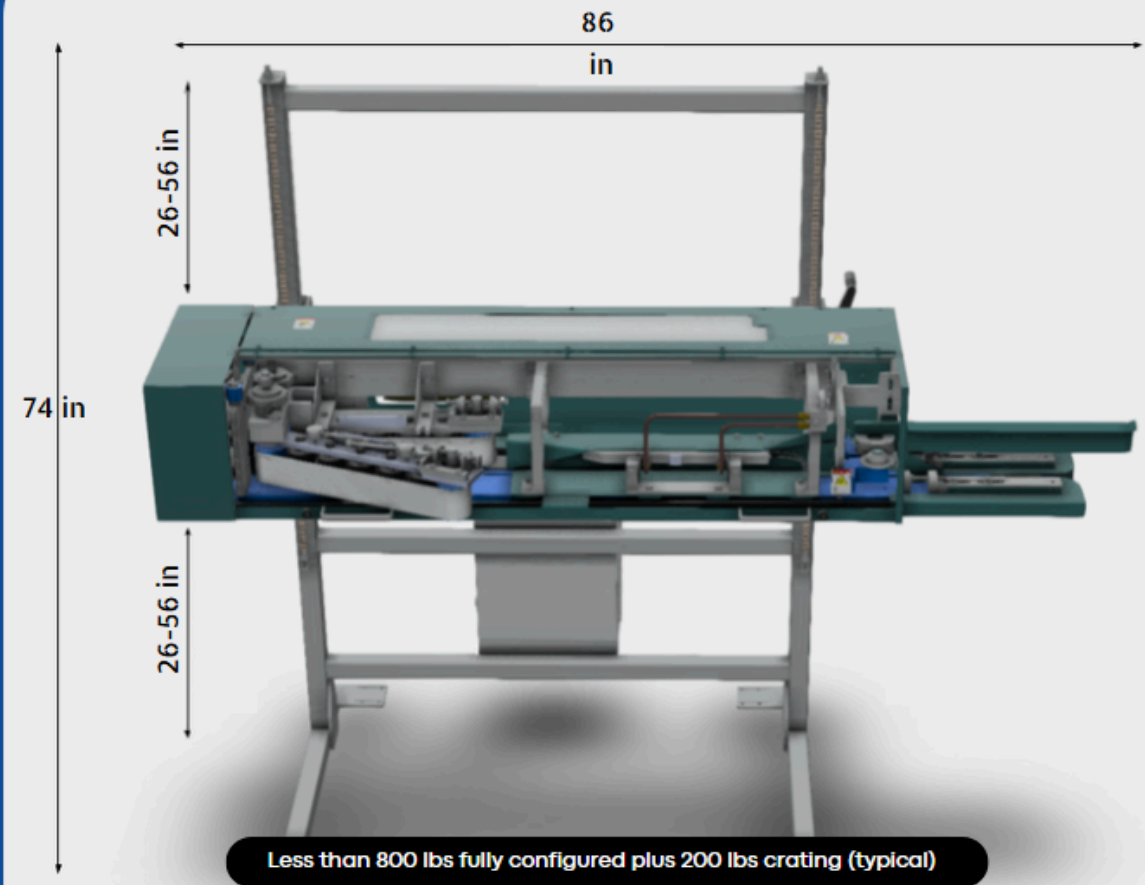
OPERATIONS AND OWNERS MANUAL
EPS500-001.VER1.0 6/2024

Elevation
Packaging & Equipment

PINCH BOTTOM MULTI-WALL PAPER BAG SEALER

EPS 5000



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FOR SPARE PARTS OR TECHNICAL QUESTIONS PLEASE CALL:
402-999-0827

DANGER!

DO NOT ATTEMPT ANY MAINTENANCE OR REPAIRS WHILE MACHINE IS RUNNING OR PLUGGED IN!! THIS COULD CAUSE SERIOUS INJURY OR DAMAGE TO MACHINE!!
ONLY QUALIFIED PERSONNEL SHOULD PERFORM ELECTRICAL REPAIRS

BE CAREFUL OF INTAKE BELT SYSTEM - KEEP FINGERS CLEAR OF CARRIER BELTS AND MOVING PARTS WHILE FEEDING BAGS. DO NOT OPERATE MACHINE WITHOUT GUARDS IN PLACE
WARNING LABELS ARE PROVIDED AND SHOULD BE REPLACED WHEN WORN

BEFORE CONSIDERING A SEALER, EXPLOSIVE ENVIRONMENTS REQUIRE DOCUMENTED ADDITIONAL SAFETY COLLABORATION AND ENGINEERING OUTSIDE OF THE NORMAL SCOPE OF ELEVATION PACKAGING. HEATING BARS CAN REACH 500 DEGREES OR HOTTER. EXTERIOR SURFACES CAN BECOME HOT - TEST SURFACE BEFORE TOUCHING - DO NOT SET ANYTHING ON TOP OF THE SEALER THAT WILL BLOCK AIR MOVEMENT -

ALWAYS KEEP A FIRE EXTINGUISHER NEAR THE SEALER WHILE OPERATING.
AUTOMATED FIRE SUPPRESSION MAY BE REQUIRED IN AREAS WHERE THE MACHINE OPERATES. CHECK YOUR LOCAL CODES

TO PREVENT TIPPING THE UNIT
AVOID ROLLING OVER UNEVEN SURFACES OR SURFACES WITH A GRADE - UNIT SHOULD BE UNPACKED AT IT'S POINT OF USE AND OPERATED ON A FLAT SURFACE - WHEN MOVING USING CASTERS - ENSURE MACHINE IS ADJUSTED TO ITS LOWEST POSITION

!! DANGER - READ BEFORE SERVICING OR OPERATING !! Only personnel trained to identify hazards and proceed safely should attempt to service the equipment. Failure to follow these guidelines could result in personal injury, damage to equipment or DEATH. Servicing, lifting, or troubleshooting this equipment may subject the user to hazards such as but not limited to the following:

- Electrical hazards, shock / arc flash
- Tipping hazards / crushing
- Pinch points / mechanical hazards
- Burns from heat bars
- Sharp edges

Model Number

EPS - 5000 - 1 - 2 - RL

- EPS: Elevation Pinch Sealer
- 5000: Pinch (Air Heat) Sealer
- 1: Single Phase
  3: Three Phase
- 4: 460 Volt
  2: 208 / 230 Volt
- RL: Right to Left (Standard)
  LR: Left to Right

Serial Numbers

01 - 23 - 23E0011 - BPC - TC

- Manufacture Month
- Manufacture Year
- Build Number
- Stainless Options:
  0- No Stainless Options
  S- Stainless Steel Floor Stand
  B- Stainless Steel Heat Bars / Heat Strips
  P- Stainless Steel Bridge Plates
  C- Stainless Steel Castors
- Accessories:
  0- Base Package
  C- Emboss Coder
  W- Caster Wheels

INSTALLING THE MACHINE INTO PRODUCTION

★ *Read the entire manual FULLY and CAREFULLY before setting up equipment*
★ *Know your sealer. Know the materials your sealer is manufactured with. Know your application and any product safety requirements you may have in your shipping and bagging process. Full machine build info can be obtained through Elevation Packaging including alloys, lubricating fluids and coatings.*
★ *Custom specialty finishes, alloys and lubricants can be provided when configured at time of purchase or upgraded through quoting.*
★ *It is the responsibility of the end user to perform a risk assessment for product safety and / or regulatory compliance with USDA, FDA, ROHS, REACH etc and no such component options are provided or sourced unless expressly specified in the sales order PO and production checklist of the machine. Un-certified components should be considered NOT safe for food contact until such time a qualified end user performs the appropriate risk assessment to deem them safe. Materials used in construction need to be evaluated by the end user for the application being used.*
★ *Two visually identical models may be built for completely different applications. When purchasing used equipment, the end user should consider the purchase history of the machine and the environment to which it may have been subjected.*

1. Once the machine arrives, un-skid the machine and check for any damage. If any damage has occurred, contact the freight carrier at once. (SEE UNCRATING INST)
2. Place the machine crate in the operating area and unpack
3. Adjust the height of the machine to the desired level.
4. Remove any protective film from surfaces
5. Install the front handle that was shipped with the unit if it was shipped in the electrical compartment
6. Connect air to the supplied quick disconnect (if applicable)- The unit should be supplied with up to 15 SCFM of clean dry air @ 50PSI
    a. Excess air condensation can cause issues with temperature control and/or damage the product in the bags.
    b. Compressed air quality requirements will depend on the end user and any additional restrictions of the product being packaged in the bags. Consult the process design requirements of your facility.
7. Wire the machine into the correct electrical service and make sure the machine is connected to the building ground.
8. Ensure the transformer (if equipped) is tapped for the supply voltage of the facility.
9. The Front door is heavy. It is recommended a chain or secure strap be fastened to the frame and used to support the handle of the door while setting up or servicing the sealer

Failure to ground the machine will increase the risk of shock.

UNCRATING THE SEALER

- Do not raise or lower the machine until it is in its operating location on a level surface.
- The machine is shipped with a cross bar secured to the feet for lifting the unit with a forklift.
    - If installing casters, place the unit on cribbing blocks, then install casters, then lift the unit with the forklift again to remove the cribbing blocks.
    - Do not remove the all thread and cross bar when installing the casters
        - Ensure the lower nuts below casters have Loctite or a nylon nut for safety.
    - If not installing casters, ensure the warning sticker is kept in place to ensure the center of gravity is kept as close to the ground as possible while moving using a forklift.
- NEVER PLACE THE FORKS UNDER THE DECK PLATES TO LIFT THE MACHINE OR SEVERE DAMAGE WILL OCCUR!!
- NEVER LIFT THE MACHINE WITH THE CHAIN LIFT MORE THAN 1 INCH ABOVE IT'S LOWEST POSITION OR THE MACHINE COULD BECOME TOP HEAVY AND FALL OVER WHEN RELEASED FROM THE FORKLIFT.
- When shipping - casters should be removed and the unit should be supported by the lower steel tubes resting on a skid and secured with at least 4) 5/16 bolts

GENERAL OPERATION

The EPS5000 sealer is an industrial grade multi wall paper bag sealer designed to seal pre-glued shipping bags in manual and automatic production runs. The basic operation of the machine is that bags are fed into the in-feed of the machine and carried through the entire machine via a pair of carrier belts.

The the bag is carried through the machine as follows:

1. The bag is creased via a pair of creaser wheels
2. The bag is folded 90 degrees
3. The bag is carried through the heat section. The bag passes through a hot air stream up to 500 degrees..
4. The bag is folded 90 degrees again for a total of 180 degree fold
5. The bag is carried through a series of rollers (up to 7) joined by a belt to press the glue into the bag

IMPORTANT*
Freeboard is the amount of distance between the horizontal plane of the carrier belt to the top of the bag.

The entire freeboard needs to be flattened by either a machine or an operator when the bag enters the machine or a bag jam may occur inside the sealer.

The infeed guards have a taller infeed opening than our typical infeed guards which helps operators determine if the bag is flat enough to enter the machine.
If a bag drags on the infeed guards, it is more likely to jam in the machine.

COMPONENT OVERVIEW

ELECTRICAL CONTROLS

Have any personnel who may be operating the machine learn the electrical controls.

10 turn potentiometer - precisely controls the carrier belt speed to a fixed setpoint. The operator must adjust to match the conveyor speed.

Power and direction switches - starts the entire sealer
Turn direction switch to the right for forward -
Turn direction switch to the left and hold the push button for reverse
The reverse is provided to clear jams in the creaser assy.

Heat control switch - enables or disables the heat

Tempco TEC-220 - Temp Controller
To change the setpoint, press the ↻ button to view, then the up and down arrows to change. Press both up and down arrows at the same time to return to the actual temperature screen.
Refer to the appropriate Tempco manual for troubleshooting.

Delta DTB - Temp Controller or Secondary Temp Control

Temp controller - To change the setpoint, press up or down arrows then SET to retain the new setpoint.

The alarm setpoint should be set below the ignition point of the material being sealed. If the alarm is adjusted from this setting; fire, equipment damage, or malfunction could occur.

Secondary Temp controller - Some units are equipped with a secondary temperature controller which should be left set below the ignition point of the material being sealed. If the controller is adjusted from these settings; fire, equipment damage or malfunction could occur.

Heat malfunction Light and Reset button
- Manual reset required

If the alarm light is lit - press the button for manual reset- a cause of the alarm should be determined prior to returning the unit to service. See Tempco and / or Delta Manuals

If, pressing the alarm reset does not reset the alarm, an alarm is still present in the temperature controller that caused the alarm.

Emergency Stop Switch
Located on the side of the electrical box - This switch will shut down all operations except the incoming air pressure -
*** NOTE - The quick release chuck should not be replaced with permanent piping for safety reasons.

INVERTEK VFD

Press the Octagon to scroll through

- Frequency
- Motor Speed
- AMPS
- FPM (c)
- Output Power

* NOTE - The drive will display any faults that occur Refer to the appropriate Invertek manual for troubleshooting

FPM (Feet per Minute) Display

- Models may vary based on availability
- See meter operators manual for troubleshooting
- Calibration voltages and speeds are in the production checklist that was shipped with the unit

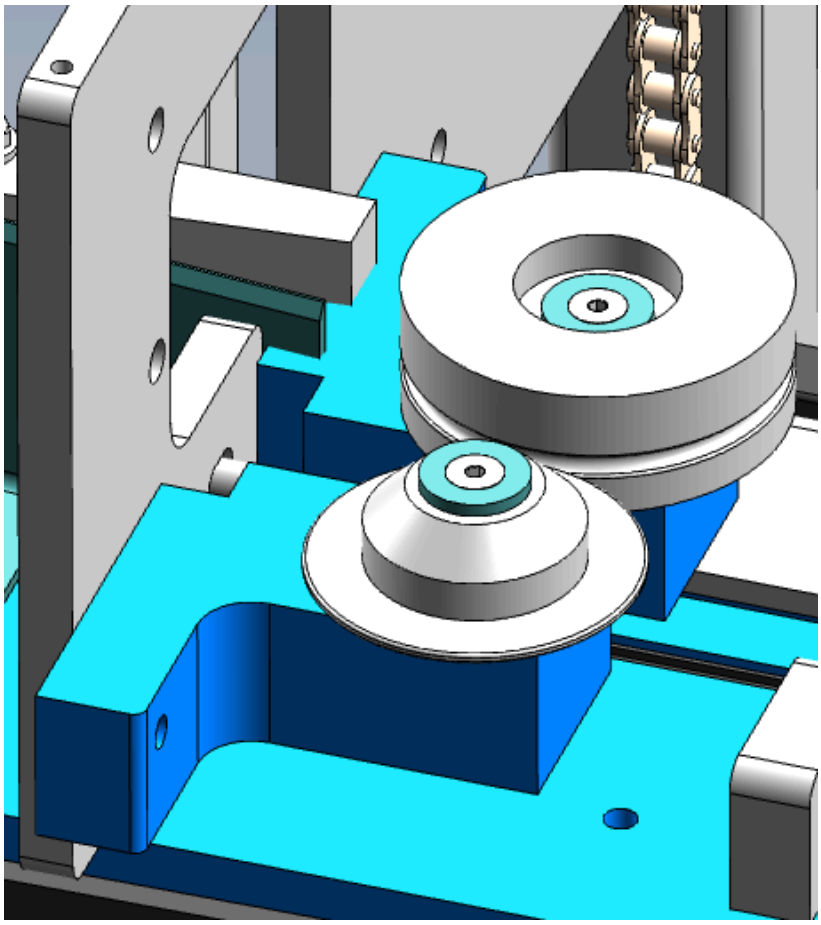
Optional Pressure control - (Recommended for all paper applications and quoted with every EPS5000 - (can be deducted if not desired) The switch makes at a minimum of 10PSI and is designed to trip only on a removal of air. For operating below 10 PSI you must adjust the pressure above 10 then reduce down to the operating pressure you desire.

The control will shut off the heat while still ejecting the bag from the machine.

An optional buzzer is available to alert the operator of a trip.

CREASER ASSEMBLY

The bag passes through a set of rollers that will put a crease in the bag just enough to ensure a precise fold at the top of the bag. Adjusting the wheels to an excess crease can shear through sections of the paper bag and more frequently, will cause paper jams. Adjustment should be set for the bags in use and tested based on fold performance. The rear wheel can be configured with a matched speed brushless DC motor for increased crease depth. Driven creaser wheels can provide the greatest fold consistency and minimum jam potential. A driven creaser and low profile, custom infeed guides may be preferable for fully automated lines.



Creaser assembly (style A shown)

The creaser is in a fixed height in line with the folder. Changing the infeed height will increase the fold over but will also increase the risk of the bag dragging on the discharge side of the heat bar when it folds its second time. This will deposit glue and require cleanup. This should be checked at the beginning and end of each shift.

HEATING SYSTEM

HEATING SYSTEM SAFETY

** DANGER**

! HEAT MANIFOLDS WILL BECOME VERY HOT !

! DO NOT TOUCH !

! SERIOUS BURNS COULD OCCUR !

!! PINCH SEALERS ARE INTENDED FOR PAPER BAGS WHICH ARE FLAMMABLE AT LOW IGNITION POINTS !!.

!! SETTING THE SEALER NEAR THE IGNITION POINT OF THE BAG COULD START A FIRE !!

!! KNOW THE IGNITION POINT OF THE MATERIAL YOU ARE SEALING !!

!! NEVER OPERATE THE MACHINE WITHOUT A FIRE EXTINGUISHER NEARBY !!

!! AUTOMATED FIRE SUPPRESSION MAY BE REQUIRED IN AREAS WHERE THIS MACHINE OPERATES!!

WHEN RUNNING PAPER BAGS, A TEST IN A CONTROLLED ENVIRONMENT SHOULD BE PERFORMED TO SIMULATE A JAM IN THE FOLDER BAR USING A BAG (PREFERABLY BOTH CONTAMINATED WITH PRODUCT AND WITHOUT PRODUCT CONTAMINATION)

THE TEST SHOULD BE PERFORMED AT THE HOTTEST PART OF THE BAR AS VERIFIED WITH A CONTACT THERMOMETER. CLEAN THE HEAT BAR ONCE TESTING IS COMPLETE

THE OPERATOR MUST UNDERSTAND ANY FIRE RISK OF THE PRODUCT BEING RUN. A FIRE EXTINGUISHER SHOULD BE PRESENT WHEN PERFORMING THE TEST

THE JAM SHOULD BE TESTED FOR ENOUGH TIME FOR OPERATOR INTERVENTION AND MACHINE CLEARING. A 10 MINUTE TEST IS RECOMMENDED

IN THE EVENT OF A BAG JAM, THE EMERGENCY STOP BUTTON SHOULD BE PRESSED AND THE BAG JAM CLEARED IMMEDIATELY.

THE SECONDARY TEMPERATURE CONTROLLER MOUNTED ON THE REAR ELECTRICAL BOX SHOULD BE SET LOWER THAN THE TEMPERATURE AT WHICH THE JAM TEST (see heating system) WAS PERFORMED. ONCE THIS TEMPERATURE IS SET, THE "KEYPAD LOCK" FEATURE SHOULD BE ACTIVATED TO PREVENT INADVERTENT CHANGES.

(see temp controller manual for how to lock display)

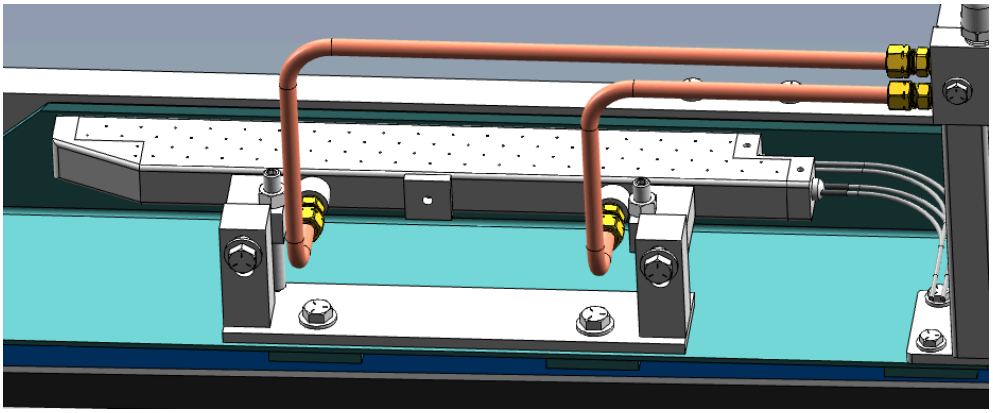
LIMIT SETTINGS TOO CLOSE TO THE OPERATING POINT WILL RESULT IN MORE FREQUENT TRIPS

SETTINGS TOO CLOSE TO THE IGNITION POINT OF THE BAG WILL RESULT IN GREATER RISK OF FIRE

AUTOMATED PINCH BAG SYSTEMS SHOULD AT MINIMAL HAVE AN EXTERNAL PHOTO EYE AND PLC PROGRAM TO ENSURE EACH BAG HAS CLEARED THE MACHINE AFTER IT ENTERS - CONTACT ELEVATION IF A QUOTE IS DESIRED

EPS5000 SEALERS SHOULD NOT BE INSTALLED IN FULLY AUTOMATED LINES WITHOUT ALSO EVALUATING AUTOMATED FIRE DETECTION, MITIGATION AND PREVENTION AND DEEMED SAFE BY A QUALIFIED PRODUCTION ENGINEER FAMILIAR WITH THE FACILITY'S PROCESS SAFETY REQUIREMENTS

HEAT BARS



Heat Bar Air Requirements

The heat bar uses 10-20 PSI of heated air, up to 500 degrees Fahrenheit to melt the glue of the bag enough that it can be absorbed into the paper. Spacing between the bag and the heat bar is set at the factory, no adjustments should be needed

The sealer consumes around 14 SCFM of air at 10 PSI
The sealer consumes around 18.5 SCFM of air at 20 PSI

SCFM numbers are for compressor installation estimates only. Testing should be performed for each bag run based on field performance of the sealer at a given manifold pressure. The SCFM should not change at a given manifold pressure unless the hole sizes of the manifold are clogged or accidentally enlarged from cleaning.

The machine should be supplied with clean dry air. A moisture collector is supplied with the unit from the factory and should be periodically checked and emptied. Excess moisture can cause issues with temperature control and / or damage the paper bags as well as the product in the bags.

An air dryer should be provided for the sealer for optimum performance.

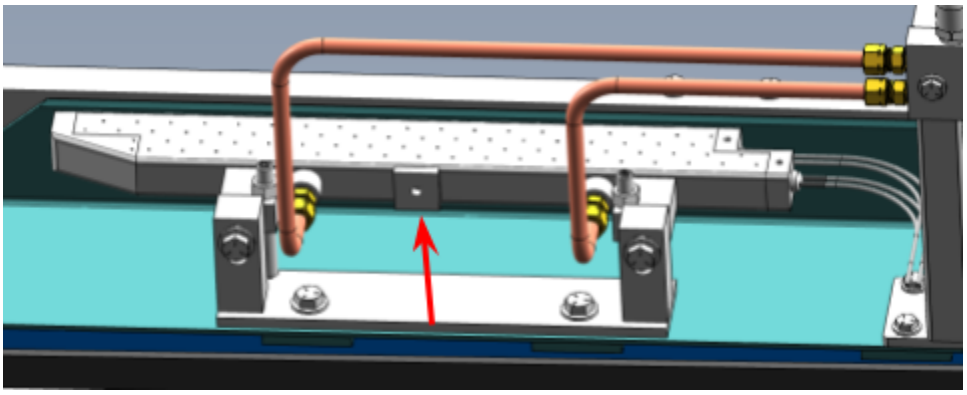
Compressed air quality requirements will depend on the end user and any additional restrictions of the product being packaged in the bags.

Elevation is not responsible for compressed air quality or any other contamination issues associated with the sealer, but can provide recommendations for clean compressed air vendors where needed. As a condition of sale, the end user must conduct a risk assessment of the equipment configuration against the product being bagged.

Setting the Air

Always start with a pressure setpoint of 9
psi and only increase air pressure if necessary

- It reduces energy consumption
- It extends heat element life
- It provides fewer hot spots on the heat bar
- Lower pressures can cause nuisance pressure safety trips



Temperature Control

The heat bar has 2 thermocouple locations

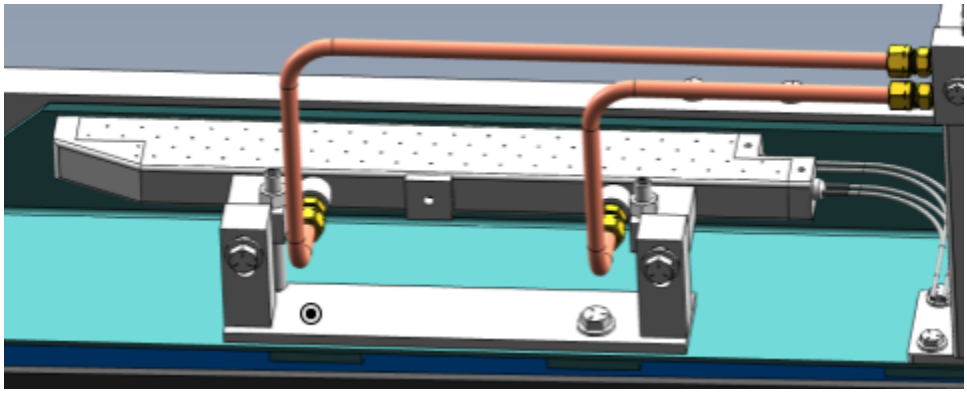
- Front thermocouple location (shown)
- Bottom Rear thermocouple location. (Underneath the rear heat element)

It is imperative that the thermocouples are not interchanged as they provide different functions and the temperature between the two will vary.

- Front thermocouple
    - This temperature is the closest to the surface temperature of the heat bar
    - Air and surface temps are usually within +30/-80 degrees F of this thermocouple. This is tested at the factory only if the parameters of a specific bag and if bag samples are provided. If the air pressure is changed in the field, the surface temperature should be checked using a reliable contact probe. Before running production on a new product or bag, or if the manifold is serviced or cleaned, run a new jam test at the hottest portion of the heat bar as verified with a surface contact thermometer.

    - This temperature is monitored on the temperature controller mounted on the rear electrical box.
    - This thermocouple controls a manual reset temperature set point that should be set lower than an actual bag jam test.

- Bottom Rear Thermocouple
    - This thermocouple provides direct control for the temperature setpoint
    - It measures the pre-heated air temperature after passing the first heat element, plus the radiant heat of the second heat element.
    - Due to its close proximity to the second element, the temperature is significantly hotter than the exiting air and the surface temperature of the heat bar.



Cleaning, temperature checks and inspections

Some units are equipped with a slide out heat bar assembly and will have stainless braided PTFE flexible hoses. In this case, the left bolt will be a socket head cap screw guide bolt only. This does not need to be tightened. The right bolt should be loosened to pull the heat bar out for cleaning, inspection and maintenance.

At the BEGINNING AND END of every shift, the heat bar should be checked for signs of glue deposits. Ensure the bag inlet feed orientation is not producing an excess fold. The bag top should run just inside the edge of the folder bar. If not, the infeed guide should be lowered. Check the heat bar height at the left edge and lower the heat bar if necessary (AND only as much as necessary) so that contact is not made during the fold.

CARRIER BELTS

1. Two continuous 7/8” wide carrier belts are used to carry the bag through the entire machine.
2. Tension is set at the factory and should require no adjustment at start up. Periodic tightening may be necessary.
3. Belt tension adjustment or belt replacement
    - Disconnect power to the machine. Unplug or Lock out equipment.
    - Remove the in-feed guards.
    - Increase / decrease belt tension using the adjustment screws (**see Figure 1**)

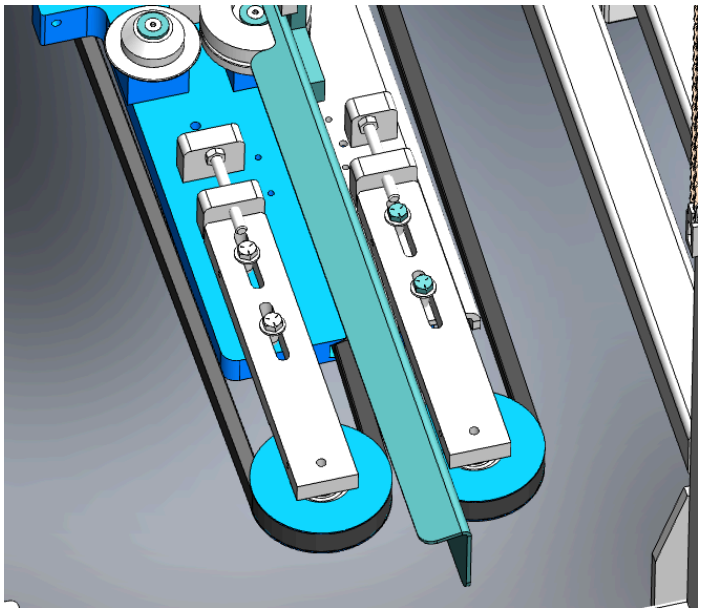


Figure 1

DRIVE SYSTEM

Motors may vary per machine - refer to the operations manual of the model that is installed on your equipment.

All motors selected are permanently lubricated maintenance free motors - Harsh environments may require additional considerations.

The drive belt is tightened by the following **(SEE FIGURE 2 HIGHLIGHTED IN GREEN)**

- adjusting the tensioning pulley between the gearbox and the main gears
- adjusting the tensioning pulley between the main gears and the compression gears

The gearbox is not user serviceable through Elevation Packaging. If repairs are needed, a new gearbox is available through Elevation.

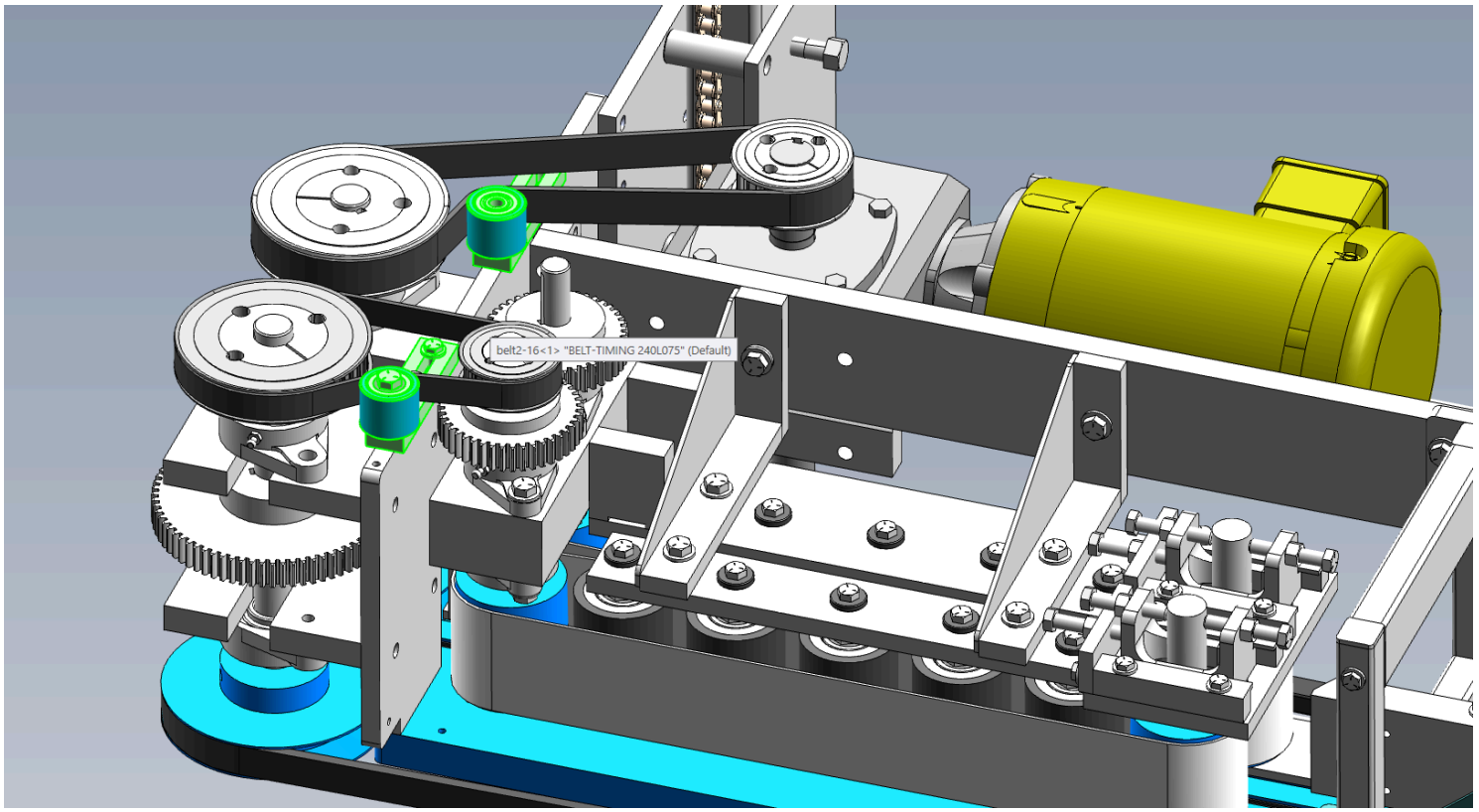
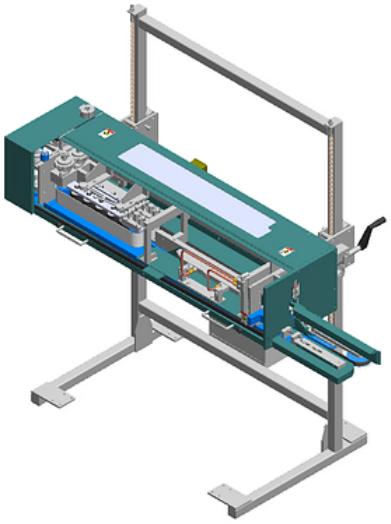
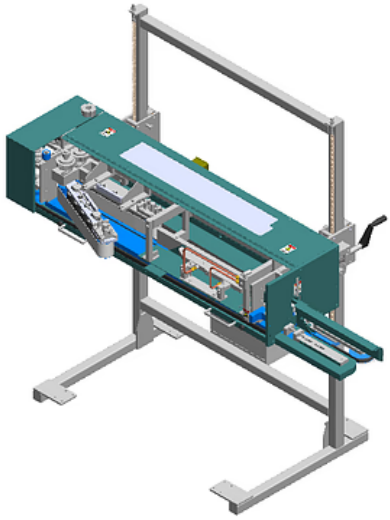


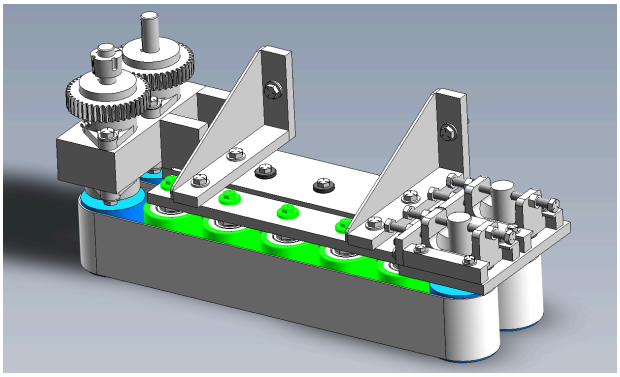
FIGURE 2
Tension Pulleys highlighted in green

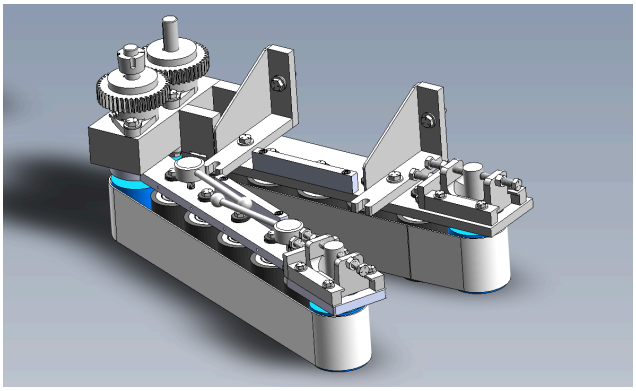
COMPRESSION ASSEMBLY

The compression wheels ensure the melted glue adheres to the layers of the paper bag. The compression assembly can be swung out for light cleaning and also can be easily removed as an assembly for thorough cleaning.







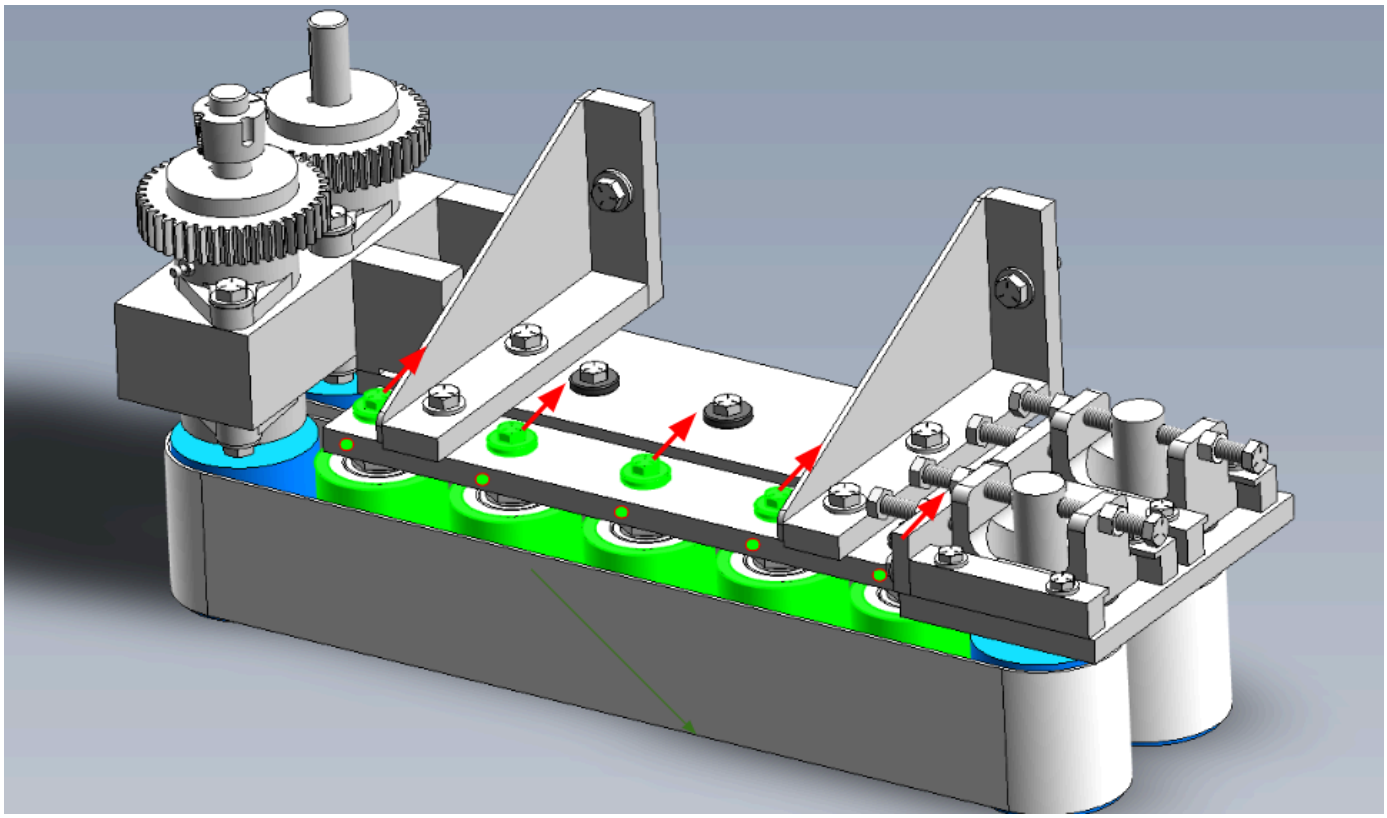


COMPRESSION ASSEMBLY(CONT)

COMPRESSION GAP ADJUSTMENT

The gap of the pinch assembly should be set smaller than the total gap of the bag material. The silicone coating applied to the rollers has some give. The bag will displace the roller material as it passes through. (SEE FIGURE 3 IN GREEN)

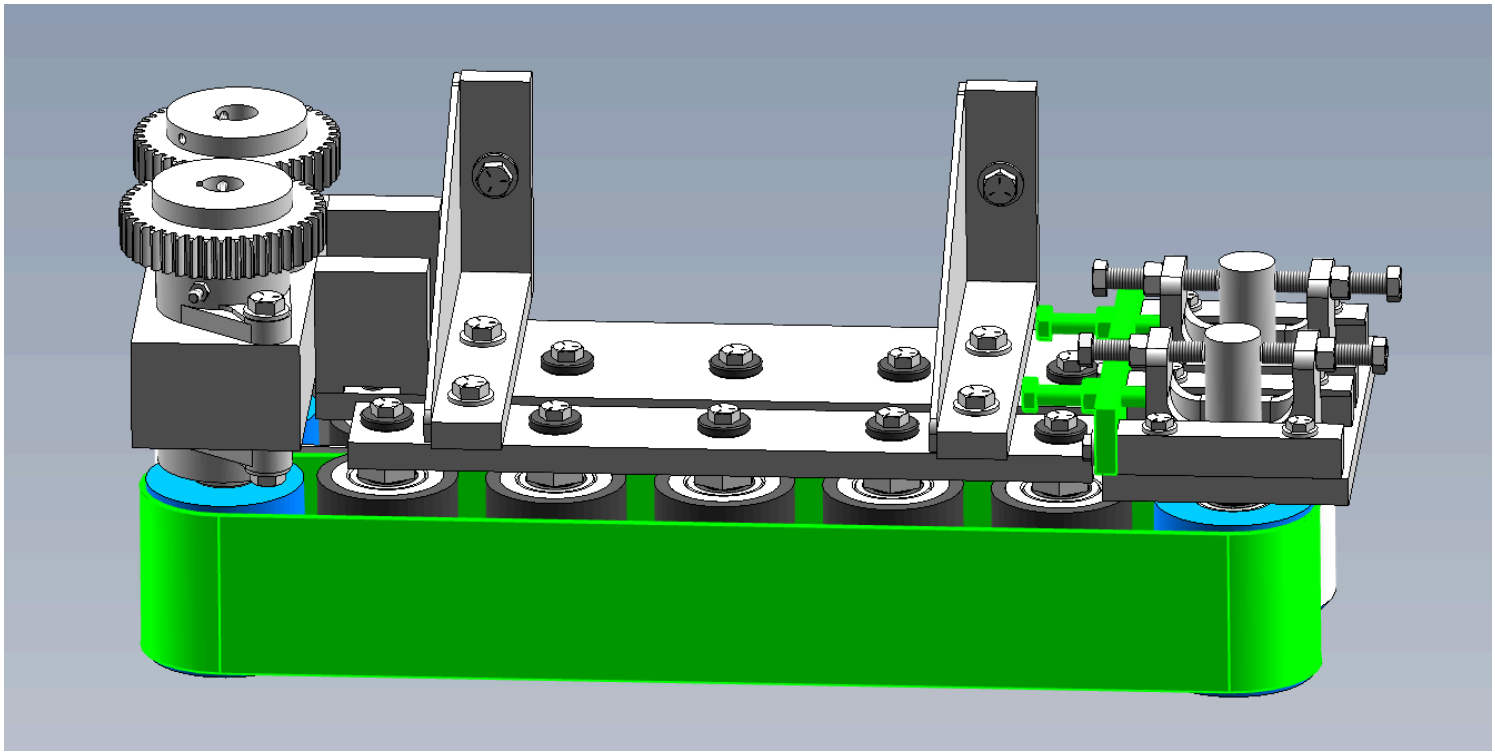
Generally, adjusting each slotted roller to the point that the rollers begin to spin intermittently will produce enough compression to press the glue into the paper. Start with this amount, loosen or tighten as necessary. Tighter rollers will produce the best glue penetration while also providing the shortest lifespan of wear components.



(FIGURE 3) Compression adjustment

COMPRESSION BELT TENSIONING

The compression belt is tightened using jackscrews and locked in place with the nut against the bar stop. (see figure 4 below in green)

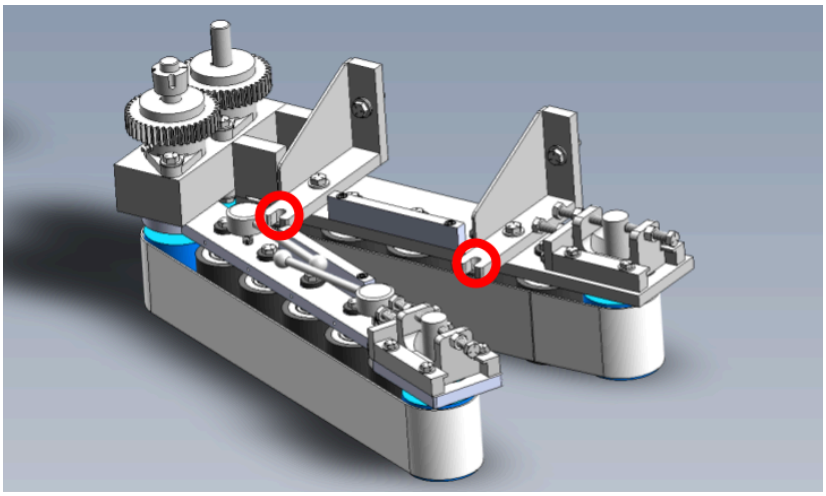


(FIGURE 4) Compression Roller Belt Tension

COMPRESSION ASSEMBLY SWING OUT AND REMOVAL

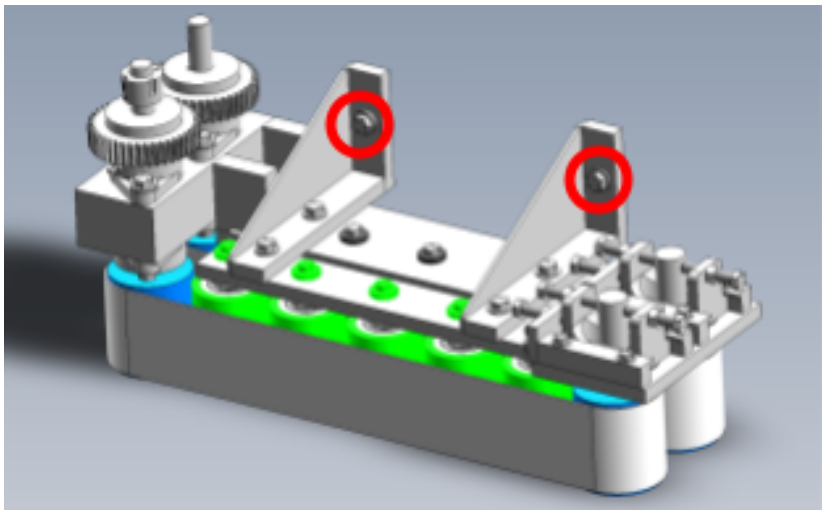
In order to swing out the compression rollers - remove the two bolts circled in red in **Figure 5**

COMPRESSION ASSEMBLY(CONT)



(FIGURE 5) Compression Swing out Fasteners

In order to remove the compression roller assembly for maintenance - remove the belt and then remove the two bolts circled in red in **Figure 6**

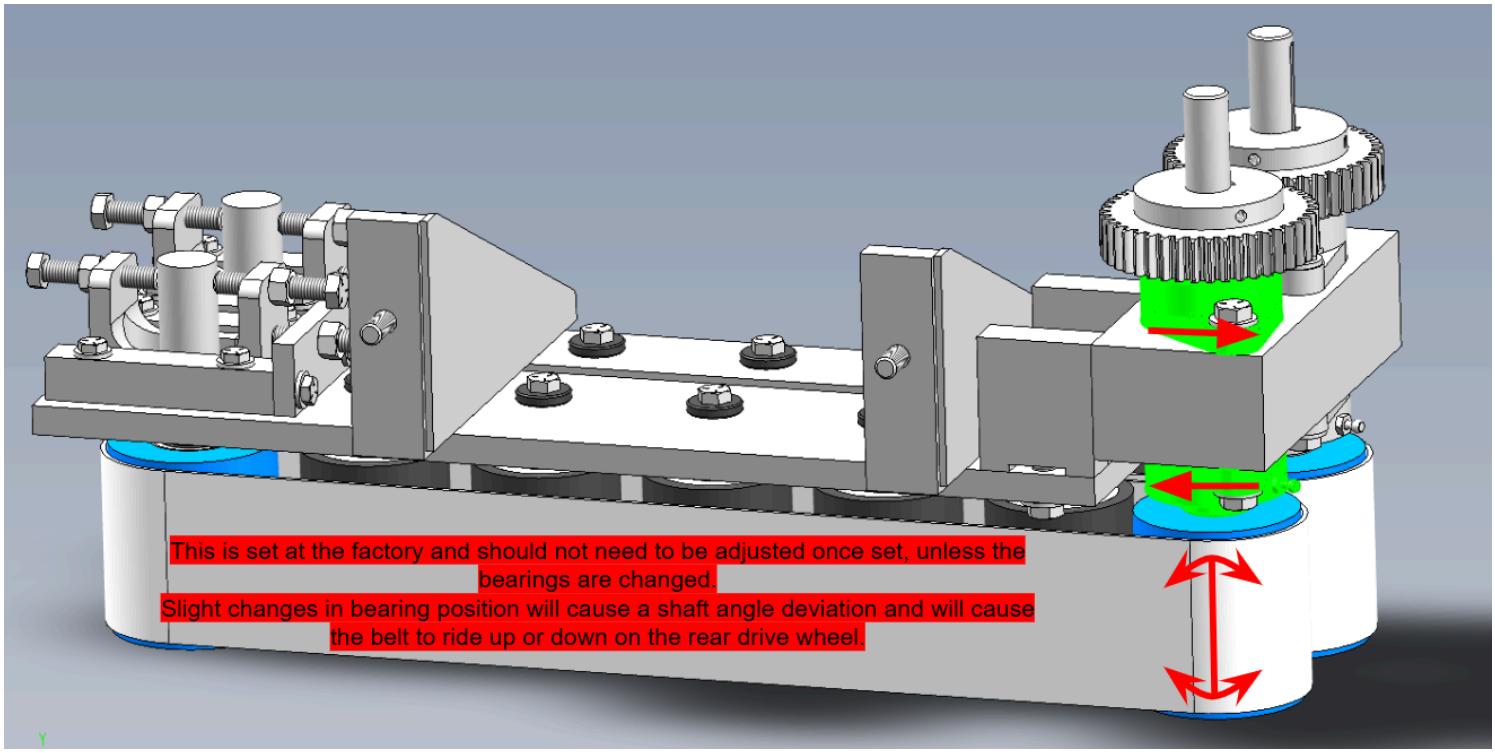


(FIGURE 6) Compression Assembly Removal Fasteners

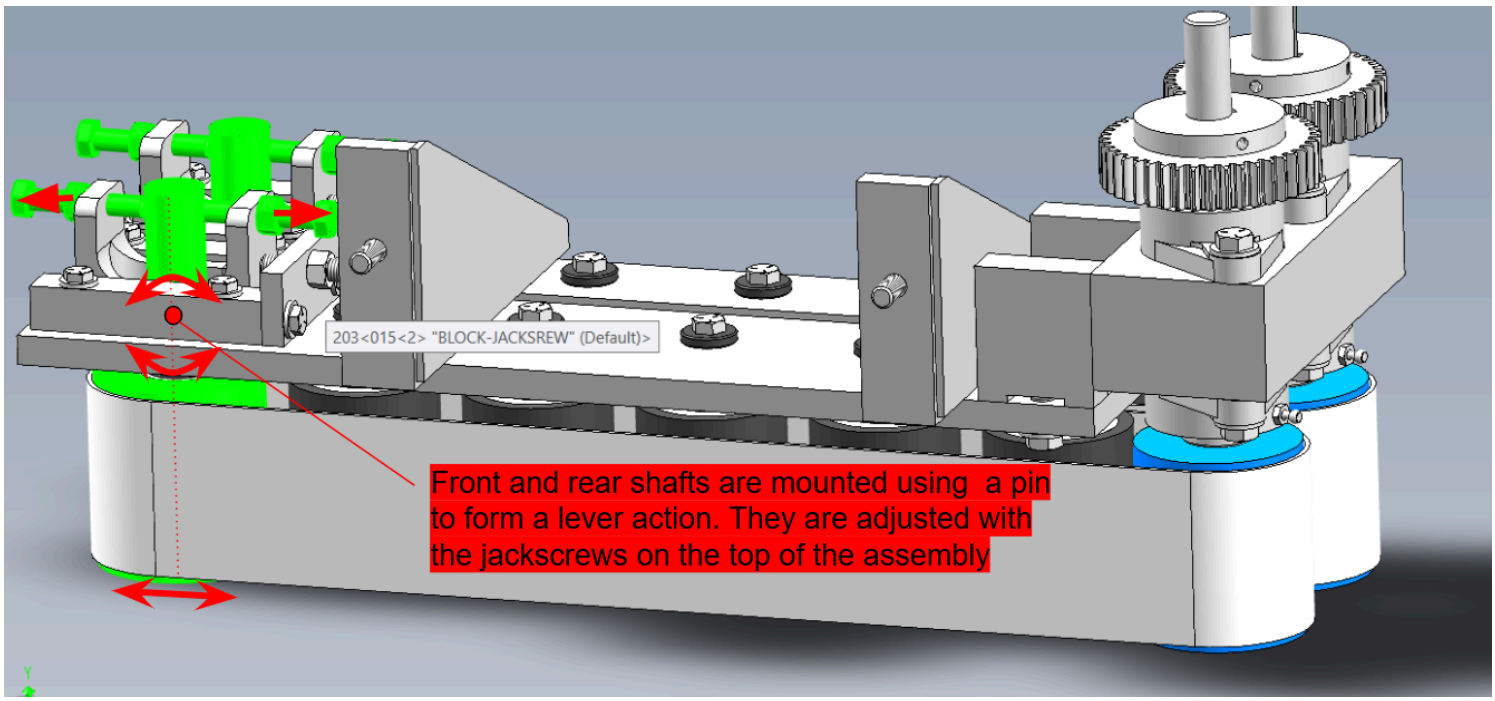
COMPRESSION ASSEMBLY(CONT)

BELT HEIGHT ADJUSTMENT

Belt ride is critical to the seal of the bag. See the Figures 7,8 and 9 to adjust the height of the belt ride.

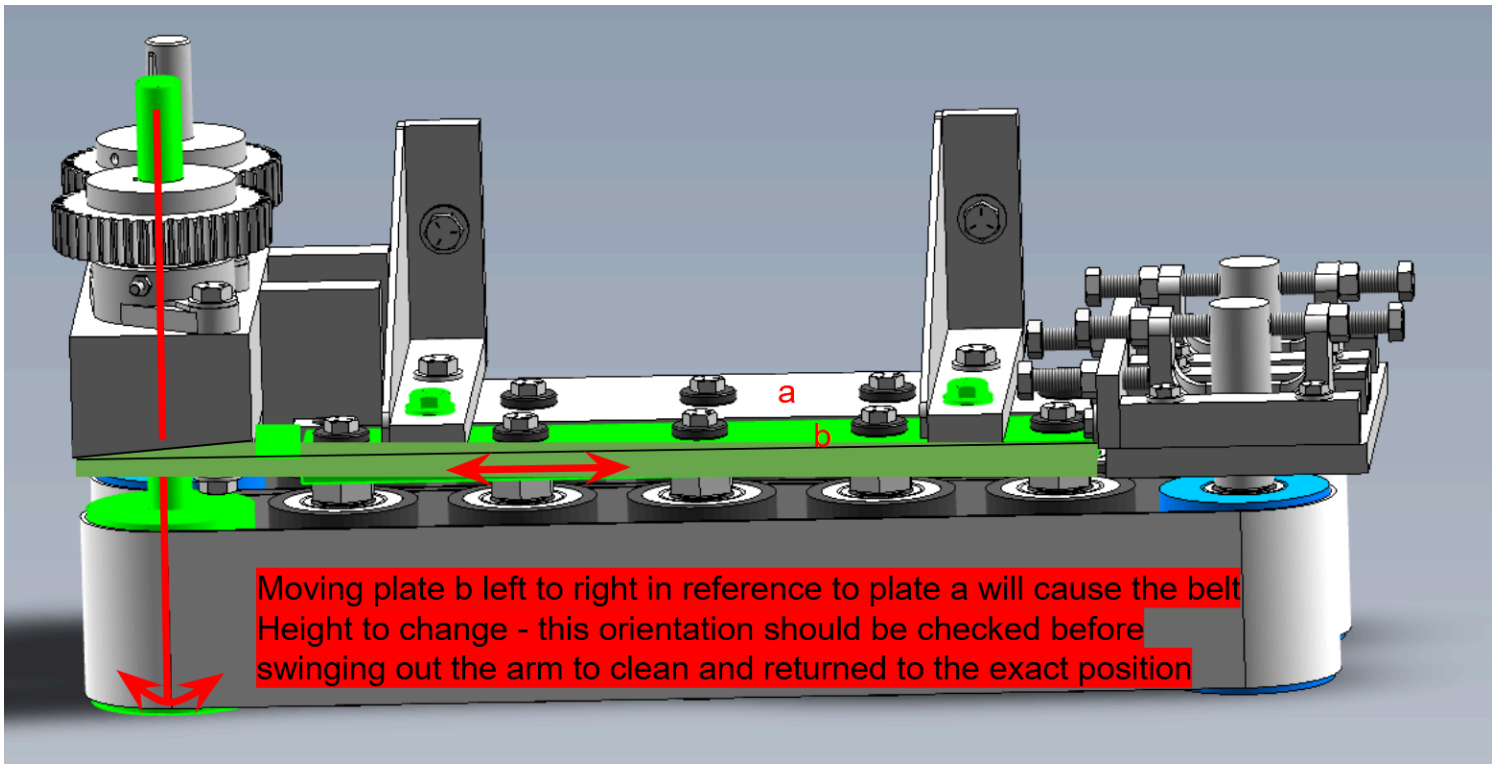


(FIGURE 7) Rear Belt Height at Drive Pulley



(FIGURE 8) Belt Height at idler wheel side

COMPRESSION ASSEMBLY(CONT)



(FIGURE 9) Front Belt Height at Drive Pulley

The pillow block bearings are self aligning which allows plate b to move left to right within the limits of the clearance holes for the bolts highlighted in green.

MAINTENANCE

Motor

All motors selected are maintenance free motors unless specified by the customer.

Bearings

The only greasable bearings in the unit are in the bearings in the compression assembly and the drive gear bearings. Some customers plug the grease zerks and run to failure on this rpm of bearing. Bearings should be greased by runtime evaluation based on each bearing. Bearing manufacturers publish recommended grease intervals for each bearing size based on duty cycle and RPM.

Gears

Gears are coated with a light grease at the factory. They should be inspected and re-coated as necessary. Dirt and debris should be removed from gears.

Compression Assembly

The compression assembly should be inspected at the beginning and end of every shift for signs of glue deposits and debris. Clean as necessary.

Heat Bar

The heat bar should be inspected at the beginning and end of every shift for signs of glue deposits and debris. Clean as necessary. Air holes should be checked for free air passage. Do not alter the heat bar hole sizes. Extreme caution should be used if cleaning with a precision drill bit - It is recommended that an undersized drill bit be used to clean or a torch tip cleaner or broach. Avoid excessive bag fold lengths that deposit glue on the heat bar. If the holes are enlarged in spots, hot spots may occur and a new heat bar is recommended. If the heat bar air openings are cleaned, a service temperature test should be conducted to compare the heat bar surface temperature to the displays on the primary and secondary controllers. The production checklist (shipped with the unit) contains the expected values.

Moisture Collector

If the incoming air is properly set up, the moisture collector should not require emptying. Inspect periodically throughout each shift to ensure the drying system is operating properly.

General Cleaning

The entire machine should be inspected and wiped down at the end of each shift. Buildup of debris or blockage of air openings can cause operational issues and also increase the risk of fire.

Guarding

There is extremely low clearance between the pulley system and the guards to facilitate a minimal amount of freeboard in the machine. The guard gap to the pulleys should be checked if the machine is moved frequently from line to line or if it is crated and shipped.

Air Pressure Switch

Periodically verify that the air pressure switch opens at 2psi and removes power from the rear secondary controller. The pressure switch should make in the vicinity of 10PSI - for operating parameters between 5-10 PSI, you will need to turn past 10 PSI to engage the switch and then turn back down to the desired operating set point.

Corrosion Checks

All lift components should be inspected regularly to ensure that product changes or environmental contaminants are not producing rust that would weaken the lift components and create a safety issue.

Belts

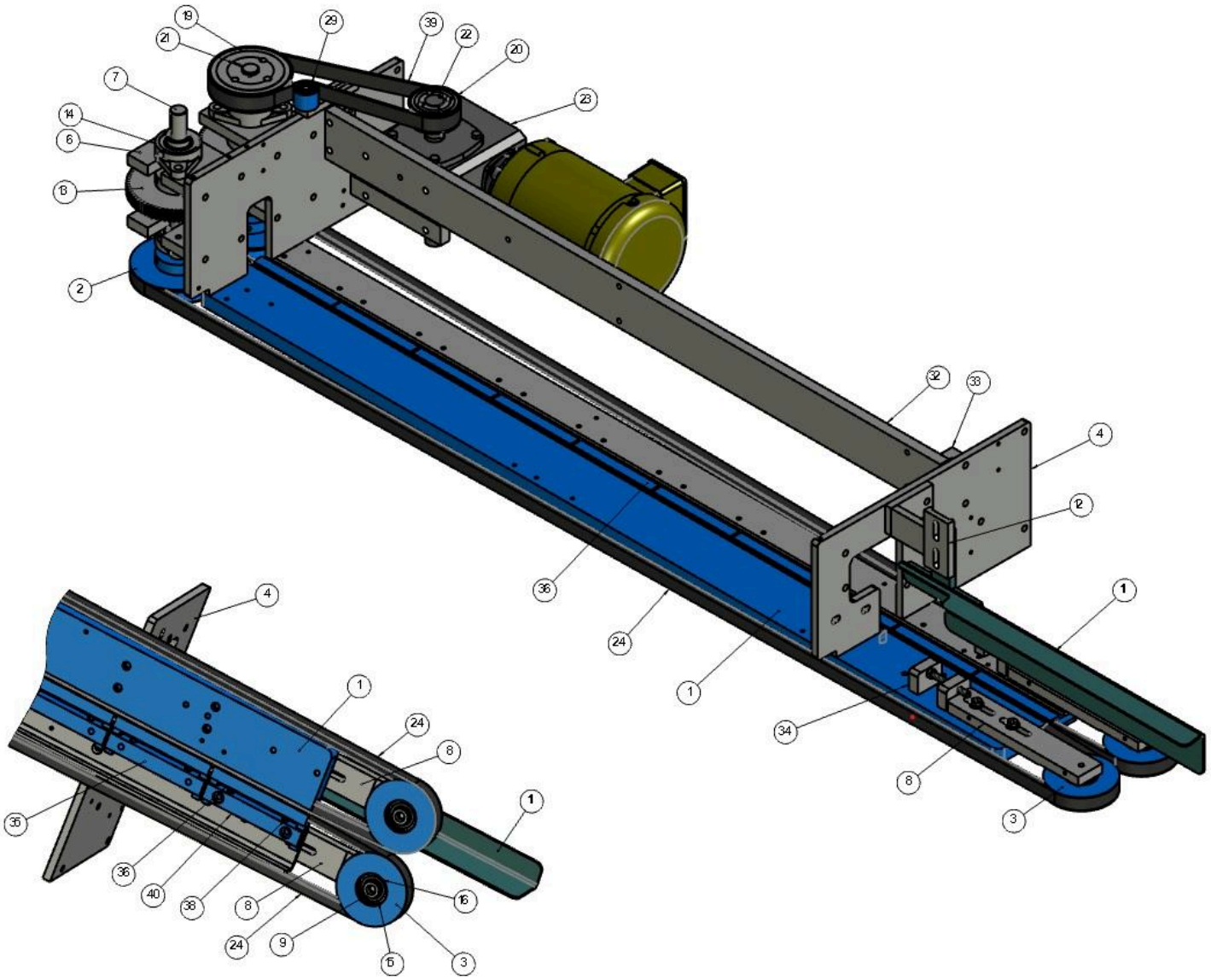
Drive and carrier belts should be checked for signs of wear and replaced when worn.

ASSEMBLY DRAWINGS

Please provide a serial number with all parts requests

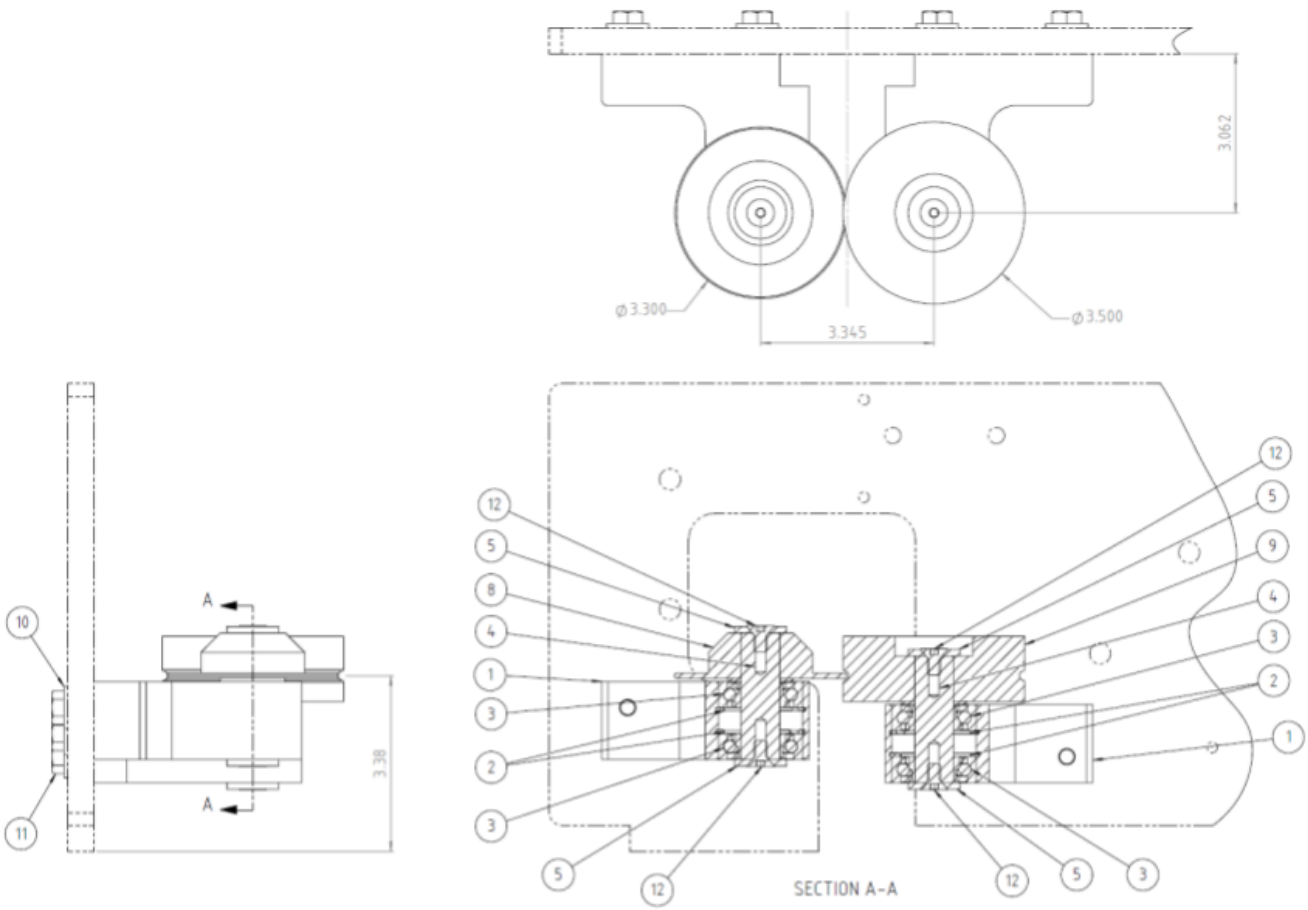
- 200-100 FRAME
- 201-100 CREASER
- 202-100 FOLDER ASSEMBLY
- 203-000 COMPRESSION ASSEMBLY
- 204-000 - FLOORSTAND ASSEMBLY
- 205-000 - GUARDS - STYLE A

200-100 - FRAME



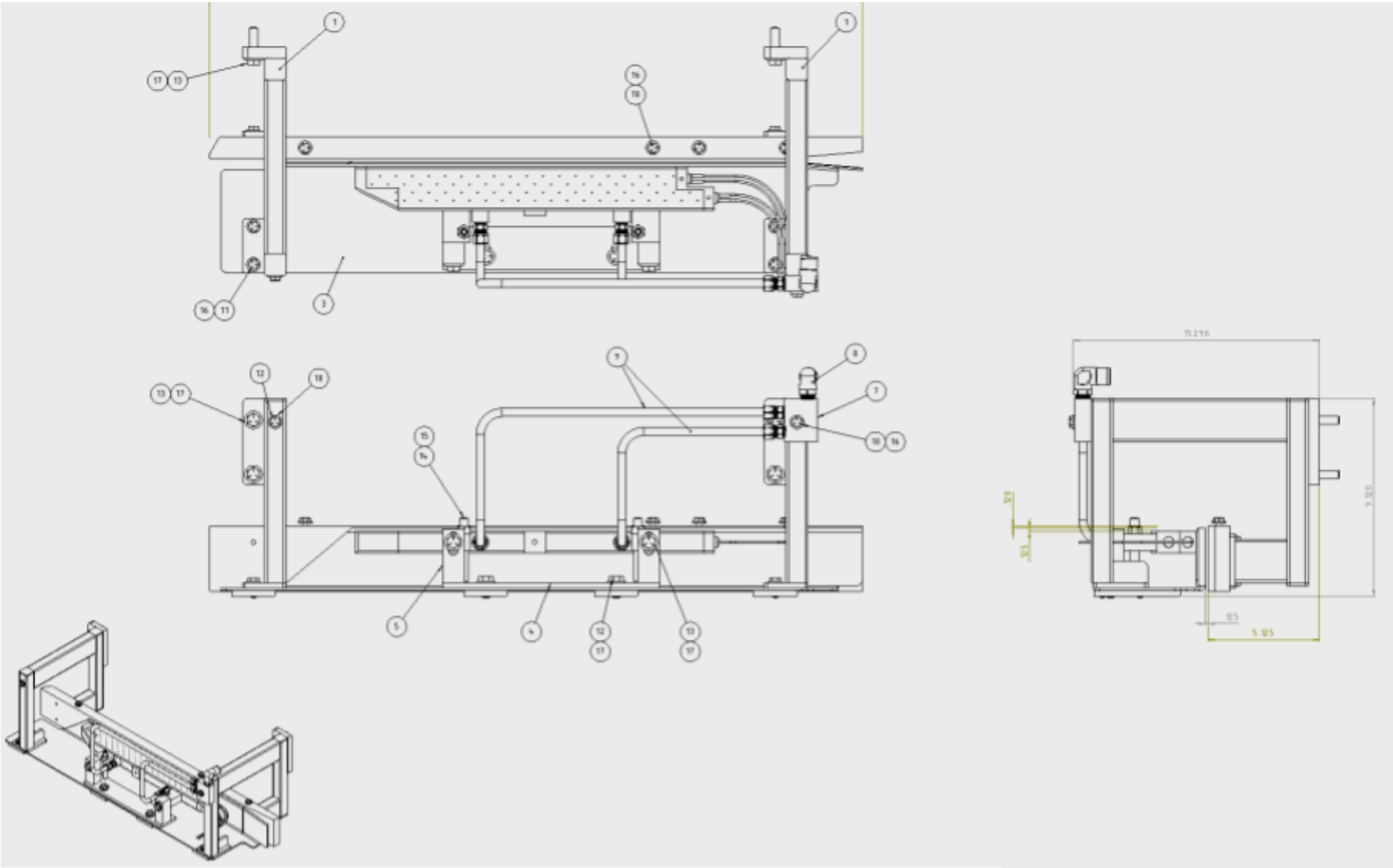
200-100 FRAME ITEMS			
Item	Part Number	Description	Qty.
1	200-105	PLATE-FRAME FRONT	1
2	200-003	PULLEY-DRIVE	2
3	200-002	PULLEY-INFEED	2
4	200-104	BRIDGE-INFEED	1
5	200-103	BRIDGE-DISCHARGE	1
6	200-008	BEARING MOUNT	4
7	200-009	DRIVE SHAFT	2
8	200-106	WELDMENT-BELT TAKE UP	2
9	200-011	SHAFT-INFEED	2
10	200-012	SPACER-PULLEY	2
11	200-110	WELDMENT-DECKPLATE-REAR	1
12	200-108	WELDMENT-INFEED GUIDE	1
13	200-109	WELDMENT-GUIDE MOUNT	1
14	200-016	SPUR GEAR	2
15	900-192	BRG-2 BOLT FLANGE 1.00	4
16	900-029	BRG-BALL .87 x 2.00 x .56	2
17	900-159	RETAINING RING-INT Ø2.00	4
18	900-156	RING-RETAINING-INT Ø1.125	2
19	900-025	BRG-BALL .38 x 1.12 x .38	2
20	900-204	PULLEY-TIMING TL30H100	1
21	900-201	PULLEY-TIMING TL18H100	1
22	900-202	BUSHING-MATCHED WITH PULLEY 1.00	1
23	900-042	BUSHING-MATCHED WITH PULLEY 1.125	1
24	900-153	GEAR REDUCER F724	1
25	900-151	BELT-V	2
26	900-062	WASHER-FLAT SAE 3/8	4
30	203-019	IDLER-BELT	1
31	203-020	IDLER BRACKET REAR	1
31	203-020B	IDLER BRACKET FRONT	1
32	203-021	SPACER-IDLER	1
33	200-101	WELDMENT-CROSSBAR	1
34	200-102	BLOCK-CROSSBAR MOUNTING	2
35	200-107	BLOCK-IDLER ADJUST	1
36	217-004	HOLDER-PRESSURE BAR	10
37	217-005	PRESSURE BAR	10
39	360H100	BELT-TIMING 3606H100	1

201-100 - CREASER ASSEMBLY (STYLE A)



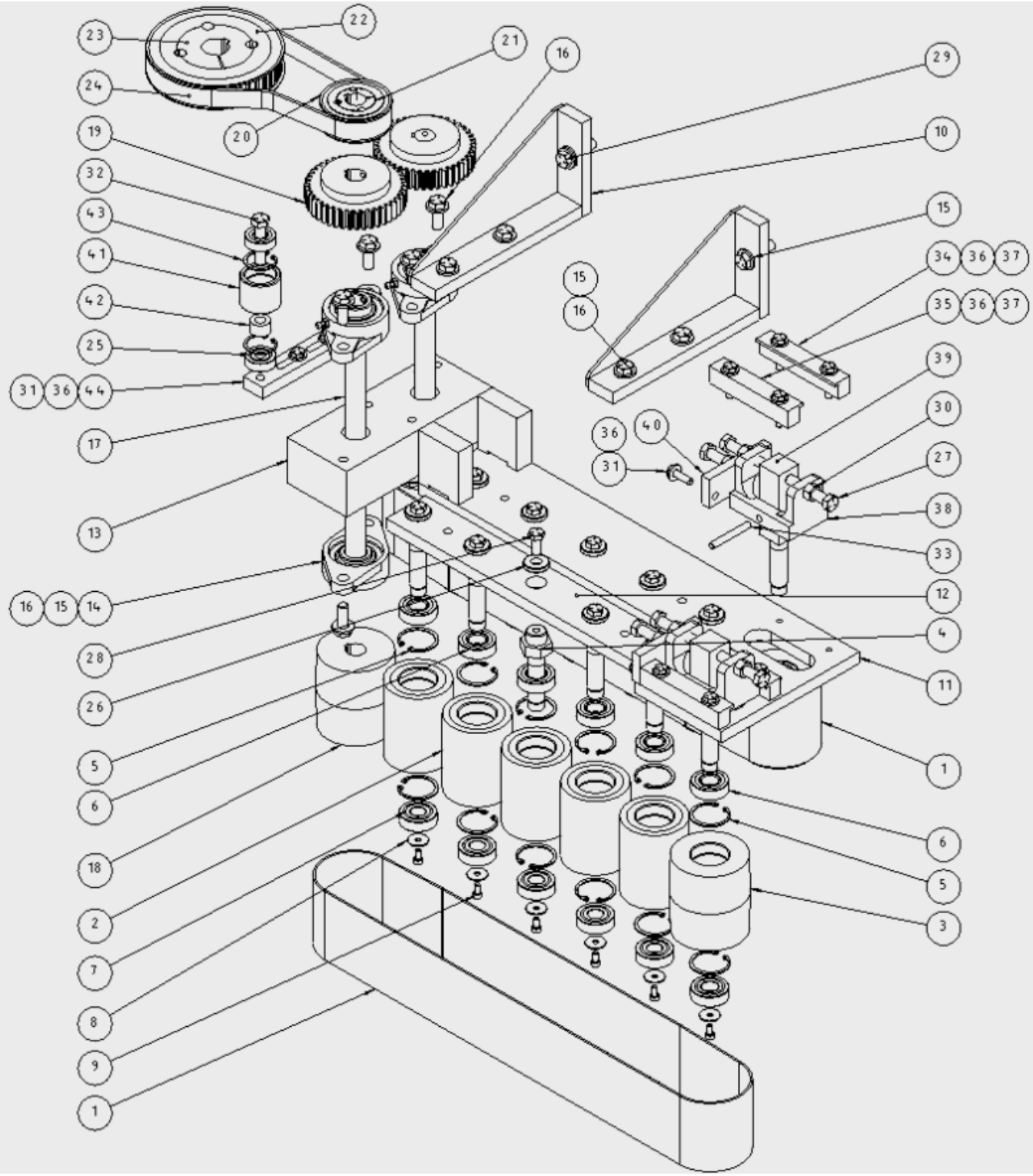
201-100 - CREASER ASSEMBLY (STYLE A) ITEMS			
Item	Part Number	Description	Qty.
1	201-101	BLOCK-CREASER BEARING	2
3	900-028	BRG-BALL .75 X 1.62 X .50	4
4	201-104	SHAFT-CREASER	2
8	201-102	WHEEL-CREASER-MALE	1
9	201-103	WHEEL-CREASER-FEMALE	1
not shown	201-106	CREASER ADJUSTER BLOCK	1

202-100 FOLDER ASSEMBLY



202-100 FOLDER ASSEMBLY ITEMS			
Item	**Part Number**	**Description**	**Qty.**
1	202-006	WELDMENT-FOLD BRACKET	2
2	202-001	FOLDER SPINE	1
3	202-106	WELDMENT-FOLD OVER BLADE	1
4	202-103B	SUPPORT-MANIFOLD	1
5	202-102	POST-MANIFOLD	2
6	202-107	WELDMENT-Ø.50 HEAT MANIFOLD 2 air inlet	1
6	202-107B	WELDMENT-Ø.50 HEAT MANIFOLD 4 air inlet	1
7	202-104	BLADE-0°-180° FOLDING	1
8	202-105	BLOCK-AIR MANIFOLD	1
9	900-038	FITTING-AIR 90° 1/2 TUBE - 3/8 NPT	1
10	900-039	FITTING-COMP 3/8 TUBE - 1/4 NPT	4
21	900-161	HEATER-CARTRIDGE Ø.50 X 15.00	2

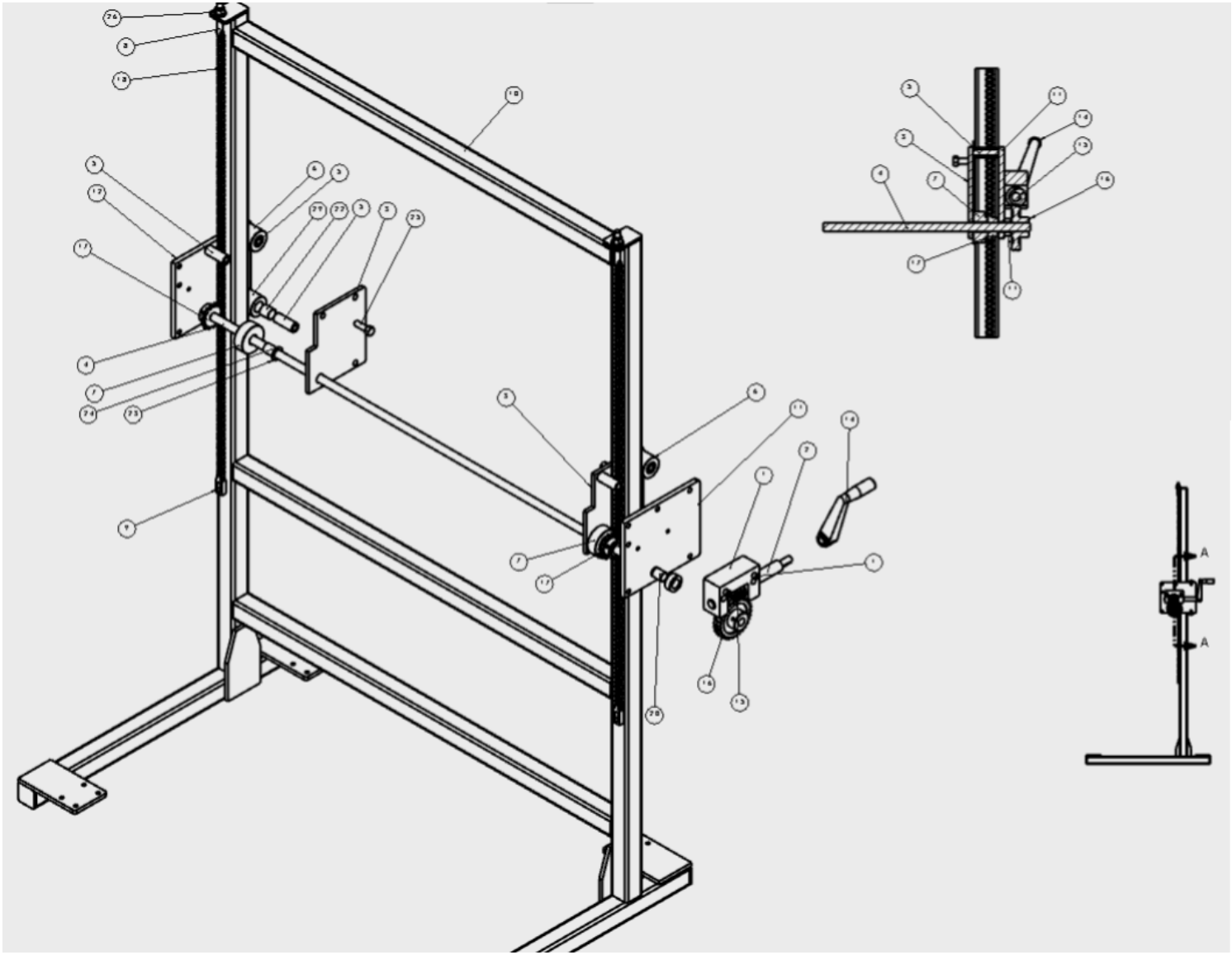
203-000 COMPRESSION ASSEMBLY (STYLE A)



203-000 COMPRESSION ASSEMBLY ITEMS

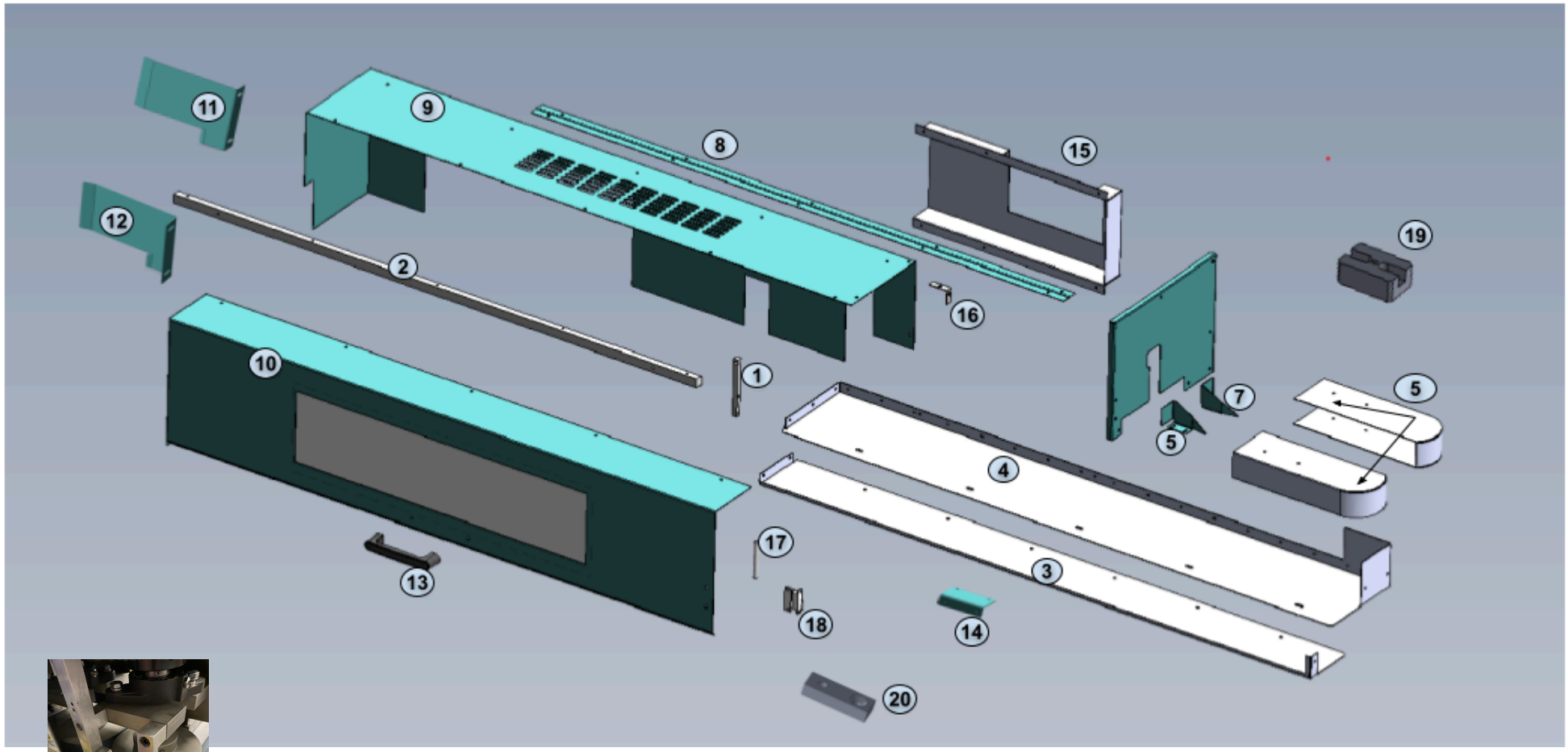
Item	Part Number	Description	Qty.
1	203-001	BELT-COMPRESSION	2
2	203-003	ROLLER-COMPRESSION	10
3	203-018	PULLEY-IDLER	2
4	203-004	SHAFT-COMP ROLLER	10
5	900-157	Retaining Ring-Int Ø1.375	24
6	900-027	BRG-BALL .62 x 1.38 x .44	14
7	900-050	BRG-BALL .56 x 1.38 x .44	10
10	203-022	WELDMENT-MTG BRACKET	2
11	203-013	PLATE-FIXED	1
12	203-005	BRACKET-ADJUST	1
13	203-008	WELDMENT-BRG MOUNT	1
14	900-193	BRG-2 BOLT FLANGE .75	4
17	203-007	SHAFT-DRIVE	2
18	203-002	PULLEY-DRIVE	2
19	203-009	SPUR GEAR S1242	2
20	900-203	PULLEY-TIMING TL19L075	1
21	900-040	BUSHING-TL MATCHED WITH PULLEY .750	1
22	900-205	PULLEY-TIMING TL35L075	1
23	900-202	BUSHING- MATCHED WITH PULLEY 1.0	1
24	900-024	BELT-TIMING 240L075	1
25	900-025	BRG-BALL .38 x 1.12 x .38	2
33	203-010	PIN-PIVOT	2
34	203-011	SLIDE	2
35	203-017	SLIDE	2
38	203-012	SLIDE BLOCK	2
39	203-014	SHAFT-ROLLER	2
40	203-015	BLOCK-JACKSCREW	2
41	203-019	IDLER-BELT	1
42	203-021	SPACER-IDLER	1
43	900-156	RING-RETAINING-INT Ø1.125	2
44	203-020	IDLER BRACKET	1

204-000 FLOOR STAND ASSEMBLY



204-000 FLOOR STAND ASSEMBLY ITEMS			
ITEM	PART NUMBER	DESCRIPTION	QTY
1	106-01	WORM PLATE	1
2	106-02	CRANKSHAFT	1
3	106-03	PLATE INSIDE	2
4	204-001	CROSS SHAFT	1
5	106-05	AXEL ROLLER	6
6	106-06	ROLLER	4
7	106-07	ROLLER CHAIN	2
8	106-08	ADJUSTER CHAIN	2
9	106-09	HANGER CHAIN	2
10	204-002	WELDMENT FLOOR STAND FRAME	1
11	106-11	WELDMENT CRANK PLATE	1
12	106-12	WELDMENT IDLER PLATE	1
13	106-13	SPACER WORM	1
14	204-100	REWORK CRANK HANDLE	1
15	900-208	WORM	1
16	106-102	WORM GEAR	1
17	900-037	SPROCKET 40B14 .75 BORE	2
18	900-048	ROLLER CHAIN #40 SINGLE	2
19	900-047	LINK CONNECTOR #40	4
28	204-101	WELDMENT GEAR COVER	1

205-900 GUARD ASSEMBLY (STYLE A)



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205-900 GUARDS STYLE A ITEMS			
Item	Part Number	Description	Qty.
1	**205-001**	POST-GUARD	4
2	**205-104**	SUPPORT-HINGE & GUARD	2
3	**205-127**	COVER-LOWER FRONT	1
4	**205-128**	COVER-LOWER REAR	1
5	**205-112**	GUARD-INFEED PULLEY	1
6	**205-101**	GUIDE-INFEED RH	1
7	**205-009**	GUIDE-INFEED LH	1
8	**205-016**	HINGE-FRONT COVER	1
9	**205-003**	COVER-REAR	1
10	**205-004**	COVER-FRONT	1
11	**205-115**	GUIDE-DISCHARGE	1
12	**205-116**	GUIDE-DISCHARGE	1
13	**900-015**	HANDLE-OVAL PULL 6" MTG CTR	2
14	**205-117**	SUPPORT-GUARD-CENTER	1
15	**205-517**	MOTOR GUARD	2
16	**205-099**	CORNER BRACE	4
17	**205-017**	POST-COVER REST	2
18	**900-174**	DOOR SAFETY SWITCH	1
19	**205-124**	GAP ADJUSTER SPACER	2
20	**205-119**	INFEED SPACER	2
21	**205-120**	DISCHARGE BASE BAR	1
22	**205-121**	DISCHARGE FRONT RISER	1
23	**205-122**	DISCHARGE REAR RISER	1

ELECTRICAL COMPONENTS

All electrical parts requests REQUIRE a serial number of the machine to ensure the correct part

900-173	SELECTOR SWITCH 22MM MAINT 1NO 10A
900-174	DOOR SAFETY SWITCH
900-175	SPEED POTENTIOMETER
900-176	SPEED POTENTIOMETER KNOB
900-179	1 1/4 X 1 5/8 WIRE DUCT
900-180	WIRE DUCT CAP
900-211	THERMOCOUPLE
900-212	TEMPCO HEAT CONTROLLER PULSE CONTROL
900-258	DELTA DTB CONTROLLER PULSE CONTROL
900-259	DELTA DTB CONTROLLER SECONDARY CONTROL
900-260	Latching relay
900-261	22 mm Alarm Light
900-216	ENCLOSURE
900-217	ENCLOSURE SUBPANEL
900-218	CONTROL ENCLOSURE
900-219	CONTROL ENCLOSURE SUBPANEL
900-226	4 POLE TERMINAL BLOCK
900-229	VFD - input 3ph ph 480V, .1 HP
900-230	VFD - input 1ph 240V, .1 HP
900-231	VFD - input 3ph 240V, .1 HP
900-240	LABEL - LIVE ELECTRICAL 1.25 x 3
900-242	EMERGENCY STOP DECAL
900-243	EMERGENCY STOP PUSHBUTTON MAINTAINED TWIST RELEASE NO DECAL
900-248	3KVA TRANSFORMER 480/208 WYE 3 PH (SEE SCHEMATIC WHERE APPLICABLE)
	Control transformer - see production checklist or contact elevation packaging with the serial number
900-262	Heat Contactor
900-263	Reset Pushbutton Assy
900-167	SOLID STATE RELAY 208/230 VOLT
900-172	NO CONTACT BLOCK 2.2 MOUNTING BASE 10A