DUNIFORM®

DUNI

USER MANUAL

DF34

TABLETOP TRAY SEALING MACHINE

Operating instructions, safety information
and maintenance guidance

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MANUFACTURER Duni AB
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TABLE OF CONTENTS

1. Preface 3
   1.1 General Information 3
2. Machine Specifications 4
   2.1 Machine Details 4
   2.2 Table of Technical Features 5
   2.3 Display 5
3. Operating the Machine 7
   3.1 Setting up the Machine 7
   3.2 Changing the Tool and Cassette 7
   3.3 Changing the Cassette 9
   3.4 Installing and Changing the Film Roll 10
   3.5 Remove the Drawer 12
   3.6 Basic Settings 13
   3.7 Work Cycle 13
   3.8 Film Knife 16
   3.9 Spike Roll 16
   3.10 Problems, Causes and Solutions 17
4. Maintenance 19
   4.1 Routine Maintenance 19
   4.2 Preventive and Corrective Maintenance 19
5. Disposal of the Machine 20
   5.1 Unit Demolition 20
6. Spare Parts 21
   6.1 How to Order Spare Parts 21
   6.2 Exploded Views 21

1. Preface

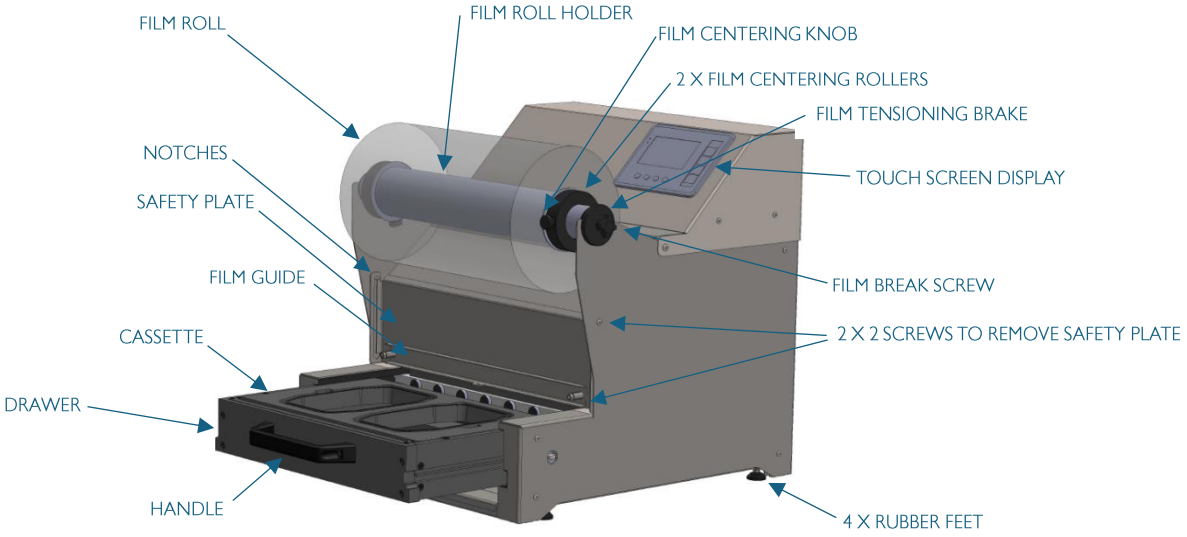
1.1 General Information

Thank you for choosing this Duniform sealing machine, which is intended for use with other Duniform products. This machine is designed to provide you with long, trouble-free operation, provided you follow the instructions found in this manual. Please read the entire manual carefully before using your DF34. It is the responsibility of the operator to thoroughly read the manual in its entirety, to secure safe operating.

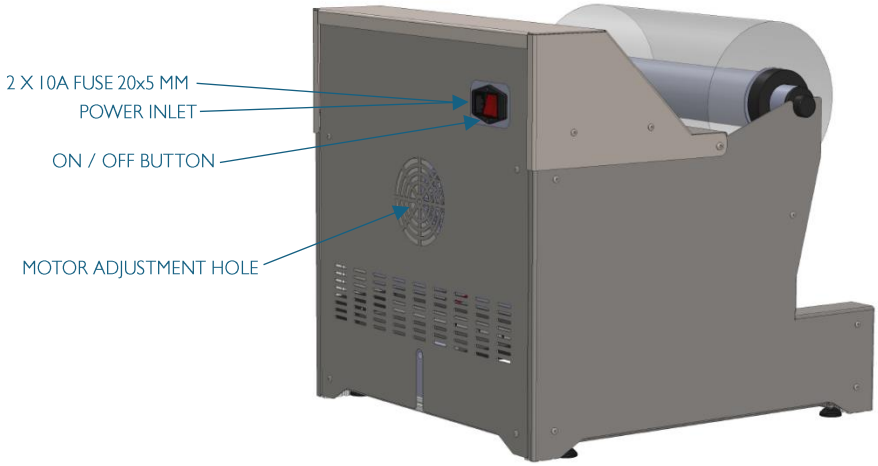
The DF34 is our user-friendly tabletop tray sealer, designed for flexible production and quick tool changes. Featuring an intuitive touchscreen for simple operation and gas flush technology to help extend product shelf-life. Built around one versatile platform, the DF34 lets you easily switch between straight cut and figure cutting tooling, with gas flush available as an additional option.

2. Machine Specifications

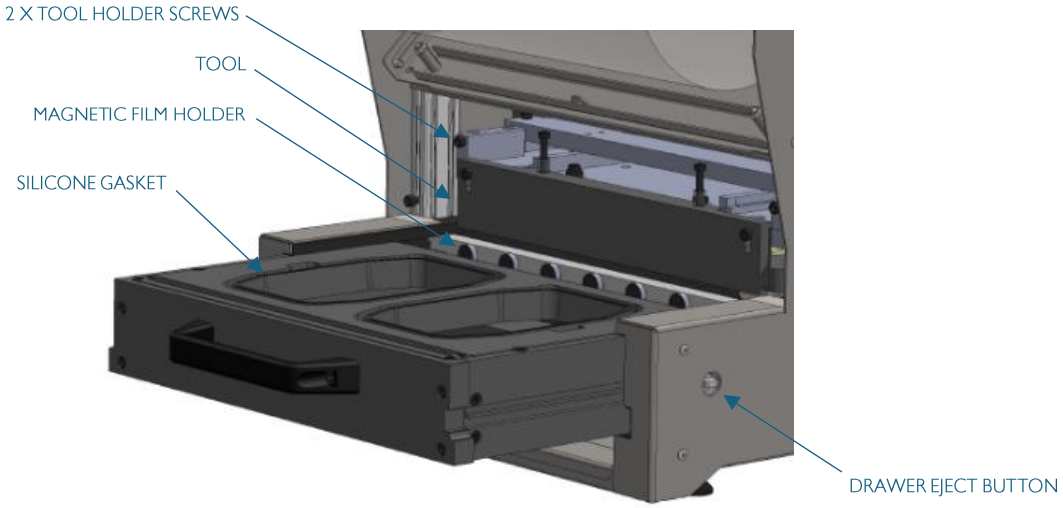
2.1 Machine Details



Picture 1. Front side of the machine



Picture 2. Back side of the machine



Picture 3. Front side of the machine, showing the tool

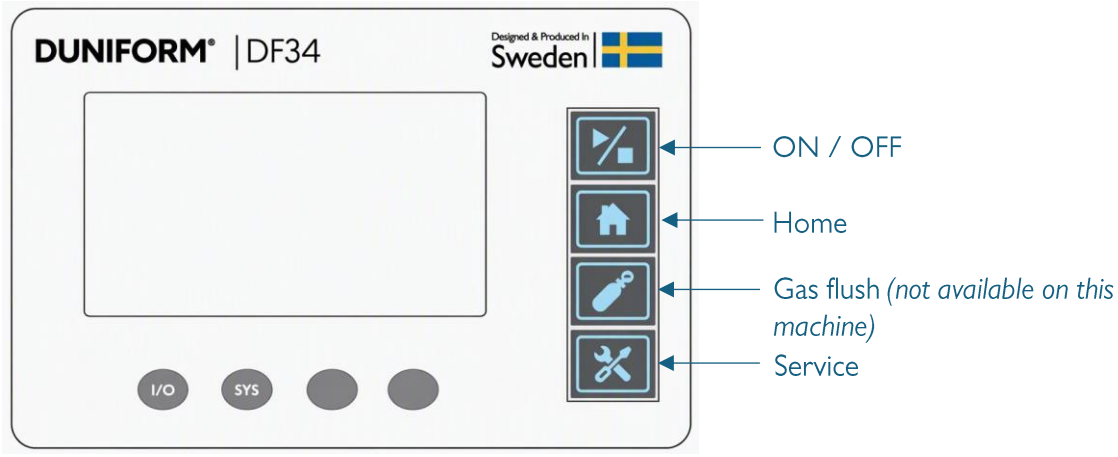
2.2 Table of Technical Features

Parameters	Value
Weight	78 kg
Width including Film Roll Holder	560 mm
Width excluding Film Roll Holder	515 mm
Depth (Closed)	565 mm
Depth (Open)	860 mm
Height	535 mm
Electrical supply	1/N/PE 230V AC-50/60 Hz
Max. Power Consumption	2 kW
Start-Up Heating time	10 min
Operating temperature	5 – 40 °C
Cycles per minute	2-4
Pressing Force	2000 N
Max. Tray Dimensions	350 x 260 x 100 mm (>1/2 GN)
Max. Depth of Tray	100 mm
Max. Film Width	390 mm
Max. Diameter of Film Roll	250 mm
Max. Sealing Temperature	200 °C
Sealing Technique	Semi-Automatic
Cable Length/Connection Plug	2,5 m / 1 phase grounded

Table 1. Technical Features

2.3 Display

The machine is equipped with four buttons, and a touch screen.



Picture 4. Display

- **ON / OFF**
  Press to turn ON the machine functionality, the button then turns green. Press to turn OFF the machine functionality, the button then turns red.

- **Home**
  On the home screen the basic settings are set, as temperature, sealing time and number of trays per cycle.

- **Gas flush**
  Not available on this machine.

- **Service**
  In the service screen you can see the alarm-list and find information on how to book service. The service button will turn yellow when it is time to book service.

The I/O and SYS buttons are not relevant when using this machine.

3. Operating the Machine

3.1 Setting up the Machine

- Select a flat and stable surface with a minimum area of 56 × 51 cm to ensure that the machine is securely supported.
- Carefully remove the machine from its packaging.

WARNING! Due to the weight of the machine, at least two people are required to lift and position it safely.

WARNING! Lift the machine where the steel is bent to ensure safe handling and prevent injury.

- Always keep the machine in a horizontal position during handling and installation.
- Ensure that all four rubber feet are resting firmly on the supporting surface. Before operating the machine, verify that it is stable and cannot tip or move.
- Connect the power cord to the power inlet on the rear of the machine and plug it into a suitable wall outlet. Only use the power cord supplied with the machine.

3.2 Changing the Tool and Cassette

3.2.1 Straight Cutting Tool

To produce straight cuts, install the straight-cut tool and use the cassette corresponding for the selected tray. The straight-cut tool can be used with all cassettes and tray sizes.

3.2.2 Figure Cutting Tool

To produce figure cuts, install the figure-cutting tool and the cassette corresponding to the selected tray. It is important to make sure that the cassette and the tool match as the tool may be damaged if operated with mismatched tooling.

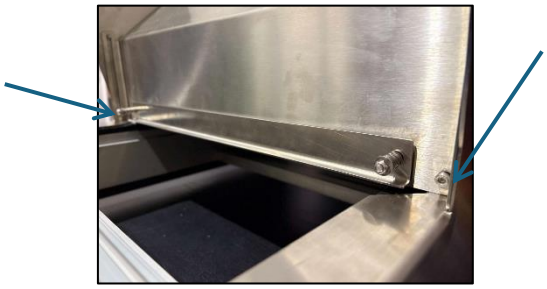
3.2.3 Changing the Tool

WARNING! Switch off the machine and disconnect the power supply before performing any tool change.

WARNING! Allow all machine components to cool down before starting the operation. Hot surfaces may cause burns, use heat-resistant protective gloves.

WARNING! Do not touch the knives while performing this procedure. Risk of cuts and lacerations.

1. Loosen the screws on the safety plate. Place the screws in a safe location for reinstallation.

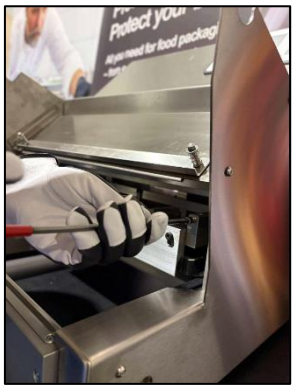


2. Lift the safety plate upwards and secure it in an upright position using the designated notches, as shown in Picture 1, section 2.1 Machine Details.

WARNING! Never run the machine without the safety plate in position, there is a risk of crushing, cutting and burn injuries.



3. Remove the two tool holder screws. Place the screws in a safe location for reinstallation.



4. Pull the tool towards you until it reaches the end position of the guide rails.



5. Grasp the tool with both hands, one on each side, and carefully lift it and pull it free from the guide rails.



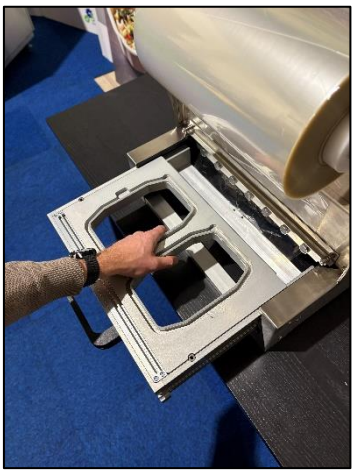
6. Place the removed tool on a stable, flat, and heat-resistant surface where it cannot be damaged, scratched, or accidentally tipped over.
7. Grasp the replacement tool with both hands, one on each side and carefully position it in line with the guide rails. With both hands, carefully slide the tool into the machine until it reaches the end position.
8. Reinstall and tighten the screws removed in Step 3.
9. Lower the safety plate to its operating position and reinstall and tighten the fastening screws.

WARNING! Do not connect the power supply or switch on the machine until the safety plate has been correctly reinstalled and secured.

WARNING! If you change to a figure cutting tool, make sure that the design of the tool corresponds to the chosen cassette. Incorrect tool and cassette combinations may result in damage to the machine and tooling.

3.3 Changing the Cassette

1. Pull out the drawer to its end position.
2. Grip the cassette firmly and lift it straight upwards to remove it from the drawer.



3. Place the cassette on a stable, flat, and secure surface where it cannot be damaged, scratched, or accidentally tipped over.
4. Position the replacement cassette in the drawer and ensure that it is correctly mounted.

WARNING! Make sure to change the cassette carefully to avoid pinch injuries.

WARNING! If a figure cutting tool is installed, a corresponding cassette for the chosen tray must also be used. Incorrect tool and cassette combinations may result in damage to the machine and tooling.

3.4 Installing and Changing the Film Roll

There are several types of film available, each designed for specific applications and packaging requirements. It is important to select a film that is suitable for the chosen tray and the intended use of the packaged product. Before operating the machine, verify that the selected film is compatible with the tray specification. In addition, ensure that the film dimensions match the machine requirements as specified in Table 1 in section 2.2. Using the correct film type and dimensions is essential for achieving optimal sealing performance and correct machine operation.

1. Pull out the drawer to its end position.
2. Loosen the film from the magnetic film holder and the film guide.
3. Loosen the film break screw, and carefully lift the film roll together with the film roll holder out of the machine.



WARNING! Always support the film roll and the film roll holder during removal and installation. Ensure that no component is dropped or subjected to impact.

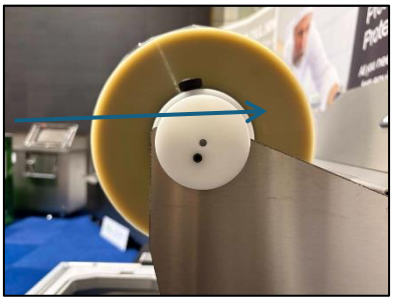
3. Place the film roll and the film roll holder on a stable, flat, and secure surface where it cannot be damaged, scratched, or tipped over.
4. Loosen the film centering knob and remove the film centering roller on the opposite side of the film tensioning break. Carefully slide out the film roll holder out of the film roll.
5. Slide the film roll holder into the new film roll, making sure the film roll is on the lip of the film centering roller.

WARNING! Keep fingers clear of pinch points when reinstalling the film roll.

WARNING! Ensure that the film unwinds towards the machine and that the sealing side of the film faces the operator. Incorrect film orientation will result in improper sealing performance and may cause damage to the sealing plate.



6. Reinstall the film centering roller with the film roll placed on the lip, and place the film roll and film roll holder assembly back in the machine.
7. If the film tensioning brake has been removed, it should be re-attached as in the picture below.



8. Verify that the film unwinds towards the machine and adjust the film brake knob to the required resistance.
9. Adjust the film centering rollers to align the film with the sealing plate and tighten the film centering knobs.
10. Guide the film carefully behind the film guide.

WARNING! The area around the film guide may be hot. To prevent burns, avoid contact with the heating plate and wear heat-resistant gloves when required.

11. Pull out sufficient length of film to cover the magnets on the magnetic film holder.
12. Secure the film by closing the drawer until it locks into position and the film is retained by the magnetic film holder.



3.5 Remove the Drawer

1. Pull the drawer out to its end position.
2. Hold the handle with your left hand and whilst pressing the drawer release button with the right hand, pull out the drawer beyond the safety lock/drawer release button.



3. Change your grip to one hand on each side of the drawer and carefully pull the drawer out until it is clear of the machine.



3.6 Basic Settings

1. Connect the power cord to the power inlet on the rear of the machine and plug it into a suitable wall outlet. Only use the power cord supplied with the machine.
2. Ensure that the machine is **not** in Run Mode. The Run Mode button should be coloured red.
3. Install your tool as described in Section 3.2.3 Changing the Tool.
4. Pull out the drawer and insert the required cassette as described in Section 3.2.4 Changing the Cassette.
5. On the Home screen, press the grey temperature field to set the wished sealing temperature.
6. On the Home screen, press the grey timer field to set the wished sealing time.
7. On the Home screen, press the grey field stated counter to set the number of trays per cycle in your chosen cassette.



3.7 Work Cycle

1. Pull out the drawer.
2. Secure the film between the magnetic strip and the cassette. To keep the film secured between the magnetic strip and the cassette when re-doing the work cycle, do not pull the drawer out completely.

WARNING! If needed to re-guide the film behind the film guide between cycles, the sealing plate may be hot. Allow the machine to cool down or use protective gloves before correcting the film in its position.

3. Activate run mode on the ON/OFF button. The ON/OFF button will illuminate green.
4. Place the filled tray(s) in the cassette.
5. Push the drawer fully into its inner position, making sure that the film follows the drawer into the chamber. Wait for the sealing cycle to finish. Do not pull out the drawer until the tool has fully lowered, sealed the tray(s), and returned to its home position.

WARNING! Only hold the handle when pushing the drawer to its inner position to prevent pinch injuries.

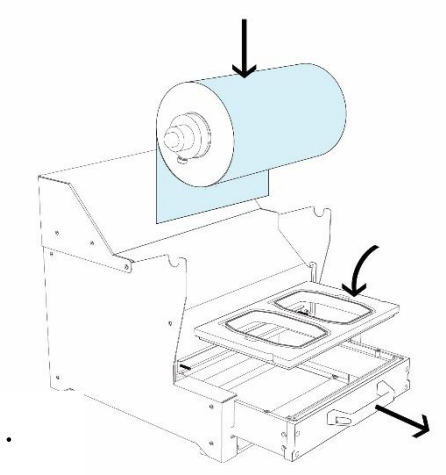
6. Pull out the drawer and remove the sealed tray(s).
7. If using a Figure Cutting Tool, remove any excess film.
8. Repeat the procedure, starting from Step 2, for the next sealing cycle.

WARNING! The front surface of the machine may become hot during operation. Avoid prolonged contact to prevent discomfort or burn injuries.

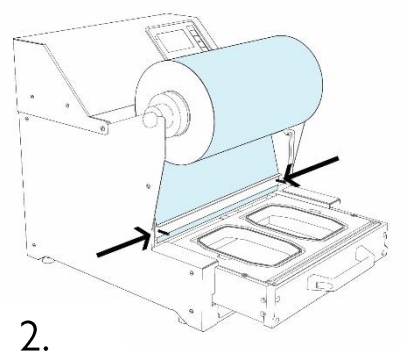
WARNING! Do not remove film residues from beneath the sealing plate while the machine is in operation or while the sealing plate is hot. Switch off the machine and allow it to cool completely before removing any residues to reduce the risk of burns.

WARNING! Never run the machine without the safety plate in position, there is a risk of crushing, cutting and burn injuries.

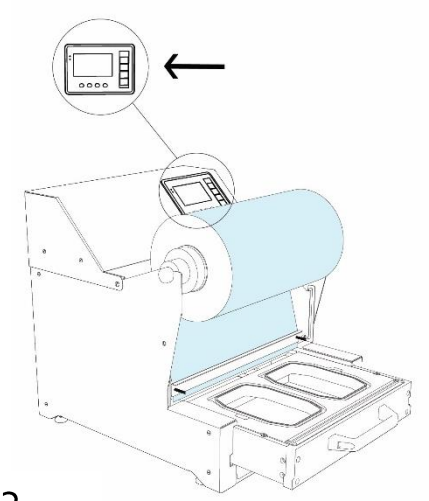
1.



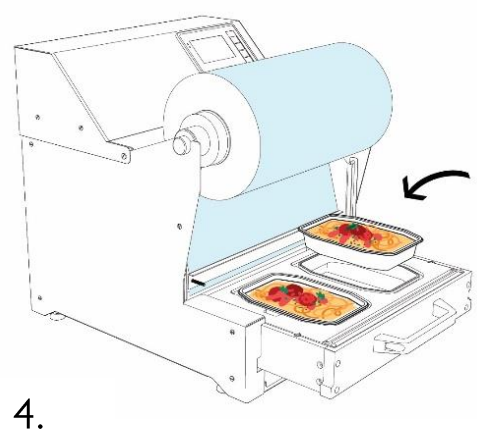
2.



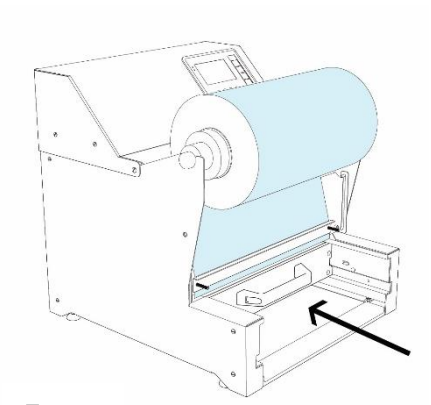
3.



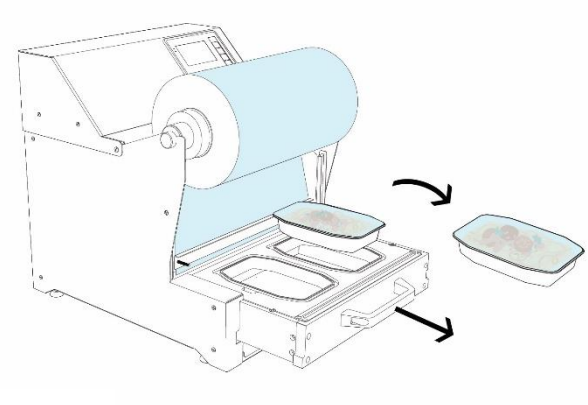
4.



5.



6.



3.8 Film Knife

The film knife is an accessory for the straight cut tool. It is mounted in front of the safety plate and cuts the film between two trays during sealing, to ensure clean package separation and an even package appearance.

Follow these steps to install the film knife:

1. Remove the four screws to remove the safety plate. Place the screws in a safe location for reinstallation.
2. Remove the safety plate.
3. Attach the safety plate mounted with the film knife holder and film knife, using the screws from step 1.



3.9 Spike Roll

The spike roll is used in applications requiring air release from the packaging. It perforates the film during the sealing cycle, allowing steam to escape and prevents internal pressure build up and fogging.

Follow these steps to install the spike roll:

1. Remove the four screws to remove the safety plate. Place the screws in a safe location for reinstallation.
2. Remove the safety plate.
3. Attach the safety plate mounted with the spike roll holder and spike roll, using the screws from step 1.



3.10 Problems, Causes and Solutions

1. **The machine does not start**
   - Check that the plug is connected to the socket, and check that the main power supply is running if necessary.
   - Check the safety fuse and replace it if necessary.

2. **The sealing plate does not heat up**
   - Check the temperature set on the display.
   - The heating plate is broken.
   - The temperature sensor is broken.

3. **Improper sealing**
   - Check the temperature set and adjust it so you reach your wished sealing of lamination.
   - Increase or decresase the sealing time so you reach your wished sealing of lamination.
   - Check the status of the silicon strip on the cassette.

4. **Improper film cutting**
   - Check the blades' status.
   - Check that there are no foreign objects or dirt on the mould.
   - Adjust the settings of the film cutting knife.

5. **The tool is stuck in lowered position**
   Follow these steps:
   - Turn OFF the machine and unplug the machine.
   - Insert a 4 mm allen key into the motor adjustment hole located on the rear of the machine. Rotate the key counterclockwise 6-10 turns until the motor is raised from its lowest position. Remove the allen key.
   - Check that correct tool and cassette are installed in the machine.
   - Check that the cassette is placed corresponding to the tool.
   - Plug-in the machine and turn it ON.
   - Press the Service button, then select "Return to Home Position".

6. **The sealing film does not follow the trays into the sealing chamber**
   - Check that the film is properly locked in between the drawer and the magnetic film holder.
   - Check if the film brake screw is screwed too tight onto the film holder, hindering it from releasing film through the process.

7. **The magnetic film holder is stuck inside the chamber**
   - Pull the drawer out to its end position. Carefully reposition the magnet film holder into its correct position.

   WARNING! The sealing plate may be hot during operation. Allow the machine to cool down or use protective gloves before correcting the magnetic film holder.

8. **The service button turned red**
   - This indicates that an alarm is triggered, press the service button and check the alarm list.


DUNIFORM
DF34
Designed & Produced in
Sweden
Start Sensor (X0)
Motorsensor Upper (X1)
Motorsensor Lower (X2)
Gas Available (X3)
Alarm1: Motor Stuck
Alarm2: Wrong Position
Alarm3: Tool Missing
Alarm4: Gas Missing
RESET ALARMS
RUN MOTOR TO HOME POSITION
BOOK SERVICE
I/O
SYS

4. Maintenance

4.1 Routine Maintenance

4.1.1 Daily Maintenance

WARNING! Never clean the machine with running water. Do not spray, rinse, or pour water or other liquids onto the machine.

- Clean your machine daily with a damp cloth.
- Make sure that no food rests are left in any splits between parts of the machine.
- Do not use any abrasive materials to scrub or clean the machine, nor any chemicals which are abrasive or otherwise not suitable for stainless steel.

4.1.2 Periodical Maintenance

Changing the Silicone gasket: The Silicone gasket on the cassette is available as spare part and can be replaced when worn or damaged.

- Remove the worn Silicone gasket from the cassette.
- Fit the new Silicone gasket by pressing it firmly into position. Ensure that the thin side faces downward and the thicker side faces outward.
- Cut the Silicone gasket to the correct length.

4.2 Preventive and Corrective Maintenance

Regular maintenance is required to ensure reliable operation and a long service life. When the recommended annual service interval has been reached, the service indicator button will illuminate yellow. We recommend booking a service appointment at that time.

If the machine is damaged, does not operate correctly, or if a fault cannot be resolved using the troubleshooting guide in this manual, contact Duniform Service for assistance. Press the service button on the display and scan the QR code to access the Duniform Service contact information.

DUNIFORM offers service and technical support to help keep your machine operating safely and efficiently. When you sign up for a DUNIFORM Service Agreement, the following are included in your service:

- One maintenance visit per year.
- Safety inspection and functional testing of programs, time, and temperature
- Inspection and replacement of wear parts
- Inspection report on the maintenance performed.
- Telephone support during normal business hours on weekdays.
- Priority support in the event of urgent breakdowns and priority delivery of spare parts.

Sign up for our Duniform service agreement today by scanning the QR code on the service button.

WARNING! Only trained and authorized personnel are permitted to perform service and maintenance in the machine.

5. Disposal of the Machine

5.1 Unit Demolition

The machine is manufactured using non-hazardous materials with a low environmental impact. However, the owner remains responsible for ensuring that the machine is dismantled and disposed of in accordance with all applicable local regulations.

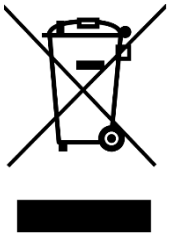
WARNING! Before commencing any dismantling or disposal work, disconnect the machine from the electrical supply.

WARNING! Machine demolition and disposal shall only be carried out by qualified personnel with appropriate electrical and mechanical competence.

Proceed as follows:

1. Disconnect the machine from all power.
2. Dismantle the machine into its individual components and assemblies.
3. Separate all parts according to material type e.g. metal, plastic, electrical and electronic components.
4. Dispose of all components in accordance with applicable local environmental and waste-handling regulations.

As disposal and recycling requirements may vary between countries and regions, the organization responsible ensures compliance with all regulations in force at the time of dismantling.



6. Spare Parts

6.1 How to Order Spare Parts

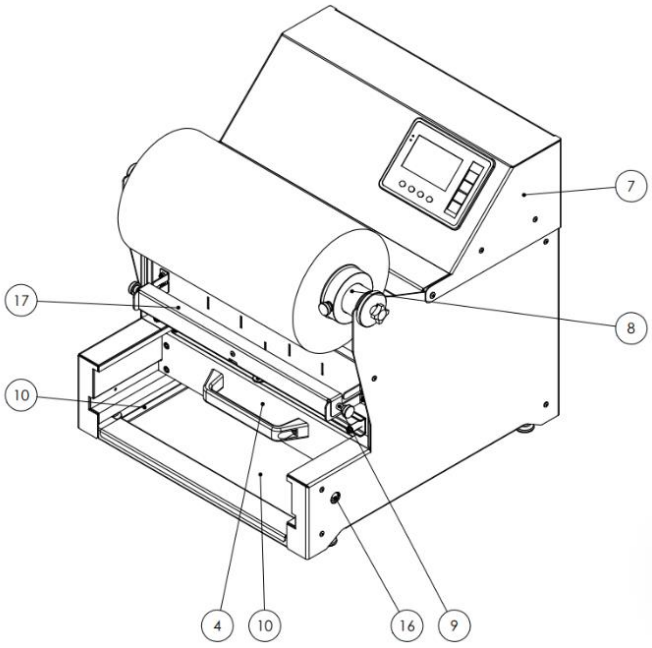
To order spare parts, please contact **info@solerv.se** and provide the following information:

- Machine number
- Item number of the required spare part
- Quantity required

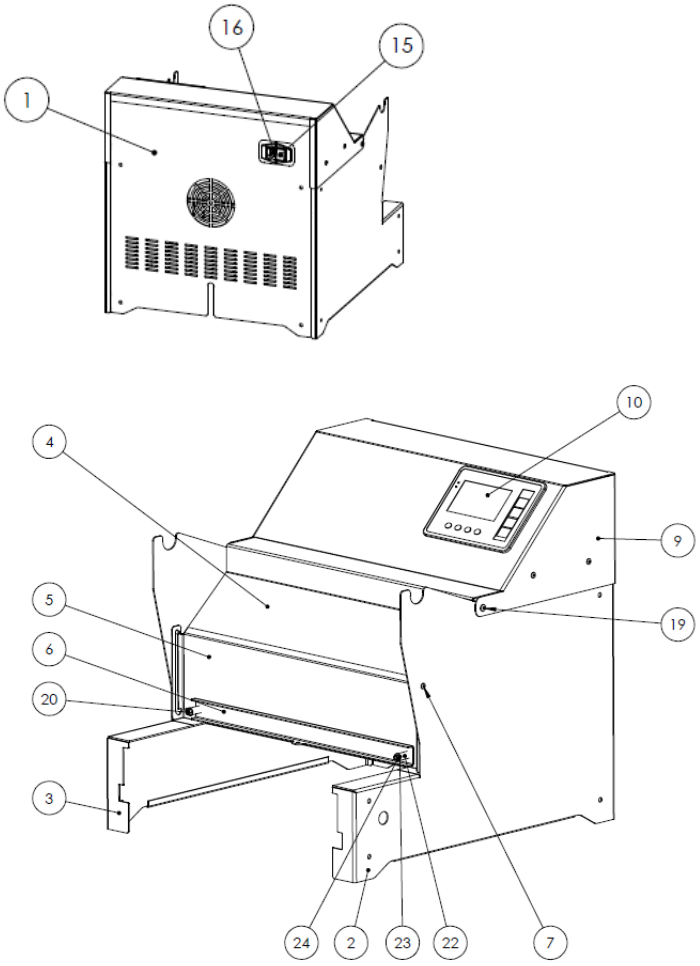
Refer to the exploded views in Section 7.2 to identify the correct spare part and item number.

6.2 Exploded Views

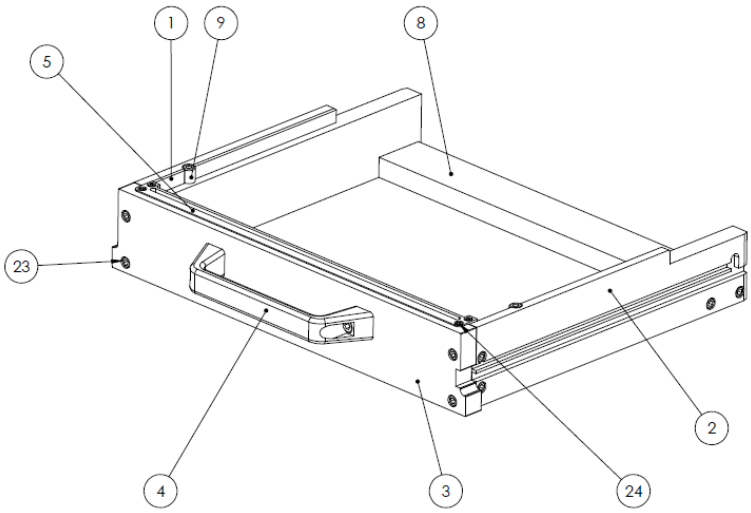
ITEM NO.	PART NO.	QTY.
4	DF34-Kassettelåda	1
7	DF34-Täckplåtar	1
8	DF34-Folierör	1
9	232572 DF ACCESS DF34 SPIKE ROLL	1
10	232571 DF ACCESS DF34 DRIP TRAY	1
16	DF34-Spärr	1
17	DF ACCESS DF34 FILM KNIFE_SPIKE ROLL HOLDER	1



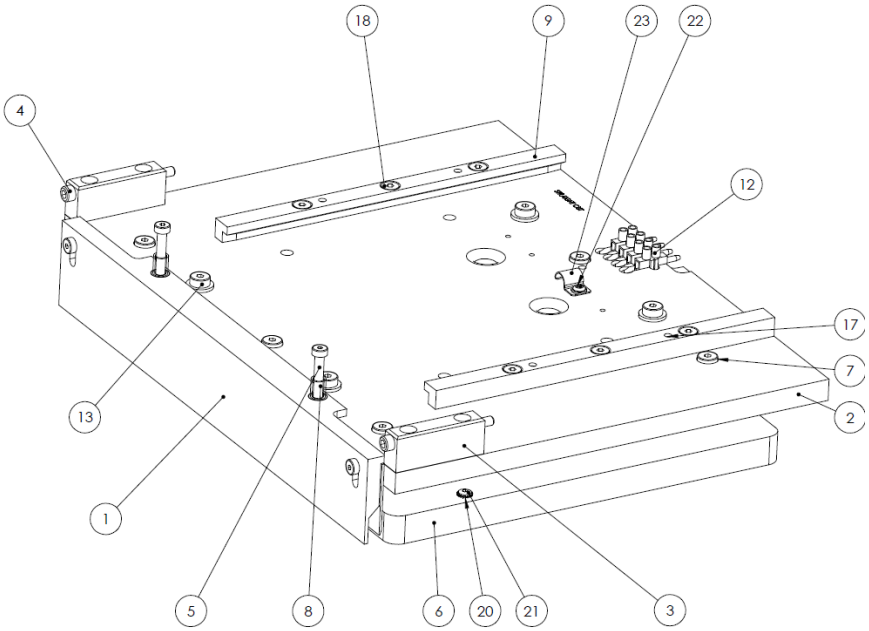
ITEM NO.	PART NO.	QTY.
1	03-1005	1
2	03-1001	1
3	03-1002	1
4	03-1004	1
5	03-1003	1
6	03-1016	1
7	K6S M5X10	12
9	03-1010	1
10	GC43MH-16MR-D	1
15	NS-1-0050 - Strömbrytare	1
16	NS-1-0050 - ElKontakt	1
19	K6S M6X16	2
20	94032___5_30-mattssons	2
22	Fjäder CS 0.75x10.75x25	2
23	Bricka_M5x12	2
24	LM6M M5_Låsmutter	3



ITEM NO.	PART NO.	QTY.
1	11-1001	1
2	11-1002	1
3	11-1003	1
4	Handtag_Wiberger	1
5	11-1005	1
8	11-1004	1
9	CP_12x30	2
23	M6_Bult_L25	12
24	M4_Bult_L16	4



ITEM NO.	PART NO.	QTY.
1	DF34-Kniv	1
2	554-1003 DF34 STRAIGHT CUT	1
3	12-1005	2
4	M6_Bult_L70	2
5	Passbult M5x35	2
6	12-1008	1
7	DF34 M6 Fjäderpaket	6
8	Fjäder CS1.2X9.65X30	2
9	12-1004	2
12	Kontakt_Hane_Vit	1
13	DF34 M6 Fjäderpaket_Lång	4
17	CPm6_5x25	4
18	MF6S M6x20	6
20	LB-AZ M5 A2	11
21	K6S M5X10	1
22	KTSF M4X6 8.8 FZB STAR	1
23	Kabelclips	1



ITEM NO.	PART NO.	QTY.
1	13-1001	1
2	13-1002	2
3	13-1003	2
4	13-1005	2
5	13-1006	2
6	13-1007	1
7	13-1008	1
8	Kontakt_Hona_Vit	1

