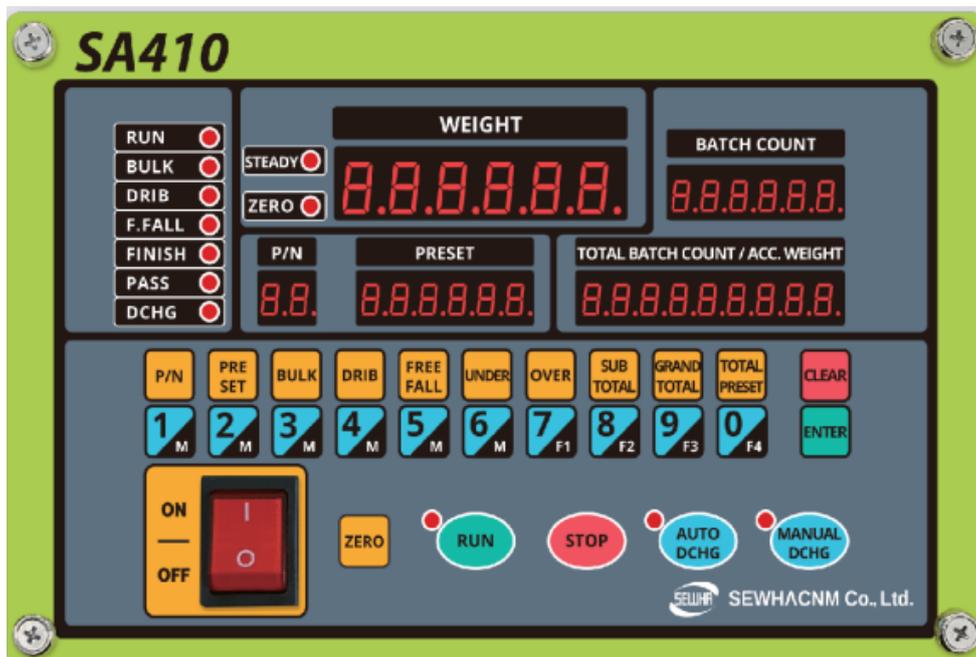


Single Packer Controller

SA410DS

User manual



MANUAL VER. 1.01

PROGRAM VER. 1.01



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1. Before Installation

1-1. Caution / Warning Marks

| | |
|---|---|
|  | This mark warns the possibility to arrive death or serious injury in case of wrongly used. |
|  | This mark cautions the possibility to arrive serious human body injury or product lose in case of wrongly used. |

1-2. Other Marks

| | |
|---|--|
|  | Warning for Electric Shock or Damage. Please do not touch by hand |
|  | Protective Ground(Earth) terminal |
|  | Prohibition of Operation process |

1-3. Copyrights

- (1) All Right and Authority for this Manual is belonged to SEWHACNM CO., LTD.
- (2) Any kinds of copy or distribution without SEWHACNM CO., LTD.'s permission will be prohibited.

1-4. Inquiries

- (1) If you have any kinds of inquiries for this model, please contact with your local agent or Head Office

- 1) Head Office: SEWHACNM CO., LTD.
- 2) Web site: sewhacnm.co.kr
- 3) Email: sales@sewhacnm.co.kr
- 4) TEL: +82 70 4754 6140

Single Packer Controller SA410DS

2. INTRODUCTION

2-1. Introduction

Thank you for your choice, "SA410DS(SINGLE PACKER CONTROLLER)" for your Production line. This Instruction Manual will help you to operate SINGLE PACKER CONTROLLER (SA410DS) with higher availability and accuracy. Thank you

2-2. Caution

- (1) Don't drop on the ground or avoid serious external damage on item.
- (2) Don't install under sunshine or heavy vibrated condition.
- (3) Don't install place where high voltage or heavy electric noise condition.
- (4) When you connect with other devices, please turn off the power.
- (5) Avoid from water damage.
- (6) For the improvement of function or performance, we will change the specification without priority notice or permission.

2-3. Features

This SINGLE PACKER CONTROLLER has been used in every kinds of industries.

But, there are a lot of difficulties to develop and produce "AUTOMATIC SINGLE PACKER CONTROLLER" as the all parts are consisted separately, like Indicator(Weight Display), Controller(PLC), Drive Parts(Solenoid Valve, Motor, Feeder), and Power supply units to drive these parts. Therefore we Sewhacnm, developed SA410DS model with searching to maximize processing efficiency and this controller has following features.

● Easy to Install

SA410A is composed by two parts. Front Panel and Control Module.

Front Panel is very thin (t=50mm) and designed elegant veneer so it can be installed easily on suitable place where the operator can see clearly.

Additionally, Control Module can be installed on wherever the operator can maintain easily.

● Various Display panel and Elegant Appearance

We verified Display panel to recognize all required information at once, and we use LEXAN Film which is good looking and strong for dust.

● SA410DS Controller has sequence Board, which controls Main Control Module and all input /

Output signal. And this Sequence Board is programmed to operate with best function.

All input/output signal is composed by "Photo-coupler" to cover all noise from external environment and protected by DATA BACK-UP function when the power is out.

In addition, it has WATCH-DOG system which can recover automatically when the MICOM has malfunction due to abnormal various from environment or noise.

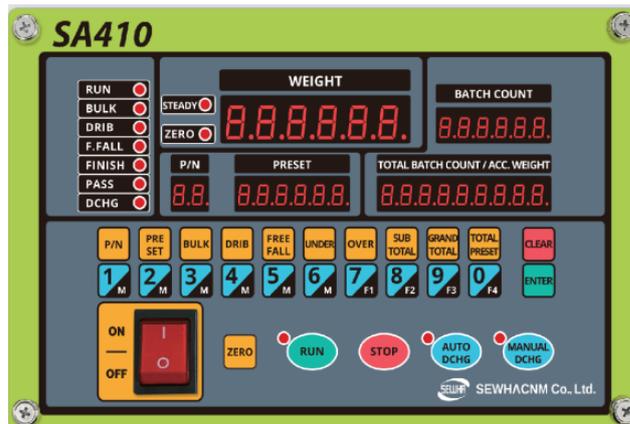
3. SPECIFICATION

3.1. Specification

| Content | | Detail | |
|----------------|-----------------------------------|--|---------------------|
| A/D Conversion | Display Resolution | 1/20,000 | |
| | Internal Resolution | 1/2,097,152 ($\pm 1,048,576$) | |
| | Input Sensitivity | Min. 0.1 μ V/V | |
| | Max. Input Signal (mV) | +3.00mV/V | |
| | Load Cell Excitation | +5V DC | |
| | Conversion Method | Sigma-Delta | |
| | Decimal Setup | 0, 0.0, 0.00, 0.000 | |
| | DRIFT | ZERO | 10PPM/ $^{\circ}$ C |
| | | SPAN | 10PPM/ $^{\circ}$ C |
| | Linearity | 0.001% of Full Scale | |
| A/D Sampling | Max. 60 times / sec | | |
| Environment | Temperature Range | 0 $^{\circ}$ C ~ +40 $^{\circ}$ C [14 $^{\circ}$ F ~ 104 $^{\circ}$ F] | |
| | Humidity Range | 40% ~ 85% RH, Non-condensing | |
| LCD Interface | Weight | 7 Segment, 6 Digit, Red LED Display 14.1(H) X 8.1(W)mm | |
| | Set Value | 7 Segment, 6 Digit, Red LED Display 10.1(H) X 5.8(W)mm | |
| | P/N | 7 Segment, 6 Digit, Red LED Display 14.1(H) X 8.1(W)mm | |
| | Batch Count Accumulated Weight | 7 Segment, 6 Digit, Red LED Display 10.1(H) X 5.8(W)mm | |
| Communication | Serial Interface | RS-232 1EA | |
| Input | Key pad | 27EA | |
| | External Input | 4EA | |
| Output | Output | Relay Output 6EA | |
| | Relay | Han-Dok Electronics Power Relay 250VAC/10A/1a | |
| Power | | AC : 110~240V, 50/60Hz, 7A | |
| Size | | 250(W) X 161.5(H) X 90 (D) | |

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3.2 Display



3-2-1. Number Display

- 1) Weight : Display the Current weight.
- 2) PRESET Value : Display the Current Set value
(Display the corresponding value at press the Set, Bulk, Drip, Free Fall, Under Value, Over Value key)
- 3) Part No. : Display the current Part No.
- 4) Batching Count : the number of times the weighing operation has been completed is displayed for each part number
- 5) Total weighing Count/Accumulate weight : The total number of weighing operations and the Total weight at which the weighing operation has been completed are displayed

3-2-2. LED Display

- 1) Bulk : Lights up at Setp1 relay operating
- 2) Drip : Lights up at Setp2 relay operating
- 3) Free Fall : Lights up at Setp3 relay operating
- 4) Finish : Lights up when the weighing is completed and the weight is stable
- 5) Pass weight judgement : Lights when the weighing is completed within the lower and upper limits of the weighing Value
- 6) Discharge : Lights up at Discharge relay operating
- 7) Steady : Lights up when the weight is steady
- 8) Zero : Lights up when the weight is Zero.
- 9) Run : light up when the weighing base is operating

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3-2-3. LED Display

| | |
|---|--|
|  | This key used for Run to the controller |
|  | If the lamp is turn on, the weighed product will be automatically discharged within few Minute after finishing batch process |
|  | If you press this key, when the batch process is finished, the discharge gate open And discharge the product |

3-2-4. Key

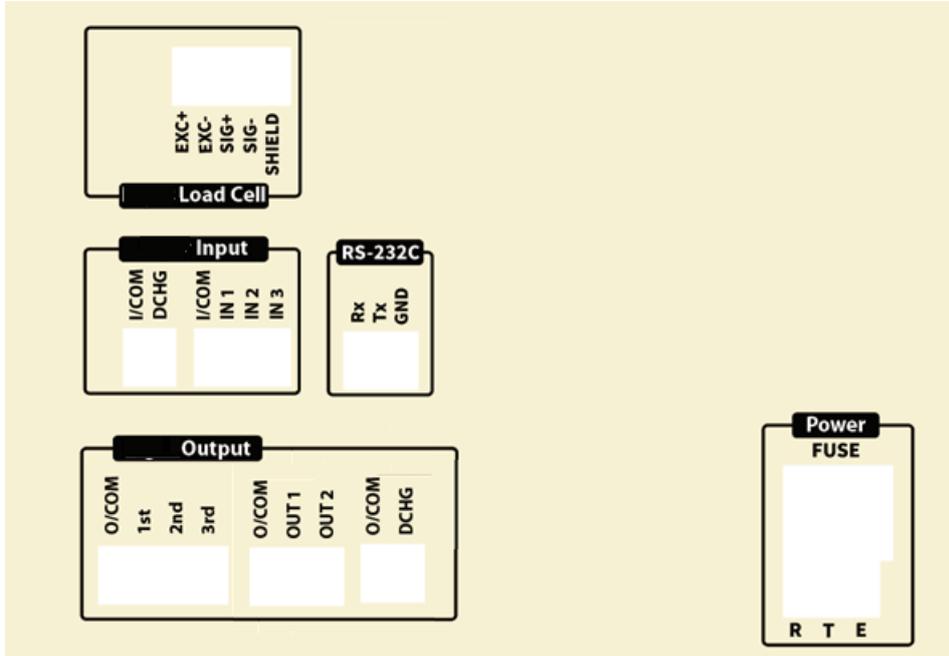
| | |
|---|--|
|  | You can use this key when you change product no. P/N number up to 50 maximum. |
|  | You can use this Key when you determine target weight When you press this key, current Preset value will displayed on the Preset window with blinking. Preset value must be bigger than bulk, drib or fall value |
|  | You can use this key when you set or change bulk setting |
|  | You can use this key when you set or change drip setting |
|  | You can use this key when you set or change free fall setting. |
|  | You can use this key, when you set the under weight error range. |
|  | You can use this key, when you set the over weight error range. |
|  | Current product's batch count and sub-total weight so far if you install interface |
|  | Print interface, you can print out all product's batch count and accumulate weight |
|  | You can use these number keys when you input various data |
|  | You can use this key when you delete wrong input data by number key. |
|  | You can use for final confirmation after input data, which you want to change by No. key |
|  | Set the display of the weight value to '0'. |
|  | Used to start the weighing operation. |
|  | Used to stop the weighing operation. |

| | |
|---|---|
|  | <p>If the lamp is turn on, the weighed product will be automatically discharged within few Minute after finishing batch process</p> |
|  | <p>If you press this key, when the batch process is finished, the discharge gate open And discharge the product</p> |
|  | <p>This key is for turning on / off the controller power</p> |

3-2-5. Combination Key

| | |
|---|---|
|  →  | <p>If you press "Sub-total key" then "Clear key" with blinking 3 times then current product's batch count and accumulated weight will be deleted</p> |
|  →  | <p>If you press "Gross-total key" then "Clear key" with blinking 3 times then current all products total batch count and accumulated weight will be deleted</p> |

3-3. Back Side



3-3-1. AC power input

| AC | 1 | 2 | 3 |
|----|---|---|-------|
| AC | R | T | Earth |

3-3-2. AC FUSE: 250V/7A 2EA

3-3-3. Serial Interface

| Interface | 1 | 2 | 3 |
|-----------|-----|-----|-----|
| RS-232 | RxD | TxD | GND |

3-3-4. Load Cell Terminal

| Terminal | 1 | 2 | 3 | 4 | 5 |
|-----------|------|------|------|------|--------|
| Load Cell | EXC+ | EXC- | SIG+ | SIG- | SHIELD |

3-3-5. External input Terminal

| Terminal | 1 | 2 | 3 | 4 | 5 | 6 |
|----------|-------|-----|------|-----------------|-------|------------------------|
| Input | I/COM | IN1 | IN2 | IN3 | I/COM | Discharge |
| | Com | RUN | STOP | Discharge Input | Com | Discharge Close sensor |

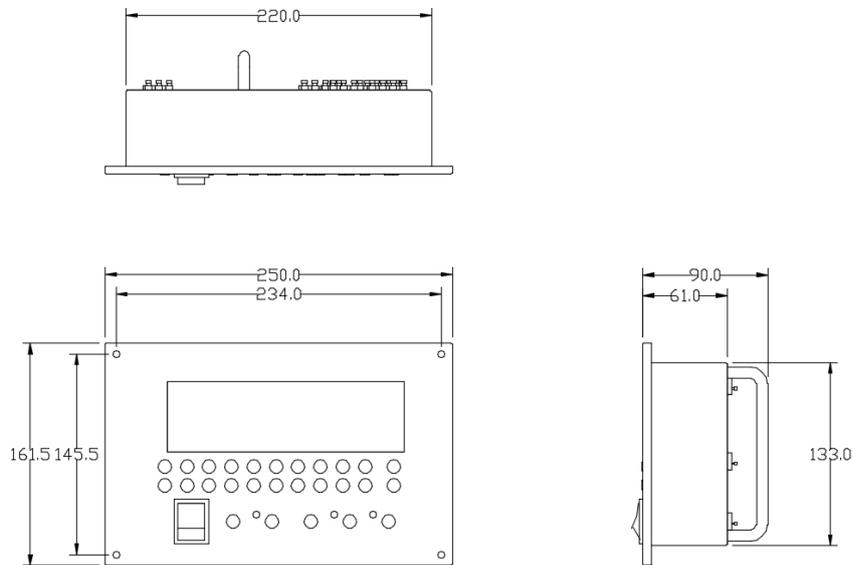
3-3-6. External Output

| Terminal | 1 | 2 | 3 | 4 | |
|--------------|----------|----------|-----------|-----------|-----------|
| Right Output | O/COM | 1-1st | 1-2nd | 1-3rd | |
| | Com | Bulk | Drib | Free Fall | |
| | 5 | 6 | 7 | 8 | 9 |
| | O/COM | Out1 | Out2 | O/COM | Discharge |
| | Com | Finish | Set value | Com | Discharge |

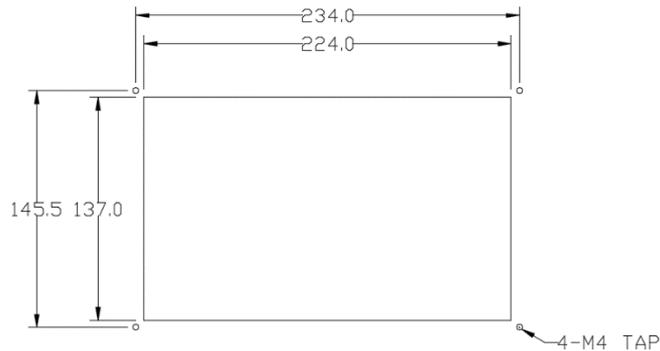
Single Packer Controller SA410DS

4. Install

4-1. Size (unit: mm)



4-2. Cutting Size (unit: mm)



4-3. Power Reset mode

- 1) When power on, left side of display showing version information and blinking 3 times.
- 2) Below picture is normal condition.



- 3) If there is some error, will be shown error code.

※ User can check error information on "6. Error Error condition".

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5. Set-up

5-1. Calibration

Calibration is the process of adjusting weight balance between "Real Weight" on the Load Cell and "Displayed weight of Indicator". When you replace Load Cell or Indicator, you have to do Calibration process once again.



- 1) Press the  key 3times for 3seconds.
- 2) Press the  at the Calibration

5-1-2. Decimal point and Division Setting



- 1) Make the division use the  key
(Division : 1, 2, 5, 10, 20, 50)
- 2) Make the Decimal point use the  key
(Decimal point: 0, 0.0, 0.00, 0.000)
- 3) Push the  key and save it

5-1-3. Setting "Capacity of weighing Scale"



- 1) Input max capacity with number key.
 - * Digit and decimal point must be fulfilled under the below condition. (division value / Max capacity value) cannot be over 1/20,000.
 - * If this condition is not fulfilled, " Err-1" will be displayed and move back to capacity setting mode..
- 2) Save & move to next step by press  key..

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5-1-4. SPAN setting



- 1) Input SPAN with number key
- ※ Balance weight should be bigger than 10% of maximum capacity or Er-005 displayed.



- 1) Save & move to next step by press  key.
- 2) Controller will calculate dead weight of scale part automatically about 10 seconds..



- 1) Load the balance weight.
- 2) Put  key, Calculate span value during 10~20 seconds.



- 3) When calibration is done, put  key and save it.

5-1-5. Calibration Error condition

| Status | Cause | Solution |
|----------|---|---|
| Err -001 | When Max capacity/digit value is over 20,000 | When Max capacity/digit value is under 20,000 |
| Err-004 | Standard weight value is over than Max Capacity | Re-write the load weight |
| Err-005 | Standard weight value is less than 10% of Max Capacity | Re-write the load weight |
| Err-009 | There is continuous vibration on the weighing part during calibration | Remove the vibration and check the load cell |
| Err-006 | When Calibration, it is excess than maximum A/D converting value | Check the load cell and weight |
| Err-007 | When Calibration, it is less than minimum A/D converting value | Check the load cell and weight |

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5-2. Function Setting

Function setting could set the indicator to operate perfectly with surrounding condition.

5-2-1. Starting F-FUNCTION Mode

| | |
|---|--|
|  | <p>1) Put  , 3 times in 3 seconds.</p> |
|  | <p>2) Put  key can be entered function setting.</p> |
|  | <p>※ The same picture of left side will be shown. (But, after #87 will be shown same as left side.)</p> |

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5-2-2. Set up Function

1) Way 1.

Put  key can be changed the next function number.

(F01_XX → F02_XX → F03_XX → . . . → F97_XX → F98_XX → F01_XX)

2) Way 2.



1) If you want to move to some function number, use the number key.

2)  can be moved exact function number.

5-2-3. How to change the function number.

1) Select the function setting part.

(Basically both sides of function setting value will be chosen.)

Use the number key for the setting number.

2) Put  key, "Accumulated weight" showing the "SAVE" and move to next step.

3) Press  key and back to main display.

※ Putting the value is over the limitation, "ERR-010" will be shown.

5-2-4. Function List

| No. | Subject | Default | Content |
|-----|--|---------|---|
| F01 | Weight-back up mode | 01 | 00 : Normal mode 01 : Weight back up mode(Zero) |
| F02 | Steady range | 08 | 01 ~ 99 (Unit: 0.25 gradation) |
| F03 | Steady condition check time | 10 | 01 ~ 99 (Unit: 0.1 seconds.) |
| F04 | Digital filter | 20 | 01: Weak vibration ~ 50: Strong vibration |
| F05 | Zero key operation range | 02 | 00: Active within 2% of max capacity 01: Active within 5% of max capacity 02: Active within 10% of max capacity 03: Active within 20% of max capacity 04: Active within 50% of max capacity 05: Active within 100% of max capacity 06: No limit |
| F07 | Zero key operation mode | 00 | 00: Always active 01: Active under steady condition only |
| F08 | Auto zero range | 00 | 00 ~ 99 (Unit: 0.25 gradation) |
| F10 | Auto zero at RUN | 01 | 00 : Disuse 01 : Use |
| F11 | Discharge gate sensor use or don't use | 01 | 00 : Disuse 01 : Use |
| F12 | Save set value | 00 | 00 : Disuse 01 : Use |
| F14 | Finish relay output delay time | 03 | 01 ~ 99 ((unit = 0.1sec) |
| F15 | Re-supply operation time in case of shortage | 00 | 01 ~ 99 (unit = 0.1sec) |
| F16 | Discharge gate Relay on time | 30 | 01 ~ 99 (unit = 0.1sec) |
| F17 | Re-weighing delay time | 15 | 00 ~ 99 (0: steady) (unit = 0.1sec) |
| F20 | Weighing count increase point | 00 | 00: Finish , 01: Discharge |
| F25 | Auto Discharge delay time | 20 | 01 ~ 99 (unit = 0.1sec) |
| F26 | Discharge at weighing Error | 00 | 00 : Disuse 01 : Use |
| F28 | Equipment No. setting (ID No.) | 01 | 01 ~ 99 |
| F31 | Under UNPASS/OVERLOAD state, weight display | 00 | 00 : Display 01 : No display |

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| No. | Subject | Default | Content |
|-----|--|---------|---|
| F33 | Buzzer sound (External input detection) | 00 | 00 : Buzzer sound 01 : No Buzzer sound |
| F34 | Key input delay time | 03 | 01 ~ 50 (Unit : 10milliseconds) |
| F35 | External input delay time | 10 | 01 ~ 50 (Unit : 10milliseconds) |
| F40 | External input left Discharge | 06 | 00: Disuse 02: RUN 03: Discharge input 04: Auto Discharge 05: Extract Discharge 06: Discharge gate close sensor input(Left) 07: Discharge gate close sensor input(Rightt) |
| F41 | External input Left #1 | 01 | |
| F42 | External input Left #2 | 02 | |
| F43 | External input Left #3 | 03 | |
| F44 | External input Right Discharge | 07 | |
| F45 | External input Right #1 | 04 | |
| F46 | External input Right #2 | 05 | |
| F47 | External input Right #3 | 00 | |
| F50 | Relay Output Standard Auto/ Manual Setting | 00 | |
| F51 | Relay output 1 step | 01 | 00: Disuse 01: Bulk 04: Finish 02: Drip 05: Pass weight Judge 03: Free Fall 06: Discharge |
| F52 | Relay output 2 step | 02 | |
| F53 | Relay output 3 step | 03 | |
| F54 | Relay output Discharge | 06 | |
| F55 | Relay output #1 | 04 | |
| F56 | Relay output #2 | 05 | |
| F64 | Parity / stop bit | 00 | |
| F65 | Communication speed | 02 | 00 : 2,400bps 05 : 28,800bps 01 : 4,800bps 06 : 38,400bps 02 : 9,600bps 07 : 57,600bps 03 : 14,400bps 08 : 76,800bps |
| No. | Subject | Default | Content |

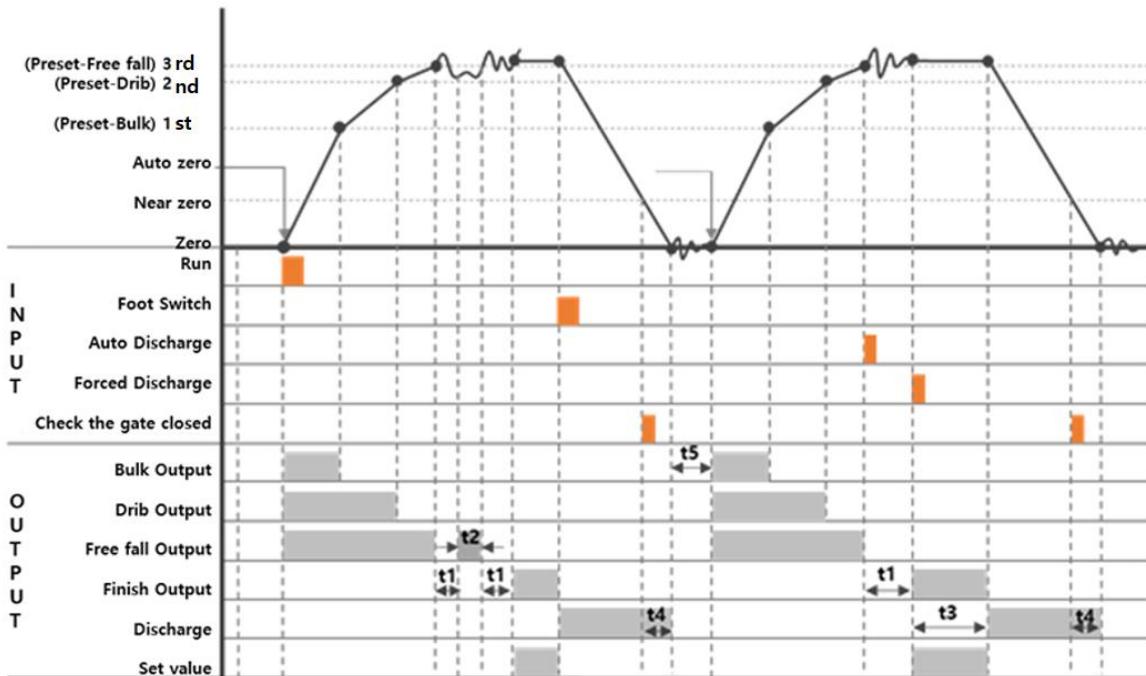
| | | | | |
|------------|--|--------|--|-----------------|
| | | | 04 : 19,200bps | 09 : 115,200bps |
| F66 | Communication mode | 00 | 00: Simplex / Stream mode | |
| F67 | Format under stream mode | 00 | 00: Format 1 (20Byte) | |
| F68 | Transference under stream mode | 00 | 00 : Continuously 01: Single time output after weighing finish | |
| F69 | "Check-Sum" under command mode | 00 | 00 : Disuse 01 : Use | |
| F84 | Near zero output setting under tare on state | 00 | 00 : Zero output 01 : Actual zero output except Tare weight | |
| F87 | Zero range check and Modification fo Right | 30.0 | Use the number key and save it to use enter key | |
| F90 | Zero range check and Modification of Left | 30.0 | Use the number key and save it to use enter key | |
| F94 | DATE(Y,M,D) check / modification | 180101 | | |
| F95 | TIME(H,M,S) check/ modification | 010101 | | |
| F96 | Function list factory reset | |  key -> "YES"-> press  , then reset | |
| F97 | Factory reset | |  key->"NO" press  , then keep the current data | |



The "F" setting value can be changed and saved separately for "left weighing base" and "right weighing base"

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◆ Time Chart



| Time | Fun | Description | Time | Fun | Description |
|------|-----|-----------------------------------|------|-----|------------------------------|
| t1 | F14 | Finish weighing output delay time | t4 | F16 | Discharge gate output time |
| t2 | F15 | Not enough re-supply time | t5 | F17 | Re-weighing start delay time |
| t3 | F25 | Discharge delay time | | | |

- 1) After weighing [Steady weight ≤ (Pre-set-Free fall)], 3 steps gate re-running and re-supply. After this step the weighing will be finished.
- 2) Discharge has Auto/Manual mode and user can check with lamp turn on/off. Manual discharge starts when the foot switch is pressed after completion of weighing, and automatic discharge proceeds after time t3 after completion of weighing.
- 3) When user press the "Stop", immediately stop no matter it's running or not. Run signal will be put, then it will be started again.
- 4) When F26 is set to '1' at the time of weight error, the foot switch is not output to the foot switch input but is discharged only by the forced exhaust input.
- 5) When forced re-entry, re-entry will return to the state before forced release.
- 6) If the weighing container is empty even after the power is supplied and the previous condition is met, weighing starts.

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5-3-1. How to Enter



- 1) Press  key 3 times in 3 seconds.
- 2) "SET.CAL" will be shown.



- 3) Put  key and can enter the test mode.

5-3-2. FND Test

1

- 1) After enter the test mode and press .
- 2) Check the FND error or not.
- 3) Press  key and back to main display.

5-3-3. External INPUT Test



2

- 1) After enter the test mode and press .
- 2) Check the error with using external INPUT.
- 3) Press  key and back to main display.

Single Packer Controller SA410DS

5-3-4. Relay output test



- 1) Enter the test mode, press **3** key.
- 2) Put  key and out of the test mode.

| 1 | 2 | 3 | 4 | 5 | 6 | 0 |
|----------------|----------------|----------------|----------------|----------------|----------------|--------------------------|
| OUT1 ON/OFF | OUT2 ON/OFF | OUT3 ON/OFF | OUT4 ON/OFF | OUT5 ON/OFF | OUT6 ON/OFF | OUT1~6 Auto Output |

5-3-5. Key Test



- 1) Enter the test mode.
- 2) Press **4** key, you can enter the test mode.
- 3) Press the 'KEY', you can check the error situation on the display.
- 4) After the test, press the  and out of the test mode.

6. Error and treatment

6-1. Error & treatment during Loadcell installation

| Problem | Cause | Treatment |
|---|---|--|
| Weight Value is unstable | 1. Load cell broken | Measure input/output resistance of Load cell |
| | 2. Load Cell isolation resistance error | Measure Load cell isolation resistance. |
| | 3. Weighing part touches other devices or some weight is on the weighing part | Clering weighing part |
| | 4. Analog PCB module Error | Check AD Module and change module. |
| | 5. Load Cell cable Error | Measure Load cell calbe isolation resistance |
| Weight Value is increased regular rate, but not return to "Zero | 1. Load cell Error | Measure Load cell isolation resistance. |
| | 2. Load Cell connecting Error | check Load cell connecting |
| | 3. Load Cell cable Error | Load cell cable Open/Short Test |
| | 4. Analog module Error | Check Analog Module and change module. |
| "Unpass" Display | 1. Load cell broken | Measure input/output resistance of Load cell |
| | 2. Power was "ON" when some weight is on the load cell. | Remove weight on the Load cell |

6-2. Error code

| Problem | Cause | Treatment |
|---------------|---|--|
| AD-Err | Load cell broken | Measure input/output resistance of Load cell |
| UNPASS | Power was "ON" when some weight is on the load cell. | Remove weight on the Load cell |
| OL | Loading over than Max Capacity | Remove over loaded weight |
| Err-01 | After finish discharge, the re-start weighing process, at this moment current weight on the scale over to EMPTY range ㄷ | Remove over loaded weight |
| Err-02 | After finish discharge, the re-start weighing process, at this moment discharge gate open or when BULK, DRIB, FREE FALL process going suddenly discharge gate open. | Check the discharge gate |

8 . WARRANTY

| WARRANTY CERTIFICATION | | |
|---|-----------------------------|---|
| <p>This product is passed SEWHACNM strict quality test.</p> <p>If there is defect of manufacturing or abnormal detection within warrantee period, please contact our Agent or Distributor with this Warrantee certificate. Then, we will repair or replace free of charge.</p> | | |
| WARRANTY CLAUSE | | |
| <p>1. The Warrantee period, we can guarantee, is one (1) year from your purchasing date</p> <p>2. Warrantee Exception Clause</p> <ul style="list-style-type: none"> - Warrantee period is expired. - Any kinds of Mal-function or defection caused by Modification or Repair without Sewhacnm's permission. - Any kinds of Mal-function, Defection, or External damage, caused by operator - Any kinds of Mal-function, Defection, caused by using spare part from Non-Authorized Distributor or Agent. - Any kinds of Mal-function, Defection, caused by not following Warnings or Cautions mentioned on this manual. - Any kinds of Mal-function, Defection caused by "Force Majeur", like Fire, Flood. - Without presentation of this "Warrantee Certification". <p>3. Other</p> <ul style="list-style-type: none"> - Any kinds of "Warrantee Certification" without authorized Stamp is out of validity | | |
| <p>Manufacturer : SEWHACNM Co.,Ltd. #504, 302Dong, 397, Seokcheon-ro, Ojeong-Gu, Bucheon-Si, Gyunggi-Do, KOREA Tel : +82 70-4754-6140 Fax :+82 32-624-0065 sales@sewhacnm.co.kr www.sewhacnm.co.kr MADE IN KOREA</p> | Product | Single Packer Controller |
| | Model | SA410DS |
| | Serial No. | |
| | AUTHORIZED STAMP |  |