



USER AND MAINTENANCE MANUAL

VM DIGITAL



**LE TRI
+ FACILE**



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1 SAFETY INSTRUCTIONS AND WARNINGS

1.1 Pictograms Legend

PICTOGRAM	DESCRIPTION
	Identify HAZARDS or points where it is mandatory to pay ATTENTION to the correct functioning of the machine
	WARNING for correct operation when using the machine
	Risk of electrocution
	Risk of scald/ burn
	Contact the technical support in the event of functional anomalies of the machine
	Reference to the WEEE and RoHS Directive



- This product complies with current safety regulations. Improper use may in any case cause personal injury and/or damage to property.
- This manual is an integral part of the product and provides all the necessary information for the correct installation, use and maintenance of the appliance, in order to avoid hazards that may cause damage to persons and/or property. The manufacturer is not liable for damage resulting from failure to comply with these instructions.
- It is mandatory for the user and the installer to carefully read this manual and always refer to it; it must also be stored in a known and easily accessible place and also delivered to possible future users.

1.2 Intended use

- The appliance must not be used in outdoor environments.
- The appliance is only intended for the use for which it was designed, i.e. for the vacuum packaging of food.
- All other uses shall be considered improper and potentially hazardous.
- Do not vacuum-pack live food (molluscs and animals in general or any living being, etc.) under no circumstances.
- This appliance is not suitable for use by persons with reduced physical, sensory and mental capacities, unless they are supervised and trained regarding use of the appliance by a person responsible for their safety. Such persons may only use the appliance without supervision if it has been explained to them how to proceed and if they are able to do so in complete safety. It is important that they know how to recognize and understand the hazards that may result from improper use of the appliance.

1.3 Children

- Keep children under the age of eight away from the appliance, or supervise them constantly.
- Children over the age of eight can use the appliance without supervision, only and exclusively if they have been explained how to do it and if they are able to do it safely.
It is important that they know how to recognize and understand the hazards that may result from improper use of the appliance.

- Supervise children who may be in the immediate vicinity of the packaging machine. Do not allow them to play with it.
- Keep children away from the appliance until the sealing bar and sealing line have cooled to prevent the risk of scalding.
- The packaging material (plastic bags, polystyrene parts, etc.) must be kept out of reach of children as they are a potential source of danger.
- Scrap the appliance in accordance with local standards regarding waste disposal and deliver it to appropriate collection points. Do not leave the appliance unattended, not even for just a few days, as it is a source of danger to children.

1.4 Technical Safety

- Due to improperly executed installation and extraordinary maintenance or repair, serious hazards may arise for the user. This type of work must only be carried out by qualified personnel authorised by the manufacturer.
- Pay particular attention to the general condition of the cover (presence of cracks, chips, scratches and deep marks). Any damage could cause an implosion, with serious danger to the user. Never use the appliance if the cover is damaged.
- An oil vacuum pump is installed in the appliance. Never tilt or overturn the appliance to prevent oil from overflowing.
- Correct operation of the appliance can only be guaranteed if it is connected to legally compliant electrical systems, which totally correspond (voltage, frequency) to the data shown on the appliance data plate. If in doubt, ask for the system to be checked by a specialised electrician.
- Electrical safety can only be guaranteed if the appliance is connected to a compliant earthing system. Ensure this essential safety condition is satisfied. If in doubt, ask for the system to be checked by a specialised electrician.
- Multiple sockets or extension cords do not guarantee the necessary safety (fire hazard). Therefore, do not connect the appliance using this type of device.
- If electrical or mechanical components are touched or modified, injuries and faults to the appliance may occur. Never open the appliance casing.
- Interventions to the electrical connection system and access to live parts are allowed only to qualified personnel.
- If the power cable is damaged, it must be replaced by an authorised service centre.
- If the plug is disconnected or if the cable is not equipped with a plug, make sure that the appliance is connected to the electrical mains by a qualified electrician.
- If you notice any anomalies in the appliance (for example: damaged power cable or failure of the control panel), do not use the machine and promptly notify the authorised service centre.
- Never use the appliance with wet hands or where there is any contact with water.
- Use suitable work clothing and protective gloves.
- Do not put objects in the ventilation openings of the machine: danger of electric shock!
- The right to warranty coverage expires if the packaging machine is not repaired by an authorised service centre.
- Replace any faulty or defective parts exclusively with original spare parts supplied by the dealer (replacement must be performed by qualified personnel).
- In the event of a power failure during the vacuum process, the chamber remains in vacuum and the cover cannot be opened. Never attempt to open the cover by applying force or using tools. Once the electrical power is restored, it will be possible to open the cover again.
- When carrying out special maintenance, installation or repair works, disconnect the appliance from the electrical mains and remove the plug from the outlet. If the plug is not accessible, deactivate the electrical system to which the appliance is connected via the main switch. Before carrying out any repair or installation work, make sure that the appliance is actually disconnected from the mains.
- At the time of scrapping, make the appliance unusable by cutting the power cable and removing the cover, so that children cannot easily access the inside.

1.5 Correct use

- Scalding hazard! After the bag sealing process, the sealing bar and bag seal itself are very hot. Do not touch the sealing bar or the sealing line immediately after the sealing process.

- Fire hazard! Do not store easily flammable materials and substances in the immediate surroundings of the packaging machine.
- Damage to the cover may cause an implosion. Do not place any object on the cover and do not collide with any type of object on the surface. In the event of an accidental collision with the cover, carefully examine for damage. If in doubt, contact an authorised service centre.
- Do not use the appliance or cover as a work, support or cutting surface.
- **Always pack food cooled from 0÷5°C:** the best vacuum and storage results are obtained. It also prevents the formation of vapours that can cause disturbances in the operation of the packaging machine, especially the vacuum pump, which can be damaged by oxidation caused by condensed vapours. Monitor the vacuum process carefully and if bubbles form in the liquid, prevent leakage by sealing in advance.
- If liquids reach the pump suction, they can cause serious damage.
- Before using containers or jars of any kind, make sure they are sturdy enough to withstand vacuum even if placed in the refrigerator, in order to avoid implosion which can be dangerous for the user.
- If the machine remains unused for a long time, turn it off by removing the plug from the socket and carry out routine maintenance (oil change and exhaust filter) (See SCHEDULED PERIODIC MAINTENANCE table Chap.14)

1.6 Cleaning and maintenance

- To clean the appliance, use only damp cloths and non-aggressive disinfectant and detergent products. Do not use sponges or abrasive cloths, to avoid damage to steel surfaces and cover surfaces.
- Water or vapour could reach live parts and cause a short circuit. Never use running water or vapour cleaning appliances: danger of electric shock!
- Cleaning and regular maintenance for the user cannot be carried out by children without supervision.
- For cleaning the PMMA cover use only drinking water or detergents declared suitable for cleaning PMMA surfaces. Products based on solvents or alcohol and their vapours irreparably damage the cover.

2 ADVICE FOR THE PROTECTION OF THE ENVIRONMENT

a) Packaging:

The packaging materials is 100% recyclable and is marked with the recycling symbol. Follow local waste disposal regulations. The packaging material (plastic bags, polystyrene parts, etc.) must be kept out of the reach of children, as it is a potential source of danger.

b) Scrapping/Disposal:

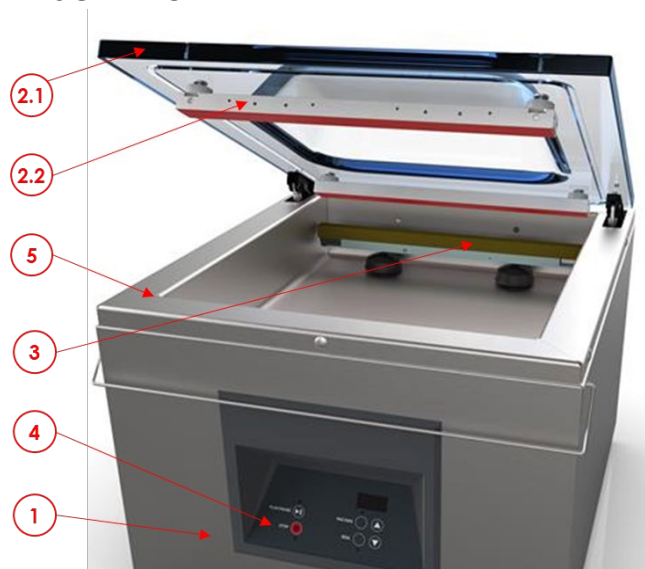
The appliance is made of recyclable material. This appliance is labelled in compliance with European Directive 2012/19/EU, Waste Electrical and Electronic Equipment (WEEE). By ensuring that this appliance is scrapped properly, you help prevent potential negative consequences for the environment and health.



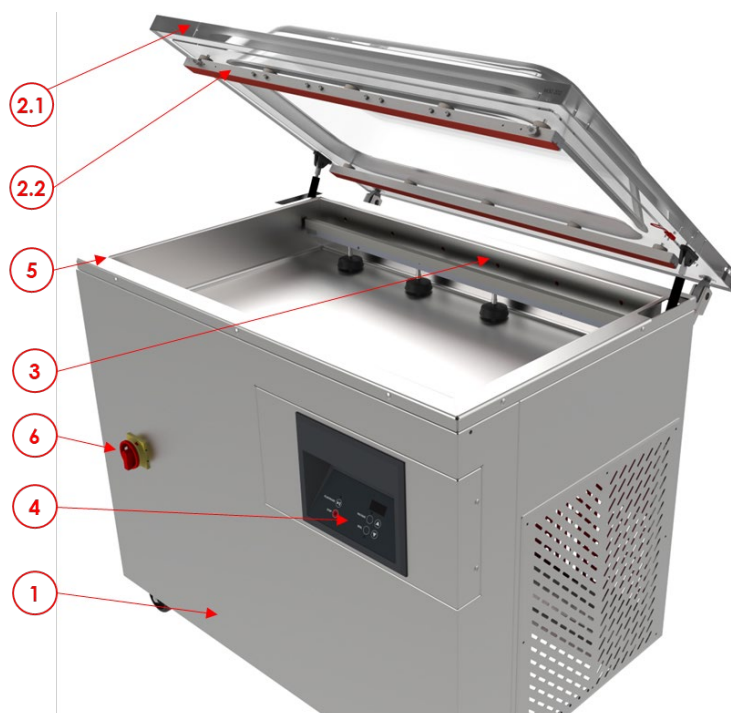
The symbol on the appliance, or on the accompanying documentation, indicates that this appliance should not be treated as household waste, but should be delivered to the appropriate collection point for the recycling of electrical and electronic equipment.

At the time of scrapping, make the appliance unusable by cutting the power cable and removing the cover so that children cannot easily access the inside. Scrap it according to local waste disposal regulations and deliver it to the appropriate collection points, not leaving it unattended as it is a source of danger for a child. For further information on the treatment, recovery and recycling of this appliance, please contact the appropriate local office, household waste collection service or the shop from which the appliance was purchased.

3 PACKAGING MACHINE DESCRIPTION



(The model in the image below may not exactly match that of the packaging machine you purchased)



3.1 Figure 1-2: Images of machine components

NR	DESCRIPTION
1	Machine body inside which all the components necessary for the operation of the machine are inserted
2.1	Cover equipped with gasket for closing the vacuum chamber
2.2	Releasable detachable bar required in the sealing phase
3	Sealing bar for sealing the bag after the vacuum cycle
4	Control panel to manage the machine's functions

NR	DESCRIPTION
5	Vacuum chamber inside which the product packaging cycle takes place
6	ON/OFF switch for free standing machine

3.2 Control panels

Digital control panel



NR	MACHINE MODEL	DIGITAL CONTROL PANEL	WELDING BAR TYPE	OPTIONAL
1	..41	✓	DOUBLE NiCr WELDING BAR	REFER TO TECHNICAL SHEET
2	..45	✓	DOUBLE NiCr WELDING BAR	REFER TO TECHNICAL SHEET
3	..61	✓	DOUBLE NiCr WELDING BAR	REFER TO TECHNICAL SHEET
4	..95	✓	DOUBLE NiCr WELDING BAR	REFER TO TECHNICAL SHEET
5	..111	✓	DOUBLE NiCr WELDING BAR	REFER TO TECHNICAL SHEET



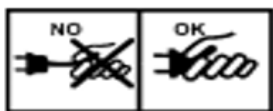
Note: The pictures included in the manual are for illustrative purposes only and may not accurately represent the actual components installed in the machine.

4 GENERAL RULES OF USE



ELECTRICAL HAZARD! Make sure in advance that the voltage indicated on the identification plate of the machine is the same as your network.

The electrical safety of this appliance is guaranteed only if it is correctly connected to an effective earthing system, as required by current safety regulations. The manufacturer declines all responsibility for any damage caused by the lack of earthing of the system.



ELECTRICAL HAZARD! Insert and remove the plug into the outlet always with the appliance switched off; do not pull on the cable but directly on the plug. Access to live parts is allowed only to qualified personnel.



WARNING! Place the machine on a solid and safe horizontal work surface.

WARNING! The appliance must be positioned so that access is possible from all sides. This will also ensure the necessary ventilation of the machine.

WARNING! If you have a machine with a gas function, it is advisable to anchor the cylinder to the wall. At the end of use and when the machine is switched off, always close the cylinder valve and the pressure reducer.



DANGER! In appliances equipped with gas option, IT IS FORBIDDEN TO USE GAS MIXTURES CONTAINING MORE THAN 21% OXYGEN, OR OTHER COMBUSTIBLE EXPLOSIVE GASES. The adjustment of the gas mixtures must be carried out by the gas manufacturer in the factory, or by authorized personnel, at the place of use of the machine. Entrust the supply and installation of the cylinder to qualified personnel of the supplier company.



WARNING! The vacuum packaging machine has been designed and studied to vacuum bags and rigid containers, with a maximum frequency of one standard complete cycle (vacuum and sealing) every 60 seconds.



WARNING! Proceed to the immediate stop of the machine, in case of gas leaks caused by defective, oxidized fittings, or by damaged pipes.



Immediately contact the nearest service desk for replacement of damaged parts



WARNING! In order to avoid an increase in oil density that could compromise the smooth operation of the pump, the ambient temperature should never fall below +10°C.

WARNING! The pump oil must be checked at each use of the machine, through the indicator slide on the side or on the rear panel of the machine. The oil level must be within the MINIMUM and MAXIMUM range. The colour must be clear and free of turbidity.

4.1.1 Figure 3-4: Oil level peephole



The position of the oil level sight glass is indicated by the dedicated yellow label applied:

Table top machine:



Free standing machine:



WARNING! THE PUMP OIL MUST BE REPLACED PERIODICALLY; THE FREQUENCY OF THE OIL CHANGE INCREASES PROPORTIONALLY TO THE WORKLOAD TO WHICH THE APPLIANCE IS SUBJECTED. THE OIL CHANGE MUST BE CARRIED OUT AT LEAST EVERY 5,000 CYCLES OR EVERY 350 HOURS OF THE SERVICE PUMP. THE DEOILING FILTER MUST BE REPLACED AT EVERY OIL CHANGE. (See SCHEDULED PERIODIC MAINTENANCE Table Chap.14)

The frequency of the oil and filter change increases if operating with liquid or wet products; moreover, in this case, after a period of machine inactivity equal to or greater than one month, replace the oil.

Before resting for a period of inactivity of more than two months, change the oil and the exhaust filter. A whitish and cloudy or dark and transparent colouration of the oil signifies the intake of liquids and moisture or the age of the oil, respectively. There is a signalling system for oil change: once the maximum limit of working cycles has been reached, at the start of the machine and at the end of each cycle, an "oil alarm" indication appears on the display. The number of cycles carried out can be detected at any time by pressing the keys on the control panel. Periodically carry out the pump oil dehumidification cycle (for more information see chapter 13).



WARNING! DO NOT touch the sealing bars after sealing the bag, as they reach high temperatures.



4.1.2 Figure 5: Scald risk image



WARNING! Do not remove the Teflon cover placed on the sealing bar; do not use knives or other sharp tools for the removal of any residue on the sealing bar; always wait for it to cool down before working with tools that are not sharp and not pointed.



WARNING! Clean the machine thoroughly after use; the PMMA cover should only be cleaned with a cloth dampened only with water and never with detergents or solvents. For stainless steel parts, use the specific products available on the market. Do not use water or vapour jets, which could damage the electrical parts of the appliance.



For any problem that may arise (malfunction or technical assistance) contact our customer service.



WARNING! THIS MACHINE IS NOT DESIGNED FOR USE WITH PURE ALCOHOL OR LIQUIDS WITH A HIGH ALCOHOL CONTENT.

The use of liquids containing ethyl alcohol may cause: sudden boiling under vacuum, the formation of flammable vapours, irreversible damage to the vacuum pump, and a risk of fire or explosion.

The maximum permitted alcohol content is 20 % vol (v/v); higher concentrations are not permitted on machines fitted with an oil-sealed vacuum pump..



STRICTLY PROHIBITED the use of: 96% ethyl alcohol, liquids with an alcohol content of > 25% vol, flammable solvents.

Failure to comply with these instructions will invalidate the warranty and relieve the manufacturer of all liability for damage to persons, property or the machine



WARNING! Containers must only be used inside the chamber vacuum sealer in accordance with the safety instructions set out below, in order to prevent risks to the operator and the machine.

Use only containers specifically designed for vacuum applications:

- Containers made of stainless steel or other metallic materials structurally suitable for vacuum conditions are preferable, as they offer high mechanical resistance to the negative pressure generated during the vacuum cycle.
- The use of plastic or glass containers carries a potential risk of structural collapse or implosion when subjected to a vacuum.

These materials may not be able to withstand the pressure difference between the inside of the container and the external environment generated during the vacuum cycle.

The rupture or implosion of the container may cause: flying fragments, risk of injury to the operator, damage to the machine.



WARNING! Plastic or glass containers must only be used if the manufacturer has expressly stated that they are "suitable for chamber vacuum sealing" and comply with the relevant technical specifications.

Before use, always check: that there are no cracks, warping or defects; the condition of the container; and its compatibility with the set vacuum level.

Do not exceed the vacuum levels recommended by the container manufacturer.

If in doubt about the suitability of the container, DO NOT use it in the machine



DANGER! DO NOT USE:

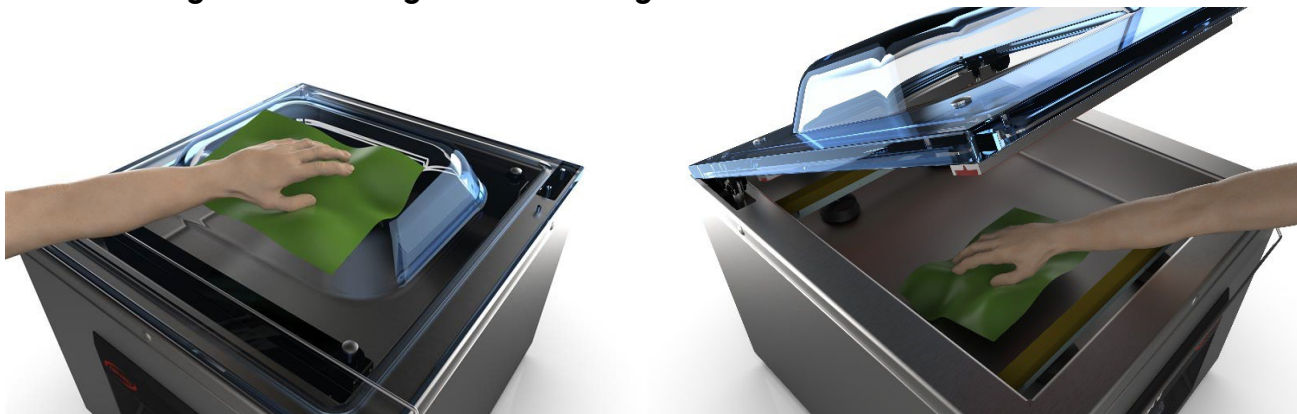
- household containers not certified for vacuum sealing,
- containers made of ordinary glass or non-reinforced plastic,
- damaged containers or those of unknown origin.

Failure to comply with these instructions may pose serious safety risks to the operator and will invalidate the machine manufacturer's liability.

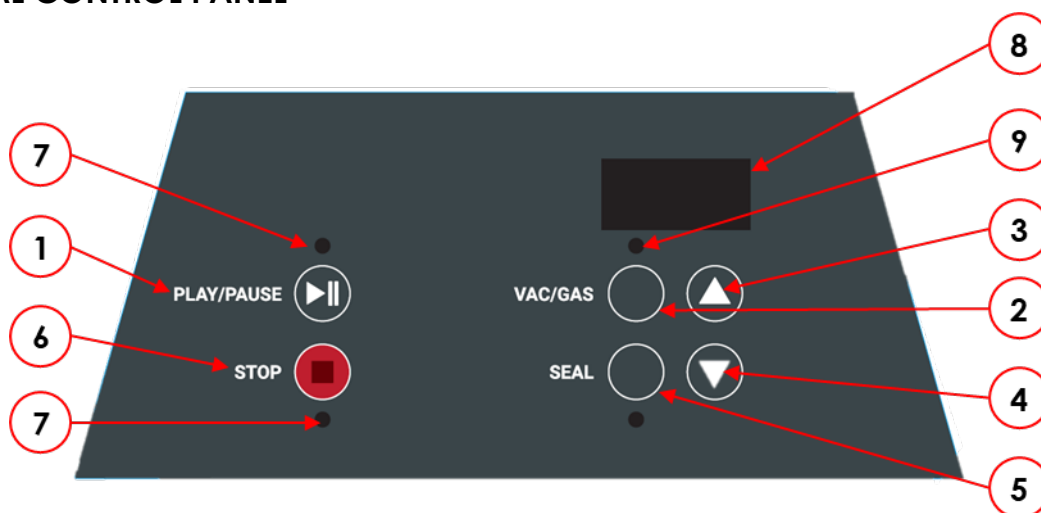
5 BEFORE USING THE PACKAGING MACHINE

- Before operating the packaging machine, it is necessary to clean the vacuum chamber and the cover, using a soft cloth dampened with drinking water.
- It is recommended not to use aggressive detergents, stainless steel scrubbers, scrapers or abrasive, acidic or aggressive substances, which may permanently damage the internal surfaces of the vacuum chamber.

5.1.1 Figure 6: Cleaning indication image



6 DIGITAL CONTROL PANEL



NR	DESCRIZIONE
1	• Pressed for 4" at the same time as STOP, allows the display of the number of cycles performed • Pressed at power on, simultaneously with STOP, allows the acoustic signal to be activated or deactivated
2	• Allows you to adjust the functions vacuum, additional vacuum, GAS • When pressed after 90% vacuum is reached, it allows the input of GAS to be anticipated
3	• Scroll through the programs P1-P20, dEG,JAr,H2o; • Variation in function values
4	• Pressed together for 4", they allow the stored programs to be reset, restoring the factory values
5	• Allows you to adjust the welding time • Pressed during the work cycle, it allows the welding to be anticipated
6	• Exit from stand-by/enter stand-by (pressed for 5") • Pressed for 4" simultaneously with PLAY/PAUSE, allows display of the number of cycles performed • Pressed at power on, simultaneously with PLAY/PAUSE, allows the acoustic signal to be activated or deactivated • Stops the current cycle
7	• Display the current function
8	• Displays active function • Displays active function and its value • Display alarm situations

NR	DESCRIZIONE
	Displays the number of cycles performed before the oil change
9	If ON is steady, it signals the active GAS function

6.1 FUNCTIONS AND WARNINGS

6.1.1 Maximum admissible values

FUNZIONE	VALORE
VACUUM	10% – 99%
ADDITIONAL VACUUM	1 – 60 sec
SEALING	0,1 – 6,0 sec
GAS	1 – 90%
SOFT AIR	0 – 60 sec
DEG	



CAUTION!

It is necessary to carry out preliminary tests, to identify the optimal percentage of GAS to be injected, for every single product to be packed.

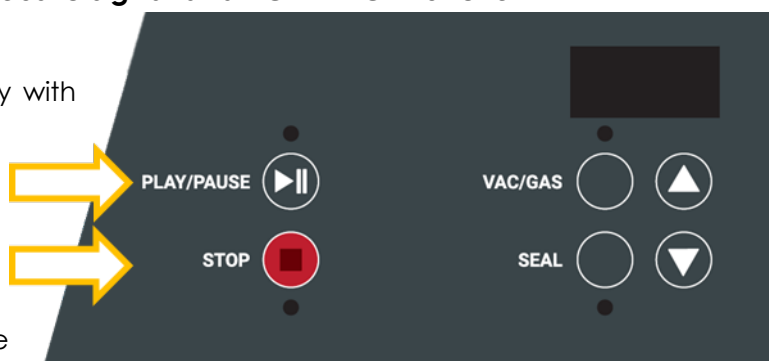
6.1.2 Factory configuration

FUNZIONE	VALORE
VACUUM	99
ADDITIONAL VACUUM	5 sec
SEALING	2,5 sec
GAS	OFF
SOFT AIR	0 – 60 sec
DEG	30÷99

6.1.3 Activate / deactivate the acoustic signal and POMPA ON function

Proceed as described below, to activate or deactivate the acoustic signal:
turn the machine on, pressing contemporarily with **STOP** and **PLAY/PAUSE** buttons.

To deactivate the **PUMP ON** mode, hold down the **PLAY/PAUSE** button until the vacuum pump turns off.
To reactivate the **PUMP ON** mode, press and hold the **PLAY/PAUSE** button again until the vacuum pump turns on.



After 15 minutes of inactivity, the packaging machine's PUMP ON function switches to OFF.

6.1.4 Visual alert



CAUTION!

In case the number of allowed cycles (preset in the machine) has been reached, at every switch-on the machine displays the pump oil change alarm "OIL".

6.1.5 Display of Machine Info – inF:

Press the ▲ "+" / "-" ▼ buttons (3 or 4) to select the **inF** function. Press **VAC/GAS** to enter the submenus listed below.

SEr – Hour counter for oil change, triggered at 2000 hours. When the maximum limit is reached, **oil** is displayed.

PtP – Pump service hours. Not resettable.

tot – Total machine hours. Counts operating time. Does not count time in standby mode – this counter is not resettable.

oil – Incremental hour counter for oil change. After 5000 cycles, **oil** is displayed.

Hot – Number of "hot" alarms – resettable via **oil** counter reset.

H2o – Number of H2O alarms – resettable via **oil** counter reset.

ESC – Exit button from submenus, returns to main menu, in the previous selection before **inF**.

How to activate the inF submenu functions:

- Machine in standby. Display: shows program number. LEDs: off.
- Select inF submenu: Press ▲ "+" / "-" ▼. L2 LED remains on. Display: shows **inF**.
- To view values: press **VAC/GAS** to display the value of the selected counter.

The values are displayed for 7 seconds, after which the screen returns to **inF**.

7 THE VACUUM



CAUTION!

Pack the product always cold, possibly at 3-4 ° C. The hotter the product, the shorter the shelf life is. You also increase the moisture inside the pump, with consequent oxidation and damage of it.

Preheating of pump oil: If the machine is used only occasionally, please perform at least 2-3 complete CYCLES (VAC 99% AND VAC+ 60") before packaging the products. This allows to pre-heat the oil and the evacuate the water in the pump.

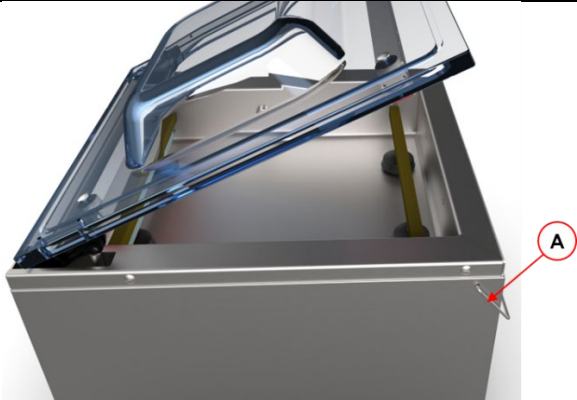
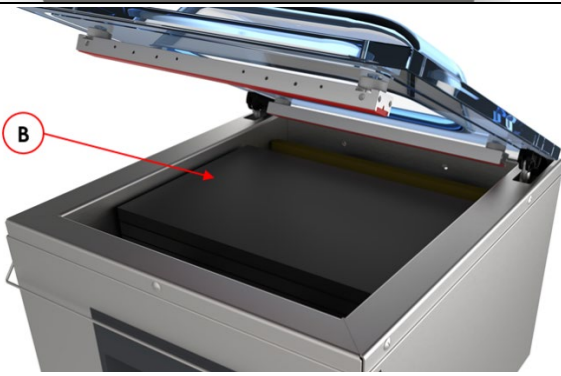
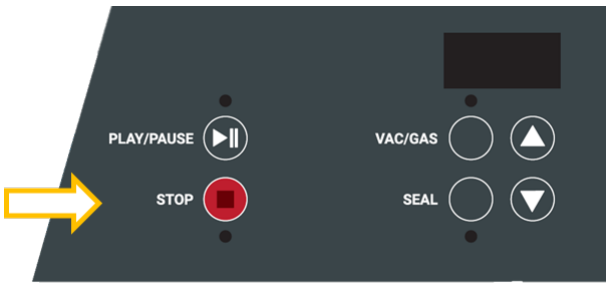
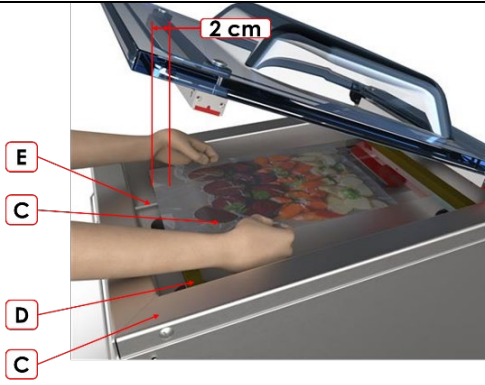
Oil pump dehumidification cycle H2Out. In case the machine is used in the restaurant sector, the H2Out pump cleaning programme should be run every day at the end of the working day. In all other cases, H2Out must be run every week.

Models with GAS option. Vacuum setting with GAS function active. If the function is activated, the vacuum level must be set at the maximum value. Whether the product still appears as crushed, the Gas percentage must be increased, without modifying the vacuum level! It can be reduced to 95-97%, only to pack stuffed products which could blow up due to the excess of vacuum (stuffed fresh pasta)

At the end of working day, unhook the piston pressing it towards and lower the lid in the rest position. Doing so, the vacuum chamber will be protected from dirt and dust.

7.1 Vacuum Packing Foodstuff In Bags

Phase	Description	Image
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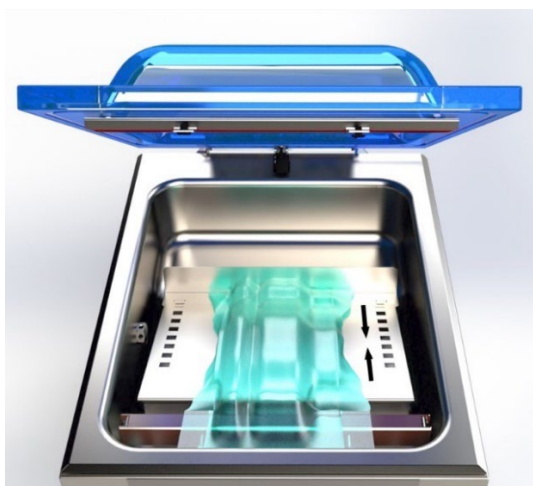
1	Choose the bag depending on the use (preservation or cooking) best suited to the dimensions of the product: the product should not take more than 2/3 of the bag actual volume. <i>Insert products cooled to +3°C to achieve the best result.</i>	
2	Unlock the lid opening by placing the lid lock downward. (A)	
3	Open the lid and make sure the vacuum chamber and product to be packaged are dry. Take care not to dirty or wet the inner part near the bag opening. Place the maximum number of black plates (B) the vacuum chamber can contain, according to the size of the product to be packed.	
4	To turn on the packaging machine, press for 5" the button indicated by the arrow	
5	Put the vacuum bag (C) containing the product to be packed, in the vacuum chamber (B) and place it centrally on the sealing bar (D). The fringe, no wrinkles, has to overpass the sealing bar about 2cm. Do not bend downwards the bag exceeding the sealing bar. In case the gas injection is required, insert the gas nozzle in the bag open part (E).	

6	Select one of the 10 programs, using UP/DOWN buttons. P1 - P20; H2O; JAR; DEG (if optional active)	
7	Press the VAC/GAS key and set a vacuum value from 30% to 99%, using the UP/DOWN keys. Vacuum values lower than the maximum, reduce or cancel the preservation effect, as residual air remains in the package.	
8	If the vacuum was set to 99%, then press UP/DOWN buttons again to set the additional vacuum level between 1" and 60".	
9	OPTIONAL GAS: Press VAC/GAS button to select GAS parameter and UP/DOWN buttons to set a value between 1% and 90%. When the GAS function is active, make sure that the vacuum level set is 99%.	
9b	OPTIONAL SOFT AIR: Press the VAC/GAS button and set the SOFT AIR value from 0 to 60 seconds using the UP/DOWN buttons.	
10	Press SEAL button to set the sealing time between 0,1" and 6,0", depending to the vacuum bag in use.	

11	Lower the lid using both hands, by pressing on the corners. The vacuum cycle starts automatically.	
12	Press VAC/GAS button to switch in advance from Vacuum phase to GAS phase. Press VAC/GAS to advance the GAS phase, verifying that the vacuum threshold of 90% was reached. Otherwise, the sealing will be activated. Press SEAL button to switch in advance to sealing.	
13	Pressing STOP button at any time, it is possible to interrupt the vacuum cycle immediately and the vacuum chamber is uncompressed. The lid opens automatically. The machine comes back to the selected program.	
14	End of cycle. The lid opens automatically. Remove the packed products, paying attention not to touch the sealing bar, as it may be still hot.	

In case of packing liquid products, fill the bag **no more one-third** of its volume; if the optional "sloping shelf for liquids" is available, adjust it according to the bag size.

Turn the machine on and proceed in setting the parameters, as described in the chart above, adjusting the vacuum level, in order to avoid any liquid overflowing.



Lower the lid using both hands, by pressing on the corners. The vacuum cycle starts automatically.

7.2 Vacuum packing foodstuff in containers



WARNING! Verify that the selected containers were suitable to resist to the vacuum pressure. At the end of working day, unhook the piston pressing it towards and lower the lid in the rest position.

Doing so, the vacuum chamber will be protected from dirt and dust.



CAUTION!

Read carefully the information written at the beginning of Chapter 7.

Choose a container suitable for vacuum packaging

Fill the container with foodstuff and close the lid.

Filling limits:

- Solid products: 100%
- Broths, infusions: 1/2
- Vegetarian and meat sauces: 1/3
- Creams, cream-based sauces: 1/4
- Egg products or egg white: 1/6



Insert products cooled to +3°C to achieve the best result.

Lift the lid to limit switch and clip the piston, pulling it forward.

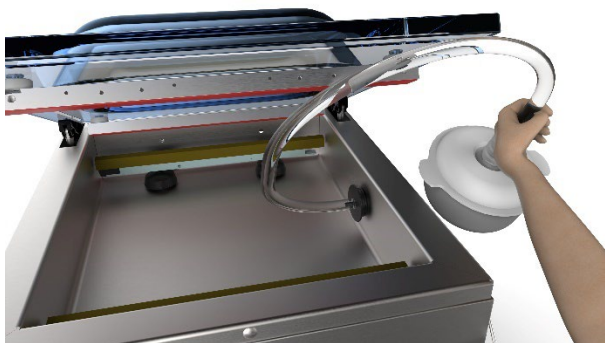
7.3 Contenitori in vasca

Fase	Descrizione	Immagine
1	Ensure that the vacuum chamber and the product to be packed are lowered <3°C (<37.4°F). Take care not to dirty or wet the inner part. Place the maximum number of black plates (B) the vacuum chamber can contain, according to the size of the product to be packed.	
2	Choose a container suitable for vacuum packaging that fits in the vacuum chamber, which remains at least 1 cm apart from the packaging machine lid once closed. It is possible to remove the sealing bar, if necessary. Make sure that the air intake device be open.	
3	To turn on the packaging machine, press for 5" the button indicated by the arrow	

4	Press UP/DOWN buttons, to select the Jars (JAR) program.	
5	Press the VAC/GAS key and set a vacuum value from 10% to 99%, using the UP/DOWN keys	
6	Lower the lid with both hands, pressing on the corners of the lid. The cycle will start automatically.	
7	Press the PLAY/PAUSE button, to start the vacuum cycle.	
8	Pressing STOP button at any time, it is possible to interrupt the vacuum cycle immediately and the vacuum chamber is uncompressed. The lid opens automatically. The machine comes back to the selected program.	
9	End of cycle. The lid opens automatically. Pull out the container.	

7.4 Containers external (ONLY FOR TABLE TOP MACHINE)

Phase	Description	Image
1	Place the accessory (A) to operate the vacuum in containers externally, both in the vacuum chamber and on the container lid. Make sure that the air intake device be open.	



2	To turn on the packaging machine, press for 5" the button indicated by the arrow	
3	Press UP/DOWN button, to select the Jars (JAR) program.	
4	Press VAC/GAS to select the parameter Vacuum and press UP/DOWN to set a value between 10% and 99%.	
5	Lower the lid and press the PLAY/PAUSE button to start the cycle	
6	Place one end of the suction device on the suction point in the chamber and slightly press the other on the container lid, to start the vacuum.	

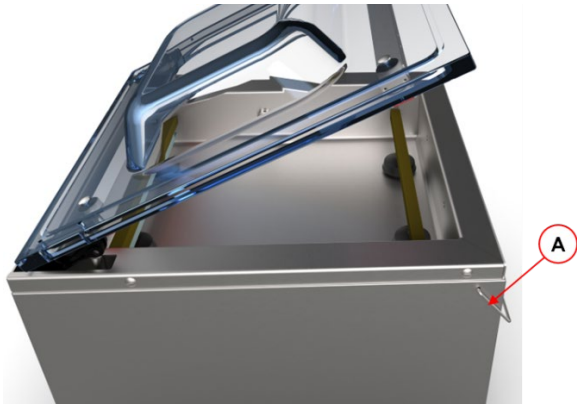
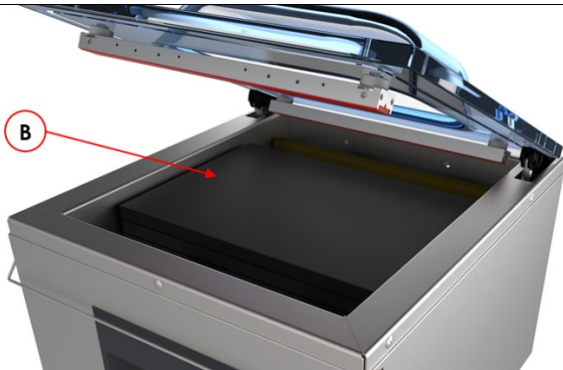
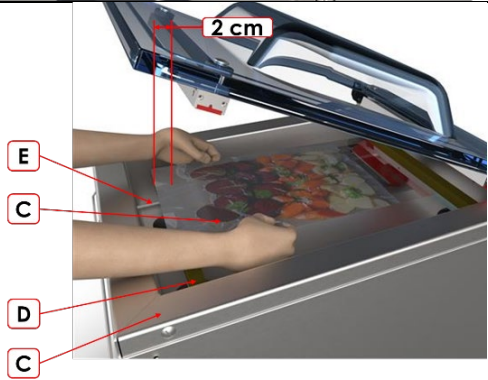
7a	In case the vacuum was set at a level lower than 99%, the pump switches off. Remove the accessory and place it on the lid of next container. Press PLAY/PAUSE button, to start a new vacuum cycle.	
7b	In case the vacuum was set at 99%, the pump remains on. Remove the accessory and place it on the lid of next container.	
8	Pressing STOP button at any time, it is possible to interrupt the vacuum cycle immediately.	
9	At the end of the vacuum cycle, remove the accessory from the vacuum chamber.	

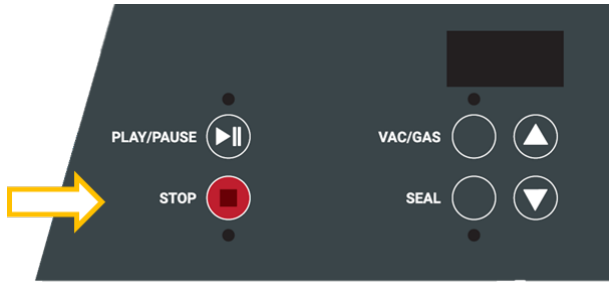
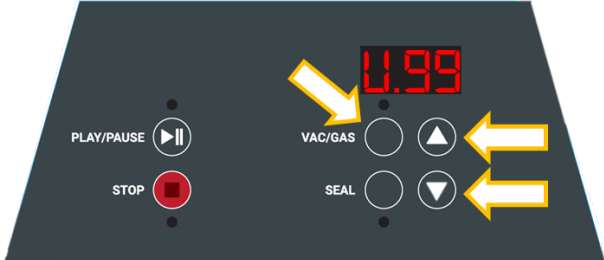
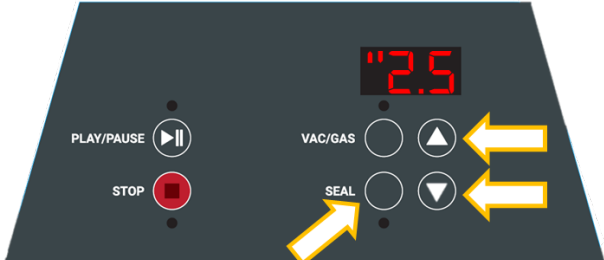
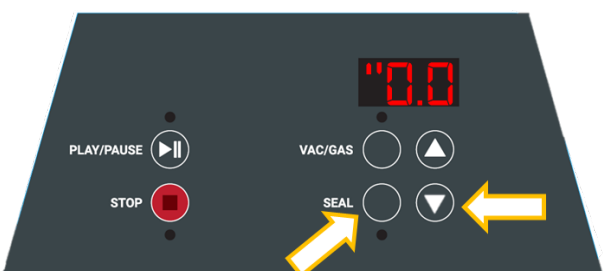
7.5 Deaeration cycle (DEG)

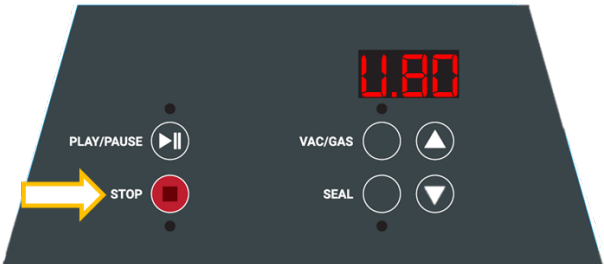
Program which allows to choose a pause and restart for the vacuum phase, as well as for the air re-entering phase, to allow the complete air evacuation from the inside part of the product.

The function is an OPTIONAL and present in machines where the function is active.

Fase	Descrizione	Immagine
1a	Choose the bag depending on the use (preservation or cooking) best suited to the dimensions of the product: the product should not take more than 2/3 of the bag actual volume. Be careful not to wet or dirty the bag open part. <i>Insert products cooled to +3°C to achieve the best result.</i>	

1b	Choose a container suitable for vacuum packaging that fits in the vacuum chamber, which remains approximately 1 cm from the packaging machine lid once closed. Fill the container with foodstuff and close the lid. Filling limits: • Solid products: 100% • Broths, infusions: 1/2 • Vegetarian and meat sauces: 1/3 • Creams, cream-based sauces: 1/4 • Egg products or egg white: 1/6 Insert products cooled to +3°C to achieve the best result.	
2	Unlock the lid opening by placing the lid lock downward. (A)	
3	Ensure that the vacuum chamber and the product to be packed are lowered <3°C (<37.4°F). Take care not to dirty or wet the inner part. Place the maximum number of black plates (B) the vacuum chamber can contain, according to the size of the product or the container to be packed.	
4a	Put the vacuum bag (C) containing the product to be packed, in the vacuum chamber (B) and place it centrally on the sealing bar (D). The fringe has to overpass the sealing bar about 2cm. Do not fold down the part of the envelope exceeding the sealing bar. If you intend to use gas injection, insert the nozzle inside the envelope (E).	

4b	Choose a container suitable for vacuum packaging that fits in the vacuum chamber and remains at least 1 cm apart from the lid closed. It is possible to remove the sealing bar, if necessary. Make sure that the air intake device be open.	
5	To turn on the packaging machine, press for 5" the button indicated by the arrow	
6	Select the deaeration program (DEG) UP/DOWN buttons.	
7	Press VAC/GAS to select the parameter Vacuum and press UP/DOWN to set a value between 60% and 99%.	
8a	Using a bag, press SEAL button to set the sealing time between 0,1" and 6,0", depending to the vacuum bag in use.	
8b	Using a container, press SEAL button to set the sealing time to 0".	

9	Lower the lid using both hands, by pressing on the corners. The vacuum cycle starts automatically.	
11	Press PLAY/PAUSE button, to pause the vacuum phase (to flat the bubbles appeared into the bag and avoid any product overflowing) and press it again, to have a partial air re-entering and start a new vacuum phase. Multiple time, to achieve Th operation can be repeated multiple time, to obtain – step by step – the vacuum level programmed.	
12a	Using a bag: Press SEAL button to switch in advance to sealing.	
13	Pressing STOP button at any time, it is possible to interrupt the vacuum cycle immediately and the vacuum chamber is uncompressed. The lid opens automatically. The machine comes back to the selected program..	
14a	End of cycle. The lid opens automatically. Remove the packed products, paying attention not to touch the sealing bar, as it may be still hot	
14b	End of cycle. The lid opens automatically. Remove the container.	

8 NOTIONS ON PRODUCT PACKAGING TEMPERATURES AND PUMP OIL



WARNING! The following simple but basic rules, explained more fully in the following points, if respected, allow you to work with your machine without inconvenience both in terms of the result (better and longer storage of the product), and in terms of the life and performance of the pump. It is essential that the pump oil (developed specifically for the application of food vacuum and FDA certified), is always in the best conditions: fluid and clean, i.e. Free of coarse impurities and of watery parts.

In order to prevent damage to the pump, the appliance stores the cycles carried out and helps you to remember to change the oil through a visual and acoustic signal, which is activated when the maximum permissible threshold of working cycles has been exceeded.

The following important rules must be adopted:



1) The products to be vacuum packed must have been cooled in the refrigerator or in a temperate blast chiller at a temperature of $0\pm5^{\circ}\text{C}$.

Once the product to be packaged has been removed from the blast chiller or refrigerator, proceed immediately with vacuum packaging: do not leave the product at room temperature for more than 1-2 minutes.

When special "chef" cycles are carried out (example: Marinade), both the solid product and the liquid part, must be blast chilled to $0\pm5^{\circ}\text{C}$.

Within this temperature:

- Bacterial proliferation is reduced and a higher yield and shelf life are obtained.
- The transfer of moisture in the form of water vapour, which is sucked by the pump causing the oxidation of the internal surfaces until it reaches the blockage, is reduced to a minimum.



2) Periodically check the oil level and carry out, on a DAILY basis, at least two "H2Out" oil dehumidification cycles: at the start of work, before starting to pack, so as to heat the pump oil; at the end of the day, before switching off the machine; in general after packaging cycles carried out with liquid products (sauces, gravies, etc.) or in the presence of liquids ("chef" cycles such as marinade in a bag or container).



3) When the environmental conditions in terms of noise allow it and if the intensity of use of the machine is sustained, we recommend enabling the "pump always on" function in the user menu (see §6.2.1) also in bench versions, while it is almost essential in wheeled models with 60, 106 and 150mc/h pumps. With this function active, the pump oil remains constantly at the ideal working temperature of about 90°C , facilitating the continuous expulsion of the water vapours sucked from it and considerably reducing the risk of blockage due to oxidation of the pump itself. In wheeled machines with high flow pumps, it reduces joint wear by avoiding continuous start-ups with each cycle.



4) Perform regular routine maintenance. In particular, the oil and the exhaust filter of the pump must be changed according to the workload, however at least every 12 months or at lower intervals, if the use is particularly heavy (frequent "chef" cycles or cycles for the packaging of liquids).



5) Use original Orved oil and deoiling filters, which guarantee maximum efficiency of the pump. The use of non-original spare parts voids the warranty. Rely on an authorised Orved service centre for maintenance.



6) After a period of non-use of the machine exceeding one month, perform an oil change BEFORE putting the machine to rest!

In the event that it is not possible to immediately change the oil, carry out three or four dehumidification cycles of the H2OUT oil.



WARNING! In order to prevent damage to the pump, the appliance stores the cycles carried out and helps you to remember to change the oil through a visual and acoustic signal, which is activated at each ignition once the maximum permissible threshold of working cycles has been exceeded. It also tells you at the end of the cycle to "cool the product" or "run H2Out" when you are working with products that are at room temperature.



WARNING! In vacuum, ROOM TEMPERATURE ($14-28^{\circ}\text{C}$) corresponds to HIGH TEMPERATURE!

8.1 Pump oil knowledge

WARNING!



It is essential that the pump oil (developed specifically for the application of food vacuum and FDA certified), is always in the best conditions: fluid and clean, i.e. free of coarse impurities and free of aqueous parts.

Check the oil level periodically: for the catering and gastronomy sectors and in all cases where products containing moisture are packaged, the "H2OUT" pump oil dehumidification cycle must be carried out daily. For dry or non-food products, at least weekly (chap. 13).

- 1) The oil change must be carried out according to the workload, in any case at least every 6 months, or when the number of expected cycles is reached**, when the machine indicates OIL on the display. **Contact the assistance service to change the pump oil. At each oil change, the exhaust filter must be replaced.**
- 2) Before a period of non-use of the machine exceeding two months, carry out an oil change.** Waste oil residues, impurities and dirt deposits are thereby discharged together with the spent oil.
- 3) The temperature of the room where the machine is installed should not fall below +10°C, in order to avoid excessive oil thickening.** Greater oil fluidity makes it easier to start the cold pump.

9 "PUMP ALWAYS ON" FUNCTION

The "pump always on" function consists of operating the pump in a continuous cycle for the entire expected working shift. It has considerable advantages, which we describe below. It is activated by enabling the function in the user menu (§6.2.1). If the packaging machine is not used for 15 minutes in a row, the pump is automatically switched off; the function is reactivated the next time it is started.

Bench models: when the environmental conditions in terms of noise allow it, in the face of a sustained intensity of use of the machine, we recommend enabling the "pump always on" function in the user menu also in the bench versions. With this function active, the pump oil remains constantly at the ideal working temperature of about 90°C, facilitating the continuous expulsion of the water vapours sucked from it and considerably reducing the risk of blockage due to oxidation of the pump itself.

10 SCHEDULED PERIODIC MAINTENANCE

The regular execution of scheduled maintenance, as indicated below in this manual, reduces or completely eliminates inconveniences and disturbances and significantly extends the life of the machine. The absence of regular maintenance can cause significant repair costs and cancel, in some cases, the right to cover the damage. In addition, respecting what is indicated, a good level of hygiene is maintained.

To carry out cleaning and maintenance routine operations safely, we refer to the following rules:

ELECTRICAL HAZARD!

If the power cable is damaged, it must be replaced.

ELECTRICAL HAZARD!

The cleaning, disinfection, maintenance and/or repair of any component of the appliance must be carried out exclusively with disconnected energy sources (disconnection of the electrical plug from the general network of the system).

DANGER!

It is strictly forbidden to remove the guards and safety devices to carry out routine maintenance operations. Orved S.p.A. declines all responsibility for accidents caused by non-compliance with the aforementioned obligation

WARNING!

For any operation of maintenance, handling, installation and cleaning of the appliance, always use appropriate means of prevention and protective clothing (gloves, etc.).

WARNINGS! Maintenance work or access to live parts of the machine must only be carried out by qualified personnel.



For any repairs, contact a technical assistance centre authorised by the manufacturer if possible. Only use and/or claim the use of original spare parts.

Do not carry out maintenance on your own, where the manual indicates the intervention of qualified personnel.

Do not touch the machine with bare, damp or wet hands or feet.

Do not insert screwdrivers, kitchen utensils or other, between the guards, openings and moving parts of the packaging machine,

At the end of the work, lower and hook the cover in the rest position, in order to protect the vacuum chamber from dirt and dust.

Key: 1-G: daily; **1-S:** weekly; **6-M:** every 6 months; **1-A:** annually

MACHINE DETAIL	INTERVENTION	FREQUENCY				INTERVENTION CARRIED OUT	
		1-D	1-W	6-M	1-A	USER	HELP CENTRE
Pump	Check the oil level and colour; top-up or change completely, if the colour is dark or whitish (call the specialized support service).	X				O	Top up or replacement
Pump	Perform a pump heating cycle of at least 5 minutes or a pump oil dehumidification cycle.	X				O	
Power cable	Check integrity; replace if faulty.	X				O	Replacement
Plexiglass cover	Check integrity; in the presence of cracks and streaks, call the help service for cover replacement.	X				O	Replacement
Silicone counterpart bar and Plexiglass cover gasket	Check that they are well inserted in their respective seats; replace if defective or worn out.	X				O	Replacement
Machine and vacuum chamber	Clean from impurities, oils and greases.	X				O	
Sealing bar connection	Check that it is well inserted on the two contact pins.	X				O	
Pump	Perform a pump oil dehumidification cycle	X	X			O	
Sealing bar	Clean the top part with a damp cloth. Clean the two pins and contact holes		X			O	
Machine, vacuum chamber, cover and shelves	Disinfect		X			O	
Pump	Change the pump oil			X	X		O
Pump	Change the exhaust filter of the pump			X	X		O
Pump	Change the oil in the pump and the exhaust filter when the machine is put out of service (for a period of more than 2 months)	<i>This intervention must be carried out before the machine is put out of service for a long period of time</i>					O

11 TROUBLESHOOTING

NUM	PROBLEM	POSSIBLE CAUSES	SOLUTION
1	Machine does not work.	Machine turned off	Start the machine by pressing the STOP button FOR 5"
		No power supply	• Insert the plug into a socket (check voltage!). • Check the condition of the power cable at regular intervals. • Check that the PF1 fuse on the power board is intact and well inserted (contact the service centre).
		Machine damage	Contact the help centre
2	Insufficient vacuum in the bag/ there is a loss of vacuum in the bag	Wrong packaging cycle parameters.	Program the vacuum parameter to the maximum level of 99%.
		Product not cooled.	Cool the product to 0-5°C.
		Badly positioned bag	Position the bag centrally on the sealing bar with a 20 mm projection beyond the bar
		Perforated bag	Choose a thicker bag and wrap the product with film or soft paper
		Insufficient sealing	Increase sealing time
		Faulty bag	Replace the bag
		The opening of the bag is dirty	Use a new bag and be careful not to dirty the opening with oil, grease, etc.
		Bag too large or too small compared to the size of the product	Choose a bag that is suitable for the size of the product to be packed.
		Inefficient pump or leak in vacuum circuit.	Call an authorized service center.
3	The bag inflates during the vacuum phase	Incorrectly positioned bag with downward flap	Position the bag correctly.
		The sealing bar is raised during the cycle.	Contact the authorised technical support centre
4	The sealing has bubbles and burns	Sealing time too long	Reduce sealing time
	Narrow and irregular sealing	Sealing time too short	Increase sealing time
5	Insufficient vacuum in the chamber.	The set vacuum value is insufficient	Increase the value using the UP and DOWN keys
		Insufficient vacuum pump performance	Contact the authorised technical service centre.
		The gasket of the cover is worn out	Replace the cover gasket (contact the support centre)
6	The machine does not generate the vacuum in the chamber.	Insufficient pressure on the cover when starting the appliance	Lower the cover with both hands on both sides, exerting more pressure
		For appliances with gas option: active gas function	Disable the gas function
		Pump does not work or does not suck, the cover does not remain lowered.	Contact the authorised technical support centre
7	Machine does not seal.	Dirty sealing bar contacts	Clean the contacts
		Interrupted sealing bar contacts	Contact the authorised technical support centre
		Broken sealing bar resistor	Contact the authorised technical support centre
		Sealing bar lifting piston defective	Contact the authorised technical support centre
8	Poor sealing quality	Dirty sealing bar	Clean the sealing bar
		Insufficient sealing time with respect to the weight of the bag	Increase sealing time
		Worn out covering Teflon	Contact the authorised technical support centre

NUM	PROBLEM	POSSIBLE CAUSES	SOLUTION
		Excessive gas percentage (close to 90%) in relation to the packaged product	Decrease the gas injection percentage
		Worn-out counter silicone	Contact the authorised technical support centre
9	Insufficient amount of gas in the bags.	Insufficient gas injection percentage	Increase the percentage of gas injection
		Insufficient gas cylinder pressure	Adjust the pressure on the cylinder reducer to 0.5-1 bar
		Gas nozzle not inserted in the mouth of the bag	Reposition the bag by inserting the gas nozzle into the open flap of the bag itself
		Incorrect bag volume/lower product volume ratio.	Choose a larger size bag or reduce the amount of product.
		Closed cylinder or pressure regulator valves	Open the cylinder valves and adjust the pressure reducer to 0.5-1.0 bar
10	There is no vacuum in the containers.	Poorly positioned container cover or open lid valve	Reposition the cover of the container, checking that the gasket is intact and inserted in its seat and that the lid intake valve is in the open position
11	PMMA cover won't close	The gasket of the cover is worn out	Contact the authorised technical support centre
		No vacuum is created in the chamber due to pump defect or leakage in the vacuum circuit or blocked solenoid valve	Contact the authorised technical support centre
		Offset hinges	Contact the authorised technical support centre
		Damaged gas spring	Contact the authorised technical support centre
12	The PMMA cover does not open at the end of the cycle	Drain solenoid valve defective or not activated due to missing connection or electrical contact.	Contact the authorised technical support centre
13	There is pump oil in the vacuum chamber	Defective pump or clogged exhaust filter.	Contact the authorised technical support centre
14	Oil mist forms in the workplace	The pump emits oil mist due to the clogged exhaust filter.	Contact the authorised technical support centre

12 INSTALLATION

12.1 Safety instructions

This manual is an integral part of the product and provides all indications necessary for correct installation and maintenance of the machine.



It is mandatory for the user and the installer to carefully read this manual and refer to it; it must also be stored in a place known and accessible to all authorized operators (installer, user, maintenance technician).

Do not touch the machine with damp or wet hands/feet or without suitable protection (suitable gloves and shoes).

Do not insert screwdrivers, cooking tools or other foreign objects between the protective devices and moving parts.

The appliance is only intended for the use for which it was designed, i.e. for the vacuum packaging of foodstuffs.

All other uses shall be considered improper and potentially hazardous.

The manufacturer declines any responsibility and any warranty obligation, in the event of damage to equipment, people or property, attributable to:

- incorrect installation and/or non-compliance with current laws;
- changes or interventions not specific to the model;

- use of non-original or non-model-specific spare parts;
- non-compliance, even partial, with the instructions in this manual;
- non-compliance during the installation of accident prevention regulations and laws in force.

12.2 Foreword



The installation must be carried out exclusively by authorised and specialised personnel, respecting the instructions and requirements of this manual.

- Before installing the appliance, make sure that the pre-existing electrical systems are in accordance with the law and adequate to the plate data of the equipment to be installed (V, kW, Hz, N° phases and available power).
- The installer must also check any fire-fighting requirements.
- The Manufacturer declares compliance with current European regulations.
- Always operate with the packaging machine disconnected from the electrical mains.
- Do not pull the power cable, to disconnect the packaging machine.



The machine must be handled using protective gloves and always by two people. All packaging components must be disposed of in accordance with the regulations in force in the country of use of the appliance. In any case nothing must be disposed of into the environment.

The components of the packaging can be potentially dangerous for children and animals, make sure they do not play with them

12.3 Plate data



Sulla confezione: applicata sul retro della confezione



(The model shown in the image may not exactly match the packaging machine you purchased.)

12.4 Transport and handling

The loading and unloading of the appliance from the means of transport must be carried out by suitable means, or by two people.

WARNING! The vacuum pump contains oil. Always keep the packaging and appliance in a horizontal position to prevent oil from leaking from the pump vent.

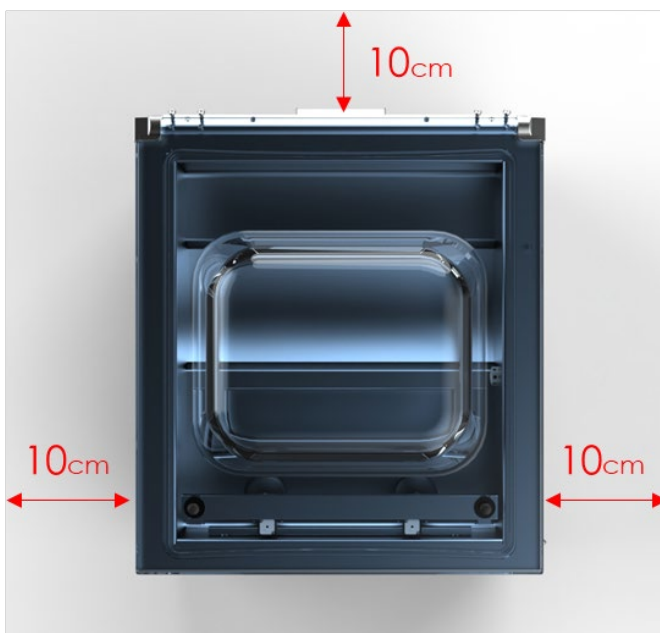


For the handling of the appliance, all necessary precautions must be taken not to damage it and not to cause damage to persons or property, respecting the instructions on the packaging.



12.5 Installation

- 1) **Check the environmental conditions: room temperature and air exchange.**
The temperature of the operating environment must be between +10°C and +35°C. The installation environment must ensure sufficient air exchange.
- 2) **Check that the electrical characteristics indicated in the plate data correspond to the existing system.**
- 3) **Place the machine on a horizontal and stable surface that is suitable for the load.**



WARNING! The appliance must be positioned so that access is possible from all sides. Do not clutter passages, escape or service routes with the machine. Do not place the appliance in front of emergency door exits.

Ensure the necessary ventilation to the machine, leaving at least 10cm of free space around the entire appliance. The ventilation slots must be kept free and unobstructed in order to maintain the pump temperature at normal levels.

4) Check the pump oil level.

- Check the correct level through the hole on the back side, as indicated.
- The ideal level corresponds to the centre line of the peephole.



WARNING! Avoid starting the machine in the most absolute way if there is no oil in the pump!

5) Connect the machine to the electrical connection.

Before installing the appliance, make sure that the existing electrical systems are in compliance with Low and adapted to the plate data of the equipment to be installed (V, kW, Hz and available power).



The equipment is supplied with a power cable with standard Schuko plug 16A or 3P + N + E 16A three-phase plug (in wheeled versions); the socket must be equipped with a 10A fuse and must be easily accessible.



In machines with three-phase power supply, if a loud abnormal noise of the pump is audible and the cover is not lowered, immediately stop the machine and reverse the phases.



ELECTRICAL HAZARD!



The reversal of the phases in three-phase machines must be carried out exclusively by qualified technical personnel. Make sure that the network to which the machine is to be connected is provided with a suitable and efficient earthing system. Check that the power cable is not damaged or stuck. If necessary, contact qualified technical personnel for replacement. Access to live parts of the machine is allowed only to qualified technical personnel. Insert and remove the plug by pulling the plug itself and not the wire.



WARNING!

Make sure that the plug is accessible even after the unit has been installed!

In the event that the plug of the appliance is not easily accessible, the power supply network must be equipped with devices for complete disconnection under the conditions of overvoltage category III. If the entire length of the cable is not used, DO NOT roll it on itself, but leave it free and make sure that it does not represent an obstacle and/or danger to the passage of people.

Make sure that the power cable does not come into contact with liquids of any kind, sharp or hot objects, or corrosive substances.

Do not allow children or animals to play with the power cable.

6) Connect the gas

Connect the machine to the gas cylinder using a special Ø10mm pipe suitable for contact with food (typically: Teflon), grafting it onto the quick coupler on the back side. Press the green ring of the connection and insert the pipe. Adjust the pressure of the reducer supplied with the cylinder between 0.5 and 1 bar.



WARNING!

Contact the food gas supply companies to request the gas mixture that best suits your needs. Also request the supply of the pressure reducer, possibly with a 0-4 bar scale. It is essential to scrupulously observe the gas supplier's instructions for the correct use of cylinders and pressure reducers.

Use a suitable connection pipe for the cylinder connection and the one on the machine. An external Ø 10mm pipe suitable for food contact (e.g. teflon) must be used.

Properly secure the pipe on the pressure regulator attachment side. Use only nitrogen (N₂), carbon dioxide (CO₂) or mixtures of nitrogen and carbon dioxide (N₂ and CO₂) or mixtures of other inert food gases.

Never use oxygen (O₂) or other explosive gases, flammable or mixtures of gases containing oxygen (O₂) or other explosive gases, flammable or not suitable for food packaging.

Securely anchor the gas cylinders so that they do not overturn.

7) Pre-clean the vacuum chamber and the cover.

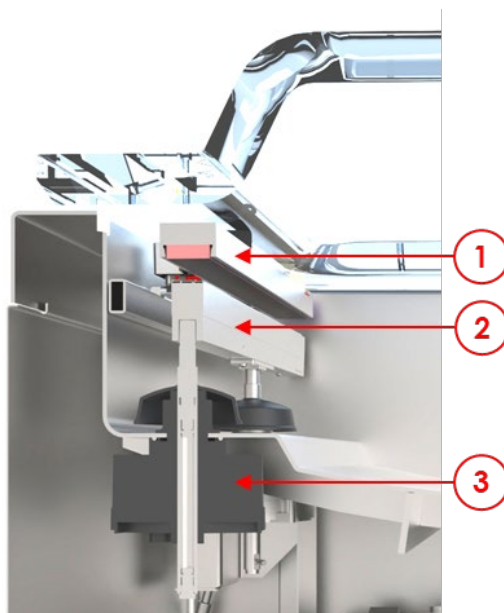
8) Check the absorption with an ammeter.

9) Carry out some complete vacuum packaging cycles for bags.

10) Inform the customer of the exact use of the appliance with specific reference to the customer's use and needs, as well as the warnings indicated in this manual on the need to package the product destroyed at 0-5°C, to carry out the dehumidification cycles of the "H2OUT" pump oil and to carry out regular routine maintenance (oil change and exhaust filter).

13 SEALING SYSTEM

The sealing system closes the bag openings to retain vacuum and/or gas in the bag. If the cutting function is present on the sealing bar, the end of the bag can be cut.



No.	Description
1	<u>SILICONE SUPPORT:</u> above the sealing bar there is a silicone, releasable bar support that provides back pressure on the cylinders during the sealing phase. For the replacement of silicone see point 16.6
2	<u>SEALING BAR:</u> the sealing bar consists of the following components: - Heating nickel-chrome (NiCr) sealing element: during the sealing process, the resistor heats up for a certain time, generating the hermetic sealing of the vacuum bag flaps; - Nickel-chromium (NiCr) cutting wire: as the cutting wire heats up, it acts to melt the bag flaps, allowing the excess part of the vacuum bag to be easily removed. Teflon Tape: The sealing and cutting NiCr are covered with Teflon tape to prevent the bag from sticking to the sealing bar. For the replacement of the sealing and cutting NiCr, being extraordinary maintenance, contact the technical service center.
3	<u>SEALING BAR LIFTING PISTONS:</u> the sealing bar is pressed onto the vacuum bag by lifting pistons. By connecting the inlet of the pistons with the atmospheric pressure outside, they press the sealing bar onto the bag.



WARNING! In order to obtain an aesthetic and functional result of the sealing or cutting on the packaged bag, IT IS IMPORTANT to adapt the sealing parameters proposed by default by the machine on the basis of the type of bag used and the operating mode adopted.

14 MAINTENANCE

WARNING!



Do not start Teflon replacement operations with the sealing bar still hot: burn danger! Always disconnect the plug from the outlet before any maintenance intervention.

DANGER!



It is strictly forbidden to remove the guards and safety devices to carry out maintenance operations. Orved S.p.A. declines all responsibility for accidents caused by non-compliance with the aforementioned obligation.

WARNING!



For any maintenance and/or repair operation, always use appropriate means of prevention and protective clothing (gloves, etc.)

The maintenance operations or access to live parts of the machine, referred to in this chapter, must only be carried out by qualified personnel.

Use and expect to use only original spare parts: non-original spare parts could damage the appliance or cause injury to people.

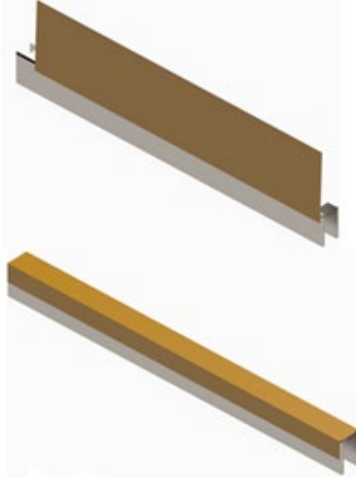
Always indicate the model and serial number of the packaging machine (see §17.3) at each service request.

14.1 Complete replacement of the sealing bar

PHASE	DESCRIPTION	IMAGE
1	Extract the sealing bar by pulling it upwards Thoroughly clean the contacts and the two pin holes on the sealing bar Insert the new bar, paying attention to the correct engagement of the same on the electrical contacts	

14.2 Replacement of the Teflon sealing bar cover (contact an authorised service centre).

PHASE	DESCRIPTION	IMAGE
1	Extract the sealing bar by pulling it upwards	
2	Remove the Teflon tape	

PHASE	DESCRIPTION	IMAGE
3	Thoroughly clean the sealing bar with alcohol	
4	Apply the new tape by cutting the excess at both ends	
5	Re-position the sealing bar in the tank, paying attention to the correct coupling of the same on the electrical contacts.	

14.3 Replacing the cover gasket (contact an authorised service centre).

No.	Description
1	Lift the cover
2	Remove the old gasket, pulling it from its seat
3	With the help of a neutral detergent, thoroughly clean the gasket seat
4	Starting from the center at the back of the cover seat (hinges side), extend the

No.	Description
	gasket along the entire path of the quarry, taking care to: a) make the two joint cuts precisely and clearly; b) check that the gasket lip is facing outwards; c) during positioning, do not tension the gasket;
5	Start a cycle with the vacuum adjusted to the maximum value. When this value is reached, turn off the machine by disconnecting the plug from the electrical wiring: the chamber will remain in vacuum and the cover lowered. In order to verify the correct execution of the work, wait 5 minutes, during which the cover must remain closed and adherent to the vacuum chamber.

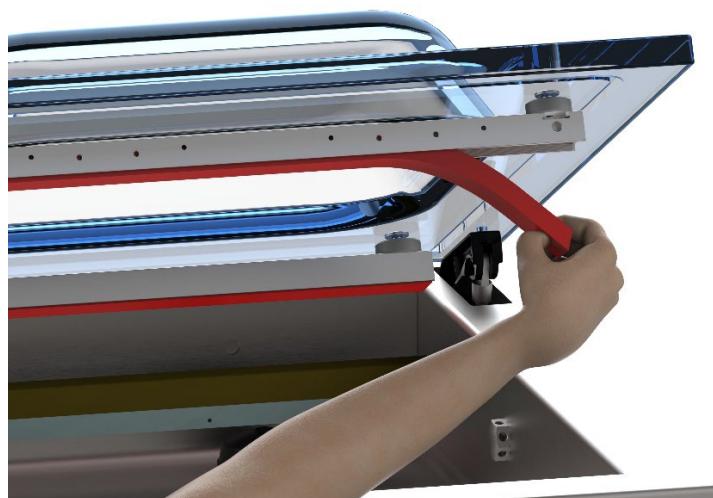


14.3.1 Figure 15: cover gasket replacement

(The model shown in the image may not exactly match the packaging machine you purchased.)

14.4 Replacement of the silicone rubber of the counterbalance bar

No.	Description
1	Raise the cover.
2	Remove the silicone rubber from the counterbalance bar
3	Thoroughly clean the quarry with an alcohol-soaked cloth
4	Place the new silicone rubber, taking care to press evenly. Do not tension the silicone during positioning



14.4.1 Figure 16: Silicone rubber replacement

(The model shown in the image may not exactly match the packaging machine you purchased.)

15 TECHNICAL DATA

* See nameplate data label

Features and technical data refer to the relevant product data sheets.

16 WARRANTY

It is standard for all **ORVED** products to be subjected to severe quality and functional tests before installation to protect and safeguard the Customers' interests.

ORVED

coverage guarantees its products for all construction and processing defects and undertakes to replace any parts found to be defective by the manufacturer free of charge to its Customers.

Duration

ORVED guarantees the products referred to in this manual for a period of 36 (thirty-six) months from the date of installation of the machine (the date shown on the installation form signed by the technician who performs the installation is authoritative). Failure to send the installation form to rdi@orved.it, reduces the warranty to the 12 months provided for by current legislation for appliances for professional use.

The warranty excludes components subject to normal wear and tear such as Teflon tape and sealing bar resistances, gaskets and gas pressure springs of the cover, deoiling filters, oil filters, pump oil.

GENERAL CONDITIONS

The Orved warranty provides for:

Invalidation of warranty

In addition to the natural expiry of the warranty period, the warranty shall be considered null and void in the following cases:

- A)** identification plate of the device tampered with, altered in any way or removed without Orved S.p.A. having been promptly notified;
- b)** making changes to the appliance or its parts without prior written authorisation from Orved S.p.A. Tampering with the appliance or its parts, as well as leading to the termination of the warranty, relieves ORVED S.p.A. from any damage reported to people, animals or property;
- c)** failure to comply with the instructions in this manual; in particular, the warranty does not cover damage to the pump (example: oxidation blocking) for non-compliant use of the machine, (typically: packaging of products not cooled to 0-5°C)
- d)** use of the appliance other than that provided for in this manual;
- e)** damage or claims suffered by the appliance deriving from external factors (example: overvoltages with consequent damage to the electrical and electronic wiring);
- f)** operation, repair and/or maintenance operations carried out by non-specialised personnel;

17 USEFUL NOTES

Purchase date: _____

Details of dealer:

Name: _____

Address: _____

Phone: _____

Fax: _____

Details of manufacturer: Orved S.p.A.

Tel.: +39 0421 54387 • E-mail: orved@orved.com • <http://www.orved.com>

Recommended Technical Support Centre:

Name: _____

Address: _____

Phone: _____

Fax: _____

18 SPARE PARTS

To get technical assistance and order spare parts, register for free at:

<http://www.orved.it/service/>