

BF 400VK / 600VK
Kwik Change Bliss-Matic[®]
Options



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Safety Practices

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

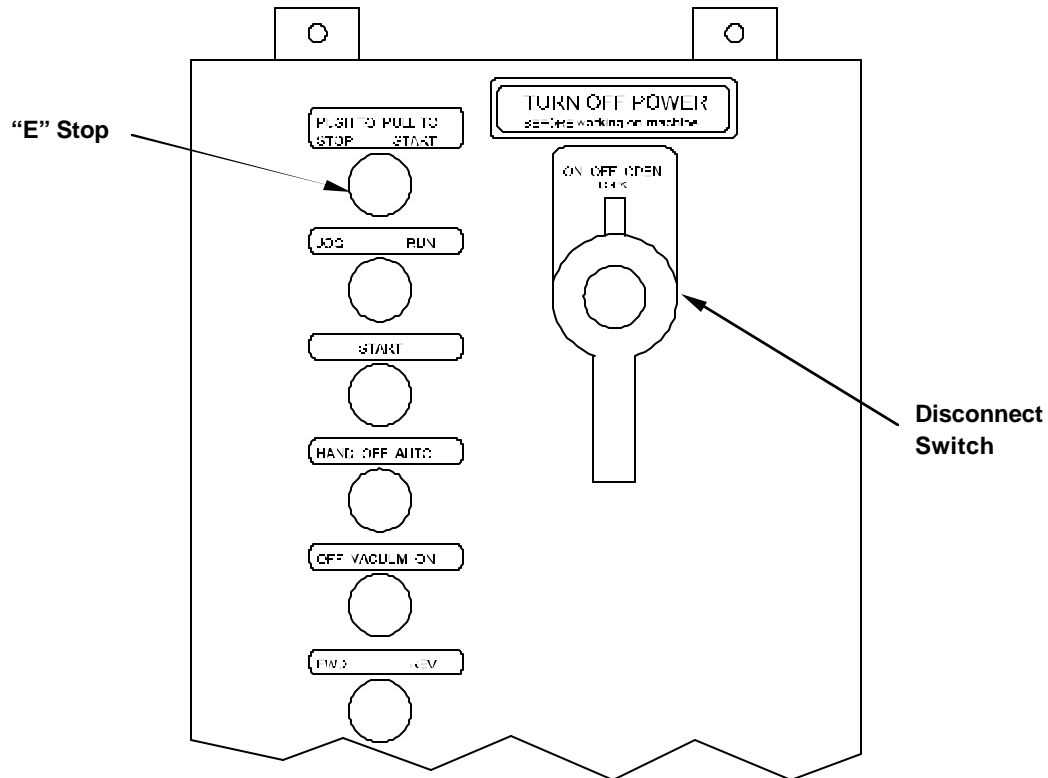
-  Never adjust, repair, clean, or clear a jam without turning the power off. To shut down the power, turn the disconnect switch to the off position and lock it in the off position.
-  Do not operate this machine without the guards in place.
-  Turn off the power before removing or opening any guards. Turning off the power means locking the power disconnect switch in the off position.
-  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.
-  Replace all broken or worn parts immediately. Check and tighten all bolts and screws.
-  High voltage electrical equipment – authorized personnel only.
-  Turn off the power when the machine is not in use.
-  This machine starts automatically in the ‘auto’ position when the downstream control contact and/or time delay attachment is used.
-  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 perform an emergency stop and a normal cycle stop 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 corrugated 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.

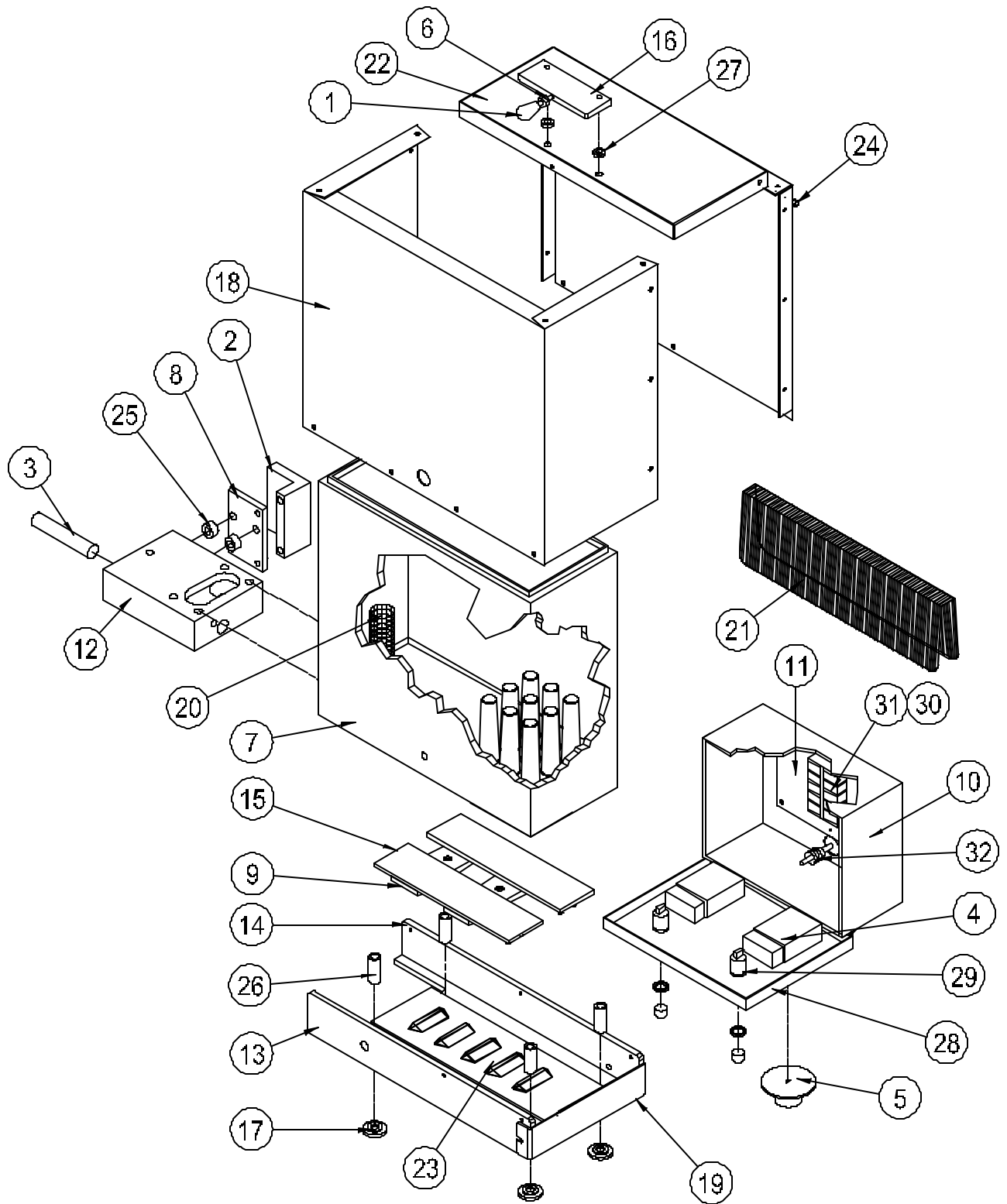
Options

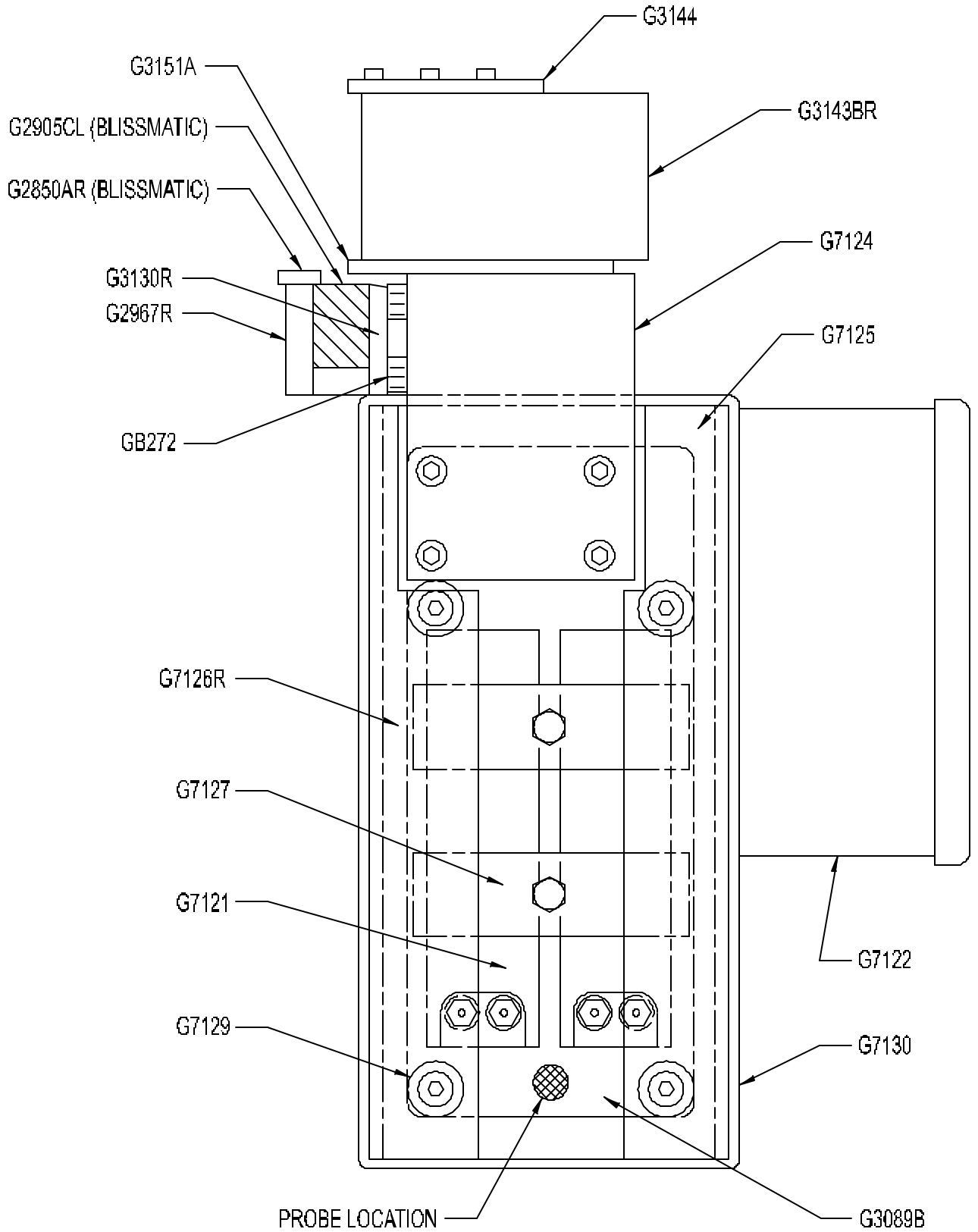
The following are available options for the SWF 1D5AK/1D6AK BLISSMATICS. Contact SWF Machinery for information.

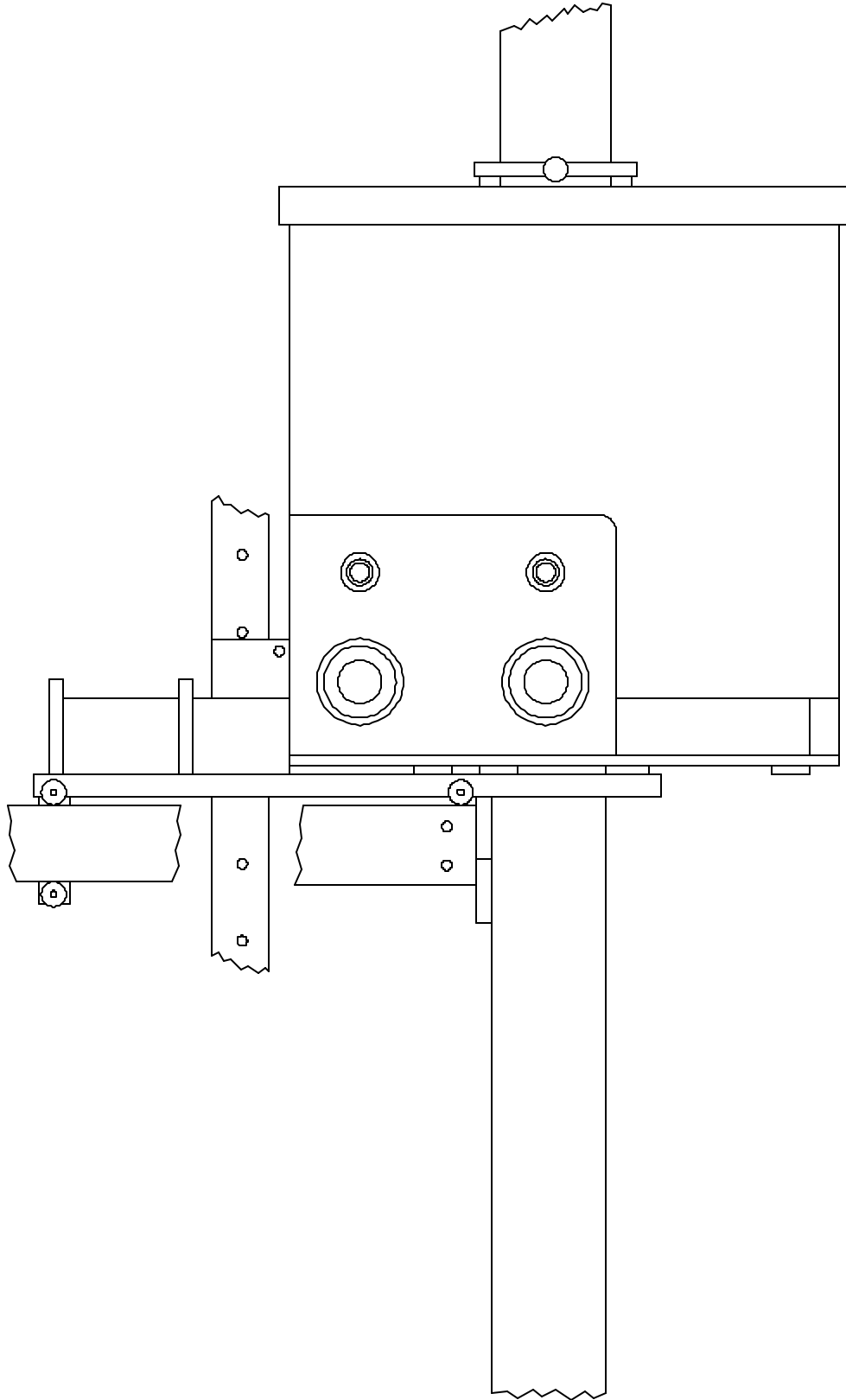
- Large capacity glue pots
- Time delay
- Down stream control systems
- Color coded wiring
- Customized paint
- Left hand control box
- NEMA 4 power cabinet enclosures
- Hoppers, various capacities
- Hopper, horizontal powered
- Hopper , low level indicator
- Hopper, empty cycle stop
- Bottom stop jam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

Double Capacity Adhesive Melt Pot

Item	Qty.	Part No.	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



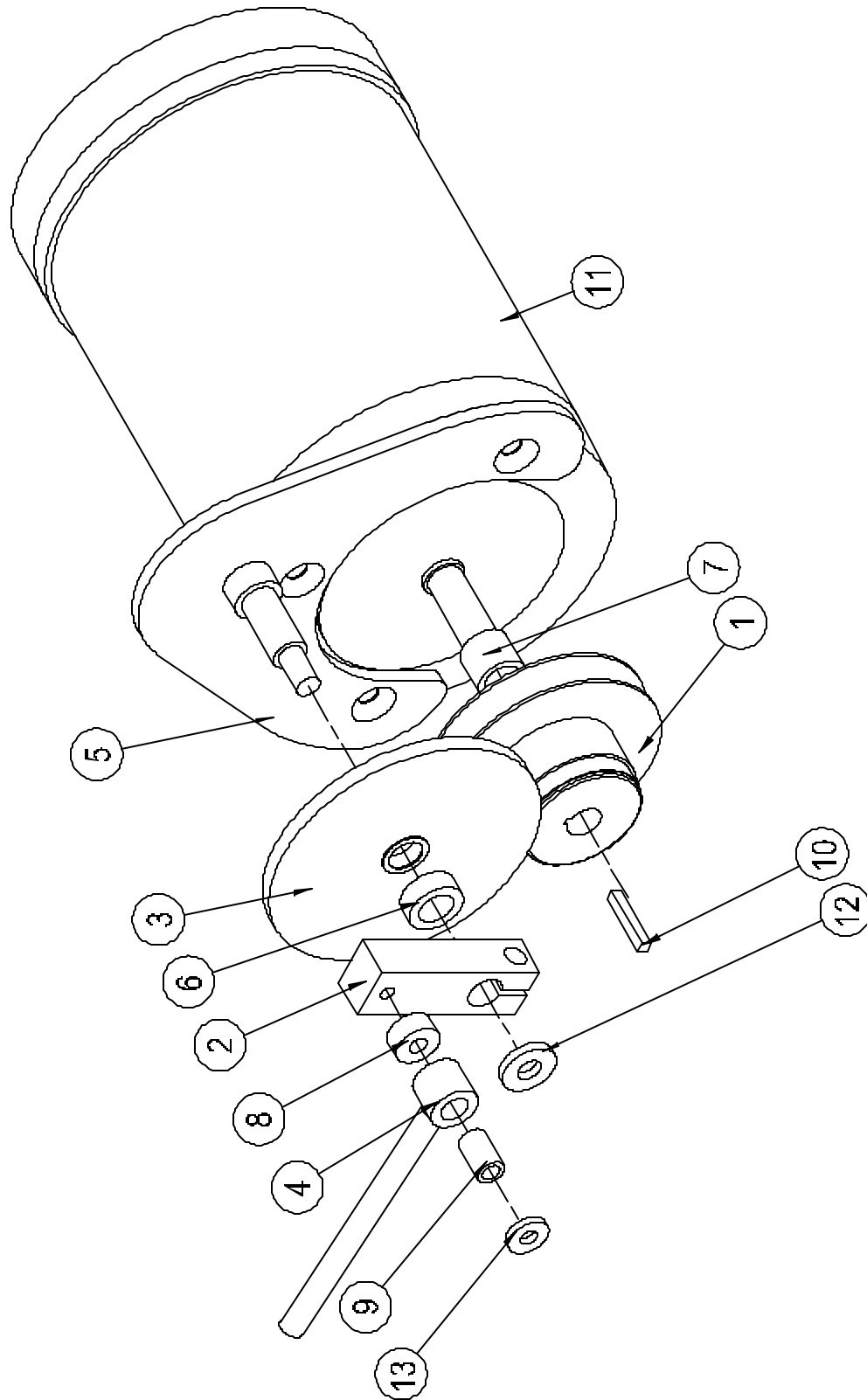




V-Belt Vari-Drive

Item	Qty.	Part No.	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
		GM5D*	MOTOR, 1 H.P., 3 PHASE, 230/460V, 50/60HZ 1140 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

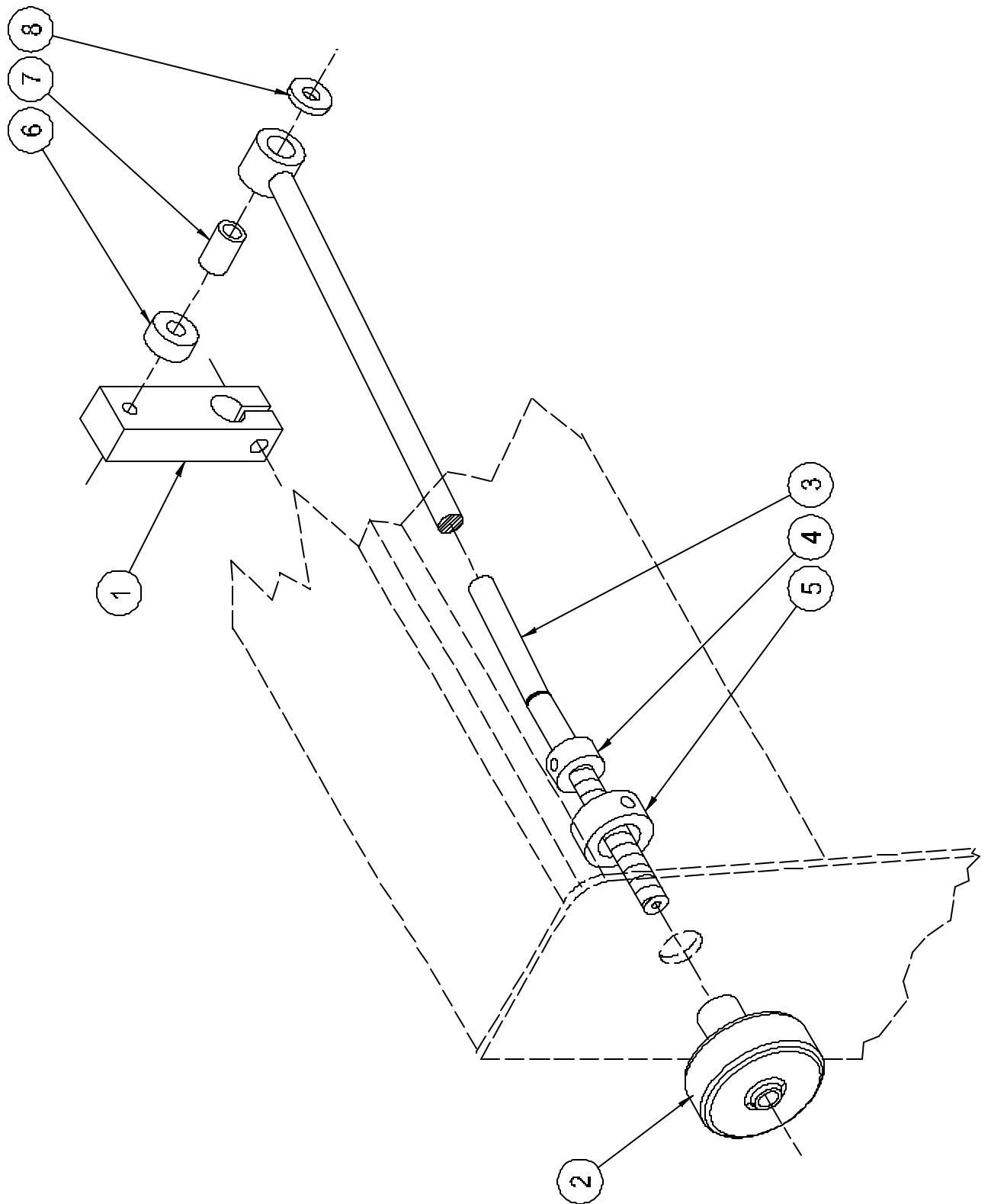
Note: * Refer to machine order part number



Vari-Speed Control

Item	Qty.	Part No.	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 KNOB RETAINING
6	1	GB267	SPACER, CONTROL OPERATING ROD
7	1	GB271	BUSHING, SPEED CONTROL OPERATING ROD
8	1	GW56	WASHER, 3/4" OD x 5/16" ID x 1/8" THICK

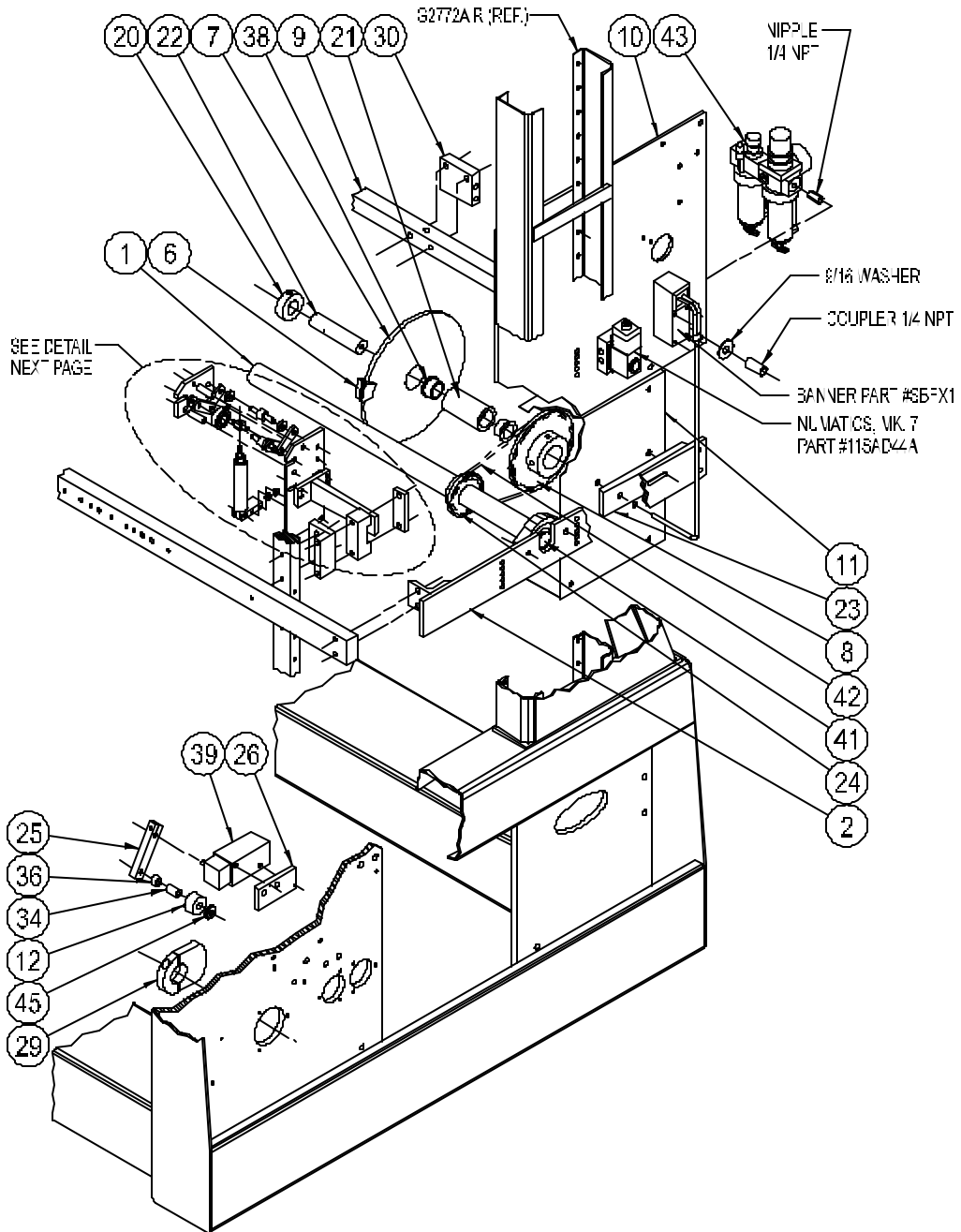
Note: These parts may be purchased as a preassembled package. To order, specify BU176.

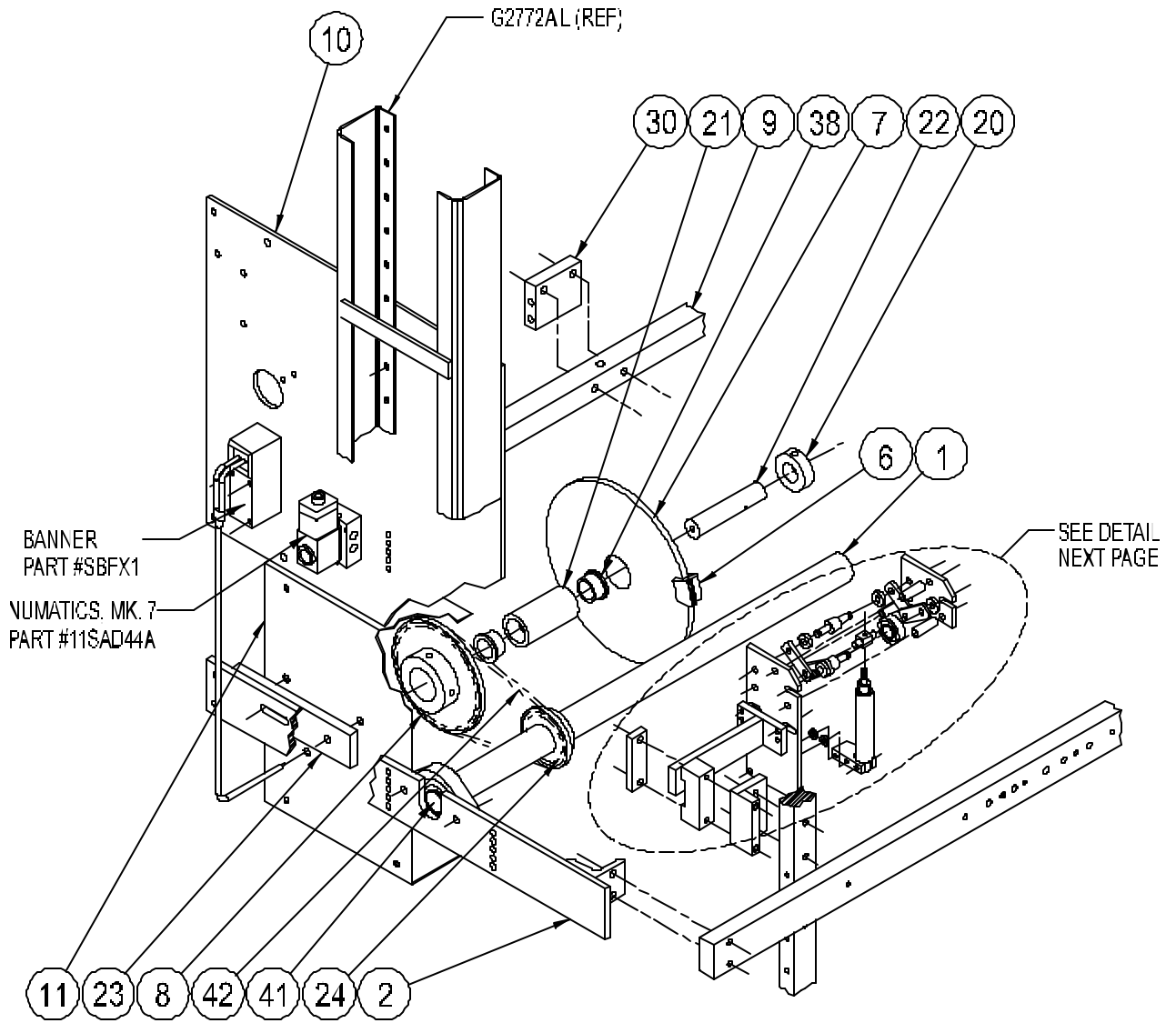


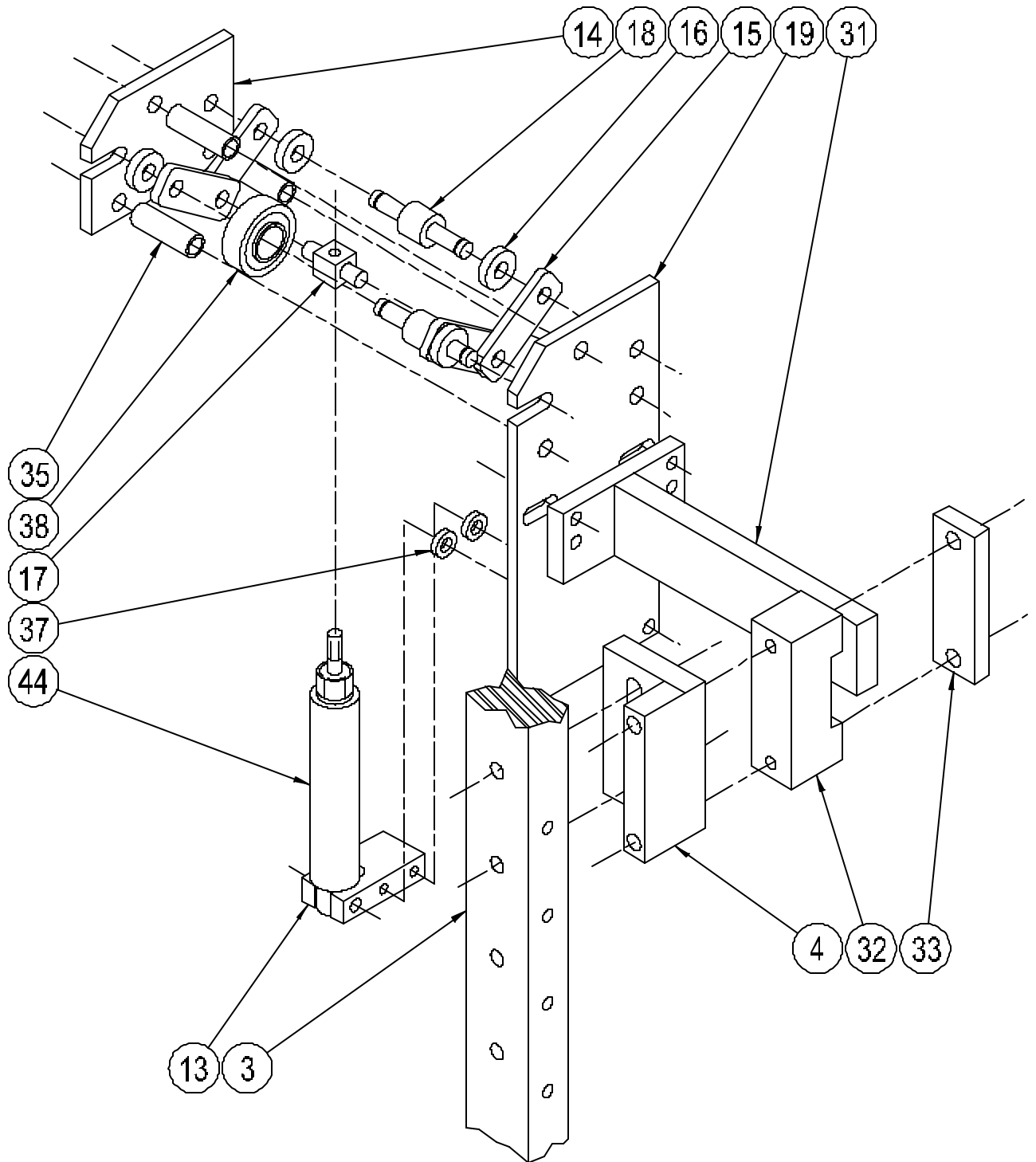
Bliss Back-up Roller Programmer (Right, Left Side & Air Programmer)

Item	Qty.	Part No.	Description
1	1	G2832E	SHAFT, MATT FEED ROLLER
2	1	G2900I	PLATE, MATT FEED WHEEL SHAFT MOUNTING
3	1	G2905C	BAR, MATT GUIDE VERTICAL R & L
4	1	G2967A	CLAMP, ADHESIVE MELT POT
5	1	G2999D	BAR, MATT FEED IDLE ROLLER
6	1	G3028B	SEGMENT, AHESIVE APPLICATOR PROGRAM
7	1	G3029A	DISC, INTERMITTENT ADHESIVE APPLICATOR PROG.
8	1	G7806C	SPROCKET, PROGRAM BACK-UP ROLLER
9	1	G7820	BAR, VACUUM FEED MOUNTING RIGHT
10	1	G7829	PLATE, VACUUM FEED MOUNTING RIGHT
11	1	G7832B	GUARD, PROGRAM DISC
12	1	G8458A	ROLLER, MICROSWITCH OPERATING
13	1	G8628	BRACKET, CYLINDER PIVOT MOUNTING
14	1	G8629	PLATE, PROGRAM BACK-UP ROLLER SIDE
15	4	G8630	LINK, PROGRAM OPERATING
16	4	G8631	SPACE, GLUE BACK-UP ROLLER
17	1	G8632	AXLE, ROLLER ACTUATOR LINK
18	2	G8633	PIN, BLISS BACK-UP ROLLER AXLE
19	1	G8634	PLATE, PROGRAM BACK-UP ROLLER MOUNTING
20	1	G8635A	SET COLLAR, PROGRAM DISC
21	1	G8636	BEARING, DISC PROGRAM
22	1	G8637	AXLE, PROGRAM DISC MOUNTING
23	1	G8638	PLATE, PROGRAM DISC MOUNTING
24	1	G8639	SPROCKET, PROGRAM BACK-UP ROLLER
25	1	G8640A	LEVER, MICROSWITCH OPERATING
26	1	G8641A	PLATE, MICROSWITCH MOUNTING
27	1	G8643A	COVER, LEAD FIBER OPTIC EYE
28	2	G8643B	PLATE, BANNER EYE MOUNTING
29	1	G8644B	CAM, BLISS PROGRAMMER REVOLUTION OPERATING
30	1	G8646	MANIFOLD, BLISS PROGRAM AIR
31	1	G8647	BRACKET, PROGRAM BACK-UP ROLLER MOUNTING
32	1	G8648	BLOCK, PROGRAM BLISS BACK-UP ROLLER MOUNTING
33	1	G8649	CLAMP, BLISS BACK-UP ROLLER PROGRAM MOUNTING
34	1	GB45	BUSHING, 9/16 OD x 3/8 ID x 51/64 LONG
35	3	GB331	BUSHING, 7/16 OD x 21/64 ID x 1 3/8 LONG
36	1	GB372	BUSHING, 3/4 OD x 3/8 ID x 25/64 LONG
37	2	GB499	BUSHING, 1/2 OD x 17/64 ID x 1/8 LONG
38	2	GB512	BUSHING, 1 1/4 OD x 1 ID x 3/4 L w/ 1 1/2 OD x 1/8 T FLANGE
39	1	GD68	MICROSWITCH, SPOT SIDE ROTARY (HDLS)

40	1	GE19	BEARING, 1.378 OD x .6299 ID x .5669 THICK
41	2	GE70A	BEARING, MATT FEED ROLLER
42	1	GHB1K	CHAIN
43	1	GP1	REGULATOR, LUBRICATOR, FILTER ASSEMBLY
44	1	GP5A	AIR CYLINDER, 3/4 DIA. BORE x 1 STROKE (AIR RETURN)
45	4	GW1A	WASHER, 1 OD x 25/64 ID x 5/32 LONG







Kwik Change Flange End Attachment 1 RH / 1 LH

Item	Qty.	Part No.	Description
1	1	G2692A R/L	STRIP, FORM PLUNGER GUIDE
		G3185	SPACER, COMPRESSION CHAMBER MOUNTING BRKT. (FOR 1 1/2" FLANGE, 7/16" MATERIAL THICKNESS)
		G3185A	SPACER, COMPRESSION CHAMBER MOUNTING BRKT. (FOR 3" FLANGE, 1 15/16" MATERIAL THICKNESS)
		G3185B	SPACER, COMPRESSION CHAMBER MOUNTING BRKT. (FOR 1 3/4" FLANGE, 11/16" MATERIAL THICKNESS)
2	4	G3185C	SPACER, COMPRESSION CHAMBER MOUNTING BRKT. (FOR 2" FLANGE, 15/16" MATERIAL THICKNESS)
		G3185D	SPACER, COMPRESSION CHAMBER MOUNTING BRKT. (FOR 2 1/2" FLANGE, 1 3/16" MATERIAL THICKNESS)
		G3185F	SPACER, COMPRESSION CHAMBER MOUNTING BRKT. (FOR 2 3/4" FLANGE, 1 11/16" MATERIAL THICKNESS)
3	1	G3189 R/L	BASE, FORM PLUNGER GUIDE
4	2	G3190	SPACER, FORM PLUNGER GUIDE BASE (FOR 3" FLANGE, 1 1/2" MATERIAL THICKNESS)
		G3191	SPACER, FORM PLUNGER GUIDE BASE (FOR 1 1/2", 2 1/4", 3" FLANGES, 1 1/8" MATERIAL THICKNESS)
5	1	G3191A	SPACER, FORM PLUNGER GUIDE BASE (FOR DBL WALL ENDS, 3/32" MATERIAL THICKNESS)
		G3191B	SPACER, FORM PLUNGER GUIDE BASE (FOR 2 1/4" FLANGE, 3/4" MATERIAL THICKNESS)
		G3191C	SPACER, FORM PLUNGER GUIDE BASE (FOR 1 3/4" FLANGE, 1/4" MATERIAL THICKNESS)
		G3191D	SPACER, FORM PLUNGER GUIDE BASE (FOR 2" FLANGE, 1/2" MATERIAL THICKNESS)
		G3191E	SPACER, FORM PLUNGER GUIDE BASE (FOR 2 1/2" FLANGE, 1" MATERIAL THICKNESS)
6	2	G3192A R/L	PLOW, BOX END FLANGE (WITH SIDE BLISS FLANGE)
		G3192B R/L	PLOW, BOX END FLANGE (WITH SIDE BLISS FLANGE 2" OR GREATER)
7*	1	G3193A R/L	RAIL, AUXILARY BOX END HOPPER REAR FLANGES AND LID FLAPS)
		G3193B R/L	RAIL, AUXILARY BOX END HOPPER BLISS ENDS)
8*	1	G7120A	FEED POST, BLISS INTERNAL FLANGE END
9	1	G7215A	DEFLECTOR, MATT (STANDARD TO 1 3/4" INTERNAL)
		G7215B	DEFLECTOR, MATT (2" INTERNAL FLANGE OR LONGER)
10	1	G7217B	PLATE, DEFLECTOR EXTENSION STD.
		G7217C	PLATE, DEFLECTOR EXT. (FOR 2" & OVER I.F.)
11*	4	GW58	WASHER, 1 1/8" OD x 29/64" x 1/16" THICK
		GW59	1 1/8" OD x 29/64" x 1/8" THICK

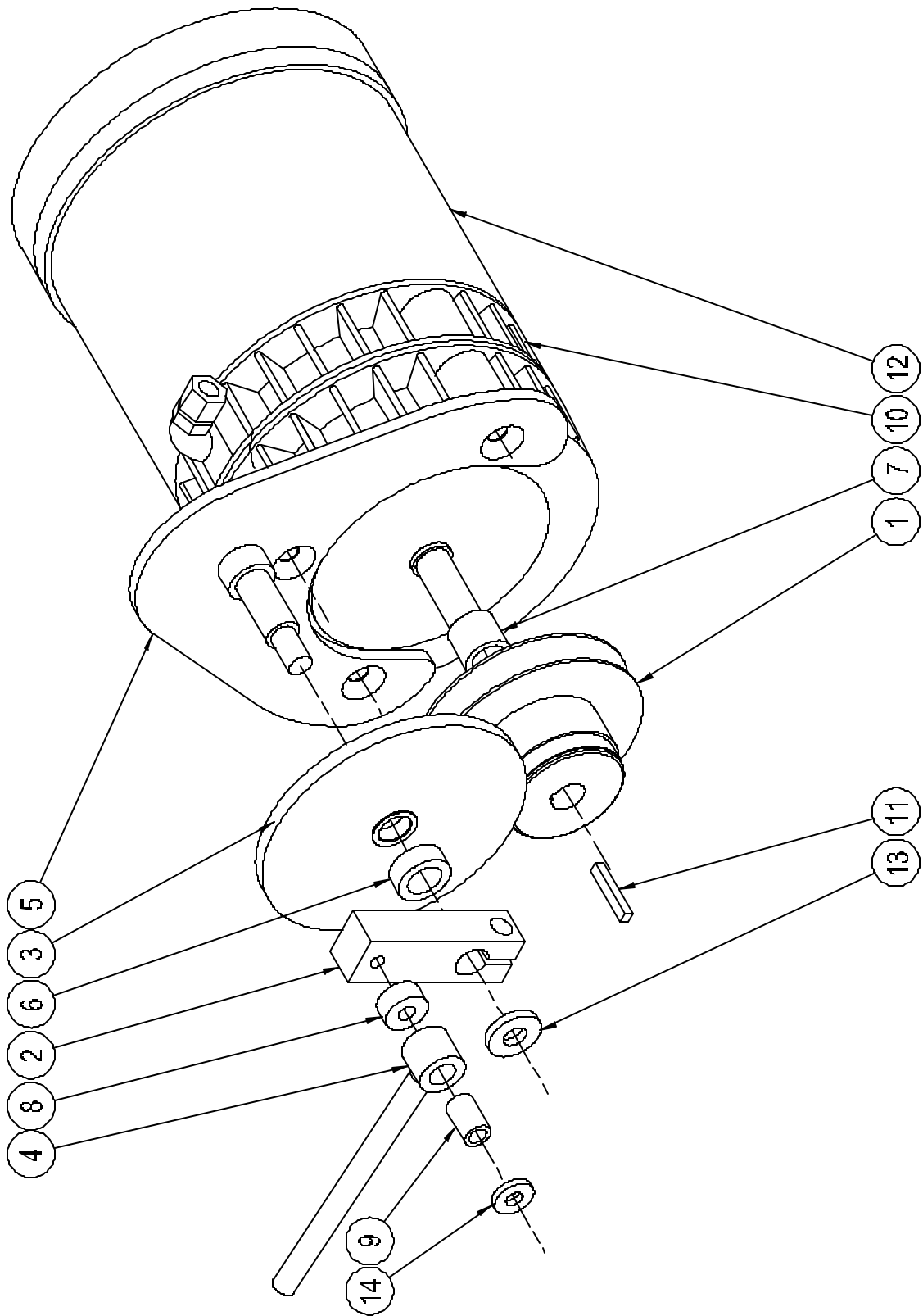
Electrical Time Delay Attachment

Item	Qty.	Part No.	Description
1	1	G3231*	PULLEY, VARI DRIVE MOTOR...12-35 OR 21-56 SPEED
	1	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
7	1	GB198	BUSHING, MOTOR PULLEY SPACER
8	1	GB267	BUSHING, CONTROL OPERATING ROD SPACER
9	1	GB271	BUSHING, SPEED CONTROL OPERATING ROD
10	1	GD52C	CLUTCH / BRAKE, TIME DELAY
11	1	GJ9D	KEY, VARI DRIVE PULLEY
12	1	GM4D	MOTOR, 3/4 HP, 3 PH 115/230 V, 50/60 HZ, 1200 RPM
13	1	GW1	WASHER, 1" OD x 7/16 ID x 5/32 THICK
14	1	GW56	WASHER, 3/4" OD x 5/16 ID x 1/8 THICK

COMPONENTS NOT SHOWN

- 1 G4723 JUNCTION BOX, ELECTRIC TIME DELAY
- 1 GD18A RELAY, TIME DELAY
- 1 GV10A SOCKET, POWER SUPPLY
- 1 GV11 POWER SUPPLY

*** REFER TO MACHINE ORDER FOR PART NUMBER**



Glue System Large- Capacity Melt Pots

TEMPERATURE CHECK AND CALIBRATION PROCEDURES

- Turn the machine power on and allow 60 minutes for the glue to reach operating temperature.
 - Measure the temperature of the melt pot with a Pyrometer at the probe location.
 - **If** the Pyro meter measurement and control dial setting are the same, the thermostat is calibrated. If the temperatures are not the same: Note the location of control dials when facing the melt pots.
 - The inner Thermostat dial controls the glue pump temperature.
 - The outer Thermostat dial controls the Melt pot temperature.
1. Set the **outer** control dial (melt pot), to the same temperature measured by the Pyrometer.
 2. Remove the **outer** control dial and note the slot in the dial shaft.
 3. Using a small screwdriver, adjust this slot until the heater light **extinguishes** (goes out.)
 4. Turn the same shaft in the **opposite** direction until the light comes back **on**.
 5. Repeat step # 3 until the light **just goes out**.
 6. Replace the **outer** control dial removed in step # 1 and set to the operating temperature.
 7. When complete, the glue pumps should be calibrated.
 8. Refer to Maintenance & Lubrication section of this manual for cleaning, purging and changing adhesive in the system.



Maintenance on any part of the adhesive section requires you wear safety goggles, heat resistant gloves, and protective clothing to prevent serious burns.

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