

Sealer Machine Error Guide

1. Our sealer machines are equipped with a PC Board that will alert you if there are any problems with your machine.
2. If you have an error code, first check your manual to see what might be causing the error.
3. We will work with you to diagnose the problem and get your machine working again.
4. Please follow the cleaning and maintenance instructions that should be performed once every two weeks.
5. If you have followed the instructions and are still having problems, please take a short video of your problem and send it to:
info@bubbleteaology.com

*****Always Turn Off and Unplug Your Machine Before Working On It*****

Contents:

How to Set Up Your Sealer Machine

How to Install Sealer Film

Sealer Machine Error Codes

Set Sealer Film Temperature

Change P5 Settings (sealing time)

Broken Sealer Film

Error 02 – Upper Mold Error

Error 04 – Sealer Film Error

Error 07 – Safety Button/Door Error

Error 03/05 – Lower Mold Error

Maintenance and Cleaning Instructions (see Error 03/05)

Please watch this video on how to set up your sealer machine properly; many errors can be avoided by proper set up.

[How to Set Up Your Sealer Machine Video](#)



How to Install Sealer Film

The Sealer Film should always turn to the left (counter-clockwise) on both rollers.

Otherwise you will get a E04 or E05 Error.

www.bubbleteaology.com

How to Install Sealer Film Video



**** make sure your film is going to the left (counter clockwise) or you will get the E04 Error****

Sealer Machine Error Codes

ERROR CODE	ERRON CONTENT	POSSIBLE CAUSE	SOLUTION
E00	Temperature control system error.	①Temperature wire error. ②P.C.B error	①Correct the wire. ②Chang P.C.B
E01	Heating circuit error.	①Heater error ②Heating wire error	①Change new heater. ②Change new heating wire.
E02	Upper motor advanced or micro switch error	①The upper micro switch didn't touch the touch plate. ②The upper micro switch didn't work.	①Move down the upper micro switch to touch the touch plate. ②Check the connecting wire of the upper micro switch.
E03	Lower motor draw back or micro switch error.	①Lower motor can not out put ② Lower mould can not move smoothly	①Check the micro switch. ②Clean both the sliders and bearings of the lower motor system.
E04	Sealing film is used up, or limited sensor error.	①Sealing film dressing error. ②Check the film sensor	①Correct the film system ②Clean, adjusting the sensor window, change new sensor.
E05	Lower motor advanced or micro switch error.	①The micro switch error	①Modify the micro switch or change.
E06	Upper motor down back or micro switch error.	①The lower micro switch didn't touch the touch plate. ②The lower micro switch didn't work.	①Move up the lower micro switch to touch the touch plate. ②Check the connecting wire of the lower micro switch. ③Check the lower micro switch.
E07	Safe door is touched or collided.	①Safety door error	①Adjust the switch of Safety door.
E19	P.C board error.	①P.C.BOARD error	①Change new P.C.BOARD

Set Sealer Machine Temperature

It's important to use the correct temperature for your sealer film. If your temperature is too hot, it could cause your film to break every time you seal.

To lower the temperature, press the **settings** button on the right (it should say P1).

Now you can use the arrows to set the correct temperature.

《12》 RELATIONSHIP AMONG MACHINE, FILM, AND CONTAINER

	ES Film	PP Film	PE Film	PS Film	Pool
PP containers	○ 145-165°C	○ 160-180°C	×	×	○ 160-170°C
Styrofoam containers	○ 125-150°C	×	×	△ 135-150°C	×
Paper containers	○ 130-150°C	×	○ 140-150°C	×	○ 140-160°C
PS containers	△ 150-165°C	×	×	○ 150-165°C	×
PET containers	△ 120-140°C	×	×	×	×

Change P5 Settings (Sealing Time)

You can change the temperature and film rolling time by adjusting the P Settings.

1. Press the **settings** button, then the right display will show P1, please press again until it is P5.
2. See the left display, it will show 000 which is the default (means controlled by the sensor).
3. Press up and down to add or reduce the value. (For example, if the value is 010, the roll will rotate for 1 second, and then the machine starts to seal)
4. Last, press **settings** again to save the parameters.

III. Function of setting

1. System parameter table:

Symbol	Function Setting	Range	Parameter Setting (Set in factory)
P1	Set Temperature	PP (160~180°C) ES (140~160°C)	160°C
P2	Counter	LOK: LOCK / OPN: UNLOCK	N (can be reset)
P3	Sealing time	001~030 unit (0.1sec~3sec)	010 unit (1sec)
P4	Cup settled time	000~030 unit (0.0sec~3sec)	010 unit (1sec)
P5	Film rolling time	000~060 unit (0.1sec~6sec)	000(controlled by sensor)

How to Fix Broken Sealer Film:

1) Make sure you're using the correct temperature for you cups/film:



	PET/ES FILM	PP Film	PE Film
PP containers	○ 145-165°C	○ 160-180°C	✗
Styrofoam containers	○ 125-150°C	✗	✗
Paper containers	○ 130-150°C	✗	○ 140-150°C
PS containers	△ 150-165°C	✗	✗
PET containers	△ 120-140°C	✗	✗

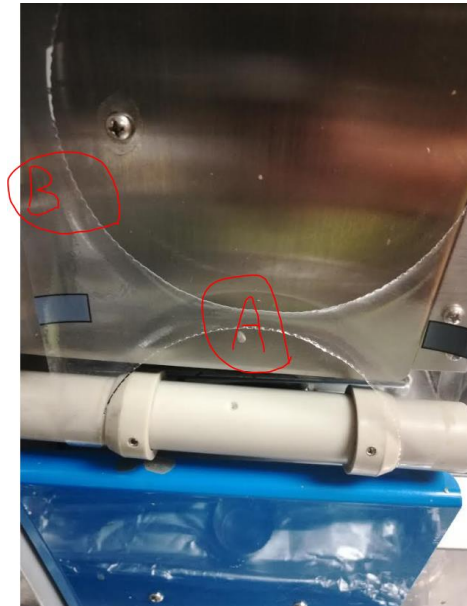
2) The clamp, spring and spacer are too tight. Please loosen then to see if this solves the problem:



3) The sealer machine cutter is dirty, you can follow the instructions in this video to clean the cutter:

<https://youtu.be/SP9cX-PcTjw>

4) Let us know where your film is breaking, is it on the side or the middle of the film?



If the problem persists, please take a **short video from the left side of the machine** and send it to service@bubbleteaology.com

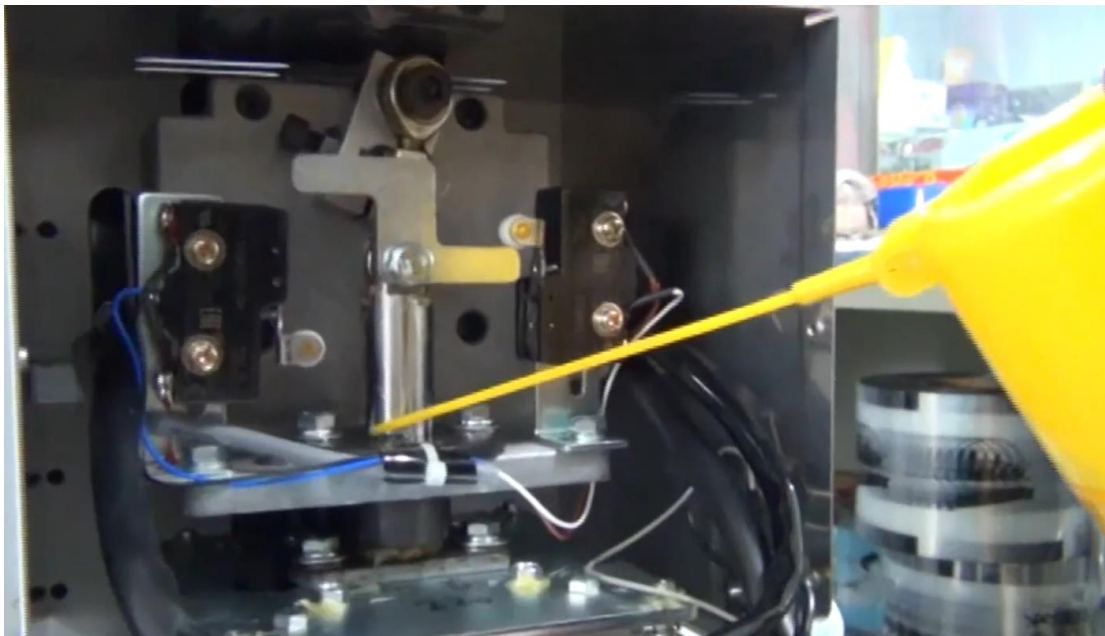
Error 02

For the E02 Error, first try and lubricate the upper mold:

Please make sure you turn off the machine and unplug it first

- 1) Power off and unplug the machine
- 2) Unscrew the front panel
- 3) Use grease to lubricate the upper mold

*1 packet of grease should be included with the machine or WD-40 will work.



[Video - Lubricate Upper Mold Error E02](#)

E04 Error – Sealer Film Eye-Mark Sensor Error

1) Please make sure that your sealer film is going in the correct direction. It should be turning left or counter-clockwise.

* The machine below has the film installed wrong and has the E04 error:



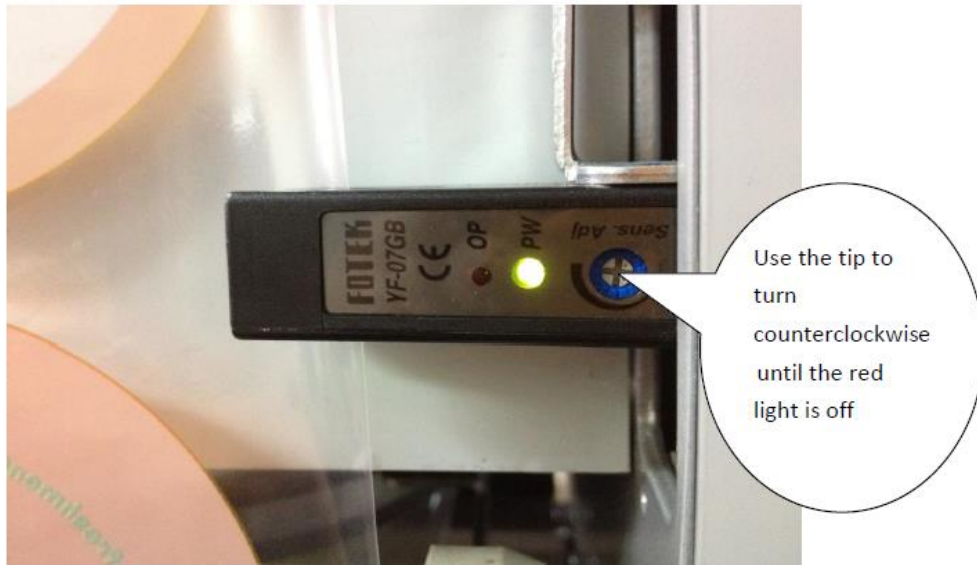
2) Please check the sensor and make sure the red light is off, this means it will detect the black “eye-mark”.



*If the red light is on, that means the sensor is too strong. You can use the tool below to adjust the sensor.

Adjustment Tool:





3) During normal use, only the red light changes. It will be off when it finds the black “eye-mark” and the red light will be on when no marks are present. This lets the machine know when to roll the film and when to stop it.



The E07 Error

The E07 Error has a simple solution, It is caused by the safety switch on the right side of the machine getting turned on and all you need to do is to turn or press in the red button on the bottom right of the machine.

Watch the video here - <https://www.youtube.com/watch?v=5aAWN9DZTfc>



Fix E07 Error

**2) The
Emergency
Door Might
be Jammed**

**1) Turn the Red
Emergency Button**

E03/E05 Error – Lower Mold Lubrication

The E03 Error is caused when the lower mold is not moving properly, most of the time this can be fixed by cleaning and lubricating the moving parts of the lower mold.

First, try cleaning and lubricating your sealer machine:

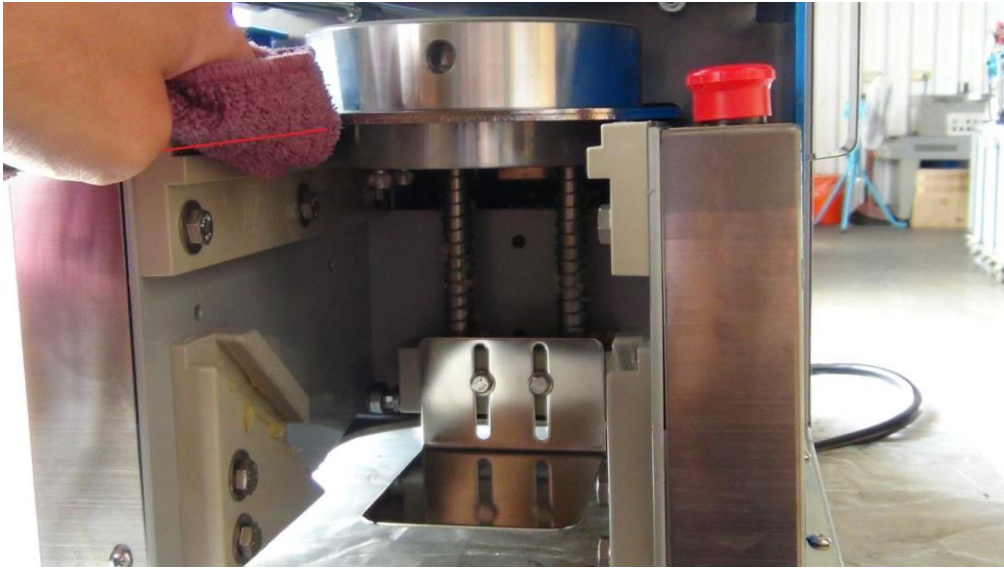
How to Keep Your Machine Clean and Lubricated

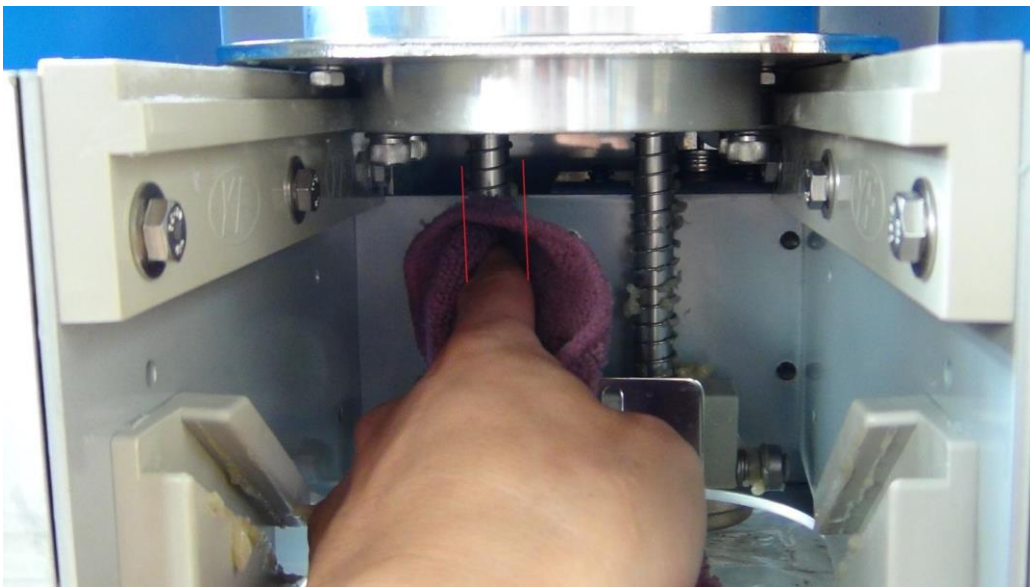
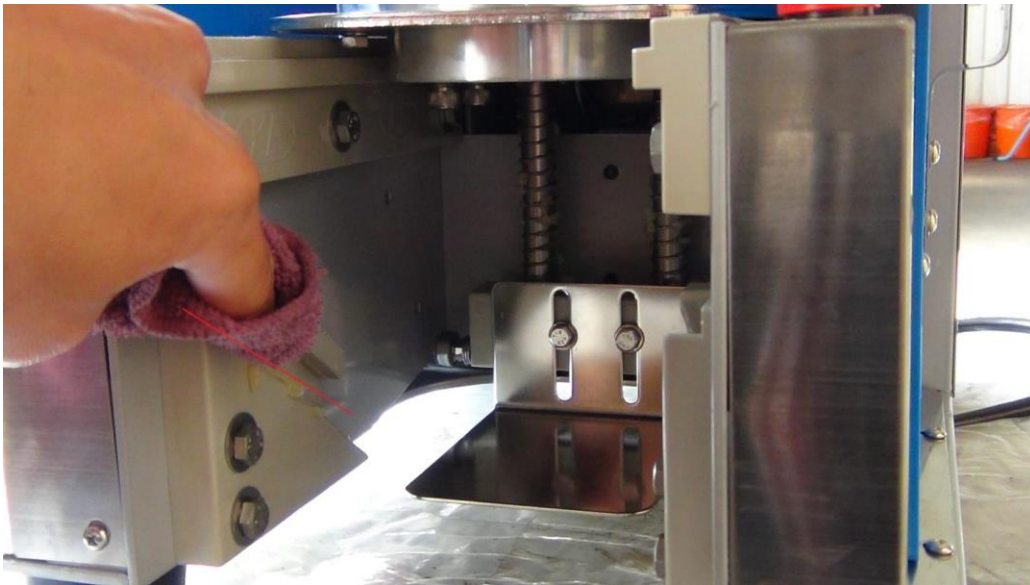
****This should be done once a month**

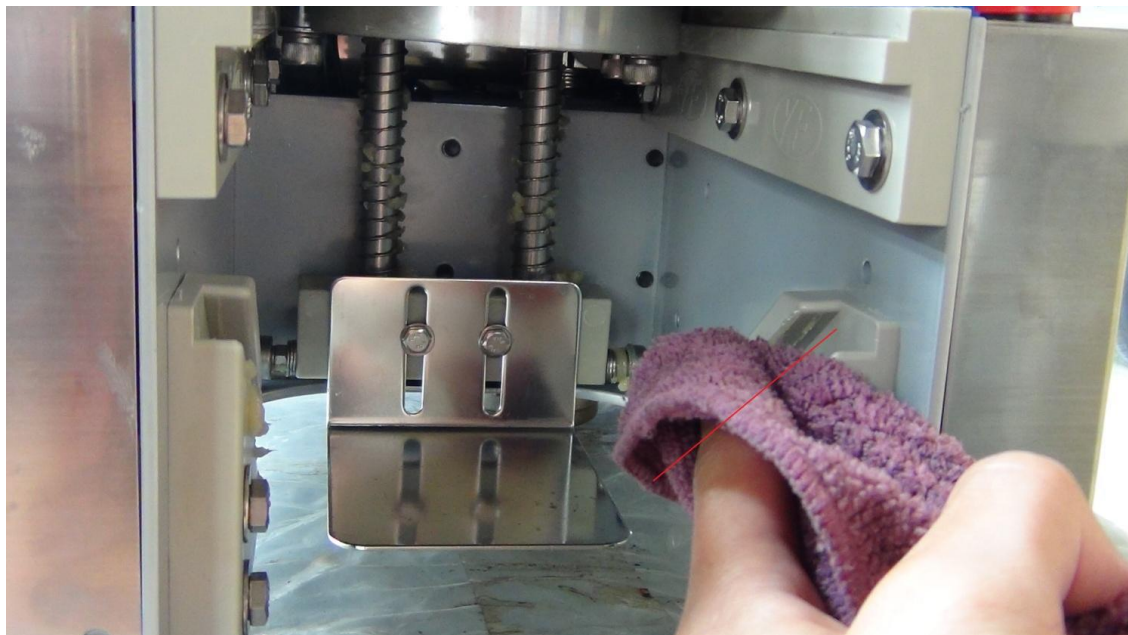
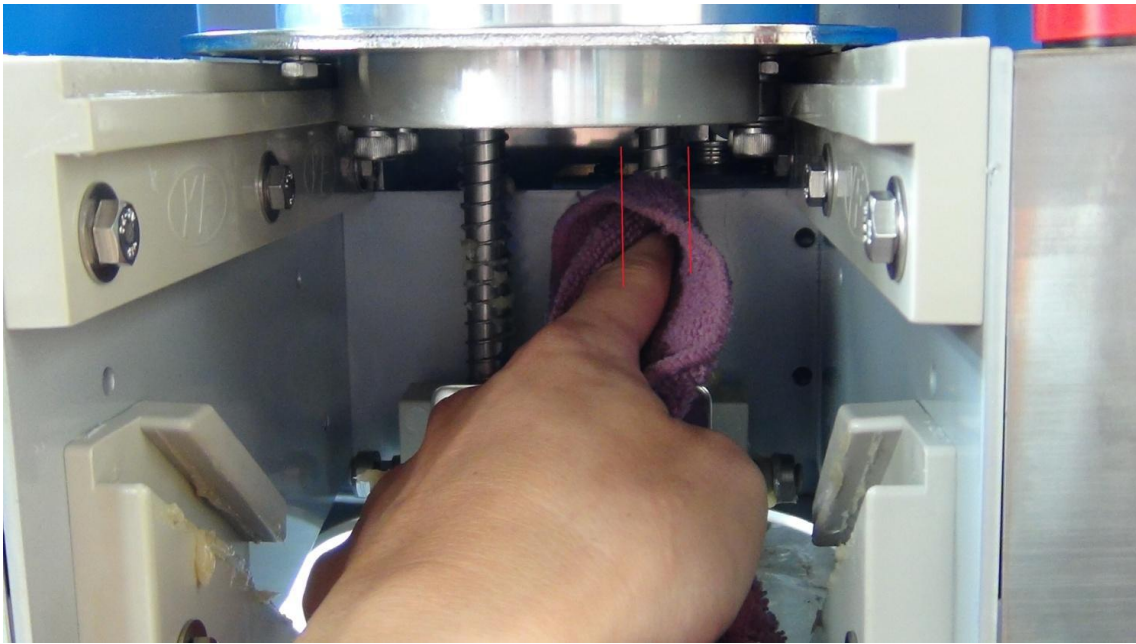
1. Power off and unplug your sealer machine.
2. You will need a clean rag, a rod and oil which were included with the owner's manual.



3. Soak the rag with warm water to help clean up the old oil and spilled drinks.
4. Follow the pictures below for proper cleaning and lubricating.

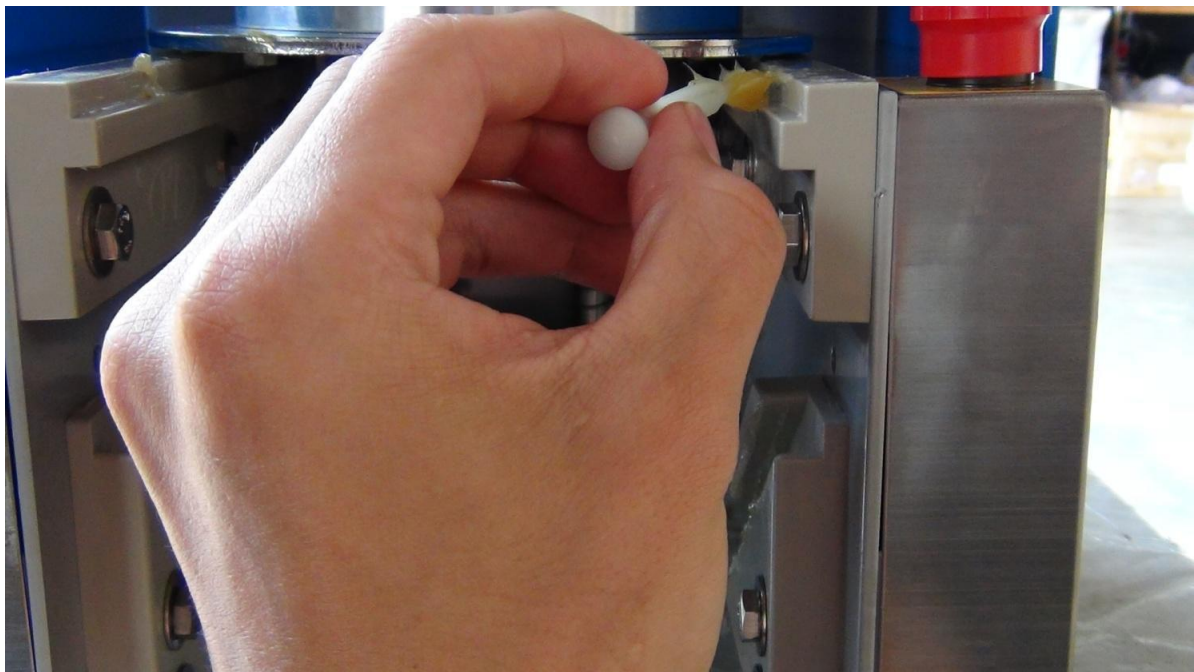
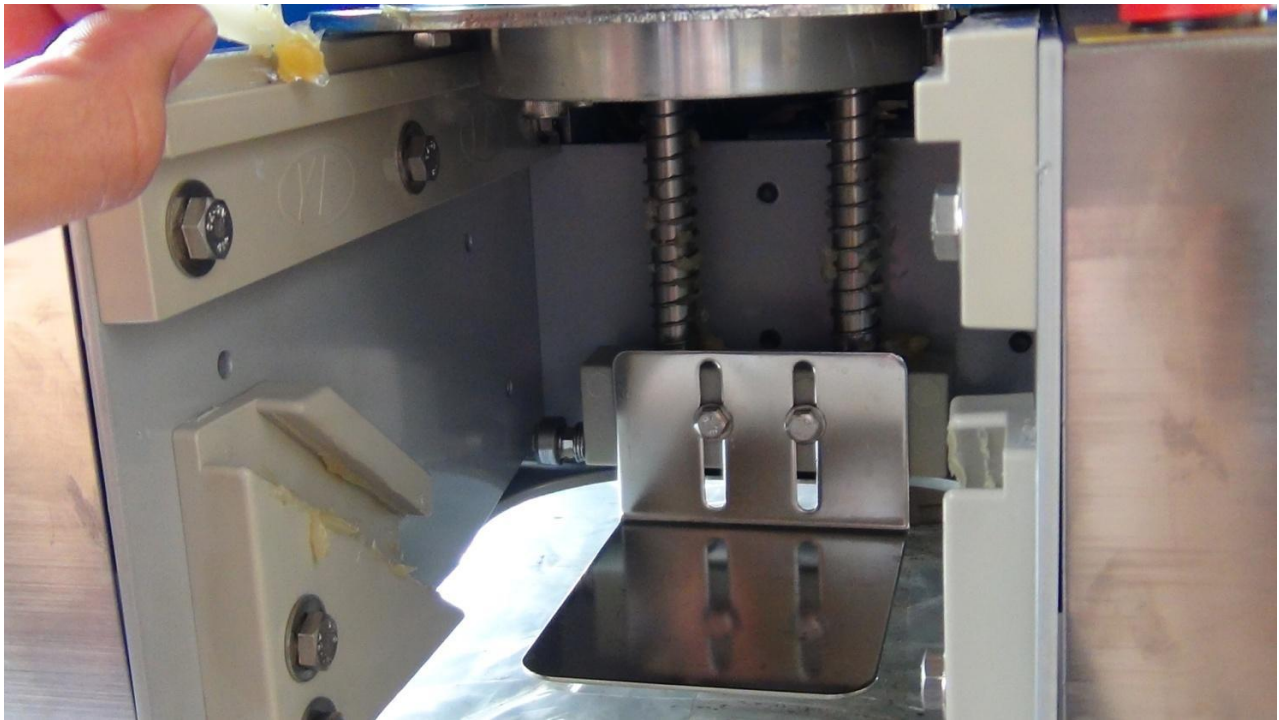


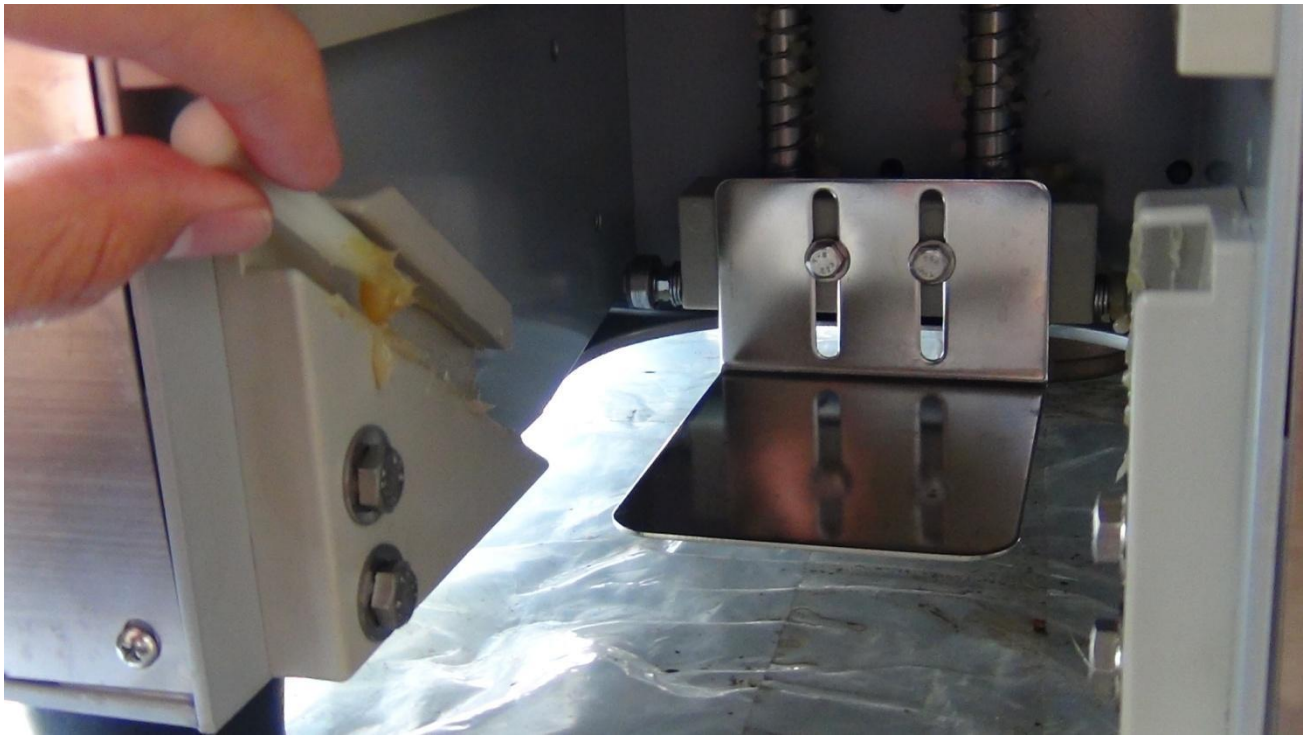


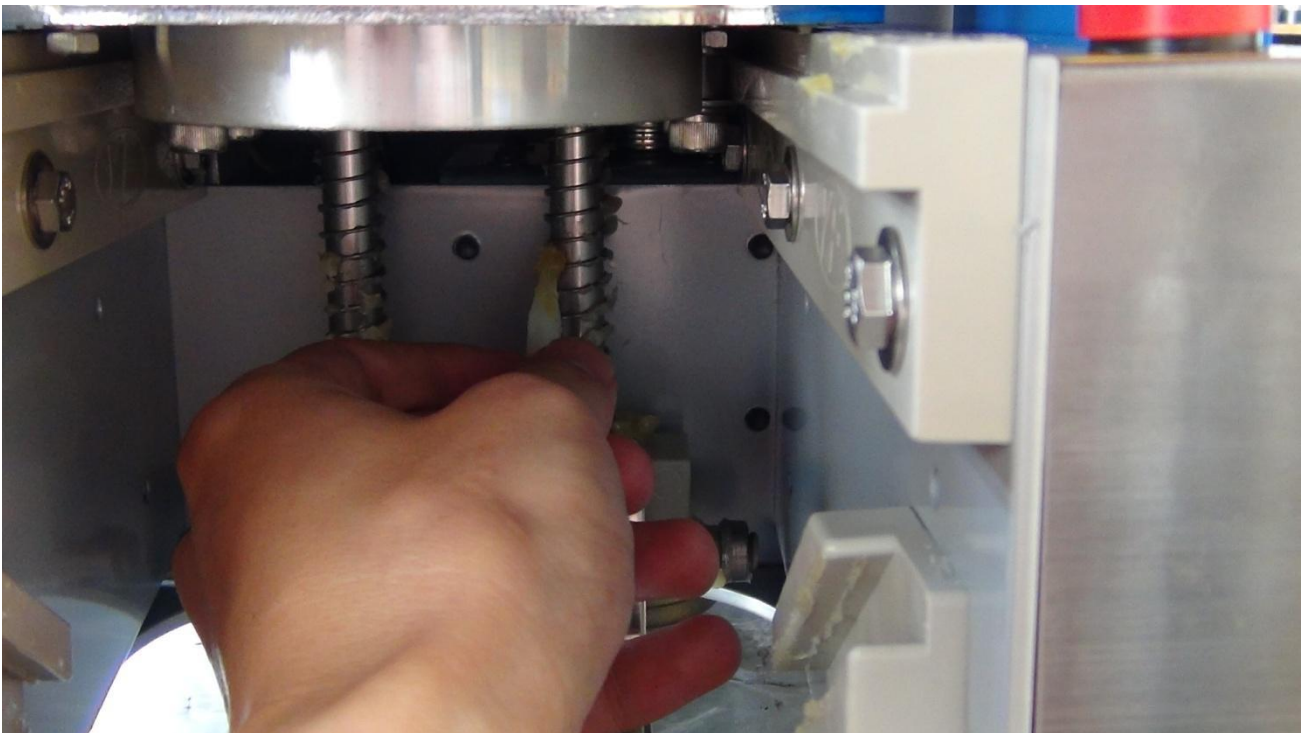
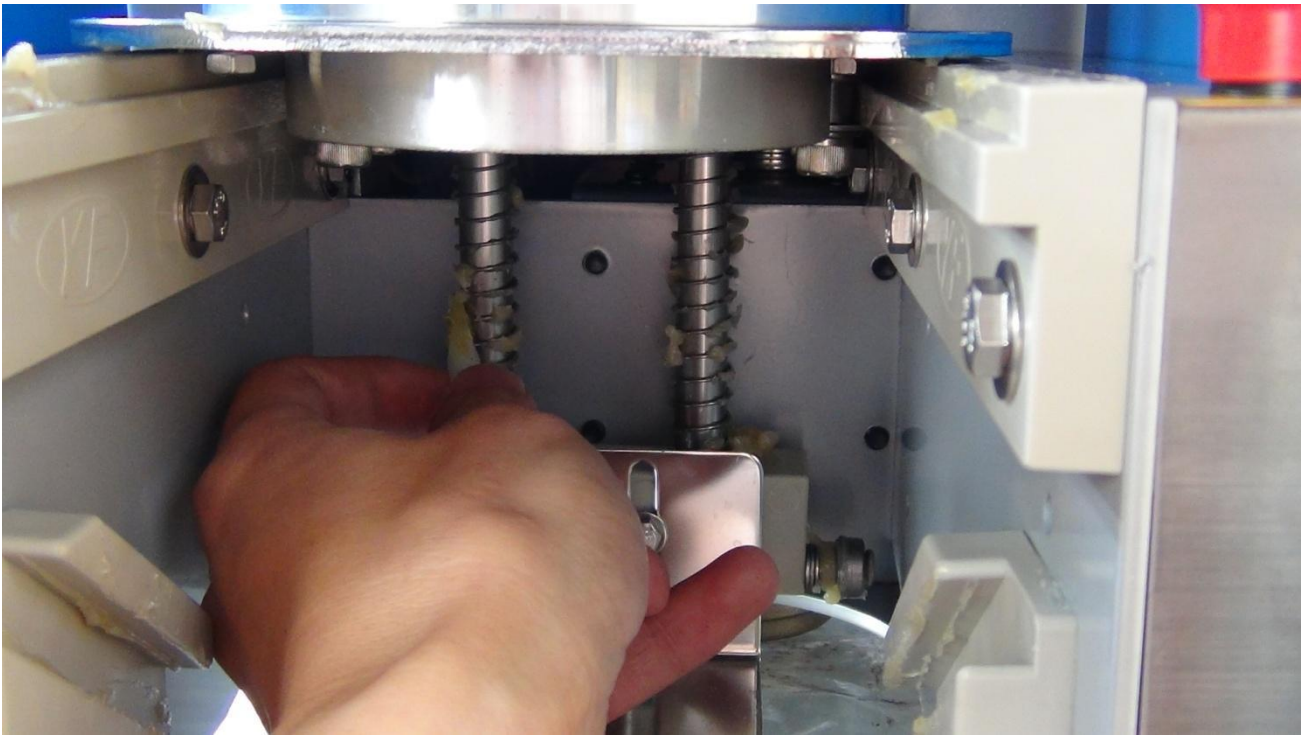


*****After cleaning, use paper towels to wipe up any remaining water*****

Now, use the rod and new oil to lubricate the parts you just cleaned:







If you have followed the instructions and are still having problems, please take a short video of your problem and send it to:

info@bubbleteaology.com