

# ES – 32

## Heat Seal Machine



Texas Automation Products, Inc.  
300 Nichols Drive  
Hutchins, TX 75141

## **About This Manual**

This manual contains information on how to install and operate the ES-32 pneumatic heat seal machine. It provides an overview of the machine, conversion charts to calculate the correct air pressure and electrical requirements, and step-by-step instructions to operate the ES-32.

## **Replacement Parts and Technical Assistance**

For replacement parts or technical assistance, please contact:

**Texas Automation Products, Inc.**  
**300 Nichols Drive**  
**Hutchins, TX 75141**  
**972-288-5000**  
**800-872-1960**  
**Fax 972-288-6022**  
**[info@texasautomationproducts.com](mailto:info@texasautomationproducts.com)**

Please have your model and serial number when calling for service.

## **Warranty**

This machine is fully warranted against defects in workmanship and material for 1 year from the date of purchase. Platen covers are excluded from warranty.

## Requirements

1. Air – 25 PSI minimum / 120 PSI maximum
2. Electrical Requirements – 120v A.C. / 60 Cycle

| POWER CONSUMPTION        |       |      |
|--------------------------|-------|------|
| PLATEN SIZE              | WATTS | AMPS |
| 2" x 4"                  | 600   | 5    |
| 3" x 5"                  | 800   | 7    |
| 4" x 6"                  | 880   | 7.3  |
| 5" x 6"                  | 1680  | 14   |
| 3 ¼" x 5" Extended Anvil | 440   | 3.7  |

## Installation

1. Connect air supply to 1/8" NPT inlet located in back of the Air Filter / Regulator that is attached to the right side of the machine.
2. Plug in electrical cord to properly fused and grounded receptacle.

## Operation

1. Set Air Regulator at required gauge pressure: 25 PSI minimum / 120 PSI maximum. To adjust regulator, pull up and turn black knob. Clockwise increases pressure, counter-clockwise decreases pressure. When pressure is set, push down black knob to lock. See *table A-1* to convert gauge pressure to total interplaten pressure and pounds of pressure per square inch on platen surface.
2. Check Air Filter Bowl located beneath Air Regulator and Gauge. If water is visible in bowl, drain moisture by turning shaft, located on the bottom of the bowl, counter-clockwise.
3. Flip power switch located on lower left side of machine to "ON". Green light on control panel indicates power is "ON".
4. Set top and bottom platen temperature controls located on right side of control panel to desired setting. Allow 10 minutes for platens to heat up. While platens are heating, their corresponding red light on the control panel will remain on. When platens reach desired temperature the red light will turn off momentarily. As the temperature controllers phase on and off to maintain desired platen temperature, the red lights will phase on and off also. Platen heat can be turned off individually by turning knob counter-clockwise until it clicks.
5. Set Timer Control located on lower left of control panel to desired cycle dwell time. This time setting will repeat each press cycle until changed.

6. To actuate press, depress both black pushbuttons labeled “Start Cycle” located on the sides of the machine simultaneously. When press cycle is in progress, the amber light on the control panel will turn on and remain on for all but the last two seconds of the timing cycle. At that time the amber light will go into a blinking mode to alert the operator that the press cycle is nearly complete.
7. To immediately open the press, push the red “Emergency Release” pushbutton located on the upper left side of the control panel. Also, the press should open immediately if the power switch is turned “OFF” or if the machine power cord is unplugged.

| CONVERSION TABLE |                             |                         |                         |                         |                         |                                          |
|------------------|-----------------------------|-------------------------|-------------------------|-------------------------|-------------------------|------------------------------------------|
| GAUGE PRESSURE   | TOTAL INTER-PLATEN PRESSURE | LBS. PSI 2" x 4" PLATEN | LBS. PSI 3" x 5" PLATEN | LBS. PSI 4" x 6" PLATEN | LBS. PSI 5" x 6" PLATEN | LBS. PSI 3 ¼" x 5" EXTENDED ANVIL PLATEN |
| 25               | 177                         | 22.1                    | 11.8                    | 7.4                     | 5.9                     | 10.9                                     |
| 30               | 212                         | 26.5                    | 14.1                    | 8.8                     | 7.1                     | 13.0                                     |
| 35               | 247                         | 30.9                    | 16.5                    | 10.3                    | 8.2                     | 15.2                                     |
| 40               | 283                         | 35.4                    | 18.9                    | 11.8                    | 9.4                     | 17.4                                     |
| 45               | 318                         | 39.8                    | 21.2                    | 13.2                    | 10.6                    | 19.6                                     |
| 50               | 353                         | 44.1                    | 23.5                    | 14.7                    | 11.8                    | 21.7                                     |
| 55               | 389                         | 48.6                    | 25.9                    | 16.2                    | 13.0                    | 23.9                                     |
| 60               | 424                         | 53.0                    | 28.3                    | 17.7                    | 14.1                    | 26.1                                     |
| 65               | 459                         | 57.4                    | 30.6                    | 19.1                    | 15.3                    | 28.2                                     |
| 70               | 495                         | 61.9                    | 33.0                    | 20.6                    | 16.5                    | 30.5                                     |
| 75               | 530                         | 66.2                    | 35.3                    | 22.1                    | 17.7                    | 32.6                                     |
| 80               | 565                         | 70.6                    | 37.7                    | 23.5                    | 18.8                    | 34.8                                     |
| 85               | 601                         | 75.1                    | 40.1                    | 25.0                    | 20.0                    | 37.0                                     |
| 90               | 636                         | 79.5                    | 42.4                    | 26.5                    | 21.2                    | 39.1                                     |
| 95               | 672                         | 84.0                    | 44.8                    | 28.0                    | 22.4                    | 41.4                                     |
| 100              | 707                         | 88.4                    | 47.1                    | 29.5                    | 23.6                    | 43.5                                     |
| 105              | 742                         | 92.7                    | 49.5                    | 30.9                    | 24.7                    | 45.7                                     |
| 110              | 778                         | 97.2                    | 51.9                    | 32.4                    | 25.9                    | 47.9                                     |
| 115              | 813                         | 101.6                   | 54.2                    | 33.9                    | 27.1                    | 50.0                                     |
| 120              | 848                         | 106.0                   | 56.5                    | 35.3                    | 28.3                    | 52.2                                     |

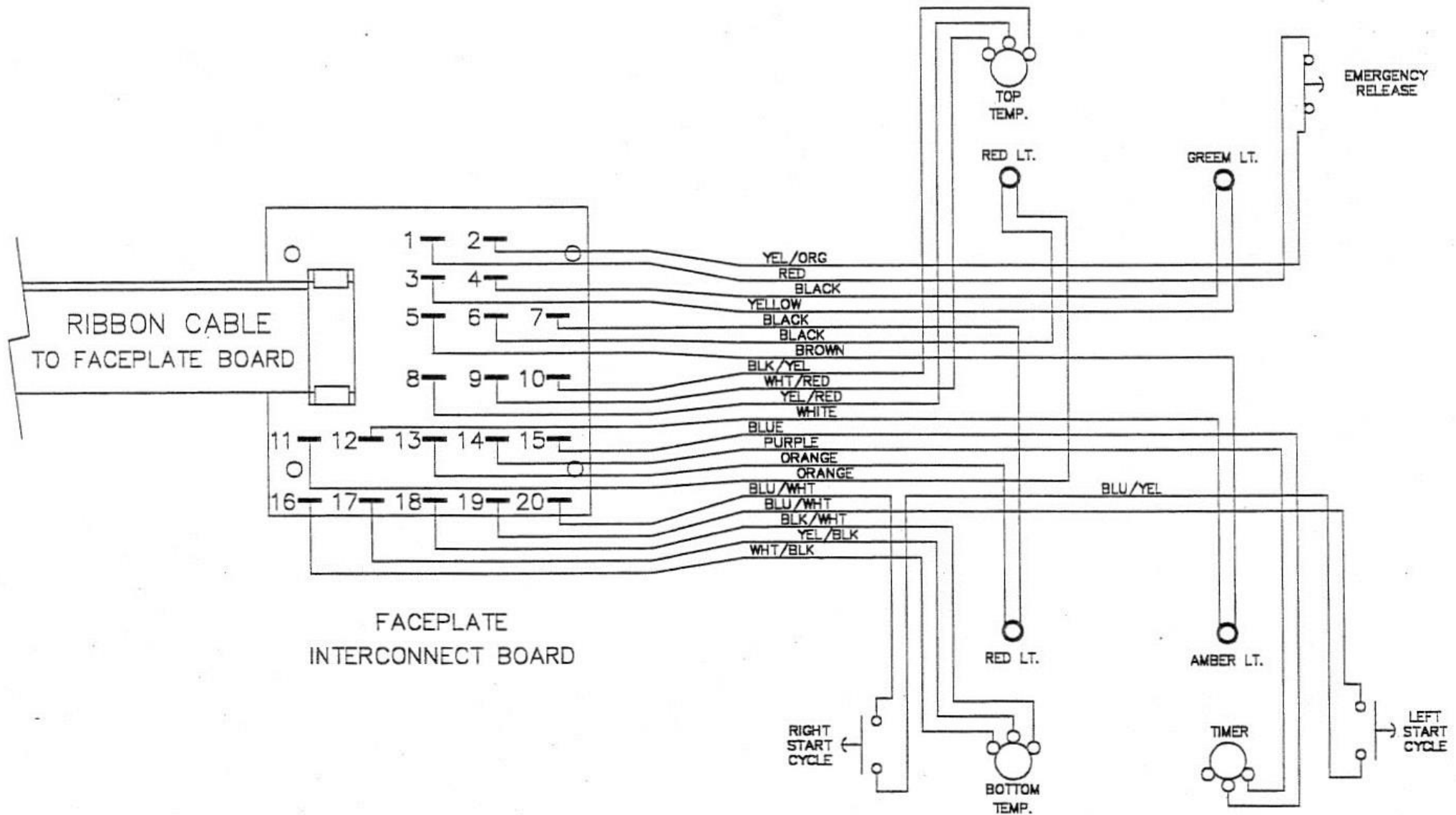
Table A-1

## Maintenance

- Drain moisture trap on Air Filter / Regulator as often as necessary.
- Check sponge and teflon. Replace if needed.

# MODEL ES-30 and MODEL ES-32

## FACEPLATE SCHEMATIC



## MACHINE BASE SCHEMATIC

