HANNAN®
PRODUCTS CORPORATION

OPERATION MANUAL
Automatic Table Top Blister/Tray Sealer B9X12

Fast
Powerful
Affordable

Standard Features:
- Balanced Heating Platen
- Self Aligning Pressure System
- Powder Coated Industrial Finish
- Fully Enclosed Sealing Chamber
- Low Cost Tooling
- 2400 Lbs. Sealing Force
- All Steel Construction
- Adjustable Pressure Regulator
- Electronic Timing System
- Stainless Steel Sealing Face
- Pressure Gauge
- Fully Adjustable Thermostat
- Industrial Quality
- Low Power Consumption
- Fast Cycle Times
The PRO PACK® B9X12 has been engineered for reliability, high productivity and efficient use of space and energy. This industrial quality machine has everything needed to produce high quality packages at the fastest possible rate. The PRO PACK® B9X12 is ideally suited for long or short run production. The balanced heat platen, automatic operation and self-aligning pressure systems assure the proper sealing of materials every time. Hannan equipment is designed to withstand rugged continuous production use with a minimum of maintenance and operator skill. From the all steel construction to the heavy-duty industrial finish, the PRO PACK® B9X12 is “The Professional’s Choice”.

Examples Of Outstanding Standard Features Include
1. Fully enclosed sealing chamber (Safe Operation).
2. Instant fixture change over (True Drop-In Tooling).

Packaging Made Easy / Packaging Made in America

**SPECIFICATIONS:**

<table>
<thead>
<tr>
<th>Specification</th>
<th>Details</th>
</tr>
</thead>
<tbody>
<tr>
<td>Sealing Area</td>
<td>9” x 12”</td>
</tr>
<tr>
<td>Maximum Card Size</td>
<td>10 ½” x 13 ½”</td>
</tr>
<tr>
<td>Maximum Blister/Tray Depth</td>
<td>1 ½”</td>
</tr>
<tr>
<td>Available Sealing Force</td>
<td>2400 Lbs.@100 PSI</td>
</tr>
<tr>
<td>Temperature Control</td>
<td>Ambient To 570°F</td>
</tr>
<tr>
<td>Electrical</td>
<td>110 VAC/12 A/1 PH/60 HZ</td>
</tr>
<tr>
<td>Minimum Air Requirement</td>
<td>40 PSI</td>
</tr>
<tr>
<td>Shipping Weight</td>
<td>140 LBS.</td>
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</tbody>
</table>

**OPERATING SEQUENCE:**

1. Load blister, package contents and card (Face Down) into sealing fixture.
2. Slide fixture shuttle completely into sealing chamber.
3. Automatic heat and pressure cycle seals blister to card.
4. Slide fixture shuttle out of the sealing chamber.
5. Remove finished package and reload for next cycle.
For Best Results Use Genuine PRO PACK®
Sealing Fixtures - Blisters - Blister Cards
We manufacture blister cards, blisters and sealing fixtures designed to give you professional results at an affordable price

Standard or Custom
Low Cost - Fast Delivery - High Quality
Sealing Fixtures - Blisters - Blister Cards

For additional information, check out our web site
www.propackinfo.com          (800) 954-4266

Made In The USA Since 1966

Hannan Products Corp. 220 N. Smith Avenue, Corona, 92880 (951) 735-1587

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SEALING FIXTURES

Sealing fixtures must comply with the drawings and specifications included in this manual.

Properly made fixtures are very important to proper machine operation.

For best results ask your Hannan representative about genuine Hannan sealing fixtures.

sales@HANNANPAK.com   (951) 735-1587 / (800) 954-4266

INSTALLING SEALING FIXTURES

Place sealing fixture into the fixture shuttle with the sealing flanges facing up.

The Fixture does NOT need to be secured in any way.

SETTING CONTROLS AND OPERATION

**WARNING - DO NOT OPERATE WITHOUT FIXTURE**

Power Switch – On

Temperature – Preset to 300°F

Timer – Preset to - 2 ½

Pressure – Preset to 50 PSI (Pull knob out to adjust – Push into lock)

SEALING CYCLE

A. Load Blister(s) into fixture.
B. Place package contents into blister(s)
C. Put blister cards into fixture (face down)
D. Push shuttle completely into sealing chamber.
E. When sealing cycle is complete (sound of exhausted air)
   pull the shuttle out and remove the finished package(s)
F. Repeat from step (A)

Temperature, time and pressure settings may need minor adjustments to meet your sealing requirements. (See Sealing Tips)
CHECK LIST

1. Has machine had sufficient time to preheat (Approximately 15 minutes.)

2. Cold environments may necessitate preheating the sealing fixture. This is accomplished by cycling the machine several times without cards or blisters until the sealing fixture flanges are warm.

3. Is card warm when removed from machine? If not, increase heat by adjusting the temperature control clockwise. (Allow several minutes for increased heat settings to take effect.)

4. If card is warm when removed from fixture, increase the sealing time by adjusting the time control clockwise.

5. If increased sealing time and/or heat settings do not result in proper sealing, increase sealing pressure.

6. If blister seals to card but is warped excessively, it is usually caused by excessive heat sealing time and/or sealing pressure.

7. When decreasing heat settings, allow sufficient time for the platen to cool down to new setting before testing.

Although difficulties may be caused by any one of these functions it is not unusual to find a combination of factors to be the cause.
B9X12

EXAMPLE FOR STD. 2" X 3" RECTANGULAR BLISTER
AND
NOMINAL 9" X 6" CARD

MATERIALS:

.125 RESILIENT SEALING HI TEMP MATERIAL
.625 MDF
.625 MDF
.250 MDF
.187 DIA HEAVY DUTY REGISTRATION PINS

HANNAN PRODUCTS P/N 6507
MODEL 39X12
CONTROL CIRCUIT
110V 1 PH.

15 AMP CB

250 K.

Q1S552C

TIMER MODULE

POWER OFF ON

MICRO

OFF ON

THERMOSTAT

HEATER PLATEN
<table>
<thead>
<tr>
<th>P/N</th>
<th>Description</th>
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<tbody>
<tr>
<td>3130</td>
<td>TEMP CONTROLLER – SELCO</td>
</tr>
<tr>
<td>3022</td>
<td>SWITCH (SNAP ACTION)</td>
</tr>
<tr>
<td>3027</td>
<td>SWITCH (TOGGLE) W/NUTS</td>
</tr>
<tr>
<td>3059</td>
<td>HEATING ELEMENT (110V) 4 REQ</td>
</tr>
<tr>
<td>3015</td>
<td>LIGHT (PANEL MOUNT)</td>
</tr>
<tr>
<td>3013</td>
<td>POTENTIOMETER (250 K)</td>
</tr>
<tr>
<td>3118</td>
<td>POWER CORD 8’ (16/3)</td>
</tr>
<tr>
<td>3132</td>
<td>TIMER MODULE – QIS526</td>
</tr>
<tr>
<td>4030</td>
<td>ACTUATOR-AIR (MED)</td>
</tr>
<tr>
<td>4039</td>
<td>REGULATOR-AIR</td>
</tr>
<tr>
<td>2441</td>
<td>RETURN SPRING</td>
</tr>
<tr>
<td>6507</td>
<td>REGISTRATION PIN .375 DIA.</td>
</tr>
<tr>
<td>7014</td>
<td>PRESSURE STABILIZER</td>
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NOTES