

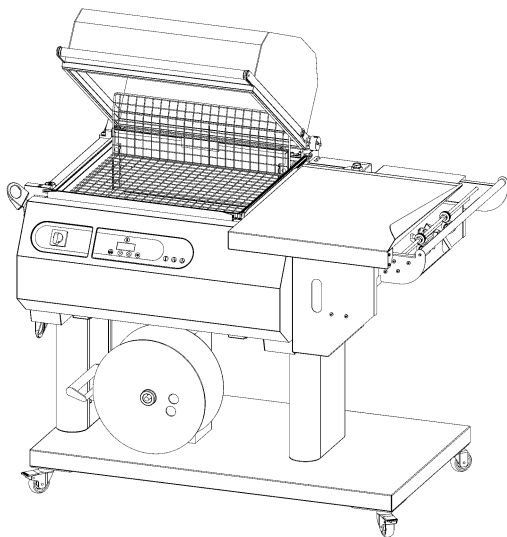


Minipack-torre S.p.A.
Via Provinciale, 54 - 24044 Dalmine (BG) - Italy
Tel. (035) 563525
E-mail: info@minipack.it
http://www.minipack.it

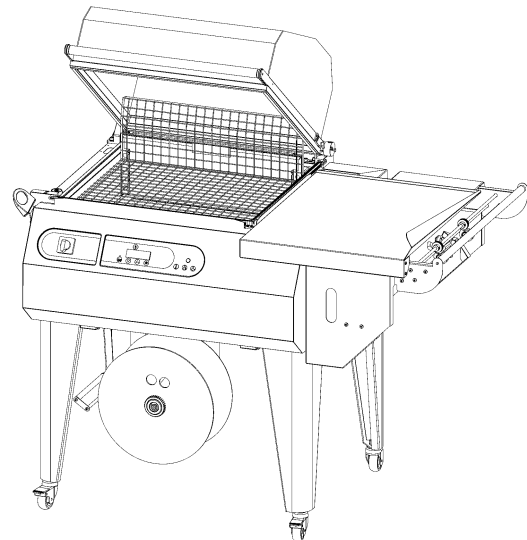


INSTALLATION, OPERATION AND MAINTENANCE

FM75 evo
FM76 evo



Replay 40 evo
Replay 55 evo



BEFORE USING THE MACHINE PLEASE CAREFULLY READ THE INSTRUCTIONS



DOC. N. FM111235A
REV. 0
ED. 01.2022





TRANSLATION OF THE ORIGINAL INSTRUCTIONS

Contents	EN
-----------------	-----------

	page
Chapter 1. Description	
1.1. Preface	19
1.2. Machine features	19
1.3. Machine technical data	19
Chapter 2. Film features	
2.1. Films to be used	20
2.2. Band A calculation	20
Chapter 3. Machine usage conditions	
3.1. Max. weight and dimensions of the package	20
3.2. Items that may be packaged	20
3.3. Items which must not be packed	20
Chapter 4. Safety standards	
4.1. Warnings	21
4.2. Description of safety stickers	22
4.3. Individual protection devices	22
Chapter 5. Machine installation	
5.1. Transport and positioning	23
5.2. Environmental conditions	24
5.3. Electrical connections	24
Chapter 6. Machine adjustment and setting up	
6.1. Adjustment	25
6.1.1. Control panel	25
6.1.2. Switching the machine on	25
6.1.3. Selection of programs and calibration of parameters	25
6.1.4. Alarm messages	28
6.2. Film reel insertion	29
6.3. Adjustment of the micropunches	29
6.4. Reticulated plate installation	29
6.5. Reel support and packaging plate adjustment	29
6.6. Making the first seal	30
6.7. Film binding on rewinder (if present)	30
6.8. Introducing the object to be packaged	30
6.9. Packaging	30
Chapter 7. Ordinary maintenance	
7.1. Instructions for ordinary maintenance work	31
7.2. Maintenance table	31
7.3. Sealing blade cleaning	31
7.4. Plastic film and other scrap removal	31
7.5. Machine cleaning	32
7.6. Coolant check (if present)	32
7.7. Substituting the rubber and Teflon	32
7.8. Changing the sealing blade	33
7.9. Problem solving	33
7.10. Disassembling, demolition and elimination of residuals	34
Chapter 8. Guarantee	
8.1. Guarantee conditions	34
CE declaration of conformity	69

1.1. Preface

This manual has been drawn up in compliance with the UNI10893 standard dated July 2000. It is meant for all users in order to enable them to use the machine correctly. Keep it in a place which can be easily accessed in the proximity of the machine and which is known to all users. This manual is an integral part of the machine for safety reasons. We wish to specify the symbols in use here below in order to improve understanding of them.

	ATTENTION: Accident prevention rules for the operator. This warning indicates the presence of dangers which can injure the person operating on the machine.
	ATTENTION: Hot parts. Shows the danger of burning, thus involving the risk of a serious accident for the exposed person.
	ATTENTION: Don't touch!
	WARNING: It indicates the possibility of damaging the machine and/or its components.

All reproduction rights of this manual are reserved to the manufacturer. Partial or complete reproduction is forbidden as provided by the law. Descriptions and pictures provided in this manual are not binding. Therefore the manufacturer, reserves the right to make any change considered necessary. This manual cannot be transferred for viewing to third parties without authorisation in writing from the manufacturing company.

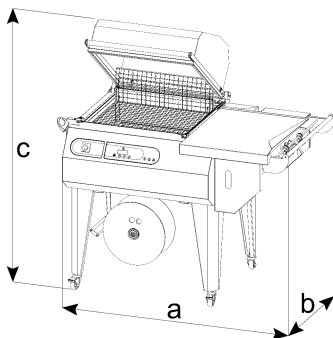
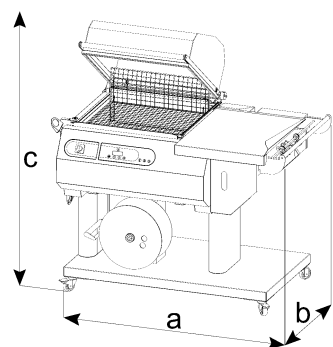
1.2. Machine features

You have bought a machine with outstanding features and performance and we thank you very much for choosing it. The system is unique and has achieved worldwide success with more than 400000 units operating in the packaging and wrapping sector.

The technological concept of its design, as well as the components and materials used in the manufacturing and testing process are the best assurance of proper operation and lasting reliability.

Thanks to its particular operating circuit, it can be used both as a sealing and shrinking machine or as a sealing machine only. In the latter case it is possible to pack the object in a soft bag without shrink-wrapping.

1.3. Machine technical data



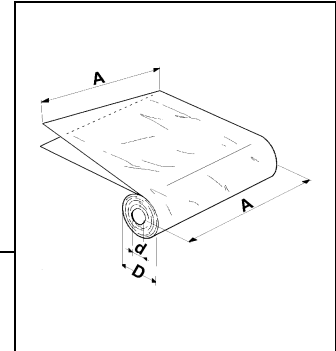
	FM75	Replay 40	FM76	Replay 55
“a” (mm)	1160	1160	1260	1260
“b” (mm)	700	700	810	810
“c” (mm) (hood closed)	1120	1120	1165	1165
“c” (mm) (hood open)	1220	1220	1310	1310
Maximum production (packs/hour)	300	300	300	300
Machine weight (kg)	112	90	126	105
Package weight (kg)	136	111	150	126

2.1. Films to be used

The machine can work with polyolefin heat-shrink film between 9 and 25 micron thick, both technical and suitable for food. To guarantee the best results, use the films marketed by us.

The special features of our films, with regard both to compliance with laws in force and to excellent machine performance.

FM75 – Replay 40 **A = 500 mm MAX** **D = 250 mm MAX** **d = 77 mm**
FM76 – Replay 55 **A = 600 mm MAX** **D = 250 mm MAX** **d = 77 mm**

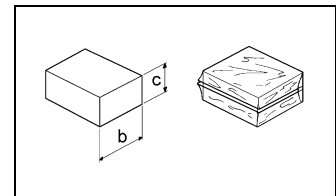


	Consult the data and safety sheets of the films in use and observe the corresponding instructions!
--	---

2.2. Band A calculation

Band A = b + c + 100 mm

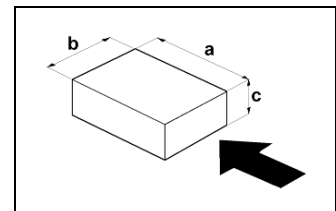
By band “A” we mean the width that the film must have to package the product.



3.1. Max. weight and dimensions of the package

FM75 – Replay 40 a = 400 mm b = 250 mm c = 160 mm Weight = 10 kg
FM76 – Replay 55 a = 500 mm b = 380 mm c = 200 mm Weight = 15 kg

Note: measurements shown refer to the maximum for the single dimension.
 Refer to chapter 2.2. to get max. dimension of pack (b x c); the addition of (b + c) is equal to film roll width minus 100 mm.



3.2. Items that may be packaged

These machines are capable of packing a wide range of completely different products. They are used successfully in the following sectors: food, marketing, graphics and mailing, large distribution, industry, fabrics.

3.3. Items which must not be packed

The products listed below must absolutely not be wrapped to avoid permanent damage to the machine and serious injuries to the operator:

	<ul style="list-style-type: none"> • Wet and unstable products • Liquids of any kind and density in fragile containers • Flammable and explosive materials • Pressurised gas cylinder of any kind • Loose and volatile powders • Bulk materials with grain size smaller than the holes of the reticulated plate • Any materials and products not listed but which might harm operator and damage the machine.
--	--

4.1. Warnings

It is extremely important to read this entire chapter as it contains important information regarding risks that personnel are subject to in the event of incorrect use of the machine. These basic standards must be observed as well as specific standards applicable in the country of installation.

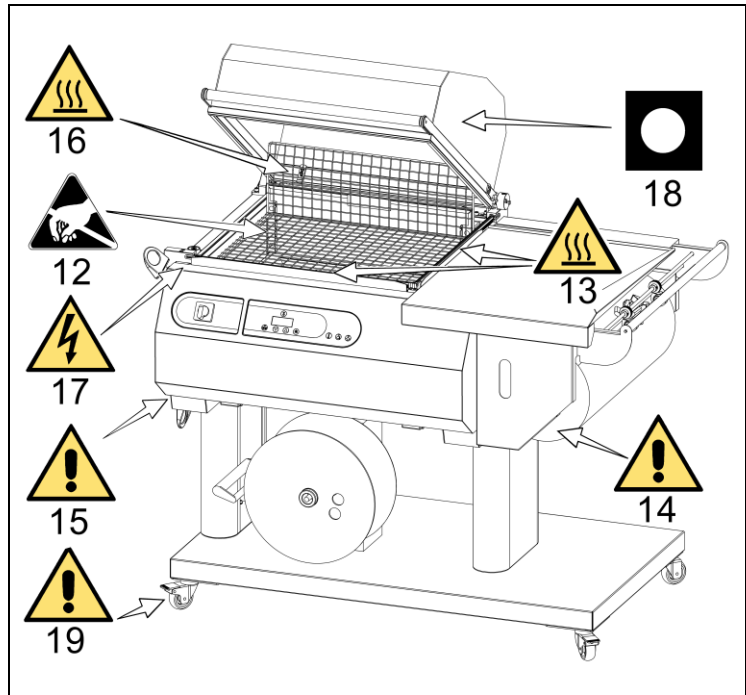
- This machine is not intended for use by persons (including children) with reduced physical, sensory or mental capabilities, or lack experience and knowledge, unless they have been given supervision or instruction concerning use of the machine by a person responsible for their safety.
- Children should be supervised to ensure that they do not play with the machine.
- Never use the machine for purposes other than as specified in the sales contract.
- Never allow unauthorised personnel to perform repairs or other operations on the machinery.
- The operator must be familiar with all warnings related to the tasks in hand and always be informed by the head of the site regarding risks.
- Ensure that all clothing is tight fitting, with particular reference to cuffs or other loose clothing.
- Ensure that all operating areas and transit zones are kept clear, clean and adequately lit at all times.
- Eliminate all safety hazard conditions before using the machine and always notify the head personnel of any malfunction.
- Never use the machine in the event of fault.
- Never tamper with safety devices or circuits.
- Never perform modifications on the machine without prior authorisation from the manufacturer.
- If the supply cord is damaged, it must be replaced by the manufacturer, its service agent or similarly qualified persons in order to avoid a hazard.
- The electrical enclosure must remain closed during operation.
- Smoking is forbidden while the machine is operating!
- Never performs maintenance and/or adjustments to the machine during operation. Guards may only be disassembled by suitably trained and qualified maintenance engineers.
- Never operate the machine without all guards fitted. Ensure correct position of all guards before resuming normal operation.
- If it is necessary to leave the machine unattended, switch it off by turning the main switch to the "0" (OFF) position!
- The manufacturer declines all liability for damage or phisical injury caused by failure to observe safety standards.

THE MACHINE CAN NOT BE USED BY UNTRAINED PERSONNEL!





During work pay attention to all hot parts of the machine. The temperature they can reach is so high that it can cause burns.

- Do not touch the sealing blade (13) soon after sealing by reaching beyond the safety guard. Danger of burns due to residual heat on the sealing blade (13)
- Do not keep on sealing if the sealing blade breaks (13). Replace it at once
- Do not touch the chamber closing flap (16) during warm-up. Danger of burns
- Do not touch the fan while moving or using the machine without the reticulated plate (12)
- Make sure the film reel is properly lodged in its place (14)
- Ensure that the machine is secured correctly to the four holes (15) on the trolley (if present)
- When the machine is not in use, leave the upper hood (18) open.
- The wheels (19) must be used only for moving the unit short distances across smooth, horizontal floors.






4.2. Description of safety stickers




The following safety stickers feature on the machine:

	<ul style="list-style-type: none"> ▪ On machine front panel. <p>Danger of electrocution! Risk due to presence of electrical power in electrical system inside front panel (17). When the panel is opened, the machine must be switched off and the plug must be pulled from the socket of the main circuit.</p> <p>While the machine is running, the front panel must be mounted properly.</p>
	<ul style="list-style-type: none"> ▪ On the guard in front of the sealing blade. ▪ On the protection panel of the heat diaphragm positioned behind the reticulated plate. <p>ATTENTION! Hot members. It shows the danger of burning, thus involving the risk of a serious accident for the exposed person.</p>

4.3. Individual protection devices

	<p>Wear safety shoes that protect feet from impacts, crushing and compression while moving or handling the machine.</p>
	<p>Wear safety gloves that protect the hands from crushing and mechanical hazards and while moving or handling the machine.</p>
	<p>Wear safety gloves that protect the hands against cutting risks while changing the sealing blade.</p>
	<p>Wear safety gloves that protect the hands against the specific risks associated with the materials to be packed (mechanical, chemical) and against coming into contact with the high temperatures present on the seals and/or sealing blade (up to 100°C).</p>
	<p>Wear safety gloves that prevent the hands from coming into contact with foodstuffs when packaging them.</p>

5.1. Transport and positioning

	<p>Wear safety shoes that protect feet from impacts, crushing and compression while moving or handling the machine.</p>
	<p>Wear safety gloves that protect the hands from crushing and mechanical hazards and while moving or handling the machine.</p>
	<p>The machine must be installed by personnel who are qualified for this operation: personnel specifically trained to safely carry out the loading, unloading and handling operations, who are familiar with the accident prevention rules.</p> <p>Where a forklift must be used, please note that:</p> <ul style="list-style-type: none"> • The forklift truck must only be driven and manoeuvred by specialised and trained personnel who have the skills to carry out these activities, • the load to be handled must not exceed the capacity of the forklift, • the load to be handled must be stable and positioned in absolute safety.

- Cut the strap with scissors make sure you protect your eyes by wearing glasses and withdraw the cardboard. Remove the screws and any plate intended to fasten the machine to the pallet.

If you have purchased the trolley (FM75/76 evo):

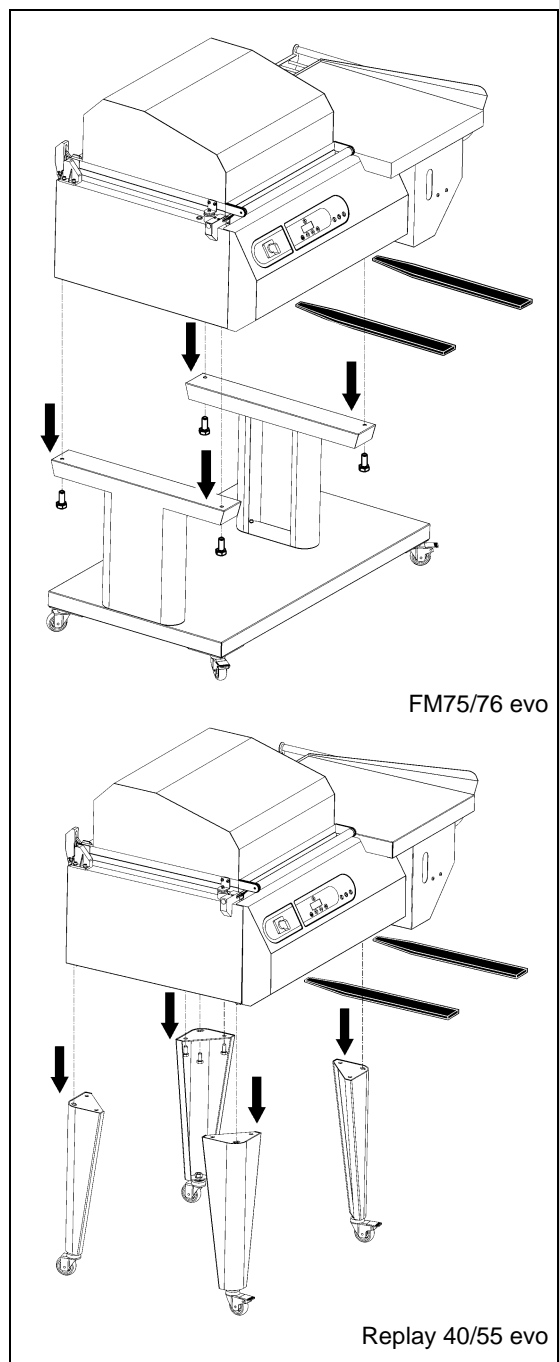
- Remove the box containing the trolley and assemble it according to the instructions inside the box
- Lift the machine by means of a fork lift truck and place it on its trolley, securing it in place using the four screws that were used to secure the packaging plates to the machine
- Cut the strap to release the upper hood.

If you have purchased the legs (Replay 40/55 evo):

- Remove the box containing the legs.
- Raise the machine using a fork lift and fit the 4 legs using the screws provided.
- Cut the strap to release the upper hood.

If you have purchased the waste rewriter:

- Unpack the waste rewriter and position it as indicated in the instructions provided.



5.2. Environmental conditions

- Place the machine level on the floor in a suitable environment free from humidity, gases, explosives, combustible materials. The machine may only be installed on smooth, flat non-inflammable surfaces
- Leave a minimum space of 0,5 m around the machine so that not to obstruct air inlets
- Once the correct position is achieved, lock the machine by means of the wheel brakes.

Working environment conditions:

- Temperature from + 5°C to + 40°C
- Relative humidity from 30% to 90%, without condensation.


The lighting of the operation room shall comply with the laws in force in the country where the machine is installed. However, it shall be uniform and allow good visibility in order to safeguard the operator’s safety and health.


MACHINE PROTECTION FACTOR = IP20
THE AIRBORNE NOISE MADE BY THE MACHINE IS LOWER THAN 70 dB(A)

5.3. Electrical connections

Voltage (V): see data on plate
 Frequency (Hz): see data on plate
 Maximum absorbed power (W): see data on plate
 Maximum absorbed current (A): see data on plate

Note: when contacting the Manufacturer, always indicate the model and the serial number specified on the plate on the rear part of the machine.

V~	Hz	W max	A max
		MOD	
MADE IN ITALY		FAVING	
		MATR.	



The power line must be protected with a type A residual current device with rated residual current equal to “IΔn”, 30 mA.
 As a result, the maximum resistance of the earth electrode must correspond to the values indicated in the following table

IΔn	Maximum resistance of the earth electrode	
	(50 V)	(25 V)
3 A	16 Ω	8 Ω
1 A	50 Ω	25 Ω
500 mA	100 Ω	50 Ω
300 mA	166 Ω	83 Ω
30 mA	1666 Ω	833 Ω



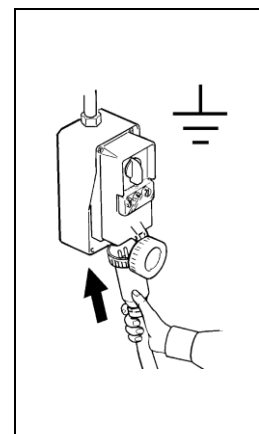
OBSERVE HEALTH AND SAFETY REGULATIONS!

If the machine is not equipped with the power supply plug, use a plug that is suitable for the voltage and amperage values described by the rating plate and that can comply with the rules in force in the installation country.

GROUNDING OF THE UNIT IS OBLIGATORY!

Before making electrical connections, make sure the mains voltage matches the one on the plate on machine rear and that the ground contact complies with the safety rules in force. In case of doubts about the mains voltage, contact the local power supply company.

Insert the plug on the cable from machine electrical cabinet in a mains power supply socket that can be reached easily by the operator.

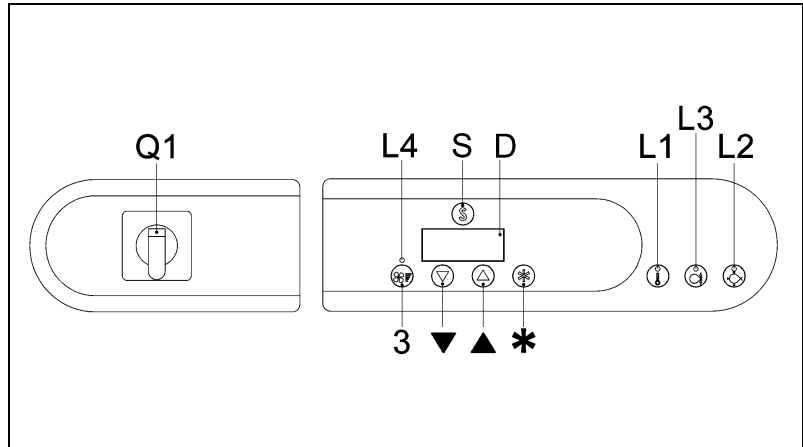


6.1. Adjustment

6.1.1. Control panel

The machine is fitted with a control panel, from which all programming and operation functions can be set.

- Q1** Main switch
- ▼** Button "DECREASE".
Reduces set function values
- ▲** Button "INCREASE".
Increases set function values
- 3** Button "Soft Shrink".
Reduces the fan speed
- L1** Temperature warning light
- L2** Shrinking warning light
- L3** Sealing warning light
- L4** LED Soft Shrink
- D** Display.
Displays selected functions and relative settings
- *** Cycle counter selection button
- S** Parameters selection button



6.1.2. Switching the machine on

Turn the main switch (Q1) into pos. 1.

The display (D) turns on and the number of the currently selected program will appear.

Switching the machine on powers the shrinking heat element which begins to heat up.

Before using the machine, wait until the adjusting temperature is reached. This is signalled by the extinction of the warning light (L1).

6.1.3. Selection of programs and calibration of parameters

The machine has 10 programs (Pr 1-Pr 10) that can be selected by pressing (▲) and (▼).

The programs are identical and, with the appropriate settings, can make 2 different types of packaging:

ONLY SEALING

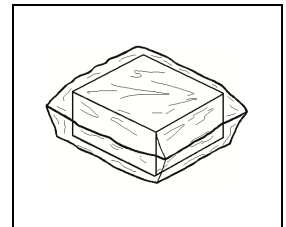
This program is for film sealing only.

The film melts due to the heat of the sealing blade. The pressure between the sealing blade and the upper contrast lined in Teflon separates the 2 edges of the film.

The product to be packed is enclosed in a slack bag.

This is obtained by setting:

- Heat chamber temperature "tEMP" = OFF.



SEALING AND SHRINKING

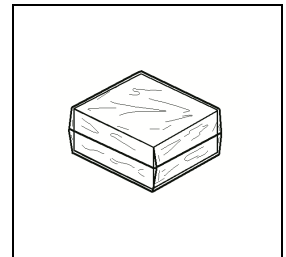
This program seals and shrinks film simultaneously.

Shrinking is produced by the forced circulation of hot air around the the package. Air is heated by passing through a heat element (heat diaphragm).

The product to be packed is enclosed in a bag which perfectly adheres to its shape.

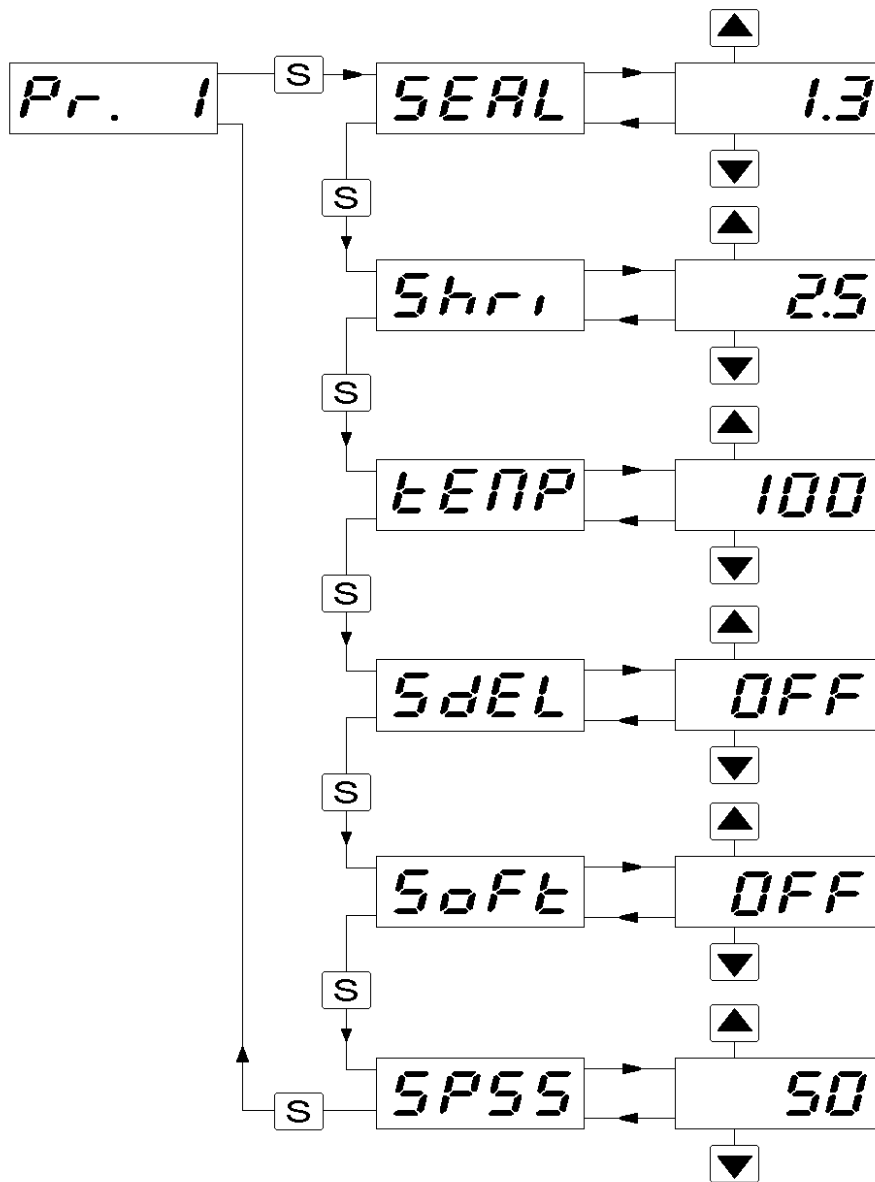
This is obtained by setting:

- Heat chamber temperature "tEMP" = to the desired value,
- Shrinking time "Shri" = to the desired value.



Once the desired program has been selected, press the button (S) to display the program's parameters. The code (flashing) that identifies the first parameter that will be alternated with the set value will appear on the display. If the parameter indicates a function that can be linked to an LED indicator on the panel, said LED will flash to show that a parameter for the linked function is being programmed. Then press (▲) and (▼) to change the value. Once the desired value has been set, press the button (S) again to go to the next parameter and so on until you exit the parameters programming mode indicated by the return of the display to indication of the program selected.

Note: the (▲) and (▼) buttons move at one digit at a time but if they are pressed for more than one second the value increases or decreases quickly.



The operating parameters for each program are:

Parameter	Description	Range	Default
<i>SEAL</i>	Sealing time Time in which film sealing occurs.	OFF / 0,1 ÷ 3,0 sec.	1,3
<i>Shri</i>	Shrinking time Time in which shrinking occurs (operation of the fan).	OFF / 0,1 ÷ 10,0 sec.	2,5
<i>tENP</i>	Heat chamber temperature Temperature that the heat chamber must reach. The indicated value will correspond to: 0 = 0° (the heating element is switched off) 1 ... 150 = 100° ... 398°C (2°C each point)	OFF / 1 ÷ 150	100
<i>SDEL</i>	Fan delay time after sealing Delay time between the end of sealing and the start of shrinking (operation of the fan).	OFF / 0,1 ÷ 1,0 sec.	OFF
<i>Soft</i>	Soft Shrink Reduces the fan speed to the value set in the next parameter "SPSS". To quickly enter/remove the "SoFt" function use the Soft-Shrink (3) button that, when pressed/released, enters/removes the function. If the function is entered the display immediately shows the "SPSS" parameter of the active program which can then be changed. To exit this mode simply start an operating cycle or press the button (S). <u>This function is useful for packaging light products.</u>	OFF - On	OFF
<i>SPSS</i>	Speed Soft Shrink Parameter for adjusting the fan speed.	40 ÷ 100 %	50

PARTIAL CYCLE COUNTER

When the machine is in SELECTION OF PROGRAMS mode, the display shows the program in execution (e.g. "Pr. 1"). In this mode press (*) to enter the "partial cycle counter" function in which the display shows the partial counter value reached.

Press the (*) button again to return to the selection of programs and so on in rotation.

The partial cycle counter increases at each sealing up to a maximum of 9999 cycles (displayed), after which the count is blocked whilst waiting for the reset command.

The partial cycle counter reset command occurs only when you are in the cycle counter mode by pressing the (*) button and keeping it pressed for more than 3 sec.

When the reset command has been given the display will then show "0".

6.1.4. Alarm messages

The electronic board detects series of alarms that are indicated on the display (D) by the following messages:

AL1: Limit switch B1 closed when the machine is switched on.

Possible causes are:

- Machine on and hood down. Lift the hood.
- Limit switch B1 faulty. Check the operation of the limit switch and replace if required.

The machine will not execute the cycle in both cases. It is necessary to open the limit switch contact to cancel signalling.

The alarm will disappear as soon as the contact is opened.

AL2: Temperature not reached.

A possible cause is:

- The working temperature was not reached in the pre-set time (15 min.).

Check that the thermocouple is positioned correctly. Check the heating element.

To reset the alarm, switch the machine off and on again.

AL3: Maximum temperature exceeded.

Possible causes are:

- Thermocouple with broken wires, damaged, or not in contact at the point of attachment on the heat sink.
- Membrane board with relative flat connection, damaged with loss of electrical insulation.
- Shrinking magnet damaged with loss of electrical insulation.
- The electronic component for the control of the heat sink on the power board is faulty.

Take electrical measurements and/or replace the components.

To reset the alarm, switch the machine off and on again.

AL4: Thermocouple interrupted.

To reset the alarm, switch the machine off and on again.

AL5: Sealing blade safety device.

A possible cause is:

- Triac sealing short circuit or mains voltage side sealing open circuit.

To reset the alarm, switch the machine off and on again.

AL6: Chamber safety thermostat tripped due to overheating.

A possible cause is:

- Malfunction of the heat sink temperature control system.

Check that the machine has no faults during operation (strange noises, burning odours, strangely high work temperatures).

Try to manually rearm the safety thermostat under the front panel (disconnect the power to the machine before opening the panel).

AL7: Operator safety.

A possible cause is:

- QM0 relay short circuit.

To reset the alarm, switch the machine off and on again.

AL8: Operator safety.

A possible cause is:

- QM0 relay open circuit.
- Limit switch B1 faulty. Check the operation of the limit switch and replace if required.

To reset the alarm, switch the machine off and on again.

ALL: Hood closed after shrinking.

If the hood remains closed during a shrinking cycle for longer than the pre-set shrinking time, the machine continues the shrinking for a maximum of 10 seconds, after which it stops running.

To reset the alarm, simply open the hood.

EEE: Machine lock.

Contact the technical assistance.

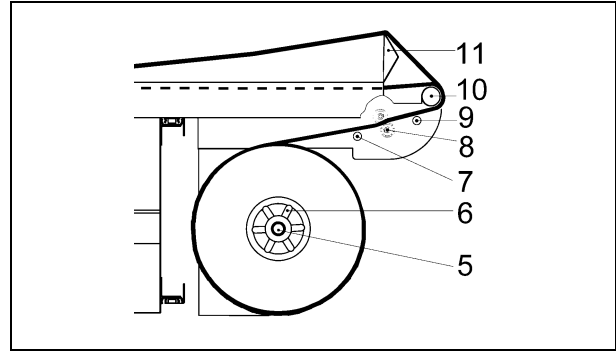
OffL: No communication between the display unit and the power unit.

Contact the technical assistance.

If the alarm remains after having carried out the indicated interventions and controls to restore the machine, contact the technical assistance.

6.2. Film reel insertion

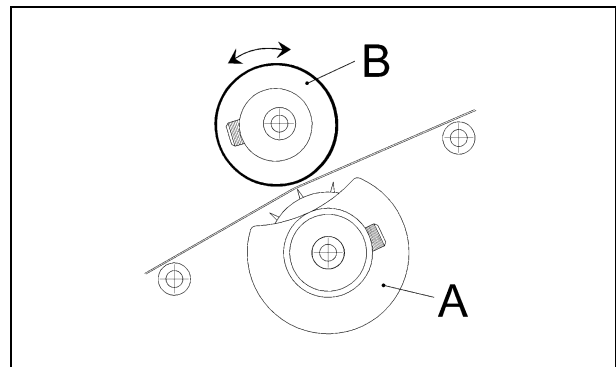
- Insert the reel of film on the roller (5) and lock it with the centring cones (6)
- Position the roller on the film reel support
- Feed the film around the return roller (7)
- Run through the micropunches (8)
- Run the film over the film drive roller (9)
- Feed the film around the return roller (10)
- Run the film lower layer under the packaging plate (11)
- Run the film upper layer over the packaging plate (11).



6.3. Adjustment of the micropunches

The correct position of the micropunches allows optimal shrinking and prevents the packaged packet from tearing along the seal.

For this purpose you can adjust the distance between the micropunch (A) and the contrast (B) by turning said contrast. The film punch becomes more pronounced when this distance is reduced.



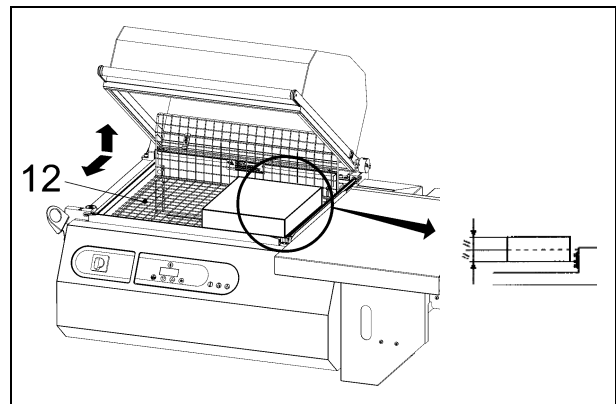
6.4. Reticulated plate installation

The reticulated plate (12) can be placed according to the height of the product to pack.

For a proper packaging the reticulated plate must be positioned so that film sealing is at the half of the package height.

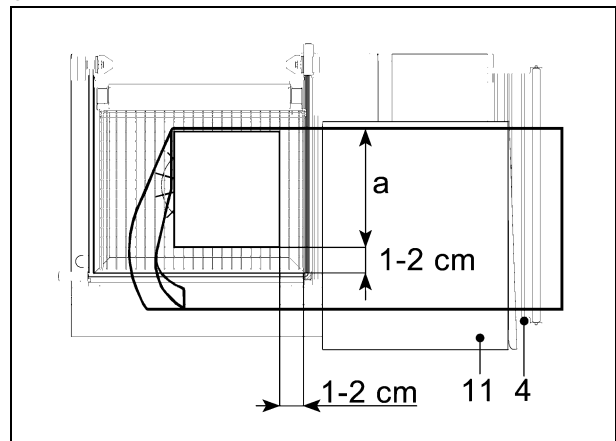
To position it follow this procedure:

- Pull the reticulated plate in direction of the arrows
- Remove it from the stops
- Position the plate on the stops at the required height.



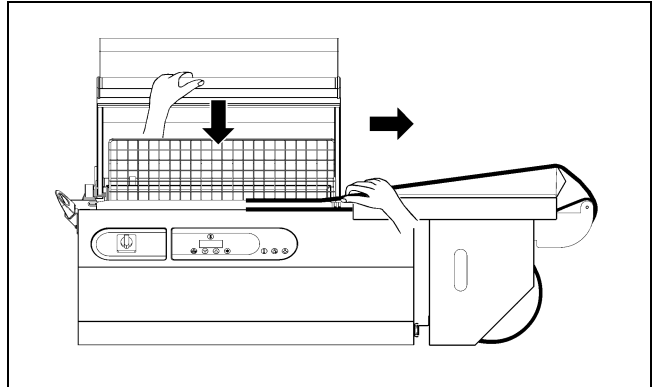
6.5. Reel support and packaging plate adjustment

The reel support (4) and the packaging plate (11) must be adjusted according to the width of the article to be packaged, leaving a space of about 1-2 cm between the article and the welding edge.



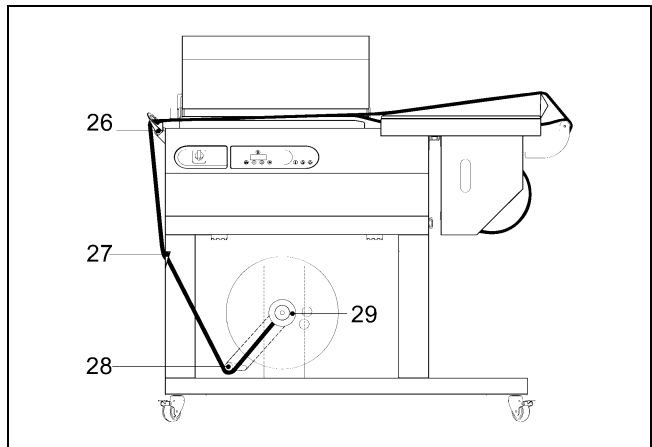
6.6. Making the first seal

Place film as shown in the picture to carry out the 1st seal. Lower the handle of the cover with your left hand and make a pressure of 10-15 kg. Machine will automatically operate and the first seal will be carried out on the side of the film. With the right hand detach the film from the sealing blade.



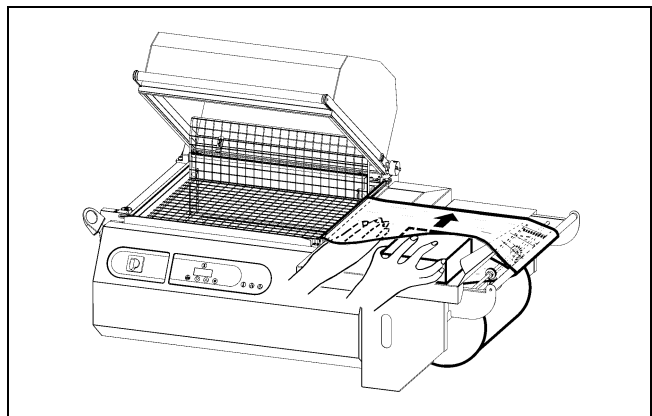
6.7. Film binding on rewriter (if present)

Carry out a number of cycles sufficient to make a strip of scrap film. Guide this film strip around the transmission rollers (26) and (27) and the control roller (28) and bind it to the rewriter (29). The machine is now ready to start packaging.



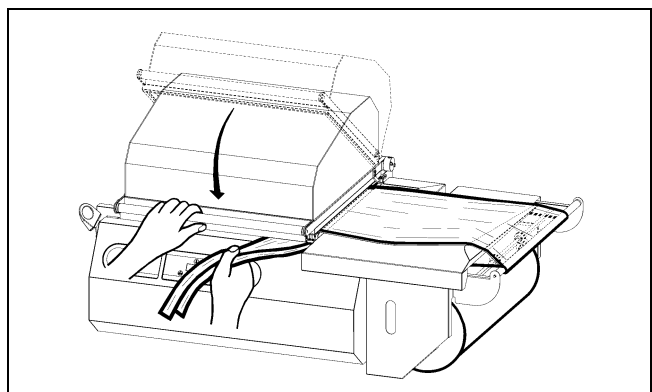
6.8. Introducing the object to be packaged

With the left hand slide on the packaging plate the quantity of film necessary to contain the product to be packed. Introduce the product into the bag using the right hand and make it slide to the left until it is laid on the screen leaving a little space of about 1-2 cm to allow the passage of air for shrinkwrapping.




6.9. Packaging

By pushing the cover handle with a pressure of 15 kg the cover rests on the sealing blade; by pinching the film, it is automatically sealed on the open sides (right and front). If you have set "shrinking" you will see the film shrink around the product. Slightly decrease the pressure on the cover handle to allow film detach from the sealing area on the inside. With the right hand detach the film from the sealing blade towards the outside.



7.1. Instructions for ordinary maintenance work

ORDINARY MAINTENANCE MUST BE CARRIED OUT BY QUALIFIED, APPROPRIATELY TRAINED STAFF.

	<p>Before carrying out maintenance, switch the machine off with the main switch (Q1), disconnect it and wait for the machine to cool down!</p>
---	--

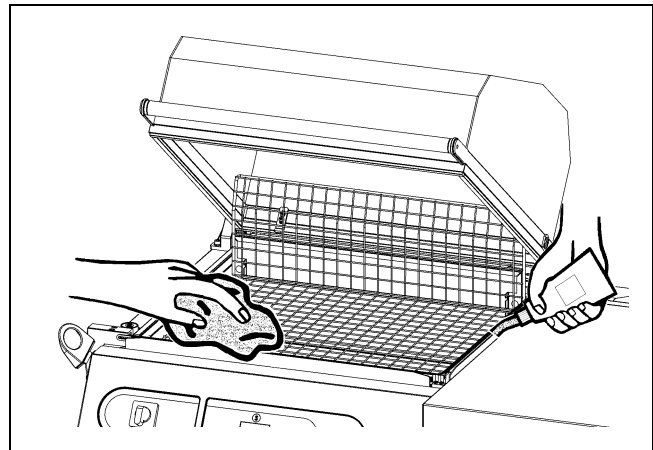
7.2. Maintenance table

The type of machine requires reduced maintenance operations; you must nevertheless stick to the Maintenance plan.

FREQUENCY	COMPONENT	TYPE OF OPERATION
Each day	Machine	Clean the machine with a water dampened cloth.
Each day	Sealing blade	Using a dry cloth, wipe any film residues off the sealing blade.
Each day	Upper hood in Plexiglass	Use only soap and water to clean both the outside and the inside of the Plexiglass hood.
Each day	Lower hood	Use compressed air to remove any film residues from the inside of the hood and in the heat chamber zone.
Each month	Sealing blade	Check that the sealing blade is not worn. Check the wear status of the Teflon and replace if necessary.
Every 3 months	Coolant	Check the level of coolant and top-up if necessary.

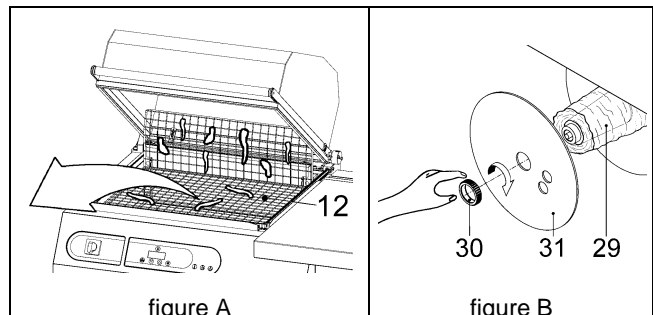
7.3. Sealing blade cleaning

- Using a dry cloth, wipe any film residues off the sealing blade: do this at once after sealing since they are easier to remove when still warm
- For improved cleaning, regularly lubricate the sealing blade with the Teflon non-stick grease supplied with the machine.

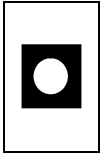


7.4. Plastic film and other scrap removal

- Wait for the machine to cool down completely before removing any scraps stuck to the hot parts of the machine (e.g. , on the flaps of the heat chamber)
- If the lower cover requires cleaning (where the fan is installed), remove the reticulated plate (12) and take out any pieces that may have fallen inside (figure A)
- When the reel on the automatic rewinder (29) is full, remove the film by unscrewing the knob (30) and taking away the disk (31) (figure B).

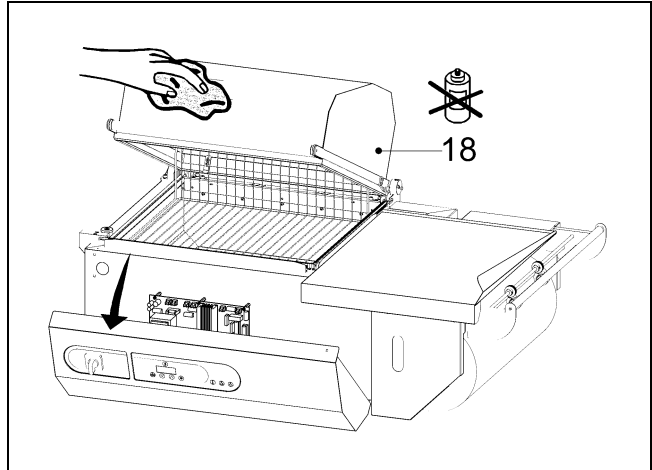


7.5. Machine cleaning



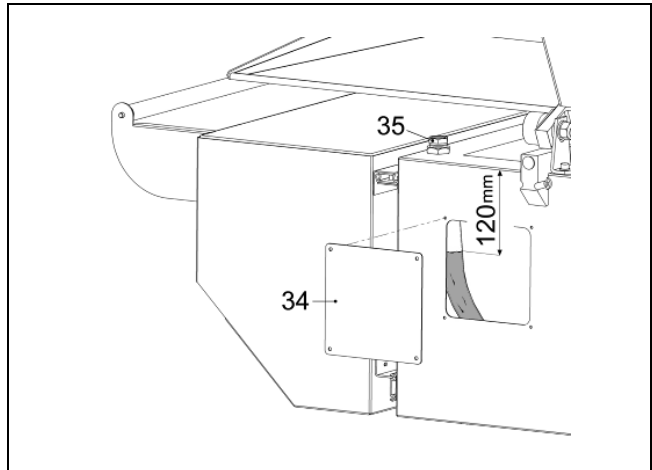
To clean the upper hood (18), clean both the outside and the inside with water and soap only. Do not use any detergents with solvents which could damage the upper hood (18) and reduce the transparency.

- Use a cloth moistened with water to clean the machine
- If the machine works in a dusty environment it is necessary to clean it more frequently inside as well as outside. We especially recommend you vacuum up the dust which settles on the interior electrical components.



7.6. Coolant check (if present)

Check the level of the coolant every 3 months by unscrewing the rear panel (34). Make sure the level of the liquid is not below the indicated measure. Otherwise unscrew the cap (35) and add the mixture of water and antifreeze (10%).



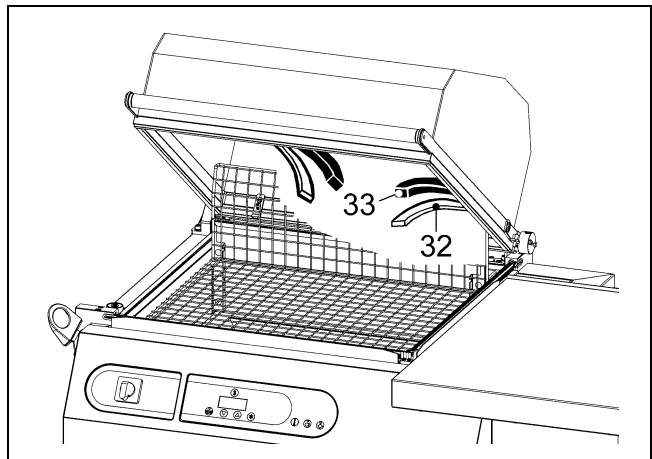
7.7. Substituting the rubber and Teflon

When the Teflon-strikers (32) are worn out, substitute them with spare parts, making sure the application is linear and even.

Before applying the Teflon self-adhesive strip clean the rubber part (33) with a detergent.

If the rubber (33) is also damaged, substitute it as follows:

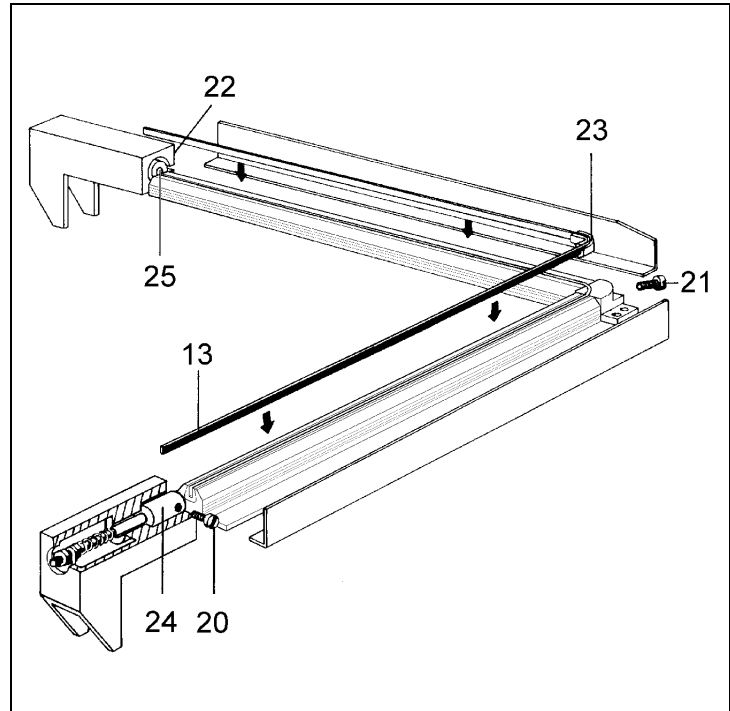
- Remove the old rubber
- Clean its housing
- Insert the new rubber in a linear way
- Clean the rubber with a detergent
- Apply the self-adhesive Teflon-strip.



7.8. Changing the sealing blade

To substitute the sealing blade (13) follow this procedure:

- Switch the machine off with the main switch (Q1), disconnect it and wait for the machine to cool down
- Unscrew the three screws (20), (21), (22)
- Remove the old sealing blade
- Clean the housing and if necessary substitute the insulating Teflon (23) of the central clamp
- Insert the new sealing blade starting from the central clamp and tighten the screw (21)
- Trim the new sealing blade according to the holes of the pistons (24) and (25)
- Complete the insertion if the sealing blade in the whole housing
- Push the rear piston completely (24) towards the sealing blade to make it enter the hole of the piston itself and then tighten screw (22)
- Push the front piston (25) completely towards the sealing blade to make it enter the hole of the piston itself and then tighten screw (20)
- Trim the Teflon projecting from the central clamp
- Make sure that the sealing blade is well positioned and under tension.




7.9. Problem solving

PROBLEM	CAUSE	SOLUTION
The machine seals but it does not shrink.	The head lung's temperature is too low	Increase the set value
	The shrink time parameter "Shri" is set on OFF.	Increase the value (0.1 ÷ 10)
	The chamber temperature parameter "tEMP" is set on OFF.	Increase the value (1 ÷ 150)
	The machine is in heating mode	Wait for the machine to reach the set temperature (Led "L1" switch-off)
	The fan does not turn	The fan's motor is faulty. Contact the after-sales technical assistance.
	The maximum temperature of the heat lung is exceeded. The safety thermostat intervened, disconnecting the heating element.	Contact the after-sales technical assistance.
Shrinking takes place, but it is not even and complete	The film is not suitable or of scarce quality	Replace the film
	The product is too big	The product is bigger than admitted (see paragraph 3.1.)
Shrinking contains "bubbles" (the film does not adhere to the product)	The film is without micro-holes	Make the film properly slide through the micro-holes (see paragraph 6.2.)
	The micropunches are too small	Reduce the distance between the micropunch and the contrast (see paragraph 6.3.)
Sealing opens during shrinking	The sealing blade is dirty or damaged	Clean the sealing blade or replace it if damaged
	Sealing time is incorrect	Adjust the sealing time
	Insufficient hood pressure	Slightly increase pressure on the hood's handle
Sealing is irregular	The film is not suitable or of scarce quality	Replace the film

PROBLEM	CAUSE	SOLUTION
Sealing does not take place	Sealing time is not enough	Increase the set value
	The sealing blade does not receive current	Repair the power supply circuit of the sealing blade. Contact the after-sales technical assistance.
	The Teflon and/or gasket of the cover are worn	Replace the Teflon and/or gasket of the cover
	The sealing blade is damaged	Replace the sealing blade. Contact the after-sales technical assistance.
Fumes present during sealing	Sealing time is long	Decrease the set value
	Residues present on the sealing blade	Clean the sealing blade

If the machine does not work properly after the above-mentioned checks, contact the assistance service describing the detected defect.


7.10. Disassembling, demolition and elimination of residuals

	<p>ATTENTION! All disassembling and demolition operations must be done by qualified personnel with mechanical and electrical expertise required to work in safe conditions.</p>
---	--

Proceed as follows:

- Switch the machine off with the main switch (Q1), disconnect it and wait for the machine to cool down
- Disassemble components.

All wastes must be treated, eliminated or recycled according to their classification and to the procedures in force established by the laws in force in the country where the equipment has been installed.

	<p>The symbol indicates that this product shall not be treated as household waste. By making sure that the product will be properly disposed of, you will facilitate the prevention of potential negative effects for the environment and human health, which might be otherwise caused by the improper waste treatment of this product. For more detailed information about the recycling of this product, please contact the product seller or, as an alternative, the after-sales service or the corresponding waste treatment service.</p>
---	---

8.1. Guarantee conditions

The guarantee runs for 12 months and comes into force on the installation date of the machine. The guarantee covers free replacement or repair of any parts due to defects arising from faulty material. The repairs or replacement are usually carried out at the manufacturer's premises, with transport or labour charged to the buyer. If the repair or replacement is carried out at the buyer's premises, he shall bear the travelling, transfer and labour costs. Work under guarantee can be carried out exclusively by the manufacturer or by the authorised dealer. In order to be entitled to repairs under the guarantee, the faulty part must be sent for repair or replacement to the manufacturer or his authorised dealer. The return of such repaired or replaced part will be considered fulfilment of the guarantee.

The guarantee is voided:

- In case of inappropriate installation, power supply, misuse and mishandling by unauthorised persons
- In case of changes made to the machine without prior agreement in writing from the manufacturer
- If the machine is no longer the property of the first buyer.

The manufacturer declines all liability for personal injury or damage in case of inappropriate installation or connection to the power mains or omission of connection to earth or in case of any mishandling of the machine. The manufacturer undertakes to carry out any variations and changes made necessary by technical and operating requirements.

**IN THE EVENT OF DISPUTES THE COURT OF BERGAMO (ITALY)
SHALL HAVE SOLE JURISDICTION.**



IT	DICHIARAZIONE CE DI CONFORMITA'	EL	ΔΗΛΩΣΗ ΠΙΣΤΟΠΟΙΗΣΗΣ CE
EN	CE DECLARATION OF CONFORMITY	CS	ES PROHLÁŠENÍ O SHODĚ
DE	KONFORMITÄTSERKLÄRUNG	NL	CE GELIJKVORMIGHEIDSVERKLARING
FR	DECLARATION CE DE CONFORMITE'	FI	EY-VAATIMUSTENMUKAISUUSVAKUUTUS
ES	DECLARACIÓN CE DE CONFORMIDAD	RU	ДЕКЛАРАЦИЯ СООТВЕТВИЯ CE
SV	ÖVERENSTÄMMELSEFÖRKLARING EC	한국어	적합성의 CE 선언
PT	DECLARAÇÃO CE DE CONFORMIDADE		

IT	Noi:	SV	Vi:	FI	Me:
EN	We:	PT	Nós:	RU	Мы:
DE	Wir:	EL	Εμείς:	한국어	자사:
FR	Nous:	CS	My:		
ES	Nosotros:	NL	Wij:		

MINIPACK-TORRE S.p.A.
Via Provinciale, 54 – 24044 Dalmine (BG) - Italy

IT dichiariamo sotto la nostra esclusiva responsabilità che il prodotto
 EN declare under our responsibility that the product
 DE erklären unter unserer ausschließlichen Verantwortung, dass das in dieser Erklärung genannte Produkt
 FR déclarons sous notre exclusive responsabilité que le produit
 ES declaramos bajo nuestra exclusiva responsabilidad que el producto
 SV förklarar under eget ansvar, att produkten
 PT declaramos sob a nossa exclusiva responsabilidade que o produto
 EL δηλώνουμε υπεύθυνα ότι το προϊόν
 CS prohlašujeme výhradně na vlastní zodpovědnost, že produkt
 NL verklaren op onze exclusieve verantwoordelijkheid dat het product
 FI vakuutamme yksinomaisella vastuullamme, että tuote
 RU под нашу исключительную ответственность заявляем, что данное изделие
 한국어 자사의 독점적인 책임 하에 다음을 선언합니다. 제품

IT	MACCHINA CONFEZIONATRICE TIPO:	SV	PACKNINGSMASKIN TYP:	FI	PAKKAUSKONE TYYPPI:
EN	PACKAGING MACHINE MODEL:	PT	MÁQUINA CONFECCIONADORA TIPO:	RU	УПАКОВОЧНАЯ МАШИНА ТИПА:
DE	VERPACKUNGSMASCHINE TYP:	EL	ΜΗΧΑΝΗ ΣΥΣΚΕΥΑΣΙΑΣ ΤΥΠΟΥ:	한국어	포장 기계 유형:
FR	MACHINE D'EMBALLAGE MODELE:	CS	BALICI SROJ MODEL:		
ES	MÁQUINA CONFECCIONADORA TIPO:	NL	VERPAKKINGSMACHINE TYPE:		

<input type="checkbox"/>	FM75 evo	n°	/
<input type="checkbox"/>	FM76 evo	n°	/
<input type="checkbox"/>	Replay 40 evo	n°	/
<input type="checkbox"/>	Replay 55 evo	n°	/


IT è conforme ai requisiti essenziali di sicurezza e a tutte le disposizioni pertinenti delle direttive applicabili
 EN conforms to the essential safety requirements and all the provisions of the applicable directives
 DE entspricht den grundlegenden Sicherheitsanforderungen und allen betreffenden Bestimmungen der einschlägigen Richtlinien
 FR est conforme aux exigences essentielles de sécurité et à toutes les dispositions pertinentes des directives applicables
 ES cumple los requisitos fundamentales de seguridad y todas las normas pertinentes de las directivas aplicables
 SV uppfyller de väsentliga säkerhetskraven och relevanta bestämmelser i gällande direktiv
 PT é conforme os requisitos essenciais de segurança e a todas as disposições pertinentes das directivas aplicáveis
 EL συμμορφώνεται με τις βασικές απαιτήσεις ασφαλείας και όλες τις συναφείς διατάξεις των εφαρμοσίμων οδηγιών
 CS splňuje základní požadavky na bezpečnost a všechna příslušná ustanovení platných směrnic
 NL conform is met de essentiële veiligheidsvereisten en met alle pertinente bepalingen van de richtlijnen die van toepassing zijn
 FI vastaa kaikkia olennaisia turvallisuutta koskevia vaatimuksia ja kaikkia sovellettavien direktiivien asiaa koskevia määräyksiä
 RU соответствует основным требованиям безопасности и всем соответствующим положениям в действующих директивах
 한국어 은 필수 안전 요구사항들과 적용할 수 있는 지침들의 관련된 모든 규정을 준수합니다

2006/42/CE, 2014/30/UE, 2014/35/UE

IT E inoltre dichiariamo che sono state applicate le seguenti norme armonizzate
 EN And furthermore we declare that the following rules have been applied
 DE außerdem bestätigen wir, dass folgende harmonisierte Richtlinien angewendet wurden
 FR Nous déclarons également que les normes harmonisées suivantes ont été appliquées
 ES Además declaramos que han sido aplicadas las siguientes normas armonizadas
 SV Dessutom förklarar vi, att följande harmoniserade normer har använts
 PT E, além disso, declaramos que foram aplicadas as seguintes normas harmonizadas
 EL Επίσης δηλώνουμε ότι εφαρμόστηκαν οι εξής εναρμονισμένες προδιαγραφές
 CS A kromě toho prohlašujeme, že byly aplikované následující harmonizované normy
 NL We verklaren bovendien dat de volgende geharmoniseerde normen toegepast
 FI Tämän lisäksi vakuutamme, että olemme soveltaneet seuraavia yhdenmukaistettuja standardeja
 RU Также мы заявляем, что были применены следующие согласованные нормативы
 한국어 또한 일치되는 다음 규범들이 적용되었음을 선언합니다

EN 12100:2010, EN 61000-6-3:2007, EN 61000-6-1:2007, EN 60335-1:2013

IT Persona autorizzata a costituire il Fascicolo Tecnico: Responsabile Ufficio Tecnico
 EN Person authorized to draft the Technical File: Head of the Technical Dept
 DE Zur Erstellung des Technischen Merkhefts befugte Person: Verantwortlicher der Technischen Abteilung
 FR Personne autorisée à constituer le Fascicule Technique : Responsable Bureau Technique
 ES Persona autorizada a elaborar el Fascículo Técnico: Responsable del Departamento Técnico
 SV Person med behörighet att skapa den Tekniska Dokumentationen: Tekniskt ansvarig
 PT Pessoa autorizada a compilar o Processo Técnico: Responsável pelo Gabinete Técnico
 EL Άτομο εξουσιοδοτημένο να καταρτίσει το Τεχνικό Τεύχος: Υπεύθυνος Τεχνικού Γραφείου
 CS Osoba autorizovaná k vystavení Technické dokumentace: Vedoucí technického oddělení
 NL Persoon bevoegd om het technisch dossier op te stellen: Verantwoordelijke technische dienst
 FI Teknisten asiakirjojen laatimiseen valtuutettu henkilö: Teknisen toimiston vastuuhenkilö
 RU Лицо, уполномоченное для составления технического файла: начальник технического отдела
 한국어 기술 파일을 제조하도록 공인된 인력: 공식 기술 책임자

Dalmine, 

IT	Consigliere Delegato	SV	Verkställande Direktör	FI	Toimitusjohtaja
EN	Managing Director	PT	Conselheiro Delegado	RU	Управляющий директор
DE	Geschäftsführer	EL	Ο Διευθύνων Σύμβουλος	한국어	대표 이사
FR	Directeur Général	CS	Generální ředitel		
ES	Consejero Delegado	NL	Gedelegeerd bestuurder		