

IMPULSE SEALER INSTRUCTIONS

(For Portable Operation of AIE 305 A1 Sealer)

Please read entire sheet before starting.

Set up

1. Remove sealer from case. Set case lid in supported, sloped position. Install shelf on front of case/stand. Place sealer on stand. If a stand is not provided, place sealer on a sturdy box, with lower sealer jaw 8 1/2" above table. Connect switch line to sealer back and place switch on floor.
2. Set dials: **Recycle** to 2, **Congeaing** to 6, **Sealing** to 4, and **Action Selector** switch to Manual.
3. Turn **Power** switch on. (Do not allow small children in area when sealer is on.)
4. Cut open top of bag containing oxygen absorbers. Remove only enough packets for the next 30 minutes. Reseal bag with impulse sealer. Reopen and reseal bag, as additional absorbers are needed.

Filling pouches

5. Fill pouch with one **level** gallon of product. Overfilling will result in poor seams.
6. Place an oxygen absorber packet on top of product in pouch.
7. Wipe product dust from inside seal area using a dry towel. (Powdered products)

Sealing pouches

8. Place pouch, in an upright position, in front of sealer.
9. Close pouch opening by grasping side seams and pulling outward. **Bend top** 1 1/2" of pouch over at a right angle to evacuate air out of headspace, settle product, and flatten top.
10. Hold pouch by side seams and insert pouch top into jaw opening (**keep fingers clear of jaw**).
11. Position pouch to seal near top. Stretch outward on side seams to **remove wrinkles** and press foot switch. Remove pouch when cycle is completed.

Testing seals

12. Visually inspect seams for complete seals and absence of burned spots.
13. Check to see if seam can be pulled apart. Push on pouch to see if air or product can be forced out.
14. If seams pull apart, check for inadequate cleaning of seam area or overfill. If necessary, increase sealing setting by 1/4 step. (Example: From 4 to 4.25) Verify that congealing setting is at 6.
15. If seams are burned, decrease sealing setting 1/4 step.

Notes

16. The sealer comes from the factory with two bolts protruding from the front of machine. These bolts are for holding the shelf provided in the box. Remove bolts and do not use the shelf unless the shelf is used as part of a separate stand.
17. A 2-quart pitcher, with the top rim cut off at the 2 qt. line, is a good measure to use in filling pouches. Fill with 2 level measures. For ease of filling, pull empty pouch over top of first filled pitcher, then upend pitcher. Pour in second pitcher.
3. If Teflon cover on lower jaw is burned: unplug sealer, loosen and lift up cover, carefully clean off any burrs that may be on heat strip, advance cover 1/2 inch, trim excess, and retighten.
4. If sealer fails to operate, check the two fuses mounted in lower back of case. Replace with correct fuse size.