

Dear user,

Thank you for buying PRS series rollstock machine.

Before operating the machine you must study and familiarize yourself with this Installation and User Manual for your PRS series rollstock machine.

You can use bookmarks pane / 'table of content' to access different sections of this manual. No matter where you are in this manual you can always go back to table of content just by clicking at top right corner of any page.



We hope you'd find this publication helpful. However, after consulting this manual you still find something not covering the particular question/issue, you can always contact us through the details at this page.



Your PRS Configuration Details:

Model: 420M with 240 Advance.

Rotary: 3 Rotary Blades.

Number of Dies: 2 Forming & 2 Sealing Standard Die Sets (1x2 UP, 1x4UP).

Vacuum Pump: Busch 63.

Machine Interface: Fixed 7" Color HMI.

Printer: NO.

Chiller: NO.

Trim Winder: Yes (Motorized).

Other: Stainless Steel Grommets, Larger Safety Covers, High Flow Valve for Forming, 2-Piece Outer Cover, Rotary Blades Made of Single Piece Metal, Pneumatic Brakes for Forming & Sealing Racks.

Electric: 220V 60 Hz 3Phase. (With Safety Relays)

Guillotine/Cross Cutter: 2 Sets.

Vacuum Valve: Solenoid (With Gas Fluch Option)

Photoelectric Sensor: Yes.

Transport Chain: Stainless Steel with Servo.

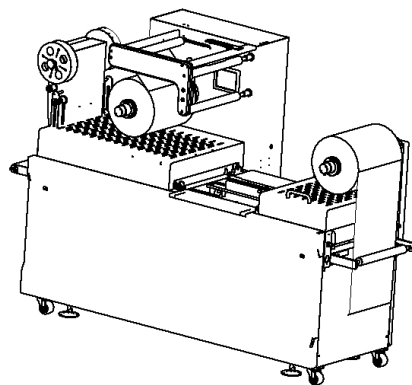
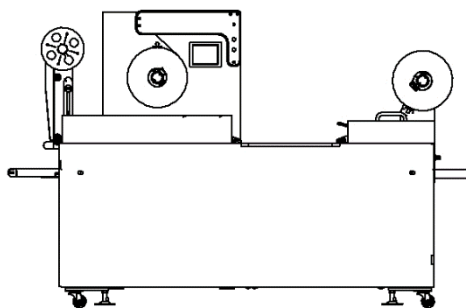
Exit System: Motorized Exit Conveyor.

Installation and User Manual

PRS Series Rollstock

Model: 420M-240

CE
REPORT
No.02-SKM-
CM-121



NOTE

**This manual should be retained for future reference.
Store it close to the machine for quick and easy reference.**

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TRADEMARKS



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1. Disclaimer

WARNING: YOUR RESPONSIBILITY

This machine should only be operated by qualified staff that can read, understand and respect warnings and instructions mentioned about this machine in this user manual. Doing so otherwise can cause serious machine malfunction, serious or even fatal personal injury and even death. Save this user manual for future reference.

Document Revisions:

Date	Version Number	Document Changes
Oct. 15, 2021	2.0	

Distribution:

This document has been distributed to:

Name	Title
Promarksvac	

1.1 Changes not covered in the manual

We continuously add newer functions / made improvements to our PRS series machines to ensure that our machines are technically advanced and of high quality. For this reason, you may discover slight deviations between the specifications in the manual and your machine. We also cannot rule out errors. The specifications, figures and descriptions in this manual do not constitute a legal contract between the manufacturer and customer.

2. Warning:

IMPORTANT NOTICE

This manual should be retained for future reference. Store it close to machine for easy accessibility.

The points listed below indicate precautions that the user must be aware of in order to safely operate this equipment. Failure to follow these precautions can result in serious or possibly fatal injury as well as possible damage to the equipment. The symbols shown here in this user manual and on machine indicate the presence of a potentially hazardous condition which if not avoided, could result in serious personal injury or even death.

- Read and understand all of the instructions in this manual before starting this equipment. Keep this manual in a safe place for further reference and for ordering parts.
- Only allow responsible individuals familiar with the operating instructions to operate this machine. Be sure that they understand the controls and how to stop the machine quickly.
- Never put your hands near any moving parts.
- Only allow qualified individuals to perform maintenance on the machine.
- Remove all obstacles that may interfere with the machine's functions.
- Clear the work area of all obstacles before beginning production.
- Be sure that all other personnel are clear of your work area before operating the machine.
- Do not sit or stand on the machine.
- Always turn off the machine when your work is completed. Never leave a running machine unattended.
- Always disconnect, lock out / tag out and wait for the machine to cool before attempting any maintenance.
- Do not wear any loose fitting clothes or jewelry as they may become caught in the machine's moving parts.

Continued to next page

- Work only in good natural or artificial light.
- Do not operate the machine under the influence of alcohol or drugs.
- Always turn off all power, including the main power supply, before carrying out the required daily inspection. Performing the inspection with the power connected may result in electrical shock.
- Do not touch any of the electrical control components while the power is turned on as this may result in electric shock or machine malfunction.
- Do not damage cables, pinch them or subject them to excessive stress as this may result in electrical shock.
- Never modify the machine.

2.1 SERVICE POINTS

- ✓ Always use proper containers when draining the oil.
- ✓ Do not use food or beverage containers as this may mislead someone into drinking the contents.
- ✓ Properly dispose of the containers or store them in a safe place immediately after draining the oil.
- ✓ Prior to disposal, determine the proper method of disposal of this type of waste by calling the local office of the Environmental Protection Agency.

2.2 Authorized Technician / Qualified Installation Technician

All installation and / or service on your PRS must be performed by qualified, certified and / or authorized installation or technical service personnel. All electrical, gas and plumbing connections must be made by authorized technicians and in compliance with all the respective safety requirements and adherence to local building codes.

DEFINITIONS:

AUTHORIZED TECHNICIAN / QUALIFIED INSTALLATION TECHNICIAN:

- A qualified installation technician can be: an individual, a company or a corporation that is involved and responsible for:

Continued to next page

- The installation of electrical wiring from the main electrical meter, main control box or from the service outlet of an electrical appliance.
- A qualified technician must be experienced and be familiar with all of the precautions, safety requirements and local building codes.

The appliance once installed must be properly grounded in accordance with local codes or in the absence of local codes then in accordance with the electrical diagrams provided with your PRS machine.

3. Safety

Please read and follow the safety guidelines and recommendations provided in this manual, and practice good safety habits. The possible consequences of failure to observe these guidelines could result in property damage, bodily injury, or death.

3.1 GENERAL SAFETY

- ✓ Press any of the four “EMERGENCY STOP” push buttons when there is any danger or abnormal condition on the machine.
- ✓ Before performing any work/repairs in that area or on the machine in general, remember to turn off the mains / disconnect power, turn the machine’s main switch to “OFF” position and lock it in this position.
- ✓ Prior to performing any work in a danger area, shut off the compressed air supply to the machine. Only authorized personnel should perform repairs on this machine.
- ✓ Only properly trained employees can operate this machine
- ✓ All safety devices must be used properly and maintained properly to keep them operational.
- ✓ Never operate the machine without the safety covers in place

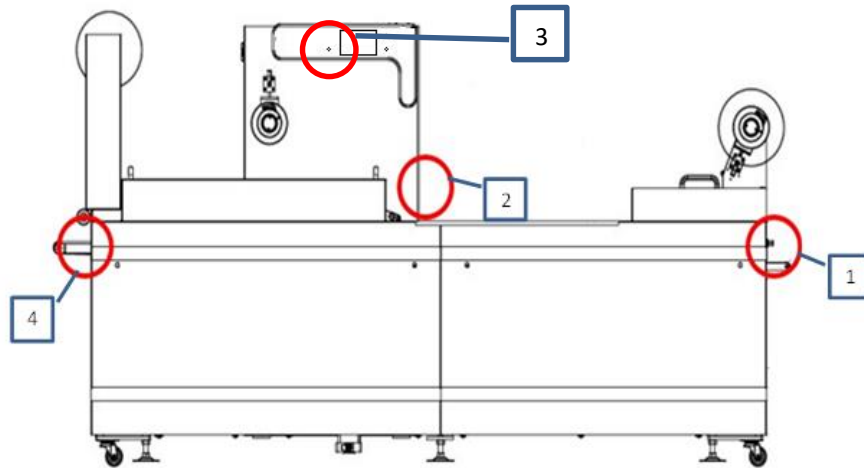
**MAINS / POWER
DISCONNECT SWITCH
LOCATION**



Fig. Safety-1

Continued to next page

Your PRS machine is equipped with **four** emergency stops, #1 at the bottom film loading area, #2 on the main electrical panel, #3 on the HMI box/next to HMI, and #4 at the output side of the machine.



IMPORTANT!

1 - The electricity supply and air supply to the machine is not cut off when any of the emergency stop buttons is pressed.

2 - In "Maintenance" mode all safeties are turned off.

4. Compressed Air

- For standard PRS (PRS 320 / 420) the air consumption is 35 liters per cycle.

For example, 6 cycles per minute you will need $6 \times 35L = 210$ Liters per minute.

More cycles you run per minute, more air flow per minute is required.

- Minimum air pressure of 90psi is required for operation.

5. Extreme Caution Areas

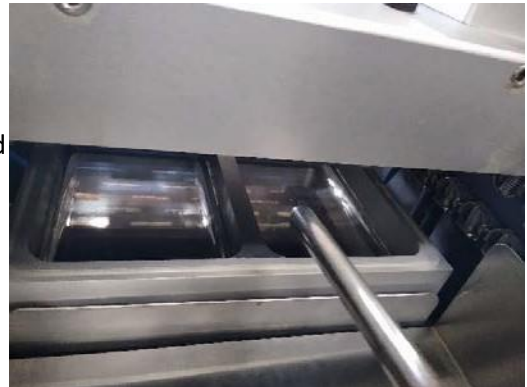
DIE SCISSOR / LIFTING MECHANISM

The die lifting mechanism is made of moving parts that operate at high pneumatic pressure. Never reach inside the scissor mechanism without first turning off the electrical power and shutting off the main air pressure.



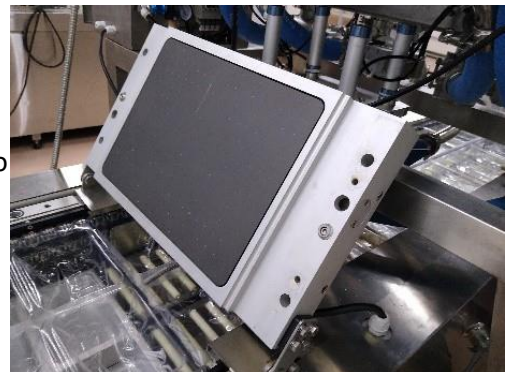
DIE SAFETY

The forming and sealing die have parts hidden from normal view. These parts can crush and amputate fingers if caught between the forming or sealing head and the die. Never place your hand or any part of your body under the heads of the machine without first turning off the electrical power and shutting off the main air pressure. Never remove or bypass the guards on the machine.



HOT SURFACES

Both the forming and sealing heads use heater elements to form and seal the film. Heating plates can reach high temperatures and can cause severe burns to the skin. Always allow the die sets to cool down before working inside the forming or sealing area, or when making die changes. Even after shutdown of the machine, these areas can be extremely hot. Wear protective gloves when handling this parts without a cooling period.



Continue to the next page

GILLOTINE / CROSS CUTTERS

The guillotine cuts across the full width of the film with a pneumatic cylinder going up at high speed and great force. The serrated blade can severely cut or amputate fingers, hand or any part place between the blade and the blade support. Never place your hand or any part of your body in the guillotine area without first turning off the electrical power and shutting off the main air pressure. Never remove or bypass the guards on the machine.



ROTARY BLADES / CIRCULAR CUTTERS

The rotary blades run at high speed to cut and separate the packages lengthwise. The blades can start intermittently when the machine is running. These blades are extremely sharp and can cut or amputate parts of the body. Never place your hand or any part of your body in the rotary blade area without first turning off the electrical power and shutting off the main air pressure. Never remove or bypass the guards on the machine. Do not reach under the safety guards while the machine is running.



FILM INFEEED

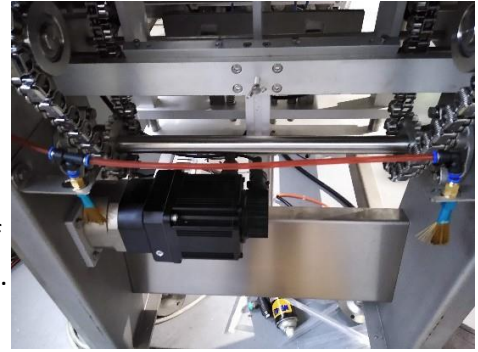
The film infeed sprockets can grip clothing, and through mere skin contact force an arm or hand into a dangerous position. Injuries due to contact with rotating parts can be severe. Do not wear any loose clothing or jewelry. Use safe lifting techniques to place the film reels into place



Continue to the next page

SERVO MOTOR

The servo motor area sprockets can grip clothing, and through mere skin contact force an arm or hand into a dangerous position. Injuries due to contact with rotating parts can be severe. Never place your hand or any part of your body in the rotary blade area without first turning off the electrical power and shutting off the main air pressure. Never remove or bypass the guards on the machine. Do not reach under the safety guards while the machine is running.



6. Intended use

This machine is a technical piece of equipment to be used exclusively for production purposes. Use the machine only to package products in film-covered packs. Mono or composite films on rolls serve as the packaging material. The forming, filling and sealing of the packs occurs on the machine.

Any other use is considered improper and can endanger persons, the product and the machine.

6.1 EMC - Electromagnetic compatibility

The machine is designed for industrial use (with a separate power station). For use in residential, business and commercial areas, additional fault clearance measures for EMC must be taken. For this, consultation with the proper concerned governing body is necessary.

6.2 Predictable incorrect use

The following work methods are not in accordance with regulations and therefore are prohibited:

- Operating in an atmosphere capable of explosion.
- Packing of highly flammable or combustible products.
- Packing of dust-forming or powdery material.
- Gas flushing of film pouches with explosive gas mixtures (e.g. oxygen proportion over 21 %).
- Aseptic packing of products.

6.3 Incorrect use

- Incorrect use examples:

Sealing times that are too short or too long and therefore resulting in improperly sealed packs which in turn damage the product.

- Neglecting to do the necessary routine work such as:
Inspections, Cleaning work, Maintenance work.
- Use of third-party parts, i.e. parts that are not genuine Promarksvac / Promax spare parts.
- Operation under impermissible environmental conditions.

Continue to the next page

6.4 Other risks

The safety instructions in this manual serve as guidelines for trained machine operators so that they can work safely with the machine.

The manufacturer cannot however foresee all possible product- related hazards. This is why the safety instructions and warnings on the machine and in this manual cannot be considered exhaustive.

The operating company and machine operators are ultimately responsible for the safety.

6.5 Operating company' obligations

The machine and operating materials are a potential source of hazards. The operating company is required to draw up a directive that explains how to handle dangerous machines or operating supplies. The required information can be found in the following documents:

- ✧ The EC directives for occupational safety.
- ✧ National legislation.
- ✧ Accident prevention regulations.
- ✧ This manual.
- ✧ The operating company is also responsible for issuing directives for conduct in emergencies.
- ✧ The operating company is required continuously to monitor the technical condition of the entire machine, for example:
 - ✧ Visible defects or damage
 - ✧ Changes in the operating behavior

DO NOT start up the machine if there are visible defects!

7. Safety/Caution Labels

ON EACH PRS YOU WILL FIND THE FOLLOWING LABELS (NOT TO SCALE) THESE LABELS SHOULD NEVER BE REMOVED AND SHOULD BE REPLACED IF THEY BECOME UNREADABLE. PROMARKSVAC CAN SUPPLY REPLACEMENTS.



This symbol indicates that an ELECTRICAL SHOCK HAZARD condition exists. DO NOT TOUCH any of the electrical connection terminals when the machine' power is on. This precautionary symbol appears on labels attached to the PRS to alert the user to conditions requiring concern for safety.

Continued to next page



This symbol indicates that a **HAND CRUSH HAZARD** condition exists. Always keep your hands clear of this area and follow all lock out / tag out procedures before any service work is started. Labels with this symbol are attached to your PRS to alert the user to conditions requiring concern for safety.



This symbol indicates that a **HAND STUCK HAZARD** condition exists. Always keep your hands clear of this area and follow all lock out / tag out procedures before any service work is started. Labels with this symbol are attached to your PRS to alert the user to conditions requiring a concern for safety.

Continued to next page



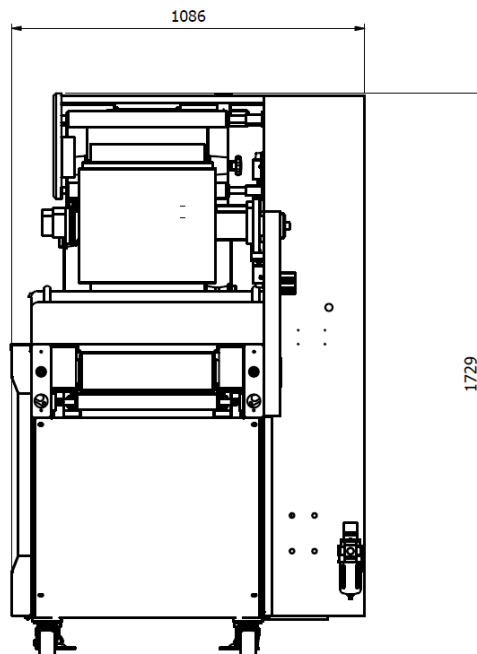
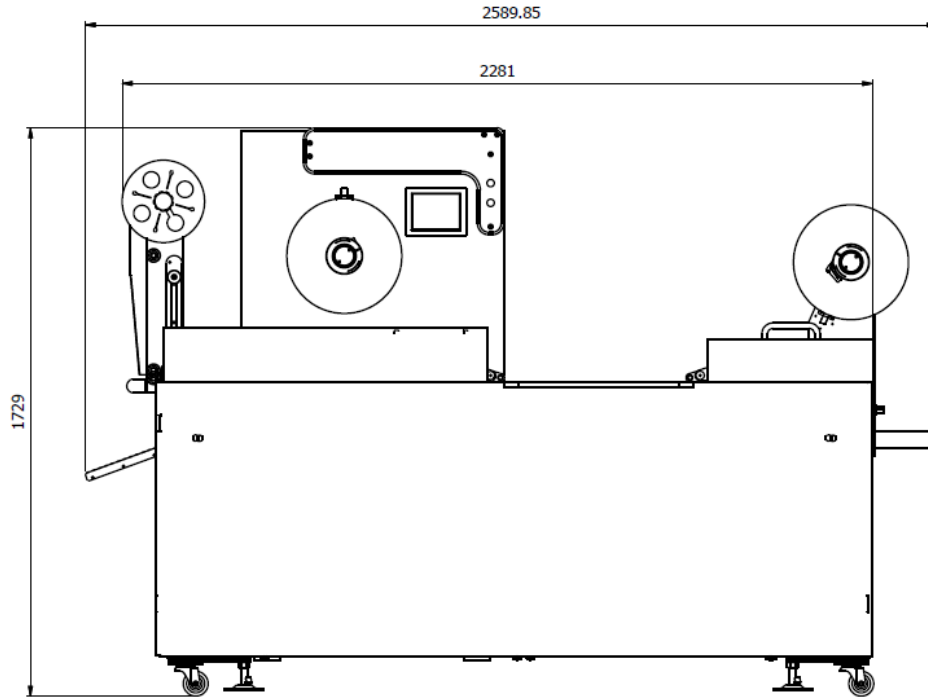
This symbol indicates that a MOVING BLADE HAZARD condition exists. Always keep your hands clear of this area and follow all lock out / tag out procedures before any service work is started. Labels with this symbol are attached to your PRS to alert the user to conditions requiring a concern for safety.



This symbol indicates that a HOT SURFACE HAZARD condition exists. Always keep your hands clear of this area and follow all lock out / tag out procedures before any service work is started. Labels with this symbol are attached to your PRS to alert the user to conditions requiring a concern for safety.

8. Specification & Installation

8.1 YOUR PRS' OVERALL DIMENSIONS



All measurements are in mm.

9. Installation Requirements

Improper installation, adjustments, alterations, service or maintenance could result in damage, injury or even death.

Prior to the installation of your new PRS, you should make sure that:

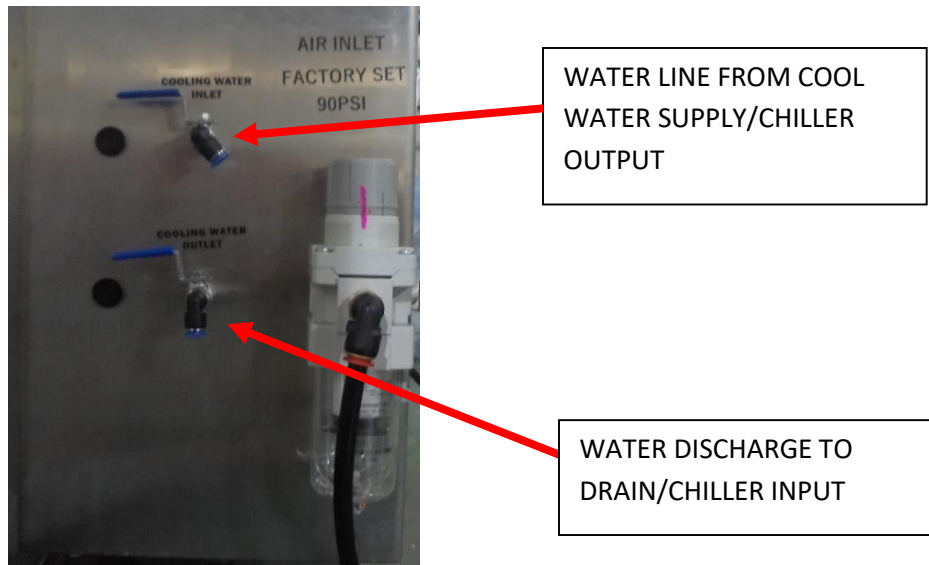
- You have a clear path within your building to the desired location that takes into account the overall dimensions of your PRS-420 as shown in ‘specification & installation’ on page 23.
- A qualified technician will be in charge of the installation and first start up.
- The conditions required for the start-up of the machine is already in place.
- The positioning of the machine must allow for proper accessibility for maintenance and operation. Before choosing the site for your new PRS machine, please consider that you also need room for both packaged and non-packaged product in addition to the space required for the machine itself. Below are the clearances we suggest:
 1. 36” of clearance minimum on both sides for workers
 2. 33” of clearance minimum between the electrical box door and the wall.
 3. 24” of clearance minimum between the back of the machine and the wall.
- Leveling of the machine is accomplished using a level and the adjusting the machine’s feet. Make sure to lock each foot using the locknut after completing the leveling procedure. Use the sealing and forming heads as reference for leveling.
- Maximum ambient temperature 35 degrees C and no freezing. The machine must be distanced from any heat generating devices and must be indoors.

Continued to next page

10. Connections

The machine must be supplied the following:

- **Electrical:** 220V/3PH/60HZ @ 50AMPS with a disconnect switch in close proximity to machine's main electrical housing.
 - **Compressed Air:** 3/4" to 1" air line with compressed air shut-off valve. 20 SCFM@90-100 PSI. The operating pressure is 90 PSI. Filter element 25 microns (to be fitted by customer) and moisture content max 7 g/m³.
 - **Cooling Water:** Water connections are located on the side of the main electric box, at the rear. Water pressure in supply line must be of 20 PSI (minimum) ~ 65 PSI (maximum).
- A chiller could be provided as an option. Connect cool water supply to the "cooling water inlet" port, and the "Cooling water outlet" port to drain.



11. Machine Setup

11.1 Loading Bottom / Forming Film

- Once the roll of film has been loaded into the film rack follow the forming film loading diagram shown in (Fig. MS-1 below) to complete the forming film loading process.
- Advance the film as required by using the JOG button shown in (Fig. MS-2 below).

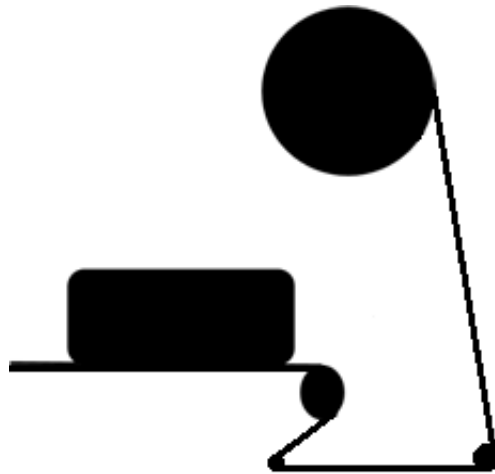


Fig. MS-1



Fig. MS-2

Continued to next page

11.2 Loading Sealing / Top Film

- Once the film has been loaded into the film rack follow the sealing film loading diagrams shown in (MS-3) based on your PRS machine to complete the sealing film loading process.
- Advance the sealing film as required by hand.

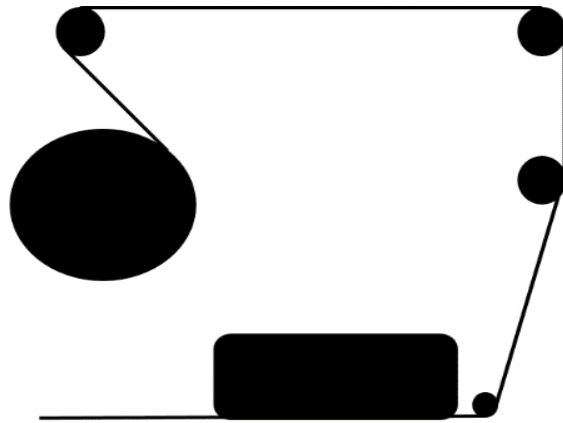


Fig. MS-3

12. Operation

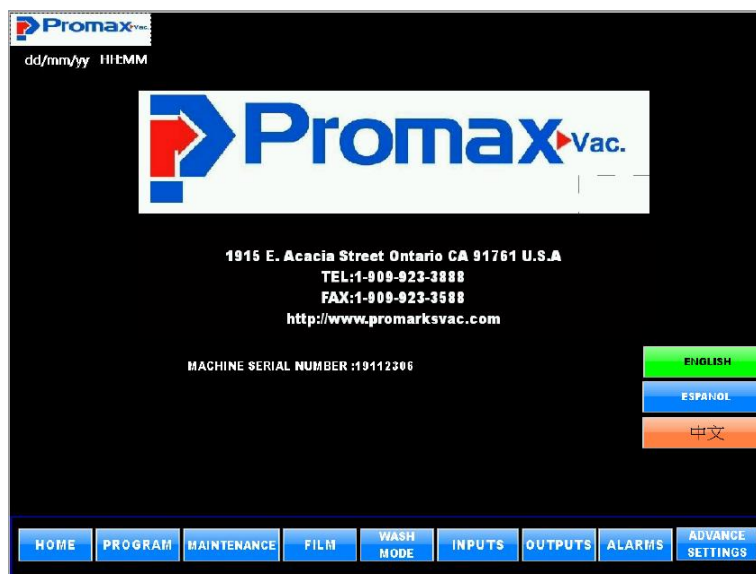
Your PRS series thermoforming machines have been designed to package a wide variety of fresh, frozen and processed food and non-food products. These products will be sold in safe, clean and appealing containers. (If your PRS is equipped with the optional M.A.P. (Modified Atmosphere Packaging) system that helps provide a tightly controlled oxygen level, you can expect a higher level of freshness for even longer periods of time.)

12.1 HMI Screen Start Up

Fig.OP-1



Fig.OP-2



12.2 Power On and Safety Check



Rotate the main power switch to the ON position (Fig.OP-3).

Fig.OP-3

Once the HMI completes the loading process, the SAFETY INSTRUCTIONS SCREEN (Fig. OP-4) will appear. At this point you need to make the following safety checks.

- Verify that all safety covers are in place
- Verify main air pressure.
- Verify that no objects are in loading area.
- Press e-stops from entrance, main electric box, loading and exit area as well as on HMI box.

Once all these safety items have been checked on the screen, the home button will appear. Press the home button to go to HOME SCREEN.

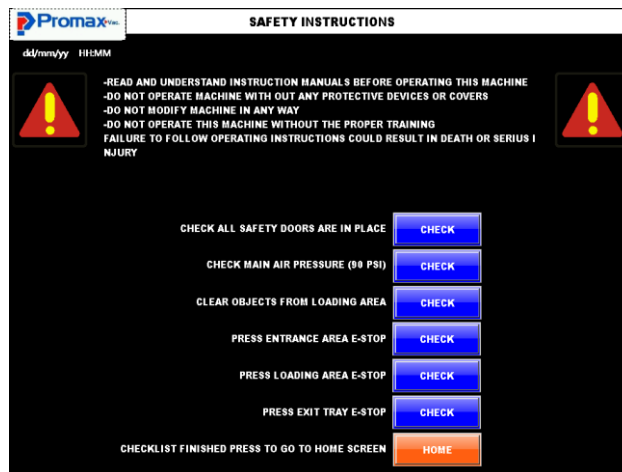


Fig.OP-4

12.3 Home Screen

Once on HOME screen (Fig. OP-5), release all the E-STOP buttons pressed on the previous step. You can return to HOME screen from anywhere by pressing HOME on the Screen Navigation bar.

Please familiarize yourself with Home screen; for the most part this is screen that you will access to first before accessing detailed functions.

For better understanding, different sections of Home Screen are highlighted in different colors and numbered in bellow diagram (Namely: Screen Navigation, Operation Buttons, Peripherals, Sealing & Forming Temperature Controls, Indicators and Sealing Vacuum Control). Following pages would briefly introduce these different sections' functions.

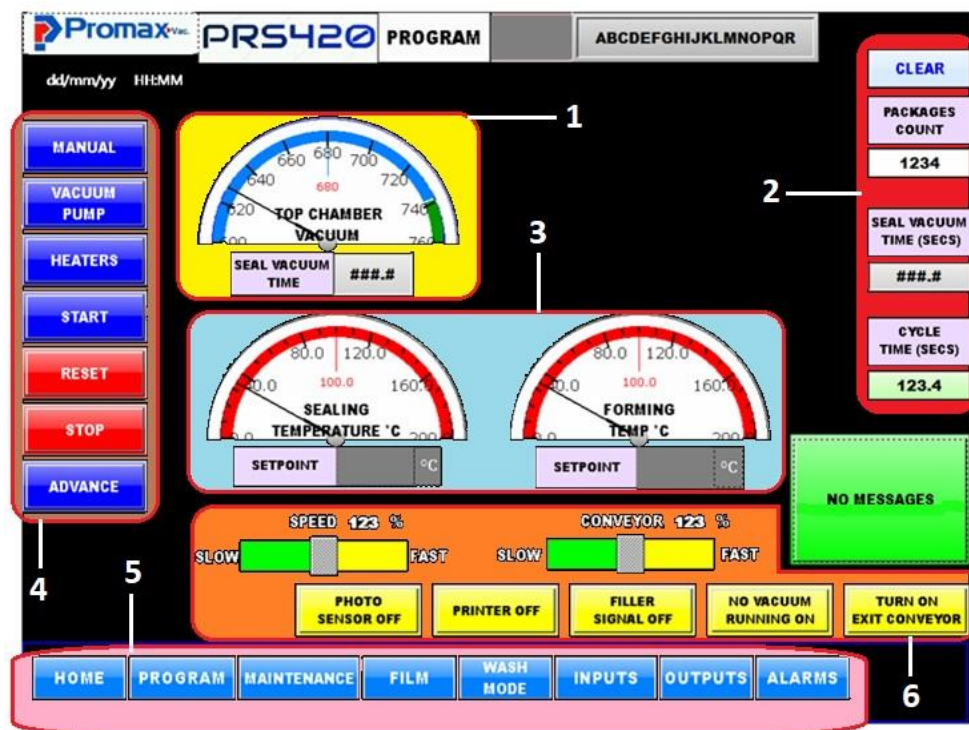


Fig. OP-5

1. Sealing Vacuum Control	4. Operation Buttons
2. Indicators	5. Screen Navigation
3. Sealing & Forming Temp. Controls	6. Peripherals

12.3.1 Screen Navigation



To return to HOME SCREEN. *Fig.OP-5.1*



To access and to set parameters for all the programmable components. *Fig.OP-5.2*



Here you can operate each of the machine's components individually for testing or troubleshooting. *Fig.OP-5.3*



Film tension adjustment and film tracking diagrams/video can be accessed on this screen. *Fig.OP-5.4*



Screen for wash mode setup and control (optional). *Fig.OP-5.5*



Shows all the inputs in and their current status. *Fig.OP-5.6*



Shows all the outputs and their current status. *Fig.OP-5.7*



Alarm history screen. *Fig.OP-5.8*



Fig.OP-5.1

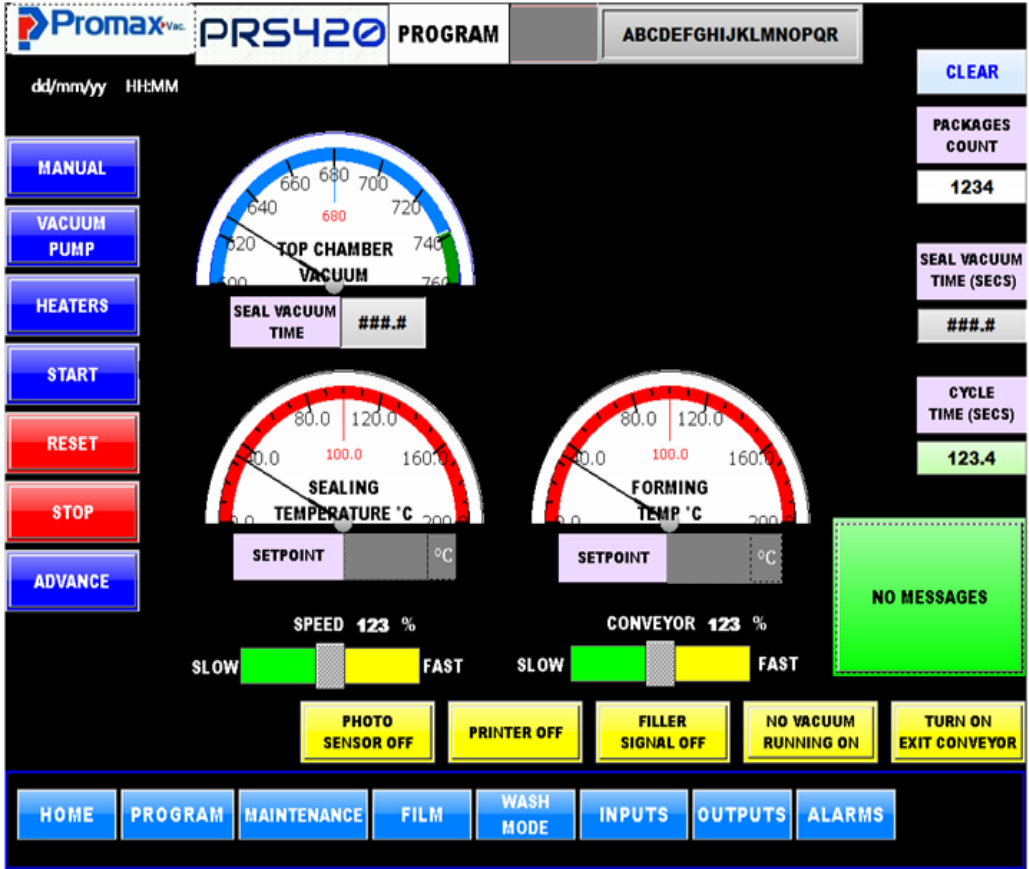




Fig.OP-5.2

Promax^{vac}

PROGRAM *****

dd/mm/yy HHEMM

FORM	TEMP			HEATING TIME		
	FORMING TIME			FORMING VENT TIME		
SEAL	TEMP			SEAL TIME		
	VAC PRESSURE			GAS TIME		
	VAC TIME			VENT TIME		
	VAC DELAY TOP			VENT DELAY TOP		
	MIDDLE VACUUM DELAY			MIDDLE VENT DELAY		
	VAC DELAY BOTTOM			VENT DELAY BOTTOM		
	FULL CYCLE TIME			MARK SENSOR DELAY		
	PACKS PER CYCLE			GUILLotine 1 OFF	GUILLotine 2 OFF	

HOME PROGRAM MAINTENANCE FILM WASH MODE INPUTS OUTPUTS ALARMS



Fig.OP-5.3

Promax Vac

dd/mm/yy H:MM

MAINTENANCE MAIN MENU

MANUAL

VACUUM PUMP

HEATERS

RESET

VACUUM SETTINGS

TEMPERATURE SETTINGS

FORMING STATION

SEALING STATION

FORMING	FORMING DIE UP	TOP BLOW (FORMING)	BOTTOM BLOW (HEATING)
SEALING	TOP VAC VALVE	TOP VENT VALVE	VACUUM PUMP
	SEALING DIE UP	GAS VAC	VENT GAS
	BOTTOM VAC VALVE	BOTTOM VENT VALVE	SEAL PLATE
CHAIN JOG	FRONT TRIM MOTOR	TOP FILM PRESS PLATE	SAFETY GUARD
SLOW JOG SPEED	REAR TRIM MOTOR	AIR CLEAN VALVE	ROTARY CUTTER
GUILLOTINE 1	GUILLOTINE 2	FILM RELEASED	PRINTER LEFT
FILLER	RESET TOP FILM MARK	PRINTER RIGHT	

MAIN AIR PRESSURE

PSI

TOP CHAMBER VACUUM

mm/Hg

HOME

PROGRAM

MAINTENANCE

FILM

WASH MODE

INPUTS

OUTPUTS

ALARMS



Fig.OP-5.4

Promax[™] Vac

dd/mm/yy HHEMM

MANUAL

VACUUM PUMP

HEATERS

RESET

ADVANCE

FILM

TOP FILM

ADVANCE

PHOTO SENSOR

FILM MARK

FILM DETECTION WINDOW AT LOW SPEED

TOP FILM

400 MM

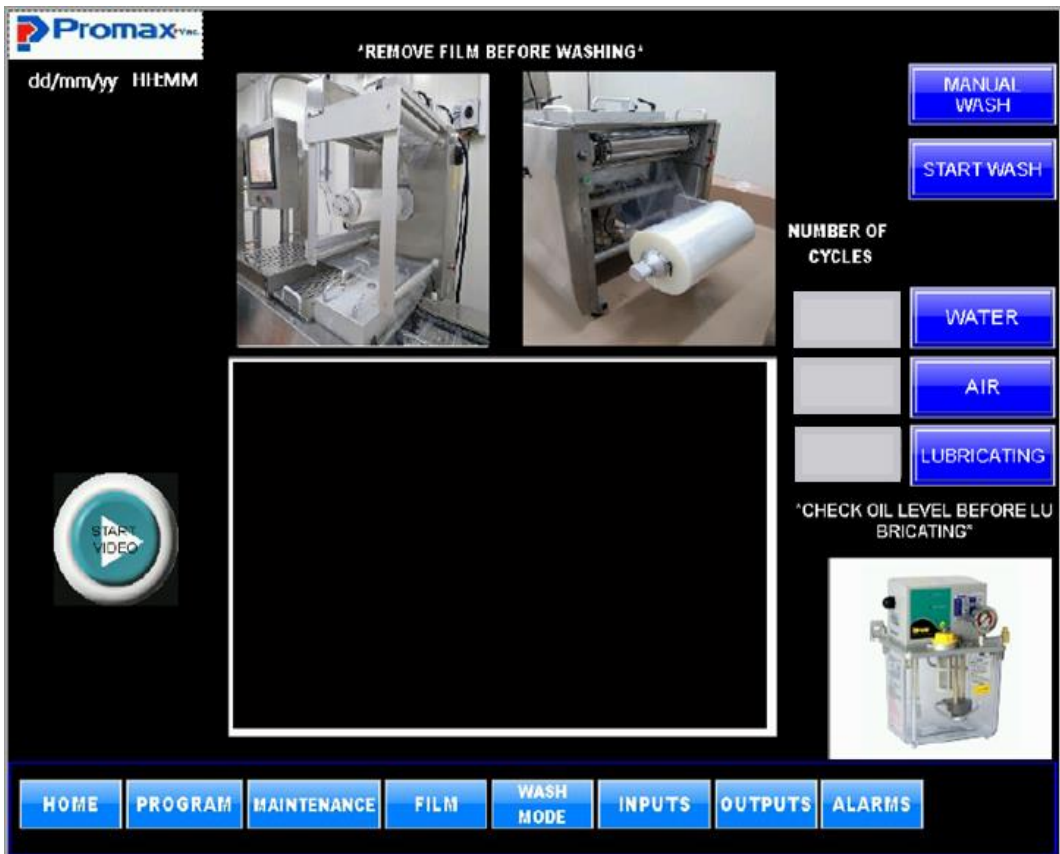
BOTTOM FILM

START VIDEO

HOME **PROGRAM** **MAINTENANCE** **FILM** **WASH MODE** **INPUTS** **OUTPUTS** **ALARMS**



Fig.OP-5.5



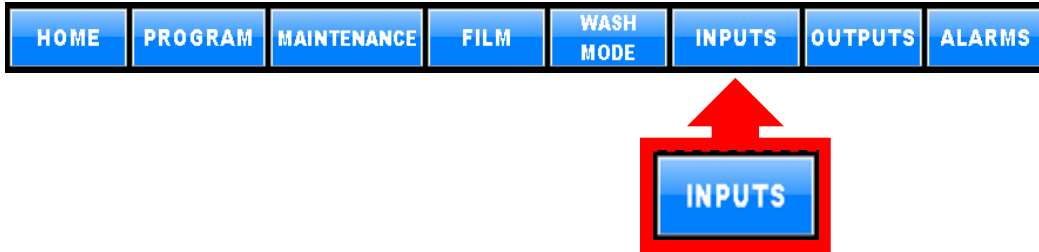


Fig.OP-5.6

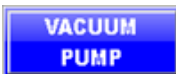
Promax **INPUTS**

dd/mm/yy HHEMM

<p>MANUAL</p> <p>VACUUM PUMP</p> <p>HEATERS</p> <p>START</p> <p>RESET</p> <p>STOP</p> <p>OUTPUTS</p>	BOTTOM FILM JOG	X0	FRONT TRIM PROXIMITY SWITCH	X20	FILM MARK POINT DETECTION	X40
	E-STOP (FORMING DIE)	X1	REAR TRIM PROXIMITY SWITCH	X21	FORMING DIE UP POSITION	X41
	E-STOP (ELECTRICAL BOX)	X2	FRONT TRIM LIMIT SWITCH	X22	FORMING DIE DOWN POSITION	X42
	E-STOP (EXIT TRAY)	X3	REAR TRIM LIMIT SWITCH	X23	SEALING DIE UP POSITION	X43
	START	X4	GUILLOTINE 1 UP	X24	SEALING DIE DOWN POSITION	X44
	STOP	X5	GUILLOTINE 1 DOWN	X25	CHAIN POSITION SET	X45
	TRIM MOTOR ON/OFF	X6	FORMING SAFETY GUARD	X26	SERVO WARNING	X46
	PHASE SENSOR	X7	SEALING SAFETY GUARD	X27	NOT USED	X47
	EXPANSION	X10	SAFETY RELAY ON	X30	FRONT TRIM MOTOR OVERLOAD	X50
	EXPANSION	X11	SPARE	X31	REAR TRIM MOTOR OVERLOAD	X51
	EXPANSION	X22	REAR SAFETY DOOR	X32	ROTARY BLADES MOTOR OVERLOAD	X52
	EXPANSION	X23	FRONT SAFETY DOOR	X33	PRINT MOTOR FRONT POSITIONING	X53
	EXPANSION	X24	GUILLOTINE 2 UP	X34	PRINT MOTOR REAR POSITIONING	X54
	EXPANSION	X25	GUILLOTINE 2 DOWN	X35	VAC PUMP OVERLOAD (FORMING)	X55
EXPANSION	X26	TOP PRESSING PLATE DOWN	X36	VAC PUMP OVERLOAD (SEALING)	X56	
EXPANSION	X27	TOP PRESSING PLATE UP	X37	PRINT MOTOR OVERLOAD	X57	

HOME PROGRAM MAINTENANCE FILM WASH MODE INPUTS OUTPUTS ALARMS

12.3.2 Operation Buttons



MANUAL/SEMI/AUTO Selects the operation mode for the machine.

- Manual mode for maintenance or troubleshooting.
- Semi Auto for running one cycle each time the button is pressed.
- Auto for running continuously until the stop button is pressed.

Starts/stops the vacuum pump.

Starts/stops forming and sealing heater elements.

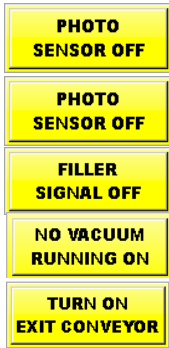
Press to start machine's cycle.

Press to reset faults or warnings.

Press to stop the machine. Machine will finish the current cycle and then stops.

Press to advance the chain once.

12.3.3 Peripherals



Turns on/off film mark detection program for registered printed film. (optional)

Turns on/off printer program for date/lot coding. (optional)

Turns on/off signal for external filler/loader equipment.

Indicates whether the machine will run cycles without vacuum.

Turns on/off exit conveyor (optional).



Controls the speed of the machine.

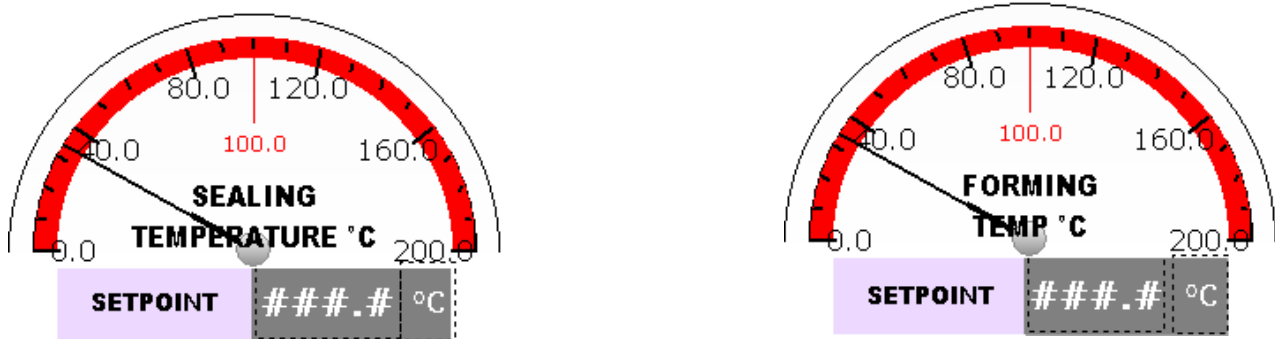
At 100% the machine works at full speed.

If speed percentage is reduced, the machine will have a delay between cycles.



Conveyor speed control.

12.3.4 Forming / Sealing Temperature Controls



- Push the RUN button to begin the packaging operation.
- For a quick tweak of temperature of either FORMING or SEALING just press the current temperature numbers on HOME screen (Fig.OP-5.9). Enter the new value and push the OK button (Fig. OP-5.10).
- To configure temperature control press PROGRAM on HOME screen (Fig. OP-5.11) and select temperature settings for either FORMING or SEALING (Fig. OP-5.12).
- To access temperature limit adjustments/temperature parameters press MAINTENANCE on HOME screen (Fig. OP-5.13), enter user credentials and press ok, press the TEMPERATURE SETTING button (Fig. OP-5.14) to go to next control screen (Fig. OP-5.15) to control temperature limits to every related component.

Continued to next page

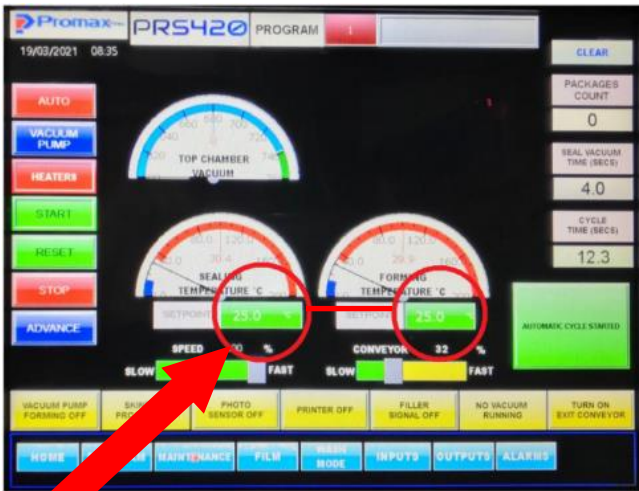


Fig.OP-5.9



Fig.OP-5.10



Fig.OP-5.11

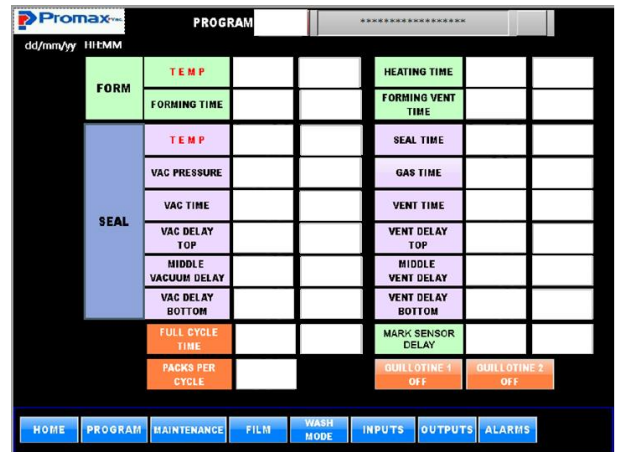


Fig.OP-5.12

Continued to next page



Fig.OP-35.13

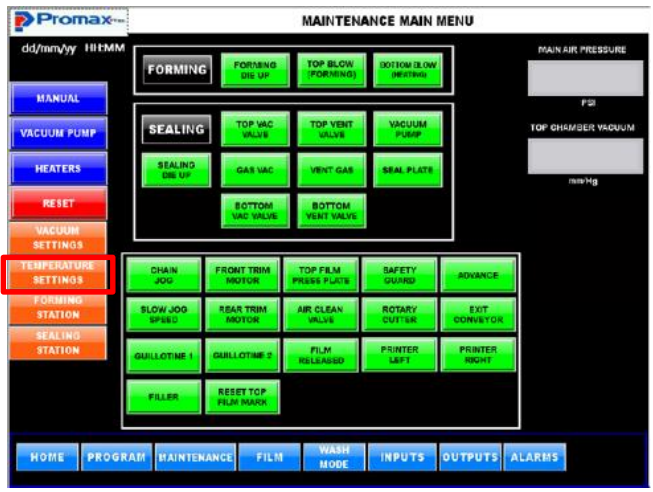


Fig.OP-5.14

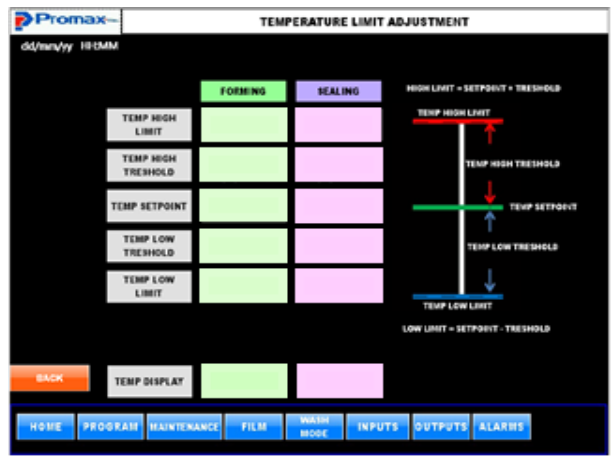
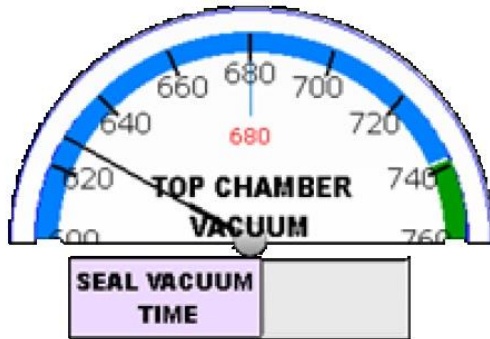


Fig.OP-5.15

12.3.5 Sealing Vacuum Control



- For a quick tweak of vacuum time just press the current seal vacuum time on HOME screen (Fig.OP-5.16). Enter the new value and push the OK button (Fig. OP-517.).
- To configure vacuum press PROGRAM on HOME screen (Fig. OP-5.18) and select desired vacuum settings as highlighted (circled) in (Fig. OP-5.19).
- To access vacuum limit adjustments/vacuum parameters press MAINTENANCE on HOME screen (Fig. OP-5.20), enter user credentials and press ok, press the VACUUM SETTING button (Fig. OP-5.21) to go to next control screen (Fig. OP-5.22) to access to vacuum related settings.

Continued to next page

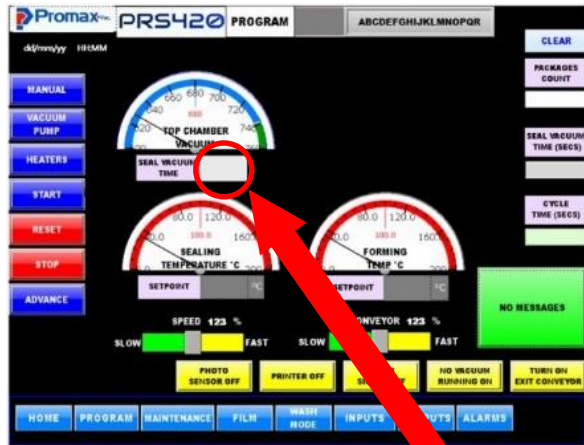


Fig.OP-5.16



Fig.OP-5.17

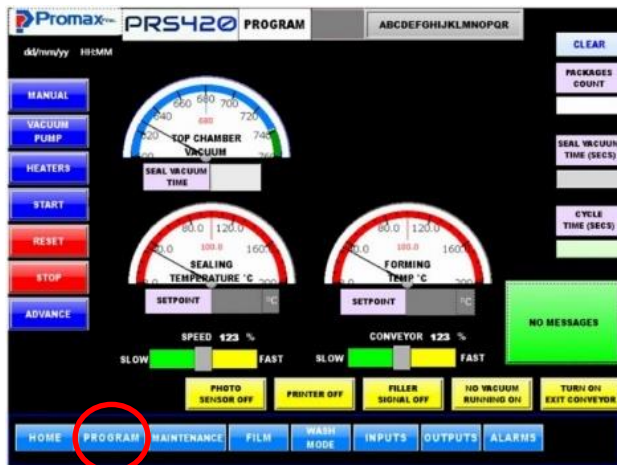


Fig.OP-5.18

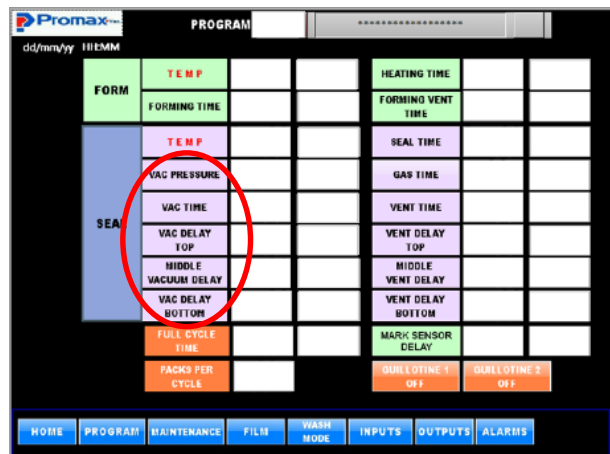


Fig.OP-5.19

Continued to next page



Fig.OP-5.20

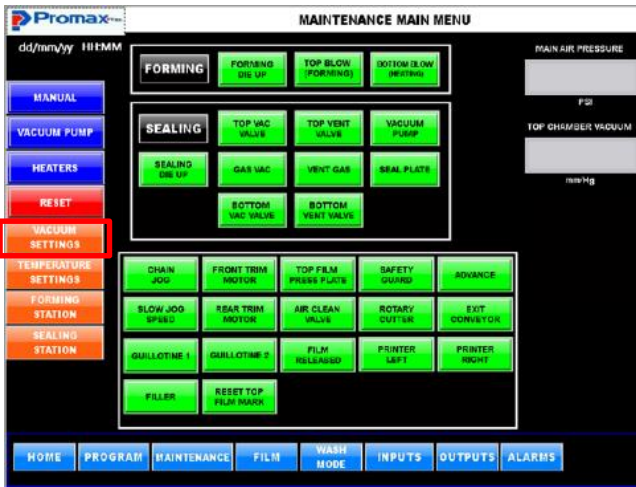


Fig.OP-5.21

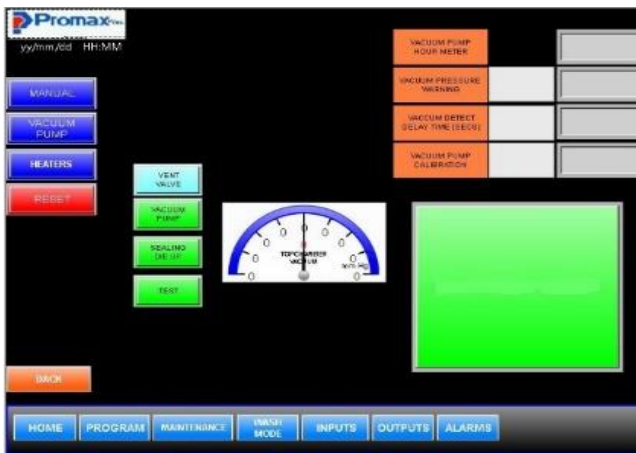


Fig.OP-5.22

12.3.6 Indicators

CLEAR

**PACKAGES
COUNT**

1234

Counts packages accordingly to tool configuration (packages per cycle)
Press clear to reset the counter to 0.

**SEAL VACUUM
TIME (SECS)**

1234

Seal Vacuum time. Press the numeric display to change the value.

**CYCLE
TIME (SECS)**

123.4

Displays machine's last cycle time.

13 Setting up New Programs

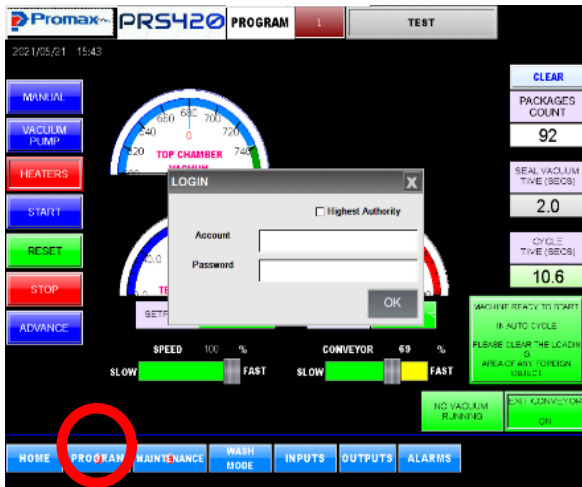


Fig.OP-5.23

Account: 4
Password: 4444

-Press the PROGRAM button on the left side of the home screen (Fig. OP-5.23) and a password screen will appear.

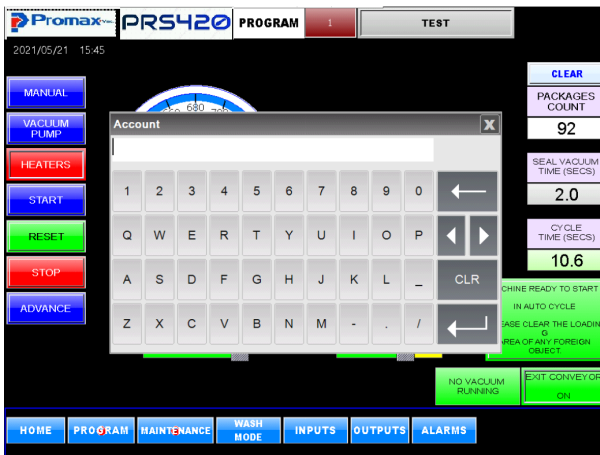


Fig.OP-5.24

-Enter the proper account number and password the push the OK button. (Fig. OP-5.24)

Continued to next page

-The program screen will appear (Fig. OP-5.25 below).

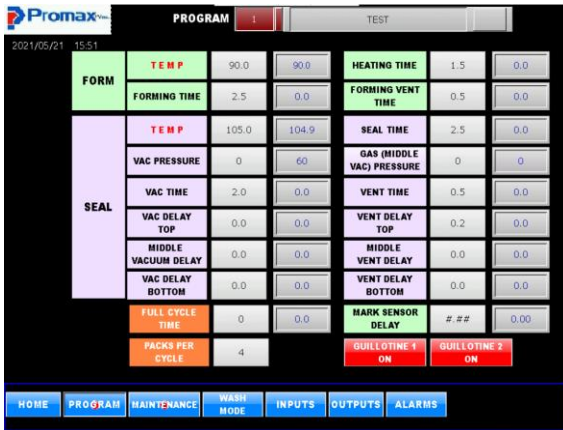


Fig.OP-5.25

-Push the button for the first parameter you wish to set and a keyboard screen.

-Enter the parameter and push Enter.

-Continue this process until all the parameters for Forming / Sealing etc. have been entered.

14. Maintenance

NOTE- In "Maintenance" mode all safeties are turned off.

-Press the Maintenance button on the left side of the home screen (Fig. OP-5.26) and a password screen will appear .

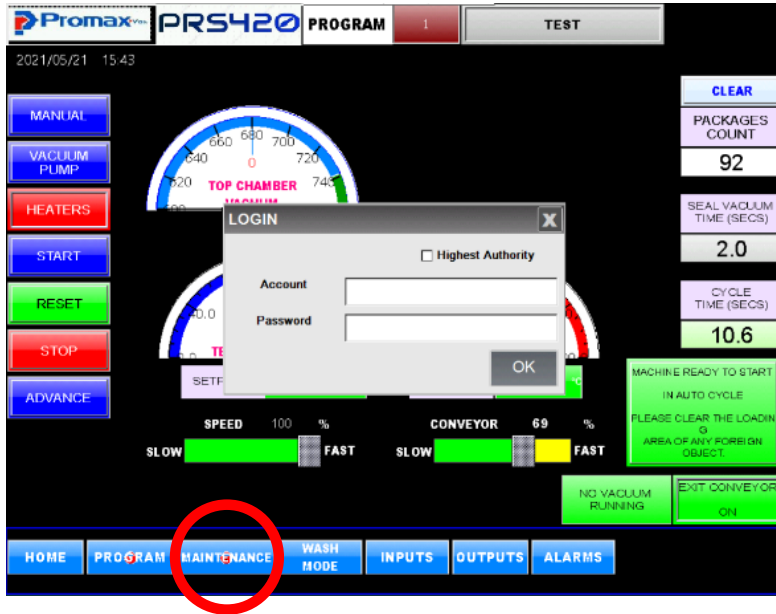


Fig.OP-5.26

Account: 4
Password: 4444

-Enter the proper account number and password the push the OK button. (Fig. OP-5.27)



Fig.OP-5.27

Continued to next page

-The program screen will appear (Fig. OP-5.28 below).

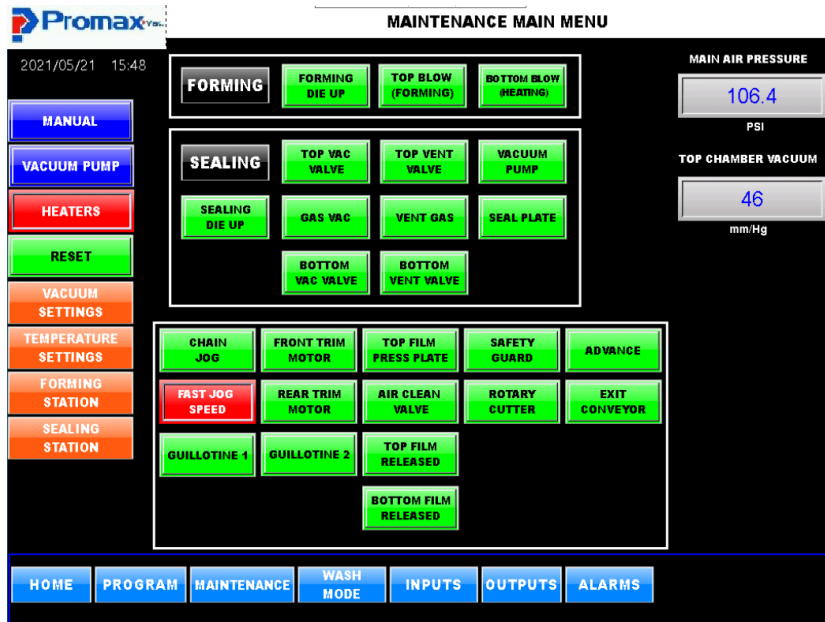


Fig.OP-5.28

-Push the button for the component that you wish to do the maintenance of.

-Enter the parameter for the e to carry out the maintenance.

-Continue this process until all the maintenance has been done.

15. Factory Reset

-Press the marked (circled) points on the screen as shown in the below picture (Fig.OP-5.29) to access to factory reset option.

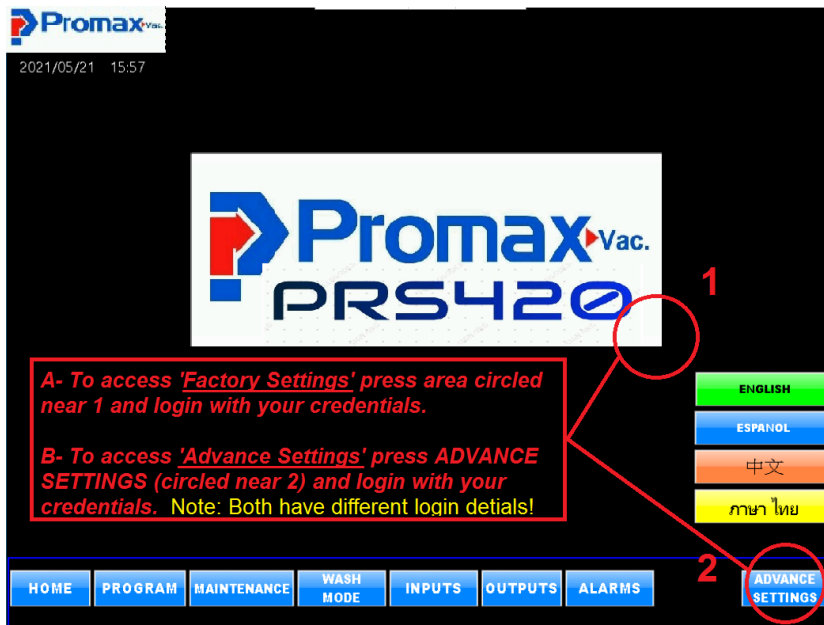


Fig.OP-5.29

-A password screen will come up, enter the appropriate higher level credentials for first level and then advance setting. (Fig. OP-5.30)



Fig.OP-5.30

Account: FOODMAX
Password: 3888

Continued to next page

Advance setting screen will appear (Fig. OP-5.31)

Promax Vmax **ADVANCE SETTINGS**

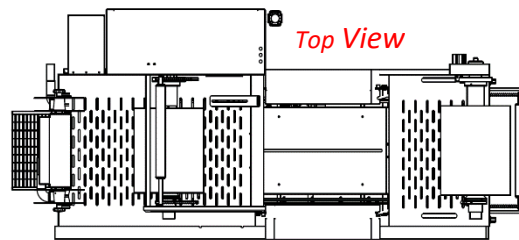
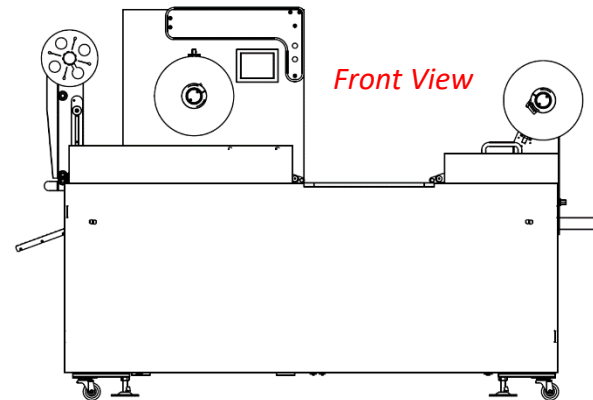
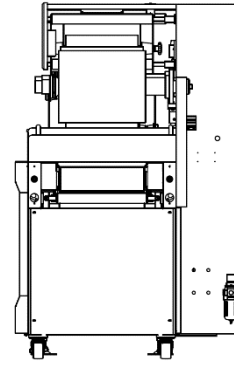
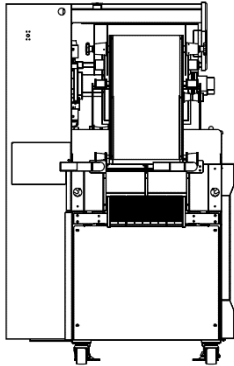
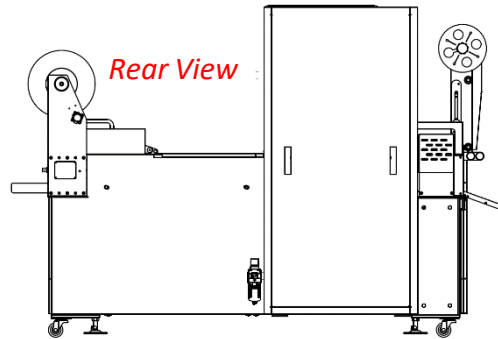
2021/05/21 15:54

POWER SAVING SHUTDOWN TIME (MINUTES)		RESET VACUUM PUMP OIL CHANGE TIMER		ENGLISH	
PUMP	HEATERS			ESPAÑOL	
10	10			中文	
				ภาษาไทย	
PRINT MARK PROGRAM OFF				VACUUM PUMP HOUR METER	13
PRINTER PROGRAM OFF				WASH CHAIN ADVANCE MM	1110.55
NO VACUUM RUN PROGRAM ON	FORMING VENT TIME	0.5 sec	0.0 sec	WASH CHAIN SPEED	500.0
3 STEP INDEX PROGRAM ON	AIR PRESSURE WARNING	45.0 psi	45.0 psi	JOG CHAIN FAST SPEED	800
FILLER PROGRAM OFF	PRESSURE DETECT DELAY TIME	1.0 sec	1.0 sec	JOG CHAIN SLOW SPEED	200
SECOND CROSS CUT ENABLE	MAIN AIR CALIBRATION	0.0 +20 -20	107.8 psi	MARK SEARCH CHAIN SPEED	400
BOTTOM VAC SENSOR ENABLED	VACUUM PUMP CALIBRATION	0.0 +20 -20	45 mm Hg		
PASSWORD SETUP				CHAIN TEST (Minute)	0
SYSTEM DATE/TIME	Mini Computer OFF				

HOME PROGRAM MAINTENANCE WASH MODE INPUTS OUTPUTS ALARMS

Fig.OP-5.31

16. Different Views of PRS



17. Remote Diagnostics

17.1 PRS Remote Diagnostics (First Installation/End User)

17.1.1: Turn on the mini-computer by pressing the *Power On/Off* switch as shown in pictures below.

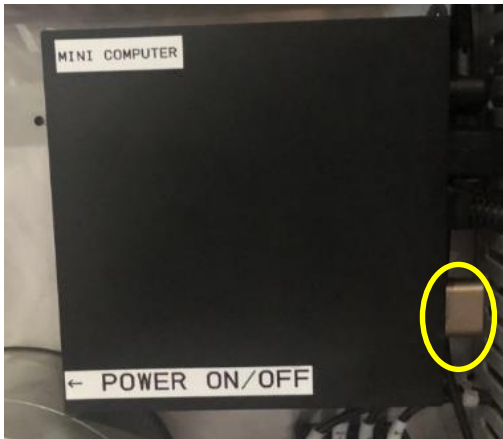


17.1.2: Link the *Mini Computer* to the internet via Ethernet cable of Wi-Fi. If using Ethernet cable, please plug it in the port shown in the following pictures.

Continued to next page

17.1.3: Connecting to Wi-Fi.

17.1.3.1 Remove the HDMI port protective cover (shown in the picture below).



17.1.3.2 Connect a laptop or a monitor with keyboard to the HDMI or VGA port at the rear.



Continued to next page

17.1.3.3 Power on the Mini-Computer, you should see the screen (shown below) on the connected laptop/monitor.



17.1.3.4 Click on the circled area to see available Wi-Fi connections list. Select one, check “Connect Automatically” and click “Connect”.



Continued to next page

17.1.3.5 When *Mini-Computer's* internet connection has been configured using Ethernet cable or Wi-Fi, please inform PROMAX engineer to log on to your PRS machine remotely via [AnyDesk](#).

17.1.3.6 Please note that when the PRS machine is being diagnosed/worked on via the remote diagnostic, **Do Not Power Off** the machine.

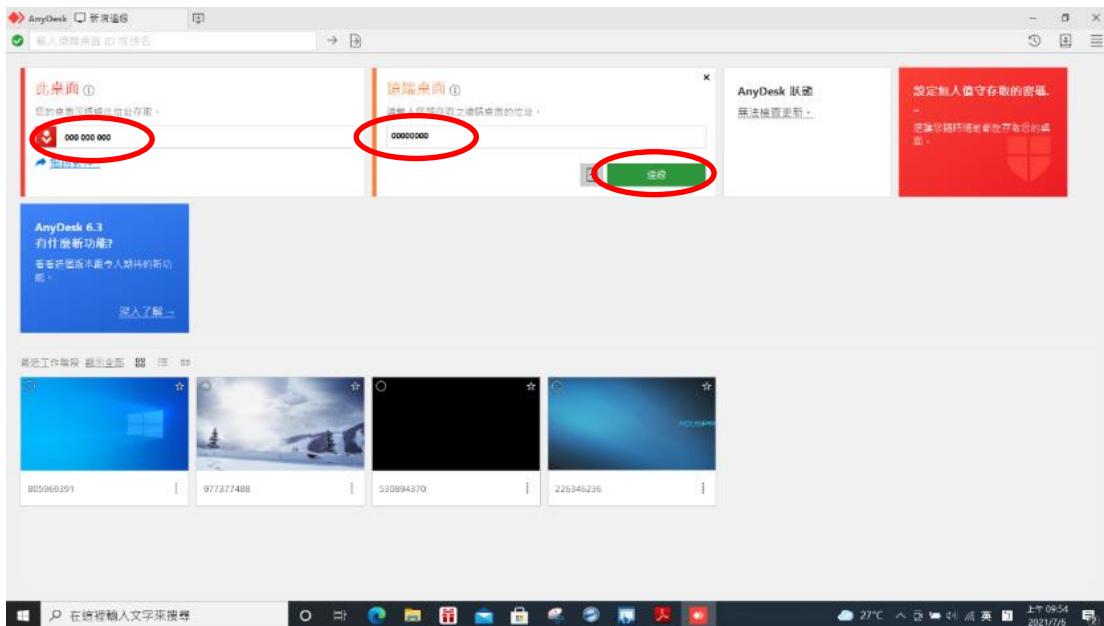
17.2 PRS Remote Diagnostics (Promax Service Team / Distributor)

17.2.1 How to remote diagnose PRS?



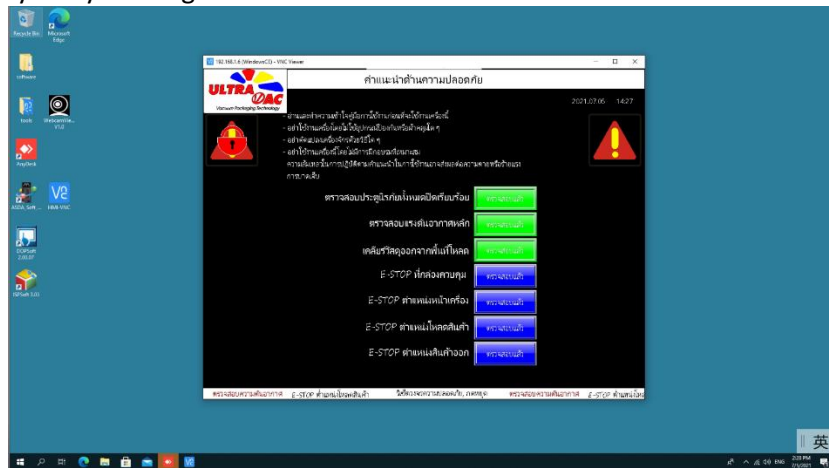
17.2.1.1 Install “AnyDesk” on your laptop.

17.2.1.2 Open “AnyDesk”, enter the account and password.

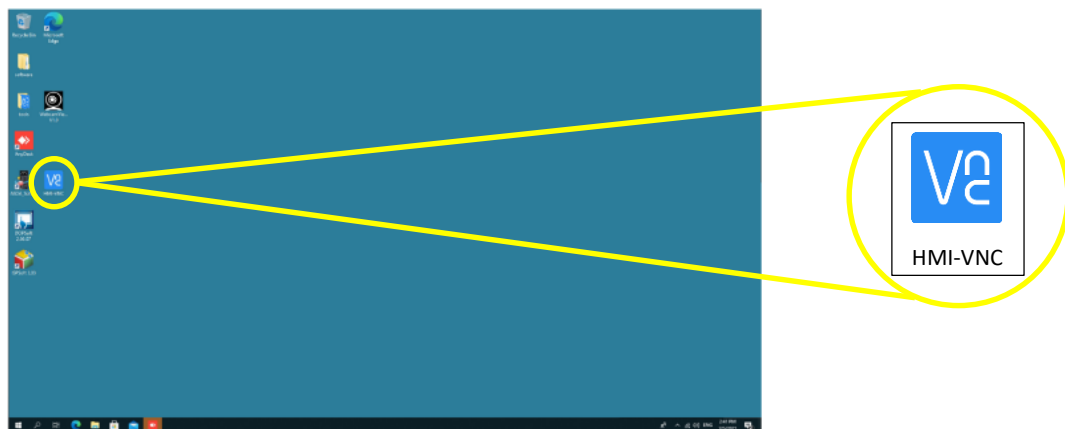


Continued to next page

17.2.1.3 After logging in you should see the same display as machine's HMI is showing. You may run your diagnostics.

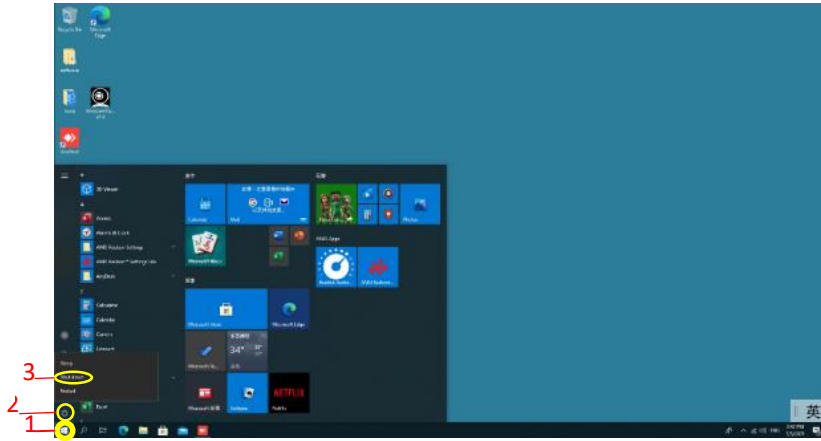


17.2.1.4 If you do not see the machine's HMI screen, please click "HMI-VNC" and run the diagnostics.

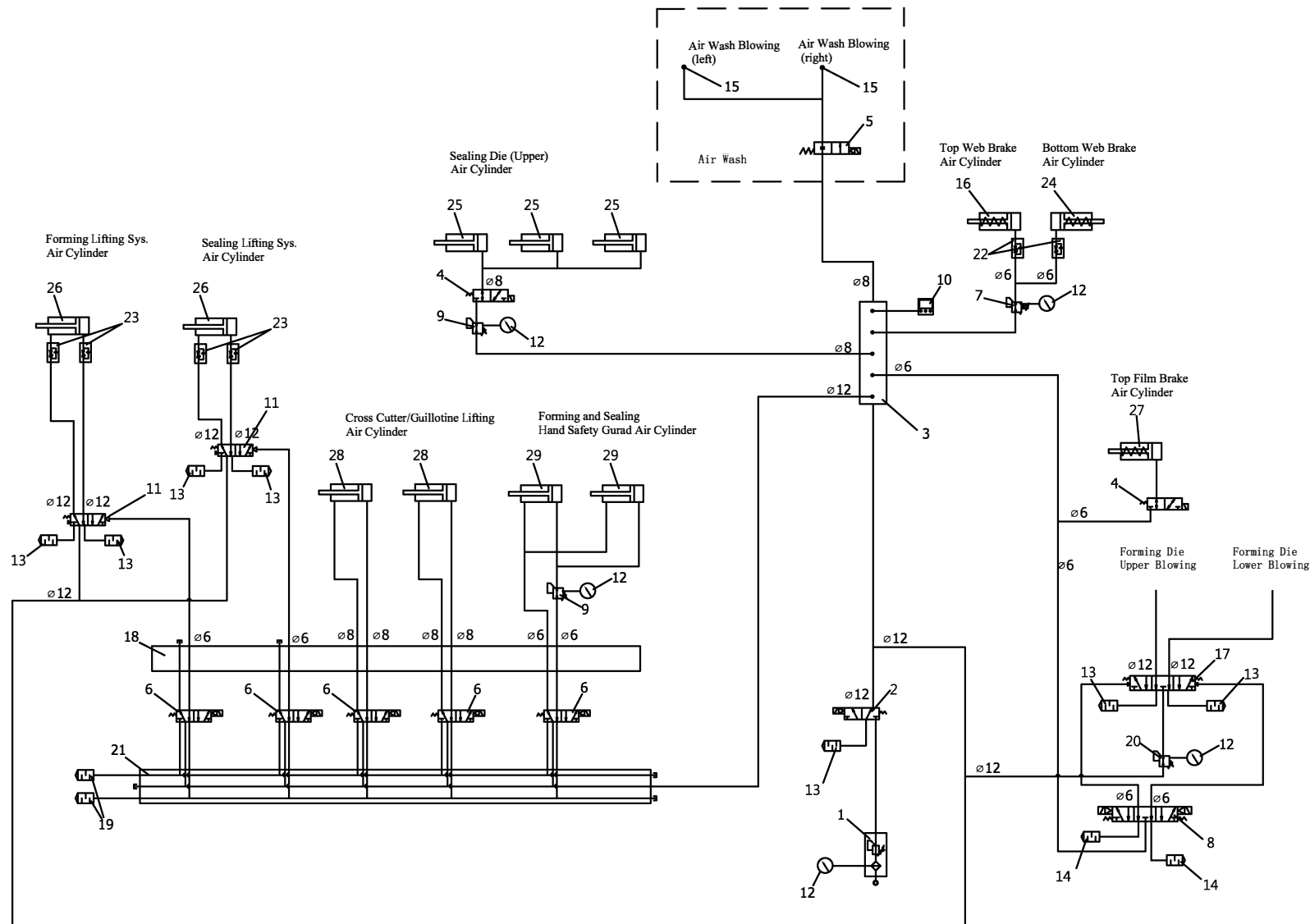


Continued to next page

17.2.1.5 Once completed the remote diagnostic, please power off the “Mini-Computer” by following the steps shown in picture below:

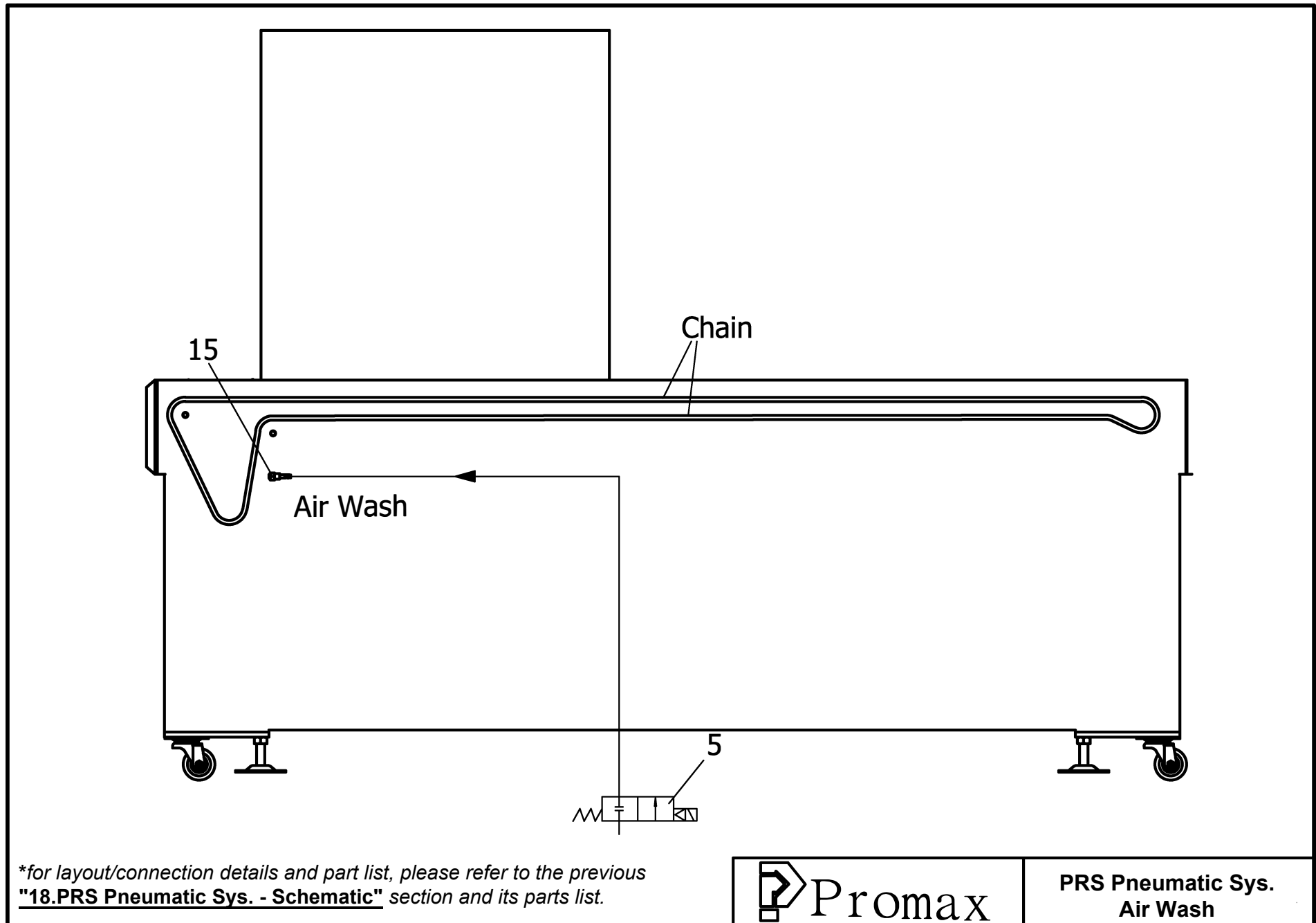


18. PRS Pneumatic System - Schematic

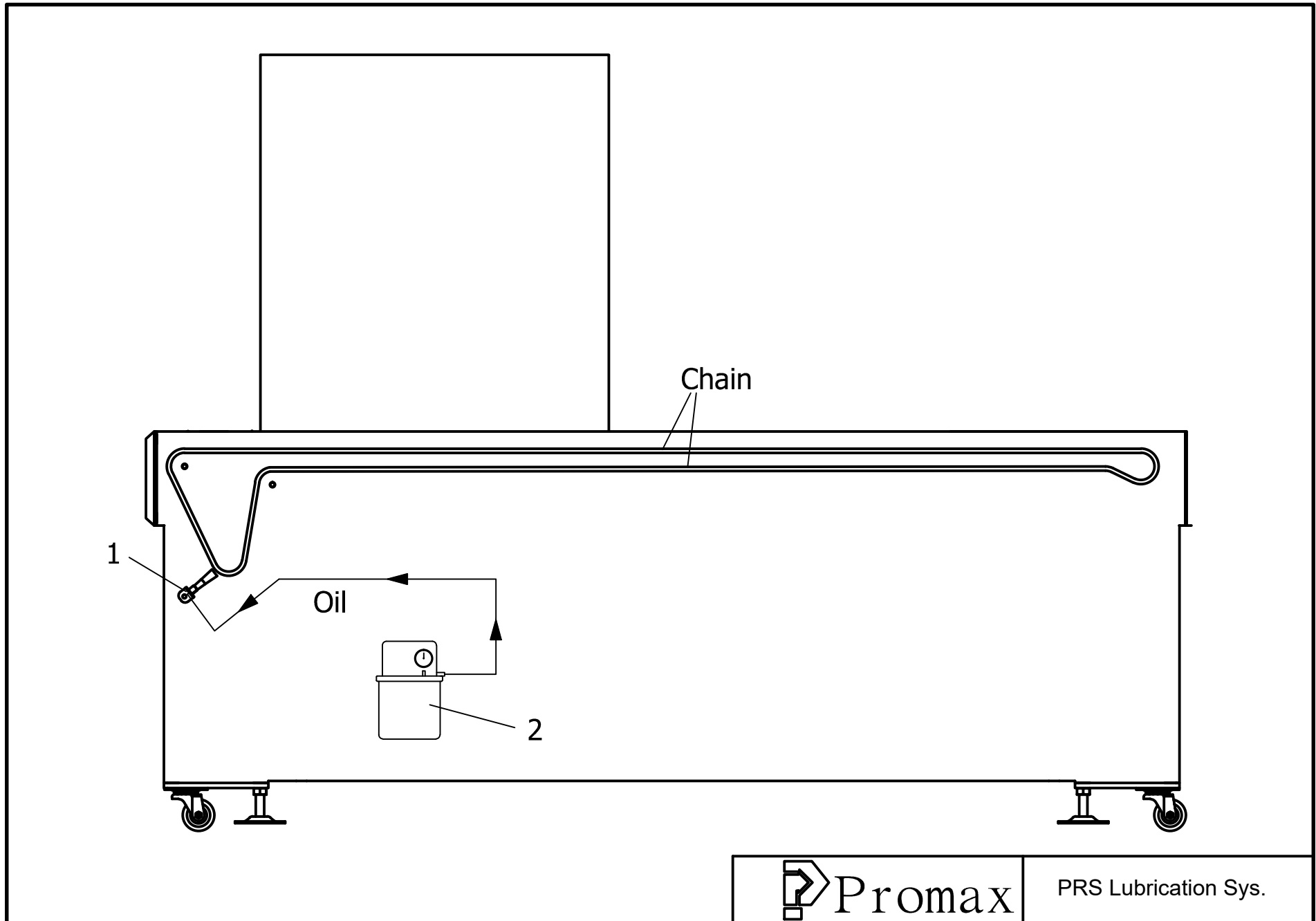


PRS 420M - Pneumatic Sys.

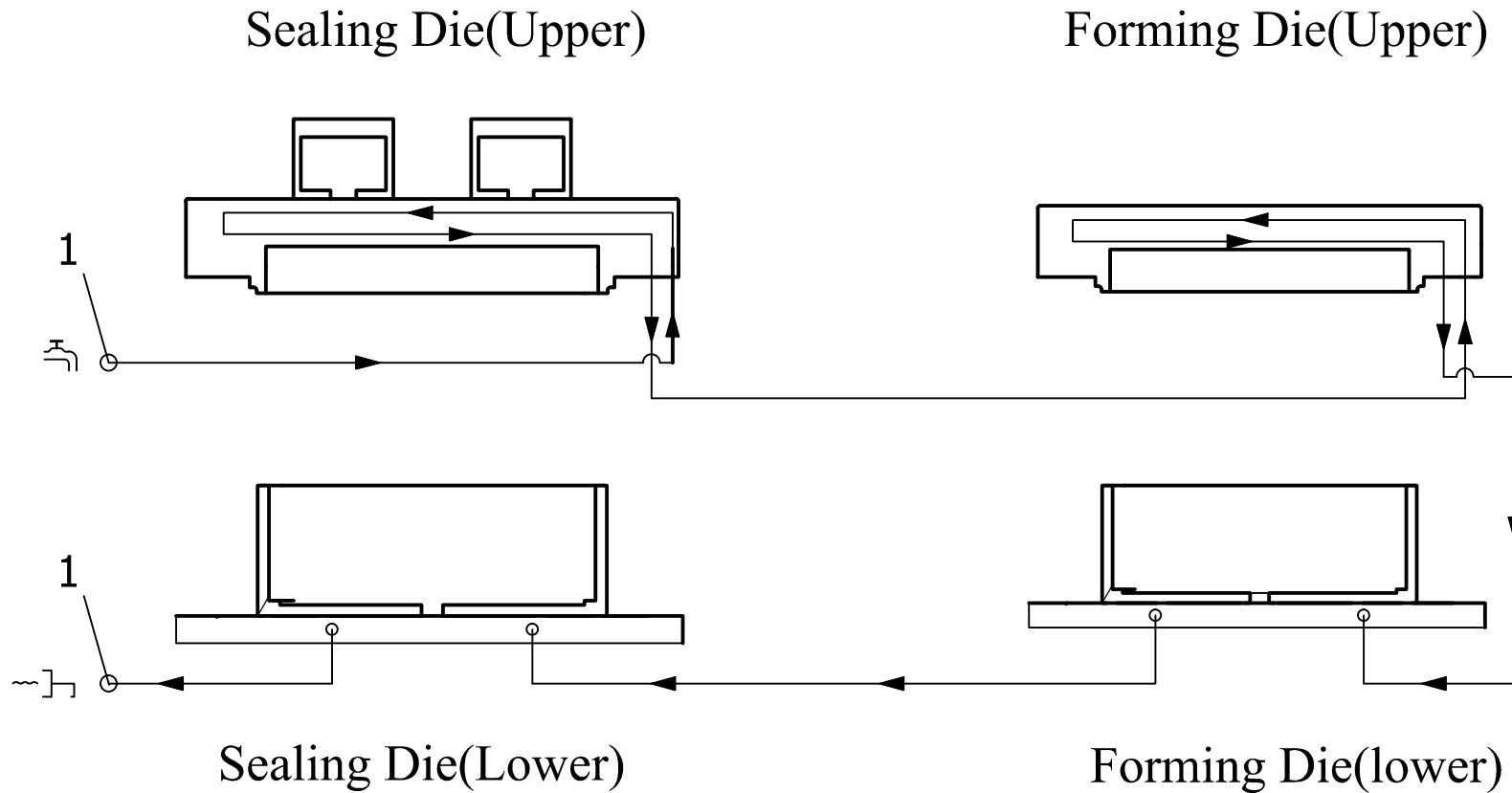
19. PRS Air Wash Sys.



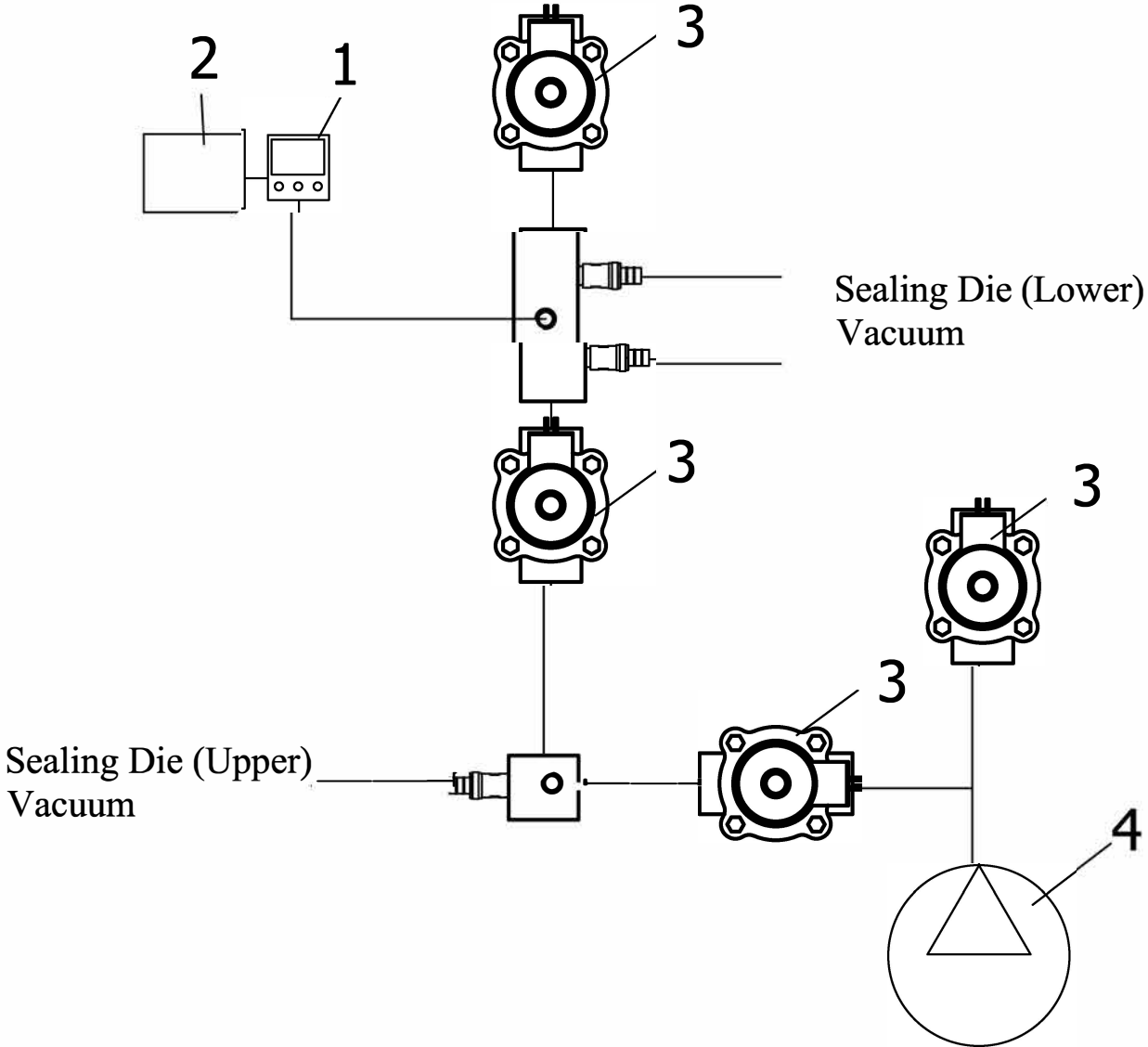
20. PRS Lubrication Sys.



21. PRS Chilled Water Sys.



22. PRS Solenoid Vacuum Valve Sys.

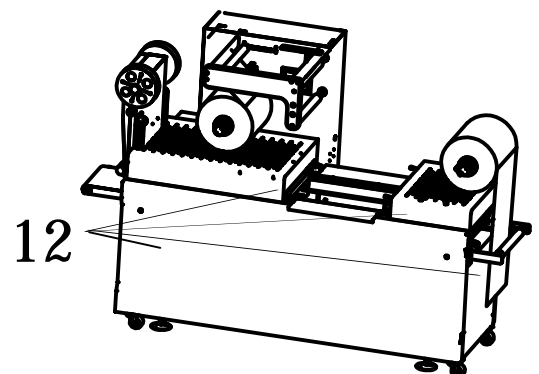
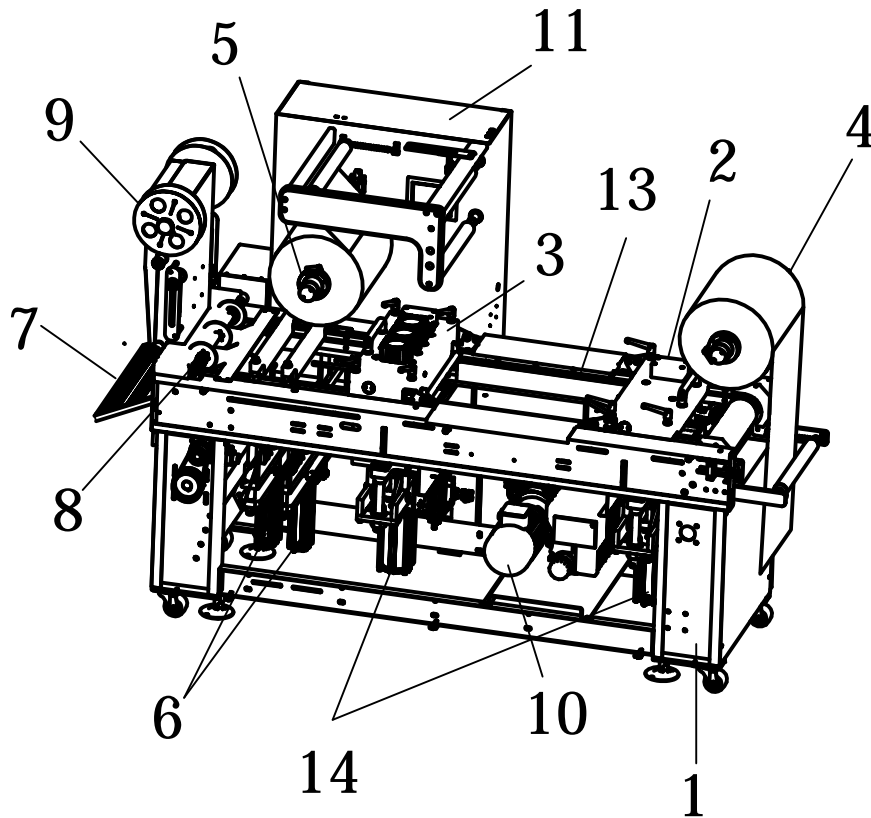


PRS Solenoid Vacuum Valve System.

23. PRS Machine and Parts List

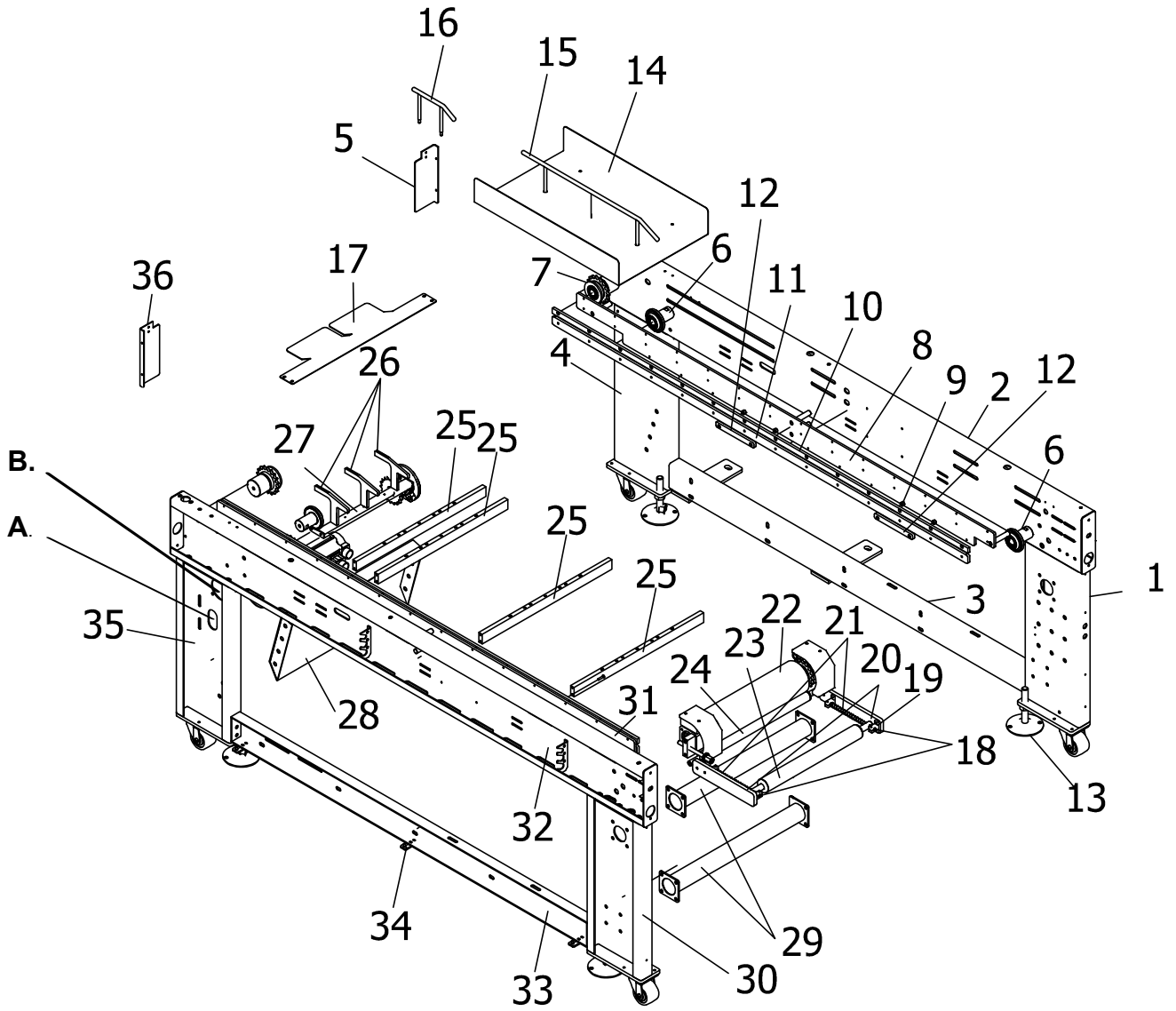
S#. Corresponding Section

- 1 PRS Frame
- 2 Forming Die
- 3 Sealing Die
- 4 Bottom Web
- 5 Top Web
- 6 Cross Cutter
- 7 Exit Roller Pass
- 8 Rotary Cutter
- 9 Film Trim Winder
- 10 Vacuum Pump
- 11 Main Electric Box
- 12 Safety Covers
- 13 Transport Chain
- 14 Lifting System



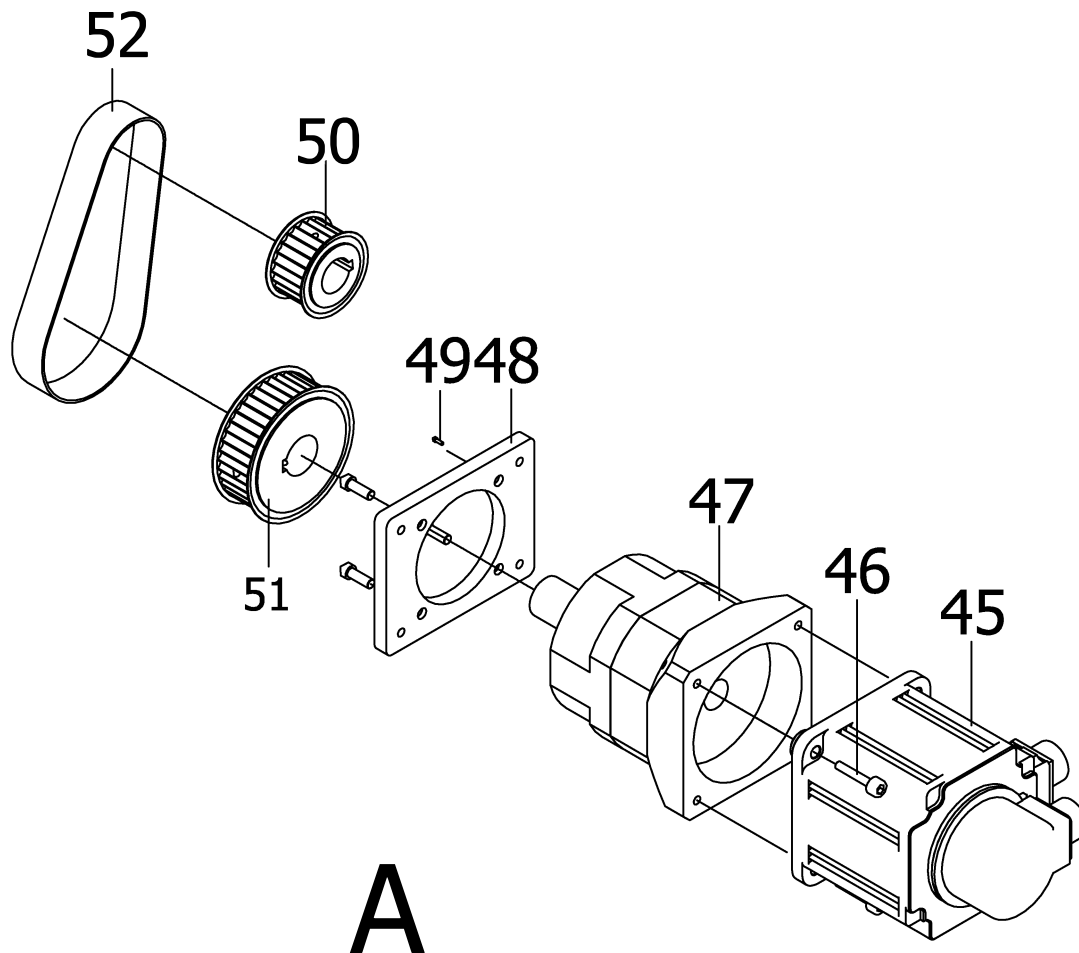
Promax

PRS Machine



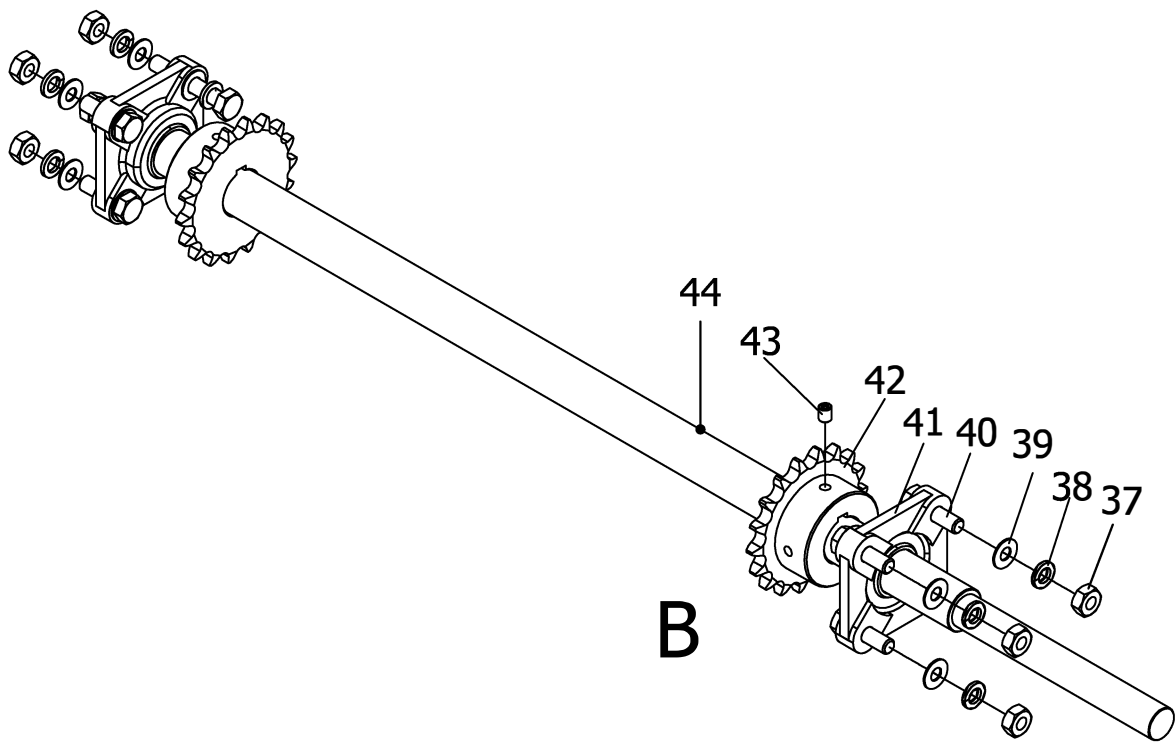
Promax

PRS Frame



Promax

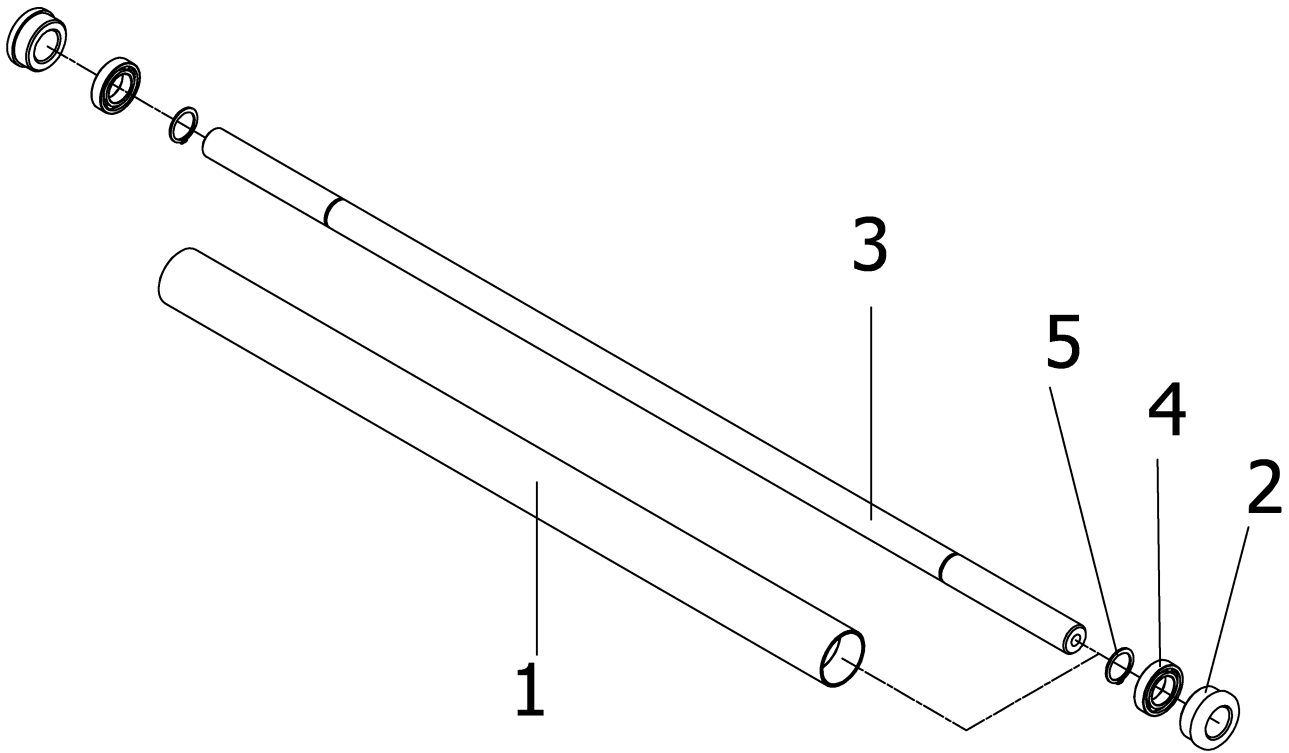
Chain Servo Drive System



Promax

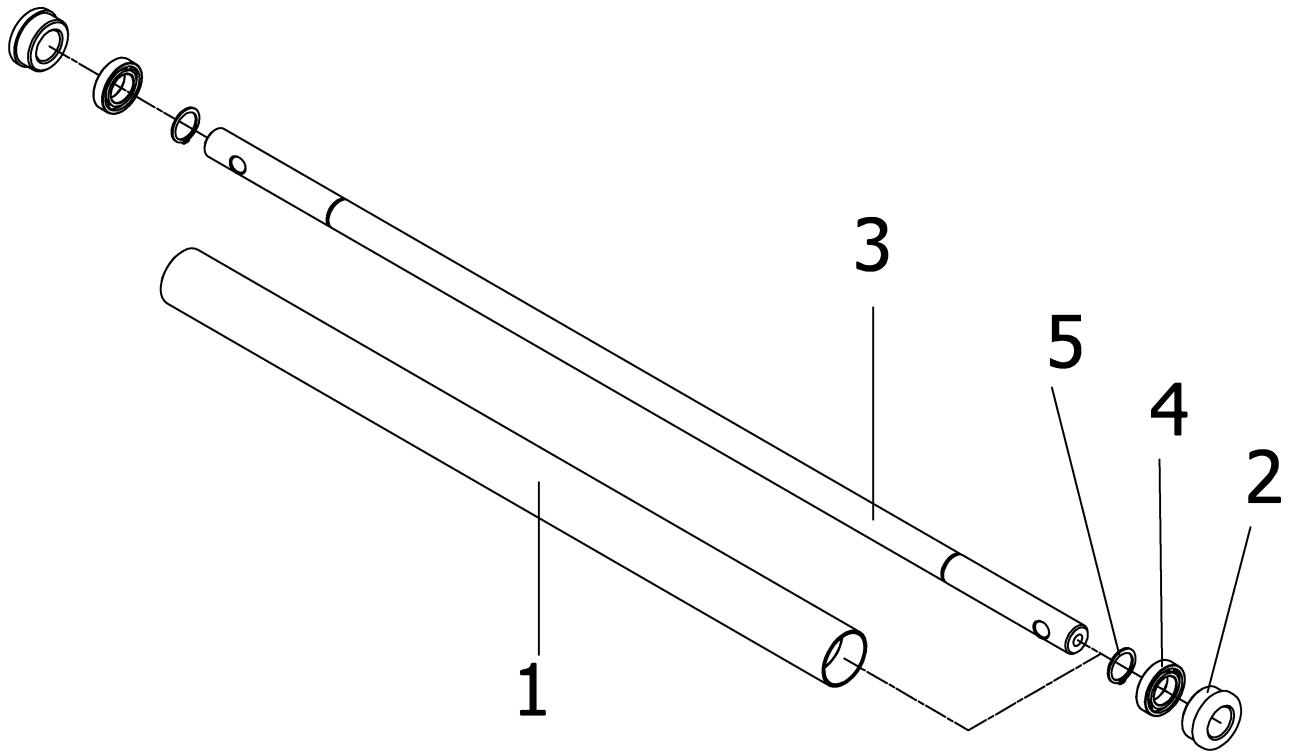
Chain Drive System

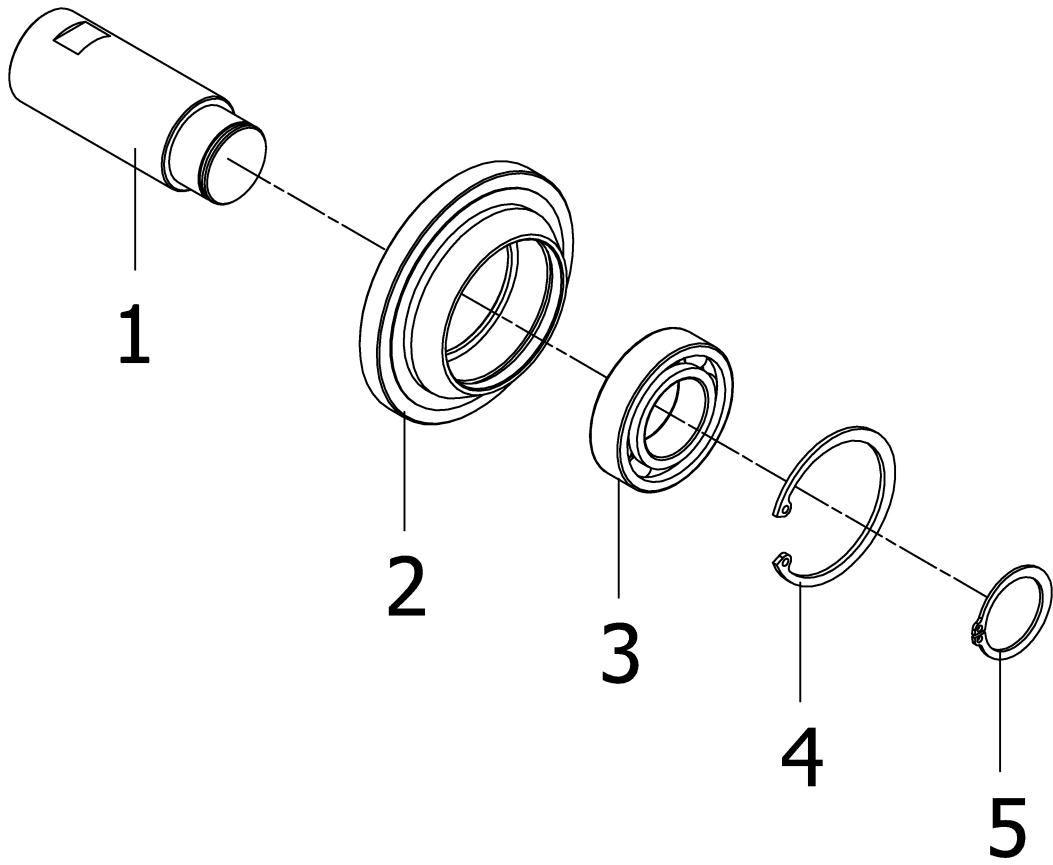
N0.	PART NO.	DESCRIPTION	QTY	NOTE
1	RS4N110000	Frame End Support Column (Infeed - R)	1	
2	RS4M113000	Frame Channel - R	1	
3	RS4M112000	Frame Lower C Beam R	1	
4	RS3M109000	Frame End Support Column (Exit - R)	1	
5	RS3M121000	Exit Roller Side Cover - R	1	
6	RS39116000	Idler Roller	4	
7	RS39119000	Idler Sprocket	1	
8	RS4M124000	Chain Support - Metal (R)	1	
9	RS39131000	Chain Support - Plastic	78	
10	RS4M128000	Chain Support - Plastic	2	
11	RS4M133000	Chain Support - Plastic	2	
12	RS4M130000	Chain Support - Plastic	4	
13	RS42103000	Adjustable Leveling Foot	4	
14	RS4M145000	Loading Area Tray	1	
15	RS4M146000	Loading Area Package Support Bar	1	
16	RS4M148000	Exit Area Package Support Bar	1	
17	RS4M150000	Rotary Cutter Package Press Plate	1	
18	RS3M705000	Bottom Tension Roller Spring Shaft	2	
19	27281070	Bottom Tension Roller Spring Shaft Bracket	4	
20	RS4M184000	Bottom Tension Roller Bracket	2	
21	RS3M740000	Bottom Tension Roller Spring	2	
22	Not Used	Not Used		
23	RS4M149000	Bottom Tension Roller	1	
24	RS4N115000	Bottom Film Guide Roller	1	
25	RS4N107002	Frame Cross Support Bars	4	
26	RS4M141001	Rotary Cutter Bridge	3	
27	RS4M122000	Rotary Cutter Bridge Plate	1	
28	RS4N101000	Cross Plate - Exit	1	
29	RS4N102000	Frame Cross Pipes	2	
30	RS4N111000	Frame End Support Column (Infeed - L)	1	
31	RS4M127000	Chain Support - Metal (L)	1	
32	RS4M114000	Frame Channel -L	1	
33	RS4M147000	Frame Lower C Beam L	1	
34	RS4A179000	Outer Cover Bottom Support Pin	5	
35	RS3M108000	Frame End Support Column (Exit - L)	1	
36	RS3M122000	Exit Roller Side Cover -L	1	
37	2707017	Nut M10	8	
38	27046155	Flat Washer M10	16	
39	27141132	Spring Washer M10	16	
40	2700443	Hex Head Screw M10x35	8	
41	27285631	Bearing	2	
42	RS42135000	Sprocket	2	
43	2704618	Socket Set Screw M8x10	4	
44	RS4N120000	Chain Drive Shaft	1	
45	28204659	Servo Motor	1	
46	27011882	Hex Socket Head Screw M8x50	4	



Promax

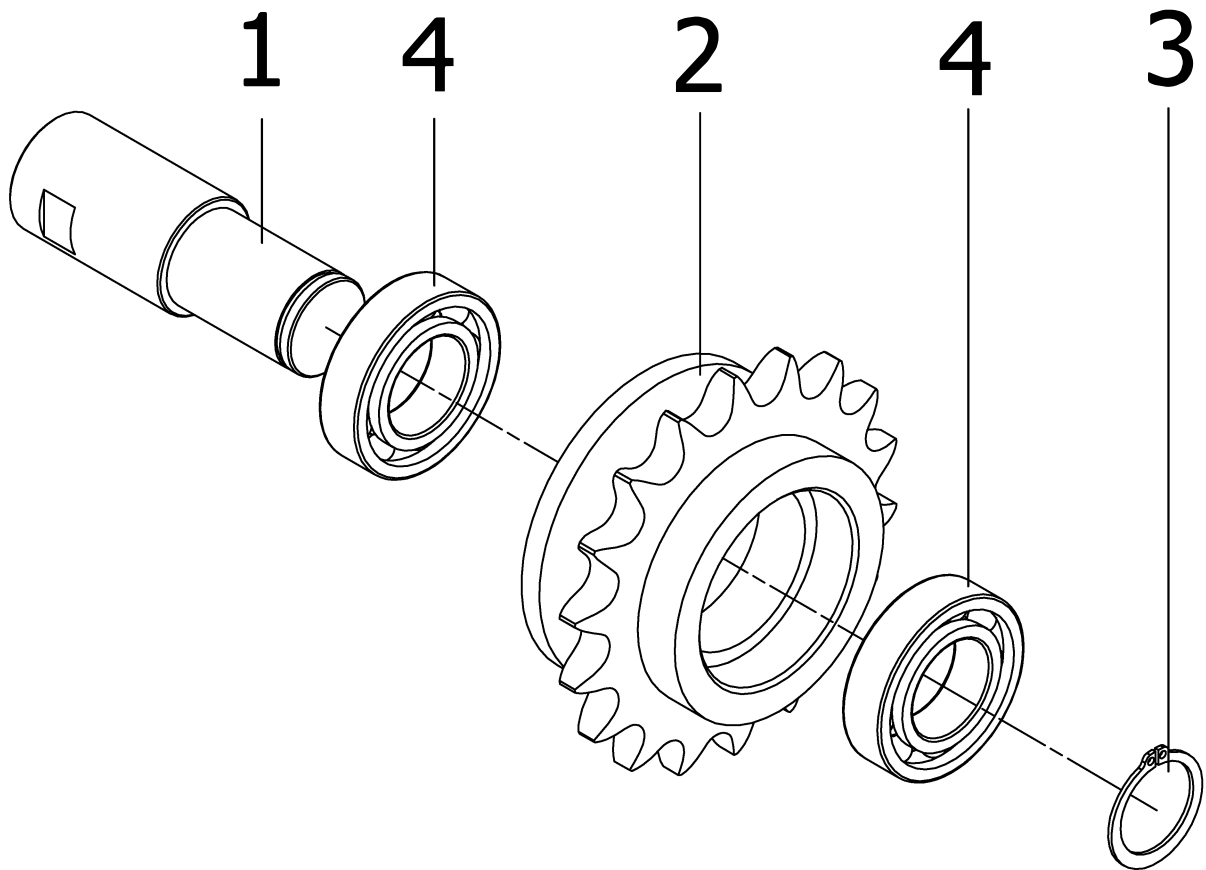
Bottom Film Guide Roller





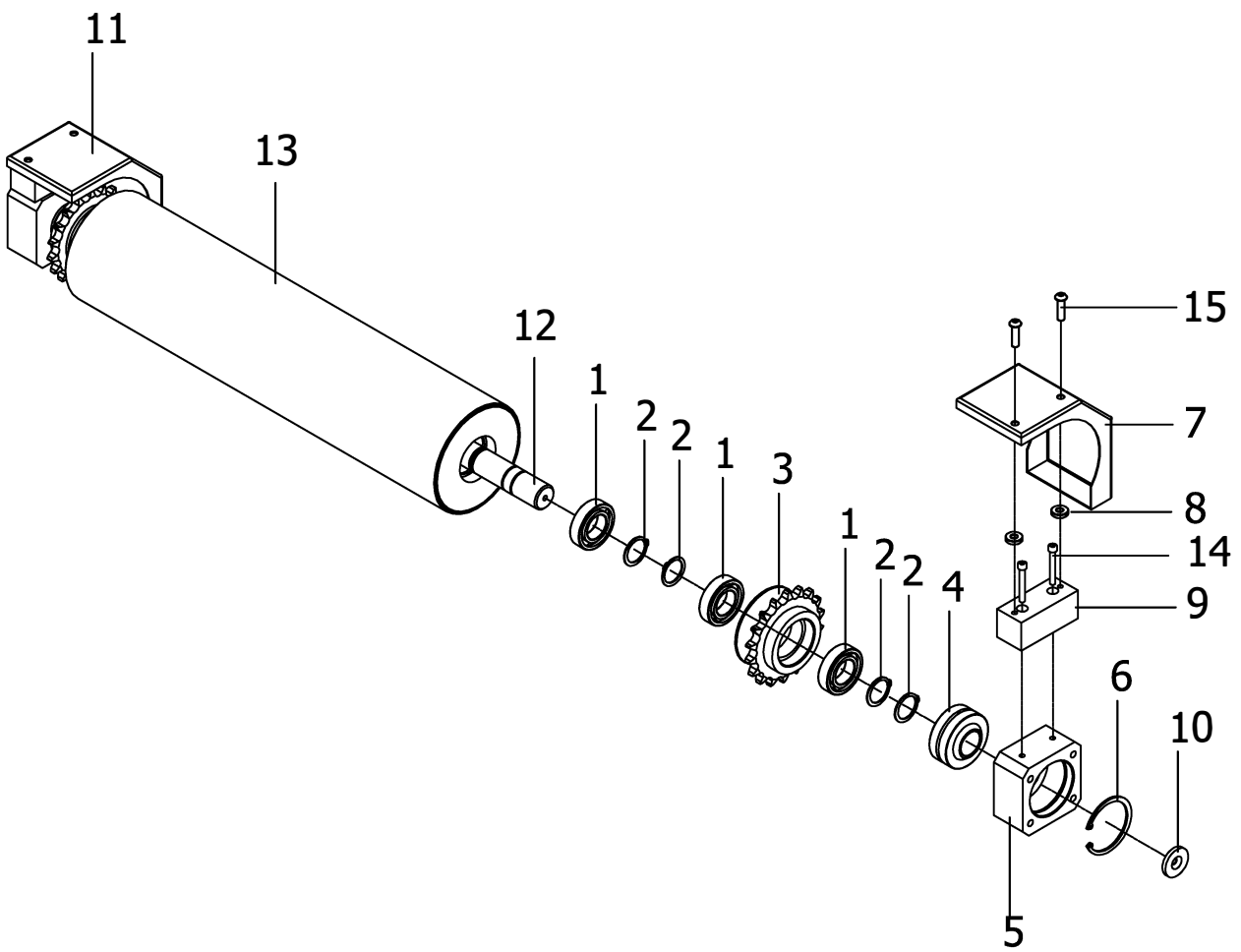
Promax

Idler Roller



Promax

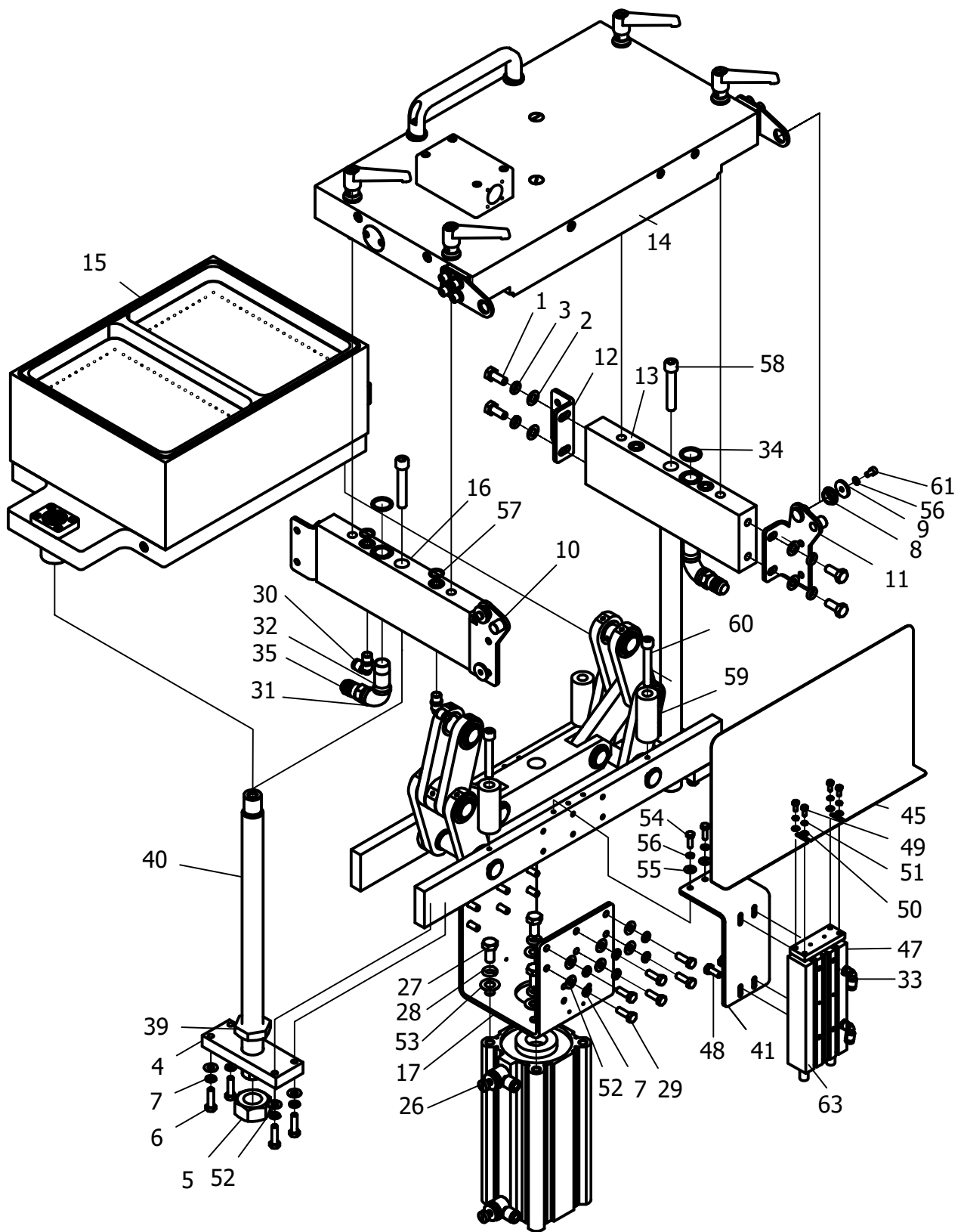
Idler Sprocket

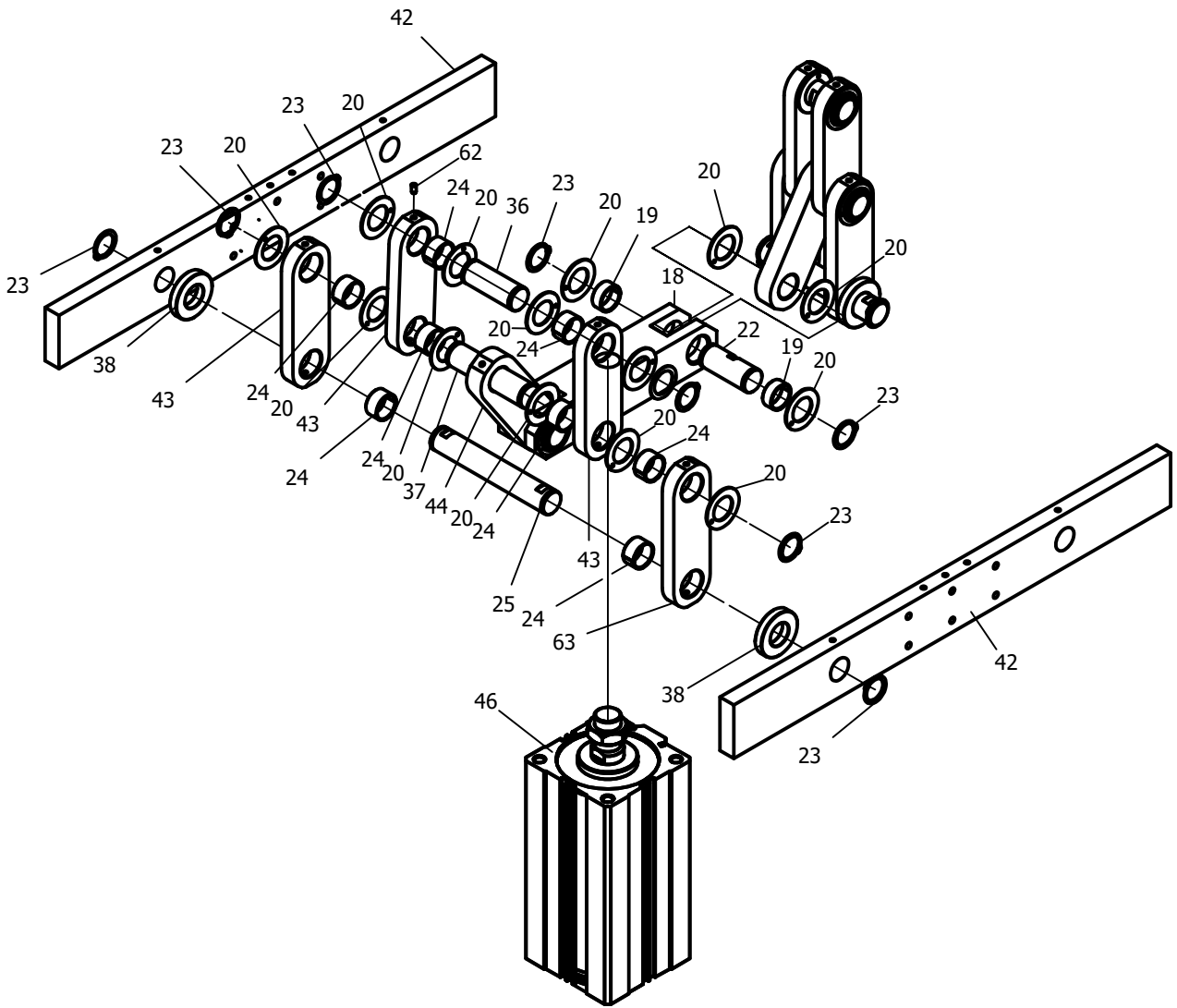


Promax

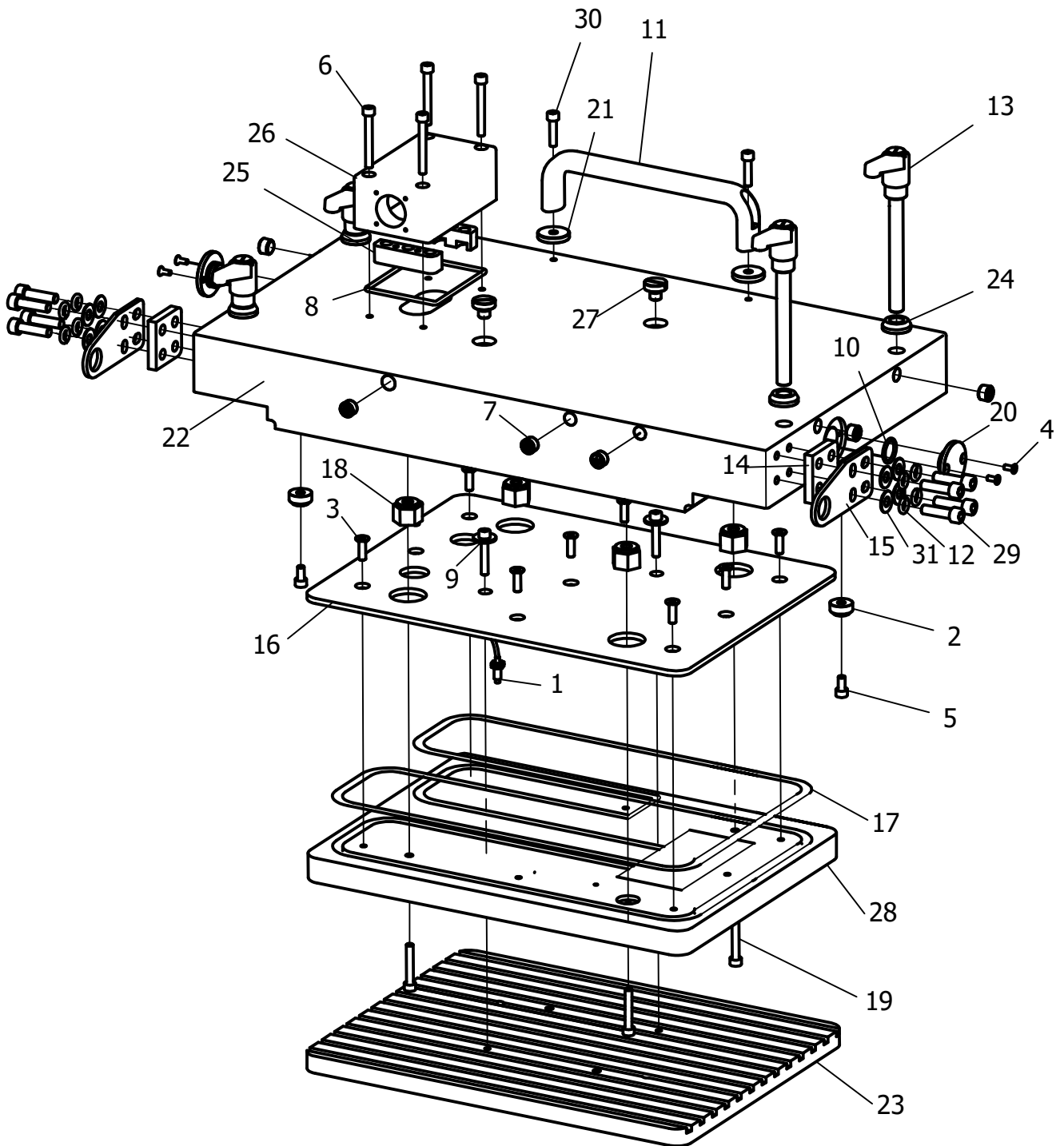
Infeed Roller

N0.	PART NO.	DESCRIPTION	QTY	NOTE
1	27280454	Bearing	6	
2	27060171	Lock Ring S25	8	
3	RS4N147002	Infeed Sprocket	2	
4	27284342	Self Aligning Bearing	2	
5	RS39117020	Bearing Housing	2	
6	27062201	Lock Ring R55	2	
7	RS39117042	Infeed Side Cover - L	1	
8	RS4N148000	Washer	4	
9	RS66164000	Infeed Side Cover Mounting Bracket	2	
10	RS4A143000	Washer	2	
11	RS39117032	Infeed Side Cover - R	1	
12	RS4N117010	Infeed Shaft	1	
13	RS4N118000	Infeed Roller Cylinder	1	
14	27011551	Hex Socket Head Bolt M6x35	4	
15	27040053	Flat Round Head Hex Socket Screw M6x12	4	





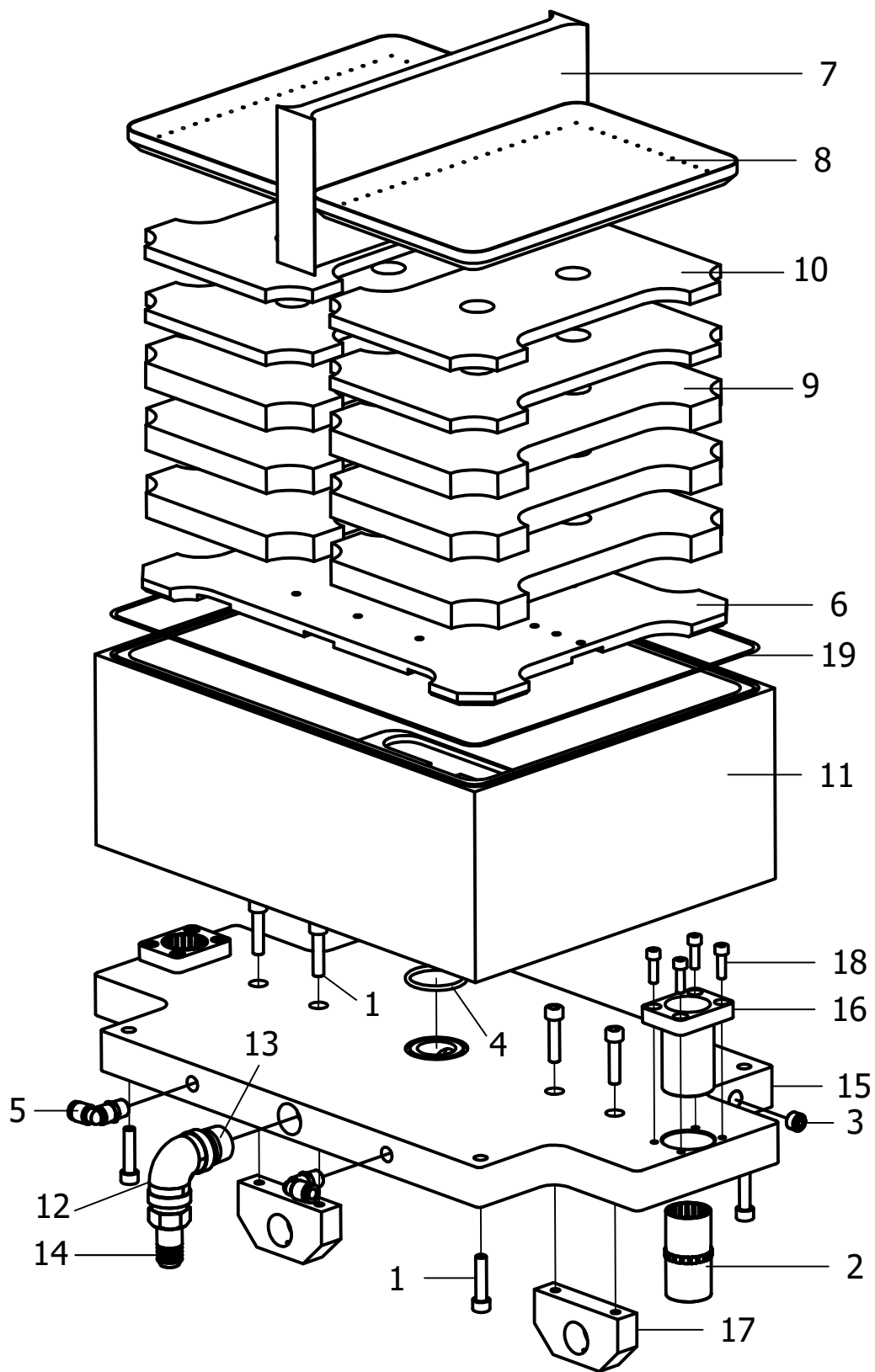
N0.	PART NO.	DESCRIPTION	QTY	NOTE
1	2700400	Hex Head Bolt M10x25L	8	
2	27046155	Flat Washer M10	8	
3	27141132	Spring Washer M10	8	
4	RS39406000	Lifting System Shaft Base Mount Bracket	2	
5	2707229	Nut M30	2	
6	2700427	Hex Head Bolt M8x30L	8	
7	2705301	Spring Washer M8	20	
8	RS4A418000	Die Hinge Bushing	2	
9	RS4A419000	Washer	2	
10	RS39422000	Die Hinge - Frame - L	1	
11	RS39423000	Die Hinge - Frame - R	1	
12	RS39421000	Lifting System Shaft Top Mount Plate	2	
13	RS4M402000	Lifting System Shaft Top Frame Mount Bracket - L	1	
14	RS4M403000	Forming Die (Upper)	1	
15	RS4M404000	Forming Die (Lower)	1	
16	RS4M401000	Lifting System Shaft Top Frame Mount Bracket - R	1	
17	RS4M414000	Lifting System 'U' Base Plate	1	
18	RS39408000	Lifting System - Cylinder Shaft Connector	1	
19	272832512	Dry Bearing	4	
20	27280201	Spacer (Nylon Coated)	32	
	Not Used	Not Used		
22	RS39410000	Shaft-B	2	
23	27060171	Lock Ring	16	
24	272832532	Dry Bearing	16	
25	RS39416000	Shaft - D	2	
26	29080200	One Touch ' L' Connector with Air Regulator Knob		
27	2700457	Hex Head Bolt M12x25	4	
28	2714813	Spring Washer M12	4	
29	2700405	Hex Head Bolt M8x25L	12	
30	2909345	One Touch ' L' Connector	2	
31	27400066S	Fitting	2	
32	290932651	Nipple	2	
33	2909321	One Touch ' L' Connector	2	
34	27401587	O Ring	2	
35	29093336	One Touch ' Straight' Connector	2	
36	RS4N414000	Shaft - A	2	
37	RS4N415000	Shaft - C	2	
38	RS4N416000	Spacer - White Plastic	4	
39	RS66407000	Nut M30	2	
40	RS4M413000	Vertical Shaft	2	
41	RS4M410000	Hand Safety Guard Cylinder Mounting Plate	1	
42	RS4N512001	Lifting System Base Bar	2	
43	RS4N509000	Lever - Inner	8	
44	RS4N511000	Lever - Cental	2	
45	RS4M411000	Hand Safety Guard Plate	1	
46	29201928	Lifting System Main Air Cylinder	1	

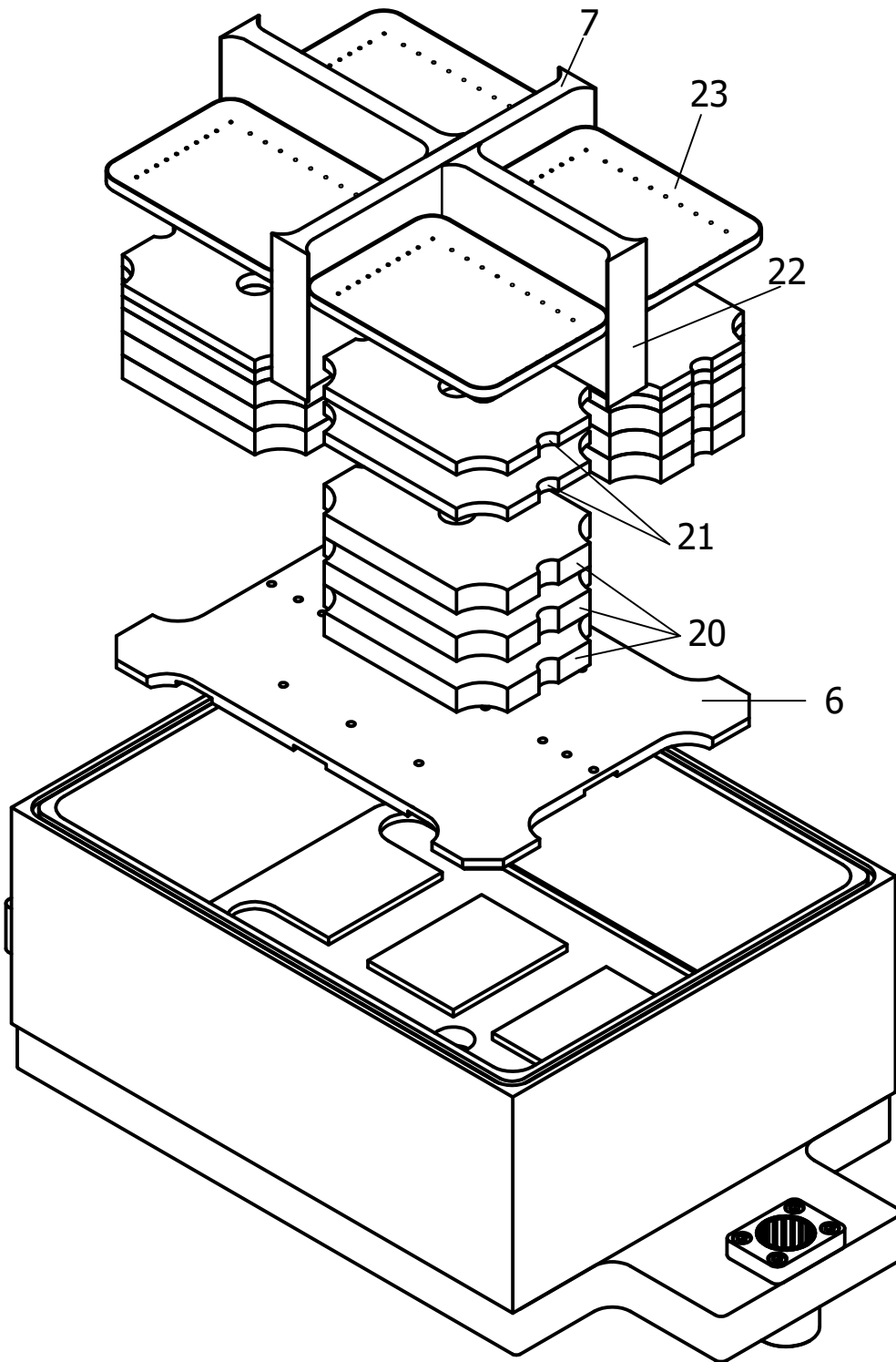


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Forming Die (Upper).

NØ.	PART NO.	DESCRIPTION	QTY	NOTE
1	2856192	Thermocouple	1	
2	RS42462001	Die Positioning Sleeve	2	
3	27020841	Countersunk Screw Flat Socket Head M6x20L	9	
4	2702090	Countersunk Screw Flat Socket Head M4x10L	4	
5	2701151	Hex Socket Head Bolt M6x12L	2	
6	27011821	Hex Socket Head Bolt M6x50	4	
7	2909013	Hex Socket Set plug	7	
8	27401511	O Ring	1	
9	RS4A406000	Set Screw	2	
10	27401633	O Ring	2	
11	2740244	Die Fix Handle	1	
12	2705301	Spring washer M8	8	
13	RS4A433000	Die Ratchet Handle	4	
14	RS39403080	Die Hinge Spacer - Black Plastic	2	
15	RS4N403070	Die Hinge Connector Plate - 4 Holes	2	
16	RS4M403040	Heating Plate Cover	1	
17	RS4M403020	Heating Element	1	
18	RS4N403020	Heating Plate - Die Spacer	4	
19	27011551	Hex Socket Head Bolt M6x35	4	
20	RS4N403080	Die Plug	2	
21	RS4N403090	Die Fix Handle Spacer	2	
22	RS4M403010	Main Forming Die Top Body	1	
23	RS4M403050	Teflon Heating Plate	1	
24	RS42577003	Ratchet Handle Spacer	4	
25	RS4M403080	Die Electrical Connection Terminal	2	
26	RS39403060	Die Electrical Wiring Box	1	
27	RS4A407012	Die Top Plug Bolt - Beige Plastic	2	
28	RS4M403030	Heating Plate	1	
29	2701174	Hex Socket Head Bolt M8x30L	8	
30	2701154	Hex Socket Head Bolt M6x25L	2	
31	2705152	Flat Washer M8	8	



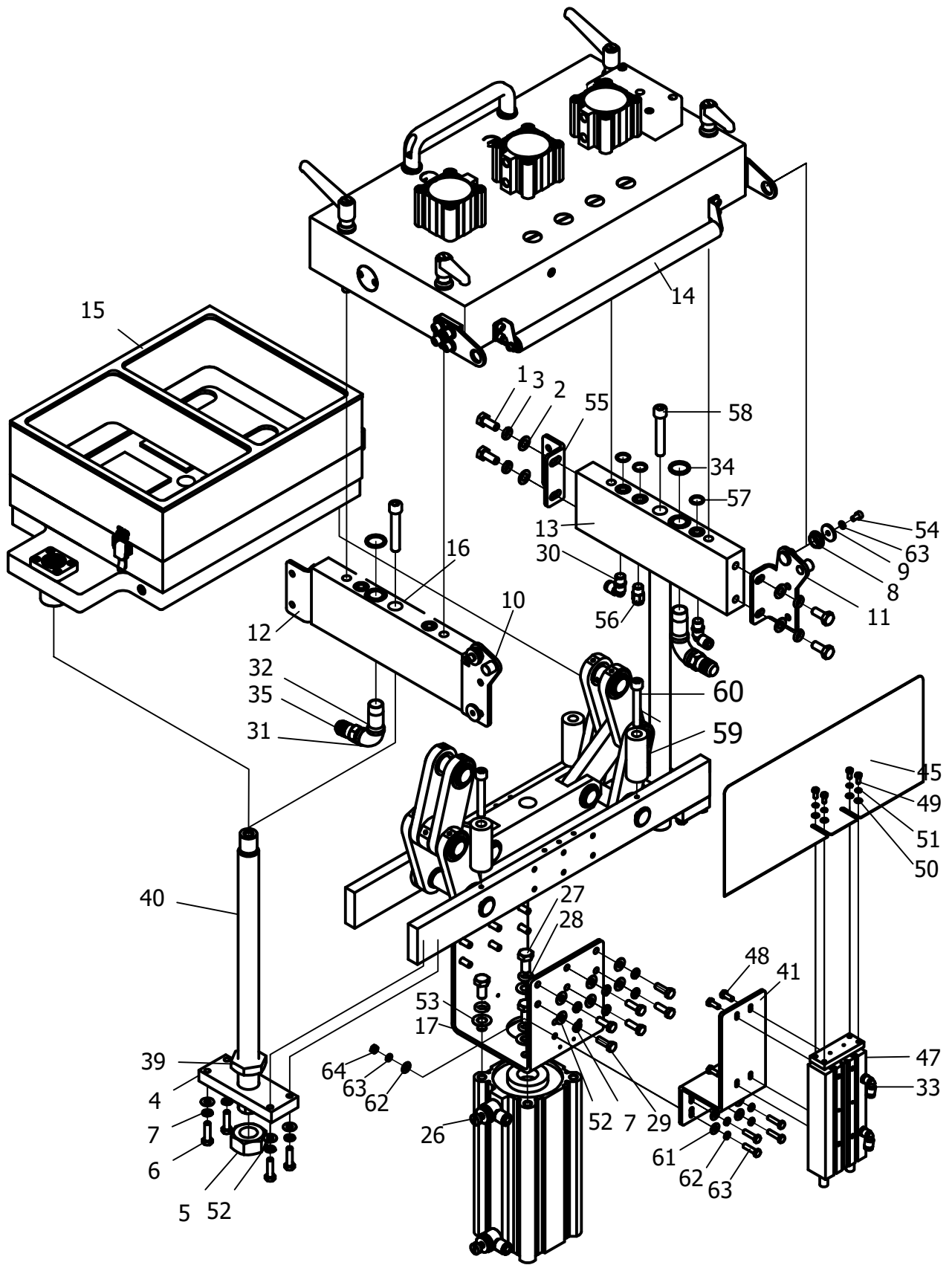


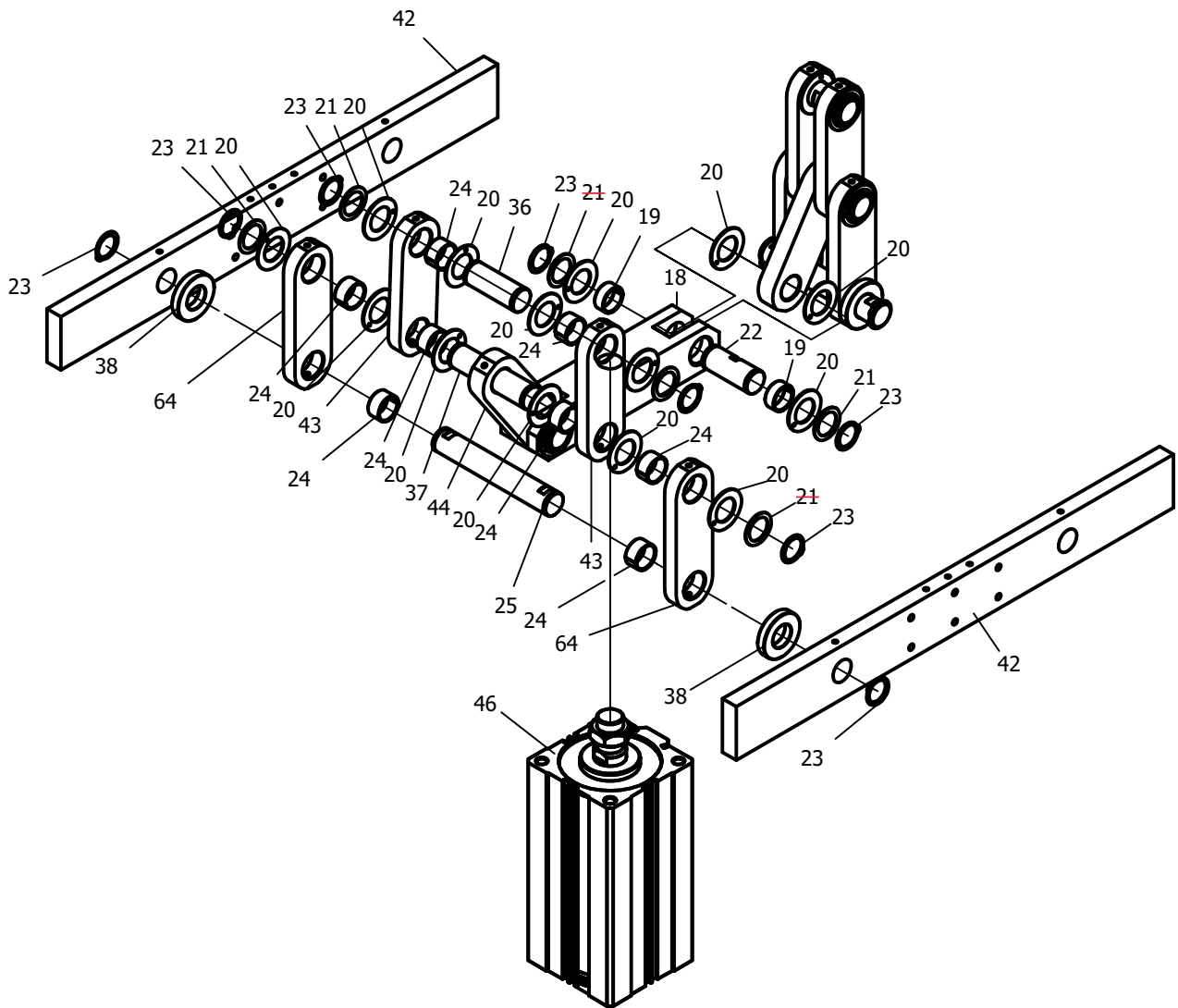
Promax

Forming Die (Lower).

4 UP / 2T2R

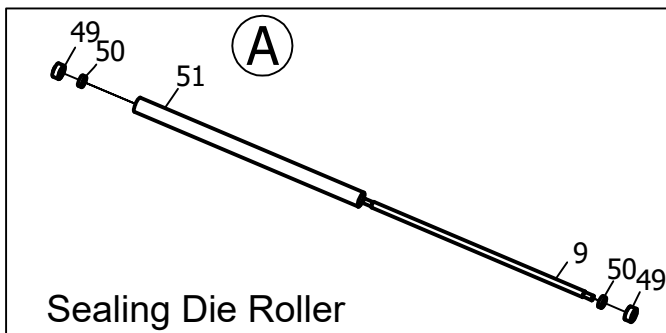
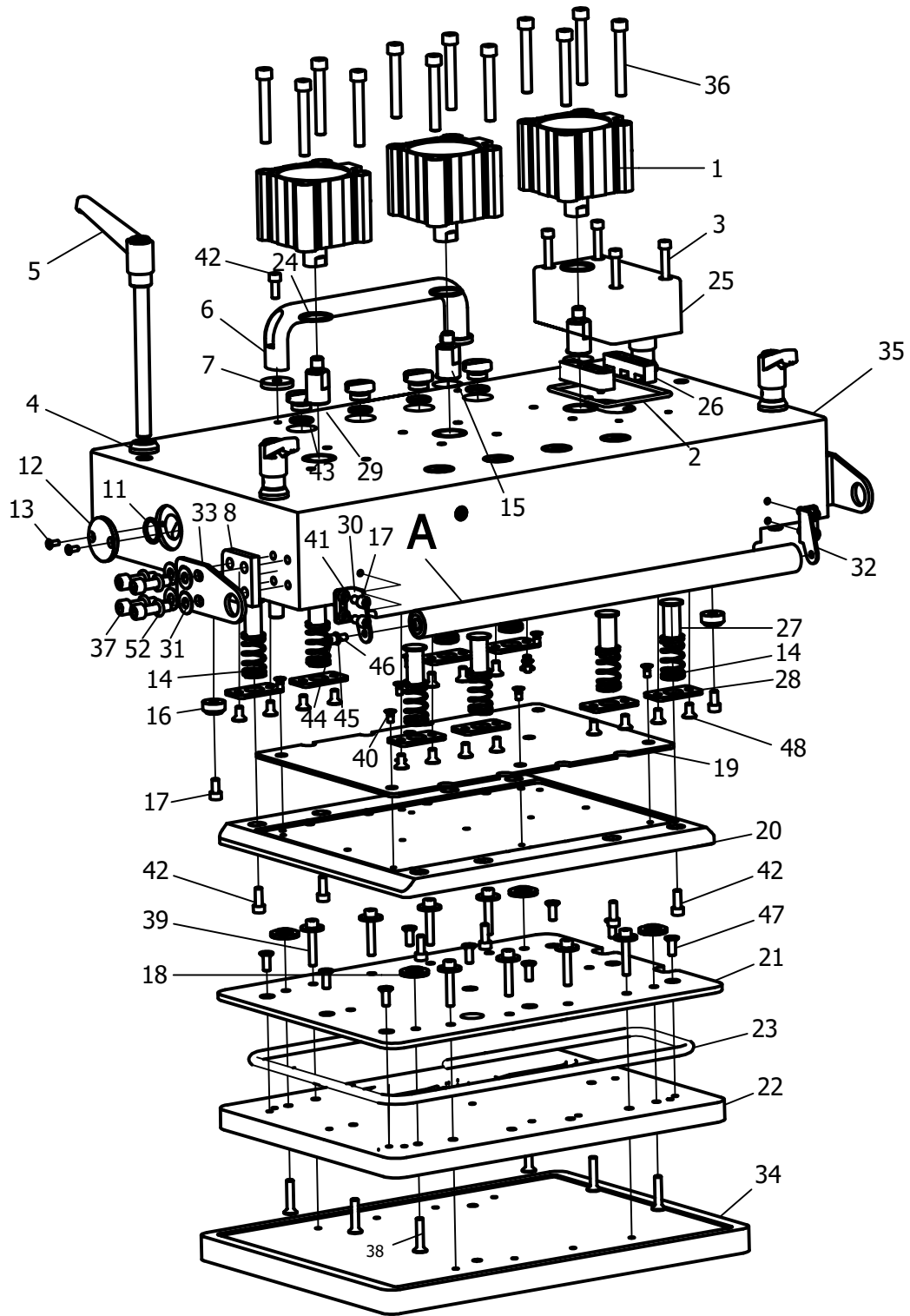
N0.	PART NO.	DESCRIPTION	QTY	NOTE
1	2701179	Hex Socket Head Bolt M8x35L	8	
2	27281066	Bushing - White Plastic	2	
3	2909013	Hex Socket Head Set Plug	1	
4	27401564	O Ring	1	
5	2909345	One Touch 'L' Connector	2	
6	RS4M404190	Die - Forming Plate - Metal (2 Pockets)	1	
7	RS4M404120	Die - Inner Divider (2 UP)	1	
8	RS4M404110	Die - Inner Bottom Plate - Metal	2	
9	RS4M404120	Die - Depth Spacer - White Plastic - 2 Pockets	6	
10	RS4M404110	Die - Depth Spacer - White Plastic - 2 Pockets	4	
11	RS4M404010	Forming Die (Lower)	1	
12	2740006A1	Fitting	1	
13	29092183	Nipple	1	
14	2909250	Fitting	1	
15	RS4M404080	Forming Lower Die Base Plate	1	
16	RS4T404110	Bushing Bracket	2	
17	RS4T404120	Lifting System Connector Piece	2	
18	2701153	Hex Socket Head Bolt M6x20L	8	
19	31144515	Round-Gasket	1	
20	RS4M404130	Die - Depth Spacer - White Plastic - 4 Pockets	12	
21	RS4M404070	Die - Depth Spacer - White Plastic - 4 Pockets	8	
22	RS4M404060	Die - Inner Divider (4 UP)	1	
23	RS4M404070	Die - Forming Plate - Metal (4 Pockets)	4	



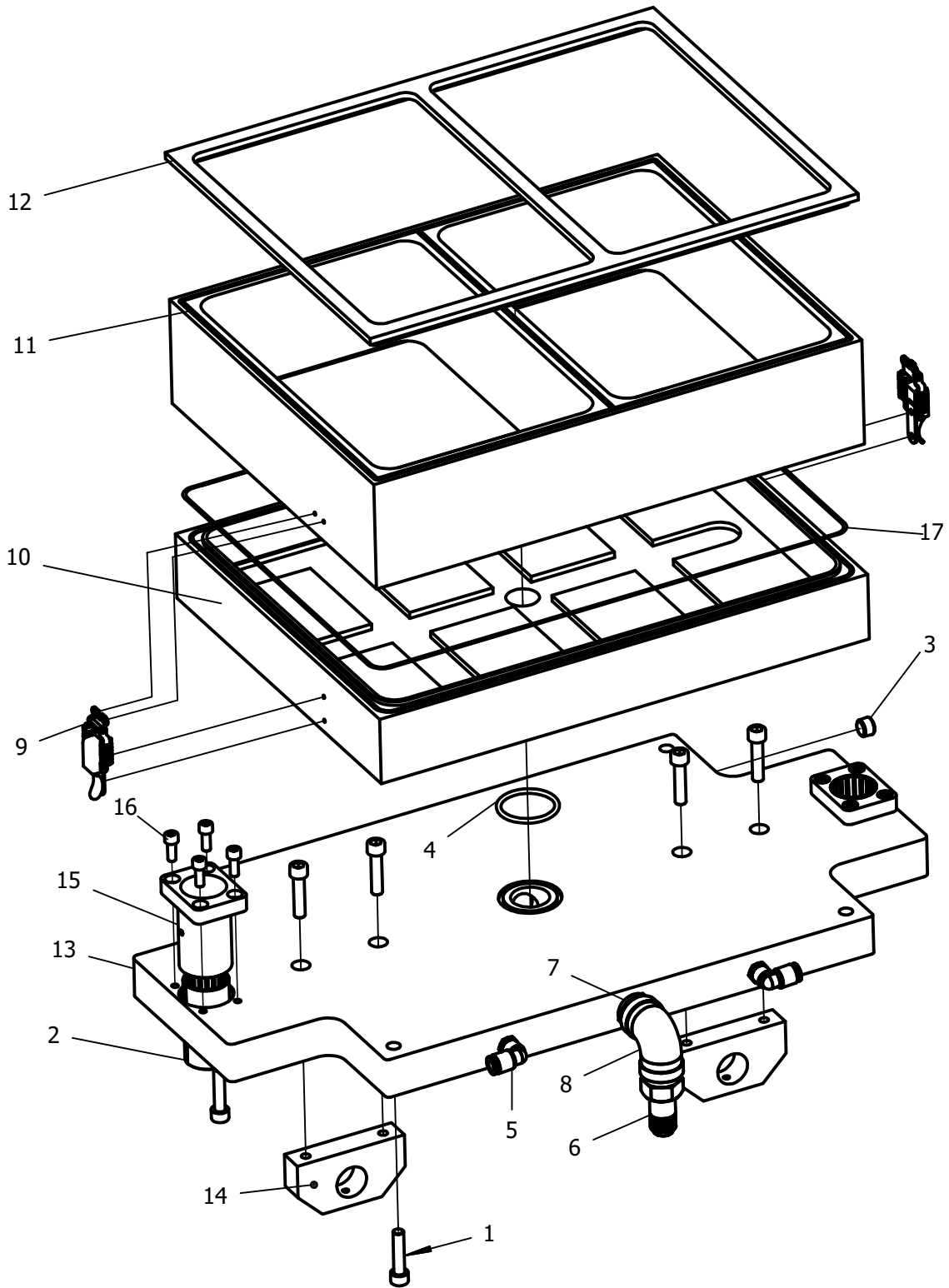


N0.	PART NO.	DESCRIPTION	QTY	NOTE
1	2700400	Hex Head Bolt M10x25L	8	
2	27046155	Flat washer M10	8	
3	27141132	Spring Washer 1/2"	8	
4	RS39406000	Lifting System Shaft Base Mount Bracket	2	
5	2707229	Nut M30	2	
6	2700427	Hex Head Bolt M8x30L	8	
7	2705301	Spring Washer M8	20	
8	RS4A418000	Die Hinge Bushing	2	
9	RS4A419000	Washer	2	
10	RS39422000	Die Hinge - Frame	1	
11	RS39423000	Die Hinge - Frame	1	
12	RS39421000	Lifting System Shaft Top Mount Plate	2	
13	RS4M501000	Lifting System Shaft Top Frame Mount Bracket - R	1	
14	RS4M506000	Sealing Die Roller	1	
15	RS4M504000	Sealing Die Gasket	1	
16	RS4M402000	Lifting System Shaft Top Frame Mount Bracket - L	1	
17	RS4M414000	Lifting System 'U' Base Plate	1	
18	RS39408000	Lifting System - Cylinder Shaft Connector	1	
19	272832512	Dry Bearing	4	
20	27280201	Spacer (Nylon Coated)	32	
	Not Used	Not Used		
22	RS39410000	Shaft - B	2	
23	27060171	Lock Ring	16	
24	272832532	Dry Bearing	16	
25	RS39416000	Shaft - D	2	
26	29080200	One Touch ' L' Connector with Air Regulator Knob		
27	2700457	Hex Head Bolt M12x25L	4	
28	2714813	Spring Washer M12	4	
29	2700405	Hex Head Bolt M8x25L	12	
30	2909345	One Touch ' L' Connector	2	
31	27400066S	Fitting	2	
32	290932651	Nipple	2	
33	2909321	One Touch ' L' Connector	2	
34	27401587	O Ring	2	
35	2909239	Fitting	2	
36	RS4N414000	Shaft - A	2	
37	RS4N415000	Shaft - C	2	
38	RS4N416000	Spacer - White Plastic	4	
39	RS66407000	Nut M30	2	
40	RS4M413000	Vertical Shaft	2	
41	RS4M410000	Hand Guard Cylinder Mounting Plate	1	
42	RS4N512001	Lifting System Base Bar	2	
43	RS4N509000	Lever - Inner	8	
44	RS4N511000	Lever - Cental	2	
45	RS4M411000	Safety Guard	1	
46	29201928	Lifting System Nain Air Cylinder	1	

N0.	PART NO.	DESCRIPTION	QTY	NOTE
47	29201929	Safety Guard Cylinder	1	
48	2700402	Socket Set Screw M6x8L	4	
49	2700414	Hex Head Bolt M5x12L	2	
50	2705150	Flat Washer M5	2	
51	2705303	Spring Washer M5	2	
52	2705152	Flat Washer M8	20	
53	2705137	Flat Washer M12	4	
54	2701195	Hex Socket Head Bolt M6x20L	2	
55	RS39505000	Lifting System Shaft Top Mount Plate	1	
56	2909461	One Touch ' Straight' Connector	2	
57	27401631	O Ring P16	3	
58	27004580	Hex Socket Head Bolt M12x70L	2	
59	RS4N515000	Spacer - Green Nylon	4	
60	2700470	Hex Socket Head Bolt M6x55L	4	
61	27046151	Flat Washer M6	7	
62	270461511	Spring Washer M5	9	
63	27004011	Hex Head Bolt M6x20	7	
64	RS4N510000	Lever - Outter	8	

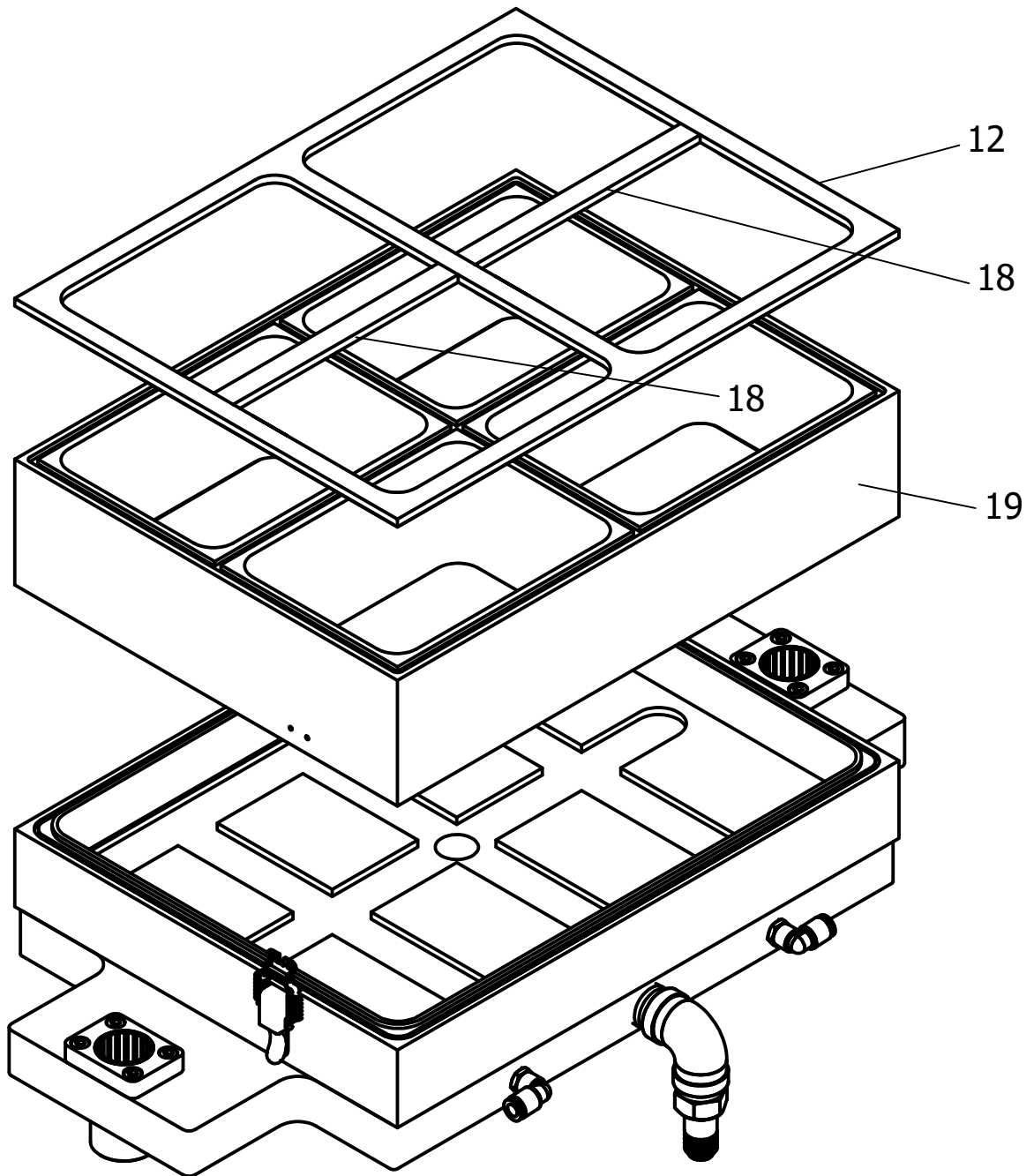


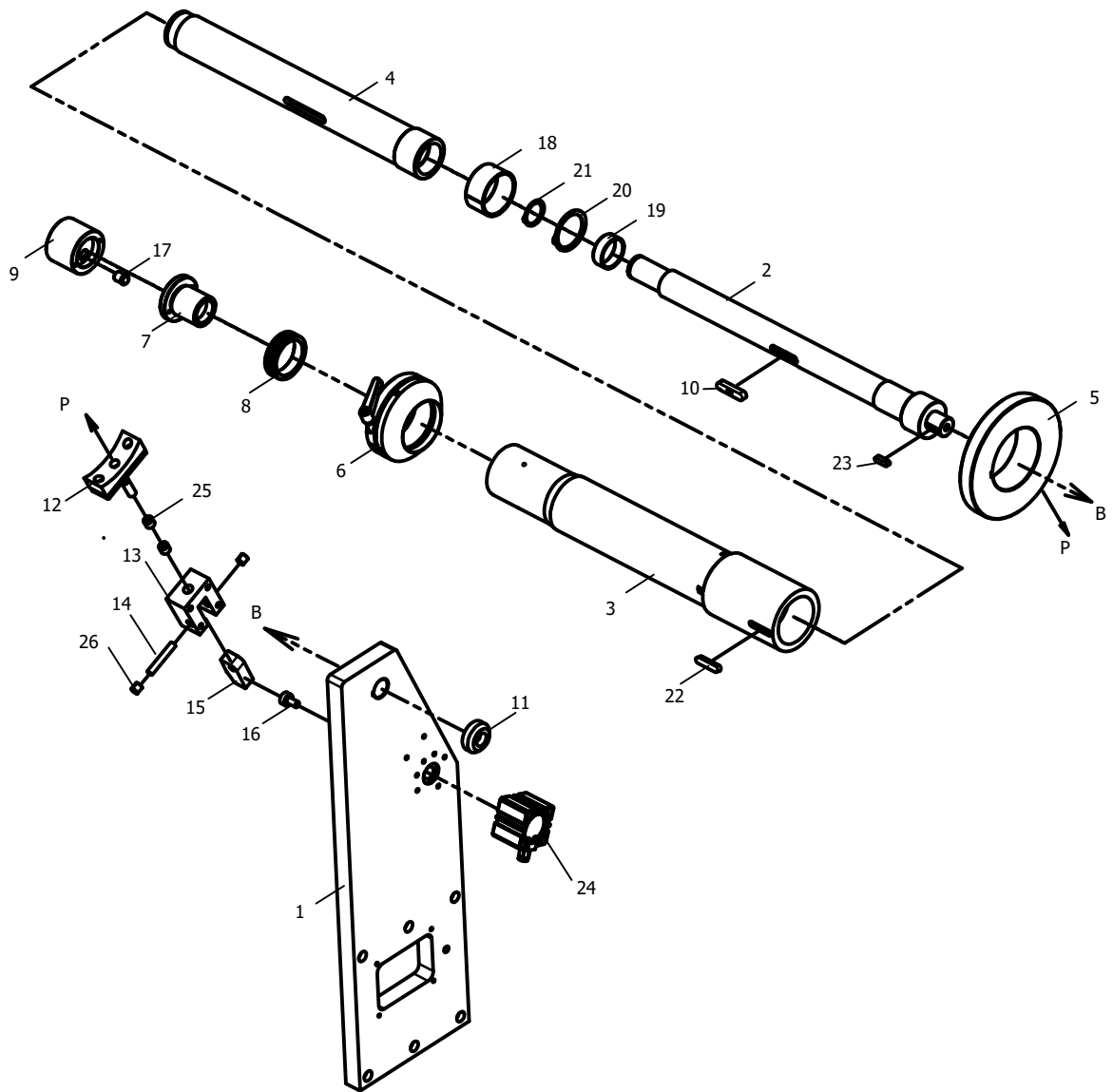
N0.	PART NO.	DESCRIPTION	QTY	NOTE
1	29201930	Sealing Die Top Cylinder	3	
2	27401511	O Ring	1	
3	27011821	Hex Socket Head Bolt M6x50	4	
4	RS42577003	Ratchet Handle Spacer	4	
5	RS4N533000	Ratchet Handle	4	
6	2740244	Die Fix Handle	1	
7	RS4N403090	Die Fix Handle Spacer	2	
8	RS39403080	Die Ratchet Handle Spacer - Black Plastic	2	
9	RS4N508010	Sealing Die Roller Shaft	1	
10	2909013	Hex Socket Set Plug	3	
11	27401633	O Ring	2	
12	RS4N403080	Die Plug	2	
13	2702090	Countersunk Flat Socket Head Screw M4x10L	4	
14	RS4A502110	Spring	8	
15	RS4T502090	Shaft	3	
16	RS42462001	Die Positioning Sleeve	2	
17	2701151	Hex Socket Head Bolt M6x12L	6	
18	RS39502040	Heating Plate Alighning Spacer	4	
19	RS4M506100	Heat Insulation Board	1	
20	RS4M506110	Heat Insulation Plate	1	
21	RS4M506120	Heater Plate Cover	1	
22	RS4M506130	Heating Plate	1	
23	RS4M403020	Heating Element	1	
24	27060171	O Ring	3	
25	RS39403060	Die Electrical Wiring Box	1	
26	RS4M403081	Die Electrical Connection Terminal	2	
27	RS4A502122	Heat Insulation Plate Alignment Shaft	8	
28	RS4A502142	Heat Insulation Plate Alignment Shaft Holder	8	
29	RS4N502210	Die Top Plug Bolt - Beige Plastic	8	
30	RS32502130	Sealing Die Roller Hinge - L	1	
31	2705152	Flat Washer M8	8	
32	RS32502120	Sealing Die Roller Hinge - R	1	
33	RS4N403071	Die Hinge Connector Plate - 4 Holes	2	
34	RS4M506020	Teflon Sealing Plate	1	
35	RS4M506010	Main Sealing Die top body	1	
36	27010773	Hex Socket Head Bolt M8x60L	12	
37	2701174	Hex Socket Head Bolt M8x30L	8	
38	2702086	Countersunk Screw Flat Socket Head M6x30L	6	
39	RS4A406000	Set Screw	8	
40	2702267	Countersunk Screw Flat Socket Hhead M5x10L	8	
41	270461511	Spring washer M6	4	
42	2701152	Hex Socket Head Screw M6x16L	10	
43	27401631	O Ring	8	
44	2701165	Hex Socket Head Bolt M5x12L	2	
45	2705303	Spring Washer M5	2	
46	2705150	Flat Washer M5	2	



Promax

Sealing Die (Lower).
2 UP/ 2T1R

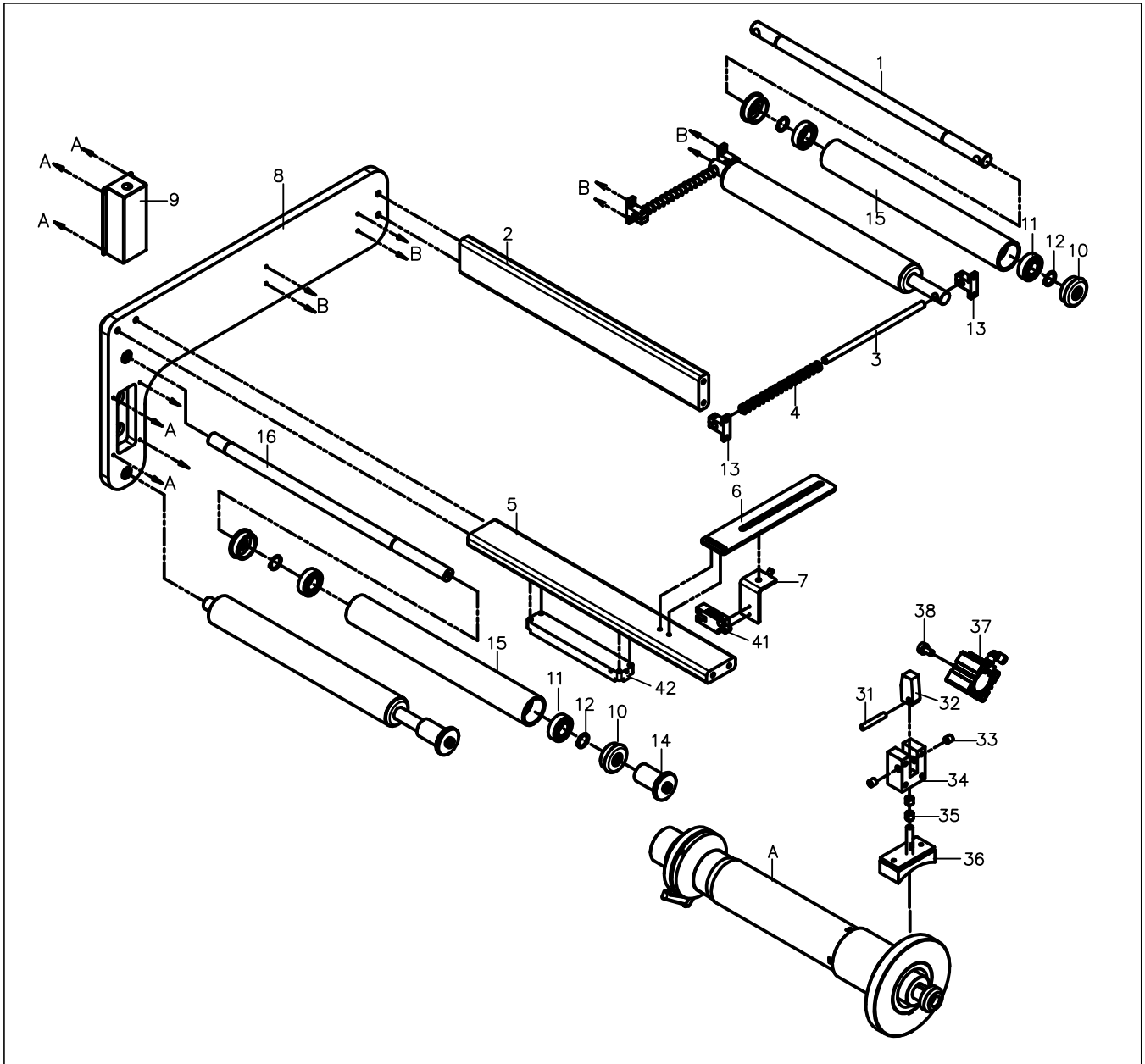




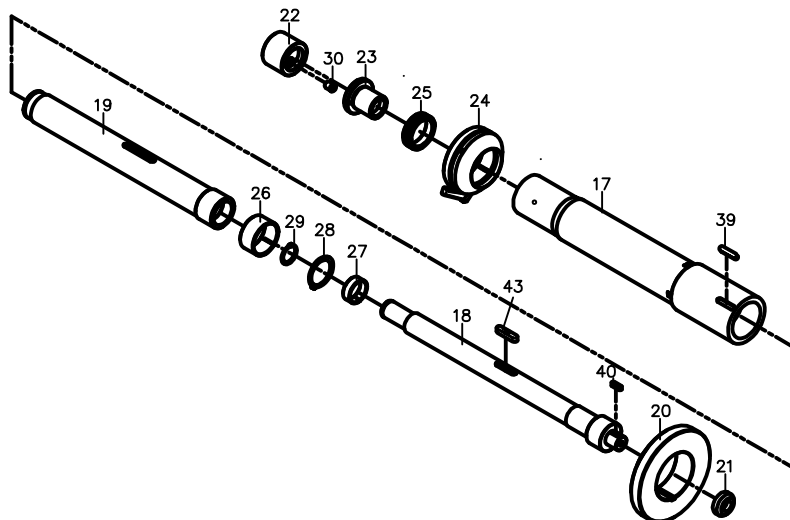
Promax

Bottom Web System

NO.	PART NO.	DESCRIPTION	QTY	NOTES
1	RS32301001	Fixed plate	1	
2	RS4N712002	Shaft	1	
3	RS4N713003	Bottom Rack Outer Roller	1	
4	RS4N714001	Bottom Rack Inner Roller	1	
5	RS4N306000	Disk Brake	1	
6	RS4N315000	Film Roll Lock	1	
7	RS4N722000	Inner Adjustment Nut (Brass)	1	
8	RS4N316001	Bushing - White Plastic	1	
9	RS4N308000	Rack - Outer Adjustment Knob	1	
10	RS4N305000	Key	1	
11	RS4N309000	Washer	1	
12	RS4N313000	Brake Pad	1	
13	RS4N310000	Brake Mount	1	
14	RS4N312000	Shaft	1	
15	RS4N311000	Brake Lever	1	
16	RS4N314000	Shaft	1	
17	2701804	Ball Bolt	1	
18	27283426	Dried Bearing	1	
19	27283427	Dried Bearing	1	
20	2706037	Lock Ring	1	
21	27060091	Lock Ring	1	
22	2709041	Key	1	
23	2709201	Key	1	
24	2927642	Pneumatic Brake Cylinder	1	
25	2728304	Dried Bearing	2	
26	2728308	Dried Bearing	2	



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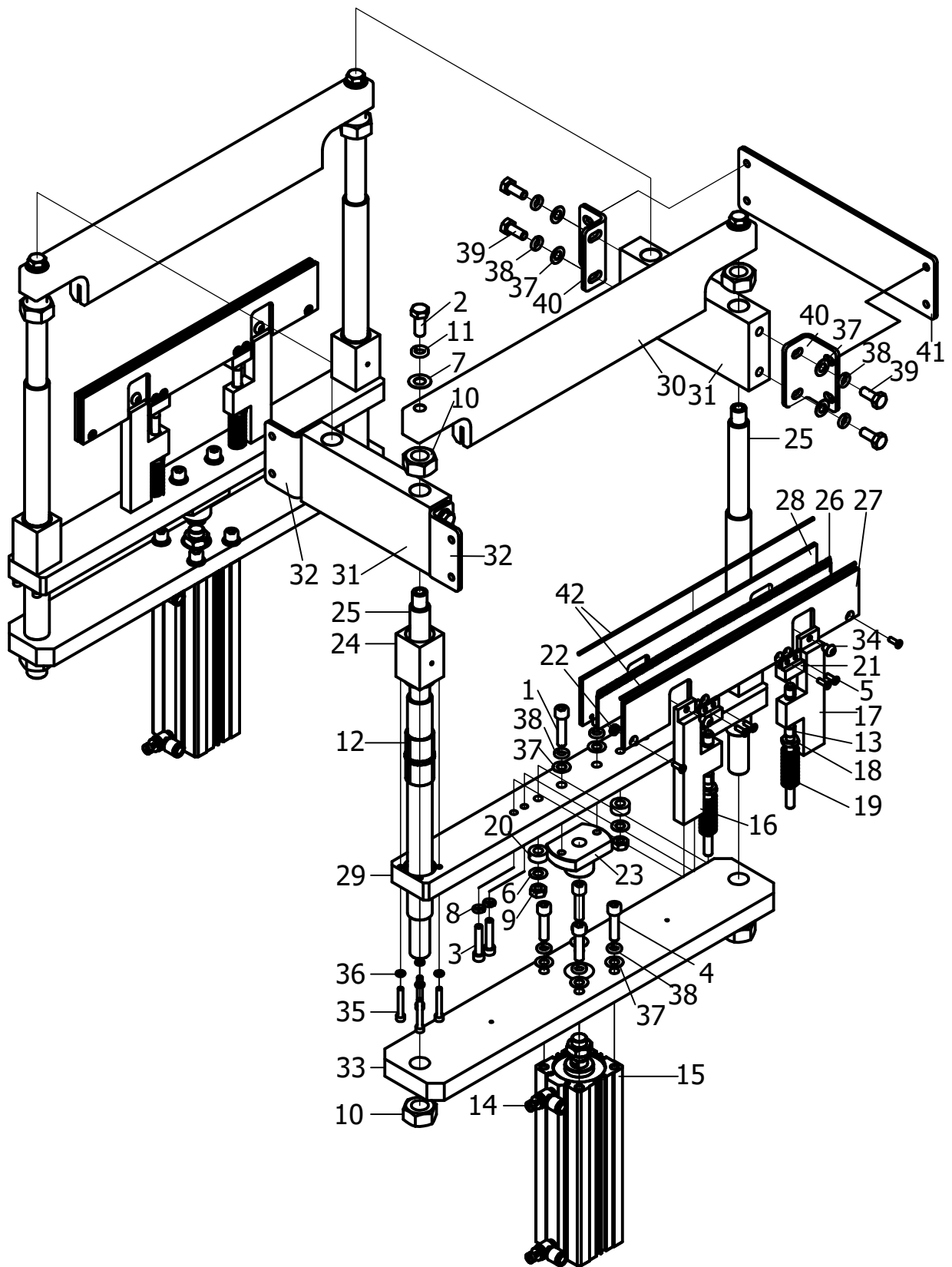
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Top Web System.

NO.	PART NO.	DESCRIPTION	QTY	NOTES
1	RS4M706010	Top Tension Roller Shaft	1	
2	RS4M707000	Face Plate Side Beam	1	
3	RS3M705000	Top Tension Roller Spring Shaft	2	
4	RS3M740000	Spring	2	
5	RS4T704001	Face Plate Top Beam	1	
6	RS3M711000	Photoelectric Sensor Adjustment Plate	1	
7	RS3M719000	Photoelectric Sensor Mounting Bracket	1	
8	RS3M722000	Face Plate	1	
9	RS3M727000	Start/Stop Switches Rear Cover	1	
10	RS42233000	Top Film Guide Roller End Plug	6	
11	27280044	Bearing	2	
12	27060151	Lock Ring	1	
13	27281070	Top Tension Roller Spring Shaft Bracket	4	
14	RS4A719000	Film Guide Roller Mount Bushing	2	
15	RS4N705000	Roller Cylinder Tube	3	
16	RS4N706000	Top Film Guide Roller Shaft	2	
17	RS4N713003	Top Rack Outer Roller	1	
18	RS4N712002	Top Rack Shaft	1	
19	RS4N714001	Top Rack Inner Roller	1	
20	RS4N306000	Disk Brake	1	
21	RS4N309000	Top Rack Thick Washer	1	
22	RS4N308000	Rack - Outer Adjustment Knob	1	
23	RS4N722000	Inner Adjustment Nut (Brass)	1	
24	RS4N740000	Film Roll Lock	1	
25	RS4N316001	Bushing - White Plastic	1	
26	27283426	Dry Bearing	1	
27	27283427	Dry Bearing	1	
28	2706037	Lock Ring	1	
29	27060091	Lock Ring	1	
30	2701804	Ball Bolt	1	
31	RS4N312000	Shaft	1	
32	RS4N311000	Brake Lever	1	
33	2728308	Dry Bearing	2	
34	RS4N310000	Brake Mount	1	
35	2728304	Dry Bearing	2	

36	RS4N313000	Brake Pad	1	
37	2927648	Pneumatic Brake Cylinder	1	
38	RS4N314000	Shaft	1	
39	2709041	Key	1	
40	2709201	Key	1	
41	2850123	Film Sensor	1	
42	2927653	Top Flim Brake - Festo	1	
43	RS4N305000	Film Rack Shaft Key	1	

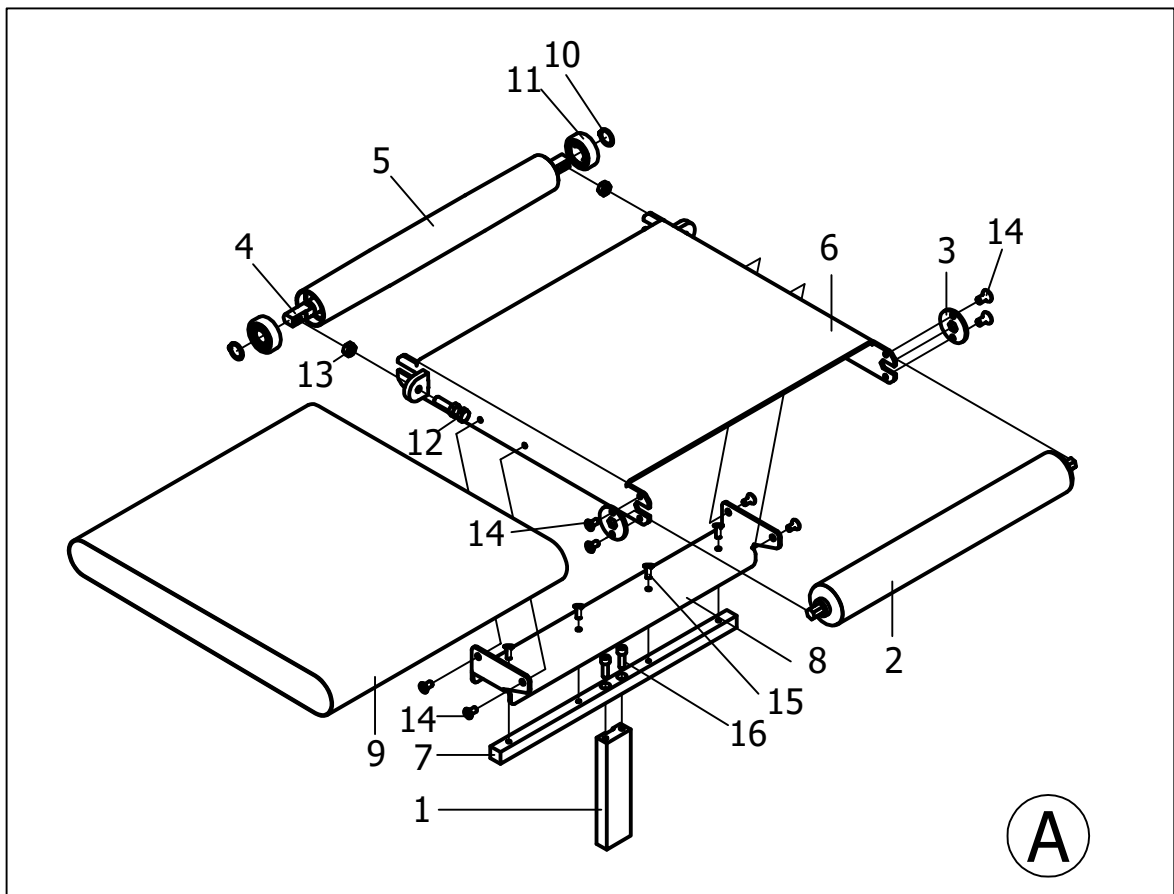
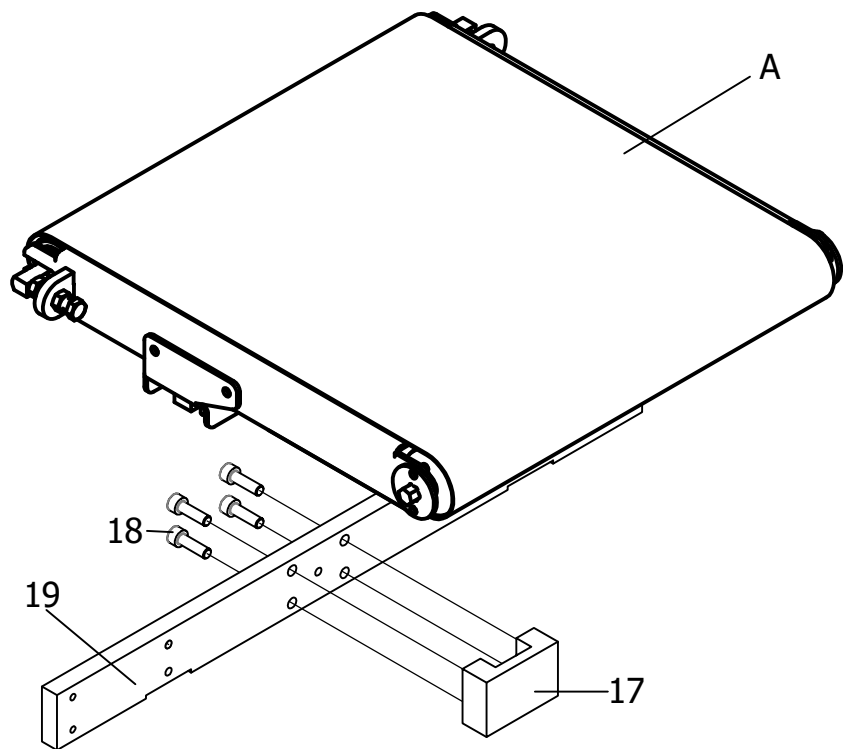
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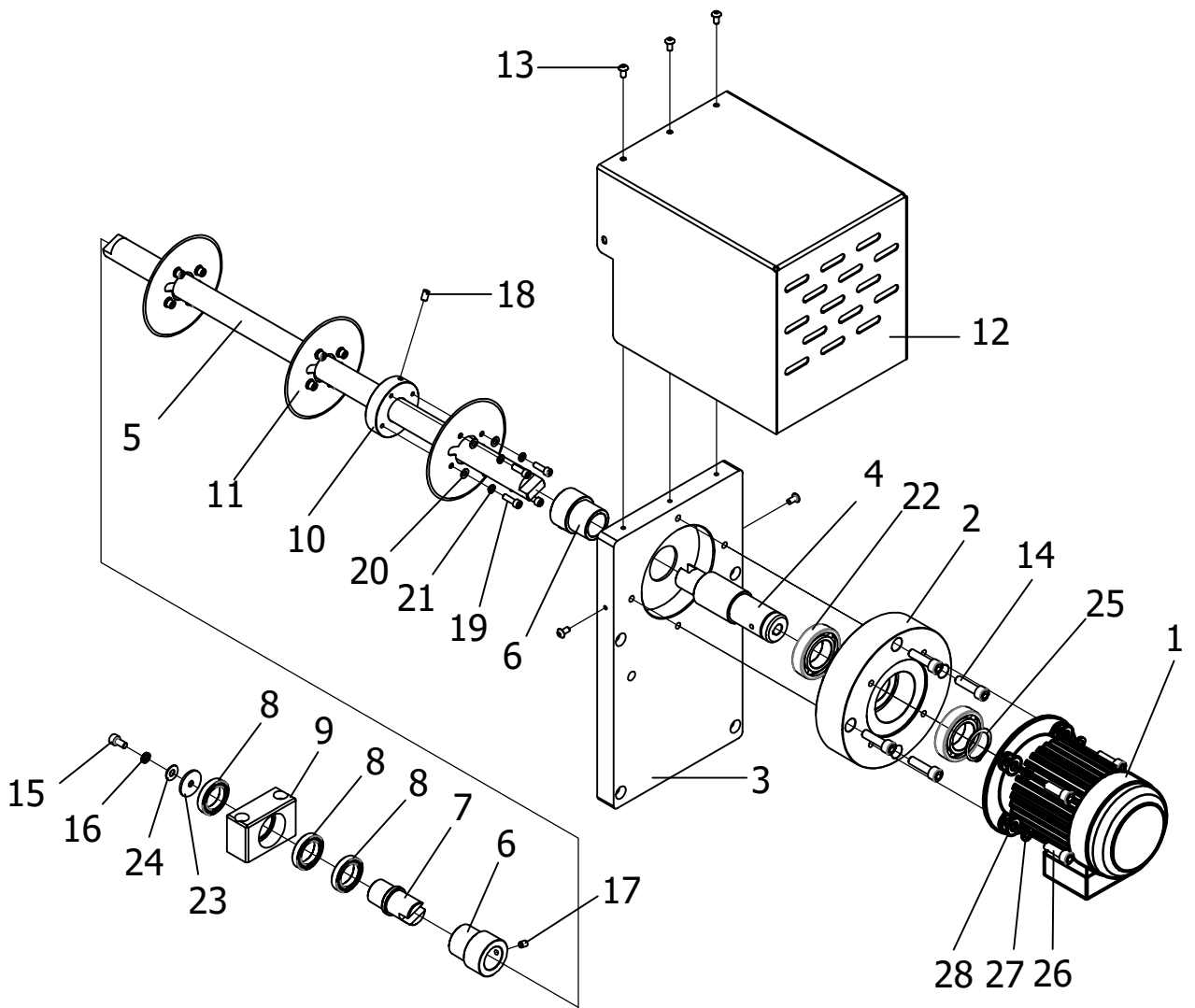
Cross Cutter.

N0.	PART NO.	DESCRIPTION	QTY	NOTE
1	2701091	Hex Socket Head Bolt M10x45L	4	
2	27004571	HexHead Bolt M12x30L	4	
3	2701157	Hex Socket Head Bolt M8x40L	8	
4	2700464	Hex Socket Head Bolt M10x40L	8	
5	2702081	Countersunk Flat Socket Head Screw M5x16L	12	
6	27046155	Flat Washer M10	4	
7	2705124	Flat Washer M12	4	
8	2705301	Spring Washer M8	8	
9	2707017	Nut M10	4	
10	2707072	Nut M24	8	
11	2714813	Spring Washer M10	4	
12	27281066	Bushing - Beige Plastic	4	
13	2728303	Dry Bearing	8	
14	2908020	One Touch ' L ' Connector with Air Regulator Knob		
15	2927661	Main Air Cylinder	2	
16	RS42607001	Guillotine Blade Holder - L	2	
17	RS42608001	Guillotine Blade Holder - R	2	
18	RS42610000	Spring Rod	4	
19	RS42611001	Spring	4	
20	RS42612000	Rubber Spacer	4	
21	RS42613000	Spring Rod - Guillotine Connector Bracket	4	
22	RS42616000	Guillotine Hosing Spacer	4	
23	RS4A602001	Main Air Cylinder - ' T ' Nut	2	
24	RS4A605001	Vertical Shaft Bushing Housing	4	
25	RS4A604002	Vertical Shaft	4	
26	RS4N606001	Guillotine Blade	2	
27	RS4N607001	Guillotine Blade Housing Bracket	2	
28	RS4N608001	Guillotine Blade Housing Bracket	2	
29	RS4N602000	Guillotine Sliding Base Plate	2	
30	RS4N603001	Guillotine Anvil Top	2	
31	RS4M604000	Guillotine System Shaft Top Frame Mounting Housing	2	
32	RS3M421000	Guillotine System - Frame Mounting 'L' Bracket	2	
33	RS4M601000	Guillotine Main Air Cylinder Plate	2	
34	2704005	Button Head Hex Socket Bolt M8x10	4	
35	2701180	Hex Socket Head Bolt M6x40	16	
36	270461511	Spring Washer M6	16	
37	27046155	Flat Washer M10	20	
38	27141132	Spring Washer M10	20	
39	27004001	Hex Head Bolt M10x20L	8	
40	RS4M505001	Guillotine - Frame Mounting 'L' Bracket	2	
41	RS4M605001	Guillotine - Frame Mounting Channel Plate - Tapped	1	
42	31144514	Gasket	4	



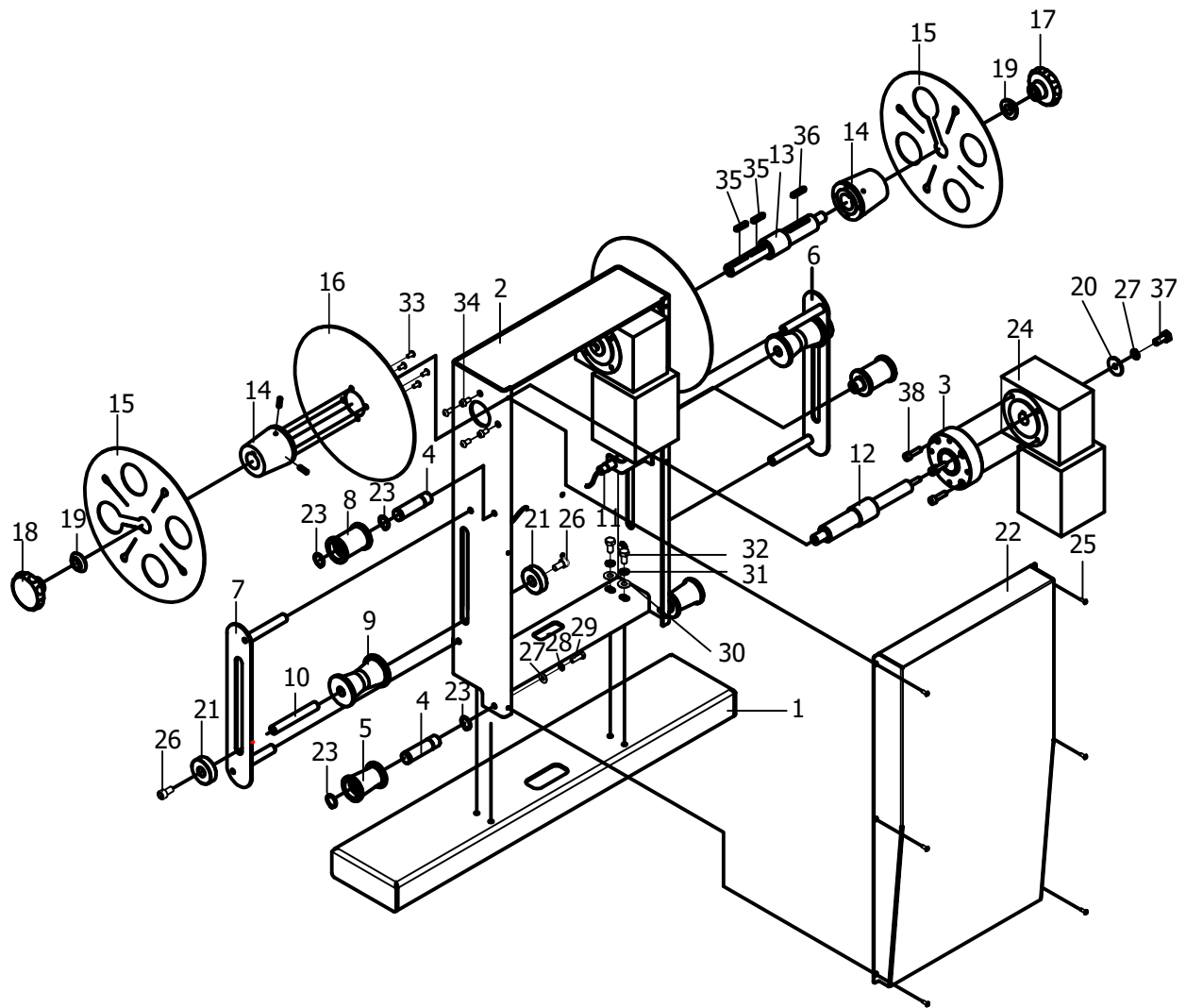
Promax

Exit Conveyor



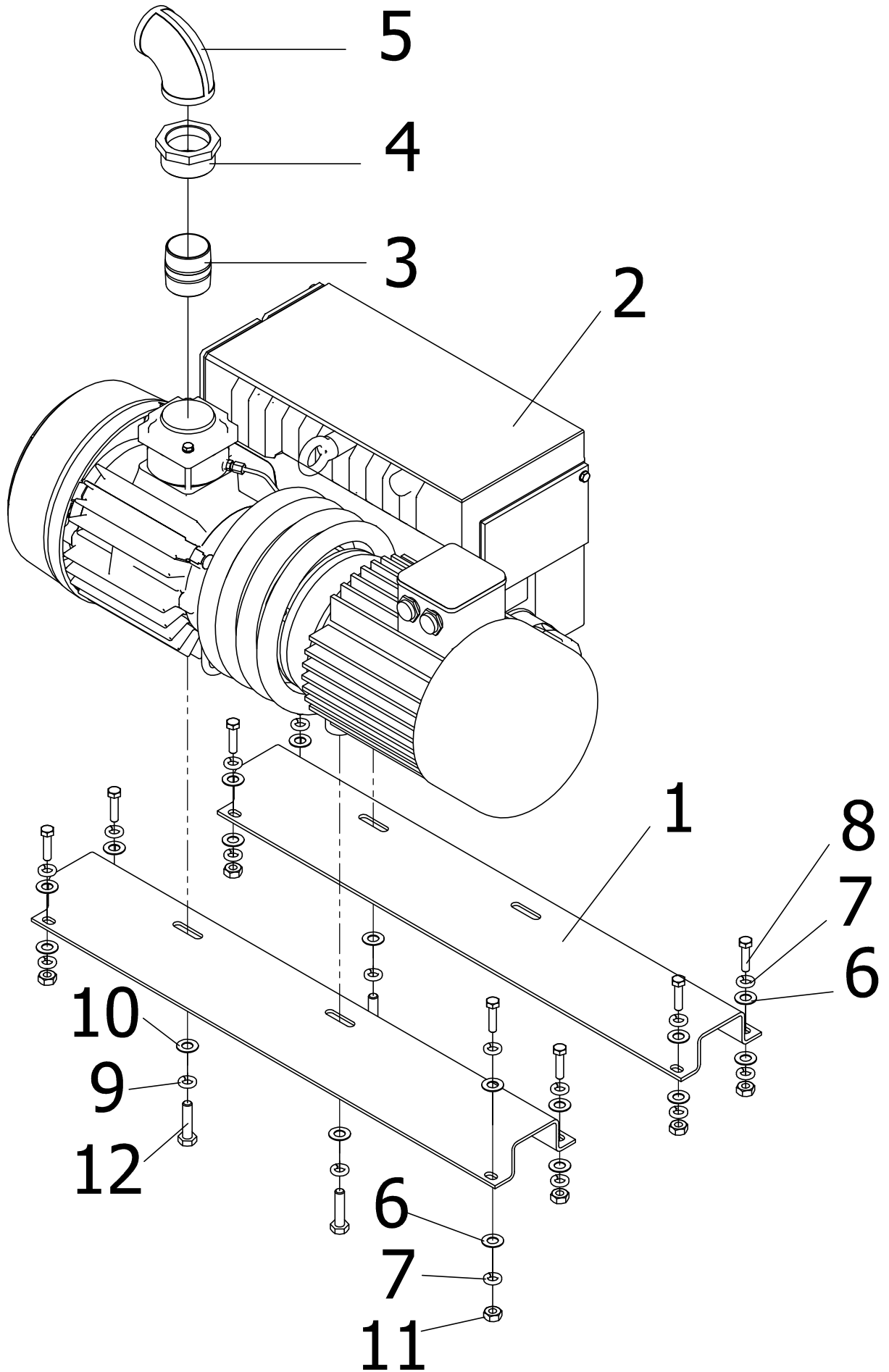
Promax

Rotary Cutter Sys.



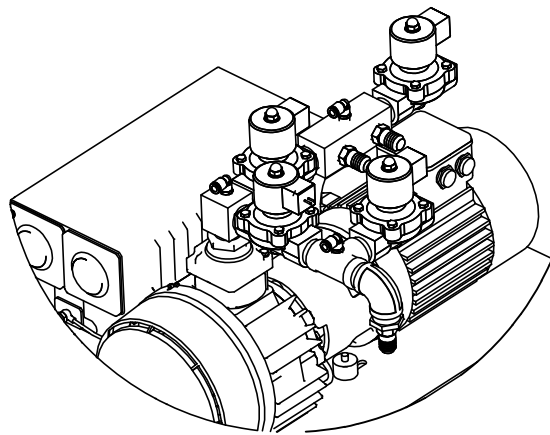
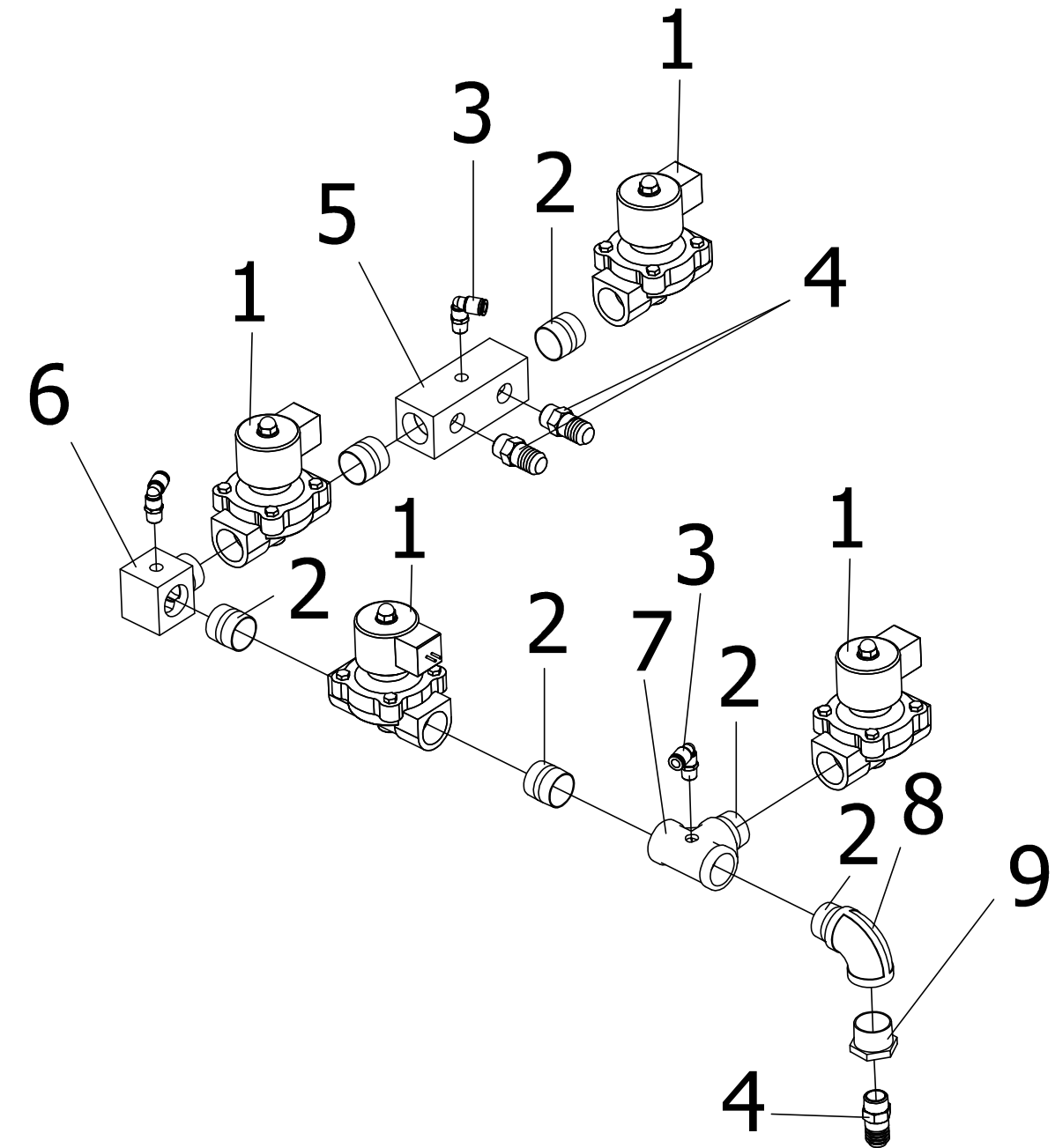
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Film Trim Winder Sys.



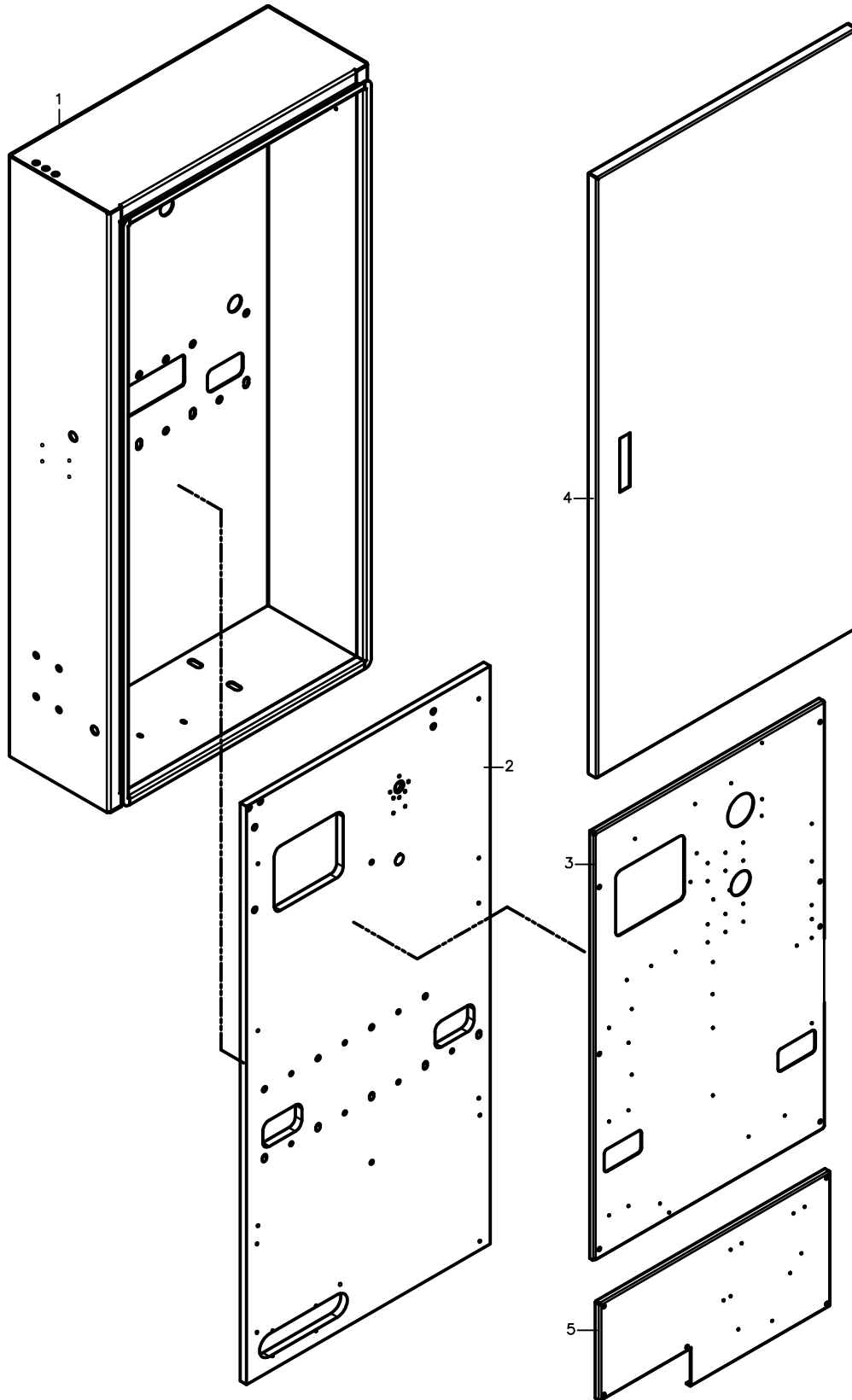
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Vacuum Pump.



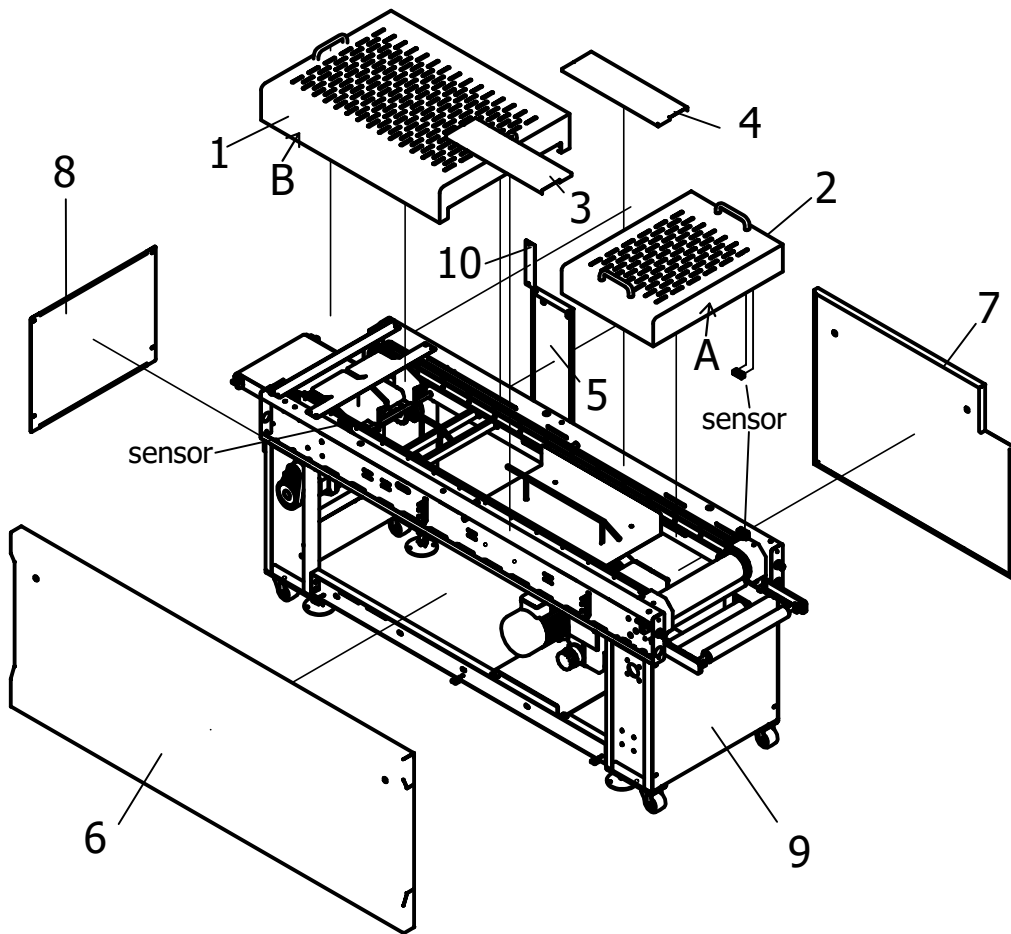
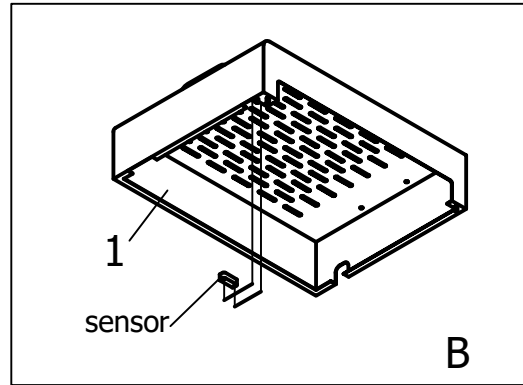
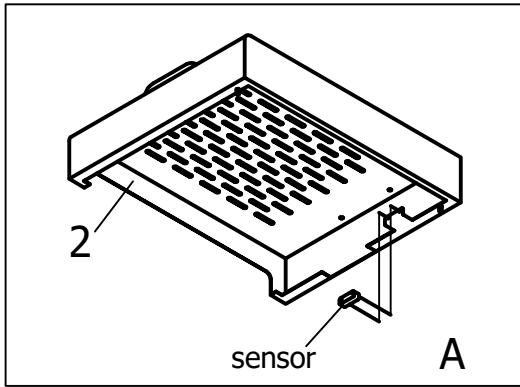
Promax

Solenoid Vacuum Valve Sys.



Promax

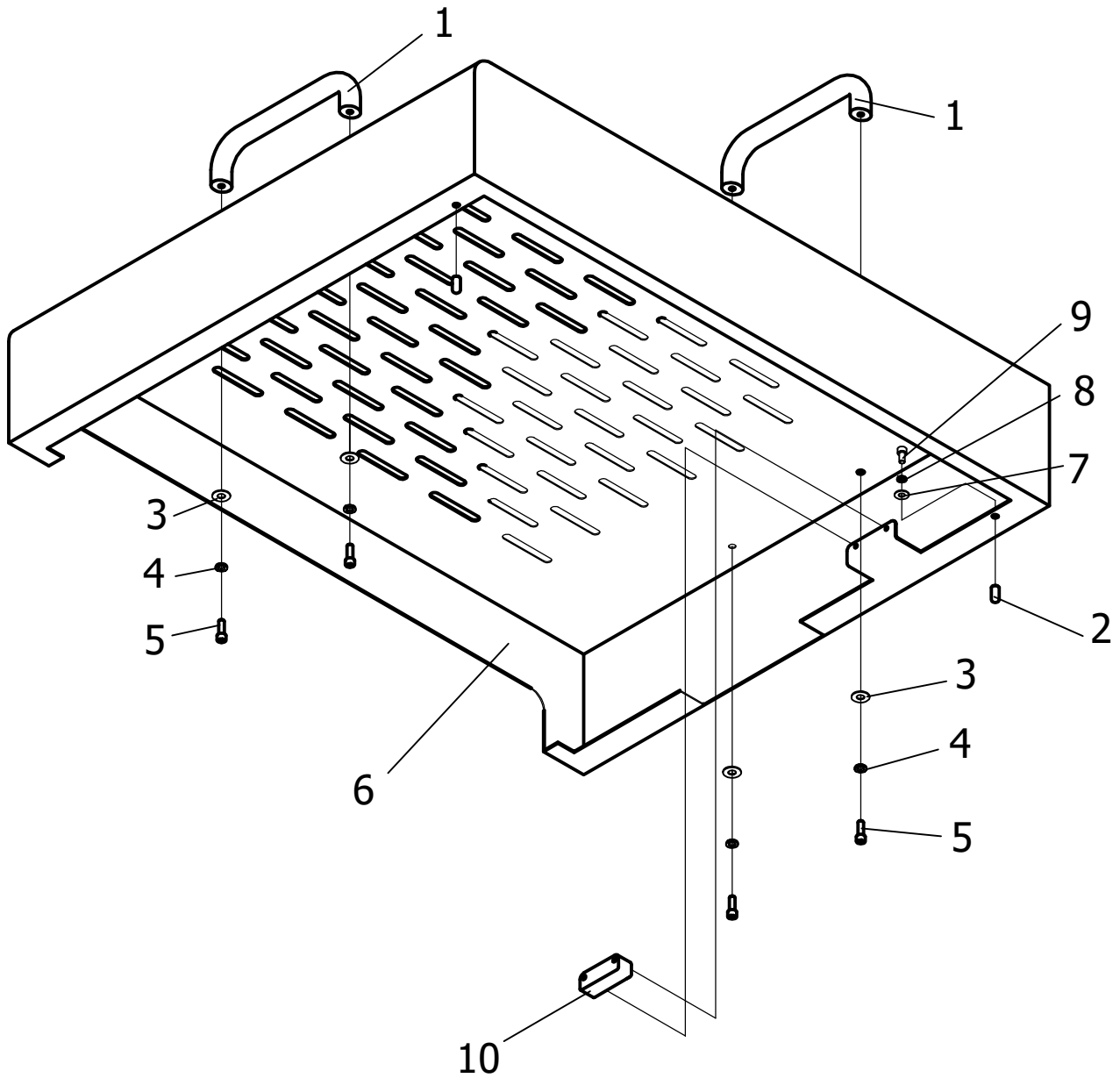
Main Electric Box



Promax

Safety covers

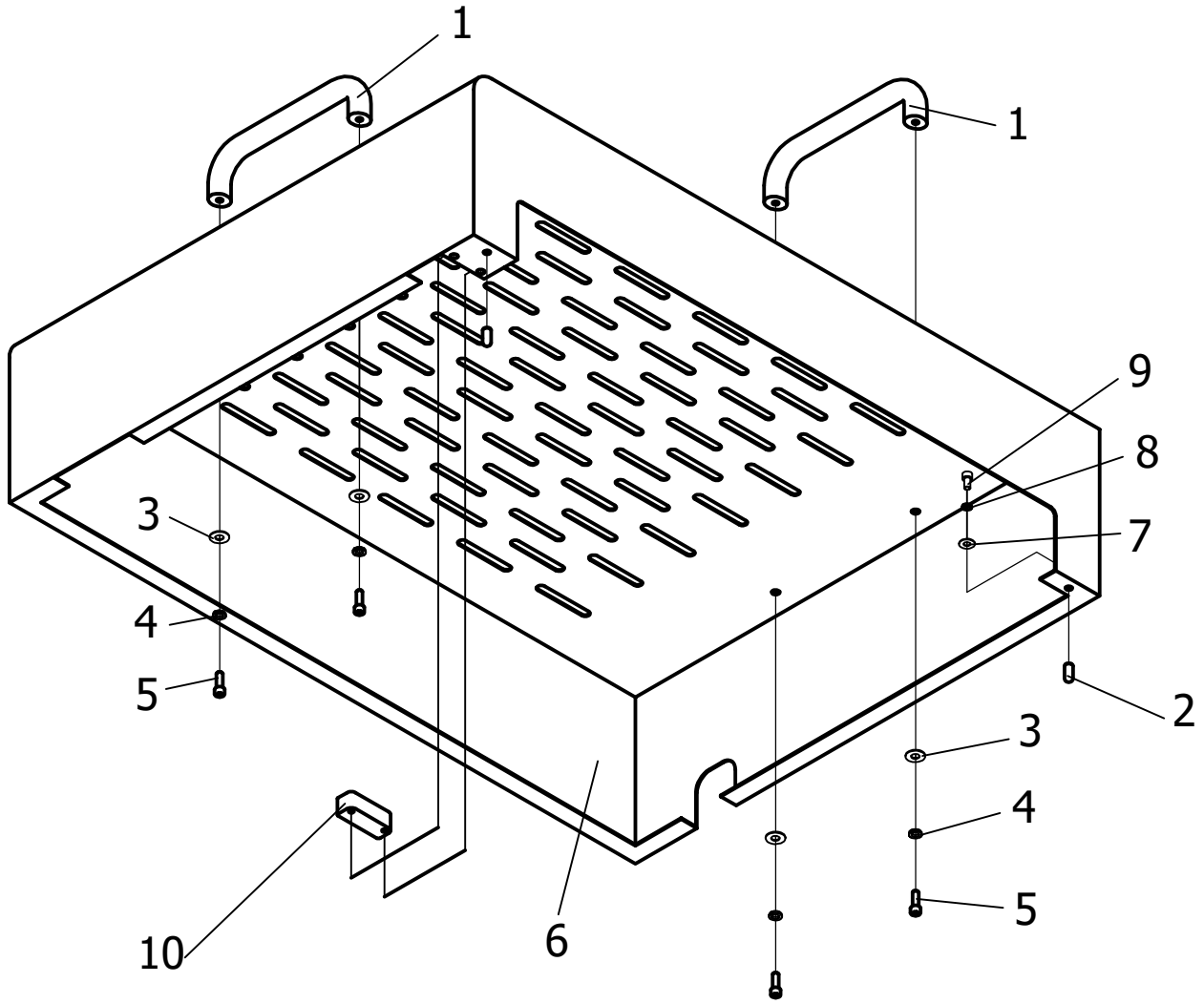
A



Promax

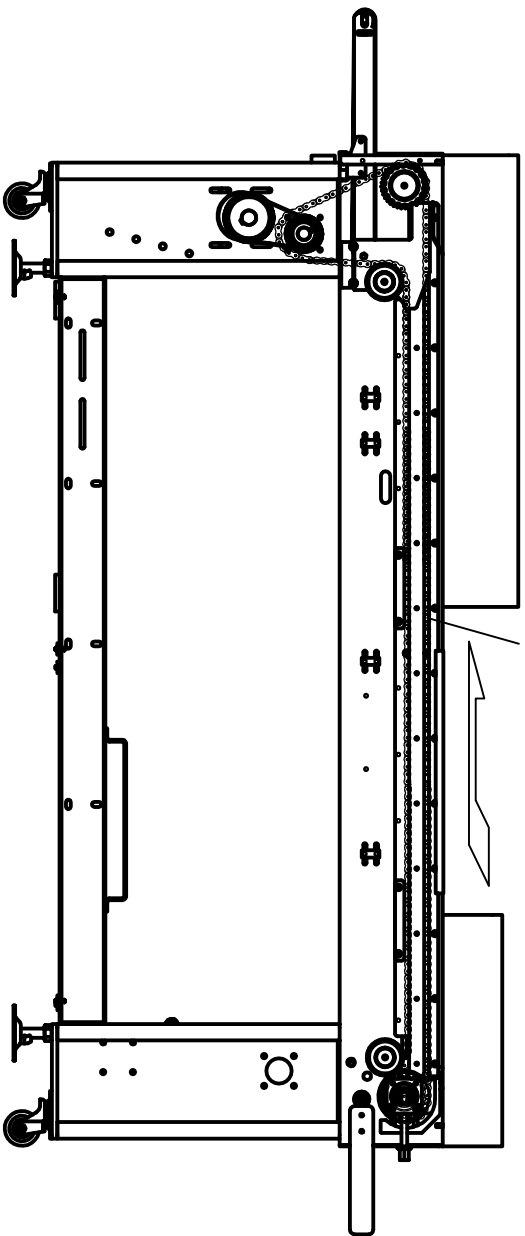
Forming Safety Cover.

B



Promax

Sealing, Cross & Rotary
Cutter Safety Cover.



Transport Chain (Part NO. RS421H0000)

 Promax

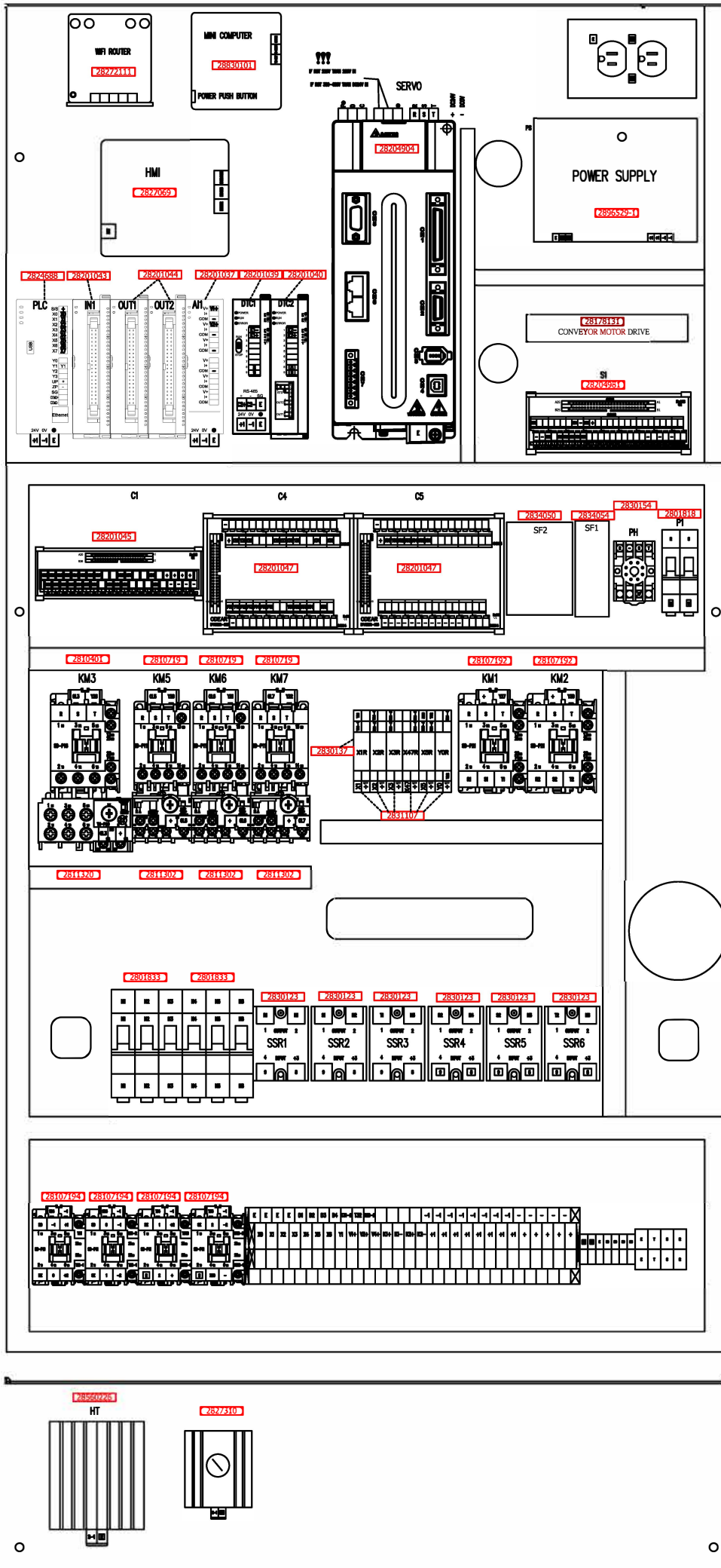
Transport Chain

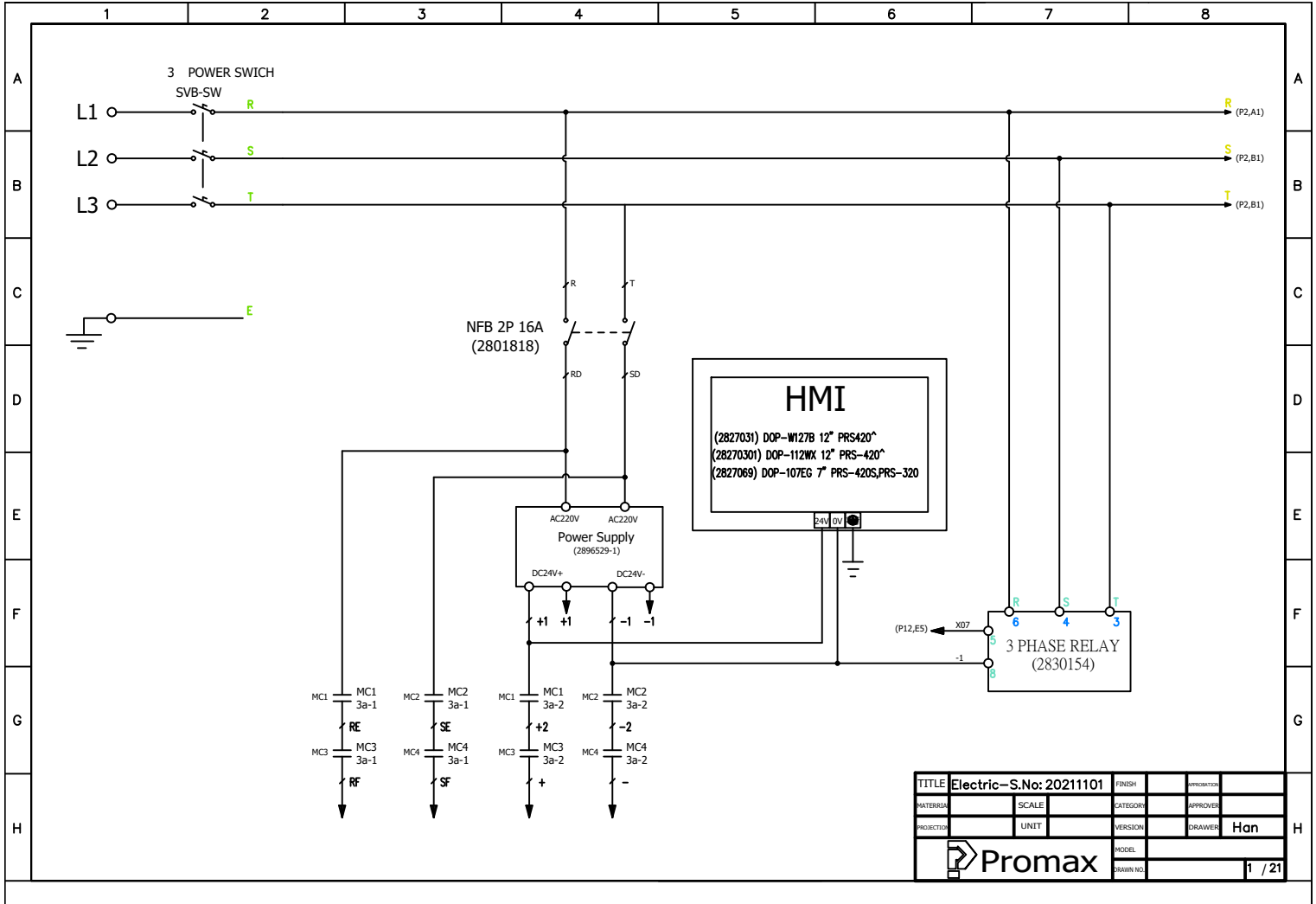
24. PRS Electrical Schematic & Component List

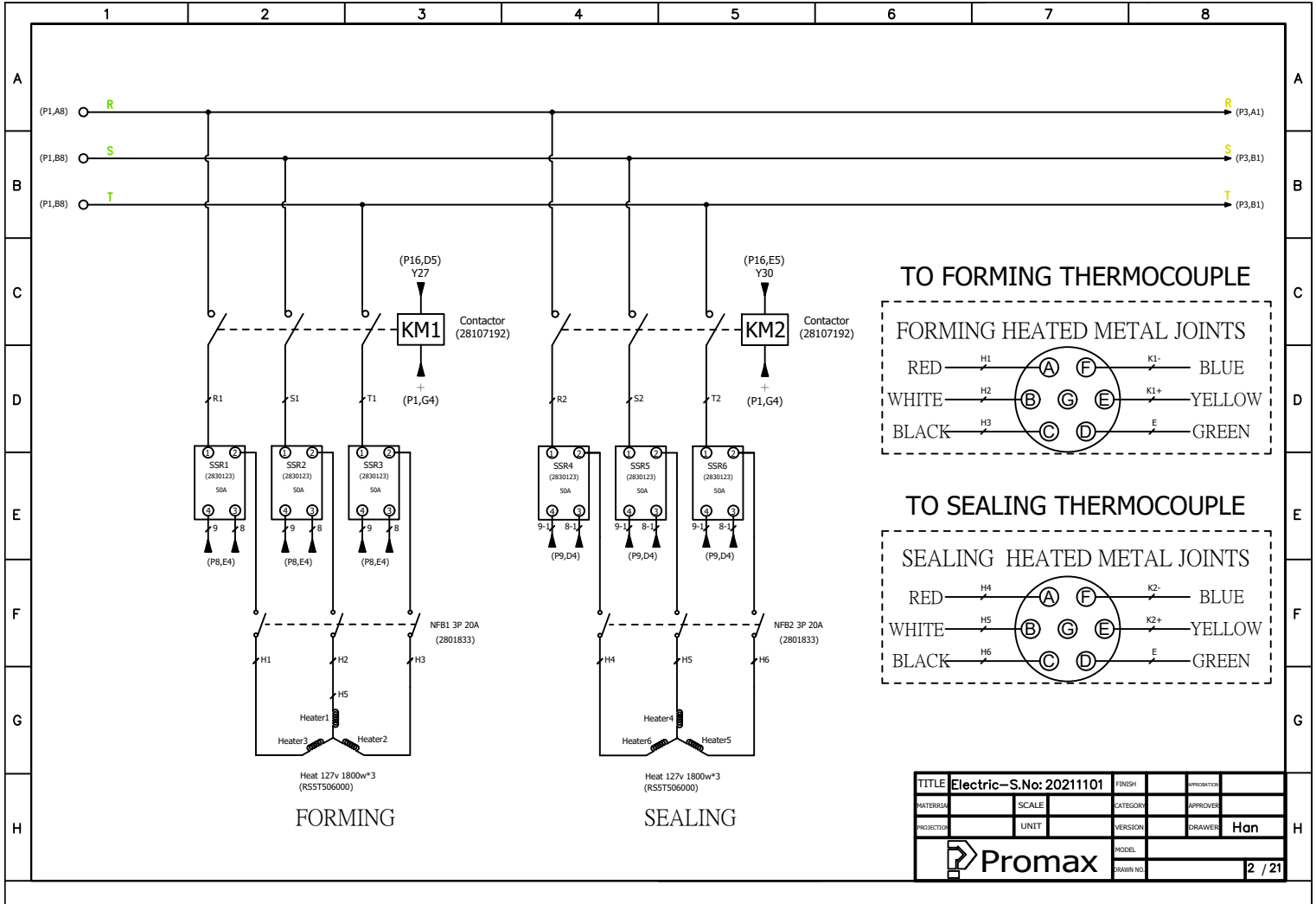
PRS Electric Box Components

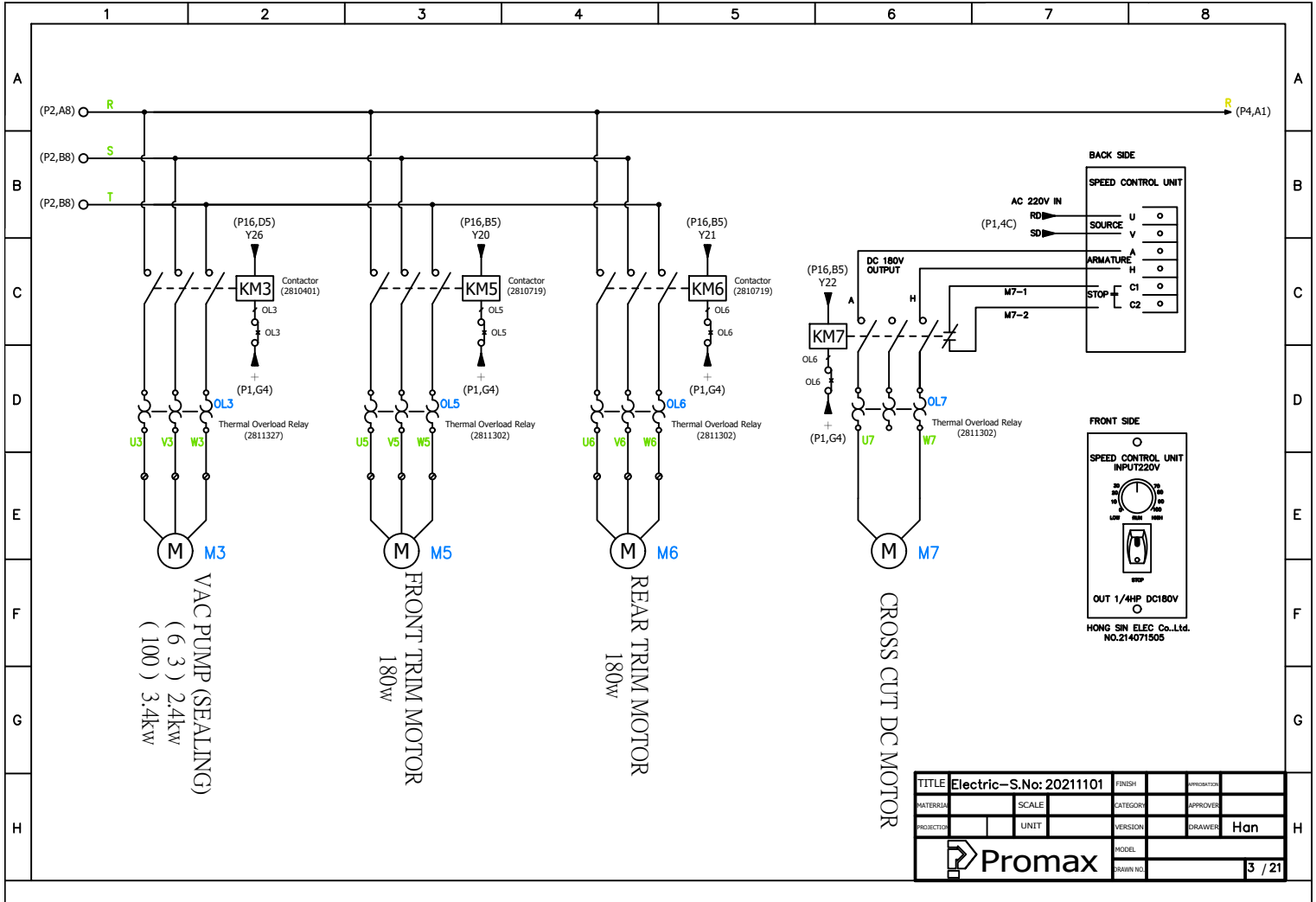
Part No.	Description
28272111	Wi-Fi Router
28830101	Mini PC
28204904	Servo Drive
2827069	HMI (7")
2896529-1	Power Supply
2824688	PLC
28201043	Module
28201044	Module
28201037	Module
28201039	Module
28201040	Module
28178131	Conveyor Motor Driver
28204981	I / O Module
28201045	I / O Module
28201047	Safety Relay Module
2834050	SF2 - Safety Relay Controller
2834054	SF1 - Safety Sensor Controller
2830154	Phase Sensor
2801818	Miniature Safety Breaker
2810401	Contactactor
2811320	Thermal Overload Relay
2811302	Thermal Overload Relay
2810719	Contactactor
2830137	Relay
2831107	Relay Base
28107192	Contactactor
2801833	Mini Circuit Breaker
2830123	Solid State Relay
28107194	Contactactor
28560226	Electric Box Heater
2827310	Electric Box Heater Controller

Electric Box Panel Layout

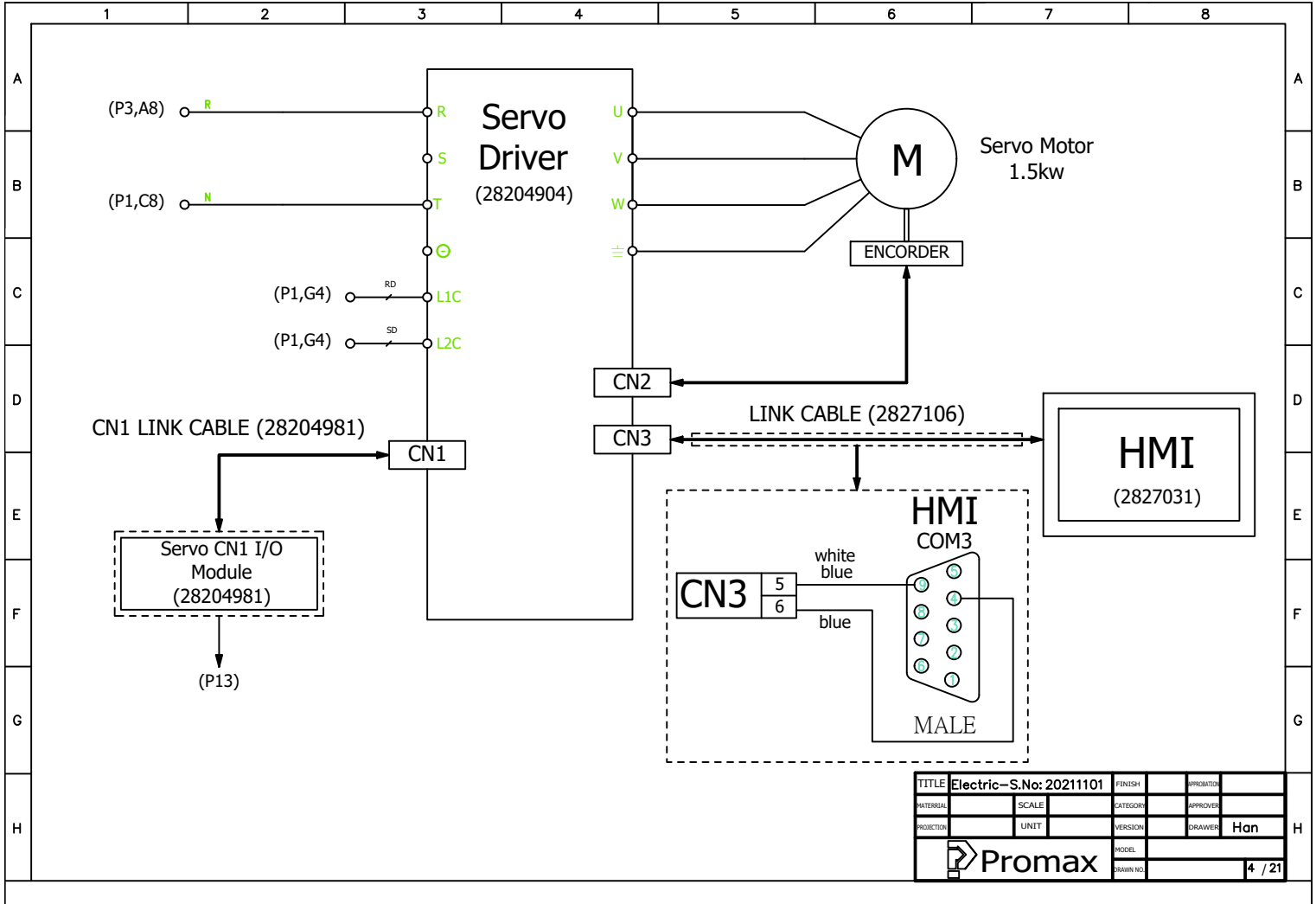




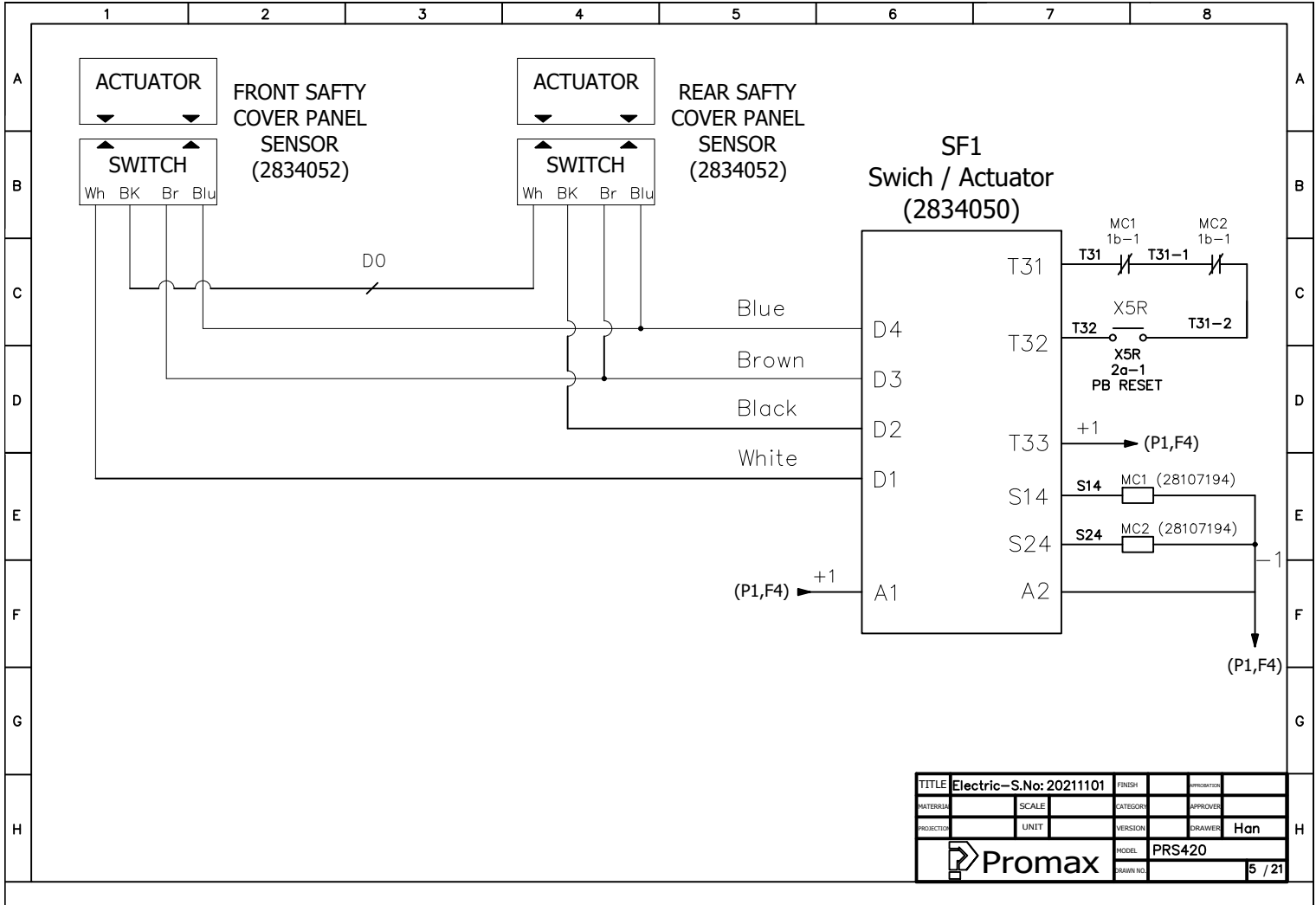




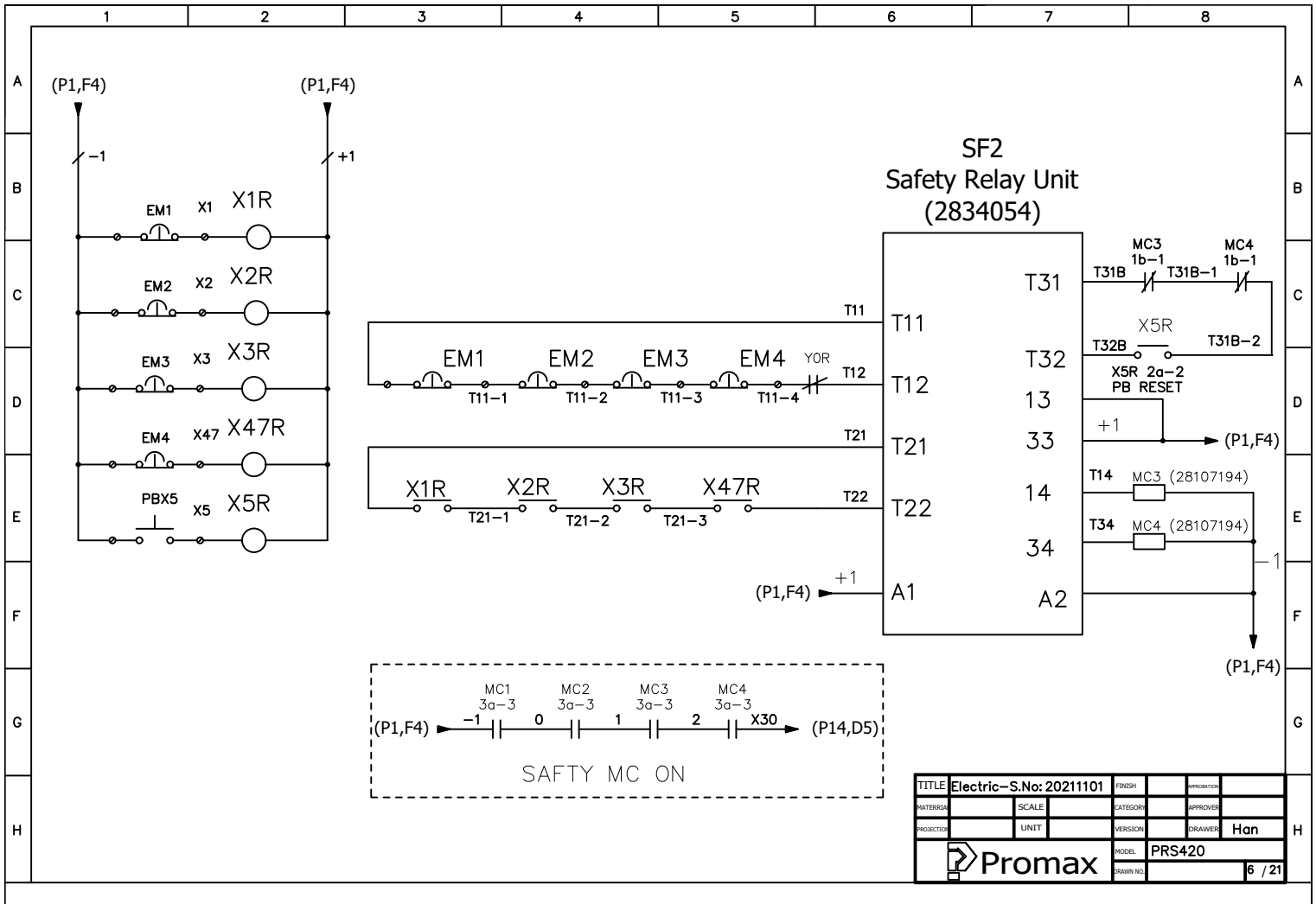
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MATERIAL		SCALE		CATEGORY	APPROVER
PROJECTOR		UNIT		VERSION	DRAWER Han
		MODEL		3	21

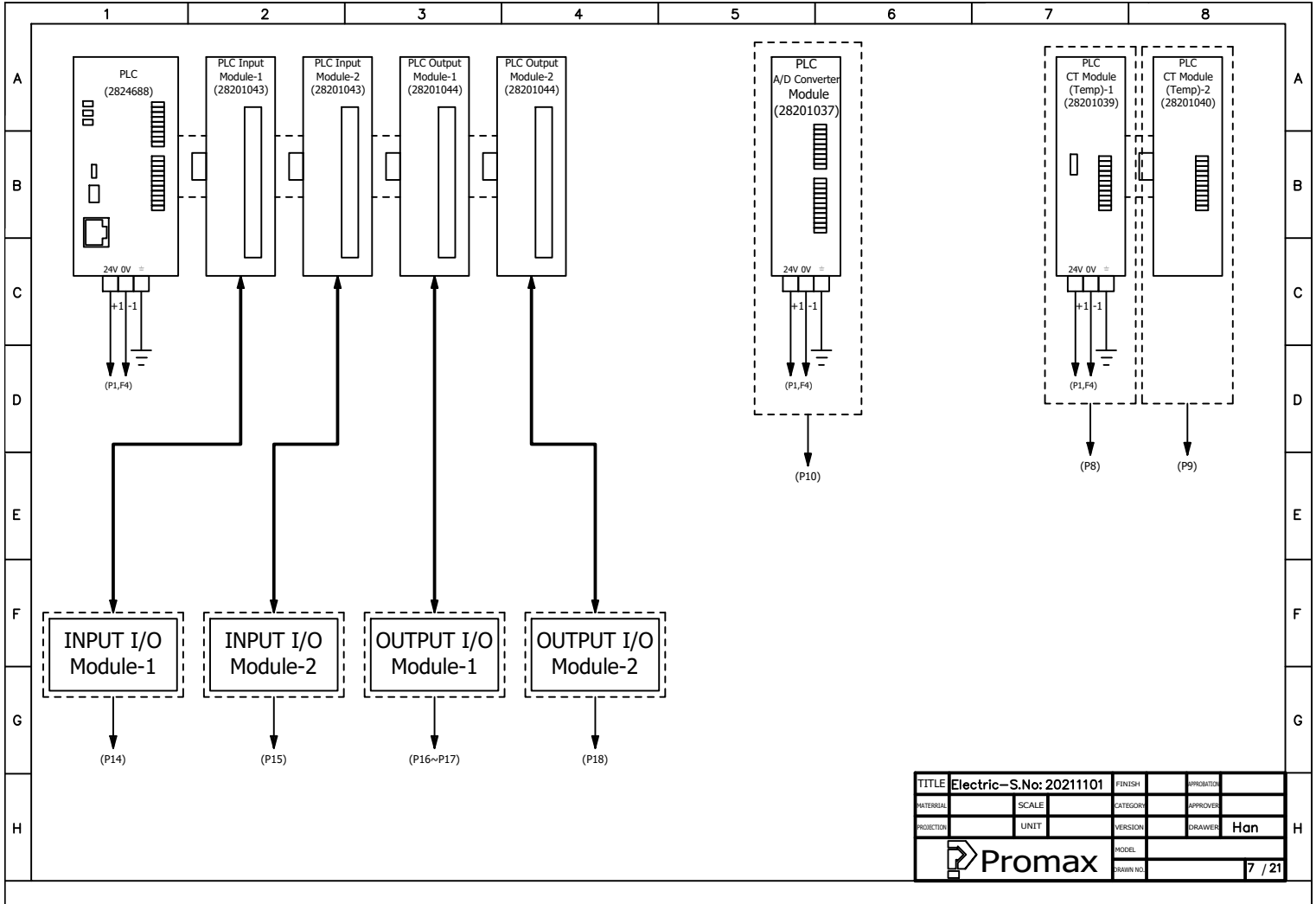


TITLE	Electric-S.No: 20211101	FINISH	PROBATION
MATERIAL	SCALE	CATEGORY	APPROVER
PROJECTION	UNIT	VERSION	DRAWER Han
			MODEL
			SHAWN NO 4 / 21

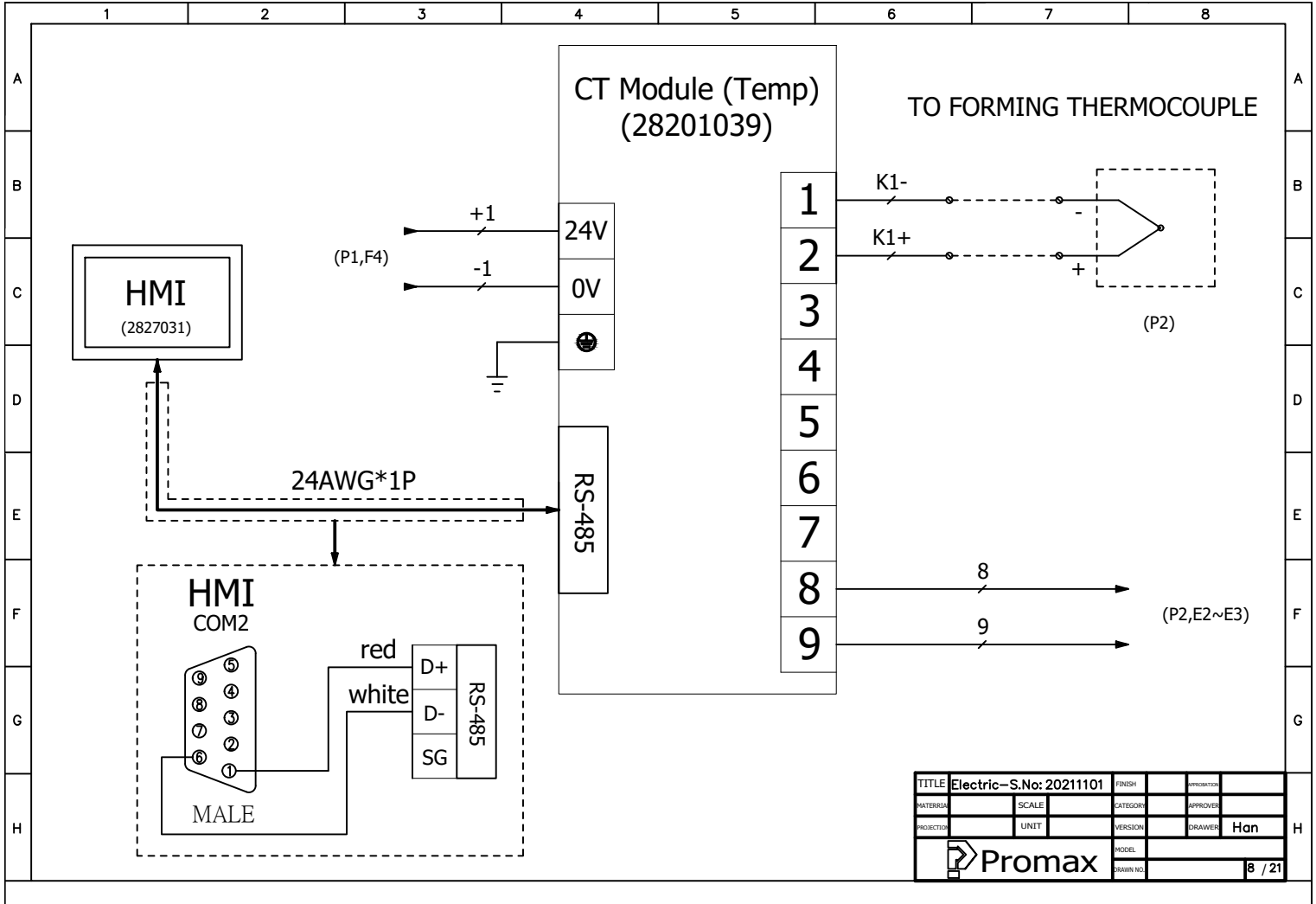


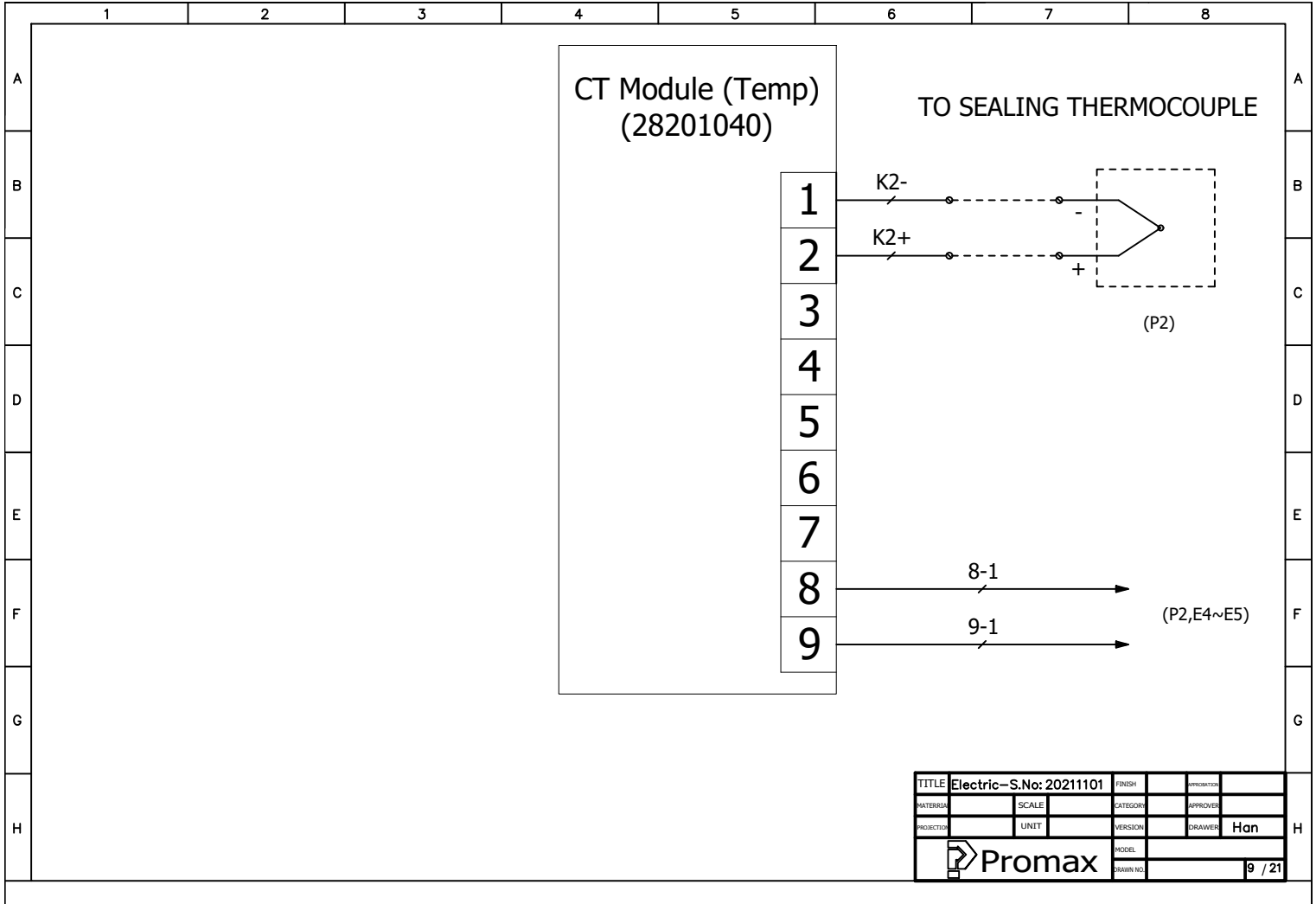
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MATERIAL		SCALE		APPROVER	
PROJECTOR		UNIT		DRAWER	Han
		MODEL	PRS420		
		SHEET NO.		5 / 21	

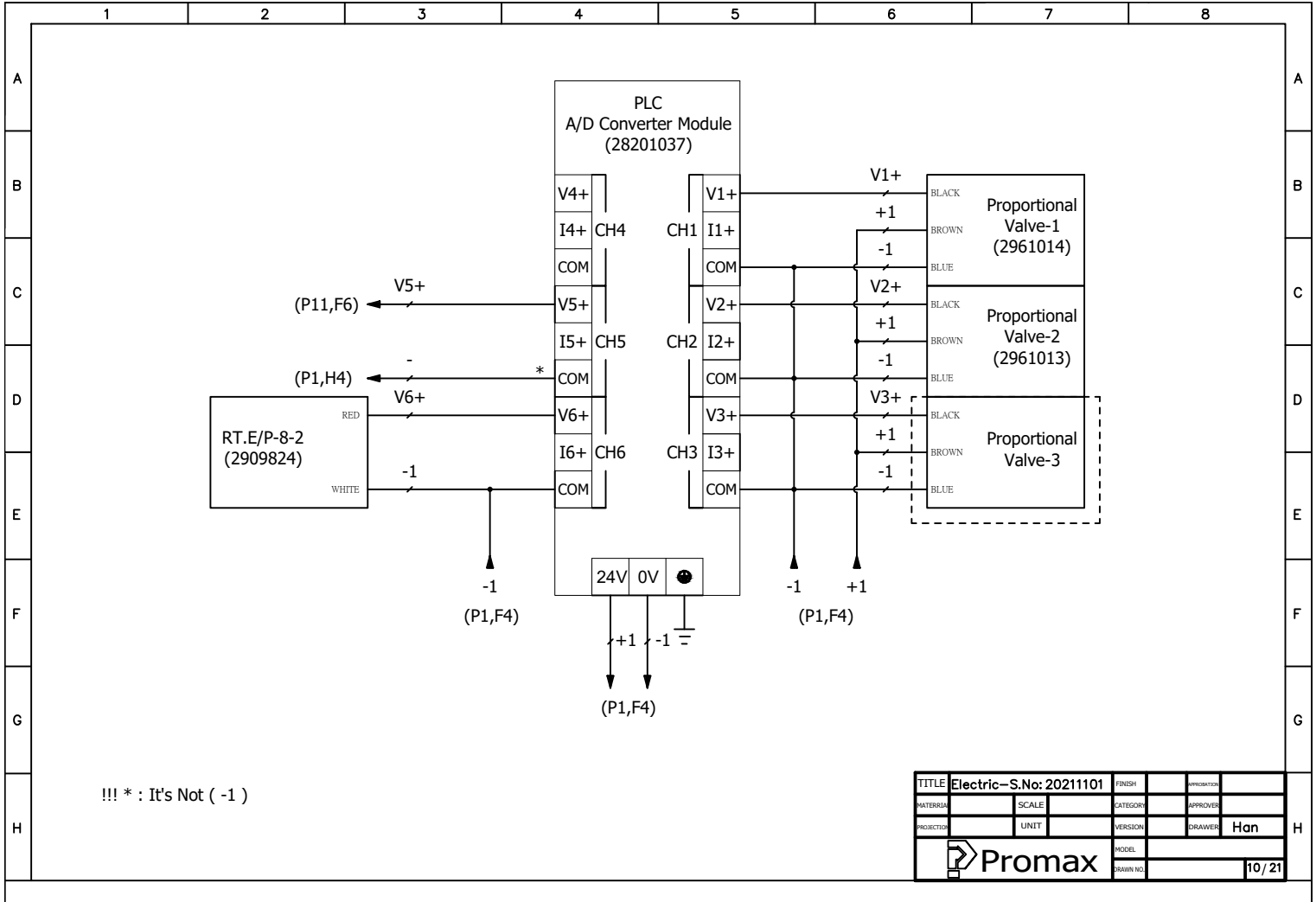


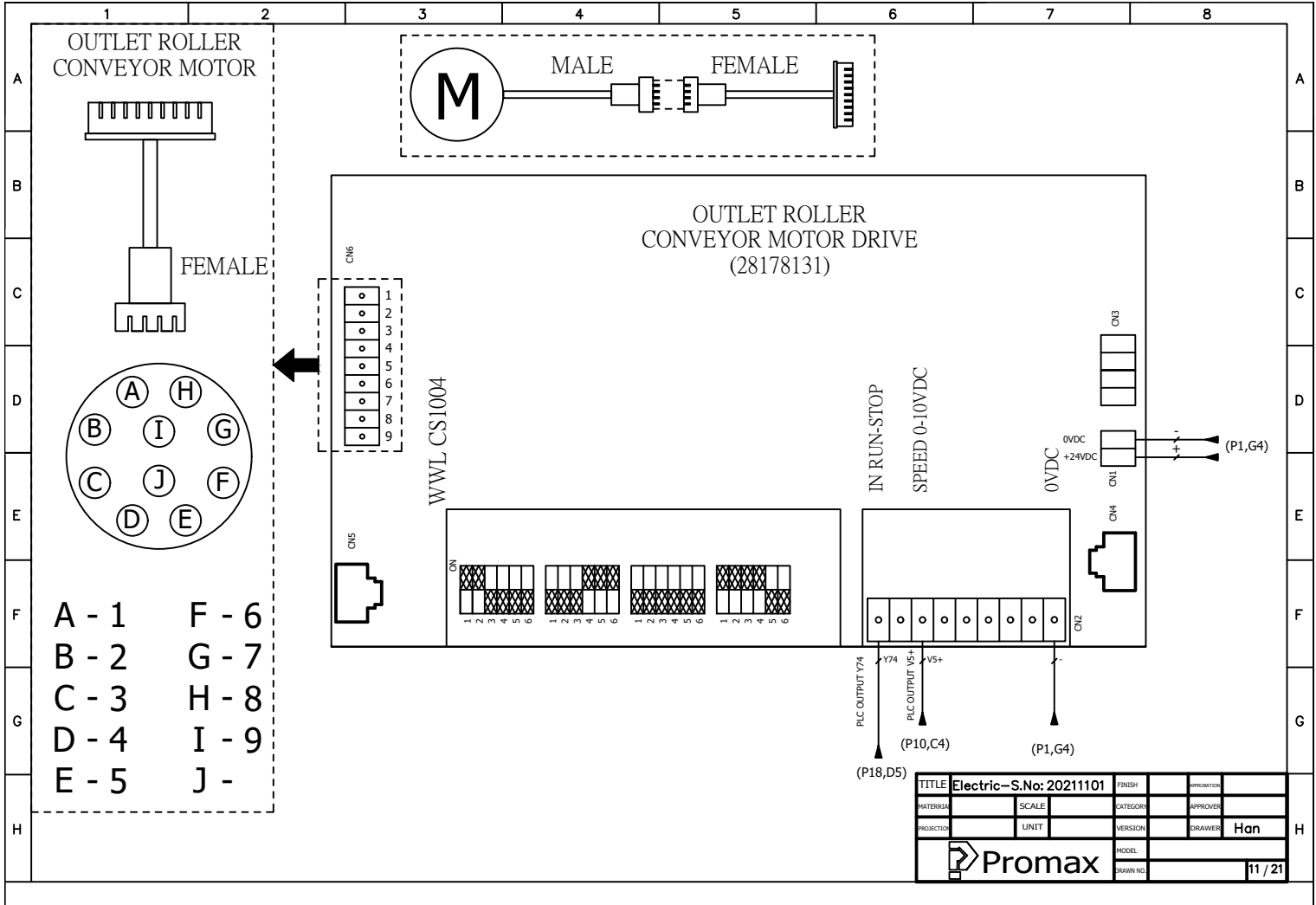


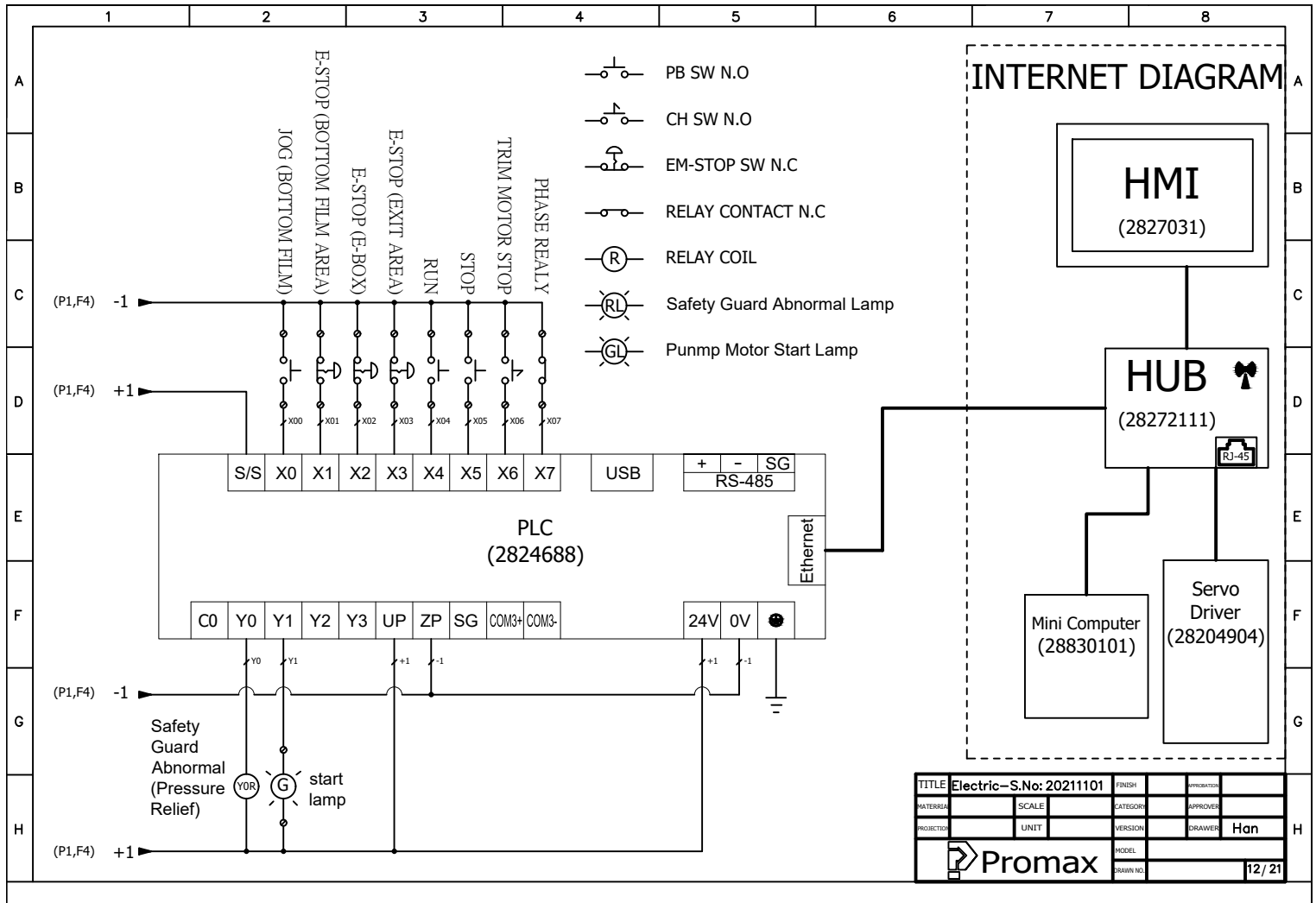
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MATERIAL	SCALE	CATEGORY	APPROVER
PROJECTION	UNIT	VERSION	DRAWER Han
			MODEL
SHEET NO.			7 / 21

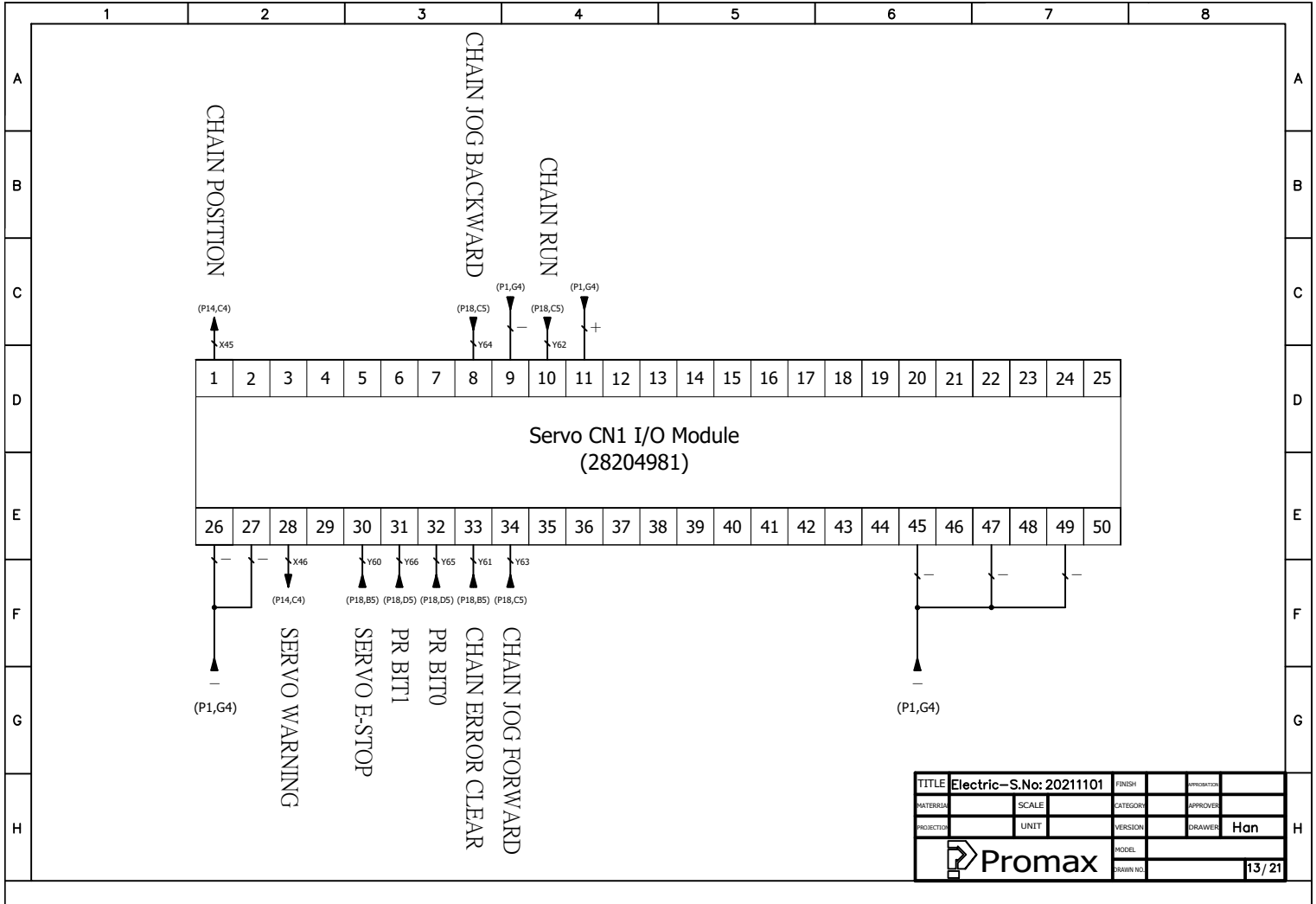




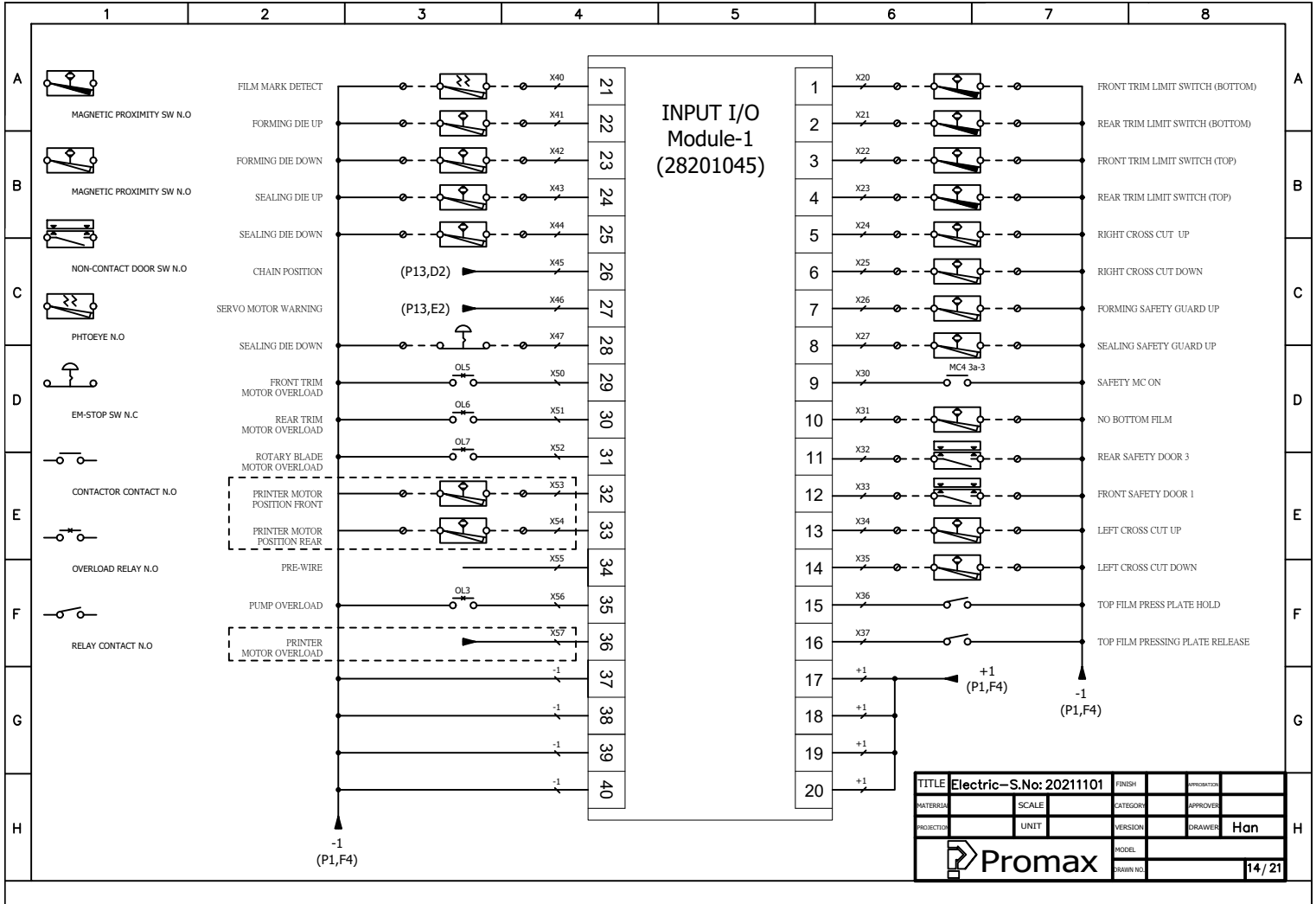




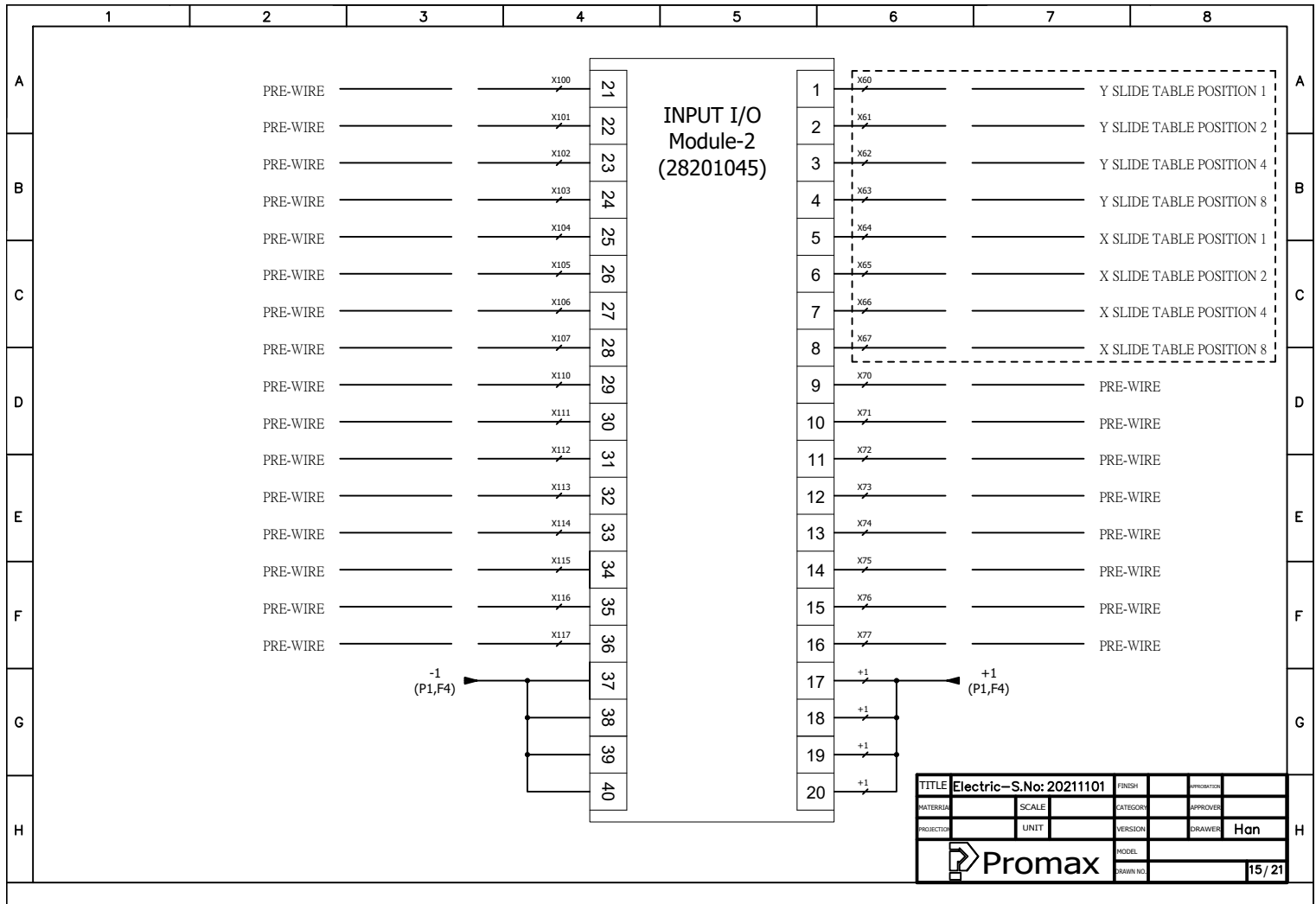


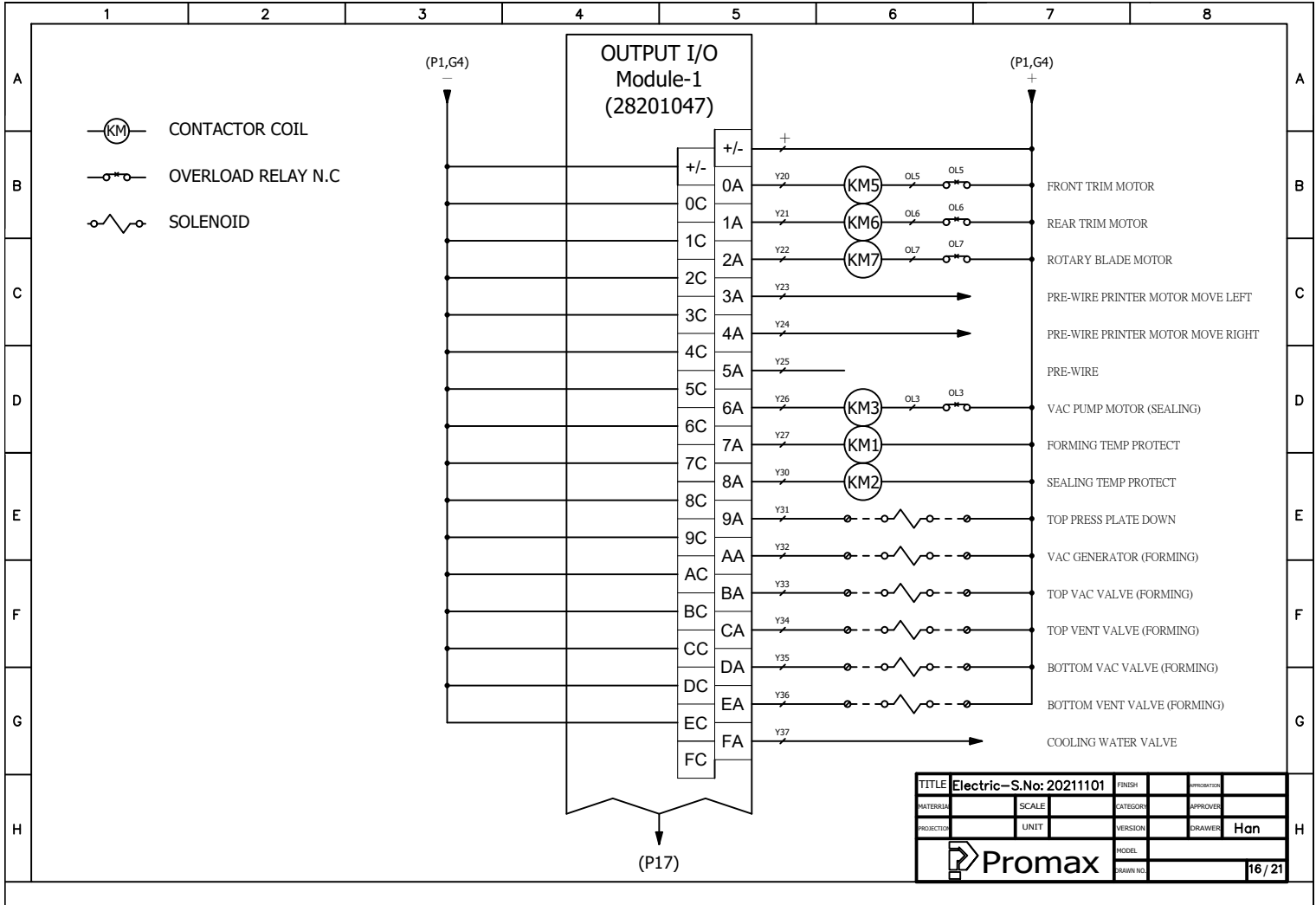


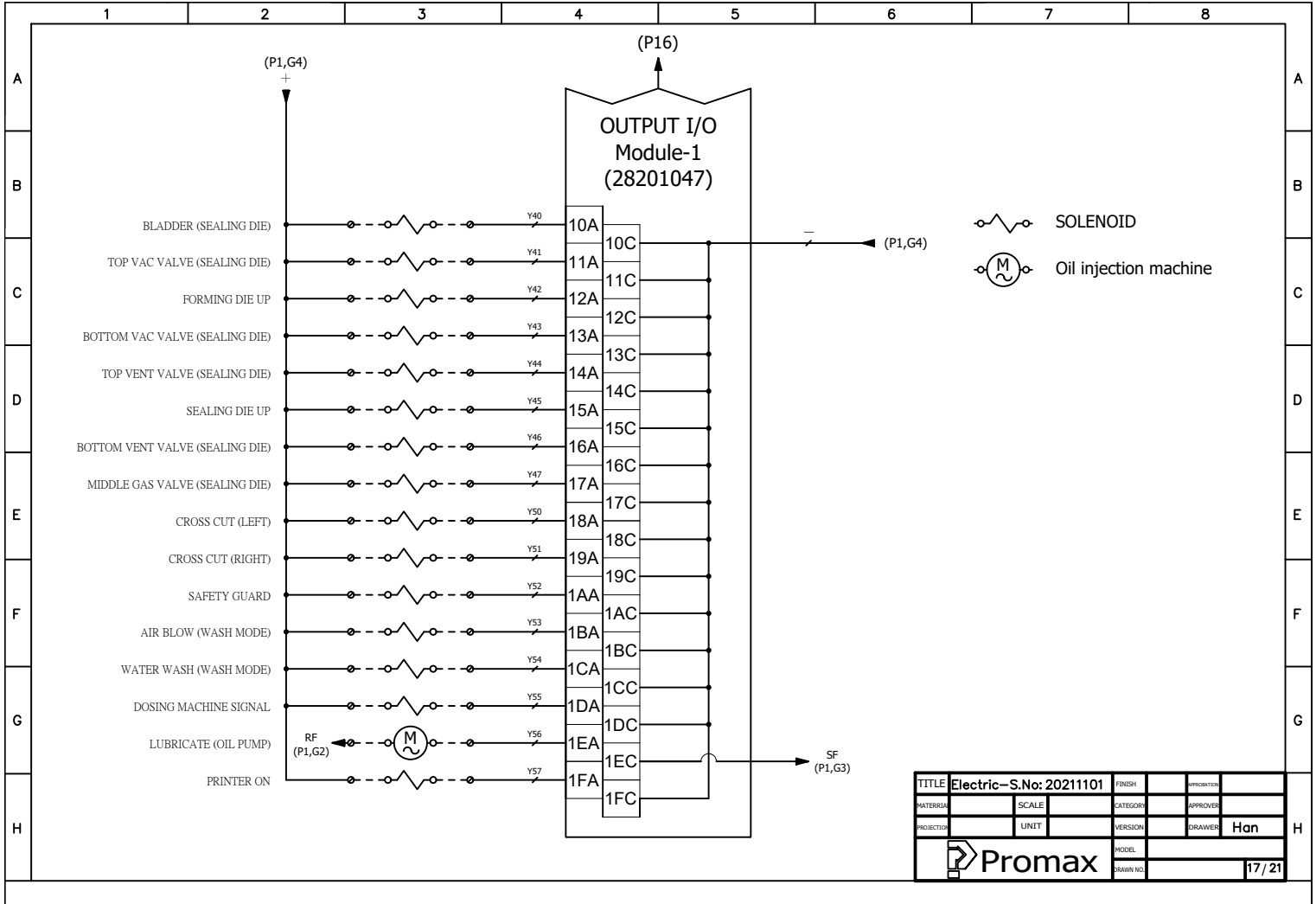
TITLE	Electric-S.No: 20211101	FINISH		PROJECTION	
MATERIAL		SCALE		APPROVER	
PROJECTOR		UNIT		DRAWER	Han
		MODEL			
		SHEET NO.	13 / 21		



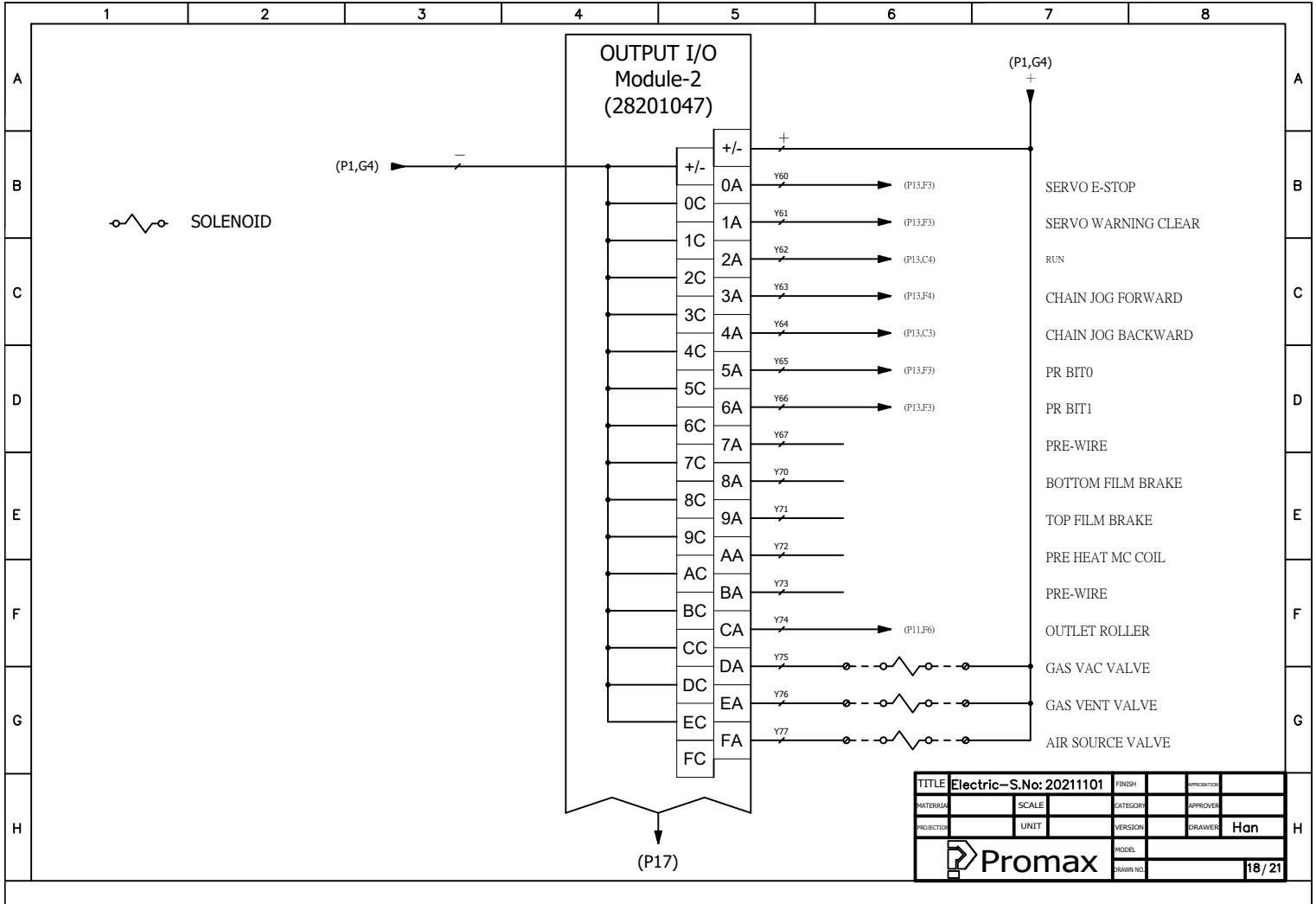
TITLE		Electric—S.No: 20211101		FINISH		PRODUCTION	
MATERIAL	SCALE	CATEGORY	APPROVER				
PROJECTOR	UNIT	VERSION	DRAWER	Han			
			MODEL				
DRAWING NO.			14 / 21				



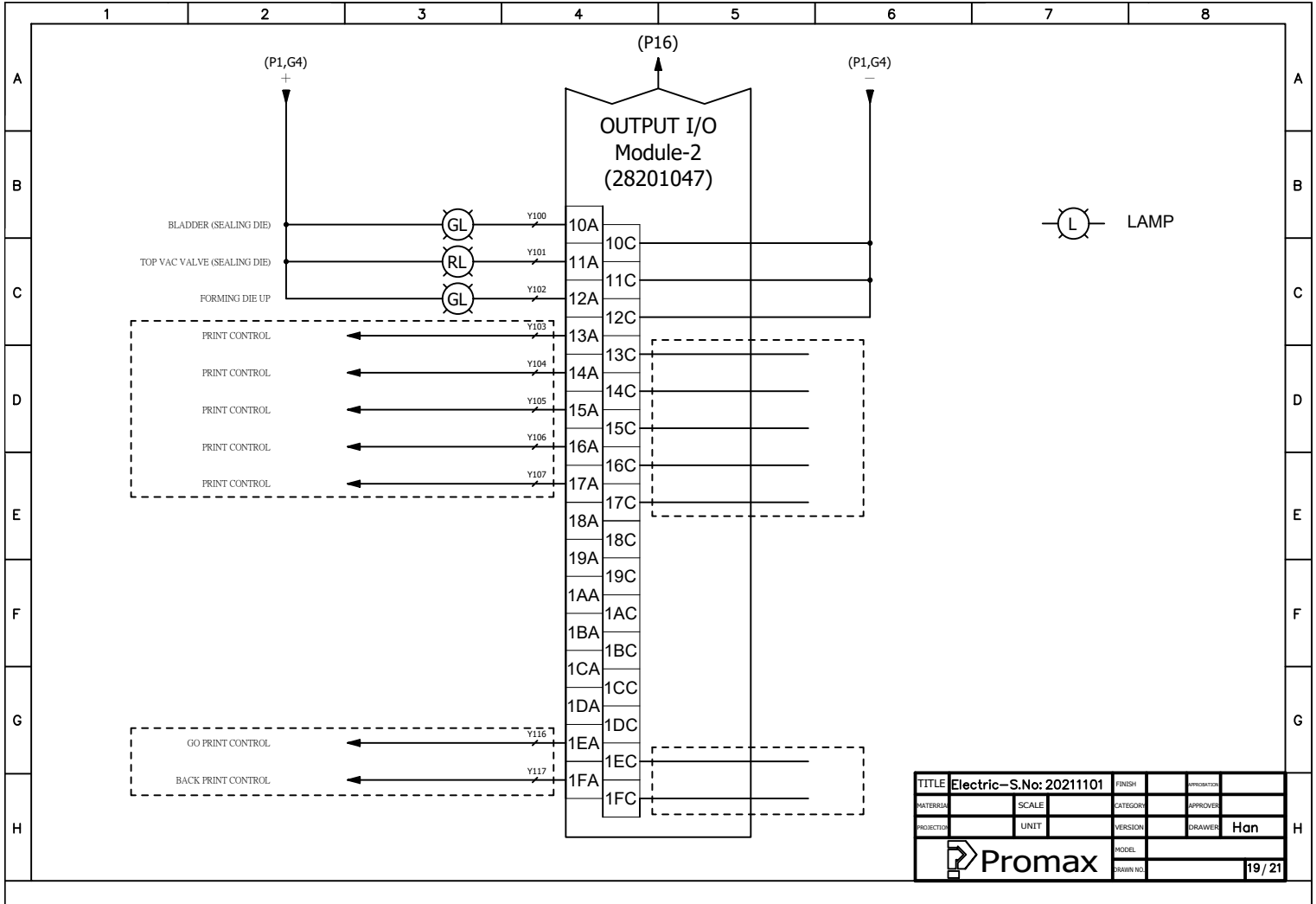




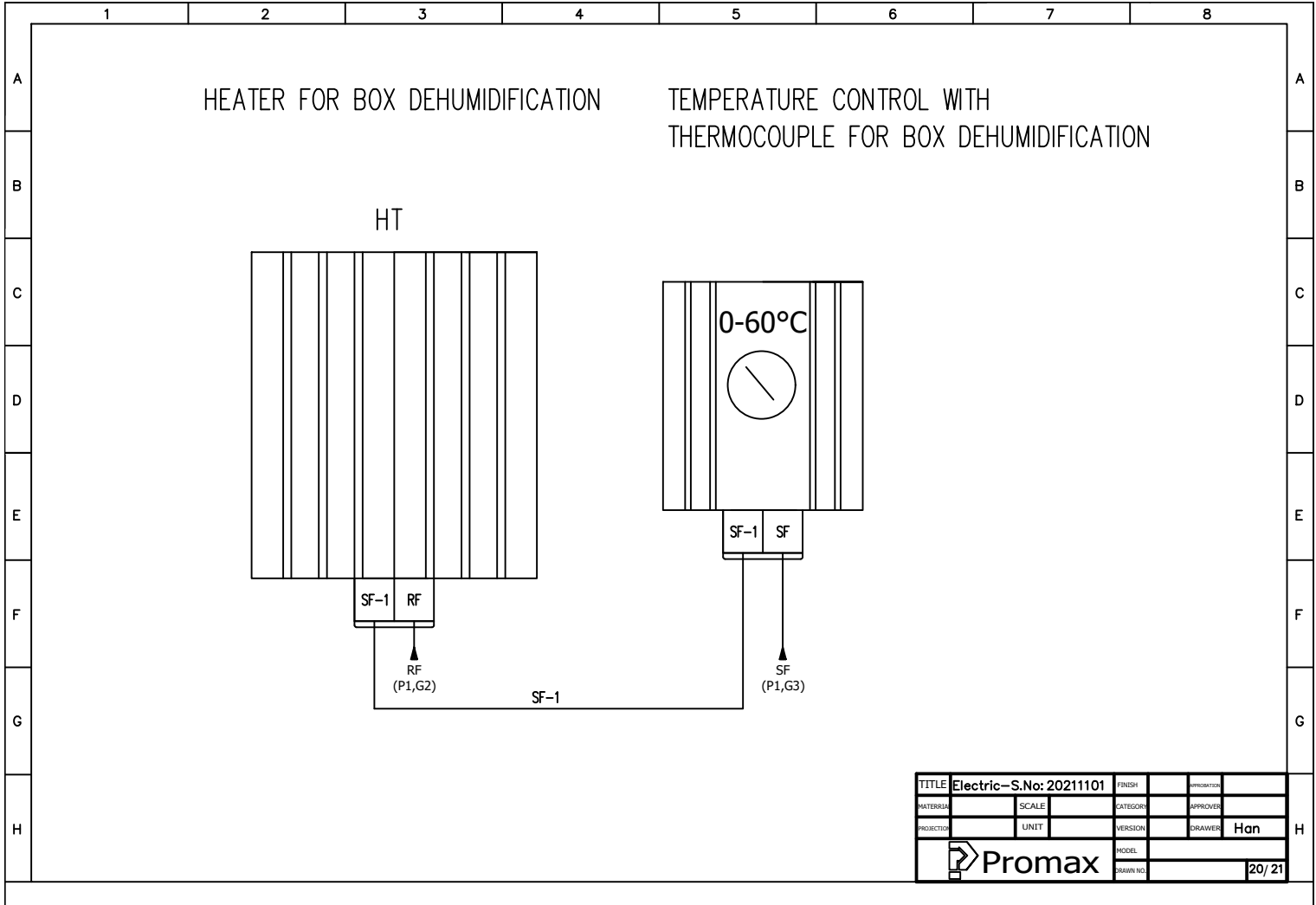
TITLE	Electric-S.No: 20211101	FINISH		PROJECTION	
MATERIAL		SCALE		APPROVER	
PROJECTOR		UNIT		DRAWER	Han
		MODEL		ISSUE NO.	17 / 21

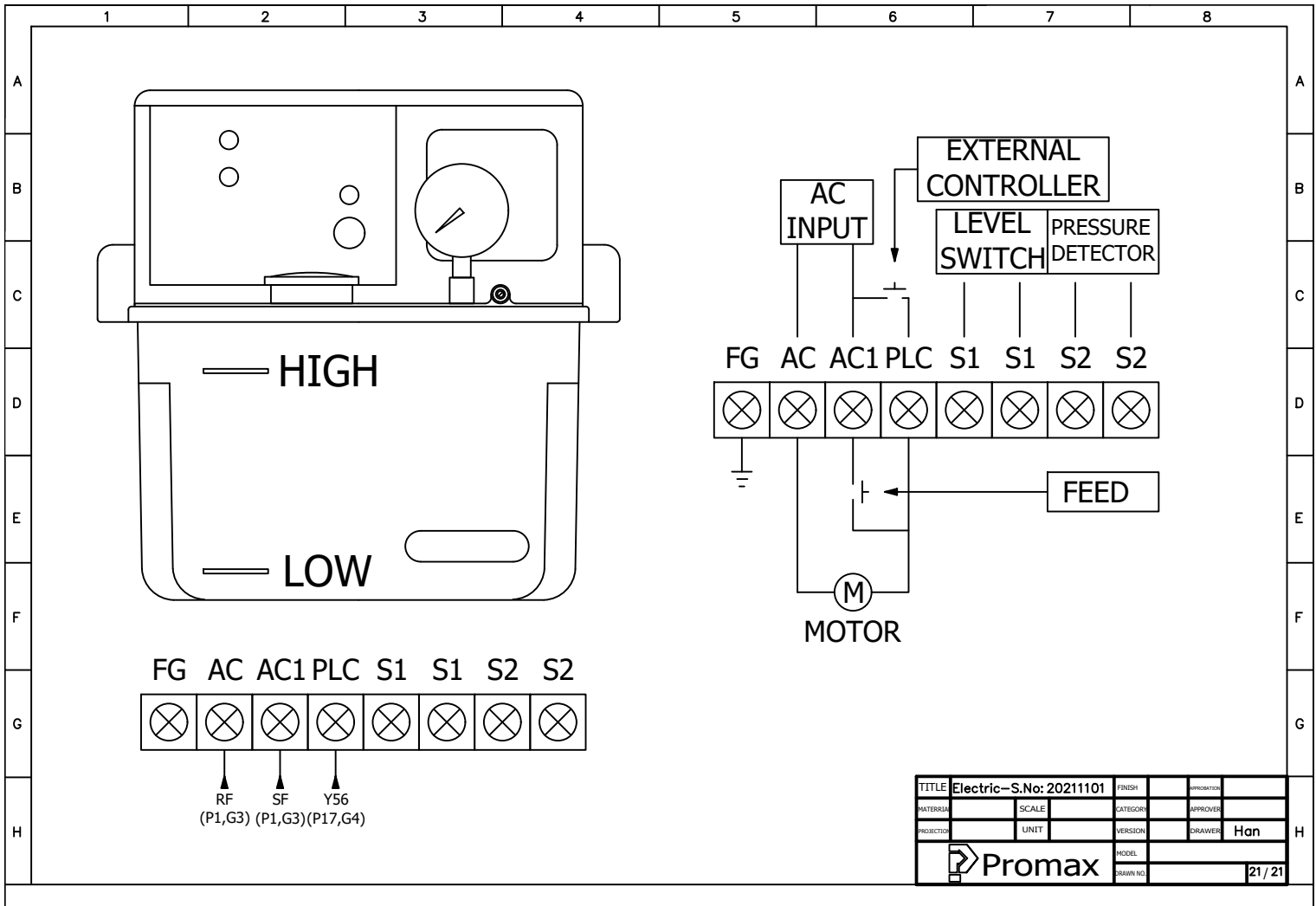


TITLE	Electric-S.No: 20211101	FINISH		PROJECTION	
MATERIAL		SCALE		APPROVER	
PROJECTOR		UNIT		DRAWER	Han
		MODEL		ISSUE NO.	18 / 21



TITLE	Electric-S.No: 20211101	FINISH		PROJECTION	
MATERIAL		SCALE		APPROVER	
PROJECTOR		UNIT		DRAWER	Han
		MODEL		ISSUE NO.	19 / 21





TITLE	Electric-S.No: 20211101	FINISH		PRODUCTION	
MATERIAL		SCALE		APPROVER	
PROJECTOR		UNIT		DRAWER	Han
		MODEL			
		SHEET NO.			21 / 21

