with:**



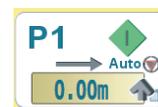
(Distance length not equal to 0, also with the distance



(Distance length = 0)



(Distance length = 0  
Distance arrow at the end)



(distance, distance arrow at the end)



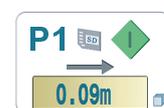
(force, distance arrow not at the end)



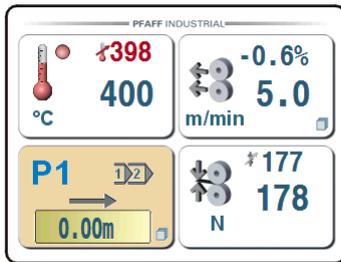
Automatic return motion to the seam start (Home: activated by pressing the start push-button/push-button of the handlebar twice briefly).



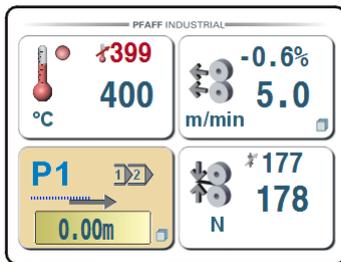
erted



## 10.06.02.06 Selecting parameters P1..P9



Press the rotary push-button once briefly to accept the selection (ENTER). The selected parameter "P1..P9" is underlined.



Input: e.g. P1.



Now the parameter can be selected by turning the rotary push-button in a clockwise direction. (P1..P2.....P9).



Now the parameter can be selected by turning the rotary push-button in an anti-clockwise direction. (P9..P8.....P1).

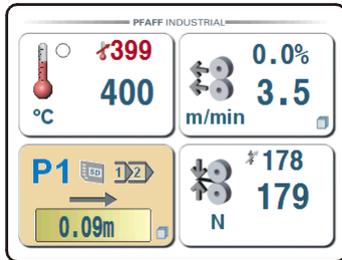


The modified parameter is accepted by again pressing the rotary push-button once briefly (ENTER). The modified parameter is no longer underlined; now the parameter is not modified by turning the rotary push-button but instead a new parameter selection is performed.

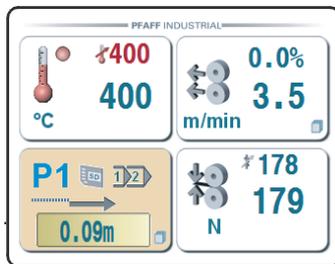
10.06.02.07 Savings parameters P1..P9 on an SD card or loading them from an SD card

Note:

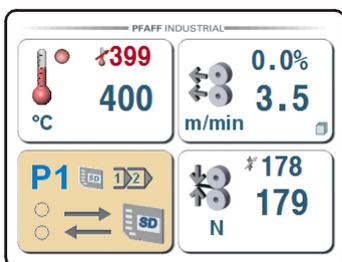
An SD card must be inserted for this function



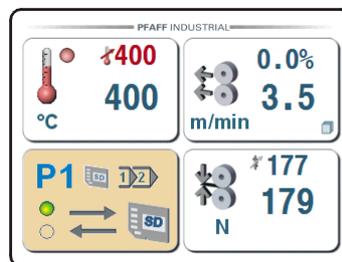
- 1x Press the rotary push-button once briefly to accept the selection (ENTER). The selected parameter "P1..P9" is underlined.



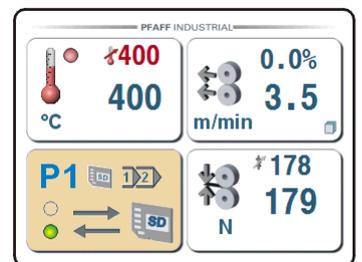
- C Press and hold the rotary push-button once (CLEAR) directly from the selection of P1..P9 or via input P1..P9 in the next menu.



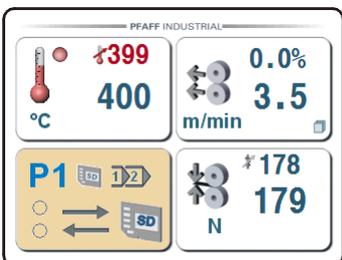
No selection



Selection of save P1..P9



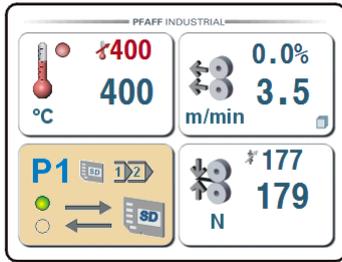
Selection of load P1..P9



- ↻ Now the parameter can be selected by turning the rotary push-button in a clockwise direction. (Select save P1..P9).

- ↻ Now the parameter can be selected by turning the rotary push-button in an anti-clockwise direction. (Select load P1..P9).

- 1x
- 2x
- C Press the rotary push-button once briefly (ENTER) or press the rotary push-button twice briefly (ESC) or press and hold the rotary push-button once (CLEAR) to return to the input P1...P9.



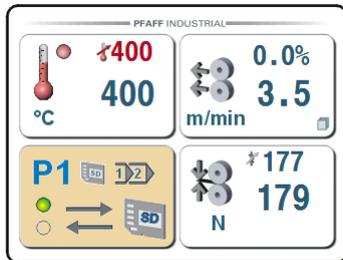
Now the parameter can be selected by turning the rotary push-button in a clockwise direction. (Select load P1..P9).



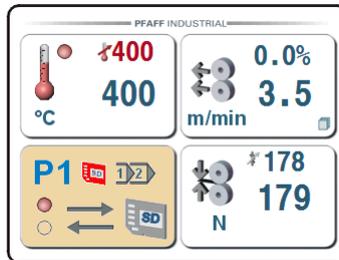
No selection



Press the rotary push-button once briefly (ENTER) to save P1...P9 on an SD card.



No errors



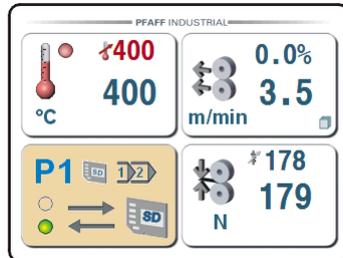
SD card write error



or



Press the rotary push-button twice briefly (ESC) or press and hold the rotary push-button once (CLEAR) to return to the input P1..P9.



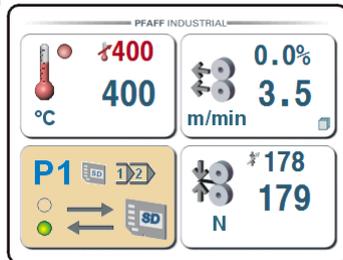
No selection



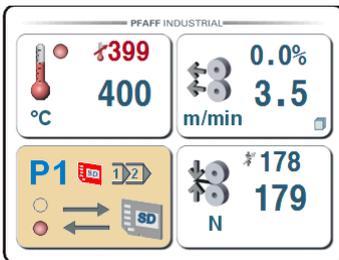
Now the parameter can be selected by turning the rotary push-button in an anti-clockwise direction. (Select save P1..P9).



Press the rotary push-button once briefly (ENTER) to load P1..P9 from an SD card.



No errors



SD card read error



or

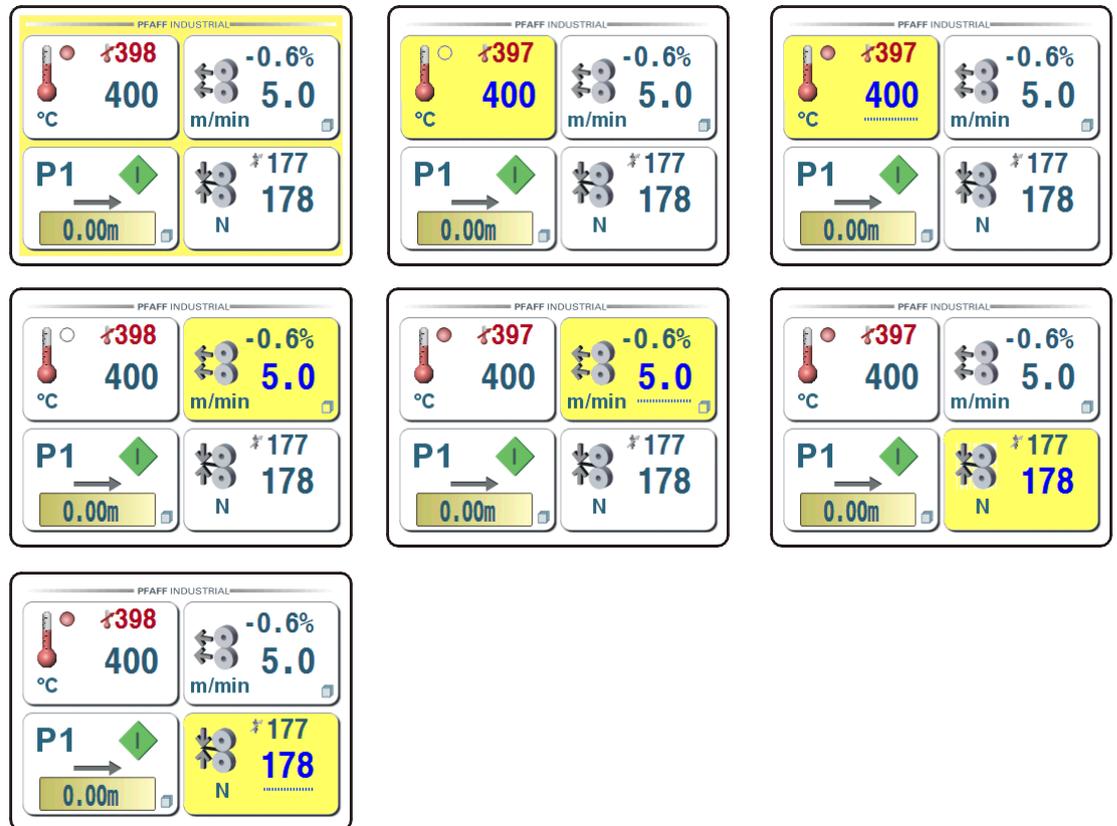


Press the rotary push-button twice briefly (ESC) or press and hold the rotary push-button once (CLEAR) to return to the input P1...P9.

You can find the files as binary files with the file names P1, P1 ... in folder P8362 on the SD card. P9 without an extension.

10.06.02.08 Starting the sealing process

The sealing process can be started with the start push-button or the push-button of the handlebar in all windows with a yellow frame or yellow selection. The actual temperature and roller force must be within the start window in order to do this.



Press the start push-button or push-button of the handlebar once briefly to start the sealing process.



The wedge is engaged and the rollers start. The sealing distance is incremented in the window at the bottom left.



The start symbol  switches to a stop symbol .



Press the start push-button or push-button of the handlebar once briefly to interrupt the sealing process at any time. The hot wedge is disengaged and the machine can continue to run for an adjustable distance and then turn back again for an adjustable distance.



Press the start push-button or push-button of the handlebar once briefly to continue the sealing process again.

The sealing process is ended if the rollers are opened when they stop. The sealing distance display is reset to 0.00 m and the piece counter is incremented.



or



Press and hold the start push-button or push-button of the handlebar once or press and hold the rotary push-button once (CLEAR) to end a stopped sealing process also without opening the rollers. The sealing distance display is reset to 0.00 m and the piece counter is incremented.

The machine can automatically recognise the end of the workpiece **Auto** without activating the force analysis. The hot wedge disengages and the machine can continue to run on for an adjustable distance. The sealing distance display is reset to 0.00 m and the piece counter is incremented.

Alternatively, a fixed sealing distance can be predefined. The machine seals the set distance, then disengages the hot wedge and continues to run for another adjustable distance. The sealing distance display is reset to 0.00 m and the piece counter is incremented.

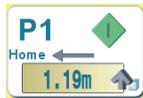
**Note:**

The force analysis and programmable distance can be combined.

An automatic return motion to the seam start can be activated after a sealing process is ended.



(Home: activated by pressing the start push-button or push-button of the handlebar twice briefly.



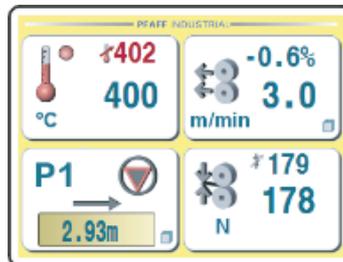
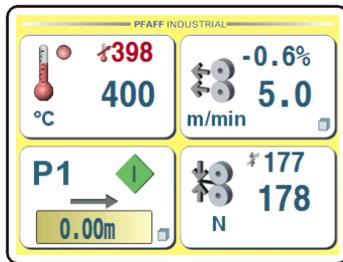
**Note:**



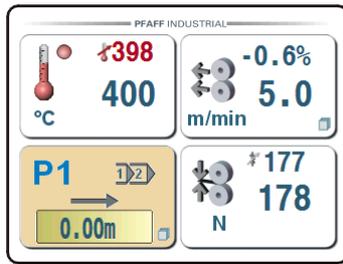
or



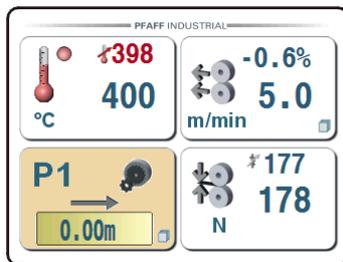
The sealing process can be started or stopped in these windows by pressing the start push-button or push-button of the handlebar once briefly or by pressing the rotary push-button once briefly (ENTER).



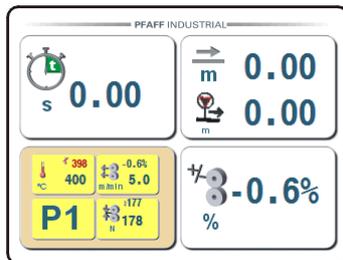
10.06.02.09 Selecting an input



Now the parameter can be selected by turning the rotary push-button in a clockwise direction. (**Input** selection).

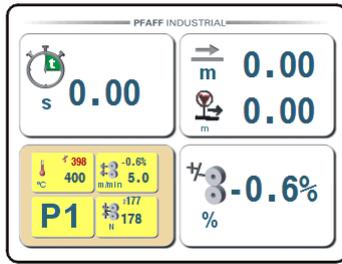


Press the rotary push-button once briefly (ENTER) to open the "Input" menu.



See chapter 11 Input.

## 11 Input



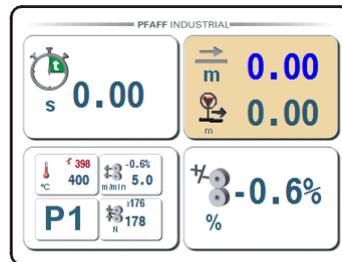
Press the rotary push-button once briefly (ENTER) to return to the "Production" menu, see chapter 10.06 Production.

## 11.01 Overview

Other sealing parameters for the parameter sets P1 .. P9 are entered under input. In addition, information can be called up and functions can be performed that require now special authorisations.



Selection of start delay



Selection of sealing length



Selection of follow-up movement after end of sealing length



Selection of differential



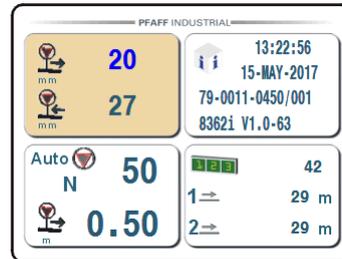
Selection of follow-up movement after autostop



Selection of autostop force



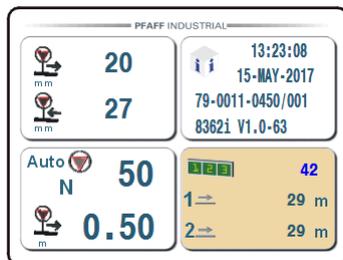
Selection of reverse rotation after stop with push-button



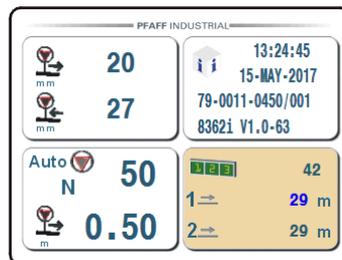
Selection of follow-up movement after stop with push-button



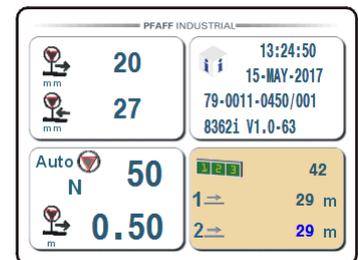
Info set display



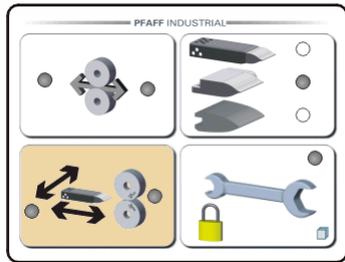
Selection of delete daily piece counter



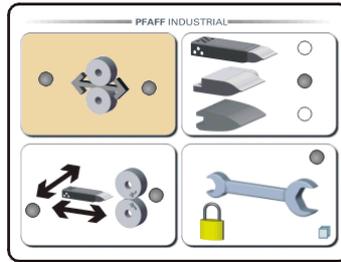
Selection of delete sealing length 1



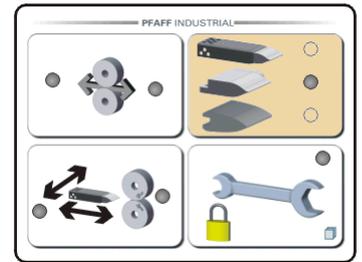
Selection of delete sealing length 2 (only with authorisation)



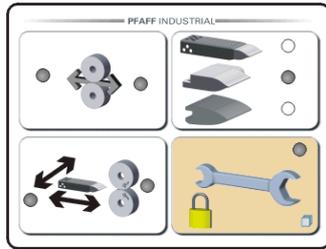
Selection of grind hot wedge



Selection of rotate rollers  
(test function)



Selection of hot wedge



Selection of settings  
(only with authorisation)



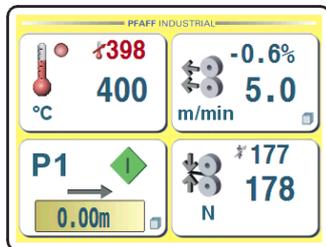
Turning the rotary push-button in a clockwise direction selects the functions in the top sequence (see pages 46 to 47).



Turning the rotary push-button in an anti-clockwise direction selects the functions in the reverse order (see pages 46 to 47).



Briefly press the rotary push-button twice (ESC) to jump to production immediately.



## 11.02 Start delay

The start delay controls the start of the rollers relative to the engaging of the hot wedge. The start delay can accept positive and negative values.

### Positive start delay (or = 0):

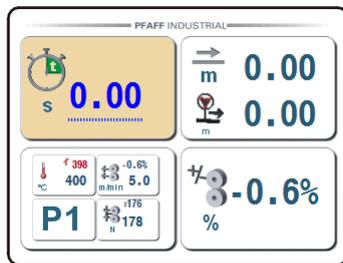
The hot wedge engages completely after a start with . Then the set time is started and the rollers are only started when this time elapses.

### Negative start delay:

The set time is started and the hot wedge is engaged at the same time after a start with . The rollers are started after the time elapses regardless of whether or not the hot wedge is completely engaged.



-  Press the rotary push-button once briefly to accept the selection (ENTER). The selected parameter "**Start delay**" is underlined.



Start delay input:

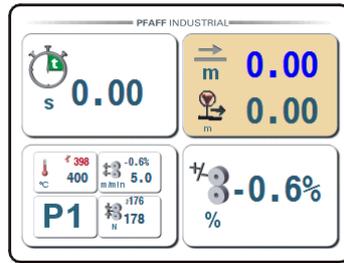
-  Now the parameter can be increased by turning the rotary push-button. (Increment the start delay up to + 3.00).

-  Now the parameter can be decreased by turning the rotary push-button. (Decrement the start delay down to - 3.00).

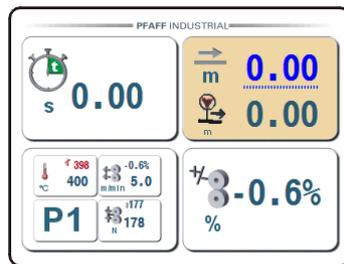
-  or  Press the rotary push-button twice briefly (ESC) or press and hold the rotary push-button once (CLEAR) to set start delay to 0.00.

-  The modified parameter is accepted by again pressing the rotary push-button once briefly (ENTER). The modified parameter is no longer underlined; now the parameter is not modified by turning the rotary push-button but instead a new parameter selection is performed.

11.03 Distance / follow-up movement after distance



- 1x Press the rotary push-button once briefly to accept the selection (ENTER). The selected parameter "Distance" is underlined.



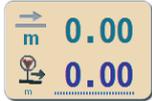
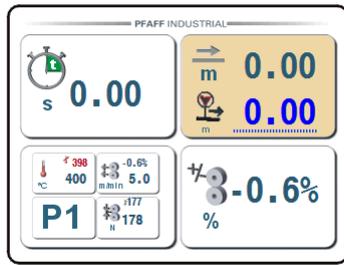
Distance input:

- Now the parameter can be increased by turning the rotary push-button. (Increment distance to +99.99 m).
- Now the parameter can be decreased by turning the rotary push-button. (Decrement distance to 0.00 m).
- 2x Press the rotary push-button twice briefly (ESC) to increment the distance to 5.00 m.
- C Press and hold the rotary push-button once (CLEAR) to set the distance to 0.00 m (function switched off).
- 1x The modified parameter is accepted by again pressing the rotary push-button once briefly (ENTER). The modified parameter is no longer underlined; now the parameter is not modified by turning the rotary push-button but instead a new parameter selection is performed

The follow-up movement after the distance is how long the machine continues to run after sealing the distance with the wedge disengaged.



- 1x Press the rotary push-button once briefly to accept the selection (ENTER). The selected parameter "Follow-up movement after distance" is underlined.



Follow-up movement after distance input:



Now the parameter can be increased by turning the rotary push-button. (Increment the follow-up movement up to **+5.00 m**).



Now the parameter can be decreased by turning the rotary push-button. (Decrement the follow-up movement to **0.00 m**).



Press the rotary push-button twice briefly (ESC) to set the follow-up movement to the maximum value of **5.00 m**.



Press and hold the rotary push-button once (CLEAR) to set the follow-up movement to **0.00 m**.



The modified parameter is accepted by again pressing the rotary push-button once briefly (ENTER). The modified parameter is no longer underlined; now the parameter is not modified by turning the rotary push-button but instead a new parameter selection is performed

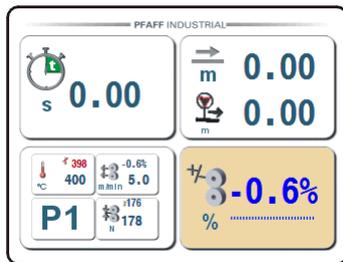
### Note:

If the function is switched off by entering a distance of 0.00 m, the follow-up movement value entered is ignored.

11.04 Roller differential



Press the rotary push-button once briefly to accept the selection (ENTER). The selected parameter "Roller differential" is underlined.



Roller differential input: e.g. 0.6%.



Now the parameter can be increased by turning the rotary push-button. (Increase the differential up to +9.9%).



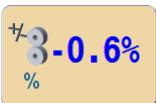
Now the parameter can be decreased by turning the rotary push-button. (Reduce the differential to -9.9%).



or



Pressing and holding the rotary push-button once (CLEAR) or pressing the rotary push-button twice briefly (ESC) sets the parameter to its minimum value of 0.0%.



The modified parameter is accepted by again pressing the rotary push-button once briefly (ENTER). The modified parameter is no longer underlined; now the parameter is not modified by turning the rotary push-button but instead a new parameter selection is performed.

**Note:**

The roller differential can also be selected directly from the roller speed window, see chapter 10.06.02.02 Roller speed / differential input.

## 11.05 Stop by force analysis (autostop) / follow-up movement after stop by force analysis (autostop)

The measurement of the roller force can be used to recognise the material edge.

A force threshold value that triggers the stop process is entered to activate this function. The hot wedge is disengaged if the roller force drops below values lower than the target roller force that has been set minus the threshold value. The machine then continues to run for the set follow-up movement and then stops.



Press the rotary push-button once briefly to accept the selection (ENTER). The selected parameter "**Force threshold value**" is underlined.



Force threshold value input: e.g. 50 N



Now the parameter can be increased by turning the rotary push-button. (Increment the force threshold value up to 200 N).



Now the parameter can be decreased by turning the rotary push-button. (Decrement the force threshold value to 0 N).



Press the rotary push-button twice briefly (ESC) to set the force threshold value to 200 N.



Press and hold the rotary push-button once (CLEAR) to set the force threshold value of 0 N (switch off the function).



The modified parameter is accepted by again pressing the rotary push-button once briefly (ENTER). The modified parameter is no longer underlined; now the parameter is not modified by turning the rotary push-button but instead a new parameter selection is performed



Press the rotary push-button once briefly to accept the selection (ENTER). The selected parameter "**Follow-up movement value**" is underlined.



Input of follow-up movement value: e.g. 0.50 m



Now the parameter can be increased by turning the rotary push-button. (Increment the follow-up movement value up to 5.00 m).



Now the parameter can be decreased by turning the rotary push-button. (Decrement the follow-up movement to 0.00 m) .



Press the rotary push-button twice briefly (ESC) to set the follow-up movement to the maximum value of 5.00 m.



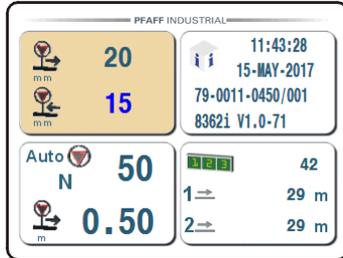
Press and hold the rotary push-button once (CLEAR) to set the follow-up movement to 0.00 m.



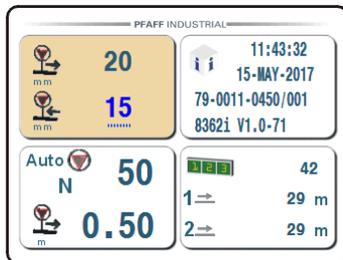
The modified parameter is accepted by again pressing the rotary push-button once briefly (ENTER). The modified parameter is no longer underlined; now the parameter is not modified by turning the rotary push-button but instead a new parameter selection is performed

## 11.06 Reverse rotation after a stop / follow-up movement after a stop

These functions are performed after a stop by pressing the  or  push-button. Both functions are switched off after entering a value of 0 and are activated by entering a distance of 1..99 mm. The hot wedge is disengaged and the trailer is started at the same time after a manual stop. At the end of the distance the rollers stop briefly and then move back the reverse rotation distance at a speed of 1.2 m/min.



Press the rotary push-button once briefly to accept the selection (ENTER). The selected parameter "**Reverse rotation after a stop**" is underlined.



Input of reverse rotation after stop: e.g. 15 mm



Now the parameter can be increased by turning the rotary push-button. (Increment the reverse rotation after a stop up to 99 mm).



Now the parameter can be decreased by turning the rotary push-button. (Decrement the reverse rotation after a stop to 0 mm).



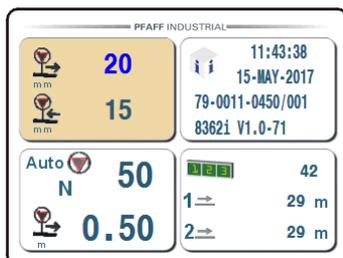
Press the rotary push-button twice briefly (ESC) to set the reverse rotation after a stop to 99 mm.



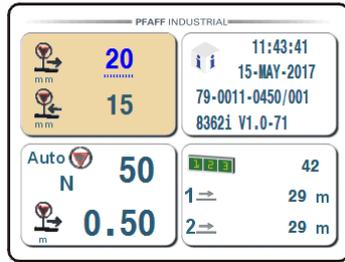
Press and hold the rotary push-button once (CLEAR) to set the reverse rotation after a stop to 0 mm (function switched off).



The modified parameter is accepted by again pressing the rotary push-button once briefly (ENTER). The modified parameter is no longer underlined; now the parameter is not modified by turning the rotary push-button but instead a new parameter selection is performed



Press the rotary push-button once briefly to accept the selection (ENTER). The selected parameter "**Follow-up movement after a stop**" is underlined.



Input of follow-up movement after a stop: e.g. 20 mm



Now the parameter can be increased by turning the rotary push-button. (Increment the follow-up movement after a stop to **99 mm**).



Now the parameter can be decreased by turning the rotary push-button. (Decrement the follow-up movement after a stop to **0 mm**).



Press the rotary push-button twice briefly (ESC) to set the follow-up movement after a stop to **99 mm**.



Press and hold the rotary push-button once (CLEAR) to set the follow-up movement after a stop to **0 mm** (function switched off).



The modified parameter is accepted by again pressing the rotary push-button once briefly (ENTER). The modified parameter is no longer underlined; now the parameter is not modified by turning the rotary push-button but instead a new parameter selection is performed.

## 11.07

### Info

Display of a variety of information:



13:22:59

Date

15-MAY-2017

Software number/index

79-0011-0450/001

LCD for machine type 8362i

8362i

Version display V1.0

V1.0

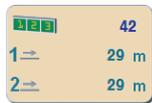
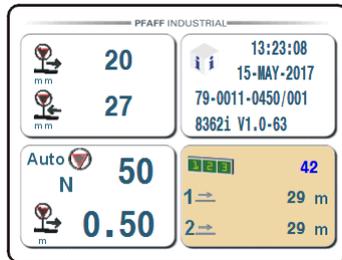
Control panel (manufacturer) software number (~V6.3)

-63

## 11.08 Display of piece counter, sealing distance 1 and sealing distance 2

The (daily) piece counter is incremented if the rollers to remove the workpiece are opened after a stop. It is also incremented after a stop with the force analysis or distance function or with the  or  push-buttons.

The sealed distance is added to the two sealing distances 1 and 2 at the same time. This function can now be used to check the values and delete them if necessary.



Piece counter display



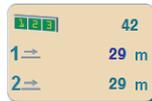
Press and hold the rotary push-button once (CLEAR) to delete the piece counter.



Now the parameter can be selected by turning the rotary push-button in a clockwise direction. (Selection of sealing distance 1).



Now the parameter can be selected by turning the rotary push-button in an anti-clockwise direction. (Selection of info).



Display of sealing distance 1



Press and hold the rotary push-button once (CLEAR) to delete the sealing distance 1.



Now the parameter can be selected by turning the rotary push-button in a clockwise direction. (Selection of sealing distance 2).



Now the parameter can be selected by turning the rotary push-button in an anti-clockwise direction. (Selection of piece counter).



Display of sealing distance 2



Now the parameter can be selected by turning the rotary push-button in a clockwise direction. (Selection of grinding).



Now the parameter can be selected by turning the rotary push-button in an anti-clockwise direction. (Selection of sealing distance 1).



Press the rotary push-button once briefly (ENTER) to request deletion authorisation.



Deletion authorisation closed



Now the parameter can be selected by turning the rotary push-button in a clockwise direction. (Selection of deletion authorisation open).



Deletion authorisation open.

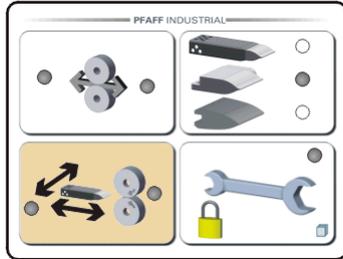


Press and hold the rotary push-button once (CLEAR) to delete the sealing distance 2 only with authorisation.

11.09

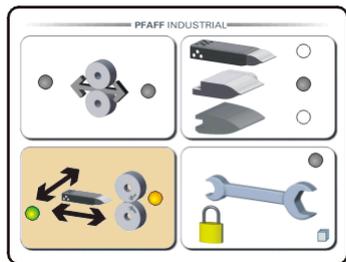
## Hot wedge grinding

The hot wedge grinding function is used to adjust the contour of the hot wedge to the rollers. To do this, sandpaper is clamped between the rollers, the hot wedge is engaged and the rollers are started in reverse. The machine is operated whilst stationary. Although the heating regulator is switched off when this function is activated, it is recommended that the heating regulator is switched off beforehand at a temperature input of 20 °C (because of the long cool-down period).



Selection of hot wedge grinding

- 1x Press the rotary push-button once briefly (ENTER) to activate the hot wedge grinding.

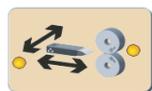


Hot wedge grinding selection activated

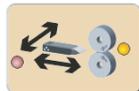


Wedge disengaged

- 1x Press the rotary push-button once briefly (ENTER) to move the hot wedge.

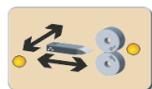


Wedge moves

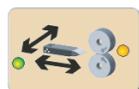


Wedge forward

- 1x Press the rotary push-button once briefly (ENTER) to move the hot wedge.

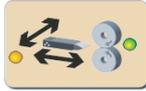


Wedge moves

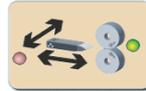


Wedge disengaged / rollers are stationary

- 1x Pressing the start push-button or push-button of the handlebar once briefly engages the hot wedge completely and the rollers rotate.



Wedge / rollers are rotating



Wedge forward / rollers are rotating



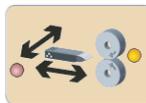
Now the parameter can be selected by turning the rotary push-button in a clockwise direction. (Increase the roller speed).



Now the parameter can be selected by turning the rotary push-button in an anti-clockwise direction. (Reduce the roller speed).



Press the start push-button or push-button of the handlebar once briefly to stop the rollers.



Wedge forward / rollers are stationary

Rollers are stationary



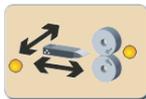
Wedge disengaged or engaged / rollers are stationary



or



Press and hold the start push-button or push-button of the handlebar once (CLEAR) to switch off the wedge positioning motors.



Wedge positioning motors switched off.

Rollers are stationary



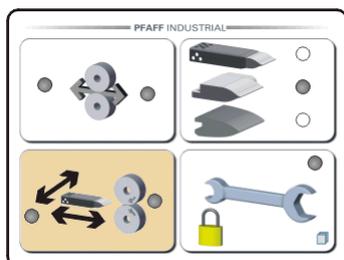
Wedge disengaged or engaged / rollers are stationary



or



Press the start push-button or push-button of the handlebar twice briefly or press the rotary push-button twice briefly (ESC) to terminate the function.

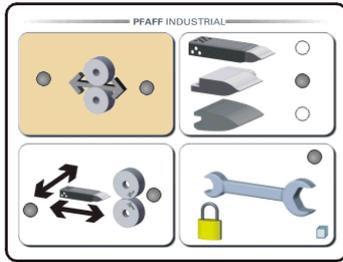


Function terminated.

11.10

## Rotating the sealing rollers (test function)

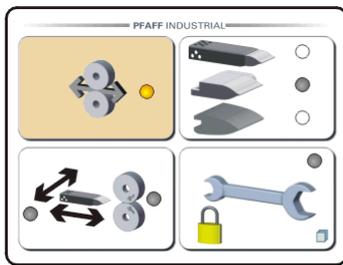
This function can be used to switch on the sealing roller test.



Selection of rotate sealing rollers



Press the rotary push-button once briefly (ENTER) to switch off the function.



Motors are stationary, select direction of rotation (yellow LED)



or



forward

or



reverse

or



forward

Start motors in a forward direction (green LED)



or



Motors are stationary

or



Motors are rotating

or



Motors are stationary

Start the motors in a reverse direction (green LED)



or



Motors are stationary

or..



Motors are rotating

or



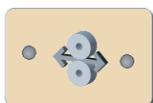
Motors are stationary



or



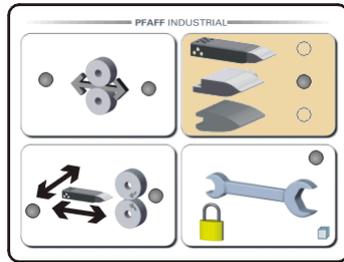
Press the start push-button or push-button of the handlebar twice briefly or press the rotary push-button twice briefly (ESC) to terminate the function.



Return to the function selection

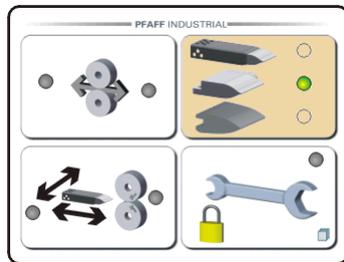
11.11 **Wedge selection**

This function is used to set the type of hot wedge installed. The hot wedges differ in their heating power and shape. The shape of the wedge has an impact especially when it is engaged. The heating power is taken into account in the control parameters.



Wedge selection closed

1x The wedge shapes can be selected by pressing the rotary push-button once briefly (ENTER).



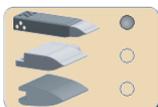
Wedge selection open

Now the parameter can be selected by turning the rotary push-button in a clockwise direction. (Select wedge shape).



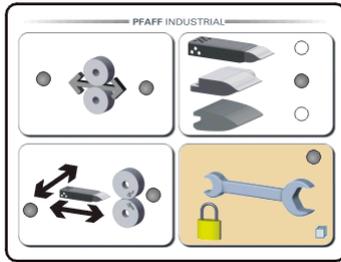
Wedge shape 1    Wedge shape 2    Wedge shape 3

1x Press the rotary push-button once briefly (ENTER) to accept the selected wedge shape.

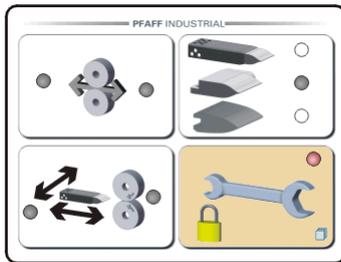


The wedge shape 1 is accepted.

## 11.12 Selection of settings



Press the rotary push-button once briefly (ENTER) to be able to open the "Settings" menu.



The following setting functions should only be accessible to qualified people. Access is therefore only given after authorisation has been granted.



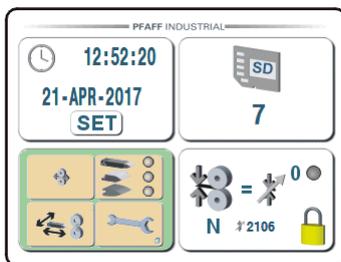
Press the rotary push-button once briefly (ENTER) to secure the lock and prevent access (BEEP).



Open the lock.

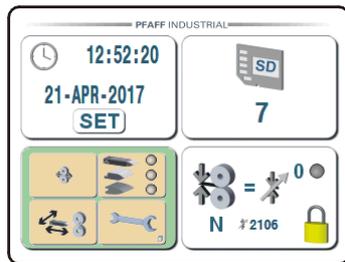


Press the rotary push-button once briefly (ENTER) to open the lock and grant access.



See chapter 12 Settings.

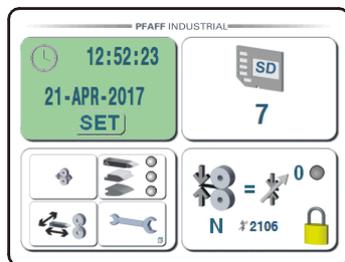
12 Settings



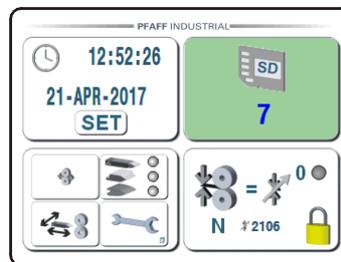
Press the rotary push-button once briefly (ENTER) to return to the "Input" menu, see chapter 11 Input.

12.01 Overview

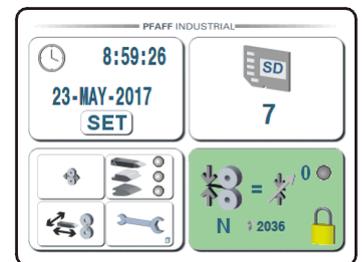
Special parameters and functions that should not be accessible to the normal user are determined in this group. A few of these functions require authorisation again to prevent them from being performed inadvertently.



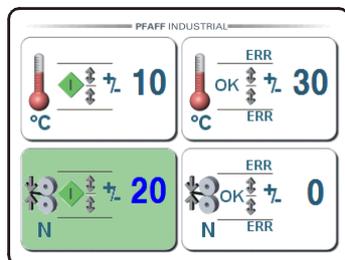
Selection of set date/time



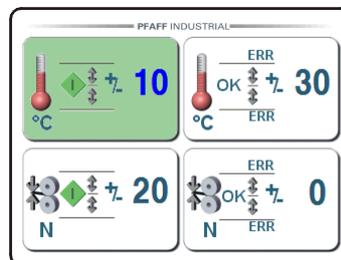
Selection of protocol type



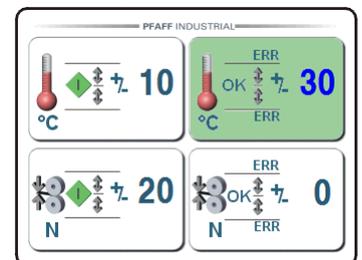
Selection of set zero point of the measuring device roller force (only with authorisation)



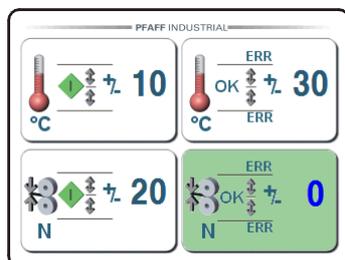
Selection of start window force



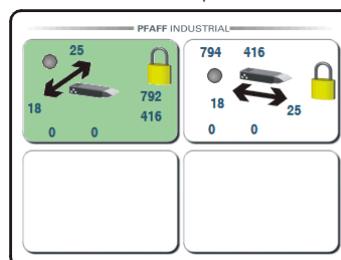
Selection of start window temperature



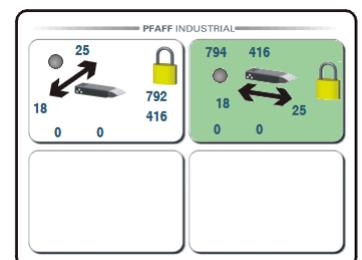
Selection of temperature target error limit



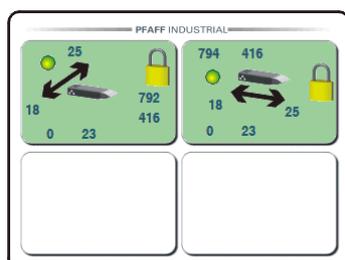
Selection of force error limit



Selection of optimise motor 3 (Positioning arm with authorisation)



Selection of optimise motor 4 (wedge forward/back with authorisation)



Selection of check positioning arm

# Settings

---



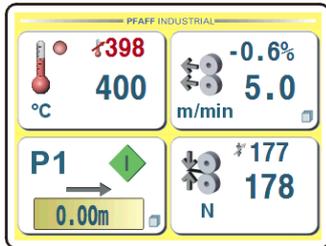
Turning the rotary push-button in a clockwise direction selects the functions in the top sequence (see page 63).



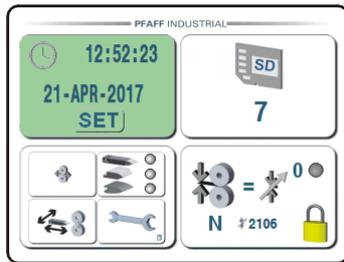
Turning the rotary push-button in an anti-clockwise direction selects the functions in the reverse order (see page 63).



Briefly press the rotary push-button twice (ESC) to jump to production immediately.



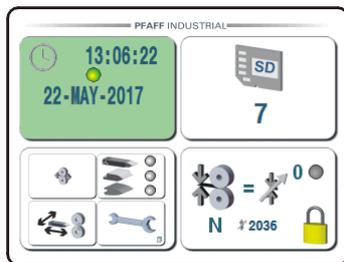
12.02 Setting the date / time



Selection of the date / time function



Press the rotary push-button once briefly (ENTER) to accept the selection. The selected parameter "Date / time" is displayed. The individual components of the date and time are displayed.



Selection of hours



Selection of minutes



Selection of seconds



Selection of day



Selection of months



Selection of year



Selection of accept time / date



Turning the rotary push-button in a clockwise direction selects the functions in the top sequence.



Turning the rotary push-button in an anti-clockwise direction selects the functions in the reverse order.

Example of how to change the hours:



The parameter "Hours" can be changed by pressing the rotary push-button once briefly (ENTER).



Now the parameter can be increased by turning the rotary push-button. Hours 14..23..00..13).



Now the parameter can be decreased by turning the rotary push-button. Hours 12..00..23..13).

- 2x** Press the rotary push-button twice briefly (ESC) to discard all changes and display the current time.



- 1x** To accept the selection, press the rotary push-button once briefly (ENTER) to accept the modified parameter "Hours".



The other individual components of the time and date are changed in the same way.

### Acceptance:

The following functions are used to accept the modified time and date settings.



Accept time / date selection

- 1x** To accept the selection, press the rotary push-button once briefly (ENTER) to accept the modified parameter "Time / date".



Accept time / date

- 2x** Press the rotary push-button twice briefly (ESC) to discard all changes (cancel).



## 12.03 Defining a protocol file

The PFAFF 8362i can save a protocol file from every sealing process on an SD card. A simple or extended protocol file can be saved.

### 12.03.01 Simple protocol file

The simple protocol file contains the following data:

Read 104 Bytes from Log file X:\20170224\100930.BIN

Date/Time: 20170224 - 10:09:21

Short Log file

Welding data P1:

---

machine type: 8362i  
data type: PR  
data version: 1  
pnr: 1  
temp: 364°C  
speed: 3.9m/min  
diff: -2.1%  
startdelay: -0.20s  
dist: 0.00m  
trailer after distance: 0.00m  
force: 54N  
trailer after stop: 0mm  
backwards after stop: 0mm  
autostop force: 10N  
autostop trailer: 0.10m  
wedge type: 1

---

start position: 0.00m  
min temp: 370.3°C  
max temp: 371.1°C  
min force: 47N  
max force: 56N  
last setpoint temp: 364°C  
last setpoint speed: 3.9m/min  
last setpoint force: 54N  
welding length: 0.38m  
heater ONtime: 75  
powerfactor: 525Wsec

---

Stop by autostop force : 43N

## 12.03.02 Extended protocol file

The extended protocol file contains the following data:

Read 1736 Bytes  
from Log file X:\20170509\132640.BIN  
Date/Time: 20170509 - 13:26:26  
Extended Log file  
Welding data P1:

---

machine type: 8362i  
data type: PR  
data version: 1  
pnr: 1  
temp: 370°C  
speed: 2.0m/min  
diff: -0.6%  
startdelay: 0.00s  
dist: 0.00m  
trailer after distance: 0.00m  
force: 82N  
trailer after stop: 0mm  
backwards after stop: 0mm  
autostop force: 33N  
autostop trailer: 0.30m  
wedge type: 1

---

start position: 0.00m  
0.0 sec -----  
Temp1=370.1°C  
Temp2=371.6°C  
force=73N  
ONtime=9%  
KPR=-8  
yi=102  
yd=2  
yz=0  
pfail=0  
min temp: 370.1°C  
max temp: 370.1°C  
min force: 70N  
max force: 70N  
last setpoint temp: 370°C  
last setpoint speed: 2.0m/min  
last setpoint force: 82N  
0.3 sec -----  
Temp1=369.3°C  
Temp2=371.3°C

force=76N  
ONtime=9%  
KPR=56  
yi=102  
yd=12  
yz=0  
pfail=0  
min temp: 369.3°C  
max temp: 370.1°C  
min force: 70N  
max force: 76N  
last setpoint temp: 370°C  
last setpoint speed: 2.0m/min  
last setpoint force: 82N           usw  
.....  
Alle 250ms eine Messung  
.....  
12.8 sec -----  
Temp1=368.6°C  
Temp2=369.3°C  
force=77N  
ONtime=25%  
KPR=112  
yi=159  
yd=5  
yz=0  
pfail=0  
min temp: 367.8°C  
max temp: 370.1°C  
min force: 69N  
max force: 77N  
last setpoint temp: 370°C  
last setpoint speed: 2.0m/min  
last setpoint force: 82N

welding length: 0.42m  
heater ONtime: 275  
powerfactor: 1925Wsec

-----  
Stop by stop-button

## 12.03.03 Error.txt

A further protocol file is the creation of the ERROR.TXT file where all the error messages are saved with a date and time.

Excerpt:

2017-02-24 8:37:48

ERROR : 203

ROLLERS OPEN

2017-02-24 10:26:03

ERROR : 203

ROLLERS OPEN

2017-02-24 11:13:52

ERROR : 203

ROLLERS OPEN

2017-02-24 11:23:23

ERROR : 203

ROLLERS OPEN

## 12.03.04 File formats and folders

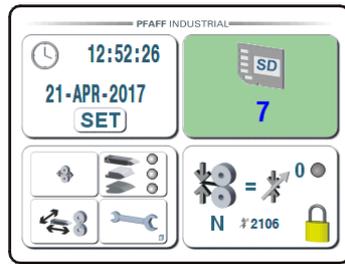
The protocols are saved in a folder derived from the actual date in the format YYYYMMDD. The protocol file has the file name HHMMSS.bin. The HHMMSS is the time at which the file was created (usually at the end of the sealing process).

If the sealing parameter sets P1...P9 are saved, they can be found in the folder P8362 as a binary file with the file name P1...P9 (without an extension).

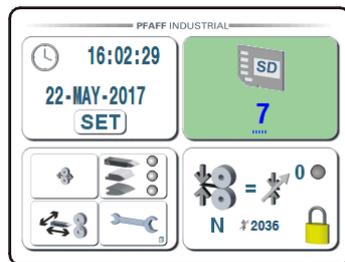
The above-mentioned error protocol file ERROR.TXT can also be found in the folder.

As the name suggests, it is a text file that can be displayed directly on any PC or mobile device.

12.03.05 Activating the protocol file



- 1x Press the rotary push-button once briefly to accept the selection (ENTER). The selected parameter "Protocol file" is underlined.



Protocol file input:

- ↻ Now the parameter can be increased by turning the rotary push-button. (Increase the value to between 0..7).
- ↻ Now the parameter can be decreased by turning the rotary push-button. Decrease the value to between 7..0).
- C Press and hold the rotary push-button once (CLEAR) to set the value to 0 (switch off the Error.txt and protocol).
- 2x Press the rotary push-button twice (ESC) to set the value to 7 (Error.txt and extended protocol).
- 1x Press the rotary push-button briefly once again (ENTER) to accept the modified parameter. The modified parameter is no longer underlined; now the parameter is not modified by turning the rotary push-button but instead a new parameter selection is performed

Settings:



No protocol  
No Error.txt



No Error.txt  
No protocol



Error.txt and  
simple protocol



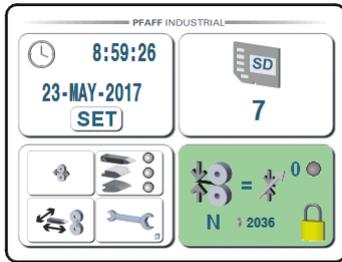
Error.txt and  
extended protocol

Other combinations:

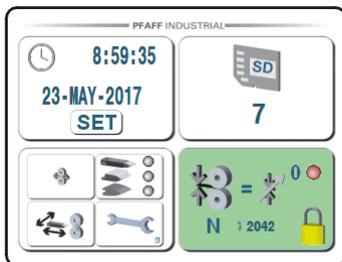
- 2 = simple protocol, no Error.txt
- 4.6 = extended protocol, no Error.txt
- 5 = same function as 7

## 12.04 Setting the zero point of the roller force measuring device

This function is used to set the zero point of the testing bridge for the roller force. To do this, the rollers are fully open and this function is performed.



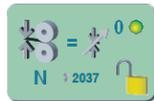
Press the rotary push-button once briefly (ENTER) to be able to open the "Zero point" menu.



Request authorisation



Open the lock



Authorisation granted



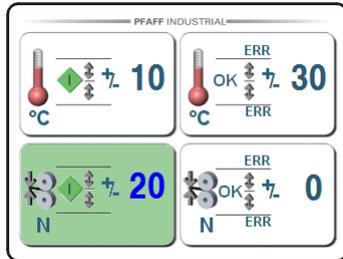
The modified parameter is accepted by again pressing the rotary push-button once briefly (ENTER). The zero point is saved; now the parameter is not modified by turning the rotary push-button but instead a new parameter selection is performed



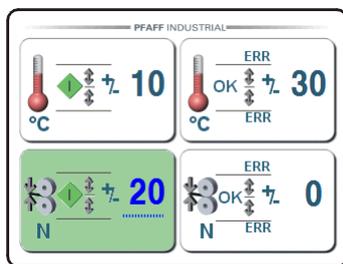
Zero point saved

## 12.05 Setting the roller force start window

The measured roller force in combination with an adjustable target force can prevent the start of the sealing if it is not without an adjustable force window.



Press the rotary push-button once briefly to accept the selection (ENTER). The selected parameter "**Roller force**" is underlined.



Roller force input:



Now the parameter can be increased by turning the rotary push-button. (Increase the value to between 0..50 N).



Now the parameter can be decreased by turning the rotary push-button. (Decrease the value to between 50..0 N).



Press and hold the rotary push-button once (CLEAR) to set the value to 0 (switch off the start window function).



Roller force symbol no longer flashes.



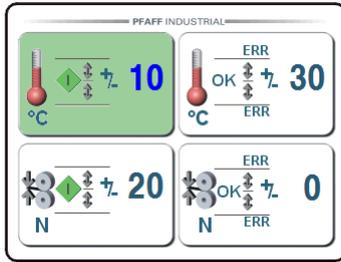
Press the rotary push-button twice briefly to set the value to the maximum value of 50 N.



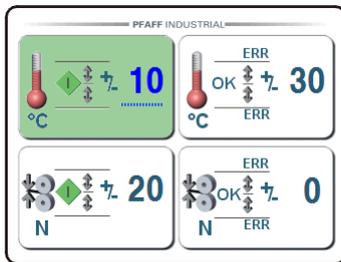
The modified parameter is accepted by again pressing the rotary push-button once briefly (ENTER). The modified parameter is no longer underlined; now the parameter is not modified by turning the rotary push-button but instead a new parameter selection is performed.

## 12.06 Adjusting the temperature start window

The temperature start window prevents the machine starting if the hot wedge is too cold or hot.



Press the rotary push-button once briefly to accept the selection (ENTER). The selected parameter "Temperature" is underlined.



Temperature input:



Now the parameter can be increased by turning the rotary push-button. (Increase the value to between 5..20°).



Now the parameter can be decreased by turning the rotary push-button. (Decrease the value to between 20..5°).



Press and hold the rotary push-button once (CLEAR) to set the value to 5 °C.



Press the rotary push-button twice briefly (ESC) to set the value to the maximum value of 20 °C.

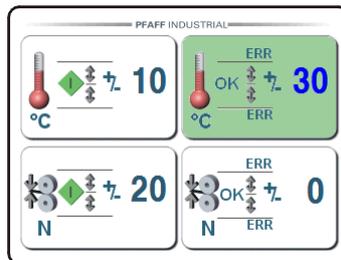


The modified parameter is accepted by again pressing the rotary push-button once briefly (ENTER). The modified parameter is no longer underlined; now the parameter is not modified by turning the rotary push-button but instead a new parameter selection is performed.

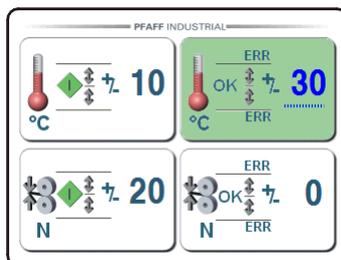
## 12.07 Adjusting the temperature error limit

If the hot wedge temperature leaves the target temperature range +/- this error limit, the error 14003 is displayed.

Error:



Press the rotary push-button once briefly to accept the selection (ENTER). The selected parameter "Temperature error limit" is underlined.



Temperature error limit input:



Now the parameter can be increased by turning the rotary push-button (start window value +5 °C) ....50 °C.



Now the parameter can be reduced from 50°.... by turning the rotary push-button (start window value +5 °C).



Press and hold the rotary push-button once (CLEAR) to set the start window value to +5 °C.



Press the rotary push-button twice briefly (ESC) to set the value to the maximum value of 50 °C.



The modified parameter is accepted by again pressing the rotary push-button once briefly (ENTER). The modified parameter is no longer underlined; now the parameter is not modified by turning the rotary push-button but instead a new parameter selection is performed.

**Note:**

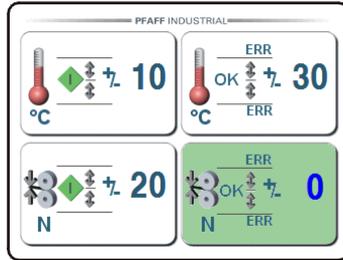
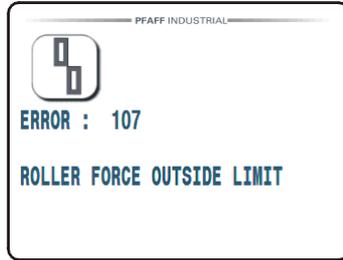
The value for the error limit should be at least 5° above the standard window value.

The start window value of +5 is therefore defined as a minimum value. If the start window is changed at a later stage, change the error limit if necessary.

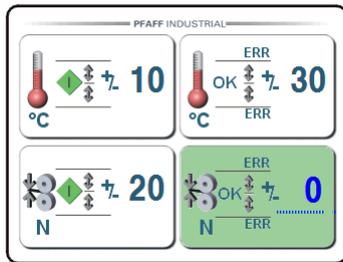
## 12.08 Adjusting the roller force error limit

If the roller force leaves the target force range  $\pm$  this error limit, the error 107 is displayed.

Error:



Press the rotary push-button once briefly to accept the selection (ENTER). The selected parameter "Roller force error limit" is underlined.



Roller force error limit input:



Now the parameter can be increased by turning the rotary push-button. (Increase the value to between 0..99 N).



Now the parameter can be decreased by turning the rotary push-button. (Decrease the value to between 99..0 N).



Press and hold the rotary push-button once (CLEAR) to set the force threshold value of 0 N (switch off the function).



Press the rotary push-button twice briefly to set the value to the maximum value of 99 N.



The modified parameter is accepted by again pressing the rotary push-button once briefly (ENTER). The modified parameter is no longer underlined; now the parameter is not modified by turning the rotary push-button but instead a new parameter selection is performed.

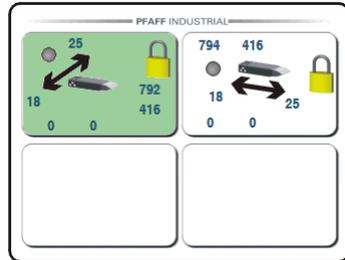
**Note:**

The error function is switched off if the value for the error limit is set to 0 N. The error 107 is then no longer generated.

12.09 Optimising the positioning motors, motors 3 and 4

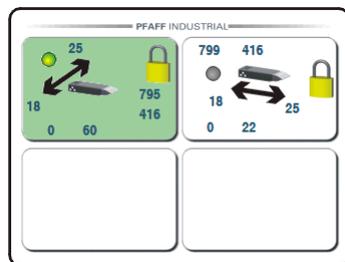
The hot wedge on the PFAFF 8362i is motor driven into the sealing position and back into the standby position. A function is needed to adjust and optimise this movement because of the various positions of the different types of hot wedges.

12.09.01 Optimising (engaging/disengaging) the positioning motor, motor 3



1x

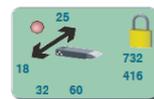
Press the rotary push-button once briefly (ENTER) to be able to optimise the "Motor3" menu.



Hot wedge disengaged

1x

Press the rotary push-button once briefly (ENTER)



Hot wedge engaged

1x

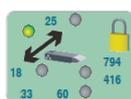
Press the rotary push-button once briefly (ENTER)



Hot wedge disengaged

1x

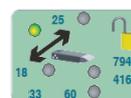
Press the start push-button or push-button of the handlebar once briefly



Lock closed



Turning the rotary push-button in a clockwise direction opens the lock.

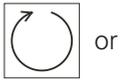


Lock open

1x

Press the rotary push-button once briefly (ENTER)

# Settings



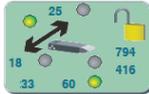
Turning the rotary push-button in a clockwise or anti-clockwise direction moves the value to the desired position where it should be changed.



Value "60" should be changed to the value "33".



Press the rotary push-button once briefly (ENTER)



Value "60" can be changed at any time.



Turning the rotary push-button in a clockwise or anti-clockwise direction changes the desired value from "60" to "33".



Press the rotary push-button once briefly (ENTER)



Value is changed to "33".



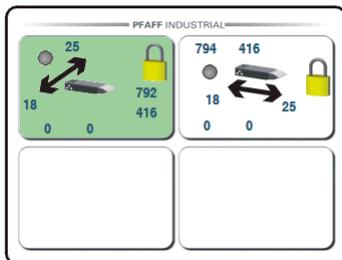
Press the rotary push-button twice briefly (ESC) to return to "Hot wedge disengaged".



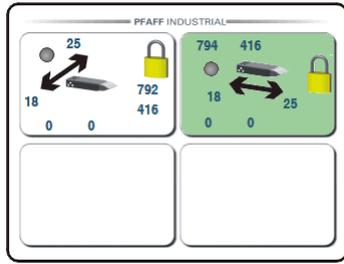
Hot wedge disengaged



Press the rotary push-button twice briefly (ESC)

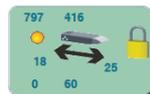
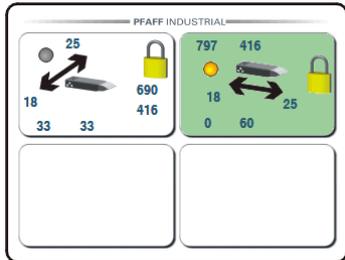


12.09.02 Optimising the positioning motor, motor 4 (forward/back)



1x

Press the rotary push-button once briefly (ENTER) to be able to optimise the "Motor4 " menu.



Hot wedge back

1x

Press the rotary push-button once briefly (ENTER)



Hot wedge forward

1x

Press the rotary push-button once briefly (ENTER)



Hot wedge back

1x

Press the start push-button or push-button of the handlebar once briefly



Lock closed

↻

Turning the rotary push-button in a clockwise direction opens the lock.



Lock open

1x

Press the rotary push-button once briefly (ENTER)

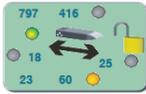


or



Turning the rotary push-button in a clockwise or anti-clockwise direction moves the value to the desired position where it should be changed.

# Settings



The value "60" should be changed to the value "23".

1x

Press the rotary push-button once briefly (ENTER)



Value "60" can be changed at any time.



or



Turning the rotary push-button in a clockwise or anti-clockwise direction changes the desired value from "60" to "23".

1x

Press the rotary push-button once briefly (ENTER)



Value is changed to "23".

2x

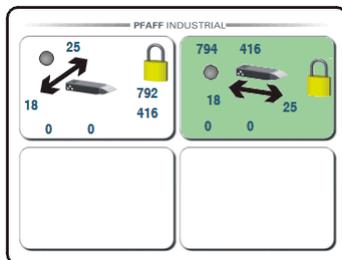
Press the rotary push-button twice briefly (ESC) to return to "Hot moves back".



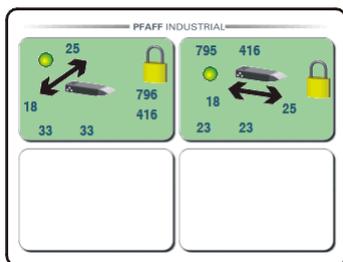
Hot wedge back

2x

Press the rotary push-button twice briefly (ESC)



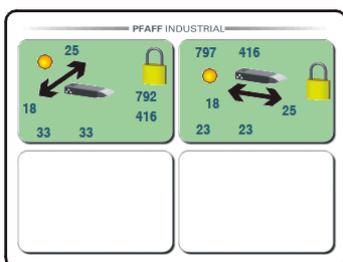
12.09.03 Checking the positioning motors, motors 3 and 4



Disengaged / back

1x

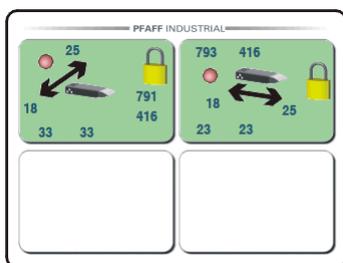
Press the rotary push-button once briefly (ENTER)



Hot wedge moves

1x

Press the rotary push-button once briefly (ENTER)



Engaged / forward

## 13 Maintenance and Care

### 13.01 Maintenance intervals

Check the cable and plug-in connections.....	daily, before start-up
Clean the hot wedge.....	daily, before start-up
Replace the hot wedge.....	as required
Replace the feed rollers .....	as required

### 13.02 Cleaning



Switch off the machine and let it cool down!  
Risk of burns when touching the heating element!

### 13.03 Checking the cable and plug-in connections



Switch off the machine!  
Remove the power lead! Fatal danger from electric voltage!

- Check the cable and plug-in connections for mechanical damage daily before start-up.



Never operate the machine in the event of a defect!  
Only arrange for qualified technical peoples to repair the machine!

### 13.04 Cleaning the hot wedge

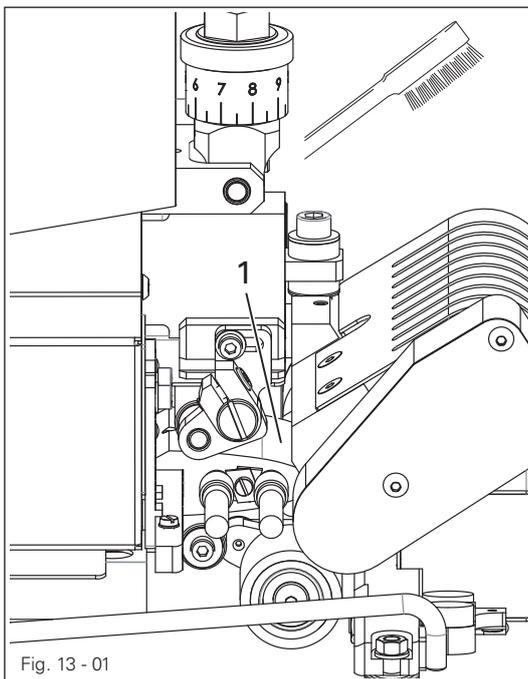


Fig. 13 - 01

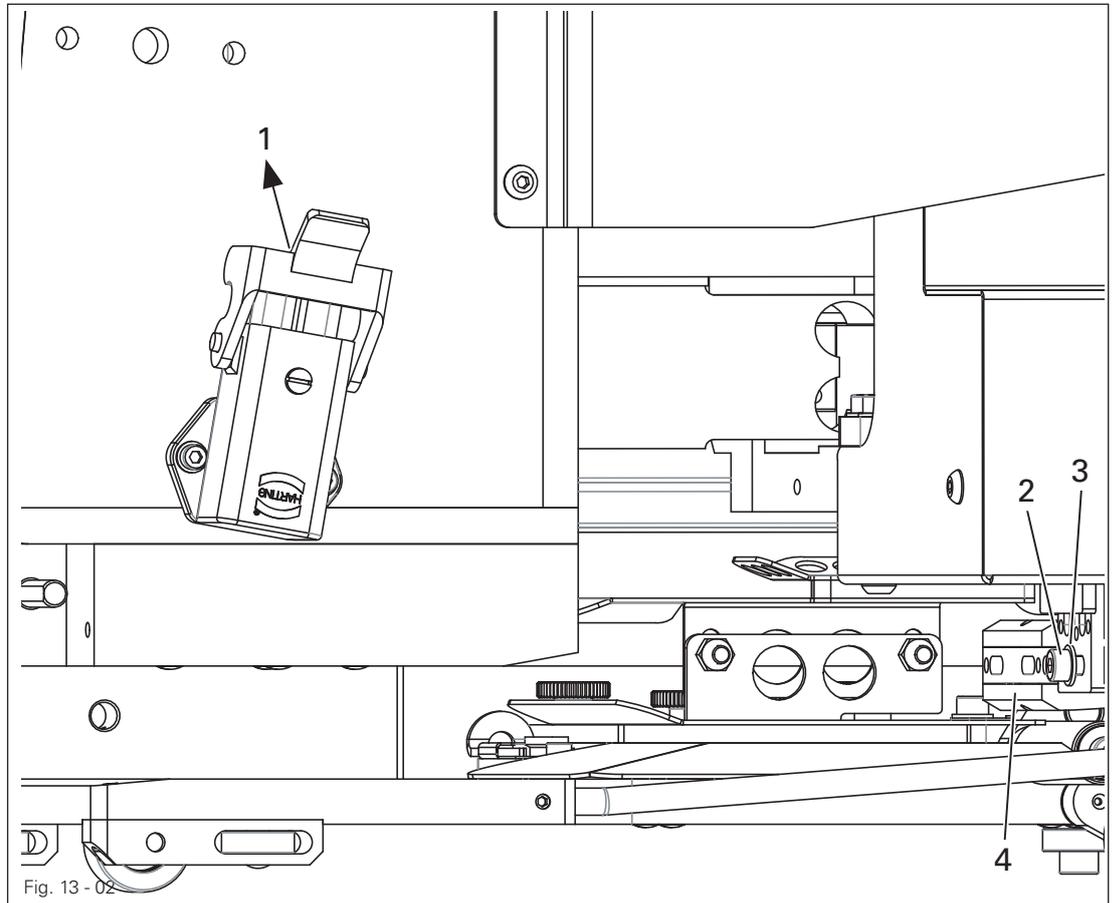


Make sure that the machine is switched off and the hot wedge has cooled down!  
Danger of burning!

- Remove the burnt-on residues on the top and bottom of the hot wedge 1 with a soft brass brush before starting up the machine.

## 13.05 Replacing and grinding the hot wedge

If the heating cartridges are defective or the hot wedge is very worn and can no longer achieve optimum sealing results when it is adjusted, the hot wedge must be replaced and ground, see **chapter 11.09 Hot wedge grinding**.



Let the heating element cool down!  
Risk of burns when touching the heating element!

- Remove the hot wedge connector 1.
- Loosen the screw 2 and the disc 3.
- Remove the hot wedge 4.
- Perform the above-mentioned work steps in the reverse order to mount the new hot wedge 4.

## 13.06 Replacing the feed rollers

The feed rollers must be replaced depending on the material and the thickness of the foil and the desired seam type, see **chapter 9.01 Replacing the feed rollers**.

## 14 Adjustment

### 14.01 Notes on adjustment

All adjustments in this manual are based on a fully assembled machine and may only be carried out by technical staff trained for this purpose. Machine covers, which have to be removed and replaced to carry out checks and adjustments, are not mentioned in the text. The order of the following chapters corresponds to the most logical work sequence for machines that have to be completely adjusted. Both the preceding and following chapters must be observed if only specific individual work steps are carried out. Most of the adjustments are already described in **chapter 9 Set-up**.

The screws and nuts indicated in brackets ( ) are fastenings for machine parts, which must be loosened before any adjustment and tightened again afterwards.



Unless otherwise stated, the machine must be disconnected from the power supply during all the adjustment work!

Risk of injury due to accidental machine start-up!



Let the machine cool down after it is switched off!

Risk of burns when touching the heating element!

### 14.02 Tools, gauges and other accessories

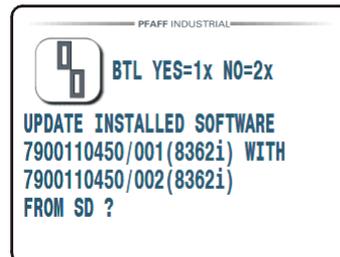
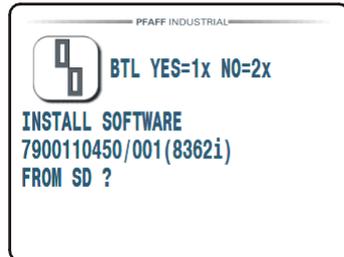
- 1 set of screwdrivers with knife widths of 2 to 10 mm
- 1 set of wrenches with jaw widths of 7 to 14 mm
- 1 set of Allen keys from 1.5 to 6 mm

## 14.03 Software update

The software of the PFAFF 8362i tape sealing machine can be updated with an SD card.



This requires a micro SD card (formatted for FAT32) with a micro SD adapter. To update the machine software, insert the micro SD card into the adapter and then insert this into the SD card reader (next to the hot wedge connector) before switching on the machine. After switching on the machine, a special program (boot loader) is activated that performs the software update.



Press the rotary push-button twice briefly (ESC)



The update is rejected with this function and the existing version is retained. The boot loader starts the previously installed machine software. No settings and sealing parameters are changed.

**Note:**

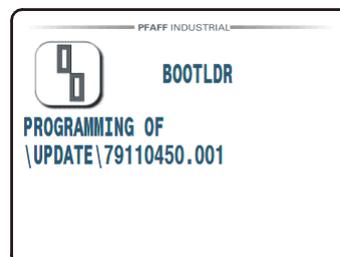
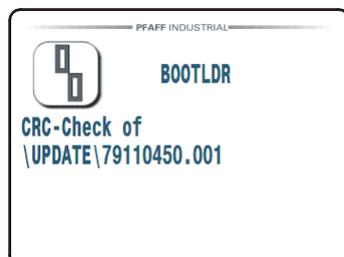
The process is repeated when the machine is next switched on if the SD card remains in the reader.



Press the rotary push-button once briefly (ENTER)



The software update is activated with this function. The boot loader checks the update on the SD card and then programs the new machine software.



The machine then performs a factory reset and then reads back the stored configurations, settings and sealing parameter sets P1..P9 from the non-volatile memory.

**Note:**

If the SD card remains in the reader, the boot loader detects that the versions of the installed machine software and the software on the SD are the same when the machine is next switched on. In this case, the update is not offered. The machine is then started up again.

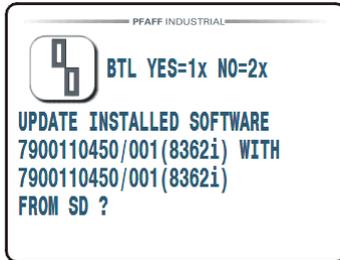
# Adjustment



or



Should a software update be essential for whatever reason, press one of the buttons (press and hold the rotary push-button once (ENTER) or press and hold the start push-button or push-button of the handlebar once) when switching on the machine. The boot loader then appears with the same software version.

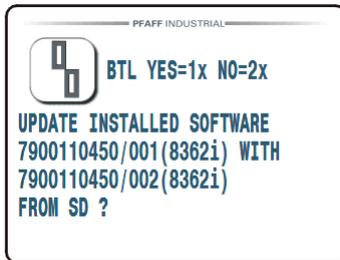


If the software update on the SD card is incomplete or defective, the update process is cancelled without changing the previously programmed software. In addition, no settings and sealing parameters are changed.

It should go without saying that the machine must not be switched off during the software update. However, if the power fails during the update, the boot loader detects the faulty programming and prevents the machine starting up until the update has been successfully repeated.

### ATTENTION!

The boot loader is activated when the versions of programmed software and the software on the SD card are different. It is therefore also activated when an SD card is inserted with an older version of software.



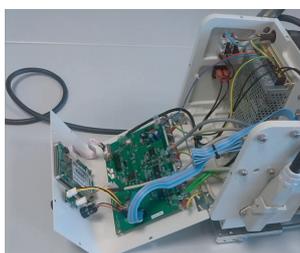
## 14.03.01 Software update of the LCD display

An update of the LCD display may potentially be required when updating the control software.

This requires a micro SD card formatted for FAT32. A folder DWIN.SET containing update information for the LCD display can be found on the micro SD card with the new software.



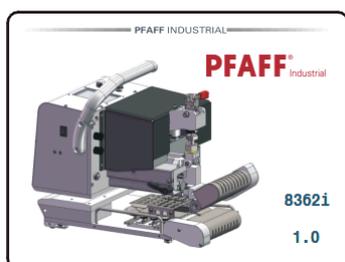
Place the machine on a flat surface. Switch off the machine and pull out the mains plug. Then loosen the 6 retaining screws (Allen key size 2.5 mm) and open the cover.



Insert the micro SD card in the LCD slot and allow it to engage. Now close the cover again and screw on one screw by hand a few turns so that the cover remains closed.



Insert the mains plug again and switch on the machine. The control panel initially displays a blue screen for a few seconds. Then all screen templates are displayed briefly in quick succession. The start screen then remains on the display.



Switch the machine off again, pull out the mains plug again, loosen the screw on the cover again and open it. Now remove the micro SD card from the LCD slot. Finally close the cover again with all the screws.

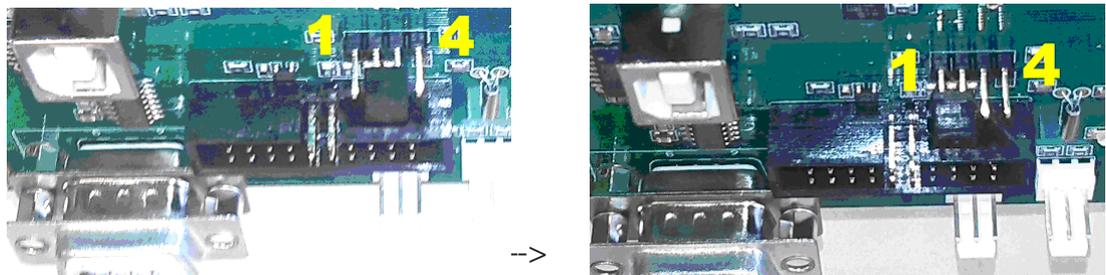
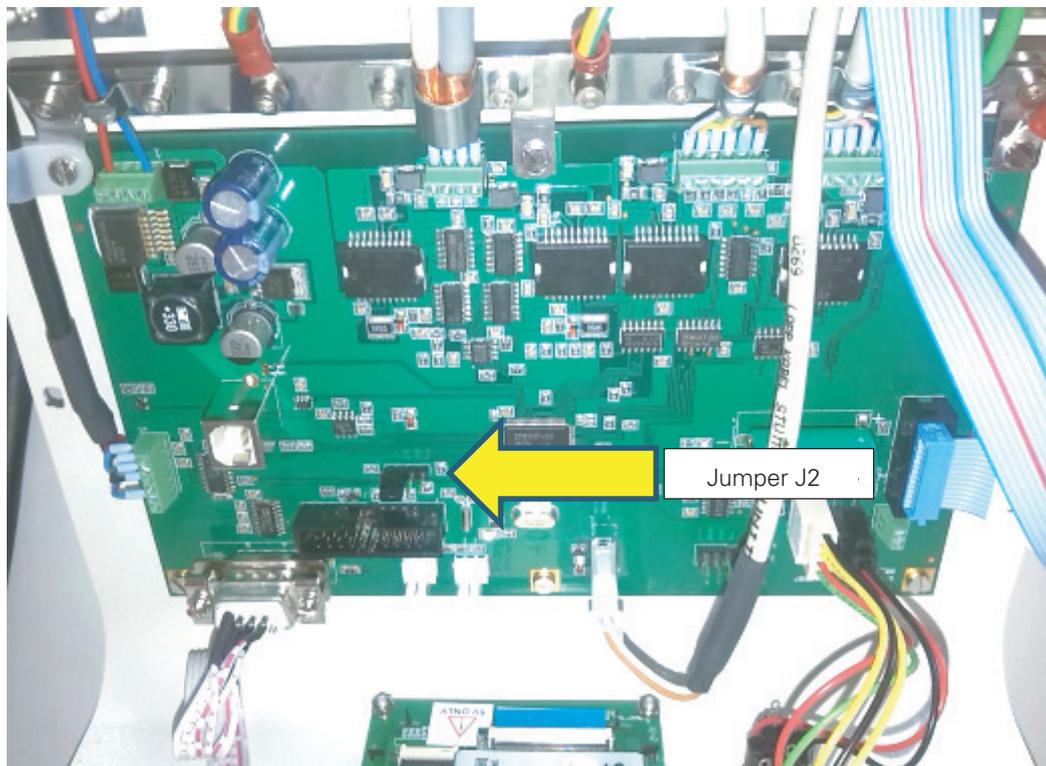
The machine is now ready for operation again.

## 14.04 Resetting to the factory settings

The sealing parameter sets, settings and parameters for the 8362i are stored in two separate memory modules with power loss protection. The data is therefore retained when the machine is switched off and after a software update. Sometimes it may be useful to reset this data back to the factory settings.

To do this, place the machine on a flat surface, switch it off and pull out the mains plug as already described in **chapter 14.03.01 Software update of the LCD display**. Then loosen the 6 cover screws again and open the cover.

Then place the jumper J2 from the middle position in the pins 1-2.



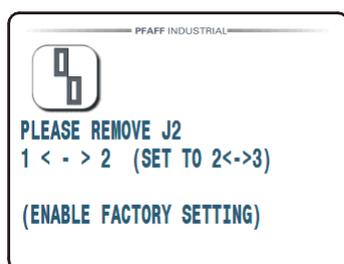
Close the cover again temporarily with one screw and then switch on the machine.



or



Press the rotary push-button once briefly (ENTER) or press the start push-button or push-button of the handlebar once briefly.

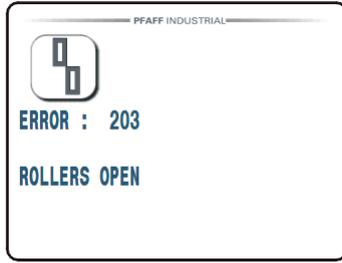


Switch the machine off again, pull out the mains plug and open the cover again. Place the jumper J2 in the middle position again and then screw on the cover completely again.

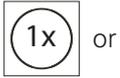
Now all parameters P1..P9 and all settings are reset and must be set again, for instance when the machine is initially started up.

## 14.05 Error messages

### 14.05.01 General errors



If the control unit detects an error caused by improper use, handling errors or breakdowns on the machine, the action that is currently being executed is cancelled and the error is displayed. The error is generally displayed with an error number and additional text that is of use when eliminating the error. The error numbers are divided into different groups.



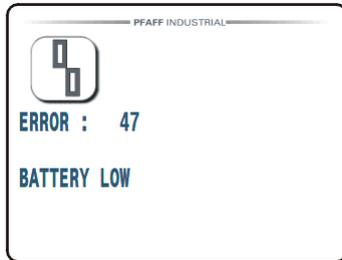
or



Press the rotary push-button once briefly (ENTER) or press the start push-button or push-button of the handlebar once briefly.

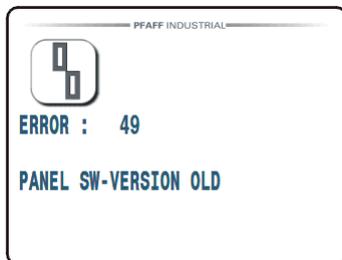
The machine software returns to the point where the error occurred by pressing a push-button. This is only of use if the cause of the error has been eliminated.

### 14.05.02 Error texts



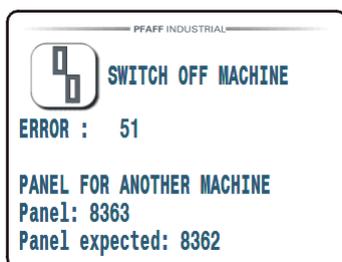
Battery voltage of the 3V cell is less than 2.4V. This means that the date and time of the real-time clock may be lost. This has an impact on the protocol function.

Remedy: Replace the battery



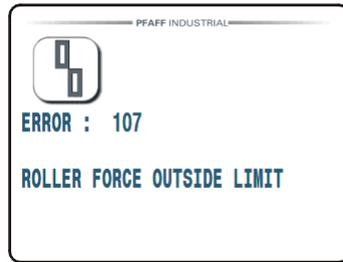
The LCD display has not been programmed with the last screen templates that match the current machine software. This means that different functions may potentially not be displayed or may be incorrectly displayed.

Remedy: Update the software of the LCD display (see [chapter 14.03.01 Software update of the LCD display](#)).



The LCD display is loaded with the screen templates of another machine. This means that the machine is unable to operate.

Remedy: Update the software of the LCD display (see [chapter 14.03.01 Software update of the LCD display](#)).



The roller force during the sealing process was outside the set error limit (see **chapter 12.08 Adjusting the roller force error limit**).

Remedy: Adjust the sealing process



Contouring error (blockage) on the roller drive of the bottom roller. Possible blockage from drawing the hot wedge into the roller gap.

Remedy: Check the hot wedge position

Other possible errors on the bottom roller drive:

11010	-	DC1: UNDEFINED INSTRUCTION
11013	-	DC1: START WITH MOT OFF
11014	-	DC1: SYNC CMD MASTER
11015	-	DC1: DRAG ERROR
11016	-	DC1: OVERCURRENT
11017	-	DC1: ERR HOLDING TORQUE



Contouring error (blockage) on the roller drive of the top roller. Possible blockage from drawing the hot wedge into the roller gap.

Remedy: Check the hot wedge position

Other possible errors on the bottom roller drive:

12010	-	DC1: UNDEFINED INSTRUCTION
12013	-	DC1: START WITH MOT OFF
12014	-	DC1: SYNC CMD MASTER
12015	-	DC1: DRAG ERROR
12016	-	DC1: OVERCURRENT
12017	-	DC1: ERR HOLDING TORQUE

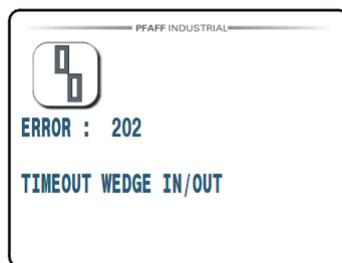


Temperature control error message: Temperature sensor in the hot wedge is defective.

Remedy: Repair the hot wedge

Other possible temperature control errors:

- 14001 - THERMOCOUPLE 1 BROKEN
- 14002 - TEMP. REGULATOR CIRCUIT NOT REACTING
- 14003 - TEMP. WINDOW EXCEEDED
- 14004 - TEMP. REGULATOR CIRCUIT NOT REACTING
- 14005 - THERMOCOUPLE 2 BROKEN
- 14006 - THERMOCOUPLE NOT WORKING



Error in the positioning drives of the hot wedge positioning arm

Remedy: Check the guides move freely



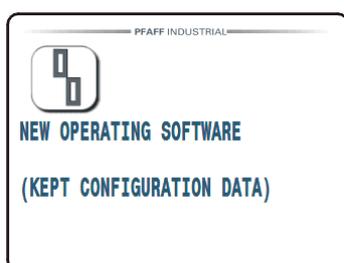
The rollers were opened incorrectly during the sealing process (or during various service functions).

Remedy due to neglect

## 14.05.03 Other information texts



The machine has been reset to the initial software configuration after a software update. The settings and parameters must be re-entered.



The machine has been reset to the initial software configuration after a software update. The settings and parameters have been read back from the memory modules with power loss protection.

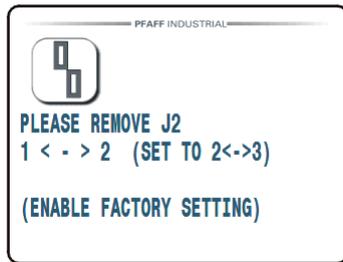


The machine has been reset to the initial software configuration after a software update. The settings and parameters of the previous version have been read back from the memory modules with power loss protection and the new basic parameter values have been added.

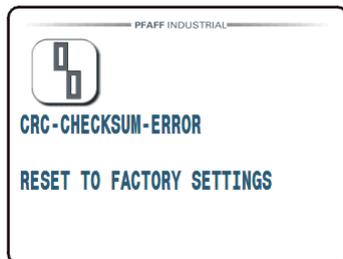


The settings and parameters have been reset to the basic software configuration with the jumper J2 (see [chapter 14.04 Resetting to the factory settings](#)).

The settings and parameters must be re-entered.



Information text after a reset (see chapter 14.04 Resetting to the factory settings).

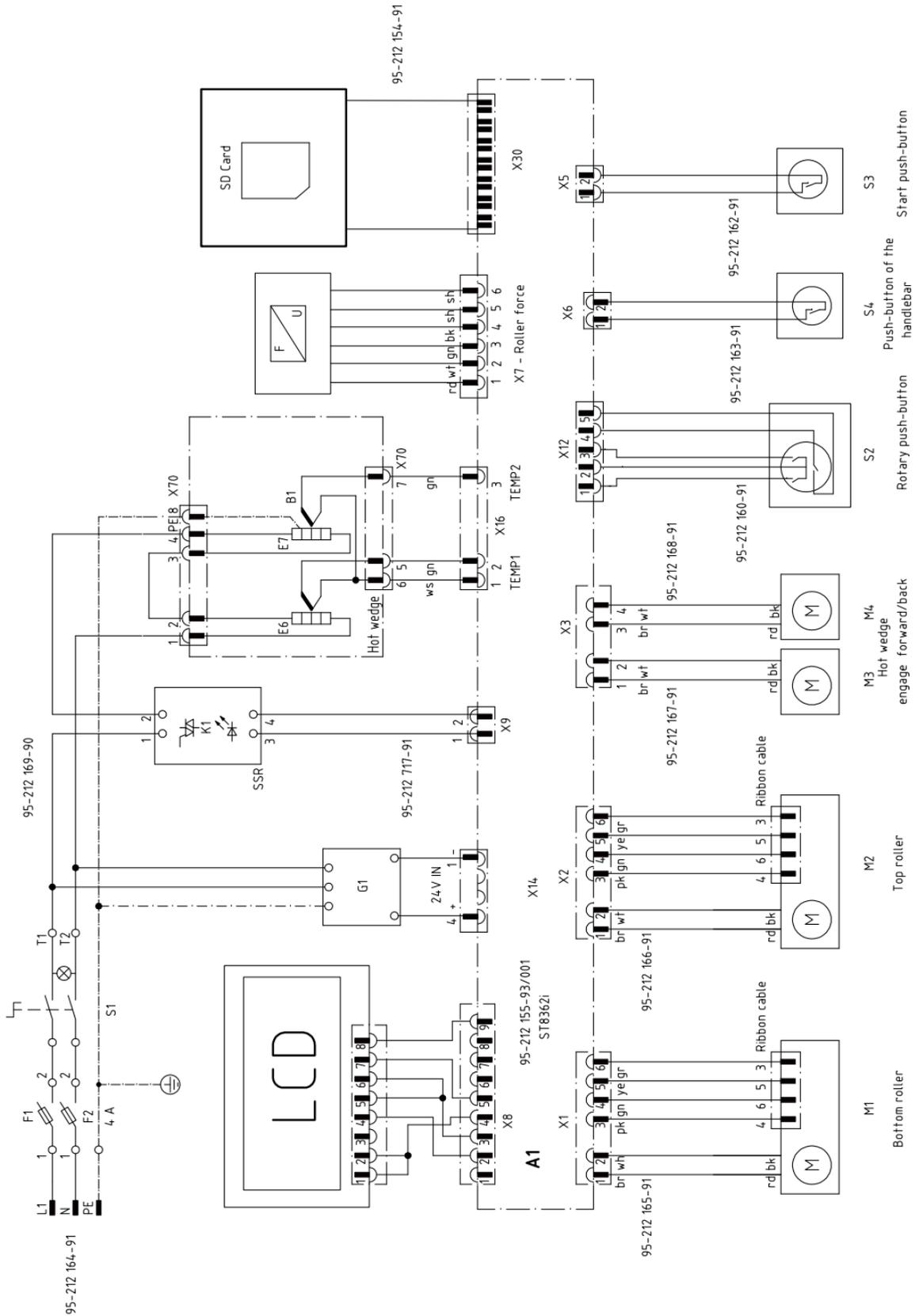


The two memories with power loss protection have lost their data and consequently all settings and parameters have been reset to their initial software configuration.

The settings and parameters must be re-entered.

# Circuit Diagrams

- 15 Circuit Diagrams
- 15.01 Circuit diagrams 95-212 173-95





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