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# USER MANUAL
# USA 2024-WAT-EU

For Serial Numbers:
TM805 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

REV01 ..... Second Release

## 1.2 TECHNICAL SUPPORT

This is the Interpack Model AUTO H2O Uniform Semi-Automatic 2024-WAT-EU Side-Belt Case Sealer (USA2024-WAT-EU 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 Heads' 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 USA2024-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 USA2024-WAT-EU Case Sealer**

The USA2024-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 USA2024-WAT-EU Case Sealer is manually adjustable to a random variety of case sizes (see Carton Specifications, page 3-3). The USA2024-WAT-EU Case Sealer features reversible operator controls to facilitate its adaptation into an existing conveyor line.

## *1.7 OPTIONAL EQUIPMENT*

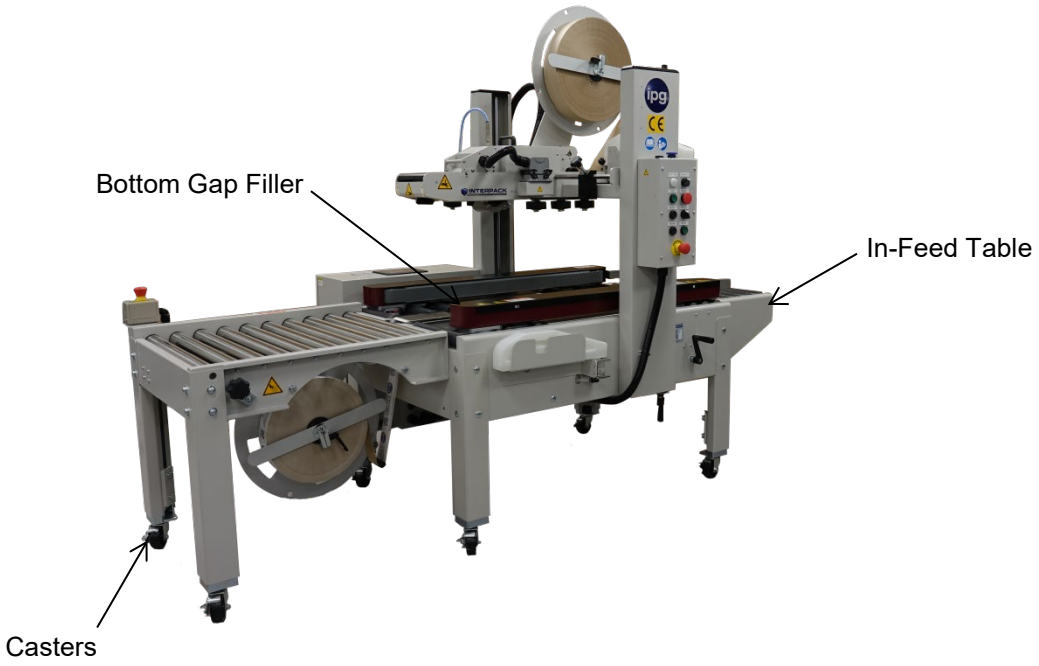



**Figure 1-2 Optional Equipment**

# Chapter 2
# IMPORTANT SAFEGUARDS

## 2.1 SAFETY LABELS

There are a number of safety labels used on the USA2024-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*

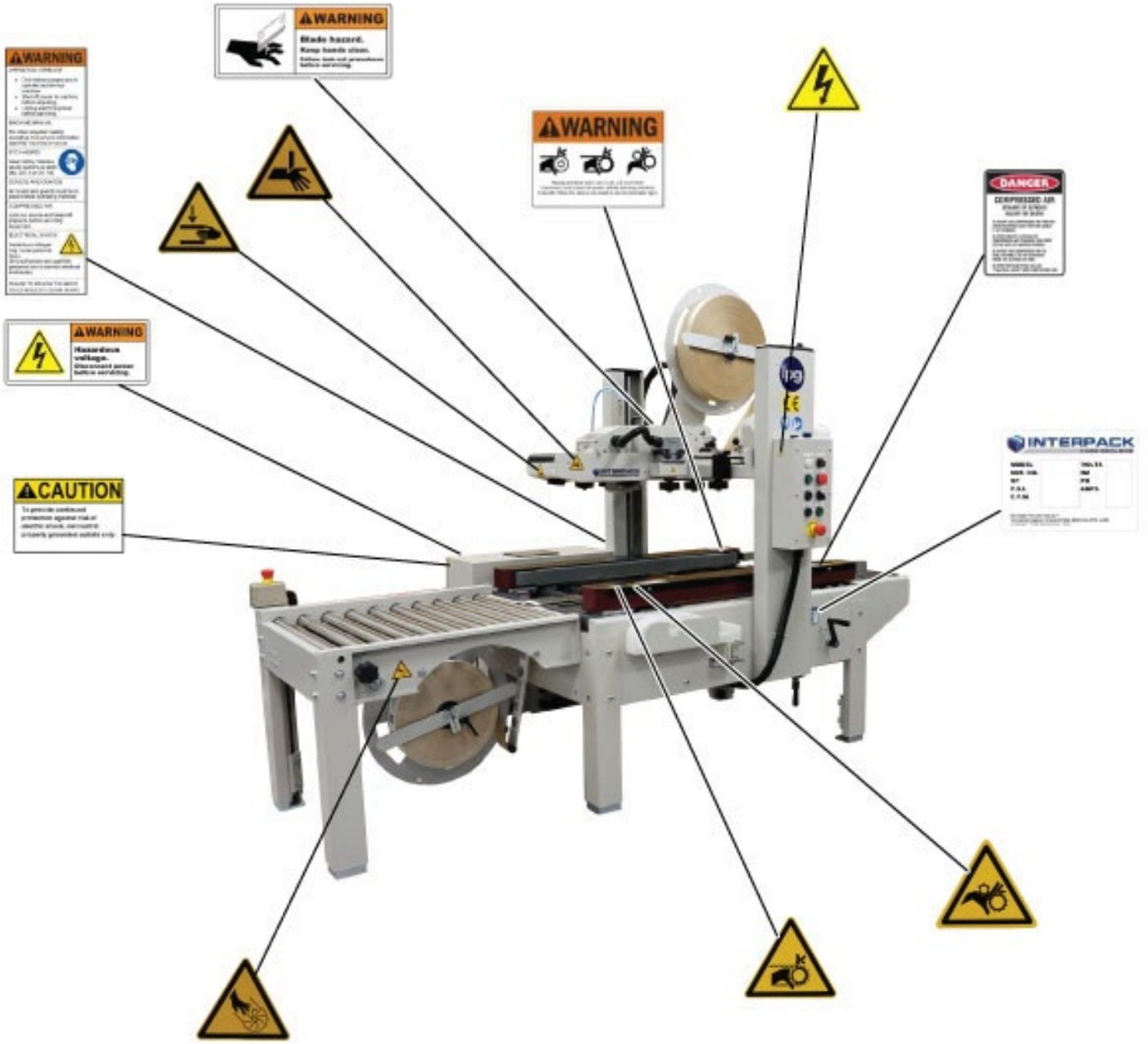
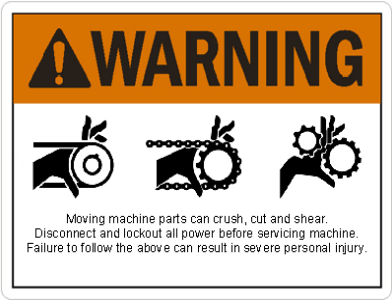
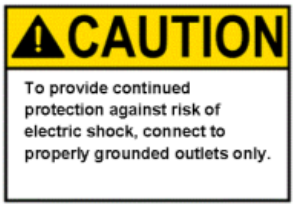
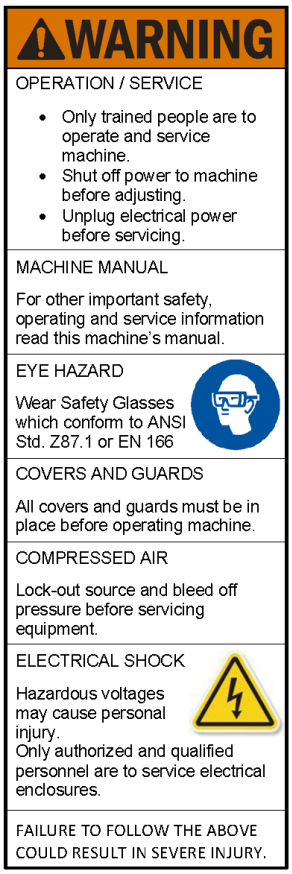



**Figure 2-1 Safety Label Placement**

## *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**

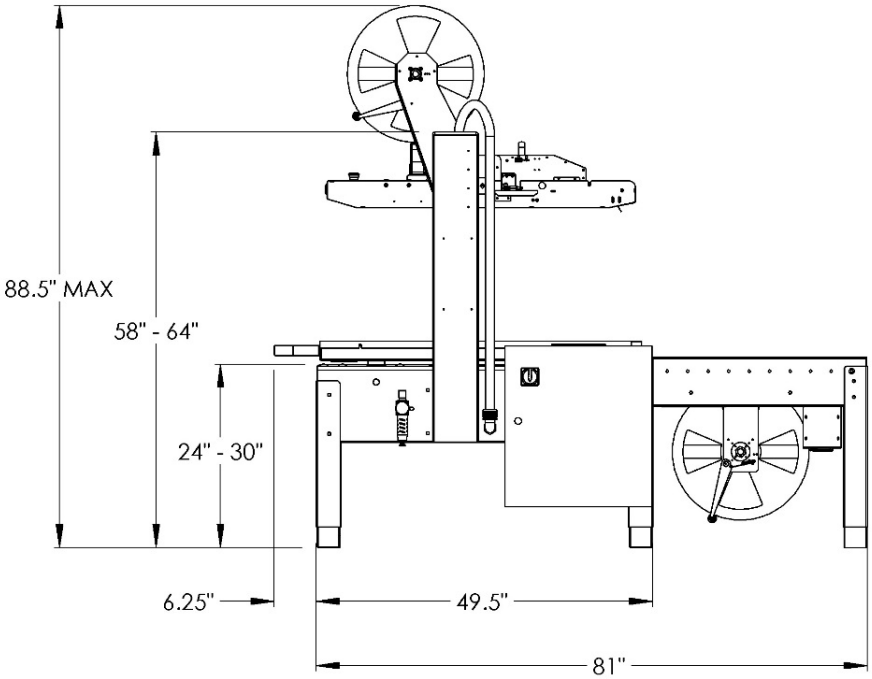
| Operation | Machine Condition | Operator Skill Level | Number of Operators |
|---|---|---|---|
| Machine Installation & Set-Up | Running with Safety Protections Disabled | B & C | 2 |
| Tape Roll Replacement | Stopped by Pressing the Emergency Stop Button | A | 1 |
| Blade Replacement | Electrical 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:** 1182 lbs (536kg) crated



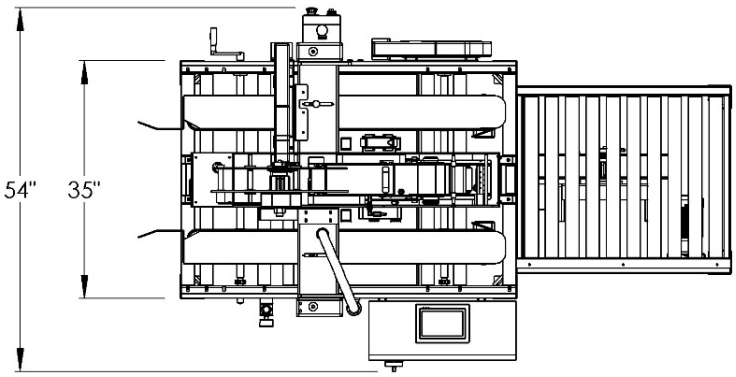




**Figure 3-1 Machine Dimensions**

## *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 40-105° F (5-40° C) 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 - 220 V, 50 HZ, 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 Start button, the Emergency Stop switch, a Manual/Auto switch, a Tape Threading/Stop button, a Belt Drive button, a Tape Feed button, a Cut Tape button, a Clear button, and a Top/Both/Bottom selector switch.

A 12 ft (365.8cm) standard, three-conductor power cord with plug is provided. 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 14 in. (355.6mm). Belt speed is 70 ft/min.

## 3.3.3 Tape Specifications

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

A maximum tape roll length of 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 3 in. (76.2mm) is factory set. The standard tape leg length may vary up to ¼" (6mm) 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 2 in. (48mm) and the maximum recommended is 3 in. (76.2mm).

## 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**

85 lbs (38.6kg) maximum

**Size**

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

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

### 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 0.75 in. (19.1mm) or less then several boxes should be test run to ensure proper machine performance. The formula is as follows:

CARTON LENGTH IN DIRECTION OF SEAL > 0.75 in. (19.1mm) ÷ CARTON HEIGHT

# Chapter 4
# SET-UP PROCEDURES

## 4.1 RECEIVING AND HANDLING

The machine is shipped to the customer affixed 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.

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

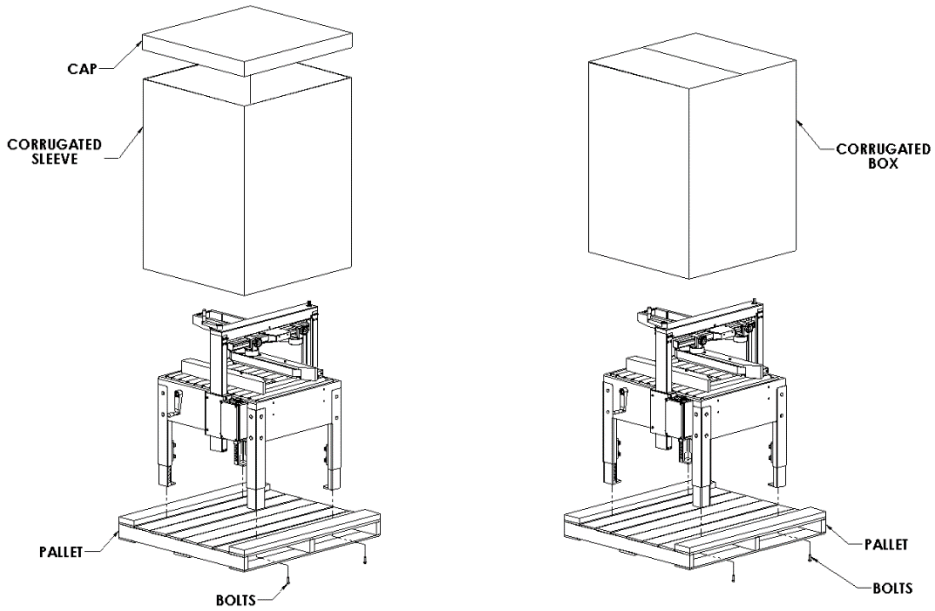



**Figure 4-1 Receiving and Handling**

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

- USA2024-WAT-EU Case Sealer
- Operation Manual & Parts List
- Plastic bag containing tape head spare parts.

**Note:** After unpacking the USA2024-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).

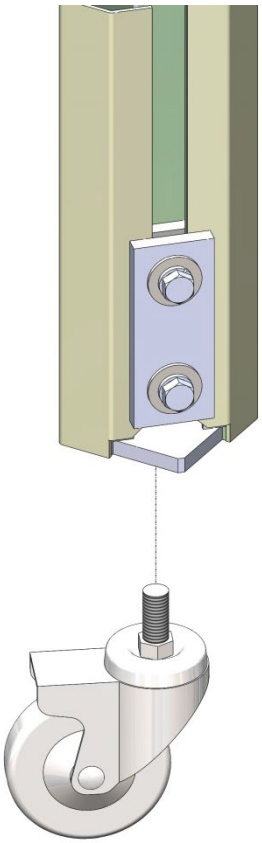


**Figure 4-2 Caster Installation**

## *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 USA2024-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 24 - 30 in. (61.0 - 76.2cm).

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, loose eight 12mm hex head adjustment bol (refer to Figure 4-3).
3. Adjust the legs to the desired convey height and tighten bolts. Etched lines the legs ease leveling.

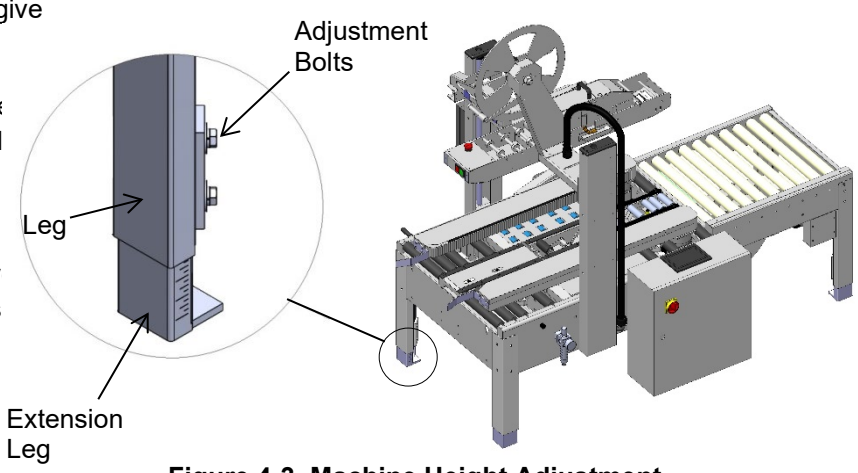



**Figure 4-3 Machine Height Adjustment**

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

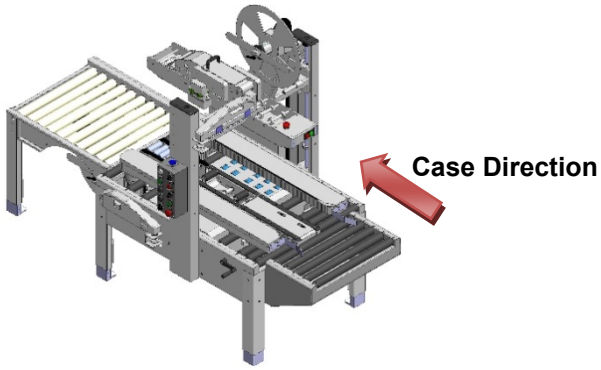



**Figure 4-4 Case Direction**

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

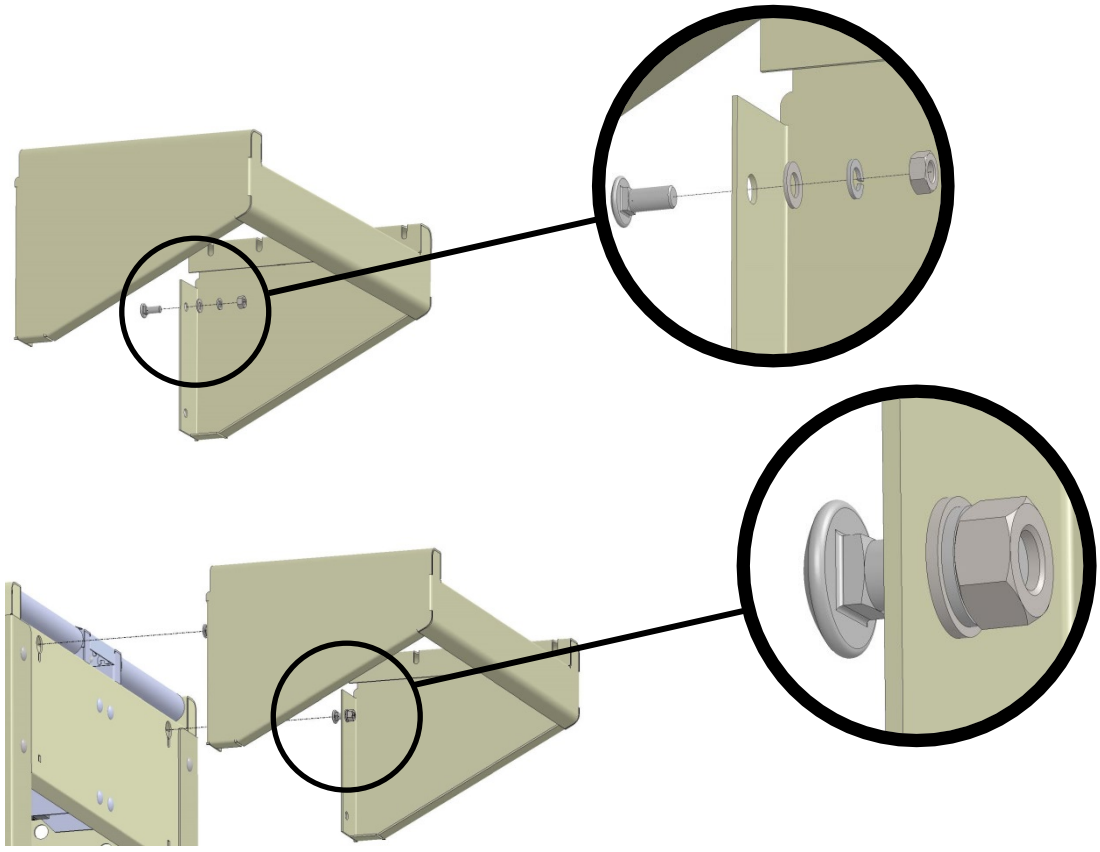


**Figure 4-5 Carriage Bolt Installation**

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.

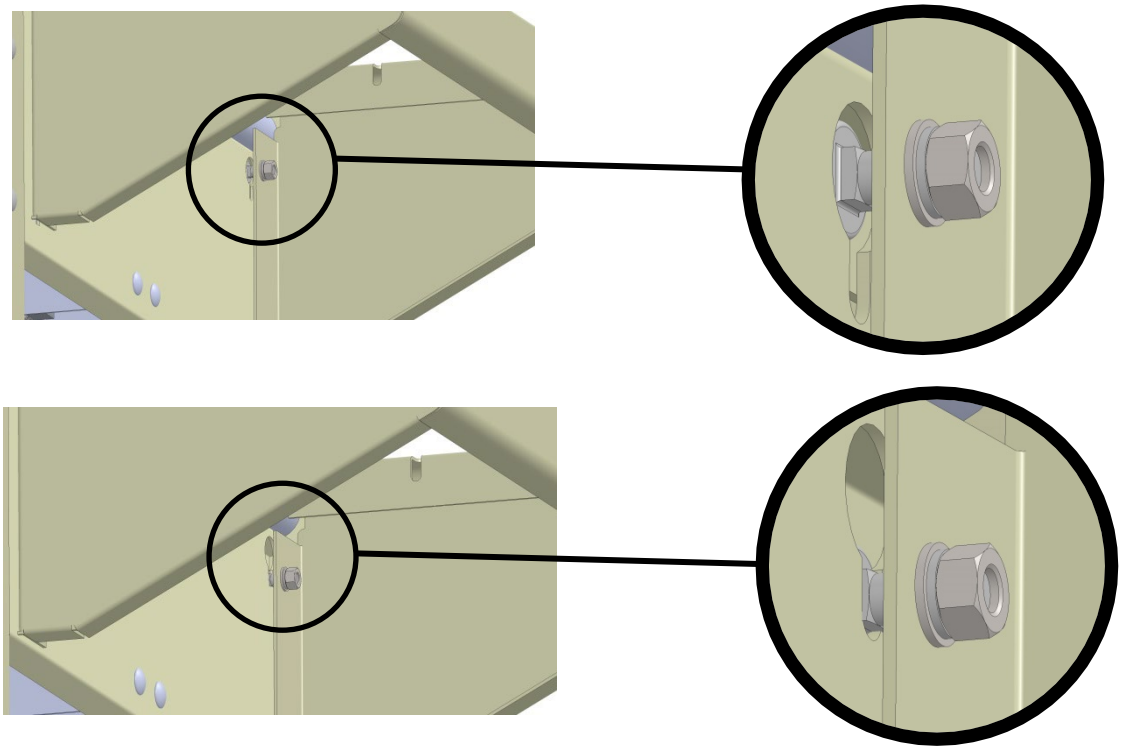


**Figure 4-6 Roller Table to Machine Base Installation**

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).

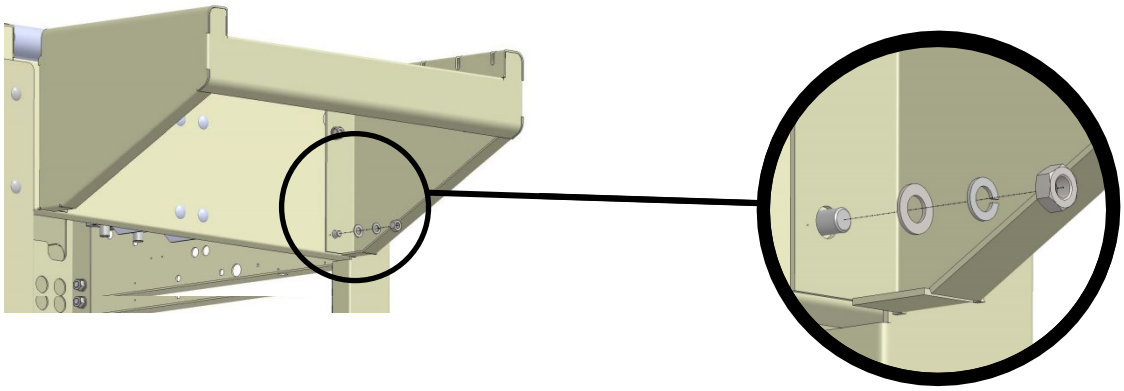


**Figure 4-7 Remaining Carriage Bolt Installation**

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.

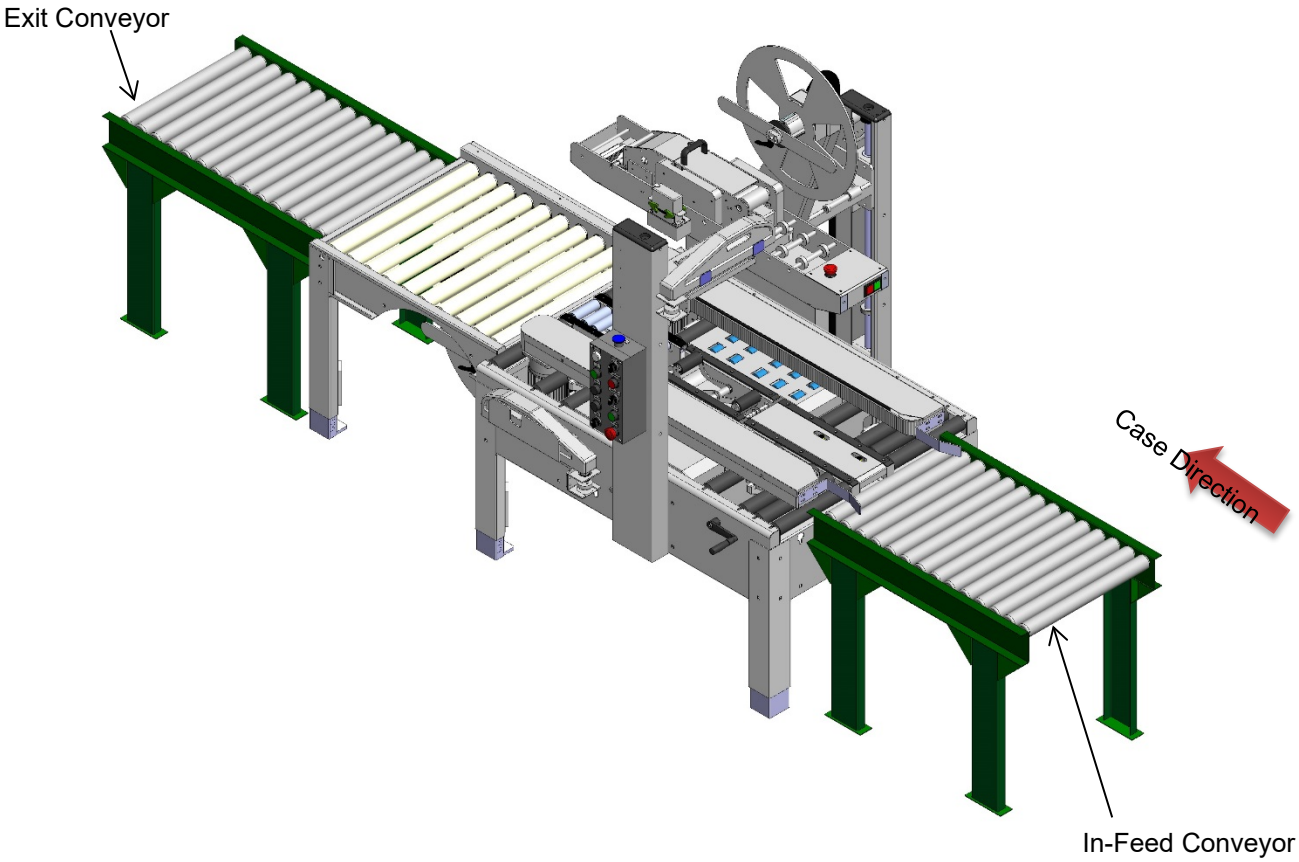



**Figure 4-8 Installing In-Feed and Exit Conveyors**

# *4.6 CONNECTING UTILITIES*

## 4.6.1 Electrical Utilities

A 12 ft (365.8cm) standard three-conductor power cord with plug is provided. 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 USA2024-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 Belt Drive button, a Tape Feed button, a Cut Tape button, a Clear button, and a Top/Both/Bottom selector switch (refer to Figure 4-11).

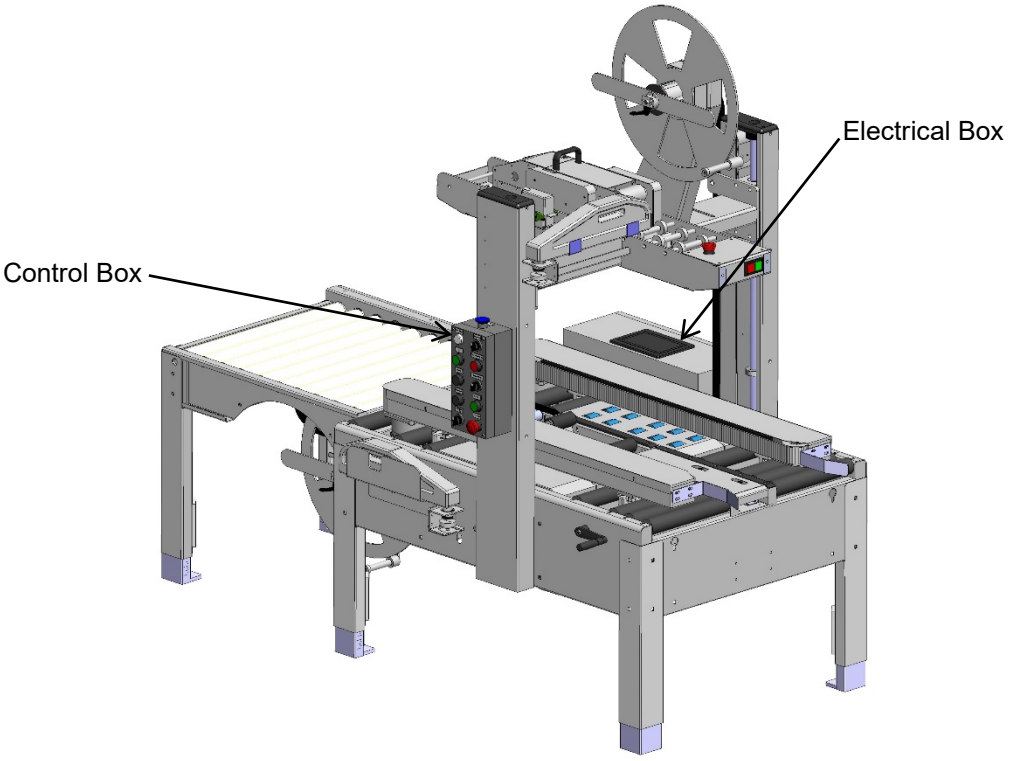



**Figure 4-9 Electrical Utilities**

| | |
|---|---|
| **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 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 USA2024-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. Turn the knob clockwise for more pressure and counterclockwise for less. When the air pressure is at 90 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**

## *4.7 OPERATOR CONTROL BOX*

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

1. Power Lamp – Electricity is being delivered throughout the machine.
2. Manual Mode/Auto Mode
   a. Auto Mode is for machine production operation.
   b. Manual Mode is for tape threading/troubleshooting.
3. Start
   a. On Auto Mode, starts machine operation.
   b. No function on Manual Mode.
4. Tape Threading/Stop
   a. On Auto Mode, stops machine operation.
   b. On Manual Mode, engages/disengages pinch roller which drives the tape.
5. Belt Drive
   a. No function on Auto Mode.
   b. On Manual Mode, jobs side belt drives.
6. Top/Both/Bottom
   a. On Auto Mode, selects the seams of the box to be taped.
   b. On Manual Mode, selects which tape head dispenses tape.
7. Tape Feed
   a. No function on Auto Mode.
   b. On Manual Mode, feeds tape on tape heads.
8. Cut Tape
   a. No function on Auto Mode.
   b. On Manual Mode, engages cutting mechanism in tape head to cut tape.
9. EMG. Stop
   a. On Auto Mode, de-energizes machine.
   b. On Manual Mode, de-energizes machine.
10. Reset
    Used to reset machine after clearing a jam.
11. Clear (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. When pressed a second time, machine will feed preset length of tape and cut it to make sure there is no jammed tape.

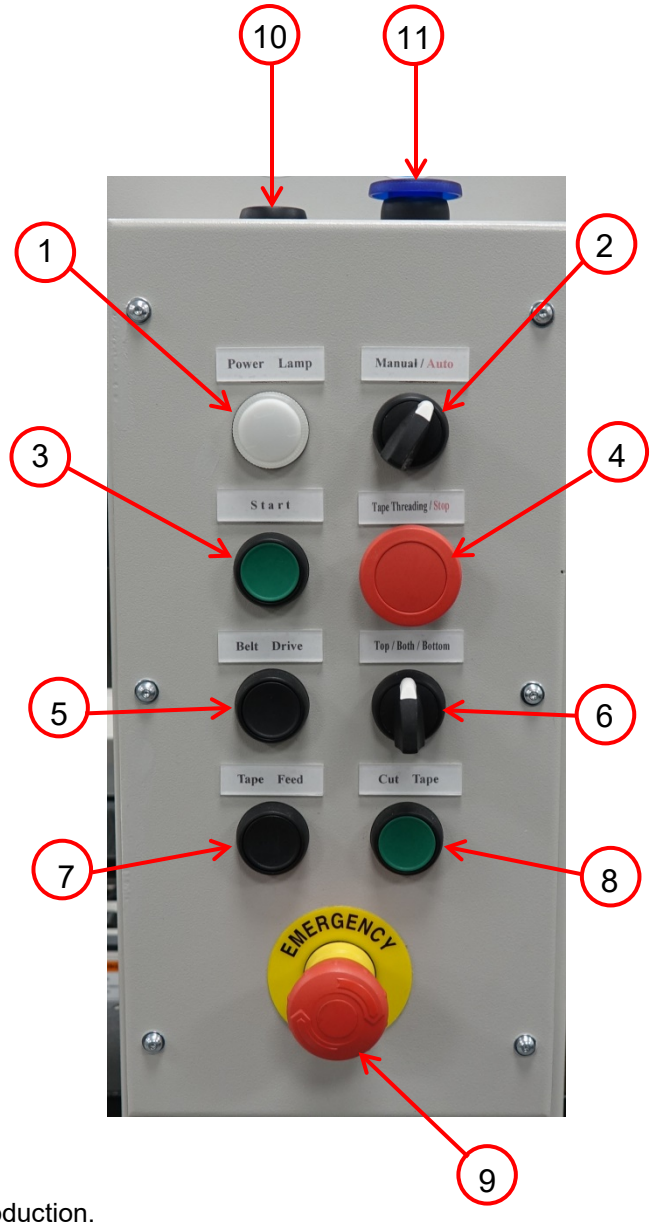



**Figure 4-11 Operator Control Box**

# *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 front panel from 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.

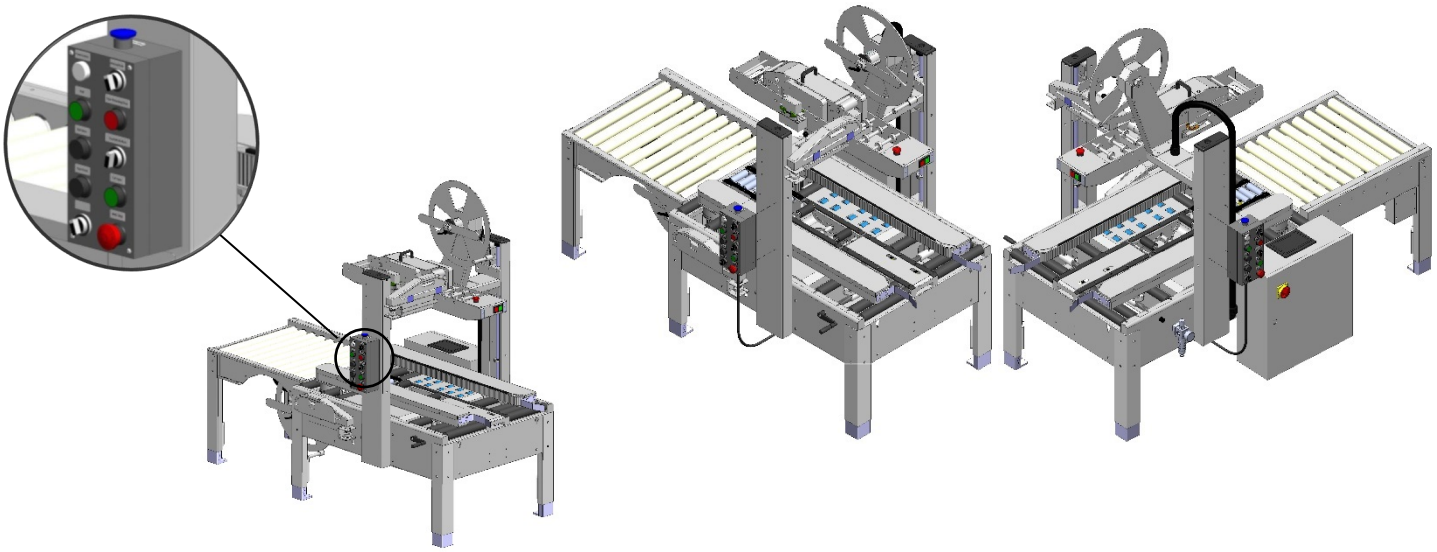


**Figure 4-12 Control Box Relocation**

# *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. Use Figure 4-13 and steps on page 4-12 for proper tape threading. 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.

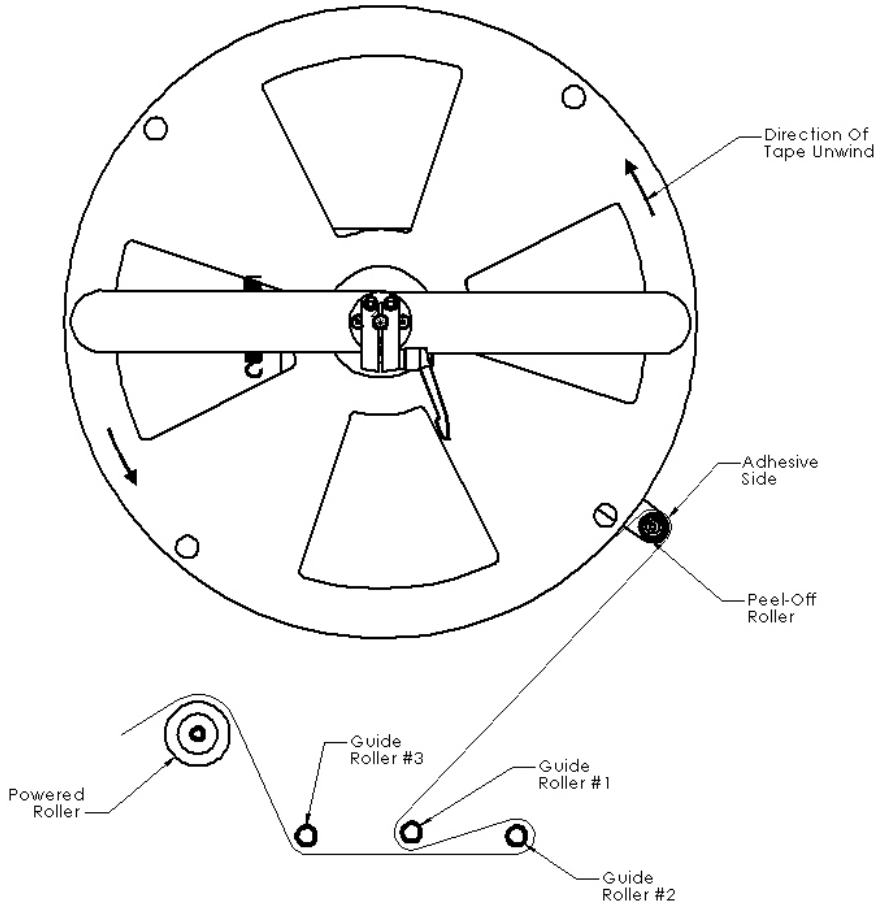



**Figure 4-13 Top Tape Threading Diagram**

### 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 4-11.

1. Put machine in Manual Mode using Manual/Auto selector switch (1, Figure 4-14).
2. Install tape roll on to mandrel making sure the unwind direction is counterclockwise (refer to page 4-11).
3. Pull tape around peel-off roller and towards the front of the machine (6, Figure 4-15).
4. Bring tape around the front of the first guide roller (8) followed by bringing the tape back towards the second guide roller (9).
5. After threading around second guide roller, pass tape under the third roller (7) and pull towards the front of the machine.
6. Bring the tape over the powered drive roller (6) and towards pinch roller (10).
7. Thread tape under guide plate until it reaches the pinch roller (10). During this process, make sure pinch roller is not engaged. To engage/disengage the pinch roller, use the Tape Threading/Stop button (2, Figure 4-14) located on the control box.
8. Once tape has been passed under the pinch roller, engage pinch roller using Tape Threading/Stop button.

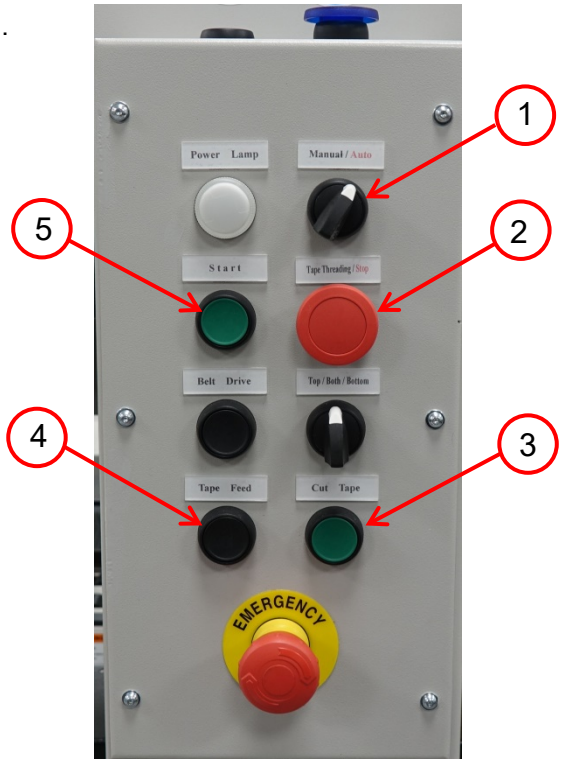



**Figure 4-14 Control Box – Top Threading**

9. Press down the Tape Feed button (4) to allow machine to pass tape through tape shoe and feed out of the tape head.
10. If tape passes with no jams, press down the Cut Tape button (3) then remove tape from tape shoe guide, switch machine to Auto (1), and press Start button (5) and hold for one second to begin machine operation. If you encounter a jam, see Clear Mode (Clear Jam), on page 5-7.

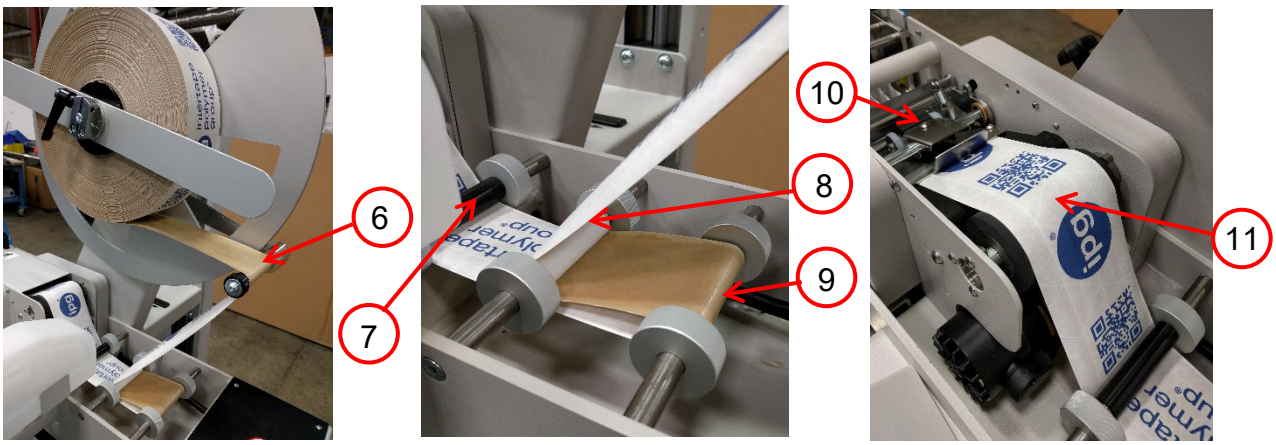



**Figure 4-15 Top Tape Head Loading/Threading**

# *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. Use Figure 4-16 and the steps on page 4-14 for proper threading of tape. 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.

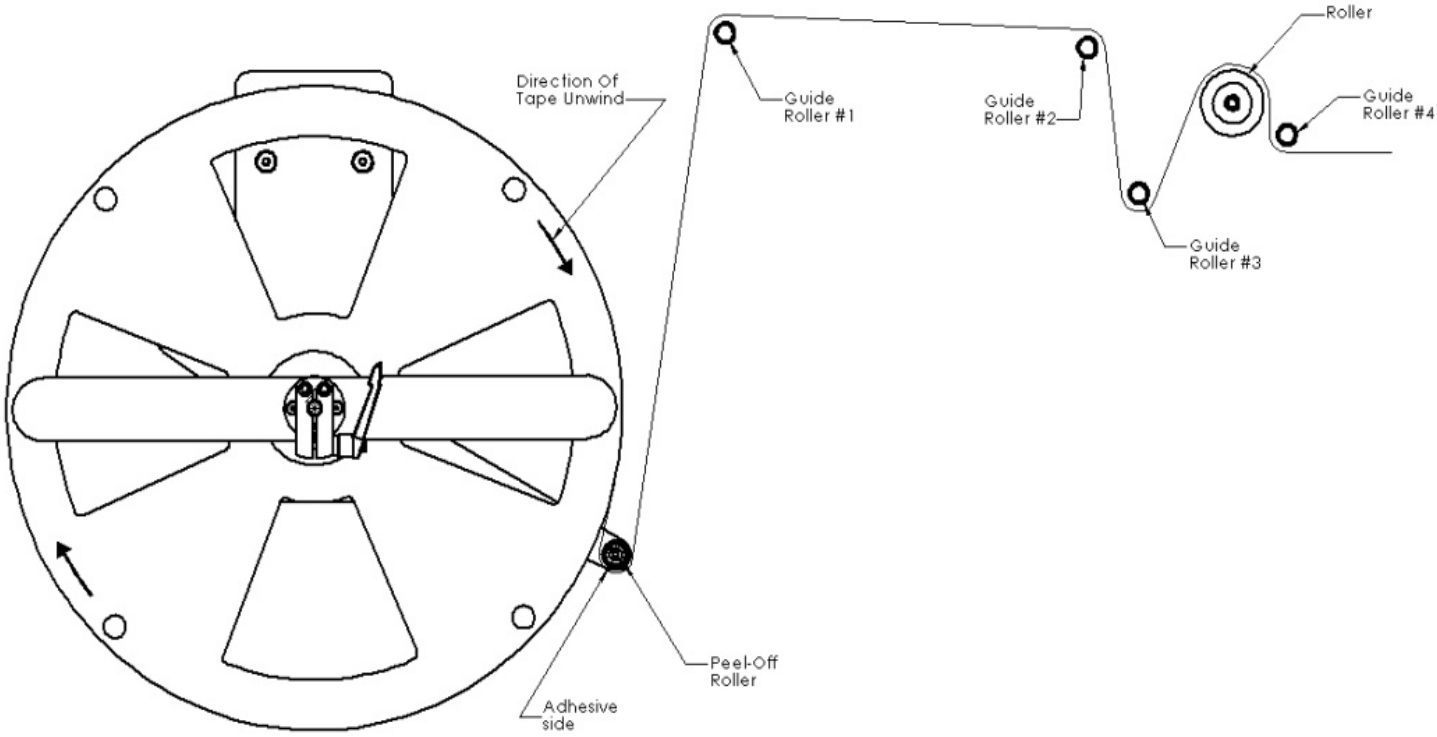



**Figure 4-16 Bottom Tape Threading Diagram**

### 4.10.3 Bottom Tape Threading/Loading Instructions

The instructions below will assist in threading of tape on the top tape head. Bottom Threading diagram is located on page 4-13.

1. Put machine in Manual Mode using Manual/Auto selector switch (1, Figure 4-17).
2. Install tape roll onto mandrel making sure the unwind direction is clockwise (refer to page 4-13). To move mandrel to tape roll installation position, pull locking lever to unlock mandrel slide handle (5, Figure 4-18) 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 (6, Figure 4-19).
4. Thread tape over the first guide roller (7), bring tape around and under the second guide roller (8), and pull towards the front of the tape head.
5. After threading through the second guide roller, pass tape over powered roller (10), pull under third guide roller (9), and bring tape up to the pinch roller (11). Ensure pinch roller is not engaged, using the Tape Threading/Stop button (2, Figure 4-17) to engage/disengage the pinch roller.
6. Once tape has been passed under the pinch roller, engage pinch roller using Tape Threading/Stop button (2).
7. Press down the Tape Feed/Cut button (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 (1), press Start button (4), and hold for one second to begin machine operation. If you encounter a jam, see Clear Mode (Clear Jam) on page 5-7.

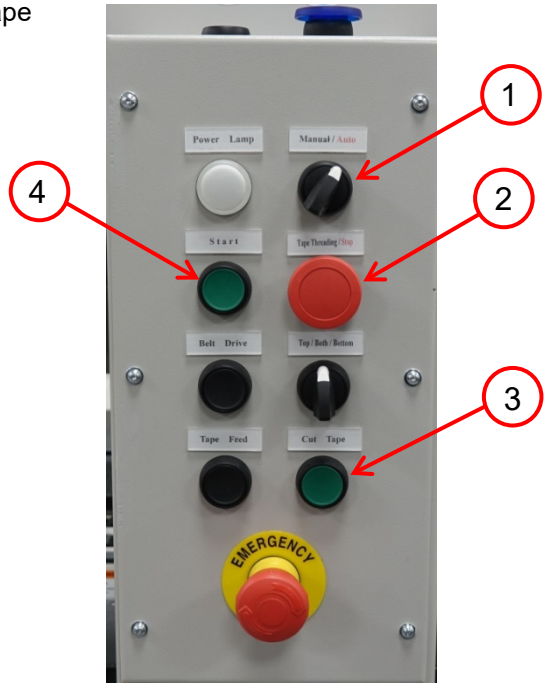



**Figure 4-17 Control Box – Bottom Threading**

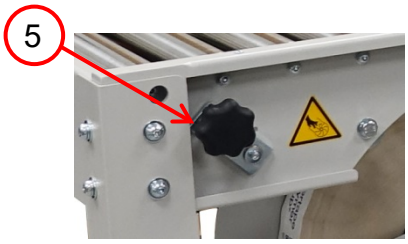



**Figure 4-18 Mandrel Slide Handle**

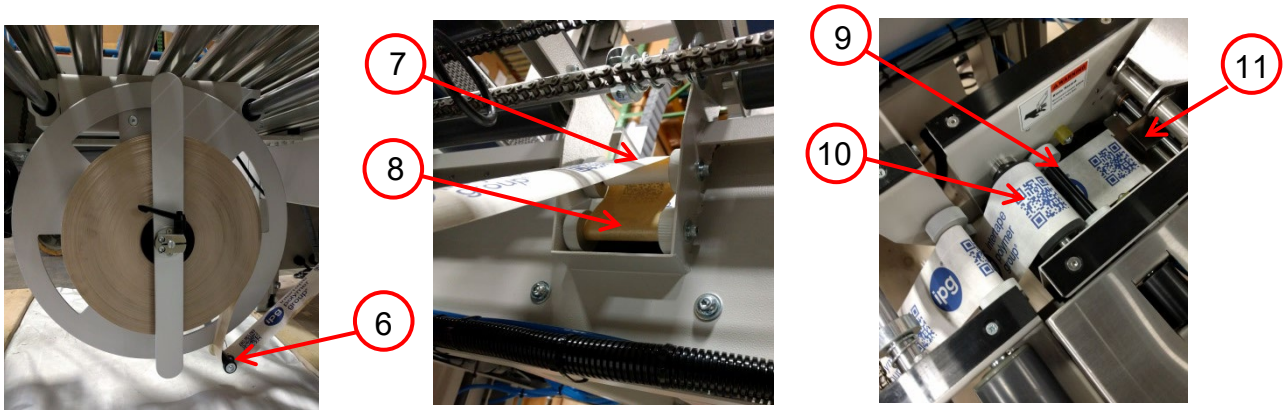



**Figure 4-19 Bottom Tape Head Loading/Threading**

## *4.11 ADDING WATER TO THE SYSTEM*

1. Remove the water bottles by pulling them straight up from support brackets (refer to Figure 4-20).
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.

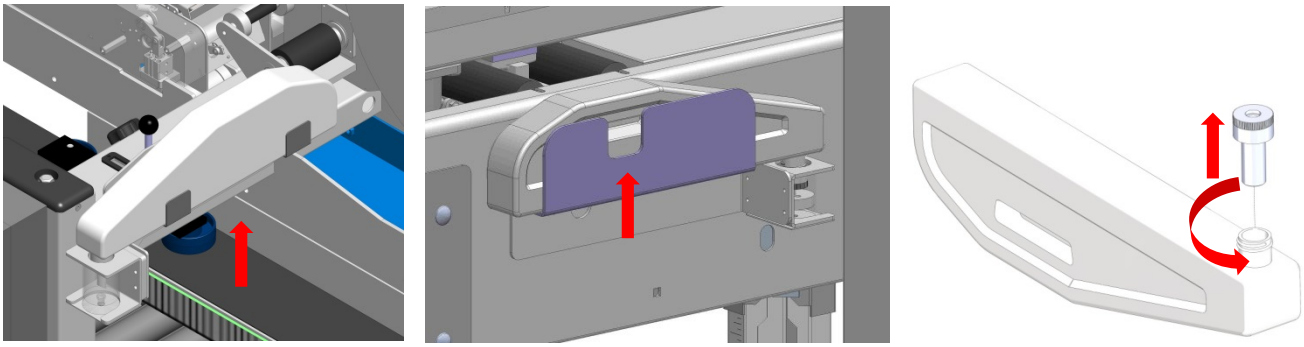


**Figure 4-20 Adding Water to the System**

## Notes

# 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 USA2024-WAT-EU Case Sealer.

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 90 PSI.
6. Supply or connect machine to 220 VAC electrical supply.
7. Turn on main power disconnect switch located on machine electrical box.
8. Twist both E-stops, on the control box and the outfeed conveyor, clockwise to release and 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 5-14).
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 5-14).

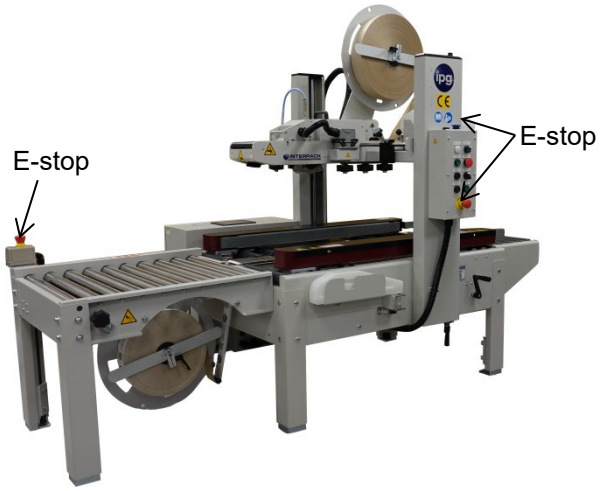



**Figure 5-1 E-stop Locations**

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 5-14).
13. Press Start button on the control box, and hold for one second to begin machine operation (refer to Figure 5-14).
14. Introduce a case to the machine indexing gate.
15. Once box has been processed, machine is ready for production.

## *5.2 CASE SIZE SET-UP FUNCTIONS*

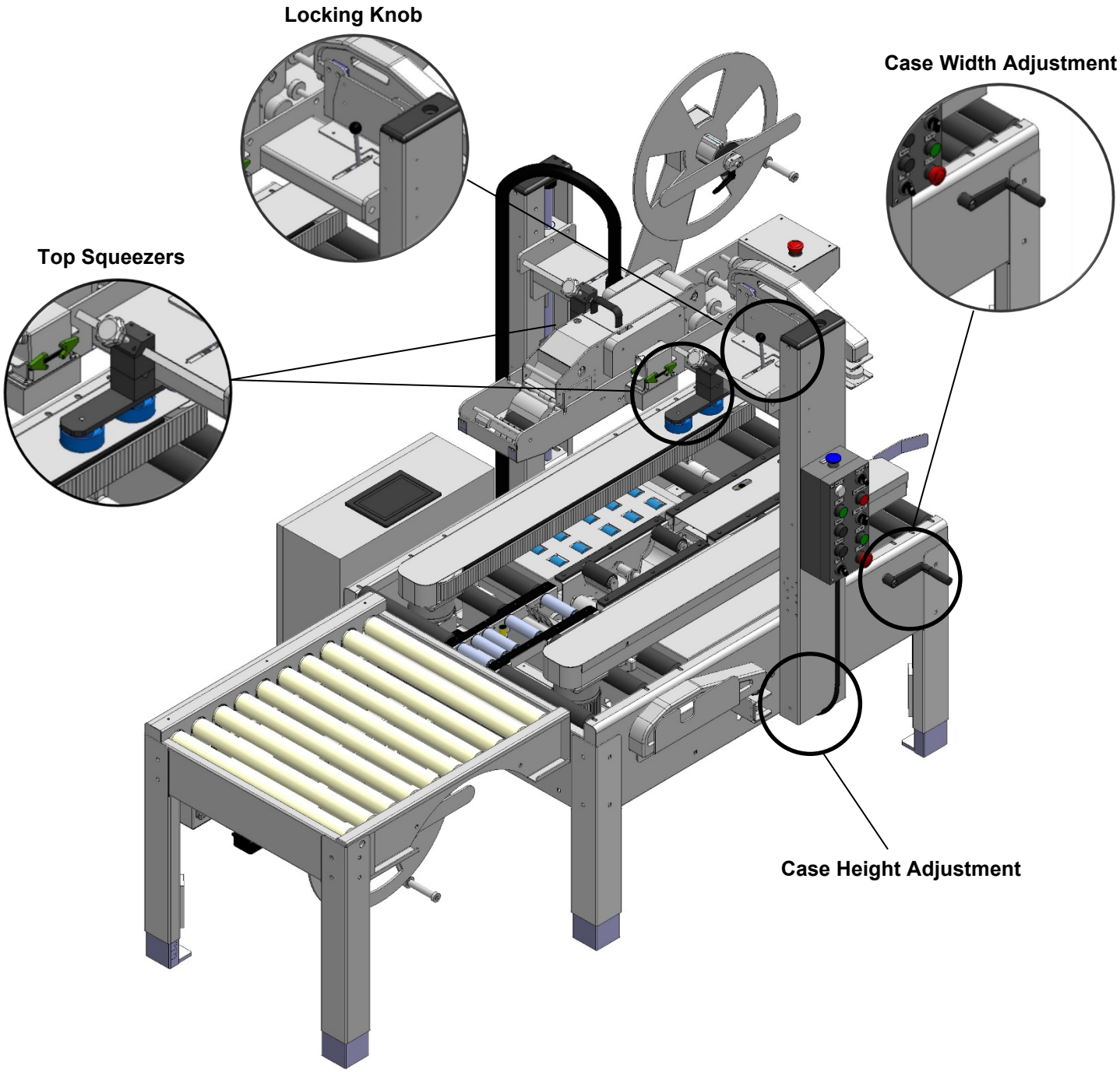



**Figure 5-2 Case Size Set-Up**

## 5.3 INITIAL CONDITION

1. Using the height adjustment handle, raise the upper head, as shown in Figure 5-3.
2. Using the width adjustment handle, open side drives or centering guides, as shown in Figure 5-4.
3. Loosen each locking knob and open top squeezers, as shown in Figure 5-5.

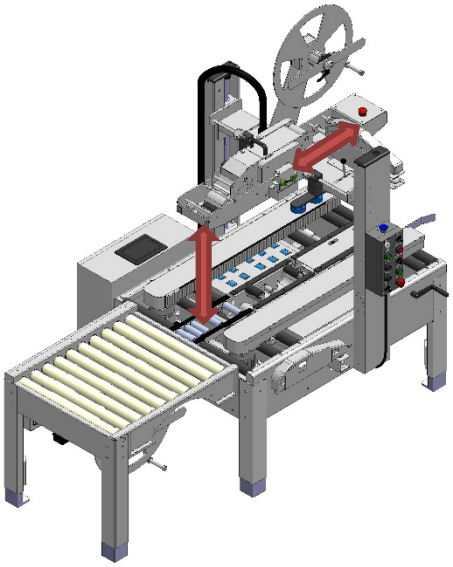


**Figure 5-3 Raise Upper Head**

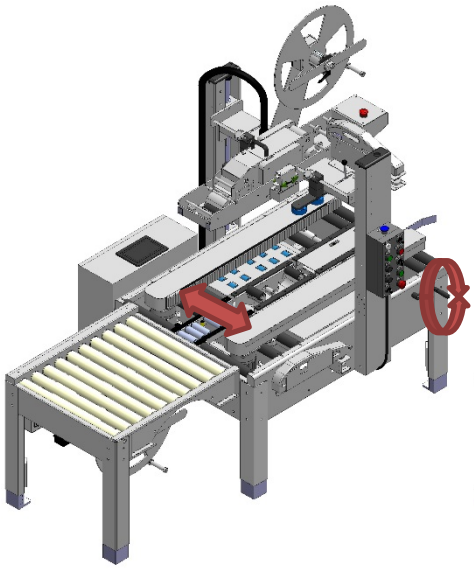


**Figure 5-4 Open Side Drives**

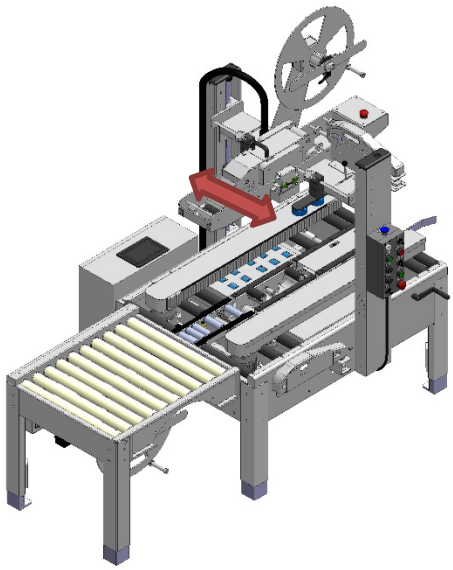


**Figure 5-5 Open Top Squeezers**

## 5.4 PREPARING CASE TO BE PROCESSED

### 5.4.1 Flap Folding

1. Fold minor flaps inward, as shown in Figure 5-6.
2. Fold major flaps inward, as shown in Figure 5-7.

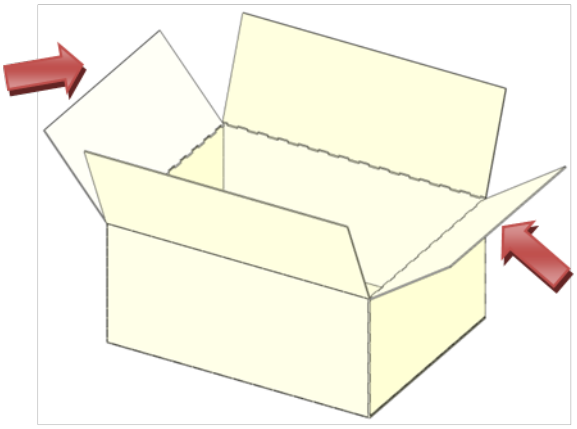


**Figure 5-6 Fold Minor Flaps**

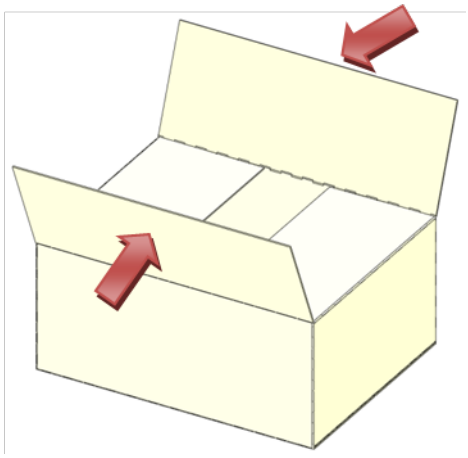


**Figure 5-7 Fold Major Flaps**

### 5.4.2 Overfills and Voids

Overfills and Void Fills, as shown in Figures 5-8 and 5-9, should be avoided to assure proper processing of the corrugated case. Each of these scenarios put stress on the pressure sensitive tape seal which could be detrimental to the integrity of the closure.

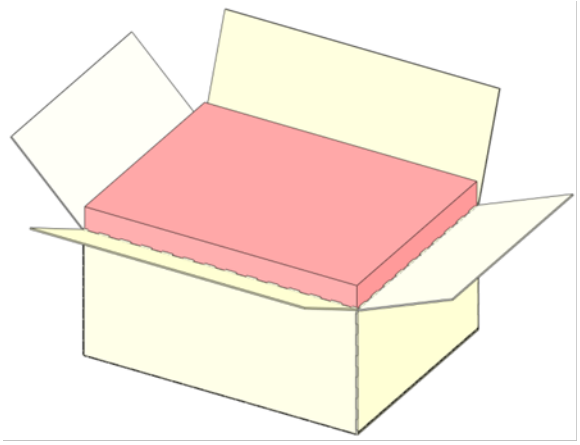


**Figure 5-8 Overfill**

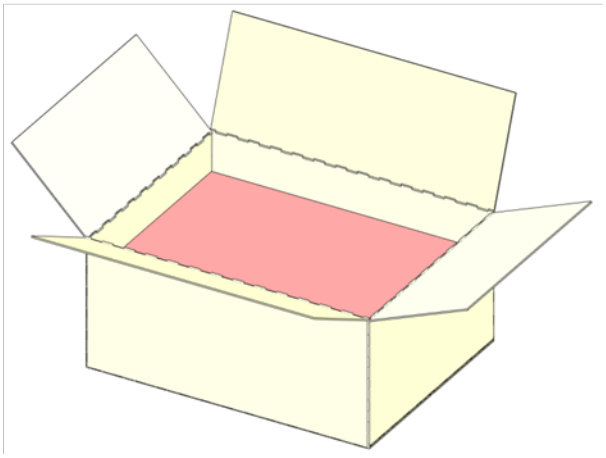


**Figure 5-9 Void Fill**

## *5.5 CASE HEIGHT ADJUSTMENT*

1. Insert the case to just before lower tape head, as shown in Figure 5-10.
2. Move locking handle to unlock position. Turn case height handle, as shown in Figure 5-11, to lower the upper head until it contacts top of case. Upper head should contact case firmly enough to keep major flaps closed but not restrict processing of case or score the top of case. Move locking handle to locked position.

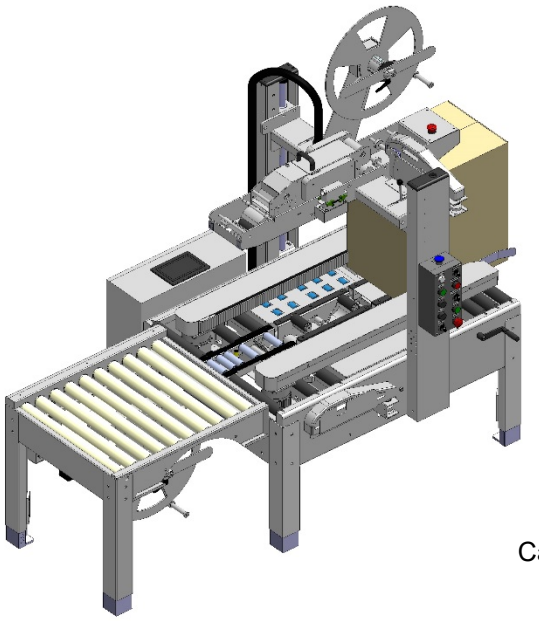


**Figure 5-10 Insert Case**

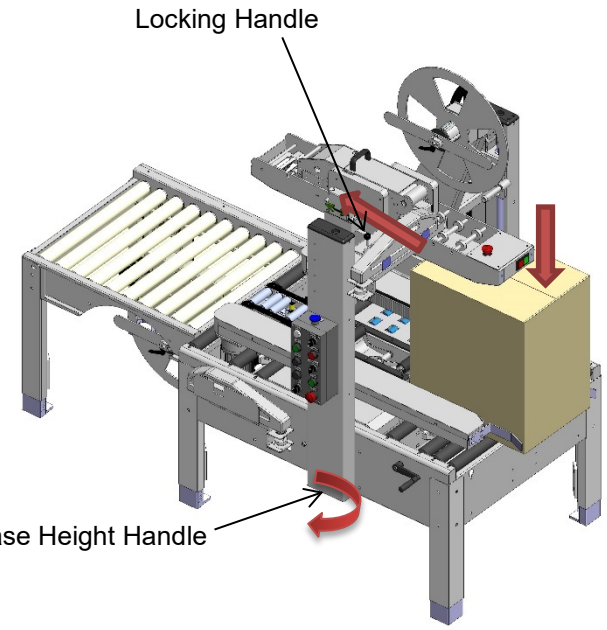



**Figure 5-11 Adjust Upper Head**

## 5.6 CASE WIDTH ADJUSTMENT

Turn case width handle, as shown in Figure 5-12, until side drive belts contact case. Side drive belts should contact the case firmly enough so case processes smoothly but not so firm as to score the side of the case.

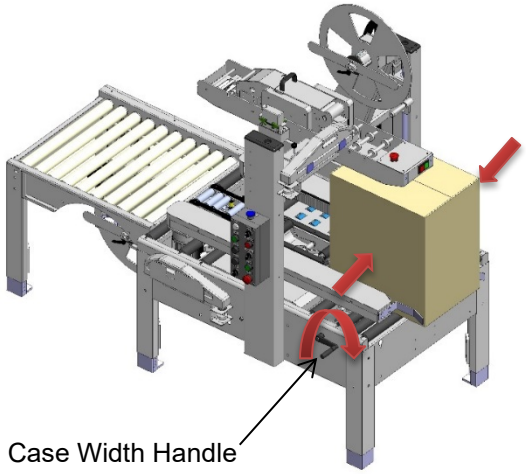



**Figure 5-12 Case Width Adjustment**

## 5.7 TOP SQUEEZER ADJUSTMENT

Slide each top squeezer to contact the case firmly and tighten each locking knob, as shown in Figure 5-13. Each top squeezer should be firm enough on the case to completely close any gap on the center seam but not so firm as to restrict the smooth processing of the case.

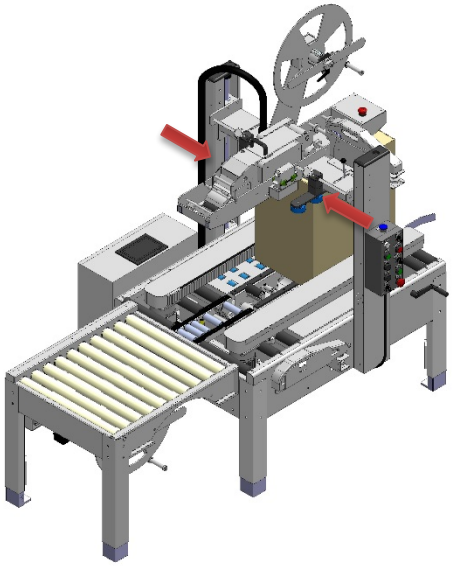


**Figure 5-13 Top Squeezer Adjustment**

# 5.8 CONTROL BOX

Once the tape has been loaded on both the top and bottom and threaded (refer to Top Tape Head Loading/Threading on page 4-11 and Bottom Tape Head Loading/Threading on page 4-13), allow up to 10 minutes of being powered on for the machine to be completely ready to process regular slotted cases. The following instructions are presented in the order recommended for processing cases successfully through the USA2024-WAT-EU Case Sealer.

The USA2024-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 5-14).

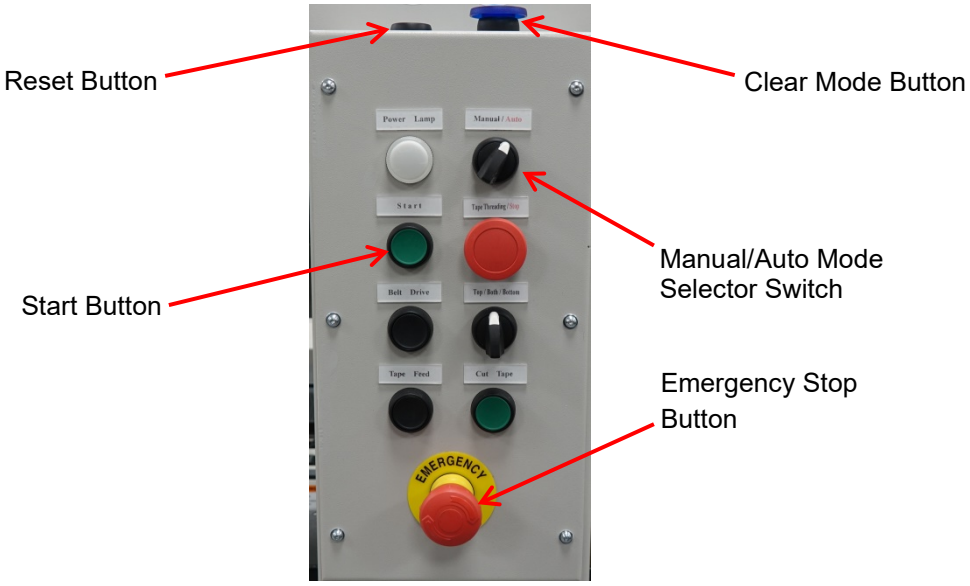



**Figure 5-14 Control Box**

## 5.8.1 Auto Mode

This is the standard operating mode of the machine. In this mode, when a case is being processed, the side belts will process a case and then tape is applied to the top and bottom center seams of the case.

1. Ensure that the compressed air is plugged and at 90 PSI.
2. Turn the Manual/Auto selector switch on the control box to Auto (Automatic) (refer to Figure 5-14).
3. Using adjustment handles, set the height of the upper head to match case height and set the side belts to match the width of case to be processed.
4. Press the Start button and hold for one second; the drive belts will start.
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 case will be processed and tape applied to top and bottom center seams.
7. Once the case is processed and exits the machine, the indicator light at the front of the machine will change from red to green indicating that the machine is ready for another case to be processed.

### 5.8.2 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 5-14).
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 4-9, for an explanation of button usage.

### 5.8.3 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 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 5-14).
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 4-15).
   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. Pressing the Clear Mode button a second time will feed a preset length of tape and cut. If no tape is dispensed, refer to Chapter 6, Troubleshooting.
7. 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

# Chapter 6
# TROUBLESHOOTING

The USA2024-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 220 V, 50 HZ, 10A electrical service. |
| | Machine set to manual operation. | Switch machine to auto using selector switch (page 4-9). |
| | Clear mode activated. | Press clear button on control box to deactivate clear mode (page 4-9). |
| 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). |
| | 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 width of side belt drives. |
| Case processes but side of case is crushed. | Case width adjustment incorrect. | Re-adjust case width (page 5-5). |
| 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. |
| Drive belts start then stop. | Motor starter trips. | Call maintenance. |

| Trouble | Possible Causes | Solutions |
|---|---|---|
| Overfilled cases do not process properly. | Product height exceeds case height. | Reduce product in case to match case height.<br>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 4-11; page 4-13). |
| 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 4-11; page 4-13). |
| | 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. |
| | 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. |
| | Water pot not seated properly. | Re-seat water pot (page 4-15). |
| | Roller dry; no or low water pot level. | Add water or adjust water bottle level (page 4-15). |

| Trouble | Possible Causes | Solutions |
|---|---|---|
| Tape is too dry. | Worn roller. | Replace roller. |
| | Water level in water pot too low. | Adjust water level in water pot (page 4-15). |
| | 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 4-15). |
| | Water bottle is out of water. | Refill water bottle (page 4-15). |
| | 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 4-15). |
| | 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 4-11; page 4-13). |
| | 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 4-15). |
| | Tape threaded incorrectly. | Thread tape correctly (page 4-11; page 4-13). |
| | 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. |

| 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 90 PSI. |
| | Tape tension is incorrect. | Thread tape correctly (page 4-11; page 4-13). |
| | Motor RPM is incorrectly set. | Adjust motor RPM in HMI. |
| | Tape not threaded properly. | Thread tape correctly (page 4-11; page 4-13). |

# Chapter 7
# PREVENTIVE MAINTENANCE

## 7.1 MACHINE PREVENTIVE MAINTENANCE

The USA2024-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.

**Figure 7-1 Machine Preventive Maintenance Chart**

| | | | 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 | | |

# *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).

### 7.2.2 Column Shaft

1. With a cloth, wipe down any accumulation of dust and dirt (refer to Figure 7-2).

2. Be sure to wipe down both columns.

### 7.2.3 Connecting Chain for Centering Assembly

Blow off any accumulation of dust and dirt from the connecting chain (refer to Figure 7-2).

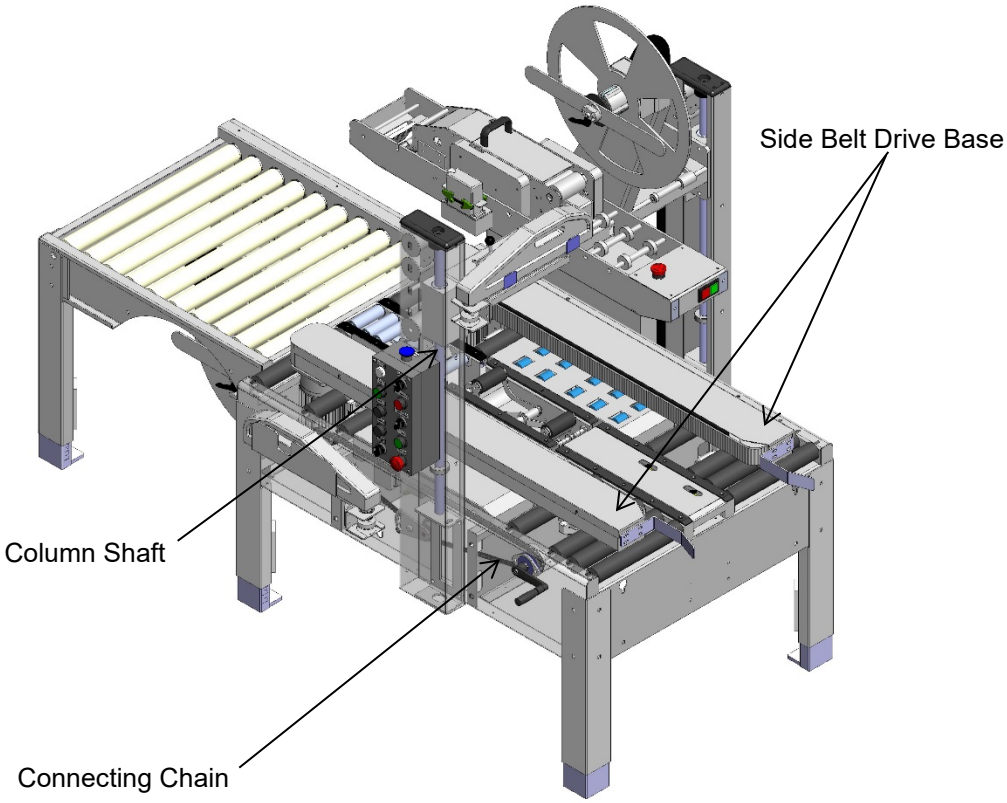



**Figure 7-2 Cleaning the Machine**

## *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).

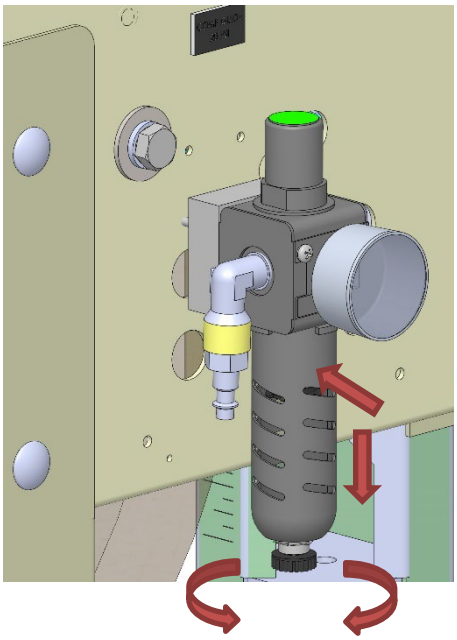


**Figure 7-3 Remove Guard**

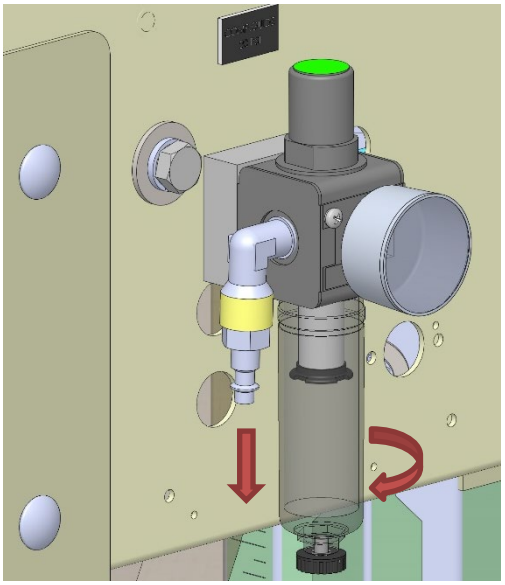


**Figure 7-4 Remove Reservoir**

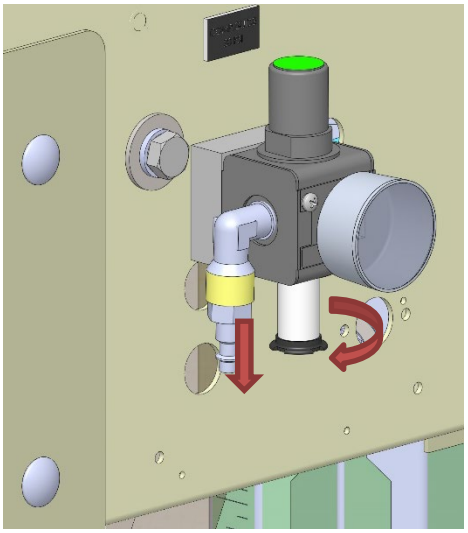


**Figure 7-5 Remove Filter**

# *7.4 LUBRICATING THE MACHINE*

### 7.4.1 Column Shaft

Lubricate both shafts with industrial grade silicone.

### 7.4.2 Acme Drive Base Shafts

Lubricate both shafts with light machine grease.

### 7.4.3 Centering Chain

Lubricate chain with chain lubricant.

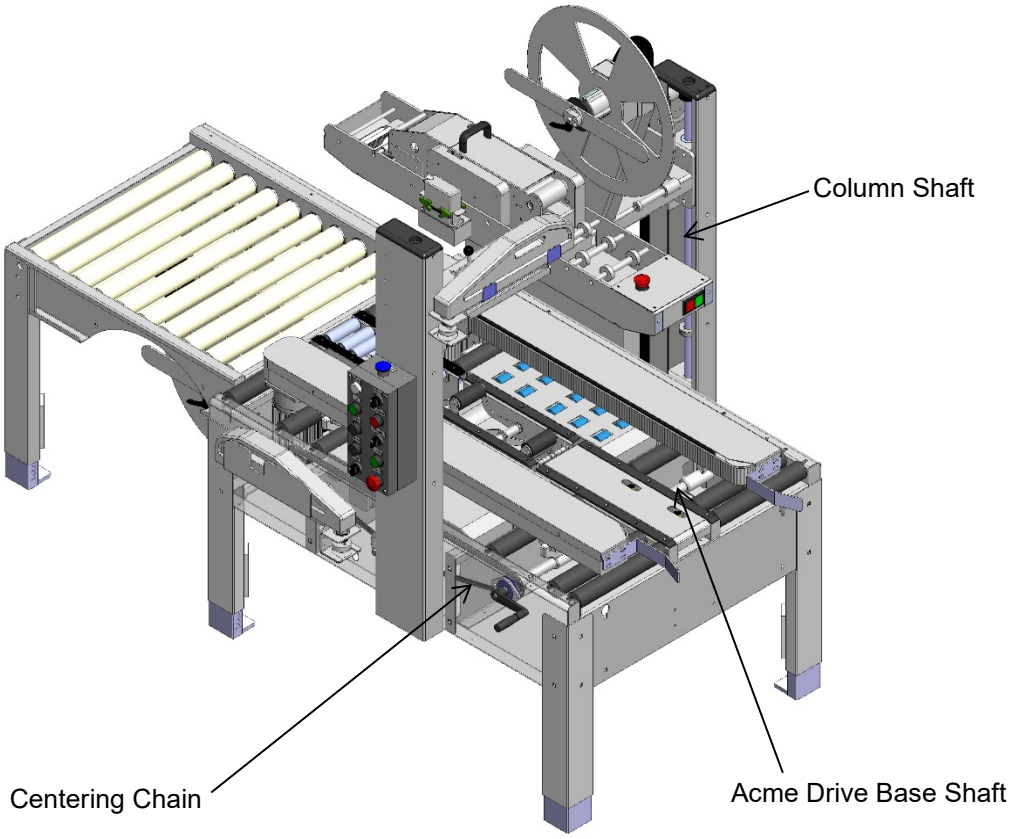



**Figure 7-6 Lubricating the Machine**

## *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, as shown on Figure 7-7.
2. Disconnect electrical connection of tape head by unhinging and removing plug, as shown in 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, as shown in Figure 7-9.

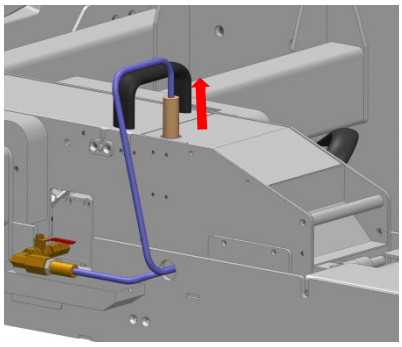


**Figure 7-7 Quick-disconnect**

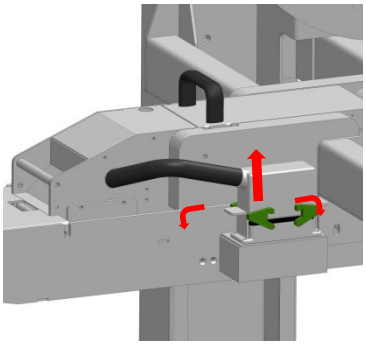


**Figure 7-8 Electrical Disconnect**

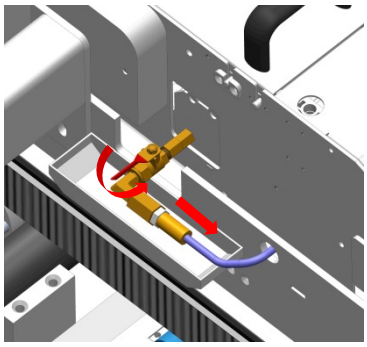


**Figure 7-9 Quick-disconnect**

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

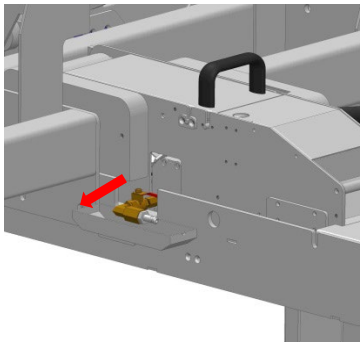


**Figure 7-10 Remove Water Pot**

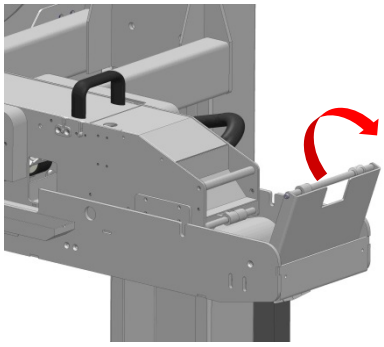


**Figure 7-11 Pull Hold-down Plate**

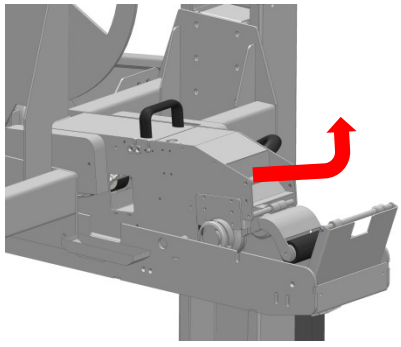


**Figure 7-12 Remove Tape Head Box**

## 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, as shown on Figure 7-13.
2. Disconnect electrical connection of tape head by unhinging and removing plug, as shown on 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, as shown on Figure 7-15.

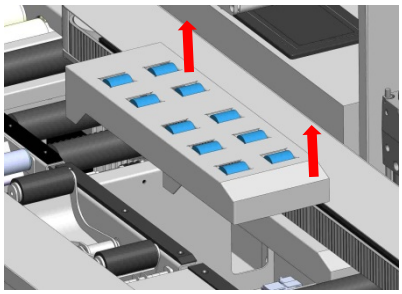


**Figure 7-13 Remove Side Covers**

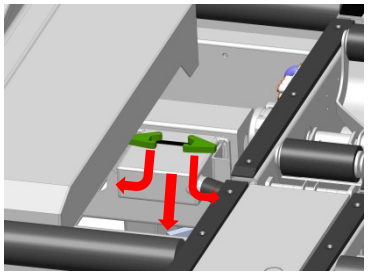


**Figure 7-14 Electrical Disconnect**

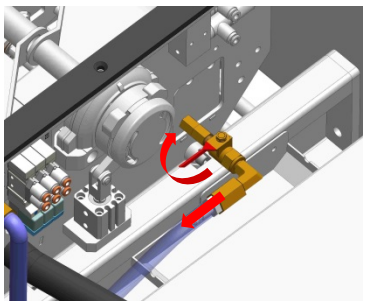


**Figure 7-15 Quick-disconnect**

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

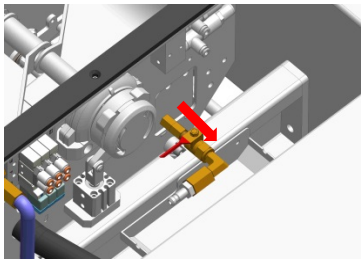


**Figure 7-16 Remove Water Pot**

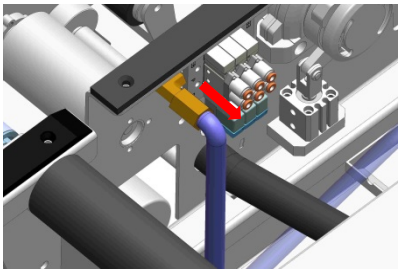


**Figure 7-17 Quick-disconnect**

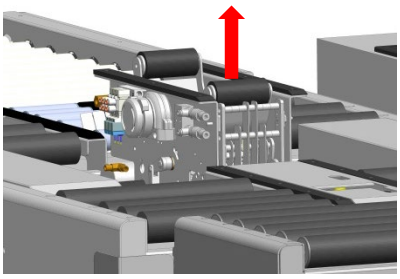


**Figure 7-18 Lift Tape Head**

# *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, as shown in Figure 7-19.
2. Remove tape shoe and water pot from tape head, as shown in 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.

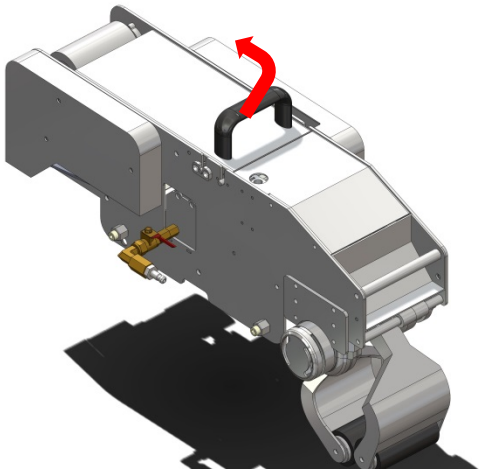


**Figure 7-19 Remove Top Cover**

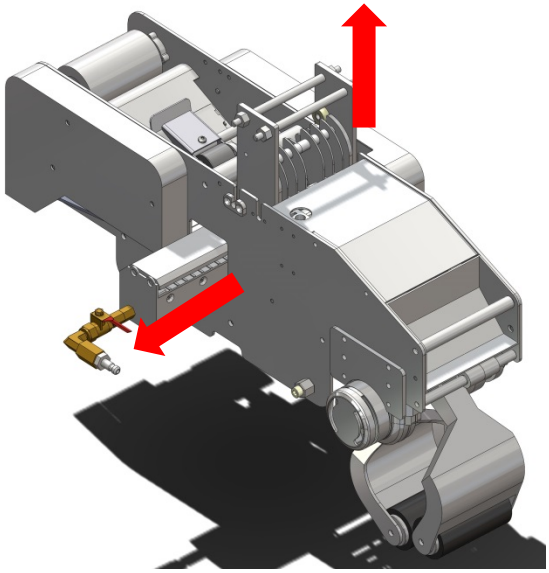


**Figure 7-20 Remove Tape Shoe and Water Pot**

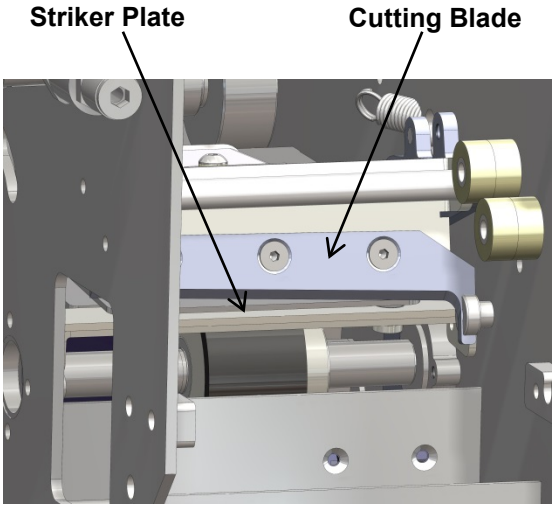



**Figure 7-21 Clean Striker Plate**

## *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, as shown in 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.

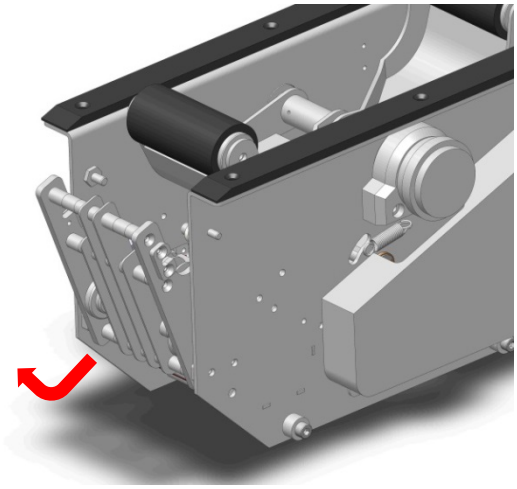


**Figure 7-22 Remove Tape Shoe**

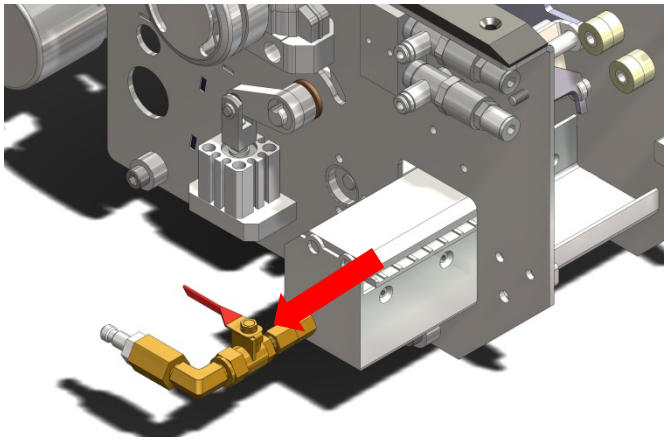


**Figure 7-23 Remove Water Pot**

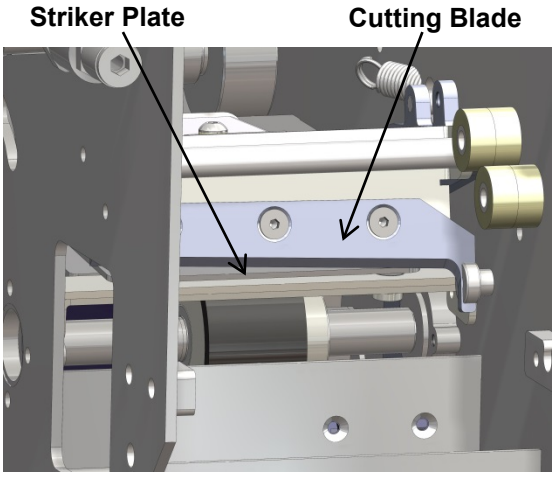



**Figure 7-24 Clean Striker Plate**

# *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 raise 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.
2. Remove the water pot.
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.

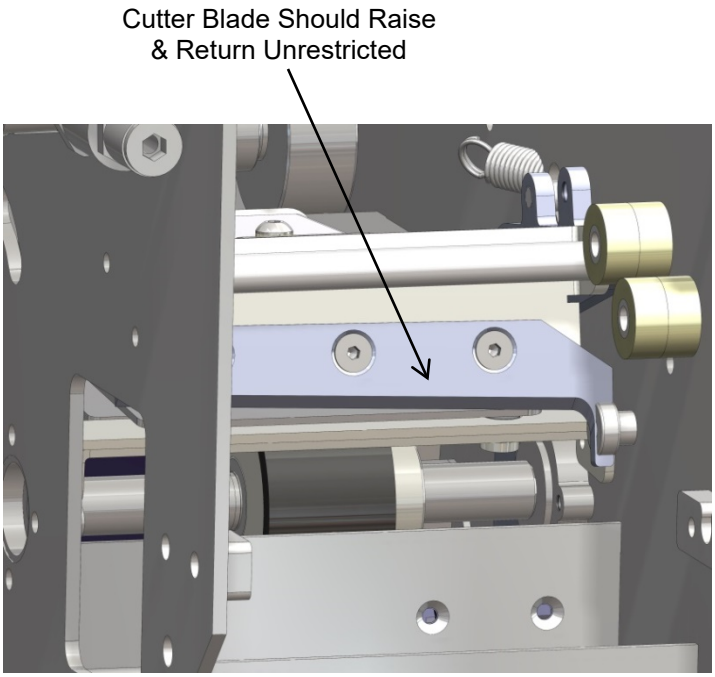



**Figure 7-25 Cutter Blade Maintenance**

## *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 the tape shoe assembly.
2. Remove the water pot assembly.
3. Remove the upper guide plate.
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.

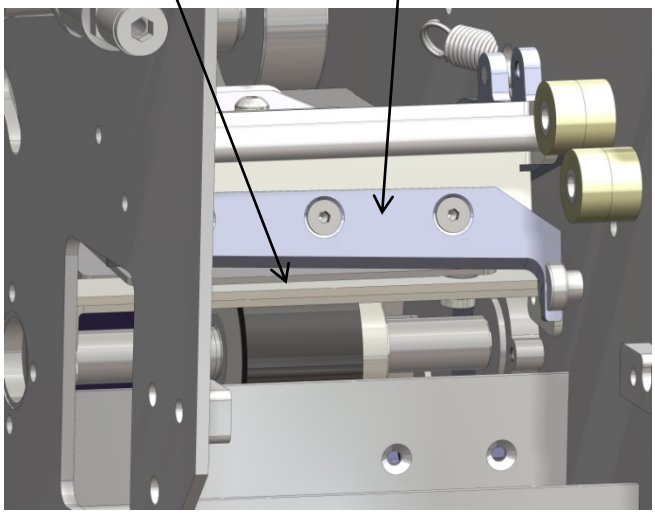



**Figure 7-26 Striker Plate and Cutting Blade**

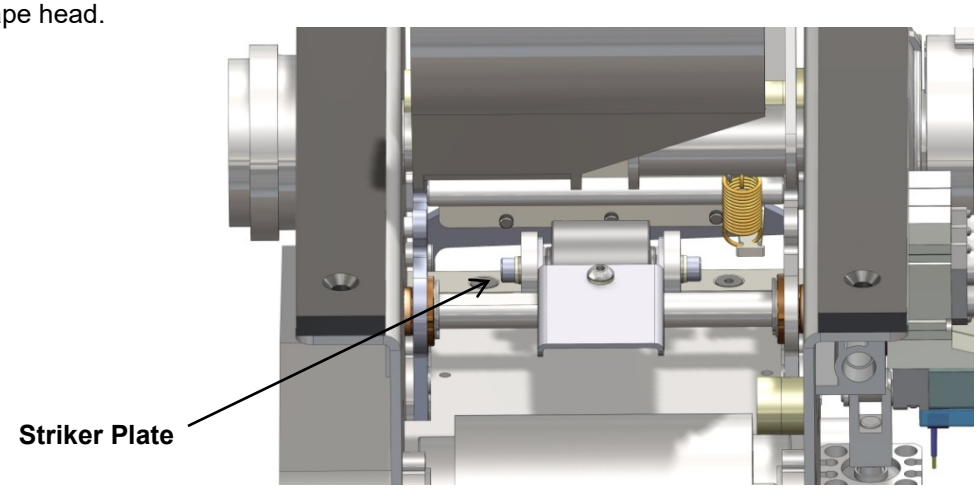
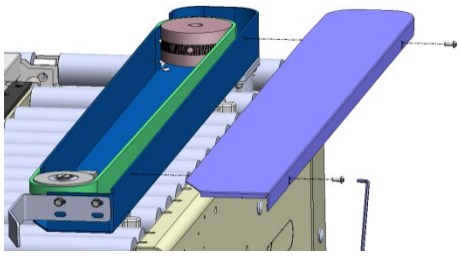
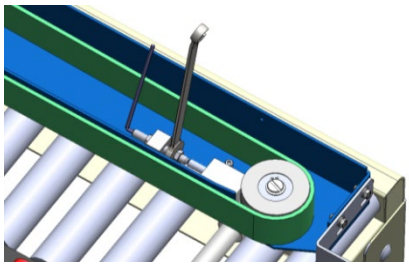
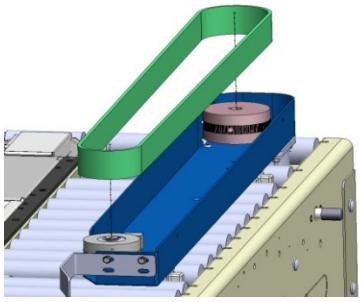
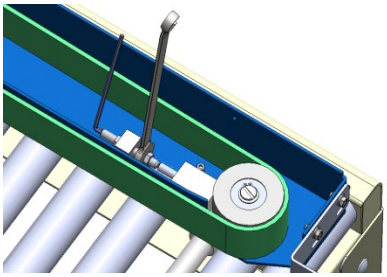
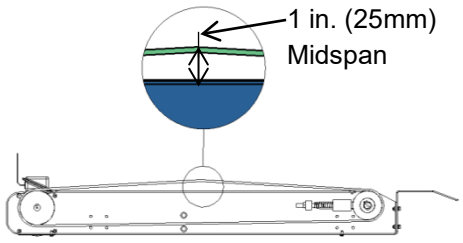
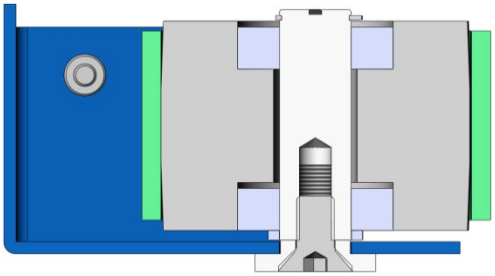
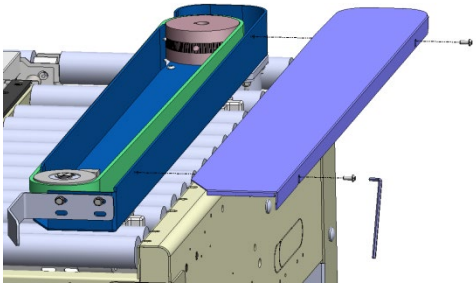



**Figure 7-27 Striker Plate**

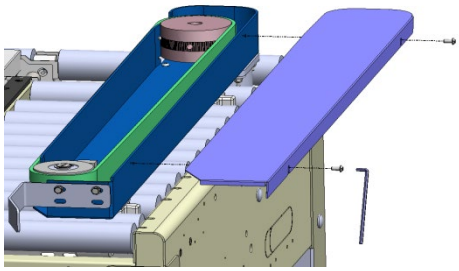
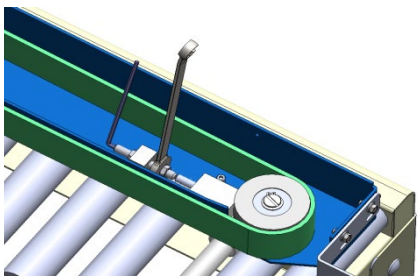
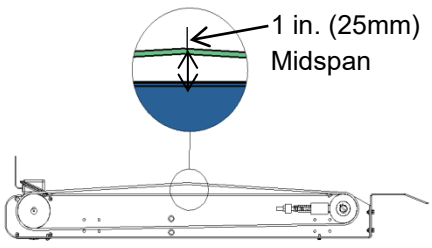
# Chapter 8
# MACHINE MAINTENANCE & ADJUSTMENT

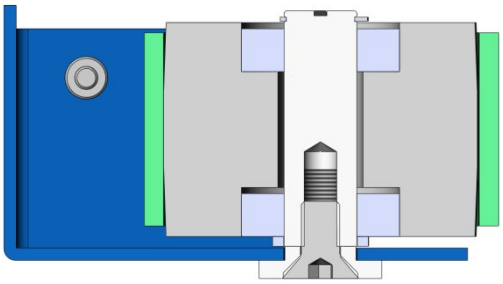
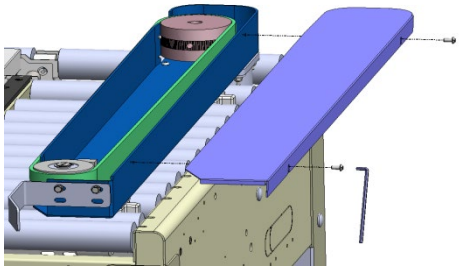
## 8.1 DRIVE BELT REPLACEMENT

| | |
|---|---|
| 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.<br><br>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 1 in. (25mm) gap, as shown in the middle of the drive base. |  |

| | |
|---|---|
| Intertape S/B drive idler pulleys are engineered to self-track to center.<br><br>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.<br><br>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 1 in. (25mm) gap as shown in the middle of the drive base. |  |

| | |
|---|---|
| Intertape S/B drive idler pulleys are engineered to self-track to center.<br><br>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

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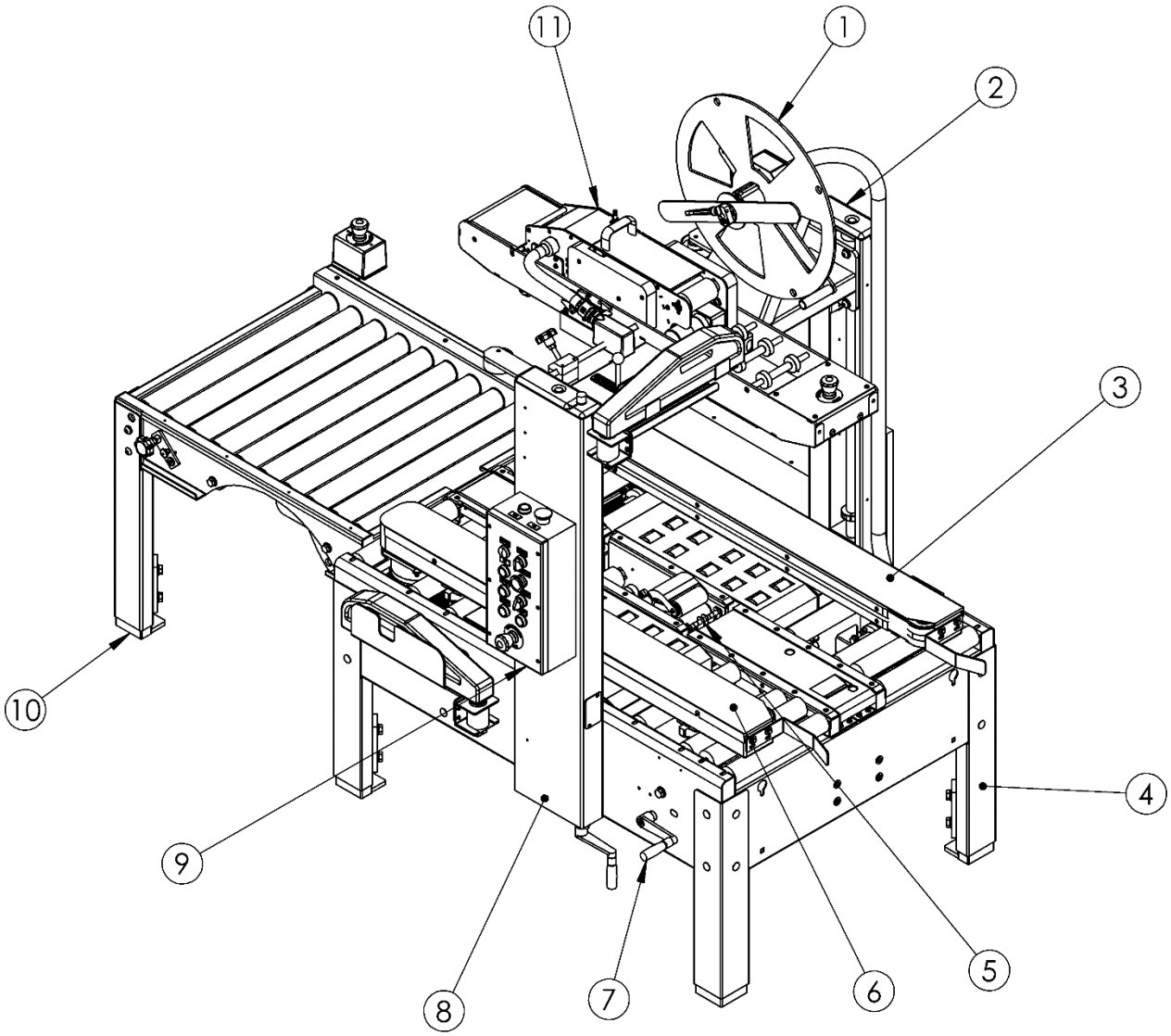
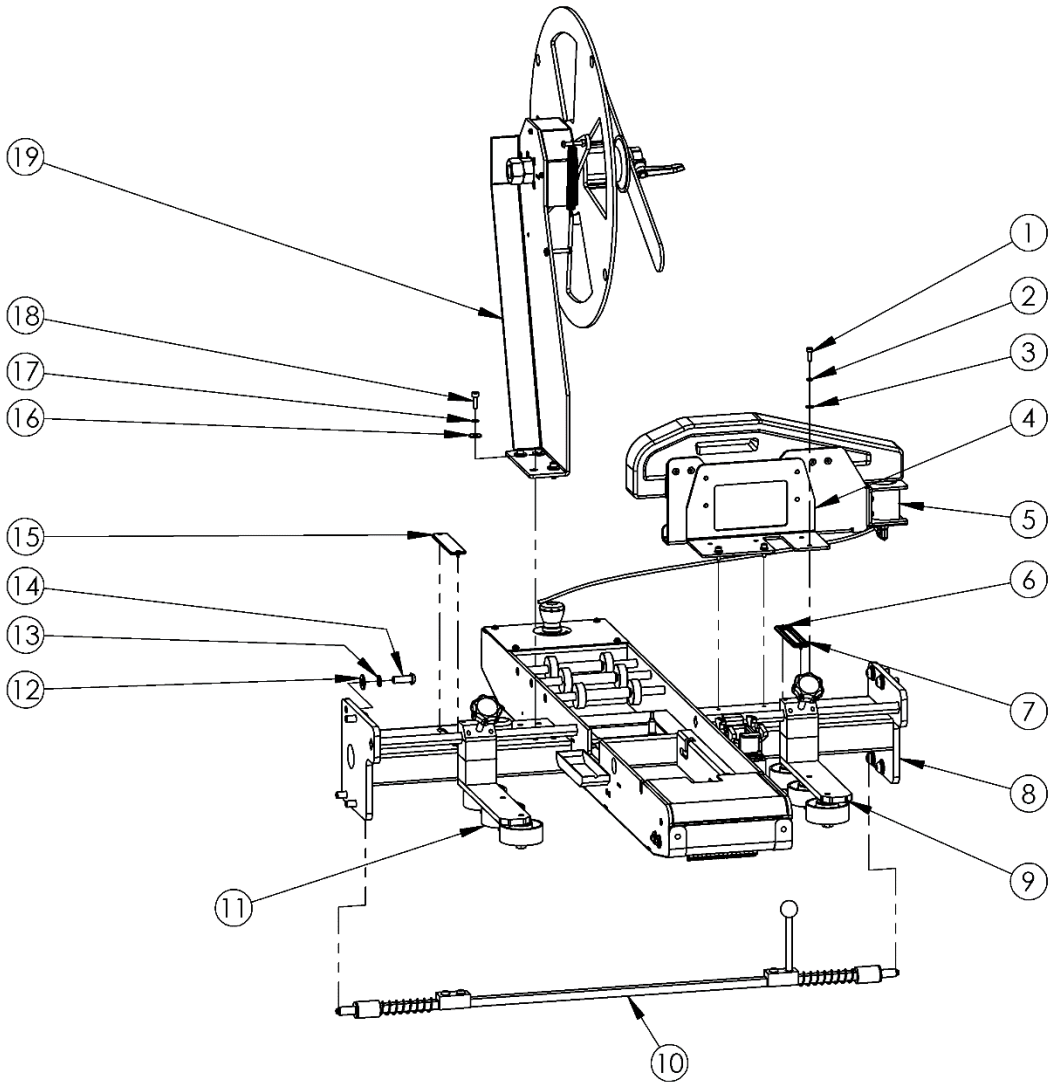
# *9.1 UM805T - USA2024-WAT-EU TOP LEVEL ASSEMBLY*



USM0868 - USA2024-WAT-EU CASE SEALER

| ITEM | PART NUMBER | DESCRIPTION | QTY. |
|---|---|---|---|
| 1 | UAM0512 | BRIDGE ASSEMBLY | 1 |
| 2 | UAM0487 | COLUMN ASSEMBLY, R.H. | 1 |
| 3 | UAM0511 | DRIVE UNIT, R.H | 1 |
| 4 | USM0867 | BASE ASSEMBLY | 1 |
| 5 | WST1036 | BOTTOM TAPE HEAD | 1 |
| 6 | UAM0510 | DRIVE UNIT, L.H | 1 |
| 7 | UAM0508 | GUIDE ADJUSTMENT ASSEMBLY | 1 |
| 8 | UPM5987 | COLUMN ASSEMBLY, ADJUSTABLE, L.H. | 1 |
| 9 | UAM0488 | CONTROL BOX | 1 |
| 10 | UAM0489 | OUTPUT TABLE | 1 |
| 11 | WST1047 | TOP TAPE HEAD | 1 |

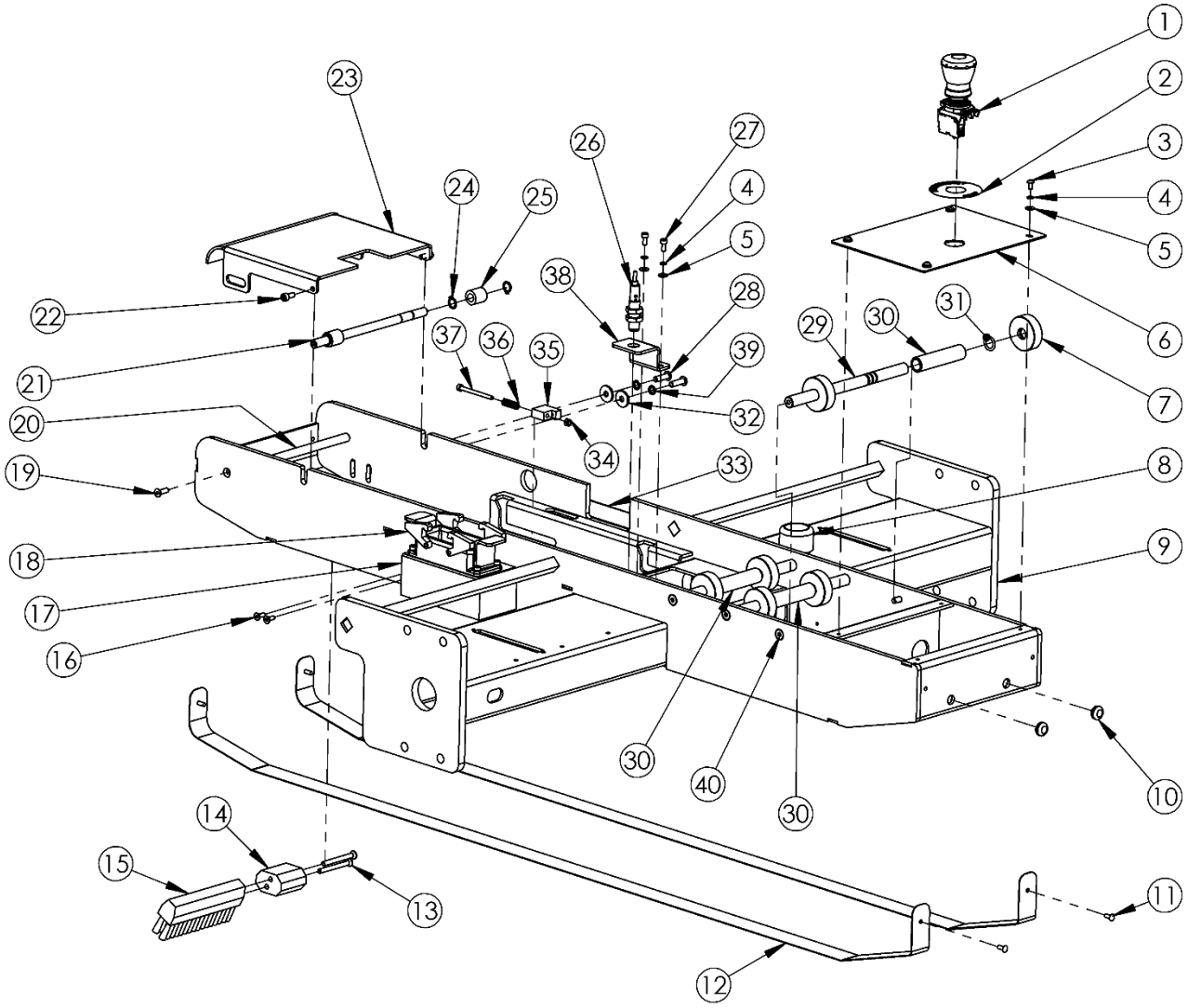
## *9.2 UAM0512 - BRIDGE ASSEMBLY*



UAM0512 - BRIDGE ASSEMBLY

| ITEM | PART NUMBER | DESCRIPTION | QTY. |
|---|---|---|---|
| 1 | UF3169 | SHCS M5-0.8 x 16mm | 3 |
| 2 | UF7021 | LW M5 | 3 |
| 3 | UF1827 | M5 FW | 3 |
| 4 | UPM6166 | BRACKET | 1 |
| 5 | USM0907 | TOP T.H. WATER BOTTLE ASS'Y | 1 |
| 6 | UPM2192 | BLACK PLUG | 4 |
| 7 | UPM1011 | BRIDGE COVER PLATE SLOTTED | 1 |
| 8 | UAM0513 | BRIDGE BASE ASSEMBLY | 1 |
| 9 | USM0823 | COMPRESSION GUIDE ASS'Y R.H. | 1 |
| 10 | USM0391 | SINGLE LOCK.ASS'Y | 1 |
| 11 | UAM0471 | COMPRESSION GUIDE ASS'Y L.H. | 1 |
| 12 | UF3680 | M10 FW | 8 |
| 13 | UF3743 | LW M10 | 8 |
| 14 | UF4310 | BHCS M10-1.5×30L | 8 |
| 15 | UPM1008 | BRIDGE PLATE COVER | 1 |
| 16 | UF1828 | M6 FW | 4 |
| 17 | UF6363 | LW M6 | 4 |
| 18 | UF3179 | SHCS M6-1.0×20L | 4 |
| 19 | USM7585 | TOP TAPE CARRIAGE ASSEMBLY | 1 |

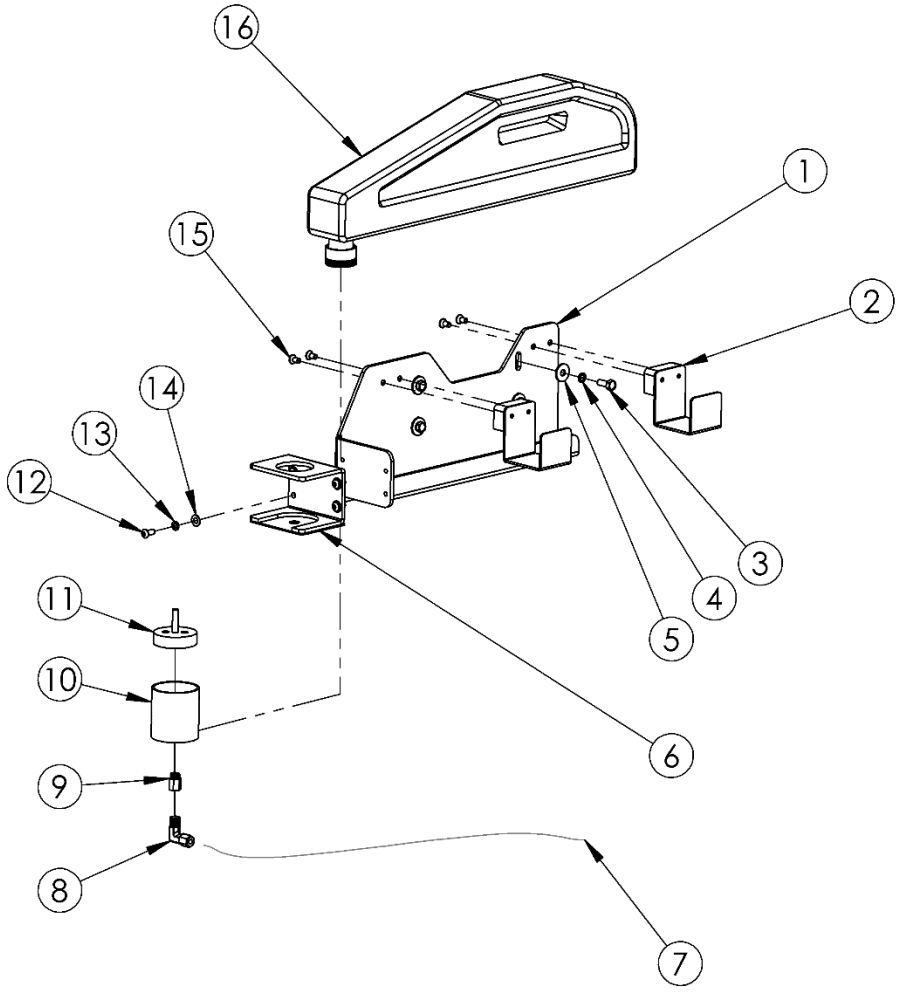
### 9.2.1 UAM0513 – Bridge Base Assembly



UAM0513 - BRIDGE BASE ASSEMBLY

| ITEM | PART NUMBER | DESCRIPTION | QTY. |
|---|---|---|---|
| 1 | UPM5733 | E-STOP | 1 |
| 2 | UPM6045 | E-STOP LABEL | 1 |
| 3 | UF3685 | BHCS M4-0.7×8L | 4 |
| 4 | UF3749 | LW M4 | 10 |
| 5 | UF3710 | M4 FW | 6 |
| 6 | UPM6167 | E-STOP PLATE | 1 |
| 7 | UPM5967 | GUIDE ROLLER, 40OD | 6 |
| 8 | WET0241 | CORD GRIP | 1 |
| 9 | UPM6165 | BRIDGE WELDMENT | 1 |
| 10 | UPM6146 | 10.9MM GROMET | 2 |
| 11 | UF3691 | Pop Rivet 4mm | 4 |
| 12 | UPM5091 | USA UHMW STRIP | 2 |
| 13 | UF0074 | FHCS M5-0.8×50L | 2 |
| 14 | UPM4968 | BRUSH HOLDER ADAPTER | 1 |
| 15 | UPH4004 | BRUSH 4" TH | 1 |
| 16 | UF3714 | FHCS M4-0.7×12L | 4 |
| 17 | UPM4980 | ELECTRICAL RECEPTACLE BASE | 1 |
| 18 | UPM4938 | RECEPTACLE CONNECTION | 1 |
| 19 | UF5404 | FHCS M5-0.8×16L | 2 |
| 20 | UPM5102 | SHAFT, dia 9.5 | 1 |
| 21 | UPM4991 | SHAFT, dia 9.5, 181L | 1 |
| 22 | UF7003 | SHCS M5-0.8 x 12mm | 6 |
| 23 | UPM4989 | TOP COVER | 1 |
| 24 | UPM6145 | RETAINING RING S10 | 4 |
| 25 | UPM4992 | SPACER, 18L | 2 |
| 26 | UPM5137 | PHOTOELECTRIC SENSOR | 1 |
| 27 | UF9148 | SHCS M4-0.7×10L | 6 |
| 28 | UF1241EV | BHCS M6-1.0×20L | 2 |
| 29 | UPM4993 | SHAFT, dia 12.7, 189L | 3 |
| 30 | UPM4933 | ROLLER, dia 17, 72L | 3 |
| 31 | UPM4936 | RUBBER RING | 6 |
| 32 | UF1828 | M6 FW | 2 |
| 33 | UPM4990 | OVER FLOW TRAY | 1 |
| 34 | UF6376 | LOCK-NUT | 2 |
| 35 | UPM5084 | SPRING SUPPORT | 2 |
| 36 | UPM1068 | COMPRESSION SPRING | 2 |
| 37 | UF3760 | SHCS M4-0.7×50L | 2 |
| 38 | UPM4997 | BRACKET | 1 |
| 39 | UF6363 | LW M6 | 2 |
| 40 | UF1192 | FHCS M6-1.0×16L | 6 |

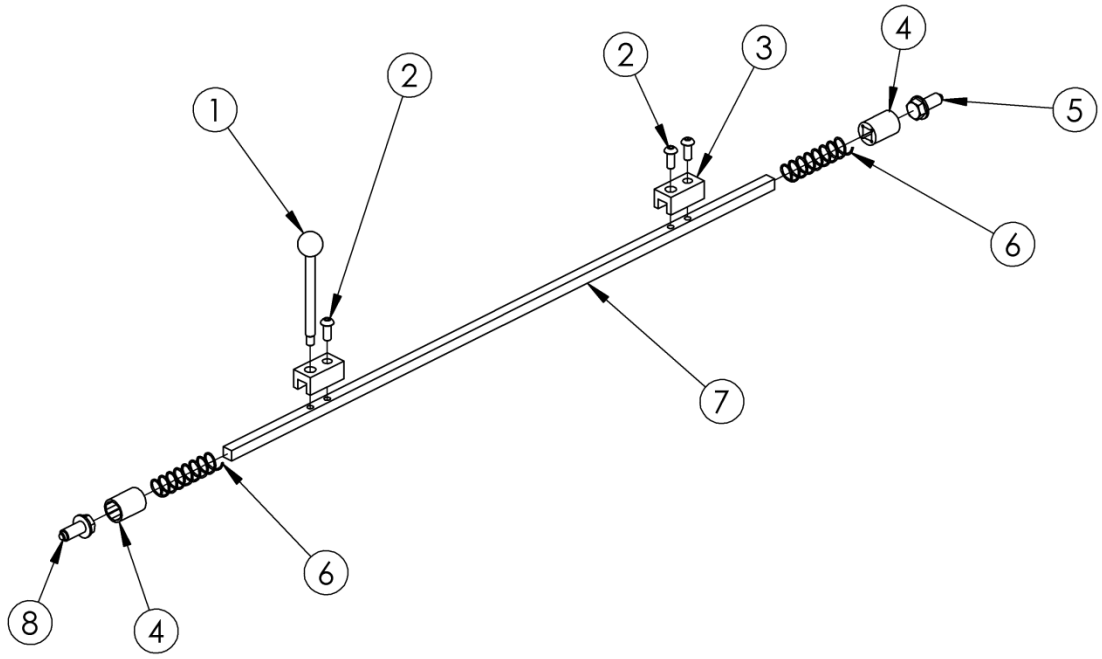
### 9.2.2 USM0907 – Top Tape Head Water Bottle Assembly




USM0907 - TOP TAPE HEAD WATER BOTTLE 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 |

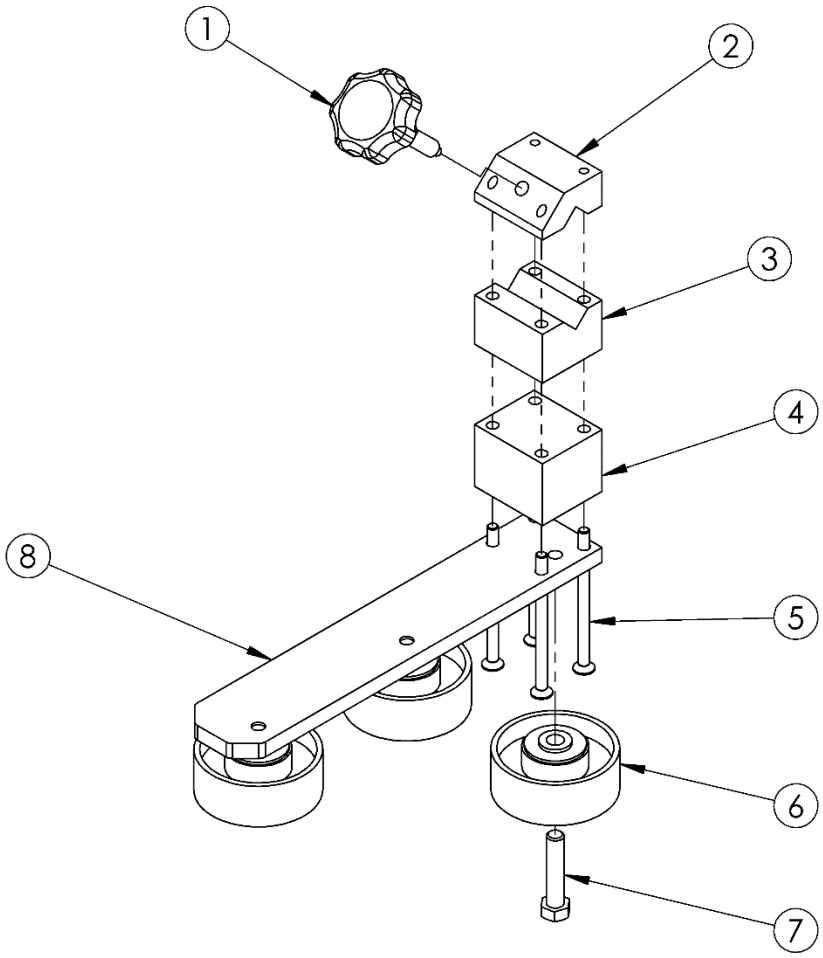
### 9.2.3 USM0391 – Single Lock Assembly




USM0391 - SINGLE LOCK ASSEMBLY

| ITEM NO. | PART NUMBER | DESCRIPTION | QTY. |
|---|---|---|---|
| 1 | UPM0688 | SINGLE LOCKING HANDLE | 1 |
| 2 | UF1318 | M8-1.25-BHCS | 3 |
| 3 | UPM0700 | SINGLE LOCKING BLOCK | 2 |
| 4 | UPM0703 | SHORT BOX 3/4", 1/2" DR, 12 PT | 2 |
| 5 | UPM0698 | FLANGED SCREW 1/2-13 L.H. | 1 |
| 6 | UPM2184 | COMPRESION SPRING | 2 |
| 7 | UPM2187 | SQUARE BAR 0.50" | 1 |
| 8 | UPM0699 | FLANGED SCREW 1/2-13 R.H. | 1 |

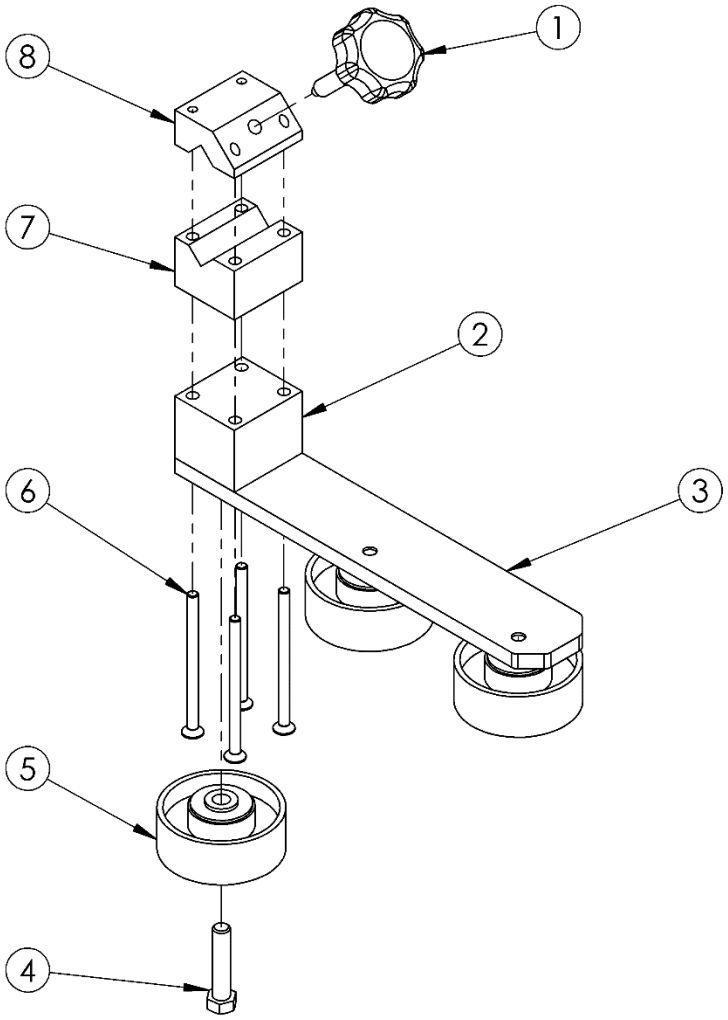
### 9.2.4 UAM0471 – Compression Guide Assembly, Left Hand




UAM0471 - COMPRESSION GUIDE ASSEMBLY, LEFT HAND

| ITEM | PART NUMBER | DESCRIPTION | QTY. |
|---|---|---|---|
| 1 | UAM0376 | KNOB CW 5mm PIN-SS | 1 |
| 2 | UPM7538 | GUIDE BLOCK TOP | 1 |
| 3 | UPM3285EV | GUIDE BLOCK | 1 |
| 4 | UPM9740 | WHEEL GUIDE SPACER | 1 |
| 5 | UF3819 | FHCS M6 - 1 x 90 | 4 |
| 6 | UPM6482 | ROLLER GUIDE 2 7/8” DIA BLACK | 3 |
| 7 | UF3024 | SS HHCS 3/8-16 x 1.75 | 3 |
| 8 | UPM5132 | WHEEL SUPPORT PLATE | 1 |

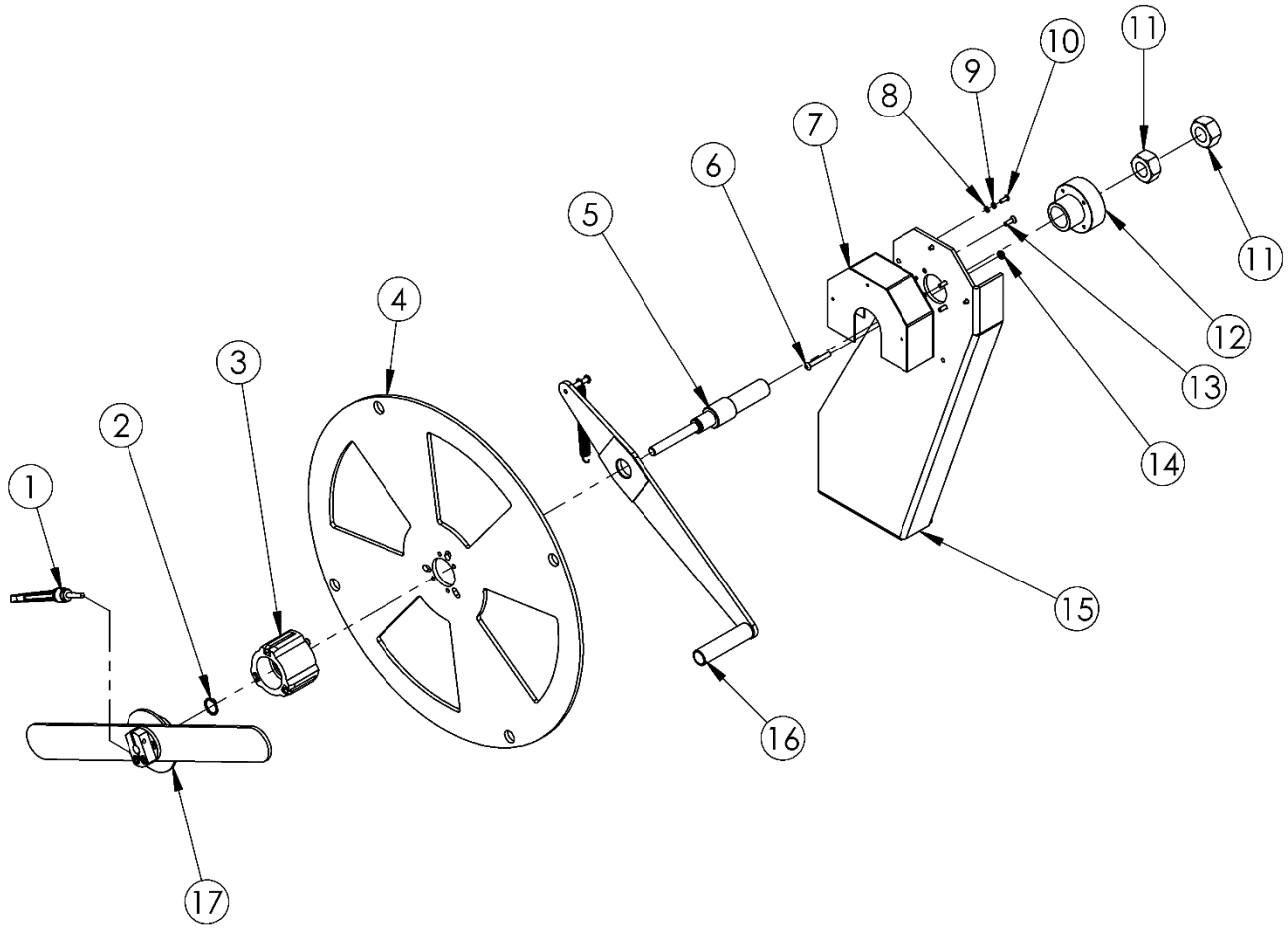
### 9.2.5 USM0823 – Compression Guide Assembly, Right Hand




USM0823 - COMPRESSION GUIDE ASSEMBLY, RIGHT HAND

| ITEM | PART NUMBER | DESCRIPTION | QTY. |
|---|---|---|---|
| 1 | UAM0376 | KNOB CW 5mm PIN-SS | 1 |
| 2 | UPM9740 | WHEEL GUIDE SPACER | 1 |
| 3 | UPM9740 | WHEEL SUPPORT PLATE | 1 |
| 4 | UF3024 | SS HHCS 3/8-16 x 1.75 | 3 |
| 5 | UPM6482 | PLASTIC WHEEL 3"DIA. WITH BEARING | 3 |
| 6 | UF3819 | FHCS M6 - 1 x 90 | 4 |
| 7 | UPM3285EV | GUIDE BLOCK | 1 |
| 8 | UPM7538 | GUIDE BLOCK TOP | 1 |

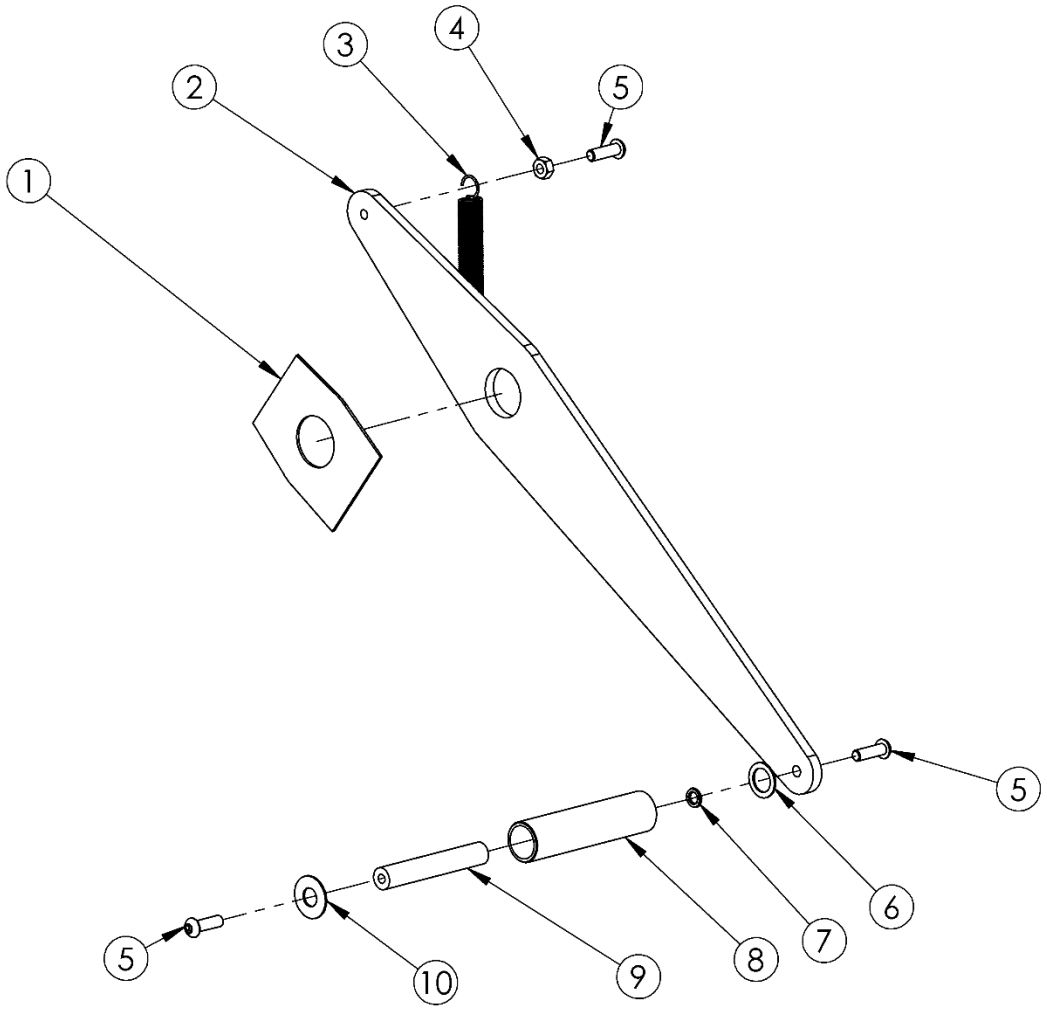
### 9.2.6 USM7585 – Top Tape Carriage Assembly




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 |

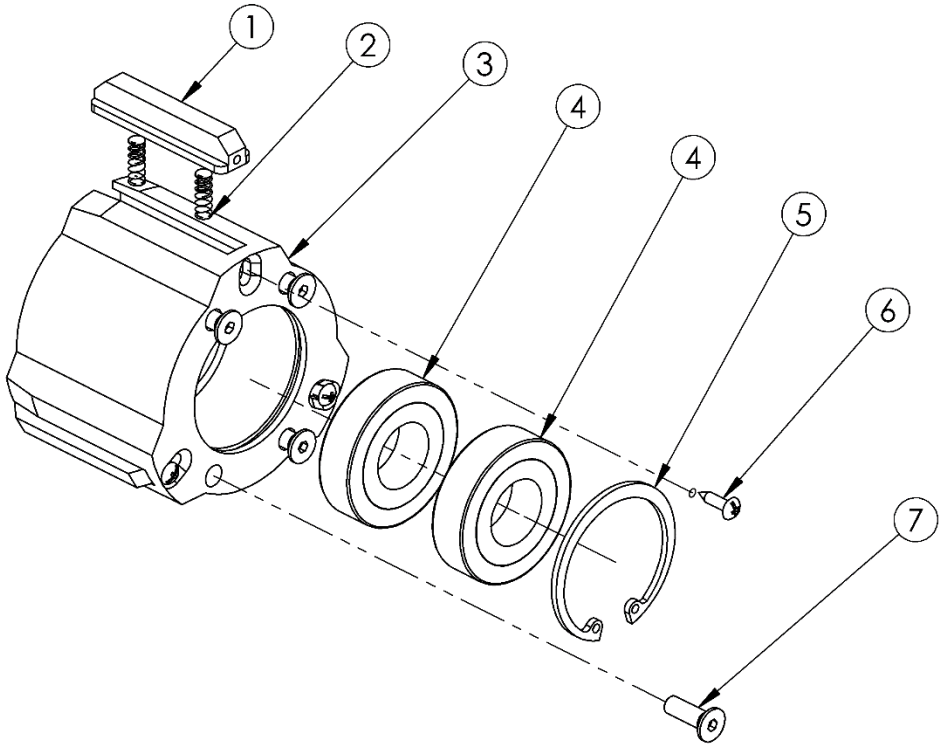
### 9.2.6.1 UAM0479 – Dancer Arm Assembly




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 |

### 9.2.6.2 UAM0195 – Mandrel Hub




UAM0195 - MANDREL HUB

| 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 |

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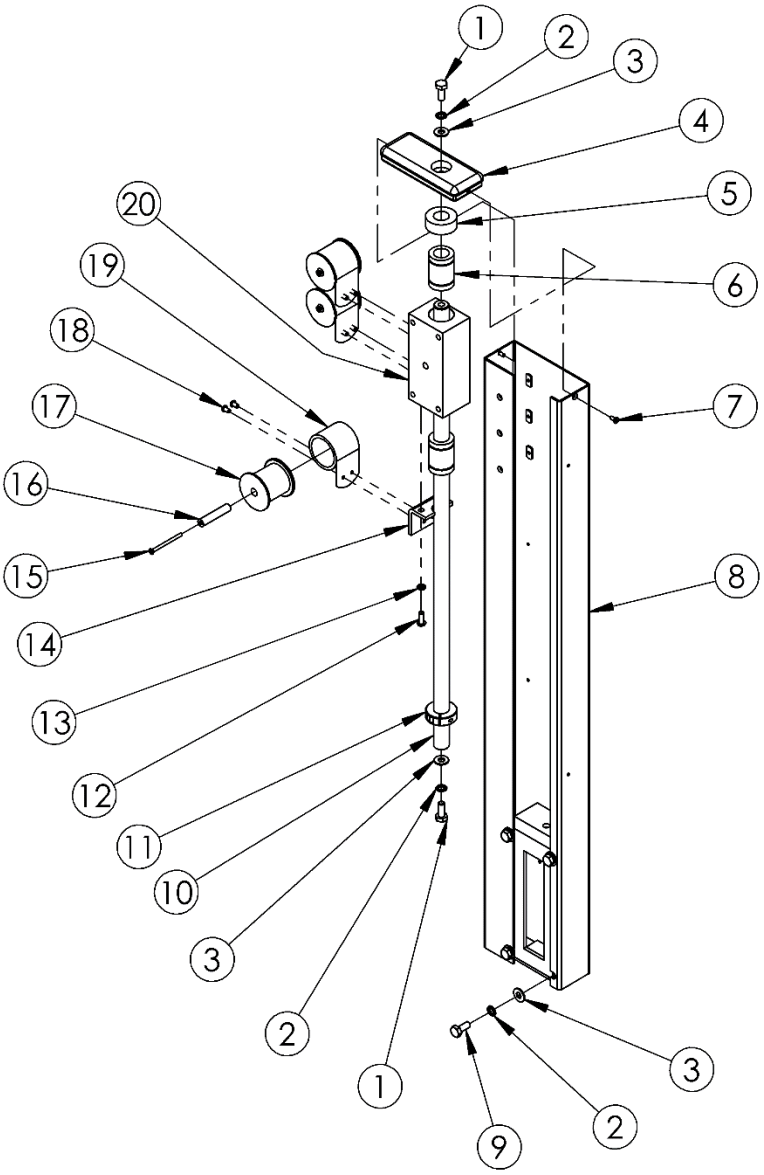
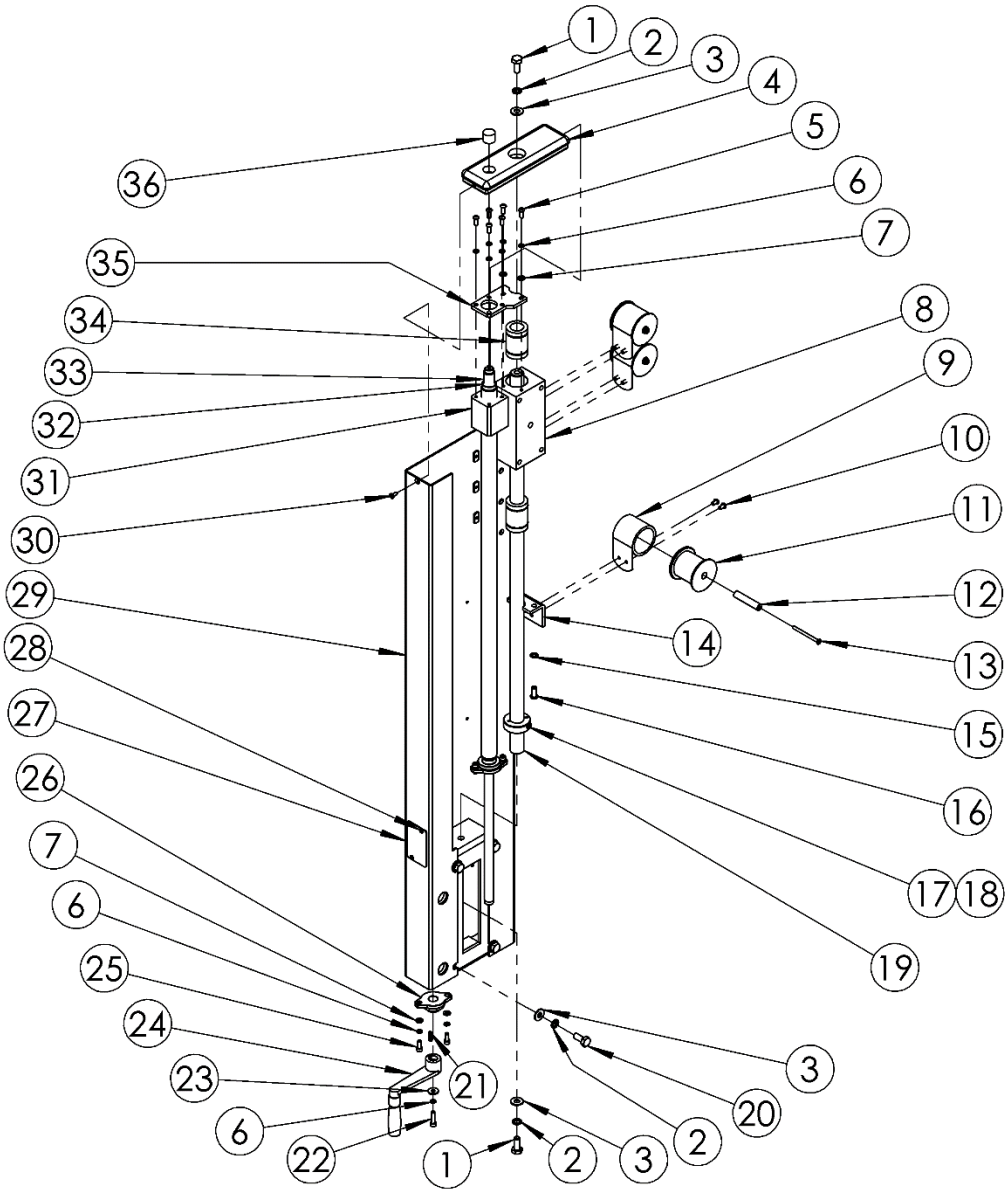
## *9.3 UAM0487 - COLUMN ASSEMBLY, RIGHT HAND*



UAM0487 - COLUMN ASSEMBLY, RIGHT HAND

| ITEM | PART NUMBER | DESCRIPTION | QTY. |
|---|---|---|---|
| 1 | UF6382 | M10-1.5×25L | 2 |
| 2 | UF3743 | LW M10 | 6 |
| 3 | UF3680 | M10 FW | 6 |
| 4 | UPM2182 | COLUMN CAP RIGHT SIDE | 1 |
| 5 | UPM2251 | SAFETY BUMPER | 1 |
| 6 | UPM4986 | LINEAR BEARING 25 mm | 2 |
| 7 | UF5400 | FHCS M5-0.8×12L | 2 |
| 8 | UPM6013 | COLUMN WELDMENT, R.H. | 1 |
| 9 | UF3647 | HHCS M10 X 1.25 X 25 | 4 |
| 10 | UPM0738 | COLUMN SHAFT USA2024 SB222 | 1 |
| 11 | UPM9741 | SHAFT COLLAR | 1 |
| 12 | UF1318 | BHCS M8-1.25×20L | 2 |
| 13 | UF3640 | LW M8 | 2 |
| 14 | UPM3740 | SPRING ANCHOR RIGHT SIDE | 1 |
| 15 | UF0075 | PHS M5-0.8×68L | 3 |
| 16 | UPM0743 | SPRING MANDREL SHAFT | 3 |
| 17 | UPM0742 | SPRING MANDREL 2" | 3 |
| 18 | UF1211 | BHCS M6-1.0×10L | 6 |
| 19 | UPM0740 | CONSTANT FORCE SPRING 33LB | 3 |
| 20 | UPE0164 | COLUMN BLOCK, RIGHT | 1 |

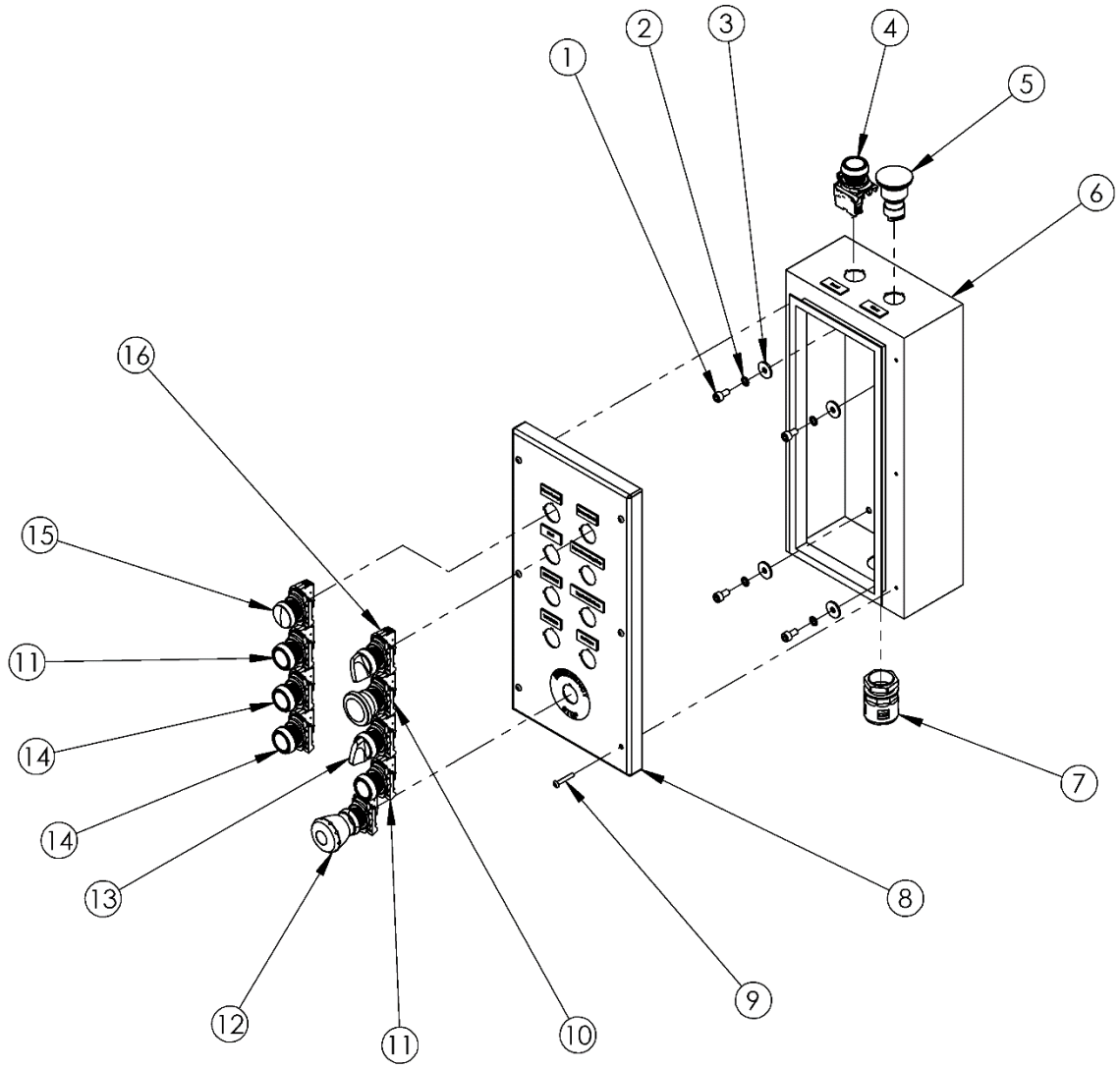
## *9.4 UPM5987 - COLUMN ASSEMBLY, ADJUSTABLE, LEFT HAND*



UPM5987 - COLUMN ASSEMBLY, ADJUSTABLE, LEFT HAND

| ITEM | PART NUMBER | DESCRIPTION | QTY. |
|---|---|---|---|
| 1 | UF6382 | M10-1.5×25L | 2 |
| 2 | UF3743 | LW M10 | 6 |
| 3 | UF3680 | M10 FW | 6 |
| 4 | UPM5992 | CAP | 1 |
| 5 | UF1250EV | BHCS M6-1.0×16L | 6 |
| 6 | UF6363 | LW M6 | 11 |
| 7 | UF1828 | M6 FW | 6 |
| 8 | UPM5991 | COLUMN MOVING BLOCK | 1 |
| 9 | UPM0740 | CONSTANT FORCE SPRING 33LB | 3 |
| 10 | UF1211 | BHCS M6-1.0×10L | 6 |
| 11 | UPM0742 | SPRING MANDREL 2" | 3 |
| 12 | UPM0743 | SPRING MANDREL SHAFT | 3 |
| 13 | UF0075 | PHS M5-0.8×68L | 3 |
| 14 | UPM4150 | SPRING ANCHOR UA2024 | 1 |
| 15 | UF3640 | LW M8 | 2 |
| 16 | UF1318 | BHCS M8-1.25×20L | 2 |
| 17 | UF0835 | SHCS M6-1.0×20L | 1 |
| 18 | UPM9741 | SHAFT COLLAR | 1 |
| 19 | UPM0738 | COLUMN SHAFT USA2024 SB222 | 1 |
| 20 | UF3647 | HHCS M10 X 1.25 X 25 | 4 |
| 21 | UPM5773 | KEY 5X5X20 | 1 |
| 22 | UF0630EV | SHCS M6-1.0×25L | 1 |
| 23 | UF0103 | M6 FW, 19MM OD 2MM THK | 1 |
| 24 | UPE0001 | HANDLE, FOLDABLE | 1 |
| 25 | UF3187 | SHCS M6-1.0×16L | 4 |
| 26 | UPM5226 | CONNECTING BEARING | 2 |
| 27 | UPM5998 | COVER | 1 |
| 28 | UF6374 | BHCS M4-0.7×6L | 2 |
| 29 | UAM0485 | COLUMN WELDMENT | 1 |
| 30 | UF5400 | FHCS M5-0.8×12L | 2 |
| 31 | UPM5989 | BALL SCREW BLOCK | 1 |
| 32 | UPM5614 | BEARING | 1 |
| 33 | UPM5990 | BALL SCREW | 1 |
| 34 | UPM4986 | LINEAR BEARING 25 mm | 2 |
| 35 | UPM5993 | PLATE | 1 |
| 36 | UPM6013 | CAP | 1 |

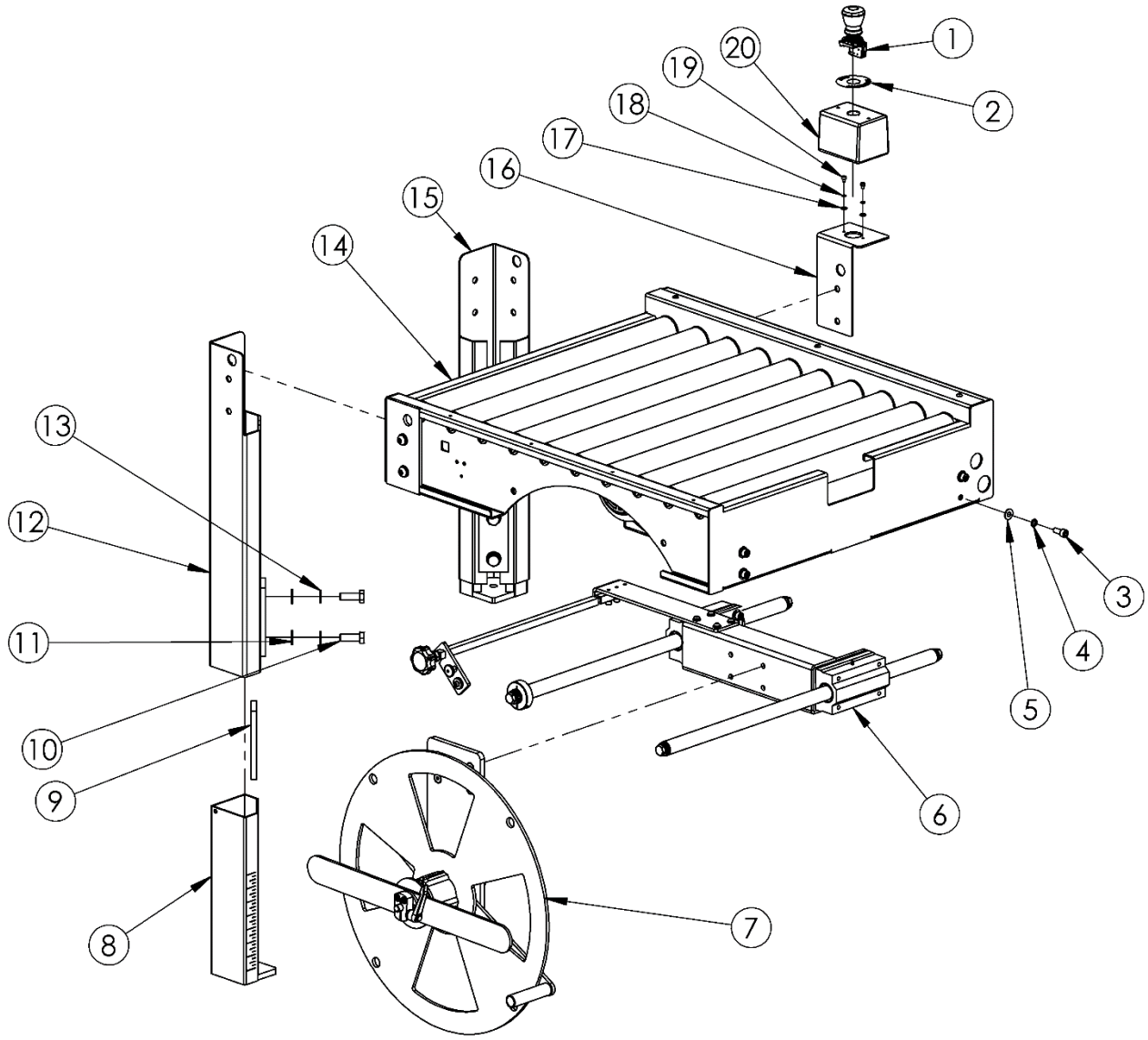
## *9.5 UAM0488 – CONTROL BOX*



UAM0488 - CONTROL BOX

| ITEM | PART NUMBER | DESCRIPTION | QTY. |
|---|---|---|---|
| 1 | UF0038 | SHCS M6-1.0×12L | 4 |
| 2 | UF6363 | LW M6 | 4 |
| 3 | UF0103 | M6 FW, 19MM OD 2MM THK | 4 |
| 4 | UPM6047 | PUSH BUTTON, BLUE | 1 |
| 5 | UPM4926 | ILLUMINATED PB, MUSHROOM, BLUE | 1 |
| 6 | UPM6169 | OPERATION BOX | 1 |
| 7 | UPM4905 | CORD GRIP | 1 |
| 8 | UPM6168 | OPERATION BOX COVER | 1 |
| 9 | UF0069 | BHCS M4-0.7×25L | 6 |
| 10 | UPM6051 | PUSH BUTTON, RED | 1 |
| 11 | UPM5734 | START SWITCH | 2 |
| 12 | UPM5733 | E-STOP | 1 |
| 13 | UPM6050 | 3 POS SELECTOR SWITCH | 1 |
| 14 | UPM5709 | PUSH BUTTON | 2 |
| 15 | UPM6048 | ILLUMINATED PILOT LIGHT | 1 |
| 16 | UPM6049 | 2 POS SELECTOR SWITCH | 1 |

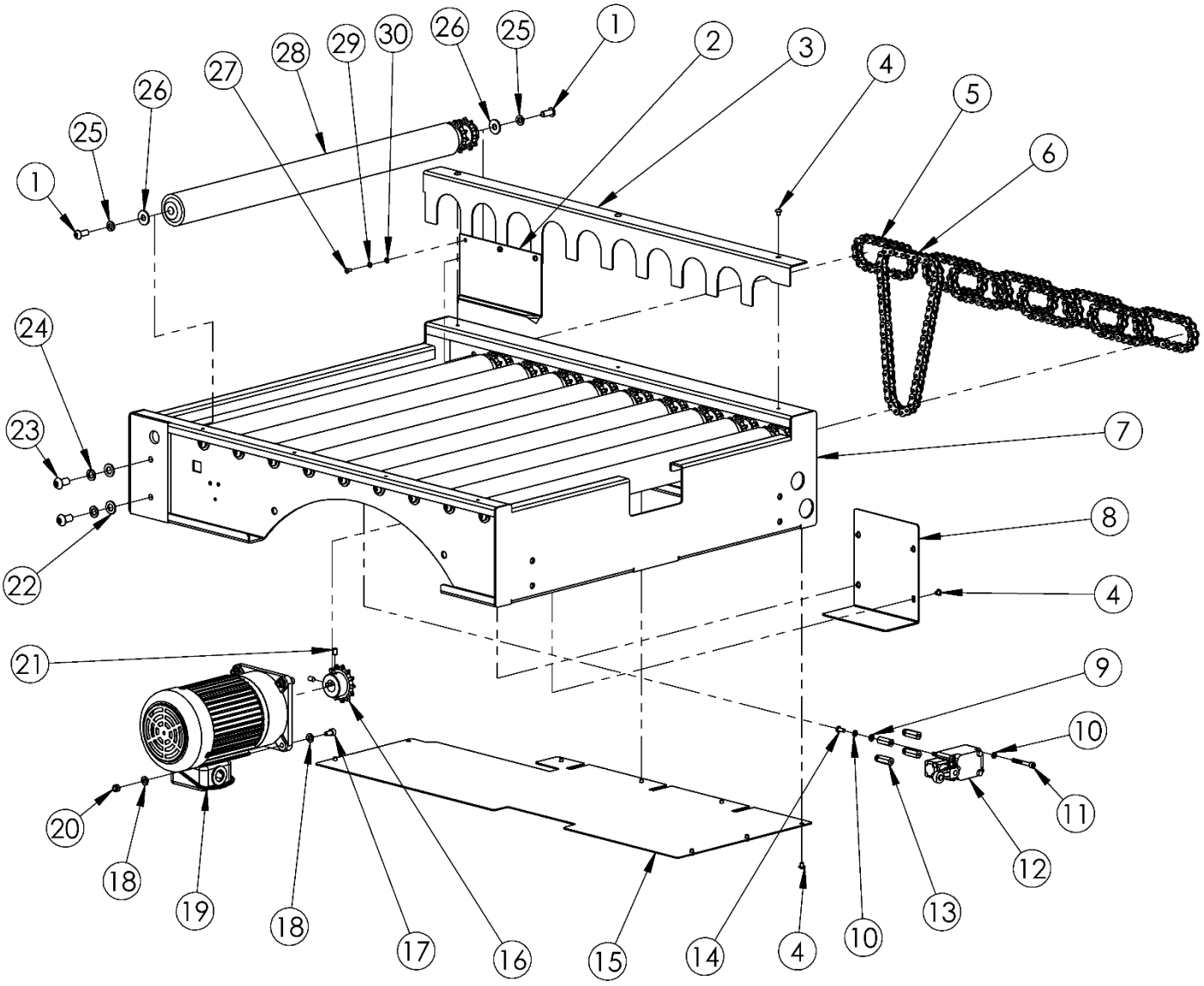
## *9.6 UAM0489 – OUTPUT TABLE*



UAM0489 - OUTPUT TABLE

| ITEM | PART NUMBER | DESCRIPTION | QTY. |
|---|---|---|---|
| 1 | UPM5733 | E-STOP | 1 |
| 2 | UPM6045 | E-STOP LABEL | 1 |
| 3 | UF0864 | SHCS M8-1.25×20L | 4 |
| 4 | UF3640 | LW M8 | 4 |
| 5 | UF0105 | M8 FW | 4 |
| 6 | UPM6039 | TAPE ROLL CARRIAGE | 1 |
| 7 | UAM0506 | BTM TAPE CARRIAGE | 1 |
| 8 | UPM0847 | LEG ADJUSTMENT WELDMENT FOR USA2024 REDESIGN | 2 |
| 9 | UPM0931 | LEG FRICTION PLATE | 2 |
| 10 | UF3734 | HHCS M12-1.75×35L | 4 |
| 11 | UF4231 | M12 FW | 4 |
| 12 | UPM5142 | LEG WELDMENT | 1 |
| 13 | UF4230 | LW M12 | 4 |
| 14 | UAM0504 | OUTPUT TABLE TOP | 1 |
| 15 | UPM5141 | LEG WELDMENT | 1 |
| 16 | UPM6044 | E-STOP BRACKET | 1 |
| 17 | UF3710 | M4 FW | 2 |
| 18 | UF3749 | LW M4 | 2 |
| 19 | UF4312 | SHCS M4-0.7×6L | 2 |
| 20 | UPM6170 | BUTTON BOX | 1 |

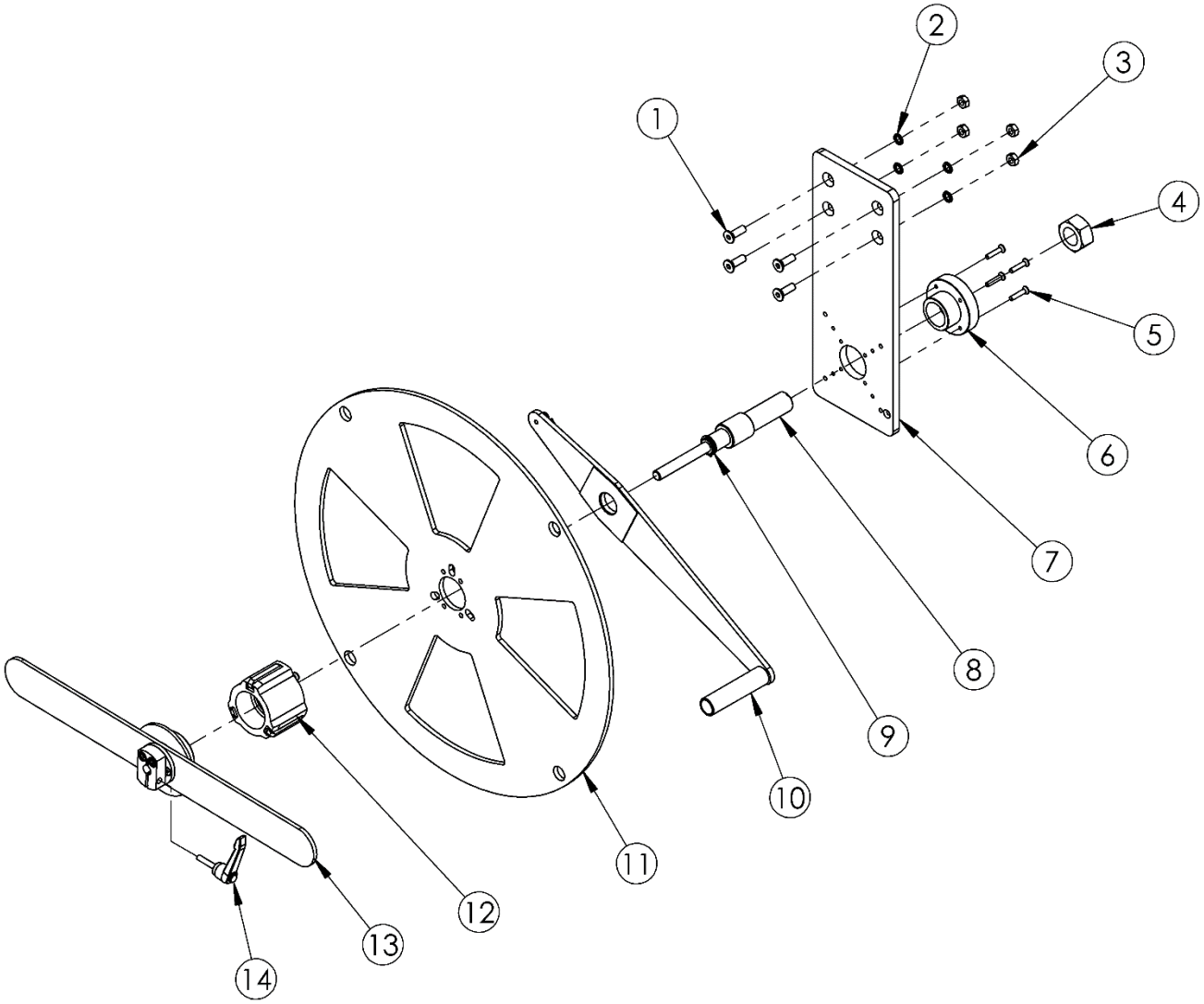
### 9.6.1 UAM0504 – Output Table Top



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 |

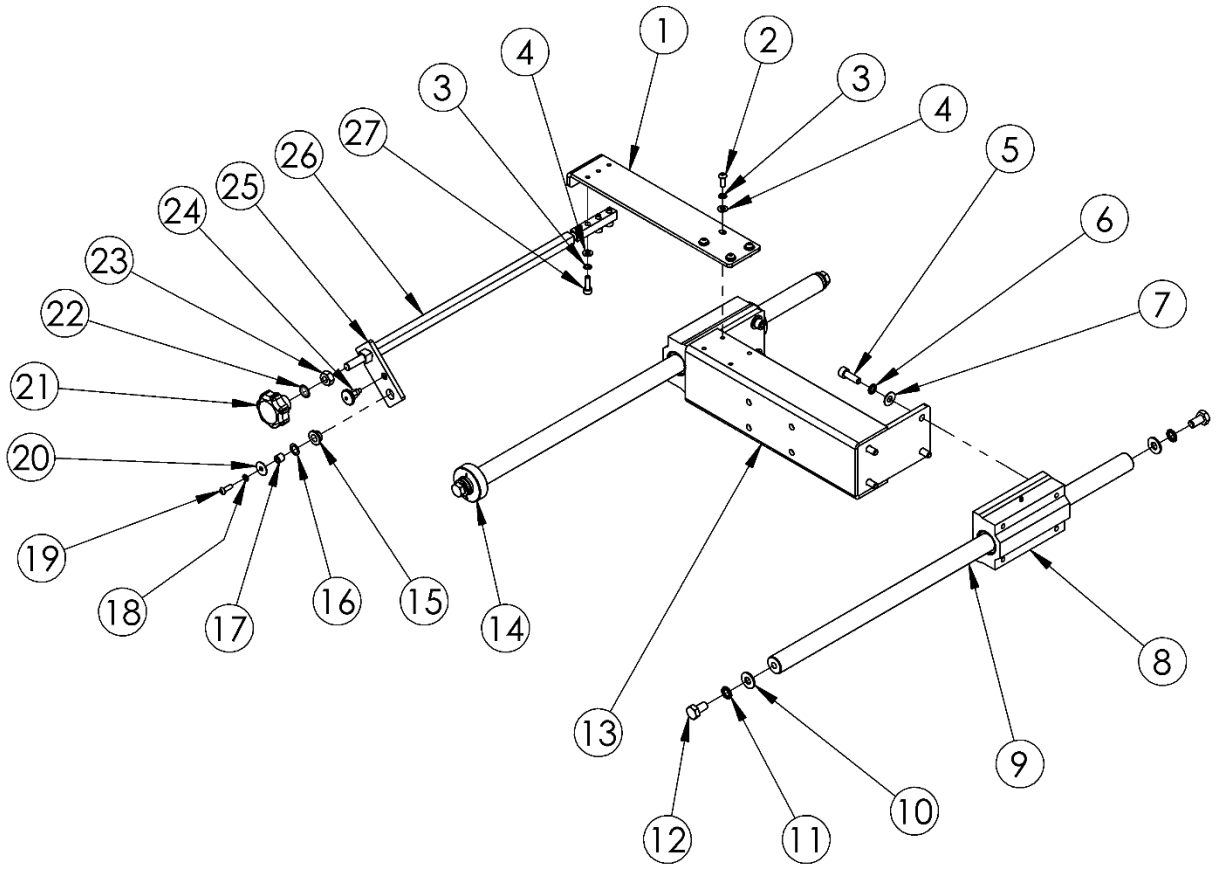
### 9.6.2 UAM0506 – BTM Tape Carriage



UAM0506 - BTM TAPE CARRIAGE

| ITEM | PART NUMBER | DESCRIPTION | QTY. |
|---|---|---|---|
| 1 | UF0091 | FHCS M8-1.25×25L | 4 |
| 2 | UF3640 | LW M8 | 4 |
| 3 | UF6369 | M8-1.25-HNR | 4 |
| 4 | UF3816 | M24-1.5-HNR | 1 |
| 5 | UF5399 | FHCS M5-0.8×25L | 4 |
| 6 | UPM5114 | HUB | 1 |
| 7 | UPM6143 | BACK FRAME | 1 |
| 8 | UPM5109 | STEPPED SHAFT R.H. | 1 |
| 9 | UF3815 | RET'G RING, ID 10 | 1 |
| 10 | UAM0481 | DANCER ARM ASSEMBLY | 1 |
| 11 | UPM5111 | PANCAKE | 1 |
| 12 | UAM0195 | MANDREL HUB | 1 |
| 13 | UPM5715 | CROSS BAR ASSEMBLY | 1 |
| 14 | UPM4889 | HANDLE | 1 |

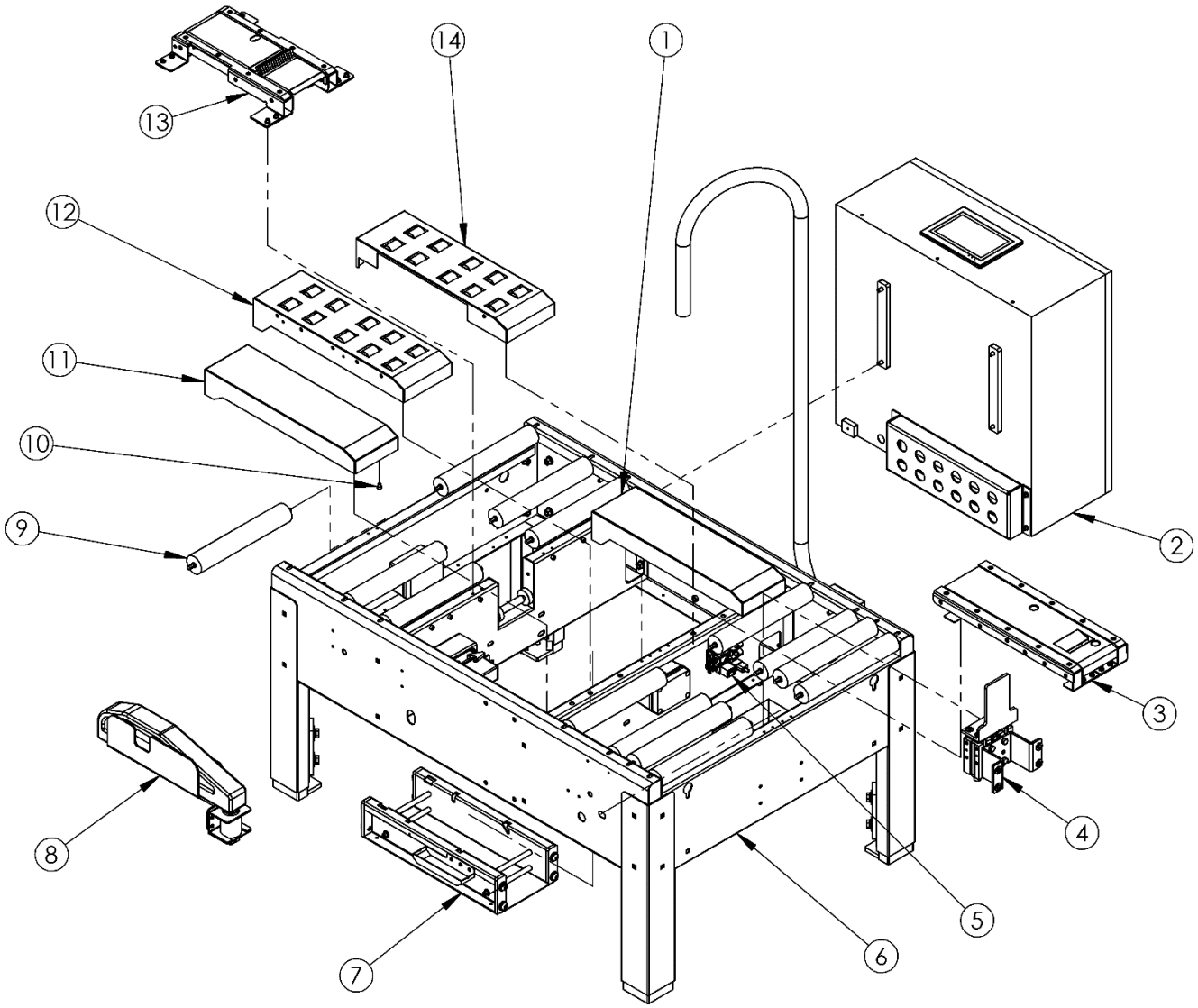
### 9.6.3 UPM6039 –Tape Roll Carriage



UPM6039 - TAPE ROLL CARRIAGE

| ITEM | PART# | 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 |

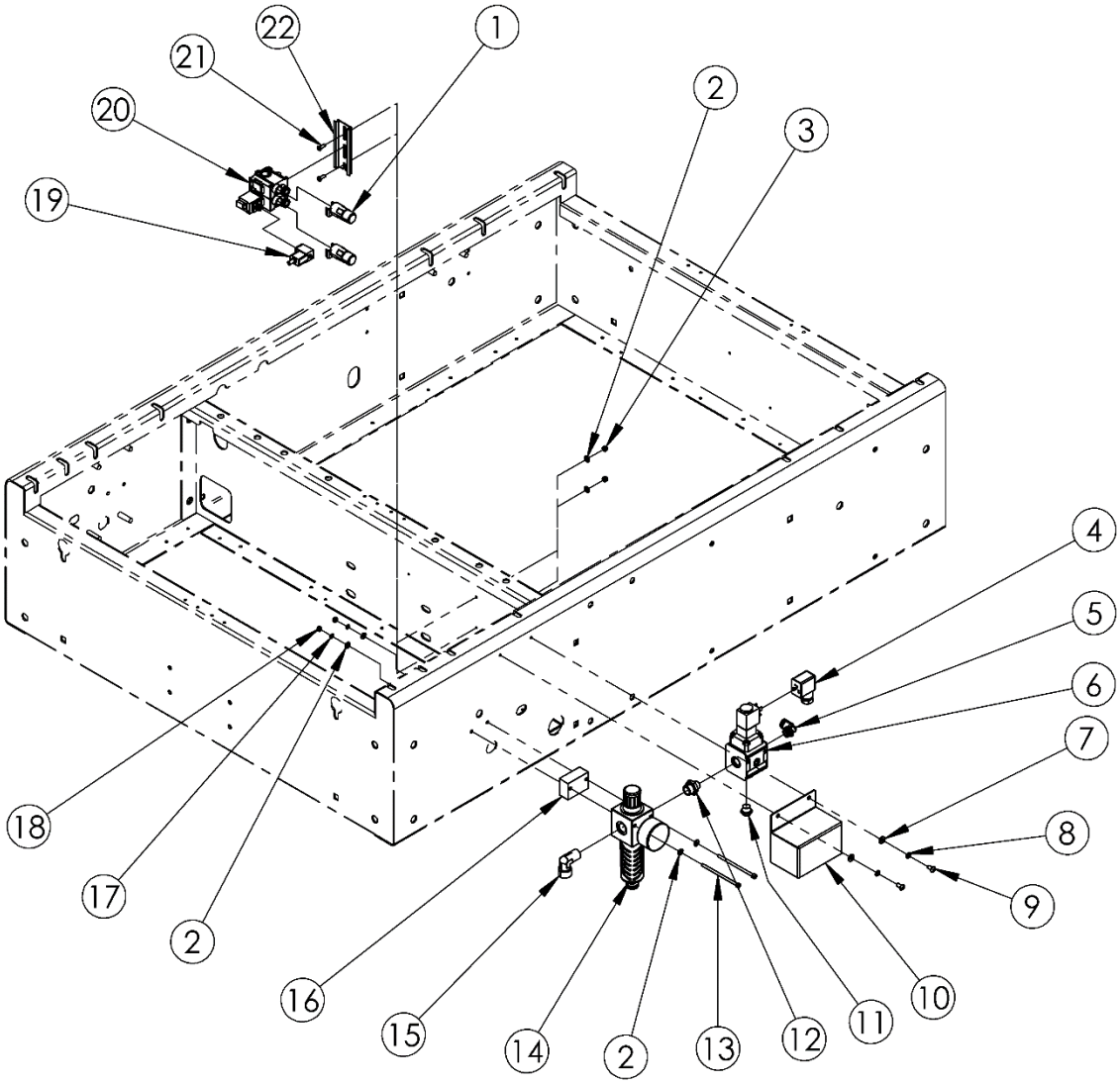
# *9.7 USM0867 – BASE ASSEMBLY*



USM0867 - BASE ASSEMBLY

| ITEM | PART NUMBER | DESCRIPTION | QTY. |
|---|---|---|---|
| 1 | UPM5986 | SIDE COVER, R.H. | 1 |
| 2 | UAM0503 | ELECTRICAL BOX | 1 |
| 3 | UAM0473 | INLET TABLE ASSEMBLY | 1 |
| 4 | UAM0483 | INLET STOP ASSEMBLY | 1 |
| 5 | UAM0485 | PNEUMATIC ASSEMBLY | 1 |
| 6 | UAM0468 | FRAME ASSEMBLY | 1 |
| 7 | UAM0482 | LOWER HOST BASE ASSEMBLY | 1 |
| 8 | USM0901 | WATER BOTTLE UNIT ASS'Y | 1 |
| 9 | UPM3226 | PVC ROL CHARCOAL DIA 1.9 X 12.00 | 14 |
| 10 | UF3170 | SHCS M6-1.0×8L | 4 |
| 11 | UPM5985 | SIDE COVER, L.H. | 1 |
| 12 | UAM0474 | ROLLER ASSEMBLY, L.H. | 1 |
| 13 | UAM0478 | OUTLET TABLE ASSEMBLY | 1 |
| 14 | UAM0477 | ROLLER ASSEMBLY, R.H. | 1 |

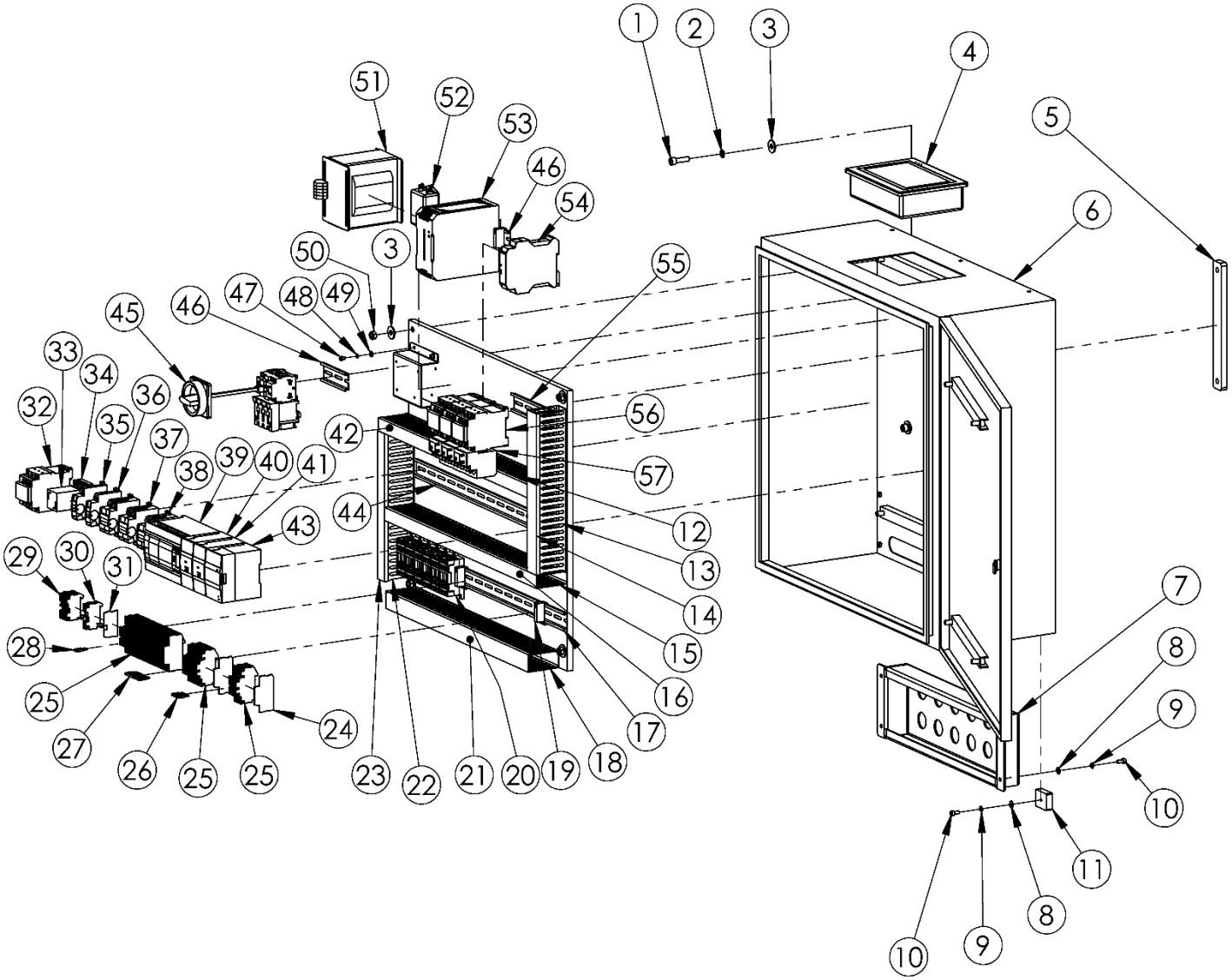
### 9.7.1 UAM0485 –Pneumatic Assembly



UAM0485 - PNEUMATIC ASSEMBLY

| ITEM | PART NUMBER | DESCRIPTION | QTY. |
|---|---|---|---|
| 1 | UPM3391 | SILENCER VALVE | 2 |
| 2 | UF3710 | M4 FW | 6 |
| 3 | UF6376 | LOCK-NUT | 2 |
| 4 | UPM5979 | ELECTRIC CONTROL CONNECTOR | 1 |
| 5 | UPM5984 | 90° QUICK CONNECTOR | 1 |
| 6 | UPM5978 | ON-OFF VALVE | 1 |
| 7 | UF1827 | M5 FW | 2 |
| 8 | UF7021 | LW M5 | 2 |
| 9 | UF3686 | BHCS M5-0.8×10L | 2 |
| 10 | UPM5975 | COIL CONNECTOR COVER | 1 |
| 11 | UPM6171 | SILENCER | 1 |
| 12 | UPM5983 | CONNECTOR, STRAIGHT | 1 |
| 13 | UF3694 | SHCS M4-0.7×80L | 2 |
| 14 | UPM5977 | REGULATOR | 1 |
| 15 | UPM5982 | 90° ELBOW | 1 |
| 16 | UPM5976 | SPACER | 1 |
| 17 | UF3749 | LW M4 | 2 |
| 18 | UF4237 | M4-0.7-HNR | 2 |
| 19 | UPM5981 | WIRE CONNECTOR | 1 |
| 20 | UPM5980 | SOLENOID VALVE | 1 |
| 21 | UF3649 | BHCS M4-0.7×12L | 2 |
| 22 | UPM6172 | RAIL | 1 |

### 9.7.2 UAM0503 – Electrical Box

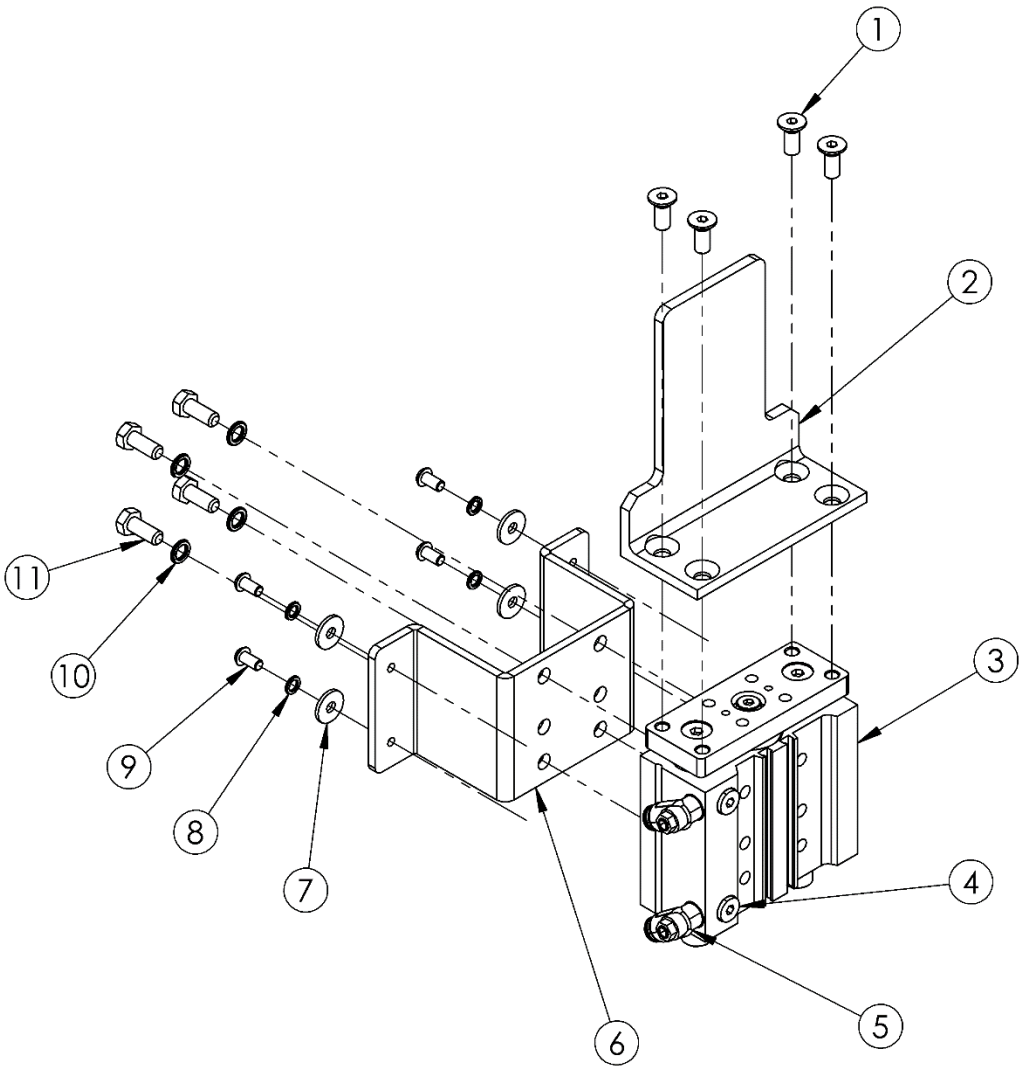


UAM0503 - ELECTRICAL BOX

| 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 |

| ITEM | PART NUMBER | DESCRIPTION | QTY. |
|---|---|---|---|
| 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 |

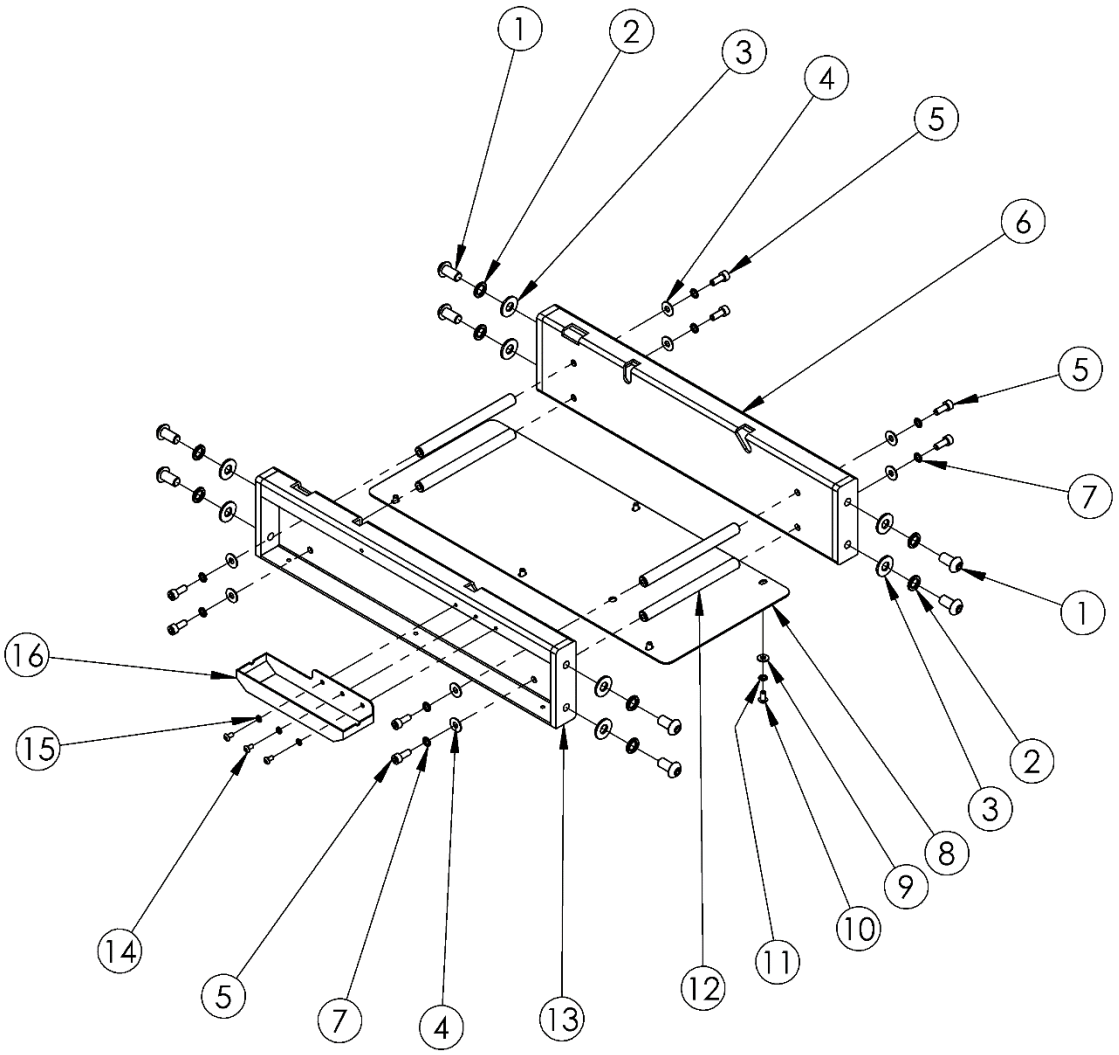
### 9.7.3 UAM0483 – Inlet Stop Assembly




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 |

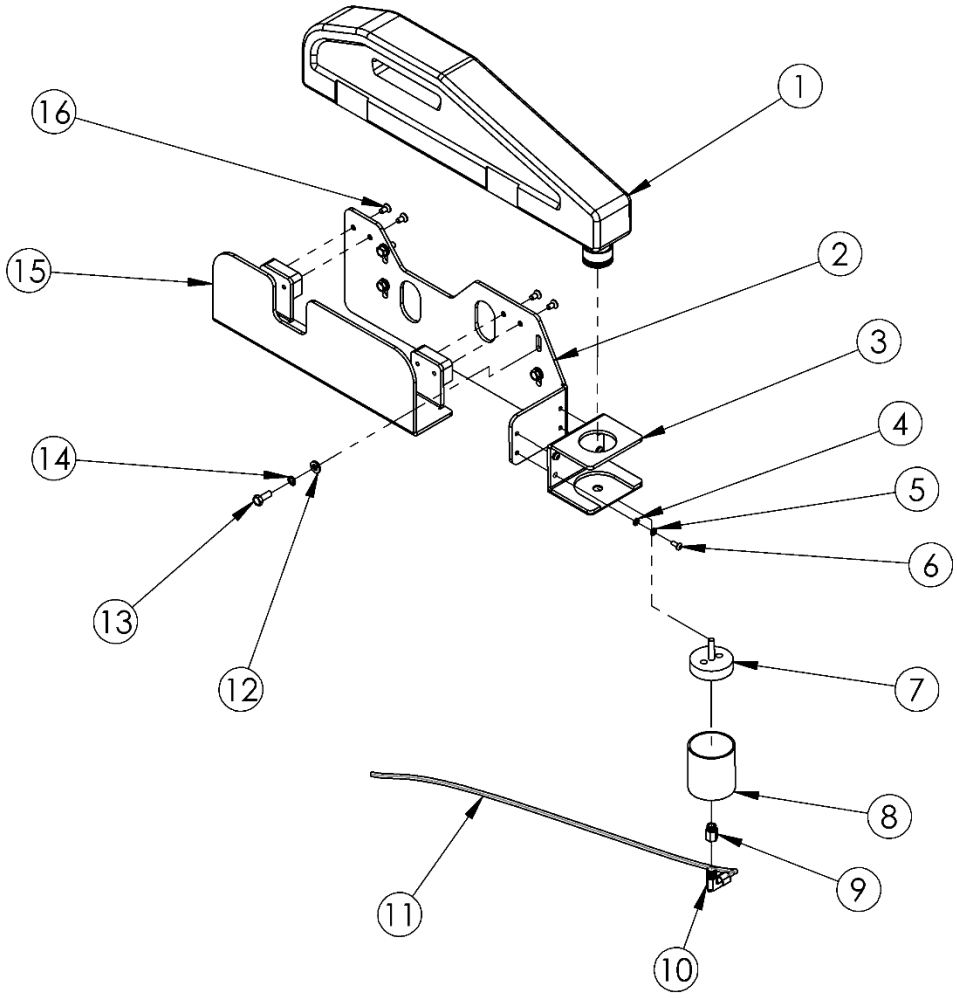
### 9.7.4 UAM0482 – Lower Host Base Assembly




UAM0482 - LOWER HOST BASE ASSEMBLY

| ITEM | PART NUMBER | DESCRIPTION | QTY. |
|---|---|---|---|
| 1 | UF4252 | BHCS M10-1.5×20L | 8 |
| 2 | UF3743 | LW M10 | 8 |
| 3 | UF3680 | M10 FW | 8 |
| 4 | UF1828 | M6 FW | 8 |
| 5 | UF3187 | SHCS M6-1.0×16L | 8 |
| 6 | UPM6148 | LOWER HOST BASE, R.H. | 1 |
| 7 | UF6363 | LW M6 | 8 |
| 8 | UPM5970 | LOWER HOST COVER | 1 |
| 9 | UF1827 | M5 FW | 6 |
| 10 | UF3686 | BHCS M5-0.8×10L | 6 |
| 11 | UF7021 | LW M5 | 6 |
| 12 | UPM6252 | SHAFT, 140L | 4 |
| 13 | UPM6147 | LOWER HOST BASE, L.H. | 1 |
| 14 | UF7009 | M4-0.7-SS BHCS | 3 |
| 15 | UF3749 | M4 SS LW | 3 |
| 16 | UPM6253 | LOWER DRAIN TRAY | 1 |

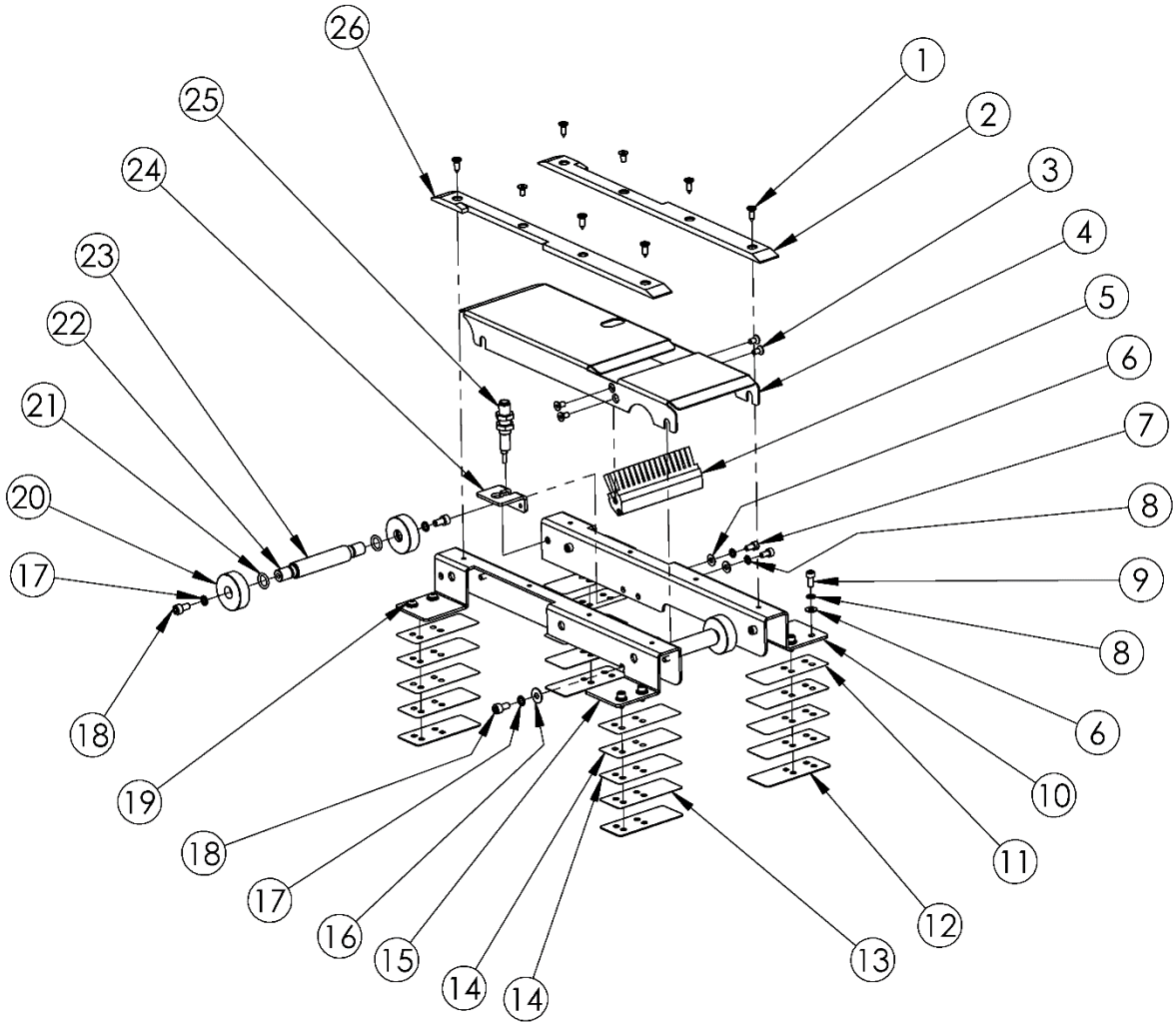
### 9.7.5 USM0901 – Water Bottle Unit Assembly



USM0901 - WATER BOTTLE UNIT ASSEMBLY

| ITEM | PART NUMBER | DESCRIPTION | QTY. |
|---|---|---|---|
| 1 | WST1014 | WT Bottle SA | 1 |
| 2 | UPM4943 | FRAME | 1 |
| 3 | UPM4945 | CUP HOLDER | 1 |
| 4 | UF6339 | SS FW M4 | 4 |
| 5 | UF3749 | SS LW M4 | 4 |
| 6 | UF6364 | SS BHCS M4 x 0.7 x 10mm | 4 |
| 7 | UPM4947 | PLUNGER | 1 |
| 8 | UPM4946 | RESERVOIR CUP | 1 |
| 9 | UPH1496 | REDUCER | 1 |
| 10 | UPM5148 | ELBOW FITTING | 1 |
| 11 | UPM5165 | TUBE, 6 OD x 4 ID | 1 |
| 12 | UF6341 | SS FW M6 | 4 |
| 13 | UF3751 | SS HHCS M6-1.0 x 16mm | 4 |
| 14 | UF6411 | SS LW M6 | 4 |
| 15 | UPM4944 | HOLDER BRACKET | 1 |
| 16 | UF3262 | SS FHCS M5-0.8 x 10 mm | 4 |

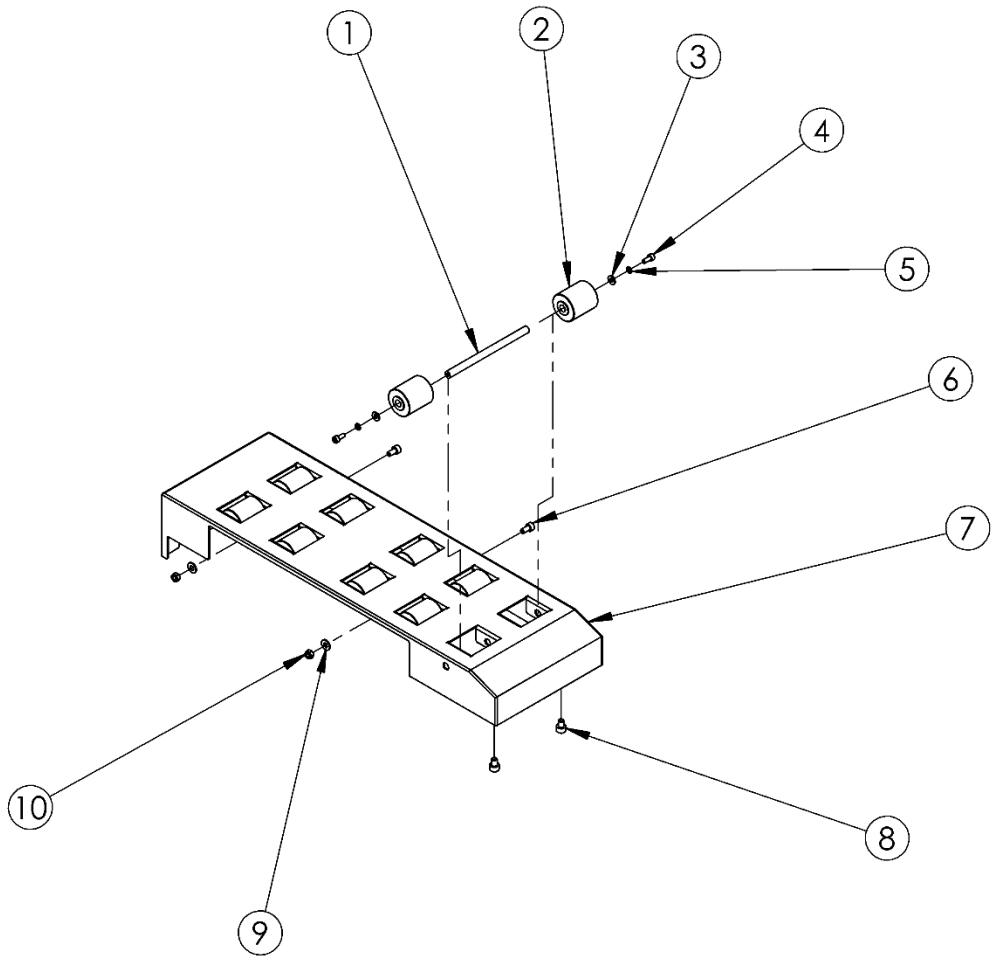
### 9.7.6 UAM0478 – Outlet Table Assembly



UAM0478 - OUTLET TABLE ASSEMBLY

| ITEM | PART NUMBER | 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 |

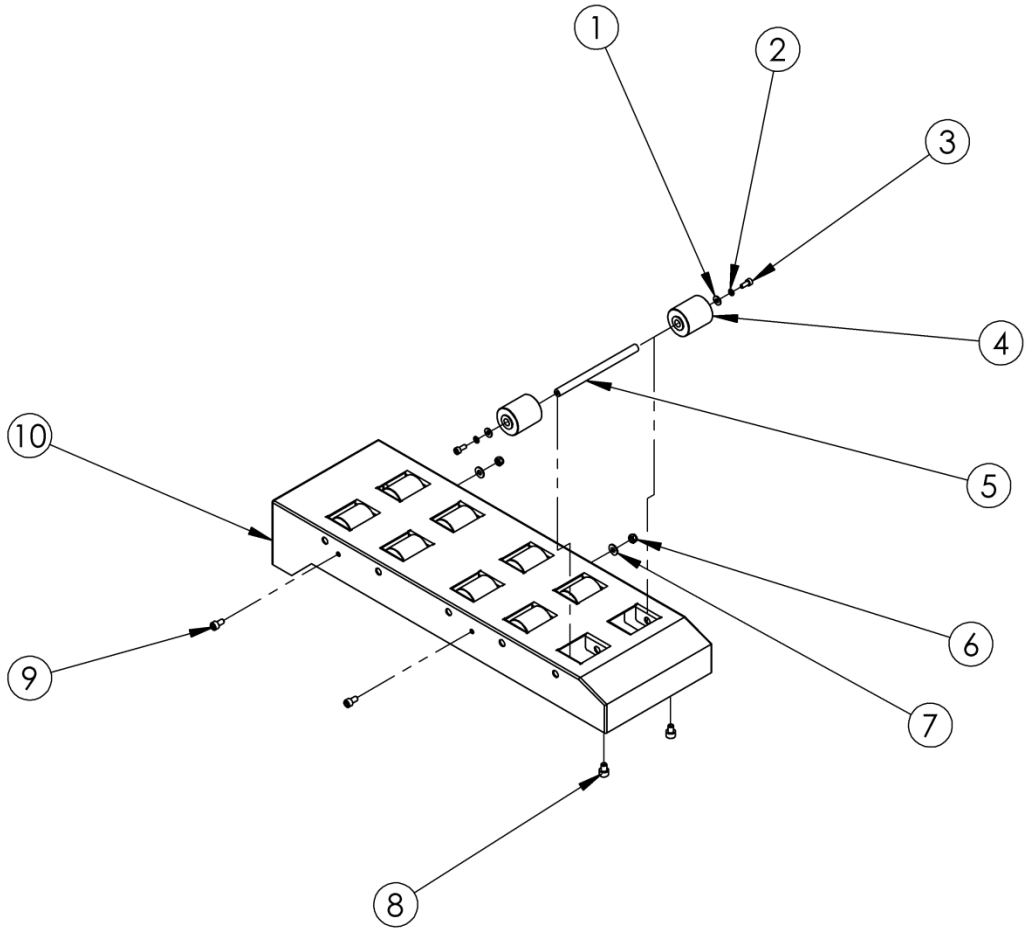
### 9.7.7 UAM0477 – Roller Assembly, Right Hand




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 |

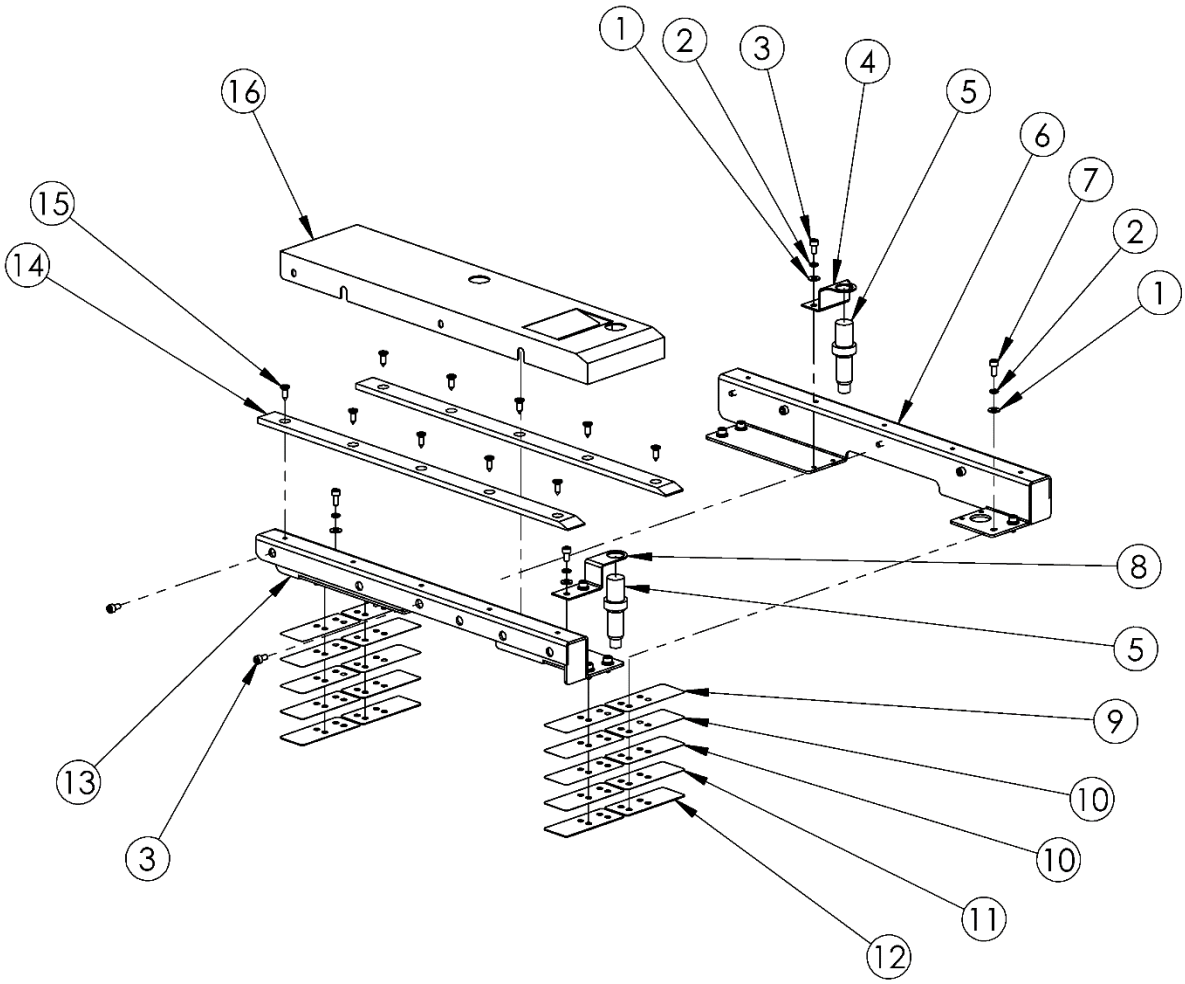
### 9.7.8 UAM0474 – Roller Assembly, Left Hand




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 |

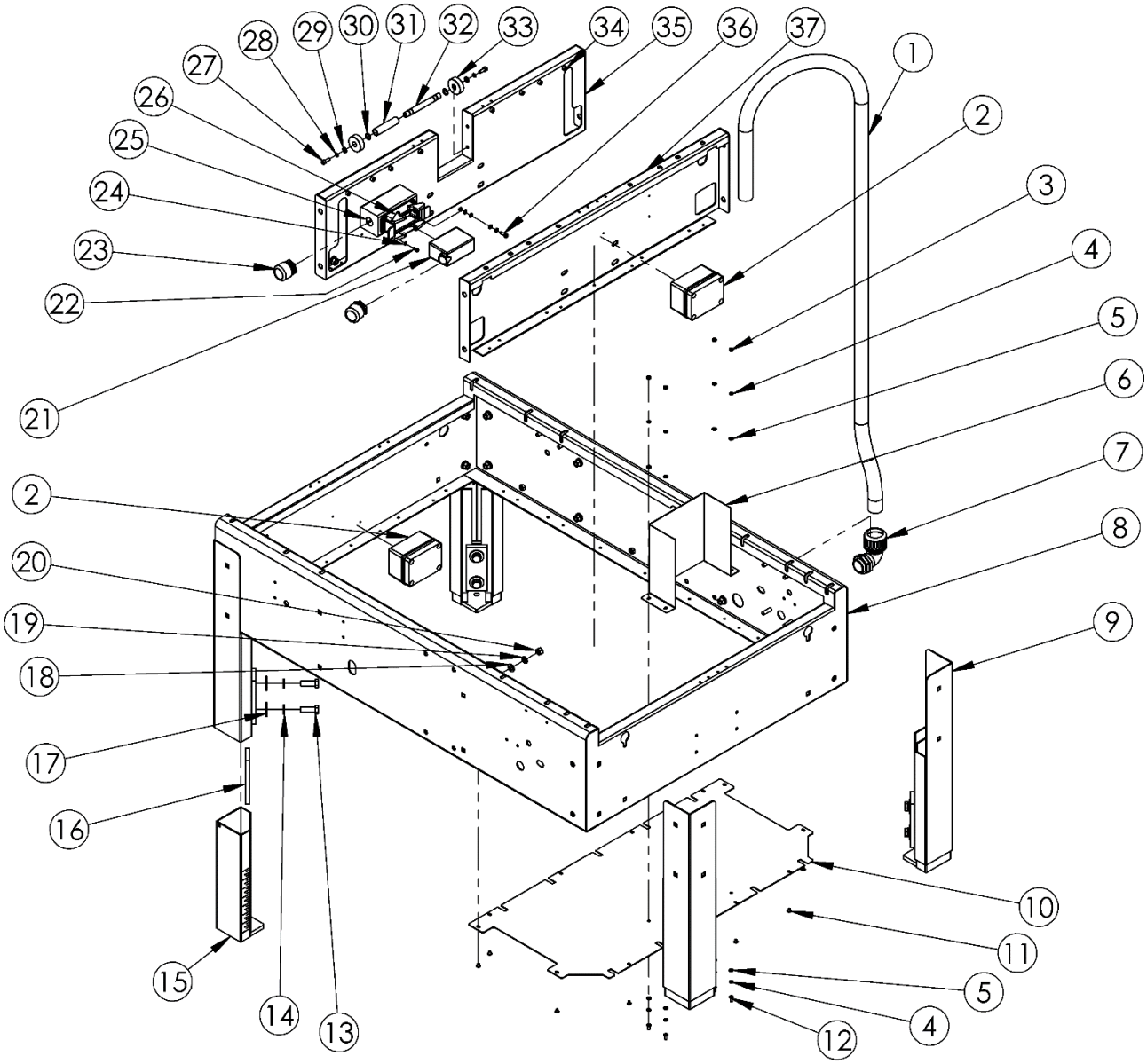
### 9.7.9 UAM0473 – Inlet Table Assembly



UAM0473 - INLET TABLE ASSEMBLY

| ITEM | PART NUMBER | DESCRIPTION | QTY. |
|---|---|---|---|
| 1 | UF1827 | M5 FW | 12 |
| 2 | UF7021 | LW M5 | 12 |
| 3 | UF0039 | SHCS M5-0.8 x 10mm | 12 |
| 4 | UPM5956 | SENSOR SUPPORT | 1 |
| 5 | UPM0317 | SENSOR | 2 |
| 6 | UPM5952 | FRONT SEAT, R.H. | 1 |
| 7 | UF7003 | SHCS M5-0.8 x 12mm | 8 |
| 8 | UPM5955 | SENSOR SUPPORT | 1 |
| 9 | UPM6254 | SHIM 0.1mm | 4 |
| 10 | UPM6255 | SHIM 0.2mm | 8 |
| 11 | UPM6265 | SHIM 0.5mm | 4 |
| 12 | UPM5953 | SHIM 1.0mm | 4 |
| 13 | UPM5951 | FRONT SEAT, L.H. | 1 |
| 14 | UPM4954 | SLIDING PAD | 2 |
| 15 | UF0075 | M5-0.8-SELF TAPPING | 10 |
| 16 | UPM5954 | COVER PLATE | 1 |

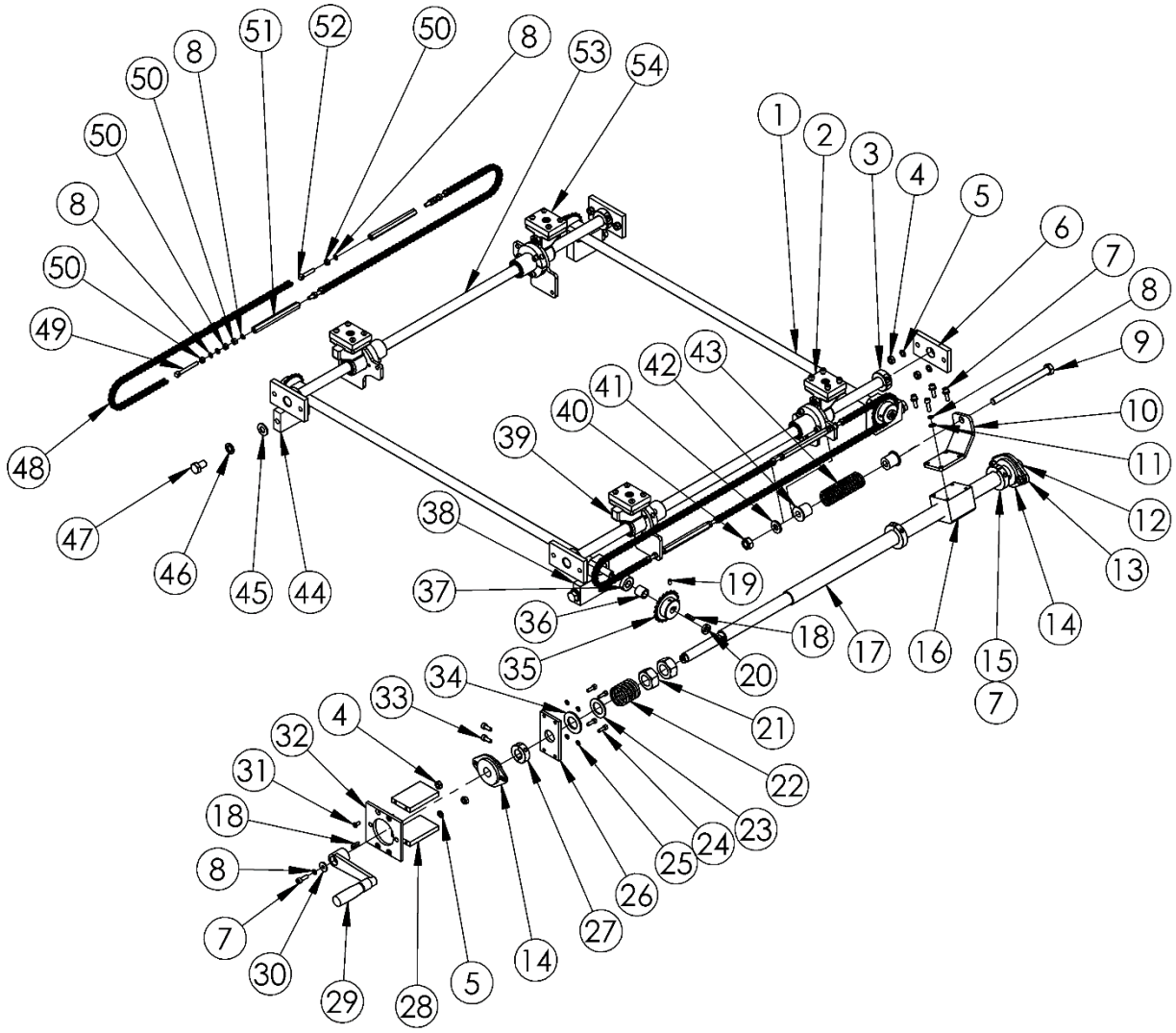
### 9.7.10 UAM0468 – Frame Assembly



UAM0468 - FRAME ASSEMBLY

| ITEM | PART NUMBER | DESCRIPTION | QTY. |
|---|---|---|---|
| 1 | UPM5950 | CORD SLEEVE | 1 |
| 2 | UPM6267 | WIRING BOX | 2 |
| 3 | UF6307 | HEX NUT M5-0.8 | 6 |
| 4 | UF7023 | LW 5MM | 12 |
| 5 | UF6340 | SS FW M5 | 12 |
| 6 | UPM5949 | CYLINDER HEAD | 1 |
| 7 | UPM4987 | CORD SLEEVE ELBOW | 1 |
| 8 | UPM5940 | BASE WELDMENT | 1 |
| 9 | UPM0602 | LEG WELDMENT | 4 |
| 10 | UPM5948 | BASE FRONT COVER | 1 |
| 11 | UF5601 | BHCS M5-0.8×6L | 12 |
| 12 | UF3687 | BHCS M5-0.8×12L | 4 |
| 13 | UF3734 | SS HHCS M12-1.75 x 35mm | 8 |
| 14 | UF3733 | SS LW M12 | 8 |
| 15 | UPM0847 | LEG ADJUSTMENT WELDMENT FOR USA2024 REDESIGN | 4 |
| 16 | UPM0931 | LEG FRICTION PLATE | 4 |
| 17 | UF6343 | SS FW M12 | 8 |
| 18 | UF3680 | FW M10 | 24 |
| 19 | UF6371 | M10 LW | 24 |
| 20 | UF1540 | HNR 3/8-16 | 24 |
| 21 | UPM4939 | ELECTRICAL RECEPTACLE CONNECTION MALE | 1 |
| 22 | UF3759 | SS SHCS M4-0.7 x 10mm | 4 |
| 23 | WET0241 | CORD GRIP | 2 |
| 24 | UF3681 | LW M4 | 4 |
| 25 | UPM4929 | ELECTRICAL RECEPTACLE BASE | 1 |
| 26 | UPM4938 | RECEPTACLE CONNECTION | 1 |
| 27 | UF3187 | SHCS M6-1.0×16L | 2 |
| 28 | UF6411 | SS LW M6 | 2 |
| 29 | UF6341 | SS FW M6 | 2 |
| 30 | UPM4936 | RUBBER RING | 2 |
| 31 | UPM5966 | ROLLER, dia 17, 72L, BLACK | 1 |
| 32 | UPM6228 | SHAFT, L115, GROOVED | 1 |
| 33 | UPM5967 | GUIDE ROLLER, 40OD | 2 |
| 34 | UF0079 | SHCS M6-1.0×6L | 8 |
| 35 | UPM5945 | REAR BEAM | 1 |
| 36 | UF3148 | M5-0.8 x 16 SHCS | 2 |
| 37 | UPM5944 | FRONT BEAM | 1 |

# *9.8 UAM0508 – GUIDE ADJUSTMENT ASSEMBLY*

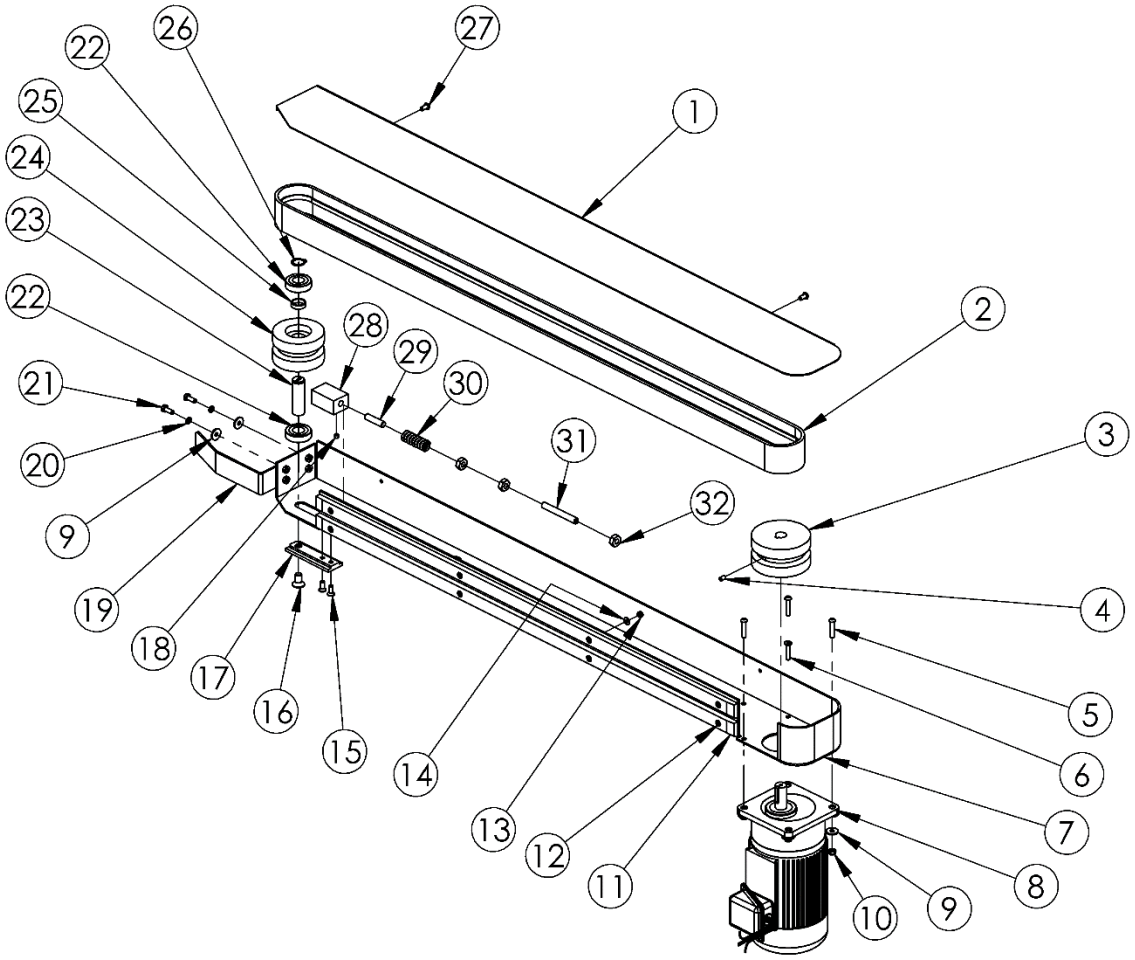



UAM0508 - GUIDE ADJUSTMENT ASSEMBLY

| ITEM | PART NUMBER | DESCRIPTION | QTY. |
|---|---|---|---|
| 1 | UPM6269 | SHAFT 888.6mm L | 2 |
| 2 | UAM0509 | FLOATING SUPPORT | 1 |
| 3 | UPM3330 | SHAFT COLLAR, 20mm | 4 |
| 4 | UF6369 | M8-1.25-HNR | 12 |
| 5 | UF3640 | LW M8 | 12 |
| 6 | UPM6079 | SHAFT ANCHOR PLATE, SS | 4 |
| 7 | UF3179 | SHCS M6-1.0×20L | 7 |
| 8 | UF6363 | LW M6 | 21 |
| 9 | UF0114 | M12-1.75-HHCS | 1 |
| 10 | UPM6153 | BRACKET | 1 |
| 11 | UF1828 | M6 FW | 4 |

| ITEM | PART NUMBER | DESCRIPTION | QTY. |
|---|---|---|---|
| 12 | UPM6270 | CAP | 1 |
| 13 | UPM6268 | BRING SPCR ALU. 2.00ID X .125THK | 1 |
| 14 | UPM0523 | FLANGE BEARING | 2 |
| 15 | UPM6156 | SHAFT COLLAR, ONE PIECE | 2 |
| 16 | UPM6272 | GUIDE BLOCK | 1 |
| 17 | UPM6152 | ADJUSTMENT SHAFT | 1 |
| 18 | UPM5773 | KEY 5x5-20 | 5 |
| 19 | UF5925 | M5-0.8 10L SET SCREW | 8 |
| 20 | UPM0150 | SPROCKET SHAFT WASHER | 4 |
| 21 | UF3816 | M24-1.5-HNR | 2 |
| 22 | UPM0054 | SPRING 1-17/64 OD X 1-5/8 LG X .148 | 1 |
| 23 | UF0053 | M24 FW | 1 |
| 24 | UF3169 | SHCS M5-0.8 x 16mm | 4 |
| 25 | UF7021 | LW M5 | 4 |
| 26 | UPM6160 | SPRING PLATE | 1 |
| 27 | UF2231 | SHAFT COLLAR, SET SCR, 3/4" BORE | 1 |
| 28 | UPM6159 | STANDOFF | 2 |
| 29 | UPE0001 | HANDLE, FOLDABLE | 1 |
| 30 | UF0103 | M6 FW, 19MM OD 2MM THK | 1 |
| 31 | UF5400 | FHCS M5-0.8×12L | 8 |
| 32 | UPM6157 | BEARING SPACER | 1 |
| 33 | UF3187 | SHCS M6-1.0×16L | 4 |
| 34 | UPM6161 | FIBER WASHER | 1 |
| 35 | UPM0028 | SPROCKET | 4 |
| 36 | UPM1646 | SPROCKET SHAFT SPACER (LONG) | 4 |
| 37 | UPM1637 | BEARING R8-2RS | 4 |
| 38 | UPM3262 | SPROCKET SHAFT BEARING HOUSING RH | 2 |
| 39 | UAM0141 | DRIVE SUPPORT RSA 2024 | 1 |
| 40 | M12-1.75 | LOCK-NUT | 1 |
| 41 | UPM6158 | SEAL | 1 |
| 42 | UPM6154 | SPRING SHAFT | 2 |
| 43 | UPM6155 | SPRING | 1 |
| 44 | UPM3275 | SPROCKET SHAFT BEARING HOUSING LH | 2 |
| 45 | UF4231 | M12 FW | 4 |
| 46 | UF4230 | LW M12 | 4 |
| 47 | UF0061 | HHCS M12-1.75×20L | 4 |
| 48 | UPM6272 | CHAIN #35 | 4 |
| 49 | UPM3260 | CHAIN THREADED LINK RH | 4 |
| 50 | UF0062 | M6-1.0-HNR | 16 |
| 51 | UPM3255 | TURNBUCKLE | 4 |
| 52 | UPM1168 | CHAIN THREADED LINK LH | 4 |
| 53 | UPM3316 | SHAFT 20MM CG RSA 2024 | 2 |
| 54 | UAM0516 | DRIVE SUPPORT RSA 2024 MODIFIED | 2 |

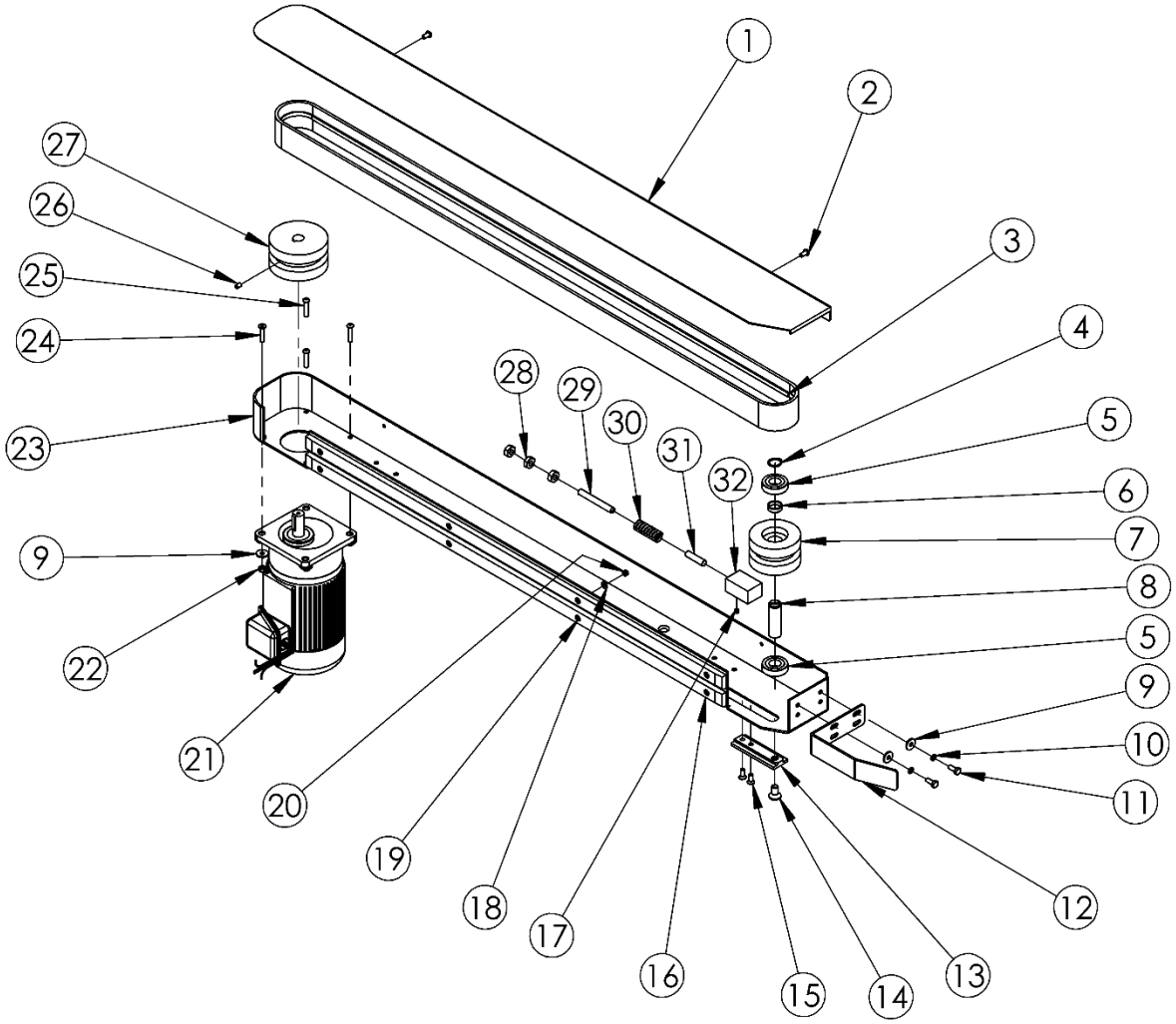
## *9.9 UAM0510 – DRIVE UNIT, LEFT HAND*



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 |

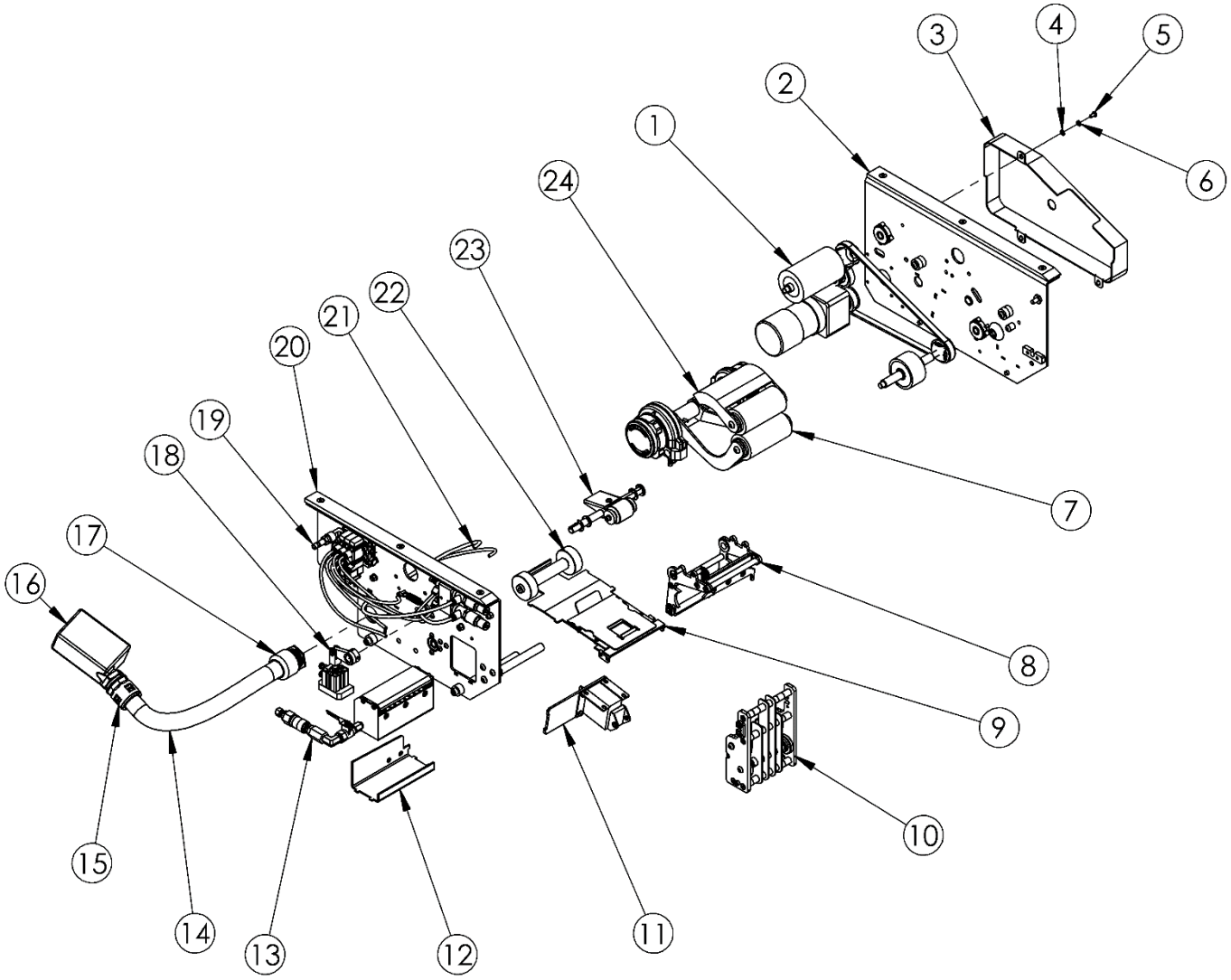
## *9.10 UAM0511 – DRIVE UNIT, RIGHT HAND*



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 |

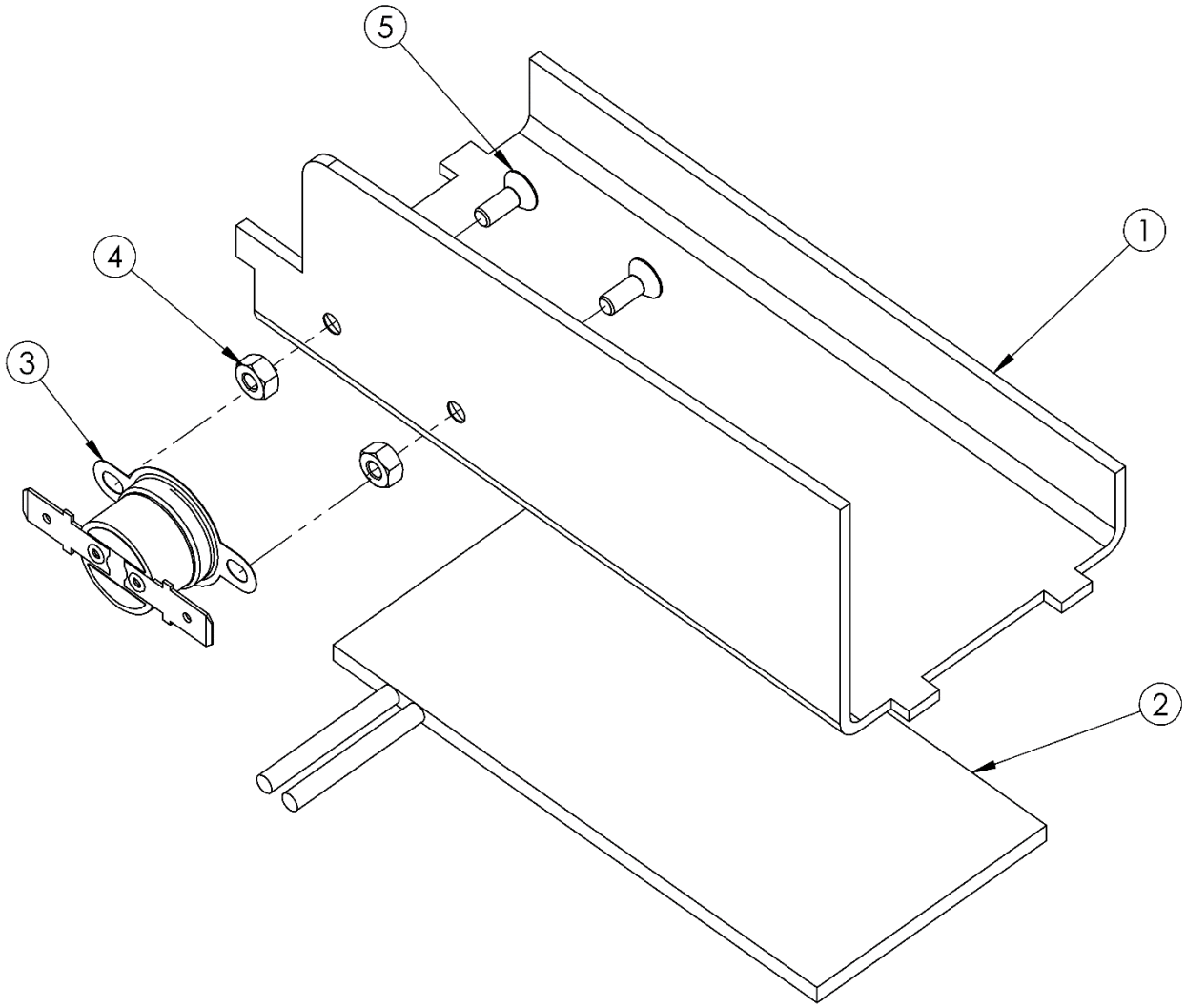
## *9.11 WST1036 – BOTTOM TAPE HEAD ASSEMBLY*



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 |

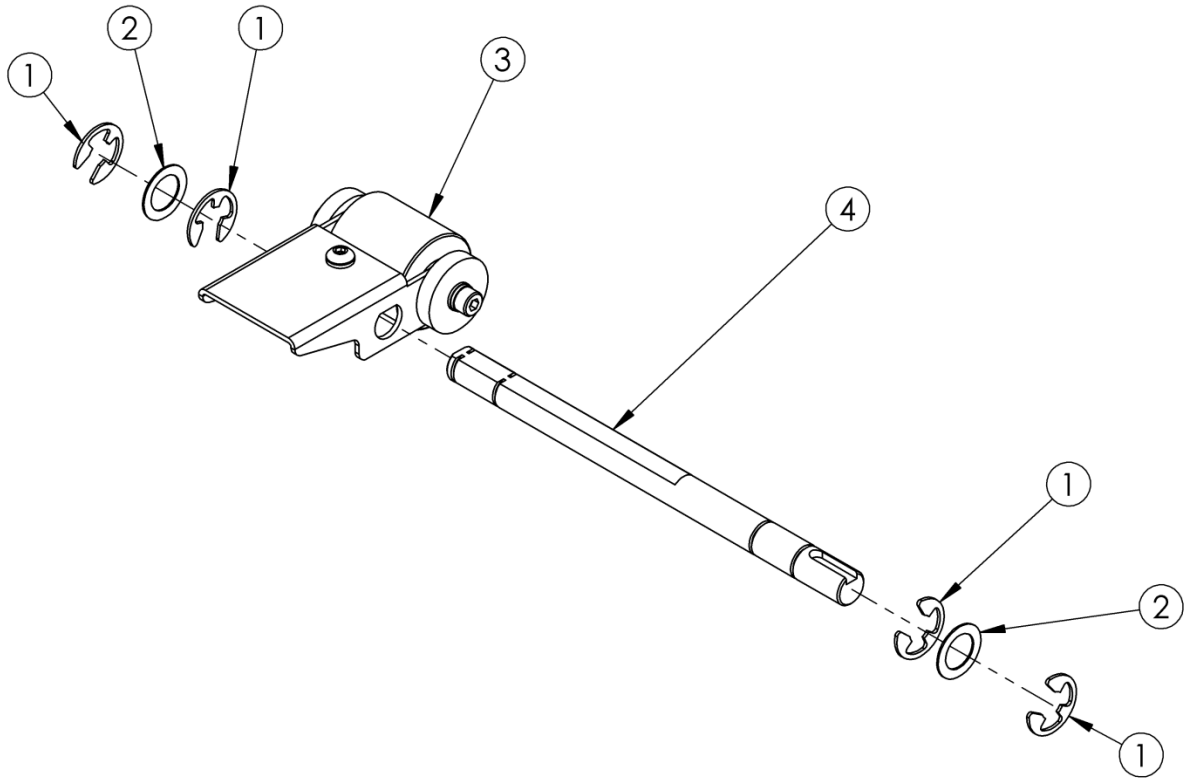
### 9.11.1 WST1023 – Heater Plate Assembly




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 |

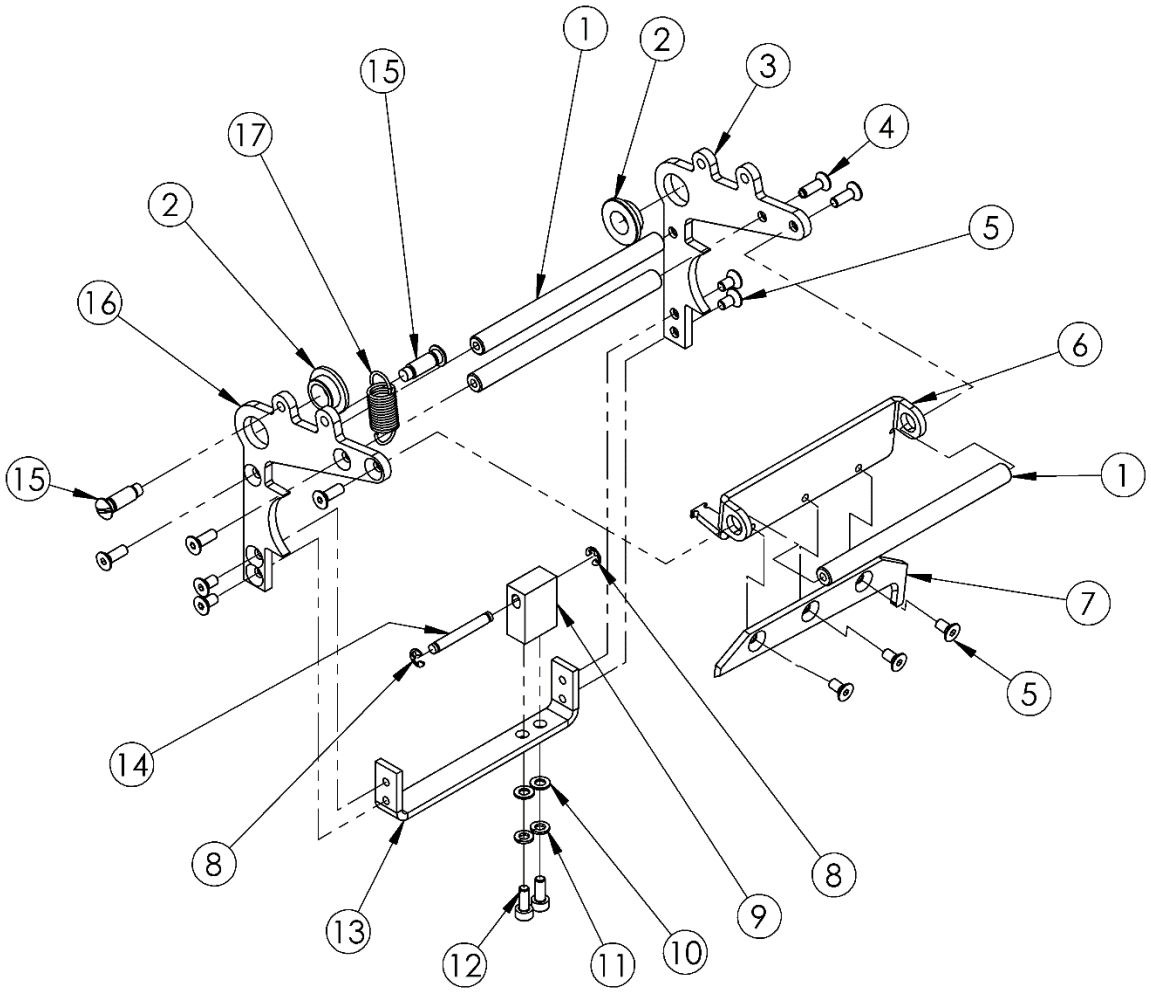
### 9.11.2 WST0059 – Pinch Roller Assembly




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 |

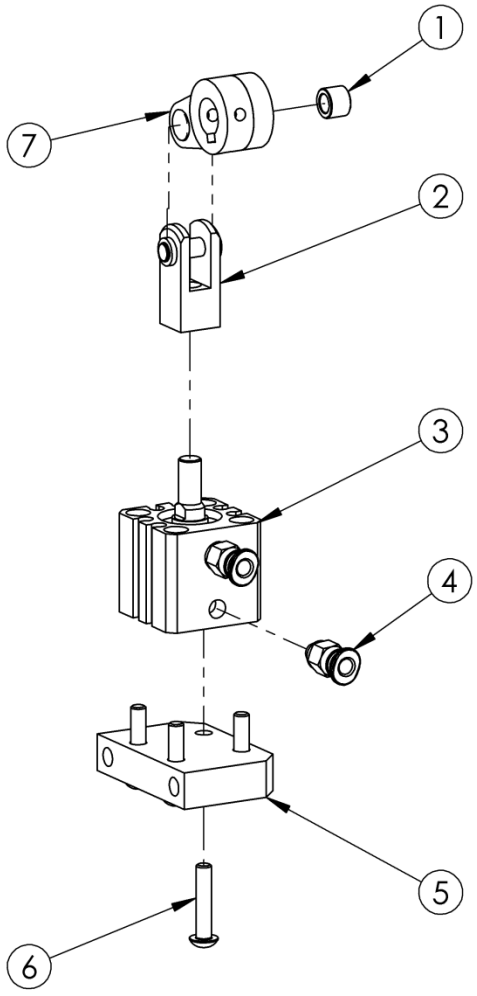
### 9.11.3 WST0058 – Bottom Knife Arm Assembly




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 |

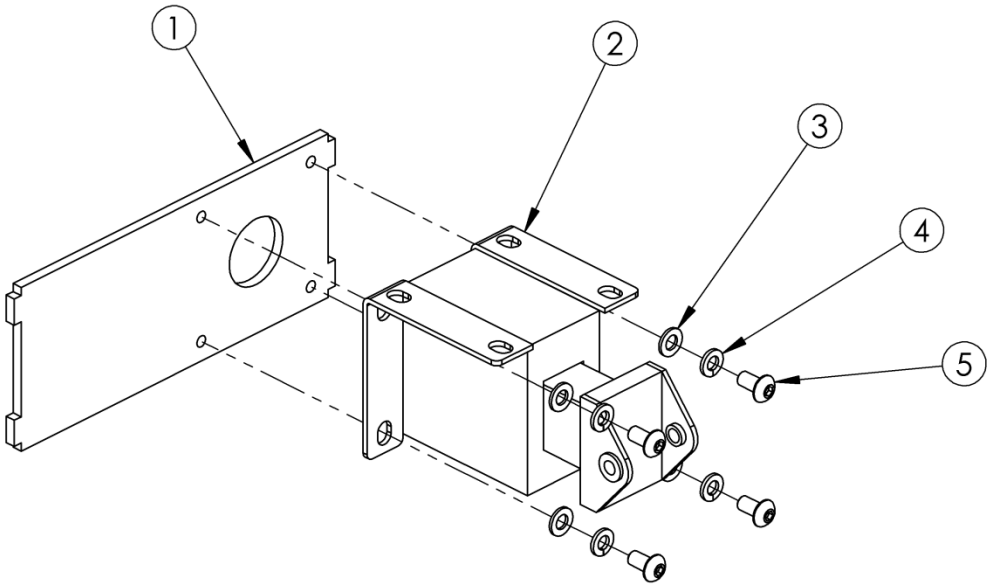
### 9.11.4 WST1025 – Pinch Roller Cylinder Assembly




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 |

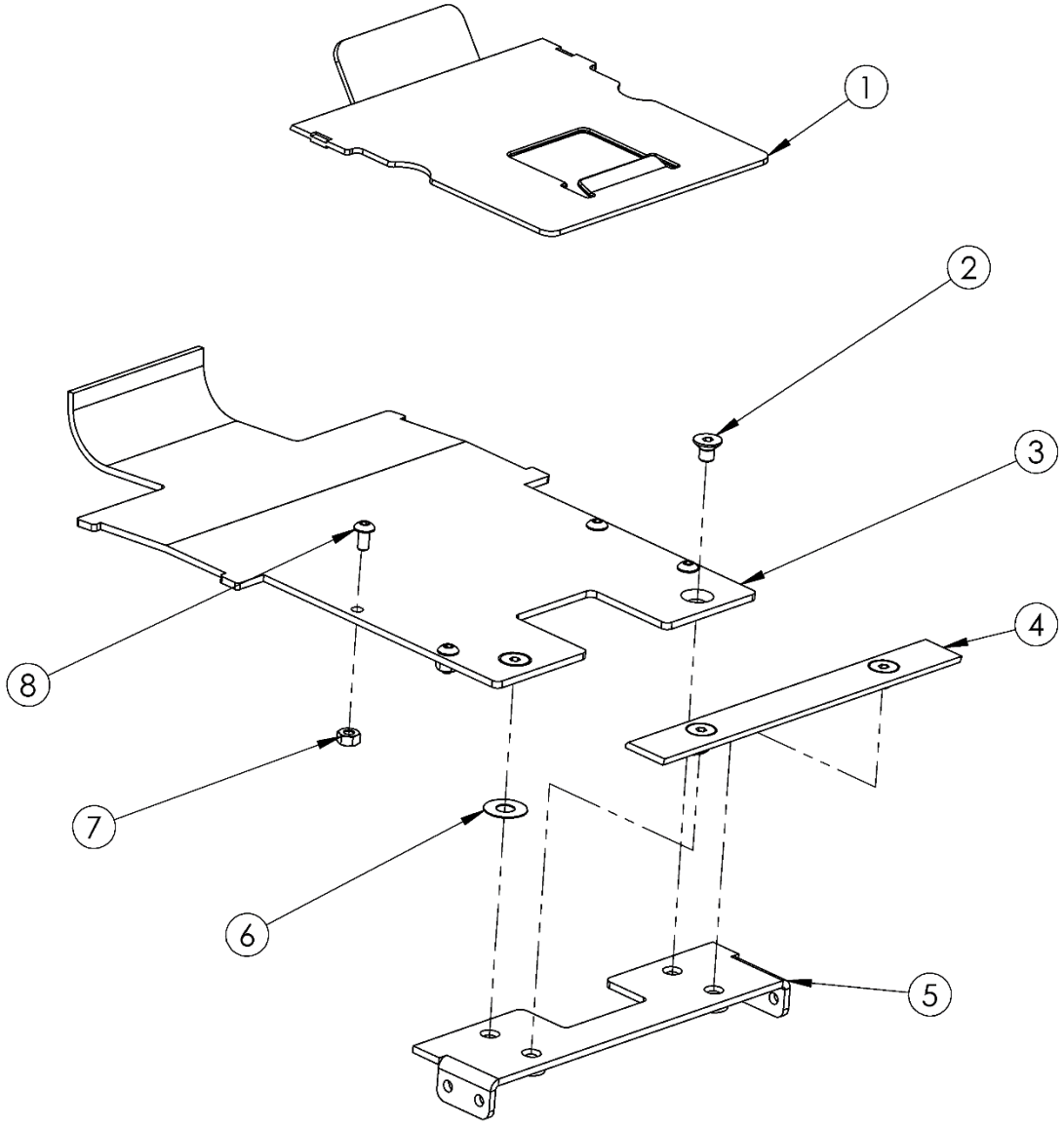
### 9.11.5 WST0057 – Solenoid Assembly




WST0057 - SOLENOID 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 |

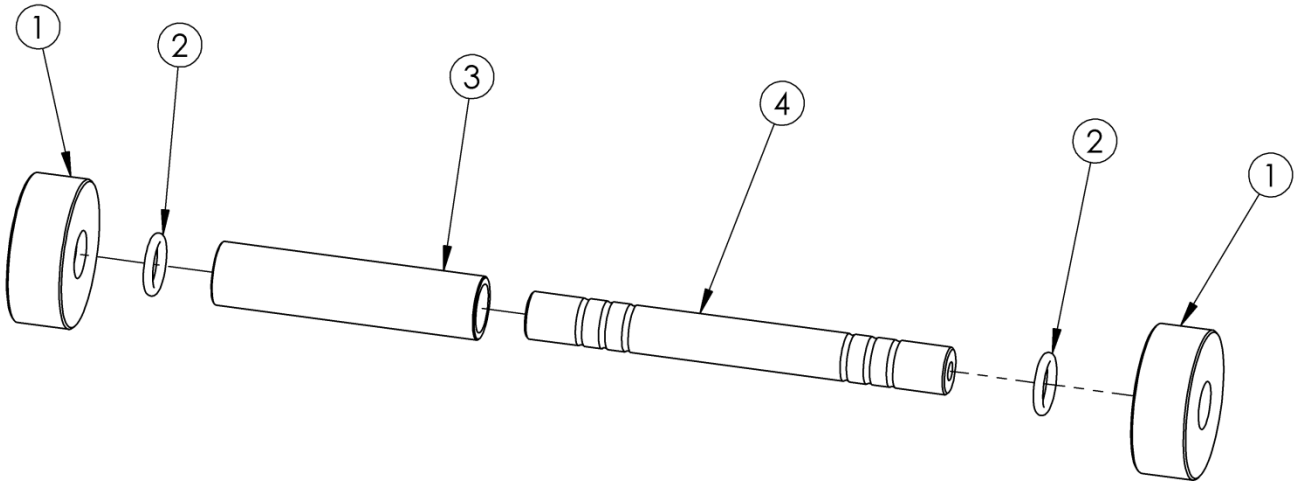
### 9.11.6 WST1027 – Tape Guide Assembly




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 |

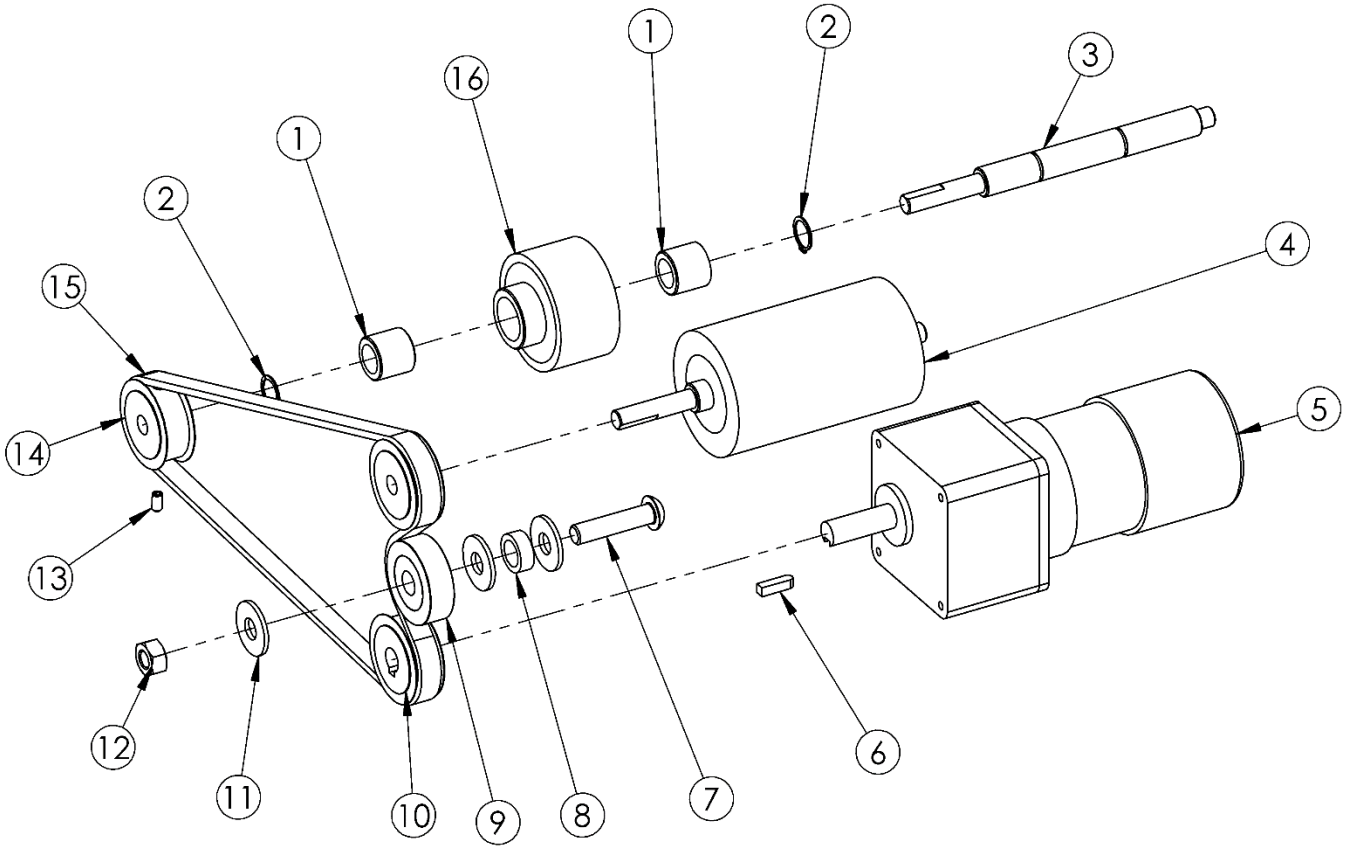
### 9.11.7 WST1026 – Guide Roller Assembly




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 |

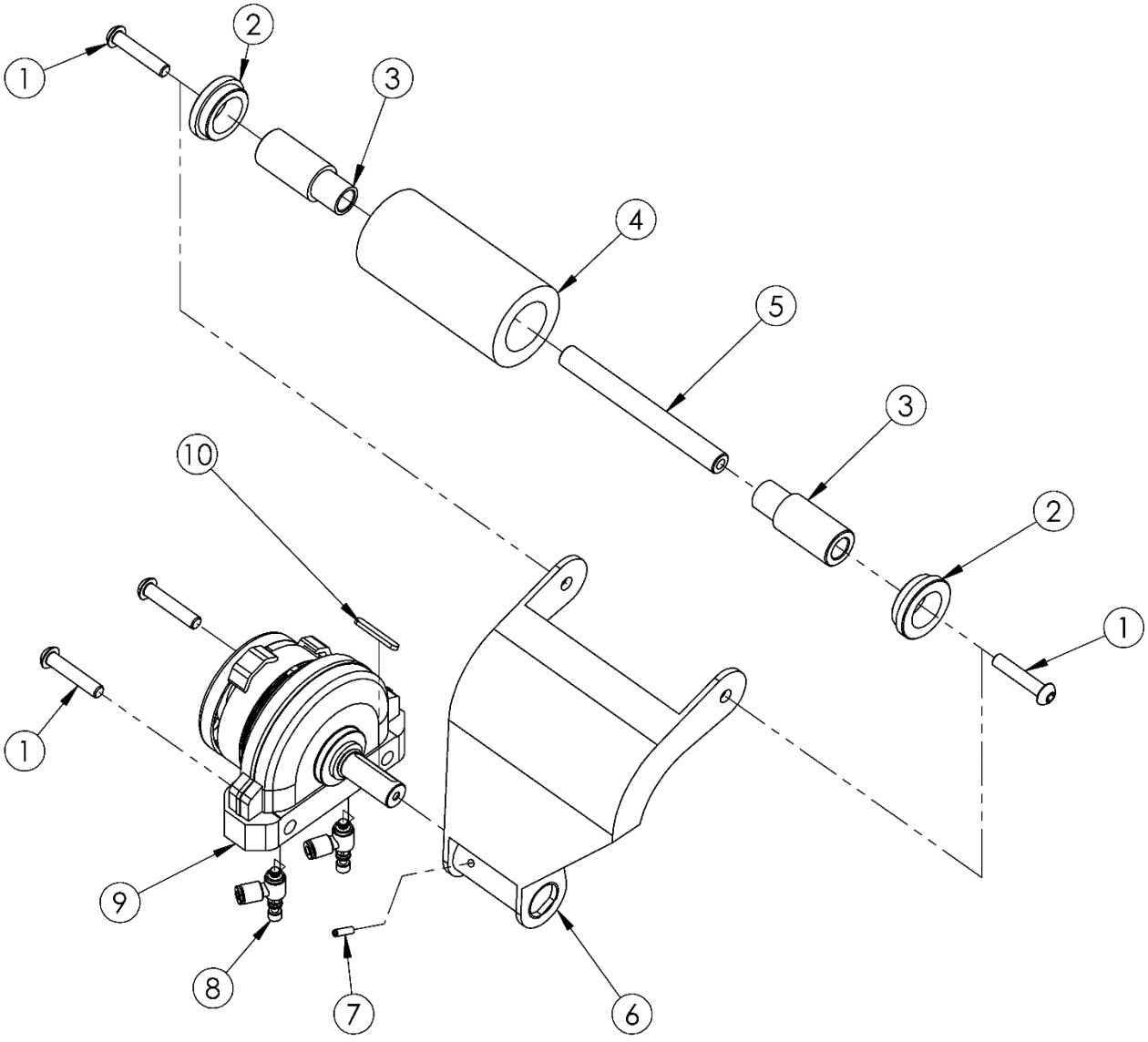
### 9.11.8 WST1028 – Drivetrain Assembly




WST1028 - DRIVETRAIN 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 |

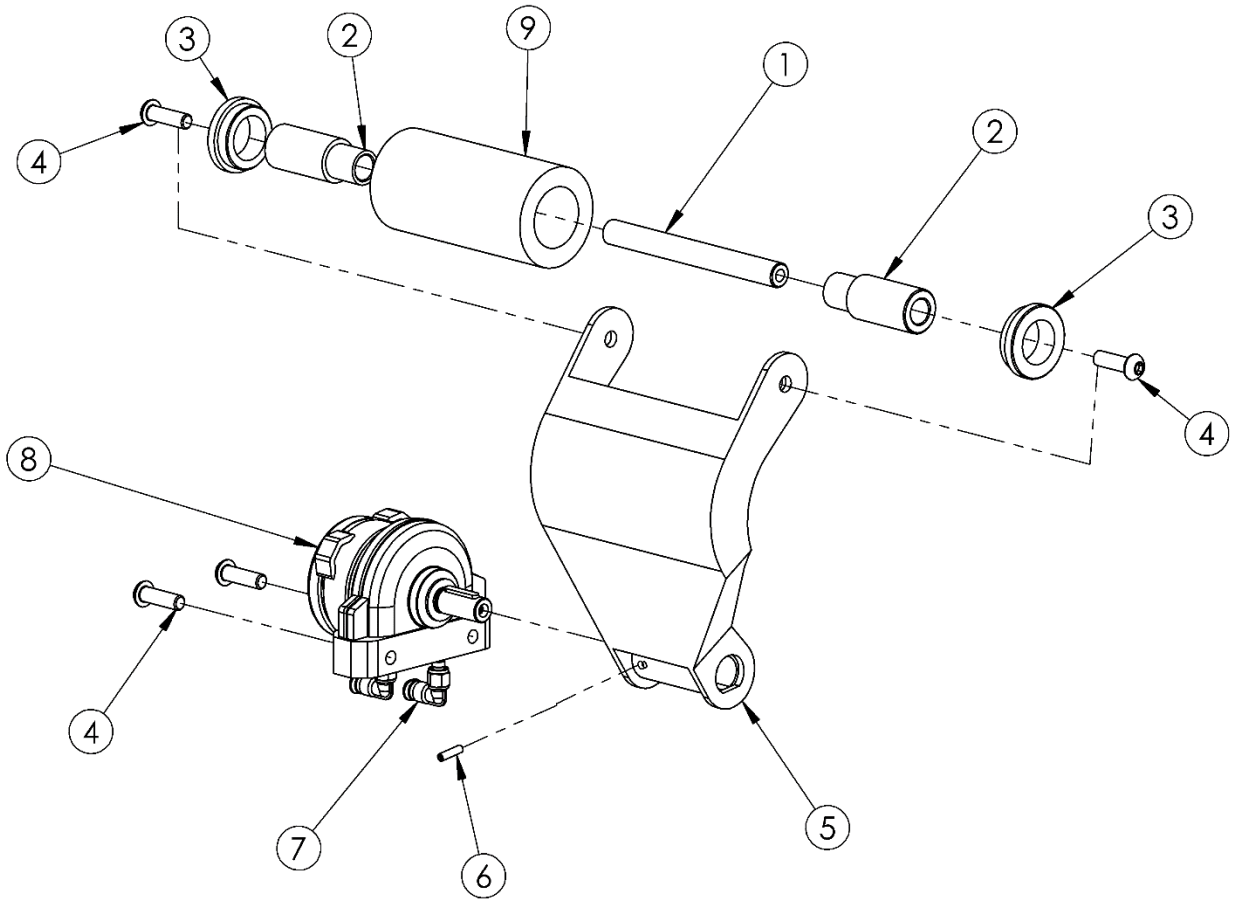
### 9.11.9 WST1030 – Rear Tucking Arm Assembly




WST1030 - REAR TUCKING 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 |

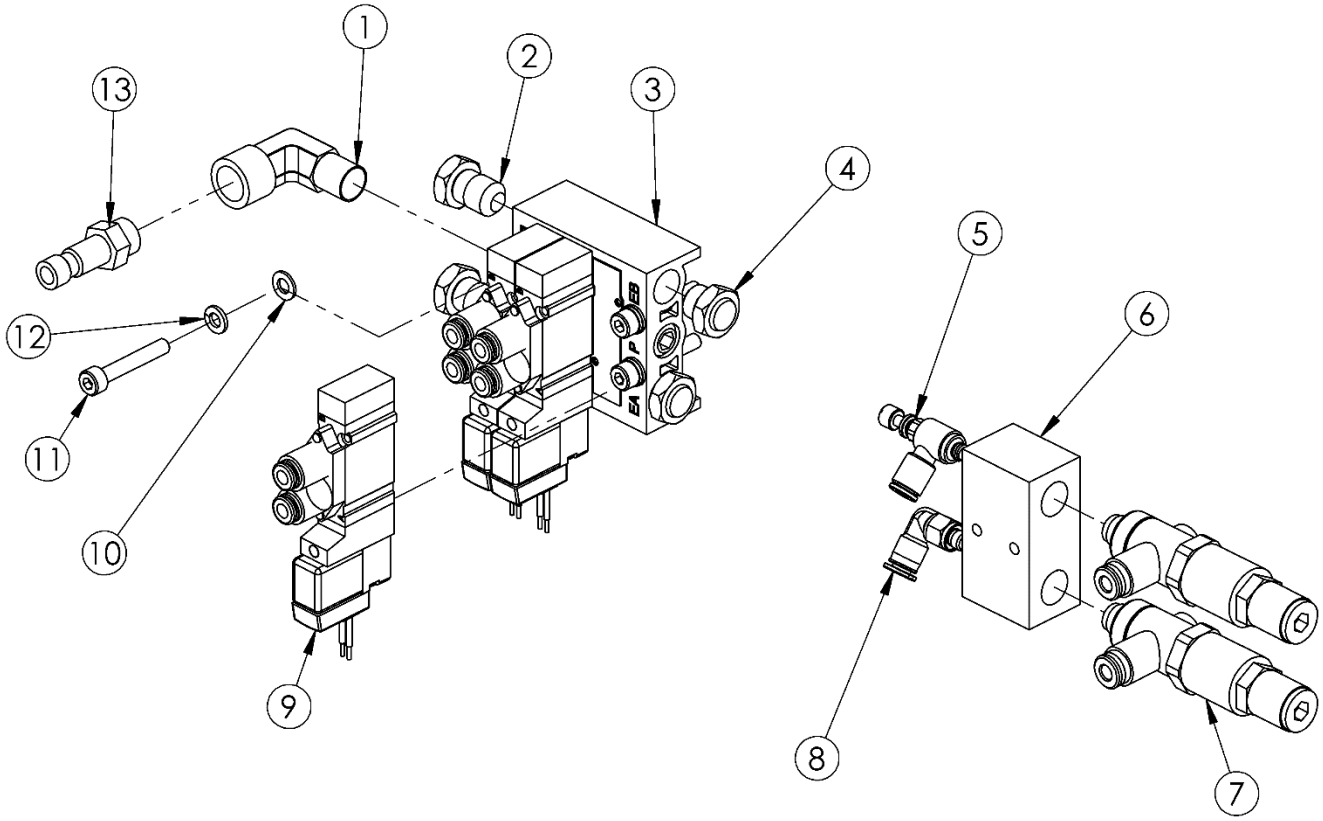
### 9.11.10 WST1029 – Front Wipe Down Arm Assembly




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 |

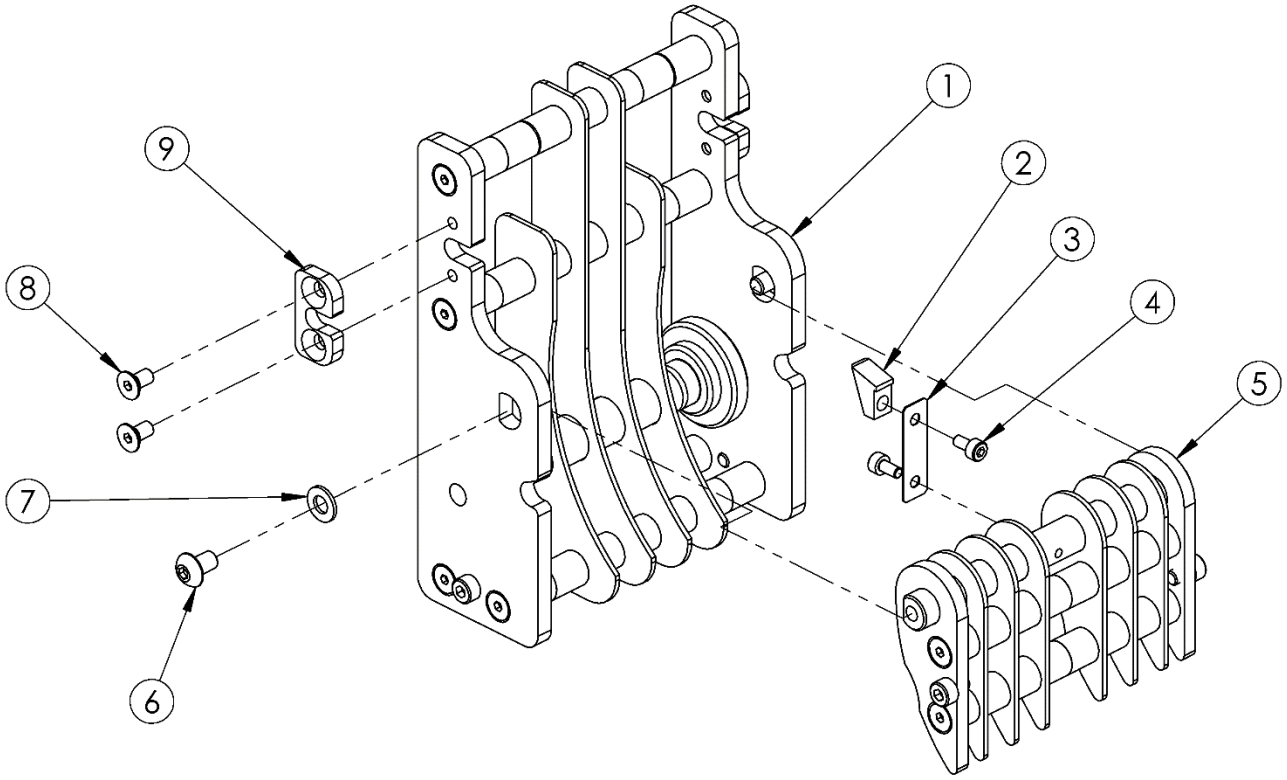
### 9.11.11 WST1032 – Control Valve Assembly




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 |

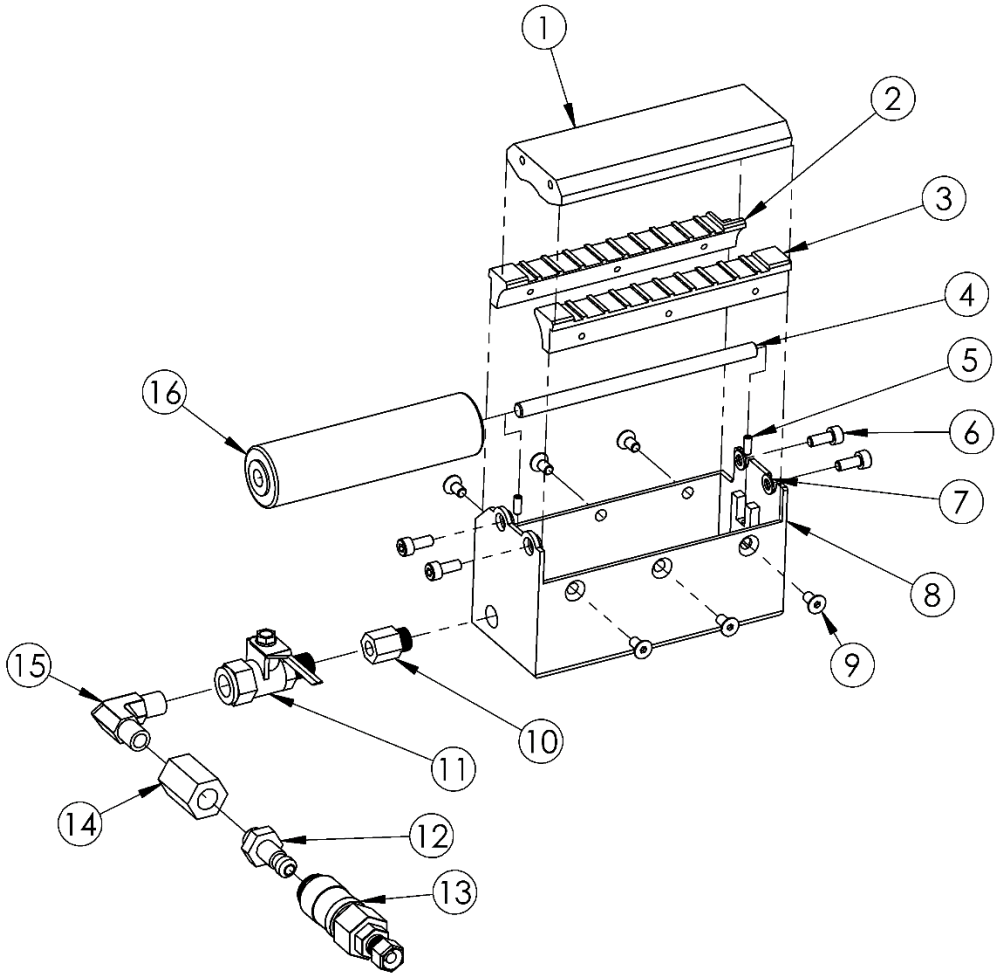
### 9.11.12 WST1022 – Tape Shoe Assembly




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 |

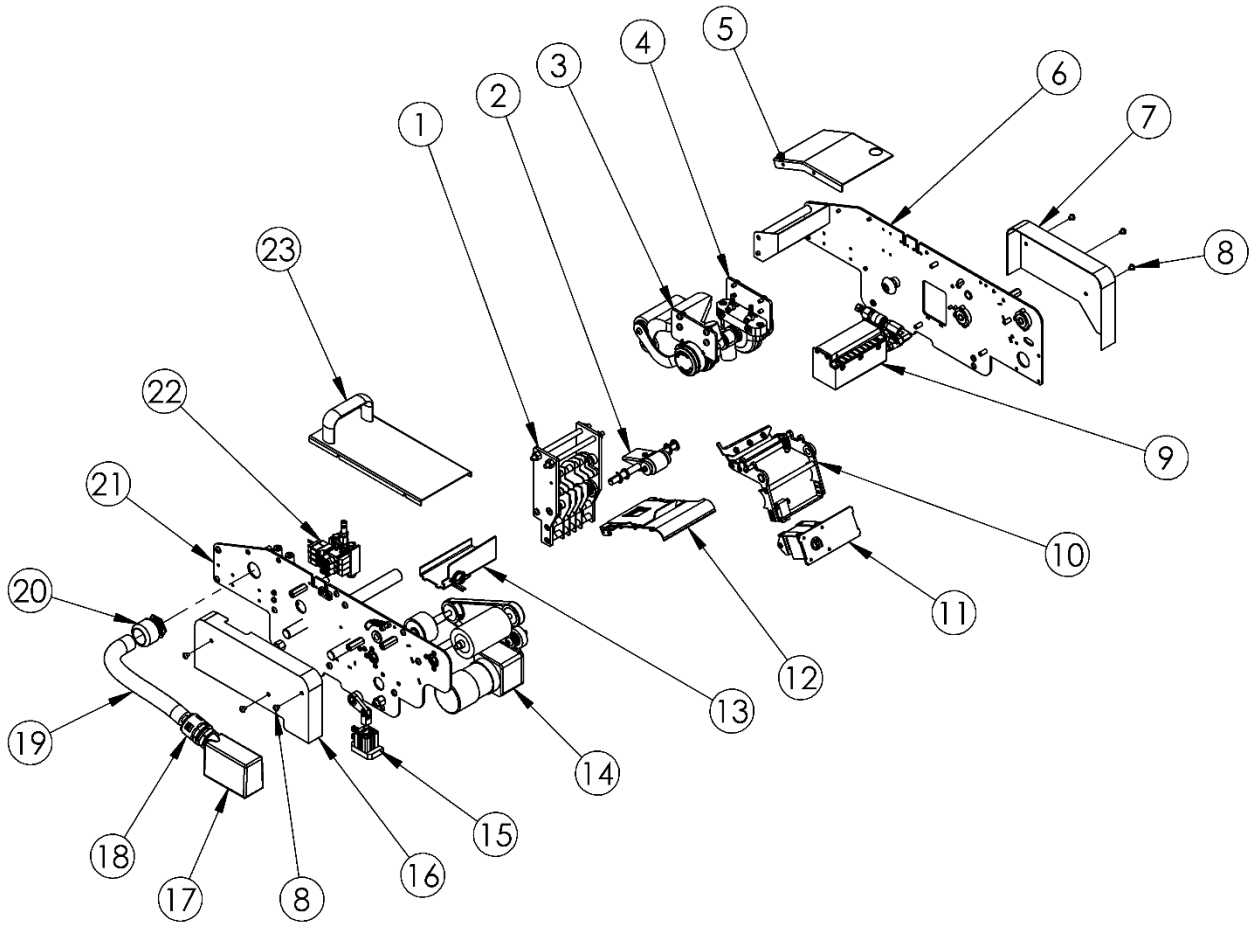
### 9.11.13 WST1031 – Water Pot Assembly




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 |

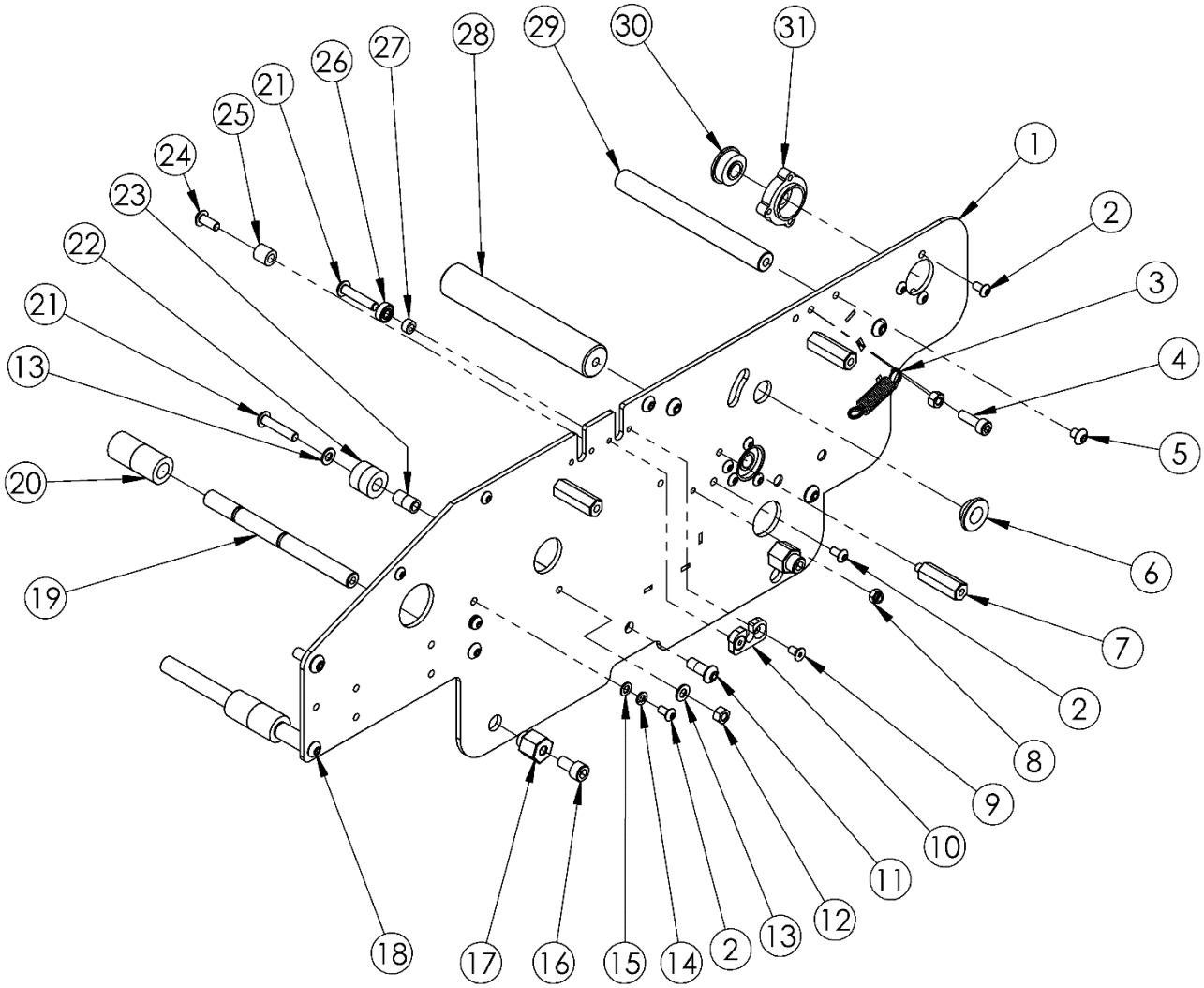
# *9.12 WST1047 – TOP TAPE HEAD ASSEMBLY*



WST1047 - TOP TAPE HEAD ASSEMBLY

| 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 |

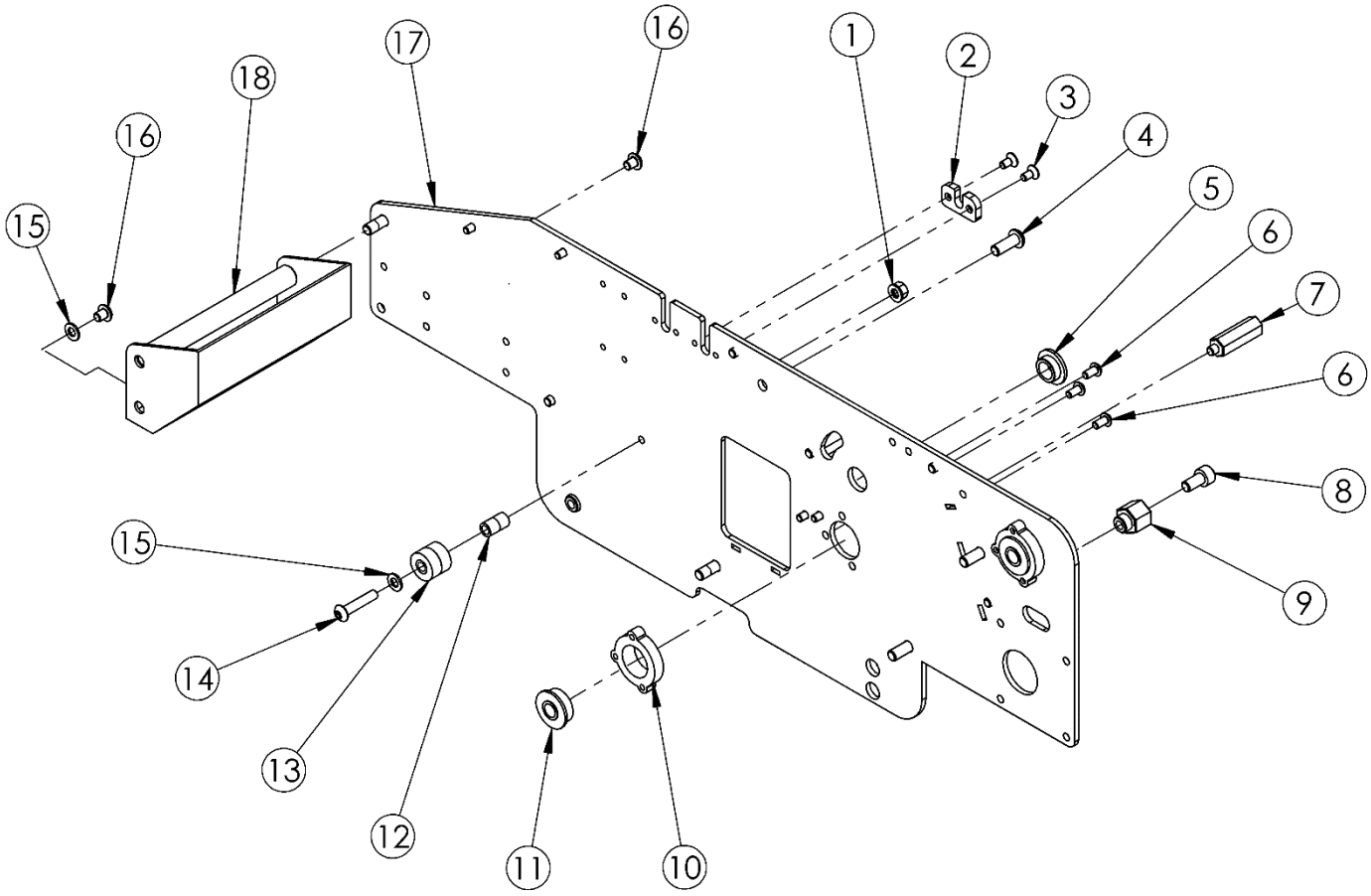
### 9.12.1 WST1037 – Left Frame Assembly



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 |

### 9.12.2 WST1038 – Right Frame Assembly



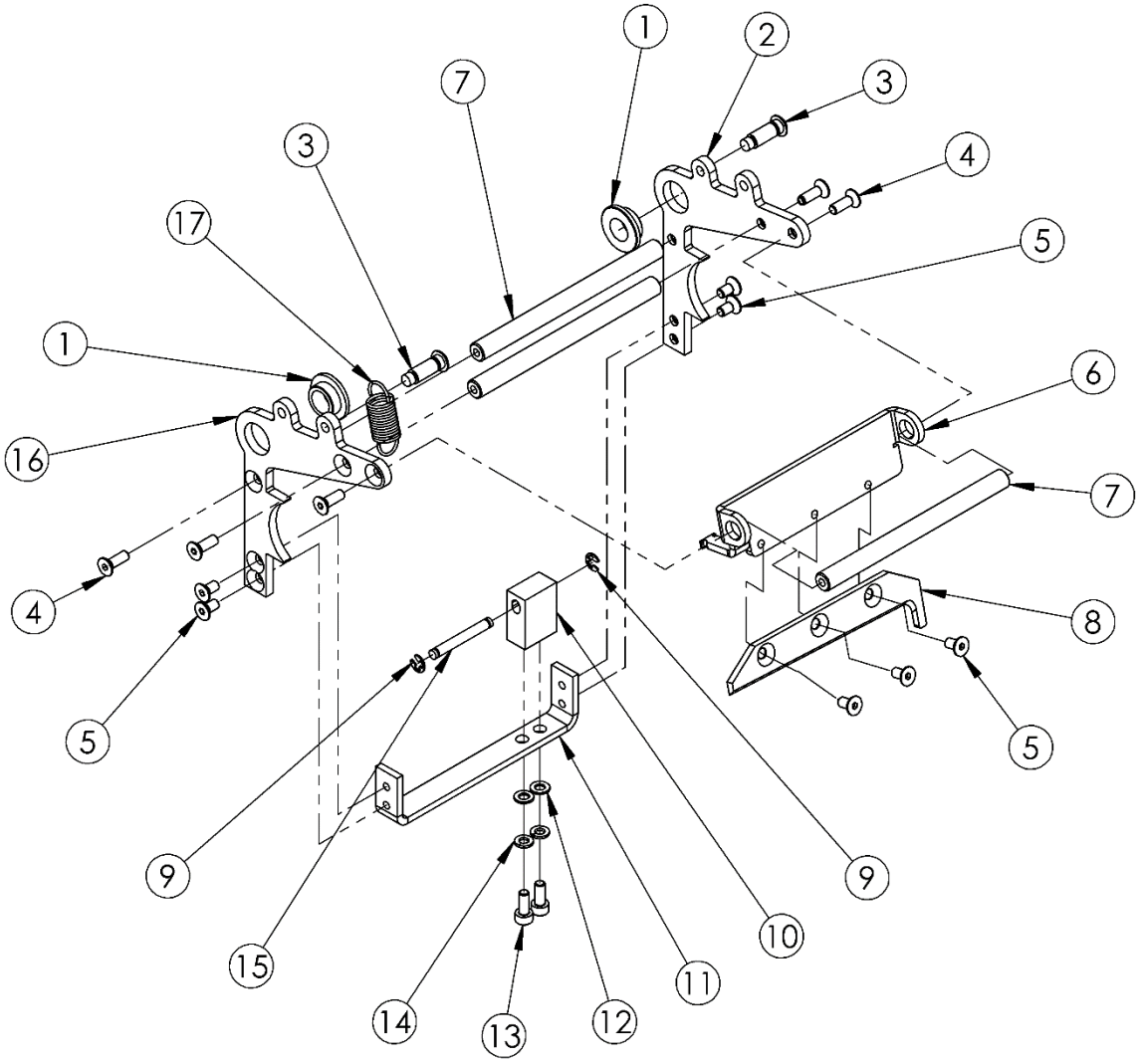
WST1038 - RIGHT FRAME ASSEMBLY

| 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 |

**9.12.3 WST1023 – Heater Plate Assembly** - Same as for Bottom Tape Head Assembly.
Refer to **9.11.1 WST1023 – Heater Plate Assembly**.

**9.12.4 WST0059 – Pinch Roller Assembly** - Same as for Bottom Tape Head Assembly.
Refer to **9.11.2 WST0059 – Pinch Roller Assembly**.

### 9.12.5 WST0060 – Top Knife Arm Assembly



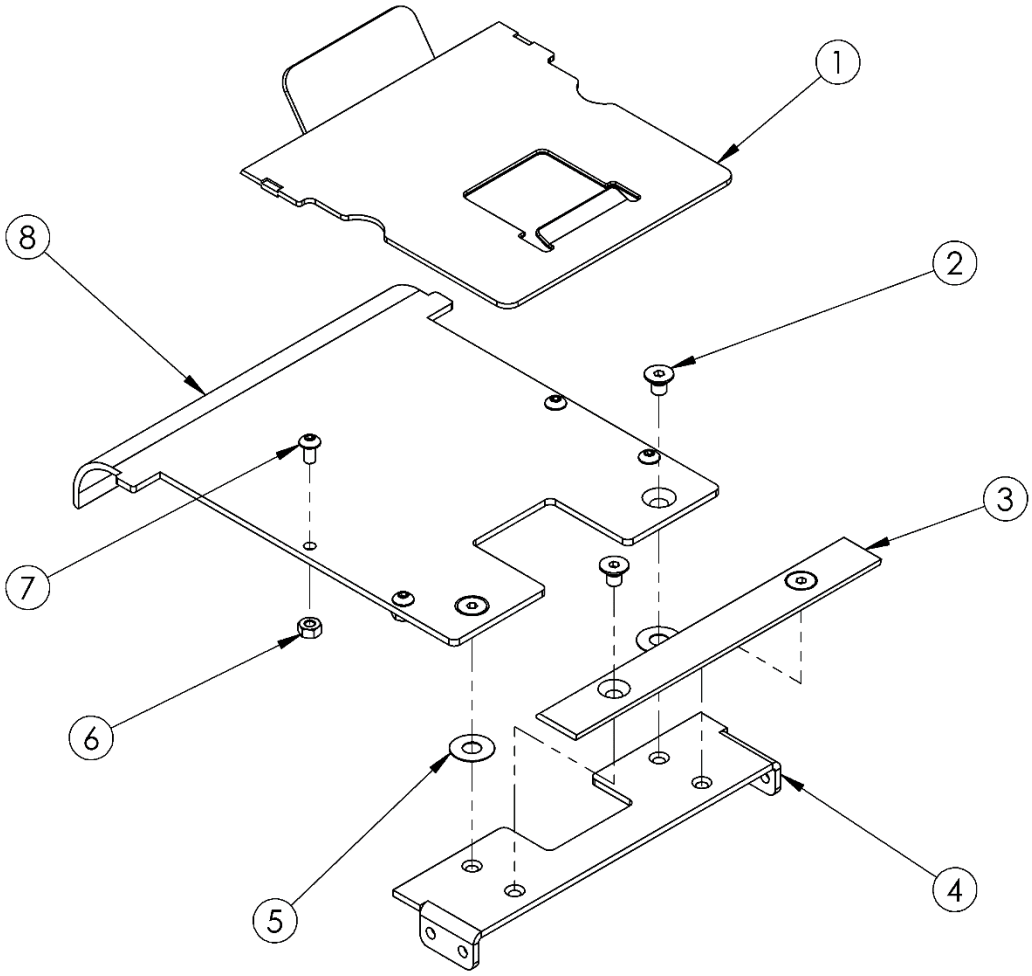
WST0060 - TOP KNIFE ARM ASSEMBLY

| 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 |

**9.12.6 WST1025 – Pinch Roller Cylinder Assembly** - Same as for Bottom Tape Head Assembly.
Refer to **9.11.4 WST1025 – Pinch Roller Cylinder Assembly**.

**9.12.7 WST0057 – Pinch Roller Assembly** - Same as for Bottom Tape Head Assembly.
Refer to **9.11.5 WST0057 – Solenoid Assembly**.

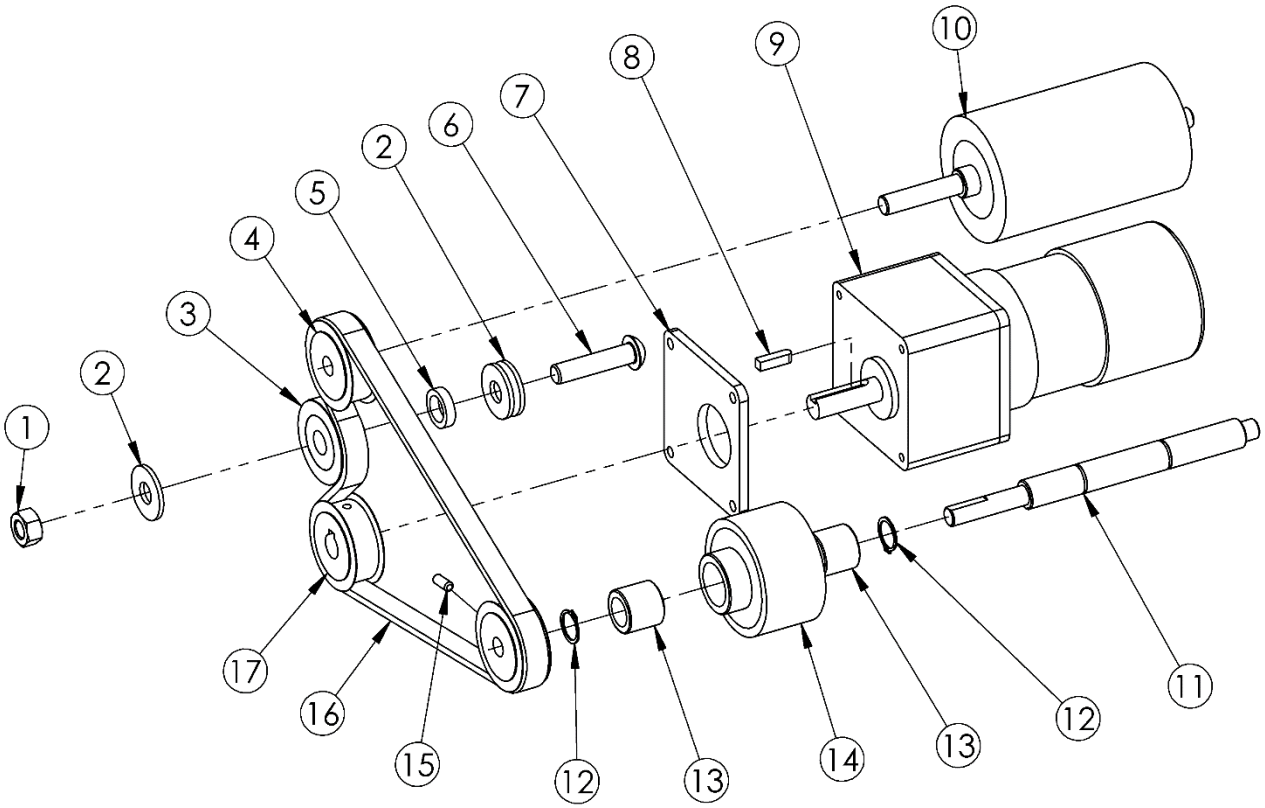
### 9.12.8 WST1040 – Top Tape Guide Assembly




WST1040 - TOP 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 | 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 |

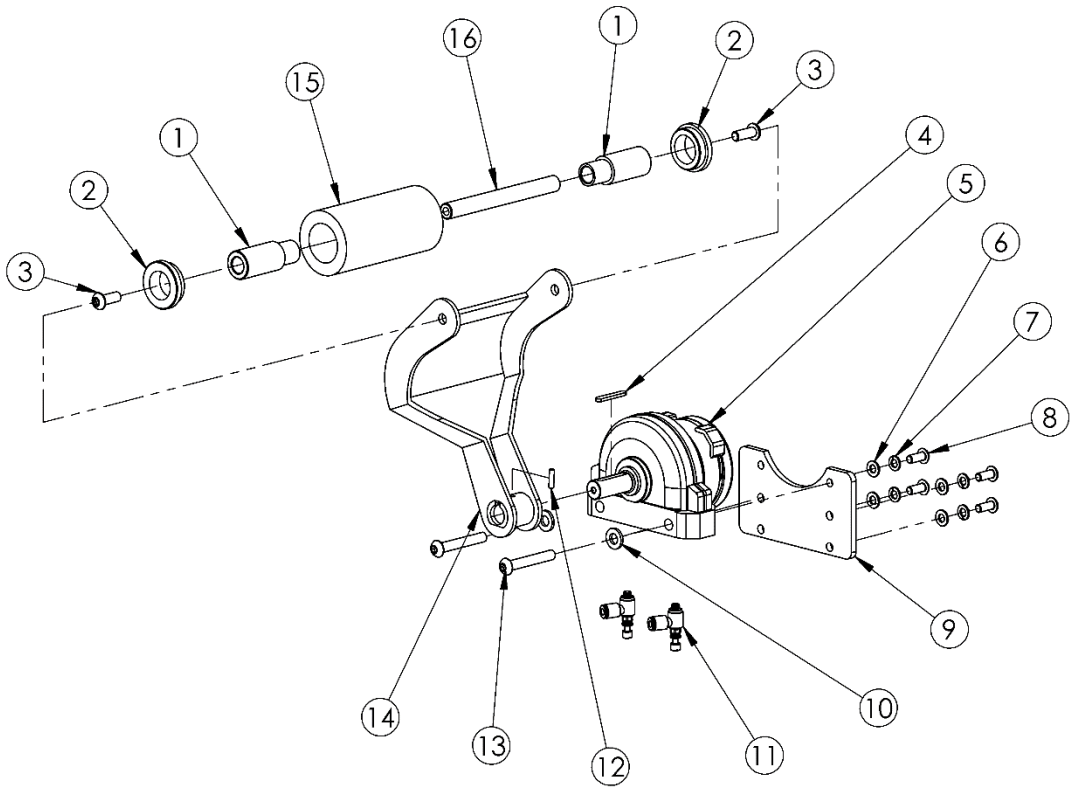
### 9.12.9 WST1043 – Drivetrain Assembly




WST1043 - DRIVETRAIN 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 |

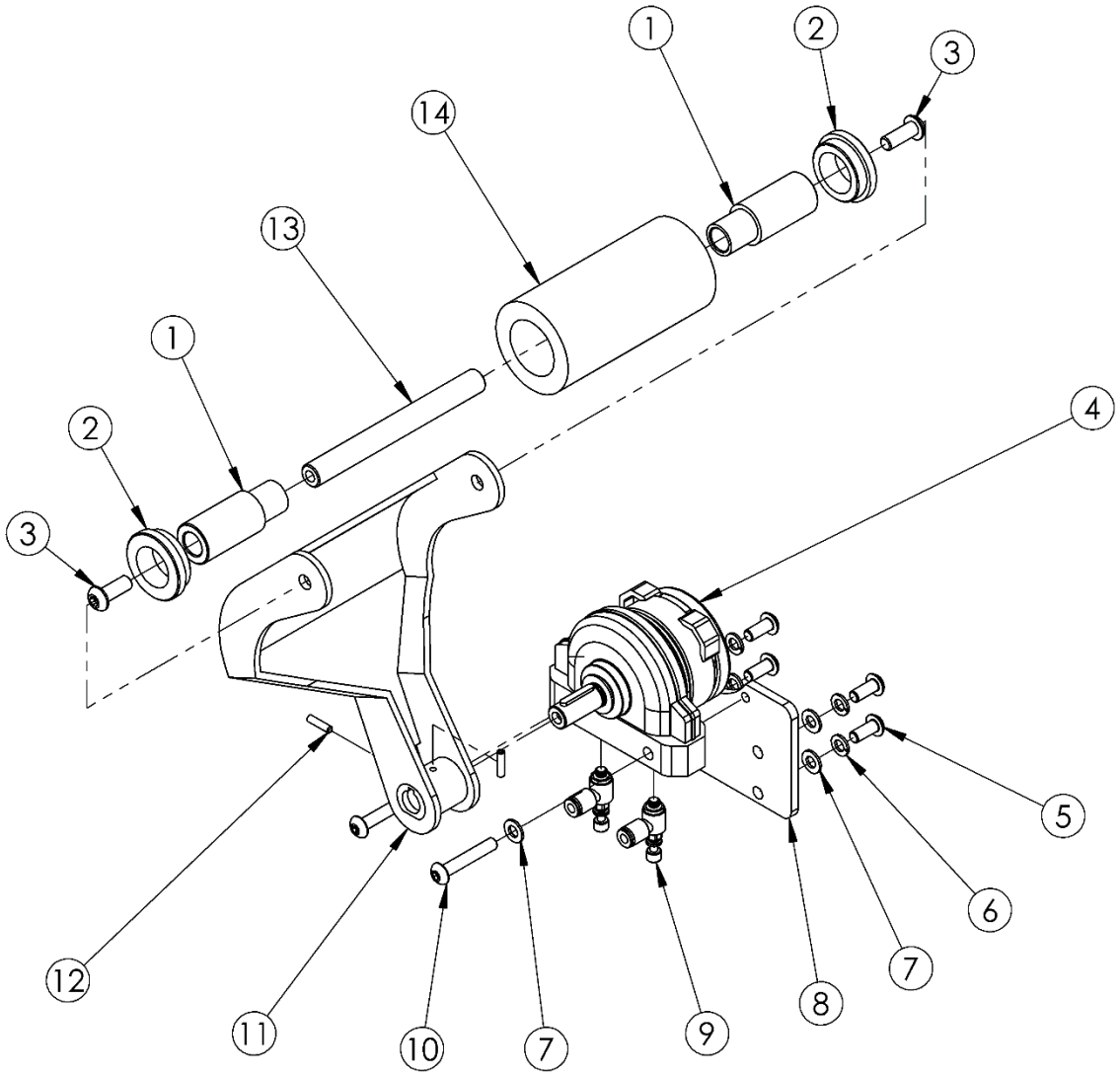
### 9.12.10 WST1044 – Rear Tucking Arm Assembly




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 |

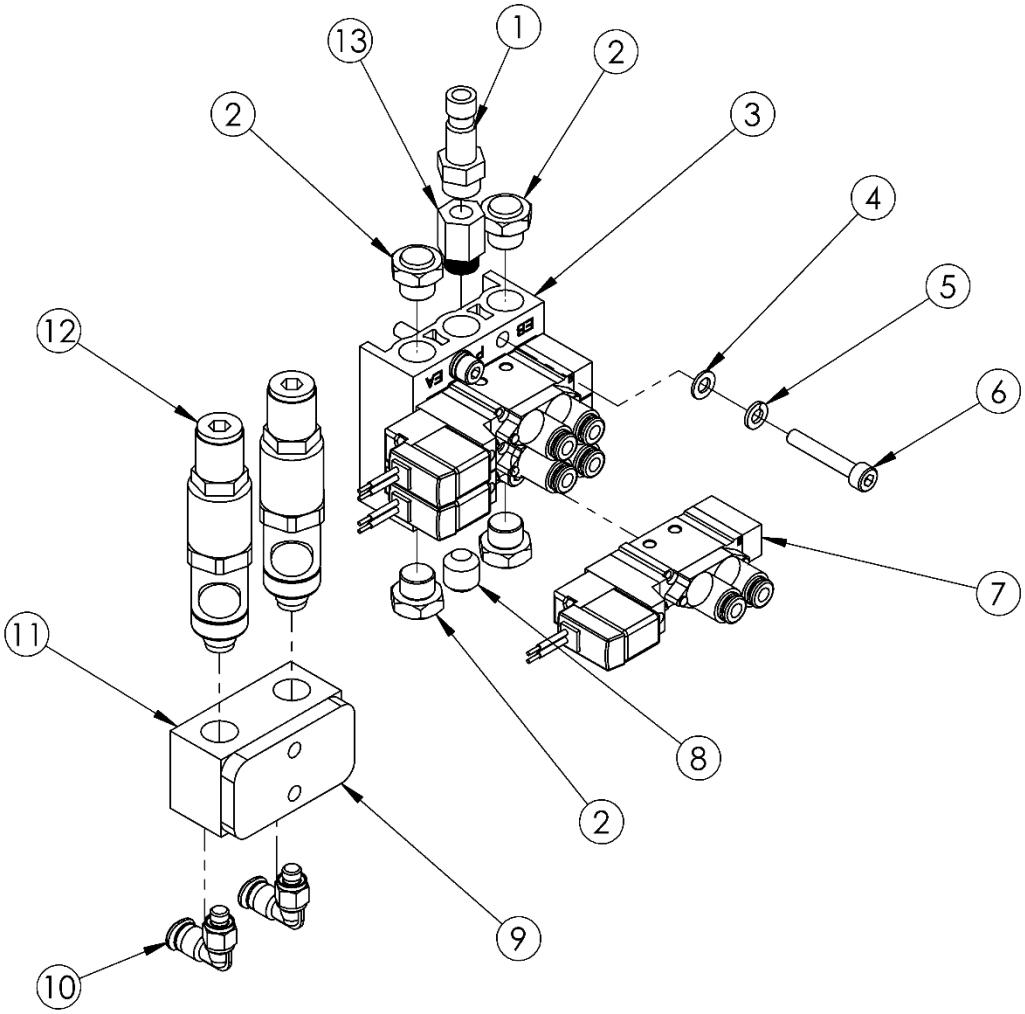
### 9.12.11 WST1045 – Front Tucking Arm Assembly




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 |

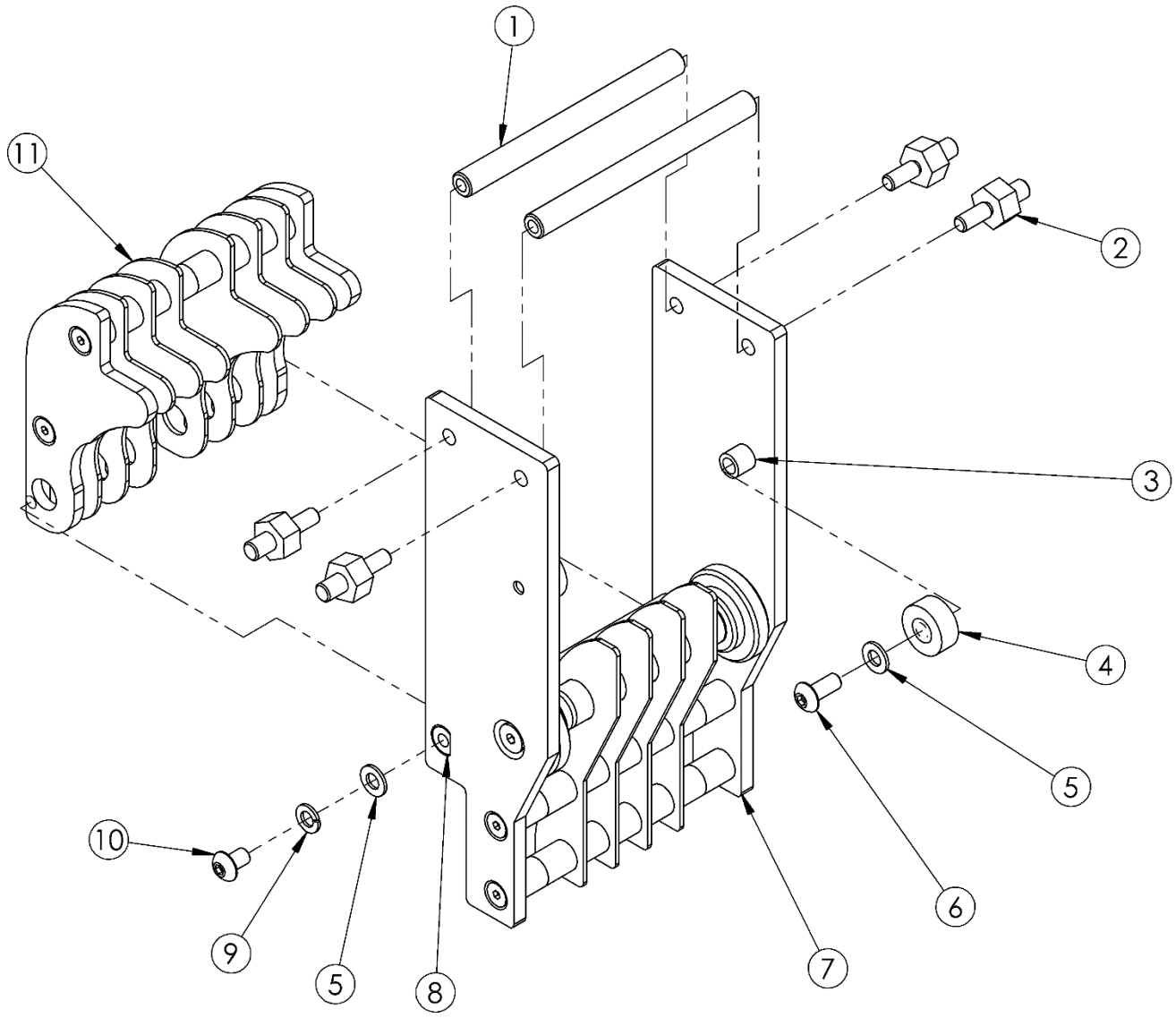
### 9.12.12 WST1042 – Pneumatic Assembly




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 |

### 9.12.13 WST1039 – Tape Shoe Assembly



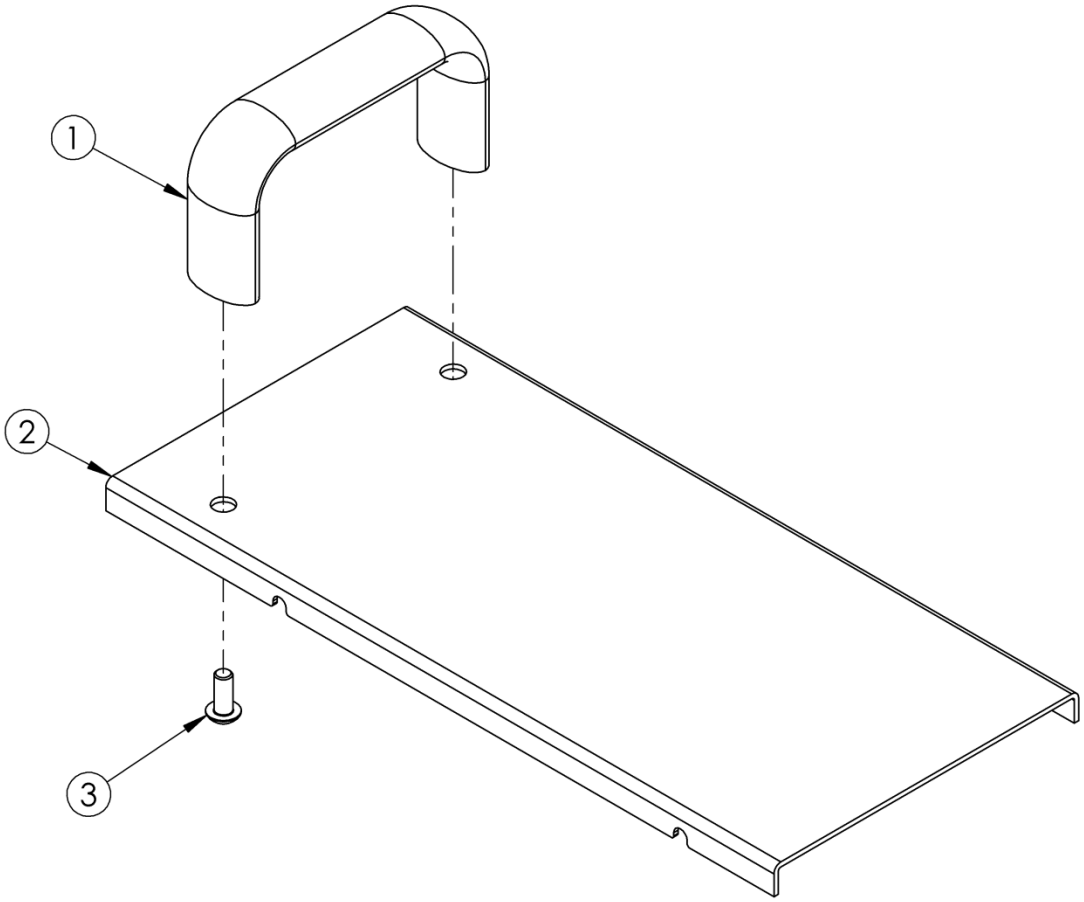

WST1039 - TAPE SHOE ASSEMBLY

| 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 |

**9.12.14 WST1031 – Water Pot Assembly** - Same as for Bottom Tape Head Assembly.

Refer to **9.11.13 WST1031 – Water Pot Assembly**.

### 9.12.15 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 |