



RSA 2625-TB

Random Semi-Automatic Case Sealer

OPERATIONS MANUAL & PARTS LIST



For Machines Starting With Serial Number TM154 XX X XXX

For all other serial numbers, contact Customer Service @ 800-474-8273 (Menu #3)
This manual also available at www.Intertapepolymer.com



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Chapter 1 **GENERAL INFORMATION**

1.1 REVISION CONTROL

REV00..... Initial Release

1.2 TECHNICAL SUPPORT

This is the Interpack Model RSA 2625-TB Random Semi-Automatic Case Sealer you ordered. It has been setup and tested in our factory with Intertape manufactured pressure sensitive tapes. 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, Interpack Technical Support is available. Should the need to contact Interpack Technical Support arise, please have the Case Sealer model number and serial number on hand. This information can be found on the nameplate of the side panel of the machine. Interpack Technical Support is available during normal business hours (Eastern Time).

- **PHONE: 813 621-8410 x101**

If you have a technical question that does not require an immediate response, you may contact Interpack by fax.

- **FAX: 813-621-8449**

Technical support may also be contacted via email at the address below:

- **EMAIL: Machsupp@itape.com**

1.3 REPLACEMENT PARTS

This Machine Is Designed To Provide Years Of Trouble Free Operation. However, Maintaining A Small Inventory Of Spare Parts Assures Minimum Downtime In The Event Of A Problem. We Recommend That You Stock The Following Spare Parts.

DESCRIPTION	ITEM NUMBER	RECOMMENDED QUANTITY
Bearing Pulley	UPM0324	2
Belt, DRV SAG12E, 2" X 6ft. 7.50"	TBD	2
Linear Bearing 25mm Shaft	LM25UU	2
Spring Blade	UPM0011	2
BO Pressure Gauge 40mm 0.6 Bar	UPM3273	1
Wheel 2-7/8"DIA. Compr. Guide	UPM1659	2

Table 1-1 Replacement Parts

Replacement Parts

Order parts by item number, part description, and quantity required. Replacement parts are available from your authorized Interpack distributor exclusively.

Should you require assistance selecting the correct part, you may call:

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

Tel: 1-800-474-8273, Option 3

Fax: 1-800-462-1293

MODEL: _____

SERIAL NUMBER: _____

DISTRIBUTOR PURCHASED FROM: _____

DATE OF PURCHASE: _____

1.4 FIELD SERVICE ASSISTANCE

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 Chapter 6, [Troubleshooting](#).

Service support is available from your authorized Interpack distributor at additional cost if the problem cannot be remedied after consulting the Troubleshooting chapter of this manual.

1.5 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 Interpack Tape Heads, Case Tapers, and Case Erectors with the following warranties:

1. The ETX 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 ETX Tape Head parts will be free from all defects for one (1) year after delivery.
3. Water Activated Tape Head 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.

1.6 DESCRIPTION OF RSA 2625-TB RANDOM SEMI-AUTOMATIC CASE SEALER

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.

Figure 1-1 RSA 2625-TB Random Semi-Automatic Case Sealer

The Interpack RSA 2625-TB Random Semi-Automatic Case Sealer Machine with ETX Tape Heads is designed to apply Intertape brand pressure sensitive case sealing tape to the top and bottom center seam of regular slotted



corrugated cases. The RSA 2625-TB Random Semi-Automatic Case Sealer is manually adjustable to a wide range of case sizes (refer to Case Specifications, [page 3-2](#)). Multi-Wheel Top Squeezers compress the top major flaps ensuring superior seal. The RSA 2625-TB Random Semi-Automatic Case Sealer features reversible operator controls to facilitate its adaptation into an existing conveyor line.

Chapter 2 **IMPORTANT SAFEGUARDS**

2.1 SAFETY LABEL DESCRIPTIONS

There Are A Number Of Safety Labels Used On Intertape Case Sealers.

<p>The illustrated label, as shown, is attached to the Knife Guard inside the upper and lower ETX 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.</p> <p>The ETX Tape Heads are equipped with a Knife guard that covers the blade. The Tape Heads should never be operated with the blade guards removed.</p> <p>Turn air and electrical supplies off before servicing the tape heads.</p>	
<p>The label shown is affixed on the in-feed and exit ends of the machine belt drives. The label warns the operators and service personnel of the pinch points at each end of the belt drives.</p>	

The label shown is attached to the control box. The label warns the service personnel to unplug the power supply before attempting any service work on the case sealer.



The label shown is affixed on the “EXIT” end of the Left Hand side cover. The label warns the operators and service personnel of the pinch point at the exit ends of the machine.



The label shown is affixed on the side of the column. This label provides convenient safety instruction for the operator and service personnel in the operation of the Interpack Case Sealing Equipment.



Note: Should any of the safety labels placed on the Case Sealer be damaged or destroyed, replacements are available through your distributor.

2.2 EXPLANATION OF SIGNAL WORD CONSEQUENCES

 **WARNING:** Indicates a potentially hazardous situation that, if not avoided, could result in death or serious injury or property damage.

 **CAUTION:** Indicates a potentially hazardous situation that, if not avoided, could result in minor or moderate injury or property damage.

WARNING

- **To reduce the risk associated with mechanical, pneumatic, and electrical hazards:**
 - a. Read, understand, and follow all safety and operating instructions before operating or servicing the case sealer.
 - b. Allow only properly trained and qualified personnel to operate and service this equipment.
- **To reduce the risk associated with pinches, entanglement, and hazardous voltage:**

Turn electrical supply off and disconnect before performing any adjustments, maintenance, or servicing of the machine or taping heads.
- **To reduce the risk associated with pinches and entanglement hazards:**
 - a. Do not leave the machine running while unattended.
 - b. Turn the machine off when not in use.
 - c. Never attempt to work on any part of the machine, load tape, or remove jammed boxes from the machine while the machine is running.
- **To reduce the risk associated with hazardous voltage:**

Position electrical cord away from foot and vehicle traffic.
- **To reduce the risk associated with sharp blade hazards:**

Keep hands and fingers away from tape cutoff blades. Blades are extremely sharp.
- **To reduce the risk associated with fire and explosion hazards:**

Do not operate this equipment in potentially flammable/explosive environments.
- **To reduce the risk associated with muscle strain:**
 - a. Use the appropriate rigging and material handling equipment when lifting or repositioning this equipment.
 - b. Use proper body mechanics when removing or installing taping heads that are moderately heavy or may be considered awkward to lift.

CAUTION

- **To reduce the risk associated with pinch hazards:**
 - a. Keep hands clear of the upper head support assembly as boxes are transported through the machine.
 - b. Keep hands, hair, loose clothing, and jewelry away from box compression rollers.
 - c. Always feed boxes into the machine by pushing only from the end of the box.
 - d. Keep hands, hair, loose clothing, and jewelry away from moving belts and taping heads.

2.3 OPERATOR SKILL LEVEL DESCRIPTIONS

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

2.3.1 Skill “A” Machine Operator

This operator is trained to use the machine with the machine controls. This operator can feed cases into the machine, make adjustments for different case sizes, change tapes, and start/stop, and re-start production.

2.3.2 Skill “B” Mechanical Maintenance Technician

This technician is trained to use the machine as the machine operator, and is able to work with the safety protection disconnected, check and adjust mechanical components, perform maintenance operations, and repair the machine. He is not allowed to work on live electrical components.

2.3.3 Skill “C” Electrical Maintenance Technician

This technician is trained to use the machine as the machine operator, and is able to work with the safety protection disconnected, check and adjust mechanical components, perform maintenance operations, and repair the machine. He is allowed to work on live electrical panels, terminal blocks, and control equipment.

2.3.4 Skill “D” Manufacturer’s Technician

Skilled technician sent by the manufacturer, or its agent, to perform complex repairs or modifications, when agreed to by the customer.

Operation	Machine Condition	Operator Skill Level	Number of Operators
Machine Installation & Set-Up	Running with Safety Protections Disabled	B & C	2
Adjusting Case Size	Stopped by Pressing the Emergency Stop (E-Stop) Button	A	1
Tape Roll Replacement	Stopped by Pressing the Emergency Stop (E-Stop) Button	A	1
Blade Replacement	Electrical Power Disconnected	B	1
Drive Belt Replacement	Electrical Power Disconnected	B	1
Ordinary Maintenance	Electrical Power Disconnected	B	1
Extraordinary Mechanical Maintenance	Running with Safety Protections Disabled	D	1
Extraordinary Electrical Maintenance	Running with Safety Protections Disabled	C	1

Table 2-1 Operators Skill Level

Notes

Chapter 3 **SPECIFICATIONS**

3.1 MACHINE DIMENSIONS

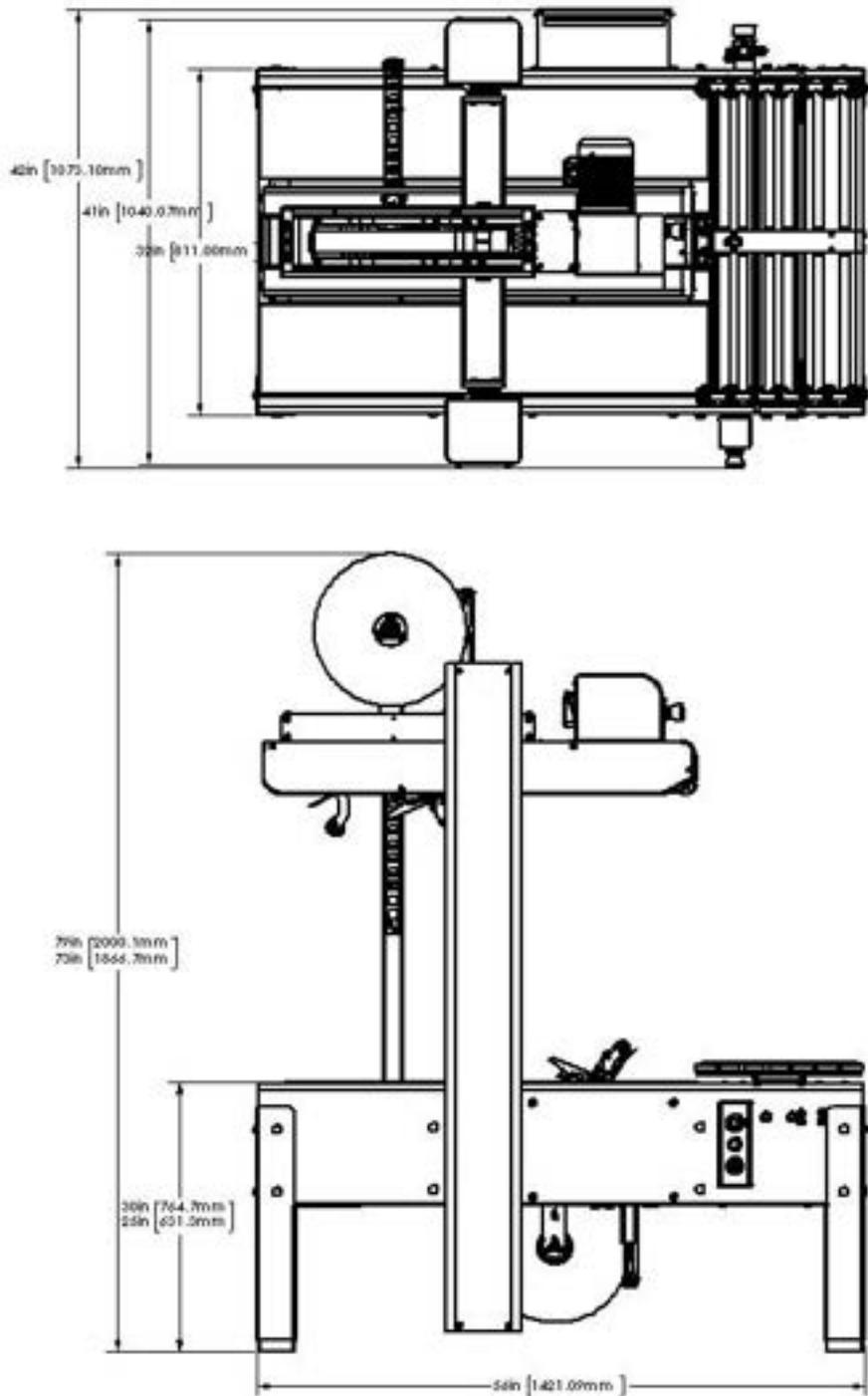


Figure 3-1 Machine Dimensions

3.2 MACHINE OPERATING CONDITIONS

Always operate the machine in a dry, relatively clean environment at 40 to 105 °F (5 to 40 °C) with clean, dry cases. Machine must be set on a level surface or adjusted to operate on a level plane.

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

3.2.1 Power Requirements

- Electrical - 115V, 60HZ, 8.4A (966 Watts)
- Compressed Air – N/A

This machine comes standard with one (1) 1/6 H.P. and one (1) 1/3 H.P. gear motors and comes with a standard neoprene covered power cord and a grounded plug. Contact your Intertape Representative for power requirements not listed above.

3.2.2 Operating Speed

Actual production rate is dependent on operator's efficiency and the case size mix. Belt speed is 82 ft. per minute.

3.2.3 Tape Specifications

Use **IPG Pressure Sensitive Case Sealing Tape**.

A maximum tape roll diameter of 16 in. (406mm) on a 2 in. (50.8mm) diameter core can be installed on the tape head. (Accommodates all Intertape brand film tape machine roll lengths).

The standard Tape Leg Length of 2.5 in. (63.5mm) is factory set. The standard tape leg length may vary up to ¼ in. (6mm) based on tape tension and line speed.

The optional Tape Leg Length of 2 in. (50.8mm) is factory set. The standard tape leg length may vary up to ¼ in. (6mm) based on tape tension and line speed.

The standard tape leg length is adjustable +/- ¼ in. Refer to the tape head manual for adjustment of tape leg length.

Note: for further specifications on ETX Tape Heads, consult the ETX Tape Head manual provided with this machine.

3.2.4 Case Specifications

Type

- Regular Slotted Containers (RSC).
- Other style cases may be processed. Consult factory for details.

Material

125 - 275 PSI Bursting Test, Single or Double Wall B or C Flutes.

Size

The case sealer can accommodate most cases within the size ranges listed below.

Standard Case Size Capacities			
Case Size	Length	Width	Height
Minimum	6 in. (150mm)	6 in. (150mm)	5 in. (127mm)
Maximum	Infinite	26 in. (508mm)	25 in. (609.6mm)
Optional Case Size Capacities			
Case Size	Length	Width	Height
Minimum	6 in. (150mm)	6 in. (150mm)	2 in. (50.8mm)
Maximum	Infinite	26 in. (508mm)	25 in. (533.4mm)
Minimum	8 in. (203.2mm)	8 in. (203.2mm)	2 in. (50.8mm)
Maximum	Infinite	26 in. (558.8mm)	25 in. (533.4mm)

Table 3-1 Case Sizes

Notes

Chapter 4

SET-UP PROCEDURES

4.1 RECEIVING AND HANDLING

The following instructions are presented in **the order recommended** for setting up and installing the RSA 2625-TB Random Semi-Automatic Case Sealer as well as for **learning the operating functions and adjustments**. Following them step by step will result in your thorough understanding of the machine and an installation in your production line that best utilizes the many features built into the case sealer.

1. Lift off cover and sleeve after removing the strapping and staples at bottom.
2. Remove mounting bolts and nuts, which secure the RSA 2625-TB Random Semi-Automatic Case Sealer to the shipping pallet.
3. Lift machine off pallet and install on your packaging line.
4. Remove machine from the pallet to the location of final installation.

Note: 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 authorized Intertape distributor.

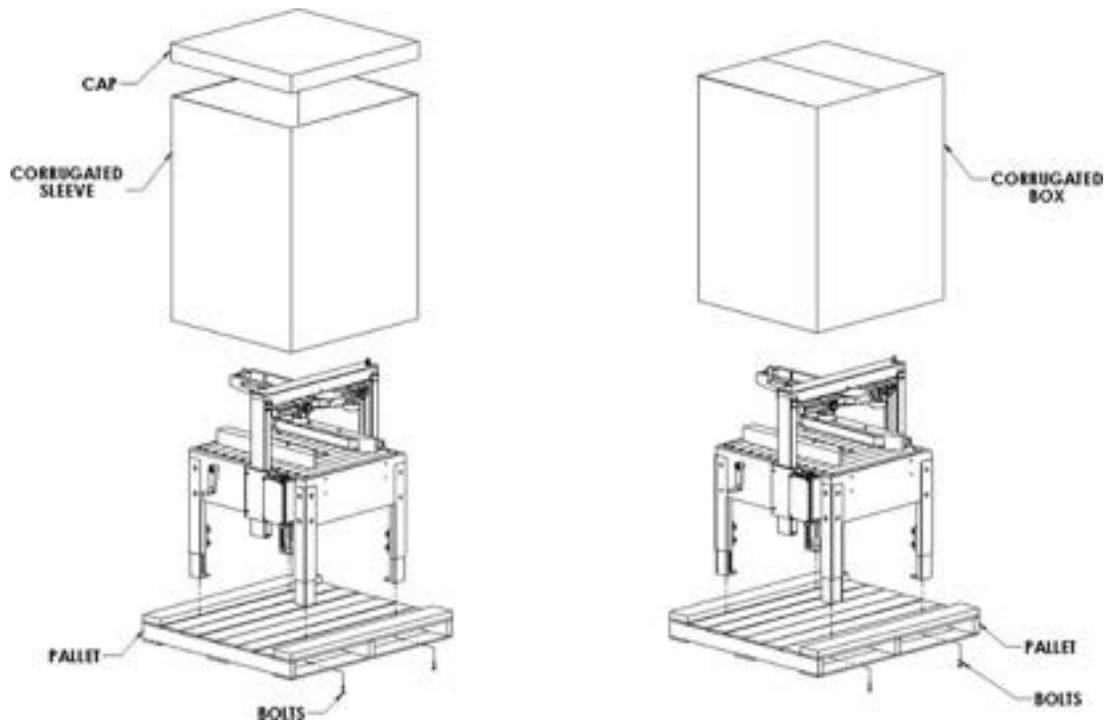


Figure 4-1 Receiving and Handling

4.2 TABLE LEVELING

⚠ WARNING: MACHINE HEIGHT ADJUSTMENT REQUIRES RAISING THE MACHINE TO ADJUST EACH LEG. FOLLOW ALL POSSIBLE SAFETY PROCEDURES PRIOR TO AND DURING THIS PROCESS.

The Case Sealer must be installed on a near level ground.

Ensure that the machine is level and firmly on the ground (no rocking). Adjust the roller height with the four (4) telescopic adjustment legs to accommodate conveyor heights from 24 to 30 inches.

To adjust the Case Sealer height (refer to Figure 4-2):

1. Jack up the machine to give ample room to extend the legs.
2. Using a 3/4" (19 mm) box end wrench, loosen the eight (8) M10 hex head bolts.
3. Adjust the legs to the desired conveyor height and tighten the bolts.

Note: There are etched lines on the legs for ease of leveling.

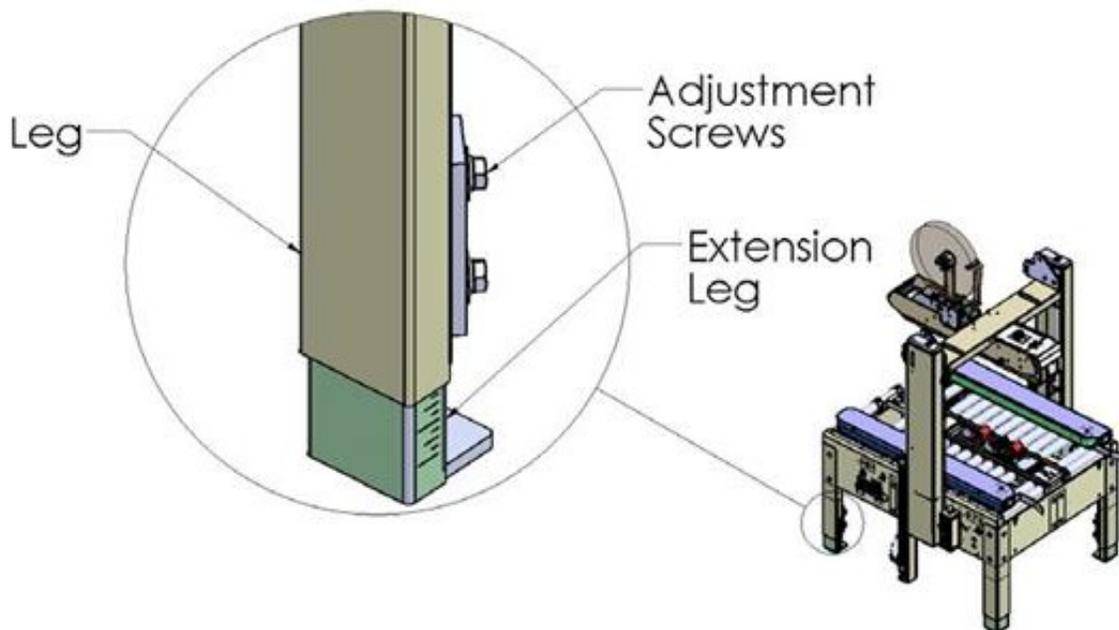


Figure 4-2 Table Leveling

4.3 INSTALLATION OF EXTERNAL IN-FEED AND EXIT CONVEYORS

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 0.24 in./ft. (20mm/meter) away from the machine to convey the sealed cases away from the machine.
3. Customer supplied powered exit conveyor should be straight and level to convey the sealed cases away from the machine.

4.4 CONTROL BOX

The control box contains the following (refer to Figure 4-3):

1. EMERGENCY STOP button (E-Stop) - The E-Stop is a detent type, when it is pushed down, it will stay in the down position. In order to re-start the machine, the operator has to pull up the E-Stop button and press on the green START push button.
2. START push button - Starts machine operation.
3. BLOCKED selector switch.

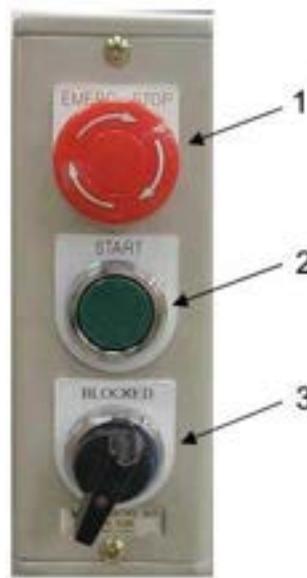


Figure 4-3 Control Box

4.5 CONNECTING UTILITIES

4.5.1 Electrical Utilities

A 12 foot (3.7m) standard three conductor power cord with plug is provided for 115V, 60Hz, 15A electrical service. The servicing receptacle must be properly grounded. Before the machine is plugged into the receptacle, ensure that all materials are removed from the machine.

Note: Use of an extension cord is not recommended because of voltage drop.

The electrical control is protected with an automatic circuit breaker with re-settable overload. This reset is located in the electrical box in the lower left quadrant. Push on the blue button to reset (refer to Figure 4-4).

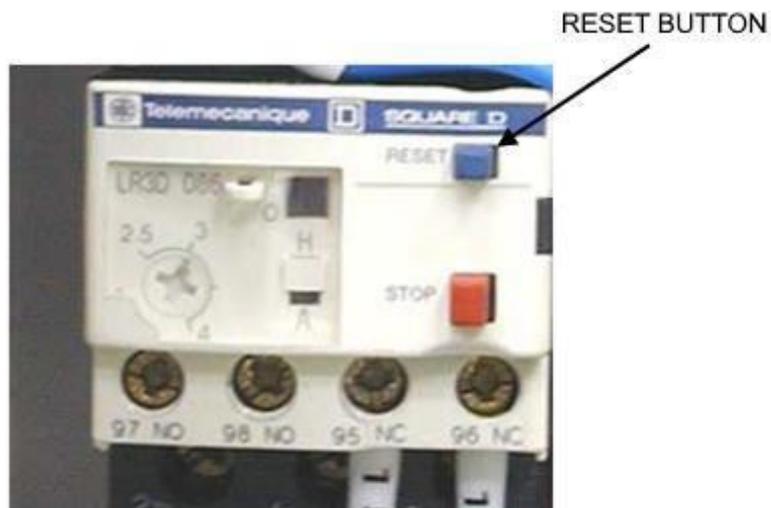


Figure 4-4 Electrical Utilities

4.5.2 Air Connection

The regulator has a male "quick disconnect" adaptor. Connect clean dry compressed air to this adapter. The RSA2625-TB Random Semi-Automatic Case Sealer requires a minimum of 3 C.F.M. at **75 PSI** maximum.

To regulate the air pressure, pull on the green knob located on the side of the machine. Turn the knob clockwise for more pressure and counter clockwise for less. When the air pressure is at **75 PSI**, push back down on the button until a "click" is felt. The threading size is 3/8 NPT (refer to Figure 4-5).



Figure 4-5 Air Regulator

4.5.3 Pneumatic Adjustment

The main air filter/regulator controls the air pressure going inside the machine. It also controls the air pressure inside the cylinders that raise the Top Belt Drive Assembly and open the infeed guides. **The recommended pressure setting for the main air filter/regulator is between 60 and 70 PSI.**

The Infeed Guide Pressure is controlled with the pressure regulator located at the infeed end of the machine, under the left hand Side Cover. By **increasing** the air pressure, you **increase** the centering force of the guides on the box. **The recommended pressure setting for the Infeed Guide regulator is between 30 and 40 PSI.**

The weight of the Top Belt Drive Assembly on the box is controlled by the High Flow Pressure Control located at the discharge end of the machine, under the left hand Side Cover. This controls the air pressure at the bottom of the cylinder and counterbalance for the weight of the Top Belt Drive Assembly. Therefore, to **reduce** the weight applied on the top of the box, you have to **increase** the air pressure. **The recommended pressure setting for the High Flow Pressure Control is between 35 and 45 PSI.**

4.6 TAPE LOADING

The ETX Tape Heads accommodate 2 in. (50.8mm) wide tape rolls, while the ETX /3 in. Tape Heads accommodate 3 in. (76.2mm) wide rolls.

1. Place the tape head onto a sturdy, flat surface.
2. Move the peel off roller away from the mandrel.
3. Push the roll of tape onto the mandrel with the adhesive side up (refer to Tape Threading [page 4-8](#)) until the core seats against the mandrel flange. This ensures the tape will be aligned when feeding into the tape head.
4. Replace the peel roller against the tape roll.

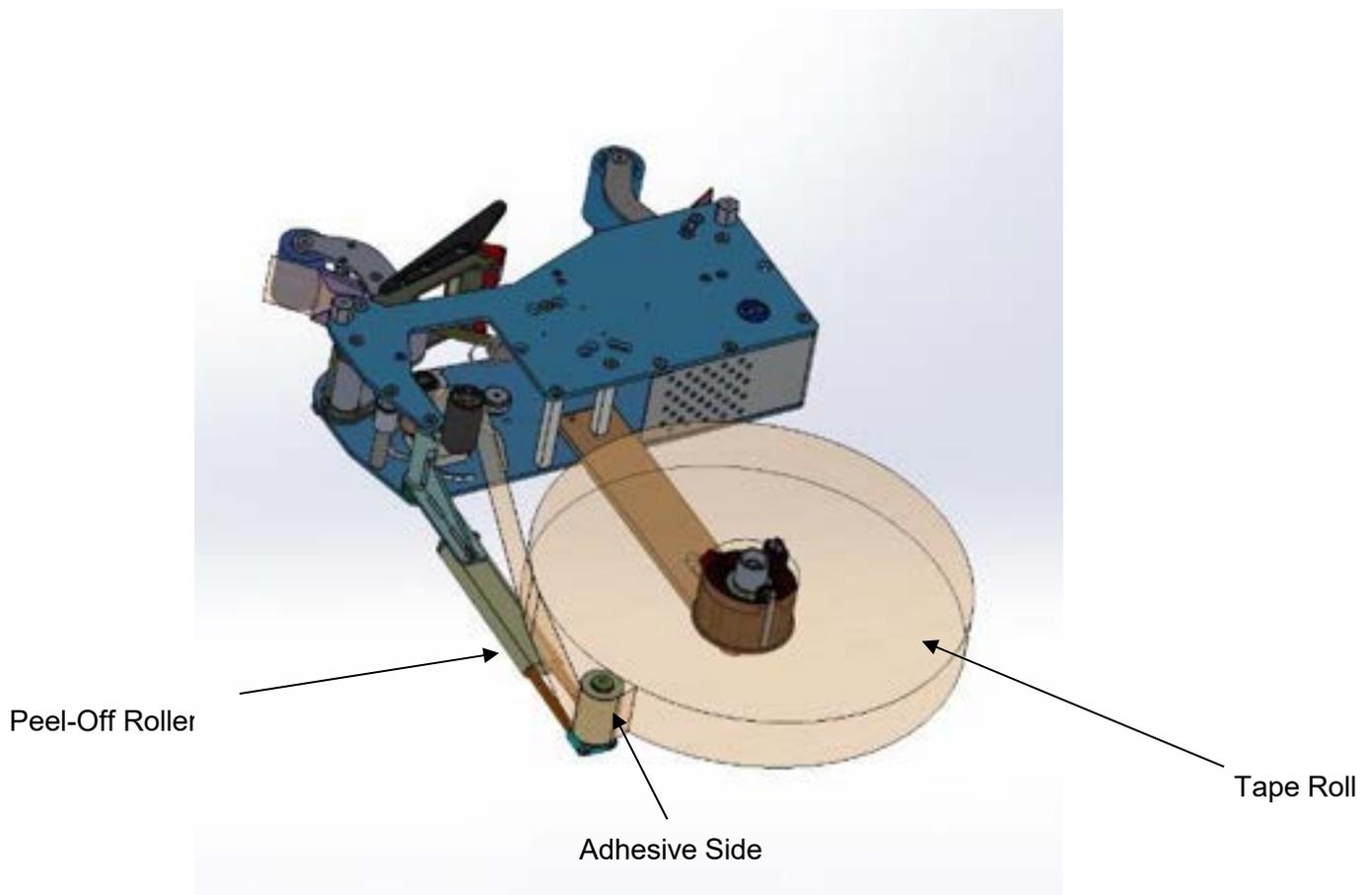


Figure 4-6 Tape Loading

4.7 TAPE THREADING PREPARATION

Threading the tape in the Tape Head does not require any special tools.

Pull approximately 12 in. (304.8mm) of tape from the roll and fold in half lengthwise, adhesive side to adhesive side. This allows you to thread the tape without it adhering to the guide and clutch rollers inside the Tape Head.

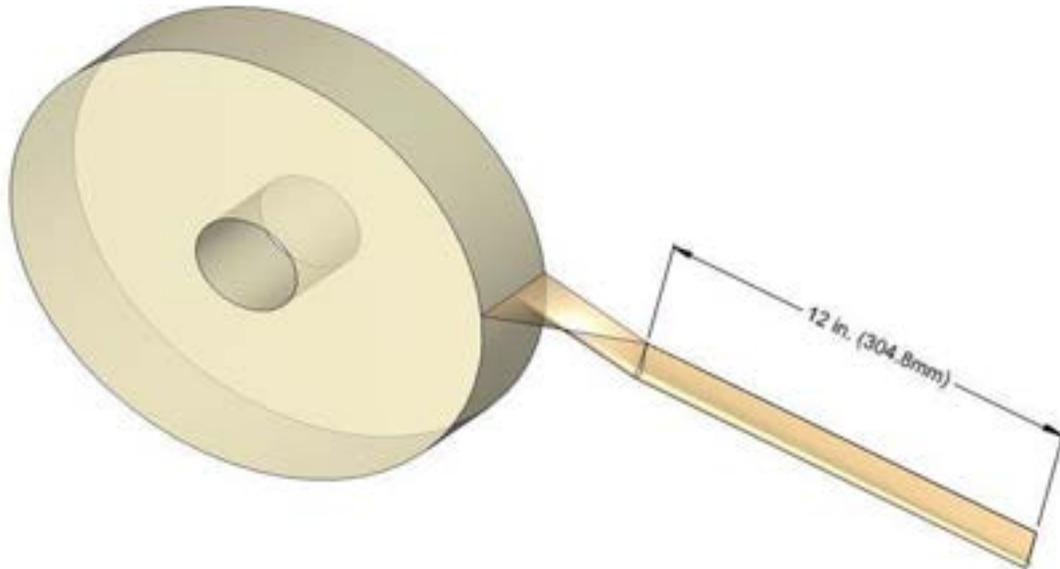


Figure 4-7 Tape Threading Preparation

4.8 TAPE THREADING



WARNING: TURN OFF ELECTRICAL POWER SUPPLY AND DISCONNECT THE POWER CORD FROM THE ELECTRICAL SUPPLY BEFORE BEGINNING TO WORK ON THE TAPE HEADS OR TO LOAD TAPE. IF POWER CORDS ARE NOT DISCONNECTED, SEVERE INJURY TO PERSONNEL COULD RESULT. THE KNIFE CONTAINED IN THE TAPE HEAD IS EXTREMELY SHARP. USE CAUTION WHEN REMOVING THE BLADE GUARD AND THREADING THE TAPE TO AVOID PERSONNEL INJURY.

4.8.1 Upper Tape Head

1. Remove the blade guard from the knife in the Tape head.
2. Follow the Tape Threading Diagram on the side plate of the ETX Tape Head.
3. See your Tape Head manual for further information if required.

4.8.2 Lower Tape Head

1. Lift Top tape Head Box to the uppermost position by activating the “**BLOCKED**” selector switch on the control box.
2. Remove the Lower tape Head by grasping the tape application rollers and lifting straight up.
3. Remove the blade guard from the knife in the Tape head.
4. Follow the Tape threading diagram on the side plate of the ETX Tape Head.
5. See your Tape Head manual for further information if required.
6. Replace the Lower tape head in the machine.
7. Turn off the “**BLOCKED**” selector switch.

Notes

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Chapter 5

OPERATING INSTRUCTIONS

5.1 OPERATING PROCEDURES

Once the ETX Tape Heads, (both bottom and top) have been loaded with tape and threaded the machine is ready to process RCS cases. The following instructions are presented in **the order recommended** for processing cases successfully through the RSA 2625-TB Case Sealing machine.

WARNING: ENSURE THAT THE OPERATOR'S HANDS ARE AWAY FROM THE CONTACT AREA BETWEEN THE INFEED GUIDES AND THE CASE.

1. Activate air Supply (3 C.F.M. at 80 PSI).
2. Switch the machine on with START push button.
3. Place case with flaps held in closed position on the Infeed Table up to sensor #1. Sensor will detect case and the Infeed Guides will center the case.
4. Push case with flaps held in closed position against the Front Sensing Paddle at the front of the Top Belt Drive Assembly.
5. This will raise the Top Belt Drive Assembly.
6. Push the rear of the case until it is between the top and bottom drive belts.
7. When the case exits the Case Sealer, the Top Belt Drive Assembly will go down to its initial position.
8. The Case Sealer is now ready to process the next case.

Chapter 6

TROUBLESHOOTING

The RSA 2625-TB Random Semi-Automatic 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 table. If the problem you encounter is not discussed in this table, call toll-free (877) 447-4832 Interpack [Technical Support](#). Toll-free (877) 447-4832

Trouble	Possible Causes	Solutions
The main power is turned on and nothing happens.	One of the fuses is burned.	Verify all fuses in the electric box.
The machine is ON but the Infeed Guides do not center the case on the Infeed Table.	Compressed air supply is not connected. The air tubing or the valve is obstructed or defective.	Inspect air connection and operating pressure. Inspect the air tubing and the valve for leaks or obstructions.
The Infeed Guides closes when the machine is powered up even when there is no case on the Infeed Table.	The Infeed Table's Sensor is not aligned with his reflector.	Check the alignment of the Infeed Sensor with his reflector.
The Top Belt Drive Assembly stays up or goes down too slowly.	The High Flow Pressure Regulator is adjusted too high.	Reduce the air pressure setting of the High Flow Pressure Regulator, located at the infeed end of the machine, under the left hand Side Cover.
The Top Belt Drive Assembly goes down too quickly or crushes the case.	The High Flow Pressure Regulator is adjusted too low.	Increase the air pressure setting of the High Flow Pressure Regulator, located at the infeed end of the machine, under the left hand Side Cover.
The Top Belt Drive Assembly raises too slowly.	The inlet pressure is too low. The moving parts are rubbing on something.	Adjust the inlet pressure on the main regulator to 80 psi and make sure that the pressure doesn't fall below 70 psi while it is operating. Inspect the Top Belt Drive Assembly to make sure that nothing interferes with them.
The Top Belt Drive Assembly does not rise when the case pushes the Front Sensor Plate.	The Proxy Sensor behind the sensor plate is too far from the Front Sensor Plate.	Remove the Front Sensor Plate and adjust the position of the Proxy Sensor by moving it by 1/16", then replace the Front Sensor Plate and verify proper operation. Make sure that the sensor does not touch the Front Sensor Plate.
The cases are not taped properly.	The tape head is not adjusted correctly.	Refer to the tape head manual.

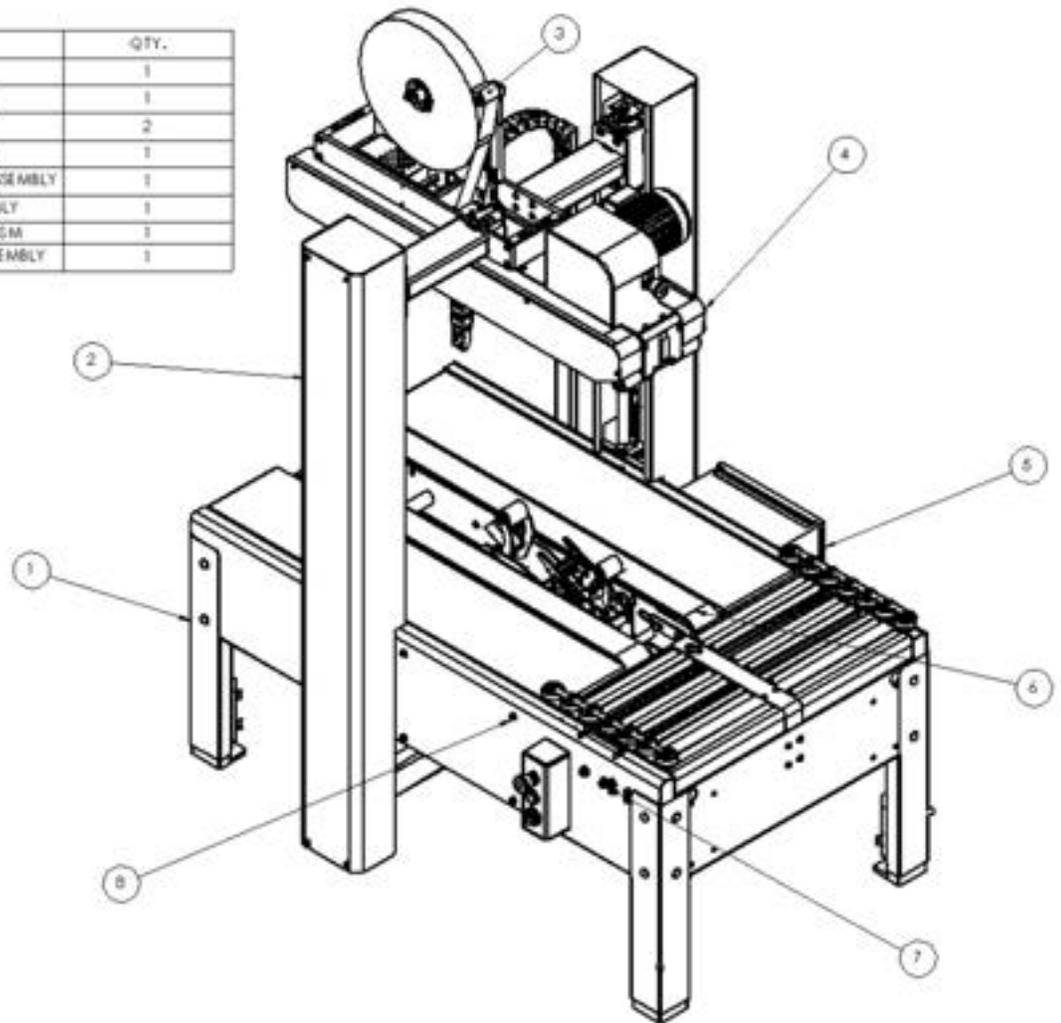
CHAPTER 7 **ILLUSTRATED PARTS LIST**

List Of Assemblies

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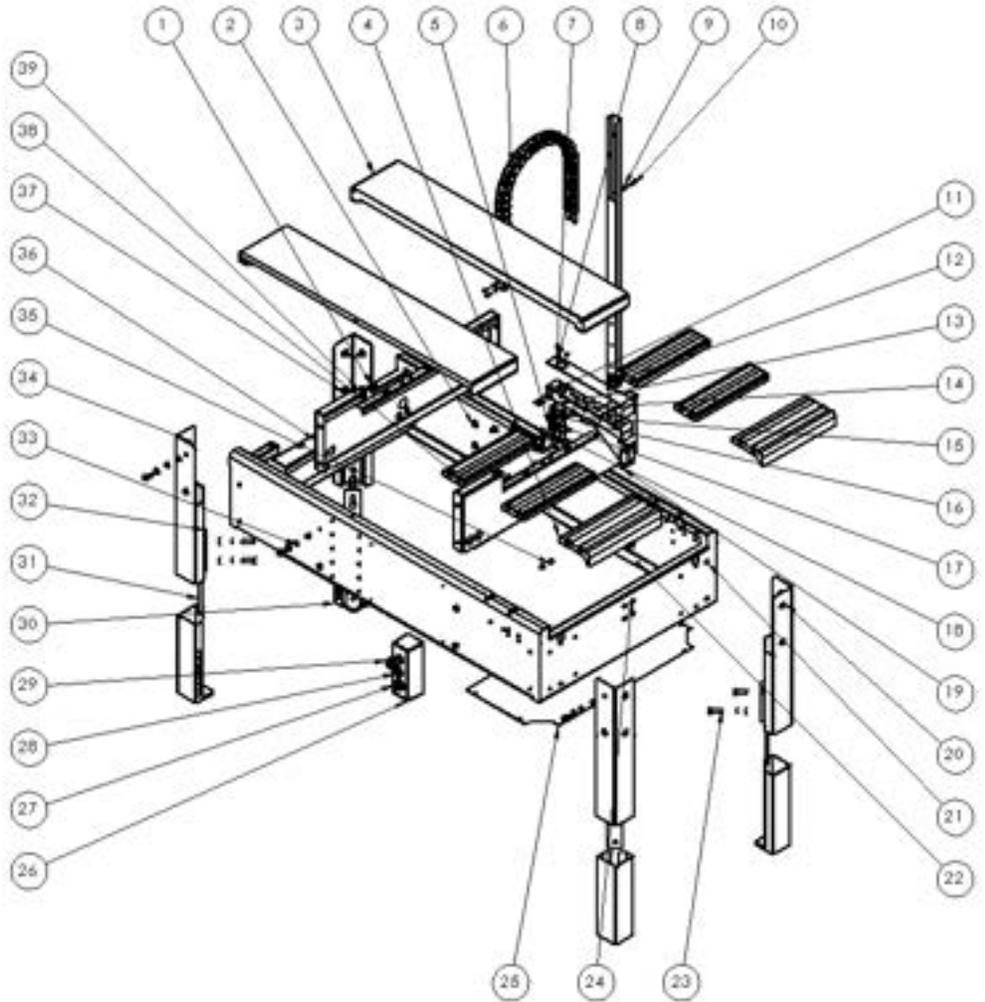
7.1 UMXXX – RSA2625-TB TOP LEVEL ASSEMBLY

ITEM NO.	Part#	DESCRIPTION	QTY.
1	USM0082	BASE ASSEMBLY	1
2	USM0073	COLUMN ASSEMBLY	1
3	UH2201	ET-III	2
4	USM0079	TOP BELT ASSEMBLY	1
5	USM0411	ELECTRIC CONTROL BOX ASSEMBLY	1
6	USM0080	BOTTOM DRIVE ASSEMBLY	1
7	USM0078	CENTERING MECHANISM	1
8	USM0081	PNEUMATIC CONTROL ASSEMBLY	1

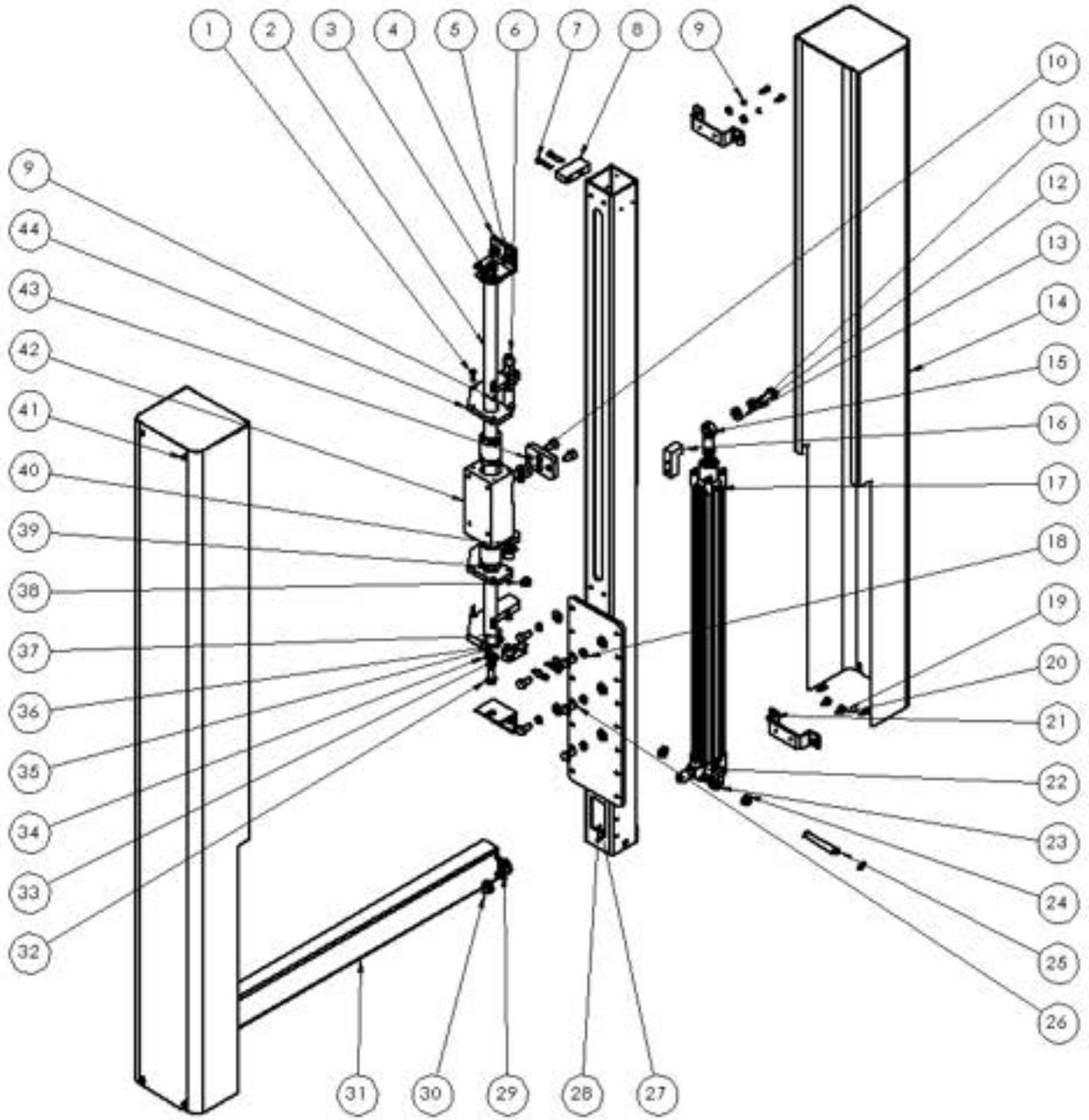


7.2 USM0882 – BASE ASSEMBLY

ITEM NO.	Part#	DESCRIPTION	QTY.
1	UF3391	SS NYLON LOCK NUT M6-T.0	6
2	UF0066	SHCS M6-T x 8mm	13
3	UPM6472	BELT SIDE COVER	2
4	UAM0541	FRONT ROLLER SET	2
5	UF5204	SHCS M6-T 25-20mm	2
6	UPM6479	DRAG CHAIN	1
7	UPM6474	CENTER SUPPORT	1
8	UF6305	HRC'S M5 X 0.8 X TORMM	4
9	UF5900	NYLON LOCK NUT M6-T.0	4
10	UF1216	BHCS M6-T 0-12mm	4
11	UP9154	SHCS M5 X 0.8 X T2	6
12	UPM6471	CABLE RAIL BRACKET	1
13	UF3687	BHCS M5-0.8 X 12MM	2
14	UF7023	LW 5MM	6
16	UPM3240	SENSOR SUPPORT	1
18	UF1827	FWMS	6
17	UPM6478	SENSOR	1
18	UPM6475	ROLLER COVER SUPPORT SEAT	1
19	UPM6473	CENTERING SUPPORT SEAT	1
20	UF4020	SS CARRIAGE BOLT 3/8-T x 1	24
21	UPM6469	BASE FRAME WELDMENT	1
22	UF5601	BHCS M5 X 0.8 X 6 LG	7
23	UF6393	HRC'S M12-T 75-35mm	8
24	UF0093	BHCS M6-T 25-16mm	4
25	UPM6477	BASE BOTTOM COVER	1
26	UPM6480	CONTROL BOX HOUSING	1
27	UPM4517	SELECTOR SWITCH	1
28	UPM5704	START SWITCH	1
29	UPM5703	Emergency Button 22.5mm lead	1
30	UPM0647	LEG ADJUSTMENT	4
31	UPM0931	LEG FRICTION PLATE	4
32	UPM2830	LEG BASE	4
33	UF6371	M10/LW	27
34	UF1821	FWMS	51
35	UF0063	NYLON LOCK NUT M6-T.25	6
36	UPM6470	BASE FRAME REINFORCEMENT	2
37	UF6371	LW M10	14
38	UAM0542	REAR ROLLER SET	4
39	UF1540	HRR 3/8-16	30
40	UPM6481	MAGNET Ø25 x Ø5.5 x 8mm	2



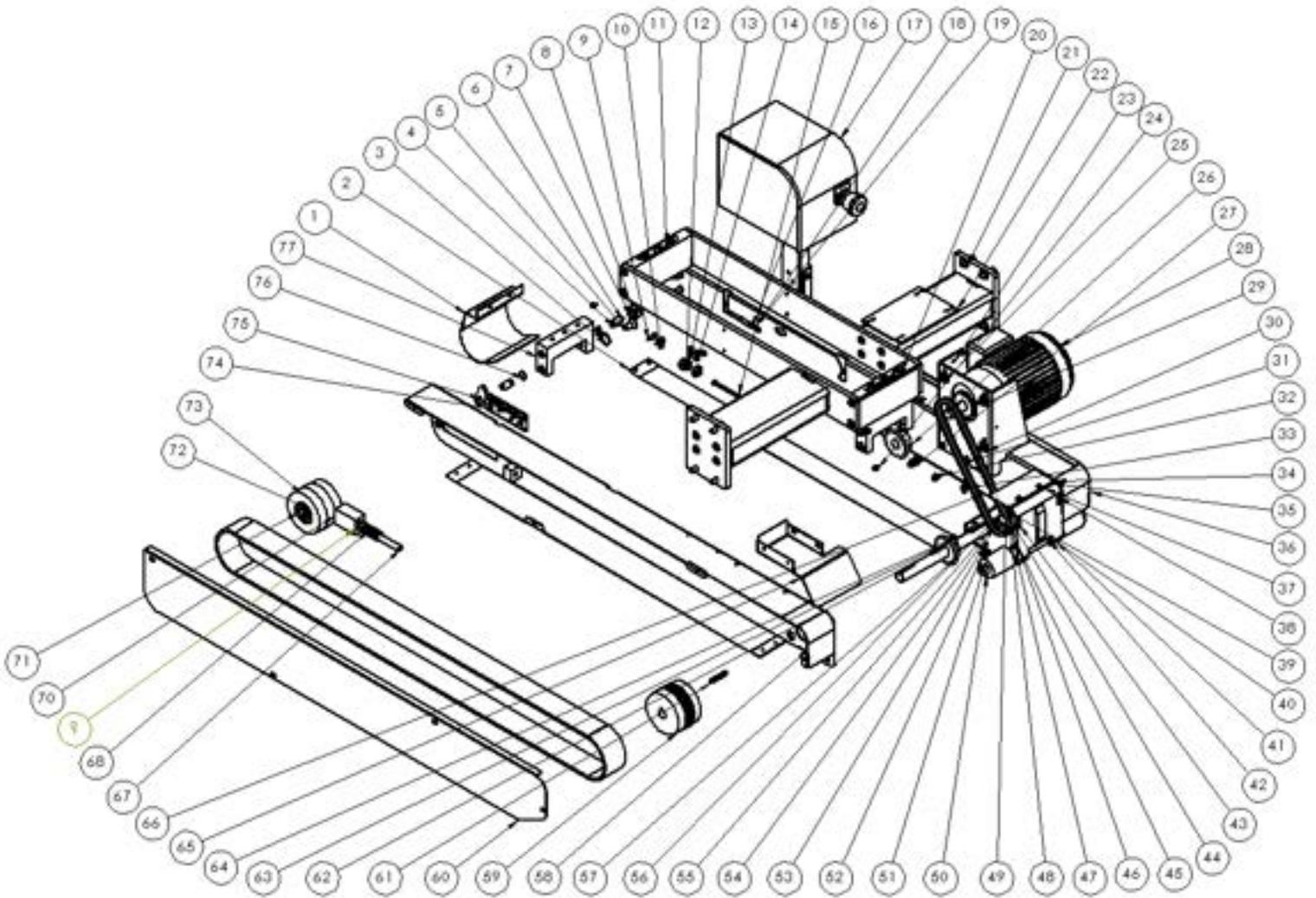
7.3 USM0873 – COLUMN ASSEMBLY



ITEM NO.	Part#	DESCRIPTION	QTY.
1	UF9172	SS BHCS M5-0.8 x 20	16
2	UPM6419	LINEAR AXE ROD	2
3	UPM4180	SS SHAFT COLLAR METRIC 25mm	2
4	UPM6415	MANDREL FIXING PLATE	4
5	UF1821	FWMB	8
6	UPM6424	SHOCK ABSORBER UPPER	2
7	UF3739	SS SHCS M6-1 X 30mm	14
8	UPM6412	UPPER BLOCK	2
9	UF7023	LW5MM	30
10	UF3648	M10-1.5-SHCS	4
11	UF4231	M12 FW	2
12	UF0125	HHCS M12-1.75 X 30MM	2
13	UF3733	SS LW M12	2
14	UPM6406	COLUMN COVER L&R	2
15	UPM6420	12MM ROD END BEARING RH	2
16	UPM6413	LIFT CONNECTION BLOCK	2
17	UPM6421	AIR CYLINDER 600MM	2
18	UF6371	M10 LW	14
19	UF0799	SHCS M5-0.8 X 16MM	8
20	UF1827	FW REG M5	8
21	UPM6405	COVER BRACKET	4
22	UPM6426	CHECK VALVE	2
23	UPM6422	CYLINDER MOUNT	2

ITEM NO.	Part#	DESCRIPTION	QTY.
24	M3222	20MM X 12.5MM X 7MM SPACER	4
25	UPM6404	CYLINDER PIN	2
26	UF0457	HHCS M10-1.25 X 20	12
27	UPM6402	LEFT AND RIGHT SIDE COLUMN	2
28	UF7017	SS RET'G RING EXTERNAL 12mm	4
29	UPM6428	90° 10mm-8mm QUICK CONNECTOR	2
30	UPM6427	90° 8mm-7mm QUICK CONNECTOR	2
31	UPM6414	COLUMN SUPPORT CROSSBAR	1
32	UF6382	HHCS M10-1.5 x 25 mm	4
33	UPM6406	LOCK BLOCK	2
34	UF680	M10 FW	16
35	UF0867	LWMB	8
36	UF3755	SS SHCS M6-1.25 x 20mm	12
37	UPM6407	LOWER BLOCK	2
38	UPM6428	SILENCER	2
39	LM 25UU	LINEAR BEARING 25 mm	4
40	UPM6423	SHOCK ABSORBER LOWER	2
41	UF1250EV	BHCS M6-1 x 16	8
42	UPM6416	LINEAR BEARING SLIDER	2
43	UPM6417	SLIDER CONNECTING PLATE	2
44	UPM6418	BEARING SEAT COVER	4
45	UF0103	FWM6 OVERSIZED, 19mm OD, 2mm THK	4

7.4 USM0879 – TOP BELT ASSEMBLY

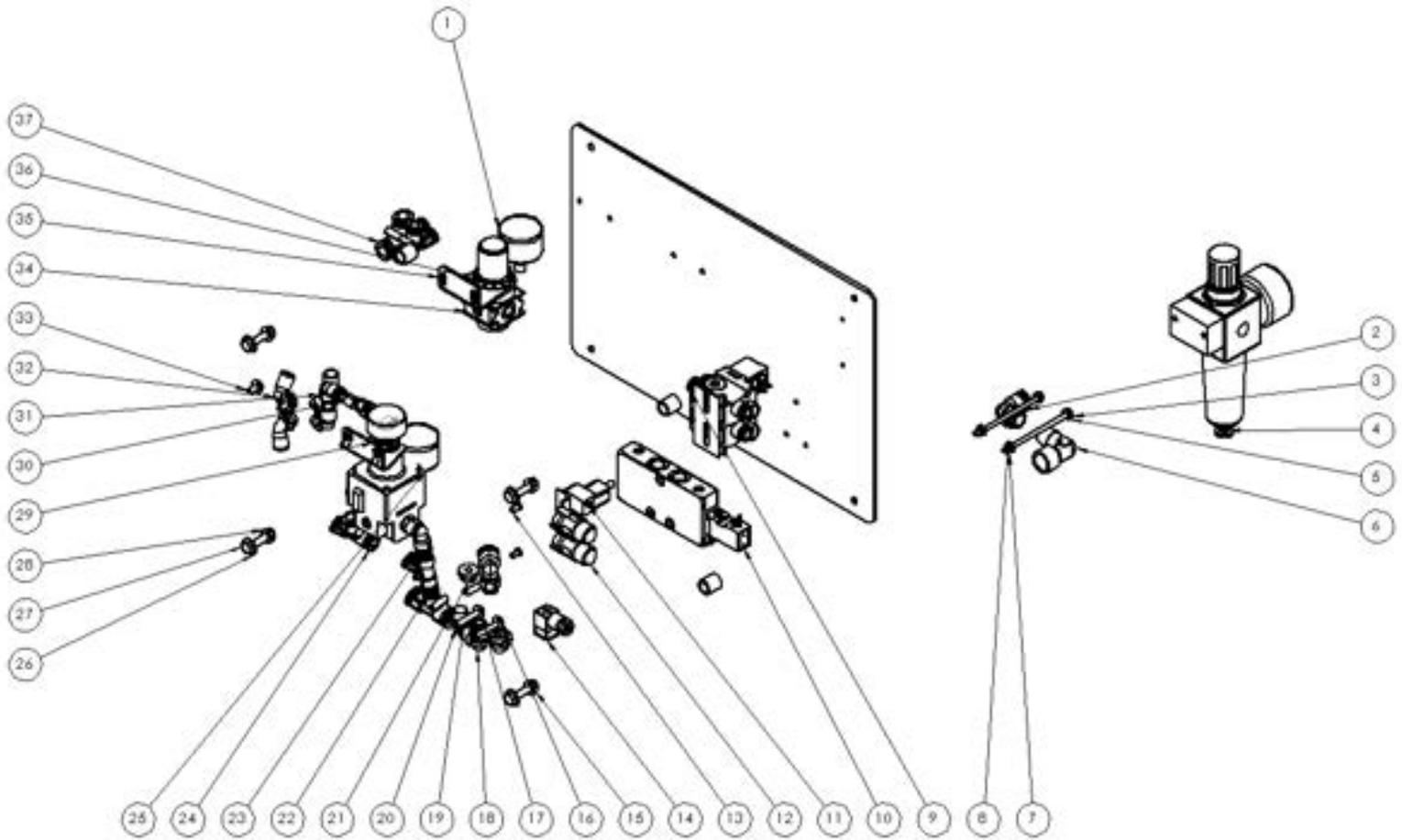


ITEM NO.	Part#	DESCRIPTION	QTY.
1	UPM6307	SENSOR PLATE	1
2	UPM6321	STRIP	2
3	UF2220EV	EXT RETG. RING 19mm	2
4	UPM6316	ADJUSTER MANDREL	2
5	UF6397	FHC5 M10-1.5 X 20MM	2
6	UF1042	FHC5 M6 X 1 X 12	2
7	UPM6315	BELT TENSIONER LH	1
8	UF6804	FHC5 M8-1.25 X 16	8
9	UF0960EV	FHC5 M6 X 16L	4
10	UF1411	SSS M6 X 6	5
11	UF0667	M8 LW	10
12	UF1540	HEX NUT G52 3/8-16	6
13	UF6893	FHC5 M4-0.7 X 20	4
14	UF6376	NYLON LOCK NUT M4-0.7	4
15	UF0121	SHCS M5-0.8 X 55MM	2
16	UPM6312	SPRING HOLDER BLOCK	2
17	UPM6308	UPPER CHAIN COVER	1
18	UF3393	NYLON LOCK NUT M5-0.8	2
19	USM0876	TOP BELT DRIVE SUB ASSY RH	1
20	UF0124	M8-1.25-75L	6
21	USM0874	BRIDGE ASSEMBLY	1
22	UPM6310	UPPER SEAT COVER	1
23	UF6887	BHC5 M5-0.8 X 12MM	2
24	UF6601	BHC5 M5 X 0.8 X 6 LG	16
25	UF5900	NYLON LOCK NUT M6-1.0	4
26	UPM6318	DRIVE SPROCKET	1
27	UF1827	FW REG M5	6
28	UPM7115	MOTOR T1/4 21.4:1	1
29	UF4236	SHCS M6-1.0 X 30	4
30	UF0103	FW M6 OVERSIZED, 19mm OD, 2mm THK	8
31	UF7023	M5 LW	6
32	UP9154	SHCS M5 X 0.8 X 12	4
33	UF0086	SHCS M6-1 X 8	2
34	UPM6335	FRONT COVER	1

ITEM NO.	Part#	DESCRIPTION	QTY.
35	UPM2129	SENSOR FLT. PIVOTBLCK. TBD-2/3	2
36	UPM6325	BELT GUARD RIGHT	1
37	UPM6333	CONTACT BLOCK	1
38	UF6352	FHC5 M4-0.7 X 6MM	2
39	UPM6350	BUSHING 20X23X10	2
40	UPM6328	SPINDLE ROLLER	1
41	UPM6329	Sensor plate c/w boss	1
42	UPM6331	MID ROLLER FOR SENSOR PLATE	1
43	UF5401	FHC5 M4 X 0.7 X 8 LG	2
44	UPM6330	SENSOR PLATE SHAFT	1
45	UF4314	RETAINING RING, EXTERNAL 12	2
46	UF6680	M10 FW	2
47	UF6371	M10 LW	2
48	UF0457	HHC5 M10-1.25 X 20	2
49	UF0666	HEX NUT M8	4
50	UF0123	M12 SHOULDER SCREW	2
51	UPM6332	SIDE ROLLER FOR SENSOR PLATE	2
52	UF0119	FHC5 M5-0.8 X 6MM	2
53	UPM6313	BOTTOM SIDE COVER	1
54	UF0091	FHC5 M8-1.25 X 25	4
55	UPM6311	DRIVE SHAFT	1
56	UPM6320	CHAIN	1
57	UPM6319	SPROCKET	1
58	USM0875	TOP BELT DRIVE SUB ASSY LH	1
59	UPM4450	DRIVE PULLEY	2
60	UPM6324	BELT GUARD LEFT	1
61	UPM6323	SQUARE KEY ROUND ENDS 5X5-40	2
62	UPM6322	SQUARE KEY ROUND ENDS 5X5-30	1
63	UF6691	Pop Rivet 4mm	8
64	UF6683	SSS M6 X 10 MM	5
65	UPM6309	REINFORCEMENT COVER PLATE	1
66	UPM6334	DRIVE BELT 50X2020	2
67	UF1400	TENSIONER ROD	2
68	UPM0112	SPRING LOCATOR PIN	2

ITEM NO.	Part#	DESCRIPTION	QTY.
69	UPM0038	DIE SPRING (DRIVE BASE)	2
70	UPM0101EV	TENSIONER SPRING HOLDER	2
71	UPM1233	IDLER SHAFT	2
72	UPM0324	BEARING PULLEY	4
73	UPM0259	IDLER PULLEY	2
74	UPM6074	TENSIONER SLIDE	2
75	UPM6314	BELT ADJUSTER RH	1
76	UPM5809	SNAP RING 12MM	2
77	UPM6306	UPPER CONNECTING BLOCK	2
78	UPM0011	SPRING BLADE	1
79	UPM6317	SPACER	2
80	UPM0733	MOUNTING BRACKET FOR M18 SENSOR	1
81	UPM2635	SS COMP SPRING SWIVEL TH. ASSY	1
82	UPM0069	FLANGE BEARING 3/4" ID	1
83	UPM6364	FRONT PADDLE SENSOR	1
84	UF5408	SHCS M3 X 12	2
85	UF3718	M8 LW	2
86	UF6374	BHC5 M4-0.7X6	1
87	UF6681	M4 LW	3
88	UF6649	BHC5 M4-0.7 X 12	2
89	UF0115	FW M6 OVERSIZED, 16mm OD, 1mm THK	2

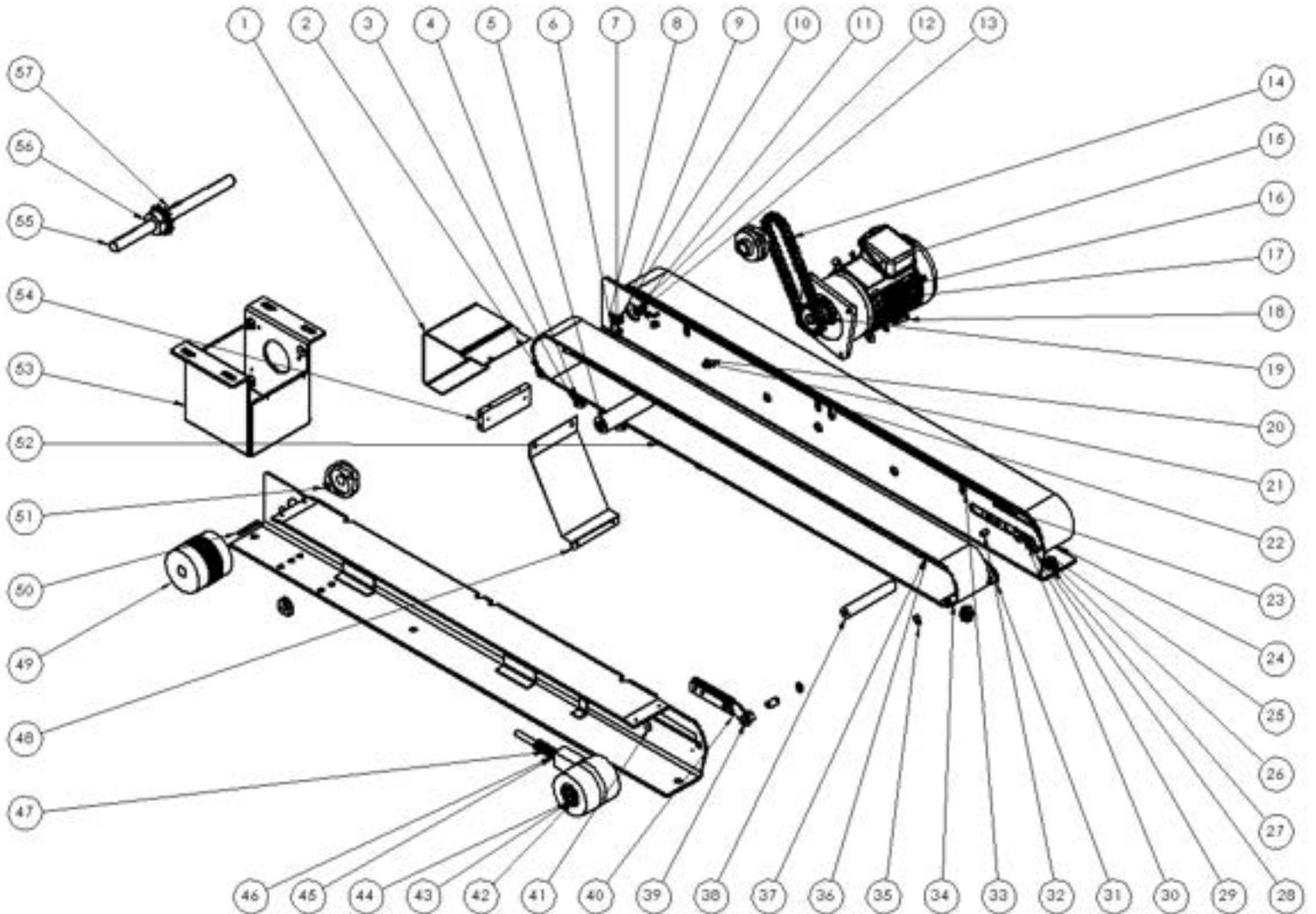
7.5 USM0411 – ELECTRIC CONTROL BOX ASSEMBLY



ITEM NO.	Part#	DESCRIPTION	QTY.
1	UPM3273	PRESSURE GAUGE G1/8	2
2	UPM6466	90° QUICK CONNECTOR 10mm	1
3	UF3694	BHCS M4-0.7 X B0	2
4	UPM3267	FILTER REGULATOR NL2 G3/8 0.2 BAR	1
5	UF0115	FWM4 OVERSIZED, 10mm OD, 1mm THK	4
6	UPM3175	ELBOW BRSS NKL PLT G3/8M x G3/8F	1
7	UF4237	HEX NUT M4-0.7	2
8	UF3681	M4 LW	2
9	UPM3394	VALVE 5/2 MAN. ADJUSTABLE 24V PE	1
10	UPM6455	SOLENOID VALVE	1
11	UPM6454	WIRE CONNECTOR	1
12	UPM3391	SILENCER VALVE	2
13	UF3685	BHCS M4-0.7 X B	2
14	UPM6456	SOLENOID CONNECTOR	1
15	UF5900	NYLON LOCK NUT M6-1.0	4
16	UF7023	M5 LW	7
17	UF1827	FWREG M5	7
18	UPM6458	90° QUICK CONNECTOR 8mm X 10mm	2
19	UPM6171	SILENCER	1

ITEM NO.	Part#	DESCRIPTION	QTY.
20	UF3093	BHCS M5-0.8 X 30MM	3
21	UPM6459	PLUG G1/4"	1
22	UPM6464	T REDUCING QUICK COUPLING 10mm-8mm	1
23	UPM6467	EXT. TOOTH 90° QUICK CONNECTOR	2
24	UPM6460	TEE QUICK CONNECTOR 8mm	3
25	UPM7736	ELBOW BRSS	2
26	UF0126	FW M6-1.6-1.0	4
27	UF0128	HCS M6-1.0 X 30	4
28	UF0127	FW M6-1.3-1.0	4
29	UPM6457	PRECISION PRESSURE REGULATOR	1
30	UPM6462	Y REDUCING QUICK PLUG 6mm-4mm	1
31	UPM6463	90° REDUCING QUICK PLUG 5.5mm-6mm	1
32	UPM3124	ELBOW FTG. SWVL G1/4	4
33	UF3687	BHCS M5-0.8 X 12MM	4
34	UPM3268	PRESSURE REGULATOR MANFOLD	1
35	UPM3271	MOUNTING BRACKET NL1	1
36	UPM3272	CONTROL PANEL NUT	1
37	UPM6461	TEE QUICK CONNECTOR 10mm	1
38	UPM6465	Ø4mm PLUG	1

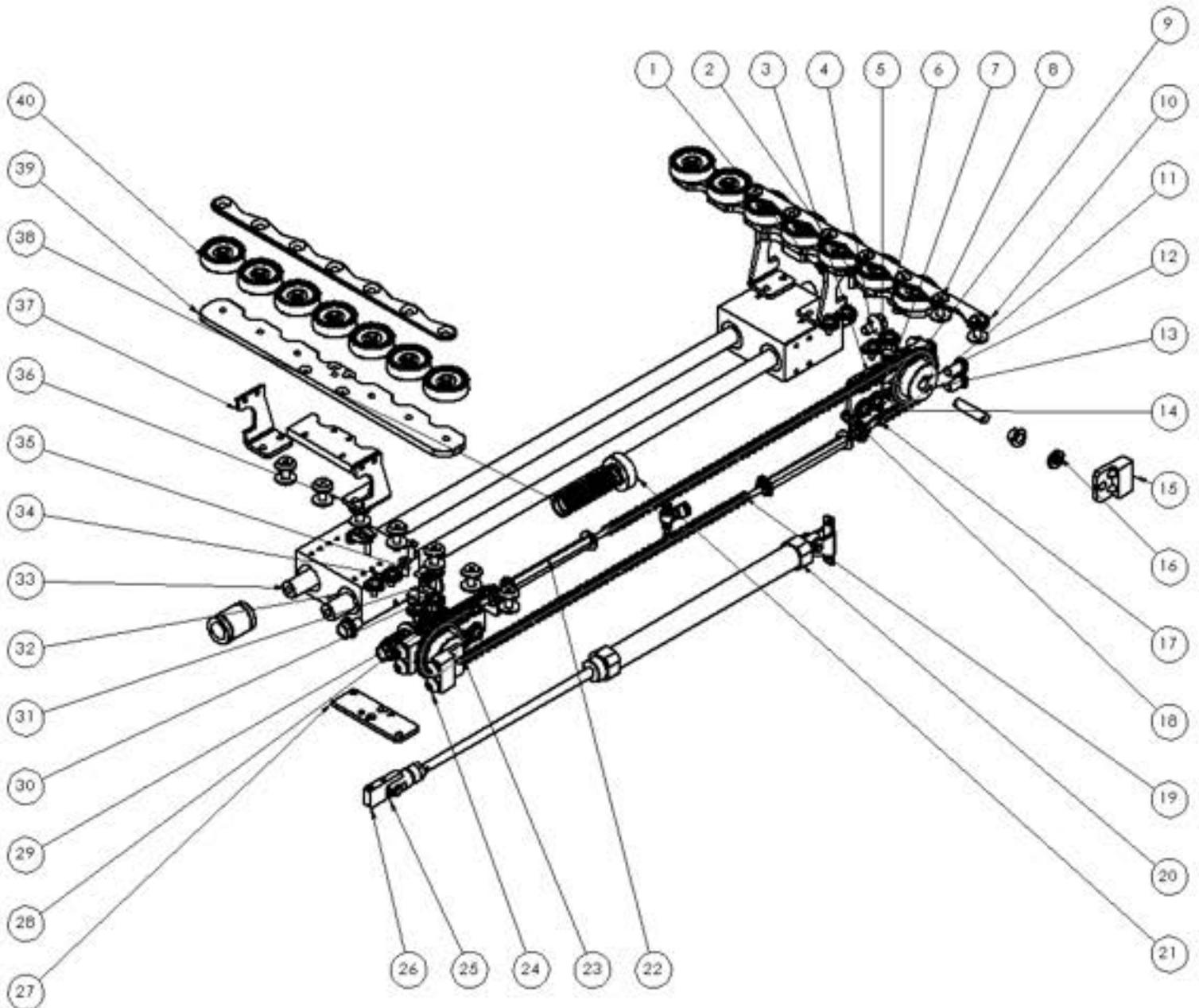
7.6 USM0880 – BOTTOM DRIVE ASSEMBLY



ITEM NO.	Part#	DESCRIPTION	QTY.
1	UPM6385	BACK CHAIN GUARD	1
2	UF6371	M10 LW	12
3	M10-1.5	M10-1.5-HNR	4
4	UF3647	HHCS M10 X 1.25 X 25	4
5	UPM6393	SPACER - 1.25" DIA	1
6	UF0960EV	FHC5 M6 X 16L	8
7	UF0115	FW M6 OVERSIZED, 10mm OD, 1mm THK	6
8	UF1411	SSS M6 X 6	3
9	UF3685	BHC5 M4-0.7 X 8	6
10	UF3683	SSS M6 X 10 MM	5
11	UF0866	HEX NUT M6	4
12	UF0867	M6 LW	4
13	UF0091	FHC5 M6 - 1.25 X 25	4
14	UPM6397	CHAIN #40	1
15	UPM7116CD	MOTOR 1/3 HP 124,1	1
16	UF6363	M6 LW	4
17	UF0103	FW M6 OVERSIZED, 19mm OD, 2mm THK	4
18	UF0630EV	BHC5 M6 X L25	4
19	UPM6396	#40 12T 18 W/ 5mm KEY	1
20	UPM6394	CUSTOM WASHER	2
21	UF6382	HHCS M10-1.5 X 25 MM	2
22	UAM0539	BOTTOM BELT DRIVE SECTION RH	1
23	UPM1234	COMPRESSION BLOCK	2
24	UPM6398	BELT DRIVE 3" X 84.1"	2
25	UPM4070	IDLER PULLEY	2
26	UF4006	VG/B-16-3/4"-CARRIAGE BOLT	6
27	UF3680	M10 FW	16
28	UF1042	FHC5 M6 X 1 X 12	2
29	UPM0109	IDLER PULLEY SPACER	2

ITEM NO.	Part#	DESCRIPTION	QTY.
30	UF6397	FHC5 M10-1.5 X 20MM	2
31	UPM6314	BELT ADJUSTER RH	1
32	UF3684	FHC5 M6-1.25 X 16	2
33	UF1540	HEX NUT G.52 3/8-16	12
34	UPM6316	ADJUSTER MANDREL	2
35	UPM5809	SNAP RING 12MM	2
36	UPM6399	STRIP UHM W 3" X .03"THK	2
37	UF3691	Pop Rivet 4mm	8
38	UPM6391	SPACER .75" DIA	1
39	UPM6315	BELT TENSIONER LH	1
40	UPM6392	TENSIONER SLIDE	2
41	UAM0538	BOTTOM BELT DRIVE SECTION LH	1
42	UF2220EV	EXT REPC RING 3/4" SHAFT	2
43	UPM4072	IDLER SHAFT	2
44	UPM0324	BEARING PULLEY	4
45	UPM0038	DIE SPRING (DRIVE BASE)	2
46	UPM0112	SPRING LOCATOR PIN	2
47	UF1400	TENSIONER ROD	2
48	UPM6388	FRONT CHAIN GUARD	1
49	UPM4069	DRIVE PULLEY	2
50	UPM6401	SQUARE KEY ROUND ENDS	2
51	UPM0069	FLANGE BEARING 3/4" ID	2
52	UF3681	M4 LW	6
53	UPM6389	MOTOR BOX DRIVE	1
54	UPM6390	GUARD MOUNTING BLOCK	1
55	UPM6299	DRIVE SHAFT	1
56	UPM6395	#40 12T .75 BORE W/ KEY	1
57	UPM6400	SQUARE KEY ROUND ENDS	1
58	UF3716	SSS M5 X 10MM	1
59	UF3731	SSS M5-0.8 X 6MM	1

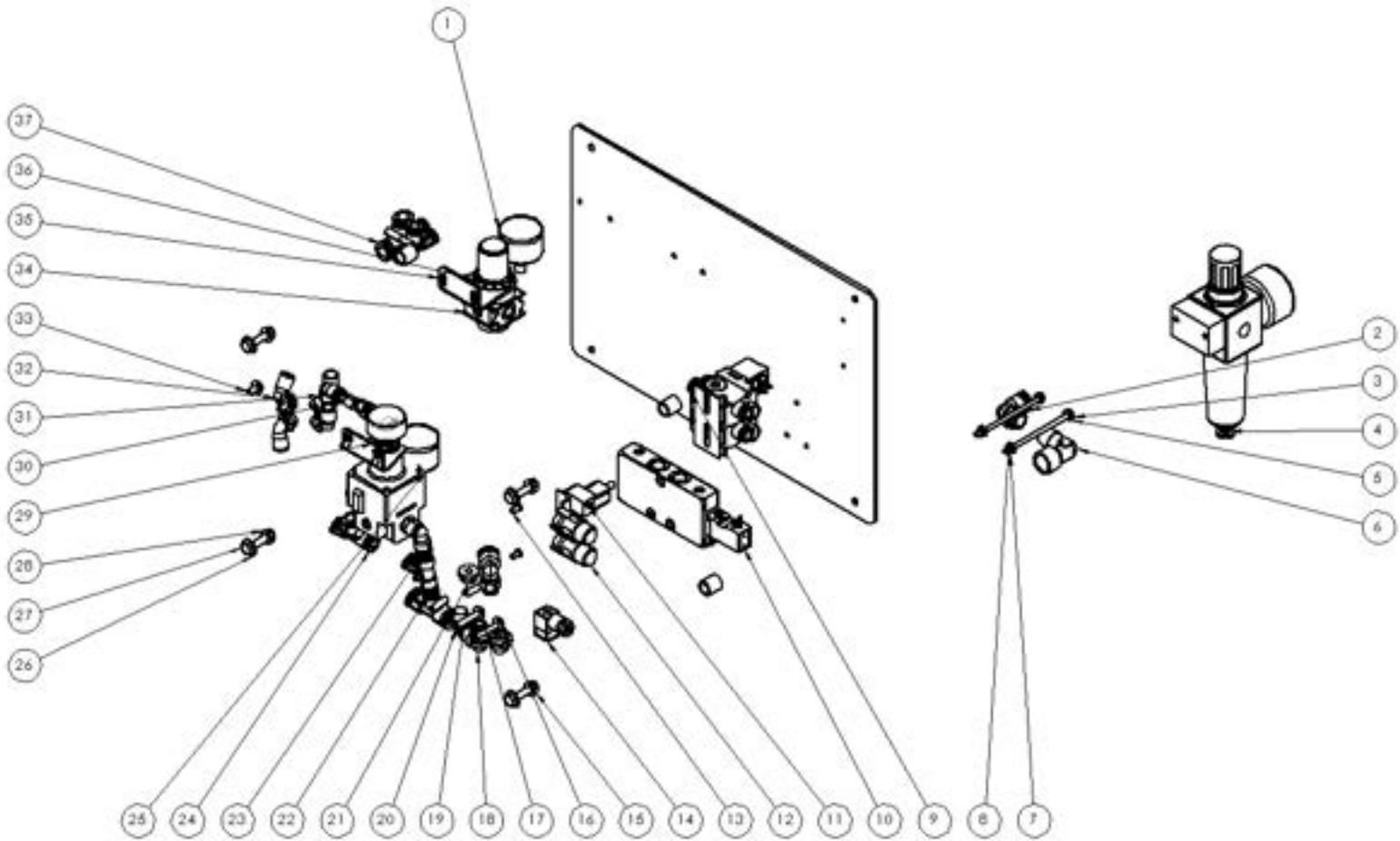
7.7 USM0878 – CENTERING MECHANISM



ITEM NO.	Part#	DESCRIPTION	QTY.
1	UPM6439	MOUNTING PLATE	2
2	UF3237	SS FHC S M6-1 X 20	8
3	UF1821	FW MB	56
4	UF3679	HHCS M10-1.5 X 20 mm	4
5	UPM6438	BTM CHAIN ADAPTOR BRACKET	1
6	UF3148	M5-0.8 X 16 SHCS	8
7	UF3391	SS NYLON LOCK NUT M6-1.0	2
8	UF6329	M6-1.25 X 30MM FHC S	14
9	UPM6445	CHAIN #35 619MM	2
10	UPM6441	TOP ROLLER PLATE	2
11	UPM6444	SPROCKET #35, T20 14mm BORE	2
12	UPM1788EV	FLANGE BEARING BRONZE 375 X 75	4
13	UF6400	SHCS M3-0.5 X 8	4
14	UF3187	SS SHCS M6-1 X 16 mm	23
15	UPM6430	SPROCKET SUPPORT	4
16	M3222	20MM X 12.5MM X 7MM SPACER	4
17	UPM3260	CHAIN THREADED LINK RH	2
18	UPM6447	SPEED CONTROL JOINT	2
19	UPM3259	THREADED LINK	2
20	UPM6448	250MM STROKE AIR CYLINDER	1

ITEM NO.	Part#	DESCRIPTION	QTY.
21	UF9150	20MM SPLIT COLLAR SHAFT	1
22	UPM3255	TURNBUKLE	2
23	UPM1803	SPROCKET FIXED SHAFT	2
24	UF4252	BHC S M10-1.5X20MM	8
25	UPM6451	CYLINDER UPPER MOUNT	1
26	UPM6435	LINK PLATE #2	1
27	UPM6440	LINK PLATE #1	1
28	UF3282	SS FHC S M5-0.8 X 12 mm	2
29	UPM1809	TOP CHAIN ADAPTOR BRACKET	1
30	UPM6442	ANTI-COLLISION GASKET	2
31	UF6371	LW M10	8
32	UPM6449	20MM LINEAR BEARING	8
33	UPM6450	20MM LINEAR SHAFT	2
34	UF6371	M10 LW	32
35	UPM6434	CROSS SHAFT BLOCK	2
36	UPM6432	SPACER FOR ROLLER PLATE (LEFT)	2
37	UPM6433	SPACER FOR ROLLER PLATE (RIGHT)	2
38	UPM6443	SPRING FOR 20MM SHAFT	2
39	UPM6436	BOTTOM ROLLER PLATE	2
40	UPM6446	48MM ROLLER WHEEL	14

7.8 USM0881 – PNEUMATIC CONTROL ASSEMBLY



ITEM NO.	Part#	DESCRIPTION	QTY.
1	UPM3273	PRESSURE GAUGE G1/8	2
2	UPM6466	90° QUICK CONNECTOR 10mm	1
3	UF3694	SHCS M4-0.7 X 80	2
4	UPM3267	FILTER REGULATOR NL2 G3/8 0.2 BAR	1
5	UF0115	FWM4 OVERSIZED, 10mm OD, 1mm THK	4
6	UPM3175	ELBOW BRSS NKL PLT G3/8M x G3/8F	1
7	UF4237	HEX NUT M4-0.7	2
8	UF3681	M4 LW	2
9	UPM3394	VALVE 5/2 MAN, ADJUSTABLE 24V PE	1
10	UPM6455	SOLENOID VALVE	1
11	UPM6454	WIRE CONNECTOR	1
12	UPM3391	SILENCER VALVE	2
13	UF3685	BHCS M4-0.7 X 8	2
14	UPM6456	SOLENOID CONNECTOR	1
15	UF5900	NYLON LOCK NUT M6-1.0	4
16	UF7023	M5 LW	7
17	UF1827	FWREG-M5	7
18	UPM6458	90° QUICK CONNECTOR 8mm X 10mm	2
19	UPM6171	SILENCER	1

ITEM NO.	Part#	DESCRIPTION	QTY.
20	UF3093	BHCS M5-0.8 X 30MM	3
21	UPM6459	PLUG G1/4"	1
22	UPM6464	Y REDUCING QUICK COUPLING 10mm-8mm	1
23	UPM6467	EXT. TOOTH 90° QUICK CONNECTOR	2
24	UPM6460	TEE QUICK CONNECTOR 8mm	3
25	UPM7736	ELBOW BRSS	2
26	UF0126	FW M6-16-1.0	4
27	UF0128	BHCS M6-1.0 X 30	4
28	UF0127	FW M6-13-1.0	4
29	UPM6457	PRECISION PRESSURE REGULATOR	1
30	UPM6462	Y REDUCING QUICK PLUG 6mm-4mm	1
31	UPM6463	90° REDUCING QUICK PLUG 5.5mm-6mm	1
32	UPM3124	ELBOW FTG SWVL G1/4	4
33	UF3687	BHCS M5-0.8 X 12MM	4
34	UPM3268	PRESSURE REGULATOR MANIFOLD	1
35	UPM3271	MOUNTING BRACKET NLI	1
36	UPM3272	CONTROL PANEL NUT	1
37	UPM6461	TEE QUICK CONNECTOR 10mm	1
38	UPM6465	Ø4mm PLUG	1