BETTER PACKAGES, Inc.

A WHOLLY OWNED SUBSIDIARY OF ipg

USER MANUAL
RSA 2024-WAT-EU

For Serial Numbers:
TM905 XX X XXX

ipg intertape polymer group®

ipg intertape polymer group®

www.itape.com
800-474-8273

REV 2 10122022

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Chapter 1
GENERAL INFORMATION

1.1 REVISION CONTROL

REV00 .....Initial Release

1.2 TECHNICAL SUPPORT

This is the Interpack Model AUTO H_2O Random Semi-Automatic-WAT-EU (RSA2024-WAT-EU) Side-Belt Case Sealer you ordered. It has been set up and tested in our factory with Intertape manufactured water activated tapes. If any problems occur when setting up or operating this equipment, please contact the authorized distributor from where you purchased this item.

If contact with the authorized distributor is not possible, Interpack Technical Support is available. Should the need to contact Interpack Technical Support arise, please have the Case Sealer model number and serial number on hand. This information can be found on the nameplate of the side panel of the machine. Interpack Technical Support is available during normal business hours (Eastern Time).

- **PHONE: 800-474-8273, Option 3**

If you have a technical question that does not require an immediate response, you may contact Interpack by fax.

- **FAX: 800-462-1293**

Technical support may also be contacted via email at the address below:

- **EMAIL: Machsupp@itape.com**

1.3 REPLACEMENT PARTS

Order parts by item number, part description, and quantity required. Replacement parts are available from your authorized Interpack distributor exclusively.

Should you require assistance selecting the correct part, you may call:

Intertape Polymer Group
Interpack Machinery

Tel: 1-800-474-8273, Option 3
Fax: 1-800-462-1293

MODEL: _____

SERIAL NUMBER: _____

DISTRIBUTOR PURCHASED FROM: _____

DATE OF PURCHASE: _____

1.4 FIELD SERVICE ASSISTANCE

This machine is designed to provide years of trouble-free operation. If any problems arise with this machine during the normal course of operation, your properly trained and qualified internal service personnel should be able to repair any issues after consulting Chapter 6, Troubleshooting.

Service support is available from your authorized Interpack distributor at additional cost if the problem cannot be remedied after consulting the Troubleshooting chapter of this manual.

1.5 WARRANTY

EQUIPMENT WARRANTY AND LIMITED REMEDY: The following warranty is made in lieu of all other warranties, express or implied, including but not limited to the implied warranty of merchantability, the implied warranty of fitness for a particular purpose, and any implied warranty arising out of a course of dealing, a custom or usage of trade:

Intertape sells its Interpack Tape Heads, Case Tapers, and Case Erectors with the following warranties:

1. The HSD® 2000 Tape Heads' knife blades, springs and wipe down rollers will be free from all defects for a period of ninety (90) days.
2. All other HSD® 2000 Tape Head parts will be free from all defects for one (1) year after delivery.
3. Water Activated Tape Head blades will be free from defects for ninety (90) days after delivery.
4. Drive Belts will be free from defects for ninety (90) days after delivery.
5. The Gear Motors will be free from defects for one (1) year after delivery.
6. All other components for Case Tapers and Case Erectors will be free from defects for one (1) year after delivery.

If any part is proven defective within its warranty period, then the exclusive remedy and Intertape's and the seller's sole obligation shall be, at Intertape's option, to repair or replace the part, provided the defective part is returned immediately to Intertape's factory or an authorized service station designated by Intertape.

A part will be presumed to have become defective after its warranty period unless the part is received or Intertape is notified of the problem no later than five (5) calendar days after the warranty period.

If Intertape is unable to repair or replace the part within a reasonable time, then Intertape, at its option, will replace the equipment or refund the purchase price. Intertape shall have no obligation to install the repaired or replacement part.

Intertape shall have no obligation to provide or pay for the labor required to install the repaired or replacement part. Intertape shall have no obligation to repair or replace (1) those parts failing due to: operator misuse, carelessness, or due to any accidental cause other than equipment failure, or (2) parts.

1. Failure or damage is due to misapplication, lack of proper maintenance, abuse, improper installation or abnormal conditions such as temperature, moisture, dirt or corrosive matter, etc.
2. Failure due to inadequate cleaning, improper operating environment, improper utilities or operator error.
3. Failure due to operations above the rated capacities, or in any other improper manner, either intentional or otherwise.

4. Failure is due to equipment, which has been altered by anyone other than an authorized representative of Intertape Polymer Group.

5. Failure is due to an attempt by the purchaser to correct alleged defective equipment. In this event the purchaser is responsible for all expenses incurred.

LIMITATION OF LIABILITY: Intertape and seller shall not be liable for direct, indirect, special, incidental or consequential damages based upon breach of warranty, breach of contract, negligence, strict liability or any other legal theory.

The foregoing Equipment Warranty and Limited Remedy and Limitation of Liability may be changed only by written agreement signed by authorized officers of Intertape and seller.

1.6 DESCRIPTION OF RSA2024-WAT-EU CASE SEALER

This machine is designed to provide years of trouble free operation. If any problems arise with this machine during the normal course of operation, your properly trained and qualified internal service personnel should be able to repair any issues after consulting the Troubleshooting section of this manual.

Figure 1-1 RSA2024-WAT-EU Case Sealer

The RSA2024-WAT-EU Case Sealer is designed to apply Intertape brand water-activated tape to the top and bottom center seam of regular slotted corrugated cartons. The RSA2024-WAT-EU Case Sealer is manually adjustable to a random variety of case sizes (see Carton Specifications, page 3-3). The RSA2024-WAT-EU Case Sealer features an enclosure for added safety and reversible operator controls to facilitate its adaptation into an existing conveyor line.

1.7 OPTIONAL EQUIPMENT

Figure 1-2 Optional Equipment

Chapter 2
IMPORTANT SAFEGUARDS

2.1 SAFETY LABELS

There are a number of safety labels used on the RSA2024-WAT-EU Case Sealer. These labels are placed at different locations on the machine to warn operators and service personnel of possible dangers (refer to Figure 2-1). Please read the labels on the machine and the following safety precautions before using the machine.

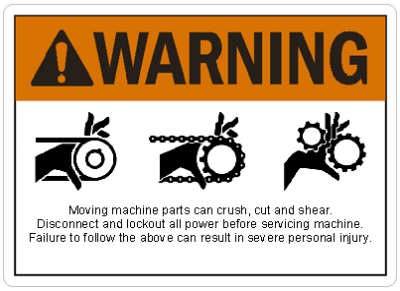
- ✓ **Read this manual for other important safety operating and service information.**
- ✓ **Only trained personnel are to operate machine.**
- ✓ **Only fully qualified technicians are to service this machine.**
- ✓ **Wear safety glasses.**
- ✓ **Shut off power to machine before adjusting machine or loading & threading tape heads.**
- ✓ **Disconnect electrical power and compressed air (where applicable) before servicing.**
- ✓ **Follow Lock Out/Tag Out Procedures BEFORE servicing any machinery.**
- ✓ **All covers and guards must be in place before operating.**
- ✓ **Stay clear of moving parts which can shear and cut.**

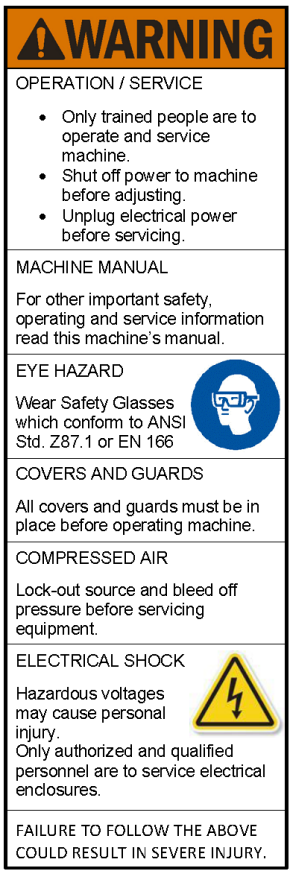
Note: Should any of the safety labels placed on the Case Sealer be damaged or destroyed, replacements are available through your distributor.

2.2 SAFETY LABEL PLACEMENT

Figure 2-1 Safety Label Placement

2.3 SAFETY LABEL DESCRIPTIONS

The label shown is affixed to the upper tape head assembly on both sides of the machine. It warns operators and service personnel of the presence of the cutting blade that may not be visible. Caution should be exercised when approaching this area.	
The label shown is affixed to the upper tape head assembly on either side of the machine. It warns operators and service personnel of the presence of the cutting blade that may not be visible. Caution should be exercised when approaching this area.	
The label shown is affixed to the bridge above the vertical intake. It warns the operator of potential pinch points between the top and bottom of the case. Keep hands away from this area when processing a case.	
The label shown is located on the in-feed and exit ends of the machine belt drives. The label warns the operators and service personnel of the pinch points at each end of the belt drives.	
The label shown is affixed to the electrical control box. The label warns the service personnel to unplug the power supply before attempting any service work on the case sealer.	
The label shown is affixed to the electrical control box. The label advises service personnel to connect the machine to a properly grounded outlet.	

The label shown is located on the side of the column. This label provides convenient safety instructions for the operator and service personnel in the operation of the Intertape Case Sealing Equipment.	
The label shown is located on the in-feed end of the machine. The label advises personnel about the dangers of the machine due to compressed air used in the system. Be aware of warnings and proper procedures when running and/or servicing the machine.	
The label shown is located on the gear side of the machine. The label warns the operators and service personnel of the pinch points.	

The label shown is located on the chain side of the machine. The label warns the operators and service personnel of the pinch points.	
The label shown is located on the side of the outfeed table. The label warns the operators and service personnel to keep fingers clear of lower tape mandrel.	

Note: Should any of the safety labels placed on the Case Sealer be damaged or destroyed, replacements are available through your distributor.

2.4 EXPLANATION OF SIGNAL WORD CONSEQUENCES

⚠ **WARNING:** Indicates a potentially hazardous situation that, if not avoided, could result in death or serious injury or property damage.

⚠ **CAUTION:** Indicates a potentially hazardous situation that, if not avoided, could result in minor or moderate injury or property damage.

⚠WARNING

- **To reduce the risk associated with mechanical, pneumatic, and electrical hazards:**
  a. Read, understand, and follow all safety and operating instructions before operating or servicing the case sealer.
  b. Allow only properly trained and qualified personnel to operate and service this equipment.
- **To reduce the risk associated with pinches, entanglement, and hazardous voltage:**
  Turn electrical supply off and disconnect before performing any adjustments, maintenance, or servicing of the machine or taping heads.
- **To reduce the risk associated with pinches and entanglement hazards:**
  a. Do not leave the machine running while unattended.
  b. Turn the machine off when not in use.
  c. Never attempt to work on any part of the machine, load tape, or remove jammed boxes from the machine while the machine is running.
- **To reduce the risk associated with hazardous voltage:**
  Position electrical cord away from foot and vehicle traffic.
- **To reduce the risk associated with sharp blade hazards:**
  Keep hands and fingers away from tape cutoff blades. Blades are extremely sharp.
- **To reduce the risk associated with fire and explosion hazards:**
  Do not operate this equipment in potentially flammable/explosive environments.
- **To reduce the risk associated with muscle strain:**
  a. Use the appropriate rigging and material handling equipment when lifting or repositioning this equipment.
  b. Use proper body mechanics when removing or installing taping heads that are moderately heavy or may be considered awkward to lift.

⚠CAUTION

- **To reduce the risk associated with pinch hazards:**
  a. Keep hands clear of the upper head support assembly as boxes are transported through the machine.
  b. Keep hands, hair, loose clothing, and jewelry away from box compression rollers.
  c. Always feed boxes into the machine by pushing only from the end of the box.
  d. Keep hands, hair, loose clothing, and jewelry away from moving belts and taping heads.

2.5 OPERATOR SKILL LEVEL DESCRIPTIONS

Important: The area supervisor must ensure that the operator has been properly trained on all machine functions before operating the machine.

2.5.1 Skill "A" Machine Operator

This operator is trained to use the machine with the machine controls. This operator can feed cases into the machine, make adjustments for different case sizes, change tapes, and start/stop, and re-start production.

2.5.2 Skill "B" Mechanical Maintenance Technician

This technician is trained to use the machine as the machine operator, and is able to work with the safety protection disconnected, check and adjust mechanical components, perform maintenance operations, and repair the machine. He is not allowed to work on live electrical components.

2.5.3 Skill "C" Electrical Maintenance Technician

This technician is trained to use the machine as the machine operator, and is able to work with the safety protection disconnected, check and adjust mechanical components, perform maintenance operations, and repair the machine. He is allowed to work on live electrical panels, terminal blocks, and control equipment.

2.5.4 Skill "D" Manufacturer's Technician

Skilled technician sent by the manufacturer, or its agent, to perform complex repairs or modifications, when agreed to by the customer.

Operator's Skill Level Required to Perform the Following Tasks on the Machine

Operation	Machine Condition	Operator Skill Level	Number of Operators
Machine Installation & Set-Up	Running with Safety Protections Disabled	B & C	2
Tape Roll Replacement	Stopped by Pressing the Emergency Stop (E-Stop) Button	A	1
Blade Replacement	Electrical Power Disconnected	B	1
Drive Belt Replacement	Electrical Power Disconnected	B	1
Ordinary Maintenance	Electrical Power Disconnected	B	1
Extraordinary Mechanical Maintenance	Running with Safety Protections Disabled	D	1
Extraordinary Electrical Maintenance	Running with Safety Protections Disabled	C	1

Notes

Chapter 3
SPECIFICATIONS

3.1 MACHINE DIMENSIONS

Machine Weight: 544kg (1200 lbs) crated

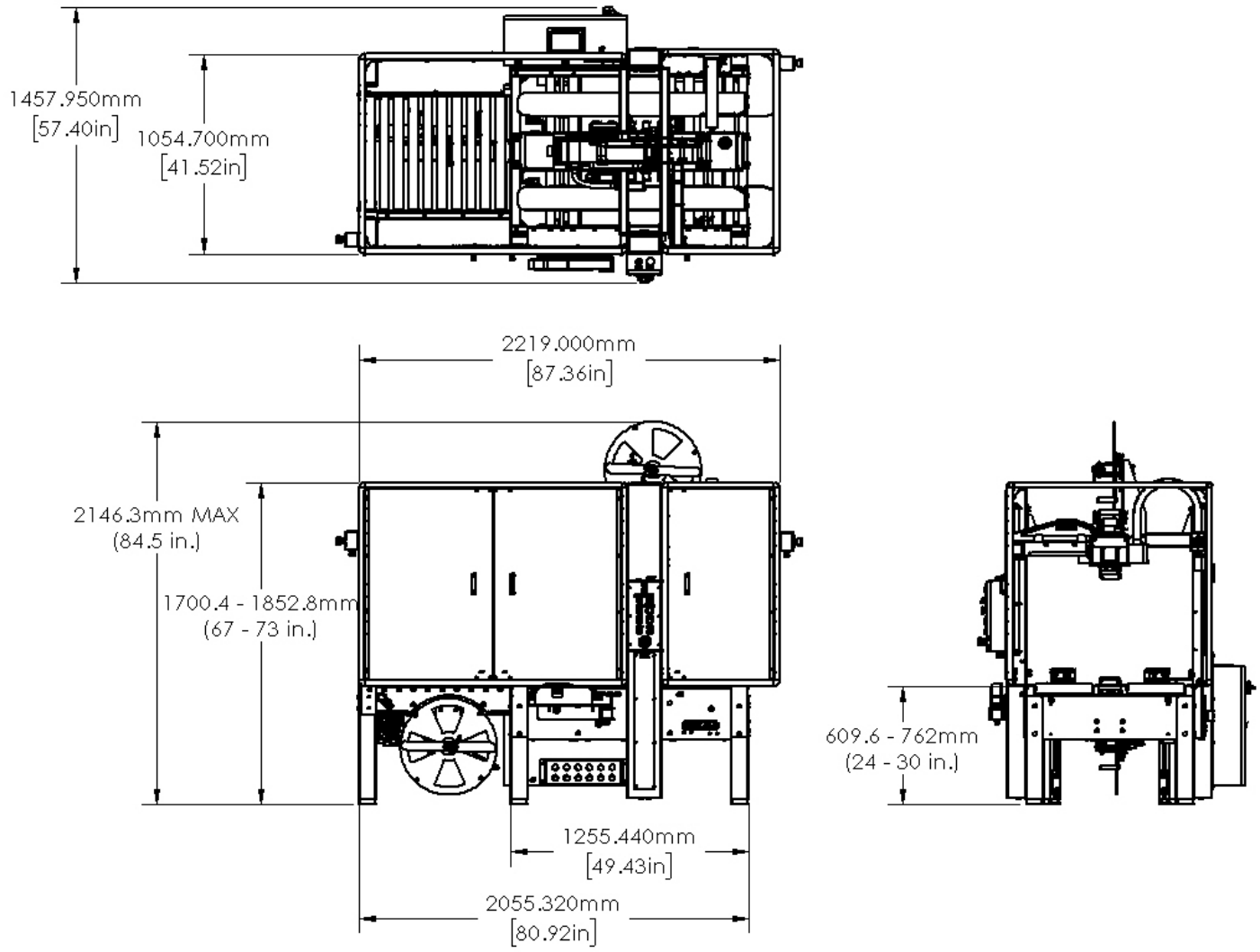


Figure 3-1 Machine Dimensions

3.2 MACHINE COMPONENTS

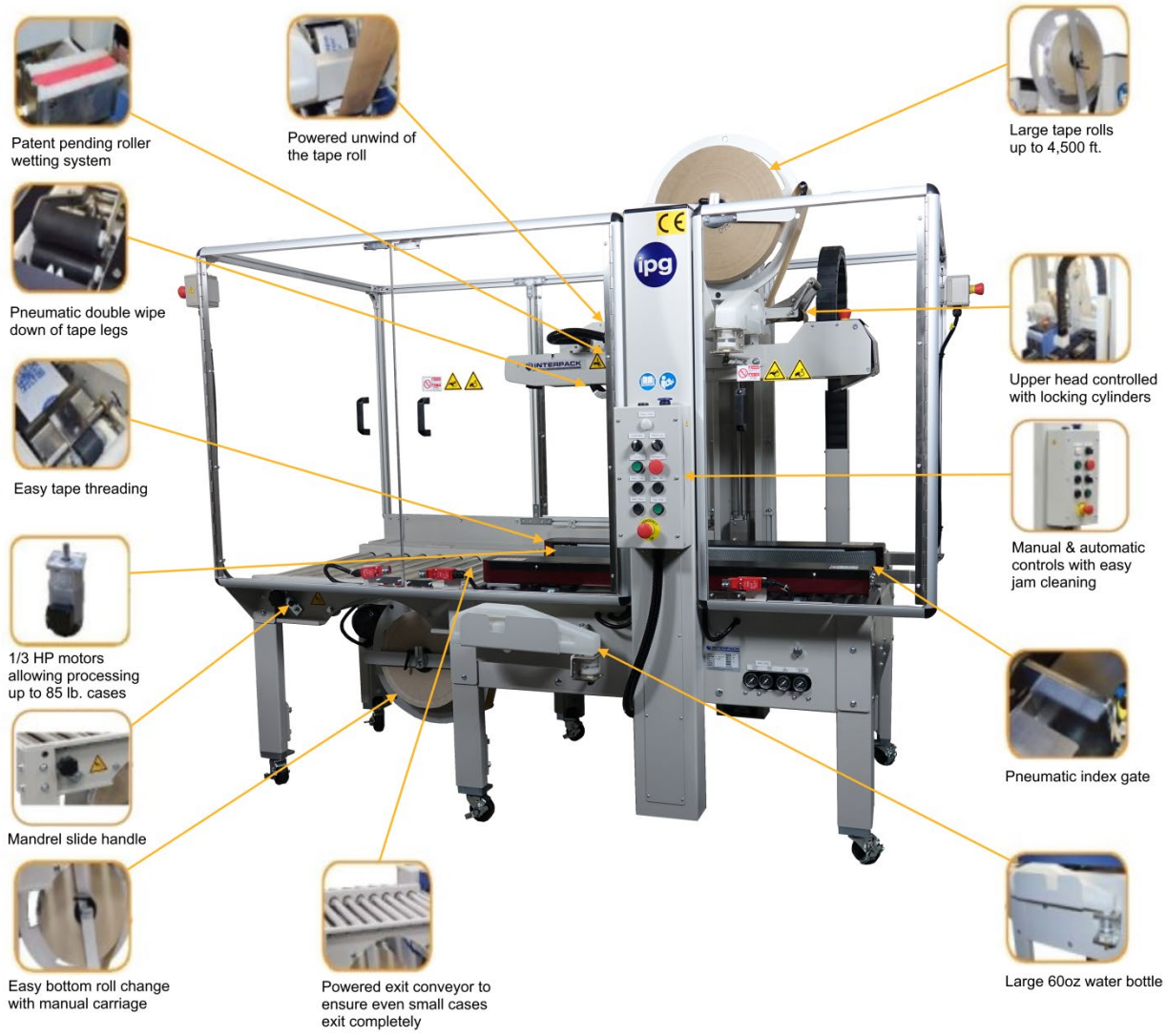


Figure 3-2 Machine Components

3.3 MACHINE OPERATING CONDITIONS

Always operate the machine in a dry, relatively clean environment at 7 to 40 °C (45 to 105 °F) with clean, dry cartons. Machine must be set on a level surface or adjusted to operate on a level plane.

3.3.1 Power Requirements

- Electrical - 220V, 50HZ, 10A
- Compressed Air - 90 PSI

This machine comes standard with two gear motors, one on each drive base, an electrical box, and a control box.

The electrical box contains an HMI for machine adjustments. The control box contains the **Clear** button, **Power Lamp**, a **Manual/Auto** switch, a **Tape Threading/Stop** button, a **Tape Cut** button, a **Tape Feed** button, an **Emergency Stop** switch, a **Head Down** button, a **Head Up** button, a **Start** button, a **Top/Both/Bottom** selector switch and a Reset button.

A 3657.6mm (12 ft) standard, three-conductor power cord with plug is provided for **220V**, **50HZ**, **10A** service. The receptacle providing this service **must** be properly grounded.

3.3.2 Operating Speed

Actual production rate is dependent on operator's dexterity and the case size mix. Boxes must be separated by 355.6mm (14 in.). Belt speed is 21.3 m/min (70 ft/min).

3.3.3 Tape Specifications

Use **IPG Water-Activated Tape**. The machine can accommodate tape widths of 48 - 75mm (2 - 3 in.).

A maximum tape roll length of 1371.6m (4500 ft) can be installed on the tape heads. This machine can accommodate all Intertape brand, water-activated tape within listed specifications.

The standard tape leg length of 75mm (3 in.) is factory set. The standard tape leg length may vary up to 6mm (¼ in.) based on tape tension and line speed.

The standard tape leg length is adjustable via the HMI on the electrical box. The minimum tape leg length recommended is 48mm (2 in.) and the maximum recommended is 75mm (3 in.).

3.3.4 Carton Specifications

Type

- Regular Slotted Containers (RSC)
- Other style cases may be processed. Consult factory for details.

Material

125 - 275 PSI Bursting Test, Single or Double Wall B or C Flutes.

Weight

39kg (85 lbs) maximum

Size

The case sealer can accommodate most cartons within the size ranges listed below.

Case Size			
Carton Size	**Length**	**Width**	**Height**
Minimum	152mm (6 in.)	165mm (6.5 in.)	127mm (5 in.)
Maximum	Infinite	508mm (20 in.)	610mm (24 in.)

3.3.5 Case Processing Stability

For optimal performance, the cases should be stable when processing through the machine. Unstable cases may tilt backwards upon contact with the upper tape head causing the machine to jam.

If the box length (in direction of seal) to box height ratio is 19mm (0.75 in.) or less, then several boxes should be test run to ensure proper machine performance. The formula is as follows:

$$\frac{\text{CARTON LENGTH IN DIRECTION OF SEAL}}{\text{CARTON HEIGHT}} > 19\text{mm (0.75 in.)}$$

Chapter 4
SET-UP PROCEDURES

4.1 RECEIVING AND HANDLING

The machine is shipped to the customer fixed to a pallet. The machine is enclosed with either a corrugated sleeve and cap or an HSC corrugated box. The sequence below is step by step instructions to remove all packing materials.

1. Remove the strapping that secures the corrugated sleeve and cap, or HSC corrugated box, to the pallet.
2. Lift off the cap and corrugated sleeve or HSC corrugated box.
3. Remove protective wrapping from machine.
4. Remove or relocate all securing devices such as tie wraps or locking collars.
5. Remove the mounting bolts that secure the machine to the shipping pallet.
6. Remove machine from the pallet to the location of final installation.

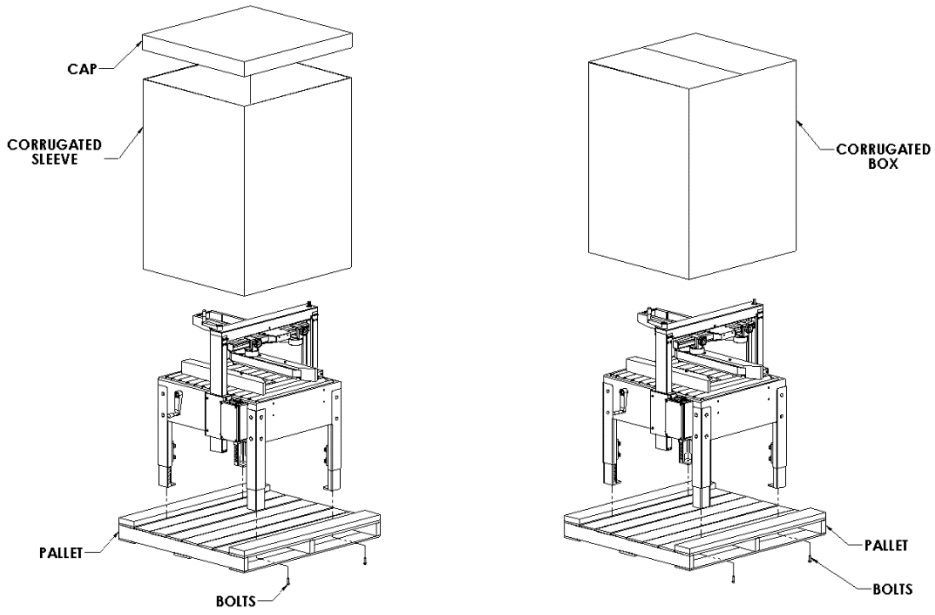


Figure 4-1 Receiving and Handling

All contents must be verified upon receipt. The following items are included with each machine:

- RSA2024-WAT-EU Case Sealer
- Operation Manual & Parts List
- Plastic bag containing tape head spare parts

Note: After unpacking the RSA2024-WAT-EU Case Sealer, look for any damage that may have occurred during shipping. Should the case sealer be damaged, file a claim with the transport company and notify your authorized Intertape distributor.

4.2 CASTER INSTALLATION (IF PURCHASED)

> ⚠ **WARNING:** Caster installation requires raising the machine to access the bottom of each leg. Follow all possible safety procedures prior to and during this process.

1. With a forklift, raise the machine to allow access to the bottom of each leg.
2. Screw a caster into each leg until it is firmly seated to the bottom of the leg (refer to Figure 4-2).
3. Tighten each caster.
4. **Do not adjust the conveyor height by adjusting the caster.** Proper conveyor height must be achieved by adjusting the leg extension of each leg (refer to Figure 4-3).

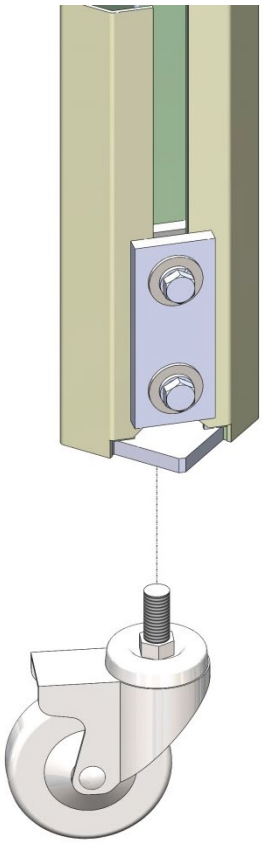


Figure 4-2 Caster Installation

4.3 MACHINE HEIGHT ADJUSTMENT

> ⚠ **WARNING:** Machine height adjustment requires raising the machine to adjust each leg. Follow all possible safety procedures prior to and during this process.

The RSA2024-WAT-EU Case Sealer must be installed on near-level ground. Use the adjustable legs to ensure that the machine is level and firmly on the ground (no rocking). Adjust the leg height with the four telescopic extension legs to accommodate conveyor heights from 609.6 - 762mm (24 - 30 in.).

1. To adjust the height of the Case Sealer, use a forklift to raise the machine to give ample room to extend the legs.
2. Using a 19mm box end wrench, loosen eight 12mm hex head adjustment bolts (refer to Figure 4-3).
3. Adjust the legs to the desired conveyor height and tighten bolts. Etched lines on the legs ease leveling.

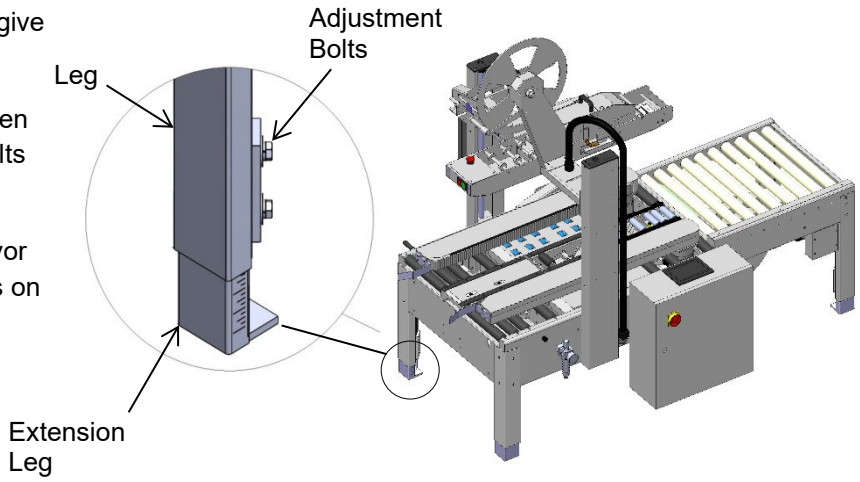


Figure 4-3 Machine Height Adjustment

4.4 INSTALLATION OF INTERPACK BRAND IN-FEED ROLLER TABLES (IF PURCHASED)

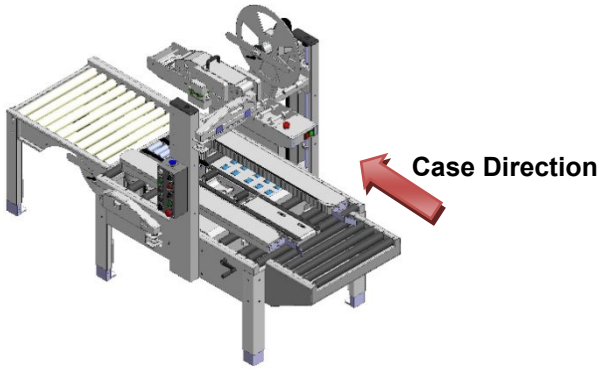


Figure 4-4 Case Direction

1. Loosely install two carriage bolts into top two mounting holes on roller table with hardware included (refer to Figure 4-5).

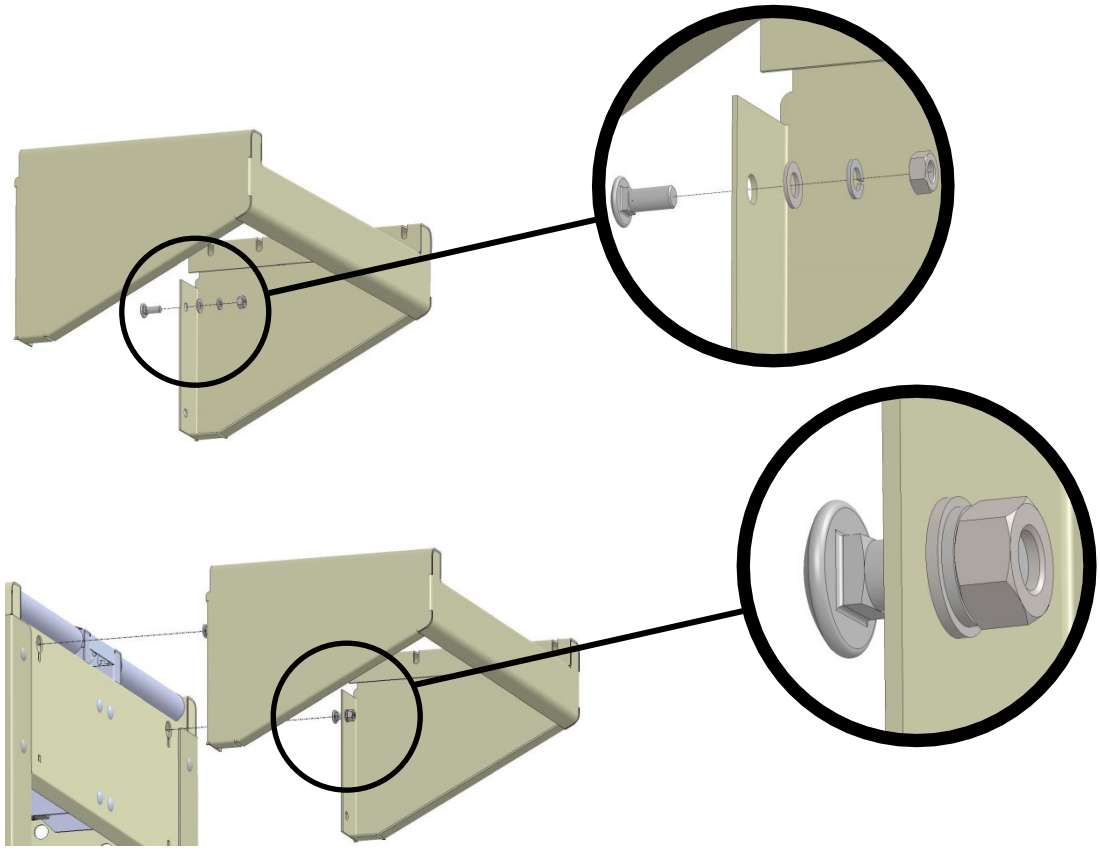


Figure 4-5 Carriage Bolt Installation

2. Utilizing the slots on the machine base, attach roller table to machine base by locating carriage bolts in slots on machine base and push down to lock in place (refer to Figure 4-6). Make sure carriage bolts are properly aligned into slot when pushed down to lock in place before proceeding.

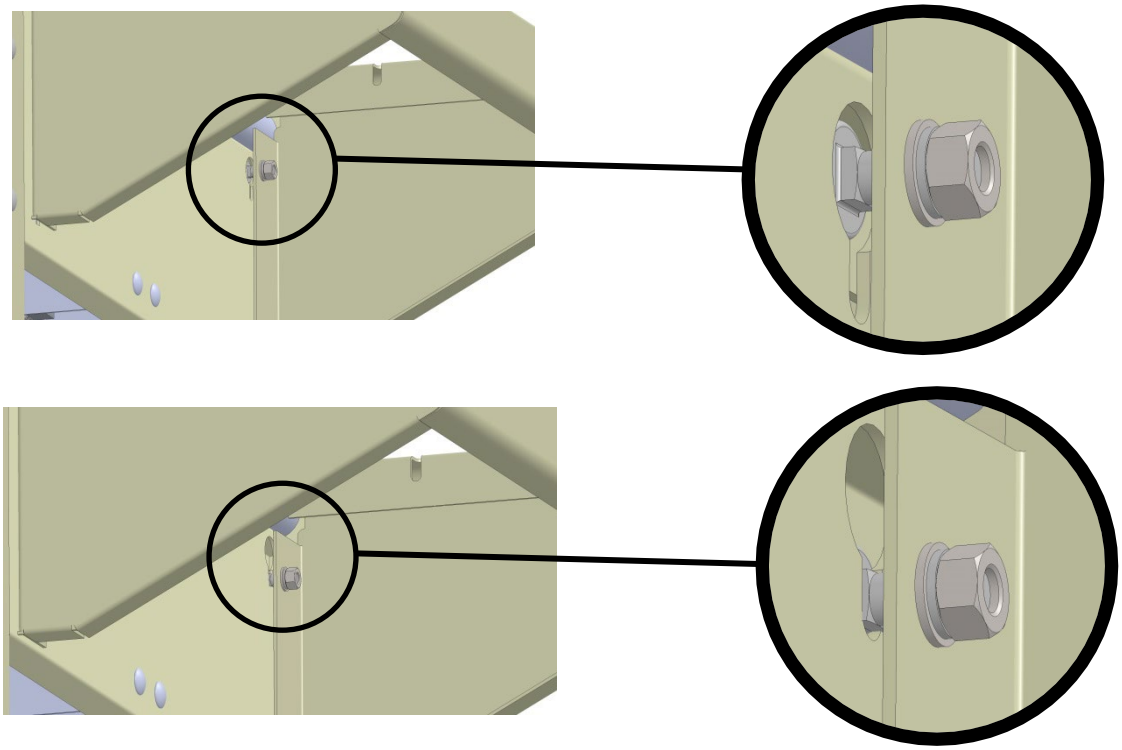


Figure 4-6 Roller Table to Machine Base Installation

3. Once roller table is attached to the machine base using the two carriage bolts, install remaining two carriage bolts with hardware included through the bottom two holes on the machine base and roller table (refer to Figure 4-7).

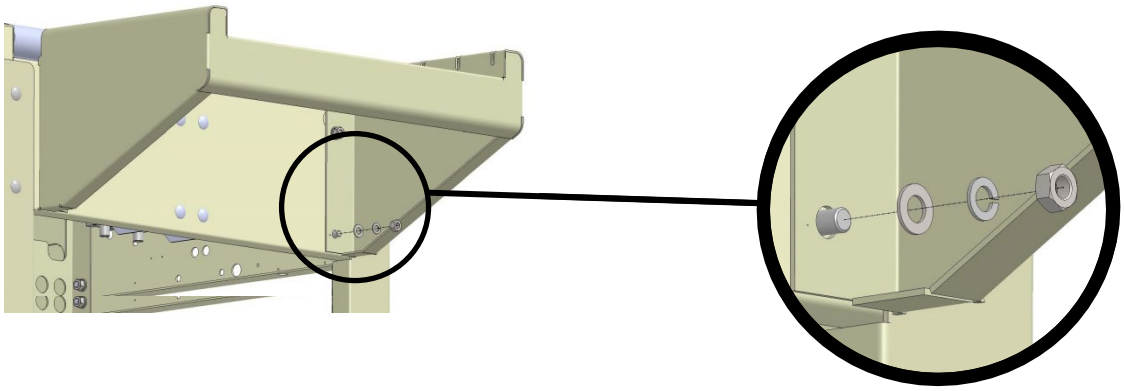


Figure 4-7 Remaining Carriage Bolt Installation

4. After all four mounting studs and included hardware have been installed, tighten all hardware to avoid roller table instability then install rollers on table.

4.5 INSTALLATION OF EXTERNAL IN-FEED AND EXIT CONVEYORS

1. Customer supplied in-feed conveyor (if used) should provide straight and level entry into the case sealer.

2. Customer supplied gravity exit conveyor (if used) should be straight and declined no more than 20mm/meter away from the machine to convey the sealed cartons away from the machine.

3. Customer supplied powered exit conveyor should be straight and level to convey the sealed cartons away from the machine.

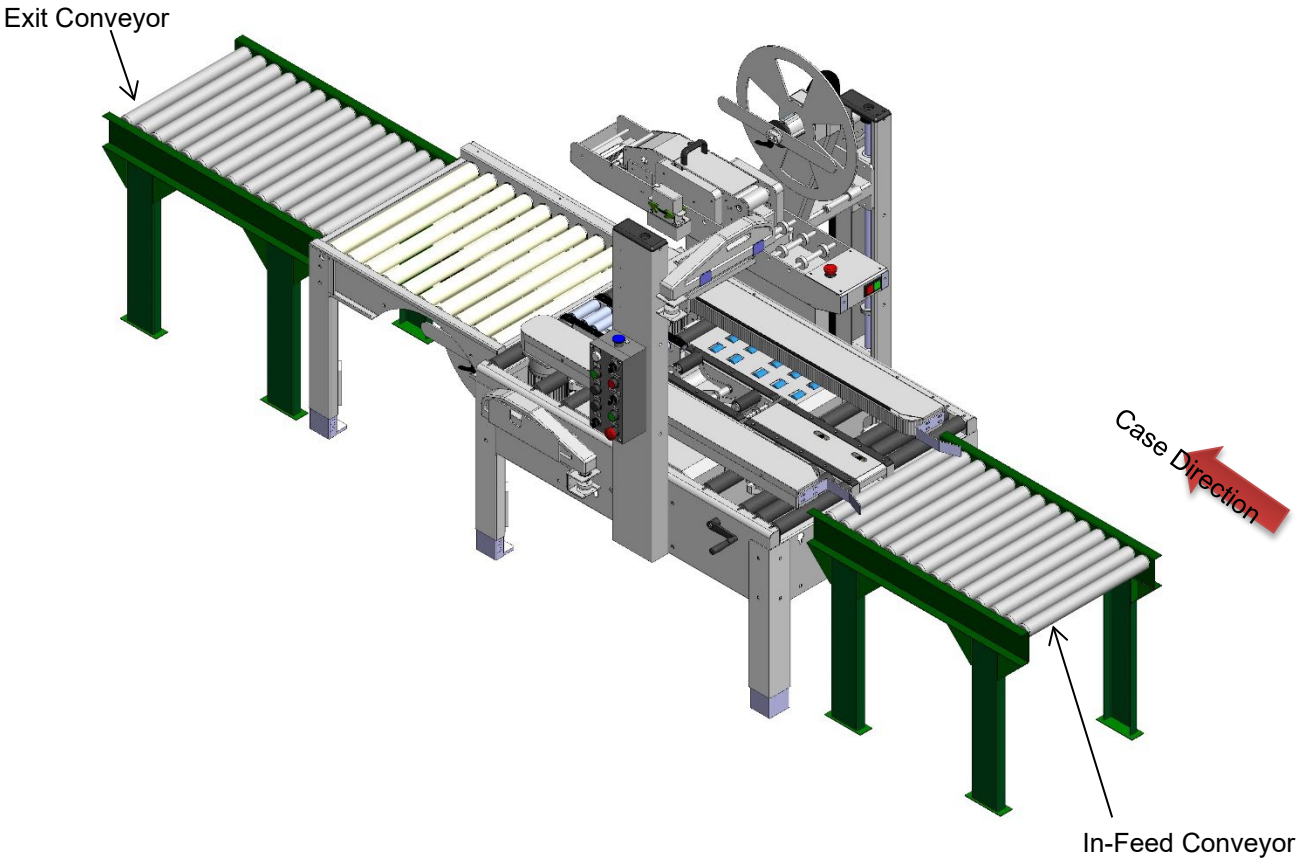


Figure 4-8 Installing In-Feed and Exit Conveyors

4.6 CONNECTING UTILITIES

4.6.1 Electrical Utilities

A 3657.6mm (12 ft) standard three-conductor power cord with plug is provided for 220V, 50HZ, 10A electric service. The receptacle must be properly grounded. Before the machine is plugged into the receptacle, ensure that all materials are removed from the machine. The electrical control is protected with an automatic circuit breaker with resettable overload.

The electrical box is located on one side of the RSA2024-WAT-EU Case Sealer. It contains an HMI that can be used to adjust machine operation settings as needed.

The control box contains a **Start** button, the **Emergency Stop** switch, a **Manual/Auto** switch, a **Tape Feed/Cut** button, a **Head Up** button, a **Head Down** button, a **Tape Threading/Stop** button, a **Tape Base In/Out** button, a **Clear** button, and a **Top/Both/Bottom** selector switch (refer to Figure 4-12).

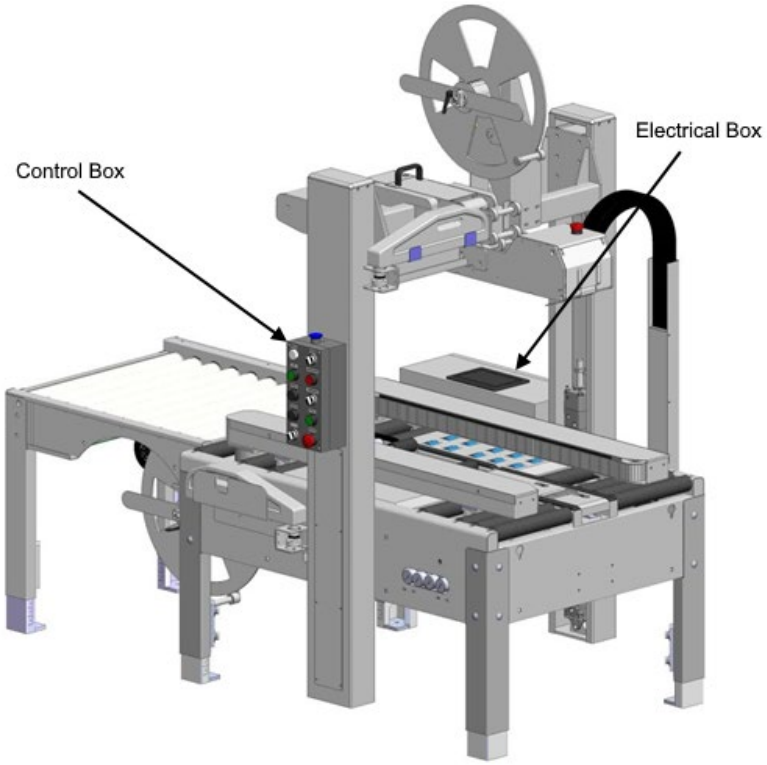


Figure 4-9 Electrical Utilities

Note:	Moving the control box to the opposite side of the machine requires disconnecting and reconnecting electrical wires and components. Only trained and qualified service technicians should access an open control box. Follow all possible safety procedures prior to and during this process.

4.6.2 Pneumatic Utilities

Note: The pressure setting for the main air regulator (Figure 4-10) is factory set. The values will need to be adjusted as needed by customer supplied pressure and volume.

The main air regulator has a male quick disconnect adaptor (refer to Figure 4-10). Connect clean dry compressed air to this adaptor. The RSA2024-WAT-EU Case Sealer requires a minimum of 9 CFM at 90 PSI.

To regulate the main air pressure, pull on the knob located on the top of the main air regulator (refer to Figure 4-10). Turn the knob clockwise for more pressure and counterclockwise for less. When the air pressure is at 75 PSI, push back down on the button until a "click" is felt to lock it in position. The thread size is 3/8 NPT.

Note: Should the supplied airline or pressure be unplugged or cut for any reason, tape will not feed and rollers will not be activated if box is processed.

Figure 4-10 Main Air Regulator

The pressure regulators in (refer to Figure 4-11) control various operations of the machine. The regulators on the left labeled “**OPEN**” and “**CLOSE**” control the pressure for the drive bases. The recommended pressure settings for the “**OPEN**” and “**CLOSE**” regulators is **30 PSI**. The third regulator from the left labeled “**UP**” controls the pressure for the top tape head box rising. The recommended pressure setting for the “**UP**” regulator is **65 PSI**. The regulator on the right labeled “**DOWNWARD**” controls the pressure of top tape head box descent.The recommended pressure setting for the “**DOWNWARD**” regulator is **35 PSI**.

Figure 4-11 Pressure Regulators

4.7 OPERATOR CONTROL BOX

Make sure machine is connected to air supply of at least 90 PSI and machine regulator is set at 75 PSI. The following describes the use of control box buttons:

1. **Clear** button (Operational in Auto Mode only). This button is used to simplify clearing a jam during production. When pressed down, belt drive motors stop, air supply is removed from tape head, and cutting mechanism is engaged.
2. **Power Lamp** - Electricity is being delivered throughout the machine.
3. **Manual/Auto** switch
   a. Auto mode is for machine operation.
   b. Manual mode is for tape threading/troubleshooting.
4. **Tape Threading/Stop** button
   a. On Auto Mode, stops machine operation.
   b. On Manual Mode, engages/disengages pinch roller which drives the tape.
5. **Tape Cut** button
   a. No function on Auto Mode.
   b. On Manual Mode, engages cutting mechanism in tape head to cut tape.
6. **Tape Feed** button
   a. No function on Auto Mode.
   b. On Manual Mode, feeds a length of tape and cuts it.
7. **EMERGENCY Stop** button
   a. On Auto Mode, de-energizes machine.
   b. On Manual Mode, de-energizes machine.
8. **Head Down** button
   a. No function on Auto mode.
   b. On Manual mode, lowers upper head assembly.
9. **Head Up** button
   a. No function on Auto mode.
   b. On Manual mode, moves bridge assembly upwards.
10. **Start** button
    a. On Auto mode, starts machine.
    b. No function on Manual mode.
11. **Top/Both/Bottom** switch
    a. On Auto Mode, selects the seams of the box to be taped.
    b. On Manual Mode, selects which tape head dispenses tape.
12. **Reset** button - Used to reset machine after clearing a jam.

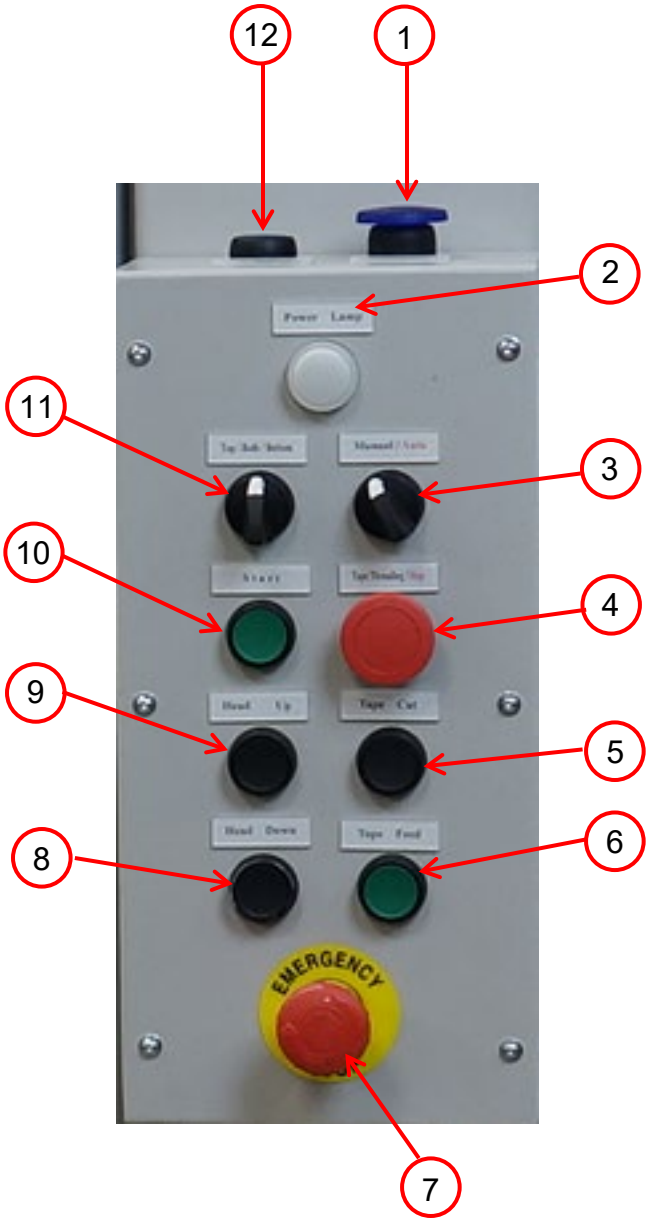


Figure 4-12 Operator Control Box

4.8 OPERATOR CONTROL BOX RELOCATION

Moving the control box to the opposite side of the machine requires detaching and reattaching the control box from the columns and reconnecting electrical wires and components.

Note:	Only trained and qualified service technicians should perform the relocation. Ensure that you follow all possible safety procedures prior to and during this process.

1. Disconnect machine from electrical supply.
2. Remove six screws that attach front panel to the control box.
3. Remove four screws attaching control box to the column.
4. Remove control box and relocate to opposite column.
5. Route control box and wire conduit to opposite side of machine.
    a. Remove wire ties holding wires under machine.
    b. Install new wire ties to secure wires to machine base.
6. Attach control box to opposite column using the four screws.
7. Attach front panel to control box with six screws.

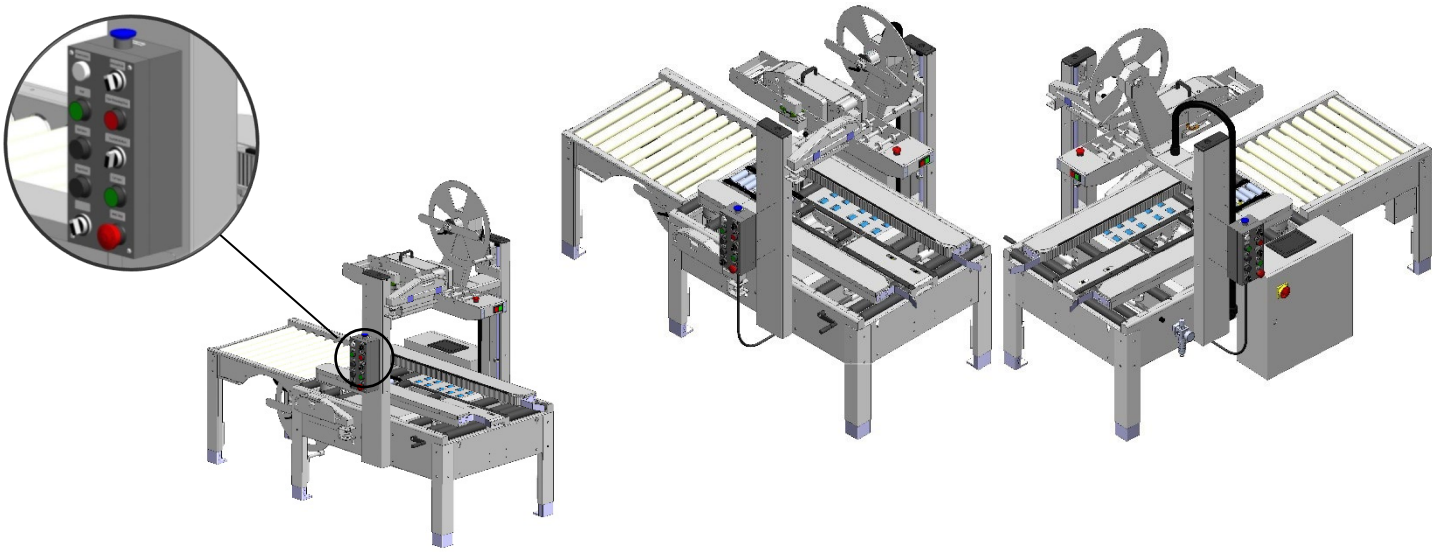


Figure 4-13 Control Box Relocation

4.9 TOP TAPE HEAD LOADING/THREADING

4.9.1 Direction of Top Tape Unwind

As shown in the diagram below, tape should be mounted with a counterclockwise, unwind direction. The adhesive side of tape will be facing up as it goes around the peel-off roller.

4.9.2 Top Tape Path

The diagram below shows the threaded tape path using the red line/arrow as the tape. For proper threading of tape use the steps on page 4-13 (refer to Figure 4-14). The order in which the tape passes the rollers starts at the peel-off roller, travels through three guide rollers and a clutch roller assembly to prevent tape from pulling out of the tape head then over powered roller as shown below.

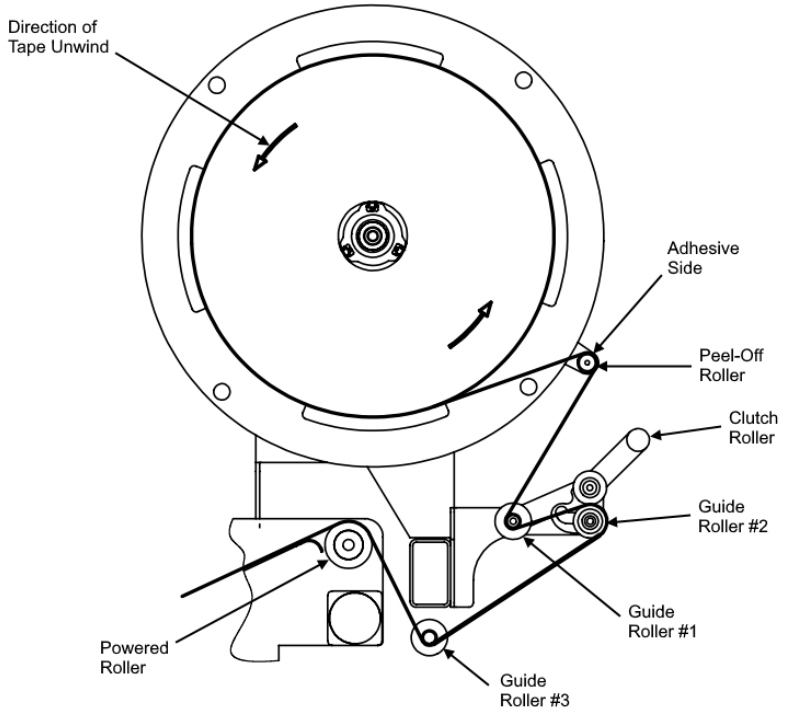


Figure 4-14 Top Tape Threading Diagram

4.9.3 Top Tape Threading/Loading Instructions

The instructions below will assist in threading tape on the top tape head. Top Threading diagram is located on page 4-12.

1. Put machine in Manual Mode using **Manual/Auto** selector switch (Figure 4-15, Item 1).
2. Install tape roll on to mandrel making sure the unwind direction is counterclockwise (refer to Figure 4-14).
3. Pull tape around peel-off roller and towards the front of the machine (Figure 4-16, Item 6).
4. Bring tape around the front of the first guide roller (Figure 4-16, Item 8) followed by bringing the tape back towards the second guide roller (Figure 4-16, Item 9).
5. After threading around second guide roller, pass tape under the third roller (Figure 4-16, Item 7) and pull towards the front of the machine.
6. Bring the tape over the powered drive roller (Figure 4-16, Item 6) and towards pinch roller (Figure 4-16, Item 10).
7. Thread tape under guide plate until it reaches the pinch roller (Figure 4-16, Item 10). During this process, make sure pinch roller is not engaged. To engage/disengage the pinch roller, use the **Tape Threading/Stop** button (Figure 4-15, Item 2) located on the control box.

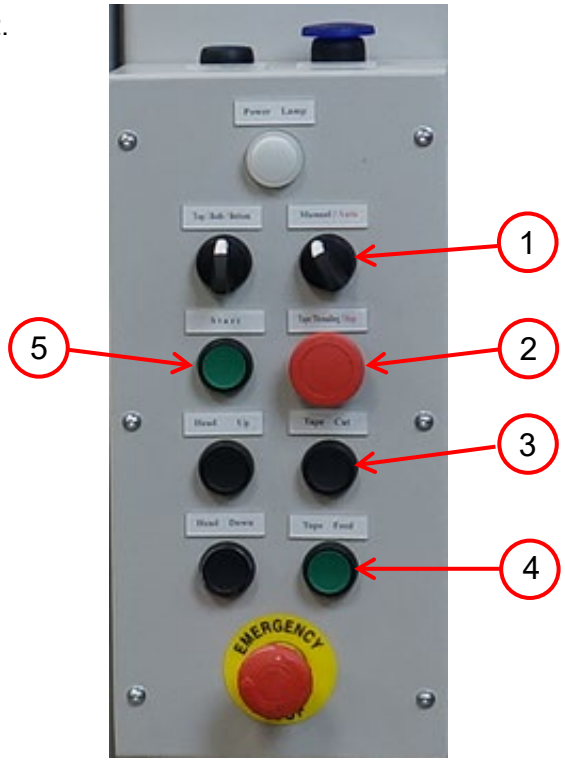


Figure 4-15 Control Box - Top Threading

8. Once tape has been passed under the pinch roller, engage pinch roller using **Tape Threading/Stop** button (Figure 4-15, Item 2).
9. Press down the **Tape Feed** button (Figure 4-15, Item 4) to allow machine to pass tape through tape shoe and feed out of the tape head.
10. If tape passes with no jams, remove tape from tape shoe guide, and press **Start** button (Figure 4-15, Item 5) and hold for one second to begin machine operation. If you encounter a jam, see Clear Mode (Clear Jam), on page 5-7.

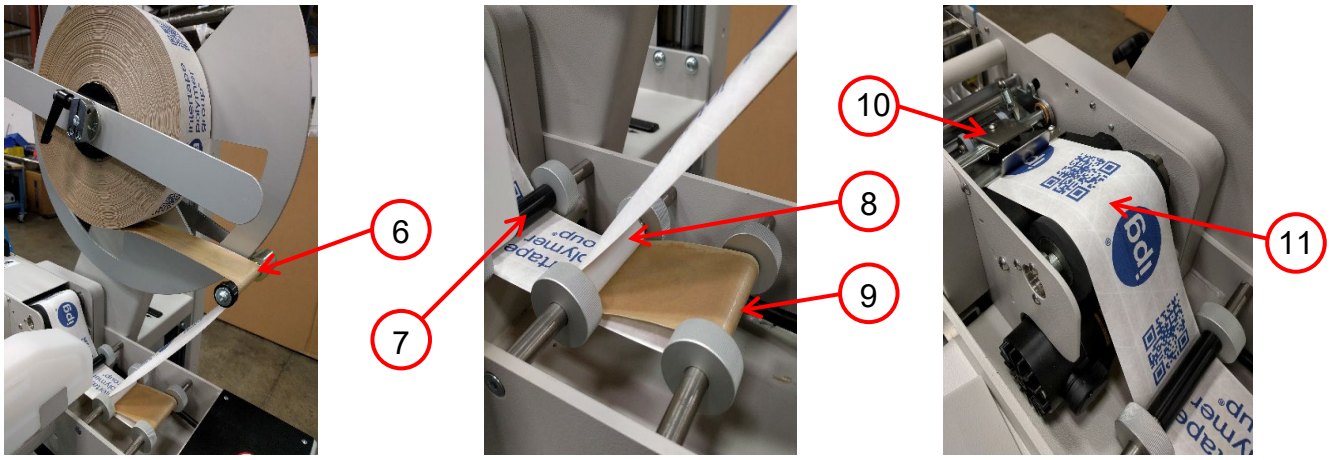


Figure 4-16 Top Tape Head Loading/Threading

4.10 BOTTOM TAPE HEAD LOADING/THREADING

4.10.1 Direction of Bottom Tape Unwind

As shown in the diagram below, tape should be mounted with a clockwise, unwind direction. The adhesive side of tape will be facing down as it goes around the peel-off roller.

4.10.2 Bottom Tape Path

The diagram below shows the threaded tape path using the red line/arrow as the tape. For proper threading of tape use the steps on page 4-15 (refer to Figure 4-17). The order in which the tape passes the rollers starts at the peel-off roller, travels through three guide rollers, as labeled below, then over powered roller, and under a fourth guide roller.

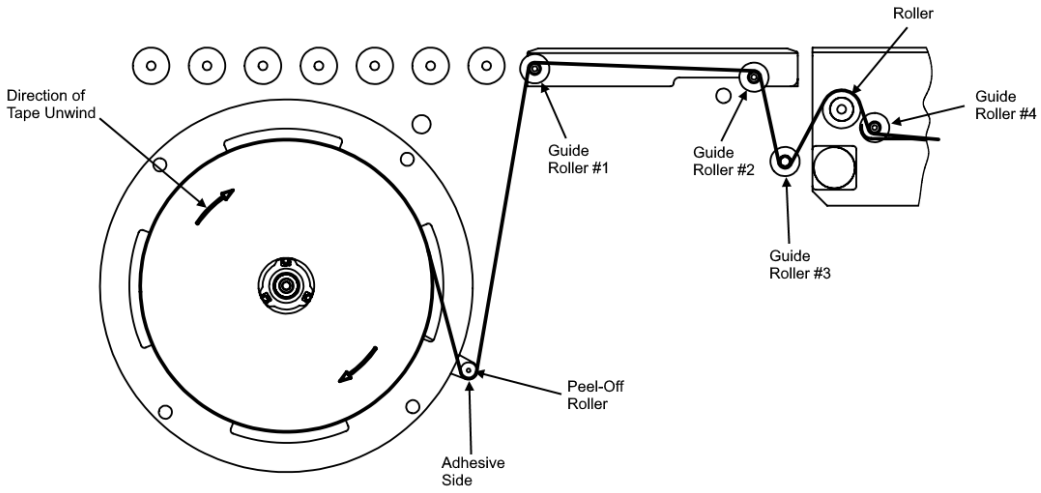


Figure 4-17 Bottom Tape Threading Diagram

4.10.3 Bottom Tape Threading/Loading Instructions

The instructions below will assist in threading of tape on the bottom tape head. Bottom Threading diagram is located on page 4-14.

1. Put machine in Manual Mode using **Manual/Auto** selector switch (Figure 4-18, Item 1).
2. Install tape roll onto mandrel making sure the unwind direction is clockwise (refer to Figure 4-17). To move mandrel to tape roll installation position, pull locking lever to unlock mandrel slide handle (Figure 4-19, Item 5) then pull handle outward. After tape roll has been installed, move mandrel to running position by pushing mandrel slide handle inward and securing with locking lever.
3. Pull tape around peel-off roller and towards the front of the machine with adhesive side facing down (Figure 4-20, Item 6).
4. Thread tape over the first guide roller (Figure 4-20, Item 7), bring tape around and under the second guide roller (Figure 4-20, Item 8), and pull towards the front of the tape head.
5. After threading through the second guide roller, pass tape over powered roller (Figure 4-20, Item 10), pull under third guide roller (Figure 4-20, Item 9), and bring tape up to the pinch roller (Figure 4-20, Item 11). Ensure pinch roller is not engaged, using the **Tape Threading/Stop** button (Figure 4-18, Item 2) to engage/disengage the pinch roller.
6. Once tape has been passed under the pinch roller, engage pinch roller using **Tape Threading/Stop** button (Figure 4-18, Item 2).
7. Press down the **Tape Feed** button (Figure 4-18, Item 3) to allow machine to pass tape through tape shoe and feed out of the tape head.
8. If tape passes with no jams, remove tape from tape shoe guide, switch machine to **Auto** (Figure 4-18, Item 1), press **Start** button (Figure 4-18, Item 4), and hold for one second to begin machine operation. If you encounter a jam, see Clear Mode (Clear Jam) on page 5-7.

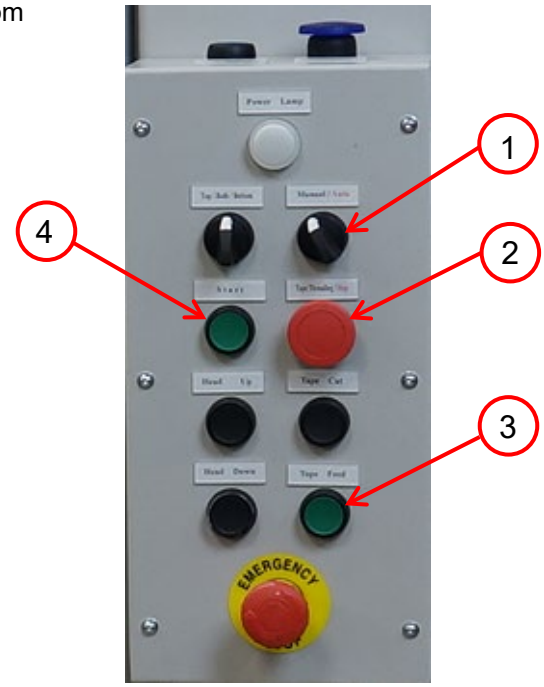


Figure 4-18 Control Box - Bottom Threading

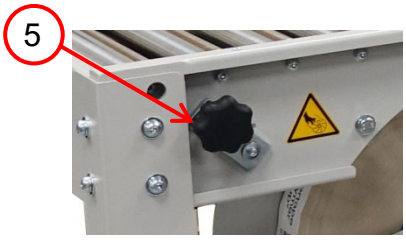


Figure 4-19 Mandrel Slide Handle

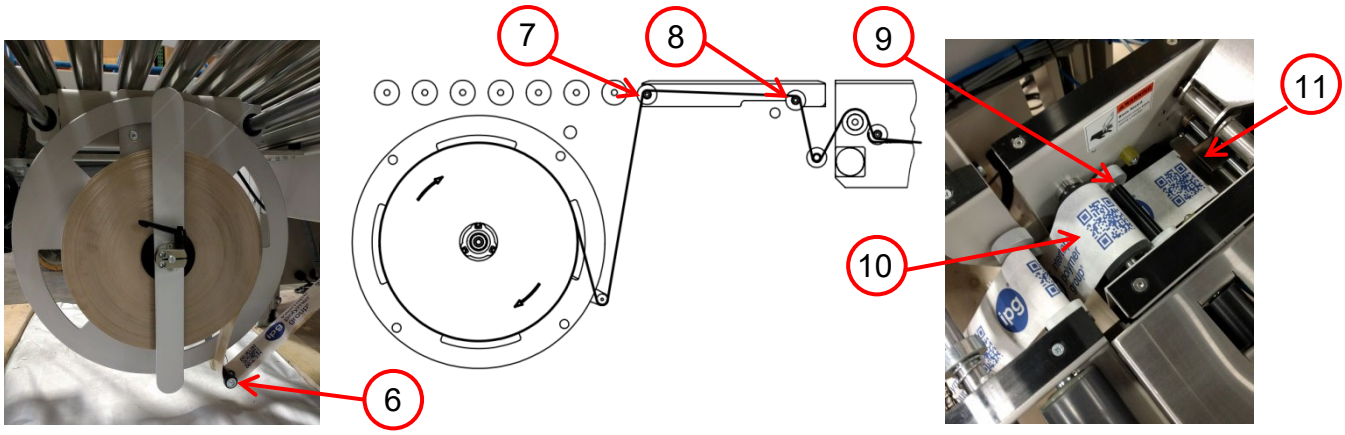


Figure 4-20 Bottom Tape Head Loading/Threading

4.11 ADDING WATER TO THE SYSTEM

1. Remove the water bottles by pulling them straight up from support brackets (refer to Figure 4-21).
2. Turn the bottles over so the water will not spill.
3. Unscrew the valve assembly and remove.
4. Fill the bottle with warm water.
5. Replace the valve assembly.
6. Install the water bottle by inserting it over the water pot post and into the support brackets located on the machine.

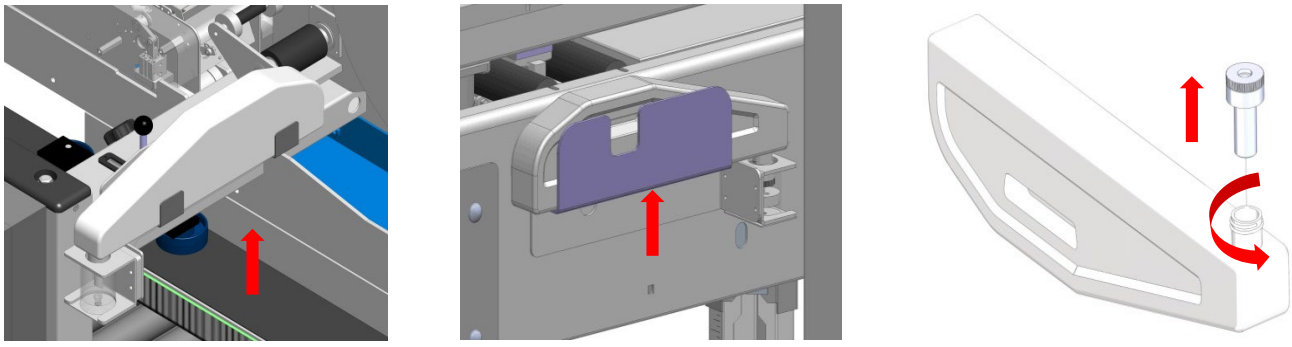


Figure 4-21 Adding Water to the System

Notes

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Chapter 5
OPERATING INSTRUCTIONS

5.1 INTRODUCTION TO OPERATING INSTRUCTIONS

Once the tape has been loaded and threaded on both the top and bottom, allow up to 10 minutes of being powered on for the machine to become completely ready to process regular slotted cases. The following instructions are presented in the order recommended for processing cases successfully through the RSA2024-WAT-EU Case Sealer.

Note: When set to **Bottom** only mode, the bridge assembly raises to the maximum height and doesn't lower while processing a case.

1. Install and thread tape roll on the top and the bottom of the machine (refer to Top Tape Head Loading/Threading and Bottom Tape Head Loading/Threading).
2. Fill water bottles and place them on machine (refer to Adding Water to the System).
3. Open water pot valves on the top and bottom tape heads - make sure water line is connected to the water pot (water pot valves can be identified in sections 7.5 and 7.6).
4. The top tape head water line must be purged to allow proper water flow into water pot. Remove the water pot from the tape head and lower it until water starts flowing into the water pot. Introduce water pot into tape head.
5. Supply or connect machine to air line, verify that the machine is set to 75 PSI.
6. Supply or connect machine to 220V electrical supply.
7. Turn on main power disconnect switch located on machine electrical box.
8. Twist four **E-stops** clockwise and make sure all enclosure doors are closed. Press **Reset** button to allow machine operation (refer to Figure 5-1).
9. Set machine to Manual Mode using **Manual/Auto** selector switch on the control box (refer to Figure 5-6).

Figure 5-1 E-stop Locations

10. Press **Tape Feed** button to feed a predetermined length of tape through the path. Tape will be cut once length of tape has been fed (refer to Figure 5-6).
11. Inspect dispensed tape to ensure water is being properly applied to adhesive side. If water is not being properly applied, refer to Chapter 6, Troubleshooting.
12. Switch machine to Auto using **Manual/Auto** selector switch on the control box (refer to Figure 5-6).
13. Press **Start** button to begin machine operation (refer to Figure 5-6).
14. Introduce a case to the machine indexing gate.

15. The top tape head box will lower or rise to match case height, the side belts will travel horizontally to match case width and process case through machine.

16. Once box has been processed, machine is ready for production.

5.2 PREPARING CASE TO BE PROCESSED

5.2.1 Flap Folding

1. Fold minor flaps inward, as shown in Figure 5-2.

2. Fold major flaps inward, as shown in Figure 5-3.

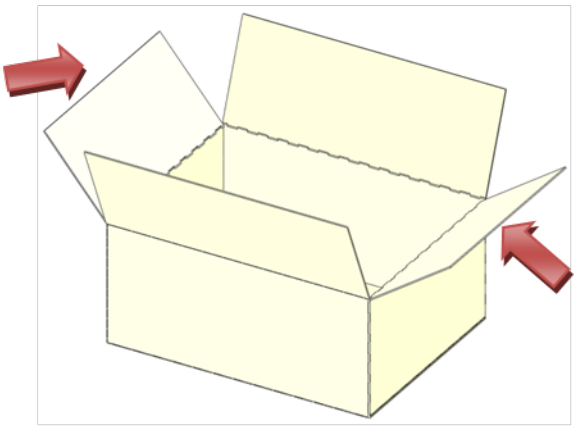

Figure 5-2 Fold Minor Flaps

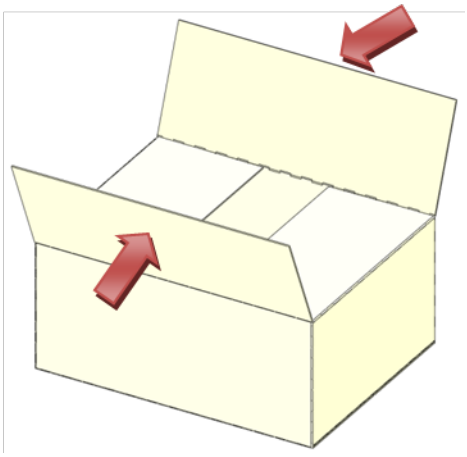

Figure 5-3 Fold Major Flaps

5.2.2 Overfills and Void Fills

Overfills and Void Fills, as shown in Figures 5-4 and 5-5, should be avoided to assure proper processing of the corrugated case. Each of these scenarios put stress on the water activated tape seal which could be detrimental to the integrity of the closure.

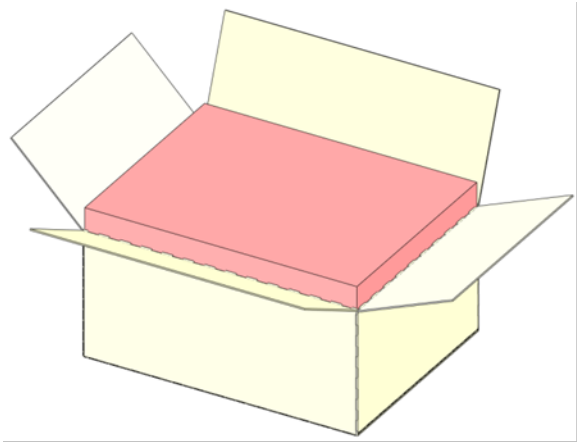

Figure 5-4 Overfill

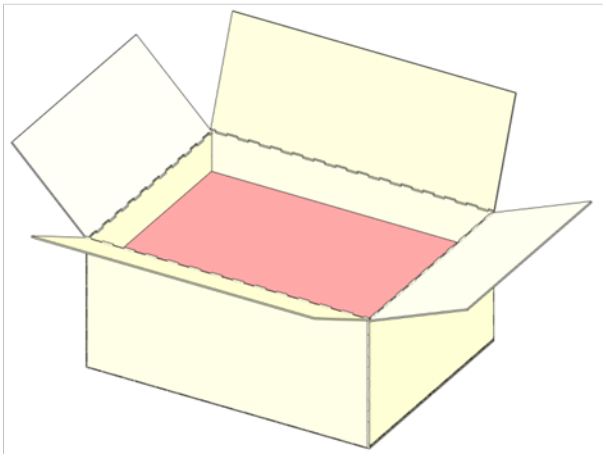

Figure 5-5 Void Fill

5.3 CONTROL BOX

The RSA2024-WAT-EU Case Sealer has three operating modes. The operator selects these modes, using the 2-position switch and push button on the Control Box (refer to Figure 5-6).

When the case sealer is turned on, the top tape head box will rise to the uppermost position and side belt drives will come out to their outermost position. These positions are referred to as their “home” positions.

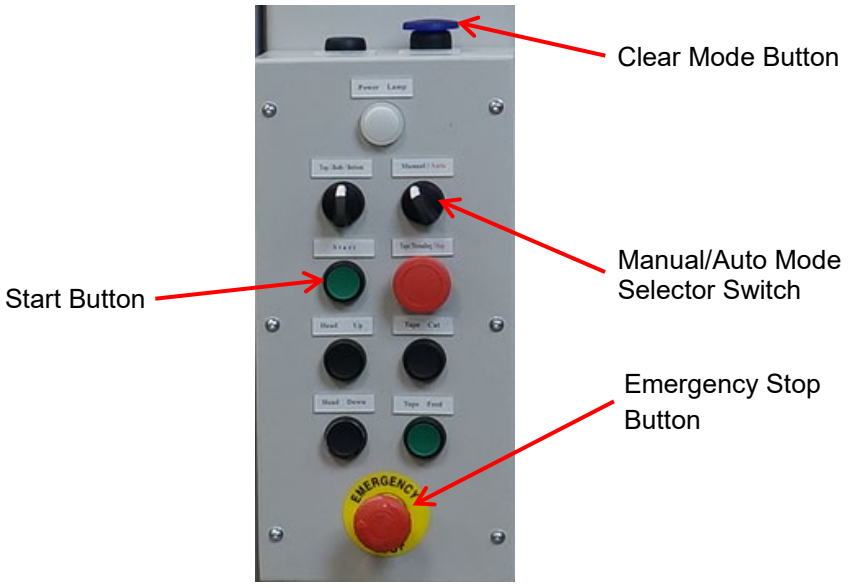

Figure 5-6 Control Box

5.3.1 Auto Mode

This is the standard operating mode of the machine. In this mode, the Top Tape Head Box will rise to upper “home” position and the side belt drives will travel to “home” position until case arrives. When a case is being processed, the top tape head box will match case size; side belt drives will move in towards the box and carrycase through the exit of the machine.

1. Ensure that the compressed air is plugged and at 75 PSI.
2. Turn the **Manual/Auto** selector switch on the control box to Auto (Automatic) (refer to Figure 5-6).
3. The bridge does not rise all the way up when Auto mode starts, except if it is Bottom only. The belts will still open up.
4. Press the **Start** button, the drive belts will return to “home” position.
5. Introduce a case with the flaps held in the closed position and advance to the indexing gate so the proper sensor is activated. Do not place hands in front of case.
6. The top tape head box will descend to set itself at the height of the case.
7. When the bottom paddle is depressed and the bottom switch is covered, the side drives will close.
8. The case will be processed and tape applied to top and bottom center seams.
9. Once the case is processed and exits the machine, the exit sensor is cleared and the side belt drives will return to “home” position.

5.3.2 Manual Mode

This mode is used for troubleshooting and loading tape on to machine.

1. Ensure that the compressed air is plugged in and at 90 PSI.
2. Turn the control selector to **Manual** mode (refer to Figure 5-6).
3. Once set to **Manual**, other buttons on control box can be used for troubleshooting or loading tape.
4. See Operator Control Box, on page 4-10, for an explanation of button usage.

5.3.3 Clear Mode (Clear Jam)

This mode is used to clear a jammed box without the need for the **E-Stop**.

Note: While in "Clear" mode, the top tape head box will return to its "home" position and the side belt drives will not retain any pressure. The belts will cease operation but the machine will continue to be powered throughout. If electricity needs to be cut off throughout the machine, use the E-stop buttons located on the control box and on the top tape head box.

1. Ensure that the compressed air is plugged in and at 90 PSI.
2. Press downward on the **Clear** mode button, at the top of the control box, to set machine to clear mode (refer to Figure 5-6).
3. Remove jammed box.
4. Determine location of tape jam:
   a. Inspect and remove tape shoe if there is visible tape in path (refer to page 7-7).
   b. Inspect and remove water pot to clear any tape that may remain from jam (refer to page 4-16).
   c. Inspect tape path prior to cutter for jam, pressing down on the pinch roller to remove any remaining tape.
5. Once box and tape have been removed, feed tape under pinch roller.
6. Remove newly dispensed tape, press **Start** button, and hold for one second to begin machine operation.

WARNING: Ensure that the operator's hands are away from the moving belts of the side drive base assembly. Do not place hands on the front edge of the case while it is entering the machine.

Note:
-- Should any problem occur during processing that requires halting the machine, press any red E-stop button.
-- The machine should **never** be washed down or subjected to conditions causing condensation on components.

Notes

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Chapter 6
TROUBLESHOOTING

The RSA2024-WAT-EU Case Sealer is fabricated with high quality components that provide trouble-free operation for a long period of time. However, should a problem occur, we recommend that you consult the following table. If the problem you encounter is not discussed in this table, call Interpack Technical Support.

Trouble	Possible Causes	Solutions
Green start button pressed but belts do not turn.	E-stops not reset.	Rotate both E-stops ¼-turn clockwise (page 5-1).
	Machine not plugged in.	Plug machine into 220V, 50HZ, 10A electrical service.
	Machine set to manual operation.	Switch machine to auto using selector switch (page 4-10).
	"Clear" mode activated.	Press clear button on control box to deactivate clear mode (page 4-10).
	Enclosure door is opened.	Close enclosure door.
	Reset button has not been pressed.	Press Reset button.
Motors turn but belts do not turn.	Belt tension too low.	Adjust tension on drive belts (page 8-2).
Drive belts do not process cases.	Belt tension too low.	Adjust tension on drive belts (page 8-2).
	"Close" PSI setting too low.	Adjust "Close" PSI setting to recommended.
	Collapsed leading end panel on case.	Adjust pressure of wipe down rollers.
	Case size is out of specification.	Compare case sizes with machine specifications.
	Box slipping on drive belts.	Adjust "Close" PSI.
Case processes but side of case is crushed.	Case width adjustment incorrect.	Re-adjust case width.
	"Close" PSI setting too high.	Adjust "Close" PSI setting to recommended.
Case processes but leading end panel is crushed.	Product does not support the end panel of the case.	Insert proper dunnage material to provide support.
	Too much pressure on wipe down rollers.	Reduce pressure of wipe down rollers.
	Rear wipe arm activates before box is processed.	Case slipping or box removed after introduction to sensor.

Trouble	Possible Causes	Solutions
Drive belts start then stop.	Motor starter trips.	Call maintenance.
Overfilled cases do not process properly.	Product height exceeds case height.	Reduce product in case to match case height.
		Increase case height to match product height.
	Excessive void fill dunnage.	Reduce void fill dunnage to match case height.
Unstable cases do not process properly.	Case height exceeds 1 ½ times the case length.	Re-configure case dimensions so that case is not unstable.
Tape not centered on carton.	Thread path rollers adjustments are misaligned.	Adjust width of thread path rollers.
	Tape roll not fully pushed on tape mandrel.	Push tape roll completely onto tape mandrel.
	Dust and dirt on drive rollers.	Clean drive rollers.
Tape leg is too short/too long.	Loss of air causing tape feeding problems.	Check inlet pressure and adjust as needed.
	Tape leg adjustment not correct.	Adjust tape leg using HMI on electrical box.
	Tape is not threaded correctly.	Thread tape correctly (page 4-12, page 4-14).
Tape does not cut.	Debris in the cutter blade.	Clean cutter blade (page 7-7; page 7-8).
	Blade dull.	Replace cutter blade (page 7-10).
	Weak return spring.	Replace return spring.
	Tape is not threaded properly.	Thread tape correctly (page 4-12, page 4-14).
	Dislocated knife spring.	Re-attach knife spring.
Tape is jamming.	Debris in the tape path.	Clean tape path.
	Adhesive build up.	Clean tape path, moistening brush/roller and water pot.
	Insufficient air pressure.	Check air pressure and adjust to 75 PSI.
	Pressure plate missing or installed incorrectly.	Install pressure plate.
	Tape dispensing guides set incorrectly; too tight or too loose.	Loosen or tighten tape dispensing guides.
	Roller too high or too low.	Adjust roller height.

Trouble	Possible Causes	Solutions
Tape is jamming.	Roller dry; no or low water pot level.	Add water or adjust water bottle level (page 4-16).
	Water pot not seated properly.	Re-seat water pot (page 4-16).
Tape is too dry.	Worn roller.	Replace roller.
	Water level in water pot too low.	Adjust water level in water pot (page 4-16).
	Water valve is off.	Make sure valve is in the on position (page 7-5; page 7-6).
	Water pot not seated properly.	Re-seat water pot (page 4-16).
	Water bottle is out of water.	Refill water bottle (page 4-16).
	Roller in water pot set too low.	Adjust roller height in the water pot.
	Machine not level on ground.	Check level of machine and adjust as needed.
Tape is not evenly moistened.	Worn roller.	Replace roller.
	Roller uneven in water pot.	Adjust set screws to make roller even.
	Water level too low.	Adjust water bottle height (page 4-16).
	Machine not level.	Make sure machine has been properly leveled on ground.
No tape dispensed.	Out of tape.	Replace tape roll.
	Not threaded properly.	Thread tape properly (page 4-12, page 4-14).
	Tape jam.	Refer to Tape is jamming on page 6-2.
	Machine set to different operation condition.	Make sure correct setting is chosen between Top/Both/Bottom.
Front or rear tape leg not sticking to the case.	Too low water level.	Check and raise water bottle if water level is low (page 4-16).
	Tape threaded incorrectly.	Thread tape correctly (page 4-12, page 4-14).
	Case slipping on side belts.	Adjust drive belt width (page 8-2).
	Insufficient air supply.	Make sure regulator is reading the recommended 90 PSI.
	Tape leg too short; timers set improperly.	Adjust tape leg timer setting in HMI.
	Assist roller clogged.	Clean assist roller on Tape Head.

Trouble	Possible Causes	Solutions
Wrinkles on tape applied to the box.	Case not introduced to machine straight.	Make sure to introduce box in square and straight.
	Case is overfilled.	Make sure case is not overfilled.
	Rear wipe down arm timing is off.	Adjust rear wipe down arm timing in HMI.
	Insufficient air supply.	Make sure supply is at least 90 PSI and machine set to 75 PSI.
	Tape tension is incorrect.	Thread tape correctly (page 4-12, page 4-14).
	Motor RPM is incorrectly set.	Adjust motor RPM in HMI.
	Tape not threaded properly.	Thread tape correctly (page 4-12, page 4-14).

Chapter 7
PREVENTIVE MAINTENANCE

7.1 MACHINE PREVENTIVE MAINTENANCE

The RSA2024-WAT-EU Case Sealer has been designed and manufactured with the finest components to provide long, trouble-free performance. General preventive maintenance will improve performance and prolong the life of the case sealer. Review the illustrations and chart below for information regarding machine maintenance.

			Frequency		
Item	Action Required	Material	Weekly	Monthly	Quarterly
Carton Dust In/On Machine	Blow Off Machine Extenally and Internally	Air hose	X		
	Pay Attention To Drive Base Centering Chain				
Hardware	Re-Tighten any Loose Hardware			X	
	Replace any Missing Hardware				
Column Shafts	Lubricate	Silicone Lubricant		X	
Cross Shafts	Lubricate	Silicone Lubricant		X	
Centering Chain	Lubricate	Chain Lubricant		X	
Air Regulator Filter	Clean Filter	Water, Mild Detergent		X	
Tape Path	Clean To Remove Adhesive	Water	X		
Water Pot/Reservoir	Rinse Out Thoroughly			X	
Wetting Roller	Clean Roller	Water, Mild Detergent		X	
Wipe Down Drive Rollers	Remove Dust	Air hose	X		
Tape Head Assist Roller	Clean Roller	Water, Mild Detergent	X		

Figure 7-1 Machine Preventive Maintenance Chart

7.2 CLEANING THE MACHINE

> ⚠ **WARNING:** Exercise all safety precautions prior to starting this procedure. Disconnect electrical power and wear approved safety glasses.

7.2.1 Side Belt Drive Base

Insert an air nozzle along the top edge of the belt into the opening of the drive base and clean out any dust and dirt (refer to Figure 7-2).

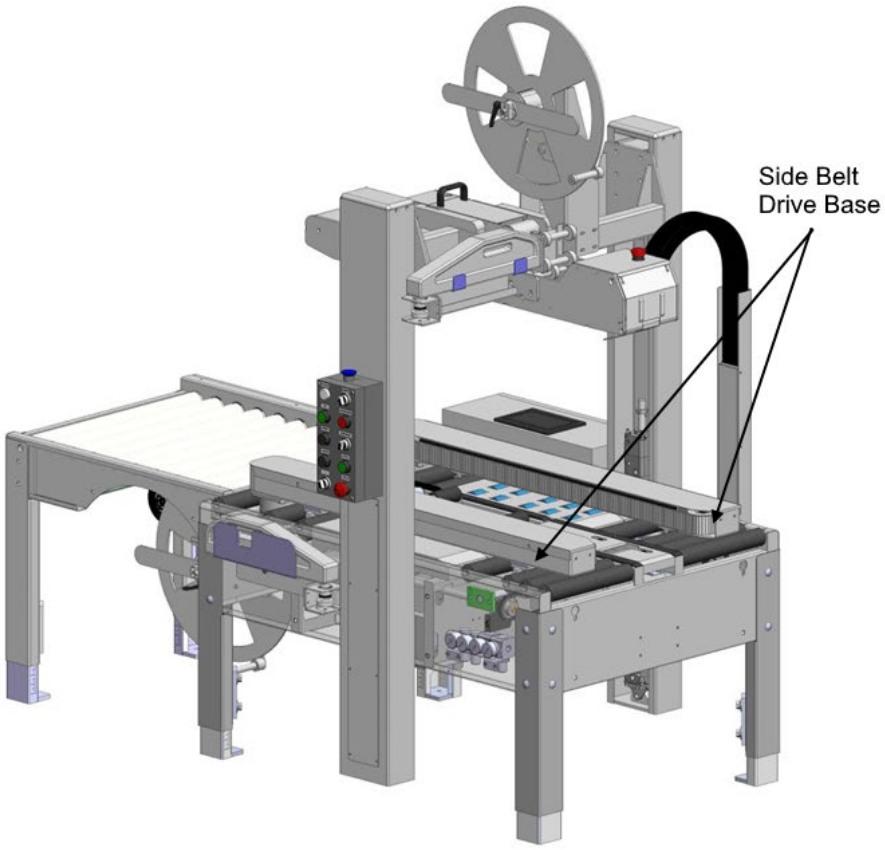


Figure 7-2 Cleaning the Machine

7.3 CHANGING THE AIR REGULATOR FILTER

> ⚠ **WARNING:** Ensure that the case sealer has been disconnected from the power source and the airline before conducting any maintenance procedures.

The filter on the air regulator removes dirt and moisture from air plant before it enters the carton sealer.

1. To remove metal protective guard, press down on locking tab located towards the top of the guard, rotate guard and pull down (refer to Figure 7-3).
2. The clear reservoir has a threaded top, which is used to attach it to the main regulator assembly. To remove the reservoir, rotate it until unfastened (refer to Figure 7-4).
3. The air regulator filter is held in place using a threaded cap fastened on to the main assembly. To remove the filter, unfasten the cap and pull down on filter (refer to Figure 7-5).

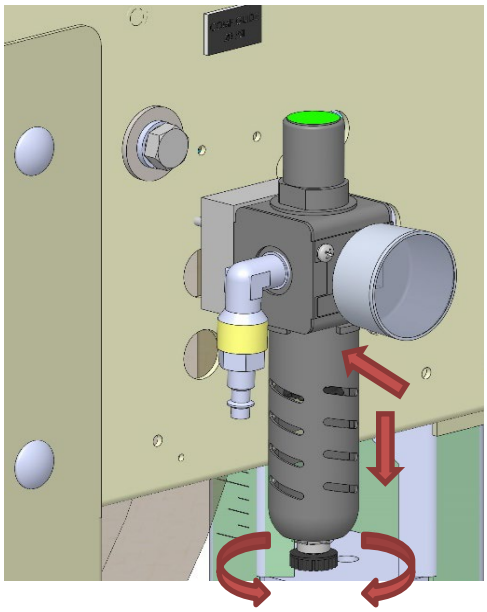


Figure 7-3 Remove Guard

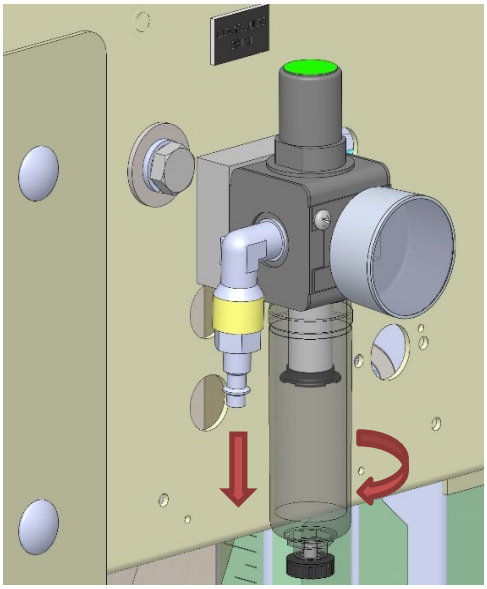


Figure 7-4 Remove Reservoir

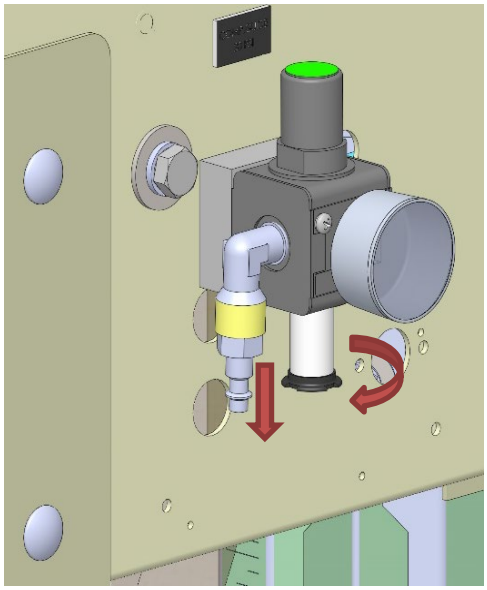


Figure 7-5 Remove Filter

7.4 LUBRICATING THE MACHINE

7.4.1 Acme Drive Base Shafts

Lubricate both shafts with light machine grease.

7.4.2 Centering Chain

Lubricate Chain With Chain Lubricant.

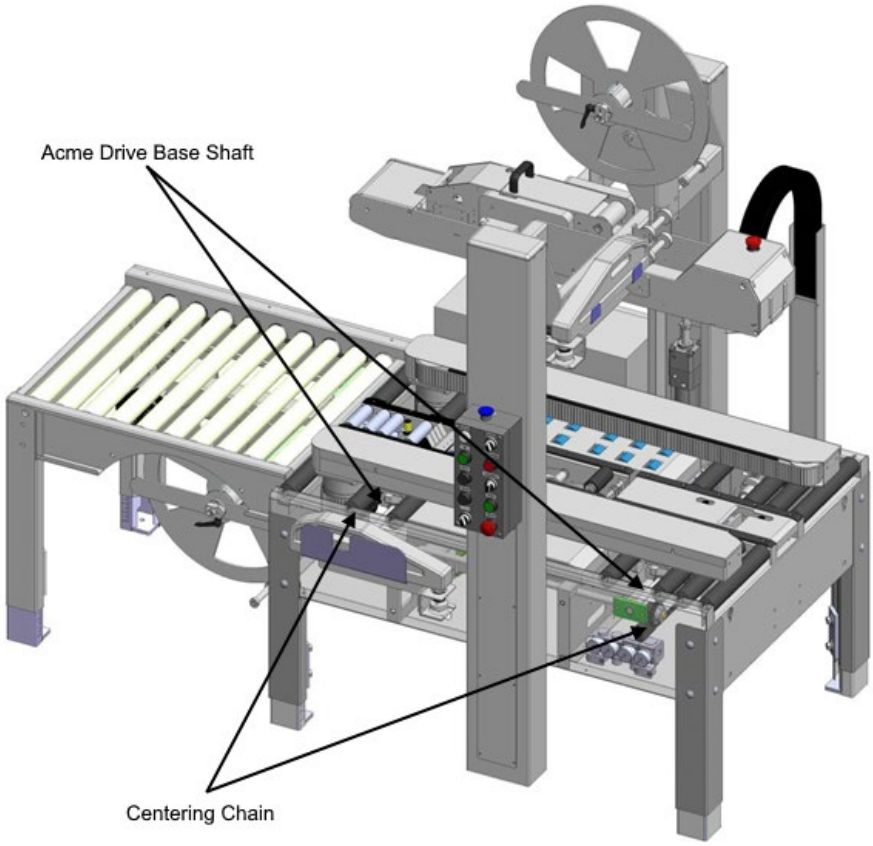


Figure 7-6 Lubricating the Machine

7.5 REMOVING THE TOP TAPE HEAD

For cutter blade maintenance and replacement, removal of the tape heads is required for ease of access. Make sure tape has been removed from the top tape head before attempting to remove them from machine.

1. Remove quick-disconnect from the top of tape head, (refer to Figure 7-7).
2. Disconnect electrical connection of tape head by unhinging and removing plug, (refer to Figure 7-8).
3. Turn off flow of water by turning valve until it is perpendicular to flow of water and remove quick-disconnect to allow removal of water pot, (refer to Figure 7-9).

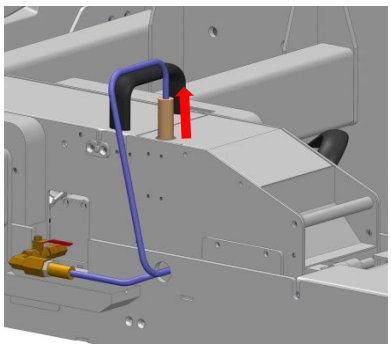


Figure 7-7 Quick-disconnect

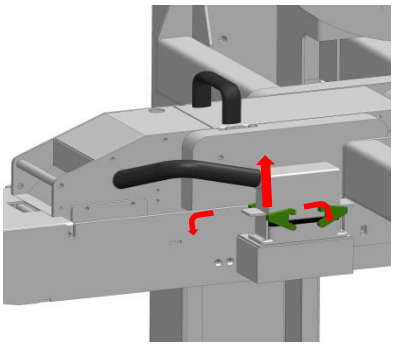


Figure 7-8 Electrical Disconnect

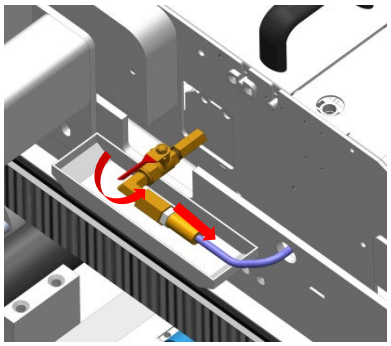


Figure 7-9 Quick-disconnect

4. Remove water pot from tape head, (refer to Figure 7-10).
5. Pull hold-down plate upwards to allow for removal of tape head, (refer to Figure 7-11).
6. Pull tape head forward then up to remove from tape head box, (refer to Figure 7-12).

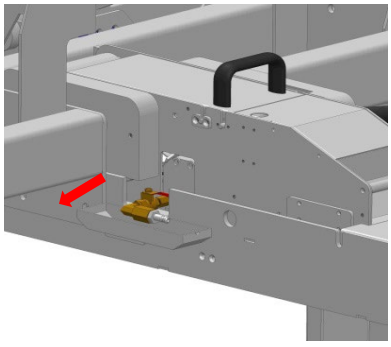


Figure 7-10 Remove Water Pot

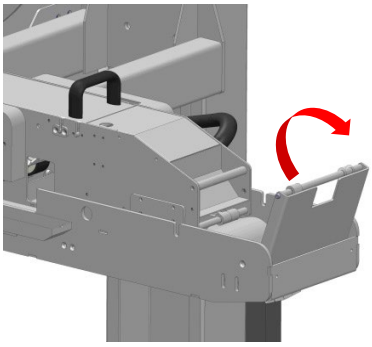


Figure 7-11 Pull Hold-down Plate

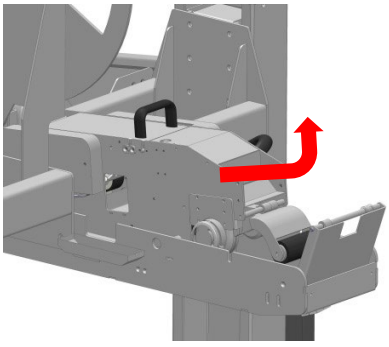


Figure 7-12 Remove Tape Head Box

7.6 REMOVING THE BOTTOM TAPE HEAD

For cutter blade maintenance and replacement, removal of the tape heads is required for ease of access. Make sure tape has been removed from the bottom tape head before attempting to remove them from machine.

1. Remove side covers on both sides of tape head, (refer to Figure 7-13).
2. Disconnect electrical connection of tape head by unhinging and removing plug, (refer to Figure 7-14).
3. Turn off flow of water by turning valve until it is perpendicular to flow of water and remove quick-disconnect to allow removal of water pot, (refer to Figure 7-15).

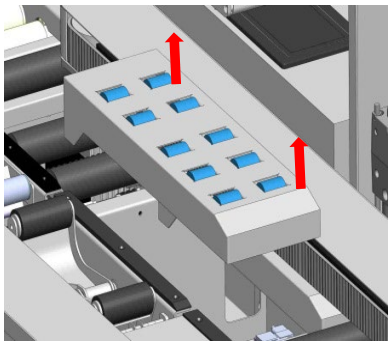


Figure 7-13 Remove Side Covers

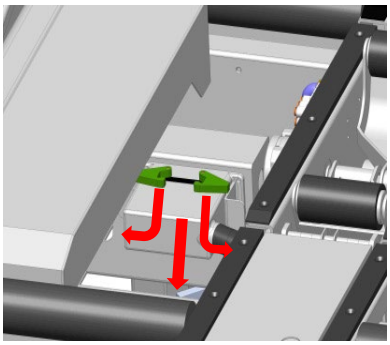


Figure 7-14 Electrical Disconnect

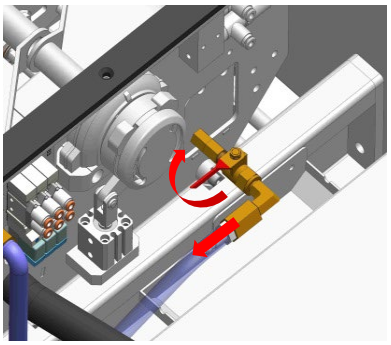


Figure 7-15 Quick-disconnect

4. Remove water pot from tape head, (refer to Figure 7-16).
5. Remove air quick-disconnect, (refer to Figure 7-17).
6. Lift tape head upwards to remove from tape head box, (refer to Figure 7-18).

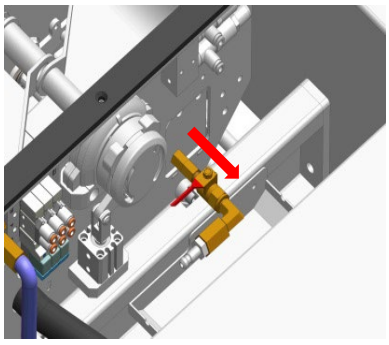


Figure 7-16 Remove Water Pot

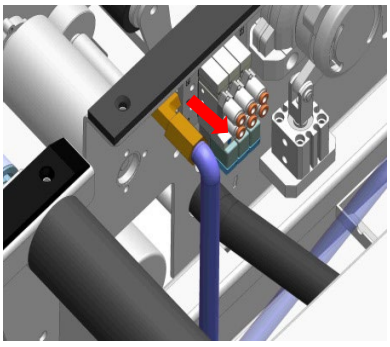


Figure 7-17 Quick-disconnect

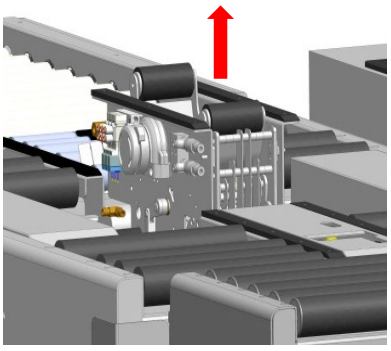


Figure 7-18 Lift Tape Head

7.7 CLEANING THE CUTTER BLADE (TOP TAPE HEAD)

> ⚠ **WARNING:** The knife contained in the tape heads is extremely sharp. Use caution when threading the tape or performing maintenance to avoid injury.

1. Remove top cover from tape head, (refer to Figure 7-19).
2. Remove tape shoe and water pot from tape head, (refer to Figure 7-20), to gain access to cutter blade area.
3. While retaining the knife arm position, clean the blade on both sides using damp cloth and a mild detergent. **Use caution as blade is extremely sharp.**
4. Clean the **Striker Plate** using damp cloth and a mild detergent (refer to Figure 7-21).
5. Insert water pot and tape shoe.

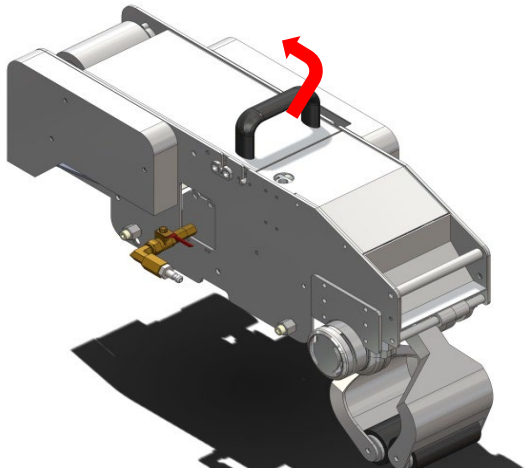


Figure 7-19 Remove Top Cover

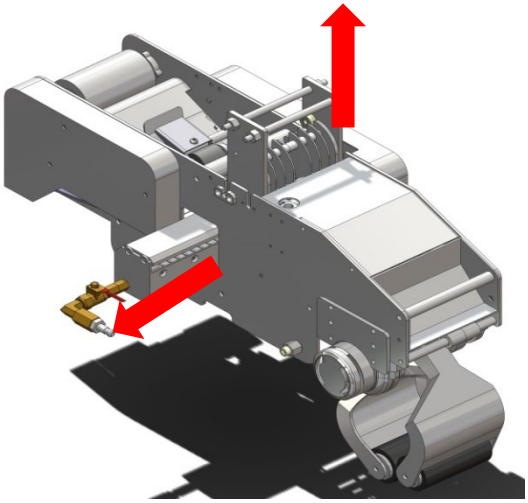


Figure 7-20 Remove Tape Shoe and Water Pot

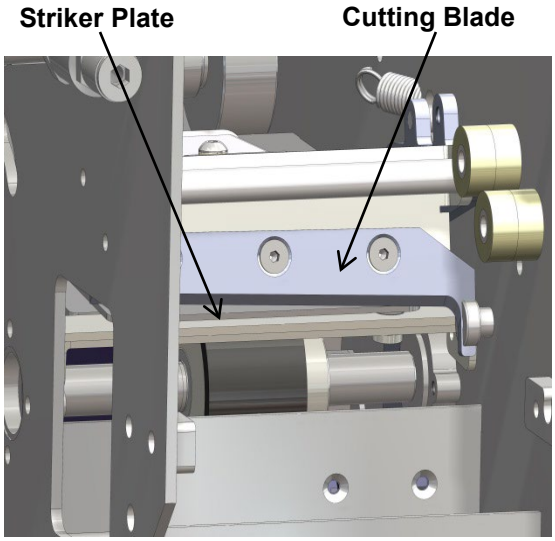


Figure 7-21 Clean Striker Plate

7.8 CLEANING THE CUTTER BLADE (BOTTOM TAPE HEAD)

> ⚠ **WARNING:** The knife contained in the tape heads is extremely sharp. Use caution when threading the tape or performing maintenance to avoid injury.

1. Remove tape shoe and water pot from tape head, (refer to Figures 7-22 and 7-23), to gain access to cutter blade area.
2. While retaining the knife arm position, clean the blade on both sides using damp cloth and a mild detergent. **Use caution as blade is extremely sharp.**
3. Clean the **Striker Plate** using damp cloth and a mild detergent (refer to Figure 7-24).
4. Re-insert water pot and tape shoe.

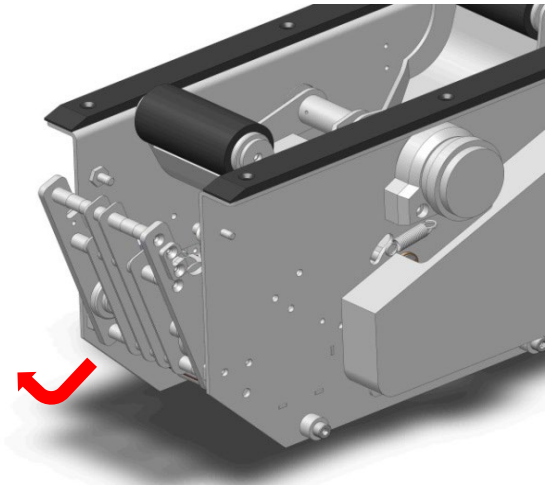


Figure 7-22 Remove Tape Shoe

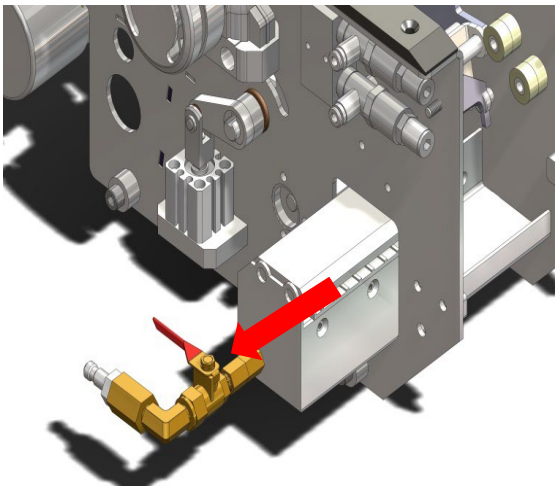


Figure 7-23 Remove Water Pot

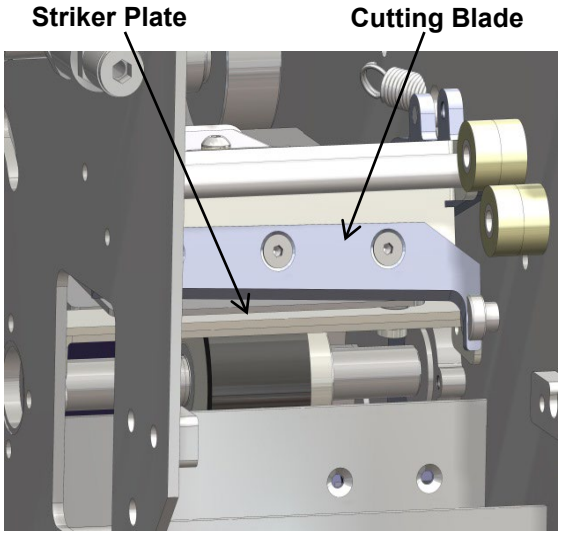


Figure 7-24 Clean Striker Plate

7.9 CUTTER BLADE MAINTENANCE

> **WARNING:** The knife contained in the tape heads is extremely sharp. Use caution when threading the tape or performing maintenance to avoid injury.

The cutter blade must rise when tape is being processed to allow the tape to proceed underneath. The blade must therefore raise and return without restriction (refer to Figure 7-25). Should the blade not raise and return when tape is processed, do the following:

1. Remove tape shoe from tape head from top tape head, (refer to Section 7.5) or tape shoe from tape head from bottom tape head, (refer to Section 7.6).
2. Remove the water pot from top tape head, (refer to Section 7.5) or water pot from tape head from bottom tape head, (refer to Section 7.6).
3. Observe to see when the blade raises that there is no hesitation or delay.
4. Observe to see that there is wide enough opening between cutter blade and the striker plate to allow the full tape width to pass through.
5. If no clearance is observed, clean the **Striker Plate** and **Cutter Blade** (see page 7-7 or page 7-8).
6. If above does not fix the problem, please contact technical support.
7. Replace tape shoe and water pot.

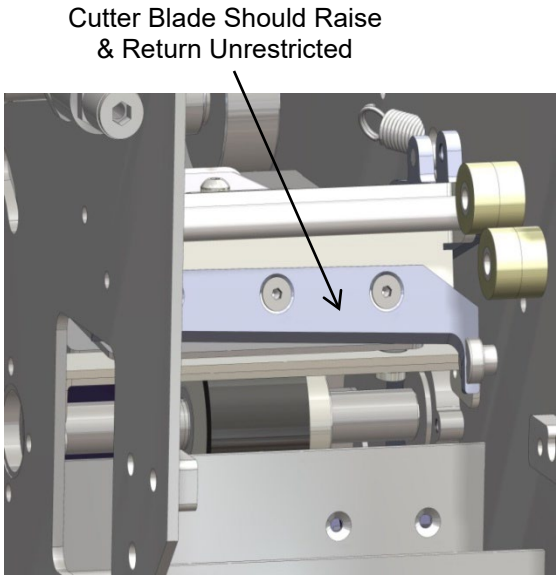


Figure 7-25 Cutter Blade Maintenance

7.10 CUTTER BLADE REPLACEMENT

> ⚠ **WARNING:** The knife contained in the tape heads is extremely sharp. Use caution when threading the tape or performing maintenance to avoid injury.

1. Remove tape shoe from tape head from top tape head, (refer to Section 7.5) or tape shoe from tape head from bottom tape head, (refer to Section 7.6).
2. Remove the water pot from top tape head, (refer to Section 7.5) or water pot from tape head from bottom tape head, (refer to Section 7.6).
3. Remove the upper guide plate, (refer to Section 7.5).
4. Remove the three 4mm countersink hex screws with a 2.5mm hex key.
5. Remove the cutter blade (refer to Figure 7-26).
6. Remove the two 4mm screws on the striker plate with a 2.5mm hex key.
7. Remove the striker plate (refer to Figure 7-27).
8. Replace the cutter blade and striker plate.
9. Place the water pot assembly and upper guide plate back into tape head.

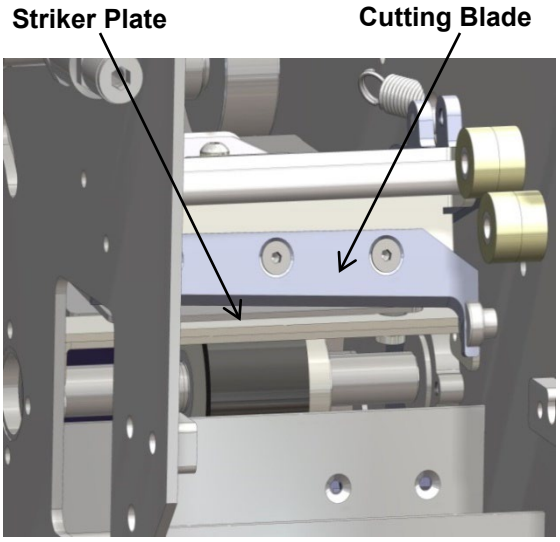


Figure 7-26 Striker Plate and Cutting Blade

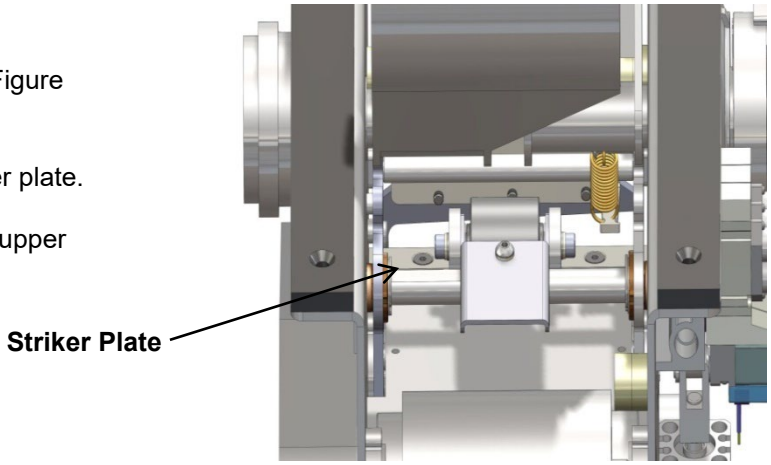
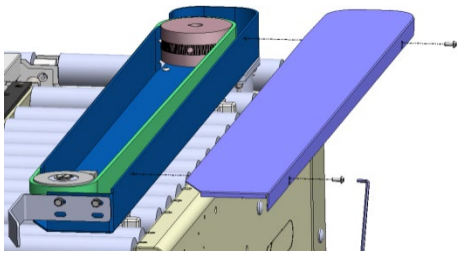
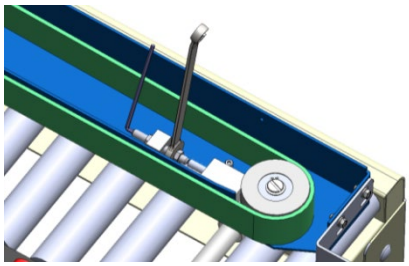
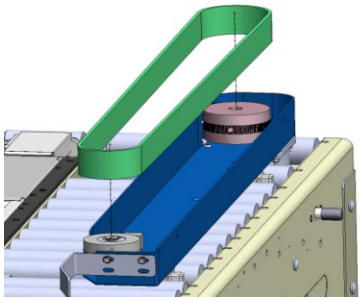
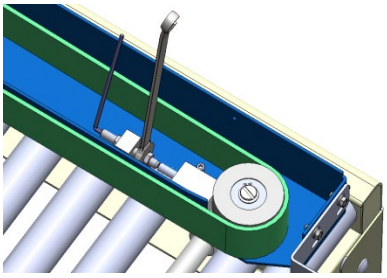
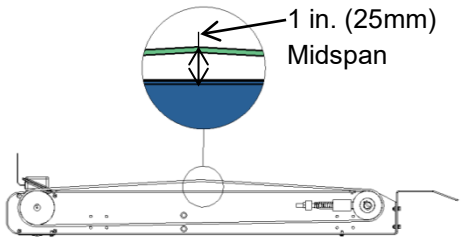
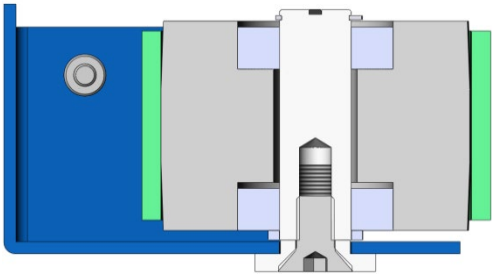
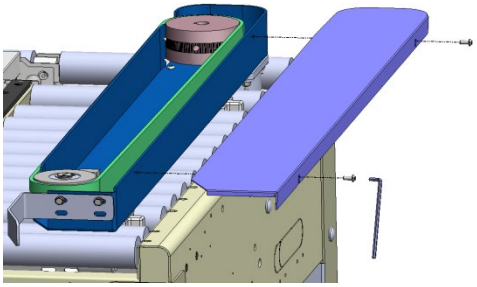


Figure 7-27 Striker Plate

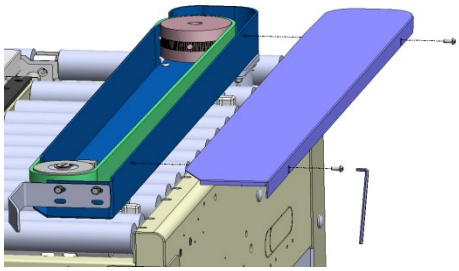
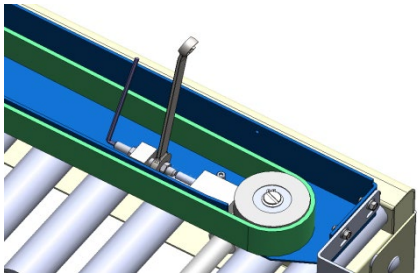
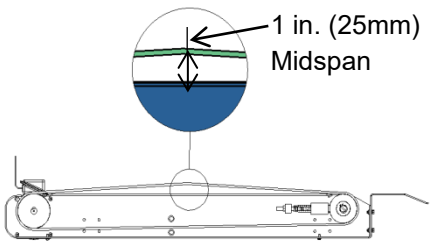
Chapter 8
MACHINE MAINTENANCE & ADJUSTMENT

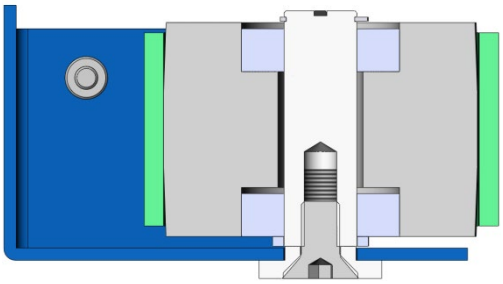
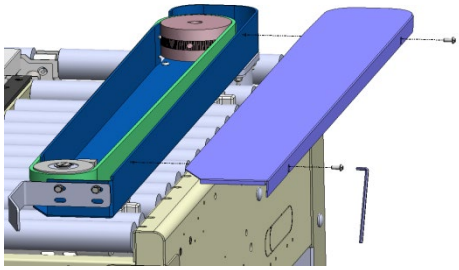
8.1 DRIVE BELT REPLACEMENT

Using a 4mm Allen key, remove two screws and remove drive base cover.	
Using appropriate Allen key and wrench, loosen belt tensioning bolts.	
Remove worn belt and replace with new belt.	
Using appropriate Allen key and wrench, tighten belt tensioning bolts. Be sure to equally adjust tensioning bolts for both drive belts.	
Proper belt tension is achieved when a 5-pound pull force is used to create a 25mm (1 in.) gap, as shown in the middle of the drive base.	

Intertape S/B drive idler pulleys are engineered to self-track to center. After tensioning, if the belts do not track on center, contact maintenance or your IPG Distributor.	
Using a 4mm Allen key, replace drive base cover, as shown.	

8.2 DRIVE BELT ADJUSTMENT

Using a 4mm Allen key, remove two screws and remove drive base cover.	
Using appropriate Allen key and wrench, tighten belt tensioning bolts. Be sure to adjust upper and lower tensioning bolts equally.	
Proper belt tension is achieved when a 5-pound pull force is used to create a 25mm (1 in.) gap as shown in the middle of the drive base.	

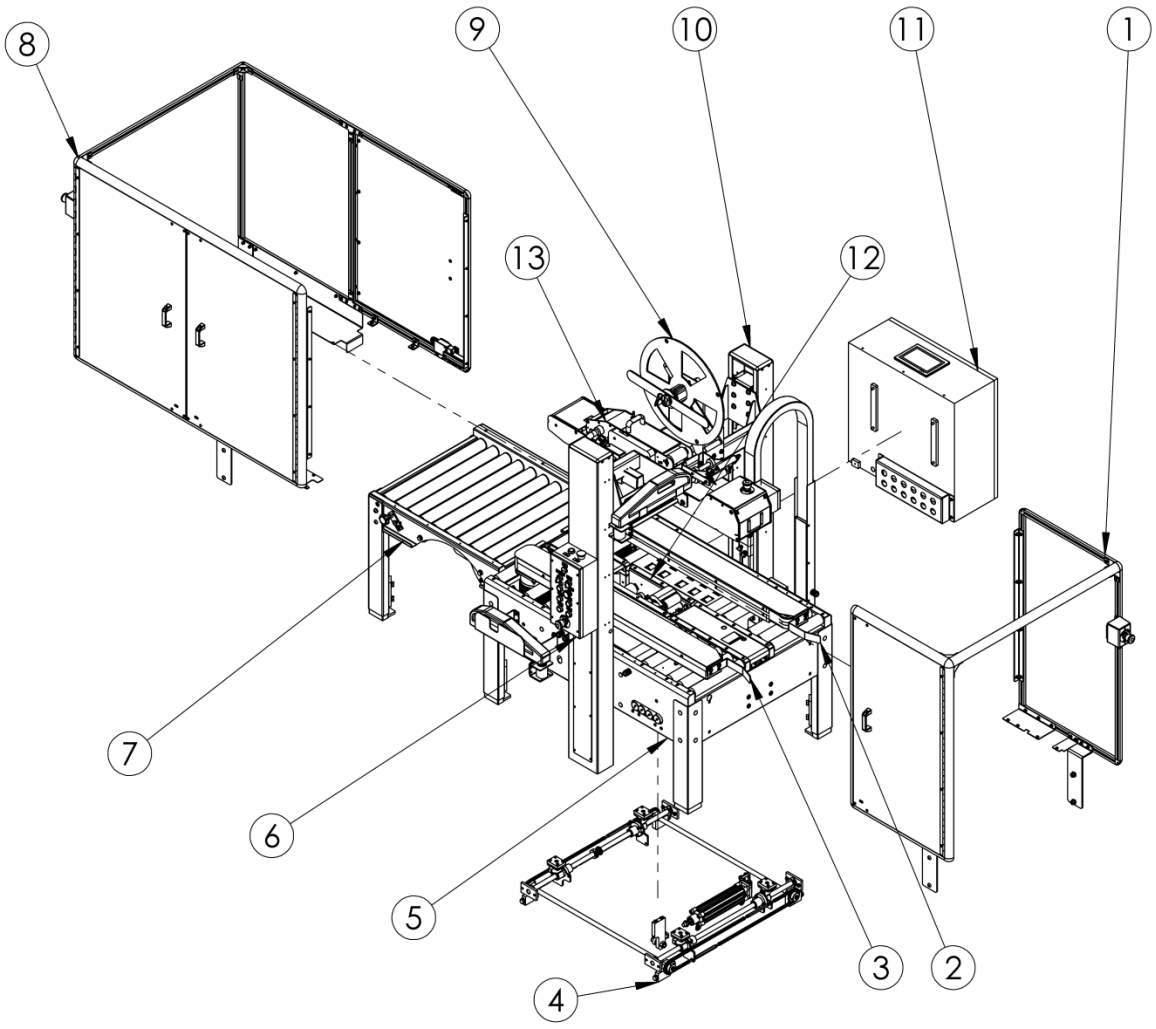
Intertape S/B drive idler pulleys are engineered to self-track to center. After tensioning, if the belts do not track on center, contact maintenance or your IPG Distributor.	
Using a 4mm Allen key, replace drive base cover as shown.	

Notes

Chapter 9
ILLUSTRATED PARTS LIST

List of Assemblies

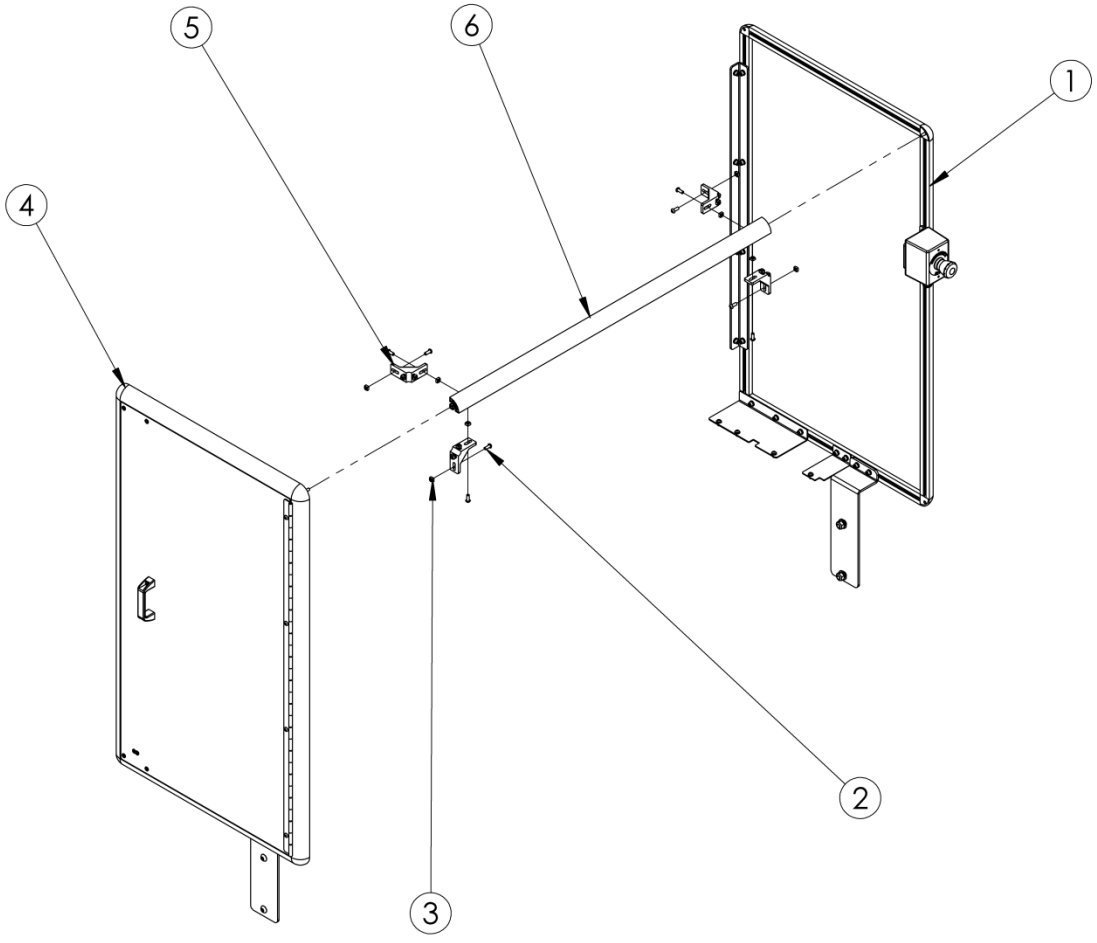
9.1 UM905TW - RSA2024-WAT-EU TOP LEVEL ASSEMBLY



UM805T - RSA2024-WAT-EU CASE SEALER

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	UAM0534	EU FRONT DOOR GUARDING ASSEMBLY	1
2	UAM0511	DRIVE UNIT, R.H	1
3	UAM0510	DRIVE UNIT, L.H	1
4	Z5310-00BA00	GUIDE ADJUSTMENT ASSEMBLY	1
5	USM0867	BASE ASSEMBLY	1
6	UAM0518	EU CONTROL BOX	1
7	UAM0489	OUTPUT TABLE	1
8	UAM0535	EU REAR DOOR GUARDING ASSEMBLY	1
9	UAM0512	BRIDGE ASSEMBLY	1
10	UAM0536	EU COLUMN ASSEMBLY	1
11	UAM0503	ELECTRICAL BOX	1
12		BOTTOM TAPE HEAD	1
13		TOP TAPE HEAD	1

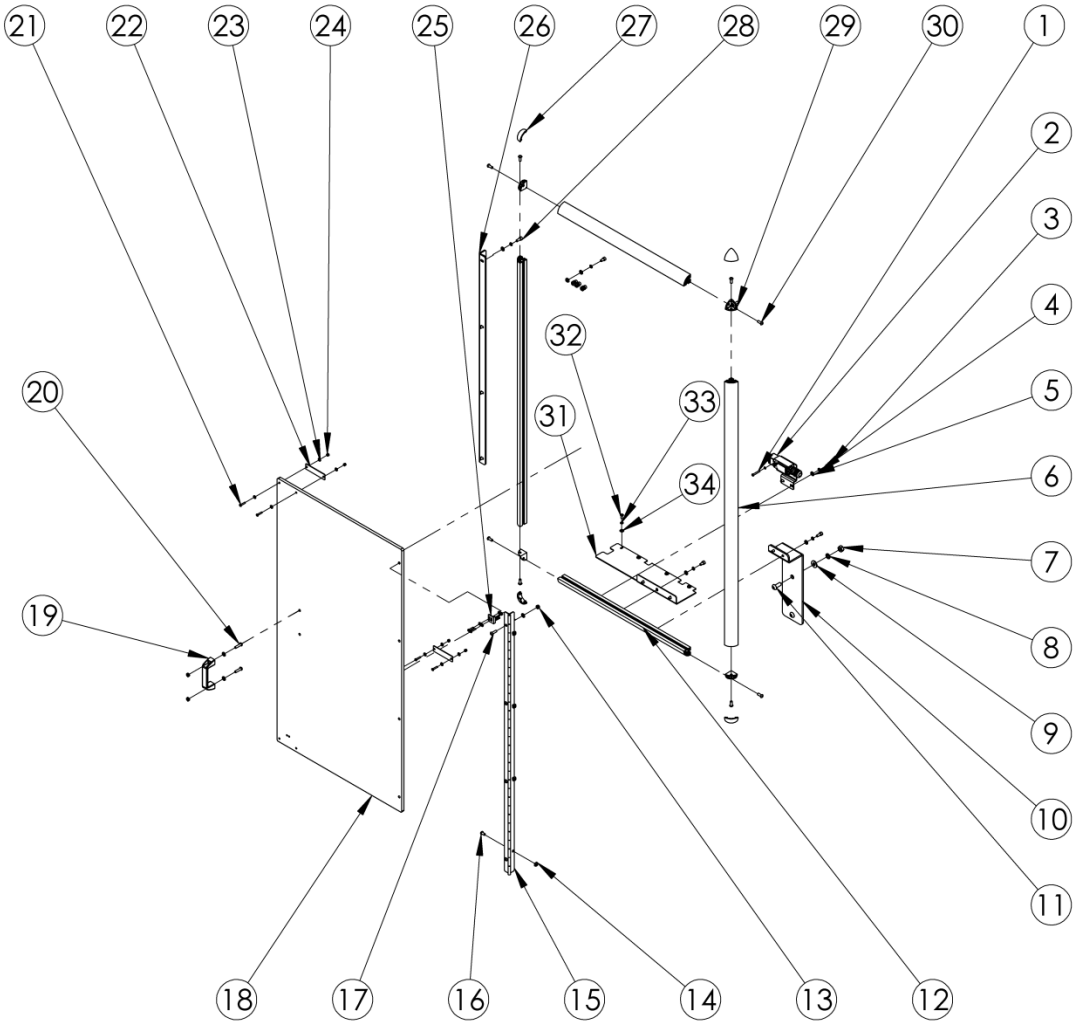
9.2 UAM0534 - FRONT DOOR GUARDING ASSEMBLY



UAM0534 - FRONT DOOR GUARDING ASSEMBLY

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	UAM0520	RSA FIXED GUARD ASSEMBLY	1
2	UF1250EV	BHCS M6-1.0X16L	16
3	UF3399	M6 INSERT NUT	16
4	UAM0519	RSA SINGLE DOOR GUARD ASSEMBLY	1
5	UPM6277	DOOR GUARDING CORNER BRACKET	4
6	UPM6296	DOOR GUARDING FRAME	1

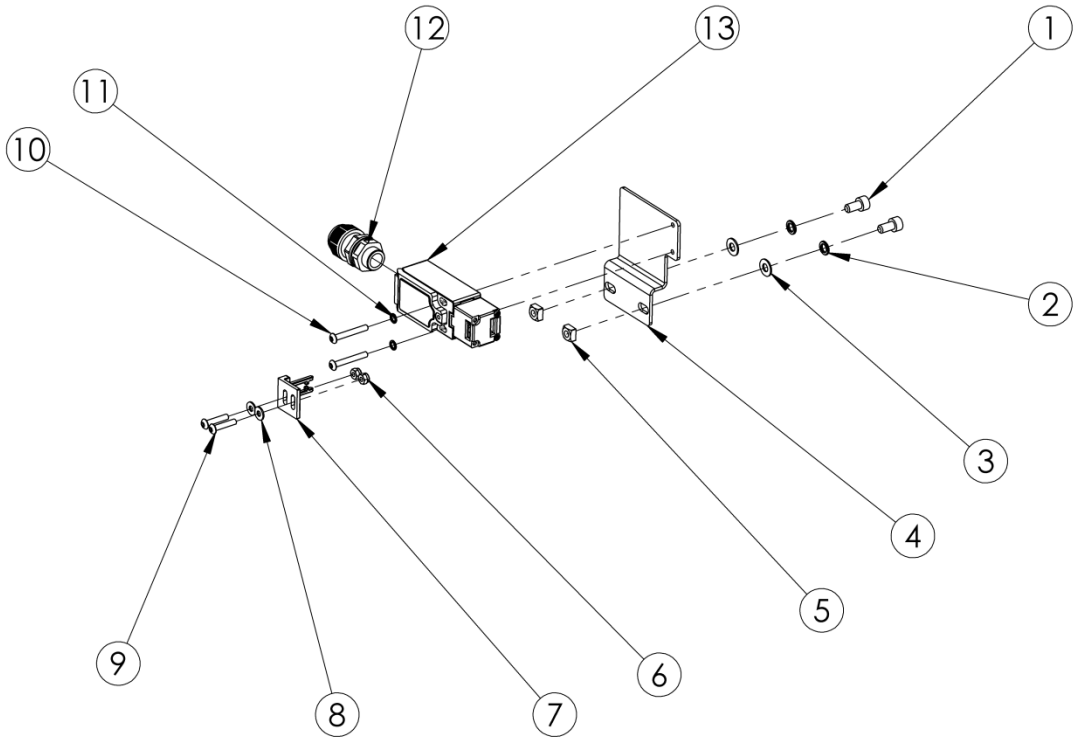
9.3 UAM0519 – SINGLE DOOR GUARDING ASSEMBLY



UAM0519 – SINGLE DOOR GUARDING ASSEMBLY

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	UPM6286	DOOR GAURDING LATCH ACTUATOR	1
2	UF6363	LW M6	23
3	UF3681	M4 LW	2
4	UF7023	LW M5	4
5	UF6371	LW M10	2
6	UF1828	FW M6	29
7	UF3710	FW M4	10
8	UF1827	FW M5	4
9	UF3680	FW M10	2
10	UF0012	HNR M10-1.5	2
11	UPM6289	DOORGUARDING LOWER MOUNT	1
12	UF6404	BHCS M10-1.5X25	2
13	UPM6296	DOOR GUARDING FRAME (560mm)	2
14	UPM6296	DOOR GUARDING FRAME 1014L	2
15	UF5900	M6 LOCK-NUT	6
16	UF6376	M4 LOCK-NUT	6
17	UF3399	M6 INSERT NUT	20
18	UPM6279	DOOR GUARDING HINGE	1
19	UPM6278	DOOR GUARDING PANEL	1
20	UPM6281	DOOR GUARDING HANDLE	1
21	UF4050EV	BHCS M4-0.7X20	6
22	UF0071	BHCS M4-0.7X30L	2
23	UPM6280	DOOR GUARDING STOPPER PANEL	2
24	UPM6283	DOOR GUARDING LATCH	1
25	UPM6277	DOOR GUARDING CORNER BRACKET	1
26	UPM6282	DOOR GUARDING CORNER CAP	4
27	UF0038	SHCS M6-1.0X12L	17
28	UF0830	M6-1.0-SHCS	6
29	UPM6284	DOOR GUARDING CORNER	4
30	UF1250EV	BHCS M6-1.0X16	9

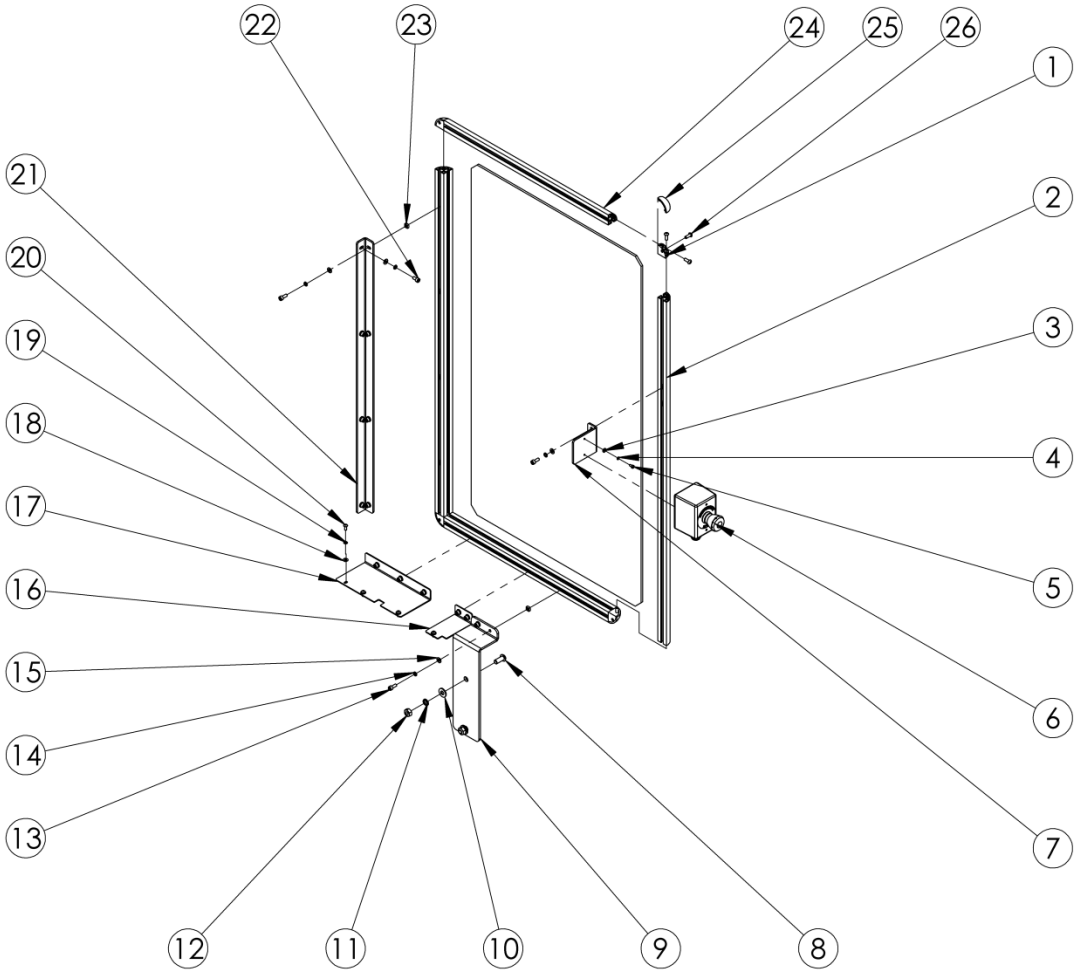
9.3.1 M8141 – DOOR SWITCH



M8141 – DOOR SWITCH

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	UF0038	SHCS M6-1.0X12	6
2	UF6363	M6 LW	6
3	UF1828	M6 FW	6
4	UPM6288	"DOOR GUARDING LOWER MOUNT SM-L	1
5	UF0025	M6 INSERT NUT	10
6	UF6376	M4 LOCK-NUT	2
7	UPM6283	DOOR GUARDING LATCH	1
8	UF3710	M4 FW	2
9	UF4050EV	BHCS M4-0.7X20	2
10	UF0071	BHCS M4-0.7X30	2
11	UF3681	M4 LW	2
12	UPM5873	CABLE GLANDS	1
13	UPM6286	"DOOR GUARDING LATCH ACTUATOR	1
14	M6-1.0×16L	BHCS M6-1.0X16	1
15	M6-1.0×12L	BHCS M6-1.0X12	8
16	M5-0.8×12L	BHCS M5-0.8X12	8
17	M5	M5 LW	8
18	M5-12-1.0	M5 FW	8
19	M10-1.5×25L	BHCS M10-1.5X25	2
20	M10-23-2.0	M10 FW	2
21	M10	M10 LW	2
22	M10-1.5	M10-1.5 HNR	2

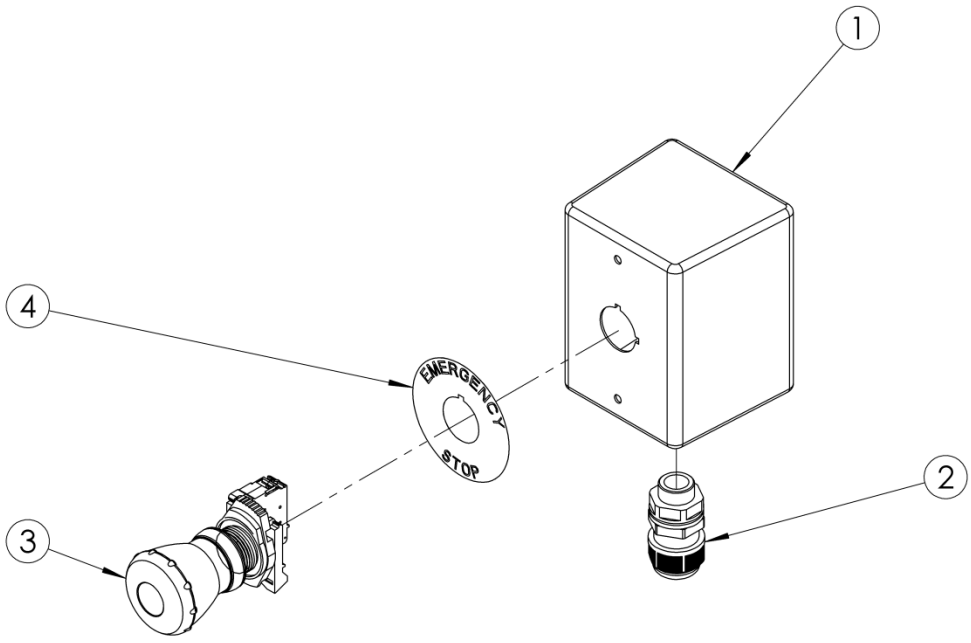
9.4 UAM0520 – FIXED GUARDING ASSEMBLY



UAM0520 – FIXED GAURDING ASSEMBLY

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	UPM6284	DOOR GUARDING CORNER	4
2	UPM6296	DOOR GUARDING FRAME 1014L	2
3	UF3710	FW M4	2
4	UF3681	M4 LW	2
5	UF0869	SHCS M4-0.7X8	2
6	UPM5733	E-STOP	1
7	UPM6293	GUARDING E-STOP MOUNTING BRACKET	1
8	UF6404	BHCS M10-1.5X25	2
9	UPM6289	DOOR GUARDING LOWER MOUNT LG	1
10	UF3680	FW M10	2
11	UF6371	LW M10	2
12	UF0012	HNR M10-1.5	2
13	UF0830	SHCS M6-1.0X16	8
14	UF6363	LW M6	17
15	UF1828	FW M6	17
16	UPM6294	DOOR GUARDING LOWER BRACKET SM	1
17	UPM6295	DOOR GUARDING LOWER BRACKET LG	1
18	UF1827	FW M5	4
19	UF7023	LW M5	4
20	UF3687	BHCS M5-0.8X12	4
21	UPM6285	DOOR GUARDING VERTICAL MOUNT	1
22	UF0038	SHCS M6-1.0X12L	9
23	UF3399	M6 INSERT NUT	13
24	UPM6296	DOOR GUARDING FRAME 560L	2
25	UPM6282	DOOR GUARDING CORNER CAP	4
26	UF1250EV	BHCS M6-1.0X16L	9

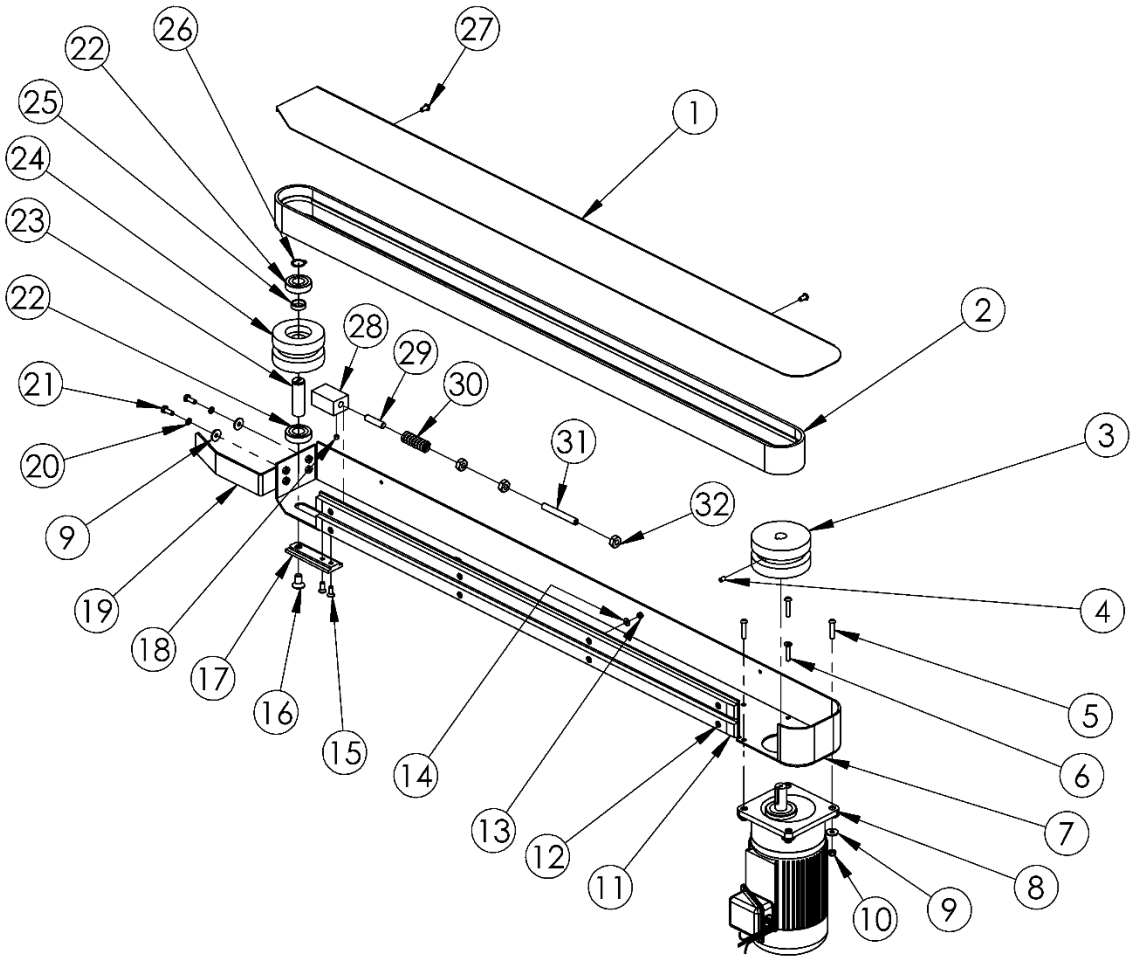
9.5 USM8075 – SECOND E-STOP



USM8075 – SECOND E-STOP

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	UPM5873	CABLE GLANDS	1
2	UPM5733	E-STOP	1
3	UPM6045	E-STOP LABEL	1
4	UPM6170	BUTTON BOX	1

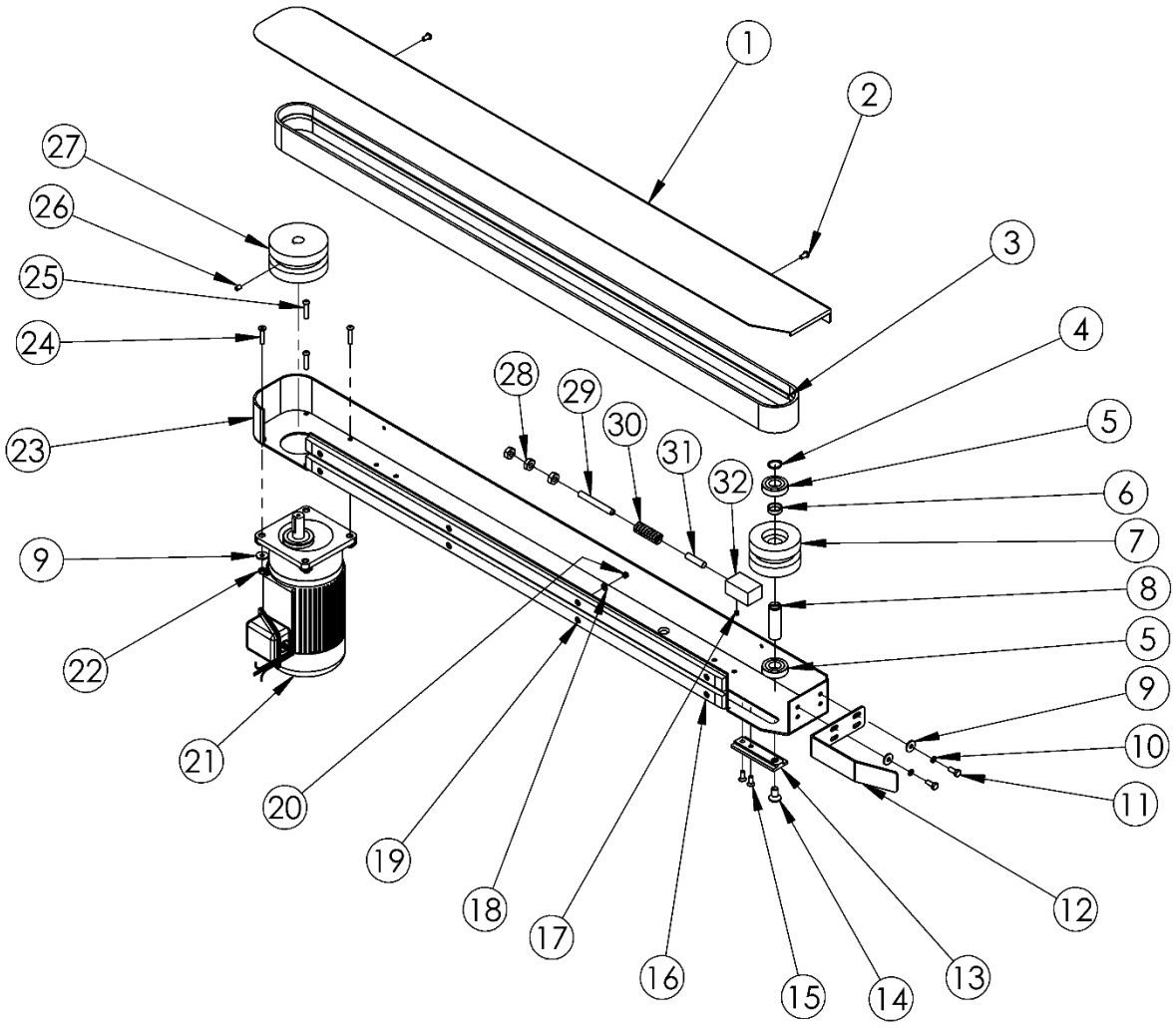
9.6 UAM0510 – DRIVE UNIT, LEFT HAND



UAM0510 – DRIVE UNIT, LEFT HAND

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	UPM4975	COVER LEFT SIDE	1
2	UPM7468	DRIVING BELT 50 x 2360L	1
3	UPM4883	DRIVE PULLEY	1
4	UF3683	M6-1.0-SSS	2
5	UF3752	BHCS M6-1.0×30L	3
6	UF3712	FHCS M6-1.0×30L	1
7	UPM6163	DRIVE WELDMENT, L.H	1
8	UPM4008	MOTOR 1/3HP 25:1 NEMA4	1
9	UF0103	M6 FW, 19MM OD 2MM THK	6
10	UF5900	LOCK-NUT M6	4
11	UPM4974	BELT PAD	2
12	UF3169	SHCS M5-0.8 x 16mm	8
13	UF3393	LOCK-NUT	8
14	UF1827	M5 FW	8
15	UF1192	FHCS M6-1.0×16L	2
16	UF3748	M10-1.5-FHCS	1
17	UPM2156	TENSIONER ALIGNMENT PLATE	1
18	UF1411	M6-1.0-SSS	1
19	UPM0647	CARTON RETAINER	1
20	UF6363	LW M6	2
21	UF0454	M6-1.0-HHCS	2
22	UPM0324	BEARING PULLEY	2
23	UPM1233EV	IDLER PULLEY SHAFT 50mm	1
24	UPM4885	IDLER PULLEY	1
25	UPM0109	IDLER PULLEY SPACER	1
26	UF0017	Ø12MM SNAP RING	1
27	UF5600	BHCS M6-1.0×12L	2
28	UPM0101	TENSIONER BACKING PLATE	1
29	UPM0112	SPRING LOCATOR PIN	1
30	UPM0038	DIE SPRING (DRIVE BASE)	1
31	UF1400	SSS HK 3/8-16 X 3"	1
32	UF3377	3/8"-16-HNR	3

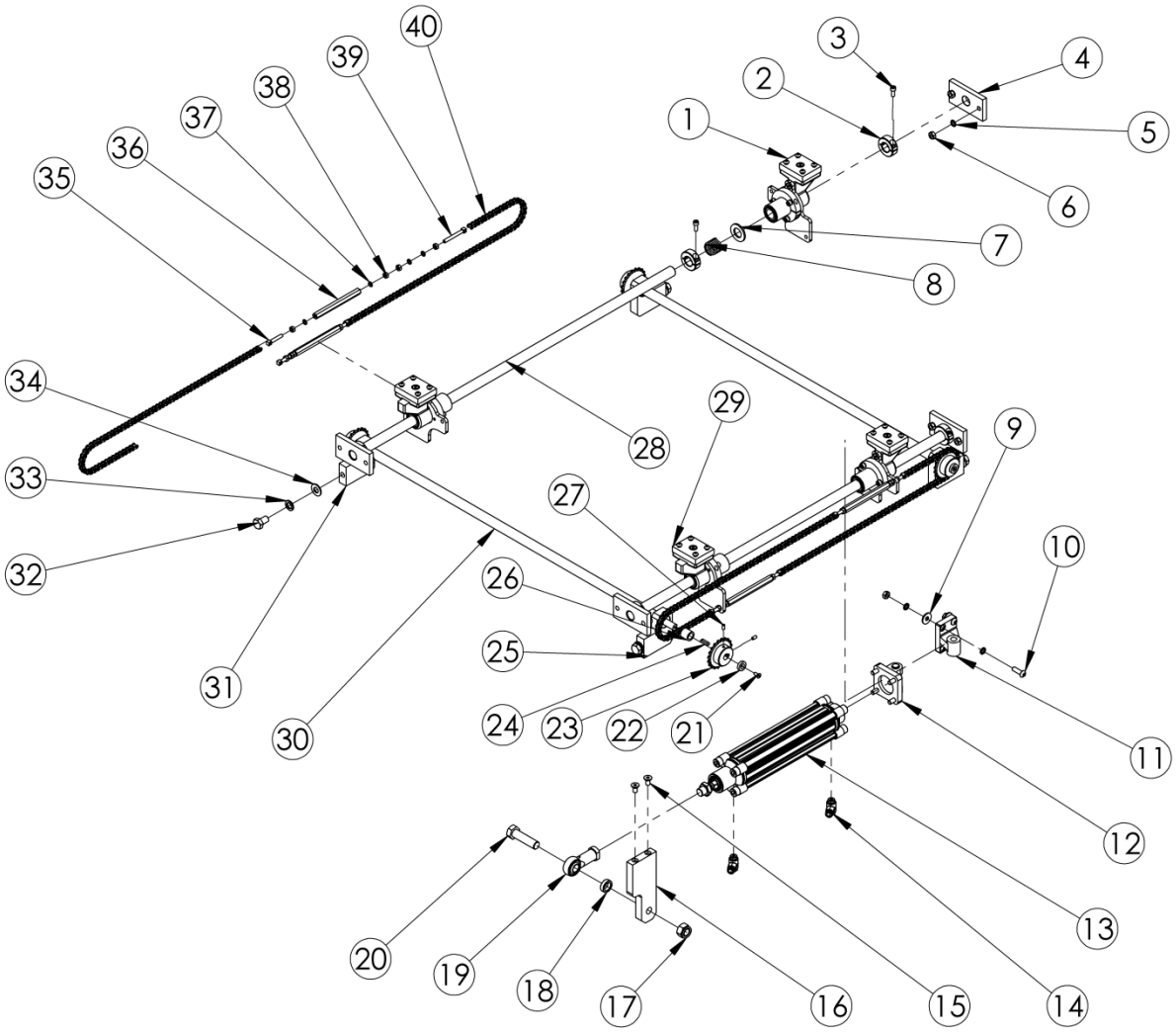
9.7 UAM0511 – DRIVE UNIT, RIGHT HAND



UAM0511 – DRIVE UNIT, RIGHT HAND

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	UPM4973	COVER RIGHT SIDE	1
2	UF5600	BHCS M6-1.0×12L	2
3	UPM7468	DRIVING BELT 50 x 2360L	1
4	UF0017	Ø12MM SNAP RING	1
5	UPM0324	BEARING PULLEY	2
6	UPM0109	IDLER PULLEY SPACER	1
7	UPM4885	IDLER PULLEY	1
8	UPM1233EV	IDLER PULLEY SHAFT 50mm	1
9	UF0103	M6 FW, 19MM OD 2MM THK	6
10	UF6363	LW M6	2
11	UF0454	M6-1.0-HHCS	2
12	UPM0647	CARTON RETAINER	1
13	UPM2156	TENSIONER ALIGNMENT PLATE	1
14	UF3748	M10-1.5-FHCS	1
15	UF1192	FHCS M6-1.0×16L	2
16	UPM4974	BELT PAD	2
17	UF1411	M6-1.0-SSS	1
18	UF1827	M5 FW	8
19	UF3169	SHCS M5-0.8 x 16mm	8
20	UF3393	LOCK-NUT	8
21	UPM4008	MOTOR 1/3HP 25:1 NEMA4	1
22	UF5900	LOCK-NUT M6	4
23	UPM6164	DRIVE WELDMENT, R.H	1
24	UF3712	FHCS M6-1.0×30L	1
25	UF3752	BHCS M6-1.0×30L	3
26	UF3683	M6-1.0-SSS	2
27	UPM4883	DRIVE PULLEY	1
28	UF3377	3/8"-16-HNR	3
29	UF1400	SSS HK 3/8-16 X 3"	1
30	UPM0038	DIE SPRING (DRIVE BASE)	1
31	UPM5759	DOWEL Ø9.5MM X 38MM LG	1
32	UPM0101	TENSIONER BACKING PLATE	1

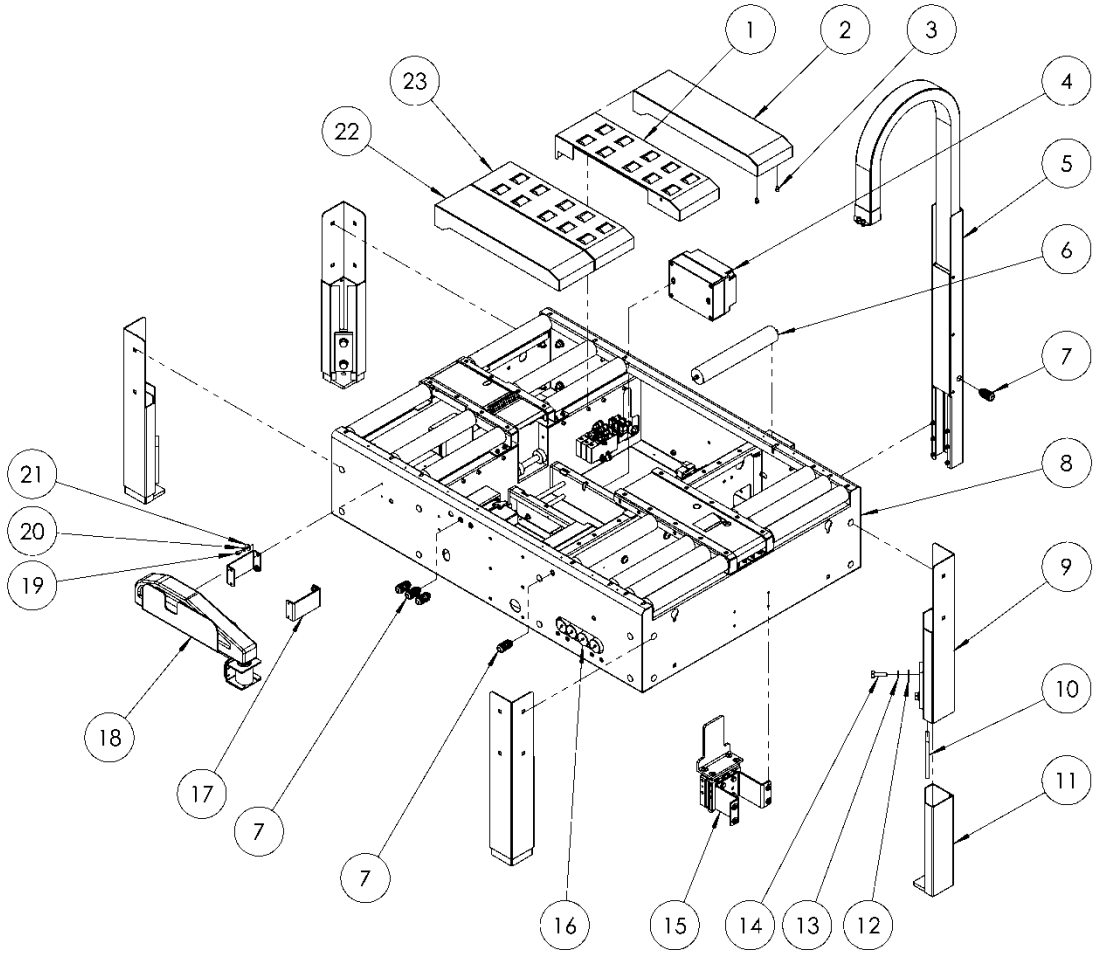
9.8 UAM0508 – GUIDE ADJUSTMENT ASSEMBLY



UAM0508 – GUIDE ADJUSTMENT ASSEMBLY

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	UAM0141	DRIVE SUPPORT RSA2024 2000	2
2	UPM3330	SHAFT COLLAR 20mm / SS	5
3	UF0079	SHCS M6-1.0X16	5
4	UPM3250 / 6079	SHAFT ANCHOR PLATE / SS	4
5	UF0867	M8 LW	16
6	UF0866	M8-1.25 HNR	12
7	UF0048	M20 FW	1
8	UPM3401	SPRING FOR 20mm SHAFT, LC 112 M0	1
9	UF3643	M8 FW	4
10	UF3802	BHCS M8-1.25X25	4
11	UPM6377	CYLINDER MOUNT	1
12	UPM6378	CYLINDER MOUNT	1
13	UPM6379	PNEUMATIC CYLINDER	1
14	UPM6383	PNEUMATIC 90 DEG CONNECTOR	2
15	UF3684	FHCS M8-1.25X16	2
16	UPM6381	DRIVE MOTOR CONNECTION BLOCK	1
17	UF0066	NYLON LOCK-NUT M16	1
18	UPM6382	SPACER	1
19	UPM6380	CYLINDER ROD CONNECTOR	1
20	UF4305	HHCS M16-2.0X60	1
21	UF5400	FHCS M5-0.8X12	4
22	UPM0150	SPROCKET SHAFT WASHER	4
23	UPM0028	SPROCKET	4
24	UPM5773	KEY 5X5X20	4
25	UPM3262 / 3275	SPROCKET SHAFT BEARING HOUSING RH RSA2024 2000 / LH	2
26	UPM1646	SPROCKET SHAFT SPACER (LONG)	4
27	UF3716	SSS M5-0.8X10	8
28	UPM3251 / 3316 / 4519	SHAFT 20mm RSA 2024 2000	2
29	UAM 0141	DRIVE SUPPORT RSA 2024 2000	2
30	UPM6269	SHAFT, 888.6mm L	2
31	UPM3262 / 3275	SPROCKET SHAFT BEARING HOUSING	2
32	UF0061	HHCS M12-1.75X20	4
33	UF4230	LW M12	4
34	UF4231	M12 FW	4
35	UPM3259	CHAIN THREADED LINK LH	4
36	UPM3255	TURNBUCKLE	4
37	UF6363	LW M6	16
38	UF3637	M6-1.0 HNR	16
39	UPM3260	CHAIN THREADED LINK RH	4
40	UPM6272	CHAIN #35	4

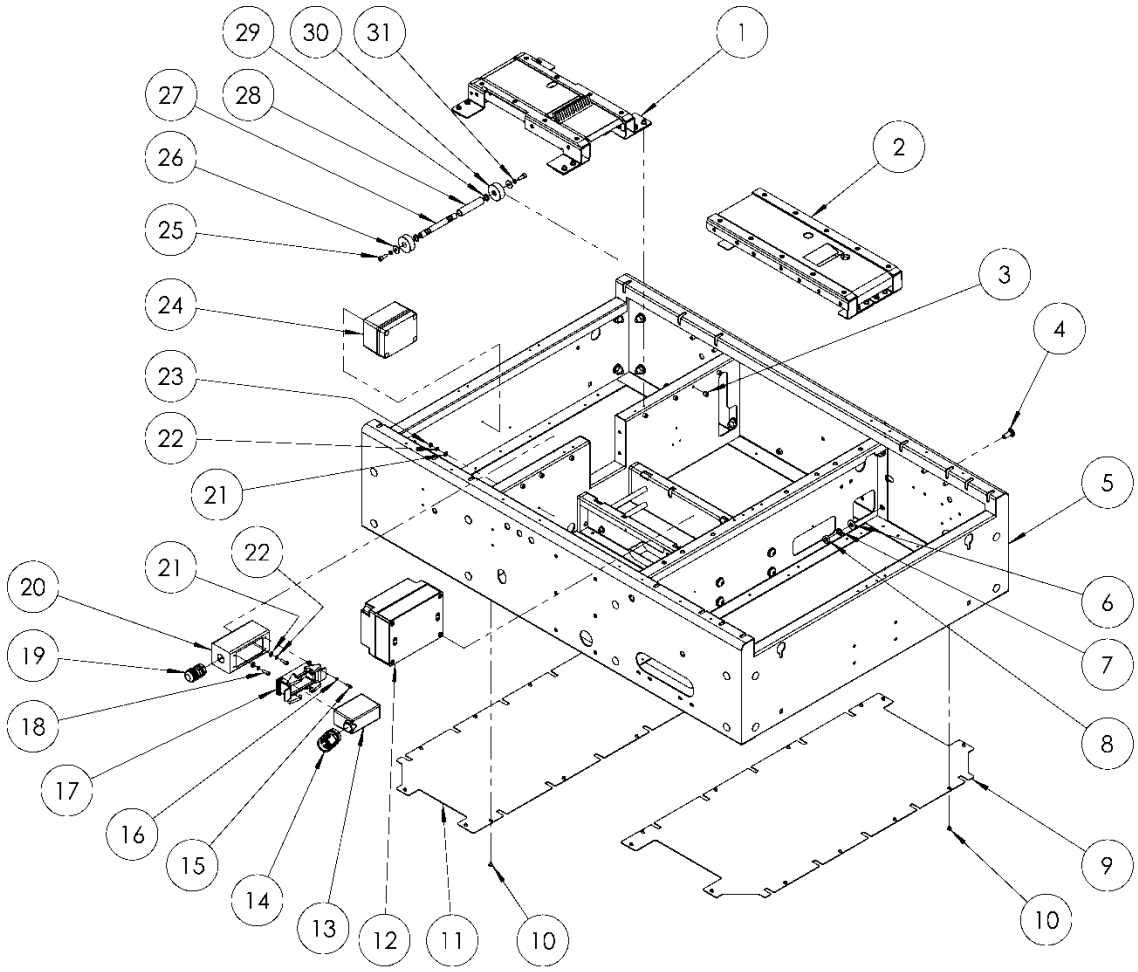
9.9 USM0867 – BASE ASSEMBLY



USM0867 – BASE ASSEMBLY

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	UAM0477	ROLLER ASSEMBLY, R.H.	1
2	UPM4930	SIDE COVER	1
3	UF0086	SHCS M6-1.0X8	4
4	UPM6267	WIRING BOX	1
5	UAM0533	CORD SLEEVE ASSEMBLY	1
6	UPM3226	PVC ROL CHARCOAL DIA 1.9 X 12.00	14
7	UPM5873	CABLE GLANDS	5
8	UAM0468	FRAME ASSEMBLY	1
9	UPM0602 / 2830	LEG MAIN FRAME WELMENT	4
10	UPM0931/2832	LEG FRICTION PLATE	4
11	UPM0847	LEG ADJUSTMENT WELDMENT	4
12	UF4231	M12 FW	4
13	UF4230	LW M12	4
14	UF6393	HHCS M12-1.75 X 35L	4
15	UAM0483	INLET STOP ASSEMBLY	1
16	UPM6359	PRESSURE GAGE	1
17	UPM6358	LOWER WATER BOTTLE STANDOFF	2
18	USM0901	WATER BOTTLER HOLDER ASSEMBLY	1
19	UF0038	SHCS M6-1.0X12L	4
20	UF6363	LW M6	4
21	UF1828	M6 FW	4
22	UPM4930	SIDE COVER	1
23	UAM0474	ROLLER ASSEMBLY, L.H.	1

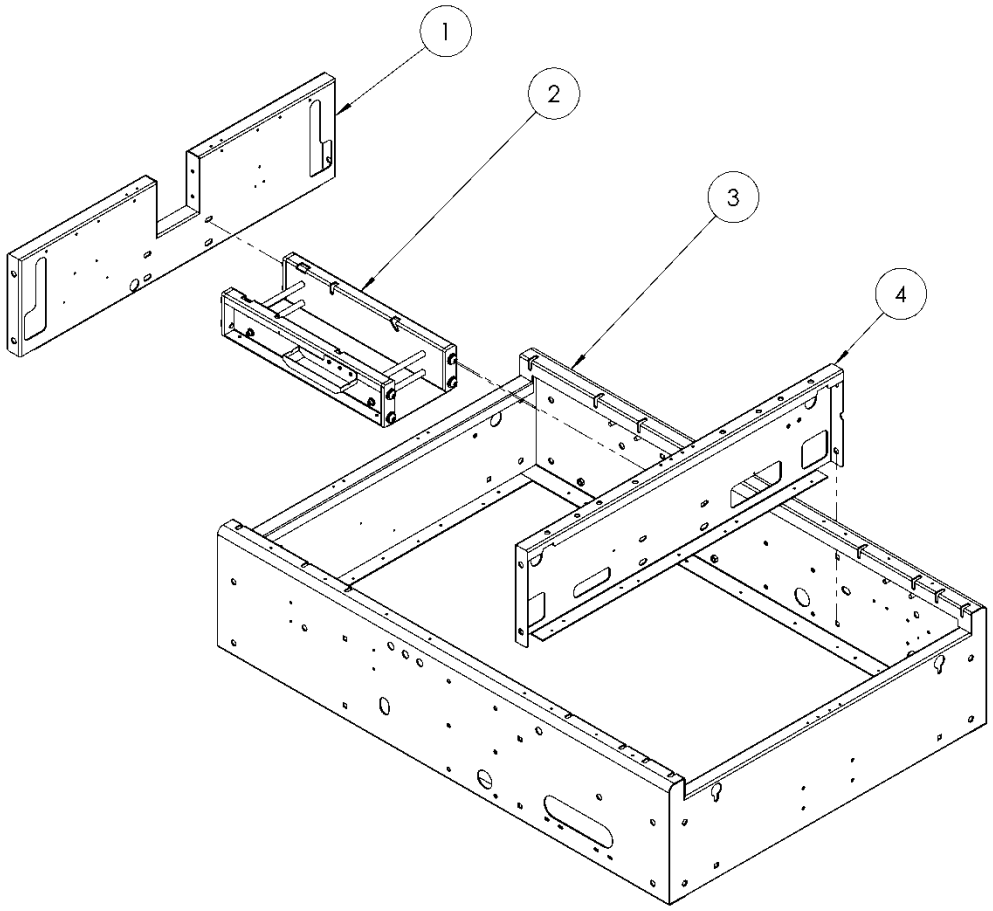
9.9.1 UAM0468 - FRAME ASSEMBLY



UAM0468 - FRAME ASSEMBLY

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	UAM0478	OUTLET TABLE ASSEMBLY	1
2	UAM0473	INLET TABLE ASSEMBLY	1
3	UF122	SHCS M6-1.0X6	8
4	UF4020	W3/8"-16×1"-CARRIAGE BOLT	24
5	UAM0469	BASE WELDMENT	1
6	UF3680	FW M10	24
7	UF6371	LW M10	24
8	UF1540	HNR 3/8"-16	24
9	UPM6386	FRAME COVER	1
10	UF5601	BHCS M5-0.8X6	24
11	UPM6387	FRAME COVER	1
12	UPM6273	WIRING BOX	1
13	UPM4939	ELECTRICAL RECEPTACLE CONNECTION MALE	1
14	UPM4905	CORD GRIP	1
15	UF9148	SHCS M4-0.7X10	4
16	UF3681	M4 LW	4
17	UPM4938	RECEPTACLE CONNECTION	1
18	UF3169	SHCS M5-0.8X16	2
19	UPM5873	CABLE GLANDS	1
20	UPM4929	ELECTRICAL RECEPTACLE BASE	1
21	UF1827	FW M5	4
22	UF7023	LW M5	4
23	UF6307	HNR M5-0.8	2
24	UPM6267	WIRING BOX	1
25	UF0830	SHCS M6-1.0X16	2
26	UF1828	M6 FW	2
27	WET0187	SHAFT, 115L	1
28	WET0189	ROLLER, dia 17, 72L	1
29	UPM4936	RUBBER RING	2
30	WET0188	GUIDE ROLLER, 40OD	2
31	UF 6363	LW M6	2

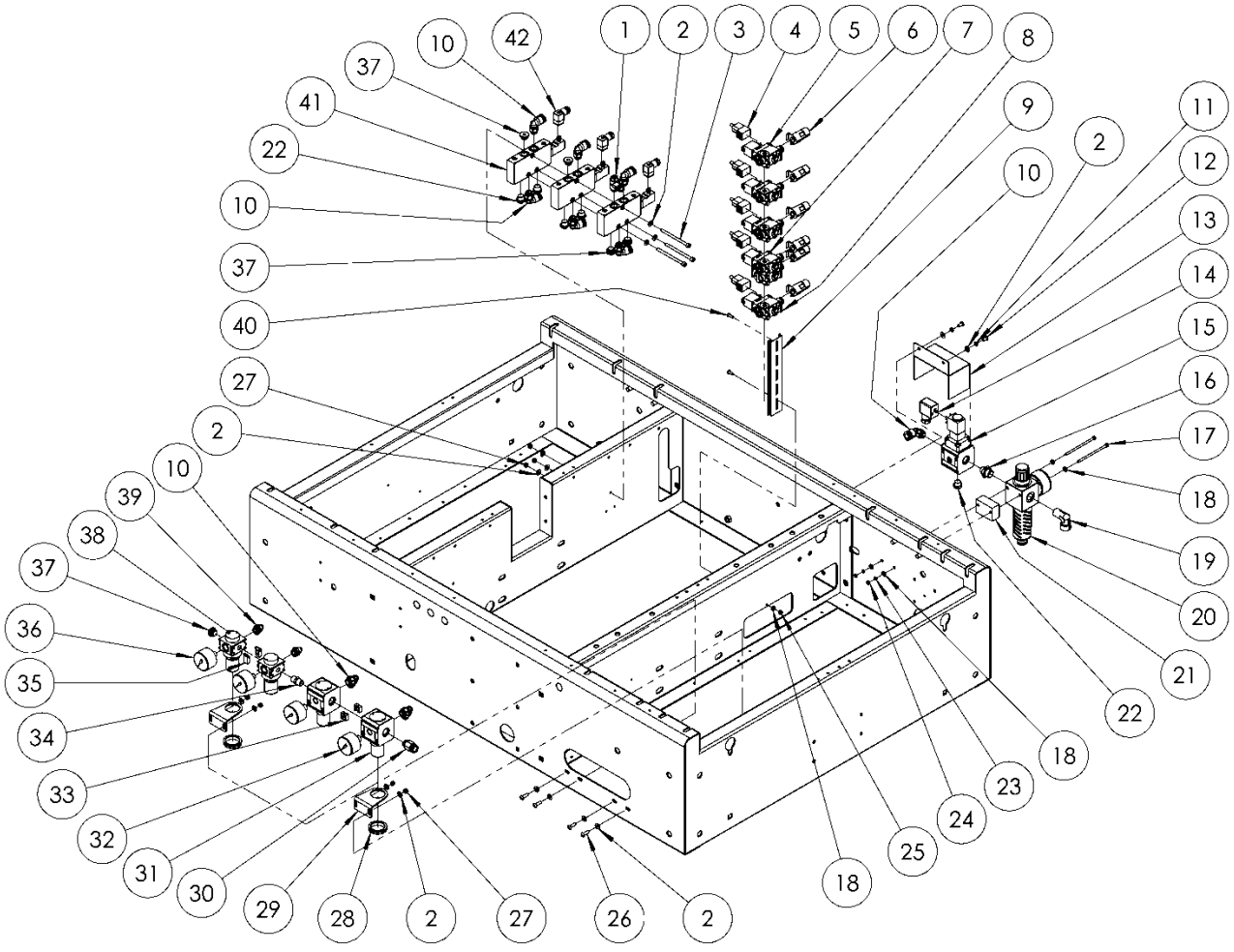
9.9.2 UAM0469 - BASE WELDMENT



UAM0469 - BASE WELDMENT

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	UPM5946	BEAM	1
2	UAM0482	LOWER HOST BASE ASSEMBLY	1
3	UPM5941	SIDE PANEL	1
4	UPM5944	FRONT BEAM	1

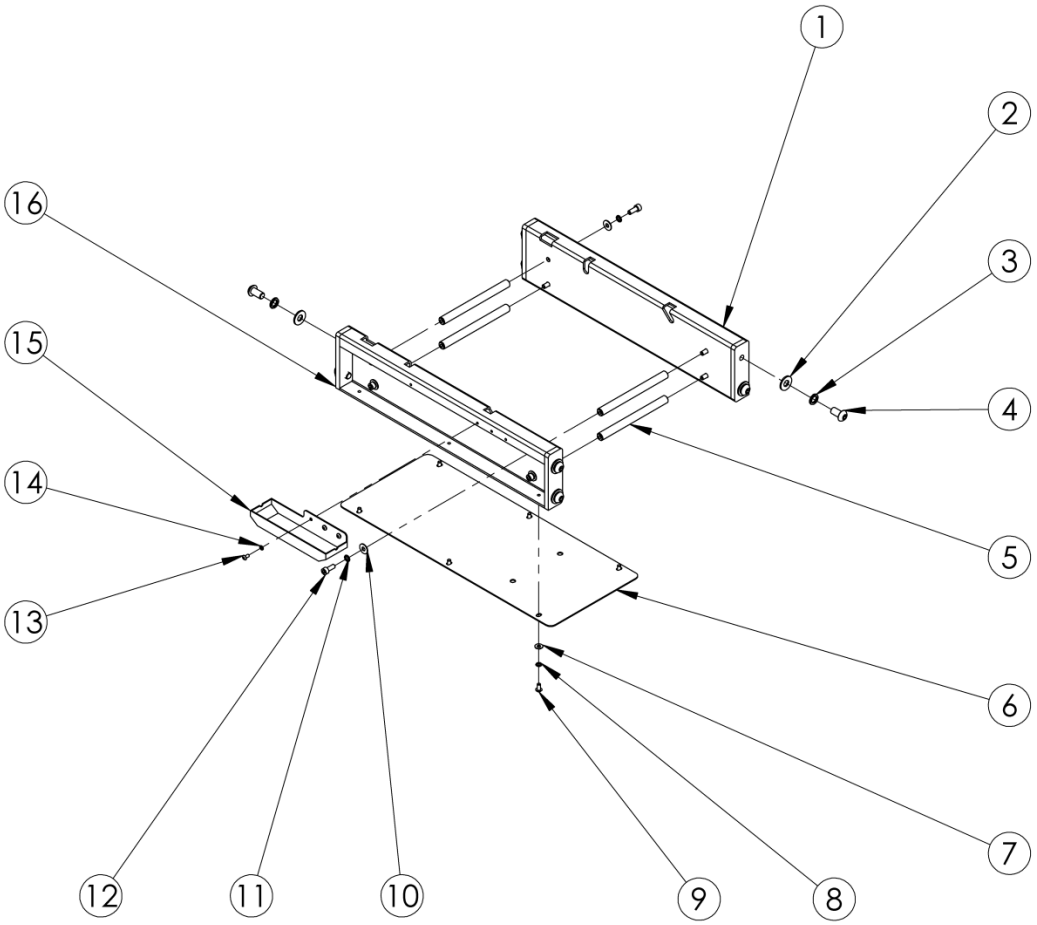
9.9.3 UAM0484 – PNEUMATIC ASSEMBLY



UAM0484 – PNEUMATIC ASEMBLY

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	UPM5973	FLOW CONTROL, 1/8	1
2	UF1827	FW M5	16
3	UF0044	SHCS M5-0.8X75	3
4	UPM5981	WIRE CONNECTOR	5
5	UPM5544	SOLENOID VALVE	3
6	UPM6363	PNEUMATIC 1/8 90 DEG QUICK CONNECT	6
7	UPM5980	SOLENOID VALVE	1
8	UPM5680	SOLENOID VALVE	1
9	UPM6172	RAIL	1
10	UPM5984	90~ QUICK CONNECTOR	9
11	UF7023	LW M5	2
12	UF3686	BHCS M5-0.8X10	2
13	UPM5975	COIL CONNECTOR COVER	1
14	UPM5979	ELECTRIC COIL CONNECTOR	1
15	UPM5978	ON-OFF VALVE	1
16	UPM5983	CONNECTOR, STRAIGHT	1
17	UF5930	SHCS M4-0.7X80	2
18	UF3710	FW M4	6
19	UPM5982	90~ ELBOW	1
20	UPM5977	REGULATOR	1
21	UPM5976	SPACER	1
22	UPM6171	SILENCER	5
23	UF5931	M4 LW	2
24	UF4237	M4-0.7 HNR	2
25	UF6376	M4 LOCK-NUT	2
26	UF5602	BHCS M5-0.8X16	4
27	UF3393	M5 LOCK-NUT	7
28	UPM6365	PNEUMATIC REGULATOR NUT	2
29	UPM6366	PNEUMATIC REGULATOR BRACKET	2
30	UPM6371	PNEUMATIC 1/8 STRAIGHT QUICK CONNECT	1
31	UPM6367	PNEUMATIC REGULATOR	2
32	UPM6368	PNUEMATIC GAGE	2
33	UPM6369	SPACER BLOCK	1
34	UPM6370	1/8 DOUBLE NIPPLE	1
35	UPM6372	SPACER	1
36	UPM6359	PRESSURE GAGE	2
37	UPM5974	PLUG, G1/8	5
38	UPM6373	PRESSURE REGULATOR SMALL	2
39	UPM6374	PNEUMATIC 90 DEG QUICK CONNECT	2
40	UF3649	BHCS M4-0.7X12	2
41	UPM6375	PNEUMATIC MANIFOLD BLOCK	3
42	UPM6376	PNEUMATIC FEMALE THREAD 90 DEG QUICK CONNECT	3

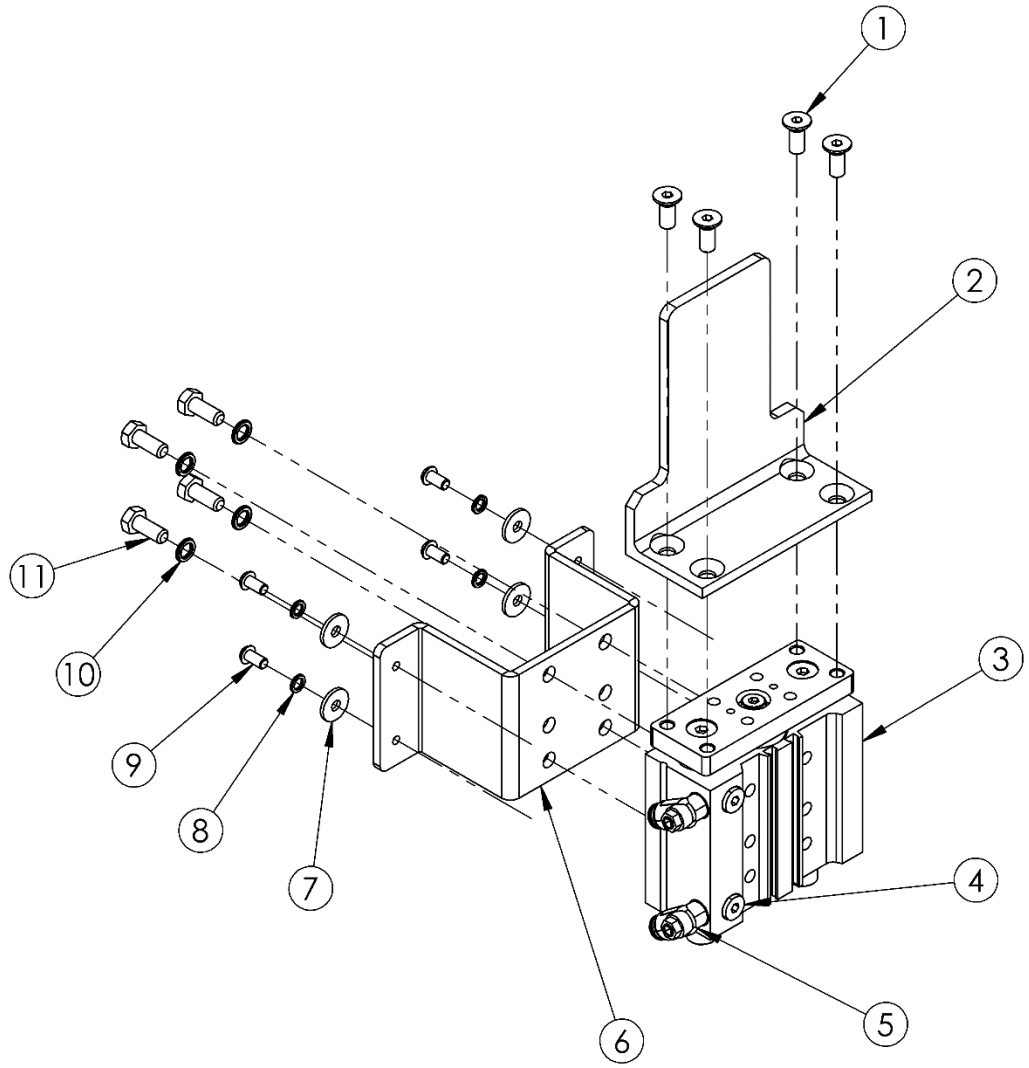
9.9.4 UAM0482 – LOWER HOST BASE ASSEMBLY



UAM0482 – LOWER HOST BASE ASSEMBLY

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	UPM6148	LOWER HOST BASE, R.H.	1
2	UF3680	M10 FW	8
3	UF6371	M10 LW	8
4	UF4252	M10-1.5-BHCS	8
5	UPM6252	SHAFT, 140L	4
6	UPM5970	LOWER HOIST COVER	1
7	UF1827	M5 FW	6
8	UF7023	M5 LW	6
9	UF3686	BHCS M5-0.8X10	6
10	UF1828	M6 FW	8
11	UF6363	M6 LW	8
12	UF0830	SHCS M6-1X16	8
13	UF7009	SS BHCS M4-0.7X8	3
14	UF3749	M4 SS LW	3
15	UPM6253	LOWER DRAIN TRAY	1
16	UPM6147	LOWER HOST BASE, L.H.	1

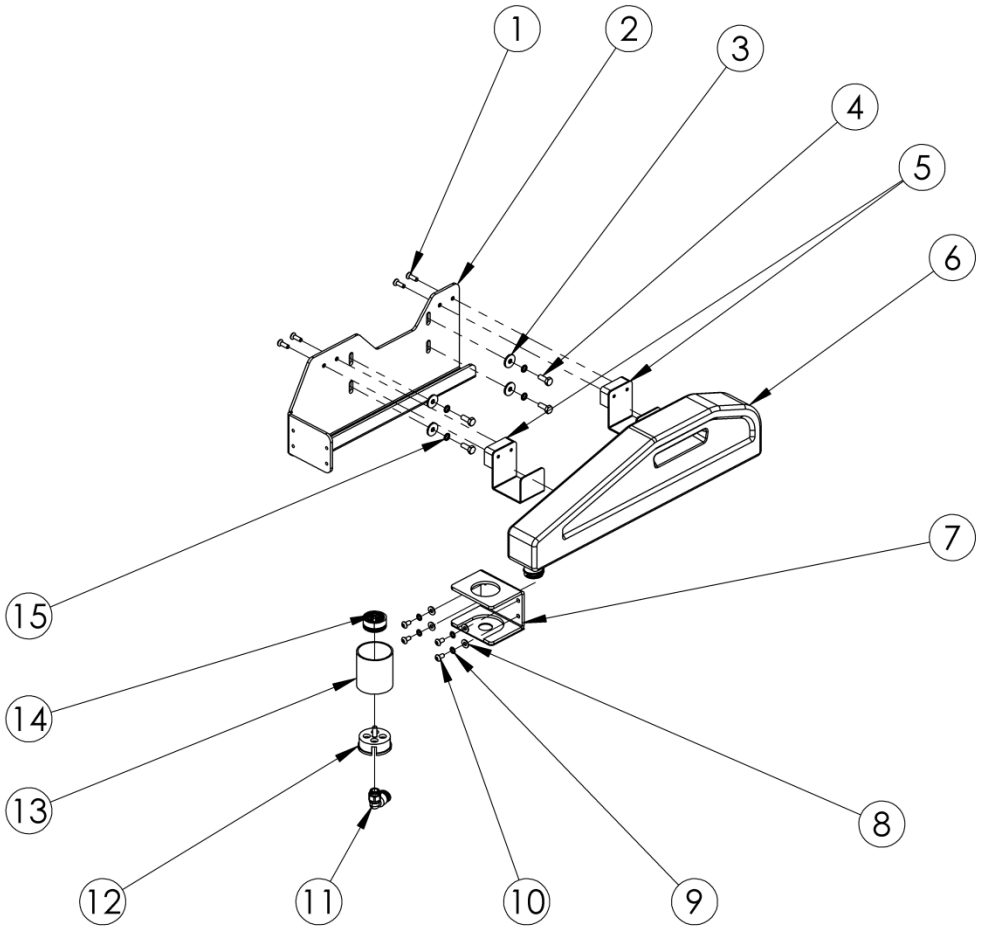
9.9.5 UAM0483 – INLET STOP ASSEMBLY



UAM0483 – INLET STOP ASSEMBLY

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	UF3264	FHCS M8-1.25×20L	4
2	UPM7513	STOP	1
3	UPM5972	CYLINDER W/ GUIDE ROD	1
4	UPM5974	PLUG, G1/8	2
5	UPM5973	FLOW CONTROL, 1/8	2
6	UPM5971	STOP BRACKET	1
7	UF0103	M6 FW, 19MM OD 2MM THK	4
8	UF6363	LW M6	4
9	UF5600	BHCS M6-1.0×12L	4
10	UF3640	LW M8	4
11	UF6309	HHCS M8-1.25×20L	4

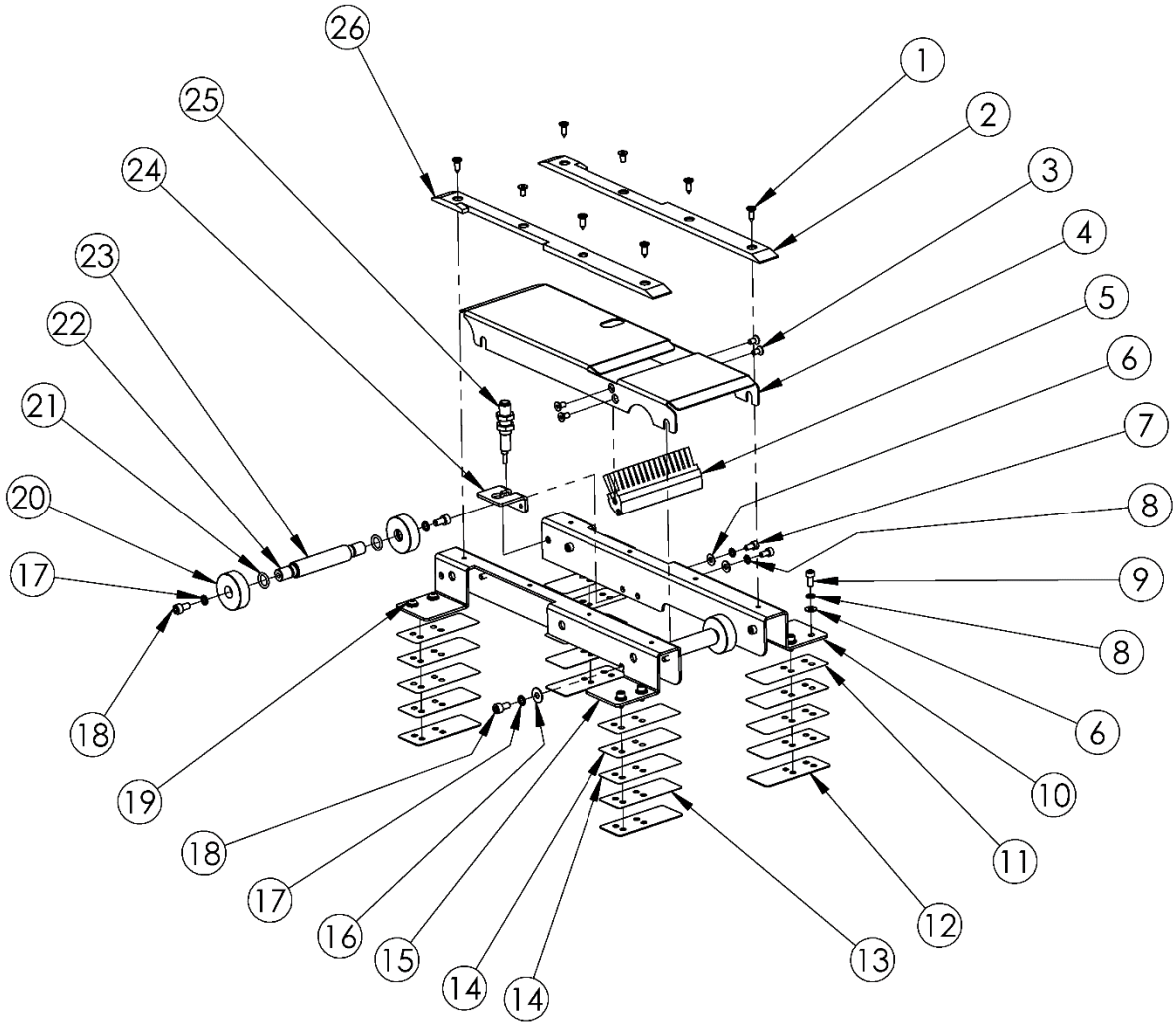
9.9.6 UAM0515 – WATER BOTTLE ASSEMBLY



UAM0515 – WATER BOTTLE ASSEMBLY

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	UF5404	FHCS M5-0.8X16	4
2	UPM5116	FRAME	1
3	UF1828	M6 FW	4
4	UF0454	HHCS M6-1.0X16	4
5	UPM5120	WT BOTTLE HOLDER	2
6	UPM5689	WATER RESERVOIR	1
7	UPM4945	CUP HOLDER	1
8	UF6340	M5 FW SS	4
9	UF7021	M5 SS LW	4
10	UF3283	BHCS M5-0.8X10 SS	4
11	UPM5148	ELBOW FITTING	1
12	UPM5901	PLUNGER - BP CAP 2	1
13	UPM4946	RESERVIOR CUP	1
14	WST1050	WAT BOTTLE BP CAP	1
15	UF6363	M6 LW	4

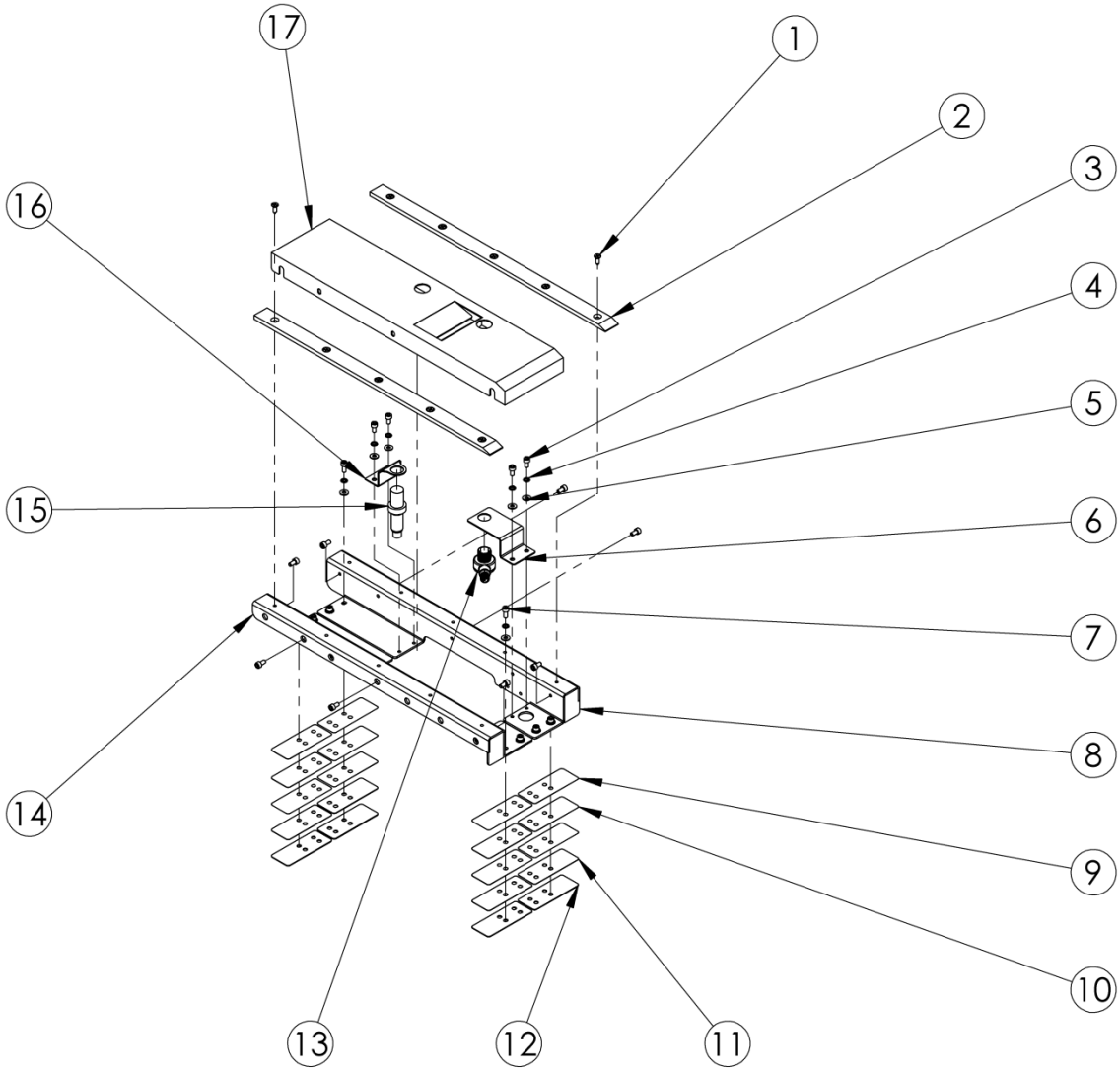
9.9.7 UAM0478 – OUTLET TABLE ASSEMBLY



UAM0478 – OUTLET TABLE ASSEMBLY

ITEM	PART#	DESCRIPTION	QTY.
1	UF0075	M5-0.8-SELF TAPPING	6
2	UPM5962	SLIP PAD, R.H.	1
3	UF6305	FHCS M5-0.8×10L	6
4	UPM5964	COVER	1
5	UPM5965	BRUSH	1
6	UF1827	M5 FW	10
7	UF0039	SHCS M5-0.8 x 10mm	6
8	UF7021	LW M5	10
9	UF7003	SHCS M5-0.8 x 12mm	4
10	UPM5960	REAR SUPPORT SEAT, R.H.	1
11	UPM6254	SHIM 0.1mm	4
12	UPM5953	SHIM 1.0mm	4
13	UPM6265	SHIM 0.5mm	4
14	UPM6255	SHIM 0.2mm	8
15	UPM5959	REAR SUPPORT SEAT, L.H.	1
16	UF1828	M6 FW	2
17	UF6363	LW M6	4
18	UF0038	SHCS M6-1.0×12L	4
19	UF3687	BHCS M5-0.8×12L	4
20	UPM5967	GUIDE ROLLER, 40OD	4
21	UF5923	O RING	4
22	UPM5968	SHAFT, 115L, GROOVED	2
23	UPM5966	ROLLER, dia 17, 72L, WHITE	2
24	UPM5963	SENSOR BRACKET	1
25	UPM5969	PHOTOELECTRIC SENSOR	1
26	UPM5961	SLIP PAD, L.H.	1

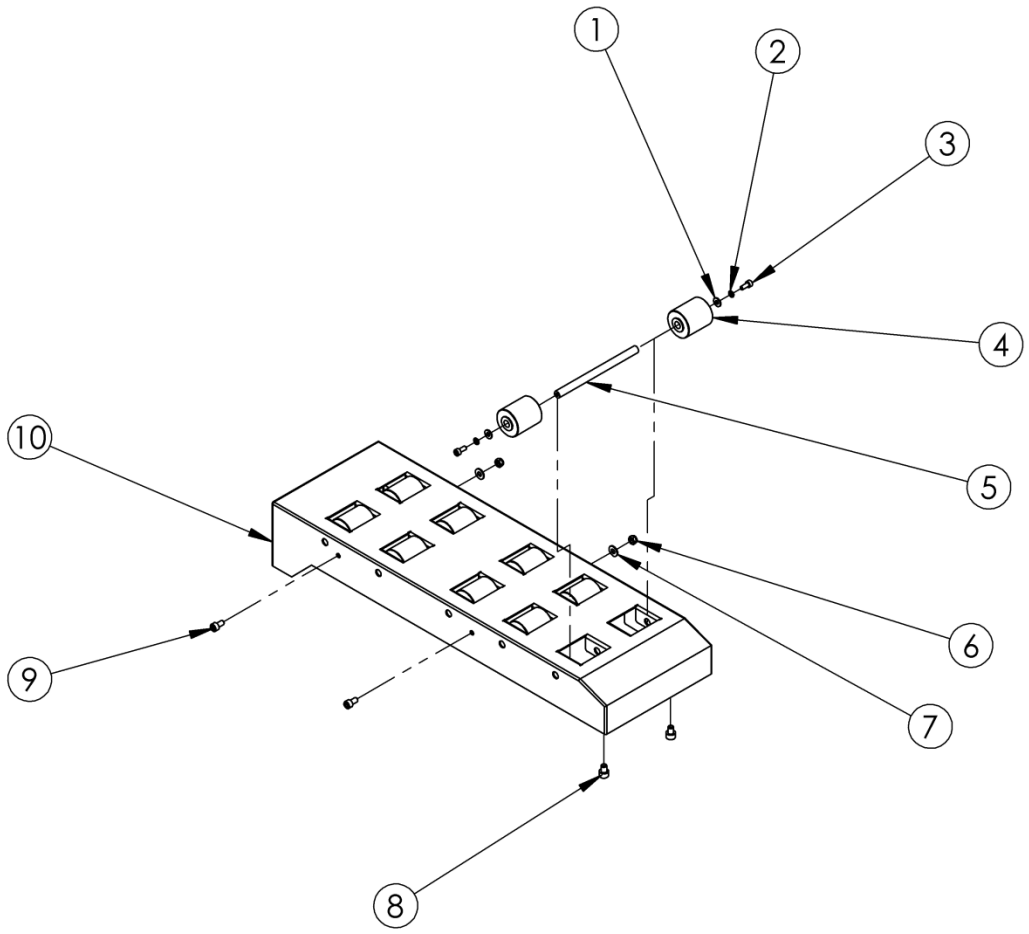
9.9.8 UAM0473 – INLET TABLE ASSEMBLY



UAM0473 – INLET TABLE ASSEMBLY

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	UF0075	M5-0.8-SELF TAPPING	10
2	UPM4954	SLIDING PAD	2
3	UF0039	SHCS M5-0.8X10	12
4	UF7021	LW M5	12
5	UF1827	FW M5	12
6	UPM5956	SENSOR SUPPORT	1
7	UF7003	SHCS M5-0.8X12	8
8	UPM5952	FRONT SEAT, R.H.	1
9	UPM5953	SHIM 0.1mm	4
10	Z5309-00AA10	SHIM 0.2mm	8
11	Z5309-00AA10	SHIM 0.5mm	4
12	Z5309-00AA10	SHIM1.0mm	4
13	UPM6384	SENSOR	1
14	UPM5951	FRONT SEAT, L.H.	1
15	UPM0317	PHOTO ELECTRIC SENSOR	1
16	UPM5956	SENSOR SUPPORT	1
17	UPM5954	COVER PLATE	1

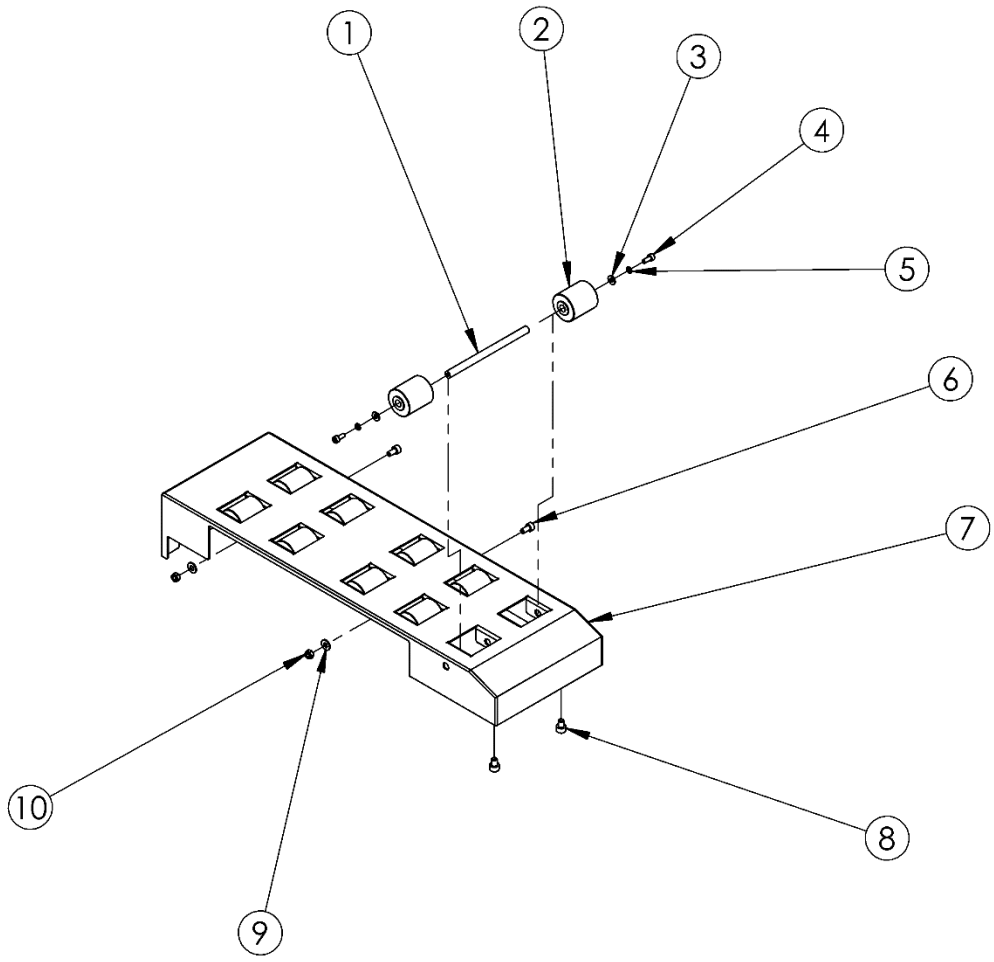
9.9.9 UAM0474 – ROLLER ASSEMBLY, LEFT HAND



UAM0474 – ROLLER ASSEMBLY, LEFT HAND

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	UF3710	M4 FW	10
2	UF3749	LW M4	10
3	UF9148	SHCS M4-0.7×10L	10
4	UPM4941	ROLLER	10
5	UPM4942	ROLLER SHAFT	5
6	UF3393	LOCK-NUT	2
7	UF1827	M5 FW	2
8	UF3170	SHCS M6-1.0×8L	2
9	UF0039	SHCS M5-0.8 x 10mm	2
10	UPM5957	ROLLER PLATE	1

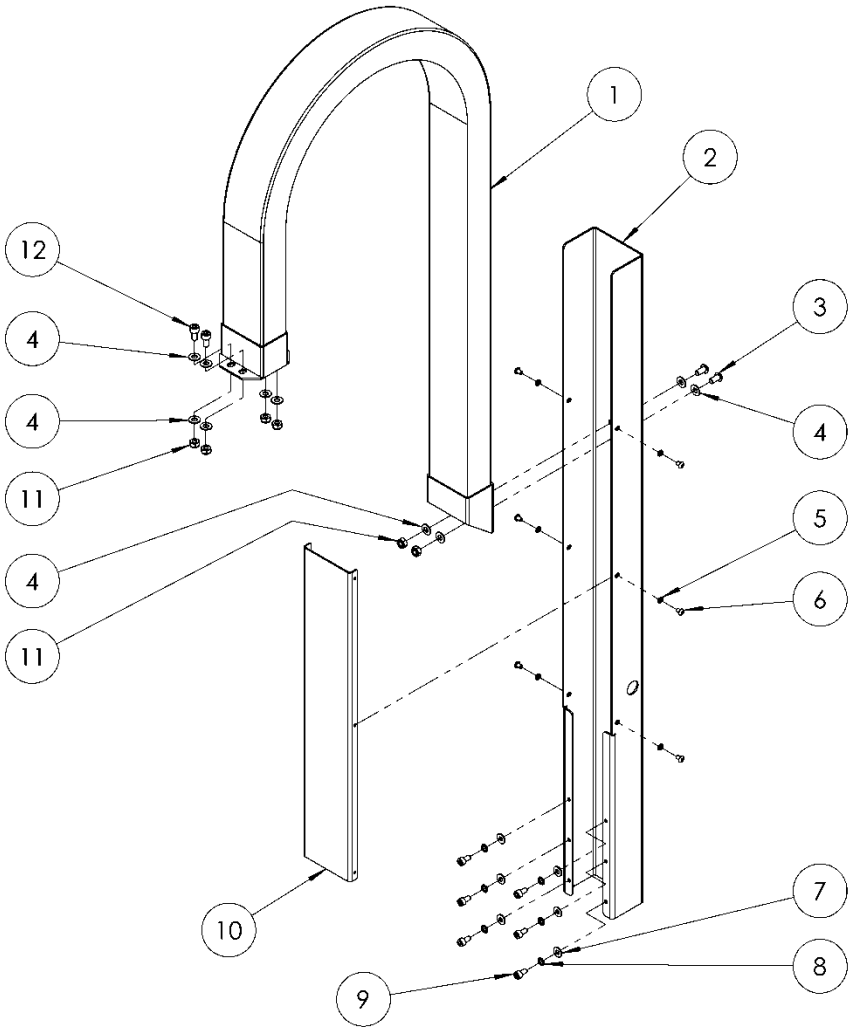
9.9.10 UAM0477 – ROLLER ASSEMBLY, RIGHT HAND



UAM0477 – ROLLER ASSEMBLY, RIGHT HAND

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	UPM4942	ROLLER SHAFT	5
2	UPM4941	ROLLER	10
3	UF3710	M4 FW	10
4	UF9148	SHCS M4-0.7×10L	10
5	UF3749	LW M4	10
6	UF0039	SHCS M5-0.8 x 10mm	2
7	UPM5958	ROLLER PLATE	1
8	UF3170	SHCS M6-1.0×8L	2
9	UF1827	M5 FW	2
10	UF3393	LOCK-NUT, M5	2

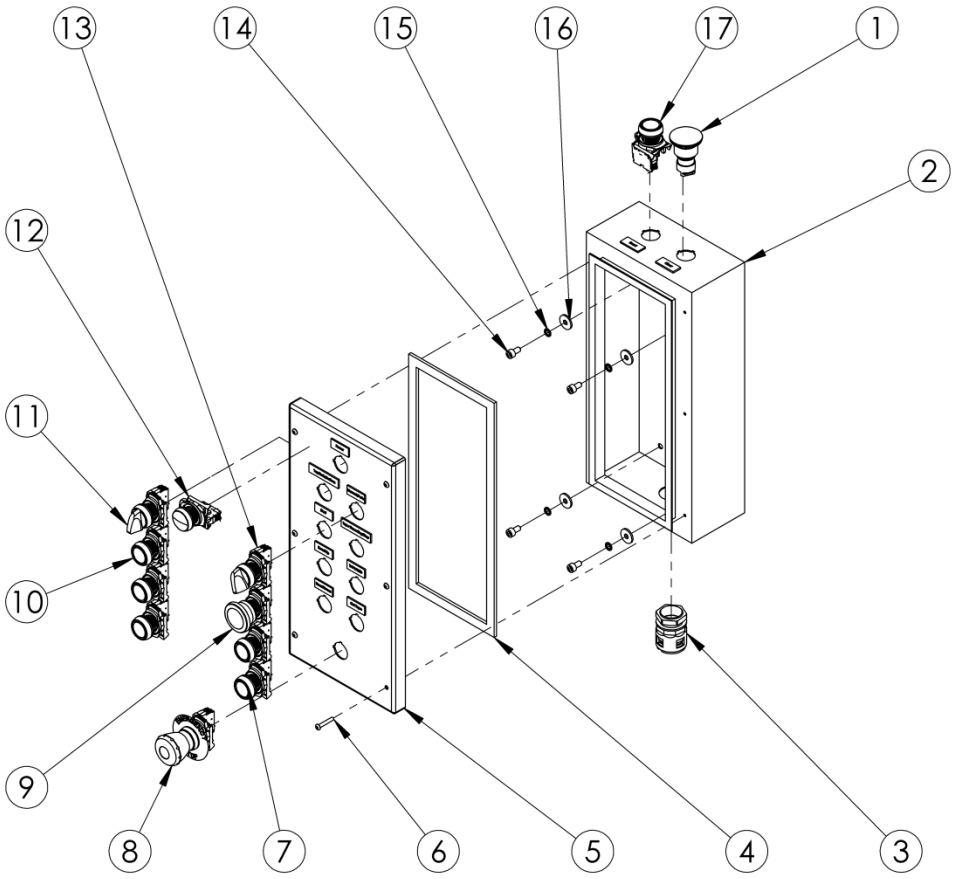
9.9.11 UAM0533 – CORD SLEEVE



UAM0533 – CORD SLEEVE

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	UPM6360	FLEXIBLE CORD SLEEVE	1
2	UPM6361	RIGID CORD SLEEVE	1
3	UF1195	BHCS M6-1.0X12L	2
4	UF1828	FW M6	12
5	UF3681	M4 LW	6
6	UF5929	BHCS M4-0.7X6	6
7	UF1827	FW M5	6
8	UF7023	LW M5	6
9	UF5201	SHCS M5-0.8X10	6
10	UPM6362	RIDGID CORD SLEEVE COVER	1
11	UF5900	M6 LOCK-NUT	6
12	UF0820	SHCS M6-1.0X12L	4

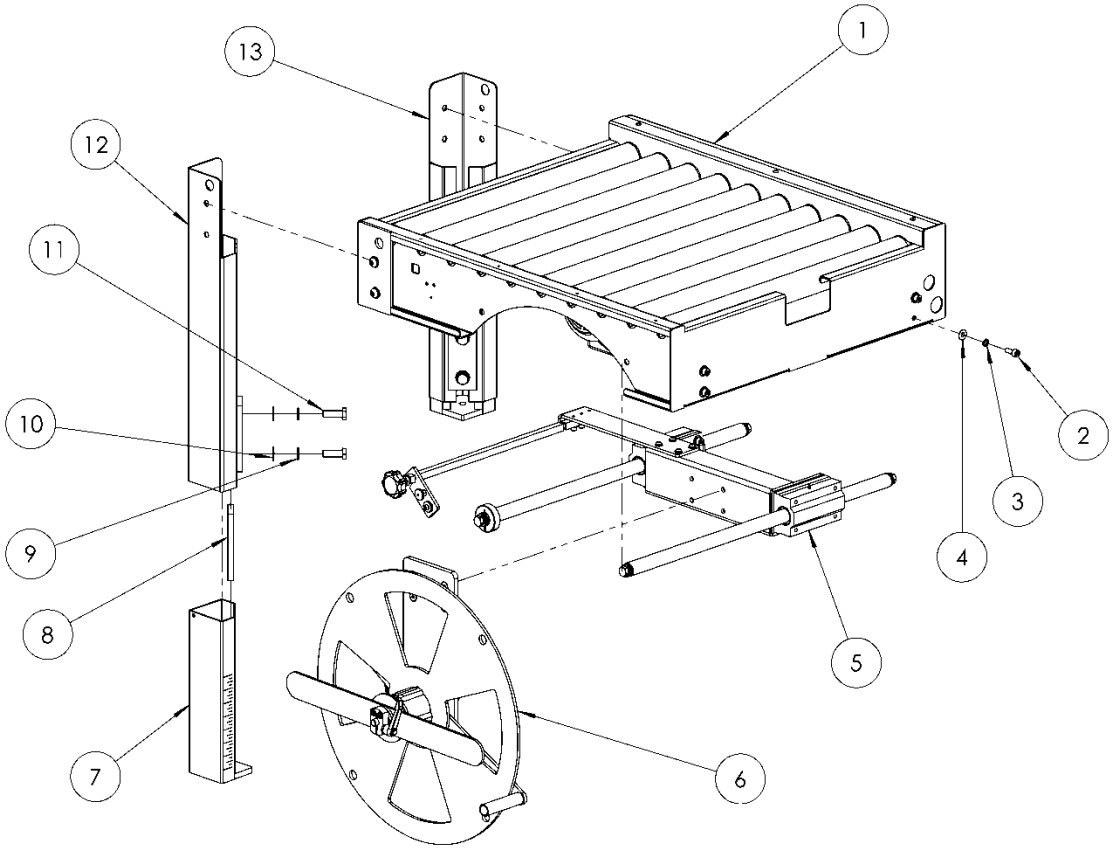
9.10 UAM0518 – CONTROL BOX



UAM0518 – CONTROL BOX

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	UPM4926	ILLUMINATED PB, MUSHROOM, BLUE	1
2	UPM6273	EU CONTROL BOX FRAME	1
3	UPM4905	CORD GRIP	1
4	UPM6275	EU CONTROL BOX SEAL	1
5	UPM6274	EU CONTROL BOX FACE PLATE	1
6	UF0069	BHCS M4-0.7x25	6
7	UPM5709	PUSH BUTTON	4
8	UPM5733	E-STOP	1
9	UPM6051	PUSH BUTTON, RED	1
10	UPM5734	START SWITCH	1
11	UPM6050	3 POS SELECTOR SWITCH	1
12	UPM6048	ILLUMINATED PILOT LIGHT	1
13	UPM6049	2 POS SELECTOR SWITCH	1
14	UF0038	SHCS M6-1.0X12L	4
15	UF6363	LW M6	4
16	UF1828	M6 FW	4
17	UPM6047	PUSH BUTTON, BLUE	1

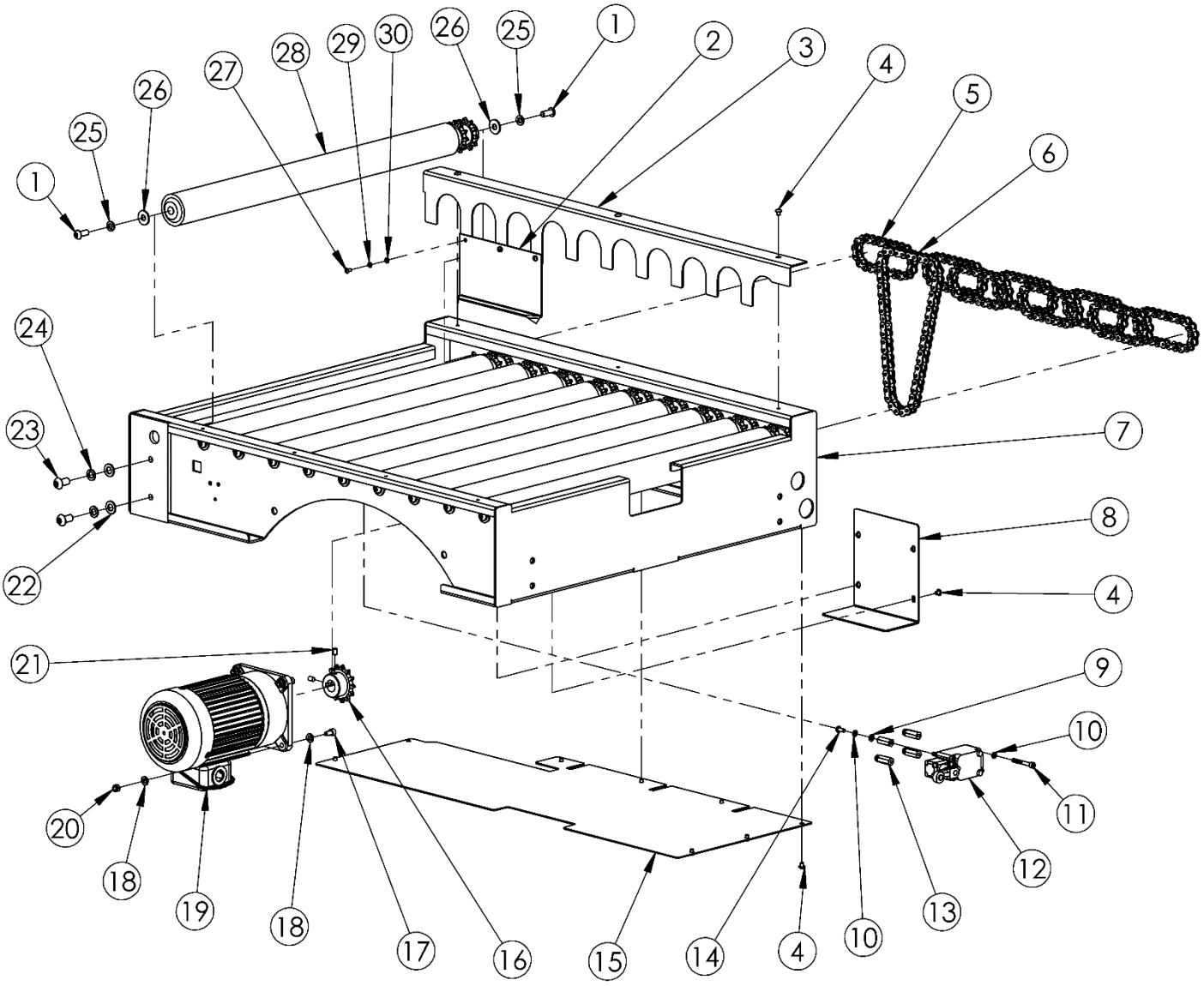
9.11 UAM0489 – OUTPUT TABLE



UAM0489 – OUTPUT TABLE

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	UAM0504	OUTPUT TABLE TOP	1
2	UF0864	SHCS M8-1.25×20L	4
3	UF0867	M8 LW	4
4	UF3643	M8 FW	4
5	UPM6039	TAPE ROLL CARRIAGE	1
6	UAM0506	BTM TAPE CARRAGE	1
7	UPM0847	LEG ADJUSTMENT WELDMENT	2
8	UPM0931	LEG FRICTION PLATE	2
9	UF4230	M12 LW	4
10	UF4231	M12 FW	4
11	UF6393	HHCS M12-1.75X35	4
12	UPM5142	LEG WELDMENT	1
13	UPM5141	LEG WELDMENT	1

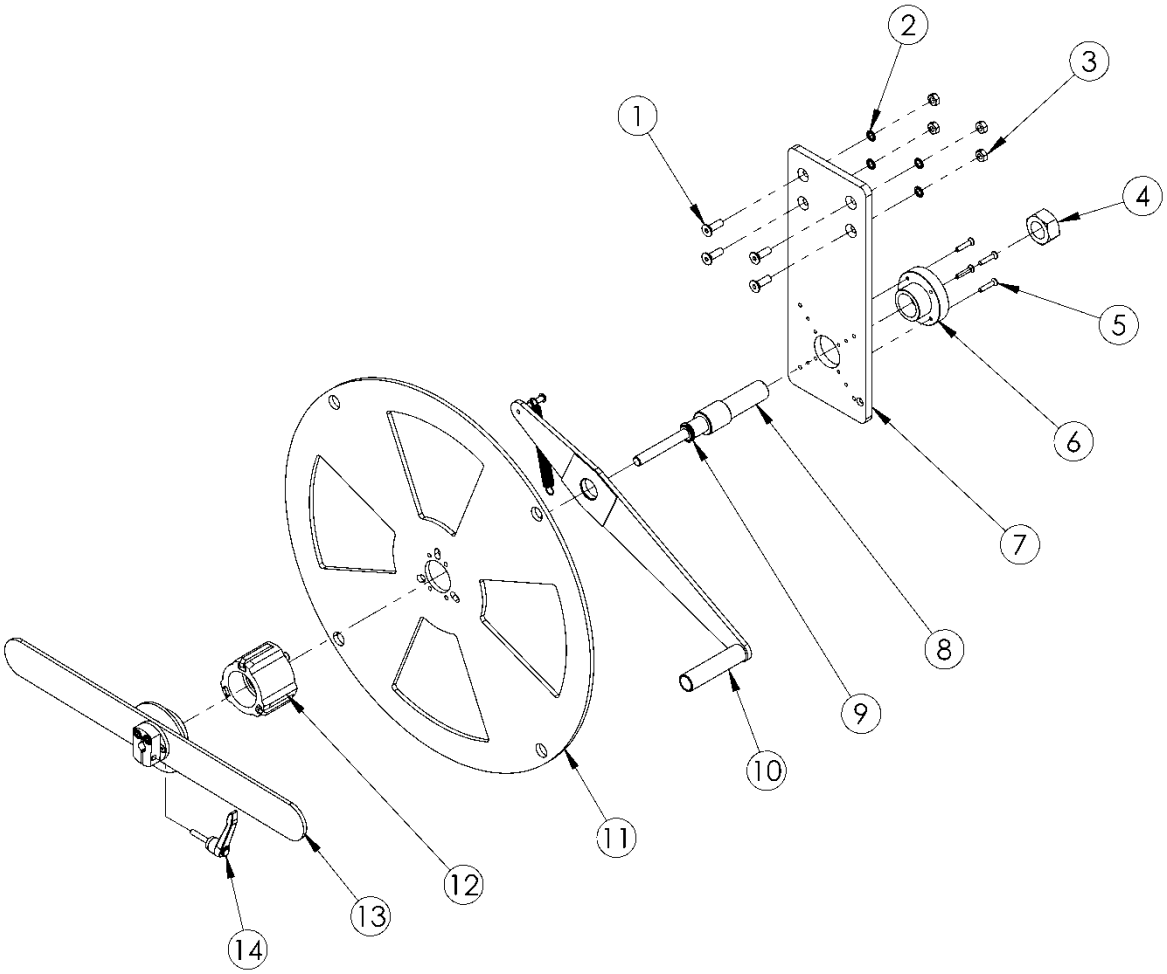
9.11.1 UAM0504 – OUTPUT TABLE TOP



UAM0504 – OUTPUT TABLE TOP

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	UF1318	BHCS M8-1.25×20L	20
2	UPM5222	CHAIN SHIELD	1
3	UPM4969	CHAIN COVER	1
4	UF5601	BHCS M5-0.8×6L	15
5	UPM4891	CHAIN #40, 12 PITCH	8
6	UPM4890	CHAIN #40, 25 PITCH	1
7	UAM0505	OUTPUT TABLE WELDMENT	1
8	UPM5124	CHAIN COVER	1
9	UF6340	SS FW M5	4
10	UF7023	LW 5MM	8
11	UF3776	SS SHCS M5 x 0.8 x 40mm	4
12	UPM5711	SWITCH SNAP ACTION SPDT 10A 125V	1
13	UPM6037	POST	4
14	UF3687	BHCS M5-0.8×12L	4
15	UPM6038	BOTTOM COVER	1
16	UPM5126	SPROCKET	1
17	UF0038	SHCS M6-1.0×12L	4
18	UF6341	SS FW M6	8
19	UPM5885	MOTOR	1
20	UF3391	SS NYLON LOCK NUT M6-1.0	4
21	UF3750	SS SSS M6 X 10mm	2
22	UF3680	FW M10	8
23	UF4252	BHCS M10-1.5×20L	8
24	UF6371	M10 LW	8
25	UF0867	LW M8	20
26	UF1821	FW M8	20
27	UF7009	SS BHCS M4-0.7 x 8	3
28	UPM5125	ROLLER	10
29	UF3681	LW M4	3
30	UF3710	FW M4	3

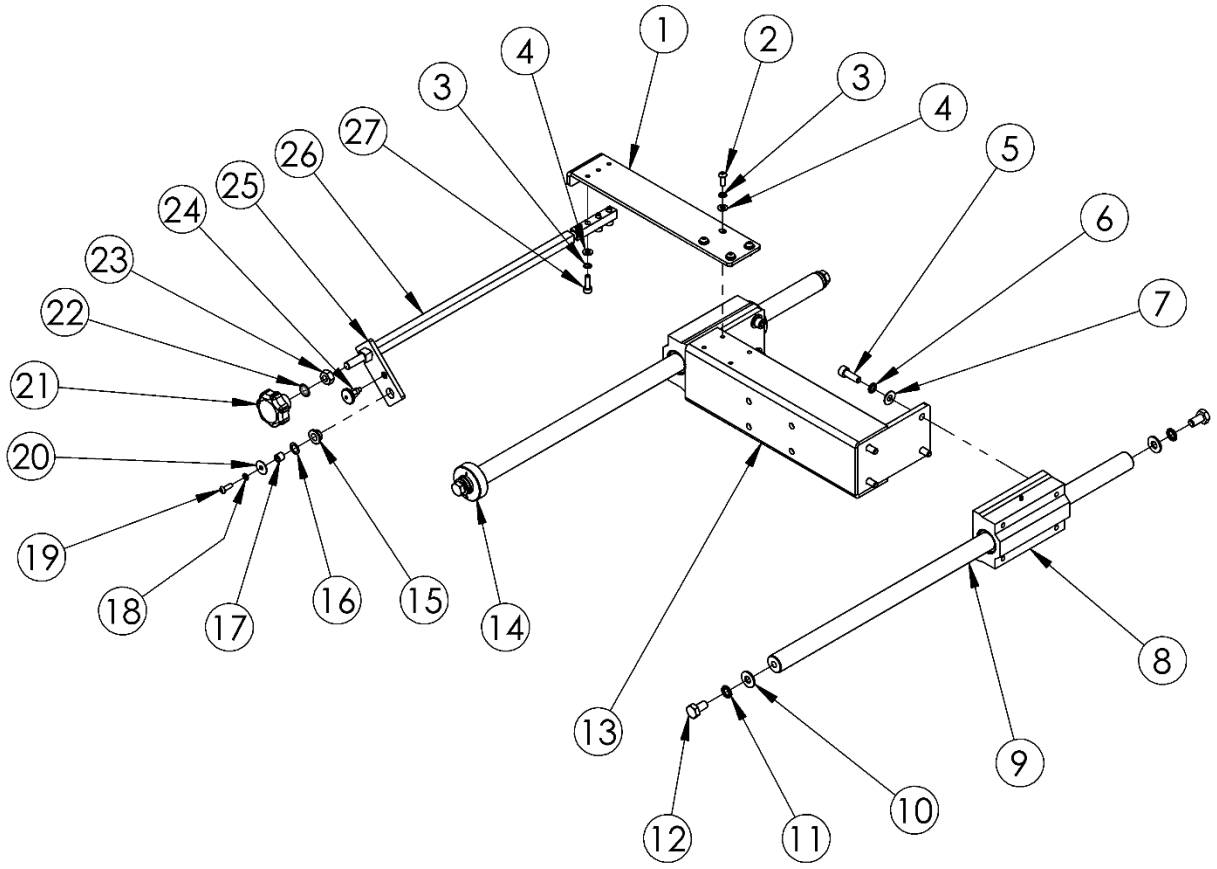
9.11.2 UAM0506 – BOTTOM TAPE CARRIAGE



UAM0506 – BOTTOM TAPE CARRIAGE

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	M8-1.25×25L	M8-1.25-FHCS	4
2	M8	M8 LW	4
3	M8-1.25	M8-1.25-HNR	4
4	M24-1.5	M24-1.5-HNR	1
5	M5-0.8×25L	M5-0.8-FHCS	4
6	UPM5114	HUB	1
7	UPM6143	BACK FRAME	1
8	UPM5109	STEPPED SHAFT L.H.	1
9	UF3815	RET'G RING, ID 10	1
10	UAM0479	DANCER ARM ASSEMBLY	1
11	UPM5111	PANCAKE	1
12	UAM0195	MANDREL HUB	1
13	UAM0462	CROSS BAR ASSEMBLY	1
14	UPM4889	HANDLE	1

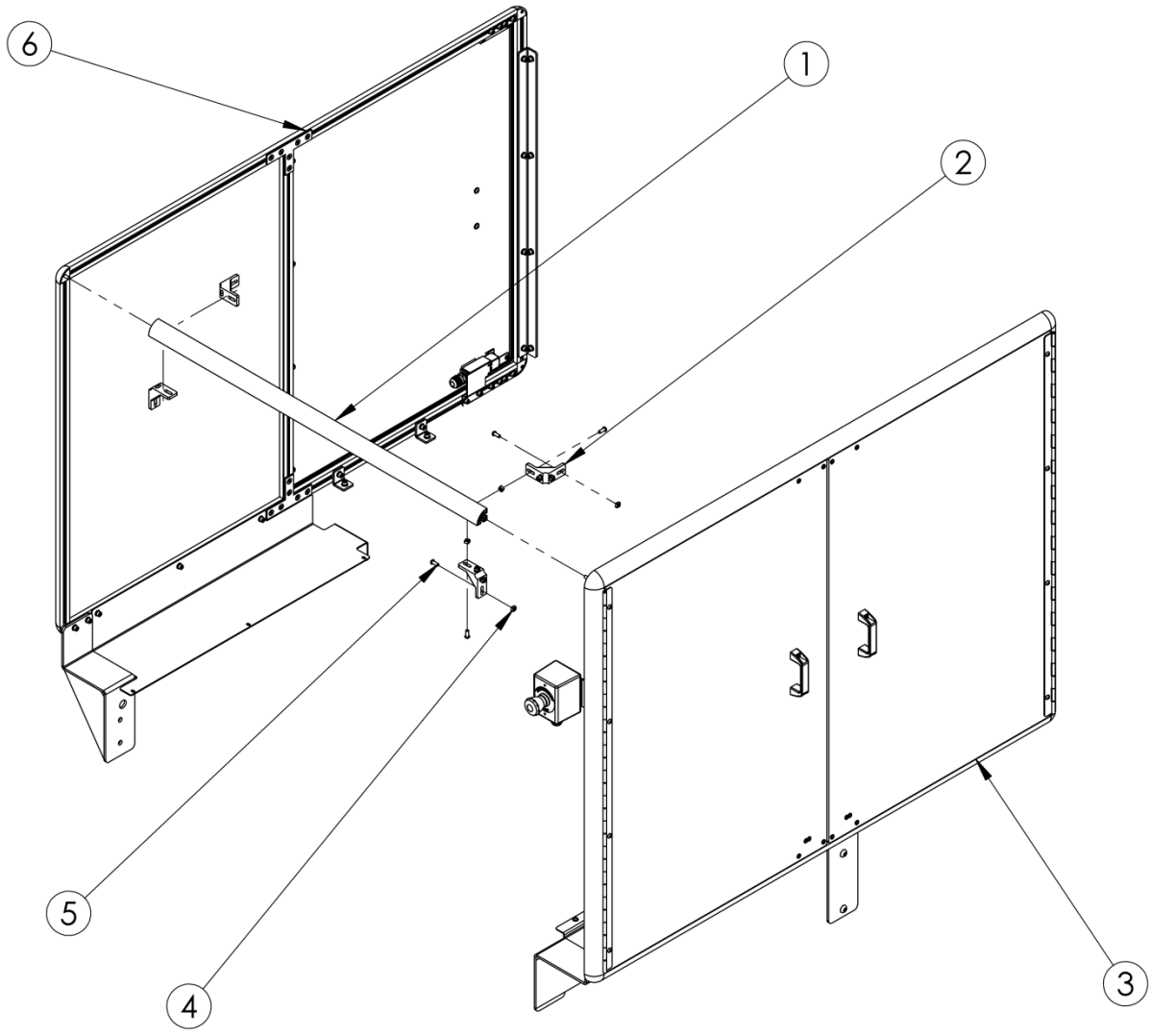
9.11.3 UPM6039 – TAPE ROLLER CARRIAGE



UPM6039 – TAPE ROLLER CARRIAGE

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	UPM6042	BRACKET	1
2	UF1250EV	BHCS M6-1.0×16L	4
3	UF6363	LW M6	7
4	UF1828	M6 FW	7
5	UF0098	SHCS M8-1.25×25L	8
6	UF3640	LW M8	8
7	UF0105	M8 FW	8
8	UPM6142	SHUTTLE BLOCK	2
9	UPM6043	SHAFT	2
10	UF3680	M10 FW	4
11	UF3743	LW M10	4
12	UF3679	HHCS M10-1.5×20L	4
13	UPM6040	BRACKET	1
14	UPM5713	SHAFT COLLAR	2
15	UPM2539	BUSHING	1
16	UF0108	FW, 16 OD, 10.5 ID, 0.5 THK	1
17	UPM2803	ROTARY SLEEVE	1
18	UF7021	LW M5	1
19	UF0037	BHCS M5-0.8×16L	1
20	UF0106	M5 FW	1
21	UPM2784	HANDLE	1
22	UF0057	INTERNAL TOOTH LW M10	1
23	UF0107	HEX JAM NUT, M10 x 1.5	1
24	UPM2792	DIVIDE POSITIONING PILLAR	1
25	UPM2471	DRAG LINK	1
26	UPM6041	BAR	1
27	UF0835	SHCS M6-1.0×20L	5

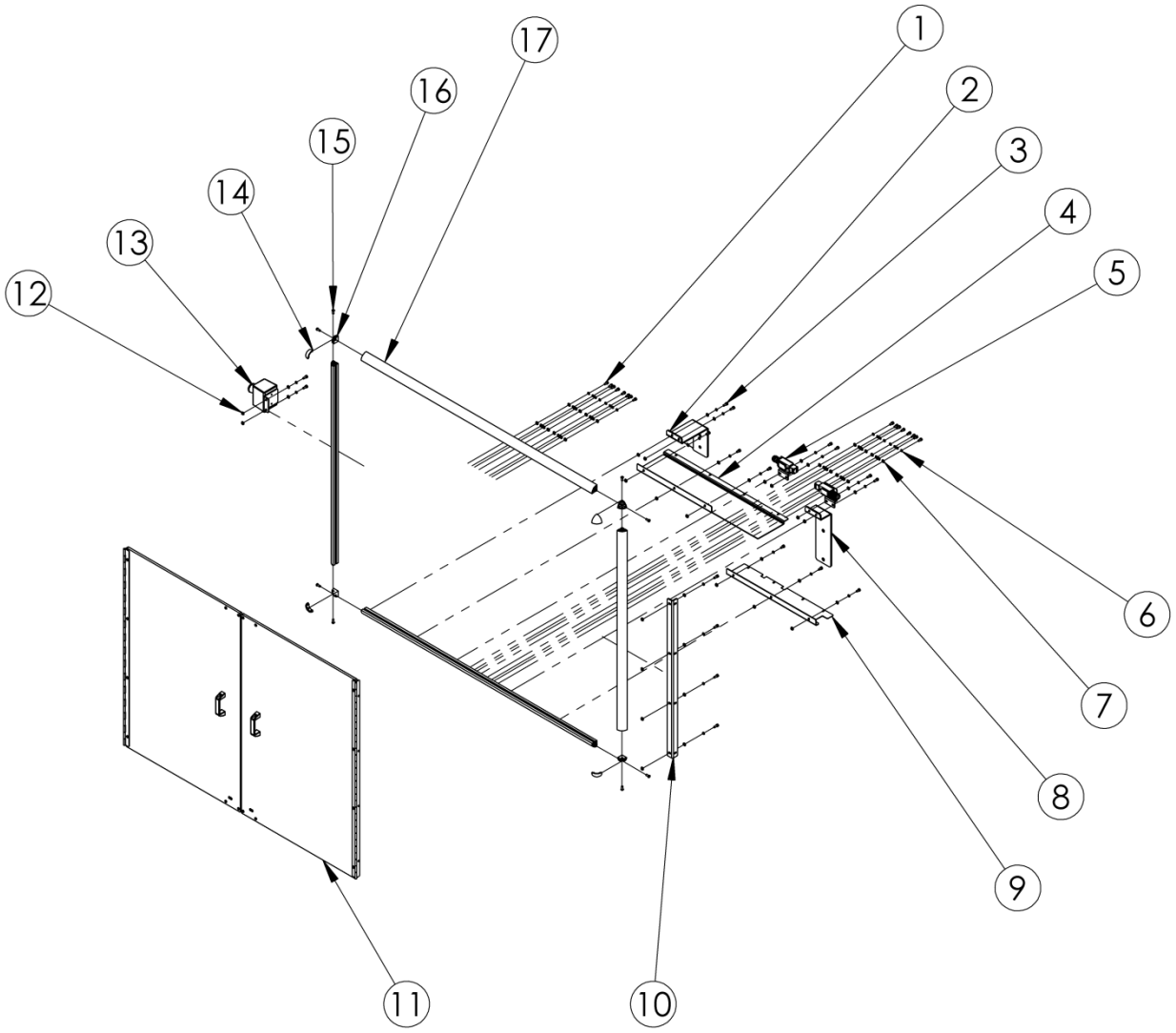
9.12 UAM0535 – REAR DOOR GUARDING ASSEMBLY



UAM0535 – REAR DOOR GUARDING ASSEMBLY

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	UPM6296	DOOR GUARDING FRAME 996L	1
2	UPM6277	DOOR GUARDING CORNER BRACKET	4
3	UAM0522	DOOR GUARDING DOUBLE DOOR ASSEMBLY	1
4	UF3399	M6 INSERT NUT	16
5	UF1250EV	BHCS M6-1.0X16L	16
6	UAM0523	DOOR GUARDING HALF DOOR ASSEMBLY	1

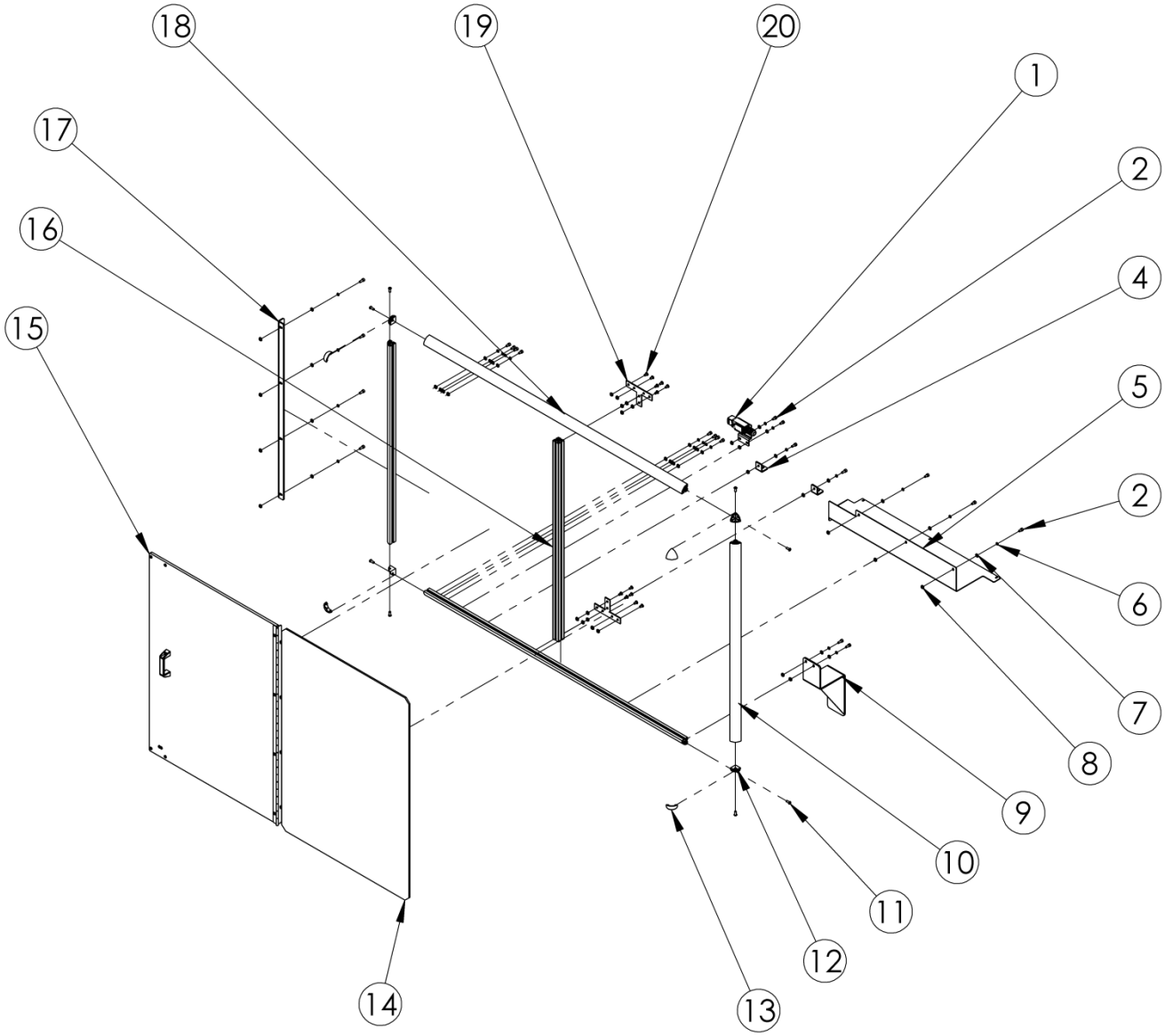
9.12.1 UAM0522 – DOOR GUARDING DOUBLE DOOR ASSEMBLY



UAM0522 – DOOR GUARDING DOUBLE DOOR ASSEMBLY

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	UF0038	SHCS M6-1.0X12L	28
2	UPM6287	DOOR GUARDING LOWER BRACKET	1
3	UF0830	SHCS M6-1.0X16	10
4	UPM6289	DOOR GUARDING LOWER MOUNT LG	1
5	UPM6286	DOOR GUARDING LATCH ACTUATOR	2
6	UF6363	LW M6	38
7	UF1828	FW M6	50
8	UPM6289	DOOR GUARDING LOWER MOUNT LG	1
9	UPM6289	DOOR GUARDING LOWER MOUNT LG	1
10	UPM6285	DOOR GUARDING VERTICAL MOUNT	1
11		DOOR GUARDING DOOR PANEL ASSEMBLY	2
12	UF3399	M6 INSERT NUT	42
13	UPM6170	BUTTON BOX	1
14	UPM6282	DOOR GUARDING CORNER CAP	4
15	UF1250EV	BHCS M6-1.0X16L	9
16	UPM6284	DOOR GUARDING CORNER	4
17	UPM6296	DOOR GUARDING FRAME 1356L	2

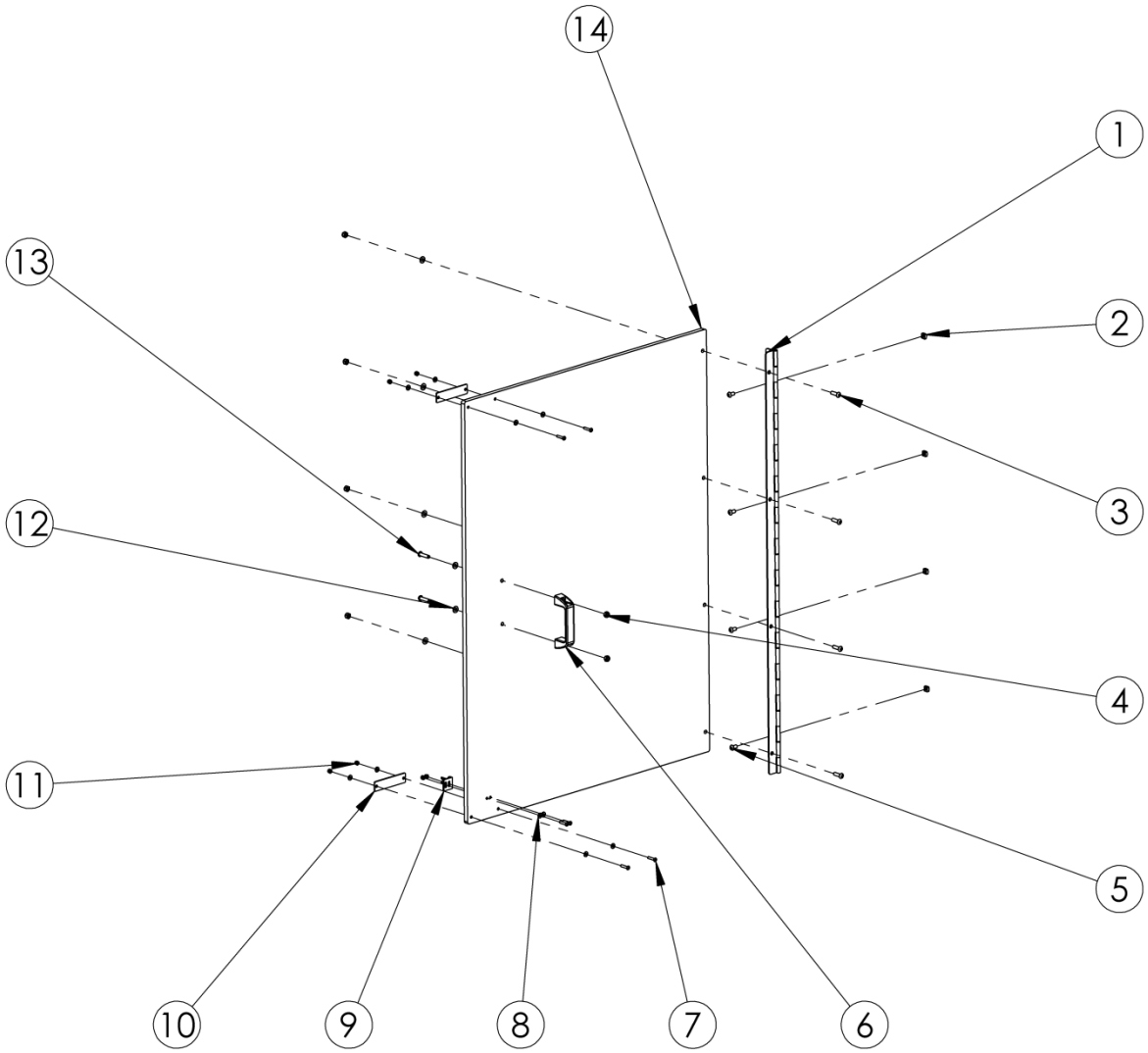
9.12.2 UAM0523 – DOOR GUARDING HALF DOOR ASSEMBLY



UAM0523 – DOOR GUARDING HALF DOOR ASSEMBLY

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	UPM6286	DOOR GUARDING LATCH ACTUATOR	1
2	UF0038	SHCS M6-1.0X12L	13
3	UF0830	SHCS M6-1.0X16	8
4	UPM6294	DOOR GUARDING LOWER BRACKET SM	2
5	UPM6289	DOOR GUARDING LOWER MOUNT	1
6	UF6363	LW M6	21
7	UF1828	FW M6	27
8	M6	INSERT NUT	37
9	UPM6287	DOOR GUARDING LOWER BRACKET	1
10	UPM6296	DOOR GUARDING FRAME 901L	2
11	UF1250EV	BHCS M6-1.0X16L	8
12	UPM6284	DOOR GUARDING CORNER	4
13	UPM6282	DOOR GUARDING CORNER CAP	4
14	UPM6292	DOOR GUARDING FIXED PANEL	1
15	UPM6278	DOOR GUARDING DOOR PANEL	1
16	UPM5456	CENTER BEAM CONNECTOR 901L	1
17	UPM6285	DOOR GUARDING VERTICAL MOUNT	1
18	UPM6296	DOOR GUARDING FRAME 1356L	2
19	UPM6347	DOOR GUARDING T BRACKET	2
20	UF1042	FHCS M6-1.0X 12	12

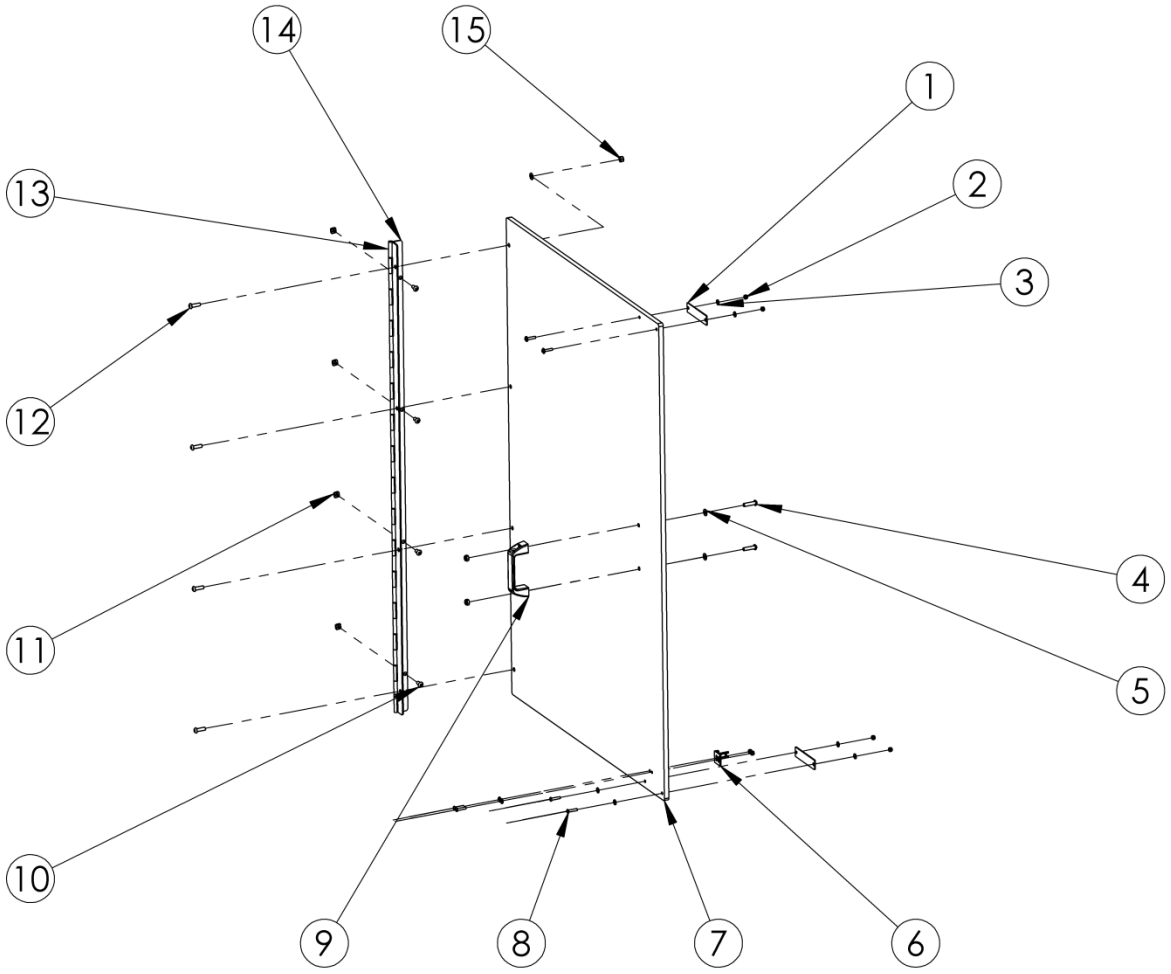
9.12.2.1 UAM0528 – DOOR GUARDING RIGHT HAND DOOR ASSEMBLY



UAM0528 – DOOR GUARDING RIGHT HAND DOOR ASSEMBLY

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	UPM6279	DOOR GUARDING HINGE	1
2	UF3399	M6 INSERT NUT	4
3	UF1241EV	BHCS M6-1.0X20L	4
4	UF5900	M6 LOCK-NUT	6
5	UF5600	BHCS M6-1.0X12L	4
6	UPM6281	DOOR GUARDING HANDLE	1
7	UF4050EV	BHCS M4-0.7X20	6
8	UF3710	FW M4	10
9	UPM6283	DOOR GUARDING LATCH	1
10	UPM6280	DOOR GUARDING STOPPER PANEL	2
11	UF6376	M4 LOCK-NUT	6
12	UF1828	FW M6	6
13	UF0076	BHCS M6-1.0X25L	2
14	UPM6278	DOOR GUARDING PANEL	1

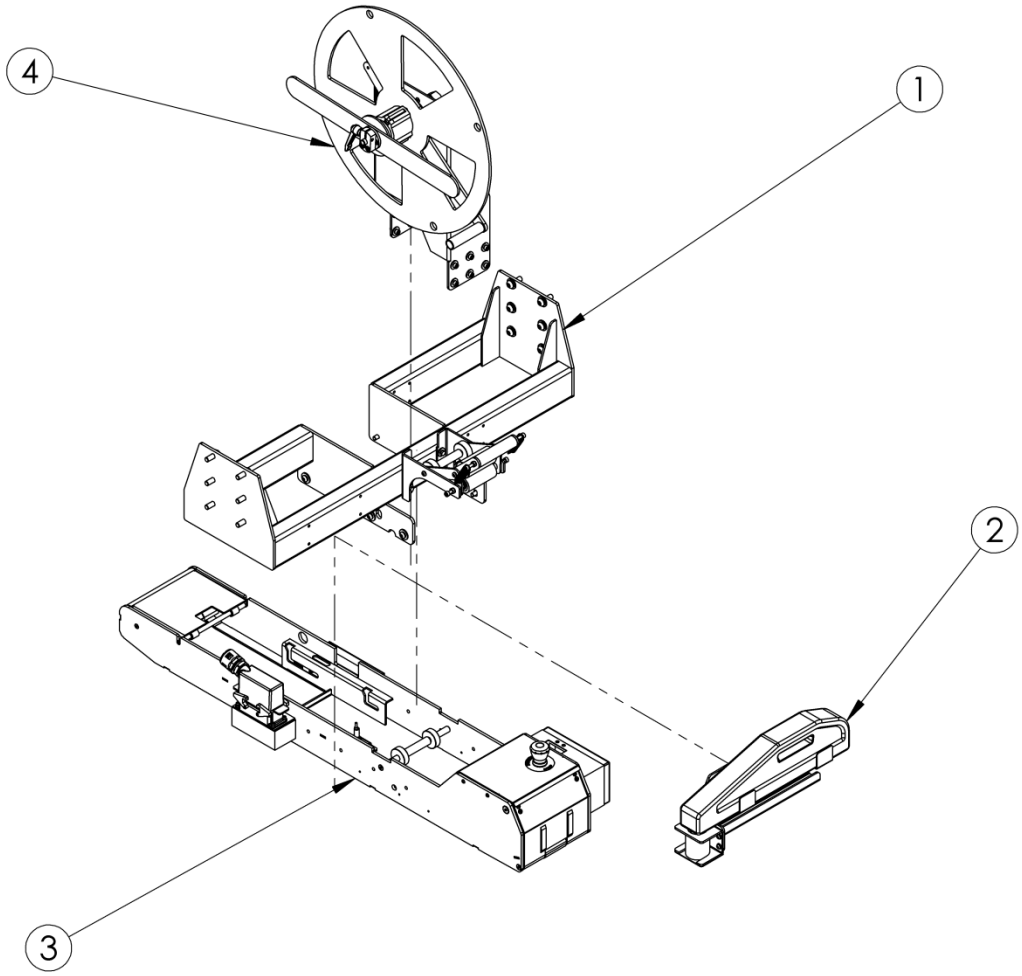
9.12.2.2 UAM0527 – DOOR GUARDING LEFT HAND DOOR



UAM0527 – DOOR GUARDING LEFT HAND DOOR

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	UPM6280	DOOR GUARDING STOPPER PANEL	2
2	UF6376	M4 LOCK-NUT	6
3	UF3710	FW M4	10
4	UF0076	BHCS M6-1.0X25L	2
5	UF1828	FW M6	6
6	UPM6283	DOOR GUARDING LATCH	1
7	UPM6278	DOOR GUARDING DOOR PANEL	1
8	UF4050EV	BHCS M4-0.7X20	6
9	UPM6281	DOOR GUARDING HANDLE	1
10	UF5600	BHCS M6-1.0X12L	4
11	UF3399	M6 INSERT NUT	4
12	UF1241EV	BHCS M6-1.0X20L	4
13	UPM6279	DOOR HINGE B	1
14	UPM6279	DOOR HINGE A	1
15	UF5900	M6 LOCK-NUT	6

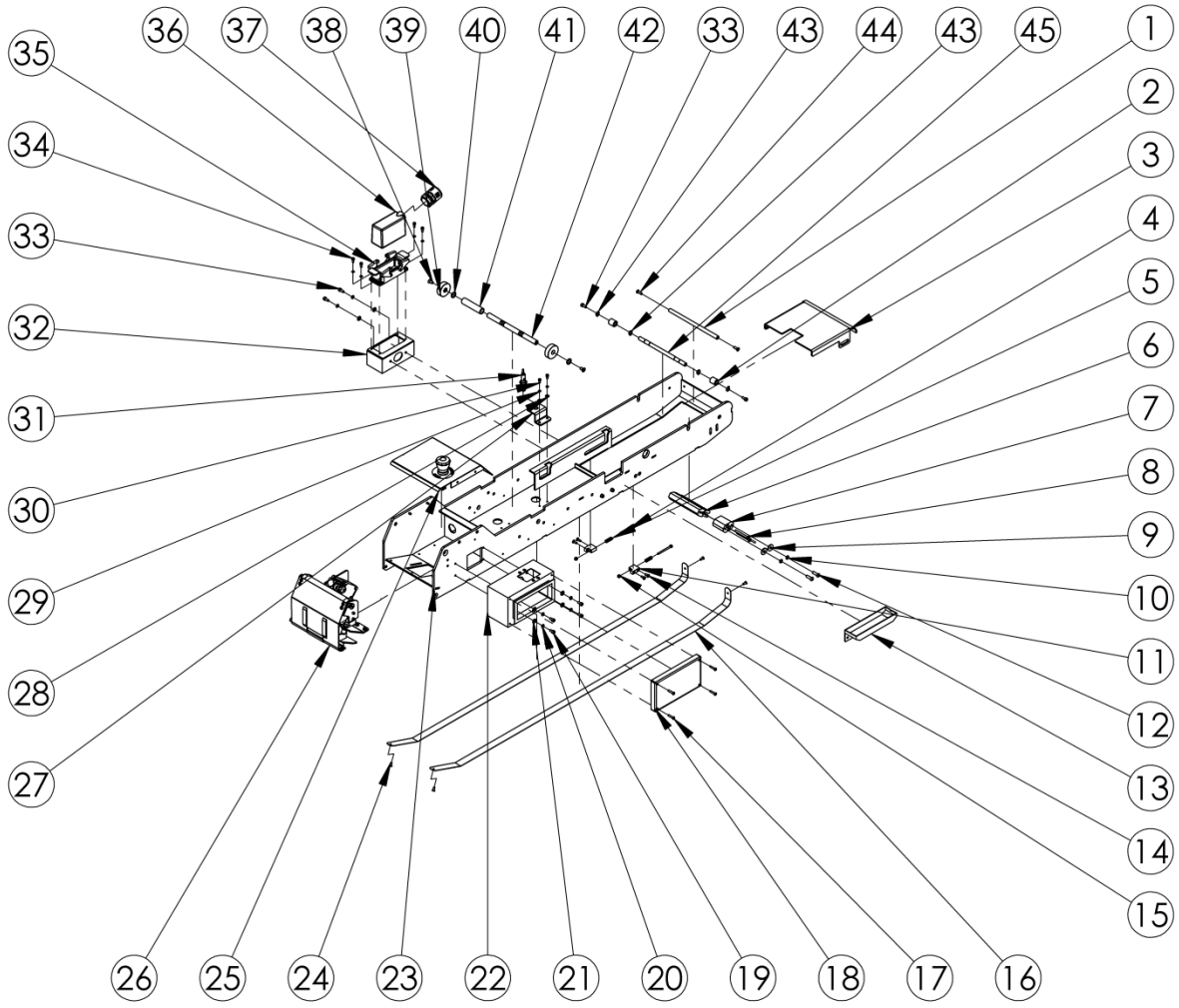
9.13 UAM0512 – BRIDGE ASSEMBLY



UAM0512 – BRIDGE ASSEMBLY

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	UAM0514	BRIDGE TAPE ROLL MOUNT ASSEMBLY	1
2	UAM0515	WATER BOTTLE ASSEMBLY	1
3	UAM0513	BRIDGE BASE ASSEMBLY	1
4	USM7583	TOP TAPE CARRIAGE ASSEMBLY	1

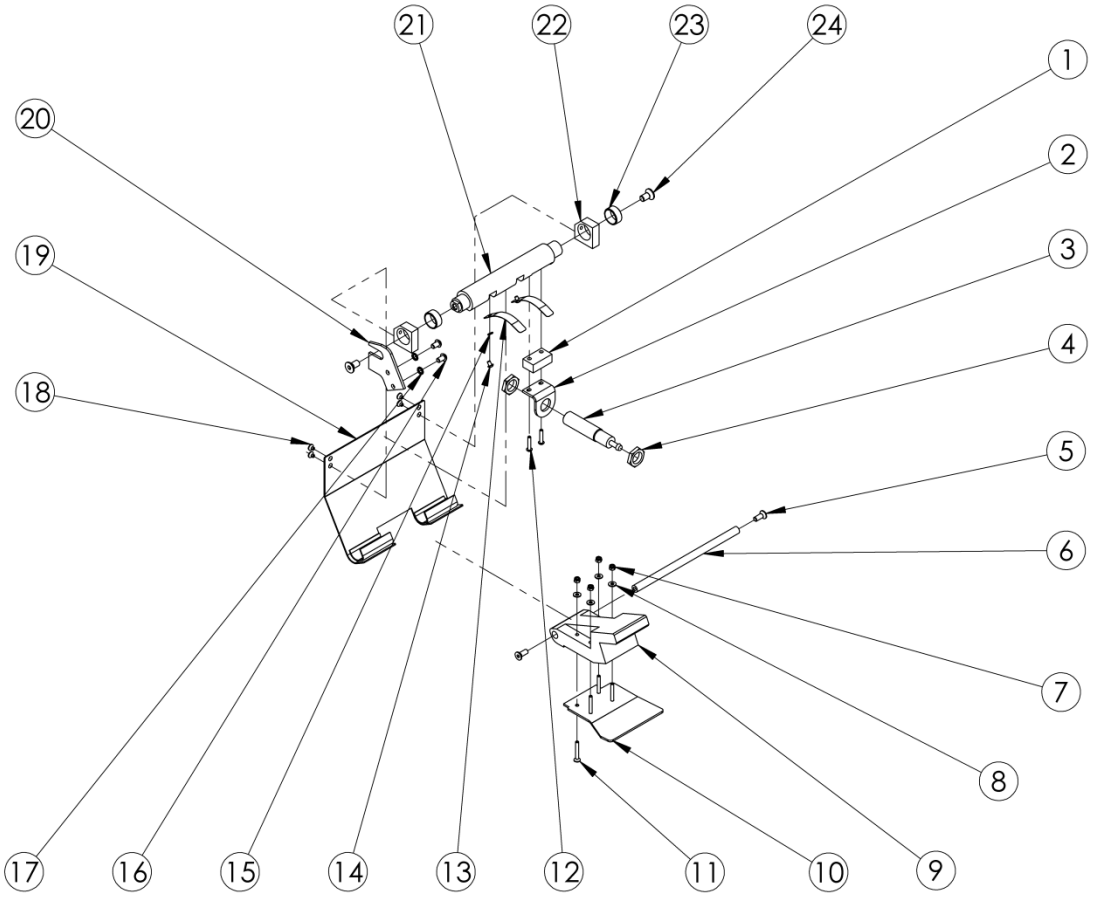
9.13.1 UAM0513 – BRIDGE BASE ASSEMBLY



UAM0513 – BRIDGE BASE ASSEMBLY

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	UPM5102	SHAFT, dia 9.5	1
2	UPM4992	SPACER, 18L	2
3	UPM4989	TOP COVER	1
4	UF6375	SHCS M4-0.7X50	2
5	UPM1068	COMPRESSION SPRING	2
6	UPH4004	BRUSH 4" TH	1
7	UPM4968	BRUSH HOLDER ADAPTER	1
8	UF0074	FHCS M5-0.8X50	2
9	UF1828	M6 FW	2
10	UF6363	LW M6	2
11	UPM5084	SPRING SUPPORT	2
12	UF1241EV	BHCS M6-1.0X20	2
13	UPM4990	OVER FLOW TRAY	1
14	UF3714	FHCS M4-0.7X12	4
15	UF6376	LOCK-NUT M4	2
16	UMP6340	UHMW STRIP W22 X T0.8 X 1220L	2
17	UF4050 EV	BHCS M4-0.7X20	4
18	UPM5677	WIRING BOX COVER	1
19	UF5201	SHCS M5-0.8X10	4
20	UF7023	LW M5	8
21	UF1827	FW M5	6
22	UPM5675	WIRING BOX	1
23	UPM6155	BRIDGE WELDMENT	1
24	UF3691	POP RIVET 4mm	4
25	UPM4978	ELECTRICAL SWITCH COVER	1
26	UPM6060	SWITCH PLATE UM122	1
27	UPM4997	BRACKET	1
28	UF3710	FW M4	2
29	UF3681	M4 LW	6
30	UF0869	SHCS M4-0.7X8	2
31	UPM5969	PHOTOELECTRIC SENSOR	1
32	UPM4980	ELECTRICAL RECEPTACLE BASE	1
33	UF9154	SHCS M5-0.8X12	6
34	UF9148	SHCS M4-0.7X10	4
35	UPM4938	RECEPTACLE CONNECTION	1
36	UPM4939	ELECTRICAL RECEPTACLE CONNECTION MALE	1
37	UPM4905	CORD GRIP	1
38	UF1042	FHCS M6-1.0X12	2
39	UPM5967	GUIDE ROLLER, 40OD	2
40	UPM4936	RUBBER RING	2
41	UPM4933	ROLLER, dia 17, 72L	1
42	UPM4993	SHAFT, dia 12.7, 189L	1
43	UPM6145	RETAINING RING S10	4
44	UF5404	FHCS M5-0.8X16	2
45	UPM4991	SHAFT, dia 9.5, 181L	1

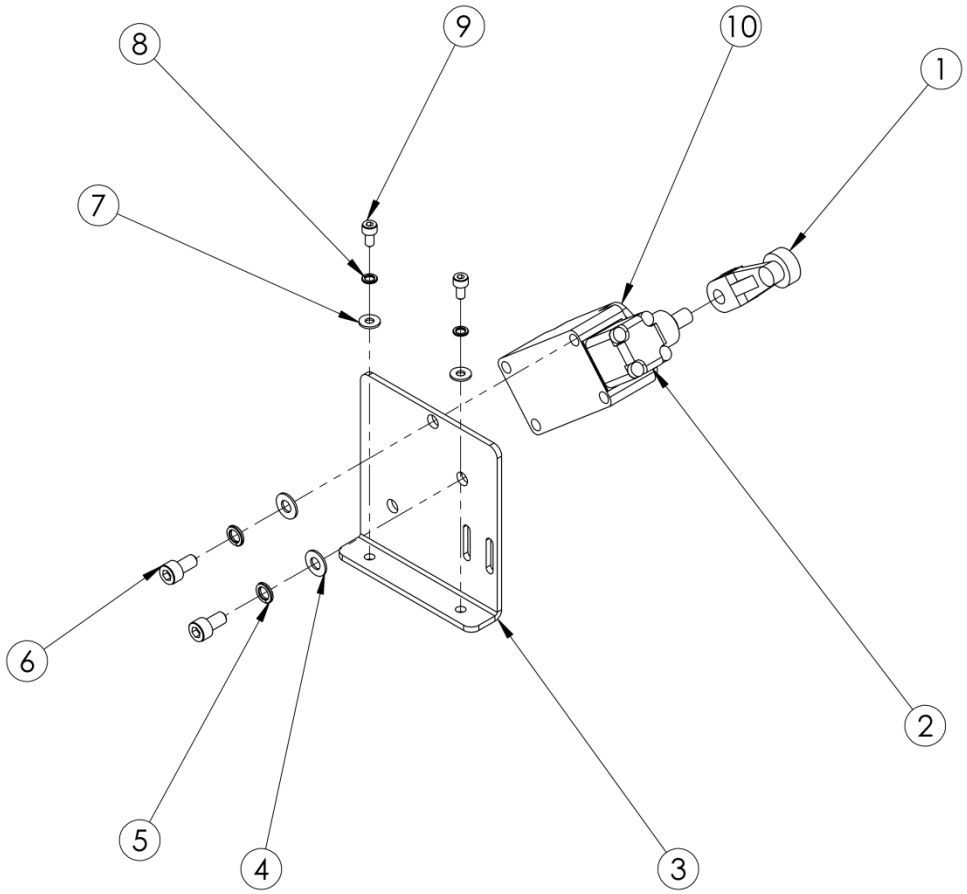
9.13.1.1 UAM0530 – BRIDGE HEAD ASSEMBLY



UAM0530 – BRIDGE HEAD ASSEMBLY

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	UPM3238	SPACER RSA 2024 2000 (UPM0733)	1
2	UPM0733	MOUNTING BRACKET FOR M18 SENSOR	1
3	UPM0014	FRONT PADDLE SENSOR IG5399	1
4	UPM0014-nut	FRONT PADDLE SENSOR IG5399 NUT	2
5	UF1192	FHCS M6-1.0X16	2
6	UPM6062	LOWER PIVOT SHAFT	1
7	UF6376	M4 LOCK-NUT	4
8	UF3710	FW M4	4
9	UPM2129EV/7817	SENSOR PLATE PIVOT BLOCK	1
10	UPM3217EV	SENSOR PLATE RSA2024	1
11	UF0073	SS FHCS M4-0.7X30	4
12	UF4050EV	BHCS M4-0.7X20	2
13	UPM0962EV	SPRING RETAINER	2
14	UF6374	BHCS M4-0.7X6	2
15	UF3681	M4 LW	2
16	UF1211	BHCS M6-1.0X10	2
17	UF6363	LW M6	2
18	UF6352	FHCS M4-0.7X6	4
19	UPM6060	SWITCH PLATE UM122	1
20	UPM6064	ANTI ROTATING PLATE UM122	1
21	UPM6065	FRONT SUPPORT SHAFT UM122	1
22	UPM6348	SWITCH PLATE SUPPORT BRACKET	2
23	UPM0335EV	PFB 20X12mm	2
24	UF3684	FHCS M8-1.25X16	2

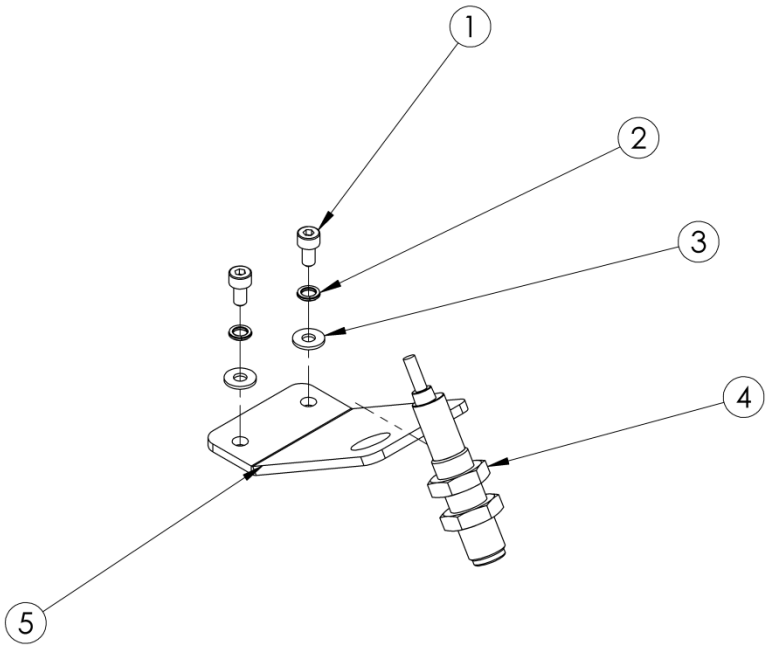
9.13.1.1.1 UAM0531 – BRIDGE SNAP SWITCH ASSEMBLY



UAM0531 – BRIDGE SNAP SWITCH ASSEMBLY

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	UPM6346	SNAP ACTION SWITCH BRACKET	1
2	UF1828	FW M6	2
3	UF6363	LW M6	2
4	UF0038	SHCS M6-1.0X12L	2
5	UF3710	FW M4	2
6	UF3681	M4 LW	2
7	UF5928	SHCS M4-0.7X8	2
8	UPM5711	SWITCH SNAP ACTION SPDT 10A 125V	1

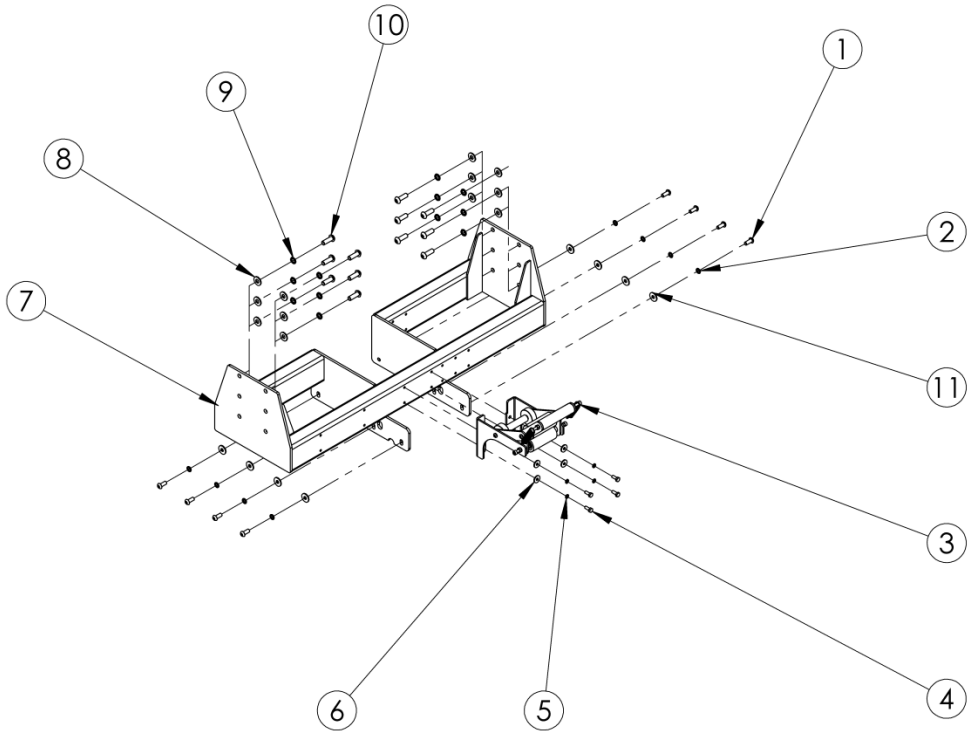
9.13.1.1.2 UAM0532 – BRIDGE HEAD PHOTOELECTRIC SENSOR ASSEMBLY



UAM0532 – BRIDGE HEAD PHOTOELECTRIC SENSOR ASSEMBLY

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	UF5928	SHCS M4-0.7X8	2
2	UF3681	M4 LW	2
3	UF3710	FW M4	2
4	UPM5969	PHOTOELECTRIC SENSOR	1
5	UPM6357	BRIDGE HEAD PHOTOELECTRIC SENSOR BRACKET	1

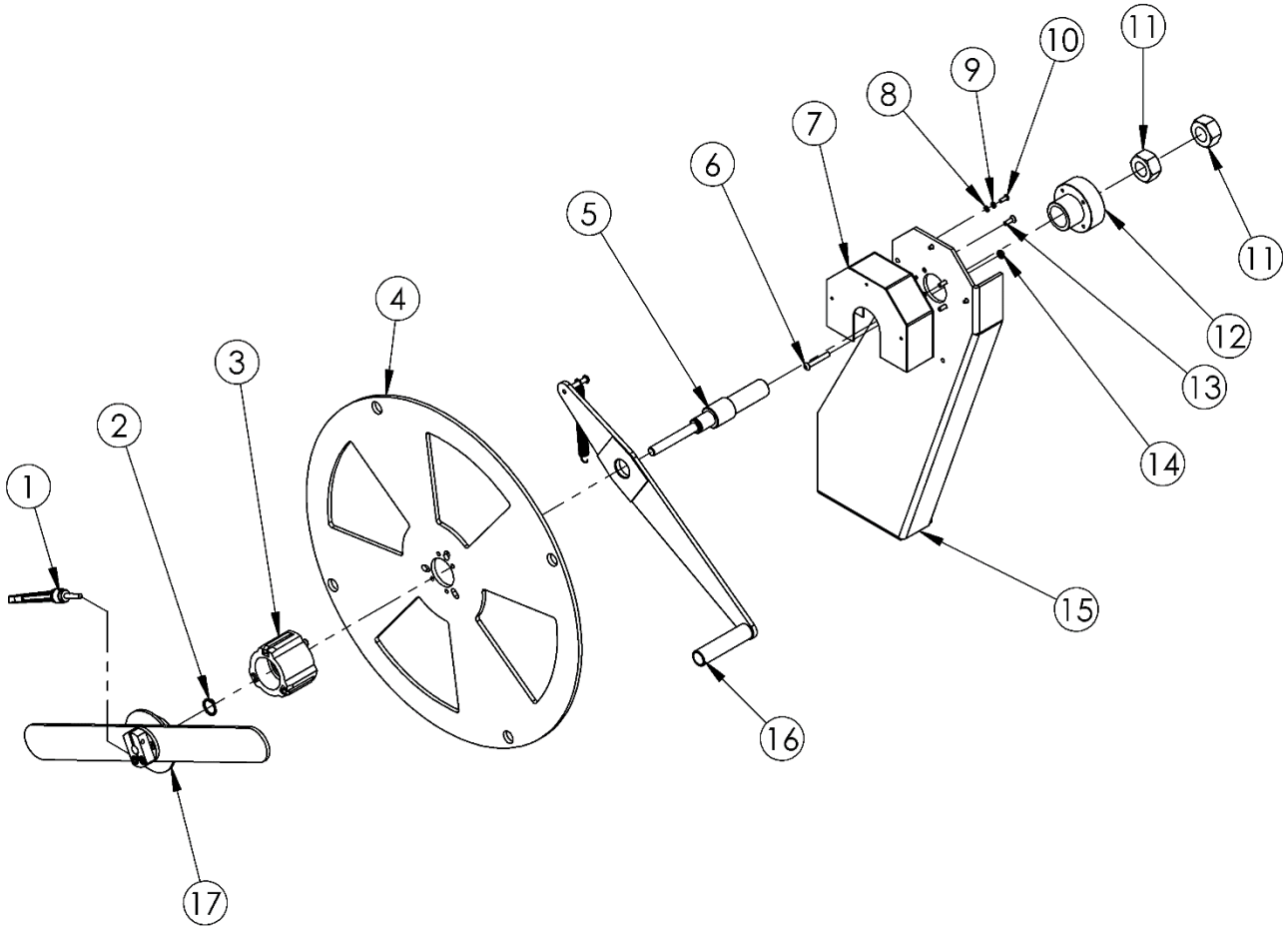
9.13.2 UAM0514 – BRIDGE TAPE ROLL MOUNT ASSEMBLY



UAM0514 – BRIDGE TAPE ROLL MOUNT ASSEMBLY

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	UF1318	BHCS M8-1.25X20	8
2	UF0867	M8 LW	8
3	UAM0025	CLUTCH MECHANISM RSA	1
4	UF0454	HHCS M6-1X16	4
5	UF6363	M6 LW	4
6	UF1828	M6 FW	4
7	UPM6165	BRIDGE WELDMENT	1
8	UF3680	M10 FW	12
9	UF6371	M10 LW	12
10	UF4310	BHCS M10-1.5X30	12
11	UF3643	M8 FW	8

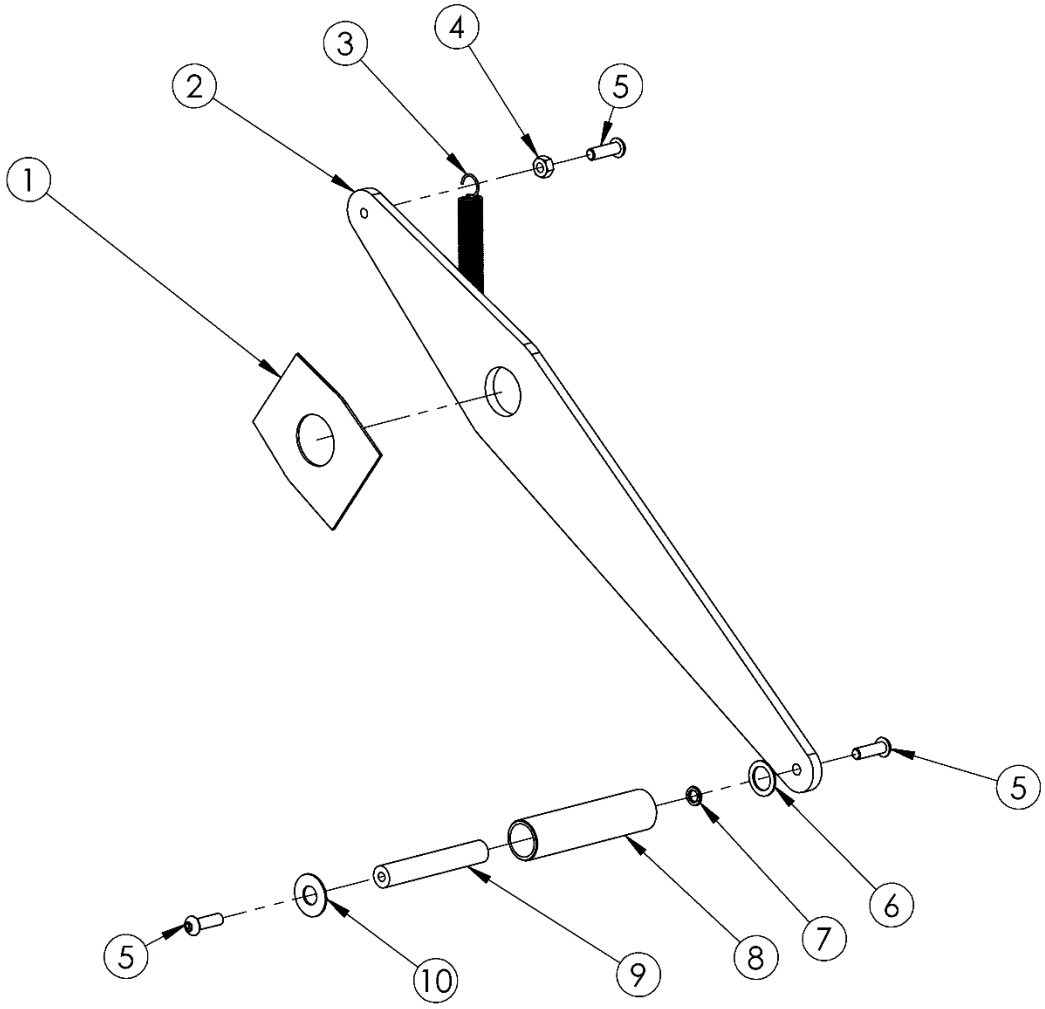
9.13.3 USM7585 – TOP TAPE CARRIAGE ASSEMBLY



USM7585 – TOP TAPE CARRIAGE ASSEMBLY

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	UPM4889	HANDLE	1
2	UF3815	RET'G RING, ID 10	1
3	UAM0195	MANDREL HUB	1
4	UPM5111	PANCAKE	1
5	UPM5109	STEPPED SHAFT R.H.	1
6	UF4503	SS BHCS M6-1 x 40mm	1
7	UPM5200	BACK COVER	1
8	UF6339	SS FW M4	3
9	UF3749	SS LW M4	3
10	UF4325	SS BHCS M4-0.7 x 12mm	3
11	UF3816	HEX NUT M24 - 1.5	2
12	UPM9901	HUB USA	1
13	UF3277	SS FHCS M5-0.8 x 16 mm	4
14	UF3361	SS JAM NUT M6	1
15	UPM5201	MANDREL FRAME	1
16	UAM0479	DANCER ARM ASSEMBLY	1
17	UPM5715	CROSS BAR ASSEMBLY	1

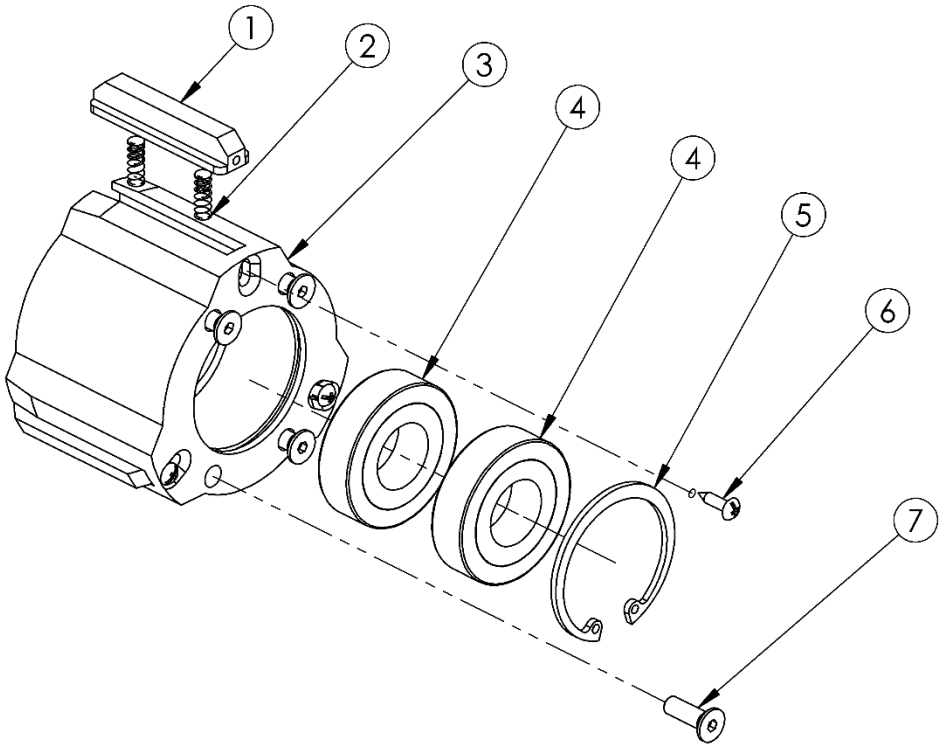
9.13.3.1 UAM0479 – DANCER ARM ASSEMBLY



UAM0479 – DANCER ARM ASSEMBLY

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	UPM9802	BREAK PAD	1
2	UPM6238	PIVOT ARM R.H.	1
3	UPM4498	EXTENSION SPRING	1
4	UF0062	M6-1.0-HNR	1
5	UF1241EV	BHCS M6-1.0×20L	3
6	UF6336	F.W. PTFE, 13 x 19 x 1 mm	1
7	UF6363	LW M6	1
8	UPH9059	PEEL OFF ROLLER ET 72	1
9	UPH0949	GUIDE ROLLER SHAFT	1
10	UF3680	M10 FW	1

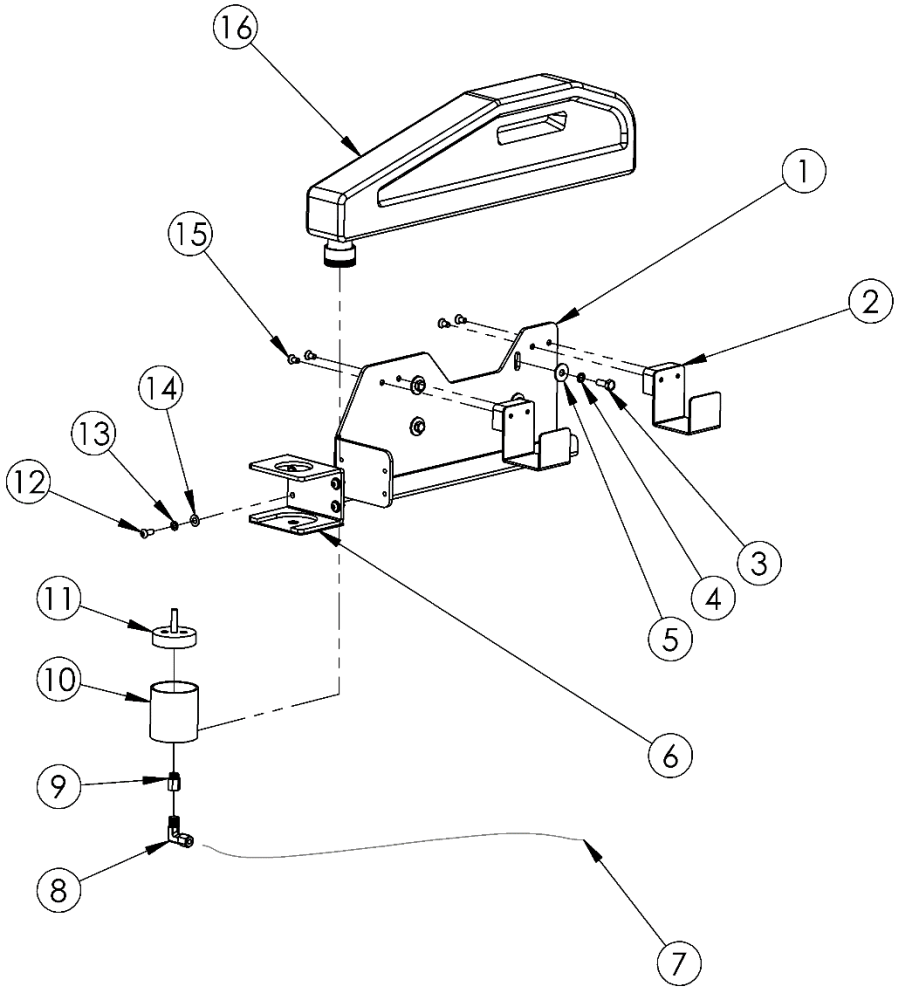
9.13.3.2 UAM0195 – MANDREL HUB ASSEMBLY



UAM0195 – MANDREL HUB ASSEMBLY

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	UPM5074	SPRAG, Mandrel	3
2	UPH1468	COMPRESSION SPRING	6
3	UPM5073	MANDREL HUB	1
4	UPM0324	BEARING PULLEY	2
5	UF0101	INTERNAL RETAINING RING, 42mm	1
6	UF9164	M3-0.5×12L	3
7	UF5404	FHCS M5-0.8×16L	4

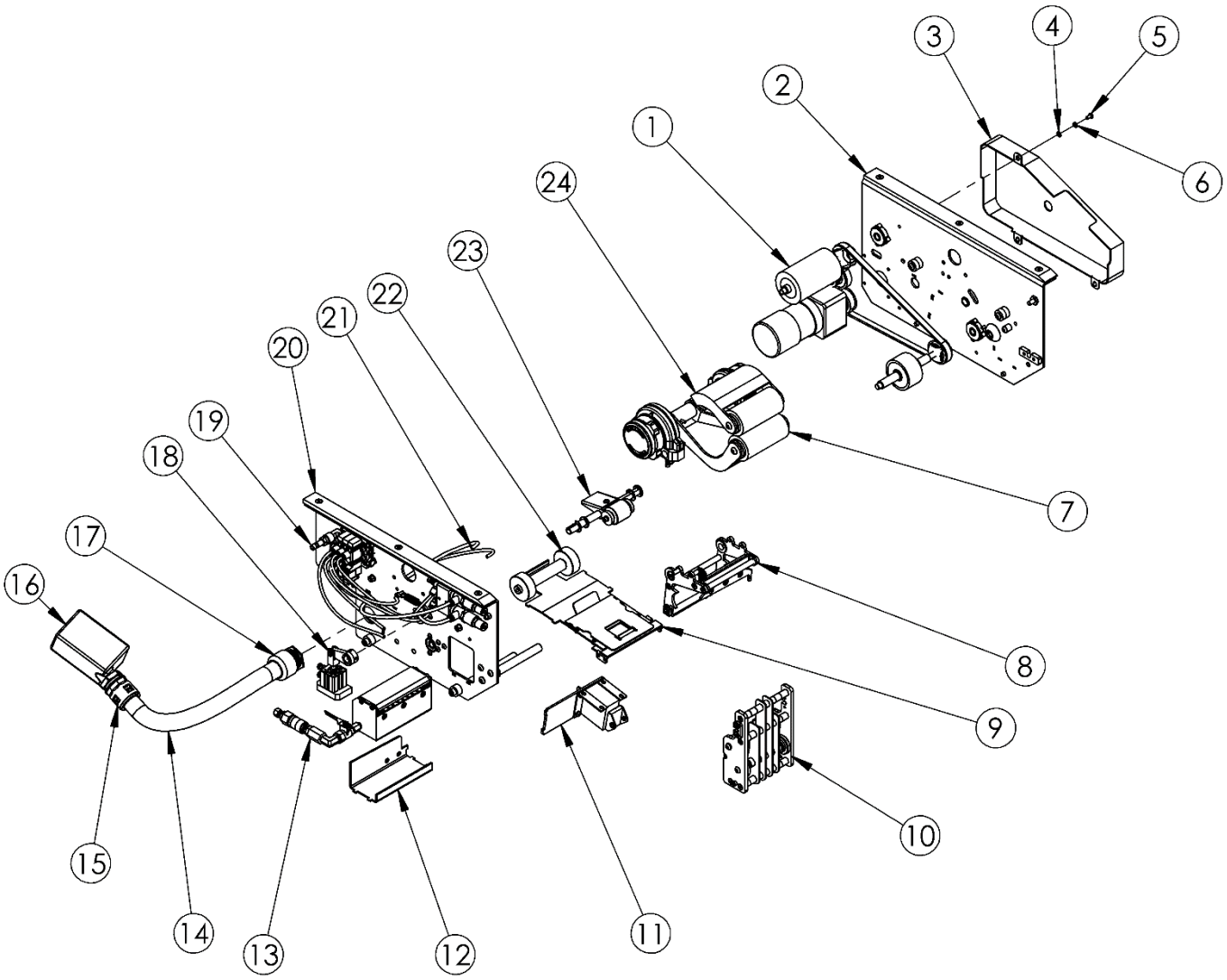
9.13.4 USM0907 – TOP WATER BOTTLE UNIT ASSEMBLY



USM0907 – TOP WATER BOTTLE UNIT ASSEMBLY

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	UPM5116	FRAME	1
2	UPM5120	WT BOTTLE HOLDER	2
3	UF3751	SS HHCS M6-1.0 x 16mm	4
4	UF6411	SS LW M6	4
5	UF1890	FLAT WASHER 1/4 x 3/4 x 1/16	4
6	UPM4945	CUP HOLDER	1
7	UPM5165	TUBE, 6 OD x 4 ID	1
8	UPM5148	ELBOW FITTING	1
9	UPH1496	REDUCER	1
10	UPM4946	RESERVOIR CUP	1
11	UPM4947	PLUNGER	1
12	UF7011	SS BHCS M5-0.8 X 12mm	4
13	UF7021	SS LW M5	4
14	UF4071	F. WASHER 6 x 12 x 0.5 SS	4
15	UF3262	SS FHCS M5-0.8 x 10 mm	4
16	WST1014	WT Bottle SA	1

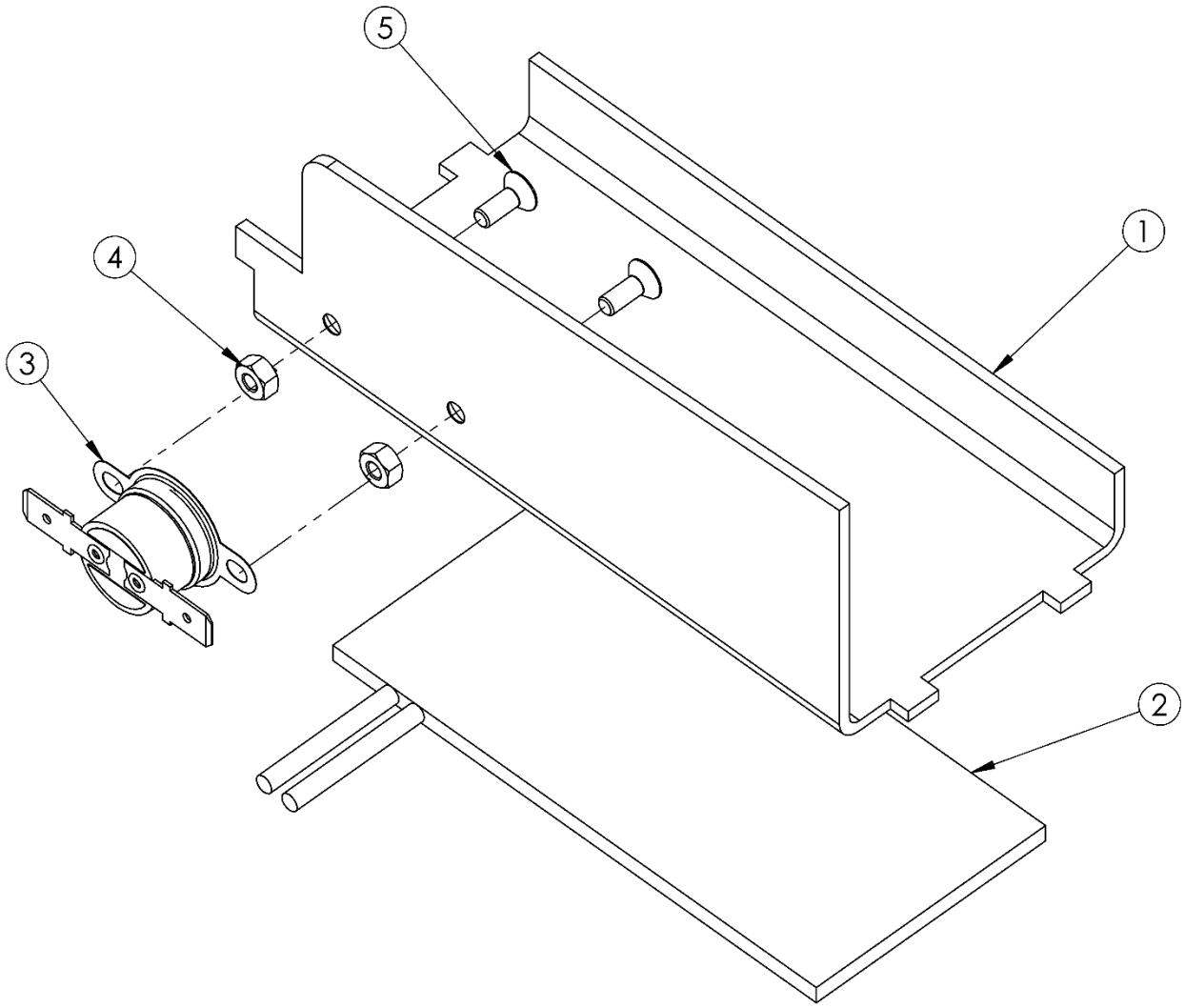
9.14 *WST1036 – BOTTOM TAPE HEAD ASSEMBLY*



WST1036 – BOTTOM TAPE HEAD ASSEMBLY

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	WST1028	DRIVETRAIN ASS'Y	1
2	WST1021	RIGHT FRAME ASS'Y	1
3	WET0165	COVER BELT	1
4	UF6339	SS FW M4	3
5	UF7009	SS BHCS M4-0.7 x 8	3
6	UF3749	SS LW M4	3
7	WST1030	REAR TUCKING ARM ASS'Y	1
8	WST0058	BOTTOM KNIFE ARM ASS'Y	1
9	WST1027	TAPE GUIDE ASS'Y	1
10	WST1022	TAPE SHOE ASS'Y	1
11	WST0057	SOLENOID ASS'Y	1
12	WST1023	HEATER PLATE ASS'Y	1
13	WST1031	WATER POT ASS'Y	1
14	UPM6231	CORD	1
15	UPM4905	CORD GRIP	1
16	UPM4939	ELECTRICAL RECEPTACLE CONNECTION MALE	1
17	WET0241	CORD GRIP	1
18	WST1025 TOP HEAD	PINCH ROLLER CYLINDER ASS'Y	1
19	WST1032	CONTROL VALVE ASS'Y	1
20	WST1020	LEFT FRAME ASS'Y	1
21	UPM3583	TUBE 4mm BLUE, SOFT	1
22	WST1026	GUIDE ROLLER ASS'Y	1
23	WST0059	PINCH ROLLER ASS'Y	1
24	WST1029	FRONT WIPE DOWN ARM ASS'Y	1

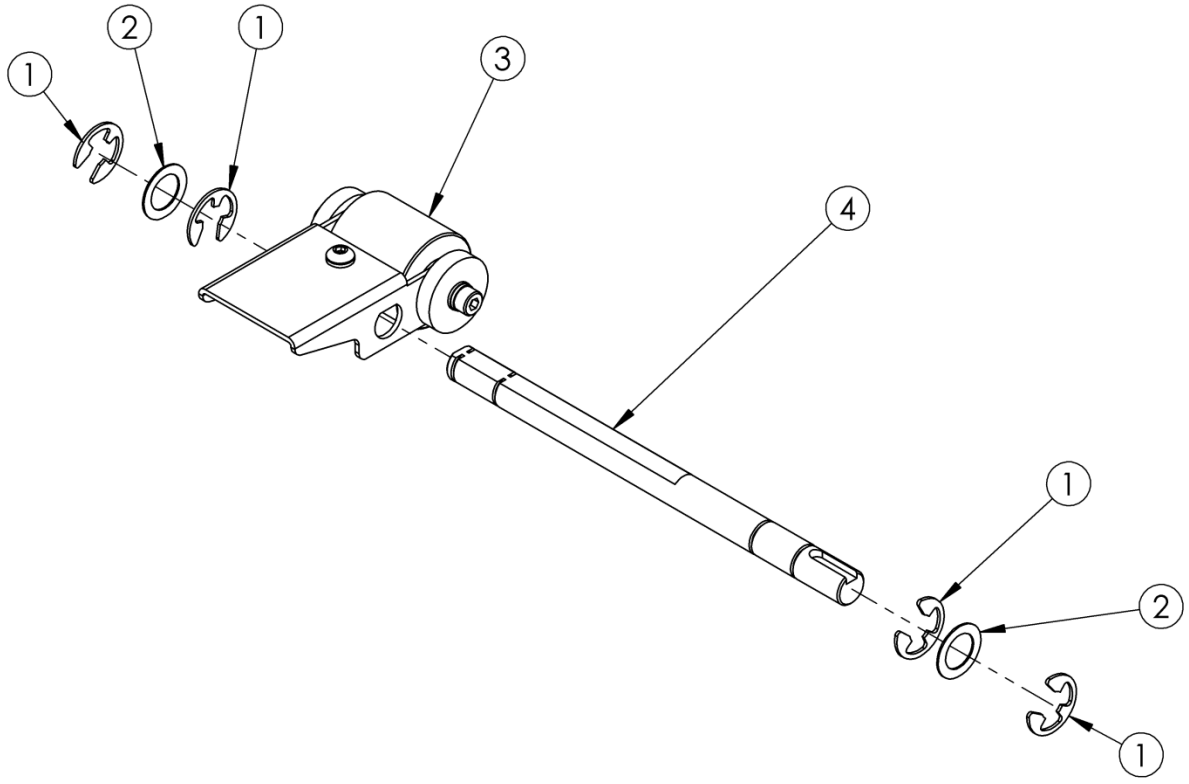
9.14.1 WST1023 – HEATER PLATE ASSEMBLY



WST1023 – HEATER PLATE ASSEMBLY

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	WET0148	WATER RESERVOIR SUPPORT	1
2	WET0186	HEATER PAD	1
3	WET0185	THERMOSTAT	1
4	UF3717	SS HEX NUT M3-0.5	2
5	UF6350	SS FHCS M3-0.5 x 8 mm	2

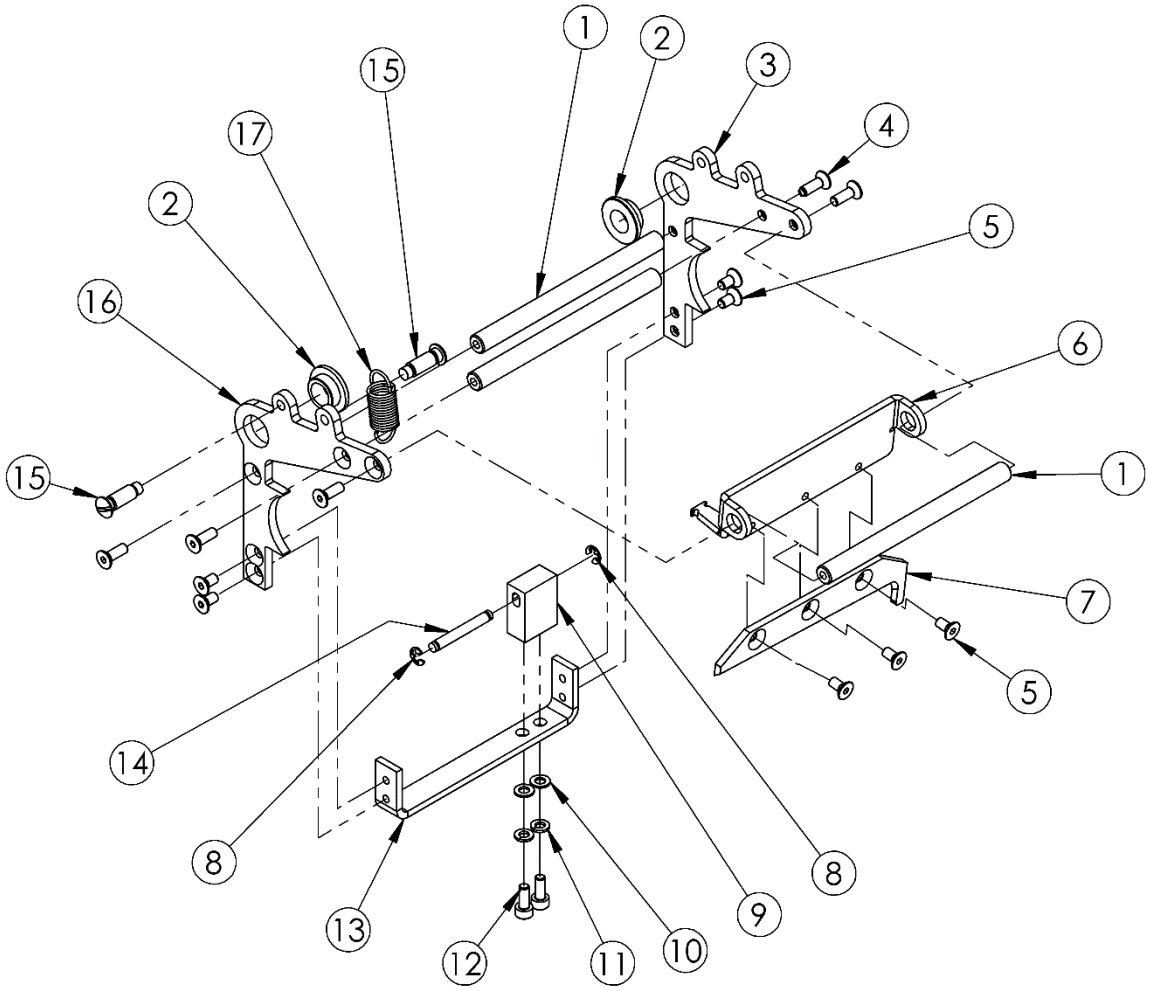
9.14.2 WST0059 – PINCH ROLLER ASSEMBLY



WST0059 – PINCH ROLLER ASSEMBLY

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	UF7019	SS E RET'G RING EXTERNAL, 10 mm	4
2	UF6389	NYLON FW10.5 x16 x 0.5	2
3	WST0009	WT PINCH ROLLER SA	1
4	WET0149	SHAFT, dia 10mm	1

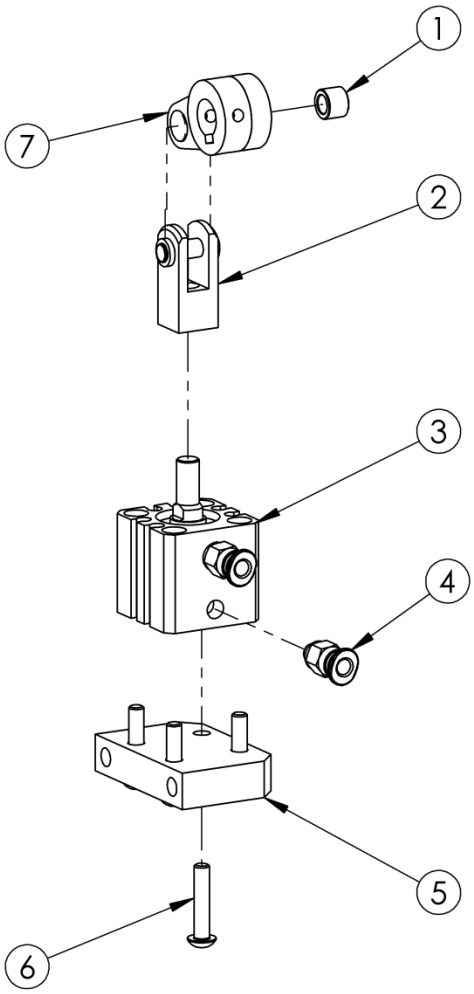
9.14.3 WST0058 – BOTTOM KNIFE ARM ASSEMBLY



WST0058 – BOTTOM KNIFE ARM ASSEMBLY

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	WPT0048	WT KNIFE ARM PIVOT SHAFT	3
2	WPT0004	OILITE FLANGE BEARING 10mm	2
3	WPT0075	KNIFE ARM RIGHT FRAME	1
4	UF3761	SS FHCS M4-0.7 x 12mm	6
5	UF3274	SS FHCS M4-0.7 x 8 mm	7
6	WPT0049	WT Cutter Blade Support	1
7	WPT0050	CUTTER BLADE	1
8	UF3553	SS E RET RING EXTERNAL 4mm	2
9	WPT0078	KNIFE ARM BLOCK	1
10	UF6339	SS FW M4	2
11	UF3749	SS LW M4	2
12	UF3759	SS SHCS M4-0.7 x 10mm	2
13	WPT0104	WT KNIFE ARM SUPPORT	1
14	WPT0079	KNIFE ARM BLOCK SHAFT	1
15	UF2215	SHOULDER SCREW M5 x 15L SHOULDER	2
16	WPT0076	KNIFE ARM LEFT FRAME	1
17	WPT0053	EXTENSION SPRING 14.75 COILS	1

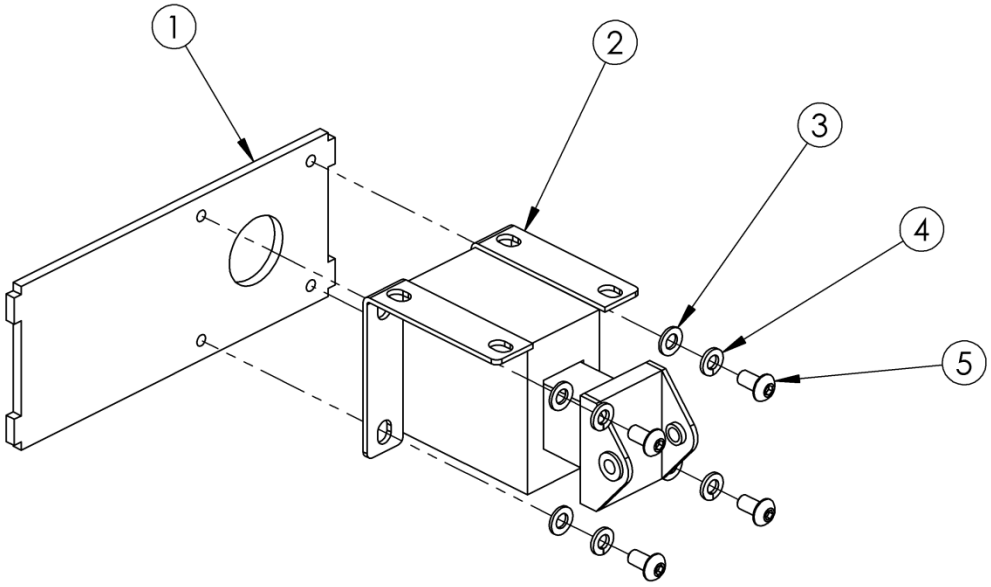
9.14.4 WST1025 – PINCH ROLLER CYLINDER ASSEMBLY



WST1025 – PINCH ROLLER CYLINDER ASSEMBLY

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	UPM4493	8OD x 5ID x 6 BUSHING	1
2	WET0152	CLEVIS	1
3	WET0151	CYLINDER	1
4	UPH4906	M5 x 4mm STRAIGHT FITTING	2
5	WET0150	CYLINDER SUPPORT	1
6	UF4323	SS BHCS M4 - 0.7 x 20mm	4
7	WET0153	PIVOT ARM	1

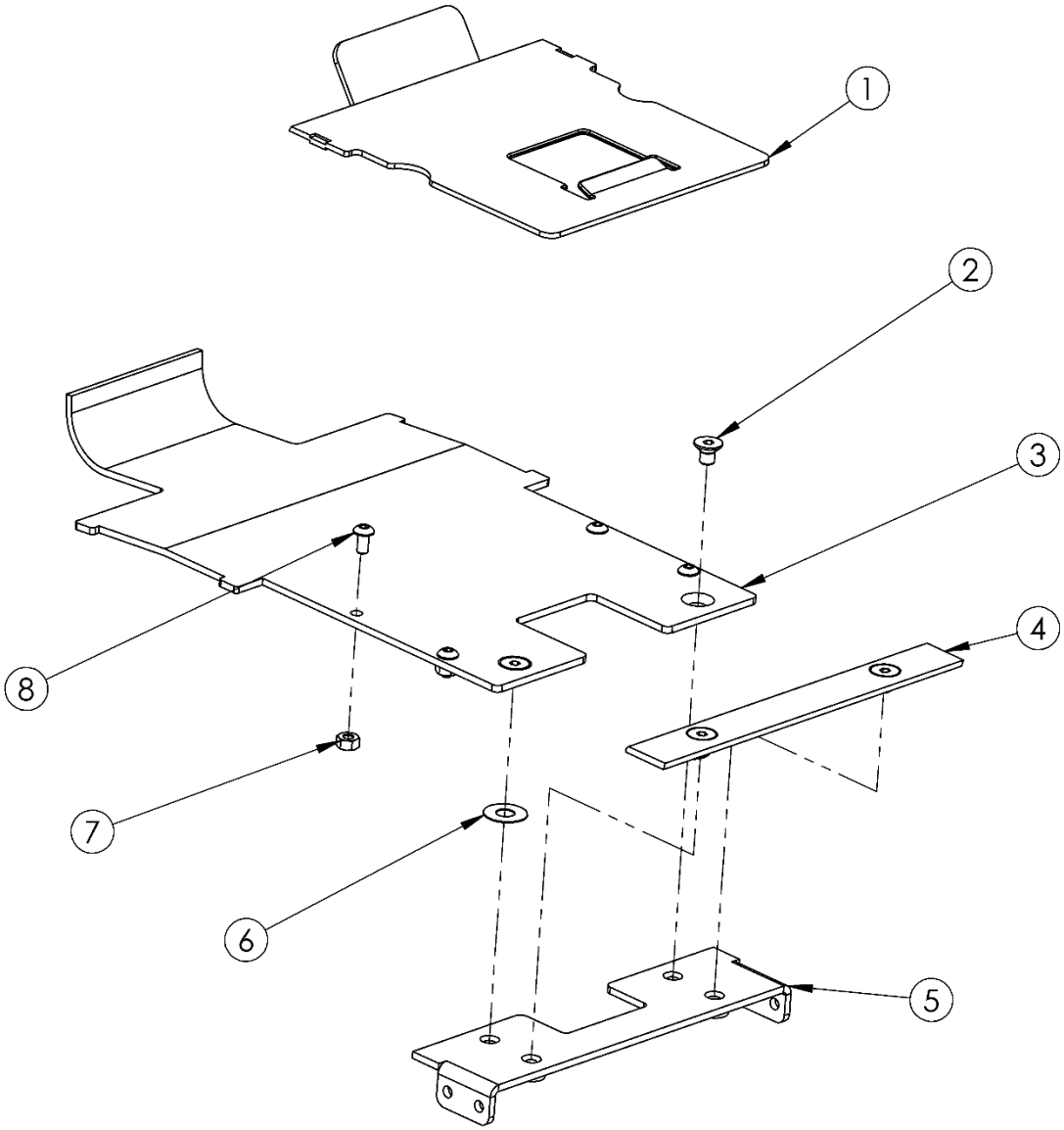
9.14.5 WST0057 – SOLENOID ASSEMBLY



WST0057 – SOLINOID ASSEMBLY

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	WET0019	MOUNTING PLATE	1
2	WET0026	SOLENOID	1
3	UF3710	FW M4	4
4	UF3681	LW M4	4
5	UF7009	SS BHCS M4-0.7 x 8	4

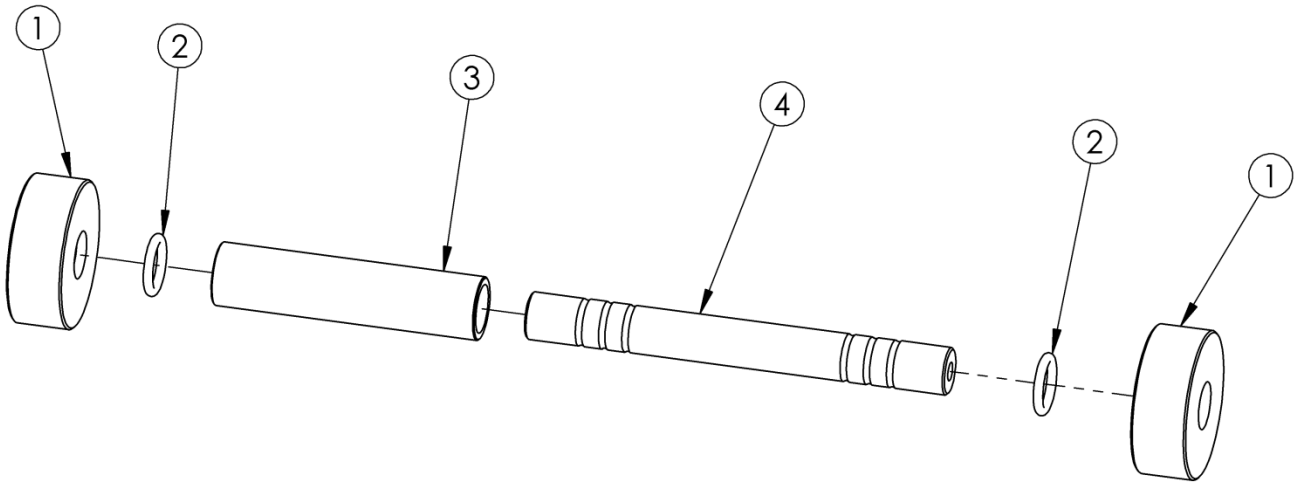
9.14.6 WST1027 – TAPE GUIDE ASSEMBLY



WST1027 – TAPE GUIDE ASSEMBLY

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	WET0190	Upper Guide Plate	1
2	UF6351	SS FHCS M4-0.7 x 6 mm	4
3	WET0154	WT TAPE GUIDE	1
4	WPT0044	STRIKER PLATE	1
5	WET0156	TAPE GUIDE SUPPORT	1
6	UF7030	BRASS WASHER 5.18x12x.28mm THK	2
7	UF3717	SS HEX NUT M3-0.5	4
8	UF4518	SS BHCS M3 - 0.5 x 6	4

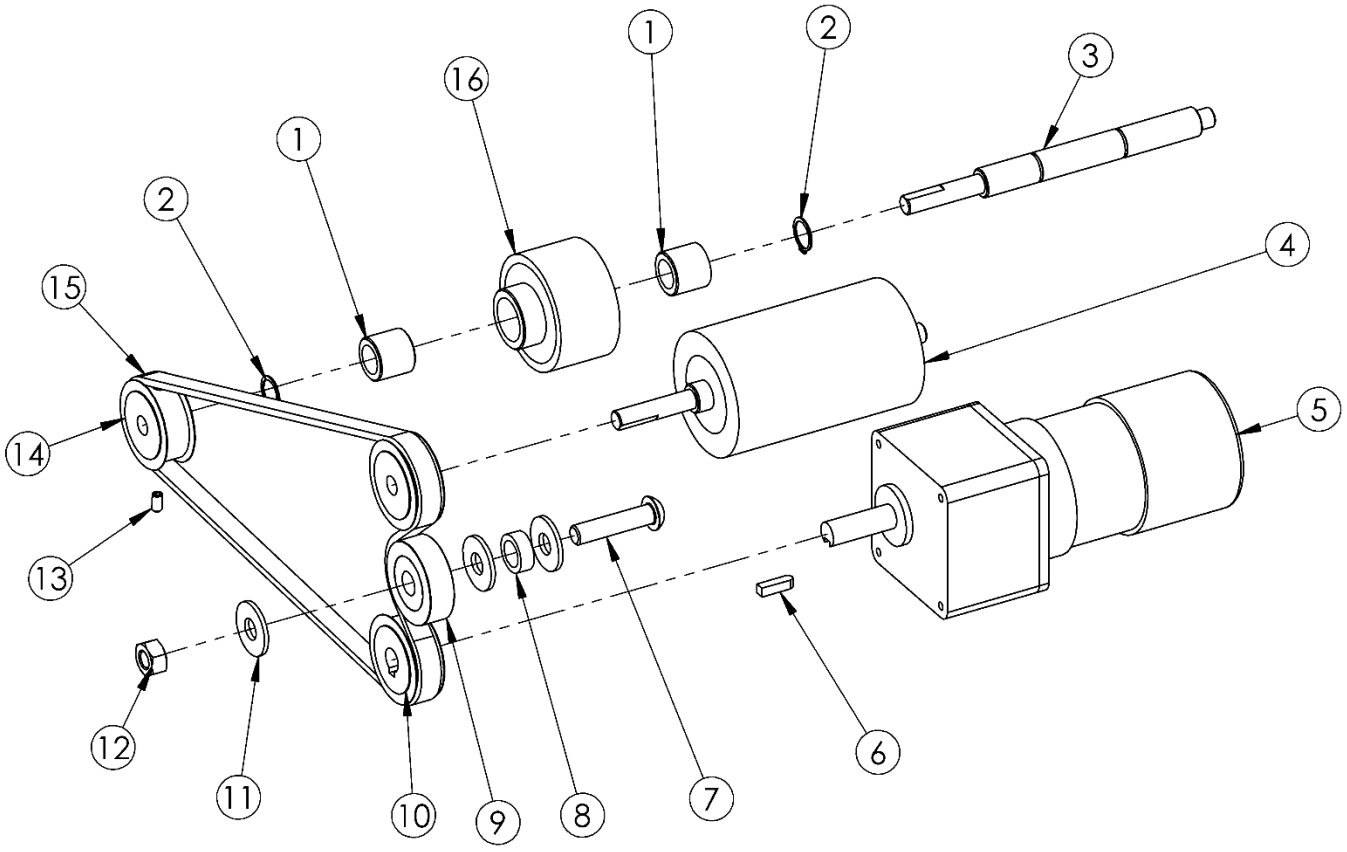
9.14.7 WST1026 – GUIDE ROLLER ASSEMBLY



WST1026 – GUIDE ROLLER ASSEMBLY

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	WET0188	GUIDE ROLLER, 40OD	2
2	UPM4936	RUBBER RING	2
3	WET0189	ROLLER, dia 17, 72L	1
4	WET0187	SHAFT, 115L	1

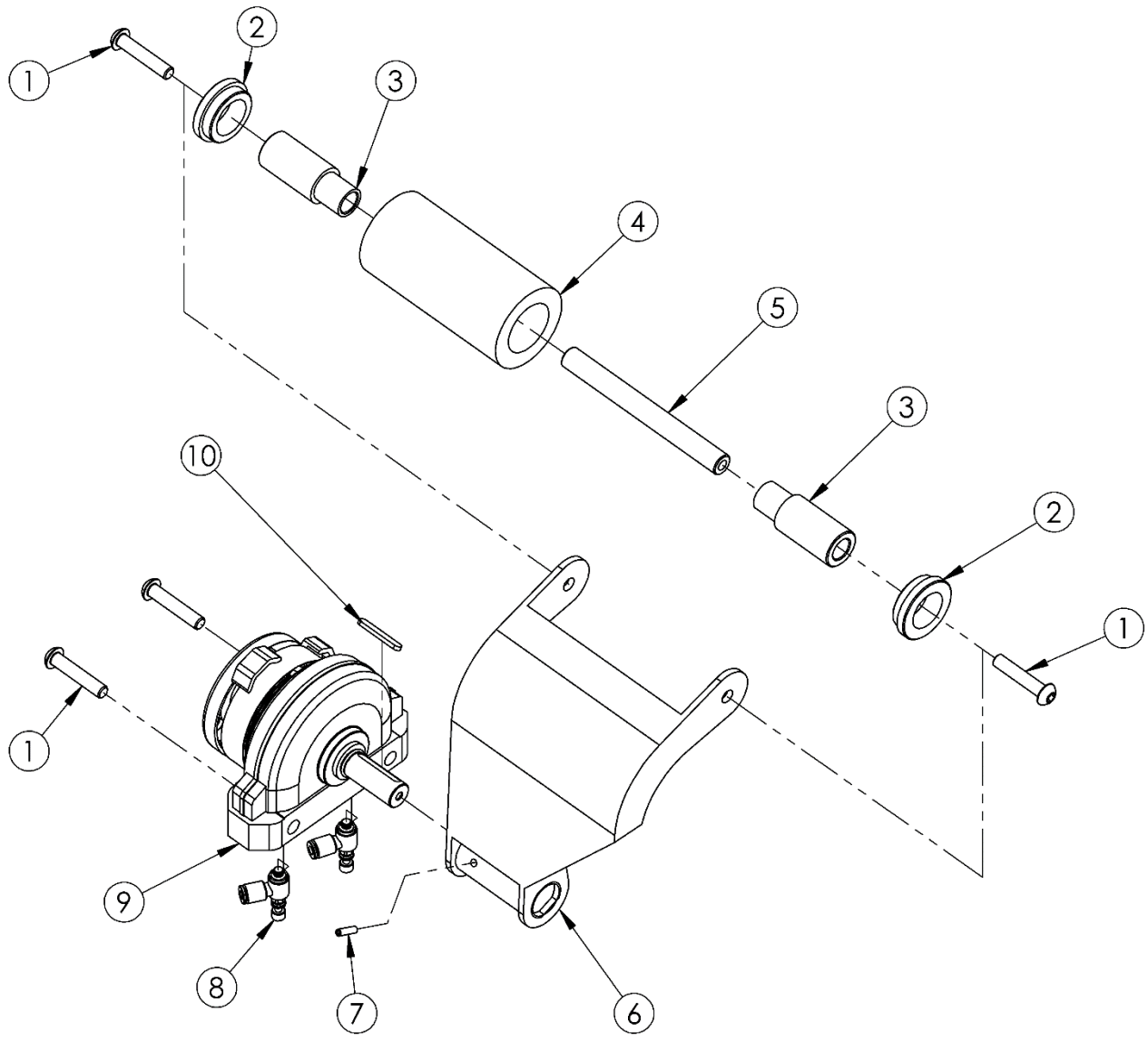
9.14.8 WST1028 – DRIVE TRAIN ASSEMBLY



WST1028 – DRIVE TRAIN ASSEMBLY

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	WET0198	ONE WAY CLUTCH BEARING	2
2	UF6300	Ret'g Ring External 12mm	2
3	WET0196	SHAFT, 140L	1
4	WET0195	DRIVE ROLLER TAPE ASSIST	1
5	WET0183	MOTOR, 2GH 20K	1
6	UF2213	SQUARE KEY, ONE ROUND END	1
7	UF4316	BHCS M8-1.25 x 35mm	1
8	WET0194	SPACER, dia 16,6L	1
9	UPH4919	BALL BEARING, 10ID, 35OD, 11t	1
10	WET0192	SPROCKET GEAR WITH KEY	1
11	UF3643	SS FW M8	3
12	UF3735	SS HNR M8-1.25	1
13	UF4508	SS SSS M4-0.7 x 8	6
14	WET0193	SPROCKET GEAR	2
15	WET0199	DRIVE BELT	1
16	WET0197	GUIDE ROLLER	1

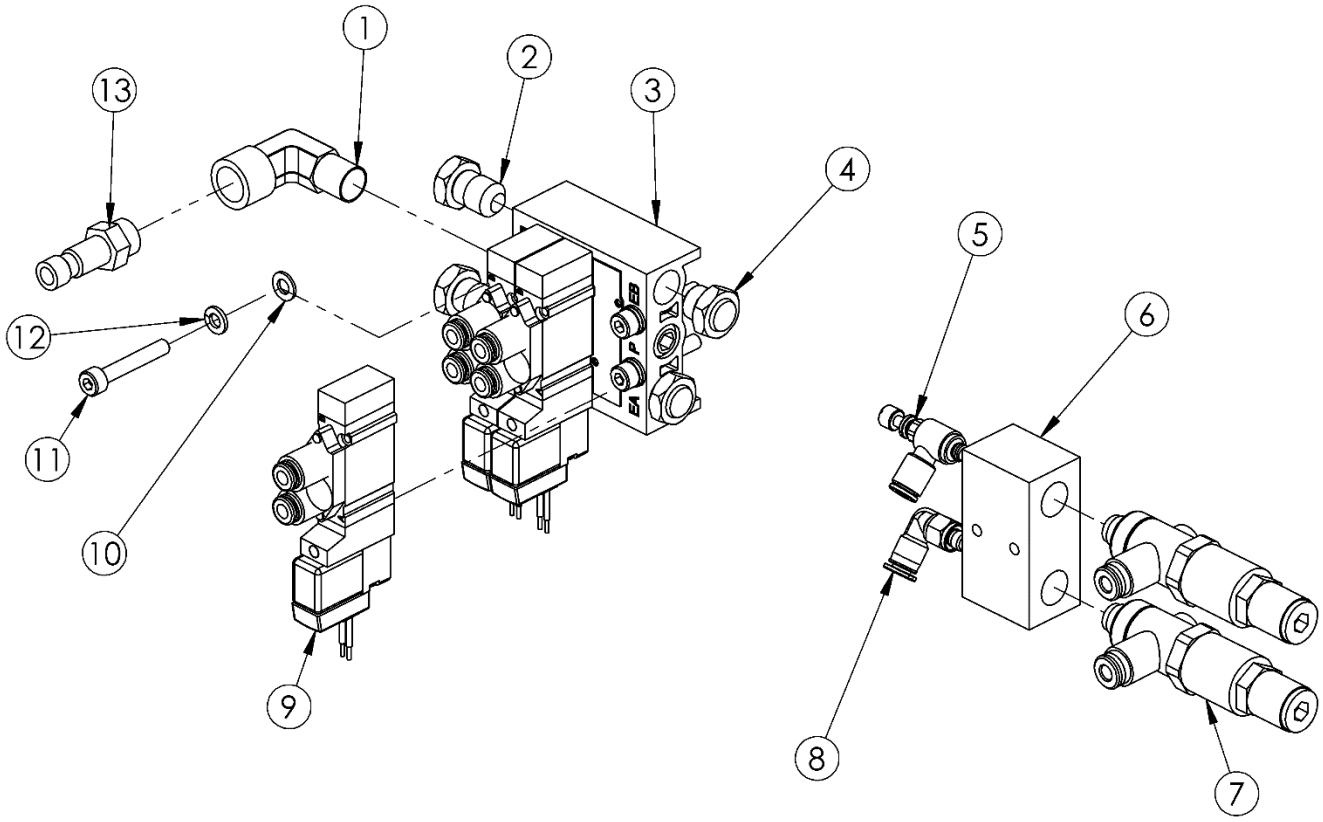
9.14.9 WST1030 – REAR TUCKIN ARM ASSEMBLY



WST1030 – REAR TUCKIN ARM ASSEMBLY

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	UF3752	SS BHCS M6-1 x 30mm	4
2	WET0202	COLLAR	2
3	WET0201	ROLLER CORE	2
4	WET0005	WIPE ARM ROLLER REAR	1
5	WET0203	SHAFT, dia 10	1
6	WET0157	REAR WIPE ARM	1
7	UF3804	SS SSS M3-0.5 x 12mm	2
8	UPH4904	M5 x 4mm OD, FLOW CONTROL	2
9	UPH4849	ROTORY AIR CYLINDER	1
10	UF2214	ROUND KEY	1

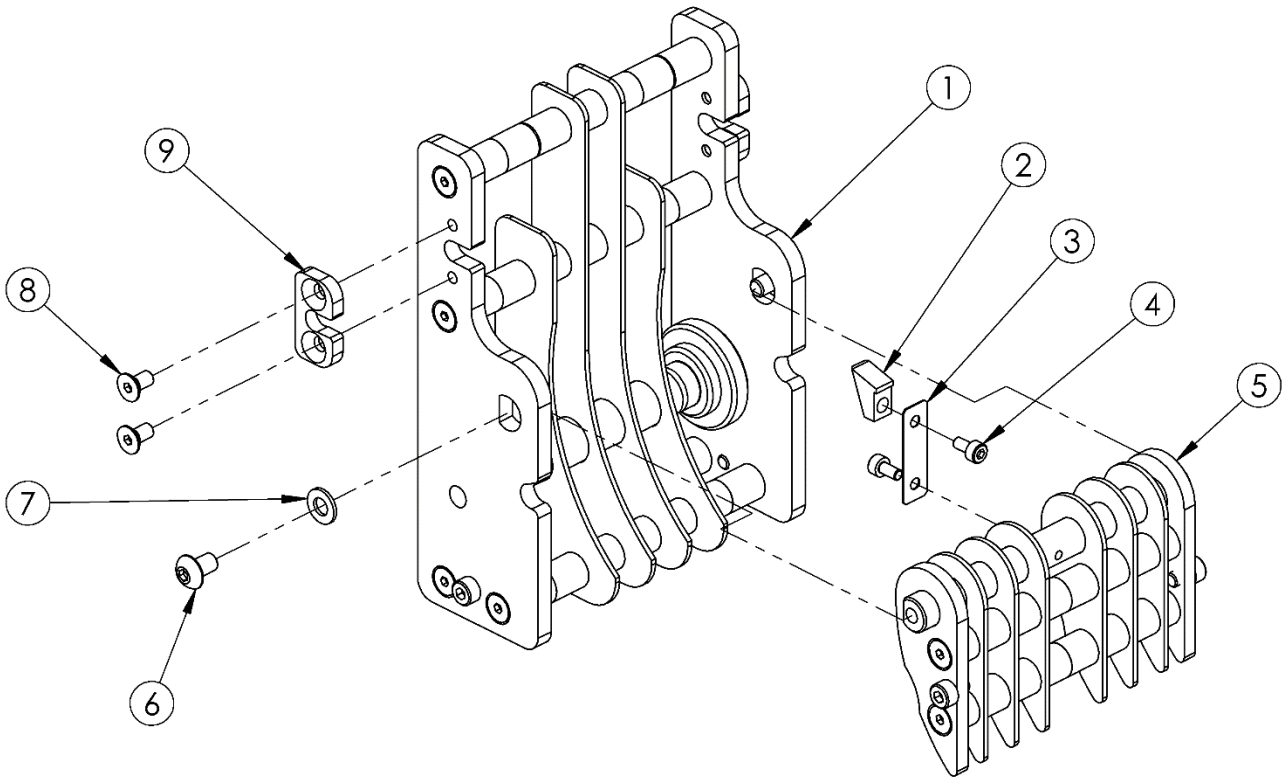
9.14.10 WST1032 – CONTROL VALVE ASSEMBLY



WST1032 – CONTROL VALVE ASSEMBLY

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	UPH1503	FEMALE/MALE ELBOW	1
2	UPM8001	PLUG, G/18	3
3	WET0208	MANIFOLD	1
4	UPH4903	FLAT MUFFLER G1/8	4
5	UPH4904	M5 x 4mm OD, FLOW CONTROL	1
6	WET0210	MANIFOLD	1
7	WET0211	PRESSURE REGULATOR	2
8	UPH4905	M5 x 4mm ELBOW FITTING	1
9	WET0209	VALVE	3
10	UF6339	SS FW M4	4
11	UF3758	SS SHCS M4-0.7 x 25mm	4
12	UF3749	SS LW M4	4
13	UPH1504	COUPLING PLUG	1

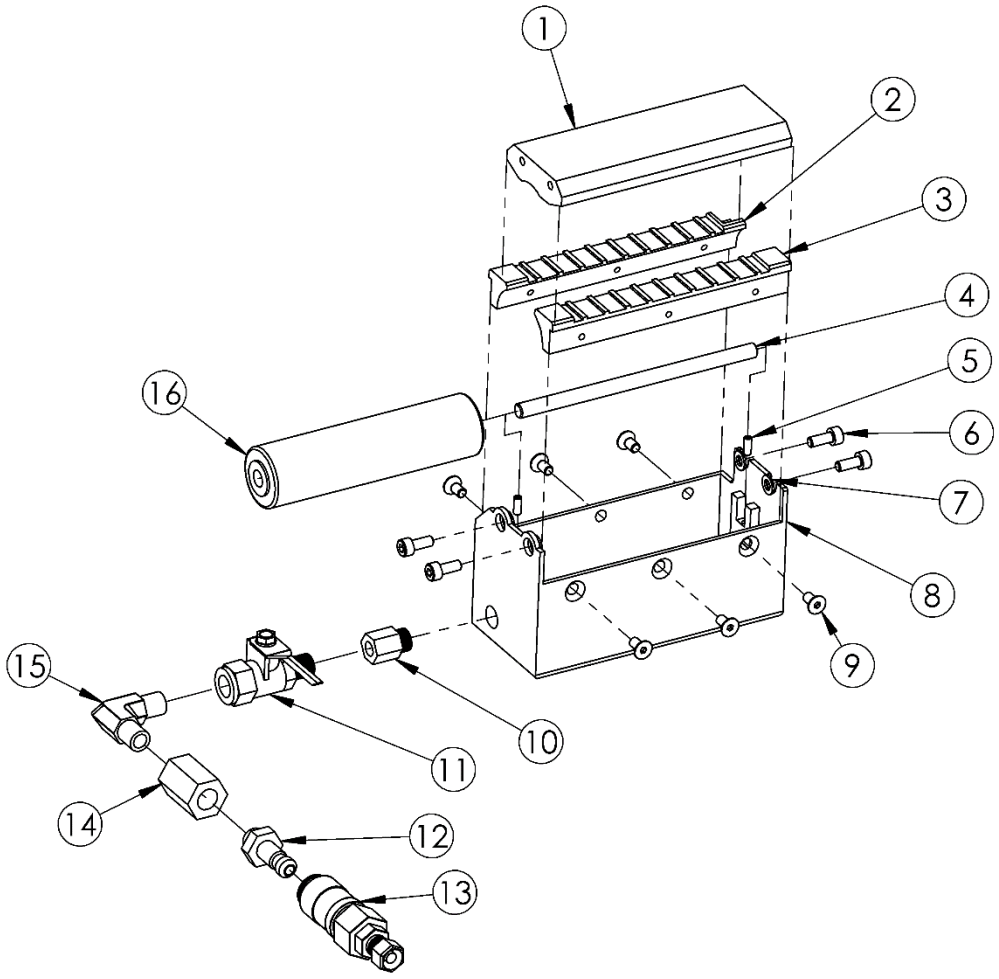
9.14.11 WST1022 – TAPE SHOE ASSEMBLY



WST1022 – TAPE SHOE ASSEMBLY

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	WST1048	MAIN ASS'Y	1
2	UPH4540	FINGER	1
3	UPH3706	SPRING BLADE	1
4	UF3145	SS SHCS M3-0.5 x 6 mm	2
5	WST1049	HINGE ASS'Y	1
6	UF7010	SS BHCS M5 - 0.8 x 8 mm	2
7	UF6340	SS FW M5	2
8	UF3274	SS FHCS M4-0.7 x 8 mm	4
9	WET0182	TAPE SHOE LOCATOR	2

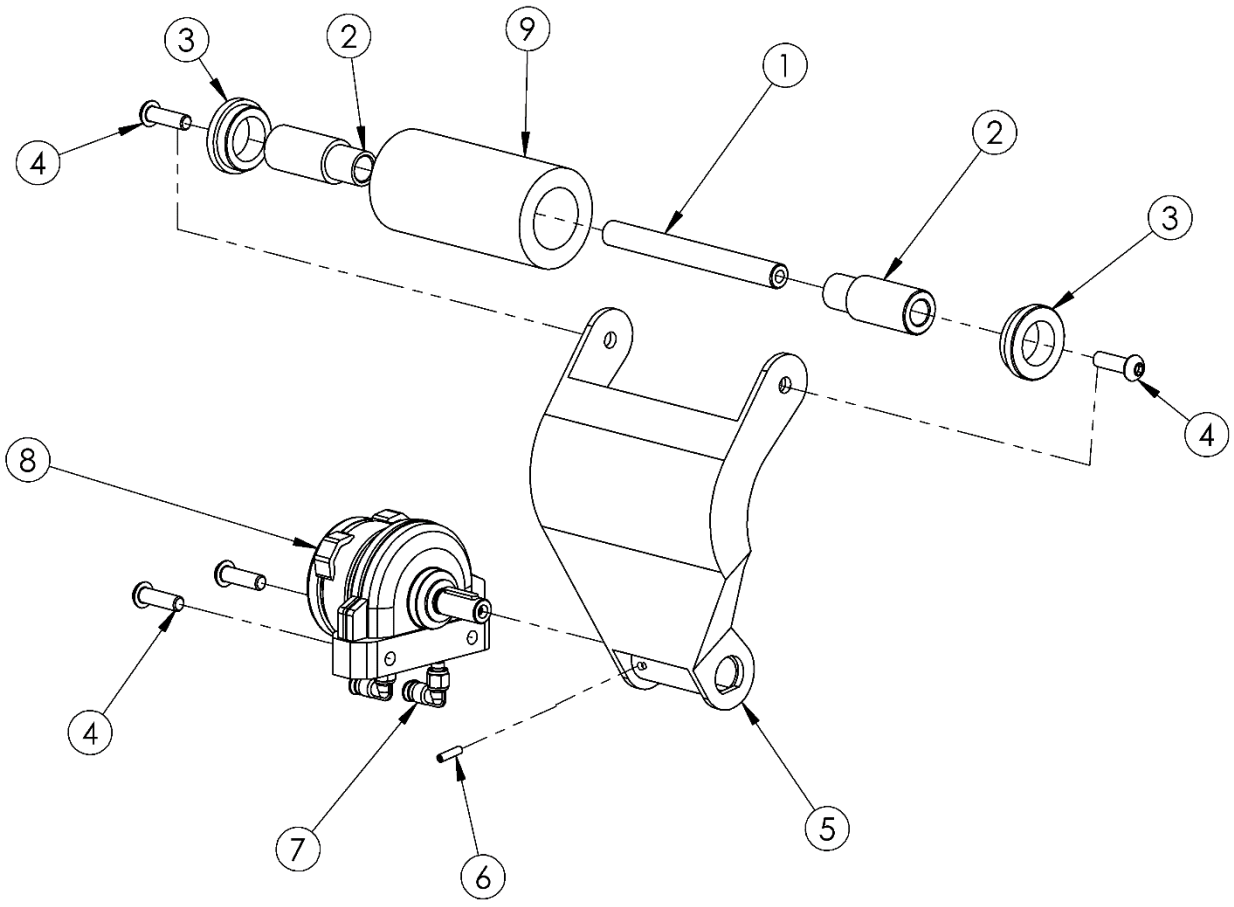
9.14.12 WST1031 – WATER POT ASSEMBLY



WST1031 – WATER POT ASSEMBLY

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	WET0205	PRESSURE PLATE	1
2	WET0167	TAPE GUIDE ENTERANCE	1
3	WET0206	TAPE GUIDE EXIT	1
4	WET0207	SHAFT, 6mm	1
5	UF3804	M3-0.5 X 8mm SSS	2
6	UF3759	SS SHCS M4-0.7 x 10mm	4
7	UF3710	FW M4	4
8	WET0204	WATER POT	1
9	UF3274	SS FHCS M4-0.7 x 8 mm	6
10	UPH1496	REDUCER	1
11	X3117	BALL VALVE	1
12	UPH1500	QUICK COUPLING PLUG	1
13	UPH4921	FEMALE DISCONNECT COUPLING	1
14	UPH1499	REDUCER	1
15	UPH1498	ELBOW FITTING	1
16	WET0071	ROLLER	1

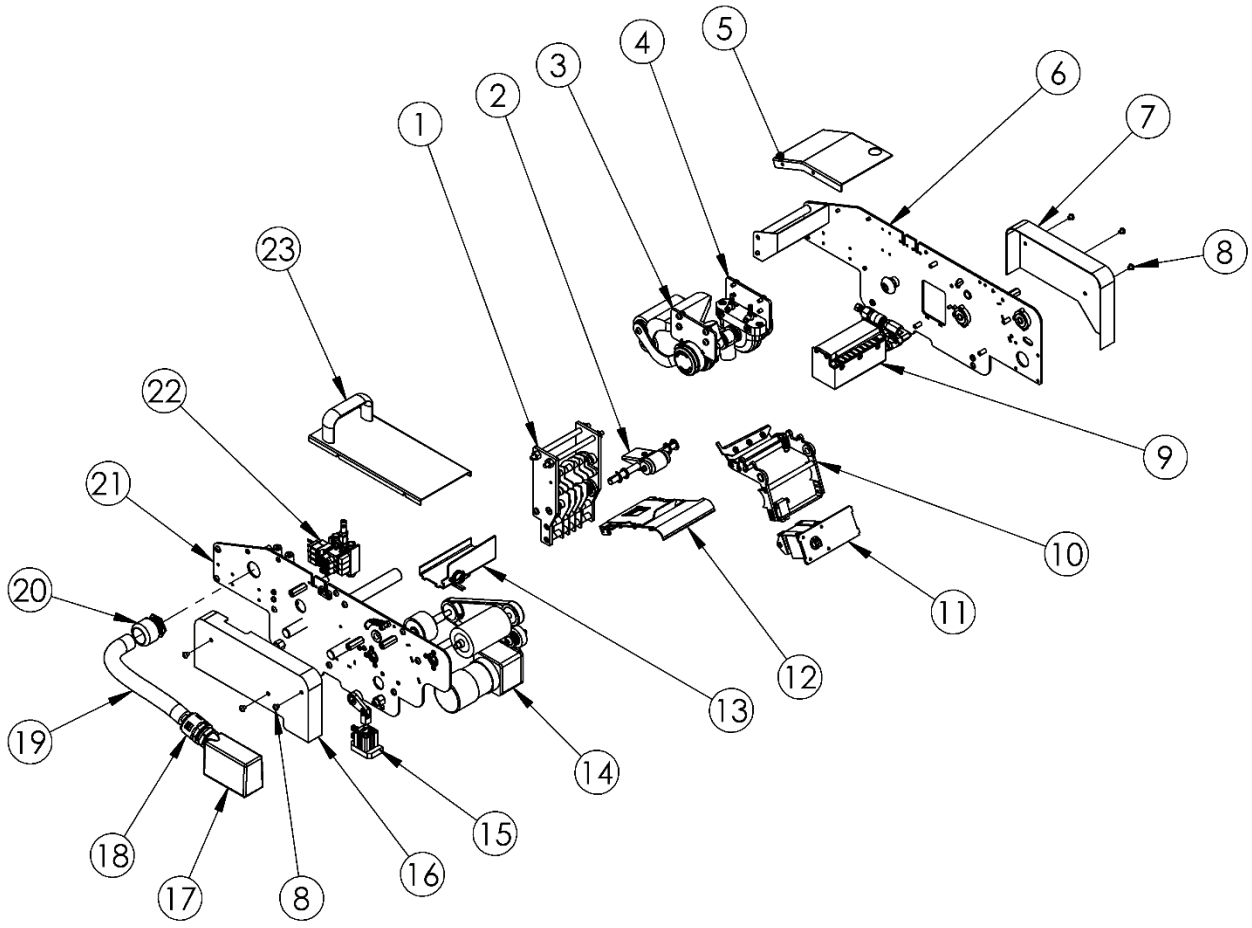
9.14.13 WST1029 – FRONT WIPE DOWN ARM ASSEMBLY



WST1029 – FRONT WIPE DOWN ARM ASSEMBLY

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	WET0203	SHAFT, dia 10	1
2	WET0201	ROLLER CORE	2
3	WET0202	COLLAR	2
4	UF6325	M6-1 x 20 BHCS	4
5	WET0158	FRONT WIPE ARM	1
6	UF3804	SS SSS M3-0.5 x 12mm	2
7	UPH4905	M5 x 4mm ELBOW FITTING	2
8	UPH4917	ROTARY AIR CYLINDER	1
9	WET0144	WIPE ARM ROLLER	1

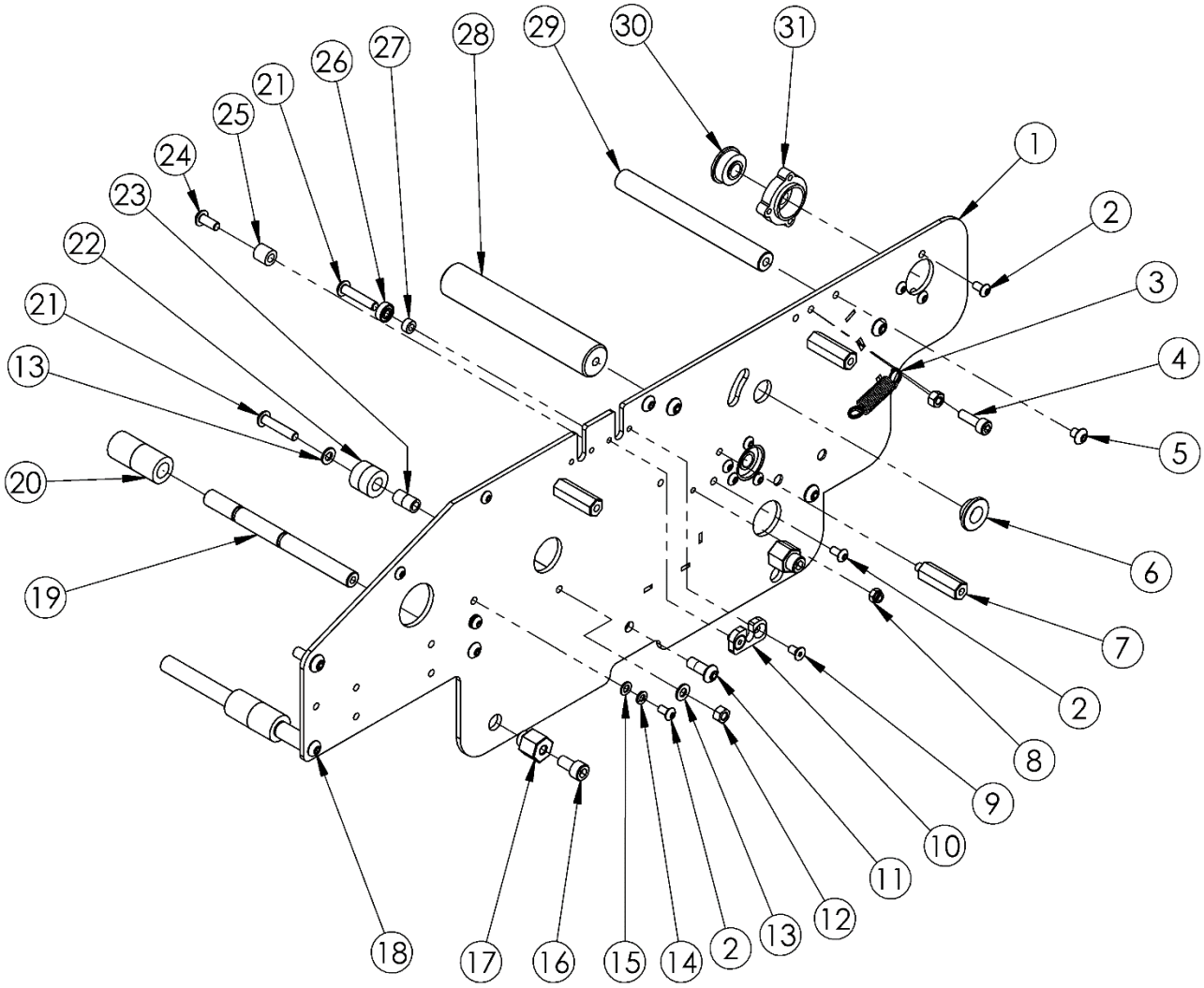
9.15 *WST1047 – TOP TAPE HEAD*



WST1047 – TOP TAPE HEAD

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	WST1039	TAPE SHOE ASS'Y	1
2	WST0059	PINCH ROLLER ASS'Y	1
3	WST1045	FRONT TUCKING ARM ASS'Y	1
4	WST1044	REAR TUCKING ARM ASS'Y	1
5	WET0221	TOP COVER	1
6	WST1038	RIGHT FRAME ASS'Y	1
7	WET0213	COVER BELT	1
8	UF3276	SS BHCS M5-0.8 x 6	6
9	WST1046	WATER POT ASS'Y	1
10	WST0060	TOP KNIFE ARM ASS'Y	1
11	WST0057	SOLENOID ASS'Y	1
12	WST1040	TOP TAPE GUIDE ASS'Y	1
13	WST1023	HEATER PLATE ASS'Y	1
14	WST1043	DRIVETRAIN ASS'Y	1
15	WST1025 TOP HEAD	PINCH ROLLER CYLINDER ASS'Y	1
16	WET0212	COVER LEFT SIDE	1
17	UPM4939	ELECTRICAL RECEPTACLE CONNECTION MALE	1
18	UPM4905	CORD GRIP	1
19	UPM6231	CORD	1
20	WET0241	CORD GRIP	1
21	WST1037	LEFT FRAME ASS'Y	1
22	WST1042	PNEUMATIC ASS'Y	1
23	WST1035	COVER WITH HANDLE	1

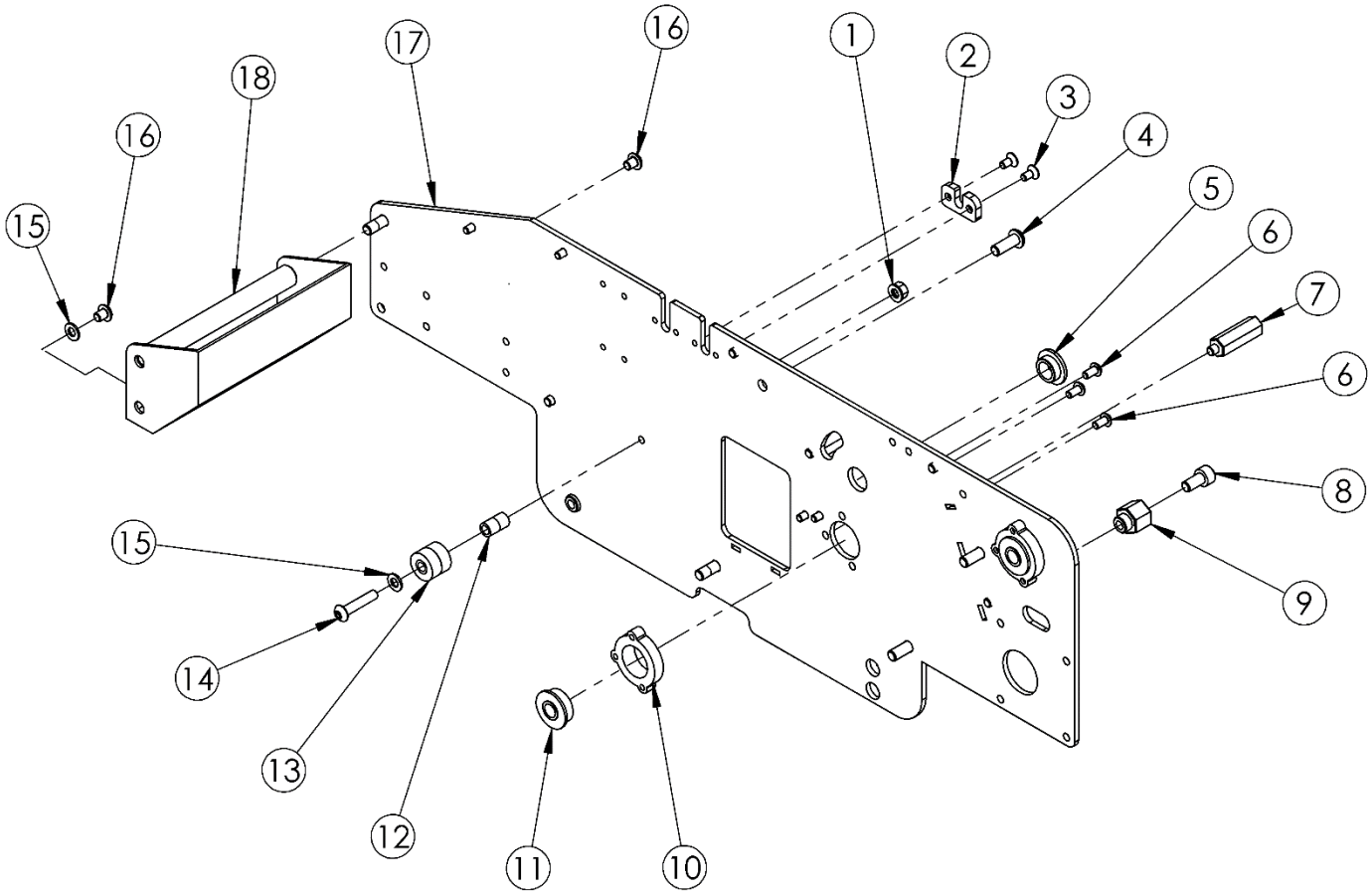
9.15.1 WST1037 – LEFT FRAME ASSEMBLY



WST1037 – LEFT FRAME ASSEMBLY

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	WET0214	LEFT FRAME PLATE	1
2	UF7009	SS BHCS M4-0.7 x 8	12
3	WET0164	EXTENSION SPRING	1
4	UF3169	SS SHCS M5-0.8 x 16mm	1
5	UF3276	SS BHCS M5-0.8 x 6	2
6	WPT0004	OILITE FLANGE BEARING 10mm	1
7	WET0216	ADAPTOR, 30L	3
8	UF4324	SS NYLON LOCKNUT M4	1
9	UF3274	SS FHCS M4-0.7 x 8 mm	2
10	WET0182	TAPE SHOE LOCATOR	1
11	UF1250	BHCS M6-1 x 16	4
12	UF7007	SS HEX NUT M5-0.8	2
13	UF6340	SS FW M5	2
14	UF3749	SS LW M4	2
15	UF6339	SS FW M4	2
16	UF3183	SS SHCS M6-1 x 12mm	2
17	WET0215	ADAPTOR, 12L	2
18	UF7035	SS BHCS M5-0.8 X 16mm	1
19	WET0217	SHAFT, dia 9.5, 115L	2
20	WET0218	SPACER, 18L	4
21	UF3279	SS BHCS M5-0.8 X 25mm	2
22	UPH4613	KNIFE ARM BUMPER 6"TH	2
23	WET0161	SLEEVE TUBE	2
24	UF3687	BHCS M5-0.8 X 12mm	2
25	UPH0589	REAR SWL BLOCK HOLLOW SHAFT HI	1
26	UPH1501	BALL BEARING 11 x 4 x 4	1
27	UPH1502	SPACER, dia 7.5, 4L	1
28	WET0219	SPACER ROD, dia 20, 115L	1
29	WET0163	SHAFT, dia 12, 115L	3
30	WPT0109	FLANGE BALL BEARING 8 x 19 x 6	2
31	WET0132	WE BEARING HOUSING	2
32	UF6414	SS BHCS M6-1 x 16mm	1

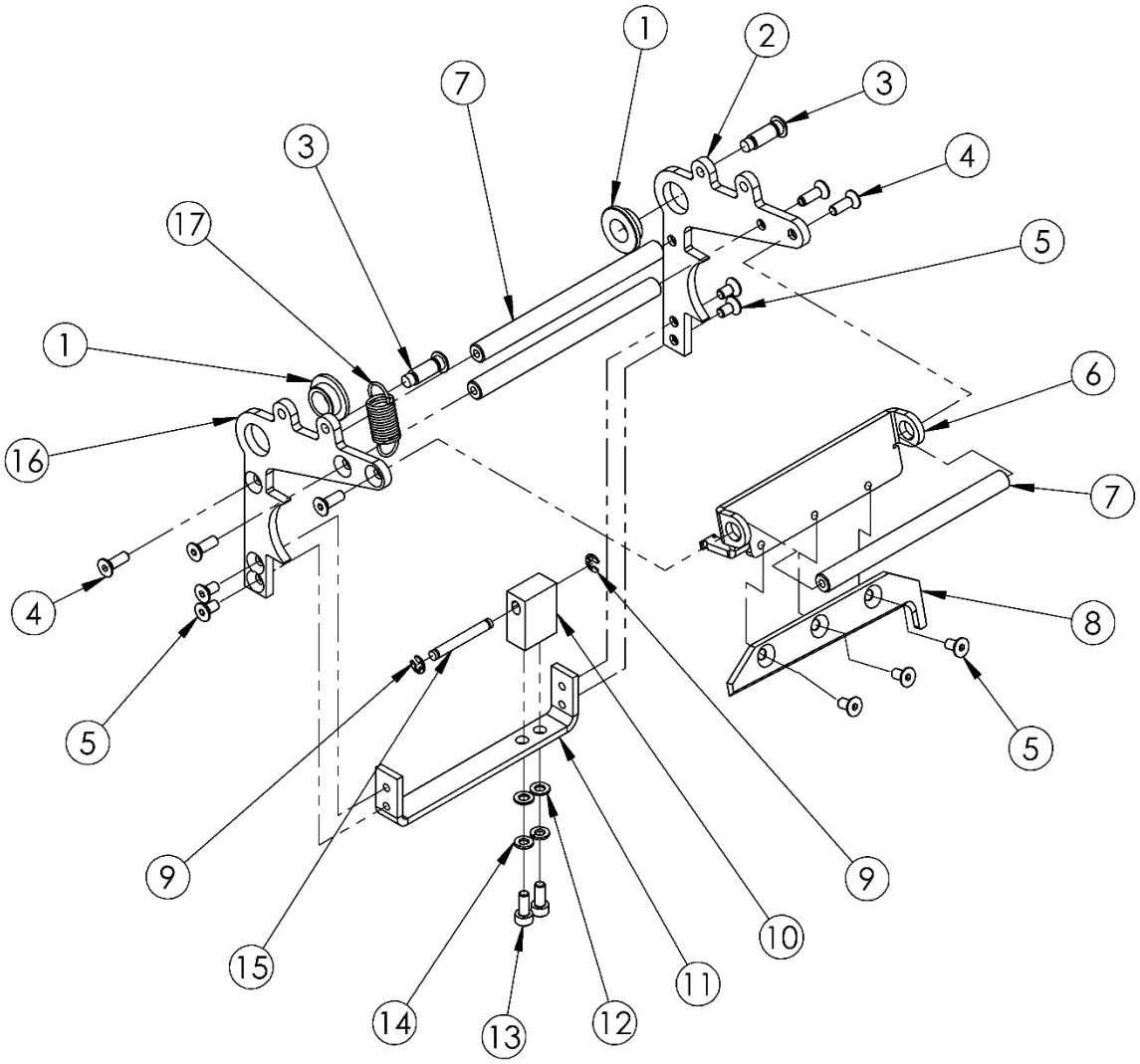
9.15.2 WST1038 – RIGHT FRAME ASSEMBLY



WST1038 – RIGTH FRAME ASSEMBLY

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	UF7007	SS HEX NUT M5-0.8	1
2	WET0182	TAPE SHOE LOCATOR	1
3	UF3274	SS FHCS M4-0.7 x 8 mm	2
4	UF1250	BHCS M6-1 x 16	5
5	WPT0004	OILITE FLANGE BEARING 10mm	1
6	UF7009	SS BHCS M4-0.7 x 8	10
7	WET0216	ADAPTOR, 30L	3
8	UF3183	SS SHCS M6-1 x 12mm	2
9	WET0215	ADAPTOR, 12L	2
10	WET0132	WE BEARING HOUSING	2
11	WPT0109	FLANGE BALL BEARING 8 x 19 x 6	2
12	WET0161	SLEEVE TUBE	2
13	UPH4613	KNIFE ARM BUMPER 6"TH	2
14	UF3279	SS BHCS M5-0.8 X 25mm	1
15	UF6340	SS FW M5	4
16	UF3276	SS BHCS M5-0.8 x 6	6
17	WET0220	RIGHT FRAME PLATE	1
18	WET0222	COVER	1

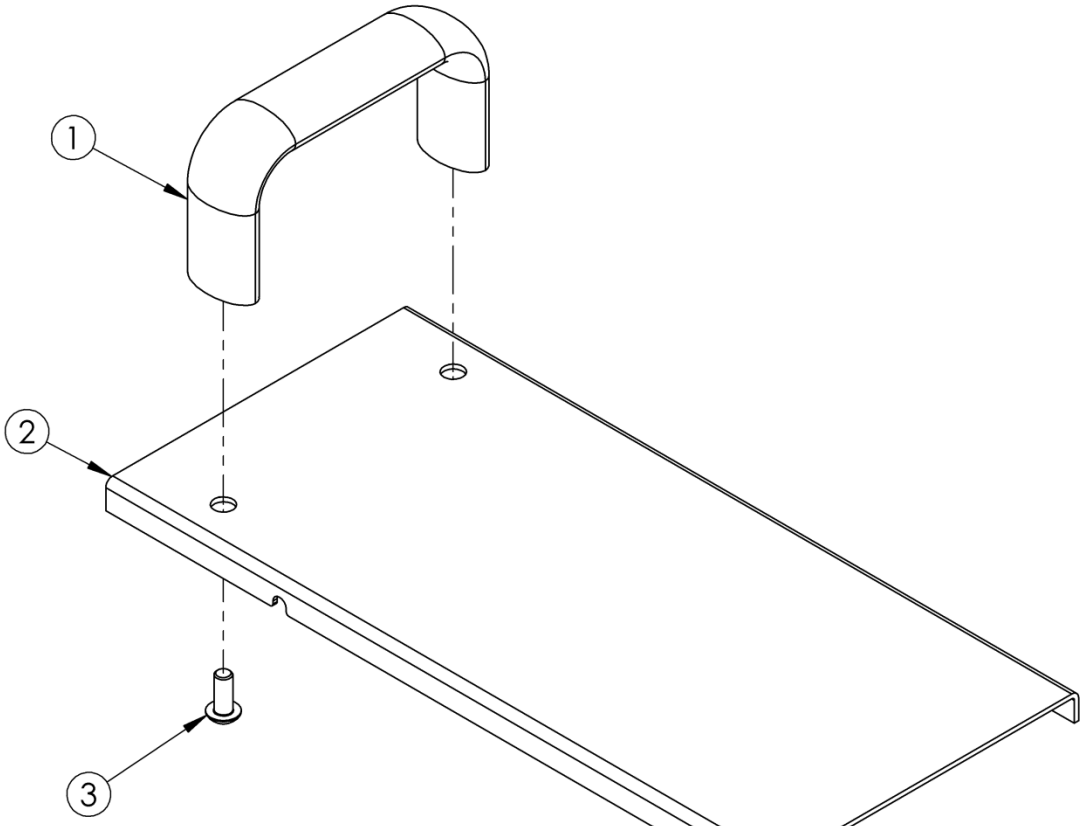
9.15.3 WST0060 – TOP KNIFE ARM ASSEMBLY



WST0060 – TOP KNIFE ARM ASSEMBLY

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	WPT0004	OILITE FLANGE BEARING 10mm	2
2	WPT0075	KNIFE ARM RIGHT FRAME	1
3	UF2215	SHOULDER SCREW M5 x 15L SHOULDER	2
4	UF3761	SS FHCS M4-0.7 x 12mm	6
5	UF3274	SS FHCS M4-0.7 x 8 mm	7
6	WPT0049	WT Cutter Blade Support	1
7	WPT0048	WT KNIFE ARM PIVOT SHAFT	3
8	WPT0050	CUTTER BLADE	1
9	UF3553	SS E RET RING EXTERNAL 4mm	2
10	WPT0078	KNIFE ARM BLOCK	1
11	WPT0104	WT KNIFE ARM SUPPORT	1
12	UF6339	SS FW M4	2
13	UF3759	SS SHCS M4-0.7 x 10mm	2
14	UF3749	SS LW M4	2
15	WPT0079	KNIFE ARM BLOCK SHAFT	1
16	WPT0076	KNIFE ARM LEFT FRAME	1
17	WPT0053	EXTENSION SPRING 14.75 COILS	1

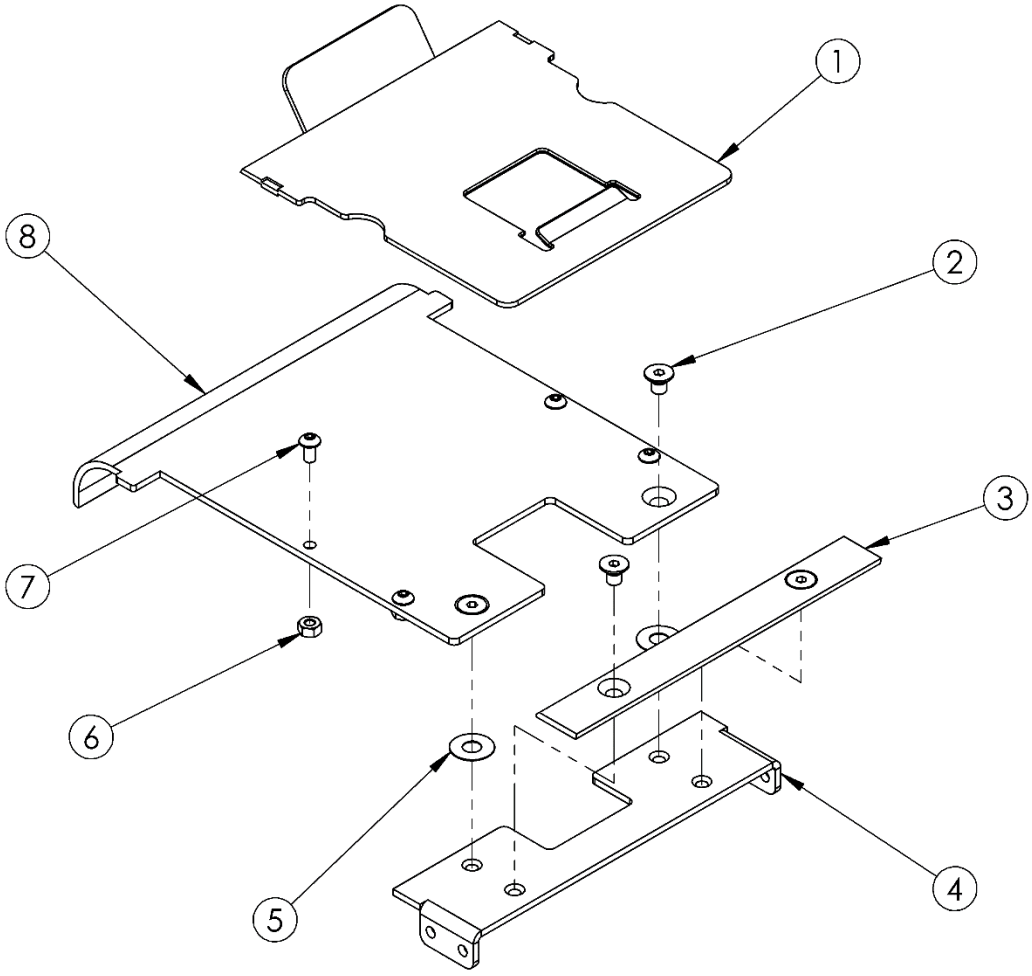
9.15.4 WST1035 – COVER WITH HANDLE



WST1035 - COVER WITH HANDLE

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	WET0234	HANDLE	1
2	WET0233	COVER PLATE	1
3	UF7011	SS BHCS M5-0.8 X 12mm	2

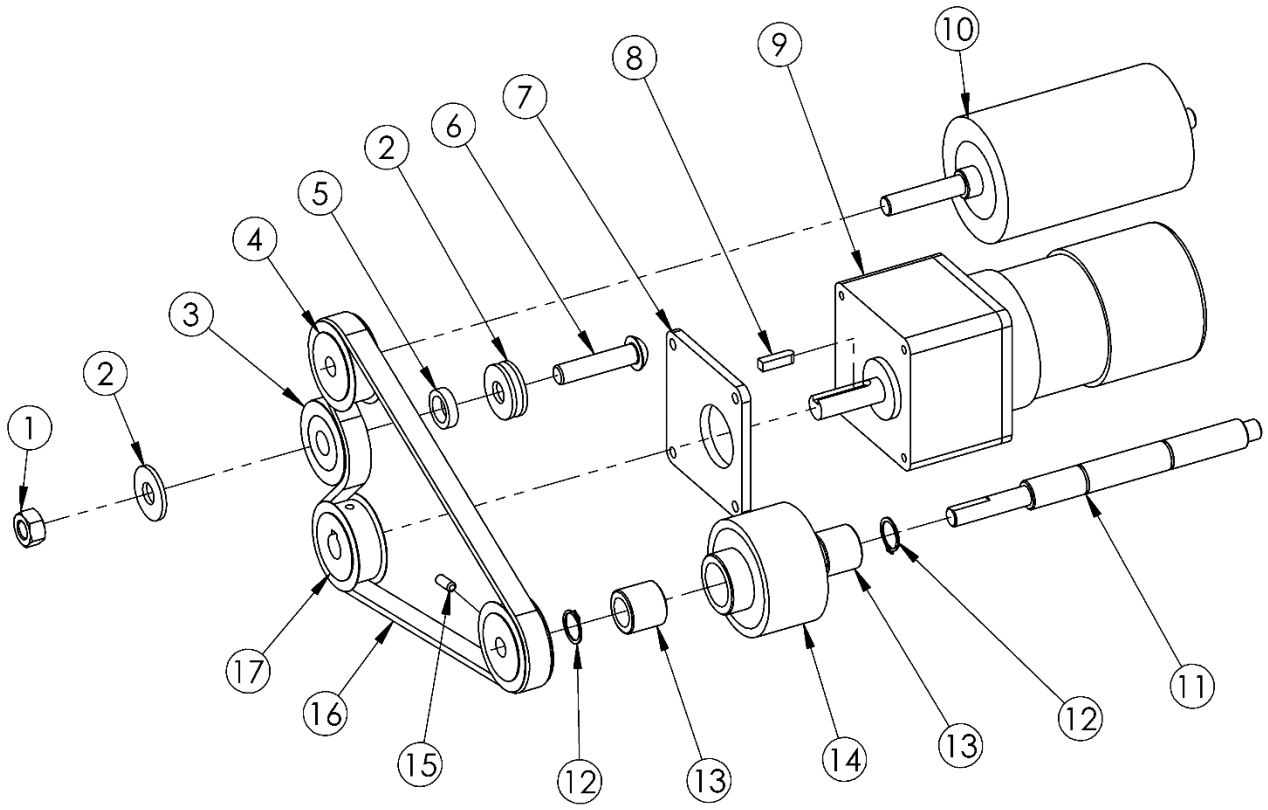
9.15.5 WST1040 – TOP TAPE GUIDE



WST1040 – TOP TAPE GUIDE

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	WET0190	Upper Guide Plate	1
2	UF6351	SS FHCS M4-0.7 x 6 mm	4
3	WPT0044	STRIKER PLATE	1
4	WET0156	TAPE GUIDE SUPPORT	1
5	UF7030	BRASS WASHER 5.18x12x.28mm THK	2
6	UF3717	SS HEX NUT M3-0.5	4
7	UF4518	SS BHCS M3 - 0.5 x 6	4
8	WET0237	TAPE GUIDE PLATE	1

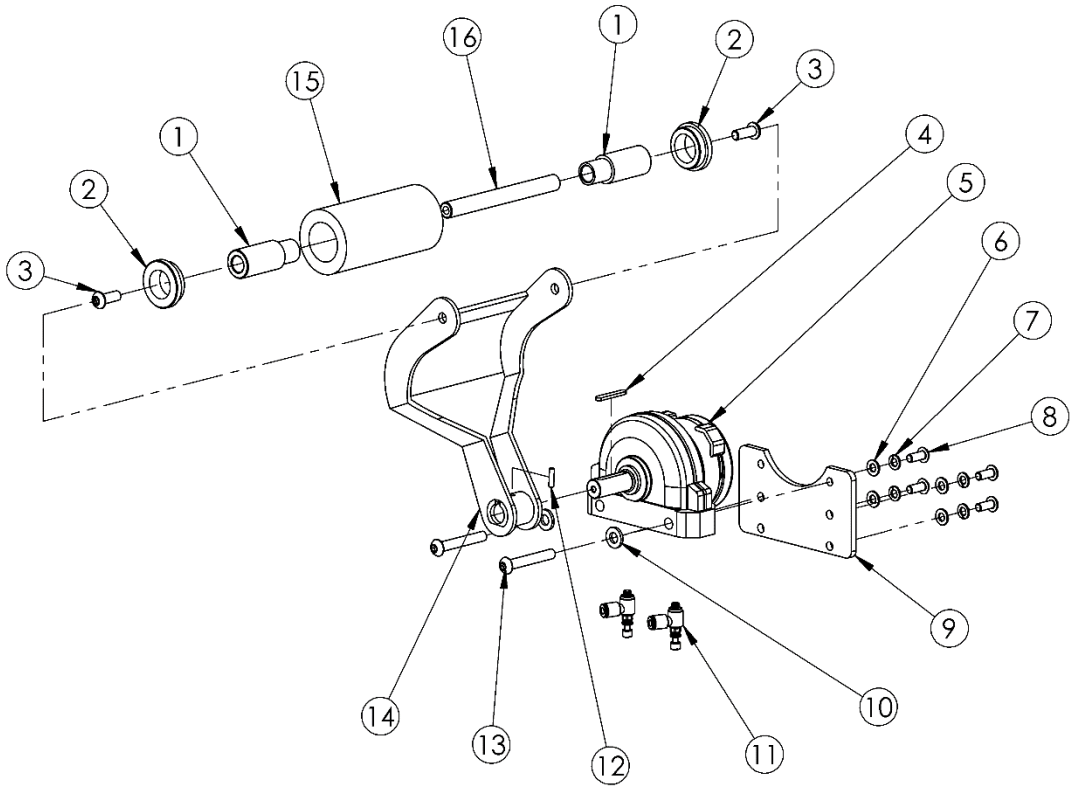
9.15.6 WST1043 – DRIVE TRAIN ASSEMBLY



WST1043 – DRIVE TRAIN ASSEMBLY

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	UF3735	SS HNR M8-1.25	1
2	UF3643	SS FW M8	3
3	UPH4919	BALL BEARING, 10ID, 35OD, 11t	1
4	WET0193	SPROCKET GEAR	2
5	WET0229	SPACER, dia 16, 4L	1
6	UF4316	BHCS M8-1.25 x 35mm	1
7	WET0230	MOTOR PLATE	1
8	UF2213	SQUARE KEY, ONE ROUND END	1
9	WET0183	MOTOR, 2GH 20K	1
10	WET0195	DRIVE ROLLER TAPE ASSIST	1
11	WET0196	SHAFT, 140L	1
12	UF7017	SS RET'G RING EXTERNAL 12mm	2
13	WET0198	ONE WAY CLUTCH BEARING	2
14	WET0197	GUIDE ROLLER	1
15	SHSS M4-0.7 x 10	SHSS M4-0.7 x 12	6
16	WET0238	DRIVE BELT	1
17	WET0192	SPROCKET GEAR WITH KEY	1

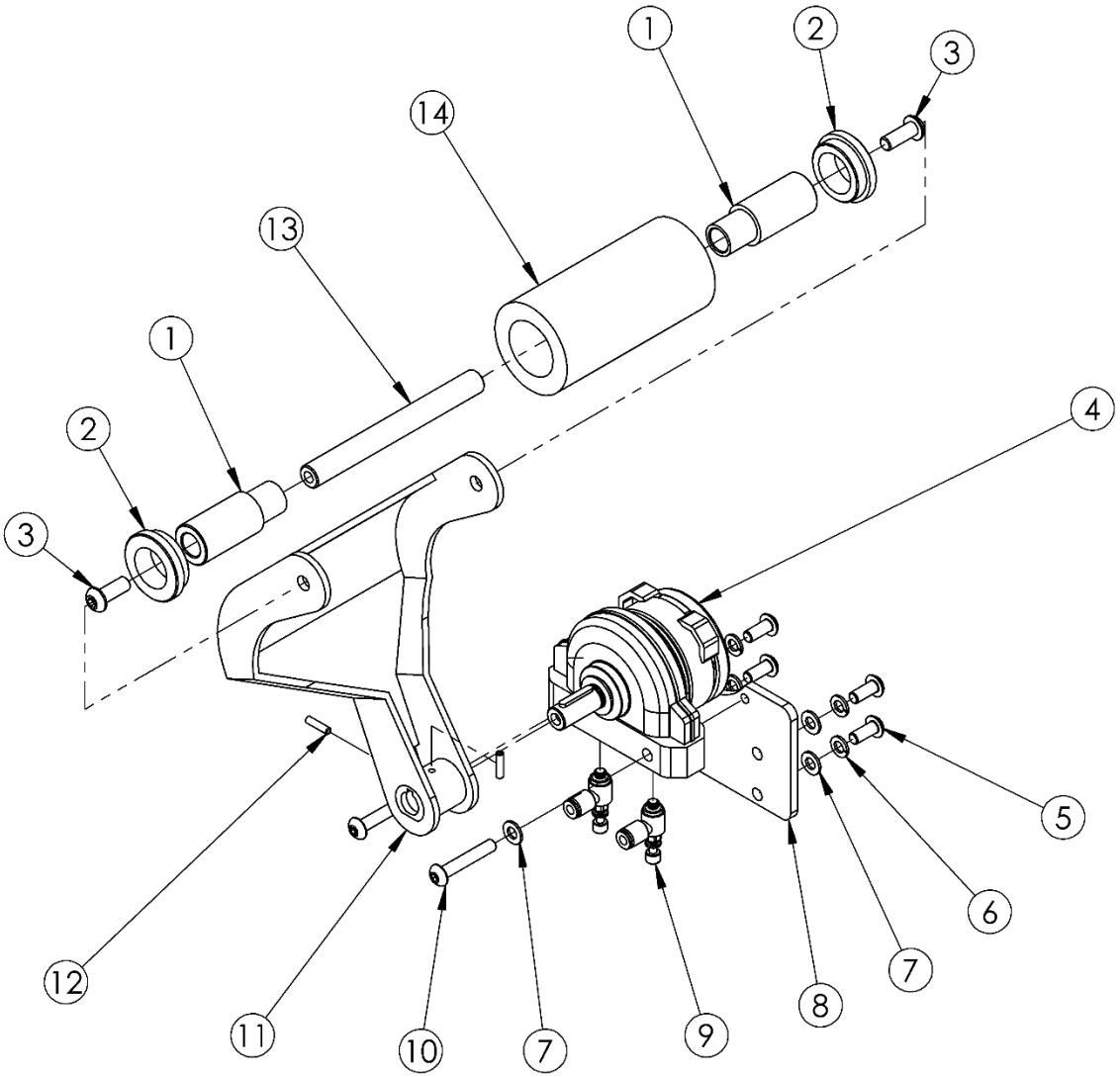
9.15.7 WST1044 – REAR TUCKING ARM ASSEMBLY



WST1044 – REAR TUCKING ARM ASSEMBLY

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	WET0201	ROLLER CORE	2
2	WET0202	COLLAR	2
3	UF1250	BHCS M6-1 x 16	2
4	UF2214	ROUND KEY	1
5	UPH4849	ROTORY AIR CYLINDER	1
6	UF6340	SS FW M5	4
7	UF7021	SS LW M5	4
8	UF7011	SS BHCS M5-0.8 X 12mm	4
9	WET0231	BRACKET	1
10	UF6341	SS FW M6	2
11	UPH4904	M5 x 4mm OD, FLOW CONTROL	2
12	UF3804	SS SSS M3-0.5 x 12mm	2
13	UF4503	SS BHCS M6-1 x 40mm	2
14	WET0239	REAR WIPE DOWN ARM	1
15	WET0005	WIPE ARM ROLLER REAR	1
16	WET0203	SHAFT, dia 10	1

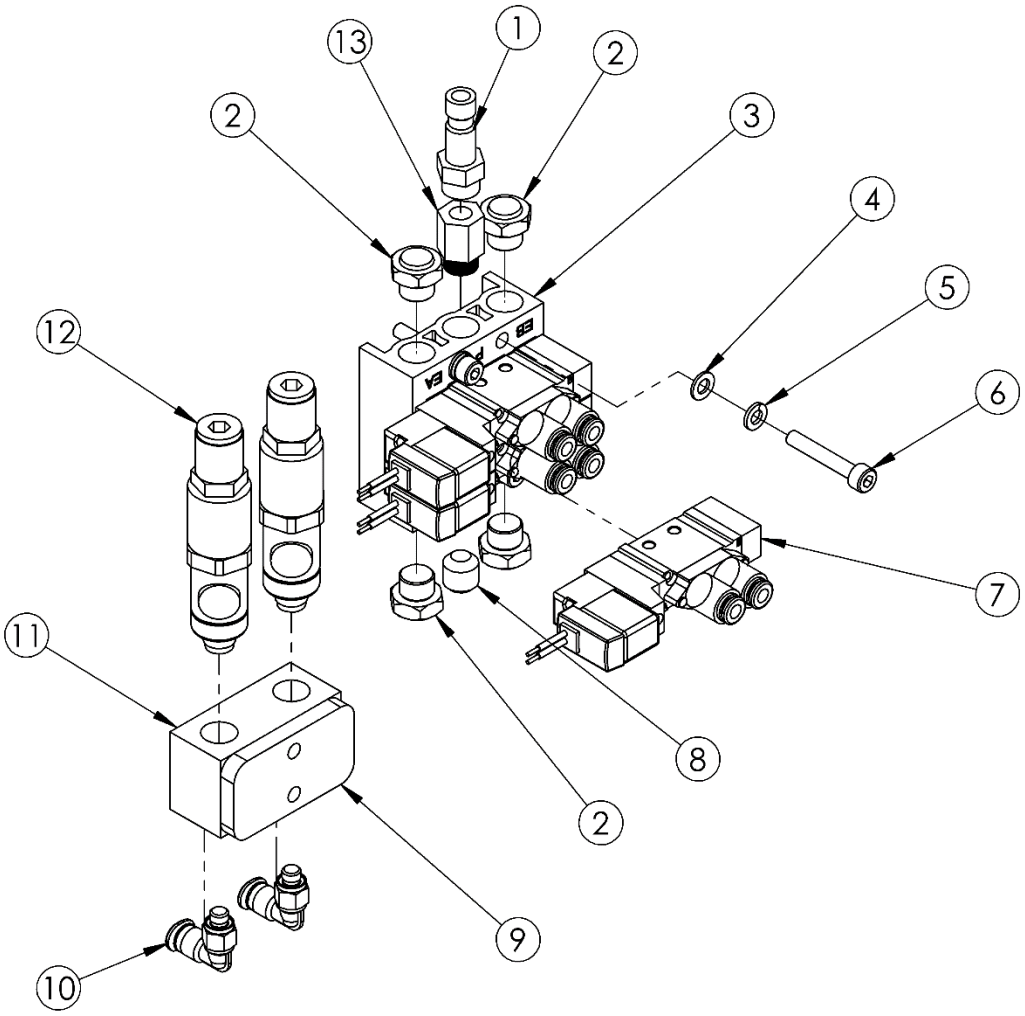
9.15.8 WST1045 – FRONT TUCKING ARM ASSEMBLY



WST1045 – FRONT TUCKING ARM ASSEMBLY

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	WET0201	ROLLER CORE	2
2	WET0202	COLLAR	2
3	UF1250	BHCS M6-1 x 16	2
4	UPH4917	ROTARY AIR CYLINDER	1
5	UF7011	SS BHCS M5-0.8 X 12mm	4
6	UF7021	SS LW M5	4
7	UF6340	SS FW M5	6
8	WET0232	BRACKET	1
9	UPH4904	M5 x 4mm OD, FLOW CONTROL	2
10	UF3094	M5-0.8 x 30 BHCS	2
11	WET0240	FRONT WIPE ARM	1
12	UF3804	SS SSS M3-0.5 x 12mm	2
13	WET0203	SHAFT, dia 10	1
14	WET0144	WIPE ARM ROLLER	1

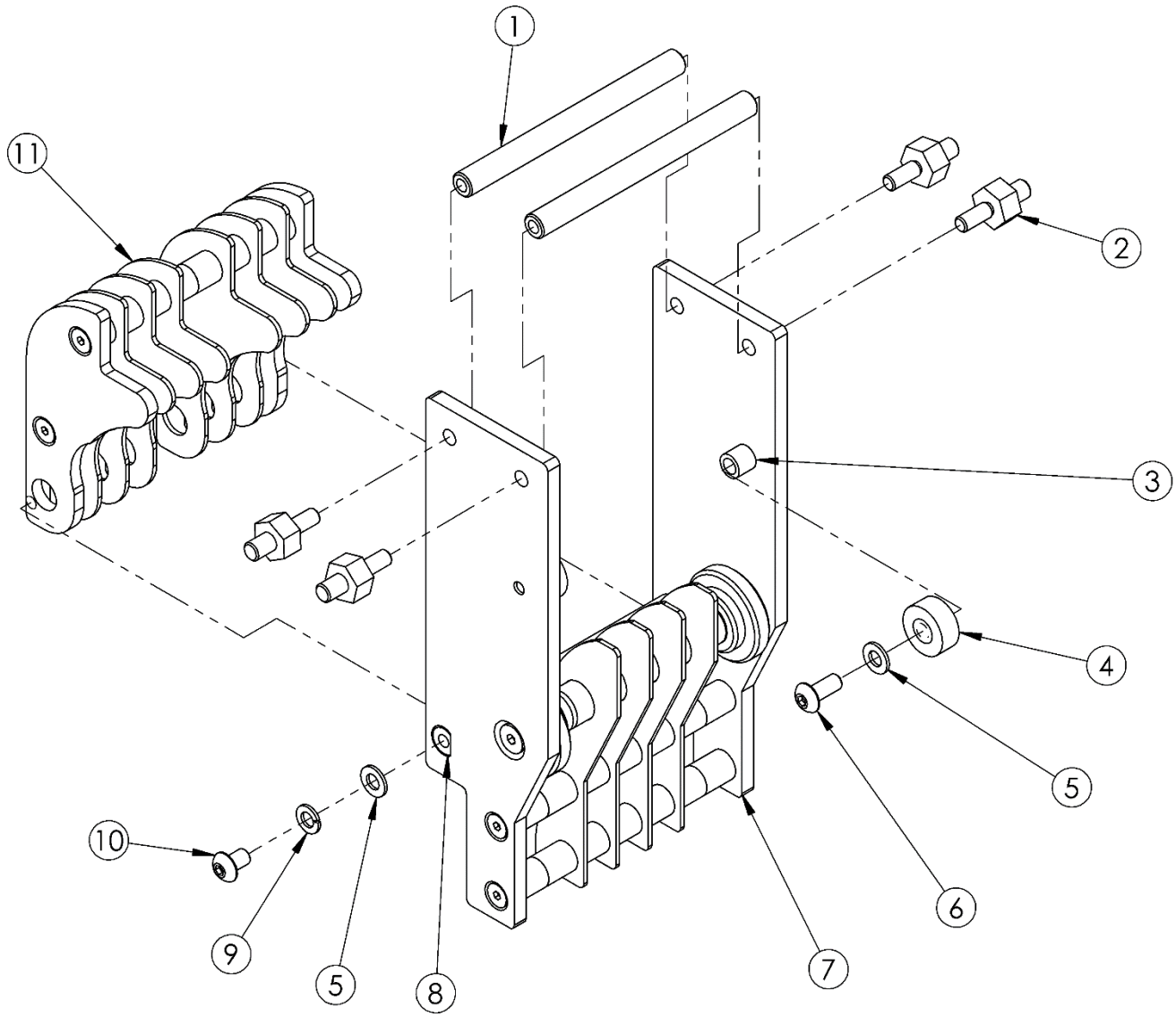
9.15.9 WST1042 – PNEUMATIC ASSEMBLY



WST1042 – PNEUMATIC ASSEMBLY

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	UPH1504	COUPLING PLUG	1
2	UPH4903	FLAT MUFFLER G1/8	4
3	WET0208	MANIFOLD	1
4	UF3710	FW M4	4
5	UF3749	SS LW M4	4
6	UF4308	SHCS M4-0.7 x 25mm	4
7	WET0209	VALVE	3
8	UPM8001	PLUG, G/18	3
9	WET0228	PLATE	1
10	UPH4905	M5 x 4mm ELBOW FITTING	2
11	WET0210	MANIFOLD	1
12	WET0211	PRESSURE REGULATOR	2
13	UPH1496	REDUCER	1

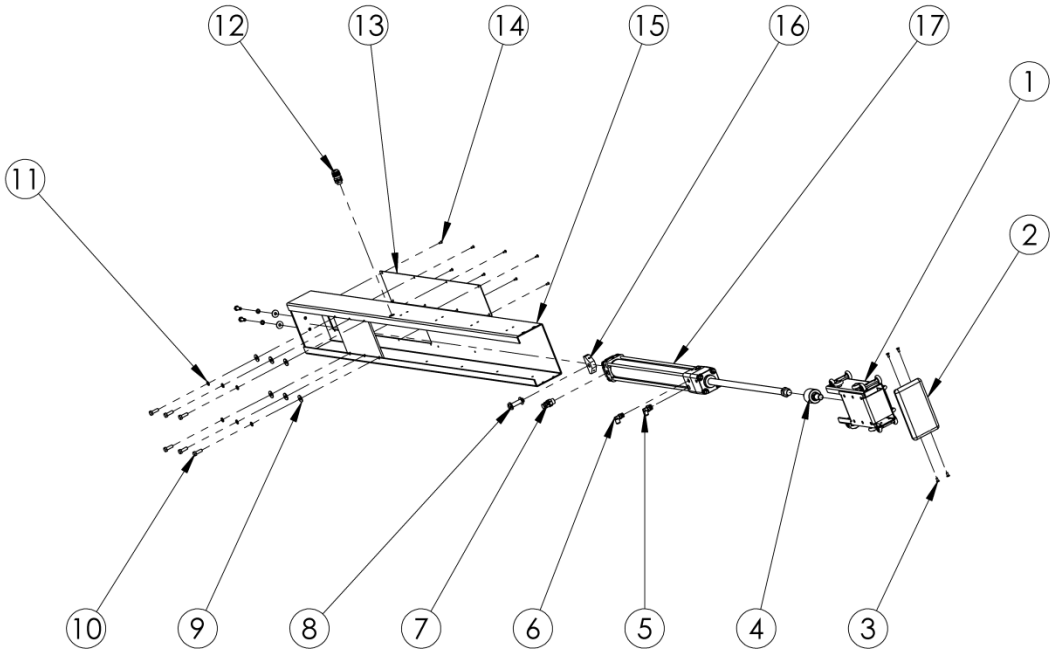
9.15.10 WST1039 – TAPE SHOE ASSEMBLY



WST1039 – TAPE SHOE ASSEMBLY

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	WET0225	SHAFT, 90L	2
2	WET0191	HEX ADAPTER	4
3	WET0161	SLEEVE TUBE	2
4	UPH4613	KNIFE ARM BUMPER 6"TH	2
5	UF6340	SS FW M5	4
6	UF7011	SS BHCS M5-0.8 X 12mm	2
7	WST1050	MAIN ASS'Y	1
8	WET0177	SHAFT, dia 10, 100L	1
9	UF7021	SS LW M5	2
10	UF4319	BHCS M5-0.8 x 8mm	2
11	WST1051	HINGE ASS'Y	1

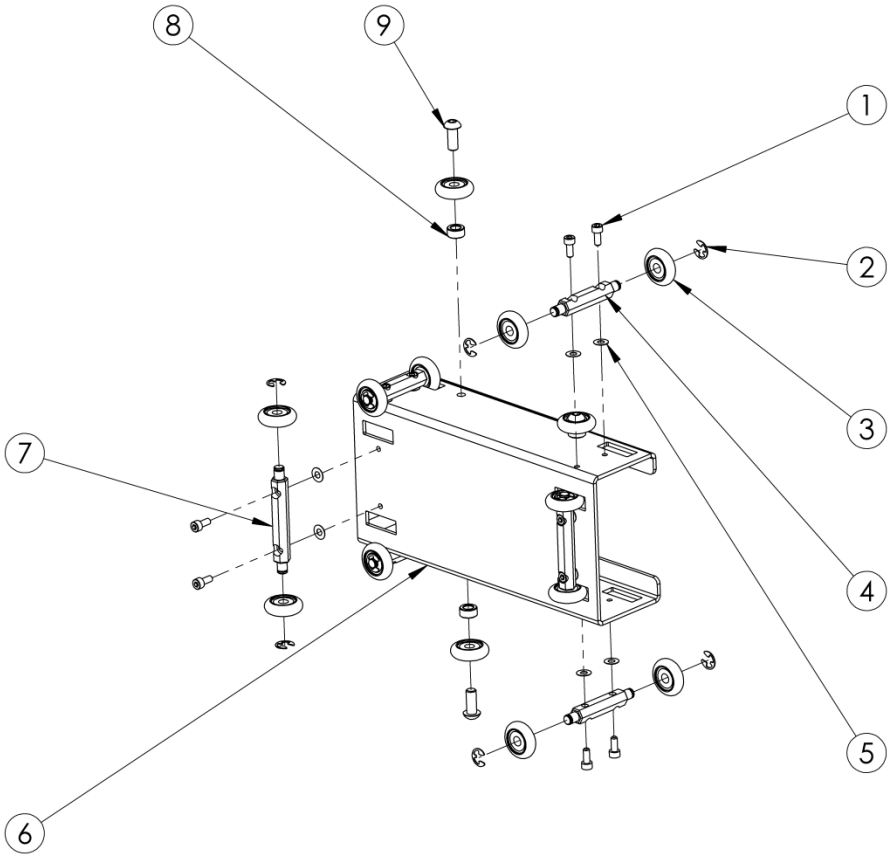
9.16 UAM0536 – COLUMN ASSEMBLY



UAM0536 – COLUMN ASSEMBLY

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	UAM0529	COLUMN BRIDGE MOUNT CART ASSEMBLY	1
2	UPM4960	COLUMN CAP	1
3	UF5400	FHCS M5-0.8X12	4
4	UPM6216	FLEXIBLE COUPLING M18	1
5	UPM6343	AIR CYLINDER PNEUMATIC COUPLER, SMC	1
6	UPM6344	AIR CYLINDER PNEUMATIC COUPLER, SMC	1
7	UPM6345	AIR CYLINDER PNEUMATIC COUPLER, SMC	1
8	UPM6342	AIR CYLINDER PIN	1
9	UF3643	M8 FW	8
10	UF6310	HHCS M8-1.25X25	8
11	UF0867	M8 LW	8
12	UPM5873	CABLE GLANDS	1
13	UPM6341	COLUMN ACCESS PANEL	1
14	UF3685	BHCS M4-0.7X8	8
15	UAM0486	COLUMN WELDMENT	1
16	UPM6214	VERTICAL LINK	1
17	UPM6217	AIR CYLINDER	1

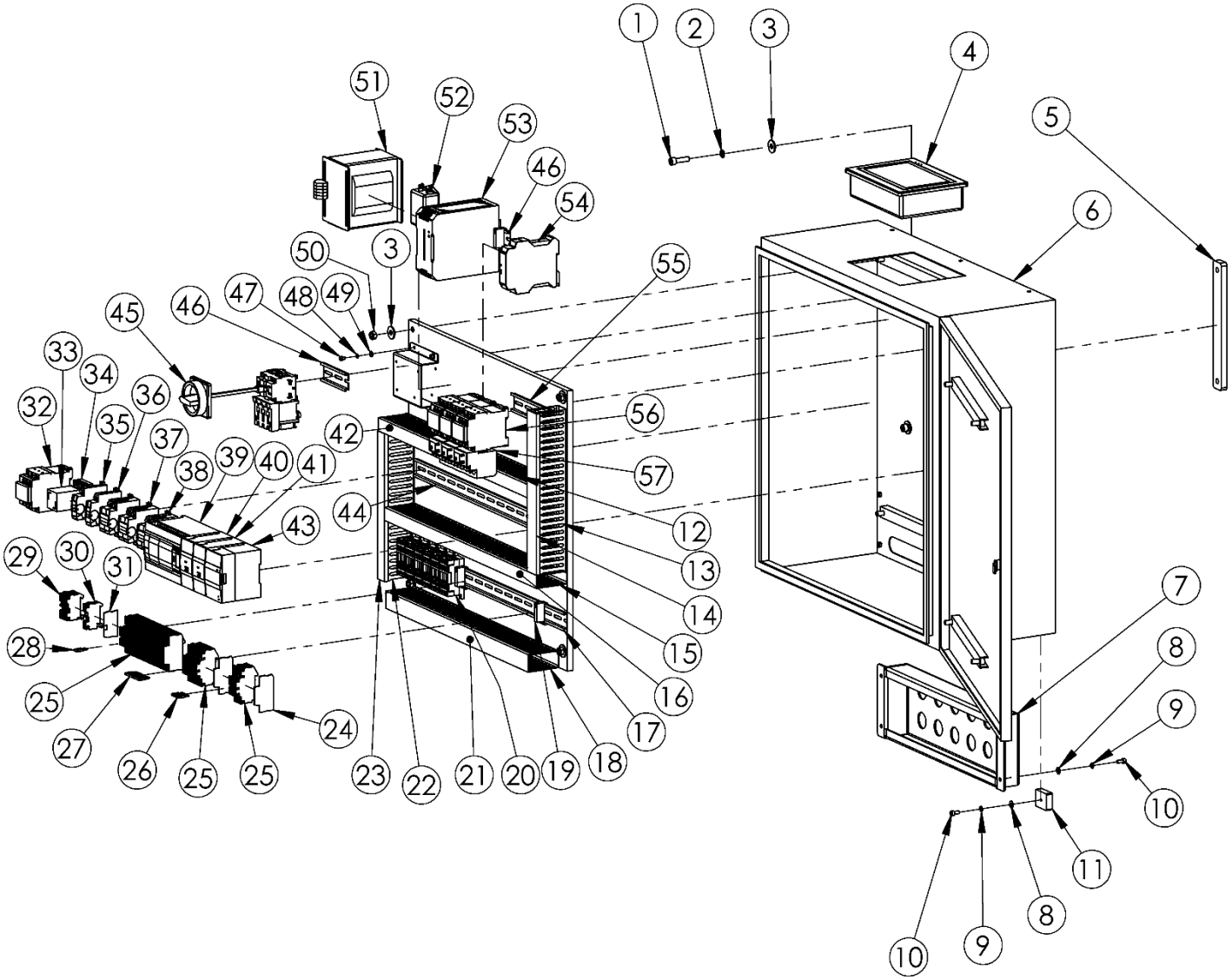
9.16.1 UAM0529 – COLUMN BRIDGE MOUNT CART ASSEMBLY



UAM0529 – COLUMN BRIDGE MOUNT CART ASSEMBLY

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	UF9154	SHCS M5-0.8 X 12	12
2	UF6302	RETAINING RING 6MM SHAFT	12
3	UPM5801	ROLLER WHEEL	16
4	UPM6351	COLUMN CART ROLLER HUB	4
5	UF5927	M5 CW	12
6	UPM6353	COLUMN BRIDGE MOUNT CART WELDMENT	1
7	UPM6352	COLUMN CART ROLLER HUB	2
8	UPM6357	SPACER	4
9	UF0036	BHCS M8-1.25X20	4

9.17 UAM0503 – ELECTRICAL BOX



UAM0503 – ELECTRICAL BOX

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	UF0099	SHCS M8-1.25×30L	4
2	UF3640	LW M8	4
3	UF0113	M8 FW	8
4	UPM6177	HMI, SCREEN	1
5	UPM6174	ELEC. CAB. MOUNT BAR	2
6	UPM6173	ELECTRICAL CABNET	1
7	UPM6175	ELEC. CAB. COVER	1
8	UF1827	M5 FW	5
9	UF7021	LW M5	5
10	UF7003	SHCS M5-0.8 x 12mm	5
11	UPM6176	ELEC. CAB. GROUND BLOCK	1
12	UPM6242	WIRE WAY 33mm, 545L	1
13	UPM6239	WIRE WAY 33mm, 305L	1
14	UPM6244	COVER 33mm, 305L	1
15	UPM6243	WIRE WAY 33mm, 555L	1
16	UPM6248	COVER 33mm, 555L	1
17	UPM6250	RAIL, 555L	1
18	UPM6240	WIRE WAY 33mm, 520L	1
19	UPM7440EV	DIN RAIL ANCHOR	4
20	UPM4922	RELAY	6
21	UPM6245	COVER 33mm, 520L	1
22	UPM6241	WIRE WAY 33mm, 280L	1
23	UPM6246	COVER 33mm, 280L	1
24	UPM6195	END COVER	5
25	UPM6193	DOUBLE LEVEL TERMINAL BLOCK, 1	45
26	UPM6198	5 PIN BRIDGE	2
27	UPM6199	10 PIN BRIDGE	2
28	UPM6197	2 PIN BRIDGE	2
29	UPM6194	TERMINAL BLOCK, GROUND, 1	5
30	UPM6193	TERMINAL BLOCK, 1	2
31	UPM6196	END COVER	1
32	UPM6188	ELECTROMAGNETIC CONTACTOR (DC24V)	1
33	UPM6190	AC120 RELAY, MECHANICAL INDICATOR	1
34	UPM6191	RELAY SOCKET, DIN RAIL, 8 PIN	1
35	UPM6179	LOOP PROTECTOR, 7A	1
36	UPM6180	LOOP PROTECTOR, 3A	1
37	UPM6182	LOOP PROTECTOR, 3A, 2100	1
38	UPM6181	LOOP PROTECTOR, 2A, 2100	2
39	UPM4909	PLC 24 INPUT / 16 OUTPUT	1
40	UPM6183	PLC EXPANSION MODULE	1
41	UPM6184	PLC EXPANSION MODULE	1
42	UPM6247	COVER 33mm, 545L	1
43	UPM4907	PLC ANALOG I/O CONTROL CARD	1
44	UPM6251	RAIL, 508L	1
45	UPM6178	POWER SWITCH	1
46	UPM6172	RAIL, 90L	2
47	UF4312	SHCS M4-0.7×6L	4

48	UF3749	LW M4	4
49	UF3710	M4 FW	4
50	UF0063	LOCK-NUT	4
51	UPM6185	TRANSFORMER	1
52	UPM6186	FILTER	1
53	UPM4912	POWER SUPPLY 240W	1
54	UPM6187	SAFETY MODULE	1
55	UPM6249	RAIL, 160L	1
56	UPM6189	ELECTROMAGNETIC CONTACTOR (AC110V)	3
57	UPM4914	MOTOR OVERLOAD RELAYS	3

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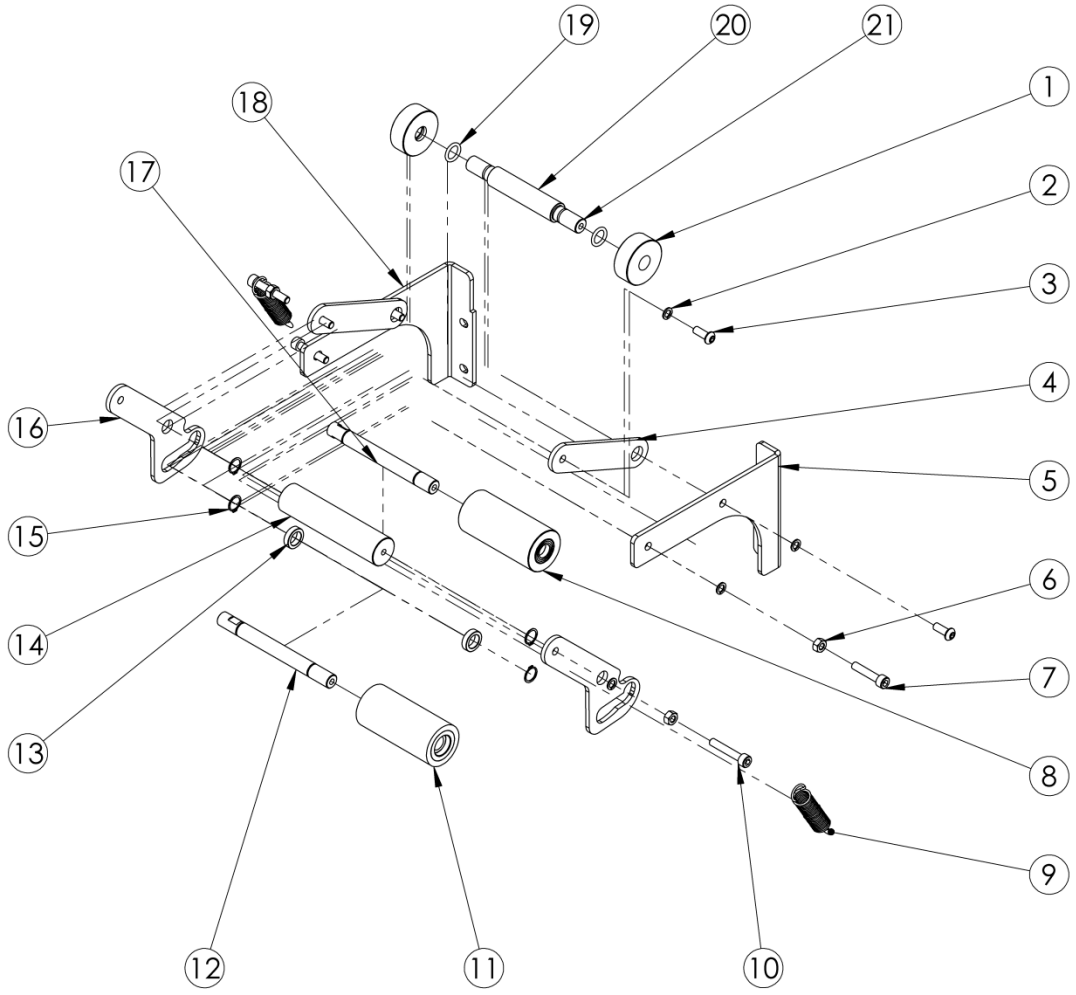
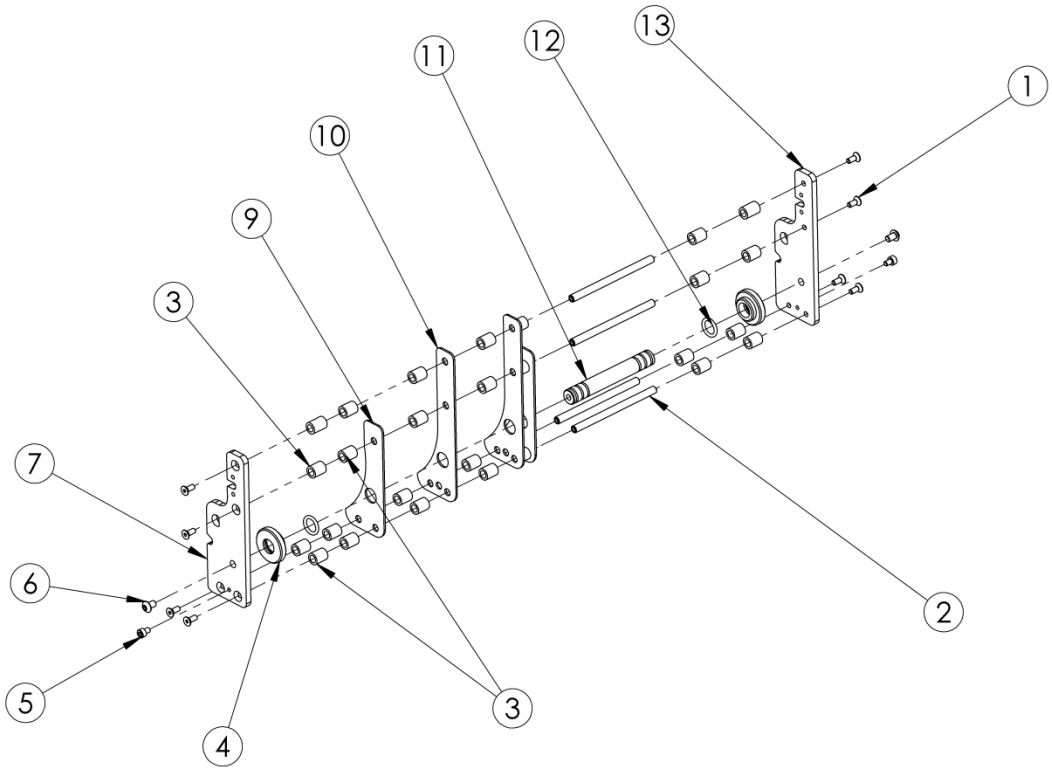
9.18 UAM0025 – CLUTCH MECHANISM



UAM0025 – CLUTCH MECHANISM

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	UPM2485	ADJUSTMENT RING	2
2	UF6363	LW M6	8
3	UF6414	SS BHCS M6-1 x 16mm	4
4	UPM5908	CM PIVOT ARM	2
5	UPM5904	CM RIGHT MOUNT BRACKET	1
6	UF3637	HNR M6-1.0	4
7	UF4236	SHCS M6-1 X 30mm	2
8	UAM0034	PINCH ROLLER ASSEM	1
9	UPM5999	CM SPRING	2
10	UF0850	SHCS BB M6-1 X 35MM	2
11	UAM0033	CLUTCH ROLLER ASSEM	1
12	UPM5906	CM CLUTCH ROLLER SHAFT RSA	1
13	UPM5911	CM CLUTCH SHIELD	2
14	UPM5909	CM CLAMP ARM HANDLE	1
15	UF6300	SS RETAINING RING 12 mm SHAFT	4
16	UPM5910	CM CLAMP ARM	2
17	UPM5907	CM PINCH ROLLER SHAFT	1
18	UPM5905	CM LEFT MOUNT BRACKET	1
19	UPM2492	O RING	2
20	UPM4667	IDLER ROLLER	1
21	UPM5903	CM PIVOT SHAFT RSA	1

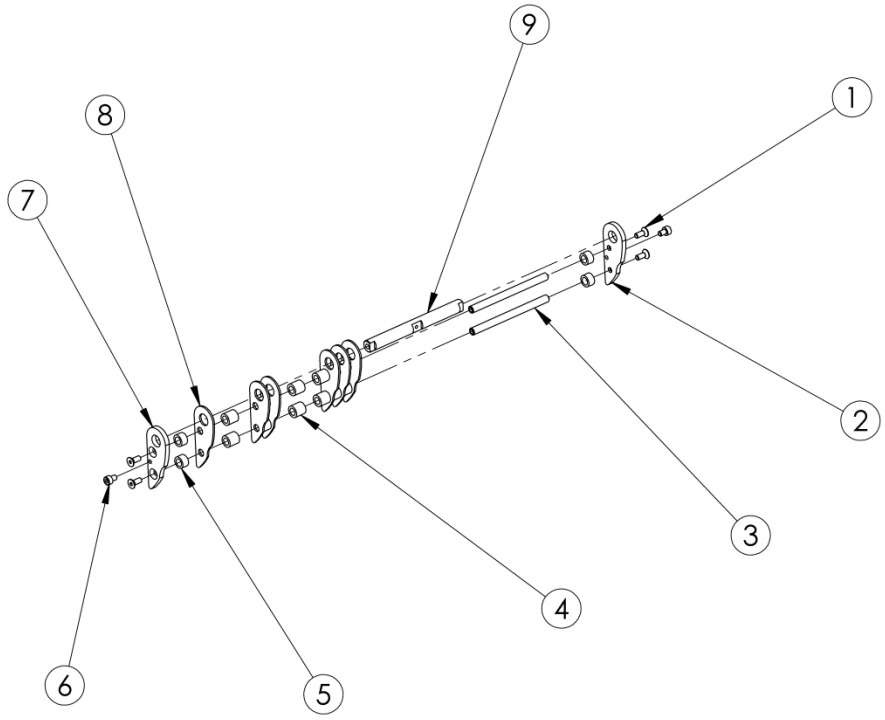
9.19 WST1048 – RSA WAT BOTTOM T.H. MAIN ASSEMBLY



WST1048 – RSA WAT BOTTOM T.H. MAIN ASSEMBLY

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	UF4514	SS M4-0.7 x 10 FHCS	8
2	WEWT0176	SHAFT, dia 6, 90L	4
3	WET0179	SPACER, dia 10, 12L	26
4	WET0175	STOP BEARING	2
5	UF3725	SHCS M4-0.7 x 6mm	2
6	UF7010	SS BHCS M5 - 0.8 x 8 mm	2
7	WET0168	MAIN BRACKET LEFT	1
8	WET0184	SPACER, dia 10, 14L	2
9	WET0171	TEFLON GUIDE B	2
10	WET0170	TEFLON GUIDE C	2
11	WET0166	MAIN SHAFT 90mm	1
12	UPM4936	RUBBER RING	2
13	WET0169	MAIN BRACKET RIGHT	1

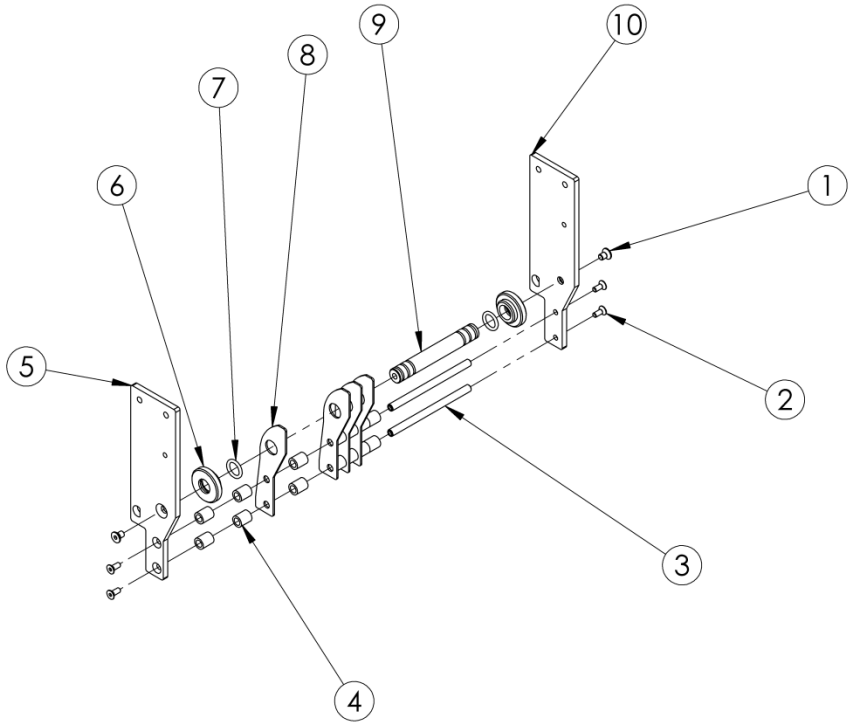
9.20 WST1049 – RSA WAT BOTTOM T.H. HINGE ASSEMBLY



WST1049 – RSA WAT BOTTOM T.H. HINGE ASSEMBLY

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	UF4514	SS M4-0.7 x 10 FHCS	4
2	WET0174	INSIDE BRACKET MIRROR	1
3	WET0178	SHAFT, dia 6, 81L	2
4	WET0180	SPACER, dia 10, 10L	12
5	WET0181	SPACER, dia 10, 6L	4
6	UF3725	SHCS M4-0.7 x 6mm	2
7	WET0173	INSIDE BRACKET	1
8	WET0172	TEFLON GUIDE A	6
9	WET0177	SHAFT, dia 10, 100L	1

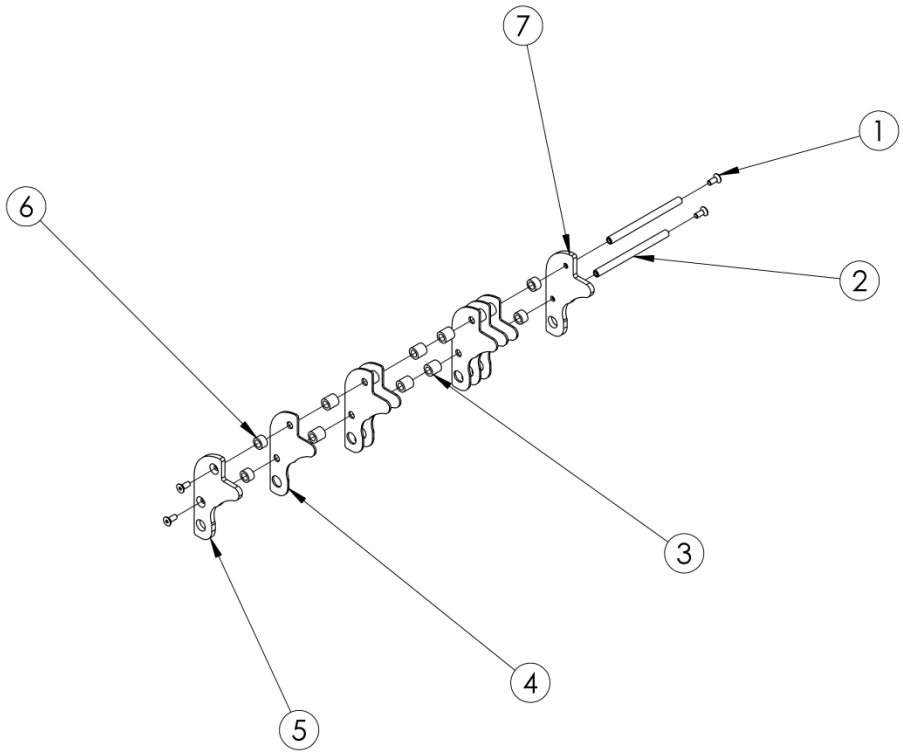
9.21 WST1050 – RSA WAT TOP T.H. MAIN ASSEMBLY



WST1035 - COVER WITH HANDLE

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	UF7024	FHCS M5-0.8 x 8 mm	2
2	UF0890EV	M4-0.7 x 10 FHCS	4
3	WEWT0176	SHAFT, dia 6, 90L	2
4	WET0179	SPACER, dia 10, 12L	14
5	WET0223	MAIN BRACKET	1
6	WET0175	STOP BEARING	2
7	UPM4936	RUBBER RING	2
8	WET0235	TEFLON GUIDE B	4
9	WET0166	MAIN SHAFT 90mm	1
10	WET0224	MAIN BRACKET MIRROR	1

9.22 WST1051 – RSA WAT TOP T.H. HINGE ASSEMBLY



WST1051 – RSA WAT TOP T.H. HINGE ASSEMBLY

ITEM	PART NUMBER	DESCRIPTION	QTY.
1	UF0890EV	M4-0.7 x 10 FHCS	4
2	WET0178	SHAFT, dia 6, 81L	2
3	WET0180	SPACER, dia 10, 10L	12
4	WET0236	TEFLON GUIDE A	6
5	WET0226	INSIDE BRACKET	1
6	WET0181	SPACER, dia 10, 6L	4
7	WET0227	INSIDE BRACKET MIRROR	1