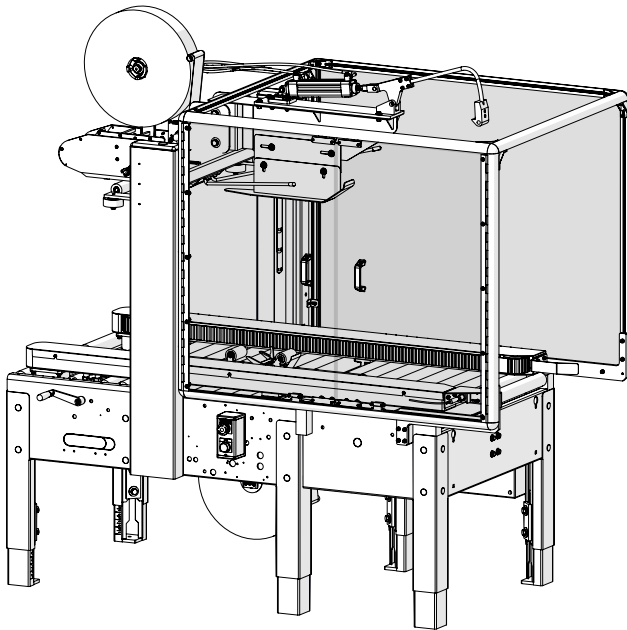




USER MANUAL

UA 262024-SB



For Serial Numbers:
CST140 XX X XXX



USER NOTES

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TECHNICAL ASSISTANCE

This is the Interpack Model **Uniform Automatic (UA 262024-SB)** Side-Belt Case Sealer you ordered. It has been set up and tested in our factory with Intertape manufactured pressure sensitive tapes (acrylic or hot melt). If any problems occur when setting up or operating this equipment, please contact the authorized distributor from where you purchased this item.

If contact with the authorized distributor is not possible, **IPG Machinery Support** is available. Should the need to contact **IPG Machinery Support** arise, **please have the equipment model and serial number available prior to contact**. This information can be found on the nameplate of the tape head as well as on the machine, both sets of information may be necessary to assist. A section at the bottom of this page is available to write this information down. **IPG Machinery Support** is available during normal business hours (M-F 8am-7pm) Eastern Time.

Phone: 813-345-3070

Email: machsupp@itape.com

Replacement Parts

A breakdown of parts, including part numbers, can be found in the appendix of this manual. If you know the part number that you require please contact your authorized distributor or IPG Customer Service 877-447-4832 Option 3

Please use this area to enter the detailed information on your Case Sealer and Tape Heads. This should be filled out at the time of install. This information can be found on the nameplate of the machine, typically on the side the electrical box is on. On pressure sensitive tape the nameplate is located on the same side the tape is loaded from. On the WAT Tape Heads serial information can be found near the air intake of the head.

Machine

Tape Head Top

Model

Model

Serial

Serial

Tape Head Bottom (if applicable)

Model

Serial

Distributor

Date of Purchase

Name

Date of Install

Phone/Email

FIELD SERVICE ASSISTANCE

Your Interpack Case Sealer and Tape Heads are designed to provide years of trouble free operation. This is not without proper preventative maintenance, a recommended schedule can be located in the maintenance section of this manual, performed by the end user of the equipment. If any problems arise with this machine during the normal course of operation, your properly trained and qualified internal service personnel should be able to repair any issues after consulting the troubleshooting section of this manual in conjunction with phone and/or email support from IPG Machinery Support.

Field Service Support is available from your IPG Authorized Distributor at additional cost if the problem cannot be remedied after consulting the troubleshooting section of this manual.

IPG offers comprehensive programs that help keep your equipment up and running.

Proactive maintenance efforts help to prevent equipment failures and costly emergency repairs. Keeping your machine in optimal working condition also enhances employee safety, reduces facility downtime and efficiently allocates internal resources.

Please contact your IPG Representative to discuss the best options for your IPG equipment.

WARRANTY INFORMATION

EQUIPMENT WARRANTY AND LIMITED REMEDY: The following warranty is made in lieu of all other warranties, express or implied, including, but not limited to, the implied warranty of merchantability, the implied warranty of fitness for a particular purpose, and any implied warranty arising out of a course of dealing, a custom or usage of trade:

Intertape sells its Interpack Tape Heads, Case Tapers and Case Erectors with the following warranties:

1. The IPG Pressure Sensitive Tape Heads' knife blades, springs and wipe down rollers will be free from all defects for a period of ninety (90) days.
2. All other IPG Pressure Sensitive Tape Head parts will be free from all defects for one (1) year after delivery.
3. Water Activated Tape Heads' blades will be free from defects for ninety (90) days after delivery.
4. Drive Belts will be free from defects for ninety (90) days after delivery
5. The Gear Motors will be free from defects for one (1) year after delivery.
6. All other components for Case Tapers and Case Erectors will be free from defects for one (1) year after delivery.

If any part is proven defective within its warranty period, then the exclusive remedy and Intertape's and the seller's sole obligation shall be, at Intertape's option, to repair or replace the part, provided the defective part is returned immediately to Intertape's factory or an authorized service station designated by Intertape.

A part will be presumed to have become defective after its warranty period unless the part is received or Intertape is notified of the problem no later than five (5) calendar days after the warranty period.

If Intertape is unable to repair or replace the part within a reasonable time, then Intertape, at its option, will replace the equipment or refund the purchase price. Intertape shall have no obligation to install the repaired or replacement part.

Intertape shall have no obligation to provide or pay for the labor required to install the repaired or replacement part.

Intertape shall have no obligation to repair or replace (1) those parts failing due to: operator misuse, carelessness, or due to any accidental cause other than equipment failure, or (2) parts

1. Failure or damage is due to misapplication, lack of proper maintenance, abuse, improper installation or abnormal conditions such as temperature, moisture, dirt or corrosive matter, etc.
2. Failure due to inadequate cleaning, improper operating environment, improper utilities or operator error.
3. Failure due to operations above the rated capacities, or in any other improper manner, either intentional or otherwise.
4. Failure is due to equipment, which has been altered by anyone other than an authorized representative of Intertape Polymer Group.
5. Failure is due to an attempt by the purchaser to correct alleged defective equipment. In this event the purchaser is responsible for all expenses incurred.

LIMITATION OF LIABILITY: Intertape and seller shall not be liable for direct, indirect, special, incidental or consequential damages based upon breach of warranty, breach of contract, negligence, strict liability or any other legal theory.

The foregoing Equipment Warranty and Limited Remedy and Limitation of Liability may be changed only by written agreement signed by authorized officers of Intertape and seller.

GENERAL INFORMATION

Description of UA 262024-SB

This machine is designed to provide years of trouble free operation. If any problems arise with this machine during the normal course of operation, your properly trained and qualified internal service personnel should be able to repair any issues after consulting the Troubleshooting section of this manual.

The Interpack UA 262024-SB Case Sealing Machine with HSD® 2000-ET 2Plus Tape Heads is designed to apply Intertape brand pressure sensitive case sealing tape to the top and bottom center seam of regular slotted corrugated (RSC) cases. The UA 262024-SB is manually adjustable to a variety of case sizes.

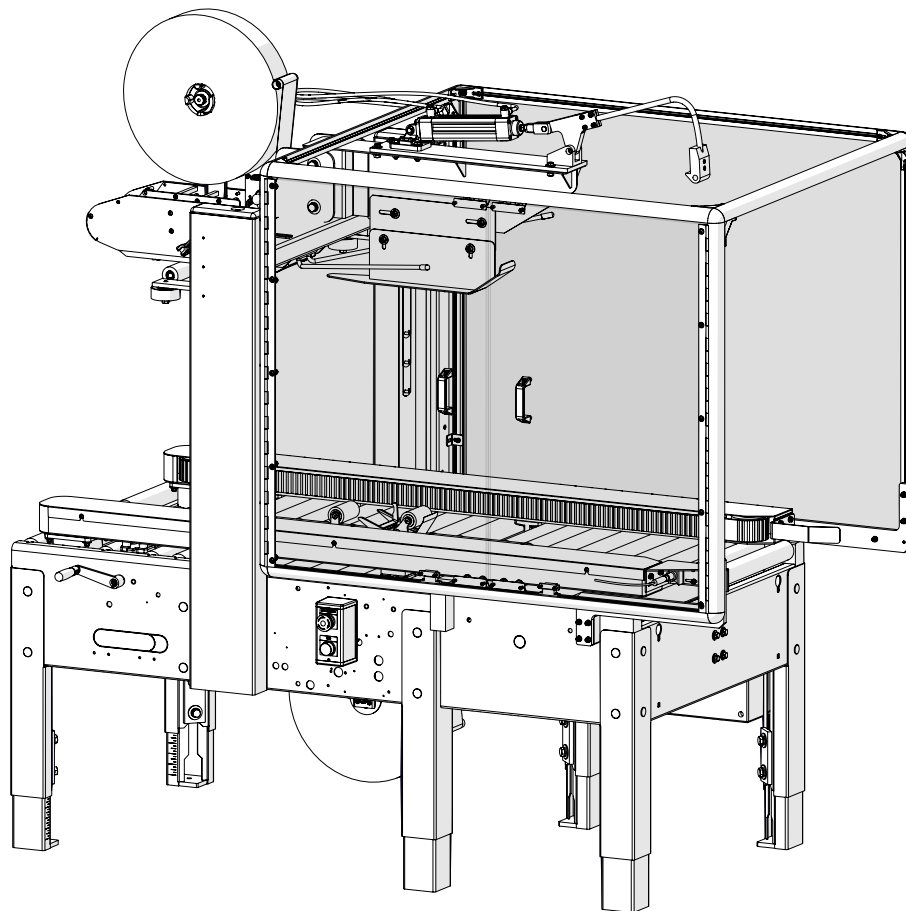


Figure 1: UA 262024-SB

Definitions

Common terms that will be used throughout this manual.

Tape Head – This will refer to the IPG branded tape heads for the remainder of this manual, these may be HSD 2000 ET 2Plus or ET Xtreme™

Case Sealer – Refers to IPG manufactured Case Sealers

Machine System – Refers to the fully assembled Case Sealer with the Tape Head(s) installed

User/Operator – The individual who has been trained on the daily use of the Machine System

Maintenance Champion – The individual(s) who work for the end user of the Machine System who are responsible for conducting general and preventative maintenance

OPTIONAL EQUIPMENT

The UA 262024-SB can be outfitted with a variety of optional equipment. The below list is **not standard** and should be discussed with your distributor or authorized IPG representative if you would like them to be added to your machine.

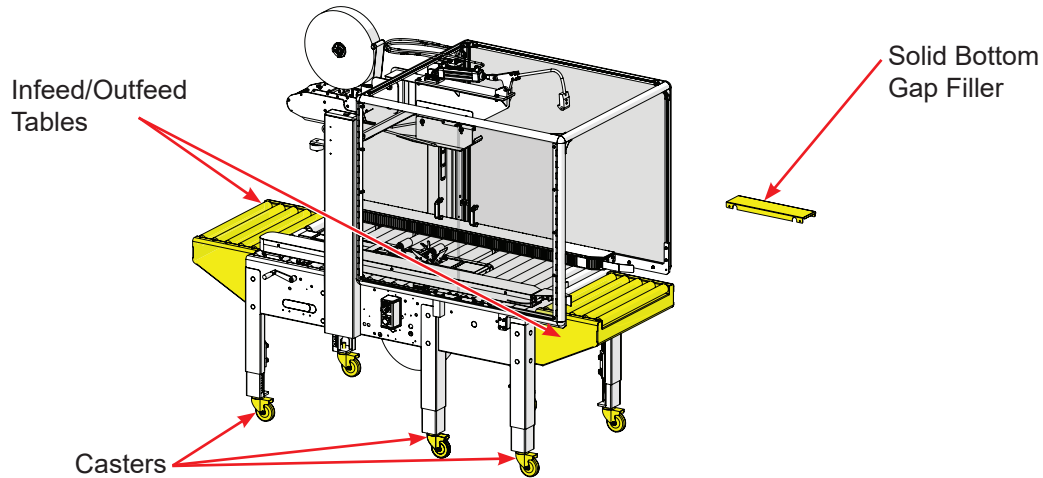


Figure 2: Optional Equipment

Additional Tape Heads

It is recommended to keep a spare tape head in the event any failure or malfunction causes the machine to stop production. This is to help reduce any possible downtime.

Description	Item Number
HSD 2000-ET II+ 2"	UH275TW
HSD 2000-ET II+ 3"	UH775TW
ET Xtreme™ 2"	UH230TW
ET Xtreme™ 3"	UH430TW

Can be installed on site

Description	Item Number	Quantity Per Machine
Solid Bottom Gap Filler	UPM3655	1
Feed Table 16" (.4M)	UM894T	2
Feed Table 24" (.6M)	UM998T	2
Feed Table 36" (.9M)	UM898T	2
Casters	UM708	1 set of 6 (36" Feed Table will require 2 additional casters)

Recommended to be installed at the factory

Description	Item Number	Quantity Per Machine
Secondary Emergency Stop	UM9003	1
4" Drive Bases	USM8127 (right) and USM8128 (left)	1 and 1
Reverse Electrical Box	UM085	1
Reverse Operator Control and Safety Gates	UM003	1
Low Tape No Tape Box	UH1426	1
Ski Nose Affix	UPM7469	

IMPORTANT SAFEGUARDS

There are a number of safety labels used on the UA 262024-SB Case Sealer. These labels are placed at different locations on the machine to warn operators and service personnel of possible dangers. Please read the labels on the machine and the following safety precautions before using the machine.

Read this manual for other important safety operating and service information.

Only trained personnel are to operate machine.

Only fully qualified technicians are to service this machine.

Wear safety glasses.

Shut off power to machine before adjusting machine or loading & threading Tape Heads.

Disconnect electrical power and compressed air (where applicable) before servicing.

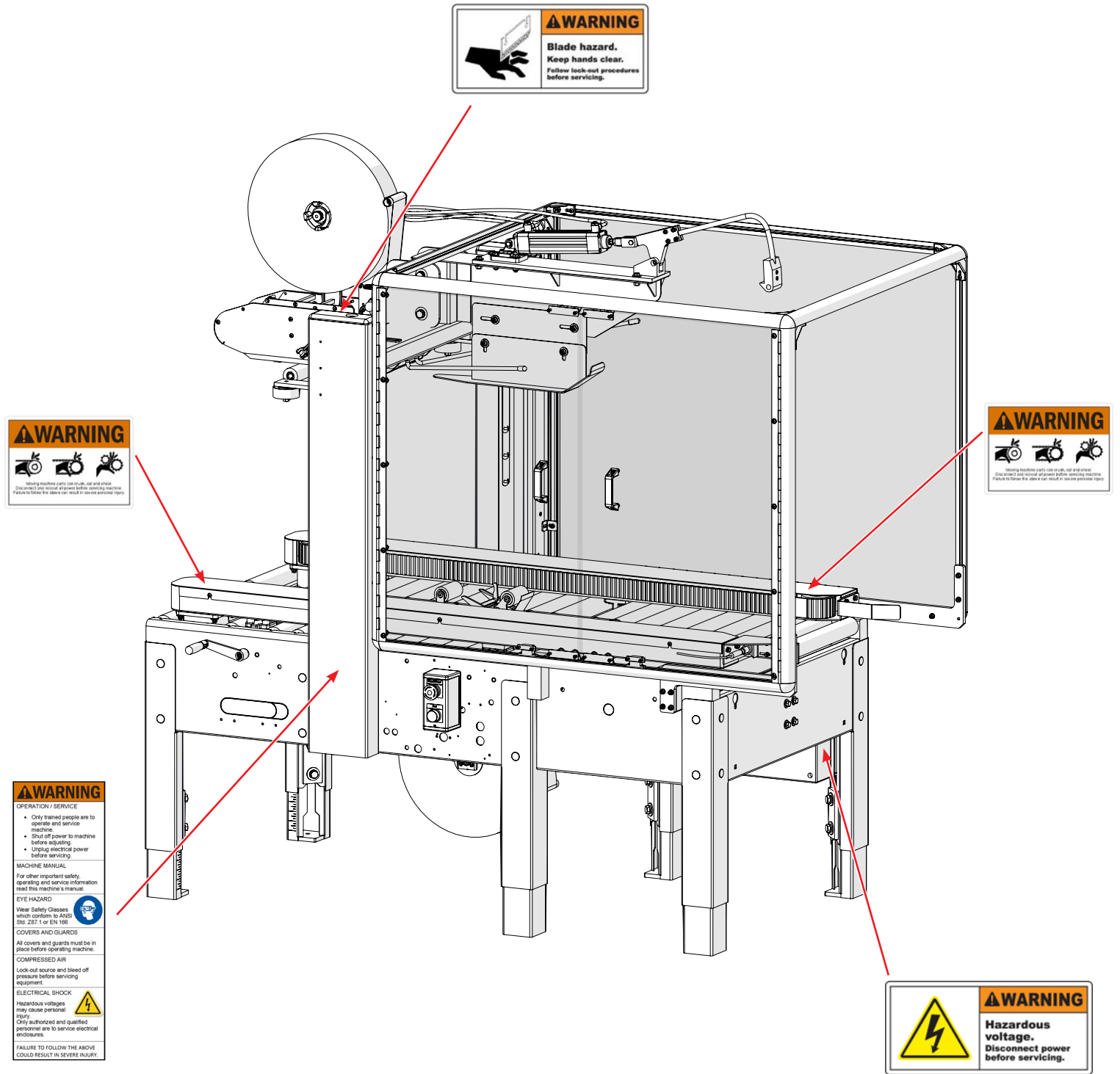
Follow Lock Out / Tag Out Procedures BEFORE servicing any machinery.

All factory installed covers and guards must be in place before operating.

Stay clear of moving parts which can shear and cut.

Should any of the safety labels on the Case Sealer be damaged or destroyed, replacements can be ordered through your distributor.






SAFETY LABEL PLACEMENT



Located on Electrical Box

Figure 3: Safety Label Placement

SAFETY LABEL DESCRIPTIONS

<p>The label shown is affixed to the upper tape head assembly on both sides of the machine.</p> <p>It warns operators and service personnel of the presence of the cutting blade that may not be visible. Caution should be exercised when approaching this area.</p>	 <p>Figure 4: Blade Hazard</p>
<p>The label shown is affixed to the upper tape head assembly on either side of the machine.</p> <p>It warns operators and service personnel of the presence of the cutting blade that may not be visible. Caution should be exercised when approaching this area.</p>	 <p>Figure 5: Sharp Hazard</p>
<p>The label shown is affixed to the bridge above the vertical intake.</p> <p>It warns the operator of potential pinch points between the top and bottom of the case. Keep hands away from this area when processing a case.</p>	 <p>Figure 6: Pinch Point</p>
<p>The label shown is located on the in-feed and exit ends of the machine belt drives.</p> <p>The label warns the operators and service personnel of the pinch points at each end of the belt drives.</p>	 <p>Figure 7: Drive Base Hazard</p>
<p>The label shown is affixed to the electrical control box.</p> <p>The label advises service personnel to connect the machine to a properly grounded outlet.</p>	 <p>Figure 8: Hazardous Voltage</p>

SAFETY LABEL DESCRIPTIONS CONTINUED

The label shown is affixed to the electrical control box.

The label advises service personnel to connect the machine to a properly grounded outlet.



Figure 9: Ground Connection

The label shown is located on the side of the column.

This label provides convenient safety instructions for the operator and service personnel in the operation of the Intertape Case Sealing Equipment.

UPM2012



Figure 10: Safety Instructions

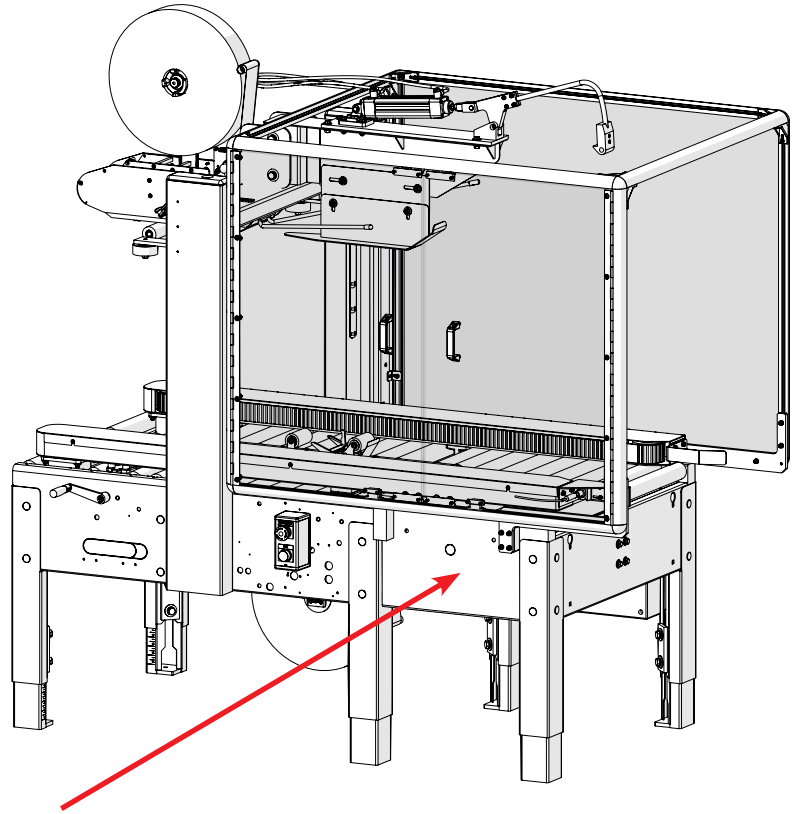
The label shown is located on the gear side of the machine.


The label warns the operators and service personnel of the pinch points.



Figure 11: Gear Pinch Point

MACHINE NAMEPLATE





MODEL	UA 262024-SB	VOLTS	110
SER. NO.	TM09523A001	HZ	60
HP	2x 1/3HP	PH	1
P.S.I.	60	AMPS	7.6
C.F.M.	9	SCCR	
DWG #			

Intertape Polymer Group™
Technical Support & Spare Parts (800) 474-8273 x4303
An Interpack™ Design Manufactured in Taiwan.

Machine Identification and Motor Power

Machine Electrical Requirements

Machine Pneumatic Requirements if applicable

Applicable Machine Drawing Number

Manufacturer Details

Figure 12: Machine Nameplate

Reading Interpack Serial Numbers

Model Identifier	Year and Month of Manufacture	Machine Production Number
CST095	23A	001

Should any of the safety labels on the Case Sealer be damaged or destroyed, replacements can be ordered through your distributor.

IMPORTANT SAFEGUARDS

Explanation of Signal Word Consequences



WARNING: INDICATES A POTENTIALLY HAZARDOUS SITUATION, WHICH IF NOT AVOIDED COULD RESULT IN DEATH OR SERIOUS INJURY OR PROPERTY DAMAGE



CAUTION: INDICATES A POTENTIALLY HAZARDOUS SITUATION, WHICH IF NOT AVOIDED COULD RESULT IN MINOR OR MODERATE INJURY OR PROPERTY DAMAGE



WARNING

- 1. To reduce the risk associated with mechanical, pneumatic, and electrical hazards:**
 - Read, understand, and follow all safety and operating instructions before operating or servicing the Case Sealer and/or Tape Head
 - Allow only properly trained and qualified personnel to operate and service this equipment
- 2. To reduce the risk associated with pinches, entanglement, and hazardous voltage:**
 - Turn electrical supply off and disconnect before performing any adjustments, maintenance, or servicing the Case Sealer or Tape Head
- 3. To reduce the risk associated with pinches and entanglement hazards:**
 - Do not leave the Case Sealer running while unattended
 - Turn the Case Sealer off when not in use
 - Never attempt to work on any part of the Case Sealer, Tape Head, load tape, or remove jammed boxes from the Case Sealer while the machine is running
- 4. To reduce the risk associated with hazardous voltage**
 - Position electrical cord away from foot traffic and vehicle traffic
 - Do not operate the Case Sealer with a damaged power cord
- 5. To reduce the risk associated with sharp blades hazards:**
 - Keep hand and fingers away from the tape cutoff blades, the blades are very sharp
- 6. To reduce the risk associated with fire and explosion hazards:**
 - Do not operate this equipment in potentially flammable and/or explosive environments
- 7. To reduce the risk associated with muscle strain:**
 - Use the appropriate rigging and material handling equipment when lifting or repositioning this equipment
 - Use proper body mechanics when removing or installing Tape Heads that are moderately heavy or may be considered awkward to lift
- 8. To reduce the risk associated with mechanical, pneumatic, and electrical hazards:**
 - Allow only properly trained and qualified personnel to operate and service this equipment



CAUTION

- 1. To reduce the risk associated with pinch hazards:**
 - Keep hands clear of the upper head support assembly as boxes are transported through the Case Sealer
 - Keep hands, hair, loose clothing, and jewelry away from box compression rollers, moving belts, and Tape Heads
 - Always feed boxes into the Case Sealer by pushing only from the end of the box



CAUTION: TO AVOID INJURY THE MACHINE OPERATOR SHOULD REMAIN ATTENTIVE AND SHOULD NEVER REST THEIR HANDS, ARMS, HEAD, OR ANY OTHER BODY PART ON THE MACHINE.

IMPORTANT SAFEGUARDS

Operator Skill Level Descriptions

These descriptions and levels are uniform across all IPG Case Sealers

Skill “A” Machine Operator

This operator is trained to use the Case Sealer with the machine controls, to feed cases into the machine, make adjustments for different case sizes (USA series machines), to change tape, to start, stop, and restart production, and to clear jams and perform basic troubleshooting.

Important: The end user area supervisor must ensure that the operator has been properly trained on all machine functions before operating the machine.

Skill “B” Mechanical Maintenance Technician

Also referred to as the Maintenance Champion, this technician, is trained to use the Case Sealer as the Operator is able and in addition is able to work with the safety protection disconnected to check and adjust mechanical components, to perform maintenance operations and repair the Case Sealer. A skill “B” operator is not allowed to work on live electrical components.

Skill “C” Electrical Maintenance Technician

This technician is trained to use the Case Sealer as the Operator is able and in addition is able to work with the safety protection disconnected, to check and adjust mechanical components, to perform maintenance operations and repair the Case Sealer. A skill “C” operator is allowed to work on live electrical panels, terminal blocks, and control equipment.

Skill “D” Manufacturer Technician

Skilled technician sent by the manufacturer or its agent (distributors) to perform complex repairs of modifications, when agreed with the customer.

Operators skill level required to perform the following tasks on the Machine System

OPERATION	MACHINE CONDITION	OPERATOR SKILL LEVEL	NUMBER OF OPERATORS
Tape Roll Replacement	Stopped by pressing the Emergency Stop Button	A	1
Blade Replacement	Electrical Power Disconnected	B	1
Ordinary Maintenance and Preventative Maintenance	Electrical Power Disconnected	B	1
Extraordinary Mechanical Maintenance	Running with Safety Protections Disabled	C	1
Extraordinary Electrical and/or Pneumatic Maintenance	Running with Safety Protections Disabled	D	1
Drive Belt Replacement	Electrical Power Disconnected	B	1
Machine Installation & Set-Up	Running with Safety Protections Disabled	B & C	2

Proper Electrical Disconnect is achieved when the machine is unplugged from the electrical socket.

SPECIFICATIONS

UA 262024-SB Dimensions

Machine Weight: 650 lbs. (295 kg)

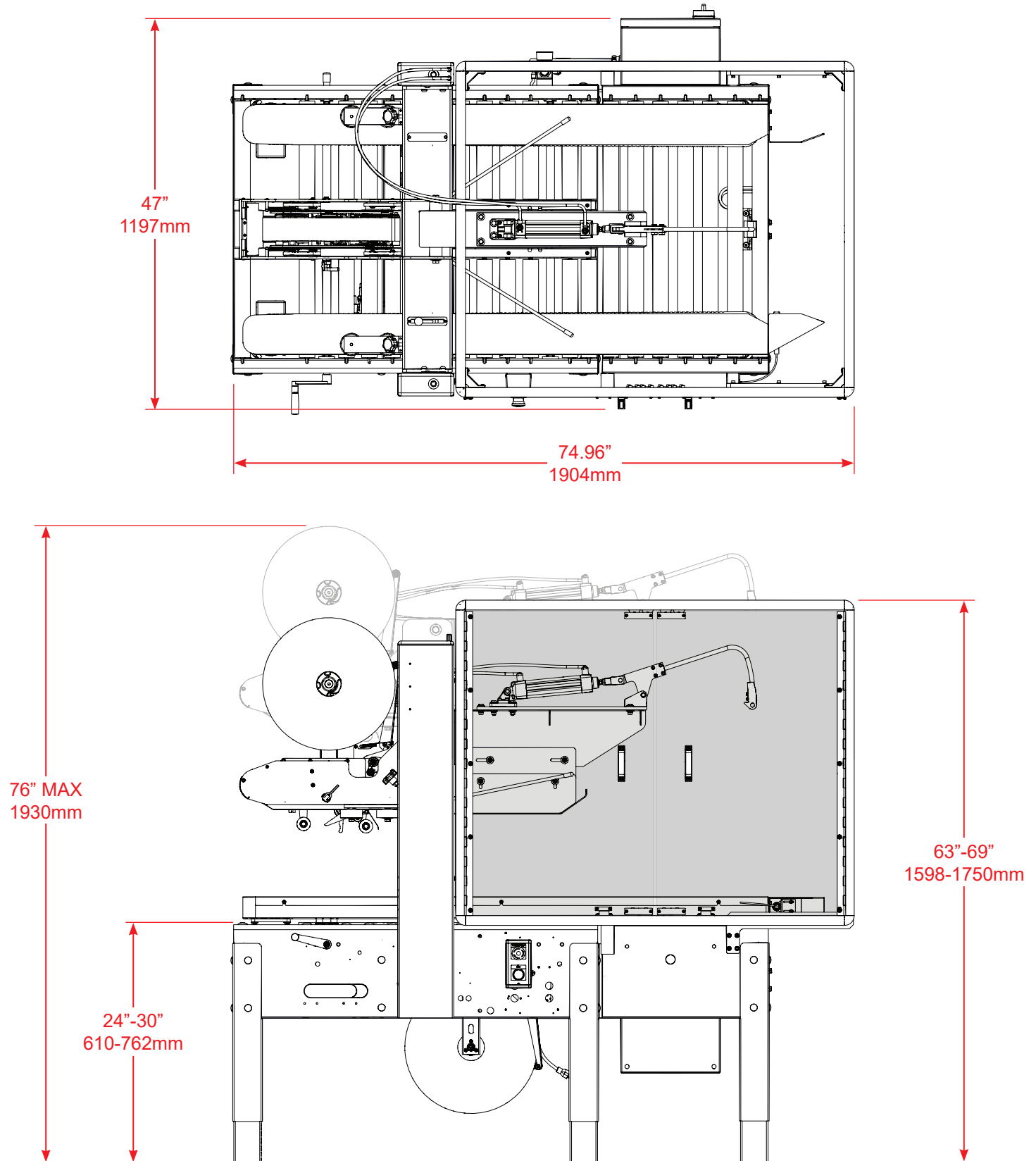


Figure 13: Machine Dimensions

SPECIFICATIONS

Machine Components

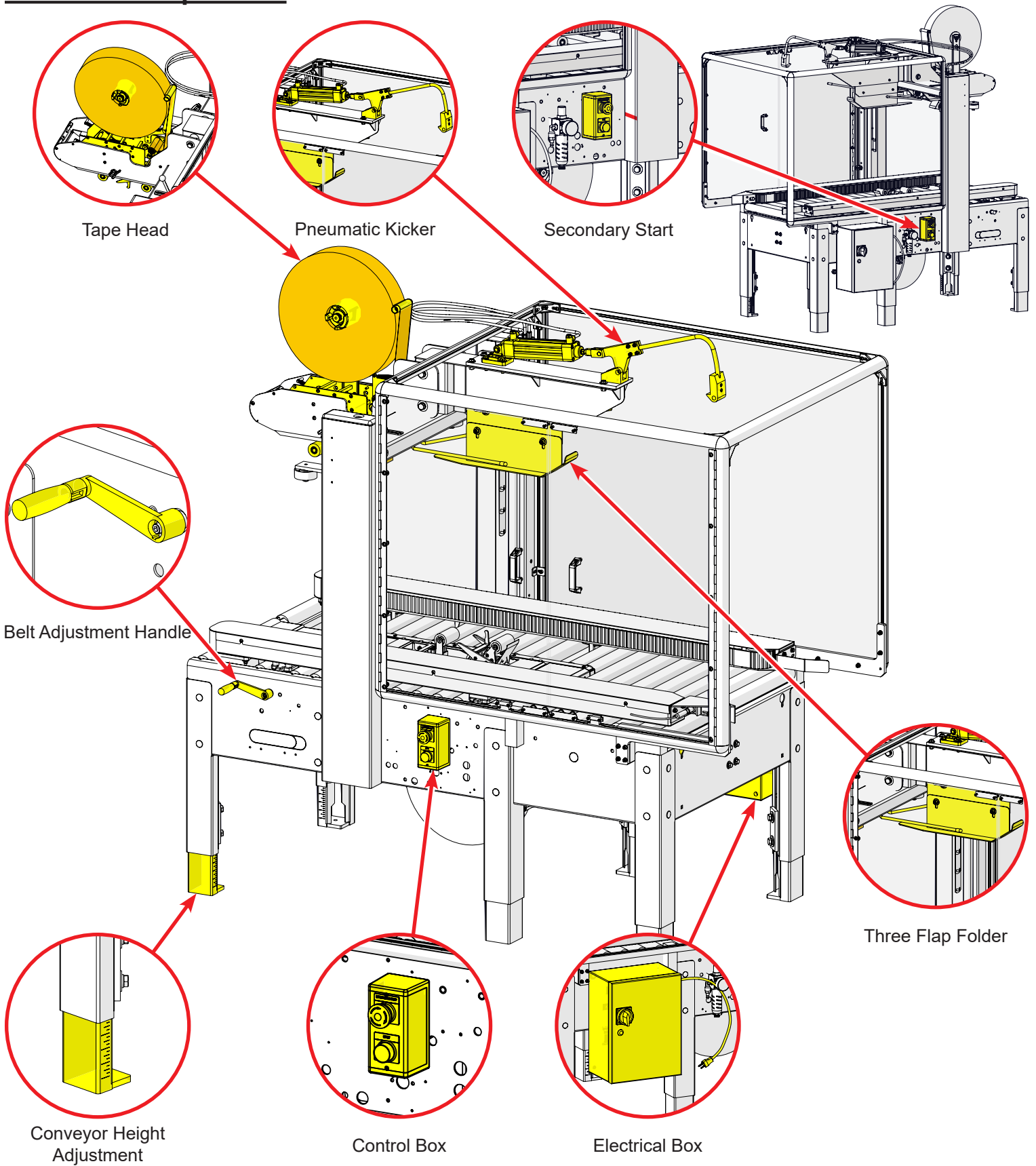


Figure 14: Machine Components

SPECIFICATIONS

Power Requirements

Electrical: **110v, 60HZ, 5A (550 Watts)**

This machine comes standard with two gear motors, one on each drive base, and a control box.

The control box contains a **Start** switch and an **Emergency Stop**. A 12 ft (3657.6mm) standard, three-conductor power cord with plug is provided for **110V, 60HZ, 15A** service. The receptacle providing this service **must** be properly grounded.

Pneumatic Requirements

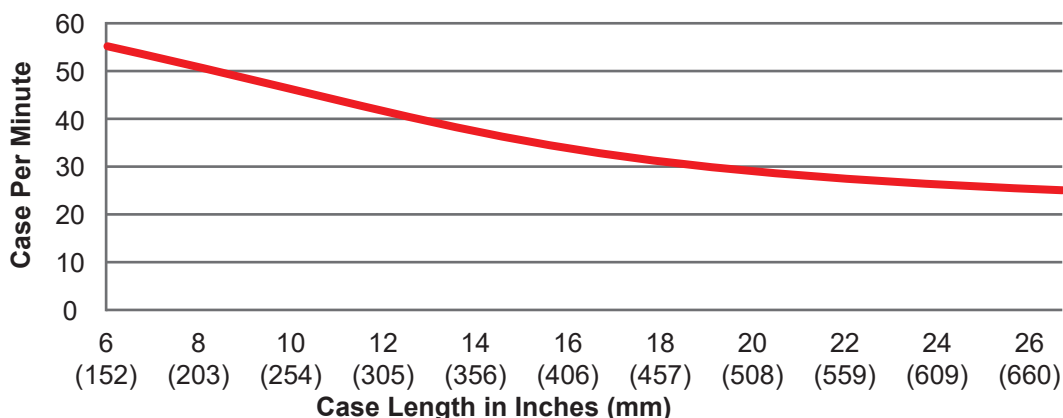
Compressed Air: **9CFM at 90PSI (28.3Liter/min at 620.5 kPa)**

This machine comes standard with one main regulator.

Air supply must be clean and dry. If moisture enters the system's valves they can begin to degrade and slowly clog lines. This can cause reduced air flow resulting in undesired machine behavior. A customer supplied inline air dryer may be necessary.

Operating Speed

Actual production rate is dependent on operator's dexterity and the case size mix. Belt speed is 82 ft/min, boxes must be separated by 14 in. (355.6mm).



Tape Specifications

Use only **Intertape Brand** Pressure Sensitive Tape. The machine can accommodate tape widths of 2 – 3 in. (48 - 75mm) depending on the tape heads supplied.

A maximum tape roll diameter of 16" (406mm) on a 3" (76mm) core can be installed on the tape heads. This machine can accommodate a variety of Intertape Brand tape. Consult the factory if a specific tape is needed for your application.

The standard tape leg length of 2.25" (57.2mm) is factory set. The standard tape leg length may vary up to ¼" (6mm) based on tape tension and line speed.

The standard tape leg length is adjustable +/- ¼" (6mm). Refer to the tape head manual for your tape heads for how to adjust the tape leg length.

Operating Conditions

Use in a dry, relatively clean environment at 40° to 105° F (5° to 40° C) with clean dry cartons.



CAUTION: MACHINE SHOULD NOT BE WASHED DOWN OR SUBJECTED TO CONDITIONS CAUSING CONDENSATION ON COMPONENTS.

SPECIFICATIONS

Carton Specifications

Type

- Regular Slotted Containers (RSC)
- Other styles may be processed. Consult factory.

Material

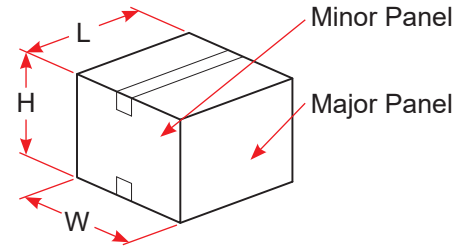
- 125 to 175 PSI bursting test, single or double wall, B or C flutes
- Other styles may be processed. Consult factory.

Weight

- 0 to 85 lbs. Max (0 to 38.5 kg)

Size

Carton Size	Length	Width	Height
Minimum	6" (152mm)	3.5" (89mm)	4.5" (114mm)
Maximum	26" (660mm)	20" (508mm)	24" (610mm)



If the box length (in the direction of the seal) to box height ratio is 0.75 or less, several boxes should be test run to assure proper machine performance. The formula is as follows:

$$\frac{\text{Carton Length in direction of seal}}{\text{Carton Height}} > 0.75$$

SET-UP PROCEDURE

Receiving and Handling

The Interpack UA 262024-SB is shipped to the customer in a box and fixed to a pallet. The machine is enclosed with either a corrugated sleeve and cap or an HSC corrugated box. The sequence below is step by step instructions to remove all packing materials.

PRIOR TO SIGNING FOR THE MACHINE INSPECT IT FOR ANY DAMAGE THAT MAY HAVE OCCURRED DURING SHIPPING

1. Remove the strapping and staples at the bottom of the box
2. Lift the box cover off of the machine, use caution and team lift
3. Inspect the machine for any damage that may have occurred during shipping
4. Remove the mounting bolts and nuts that secure the machine to the pallet
5. Using a forklift or other lifting device, lift the machine off the pallet
 - Install any optional casters at this point as well as adjusting leg height for desired conveyor height
6. Position the machine in its desired location
7. Remove any remaining tie wraps and shipping materials
8. Install any optionally ordered equipment

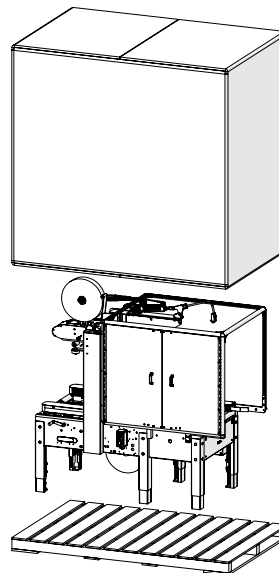


Figure 15: Unboxing

After unpacking the Case Sealer, look for any damage that may have occurred during shipping. Should the Case Sealer be damaged, file a claim with the transport company and notify your IPG representative as soon as possible.

Set up

The Case Sealer must be installed on a near level ground. Use the adjustable legs to ensure the machine is level and firmly planted on the ground (no rocking). Adjust the leg height with the four (4) telescopic adjustment legs to accommodate conveyor heights from 24 to 30 inches (609 to 762mm). Consult with the factory for any other conveyor heights that may be required. The UA 262424-SB cannot achieve a conveyor height lower than 22" without moving the electrical cabinet.

To adjust the Case Sealer height, jack up the machine to give ample room to extend the legs. Using a 19mm box end wrench, loosen the eight (8) M12mm hex locking bolts. Adjust the legs to the desired conveyor height and tighten the bolts. Etched lines on the legs ease leveling.

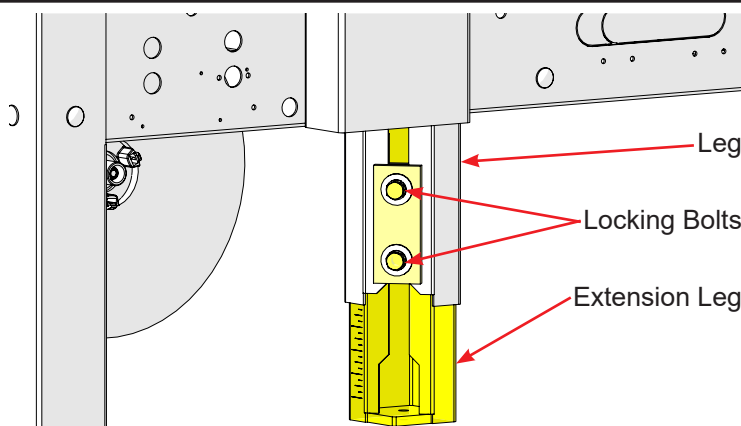


Figure 16: Leg Adjustment

Customer supplied feed conveyor (if used) should provide straight and level entry into the Case Sealer. Customer supplied exit conveyor (if used) should be straight and declined no more than 1" per foot (20mm/meter) away from the Case Sealer to convey the sealed cartons away from the machine.

SET-UP PROCEDURE

Optional Equipment: Caster Installation



WARNING: CASTER INSTALLATION REQUIRES RAISING THE MACHINE TO ACCESS THE BOTTOM OF EACH LEG. FOLLOW ALL POSSIBLE SAFETY PROCEDURES PRIOR TO AND DURING THIS PROCESS.

Be advised there are several ways to install the casters on IPG Case Sealers. Consult your company's safety practices after reading through the below directions. Take all precautions necessary.

1. Raise the machine to allow access to the bottom of each leg.
2. By hand, screw the caster into each leg.
3. Using a wrench, verify each caster is firmly seated to the bottom of the legs.
4. Lower the machine back down until it is resting on the casters.
5. Adjust the legs as necessary to achieve proper level of the machine.



CAUTION: DO NOT ADJUST THE HEIGHT USING THE CASTERS. HEIGHT CHANGES ARE TO ONLY BE MADE BY ADJUSTING THE LEG EXTENSIONS.

6. Position the machine in its desired location.
7. Lock the casters.

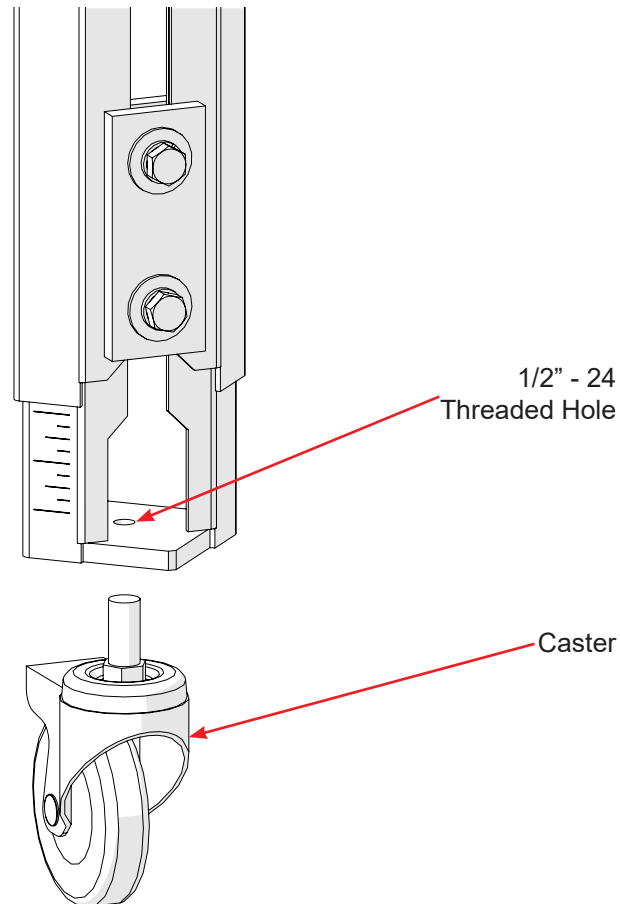


Figure 17: Caster Installation

SET-UP PROCEDURE

Optional Equipment: In-feed/Out-feed Table Installation

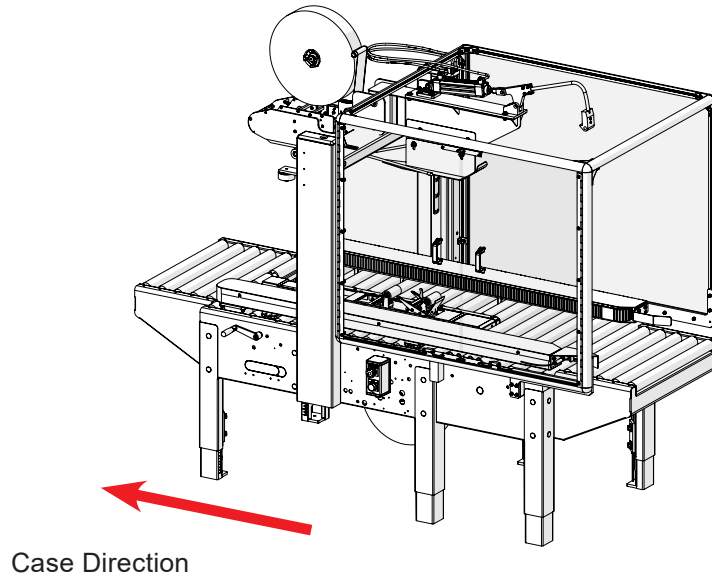


Figure 18: Case Direction

IPG Case Sealers come with the necessary mounting points for in-feed/out-feed tables. The optional in-feed/out-feed tables will come with all necessary hardware to mount to the machine. The case sealers can accept a variety of table sizes. Please consult with the factory on the best size table for your application.

1. Loosely install two carriage bolts into top two mounting holes on roller table with hardware included.

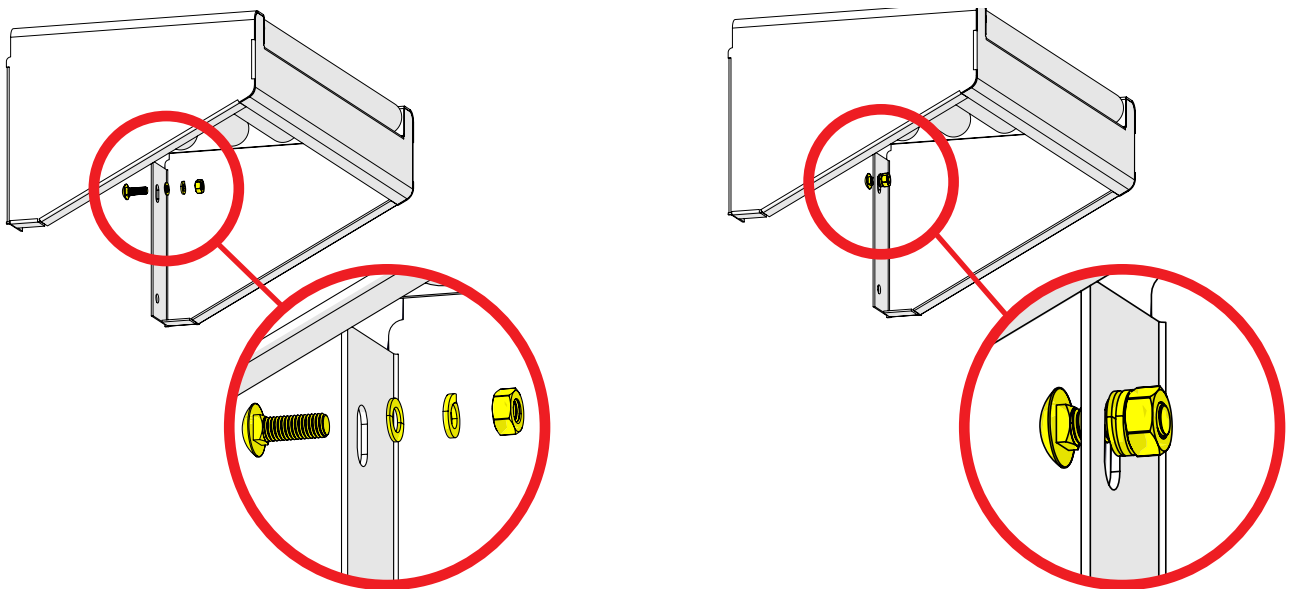


Figure 19: Carriage Bolt Assembly

SET-UP PROCEDURE

Optional Equipment: In-feed/Out-feed Table Installation (Continued)

- Utilizing the slots on the machine base, attach roller table to machine base by locating carriage bolts in slots on machine base and push down to lock in place. Make sure carriage bolts are properly aligned into slot when pushed down to lock in place before proceeding.

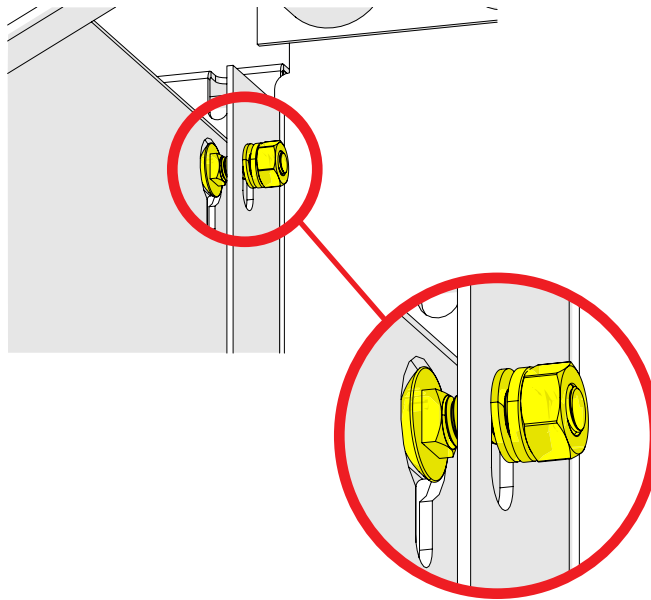


Figure 20: Table to Machine Base Installation

- Once roller table is attached to the machine base using the two carriage bolts, install remaining two carriage bolts with hardware included through the bottom two holes on the machine base and roller table.
- After all four mounting studs and included hardware have been installed, tighten all hardware to avoid roller table instability then install rollers on table.

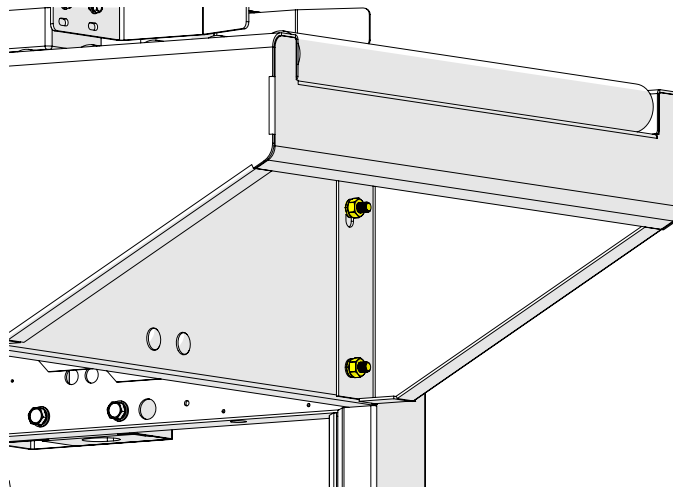


Figure 21: Remaining Carriage Bolt Installation

SET-UP PROCEDURE

Optional Equipment: Installation of External In-feed and Exit Conveyors

IPG does not supply conveyors. All conveyors are to be customer supplied.

1. Customer supplied in-feed conveyor (if used) should provide straight and level entry into the case sealer.
2. Customer supplied gravity exit conveyor (if used) should be straight and declined no more than 20mm/meter away from the machine to convey the sealed cartons away from the machine.
3. Customer supplied powered exit conveyor should be straight and level to convey the sealed cartons away from the machine.

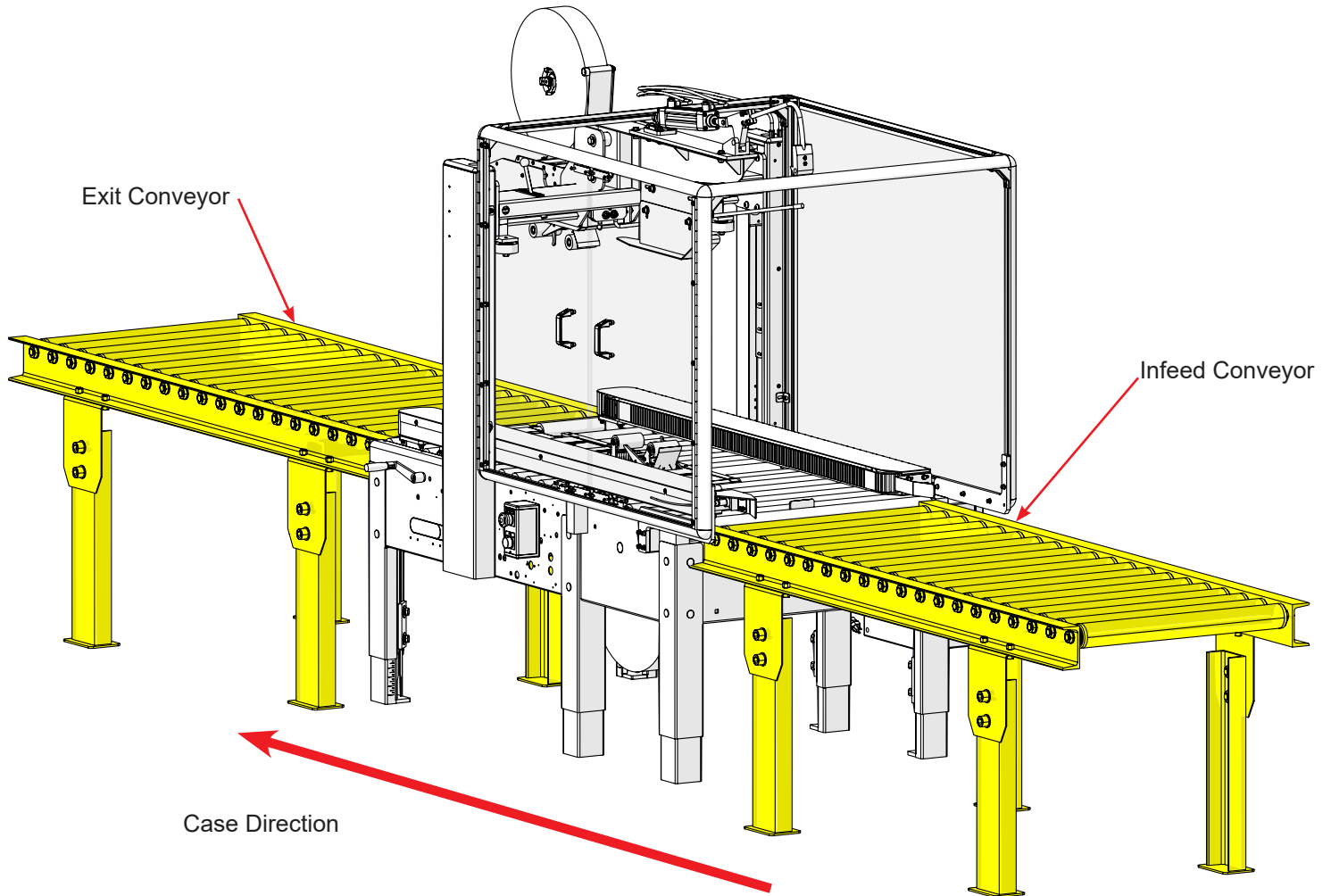


Figure 22: Installing In-Feed and Exit Conveyors

CONNECTING UTILITIES

Electrical Utilities

A 12 ft (3657.6mm) standard three-conductor power cord with plug is provided for 110V, 60HZ, 15A electric service. The receptacle must be properly grounded. Prior to the machine is plugged into the receptacle, ensure that all materials are removed from the machine. The electrical control is protected with a resettable motor overload and main power switch. True power disconnect is achieved by unplugging the machine.

The electrical box and operator control box can be moved to the opposite side of the machine. This requires disconnecting and reconnecting electrical wires and components. Only trained and qualified service technicians should access and open the control box. Should the operator control box need to be swapped the pneumatic connection will also need to be swapped to its opposite side.

If reversing the electrical utilities is required it is recommended to have this done at the factory prior to machine delivery. Please consult your IPG Representative if this process is required.

Pneumatic Utilities

The pressure setting for the main air regulator is factory set. The value may need to be adjusted as needed depending on customer supplied pressure and volume.

The main air regulator has a male quick disconnect adapter. Customers must connect clean dry compressed air to this adapter. The UA 262024-SB Case Sealer requires a minimum of 9 CFM at 90 PSI (28.3 Liter/min at 689 kPa).

To regulate the main air pressure, pull on the knob located on the top of the main air regulator. Turn the knob clockwise for increased pressure and counterclockwise for decreased pressure. When the air pressure is at 90 PSI, push back down on the button until a “click” is felt to lock it in position. The thread size is 3/8 in NPT.

Should the supplied airline or pressure be unplugged or cut for any reason the pneumatic flap folder will not actuate.

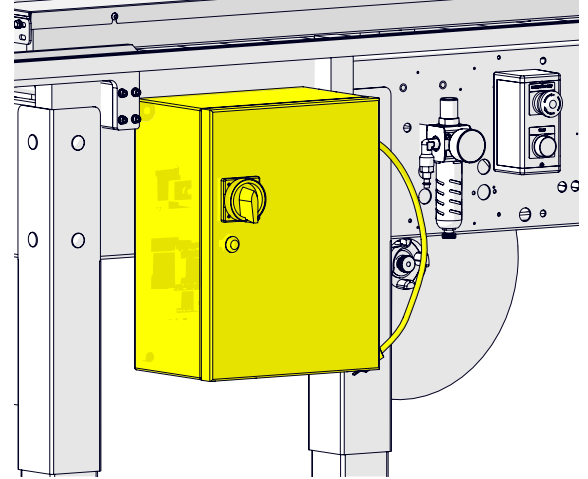


Figure 23: Electrical Box

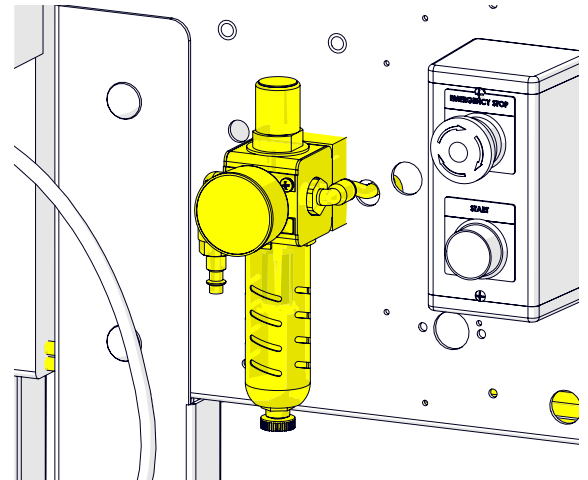


Figure 24: Pneumatic Regulator

OPERATOR CONTROL BOX

Make sure machine is connected to air supply of at least 90 PSI and machine regulator is set at 75 PSI. The following describes the use of control box buttons:

1. **Start** button (Green), machine will give an audible alarm and start after a three (3) second timer.
2. **Emergency Stop** - De-energizes the machine (Red).

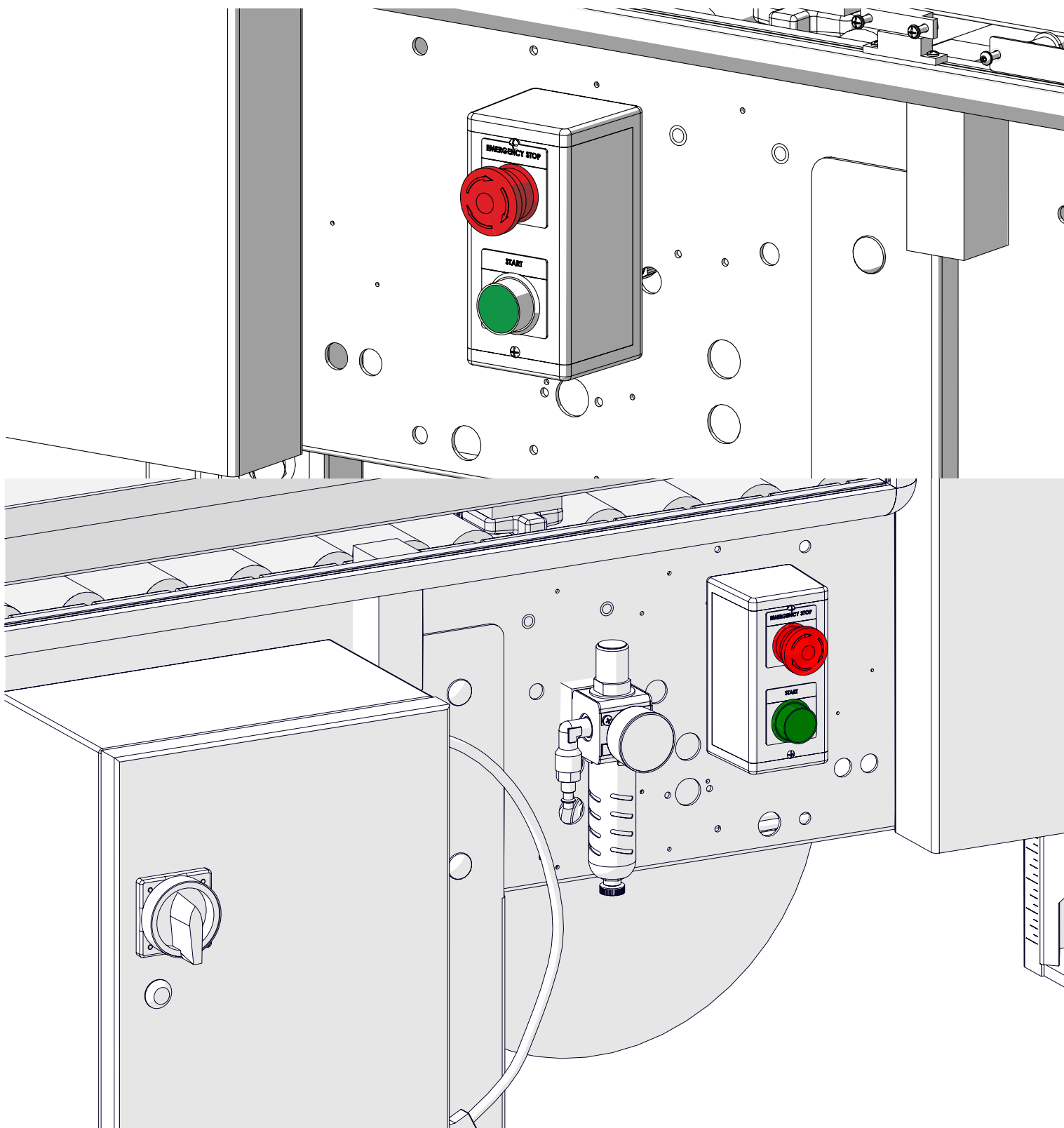


Figure 25: Operator Control Boxes

TAPE HEAD LOADING/THREADING

The UA 262024-SB comes equipped with two (2) ET 2Plus 2" tape heads standard. Optional 3" and ETX tape heads are available, please consult your authorized IPG Representative.

Removing the Top Tape Head

The top tape head is locked in with spring force. To remove the top tape head you must push the head forward and then lift the front upward. The head can be pulled straight up out of the machine. The tape head can pivot on the rear pins allowing for reloading without removing the tape head from the machine.

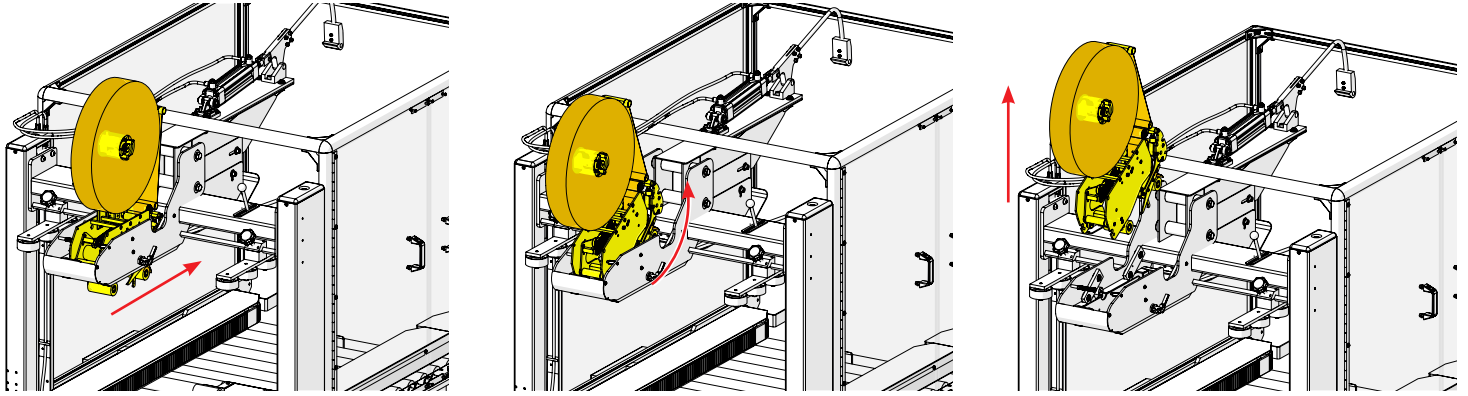


Figure 26: Removing the Top Tape Head

Removing the Bottom Tape Head

The bottom tape head is held in by gravity. To remove the bottom tape head you must raise the bridge all the way to allow for room. Next you must open the drive belts to allow for room around the bottom tape head. Open the two doors to allow access to the tape head. The bottom gap fill plate, if installed, will need to be removed prior to removing the tape head. The bottom tape head can then be pulled straight up out of the cavity. The head may need to be tilted toward the rear of the machine if there is still tape installed to clear the raised bridge.

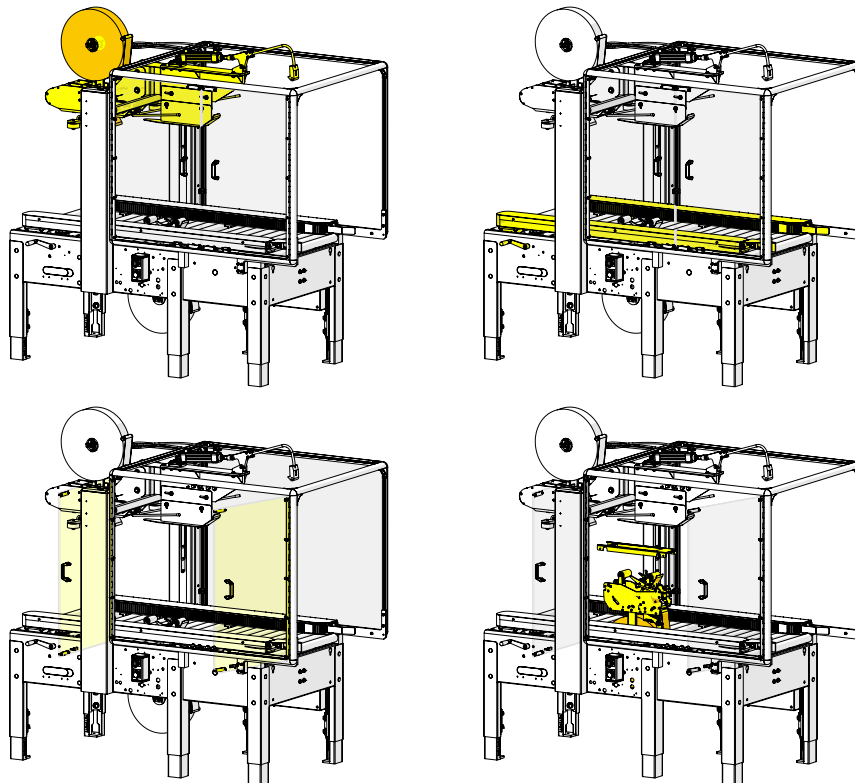


Figure 27: Removing the Bottom Tape Head

TAPE HEAD LOADING/THREADING CONTINUED

Tape Threading

Tape threading is simple and easy. Below are two diagrams for the ET 2Plus and ETX tape path. Please refer to the tape head manual for your installed tape head for a full set of instructions on how to reload and thread the tape.



WARNING: THE KNIFE BLADES IN THE TAPE HEADS ARE EXTREMELY SHARP. USE CAUTION WHEN RELOADING TAPE.

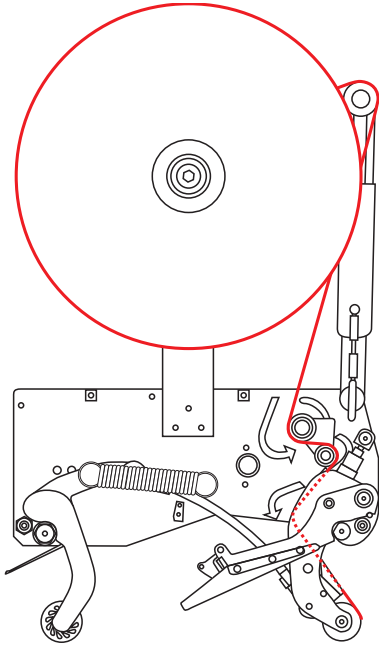


Figure 29: ETX Tape Path

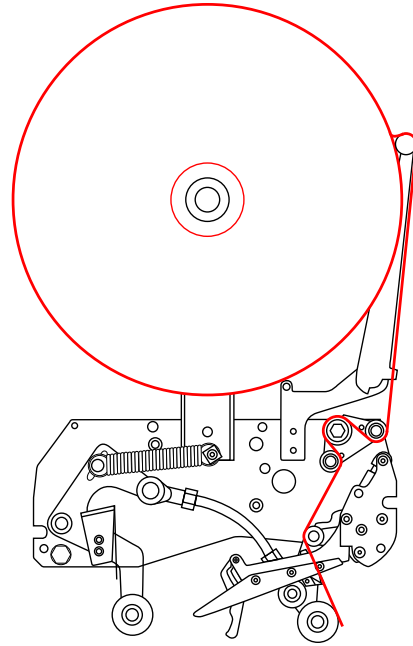


Figure 30: ET 2Plus Tape Path

TAPE HEAD LOADING/THREADING CONTINUED

Reinstalling the Top Tape Head

To reinstall the top tape head place the rear adapter pins in the rear slot. Pivot the front of the tape head down, the front adapter pin slots are angled such that the head will drop into position, you may need to push the tape head forward to allow it to drop into place. Once all adapter pins are in place springs will push the tape head back into the locked position.

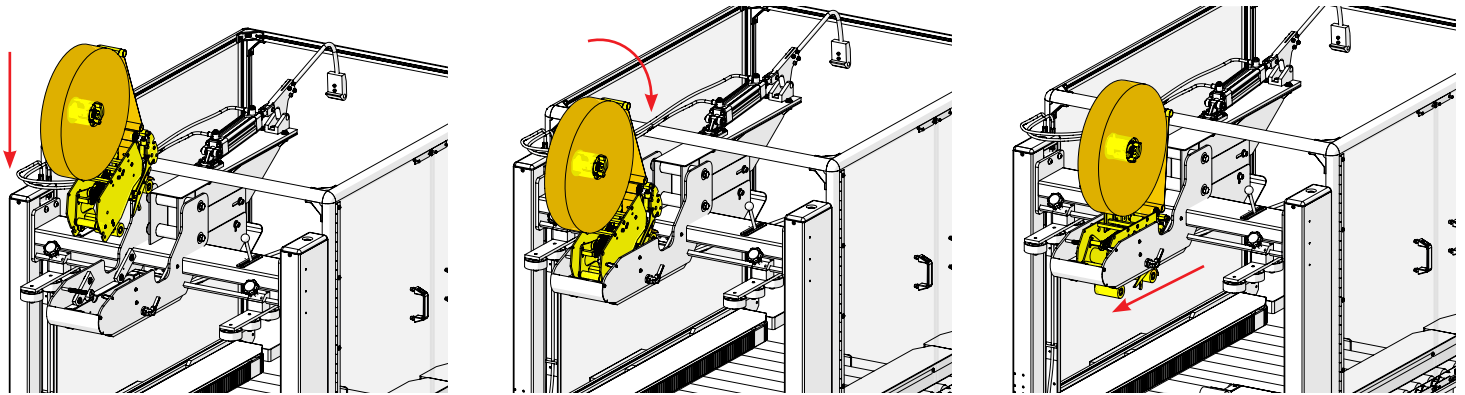


Figure 31: Reinstalling the Top Tape Head

Reinstalling the Bottom Tape Head

The bottom tape head is held in by gravity. To reinstall the bottom tape head you must raise the bridge all the way to allow for room. Carefully position the bottom tape head into the lower cavity. You may need to insert it at an angle to allow the new roll of tape to clear the cavity. Verify the adapter pins are fully seated in the slots. If used, reinstall the gap fill plate around the tape head. If you are using a 3" tape head there will be no gap fill plate. Close the doors fully.

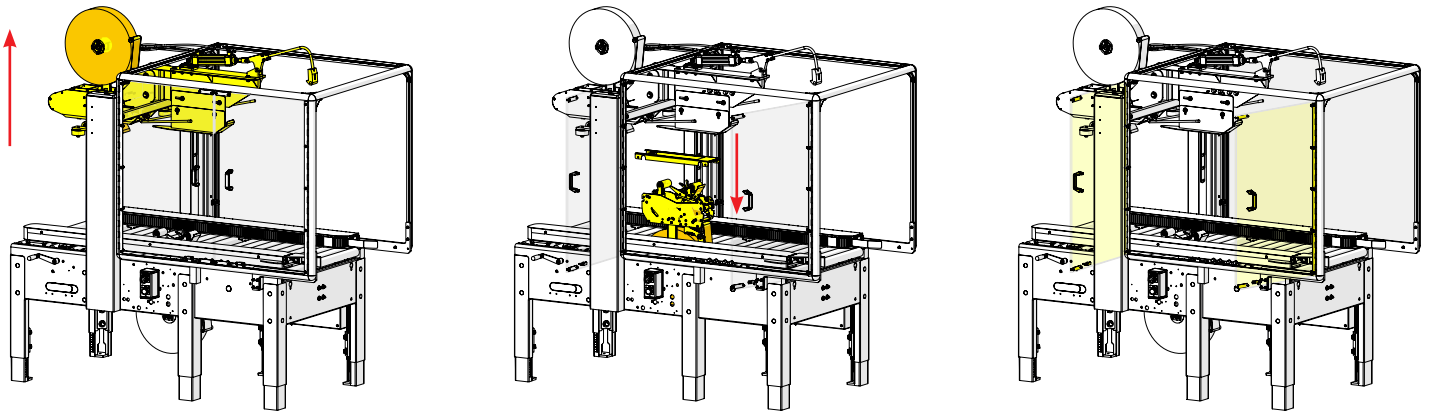


Figure 32: Reinstalling the Bottom Tape Head

SETTING THE MACHINE TO PROCESS CASE SIZES

The UA 262024-SB has a short and simple set-up procedure that can process a wide variety of case sizes.

1. Place a fully folded case toward the exit side of the UA 262024-SB, under or just behind the rollers of the top tape head. If the box is wider than the belts are open the belts to allow the case to easily fit between them.

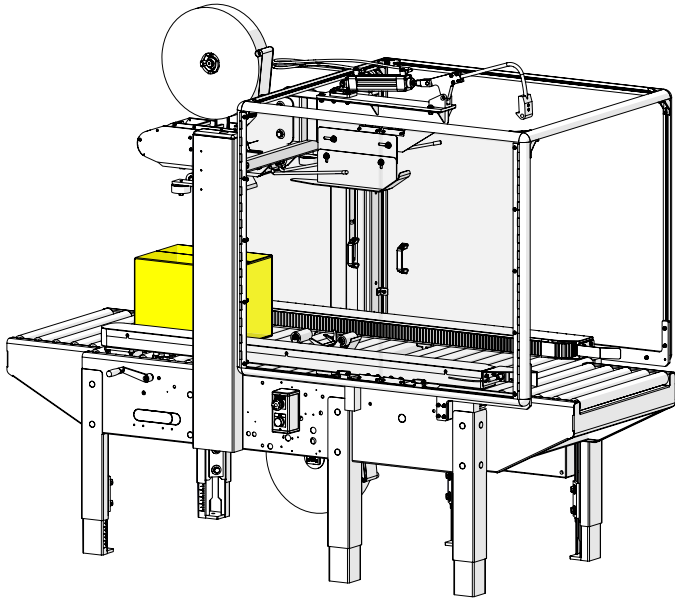


Figure 33: Place Case Inside the Belts

2. Using the crank handle bring the belt drives in toward the case until the case is snug and cannot be easily moved.

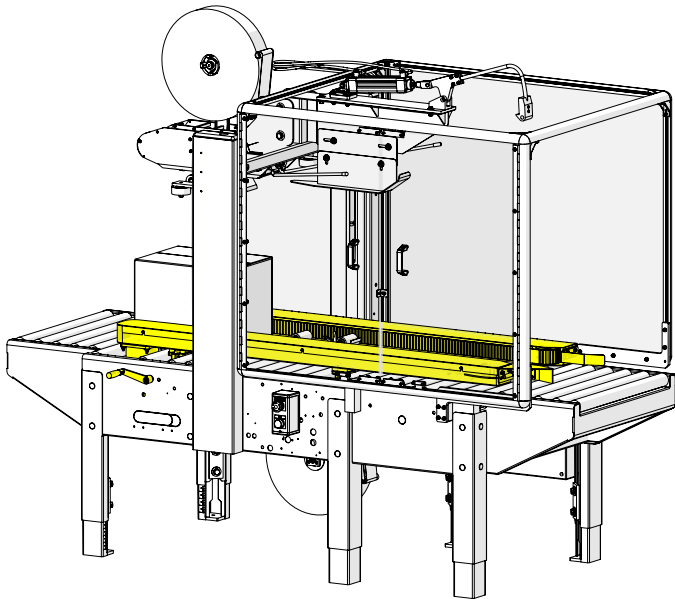


Figure 35: Adjust Belts to Box

3. Unlock the bridge using the locking handle.

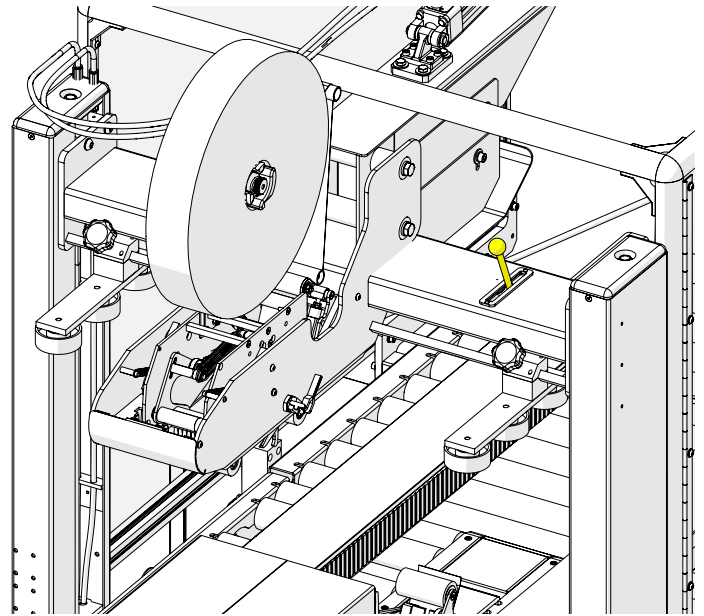


Figure 34: Unlocking the Bridge

4. Lower the bridge so it sits on top of the carton. You may need assist the top tape head rollers if the case is under the tape head.

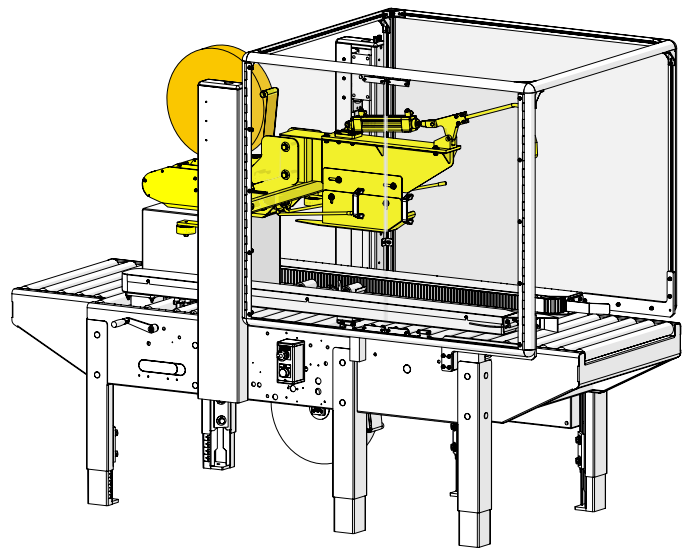


Figure 36: Lower Bridge to Box

SETTING THE MACHINE TO PROCESS CASE SIZES CONTINUED

5. Bring the top squeezers in until they make contact with the case. Do not force them into the case as this may cause processing errors.

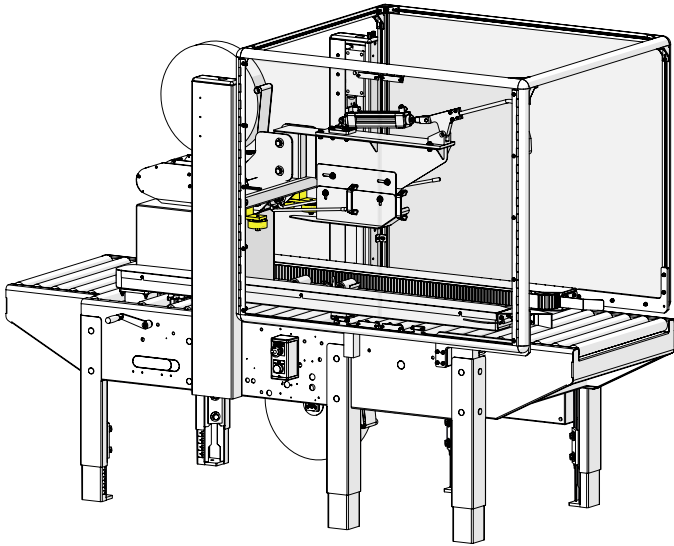


Figure 37: Top Squeezers

6. Remove the case from under the bridge. Begin to process it until it is under the front flap folding ski.

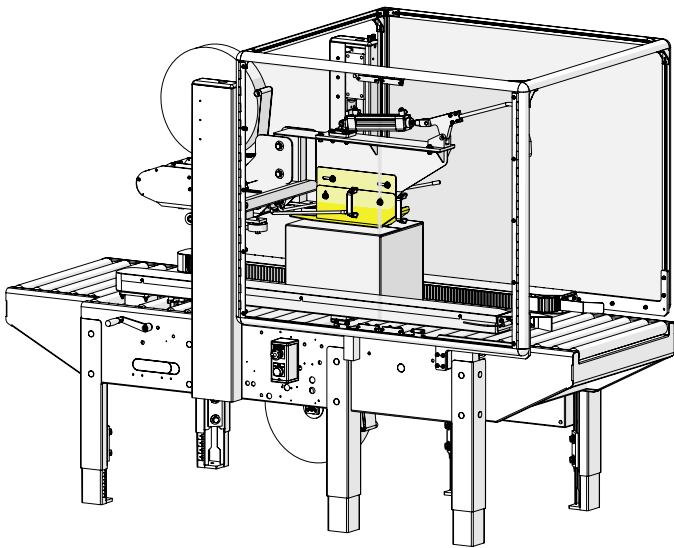


Figure 38: Front Flap Folding Ski

7. In the event the ski does not allow the case to fit under or it is too high there are adjustments that can be made. The ski may move both vertically for fit (red circled bolts) and forward and backward (blue circled bolts). The forward position will help with shorter length cases and the more rear position will help with longer cases.

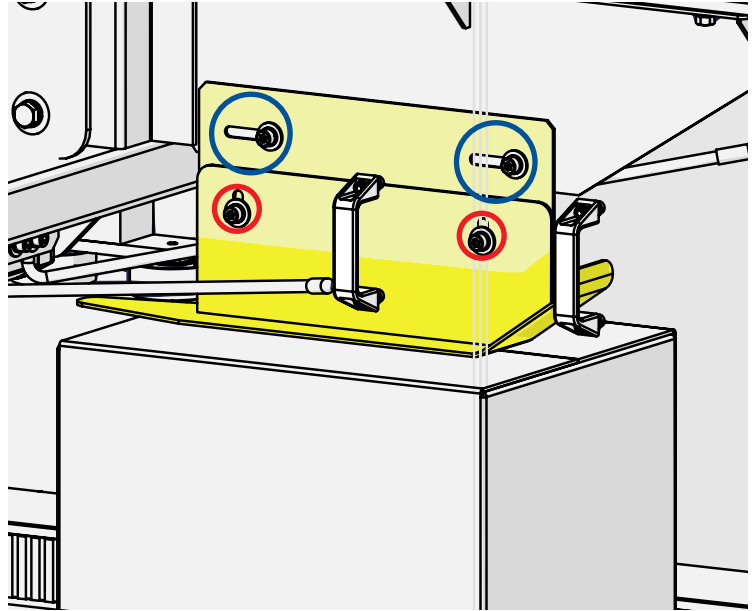


Figure 39: Adjusting the Ski

8. Feed a case with the top flaps open. The ski will fold the front minor flap while the two antenna will fold the side major flaps. The rear flap kicker will automatically engage to fold the rear minor flap before the side majors are folded in. If there is trouble at this stage please consult the troubleshooting section of this manual.

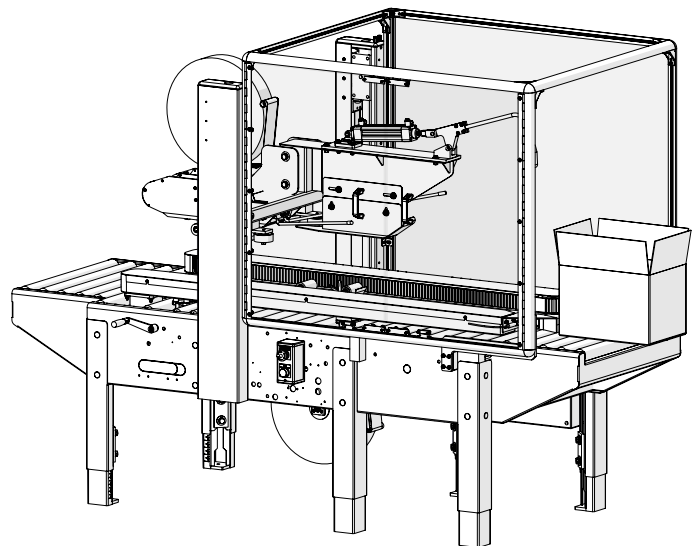


Figure 40: Processing a Case

PREPARING CASES TO BE PROCESSED

Overfills and Underfills

Overfills and Underfills, as shown in Figures 41 and 42, should be avoided to assure proper processing of the corrugated case. Each of these scenarios put stress on the water activated tape seal which could be detrimental to the integrity of the closure.

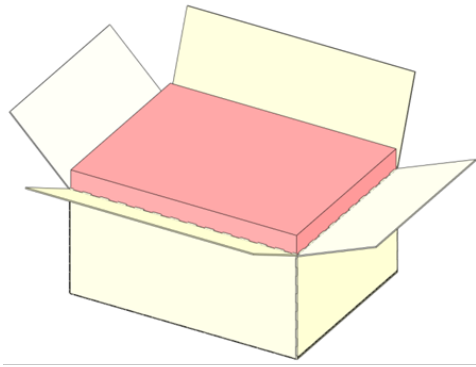


Figure 41: Overfill

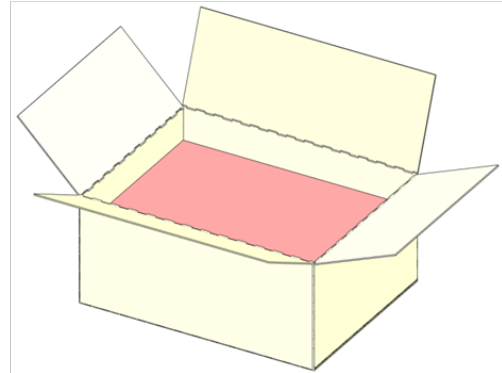


Figure 42: Underfill

Preparing the Machine for Overfilled Cases

The UA 262024-SB comes equipped with a floating section of the bridge that can be locked and unlocked for processing. Allowing the bridge to float assists with processing overfilled cases by holding the top flaps in a better position to be taped. To allow the bridge to float use the locking level (Figure 43) to unlock the bridge. This will allow the blue section of the bridge to “float.”

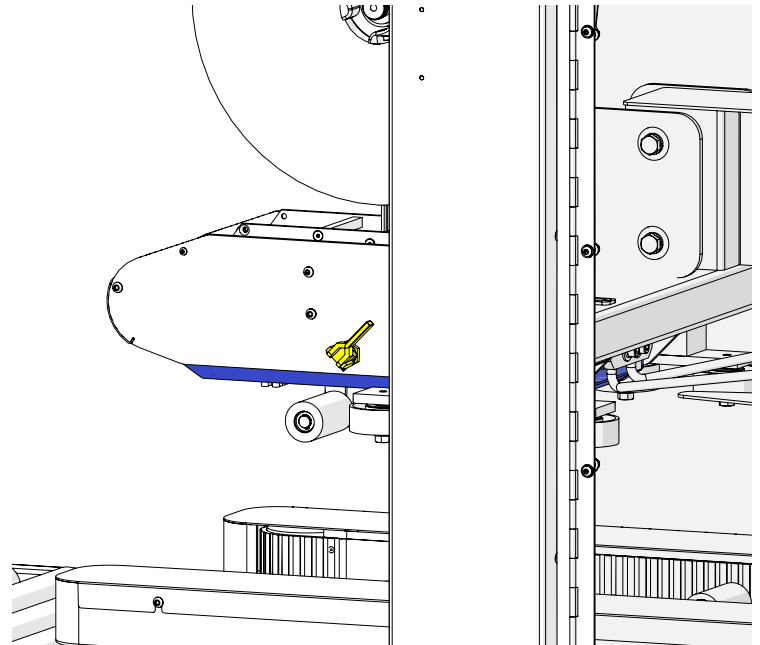


Figure 43: Floating Bridge

OPERATING INSTRUCTIONS

Once the tape has been loaded and threaded on the top and/or bottom, the case sealer is ready for use. The following instructions are presented in the order recommended for processing cases through the UA 262024-SB Case Sealer.

1. Install and thread tape on the top and/or the bottom of the machine (refer to Top Tape Head Loading/Threading and Bottom Tape Head Loading/Threading).
2. Supply or connect machine to 110V electrical supply.
3. Twist the E-stops clockwise.
4. Follow the Adjusting for Case Size procedure to set the UA 262024-SB to process the desired case size.
5. Verify the doors are fully closed.
6. Press the Start button to turn the belts on to begin processing.
 - On machines with two (2) start buttons after the operator presses the green start button the machine will give an audible alarm for three (3) seconds before starting the belts.
 - In the event an emergency stop has been activated or a door is open and an operator pressed the start button after the standard three (3) second pause time an additional rapid beeping alarm will alert the operator the machine has an emergency stop engaged or a door is open.



WARNING: ENSURE THAT THE OPERATOR'S HANDS ARE AWAY FROM THE CONTACT AREA BETWEEN THE TOP TAPE HEAD ASSEMBLY AND THE CARTON. OPERATORS SHOULD GRIP THE CASE AT THE REAR AND LET GO ONCE THE MACHINE HAS TAKEN THE CASE. IMPROPER HANDLING CAN LEAD TO INJURY.

7. Present a box for processing.
8. The belts will take the box, there is no need for an operator to close any of the top flaps.
9. There is a photoeye sensor located in the left drive base carton retainer. This sensor will trigger the timer for the rear flap kicker to engage.
10. The machine side belts will carry the box through the machine folding the top flaps before applying a strip of tape to the top and/or bottom center seam of the box.

When feeding cartons into the Case Sealer all flaps must be closed prior to entering the belts. Be sure that all cases are fed squarely and straightly into the Case Sealer, feeding cases crooked can result in poor seals. Cases must be separated by at least 14 inches.

In the event of a box jam the operator should follow the jam clear procedures.



WARNING: DO NOT ATTEMPT TO REMOVE ANY JAMMED CASE FROM A CASE SEALER THAT IS CURRENTLY ON. DO NOT ATTEMPT TO PUSH A JAMMED CASE THROUGH THE MACHINE. THE MACHINE HAS PNEUMATIC COMPONENTS UNDER PRESSURE. NOT FOLLOWING THE PROPER CASE JAM CLEARING METHODS CAN RESULT IN INJURY. KNIFE BLADES ARE SHARP USE EXTREME CAUTION WHEN CLEARING A JAM.

To properly clear a case jam follow the following procedure.

1. Press the Emergency Stop button to stop the belts.
2. Open the doors.
3. Unlock the bridge using the locking handle.
4. Raise the bridge all the way.
5. Lock the bridge using the locking handle.
6. Open the belts slightly to fully release the carton.
7. Using scissors cut any tape that has been dispensed freeing the carton from the machine.
8. Remove the carton from the machine.
9. Follow the machine set up procedures on [page 30](#) to reset the machine for carton processing.

TROUBLESHOOTING

The UA 262024-SB Case Sealer is fabricated with high quality components that provide trouble-free operation for a long period of time. However, should a problem occur, we recommend that you consult the following troubleshooting guides. If the problem you encounter is not discussed in this section, call IPG Technical Support.

IPG Machinery Support is available Monday through Friday from 8am until 7pm Eastern Time 813-345-3070 or machsupp@itape.com.

The following is a short set of brief questions and answers for some mild troubleshooting in pressure sensitive case sealers. More in-depth troubleshooting can be found in the following pages.

Q: Why does my front tape leg fold down in the tape head?

In most circumstances the tape leg can fall over when strong air circulation has been turned on in the vicinity, normally this can happen when the heating or air conditioning is turned on. Other options can include the tape not being threaded through the tape shoe or the spring tab in the tape shoe is broken.

Q: Are the top and bottom tape heads interchangeable?

All IPG tape heads can be used in a top or bottom configuration. The only recommended change is to install the correct spring in the tape head. A lighter spring is recommended for the top head and a heavier spring is recommended for the bottom tape head.

Q: The machine shipped with 2" tape heads, can I change them to 3"?

All currently manufactured IPG case sealers can accept either 2" or 3" tape heads. Many machine models will need to have the top and bottom gap fill plates removed to accept a 3" tape head. Some old models of machines can only accept a 2" tape head. If you have an older machine please contact IPG Machinery Support for confirmation.

Q: What is the best way to clean the tape heads?

It is recommended to clean the tape path with a mild detergent and water solution. Do not use any harsh industrial cleaners as they can deteriorate parts quickly. Do not use excessive amounts of water and dry the tape head soon after washing.

Q: Can we reverse the side the tape is loaded on?

Standard IPG tape heads cannot be modified in this way, however, both ET 2Plus and ETX tape heads are available in mirror versions. These are available in both 2" and 3" tape heads.

Motor Overloads

The electric motors are protected with an automatic re-settable overload (Figure 44). This reset is located in the electrical box in the lower left quadrant. Push on the top blue button to reset. The current setting should be set at 110% of the FLA (Full Load Amps) of a single motor.

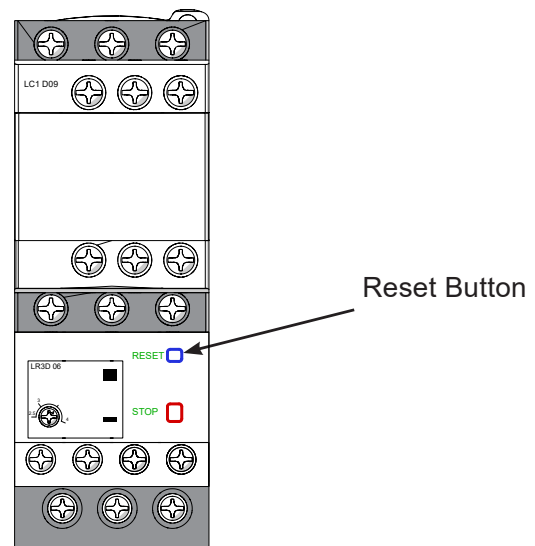
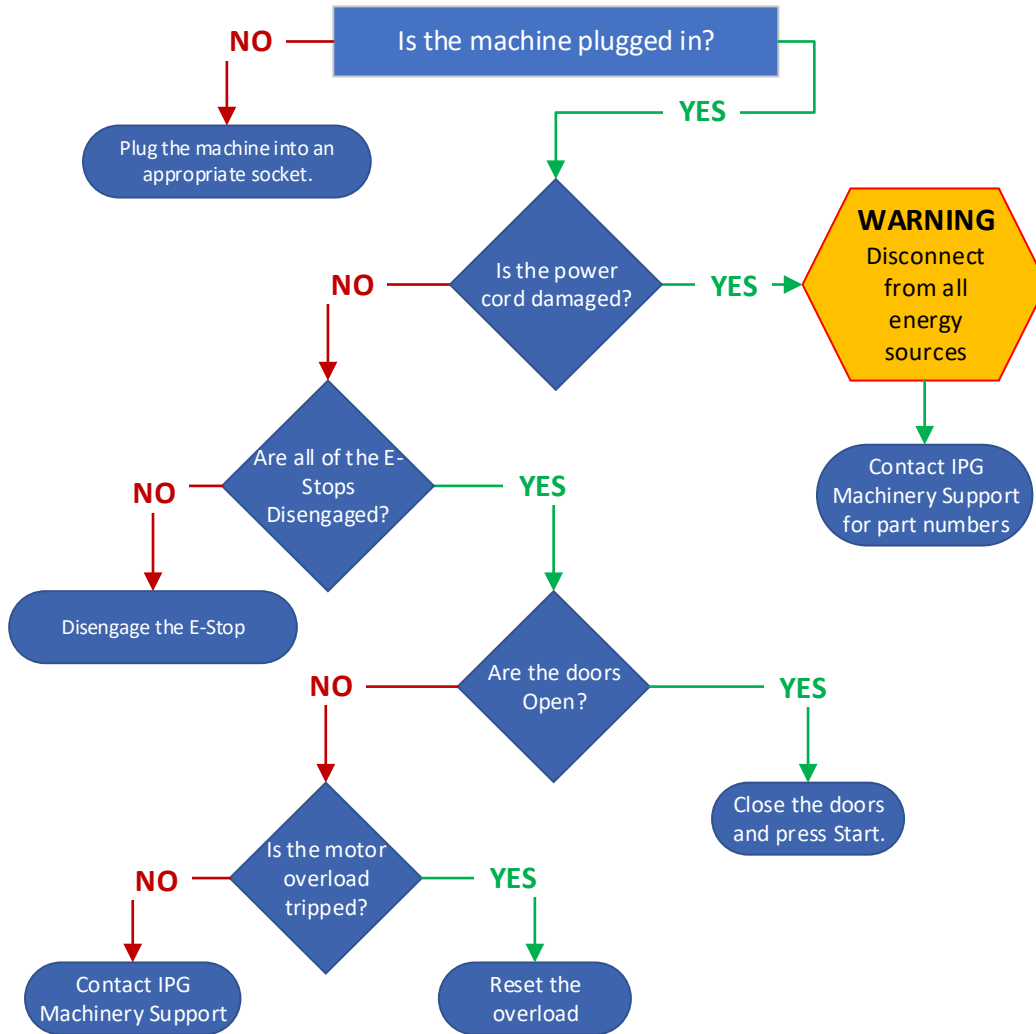


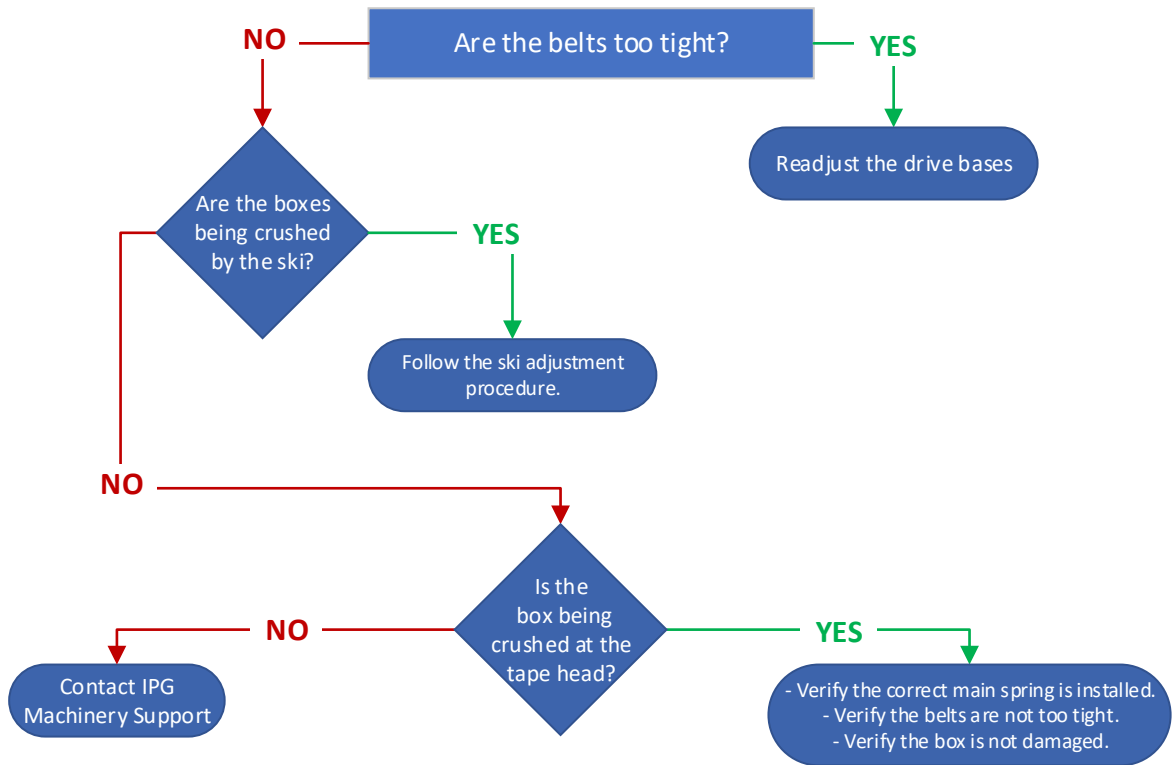
Figure 44: Major Flaps

TROUBLESHOOTING

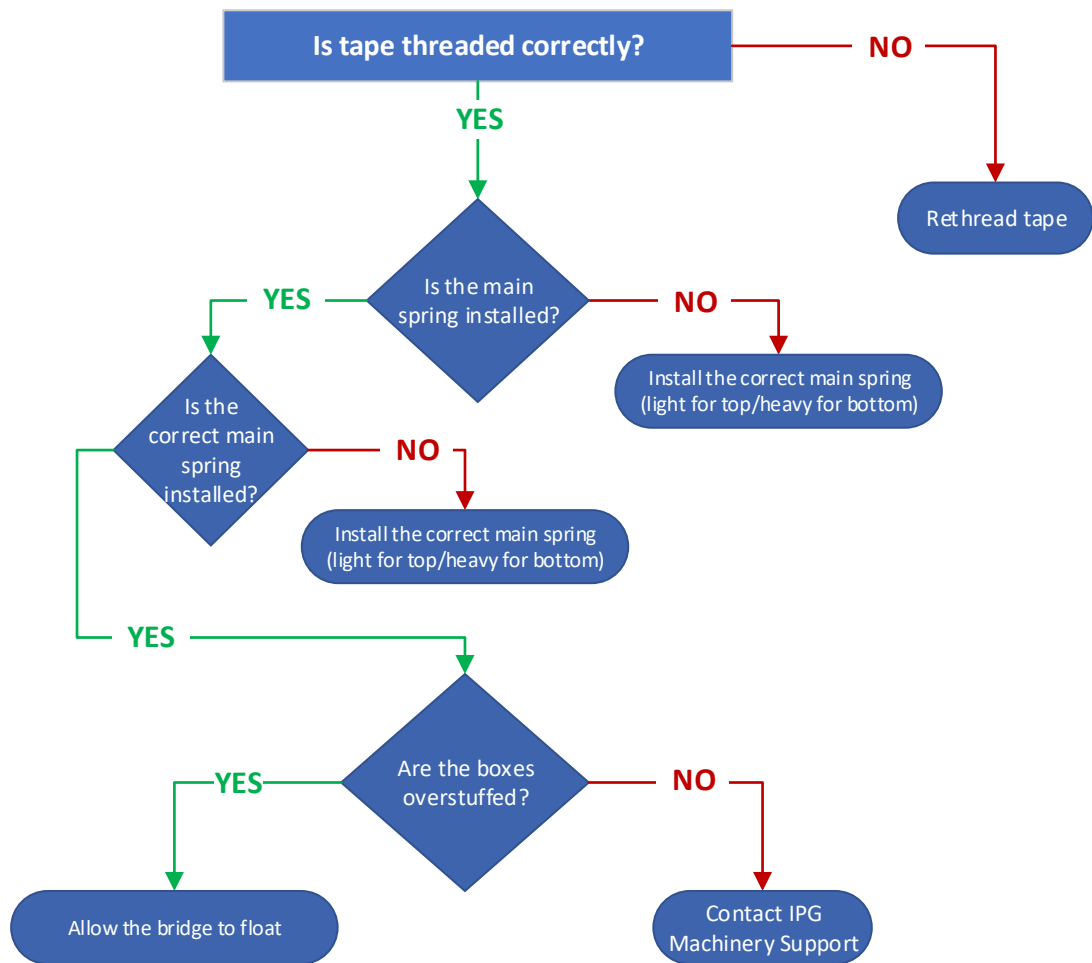
The Machine is Turned on and Nothing Happens



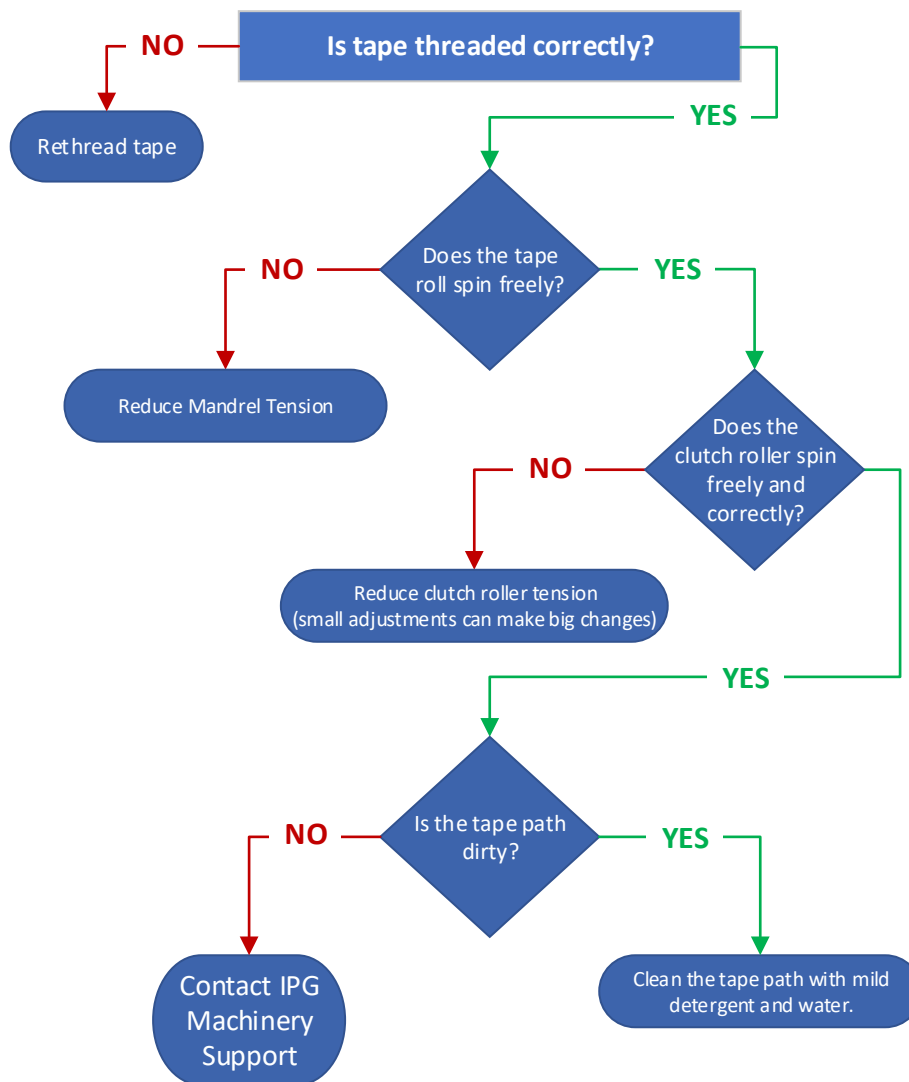
Case is Getting Crushed



Poor Tape Wipedown

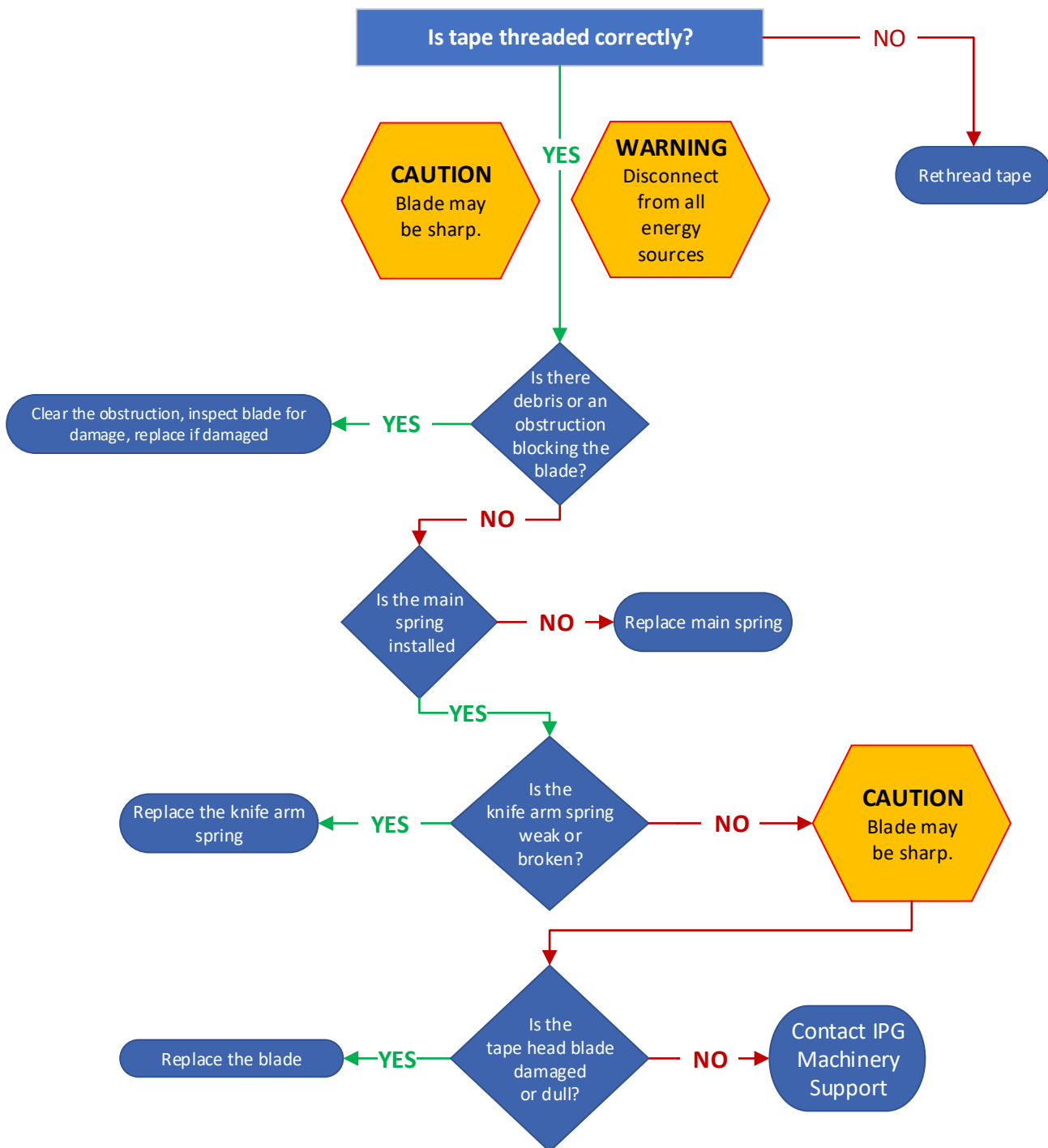


Rear Tape Leg is Tabbing



IPG Machinery Support
877-447-4832 Option 4

Tape Does Not Cut



IPG Machinery Support
877-447-4832 Option 4

MAINTENANCE

The UA 262024-SB Case Sealer has been designed and manufactured with the finest components to provide long, trouble-free performance. General preventive maintenance will improve performance and prolong the life of the case sealer. Review the illustrations and chart below for information regarding machine maintenance.



WARNING: TURN OFF ELECTRICAL POWER AND LOCK OUT THE ELECTRICAL SUPPLY BEFORE CLEANING OR MAINTENANCE. IF POWER CORDS ARE NOT DISCONNECTED, SEVERE INJURY TO PERSONNEL COULD RESULT.

Lubrication:

Spray column shafts, centering guide shafts, and compression guide shafts once a month with a silicone based dry film lubricant. This will not attract dust or lint from the surroundings.

Apply chain lube on the drive and centering guide chain once a month.

No other lubrication is necessary to operate the machine.

Cleaning:

Cartons produce a sizable amount of dust and paper chips when processed or handled. If this dust is allowed to build up in the machine, it may cause component wear and overheating of motors. Remove the accumulated dust with a shop vacuum. Avoid using compressed air to remove the dust as this may cause the dust to penetrate into parts.

Item	Action Required	Material	Frequency		
			Weekly	Monthly	Quarterly
Carton Dust In/On Machine	Blow off machine externally and internally, pay attention to drive base centering chain	Air Hose	X		
Hardware	Re-tighten any loose hardware, replace any missing hardware			X	
Column Shafts	Lubricate	Dry PTFE		X	
Cross Shafts	Lubricate	Dry PTFE		X	
Centering Chain	Lubricate	Chain Lubricant		X	
Tape Path	Clean to remove adhesive	Water	X		

Recommended Spare Parts:

It is recommended to keep a small supply of spare parts on hand in order to reduce any potential down time for maintenance. Different applications of machinery may require some amendments to this list, please consult IPG Machinery Support for any additional recommended material.

Description	Item Number	QTY
Flanged Screw L.H.	UPM0698	1
Flanged Screw R.H.	UPM0699	1
Emergency Stop Button	UPM4516	1
Driving Belts	UPM3544	2
Drive Motor	UPM7116CD	1
Tape head spare kit	See tape head manual	2

Please consult the tape head manual for the model of tape head that is currently installed in the machine for its preventative maintenance schedule as well as any recommended spare parts.

MAINTENANCE

Drive Belt Replacement

1. Using a 4mm Allen key, remove two screws and remove drive base cover.

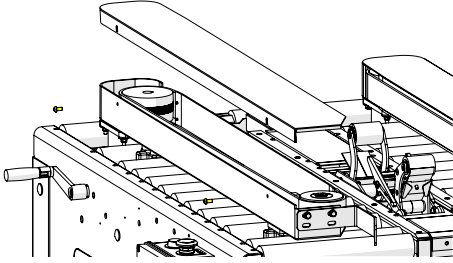


Figure 45: Floating Bridge Adjustment

2. Using appropriate Allen key and wrench, loosen belt tensioning bolts.

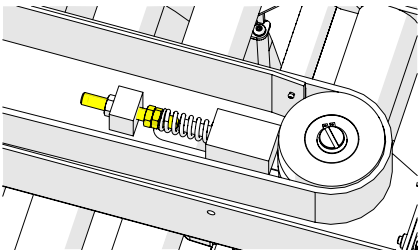


Figure 46: Motor Overload

3. Remove worn belt and replace with new belt.

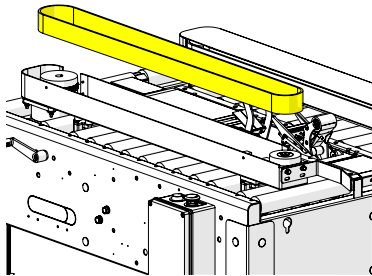


Figure 47: Drive Base Cover

4. Using appropriate Allen key and wrench, tighten belt tensioning bolts. Be sure to equally adjust tensioning bolts for both drive belts.

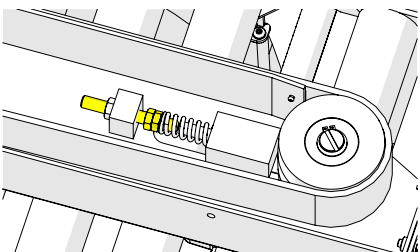


Figure 48: Loosen Belt Tension Bolt

5. Proper belt tension is achieved when a 5-pound pull force is used to create a 25mm (1 in.) gap, as shown in the middle of the drive base.

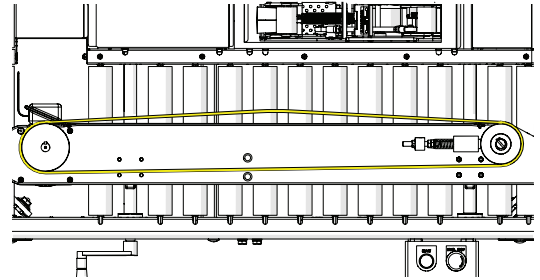


Figure 49: Replace Belt

6. Intertape S/B drive idler pulleys are engineered to self-track to center. After tensioning, if the belts do not track on center, contact maintenance or your IPG Distributor.

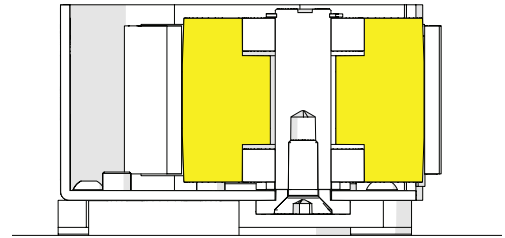


Figure 50: Tighten Belt Tension Bolt

7. Using a 4mm Allen key, replace drive base cover, as shown.

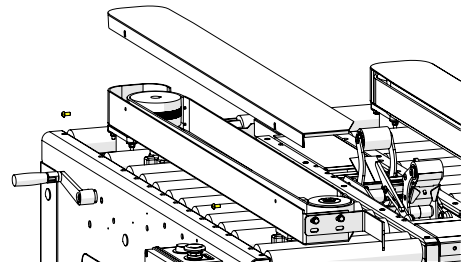


Figure 51: Proper Belt Tension

MAINTENANCE

Drive Belt Adjustment

1. Using a 4mm Allen key, remove two screws and remove drive base cover.

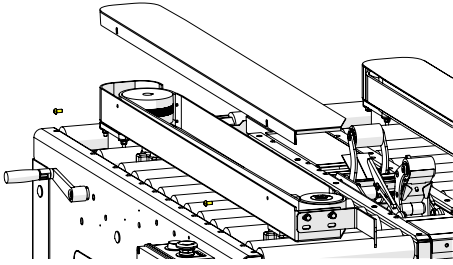


Figure 52: Self-Center Pulley

2. Using appropriate Allen key and wrench, tighten belt tensioning bolts. Be sure to equally adjust tensioning bolts for both drive belts.

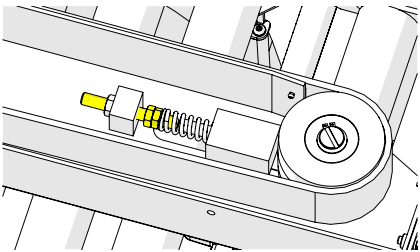


Figure 53: Drive Base Cover

3. Proper belt tension is achieved when a 5-pound pull force is used to create a 25mm (1 in.) gap, as shown in the middle of the drive base.

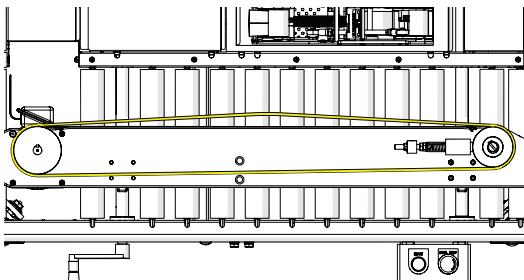


Figure 54: Drive Base Cover

4. Intertape S/B drive idler pulleys are engineered to self-track to center. After tensioning, if the belts do not track on center, contact maintenance or your IPG Distributor.

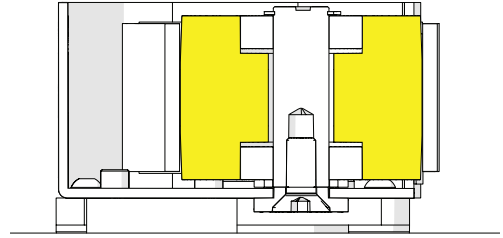


Figure 55: Tighten Belt Tension Bolt

5. Using a 4mm Allen key, replace drive base cover, as shown.

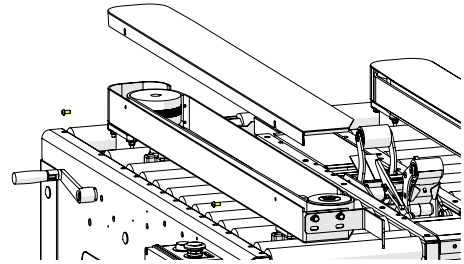


Figure 56: Proper Belt Tension

MAINTENANCE

Ski and Flap Folder Adjustment

If the case is getting jammed against the ski or there are problems in processing adjusting the ski and flap folder position can assist in processing.

If the case is not clearing under the ski it can be moved up through loosening two (2) bolts (circled in red), repositioning the ski, and locking it back down by tightening the bolts. There should be enough of a gap between the bottom of the ski and the top of the front minor panel to allow for smooth processing.

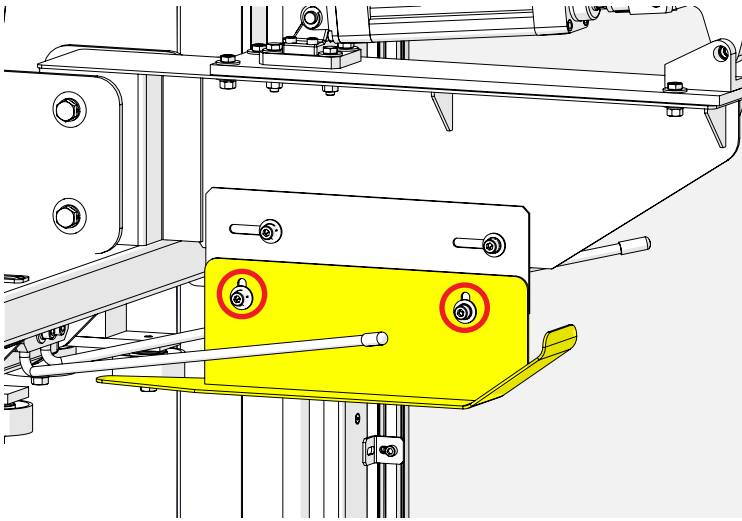


Figure 57: Ski Height Adjustment

When processing cases that are short in length or close to square the entire ski should be adjusted horizontally closer to the in-feed of the machine. This will assist if the rear minor flap is popping up and getting jammed on the ski. If a box is near the maximum length moving the ski closer to the tape head may give more consistent processing. To adjust the horizontal position of the ski loosen the two (2) bolts circled in blue and adjust the position along the slot. Then tighten the two (2) bolts until the assembly is snug.

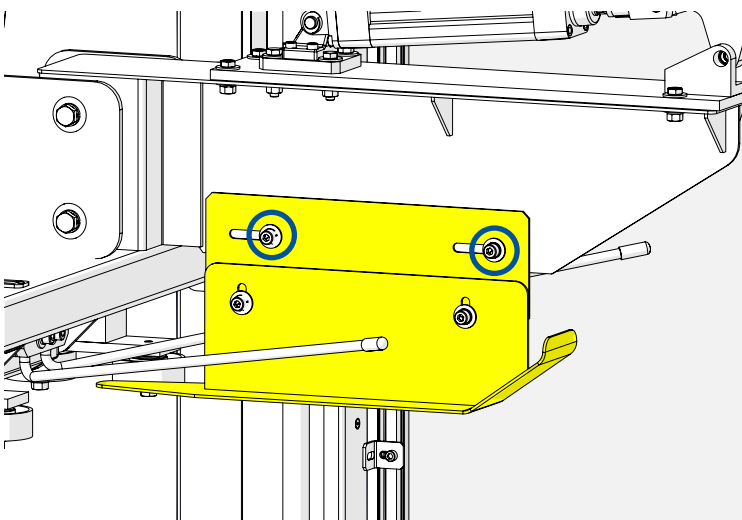


Figure 58: Ski Horizontal Position Adjustment

The final adjustment to 3 flap folding mechanism are the antenna responsible for folding the side majors. These are adjusted by loosening but not removing the four (4) bolts securing them to the bridge.

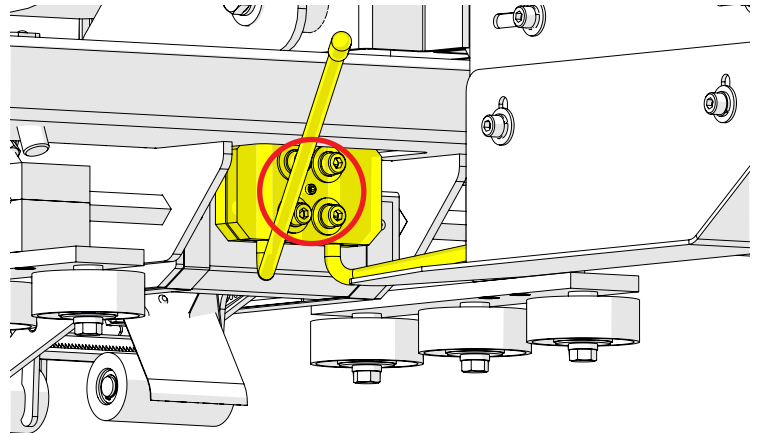


Figure 59: Antenna Adjustment

This will allow for the antenna to rotate as well as a mild height adjustment. When cases are processed the antenna should allow for the front and rear minors to be fully closed prior to completely folding the side major flaps. These are factory set for roughly the 80 percentile of cases that can be processed by the UA 262024-SB, at roughly a 90° angle. However, some adjustment may be needed bases on box suite configurations. When the antenna are positioned wide it will fold the side majors later in the process. Reversely when they are positioned to be more narrow the side majors will begin to fold earlier. When processing smaller cartons narrowing the antenna closer to 70° will be more beneficial.

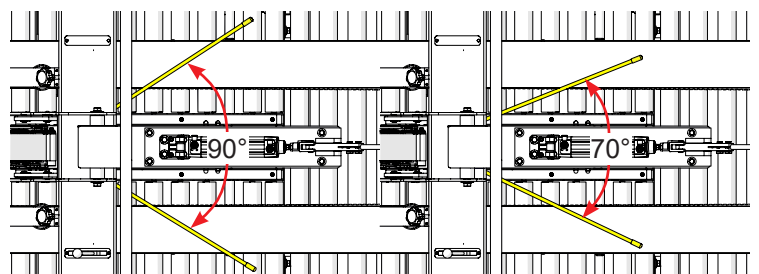
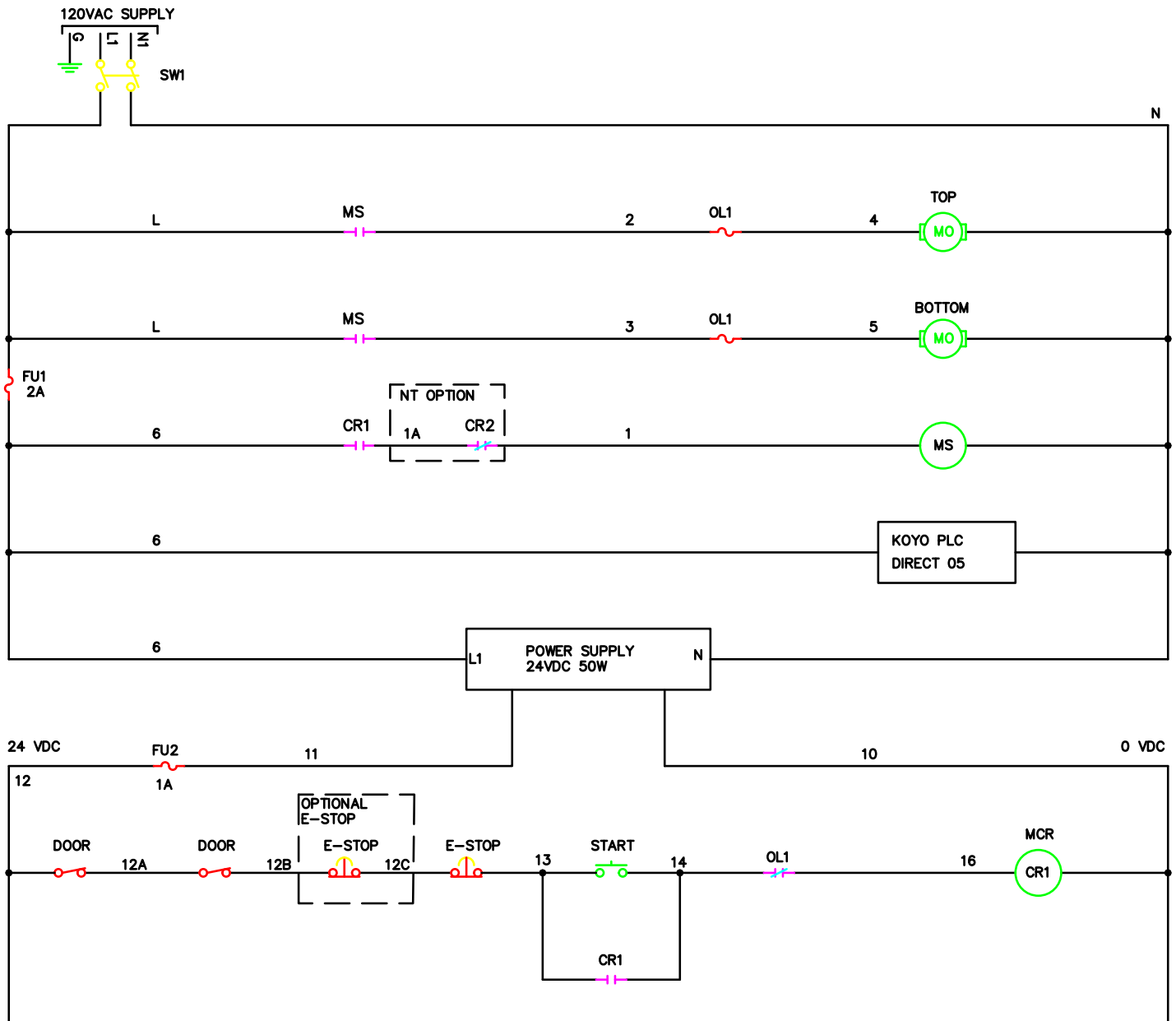


Figure 60: Antenna Angle

APPENDIX A - MACHINE DRAWINGS

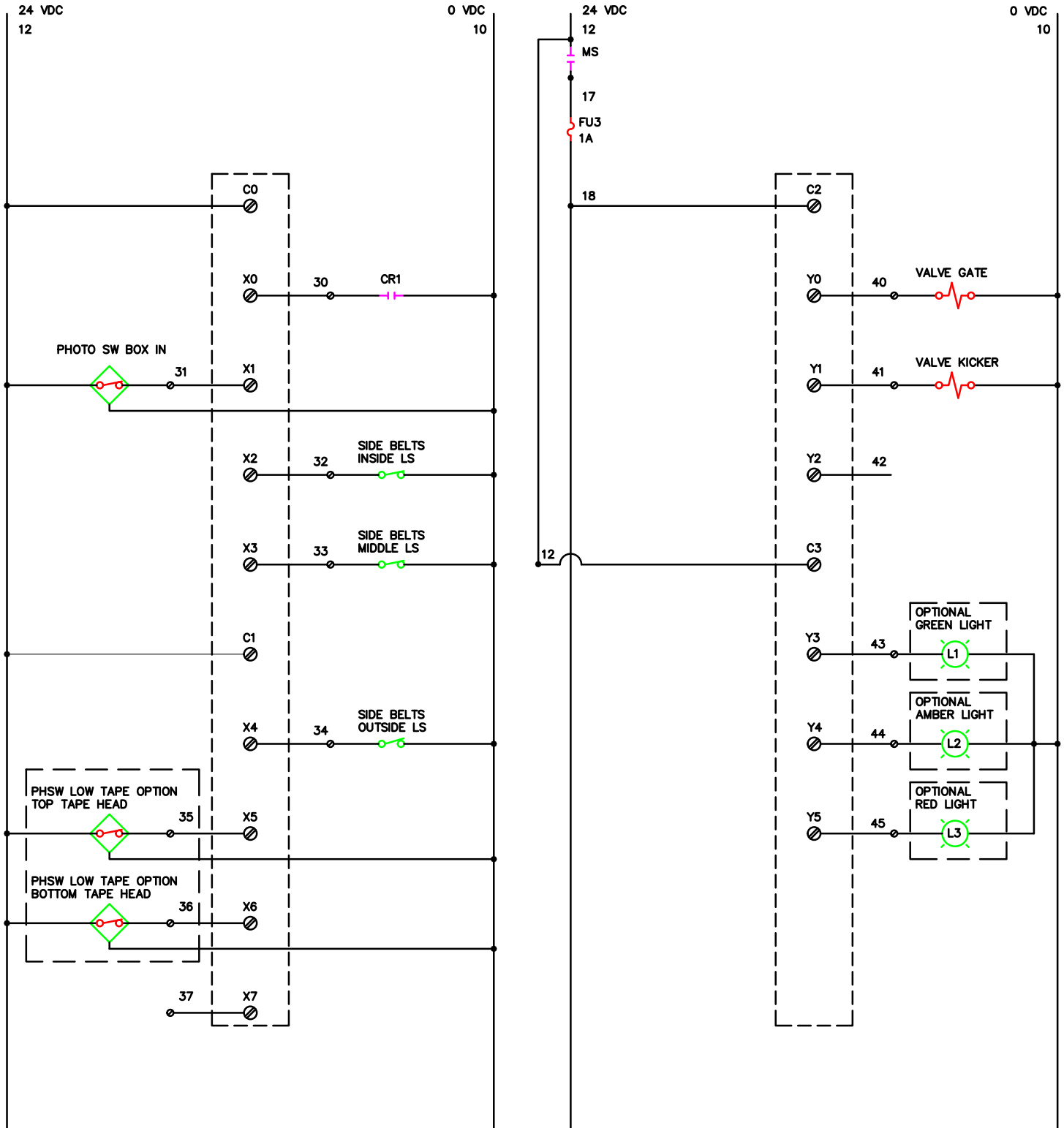
Electrical Drawings



APPENDIX A - MACHINE DRAWINGS

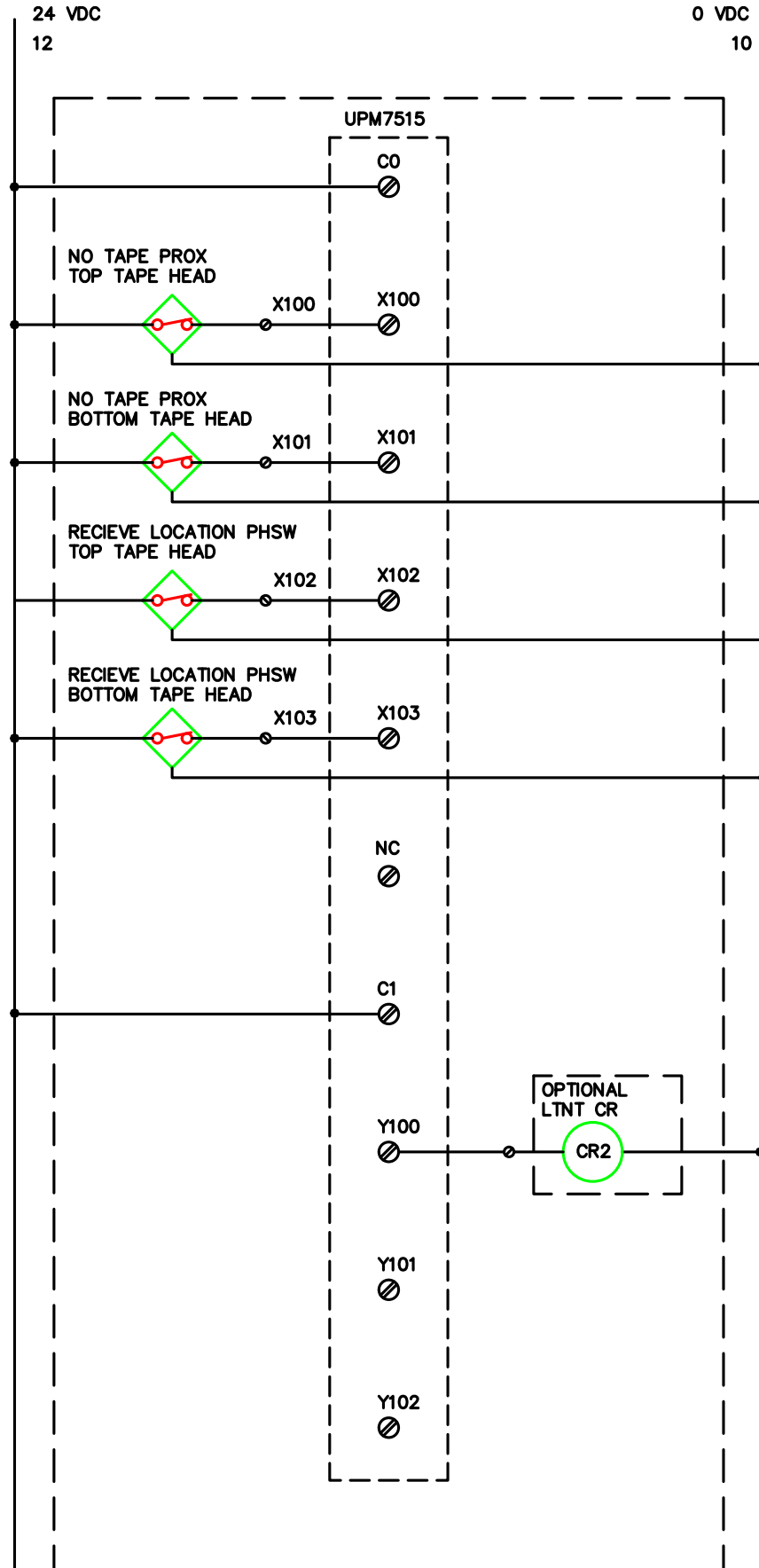
Electrical Drawings

KOYO PLC DIRECT 05



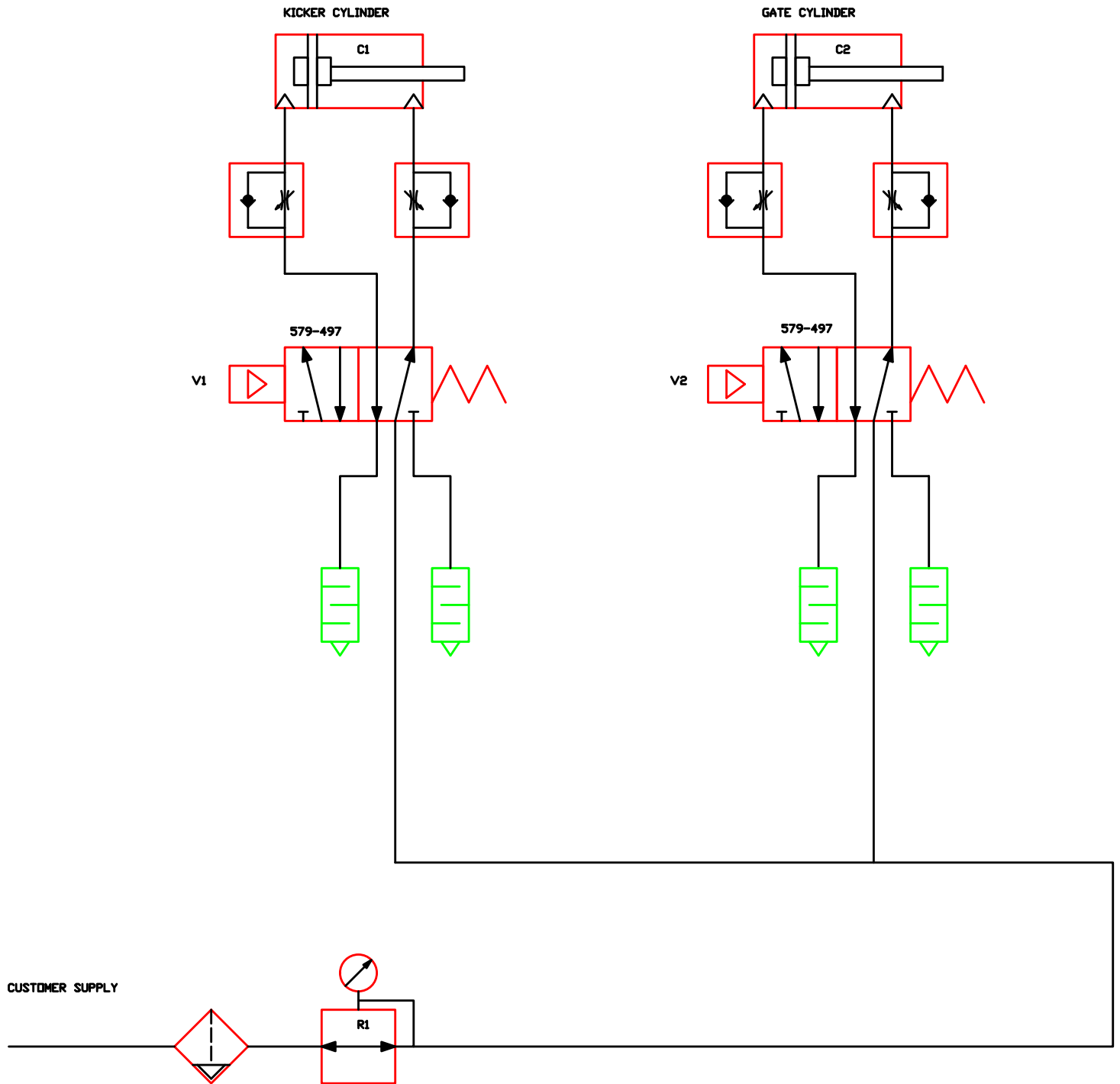
APPENDIX A - MACHINE DRAWINGS

Electrical Drawings (Optional Low Tape No Tape)



APPENDIX A - MACHINE DRAWINGS

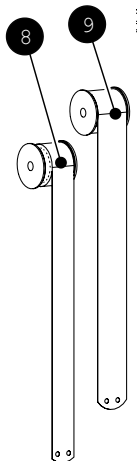
Pneumatic Drawings



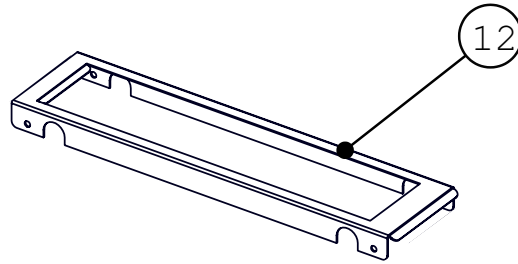
APPENDIX B - MACHINE PARTS LIST

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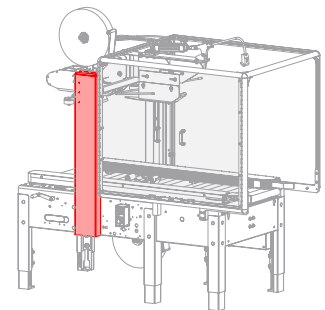
Items with black balloon call outs are assemblies (made of more than one individual part).



Items with white balloon call outs are single parts.



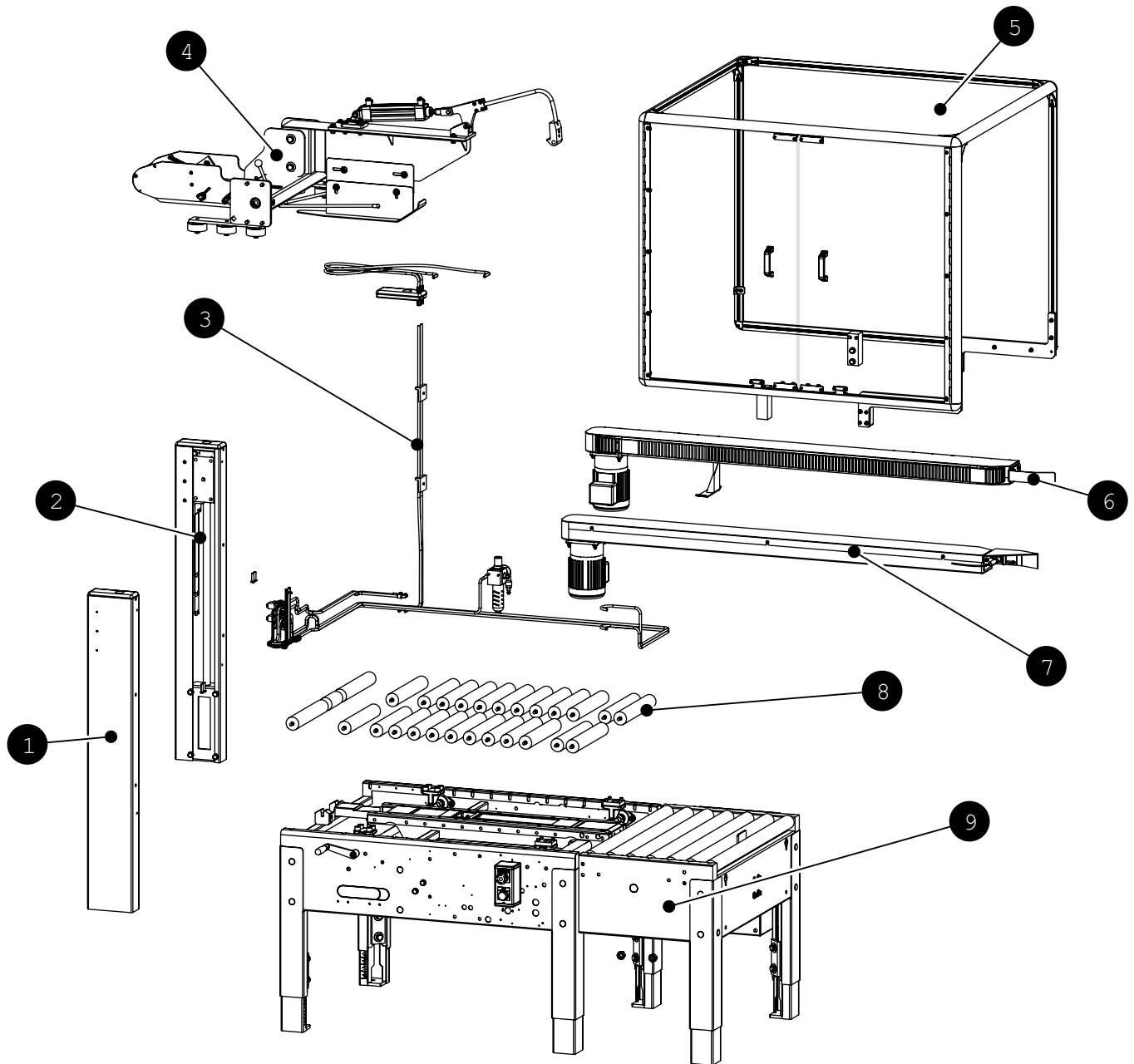
The top right of each page with a parts breakdown will show a red highlighted section of the machine that is being broken out into more detail.



Not all assemblies are sold as assemblies please consult IPG Machine Support for details.

APPENDIX B - MACHINE PARTS LIST

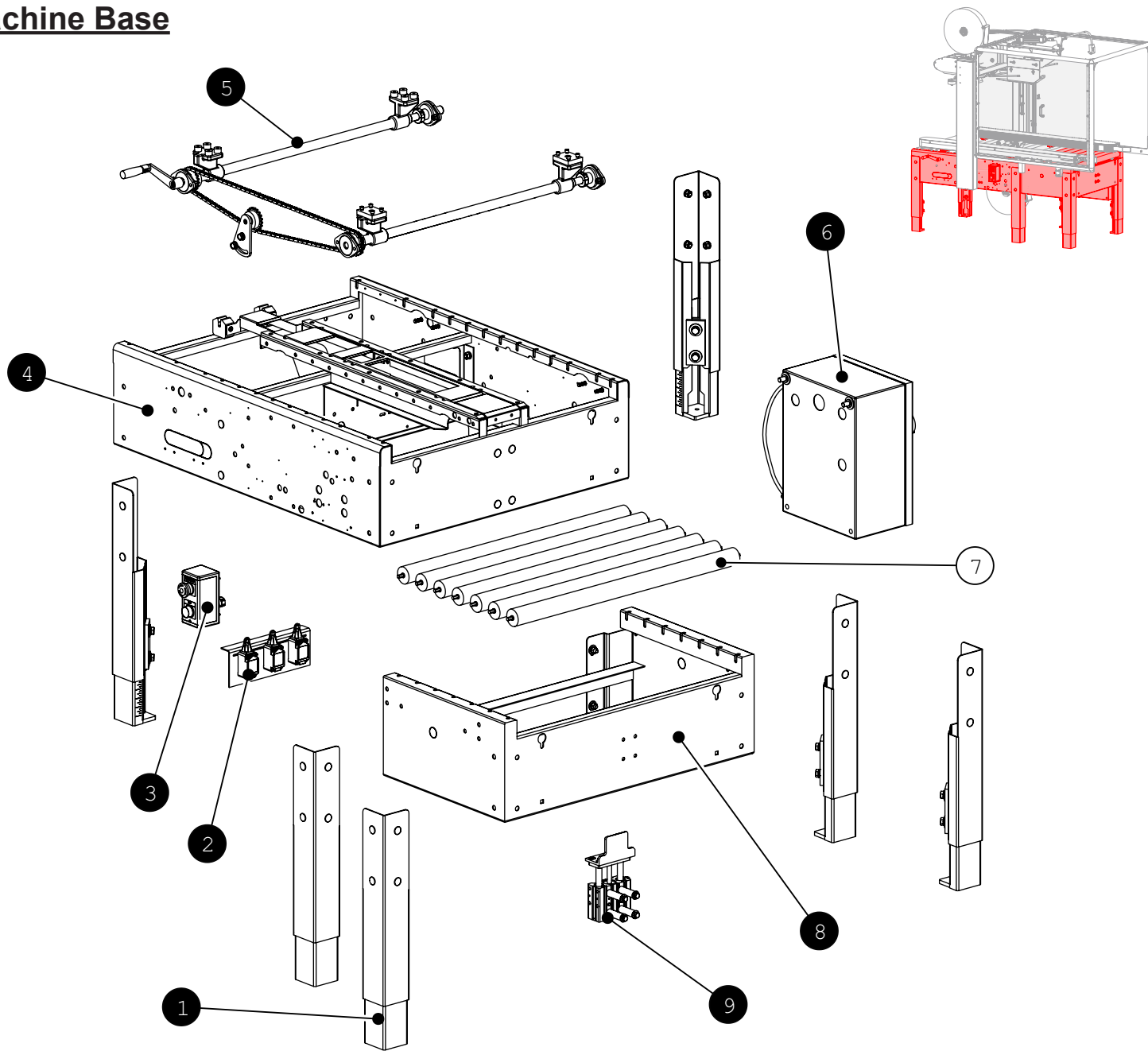
Main Machine



ITEM	PART NUMBER	DESCRIPTION	QTY
1	USM6100	COLUMN ASSEMBLY LH	1
2	USM6101	COLUMN ASSEMBLY RH	1
3	USM6106	PNEUMATIC ASSEMBLY	1
4	USM6125	BRIDGE WITH SUB ASSEMBLIES	1
5	USM6108	UA CENTER DOORS GUARDING	1
6	USM6102	DRIVE SECTION ASS'Y RH	1
7	USM6103	DRIVE SECTION ASS'Y LH	1
8	USM0678	SET OF ROLLERS	1
9	USM6104	BASE ASSEMBLY	1

APPENDIX B - MACHINE PARTS LIST

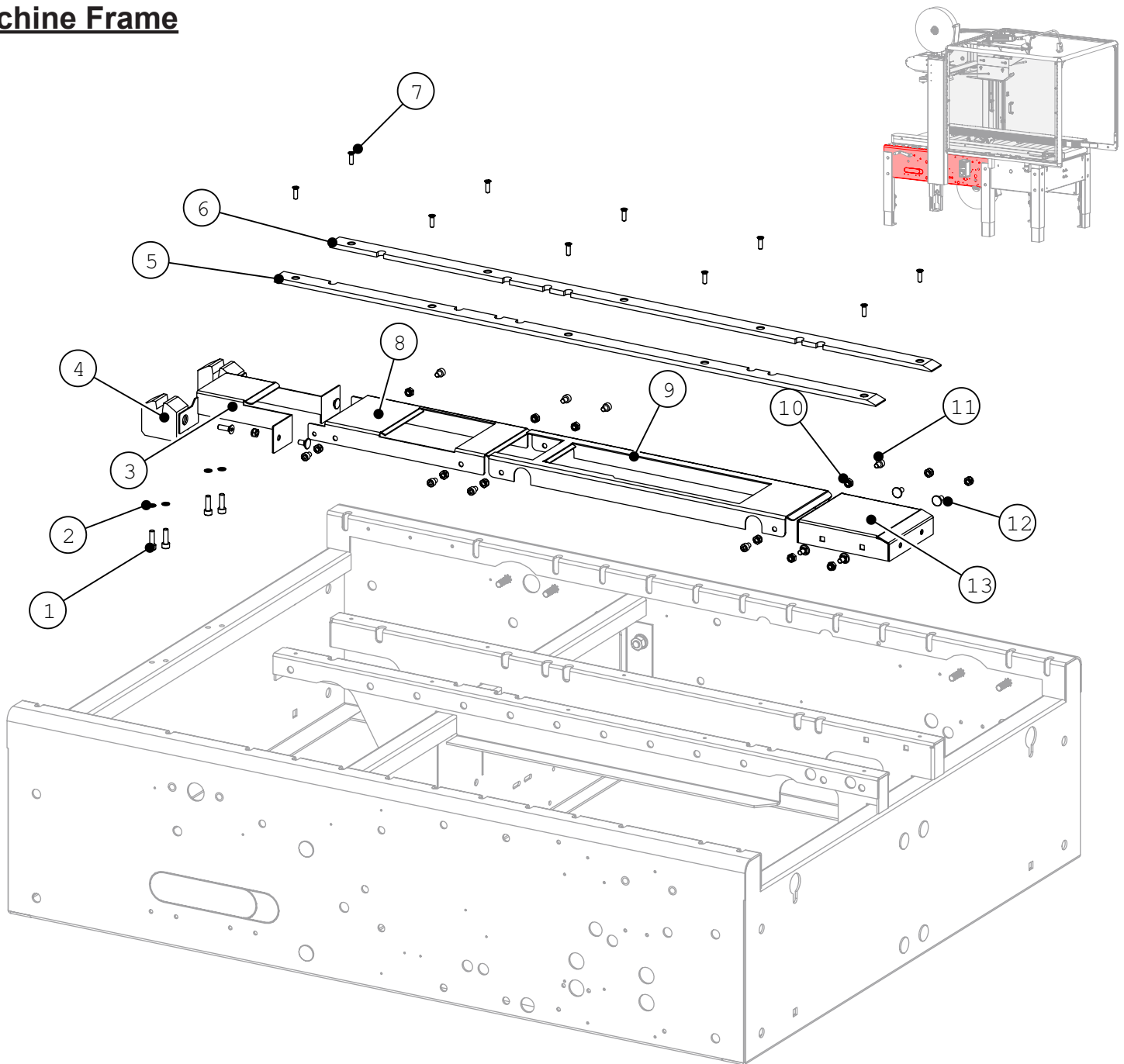
Machine Base



ITEM	PART NUMBER	DESCRIPTION	QTY
1	UAM0275	LEG ASSY	6
2		LIMIT SWITCH ASSY	1
3	UAM1084	STOP START ELECTR. BOX	1
4	UAM0352	BASE SUB-ASS'Y	1
5	USM6111	DRIVE CENTRING ASSY	1
6	USM0808	ELECTRIC ASSY	1
7	UPM4173	PVC ROL CHARCOAL DIA 1.9 X 31.04	7
8		INFEED TABLE	1
9	USM6110	GATE SA BOSCH GUIDED CYLINDER	1

APPENDIX B - MACHINE PARTS LIST

Machine Frame

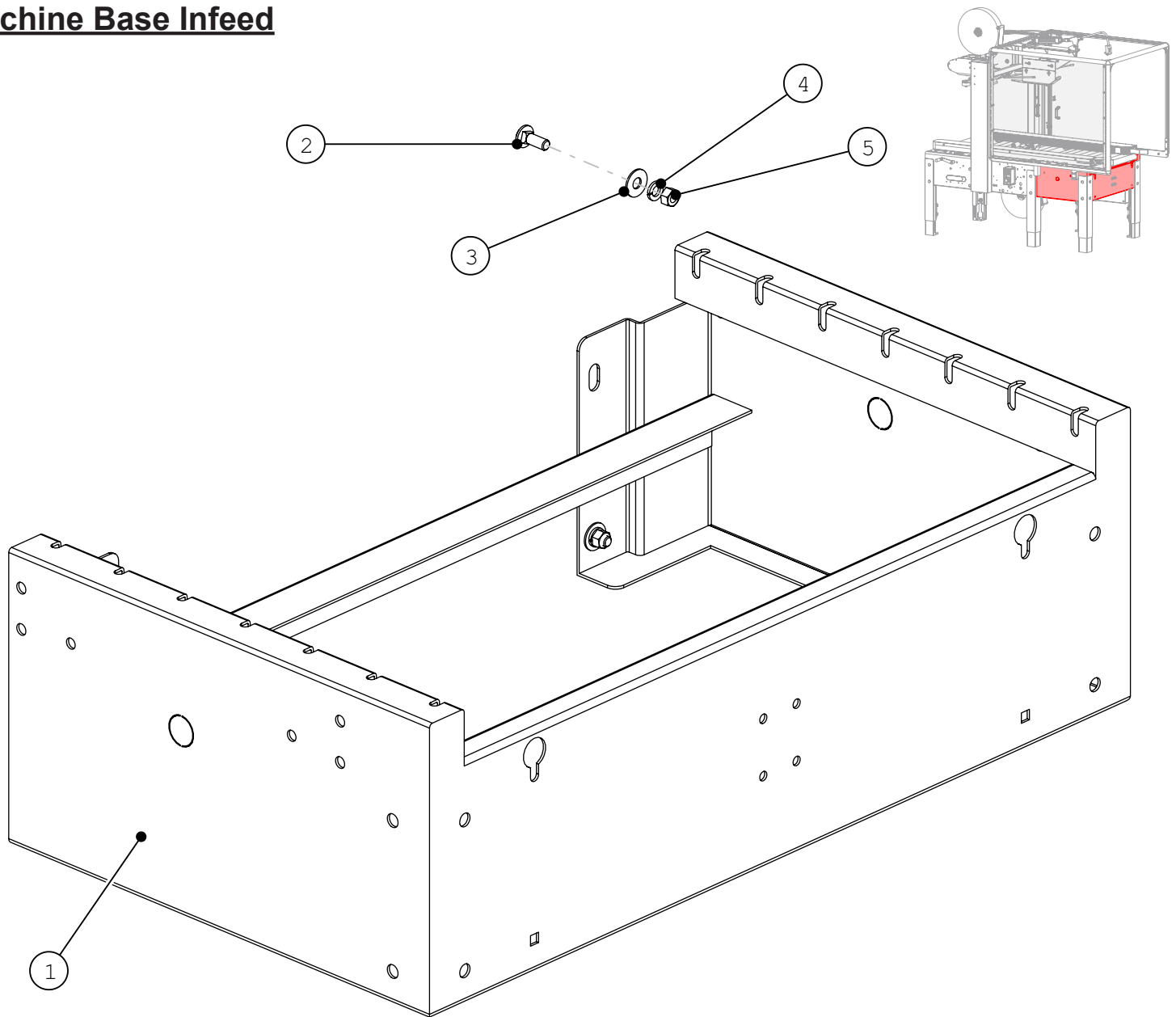


ITEM	PART NUMBER	DESCRIPTION	QTY
1	UF0835	M6-1 x 20 SHCS	4
2	UF6363	M6 LW	4
3	UF5402	M6 -1 x 20 FHCS	2
4	UPM3234EV	M1284	2
5	UPM0609EV	SLIDING PAD L.H.	1
6	UPM0606EV	SLIDING PAD R.H.	1
7	UF4114	M5 x 16 SELF TAPPING	10

ITEM	PART NUMBER	DESCRIPTION	QTY
8	UPM3553	NEAR GAP FILLER	1
9	UPM3235	ET T. H. INSERT 2"	1
10	UF5900	M6-1.0 LOCK-NUT	14
11	UF3170	M6-1 x 8 SHCS	8
12	UF3745	M6-1 x 12 CARRIAGE BOLT	4
13	UPM3229	INLET COVER	1

APPENDIX B - MACHINE PARTS LIST

Machine Base Infeed

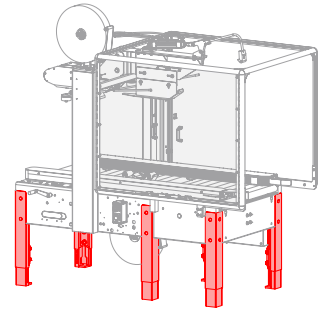
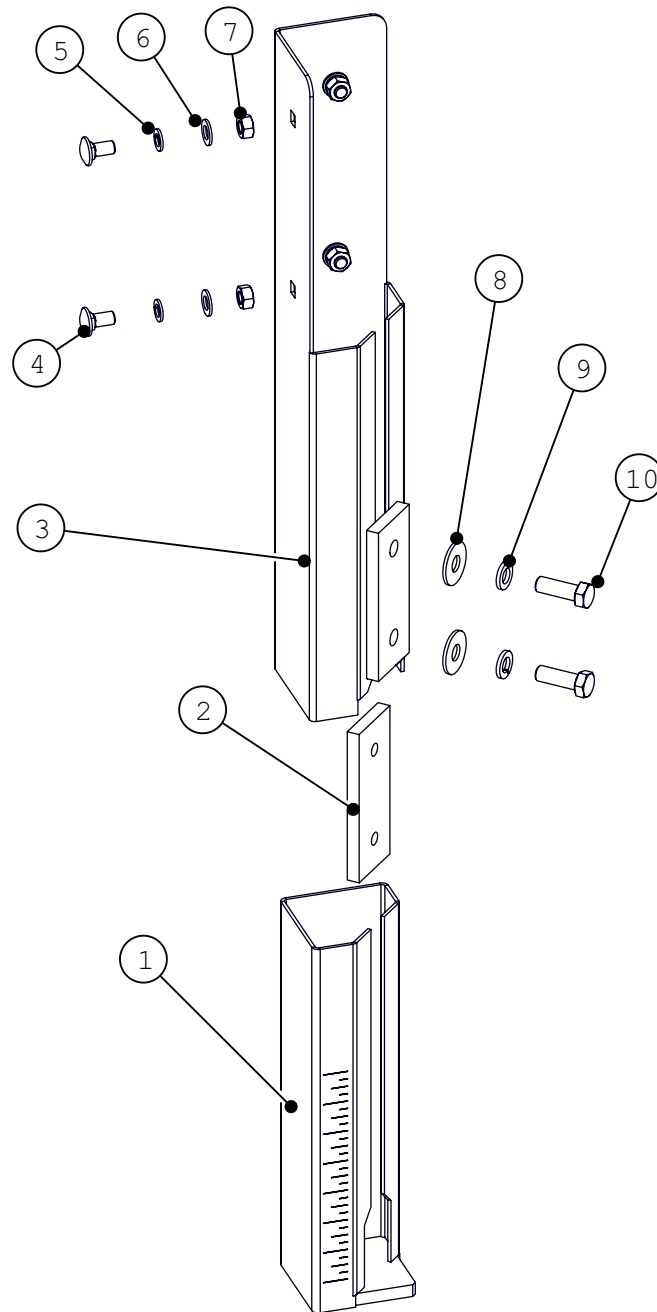


ITEM	PART NUMBER	DESCRIPTION	QTY
1	UPM4154EV	INFEEED TABLE	1
2	UF4020	CARRIAGE BOLT 3/8-16 X 1	4
3	UF1720	3.8 FW	4

ITEM	PART NUMBER	DESCRIPTION	QTY
4	UF1770	3.8 LW	4
5	UF1540	HNR 3/8-16	4

APPENDIX B - MACHINE PARTS LIST

Machine Legs

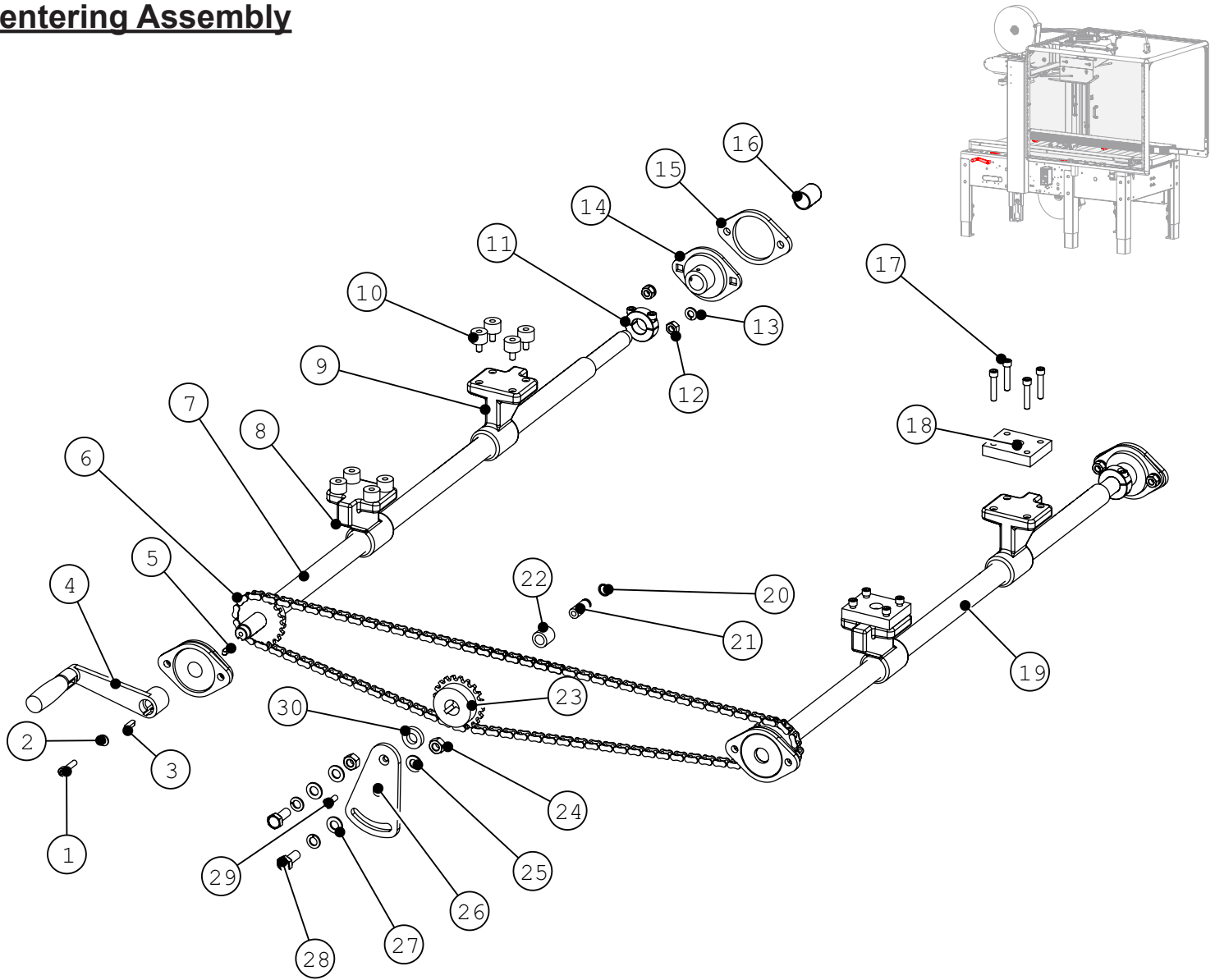


ITEM	PART NUMBER	DESCRIPTION	QTY
1	UMP7641	LEG ADJUSTMENT	1
2	UPM7642	LEG FRICTION PLATE	1
3	UPM7640	LEG MAIN FRAME	1
4	UF4229	M10-1.5 x 20-CARRIAGE BOLT	4
5	UF6371	M10 LW	4
6	UF3680	M10 FW	4

ITEM	PART NUMBER	DESCRIPTION	QTY
7	UF6314	M10-1.5 HNR	4
8	UF4231	M12 FW	2
9	UF4230	M12 LW	2
10	UF6393	M12-1.75 x 35 HHCS	2

APPENDIX B - MACHINE PARTS LIST

Centering Assembly

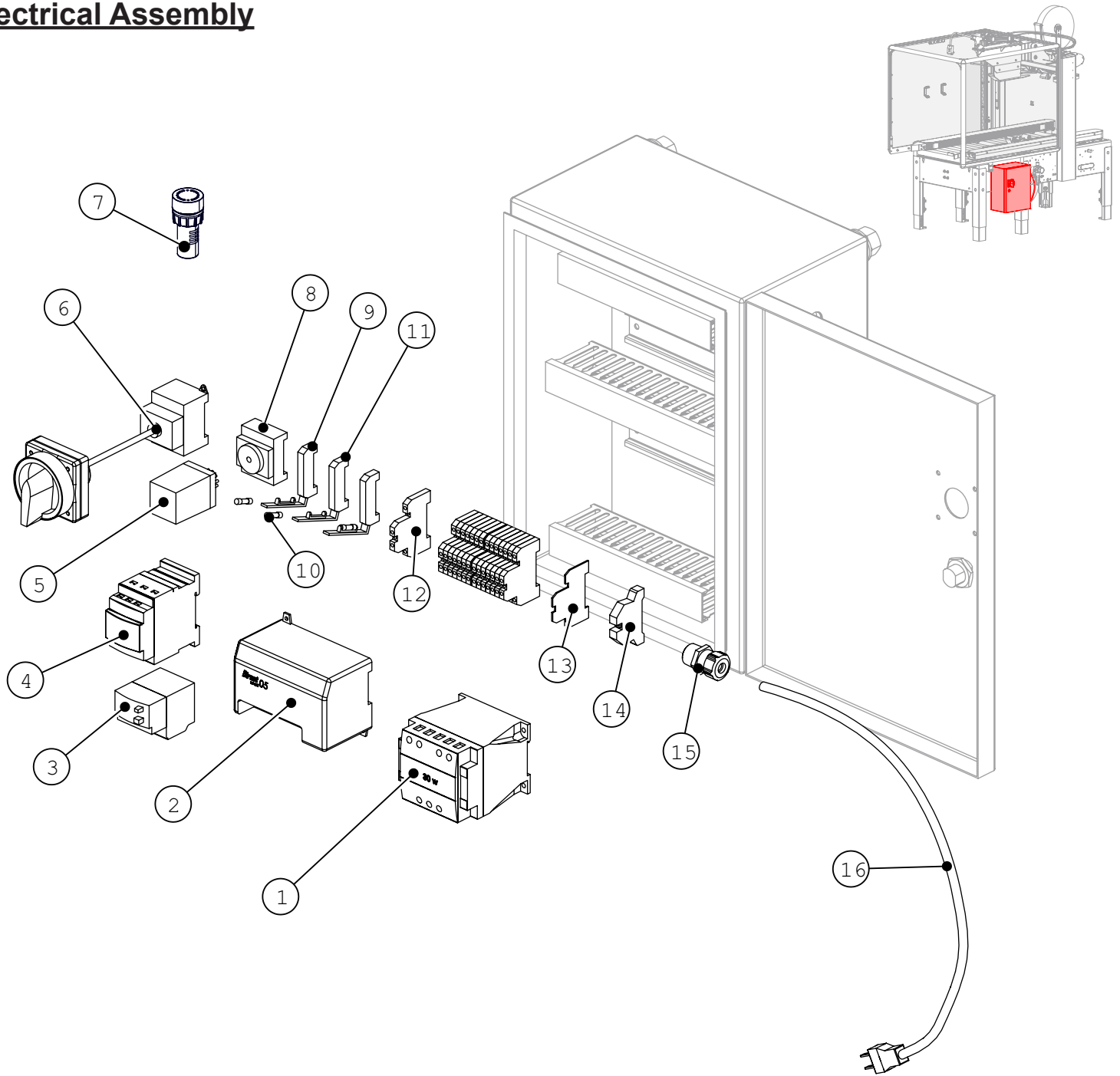


ITEM	PART NUMBER	DESCRIPTION	QTY
1	UF0840	M6-1 x 25 SHCS	1
2	UF1828	M6 FW	1
3	UF2210EV	SQUARE KEY ROUND ENDS 5x5x20	1
4	UPE0001EV	CRANK HANDLE, FOLDABLE	1
5	UF2210	SQUARE KEY	1
6	UPM0618	CHAIN #35-165	1
7	UPM0566EV	ACME SHAFT FOR HANDLE	1
8	UPM0575EV	CASTING LH	2
9	UPM0574EV	CASTING RH	2
10	UPM0576	BUMPER	8
11	UPM7583	SHAFT COLLAR	2
12	UF0866	M8-1.25 HNR	8
13	UF0867	M8 LW	8
14	UPM0523EV	FLANGE BEARING	4
15	UPM2198	BEARING SPACER	4
16	UPM2207	CAP VINYL BLACK	1

ITEM	PART NUMBER	DESCRIPTION	QTY
17	UF0640	1.4-20_1.25_SHCS	8
18	UPM3242	DRIVE SUPPORT SPACER	2
19	UPM0573EV	ACME SHAFT	1
20	UF2170	1/2" RETAINING RING	1
21	UPM0640EV	TENSIONNER PIN	1
22	UPM0639EV	BRASS BUSHING	1
23	UPM0620	SPROCKET	3
24	UF6314	M10-1.5 HNR	2
25	UF3680	M10 FW	4
26	UPM0631EV	M1286	1
27	UF6371	M10 LW	2
28	UF6382	M10-1.5 x 25 HHCS	2
29	UF5402	M6 - 1 x 20 FHCS	1
30	UPM0641	CHAIN TENSIONNER SPACER	1

APPENDIX B - MACHINE PARTS LIST

Electrical Assembly

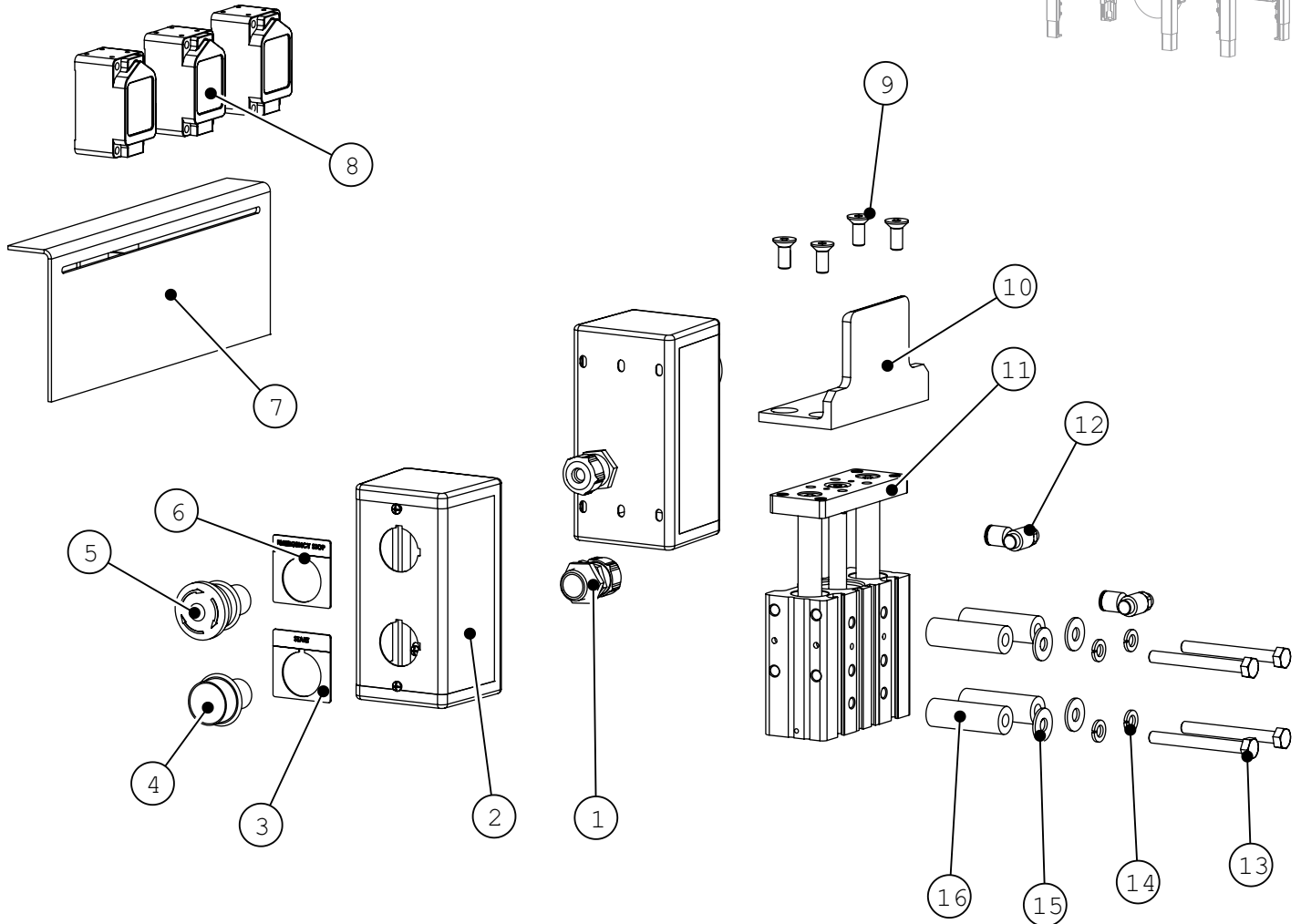
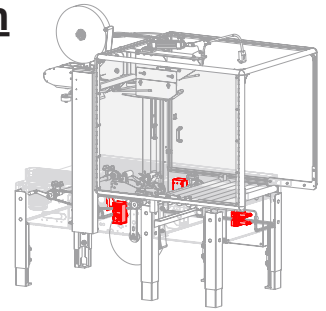


ITEM	PART NUMBER	DESCRIPTION	QTY
1	UPM4458	POWER SUPPLY IDEC 1.3 A	1
2	UPM3833	PLC KOYO 8IN VDC 6 OUT RELAY	1
3	UPM4505	MOTOR O/L TELEMEC 7-10A	1
4	UPM7524	MOTOR STARTER TELEMEC 110VAC	1
5	UPM4459	RELAY IDEC 24V 11 PINS	1
6	UPM7211	ON / OFF SAF SWITCH CONT PANEL	1
7	UPH7624	AUDIBLE BUZZER	1
8	UPM9726	RELAY SOCKET	1
9	UPM7428EV	FUSE TERMINAL BLOCK 5mm, WHITE LED	1

ITEM	PART NUMBER	DESCRIPTION	QTY
10	UPM7120	FUSE 5mm X 20mm 1A 250V	3
11	UPM4466	FUSE TERMINAL BLOCK 5mm, RED LED	2
12	UPM2880	TERMINAL BLOCK DOUBLE	15
13	UPM2881	TERMINAL BLOCK DOUBLE END CAP	2
14	UPM7440	TB END ANCHOR	1
15	UPM0197EV	STR.RELF	1
16	UPM0209	POWER CORD, 14/3	1

APPENDIX B - MACHINE PARTS LIST

Machine Base Sub Assys, Operator Control, Gate, Limit Switch

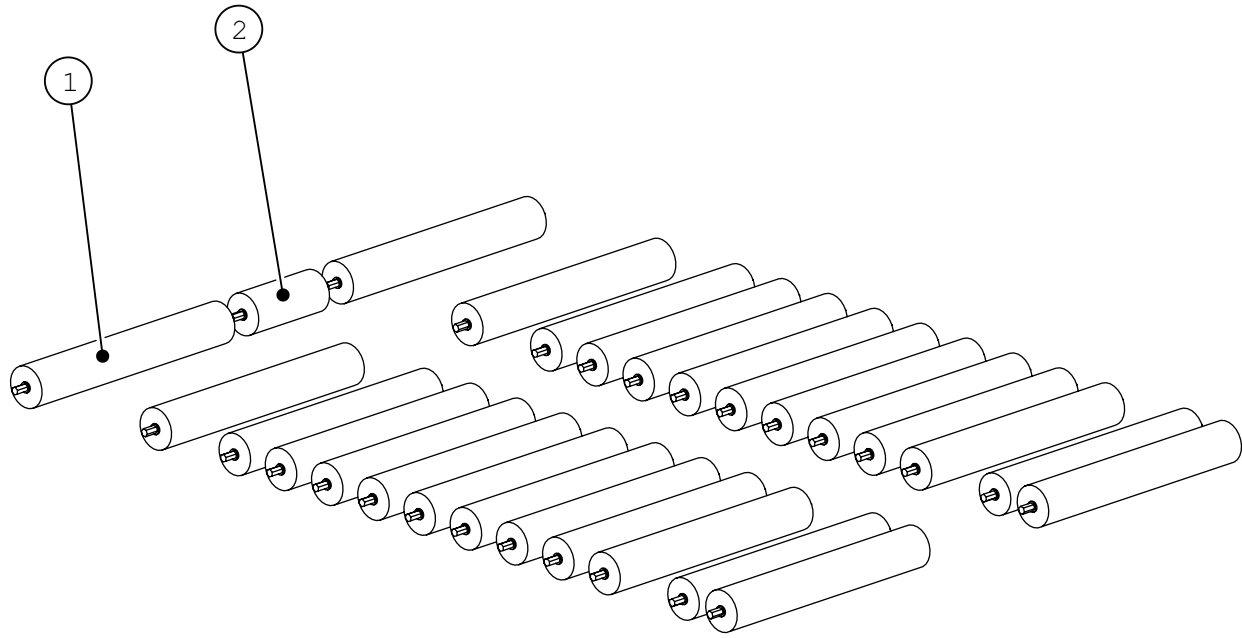
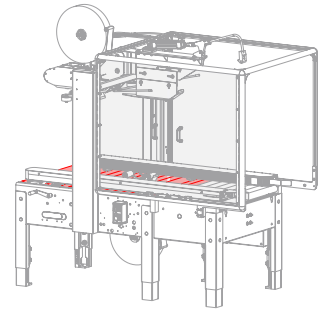


ITEM	PART NUMBER	DESCRIPTION	QTY
1	UPM0197EV	STR.RELF	2
2	UPM3962EV	ELECT. BOX	2
3	UPM0418	LEGEND PLATE "START"	2
4	UPM4514	ON/OFF GREEN BUTTON	2
5	UPM0693EV	STOP BUTTON RED MUSH INC	2
6	UPM0419	LEGEND PLATE "EMERG.STOP"	2
7	UPM4402EV	LIMIT SWITCH SUPPORT	1
8	UPM4403EV	OMRON LIMIT SWITCH	3
9	UF6370	M8-1.25 x 20 FHCS	4

ITEM	PART NUMBER	DESCRIPTION	QTY
10	UPM3854	GATE FOR BOSCH GUIDED CYL	1
11	UPM3804	CPC GUIDE CYLINDER	1
12	UPM3787	FLOW CONTROL VALVE	2
13	UF1190	M8-1.25 x 75 HHCS	4
14	UF0867	M8 LW	4
15	UF1821	M8 FW	4
16	UPM3870	GATE SPACER	4

APPENDIX B - MACHINE PARTS LIST

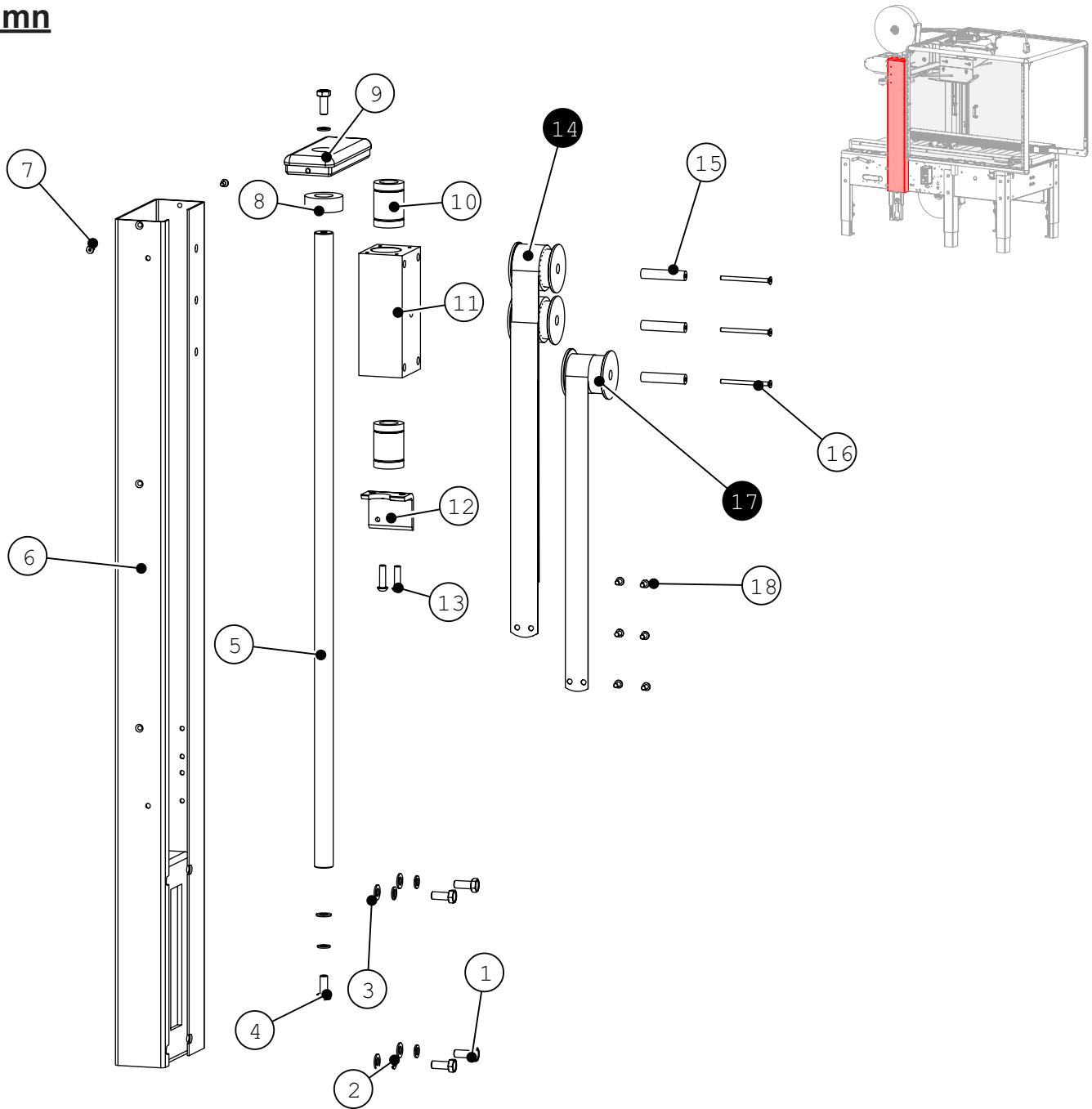
Machine Rollers



ITEM	PART NUMBER	DESCRIPTION	QTY
1	UPM3226	PVC ROL CHARCOAL DIA 1.9 X 12.00	26
2	UPM3227	PVC ROL CHARCOAL DIA 1.9 X 4.50	1

APPENDIX B - MACHINE PARTS LIST

Left Column

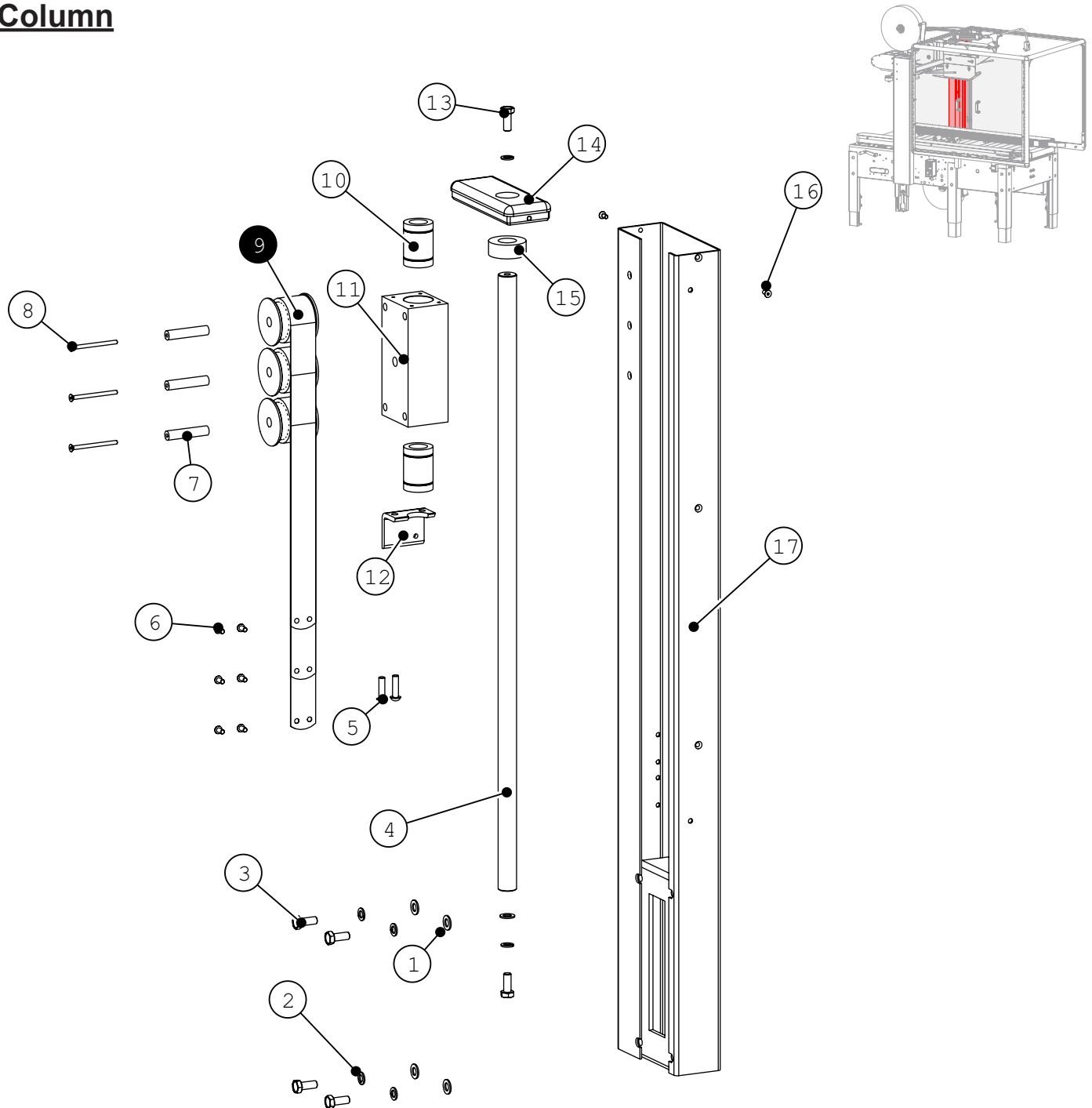


ITEM	PART NUMBER	DESCRIPTION	QTY
1	UF3647	M10-1.25 x 25 HHCS	4
2	UF6371	M10 LW	6
3	UF3680	M10 FW	5
4	UF6382	M10-1.5 x 25 HHCS	2
5	UPM0738EV	COLUMN SHAFT	1
6	UPM4428EV	COLUMN LH	1
7	UF5400	M5-0.8 x 12 FHCS	2
8	SAFETY BUMPER	UPM2251	1
9	UPM0741EV	COLUMN CAP LEFT SIDE	1
10	UPM4986	LINEAR BEARING 25MM	2

ITEM	PART NUMBER	DESCRIPTION	QTY
11	UPM0737EV	COLUMN BLOCK LEFT SIDE	1
12	UPM3730EV	SPRING ANCHOR LEFT SIDE	1
13	UF1318	M8-1 x 12 BHCS	2
14	USM0894	CONSTANT FORCE SPRING & SPOOL 24LB	2
15	UPM0743	SPRING MANDREL SHAFT	3
16	UF1157	M5-0.8 x 70 FHCS	3
17	USM0893	CONSTANT FORCE SPRING & SPOOL 33LB	1
18	UF1195	M6-1 x 12 BHCS	6

APPENDIX B - MACHINE PARTS LIST

Right Column

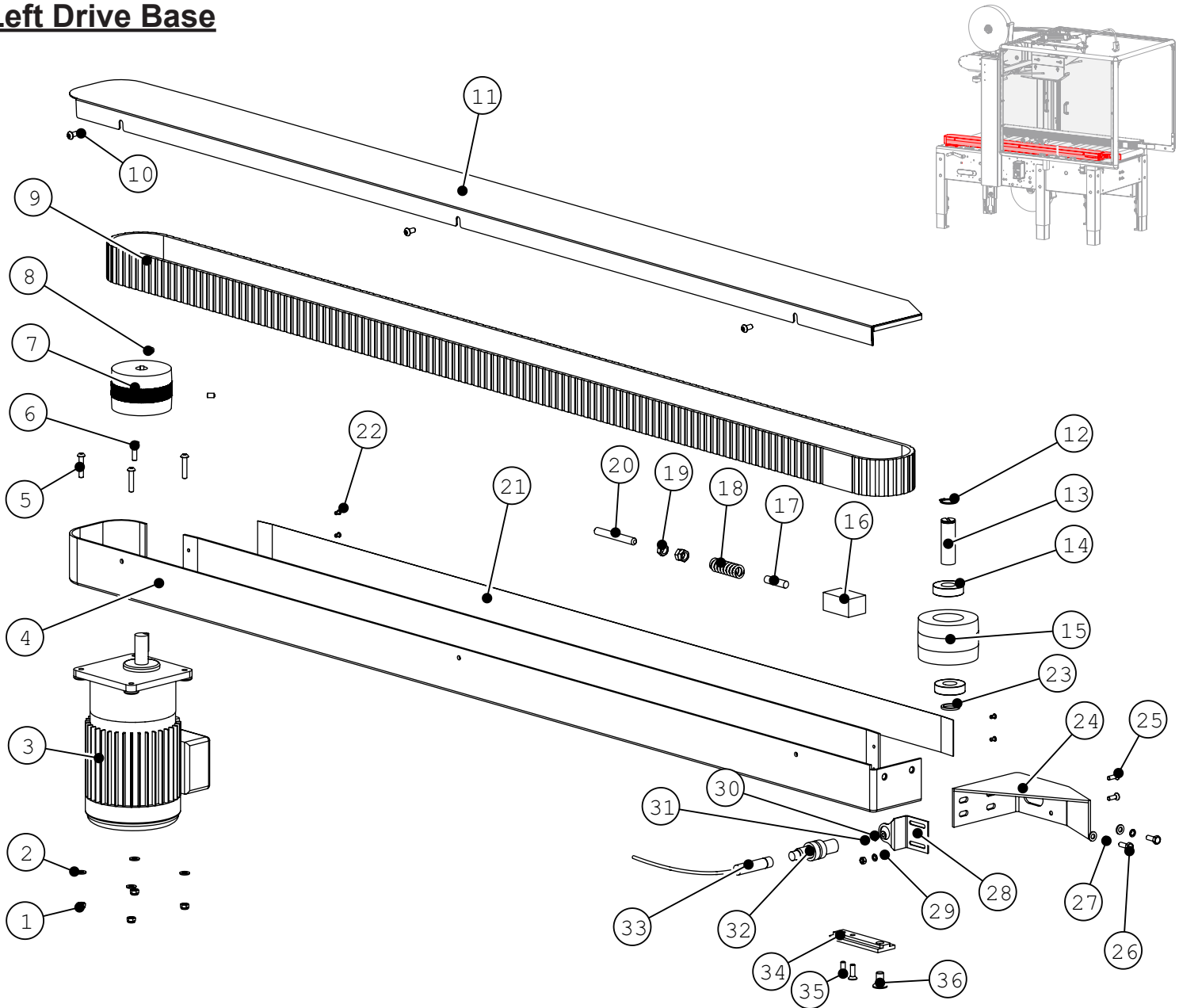


ITEM	PART NUMBER	DESCRIPTION	QTY
1	UF3680	M10 FW	5
2	UF6371	M10 LW	6
3	UF3647	M10-1.25 x 25 HHCS	4
4	UPM0738EV	COLUMN SHAFT	1
5	UF1318	M8-1 x 12 BHCS	2
6	UF1195	M6-1 x 12 BHCS	6
7	UPM0743	SPRING MANDREL SHAFT	3
8	UF1157	M5-0.8 x 70 FHCS	3
9	USM0894	CONSTANT FORCE SPRING & SPOOL 24LB	3

ITEM	PART NUMBER	DESCRIPTION	QTY
10	UPM4986	LINEAR BEARING 25MM	2
11	UPM0735EV	COLUMN BLOCK, RIGHT	1
12	UPM3731EV	SPRING ANCHOR RIGHT SIDE	1
13	UF6382	M10-1.5 x 25 HHCS	2
14	UPE0141	COLUMN CAP PNEUMATIC PASS THROUGH	1
15	UPM2251	SAFETY BUMPER	1
16	UF5400	M5-0.8 x 12 FHCS	2
17	UPM4429EV	COLUMN RH	1

APPENDIX B - MACHINE PARTS LIST

Left Drive Base

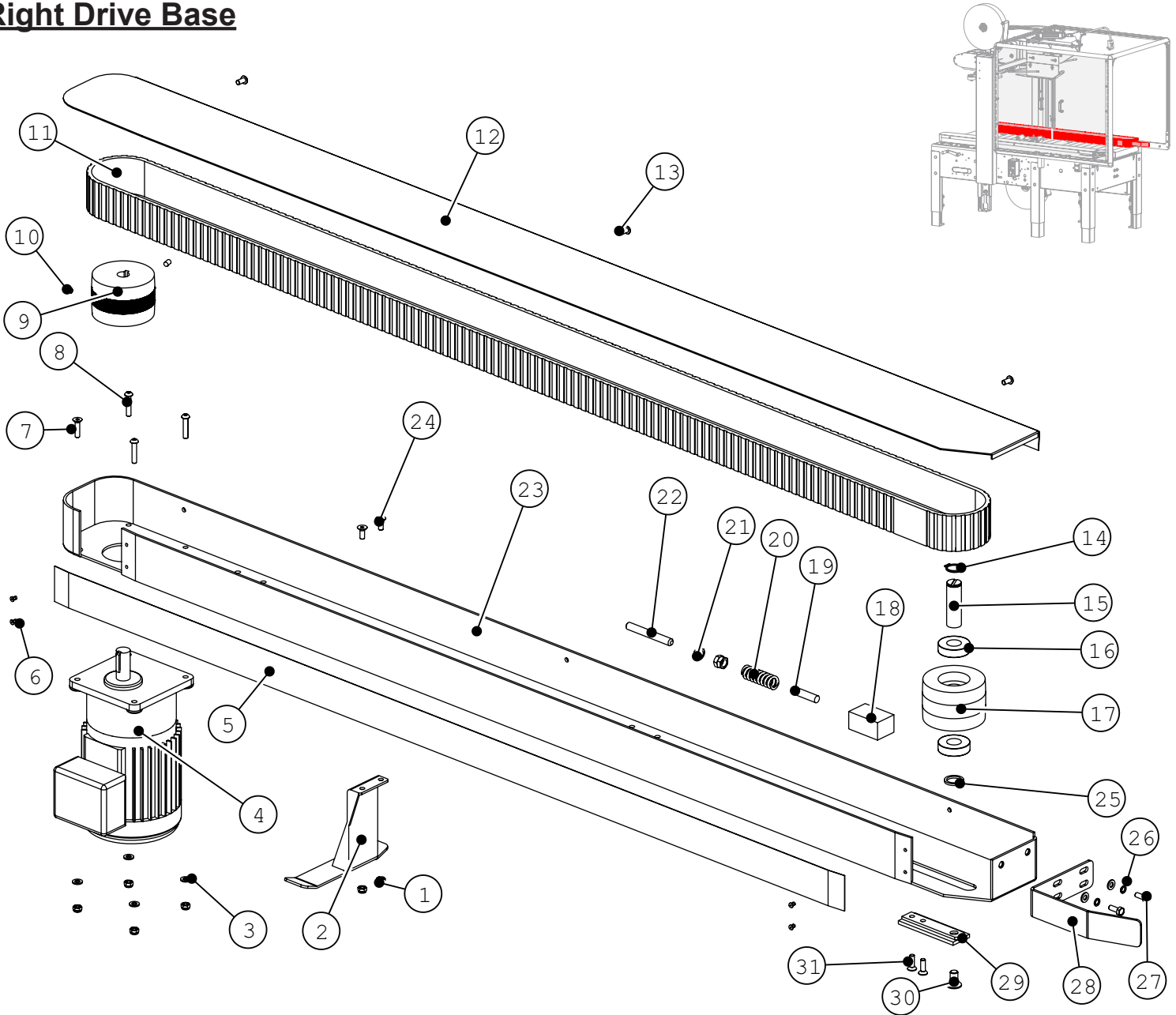


ITEM	PART NUMBER	DESCRIPTION	QTY
1	UF5900	M6-1.0 LOCK-NUT	4
2	UF1828	M6 FW	6
3	UPM7116CD	MOTOR 1/3 21.4 : 1	1
4	UPM3546EV	DRIVE SECTION LH	1
5	UF3711	M6-1 x 30 BHCS	3
6	UF1194	M6-1 x 25 FHCS	1
7	UPM4450	DRIVE PULLEY	1
8	UF3683	M6-1 x 10 SSS	2
9	UPM3544	BELT ENDL. SAG 12E, 2" X 124.5"	1
10	UF1195	M6-1 x 12 BHCS	3
11	UPM3548EV	DRIVE COVER LH	1
12	UF2220	SNAP RING	1
13	UPM1233EV	IDLER PULLEY SHAFT	1
14	UPM0324	BEARING, PULLEY	2
15	UPM0259	IDLER PULLEY	1
16	UPM0101EV	TENSIONNER SPRING HOLDER	1
17	UPM0112	SPRING LOCATOR PIN	1
18	UPM0038	DIE SPRING	1
19	UF1610	3.8-16 HNJ	3

ITEM	PART NUMBER	DESCRIPTION	QTY
20	UF1400	3.8-16 3.0 SS	1
21	UPM0029	STRIP UHMW 2" X .03"THK	1
22	UF2080	POP RIVET S-44	4
23	UPM0109	IDLER PULLEY SPACER	1
24	UPM3574EV	CARTON RETAINER	1
25	UF5404	M5-0.8 x 16 FHCS	2
26	UF0454	M6-1.0 x 16 HHCS	2
27	UF6363	M6 LW	2
28	UPM3248EV	SENSOR SUPPORT	1
29	UF6340	M5 FW	2
30	UF7023	M5 LW	2
31	UF6307	M5-0.8 HNR	2
32	UPM0317	PHOTOELECTRIC SENSOR	1
33	UPM0321	QUICK CONNECT CABLE	1
34	UPM1879EV	TENSIONNER SLIDE	1
35	UF5402	M6-1 x 20 FHCS	2
36	UF6397	M10-1.5 x 20 FHCS	1

APPENDIX B - MACHINE PARTS LIST

Right Drive Base

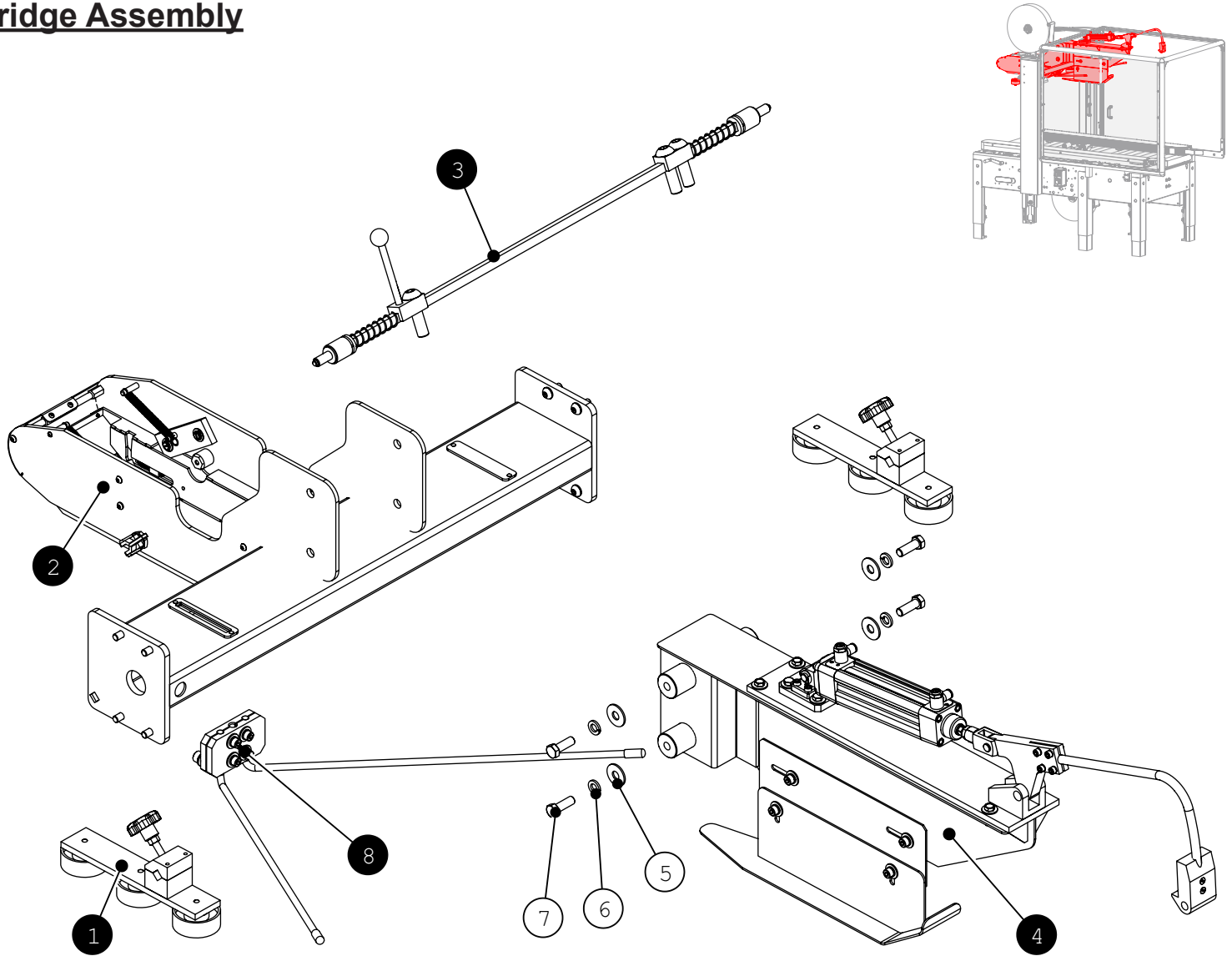


ITEM	PART NUMBER	DESCRIPTION	QTY
1	UF5900	M6-1.0 LOCK-NUT	6
2	UPM4401EV	LIMIT SWITCH BRACKET	1
3	UF1828	M6 FW	6
4	UPM7116CD	MOTOR 1/3 21.4 : 1	1
5	UPM0029	STRIP UHMW 2" X .03"THK	1
6	UF2080	POP RIVET S-44	4
7	UF1194	M6-1 x 25 FHCS	1
8	UF3711	M6-1 x 30 BHCS	3
9	UPM4450	DRIVE PULLEY	1
10	UF3683	M6-1 x 10 SSS	2
11	UPM3544	BELT ENDL. SAG 12E, 2" X 124.5"	1
12	UPM3547EV	DRIVE COVER RH	1
13	UF1195	M6-1 x 12 BHCS	3
14	UF2220	SNAP RING	1
15	UPM1233EV	IDLER PULLEY SHAFT	1
16	UPM0324	BEARING, PULLEY	2

ITEM	PART NUMBER	DESCRIPTION	QTY
17	UPM0259	IDLER PULLEY	1
18	UPM0101EV	TENSIONNER SPRING HOLDER	1
19	UPM0112	SPRING LOCATOR PIN	1
20	UPM0038	DIE SPRING	1
21	UF1610	3.8-16 HNJ	3
22	UF1400	3.8-16 3.0 SS	1
23	UPM3545EV	DRIVE SECTION RH	1
24	UF1192	M6-1 x 16 FHCS	2
25	UPM0109	IDLER PULLEY SPACER	1
26	UF6363	M6 LW	2
27	UF0454	M6-1.0 x 16 HHCS	2
28	UPM0647	CARTON RETAINER	1
29	UPM1879EV	TENSIONNER SLIDE	1
30	UF6397	M10-1.5 x 20 FHCS	1
31	UF5402	M6-1 x 20 FHCS	2

APPENDIX B - MACHINE PARTS LIST

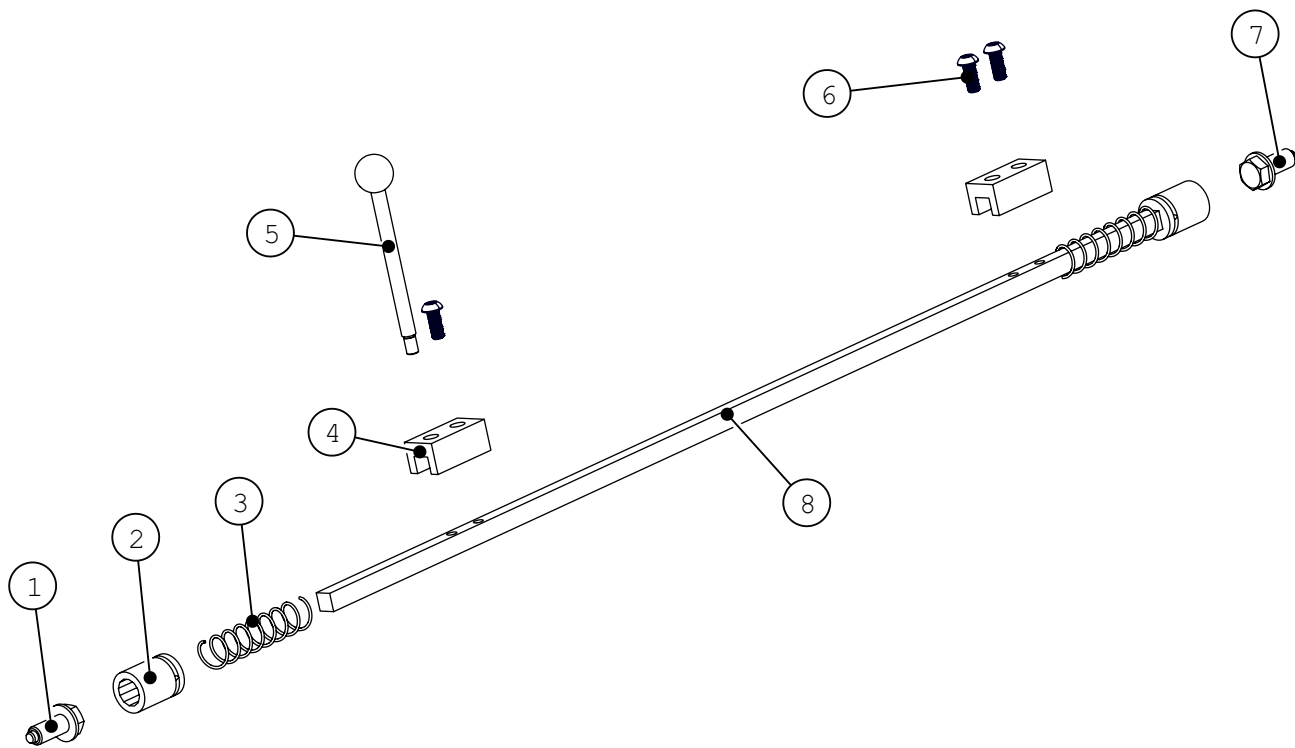
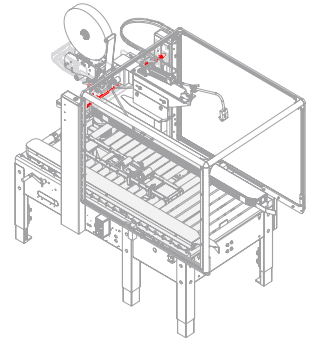
Bridge Assembly



ITEM	PART NUMBER	DESCRIPTION	QTY
1	USM6109	COMPRESSION GUIDE ASS'Y	2
2	USM6105	BRIDGE WITH TH BOX ASSEMBLY	1
3	USM0391	SINGLE LOCK ASS'Y	1
4	USM6107	KICKER ASSEMBLY	1
5	UF4231	M12 FW	4
6	UF4230	M12 LW	4
7	UF3062	M12-1.75 x 25 HHCS	4
8	UAM0351	PLOW ASSEMBLY	1

APPENDIX B - MACHINE PARTS LIST

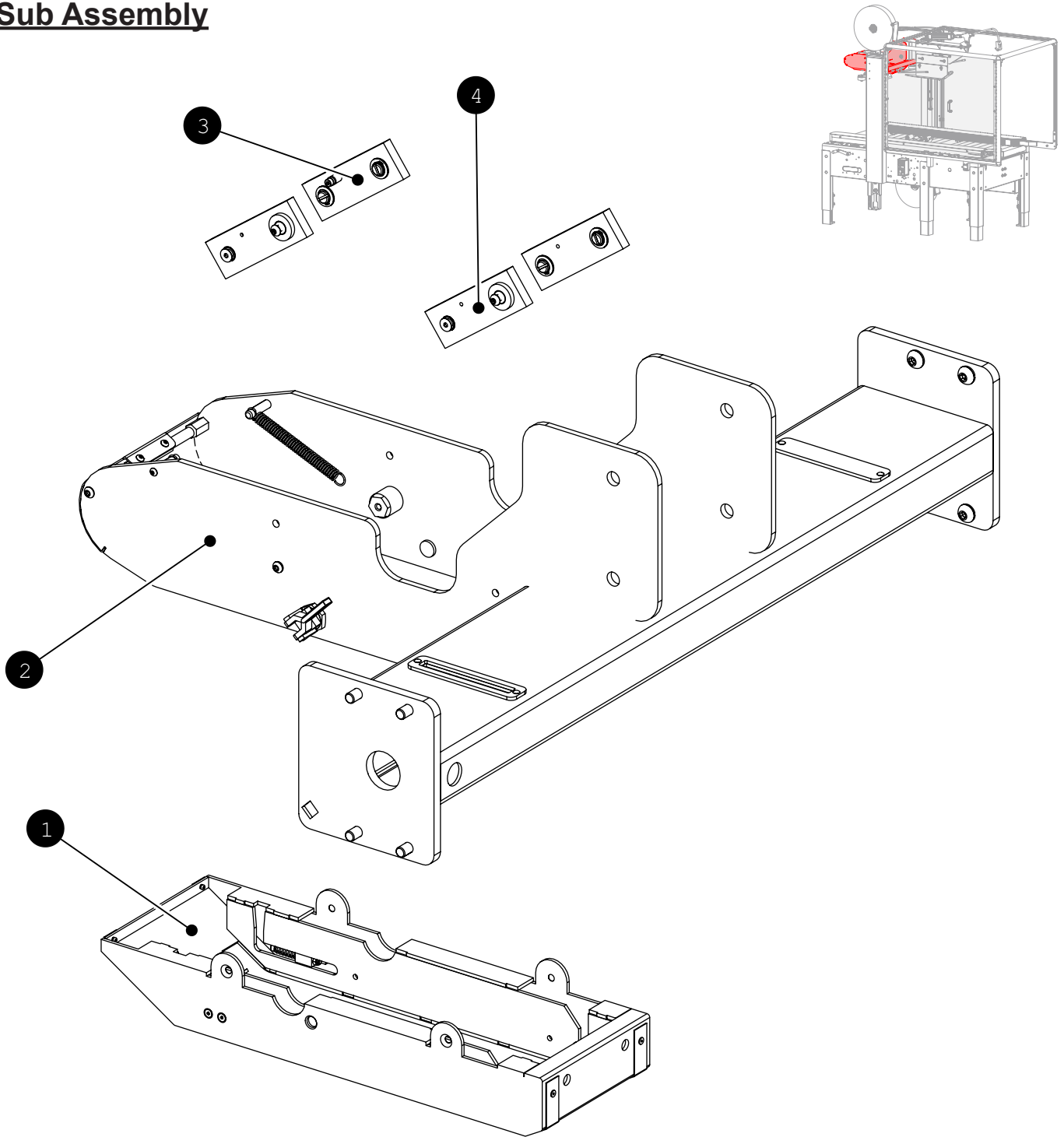
Locking Assembly



ITEM	PART NUMBER	DESCRIPTION	QTY
1	UPM0699	FLANGED SCREW, 1/2 R.H.	1
2	UPM0703	SHORT BOX 3/4", 1/2" DR, 12 PT	2
3	UPM2184	COMPRESSION SPRING	2
4	UPM0700	SINGLE LOCKING BLOCK	2
5	UPM0688	SINGLE LOCKING HANDLE	1
6	UF1318	M8-1.25 x 20 BHCS	1
7	UPM0698	FLANGED SCREW, 1/2 L.H.	1
8	UPM2187	SQUARE BAR 0.50"	1

APPENDIX B - MACHINE PARTS LIST

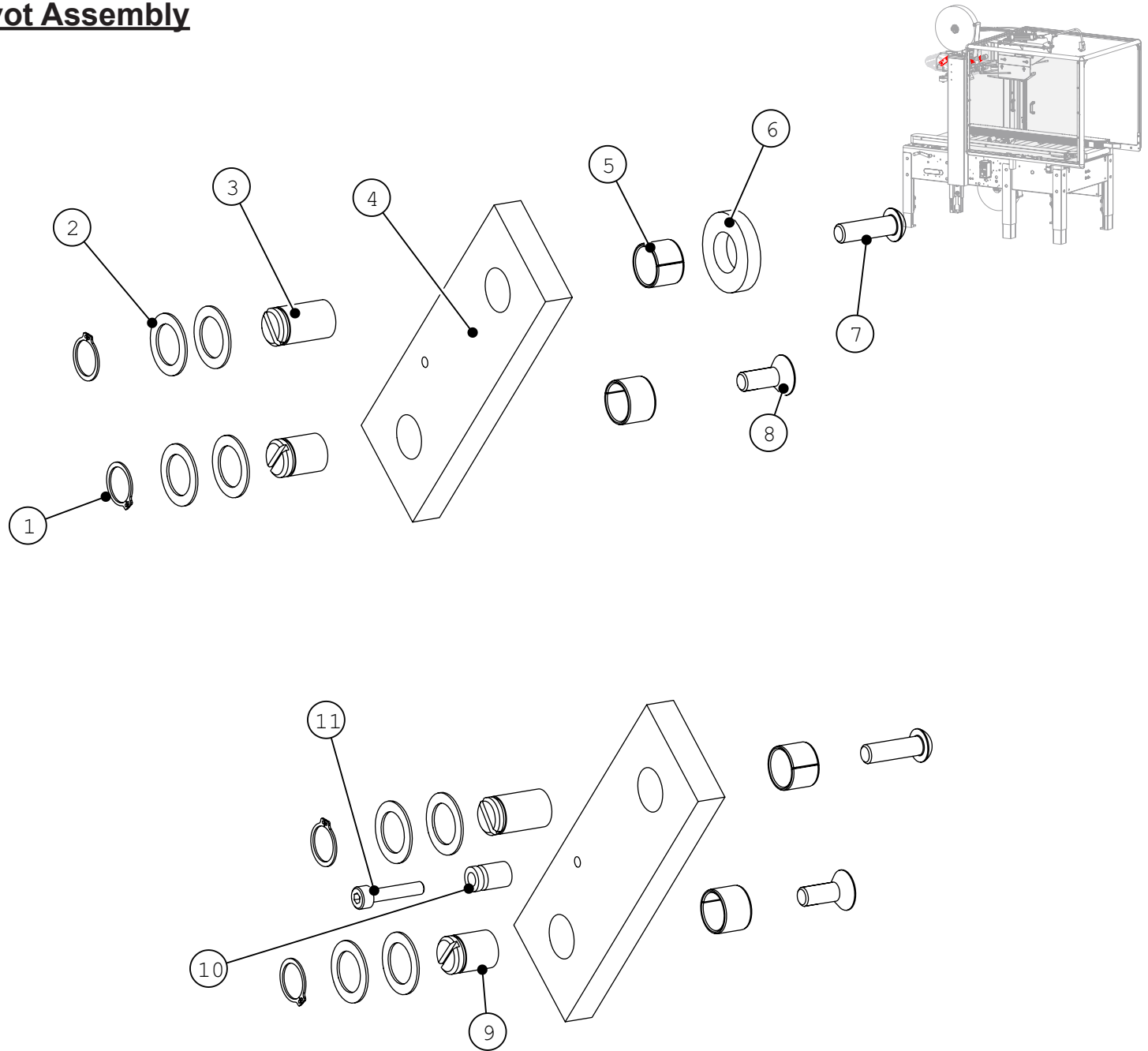
Bridge Sub Assembly



ITEM	PART NUMBER	DESCRIPTION	QTY
1	UAM0350	TAPE HEAD BOX ASSEMBLY	1
2	UAM0349	BRIDGE WELDMENT ASSEMBLY	1
3	UAM0297	PIVOT ASS'Y	2
4	UAM0296	PIVOT ASS'Y	2

APPENDIX B - MACHINE PARTS LIST

Pivot Assembly

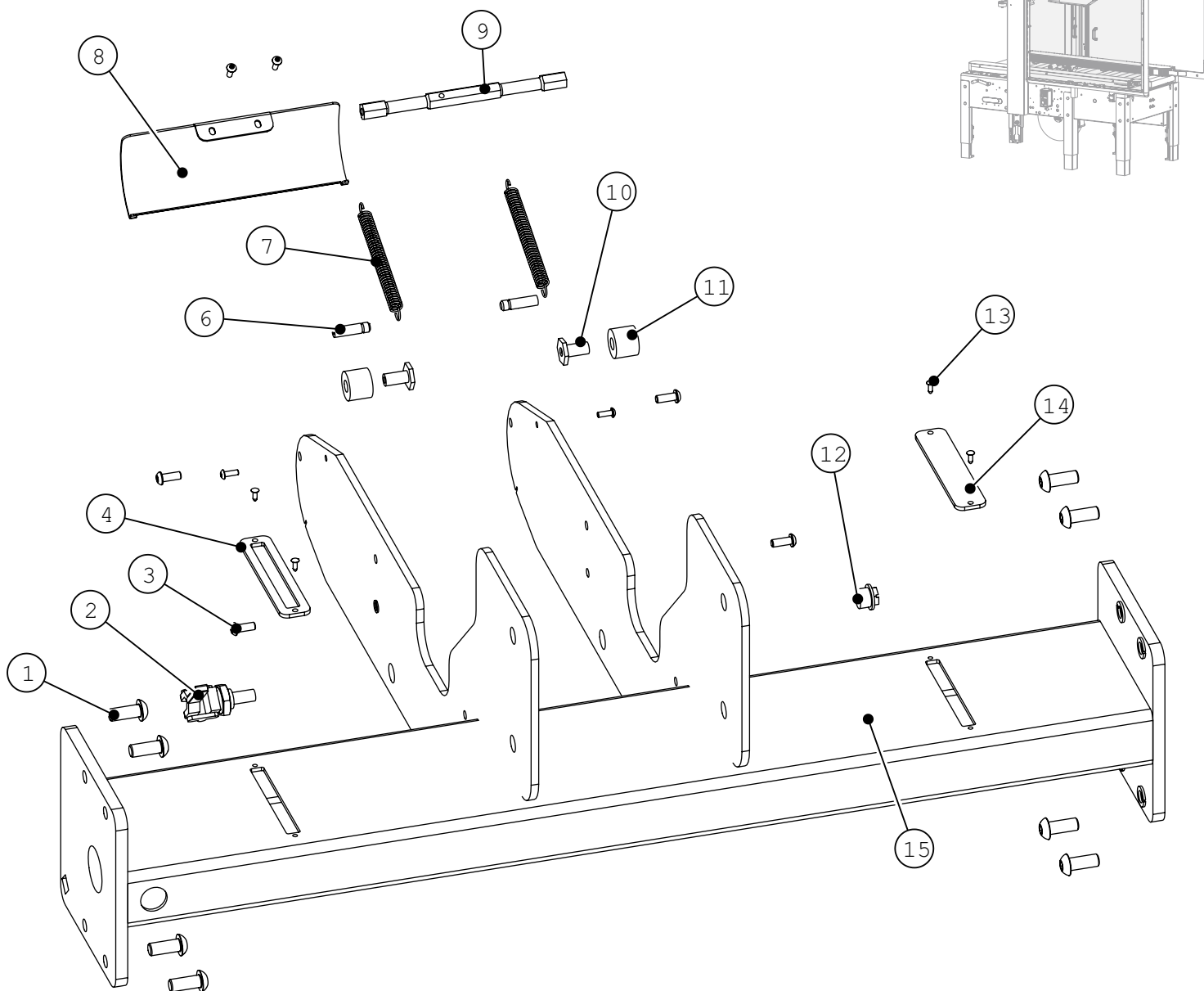


ITEM	PART NUMBER	DESCRIPTION	QTY
1	UF6300	RETAINING RING	8
2	UF1940	F.W. NYLON	16
3	UPM0968EV	PIVOT SHAFT LONG	4
4	UPM1130EV	PIVOT PLATE	4
5	UPM9075	BEARING, PLAIN	8
6	UPM1158	PIVOT SHAFT SPACER	2

ITEM	PART NUMBER	DESCRIPTION	QTY
7	UF1241EV	M6-1 x 20 BHCS	4
8	UF1192	M6-1 x 16 FHCS	4
9	UPM2247EV	PIVOT SHAFT SHORT	4
10	UPM0962EV	SPRING RETAINER	2
11	UF3646	M4-0.7 x 20 SHCS	2

APPENDIX B - MACHINE PARTS LIST

Bridge Weldment Assembly

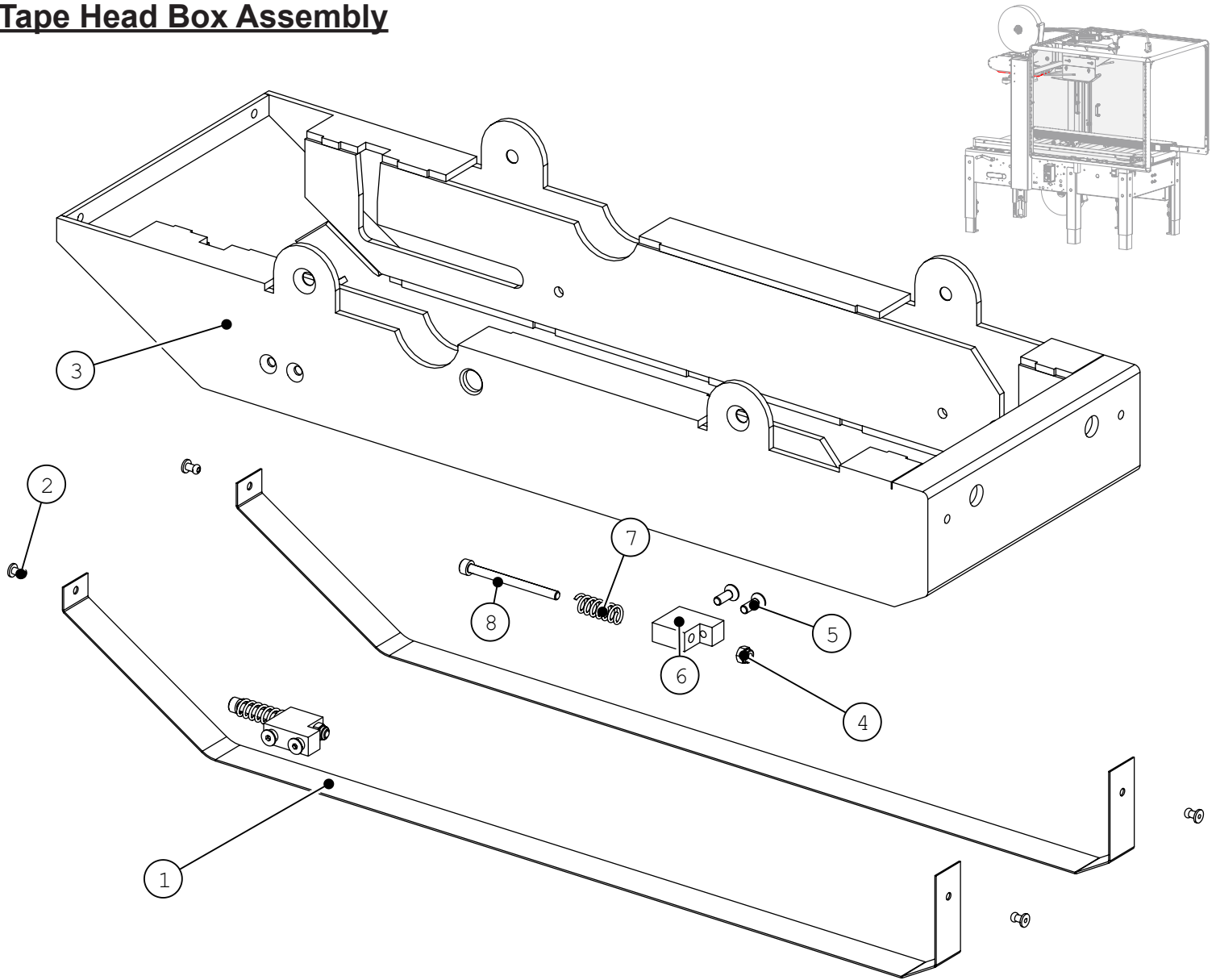


ITEM	PART NUMBER	DESCRIPTION	QTY
1	UF6404	M10-1.5 x 25 BHCS	7
2	UPM2196	TOGGLE CLAMP	1
3	UF1250EV	M6-1 x 16 BHCS	4
4	UPM1011	BRIDGE PLATE COVER SLOTTED	1
6	UPM0967EV	SPRING RETAINER LONG	2
7	UPM1042	PIVOT EXTENTION SPRING	2
8	UPM3292	REAR COVER GUARDING	1
9	UPM3291EV	REAR HEX SPACER BAR	1

ITEM	PART NUMBER	DESCRIPTION	QTY
10	UPM2168EV	STOP RETAINER TH BOX	2
11	UPM4449	FLOATING THB STOP	2
12	UPM2237	THREADED PLUG	1
13	UPM2192	BLACK PLUG	2
14	UPM1008	BRIDGE PLATE COVER	1
15	UPM3549EV	BRIDGE WELDMENT	1

APPENDIX B - MACHINE PARTS LIST

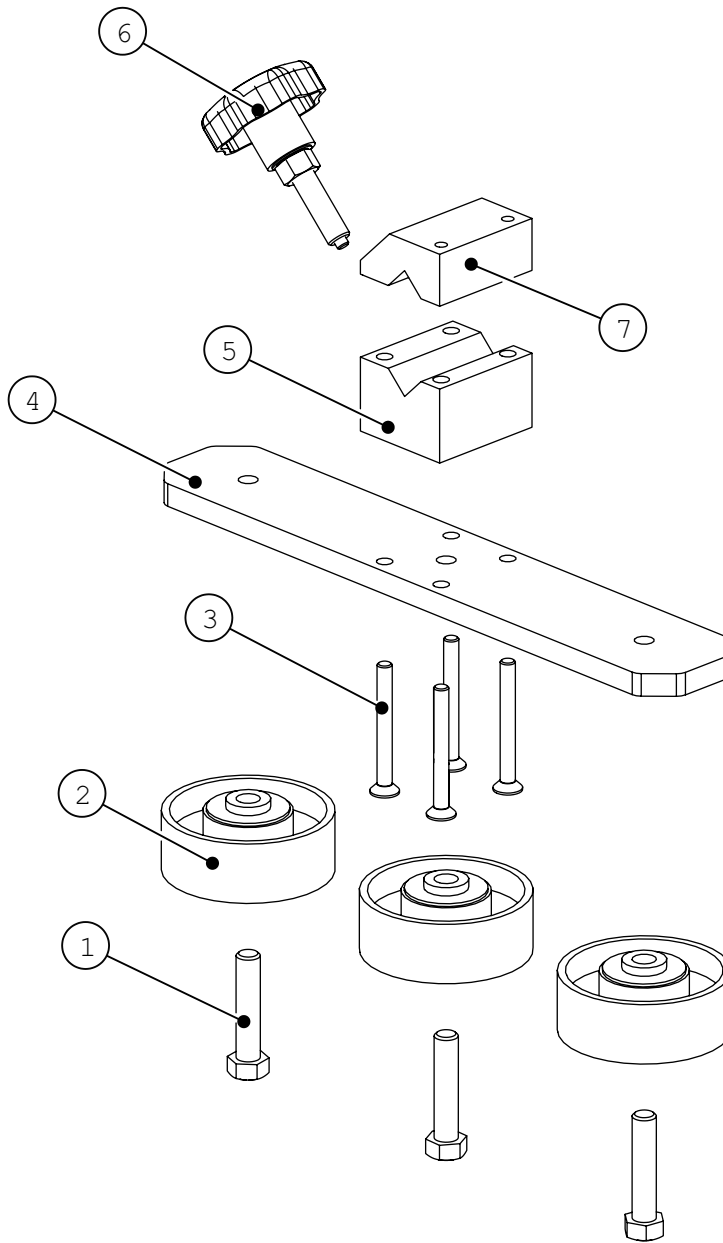
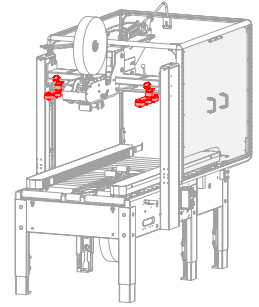
Tape Head Box Assembly



ITEM	PART NUMBER	DESCRIPTION	QTY
1	UPM0029	STRIP, UHMW, 2" W X .03" THK	2
2	UF2080	POP RIVET S-44	4
3	UPM3550EV	TH BOX WELDMENT	1
4	UF6376	M4-0.7 LOCK-NUT	2
5	UF3714	M4-0.7 x 12 FHCS	4
6	UPM7541	SPRING SUPPORT M4	2
7	UPM1068	COMP.SPRING SWIVEL T.H. ASSY	2
8	Default	M4-0.7 x 50 SHCS	2

APPENDIX B - MACHINE PARTS LIST

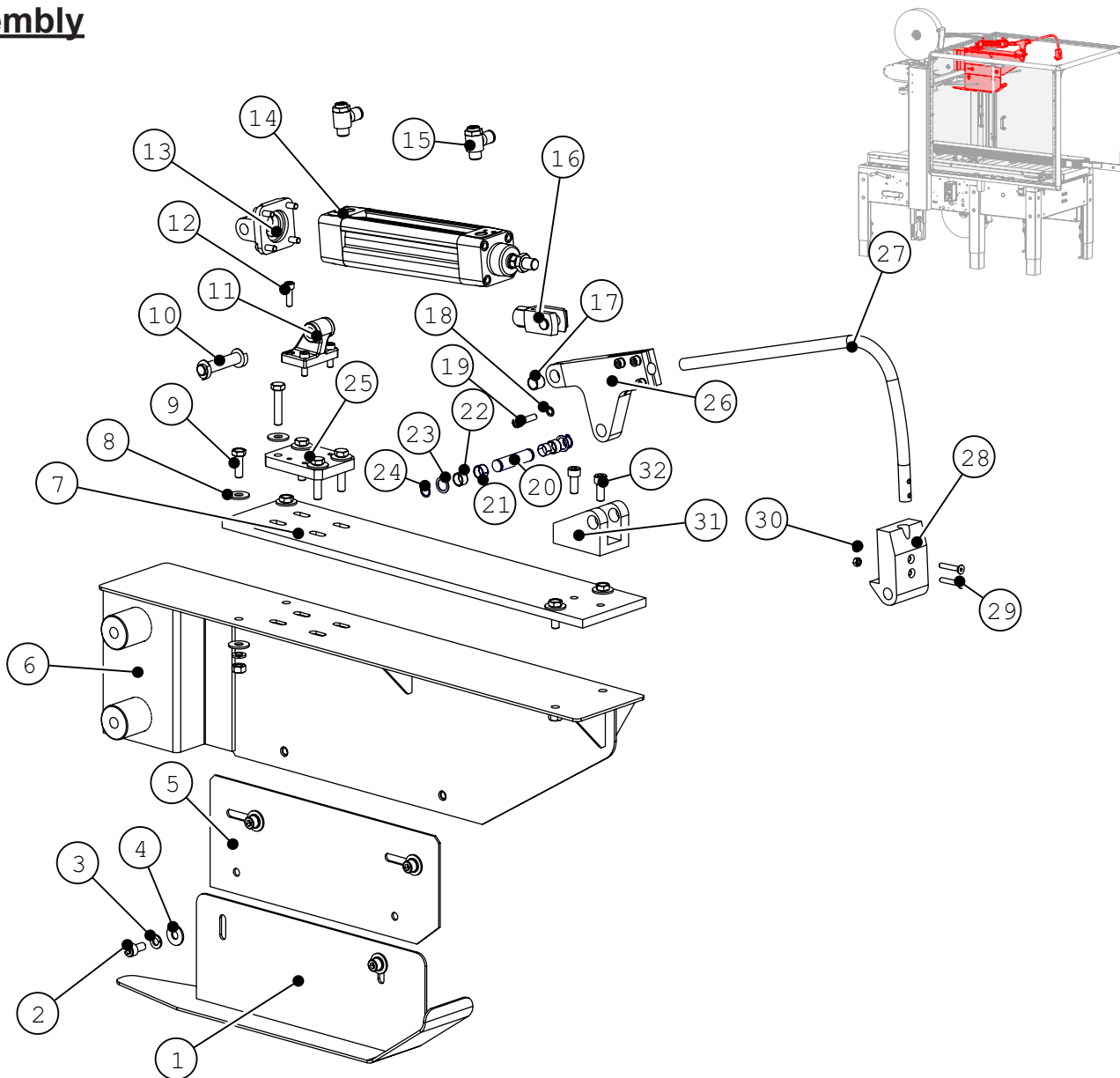
Compression Guide



ITEM	PART NUMBER	DESCRIPTION	QTY
1	UF0240	3.8-16 x 1.75" HHCS	3
2	UPM1659	WHEEL 2-7/8"DIA.COMPR.GUIDE	3
3	UF6373	M6 - 1 x 55 FHCS	4
4	UPM7491	WHEEL SUPPORT PLATE	1
5	UPM3285EV	GUIDE BLOCK	1
6	6020-50-38	KNOB	1
7	UPM7538	GUIDE BLOCK TOP	1

APPENDIX B - MACHINE PARTS LIST

Kicker Assembly



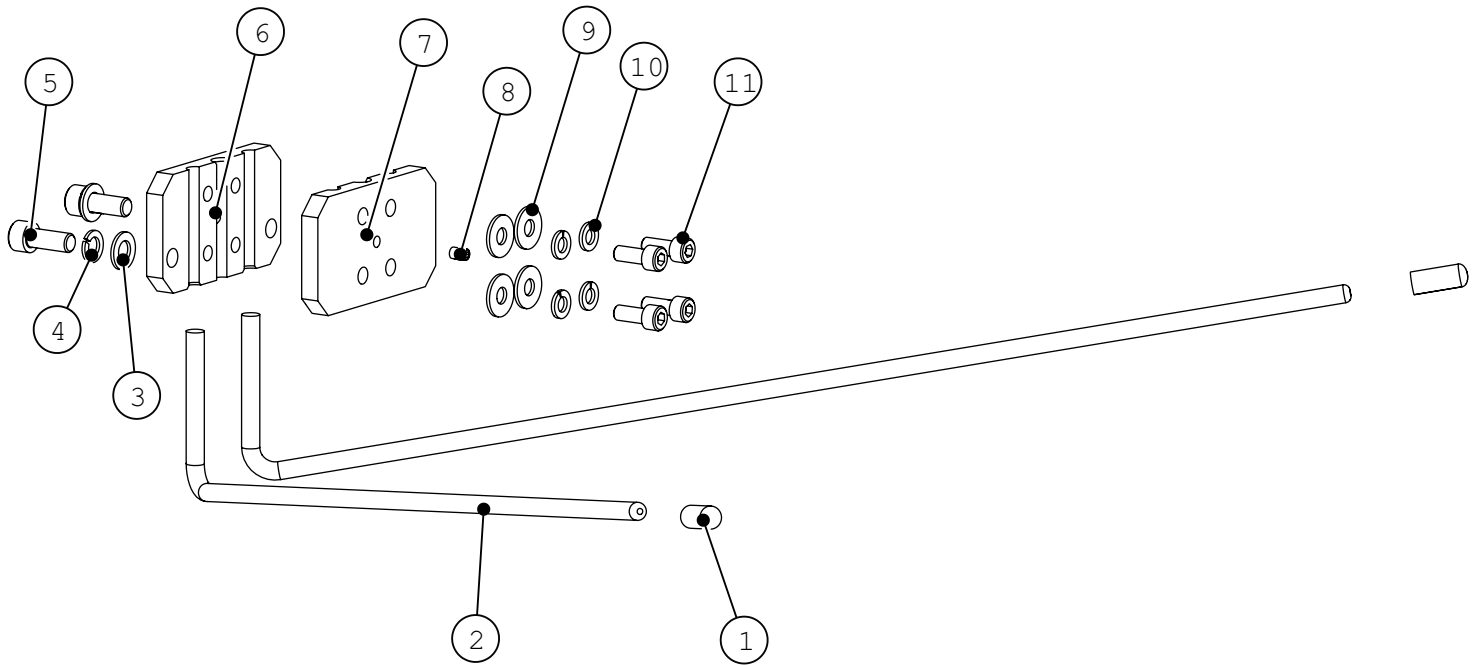
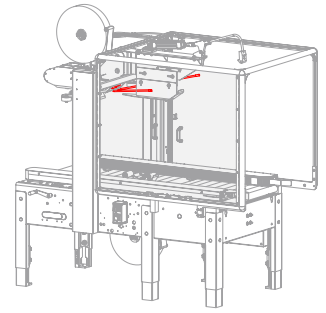
ITEM	PART NUMBER	DESCRIPTION	QTY
1	UPM4352	SKI	1
2	UF6367	M8-1.25 x 16 SHCS	4
3	UF0867	M8 LW	12
4	UF1821	M8 FW	20
5	UPM4350EV	SKI MOUNTING PLATE	1
6	UPM4351EV	BRIDGE EXTENSION	1
7	UPM3874EV	KICKER MOUNTING PLATE	1
8	UF6310	M8-1.25 x 25 HHCS	4
9	UF4232	M8-1.25 x 40 HHCS	4
10	UPM2903	PIVOT PIN-SNAP RING	1
11	UPM2900	BEARING BLK FOR 40mmCYL.	1
12	UF0835	M6-1 x 20 SHCS	4
13	UPM2901	REAR CLEVIS, 40mmCYL.	1
14	UPM2899	AIR CYL. 40 X 130mm ISO	1
15	UPM3132	FLOW CONTROL G 1/4	2
16	UPM2902	CLEVIS (P1) FOR ISO 40mm CYL.	1
17	UPH0907	BEARING 12 x 14 x 12 LG.	1

ITEM	PART NUMBER	DESCRIPTION	QTY
18	UF6363	M6 LW	4
19	UF0840	M6-1 x 25 SHCS	1
20	UPM3849	SS CLEVIS PIN 0.50 DIA	1
21	UPH0909	BEARING 12x14x8LG	1
22	UPH0089	BEARING GLYCODUR .50x .38 LG	2
23	UF1940	F.W. NYLON 1/2IDx.772ODx.032TH	2
24	UF3552	SS 1/2" RETAINING RING	2
25	UPM2917	CYLINDER ANCHOR BLOCK	1
26	UPM9693	KICKER BLOCK LIGHT	1
27	UPM2628	UA KICKER IN SS TUBE	1
28	UPM2615	UHMW DUCK SHAPE KICKER HEAD	1
29	UF4332	M5-0.8 x 30 FHCS	2
30	UF6307	M5-0.8 HNR	2
31	UPM0380	KICKER CLEVIS	1
32	UF5204	M8-1.25 x 20 SHCS	2

If your Kicker Assembly appears different from the above please contact IPG Machine Support.

APPENDIX B - MACHINE PARTS LIST

Flap Folder

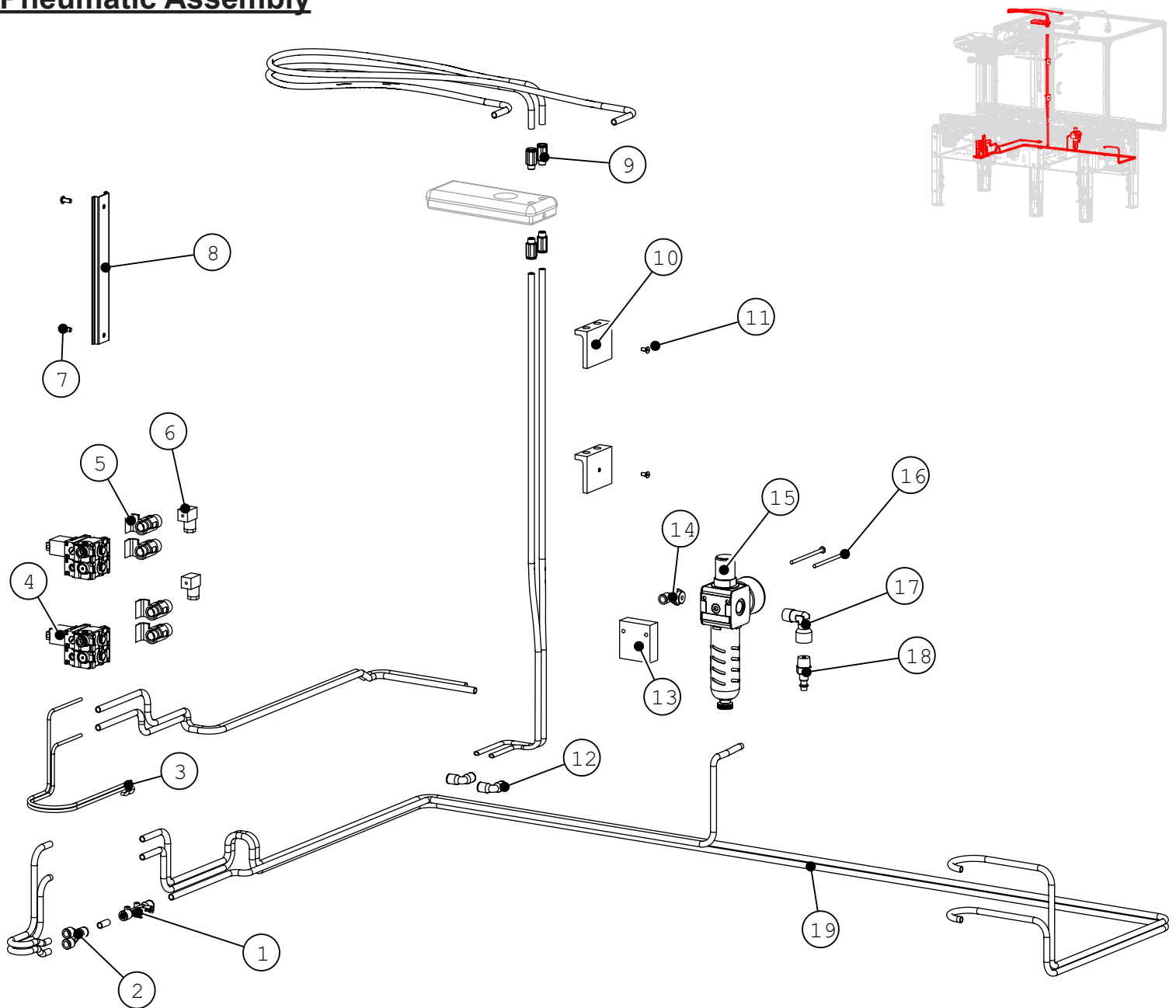


ITEM	PART NUMBER	DESCRIPTION	QTY
1	UPM3413	3/8 VINYL CAP YELLOW	2
2	UPM3741	PLOW ROD	2
3	UF3680	M10 FW	2
4	UF6371	M10 LW	2
5	UF0868	M10-1.5 x 25 SHCS	2
6	UPM7207EV	PLOW BLOCK BACK	1

ITEM	PART NUMBER	DESCRIPTION	QTY
7	UPM2287EV	PLOW BLOCK FRONT	1
8	UF3683	M6-1 x 10 SSS	1
9	UF1821	M8 FW	4
10	UF0867	M8 LW	4
11	UF5204	M8-1.25 x 20 SHCS	4

APPENDIX B - MACHINE PARTS LIST

Pneumatic Assembly

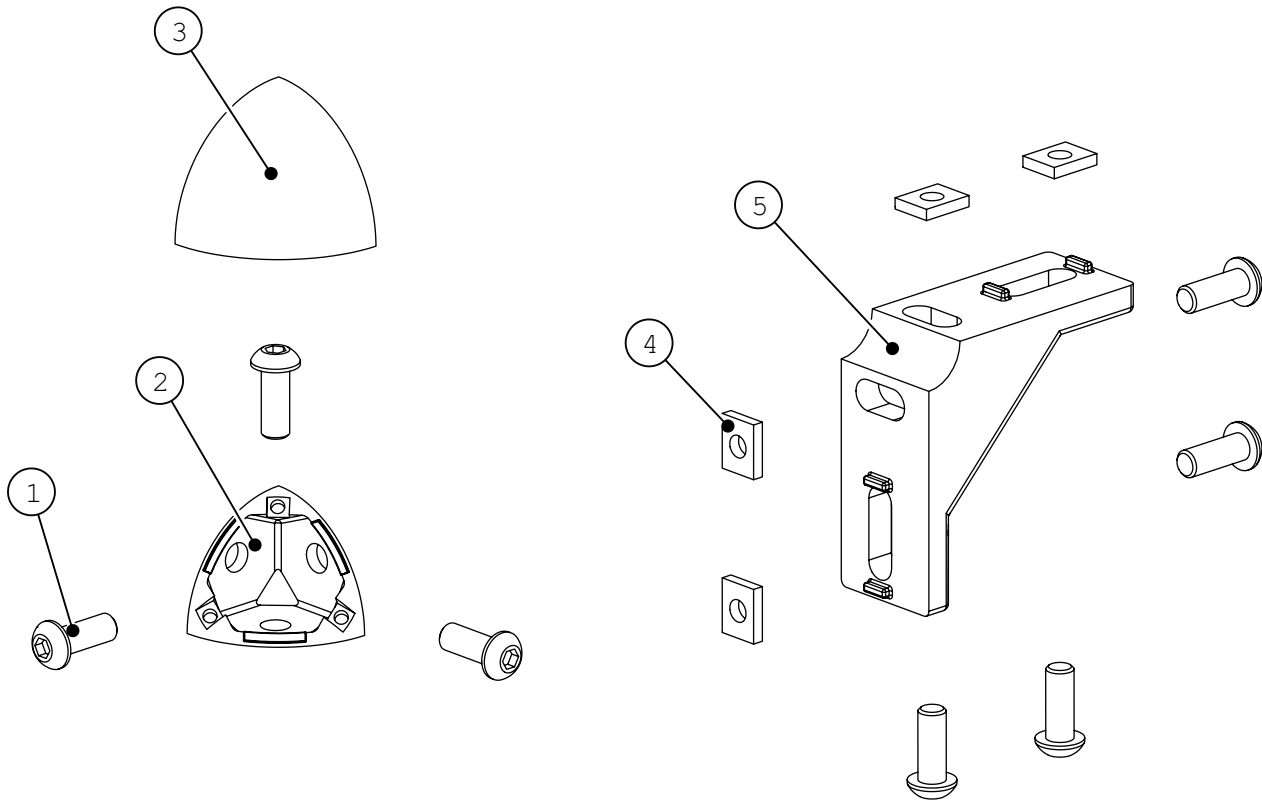
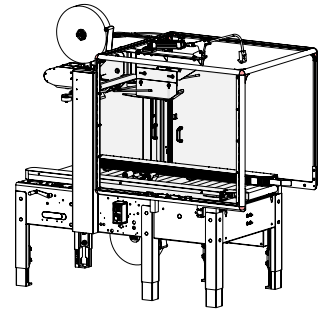


ITEM	PART NUMBER	DESCRIPTION	QTY
1	UPM3396	MULT T-CON	1
2	UPM4346	Y CONNECTOR (8MM to 2 x 8MM)	1
3	UPM3583	4MM TUBE, BLUE	1
4	UPM3394	VALVE 5/2 MAN. ADJUSTABLE 24V PE	2
5	UPM3391	SILENCER VALVE	4
6	UPM3392	ELECT. CONN WITH LED VALVE	2
7	UF3687	M5-0.8 x 12 BHCS	2
8	UPM0407	DIN RAIL	1
9	UPM3182	FTG. STR 8MMTUBE 1/8NPT MALE	4
10	UPM3386	AIR TUBE GUIDE	2

ITEM	PART NUMBER	DESCRIPTION	QTY
11	UF0890	#8-32 0.38_FHCS	2
12	FTG "L" 8MM TUBE	UPM3140	2
13	UPM3755	FILTER REG. MOUNTING BRKT.	1
14	UPM3179	ELBOW 3/8	1
15	UPM3267	FILTER REGULATOR G3/8	1
16	UF2025	RH PH 8-32 X 3	2
17	UPM3175	BRASS ELBOW	1
18	UPM0436	FTG Q.D. 3/8	1
19	UPM7879	8MM TUBE, BLUE	1

APPENDIX B - MACHINE PARTS LIST

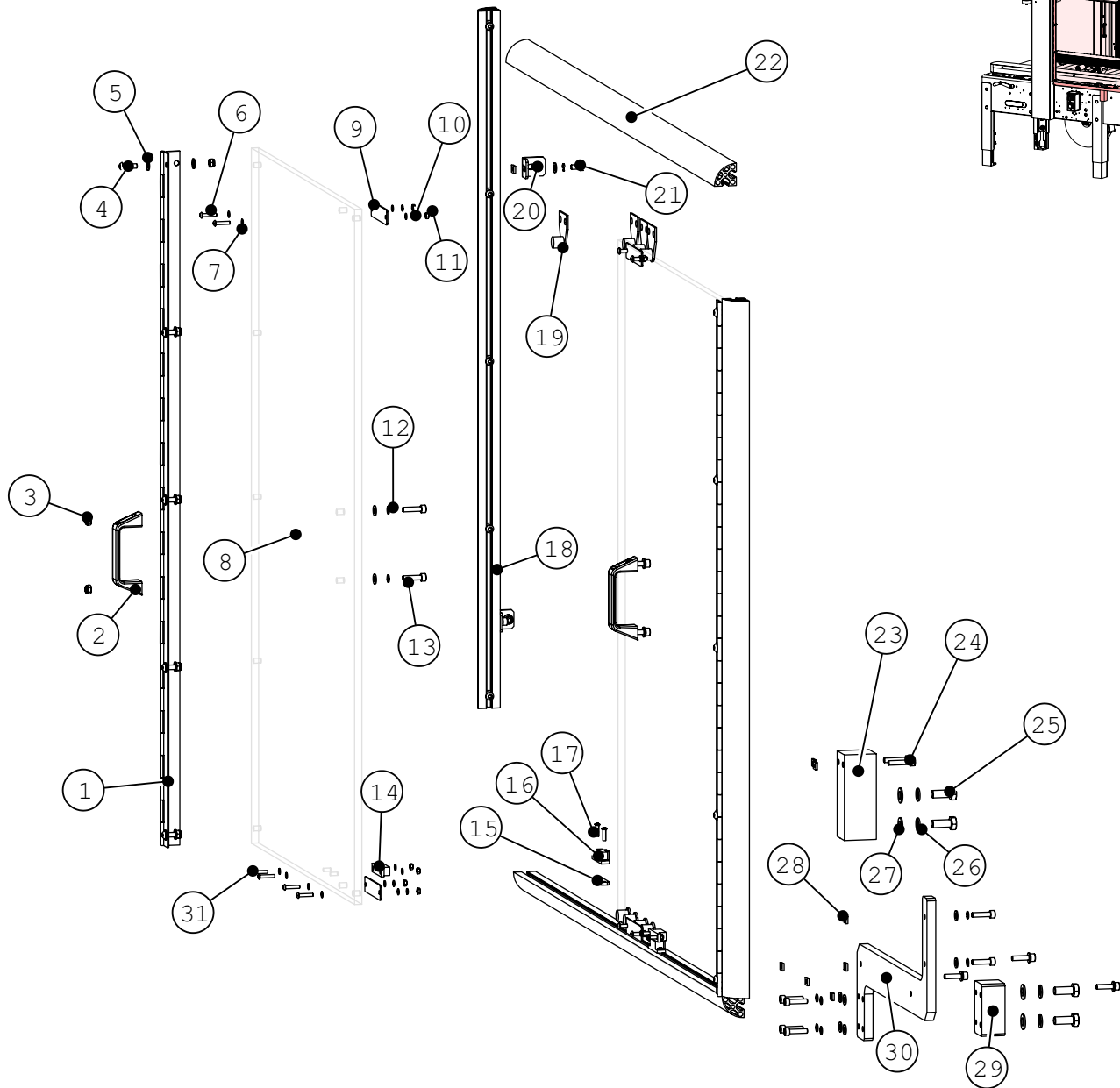
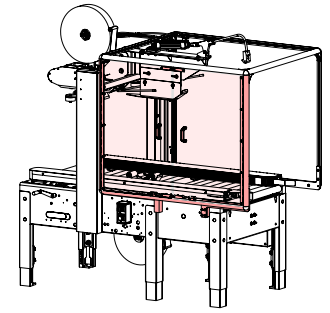
Guarding Corner Brackets



ITEM	PART NUMBER	DESCRIPTION	QTY
1	UF1250EV	M6-1 x 16 BHCS	52
2	UPM0614EV	CORNER BLOCK	8
3	UPM2922EV	CORNER CAP FINISHING	8
4	UF3778	DROP IN T-NUT M6	28
5	UPM4398EV	INSIDE CORNER	7

APPENDIX B - MACHINE PARTS LIST

Guarding Doors

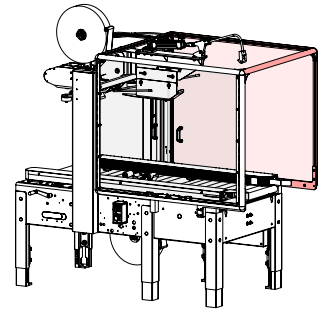
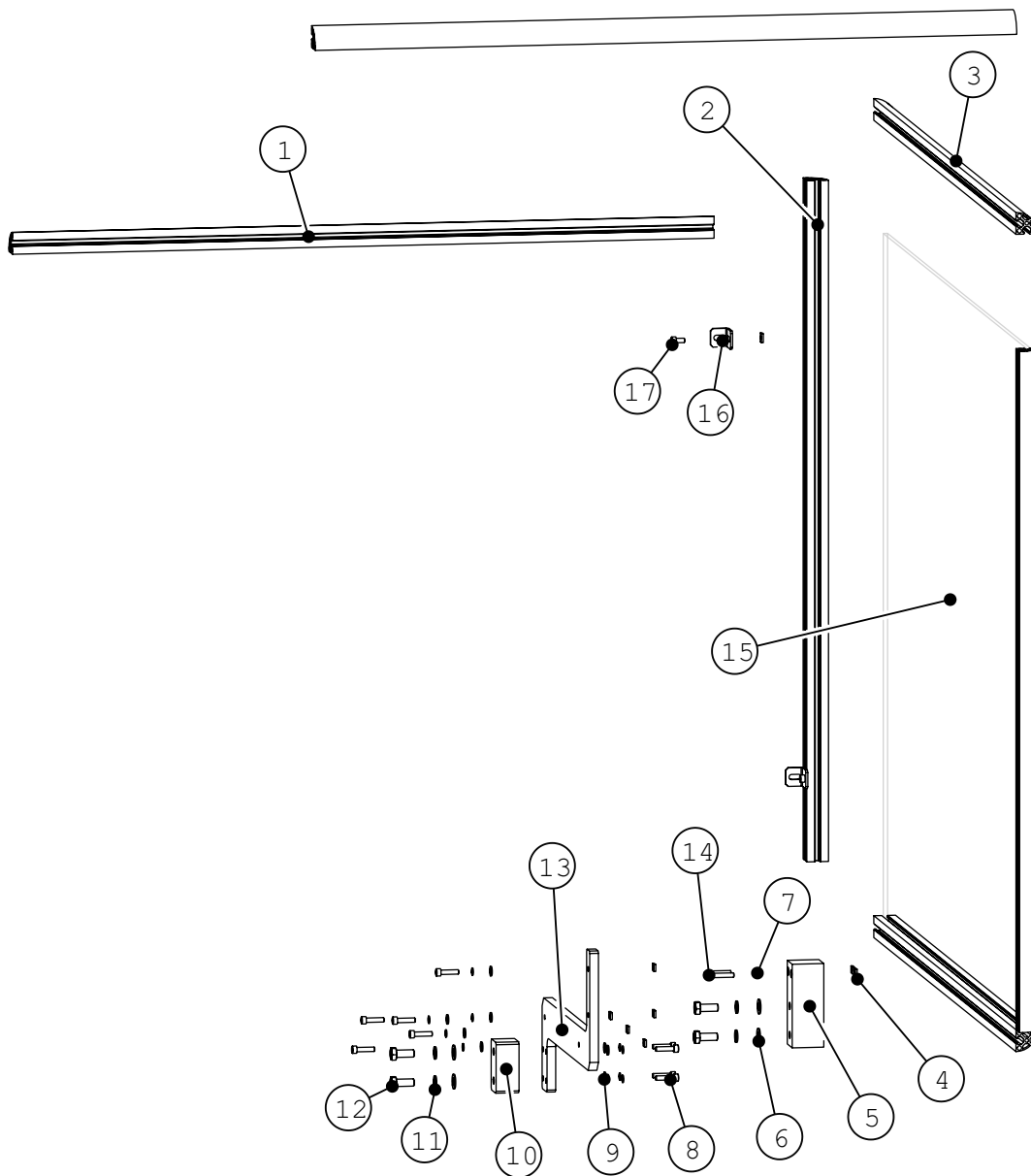


ITEM	PART NUMBER	DESCRIPTION	QTY
1	UPM6279	DOOR HINGE	2
2	UPM6281	DOOR GUARDING HANDLE	2
3	UF5900	M6-1.0 LOCK-NUT	16
4	UF1241EV	M6-1 x 20 BHCS	10
5	UF1828	M6 FW	37
6	UF4050EV	M4-0.7 x 20 BHCS	8
7	UF3710	M4 FW	25
8	UPM3861EV	M8039	2
9	UPM4400EV	MAGNET PLATE	4
10	UF3681	M4 LW	8
11	UF4237	M4-0.7 HNR	12
12	UF6363	M6 LW	14
13	UF0840	M6-1 x 25 SHCS	11
14	UPM4397EV	INTERLOCK, OMRON TYPE GLS-M1	2
15	UPM4453	OMRON INTERLOCK DOUBLE NUT	2
16	UPM4396EV	INTERLOCK, OMRON TYPE GLS-S1	2

ITEM	PART NUMBER	DESCRIPTION	QTY
17	UF4239	PHCS M4-0.7 x 15	4
18	UPM3864EV	VERTICAL EXTRUSION	2
19	UPM4399EV	MAGNET ASSY	8
20	UPM0732	FIXED GUARDING "L" BRACKET	2
21	UF0820	M6-1 x 12 SHCS	2
22	UPM3865EV	HORIZONTAL EXTRUSION	2
23	UPM4452	2nd SUPPORT MEMBER	1
24	UF4236	M6-1 x 30 SHCS	2
25	UF6382	M10-1.5 x 25 HHCS	4
26	UF6371	M10 LW	4
27	UF3680	M10 FW	4
28	UPM0687EV	DROP IN T-NUT M6	27
29	UPM3852EV	DOOR SUPPORT MEMBER	1
30	UPM3853EV	DOOR SUPPORT	1
31	UF4238	PHCS M4-0.7 x 20	4

APPENDIX B - MACHINE PARTS LIST

Guarding Panel Side



ITEM	PART NUMBER	DESCRIPTION	QTY
1	UPM4512EV	CROSS-OVER EXTRUSION	2
2	UPM3864EV	VERTICAL EXTRUSION	2
3	UPM3865EV	HORIZONTAL EXTRUSION	2
4	UPM0687EV	DROP IN T-NUT M6	9
5	UPM4452	2nd SUPPORT MEMBER	1
6	UF3680	M10 FW	4
7	UF6363	M6 LW	11
8	UF0840	M6-1 x 25 SHCS	9
9	UF1828	M6 FW	9

ITEM	PART NUMBER	DESCRIPTION	QTY
10	UPM3852EV	DOOR SUPPORT MEMBER	1
11	UF6371	M10 LW	4
12	UF6382	M10-1.5 x 25 HHCS	4
13	UPM3853EV	DOOR SUPPORT	1
14	UF4236	M6-1 x 30 SHCS	2
15	UPM3862EV	GUARDING PANEL	1
16	UPM0732	FIXED GUARDING "L" BRACKET	2
17	UF0820	M6-1 x 12 SHCS	2

USER NOTES
