



Chapter 6

Adjustment and Repair Procedures

This chapter describes adjustment and repair procedures for the EDL Bundler.

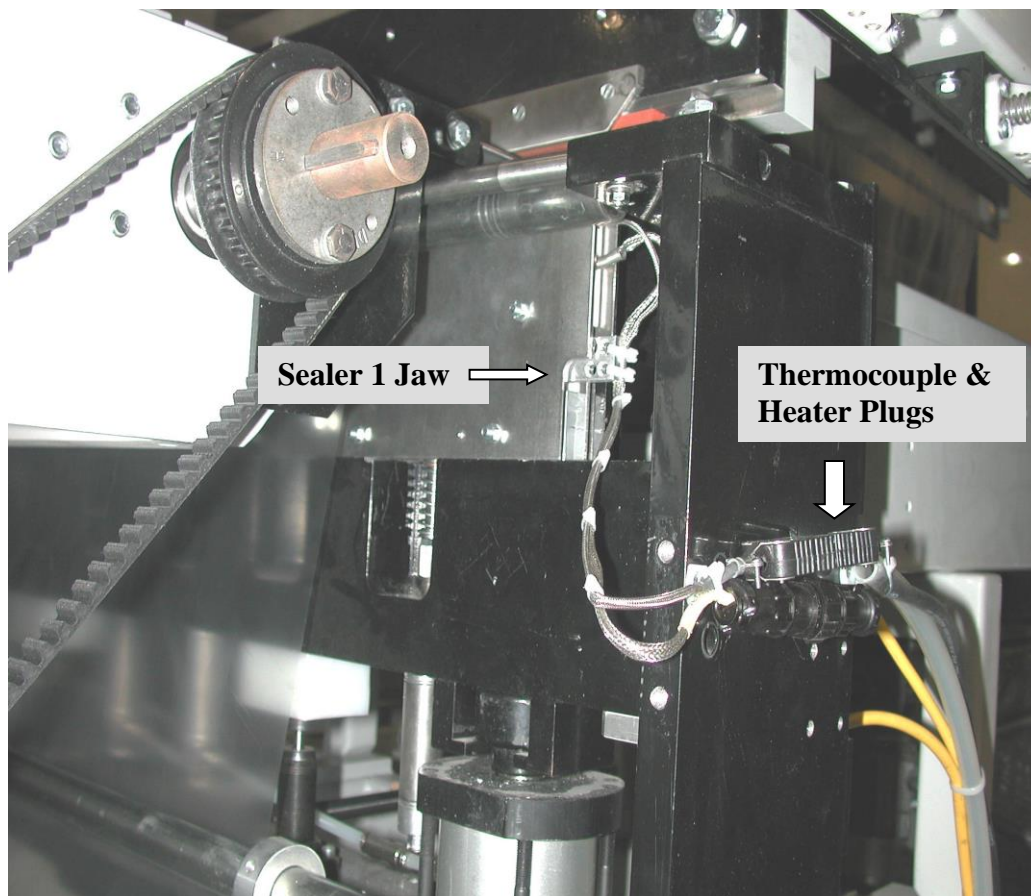
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6.1 Removing and Replacing Sealer 1 Flight Bar Jaw

Use the following procedure to remove and replace the seal jaw for Flight Bar Sealer.

1. Follow shut down procedures and stop bundler, allowing heaters sufficient time to cool down.
2. **SHUT OFF** electrical and air power to the machine.
3. **LOCKOUT** and tag the machine to prevent an accidental startup.
4. Disconnect the electrical connections to the seal jaw at the plug connections.



- Sealer 1 Flight Bar Jaw Removal

5. Remove the film from in front of jaw, for access to Seal Jaw.
6. Remove the two metric bolts holding the 750 seal jaw in place.



7. Grasp and remove the seal jaw.

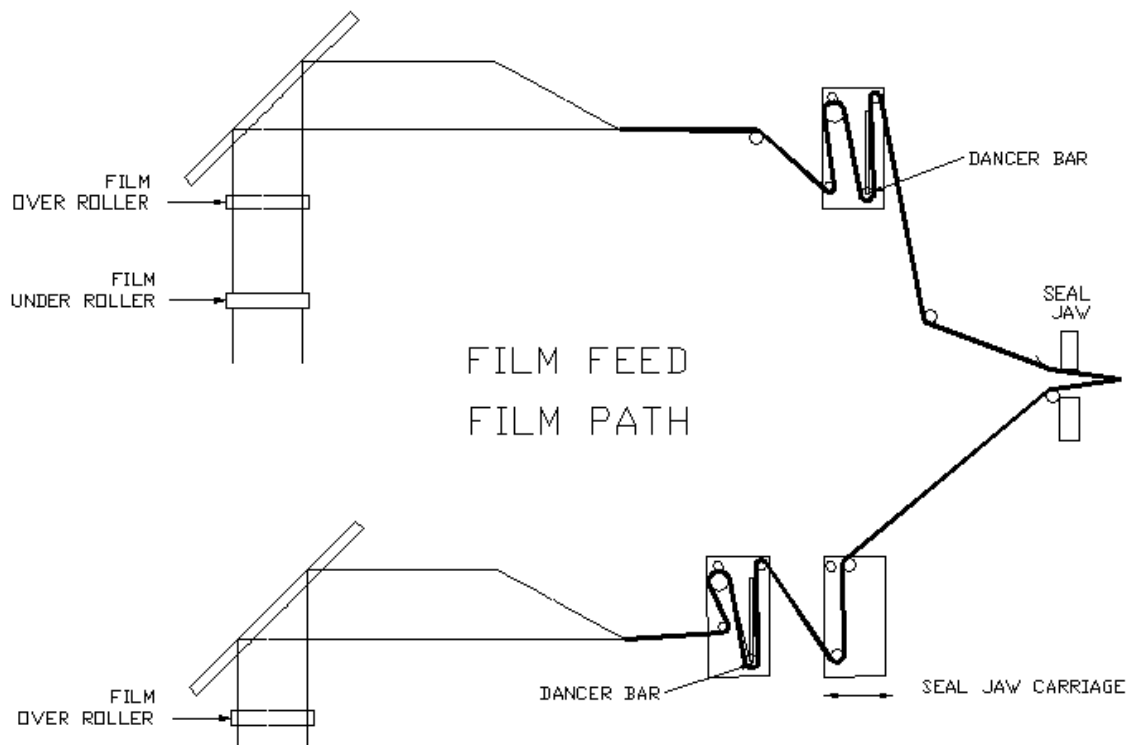


NOTE: JAW WEIGHS 40 LBS!

8. To reinstall seal jaw, perform the above steps in reverse order.

NOTE: Make sure both Heater and Thermocouple wires are secured to prevent damage to wires.

9. After completion of jaw installation, follow film threading diagram and perform manual seal after jaw has reached operating temperature.

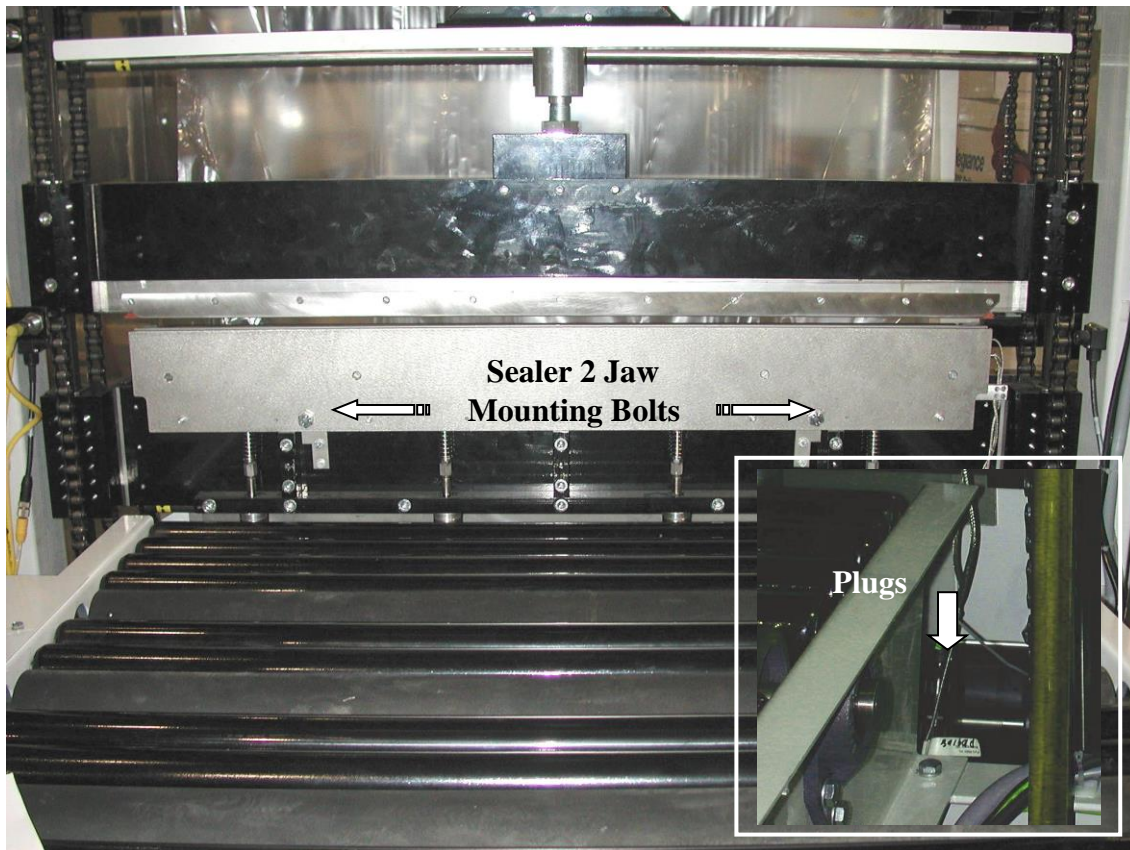


- Film Feed Threading Diagram

6.2 Removing and Replacing Sealer 2 Jaw

Use the following procedure to remove and replace the seal jaw for Sealer 2.

1. Follow shut down procedures and stop bundler, allowing heaters sufficient time to cool down.
2. Cycle the 1000 Seal Jaw into **UP** position for access to mounting hardware.
3. **SHUT OFF** electrical and air power to the machine.
4. **LOCKOUT** and tag the machine to prevent accidental startup.
5. Disconnect the electrical connections to the seal jaw at the plug connections.



Sealer 2 Jaw Removal



Removing and Replacing Seal Jaws (Continued)

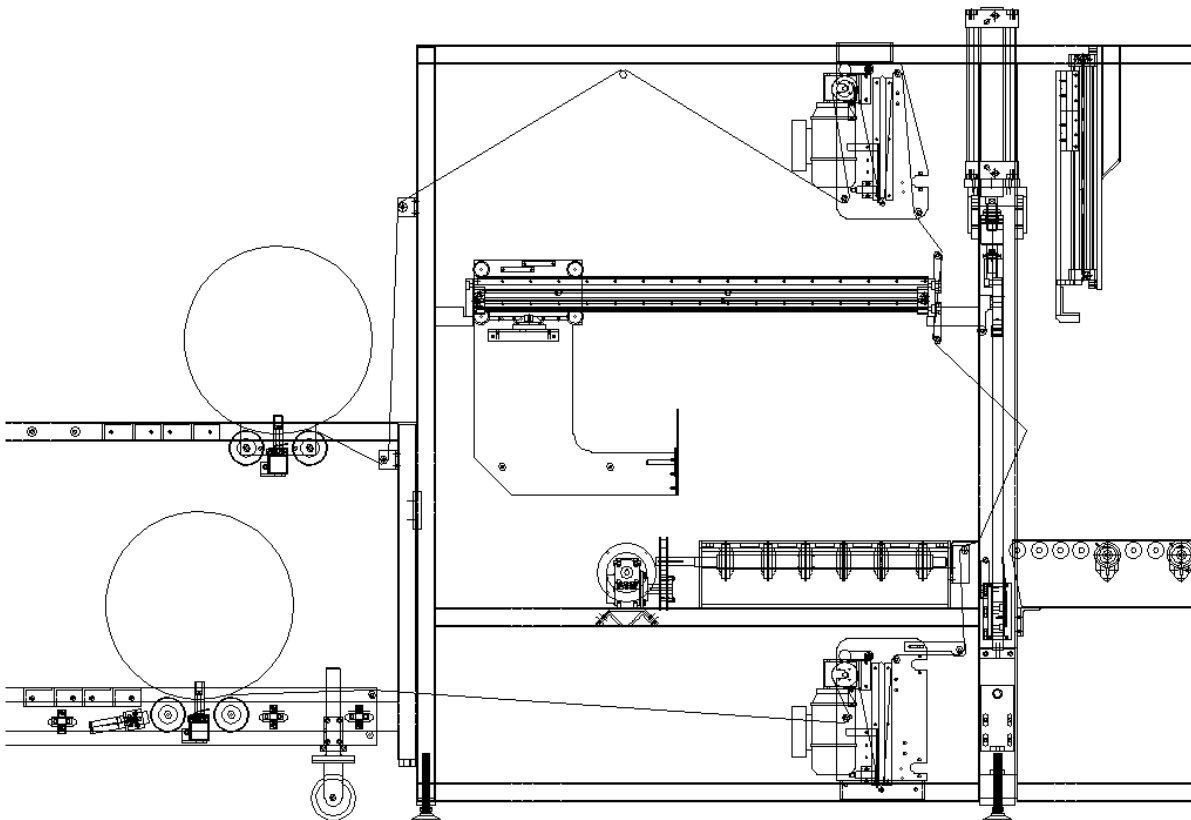
6. Remove the three screws on the seal jaw cover plate.
7. Remove the two metric bolts holding the 1000 seal jaw in place.
8. Grasp and remove the seal jaw.



NOTE: JAW WEIGHS 60 LBS!

9. To reinstall a seal jaw, perform the above steps in reverse order.
10. After completion of jaw installation, follow film threading diagram and perform manual seal after jaw has reached operating temperature.

NOTE: Make sure both Heater and Thermocouple wires are secured to prevent damage to wires.



- Film Feed Threading Diagram

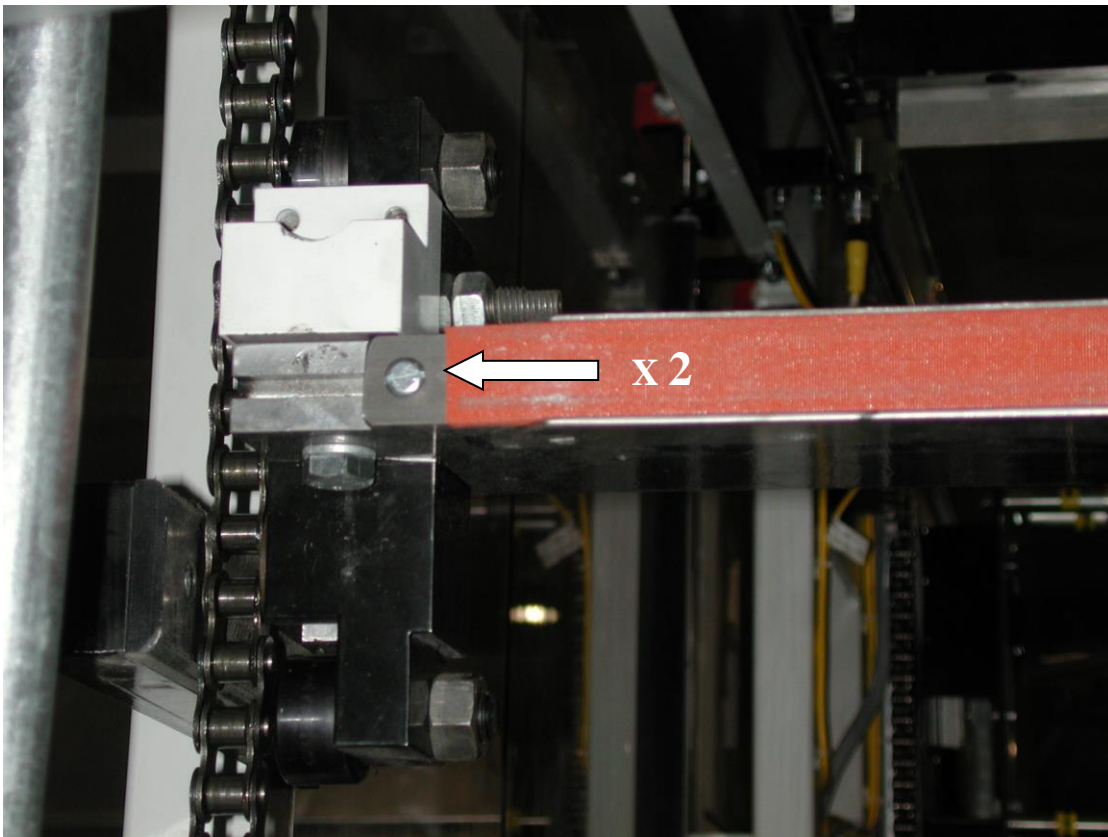
6.3 Removing and Replacing Anvils

6.3.1 Flight Bar Anvil Removal (4)

Use the following procedure to remove and replace the anvil (s) on Flight Bar.

Access to Flight Bar Anvils is best done from inlet side or upstream side of conveyor.

1. Follow shut down procedures and stop bundler, allowing heaters sufficient time to cool down.
2. **SHUT OFF** electrical and air power to the machine.
3. **LOCKOUT** and tag the machine to prevent accidental startup.
4. Rotate (by hand) Flight Bar chain to bring Anvil into position for removal.

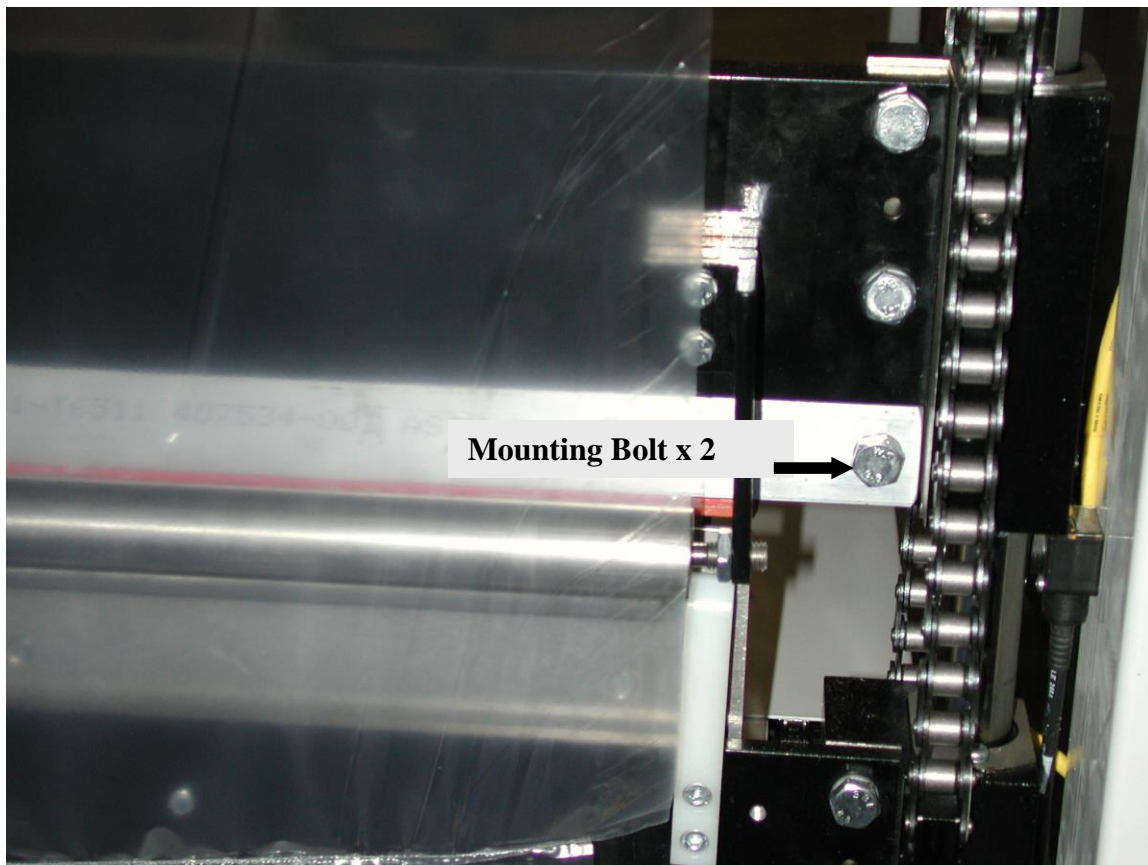


- Flight Bar Anvil Removal

5. Remove two (2) machine screws holding ANVIL to Flight Bar, replace with spare ANVIL
6. Repeat Steps 4 and 5 to remove remainder of Flight Bar Anvils (4).

6.3.2 Sealer 2 Anvil Removal

1. Follow shut down procedures and stop bundler, allowing heaters sufficient time to cool down.
2. **SHUT OFF** electrical and air power to the machine.
3. **LOCKOUT** and tag the machine to prevent accidental startup.

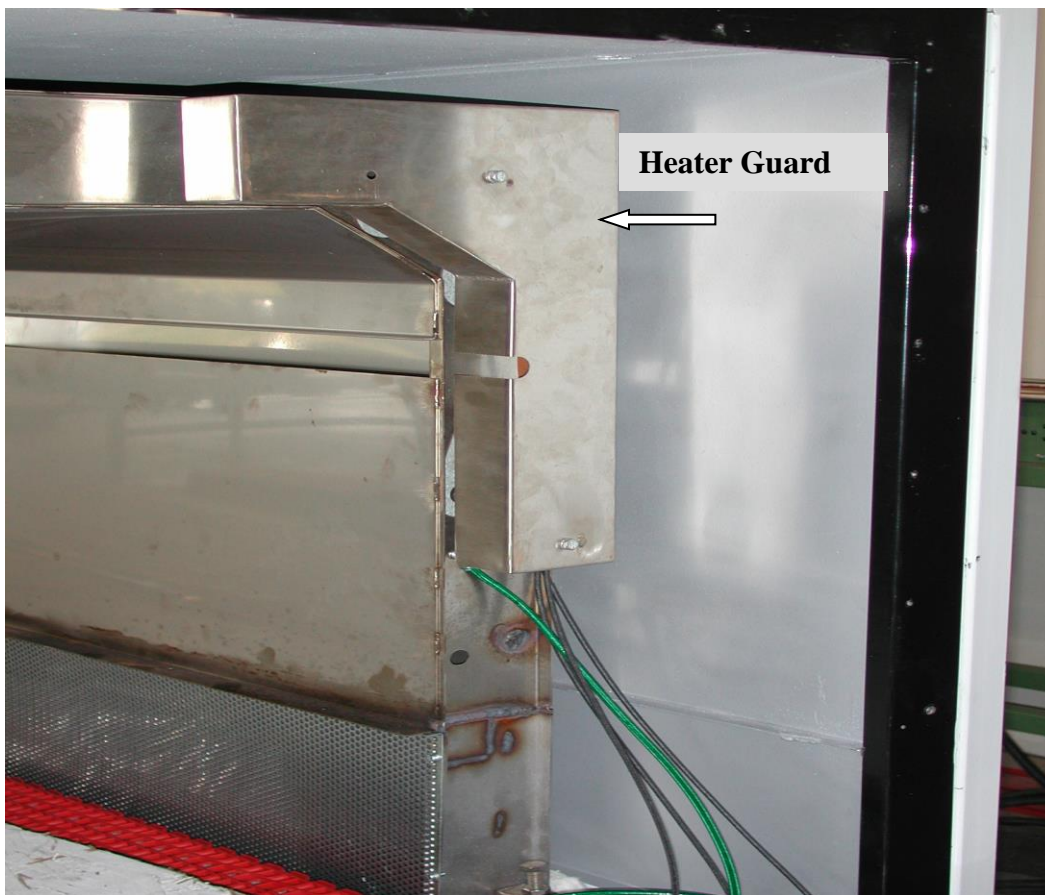


- Sealer 2 Anvil Removal
4. Support Anvil and remove two (2) bolts holding anvil at both ends, replace with spare anvil.
 5. To reinstall, perform the above steps in reverse order.
 6. After completion of anvil installation, follow film threading diagram and perform manual seal, once heaters are up to temperature.

6.4 Removing and Replacing Shrink Tunnel Heater Elements

Use the following procedure to remove and replace the Heater Elements.

1. Stop the bundler and turn off the heaters. Allow the heaters a sufficient time to cool.
2. **SHUT OFF** electrical and air power to the machine.
3. **LOCKOUT** and tag the machine to prevent accidental startup.
4. Remove external sheet metal from both ends of shrink tunnel.
5. Remove two (2) bolts holding heater guards covering ends of heaters.



- Shrink Tunnel Heater Guard

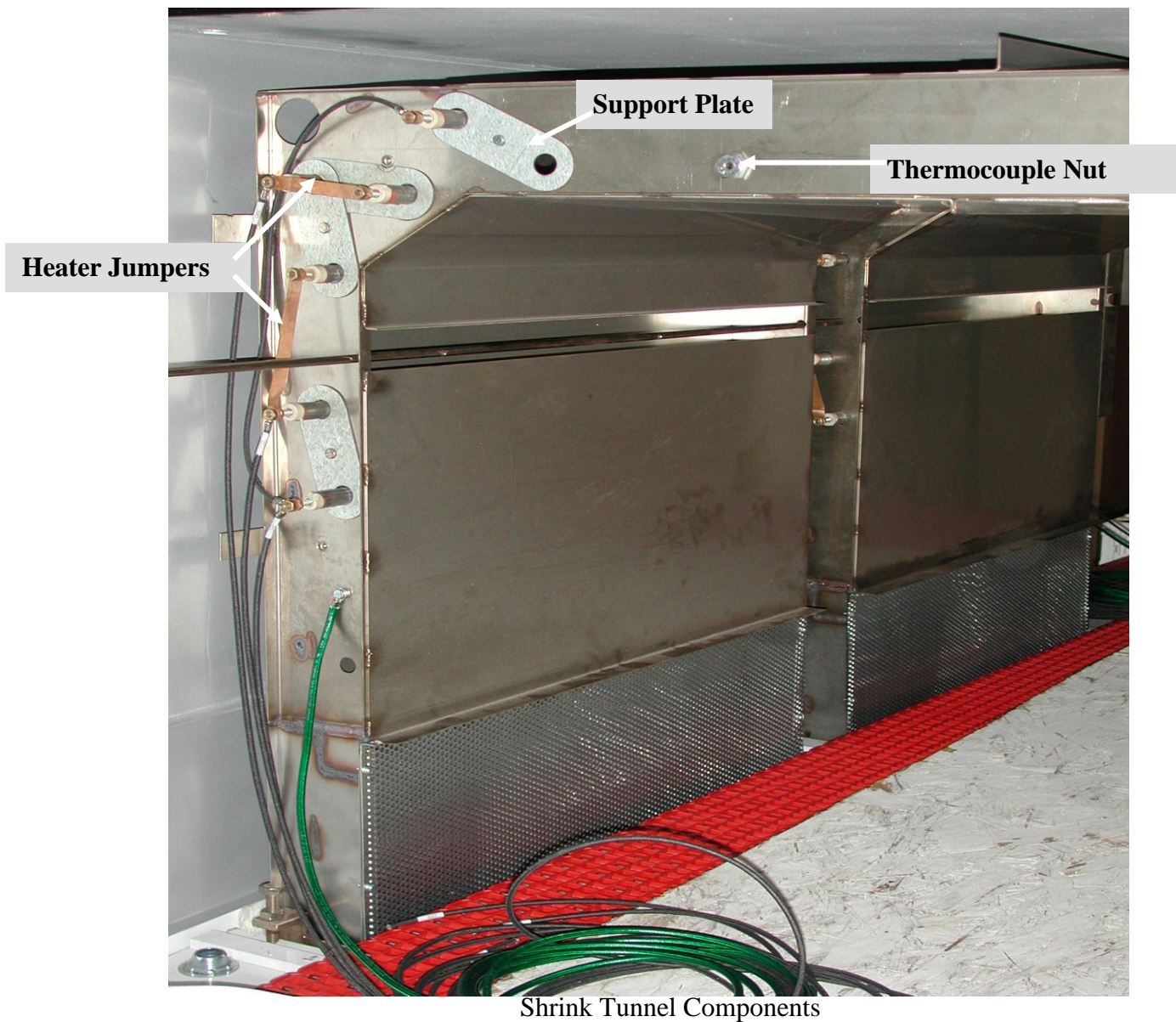
Removing and Replacing Shrink Tunnel Heaters (Continued)

6. Mark wires and disconnect from heaters at both ends.



7. Disconnect heater jumper plates and heater support plates.
8. Remove heaters.
9. Assemble in reverse order.

NOTE: Wires must be disconnected from both ends of tunnels in order to remove Heater Elements



NOTES: