

# TF 400V / 600V TRAY-MATIC®

Options



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# Table of Contents

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Table of Contents.....	3
Introduction.....	7
Safety.....	7
Equipment Safety.....	8
Precautions and Warnings.....	8
Power Disconnect Switch.....	9
Additional Safety Notes.....	10
Vacuum Feed.....	11
Overall Operation.....	24
Troubleshooting the Vacuum Feed System.....	25
Lubrication Procedures.....	27
Options – Parts List and Illustrations.....	31
Vacuum Feed Frame Assembly.....	34
Vacuum Feed Drive Mechanism Assembly.....	36
Vacuum Feed Manifold and Blower Assembly.....	38
Vacuum Feed Linkage Assembly.....	39
Vacuum Feed Linkage Assembly.....	40
Vacuum Feed Slide Bearing Assembly.....	42
Vacuum Feed Cup Mounting Assembly.....	44
Feed Roll And Programmer Assembly (Vacuum Pick).....	46
Transmission Gear Shaft Assembly.....	48
Double Capacity Adhesive Melt Pot (Optional).....	50
Vari Speed Control Knob Assembly.....	56
Mandrel Stop Brake Assembly.....	57
Mandrel Stop Brake Assembly.....	58
“V” Belt Vari-Drive Assembly.....	60
Master Parts List.....	62
Vacuum Feed Parts List : (optional).....	62
Options.....	65

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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.</p> <p>1949 E Manning Ave</p> <p>Reedley, CA 93654</p> <p>2003</p>
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## Introduction

The traymatic machines may be referred to by two different machine notations.

New Designation	Old Designation
TF 400V Traymatic	1T4 Traymatic
TF 600V Traymatic	1T6 Traymatic

The following terms are interchangeable:

- Traymatic, Former, Case Former, Tray Former, and Machine
- Carton, Box, Tray, Case, Blank
- Glue, Adhesive, Bonding Material

## Safety

Machinery is hazardous when safety precautions are not followed. Follow these safety rules and practices for safe operation of the machinery and to prevent accidents. All operators and maintenance personnel working on or near SWF Companies machinery should be informed and supervised regarding safe machine operation.

All equipment manufactured by SWF Companies is safety tested prior to shipment. 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 new equipment.

Verify all supervisors read and understand the entire contents of the operation portion of this manual, with particular attention to safety precautions. Anyone who works on or around the machine should read and understand 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.
- Accident prevention should be continually evaluated. This means ALL potential hazards must be identified, and either eliminated or safeguarded. Along with creating safe conditions, employees should follow all safety procedures.
- If any questions arise regarding the safe operation or maintenance of this machine, immediately contact the service department of:



SWF Companies  
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## Equipment Safety

SWF machinery uses safety devices to prevent injury to personnel coming into contact with the machine. Check all safety switches and devices daily to ensure they operate properly. Any removal or alteration of these devices results in serious injury.

Device	Description
	<p>Guarding includes sheet metal fixed guards or transparent polycarbonate plastic. Hinged or sliding guard doors are installed in areas requiring easy access.</p> <p>Doors with safety interlocks automatically stop the machine by disconnecting the electrical power and dropping air from the machine when the door opens.</p> <p>The electrical power and air pressure remain off until all guard doors are closed and the start-up sequence is followed.</p>
 <p>The image shows a red emergency stop button with a silver ring. Above the button, the text 'FP-1 EMERGENCY STOP' is printed in white.</p>	<p><b>Emergency Stop, or E-Stop</b> 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.</p> <p>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.</p> <p><b>WARNING:</b> 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.</p>
 <p>The image shows a yellow disconnect switch with a red handle. The handle is currently in the 'ON' position. The text 'ON I' is visible above the handle.</p>	<p>The <b>DISCONNECT SWITCH or CIRCUIT BREAKER</b> 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.</p> <p>To open the electrical cabinet door, first move the disconnect switch to the <b>off</b> position.</p> <p><b>WARNING:</b> Always use the lockout feature of the disconnect switch to ensure the electrical power remains off during any maintenance or repair work.</p> <p>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.</p>

## Precautions and Warnings

1. Always closely observe all DANGER, WARNING and CAUTION signs.
2. Machinery should never be operated or serviced by personnel taking any type of drug or sedative, under the influence of alcohol, or who is experiencing excessive fatigue.
3. Before starting any machinery, confirm all personnel and materials are clear of the machine.
4. Alert all personnel involved with the machine of any automatic cycling features.
5. Do not perform any maintenance or repair work without completing the following:
  - a. Turn off electrical power at the main control panel.
  - b. Use a padlock or other lock-out device to ensure the power stays off.
  - c. Turn off the air supply.
  - d. Use a padlock or other lock-out device to ensure the air stays off.

- e. **NOTE:** Always follow ALL Start-up/Shut-down Procedures.
6. **NEVER** reach into or near any moving parts to clear a jam.
  7. **NEVER** wear loose clothing or jewelry around moving parts.
  8. **NEVER** place fingers near any “nip” point between driving pulleys, gears, belts, or sprockets while the machine is in operation. Take particular care around open areas such as conveyor drive chains, take-up pulleys, overhead ram shafts, case chairs and any carriages.
  9. Always wear protective equipment such as safety glasses, hard hats, and hearing protection where required.
  10. Keep the areas around transfer carriages, cylinders, case chairs, vacuum cap bars, and other moving parts free of obstructions.
  11. Keep all floors around the machine free of obstructions and liquids. All personnel using water nearby should wear non-slip shoes.
  12. Always use SWF recommended replacement parts to prevent injury and machine damage. Consult with SWF regarding possible equivalent substitutions prior to replacing any parts.
  13. Wear safety glasses, safety gloves, and protective clothing to prevent injury from hot applicator parts, splashed hot melt adhesive material, and hot gun services.

**ELECTRICAL:** Always turn off and lock-out the main power disconnect on the electrical cabinet before proceeding with any electrical repairs. When the power must remain on to perform certain tests, use the following guidelines:

- Know what voltages are present before beginning any electrical work.
- **NEVER** allow any part of your body to touch the machine while testing voltages.
- **NEVER** work on a wet floor, a steel floor or other conductive surface. Cement is conductive due its ability to retain moisture. When working on a cement floor, stand on a rubber mat, plywood, or other non-conductive material.

**DANGER: LOCK-OUT ALL POWER AND AIR BEFORE CLEARING ANY JAM.**

After de-energizing the machine, carefully remove product to prevent personal injury or damage to the machine.

**GLUE OPERATIONS:** Wear safety glasses, safety gloves, and protective clothing to prevent injury from hot applicator parts, splashed hot melt adhesive material, and hot gun services.

## Power Disconnect Switch

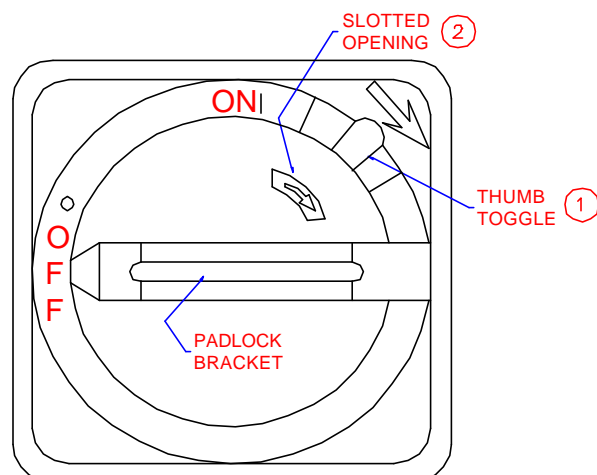
This switch must be in the ON position to operate the machine. Turn OFF when washing the machine or when making repairs or adjustments other than changeovers.

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.

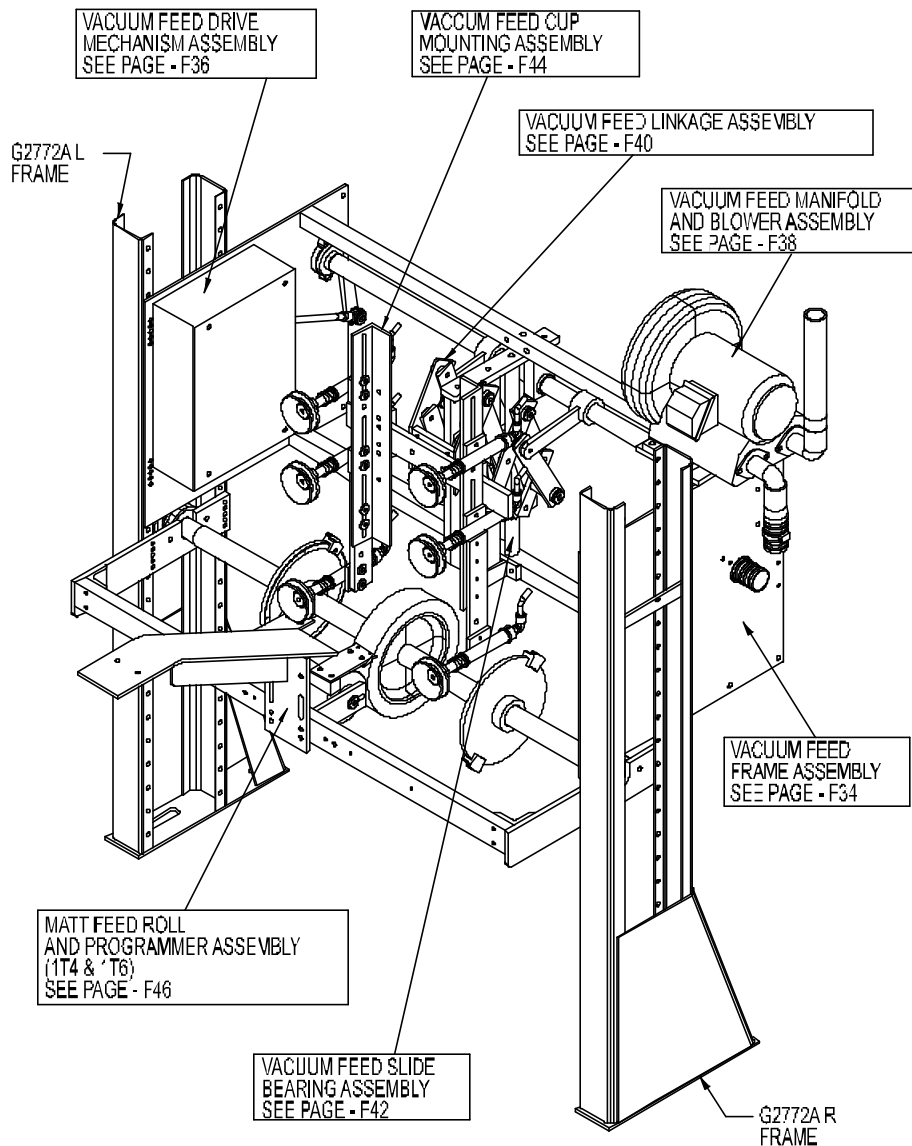


- ① OPENS DOOR WHILE DISCONNECT SWITCH IS IN THE OFF POSITION:  
 1) PUSH DOWN ON THUMB SWITCH  
 2) OPEN DOOR

## Additional Safety Notes

- Examine the frame and machine surfaces for abraded surfaces and sharp edges. File any sharp edges or surfaces smooth and cushion them against collision if the machine is near employee traffic patterns.
- Turn the main power switch to the “OFF” position before removing any guards at a drive or nip point.
- All guards and safety devices (interlocks) as manufactured and installed at the factory must be reinstalled after maintenance and before machine start-up.
- Maintenance personnel should always use protective measures to avoid contact with hot surfaces, resins, glue, or wax during clean up or repair of the adhesive system.
- The adhesive melt pots are provided with a temperature regulator. Turn the machine main electrical disconnect off at the end of each workday.
- Guards mounted at the factory protect the operator from drive units, nip points, and contact with electrical circuitry.
- All guards for the lower transmission, feed post, and program feed wheel must be securely in place before operating the machine.
- All guarding must always be in place while operating. Take extreme caution while making adjustments or size changes with the guards removed.

# Vacuum Feed



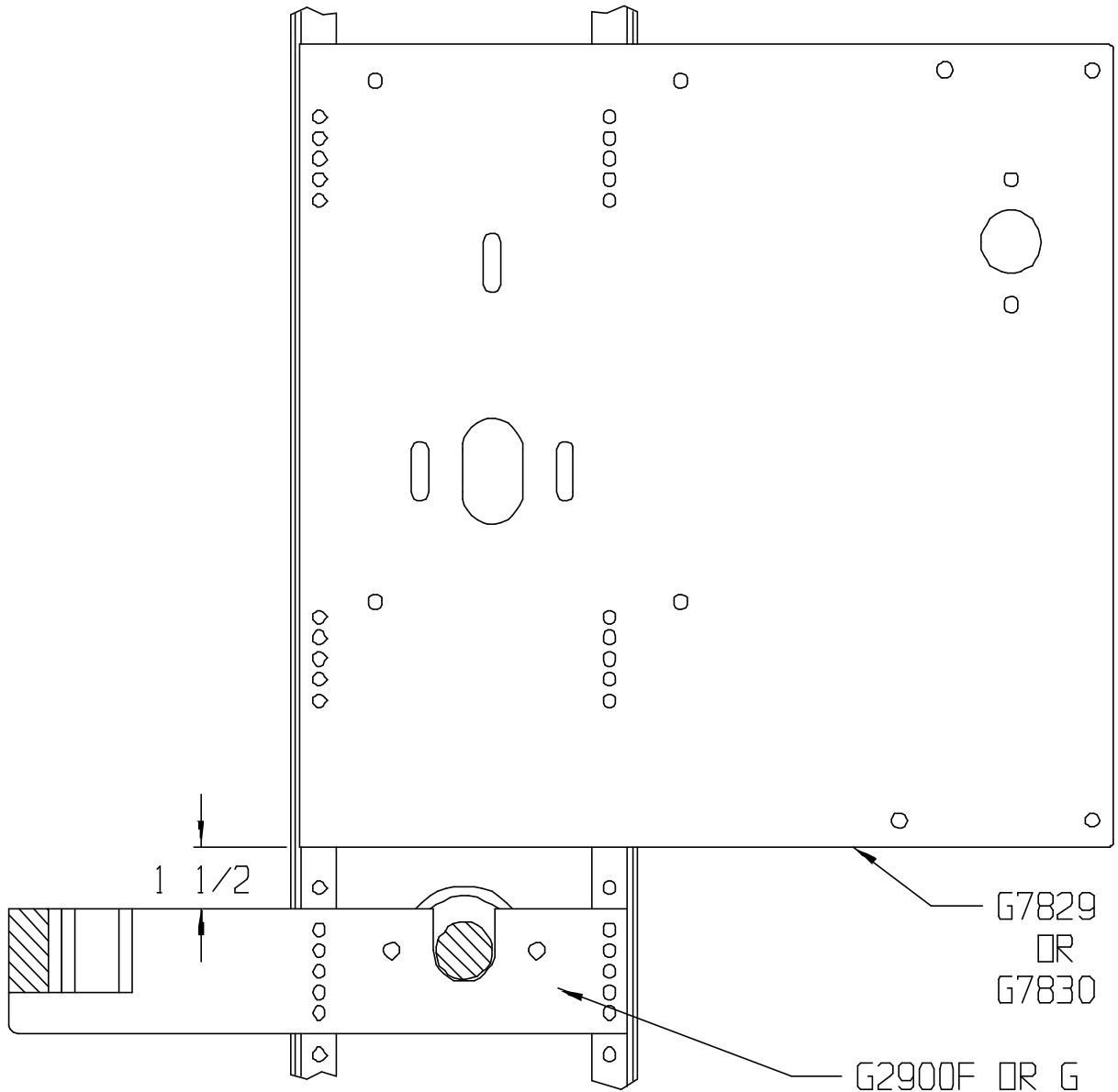
The vacuum feed system operates mechanically. The suction required to pick, or select, each corrugated blank from the hopper is supplied by a 5/8 HP vacuum motor. The vacuum system creates a positive selection of each blank, preventing slippage as the blank inserts into the feed rolls. The vacuum system is more tolerant of slightly warped board within the specifications set forth in the Fibre Box Association manual. Vacuum select also maintains the timing as the blank is glue programmed.

*Vacuum Feed Mount Plates positioning*

Alignment of the vacuum system

1. Mount plate G 7829/G7830 to machine frame uprights.
2. Mount plate should sit 1 1/2" above previously positioned feed roll assembly.

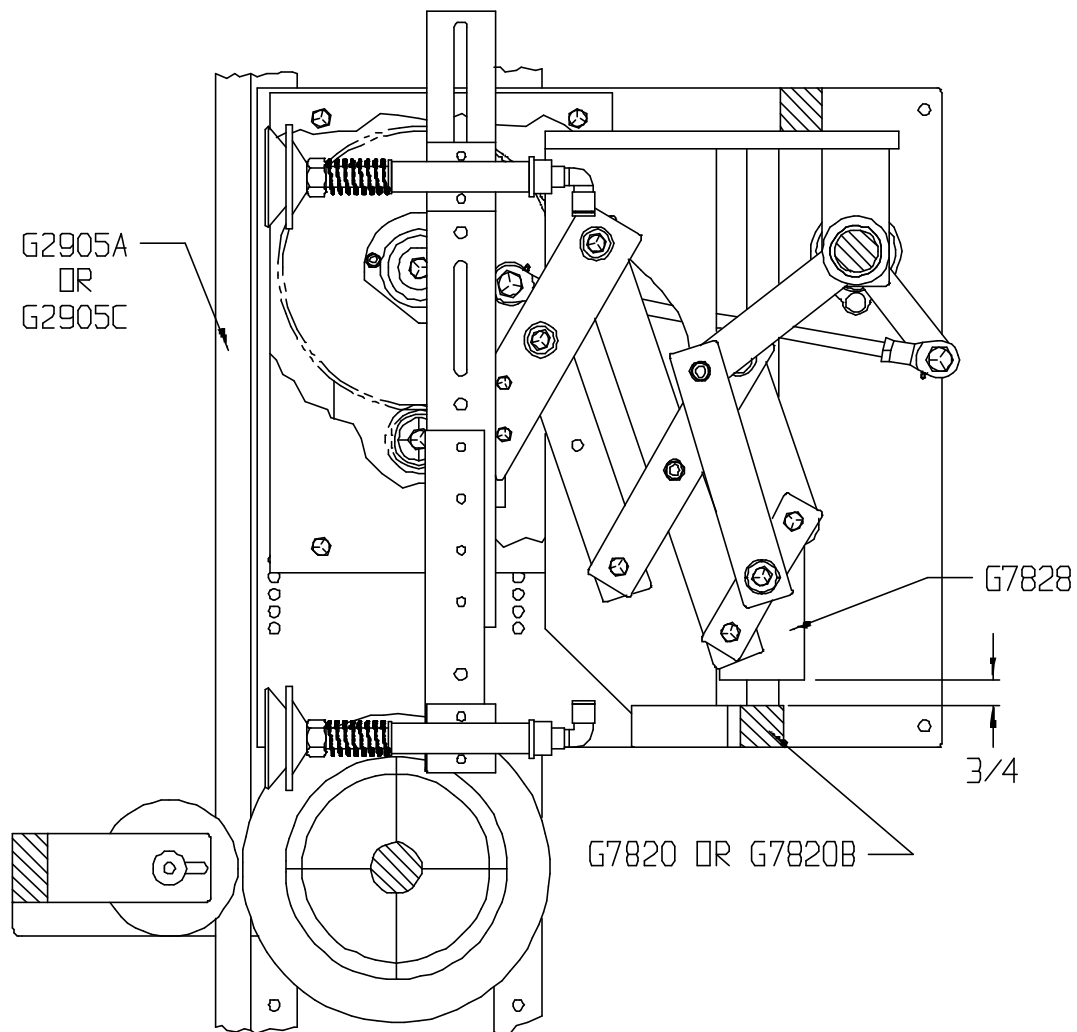
Note: If blank is extremely long a different dimension may be required. (Contact SWF )



### *Vacuum Slide Bearing Block Adjustment*

To adjust the bearing block:

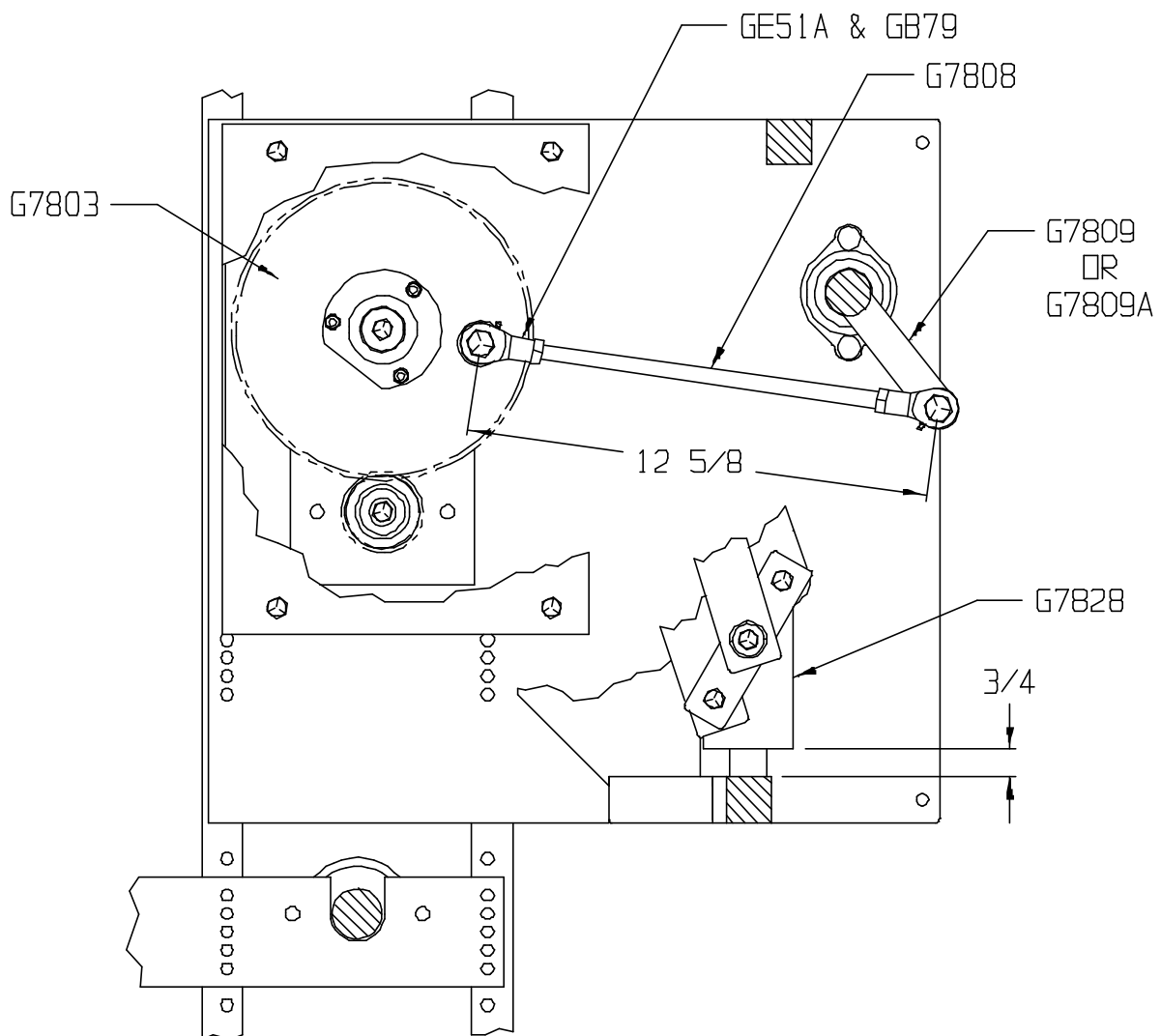
1. Disconnect the vacuum feed chain and jog the mandrel until the beginning of the return stroke.
2. Stop jogging when the mandrel is even with the front of the vertical guide bars (G2905).
3. Slide the bearing block (G7828) until there is  $\frac{3}{4}$ -inches between it and the support bar (G7820).
4. Rest the slide bearing block on a  $\frac{3}{4}$ -inch spacer.
5. This initial set up is required to adjust the connecting rod.



### Vacuum Drive Connecting Rod

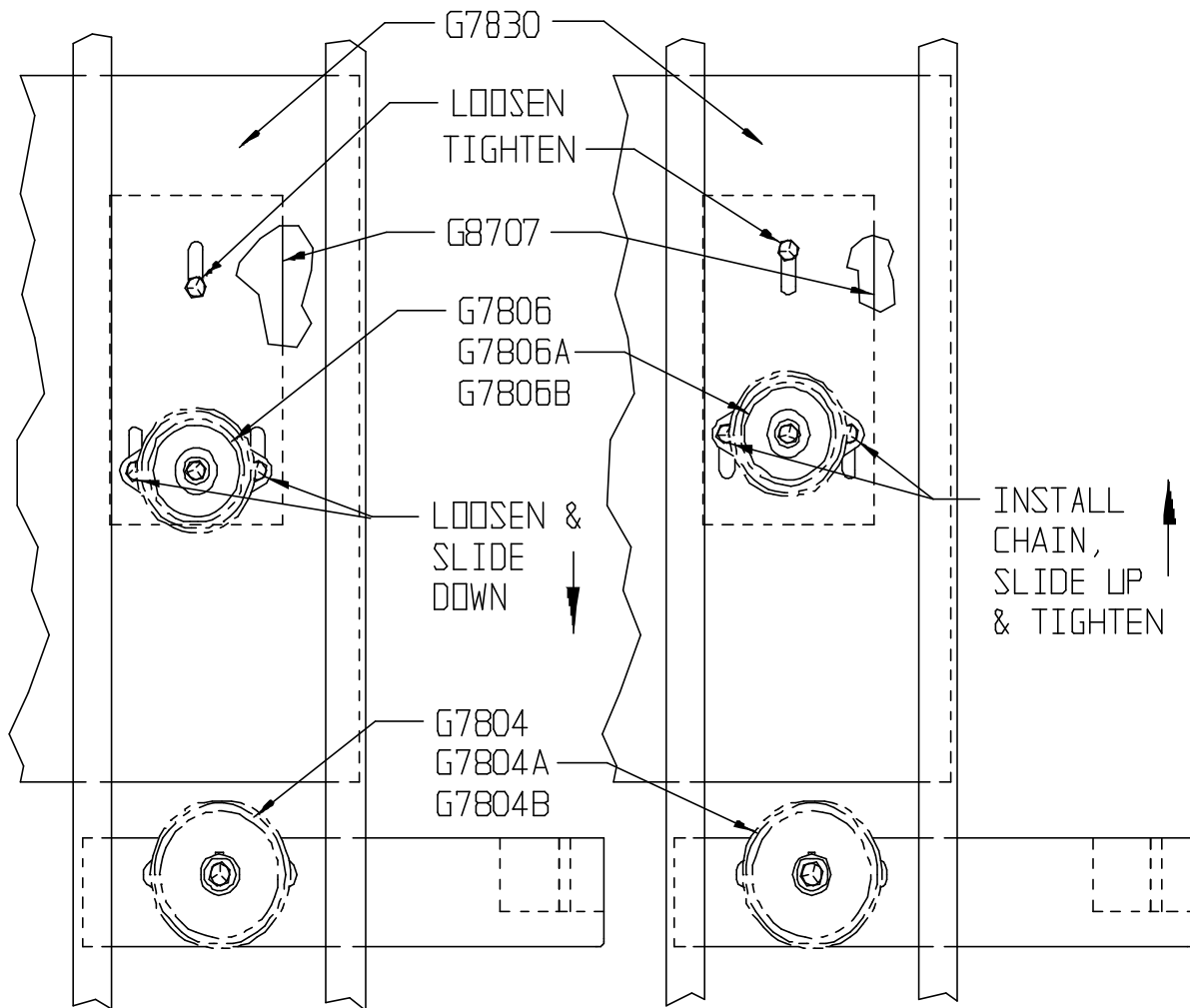
Adjustment of Connecting rod.

1. Slide the bearing block G7828 to its lowest point of travel.
2. Thread the rod end bearing GE51A & GB79 in/out until reaching a length of 12 5/8-inches.
3. Arm G7809 must point to the rear of the attachment before hookup.
4. Attach connecting rod GE51A & GB79 to the drive gear G7803 using spacer bushing GB79.
5. Rotate the drive gear G7803 until the connecting rod can be connected to arm G7809



### Vacuum Drive Chain Adjustment

1. Loosen the bolts holding mount plates (G7807) to mount plates (G7830)
2. Slide the mount plate to the bottom of the mounting slots.
3. Install the chain on the drive sprocket (G7804) A or B; to ratio sprocket (G7806) A or B.
4. Slide the mounting plate up and tighten the mount bolts.



### Vacuum Feed Timing Adjustment

Note: "Original Start Position" is: Mandrel on return stroke and forming end of mandrel is even with the front of the vertical guide bars and the slide bearing block is at its lowest point of travel.

Method #1 and #2 will require adjustment of the adhesive program segments upon completion.

1. Set former to the "Original Start Position".
2. Cycle former to determine whether blanks should be fed earlier (mandrel closer to return stroke) or later.
3. When direction is determined, return to "original start position" before starting Method #1.

#### Method #1

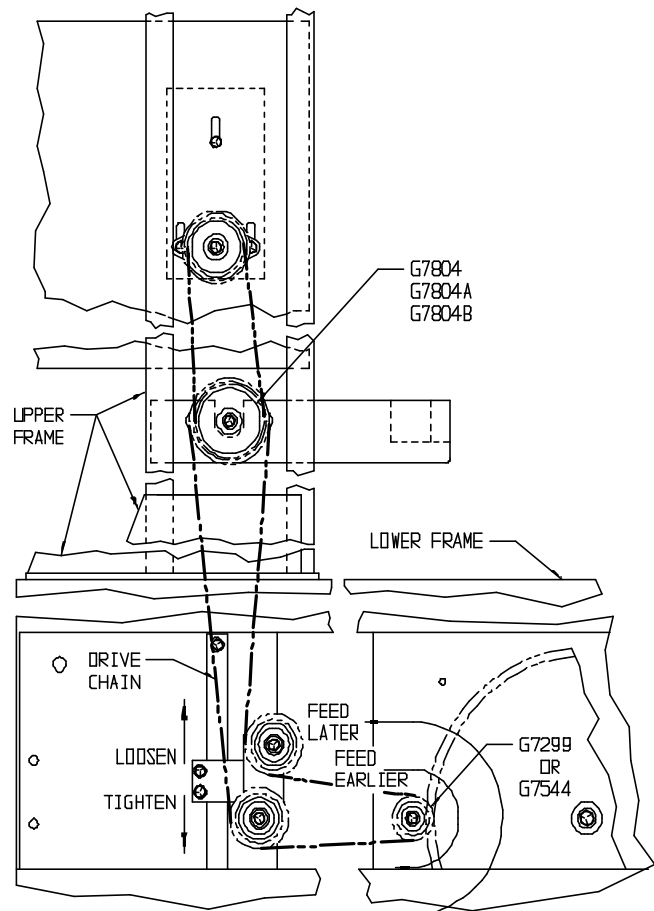
4. The timing is set at the drive sprocket.
5. "Original start position": Loosen take up chain idler (located lower left side frame).
6. Feed blanks later: jump the chain counterclockwise on sprocket (G7299).
7. Feed blanks earlier: jump chain clockwise on sprocket (G7299).
8. Tighten the idler and cycle the machine to check the timing.

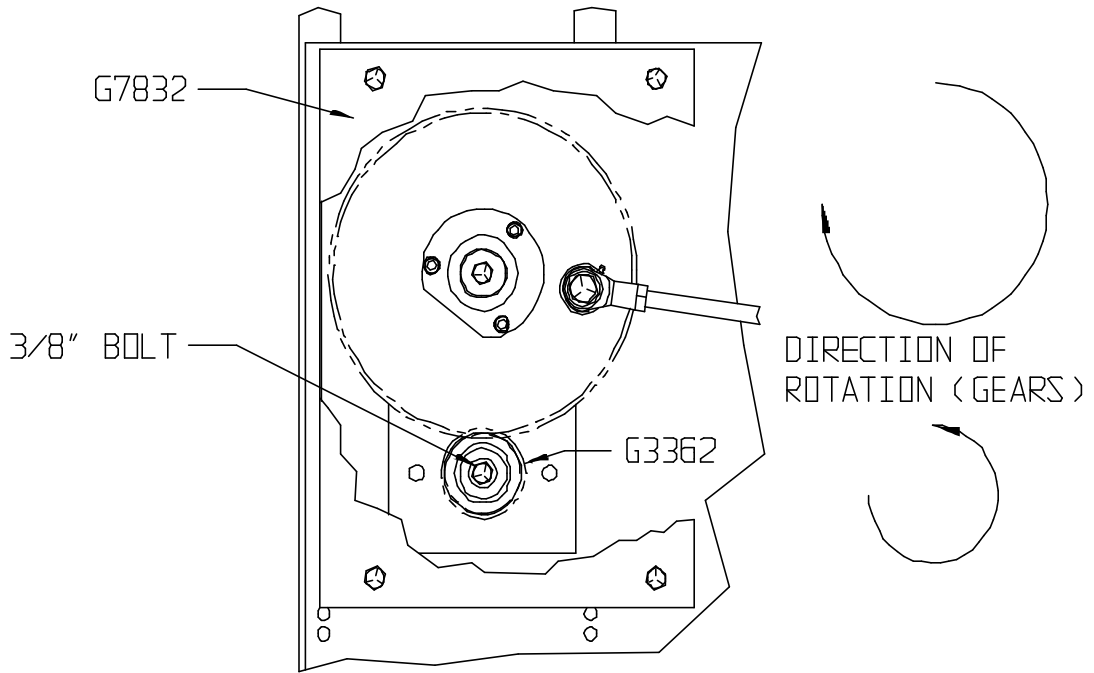
Note: This is a good timing start for most formers, but some may require further adjustment as described in method #2.

#### Method #2

Starting point for timing.

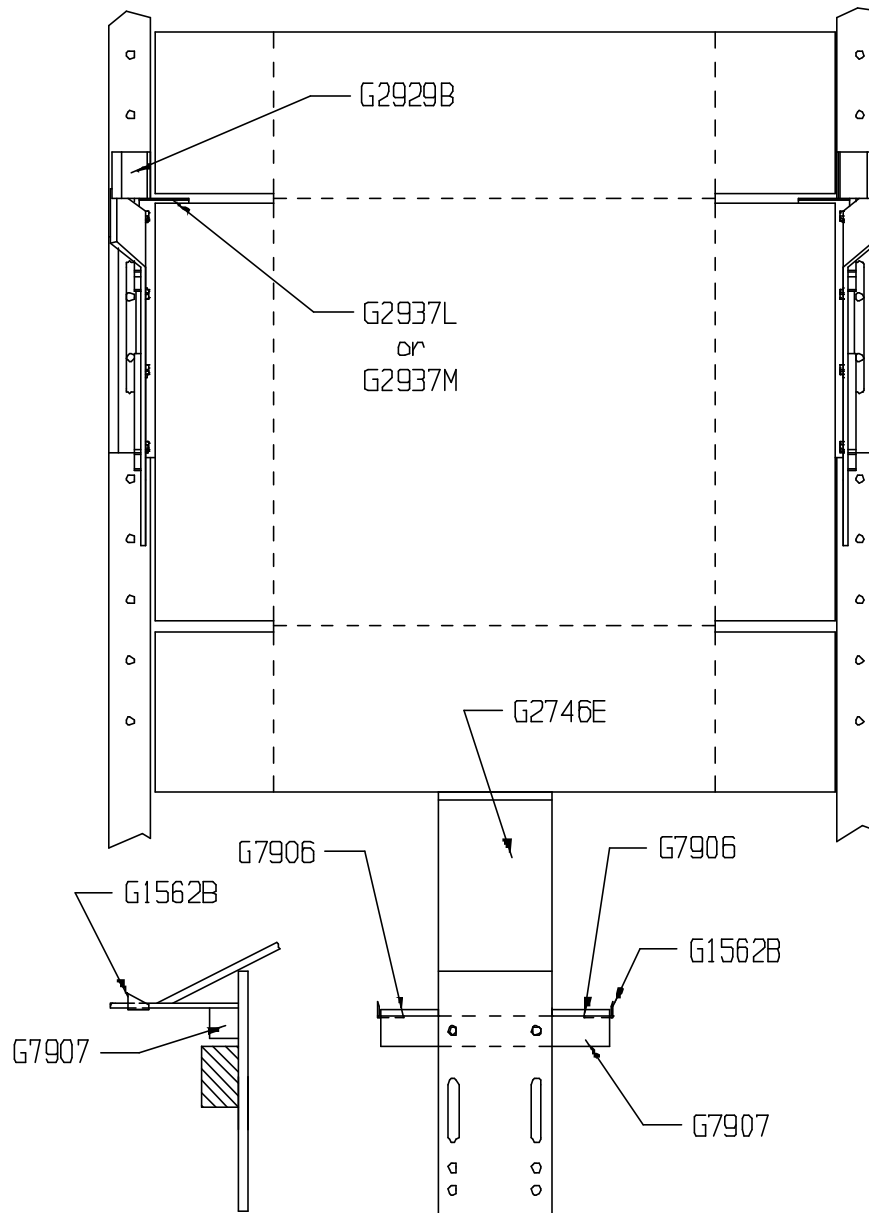
1. Remove guard G7832.
2. Remove the bolt holding the pinion gear G3362 and remove the gear.
3. **TO FEED BLANKS LATER**
4. Mandrel near end of return stroke.
5. Rotate the Feed wheel in direction of rotation.
6. Mandrel moves forward and in this position it will allow blank to miss mandrel and reach bottom stop before forming starts.
7. Reinstall Pinion gear and recheck.
8. **TO FEED BLANKS EARLIER**
9. Mandrel just beginning the return stroke.
10. Remove the Pinion gear.
11. Rotate the Feed wheel in direction of rotation.
12. Mandrel moves rearward and in this position it will allow blank to miss mandrel and reach bottom stop before forming starts.
13. Reinstall Pinion gear and recheck.





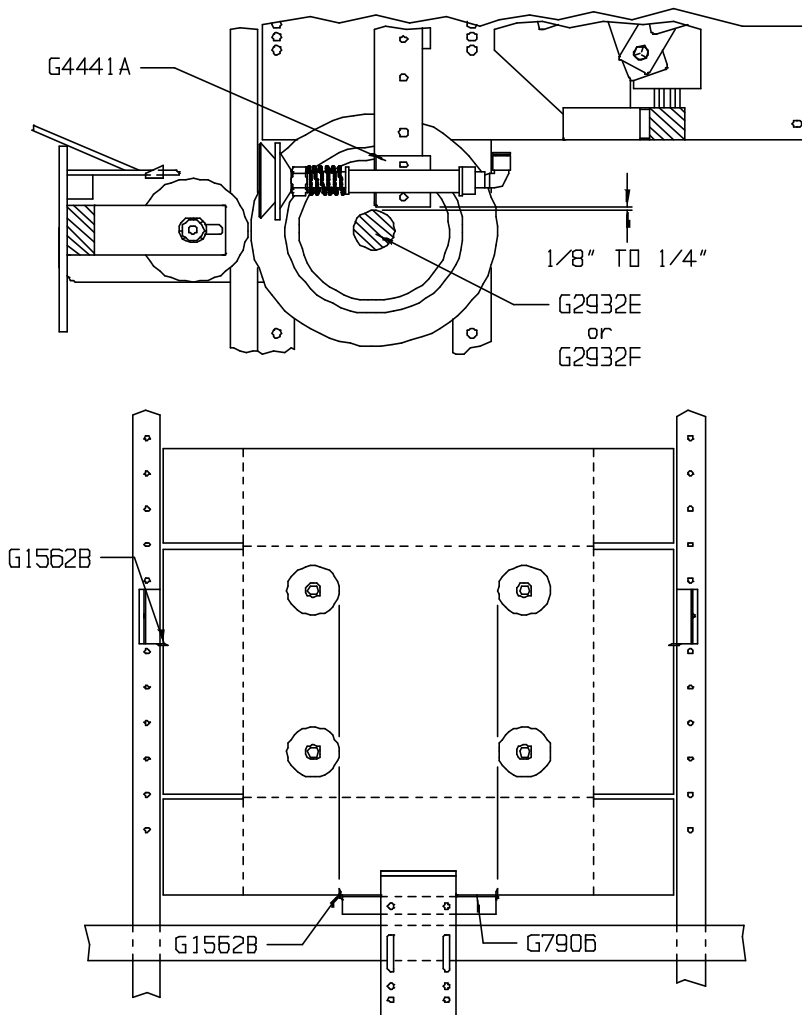
### Blank Hopper

1. Set a blank on the load support G2746E and adjust the blank support bar G2929B R/L.
2. Loosen the 5/16-inch bolt on the vertical guide bars and slide bars up/down in order to position the blades in the center of the blank cut outs or slits.
3. If the blank is not square or the slots are irregular, adjust the support blades so that the blank is square when running between the vertical guides.



### Vacuum Cup Position

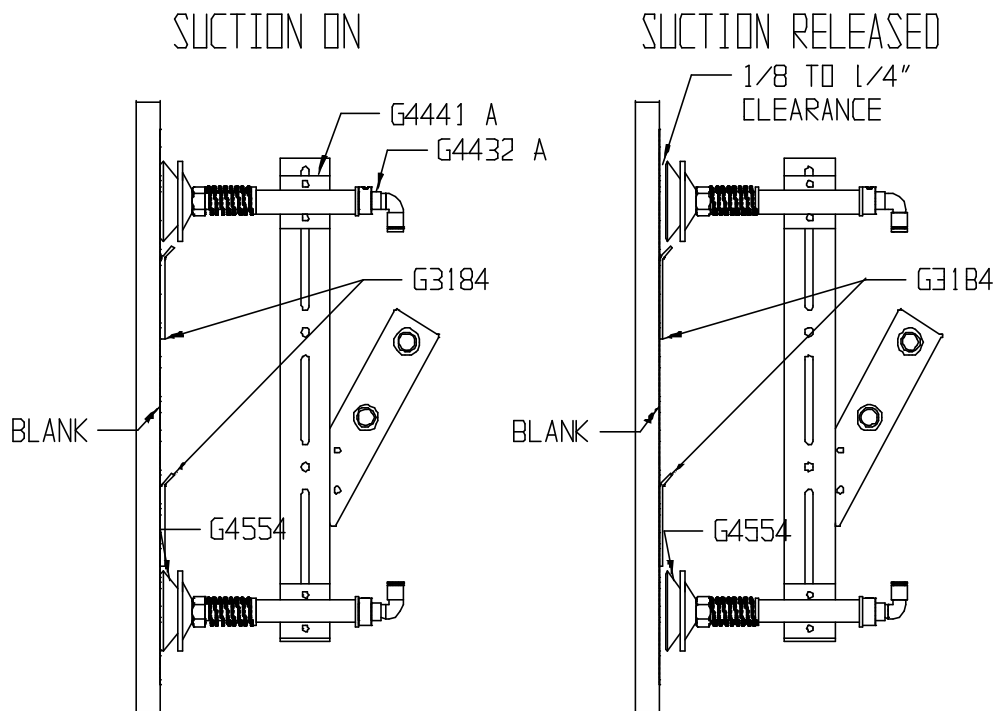
1. Adjust the lower cups by bottoming out the slide bearing block.
2. Adjust the lower brackets (G4441A) to clear the feed roller shaft by 1/8-inch to 1/4-inch.
3. Jog the former until the slide bearing block reaches its maximum 'up' position.
4. Adjust the width of the lower cup pads until the inside of the cups align with the blank support knives (G1562B) mounted on the hopper bottom stop plates.
5. Adjust the width of the upper set of cups to align to the lower set.
6. Position the cups high enough that the centerline of the cups aligns with, or is slightly above, the blank support knives.



### Suction Cup Mount Tube

To adjust suction cup mounting tubes:

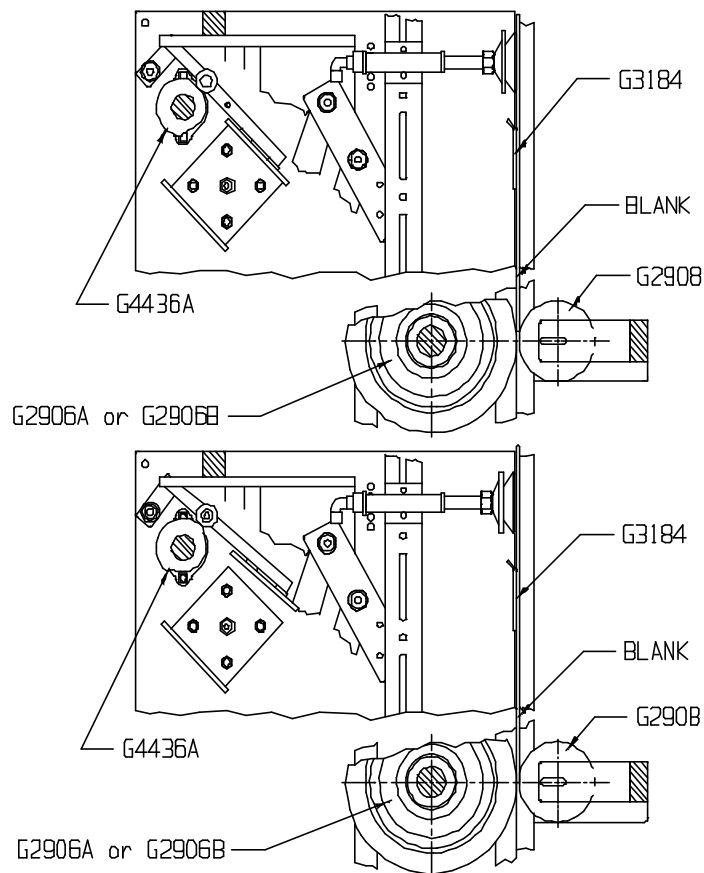
1. Stop the mandrel on the return stroke
2. Slide the bearing block to its lowest point of travel.
3. Turn the vacuum blower on and place a blank against the suction cups (G4554).
  - a. The blank is held between the vertical guide bars, against the rear stop (G3184) mounted on the rear side of the vertical guide bars.
4. Slide the tubes in/out until the blanks are held against the rear stops. Loosen, set, and tighten the set collars to maintain this condition.
5. Release the suction at the manifold by lifting the manifold pad cover. The suction cup faces retract slightly (1/8-inches to 1/4-inches) from the blank. Make this adjustment to prevent the cups from wearing or tearing.



### *Vacuum Feed Valve Operating Cam Adjustment:*

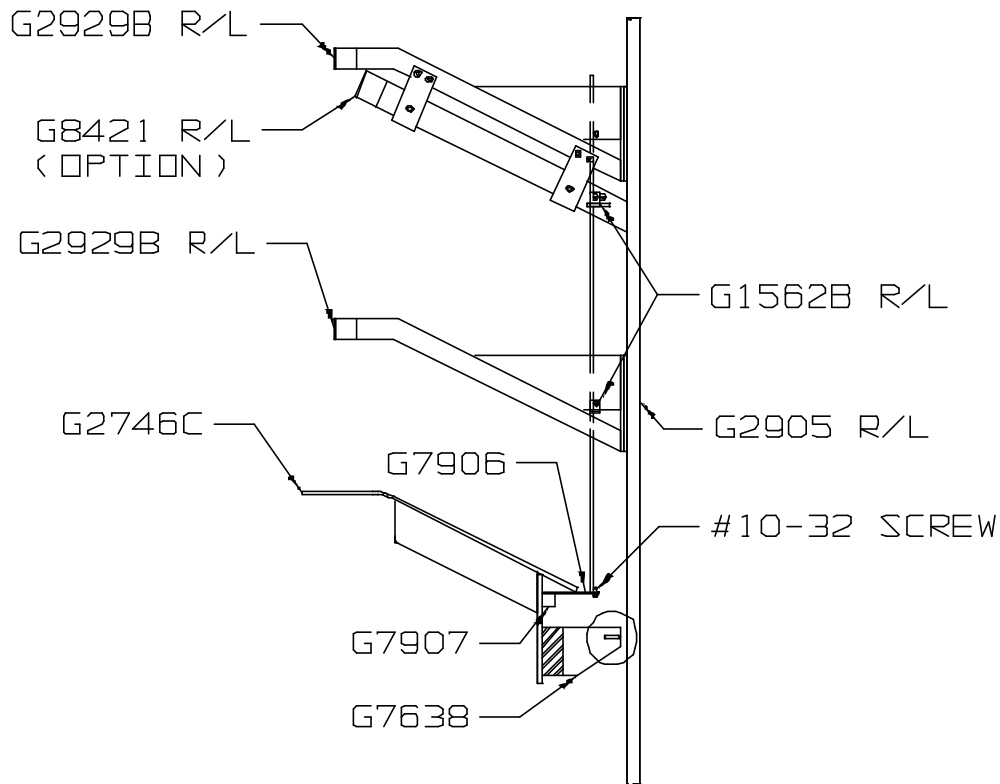
Cam adjustment:

1. Load the hopper (magazine) with blanks and turn the vacuum blower on.
2. Jog the case former until the vacuum cups hold the blank between the vertical guide bars and against the blank rear stops (G3184).
3. When the blank starts to enter the space between the feed wheel (G2906) and the backup roller (G2908), the operating cam (G4436A) starts to release suction.
4. Suction completely releases when the bottom of the blank aligns with the centerline of the feed wheel (G2906).
  - a. An early release may cause the blank to skew and create a feed problem.
  - b. A late release causes glue misprogramming and tears the vacuum cup pads.



### Blank Support Knives Adjustment

1. Blank support knives (G1562B R/L) are located:
  - On the hopper side guide, G8421 R/L
  - On the hopper bottom stop plate, G7906 (optional)
  - On the lower tray blank support bars, G2929B R/L
2. Mount the knives to provide a restraint on the blanks but loose enough that one blank pulls through the knives at each cycle.
3. Adjust the knife by adding flat washers between the knife and the hopper support guide, G2929B R/L or G8421 R/L.
4. Note: If there is not enough knife restraining the blank, two or more blanks can pull through on each cycle. If there is too much restraint, the blank will not pull through, causing the vacuum pick cups to release from the corrugated blank.



*Vacuum Feed Drive Combinations*

Ratio	Jack Shaft	Matt Feed Shaft		Vacuum Feed
4:1	40B10	G7804		G7806
		40B24	40B20	G7806A
6:1	40B12	G7804A		G7806A
		40B24	40B20	
7.2:1	40B15	G7804A		G7806B
		40B20	40B20	40B36
8:1	40B15	G7804B		G7806B
		40B18	40B18	

*Maximum Blank Length*

Ratio	Matt Feed Wheel G2906A (9" Dia)	Matt Feed Wheel G2906B (10 ½" Dia)
4:1	33"	38"
6:1	47"	54 ½"
7.2:1	55 ½"	
8:1	61"	

## Overall Operation

1. Load the hopper full of corrugated blanks.
2. Turn the speed control knob G3234 clockwise to the slowest speed.
3. Turn the vacuum blower on.
4. Jog the machine until a blank is picked from the hopper. Continue to jog the machine until the blank pulls between the vertical guide bars, against the rear stops.
5. Continue jogging until the blank is placed between the feed wheel and the back up roller.
6. Halt the blank when the bottom reaches the feed wheel centerline. Verify the vacuum operating cam releases suction
7. At this same time, the vacuum cups start retracting from the corrugated blank.
8. Jog the blank through the feed wheel, down the vertical guides, and stopping at the bottom stop.
9. The blank must clear the forming mandrel before it starts its forming stroke.
10. Check the glue pattern as the blank sits on the bottom stop.
11. When the pattern is adjusted or approved, continue the jogging the machine until the blank forms and is in the compression section.
12. When the operator is satisfied the forming operation is correct, turn the speed control knob up to the production speed.

## Troubleshooting the Vacuum Feed System

### *Vacuum Feed Problems*

<b>TROUBLE</b>	<b>PROBABLE CAUSE</b>	<b>POSSIBLE SOLUTIONS</b>
1. Blank drops from vacuum cups before it is placed into the feed wheels.	Vacuum valve operating cam	See Cam adjustment
	Return stroke of mounting tubes.	See Tube adjustment
	Vertical guide bars	See Vertical Guide adjustment
2. Suction does not release.	Vacuum operating cam	See Vacuum adjustment
3. Mandrel contacts blank before it reaches the bottom stops.	Vacuum feed timing	See Vacuum adjustment
4. Multiple blanks being pulled from the hopper.	Blank support knives.	See Blank Knives adjustment.
	Vertical guide bars	See adjustment
	Blanks are interlocking	Check with corrugator supplier
	Blank width incorrect	Check with corrugator supplier
5. No suction at vacuum cups	Blower inoperative.	Check electrical print.
	Tubing damage	Check for cracks, holes or loose connections.
	Vacuum cup bolt clogged.	Hole in bolt center needs to be cleaned out.
	Vacuum manifold cover.	See cam cover adjustment.
	Vacuum cup pads.	Replace pads if worn, torn or misshapen.
6. Vacuum blower does not operate.	Main disconnect switch.	Check switch is "ON"
	Blower "ON/OFF" switch	Turn blower switch to "ON"
	Loose wiring or terminals	Tighten connectors..
	Motor starter	Check continuity. Replace if defective.
	Blower shuts off during short	Check incoming voltage versus

TROUBLE	PROBABLE CAUSE	POSSIBLE SOLUTIONS
	period of operation.  Blower cutting out after long period of operation.	wired voltage.  The thermistor overheats.. Allow motor to cool . Replace unit if faulty.
7.Vacuum motor is blowing and not producing suction.	Motor rotation.	For 3 phase machines , reverse wires M1 and M2.
8..Vacuum mechanism cycles but does not pull blanks from the hopper.	Blower inoperative.  Vacuum cups select blank over slots or holes.  Lower set of cups set too low.  Blank knives .  Too few blanks in the Hopper	Refer to electrical print.  See Cup positioning  See Cup positioning.  See Knife adjustments.  Add blanks to the Hopper.

# Lubrication Procedures

Lubrication is critical to machine performance. Lubrication schedules are divided into three categories:

- Daily
- Weekly
- Periodic.

The schedule however should be determined by visual examination of all equipment and lubricated as needed.

## *Daily Lubrication Requirements*

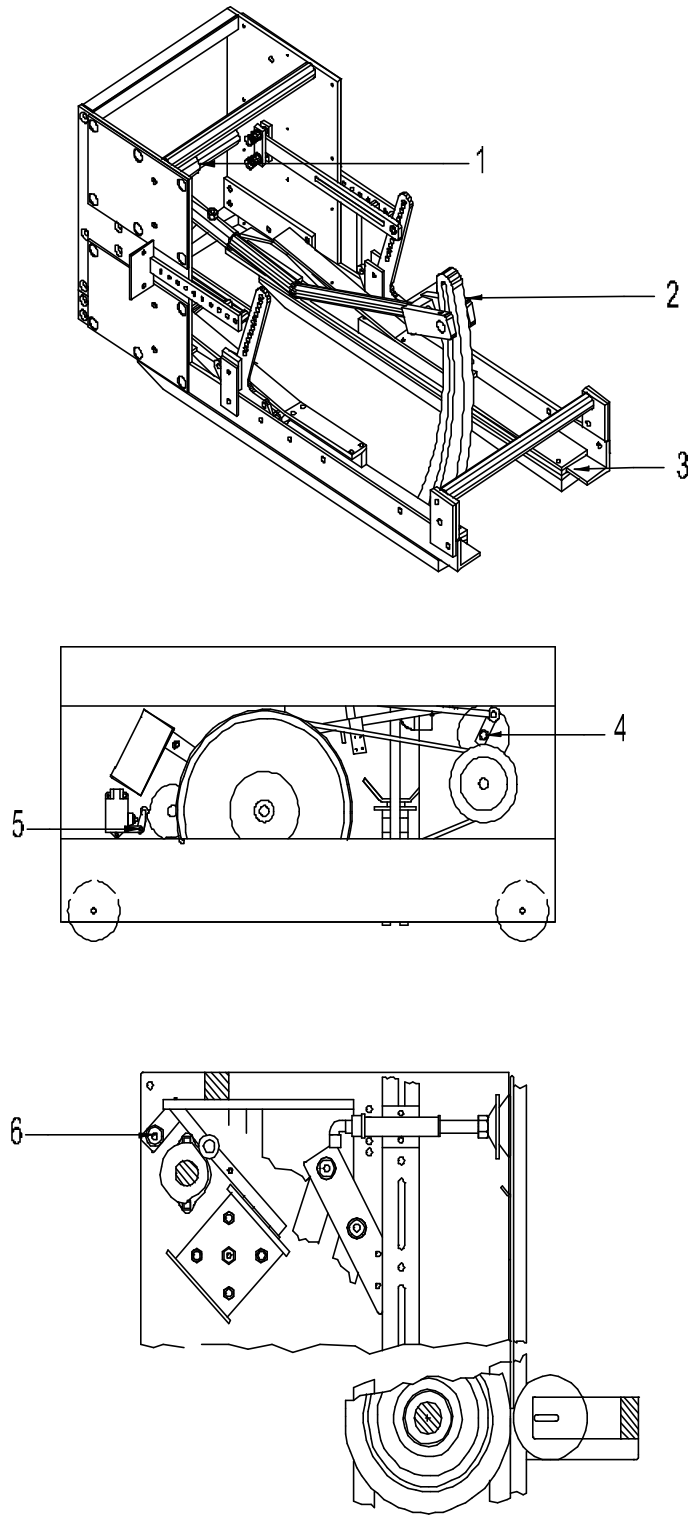
Item	Part	Action
1	Mandrel con rod	Oil mandrel, pivot, and feed post
2	Mandrel connecting bolt	Oil with 10 weight oil
3	Mandrel guide rails	Oil surfaces between guide rails and fabric guides
4	Vari-Speed control rod	Oil between rod and end plate
5	Micro switch cam	Oil roller and pivot joints on the switch
6	Vacuum dump valve	Oil pivot joints
7	Vacuum assembly	Oil slide bearing block
8	Vacuum assembly	Oil cup shafts, feed linkage bushings, scissors
9	Horizontal Compression slides	Oil slide surfaces
10	Vertical Compression slides	Oil slide surfaces
11	Idler sprockets	Oil

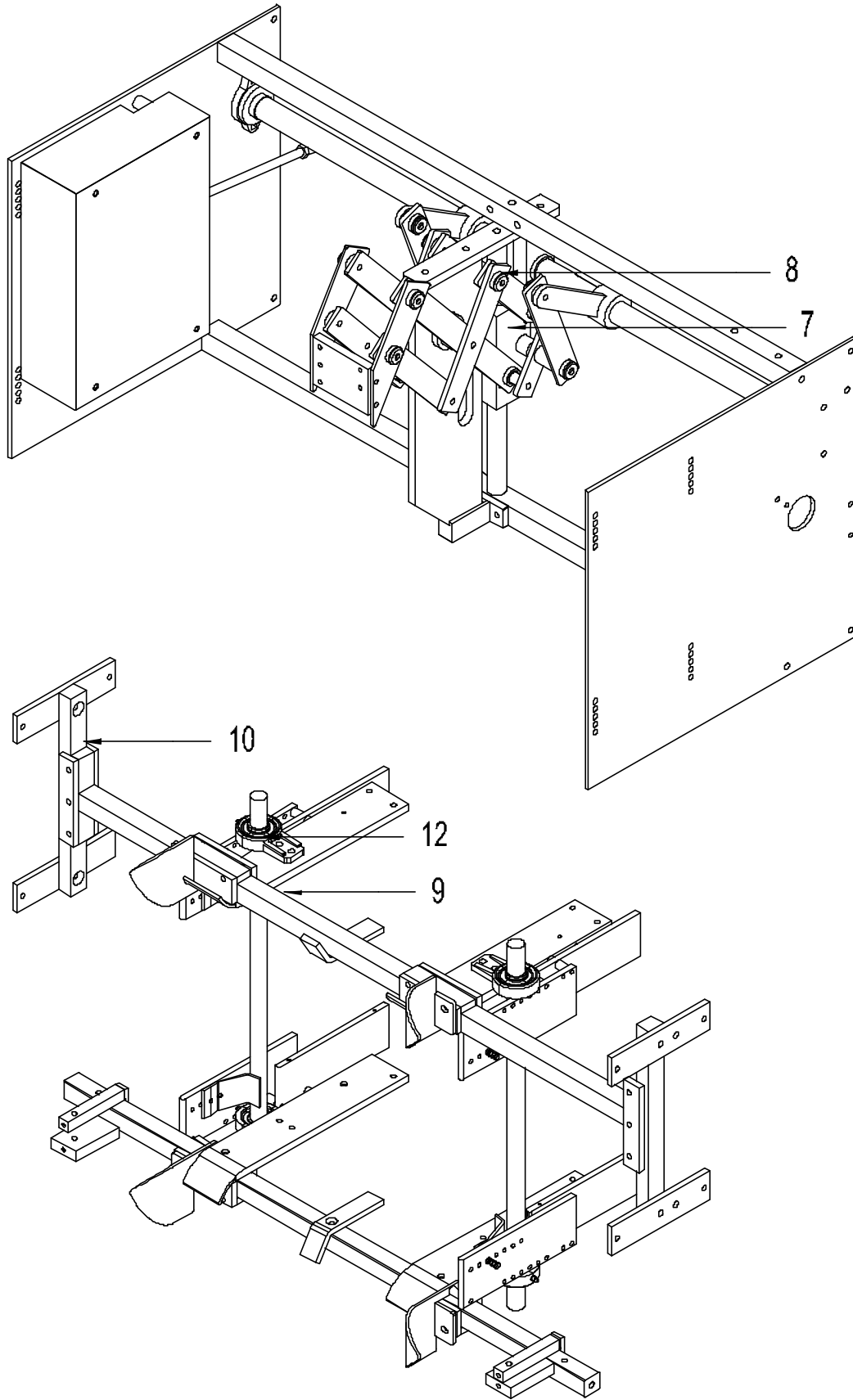
## *Weekly Lubrication Requirements*

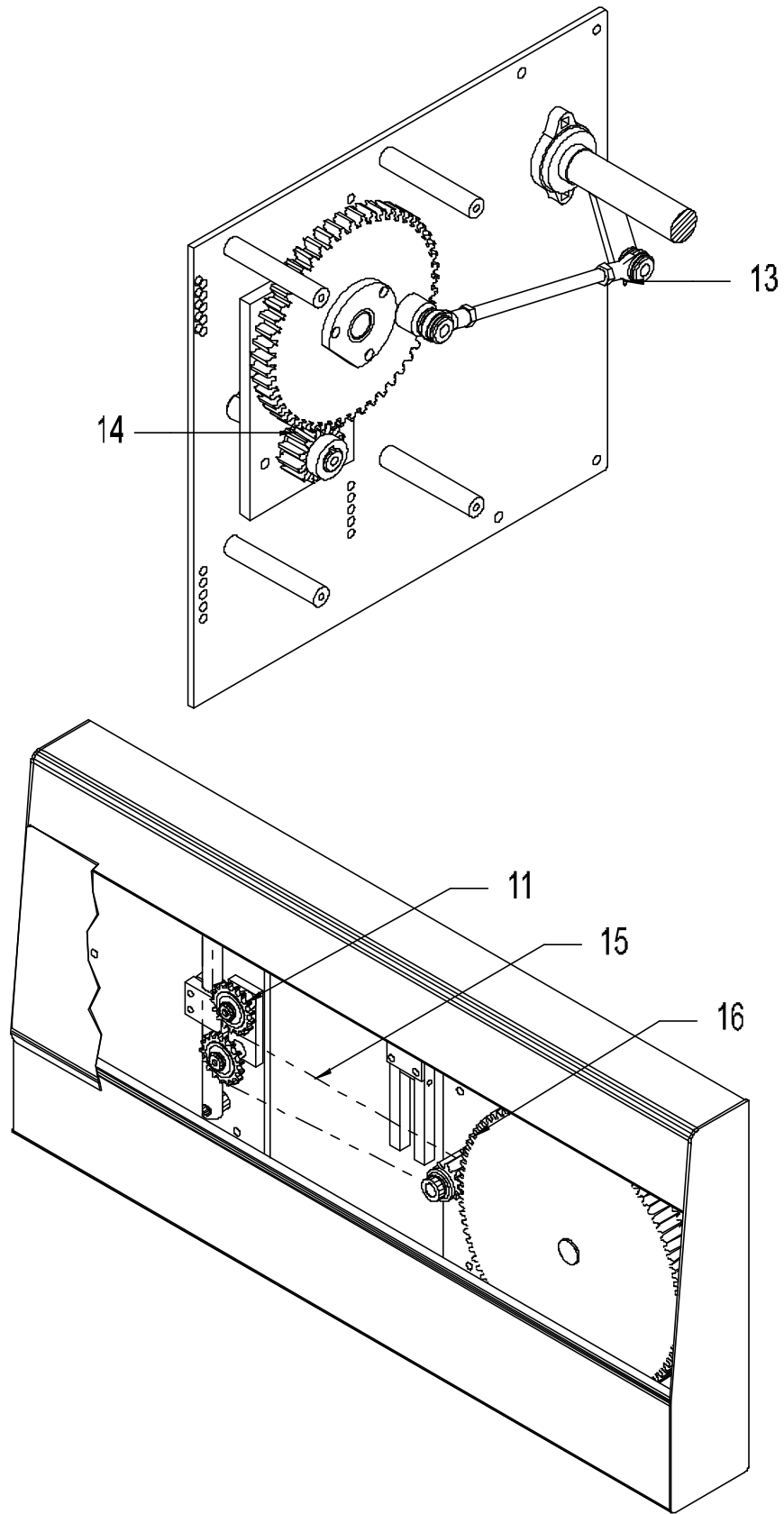
Item	Part	Action
12	Compression bearings	Grease zerk fittings

## *Periodic Lubrication Requirements*

Item	Part	Action
13	Vacuum gear con rod	Oil arm to rod
14	Vacuum and drive gear	Use gear grease as required
15	Drive chain	Use chain oil and keep well lubricated
16	Main gear	Use gear grease and keep greased



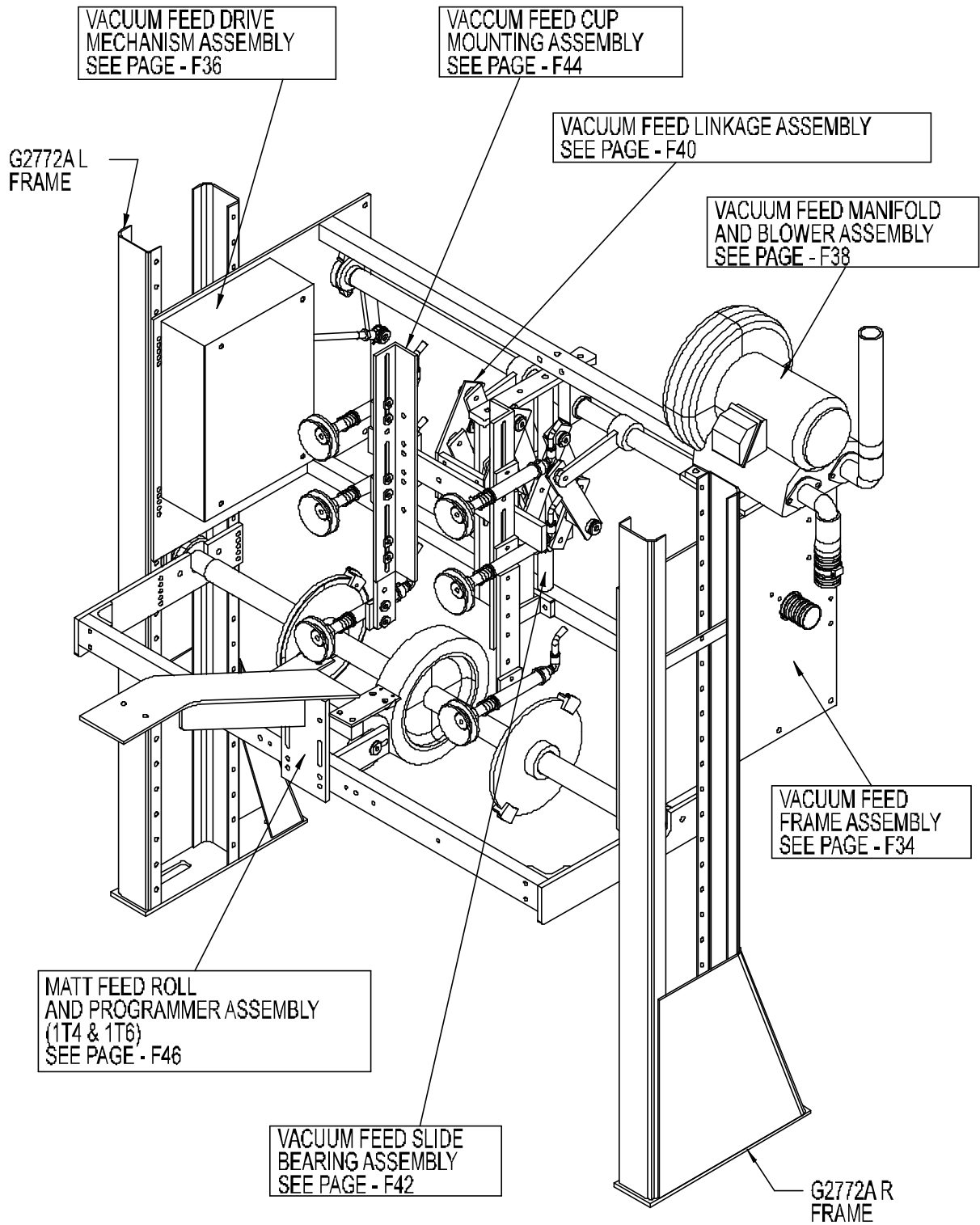




# Options – Parts List and Illustrations

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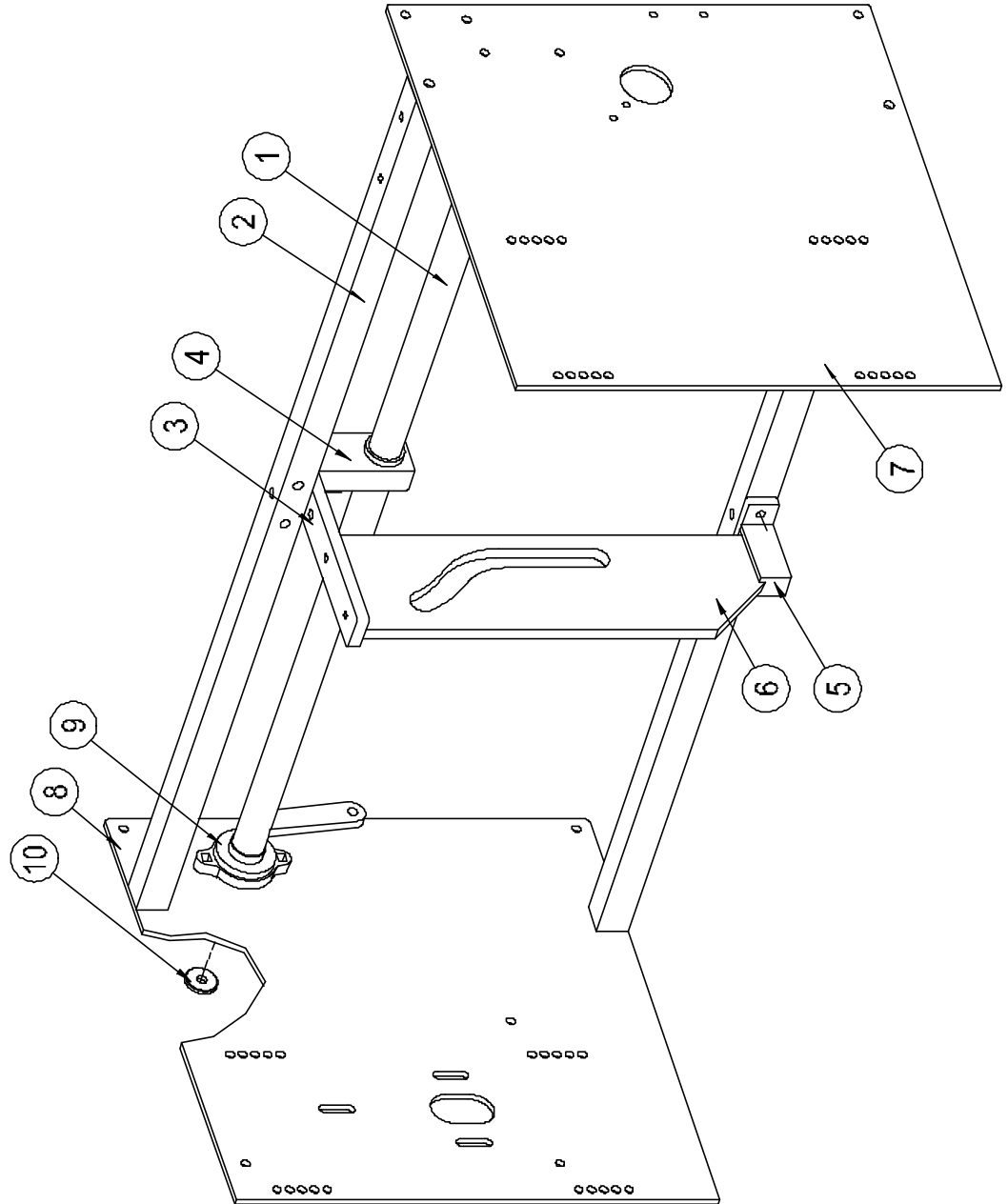


### Vacuum Feed Frame Assembly

Item	Quantity	Part Number	Description
1	1	G7809	SHAFT VACUUM CUP OPERATING 1T4
	1	G7809A	SHAFT VACUUM CUP OPERATING 1T6
2	2	G7820	BAR, VACUUM CUP SUPPORT 1T4
	2	G7820A	BAR, VACUUM CUP SUPPORT 1T6
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 (RIGHT)
8	1	G7830	PLATE, VACUM FEED MOUNTING (LEFT)
9	2	GE70	BEARING 2" HOLE FLANGE (1" I.D.)
10	1	GW12	WASHER, DRIVE GEAR & SPROCKET 1 1/4O.D x 25/64 x 3/16 LONG

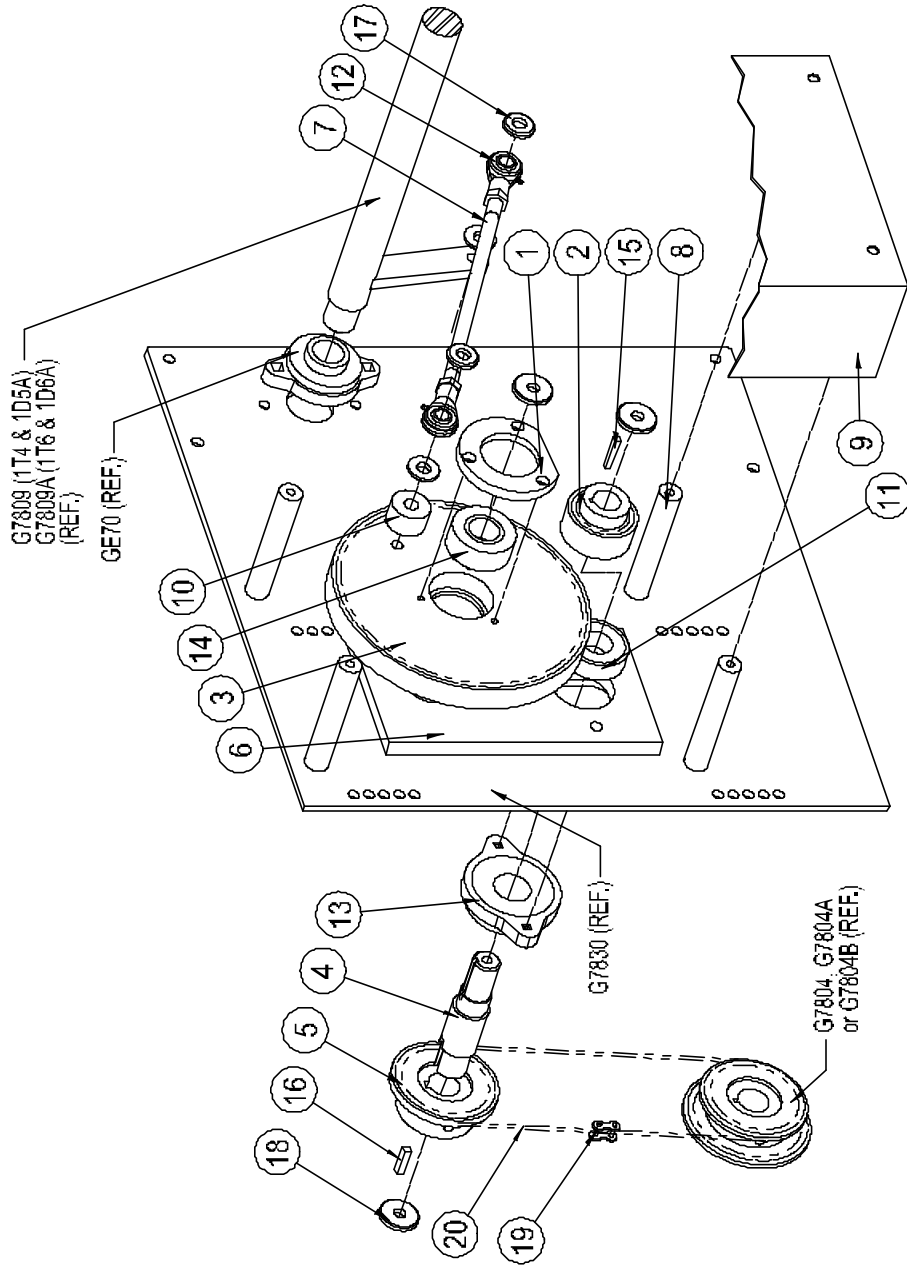
Note: Additional Electrical Components Required

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



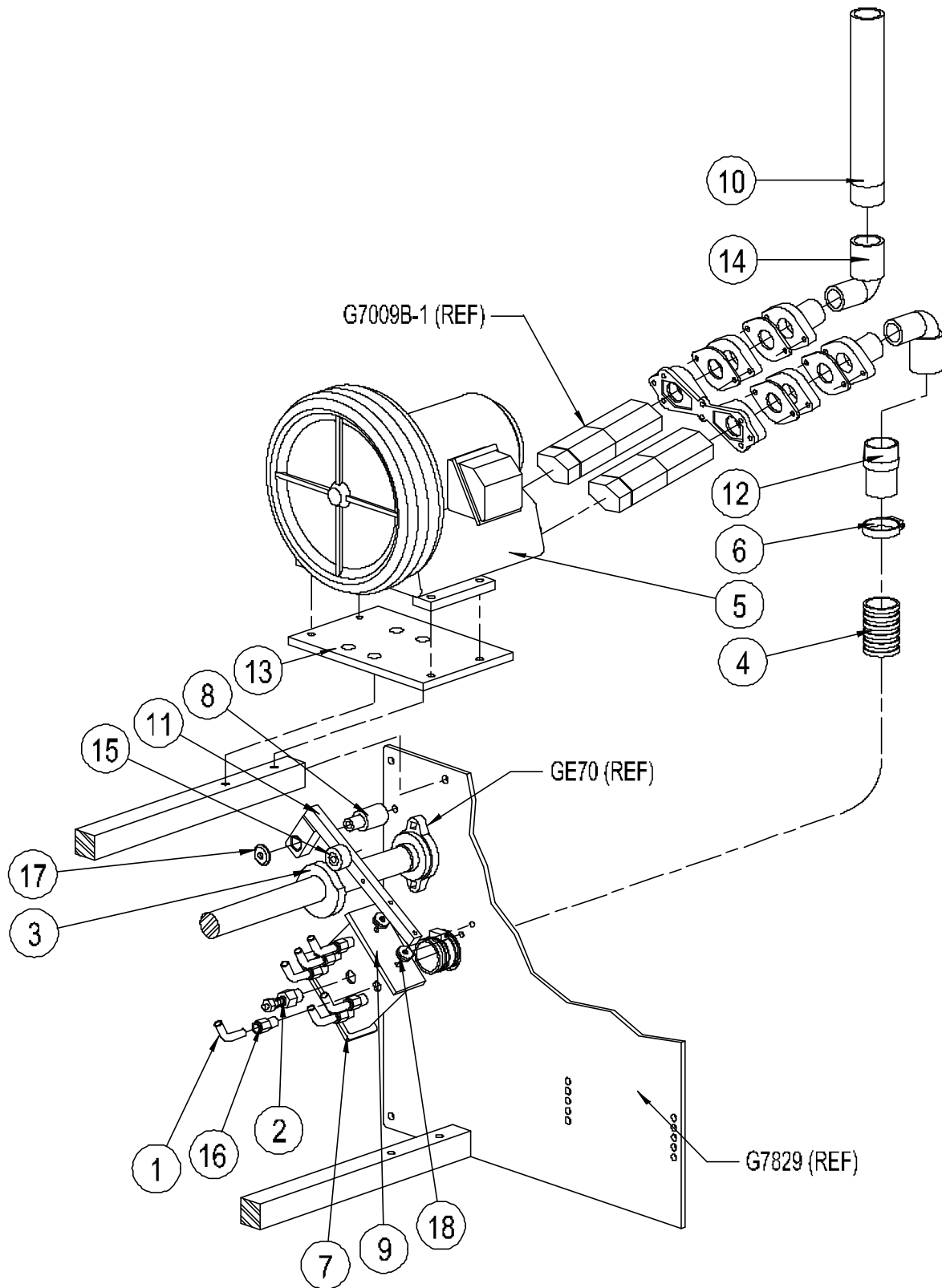
## Vacuum Feed Drive Mechanism Assembly

Item	Quantity	Part Number	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	G7807-01	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 1 1/4 OD x 29/64 ID x 49/64 LONG
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 1 OD x 29/64 ID x 5/32 LONG
18	3	GW12	WASHER, DRIVE GEAR & SPROCKET 1 1/4 OD x 25/64 ID x 3/16 LONG
19	1	GHB1A	CONNECTING LINK
20		#40	ROLLER CHAIN



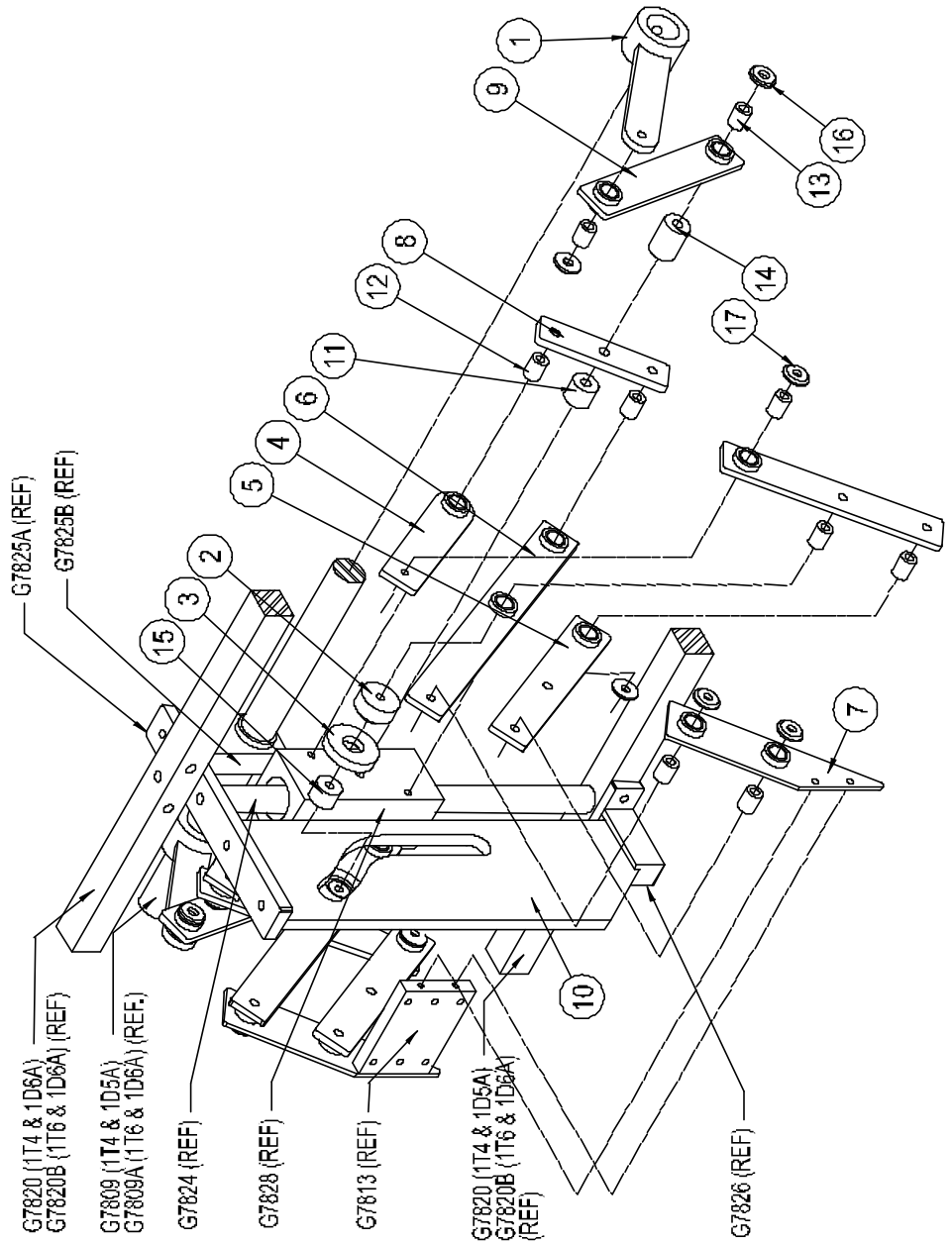
## Vacuum Feed Manifold and Blower Assembly

Item	Quantity	Part Number	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 1 OD x 21/64 ID x 5/32 LONG



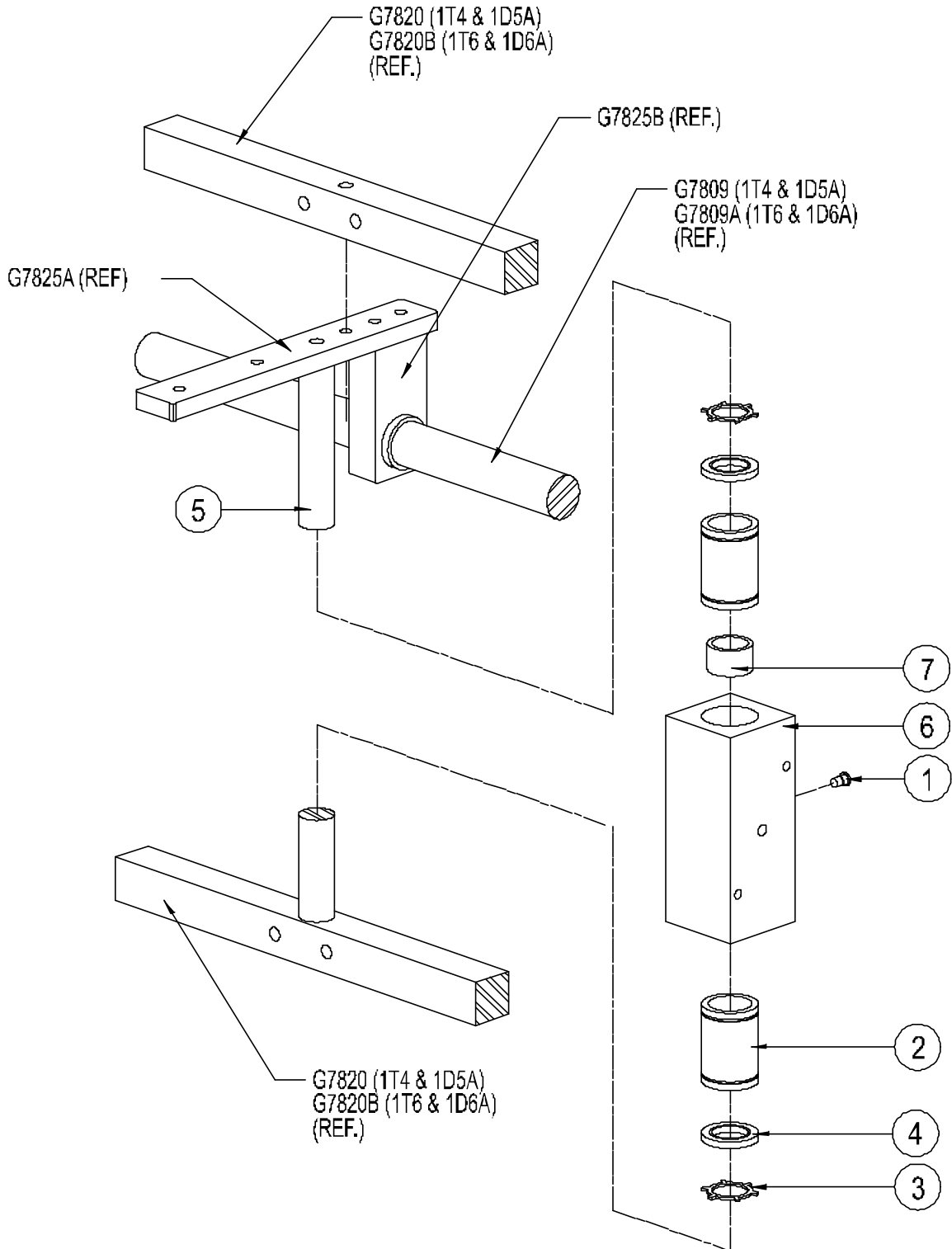
## Vacuum Feed Linkage Assembly

Item	Quantity	Part Number	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 1 OD x 25/64 ID x 13/16 LONG
12	14	GB361	BUSHING, VACUUM FEED LINKAGE 5/8 OD x 21/64 ID x 13/16 LONG
13	4	GB435	BUSHING, VACUUM FEED LINKAGE 5/8 OD x 3/8 ID x 49/64 LONG
14	2	GB514	SPACER, LIFT CON ROD MOUNTING 1 OD x 25/64 ID x 1 3/8 LONG
15	1	GE83	BEARING, CAM FOLLOWER (1 OD x 5/16 ID)
16	4	GW1A	WASHER, VACUUM FEED OPERATING SHAFT 1 OD x 25/64 ID x 5/32 LONG
17	8	GW1B	WASHER, VACUUM FEED LINKAGE 1 OD x 21/64 ID x 5/32 LONG



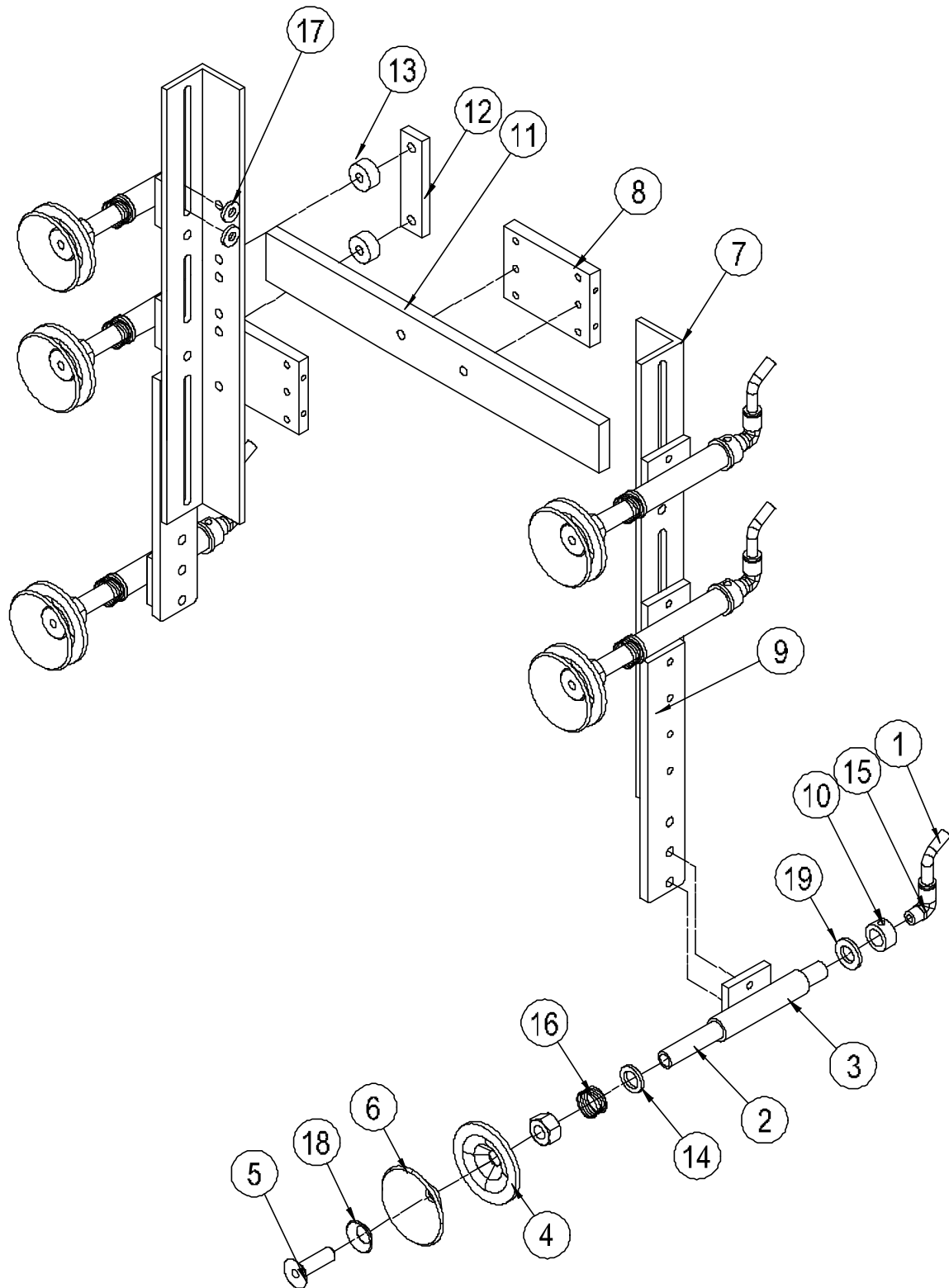
**Vacuum Feed Slide Bearing Assembly**

<b>Item</b>	<b>Quantity</b>	<b>Part Number</b>	<b>Description</b>
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 Cup Mounting Assembly

Item	Quantity	Part Number	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 1 OD x 21/64 ID x 31/64 LONG
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 1 1/8 OD x 5/8 ID x 1/8 LONG



## Feed Roll And Programmer Assembly (Vacuum Pick)

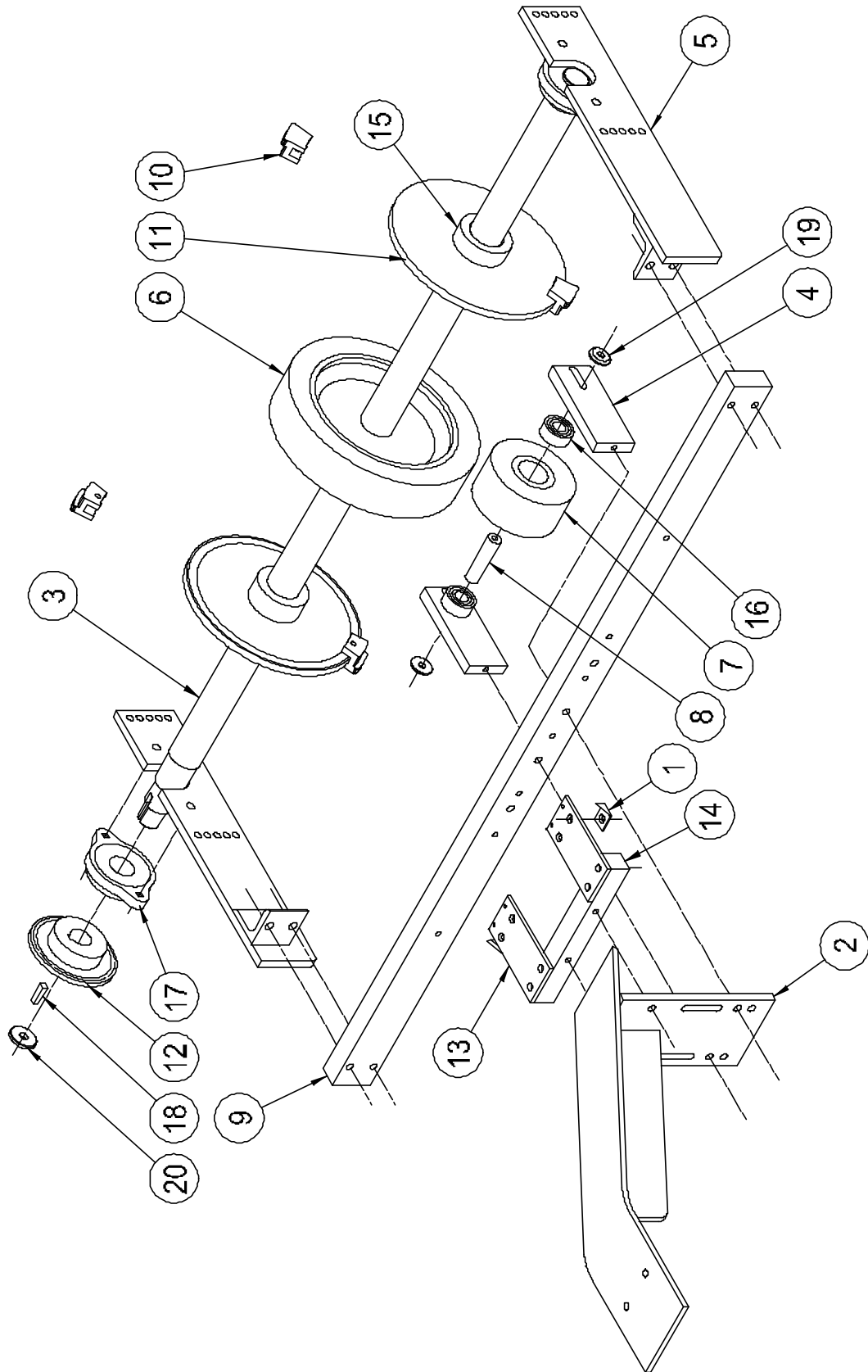
Item	Quantity	Part Number	Description
1	2R/2L	G1562B	KNIFE, MATT SUPPORT
2	1	G2746E	SUPPORT, MATT HOPPER LOADING
3	1	G2832E	SHAFT, MATT FEED ROLLER (1T4)
	1	G2832F	SHAFT, MATT FEED ROLLER (1T6)
4	2	G2872	MOUNT, MATT FEED IDLE ROLL
5	2R/2L	G2900F	PLATE, MATT FEED WHEEL SHAFT MOUNTING (1T4)
	2R/2L	G2900G	PLATE, MATT FEED WHEEL SHAFT MOUNTING (1T6)
6	1	G2906A	WHEEL, MATT FEED (1T4)
	1	G2906B	WHEEL, MATT FEED (1T6)
7	1	G2908	ROLLER, MATT FEED IDLE
8	1	G2911A	SHAFT, MATT FEED IDLE ROLL
9	1	G2999D	BAR, MATT FEED IDLE ROLLER MOUNTING (1T4)
	1	G2999E	BAR, MATT FEED IDLE ROLLER MOUNTING (1T6)
10	*	G3028B	SEGMENT, ADHESIVE APPLICATOR PROGRAM
11	2	G3029	DISC, INTERMITTENT ADHESIVE APPL. PROGRAM (1T4)
	2	G3029A	DISC, INTERMITTENT ADHESIVE APPL. PROGRAM (1T6)
12	1	G7804	SPROCKET, VACUUM FEED DRIVE (4:1 & 6:1)
	1	G7804A	SPROCKET, VACUUM FEED DRIVE (7.2:1)
	1	G7804B	SPROCKET, VACUUM FEED DRIVE (8:1)
13	2	G7906	PLATE, HOPPER BOTTOM STOP
14	1	G7907	BAR, HOPPER BOTTOM STOP PLATE
15	2	GA15	SET COLLAR, ADHESIVE APPL. DISC LOCATING (1T4)
	2	GA17	SET COLLAR, ADHESIVE APPL. DISC LOCATING (1T6)
16	2	GE38	BEARING, MATT FEED IDLE ROLL
17	2	GE70A	BEARING, MATT FEED ROLL DRIVE SHAFT
18	1	GJ10A	KEY 1/4 x 1/4 x 1 LONG
19	2	GW1B	WASHER, 1 OD x 5/16 ID x 5/32 THICK
20	1	GW12	WASHER, 1 1/4 x 25/64 ID x 3/16 THICK

## NOTE:

\* 4 required for 2"- 3 3/4" deep trays

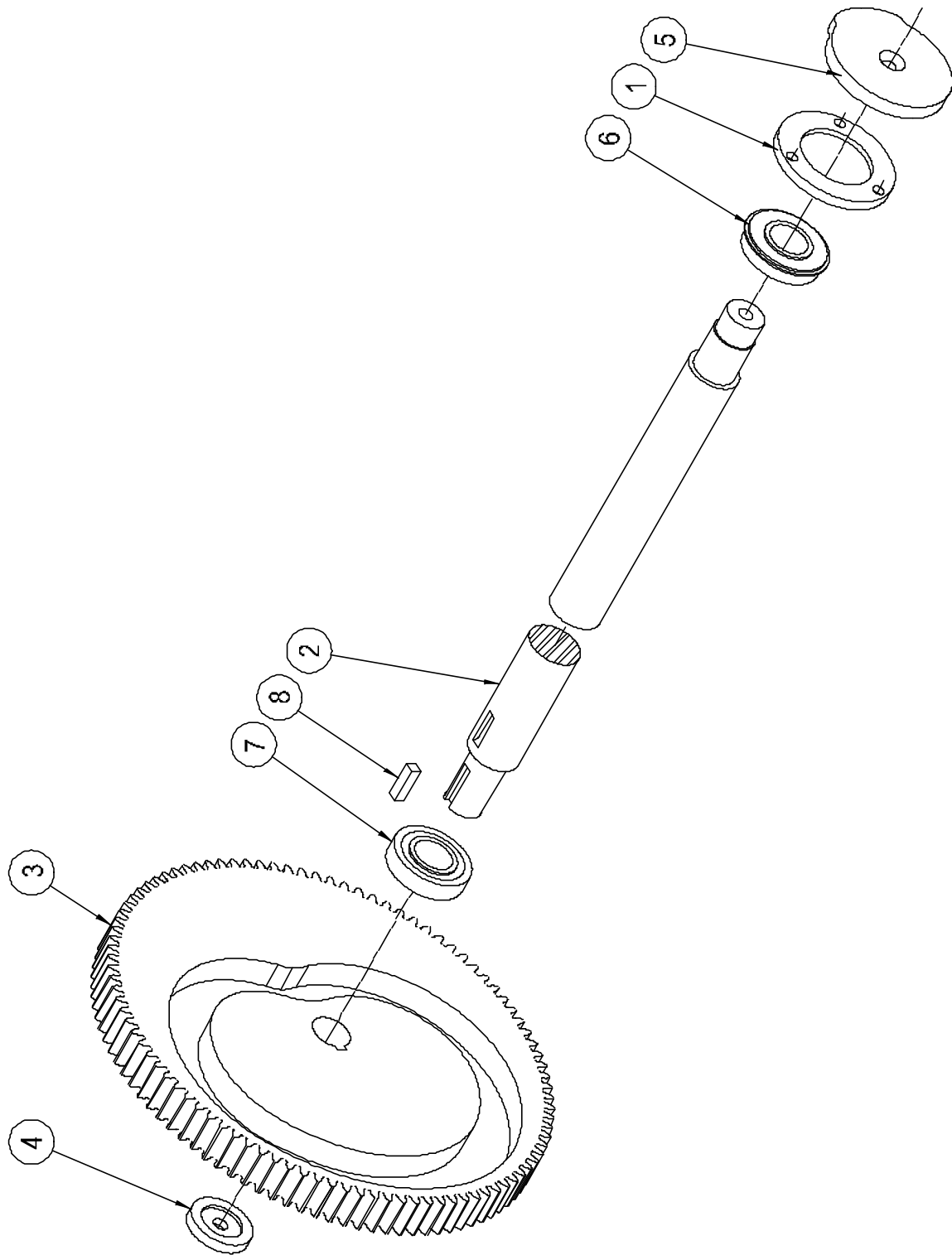
8 Required for 4"- 9" deep trays

\*\* Quantity will be the same as quantity for item 10 (G3028B)



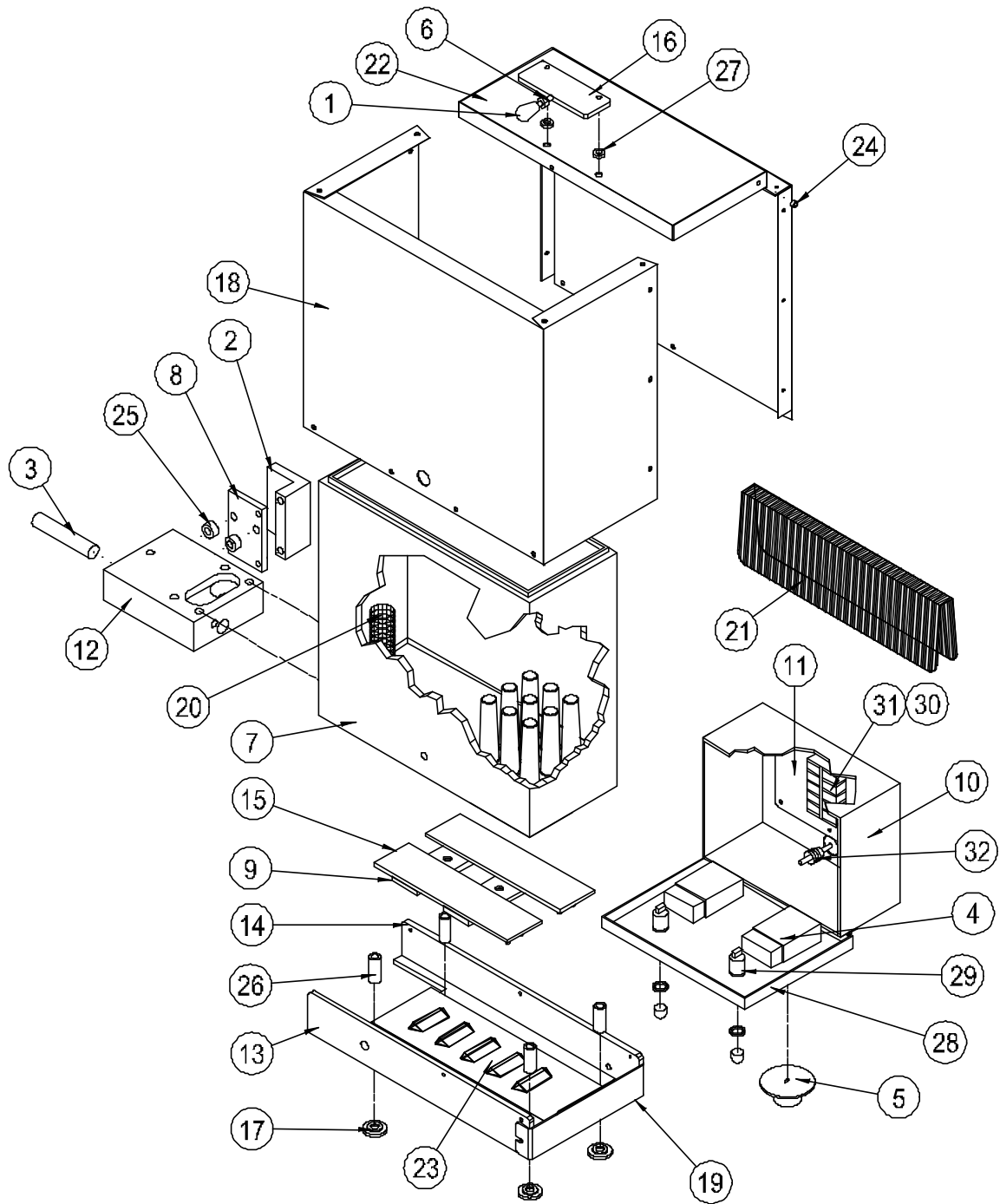
### Transmission Gear Shaft Assembly

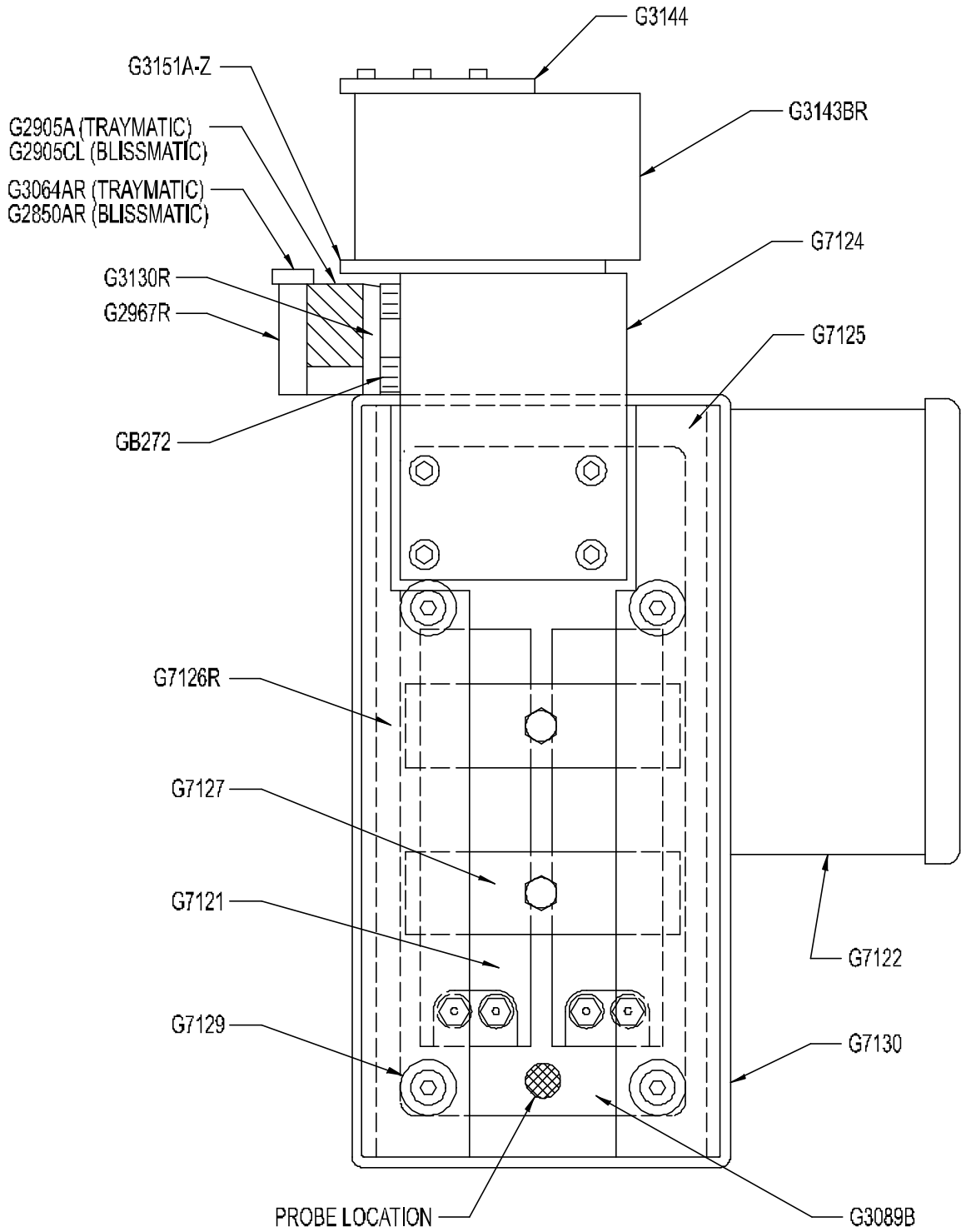
Item	Quantity	Part Number	Description
1	1	G2447	RING, MAIN SHAFT BEARING CLAMP
2	1	G2508B	SHAFT, TRANSMISSION GEAR (1T4)
	1	G2508C	SHAFT, TRANSMISSION GEAR (1T6)
3	1	G2619A	GEAR, TRANSMISSION MAIN
4	1	G3197	WASHER, MAIN DRIVE GEAR RETENTION
5	1	G3245A	CAM, CYCLE MICRO LIMIT SWITCH
6	1	GE2	BEARING, TRANSMISSION 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

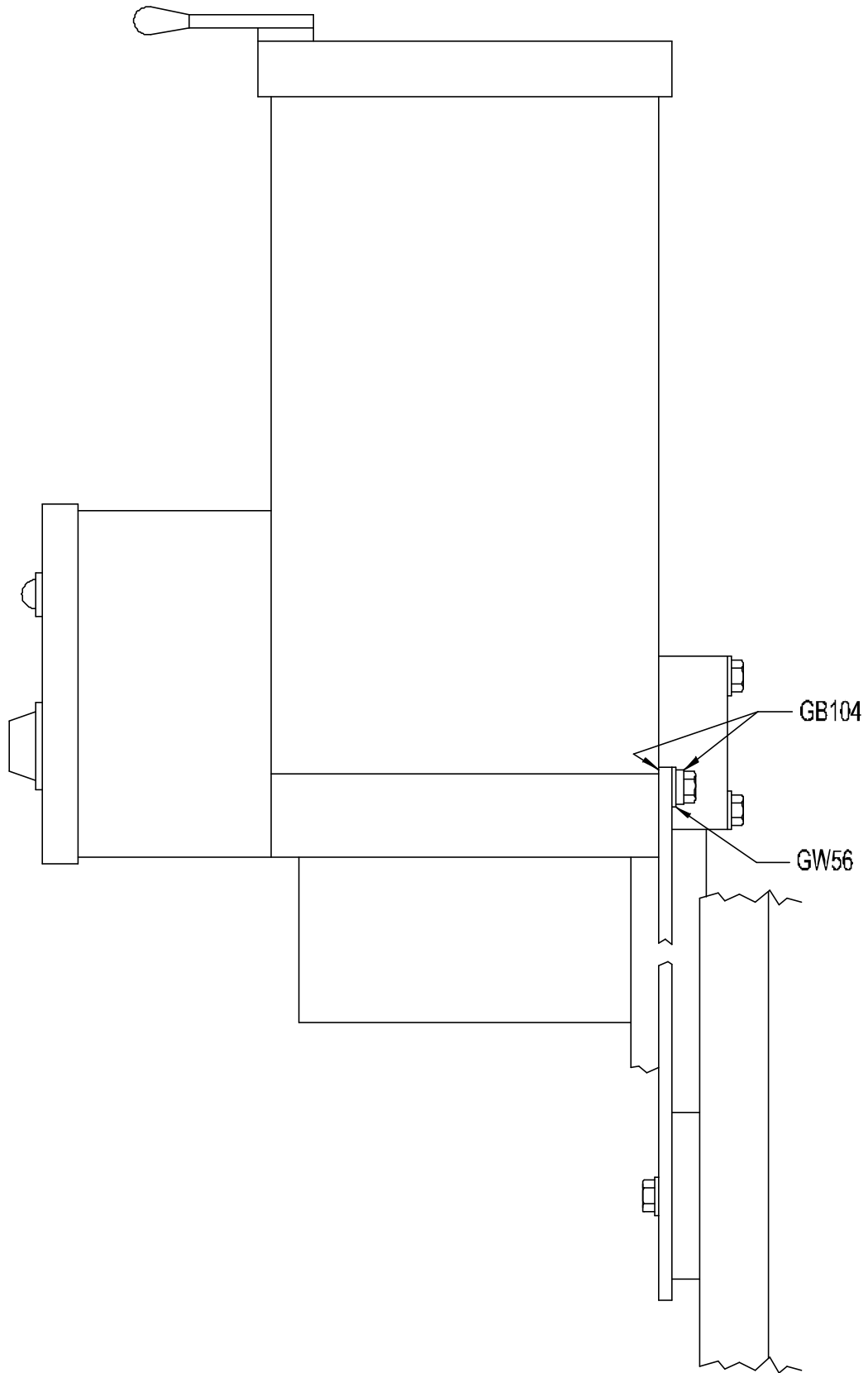


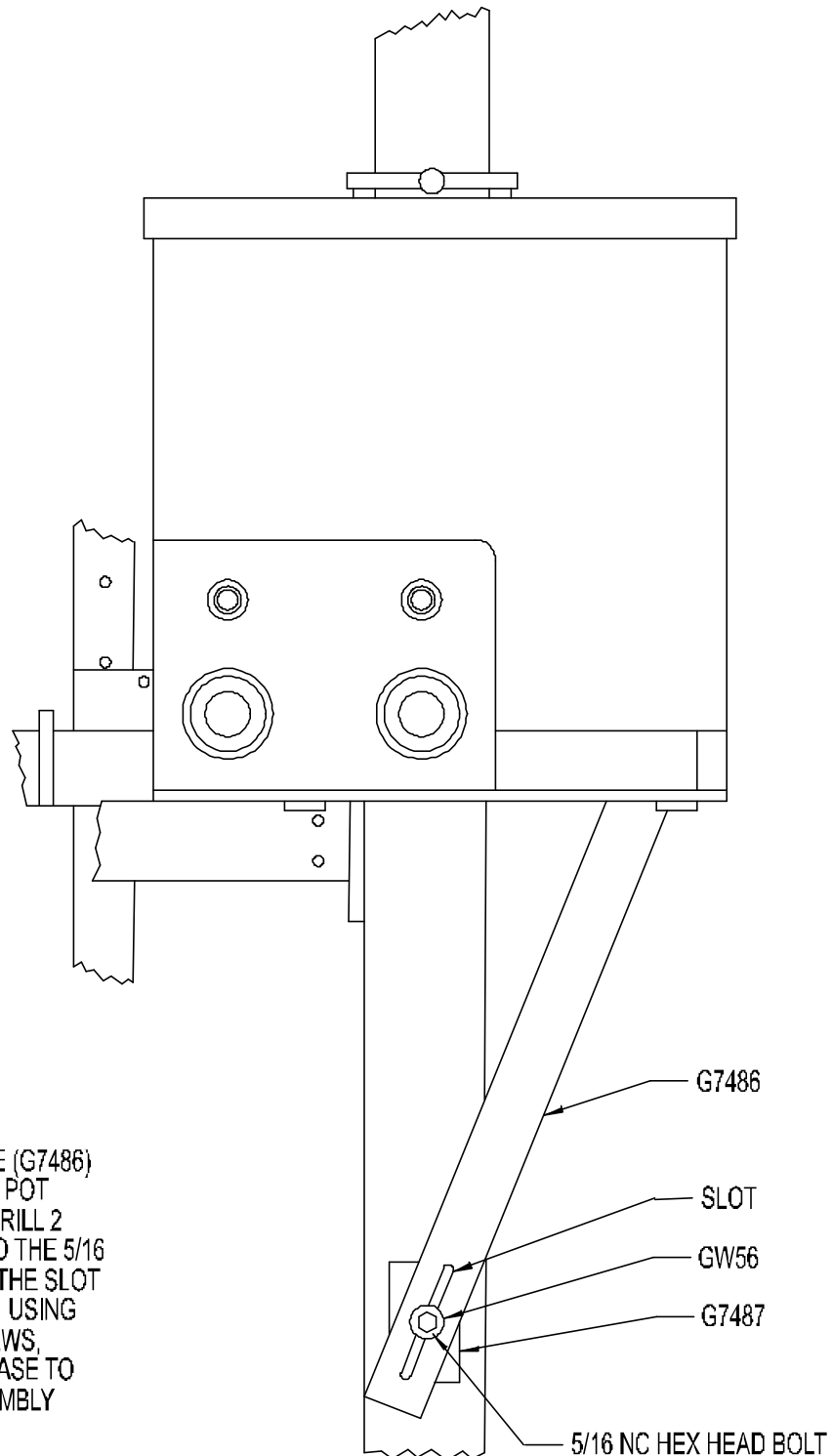
## Double Capacity Adhesive Melt Pot (Optional)

Item	Quantity	Part Number	Description
1	1	G2758	KNOB, MELT POT COVER
2	1R / 1L	G2967	CLAMP, GLUE POT MOUNTING
3	1	G2997	HEATER, GLUE MELTING
4	2	G2998B	THERMOSTAT
5	2	G2998B-1	KNOB ,THERMOSTAT
6	1	G3067	STUD, GLUE POT COVER KNOB W/ LOCKNUT 10-32
7	1R / 1L	G3089B	CASTING, GLUE POT
8	1R / 1L	G3130	PLATE, GLUE POT MOUNTING
9	2	G7121	HEATER, GLUE POT STRIP
10	1	G7122	ENCLOSURE, GLUE POT CONTROL
11	1	G7123	PANEL, GLUE ENCLOSURE
12	1R / 1L	G7124	MANIFOLD, GLUE POT
13	1R / 1L	G7125	BASE, GLUE POT FRONT
14	1R / 1L	G7126	BASE, GLUE POT REAR
15	2	G7127	PLATE, STRIP HEATER CLAMP
16	1	G7128	HANDLE, LARGE GLUE POT
17	4	G7129	WASHER, GLUE POT MOUNTING
18	1	G7130	SHROUD, GLUE POT
19	1	G7131	END CAP, GLUE POT FIXED
20	1	G7132	SCREEN, GLUE POT FIXED
21	1	G7133	SCREEN, GLUE POT
22	1	G7134	COVER, GLUE POT
23	1	G7135	PLATE, BOTTOM ENCLOSURE SHROUD
24	2	GB40	BUSHING, GLUE POT COVER AXLE
25	2	GB272	BUSHING, GLUE POT MOUNTING
26	4	GB396	SPACER, GLUE POT CASTING MOUNTING
27	2	GB499	SPACER, HANDLE MOUNTING
28	2	GV6A	LIGHT, HEATER INDICATING
29	2	GV6B	LAMP, HEATER INDICATING
30	2	G8D-2	TERMINAL BLOCK SECTION END 230
31	6	G8A-11	TERMINAL SECTION 514







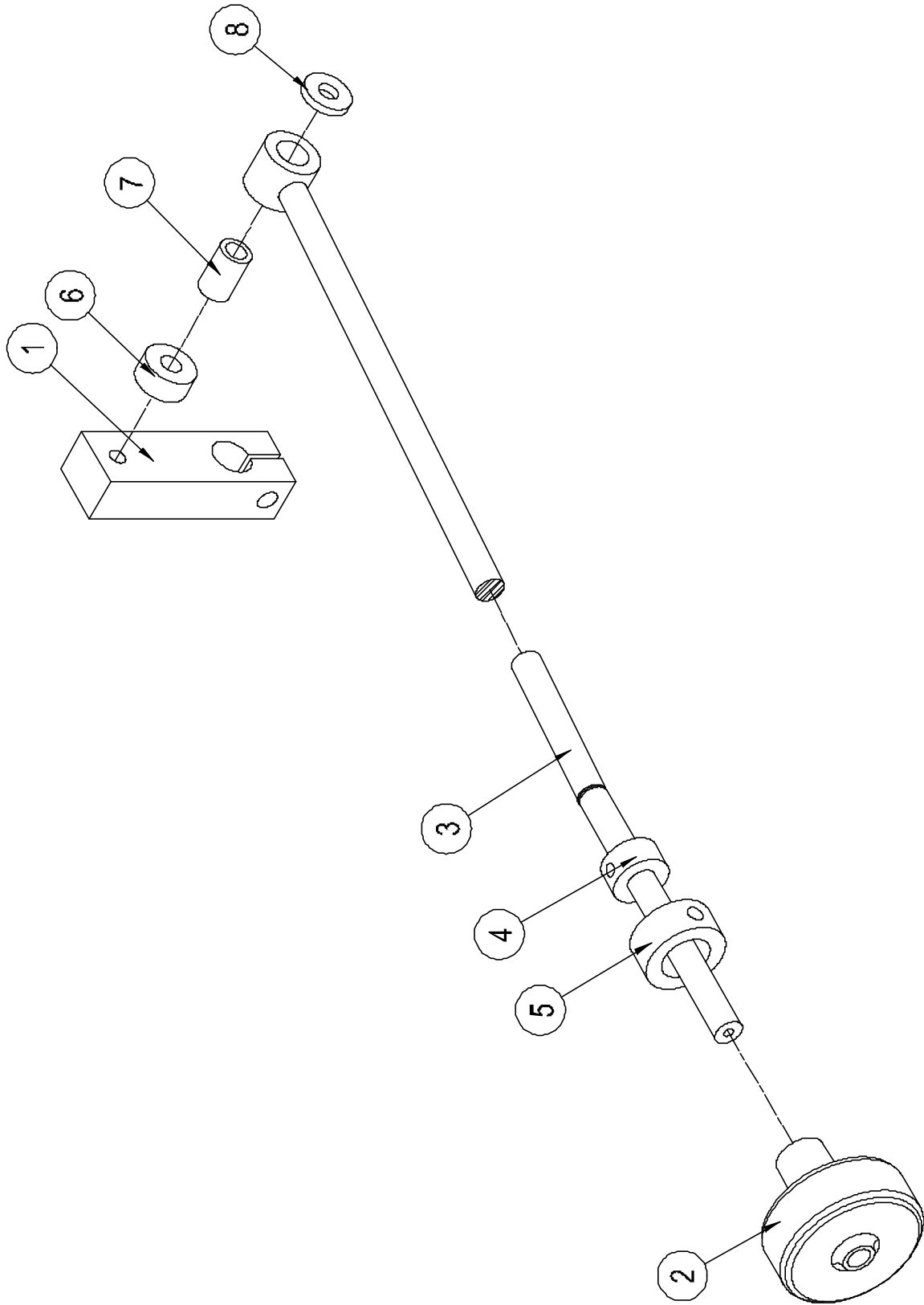


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### Vari Speed Control Knob Assembly

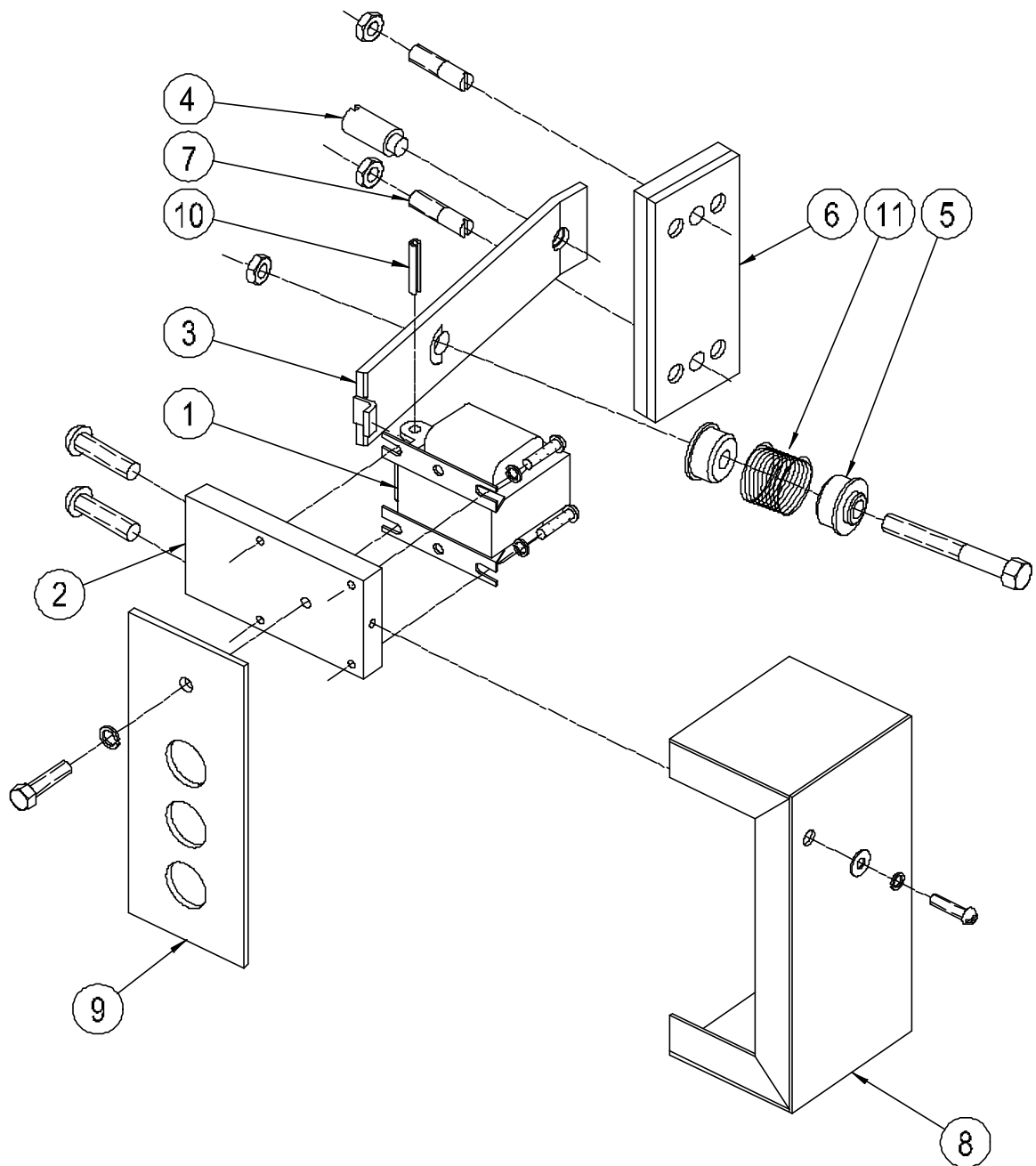
Item	Quantity	Part Number	Description
1	1	G3232	ARM, MOTOR DRIVE SPEED CONTROL
2	1	G3234	KNOB, SPEED CONTROL
3	1	G3235	ROD, SPEED CONTROL OPERATING
4	1	GA5	SET COLLAR, SPEED CONTROL ROD STOP
5	1	GA9	SET COLLAR, SPEED CONTROL ROD RETAINING
6	1	GB267	SPACER, SPEED CONTROL OPERATING ROD 13/16 OD x 21/64 ID x 3/8 LONG
7	1	GB271	BUSHING, SPEED CONTROL OPERATING ROD 1/2 OD x 21/64 ID x 25/32 LONG
8	1	GW56	WASHER, 3/4 OD x 5/16 ID x 1/8 THICK

Note: These parts may be purchased as a assembled package, to order specify BU176.



**Mandrel Stop Brake Assembly**

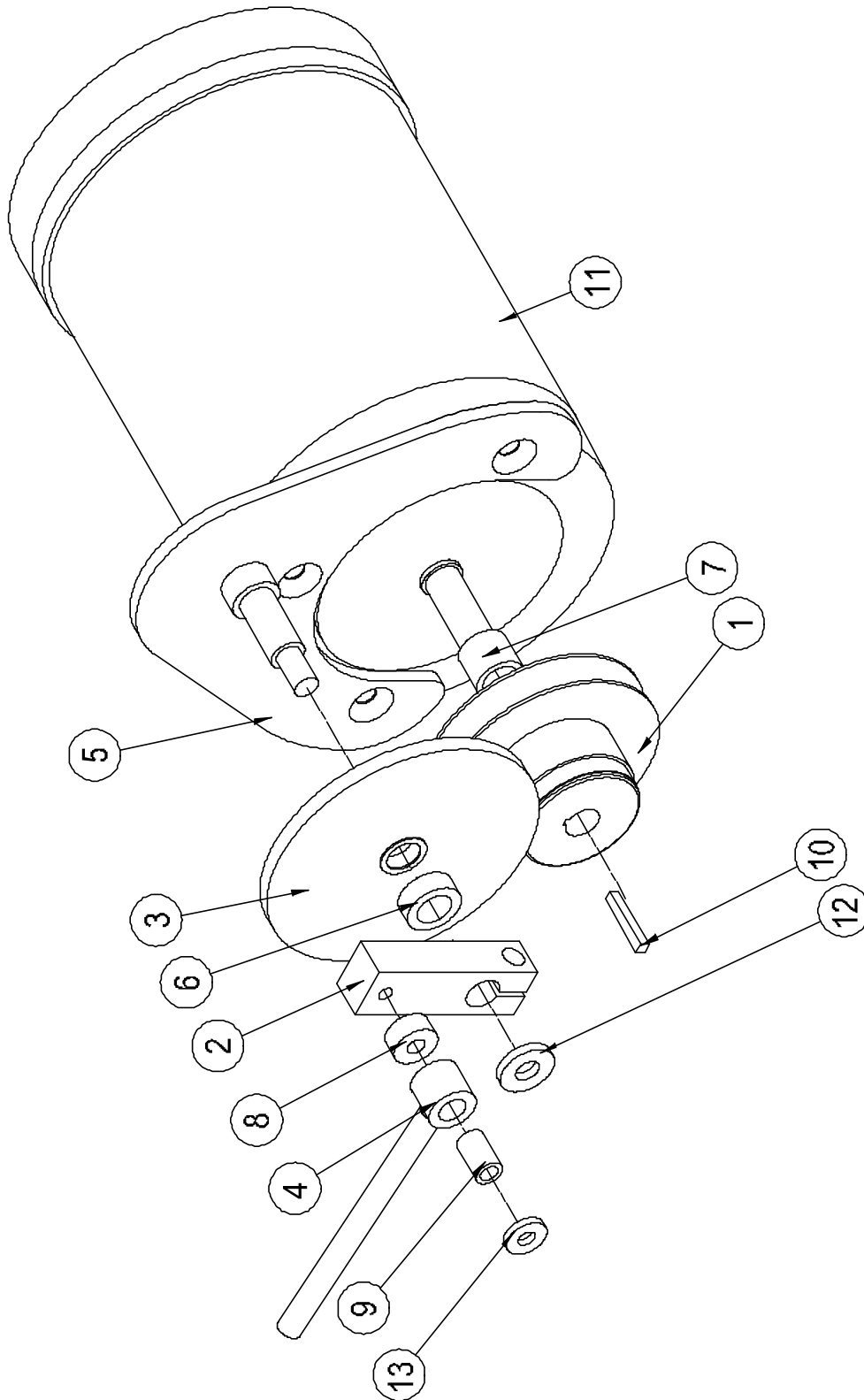
<b>Item</b>	<b>Quantity</b>	<b>Part Number</b>	<b>Description</b>
1	1	G3237B	SOLENOID, MAGNETIC BRAKE RELEASE (115 VOLT)
2	1	G3238	BRACKET, BRAKE SOLENOID MOUNT
3	1	G3239	LEVER, BRAKE PIVOT
4	1	G3240A	SCREW, BRAKE PRESSURE SPRING
5	2	G3241	WASHER, BRAKE PRESSURE SPRING
6	1	G3242	BRAKE SHOE AND LINING
7	2	G3243A	STUD, BRAKE SHOE RETAINING
8	1	G3244	COVER, BRAKE SOLENOID
9	1	G3244A	FLAT, BRAKE SOLENOID COVER MOUNTING
10	1	GG5G	PIN, SOLENOID PLUNGER
11	1	GS17	SPRING, BRAKE PRESSURE



### “V” Belt Vari-Drive Assembly

Item	Quantity	Part Number	Description
1	1	G3231*	PULLEY, VARI-DRIVE MOTOR..12-35 OR 21-58 SPEED
		G3231*	PULLEY, VARI-DRIVE MOTOR..29-70 SPEED
2	1	G3232	ARM, MOTOR DRIVE SPEED CONTROL
3	1	G3233	WASHER, MOTOR DRIVE BASE
4	1	G3235	ROD, SPEED CONTROL OPERATING
5	1	G3236	BASE, MOTOR DRIVE
6	1	GB145	BUSHING, SPEED CONTROL ARM SPACER 1 OD x 41/64 ID x 3/8 LONG
7	1	GB198	BUSHING, MOTOR PULLEY SPACER 7/8 OD 5/8 ID x 3/4 LONG
8	1	GB267	BUSHING, SPEED CONTROL OPERATING SPACER 13/16 OD x 21/64 ID x 3/8 LONG
9	1	GB271	BUSHING, SPEED CONTROL OPERATING ROD 1/2 OD x 21/64 ID x 25/32 LONG
10	1	GJ9D	KEY, VARI-DRIVE PULLEY
11	1	GM4B*	MOTOR, 3/4 H.P., 3 PHASE, 240/460V, 50/60HZ 1800 RPM
		GM4D*	MOTOR, 3/4 H.P., 3 PHASE, 115/230V, 50/60HZ 1200 RPM
12	1	GW1	WASHER, 1 OD x 7/16 ID x 5/32 THICK
13	1	GW56	WASHER, 3/4 OD x 5/16 ID x 1/8 THICK

Note: \* Refer to machine order part number.



# Master Parts List

## Vacuum Feed Parts List : (optional)

Total package- PART # 60-00259-00 - Vacuum Feed

Sub Part breakdown below:

Sub Part #	Description	Sub Part Qty.
00-00170-00	OIL CUP	1
00-01562-02L	KNIFE SUPPORT	2
00-01562-02R	KNIFE SUPPORT	2
00-02444-00	RING BEARING CLAMP	1
00-02746-05	SUPPORT , HOPPER LOADING	1
00-03362-00	GEAR, TRANSMISSION PINION	1
00-03737-00	TUBING,3/8" POLY WTHRHD PT240-6	30
00-04423-00	VALVE, VACUUM RELIEF	1
00-04432-01	TUBE, SUCTION CUP MOUNTING VP	6
00-04436-01	CAM, VACUUM VALVE OPERATING	1
00-04441-01	BRACKET, VAC. CUP TUBE SUPPORT	6
00-04552-00	PLATE , VACUUM CUP BACK VP	6
00-04553-00	BOLT, VACUUM CUP	6
00-04554-00	PAD, VACUUM CUP	6
00-04557-00	PLATE, VAC. SUPPORT	2
00-07006-00	VACUUM HOSE, 1 1/2" ID BANTAMFL	2
00-07009-02	BLOWER, FUJI VFC 309A-7W	1
00-07012-00	VACUUM HOSE CLAMP NORTON # 28	2
00-07299-00	SPROCKET, 40B10 KEY WAY & S.S.3	1
00-07553-00	MANIFOLD VAC. DUMP VALVE	1
00-07554-00	PIVOT, VACUUM VALVE ARM	1
00-07555-00	PAD, VACUUM VALVE COVER	1
00-07556-00	DEFLECTOR, VAC. BLOWER EXHAUST	1
00-07557-00	ARM, VAC. VALVE OPERATING	1
00-07802-00	FITTING, VACUUM HOSE	1
00-07803-00	GEAR, VACUUM FEED DRIVE	1
00-07804-00	SPROCKET, VAC. FEED DRIVE	1
00-07805-00	AXLE PINION DRIVE 1T4	1
00-07805-01	AXLE PINION DRIVE 1T6	1
00-07806-00	SPROCKET , VAC. FEED RATIO 4: 1	1
00-07807-00	PLATE, VAC. FEED DRIVE MOUNT	1
00-07808-00	CON ROD, VACUUM FEED DRIVE	1
00-07809-00	SHAFT, VAC. CUP OPERATING	1
00-07810-00	LEVER, VAC. CUP SLIDE OPERATING	2
00-07811-00	SPACER, CAM FOLLOWER	2
00-07812-00	WEAR PAD CAM FOLLOWER SPACER	2
00-07813-00	PLATE, VACUM CUP MOUNTING	1
00-07814-00	LINKAGE, VAC. CUP MOUNTING	2
00-07815-00	LEVER , VERTICAL ALIGNMENT	4
00-07816-00	LEVER, VAC. CUP MOUNT PLATE	2
00-07817-01	BRACKET, CUP MOUNTING PLATE	2

Sub Part #	Description	Sub Part Qty.
00-07818-00	PLATE, MAIN LINKAGE MOUNTING	2
00-07819-01	LINK VAC. FEED CONNECTING	2
00-07820-00	BAR, VACUUM CUP CAM SUPPORT	2
00-07821-00	BEARING LINEAR BALL SLIDE VAC.	2
00-07822-00	RETAINING RING , BEARING VAC.	2
00-07823-00	SEAL, LINEAR BALL BUSHING VAC.	2
00-07824-00	SHAFT, VAC. FEEDER SLIDE BLOCK	1
00-07825-01	BRACKET, VAC. FEED CAM TOP	1
00-07825-02	BEARING, VACUUM FEED OPERATING	1
00-07826-00	BRACKET, VAC. CUP CAM BOTTOM	1
00-07827-00	CAM, VAC. CUP OPERATING	1
00-07828-00	BLOCK, SLIDE BEARING	1
00-07829-00	PLATE, VAC. FEED MOUNTING RIGHT	1
00-07830-00	PLATE, VAC. FEED MOUNTING LEFT	1
00-07831-00	STUD, VAC. FEED GUARD MOUNTING	4
00-07832-01	GUARD, VAC. FEED 1T4	1
00-07832-02	GUARD , VAC. FEED 1T6	1
00-07833-00	BASE, VAC. BLOWER MOUNTING	1
00-07905-00	BAR, VAC. CUP BOTTOM PLACE	2
00-07906-00	PLATE, HOPPER BOTTOM STOP	2
00-07907-00	BAR, HOPPER BOTTOM STOP PLATE	1
00-08244-00	SET COLLAR, VACUUM TUBE LOCATING	6
00-08358-00	ELBOW 90 DEGREE STREET	1
00-08418-00	CLAMP, VAC. CUP BRACKET MOUNTING	2
00-08419-00	SPACER, VAC. CUP BRACKET CL	4
00-08420-00	BRACKET, HOPPER SIDE GUIDE	4
00-08421-00L	GUIDE TRAY HOPPER SIDE	1
00-08421-00R	GUIDE TRAY HOPPER SIDE	1
02-00060-00	BUSHING 1: OD x 25/64 ID x 13/16 LONG	2
02-00079-00	BUSHING 11/4 OD x 29/64 ID x 9/16 LONG	1
02-00326-00	BUSHING 11/4 OD x 1" ID x 3/4 " BRO	1
02-00352-00	BUSHING, 1" OD x 21/32" ID x 1/8" LONG	6
02-00361-00	BUSHING, 5/8" OD x 21/64" ID x 13/16 LONG	14
02-00435-00	BUSHING, 5/8" OD x 3/8" ID x 49/64" LONG	4
02-00514-00	BUSHING, 1" OD x 25/64" ID x 1 3/8" LONG	2
04-00028-00	VACUUM SWITCH , A/B 800TH2D1	1
04-00063-01	1EC CONTACTOR, A/B 100-A09ND3	1
04-00067-03	OVERLOAD RELAY , A/B 193-BSB22	1
05-00013-00	BEARING, NDH 488505 OR EQUAL	1
05-00050-00	CAM FOLLOWER	1
05-00051-01	ROD END BEARING 7/16"	2
05-00070-00	BEARING	2
05-00070-01	BEARING	1
05-00082-00	BEARING, NDH #55505 OR EQUAL	1
05-00083-00	CAM YOKE ROLLER , 1" MCGILL #C	1
08-20001-00	ROLLER CHAIN #40 RIV. BULK ROLL	4
08-20001-01	MASTER LINK #40	1
10-00009-04	KEY, 3/16" x 3/16" x 1 1/4	1
10-00010-01	KEY, 1/4" x 1/4" x 1 LONG	1

Sub Part #	Description	Sub Part Qty.
19-00180-00	SPRING, 31/32" OD x .045 x 3 3/8 LONG	6
23-00001-00	WASHER 1" OD x 29/64 ID x 5/32' THICK	4
23-00001-01	WASHER 1" OD x 29/64 ID x 5/32' THICK	6
23-00001-02	WASHER 1" OD x 5/16 ID x 5/32' THICK	13
23-00012-00	WASHER 1 1/4" OD x 25/64 ID x 3/16" THICK6	
23-00063-00	WASHER 3/4" OD x 17/64 ID x 1/8" THICK	4
23-00084-00	WASHER 1 1/4" OD SPEC. DIMPLED 5/8	6
23-00089-00	WASHER 1 1/8" OD x 5/8" ID x 1/8" THICK	6
40-008-04	TERMINAL BLOCK	3
	SPECIAL ORDER 1/4 PIPE TO 3/8 TUBE CONNECTOR	6
	SPECIAL ORDER 1/4 PIPE TO 3/8 TUBE MALE ELBOW	6

# Options

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The following are available options for the TF400/600V Traymatics. Contact SWF Machinery for information.

- Large capacity glue pots
- Time delay
- Down stream control systems
- Color coded wiring
- Customized paint
- Left hand control box
- NEMA 4 power cabinet enclosures
- Hoppers, various capacities
- Hopper, horizontal powered
- Hopper , low level indicator
- Hopper, empty cycle stop
- Bottom stop jam detector
- Pressurized hot melt systems
- Cold glue systems
- Code daters / Bar counters
- Adjustable legs
- Special guarding
- Additional manuals

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