

# TF 400VK

# TrayMatic

Parts Illustrations



The following are the standard illustrations and parts lists for a TF 400VK machine. Not all parts or illustrations shown apply to your specific machine. A set of prints, or inserts, unique to your machine will be created and mailed to you as soon as we complete them.

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**Thank you for choosing packaging equipment from SWF Companies.**



The equipment you purchased will provide years of productive service, producing a high return on your investment. Your equipment was thoroughly tested for proper operation prior to shipment.

Before unpacking and installing your new equipment, please read this manual. It is your guide to safe installation, productive operation, and effective maintenance. We recommend you keep this manual available for future reference.

Be aware that our commitment to you does not end with your purchase. That is just the beginning. The safe and efficient operation of your SWF equipment is very important to us as a machine manufacturer.

Training and parts distribution are an integral part of our business. SWF service technicians have spent months of in-plant hands-on training, prior to servicing our worldwide installations. Their expertise on our equipment is as close as your telephone. Given sufficient notice, service technicians are available for dispatch to your installation. We also maintain an extensive inventory of spare parts. We typically can have the parts you need in your plant the next working day.

**The entire family of SWF Companies, a Dover Diversified Company is committed to the success of your operation and thanks you again. Feel free to call us anytime.**

SWF Companies is committed to providing product manuals that meet the needs of its valued customers. We invite you to offer suggestions for continued improvement of this manual.

<p>To contact SWF Companies, Inc. Parts and Service</p> <p>Local .....(559) 638-8484</p> <p>Toll-Free.....(800) 344-8951</p> <p>Fax.....(559) 638-7478</p>	<p>Published by:</p> <p>SWF Companies, Inc. 1949 E Manning Ave Reedley, CA 93654 2003</p>
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# Spare Parts Ordering

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For General Information and Ordering Parts Contact:



1949 E Manning Ave • Reedley, CA 93654  
Tel. (559) 638-8484 • Fax. (559) 638-7478 • (800) 344-8951  
Web: [www.swfcompanies.com](http://www.swfcompanies.com)

Before contacting SWF Companies for parts or service, please know the machine model and serial number of your equipment. Locate the serial number, usually noted on a metal tag riveted to the frame. You need this serial number when ordering parts:

- 1) Included with this manual is a complete set of assembly drawings to assist you in locating your part. Locate the assembly the part is ordered for.
- 2) Once you have the assembly drawing, locate the item number of the part you want to order and write down the part number from the bill of materials.
- 3) When calling the SWF Companies for parts, have the following information ready:
  - (a) Machine model and serial number (Example: CE-300 TA, s/n CG00001 ).
  - (b) The assembly drawing number and description (CG-000150, vacuum lift arm).
  - (c) The item number, part number and description (item #16, 201806, male rod end bearing).

Following the above procedure assists us in supplying you with the correct parts for your machine and eliminates misunderstandings between your purchasing agent and our parts department.

The contact information below may be subject to change. Please refer to our website at: [www.swfcompanies.com/cs1.html](http://www.swfcompanies.com/cs1.html) for updated service department information.

## ***General Information***

1949 E Manning Ave • PO Box 548 • Reedley, CA 93654  
559-638-8484 • 559-638-7478 (Fax)  
800-344-8951 (USA Toll Free)  
Web: [www.swfcompanies.com](http://www.swfcompanies.com)

## ***Parts Sales Department***

800-344-8951 (USA Toll Free)  
559-638-7478 (Fax)  
[parts@swfcompanies.com](mailto:parts@swfcompanies.com)

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559-638-8484 ♦ 559-638-7478 (Fax)  
800-344-8951 (USA Toll Free)  
Service and Support 24/7 Mobile: 559-250-6046

Marty Silveiria, Keith Henvit, Alan Eastep

***Machine Upgrades and Conversions***

1949 E Manning Ave ♦ PO Box 548 ♦ Reedley, CA 93654  
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# Safety

Machinery can be hazardous if safety precautions are not followed. This section deals with safety rules and practices that **MUST** be followed for safe operation of the machinery and to prevent accidents from occurring. All operators and maintenance personnel working on or near SWF Companies' machinery should be fully informed and correctly supervised concerning safe and correct machine operation.

All equipment manufactured by SWF Companies is safety tested before shipping from the plant. Records of machine safety tests are filed at the plant. Safety equipment on SWF machines is also tested in the customer's plant when a SWF Service Representative assists in starting up newly installed machinery.

Be sure all supervisors read and fully understand the contents of the operation portion of this manual, with particular attention to safety precautions. Verify anyone working on or around the machine has read and fully understands the safety precautions noted throughout this manual.

- The responsibility for safe machine operation is shared among the employer, supervisor, operator, attendant, and all maintenance personnel working with the machine. Read the instructions. Re-read them periodically.
- Continually evaluate accident prevention procedures. This means ALL potential hazards must be identified, and eliminated or safeguarded. Along with creating safe conditions, all employees should follow safe practices.
- If any questions ever arise regarding the safe operation or maintenance of this machine, immediately contact:

SWF Companies  
1949 E. Manning Ave  
P.O. Box 548  
Reedley, CA 93654-0548

Phone: 559-638-8484  
Fax: 559-638-7478



## Equipment Safety

SWF machinery uses many safety devices designed to prevent injury to personnel who come in contact with the machine. All safety switches and devices should be checked daily to ensure that they operate properly. Any removal or alteration of these devices can result in serious injury.

### Guards

Guarding includes sheet metal fixed guards or transparent polycarbonate plastic. Hinged or sliding guard doors are installed in areas requiring easy access. Doors with safety interlocks automatically stop the machine by disconnecting the electrical power and dropping air from the machine when the door opens.

The electrical power and air pressure remain off until all guard doors are closed and the start-up sequence is followed.

### Emergency Stop

Emergency stop controls or "E-STOP" is a lighted push/pull button installed on each operator control panel. The pulled-out (on) position allows for operation. The pushed-in (off) position of any e-stop button causes a complete machine shut-down by shutting off power and air to the machine.

The dump valve releases air pressure, causing the air pressure switch to open and shut off the master control relay. The machine remains shut down until all emergency stop buttons are reset and the start-up sequence is performed.



**WARNING:** Do not use the e-stops to prevent inadvertent starting of the machine. Always perform power and air lock out procedures on the main disconnect or designated auxiliary disconnect before reaching into the machine.

### *Power Disconnect*

The DISCONNECT SWITCH or CIRCUIT BREAKER mounts on the main electrical cabinet and shuts off electrical power to the machine. There may be additional remote disconnect switches mounted elsewhere on the machine.

To open the electrical cabinet door, first move the disconnect switch to the **off** position.

**WARNING:** Always use the lockout feature of the disconnect switch to ensure the electrical power remains off during any maintenance or repair work.

Not all disconnect switches shut off all power. Some switches only shut-off power to a particular area or to certain components. Never assume any single disconnect switch shuts-off ALL power to the machine. Refer to the electrical schematics for specific information.






## Precautions and Warnings

Injury or loss of limbs may result if this machine is improperly operated or maintained. Please note the following precautions:

- X-⚠ Never adjust, repair, clean, or clear a jam without turning the power off. To shut down the power, turn the disconnect switch to the off position and lock it in the off position.
- X-⚠ Do not operate this machine without the guards in place.
- X-⚠ Turn off the power before removing or opening any guards. Turning off the power means locking the power disconnect switch in the off position.
- X-⚠ Hot surfaces! Severe burns result from the improper handling of the hot melt glue system. Wear proper clothing and high temperature gloves when cleaning or repairing the hot melt glue system.
- X-⚠ Replace all broken or worn parts immediately. Check and tighten all bolts and screws.
- X-⚠ High voltage electrical equipment – authorized personnel only.
- X-⚠ Turn off the power when the machine is not in use.
- X-⚠ This machine starts automatically in the ‘auto’ position when the downstream control contact and/or time delay attachment is used.
- X-⚠ Always wear proper clothing during operation of heavy-duty machinery.

SWF Machinery endeavors to comply with OSHA standards. You, however, are the most important part of safe equipment operation. In order to provide for your safety, you should be knowledgeable and put into practice the following:

- ↪ Always know the purpose of the control buttons and selector switches before operating any equipment.
- ↪ Always test the emergency stop and a normal cycle stop buttons before operating this machine.

-  Be familiar with the power off or disconnect procedure. This procedure includes turning off the power and locking the power disconnect switch in the off position.
-  Always be aware of all moving parts and of the danger in putting hands or limbs in or around these areas.
-  Note the high operating temperatures required in operating the glue system. Always wear gloves, goggles, and protective clothing when servicing the glue systems.

## Lockout Information

Never attempt to adjust, repair, clean, or remove cases in a jam condition without stopping, powering down, and locking the machine out.

### Main Power Panel

To lock out the power:

1. Push the red emergency stop button.
2. Rotate the disconnect switch to the “Off-Lock” position.
3. Under the disconnect switch, locate and push up the lock slide.
4. Insert a lock into the exposed squared area.
5. Test all buttons and try moving the switch to make sure power cannot be applied.

### Power Disconnect Switch

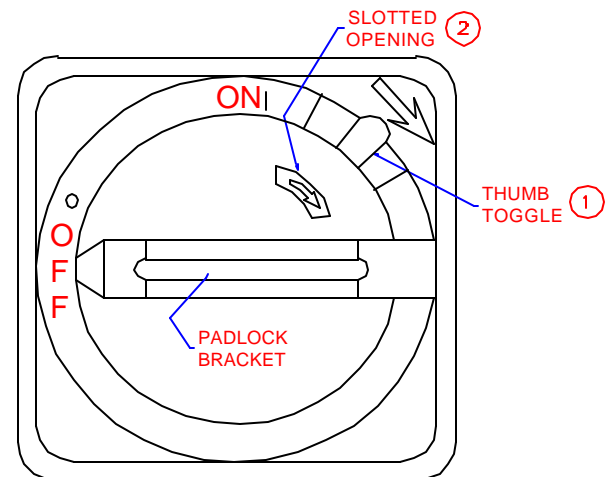
This switch must be in the ON position to operate the machine. Turn OFF when washing the machine or when making repairs or adjustments other than changeovers.

To open the control panel:

1. Twist the disconnect switch to the OFF position
2. Push down on the thumb switch (see figure 4, item 1) and slide the outer ring down
3. Pull open the door.

The power disconnect switch may be locked in the OFF position. To lockout the power, pull the black plastic bracket out from the handle and hook a padlock into the opening (in the off position only).

This prevents the power from being restored to the machine. For further instructions, refer to the documentation for the power lockout switch.



- ① OPENS DOOR WHILE DISCONNECT SWITCH IS IN THE OFF POSITION:  
 1) PUSH DOWN ON THUMB SWITCH  
 2) OPEN DOOR

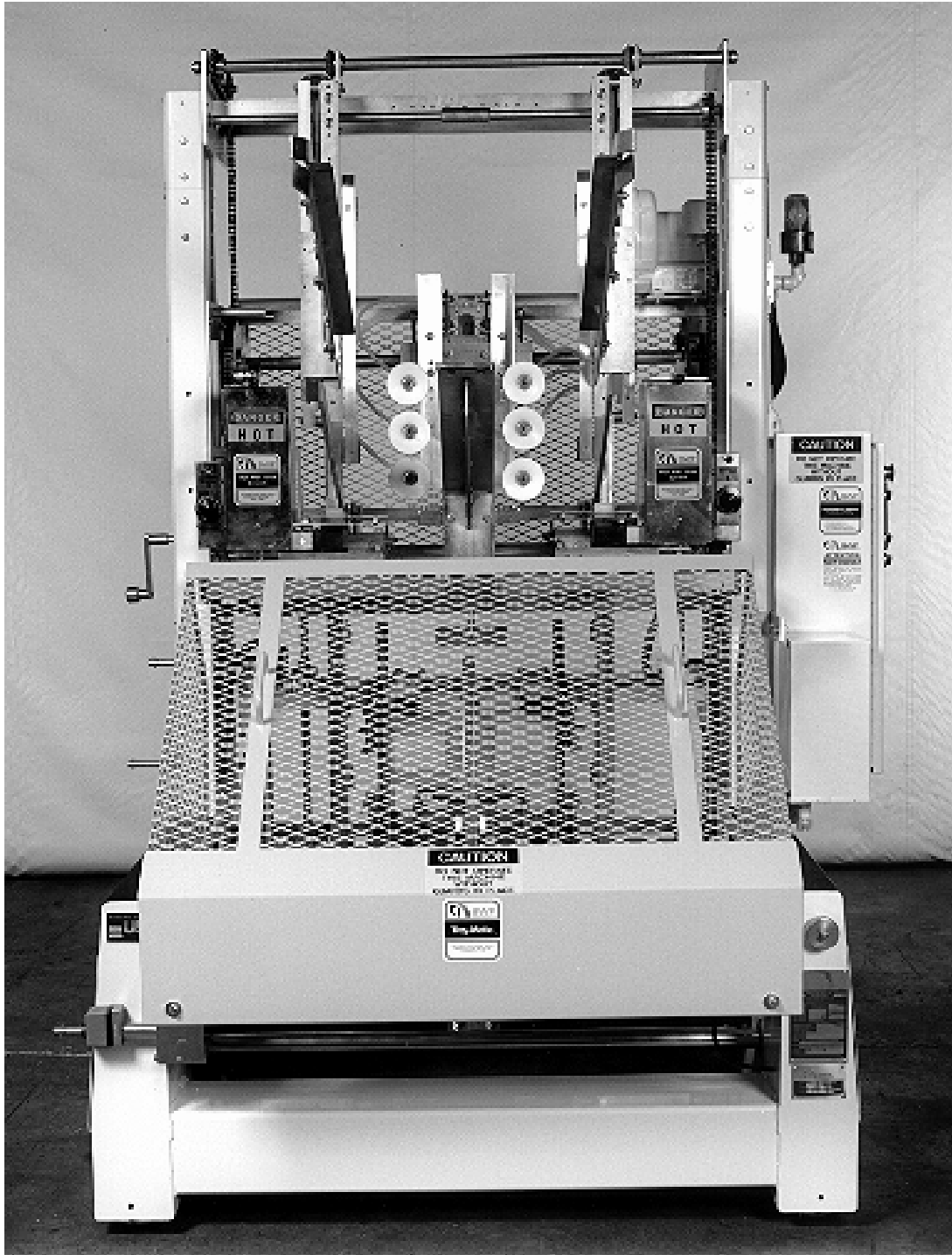
## Safety Features

The 1T4K Traymatic has been built with safety as a prime consideration. To protect personnel from moving parts, wire mesh guards are installed front and rear, over the mandrel and feed wheel areas. All mesh guards are prewired to halt the Traymatic when they are removed or not secured properly. A flashing amber strobe light indicates the machine is powered up and operational. The red “E” stop switch located on the main power panel is of the push/pull type and must be manually operated. This power panel also contains the lockable disconnect lever.

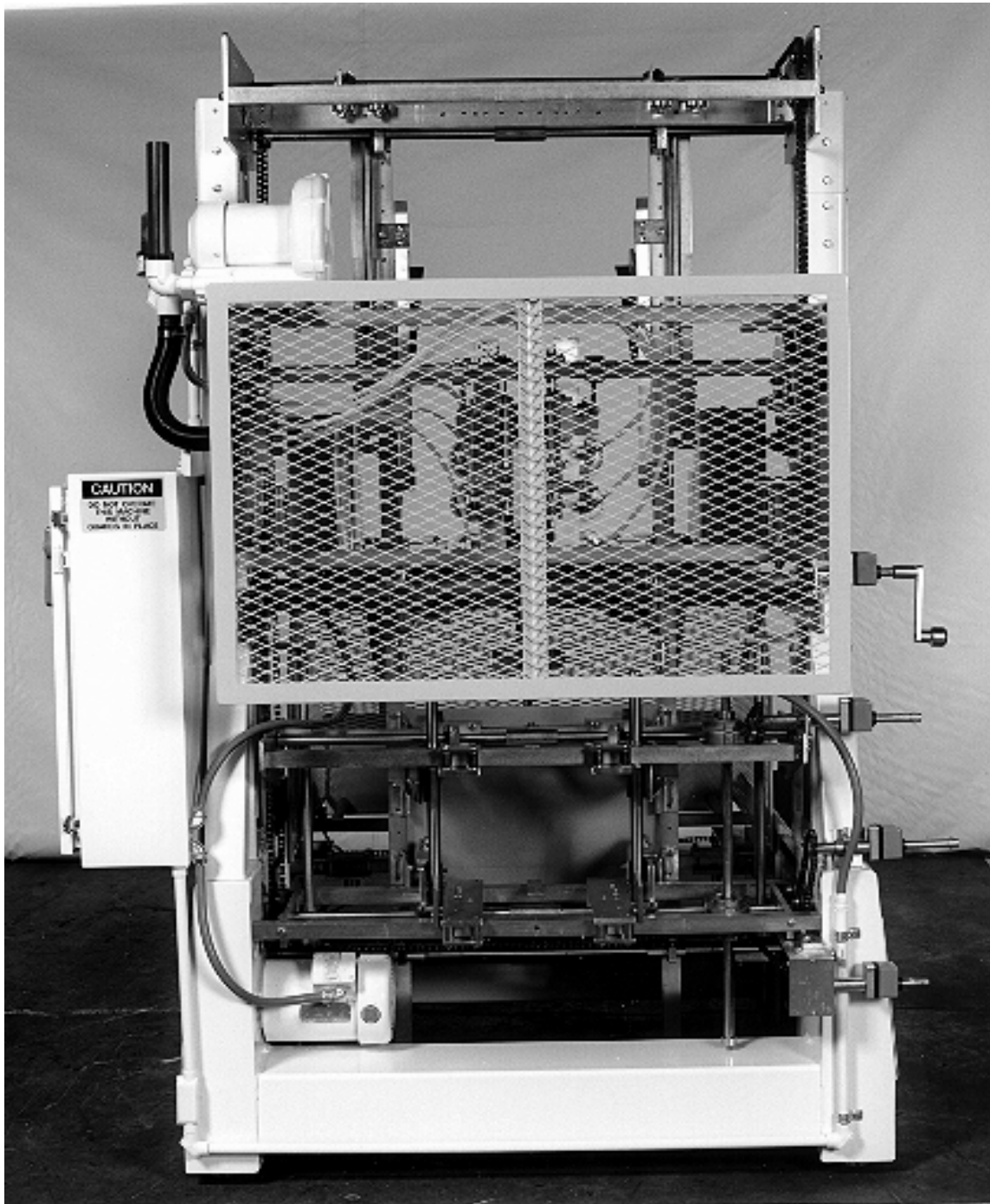
# Parts Illustrations

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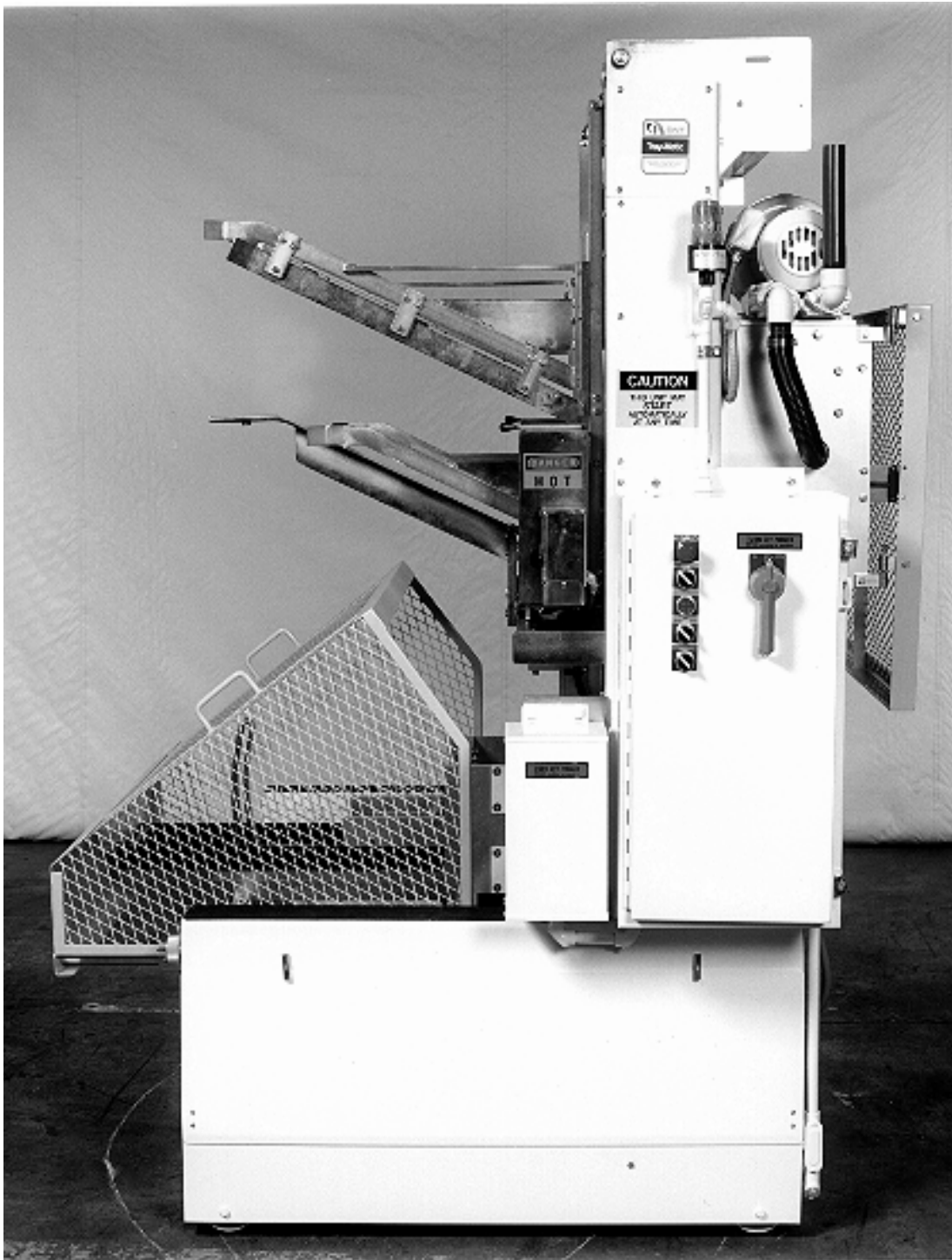
TF 400VK (1T4K) Front View



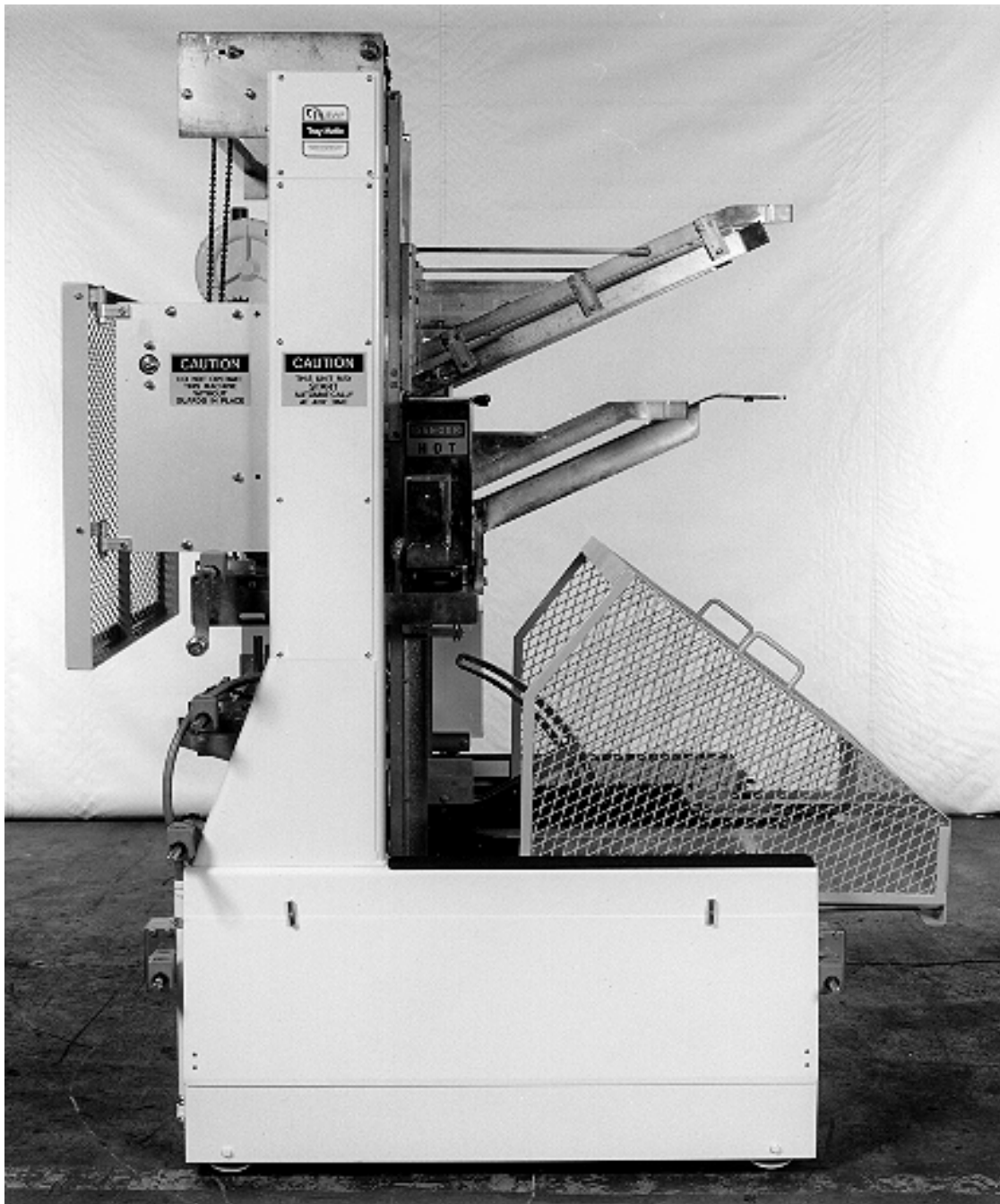
TF 400VK (1T4K) Rear View



TF 400VK (1T4K) Right Side View



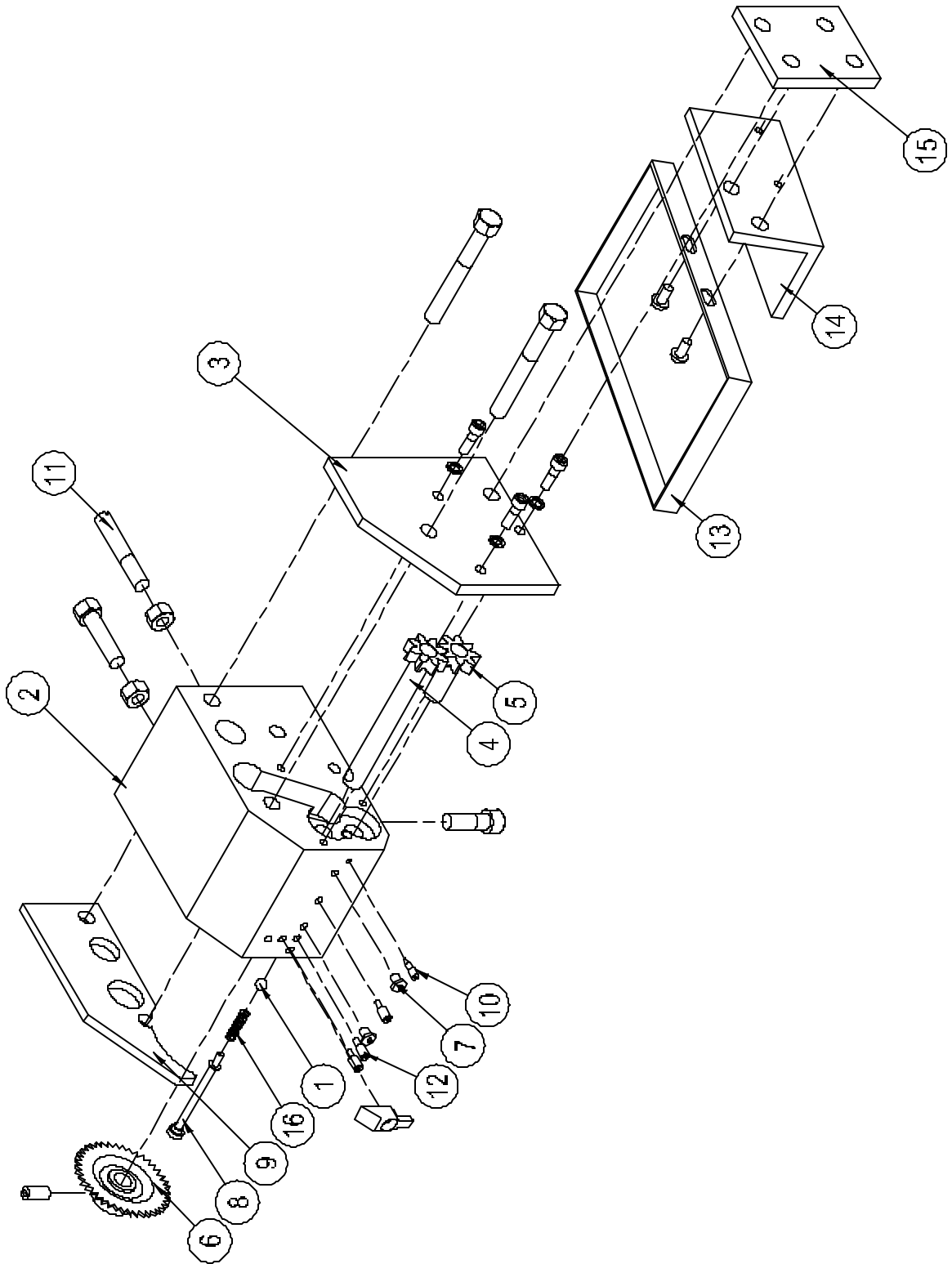
TF400VK (1T4K) Left Side View:



## Entry Conveyor

Item	Qty.	Part No.	Description
1	1	G967E	7/32 DIA BALL, ADHESIVE APPLICATOR CHECK VALVE
2	1	G3143B R/L	HOUSING, ADHESIVE APPLICATOR PUMP
3	1	G3144 R/L	PLATE, ADHESIVE APPLICATOR HOUSING
4	1	G3145B	GEAR, ADHESIVE PUMP DRIVE
5	1	G3146A	GEAR, ADHESIVE PUMP IDLE
6	1	G3147	WHEEL, ADHESIVE PUMP DRIVE
7	2	G3148	JET, ADHESIVE APPLICATOR
8	1	G3149B	PLUG, ADHESIVE APPLICATOR CHECK VALVE SPRING
9	1	G3151A-Z	SPACER, ADHESIVE APPLICATOR PUMP HOUSING
10	1	G3153	NEEDLE VALVE, ADHESIVE APPLICATOR VOLUME CNTRL
11	1	G3477	STUD, ADHESIVE APPLICATOR SUPPORT
12	3	G3665	SCREW, ADHESIVE APPLICATOR JET HOLE PLUG
13	1	G8232	PAN, ADHESIVE APPLICATOR DRIP (STANDARD)
	1	G8232A	PAN, ADHESIVE APPLICATOR DRIP (W/AUXILIARY & 1" PUMP TO AUXILIARY SPACERS)
	1	G8232B	PAN, ADHESIVE APPLICATOR DRIP (W/AUXILIARY ONLY)
	1	G8232C	PAN, ADHESIVE APPLICATOR DRIP (W/AUXILIARY & 2 1/2" PUMP TO AUXILIARY SPACERS)
14	1	G8233 R/L	ANGLE, DRIP PAN MOUNTING
15	1	G8424	EXTENSION, ADHESIVE PUMP DRIP PAN
16	1	GS152	SPRING, ADHESIVE APPLICATOR CHECK VALVE

Entry Conveyor



## Adhesive Melt Pot

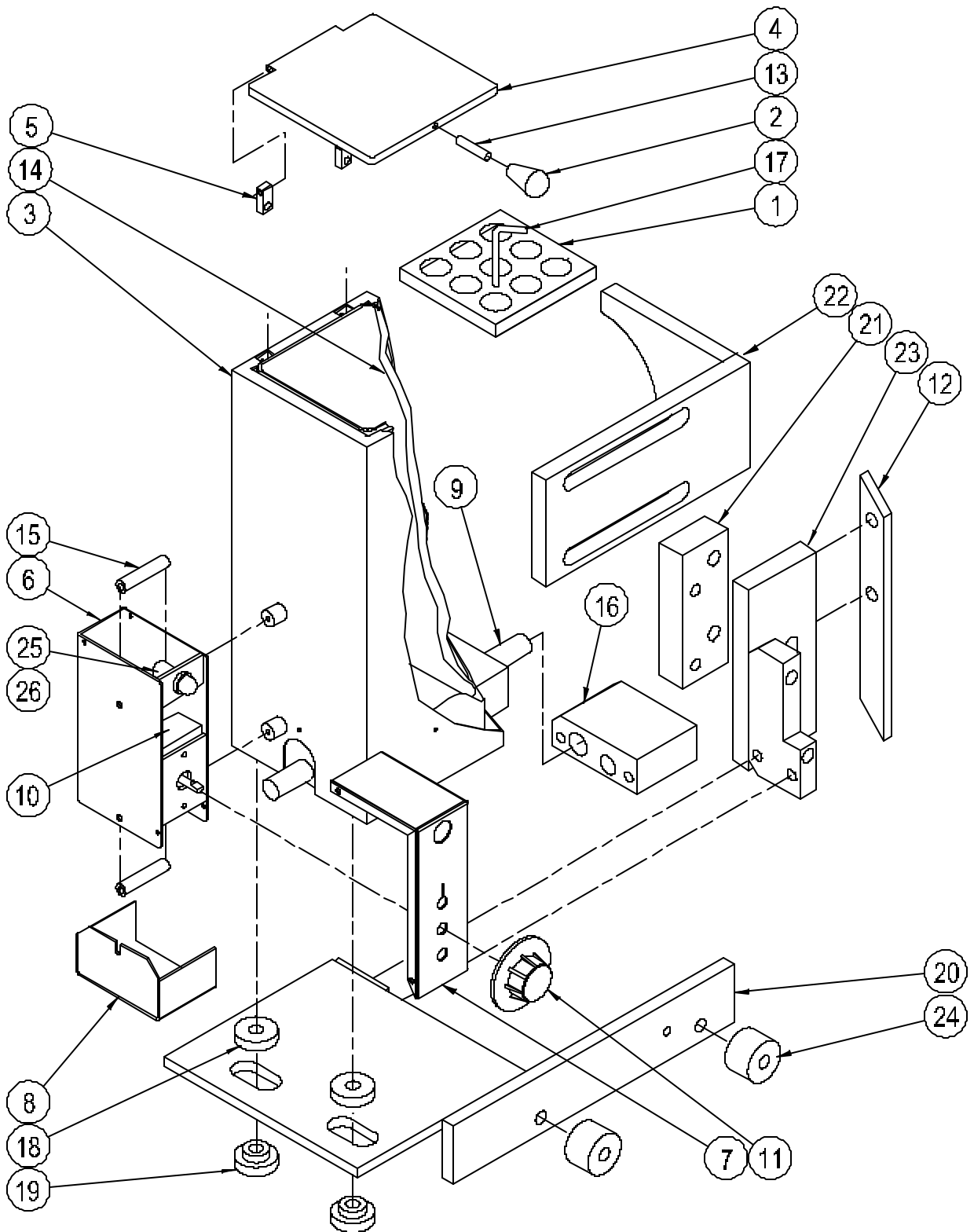
Item	Qty.	Part No.	Description
1	1	G2743*	SCREEN, ADHESIVE MELT
2	1	G2758*	KNOB, ADHESIVE MELT POT COVER
3	1	G2781A*	SHROUD, ADHESIVE MELT POT
4	1	G2782*	COVER, ADHESIVE MELT POT
5	2	G2853*	HINGE, ADHESIVE MELT POT COVER
6	1	G2873B*	BOX, THERMOSTAT CONTROL
7	1	G2874B*	COVER, ADHESIVE MELT THERMOSTAT
8	1	G2936A*	GUARD, THERMOSTAT WIRE
9	1	G2997#*	HEATER, ADHESIVE MELT POT
10	1	G2998B*	THERMOSTAT, ADHESIVE MELT POT
11	1	G2998B-1*	CONTROL DAIL, THERMOSTAT - PART OF G2998B
12	1	G3064 R/L	BAR, MELT POT CLAMP
13	1	G3067*	STUD, MELT POT COVER
14	1	G3089 R/L*	POT, ADHESIVE MELT
15	2	G3092*	SPREADER, THERMOSTAT CONTROL BOX
16	1	G3443-14	PUMP SPACER 2 1/2"
17	1	G3508B*	HANDLE, ADHESIVE MELT POT SCREEN
18	2	G7574*	WASHER, INSULATING
19	2	G7575*	BUSHING, POT INSULATING
20	1	G7576A R/L	BRACKET, ADHESIVE SYSTEM MOUNTING
21	1	G7643A	SPACER, PROGRAM WHEEL BRACKET
22	1	G7650 R/L	BRACKET, PROGRAM WHEEL ADJUSTING
23	1	G8246 R/L*	MOUNT, ADHESIVE MOUNTING BRACKET
24	2	GE83*	CAM FOLLOWER BEARING
25	1	GV6A*	LIGHT, INDICATOR ASSEMBLY
26	1	GV6B*	LAMP, INDICATOR

Note: # Variable Part - Order By Manufactures Number On Heater, And Length.

Note: (+) These Parts May Be Purchased As A Preassembled Package. To Order, Specify Bu188 Right Or Left.

Note: (\*) These Parts May Be Purchased As A Preassembled Package. To Order, Specify Bu199a Right Or Left.

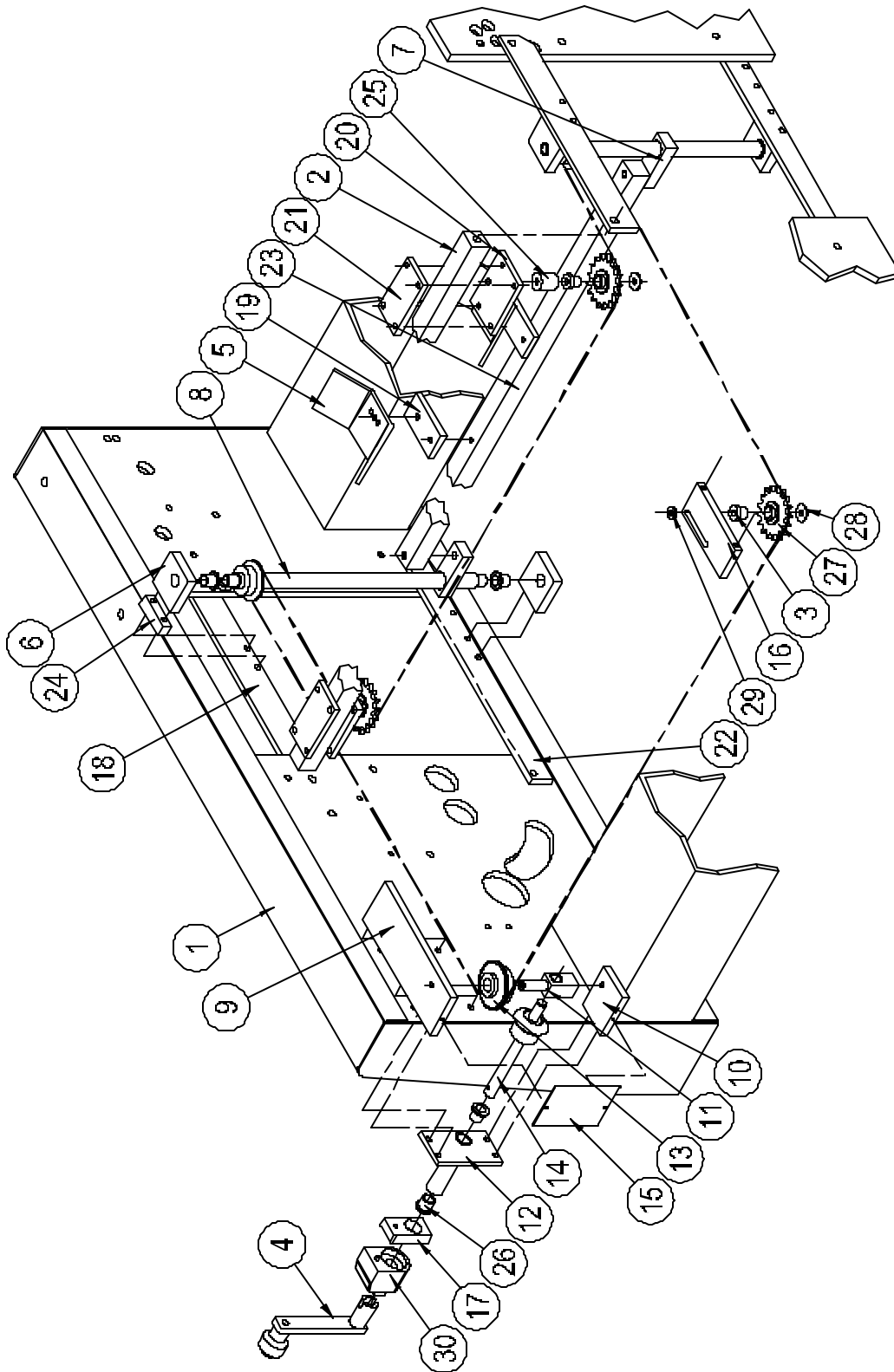
Adhesive Melt Pot



## Bottom Stop Assembly

Item	Qty.	Part No.	Description
1	1	G2411B	FRAME, LOWER ASSEMBLY
2	1	G2430C	SPREADER, TRANSMISSION PLATE
3	3	G3377F	AXLE, IDLER
4	1	G3402	HAND, CRANK
5	2	G03465B	STOP, TRAY BOTTOM
6	4	G8278A	BLOCK, BEARING
7	2	G8279	BLOCK, BOTTOM STOP MOUNTING
8	2	G8281A	SCREW, SHAFT, ADJUST
9	1	G8283	PLATE, BOTTOM STOP MOUNTING
10	1	G8284	PLATE, BOTTOM GEAR BOX
11	1	G8285	AXLE, BOTTOM STOP DRIVE
12	1	G8286	SHAFT SUPPORT
13	1	G8287	SPROCKET, BOTTOM STOP DRIVE
14	1	G8288	GEAR, BOTTOM STOP DRIVE SHAFT
15	1	G8289	COVER PLATE
16	1	G8290	PLATE, BOTTOM STOP TAKE-UP
17	1	G8790	STOP, POSITION INDICATOR
18	2	5000-08	BAR, UPPER BEARING BLOCK MOUNT
19	2	5000-09	BRACKET, BOTTOM STOP EXTENSION
20	2	5000-22	PLATE, IDLER SPROCKET MOUNT
21	2	5000-23	PLATE, IDLER SPROCKET MOUNT CLAMP
22	2	5000-50	BAR, LOWER BEARING BLOCK MOUNT
23	1	5000-73	BAR, BOTTOM STOP
24	2	5000-74	SPACER, UPPER BOTTOM STOP MOUNT
25	2	GB329	IDLER SPROCKET SPACER
26	6	GB413	BUCHING, SHAFT
27	3	CG9B	SPROCKET, IDLER
28	3	GW18	WASHER, IDLER SPROCKET
29	1	GW56	WASHER, HEAVY DUTY
30	1		SIKO DIGITAL READOUT DA0912001.00-CW-.625

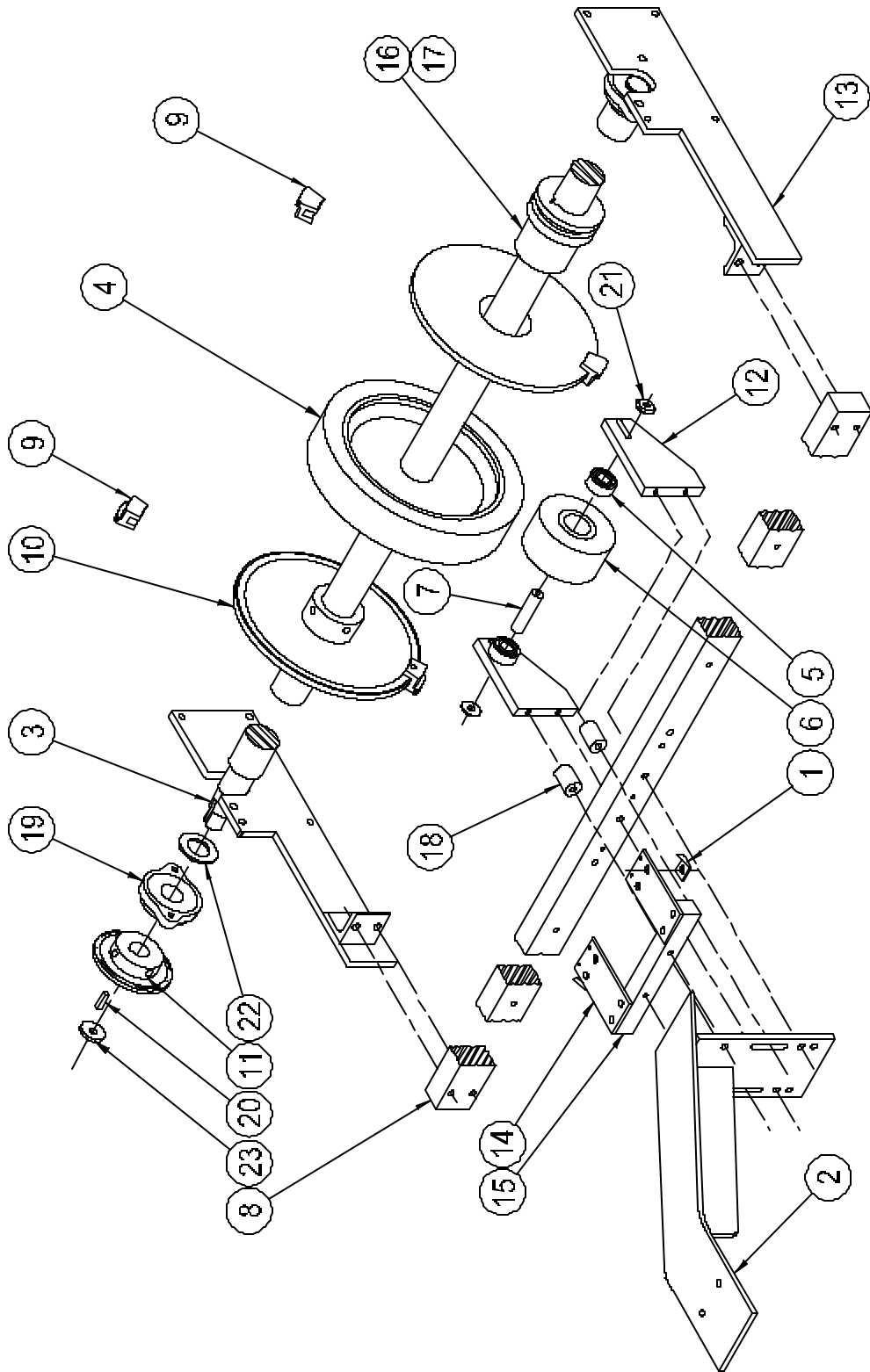
*Bottom Stop Assembly*



## Feed Roll & Programmer

Item	Qty.	Part No.	Description
1	2	G1562BR	KNIFE, BLANK SUPPORT
2	1	G2746E	SUPPORT, BLANK HOPPER LOADING
3	1	5000-49	SHAFT, BLANK FEED WHEEL
4	1	5000-48	WHEEL, BLANK FEED
5	2	GE38	BEARING, BLANK FEED IDLE ROLL
6	1	G2908	ROLLER, BLANK FEED IDLE
7	1	G2911A	SHAFT, BLANK FEED IDLE ROLLER
8	1	G2999E	BAR, BLANK FEED IDLE ROLLER MOUNT
9	*	G3028B	SEGMENT, ADHESIVE PROGRAM ( * Quantity as required)
10	2	G7664	DISC, INTERMITTENT ADHESIVE APPLICATOR PROGRAM
11	1	G7804	SPROCKET, VACUUM FEED DRIVE, 4:1, 6:1
12	2	G7638	MOUNT, BLANK FEED IDLE ROLL
13	2	G7662 R/L	PLATE, FEED WHEEL MOUNTING
14	2	G7906	PLATE, HOPPER BOTTOM STOP
15	1	G7907	BAR, HOPPER BOTTOM STOP PLATE
16	2	G8243	HUB, PROGRAM WHEEL MOUNTING
17	2	G7645	KEY - PROGRAM WHEEL
18	2	GB76	SPACER, IDLER ROLL MOUNT
19	1	GE70A	BEARING, BLANK FEED ROLL DRIVE SHAFT
20	1	GJ10A	KEY 1/4 x 1/4 x 1" LONG
21	1	GW1B	WASHER, 1" O.D. x 5/16" I.D. x 5/32" THICK
22	1	GW8	WASHER, 2" O.D. x 1 3/16 I.D. x 1/8" THICK
23	1	GW12	WASHER, 1 1/4" O.D. x 25/64" I.D. x 3/16" THICK

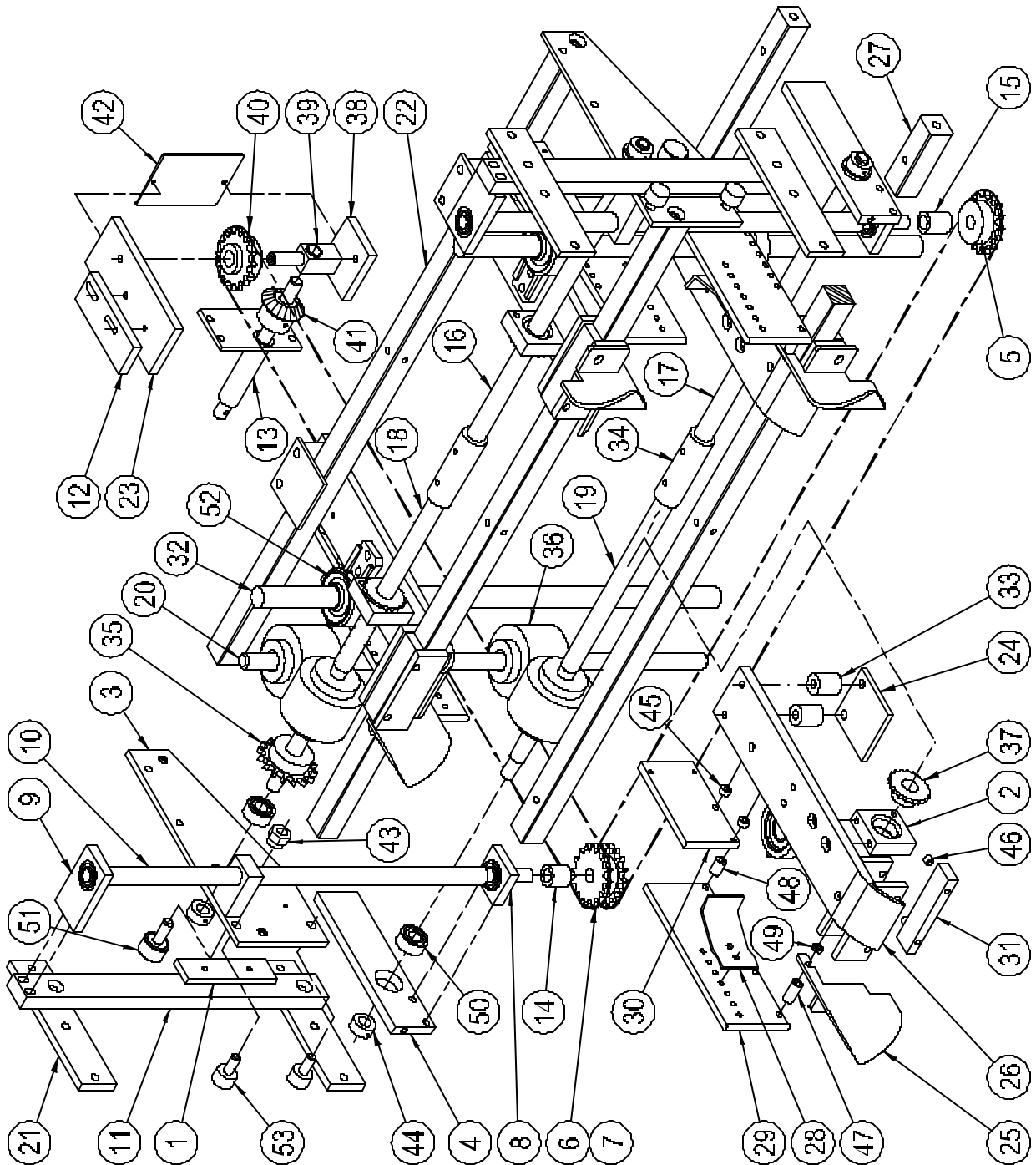
Feed Roll & Programmer



## Compression Chamber Assembly

Item	Qty.	Part No.	Description
1	2	5000-01	WEAR STRIP, UPPER COMPRESSION
2	4	5000-02	BLOCK, COMPRESSION SHOE ADJUSTMENT
3	1R/1L	5000-03	PLATE, TOP COMPRESSION SUPPORT-1R/ 1L
4	2	5000-04	BAR, LOWER ADJUSTMENT SHAFT SUPPORT
5	1	5000-10	SPROCKET, VERTICAL ADJUSTMENT SCREW R.H
6	1	5000-11	SPROCKET, VERTICAL ADJUSTMENT SCREW L..H
7	1	5000-12	SPROCKET, VERT. ADJUSTMENT SCREW L..H . CROSS
8	2	5000-14	BLOCK, VERTICAL ADJ. SCREW BOTTOM BEARING
9	2	5000-15	BLOCK, VERTICAL ADJ. SCREW TOP BEARING
10	2	5000-16	SCREW, VERTICAL COMPRESSION ADJUSTMENT
11	2	5000-17	BAR, VERTICAL COMPRESSION ADJUSTMENT GUIDE
12	1	5000-18	BRACKET, VERTICAL ADJUSTMENT GEARBOX MOUNTING
13	1	5000-21	PLATE, VERTICAL COMPRESSION ADJ. DRIVE CRANK
14	1	5000-26	SPACER, VERT. COMPRESSION ADJUSTMENT SHAFT L.H.
15	1	5000-27	SPACER, VERT. COMPRESSION ADJUSTMENT SHAFT R.H.
16	1	5000-55	SCREW. BLISS K.C. (42 1/2" FRAME) UPPER -R.H.
17	1	5000-56	SCREW. BLISS K.C. (42 1/2" FRAME) LOWER -R.H.
18	1	5000-57	SCREW. BLISS K.C. CRANK (42 1/2" FRAME) UPPER L.H.
19	1	5000-58	SCREW. BLISS K.C. 42 1/2" FRAME) LOWER -L.H.
20	1	5000-59	SHAFT, SIDE COMPRESSION ADJUSTING
21	6	5000-62	BRACKET, GUIDE BAR MOUNTING
22	2	5000-63	BAR, TOP COMPRESSION SUPPORT
23	1	5000-64	PLATE, MOUNTING VERTICAL ADJUSTMENT GEAR BOX
24	4	5000-65	CAP, TOP COMPRESSION SUPPORT
25	2R/2L	5000-66	PLOW, INNER FLAP FORMING
26	2R/2L	5000-67	SHOE, TRAY FORMING
27	2	G2430C	SPREADER, TRANSMISSION PLATE
28	4	G2879A	PAWL, TRAY STRIPPER
29	4	G2933C	SHOE, TRAY OUTSIDE FLAP FORMING
30	4	G3514A	PLATE, TRAY COMPRESSION EXT.
31	4	G3566	BAR, TRAY FORMING SHOE CLAMP
32	2	G7604	ROD, TRAY FORMING COMPRESSION
33	8	G7616	SPACER, TOP COMPRESSION SHOE SUPPORT
34	2	G7668	COUPLING, ADJUSTMENT SCREW
35	1	G7669	SPROCKET, COMPRESSION ADJUSTMENT
36	2	G7675	FLOAT-A-SHAFT
37	2R/2L	G8251	NUT ADJUSTING SCREW
38	1	G8284	PLATE, VERTICAL COMPRESSION ADJ. GEARBOX
39	1	G8285	AXLE, VERTICAL COMPRESSION ADJ. GEAR BOX
40	1	G8287	SPROCKET, VERTICAL COMPRESSION ADJ. GEARBOX
41	1	G8288	GEAR, VERTICAL COMPRESSION ADJ. GEARBOX
42	1	G8289	COVER, VERTICAL COMPRESSION ADJ. GEARBOX
43	2	G8422	SPACER, TOP COMPRESSION SUPPORT BEARING
44	4	GA8	SET COLLAR
45	8	GB53	BUSHING
46	8	GB62	BUSHING
47	4	GB410	BUSHING
48	4	GB475	BUSHING
49	4	GB499	BUSHING
50	8	GE38	BEARING
51	4	GE64	BEARING, CF 1 1/4"

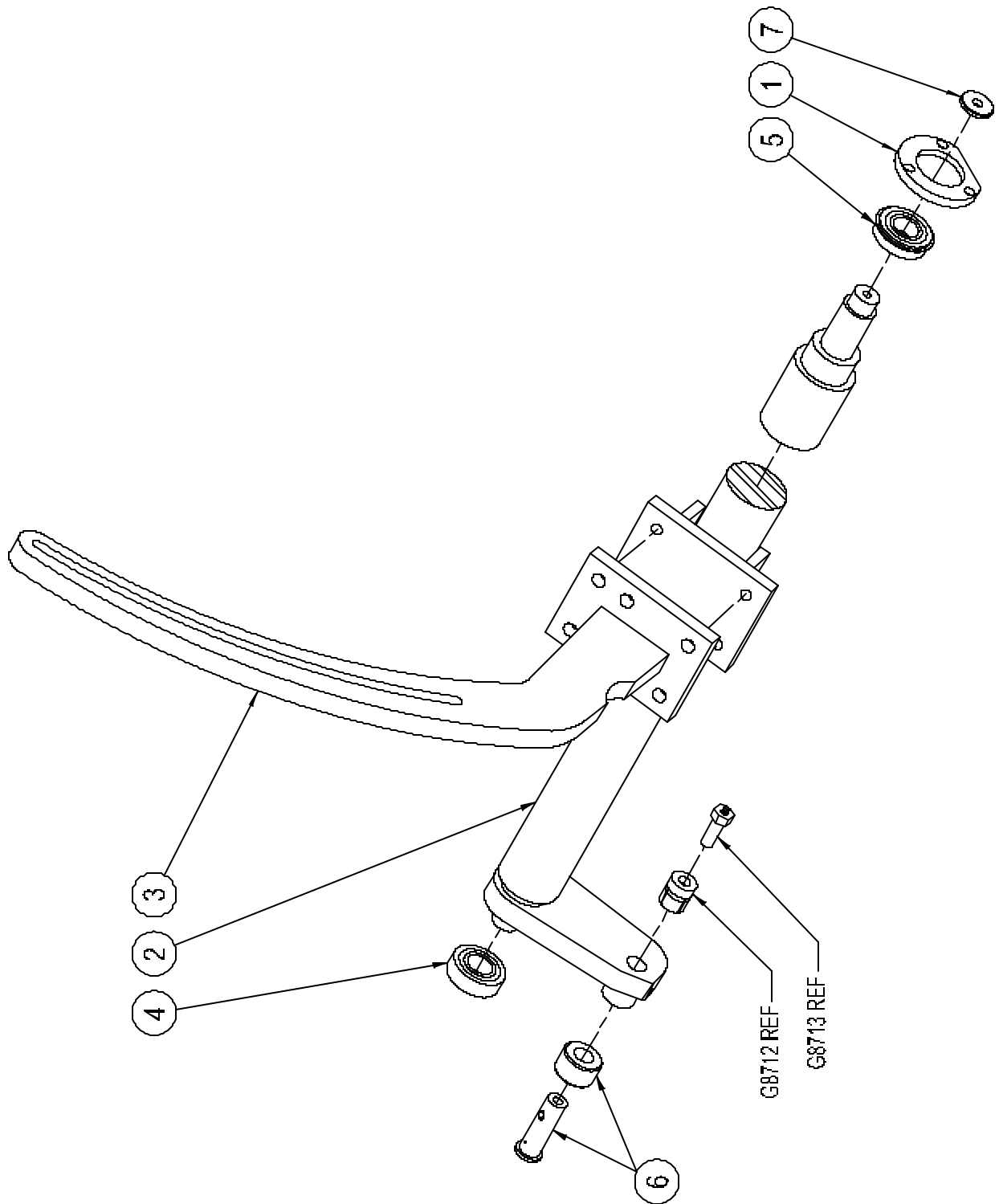
52	4	GE65A	BEARING, ROBERTS # RBS 16
53	4	GE71	BEARING, CF 1"



### Feed Post Shaft Assembly

Item	Qty.	Part No.	Description
1	1	G2444	RING, BEARING CLAMP
2	1	G4681	SHAFT, MANDREL CRANK ARM
3	1	G7587	FEED POST MANDREL
4	1	GE13	BEARING FEED POST SHAFT R.H
5	1	GE13A	BEARING FEED POST SHAFT L.H
6	1	GE43C	CAM FOLLOWER ROLLER FEED POST
7	1	GW12	WASHER, 1 1/4 OD x 3/8 ID x 3/16" LONG

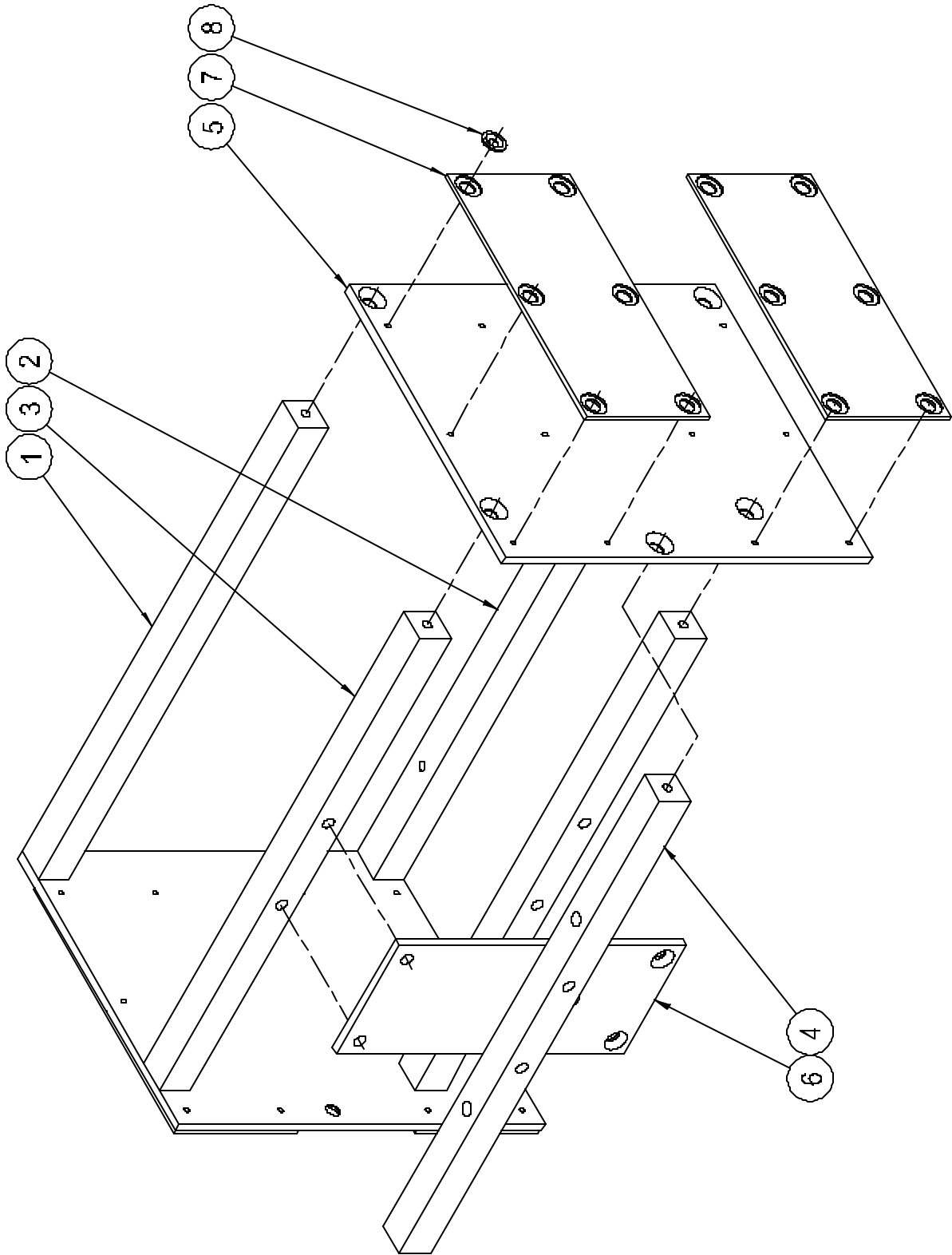
*Feed Post Shaft Assembly*



## Mandrel Assembly

Item	Qty.	Part No.	Description
1	1	G7588	BAR MANDREL SPACER
2	1	G7588A	BAR MANDREL SPACER
3	2	G7589	BAR MANDREL SPACER
4	1	G7590	BAR MANDREL SPACER
5	1R/1L	G7592	PLATE, MANDREL SIDE
6	1	G7591	PLATE, MANDREL MOUNTING
7	4	G3311A	SHEET, MANDREL TEFLON COVER
8	24	G3463	WASHER, TEFLON CLAMP

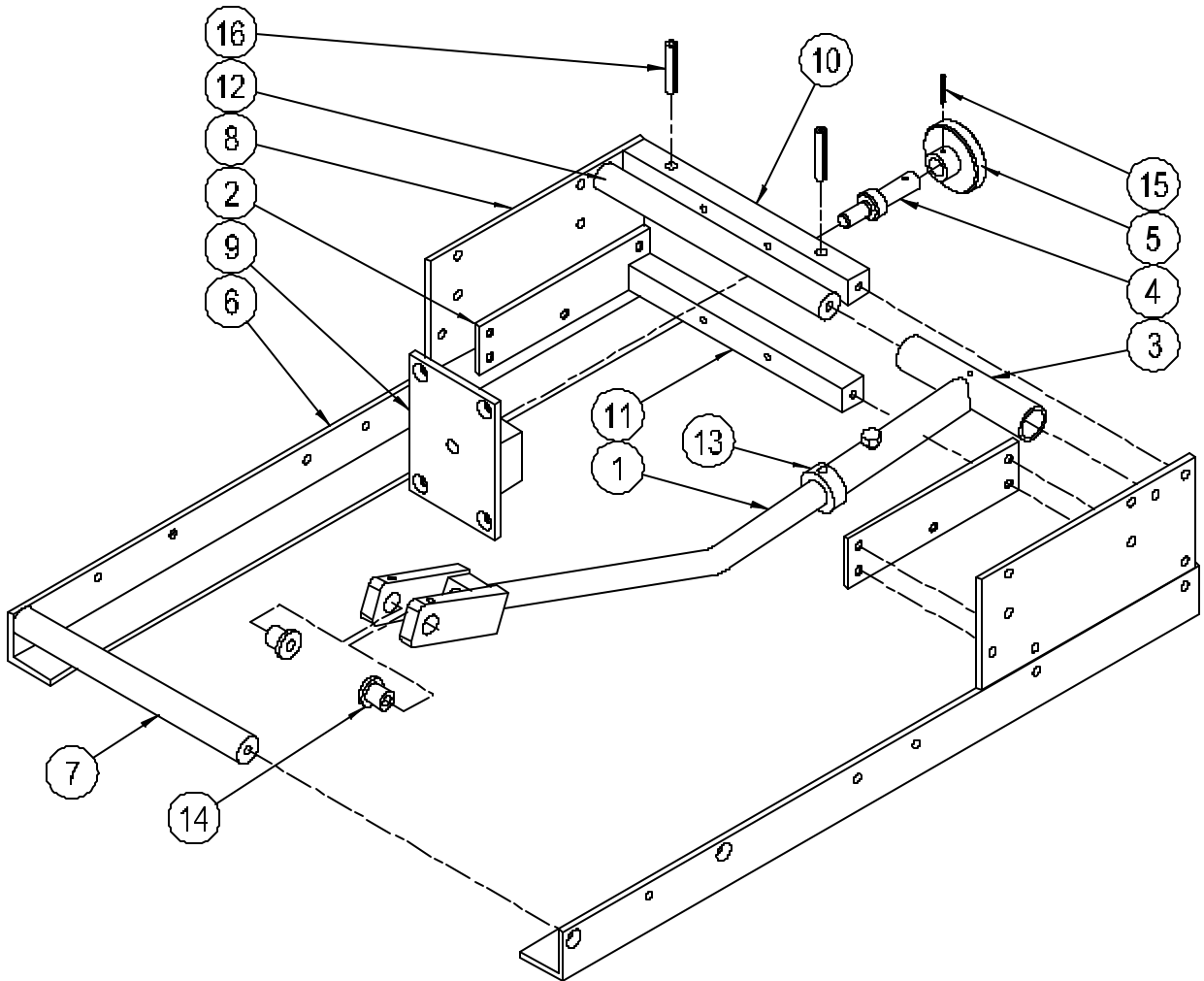
Mandrel Assembly



## Mandrel Carriage Assembly

Item	Qty.	Part No.	Description
1	1	G2680	ROD, MANDREL CONNECTING
2	2	G3043	PLATE, MANDREL FRAME PLATE MOUNTING SPLICE
3	1	G3603	END, MANDREL CON ROD
4	1	G4852A	STUD, MANDREL MOUNTING
5	1	G4852B	KNOB, MANDREL MOUNTING STUD
6	1R / 1L	G7835	RAIL, TRAY FORMING MANDREL
7	1	5000-32	SPACER, MANDREL CARRIAGE
8	1R / 1L	5000-33	PLATE, MANDREL CARRIAGE SIDE
9	1	5000-34	PLATE, MANDREL MOUNTING
10	1	5000-36	SPACER, MANDREL CARRIAGE TOP
11	1	5000-37	SPACER, MANDREL CARRIAGE BOTTOM
12	1	5000-38	SHAFT, CON ROD PIVOT
13	1	GA10	SET COLLAR
14	2	GB398	BUSHING, FORM PLUNGER CONNECTING TUBE YOKE
15	1	GG5G	3/16 DIA. 1 LONG SPRING PIN
16	2	GG6	3/8 DIA. x 1 1/4 LONG SPRING PIN

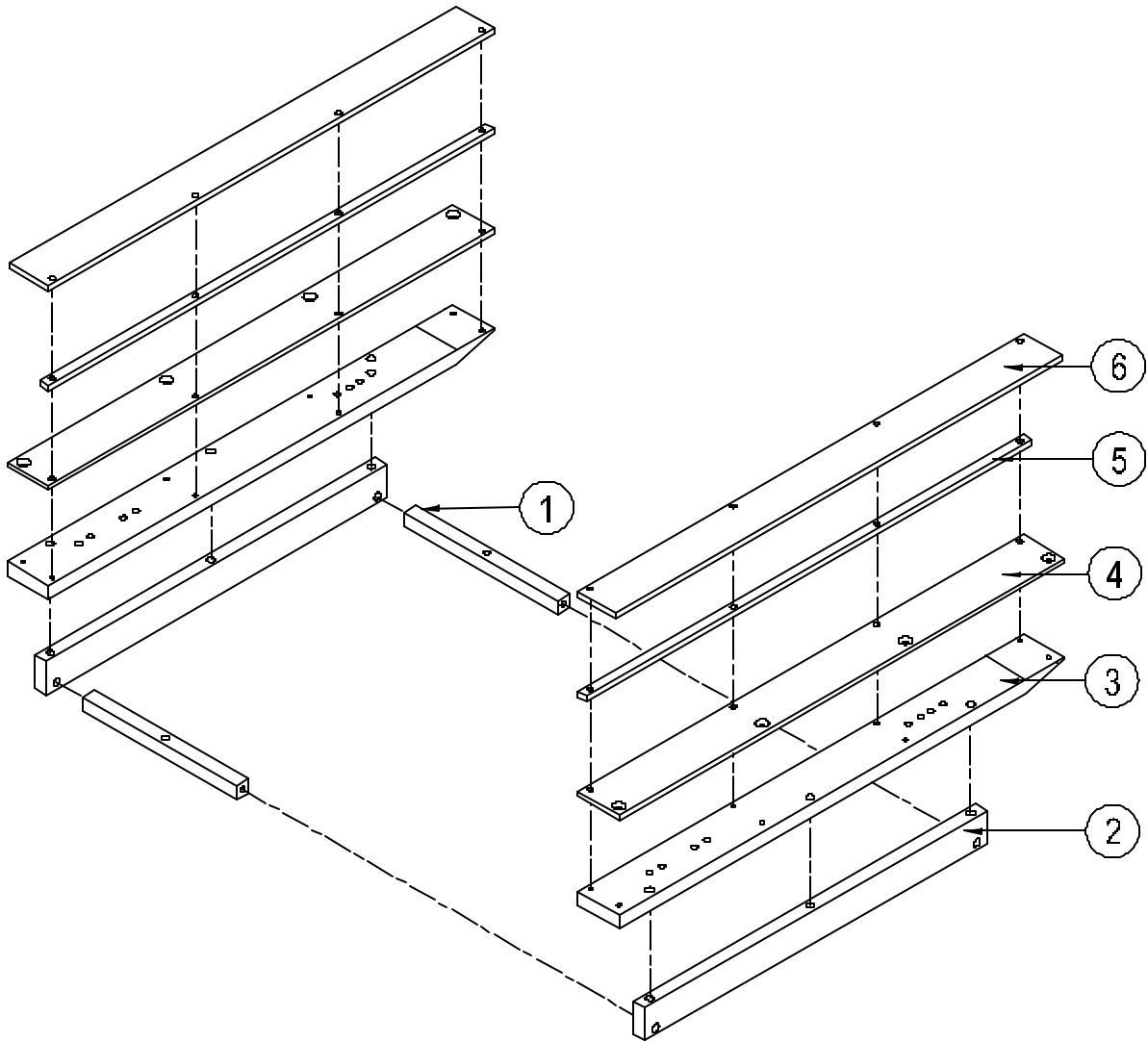
*Mandrel Carriage Assembly*



## Mandrel Guide Rail Assembly

Item	Qty.	Part No.	Description
1	2	5000-35	SPACER, MANDREL GUIDE SUPPORT BAR
2	2	G7586	BAR, MANDREL GUIDE SUPPORT
3	1R / 1L	G7585	BASE, TRAY FORMAR MANDREL
4	2	G3203	GIB, TRAY FORMER MANDREL BASE
5	2	G7682	SPACER, TRAY FORMER GUIDE CUP
6	2	G7681	CAP, TRAY FORMER MANDREL GUIDE

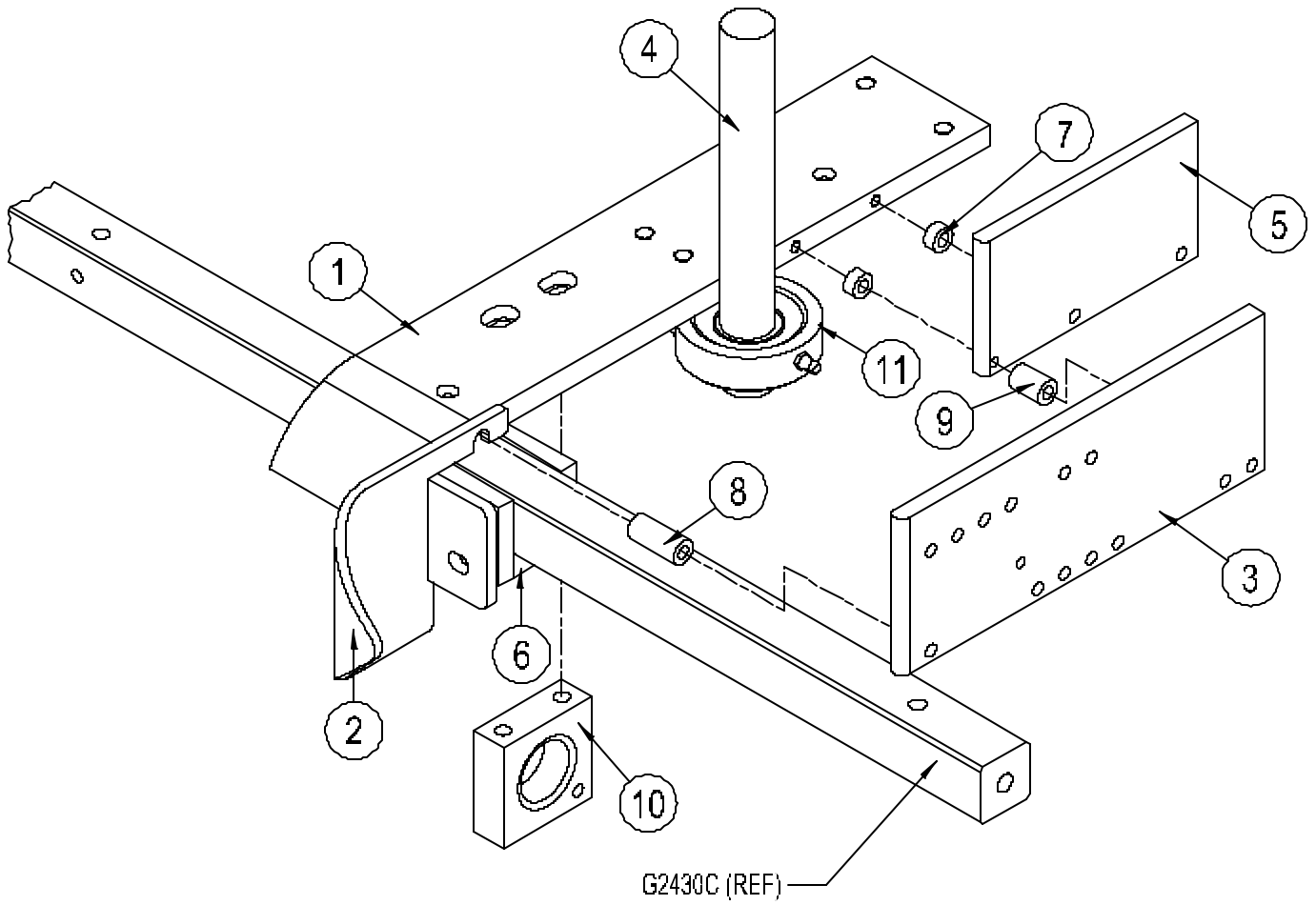
*Mandrel Guide Rail Assembly*



### Minor Flap Folding Plow Assembly

Item	Qty.	Part No.	Description
1	1L	G2785H	SHOE, TRAY FORMING
2	1L	G2927B	PLOW, INNER FLAP FORMING
3	1	G2933C	SHOE, TRAY OUTSIDE FLAP FORMING
4	1	G7604	ROD, TRAY FORM COMPRESSION
5	1	G3514A	PLATE, AUX. COMPRESSION
6	1	G3566	BAR, SHOE BOX FORMING CLAMP
7	2	GB53	SPACER, TRAY COMPRESSION PLATE
8	1	GB410	SPACER, 1/2 OD. x 17/64 ID. x 1 3/16 LONG
9	1	GB475	SPACER, 1/2 OD. x 17/64 ID. x 3/4 LONG
10	1	G7617	BLOCK, COMPRESSION SHOE ADJUSTMENT
11	1	GE65A	BEARING, COMPRESSION ROD

*Minor Flap Folding Plow Assembly*

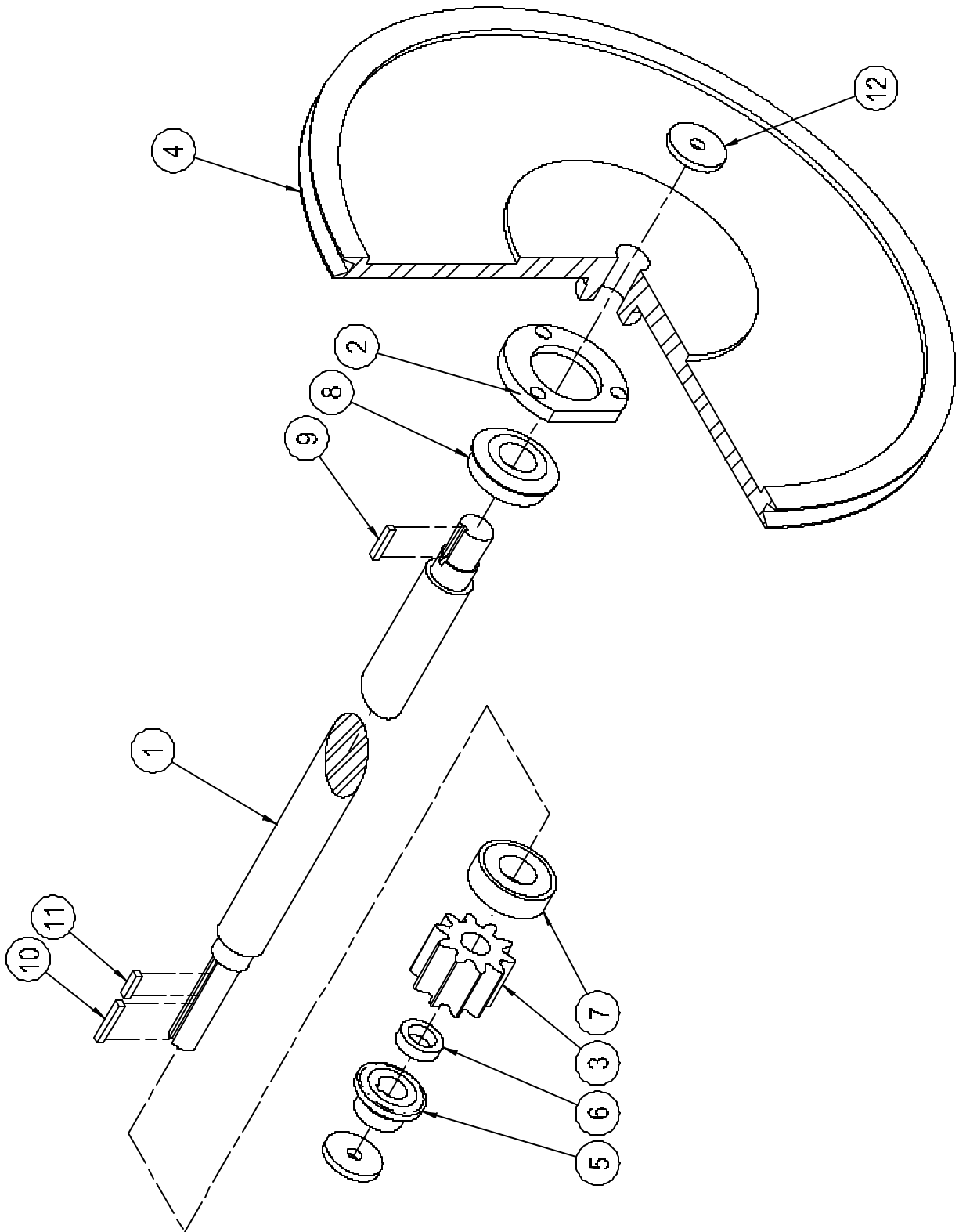


## Pinion Shaft Assembly

Item	Qty.	Part No.	Description
1	1	G2443C	SHAFT, TRANSMISSION PINION
2	1	G2444	RING, PINION SHAFT BEARING CLAMP
3	1	G2456	PINION, TRANSMISSION
4	1	*G3218	PULLEY, PINION SHAFT.... 12-35
4	1	G3218A	PULLEY, PINION SHAFT.... 21-58
5	1	G7299	SPROCKET, MATT FEED ROLL CHAIN (40B10)
6	1	GB379	SPACER, PINION SHAFT SPRT. 1 1/8 OD x 3/4 ID x 5/16 LG.
7	1	GE13	BEARING, PINION SHAFT L.H.
8	1	GE13A	BEARING, PINION SHAFT R.H.
9	1	GJ6	KEY, PINION PULLEY 1/4 x 3/16 x 1 LONG
10	1	GJ9A	KEY, MATT FEED ROLL DRIVE SPRT. 3/16 x 3/16 x 3/4 LG.
11	1	GJ9D	KEY, TRANSMISSION PINION GEAR 3/16 x 3/16 x 1 1/4 LG.
12	2	GW12	WASHER, 1 1/2 OD x 3/8 ID x 3/16 THICK

\*Refer to machine order part number

*Pinion Shaft Assembly*

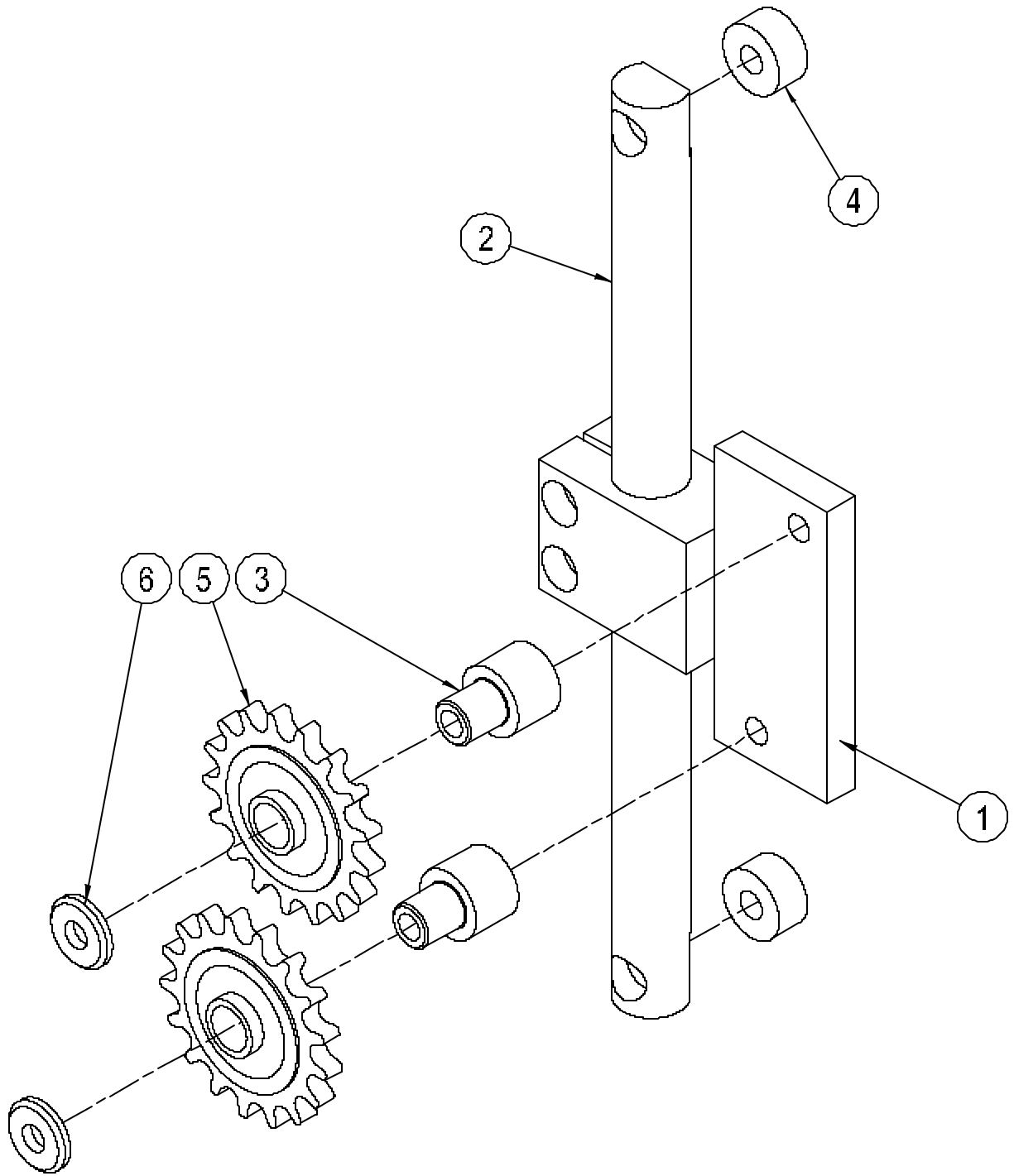


## Take-up Chain Idler Assembly

Item	Qty.	Part No.	Description
1	1	G4934	MOUNT, IDLE SPROCKET TAKE-UP
2	1	G4935	BAR, IDLE SPROCKET TAKE-UP MOUNT
3	2	G7270	AXLE, IDLE SPROCKET
4	2	GB64	BUSHING, 1 OD x 25/64 ID x 1/2 LONG
5	2	GC9A	SPROCKET, IDLE TAKE-UP
6	2	GW1A	WASHER, 1 OD x 25/64 ID x 5/32 LONG

Note: These parts may be purchased as a preassembled package. To order, specify BU171A.

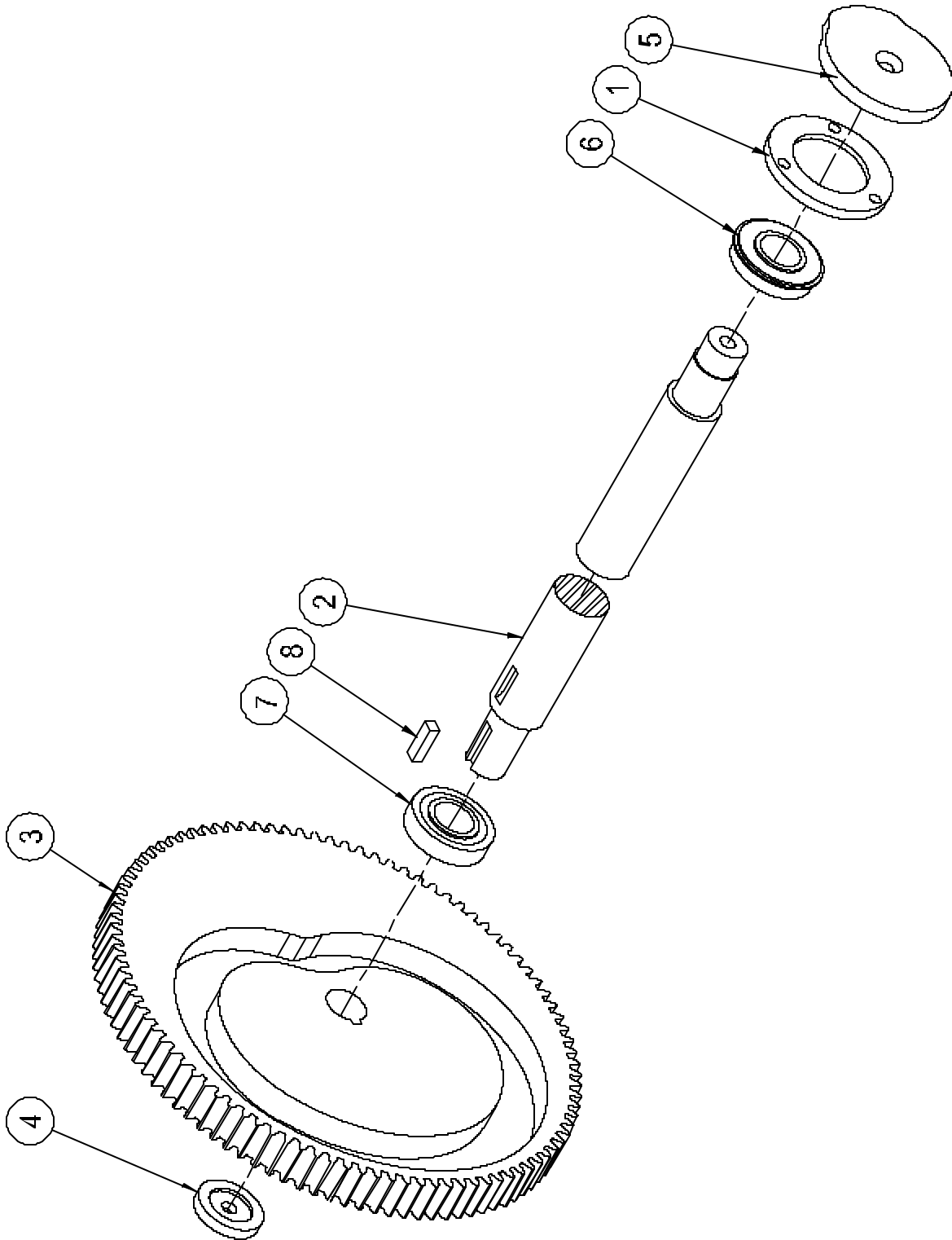
*Take-up Chain Idler Assembly*



## Transmission Gear Shaft Assembly – Matt Pick

Item	Qty.	Part No.	Description
1	1	G2447	RING, MAIN SHAFT BEARING CLAMP
2	1	G2508C	SHAFT, TRANSMISSION GEAR (1T4)
3	1	G2619A	GEAR, TRANSMISSION MAIN
4	1	G3197	WASHER, MAIN DRIVE GEAR RETENTION
5	1	G3245A	CAM, CYCLE MICRO LIMIT SWITCH
6	1	GE2	BEARING, TRANSMISSION SHAFT R.H.
7	1	GE3	BEARING, TRANSMISSION SHAFT L.H.
8	1	GJ12A	KEY, TRANSMISSION MAIN GEAR 3/8 x 3/8 x 1 3/8 LONG

Transmission Gear Shaft Assembly – Matt Pick

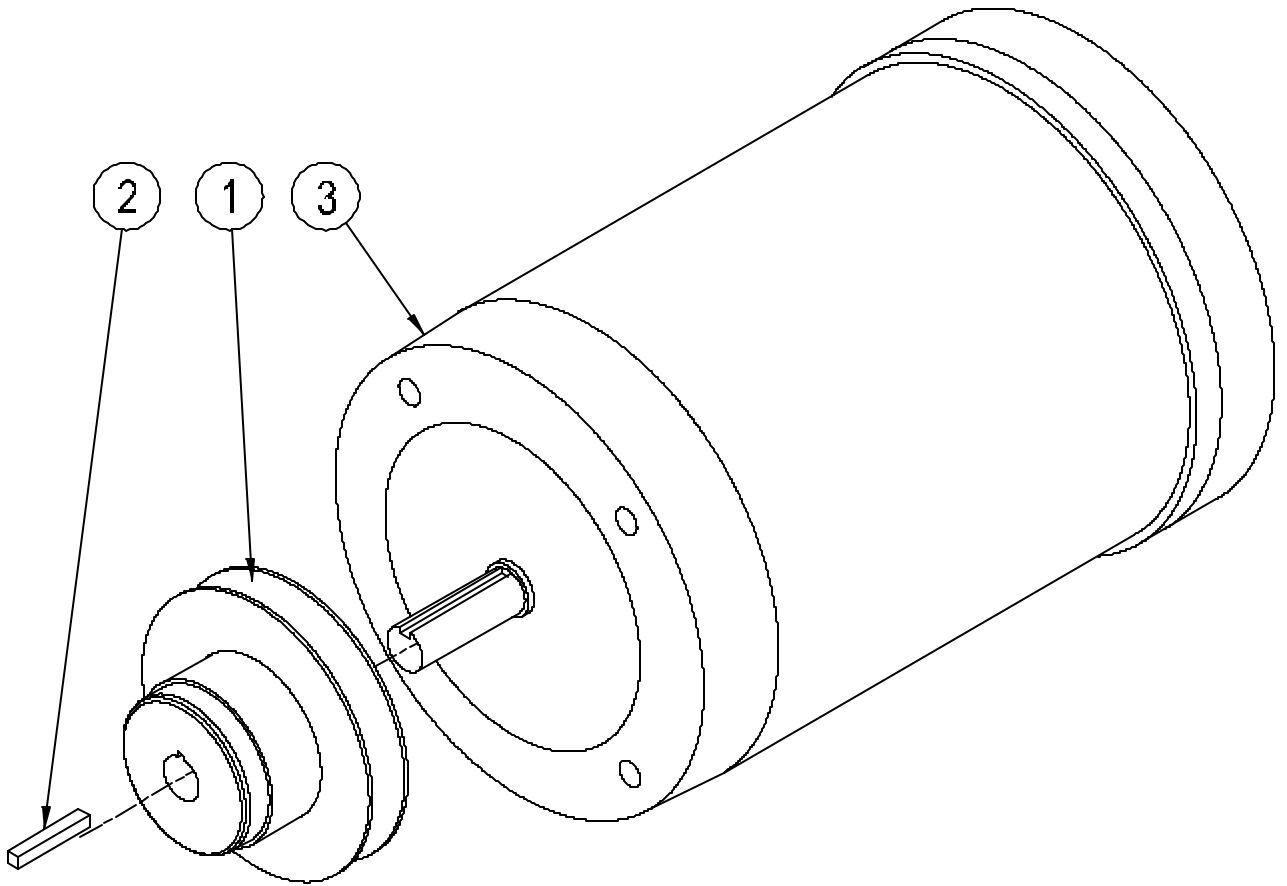


## V-Belt Drive Assembly

Item	Qty.	Part No.	Description
1	1	*G3231	PULLEY, VARI-DRIVE MOTOR 12-35 OR 21-50 TPM SPEED
		*G3231	PULLEY, VARI-DRIVE MOTOR 21-50 TPM SPEED
2	1	GJ9D	KEY, VARI-DRIVE PULLEY
3	1	GM5D	MOTOR, 1 HP 1140 RPM BALDOR

\* Refer to machine order part number.

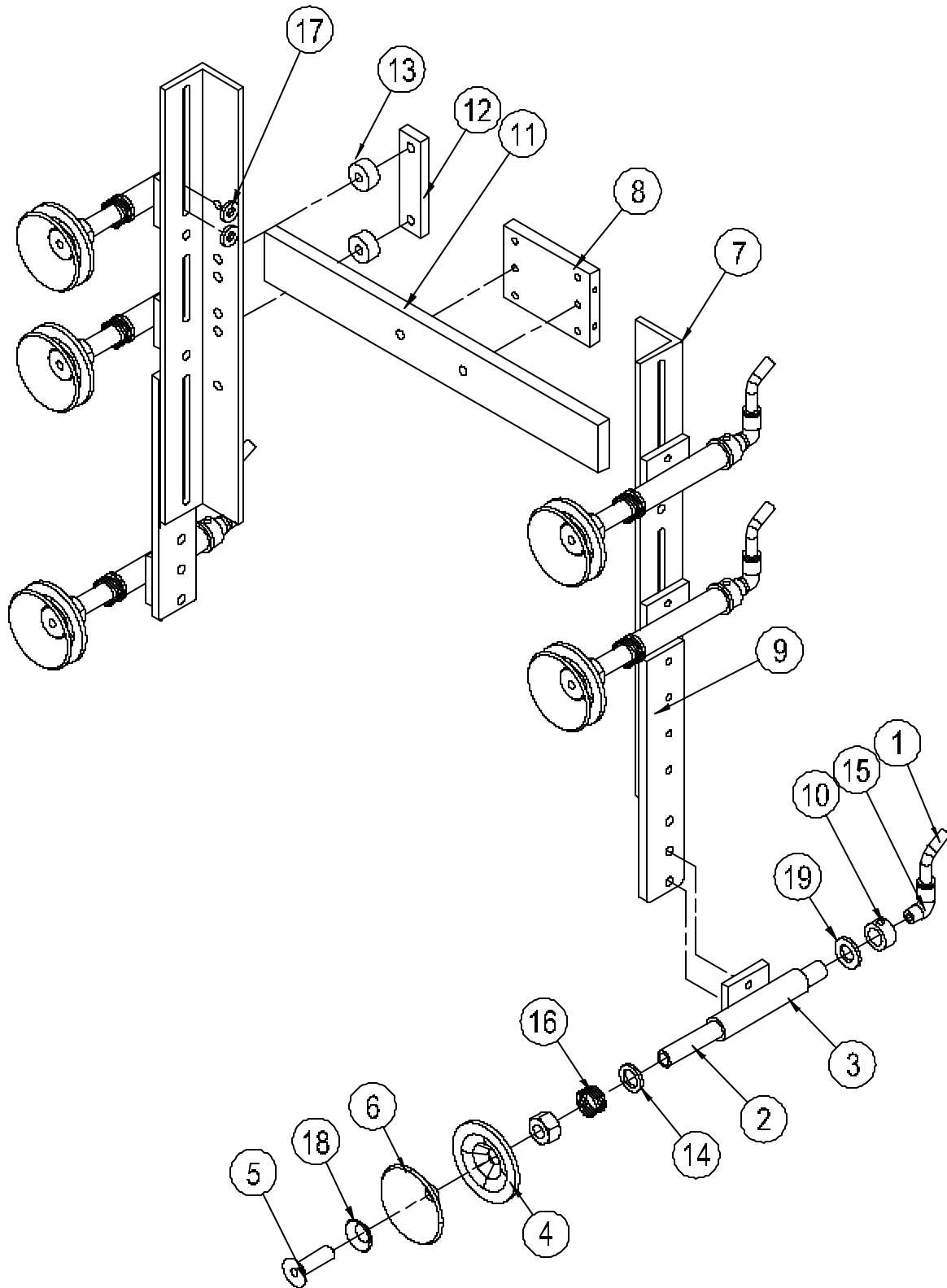
*V-Belt Drive Assembly*



## Vacuum Feed Cup Mounting Assembly

Item	Qty.	Part No.	Description
1	*	G3737	TUBE, POLY FLOW VACUUM (CUT TO LENGTH)
2	6	G4432A	TUBE, SUCTION CUP MOUNTING
3	6	G4441A	BRACKET, VACUUM CUP TUBE SUPPORT
4	6	G4552	PLATE, VACUUM CUP BACK
5	6	G4553	BOLT, VACUUM CUP
6	6	G4554	PAD, VACUUM CUP
7	2	G4557	BRACKET, VACUUM CUP MOUNTING
8	1	G7813	PLATE, VACUUM CUP MOUNTING
9	2	G7905	BAR, VACUUM CUP BOTTOM PLACEMENT
10	6	G8244	SET COLLAR, VACUUM TUBE LOCATING
11	1	G8417	BAR, VACUUM CUP BRACKET MOUNTING
12	2	G8418	CLAMP, VACUUM CUP BRACKET MOUNTING
13	4	G8419	SPACER, VACUUM CUP BRACKET CLAMP
14	6	GB352	BUSHING, SPRING RETAINING 1 OD x 21/32 ID x 1/8 LONG
15	6	GP8C	1/4 PIPE TO 3/8 TUBE MALE ELBOW
16	6	GS180	SPRING, VACUUM CUP RETURN
17	16	GW56	WASHER, 3/4 OD x 21/64 ID x 1/8 LONG
18	6	GW84	WASHER, VACUUM CUP SPECIAL - DIMPLED 5/8 S.A.E.
19	6	GW89	WASHER, VACUUM CUP SHOCK ABSORBER

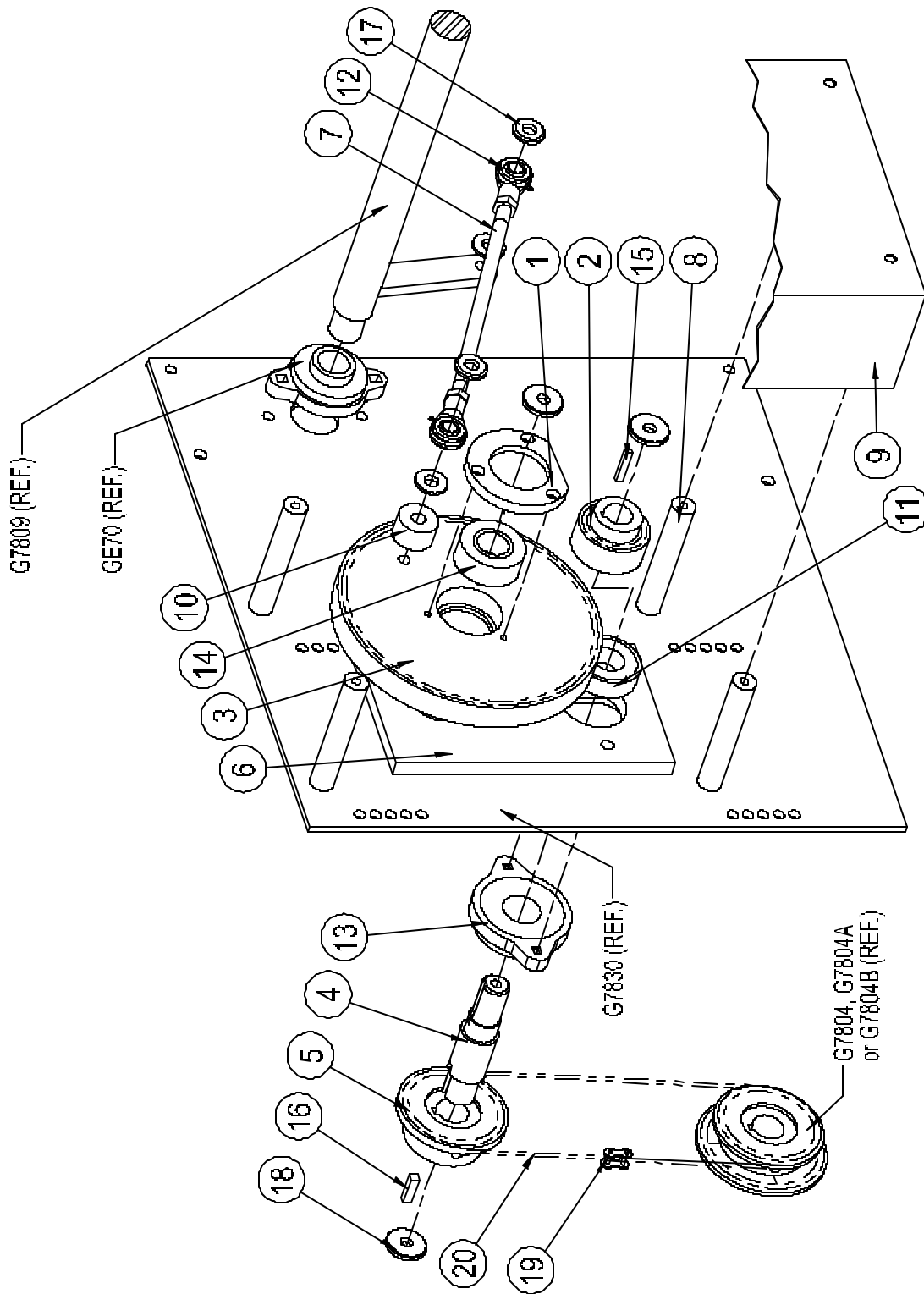
Vacuum Feed Cup Mounting Assembly



## Vacuum Feed Drive Mechanism Assembly

Item	Qty.	Part No.	Description
1	1	G2444	RING, BEARING CLAMP
2	1	G3362	GEAR, TRANSMISSION PINION
3	1	G7803	GEAR, VACUUM FEED DRIVE
4	1	G7805	AXLE, PINION DRIVE
5	1	G7806	SPROCKET, VACUUM FEED RATIO CHANGE (4:1)
	1	G7806A	SPROCKET, VACUUM FEED RATIO CHANGE (6:1)
	1	G7806B	SPROCKET, VACUUM FEED RATIO CHANGE (7.2:1 & 8.1)
6	1	G7807A	PLATE, VACUUM FEED DRIVE MOUNTING
7	1	G7808	CON ROD, VACUUM FEED DRIVE
8	4	G7831	STUD, VACUUM FEED GUARD MOUNTING
9	1	G7832	GUARD, VACUUM FEED DRIVE MECHANISM
10	1	GB79	BUSHING, DRIVE GEAR CRANK SPACER
11	1	GE13A	BEARING, PINION GEAR (N.D.#488505)
12	2	GE51A	BEARING, BALL JOINT ROD END (7/16 ID)
13	1	GE70A	BEARING, 2" HOLE FLANGE (1 3/16 ID)
14	1	GE82	BEARING, DRIVE GEAR (N.D.#5505)
15	1	GJ9D	KEY, PINION GEAR
16	1	GJ10A	KEY, SPROCKET - 1/4 x 1/4 x 1 LONG
17	4	GW1	WASHER, VACUUM FEED DRIVE CON ROD
18	3	GW12	WASHER, DRIVE GEAR & SPROCKET
19	1	GHB1A	CONNECTING LINK
20		#40	ROLLER CHAIN

Vacuum Feed Drive Mechanism Assembly



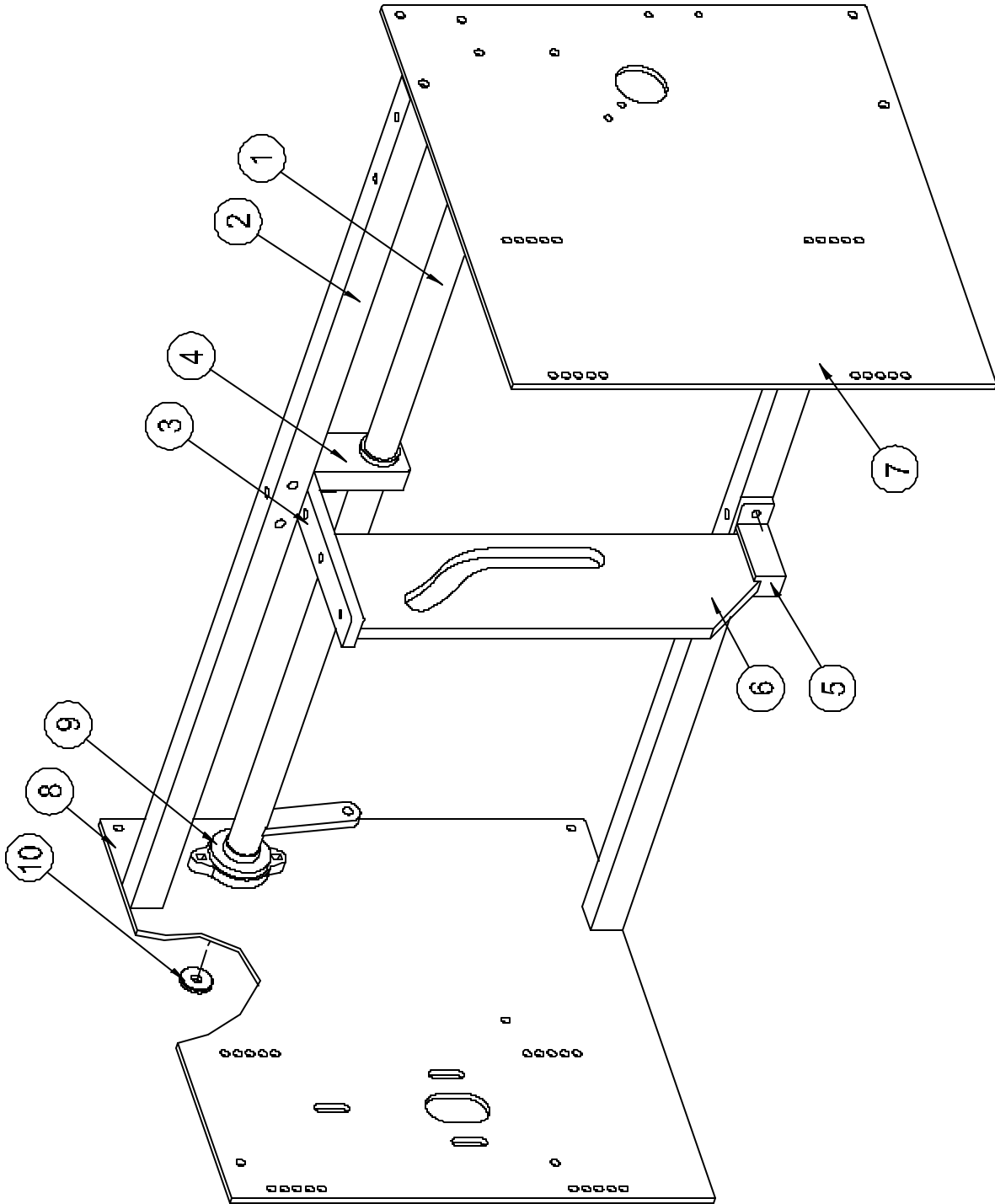
## Vacuum Feed Frame Assembly

Item	Qty.	Part No.	Description
1	1	G7809	SHAFT VACUUM CUP OPERATING
2	2	G7820	BAR, VACUUM CUP SUPPORT
3	1	G7825A	BRACKET, VACUUM FEED CAM TOP
4	1	G7825B	BEARING, VACUUM FEED OPERATING SHAFT CENTER
5	1	G7826	BRACKET, VACUUM CUP CAM BOTTOM SUPPORT
6	1	G7827	CAM, VACUUM CUP OPERATING PLATE
7	1	G7829	PLATE, VACUM FEED MOUNTING
8	1	G7830	PLATE, VACUM FEED MOUNTING
9	2	GE70	BEARING 2" HOLE FLANGE (1" I.D.)
10	1	GW12	WASHER, DRIVE GEAR & SPROCKET

Note: Additional Electrical Components Required

1	GD28	SWITCH, OFF-ON
1	GD63	STARTER, (VACUUM BLOWER)
2	40-0000-04	TERMINAL BLOCK

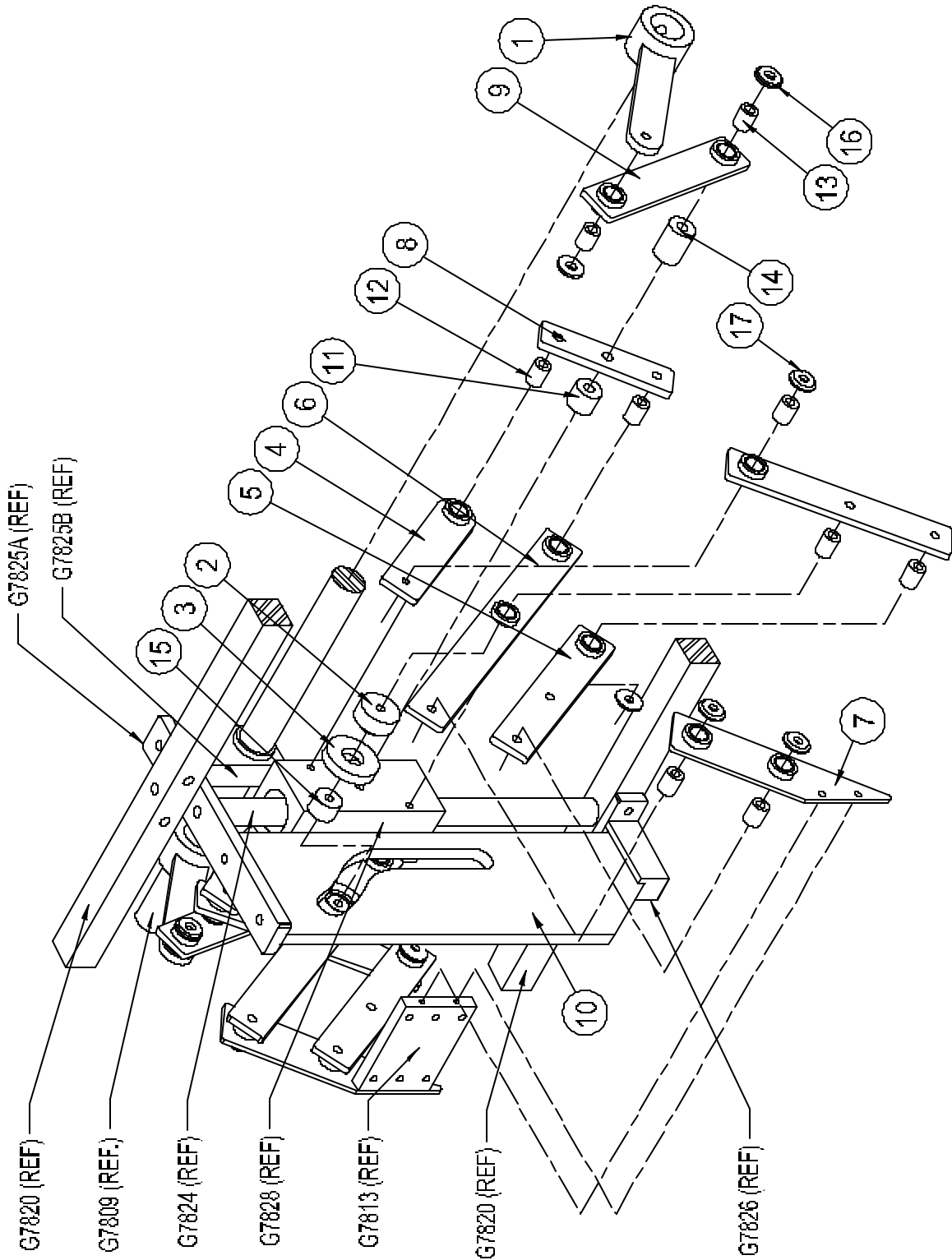
*Vacuum Feed Frame Assembly*



## Vacuum Feed Linkage Assembly

Item	Qty.	Part No.	Description
1	2	G7810	LEVER, VACUUM CUP SLIDE OPERATING
2	2	G7811	SPACER, CAM FOLLOWER
3	2	G7812	PAD, CAM FOLLOWER SPACER WEAR
4	2	G7814	LINKAGE, VACUUM CUP MOUNTING PLATE
5	4	G7815	LEVER, VERTICAL ALIGNMENT
6	2	G7816	LEVER, VACUUM CUP MOUNTING PLATE CARRIER
7	2	G7817A	BRACKET, CUP MOUNTING PLATE
8	2	G7818	PLATE, MAIN LINKAGE MOUNTING
9	2	G7819A	LINK, VACUUM FEED CONNECTING
10	1	G7827	CAM, VACUUM CUP OPERATING PLATE
11	2	GB60	SPACER, LIFT CON ROD MOUNTING
12	14	GB361	BUSHING, VACUUM FEED LINKAGE
13	4	GB435	BUSHING, VACUUM FEED LINKAGE
14	2	GB514	SPACER, LIFT CON ROD MOUNTING
15	1	GE83	BEARING, CAM FOLLOWER (1 OD x 5/16 ID)
16	4	GW1A	WASHER, VACUUM FEED OPERATING SHAFT
17	8	GW1B	WASHER, VACUUM FEED LINKAGE

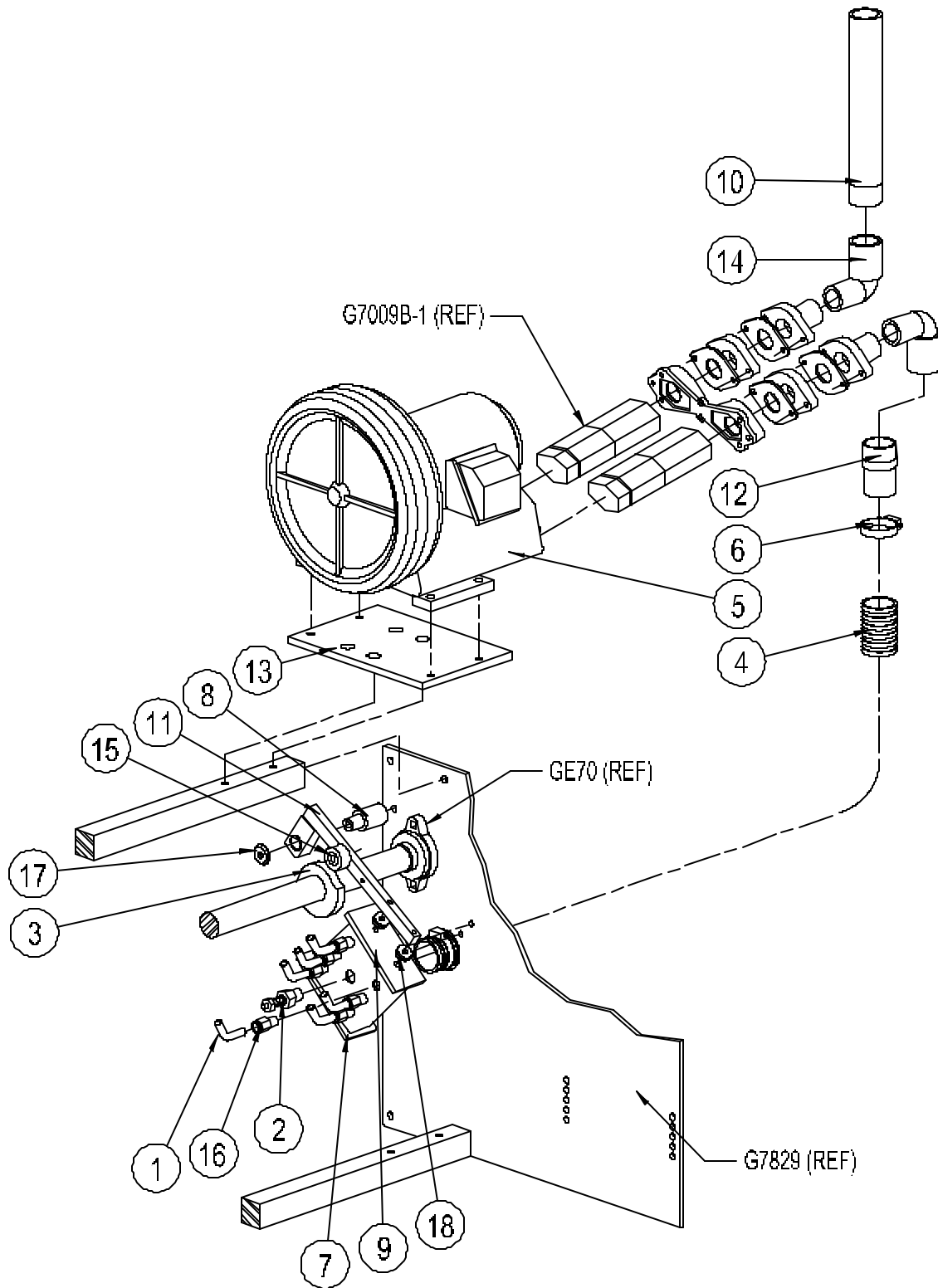
Vacuum Feed Linkage Assembly



## Vacuum Feed Manifold &amp; Blower Assembly

Item	Qty.	Part No.	Description
1	*	G3737	TUBE, POLY FLOW VACUUM (CUT TO LENGTH)
2	1	G4423	VALVE, VACUUM RELIEF
3	1	G4436A	CAM, VACUUM VALVE OPERATING
4	1	G7006	HOSE, 1 1/2 ID VACUUM
5	1	G7009B	BLOWER, VACUUM (.62HP, 3PH, 50/60HZ, 200-230/460V)
	1	G7009C	BLOWER, VACUUM (.62HP, 3PH, 50/60HZ, 600V)
	1	G7009D	BLOWER, VACUUM (.62HP, 1PH, 50/60HZ, 220V)
	1	G7009E	BLOWER, VACUUM (1.0HP, 3PH, 50/60HZ, 200-230/460V)
6	2	G7012	CLAMP,HOSE
7	1	G7553	MANIFOLD, VACUUM PUMP VALVE
8	1	G7554	AXLE, VACUUM VALVE ARM PIVOT
9	1	G7555	PAD, VACUUM VALVE COVER
10	1	G7556	DEFLECTOR, BLOWER EXHAUST
11	1	G7557	ARM, VACUUM VALVE OPERATING
12	1	G7802	FITTING, VACUUM HOSE
13	1	G7833	BASE, VACUUM BLOWER MOUNTING (.62HP)
	1	G7833A	BASE, VACUUM BLOWER MOUNTING (1.0HP)
14	2	G8358	ELBOW, 90 DEG. STREET
15	1	GE50	BEARING, CAM FOLLOWER (1 1/8 OD x 5/16 ID)
16	6	GP7C	1/4 PIPE TO 3/8 TUBE MALE CONNECTOR
17	1	GW1B	WASHER, VACUUM FEED LINKAGE
18	2	GW63	WASHER, VACUUM VALVE COVER PAD

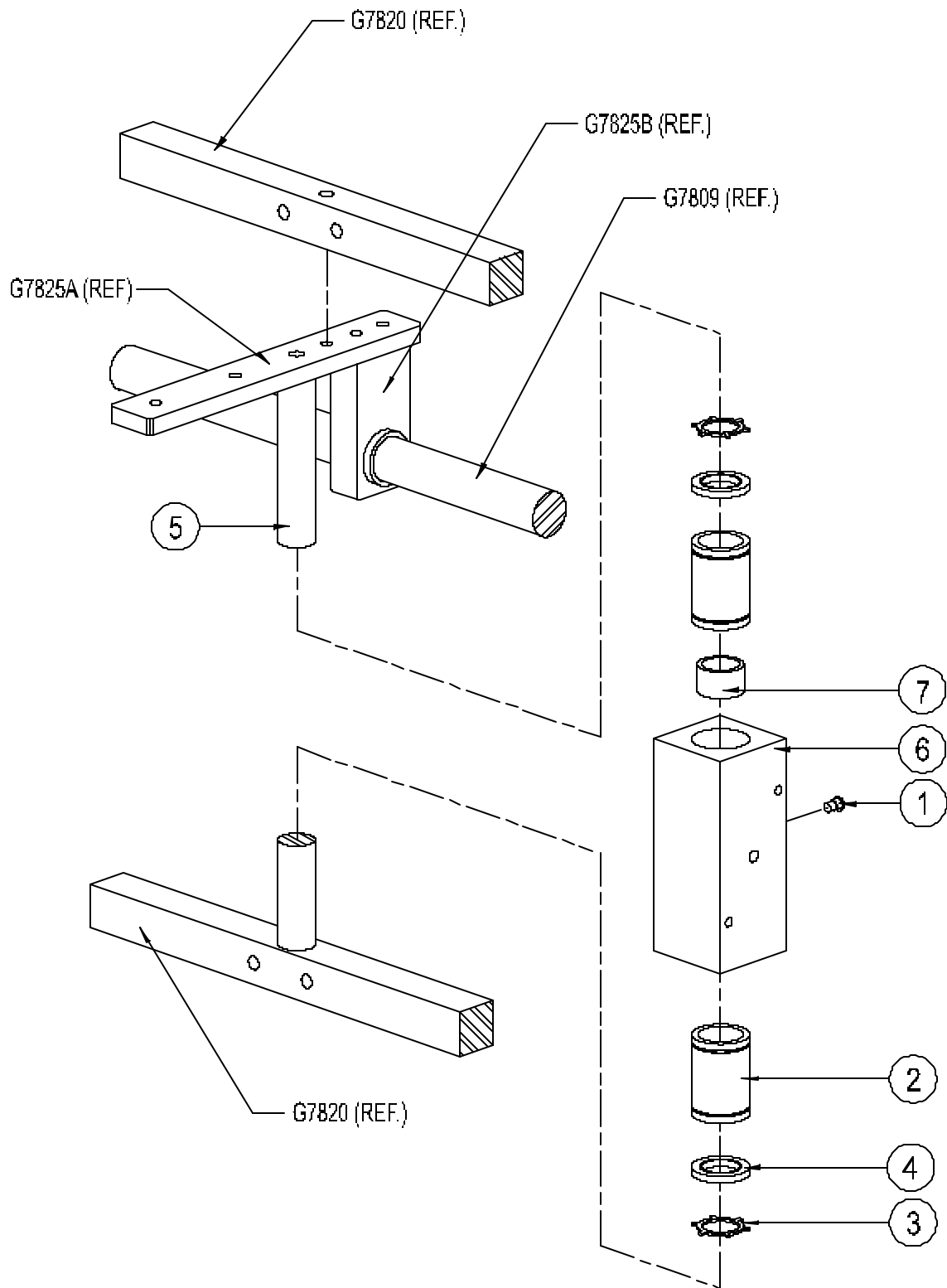
Vacuum Feed Manifold & Blower Assembly



## Vacuum Feed Slide Bearing Assembly

Item	Qty.	Part No.	Description
1	1	G170	COVER, OIL HOLE
2	2	G7821	BEARING, LINEAR BALL SLIDE
3	2	G7822	RETAINING RING, LINEAR BALL BUSHING
4	2	G7823	SEAL, LINEAR BALL BUSHING
5	1	G7824	SHAFT, VACUUM FEED SLIDE BLOCK
6	1	G7828	BLOCK, SLIDE BEARING
7	1	GB326	SPACER, LINEAR BEARING, 1 1/4 OD x 1 ID x 3/4 LONG

Vacuum Feed Slide Bearing Assembly

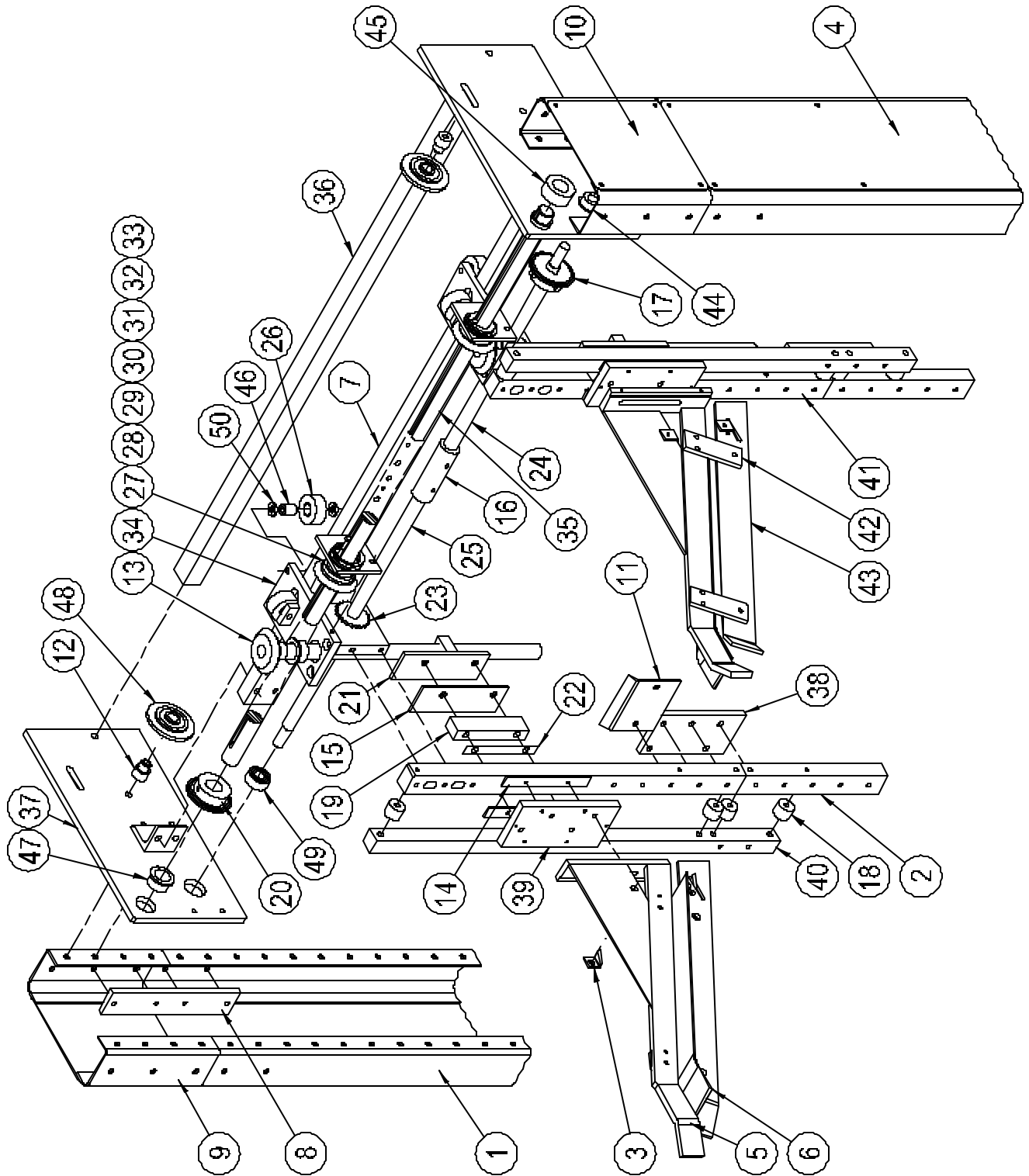


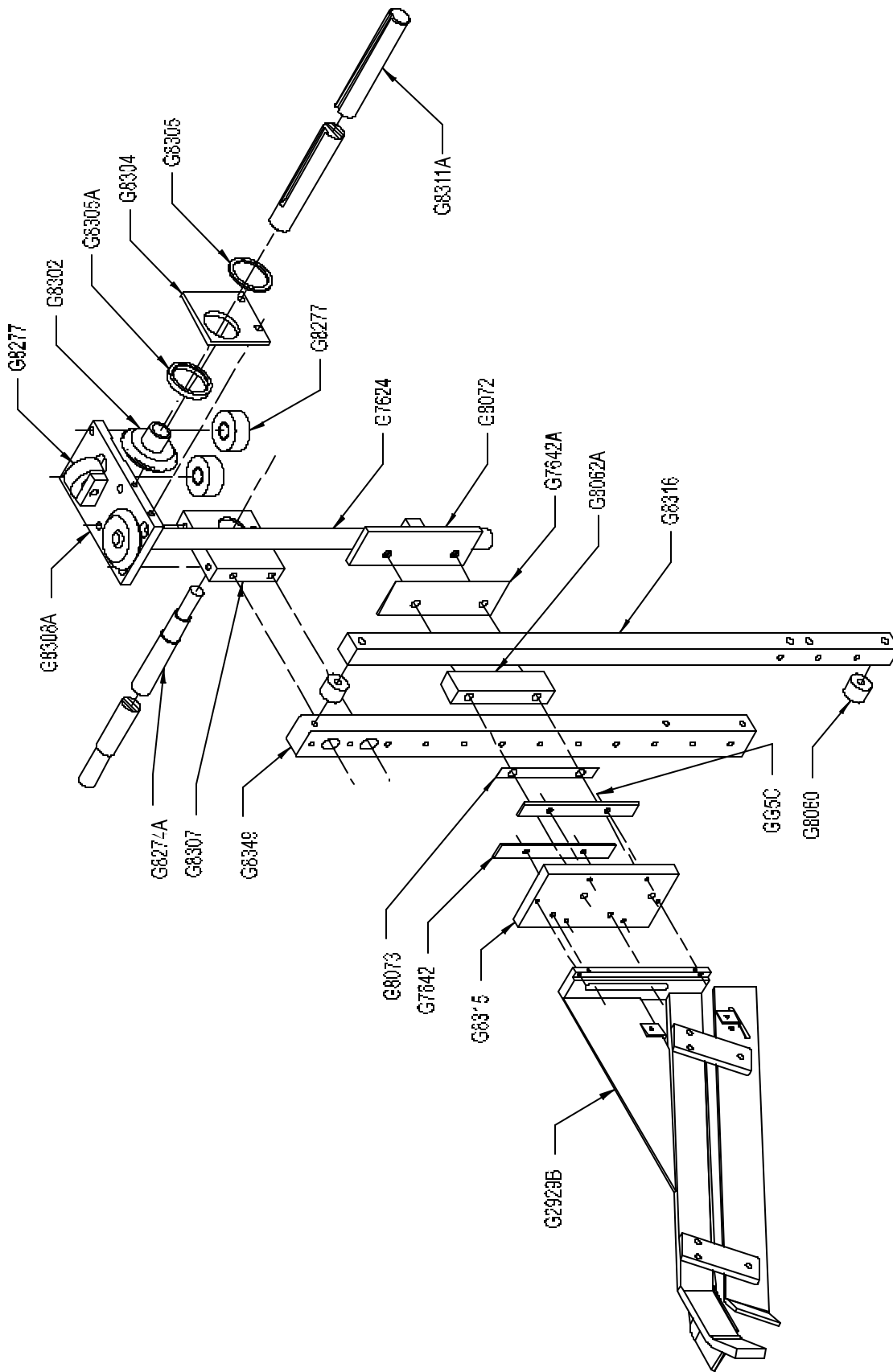
## Vertical Guides &amp; Hopper Assembly

Item	Qty.	Part No.	Description
1	1	5000-39L	ASSEMBLY, MATT FEED SYSTEM UPRIGHT
2	1R / 1L	5000-42	BAR, TRAY MATT VERTICAL GUIDE
3	1R / 1L	G1562B	KNIFE, MATT SUPPORT
4	1	G2754D	COVER, MATT FEED SYSTEM (R.H)
5	1R / 1L	G2929B	BAR, TRAY MATT BLADE SUPPORT
6	1R / 1L	G2937L	BLADE, TRAY MATT BLANK HOPPER SUPPORT
7	1	G2999D	BAR, MATT FEED IDLER ROLLER MOUNT
8	4	G3021A	PLATE, MATT FEED EXTENSION
9	4	G3022A	EXTENSION, MATT FEED FRAME
10	2	G3031A	COVER, MATT FEED EXTENSION
11	2	G3184	STOP, MATT RETAINER
12	2	G3377A	AXLE, IDLER SPROCKET
13	2	G76245R	SCREW, TOP COMPRESSION ADJUSTMENT
14	4	G7642	STRIP, WEAR
15	2	G7642A	STRIP, WEAR WIDE
16	1	G7668	COUPLINGM ADJUSTING SCREW
17	1	G7669	SPROCKET COMPRESSION ADJUSTING
18	8	G8060	SPACER, MATT GUARD BAR MOUNTING
19	2	G8062	BLOCK, MATT GUIDE SPACER
20	1	G8068	SPROCKET, MATT SHAFT ADJUSTING
21	1R / 1L	G8072	BLOCK, HOPPER ADJUST MATT
22	2	G8073	SHIM, HOPPER
23	1R / 1L	G8251	NUT, ADJUSTING SCREW
24	1	G8274A	SCREW, HORIZONTAL TREE ADJUSTING TOP
25	1	G8275A	SCREW, HORIZONTAL TREE ADJUSTING TOP
26	6	G8277	ROLLER, GUIDE SUPPORT
27	2	G8302	GEAR, HOPPER ADJUSTMENT
28	2	G8303	HEY, HOPPER ADJUSTMENT GEAR
29	2	G8304	YOKE, HOPPER GEAR RETAINER
30	2	G8305	SPACER, GEAR MOUNTING
31	2	G8305A	SPACER, GEAR MOUNTING
32	2	G8306	RING, HOPPER ADJUSTING RETAINER
33	2	G8307	BRACKET, TOP GUIDE ADJUSTING
34	2	G8308A	PLATE, TOP VERTICAL GUIDE
35	1	G8311A	SHAFT, VERTICAL HOPPER ADJUSTMENT DRIVE
36	1	G8312	BAR, TOP UPRIGHT FRAME SPACER
37	2	G8313A	PLATE, KWIK CHANGE FRAME TOP SIDE
38	2	G8314	PLATE, TREE SPLICE
39	2	G8315	PLATE, BLISS HOPPER MOUNTING

40	2	G8316	BAR, BLISS HOPPER SLIDE SIDE
41	1R / 1L	G8349	EXTENSION, MATT GUIDE
42	4	G8420	BRACKET, HOPPER SIDE GUIDE & STOP MOUNTING
43	2	G8421	GUIDE, TRAY HOPPER SIDE
44	2	GA8	SET COLLAR, ADJUSTING SPROCKETS
45	2	GA11	SET COLLAR, SHAFT HOPPER ADJUSTMENT SCREW
46	6	GB487	AXLE, ROLLER GUIDE SUPPORT
47	4	GB512	BUSHING, TOP COMP. & HOPPER ADJUSTMENT SSHAFT
48	2	GC9B	SPROCKET, IDLER (#41 CHAIN)
49	2	GE38	BEARING, MATT FEED IDLER ROLL
50	6	GW64	WASHER, AXLE ROLLER GUIDE SUPPORT

Vertical Guides & Hopper Assembly

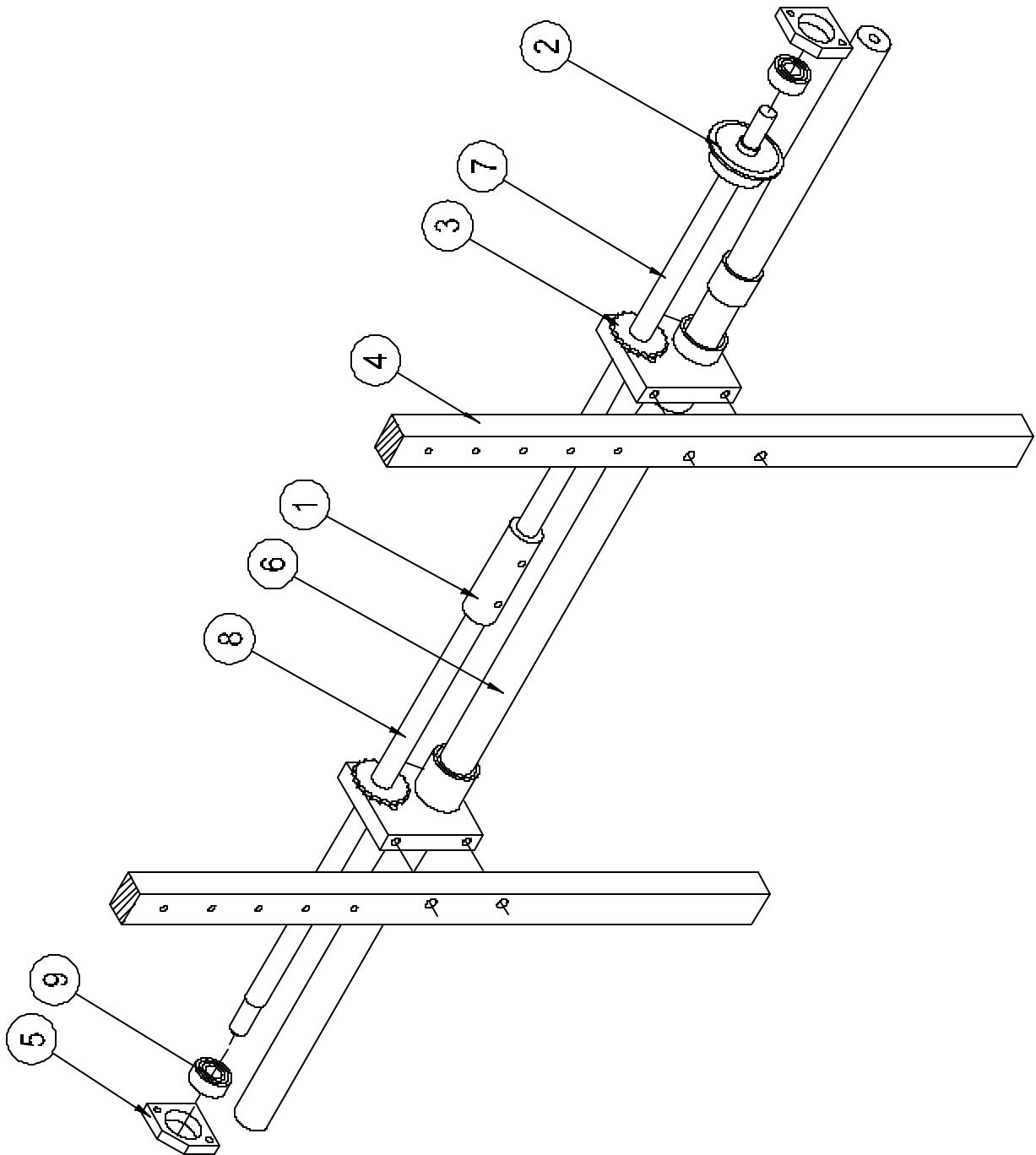




## Vertical Guide Bottom Mounting Assembly

Item	Qty.	Part No.	Description
1	1	G7668	COUPLING, ADJUSTING SCREW
2	1	G7669	SPROCKET COMPRESSION ADJUSTING
3	1R / 1L	G8251	NUT, SDJUSTING SCREW
4	1R / 1L	5000-42	EXTENSION, MATT GUIDE
5	2	5000-06	PLATE, BEARING SEAT
6	1	5000-52	SHAFT, TREE SUPPORT
7	1	5000-53	LOWER R.H. TREE SCREW
8	1	5000-54	LOWER L.H. TREE SCREW
9	2	GE38	BEARING

*Vertical Guide Bottom Mounting Assembly*



# Master Parts List

The following are the standard parts used on a TF 400VK machine.

Qty.	Stock No.	Part No.	Description
3	00-01562-02L	G1562BR	KNIFE MATT SUPPORT
3	00-01562-02R	G1562BL	KNIFE MATT SUPPORT
1	00-02411-02	G2411B	FRAME, LOWER ASSEMBLY
4	00-02430-03	G2430C	SPREADER, TRANSMISSION PLATE
1	00-02443-02	G2433B	SHAFT TRANSMISSION PINION
3	00-02444-00	G2444	RING BEARING CLAMP
1	00-02447-00	G2447	RING, MAIN SHAFT BEARING CLAMP
1	00-02456-00	G2456	PINION, TRANSMISSION ( ENLARGED)
1	00-02508-02	G2508	SHAFT, TRANSMISSION GEAR
1	00-02619-01	G2619A	GEAR, TRANSMISSION MAIN
1	00-02706-03	G2706C	GUARD, FORM MANDREL
1	00-02746-05	G2746E	SUPPORT, MATT HOPPER LOADING
1	00-02754-04	G2754D	COVER, MATT FEED SYSTEM
1	00-02772-01L	G2772AL	FRAME ASSY MATT FEED SYSTEM
1	00-02772-01R	G2772AR	FRAME ASSY MATT FEED SYSTEM
1	00-02775-01	G2775A	BAR, MATT FEED FRAME SPREADER
2	00-02785-08L	G2785HL	SHOE TRAY FORMING (1T6K)
2	00-02785-08R	G2785HR	SHOE TRAY FORMING (1T6K)
4	00-02833-00	G2833	CLIP, TRANSMISSION COVER SUPPORT
4	00-02879-01	G2879A	PAWL, TRAY STRIPPER
2	00-02880-00	G2880	COVER, LOWER TRANSMISSION
1	00-02906-01	G2906A	WHEEL, MATT FEED 9 INCH
1	00-02908-00	G2908	ROLLER,MATT FEED IDLE
2	00-02910-00	G2910	BRACE, MATT GUIDE VERTICAL BAR
1	00-02911-01	G2911A	SHAFT, MATT FEED IDLE ROLLER
4	00-02918-00	G2918	GIB, TRAY MATT SUPPORT BAR
2	00-02927-02L	G2927BL	PLOW, INNER FLAP FORMING
2	00-02927-02R	G2927BR	PLOW, INNER FLAP FORMING
4	00-02933-03	G2933C	SHOE TRAY FORMING SLIDE
4	00-02934-00	G2934	PLATE, MATT HOPPERGATE MOUNT
1	00-0293712L	G2937LL	BLADE,TRAY BLANK HOPPER SUPPORT
1	00-0293712R	G2937LR	BLADE,TRAY BLANK HOPPER SUPPORT
4	00-02942-03	G2942C	STUD, CLAMP SUPPORT (BLISS)
2	00-02997-11	G2997K	HEATER ADHESIVE MELT
1	00-02999-04	G2999D	BAR, BAR, MATT FEED IDLE ROLLER MOUNT
4	00-03018-00	G3018	LATCH, COVER
4	00-03021-02	G3021B	PLATE, MATT FEED EXTENSION

Qty.	Stock No.	Part No.	Description
4	00-03022-01	G3022A	EXTENSION, MATT FEED FRAME
10	00-03028-02	G3028B	SEGMENT, GLUE PROGRAM
4	00-03030-00	G3030	PLATE, GUIDE RAIL CLAMP
2	00-03033-01	G3033A	COVER, MATT FEED EXTENSION
1	00-03064-01L	G3064AL	BAR,MELT POT CLAMP
1	00-03064-01R	G3064AR	BAR,MELT POT CLAMP
4	00-03184-00	G3184	STOP, MATT RETAINER
1	00-03197-00	G3197	WASHER MAIN GEAR RETENTION
4	00-03198-00L	G3198L	DEFLECTOR. MATT
4	00-03198-00R	G3198R	DEFLECTOR. MATT
2	00-03203-00	G3203	GIB, TRAY FORM MANDEL BASE
4	00-03209-04	G3209D	STRIP SEALING FLAP FORMING
1	00-03218-00	G3218	PULLEY JACK SHAFT
1	00-03230-00	G3230	BELT DRIVE
1	00-03237-02	G3237B	SOLENOID, MAGNETIC BRAKE RELEASE(115V)
1	00-03238-00	G3238	BRACKET, BRAKE SOLENOID MOUNT
1	00-03239-00	G3239	LEVER, BRAKE OPERATING
1	00-03240-00	G3240	SCREW, BRAKE LEVER PIVOT
2	00-03241-00	G3241	WASHER, BRAKE PRESSURE SPRING
1	00-03242-00	G3242	BRAKE, SHOE AND LINING
2	00-03243-01	G3243A	STUD, BRAKE SHOE RETAINING
1	00-03244-00	G3244	BOX, BRAKE SOLENOID COVER
1	00-03244-01	G3244A	PLATE, BRAKE SOLENOID COVER MOUNTING
1	00-03245-01	G3245A	CAM, MICRO SWITCH OPERATING
1	00-03362-00	G3362	GEAR, TRANSMISSION PINION (VAC FEED)
10	00-03377-01	G3377A	AXLE, IDLE SPROCKET
1	00-03402-00	G3402	HANDLE CRANK
2	00-03433-14	G3443N	SPACER GLUE PUMP HOUSING (2 1/2")
4	00-03459-00	G3459	BOLT , GLUE PUMP
1	00-03464-00L	G3464L	GUIDE MATT
1	00-03464-00R	G3464R	GUIDE MATT
1	00-03465-00L	G3465L	STOP TRAY BOTTOM
1	00-03465-00R	G3465R	STOP TRAY BOTTOM
4	00-03514-01	G3514A	PLATE, TRAY COMPRESSION EXTENSION
1	00-03536-02	G3536B	GUARD, FEED WHEEL
8	00-03537-02	G3537C	BRACKET GUARD MOUNTING
1	00-03540-00	G3540	MOUNT, ELECTRICAL BOX
1	00-03541-00	G3541	MOUNT, ELECTRICAL BOX
2	00-03565-00	G3565	EXTENSION MATT BRACKET
4	00-03566-00	G3566	BAR, FORM SHOE CLAMP
1	00-03603-00	G3603	END, MANDREL CON ROD

Qty.	Stock No.	Part No.	Description
20	00-03737-00	G3737	TUBE, POLY FLOW VACUUM(CUT TO LENGTH)
4	00-03865-00	G3865	AXLE, STRIPPER LIFT CON ROD BEARING
1	00-04423-00	G4423	VALVE, VACUUM RELIEF
6	00-04432-01	G4432A	TUBE SUCTION CUP MOUNTING
1	00-04436-01	G4436A	CAM VACUUM VALVE OPERATING
6	00-04441-01	G4441A	BRACKET VACUUM CUP TUBE SUPPORT
6	00-04552-00	G4552	PLATE, VACUUM CUP,BACK
6	00-04553-00	G4553	BOLT, VACUUM CUP
6	00-04554-00	G4554	PAD, VACUUM CUP
2	00-04557-00	G4557	BRACKT VACUUM CUP MOUNTING
2	00-04722-01	G4722A	GUIDE , MATT
1	00-04839-01	G4839A	SHAFT,MANDREL CRANK ARM
1	00-04852-01	G4859A	STUD, MANDREL MOUNTING
1	00-04852-02	G4859B	KNOB, MANDREL MOUNTING STUD
2	00-5000-01	5000-01	WEAR STRIP UPPER COMPRESSION
4	00-5000-02	5000-02	BLOCK, COMPRESSION SHOE ADJUSTMENT
1	00-5000-03L	5000-03L	PLATE, TOP COMPRESSION SUPPORT
1	00-5000-03R	5000-03R	PLATE, TOP COMPRESSION SUPPORT
2	00-5000-04	5000-04	BAR, LOWER ADJUSTMENT SHAFT SUPPORT
1	00-5000-05L	5000-05L	PLATE, MATT FEED ROLL SHAFT MOUNTING
1	00-5000-05R	5000-05R	PLATE, MATT FEED ROLL SHAFT MOUNTING
2	00-5000-06	5000-06	PLATE, BEARING SEAT
2	00-5000-08	5000-08	BAR, UPPER BTM. STOP BRG. BLOCK MOUNT.
2	00-5-000-09	5000-09	BRACKET, BOTTOM STOP EXTENSION
1	00-5000-10	5000-10	SPRKT. VERT. ADJ. SCREW (R.H)
1	00-5000-11	5000-11	SPRKT. VERT. ADJ. SCREW (L.H)
1	00-5000-12	5000-12	SPRKT. VERT. ADJ. SCREW (L.H) CROSS
2	00-5000-14	5000-14	BLOCK VERT. ADJ. SCREW BOTTOM BEARING
2	00-5000-15	5000-15	BLOCK VERT. ADJ. SCREW TOP BEARING
2	00-5000-16	5000-16	SCREW, VERT COMPRESSION ADJUSTING
2	00-5000-17	5000-17	BAR, VERT. COMP. ADJ. GUIDE
1	00-5000-18	5000-18	BRACKET, VERT. ADJ. GEAR BOX MOUNTING
1	00-5000-19R	5000-19R	BRACKET, VERT. GUIDE SUPPORT (R.H)
1	00-5000-20L	5000-20L	BRACKET, VERT. GUIDE SUPPORT (L.H)
1	00-5000-21	5000-21	PLATE, VERT, COMP. ADJUST DRIVE CRANK
2	00-5000-22	5000-22	PLATE, IDLE SPROCKET MOUNTING
2	00-5000-23	5000-23	PLATE, IDLE SPROCKET MTG. CLAMP
1	00-5000-26	5000-26	SPACER, VERTICAL COMP. ADJ. SHAFT (L.H)
1	00-5000-27	5000-27	SPACER, VERTICAL COMP. ADJ. SHAFT (R.H)
1	00-5000-32	5000-32	SPACER, MANDREL CARRIAGE
1	00-5000-33L	5000-33L	PLATE, MANDREL CARIAGE SIDE

Qty.	Stock No.	Part No.	Description
1	00-5000-33R	5000-33R	PLATE, MANDREL CARIAGE SIDE
1	00-5000-34	5000-34	PLATE, MANDREL MOUNTING
2	00-5000-35	5000-35	SPACER, MANDREL GUIDE SUPPORT BAR
1	00-5000-36	5000-36	SPACER, MANDREL CARRIAGE TOP
1	00-5000-37	5000-37	SPACER, MANDREL CARRIAGE BOTTOM
1	00-5000-38	5000-38	SHAFT, CON ROD PIVOT
1	00-5000-40L	5000-40L	PLATE, KWIK CHANGE FRAME TOP SIDE
1	00-5000-40R	5000-40R	PLATE, KWIK CHANGE FRAME TOP SIDE
1	00-5000-41	5000-41	SHAFT, VERT. HOPPER ADJ. DRIVE
1	00-5000-42L	5000-42L	VERTICAL GUIDE 1T4K LEFT
1	00-5000-42R	5000-42R	VERTICAL GUIDE 1T4K RIGHT
1	00-5000-44	5000-44	HOPPER ADJUSTING CRANK
1	00-5000-45	5000-45	BASE, VACUUM BLOWER MOUNTING
1	00-5000-46L	5000-46L	BRACKET, PROGRAM WHEEL ADJUSTING
1	00-5000-46R	5000-46R	BRACKET, PROGRAM WHEEL ADJUSTING
2	00-5000-47	5000-47	DISC, INTERMITTENT GLUE PROGRAM
1	00-5000-48	5000-48	WHEEL, MATT FEED
1	00-5000-49	5000-49	SHAFT, MATT FEED ROLL
2	00-5000-50	5000-50	PLATE, BOTTOM STOP BEARING MOUNTING
1	00-5000-51	5000-51	VERT. GUIDE CRANK
2	00-5000-52	5000-52	SHAFT, VERT, GUIDE SUPPORT
1	00-5000-53	5000-53	LOWER (R.H) , VERTICAL GUIDE SCREW
1	00-5000-54	5000-54	LOWER (L.H) , VERTICAL GUIDE SCREW
1	00-5000-55	5000-55	UPPER (R.H) HOR. COMPRESSION. SCREW
1	00-5000-56	5000-56	LOWER (R.H) HOR. COMPRESSION SCREW
1	00-5000-57	5000-57	UPPER(L.H) HOR. COMPRESSION SCREW
1	00-5000-58	5000-58	LOWER (L.H) HOR. COMPRESSION SCREW
1	00-5000-59	5000-59	SHAFT, SHOE COMPRESSION ADJUSTING
1	00-5000-60	5000-60	HOR. COMPRESSION ADJ. CRANK
1	00-5000-61	5000-61	HOR. COMPRESSION ADJ. CRANK
4	00-5000-62	5000-62	BRACKET GUIDE BAR MOUNTING
4	00-5000-63	5000-63	BAR, TOP COMP, SUPPORT - REAR
1	00-5000-64	5000-64	PLATE, BOTTOM STOP DRIVE MOUNTING
2	00-5000-65	5000-65	BOTTOM COMPRESSION SHOE CLAMP
1	00-5000-68	5000-68	BRACKET, INTERLOCK MOUNTING
2	00-5000-69	5000-69	SPACER
1	00-5000-72	5000-72	BASE, DRIVE MOTOR
1	00-5000-73	5000--73	BAR, BOTTOM STOP
1	00-07009-02	G7009B	BLOWER VACUUM
2	00-07012-00	G7012	CLAMP HOSE
2	00-07115-00	G7115	SPROCKET

Qty.	Stock No.	Part No.	Description
1	00-07299-00	G7299	SPRCKT, MATT FEED ROLL SHAFT(PINION)
1	00-07553-00	G7553	MANIFOLD, VACUUM PUMP VALVE
1	00-07554-00	G7554	AXLE, VACUUM VALVE ARM PIVOT
1	00-07555-00	G7555	PAD, VACUUM VALVECOVER
1	00-07556-00	G7556	DEFLECTOR, BLOWER EXHAUST
1	00-07557-00	G7557	ARM, VACUUM VALVE OPERATING
4	00-07574-00	G7574	WASHER INSULATING
4	00-07575-00	G7575	BUSHING, POT INSULATING
1	00-07576-01L	G7576AL	BRACKET, GLUE SYSTEM MOUNTING
1	00-07576-01R	G7576AR	BRACKET, GLUE SYSTEM MOUNTING
1	00-07583-00	G7583	ROD, MANDREL CONNECTING
1	00-07585-00L	G7585L	BASE, TRAY FORMER MANDREL
1	00-07585-00R	G7585R	BASE, TRAY FORMER MANDREL
2	00-07586-00	G7586	BAR, MANDREL GUIDE SUPPORT
1	00-07587-00	G7587	POST, FEED
2	00-07612-00	G7612	SPROCKET, SIDE COMPRESSION CRANK
4	00-07615-00	G7615	CAP, TOP COMPRESSION SUPPORT
8	00-07616-00	G7616	SPACER, TOP COMP. SHOE SUPPORT
2	00-07621-00	G7621	GEAR, TOP COMPRESSION ADJUSTING
1	00-07624-00R	G7624R	SCREW, TOP COMPRESSION ADJUSTING
2	00-07638-00	G7638	MOUNT, MATT FEED IDLE ROLL
6	00-07642-00	G7642	STRIP WEAR
2	00-07642-01	G7642A	STRIP WEAR WIDE
2	00-07643-01	G7643A	SPACER PROGRAM WHEEL BRACKET
2	00-07645-00	G7645	KEY, PROGRAM WHEEL
4	00-07668-00	G7668	COUPLING, ADJUSTING SCREW
1	00-07669-00	G7669	SPROCKET, COMPRESSION ADJUSTING
2	00-07675-00	G7675	FLOAT-A-SHAFT
2	00-07676-00	G7676	WASHER, THRUST
2	00-07681-00	G7681	CAP, TRAY FORMER MANDREL GUIDE
2	00-07682-00	G7682	SPACER, TRAY FORMER GUIDE CAP
1	00-07802-00	G7802	FITTING, VACUUM HOSE
1	00-07803-00	G7803	GEAR, VACUUM FEED DRIVE
1	00-07804-00	G7804	SPROCKET , VACUUM FEED DRIVE
1	00-07805-00	G7805	AXLE, PINION DRIVE
1	00-07806-00	G7806	SPROCKET, VACUUM FEED RATIO CHANGE
1	00-07807-01	G7807A	PLATE, VACUUM FEED DRIVE MOUNTING
1	00-07808-01	G7808A	CON ROD, VACUUM FEED DRIVE
1	00-07809-00	G7809	SHAFT, VACUUM CUP OPERATING
2	00-07810-00	G7810	LEVER, VACUUM CUP SLIDE OPERATING
2	00-07811-00	G7811	SPACER, CAM FOLLOWER

Qty.	Stock No.	Part No.	Description
2	00-07812-00	G7812	PAD, CAM FOLLOWER SPACER WEAR
1	00-07813-00	G7813	PLATE, VACUUM CUP MOUNTING
2	00-07814-00	G7814	LINKAGE, VACUUM CUP MOUNT PLATE
4	00-07815-00	G7815	LEVER, VERTICAL ALIGNMENT
2	00-07816-00	G7816	LEVER, VAC. CUP MOUNT PLATE CARRIER
2	00-07817-01	G7817A	BRACKET, CUP MOUNT PLATE
2	00-07818-00	G7818	PLATE, MAIN LINKAGE MOUNTING
2	00-07819-01	G7819A	ROD, VACUUM FEED CONNECTING
2	00-07820-00	G7820	BAR, VACUUM CUP CAM SUPPORT
2	00-07821-00	G7821	BEARING, LINEAR BALL SLIDE
2	00-07822-00	G7822	RETAINING RING, LINEAR BALL BEARING
2	00-07823-00	G7823	SEAL , LINEAR BALL BUSHING
1	00-07824-00	G7824	SHAFT, VACUUM FEED SLIDE BLOCK
1	00-07825-01	G7825A	BRACKET, VACUUM FEED CAM TOP
1	00-07825-02	G7825B	BEARING, VAC.FEED OPER. SHAFT CENTER
1	00-07826-00	G7826	BRACKET, VAC.CUP CAM BOTTOM SUPPORT
1	00-07827-00	G7827	CAM, VACUUM CUP OPERATING PLATE
1	00-07828-00	G7828	BLOCK, SLIDE BEARING
1	00-07829-01	G7829A	PLATE, VAC. FEED MOUNTING (R.H)
1	00-07830-01	G7830A	PLATE, VAC. FEED MOUNTING (L.H)
3	00-07831-00	G7831	STUD, VACUUM FEED GUARD MOUNTING
1	00-07831-01	G7831A	STUD, VACUUM FEED GUARD MOUNTING
1	00-07832-01	G7832A	GUARD, VAC FEED
1	00-07835-00L	G7835L	RAIL CARRIAGE
1	00-07835-00R	G7835R	RAIL CARRIAGE
1	00-07848-00	G7848	ROD, MATT DEFLECTOR MOUNTING
1	00-07849-00	G7849	DEFLECTOR MATT TOP
2	00-07905-00	G7905	BAR, VACUUM CUP BOTTOM PLACEMENT
2	00-07906-00	G7906	PLATE, HOPPER BOTTOM STOP
1	00-07907-00	G7907	BAR, HOPPER BOTTOM STOP PLATE
4	00-08060-00	G8060	SPACER, MATT GUIDE BAR MOUNTING
2	00-08061-00	G8061	WASHER, MATT HOPPER ADJUSTING SCREW
2	00-08062-01	G8062A	BLOCK, MATT GUIDE SPACER
6	00-08073-00	G8073	SHIM HOPPER
2	00-08232-00	G8232	PAN, GLUE PUMP DRIP
1	00-08233-00L	G8233L	ANGLE, DRIP PAN MOUNTING
1	00-08233-00R	G8233R	ANGLE, DRIP PAN MOUNTING
2	00-08243-00	G8243	HUB, PROGRAM WHEEL MOUNTING
6	00-08244-00	G8244	SET COLLAR, VACUUM TUBE LOCATING
1	00-08246-00L	G8246L	MOUNT. GLUE MOUNTING BRACKET
1	00-08246-00R	G8246R	MOUNT. GLUE MOUNTING BRACKET

Qty.	Stock No.	Part No.	Description
4	00-08251-00L	G8251L	NUT, ADJUSTING SCREW
4	00-08251-00R	G8251R	NUT, ADJUSTING SCREW
1	00-08274-01	G8274A	SCREW, HORIZONTAL TREE ADJUSTING TOP
1	00-08275-01	G8275A	SCREW, HORIZONTAL TREE ADJUSTING TOP
4	00-8277-00	G8277	ROLLER GUIDE SUPPORT
4	00-08278-01	G8278	BLOCK, BOTTOM STOP MOUNTING
2	00-08279-00	G8279	BLOCK, BOTTOM STOP MOUNTING
1	00-08280-00	G8280	BAR, BOTTOM STOP
2	00-08281-01	G8281A	SCREW, BOTTOM STOP ADJUSTING
1	00-08283-00	G8283	PLATE, BOTTOM STOP DRIVE MOUNTING
2	00-08284-00	G8284	PLATE, BOTTOM GEAR BOX
2	00-08285-00	G8285	AXLE, BOTTOM STOP DRIVE
1	00-08286-00	G8286	PLATE, BOTTOM STOP DRIVE CRANK
2	00-08287-00	G8287	SPROCKET, BOTTOM STOP DRIVE
2	00-08288-00	G8288	GEAR, BOTTOM STOP DRIVE SHAFT
2	00-08289-00	G8289	COVER, BOTTOM STOP DRIVE GEAR BOX
1	00-08290-00	G8290	PLATE, BOTTOM STOP TAKE UP
2	00-08302-00	G8302	GEAR, HOPPER ADJUSTING
2	00-08303-00	G8303	KEY, HOPPER ADJUSTING GEAR
2	00-08304-00	G8304	YOKE HOPPER GEAR RETAINING
4	00-08305-00	G8305	SPACER, GEAR MOUNTING
4	00-08305-01	G8305A	SPACER, GEAR MOUNTING
4	00-08306-00	G8306	RING, HOPPER ADJUSTING RETAINING
2	00-08307-00	G8307	BRACKET, TOP GUIDE ADJUSTING
2	00-08308-01	G8308A	PLATE, TOP VERTICAL GUIDE
1	00-08312-00	G8312	BAR, TOP UPRIGHT FRAME SPACER
2	00-08314-00	G8314	PLATE TREE SPLICE
2	00-08315-00	G8315	PLATE, BLISS HOPPER MOUNTING
2	00-08316-00	G8316	BAR, BLISS HOPPER SLIDE GUIDE
1	00-08345-00	G8345	SPREADER TRANSMISSION PLATE "K"
2	00-08349-00	G8349	EXTENSION MATT GUIDE
2	00-08422-00	G8422	SPACER, TOP COMP. SUPPORT BEARING
1	01-00005-00	GA5	SET COLLAR SPEED CONTROL KNOB
4	01-00008-00	GA8	SET COLLAR VAC,FEED & ADJ, SPROCKETS
14	01-00009-00	GA9	SET COLLAR,SPD.CNTL KNOB & SET SHAFTS
3	01-00011-00	GA11	SET COLLAR COMP.ADJ. SHAFT& HOP SCREW
4	02-00020-00	GB20	SPACER, GLUE POT ROLLERS
8	02-00053-00	GB53	SPACER, TOP SHOE MOUNTING
2	02-00060-00	GB60	SPACER, LIFT CON ROD MOUNTING
8	02-00061-00	GB61	SPACER, FORMING SHOE CLAMPING
2	02-00064-00	GB64	SPACER, TAKE UP SPROCKET MOUNTING

Qty.	Stock No.	Part No.	Description
1	02-00079-00	GB79	SPACER, DRIVE GEAR CRANK
1	02-00145-00	GB145	BUSHING, SPEED CONTROL ARM SPACER
1	02-00198-00	GB198	SPACER, MOTOR PULLEY
4	02-00262-00	GB262	SPACER, GLUEPOT MTG. BRCKT ROLLER
1	02-00267-00	GB267	SPACER, SPEED CONTROL OPERATING ROD
4	02-00311-00	GB311	BUSHING, COVER MOUNTING
1	02-00326-00	GB326	SPACER, LINEAR BEARING
14	02-00361-00	GB361	BUSHING, VACUUM FEED LINKAGE
1	02-00379-00	GB379	SPACER FEED ROLL SHAFT DRIVE SPRKT.
2	02-00398-00	GB398	BUSHING FORM PLUNGER CON. YOKE
4	02-00410-00	GB410	SPACER, SHOE MOUNTING
8	02-00413-00	GB413	BUSHING SCREW ADJUSTING
2	02-00437-00	GB437	BUSHING, HOPPER ADJUST SHAFT
8	02-00475-00	GB475	SPACER, TRAY COMPRESSION PLATE
4	02-00499-00	GB499	SPACER, TRAY COMPRESSION PLATE
12	02-00511-00	GB511	BUSHING,ADJUSTING SCREW SHAFT
6	02-00512-00	GB512	BUSHING TOP COMP. & HOP. ADJUST SHAFT
2	02-00514-00	GB514	SPACER, LIFT CON ROD MOUNTING
2	03-00009-01	GC9A	SPROCKET, IDLER CHAIN (#40 CHAIN)
5	03-00009-02	GC9B	SPROCKET, IDLER CHAIN (#41 CHAIN)
1	04-00021-00	GD21	MICRO SWITCH FEED POST CAM
1	04-00050-00	GD50	LIGHT SINGLE FLASH STROBE
4	04-00065-01	GD65A	SWITCH, SAFETY INTERLOCK MAGNETIC
1	04-00069-00	GD69	VARI-DRIVE 240 VOLT
1	04-00069-01	GD69A	VARI-DRIVE 440 VOLT
1	04-00069-02	GD69B	VARI-DRIVE SINGLE PHASE
1	05-00002-00	GE2	BEARING TRANSMISSION SHAFT
1	05-00003-00	GE3	BEARING TRANSMISSION SHAFT (L.H)
2	05-00013-00	GE13	BEARING, FEED POST & PINION SHAFT (L.H)
3	05-00013-01	GE13A	BEARING, FEED POST & PINION SHAFT (R.H)
2	05-00038-00	GE38	BEAIRING, MATT FEED IDLE ROLL
1	05-00043-03	GE43C	BEARING, CAM FOLLOWER ROLLER
1	05-00050-00	GE50	BEARING, CAM FOLWER ROLR 1 1/8 Od x 5/16
4	05-00051-00	GE51	ROD END 3/8 FEMALE
2	05-00051-01	GE51A	BEARING BALL JOINT ROD END 7/16 ID
2	05-00064-00	GE64	CAM FOLLOWER BEARING
4	05-00065-01	GE65A	BEARING COMPRESSION SHAFT
2	05-00070-00	GE70	BEARING , 2 HOLE FLANGE 1" ID
3	05-00070-01	GE70A	BEARING , 2 HOLE FLANGE 1 3/16" ID
4	05-00071-00	GE71	BEARING CF !"
1	05-00082-00	GE82	BEARING NDH #55505 OR EQUAL

Qty.	Stock No.	Part No.	Description
1	05-00083-00	GE83	CAM YOKE ROLLER
2	07-00005-02	GG5B	ROLL PIN TOP COMPRESSION GEAR
20	07-00005-03	GG5C	PIN 3/16 x 5/16" BRASS
1	07-00005-04	GG5D	PIN,ROLL
25	08-00001-00	GHI	ROLLER CHAIN #41 RIV
25	08-20001-00	GH2	ROLLER CHAIN , #40N RIV BULK
2	08-20001-01	GH2A	MASTER LINK #40
1	08-20001-11	GH2K	ROLLER CHAIN #40 RIV.
1	10-00006-00	GJ6	KEY, PINION PULLEY
1	10-00009-01	GJ9A	KEY,MATT FEED ROLL DRIVE SPROCKET
3	10-00009-04	GJ9D	KEY
2	10-00010-01	GJ10A	KEY, SPROCKET
1	10-00012-01	GJ12A	KEY, TRANSMISSION MAIN GEAR
1	13-00004-02	GM4B	MOTOR 3/4 HP 1800 RPM BALDOR
1	13-00004-04	GM4D	MOTOR 3/4 HP 1140 RPM
1	13-00005-04	GM5D	MOTOR 1 HP 1140RPM
1	19-00017-00	GS17	SPRING BRAKE RELEASE
4	19-00086-00	GS86	SPRING COVER MOUNTING
4	19-00108-00	GS108	SPRING TRAY STRIPPER PAWL
6	19-00180-00	GS180	SPRING, VACUUM CUP RETURN
4	23-00001-00	GW1	WASHER, VACUUM FEED DRIVE CON ROD
7	23-00001-01	GW1A	WASHER VACUUM FEED OPERATING SHAFT
15	23-00001-02	GW1B	WASHER,VACUUM FEED LINKAGE
6	23-00012-00	GW12	WASHER, SPROCKET & GEAR RETAINING
5	23-00056-00	GW56	WASHER, GLUE POT ROLLER
2	23-00063-00	GW63	WASHER, VACUUM VALVE COVER PAD
8	23-00065-00	GW65	WASHER, ADJUSTING SCREW SHAFT
2	23-00072-00	GW72	WASHER PINION SHAFT
4	23-00084-00	GW84	WASHER VAC.CUP SPC. DIMPLET 5/8 SAE
6	23-00089-00	GW89	WASHER, VACUUM CUP SHOCK ABSORBER
			PREASSEMBLED PACKAGES
	60-00160-03L		STANDARD GLUE PUMP (LEFT)
	60-00160-03R		STANDARD GLUE PUMP (RIGHT)
	60-00170-00		ASSEMBLY, DRIVE MOTOR 1200 RPM
	60-00171-01		ASSEMBLY, IDLER TAKE UP SPROCKET
	60-00176-00		ASSEMBLY, VARI-SPEED DRIVE CONTROL
	60-00178-00		ASSEMBLY, REBOUND STOP
	60-00199-00L		ASSEMBLY, GLUE POT & THERMOSTAT (LEFT)
	60-00199-00R		ASSEMBLY, GLUE POT & THERMOSTAT(RIGHT)

Qty.	Stock No.	Part No.	Description
	60-00269-00		BOX CONTROL STANDARD ELECTRICAL

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