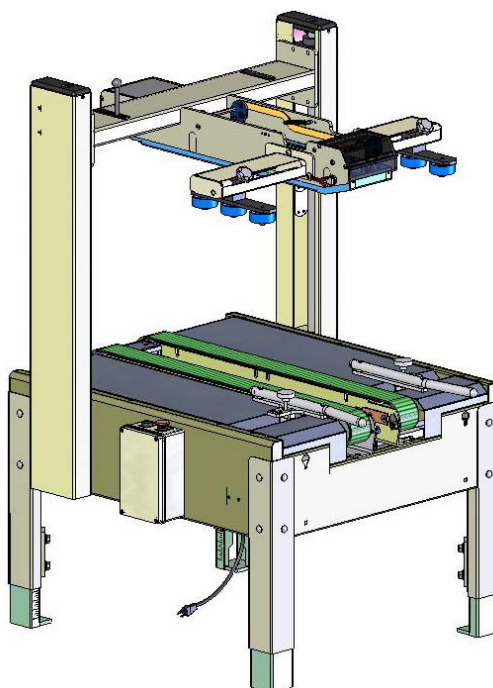




**USA 2324 BB
BOTTOM BELT DRIVE
CARTON SEALER
UM174TW / UM674TW
OPERATION MANUAL
&
PARTS LISTS**

UDM10000 Rev. 1



OPERATION MANUAL

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SERVICE INSTRUCTIONS

Service

This is the Intertape Model USA 2324 BB Carton Sealing Machine you ordered. It has been set up and tested in our factory with Intertape brand tapes. If any problems occur when operating this equipment and you desire a service call or phone consultation, call **Intertape Customer Service** at 1-800-972-4675.

Please provide the customer service representative with the Machine model number and serial number. If you have a technical question that does not require an immediate response, you may fax it to 1-813-621-9680.

Replacement Parts

Order parts by item number, part name and quantity required. Replacement parts are available from your Authorized Interpack Distributor. Should you require assistance selecting the correct part, you may call:

Intertape Polymer Group
Interpack Machinery Division
9940 Currie Davis Drive, Suite 23B
Tampa, FL, 33619

Tel: 1-800-972-4675
Fax: 1-813-621-9680

MODEL:

SERIAL NUMBER:

DATE OF PURCHASE:

WARRANTY

EQUIPMENT WARRANTY AND LIMITED REMEDY: The following warranty is made in lieu of all other warranties, express or implied, including, but not limited to, the implied warranty of merchantability, the implied warranty of fitness for a particular purpose, and any implied warranty arising out of a course of dealing, a custom or usage of trade: Intertape sells its Model USA 2324 BB Carton Sealing Machine with the following warranties:

1. The knife blades, springs and wipe down rollers will be free from all defects for a period of ninety (90) days. A lifetime warranty is available after delivery with an Annual Tape Agreement and completed Pioneering Protection Warranty form. Contact your Intertape representative for further details.
2. All other HSD2000 ET II Tape Head parts will be free from all defects for one (1) year after delivery.
3. The Gear Motor will be free from defects for one (1) year after delivery.
4. All other components will be free from all 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 failing due to inadequate cleaning, improper operating environment, improper utilities or operator error.

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.

DESCRIPTION OF MACHINE

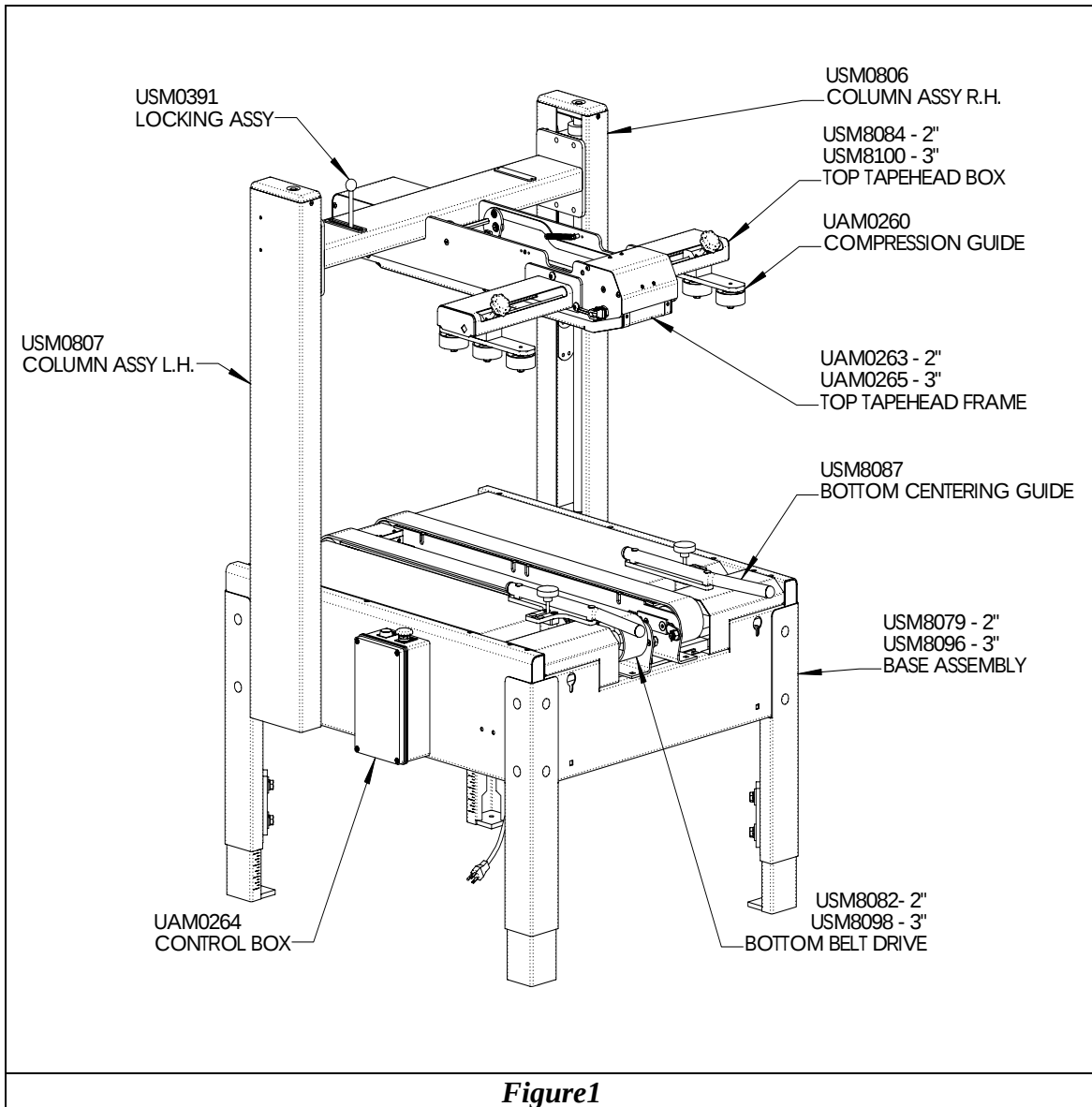


Figure1

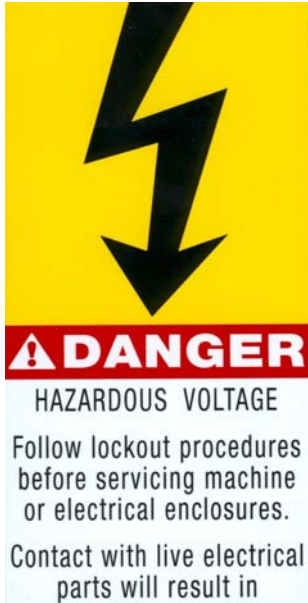
Description

The Intertape USA 2324 BB Bottom Belt Drive Carton Sealing Machine with HSD2000 ET II Tape Heads is designed to apply Intertape brand Pressure Sensitive carton sealing tape to the top and bottom center seam of Regular Slotted Containers (RSC). The USA 2324 BB is manually adjustable to a wide range of carton sizes.

IMPORTANT SAFEGUARDS

There is a number of safety labels used on Intertape Carton Sealers.

The illustrated label shown in Figure 2 is attached to the Knife Guard inside the upper and lower HSD2000 Tape Head. The label warns operators and service personnel of the very sharp knife used to cut the tape at the end of the tape application. The HSD2000 Tape Heads are equipped with a Knife guard that covers the blade. The Tape Heads should never be operated with the blade guards removed. Turn air and electrical supplies off before servicing the tape heads.	 A warning label with a black exclamation mark icon inside a triangle, followed by the word "WARNING" in large, bold, black capital letters. Below this, the text "Sharp Cutting Blade" is written in a large, black, sans-serif font on a light blue background.
<i>Figure 2</i>	

The label shown in figure 3 is attached to the control box next to the on/off switch. The label warns the service personnel to unplug the power supply before attempting any service work on the carton sealer.	 A danger label featuring a large black lightning bolt icon pointing downwards on a yellow background. Below the icon, the word "DANGER" is written in white capital letters on a red background. Underneath, the text "HAZARDOUS VOLTAGE" is written in black capital letters. At the bottom, two lines of text in a smaller black font read: "Follow lockout procedures before servicing machine or electrical enclosures." and "Contact with live electrical parts will result in".
<i>Figure 3</i>	

The illustrated label shown in Figure 4 is located on the “In feed” end of the right hand drive belt. The label warns the operators and service personnel of the pinch point at the in feed ends of the drive base.



Figure 4

The illustrated label shown in Figure 5 is located on the exit end of the drive base it warns the operators and service personnel of the pinch points at the exit ends of the drive belts.

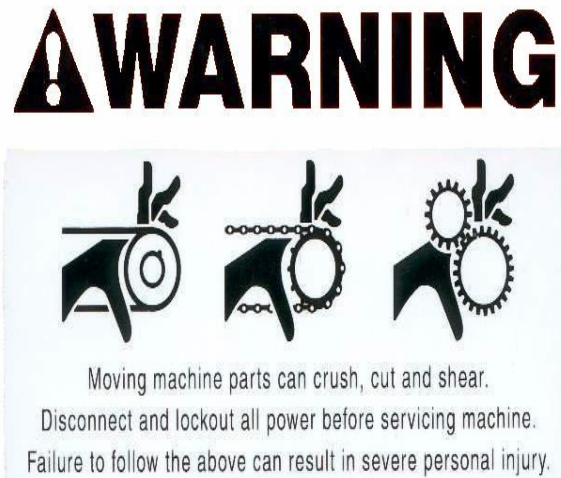


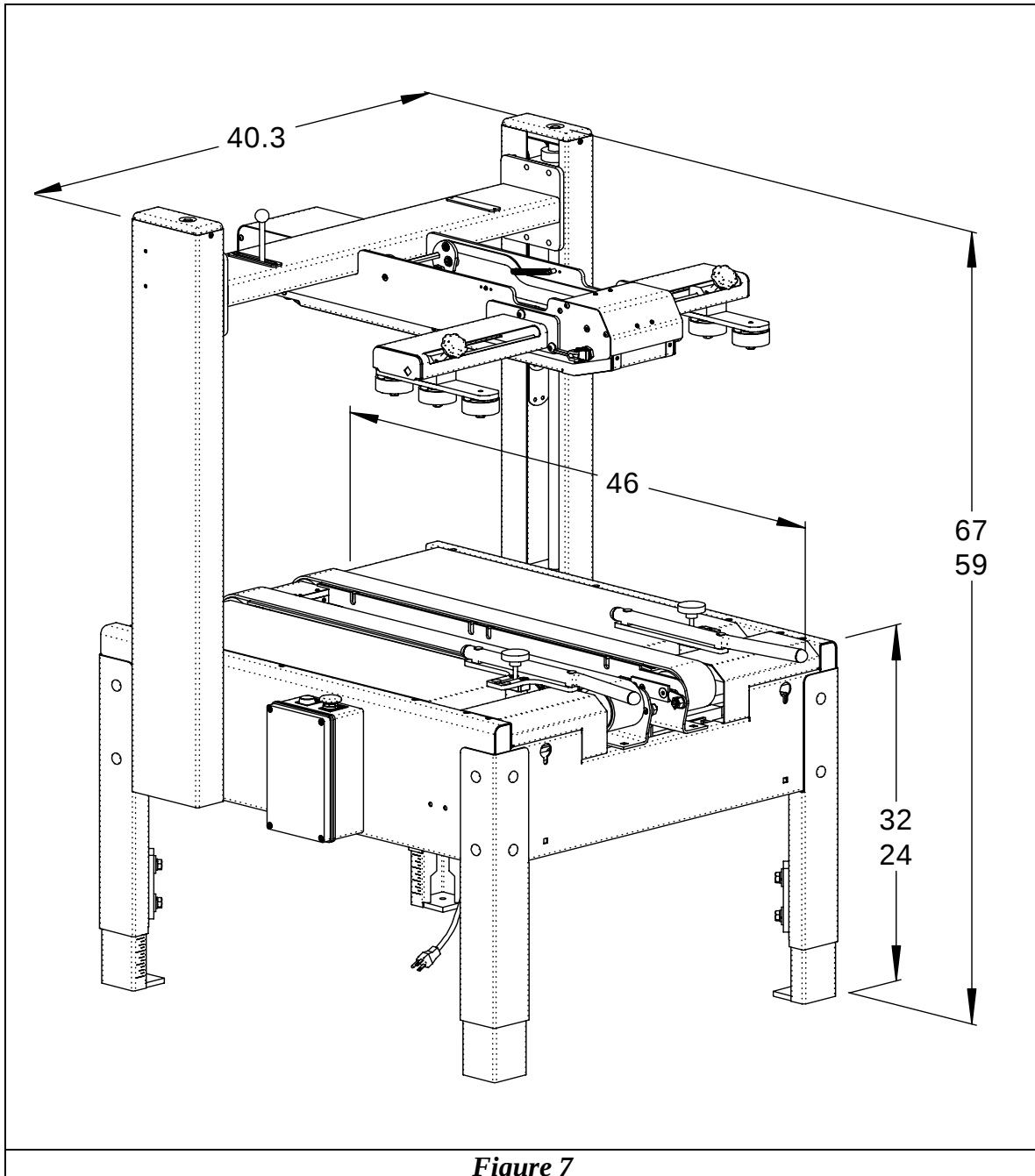
Figure 5

The illustrated label shown in Figure 6 is located on the side of the column. This label provides convenient safety instruction for the operator and service personnel in the operation of the Intertape Carton Sealing Equipment.	⚠ WARNING OPERATION / SERVICE • Only trained people are to operate and service machine. • Shut off power to machine before adjusting. • Unplug electrical power before servicing. MACHINE MANUAL For other important safety, operating and service information read this machine's manual. EYE HAZARD Wear Safety Glasses which conform to ANSI Std. Z87.1 or EN 166  COVERS AND GUARDS All covers and guards must be in place before operating machine. ELECTRICAL SHOCK Hazardous voltages may cause personal injury. Only authorized and qualified personnel are to service electrical enclosures.  FAILURE TO FOLLOW THE ABOVE COULD RESULT IN SEVERE INJURY.
Figure 6	

Note: Should any of the safety labels placed on the Machine be damaged or destroyed, replacements are available.

SPECIFICATIONS

Machine Dimensions



Machine Weight

500 lbs (225 kg).

Power Requirements

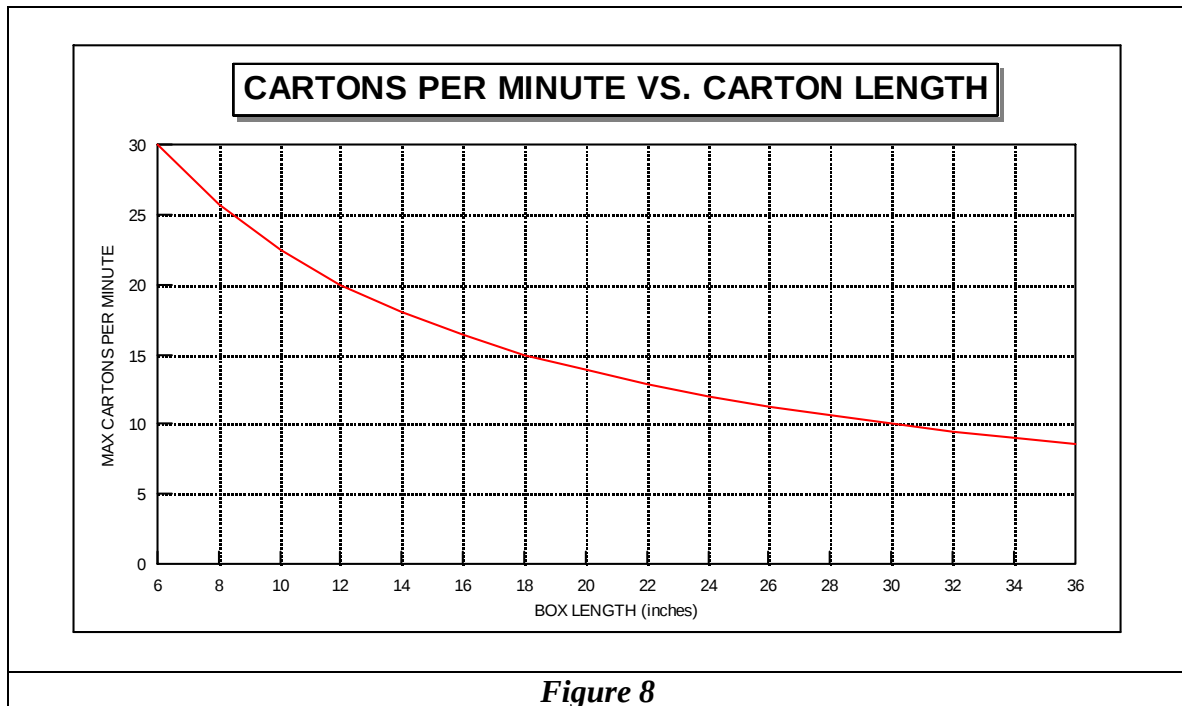
Electrical - 115 VAC, 60 HZ, 7.6 A (400 Watts)

This machine comes standard with one 1/2 HP gear motor and an electrical box.

The electrical box contains a Start switch, the Emergency Stop switch, and a Starting Relay with a thermal over load and can be located on either side of the carton sealer for customer convenience (specify with order). A six (6) foot standard three conductor power cord with plug is provided for **115V, 60HZ, 15 Amp** service. The receptacle providing this service must be properly grounded. Before the machine is plugged into the receptacle, ensure that the switch is **OFF** and all materials are removed from the machine.

Operating Speed

Actual production rate is dependent on operator's dexterity and the case size mix. Boxes must be 6 inches apart.



Operating Conditions

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

Note: Machine should not be washed down or subjected to conditions causing condensation on components.

Tape Specifications

Use **Intertape Brand** Pressure Sensitive Carton Sealing Tape.

The machine can accommodate 2 (48mm) or 3 inch (75mm) wide tape, depending on tape head supplied.

A maximum tape roll diameter of 16 inches (405 mm) on a 3-inch (76.2 mm) diameter core can be installed on the tape head. (Accommodates all Intertape brand film tape machine roll lengths).

The standard Application Leg Length of 2.5 inches (+0.25", -0") (63.5 mm, +6.3 mm, -0 mm) is the factory set length. The tape head can be adjusted to an optional length of 2 inches (+0.25", -0") (50.8 mm, +6.3 mm, -0 mm). Refer to the Tape Head manual for adjustment of tape application leg length.

Note: For further specifications on the tape heads consult the tape head manual for your specific tape head.

Carton Specifications

Type

Regular Slotted Containers (RSC)

Material

125 to 275 PSI bursting test, single or double wall B or C flutes.

Weight

5 to 85 lbs. (2.5 to 38.5 kg)

Size

Carton Size	Length	Width	Height
Minimum	6"	6" Optional 9"	2½"
Maximum	Infinite	23" Optional 26"	24"

The carton sealer can accommodate most cartons within the size ranges listed above. However, if the box length (in direction of seal) to box height ratio is .75 or less, than several boxes should be test run to assure proper machine performance. The formula is as follows;

$$\frac{\text{CARTON LENGTH IN DIRECTION OF SEAL}}{\text{CARTON HEIGHT}} > .75$$

Note: If USA 2324 BB has 3" tape heads the minimum width is 7"

SET-UP PROCEDURE

Receiving and Handling

The machine is shipped to the customer in a box and fixed to a pallet.

- Remove the strapping and the staples at the bottom of the box.
- Lift off the box cover and sleeve.
- Remove the mounting bolts and nuts, which secure the USA 2324-BB to the shipping pallet.
- Lift the machine off the pallet and install it in your packaging line.
- Remove all tie wraps and other shipping materials.

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

Set-Up

The Carton Sealer must be installed on a near level ground. Use the adjustable legs to ensure that the machine is level and firmly on the ground (no rocking). Adjust the leg height with the four (4) telescopic adjustment legs to accommodate conveyor heights from 24 to 30 inches.

To adjust the Carton Sealer height, jack up the machine to give ample room to extend the legs. Using a 3/4" (19 mm) box end wrench, loosen the eight (8) 1/2" hex head bolts. Adjust the legs to the desired conveyor height and tighten the bolts. Etched lines on the legs ease leveling.

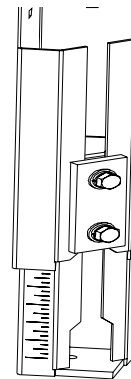
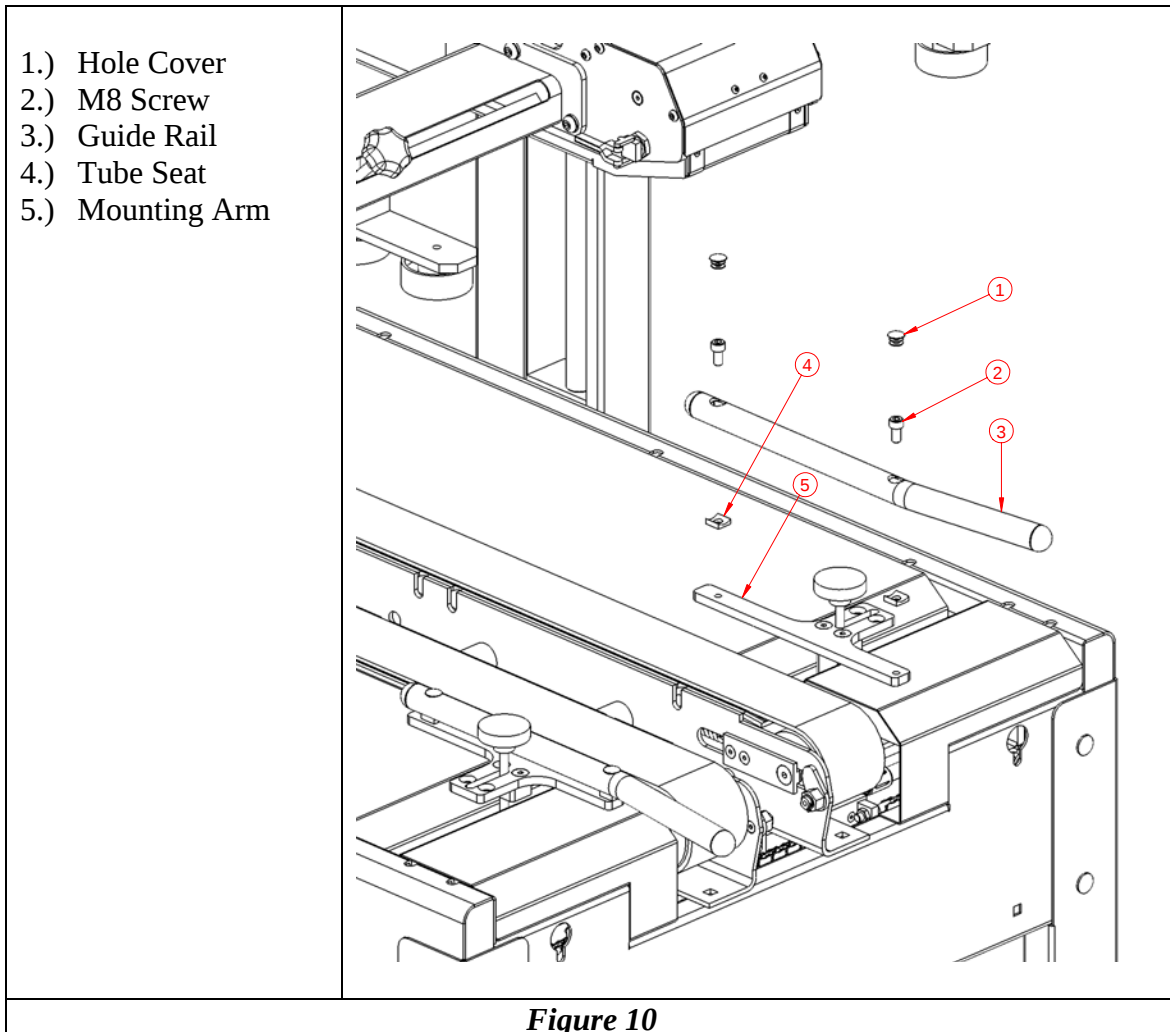


Figure 9

Customer supplied feed conveyor (if used) should provide straight and level entry into the carton sealer. Customer supplied exit conveyor (if used) should be straight and declined no more than 1/4"/foot away from the machine to convey the sealed cartons away from the machine.

To avoid shipping damage, we have removed the bottom centering rails from the machine. You will find them on the pallet wrapped separately. Please install them with the included screws as shown in figure 10.



Plug the power cord into an appropriate receptacle.

OPERATING INSTRUCTIONS

Once the Tape Heads, (both bottom and top) have been loaded with tape and threaded (refer to the appropriate Tape Head manual for loading and threading instructions) the machine is ready to process RSC cartons. The following instructions are presented in **the order recommended** for processing cartons successfully through the USA 2324 BB Carton Sealing machine.

- 1- Loosen the Arching Side Guide locking handle and open the Arching Side Guides completely (Push to outside of machine).
- 2- Loosen locking handle on the Top Tape Head Assembly and raise it until it clears the new carton.
- 3- Place a new carton between the Side Guides under the Top Tape Head Assembly, and close against carton under moderate pressure. (DO NOT CRUSH CARTON)
- 4- Lower the Top Tape Head Assembly until it rests on the carton and tighten the locking handle.
- 5- Loosen the Top Compression Guides locking handles (x2) and close against the carton enough to keep the slot in the center closed while taping and tighten the locking handles to secure the guides against the carton.
- 6- Remove the carton.
- 7- Check to insure all personal are clear.
- 8- Release the E-stop switch and start the machine with the green start button.
- 9- Feed the closed carton to the machine.

WARNING: Ensure that the operator's hands are away from the contact area between the Top Tape Head Box and the carton.

The top tape head in the top tape head can float in a lockable carriage (Figure 11). This carriage can be unlocked for overstuffed cartons or locked to apply more pressure against the belts as needed for the application.

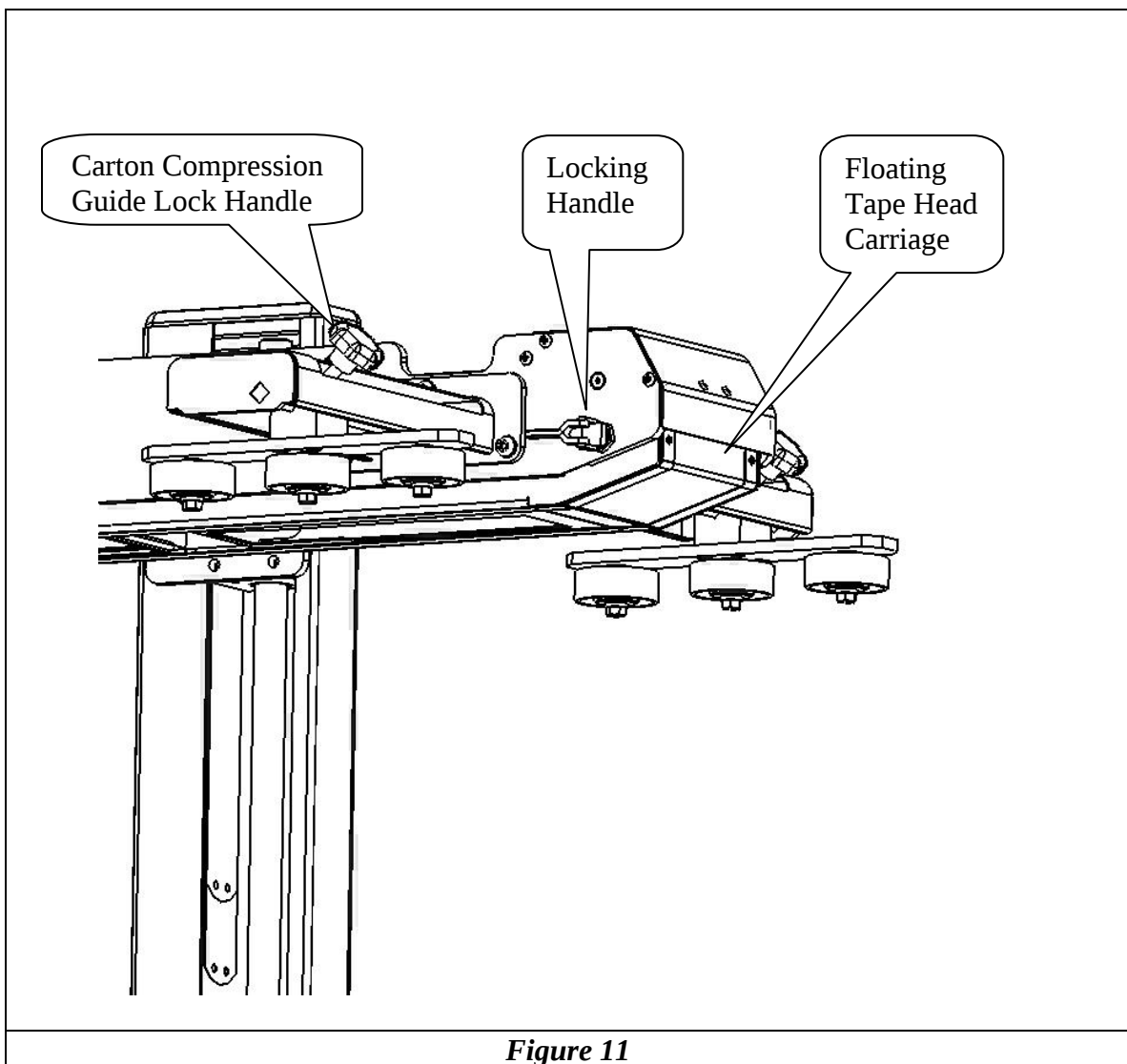


Figure 11

MAINTENANCE

The USA 2324-BB carton sealer has been designed for trouble-free service. The machine will perform best when it receives routine cleaning and maintenance.

Warning! Turn off electrical power and lock out the electrical supply before beginning 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 silicon based dry film lubricant. This won't 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

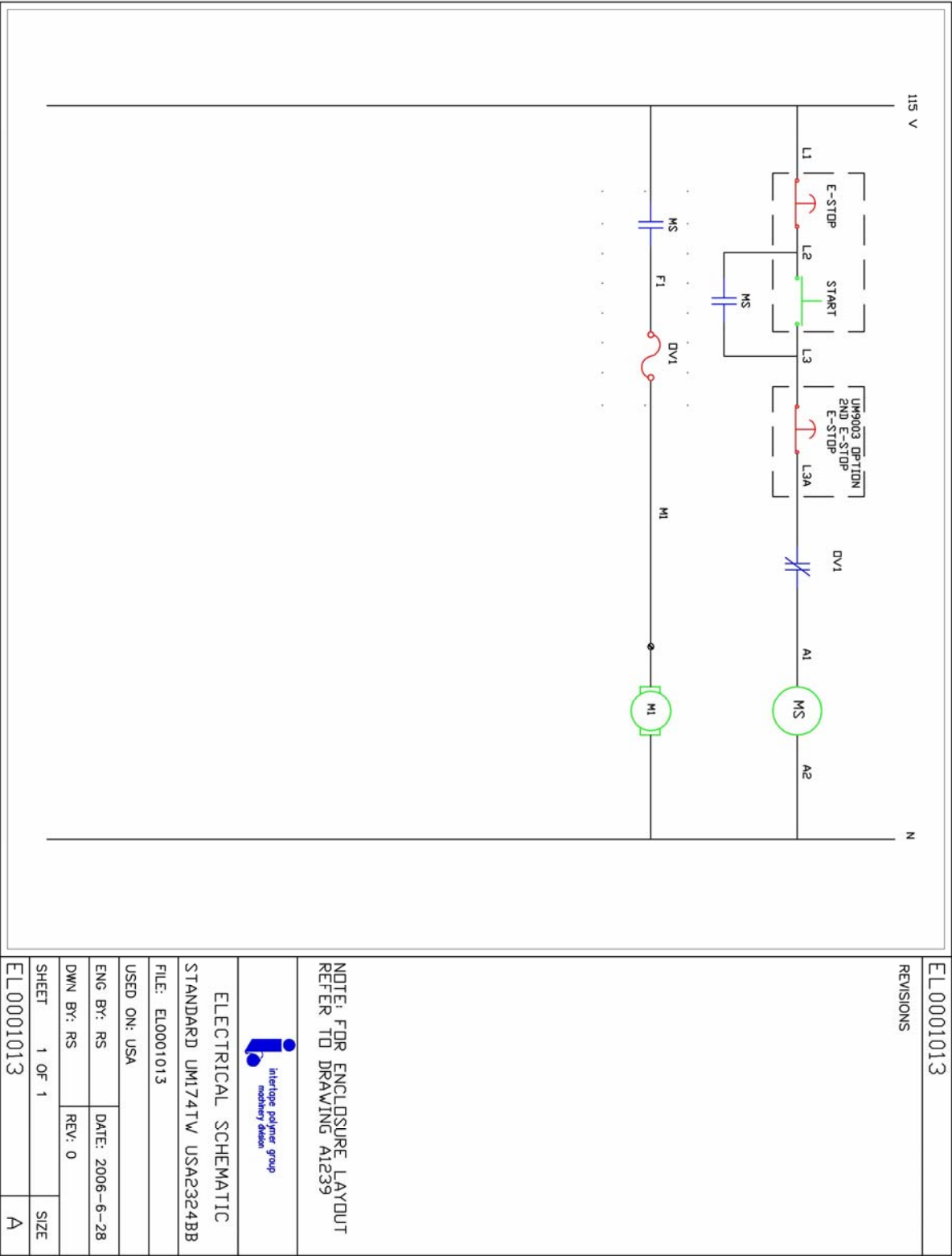
Cartons produce a sizable amount of dust and paper chips when processed or handled. If this dust is allowed to build up in the machine, it may cause component wear and overheating of motors. Remove the accumulated dust with a shop vacuum. Avoid using compressed air to remove the dust as this may cause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

TROUBLESHOOTING

Interpack Machinery Carton Sealers are fabricated with high quality components that provide trouble-free operation for a long period of time. However, if a problem should occur we recommend that you always look for simple things first, then more complex problems. This is exactly how this table is constructed, as the numbers increase, complexity increases.

TROUBLE	POSSIBLE CAUSES	SOLUTIONS
The machine is turned on and nothing happens	1- The starter overload or the circuit breaker is tripped. 2- Machine is unplugged	1- Wait a few minutes for the thermal overload to reset or reset circuit breaker. Check proper amperage and voltage at power connection.
The Top Tape Head Box marks the cartons.	1- The Top Tape Head Box Assembly is too low.	1- Adjust the height of the Top Tape Head Box Assembly.
The Drive Belts are sliding on the carton.	1- The pressure between the Top Tape Head Box and the carton is not sufficient.	1- Lower the Top Tape Head Box onto the carton.
The cartons are not taped properly.	1- The tape head is not adjusted correctly	1- Refer to the Tape Head manual.

Electrical Drawing



RECOMMENDED SPARE PARTS

DESCRIPTION	ITEM NUMBER	RECOMMENDED QTY.
BEARING PULLEY	UPM0324	2
DIE SPRING (DRIVE BASE)	UPM0038	2
BELT, DRV SAG12E 3"X 84.113"	UPM7468	2
MOTOR, LI-MING 1/2HP 1:20	UPM7516	1
FLANGED BEARING 3/4 ID	UPM0339	2
BALL BEARING 14 mm SHAFT	UPM7486	4
FLANGED COPPER BUSHING	UPM1781EV	2
CONSTANT FORCE SPRING 33LBS	UPM0740	2
LINEAR BEARING 25 mm	UPM0739EV	2
PIVOT EXTENSION SPRING	UPM1042	2
BEARING, PERMAGLIDE 12 x 10	UPH0089EV	1
BEARING PERMAGLIDE 10 x 6	UPH1095EV	2
STOP, KNIFE ARM, 15/16"D.URETH.	UPH133	3

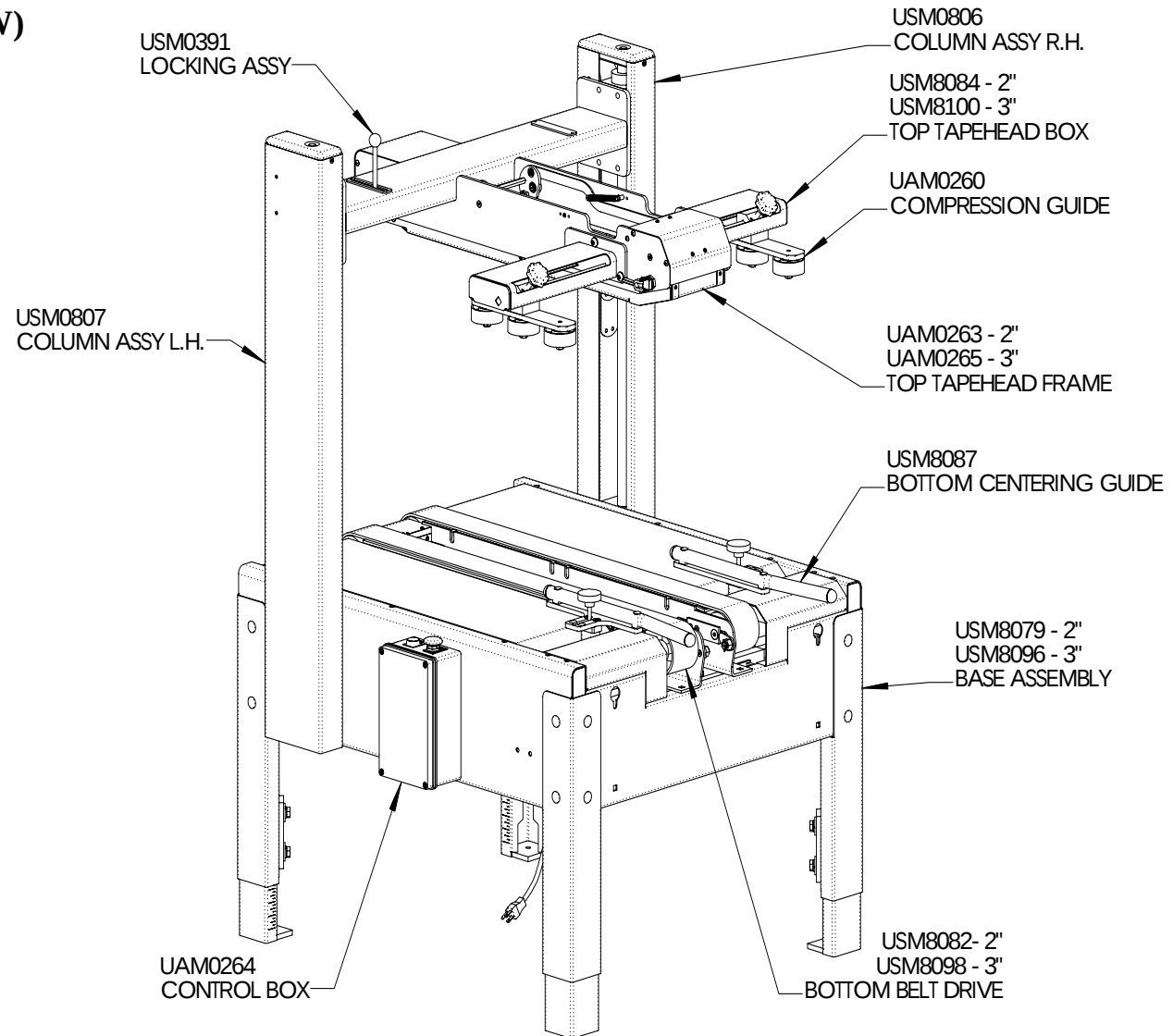
OPTIONAL EQUIPMENT

Model Number	Description	Item Number	Quantity Per Machine
USA 2324 BB	Feed/Exit Table 16" (.4 M)	UM894T	1 or 2
	Feed/Exit Table 24" (.6 M)	UM998T	1 or 2
	Feed/Exit Table 36" (.9 M)	UM898T	1 or 2
	Heavy Duty Casters	UM841	1 set of 4
	Secondary E-Stop	UM9003	1
	Carton Hold Down Device	UM897	1

PARTS LISTS

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SECOND E-STOP INSTALLED	50

COMPLETE ASSEMBLY (UM174TW / UM674TW)



This exploded view diagram illustrates the assembly of a metal frame. The components are numbered as follows:

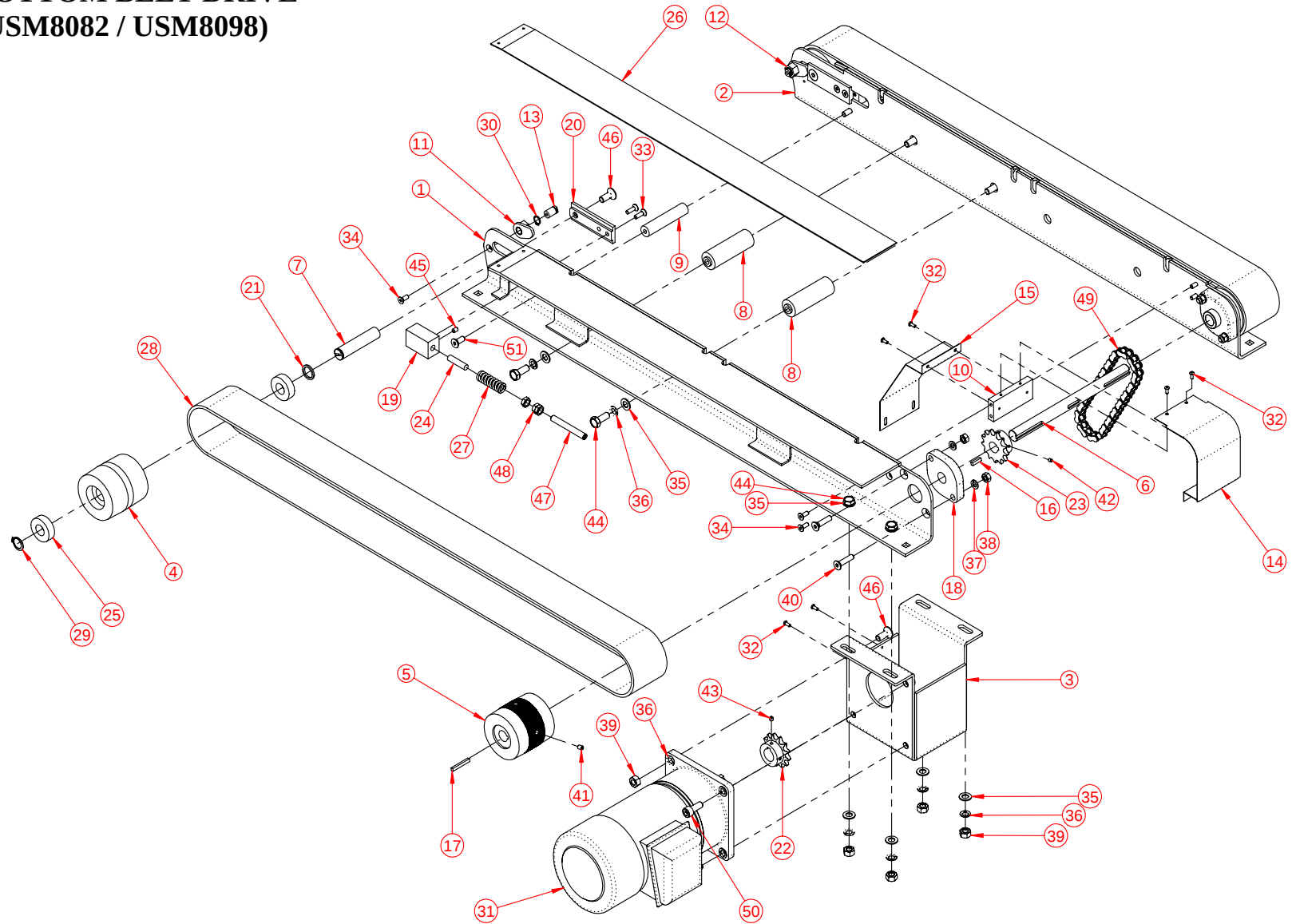
- 1**: Main horizontal frame rail.
- 2**: Vertical support rail.
- 3**: Vertical support rail (bottom section).
- 4**: Vertical support rail (top section).
- 5**: L-shaped corner bracket.
- 6**: L-shaped corner bracket.
- 7**: Horizontal support rail.
- 8**: Horizontal support rail.
- 9**: Small vertical bracket.
- 10**: Small vertical bracket.
- 11**: Small vertical bracket.
- 12**: Small vertical bracket.
- 13**: Small vertical bracket.
- 14**: Small vertical bracket.
- 15**: Small vertical bracket.
- 16**: Small vertical bracket.
- 17**: Small vertical bracket.
- 18**: Small vertical bracket.

BASE ASSEMBLY
(USM8079 / USM8096)

ITEM	PART #	DESCRIPTION	USM8079 2"/QTY.
1	UPM7394	BASE FRAME	1
2	UPM0602	LEG BASE ASSY	4
3	UPM0847	LEG ADJUSTMENT	4
4	UPM0931EV	LEG FRICTION PLATE	4
5	UPM7406	FRONT COVER	1
6	UPM7407	FRONT COVER - LH	1
7	UPM7409	REAR COVER	1
8	UPM7408	REAR COVER - LH	1
9	UF3637	HNR M6-1.0	10
10	UF6363	LW 6MM	10
11	UF0820	SHCS M6-1 X 12mm	10
12	UF6392	CARRIAGE BOLT M10-1.5 x 25	16
13	UF3680	SS FW M10	16
14	UF6371	L.W. M10	16
15	UF6314	HNR M10 x 1.5	16
16	UF6393	HHCS M12-1.75 x 35	8
17	UF6395	L.W. ZINC M12	8
18	UF6394	F.W. ZINC M12	8

ITEM	PART #	DESCRIPTION	USM8096 3"/QTY.
1	UPM7394	BASE FRAME	1
2	UPM0602	LEG BASE ASSY	4
3	UPM0847	LEG ADJUSTMENT	4
4	UPM0931EV	LEG FRICTION PLATE	4
5	UPM7545	FRONT COVER	1
6	UPM7544	FRONT COVER - LH	1
7	UPM7542	REAR COVER	1
8	UPM7543	REAR COVER - LH	1
9	UF3637	HNR M6-1.0	10
10	UF6363	LW 6MM	10
11	UF0820	SHCS M6-1 X 12mm	10
12	UF6392	CARRIAGE BOLT M10-1.5 x 25	16
13	UF3680	SS FW M10	16
14	UF6371	L.W. M10	16
15	UF6314	HNR M10 x 1.5	16
16	UF6393	HHCS M12-1.75 x 35	8
17	UF6395	L.W. ZINC M12	8
18	UF6394	F.W. ZINC M12	8

BOTTOM BELT DRIVE (USM8082 / USM8098)

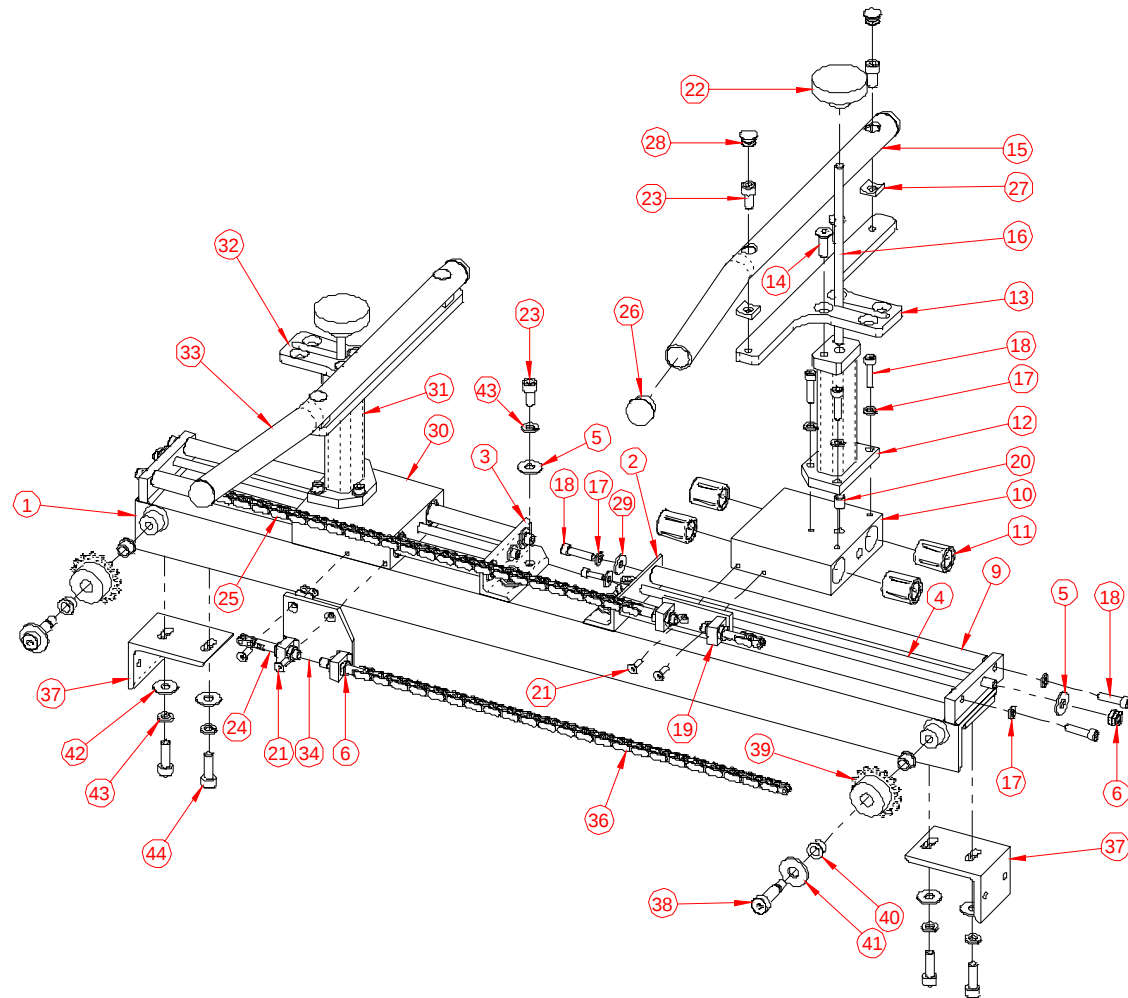


BOTTOM BELT DRIVE (USM8082 / USM8098)

ITEM	PART #	DESCRIPTION	USM8082 2" /QTY.	USM8098 3" /QTY.
1	UPM4066	FRAME RH DRIVE	1	1
2	UPM4067	FRAME LH DRIVE	1	1
3	UPM4068	MOTOR MOUNT, BRACKET 2"V	1	-
3	UPM7546	MOTOR MOUNT, BRACKET 3"V	-	1
4	UPM4070	IDLER PULLEY	2	2
5	UPM4069	DRIVE PULLEY	2	2
6	UPM4071	DRIVE SHAFT	1	1
7	UPM4072	IDLER SHAFT	2	2
8	UPM4073	SPACER, DRIVE 2"	2	-
8	UPM7552	SPACER, DRIVE 3"	-	2
9	UPM4074	SPACER 2" DRIVE 19 DIA	1	-
9	UPM7554	SPACER 3" DRIVE 19 DIA	-	1
10	UPM4075	SPACER BAR	1	-
10	UPM7550	SPACER BAR	-	1
11	UPM4076	SPRING COMP TOOL R.H.	1	1
12	UPM4077	SPRING COMP TOOL L.H.	1	1
13	UPM4078	SHAFT	2	2
14	UPM4079	BACK CHAIN GUARD	1	-
14	UPM7549	BACK CHAIN GUARD	-	1
15	UPM4080	FRONT CHAIN GUARD	1	-
15	UPM7548	FRONT CHAIN GUARD	-	1
16	UF2210	SQUARE KEY, ZINC .188 x .188 x .75	1	1
17	UF6358	SQUARE KEY, ZINC .188 x .188 x 1.5	2	2
18	UPM0339	FLANGE BEARING 3/4" ID (BBD)	2	2
19	UPM0101EV	TENSIONNER SPRING HOLDER	2	2
20	UPM1879EV	TENSIONNER SLIDE	2	2
21	UPM0109	IDLER PULLEY SPACER	2	2
22	UPM7517	40B12 22MM B - 7MM KEY	1	1
23	UPM7519	#40B-12T 3/4 BORE - 3/16KEY	1	1

ITEM	PART #	DESCRIPTION	USM8082 2" /QTY.	USM8098 3" /QTY.
24	UPM0112	SPRING LOCATOR PIN	2	2
25	UPM0324EV	BEARING, PULLEY	4	4
26	UPM7467	STRIP,UHMW,3"x.03	2	2
27	UPM0038	DIE SPRING - LHL-750B-5	2	2
28	UPM7468	BELT,DRV SAG12E 3"x84.11"	2	2
29	UF2220	EXT RET'G RING 3/4 SHAFT	2	2
30	UF2170	1/2" RETAINING RING	2	2
31	UPM7516	MOTOR, LI-MING 1/2HP 1/20RAT	1	1
32	UF6365	BHCS M4 x 0.7 x 10MM	6	6
33	UF5402	FHCS M6 - 1 x 20	4	4
34	UF1192	FHCS M6-1 x 16 mm	6	6
35	UF3680	SS FW M10	12	12
36	UF6371	L.W. M10	12	12
37	UF0867	LW M8	4	4
38	UF0866	M8-1.25 HNR	4	4
39	UF6314	HNR M10 x 1.5	5	5
40	UF6311	FHCS M8-1.25 x 35	4	4
41	UF1355	SSS 1/4-28 X 3/8	2	2
42	UF1320	SSS 10-32 X 1/4	2	2
43	UF1411	SSS M6 X 6MM	2	2
44	UF6382	HHCS M10-1.5 x 25MM	8	8
45	UF1340	SSS 1/4-20 X 3/8	2	2
46	UF1191	FHCS M10 x 25	3	3
47	UF1400	SSS HK 3/8-16 X 3	2	2
48	UF1610	HNJ 3/8-16	6	6
49	UPM0068	CHAIN #40-45 PITCH (BBD)	1	1
50	UF0868	SHCS M10-1.5 x 25	3	3
51	UF1190	FHCS HK M8-1.25 X 20	2	2

BOTTOM CENTERING GUIDES (USM8087)

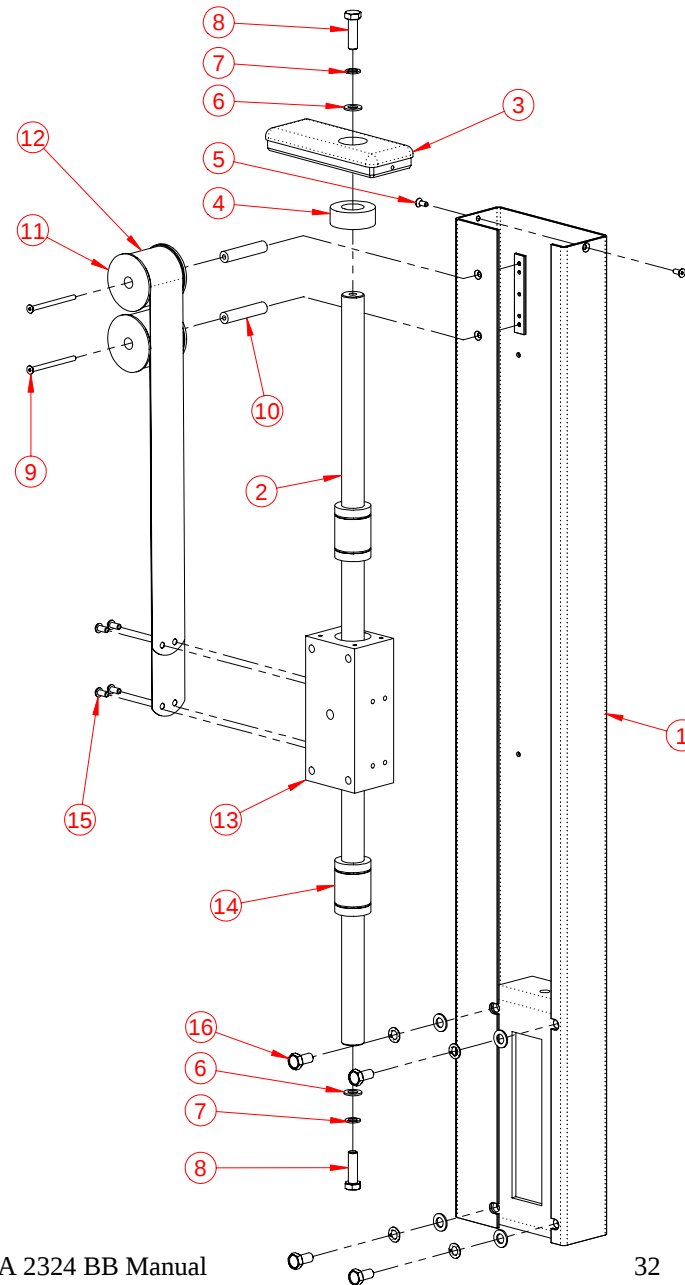


BOTTOM CENTERING GUIDES (USM8087)

ITEM	PART #	DESCRIPTION	QTY.
1	UPM4053	COMPRESSION GUIDE FRAME	1
2	UPM4057	SHAFT SUPPORT R.H.	1
3	UPM4062	SHAFT SUPPORT L.H.	1
4	UPM7479	BAR	2
5	UF3644	FW M8	6
6	UF6369	HEX JAM NUT M8 - 1.25	12
7	UF1827	FW M5	2
8	UF3148	SHCS M5 - 0.8 x 16	2
9	UPM7478	SHAFT	4
10	UPM4054	BEARING HOUSING R.H.	1
11	UPM7486	LINEAR BALL BEARING 16 mm I.D.	8
12	UPM7480	BRACKET R.H.	1
13	UPM4058	BOX GUIDE R.H.	1
14	UF6370	M8 - 1.25 x 25 FHCS	4
15	UPM4060	GUIDE ADAPTER R.H.	1
16	UPM4065	LOCKING SCREW	2
45	UF6363	LW 6MM	14
18	UF0840	M6-1 X 25MM SHCS	14
19	UPM7476	CHAIN BRACKET WITH TAKE-UP	1
20	UPM7475	LOCK, GUIDE	2
46	UF5404	FHCS M5 - 0.8 x 16 mm	4
22	UPM4083	FLUTED KNOB	2

ITEM	PART #	DESCRIPTION	QTY.
23	UF6367	SHCS M8-1.25 x 16	8
24	UPM7183	TAKE-UP SCREW	4
25	UPM7485	ANSI CHAIN #35, 84 LINK W. CONN.	1
26	UPM7482	TUBE PLUG	4
27	UPM7521	CONCAVE SEAT	4
28	UPM7523	HOLE COVER CAP	4
29	UF1828	FW 6 mm	4
30	UPM4055	BEARING HOUSING L.H.	1
31	UPM7481	BRACKET L.H.	1
32	UPM4059	BOX GUIDE L.H.	1
33	UPM4061	GUIDE ADAPTER L.H.	1
34	UPM7477	CHAIN BRACKET WITH TAKE UP	1
36	UPM7484	ANSI CHAIN #35 80 LINK W. CONN.	1
37	UPM4064	MOUNTING ANGLE	2
38	UF6368	SHOULDER SCREW M10 x 25	2
39	UPM4084	SPROCKET # 35 B 15	2
40	UPM1781EV	FLANGED BUSHING 10 x 10	4
47	UF6394	F.W. ZINC M12	2
42	UF1710	REG F.W. M8	4
43	UF0867	LW M8	8
44	UF0865	SHCS BB M8-1 X 25MM	4

COLUMN RIGHT HAND (USM0806)



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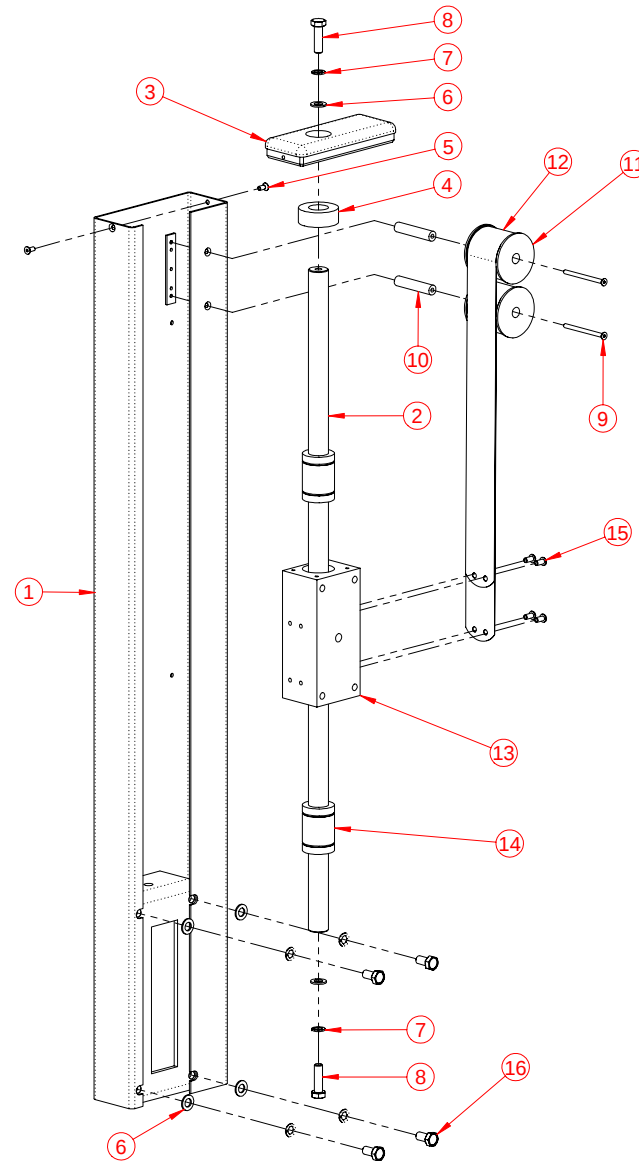
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**COLUMN RIGHT HAND
(USM0806)**

ITEM	PART #	DESCRIPTION	QTY.
1	UPM9713	COLUMN 24 RIGHT METRIC	1
2	UPM0738EV	COLUMN SHAFT	1
3	UPM2182EV	COLUMN CAP RIGHT HAND	1
4	UPM2251	RUBBER BUMPER	1
5	UF5400	FHCS M5-0.8 x 12 mm	2
6	UF3680	SS FW M10	6
7	UF6371	L.W. M10	6
8	UF0301	HHCS M10-1.5 x 35	2
9	UF1157	FHCS M5-0.8 x 70	2
10	UPM0743EV	SPRING MANDREL SHAFT	2
11	UPM0742	SPRING SPOOL	2
12	UPM0740	CONSTANT FORCE SPRING	2
13	UPM9651	COLUMN BLOCK 40 mm BORE	1
14	UPM0739EV	LINEAR BEARING DIA 25 mm	2
15	UF1195	BHCS M6-1 x 12 mm	4
16	UF0457	HHCS M10-1.25 x 20 mm	4

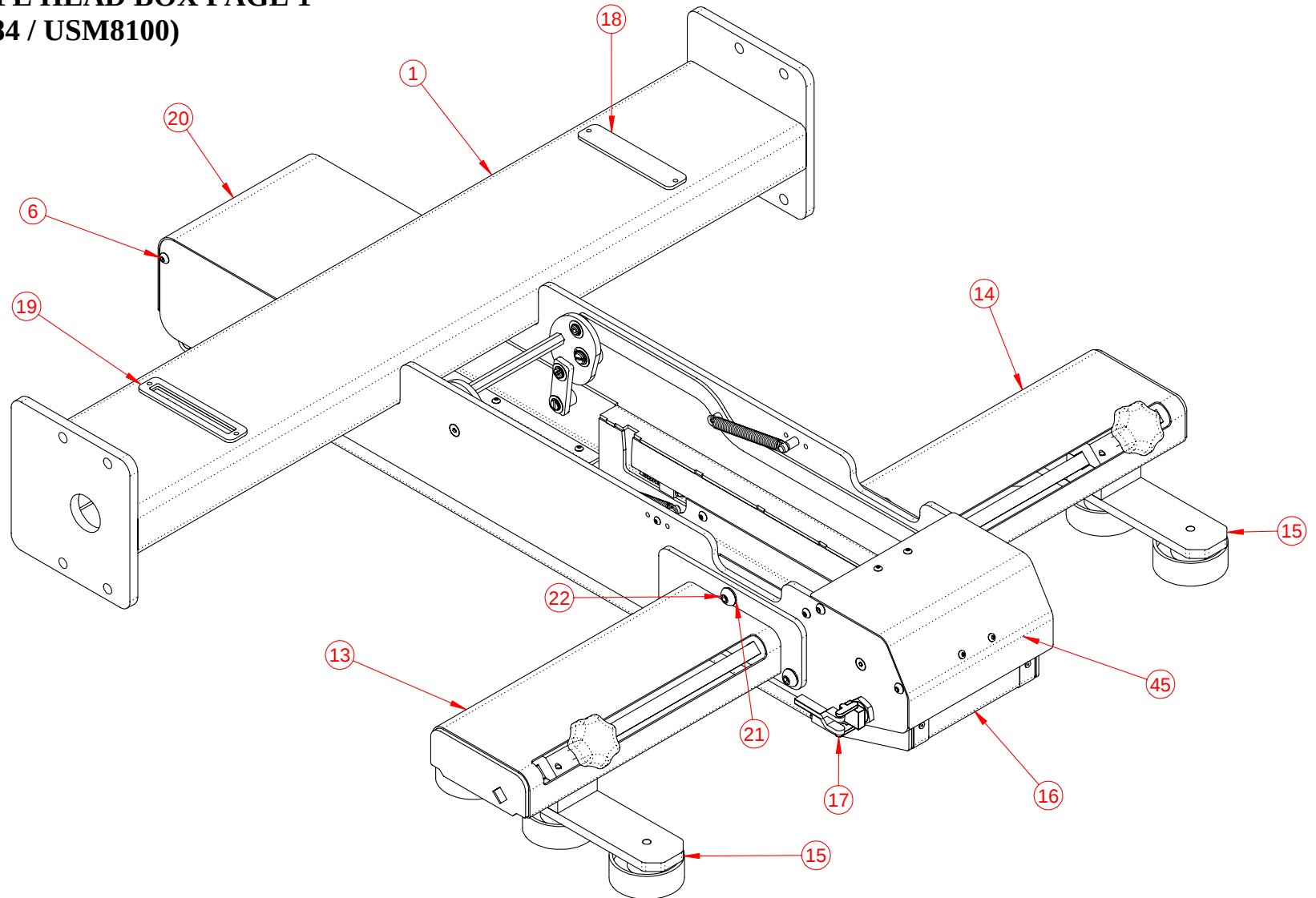
COLUMN LEFT HAND (USM0807)



**COLUMN LEFT HAND
(USM0807)**

ITEM	PART #	DESCRIPTION	QTY.
1	UPM9712	COLUMN 24 LEFT METRIC	1
2	UPM0738EV	COLUMN SHAFT	1
3	UPM0741EV	COLUMN CAP LFT HAND	1
4	UPM2251	RUBBER BUMPER	1
5	UF5400	FHCS M5-0.8 x 12 mm	2
6	UF3680	SS FW M10	6
7	UF6371	L.W. M10	6
8	UF0301	HHCS M10-1.5 x 35	2
9	UF1157	FHCS M5-0.8 x 70	2
10	UPM0743EV	SPRING MANDREL SHAFT	2
11	UPM0742	SPRING SPOOL	2
12	UPM0740	CONSTANT FORCE SPRING	2
13	UPM9651	COLUMN BLOCK 40 mm BORE	1
14	UPM0739EV	LINEAR BEARING DIA 25 mm	2
15	UF1195	BHCS M6-1 x 12 mm	4
16	UF0457	HHCS M10-1.25 x 20 mm	4

**TOP TAPE HEAD BOX PAGE 1
(USM8084 / USM8100)**

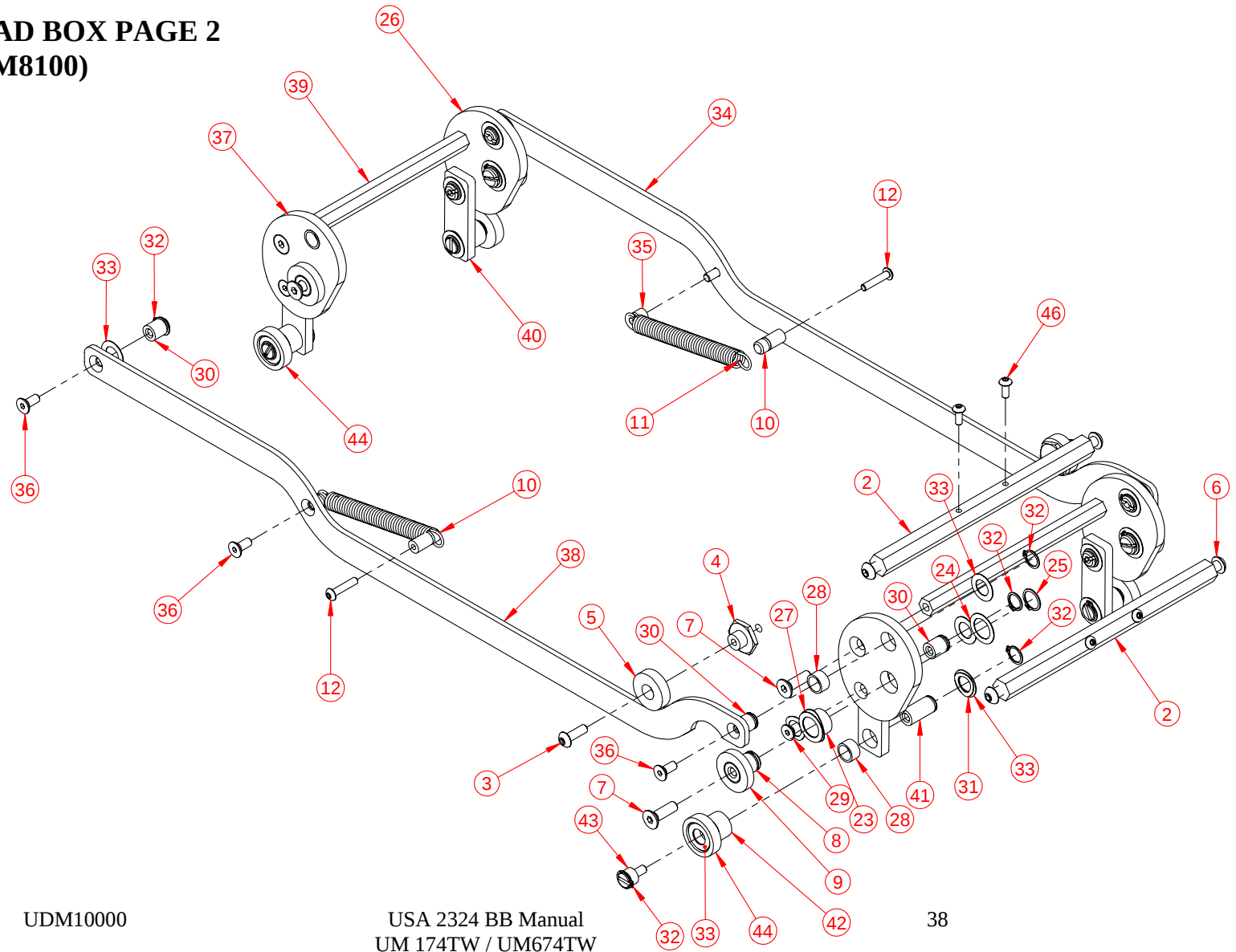


TOP TAPE HEAD BOX PAGE 1 (USM8084 / USM8100)

ITEM	PART #	DESCRIPTION	USM8084 2" USA QTY.	USM8100 3" USA QTY.
1	UPM7487	BRIDGE, WELDWENT	1	1
2	UPM7537	HEX BRACING TTH BOX	3	3
3	UF5602	BHCS M5-0.8 X 16MM	2	2
4	UPH0872	RETAINER, STOP ETM	2	2
5	UPH133	STOP, URETHANE KNIFE ARM	2	2
6	UF1241EV	M6-1 x 20 BHCS	6	6
7	UF5402	FHCS M6 - 1 x 20	8	8
8	UPM0968	PIVOT SHAFT 12 mm DIA	4	4
9	UPM1158	PIVOT SPACER	4	4
10	UPM7535	SPRING RETAINER	2	2
11	UPM1042	EXTENSION SPRING	2	2
12	UF4050EV	BHCS M4 - 0.7 x 20	2	2
13	UPM7489	TOP COMPR. GUIDE SUPPORT L.H.	1	1
14	UPM7490	TOP COMPR. GUIDE SUPPORT R.H.	1	1
15	UAM0260	COMPRESSION GUIDE USA2324 BB	2	2
16	UAM0263	TOP TH FRAME USA 2324	1	-
16	UAM0265	TOP TH FRAME USA 2324	-	1
17	UPM2196	TOGGLE CLAMP	1	1
18	UPM1008	BRIDGE PLATE COVER	1	1
19	UPM1011	BRIDGE PLATE COVER SLOTTED	1	1
20	UPM7493	TOP-END COVER	1	1
21	UF6371	L.W. M10	6	6
22	UF6372	BHCS M10 - 1.5 x 16	6	6
23	UPH 0089	GLYCODUR .50 X .38 LG	4	4

ITEM	PART #	DESCRIPTION	USM8084 2" USA QTY.	USM8100 3" USA QTY.
24	UF1960	NYLON F.W. .515 x .759 x .015	8	8
25	UF6300	RETAINING RING FOR 12mm SHAFT	4	4
26	UPM7495	SWAY HUB RIGHT	2	2
27	UF1900	WAVE W 1/2 U-500-0113	4	4
28	UPH1095	PERMAGLIDE .38 X .25 LG	8	8
29	UF5404	FHCS M5 - 0.8 x 16 mm	4	4
30	UPM7501	PIVOT SHAFT 10mm DIA TTH BOX	8	8
31	UF1896	WAVE W 3/3 U375-0130	12	12
32	UF1797	SS F.W. 10.1mm ID x 16mm OD x .38 th.	20	20
33	UPM7497	HORIZONTAL TRUSS RIGHT	1	1
34	UPM7540	SPRING RETAINER M5	2	2
35	UF5400	FHCS M5-0.8 x 12 mm	6	6
36	UPM7494	SWAY HUB	2	2
37	UF6301	RETAINING RING FOR 10mm SHAFT	16	16
38	UPM7496	HORIZONTAL TRUSS, LEFT	1	1
39	UPM4266	SINCRON HEX BAR	2	2
40	UPM7498	LINK PLATE	4	4
41	UPM7506	SUSPENSION SHAFT	4	4
42	UPM7504	SPACER	4	4
43	UPM7505	SUSPENSION SHAFT THREADED	4	4
44	UPM7507	VERTICAL GUIDE WHEEL	4	4
45	UPM7510	INLET COVER	1	1
46	UF6365	BHCS M4 x 0.7 x 10MM	6	6

TOP TAPE HEAD BOX PAGE 2 **(USM8084 / USM8100)**



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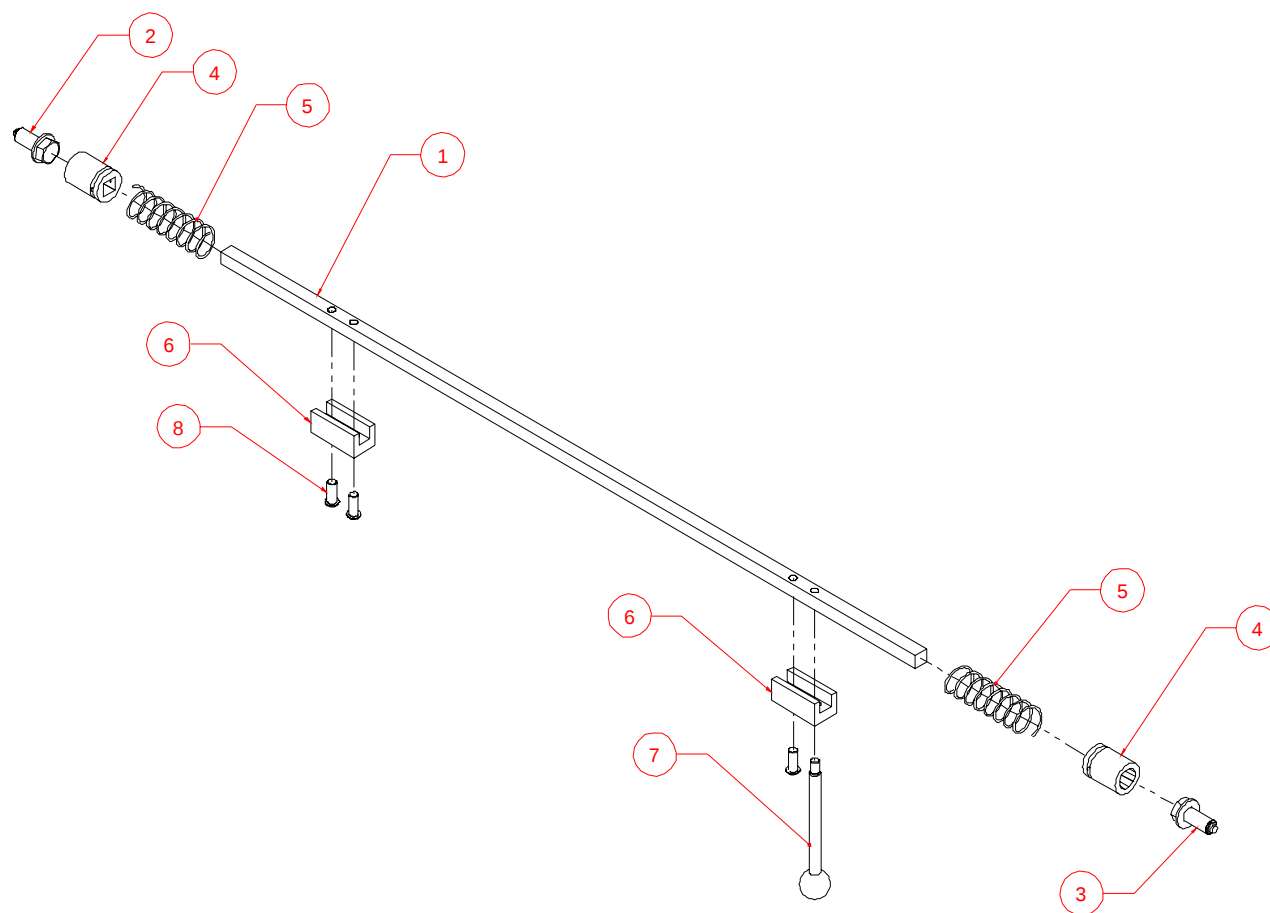
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TOP TAPE HEAD BOX PAGE 2 (USM8084 / USM8100)

ITEM	PART #	DESCRIPTION	USM8084 2" USA QTY.	USM8100 3" USA QTY.
1	UPM7487	BRIDGE, WELDMENT	1	1
2	UPM7537	HEX BRACING TTH BOX	3	3
3	UF5602	BHCS M5-0.8 X 16MM	2	2
4	UPH0872	RETAINER, STOP ETM	2	2
5	UPH133	STOP, URETHANE KNIFE ARM	2	2
6	UF1241EV	M6-1 x 20 BHCS	6	6
7	UF5402	FHCS M6 - 1 x 20	8	8
8	UPM0968	PIVOT SHAFT 12 mm DIA	4	4
9	UPM1158	PIVOT SPACER	4	4
10	UPM7535	SPRING RETAINER	2	2
11	UPM1042	EXTENSION SPRING	2	2
12	UF4050EV	BHCS M4 - 0.7 x 20	2	2
13	UPM7489	TOP COMPR. GUIDE SUPPORT L.H.	1	1
14	UPM7490	TOP COMPR. GUIDE SUPPORT R.H.	1	1
15	UAM0260	COMPRESSION GUIDE USA2324 BB	2	2
16	UAM0263	TOP TH FRAME USA 2324	1	-
16	UAM0265	TOP TH FRAME USA 2324	-	1
17	UPM2196	TOGGLE CLAMP	1	1
18	UPM1008	BRIDGE PLATE COVER	1	1
19	UPM1011	BRIDGE PLATE COVER SLOTTED	1	1
20	UPM7493	TOP-END COVER	1	1
21	UF6371	L.W. M10	6	6
22	UF6372	BHCS M10 - 1.5 x 16	6	6
23	UPH 0089	GLYCODUR .50 X .38 LG	4	4

ITEM	PART #	DESCRIPTION	USM8084 2" USA QTY.	USM8100 3" USA QTY.
24	UF1960	NYLON F.W. .515 x .759 x .015	8	8
25	UF6300	RETAINING RING FOR 12mm SHAFT	4	4
26	UPM7495	SWAY HUB RIGHT	2	2
27	UF1900	WAVE W 1/2 U-500-0113	4	4
28	UPH1095	PERMAGLIDE .38 X .25 LG	8	8
29	UF5404	FHCS M5 - 0.8 x 16 mm	4	4
30	UPM7501	PIVOT SHAFT 10mm DIA TTH BOX	8	8
31	UF1896	WAVE W 3/3 U375-0130	12	12
32	UF1797	SS F.W. 10.1mm ID x 16mm OD x .38 th.	20	20
33	UPM7497	HORIZONTAL TRUSS RIGHT	1	1
34	UPM7540	SPRING RETAINER M5	2	2
35	UF5400	FHCS M5-0.8 x 12 mm	6	6
36	UPM7494	SWAY HUB	2	2
37	UF6301	RETAINING RING FOR 10mm SHAFT	16	16
38	UPM7496	HORIZONTAL TRUSS, LEFT	1	1
39	UPM4266	SINCRON HEX BAR	2	2
40	UPM7498	LINK PLATE	4	4
41	UPM7506	SUSPENSION SHAFT	4	4
42	UPM7504	SPACER	4	4
43	UPM7505	SUSPENSION SHAFT THREADED	4	4
44	UPM7507	VERTICAL GUIDE WHEEL	4	4
45	UPM7510	INLET COVER	1	1
46	UF6365	BHCS M4 x 0.7 x 10MM	6	6

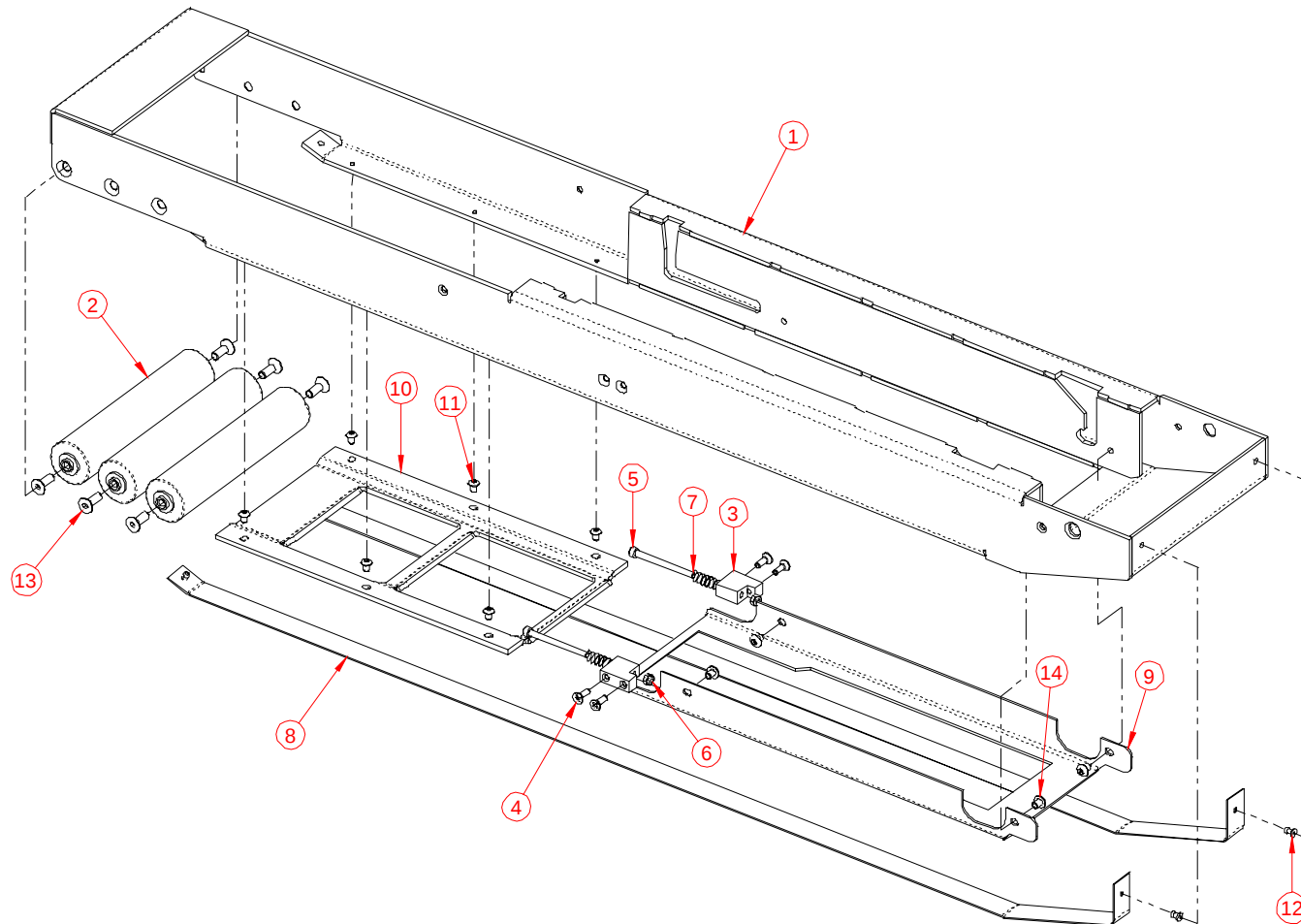
LOCKING MECHANISM (USM0391)



LOCKING MECHANISM (USM0391)

ITEM	PART #	DESCRIPTION	USM0391 QTY.
1	UPM2187EV	SQUARE BAR 0.50"	1
2	UPM0698	FLANGED SCREW 1/2-13 L.H.	1
3	UPM0699	FLANGED SCREW 1/2-13 R.H.	1
4	UPM0703	SHORT BOX 3/4", 1/2" DR, 12 PT	2
5	UPM2184	SPRING, C1100-065-4000-M	2
6	UPM0700	SINGLE LOCKING BLOCK	2
7	UPM0688EV	SINGLE LOCKING HANDLE	1
8	UF1318	BHCS M8-1.25 X 20MM	3

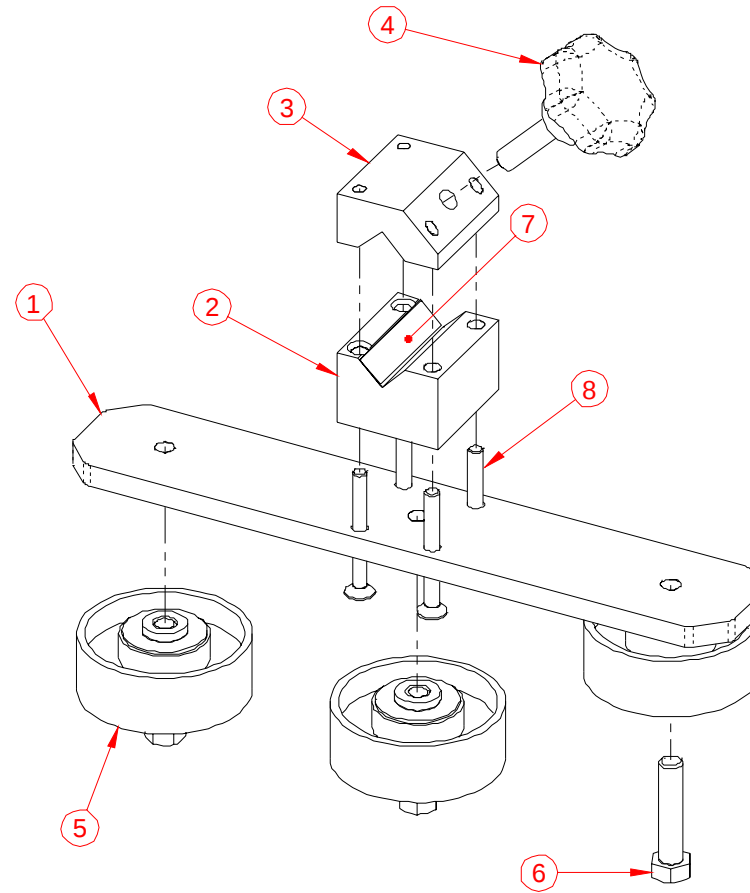
TOP TAPE HEAD FRAME (UAM0263 / UAM0265)



TOP TAPE HEAD FRAME (UAM0263 / UAM0265)

ITEM	PART #	DESCRIPTION	UAM0263 2" USA QTY.	UAM0265 3" USA QTY.
1	UPM7488	FLOATING T.H.BOX	1	1
2	UPM7492	REAR ROLLER-FLOATING	3	3
3	UPM7541	SPRING SUPPORT M4	2	2
4	UF0902EV	FHCS M4-0.7 x 12	4	4
5	UF6375	SHCS M4-0.7 x 50	2	2
6	UF6376	NYLON LOCKNUT M4	2	2
7	UPM1068	COMPRESSION SPRING	2	2
8	UPM0029	STRIP, UHMW, 2" W x .03" THK.	2	2
9	UPM7499	GAP FILLER, TOP TH BOX	1	-
10	UPM7500	REAR GAP FILLER TTH BOX	1	1
11	UF6374	BHCS M4-0.7 x 6	6	6
12	UF3510	SS POP RIVET SS-44	4	4
13	UF1192	FHCS M6 X 1 X 16MM	6	6
14	UF5601	BHCS M5 X 0.8 X 6MM	4	-

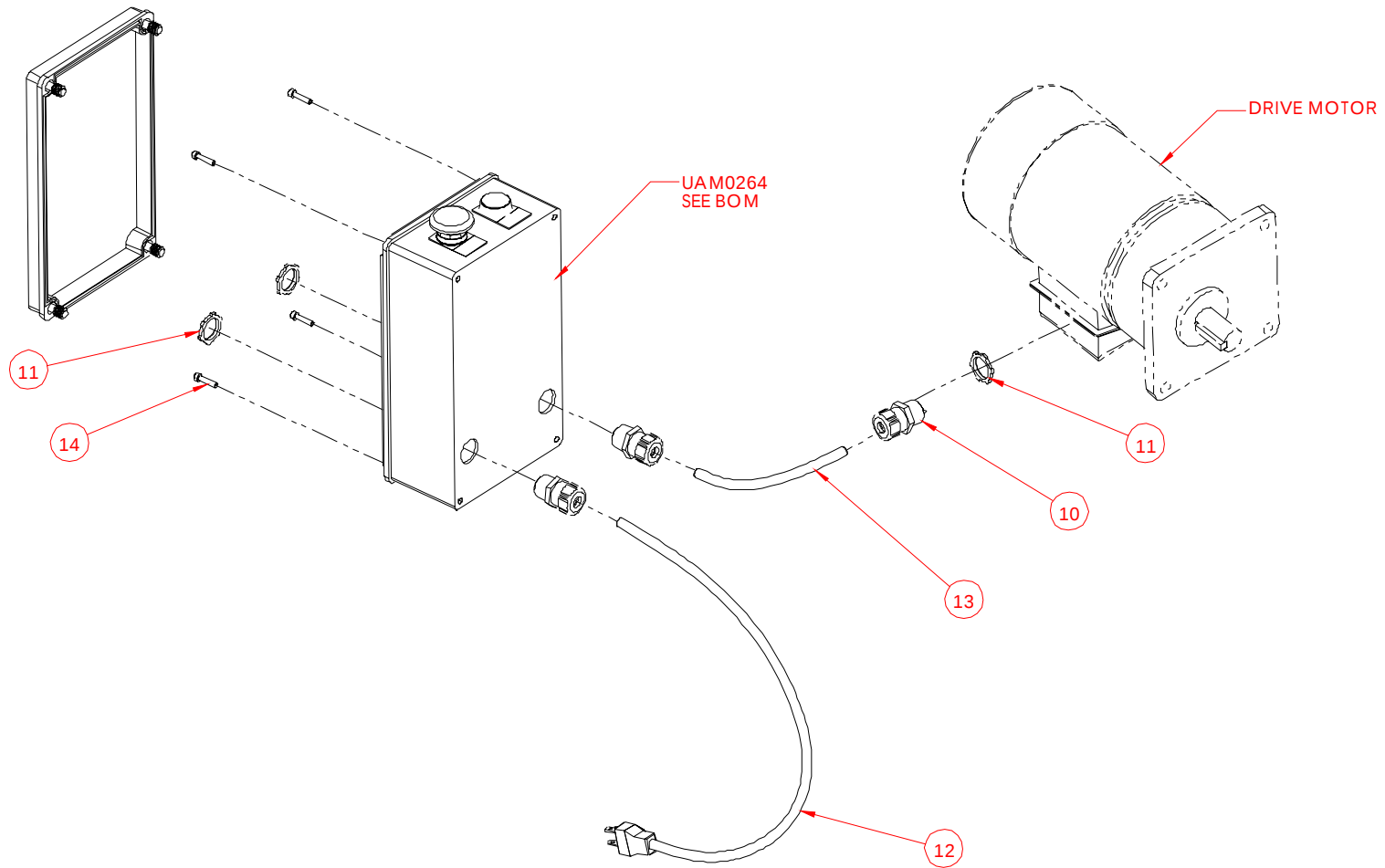
COMPRESSION GUIDES (UAM0260)



COMPRESSION GUIDES (UAM0260)

ITEM	PART #	DESCRIPTION	QTY.
1	UPM7491	WHEEL SUPPORT PLATE	1
2	UPM3285	GUIDE BLOCK	1
3	UPM7538EV	GUIDE BLOCK TOP	1
4	UPM7522	KNOB WITH M10 ROD	1
5	UPM1659	WHEEL 2-7/8"DIA.COMPR.GUIDE	3
6	UF0241EV	HHCS G5Z 3/8-16 X 1.75 FULL THREAD	3
7	UPM2170	1/2" X 0.010" THK X 2.5 LG UHMW PAD	1
8	UF6373	FHCS M6 - 1 x 55	4

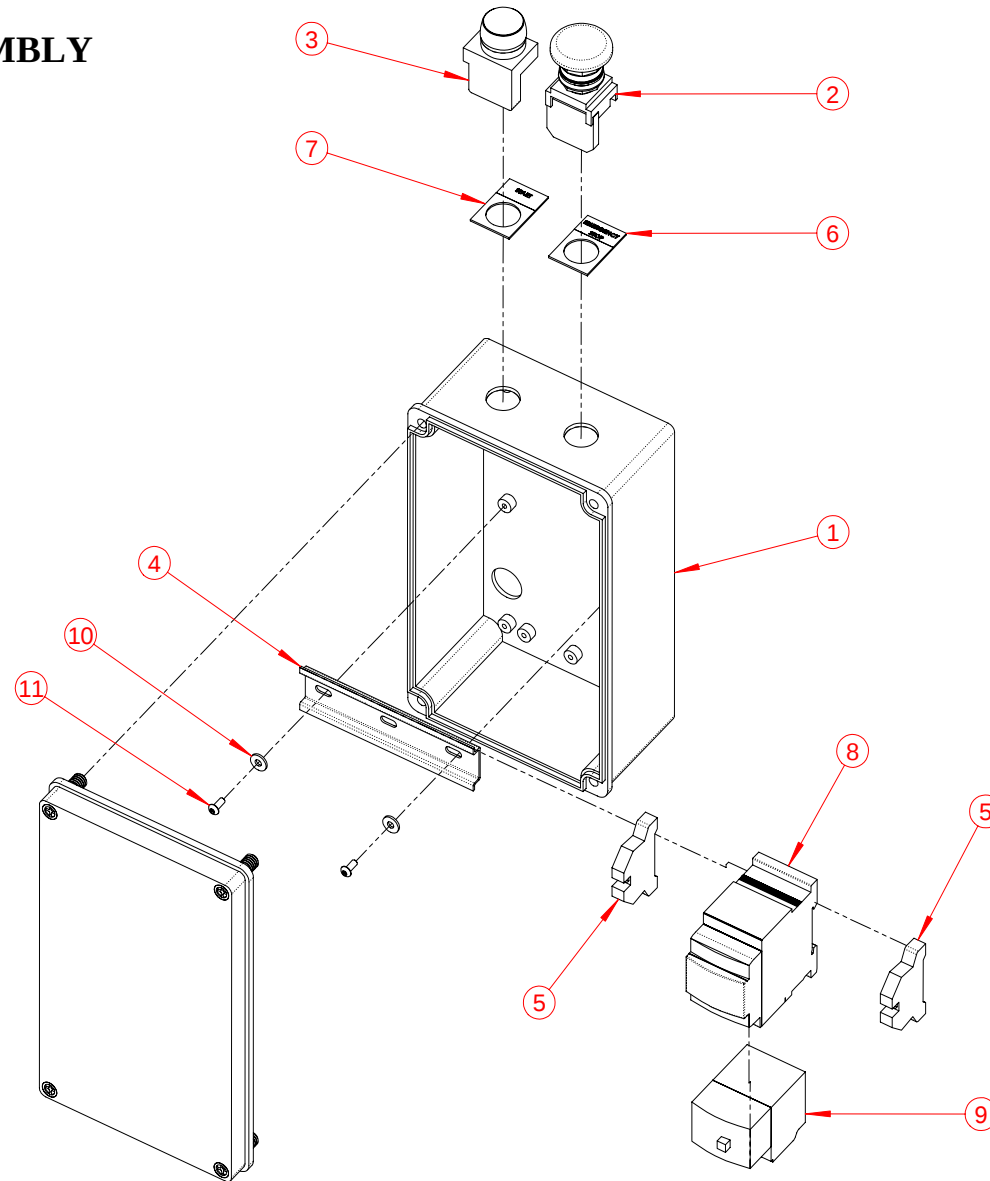
ELECTRIC BOX INSTALLED (USM8092)



**ELECTRIC BOX INSTALLED
(USM8092)**

ITEM	PART #	DESCRIPTION	USM8092 QTY.
10	UPM0197	STR.RELF METL.LIQ DTGHT 1/4-3/8	1
11	UPM0341	LOCKNUT 1/2"(FOR STRAIN RELF)	3
12	UPM0209	POWER CORD, 14/3 (9 FT)	1
13	UPM0225	CABLE 18/3 TYPE SJ	1
14	UF3646	SHCS M4-0.7 x 20	4

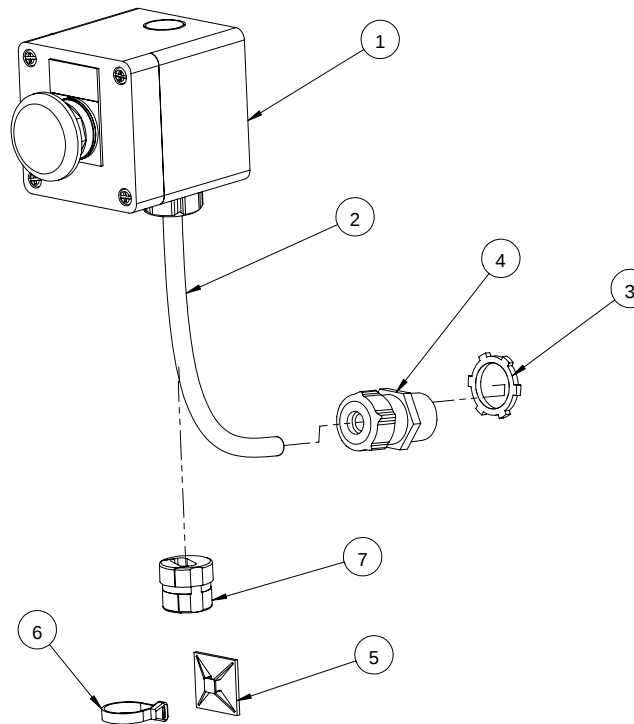
ELECTRIC BOX ASSEMBLY (UAM0264)



ELECTRIC BOX ASSEMBLY (UAM0264)

ITEM	PART #	DESCRIPTION	UAM0264QTY
1	UPM2214EV	CONTROL BOX	1
2	UPM2211	BUTTON MUSHROOM 22MM 1 N.C.	1
3	UPM2212	BUTTON GREEN 22MM 1 N.O.	1
4	UPM0407	DIN RAIL	1
5	UPM7440	TB END ANCHOR FOR DN SER	2
6	UPM2209	LEGEND PLATE "E-STOP"	1
7	UPM2210	LEGEND PLATE "START"	1
8	UPM2208EV	MOTOR STARTER TELEMEC 110VAC	1
9	UPM2213EV	MOTOR O/L TELEMEC 5.5-8A	1
10	UF6339	SS FW M4	2
11	UF6365	BHCS M4 x 0.7 x 10MM	2

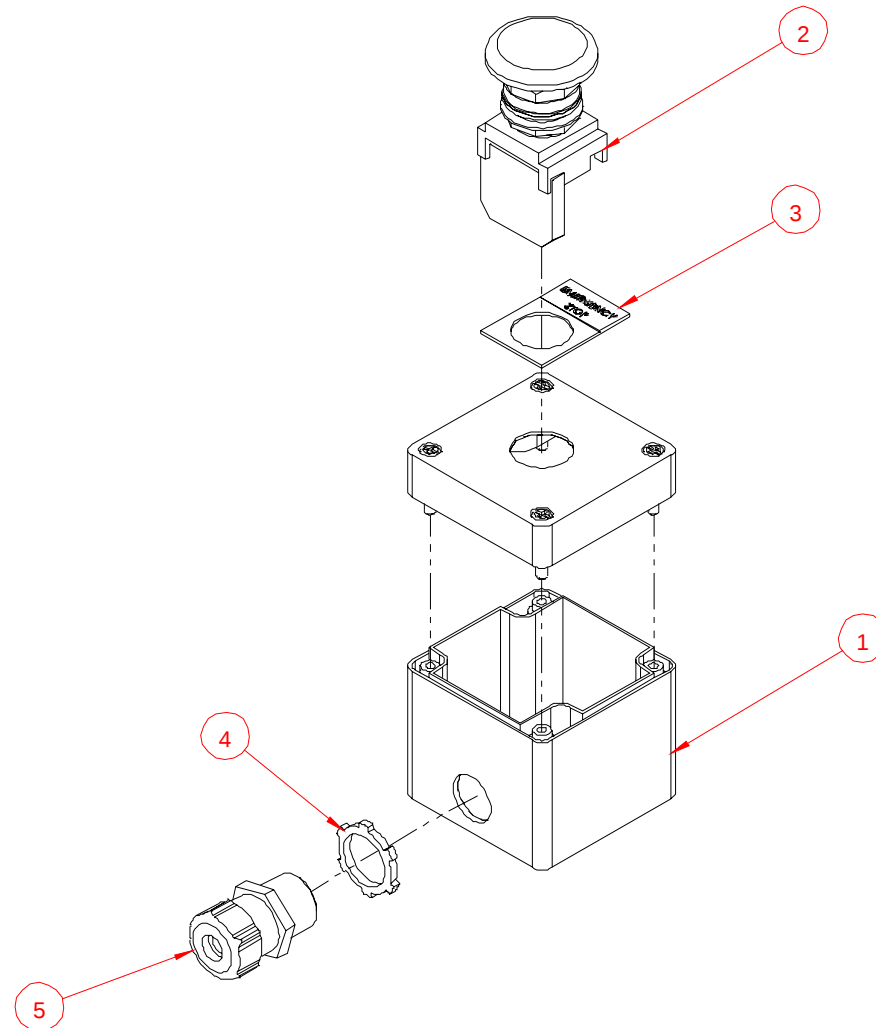
SECOND E-STOP INSTALLED (UM9003)



SECOND E-STOP INSTALLED (UM9003)

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	USM8075	SECOND E-STOP BOX FOR USA	1
2	UPM0225	CABLE 18/3 TYPE SJ	6.2 FT
3	UPM0341	LOCKNUT 1/2"(FOR STRAIN RELF)	1
4	UPM0197	STR.RELF METL.LIQDTGHT 1/4-3/8	1
5	UPM0200	MTG. CLAMP,ADH.1.2"X1.2"	4
6	UPM0222	TY-RAP,5.5"X.14"	4
7	UPM0285	STRAIN RELIEF, NON-METAL	1

SECOND E-STOP BOX ASSEMBLY (UM8075)



**SECOND E-STOP BOX ASSEMBLY
(USM8075)**

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	UPM7293	ENCLOS PB 1 HOLE NON METAL	1
2	UPM2211	BUTTON MUSHROOM 22MM 1 N.C.	1
3	UPM2209	LEGEND PLATE "E-STOP"	1
4	UPM0341	LOCKNUT 1/2"(FOR STRAIN RELF)	1
5	UPM0197	STR.RELF METL.LIQDTGHT 1/4-3/8	1