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7. Illustrated Parts Breakdown

7-1. How to Order Replacement Parts

1. Refer to the following figures and their related lists of parts on the following pages to determine the individual part number and description.

✓ Note

Complete descriptions have been included for most commercially available components. This will allow the customer/service person to obtain parts locally, if this is desired.

2. Order parts by machine model number, part number, description, and quantity required. (An order form is included at the end of this manual section).

Minimum billing on parts is \$25.00. Replacement part prices are available on request.

3. Replacement parts and part prices are available directly from:

7-2. Spare Parts

A number of spare parts are provided with the case sealer that should be replaced periodically due to normal wear or breakage. The parts provided are items that should be reordered as they are consumed to keep the case sealer in good operating condition:

Part Number	Description	Quantity	Figure No.	Item No.
78-8070-1274-1	SPRING, Upper (Silver)	1	7-29	10
78-8017-9173-8	KNIFE, Cutoff	2	7-31	2
78-8052-6602-6	SPRING, Cutter	4	7-31	12
78-8070-1273-3	SPRING, Lower (Black)	1	7-34	10

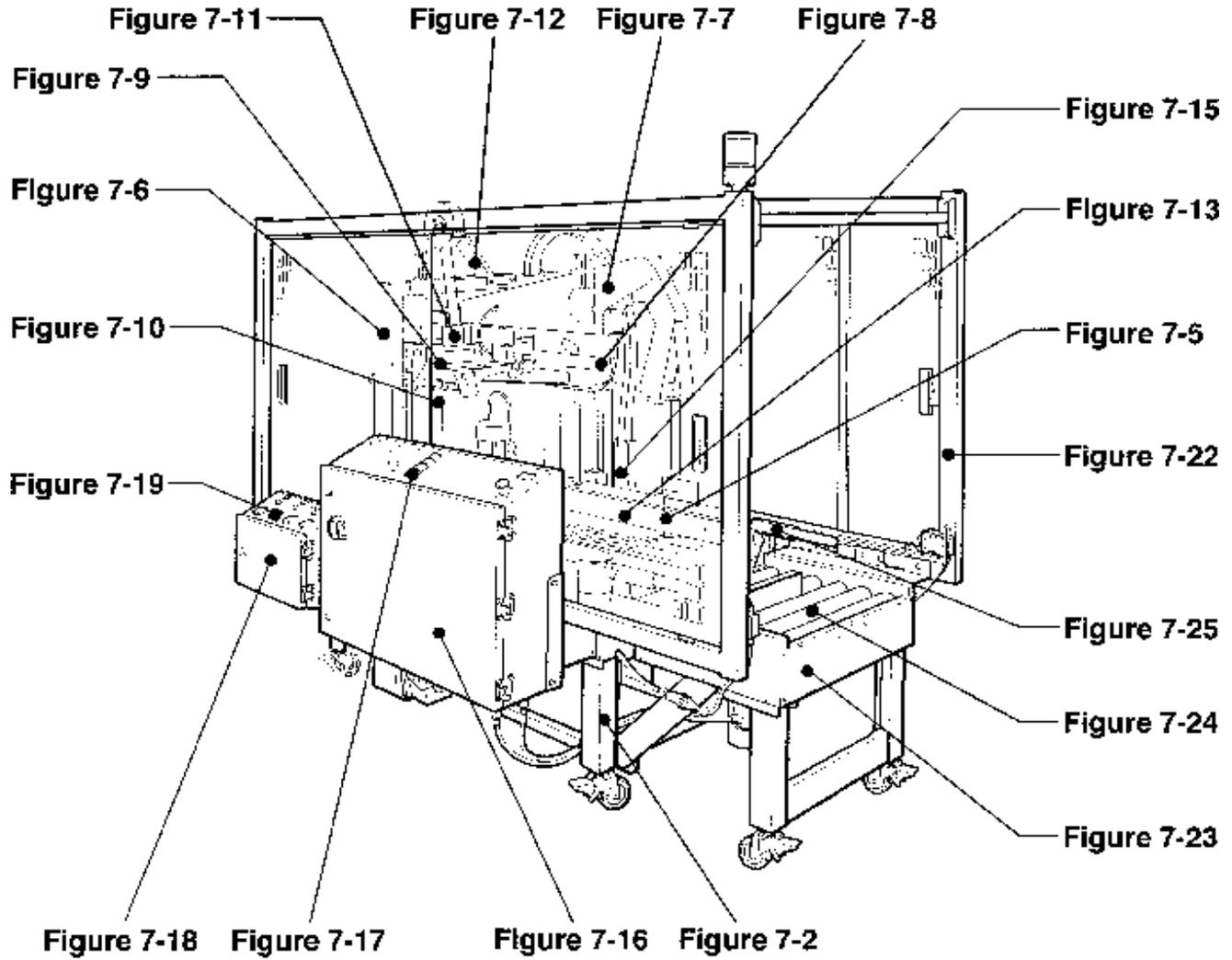
These parts are available as a kit. The kit part number is 78-8098-8893-2.

7-3. Suggested Spare Parts

In addition to the preceding minimum spare parts, it is suggested that the following items be maintained as spare parts.

Part Number	Description	Quantity	Figure No.	Item No.
78-8057-6178-6	ROLLER, Buffing	1	7-29	5
78-8057-6179-4	ROLLER, Applying	1	7-28	15
78-8054-8841-4	DRIVE BELT	2	7-13	55
78-8114-4824-6	PHOTOCELL, E3F2-R2B4-P1-E	1	7-23	39
78-8054-8648-3	ROLLER, Compression	1	7-9	8
78-8052-6713-1	RING, Polyurethane, Side Belt Drive	4	7-14	17
78-8113-7030-9	SPRING, Torsion	2	7-31	18
78-8094-6472-6	MOTOR, 200/220V, 50/60 Hz, 3-Phase	1	7-13	64

7-4. Illustrations and Parts Lists



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Figure 7-1. 800rf Case Sealer Breakdown

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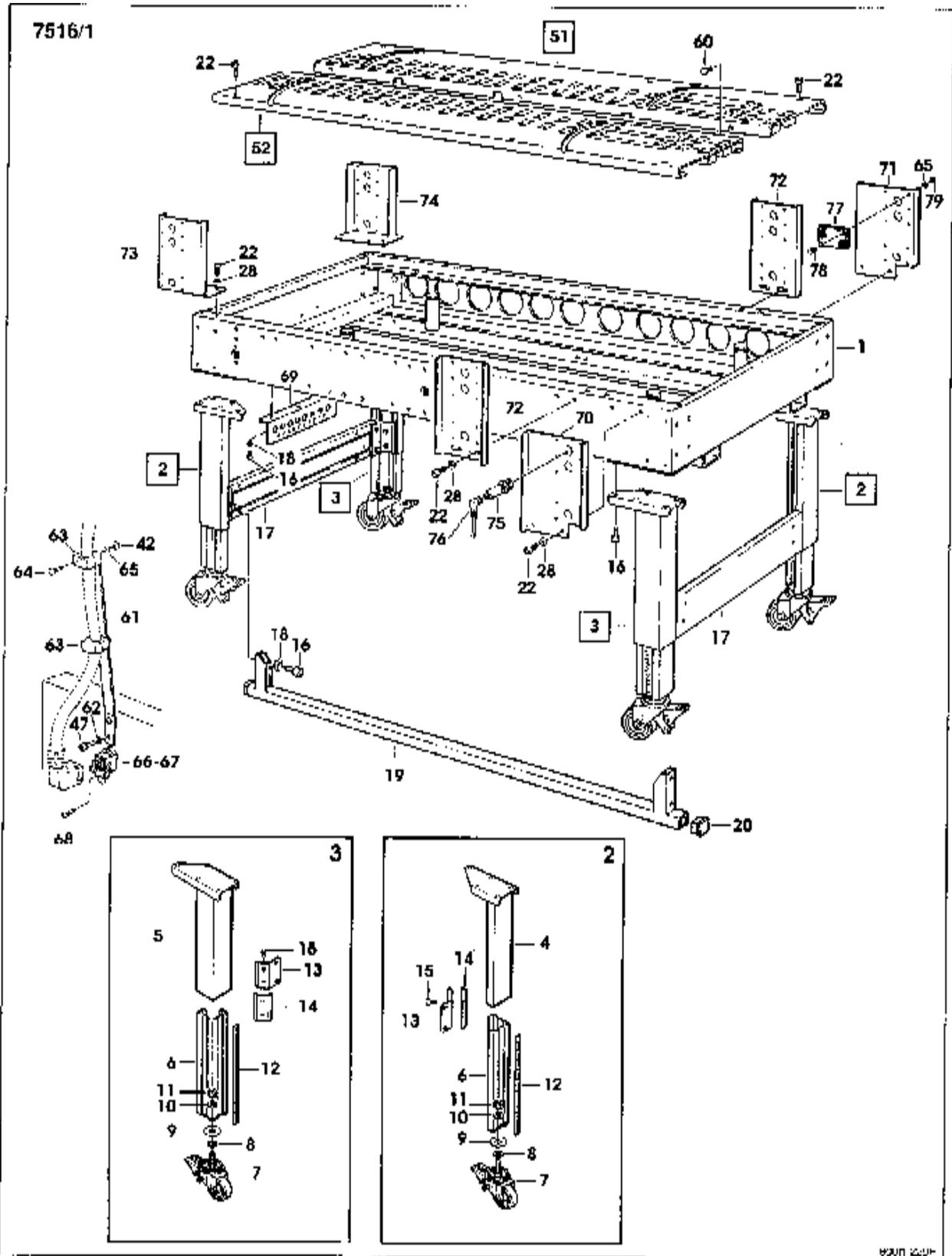


Figure 7-2. Conveyor Frame

Parts List - Conveyor Frame

Item Number	Part Number	Description	Qty
1	78-8119-8588-2	BED ASSEMBLY, Conveyor	1
2	78-8076-5038-3	LEG ASSEMBLY, Right	2
3	78-8076-5039-1	LEG ASSEMBLY, Left	2
4	78-8076-5040-9	LEG, Right	2
5	78-8076-5041-7	LEG, Left	2
6	78-8052-6678-6	LEG, Inner	4
7	78-8060-7847-9	CASTER/100	4
8	78-8060-8124-2	SPACER, Caster	4
9	78-8060-7699-4	WASHER/12-45, 5 x 4	4
10	78-8017-9059-9	WASHER, Flat for M12 Screw	4
11	78-8060-7532-7	NUT, M12 Self-Locking	4
12	78-8052-6680-2	LABEL, Height	4
13	78-8060-7697-8	BRACKET, Special	4
14	78-8052-6677-8	CLAMP, Inner	4
15	26-1003-7963-0	SCREW, Soc. Hd., M8 x 16	10
16	26-1003-7964-8	SCREW, Soc. Hd., Hex Soc. Dr., M8 x 20	39
17	78-8119-8525-4	CROSS BAR, Leg w/nutserts	2
18	78-8017-9318-9	WASHER, Plain, Metric, 8mm	21
19	78-8076-5043-3	REINFORCEMENT, Leg	2
20	78-8060-7704-2	CAP, Plastic, 40 x 40	4
22	78-8060-7896-6	SCREW, Soc. Hd., Hex Hd., M6 x 14	32
28	26-1000-0010-3	WASHER, Flat M6	32
42	26-1003-6914-4	NUT, Plastic Insert M4	24
47	26-1003-7949-9	SCREW, Soc. Hd., Hex Soc., M5 x 12	12
51	78-8119-8530-4	CONVEYOR ASSEMBLY, Right	1
52	78-8119-8531-2	CONVEYOR ASSEMBLY, Left	1
60	26-1003-5829-5	SCREW, Hex Hd., M6 x 12	6
61	78-8076-5059-9	STRAP, Wire	2
62	78-8005-5741-1	WASHER, Flat, M5	4
63	78-8060-7630-9	LOCK, Tube	4
64	78-8010-7157-8	SCREW, Hex Hd., M4 x 10	4
65	78-8005-5740-3	WASHER, Metric, Plain 4mm Nick.	20
66	78-8060-7872-7	COVER PLUG, Straight	2

Parts List - Conveyor Frame (Continued)

Item Number	Part Number	Description	Qty
67	78-8060-7873-5	PLUG, Female	2
68	78-8028-8208-0	SCREW, 6P x 9,5	4
69	78-8119-8535-3	BRACKET	1
70	78-8119-8538-7	SUPPORT, Photocell	1
71	78-8119-8536-1	SUPPORT, Photocell	1
72	78-8119-8537-9	SUPPORT, Photocell	4
73	78-8119-8589-0	BRACKET, Photocell, Rear, Left	1
74	78-8119-8590-8	BRACKET, Photocell, Rear, Right	1
75	78-8114-4824-6	PHOTOCELL, OMROM, E3F2, R2B4, P1, E	4
76	78-8114-4825-3	CONNECTOR, CS, A2, 02, S, 05	4
77	78-8076-5057-3	REFLECTOR, OMROM, E39-R1	4
78	83-0002-7336-3	SCREW, Hex Hd., M4 x 14 Zinc. Pl.	8
79	78-8010-7416-8	NUT, Metric, Hex, Steel, M4	8

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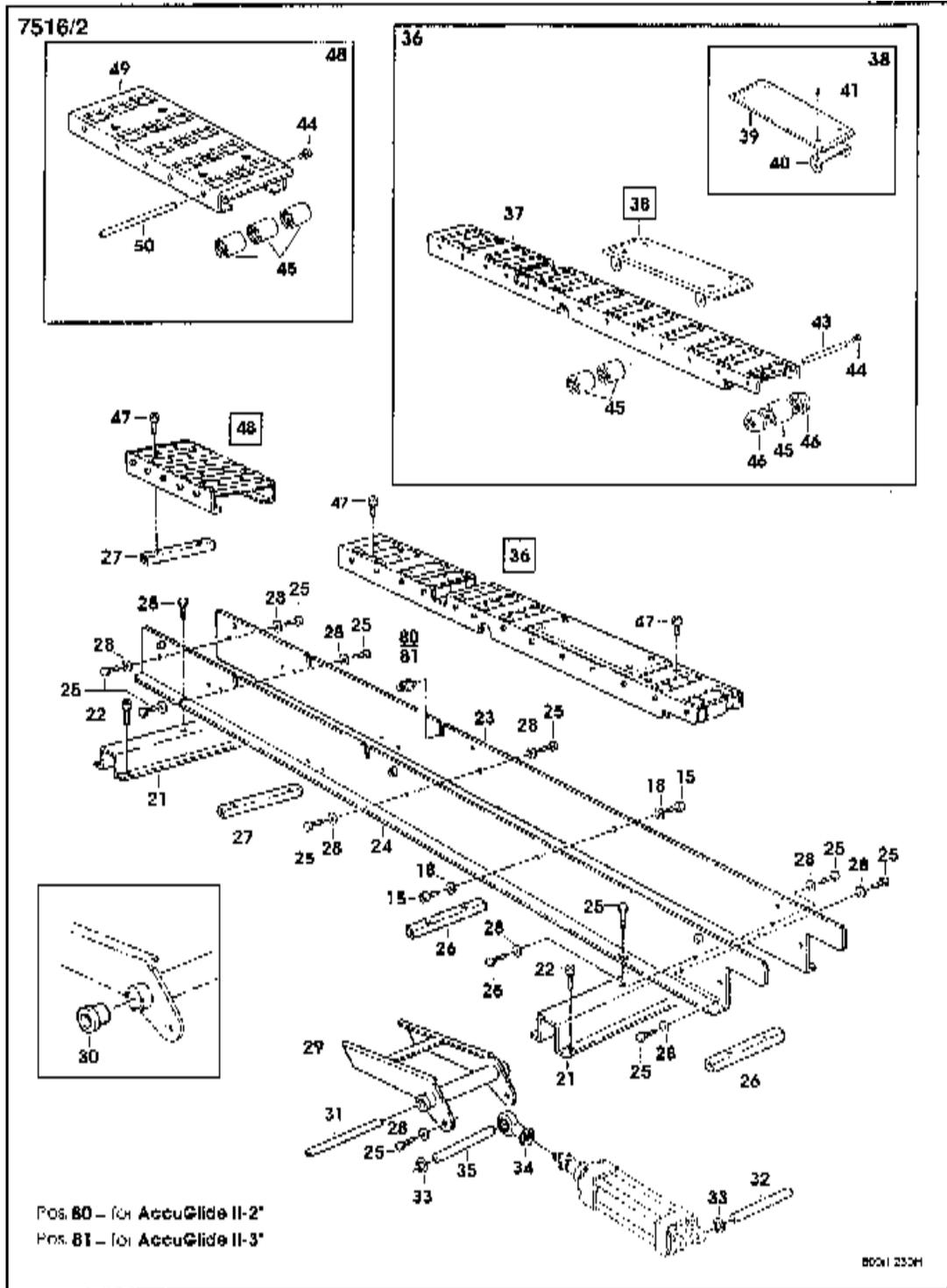


Figure 7-3. Conveyor Center Bed and Fork

Parts List - Conveyor Center Bed and Fork

Item Number	Part Number	Description	Qty
15	26-1003-7963-0	SCREW, Soc. Hd., M8 x 16	10
18	78-8017-9318-9	WASHER, Plain, Metric, 8mm	21
21	78-8076-5060-7	SUPPORT	2
22	78-8060-7896-6	SCREW, Soc. Hd., Hex Hd., M6 x 14	32
23	78-8060-7712-5	SHOULDER, Lower, Right	1
24	78-8060-7710-9	SHOULDER, Lower, Left	1
25	78-8010-7169-3	SCREW, Metric, M6 x 12, Hex Hd.	16
26	78-8060-7714-1	STRIP	2
27	78-8060-7722-4	SPACER, L=144	2
28	26-1000-0010-3	WASHER, Flat M6	32
29	78-8076-5045-8	FORK	1
30	78-8060-7718-2	BUSHING	2
31	78-8060-7717-4	SHAFT, Flap Straightener	1
32	78-8060-7721-6	STUD, Cylinder Mount	1
33	78-8052-6733-9	RING, Special M10	4
34	78-8057-5748-7	MOUNT, Cylinder Rod End	1
35	78-8060-7719-0	SHAFT, 10 x 115	1
36	78-8119-8526-2	CONVEYOR ASSEMBLY, Center	1
37	78-8076-5051-6	ROLLER ASSEMBLY, Center	1
38	78-8119-8527-0	SLIDE ASSEMBLY, Center	1
39	78-8119-8528-8	LARGE SLIDE FOR CONVEYOR	1
40	78-8119-8529-6	BRACKET, Large Slide	2
41	78-806060-78039257-9-2	SCREW, Phillip Head, M4 x 10RIVET	20
42	26-1003-6914-4	NUT, Plastic Insert, M4	24
43	78-8060-7708-3	SHAFT, 8 x 92	11
44	78-8010-7163-6	SCREW, Metric, M5 x 10, Hex Hd.	16
45	78-8060-7693-7	ROLLER, 32 x 38	98
46	78-8060-7692-9	ROLLER, Tappert	22
47	26-1003-7949-9	SCREW, Soc. Hd., Hex Soc., M5 x 12	12
48	78-8076-5052-4	ROLLER CONVEYOR ASSEMBLY, Right	1
49	78-8076-5053-2	ROLLER ASSEMBLY, Rear	1
50	78-8060-7706-7	SHAFT, 8 x 132	5
80	78-8060-8460-0	STUD, 2-inch Bottom Head Mount	4
81	78-8055-0745-2	STUD, 3-inch Bottom Head Mount	4

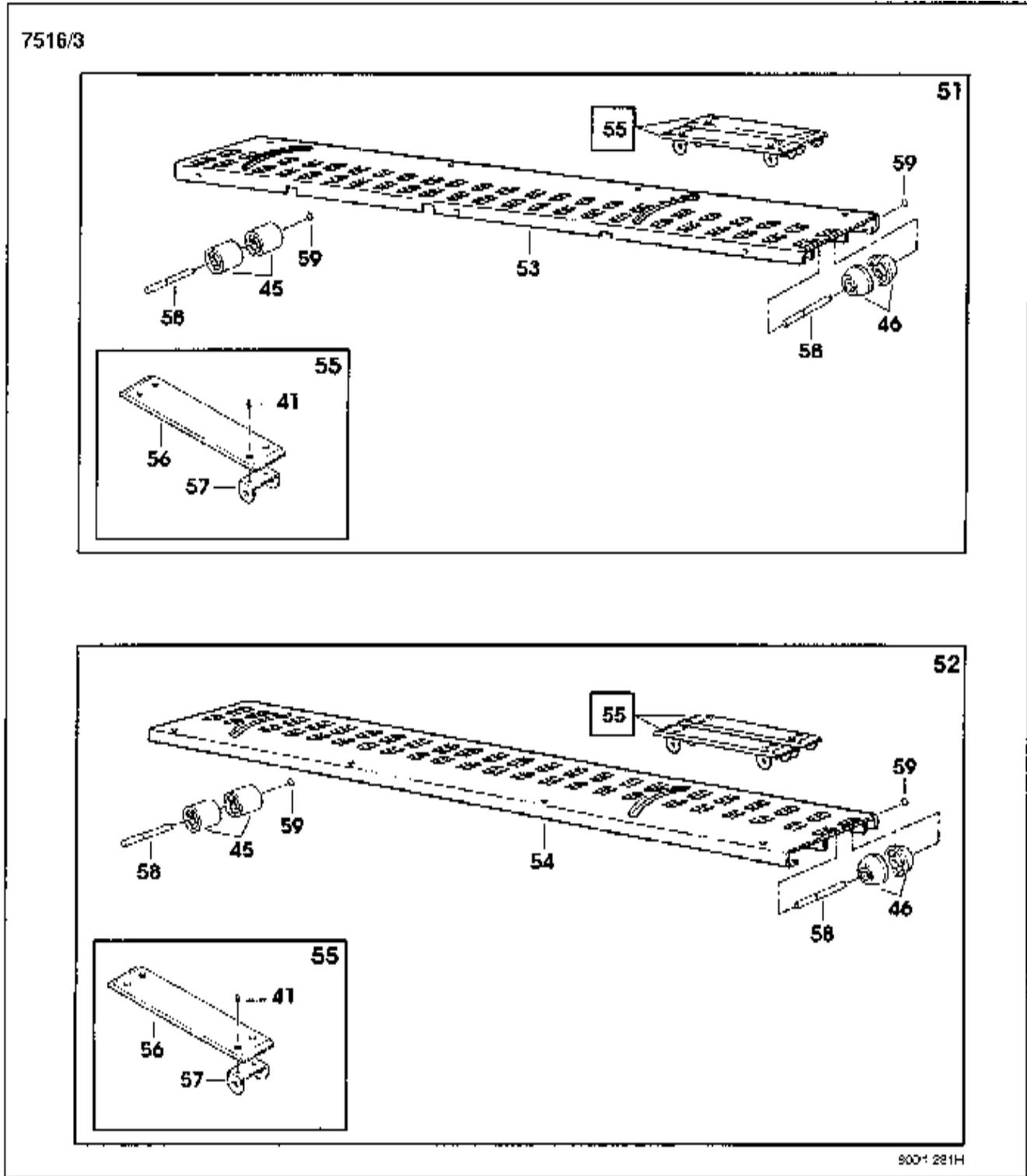
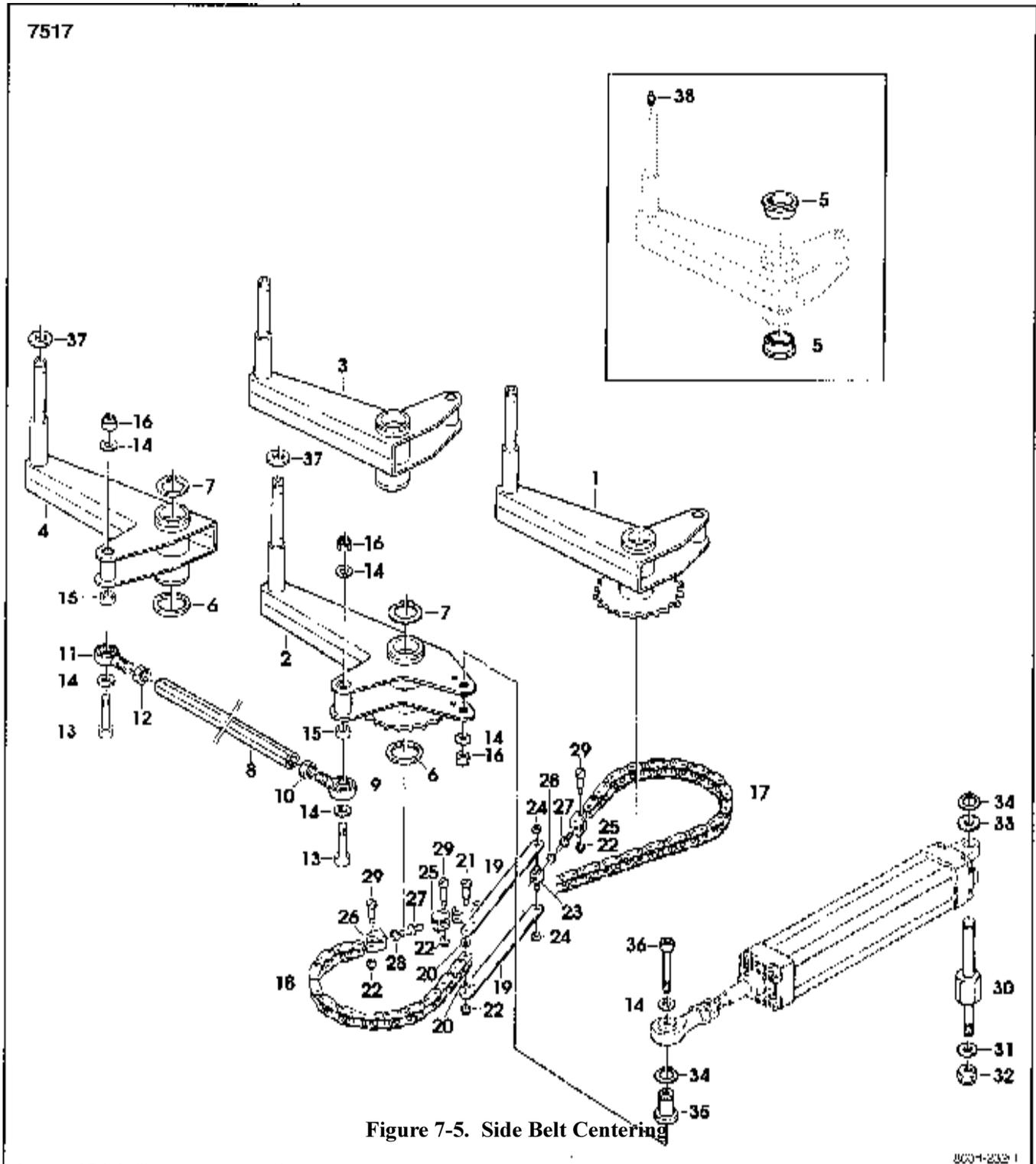


Figure 7-4. Conveyor Bed Rollers

Parts List - Conveyor Bed Rollers

Item Number	Part Number	Description	Qty
41	78-80178060-92577803-92	SCREW, Phillips Head, M4 x 10RIVET	20
42	26-1003-6914-4	NUT, Plastic Insert, M4	24
45	78-8060-7693-7	ROLLER, 32 x 38	98
46	78-8060-7692-9	ROLLER, Tappert	22
51	78-8119-8530-4	CONVEYOR ASSEMBLY, Right	1
52	78-8119-8531-2	CONVEYOR ASSEMBLY, Left	1
53	78-8091-0387-8	CONVEYOR, Right	1
54	78-8091-0388-6	CONVEYOR, Left	1
55	78-8119-8532-0	SLIDE ASSEMBLY, Side	4
56	78-8119-8533-8	NARROW SLIDE FOR CONVEYOR	4
57	78-8119-8534-6	BRACKET, Narrow Slide	8
58	78-8060-7965-9	SHAFT, 8 x 120, Hex Hd.	42
59	78-8060-8035-0	E-RING, 7DIN6799	42



Parts List - Side Belt Centering

Item Number	Part Number	Description	Qty
1	78-8114-4867-5	ARM ASSEMBLY, Front, Right	1
2	78-8114-4868-3	ARM ASSEMBLY, Front, Left	1
3	78-8114-4869-1	ARM ASSEMBLY, Rear, Right	1
4	78-8114-4870-9	ARM ASSEMBLY, Rear, Left	1
5	78-8076-4791-8	BUSHING	8
6	78-8060-7534-3	WASHER	4
7	78-8060-7521-0	LOCK RING	4
8	78-8060-7527-7	ROD	2
9	78-8076-4793-4	BALL JOINT, KA 10 D	2
10	78-8060-7525-1	NUT, M10, Right, Flat	2
11	78-8076-4794-2	BALL JOINT, KAL 10 D	2
12	78-8060-7546-7	NUT, M10, Left, Flat	2
13	78-8076-4796-7	SCREW, Soc. Hd., Hex Hd., M10 x 80	4
14	78-8052-6566-3	WASHER, Friction	10
15	78-8076-4795-9	SPACER	4
16	26-1003-6918-5	NUT, Plastic Insert, M10 Hex	5
17	78-8060-7518-6	CHAIN, 3/8-inch, 60 Pitch Long	1
18	78-8054-8777-0	CHAIN, 3/8-inch Pitch, 41 Pitch Long	1
19	78-8054-8787-9	LINK, Chain	2
20	78-8054-8783-8	WASHER, Special	2
21	78-8060-7519-4	SCREW, M3 x 25	1
22	78-8059-5517-2	NUT, Self-Locking, M3, Zinc. Pl.	4
23	78-8054-8784-6	BLOCK, Chain	1
24	78-8056-3945-3	E-RING, M4	2
25	78-8054-8786-1	CONNECTOR, Chain	2
26	78-8054-8788-7	CONNECTOR, Chain	1
27	78-8054-8785-3	ROD, Threaded Right/Left	2
28	78-8010-7418-4	NUT, Metric, Hex, Stl., M6	2
29	78-8060-7520-2	SCREW, M3 x 20	3
30	78-8114-5093-7	STUD, Cylinder	1
31	78-8017-9059-9	WASHER, Flat for M12 Screw	1
32	78-8060-7532-7	NUT, Self-Locking, M12	1
33	78-8114-5094-5	WASHER, Special	1

Parts List - Side Belt Centering (Continued)

Item Number	Part Number	Description	Qty
34	78-8060-7533-5	LOCK RING	2
35	78-8114-5095-2	BUSHING, Cylinder	1
36	78-8060-7535-0	SCREW, M10 x 60, Soc. Hd., Hex Soc.	1
37	78-8060-7541-8	WASHER	4
38	78-8114-4871-7	NIPPLE, Grease	4

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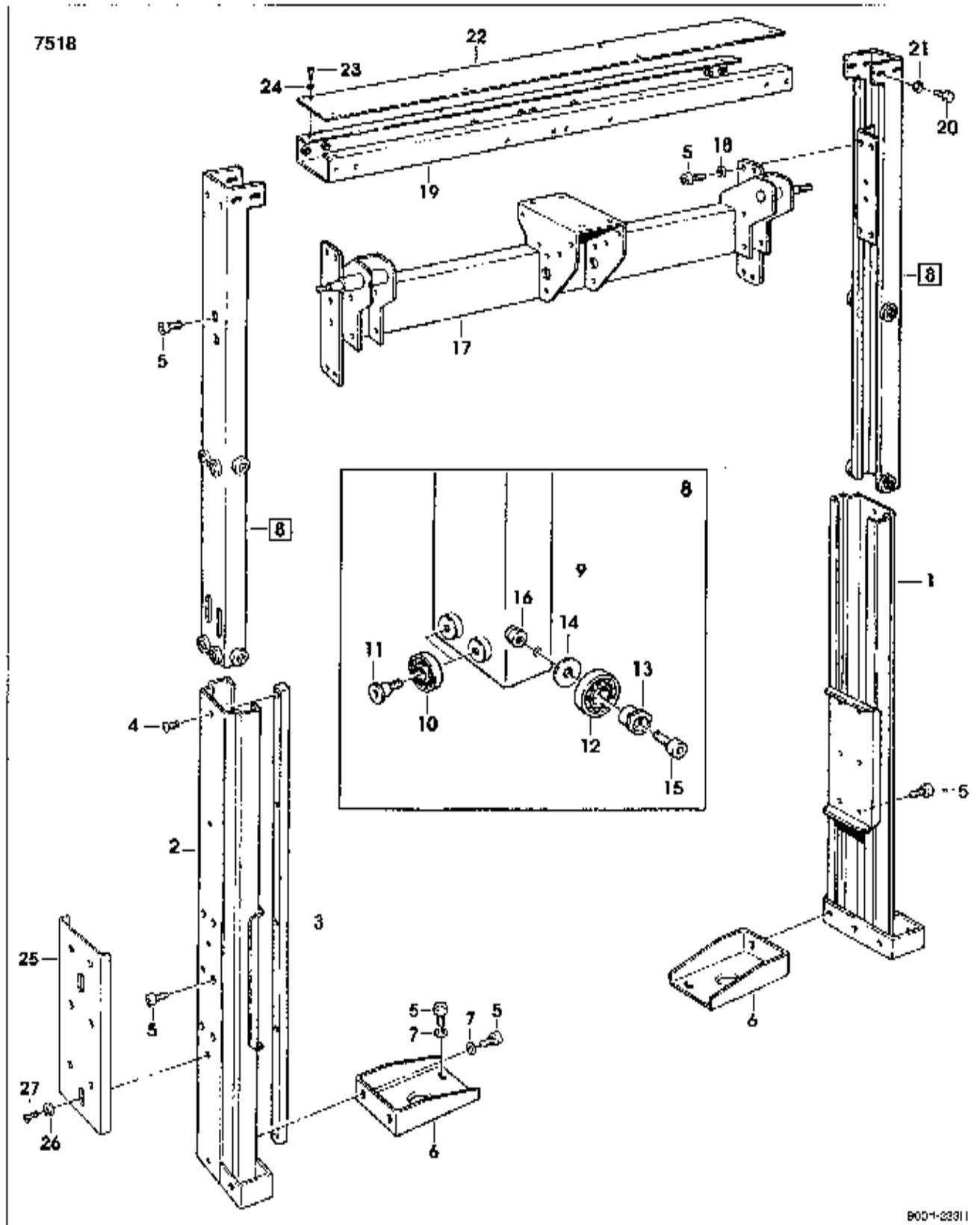


Figure 7-6. Column Assembly

Parts List - Column Assembly

Item Number	Part Number	Description	Qty
1	78-8114-5096-0	COLUMN ASSEMBLY, Right	1
2	78-8114-5097-8	COLUMN ASSEMBLY, Left	1
3	78-8114-5098-6	GUIDE, Column	2
4	78-8076-4503-7	SCREW, M6 x 12	6
5	26-1003-7964-8	SCREW, Soc. Hd., Hex Soc. Dr., M8 x 20	28
6	78-8100-0894-2	BRACKET, Column	2
7	78-8017-9318-9	WASHER, Plain, Metric, 8mm	8
8	78-8076-5068-0	COLUMN ASSEMBLY, Inner	2
9	78-8076-5069-8	COLUMN, Inner	2
10	78-8059-5625-3	BEARING	8
11	78-8076-4815-5	SCREW, Bearing	8
12	26-1000-4350-9	BEARING, 6002, 2RS	8
13	78-8076-4816-3	BUSHING, Eccentric	8
14	78-8076-5070-6	SPACER	8
15	26-1003-7957-2	SCREW, Soc. Hd., Hex Hd., M6 x 16	8
16	26-1003-6916-9	NUT, Locking, Plastic Insert, M6	8
17	78-8114-5099-4	CROSS BAR, Upper Assembly	1
18	78-8005-5736-1	LOCKWASHER, for M8 Screw	8
19	78-8119-8500-7	CROSS BAR	1
20	78-8032-0375-7	SCREW, Metric, Hex Hd., M6 x 16	8
21	26-1000-0010-3	WASHER, Flat M6	8
22	78-8094-6418-9	COVER	1
23	78-8017-9257-9	SCREW, Phillips Hd., M4 x 10	8
24	78-8005-5740-3	WASHER, Plain, Metric, 4mm, Nick.	8
25	78-8119-8501-5	GUARD	2
26	78-8091-0581-6	STOP, Protection	4
27	26-1001-9843-6	SCREW, Flat Soc. Hd., M6 x 16	4

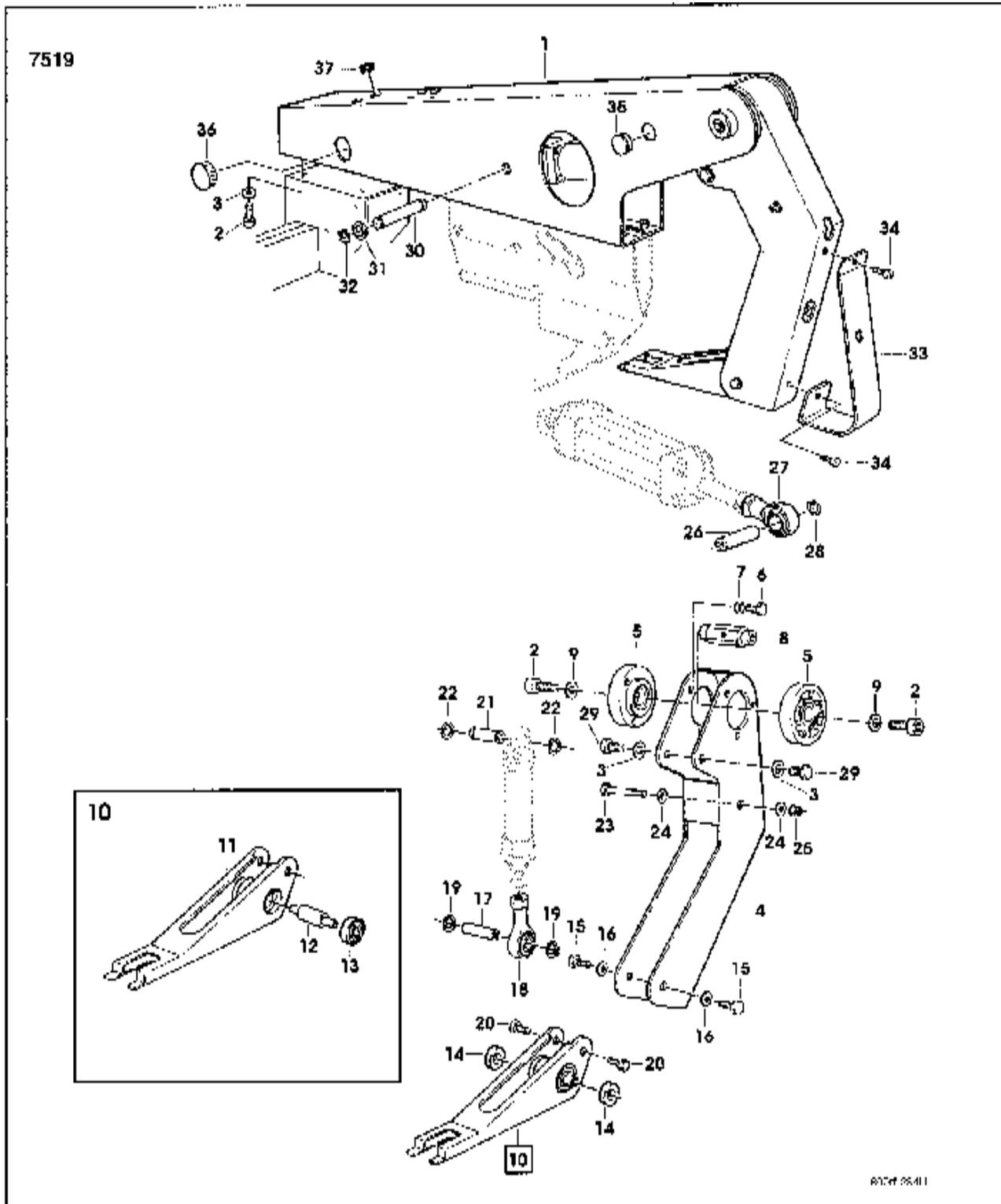


Figure 7-7. Flap Folder Assembly

Parts List - Flap Folder Assembly

Item Number	Part Number	Description	Qty
1	78-8119-8502-3	SUPPORT, Flap Folder	1
2	26-1003-7963-0	SCREW, Soc. Hd., M8 x 16	6
3	78-8017-9318-9	WASHER, Plain, Metric, 8mm	76
4	78-8119-8503-1	ARM, Flap Folder	21
5	78-8076-5442-7	FLANGE ASSEMBLY	2
6	26-1003-5829-5	SCREW, Hex Hd., M6 x 12	6
7	78-8091-0468-6	WASHER, Dented, M6	6
8	78-8119-8504-9	STUD	1
9	78-8100-0833-0	WASHER, M8	2
10	78-8091-0360-5	FLAP FOLDER ASSEMBLY, Rear	1
11	78-8091-0553-5	FLAP FOLDER, Rear	1
12	78-8091-0554-3	SHAFT, Flap Folder	1
13	78-8023-2410-9	BEARING, 6000, 2RS	2
14	78-8091-0389-4	SPACER, Bearing	2
15	78-8010-7169-3	SCREW, Metric, Hex Hd., M6 x 12	2
16	26-1000-0010-3	WASHER, Flat, M6	2
17	78-8060-7764-6	SPACER, 10 x 39	1
18	78-8057-5748-7	MOUNT, Cylinder Rod End	1
19	78-8052-6733-9	RING, Special M10	2
20	26-1003-5828-7	SCREW, Spec., Hex Hd., M6 x 10	2
21	78-8054-8946-1	SHAFT, 5/8 x 51mm	1
22	78-8052-6732-1	RING, Special M8	2
23	78-8057-5728-9	SCREW, Hex Hd., M5 x 60	1
24	78-8005-5741-1	WASHER, Flat, M5	2
25	26-1005-6859-6	NUT, Self-Locking, M5	1
26	78-8054-8944-6	SHAFT, 12 x 51mm	1
27	78-8057-5747-9	MOUNT, Cylinder Rod End	1
28	78-8656-3972-4	E-RING, M12	2
29	26-1003-5841-0	SCREW, M8 x 16	2
30	78-8054-8937-0	SHAFT, 12 x 100mm	1
31	78-8017-9059-9	WASHER, Flat for M12 Screw	2
32	78-8056-3965-1	RING, 8 DIN 6799	2
33	78-8060-7761-2	EXTENSION, Flap Folder	1

Parts List - Flap Folder Assembly (Continued)

Item Number	Part Number	Description	Qty
34	78-8060-7896-6	SCREW, Soc. Hd., Hex Hd., M6 x 14	2
35	78-8060-7885-9	CAP, End	1
36	78-80768060-46358184-76	GROMMET/32CAP	1
37	78-8060-7758-8	FAIRLEAD/20	2
38	78-8017-9301-5	SCREW, Hex Hd., M8 x 25	1

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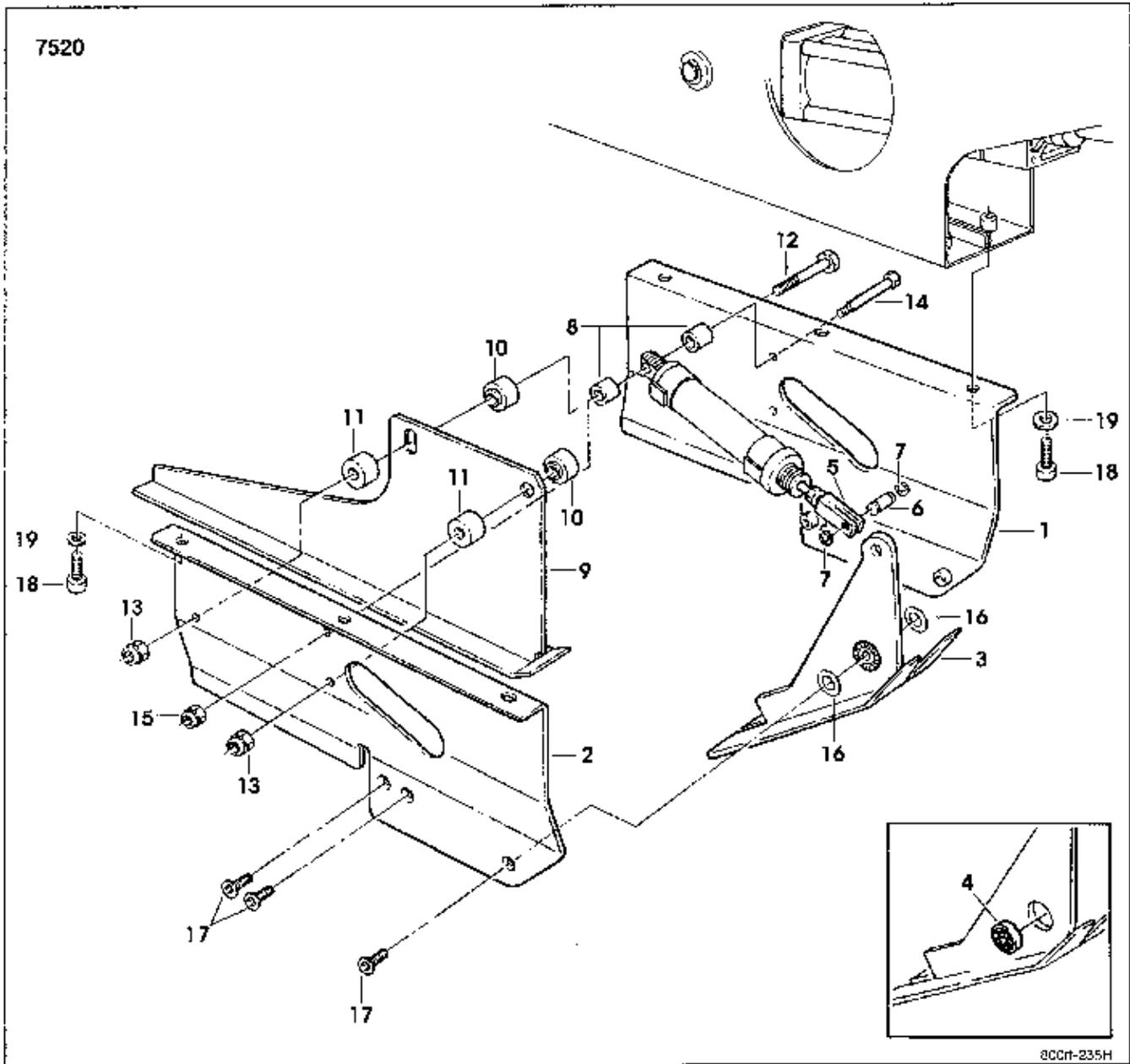


Figure 7-8. Paddle Assembly

Parts List - Paddle Assembly

Item Number	Part Number	Description	Qty
1	78-8119-8507-2	SUPPORT ASSEMBLY, Guide, Right	1
2	78-8119-8508-0	SUPPORT ASSEMBLY, Guide, Left	1
3	78-8119-8509-8	PADDLE, Box Height	1
4	78-8060-7568-1	BEARING, 618/9	1
5	78-8076-5081-3	FORK, Cylinder	1
6	78-8060-7566-5	STUD, Fork	1
7	78-8060-7565-7	RING	2
8	78-8060-7558-2	SPACER, Cylinder	2
9	78-8076-5080-5	GUIDE, Box	1
10	78-8060-7561-6	SPACER	2
11	78-8060-7562-4	SPACER	2
12	26-1002-5836-2	SCREW, Hex Hd., M6 x 40	2
13	26-1003-6916-9	NUT, Locking, Plastic Insert, M6	2
14	78-8114-4903-8	SCREW, Special, M5	1
15	26-1005-6859-6	NUT, Self-Locking, M5	1
16	78-8119-8510-6	WASHER, Special	2
17	78-8017-9170-4	SCREW, Phillips, FH, M4 x 8	3
18	26-1003-7957-2	SCREW, Soc. Hd., Hex Hd., M6 x 16	6
19	26-1000-0010-3	WASHER, Flat, M6	6

Parts List - Side Belt Rail Assembly

Item Number	Part Number	Description	Qty
1	78-8114-4904-6	SIDE FLAP FOLDER, Right	1
2	78-8076-5083-9	SIDE FLAP FOLDER, Left	1
3	78-8060-7555-8	BEARING, L-Bar	8
4	78-8060-7554-1	STUD, Flap Folder	4
5	78-8060-7747-1	RUBBER RING	4
6	26-1003-5841-0	SCREW, M8 x 16	8
7	78-8017-9318-9	WASHER, Plain, Metric, 8mm	8
8	78-8054-8648-3	ROLLER, Pressure	4
9	78-8055-0622-3	BUSHING	4
10	26-1004-5507-5	WASHER, M8	8
11	78-8070-1594-2	SCREW, Hex Hd., M8 x 60	4
12	78-8017-9313-0	NUT, Self-Locking, M8, Nick. Pl.	4
13	78-8119-8511-4	SPACER	2
14	78-8023-2334-1	SCREW, Soc. Hd., Hex Soc., M6 x 25	8
15	78-8119-8512-2	BUMPER	2

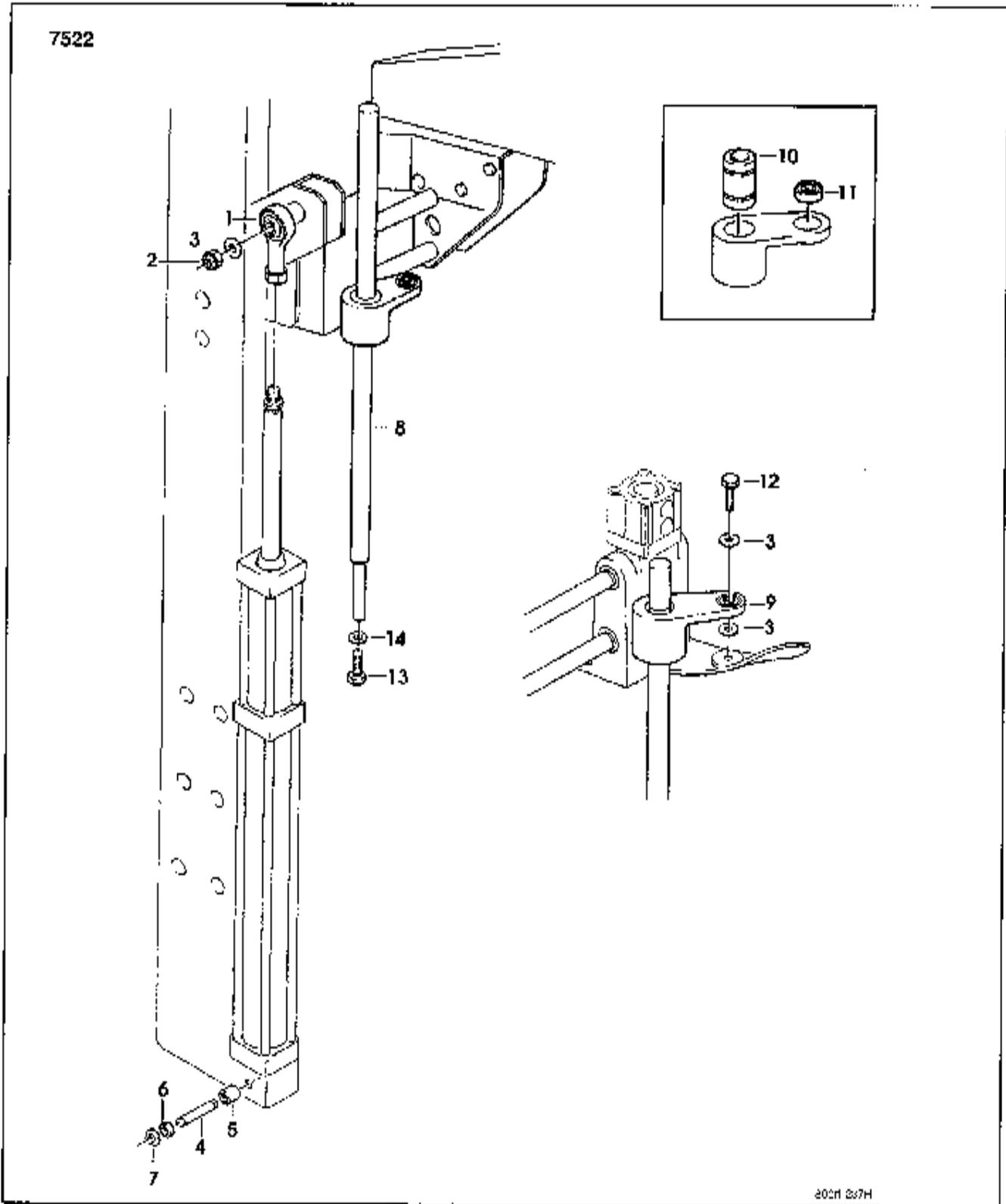


Figure 7-10. Head Cylinder Assembly

Parts List - Head Cylinder Assembly

Item Number	Part Number	Description	Qty
1	78-8057-5747-9	MOUNT, Cylinder Rod End	2
2	26-1003-6918-5	NUT, Plastic Insert, Hex, M10	2
3	78-8052-6566-3	WASHER, Friction	6
4	78-8094-6335-5	STUD, Cylinder	2
5	78-8076-5086-2	SPACER	2
6	78-8060-7754-7	SPACER, Column Cylinder	2
7	78-8056-3965-1	RING, 8 DIN 6799	4
8	78-8060-7748-9	ROD, L=583	2
9	78-8076-5087-0	ROD, Connecting	2
10	78-8060-7752-1	BEARING, L-Bar, 20-32 x 45	2
11	78-8076-5225-6	JOINT	2
12	78-8076-5088-8	SCREW, Hex Hd., M10 x 30	2
13	26-1003-5841-0	SCREW, M8 x 16	2
14	26-1004-5507-5	WASHER, M8	2

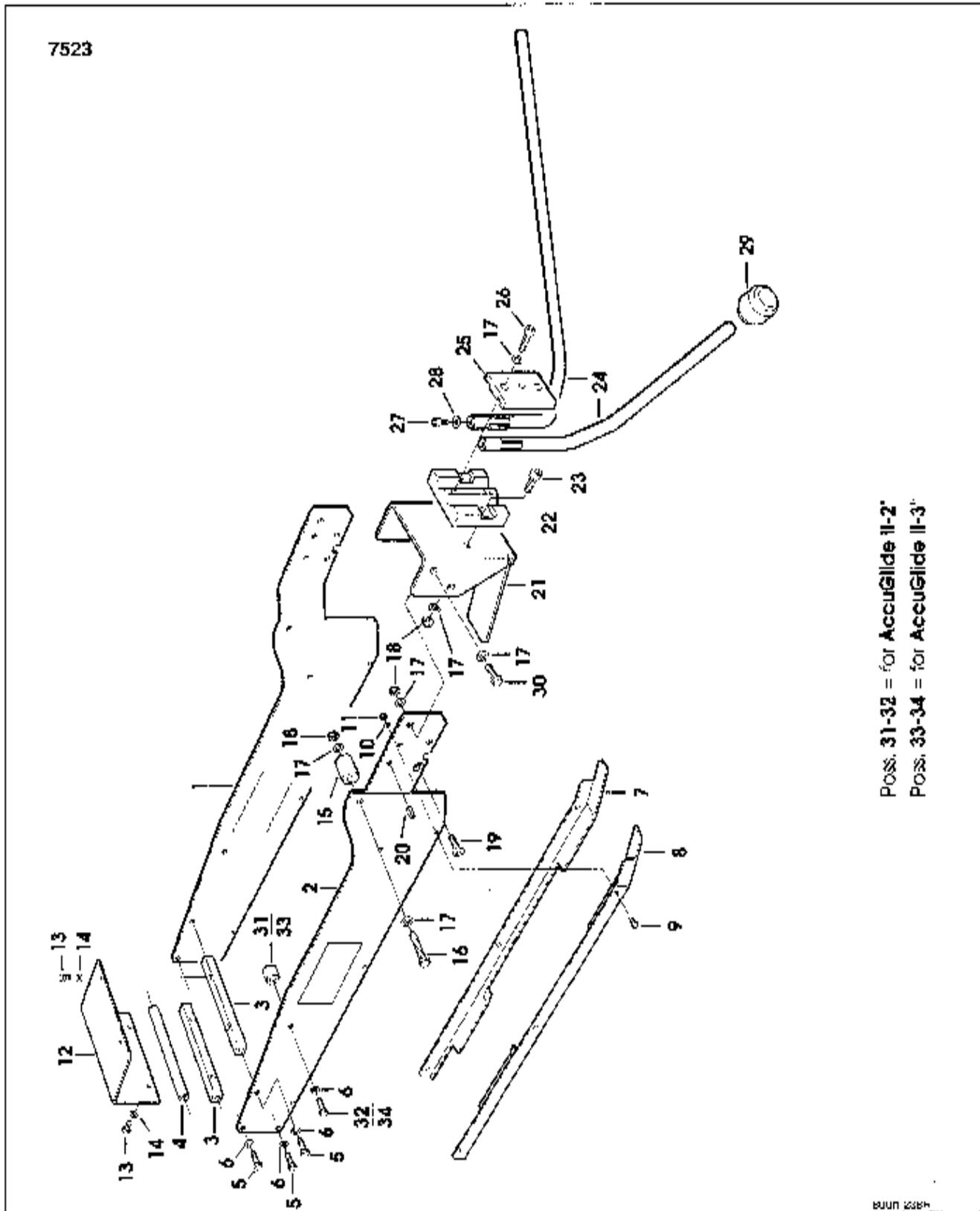


Figure 7-11. Upper Tape Head Mount

Parts List - Upper Tape Head Mount

Item Number	Part Number	Description	Qty
1	78-8122-6717-3	FRAME, Right, Upper Head, w/English Label	1
2	78-8122-6718-1	FRAME, Left, Upper Head, w/English Label	1
3	78-8054-8931-3	SPACER, 10 x 10 x 140mm	2
4	78-8054-8929-7	SPACER, 10 x 140mm	1
5	78-8032-0375-7	SCREW, Metric, Hex Hd., M6 x 16	10
6	26-1000-0010-3	WASHER, Flat, M6	14
7	78-8060-7769-5	SKI, Right	1
8	78-8060-7770-3	SKI, Left	1
9	78-8010-7157-8	SCREW, Hex Hd., M4 x 10	6
10	78-8005-5740-3	WASHER, Plain, Metric, 4mm, Nick.	6
11	26-1003-6914-4	NUT, Plastic Insert, M4	6
12	78-8119-8541-1	PLATE, Rear	1
13	78-8010-7163-6	SCREW, Metric, Hex Hd., M5 x 10	4
14	78-8005-5741-1	WASHER, Flat, M5	4
15	78-8054-8933-9	SPACER, 8,5/20 x 25mm	2
16	26-1014-4538-0	SCREW, Hex Hd., M8 x 45	2
17	78-8017-9318-9	WASHER, Plain, Metric, 8mm	16
18	78-8017-9313-0	NUT, Self-Locking, M8, Nick. Pl.	10
19	78-8054-8567-3	SCREW, Soc. Hd., Special	2
20	78-8100-0895-9	PIN, Roll, 6 x 12	4
21	78-8119-8542-9	SLIDE FRONT	1
22	78-8100-1077-3	BLOCK	1
23	26-1003-7965-5	SCREW, Soc. Hd., Hex Soc., M8 x 25	2
24	78-8119-8543-7	SIDE FLAP FOLDER	2
25	78-8119-8544-5	CLAMP, Flap Folder	1
26	78-8060-7895-8	SCREW, M8 x 35	2
27	78-8010-7209-7	SCREW, Soc. Hd., M6 x 12	2
28	78-8042-2919-9	WASHER, Triple, M6	2
29	78-8060-7869-3	PROTECTION, Rods, 12AF	2
30	78-8017-9301-5	SCREW, Hex Hd., M8 x 25	4
31	78-8054-8935-4	SPACER	4
32	26-1003-5833-7	SCREW, Hex Hd., 6 x 30	4
33	78-8076-5036-7	STUD, Mounting, 3-inch Top Head	4
34	78-8010-7193-3	SCREW, Metric, Hex Hd., M6 x 20	4

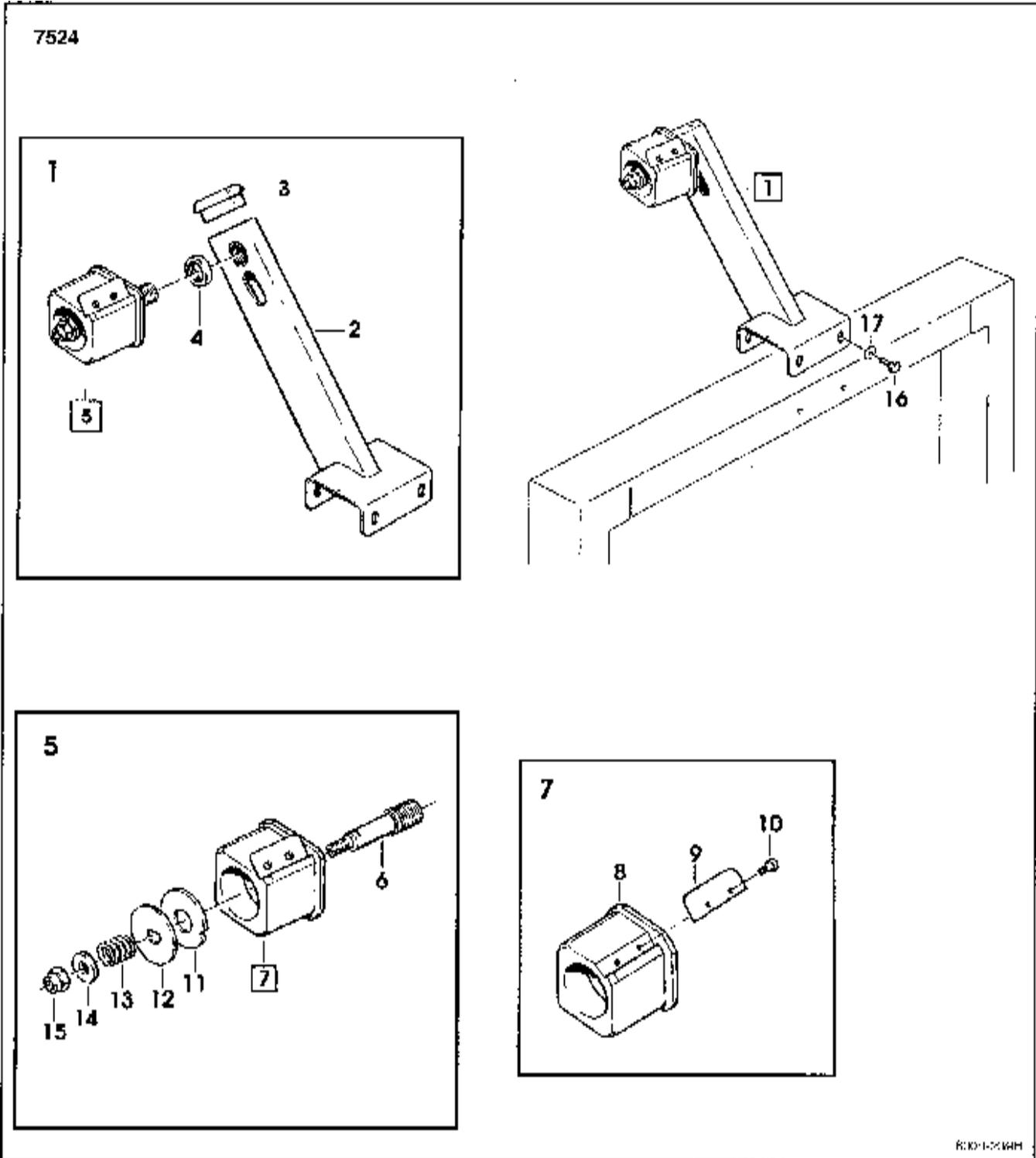


Figure 7-12. Upper Tape Drum Bracket Assembly

Parts List - Upper Tape Drum Bracket Assembly

Item Number	Part Number	Description	Qty
1	78-8094-6446-0	BRACKET ASSEMBLY, Core Holder	1
2	78-8091-0605-3	BRACKET, Core Holder	1
3	78-8070-1568-6	CAP, Bracket	1
4	78-8017-9169-6	NUT, M18 x 1	1
5	78-8060-8474-1	TAPE DRUM ASSEMBLY, 2-inch Head	1
6	78-8076-4519-3	SHAFT, Tape Drum	1
7	78-8070-1569-4	TAPE DRUM ASSEMBLY, 2-inch Wide	1
8	78-8052-6749-5	TAPE DRUM	1
9	78-8052-6268-6	LEAF SPRING	1
10	26-1002-5753-9	SCREW, Self Tapping	2
11	78-8060-8172-1	WASHER, Friction	1
12	78-8052-6271-0	WASHER, Tape Drum	1
13	78-8100-1048-4	SPRING, Core Holder	1
14	78-8052-6566-3	WASHER, Friction	1
15	78-8017-9077-1	NUT, Self-Locking, M10 x 1	1
16	78-8032-0375-7	SCREW, Metric, Hex Hd., M6 x 16	4
17	26-1000-0010-3	WASHER, Flat, M6	4

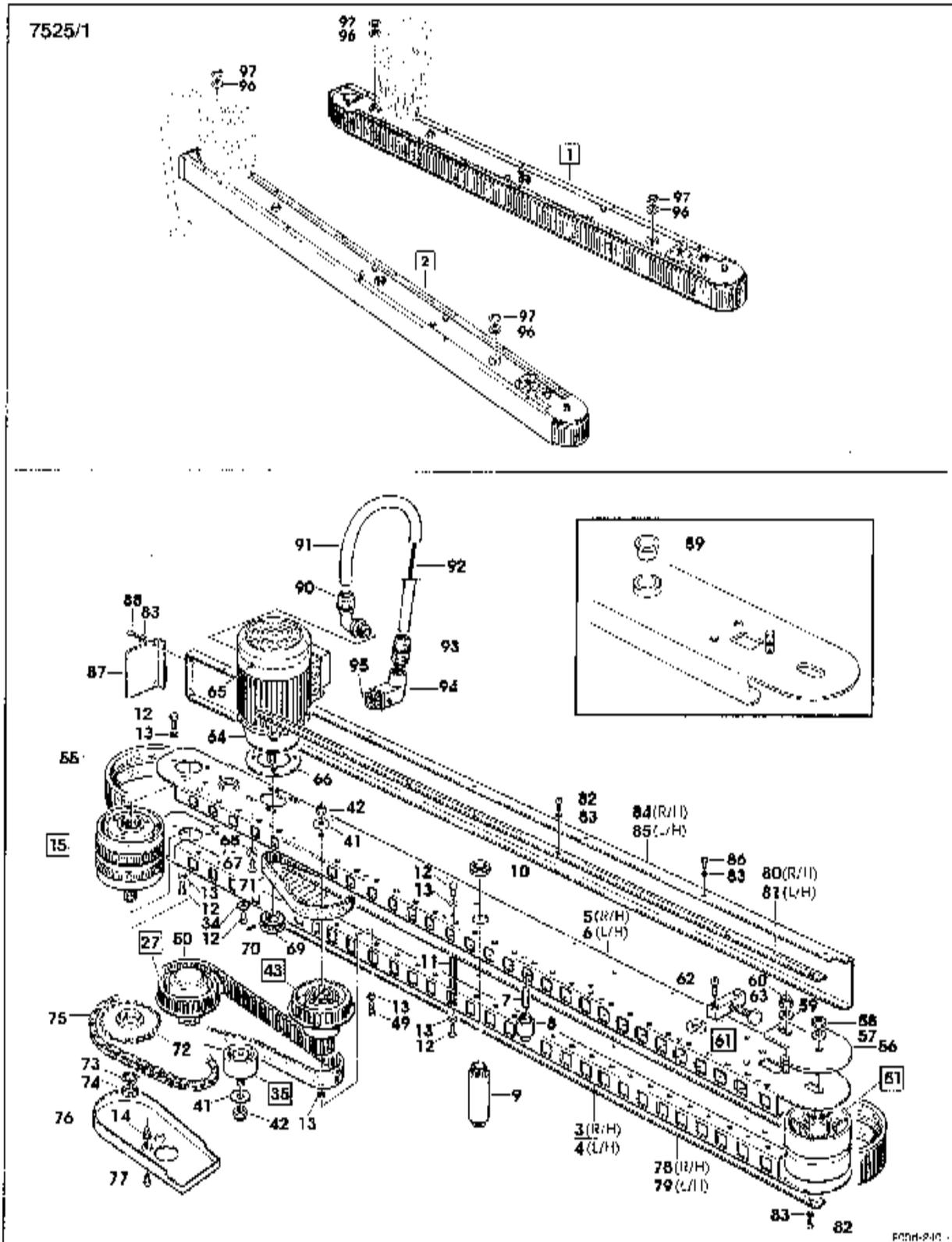


Figure 7-13. Side Belt and Drive Assemblies

Parts List - Side Belt and Drive Assemblies

Item Number	Part Number	Description	Qty
1	78-8119-8513-0	DRIVE ASSEMBLY, Side, Right, w/o Motor	1
2	78-8119-8514-8	DRIVE ASSEMBLY, Side, Left, w/o Motor	1
3	78-8119-8515-5	GUIDE, Lower, Right	1
4	78-8119-8516-3	GUIDE, Lower, Left	1
5	78-8122-6723-1	GUIDE, Upper, Right w/English Label	1
6	78-8122-6724-9	GUIDE, Upper, Left w/English Label	1
7	78-8060-7995-6	PIN, Roller	112
8	78-8060-7996-4	ROLLER	112
9	78-8060-7728-1	SLEEVE, Threaded	2
10	78-8076-5104-3	NUT, Special, M22 x 1.5, H/8	4
11	78-8054-8910-7	SPACER, Hexagonal	16
12	78-8010-7169-3	SCREW, Metric, Hex Hd., M6 x 12	46
13	26-1000-0010-3	WASHER, Flat, M6	48
14	78-8054-8891-9	SCREW, Special	4
15	78-8060-8000-4	DRIVE PULLEY ASSEMBLY	2
27	78-8060-8003-8	DRIVE PULLEY ASSEMBLY, Keyed	2
34	78-8042-2919-9	WASHER, Triple, M6	6
35	78-8060-8006-1	JOCKEY PULLEY ASSEMBLY	2
41	26-1004-5507-5	WASHER, M8	4
42	78-8017-9313-0	NUT, Self-Locking, M8, Nick. Pl.	4
43	78-8060-8011-1	WRAP PULLEY ASSEMBLY	2
49	78-8032-0375-7	SCREW, Metric, Hex Hd., M6 x 16	2
50	78-8060-8013-7	BELT, Timing, 210 L 075	2
51	78-8060-8014-5	IDLER ROLLER ASSEMBLY	2
55	78-8054-8841-4	DRIVE BELT, 12AF	2
56	78-8091-0761-4	PLATE, Tensioning Belt	4
57	78-8017-9318-9	WASHER, Plain, Metric, 8mm	4
58	26-1003-6904-5	NUT, Hex, M8	4
59	78-8052-6566-3	WASHER, Friction	4
60	26-1003-6918-5	NUT, Plastic Insert, M10 Hex	4
61	78-8054-8903-2	BLOCK, Belt	4
62	78-8010-7210-5	SCREW, Soc. Hd., Hex Soc., M6 x 20	8
63	78-8054-8904-0	SCREW, Belt Adjustment	4

Parts List - Side Belt and Drive Assemblies (Continued)

Item Number	Part Number	Description	Qty
64	78-8094-6472-6	MOTOR, 200/220V, 50/60Hz	2
65	78-8076-5226-4	FAN, Motor, F.63	2
66	78-8094-6050-0	SPACER, Motor	2
67	26-1005-4757-4	SCREW, Flat Hd., Soc. Dr., M5 x 20	8
68	78-8060-8073-1	WASHER, Motor	8
69	78-8060-8015-2	PULLEY, 17 x L050	2
70	26-1003-8816-9	SCREW, Set, M5 x 6	2
71	78-8060-8016-0	BELT, Timing, 190 x L050	2
72	78-8060-8019-4	SPROCKET, 3/8-inch, 28 Teeth	2
73	78-8057-5834-5	TAB WASHER	2
74	78-8057-5835-2	WASHER, Centering	2
75	78-8060-8020-2	CHAIN, 3/8-inch Pitch, L=50	2
76	78-8076-5112-6	COVER, Chain	2
77	26-1003-7948-1	SCREW, Soc. Hd., Hex Soc., M5 x 10	4
78	78-8119-8519-7	PLATE, Roller Stop, Lower, Right	1
79	78-8119-8520-5	PLATE, Roller Stop, Lower, Left	1
80	78-8119-8521-3	PLATE, Roller Stop, Upper, Right	1
81	78-8119-8522-1	PLATE, Roller Stop, Upper, Left	1
82	78-8017-9257-9	SCREW, Phillip Head, M4 x 10	32
83	78-8005-5740-3	WASHER, Plain, Metric, 4mm Nick.	42
84	78-8119-8523-9	COVER, Drive, Right	1
85	78-8119-8524-7	COVER, Drive, Left	1
86	26-1002-5753-9	SCREW, Self Tapping	12
87	78-8114-4787-5	GUARD, Belt	2
88	26-1002-4955-1	SCREW, Self Tap, 8P x 13	4
89	78-8114-4878-2	BUSHING	8
90	78-8076-5113-4	UNION	2
91	78-8060-8181-2	SLEEVING, 0.710 Mt.	2
92	78-8060-8052-5	CABLE, 4 x 1.5 Mt. 3PH	1
93	78-8060-7626-7	CONNECTOR	2
94	78-8060-7874-3	PLUG HOUSING, Lateral	2
95	78-8060-7875-0	PLUG, Male	2
96	78-8060-7541-8	WASHER	4
97	78-8060-7533-5	LOCK RING	4

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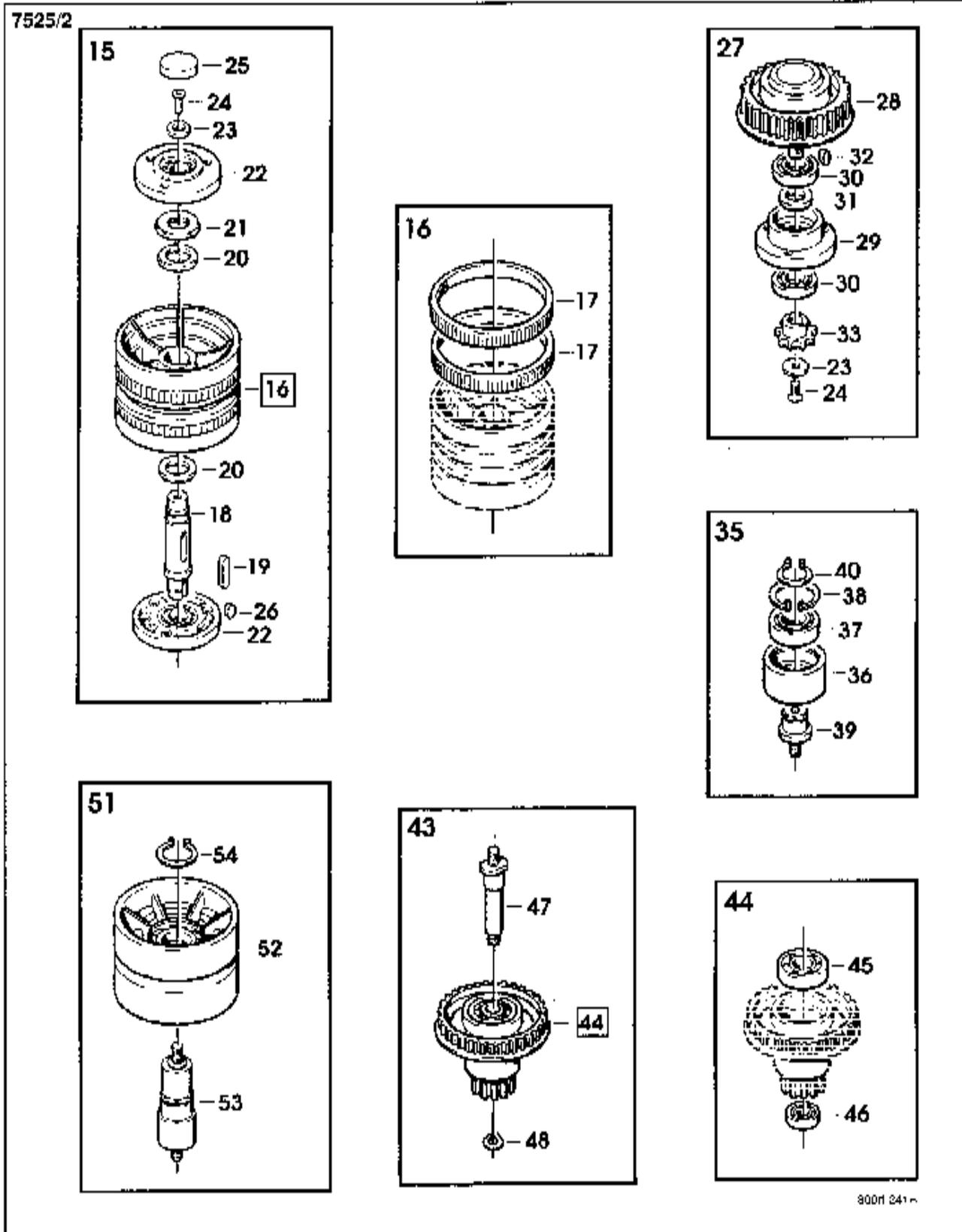


Figure 7-14. Side Belt Drive Pulleys (Detail)

Parts List - Side Belt Drive Pulleys (Detail)

Item Number	Part Number	Description	Qty
15	78-8060-8000-4	DRIVE PULLEY ASSEMBLY	2
16	78-8076-5105-0	PULLEY ASSEMBLY, Drive	2
17	78-8052-6713-1	RING, Polyurethane	4
18	78-8054-8878-6	SHAFT, Pulley Keyed	2
19	78-8057-5739-6	KEY, M5 x 5 x 30mm	2
20	78-8054-8879-4	WASHER, 20, 5mm	4
21	78-8017-9096-1	NUT, Special, M18 x 1	2
22	78-8060-7648-1	BEARING, Flanged	4
23	78-8054-8877-8	WASHER, 5, 5/20 x 4	4
24	26-0001-5862-1	SCREW, Flat Hd. Soc., M5 x 12	4
25	78-8060-8037-6	CAP, Flange	2
26	78-8046-8135-7	KEY, 5 x 5, 12mm	2
27	78-8060-8003-8	DRIVE PULLEY ASSEMBLY, Keyed	2
28	78-8055-0825-2	PULLEY, Keyed	2
29	78-8054-8889-3	SUPPORT, Pulley, Keyed	2
30	26-1000-6036-2	BEARING, 6003, 2RS	4
31	78-8060-7547-5	SPACER	2
32	78-8028-8244-5	KEY, 4 x 4 x 10mm	2
33	78-8060-8005-3	SPROCKET, 3/8-inch, 11 Teeth	2
35	78-8060-8006-1	JOCKEY PULLEY ASSEMBLY	2
36	78-8060-8009-5	JOCKEY PULLEY	2
37	78-8060-8008-7	BEARING, 6004 2RS	2
38	78-8060-8010-3	SNAP RING, 42mm Shaft	2
39	78-8060-8007-9	PIN, Jockey Pulley	2
40	78-8017-9061-5	SNAP RING, 20mm Shaft	2
43	78-8060-8011-1	WRAP PULLEY ASSEMBLY	2
44	78-8076-5106-8	PULLEY ASSEMBLY, Idler	2
45	78-8023-2544-5	BEARING, 6203, 2RS	2
46	78-8023-2410-9	BEARING, 6000, 2RS	2
47	78-8054-8887-7	SHAFT, Pulley Wrap	2
48	78-8016-5855-6	E-RING, 10mm	2
51	78-8060-8014-5	IDLER ROLLER ASSEMBLY	2
52	78-8052-6710-7	ROLLER, Idler	2
53	78-8054-8913-1	SHAFT, Roller	2
54	12-7997-0272-0	E-RING, M-25	2

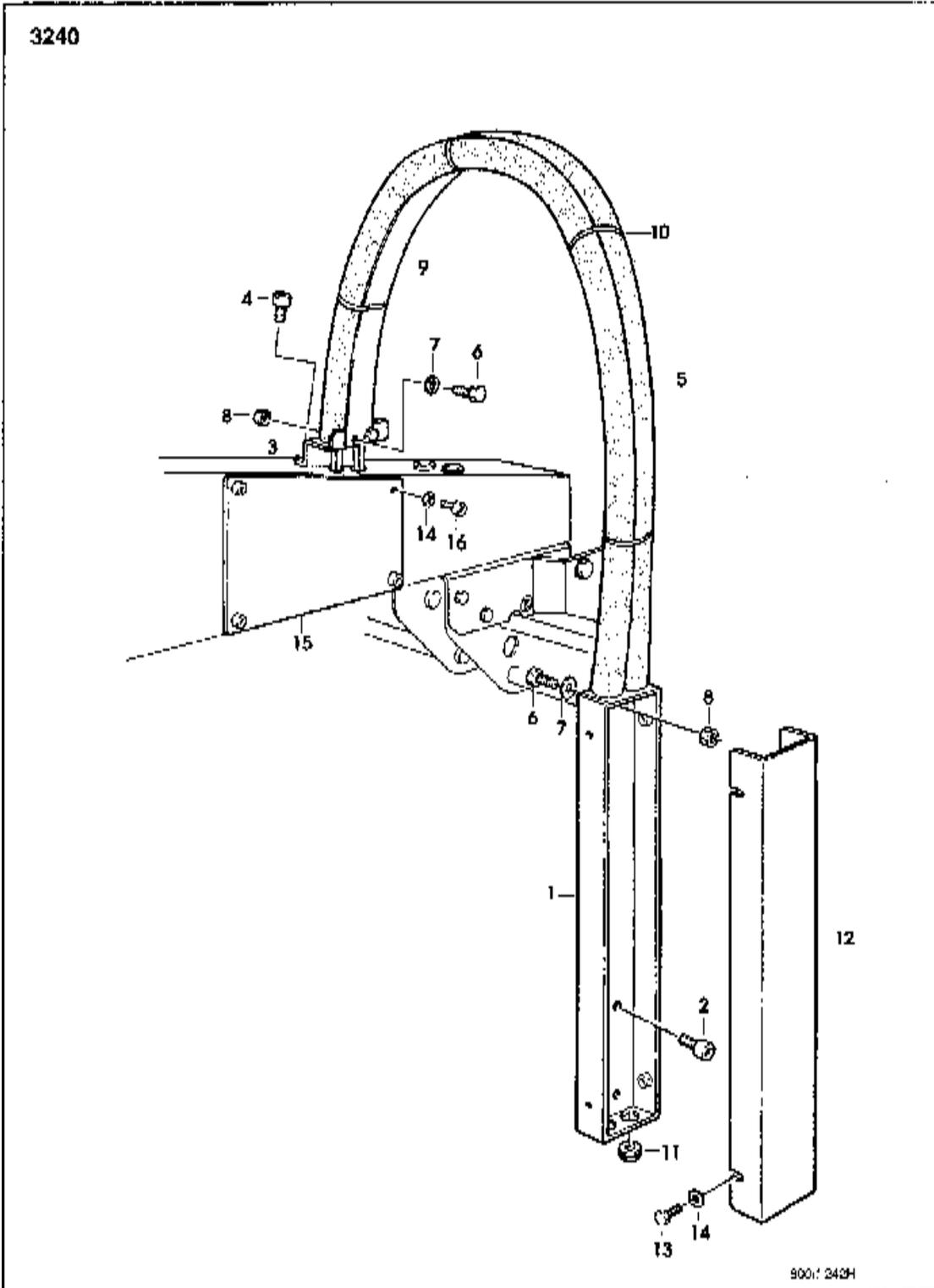


Figure 7-15. Upper Head Conduit Assembly

Parts List - Upper Head Conduit Assembly

Item Number	Part Number	Description	Qty
1	78-8100-0897-5	HOUSING, Wire	1
2	26-1003-7963-0	SCREW, Soc. Hd., M8 x 16	2
3	78-8060-7757-0	PLATE, Strap	1
4	78-8060-7896-6	SCREW, Soc. Hd., Hex Hd., M6 x 14	2
5	78-8076-5116-7	SLEEVING/22, 1.11 M.	2
6	78-8010-7163-6	SCREW, Metric, Hex Hd, M5 x 10	4
7	78-8005-5741-1	WASHER, Flat, M5	6
8	78-8010-7417-6	NUT, Metric, Hex Stl., M5	4
9	78-8076-5117-5	STRAP, Wire	1
10	78-8060-7632-5	CLAMP	5
11	78-8060-7785-1	GROMMET	1
12	78-8076-5118-3	COVER, Channel	1
13	26-1003-5810-5	SCREW, Hex Hd., M4 x 8	4
14	78-8005-5740-3	WASHER, Plain, Metric, 4mm, Nick.	8
15	78-8076-5119-1	COVER	1
16	26-1003-7943-2	SCREW, Soc. Hd., M4 x 12	4

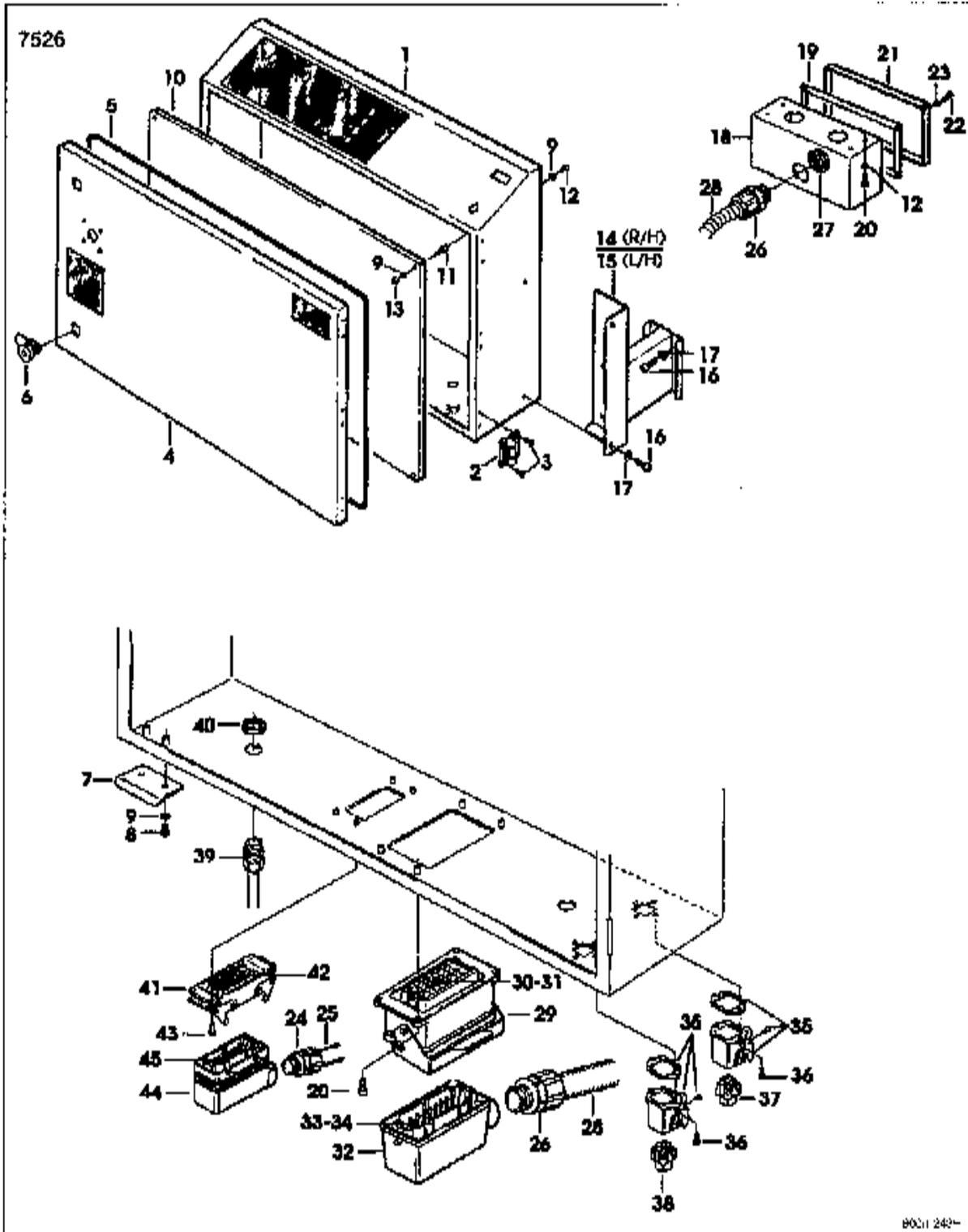


Figure 7-16. Electrical Control Panel

Parts List - Electrical Control Panel

Item Number	Part Number	Description	Qty
1	78-8122-6719-9	BOX, Electric w/English Label	1
2	78-8119-8591-6	HINGE, Southco E6, 10, 501, 20	3
3	78-8100-1165-6	SCREW, Phillips Hd., M6 x 16	12
4	78-8122-6720-7	COVER, Electrical Box w/English Label	1
5	78-8119-8548-6	FOAM RUBBER	2,8
6	78-8119-8549-4	LOCK, "Southco"	2
7	78-8119-8592-4	PLATE, Support	1
8	78-8032-0375-7	SCREW, Metric, Hex Hd., M6 x 16	2
9	26-1000-0010-3	WASHER, Flat, M6	14
10	78-8119-8550-2	PANEL, Electric Box	1
11	78-8060-7814-9	SPACER, Electric Box	4
12	78-8010-7169-3	SCREW, Metric, Hex Hd., M6 x 12	4
13	26-1003-6916-9	NUT, Locking, Plastic Insert, M6	4
14	78-8119-8551-0	BRACKET, Electrical Board, Right	1
15	78-8119-8552-8	BRACKET, Electrical Board, Left	1
16	26-1003-7964-8	SCREW, Soc. Hd., Hex Soc. Dr., M8 x20	12
17	78-8017-9318-9	WASHER, Plain, Metric, 8mm	12
18	78-8119-8553-6	SHUNTING BOX	1
19	78-8119-8554-4	ADHESIVE RUBBER SEAL	0,8
20	26-1003-7957-2	SCREW, Soc. Hd., Hex Hd., M6 x 16	8
21	78-8119-8555-1	SHUNTING BOX COVER	1
22	78-8060-8087-1	SCREW, Metric, M5 x 10	4
23	78-8005-5741-1	WASHER, Flat, M5	4
24	78-8119-8556-9	CONNECTOR	1
25	78-8076-5116-7	SLEEVING, 22,1,11 M.	1
26	78-8119-8558-5	CONNECTOR, Straight For Sleeve	2
27	78-8119-8559-3	NUT, PG36 Connector	1
28	78-8119-8560-1	SLEEVE, 40 (MM. 1000)	1
29	78-8076-5121-7	CASE	1
30	78-8076-5214-0	TAP, CNE 24FP, Grey	1
31	78-8076-5215-7	TAP, 24FPN, Black	1
32	78-8076-5213-2	HOUSING, Plug	1
33	78-8076-5122-5	PLUG, CNE 24FS	1

Parts List - Electrical Control Panel (Continued)

Item Number	Part Number	Description	Qty
34	78-8076-5123-3	PLUG, CNE 24FSN	1
35	78-8060-7872-7	COVER, Plug Straight	2
36	78-8028-8208-0	SCREW, 6P x 9,5	4
37	78-8060-7873-5	PLUG, Female	1
38	78-8060-7592-1	SOCKET	1
39	78-8076-4715-7	CORD GRIP	1
40	78-8076-5211-6	SET NUT GMP13.5	1
41	78-8119-8689-8	HOUSING, Tap CN16-I	1
42	78-8119-8690-6	TAP, 16 Poles	1
43	78-8032-0379-9	SCREW, Soc. Hd., Hex Hd., M4 x 16	4
44	78-8119-8691-4	HOUSING, Plug	1
45	78-8119-8692-2	PLUG, 16 Poles	1

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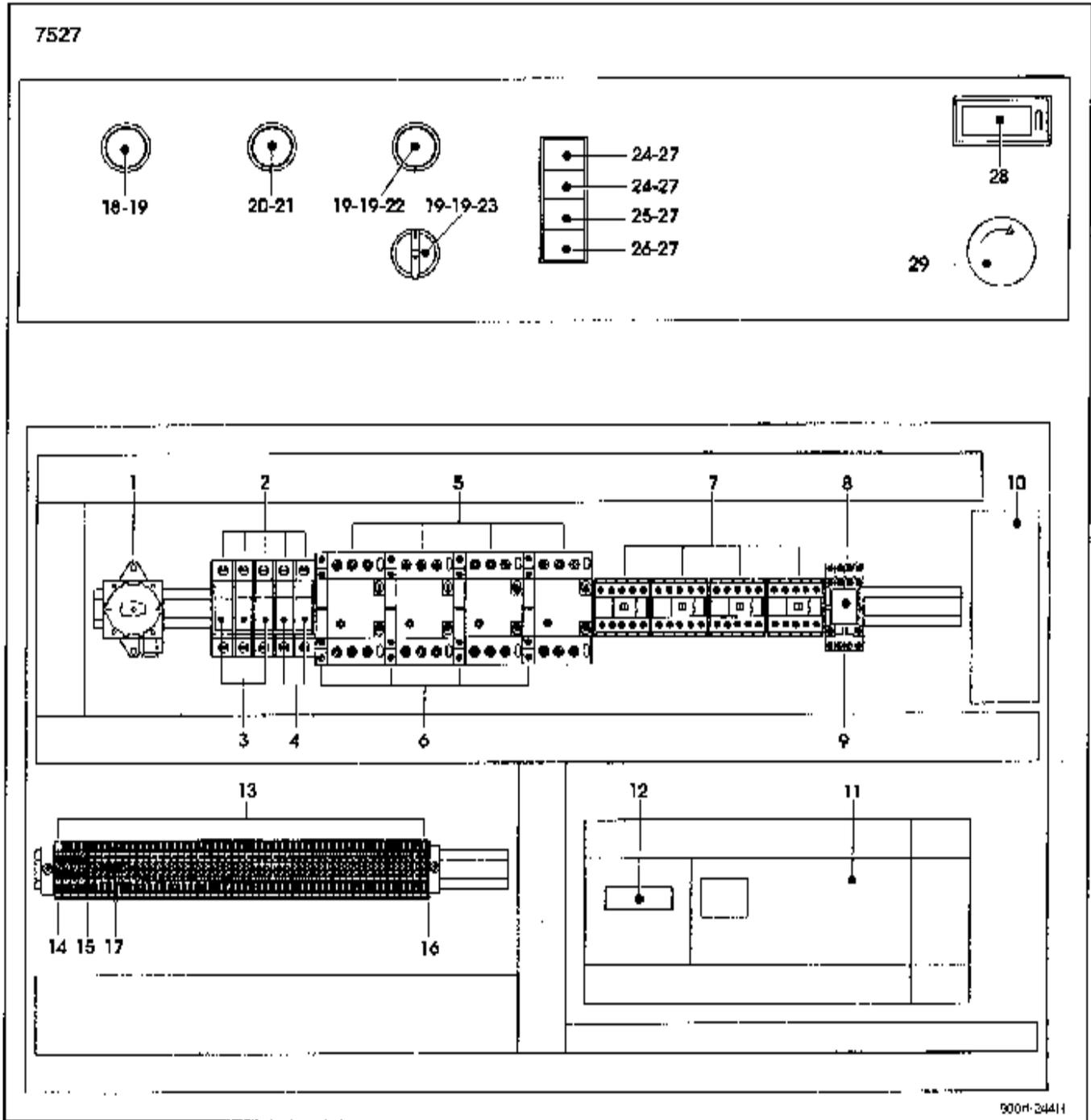


Figure 7-17. Electrical Control Panel (Detail)

Parts List - Electrical Control Panel (Detail)

Item Number	Part Number	Description	Qty
1	78-8100-0898-3	SWITCH ASSEMBLY, LA2-16	1
2	78-8060-7622-6	FUSE CARRIER	5
3	78-8091-0471-0	FUSE, 10.3 x 38, 10 A	3
4	78-8060-7624-2	FUSE, 4 A, 10.3 x 38	2
5	78-8076-5223-1	SWITCH, Thermal, Allen-Bradley, KTA 3-25	4
6	78-8076-5224-9	CONTACT, Allen-Bradley, KT 3, 25, PA, 11	4
7	78-8076-5222-3	SWITCH, Sprecher + Schuh, CA4, 5C, 10, 24V, CC	4
8	78-8119-8593-2	RELAY, MG4, 24VAC	1
9	78-8076-5220-7	BASE AMG4	1
10	26-1014-6252-6	DC POWER SUPPLY, OMRON	1
11	26-1014-6253-4	Allen-Bradley, PLC Type SCL500, 1747, L40F	1
12	78-8119-8594-0	UV-PROM, 1747, M3	1
13	78-8091-0412-4	TERMINAL, VU 4-2.5	53
14	78-8091-0414-0	TERMINAL, VUPE 4-4	1
15	78-8091-0413-2	PLATE, VT 4, 2.5/4	1
16	78-8091-0411-6	PLATE, VA 4, 2.5/4	1
17	78-8119-8595-7	BRIDGE	0,2
18	78-8119-8596-5	PUSH BUTTON, Sprecher + Schuh, Green, 800EP-F3	1
19	78-8076-5230-6	CONTACT, Sprecher + Schuh, DE3-10	5
20	78-8119-8597-3	PUSH BUTTON, Sprecher + Schuh, Black, 800EP-F2	1
21	78-8076-5195-1	CONTACT, Sprecher + Schuh, DE 3-01	1
22	78-8119-8598-1	PUSH BUTTON, Sprecher + Schuh, Blue, 800EP-F6	1
23	78-8119-8599-9	SELECTOR, Dsk 3LD	1
24	78-8119-8600-5	LIGHT, Warning, Red, 800EQ-PM4D0	2
25	78-8119-8601-3	LIGHT, Warning, Green, 800EQ, PM3D0	1
26	78-8119-8602-1	LIGHT, Warning, Transparent, 800EQ, PM7D0	1
27	78-8119-8603-9	LIGHT, BA, 9S, 36 VAC	4
28	78-8119-8604-7	COUNTER, H7GP, CD	1
29	78-8094-6385-0	E-STOP, 800EP, MTS643LX01	1

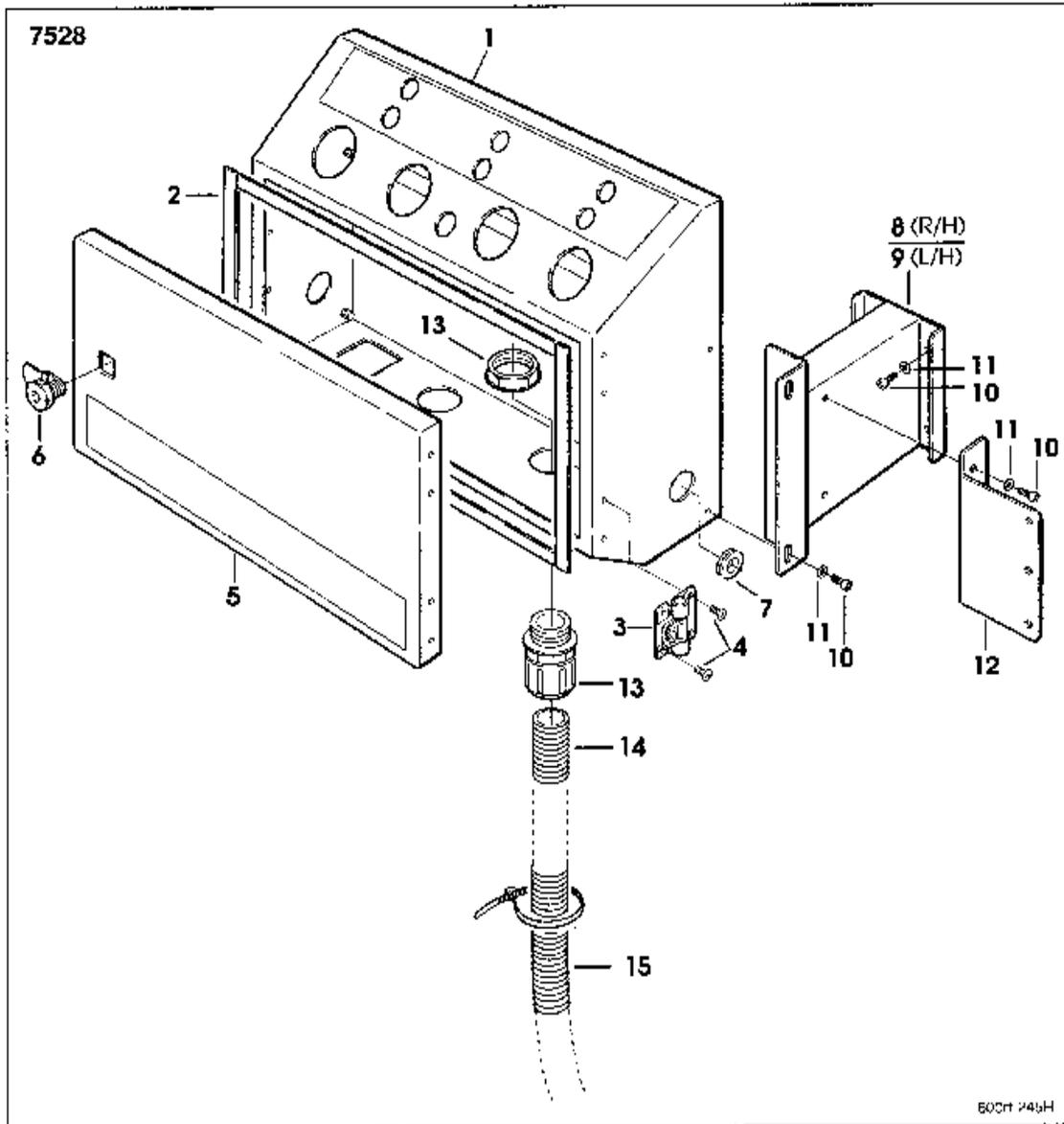


Figure 7-18. Pneumatic Control Panel

Parts List - Pneumatic Control Panel

Item Number	Part Number	Description	Qty
1	78-8122-6721-5	BOX, Pneumatics w/English Label	1
2	78-8119-8554-4	ADHESIVE, Rubber Seal	1,35
3	78-8119-8591-6	HINGE, Southco, E6, 10, 501, 20	2
4	78-8100-1165-6	SCREW, Phillips Hd., M6 X 16	8
5	78-8122-6722-3	BOX COVER, Pneumatics w/English Label.	1
6	78-8119-8549-4	LOCK, "Southco"	1
7	78-8119-8672-4	GROMMET, EZ-DG21	2
8	78-8119-8563-5	BRACKET, Pneumatic Board, Right	1
9	78-8119-8564-3	BRACKET, Pneumatic Board, Left	1
10	26-1003-7964-8	SCREW, Soc. Hd., Hex Soc. Dr., M8 x 20	14
11	78-8017-9318-9	WASHER, Plain, Metric, 8mm	14
12	78-8119-8565-0	BRACKET, Support Guards	1
13	78-8076-5124-1	UNION, 1.1/4-inch Gas	2
14	78-8119-8566-8	SLEEVE/35 (MM. 3000)	1
15	78-8119-8567-6	CLAMP MM. 4.8 x 292	4

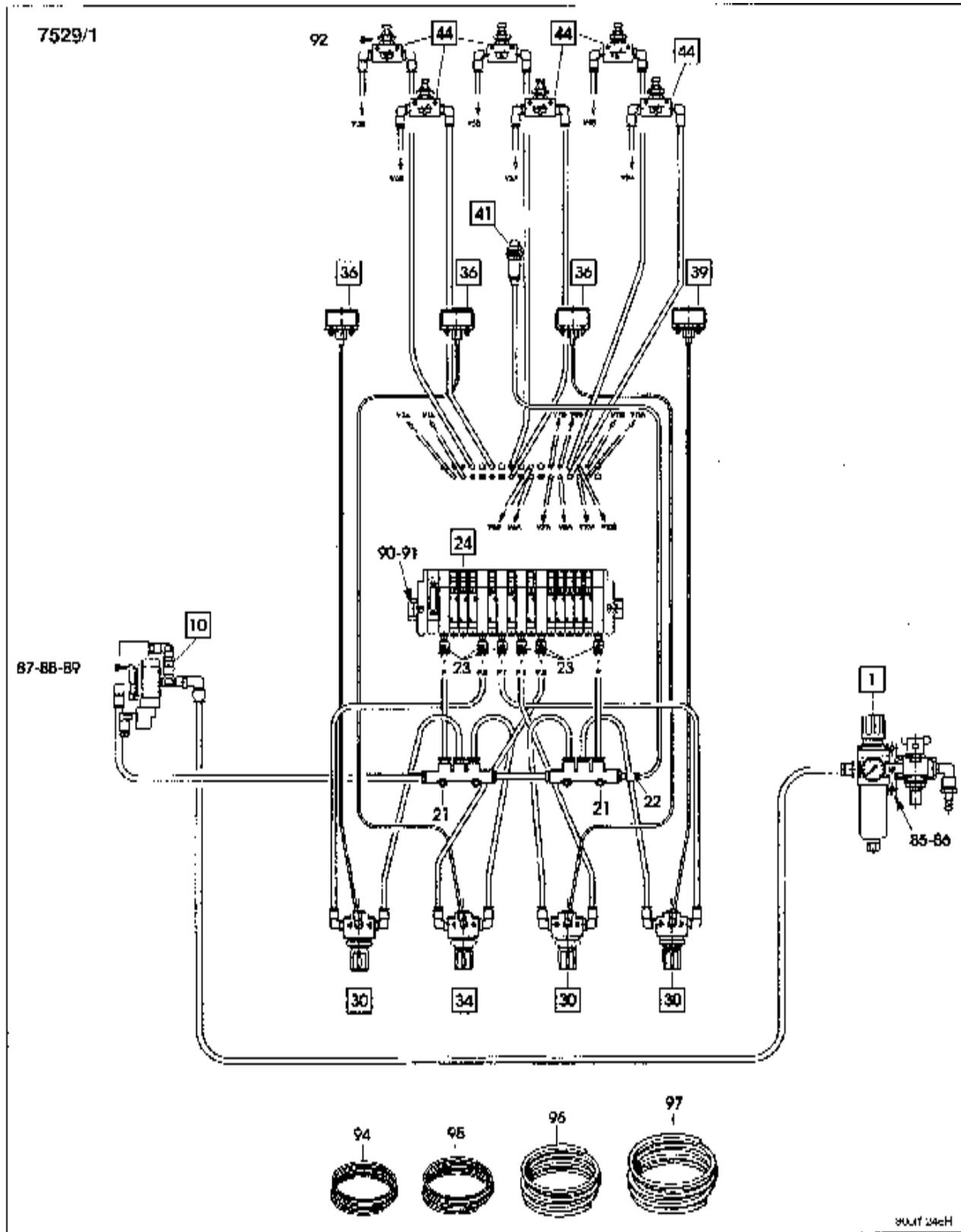


Figure 7-19. Pneumatic Components, #1

Parts List - Pneumatic Components, #1

Item Number	Part Number	Description	Qty
1	78-8119-8605-4	FILTER/REGULATOR ASSEMBLY	1
10	78-8119-8612-0	SOLENOID VALVE ASSEMBLY	1
21	78-8119-8618-7	UNION, Multiple, 33041008	2
22	78-8119-8619-5	REDUCER, 31660610	1
23	78-8119-8620-3	REDUCER, 31660810	6
24	78-8119-8621-1	SOLENOID VALVE ASSEMBLY, VQ2000	1
30	78-8119-8626-0	PRESSURE REGULATOR ASSEMBLY	3
34	78-8119-8629-4	PRESSURE REGULATOR ASSEMBLY	1
36	78-8119-8631-0	GAGE ASSEMBLY, 0-12 Bar	3
39	78-8119-8634-4	GAGE ASSEMBLY, 0-4 Bar	1
41	78-8119-8636-9	INDICATOR ASSEMBLY	1
44	78-8119-8637-7	FLOW REGULATOR ASSEMBLY	6
85	26-1003-7951-5	SCREW, Soc. Hd., Hex Soc., M5 x 20	2
86	78-8028-8214-8	WASHER	2
87	78-8017-9257-9	SCREW, Phillips Head, M4 x 10	2
88	78-8005-5740-3	WASHER, Plain, Metric, 4mm, Nick.	2
89	78-8010-7416-8	NUT, Metric, Hex, Steel, M4	2
90	78-8060-8087-1	SCREW, Metric, M5 x 10	2
91	78-8005-5741-1	WASHER, Flat, M5	2
92	78-8076-5165-4	SPACER	6
94	78-8119-8666-6	TUBE, Air, TU0425B, 5MT	3
95	78-8119-8667-4	TUBE, Air, TU0604B, 5MT	16
96	78-8119-8668-2	TUBE, Air, TU0805B, 5MT	16
97	78-8119-8669-0	TUBE, Air, TU1065B, 5MT	1

Parts List - Pneumatic Components, #2

Item Number	Part Number	Description	Qty
47	78-8091-0350-6	UNION, Special	8
48	78-8076-4666-2	ELBOW, Bulkhead	10
49	78-8119-8639-3	UNION, Elbow, 31820800	8
50	78-8119-8640-1	UNION, Elbow, 31820600	10
51	78-8057-5735-4	FITTING, Reducer	2
52	78-8094-6277-9	UNION, TE, 31040800	2
53	78-8057-6170-3	TEE, 6mm Tubing	2
54	78-8119-8641-9	COLUMN, Air Cylinder Assembly	2
58	78-8119-8643-5	COMPRESSION ROLLER, Air Cylinder Assembly	2
60	78-8119-8645-0	FLAP FOLD, Air Cylinder Assembly	1
64	78-8119-8649-2R	FLAP FOLD, Air Cylinder Assembly	1
67	78-8119-8652-6	EXHAUST VALVE ASSEMBLY	1
70	78-8119-8653-4	PADDLE, Air Cylinder Assembly	1
74	78-8119-8656-7	BOX STOP, Air Cylinder Assembly	1
77	78-8119-8659-1	SIDE DRIVE, Air Cylinder Assembly	1
80	78-8119-8662-5	GATE, Air Cylinder Assembly	1
82	78-8119-8663-3	CENTERING, Air Cylinder Assembly	1
93	78-8119-8665-8	SCREW, Soc. Hd., Hex Hd., M6 x 50	8

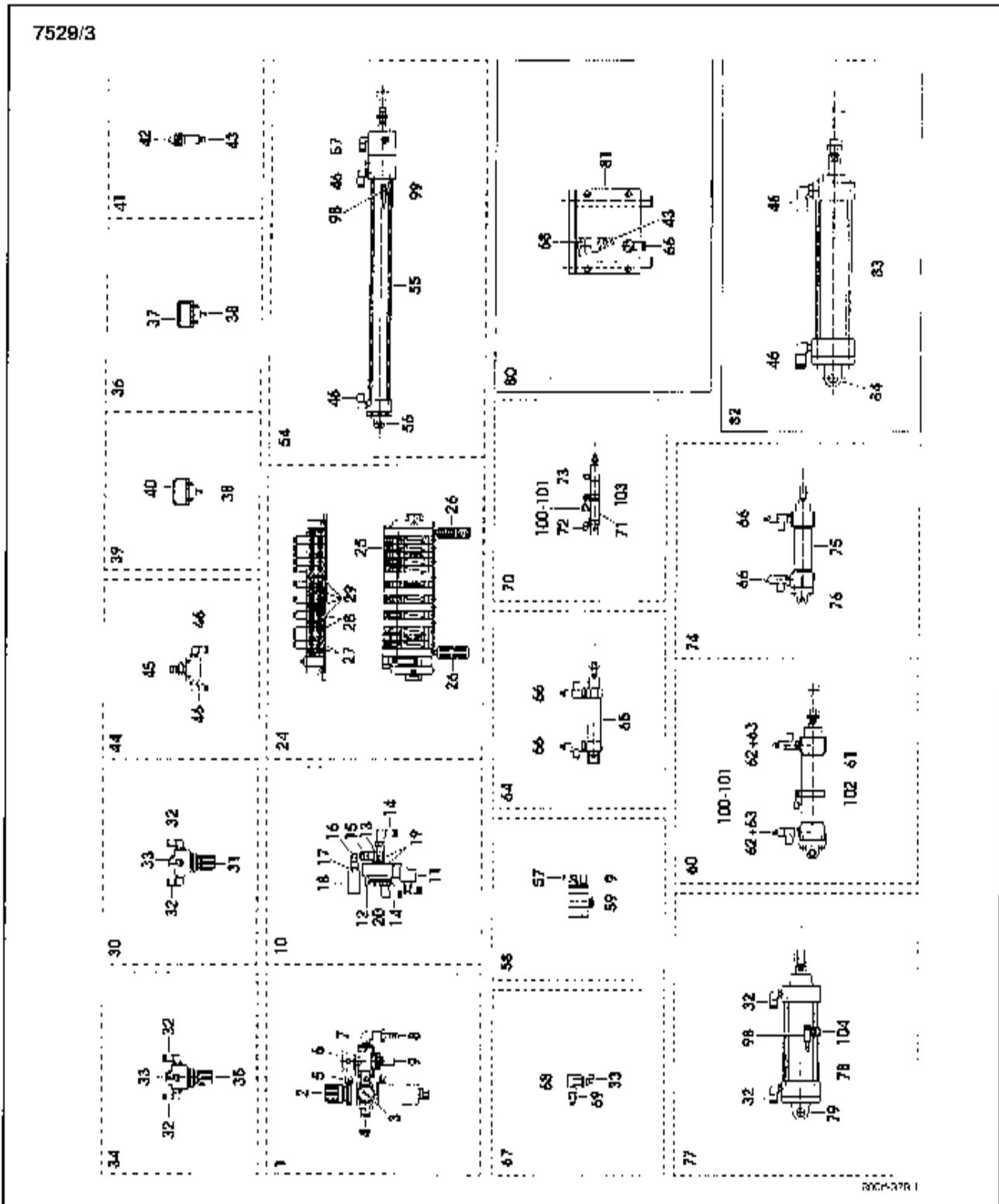


Figure 7-21. Pneumatic Components, #3

Parts List - Pneumatic Components, #3

Item Number	Part Number	Description	Qty
1	78-8119-8605-4	FILTER/REGULATOR ASSEMBLY	1
2	78-8119-8606-2	REGULATOR, Pressure, SMC, EAW3000	1
3	78-8054-8838-0	GAUGE, Air	1
4	78-8119-8607-0	UNION, 31011017	1
5	78-8119-8608-8	COUPLING, Y30T	1
6	78-8119-8609-6	VALVE, SMC, EVHS, 3500, F03, R, X116	1
7	78-8119-8610-4	UNION, Elbow, RA022, 3/8-inch, 3/8-inch	1
8	78-8119-8611-2	HOSE CONNECTOR, RA030, 3/8-inch	1
9	78-8076-4886-6	MUFFLER, 1/4-inch	3
10	78-8119-8612-0	SOLENOID VALVE ASSEMBLY	1
11	78-8119-8613-8	SOLENOID VALVE, SMC, SY7120, 5, Y0, 02F	1
12	78-8119-8614-6	BRACKET, SMC, SX7000, 16, 1A	1
13	78-8060-7753-9	ELBOW, T, MFF, RA, 025, 1/4-inch, 1/4-inch	1
14	78-8119-8615-3	UNION, Elbow, 31991013	2
15	78-8114-5012-2	REDUCTION, Conic	1
16	78-8060-7900-6	UNION	1
17	78-8094-6274-6	REDUCTION, RA 014, 1/4-inch, 1/8-inch	1
18	78-8094-6275-3	PRESSURE SWITCH, SMC, IS1000, F01 x 201	1
19	78-8119-8616-1	MUFFLER, SP 1/4-inch	2
20	78-8119-8617-9	CAP, 1/4-inch	1
24	78-8119-8621-1	SOLENOID VALVE ASSEMBLY, VQ2000	1
25	78-8119-8622-9	SOLENOID VALVE SET, SMC, SY5140	1
26	78-8119-8623-7	MUFFLER	2
27	78-8060-7861-0	END CAP	2
28	78-8119-8624-5	CAP, SMC, KQP-08	2
29	78-8119-8625-2	CAP, SMC, 31261000	4
30	78-8119-8626-0	PRESSURE REGULATOR ASSEMBLY	3
31	78-8119-8627-8	REGULATOR, Pressure SMC, EAR2500-F03	3
32	78-8119-8628-6	UNION, Elbow, 31990817	10
33	26-1005-5909-0	ELBOW	5
34	78-8119-8629-4	PRESSURE REGULATOR ASSEMBLY	1
35	78-8119-8630-2	REGULATOR, Pressure, SMC, EAR2500-0.2-2	1
36	78-8119-8631-0	GAUGE ASSEMBLY, 0-12 Bar	3

Parts List - Pneumatic Components, #3 (Continued)

Item Number	Part Number	Description	Qty
37	78-8119-8632-8	GAUGE, 50, 0-12 Bar	3
38	78-8119-8633-6	UNION, 31140413	4
39	78-8119-8634-4	GAUGE ASSEMBLY, 0-4 Bar	1
40	78-8119-8635-1	GAUGE, 50, 0-4 Bar	1
41	78-8119-8636-9	INDICATOR ASSEMBLY	1
42	78-8076-4665-4	INDICATOR, Visual	1
43	26-1005-6910-7	UNION, Straight	2
44	78-8119-8637-7	FLOW REGULATOR ASSEMBLY	6
45	78-8119-8638-5	REGULATOR, Flow, RFU-446-1/4-inch	6
46	78-8091-0315-9	ELBOW, 3199.08.13	18
54	78-8119-8641-9	COLUMN, Air Cylinder Assembly	2
55	78-8119-76428642-7	CYLINDER, Air, SMC, CNA LN40-450	2
56	78-8114-5009-3	HINGE, SMC, CD65D40	2
57	78-8055-0756-9	UNION, Rotating	4
58	78-8119-8643-5	COMPRESSOR, Air Cylinder Assembly	2
59	78-8119-8644-3	CYLINDER, Air, DN-50C, ECQ, 2B	2
60	78-8119-8645-0	FLAP FOLD, Air Cylinder Assembly	1
61	78-8119-8646-8	CYLINDER, SMC, Air, CD65, D40	1
62	78-8119-8647-6	UNION, 6610, 8, 1/4-inch	2
63	78-8119-8648-4	REGULATOR, SCU 606, 1/4-inch	2
64	78-8119-8649-2R	FLAP FOLD, Air Cylinder Assembly	1
65	78-8119-8650-0	CYLINDER, Air, SMC, CD85N25-60B	1
66	78-8119-8651-8	REGULATOR, Flow	5
67	78-8119-8652-6	EXHAUST VALVE ASSEMBLY	1
68	78-8013-9935-9	VALVE, Quick Exhaust	2
69	78-8076-4672-0	UNION, Straight, Female	1
70	78-8119-8653-4	PADDLE, Air Cylinder Assembly	1
71	78-8119-8654-2	CYLINDER, Air SMC, CD85N16, 50B+BJ2-016+DC73L	1
72	78-8057-5732-1	FITTING, Elbow	1
73	78-8119-8655-9	UNION, 31010419	1
74	78-8119-8656-7	BOX STOP, Air Cylinder Assembly	1
75	78-8119-8657-5	CYLINDER, Air, SMC, C65D32-60C	1
76	78-8119-8658-3	HINGE, Cylinder, C65-D32	1

Parts List - Pneumatic Components, #3 (Continued)

Item Number	Part Number	Description	Qty
77	78-8119-8659-1	SIDE DRIVE, Air Cylinder Assembly	1
78	78-8119-8660-9	CYLINDER, Air, SMC, C95SD, B63, 100	1
79	78-8119-8661-7	HINGE, Female, D5063	1
80	78-8119-8662-5	GATE, Air Cylinder Assembly	1
81	78-8094-6294-4	CYLINDER, MGQM/40 Stroke 50	1
82	78-8119-8663-3	CENTERING, Air Cylinder Assembly	1
83	78-8119-8664-1	CYLINDER, Air, SMC, C92-40-170	1
84	78-8076-4908-8	HINGE	1
98	78-8094-6346-2	SWITCH, Limit 24V CC 5-5-D A53L	2
99	78-8094-6345-4	CLAMP KIT	1
100	78-8119-8693-0	SENSOR, D-C73C-75	2
101	78-8119-8694-8	CABLE, DLC 50	1
102	78-8119-8695-5	CLAMP, BM2-040	1
103	78-8119-8696-3	CLAMP, BJ2-016	1
104	78-8119-8697-1	MOUNTING, BT-105	1

Parts List - Sliding Door Assembly

Item Number	Part Number	Description	Qty
1	78-8119-8568-4	FRAME, Right, Guards	1
2	78-8119-8670-8	FRAME, Left, Guards	1
3	78-8119-8569-2	BRACKET, Support Guards	2
4	26-1003-7964-8	SCREW, Soc. Hd., Hex Soc. Dr., M8x 20	32
5	78-8017-9318-9	WASHER, Plain, Metric, 8mm	32
6	78-8119-8570-0	SUPPORT, Right, Guards	2
7	78-8119-8571-8	SUPPORT, Left, Guards	2
8	78-8119-8572-6	CROSSMEMBER ASSEMBLY, Guards	2
9	78-8119-8573-4	BRACKET, Winking Light	1
10	78-8119-8574-2	GUARD	4
11	78-8119-8575-9	SLIDE, Guard	16
12	78-8060-8087-1	SCREW, Metric, M5 x 10	40
13	78-8119-8671-6	HANDLE	4
14	78-8119-8576-7	BRACKET, Switch	4
15	26-1003-7957-2	SCREW, Soc. Hd., Hex Hd., M6 x 16	16
16	26-1000-0010-3	WASHER, Flat, M6	16
17	78-8119-8577-5	LONG BRACKET, Actuator	2
18	78-8119-8578-3	SHORT BRACKET, Actuator	2
19	26-1002-5824-8	SCREW, Hex Hd., M5 x 35	22
20	78-8028-8214-8	WASHER, Flat, M5	30
21	78-8119-8579-1	STOP	2
22	78-8010-7417-6	NUT, Metric, Hex Stl., M5	2
23	78-8076-4932-8	LOCK, Wing	4
24	78-8076-4931-0	DRAWBAR, Lock	4
25	26-1005-5316-8	SCREW, Flat Hd., Hex Dr., M5 x 16	24
26	78-8119-8580-9	FRONT BRACKET	2
27	78-8119-8581-7	REAR BRACKET	2
28	78-8119-8582-5	REAR BRACKET	2
29	78-8119-8583-3	SUPPORT, On/Off Button	1
30	78-8076-5194-4	BOX, E-Stop, Yellow	1
31	78-8094-6385-0	E-STOP, 800EP-MTS643LX01	1
32	83-0002-7336-3	SCREW, Hex Hd., M4 x 14 Zinc. Pl.	2
33	78-8005-5740-3	WASHER, Plain, Metric, 4mm Nick.	2

Parts List - Sliding Door Assembly (Continued)

Item Number	Part Number	Description	Qty
34	78-8010-7416-8	NUT, Metric, Hex, Steel, M4	2
35	78-8076-4532-6	CORD GRIP	9
36	78-8119-8585-8	BUSHING, Flanged, Lamp	1
37	78-8076-5104-3	SPECIAL NUT, M22 x 1, 5/8	1
38	78-8119-8586-6	LAMP ASSEMBLY	1
39	78-8119-8587-4	LAMP, BA15D, 5W, 30V	1
40	78-8119-8584-1	COVER, Upper Guards	3
41	78-8076-4929-4	SECURITY SWITCH, Berhstein, AZ15ZVR	4
42	78-8010-7165-1	SCREW, Flat Hd., Soc., M5 x 25	8
43	78-8119-8725-0	SPACER, Bumper	2

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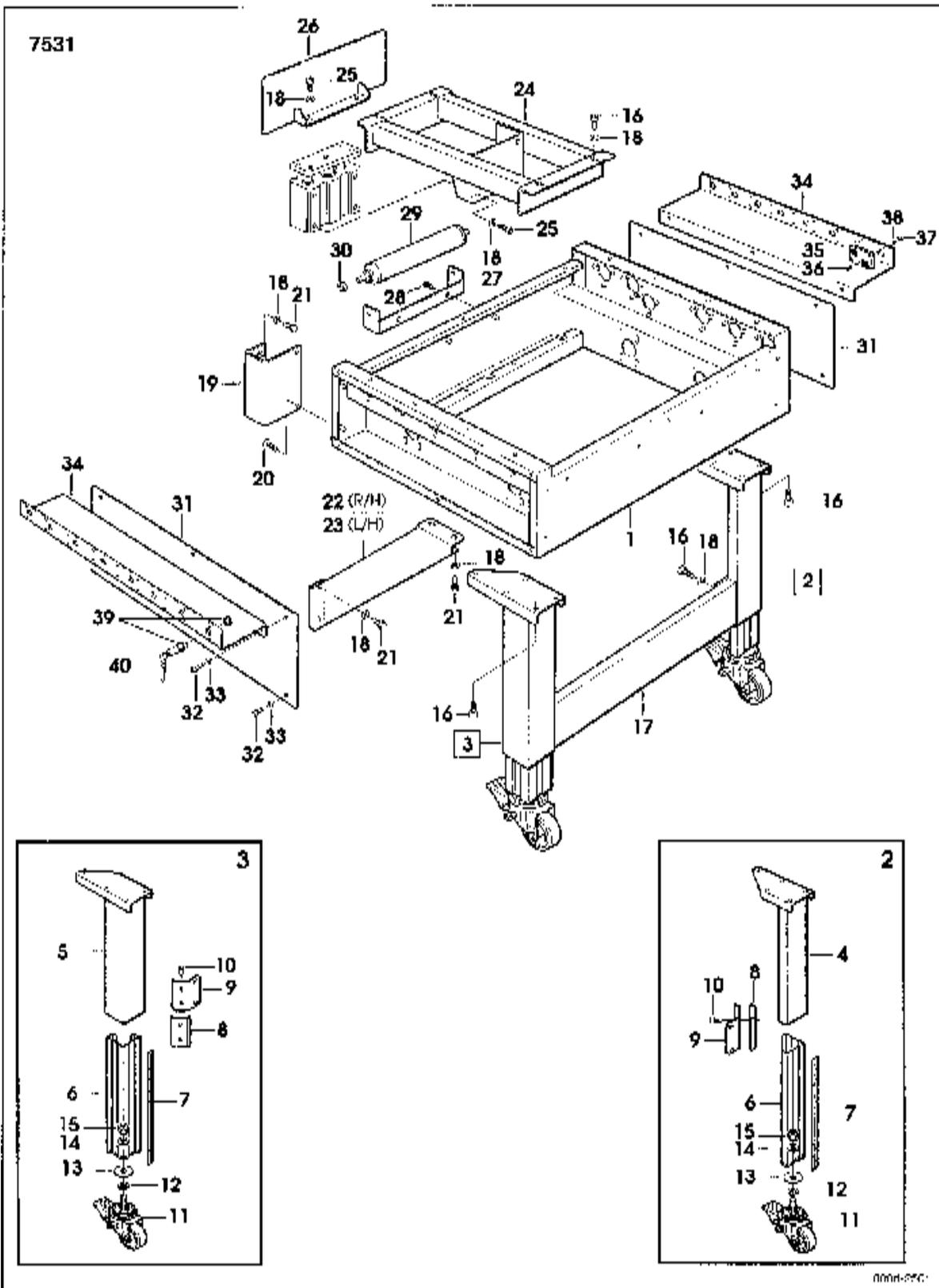


Figure 7-23. Infeed Conveyor Frame

Parts List - Infeed Conveyor Frame

Item Number	Part Number	Description	Qty
1	78-8114-4812-1	CONVEYER FRAME ASSEMBLY	1
2	78-8076-5338-7	LEG ASSEMBLY W/Caster, Right	1
3	78-8076-5337-9	LEG ASSEMBLY W/Caster, Left	1
4	78-8076-5040-9	LEG, Right	1
5	78-8076-5041-7	LEG, Left	1
6	78-8052-6678-6	LEG, Inner	2
7	78-8052-6080-2	LABEL, Height	2
8	78-8052-6677-8	CLAMP, Inner	2
9	78-8060-7697-8	BRACKET, Special	2
10	26-1003-7963-0	SCREW, Soc. Hd., M8 x 16	4
11	78-8060-8061-6	CASTER	2
12	78-8060-8124-2	SPACER, Caster	2
13	78-8060-7699-4	WASHER, /12-45, 5 x 4	2
14	78-8017-9059-9	WASHER, Flat for M12 Screw	2
15	78-8060-7532-7	NUT, M12, Self-Locking	2
16	26-1003-7964-8	SCREW, Soc. Hd., Hex Soc. Dr., M8 x 20	18
17	78-8114-4813-9	CROSS BAR, Leg	1
18	78-8017-9318-9	WASHER, Plain, Metric, 8mm	28
19	78-8114-4814-7	BRACKET	2
20	78-8054-8567-3	SCREW, Soc. Hd., Special	4
21	26-1003-5842-8	SCREW, Hex Hd., M8 x 20	12
22	78-8114-4815-4	REINFORCEMENT, Right	1
23	78-8114-4816-2	REINFORCEMENT, Left	1
24	78-8114-4817-0	SUPPORT, Gate	1
25	78-8114-4818-8	SCREW, Soc. Hd., Hex Hd., M8 x 14	8
26	78-8114-4819-6	GATE	1
27	78-8119-8738-3	SUPPORT, Roller	1
28	26-1003-5829-5	SCREW, Hex Hd., M6 x 12	2
29	78-8076-5349-4	ROLLER, /32 x 198	1
30	78-8052-6668-7	SNAP, Roller	1
31	78-8114-4822-0	COVER, Right/Left	2
32	78-8032-0382-3	SCREW, Soc. Hex Hd., M5 x 16, Zinc. Pl.	12
33	78-8005-5741-1	WASHER, Flat, M5	12

Parts List - Infeed Conveyor Frame (Continued)

Item Number	Part Number	Description	Qty
34	78-8114-4823-8	SUPPORT, Photocell/Reflector	2
35	78-8076-5057-3	REFLECTOR, E39-R1	3
36	78-8010-7157-8	SCREW, Hex Hd., M4 x 10	6
37	78-8010-7416-8	NUT, Metric, Hex, Steel, M4	6
38	78-8005-5740-3	WASHER, Plain, Metric, 4mm, Nick.	6
39	78-8114-4824-6	PHOTOCELL, E3F2, R2B4, P1, E	3
40	78-8114-4825-3	CONNECTOR, CS, A2, 02, S, 05	3

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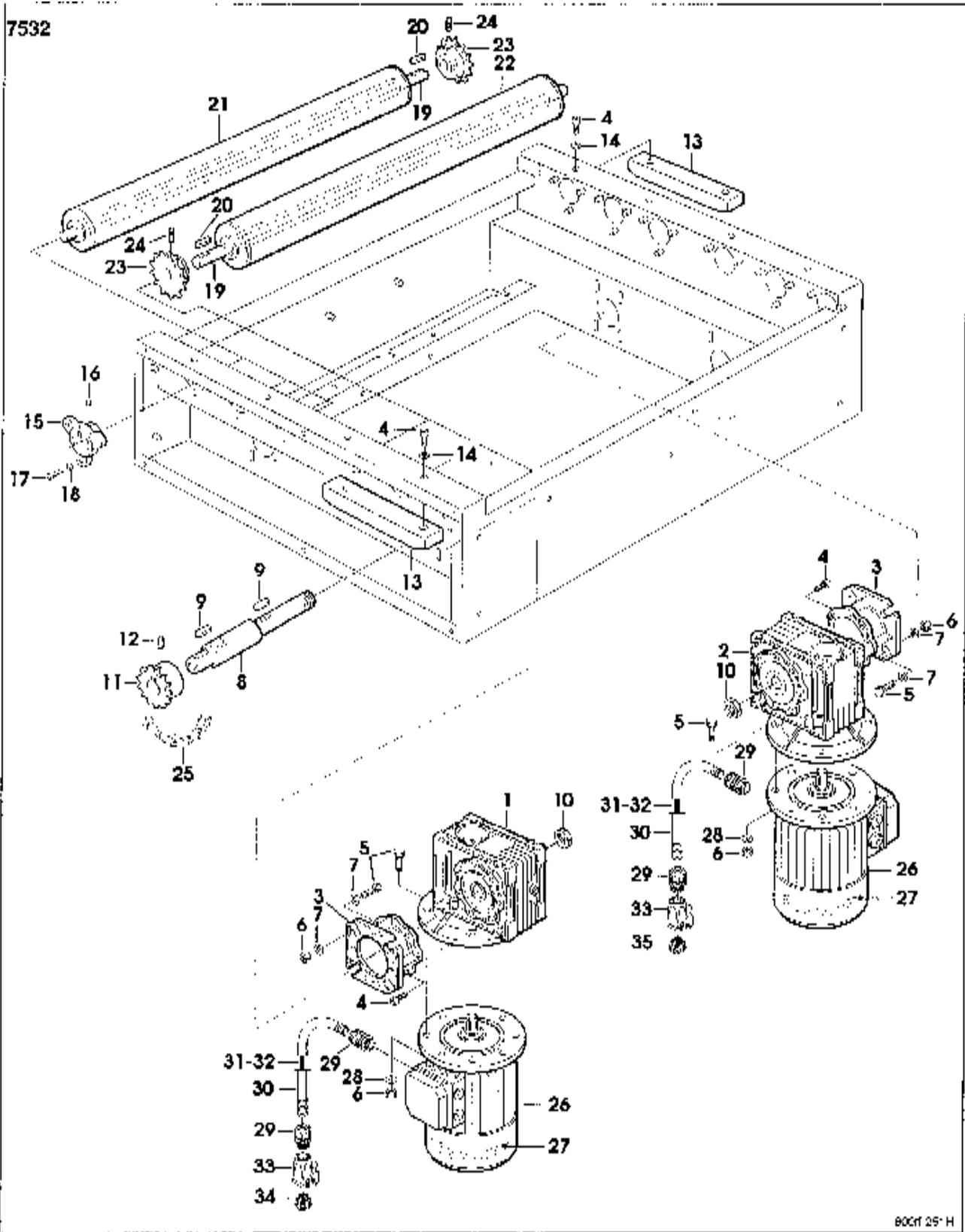


Figure 7-24. Infeed Conveyor Drive Assembly

Parts List - Infeed Conveyor Drive Assembly

Item Number	Part Number	Description	Qty
1	78-8114-4827-9	GEARBOX, NMRV40, i20, PAM63, B5	1
2	78-8114-4826-1	GEARBOX, NMRV40, i10, PAM63, B5	1
3	78-8114-4828-7	FLANGE, Gearbox	2
4	26-1003-7957-2	SCREW, Soc. Hd., Hex Hd., M6 x 16	12
5	78-8017-9301-5	SCREW, Hex Hd., M8 x 25	16
6	26-1003-6904-5	NUT, Hex, M8	16
7	78-8017-9318-9	WASHER, Plain, Metric, 8mm	16
8	78-8114-4829-5	SHAFT, Gearbox	2
9	78-8057-5811-3	KEY, 6 x 6 x 20 mm.	4
10	78-8017-9169-6	NUT, M18 x 1	2
11	78-8076-5366-8	SPROCKET, Z=16, 3/8-inch	2
12	78-8059-5617-0	SET SCREW, M6 x 8	2
13	78-8114-4830-3	SLIDE, Chain	2
14	26-1000-0010-3	WASHER, Flat, M6	4
15	78-8091-0736-6	FLANGE, Rollers	12
16	78-8091-0726-7	SET SCREW, M5 x 5	24
17	78-8032-0379-9	SCREW, Soc. Hd., Hex Hd., M4 x 16	36
18	78-8005-5740-3	WASHER, Plain, Metric, 4mm, Nick.	36
19	78-8114-5092-9	SHAFT, Sprocket	6
20	78-8059-5611-3	KEY	6
21	78-8114-4831-1	ROLLER ASSEMBLY	2
22	78-8114-4832-9	ROLLER ASSEMBLY, Gummed	4
23	78-8076-5370-0	SPROCKET, Z=17, 3/8-inch	6
24	78-8059-5613-9	SET SCREW, M5 x 14	6
25	78-8114-4833-7	CHAIN, 3/8-inch, 55 Pitch	2
26	78-8100-0865-2	MOTOR, 200/220V, 50/60Hz	2
27	78-8076-5372-6	FAN, Motor	2
28	78-8005-5736-1	LOCKWASHER, for M8 Screw	8
29	78-8060-7626-7	CONNECTOR	4
30	78-8114-4834-5	CONDUIT, /12, 3 Mt.	1
31	78-8114-4835-2	WIRE, AWG18, Black, 5 Mt.	2
32	78-8114-4836-0	WIRE, AWG16, Yellow/Green, 5 Mt.	1
33	78-8060-7877-6	PLUG HOUSING, Vertical	2
34	78-8060-7875-0	PLUG, Male	1
35	78-8060-7591-3	PLUG	1

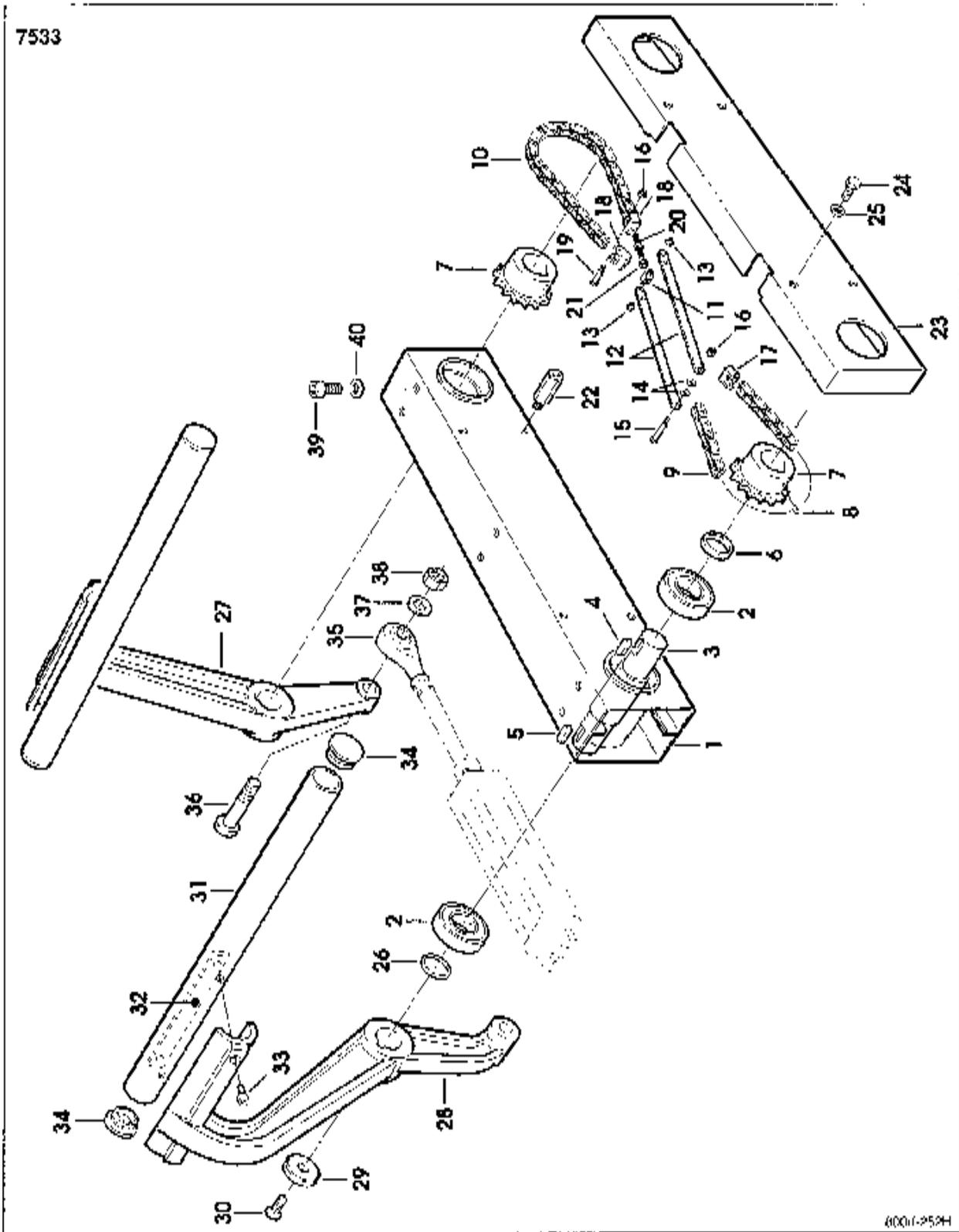


Figure 7-25. Infeed Conveyor Centering Assembly

Parts List - Infeed Conveyor Centering Assembly

Item Number	Part Number	Description	Qty
1	78-8114-4837-8	BOX	1
2	78-8023-2551-0	BEARING, 6005, 2RS	4
3	78-8076-5352-8	SHAFT, Lever	2
4	78-8057-5811-3	KEY, 6 x 6 x 20mm.	2
5	78-8076-5353-6	KEY, 6 x 6 x 25	2
6	78-8076-5354-4	SPACER, Bearing	2
7	78-8076-5355-1	SPROCKET, Z=20, 3/8-inch	2
8	78-8059-5617-0	SET SCREW, M6 x 8	2
9	78-8114-5089-5	CHAIN, 3/8-inch, 45 Pitch	1
10	78-8055-0719-7	CHAIN, 3/8-inch, 27 Pitch Long	1
11	78-8054-8784-6	BLOCK, Chain	1
12	78-8054-8787-9	CHAIN LINK	2
13	78-8056-3945-3	E-RING, M4	2
14	78-8054-8783-8	WASHER, Special	2
15	78-8060-7519-4	SCREW, M3 x 25	1
16	78-8059-5517-2	NUT, Self-Locking, M3, Zinc. Pl.	4
17	78-8054-8788-7	CHAIN CONNECTOR	1
18	78-8054-8786-1	CHAIN CONNECTOR	2
19	78-8060-7520-2	SCREW, M3 x 20	3
20	78-8054-8785-3	ROD, Threaded, Right/Left	2
21	78-8010-7418-4	NUT, Metric, Hex, Stl., M6	2
22	78-8076-5356-9	SPACER, Mounting	4
23	78-8114-5090-3	COVER	1
24	78-8032-0375-7	SCREW, Metric, Hex Hd., M6 x 16	4
25	26-1000-0010-3	WASHER, Flat, M6	4
26	78-8076-5358-5	SPACER, Bearing	2
27	78-8076-5359-3	LEVER, Right	1
28	78-8076-5360-1	LEVER, Left	1
29	78-8076-5361-9	WASHER, Special	2
30	78-8057-5716-4	SCREW, Flat Hd. Soc., M8 x 15	2
31	78-8114-8091-1	GUIDE, Infeed	2
32	78-8076-5363-5	PLATE, Bar	2
33	26-1003-7957-2	SCREW, Soc. Hd., Hex Hd., M6 x 16	4

Parts List - Infeed Conveyor Centering Assembly (Continued)

Item Number	Part Number	Description	Qty
34	78-8054-8779-6	CAP, End	4
35	78-8057-5747-9	MOUNT, Cylinder Rod End	1
36	78-8076-5364-3	SCREW, Hex Hd., M12 x 55	1
37	78-8017-9059-9	WASHER, Flat for M12 Screw	2
38	78-8060-7532-7	NUT, Self-Locking, M12	1
39	26-1003-7964-8	SCREW, Soc. Hd., Hex Soc. Dr., M8 x 20	6
40	78-8017-9318-9	WASHER, Plain, Metric, 8mm	6

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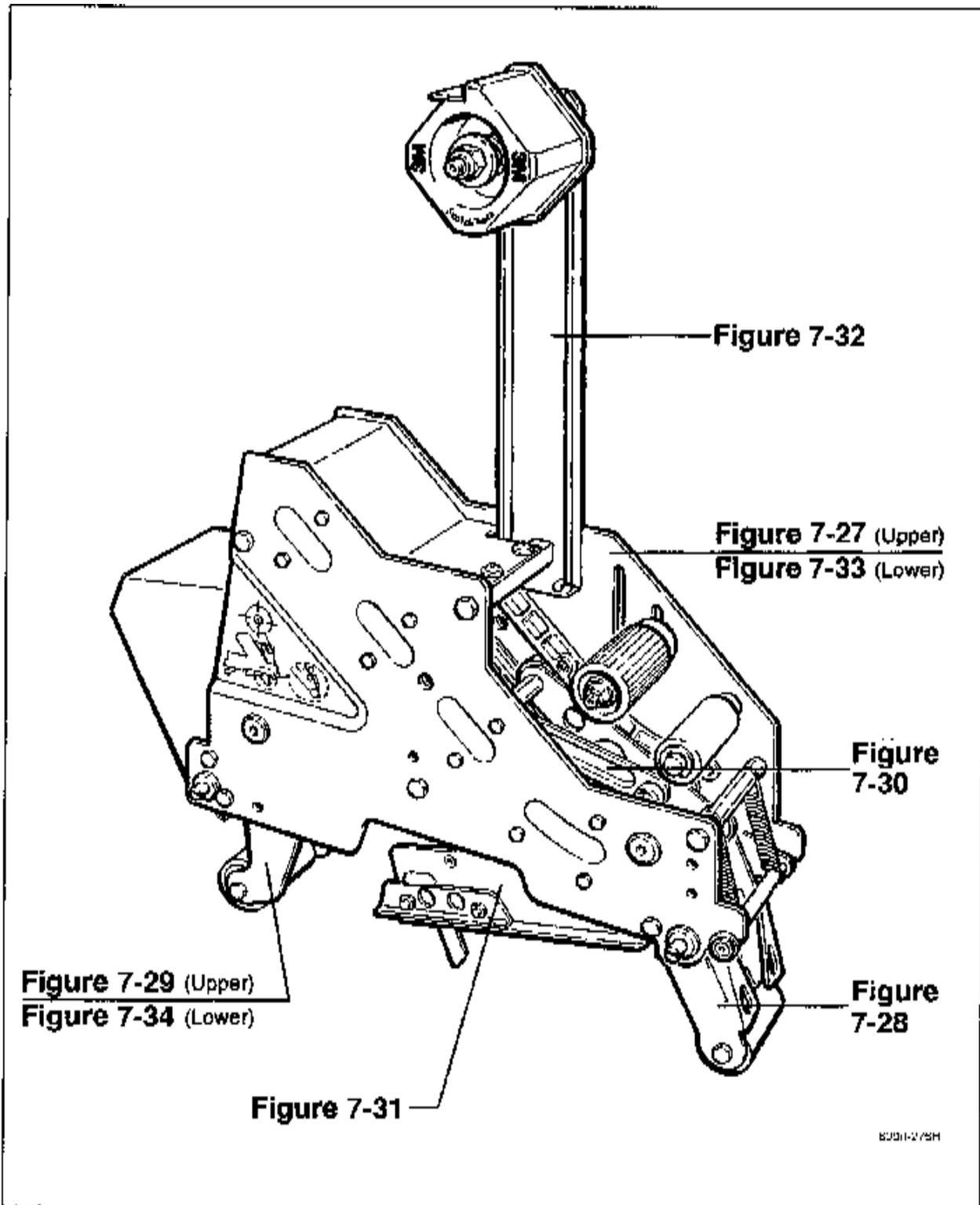


Figure 7-26. Taping Head Assemblies - AccuGlide™ II STD 2-Inch

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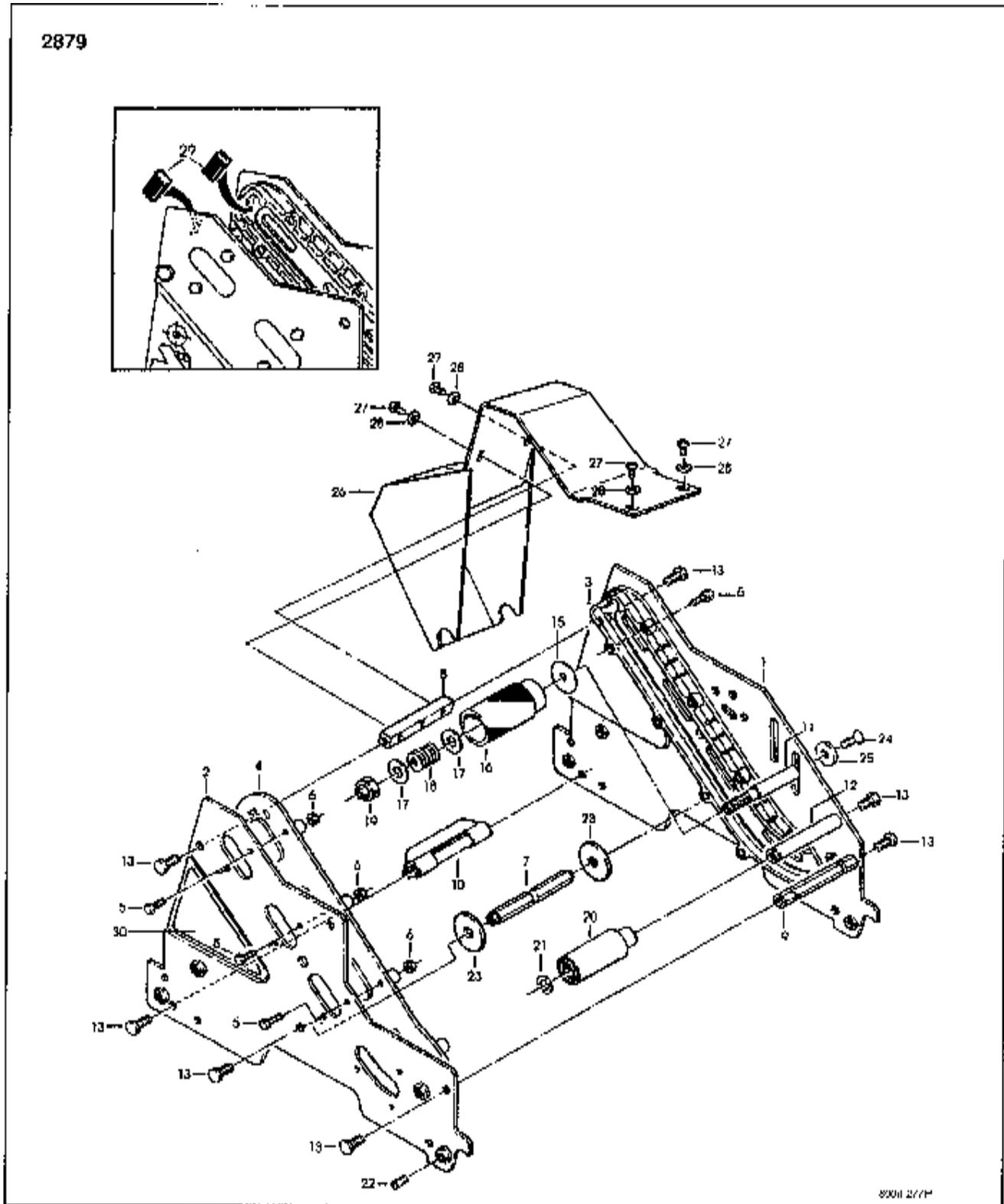


Figure 7-27. Frame Assembly for Upper Head

Parts List – Frame Assembly for Upper Head

Item Number	Part Number	Description	Qty
1	78-8070-1386-3	FRAME, Tape Mount Upper Assembly	1
2	78-8070-1387-1	FRAME, Front Upper Assembly	1
3	78-8068-4143-9	GUIDE, #1	1
4	78-8068-4144-7	GUIDE, #2	1
5	83-0002-7336-3	SCREW, Hex Hd., M4 x 14	18
6	78-8010-7416-8	NUT, Hex Jam, M4	18
7	78-8070-1251-9	SPACER, Spring	1
8	78-8054-8764-8	SPACER, 10 x 10 x 90mm	1
9	78-8052-6560-6	SPACER, Front	1
10	78-8060-7936-0	BRUSH ASSEMBLY	1
11	78-8052-6564-8	SHAFT, Tension Roller	1
12	78-8052-6568-9	SHAFT, Wrap Roller	1
13	26-1003-5829-5	SCREW, Hex Hd., M6 x 12	9
15	78-8100-1009-6	WASHER, Special	1
16	78-8052-6565-5	ROLLER, Top Tension	1
17	78-8052-6566-3	WASHER, Friction	2
18	78-8052-6567-1	SPRING, Compression	1
19	78-8017-9077-1	NUT, Self-Locking, M10 x 1	1
20	78-8052-6569-7	ROLLER, Wrap	1
21	26-1000-1613-3	RING, Retaining, Tru-Arc #1-420-0120-100	1
22	78-8076-4500-3	STUD, Mounting	4
23	78-8076-5242-1	STOP, Cut-Off Frame	2
24	78-8060-8179-6	SCREW, Flat Hd. Hex, M6 x 20	1
25	78-8076-5477-3	WASHER, Special /6.5 x 20 x 4	1
26	78-8100-1047-6	GUARD, Head	1
27	78-8060-8087-1	SCREW, M5 x 10	4
28	78-8005-5741-1	WASHER, Flat, M5	4
29	78-8076-4734-8	BUMPER	2
30	78-8070-1365-7	LABEL, Threading, English Language	1

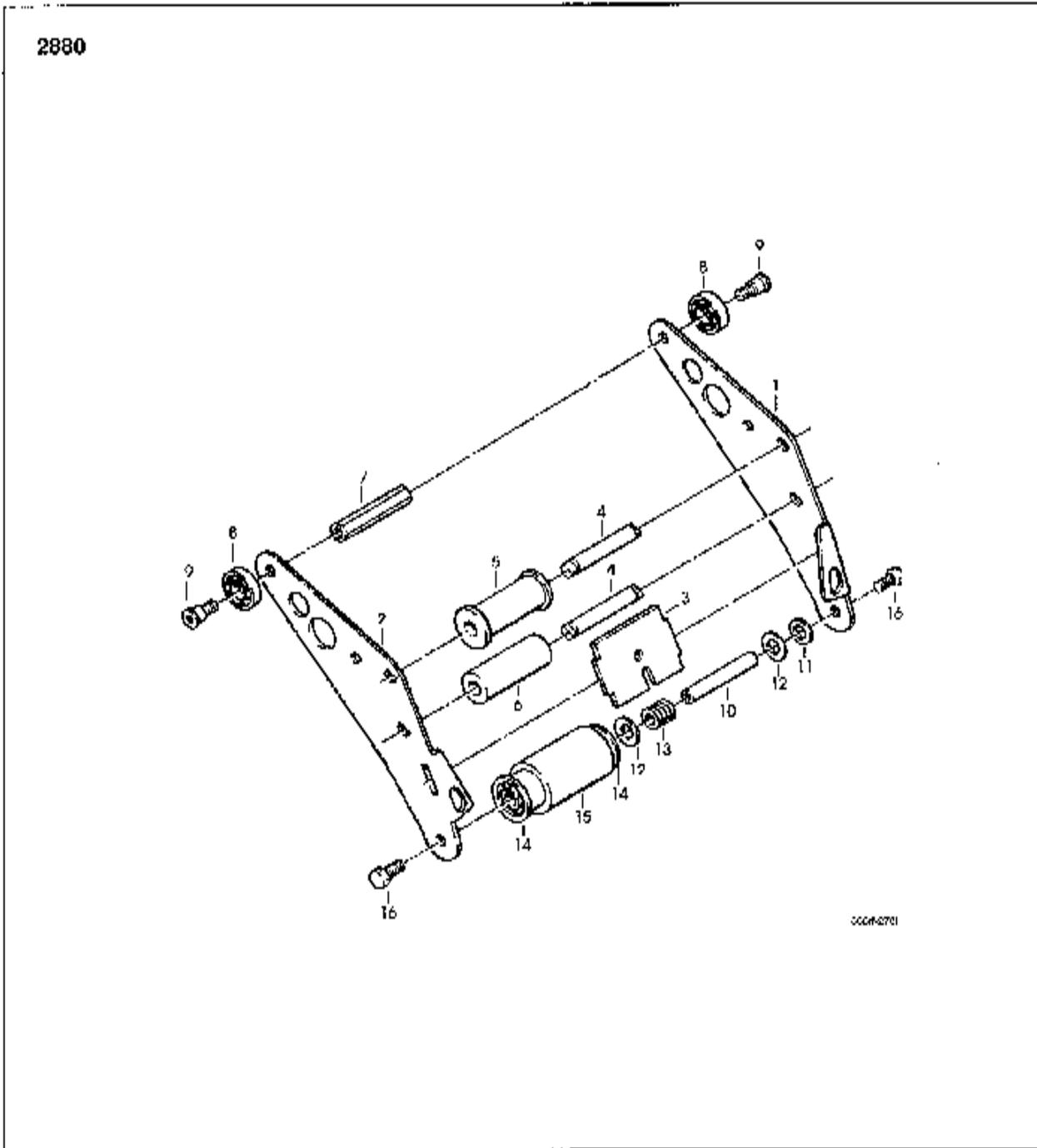


Figure 7-28. Applying Assembly for Upper and Lower Heads

Parts List – Applying Assembly for Upper and Lower Heads

Item Number	Part Number	Description	Qty
1	78-8070-1206-3	APPLYING ARM #1	1
2	78-8070-1207-1	APPLYING ARM #2	1
3	78-8070-1221-2	PLATE, Tape	1
4	78-8070-1309-5	SHAFT ROLLER	2
5	78-8070-1367-3	ROLLER, Knurled Assembly	1
6	78-8070-1266-7	ROLLER, Wrap	1
7	78-8052-6580-4	SPACER	1
8	78-8017-9082-1	BEARING, Special, 30mm	2
9	78-8017-9106-8	SCREW, Bearing Shoulder	2
10	78-8052-6575-4	SHAFT, Roller	1
11	78-8017-9074-8	WASHER, Nylon, 15mm	1
12	78-8052-6566-3	WASHER, Friction	2
13	78-8052-6567-1	SPRING, Compression	1
14	78-8060-8395-8	BUSHING, Applying Roller	1
15	78-8057-6179-4	ROLLER, Applying	1
16	26-1003-5829-5	SCREW, Hex Hd., M6 x 12	2

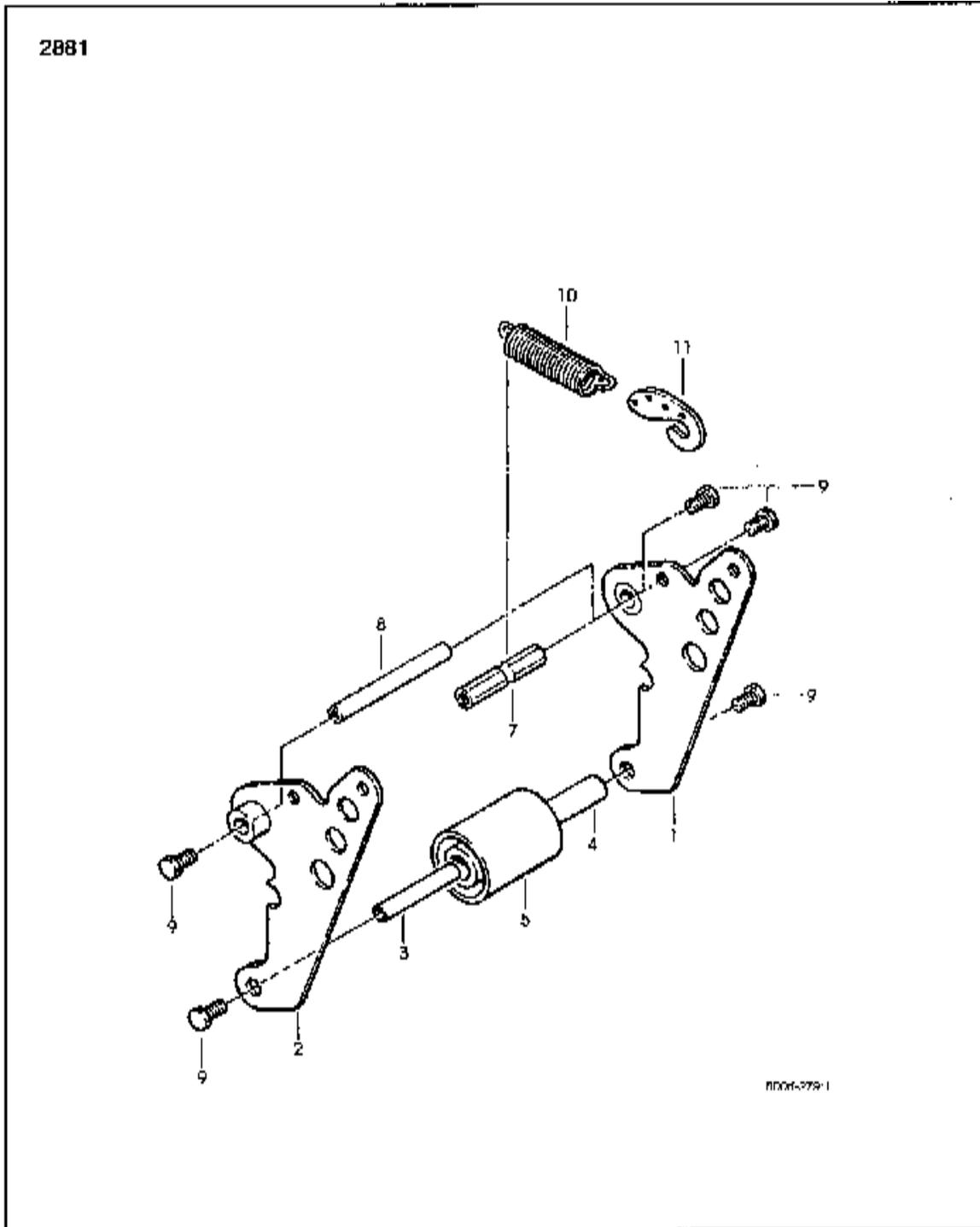


Figure 7-29. Buffing Assembly for Upper Head

Parts List – Buffing Assembly for Upper Head

Item Number	Part Number	Description	Qty
1	78-8070-1392-1	BUFFING ARM, Sub Assembly	1
2	78-8070-1391-3	BUFFING ARM, Sub Assembly	1
3	78-8052-6575-4	SHAFT, Roller	1
4	78-8052-6586-1	BUSHING, Buffing Roller	1
5	78-8057-6178-6	ROLLER, Buffing	1
7	78-8070-1220-4	SPACER, Spring	1
8	78-8017-9109-2	SHAFT, 10 x 90mm	1
9	26-1003-5829-5	SCREW, Hex Hd., M6 x 12	6
10	78-8070-1274-1	SPRING, Upper (Silver)	1
11	78-8070-1244-4	HOLDER, Spring	1

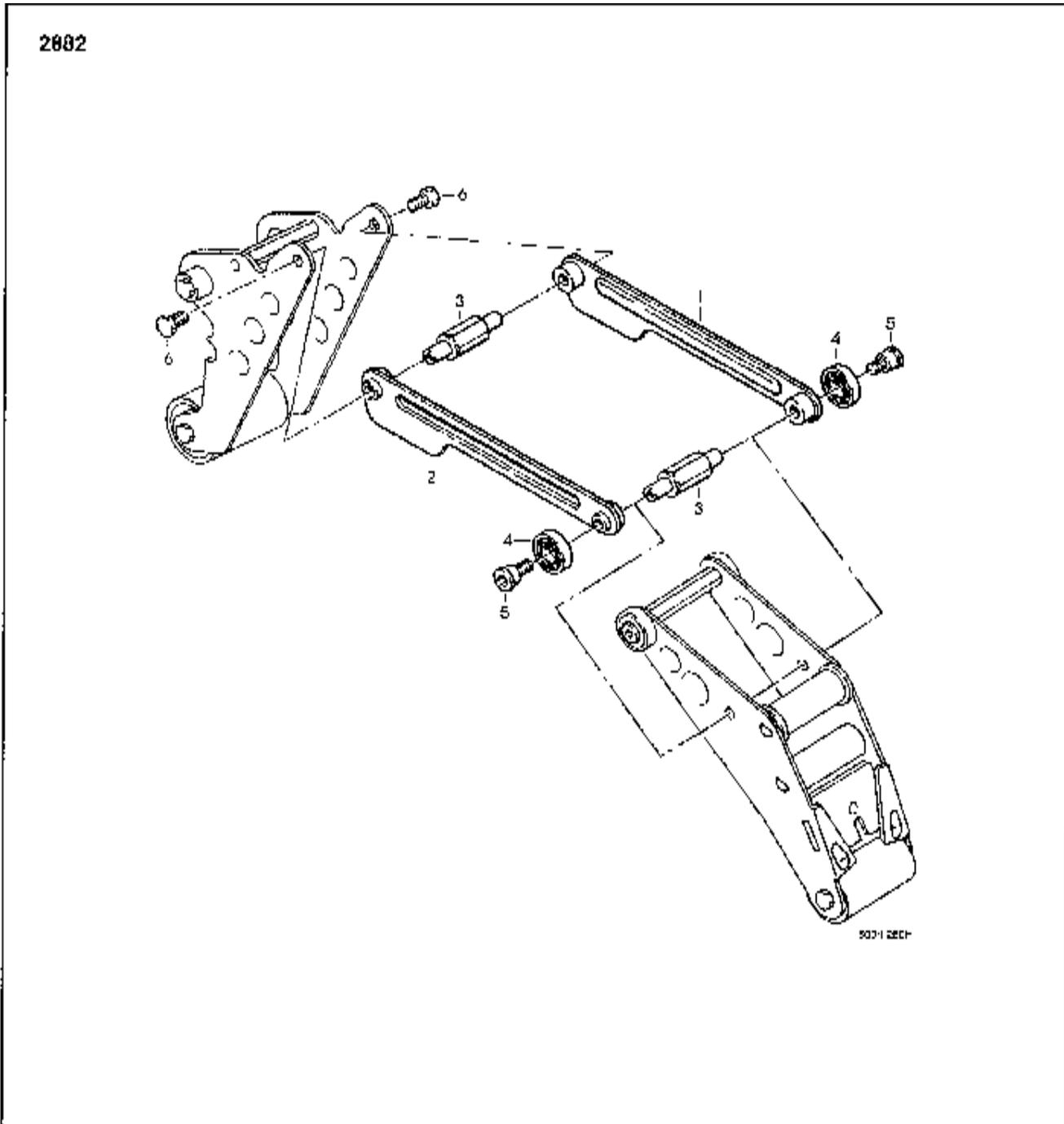


Figure 7-30. Link Assembly for Upper and Lower Heads

Parts List – Link Assembly for Upper and Lower Heads

Item Number	Part Number	Description	Qty
1	78-8070-1388-9	LINK, Arm Bushing Assembly	1
2	78-8070-1389-7	LINK, Arm Bushing Assembly	1
3	78-8070-1271-7	SHAFT, Pivot	2
4	78-8017-9082-1	BEARING, Special 30mm	2
5	78-8017-9106-8	SCREW, Bearing Shoulder	2
6	26-1003-5829-5	SCREW, Hex Hd., M6 x 12	2

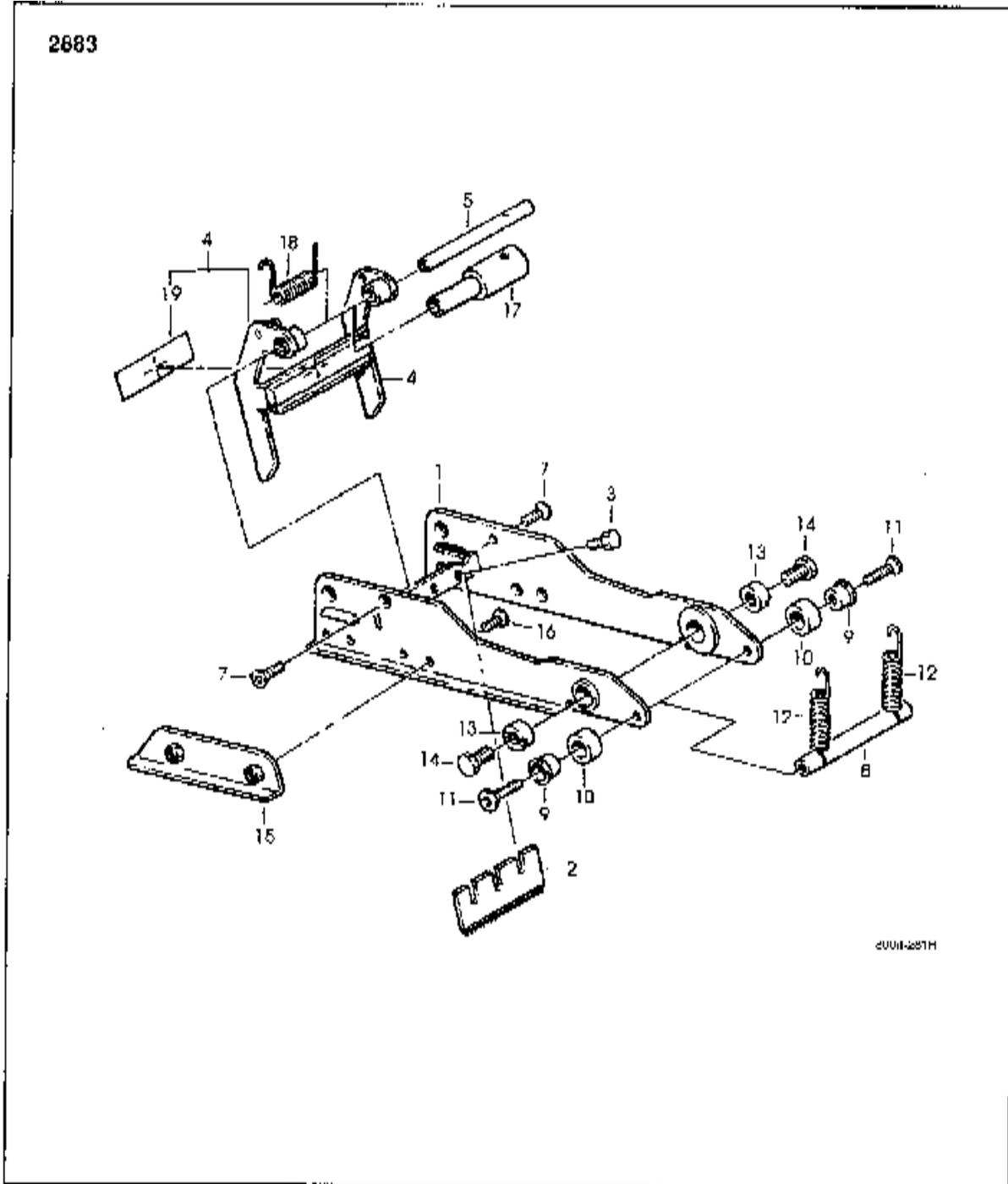


Figure 7-31. Knife Assembly for Upper and Lower Heads

Parts List – Knife Assembly for Upper and Lower Heads

Item Number	Part Number	Description	Qty
1	78-8070-1217-0	FRAME, Cut-Off Weldment	1
2	78-8017-9173-8	KNIFE, 65mm/2.56-inch	1
3	26-1002-5817-2	SCREW, Hex Hd., M5 x 8	2
4	78-8070-1371-5	KNIFE GUARD ASSEMBLY, W/English Language Label	1
5	78-8052-6597-8	SHAFT, Knife Guard	1
7	26-1005-4758-2	SCREW, Flat Hd, Soc Dr, M4 x 10	2
8	78-8017-9135-7	SHAFT, Spacer	1
9	78-8052-6600-0	SPACER	2
10	78-8070-1269-1	BUMPER	2
11	26-1005-4757-4	SCREW, Flat Hd, Soc Dr, M5 x 20	2
12	78-8052-6602-6	SPRING, Cutter	2
13	78-8017-9132-4	PIVOT, Cutter Lever	2
14	26-1003-5828-7	SCREW, Spec., Hex Hd., M6 x 10	2
15	78-8070-1216-2	SLIDE, Extension	2
16	26-1008-6574-5	SCREW, Flat Hd., Phil.Dr., M4 x 10	4
17	78-8113-7031-7	BUSHING, 58.5mm Long	1
18	78-8113-7030-9	SPRING, Torsion	1
19	78-8070-1335-0	LABEL, Warning, English	1

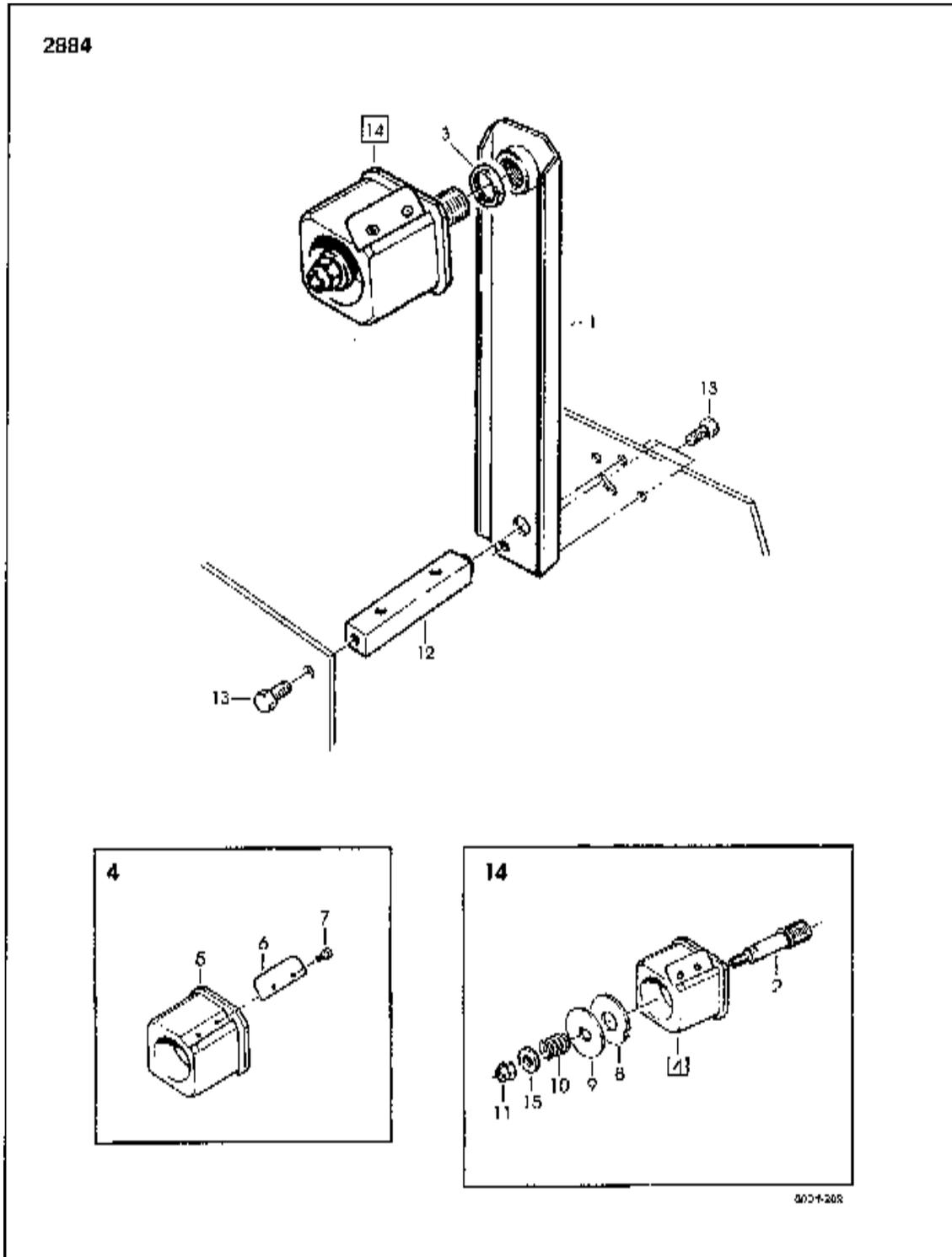


Figure 7-32. Tape Drum and Bracket for Upper and Lower Heads

Parts List – Tape Drum and Bracket for Upper and Lower Heads

Item Number	Part Number	Description	Qty
1	78-8070-1395-4	BRACKET, Bushing Assembly	1
2	78-8076-4519-3	SHAFT, Tape Drum, 50mm	1
3	78-8017-9169-6	NUT, M18 x 1	1
4	78-8070-1569-4	TAPE DRUM SUB-ASSEMBLY	1
5	78-8052-6749-5	TAPE DRUM	1
6	78-8052-6268-6	LEAF SPRING	1
7	26-1002-5753-9	SCREW, Self Tapping	2
8	78-8060-8172-1	WASHER, Friction	1
9	78-8052-6271-0	WASHER, Tape Drum	1
10	78-8100-1048-4	SPRING, Core Holder	1
11	78-8017-9077-1	NUT, Self-Locking, M10 x 1	1
12	78-8100-1046-8	SPACER, Bracket	1
13	26-1003-5829-5	SCREW, Hex Hd., M6 x 12	4
14	78-8060-8474-1	TAPE DRUM ASSEMBLY	1
15	26-1004-5510-9	WASHER, Plain, M10	1

Parts List – Frame Assembly for Lower Head

Item Number	Part Number	Description	Qty
1	78-8070-1369-9	FRAME, Tape Mount Lower Assembly	1
2	78-8070-1370-7	FRAME, Front Lower Assembly	1
3	78-8068-4144-7	GUIDE, #2	1
4	78-8068-4143-9	GUIDE, #1	1
5	83-0002-7336-3	SCREW, Hex Hd., M4 x 14	18
6	78-8010-7416-8	NUT, Hex, M4	18
7	78-8070-1251-9	SPACER, Spring	1
8	78-8054-8764-8	SPACER, 10 x 10 x 90mm	1
9	78-8052-6560-6	SPACER, Front	1
10	78-8060-7936-0	BRUSH ASSEMBLY	1
11	78-8052-6564-8	SHAFT, Tension Roller	1
12	78-8052-6568-9	SHAFT, Wrap Roller	1
13	26-1003-5829-5	SCREW, Hex Hd., M6 x 12	9
15	78-8100-1009-6	WASHER, Special	1
16	78-8052-6606-7	ROLLER, Tension Bottom	1
17	26-1004-5510-9	WASHER, Plain, M10	2
18	78-8052-6567-1	SPRING, Compression	1
19	78-8017-9077-1	NUT, Self-Locking, M10 x 1	1
20	78-8052-6569-7	ROLLER, Wrap	1
21	26-1000-1613-3	RING, Retaining, Tru-Arc #1-420-0120-100	1
22	78-8076-4500-3	STUD, Mounting	4
23	78-8076-5242-1	STOP, Cut-Off Frame	2
24	78-8060-8179-6	SCREW, Flat Hd. Hex, M6 x 20	1
25	78-8076-5477-3	WASHER, Special /6.5 x 20 x 4	1
29	78-8076-4734-8	BUMPER	2
30	78-8070-1364-0	LABEL, Threading, English Language	1

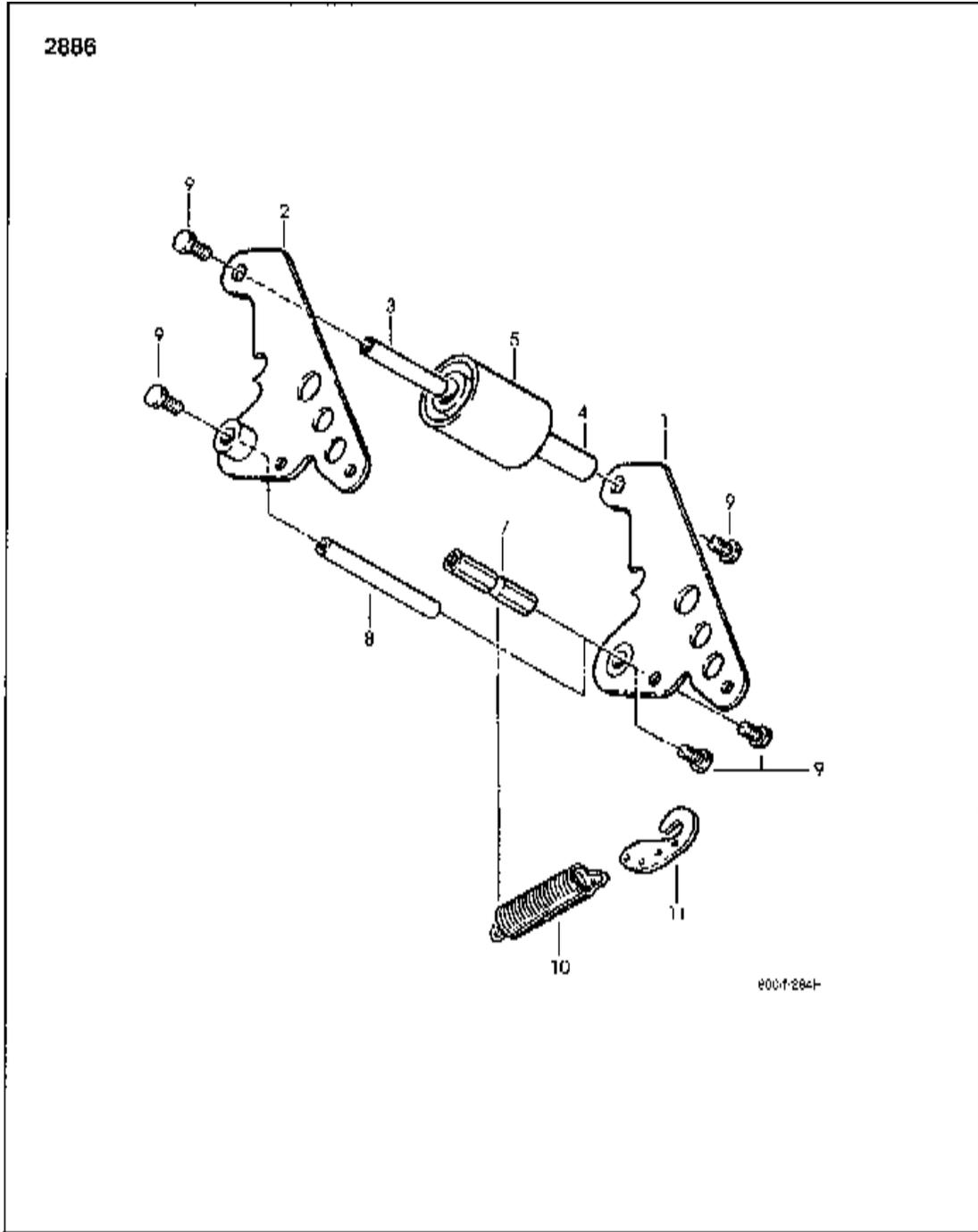


Figure 7-34. Buffing Assembly for Lower Head

Parts List – Buffing Assembly for Lower Head

Item Number	Part Number	Description	Qty
1	78-8070-1391-3	BUFFING ARM SUB ASSEMBLY	1
2	78-8070-1392-1	BUFFING ARM SUB ASSEMBLY	1
3	78-8052-6575-4	SHAFT, Roller	1
4	78-8052-6586-1	BUSHING, Buffing Roller	1
5	78-8057-6178-6	ROLLER, Buffing	1
7	78-8070-1220-4	SPACER, Spring	1
8	78-8017-9109-2	SHAFT, 10 x 90mm	1
9	26-1003-5829-5	SCREW, Hex Hd., M6 x 12	6
10	78-8070-1273-3	SPRING, Lower (Black)	1
11	78-8070-1244-4	HOLDER, Spring	1

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8. Preventative Maintenance

8-1. General

The Model 800rf Case Sealer is designed for long, trouble-free service.

8-1-1. Maintenance

The machine performs best when it receives routine maintenance and cleaning. Machine components that fail or wear excessively should be promptly repaired or replaced to prevent damage to other portions of the machine or to the product.

8-1-2. Tool Kit

Since the case sealer uses metric fasteners, a tool kit consisting of open-end and hex-socket wrenches is provided with the machine.

Warning

Turn off electrical power and compressed air at the machine. Disconnect the power cord from the electrical supply and disconnect the air supply line before beginning maintenance. If the power and compressed air are not disconnected, severe personal injury could result. Use care when replacing the tape cut-off knives. They are extremely sharp and could cause severe personal injury.

8-2. Cleaning

Regular slotted containers produce a great deal of dust and paper chips when processed or handled in equipment. If this dust is allowed to build up on machine components, it can cause component wear and overheating of the drive motors. The dust buildup can best be removed from the machine by a shop vacuum.

Depending on the number of boxes sealed in the case sealer, cleaning should be done approximately once per month. If the boxes sealed are dirty, or if the environment in which the machine operates is dusty, more frequent cleaning may be necessary.

Caution

Never attempt to remove dirt by blowing it out with compressed air. This causes dirt to be blown inside the motors and between sliding surfaces. Dirt in these areas causes serious damage and rapid wear. Never wash the machine with water or subject it to conditions that cause moisture condensation on components. Serious damage could result.

1. Vacuum the machine to remove dust and paper chips.
2. Wipe off grime with a soft cloth dampened with 3M Natural Cleaner (62-4668-2730-0).
3. Wipe off the tape cut-off knives with a cloth dampened with 3M Natural Cleaner. Use a motion away from the sharp edge.
4. Drain any water from the bowl of the Main Air Pressure Regulator/Filter and clean it as necessary.
5. Wipe off the conveyor bed rollers with a cloth dampened with 3M Natural Cleaner. Make sure the rollers are free on their shafts. If they are not free, spray them with 3M Natural Cleaner.

8-3. Lubrication

Like most other equipment, the case sealer must be lubricated periodically to ensure long, trouble-free service. Most of the machine bearings are permanently lubricated and sealed and do not need further lubrication. The drive motors and cylinders are also permanently lubricated and do not require additional lubrication.

⚠ Caution

During lubrication, wipe off all excess lubricant and grease. Excess lubricant attracts dust and dirt that can cause equipment wear and jamming. Take care that no lubricant or grease remains on the surface of rollers around which tape is wrapped.

8-3-1. Taping Heads

Figures 8-1 and 8-2 illustrate the taping head points that should be lubricated after every 250 hours of operation.

For each taping head:

1. Apply a small amount of multipurpose grease to the guides and to the ends of each spring where the spring loops are secured. Refer to Figure 8-1.

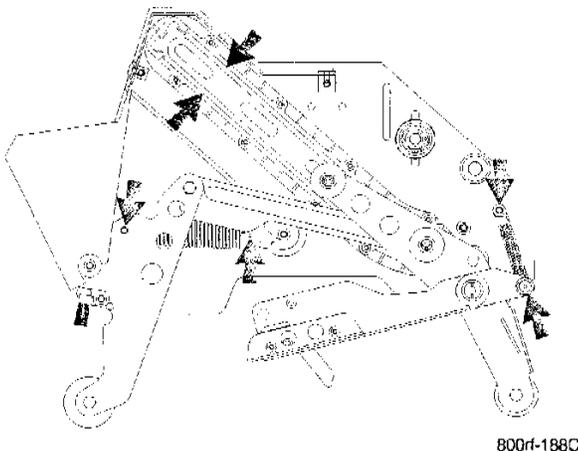
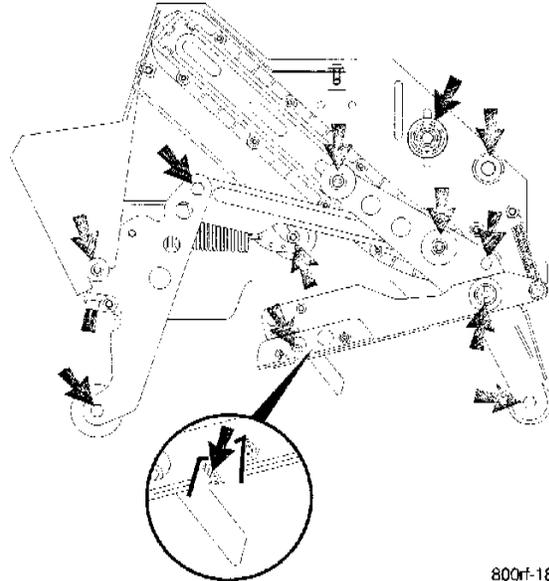


Figure 8-1. Lubricating Guides and Spring Loops

2. Apply 3M 5-Way Penetrant (62-4696-2730-1) to all pivot points of the taping head. Refer to Figure 8-2.
3. Apply 3M 5-Way Penetrant to the tape cut-off knife oiler pad. Saturate the pad.



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Figure 8-2. Lubricating Pivot Points and Oiler Pad

8-3-2. Main Assembly and Infeed Assembly

With reference to Figure 8-3 and the associated figures in Section 7, Illustrated Parts Breakdown, lubricate the machine wear points as indicated.

1. Side Belt Drive Closure Assembly

At 250 hours, use multipurpose grease.

- Lightly coat chain pitches (Figure 7-5, # 17 and #18).
- Lightly coat outside diameter of the shafts of the arm assembly (Figure 7-5, #1, #2, #3, and #4).
- Lightly coat inside diameter of bushing (Figure 7-13, #89) use grease fitting, (Figure 7-5, #38) use needle point gun on this fitting.

2. Side Belt Drive Assembly

At 250 hours, use multipurpose grease.

- Lightly coat chain pitches (Figure 7-13, # 75).

3. Column Assembly

At 250 hours, use multipurpose grease.

- Lightly coat outside surface of the column guides (Figure 7-6, #3).

4. Side Drive Belt/ Compression Roller Assembly Rails

At 250 hours, use 3M 5-Way Penetrant (62-4696-2730-1).

- Lightly coat outside surface of bushing (Figure 7-9, # 9).

At 250 hours, use multipurpose grease.

- Lightly coat rails (Figure 7-9, #4).

5. Infeed Roller Assemblies

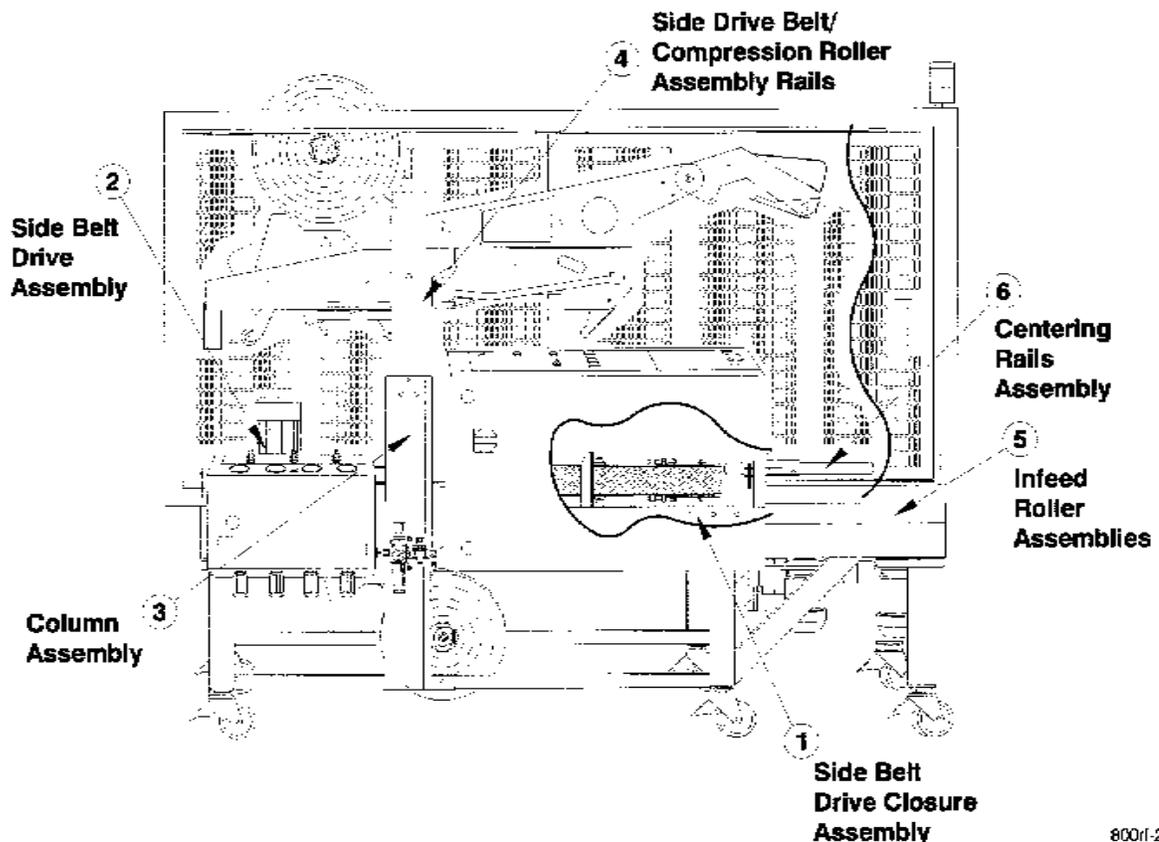
At 250 hours, use multipurpose grease.

- Coat two (2) roller chains (Figure 7-24, # 25) both sides, left front and right rear.
- Coat two (2) drive motor sprockets (Figure 7-24, # 11) both sides, left front and right rear.
- Coat six (6) roller sprockets (Figure 7-24, # 23) both sides, left front and right rear.
- Coat six (6) roller shafts (Figure 7-24, # 19) both sides, left front and right rear.

6. Centering Rails Assembly

At 250 hours, use multipurpose grease.

- Lightly coat chain pitches (Figure 7-25, #9 and #10).



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Figure 8-3. Lubricating Main Assembly and Infeed Assembly

8-4. Maintenance Schedule

1-1-1. Taping Heads

The following table provides recommendations for inspecting and replacing parts, and cleaning and lubricating the upper and lower taping heads.

Taping Head	Inspect/Replace	Clean	Lubricate	Counter Cycles *
Tape Cut-Off Knife	Inspect at 250 hours. Replace when dull, broken teeth, or poor cutting.	250 hours. 3M Natural Cleaner.	250 hours. 3M 5-Way Penetrant.	Every 120,000 cycles
Knife Oiler Pad	Inspect at 250 hours. Replace when worn, or won't hold sufficient oil.	N.A.	250 hours. 3M 5-Way Penetrant.	Every 120,000 cycles.
Rollers and Shafts	Inspect at 250 hours. Replace as needed.	250 hours. 3M Natural Cleaner.	250 hours. 3M 5-Way Penetrant.	Every 120,000 cycles.
* Based on an average of 8 cartons/minute. (480 cartons/hour x 250 hours = 120,000 cycles)				

8-4-2. Infeed Assembly

The following table provides recommendations for inspecting and replacing parts, and cleaning and lubricating the infeed assembly.

Taping Head	Inspect/Replace	Clean	Lubricate	Counter Cycles *
Centering Rails Closure Chain	Inspect at 250 hours. Replace as needed.	N.A.	250 hours. Multipurpose grease.	Every 120,000 cycles.
Infeed Drive Motor Sprockets and Chains	Inspect at 250 hours. Replace as needed.	N.A.	250 hours. Multipurpose grease.	Every 120,000 cycles.
Infeed Roller Sprockets and Shafts	Inspect at 250 hours. Replace as needed.	N.A.	250 hours. Multipurpose grease.	Every 120,000 cycles.
* Based on an average of 8 cartons/minute. (480 cartons/hour x 250 hours = 120,000 cycles)				

8-4-3. Main Assembly

The following table provides recommendations for inspecting and replacing parts, and cleaning and lubricating the main assembly.

Main Assembly	Inspect/Replace	Clean	Lubricate	Counter Cycles *
Side Drive Belts	Inspect at 250 hours. Replace when worn, or slipping on carton.	250 hours. Vacuum.	N.A.	Every 120,000 cycles.
Belt Drive Rings	Inspect at 500 hours. Replace when worn, or won't drive belts.	N.A.	N.A.	Every 240,000 cycles.
Side Belt Closure Assembly Chains, Shafts, and Bushings	Inspect at 250 hours. Replace as needed.	N.A.	250 hours. Multipurpose grease.	Every 120,000 cycles.
Side Belt Drive Assembly Chains	Inspect at 250 hours. Replace as needed.	N.A.	250 hours. Multipurpose grease.	Every 120,000 cycles.
Column Assembly Column Guides	Inspect at 250 hours. Replace as needed.	N.A.	250 hours. Multipurpose grease.	Every 120,000 cycles.
Top Flap Compression Roller Bushings	Inspect at 250 hours. Replace as needed.	N.A.	250 hours. 3M 5-Way Penetrant.	Every 120,000 cycles.
Side Drive Belt Rails	Inspect at 250 hours.	N.A.	250 hours. Multipurpose grease.	Every 120,000 cycles.
Main Air Pressure Regulator/Filter	Inspect as needed. Replace as needed.	Drain. Do not allow water to go above filter element. Clean as needed.	N.A.	N.A.
* Based on an average of 8 cartons/minute. (480 cartons/hour x 250 hours = 120,000 cycles) (480 cartons/hour x 500 hours = 240,000 cycles)				

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