

EDGEPACK, INC.

Operation and Parts Manual

Edgepack rotary fill and seal machines are precision engineered and constructed for safe and convenient filling and sealing of your special products. Operation is safe, simple and economical when the machines have been properly installed and are operated correctly.

Important

Both operating and service personnel should read and familiarize themselves with the following instructions before operating the machine.

WARRANTY

EDGEPACK, INC. warrants equipment of its own manufacture to be free from defects in materials and workmanship. This Warranty extends only to the original Buyer and is limited to repair or replacement F.O.B. EDGEPACK, INC. Factory of any part or component manufactured by EDGEPACK, INC. which is found to have been defective at the time of shipment, provided written claim has been received from Buyer within three months of shipment and such original part or component is returned prepaid to Seller.

This Warranty applies only to equipment installed and operated in accordance with EDGEPACK, INC. Recommendations, and such Warranty does not apply where EDGEPACK, INC. determines that any claimed defect arose as a result of Purchaser's misuse, neglect, improper installation, repair, alteration or accident with respect to any equipment delivered hereunder. With respect to equipment, materials, parts and accessories manufactured by others, EDGEPACK, INC. will undertake to obtain for the Buyer the full benefit of the manufacturer's warranties.

EDGEPACK, INC. will not be liable for any loss of profit, loss by reason of plant shutdown, non-operation or increased expense of operation, loss of product or materials, or other consequential loss or damage of any nature, and all claims for such loss or damage are expressly waived by Buyer.

EDGEPACK, INC. will not be responsible for system performance unless both containers and lids have been tested and approved by EDGEPACK, INC. for compatibility with any of our machine components.

THIS WARRANTY IS IN LIEU OF ALL OTHER WARRANTIES, EXPRESSED OR IMPLIED.

INSTALLATION and STARTUP PROCEDURE

1. **Do not** operate EDGEPACK, INC. rotary fill and seal machine until this instruction manual is read.
2. Make sure machine is connected to building electrical and safely grounded.
3. **Shut off** main disconnect power and air supply when cleaning, adjusting, repairing and removing jams on this unit.
4. **Do not** put fingers, hands or arms into machine when it is running or has electrical power or air connected.
5. **Do not** operate machine with guards removed.
6. Place machine in its proper place where it is going to be used.
7. Make sure the machine is level.
8. Provide a clean, dry air supply of a minimum of 70 psi. Be sure to turn to open shut-off valve on air pressure regulator. Machine will not operate without air pressure.
9. Plug in standard electrical service of 110 Vac., single phase, 20 amp. Typical running current is 17 amps.
10. Reference control panel layout drawing.
11. The red button in the lower right hand corner is the main power button and emergency stop button. PUSH button IN will turn electrical power off and stop the machine. Red light will be ON. PULL button OUT will turn electrical power on and machine will be able to operate. REMINDER: machine requires 110 Vac, single phase, 20 Amp electrical power AND a clean, dry source of air pressure at 70 psi to operate.
12. The MOTION control switch has three positions, RUN, OFF, JOG. The JOG position is spring loaded and will return to the OFF position when released. JOG allows you to position the indexing dial and tooling for setup adjustments and cleaning as required. Placing selector switch in the RUN position will run the machine as long as there is adequate air pressure and the POWER button is ON.
13. Make sure heater station is in UP position and not touching dial. If heaters are not in this position, jog dial until heaters are up. With heater in UP position, turn heaters ON. Temperature is preset at the factory. If required, heater temperature can be adjusted by pressing "up" or "down" arrows on heater control.

NOTE: heater switches must be "ON" for fill station and foil place station to operate. Heat seal will not function properly until heaters are up to "set" temperature.

Startup Adjustments

-) Cycle machine with **NO** product, **NO** cups and **NO** foils. Run machine to become familiar with controls and sequence of operation of the machine.

Machine station functions are as follows:

1. **Cup Drop Station:** place a stack of cups approximately 18" high into each cup tube.
2. **Product Fill Station:** Place product into hopper. Fill product to within approximately 2" from top. If product is to be directly piped, install a shut off valve before the "Y" tube.

Cycle machine 6 to 8 times to purge filler valves of air. NOTE: cups must be present in the dial for the product fill valves to operate. Volume control is set by adjusting threaded rod and double nut to lock adjustment.

3. **Foil Place Station:** When taking foils out of the box, be sure the foils are placed in the foil magazine "right side" up. Foils go into the magazine with the printing or shiny side down. When picked up by the vacuum cup, the foil will rotate 180 degrees before being placed on the cup.
4. **Heat Seal Station:** Be sure the heater anvils are not resting on the turntable when the heaters are up to temperature. The heaters are set to your cup and foil seal before shipment from **EDGEPACK, INC.**

-) **Container Discharge Station:** When containers come to this station, a stage from the bottom will come up and automatically lift the cup to the level of the dead plate where a sweep arm will sweep the containers clear.

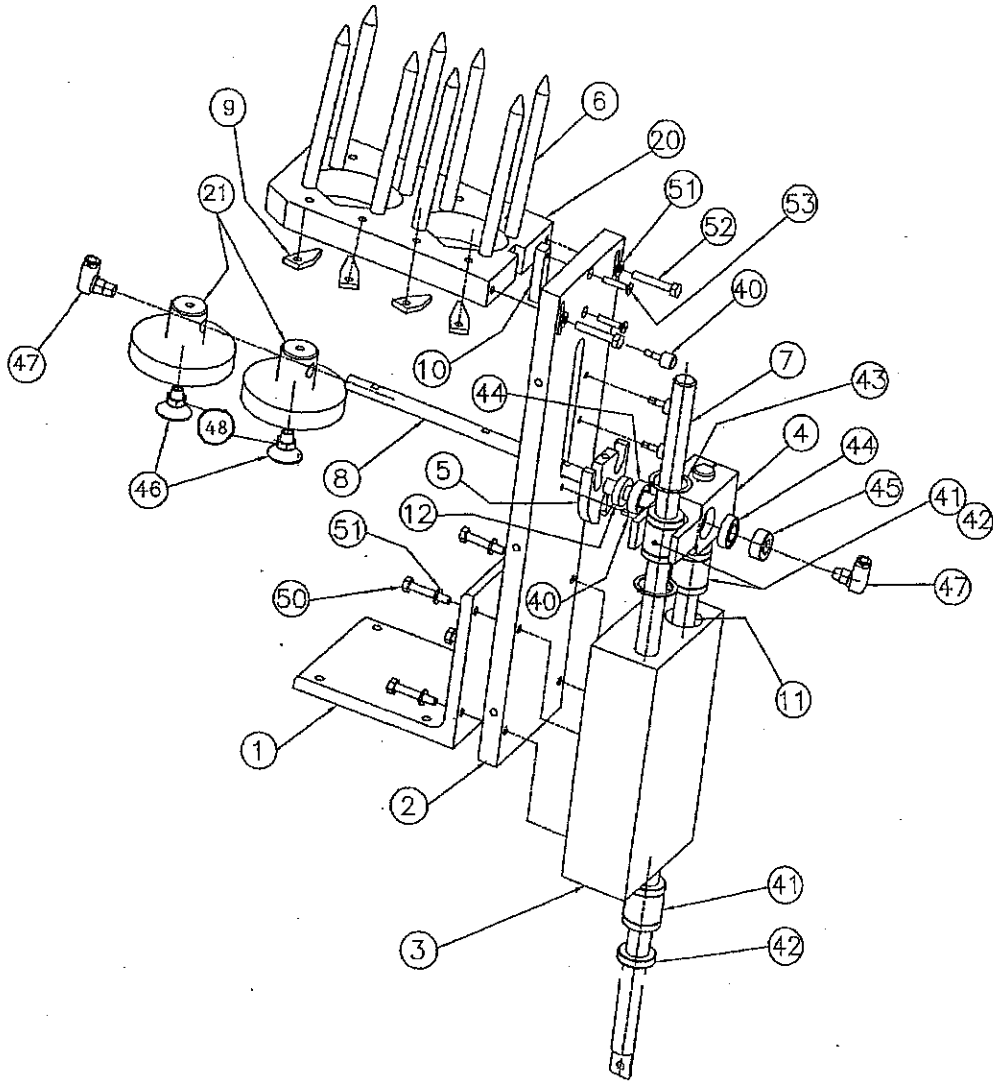
Trouble shooting:

Foil will not seal: verify that foils are loaded in the magazine correctly with the printing down. Verify that the heat seal heads are at correct temperature. Verify heater selector switches are "ON".

Foil Place Station

<u>Item No.</u>	<u>P/N</u>	<u>Description</u>	<u>Parts per Assembly</u>
1	0201-011-010	Mount-Station Angle	1
2	0201-014-010	Vertical Mount	1
3	0201-014-011	Shaft Bearing Block	1
4	0201-014-012	Lift Block	1
5	0201-014-013	Rose Cam	1
6	0201-014-014	Foil Guide	8
7	0201-014-015	Guide Shaft	1
8	0201-014-016	Vacuum Tube	1
9	0101-014-021	Foil Finger	8
10	0201-014-018	Foil Plate Key	1
11	0201-014-019	Shaft, Foil Place	1
12	0201-014-020	Spacer, Rose Cam	1
20	0201-014-050	Dual Foil Plate	**
21	0201-014-051	Foil Pick	**
25	0201-014-500	Guard-Foil Place Cover	1
40	0201-014-600	Cam Follower 1/2" Dia Roller	4
41	0201-014-601	Linear Bearing, .751dx1.250dx1.63	3
42	0201-014-602	Shaft Seal	2
43	0201-014-603	Retainer Ring	2
44	0201-014-604	Ball Bearing-Single Row	2
45	0201-014-605	Set Screw Collar 1/2"	1
46	0201-014-606	Vacuum Cup,Part # XP-U30	2
47	0201-014-607	Elbow-Pipe	2
48	0201-014-608	Fitting (Vacuum Cup)	2
50	Hardware	1/4-20 x 1.75 HCS	
51	Hardware	1/4 FW	
52	Hardware	1/4-20 x 1.25 HCS	
53	Hardware	10-24 x 1 FSLMS	
54	Hardware	10-24 x 3/8 BHSCS	

**Part of Tooling Package

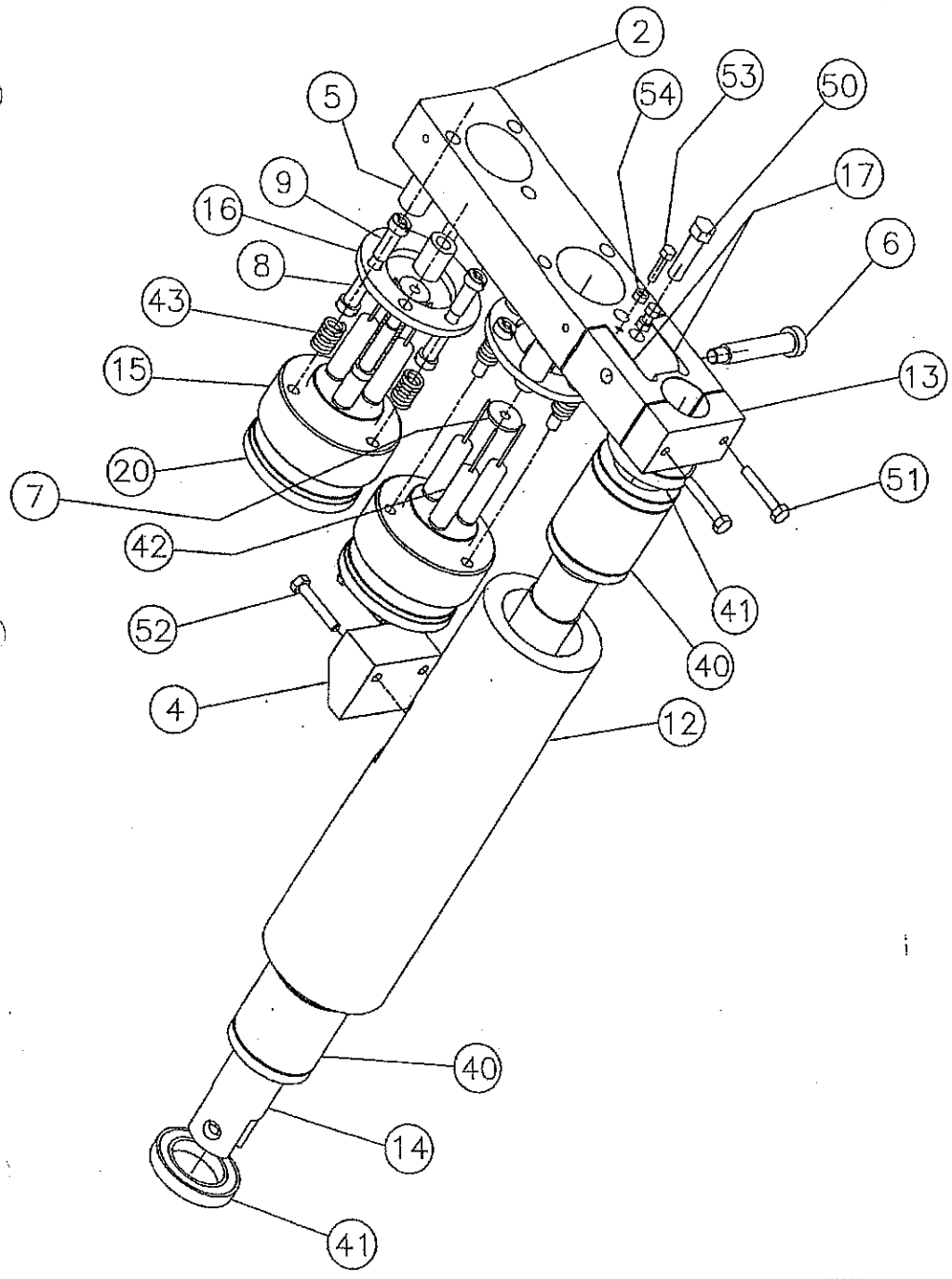


FOIL PLACE STATION

Heat Seal Station

<u>Item No.</u>	<u>P/N</u>	<u>Description</u>	<u>Parts per Assembly</u>
1	0201-015-010	Bushing, Anti Rotate	1
2	0201-015-011	Heat Seal Plate-Double Fill	1
3	0201-015-012	Anti Rotate Lift Coupler	1
4	0201-015-013	Wear Block	1
5	0201-015-014	Heater Stand Off	6
6	0201-015-015	Pivot Bolt -Shld 1/2 x 2.5 lg	1
7	0201-015-016	Heat Rod Keeper	2
8	0201-015-017	Spring Bolt-Shld 3/8 x 1.0 lg	6
9	0201-015-018	Spacer Bolt-Shld 3/8 x 1.5 lg	6
10	0201-015-019	Anti Rotate Pin	1
11	0201-015-020	Pivot Bushing	1
12	0201-015-021	Main Support	1
13	0201-015-022	Pivot Plate Clamp	1
14	0201-015-023	Main Shaft - Heat Seal	1
15	0201-015-024	Heat Head	2
16	0201-015-025	Support Ring	2
17	0201-015-026	Thrust Spacer	2
20	0201-015-050	Heat Seal Ring	**
25	0201-015-500	Guard-Heat Seal Cover	1
40	0201-015-600	Linear Bearing-1.5idx2.375odx3"	2
41	0201-015-601	Seal, Bushing	2
42	0201-015-602	Heat Rod (120V, 150W)	6
43	0201-015-603	Compression Spring, St Stil	6
50	Hardware	3/8-16 x 1.5 HCS	
51	Hardware	1/4-20 x 1.25 HCS	
52	Hardware	1/4-20 x 1.75 HCS	
53	Hardware	10-24 x 1.5 HCS	
54	Hardware	10-24 Nut	

**Part of Tooling Package

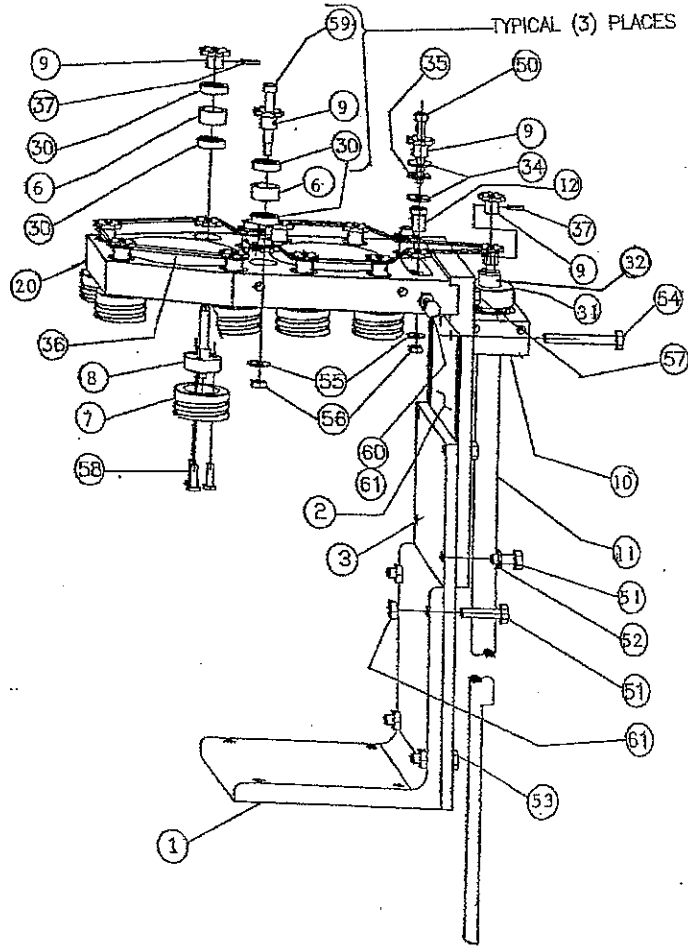
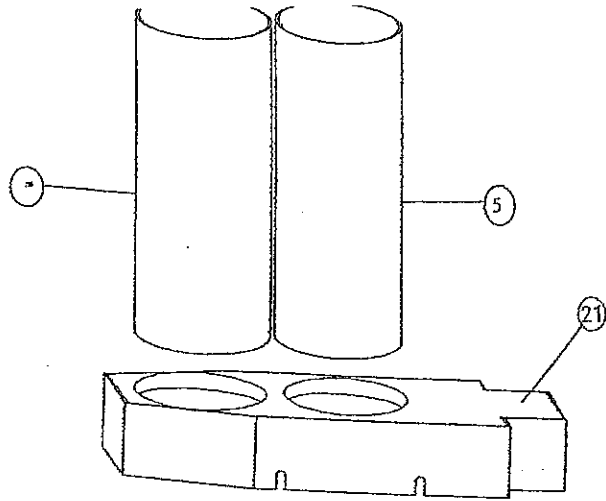


HEAT SEAL STATION

Cup Drop Station

<u>Item No.</u>	<u>P/N</u>	<u>Description</u>	<u>Parts per Assembly</u>
1	0201-011-010	Mount - Station Angle	1
2	0101-011-011	Mount - Drop Plate	1
3	0201-011-012	Mount-Vertical Short	**
4	0201-011-013	Mount-Vertical Long	**
5	0101-011-052	Cup Magazine	**
6	0201-011-016	Spacer, Bearing	11
7	0201-011-017	Cup Drop Screw	8
8	0201-011-018	Dropper Shaft	8
9	0201-011-019	Sprocket	13
10	0201-011-020	Shaft Block	1
11	0201-011-021	Shaft -Cup Drive	1
12	0201-011-025	Chain Tension Bar	1
20	0201-011-050	Bearing Drop Plate	**
21	0201-011-051	Cup Cover- Plate	**
25	0201-011-500	Cover Upper Drive	1
26	0201-011-501	Cover- Short Lower Cup Dr	**
27	0201-011-502	Cover- Long Lower Cup Dr	**
30	0201-011-600	Bearing Drop Screw	22
31	0201-011-601	Bearing, Drive Shaft	1
32	0201-011-602	Set Screw Collar 3/4" id	1
34	0201-011-604	Washer - Thrust	2
35	0201-011-605	Bearing - Thrust	1
36	0201-011-606	Chain - Roller #25	A/R
37	0201-011-607	Spiral Pin; .124 Dia x 1/2 Lg	13
38	0201-011-608	Bearing, Sintered Bronze	1
50	Hardware	1/4 x 1.5 Strip	
51	Hardware	1/4-20 x 7/8 HCS	
52	Hardware	1/4 FW	
53	Hardware	1/4-20 x 1.25 HCS	
54	Hardware	1/4-20 x 2.25 HCS	
55	Hardware	#10 FW	
56	Hardware	10-24 JamNut	
57	Hardware	1/4-20 x 1 HCS	
58	Hardware	8-32 x 3/4 BHSCS	
59	Hardware	1/4 x 1.25 Strip	
60	Hardware	1/4 x 20 x 2 HCS	
61	Hardware	1/4-20 JamNut	

**Part of Tooling Package

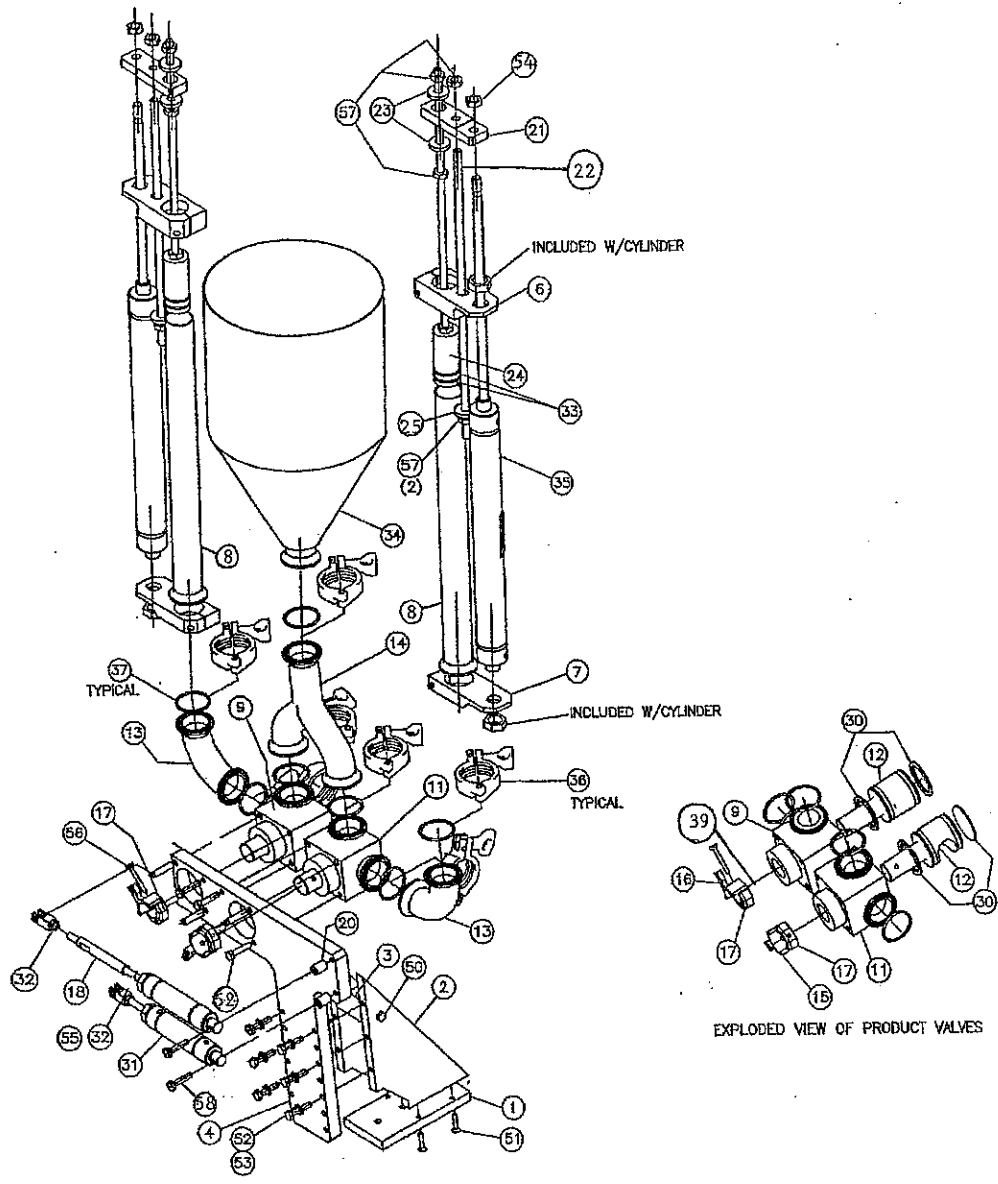


CUP DROP STATION

First Fill Station

<u>Item No.</u>	<u>P/N</u>	<u>Description</u>	<u>Parts per Assembly</u>
1	0201-012-010	Mounting Plate-Fill Base	1
2	0201-012-011	Vertical Support-Fill	2
3	0201-012-012	Support Bracket Stiffener	1
4	0201-012-015	Mounting Plate-Double Fill	1
5	0201-012-016	Coupler Nut	2
6	0201-012-017	Cylinder Mount Upper	2
7	0201-012-018	Cylinder Mount Lower	2
8	0201-012-019	Product Tube	2
9	0101-012-020	Product Valve Housing	1
10	0201-012-021	90 deg Tube w/20 deg R.H. offset	**
11	0201-012-022	Product Valve Housing- Outer	1
12	0201-012-023	Product Valve	2
13	0201-012-024	90 deg Double Flange Tube	2
14	0201-012-025	Triple Flange "Y" Fill Tube	1
15	0201-012-028	Valve Lever Outer	1
16	0201-012-029	Valve Lever Inner	1
17	0201-012-030	Valve Lever Clamp	2
18	0201-012-031	Cylinder Extension	1
20	0201-012-033	Cylinder Stand Off	2
21	0201-012-036	Tie Bar-Feed Tube Rod	2
22	0201-012-037	Threaded Rod	4
23	0201-012-038	Washer-Feed Tube Rod	2
24	0201-012-039	Product Tube Piston	2
25	0201-012-040	Product Fill Cushion	2
30	0201-012-600	O-Ring - Product Valve	4
31	0201-012-601	Air Cylinder - Product Valve	2
32	0201-012-602	Clevis-Piston Rod	2
33	0201-012-603	O-Ring-Prod Piston 1.375odx.141 Thk	4
34	0201-012-604	Product Hopper	1
35	0201-012-605	Air Cylinder - Product Tube	2
36	0201-012-606	Clamp - Schedule 5 & 10	7
37	0201-012-607	Gasket - Schedule 5 & 10	7
39	0201-012-609	Thrust Washer 1" I.D.	2
50	Hardware	1/4-20 x 1 HCS	
51	Hardware	10-24 x 1 FSLMS	
52	Hardware	1/4-20 x 1.25 HCS	
53	Hardware	1/4 FW	
54	Hardware	M12-1.25 JamNut	
55	Hardware	M10-1.25 JamNut	
56	Hardware	10-24 x 1.5 HCS	
57	Hardware	3/8 -16 JamNut	
58	Hardware	3/8 -16 x 2.5 HCS	

**Part of Tooling Package

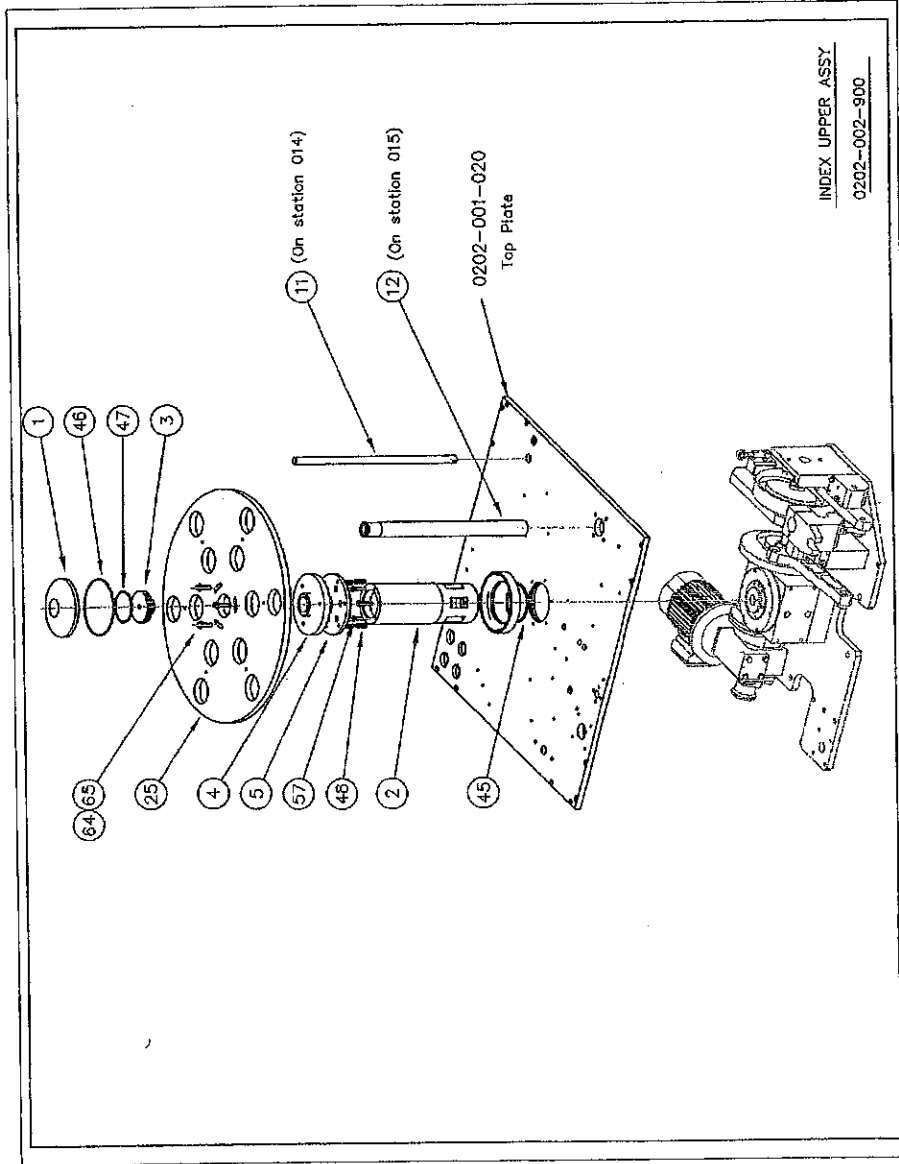


FIRST FILL STATION

Indexer Upper Assy-0202-002-900

<u>Item No.</u>	<u>P/N</u>	<u>Description</u>	<u>Parts per Assembly</u>
1	0101-002-011	Dial Cap	1
2	0202-002-042	Column, Dial Hub	1
3	0101-002-013	Dial Retainer	1
4	0101-002-014	Dial Release Hub	1
5	0101-002-015	Dial Safety Hub	1
11	0201-014-019	Shaft, Foil Place	1
12	0201-015-023	Main Shaft - Heat Seal	1
25	0101-002-050	Dial	**
45	0101-002-615	O-Ring, Dial Column, 4.125 OD x .139 THK	1
46	0101-002-616	O-Ring, Dial Cap Seal, 1/8 CS	1
47	0101-002-617	O-Ring, DL-Cap Retainer, 1/8 CS	1
48	0101-002-618	Spring Plunger Ball Nose 3/8	6
57	Hardware	Nut - 3/8-18	5
64	Hardware	5/16-18 x 1 1/4 SHCS	3
65	Hardware	5/16 Flat Washer	3

**Part of Tooling Package



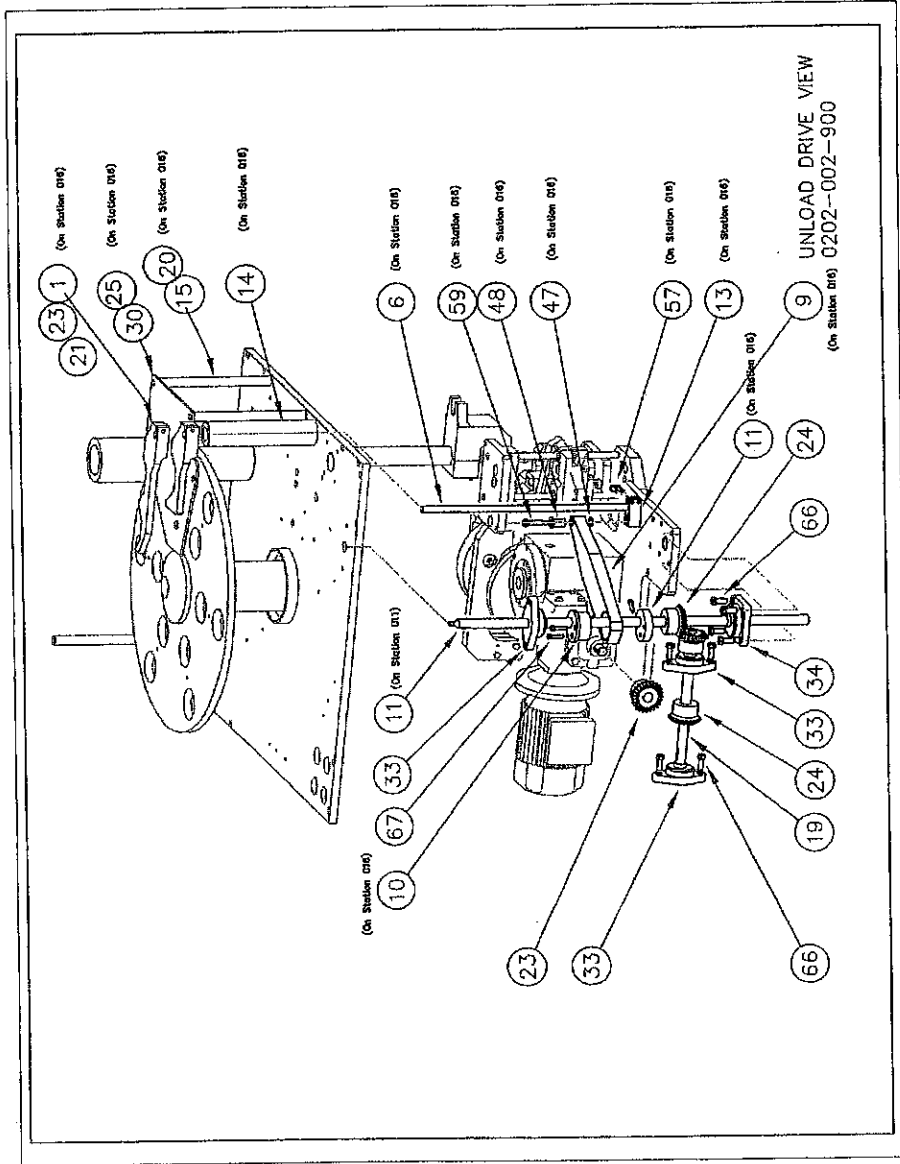
INDEX UPPER ASSY

0202-002-900

Unload Drive View-0202-002-900

<u>Item No.</u>	<u>P/N</u>	<u>Description</u>	<u>Parts per Assembly</u>
1	0201-016-010	Double Unload Arm	1
6	0201-016-016	Shaft- Pivot Unload	1
9	0201-016-019	Drive Arm Unload	1
10	0201-016-020	Pivot Block Clamp	1
11	0201-016-021	Pivot Block	1
11	0201-011-021	Shaft-Cup Drive	1
13	0201-016-023	Rotate Bar	1
14	0201-016-024	Pivot Column	1
15	0202-016-035	Post Unload Plate	3
19	0101-002-029	Shaft-Cup Ilder	1
20	0202-016-039	Clamp Post Cap	3
21	0202-016-044	Arm Safety Clamp	1
23	0202-016-043	Reset Cushion	2
23	0202-002-047	Gear-Miter Short	1
24	0101-002-034	Gear-Miter	3
25	0202-016-040	Containment Rail	1
30	0202-016-053	Dead Plate Unload	**
33	0101-002-603	Bearing 3/4" ID 2 Bolt Flange	4
34	0101-002-604	Bearing 3/4" ID 4 Bolt Flange	1
47	0202-016-610	Thrust Bearing; Sintered Bronze	1
48	0202-016-611	Sintered Bronze Flange Bearing	1
57	Hardware	Soc HD Cap Scr 1/4-20x1.0 LG	2
59	Hardware	Soc HD SHLD SCR 3/8 x 1.25 LG	1
66	Hardware	3/8-16 x 1 1/4	10
67	Hardware	1/4-20 x 1 1/2 SHCS	2

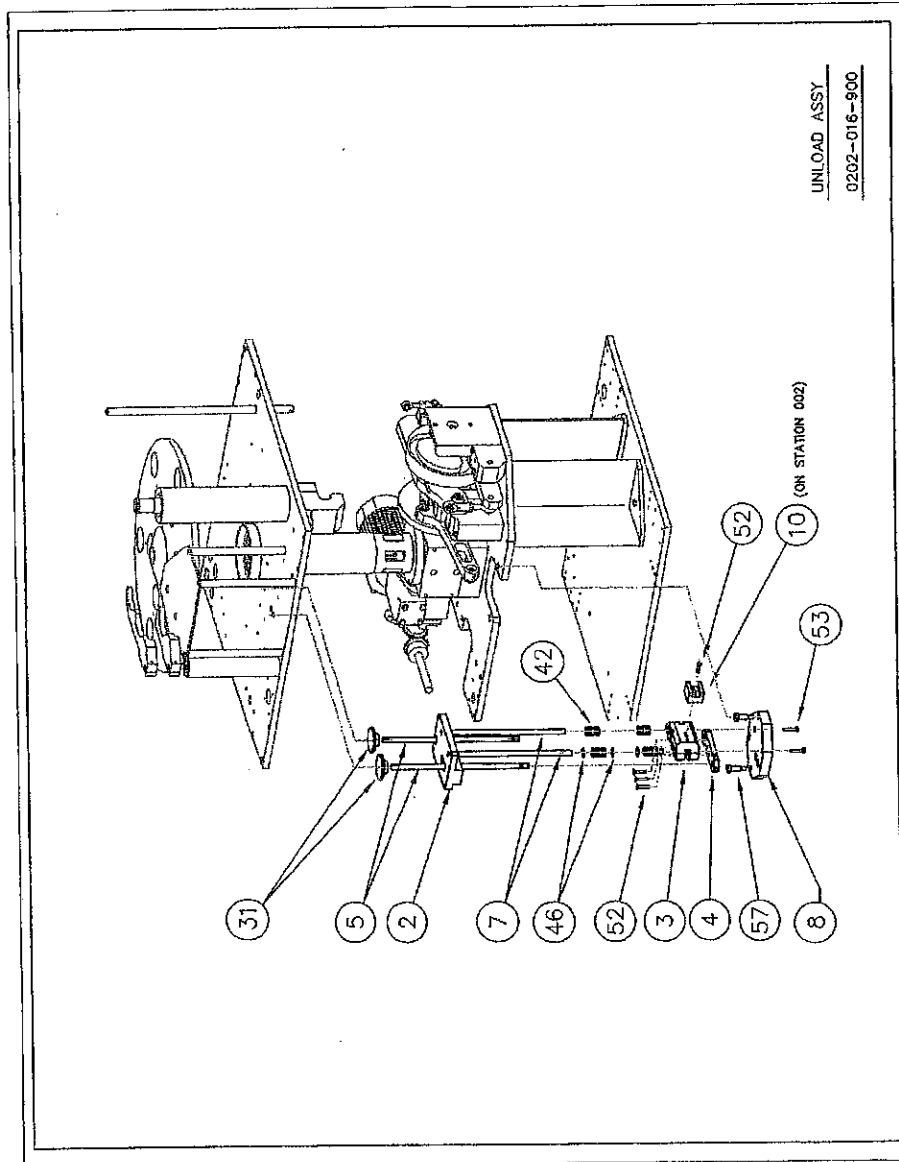
**Part of Tooling Package



Unload Assy-0202-016-900

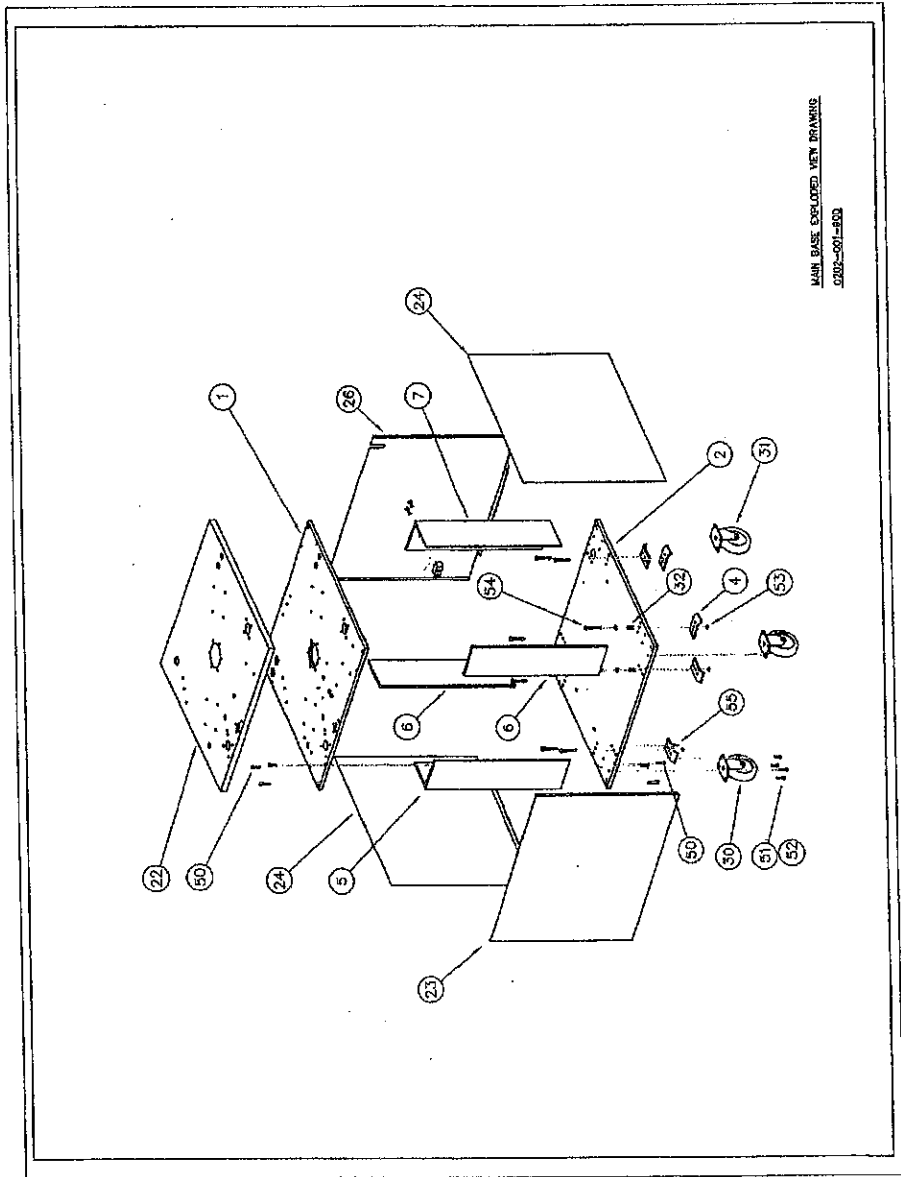
<u>Item No.</u>	<u>P/N</u>	<u>Description</u>	<u>Parts per Assembly</u>
2	0202-016-041	Mounting Block Guide Shaft	1
3	0202-016-042	Unload Lift Plate	1
4	0201-016-013	Unload Safety Bar	1
5	0201-016-014	Shaft-Cup Lift	2
7	0202-016-037	Shaft-Cup Lift Guide	2
8	0202-016-038	Unload Reset Plate	1
10	0101-002-020	Lift Rail Unload	1
31	0201-016-051	Cup Lift Puck	**
42	0201-016-602	Bearing Linear-50x.875x1.25	4
46	0202-016-609	Retainer Ring for .82 groove	8
52	Hardware	Flat HD 1/4-20x1.25 Lg	5
53	Hardware	Hex Hd 1/4-20 x .75 Lg	2
57	Hardware	Soc Hd Cap Scr 1/4-20 x 1.0 Lg	2

**Part of Tooling Package



Main Base-0202-001-900

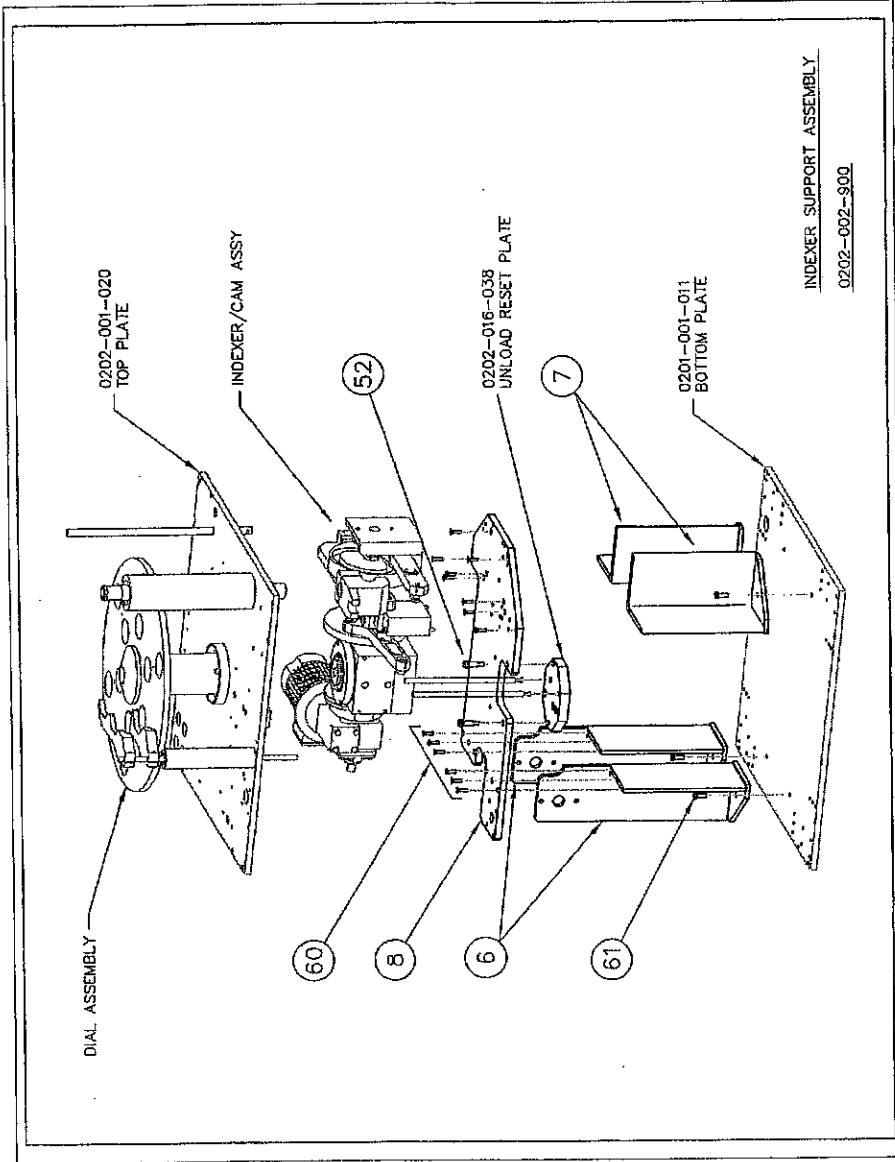
<u>Item No.</u>	<u>P/N</u>	<u>Description</u>	<u>Parts per Assembly</u>
1	0202-001-020	Top Plate	1
2	0201-001-011	Bottom Plate	1
4	0201-001-013	Guard Lock	8
5	0201-001-014	Riser-Angle	1
6	0201-001-015	Riser Plate	2
7	0201-001-016	Riser-Angle w/ MTG Holes	1
22	0202-001-511	Top Cover	1
23	0201-001-502	Guard-Side Cover Folded	1
24	0201-001-503	Guard-Side Cover Flat	2
26	0201-001-504	Guard-Side Cover Folded w/cutout	1
30	0201-001-600	Caster-Rigid Poly 2 Urethane	2
31	0201-001-601	Caster-Locking Swivel	2
32	0201-001-602	Spring-Comp Guard Lock	8
50	Hardware	1/4-20x1 1/4 FHSCS	24
51	Hardware	1/4-20x 3/4 HCS	32
52	Hardware	1/4 Flat Washer	8
53	Hardware	1/4-20 Jam Nut	16
54	Hardware	1/4-20 x 2 HCS	8
55	Hardware	1/4-20 x 1 1/4 HCS	8



MAIN BASE EXPLODED VIEW DRAWING
0282-501-609

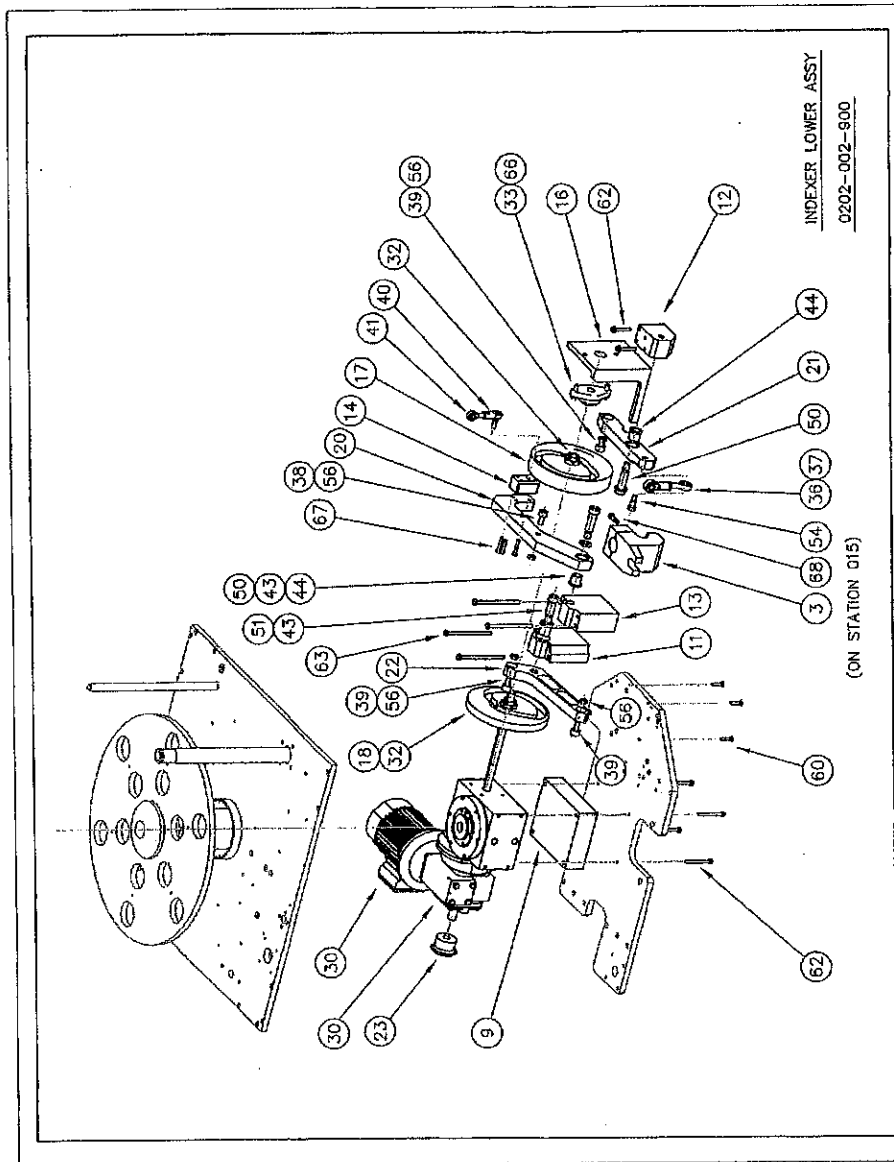
Indexer Support Assy-0202-002-900

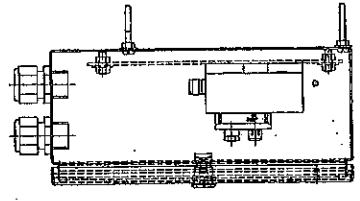
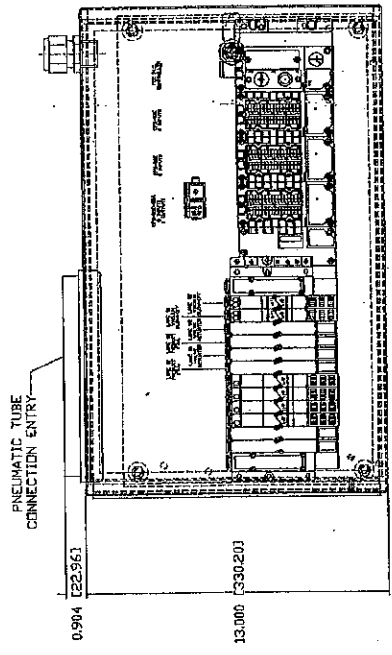
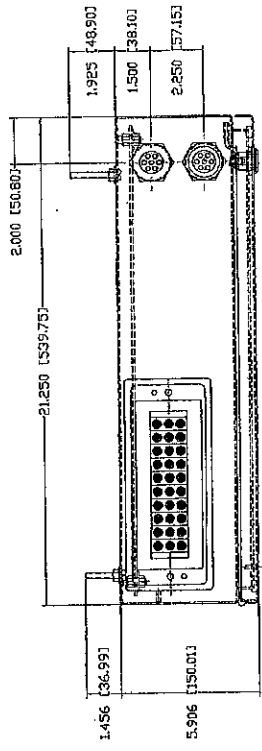
<u>Item No.</u>	<u>P/N</u>	<u>Description</u>	<u>Parts per Assembly</u>
6	0202-002-048	Drive Leg Cup Drop	2
7	0101-002-017	Drive Leg	2
8	0202-002-043	Drive Plate	1
52	Hardware	1/2" Dia x 1" Lg w/ 3/8 x 16 thd	2
60	Hardware	1/4-20 x 1 1/4 FHSCS	14
61	Hardware	3/8-16 x 1 HCS	4



Indexer Lower Assembly-0202-002-900

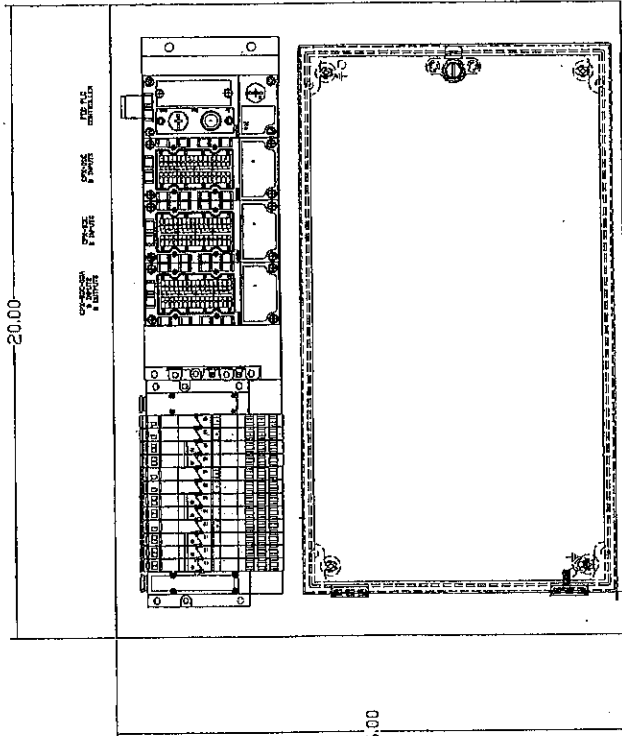
<u>Item No.</u>	<u>P/N</u>	<u>Description</u>	<u>Parts per Assembly</u>
3	0201-015-012	Anti Rotate Lift Coupler	1
9	0202-002-044	Mount indexer	1
11	0202-002-039	Block-Unload Pivot	1
12	0101-002-022	Block-Heat Seal Pivot	1
13	0101-002-023	Block-Foil Place Pivot	1
14	0101-002-024	Lever Extension Foil Place	1
16	0101-002-026	Mount Drive Bearing	1
17	0202-002-045	Cam-Dual Foil PLC Heat Seal	1
18	0202-002-046	Cam-Unload	1
20	0101-002-030	Lever Foil Place	1
21	0101-002-031	Lever Heat Seal	1
22	0202-002-040	Lever Unload	1
23	0202-002-047	Gear-Miter Short	1
30	0202-002-620	Stelron Indexer RD-75	1
32	0101-002-602	Trantorque-Standard Series	2
33	0101-002-603	Bearing 3/4" ID 2 Bolt Flange	4
36	0101-002-606	Spherical Rod End Male .5000"	1
37	0101-002-607	Spherical Rod End Female .5000"	1
38	0101-002-608	Cam Follower 3/4 Dia Roller	1
39	0101-002-609	Cam Follower 7/8 Dia Roller	3
40	0101-002-610	Spherical Rod End Female 3/8	1
41	0101-002-611	Spherical Rod End Male 3/8	1
43	0101-002-613	Washer-Thrust Stainless Steel	3
44	0101-002-614	Bearing-Bronze Bushing	2
50	Hardware	Bolt 3/4" Dia x 2.00" Lg w/ 5/8-11 THD	2
51	Hardware	Bolt 3/4" Dia x 1.50" Lg w/ 5/8-11 THD	1
54	Hardware	Bolt 1/2" Dia x 1.50" Lg w/ 3/8-16 THD	1
56	Hardware	Nut - Jam 7/16 - 20	4
60	Hardware	1/4-20 x 1 1/4 FHSCS	14
62	Hardware	5/16 - 18 x 3 1/2 HCS	6
63	Hardware	5/16 - 18 x 5 HCS	4
66	Hardware	3/8 - 16 x 1/4	10
67	Hardware	1/4-20 x 1 1/2 HCS	2
68	Hardware	5/16 - 18 x 1 3/4 HCS	4





Automation Solutions
 Innovative Solutions by Design
 Mequon, WI

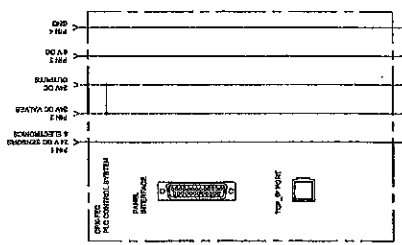
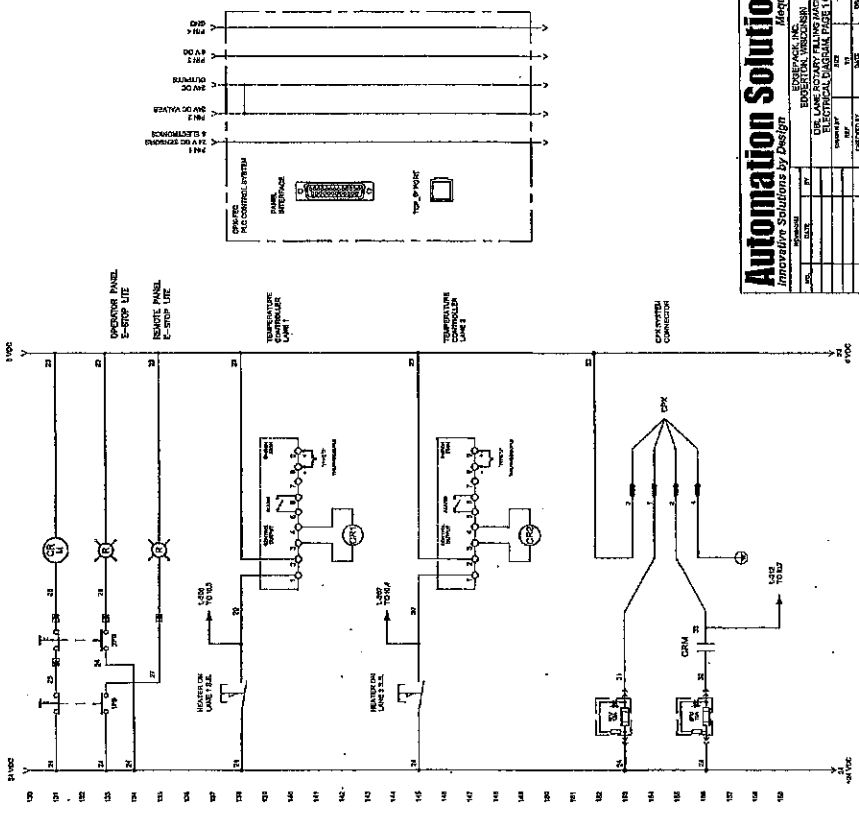
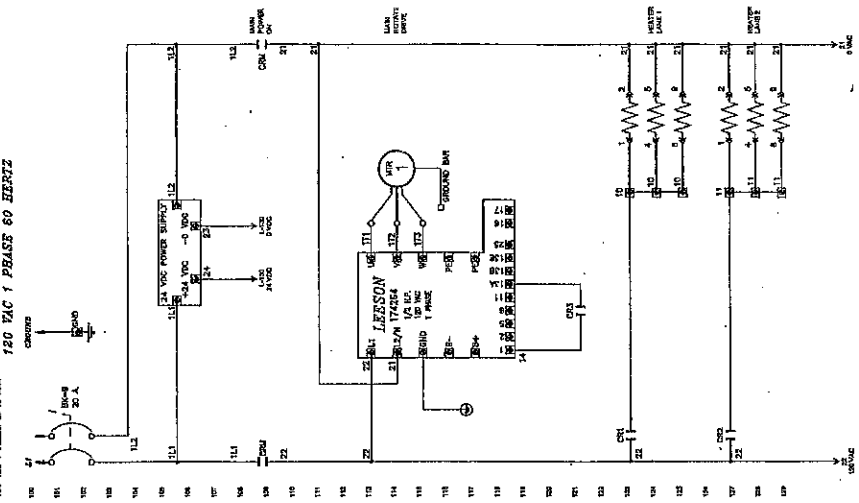
NO.	REV.	DATE	BY	CHKD.	DESCRIPTION
1	1	02/26/04	REP	REP	DBL. LAKE ROTARY FILLING MACHINE CPX PANEL LAYOUT
					JOB NUMBER
					DATE
					DRAWN BY
					CHECKED BY
					DATE
					JOB NUMBER
					DATE



Automation Solutions
 Innovative Solutions by Design
 Edgerton, WI

DATE	BY	EDGERTON, WISERSEN
REVISED		
		DBL LANE ROTARY FILLING MACHINE
		DRAWN BY
		CHECKED BY
		DATE
		QUANTITY
		JOB NUMBER
		DRAWING NUMBER
		H-S&M-00

120 VAC 1 PHASE 60 HERTZ



Automation Solutions
Innovative Solutions by Design

EXPERIENCE, INC.
 3000 WISCONSIN AVENUE
 MILWAUKEE, WI 53212
 TEL: 414-224-1111
 FAX: 414-224-1112
 WWW: WWW.AUTOSOL.COM

DATE: _____
 CHECKED BY: _____
 DESIGNED BY: _____

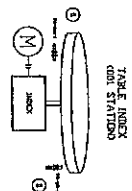
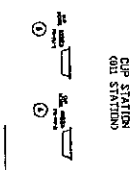


TABLE INFED
CUP STATION
OIL STATION



DIP STATION
OIL STATION

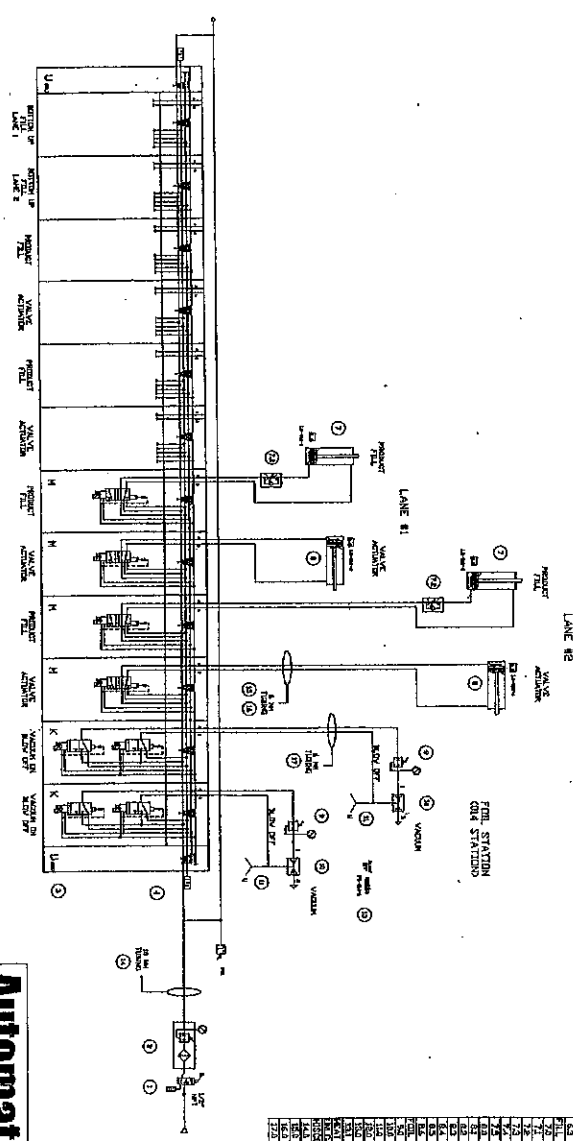
FILL STATION #1
(OIL STATION)

LANE #2

LANE #1

HEAT SEAL STATION
OIL STATION

UNLOAD STATION
OIL STATION



ADD-IN
FUNCTIONS

STANDARD
STATION

Automation Solutions
Innovative Solutions by Design

EDWARD J. JENSEN
Madison, WI

REVISIONS		DATE		BY	
1	NO	11/10/04	EDJ	EDJ	EDJ
2	NO	11/10/04	EDJ	EDJ	EDJ
3	NO	11/10/04	EDJ	EDJ	EDJ

DOB LANE ROTARY FILLING MACHINE
BASE MACHINE CONFIGURATION

REV. DATE SIZE JOB NUMBER

CHANGED BY DATE DRAWING NUMBER

REV. DATE DRAWING NUMBER

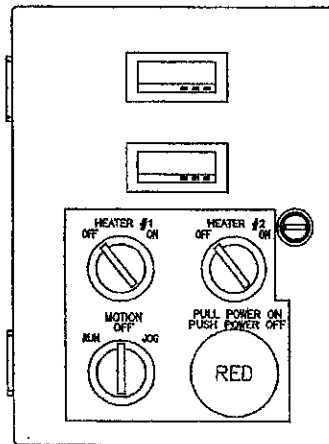
NO.	DESCRIPTION	QTY.	UNIT	PRICE	TOTAL
1	TABLE INFED CUP STATION OIL STATION	1	UNIT	1000.00	1000.00
2	DIP STATION OIL STATION	1	UNIT	500.00	500.00
3	FILL STATION #1 (OIL STATION)	1	UNIT	1000.00	1000.00
4	LANE #2	1	UNIT	1000.00	1000.00
5	LANE #1	1	UNIT	1000.00	1000.00
6	HEAT SEAL STATION OIL STATION	1	UNIT	1000.00	1000.00
7	UNLOAD STATION OIL STATION	1	UNIT	1000.00	1000.00
8	ADD-IN FUNCTIONS	1	UNIT	1000.00	1000.00
9	STANDARD STATION	1	UNIT	1000.00	1000.00
10	BASE MACHINE CONFIGURATION	1	UNIT	1000.00	1000.00
11	DOOR	1	UNIT	1000.00	1000.00
12	CONVEYOR	1	UNIT	1000.00	1000.00
13	WARRANTY	1	UNIT	1000.00	1000.00
14	INSTALLATION	1	UNIT	1000.00	1000.00
15	TRAINING	1	UNIT	1000.00	1000.00
16	TESTING	1	UNIT	1000.00	1000.00
17	DELIVERY	1	UNIT	1000.00	1000.00
18	TOTAL				10000.00

Heater station #1 (inside lane) switch.
"ON" position provides power to heating elements and allows fill station and foil place station to function.

Motion Selector Switch
Shown in "OFF" position, machine will not run.

Placing switch in "RUN" position allows machine to run until switch is moved to "OFF" position.

Placing switch in "JOG" position allows machine to run as long as switch is held in that position. Releasing switch allows it to return to "OFF" position.



Heater station #2 (outside lane) switch.
"ON" position provides power to heating elements and allows fill station and foil place station to function.

This is the main power button.
"PULL" button turns power ON.
"PUSH" button turns power OFF.

LEESON

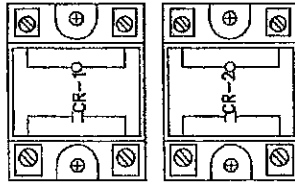
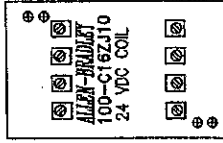
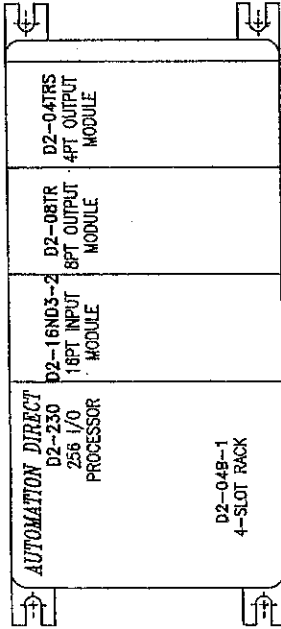
174264

120 VAC / 1 PHASE
1/2 H.P.
VARIABLE SPEED MOTOR CONTROLLER

AUTOMATION DIRECT

PS-24-750

24 VDC 75 WATT
POWER SUPPLY



⊗	BK-1	BK-2	BK-3	BK-4	BK-5	BK-6	BK-7	BK-8	BK-9	⊗
	0.5A	0.5A	0.5A	0.5A	0.5A	0.5A	0.5A	0.5A	20A	

