

# **Texwrap**

## **“Built-Better/Backed-Better Warranty©”**

All Texwrap manufactured components are warranted against defects in design, material and workmanship for a period of three (3) years- unlimited cycles. All purchased components are warranted for a period of one year. Warranty is transferrable for the life of the Warranty beginning with date of shipment to the original purchaser's facility. Warranty does not cover the replacement of consumable/wear items (sealing blades, sealing pads, tape, belts, etc), routine maintenance, or alignments.

Texwrap will, at their discretion, repair or replace a defective component at no charge including UPS ground transportation. Field technician labor is typically handled on warranted items by local Texwrap distributors on a billable basis. Contact your local Texwrap distributor for their warranty claim procedure and policies.

This warranty will become null and void if it is determined by Texwrap that:

- the equipment is misused, abused or neglected in any way.
- the equipment is altered or modified without prior written approval from Texwrap.

Texwrap does not warrant that the equipment conforms to any insurance regulation, electrical or safety code (with the exception of panels containing UL stickers, which meet UL codes). The purchaser assumes liability for compliance with all applicable statutes, codes and regulations whether federal, state or local.

This limited warranty applies only to the repair or replacement of defective parts. Warranty does not cover replacement parts not purchased from Texwrap.

For any replacement part shipped under warranty, the defective part must be returned to Texwrap by a Texwrap distributor within 30 days for examination. If determined to be defective, a credit will be issued. If the part is determined not to be defective, the part will be returned to shipper and no credit issued. Credits will not be issued for parts after 30 days.

Please note: A Return Authorization (RA) number must be obtained from the Parts Department prior to shipment of a defective part to Texwrap.

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## Introduction

### Welcome to the TEXWRAP 2219 series L-Sealer Wrapper!

This manual covers the operations and parts labeling of the 2219 L-Sealer machine.

The majority of the TEXWRAP 2219 machine controls are located in the machine's swivel touch-pad interface. TEXWRAP recommends you read this manual and familiarize yourself with the controls, terminology and operations of this machine before attempting any of the following procedures including the basic installation of this equipment.

The TEXWRAP model 2219 is a horizontal form, fill and seal. The L-Sealer seal head is pneumatically operated, with all other functions performed with VFD AC motors. All moving parts have been covered with safety interlocked guards so as to keep the user safe.

**NOTE: If your machine is the Enhanced Version, all time based screens will show distance based items, i.e. Rear Bag Timer will now be Rear Bag Distance.**

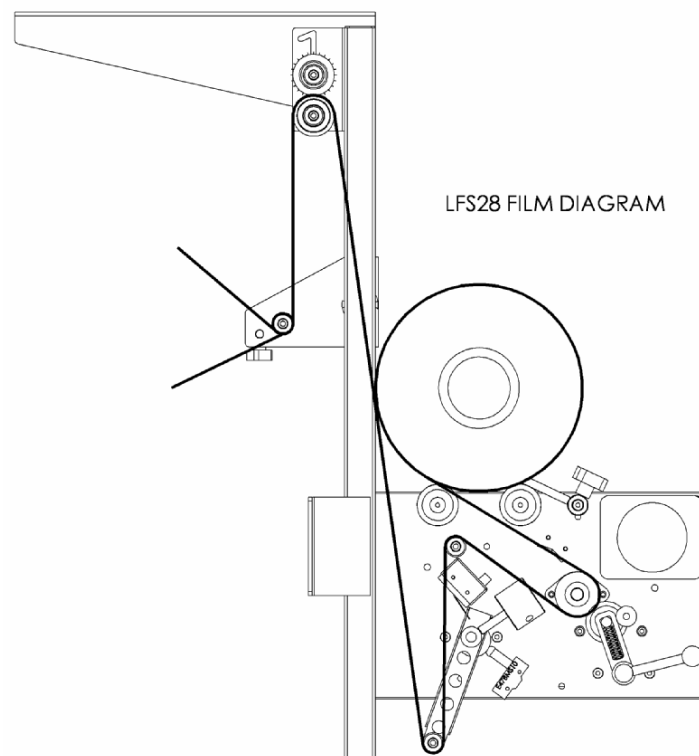
**The distance based feature means that as the belt speed changes, settings such as front and rear bag will not have to be changed to accommodate the new speed setting.**

## INSTALLATION REQUIREMENTS

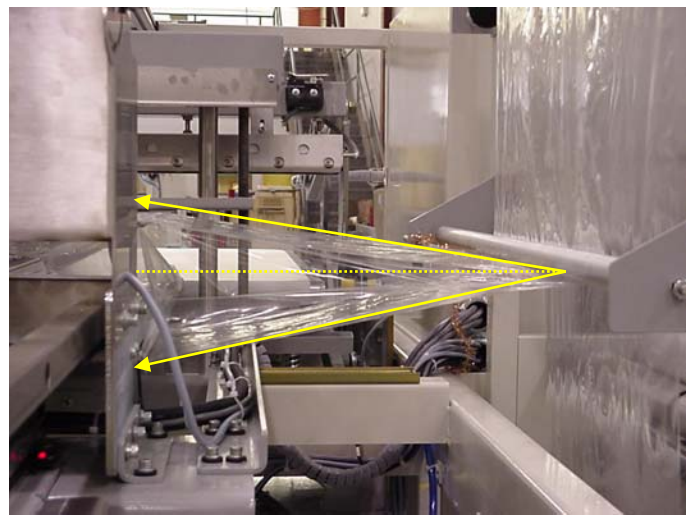
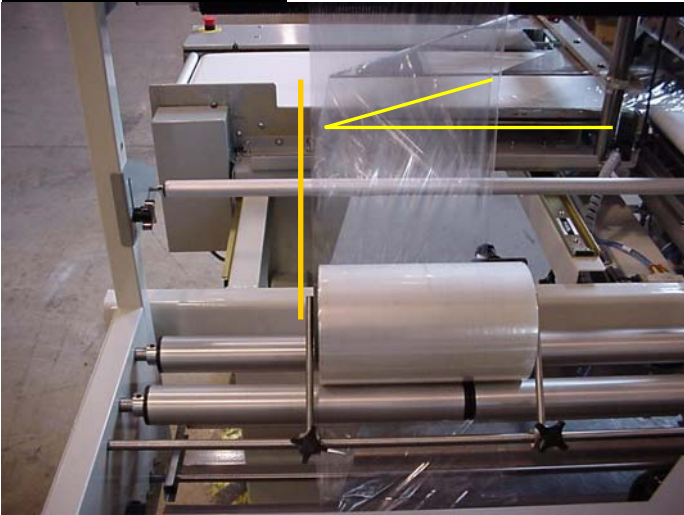
- 1) Wrapper must have dedicated, hard wire drop circuit 240 VAC single phase, 20 Amp, with local disconnect capabilities.
- 2) All connections must be properly grounded from circuit box, with earth ground origin.
- 3) Compressed air line capable of 80PSI, 2CFM – clean, dry air.
- 4) There should be a minimum clearance of 6ft. on each side of machine.
- 5) Floor should be level concrete, or similar structure.

## MACHINE SET-UP PROCEDURE

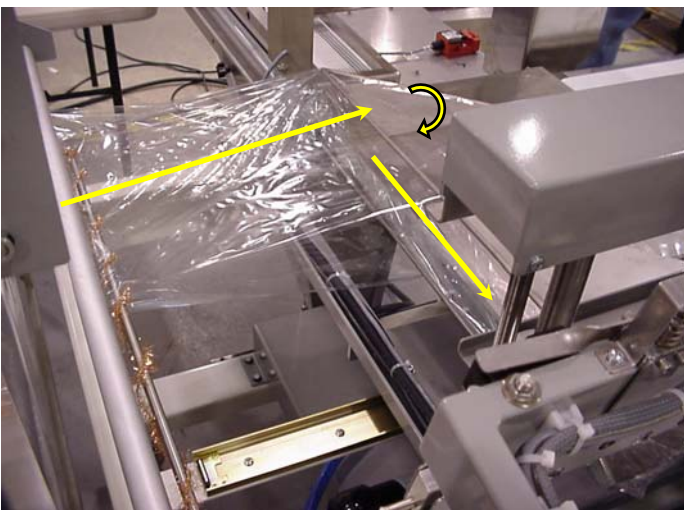
- 1) Uncrate, unpack and level machine. Check that all ORANGE shipping straps and ties have been removed. Assemble scrap winder, feet and any other components in shipping box.
- 2) Assure that proper electric and air has been supplied to machine, and turn on main disconnect.
- 3) After boot up, press the red RESET button. If button is not lit, troubleshoot E-stop circuit.
- 4) Turn on cross seal and side seal heaters.
- 5) Load film through the machine using the film thread diagram and following pictures.
- 6) Slide infeed conveyor/inverter heads to accommodate product width plus 1.5x product height. (Unlock slider with handle under deck).
- 7) Raise or lower inverting heads to accommodate product height plus 1/4in.
- 8) Adjust sealing mechanism height to accommodate the product being run. This is done by the handle located on the lower left hand out feed leg. When jaws close, the center-line should be roughly half the height of the package.
- 9) Check Front and Rear Bag settings, these should be about 1.5x the product height. These settings can be adjusted as machine runs to fine tune the position. Adjust Seal Time as needed.
- 10) Set main belt speed to the lowest pot. setting (20FPM) and press the green RUN button.
- 11) Any adjustments can be made while the machine is running, both mechanical and touch pad values.



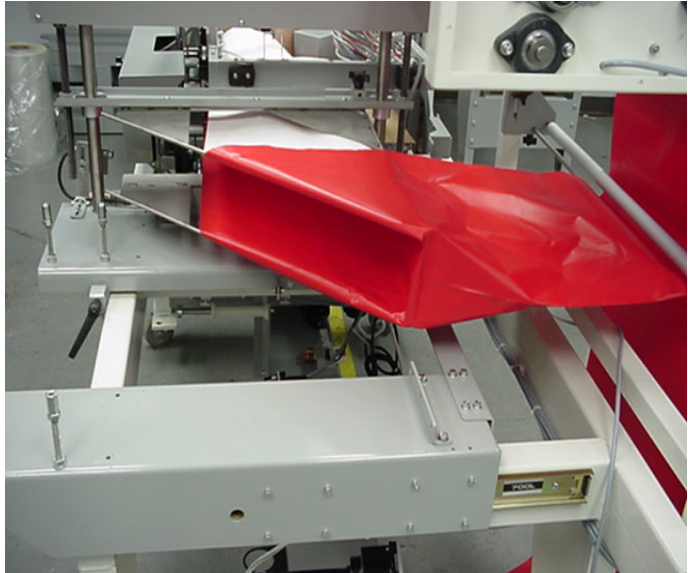
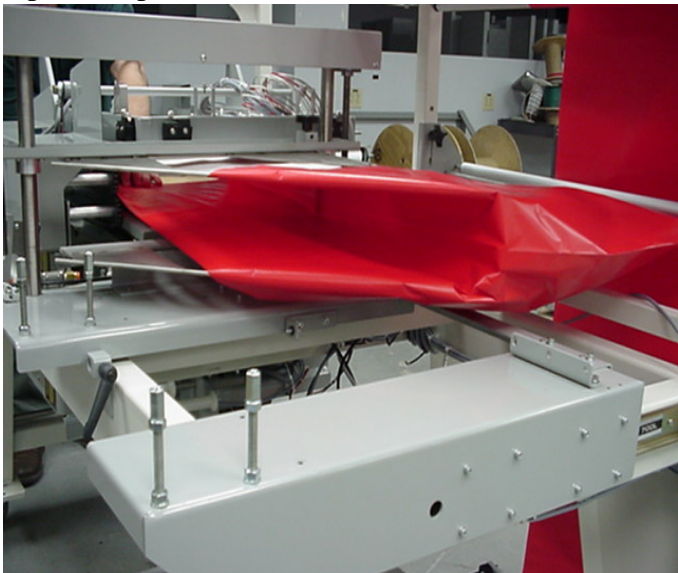
## FILM ROUTING



1. Align roll of film so that edge is slightly in front of inverter point, follow thread diagram. Set tracking roller so that equal tension is applied to top and bottom inverters.

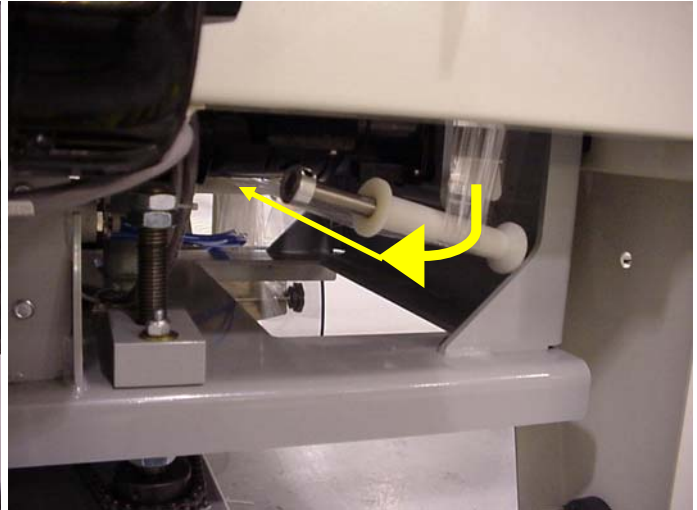


2. Thread film over inverting heads, note conveyor removed to show process; red back with white interior. Separate laps of film with anti-static tinsel bar.

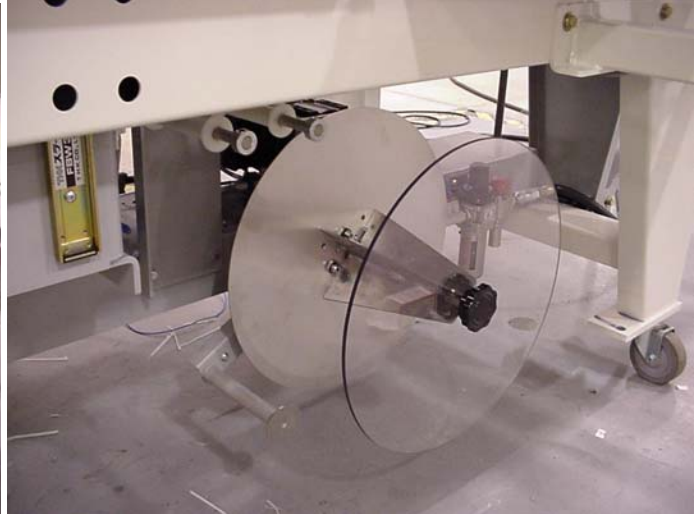
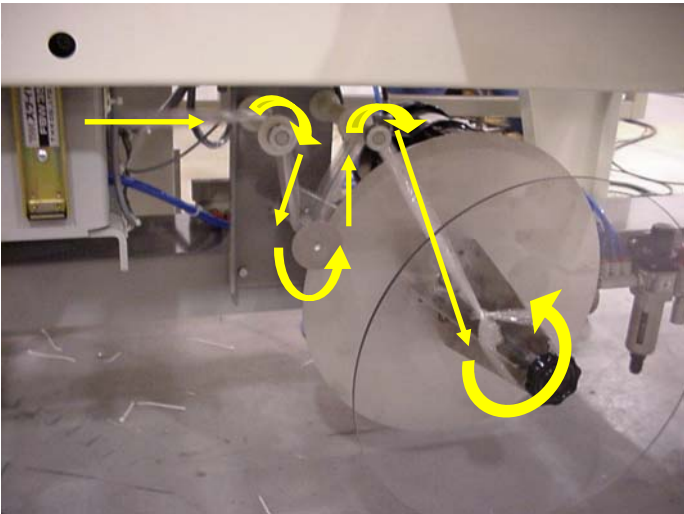




## SCRAP ROUTING



1. Place film between puller chains to begin scrap tail. Use manual jog and seal to create tail. Route around rollers and tie onto spooler.



### NOTICE:

Machine ships with spool assembly removed. Use above picture for assembly aid.

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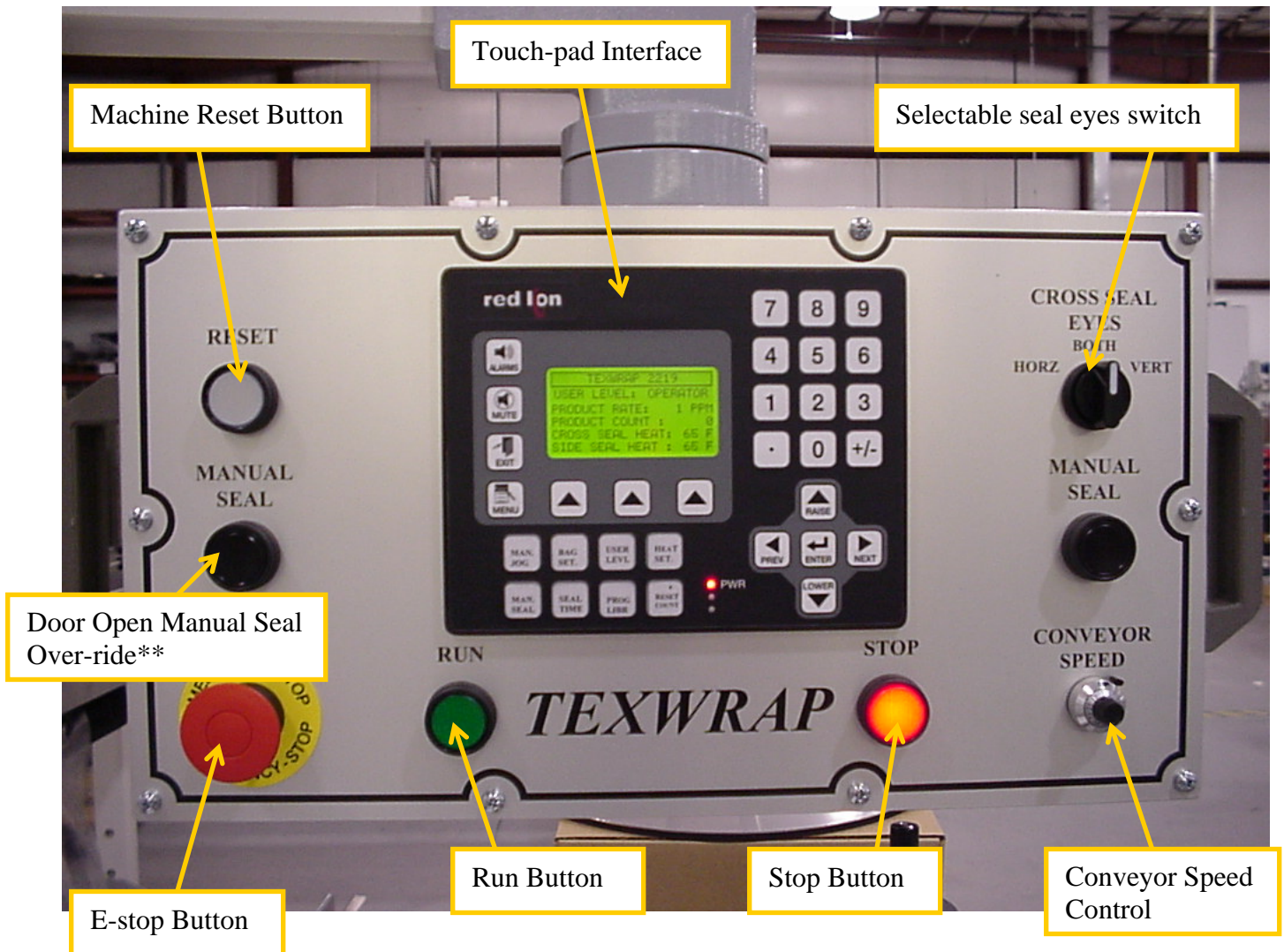


# **TEXWRAP**

## **2219** **OPERATIONS MANUAL**

## Machine Interface

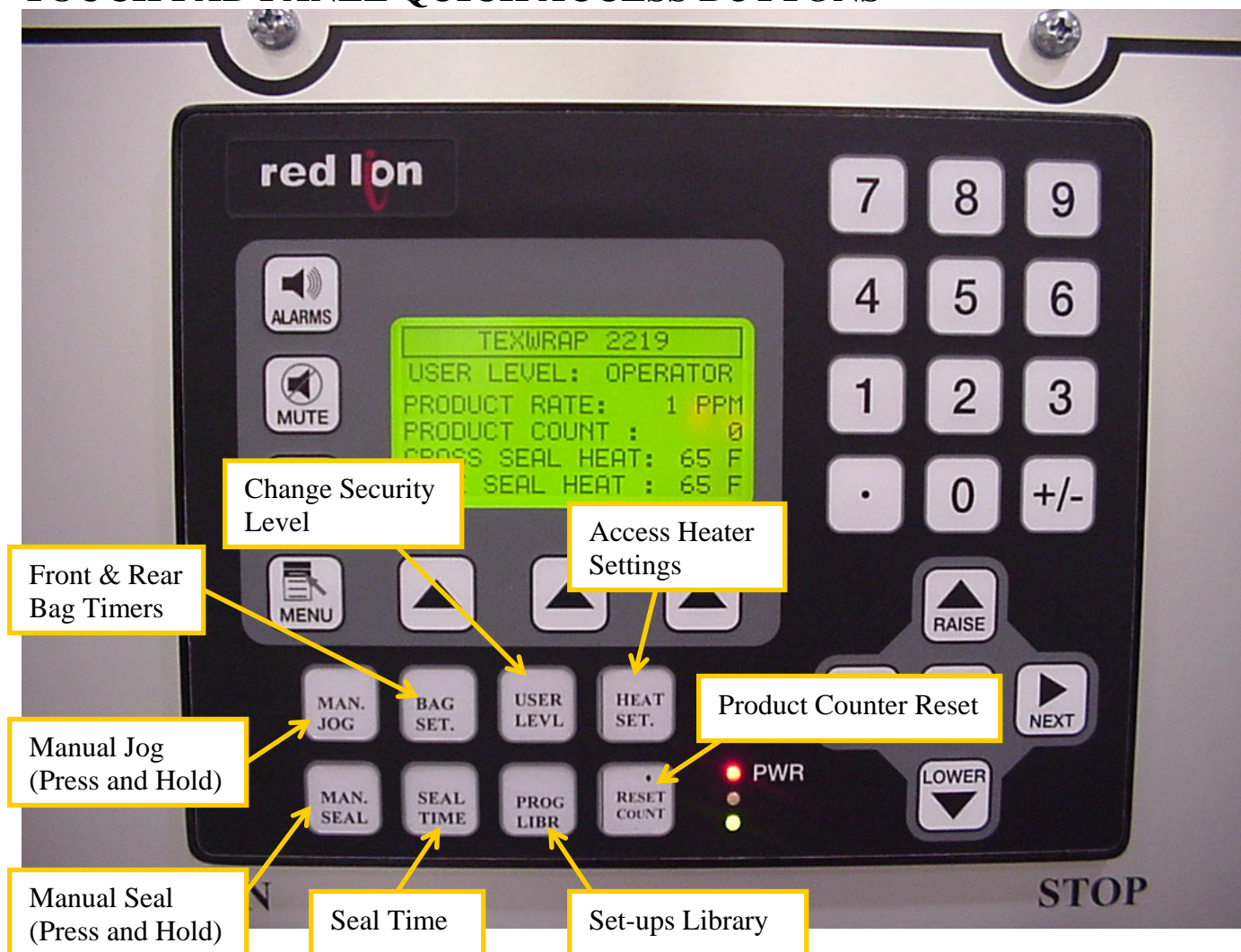
This Texwrap model features a swivel user interface with touch-pad control. All controls and electrical settings can be modified by the user through this interface.



**\*\*** With the seal area door open, a manual seal can be made by pressing BOTH Manual Seal buttons on the control panel. When the door is closed, only the touch pad Manual Seal button will be active.

**NOTICE:** To reset the machine to factory defaults, press and hold the Stop and Reset button for 5 seconds. Display will acknowledge when procedure is done.

## TOUCH PAD PANEL QUICK ACCESS BUTTONS



**Manual Jog and Manual Seal** – Press and hold these buttons to activate. Manual Seal will only work with the seal area door closed, otherwise use the two hand seal buttons.

**Reset Counter** – Press this button once, and the product counter will reset.

**Bag Settings** .....Page 13

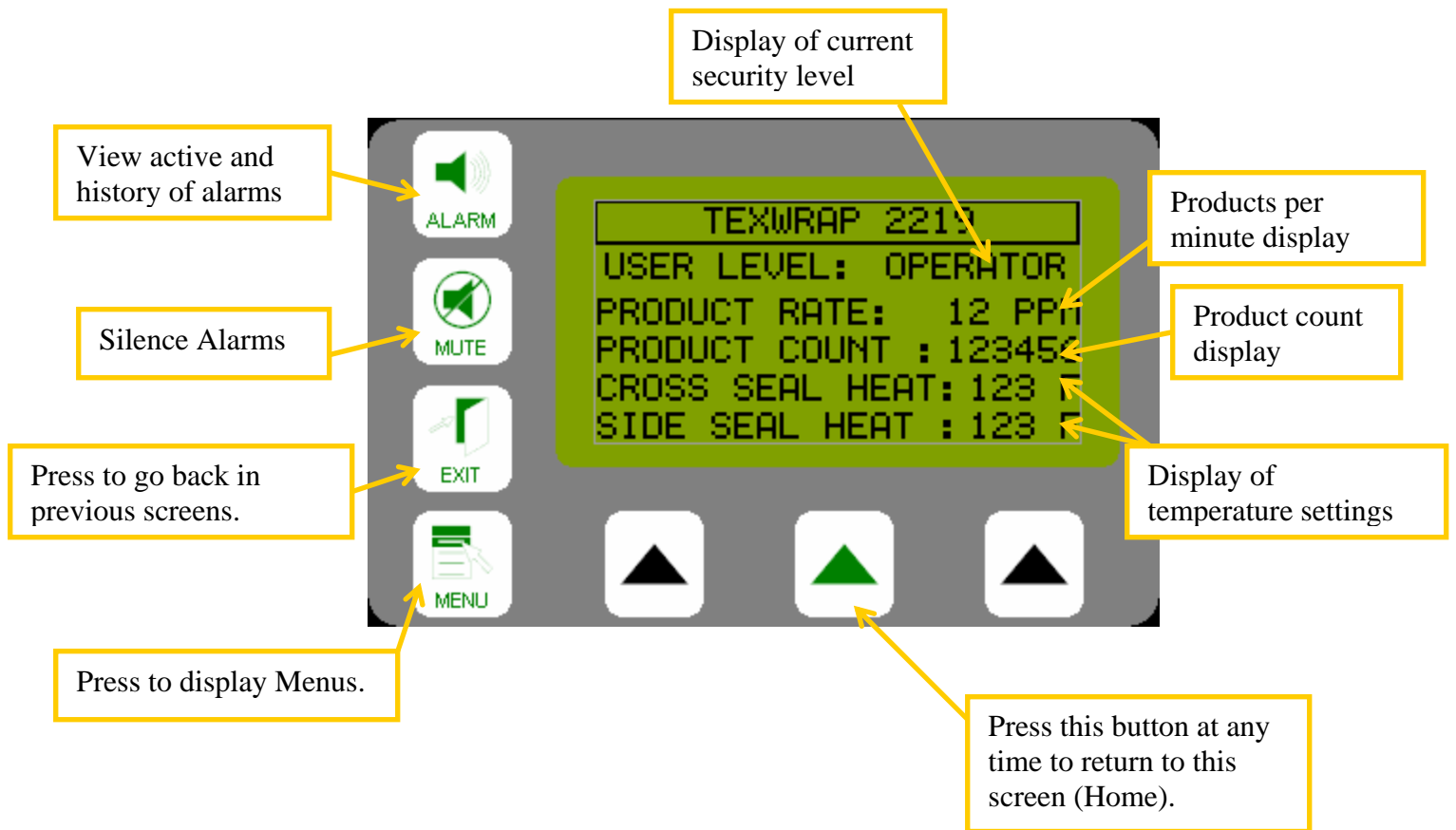
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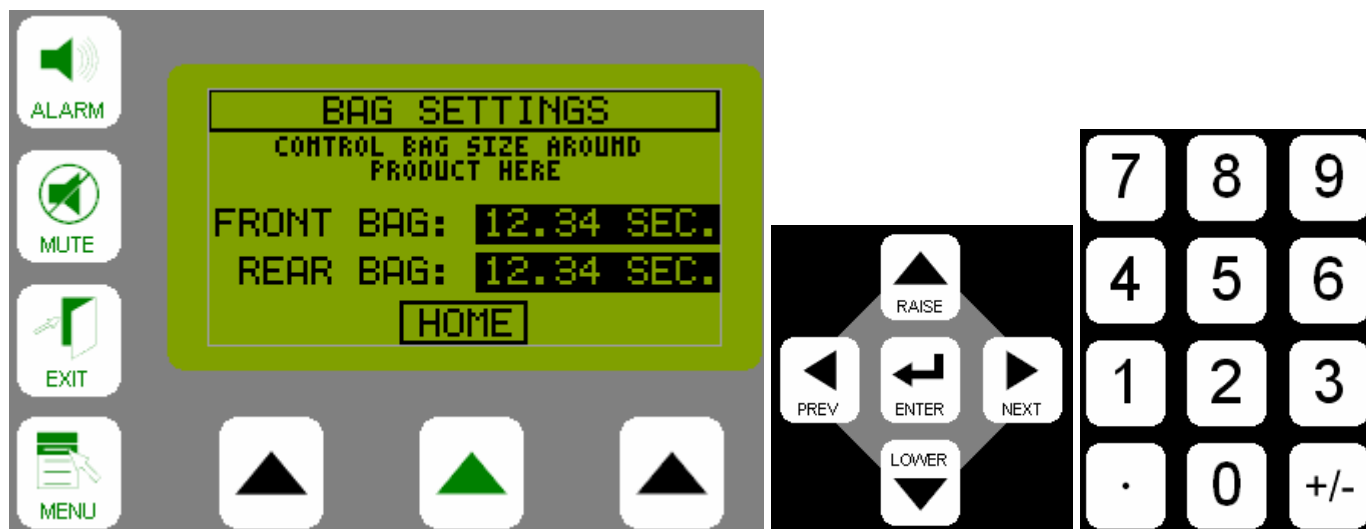
**Seal Time**.....Page 15

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## HOME SCREEN



## Front and Rear Bag Settings



### Front Bag Timer

Front bag is the amount of bag in front of the package. When the Run button is pressed, or after each seal cycle, this will be the amount of film pulled.

Press the PREV (UP) or NEXT (DOWN) button to highlight the setting to change. The user may press the RAISE or LOWER button to adjust the value, or type in a desired setting. When done press ENTER.

### Rear Bag Timer

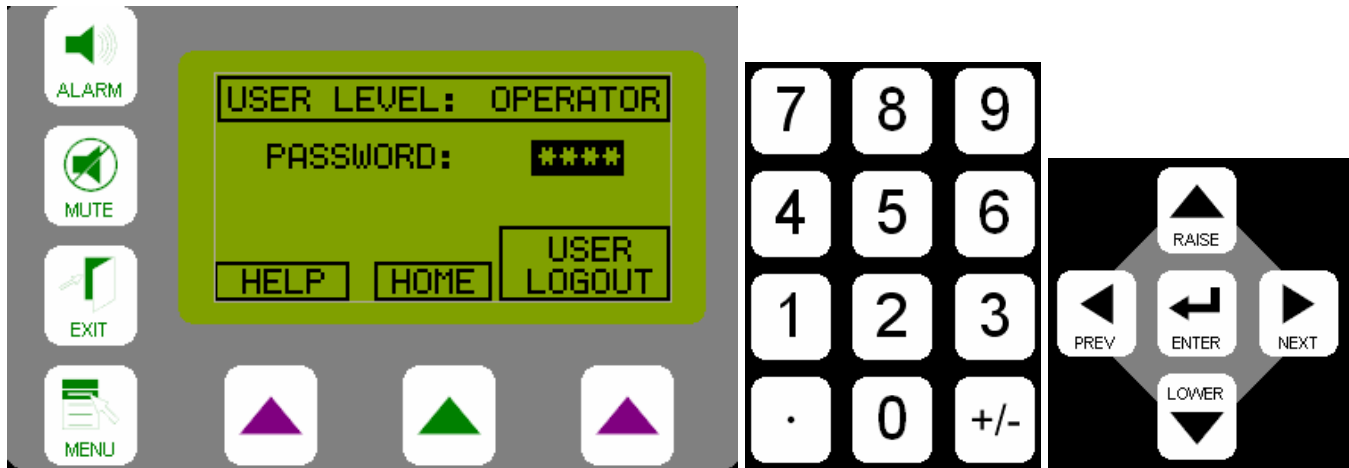
Rear Bag is the amount of bag at the rear of the package. After the product clears the staging eye, this counter begins. This will be the amount of film pulled after the staging eye is cleared.

Press the PREV or NEXT button to highlight the setting to change. The user may press the RAISE or LOWER button to adjust the value, or type in a desired setting. When done press ENTER.

**(NOTE: Since these are time values, the bag size will change if the conveyor speed is adjusted. Therefore be sure to adjust these values if conveyor speed is increased or decreased).**

To return to the previous screen press the EXIT button. To return HOME, press the button directly below the label HOME.

## User Levels



Texwrap offers 3 levels of security for the customer.

**OPERATOR** – This level gives the least amount of access, only allowing a program to be loaded, manual jog and seal, and alarm clearing.

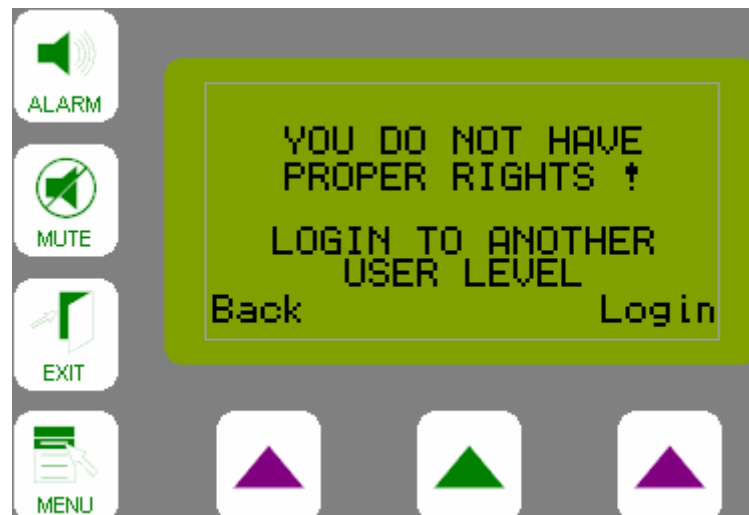
**SETUP** – Allows access to every setting except the service screen.

**SERVICE** – Has access to all features.

To change to a different user, type in the appropriate code and press ENTER. If the correct code is entered, one of the above level names will be displayed. To log out, press the button directly below the Logout label. This will automatically put the user level back to Operator.

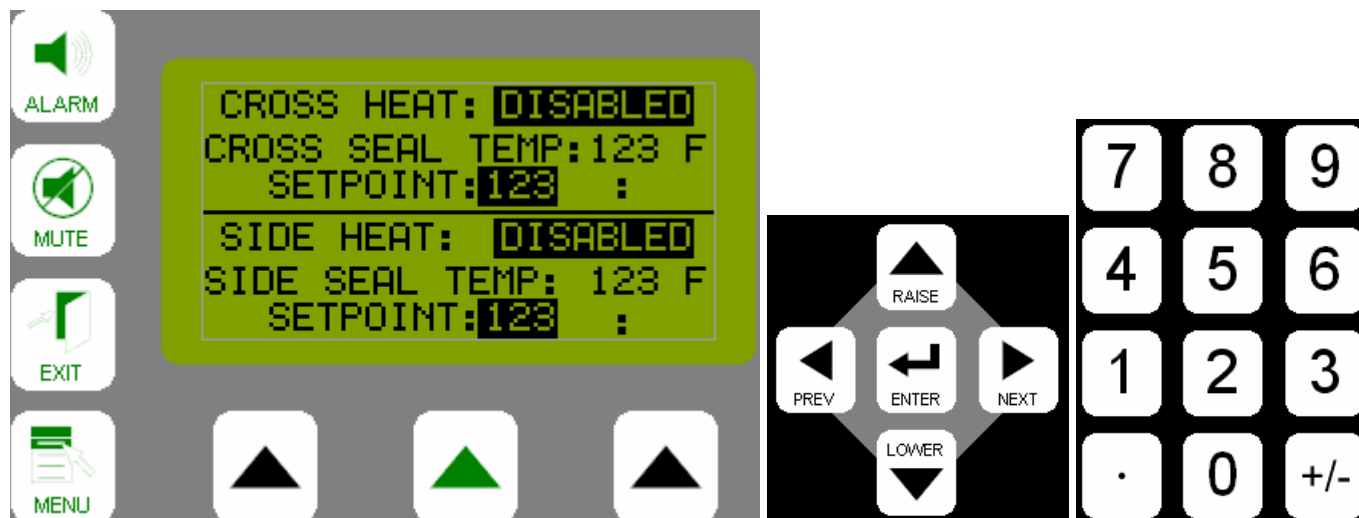
To return to the previous screen press the EXIT button. To return HOME, press the button directly below the label HOME.

If the touch pad is in level that does not allow access to certain screens, the following screen will be displayed when the secured button is pressed. At this point the user has the option to login.





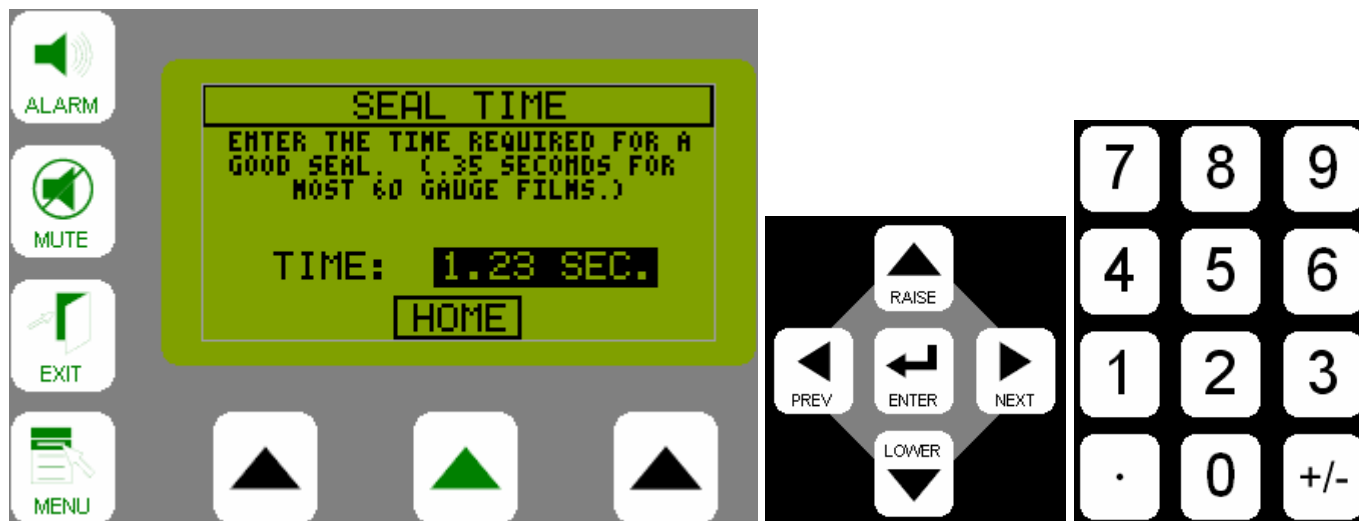
## Heater Settings



Press the PREV (UP) or NEXT (DOWN) button to highlight the setting to change. The user may press the RAISE or LOWER button to adjust the value or to ENABLE/DISABLE a desired setting. When done press ENTER.

To return to the previous screen press the EXIT button. To return HOME, press the center button directly below the display screen.

## Seal Time



Seal Time is the amount of time the seal bar stays in contact with the lower seal pad.

Press the RAISE or LOWER button to adjust the value, or type in a desired setting. When done press ENTER.

To return to the previous screen press the EXIT button. To return HOME, press the button directly below the label HOME.

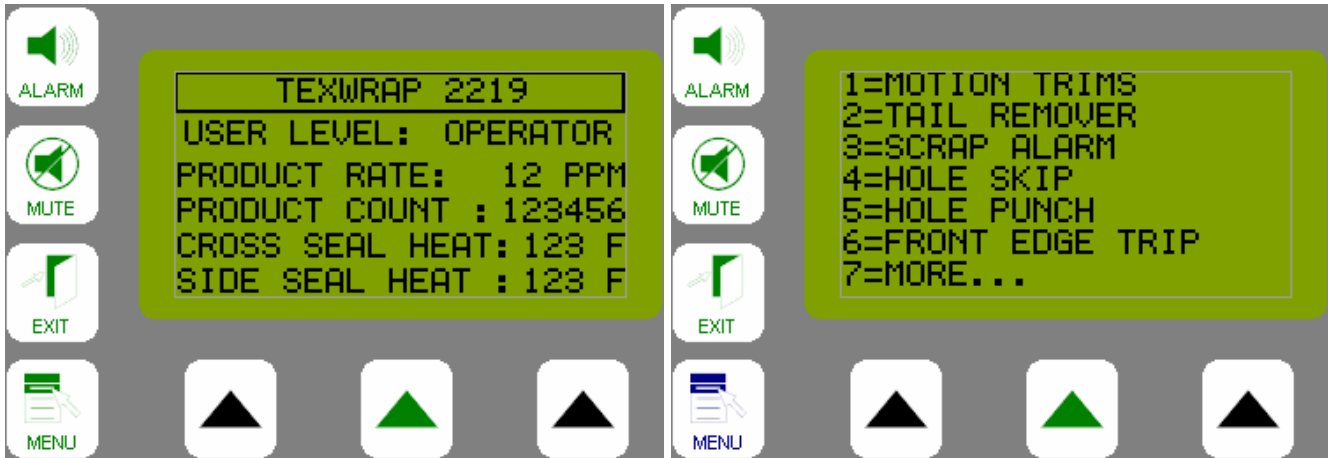


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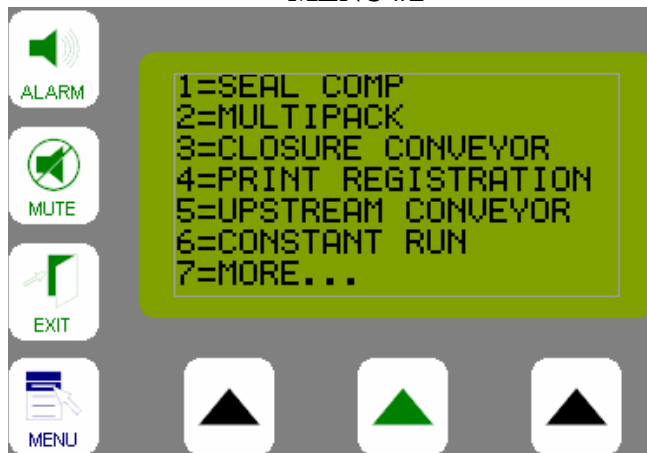
## MENUS

When the MENU button is pressed, Menu #1 screen will be displayed. To access the screen of the item desired, press the number on the keypad corresponding to the label. To access the next menu, press the number 7 on the keypad. Pressing the MENU button repeatedly will also scroll through the Menu screens.

**MENU #1**



**MENU #2**

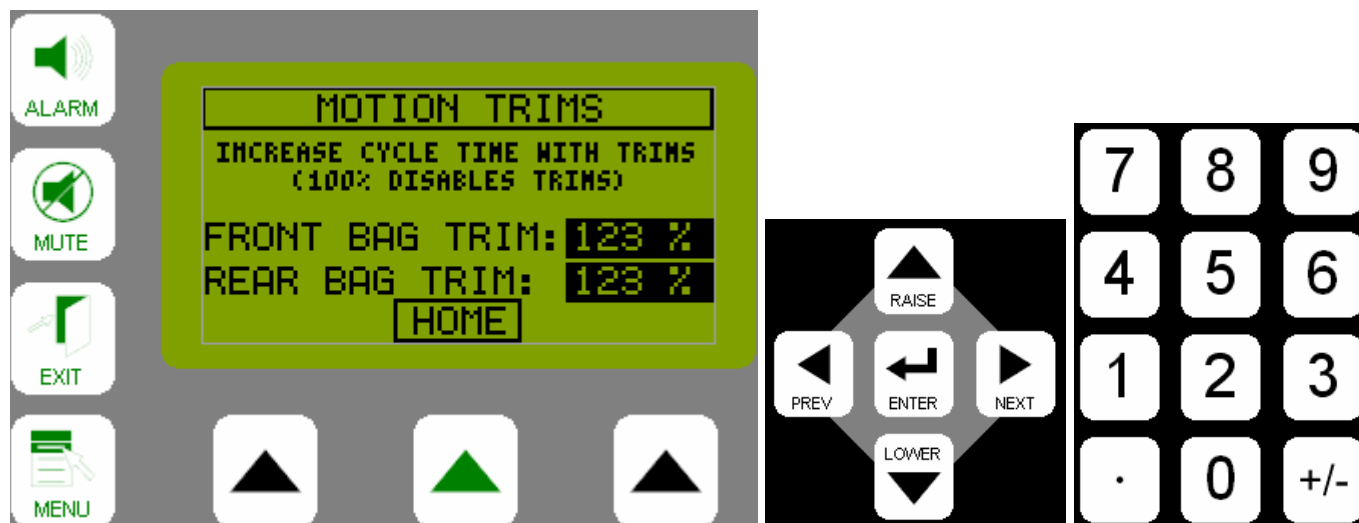


**MENU #3**



**Press the corresponding button to access the desired screen.**

## Motion Trims



**TEXWRAP MOTION TRIMS** The purpose of this feature is to increase the throughput of any certain product. This is accomplished by starting the opening or closing action of the seal bar before the staging eyes tell the machine to do so.

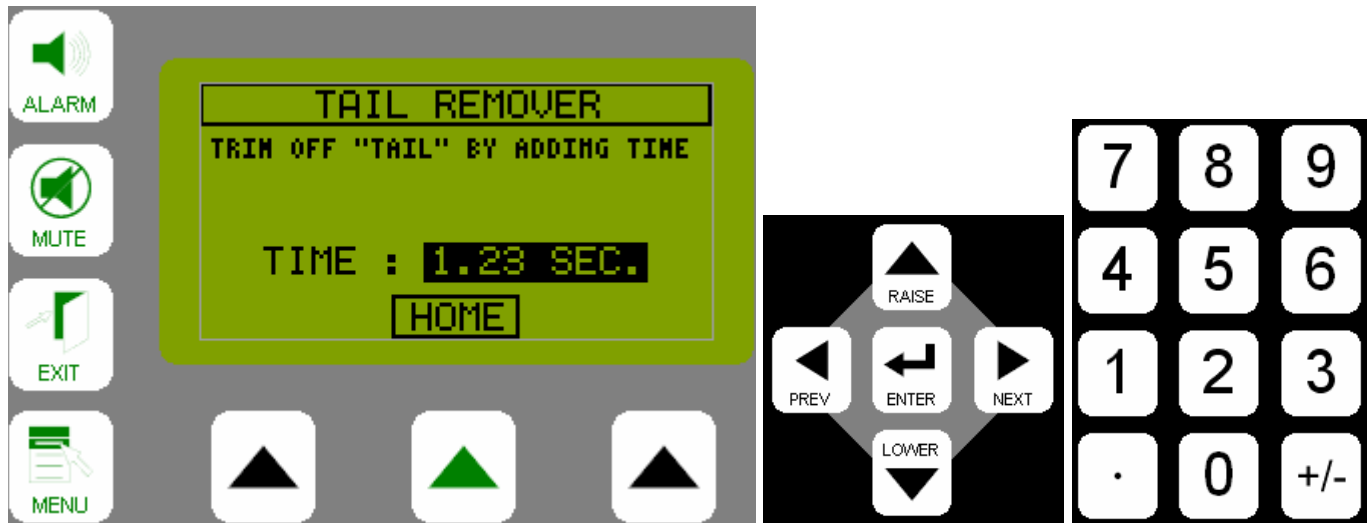
**FRONT BAG TRIM** In a normal seal cycle, the product does not begin the transfer into the seal area until the seal bar is completely open. Front Bag Trim uses a number from 0 to 100 to determine when the product should start moving into the seal area, even if the seal bar is not completely open. A number of 50 would mean that the seal bar will be 50% open when the transfer will begin. Depending on the product height and speed, a low number could allow the product to run into the seal bar. To turn this feature off, set Front Bag Trim to 100.

**REAR BAG TRIM** In a normal seal cycle, the Rear Bag timer must finish before the seal bar is allowed to close. Rear Bag Trim uses a number from 0 to 100 to determine when the seal bar should start the closing process, even if the Rear bag timer is not done. A number of 50 would mean that when 50% of the Rear Bag timer is left, the seal bar will begin to close. To turn this feature off, set Rear Bag Trim to 100.

Press the PREV (UP) or NEXT (DOWN) button to highlight the setting to change. The user may press the RAISE or LOWER button to adjust the value, or type in a desired setting. When done press ENTER.

To return to the previous screen press the EXIT button. To return HOME, press the button directly below the label HOME.

## Tail Remover



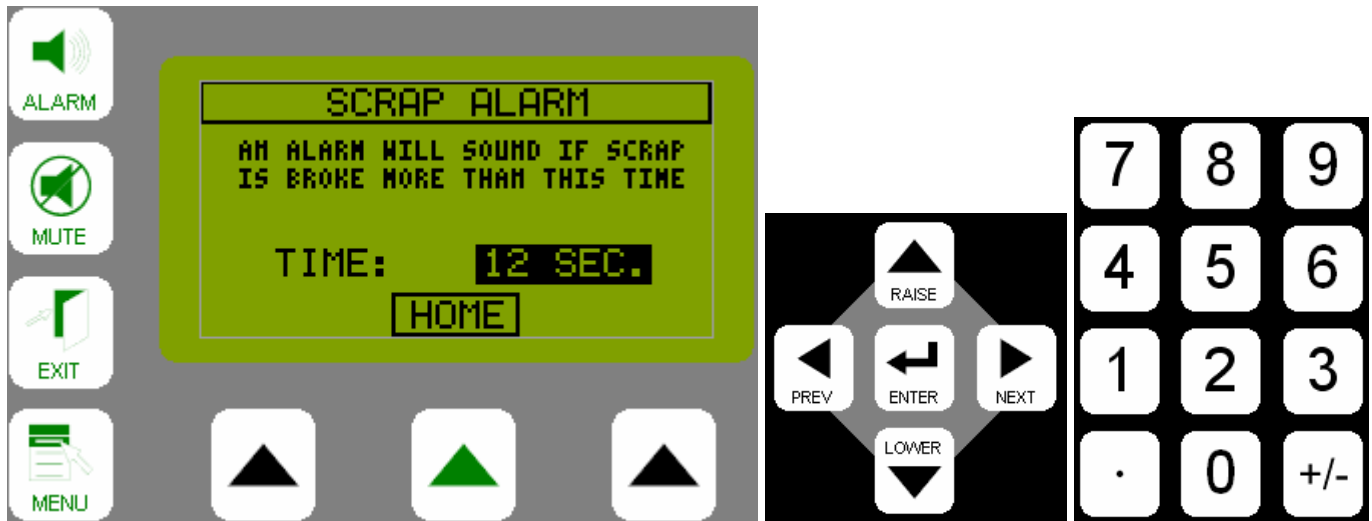
The purpose of this feature is to help remove the corner strip of film that sometimes develops in the corner of the 'L' seal. This is accomplished by stopping the film pull chains and keep the outfeed conveyor running (for the specified amount of time) to turn the product slightly. This will allow the seal bar to cut a clean corner away from the scrap section. This works best with heavier products. For proper machine operation, this number should be kept to a minimum.

**NOTE: This timer will add to the Rear Bag setting slightly.**

Press the RAISE or LOWER button to adjust the value, or type in a desired setting. When done press ENTER.

To return to the previous screen press the EXIT button. To return HOME, press the button directly below the label HOME.

## Scrap Alarm

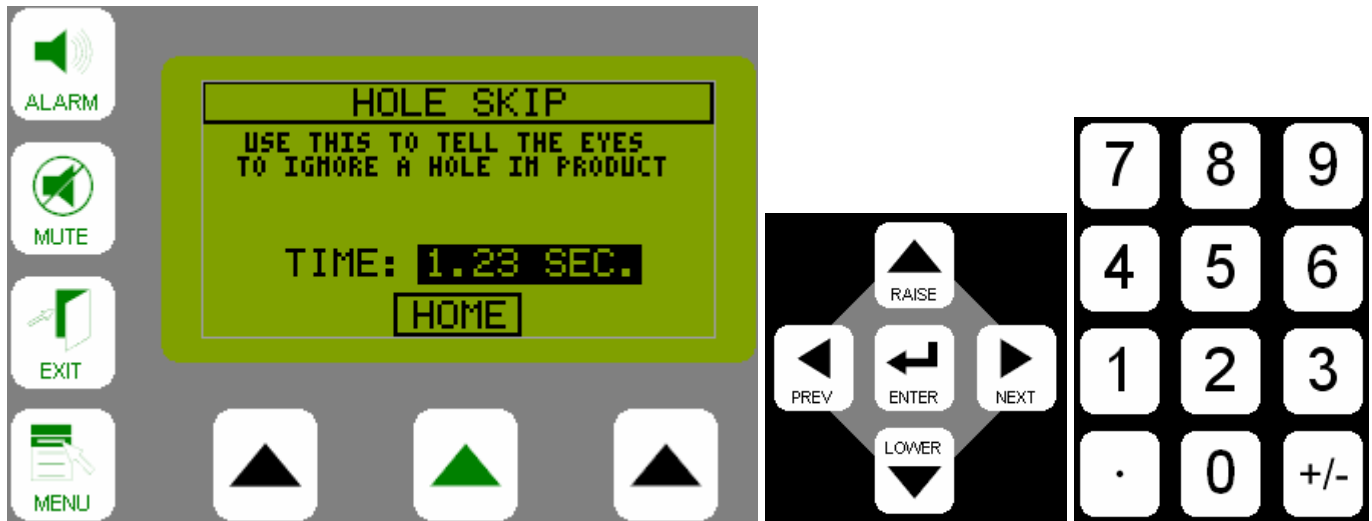


As the machine runs, the scrap spool cycles on and off rolling up the scrap stream. This is done by running the spool until the dancer arm hits the switch, which stops the spool allowing the arm to drop again. If the switch is not made in the time allowed in this screen then the machine will alarm and stop. This is so that any break in the scrap stream will not continue for an extended amount of time causing bad packaging and a mess.

Press the RAISE or LOWER button to adjust the value, or type in a desired setting. When done press ENTER.

To return to the previous screen press the EXIT button. To return HOME, press the button directly below the label HOME.

## Hole Skip



Some products being packaged are not always solid from front edge to rear edge. This feature allows the user to enter an amount of time for the staging eyes to ignore small gaps in the product or reflections off of the film, so that the product is treated as a complete unit. A good default time is 0.10 seconds. **Note that this time will add to the over all package size** so it should be kept as small as possible.

Press the RAISE or LOWER button to adjust the value, or type in a desired setting. When done press ENTER.

To return to the previous screen press the EXIT button. To return HOME, press the button directly below the label HOME.

## Hole Punch



These parameters are for control of a pneumatic punch. Additional equipment will be necessary to use this feature.

Press the PREV (UP) or NEXT (DOWN) button to highlight the setting to change. The user may press the RAISE or LOWER button to adjust the value or to ENABLE/DISABLE a desired setting. Press ENTER when done.

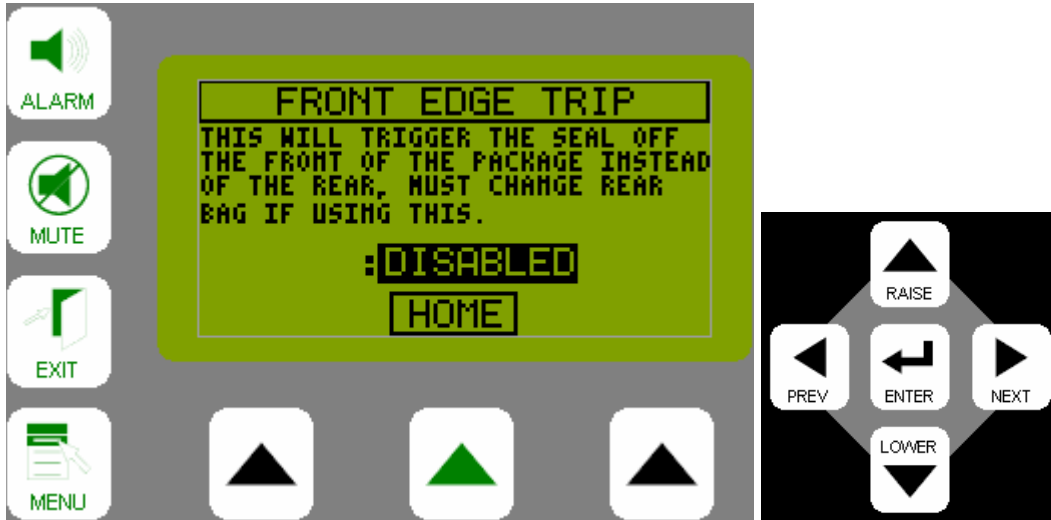
OFFSET TIME is an amount of time to delay the punch so that the user can properly place the punch with the product. A zero setting would punch when the seal jaws close.

OUTPUT TIME is an amount of time to energize the solenoid. Enter a small time to have a quick reacting punch.

To return to the previous screen press the EXIT button. To return HOME, press the button directly below the label HOME.



## Front Edge Trip



Use this feature if the rear of the package is indefinable (not a straight edge). First turn the feature ON/OFF by pressing the RAISE or LOWER button. Next adjust the Rear Bag timer to a large enough time to allow the package plus rear bag to enter the seal area.

To return to the previous screen press the EXIT button. To return HOME, press the button directly below the label HOME.

## Seal Compensation



As the machine cycles, the seal pad will begin to warm up from coming in contact with the hot seal knife. When the seal pad warms up to a certain amount, the seal time necessary to make a good seal diminishes. The Seal Compensation parameter allows the cycle time to slightly increase based off of observations of the seal time and amount of time required to heat up the seal pad. Turn the feature on by entering a 1 into the parameter box.

**Time Window** is the amount of time before the Seal Compensation will begin. This should be the amount of time the user notes that the seal pad is now warm enough to lessen the seal time.

**Seal Quantity** is the number of seals that the user wants to see happen in the Compensation Time Window. If the number of seals specified does not happen, the compensation will not begin. Once both parameters are met the compensation will begin. It will lessen the seal time by the amount specified in the next screen **Quick Seal**.

Press the PREV (UP) or NEXT (DOWN) button to highlight the setting to change. The user may press the RAISE or LOWER button to adjust the value or to ENABLE/DISABLE a desired setting. Press ENTER when done.

To return to the previous screen press the EXIT button. To return HOME, press the button directly below the label HOME. You may also press the button directly under the label HELP to see on-screen instructions.

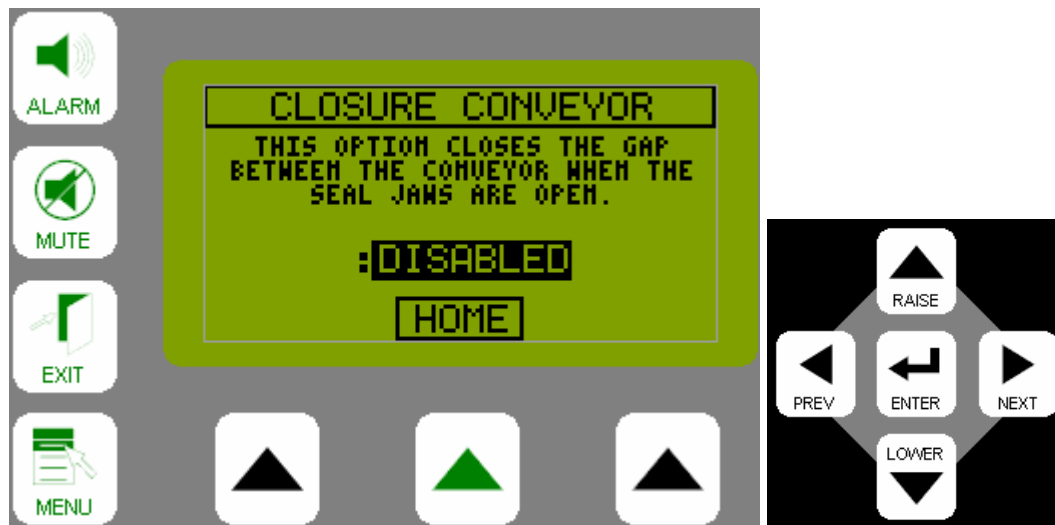
## Multi-Pack



The 2219 can multi-pack a single row of items to the extent of the side seal area. It performs this by indexing product into the seal area, one at a time, pushing them back-to-back. When the number entered is achieved, the seal bar will close. A setting of “01” is a single package.

To return to the previous screen press the EXIT button. To return HOME, press the button directly below the label HOME.

## Closing Conveyor

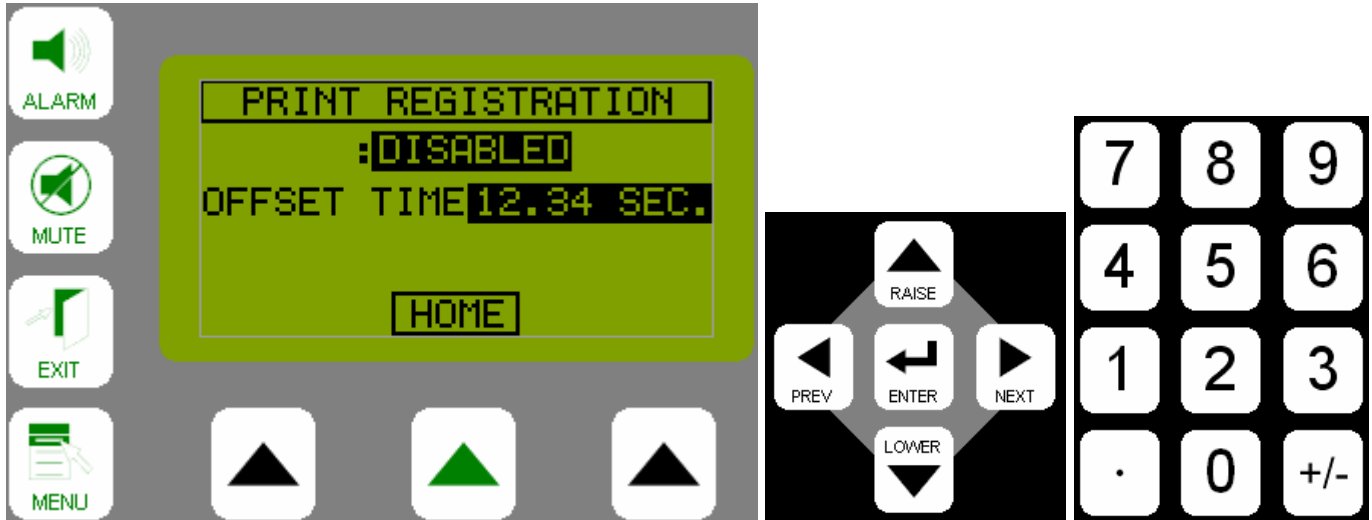


This feature is to help transfer products less than 4 inches in length between the infeed and outfeed conveyor.

If equipped, this will move the nose of the outfeed conveyor in and out to close the gap between the outfeed and the infeed conveyor, extending to transfer, then retracting for the seal cycle. Turn the feature ON/OFF by pressing the RAISE or LOWER button.

To return to the previous screen press the EXIT button. To return HOME, press the button directly below the label HOME.

## Print Registration



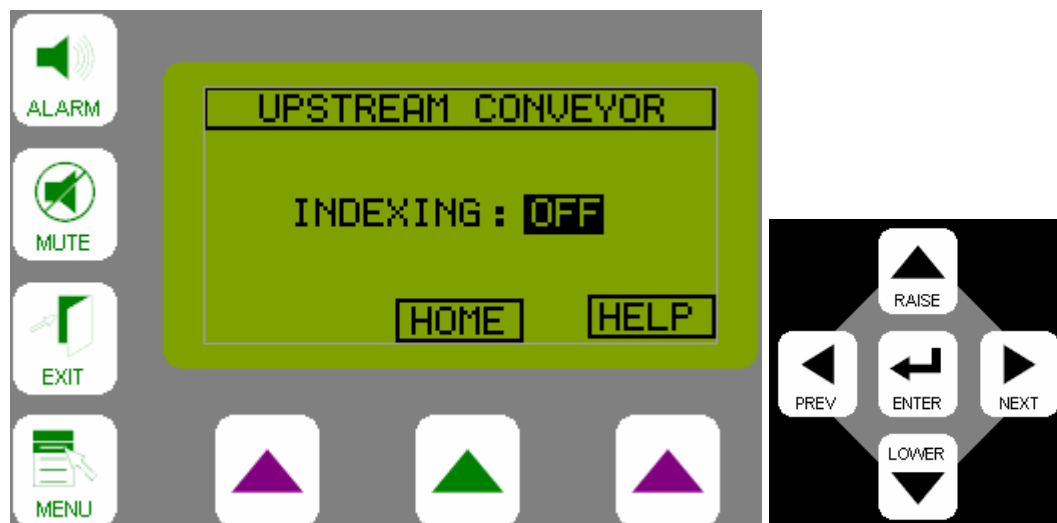
These parameters are for use with printed film. Additional equipment will be necessary to use this feature.

Press the PREV (UP) or NEXT (DOWN) button to highlight the setting to change. The user may press the RAISE or LOWER button to adjust the value or to ENABLE/DISABLE a desired setting. Press ENTER when done.

OFFSET TIME is an amount of time the machine will advance the film after the film sensor has detected a register mark. This is so the user can properly place the product with the printing on the film. A zero setting would stop the film pull at the register mark.

To return to the previous screen press the EXIT button. To return HOME, press the button directly below the label HOME.

## Upstream Conveyor



This feature is for the control of a feeder conveyor. When wired properly, this can start and stop the conveyor with the seal head (Indexing ON) or let the conveyor run continuously (Indexing OFF). Turn the feature ON/OFF by pressing the RAISE or LOWER button.

To return to the previous screen press the EXIT button. To return HOME, press the button directly below the label HOME. You may also press the button directly under the label HELP to see on-screen instructions.

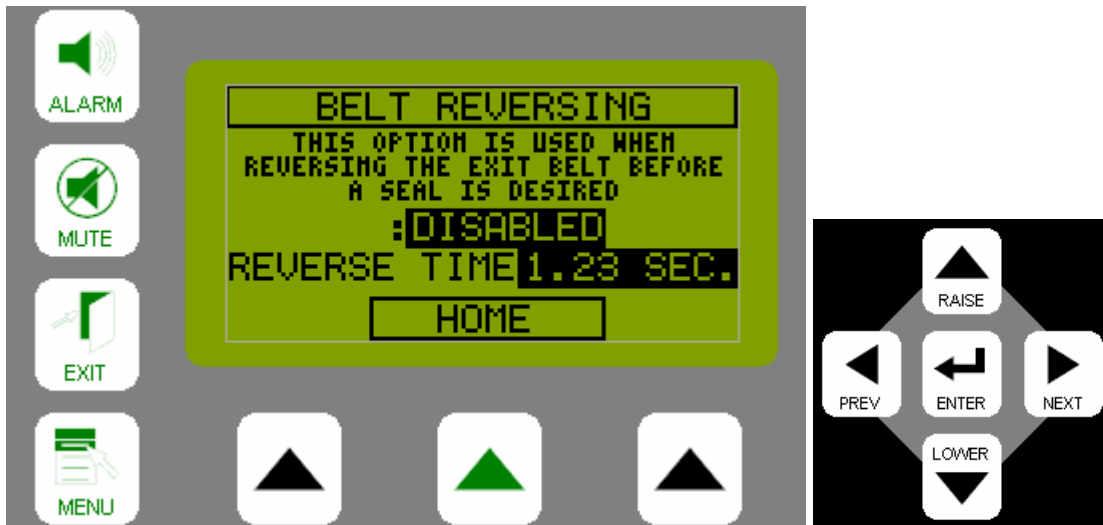
## Constant Run Conveyor



The purpose of this feature is to increase product output when upstream product gaps are large. With this feature enabled, the infeed conveyor will continue to run while the seal bar is closed and sealing. If the upstream gaps are not big enough, the spacing will quickly become too small and machine errors will occur. Turn the feature ON/OFF by pressing the RAISE or LOWER button.

**NOTE: The conveyor will stop if the photo eye is blocked.**

## Belt Reversing



This feature will reverse the exit for a desired period of time, thus relaxing the film prior to the seal bars closing.

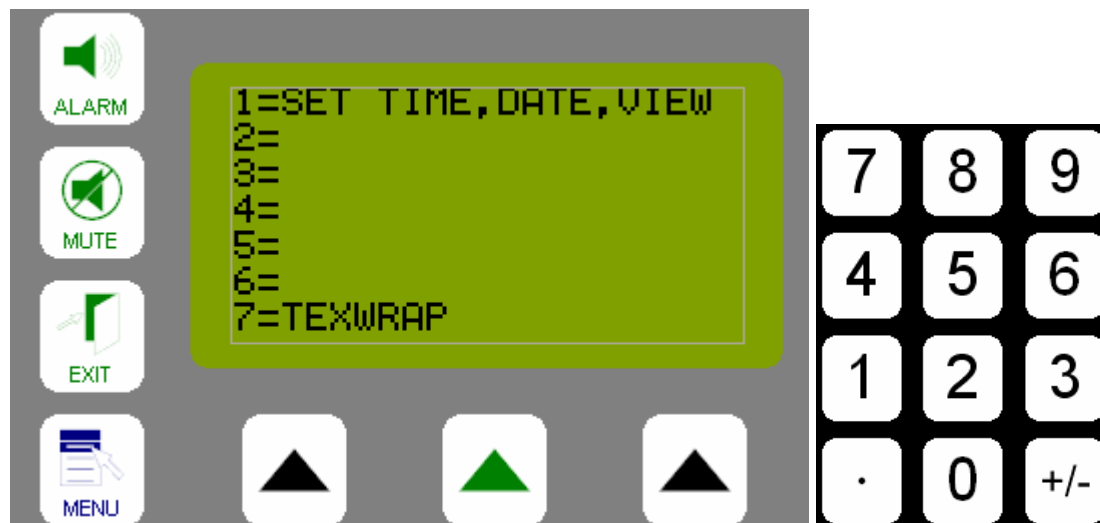
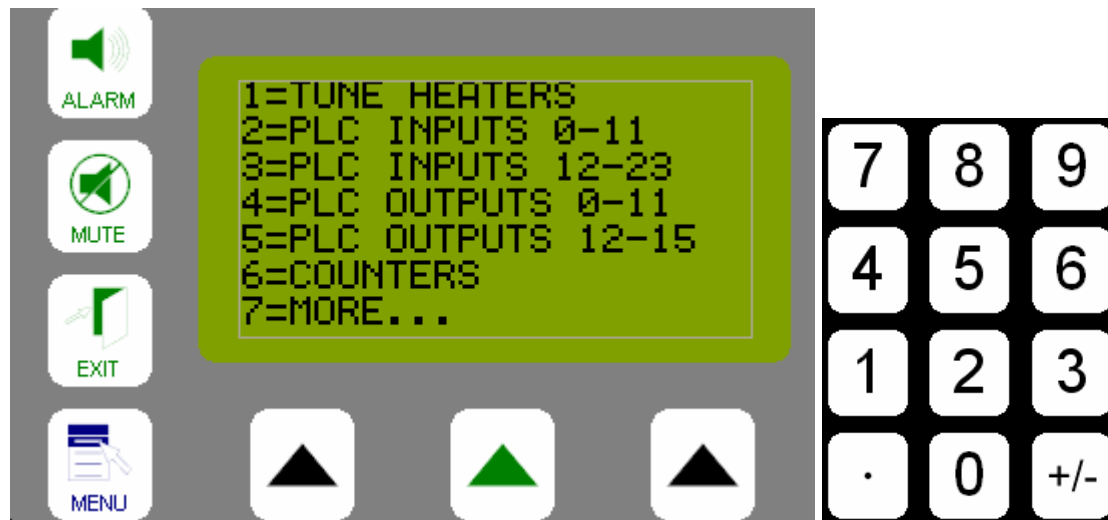
## Pass Through Mode



Turn the feature ON/OFF by pressing the RAISE or LOWER button. This turns all machine functions off except the conveyors, turning the machine into one conveyor so that the line configuration does not have to change for differing production needs.

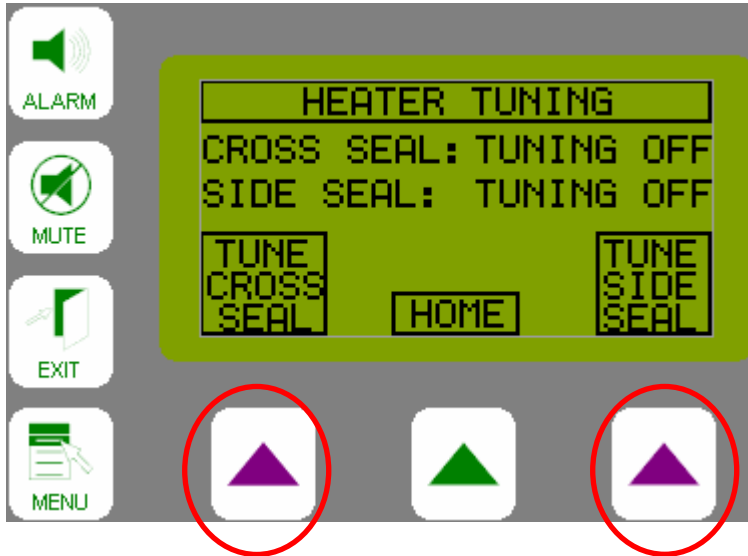
## Service

Press the corresponding number to access the desired screen





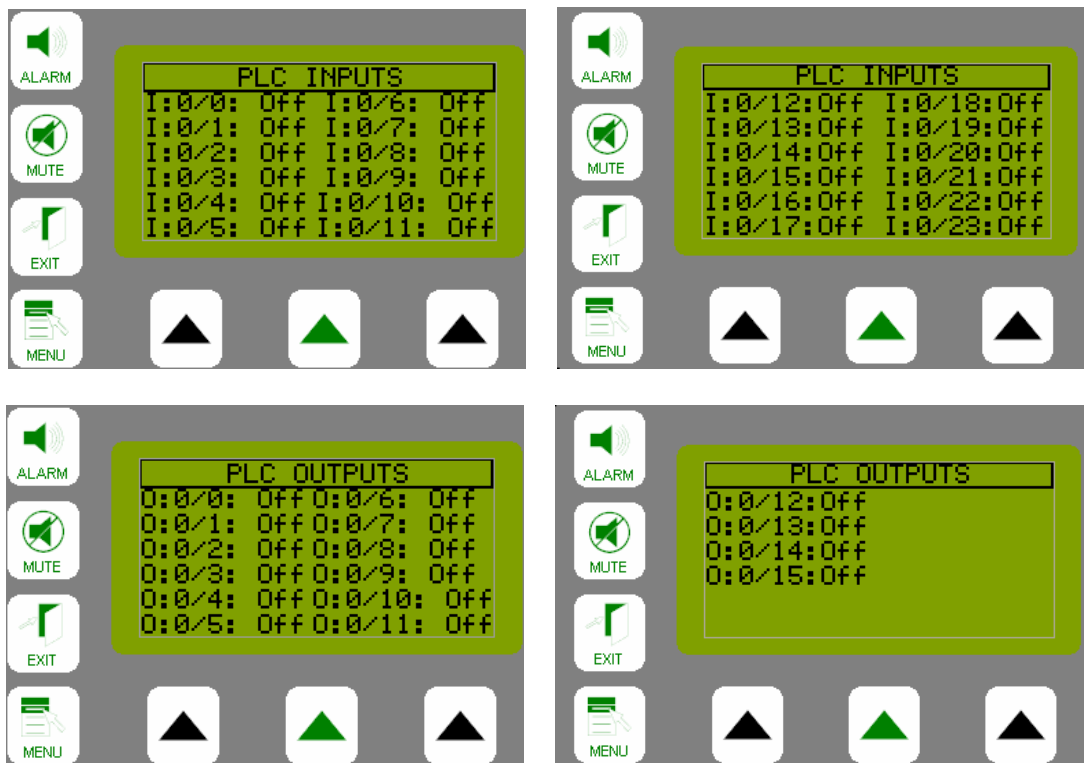
## Tune Heaters



Press the button directly below the label of the heater desired to tune. The display will show that the heater is tuning. Nothing else is needed, the tuning will stop automatically when it is finished. The heaters need to be tuned only if a heater element or thermocouple has been changed. However it will not hurt anything if it is done without any change.

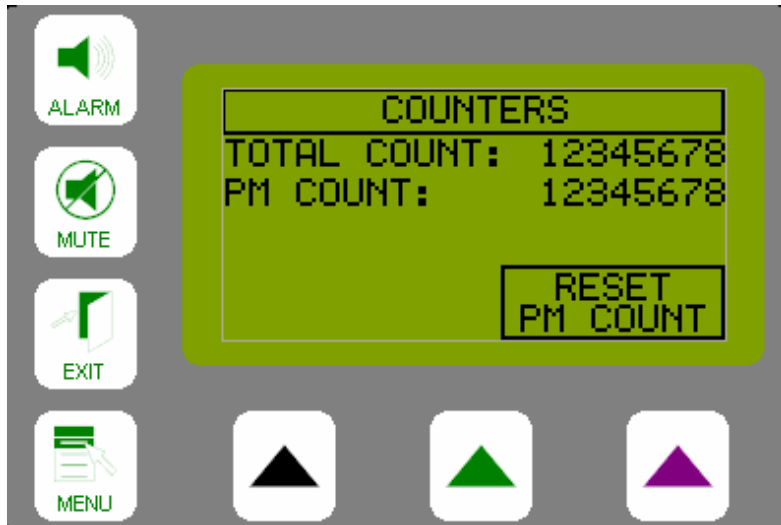
No further adjustments are needed until a heater element or a thermocouple is changed again.

## PLC Inputs / Outputs



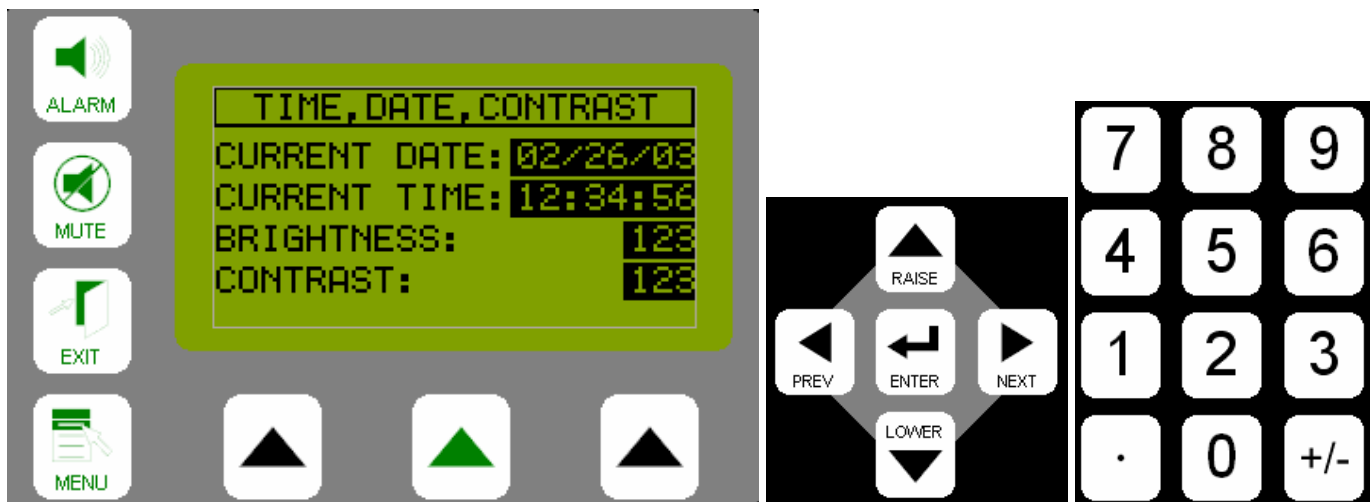
For aid in troubleshooting, the 2219 has a list of the inputs and outputs. It will display which ones are on and off. If the input or output seems to not be showing properly, there may be a communication lag. Check PLC lights as these will always be correct.

## Counters



This screen displays the total cycles the machine has made and the number of cycles since the last time the “Reset PM Counter button was pressed.

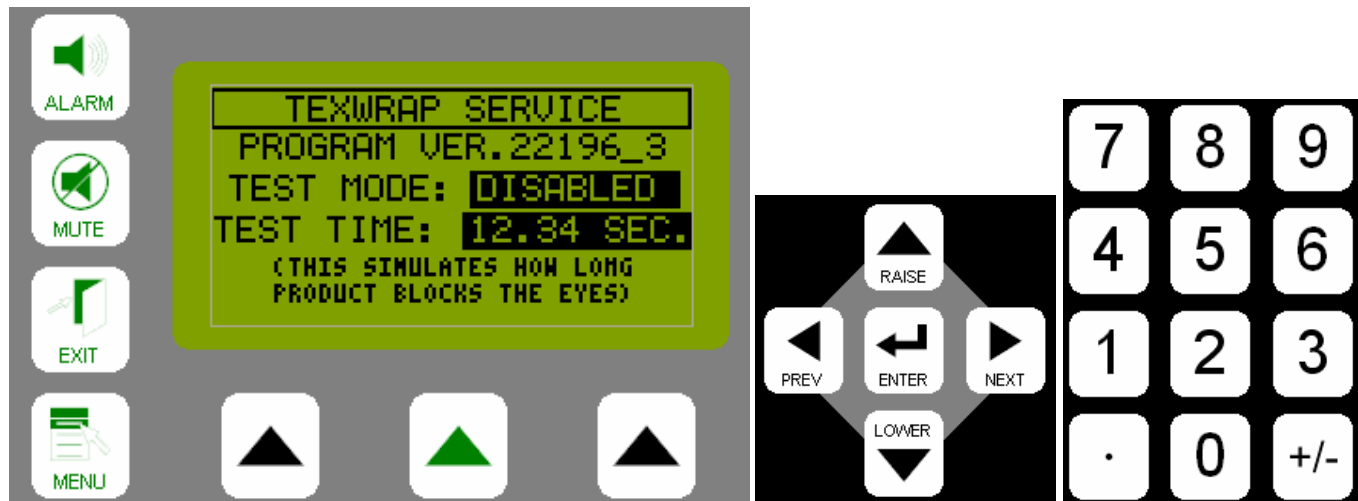
## Set Time, Date and View



Press the PREV (UP) or NEXT (DOWN) button to highlight the setting to change. The user may press the RAISE or LOWER button to adjust the value, or type in a desired setting. When done press ENTER.

To return to the previous screen press the EXIT button. To return HOME, press the button directly below the label HOME.

## Texwrap



To turn the “Test Mode” feature ON/OFF press the RAISE or LOWER button

Press the PREV (UP) or NEXT (DOWN) button to highlight the setting to change. The user may press the RAISE or LOWER button to adjust the value, or type in a desired setting. When done press ENTER.

To return to the previous screen press the EXIT button. To return HOME, press the button directly below the label HOME.

# PROGRAM LIBRARY

The purpose of program library is to store the Electronic machine settings for a particular product. This allows you to store a program for your product, give it a name or code and recall it any given time. After the operator selects the program to run, and adjusts any physical items, you will be ready to start production of that product.

**The following are some important things to remember about Program Library.**

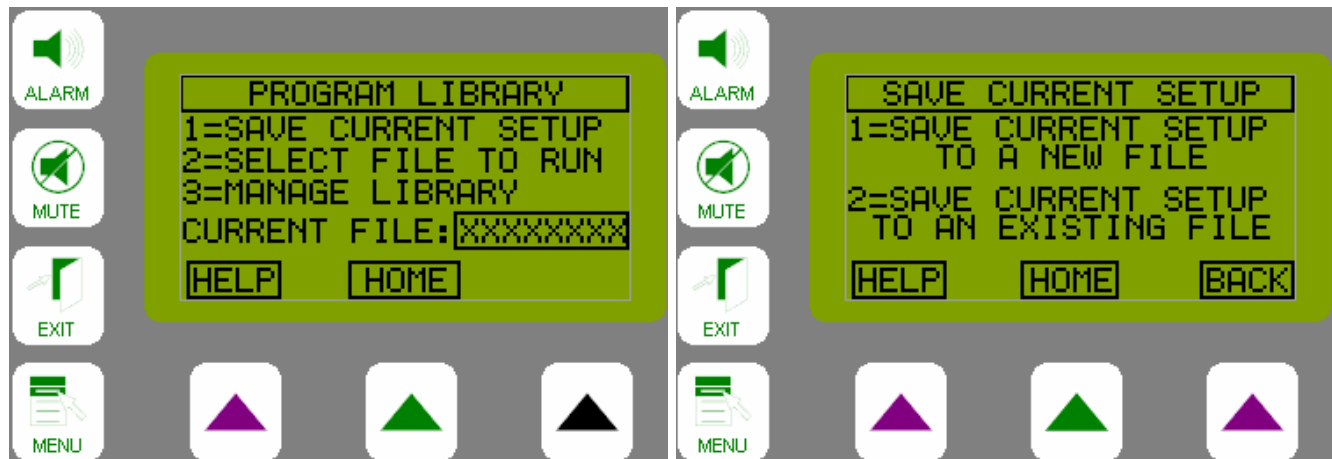
- When you assign the program a name or a code you have up to *eight* characters to use for your description. The name cannot contain spaces, use a dash or period if a space is necessary.
- When you load a program in the Machine it will load the Electronic setting only. The mechanical adjustments (Film roll locations) must still be done by the operator.
- The number of programs you can enter is almost unlimited, each file is roughly 1KB and the standard flash card size is 16MB.

**NOTE: Read the help located on the screens for direct assistance while using this feature.**

To **SAVE** a setup, follow these steps.

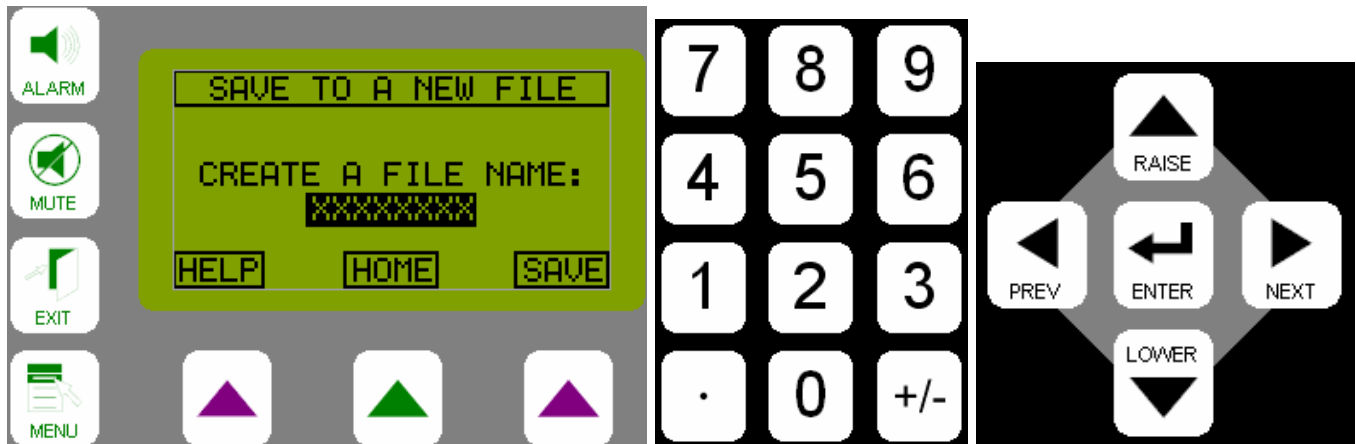
**Step 1:** Press number 1 on the keypad.

**Step 2:** If number 1 is pressed for Save Current Setup, the Save Current Setup screen will appear. On this screen, choose a save method.

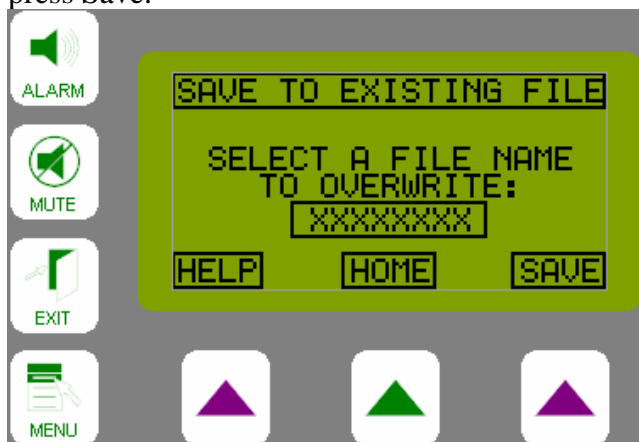


## Save Setups Cont'd

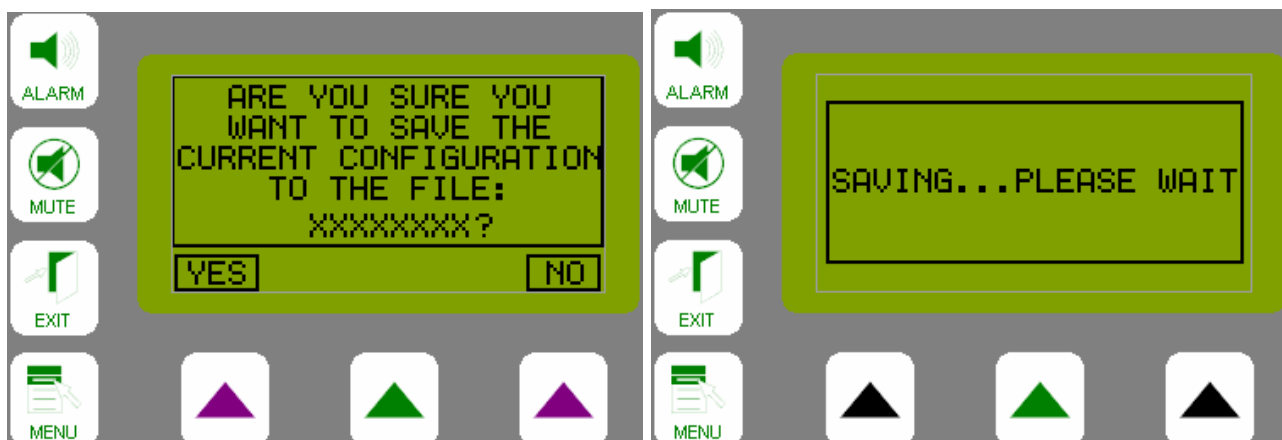
**Step 3:** If the setup is to be saved as a new name, the following screen will appear. Enter a name, press ENTER and then press the button below the SAVE label to initiate the save. NOTE; a name must be entered, limited to 8 characters, no spaces, and the file name must be different than one already in the library. When the save process is complete, the Please Wait screen will disappear.



If the setup is to replace a currently saved file, use the up/down arrows to scroll to the desired name and press Save.



The following confirmation screens will show for the save process.

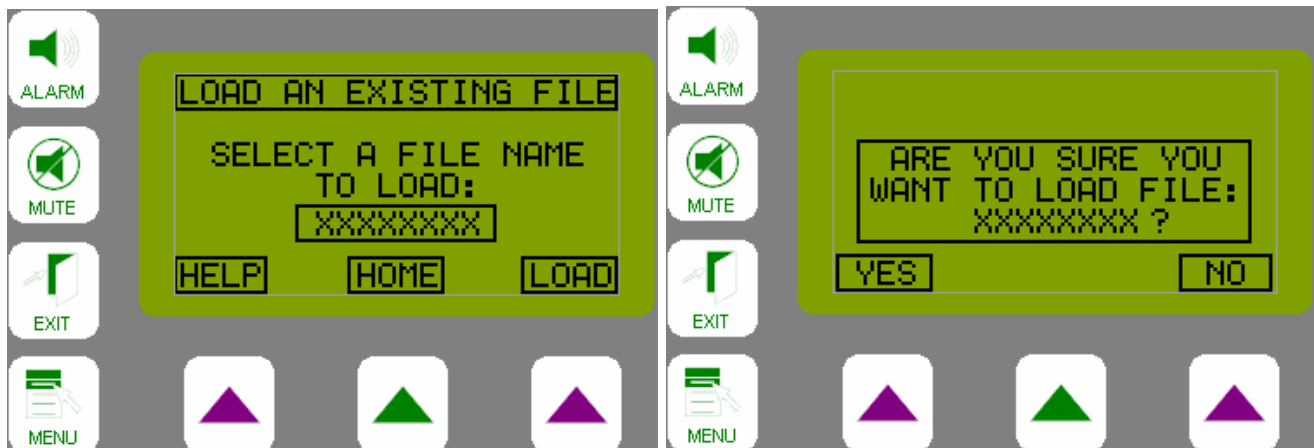
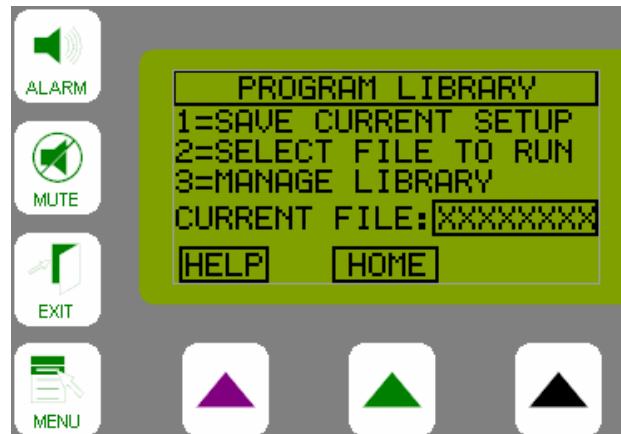


To **LOAD** a setup, follow these steps.

**Step 1:** Press number 2 on the keypad for Select File to Run.

**Step 2:** If number 2 is pressed, the Load Existing File screen will appear. On this screen, press the up/down arrows to scroll to the desired file to load and press the button under the LOAD label.

**Step 3:** After confirming the action, the loading process screen shows. The Please Wait screen will disappear when load is complete.



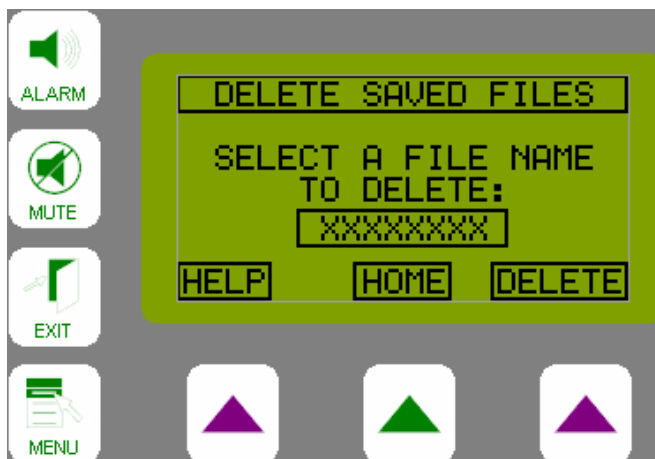
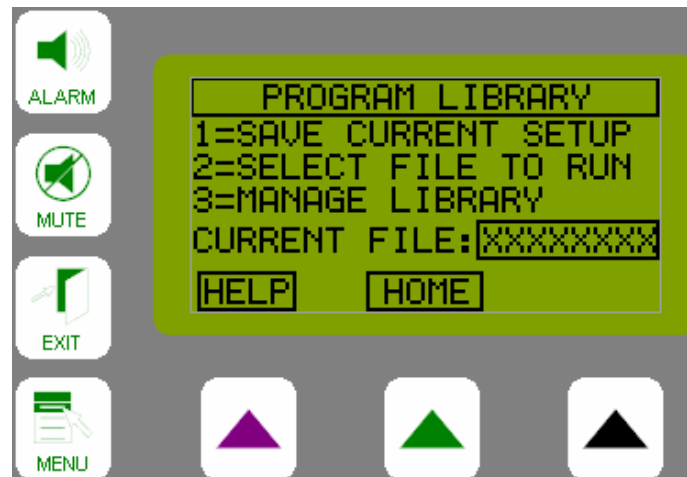


To **DELETE** a setup, follow these steps.

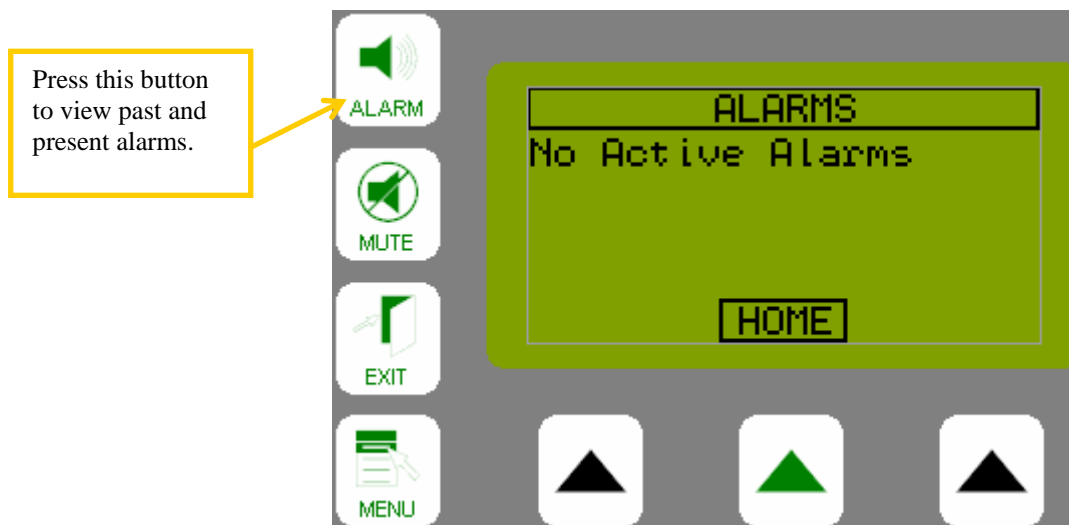
**Step 1:** Press number 3 on the keypad for Manage Library.

**Step 2:** If number 3 is pressed, the Delete Saved Files screen will appear. On this screen, press the up/down arrows to scroll to the desired file to delete and press the button under the DELETE label. NOTE; the Master file cannot be deleted.

**Step 3:** After confirming the action, the file will be deleted.



## ERROR SCREENS & SOLUTIONS



If an error occurs that triggers an alarm, the screen will flash a message saying what the error is. Press the alarm button to view a list of the current and past alarms. Once the error is fixed, RESET will clear the error. If the error is acknowledged, it will go away from the list. If not, the message will remain for future reference. (The error cannot be acknowledged in OPERATOR level).

Below is a list of the errors that might show, along with ways of correcting the problem.

**Machine Estop** – This is a general error caused by an estop button being pushed or film jam. Pull out estop buttons or clear film jam at film unwind (dancer bar full up). Estop circuit is OK if Reset light is lit.

**Guard Open** – The main guard door is open while trying to run. Check wiring to input 6.

**Scrap Winder** – Scrap tail has broken. Increase scrap timer value if scrap is not broken. Check function of dancer arm switch (input 9).

**Film Clamp** – The jaws have closed on an object before over-ride prox is made. Check that the 4 safety switches are held closed by the trip dog. Adjust safety over-ride prox down to pick up seal bar sooner. Check wiring to input 8.

**Jaw Close** – Check that air is supplied to machine. Check wiring to input 8.

**Jaw Open** – Check that air is supplied to machine. See that reed switch on actuating cylinder is lit green with seal bar full open. Check wiring to input 7.

**Closure Retract** – Check that air is supplied to machine. See that reed switch on extending nose of conveyor is lit green when nose is retracted. Check wiring to input 11.

**AC Drive** – Under or Over Voltage has occurred. Check belt tension. See that drive line breakers are OK.

Texwrap recommends the following maintenance schedule.

**Recommended Maintenance Schedule:**

*Daily:*

1. Check the silicon pad beneath the seal bars for wear. Replace if necessary.
2. Check conveyor belts for proper tension and tracking.
3. Look under and inside conveyors for any scrap bags. Remove and discard.
4. Using a dry cotton cloth, rub cross seal and side seal blades clean – do not use any solvent.

*Weekly:*

1. Clean film residue off of film drive roller, suggest rubbing alcohol.
2. Wipe down the conveyor belts, *Simple Green* cleaning solution works well.
3. Clean air filtration unit, empty of moisture.

*Monthly:*

1. Check all chain drives for proper tension and lubricate.
2. Wipe down machine completely.
3. Take out electrical cabinet air cleaners and wash. More often as needed.
4. Go over any film-to-metal contact surface with 400 grit sandpaper, smooth looking surfaces cause high drag on the film.
5. Grease all bearings that have grease fittings. If it is noticed that these bearings are needing grease before this time period (possibly used in a harsh environment), apply a single pump into each zerk. Use multi-purpose Polyurea grease.
6. Lightly grease ACME thread shafts and inverter adjuster thread shafts with same Polyurea grease.
7. Oil rocker rod ends and main air cylinder clevis pin with light oil.

## CONVEYOR BELT TRACKING

A daily glance at the conveyor belts for proper tracking is recommended. Sometimes a change in product size or weight can cause shifts in belt tracking. If any of the belts have drifted to the edge of the conveyor, adjustments are necessary. If the machine runs with an untracked belt it will eventually destroy the belt causing poor machine operation.

### **Adjust Belt Tracking as follows:**

Locate the two 1/4-28x3 SHCS (allen head) tracking screws. (Look for half circle notches in top or ends of conveyor guards). Turn the screw 1/4 turn and wait for the belt to settle as conveyor runs full speed. The key is to make small moves so tracking does not get out of hand.

**If the belt does not track with the above procedure, or if any work has been done in which the conveyor side plates have been removed, do the following:**

Firstly, remove the slack in the belt with equal turns to both adjusting screws. Slack has been removed when belt does not slip over drive roller with a hand on the belt. Adjust tension screws 3 full turns, increasing the tension. Let the drive roller bearings equalize by loosening their mounts. After this adjustment, retighten bearings where they align to. Tighten adjusting screws an additional complete turn. Now proceed with tracking the belt following the previous paragraph on belt tracking.

## **Film Clamp Safety**

The “Film Clamp Safety” is designed to protect the operator from accidental injury during normal operating procedures. When the film clamp safeties are properly set the seal head will instantly retract if it comes into contact with any object during the sealing cycle. The film clamp safety must be set-up and tested by a qualified service technician or a properly trained operator. Testing of the film clamp safety should be done daily and anytime any changes are made to the machine to make sure they are in proper adjustment.

Each Texwrap sealer machine is shipped with a “Safety Tester” (Part # 80-SAFETYTEST) this is used to properly set-up and test the film clamps. The film clamps should always be tested before the machine is to be operated. **THIS INCLUDES NEW EQUIPMENT JUST ARRIVING FROM TEXWRAP.** Shipping vibration could affect the settings.



Safety Tester (80-SAFETYTEST)



(Illustration #1)



(Illustration #2)



(Illustration #3)

## **Testing Procedure**

1. With the machine properly locked out, place the safety tester approximately 6 inches from the either end of the seal pad and between the cross seal jaw with the yellow tab on the exit side of the jaw. (see illustration #1) This will insure that the photo eyes are not blocked. When the jaws close they should close on the widest portion of the tester (see illustration #2).

2. With the tester in place remove the lock out, press the reset button and simulate a manual seal. **TO AVOID INJURY DO NOT HOLD THE TESTER IN PLACE WITH YOUR HANDS OR FINGERS DURING THE SEAL CYCLE.** When the machine attempts to cycle, the seal head should instantly open upon striking the safety tester and the machine should go into an e-stop mode. If the jaws do not instantly open then the film clamps are **not** set properly and need to be adjusted until the seal head instantly retracts. This protects the operator and the product. Repeat this procedure on the side seal jaw (see illustration #3).



(Illustration #4)

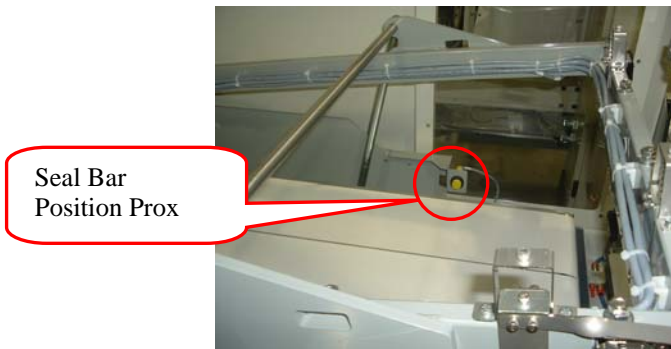


(Illustration #5)

3. With the tester removed, simulate a manual seal. If the seal head closes and stays closed for the designated seal time (see illustrations 4 & 5) then the film clamps are set correctly.
4. This procedure should be repeated in 6" intervals on both cross and side seal film clamps.

## **Adjusting the Film Clamp Safety Switches**

- Step 1** Remove air from the machine by turning the air dump valve clockwise.
- Step 2** Close the seal bars until the film clamps are resting on the seal pad. (The entire cross and side film clamps must be evenly in contact with the pad).
- Step 3** Adjust the seal bar position prox until there is approximately 1/16<sup>th</sup> of an inch between the prox and the bottom jaw rail (see illustration #7).

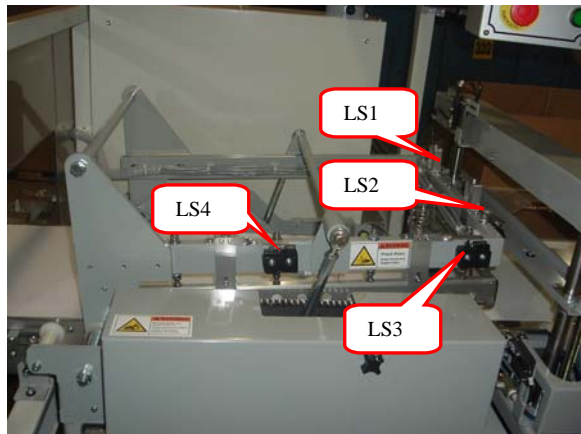


(Illustration #6)



(Illustration #7)

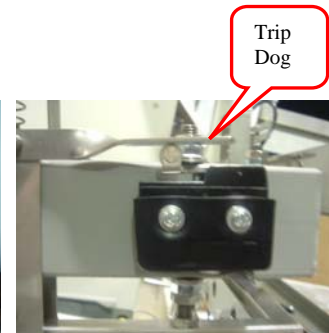
- Step 4** Loosen the bolts on the seal bar position prox bracket (see illustration #7) and pull the bracket up 1" past where the indicator light goes off.
- Step 5** With the film clamps still resting on the seal pad lower the prox bracket until the prox indicator light comes on.
- Step 6** Tighten the prox bracket in place and open the seal jaw.



(Illustration #8)



(Illustration #9)



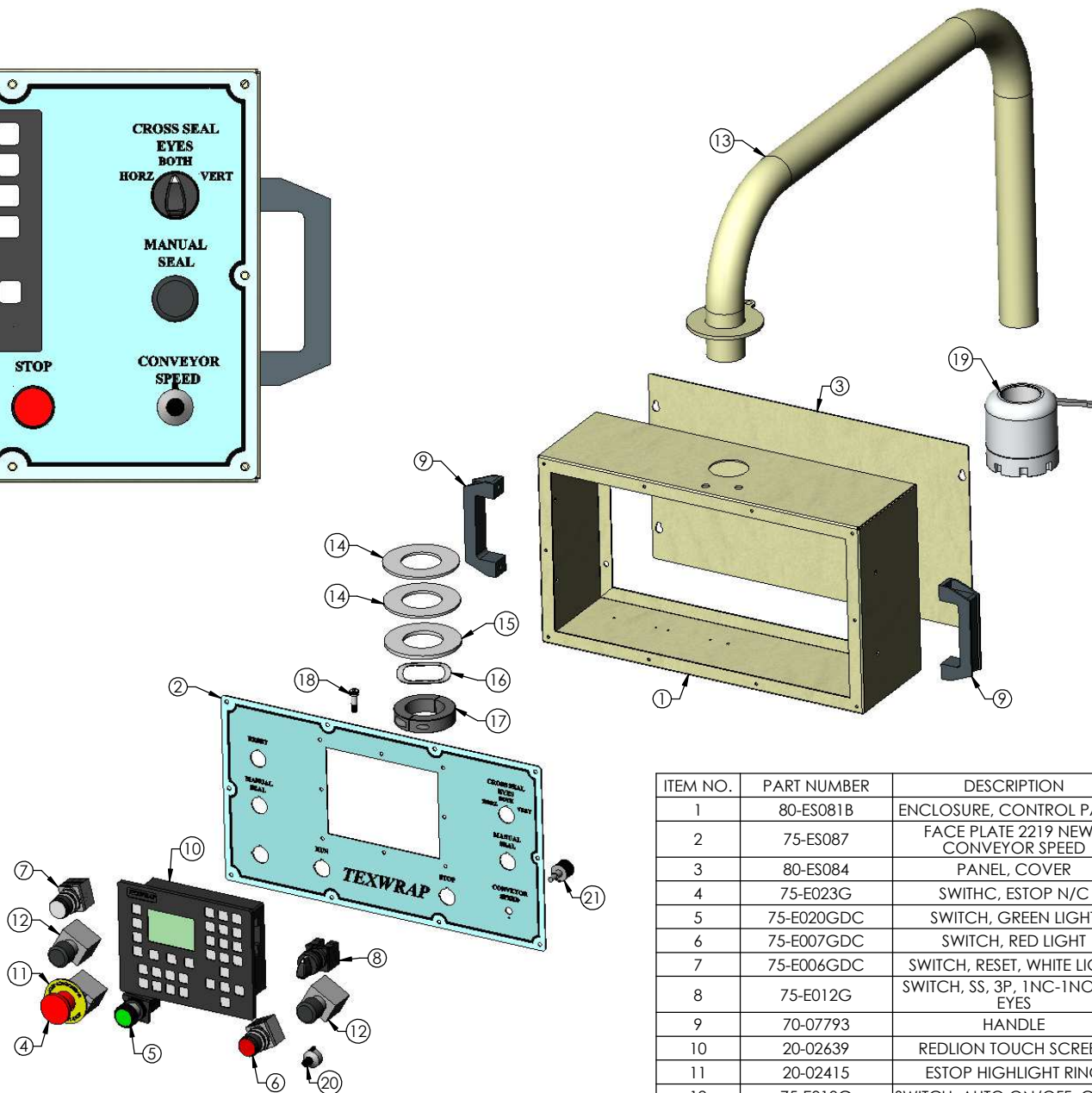
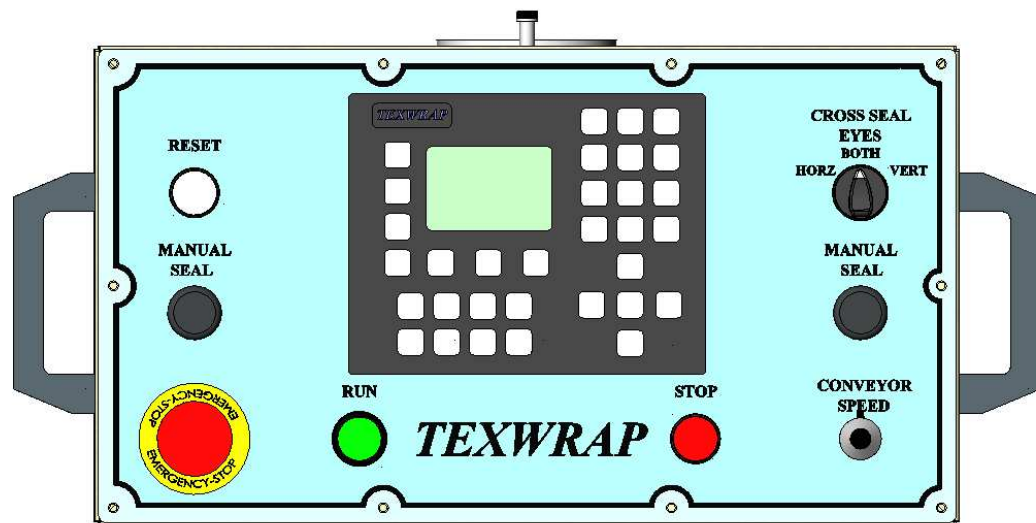
(Illustration #10)

- Step 7** Adjust the trip dog on LS4 down so that it holds the limit switch lever down against the switch housing (see illustration #9). Do not over adjust to the point that the film clamp lifts off the seal pad.
- Step 8** Adjust LS 1, 2 & 3 trip dogs downward approximately 3/32 of an inch past the point where the switch engages (see illustration #10). You will here the switch trip when it engages.
- Step 9** Turn the air back on to the machine and reset the machine. The reset light should go out.
- Step 10** With the tester in place, press the reset button and simulate a manual seal. **TO AVOID INJURY DO NOT HOLD THE TESTER IN PLACE WITH YOUR HANDS OR FINGERS DURING THE SEAL CYCLE.** When the machine attempts to cycle, the seal head should instantly open upon striking the safety tester and the machine should go into an e-stop mode. If the jaws do not instantly open then the film clamps are **not** set properly and need to be adjusted until the seal head instantly retracts. One or more of the following conditions could apply:
- Check the film clamp safety switches. They may be set too low and not tripping when they should.
  - Also check the seal bar position prox, it may be set too low and activating before the film clamps hit the safety tester.

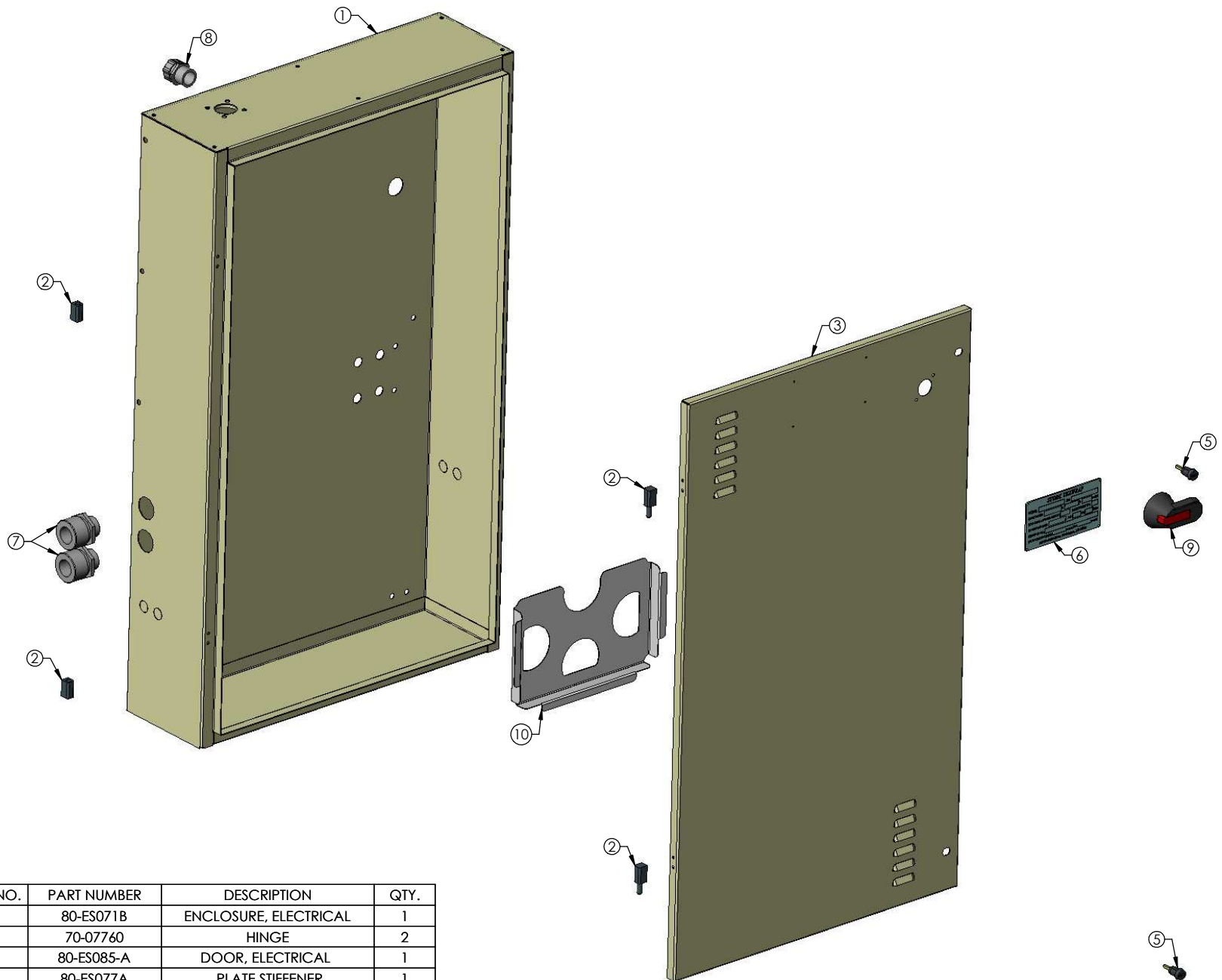
## **CAUTION**

If the problem continues **DO NOT OPERATE THE MACHINE** contact your Texwrap distributor.

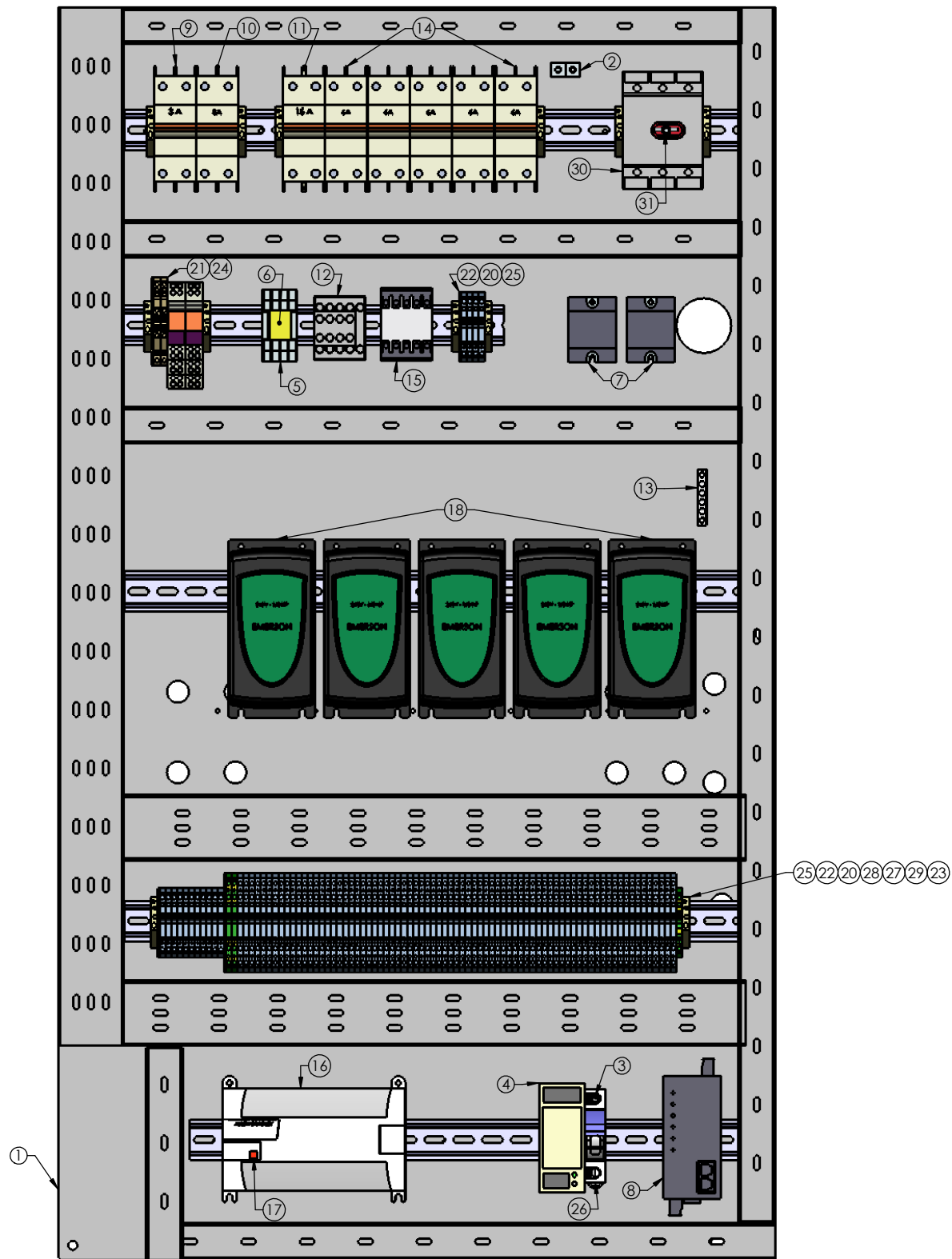




ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	80-ES081B	ENCLOSURE, CONTROL PANEL	1
2	75-ES087	FACE PLATE 2219 NEW - CONVEYOR SPEED	1
3	80-ES084	PANEL, COVER	1
4	75-E023G	SWITHC, ESTOP N/C	1
5	75-E020GDC	SWITCH, GREEN LIGHT	1
6	75-E007GDC	SWITCH, RED LIGHT	1
7	75-E006GDC	SWITCH, RESET, WHITE LIGHT	1
8	75-E012G	SWITCH, SS, 3P, 1NC-1NO, CS EYES	1
9	70-07793	HANDLE	2
10	20-02639	REDLION TOUCH SCREEN	1
11	20-02415	ESTOP HIGHLIGHT RING	1
12	75-E010G	SWITCH, AUTO ON/OFF, GREEN	2
13	80-ES109	ARM, CONTROL PANEL 2219	1
14	75-ES108	FRICTION SPACER, UHMW	2
15	80-ES110	PLATE, PANEL MOUNT	1
16	70-07935	SPRING, WAVE DISK 2.057" ID	1
17	40-04331	CLLR, SET, 1.938" B , 2 PC, BO	1
18	70-07984-250	SHOULDER BOLT, 5/16 OD X 1/2"	1
19	80-ES183	ASSY, CONTROL ARM SWIVEL, 1.9"OD TUBE	1
20	20-02107	KNOB, POTENTIOMETER	1
21	20-02429	POTENTIOMETER, 2K - 5 TURN	1

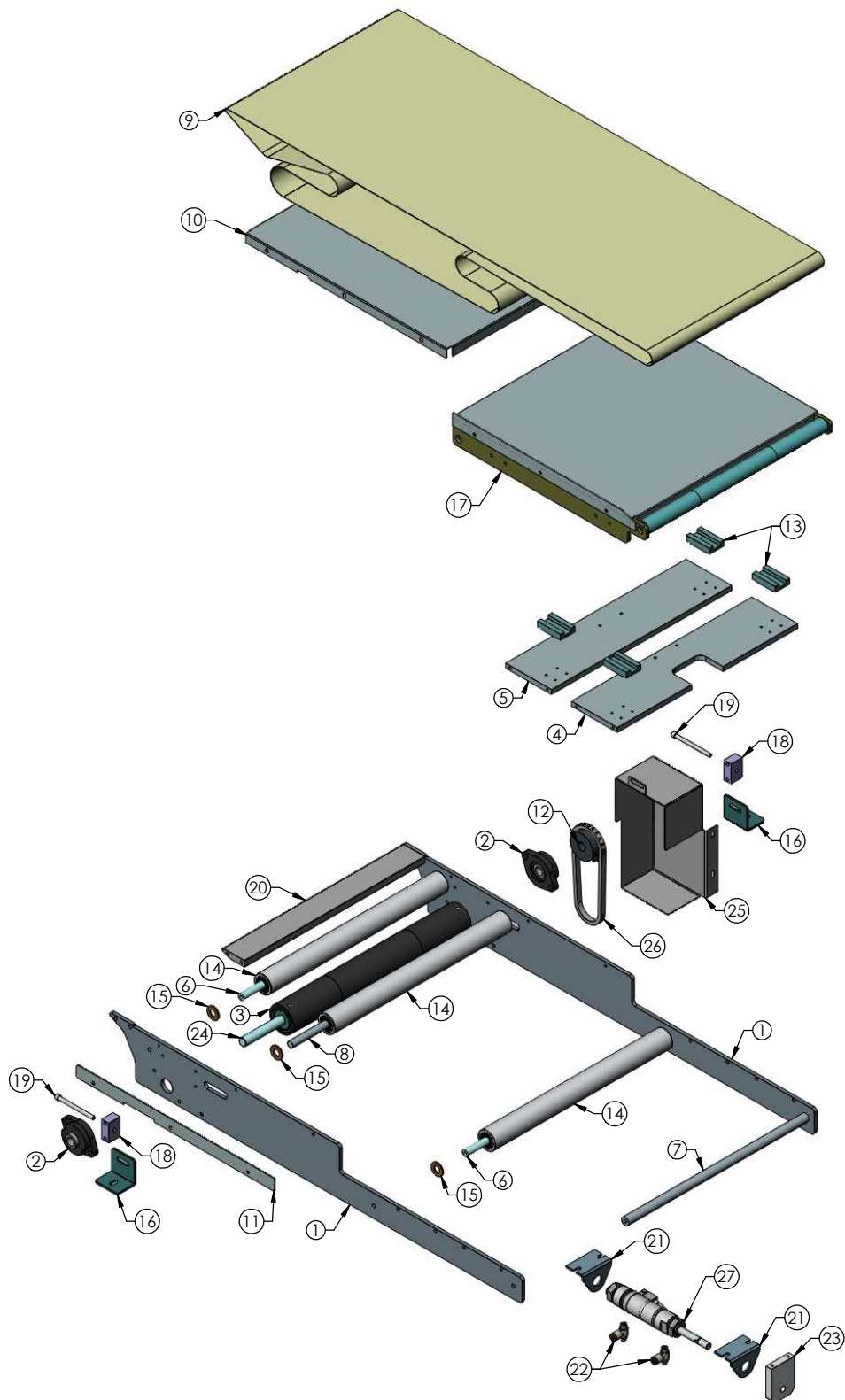


ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	80-ES071B	ENCLOSURE, ELECTRICAL	1
2	70-07760	HINGE	2
3	80-ES085-A	DOOR, ELECTRICAL	1
4	80-ES077A	PLATE STIFFENER	1
5	70-07761	LATCH, 146 ENCLOSURES	2
6	20-00290A	NAME PLATE/ POWER OUTPUT	1
7	20-02354	CORD RESTRAINT, 1.25", ALUMINUM	2
8	20-02246	RESTRAINT, 1"	1
9	20-20058-12	HANDLE, DISCONNECT	1
10	80-EES060	PRINT POCKET	1



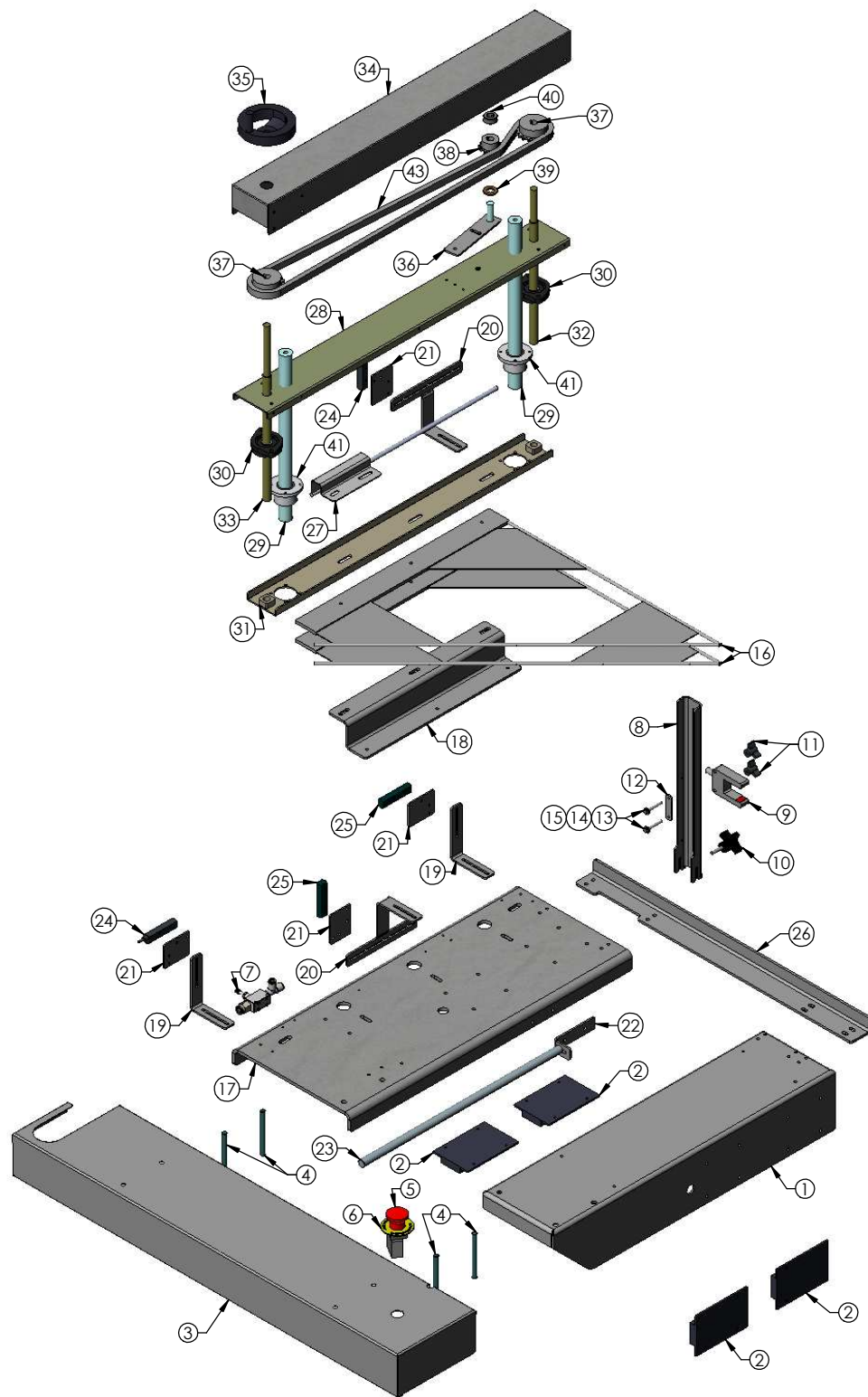
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	80-ES073-B	SUB PANEL, 2219 AC STYLE	1
2	20-02033	GROUND LUG ALUMINUM	1
3	20-02086	FUSE, 3A, 600V, ATDR	1
4	20-02156UL	POWER SUPPLY, 24VDC	1
5	20-02166	SOCKET, RELAY (4PDT)	1
6	20-02164	RELAY, (4PDT)	1
7	20-02184	RELAY, SOLID STATE, 24VDC 10A	2
8	20-02277	CONTROL, TEMPERATURE MODULE	1
9	20-02487	CIRCUIT BREAKER, 2 POLE, 3 AMP, UL LISTED	1
10	20-02488	CIRCUIT BREAKER, 2 POLE, 8 AMP, UL LISTED	1
11	20-20089	CIRCUIT BREAKER, 2 POLE, 15 AMP, UL LISTED	1
12	20-02594-S	RELAY, SAFETY CONTROL 24VDC 6NO x 2NC	1
13	20-02610	ALUMINUM LUG, GROUNDED BAR	1
14	20-02664	CIRCUIT BREAKER, 2 POLE, 6 AMP, UL LISTED	5
15	20-02693	CONTACTOR, SEAL HEATER	1
16	20-02760	MICROLOGIX 1200	1
17	20-02761	PLC, MLX 1200, MEMORY MODULE	1
18	20-02863	DRIVE, AC VECTOR, EMERSON, 1/3HP	5
19	20-02922	RELAY, BASE AND SOCKET	2
20	20-02926	TERMINAL BLOCK, BLUE 2 P	15
21	20-02928	TERMINAL BLOCK DIODE	2
22	20-02929	END PLATE, TERMINAL BLOCK	2
23	20-02931	TERMINAL BLOCK GROUND	1
24	20-02932	DIODE END PLATE	1
25	20-02933	TERMINAL BLOCK, END BRACKET	12
26	20-02934	FUSE HOLDER, 1-POLE 30A, 600V, CC IL	1
27	20-02947	TERMINAL BLOCK, BLUE 4 P	75
28	20-02948	END PLATE, TERMINAL BLOCK	1
29	20-02981	TERMINAL BLOCK, GROUND 4-POLE	2
30	20-20056-30	DISCONNECT, 30 Amp	1
31	20-20059-210	SHAFT, EXTENSION	1

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	80-OC050	SIDE PLATE (FRONT)	2
2	40-00401	5/8" FLANGED BEARING	2
3	75-IC032GA-A	ROLLER, DRIVE	1
4	80-CC042A-A	CYLINDER SUPPORT BAR -B	1
5	80-CC041A-A	CYLINDER SUPPORT BAR -A	1
6	80-IC027GA	IDLER AXLE	2
7	80-OC014GA	SUPPORT SHAFT	1
8	80-OC053	AXLE, ADJUSTING	1
9	50-05659	BELT, TRANSFER CLOSURE	1
10	80-OC051	DECK, FIXED	1
11	80-OC052	GUIDE, EXTENDED CLOSURE	1
12	10-00137	SPKT, CHN, 35B20, 0.625" B, KSS	1
13	40-04010	BEARING, SLIDER	4
14	80-IC031C	ROLLER, IDLER STRAIGHT W/ BEARINGS	3
15	40-00425	1/2" THRUST WASHER	6
16	80-OC034C	CONVEYOR FOOT	2
17	SLIDING DECK	SEE PAGE 2	1
18	80-IC017G-A	ADJUSTING BLOCK	2
19	50-05612	1/4-28 X 3" SHCS	2
20	80-OC054	NOSE BAR, OUTFEED CONVEYOR	1
21	60-00637	AIR CYLINDER BRACKET	2
22	60-00610	1/4" HOSE, 1/8" NPT FLOW CONTROL	2
23	80-CC025G	PISTON BRACKET	1
24	80-IC050A	AXLE, DRIVE	1
25	80-MF041	EXIT CONVEYOR CHAIN GUARD	1
26	10-00109-43	CHAIN, #35, 43 LINKS 1 MASTER LINK	1
27	60-06781	CYLINDER, AIR, 1.25 BORE 1.50 STROKE	1

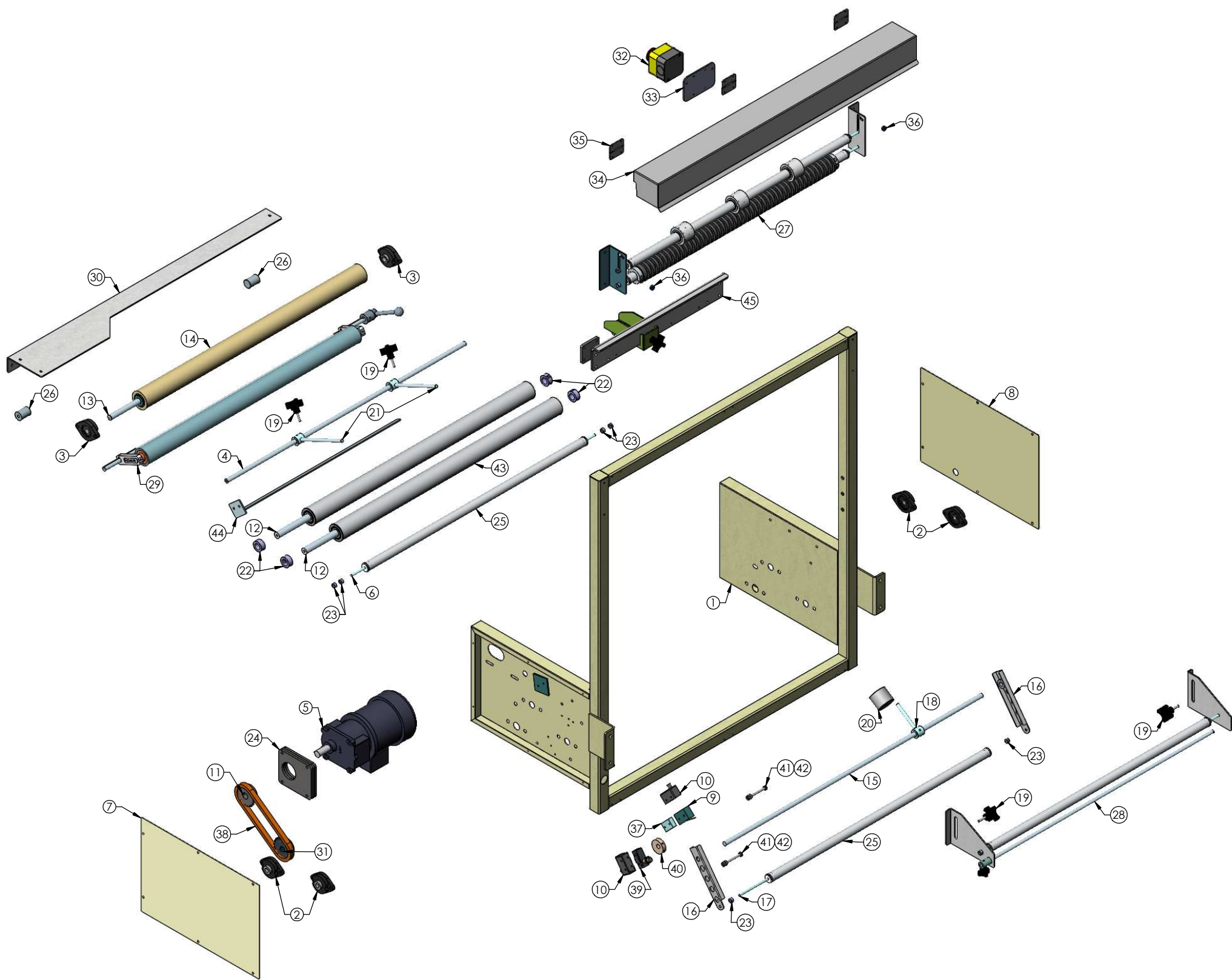






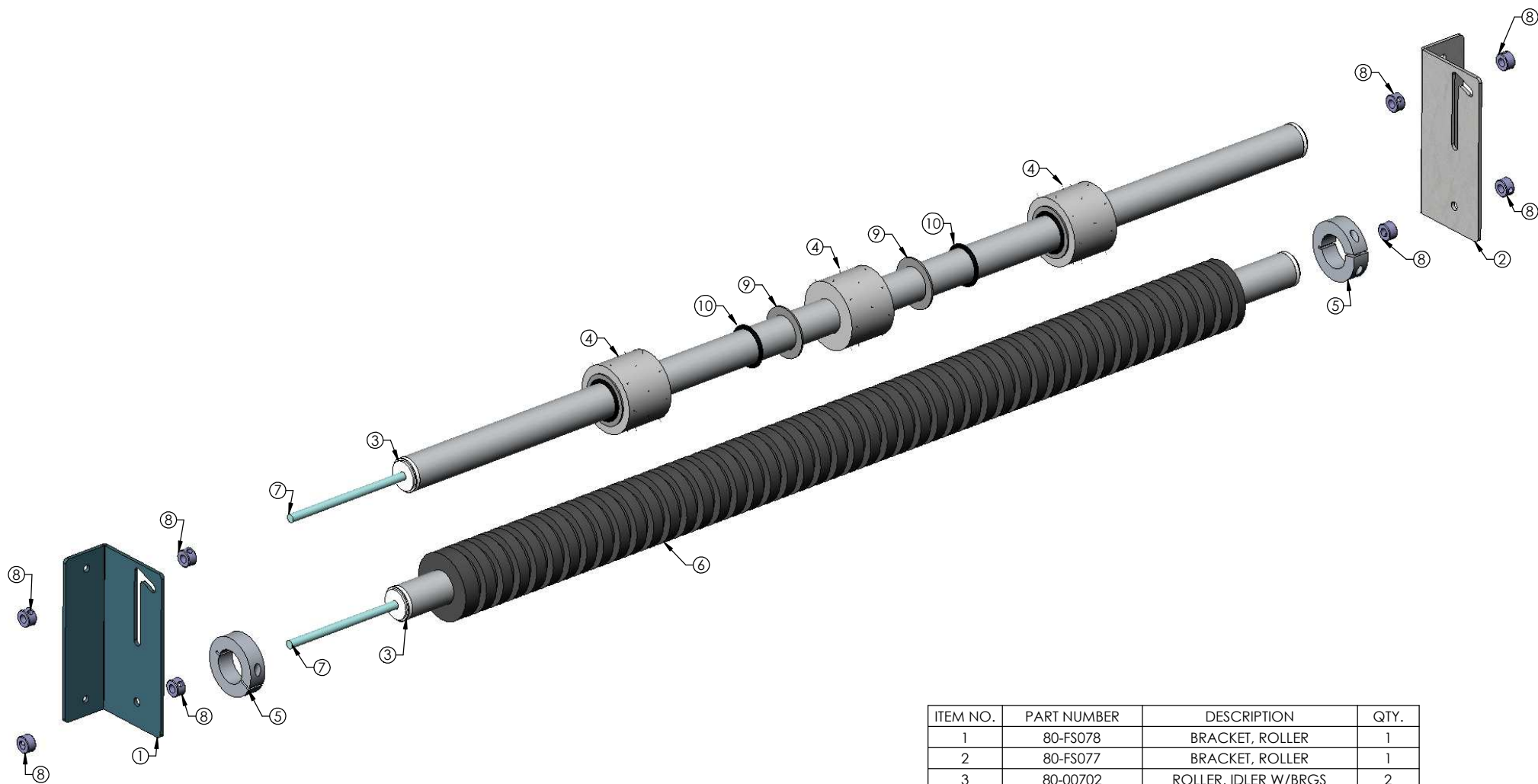


ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	80-FA027C-A	FRONT INFEED SLIDE PLATE	1
2	40-00427	BRG, SLIDE, ASSY, 2-PAD, 700MM, THK	4
3	80-FA047A-B	SIDE COVER, 2219	1
4	80-FA028G	COVER STUDS	4
5	75-E021G	E-STOP, RED MUSHROOM, RETAIN, INC	1
6	20-02415	ESTOP HIGHLIGHT RING	1
7	60-06720	ASSEMBLY, NEEDLE VALVE	1
8	80-ACC06-2	BRACKET, VERTICAL SLIDING	1
9	20-02584	SENSOR, FILM REGISTER	1
10	30-00301	KNOB, 1/4-20, MALE	1
11	30-00320	KNOB, FEMALE - #10-32	2
12	80-ACC200	PLATE, SENSOR NUT	1
13	BOLT	#10-32 HHCS X 1.5"	2
14	#10SS FLAT	WASHER	2
15	LOCK WASHER	#10 SS LOCK WASHER	2
16	80-FA023A	FORMER, FILM	2
17	80-FA038C-B	REAR INFEED SLIDE PLATE	1
18	80-FA024A	CHANNEL, Z	1
19	80-FA031G	BRACKET, EYE	2
20	80-FA003C	BRKT, PHOTO EYE	2
21	80-FA001G	PLATE, PHOTO EYE	4
22	80-FA039C	STOP BRACKET	1
23	80-FA042C	SLIDE SHAFT	1
24	20-02109	PHOTO-EYE DETECTOR/RECIEVER	2
25	20-02108	PHOTO-EYE EMITTER	2
26	80-FA026C-A	JOINT BAR	1
27	80-FA088	WELDMENT, FILM LIFTING BAR	1
28	80-FA022A	PLATE, FA ADJ MOUNTING	1
29	80-FA016A	SHAFT	2
30	40-00400	BEARING, 1/2" PEER, FLANGED	2
31	80-FA019A	PLATE, ADJUSTING	1
32	80-FA004G	SCREW SHAFT (REAR)	1
33	80-FA005G	SCREW SHAFT (FRONT)	1
34	80-FA012A	COVER	1
35	80-FA305G	HANDLE ASSEMBLY FOR FILM ADJ	1
36	80-FA011G	BRACKET, TENSION	1
37	10-00110	SPKT, CHN, 35B20, 0.500" B, KSS	2
38	10-00131	SPROCKET, 1/2"BORE 12T	1
39	40-00425	1/2" THRUST WASHER	1
40	40-00420	CLLR, SET, 0.500" B , 1 PC, ZP	1
41	80-FA018G	BEARING HOUSING	2
42	40-00426	BEARING	2
43	10-00109-159	CHAIN, ADJUSTER	1

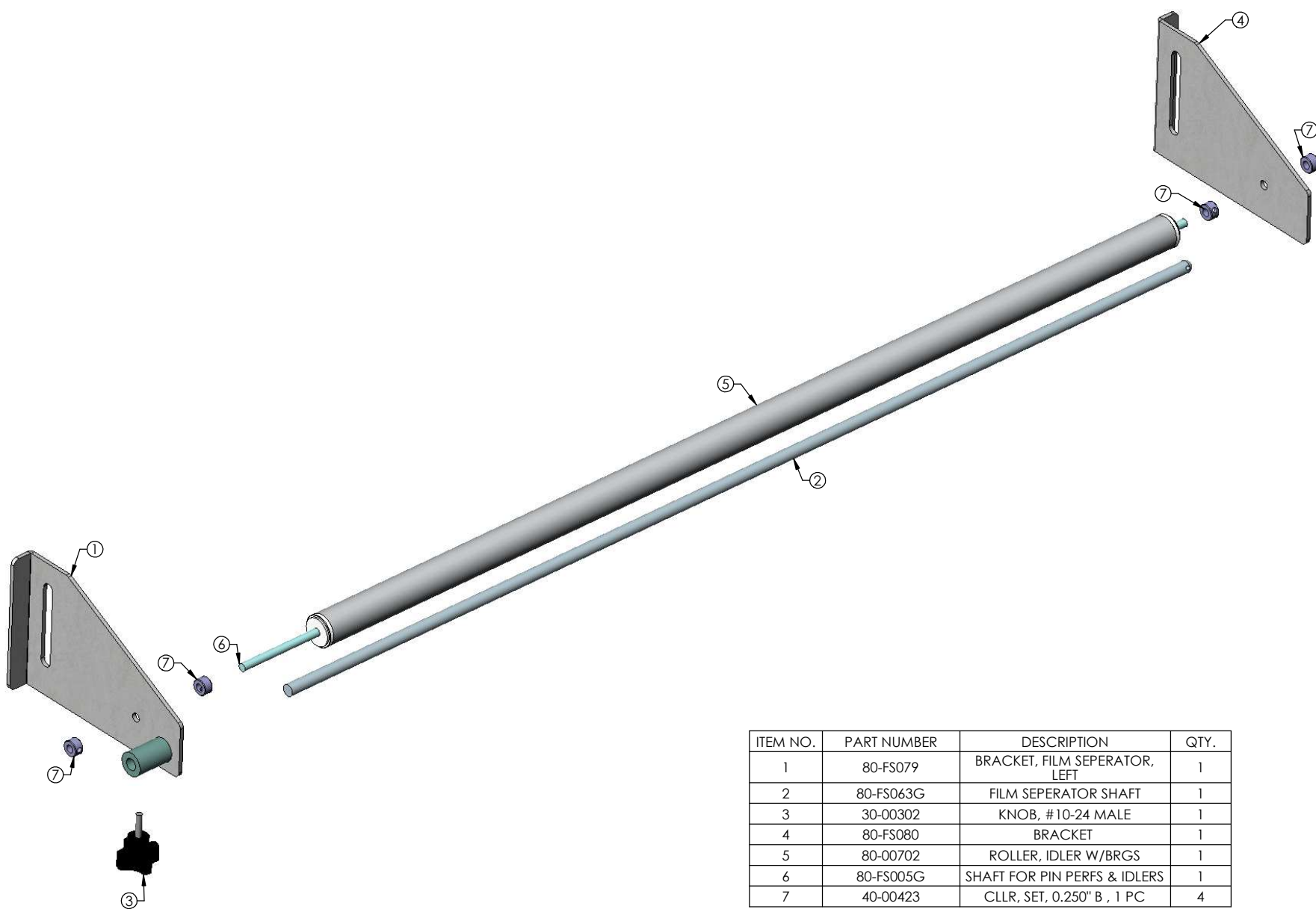


ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	80-FS087	FILM STAND FRAME	1
2	40-00400	BEARING, 1/2" PEER, FLANGED	4
3	40-00401	5/8" FLANGED BEARING	2
4	80-FS008G	ROLLER STOPPER SHAFT	1
5	20-02311AC	MOTOR, AC	1
6	80-FS005G	SHAFT FOR PIN PERFS & IDLERS	1
7	80-FS088	COVER, EXIT END	1
8	80-FS090	COVER, ENTRANCE END	1
9	20-00210	MICROSWITCH	1
10	20-02083	COVER, MICROSWITCH (90 Deg)	2
11	10-01173	SPKT, CHN, 35B20, 0.750" B, KSS	1
12	80-FS012G	FILM DISPENSER SHAFT	2
13	80-FS047G	DRIVE SHAFT, 28"W UNWIND	1
14	80-FS024G-A	ROLLER, DRIVE 28" FILM UNWIND	1
15	80-FS021G	IDLER PIVOT SHAFT	1
16	80-FS020C	DANCER BAR SWING ARM	2
17	80-FS016G	IDLER SHAFT	1
18	80-FS022G	WEIGHT BRACKET	1
19	30-00301	KNOB, 1/4-20, MALE	4
20	80-FS023G	WEIGHT	1
21	80-FS009G	FILM STOPPER	2
22	40-00403	CLLR, SET, 0.750" B , 1 PC, ZP	4
23	40-00423	CLLR, SET, 0.250" B , 1 PC	6
24	80-FS015	MOTOR SPACERS	1
25	80-00702	ROLLER, IDLER W/BRGS	2
26	80-FS084	PIVOT PIN	2
27	PIN PERF SYSTEM	SEE PAGE 3	1
28	HEIGHT ADJUSTER	SEE PAGE 4	1
29	PRESSURE ROLLER	SEE PAGE 5	1
30	80-FS091	MOTOR GUARD	1
31	10-00137	SPKT, CHN, 35B20, 0.625" B, KSS	1
32	20-02595	PUSH-PULL RESET	1
33	80-FS094	PLATE, E-STOP MOUNTING	1
34	80-FS092	COVER, LFS28 PINPERF ROLLER, PAINTED	1
35	70-07712	HINGE	3
36	70-07725	BUMPER	2
37	80-FS031G	MICROSWITCH SPACER	1
38	10-00109-55	CHAIN, LFS28AC	1
39	20-00202	SWITCH, DANCER/ ROLLER TYPE	1
40	80-FS026G	CAM	1
41	BOLT	1/4-28 X 2.5" HHCS	2
42	NUT	1/4-28 HEX NUT	4
43	80-FS004-LONG	ROLLER, FILM CRADLE	2
44	80-FS017G	FILM SEPERATOR BAR	1
45	FILM REGISTRATION	SEE PAGE 6	1

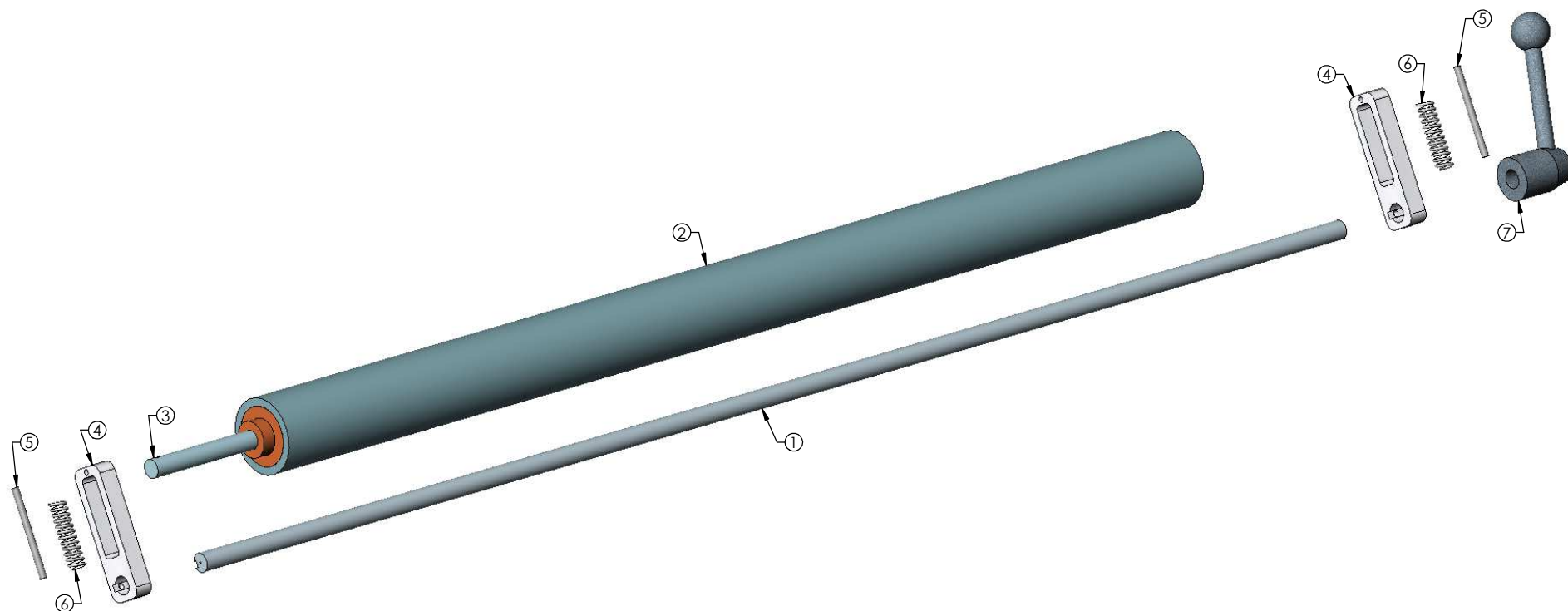




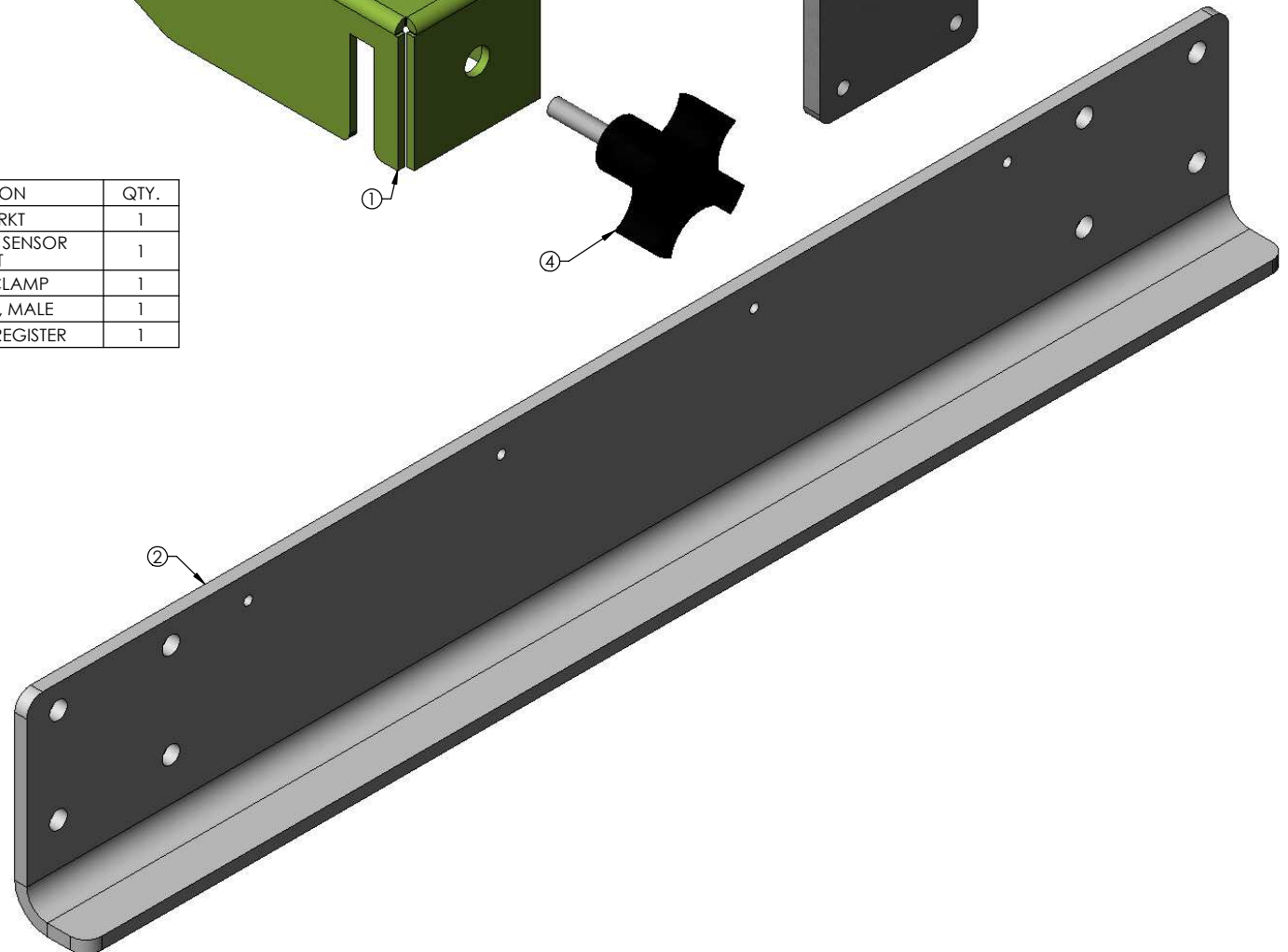
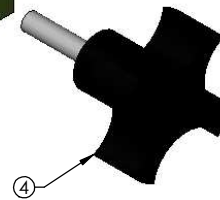
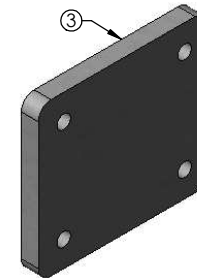
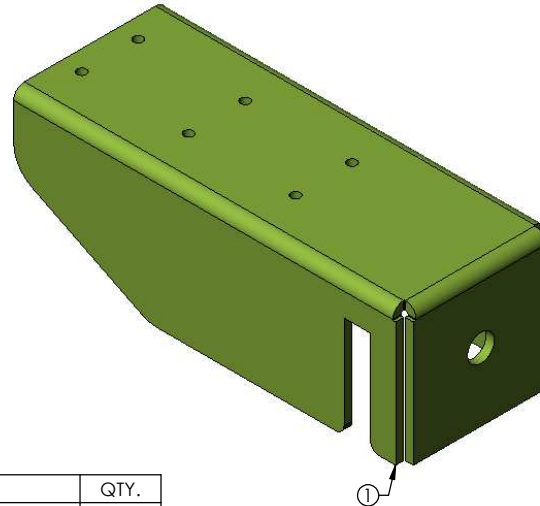
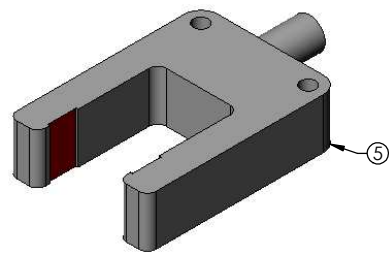
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	80-FS078	BRACKET, ROLLER	1
2	80-FS077	BRACKET, ROLLER	1
3	80-00702	ROLLER, IDLER W/BRGS	2
4	75-FS059G	PIN PERF RING	3
5	40-04032	CLLR, SET, 1.000" B , 1 PC, SPLT, AL	2
6	80-07781-104	BRUSH, PERF BACKUP	1
7	80-FS005G	SHAFT FOR PIN PERFS & IDLERS	2
8	40-00423	CLLR, SET, 0.250" B , 1 PC	8
9	40-00437	BUSHING FILM PERF	6
10	70-00750	O RING FOR FILM STAND	6



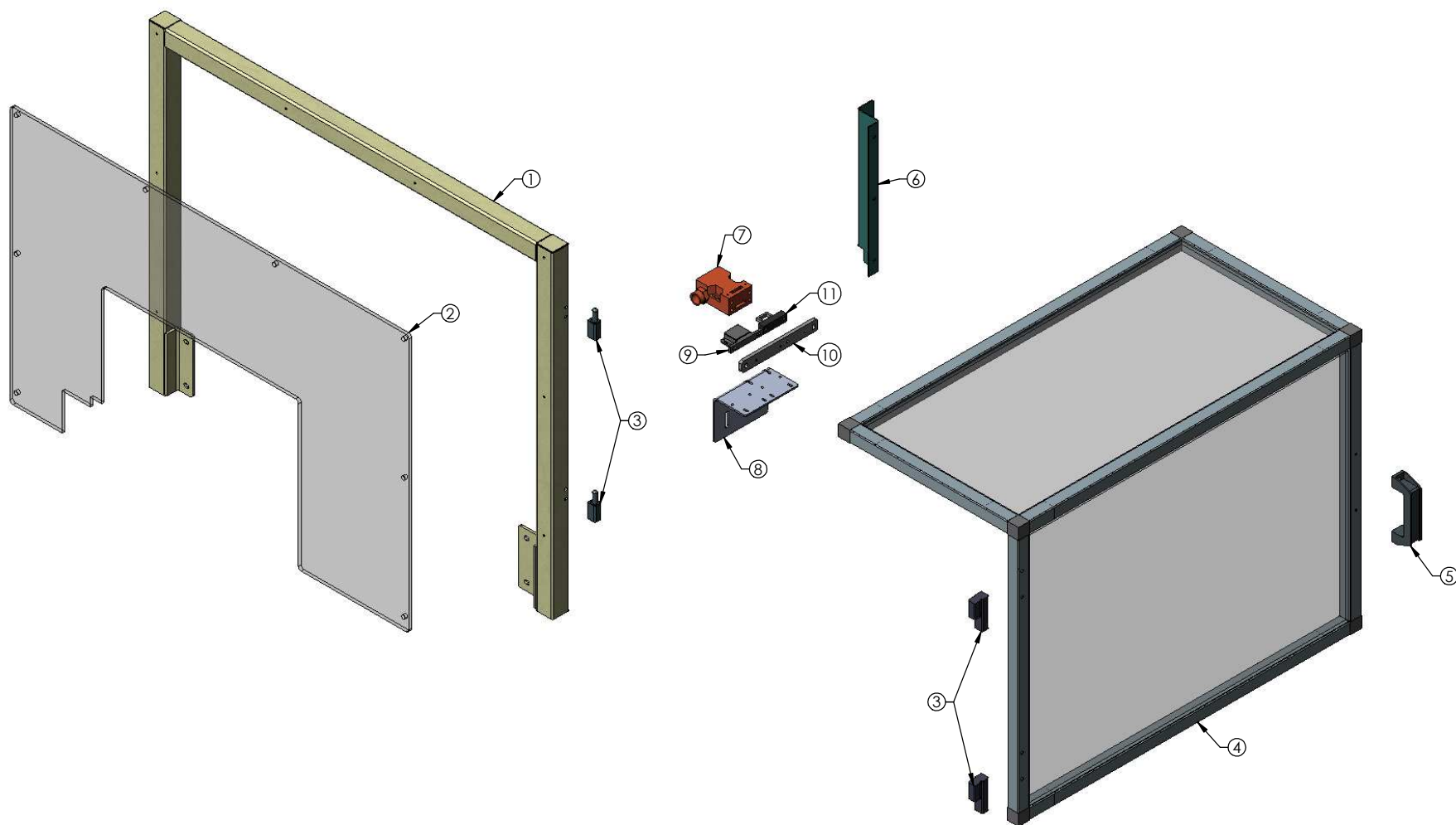
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	80-FS079	BRACKET, FILM SEPERATOR, LEFT	1
2	80-FS063G	FILM SEPERATOR SHAFT	1
3	30-00302	KNOB, #10-24 MALE	1
4	80-FS080	BRACKET	1
5	80-00702	ROLLER, IDLER W/BRGS	1
6	80-FS005G	SHAFT FOR PIN PERFS & IDLERS	1
7	40-00423	CLLR, SET, 0.250" B , 1 PC	4



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	80-FS082	PRESSURE ROLLER PIVOT AXLE	1
2	80-MPU077	ROLLER, DRIVE PRESSURE ASSY	1
3	80-MPU075	PRESSURE ROLLER AXLE	1
4	80-MPUR015	PRESSURE ROLLER ARM	2
5	80-MPUR012	ROD, PRESSURE ROLLER SLIDE	2
6	70-07777	SPRING, COMPRESSION	2
7	30-00300	HANDLE FOR FILM STAND LEVER	1

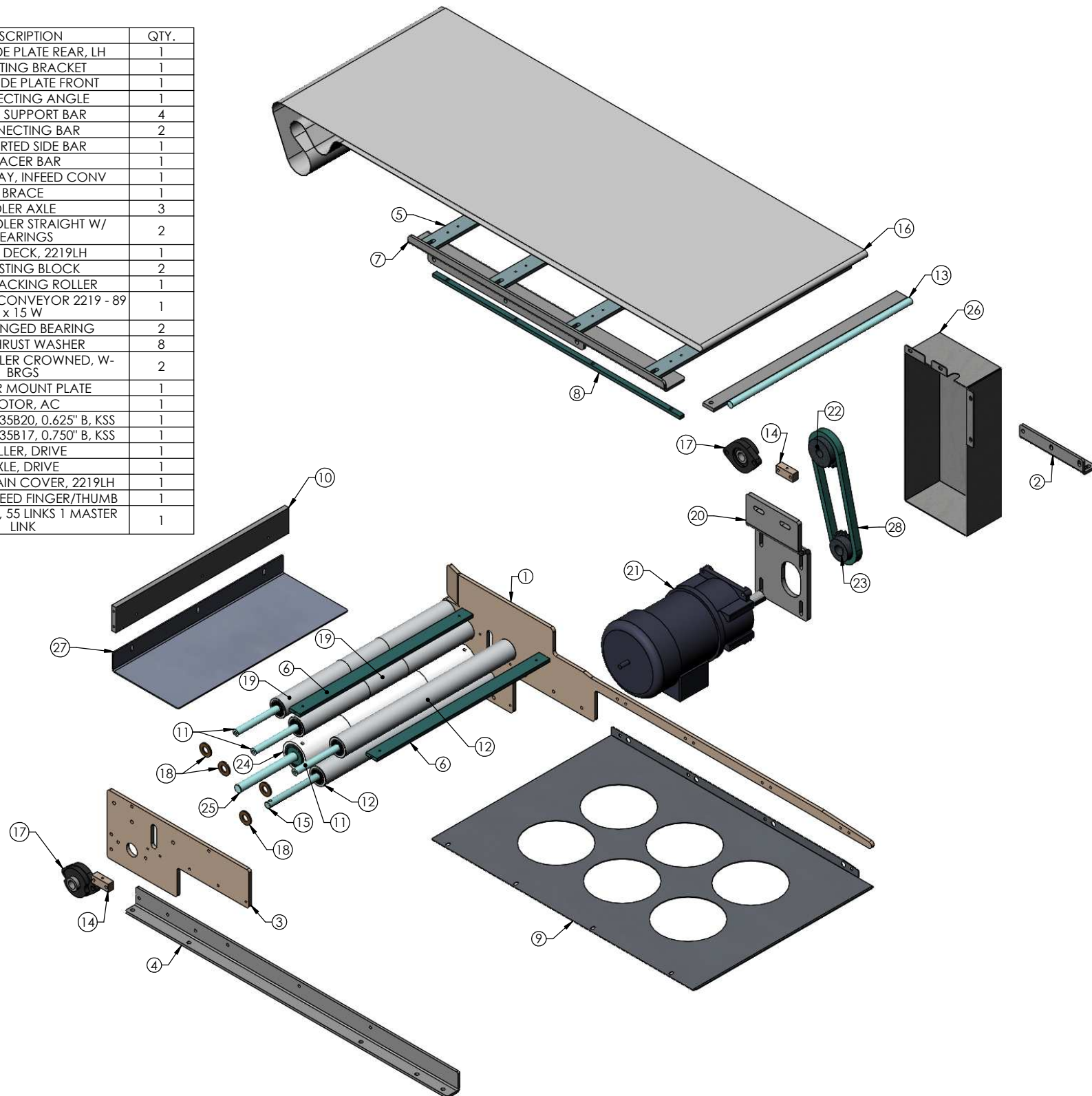


ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	80-FF117-1	SENSOR BRKT	1
2	80-FF116-1	BRACKET ARM, SENSOR MOUNT	1
3	80-ACC07-1	PLATE, NUT CLAMP	1
4	30-00301	KNOB, 1/4-20, MALE	1
5	20-02584	SENSOR, FILM REGISTER	1

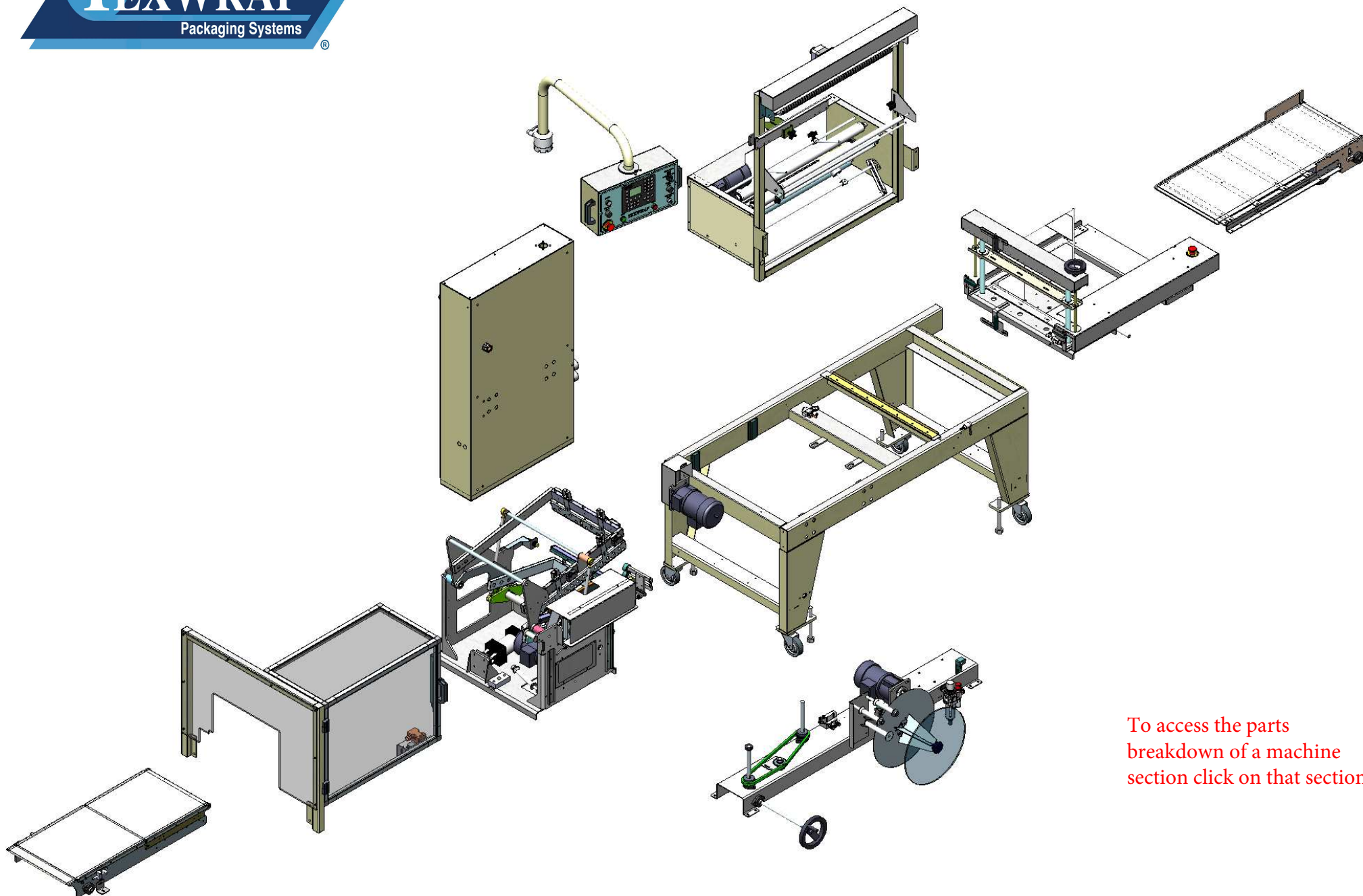


ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	80-GS001E	GUARD DOOR SUPPORT FRAME	1
2	75-GS030A	REAR COVER MACHINE (AC)	1
3	70-07760	HINGE	2
4	75-GS003C	SEAL HEAD DOOR	1
5	70-07793	HANDLE	1
6	80-GS019C-A	GUARD	1
7	20-02306	SWITCH, LEFT SAFETY INTERLOCK	1
8	80-GS028	BRKT, SWITCH MOUNT	1
9	70-07700	LATCH, GRAB	1
10	80-GS048	NUT PLATE, SAFETY SWITCH & LATCH	1
11	20-02306-KEY	SWITCH KEY, (INTERLOCK)	1

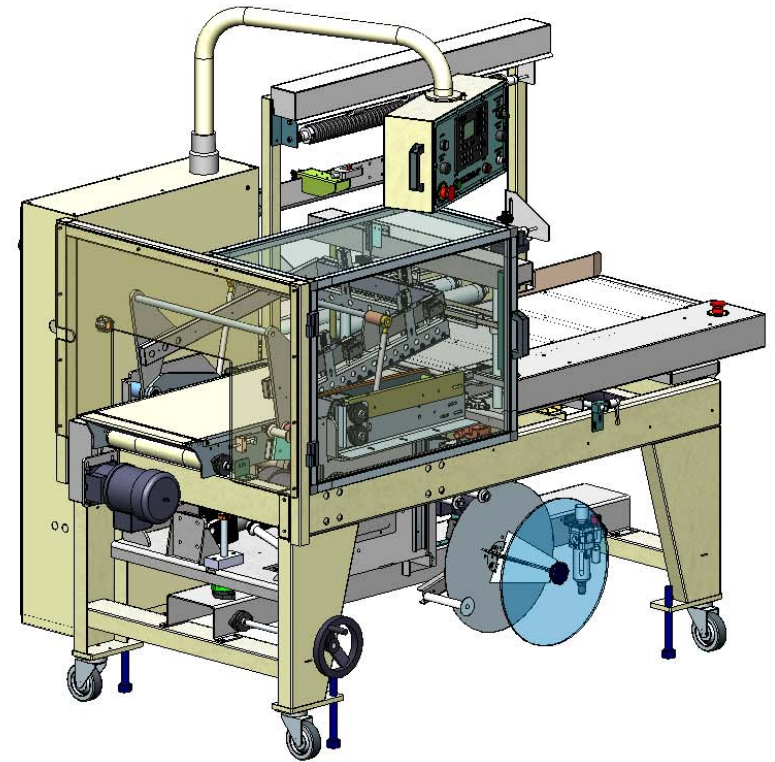
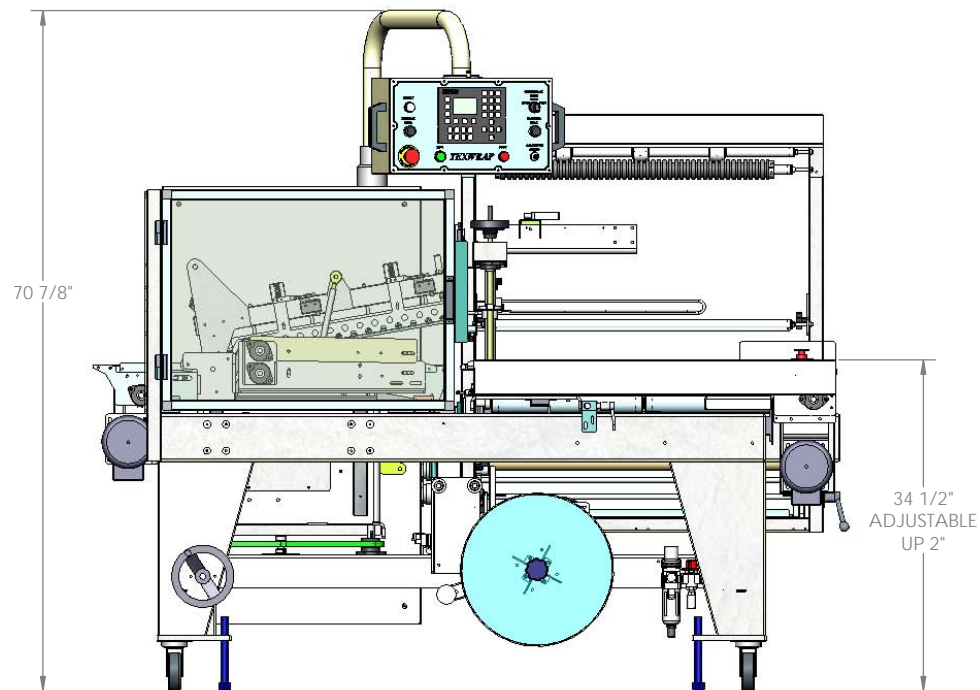
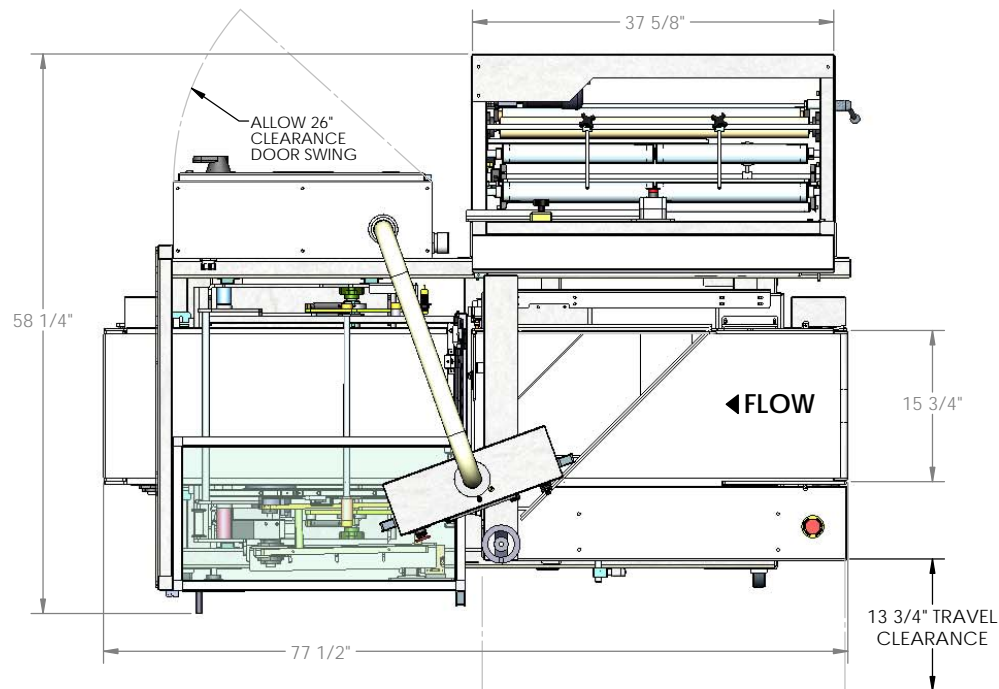
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	80-IC018C-AZ	INFEED SIDE PLATE REAR, LH	1
2	80-IC016GZ	MOUNTING BRACKET	1
3	80-IC034C-A	INFEED SIDE PLATE FRONT	1
4	80-IC022AZ	CONNECTING ANGLE	1
5	80-IC021A	INFEED SUPPORT BAR	4
6	80-IC029A	CONNECTING BAR	2
7	80-IC023AZ	SUPPORTED SIDE BAR	1
8	80-IC039A	SPACER BAR	1
9	80-IC019AZ	UNDER TRAY, INFEED CONV	1
10	80-IC037A	BRACE	1
11	80-IC027GA	IDLER AXLE	3
12	80-IC031C	ROLLER, IDLER STRAIGHT W/ BEARINGS	2
13	80-IC003A-AZ	INFEED DECK, 2219LH	1
14	80-IC017G	ADJUSTING BLOCK	2
15	80-IC028A	AXLE, TRACKING ROLLER	1
16	50-00508-A	BELT, INFEED CONVEYOR 2219 - 89 x 15 W	1
17	40-00401	5/8" FLANGED BEARING	2
18	40-00425	1/2" THRUST WASHER	8
19	80-IC033C	ROLLER, IDLER CROWNED, W- BRGS	2
20	80-IC024	MOTOR MOUNT PLATE	1
21	20-02311AC	MOTOR, AC	1
22	10-00137	SPKT, CHN, 35B20, 0.625" B, KSS	1
23	10-01135	SPKT, CHN, 35B17, 0.750" B, KSS	1
24	75-IC032GA-A	ROLLER, DRIVE	1
25	80-IC050A	AXLE, DRIVE	1
26	80-IC001C-BZ	INFEED CHAIN COVER, 2219LH	1
27	80-IC088	GUARD, INFEED FINGER/THUMB	1
28	10-00109-55	CHAIN, #35, 55 LINKS 1 MASTER LINK	1







To access the parts  
breakdown of a machine  
section click on that section

**T2219**

TEXWRAP MODEL T2219 L-SEALER WRAPPER  
LFS28AC FILM STAND

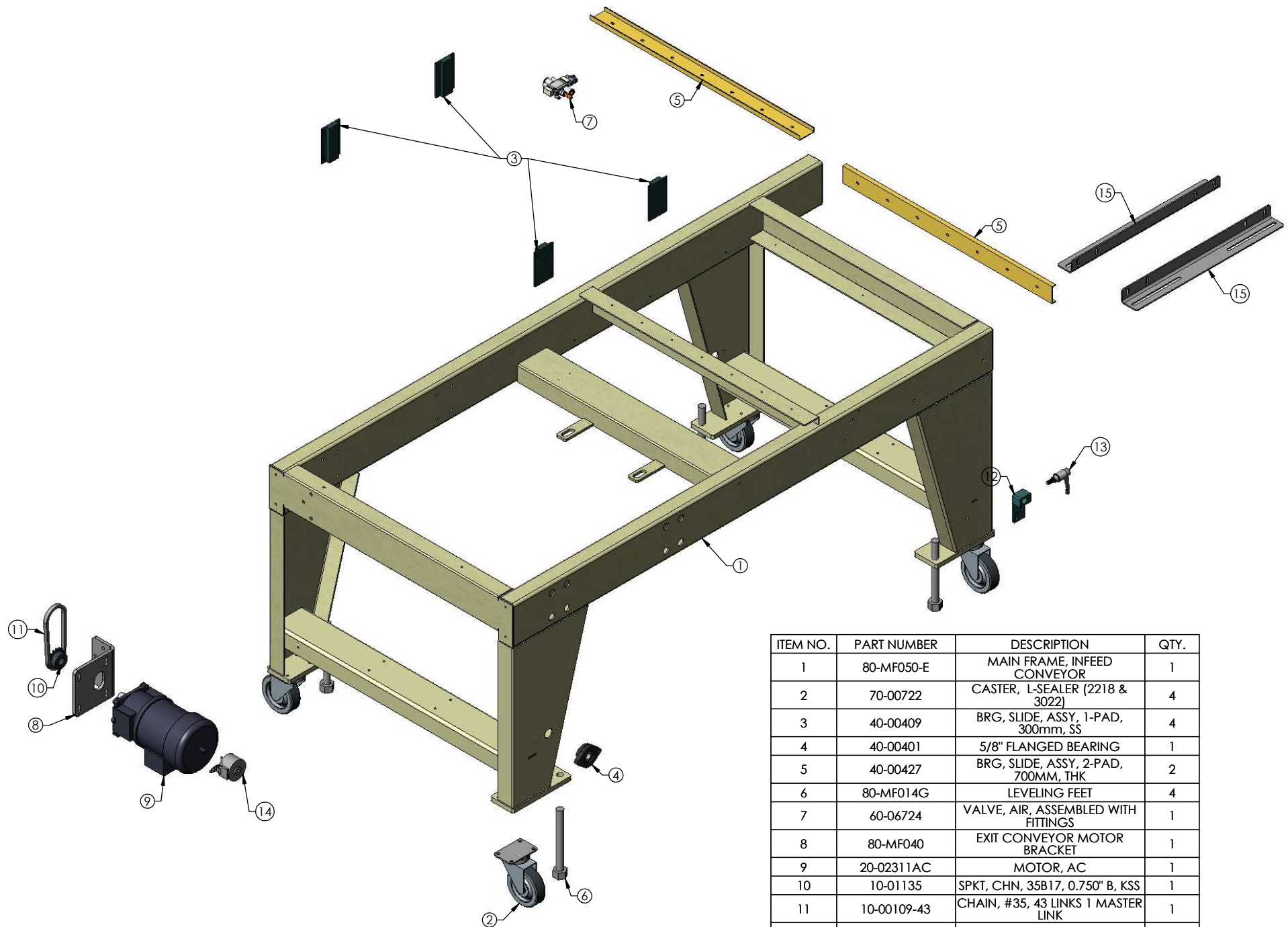
**POWER REQUIREMENTS**

240 VAC, 1 PHASE @ 50/60 HZ @ 22 AMPS

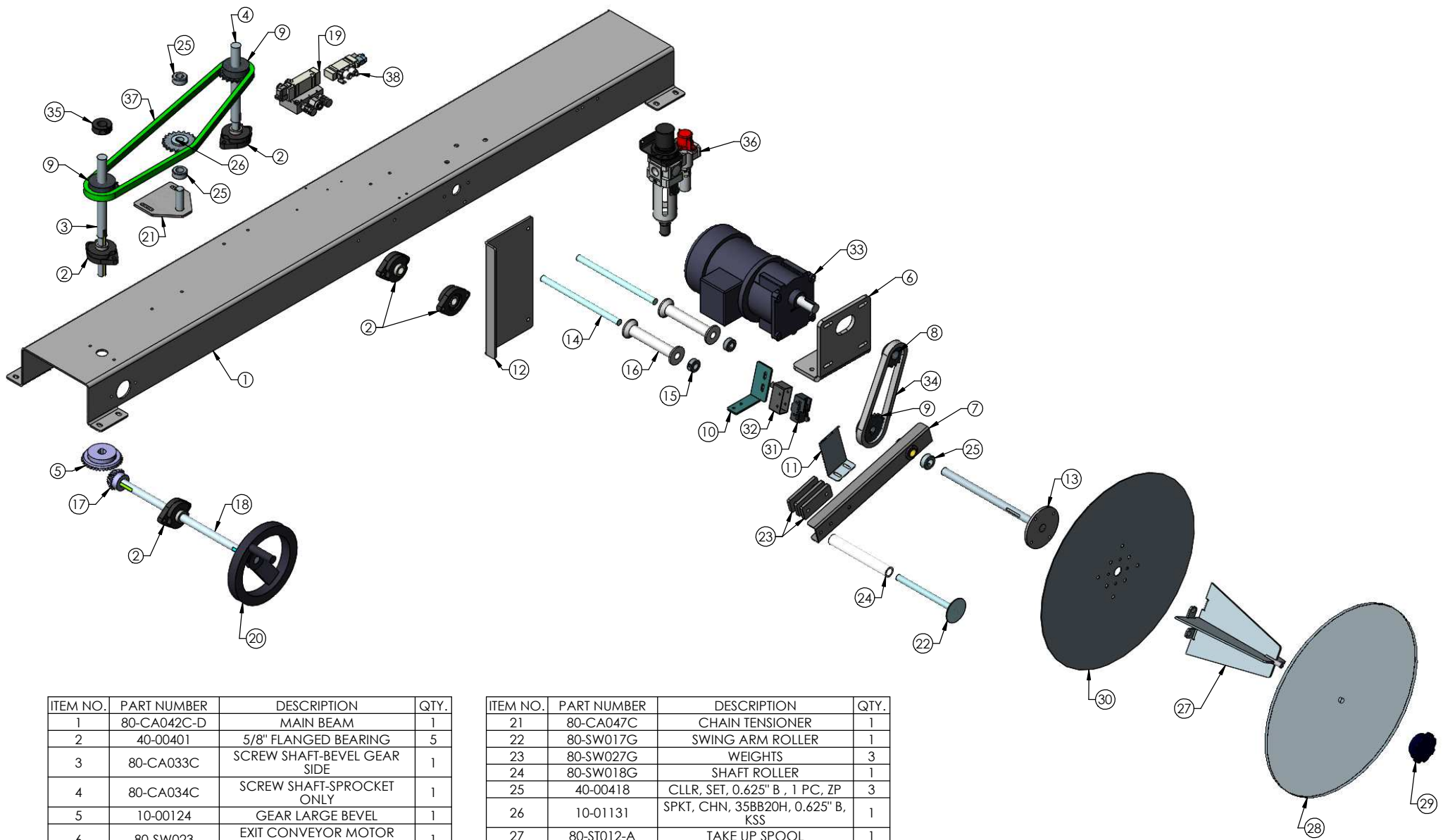
**AIR REQUIREMENTS**

4 C.F.M. @ 80 P.S.I.



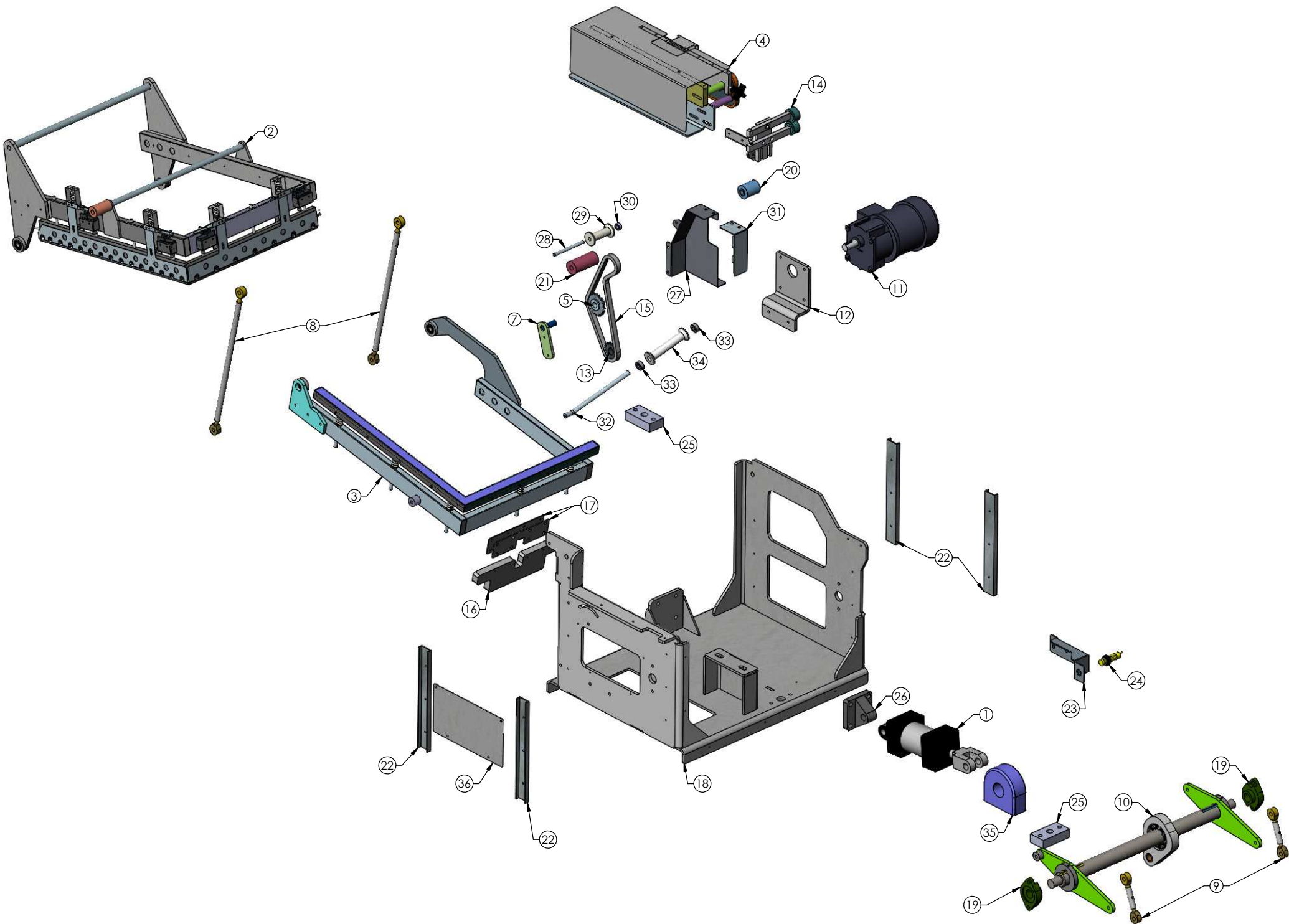


ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	80-MF050-E	MAIN FRAME, INFEED CONVEYOR	1
2	70-00722	CASTER, L-SEALER (2218 & 3022)	4
3	40-00409	BRG, SLIDE, ASSY, 1-PAD, 300mm, SS	4
4	40-00401	5/8" FLANGED BEARING	1
5	40-00427	BRG, SLIDE, ASSY, 2-PAD, 700MM, THK	2
6	80-MF014G	LEVELING FEET	4
7	60-06724	VALVE, AIR, ASSEMBLED WITH FITTINGS	1
8	80-MF040	EXIT CONVEYOR MOTOR BRACKET	1
9	20-02311AC	MOTOR, AC	1
10	10-01135	SPKT, CHN, 35B17, 0.750" B, KSS	1
11	10-00109-43	CHAIN, #35, 43 LINKS 1 MASTER LINK	1
12	80-FA043G	STOP BRACKET	1
13	30-00304	HANDLE-RATCHETING 3/8 -16 THREADS	1
14	20-02844	ENCODER, 5/16 BORE	1
15	80-ACC387	BRACKET, 2219-MPFC	2

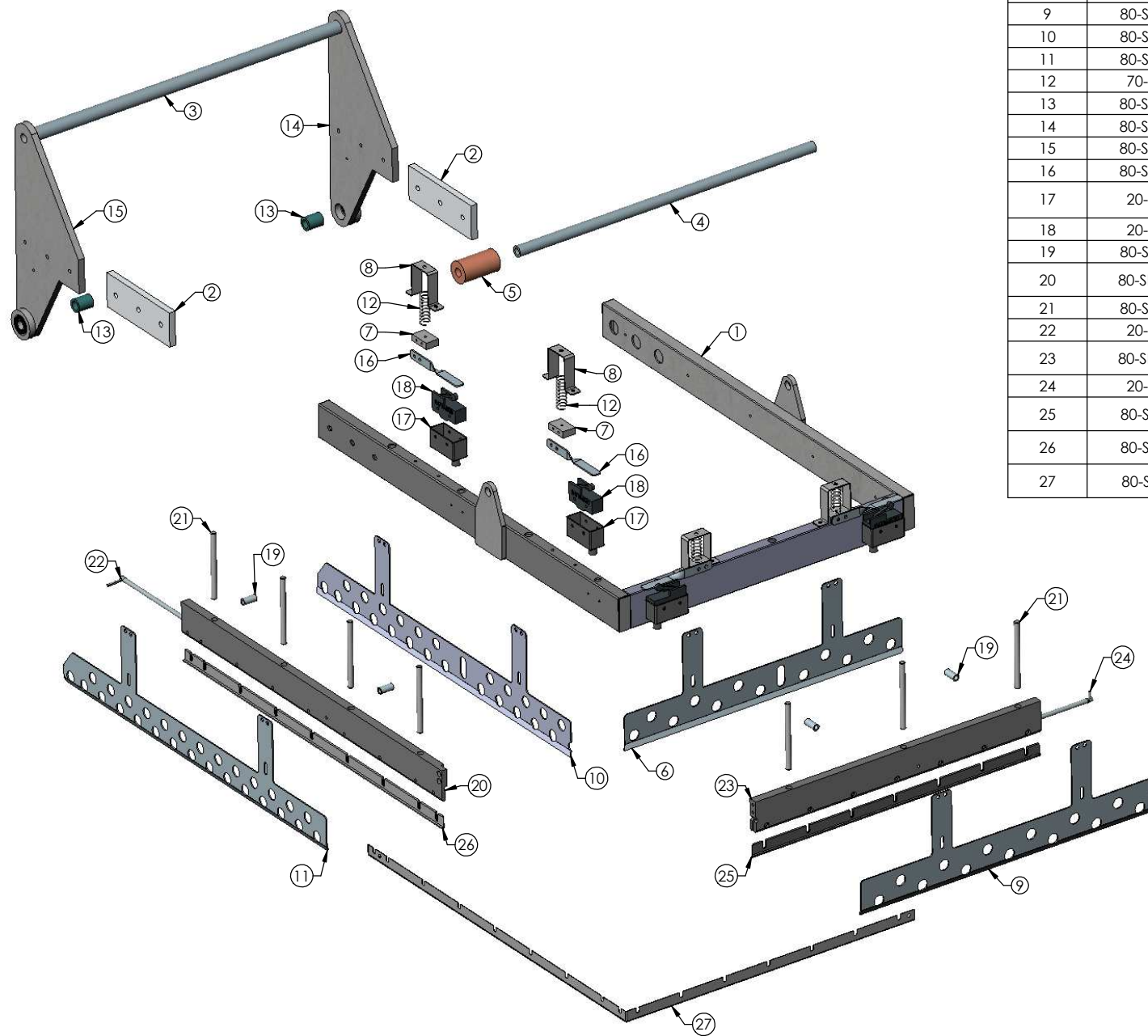


ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	80-CA042C-D	MAIN BEAM	1
2	40-00401	5/8" FLANGED BEARING	5
3	80-CA033C	SCREW SHAFT-BEVEL GEAR SIDE	1
4	80-CA034C	SCREW SHAFT-SPROCKET ONLY	1
5	10-00124	GEAR LARGE BEVEL	1
6	80-SW023	EXIT CONVEYOR MOTOR BRACKET	1
7	80-SW021B	SWING ARM 3022	1
8	10-01112	SPKT, CHN, 35B15, 0.750" B, KSS	1
9	10-00137	SPKT, CHN, 35B20, 0.625" B, KSS	3
10	80-SW007b	MICROSWITCH BRACKET	1
11	80-SW022C	TRIP FLAG	1
12	80-SW031C	SCRAP PATH BRACKET	1
13	80-SW009C-A	SCRAP WINDER SHAFT	1
14	80-SW033C	SHAFT, LOWER SCRAP SPOOL	2
15	40-00420	CLLR, SET, 0.500" B, 1 PC, ZP	2
16	80-SW032C	SCRAP PATH ROLLER SPOOL	2
17	10-00123	GEAR, SMALL BEVEL	1
18	80-CA053C-A	CRANK AXLE, CARRIAGE	1
19	60-06719	VALVE, ASSEMBLY	1
20	80-CA303A	HANDLE, COLLAPSABLE	1

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
21	80-CA047C	CHAIN TENSIONER	1
22	80-SW017G	SWING ARM ROLLER	1
23	80-SW027G	WEIGHTS	3
24	80-SW018G	SHAFT ROLLER	1
25	40-00418	CLLR, SET, 0.625" B, 1 PC, ZP	3
26	10-01131	SPKT, CHN, 35B20H, 0.625" B, KSS	1
27	80-ST012-A	TAKE UP SPOOL	1
28	70-07710	SPOOL SHIELD, OUTER- PLEXIGLASS	1
29	30-00314	HANDLE-FEMALE THREADED 3/8-16	1
30	80-SW012G	GUARD, INSIDE SPOOL	1
31	20-00203	SWITCH, ROLLER	1
32	20-02083	COVER, MICROSWITCH (90 Deg)	1
33	20-02311AC	MOTOR, AC	1
34	10-00109-49	CHN, #35, 181 LINKS & 1 MSTR LNK	1
35	40-04073	CLLR, SET, 0.750" B, 1 PC, ZP	1
36	60-06755	REGULATOR, SMALL	1
37	10-00109-115	CHAIN, #35, 115 LINKS 1 MASTER LINK	1
38	60-06108	AIR MANIFOLD	1

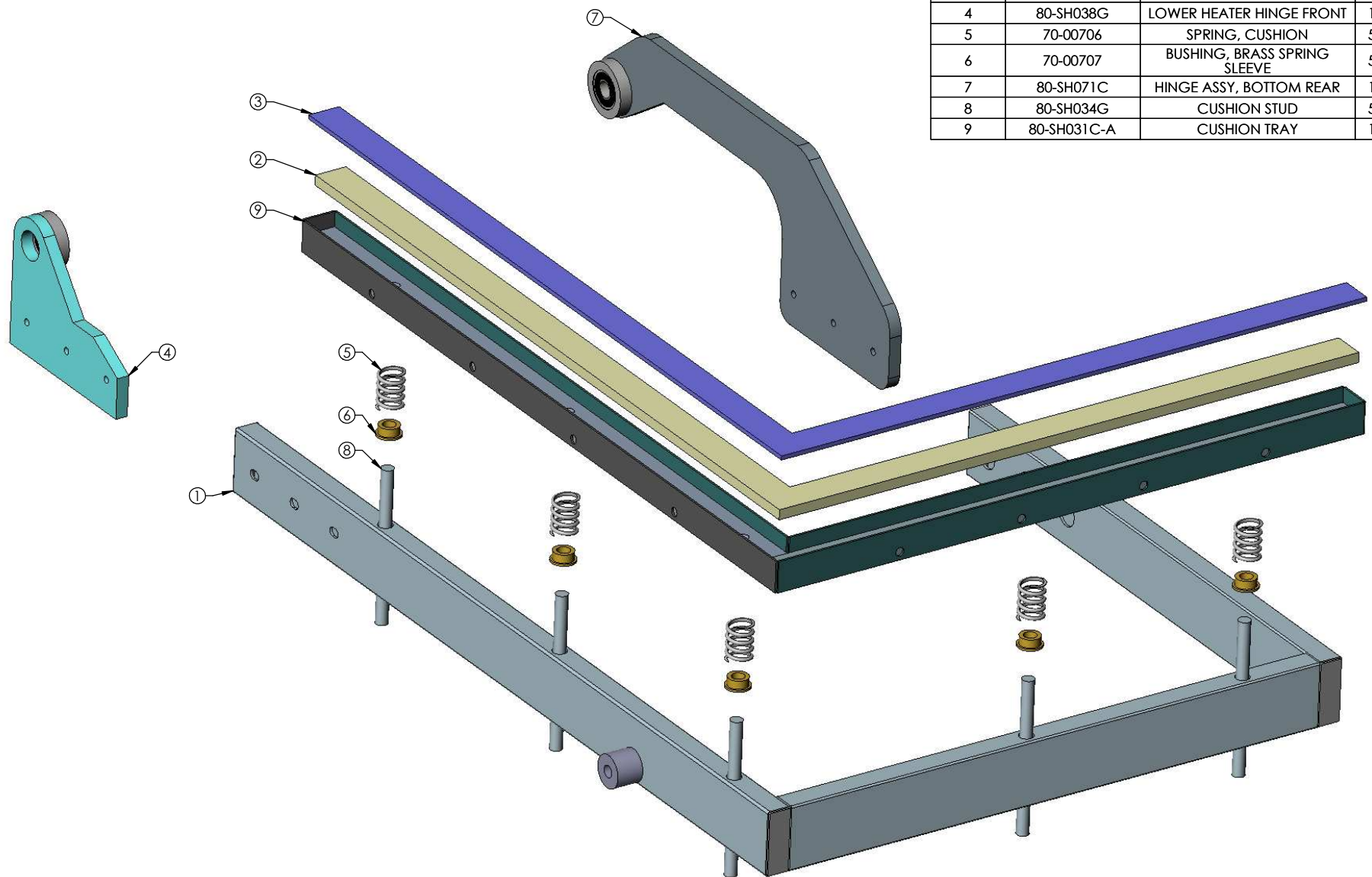


ITEM NO.	PART NUMBER	DESCRIPTION	Default/ QTY.
1	60-06725	CYLINDER, AIR 3.25 BORE X 2"ST	1
2	TOP JAW	SEE PAGE 3	1
3	BOTTOM JAW	SEE PAGE 4	1
4	FILM GUIDE	SEE PAGE 5	1
5	10-01131	SPKT, CHN, 35BB20H, 0.625" B, KSS	1
6	40-00418	CLLR, SET, 0.625" B , 1 PC, ZP	1
7	80-SP066C	TENSIONER, CHAIN	1
8	LONG PUSHROD	SEE PAGE 6	2
9	SHORT PUSHROD	SEE PAGE 7	2
10	ACTUATINGSHAFT	SEE PAGE 8	1
11	20-02311AC	MOTOR, AC	1
12	80-CA072	MOTOR BRACKET, SCRAP PULLER	1
13	10-01112	SPKT, CHN, 35B15, 0.750" B, KSS	1
14	FILM MISER	SEE PAGE 9	1
15	10-00109-75	CHAIN, #35, 75 LINKS 1 MASTER LINK	1
16	80-CA092	LOWER JAW OPEN WEIGHT	1
17	80-CA093	WEIGHT MOUNT PLATE	2
18	80-CA003C-E	CARRAIGE FRAME AC	1
19	40-00404	BRG, CRRG BLT, LGHT DTY	2
20	80-CA010C-C	REAR SPACER	1
21	80-CA007C-C	FRONT SPACER	1
22	40-00409	THK FB3590RUU300L	4
23	80-CA062C-A	PROX BRACKET	1
24	20-02155	PROXIMITY SWITCH	1
25	80-CA032B	NUT PLATE	2
26	60-00603	EYE BRACKET (REAR OF CYLINDER)	1
27	80-SP073C	SCRAP PULLER CHAIN COVER	1
28	80-CA069C	SHAFT, UPPER SCRAP SPOOL	1
29	80-ST014	FILM GUIDE ROLLER	1
30	40-00430	CLLR, SET, 0.375" B , 1 PC, BO	1
31	80-SP074C	SCRAP PULLER SPROCKET COVER	1
32	80-SW034C	SHAFT, LOWER SCRAP SPOOL- BENT	1
33	40-00420	CLLR, SET, 0.500" B , 1 PC, ZP	2
34	80-SW032C	SCRAP PATH ROLLER SPOOL	1
35	40-00451	BEARING 1-5/8" PILLOW BLOCK	1
36	80-CA073	FRONT COVER	1

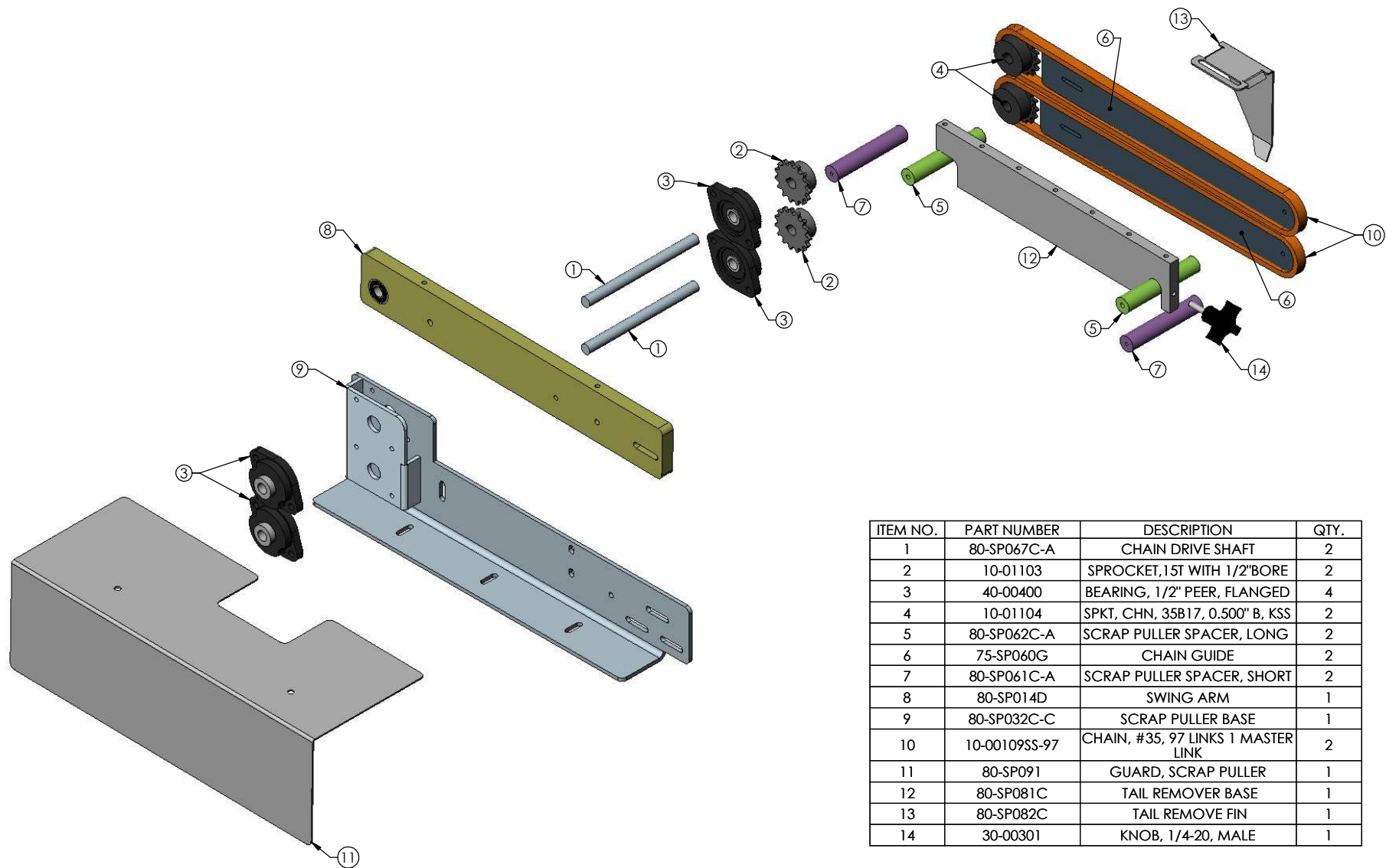


ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	80-SH007C-A	TOP HEATER FRAME	1
2	80-SH003G	HINGE SPACER BLOCK	2
3	80-SH006C	TOP SPACE BAR	1
4	80-SH018C	LOWER SPACE BAR	1
5	80-SH022C	SPACER BOSS	1
6	80-SH009C	FILM CLAMP, INSIDE CROSS	1
7	80-SH011C-A	FILM CLAMP SPACER	4
8	80-SH013G	BRACKET, FILM CLAMP SPRING	4
9	80-SH017C	FILM CLAMP, OUTSIDE CROSS	1
10	80-SH021C	FILM CLAMP, INSIDE SIDE	1
11	80-SH023C	FILM CLAMP, OUTSIDE CROSS	1
12	70-00705	SPRING, LIGHT FILM CLAMP	4
13	80-SH024G	BEARING SPACER	2
14	80-SH004G	UPPER HEATER HINGE - REAR	1
15	80-SH026G	UPPER HEATER HINGE - FRONT	1
16	80-SH016G	TRIP DOG	4
17	20-02083	COVER, MICROSWITCH (90 Deg)	4
18	20-00203	SWITCH, ROLLER	4
19	80-SH014C	SPACER, FILM CLAMP	4
20	80-SH203-A	SEAL BAR, REYNOLDS, 2219 SIDE	1
21	80-SH039C	HEATER STUD	7
22	20-02312	HEAT ELEMENT, CROSS 2202	1
23	80-SH200-A	SEAL BAR, REYNOLDS, 2219 CROSS	1
24	20-02357	HEAT ELEMENT, CROSS BEAM	1
25	80-SH201A	MUSHROOM INSERT, ONE PIECE BLADE	1
26	80-SH204A	MUSHROOM INSERT, ONE PIECE BLADE	1
27	80-SH250P	CUTTING BLADE, ONE PIECE, TEFLON	1

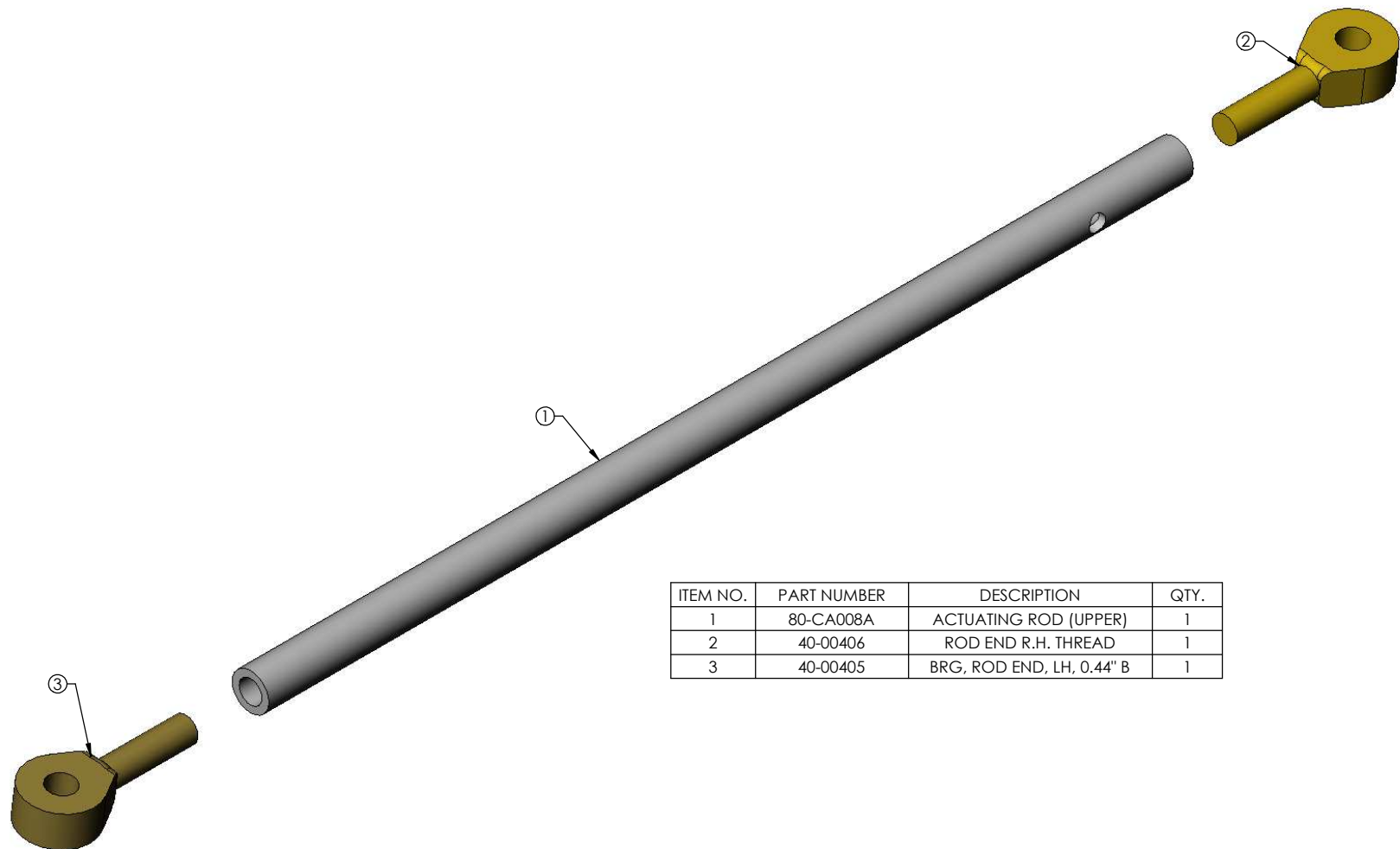




ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	80-SH029C-A	CUSHION FRAME	1
2	50-05041	PAD, SILICON RUBBER	1
3	50-05043	PAD, SILICON RUBBER	1
4	80-SH038G	LOWER HEATER HINGE FRONT	1
5	70-00706	SPRING, CUSHION	5
6	70-00707	BUSHING, BRASS SPRING SLEEVE	5
7	80-SH071C	HINGE ASSY, BOTTOM REAR	1
8	80-SH034G	CUSHION STUD	5
9	80-SH031C-A	CUSHION TRAY	1

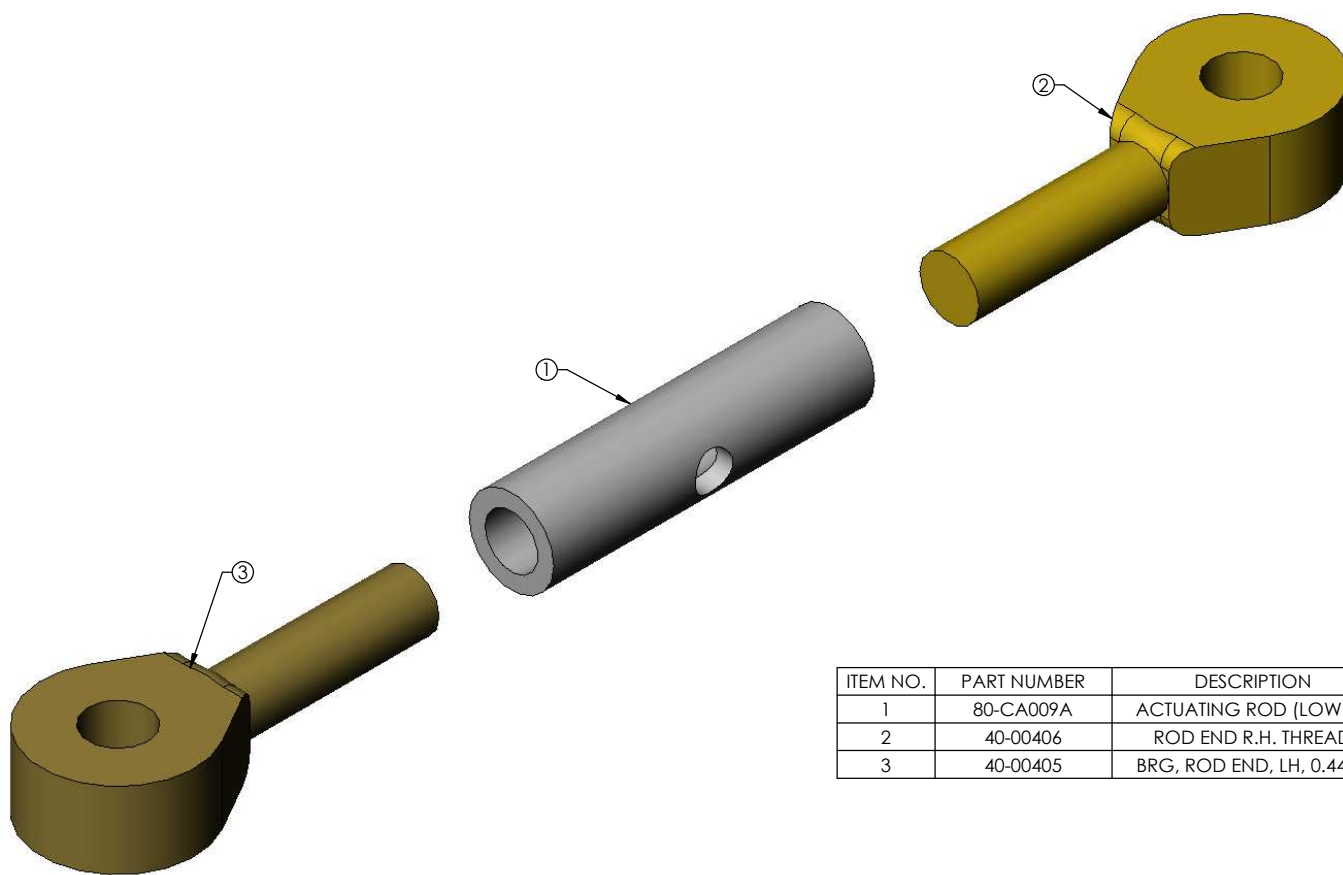


ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	80-SP067C-A	CHAIN DRIVE SHAFT	2
2	10-01103	SPROCKET, 15T WITH 1/2" BORE	2
3	40-00400	BEARING, 1/2" PEER, FLANGED	4
4	10-01104	SPKT, CHN, 35B17, 0.500" B, KSS	2
5	80-SP062C-A	SCRAP PULLER SPACER, LONG	2
6	75-SP060G	CHAIN GUIDE	2
7	80-SP061C-A	SCRAP PULLER SPACER, SHORT	2
8	80-SP014D	SWING ARM	1
9	80-SP032C-C	SCRAP PULLER BASE	1
10	10-00109SS-97	CHAIN, #35, 97 LINKS 1 MASTER LINK	2
11	80-SP091	GUARD, SCRAP PULLER	1
12	80-SP081C	TAIL REMOVER BASE	1
13	80-SP082C	TAIL REMOVE FIN	1
14	30-00301	KNOB, 1/4-20, MALE	1

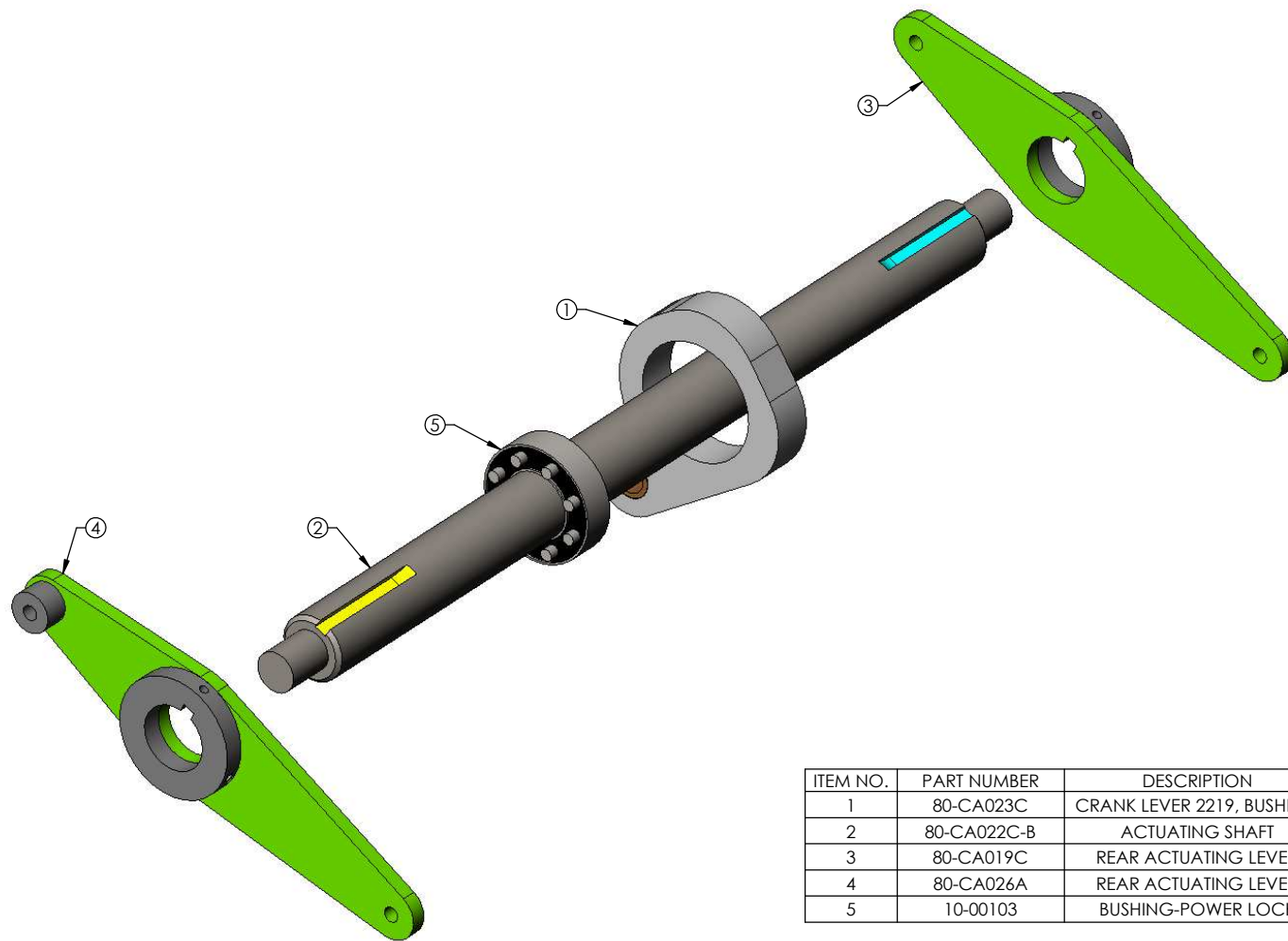


ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	80-CA008A	ACTUATING ROD (UPPER)	1
2	40-00406	ROD END R.H. THREAD	1
3	40-00405	BRG, ROD END, LH, 0.44" B	1





ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	80-CA009A	ACTUATING ROD (LOWER)	1
2	40-00406	ROD END R.H. THREAD	1
3	40-00405	BRG, ROD END, LH, 0.44" B	1



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	80-CA023C	CRANK LEVER 2219, BUSHING	1
2	80-CA022C-B	ACTUATING SHAFT	1
3	80-CA019C	REAR ACTUATING LEVER	1
4	80-CA026A	REAR ACTUATING LEVER	1
5	10-00103	BUSHING-POWER LOCK	1

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	80-EH055	BAR, LOWER PINCH WHEEL MOUNT	1
2	80-EH062	BAR, UPPER PINCH WHEEL MOUNT	1
3	80-EH054	BRACKET, PINCH WHEEL ADJUSTMENT	1
4	70-07709	SPRING, FILM CLAMP, HEAVY	1
5	50-00502	ROLLER, FILM MISER	2
6	80-EH063	ANGLE, FILM MISER MOUNTING	1
7	80-EH064	BRACKET, FILM MISER MOUNTING	1

