



Air Cushion Machine Operation Manual

Navy Seal



The Navy Seal is a high-speed air cushion machine that makes bubble film, pillows, cushions and tubes on demand. It has a brushless motor for stable running and long service life, with full inflation, strong seal lines and speeds of up to 28 m/min.

Please read this manual carefully before installing and using the machine, and keep it safe.

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1.0 About this manual

This manual helps you identify the parts of the Navy Seal, understand how it works and solve basic faults.

Symbols used on the machine and in this manual:



Electric shock. Uninsulated parts inside the machine. Touching them may cause an electric shock.



High temperature. Hot surfaces. Do not touch them.



Hand clamping. Take care: hands can be trapped while the machine is running.



Emergency stop. In an emergency, press this button to stop the machine quickly.

2.0 Safety instructions

2.1 Read this manual fully

Please read and make sure you understand all the information in this manual before using the machine.

2.2 Before operating the machine, confirm that

- the operator has been fully trained by the authorised dealer or a technician;
- the operator has read and understood all the safety signs on the machine;
- the power supply meets the machine's requirements and is properly earthed.



Warning

Improper earthing may cause an electric shock.

Do not open the machine cover. Only authorised technicians or trained maintenance staff may remove it.





Warning

Take care when loading film. Press the feed button while gently pulling the film.
Keep fingers, hair, jewellery and clothing away from the sealing roller.
The sealing rollers and seal line are hot and may cause burns.

2.3 Before maintenance or repair

- Switch off the machine and unplug it from the power supply.

Important: the Navy Seal is designed for use with Forever Green Packaging film. We support it for as long as it is being used with our film. See Section 14, Warranty and support.



Warning

Do not attempt any repair or modification other than those described in Section 13, Maintenance & repair. Repairs should be carried out by us, an authorised distributor or maintenance staff trained by us.
Open the belt cover only to replace the belts as shown in this manual.

2.4 Check the machine regularly to make sure that

- no wires are scratched, damaged or broken;
- no debris is left on the belt;
- all controls and the display work normally.



Warning

If the machine behaves differently from this manual, switch it off immediately, unplug it and contact our technical service team.





2.5 Noise

The maximum running noise of the Navy Seal is 95 dB. Please check that this is acceptable under your local regulations.

2.6 Environmental conditions

- Storage temperature: machine 0–43 °C; film 0–43 °C.
- Operating temperature: machine 16–43 °C; film 16–43 °C.



Warning

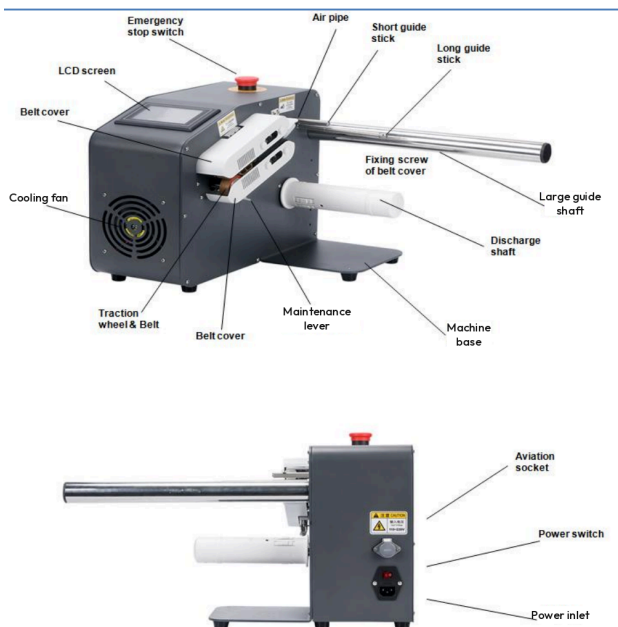
The film only seals well within the temperature range above. Outside it, seal quality may suffer and adjustments may be needed.

2.7 Potential risks

Most moving parts are covered by the belt cover, but some parts are exposed. Take care while the machine is running.



3.0 Navy Seal overview



(Fig. 1)

Note: the standard configuration does not include an aviation socket. If you use the machine with a winder table, the socket is a separate purchase.

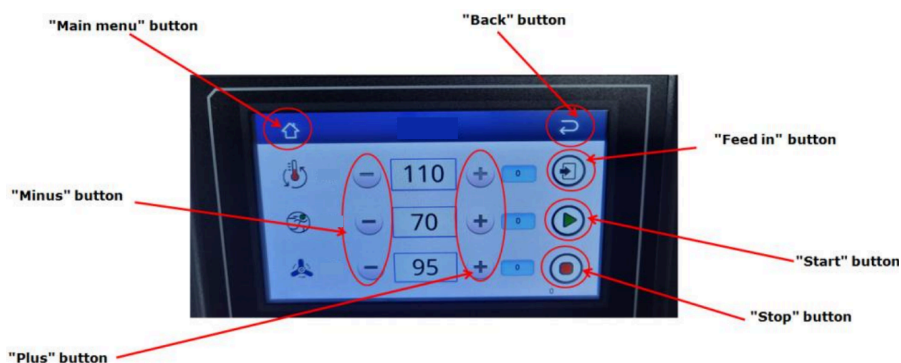
4.0 Operation panel and key functions

4.1 Main menu and sub-menus



(Fig. 2)

4.2 Operation panel



(Fig. 3)



5.0 Specification

1. Appearance

Item	Value
Dimensions (L × W × H)	400 × 165 × 310 mm
Package dimensions (L × W × H)	510 × 410 × 460 mm
Net weight	17 kg
Gross weight	19 kg

2. Electrical performance

Item	Value
Model	Navy Seal
Rated power	450 W
Frequency	50 / 60 Hz
Speed	Up to 28 m/min
Input voltage	AC 220 V by default (110 V adjustable)
Heat-seal temperature	90–150 °C
Air flow	Up to 700 L/min
Electric shock protection class	I





6.0 Packing list

Item	Qty
Navy Seal machine	1
Discharge shaft	1
Power cord	1
Hex (Allen) key	1
Guide stick	3
Spare belts	3
High-temperature resistant tape	8
Blades	5

7.0 Installation

7.1 Fit the discharge shaft, short guide stick, long guide stick and large guide shaft in the positions shown in Fig. 1. Use the hex key.

7.2 Connect and switch on the power and put the film roll on the discharge shaft. Pull the film so that the air pipe enters the film inlet. Press **Feed in** while gently pulling the film through the belt cover. Then press **Start** to inflate.

7.3 You can also watch the installation video: Main menu › Parameter › Installation & Maintenance › Installation Video.

Note: if the power switch light is on but the display is off, check whether the emergency stop switch has been pressed.





8.0 Recommended settings

These are starting points. Speed and air volume must be matched to the film you are using (see 10.8).

8.1 200mm x 100mm Cushion

Film thickness	Temperature (°C)	Speed setting	Air setting
18 µm	110	70	40
20 µm	112	70	40

8.2 200mm x 200mm Cushion

Film thickness	Temperature (°C)	Speed setting	Air setting
18 µm	110	70	60
20 µm	112	70	60

8.3 400mm Bubble (8 Row), 400 × 170 mm

Film thickness	Temperature (°C)	Speed setting	Air setting
18 µm	110	70	95
20 µm	112	70	95

8.4 400mm Quilt (4 Row), 400 × 320 mm

Film thickness	Temperature (°C)	Speed setting	Air setting
18 µm	110	70	70
20 µm	112	70	70

* Please contact us for settings for any films not listed here.



9.0 Common faults and solutions

Fault	Solution
The film does not move forward	1. Check that the hook switch is in place. 2. Reduce the air. 3. Check the blade for rust or chips and replace it if damaged. 4. Check the traction wheel and belt for debris and clean them.
The seal line is broken (temperature too high)	Reduce the temperature.
Air leaks or the film is not sealed properly	Increase the temperature.
The film comes out of the machine	Reduce the air.
The belt slips	Check the traction wheel and belt for debris and clean them.
The power switch light is on but the display is off	Check whether the emergency stop switch has been pressed. If so, pull it up to release it.

If you cannot fix a fault, please contact your authorised dealer or a service engineer.

10.0 Important points

10.1 Do not use the machine in a humid environment.

10.2 Before operating the machine, note the following:

- If the machine is not properly earthed, it may cause an electric shock.
- Do not open the protective or access cover. Only the manufacturer or authorised dealer service staff may open it.
- Keep fingers, hair, clothing and jewellery away from the traction wheel when the machine is running or when loading film, so they are not caught.

10.3 Inflated cushions are for packaging only. Do not use them as floats, pillows or toys.



10.4 Do not load film rolls heavier than 7 kg. Do not press hard on the machine when loading film, and do not lean on it.

10.5 The machine and the film generate static electricity while running. The operator should not work barefoot or in slippers, as this can cause uncomfortable static shocks.

10.6 If the film runs unevenly or sticks after long use, replace the blade promptly.

10.7 If the seal edge is weak or damaged after long use, check the temperature setting and the high-temperature tape, and replace the tape if it is damaged.

10.8 Speed and air volume must work together. Different films need different settings, and there are no fixed values, so adjust them to suit your film.

10.9 Do not start the machine without film loaded.



Warning

Improper earthing may cause an electric shock.



Warning

Electrical supply: rated voltage AC 220 V (110 V adjustable); average working current 2 A, peak current 3.5 A; 50 / 60 Hz; rated power 450 W.

Use a single-phase, three-wire power cord with a reliable earth connection. Without proper earthing, static electricity cannot discharge and the operator may feel an electric shock. Extension leads and power strips can also increase static electricity, which may cause operating problems.

11.0 Film choice and storage

11.1 Please use film supplied by Forever Green Packaging. Other film may cause bags to burst or reduce packing performance, and could damage the machine. See Section 14 for our support terms.

11.2 Store film at 0–43 °C. Outside this range, film performance may be affected.

11.3 Use the machine and film at 16–43 °C. Outside this range, film performance may be affected.





12.0 Machine structure

12.1 Main power switch. On the back of the machine. Turns the machine on and off.

12.2 Touch-screen control panel. All parameter settings, language, start, stop, feed and other functions are controlled from the screen.

12.3 Power cord. Plug it into a suitable outlet before starting the machine.

12.4 Side cover plate. Behind it are the machine's electrical and mechanical parts. Do not open it unless you are an authorised technician or trained maintenance staff.

12.5 Discharge shaft. Holds and supports the film roll.

12.6 Side seal unit. Holds the air pipe, blade and heating module. It inflates and seals the film.



Warning

The roller is very hot: risk of burns.

Keep clear of the rollers so you are not drawn into the machine.

12.7 Film roll. Film with an air inlet, which the Navy Seal inflates and seals.

12.8 Emergency stop switch. Do not use it as a pause or stop button.



13.0 Maintenance and repair

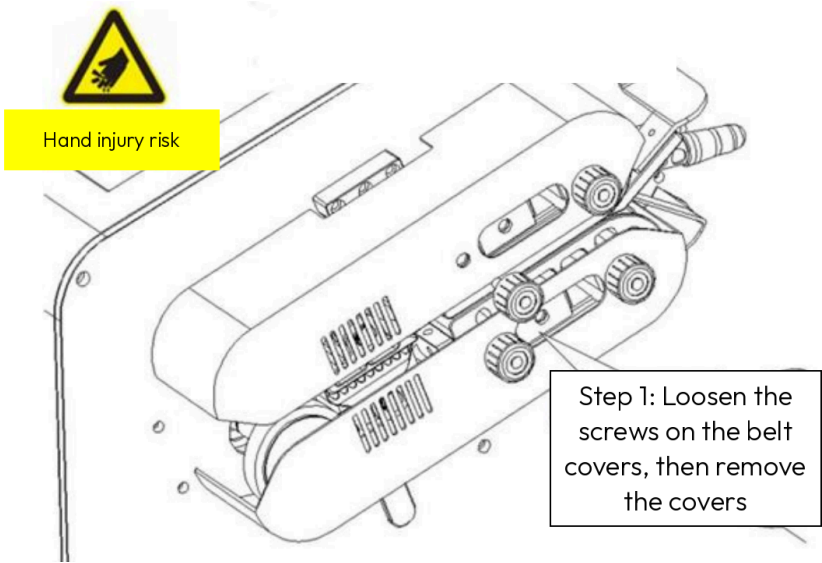
13.1 Preventive maintenance

Before maintaining or repairing the Navy Seal, switch it off and unplug the power cord.

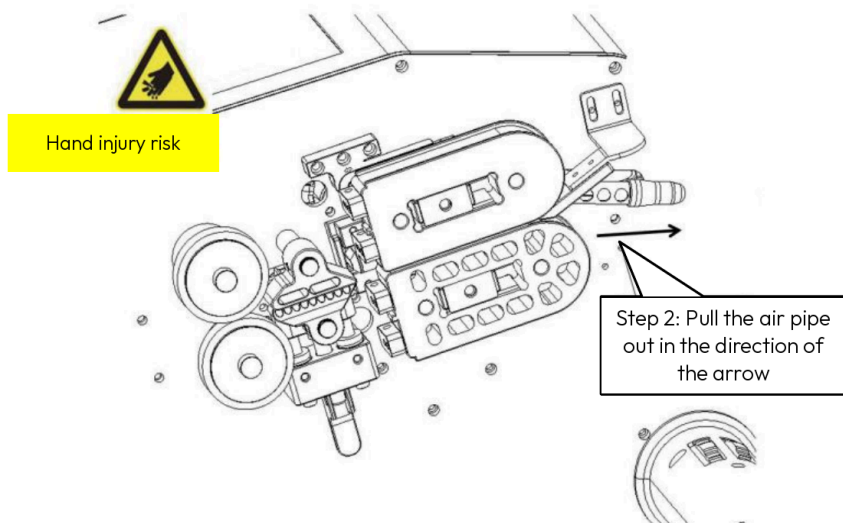
Interval	Task
Monthly	Open the belt cover and blow out dust and debris. Check the machine parts for abnormal wear.
Yearly	Contact your authorised dealer or our technical service team to arrange an on-site inspection.

13.2 Blade replacement

13.2.1 Loosen the 4 captive screws on the upper and lower belt covers and remove the covers.



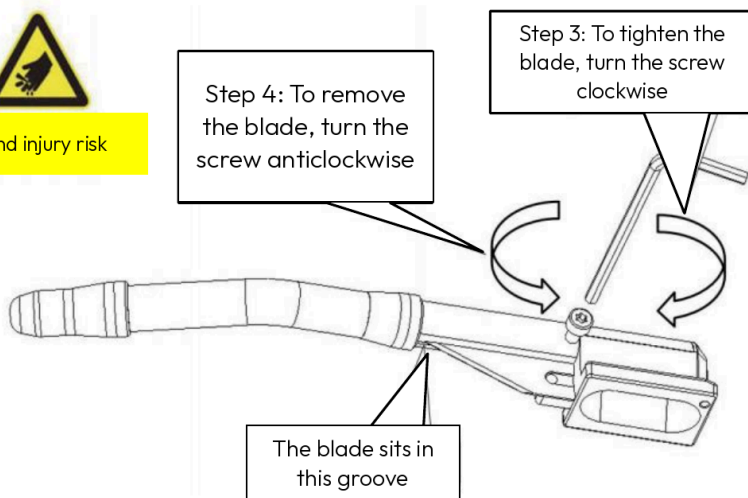
13.2.2 Pull out the air pipe in the direction of the arrow.



13.2.3 To tighten the blade, turn the fixing screw on the air pipe clockwise. To remove the blade, turn it anticlockwise. Seat the blade in its groove and make sure the tip of the blade is fully inside the groove.



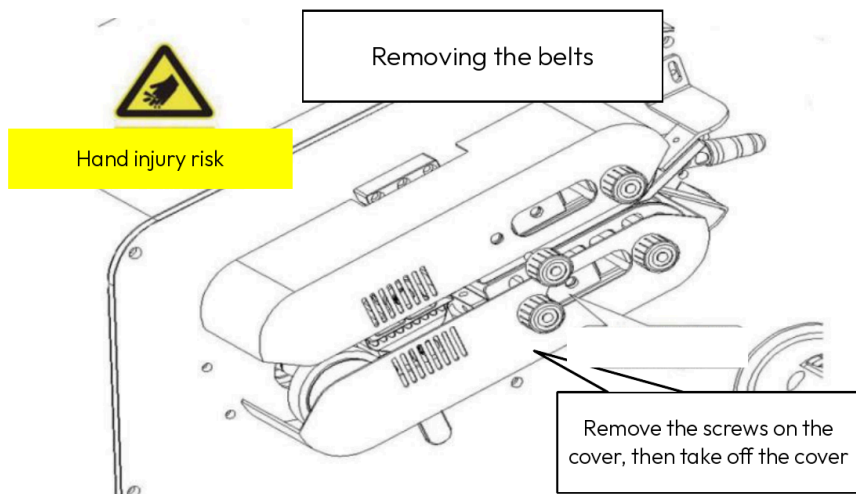
Hand injury risk



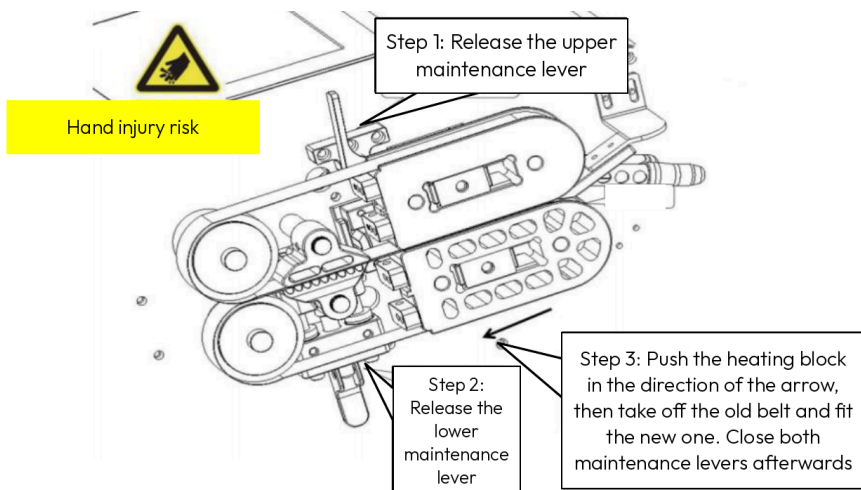
13.2.4 After replacing the blade, push the air pipe back into position.

13.3 Belt replacement

13.3.1 Loosen the captive screws of the protective cover and remove the cover.

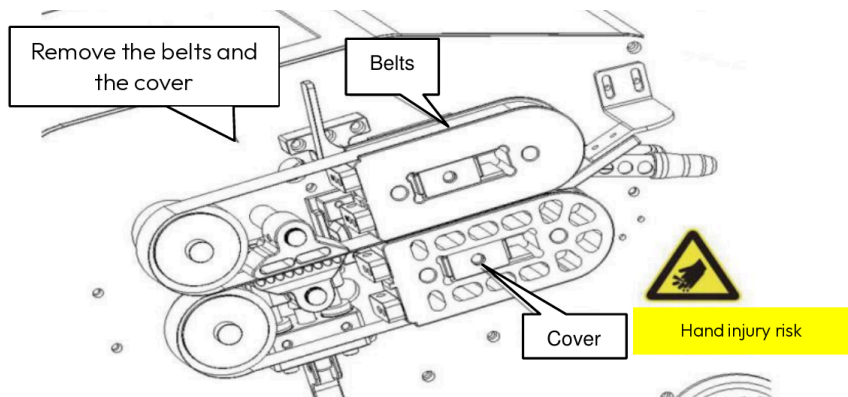


13.3.2 Release the upper and lower maintenance levers. Releasing them makes it easier to swap wearable parts such as the wheels and belts. Push the heating block towards the pulley, remove the old belt and fit the new one. Close both maintenance levers and refit the cover.

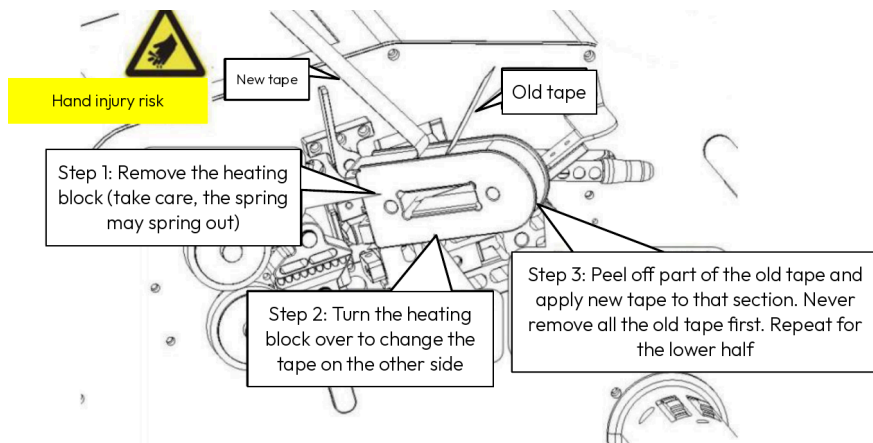


13.4 High-temperature tape replacement

13.4.1 Remove the belt cover and push the heating block towards the pulley to loosen the belt. Remove the belt, then use the hex key to loosen the screws and remove the cover in the middle of the heating block.



13.4.2 Remove the heating block (take care, as the spring may spring out). Peel off the old high-temperature tape and fit new tape, then refit the heating block, belt and belt cover in turn.



Tip: you can also watch the maintenance videos: [Main menu](#) › [Parameter setting](#) › [Installation & After-sales](#) › [After-sales video](#).



14.0 Warranty and support

Purchased machines

Machines purchased from Forever Green Packaging carry a **1 year warranty from the install date**. Parts needed after the first year may be chargeable.

Machines on loan

Machines supplied on loan are serviced at no charge for as long as the loan continues.

Film

The Navy Seal is designed for use with Forever Green Packaging film. **We support it for as long as it is being used with our film.** Using other film may affect seal quality and is outside our support.

Getting help

If you have a problem that this manual does not solve, contact us using the details on the back page, and have your machine model and a description of the fault ready.



Need help? Get in touch

Website: forevergreenpackaging.com

Email: info@forevergreenpackaging.com

Phone: 07973 818205

Forever Green Packaging is registered in England and Wales

