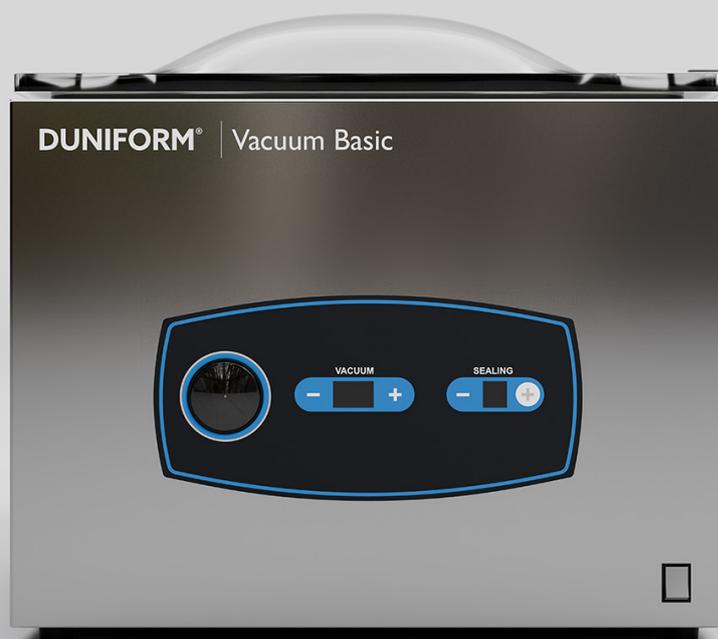


DUNIFORM®

VACUUM BASIC / INDUSTRIAL

Use and Maintenance Manual



CE

This appliance is intended for commercial use and by qualified operators only. Keep children and bystanders away while the appliance is operating. This appliance is designed to be used in commercial areas. This appliance is not intended to be used by persons with reduced physical, sensory or mental capabilities, or lack of experience or knowledge. Children must not play with the appliance. Cleaning and user maintenance must not be carried out by children without supervision.

The machine is to be used in inner environments only and only for the purposes specified in this manual. Install and use the machine only as outlined in the present instructions.

Check the state of the power cord and power button 0-1; a damaged cord or button represents a serious electrical hazard. Should the power wire be damaged, or in case of electric repairs, they must be replaced by the Manufacturer or by its service provider or by a person with similar skill to avoid any risks.



The sealing bar may reach high temperatures during and after the usage process.

It is recommended to watch out and avoid direct contact until the sealing bar has cooled down.



Before cleaning or maintenance, carefully consider the residual risks, disconnect the machine from the power supply and

always operate when the machine is cold.



The machine is supplied with ground protection wire.

The ground protection system is identified by the proper symbol.

1. IDENTIFICATION OF THE “USER MANUAL”

The user manual is a document issued by the manufacturing company and is an integral part of the machine. This document is adequately identified for easy tracing and/or subsequent references.

All rights relating to the reproduction and disclosure of the information contained in this handbook and the documentation quoted and/or attached are reserved.

Aim of the document

This manual contains the information necessary to the customer and assigned personnel for the correct installation, use and maintenance of the machine at good conditions and at maximum safety.

Safety precautions and manufacturer’s Responsibility limits.

Every operator-machine interaction relating to the intended use of the machine and its overall life cycle has been carefully and thoroughly analysed by the manufacturing company during the design phase, construction phase and the drafting of the instructions handbook.

It is nevertheless understood that experience, adequate training and “common sense” of the personnel operating on the machine are of primary importance. These requirements are therefore considered indispensable during all machine operating phases and consultation of this manual.

The non-observance of the safety precautions or specific warnings indicated in this manual, the use of the machine by unauthorized personnel, violate all safety standards regarding the design, construction, and intended use of the machine and relieve the manufacturer from every liability in the case of damage to persons or property. The manufacturing company is therefore in no way responsible for the non-observance on the part of the user of the safety precautions listed in this manual.

Waste of the machine after its usage cycle

Electric and electronic appliances contain dangerous substances with effects potentially harmful for health people and environment. The crossed-out wheellie bin symbol on the appliance or its packaging indicates that within the European Union, the product, at the end of its useful life, must be collected separately from ordinary waste.



2. HOW TO CONSULT AND USE THE USER MANUAL

This document is an integral part of the machine. Preserve a copy of this user manual for the entire working life of the machine even if transferred or sold to third parties. Requests for further copies of this document must be made by means of purchase order addressed to the manufacturing company.

To maintain the user manual in good conditions:

- Use the user manual taking care not to damage its contents. In particular, do not leave the user manual around during use and remember to return it to its proper place immediately after consultation.
- Do not remove, rip out or rewrite parts of the user manual. Any changes required must be referred to and subsequently supplied by the manufacturing company.
- Keep the user manual in a safe place, away from damp, heat and other environmental elements which could damage it.

Definitions

The following definitions are used according to the “Machine Directive” CEE 89/392 and subsequent issues:

- **Operator:** person or people assigned to machine operation, adjustment, routine maintenance or cleaning
- **User:** body or person responsible for and/or owner of the machine.

Machine manufacturer identification data and positioning of the “CE MARKING” plate.

Identification of the manufacturing company as producer of the machine takes place in accordance with the legislation in force by means of the following documents:

- Declaration of conformity;
- CE marking;
- User manual

A special plate applied to the machine is marked permanently with the following data concerning **CE MARKING**.



Do not remove the CE MARKING plate and/or replace it with a different one. Should the CE MARKING plate be accidentally damaged, detached from the machine or the manufacturer’s seal removed, the customer must compulsorily and

immediately inform the manufacturing company.

The plate is placed on the external side of the machine

MANUFACTURER	
MODEL	/
000 - X000	SERIAL
IP	
POWER AND SUPPLY VOLTAGE	
XXX	
XXX	
PRODUCTION YEAR	
REFER TO INSTRUCTIONS	
[]	
QUALITY MARKS, HAZARDS AND WASTE DISPOSAL CE MARKING	

3. WARRANTY

The manufacturing company engages, for 12 (twelve) months from the date of shipment and direct delivery of the goods, to assure the customer or concessionaire the integrity and the good working of the components regarding the above mentioned machine.

All machine components normally subject to wear, that is to say components in which use causes a constant wear and tear, are not included in the warranty:

1. Electrical resistances – Teflon – Rubber gaskets – Chamber opening pistons – Sealing diaphragms – Air filters – Oil filters – Oil change – Pump blades
2. If the vacuum pump of a machine under warranty is sent to the manufacturing company because of aspiration problems and malfunction, the manufacturing company has the right to check

whether any foreign bodies have been aspirated (liquids, solids, sauces, etc.). If this should be the case, the repair (materials and the labour) will be duly charged, since the problem is not due to manufacturing defects, but to customer negligence during use.

3. Possible problems linked to the electronic panel cards of the circuit will have to be examined by the manufacturing company before sending the part which has to be replaced under warranty. A sudden change in voltage, an electrical overfeeding, a disturbance in the external current network, could cause damages which are not to be attributed to the manufacturing company.

4. Possible problems with pneumatic, structural, mechanical parts will be duly solved as per warranty terms without any charge.

5. During the warranty period, for interventions under warranty, the replaced materials will not be charged, while the labour will be duly charged. During the warranty period, for interventions not included in the warranty for various reasons, both the materials replaced and the labour will be duly charged.

6. During the warranty period, should any external intervention of our technicians be requested, the travel costs (to and from) will be fully charged independently of the reason behind the intervention.

7. Any interventions on the machines are to be carried out at the manufacturer's premises both during the warranty period and after the warranty period; we point out that no transport costs (to and/or from) will be refunded.

8. The transport for any materials sent to the manufacturing company, both during the warranty period and after the warranty period, must compulsorily take place in ex works.

9. Any materials sent to the manufacturing company with transport charges will be automatically refused.

10. Any components considered defective (pump, electronic panel card, etc.) and mishandled by the customer during the warranty period will not be considered under warranty. The manufacturing company has the task of carrying out this function in a strict manner.

User obligations

The user must inform the manufacturing company immediately of any safety system defect and/or malfunction and of any presumed danger encountered. It is strictly forbidden to the user and/or third parties (excluding duly authorized personnel of the manufacturing company) to make modifications of any kind or extent to the machine and its functions or to this technical publication. In case of malfunctions or danger due to the non-observance of the above, the manufacturing company cannot be held responsible for the consequences. It is advisable to request any modifications directly to the Manufacturing Company.

4. GENERAL SAFETY PRECAUTIONS

It is recommended to comply strictly with the following safety precautions:

1. never touch the metal parts of the machine with wet or damp hands;
2. do not pull the power cable or the machine itself to disconnect the plug from the current outlet (ref. page 1);
3. children or unqualified personnel are not allowed to use the machine without supervision;
4. electrical safety of the machine is ensured by its correct connection to an effective earthing as in accordance with the electrical safety standards in force; it is necessary to check this fundamental requirement and, if in doubt, ask for a thorough check by professionally qualified personnel. The manufacturing company cannot be held responsible for possible damages caused by the lack of a plant earthing;
5. in the case of a possible damage to the safety earthing, disconnect the machine in order to prevent its activation;
6. always use fuses complying with safety standards in force, with the correct value and with the proper mechanical characteristics;
7. do not make use of repaired fuses and avoid causing short circuits between the terminals located on the fuse holder;
8. the user of the machine must not replace its power cable; in the case the power cable is damaged or needs replacing, refer only to the manufacturing company of the machine for its replacement;
9. keep the cable away from hot parts;
10. always switch off and disconnect the machine from the power supply before beginning any general cleaning or washing operation;
11. clean machine coating, panels and controls using soft and dry cloths, or cloths slightly soaked in mild alcohol or detergent solution.

Obligations in the case of malfunction and/or potential danger

Operators are obliged to signal any deficiency and/or potentially dangerous situation immediately to a direct superior.

5. INSTALLATION

Remove the packaging and check that the machine is undamaged. In particular, look for any possible damages caused by transport. If in doubt, do not use the machine and refer to the Manufacturing Company.

Handling



ATTENTION! Don't tilt the machine during handling.

The machine must never be tilted during handling, but always kept in the supporting position to avoid oil transfer into the air system or filters.

Place

Place the machine horizontally in a place with low humidity percentage and far from heat sources. The room temperature should be between 15°C and 40°C.



Do not install the machine in an explosive atmosphere.

CONTROLS AND INSPECTIONS

Vacuum Basic machines

Before starting the machine, check the oil level through the sight glass located on the motor/pump.



Image Pump oil level indicators.

To access the pump, unscrew the bottom center on the rear and lift the housing using the handle.

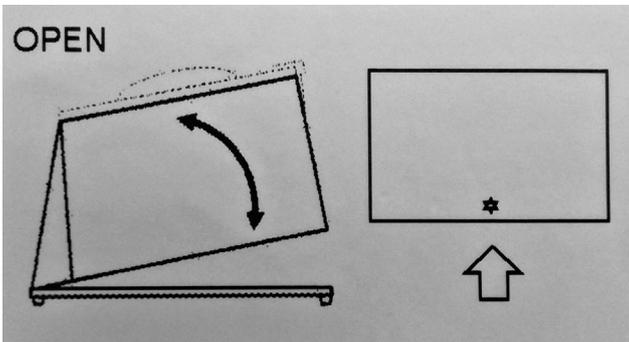


Image Instruction label for opening the structure

Vacuum Industrial machines

Before starting the machine, check the oil level through the sight glass located on the motor/pump.



Image Pump oil level indicators



Image Inspection grille

Electrical connections



Before connecting the machine to the power line check the voltage: it must be as indicated on the machine's CE marking plate.

After checking everything, insert the plug to the socket.

In case of incompatibility between the socket and the device's plug, replace the socket with a suitable type, this operation requires professionally qualified personnel.

At this stage it is necessary to ensure that the sections of the cables of the socket are suitable for the power absorbed by the apparatus. In general, the use of adapters, multiple sockets and/or extensions is not recommended.

If their use is necessary, you must use only single or multiple adapters and extensions complying with current safety regulations, taking care not to exceed the flow limit in current value, and maximum power marked on the multiple adapter.



Disconnect the machine from the power supply before carrying out any control operation involving the parts disassembly.

Electrical connections of machine with voltage 400V



INSTALLATION MUST BE CARRIED OUT BY A HIGHLY QUALIFIED ELECTRICIAN!

The technician must pay attention to the motor rotation direction indicated by a red adhesive label. Should the rotation be on the opposite direction (a loud metal noise will be heard and the chamber won't get closed), invert two of the three supply wires on the plug.



Image Adhesive labels indicating the rotation direction.

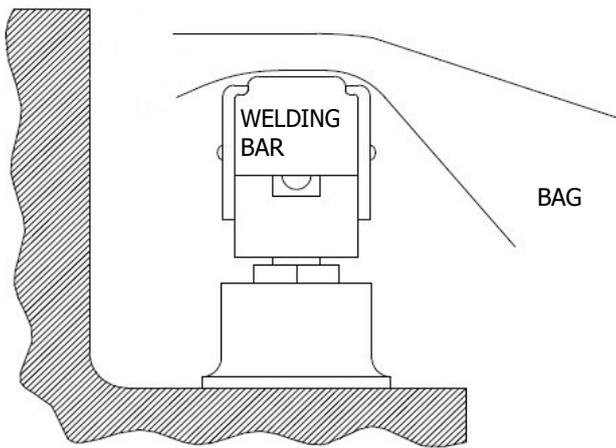
The earthing (yellow-green) must not be moved or disconnected. In the case of power 3P + N ie in the presence of the neutral wire (blue) must not be moved or dissected.

6. USAGE OF THE PACKAGING MACHINE

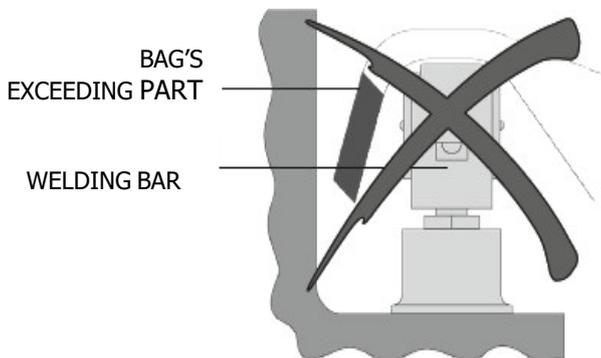
Vacuum packaging

1. Connect the plug to the current outlet.
2. Place the bag inside the vacuum chamber by laying the mouth of the bag on the sealing bar

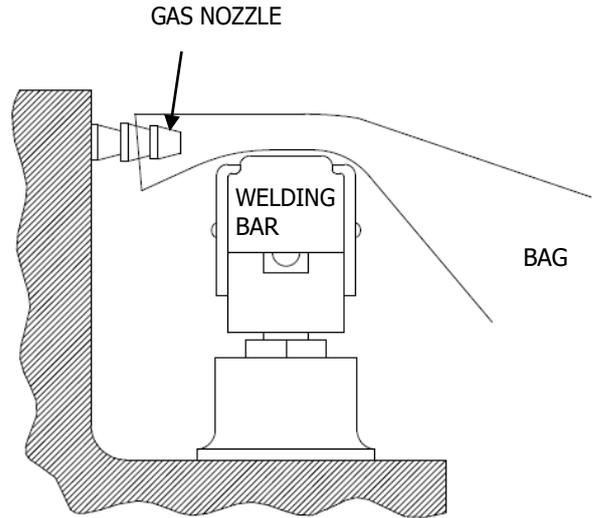
One or two removable food polyethylene shelves are positioned inside the vacuum chamber to level the product thickness according to the sealing bar. The polyethylene shelves can be removed or left inside the vacuum chamber depending on need.



Avoid letting the bag protrude more than 3 cm beyond the sealing bar.



Vacuum-packaging with inert gas injection (optional)



ATTENTION! Don't vacuum pack hot food.

The vapour rising from the hot food is aspirated during the vacuum cycle. The vapour particles are depositing inside the pump, creating rust and inevitably damaging the pump.



VACUUM CYCLE DESCRIPTION

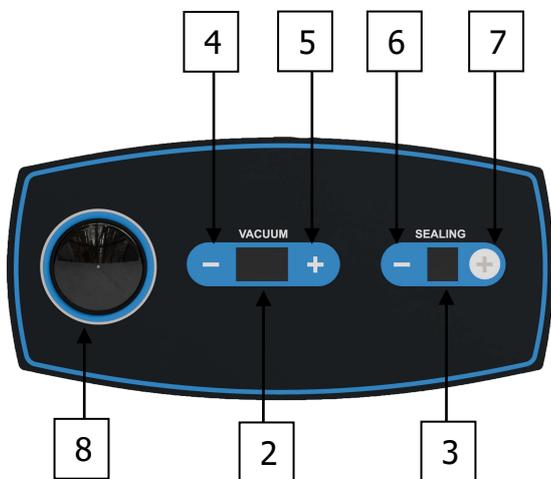
By closing the chamber lid, the vacuum cycle starts by activating the pump suction. The increasing percentage appears and goes up to 99%.

If the machine is equipped with a gas system, at the end of the vacuum the gas injection is activated.

Afterward there is the sealing, followed by the cooling process of the sealing bar. As the cycle is over, the lid opens again automatically.

7. MACHINE FUNCTIONS

7.1 VACUUM BASIC MACHINES

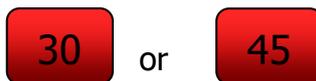


Index

1. General switch O-I
2. Display for vacuum time
3. Display for welding time
4. Button + to set vacuum time (seconds)
5. Button - to set vacuum time (seconds)
6. Button + to set welding time (seconds)
7. Button - to set welding time (seconds)
8. Vacuum gauge

Working cycle settings

When turning on the machine by pressing the O-I switch, after few seconds the following writing appears on the display:



2: Vacuum time indicator. By pressing the + and - buttons, it is possible to set the time (seconds) of vacuum cycle.



3: Sealing time indicator. By pressing the + and - buttons, it is possible to set the time (seconds) of sealing. The point indicates half second.

Closing the lid activates the vacuum pump which completes the vacuum cycle according to the settings entered.

Manual sealing

By keeping button 7 pressed for 3 seconds, you can manually advance to the sealing phase.

Vacuum in GN trays

In order to do the vacuum in GN trays, keep the lid open and press buttons 4 and 5 for 3 seconds with the lid open.

Connect one end of the external suction tube (SUCTION TUBE OPTION) to the suction nozzle at the bottom of the tank and the second end to the container valve.



Image Suction nozzle

After having checked that the pipe's manual valve is closed (pressed on the sleeve connector-side), press button 5 to start the vacuum cycle.

On the vacuum time display (2) the word PU (meaning PUMP) will appear.

On the welding time display (3) a spinning circle will appear.

7.2 LCD MODELS

Once the desired vacuum level has been reached inside the container (check the vacuum indicator), press and hold button 6 for 2 seconds. To exit the "vacuum in GN trays" function, press and hold button 6 for 2 seconds.

Program setting



To enter the program selection menu, press and hold buttons 6 and 7 for 2 seconds.

The number of the program in use (from 0 to 9) will appear on the vacuum time display (2).



To scroll through the programs, press buttons 4 and 5.

To change the programs' settings, press and hold button 7 for 2 seconds.

Display 2 indicates the set vacuum time.
Display 3 indicates the set welding time.

To modify the values use their respective buttons + and -.

To confirm the set parameters, lower the lid and start the vacuum cycle (quick selection).

Alternatively, press and hold buttons 6 and 7 simultaneously.

To return to the operating mode, press and hold button 6 for 2 seconds.

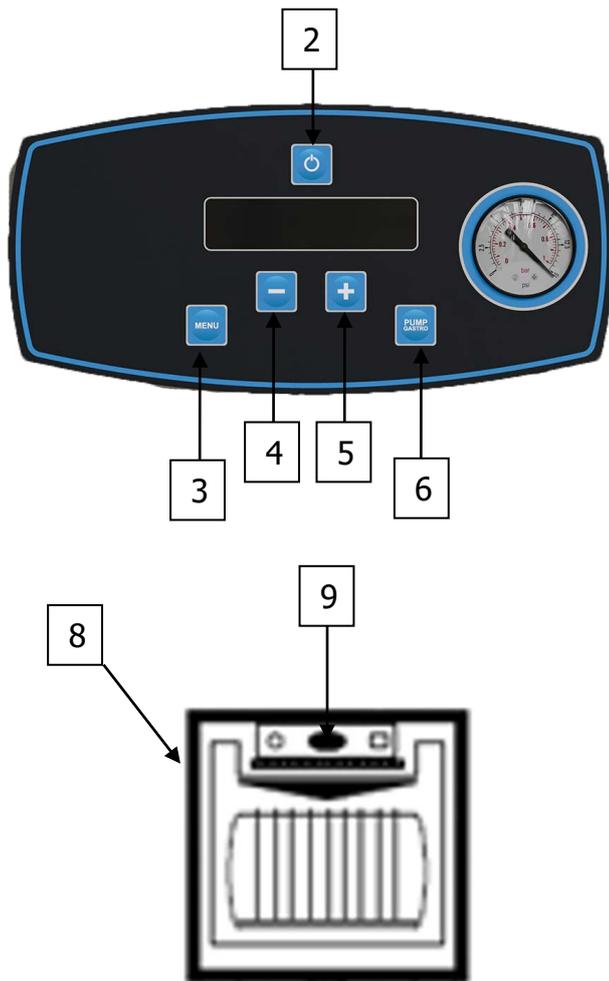
NOTE:

When the machine is turned on, the vacuum time display (2) indicates by default the last working program.

After 5 seconds the two displays respectively show the vacuum and sealing values of the program.



Buttons and display



Index

1. Main switch O-I: turns electrical power on and off
2. Button On/Off: activates and deactivates the equipment operation.
3. Button "MENU": sets up the equipment's parameters.
4. Decreases the parameter's value
5. Increases the parameter's value
6. Button "PUMP GASTRO": activates and deactivates the vacuum in GN trays, removes the "OIL" alarm.
7. Vacuum gauge: detects the negative pressure generated by the equipment
8. Printer (optional): prints up to 9 receipts showing the product's date of expiry. To replace the receipts' paper roll press button 9 and pull both sides flaps of the housing outwards.
10. Bar selector

Language and time setting

Press button 0-1 (1)

Press and hold button "Menu" (3) while pressing button On/Off (2).

To change the set values scroll with buttons 4 and 5.

To confirm the data and move on to the next item, press "Menu" (3)

LANG

Choose from English, Italian, Spanish, German, French, Czech, Slovak, Slovenian, Hungarian, Serbian languages.

Display

Set the display mode: 0: fixed: hour/date
1: intermittence: hour/date – machine setting

TIME / DATE

Time is set in 24h format and date as DD/MM/YY

TEXT

If the machine is equipped with the printer option, it is possible to enter a fixed text, which will be shown at the bottom of each label and cannot be changed in the program setting.

Program setting

The appliance has 20 customizable programs.

Activate the main switch 0-1 (1) to activate the power supply of the equipment.

Press the On / Off button (2)

---Program 1

Scroll with keys 4 and 5 to choose the program to be modified.

Press and hold the "Menu" button (3) for 3 seconds to change the program' settings.

To modify the set values use keys 4 and 5.

To confirm the data set and move on to the next item, press "Menu" (3)

1. Vacuum percentage setting

Vacuum 99%

2. Extra Vacuum

Extra Vacuum 0

The "Extra Vacuum" settings is displayed only when vacuum is set to 99%.

The "Extra Vacuum" extends the vacuum suction for maximum 15 seconds when the machine has reached vacuum 99%.

3. Soft Vacuum (liquids and creams)

Vacuum Mode 1

This option allows the pump to work intermittently to vacuum liquids and creamy products.

- 0: standard vacuum
- 1: soft vacuum with pump intermittence

The cycle consists of 4 seconds of vacuum and 7 seconds of pause until the end of the whole process to total vacuum

If intermittent operation is set in the program, the **symbol *** will appear in the machine setting information to indicate that the soft vacuum is active.

4. Marination

Marination 1

Select the desired value expressed in minutes from 0 to 180 minutes.

At the end of the marinating cycle, the bag will be sealed.

To interrupt the marinating process without sealing the bag, press the On / Off button (2). The lid will open without having sealed the bag.

To interrupt the marinating process with the sealed bag, press the PUMP GASTRO button (6).

If marination is set in the program, the **symbol #** will appear in the machine setting information to indicate that the marination is active.

5. Sealing time setting

Seal 2.0

Adjust the sealing time (seconds and tenths of a second) until a homogeneous and compact seal is achieved on the bags.

6. Gas

Gas 0.0

The parameter is displayed only if the machine is equipped with a gas system.

Select the gas injection percentage.

Attention: for correct food storage it is necessary to carry out a total vacuum before introducing the gas.

Therefore, check that the vacuum in the program is 99%.

Connect the hose coming from the gas cylinder to the hose connection positioned on the side/rear of the vacuum packaging machine by means of the relevant clamp, then set the gas cylinder gauge at a pressure value of 1 ATA.



Make sure that the gas pressure entering the chamber is not higher than 1 bar

Note: there is no direct relationship between the vacuum percentage set and the bag compression but they depend on the product and the bags' size. It is therefore necessary to do some tests and identify the most suitable setting to obtain the desired result.

7. Food preservation time setting



The parameter is displayed only if the machine is equipped with printer.

Select the number of receipts to print (1 to 9)

NB: Setting the value zero the printer will not print anything.

Press the "MENU" button (3) to move the cursor to the second modifiable item, the product storage days (from 1 to 183).

NB: the printout will show the current date and day as well as the expiry day of the product.

8. Label title



Select the text (max 16 characters) or advance by pressing the "Menu" key (3).

Manual interruption of the vacuum cycle

During the working cycle, keep the On / off button (2) pressed for 3 seconds to end the vacuum cycle without welding.

Manual Welding

During normal processing cycle by holding down the PUMP GASTRO (6) for 3 seconds you can make the welding advance compared to the end of its preset vacuum.

Vacuum in GN Trays

Connect the suction pipe (sold separately) to the nozzle in the chamber, placed in front of the sealing bar, together with the lid of the container.



Image Suction nozzle

After having checked that the pipe's manual valve is closed (pressed on the sleeve connector' side), press the button PUMP GASTRO (6) to start the vacuum cycle.

Once the desired vacuum level has been reached inside the container (check the vacuum indicator), press "PUMP GASTRO" (6) again to end the suction cycle.

8. MACHINE'S PROLONGED PERIOD OF NON-USE

If you plan not to use the machine for a long period of time (more than 4 months), proceed as below:

- Disconnect the power outlet (or disconnect the general power supply).
- Carry out a deep cleaning of the bodywork, the tank, the sealing bar and counter bar.
- Remove the oil from the pump.

Protect the machine adequately in order to keep it clean, **leave the lid open** to preserve the durability of the lid lifting pistons.

9. CLEANING AND MAINTENANCE



Disconnect the power supply plug before starting any checking operation which may require parts.

PUMP CLEANING

Check oil's level and condition at least every 4 months.

If the products packaged release volatile substances, the control should be more frequent (For example, if you package flour products, the oil should be checked on a monthly basis).

To check the oil, lift the machine rear and view the pump inspection window. See section 5.

If the oil is transparent but the level is low, add hydraulic oil as directed by the manufacturer. Don't add oil beyond the maximum level indicated on the label!

If the oil is dark or cloudy contact your dealer or service provider to make the oil change.



The control of pump filters must be carried out every 50.000 vacuum cycles by authorized personnel.

Oil alarm (ONLY ON LCD MODELS)

Every 5000 work cycles the message OIL will appear on the display instead of the normal stand-by screen. The alarm reminds you of the need to perform maintenance on the pump as per the instructions in the previous paragraph.

To remove the alarm wording

1. Press button PUMP GASTRO (6)
2. Holding down the button, close the lid
3. When the lid will be closed, release the button PUMP GASTRO (6)
4. Wait until the machine ends the impurities friction cycle (about 10 minutes)

ATTENTION! The impurity fractionation cycle does not replace the oil cleaning maintenance. Pump's oil must be replaced whenever it does not have a limpid or clear appearance (approximately every 4 months or 5.000 cycles of use).

Tank interior cleaning

Following some simple tips you can maintain proper hygiene and operation of the machine.

Clean the sealing bars and the silicone counter bar with alcohol.



Image Sealing bar within the chamber

Periodic maintenance

Periodically check (about every 2000 hours of work) the integrity of the lid gasket, the counter bar silicone and the sealing bar Teflon foil.

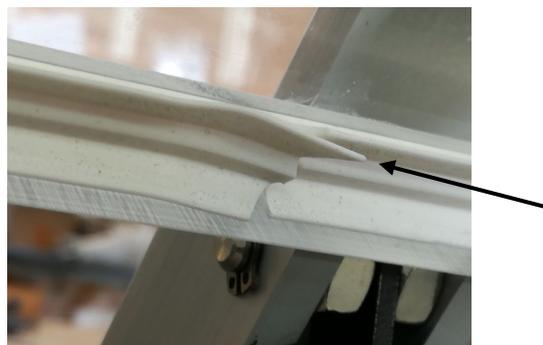


Image Lid gasket

10. TROUBLESHOOTING

THE MACHINE DOESN'T MAKE THE VACUUM?

1. Verify that the vacuum time is set at least at 30 seconds.
2. Check that the bag is properly positioned.

The air inside the bag must be able to go out from the bag's opening side. Add or remove the shelves so that product's surface is at the same level as the sealing bar and roll out the bag to make it stay as straight as possible. Limit the excess of the bag over the welding bar (max 2 cm).

3. Check that the oil is clear and clean. The correct amount of oil in the pump and the periodic oil replacement are crucial to ensure good vacuum quality and machine's durability.

THE MACHINE DOESN'T SEAL PROPERLY?

1. Check that the sealing time is sufficient in order to properly seal the type of bag used.
2. Check that the bag is clean and dry on the sealing area.
3. Verify that the vacuum time is at least of 20 seconds. The machine is set up only to perform the sealing after making the vacuum in the air system.
4. Check that the piston's rod pushing the sealing bar is clean and not covered by oxide. In this case sand with fine-grained sandpaper.



Image Couterbar silicon



Image Sealing bar teflon foil

11. EXPLODED VIEW

