

# FULLY AUTOMATIC STRAPPING MACHINE

MODEL 150

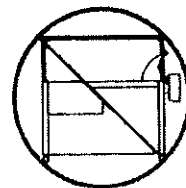
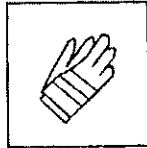


Operation Manual

## SAFETY INSTRUCTIONS

Read these safety instructions before operating or servicing your strapping machine.

1. Before operating the machine, please fit overvoltage and undervoltage protection to the machine.
2. Wear eye or face, and hand protection. Do not wear loose clothing.
3. Keep hands or other parts of the body out of the strap chute area during operation.
4. The temperature of the heater plate is very high. Do not touch.
5. Do not insert strap while there is not a package on the operation table.
6. Do not replace any safety parts of different specifications.
7. Shut off all electric power after machine operation or servicing machine.
8. Do not use water or steam to clean the machine.
9. Keep this operation manual at your strapping machine. Refer to it often.



# **SAFETY INFORMATION**

*Before attempting to service or use this machine carefully read this instruction manual.*

## **RISK ASSESSMENT**

This machinery has moving parts that may cause severe injury

- Do not remove guards
- Operate machinery only in accordance with instructions provided
- Do not operate machinery if you are unfamiliar with the safe operating instructions

This machinery may cause manual handling injury when being moved or transported

- Use mechanical aid to lift or move the machine

1. DO NOT replace any safety parts of different specifications.
2. Read the operating instructions and all of the signs on machine carefully.
3. Wear eye or face, and hand protection. Do not wear loose clothing.
4. Keep hands or other parts of the body away from the machine during operation.
5. Do not touch any hot areas.
6. Do not use water or steam near the machine or to clean machine.
7. Shut off all electric power after machine operation or servicing machine.
8. This machine has moving parts that may cause injury if not used in accordance with safe operating procedures. You must read the instruction manual and ensure you understand the operating procedures BEFORE attempting to start the machine.
9. Keep the instruction manual available at all times and ensure that your operators are fully familiar with the machine and its controls and methods of operations. The machine will then give you long and trouble free service in safety.
10. All technical queries or routine service must be referred to AAA Packaging. No liability is accepted for personal injury or consequential loss suffered as a result of unauthorized repairs/alterations, or failure to use the machine strictly in accordance with these instructions.

## **WARRANTY**

**For the warranty to be effective the machine must be serviced by a qualified technician at the recommended monthly intervals and recorded. Get Packed recommend you take up a service contract. The unit is then serviced by technicians that know the machines and we offer reduced rates compared to breakdown rates.**

- 1.0 It is agreed that the product purchased is subject to the following LIMITED WARRANTY and no other.
- 1.1 Get Packed warrant products to be free from defects in material or workmanship for a period of six months from date of shipment.
- 1.2 This warranty shall not cover failure or defective operation caused by operation in excess of recommended capacities, misuse, negligence or accident, or alteration or repair not authorised by Get Packed.
2. DISCLAIMER OF IMPLIED WARRANTY OF MERCHANTABILITY
- 2.1 Get Packed and the buyer agree that the implied warranty or merchantability is excluded from this transaction and shall not apply to the goods involved in this transaction.
3. DISCLAIMER OF IMPLIED WARRANTY OF FITNESS FOR PARTICULAR PURPOSE.
- 3.1 Get Packed and the buyer agree that the implied warranty of fitness for particular purpose is excluded from this transaction and shall not apply to the goods involved in this transaction.

# Specification

NO	DESCRIPTION		REMARKS
1-1	DIMENSION	LENGTH	1450mm
		WIDTH	640mm
		HEIGHT	1500mm
1-2	SEALING METHOD		HEAT SEALED
1-3	SPEED		29straps/m(60Hz)
			26straps/m(50Hz)
1-4	STRAP WIDTH		8-15mm
1-5	MACHINE TENSION		10-70kg
1-6	NET WEIGHT		230kg
1-7	ACOUSTIC NOISE		70dB(A)

## Operating Requirements

NO	DESCRIPTION	REMARKS
2-1	AMBIENT TEMPERATURE	5~40°C
2-2	RELATIVE HUMIDITY	35~85%RH
2-3	INSTALLATION ALTITUDE	1000M(MAX)
2-4	TRANSPORT/STORAGE TEMPERATURE	-25~55°/70°C

## Power Supply

Voltage:230V/120V

Frequency:50Hz/60Hz

Electric Supply tolerance:  $\pm 10\%$

Power consumption:1.0KW

# INDEX

PREFACE	1
ASSEMBLY OF ARCH AND MACHINE	2~3
PREPARATION BEFORE MACHINE SETUP & OPERATION	4~5
STRUCTURE AND PERFORMANCE ON UNITS	6
INSTALLATION OF P.P. STRAP & SETTING STRAP PROCESS	7~8
CONTROL PANEL	9
TENSION ADJUSTMENT	10
ELECTRICAL CONTROL BOX AND PLC	11
TEMPERATURE ADJUSTMENT	12~13
ADJUST FEEDING AND FEED-BACK ROOLER TENSION	14
THE STRAPS TO ADJUST P.P.BAND AMOUNT IN THE POOL BOX	15
LIMIT SWITCH ADJUSTMENT	16
EASY TO GUIDE AGAINST TROUBLES	17~18
PROPER P.P. STRAP ALIGNMENT	19
ELECTRICAL SCHEMATIC	20~25
PARTS LIST	27~63

## PREFACE

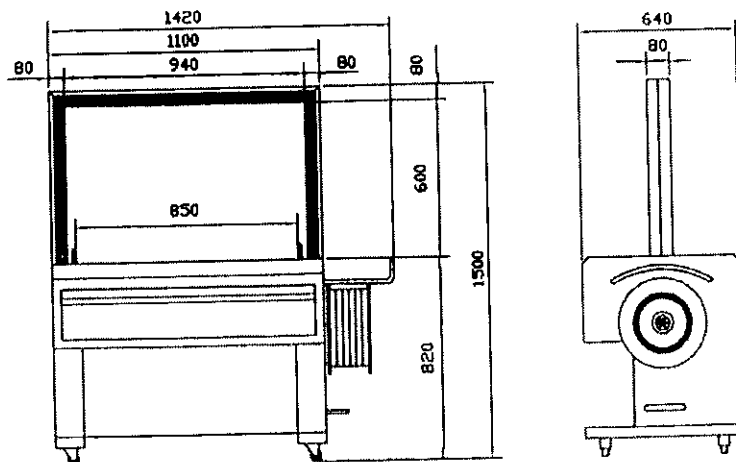
Thank you for purchasing our new automatic strapping machine. This machine has been designed by our engineering staffs to provide you with the newest in modern strapping system technology. The system with its strong yet light-weight construction has been designed to minimize maintenance and give you trouble-free operation for many years when operated properly in accordance with the instructions in this manual. We ask you to read the instructions in this manual carefully and ask you to regularly keep your machine clean and follow the maintenance instructions here-in to guarantee and prolong the life of the machine. Please check to see that all of the following accessories supplied with your machine.

### STANDARD ACCESSARIES

DESCRIPTION	Q'TY
INSTRUCTION MANUL PARTS-LIST	1 VOLUME
TOOLS	1 SET
ARCH FLAP SPRING	3 PCS
TENSION JAW SPRING	1 PC
BRAKE TENSION ARM SPRING	1 PC
UPPER ADJUST WEIGHT SPRING	1 PC
POOL SPRING	1 PC
SCREWS,NUTS,WASHERS,RINGS,ETC	

### \*Optional accessories

Foot Switch



## ASSEMBLY OF ARCH AND MACHINE

Arch and machine are packed separately. (refer to the following drawing)  
Please set the arch unit on the arch set of machine and use the tool (in the tool box) to lock the screws. It is not necessary to take off the arch cover.

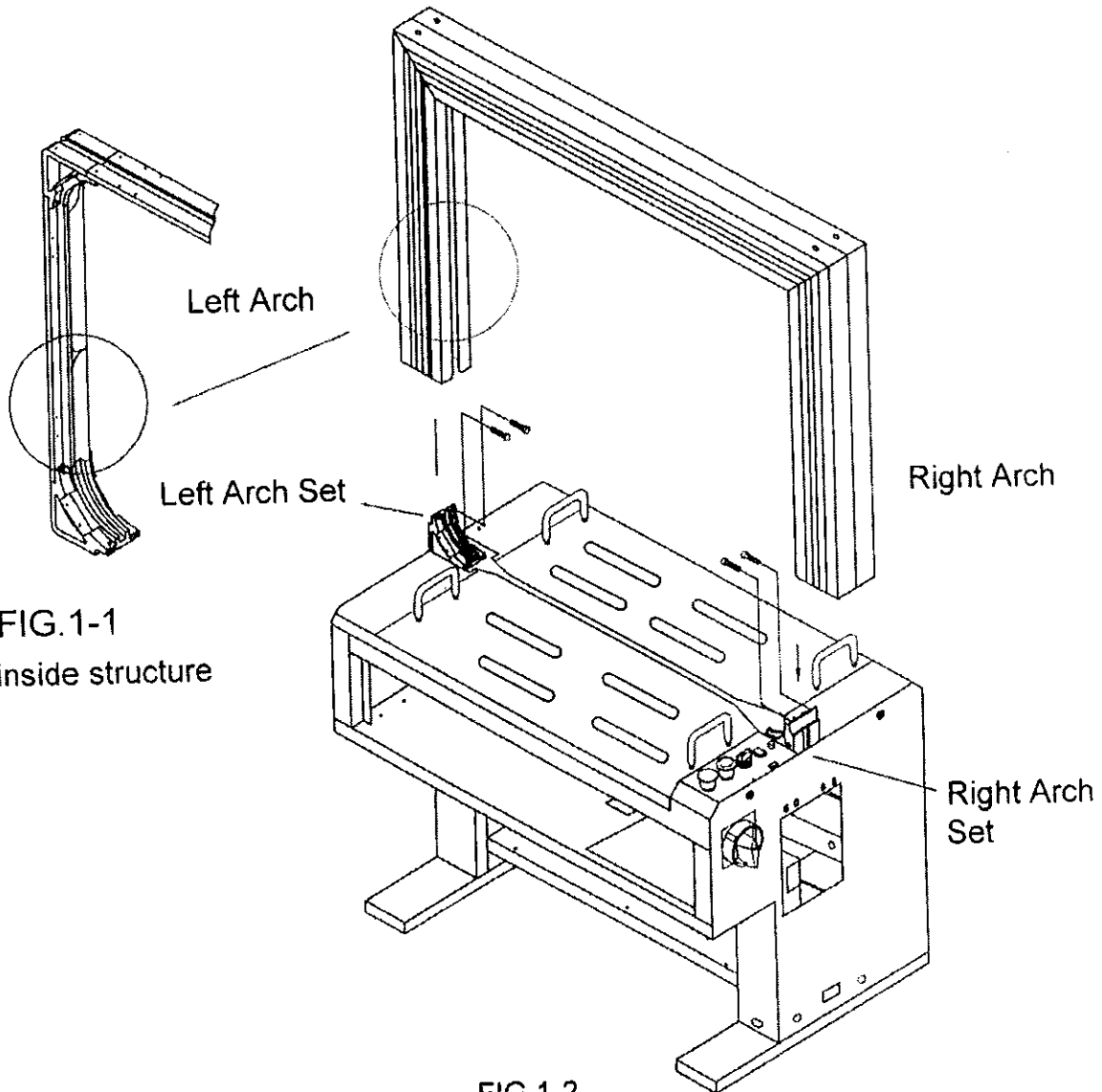


FIG.1-1  
Arch inside structure

FIG.1-2



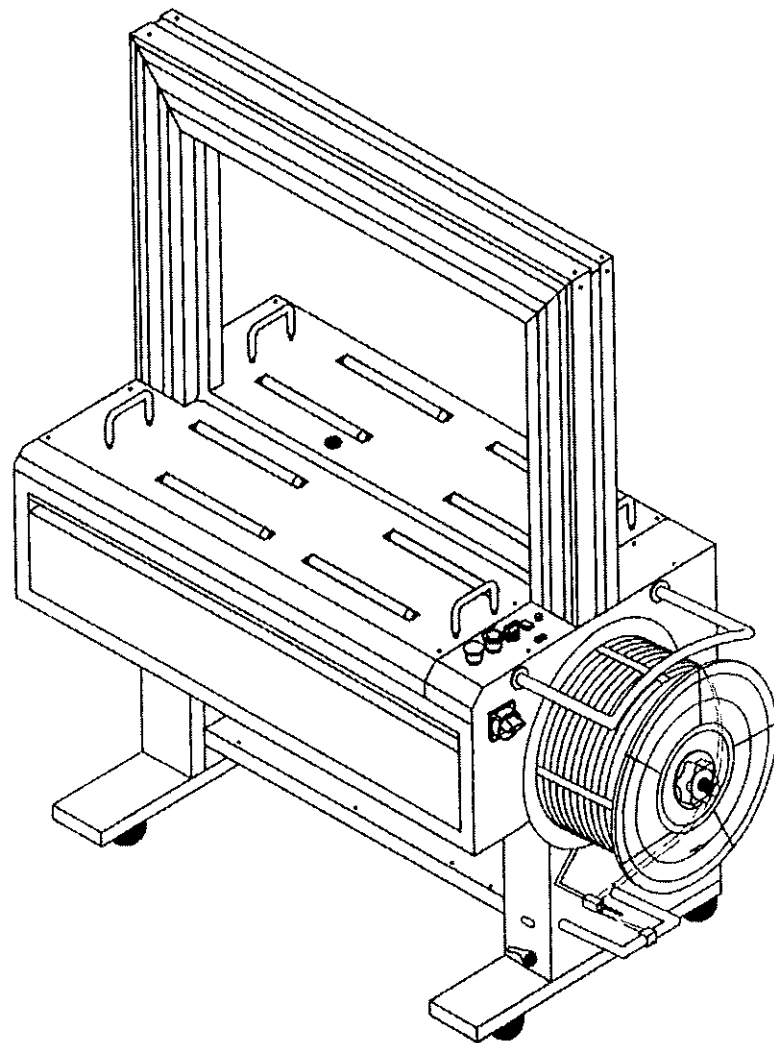
### WARNING

To Install the arch on arch set.

3-1 Please refer to the fig 1-1 (Arch inside structure). To distinguish between the left and right arch. Then install arch unit on the arch set with screws. (refer to fig1-2) Be careful not to install the wrong direction, otherwise, you will damage the arch flap and arch spring.



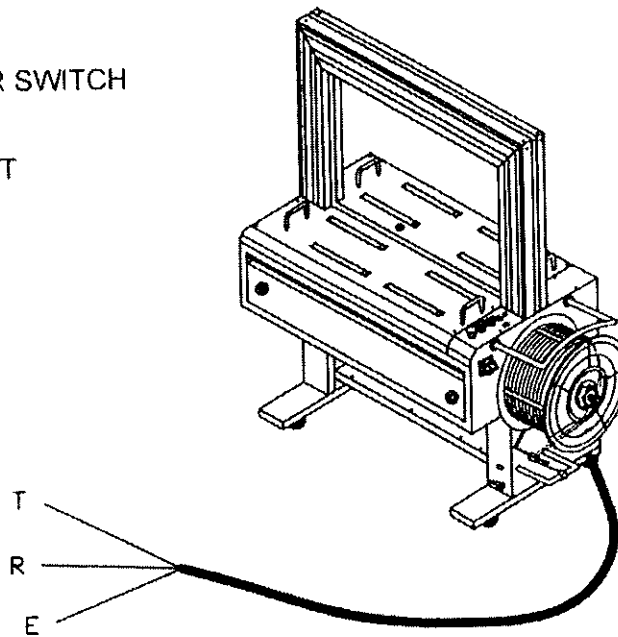
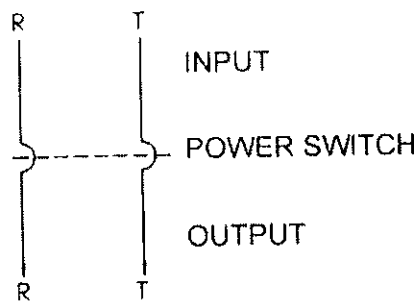
- 3-2 To set ARCH unit in machine
- 3-3 Locking screws. (4 pcs)



## PREPARATION BEFORE MACHINE SETUP & OPERATION

### (A) VOLTAGE

1. Please make sure the power supplied the machine matches the machine voltage rating.
2. Please refer to this page when setting up the machine for 1-Phase input.



### (B) PLEASE NOTICE THE FOLLOWING CONDITIONS BEFORE SUPPLYING POWER.

1. P.P. strap should not be inserted into the bandway prior to turning on the power switch for the first time.  
(Please take note of the motor rotation to assure that the electrical power supply is connected properly.)

### (C) RECOMMENDED SUPPLY CABLE

the power switch for the first time.

# PREPARATION BEFORE MACHINE SETUP & OPERATION

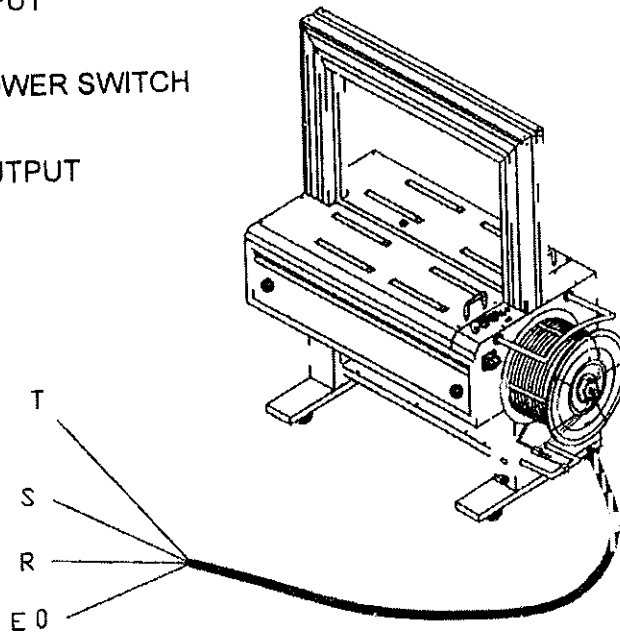
## (A) VOLTAGE

1. Please make sure the power supplied the machine matches the machine voltage rating.
2. Please refer to this page when setting up the machine for 3-Phase input.

R    S    T  
|    |    |  
INPUT

POWER SWITCH

OUTPUT  
V<sub>R</sub>    V<sub>S</sub>    V<sub>T</sub>



## (B) PLEASE NOTICE THE FOLLOWING CONDITIONS BEFORE SUPPLYING POWER.

1. P.P. strap should not be inserted into the bandway prior to turning on the power switch for the first time.  
(Please take note of the motor rotation to assure that the electrical power supply is connected properly.)
2. If motor rotation is reversed please check and choose one of the wiring configurations below to correct it.

R    S    T                    R    T    S  
|    |    |                    |    |    |

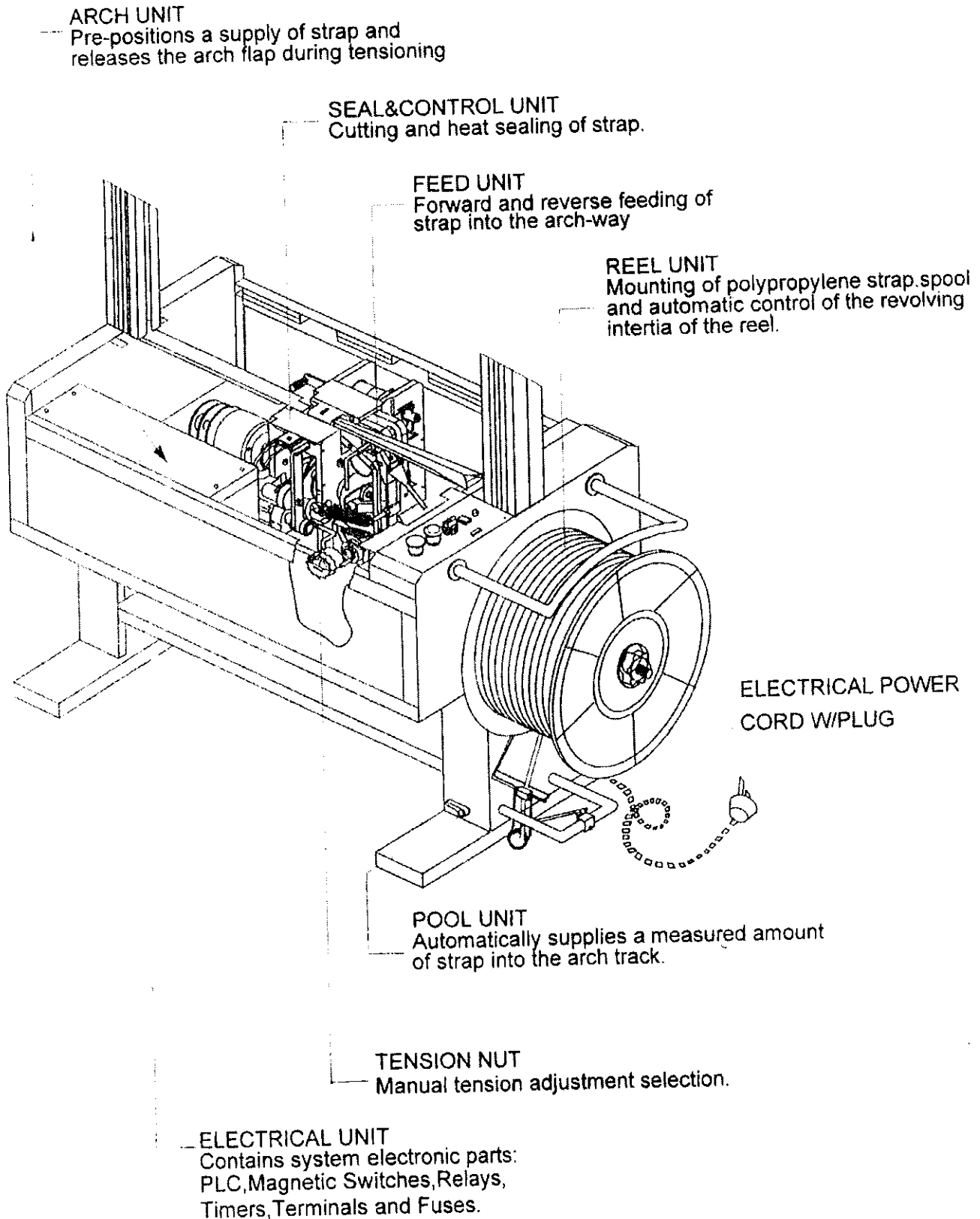


V<sub>R</sub>    V<sub>S</sub>    V<sub>T</sub>                    V<sub>R</sub>    V<sub>T</sub>    V<sub>S</sub>

## (C) RECOMMENDED SUPPLY CABLE

the power switch for the first time.

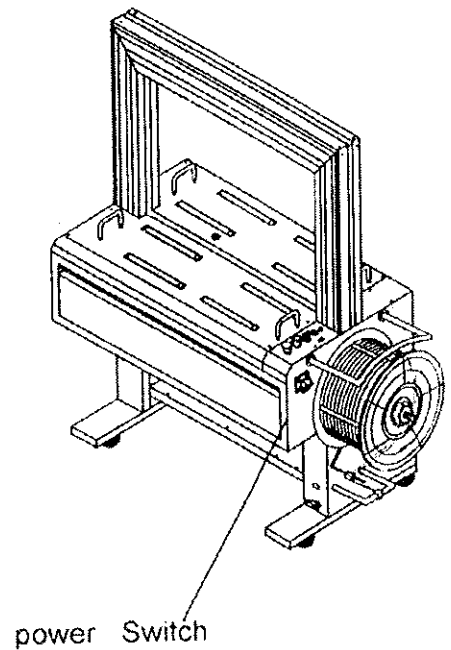
## STRUCTURE AND PERFORMANCE OF UNITS.



## INSTALLATION OF P.P BAND AND SETTING STRAP PROCESS

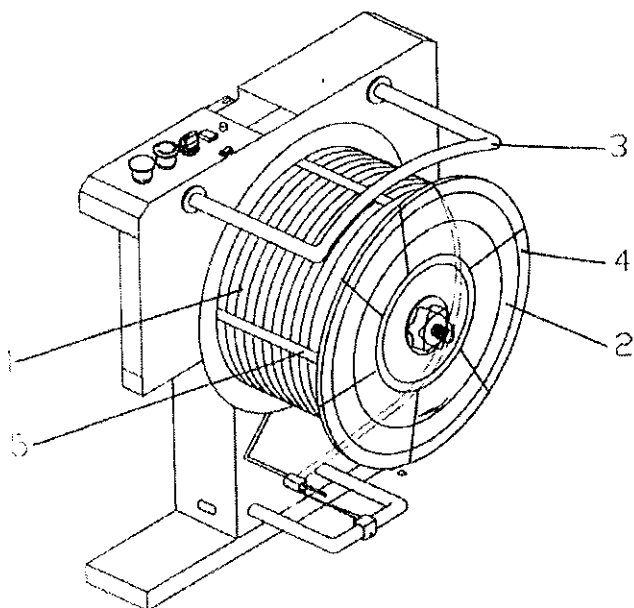
### WARNING!

Please turn off the power switch before inserting the P.P.strap.And then open the right of front door and install the p.p. strap according to the regular ways.



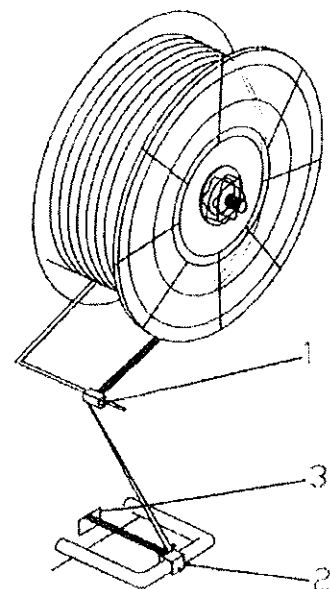
### SETTING STRAP 1

Please take off the packing paper of P.P.strap and refer to the following drawing for installing it on the dispenser (4).Then please tight the dispenser nut (2)and cut off thr packing string(5).



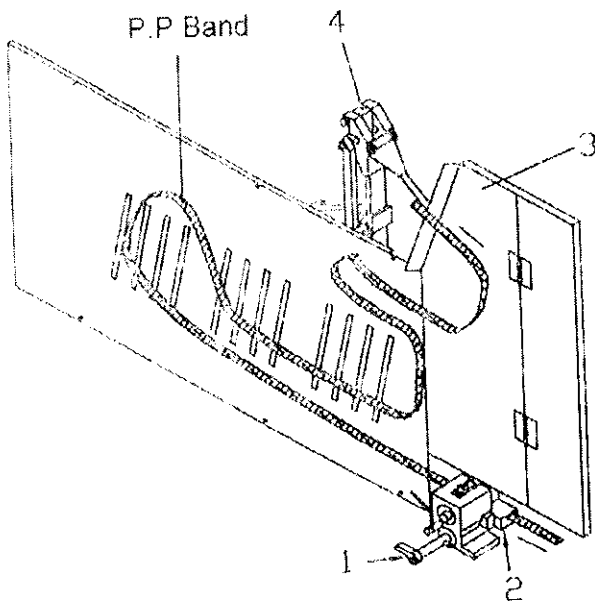
### SETTING STRAP 2

Please install the P.P.strap through the brake roller (1)and then referring to the following draft for installing the P.P. strap through the free roller(2)&the entrance(3).



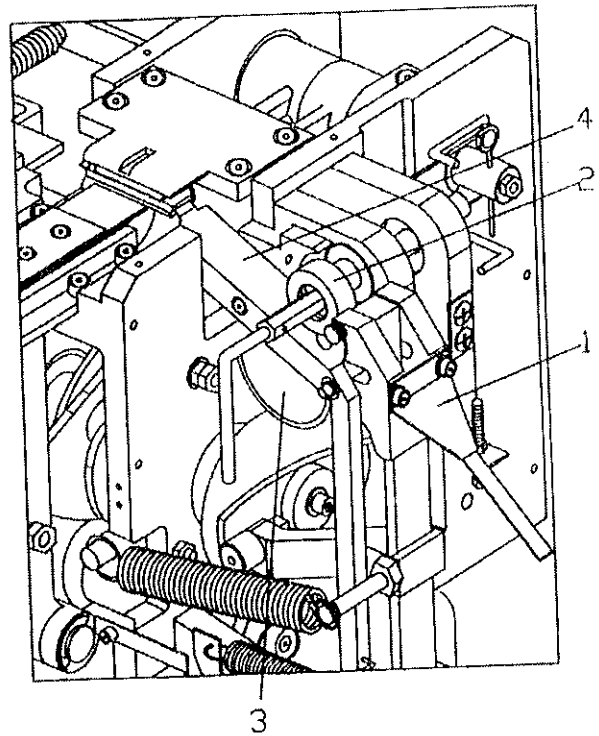
## SETTING STRAP 3

To press the bottom of Pool Box (1), route the P.P. strap along the slot (2) into the Pool Box, open the door of Pool Box (3) for pulling into the p.p. strap about 500-800 M/M and then insert it into the Tension Arm (4).



## SETTING STRAP 4

To insert the P.P. strap into Tension Arm (1), make sure the P.P. strap is through the Feed Upper Roller (2) & (3), let the strap stays inside Feed Shooter temporarily. Close the door of Pool Box and the front door, then turn on the power switch and press the Feed Button (Please refer to the Operation Board Unit).



## CONTROL PANEL

### (1) START SWITCH

Use the START SWITCH to begin a strapping cycle.

### (2) STOP SWITCH(Emergency)

The STOP SWITCH immediately shuts down the system and can be used as an Emergency SWITCH.

### (3) FORWARD Jog Switch

The FORWARD jog switch provides manual forward atrap feed.

### (4) REVERSE Jog Switch

The REVERSE jog switch provides manual reverse strap feed.

### (5) Power Light

### (6) AUTO/MANUAL SWITCH

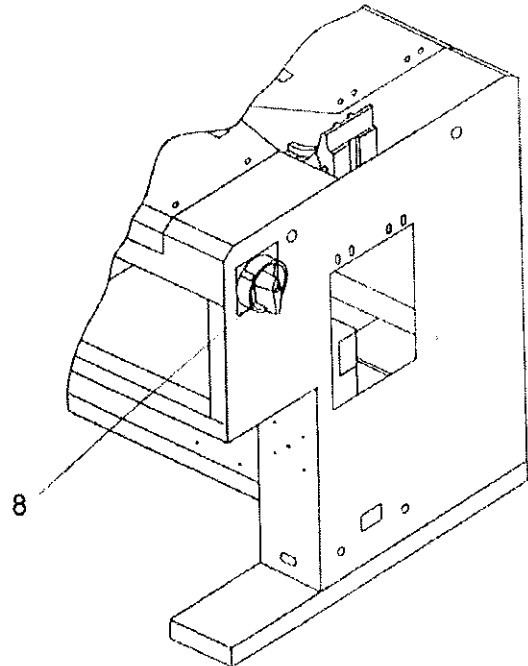
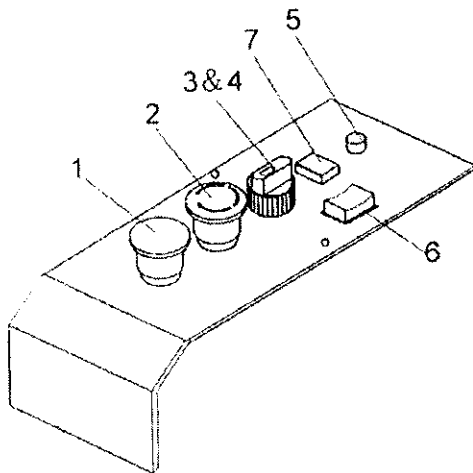
In auto model the table switch and the automatic table top switch are active. Automatic reset of the strapping cycle is also available.

### (7) RESET SWITCH

During any strap feeding related problem during operation the user can arbitrarily use the RESET SWITCH to cut P.P.strap and complete a reset action. When the Auto/Manual Switch is Auto mode this funtion is done automatically.

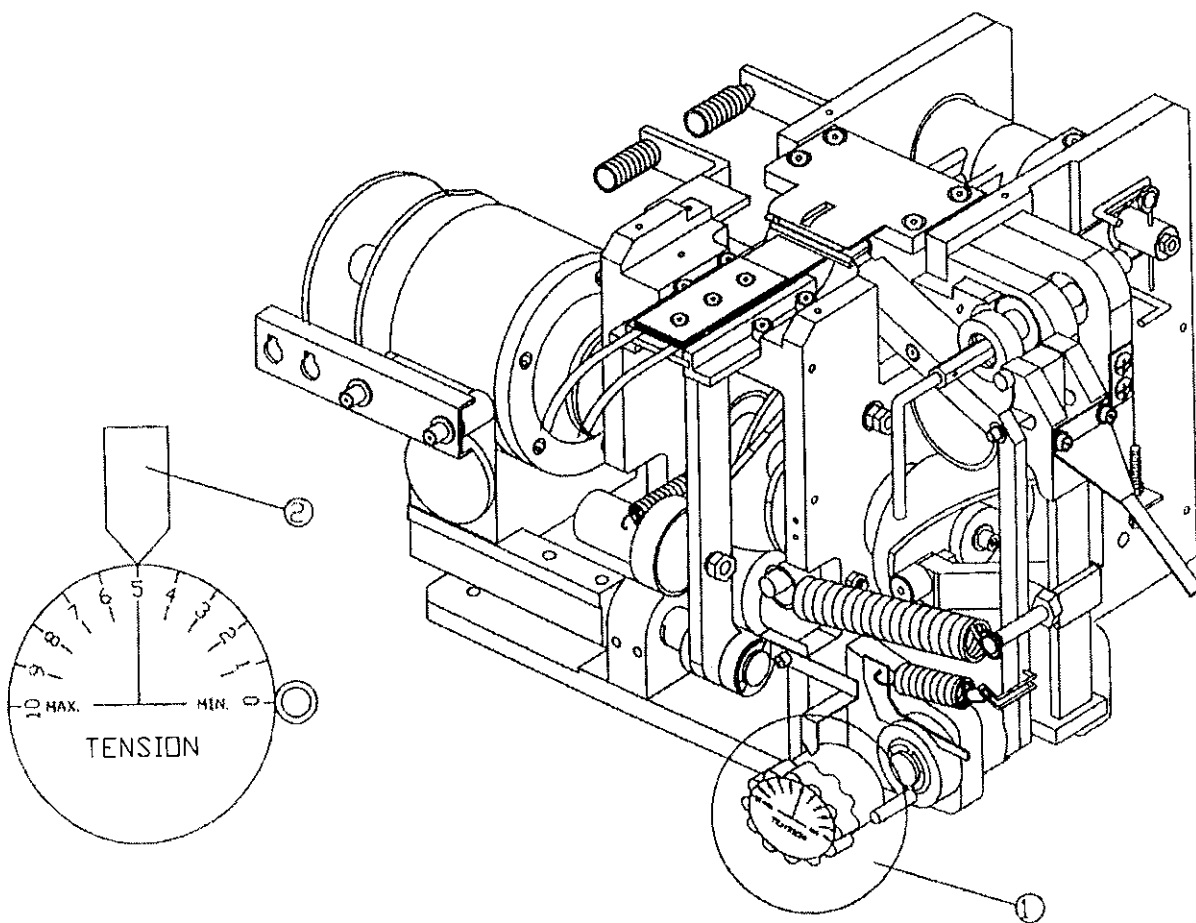
### (8) MAIN POWER SWITCH

This is the main power switch on the machine. Electrical power supply to the machine from the power source is controlled through this switch.



## TENSION ADJUSTMENT

When making tension adjustments first open the right front door of the cabinet. Next gently pull on the Tension Selection Dial (1). Turn the dial to the left or right to your desired tension strength. Gently push the dial in to secure your setting. (NOTE: For first time use try setting No. 5 on the dial and then make necessary adjustments in strength in accordance with your packing requirements.)

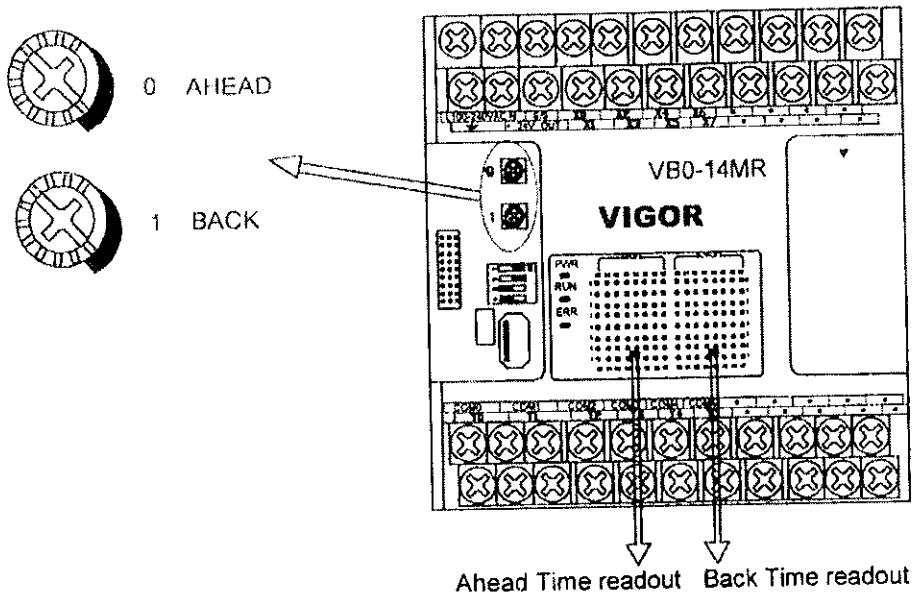
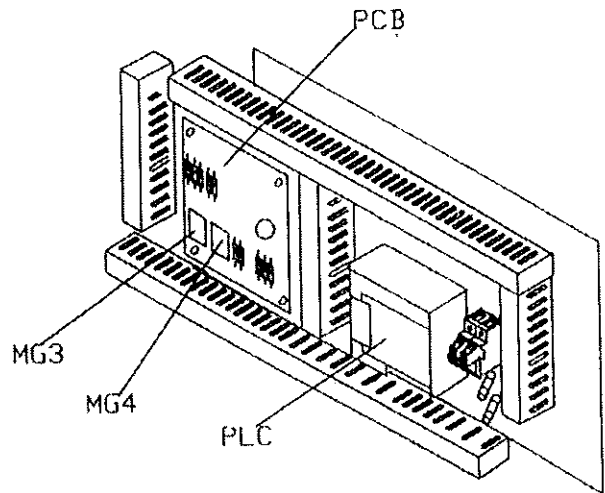




# CONTROL BOX AND PLC

MG3: To control the timing motor (M-1)  
if the power supply of machine is  
220v/1/2HP, the thermal relay be  
set at 5.7A.

MG4: To control the timing motor (M-2)  
if the power supply of machine is  
220v/1/3HP, the thermal relay be  
set at 4.2A.



## CONFIRM:

Knob "0" is used to adjust ahead time, clockwise increase time. Range (0.9sec-1.53sec)  
Knob "1" is used to adjust back time, clockwise increase time, range (0.4sec-0.8sec)

(A) As the power switch of PLC be turned on, the lamp of POWER and RUN will be lighting.

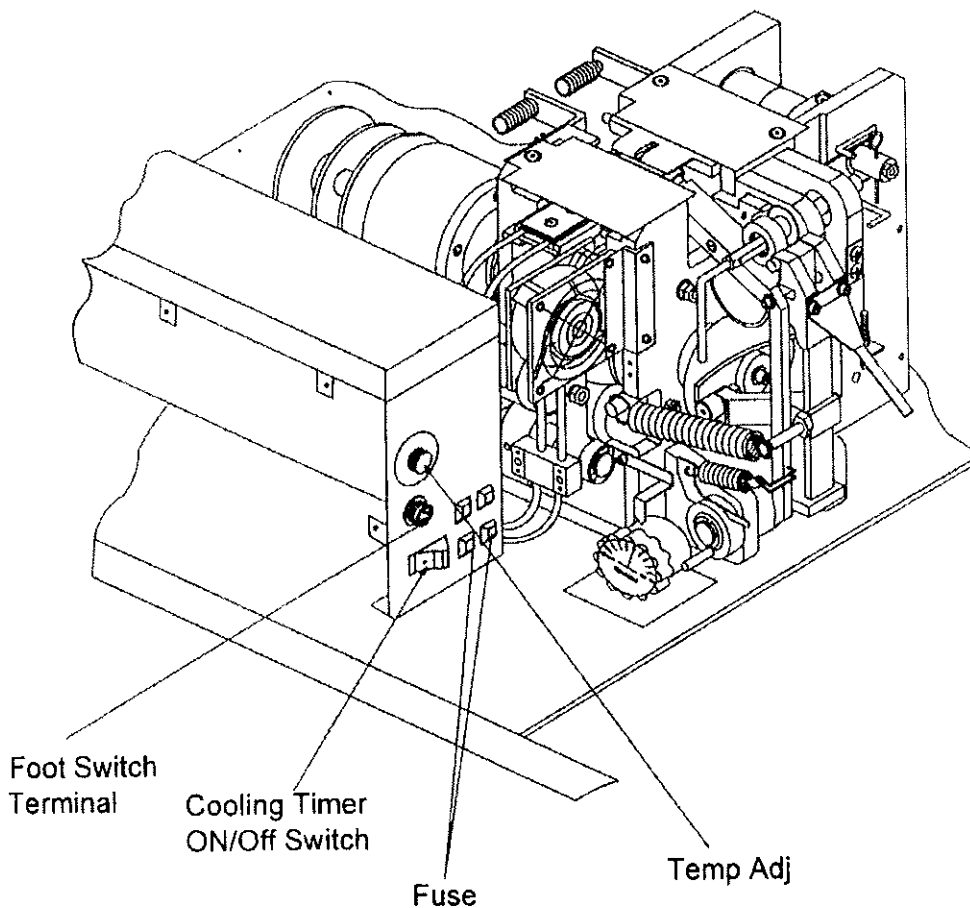
(B) As the lamp of ERR is flashing, it means the programmer irregular.

## TEMPERATURE ADJUSTMENT

Please allow approximately 2 minutes for the heater blade to reach the preset temperature after initial power "ON" start -up.

The factory setting on the heater is between 3-4 suitable for most climate environments.

In certain areas here the ambient working environment temperature is extreme, adjustment of the Temperature Adjustment Dial may be necessary.



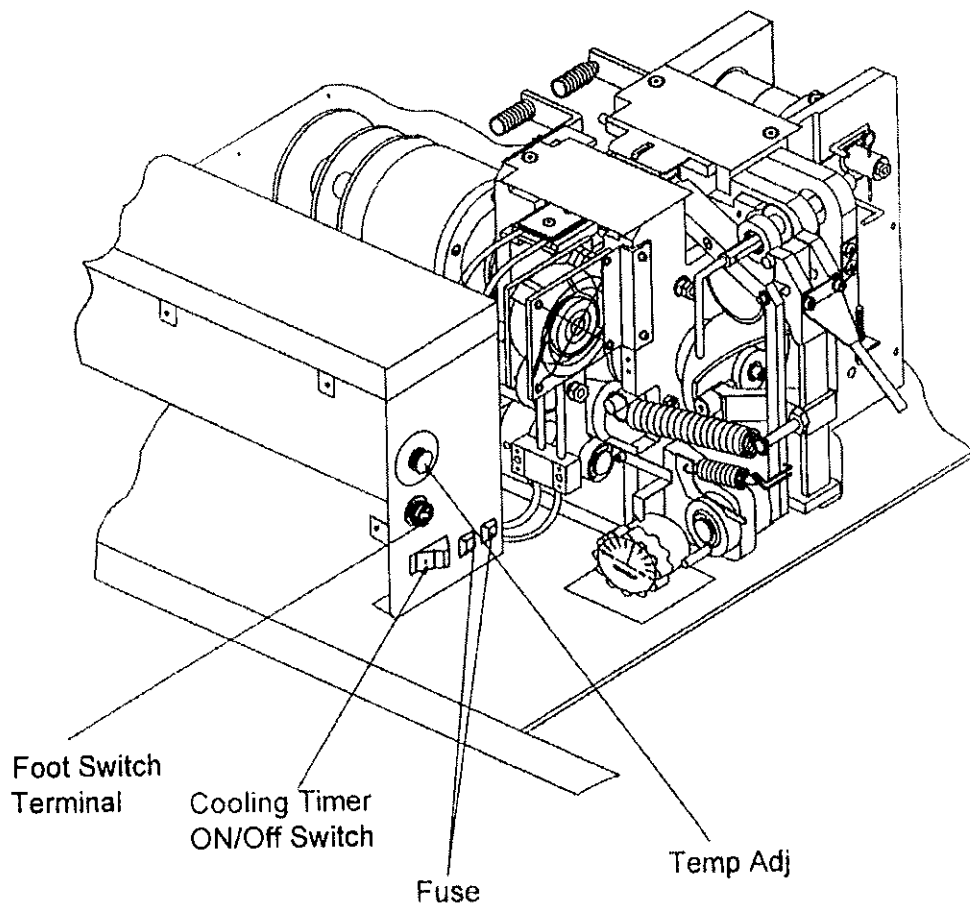
(FOR 1-Ph)

## TEMPERATURE ADJUSTMENT

Please allow approximately 2 minutes for the heater blade to reach the preset temperature after initial power "ON" start -up.

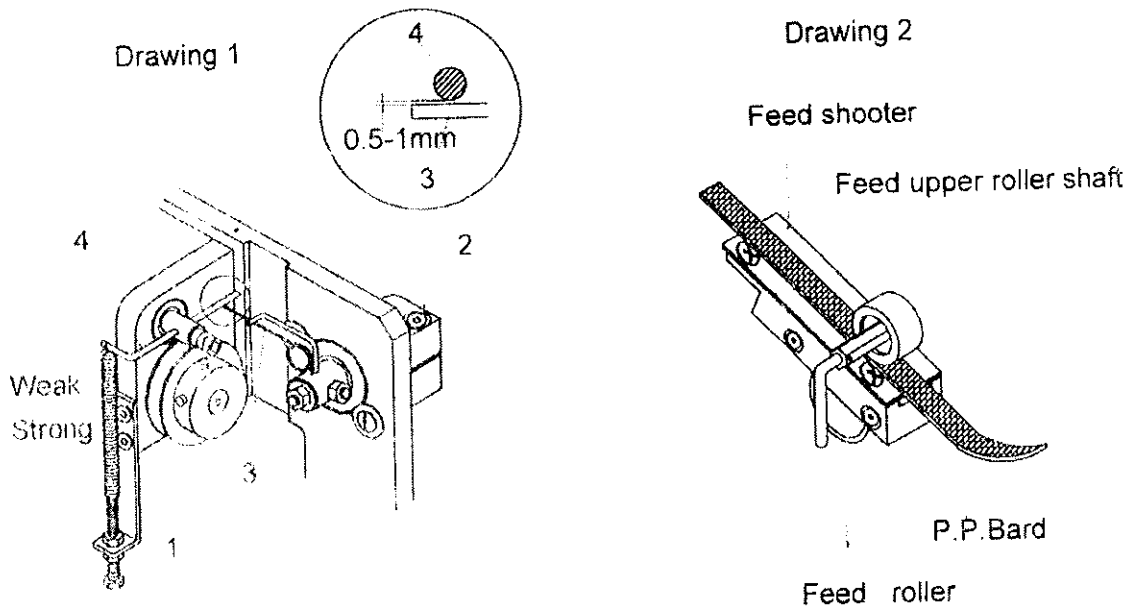
The factory setting on the heater is between 3-4 suitable for most climate environments.

In certain areas here the ambient working environment temperature is extreme, adjustment of the Temperature Adjustment Dial may be necessary.



(FOR 3-Ph)

## ADJUST FEEDING AND FEED-BACK ROLLER TENSION



In normal occasion, machines before leaving the factory, it's feeding tension and feed-back tension have been adjust to adapt to the P.P. band thickness 0.55-0.75 mm, if the P.P. band thickness is out of 0.55-0.75 mm, Please follow undermentioned steps to make right adjustment.

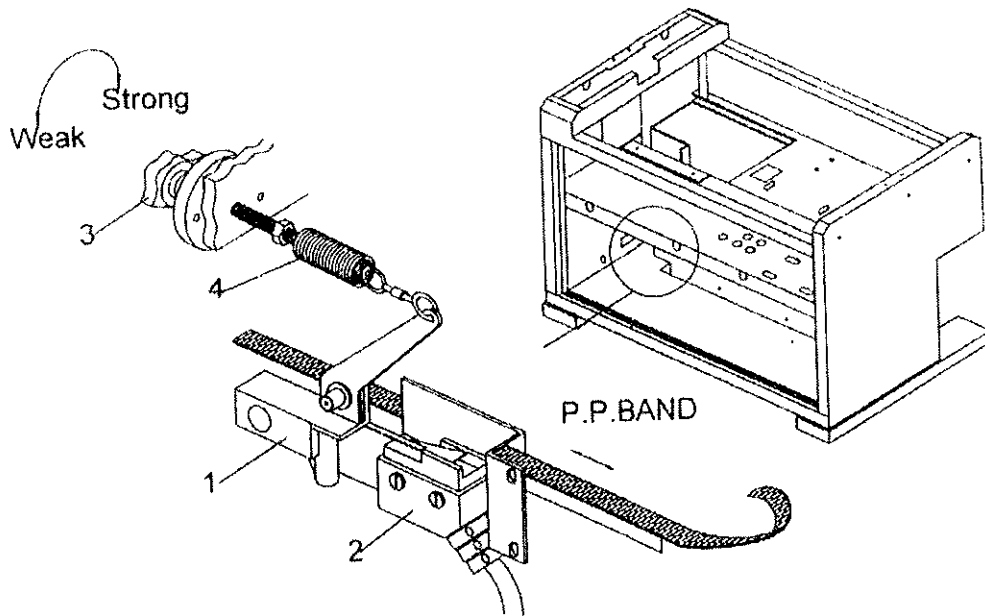
### (1) ADJUST FEEDING ROLLER TENSION

- 1-1 Please loosen the upper and bottom nuts of (1) adjust screw
- 1-2 Adjust the tension to the proper position
- 1-3 Lock tightly the nuts, The nuts goes up, the feeding tension is weak, the nuts goes down, the feeding tension is strong.

### (2) ADJUST FEED-BACK ROLLER TENSION

- 2-1 Loosen 2 pcs of screws (2) SCM-8x35
- 2-2 Feed P.P. band into feed shooter. Please be sure that the P.P. band has through between feed upper roller shaft and feed roller.  
Please refer to drawing 2.
- 2-3 Adjust 0.5-1.0 mm distance between (3) upper roller spring and (4) upper roller weight adjuster. The distance to be adjusted in accordance with the actual thickness of P.P. band.
- 2-4 Lock screws (2) SCM-8x35. Please lock as tightly as possible.

## The Steps to Adjust P.P. Band Amount in the Pool Box



1. The position of adjust unit is in the real and right side of machine. In the other words, it is in the reverse side of pool box.

2. While power switch is "ON", the pool motor starts running to feed the P.P. band to the box.

As soon as P.P. band has enough weight in the pool box to press (1) balance bar and to touch the (2) microswitch detector lever, the balance bar is in parallel with machine bottom. On the contrary, when P.P. band weight in the pool box is not enough, the balance bar leaves away from the microswitch detector lever, pool box motor will start running to feed the band.

3. Machine before leaving the factory, it has been set well to store correct amount of P.P. band in the pool box. On account of different thickness, quality and handle size, it some times requires to adjust amount of P.P. band. If the fact is necessary, please adjust per following instruction: Adjust (3) SHM-6x50 to up side or to down side, the tightness of spring will become strong or weak accordingly.

If the P.P. band amount in the pool box is too little, users can adjust spring will become strong or weak accordingly.

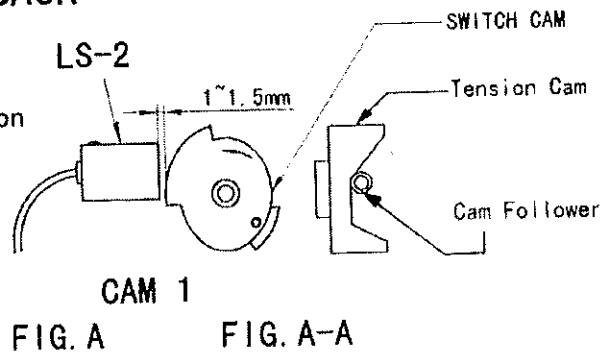
If the P.P. band amount in the pool box is too little, users can adjust spring Upwards (strong). In this way, balance bar can load more amount of P.P. band, or if the P.P. band amount in the pool box is too much, user can adjust springs downwards (weak) to keep balance bar to load little amount of P.P. band, motor will stop running.

## LIMIT SWITCHS ADJUSTMENT

There are two limit switches on the left side of reduction gear, which can make the machine stay at the setting process as the machine is running. When the power supply is too low, the speed of motor will be decreased, which causes the delay at the definite point and make the machine runs unsteadily. Please adjust the distance between following switch and cam for solving the problems mentioned above. The proximity is a kind of metal-sensed switch, which can sense cam between the distance of 0.5-4mm. The red lamp will light when the switch senses the cam, or the lamp keeps "off".

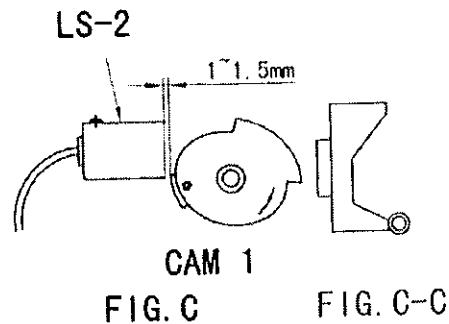
### LS-2 LIMIT SWITCH FOR FEEDBACK

1) As the limit switch, LS-2 senses the cam (the cam follower should be at the definite point of the tension cam) (Please refer to the drawing LS-2 FIG. A-A). Then the user can start the function of feedback.



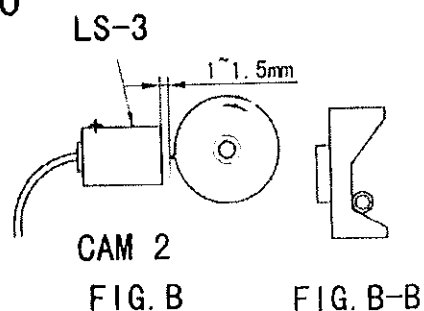
### LS-2 LIMIT SWITCH FOR FEED

1) As the limit switch, LS-2 senses the cam (the cam follower should be at the definite point of tension cam) (Please refer to the drawing LS-2, FIG. C-C). Then the user can start the function of feed.



### LS-3 LIMIT SWITCH FOR RETURN ZERO

1) As the limit switch senses the cam (the cam follower should be at the definite of tension cam) (Please refer to the drawing LS-3, FIG. B-B). Then it is in the condition of return zero. And the switch keeps lighting in this condition.



## EASY TO GUIDE AGAINST TROUBLES

CONDITION (A): THE P.P. STRAP WILL RETURN TO THE TENSION ARM WHEN THE OPERATOR COMPLETE THE PROCESS OF SETTING STRAP AND PRESS THE SWITCH.

### REASONS

- 1) If the process of setting strap is not correct, it will cause the end of P.P. Strap can not be reached to the definite. Position and the end gripper can not clip one time after banding second times.
- 2) The P.P. strap is curved. (in normal condition, the curved length can not be over 5mm in 1M length of P.P strap.
- 3) To store the P.P. strap is too little (The thickness of P.P. strap will influence the quantity of P.P. strap storage). In normal condition, it has to be stored one time after banding two times.
- 4) If the P.P. strap is stored too much, it will cause the shape of P.P. strap be changed and crowded in stored box.
- 5) To adjust the position of limit switch. And cam is not correct.
- 6) The inner of bandway is worn away it will make the feed to delay.

### SOLUTION

- 1) Refer to the unit of setting strap and the drawing.
- 2) To change the P.P. strap.
- 3) Refer to the page 11 and re-adjust the quantity of P.P. strap in storage box.
- 4) Refer to the unit of adjust the limit switch (Page 12).
- 6) To change the bandway (Refer to the parts manual).

CONDITION (B) : TO FEEDBACK AFTER BANDING OR TO CUT THE P.P. STRAP WHEN IT DOES NOT TIGHT THE PRODUCTS.

### REASONS

- 1) The gape of feed-back is not adjusted properly.
- 2) The distance of limit switch and cam is not adjusted properly.
- 3) The inner of bandway is worn away and it will make the feed to delay.

### SOLUTION

- 1) Refer to the page 10, it will mention how to adjust the gape of feed-back.
- 2) Refer to the unit of limit switch adjustment (page 12).
- 3) To change a new bandway( please refer to the parts manual page 10).

CONDITION (C) : THE P.P. STRAP CAN NOT BE BANDED TIGHTLY.

### REASONS

- 1) The tension jaw is worn away.

### SOLUTION

- 1) To change a new tension jaw. please refer to parts manual.

## CONDITION (D): THE MOTOR, M1 & M2 ARE NOT FUNCTION

### REASONS

- 1) The motor is breakdown.
- 2) When the capacity is over it's limit, then the protect switch will be leaped.

### SOLUTION

- 1) To change a new motor.
- 2) Refer to the electric control box (Page 8)
  - (a) To press the reset button for recovering the power supply.
  - (b) To check the voltage if the voltage is too low, it will cause the electric current very high. Please readjust the electric current, OVER SW-3 or SW-4.

## CONDITION (E): THE P.P. STRAP WILL RUN OUT OF ARCH

### REASONS

- 1) The corner flap of inner arch be squeezed or the spring is loosen.
- 2) The left bandway is not closed properly when feeding the P.P. Strap.

### SOLUTION

- 1) To change the arch flap spring.
- 2) Refer to page 12 and adjust the limit switch.



## PROPER P.P. STRAP ALIGNMENT

PLEASE TAKE THE FOLLOWING STEPS TO ADJUST THE ALIGNMENT OF THE P.P. STRAP WHEN IT IS NOT CONNECTED UNIFORMLY (REFER TO THE DRAWING BELOW).

CONDITION A :



STEP 1; Loosen the hex nut of the RH. Band Way and then move the RH. Band Way inward until the strap connects uniformly.

STEP 2: Tighten the hex nut.

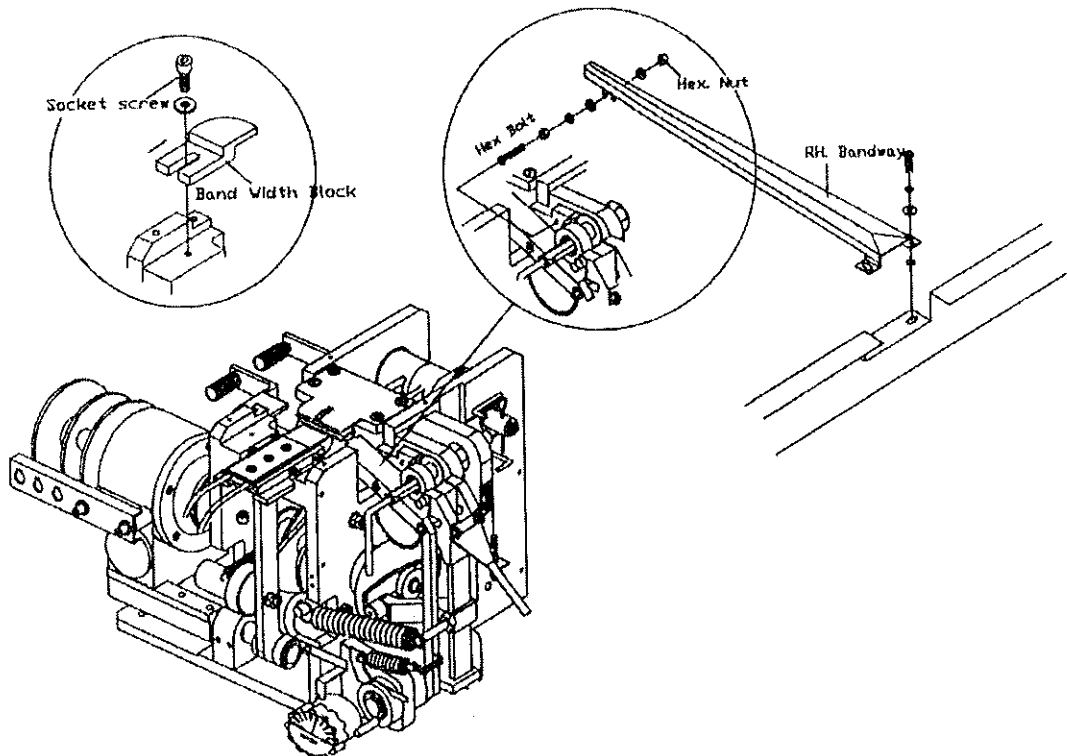
CONDITION B:

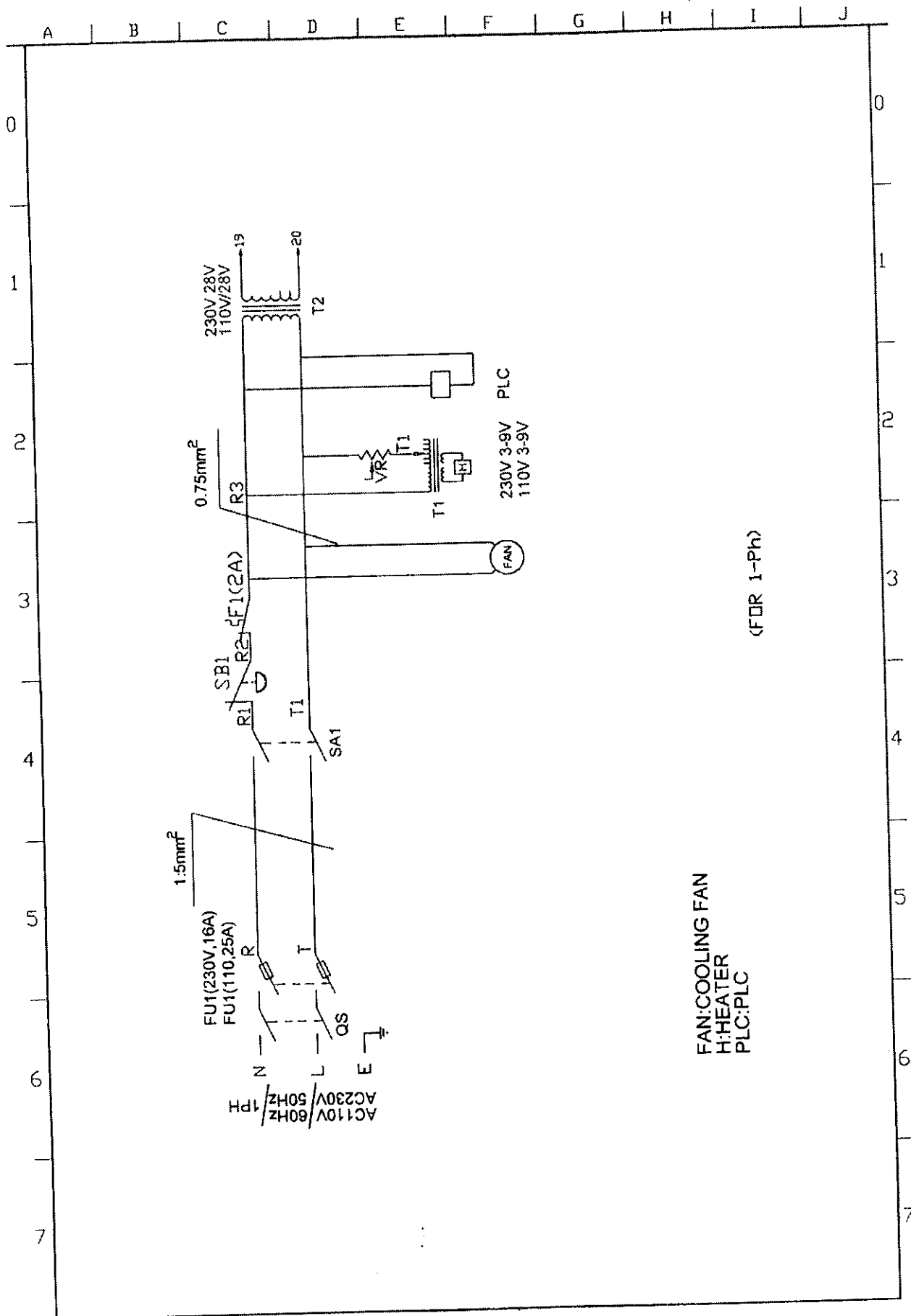


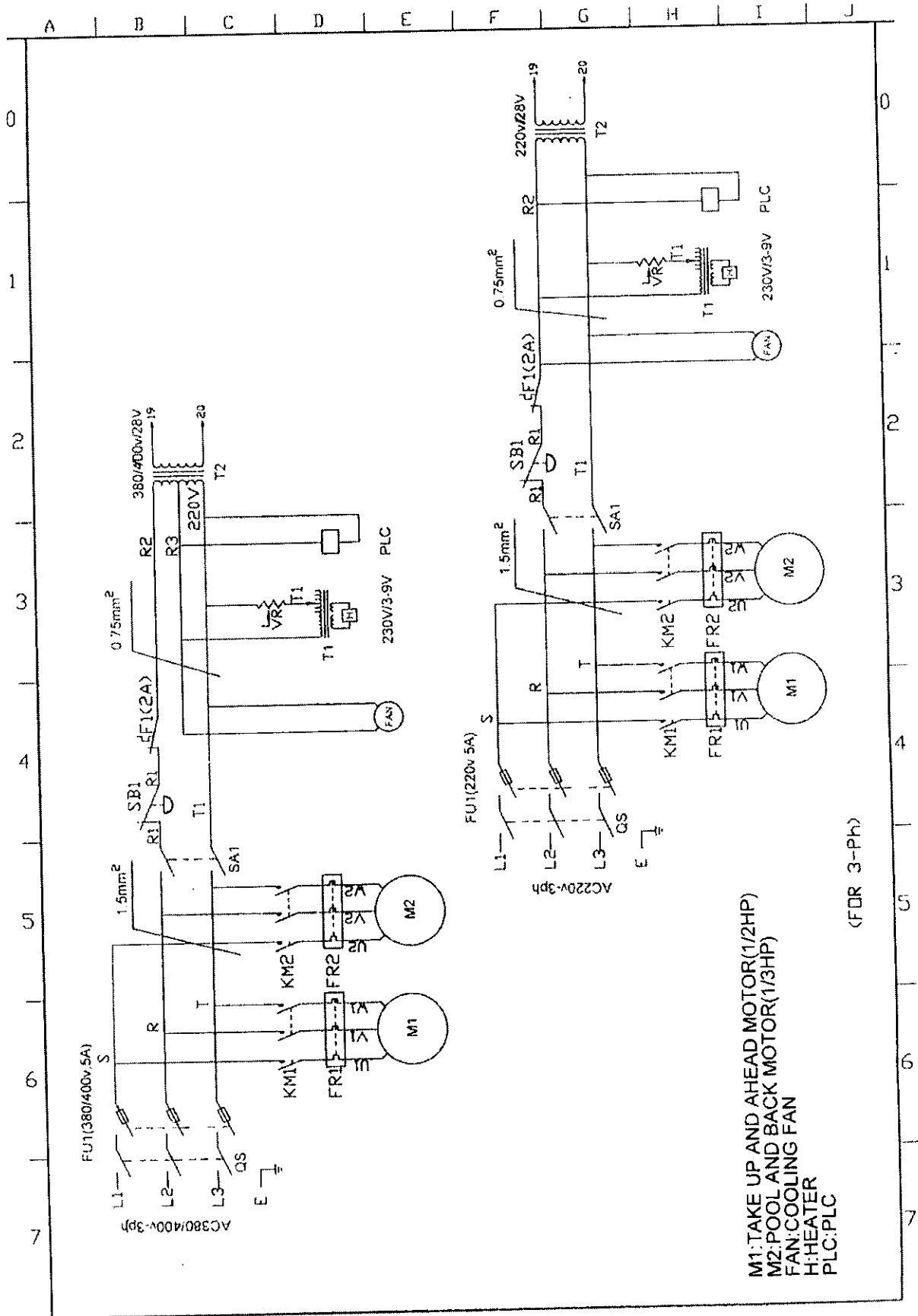
STEP 1: Loosen the hex nut of RH. Band Way and then move the RH. Band Way outward until the strap connects uniformly.

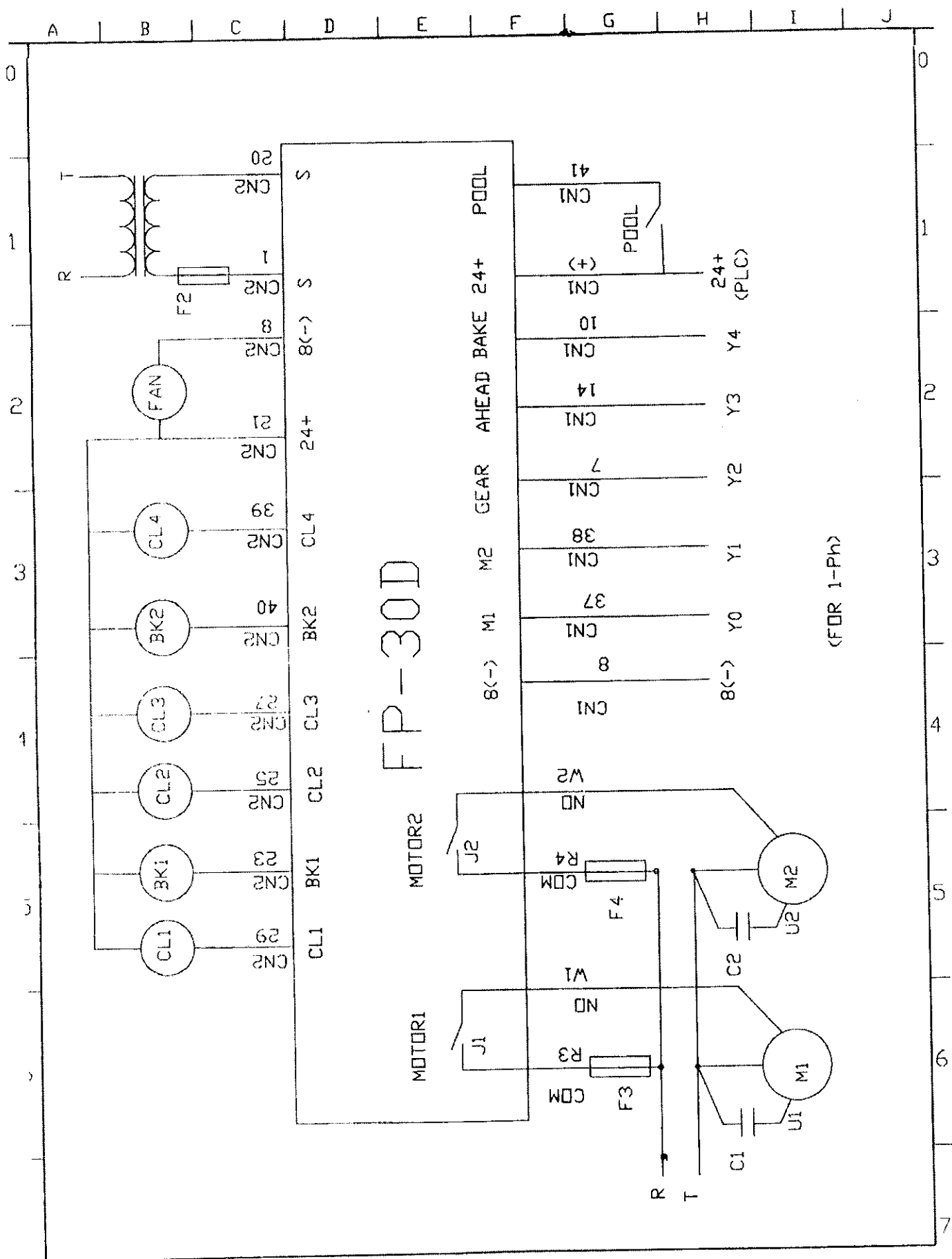
STEP 2: Tighten the hex nut.  
Also the band width block and to suit the size of P.P. strap (+ 0.5 mm) after you complete the two steps mentioned above.

METHOD : (1) Loosen the socket screw.  
(2) Adjust the band width block to the size of the strap (+ 0.5 mm)  
(3) Tighten the socket screw.

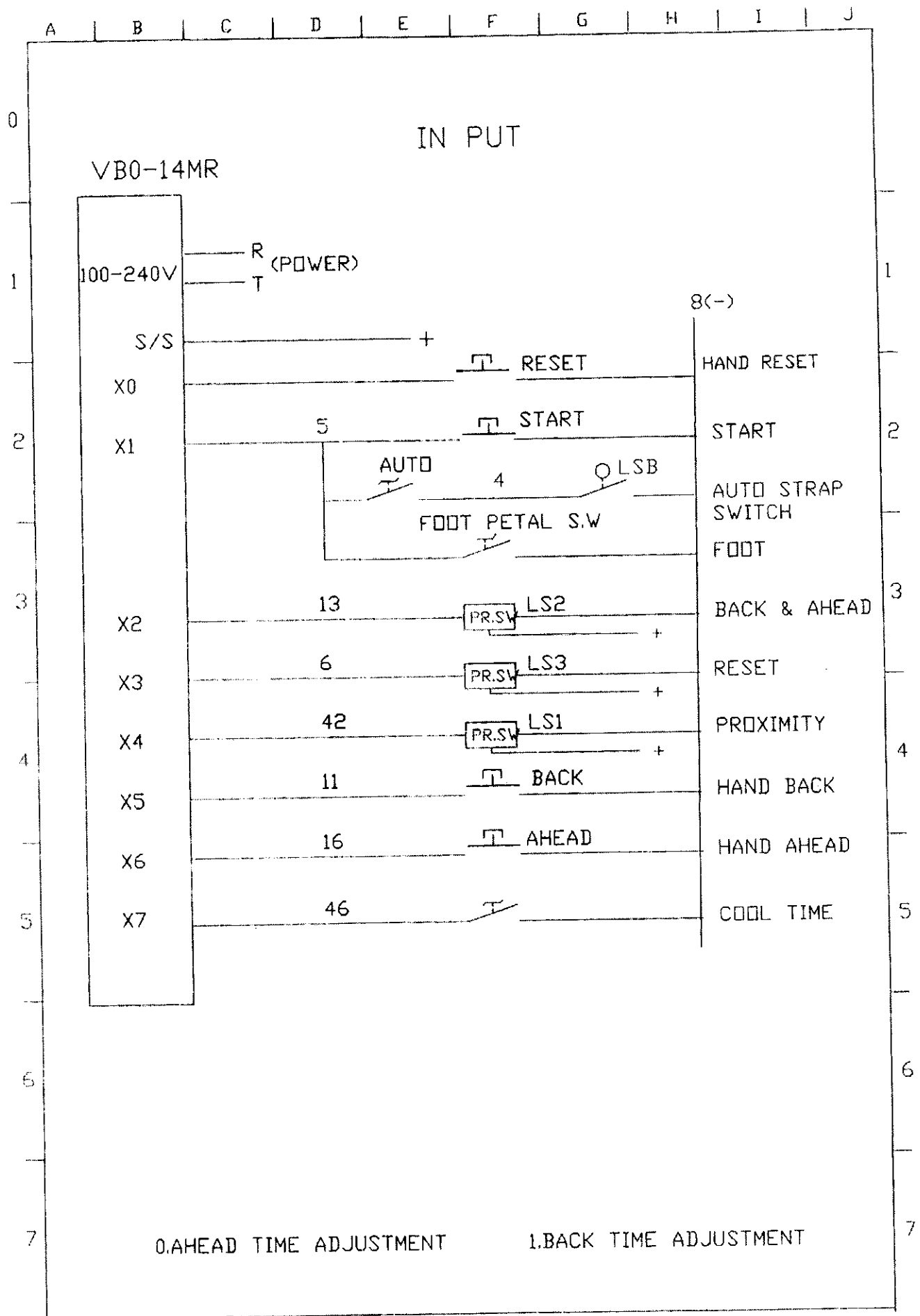


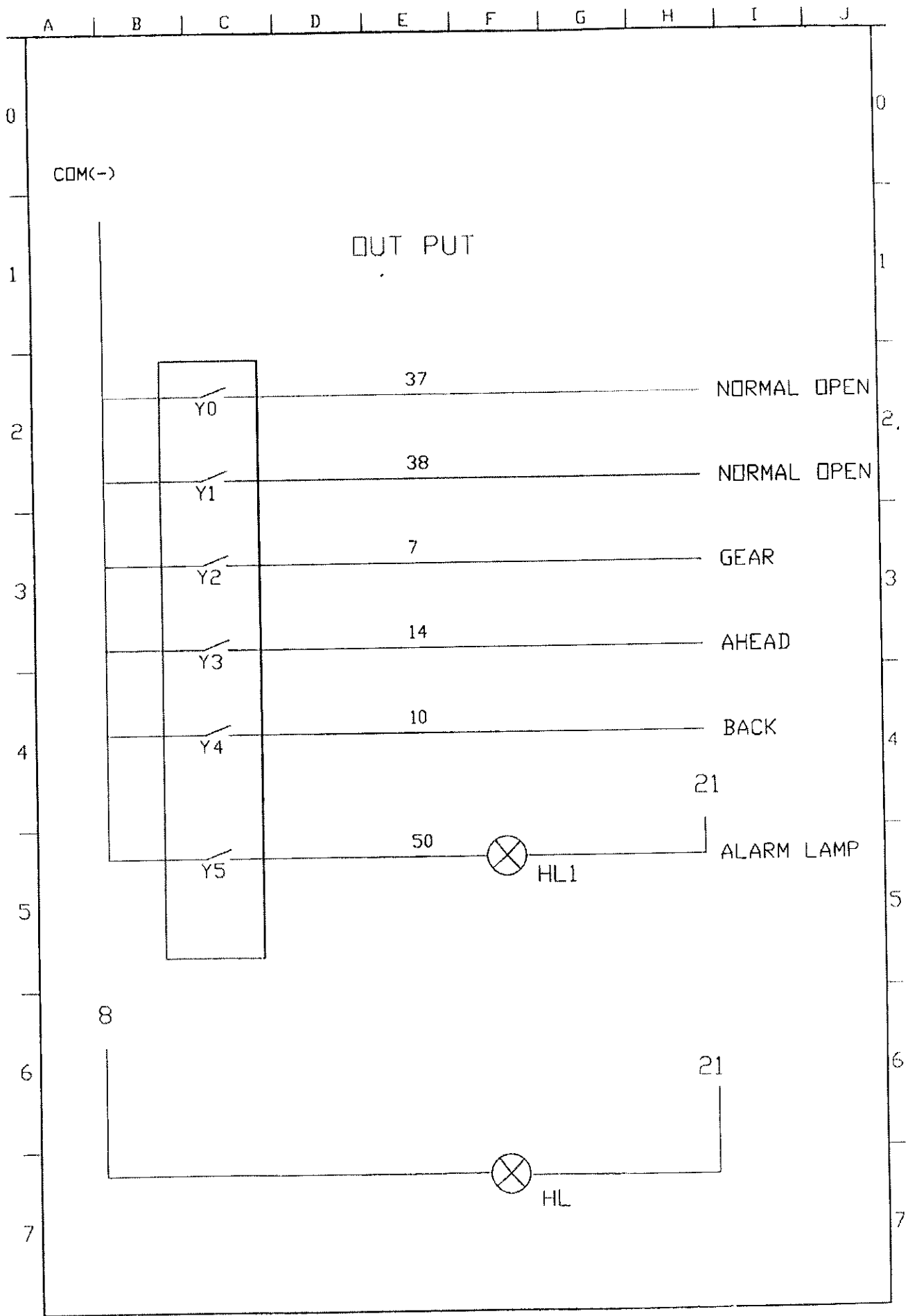












## PARTS LIST

FIG.1 CAM UNIT	28~29
FIG.2 SLIDE TABLE UNIT	30~31
FIG.3 PRESS UNIT	32~33
FIG.4 HEATER UNIT	34~35
FIG.5 CONTROL FRAME UNIT	36~37
FIG.6 TENSION UNIT	38~39
FIG.7 FEET UNIT	40~41
FIG.8~1 BAND WAY UNIT	42~43
FIG.9~1 ARCH UNIT	44~45
FIG.9~1B ARCH COVER UNIT	46~47
FIG.10A POOL UNIT	48~49
FIG.10B POOL UNIT	50~51
FIG.11 REEL UNIT	52~53
FIG.12 BODY UNIT	54~55
FIG.13 ELECTRIC UNIT	56~57
FIG.14~4 CONTROL BOX UNIT	58~59
FIG.14~5 CONTROL BOX UNIT	60~61
FIG.15~2 DRIVE UNIT	62~63

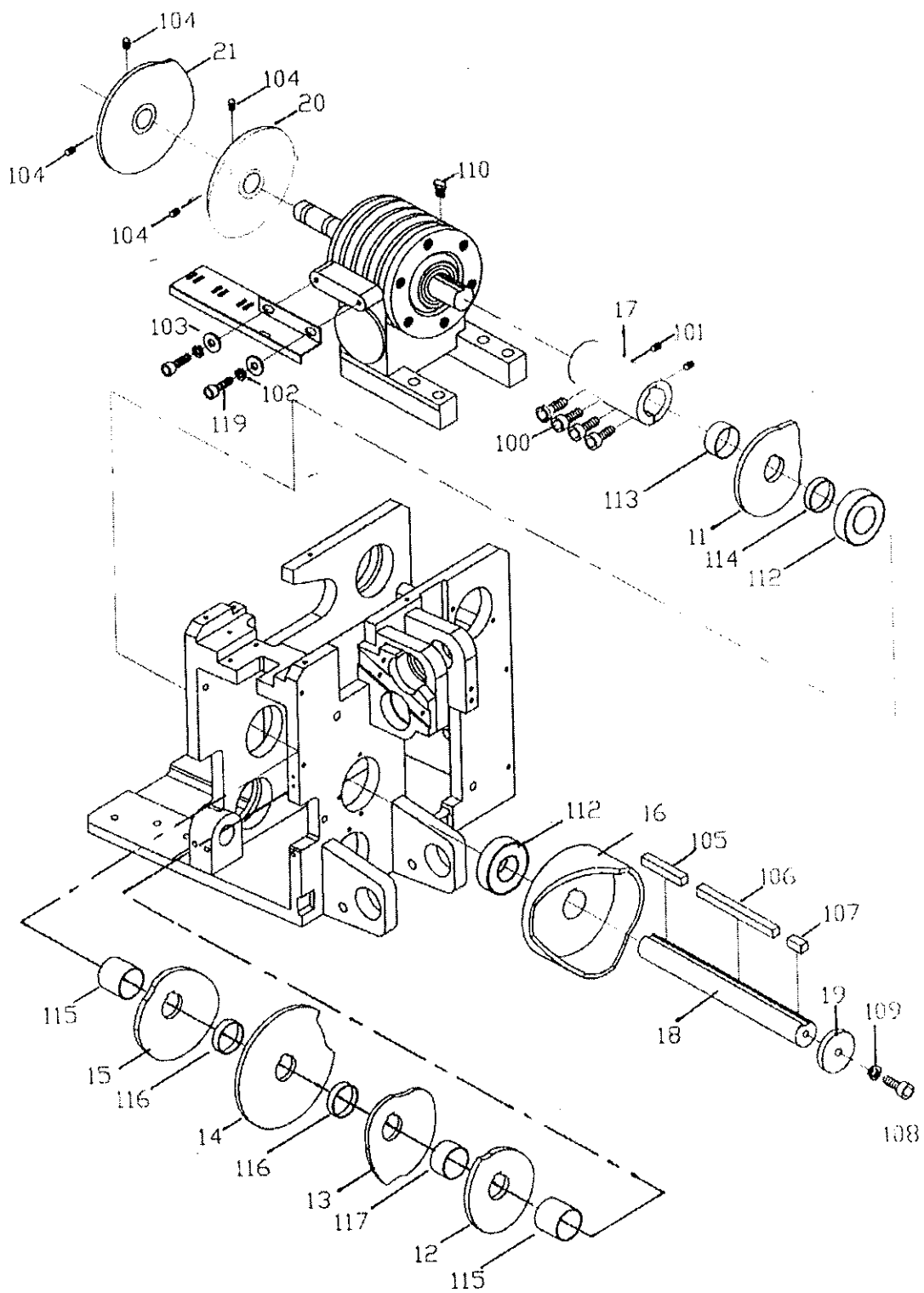
\* SUGGESTION ON HOW TO USE THIS PARTS LIST  
\* WHEN ORDERING OR ASKING FOR REPLACE PARTS, PLEASE ADVISE THE PHASE  
VOLTAGE AND PARTS NUMBER



**PARTS LIST, FIGURE 1 CAM UNIT**

**FPS-100-010**

KEY	Q'TY	PART NO.	DESCRIPTION
1	1	3-01010	CAM UNIT
11	1	3-01010-110	Slide table cam
12	1	3-01010-120	Right press cam
13	1	3-01010-130	Center press cam
14	1	3-01010-140	Heater cam
15	1	3-01010-150	Left press cam
16	1	3-01010-160	Tension cam
17	1	3-01010-170	Cam shaft coupling
18	1	3-01010-180	Cam shaft, 25*210
19	1	3-01010-190	Cam shaft end plate
20	1	3-01000-201	Proximity switch cam (LS-2)
21	1	3-01000-211	Proximity switch cam (LS-3)
100	4	200A06020	Socket head cap screw, M6*20
101	2	200G08010	Socket head set screw, M8*10
102	2	202B06	Lock washer, M6
103	2	202A062120	Plain washer, M6*21*2
104	6	200G06010	Socket head set screw, M6*10
105	1	213A0707070	Key, 7*7*70
106	1	213A0707100	Key, 7*7*100
107	1	213A0707020	Key, 7*7*20
108	1	200A08025	Socket head cap screw M8*25
109	1	202B08	Lock washer
110	1	226K163	Oil cover
112	2	210A6205ZZ	Ball bearing, 6205ZZ
113	1	202J2934100	Collar, 29*34*10
114	1	202J2934050	Collar, 29*34*5
115	2	202J2934280	Collar, 29*34*28
116	2	202J2934070	Collar, 29*34*7
117	1	202J2934190	Collar, 29*34*19
119	2	200A06016	Socket head cap screw, M6*16



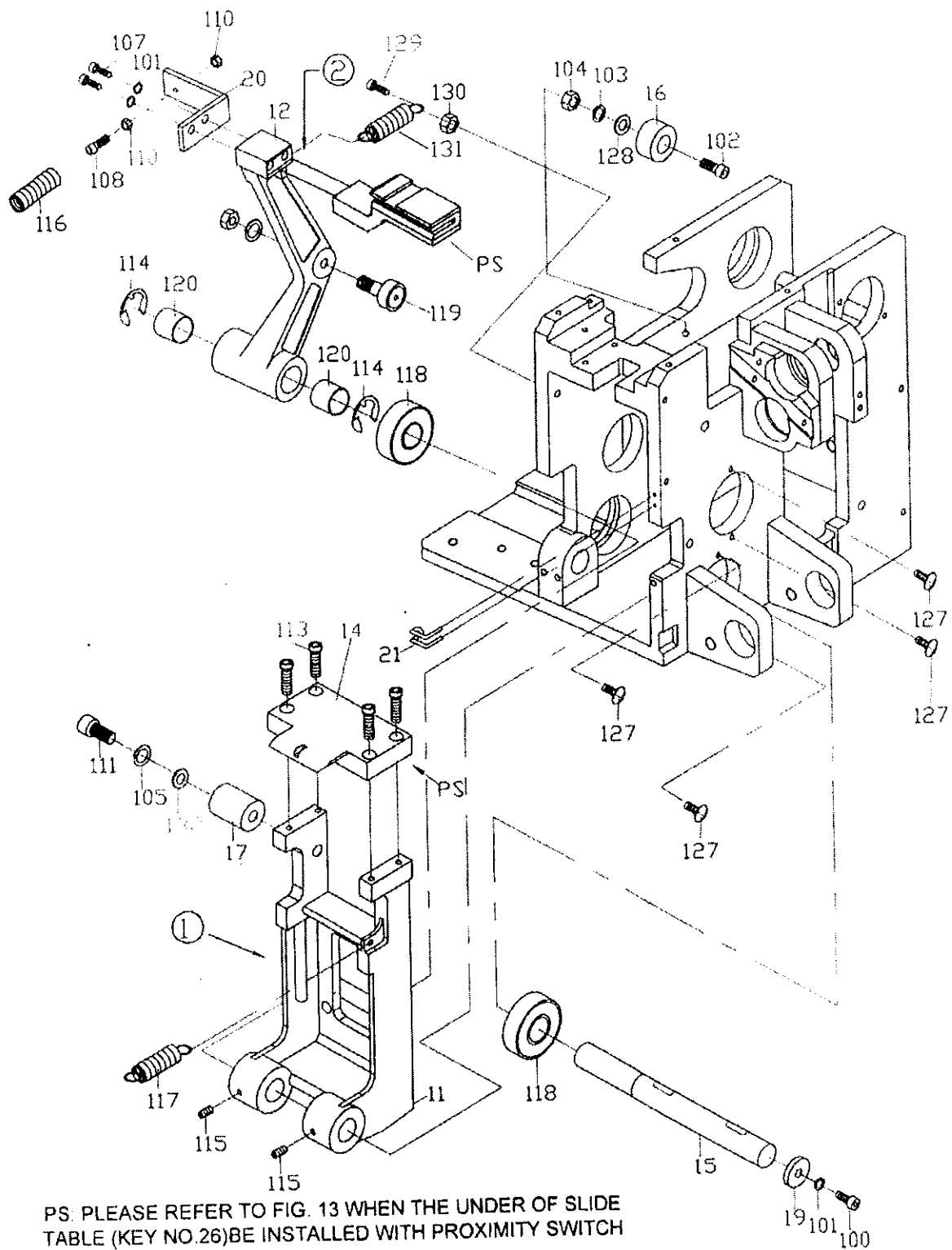
E:\Drw\qzdbzt\Fig.1

FIGURE 1 CAM UNIT

**PARTS LIST, FIGURE 2 SLIDE TABLE UNIT**

**FPS-100-020**

KEY	Q'TY	PART NO.	DESCRIPTION
1	1	3-02011-09	SLIDE TABLE UNIT, 9mm
1		3-02011-12	SLIDE TABLE UNIT, 12mm
1		3-02011-15	SLIDE TABLE UNIT, 15mm
2	1	3-02021	BAND GUIDE ARM UNIT
11	1	3-02010-110	Slide table frame
12	1	3-02020-120	Band guide arm
14	1	3-02011-1409	Slide table, 9mm
14	1	3-02011-1412	Slide table, 12mm
14	1	3-02011-1415	Slide table, 15mm
15	1	3-02000-150	Slide table frame shaft
16	1	3-02000-160	Slide table stopper
17	1	3-02000-170	Slide table back adj.
19	1	3-02000-190	End plate
20	1	3-02000-200	Band guide spring bracket
21	1	3-02000-210	Slide table frame spring hook
100	1	200A06020	Socket head cap screw, M6*20
101	3	202B06	Lock washer, M6
102	1	200A08030	Socket head cap screw, M8*30
103	1	202B08	Lock washer
104	1	201A08	Hex nut, M8
105	1	202B10	Lock washer, M10
107	2	200A06050	Socket head cap screw, M6*50
108	1	200A06016	Socket head cap screw, M6*16
110	2	201A06	Hex nut, M6
111	1	200A10050	Socket head cap screw, M10*50
113	4	200B06020	Plating socket head cap screw, M6*20
114	2	212AE15	Ring, E-15
115	2	200G06010	Socket head set screw, M6*10
116	1	2211212026	Band guide spring 1.2*12*26
117	1	2202016109	Heater crank spring 2*16*109
118	2	210A6304ZZ	Ball bearing, 6304ZZ
119	1	210F0010	Cam follower with nut, CF-10
120	2	210E2025	Metal Bush, MB2025
127	4	200H06010	Truss head machine screw, M6*10
128	1	202A0812	Plain washer, M8*12
129	1	200A05020	Socket head cap screw, M5*20
130	1	201A05	Hex nut, M5
131	1	2201311069	Spring 1.3*11.4*69
132	1	202A1020	Plain washer, 10*20



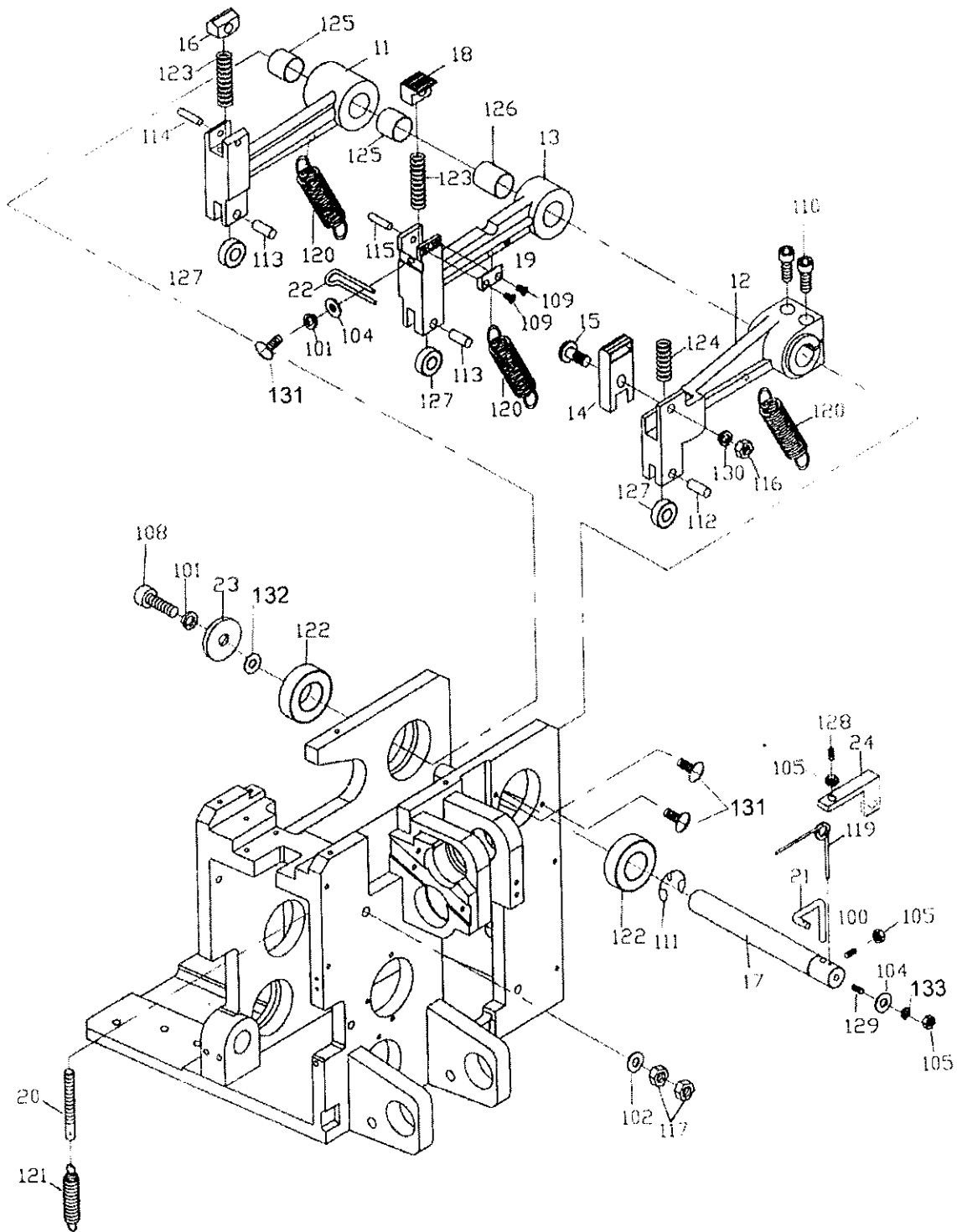
E:\Dnw\qzdbzt\Fig.2

FIGURE 2 SLIDE TABLE UNIT

**PARTS LIST, FIGURE 3 PRESS UNIT**

**FPS-100-030**

KEY	Q'TY	PART NO.	DESCRIPTION
1	1	3-03010	CUTTER (UPPER) UNIT
2	1	3-03020	UNIVERSAL PRESS UNIT
3	1	3-03030	JAM (LF.) UNIT
11	1	3-03030-110	Lf. block arm
12	1	3-03010-120	Rh. block arm
13	1	3-03020-130	Center block arm
14	1	3-03010-140	Cutter upper (9:15mm)
15	1	3-03010-150	Cutter upper pin
16	1	3-03030-160	Jam (Lf.)
17	1	3-03000-170	Press arm shaft
18	1	3-03020-180	Universal press
19	1	3-03020-190	Cutter lower
20	1	3-03000-200	Cutter tension spring hook
21	1	3-03000-210	Upper shaft spring adjust
22	1	3-03020-220	Cutter spring hook
23	1	3-03000-230	End plate
24	1	3-03000-240	Bracket
100	1	200G06016	Socket head set screw, M6*16
101	2	202B06	Lock washer, M6
102	1	202A0816	Plain washer, M8*16
104	2	202A061620	Plain washer, M6*16*2
105	3	201A06	Hex nut, M6
108	1	200A06020	Socket head cap screw, M6*20
109	2	200E05008	Phillips head machine screw, M5*8
110	2	200A08035	Socket head cap screw, M8*35
111	1	212AE15	Ring, E-15
112	1	211A0822	Spring pin, 8 dia.*22
113	2	211A0820	Spring pin, 8 dia.*20
114	1	211A0624	Spring pin, 6 dia.*24
115	1	211A0622	Spring pin, 6 dia.*22
116	1	201A10	Hex nut, M10
117	2	201A08	Hex nut, M8
119	1	220K3016046	Upper roller spring 3.0*16*46
120	3	2202219141	Press tension spring 2.2*19*141
121	1	2202014063	Cutter tension spring 2*14*63
122	2	210A6304ZZ	Ball bearing, 6304ZZ
123	2	2213513063	Center block spring 3.5*13*63
124	1	2213014048	Rh.block spring 3*14*48
125	2	210E2020	Metal Bush, MB2020
126	1	210E2025	Metal Bush, MB2025
127	3	210A0628ZZ	Ball bearing, 628ZZ
128	1	200G06010	Socket head set screw, M6*10
129	1	200G06020	Socket head set screw, M6*20
130	1	202B10	Lock washer, M10
131	3	200H06010	Truss head machine screw, M6*10
132	As require	202C061402	Copper washer, M6*14*0.2
133	1	202B06	Lock washer, M6



E:\Drw\qzdbzt\Fig 3

FIGURE 3 PRESS UNIT

**PARTS LIST, FIGURE 4 HEATER UNIT**

FPS-100-040

KEY	Q'TY	PART NO.	DESCRIPTION
1	1	3-04010	HEATER PLATE UNIT
2	1	3-04020	HEATER CRANK UNIT
11	1	3-04000-110	Heater crank
12	1	3-04000-120	Heater crank shaft
13	1	3-04000-130	Heater crank roller colar
14	1	3-04000-140	Heater bearing shaft
15	1	3-04000-150	Heater slide guide (Lf.)
16	1	3-04000-160	Heater slide guide (Rh.)
17	1	3-04010-170	Heater plate
18	1	3-04010-180	Cover plate
19	4	3-04010-191	Isolating plate
20	1	3-04010-200	Heater base
21	1	3-04000-210	Heater cover
22	1	3-04000-220	Heater plate cover
23	1	3-04000-230	Heater terminal bracket
100	3	200F04020	Flat head cap screw, M4*20
101	3	201A04	Hex nut, M4
102	4	212AE15	Ring, E-15
103	2	202B08	Lock washer
104	2	201A08	Hex nut, M8
105	4	200A06016	Socket head cap screw, M6*16
106	2	200F05010	Flat head cap screw, M5*10
107	2	200G06010	Socket head set screw, M6*10
108	2	210E2020	Metal Bush, MB2020
109	1	210A6304ZZ	Ball bearing, 6304ZZ
110	1	2202016109	Heater crank spring 2*16*109
112	1	152H001	Heater terminal
113	1	2200507050	Tension spring 0.5*7*50
114	1	200A04020	Socket head cap screw, M4*20

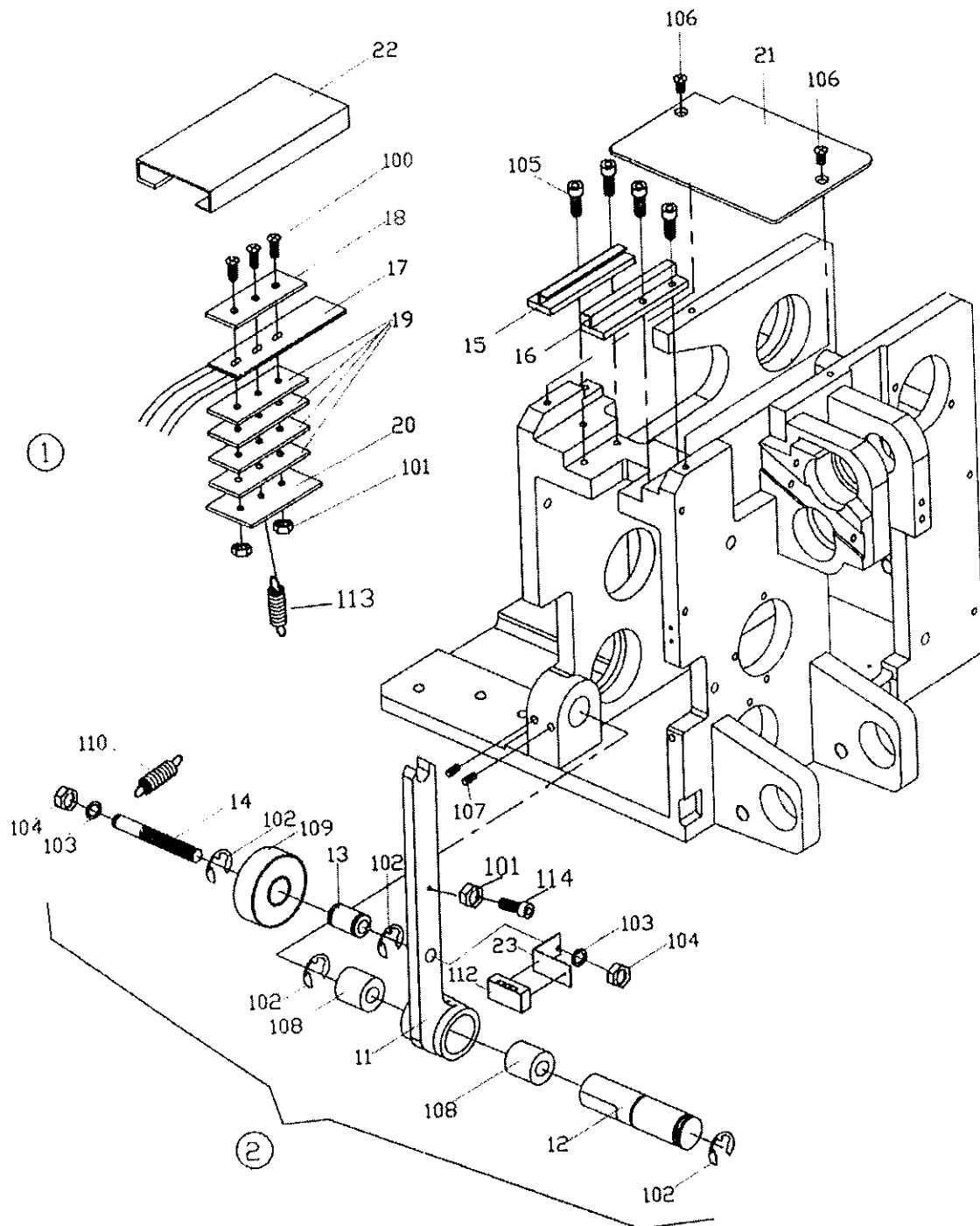


FIGURE 4 HEATER UNIT

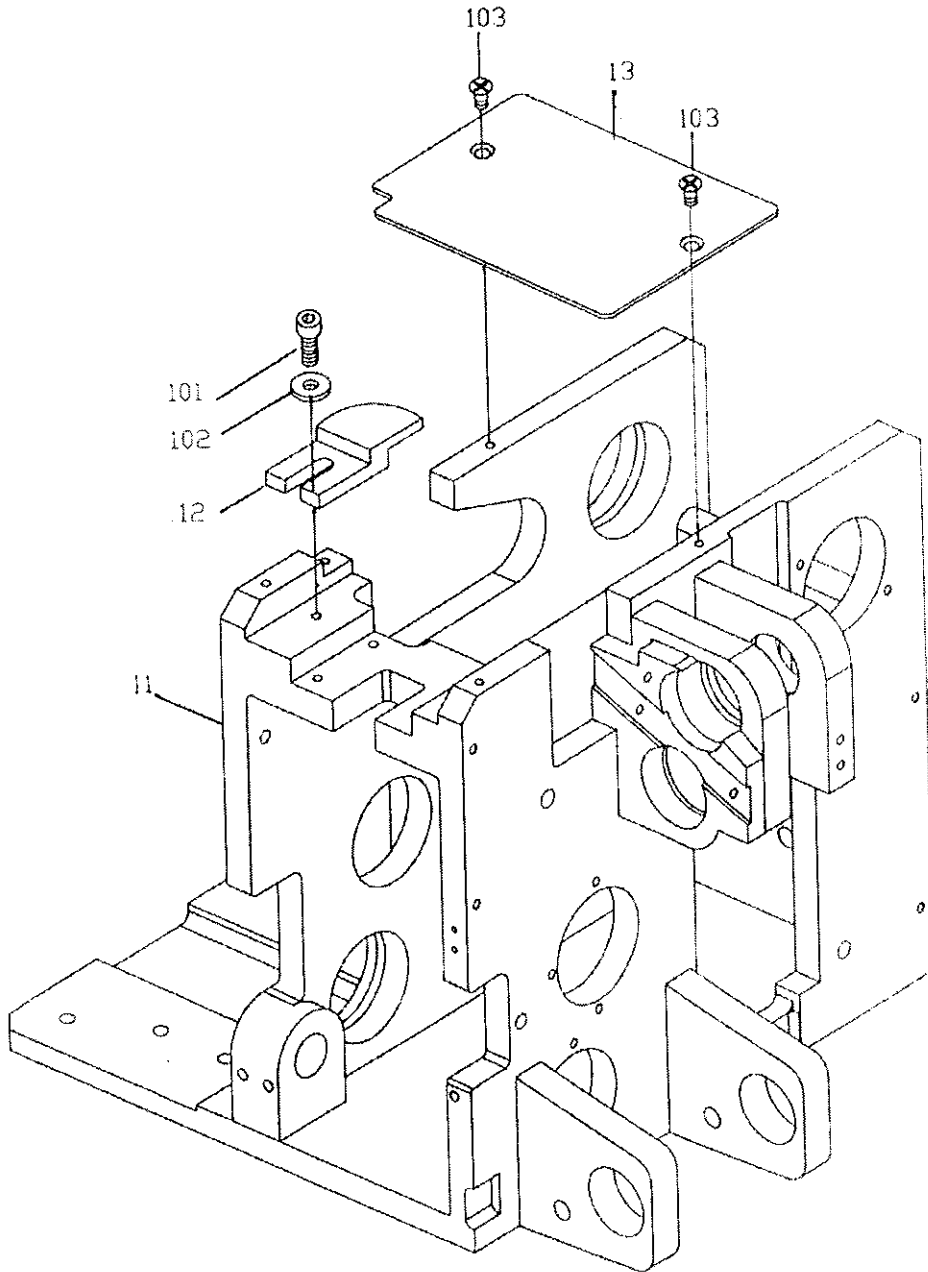
E:\Drw\qzdbzt\Fig.4



**PARTS LIST, FIGURE 5 CONTROL UNIT**

**FPS-100-050**

KEY	Q'TY	PART NO.	DESCRIPTION
11	1	3-05000-110	Control frame
12	1	3-05000-120	Band width block
13	1	3-05000-130	Slide table cover
101	1	200A06016	Socket head cap screw, M6*16
102	1	202A061620	Plain washer, M6*16*2
103	2	200F05010	Flat head cap screw, M5*10



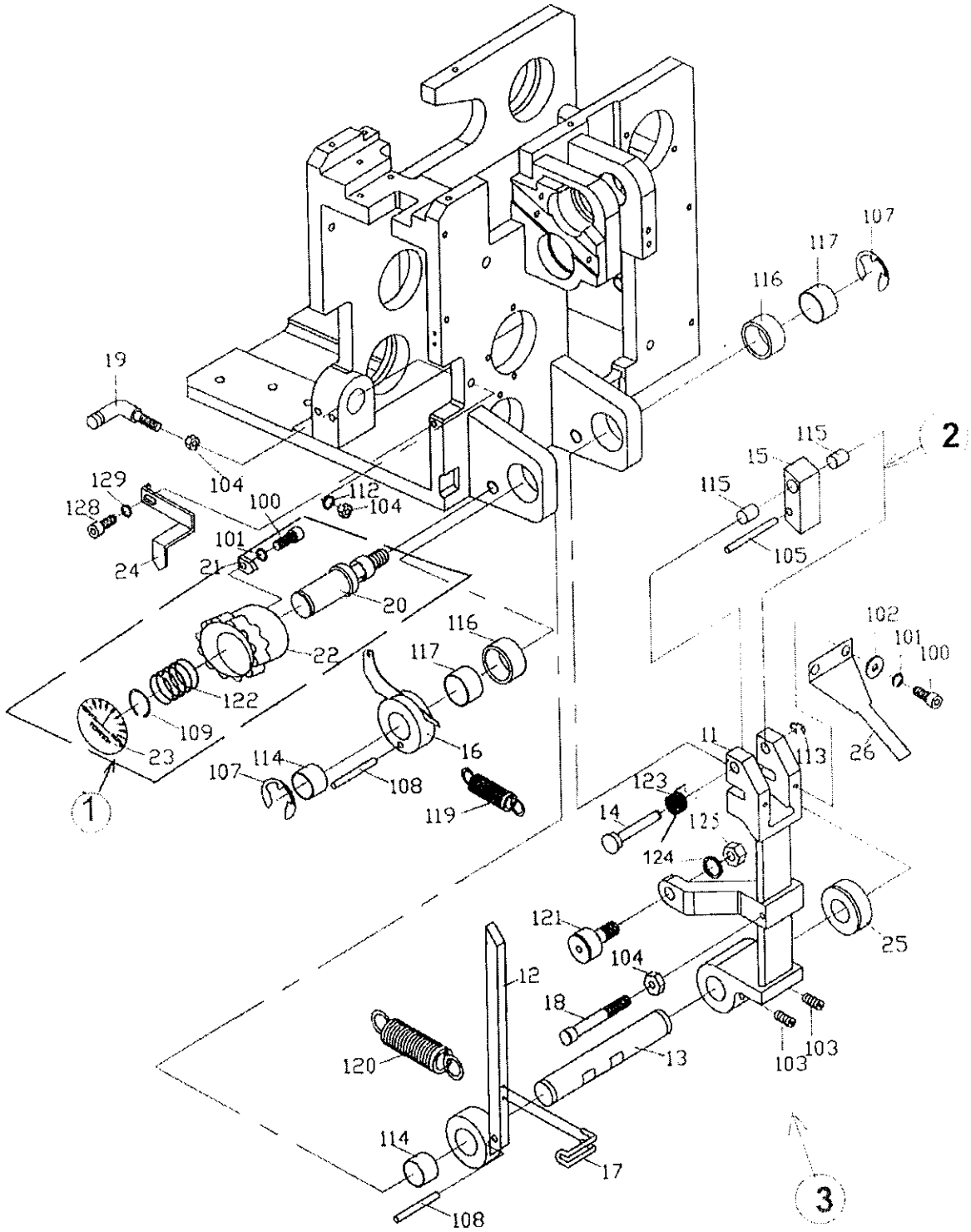
E:\Drw\qzdbzt\Fig.5

FIGURE 5 CONTROL FRAME UNIT

**PARTS LIST, FIGURE 6 TENSION UNIT**

**FPS-100-060**

KEY	Q'TY	PART NO.	DESCRIPTION
1	1	3-06010	TENSION ADJ. ARM UNIT
2	1	3-06020	TENSION JAW UNIT
3	1	3-06030	TENSION ARM UNIT
11	1	3-06030-110	Tension arm
12	1	3-06030-120	Tension adj. arm
13	1	3-06030-130	Tension arm shaft
14	1	3-06030-140	Tension jaw shaft
15	1	3-06020-150	Tension jaw
16	1	3-06000-160	Tension adjuster
17	1	3-06030-170	Tension adj. arm spring hook
18	1	3-06030-180	Tension arm spring hook
19	1	3-06000-190	Tension arm hook
20	1	3-06010-200	Tension adj. cam shaft
21	1	3-06010-210	Tension adj. cam lock
22	1	3-06010-220	Tension adj. cam
23	1	3-06010-230	Tension select dial
24	1	3-06000-240	Tension fingler
25	1	3-06030-250	Tension arm collar
26	1	3-06030-2609	Strap guide metal, 9mm
26		3-06030-2612	Strap guide metal, 12mm
26		3-06030-2615	Strap guide metal, 15mm
100	2	200A05012	Socket head cap screw, M5*12
101	2	202B05	Lock washer, M5
102	1	202A0512	Plain washer, M5*12
103	2	200G06010	Socket head set screw, M6*10
104	3	201A08	Hex nut, M8
105	1	211A0675	Spring pin, M6*75
107	2	212AE15	Ring, E-15
108	2	211A0645	Spring pin, M6*45
109	1	212AR20	Ring, R-20
112	1	202A0816	Plain washer, M8*16
113	1	212AE06	Ring, E-6
114	2	210E2015	Metal Bush, MB2015
115	2	210E0808	Metal Bush, MB0808
116	2	210F2516	Needle bearing HK2516
117	2	210F202516	Needle bearing (inner) IR202516
119	1	2202314075	Tension adj. arm spring 2.3*14*75
120	1	2202314046	Tension spring 2.3*14*46
121	1	210F0010	Cam follower with nut, CF-10
122	1	2211223023	Tension adj. cam spring 1.2*23*23
123	1	220K1215006	Tension jaw spring 1.2*15*6
128	1	200E04010	Phillips head machine screw, M4*10
129	1	202B04	Lock washer, M4

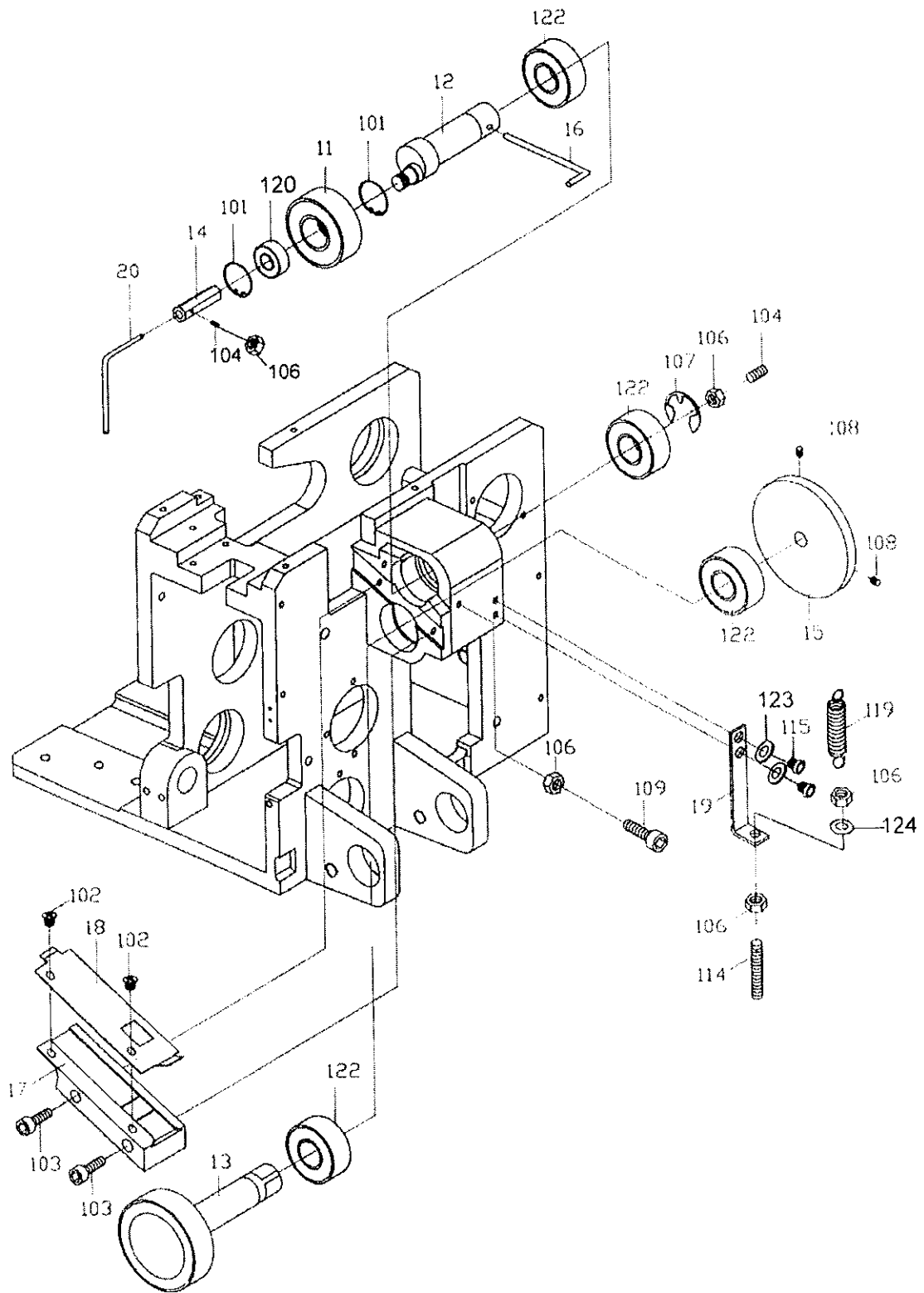


E:\Drw\qzdbzt\Fig.6

FIGURE 6 TENSION UNIT

**PARTS LIST, FIGURE 7 FEED UNIT**

KEY	Q'TY	PART NO.	DESCRIPTION	FPS-100-070
1	1	3-070109	FEED SHOOTER UNIT,9mm	
1		3-070112	FEED SHOOTER UNIT,12mm	
1		3-070115	FEED SHOOTER UNIT,15mm	
11	1	3-07000-1109	Upper feed roller, 9mm	
11		3-07000-1112	Upper feed roller, 12mm	
11		3-07000-1115	Upper feed roller, 15mm	
12	1	3-07000-120	Upper feed roller shaft	
13	1	3-07000-130	Feed roller	
14	1	3-07000-140	Upper roller grip nut	
15	1	3-07000-150	Feed roller pulley M-48	
16	1	3-07000-160	Upper roller spring hook	
17	1	3-07010-1709	Feed shooter, 9mm	
17		3-07010-1712	Feed shooter, 12mm	
17		3-07010-1715	Feed shooter, 15mm	
18	1	3-07010-180	Feed shooter cover	
19	1	3-07000-190	Spring adjuster base	
20	1	3-07000-200	Upper roller lever	
101	2	212AR24	Ring, R-24	
102	2	200H06012	Truss head machine screw, M6*12	
103	2	200A06045	Socket head cap screw, M6*45	
104	2	200G06016	Socket head set screw, M6*16	
106	5	201A06	Hex nut, M6	
107	1	212AE12	Ring, E-12	
108	2	200G06010	Socket head set screw, M6*10	
109	1	200A06012	Socket head cap screw, M6*12	
114	1	200G06065	Socket head set screw, M6*65	
115	2	200A05010	Socket head cap screw, M5*10	
119	1	220C709077	Feed spring 0.7*9.3*76 5	
120	1	210A0628	Ball bearing 628zz	
122	4	210A6202ZZV3	Ball bearing 6202ZZ-V3	
123	2	202A0512	Plain washer, M5*12	
124	1	202B06	Lock washer, M6	

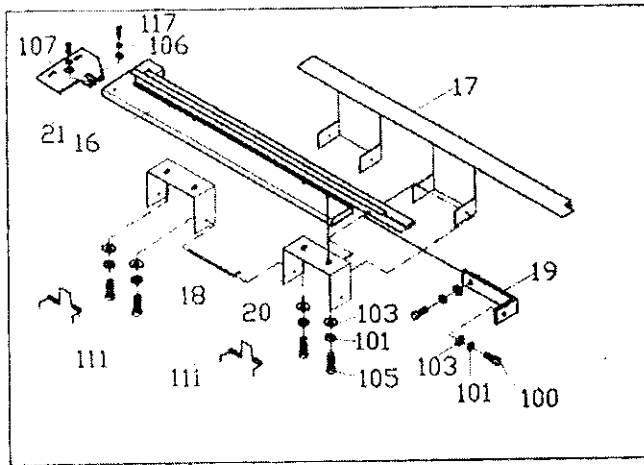


E:\Draw\qzdbzt\Fig 7

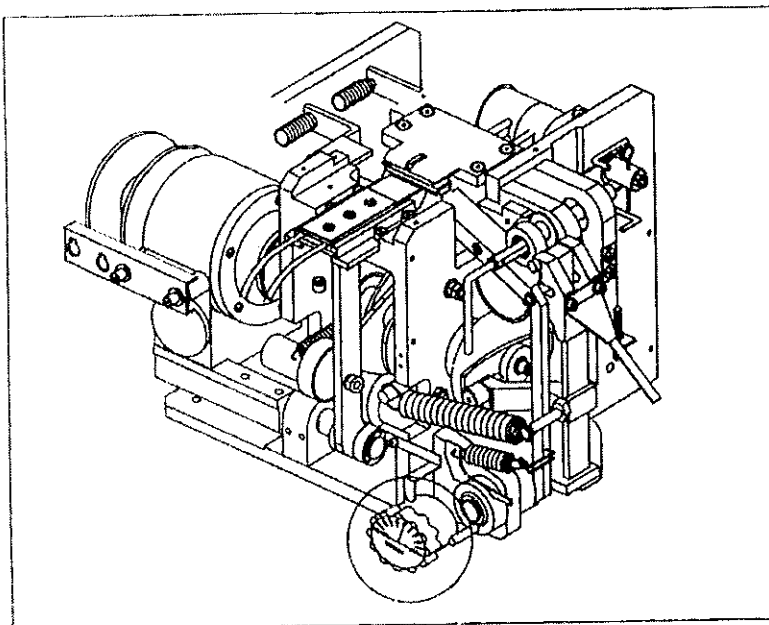
FIGURE 7 FEED UNIT (SINGLE)

**PARTS LIST, FIGURE 8-1 BAND WAY UNIT (ALUMINIUM ARCH)**

KEY	Q'TY	PART NO.	DESCRIPTION	FPS-100-081
1	1	3-081109	RH.BANDWAY ASS'Y 9mm	
1		3-081112	RH.BANDWAY ASS'Y 12mm	
1		3-081115	RH.BANDWAY ASS'Y 15mm	
2	1	3-08120	LF.BANDWAY ASS'Y (FOR STANDARD ARCH)	
2		3-08121	LF.BANDWAY ASS'Y, SHORTEN 200mm	
2		3-08122	LF.BANDWAY ASS'Y, LENGTHEN 200mm	
2		3-08123	LF.BANDWAY ASS'Y, LENGTHEN 400mm	
2		3-08124	LF.BANDWAY ASS'Y, LENGTHEN 600mm	
3	1	3-081309	CORE ASS'Y 9mm	
3		3-081312	CORE ASS'Y, 12mm	
3		3-081315	CORE ASS'Y, 15mm	
11	1	3-081109-110	Rh. bandway 9mm	
11		3-081112-110	Rh. bandway 12mm	
11		3-081115-110	Rh. bandway 15mm	
12	1	3-08110-120	Rh. bandway flap (R)	
13	1	3-08110-130	Rh. bandway flap (L)	
14	2	3-08110-140	Rh. bandway flap pin (rear)	
15	2	3-08110-150	Rh. bandway flap pin (front)	
16	1	3-08120-160	Lf. bandway	
17	1	3-08120-170	Lf. bandway flap	
18	2	3-08120-180	Lf. bandway flap pin	
19	1	3-08120-190	Lf. bandway fixer	
20	2	3-08120-200	Lf. bandway connector	
21	1	3-08120-210	LF.bandway stator	
100	2	200A05016	Socket head cap screw, M5*16	
101	6	202B05	Lock washer, M5	
102	2	202B06	Lock washer, M6	
103	6	202A0512	Plain washer, M5*12	
104	1	200C06050	Hex bolt, M6*50	
105	4	200E05010	Phillips head machine screw, M5*10	
106	2	202B04	Lock washer, M4	
107	2	202A0412	Plain washer, M4*12	
108	2	200H06015	Truss head machine screw, M6*15	
110	2	220K0804022	Rh. bandway flap spring 0.8*4*22	
111	2	220K0807060	Lf. bandway flap spring 0.8*7*60	
112	4	201B06	Hex nut, M6	
113	4	202A0612	Plain washer, M6*12	
117	2	200E04012	Phillips head machine screw, M4*12	



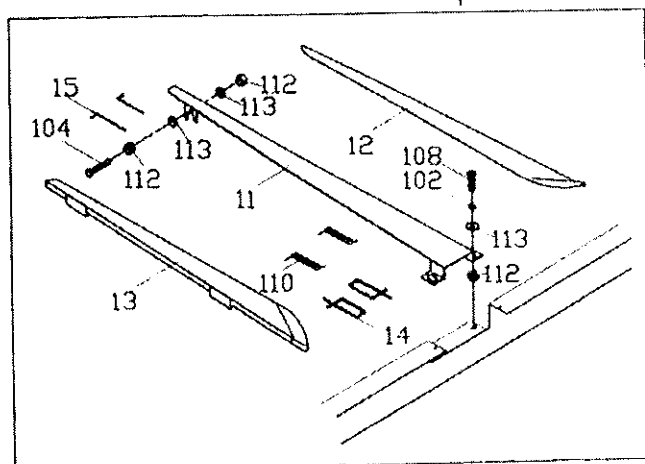
② LF.BANDWAY ASS'Y



③ CORE ASS'Y

RH.BANDWAY ASS'Y

①



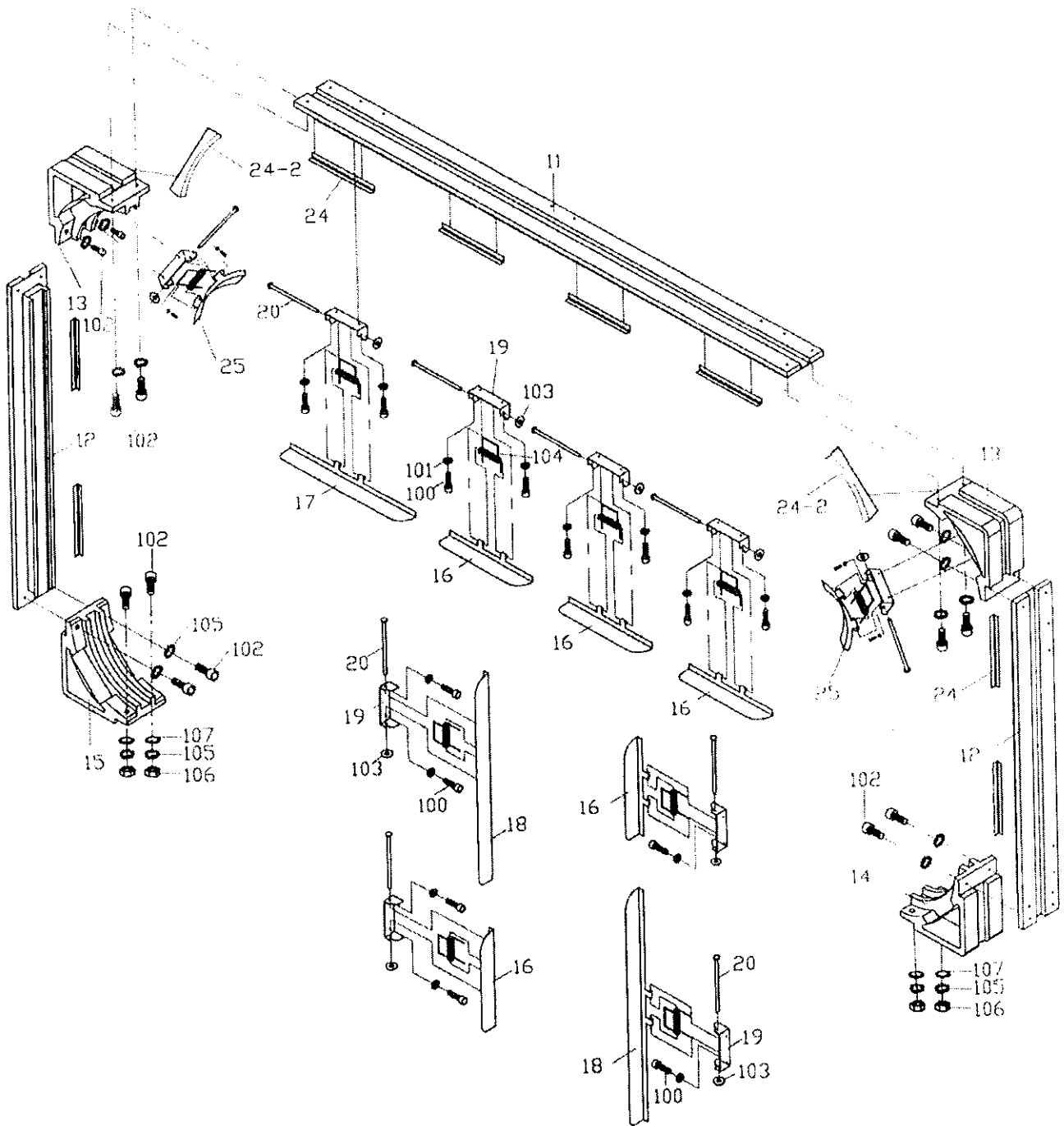
E:\Drw\qzdbzt\Fig.8-1

Fig.8-1 BAND WAY UNIT (ALUMINUM ARCH)



**PARTS LIST, FIGURE 9-1A ARCH UNIT (ALUMINIUM ARCH)**

KEY	Q'TY	PART NO.	DESCRIPTION	FPS-100-091A
1	1	3-09110-1109-085	ARCH FRAME, TOP ASSE. 850	
1	1	3-09110-1112-085	ARCH FRAME, TOP ASSE. 850	
1	1	3-09110-1115-085	ARCH FRAME, TOP ASSE. 850	
2	1	3-09110-1209-060	ARCH FRAME, SIDE ASSE. 600	
2	1	3-09110-1212-060	ARCH FRAME, SIDE ASSE. 600	
2	1	3-09110-1215-060	ARCH FRAME, SIDE ASSE. 600	
11	1	3-09110-110	Arch frame, top 850	
12	2	3-09110-120	Arch frame, side 600	
13	2	3-09110-130	Arch corner	
14	1	3-09110-131	Arch corner (RD)	
15	1	3-09110-132	Arch corner (LD)	
16	5	3-09110-1609	Arch flap ( 9mm), 205mm	
16	5	3-09110-1612	Arch flap (12mm), 205mm	
16	5	3-09110-1615	Arch flap (15mm), 205mm	
17	1	3-09110-1709	Arch flap ( 9mm), 259mm	
17	1	3-09110-1712	Arch flap (12mm), 259mm	
17	1	3-09110-1715	Arch flap (15mm), 259mm	
18	2	3-09110-1809	Arch flap ( 9mm), 269mm	
18	2	3-09110-1812	Arch flap (12mm), 269mm	
18	2	3-09110-1815	Arch flap (15mm), 269mm	
19	10	3-09110-190	Arch hinge	
20	10	3-09110-200	Arch hinge pin	
24	8	3-09110-240	Muffler silencer	
24	2	3-09110-242	Muffler silencer	
25	2	3-09110-250	Arch wing flanke	
100	16	200E04012	Phillips head machine screw, M4*12	
101	16	202B04	Lock washer, M4	
102	16	200A05016	Socket head cap screw, M5*16	
103	10	212BSP03	Pushing nut 3MM	
104	8	220K0805012	Arch hinge spring 0.8*5*12	
105	14	202B05	Lock washer, M5	
106	2	201A05	Hex nut, M5	
107	2	202A0512	Plain washer, M5*12	



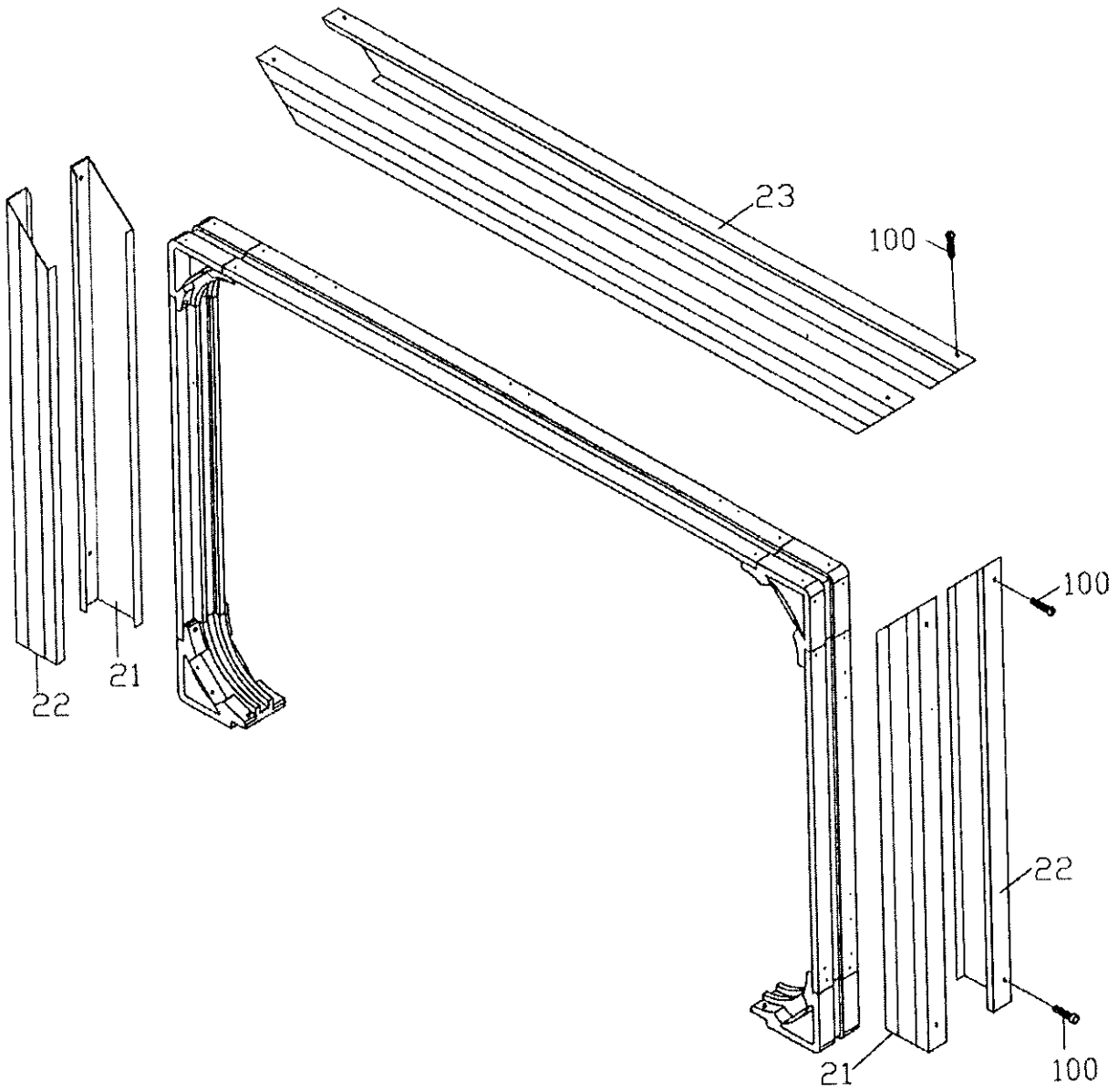
E:\Drw\qzdbzt\Fig.9-1

FIGURE 9-1 ARCH UNIT (ALUMINIUM ARCH)

**PARTS LIST, FIGURE 9-1B ARCH UNIT (ALUMINIUM ARCH)**

FPS-100-091B

KEY	Q'TY	PART NO.	DESCRIPTION
21	2	3-09110-210	Arch cover (L) 600
22	2	3-09110-220	Arch cover (R) 600
23	2	3-09110-230	Arch cover (W) 850
100	12	200H05012	Truss head machine screw, M5*12

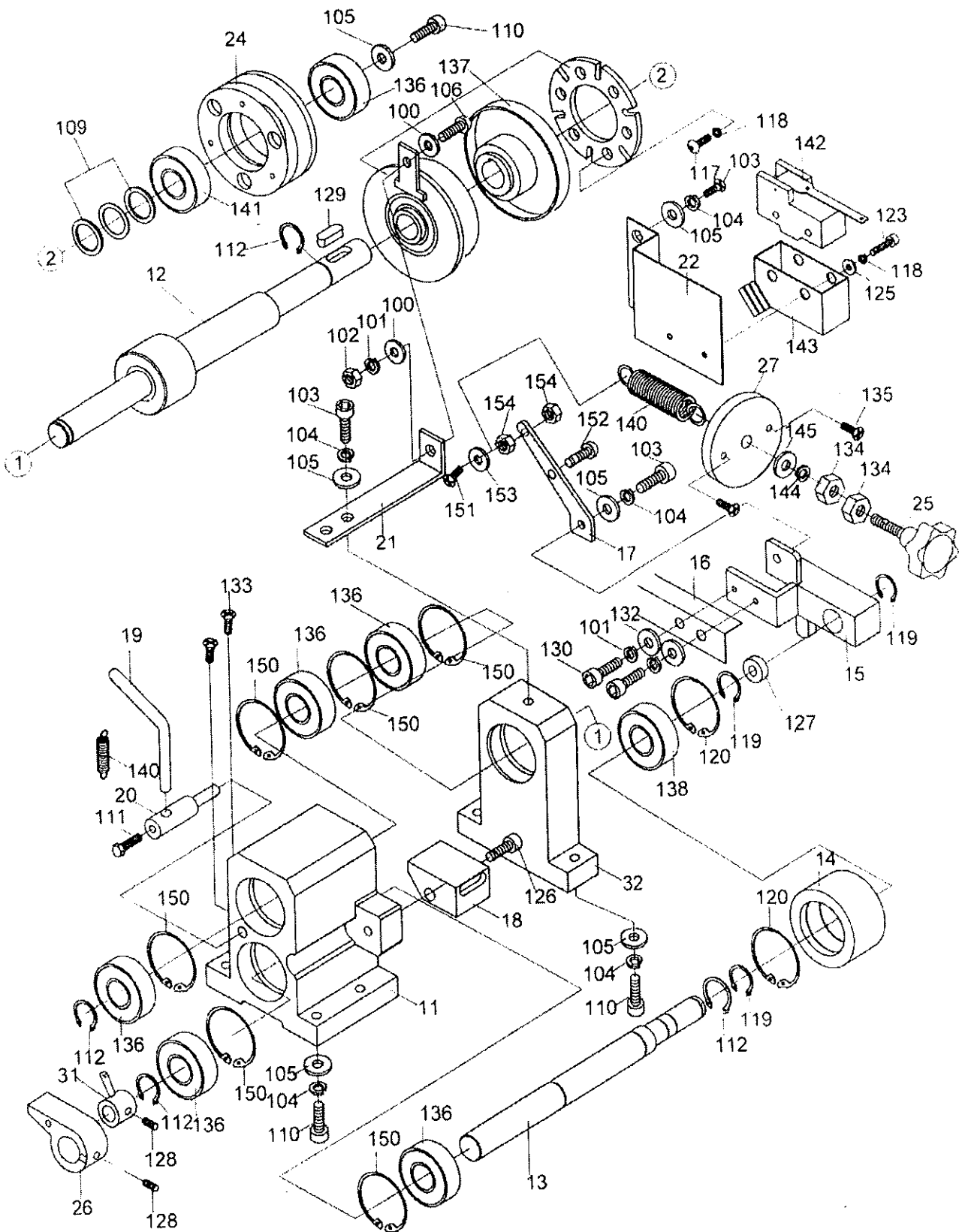


E:\Dw\qzdbzt\Fig.9-2

FIGURE 9-1B ARCH COVER(ALUMINUM ARCH)

## PARTS LIST, FIGURE 10A POOL UNIT

KEY	Q'TY	PART NO.	DESCRIPTION	FPS-100-100A
1	1	3-101109	POOL FEED UNIT, 8-12MM	
1		3-101115	POOL FEED UNIT, 15MM	
11	1	3-10010-110	Pool feed bearing housing	
12	1	3-10110-120	Pool feed roller & shaft	
13	1	3-10010-130	Pool feed lower shaft	
14	1	3-10010-140	Pool feed lower roller	
15	1	3-10010-150	Pool balance bar holder	
16	1	3-10010-1609	Pool balance bar, 9mm	
16		3-10010-1612	Pool balance bar, 12mm	
16		3-10010-1615	Pool balance bar, 15mm	
17	1	3-10010-170	Pool spring arm	
18	1	3-10010-1809	Pool feed shooter, 8-12mm	
18		3-10010-1815	Pool feed shooter, 15mm	
19	1	3-10010-190	Pool adj. spring crook	
20	1	3-10010-200	Pool adj. shaft	
21	1	3-10010-210	Pool clutch holder	
22	1	3-10000-220	Limit switch seat	
24	1	3-10110-240	Clutch pulley	
25	1	3-10010-250	Pool spring adj. bolt	
26	1	3-10010-260	Knob	
27	1	3-10010-270	Pool spring washer	
29	1	3-10010-290	Universal coupling	
31	1	3-10010-310	Pool adj. spring hook	
32	1	3-10110-320	Pool feed bearing housing bracket	
100	2	202A0512	Plain washer, M5*12	
101	3	202B05	Lock washer, M5	
102	1	201A05	Hex nut, M5	
103	5	200A06012	Socket head cap screw, M6*12	
104	11	202B06	Lock washer, M6	
105	12	202A062120	Plain washer, M6*21*2	
106	1	200A05012	Socket head cap screw, M5*12	
109	3	202E152101	Shim, M15*21*0.1	
110	7	200B06020	Plating socket head cap screw, M6*20	
111	1	200C05012	Hex bolt, M5*12	
112	4	212AS15	Ring, S-15	
117	3	200A04008	Socket head cap screw, M4*8	
118	5	202B04	Lock washer, M4	
119	3	212AS12	Ring, S-12	
120	2	212AS32	Ring, S-32	
123	2	200E04025	Phillips head machine screw, M4*25	
125	2	202A0412	Plain washer, M4*12	
126	1	200A06035	Socket head cap screw, M6*35	
127	1	210A6901ZZ	Ball bearing, 6901ZZ	
128	2	200A06010	Socket head cap screw, M6*10	
129	1	213A0505014	Key, 5*5*14	
130	2	200A05008	Socket head cap screw, M5*8	
132	2	202A0513	Plain washer, M5*13	
133	2	200E04012	Phillips head machine screw, M4*12	
134	2	201A08	Hex nut, M8	
135	2	200F05010	Flat head cap screw, M5*10	
136	6	210A6202ZZ	Ball bearing, 6202ZZ	
137	1	102E06	Magnetic clutch CD-E-0.6	
138	1	210A6201ZZ	Ball bearing, 6201ZZ	
140	2	2201015077	Pool spring 1.0*15*77	
141	1	210A6002ZZ	Ball bearing, 6002ZZ	
142	1	104H1701	Cut safety switch TM-1701	
143	1	153C001	Cut safety switch cover AMC-1	
144	1	202B08	Lock washer	
145	1	202A0816	Plain washer, M8*16	
150	6	212AS35	Ring, S-35	
151	1	200A03012	Socket head cap screw, M3*12	
152	1	200A04025	Socket head cap screw, M4*25	
153	1	202A0308	Plain washer, M3*8	
154	2	201A03	Hex nut, M3	



E:\Drw\qzdbzt\Fig.10

FIGURE 10A POOL UNIT

**PARTS LIST, FIGURE 10B POOL UNIT**

**FPS-100-100B**

KEY	QTY	PART NO.	DESCRIPTION
51	1	3-10030-510	Pool box (Front)
52	1	3-10030-520	Back pool (Front)
53	1	3-10030-530	Back pool (Rear)
101	10	200A06035	Socket head cap screw, M6*35
102	10	202A062120	Plain washer, M6*21*2
103	12	202B06	Lock washer, M6
104	10	201A06	Hex nut, M6
105	4	200E04010	Phillips head machine screw, M4*10
106	4	202B04	Lock washer, M4
107	4	202A0412	Plain washer, M4*12
108	2	200A06012	Socket head cap screw, M6*12
109	10	202J0612090	Collar, 9mm
109	10	202J0612120	Collar, 12mm
109	10	202J0612150	Collar, 15mm
110	2	297E0010	Door magnet
112	12	202A061620	Plain washer, M6*16*2

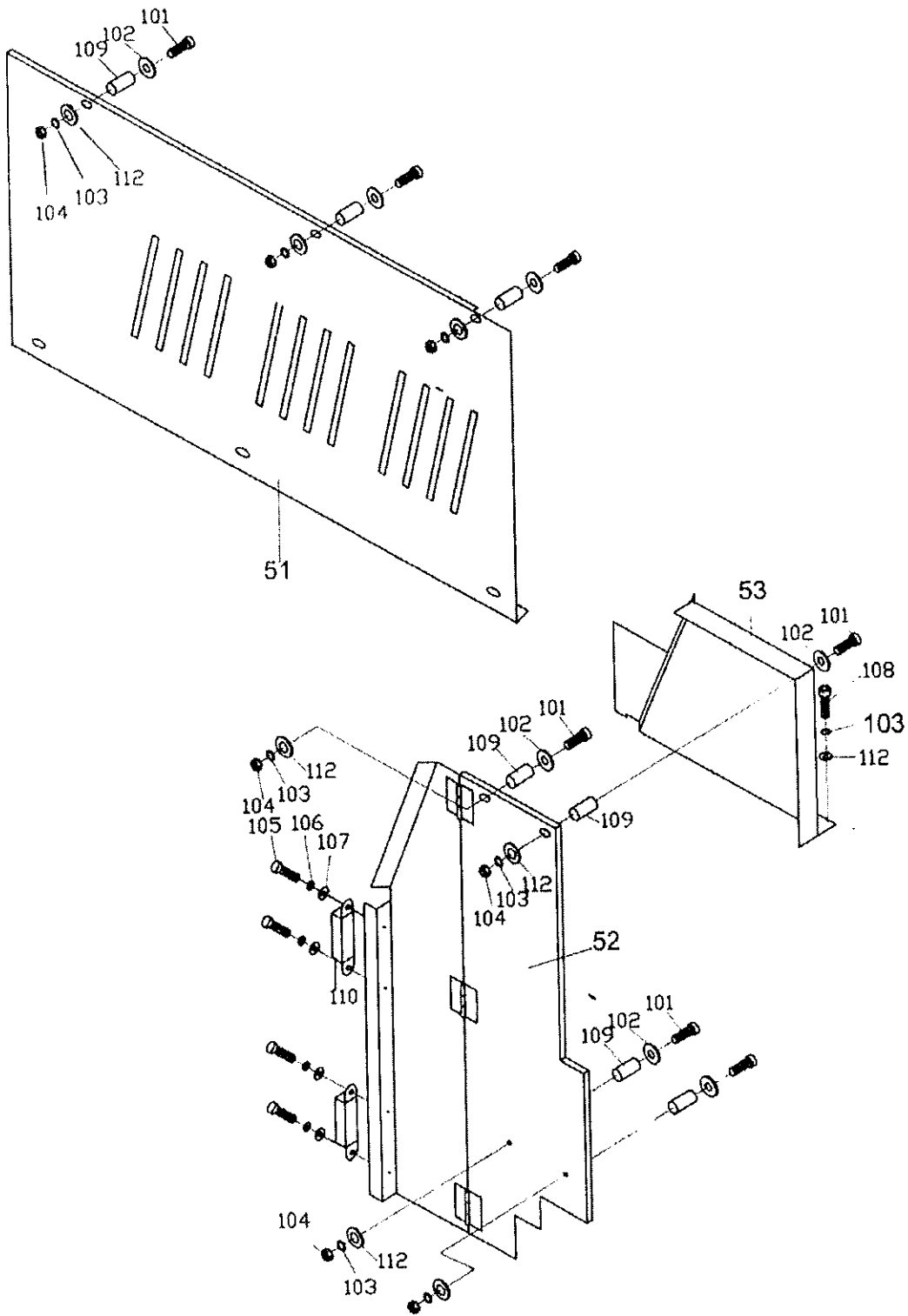
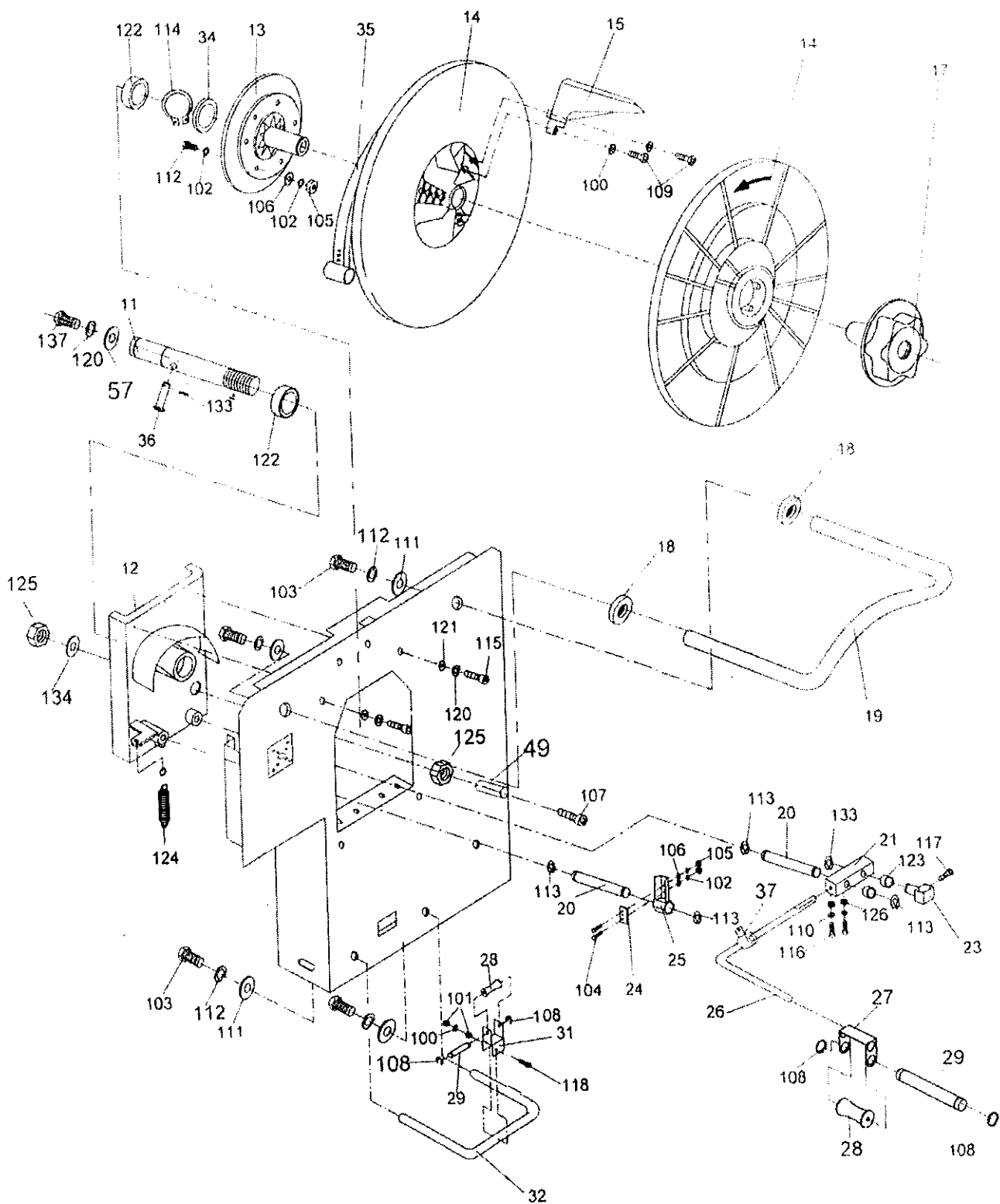


FIGURE 10B POOL UNIT



**PARTS LIST, FIGURE 11 REEL UNIT**

KEY	Q'TY	PART NO.	DESCRIPTION	FPS-101-110
1	1	3-11030	PLASTIC FLANGE UNIT	
2	1	3-11010	BRAKE UNIT	
11	1	3-11000-110	Reel shaft	
12	1	3-11000-120	Reel unit base	
13	1	4-08200-300	Reel brake pulley	
14	2	4-07000-110	Plastic flange	
15	3	4-07000-130	Reel center claw	
17	1	4-07000-192	Reel nut handwheel	
18	2	3-11000-180	Reel guard plate	
19	1	3-11000-190	Reel guard (Upper)	
20	2	3-11010-200	Holder shaft	
21	1	3-11010-210	Brake tension holder	
23	1	3-11010-230	Brake belt tightener	
24	1	4-08200-180	Belt holder plate	
25	1	4-08200-280	Brake belt tightener	
26	1	3-11010-260	Brake arm	
27	1	4-08000-130	Roller frame	
28	2	4-08000-120	Plastic roller	
29	2	4-08000-110	Pin	
31	1	3-11000-310	Angle roller bracket	
32	1	3-11000-320	Reel guard (Down)	
34	1	4-07000-160	Plain washer M40*3	
35	1	3-11000-350	Brake belt	
36	1	4-07000-170	Pin	
37	1	3-11000-370	Moving sleeve	
49	1	3-11000-490	Rubber ring	
49	1	3-11000-490	Rubber ring	
57	1	3-11000-570	End plate	
57	1	3-11000-570	End plate	
100	7	202B06	Lock washer, M6	
101	2	210E1525	Metal Bush, MB1525	
102	14	202B04	Lock washer, M4	
103	4	200C14025	Hex bolt, M14*25	
104	2	200E04025	Phillips head machine screw, M4*25	
105	8	201A04	Hex nut, M4	
106	8	202A0409	Plain washer, M4*9	
107	1	200A08050	Socket head cap screw, M8*50	
108	4	212AE06	Ring, E-6	
109	6	200A06020	Socket head cap screw, M6*20	
110	2	202B05	Lock washer, M5	
111	4	202A1423	Plain washer, M14*23	
112	10	202B14	Lock washer, M14	
113	5	212AE12	Ring, E-12	
114	1	212AE19	Ring, E-19	
115	4	200A08025	Socket head cap screw M8*25	
116	2	200A05025	Socket head cap screw, M5*25	
117	1	200A05020	Socket head cap screw, M5*20	
118	1	200A06035	Socket head cap screw, M6*35	
120	5	202B08	Lock washer	
121	4	202A0818	Plain washer $\varnothing$ 8*18*2	
122	2	210A6205ZZ	Ball bearing, 6205ZZ	
123	2	210E1525	Metal Bush, MB1525	
124	1	2201014075	Brake arm spring 1.0*14*75	
125	2	201A08	Hex nut, M8	
126	2	201A05	Hex nut, M5	
133	1	212CR8	Spring pin-CR8	
134	1	202B08	Lock washer	
137	1	200C08020	Hex bolt, M8*20	

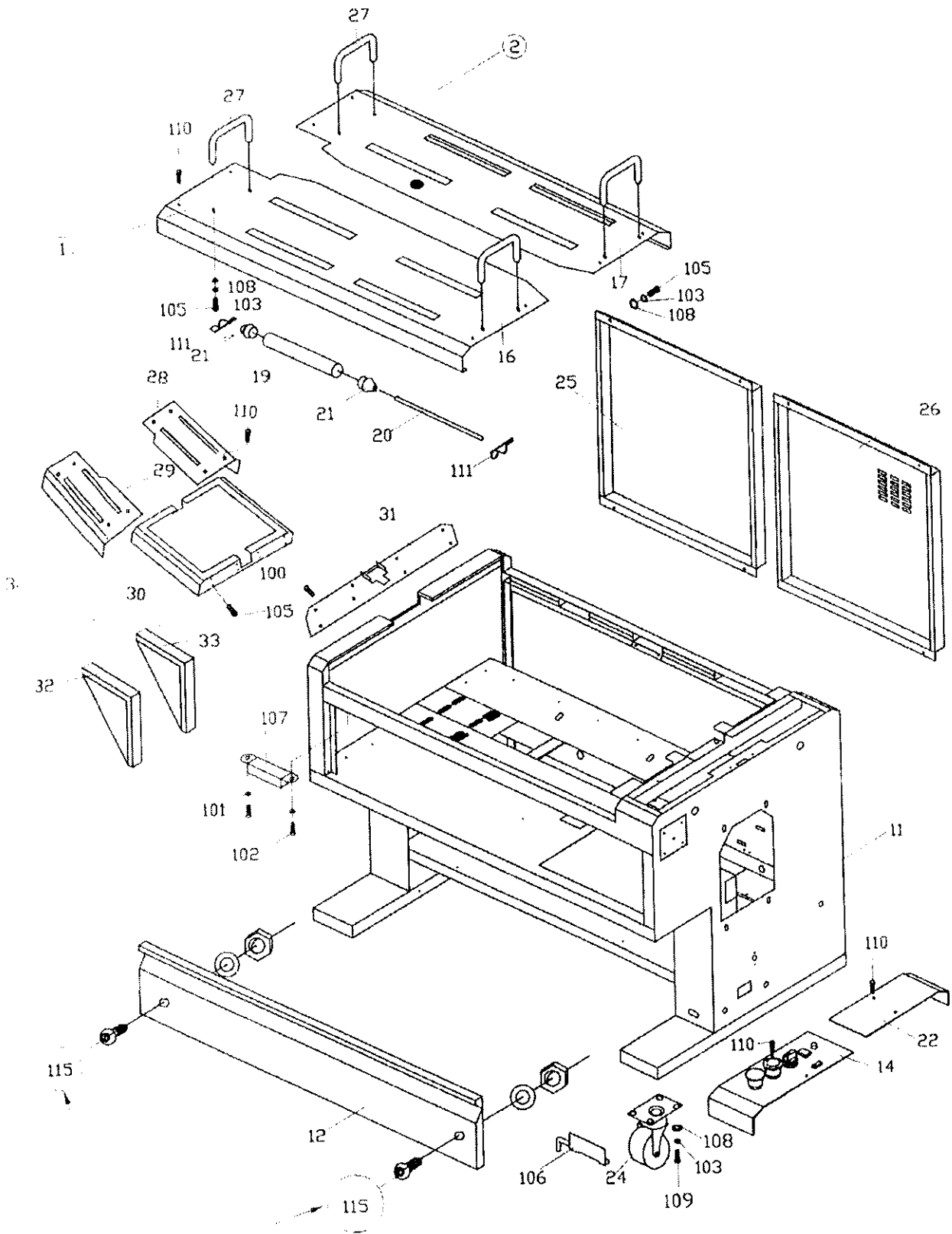


E:\Drw\qzdbzt\Fig.11

Fig.11 REEL UNIT

**PARTS LIST, FIGURE 12 BODY UNIT**

KEY	Q'TY	PART NO.	DESCRIPTION	FPS-101-120
1	1	3-12010	UPPER TABLE UNIT (FRONT)	
1	1	3-12011	UPPER TABLE UNIT (FRONT, FOR DILATED ARCH)	
1	1	3-12012	UPPER TABLE UNIT (FRONT, FOR ARCH W650MM)	
2	1	3-12020	UPPER TABLE UNIT (REAR)	
2	1	3-12021	UPPER TABLE UNIT (REAR, FOR DILATED ARCH)	
2	1	3-12022	UPPER TABLE UNIT (REAR, FOR ARCH W650MM)	
3	1	3-12030	DILATED TABLE UNIT, 200mm	
3	1	3-12031	DILATED TABLE UNIT, 400mm	
3	1	3-12032	DILATED TABLE UNIT, 600mm	
11	1	3-12000-110	Body	
12	1	3-12000-120	Front door	
14	1	3-12000-140	Control panel	
16	1	3-12010-160	Upper table (Front)	
16		3-12011-160	Upper table (Front, for dilated arch)	
16		3-12012-160	Upper table (Front, for arch W650mm)	
17	1	3-12020-170	Upper table (Rear)	
17		3-12021-170	Upper table (Rear, for dilated arch)	
17		3-12022-170	Upper table (Rear, for arch W650mm)	
19	8	3-12000-190	Table roller	
20	8	3-12000-200	Table roller shaft	
21	16	3-12000-220	Cover (L type)	
22	1	3-12000-220	Cover (L type)	
24	2	229A075PU-BK	Wheel, swivel 75mm	
24	2	229C075PU-BK	Wheel fixed 75mm	
25	1	3-12000-250	Rear panel (LR.)	
26	1	3-12000-260	Rear panel (RR.)	
27	4	3-12000-270	Steel package stop	
28	1	3-12030-280	Dilated upper table (Rear), 200mm	
28		3-12031-280	Dilated upper table (Rear), 400mm	
28		3-12032-280	Dilated upper table (Rear), 600mm	
29	1	3-12030-290	Dilated upper table (Front), 200mm	
29		3-12031-290	Dilated upper table (Front), 400mm	
29		3-12032-290	Dilated upper table (Front), 600mm	
30	1	3-12030-300	Added easel shelf, 200mm	
30		3-12031-300	Added easel shelf, 400mm	
30		3-12032-300	Added easel shelf, 600mm	
31	1	3-12000-310	Side apron	
31		3-12000-311	Side apron, for arch W650mm	
32	1	3-12031-320	Trigonal bracket (front), 400mm	
32		3-12032-320	Trigonal bracket (front), 600mm	
33	1	3-12031-330	Trigonal bracket (rear), 400mm	
33		3-12032-330	Trigonal bracket (rear), 600mm	
100	8	200H06012	Truss head machine screw, M6*12	
101	8	202A0412	Plain washer, M4*12	
102	8	200E04008	Phillips head machine screw, M4*8	
103	32	202B06	Lock washer, M6	
105	24	200B06012	Plating socket head cap screw, M6*12	
106	2	297C001	Door holder	
107	4	297E0010	Door magnet	
108	32	202A0612	Plain washer, M6*12	
109	16	200M06012	Hex bolt with washer, M6*12	
110	20	200H05012	Truss head machine screw, M5*12	
111	16	211C001	Ringent pin	
115	2	297E3010	Lock	

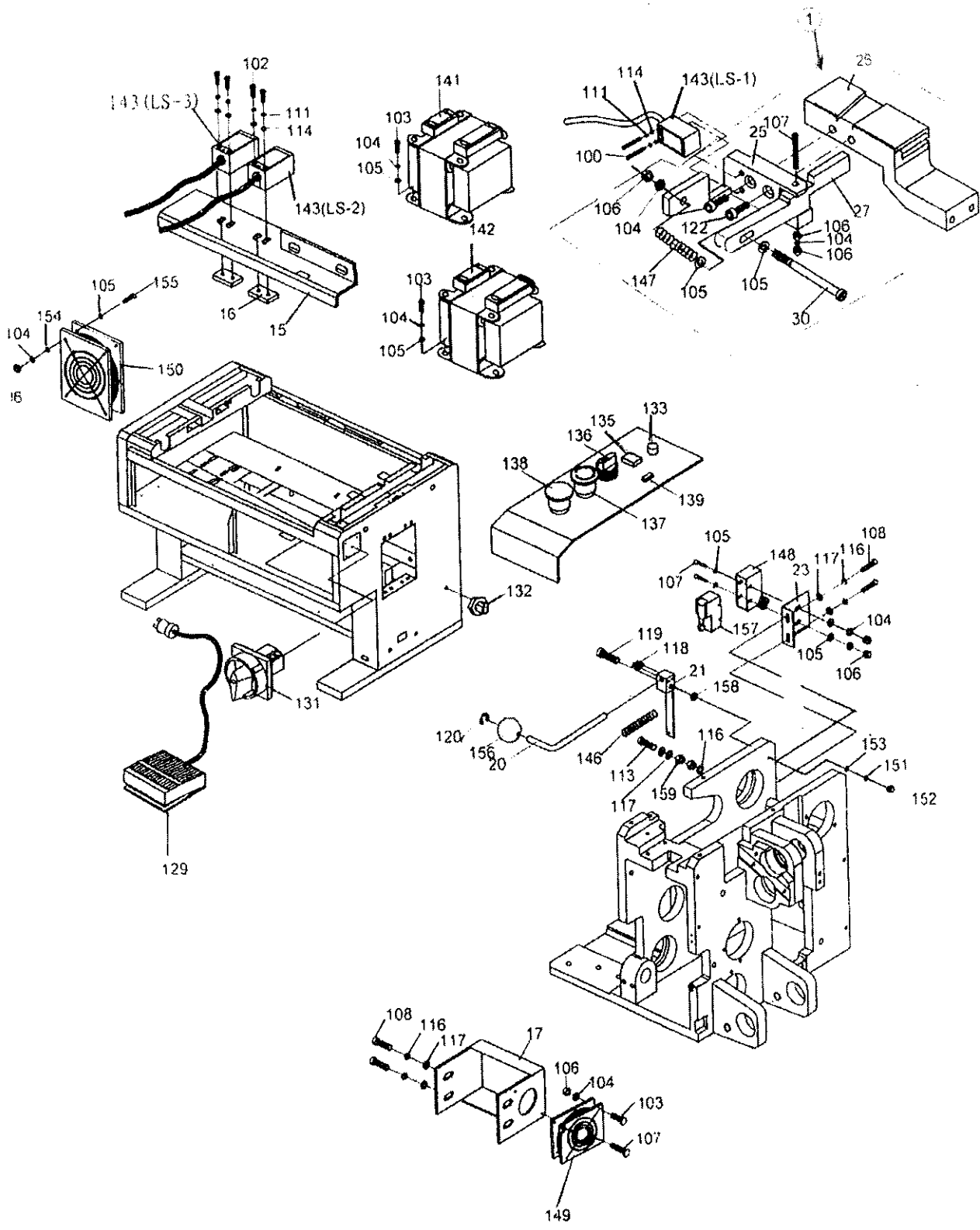


As required by customers

FIGURE 12 BODY UNIT

**PARTS LIST, FIGURE 13 ELECTRIC UNIT (PROXIMITY SWITCH TYPE)**

KEY	Q'TY	PART NO.	DESCRIPTION	FPS-100-130
1	1	3-13010	STRAP END SENSOR	
15	1	3-13000-150	Proximity switch bracket	
16	2	3-13000-160	Proximity bracket guide	
17	1	3-13000-170	Collect some box	
20	1	3-13000-200	Switch arm	
21	1	3-13000-210	Switch arm bracket	
22	1	3-13000-220	Switch adj. guide	
23	1	3-13000-230	Switch seat	
25	1	3-13010-250	Proximity seat	
26	1	3-13010-260	Band guide	
27	1	3-13010-270	Proximity lever	
30	1	3-13010-300	Screw	
100	2	200E03025	Phillips head machine screw, M3*25	
102	4	200E03030	Phillips head machine screw, M3*30	
103	10	200E04010	Phillips head machine screw, M4*10	
104	18	202B04	Lock washer, M4	
105	18	202A0412	Plain washer, M4*12	
106	11	201A04	Hex nut, M4	
107	5	200E04030	Phillips head machine screw, M4*30	
108	4	200B05012	Plating socket head cap screw, M5*12	
109	1	202B06	Lock washer, M6	
111	6	202B03	Lock washer, M3	
113	1	200A05025	Socket head cap screw, M5*25	
114	6	202A0308	Plain washer, M3*8	
116	5	202B05	Lock washer, M5	
117	6	202A0512	Plain washer, M5*12	
118	2	200G05008	Socket head set screw, M5*8	
119	1	200A08050	Socket head cap screw, M8*50	
120	1	212AE08	Ring, E-8	
122	2	200A04010	Socket head cap screw, M4*10	
129	1	104N001	Foot switch, TFS-201	
131	1	104C001	Main power switch, GN20 H-06-40U06,15A/600VAC	
132	1	153G82	Cord connector	
133	1	109A005	Indicator light	
135	1	104F101	Reset button T16-BL	
136	1	104L001	Toggle switch ZB2-BD5	
137	1	104K001	Stop button ZB2-BS54-R	
138	1	104F201	Start button ZB2-BC3-G	
139	1	104M001	Throwback switch	
141	1	103B0028150	Transformer, 28V/150VA	
142	1	103A0006200	Instant heating transformer, 6V/200VA	
143	3	104J001	Proximity switch PS-05N	
146	1	2210709047	Switch arm spring 0.7*9*47	
147	1	2210305052	Proximity lever press spring, 0.3*5*52	
148	1	153C001	Cut safety switch cover AMC-1	
149	1	116AD024	Smoke fan, 24VDC 80*80	
150	1	116BA110	Smoke fan, 110-120VAC 50/60HZ 120*120	
150	1	116BA220	Smoke fan, 220-240VAC 50/60HZ 120*120	
151	1	202B08	Lock washer	
152	1	201A08	Hex nut, M8	
153	1	202A0812	Plain washer, M8*12	
154	4	202A0409	Plain washer, M4*9	
155	4	200E04050	Phillips head machine screw, M4*50	
156	1	227BB-4010	Grip ball(Black)	
157	1	104H1703	Cut safety switch TM-1703	
158	1	202A082230	Plain washer, M8*22*3	
159	2	201A05	Hex nut, M5	



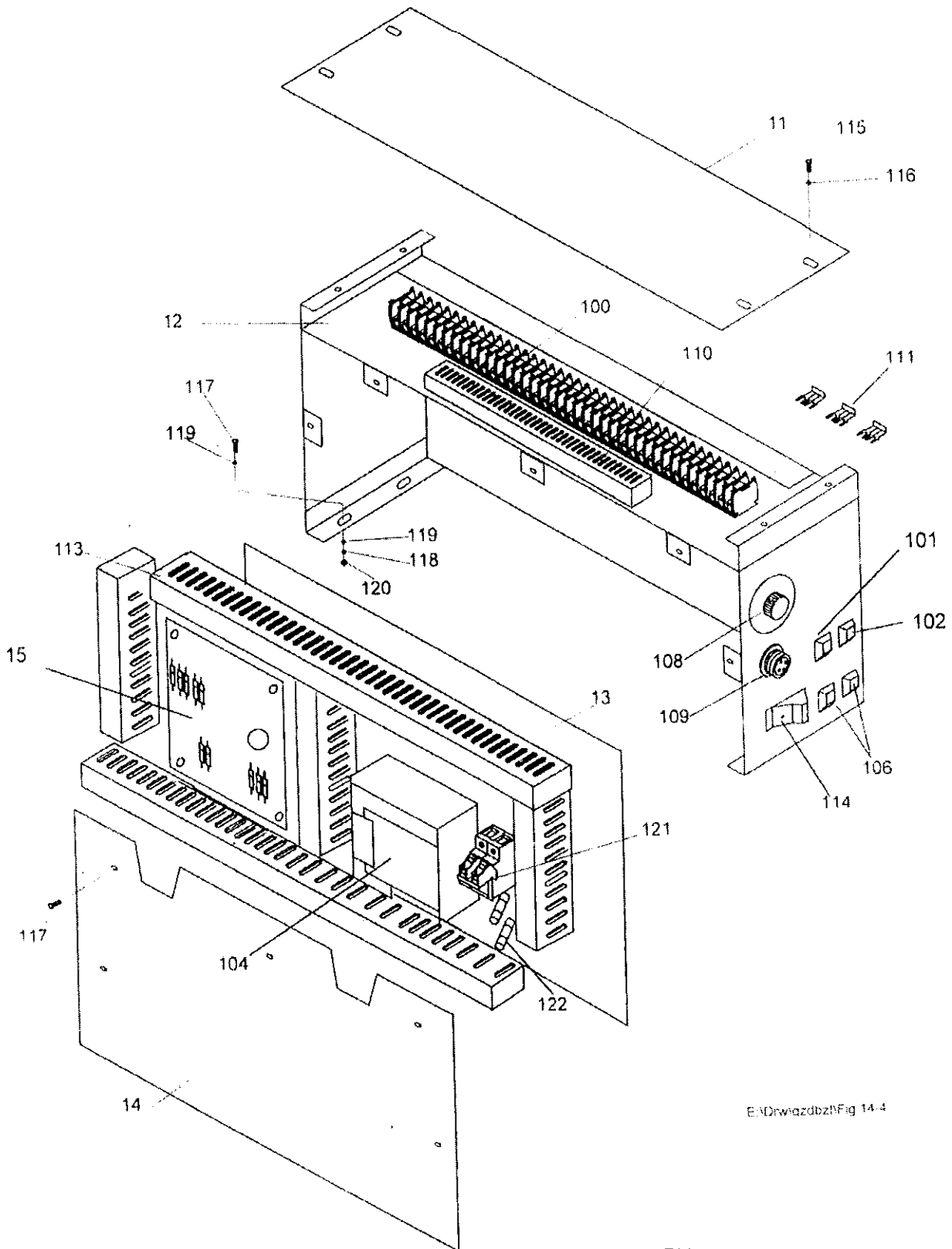
E:\Drw\qzdbzt\Fig.13

FIGURE 13 ELECTRIC UNIT (PROXIMITY SWITCH TYPE)

**PARTS LIST, FIGURE 14-4 CONTROL BOX UNIT (PLC,SINGLE PHASE)**

KEY	Q'TY	PART NO.	DESCRIPTION	FPS-100-144
11	1	3-14000-110	Control box top cover, 85#	
12	1	3-14000-120	Control box, 85#	
13	1	3-14000-130	Control box base, 85#	
14	1	3-14000-140	Control box cover, 85#	
15	1	PC-FP-30D01	ASSE.FP-30D01,110-240V/50-60Hz1Ph	
100	1	152P001	Terminal bracket, 34P	
101	1	115C0202	Circuit Protector, ZE-800, 2A, 250V50/60Hz	
101	1	115C0402	Circuit Protector, ZE-800, 4A, 250V50/60Hz	
102	1	115C0402	Circuit Protector, ZE-800, 4A, 250V50/60Hz	
102	1	115C0402	Circuit Protector, ZE-800, 4A, 250V50/60Hz	
104	1	105G014	VIGOR-PLC,VBO-14MR-A	
106	2	115C0802	Circuit Protector, ZE-800, 8A, 250V50/60Hz	
106	2	115C1502	Circuit Protector, ZE-800, 15A, 250V50/60Hz	
108	1	134A06	Heater temperature adj. 110V	
108	1	134A07	Heater temperature adj. 220V	
109	1	152N001	Foot switch socket	
110	2	153F2520	Wire track 25*20mm	
111	3	152R001	Terminal guide, 3U	
113	3	153F2535	Wire track 25*35mm	
114	1	104M001	Throwback switch	
115	4	200H06012	Truss head machine screw, M6*12	
116	4	202A0612	Plain washer, M6*12	
117	9	200B05012	Plating socket head cap screw, M5*12	
118	4	202B05	Lock washer, M5	
119	8	202A0512	Plain washer, M5*12	
120	4	201A05	Hex nut, M5	
121	2	115N002	Fuse seat, HG30-32	
122	2	115B3816	Fuse, 16A, 38mm(For 220-240V)	
122	2	115B3825	Fuse, 25A, 38mm(For 110V)	

Fig. 14-4 CONTROL BOX UNIT (PLC & TIMER)



ENDrwiqzdbz\Fig 14-4

59 (FOR 1-Ph)

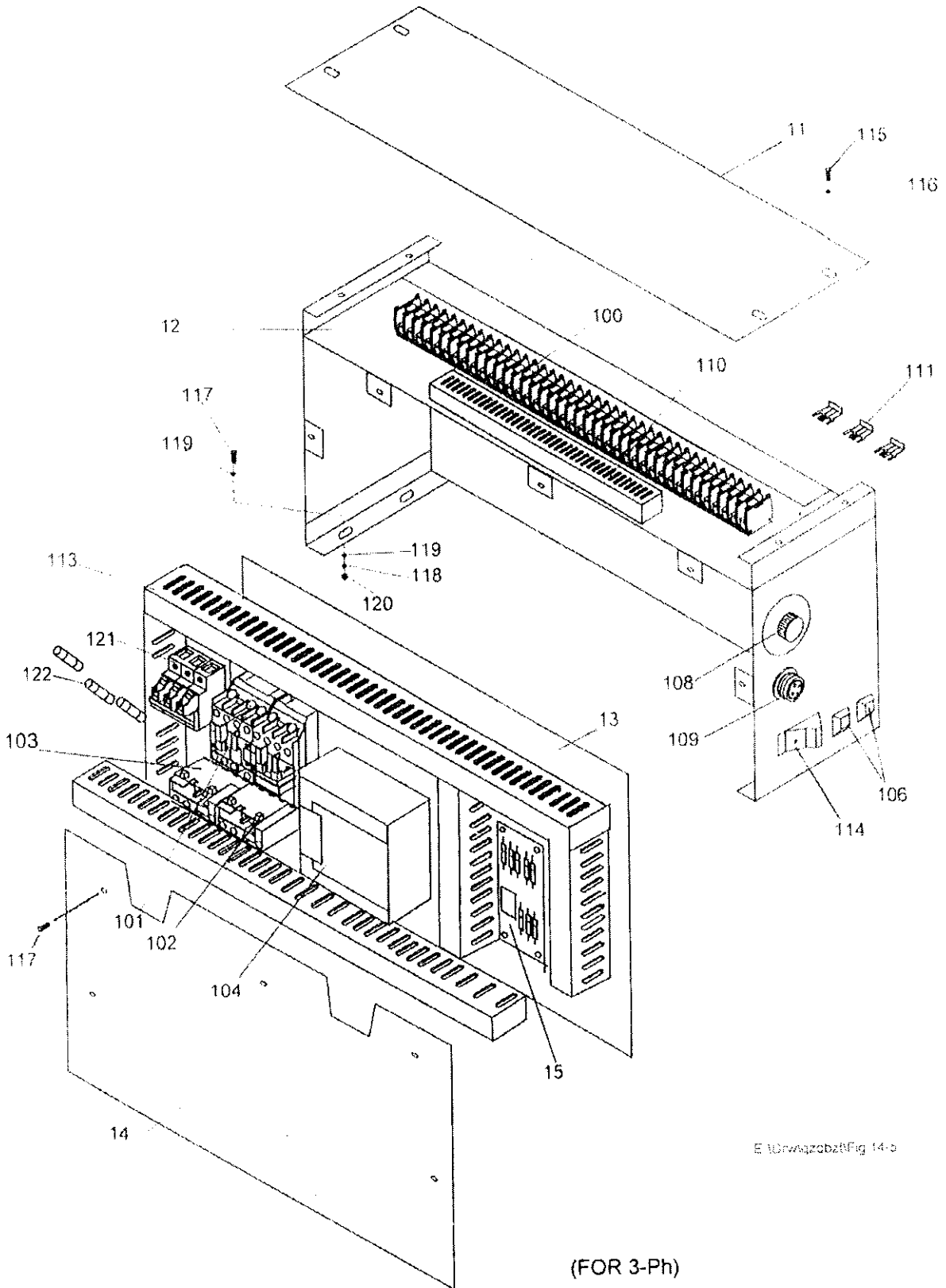


**PARTS LIST, FIGURE 14-5 CONTROL BOX UNIT (PLC,3-PHASE)**

**FPS-100-145**

KEY	Q'TY	PART NO.	DESCRIPTION
11	1	3-14000-110	Control box top cover, 85#
12	1	3-14000-120	Control box, 85#
13	1	3-14000-130	Control box base, 85#
14	1	3-14000-140	Control box cover, 85#
15	1	PC-FP-30D01	ASSE.FP-30D01,110-240V/50-60Hz1Ph
100	1	152P001	Terminal bracket, 34P
101	2	106A0610024	Contactor, LC1-D0610-24V (for 220-240V)
102	1	106E130501	Over-load relay, LR2 D1305-N 0.63-1A(For 380V3PH)
103	1	106E1306016	Over-load relay, LR2 D1306-N 1-1.6A
104	1	105G014	VIGOR-PLC,VBO-14MR-A
106	2	115C0402	Circuit Protector, ZE-800, 4A, 250V50/60Hz
108	1	134A07	Heater temperature adj. 220V
109	1	152N001	Foot switch socket
110	2	153F2520	Wire track 25*20mm
111	3	152R001	Terminal guide, 3U
113	3	153F2535	Wire track 25*35mm
114	1	104M001	Throwback switch
115	4	200H06012	Truss head machine screw, M6*12
116	4	202A0612	Plain washer, M6*12
117	9	200B05012	Plating socket head cap screw, M5*12
118	4	202B05	Lock washer, M5
119	8	202A0512	Plain washer, M5*12
120	4	201A05	Hex nut, M5
121	3	115N002	Fuse seat, HG30-32
122	3	115B3810	Fuse, 10A , 38mm

Fig. 14-5 CONTROL BOX UNIT (PLC & TIMER)

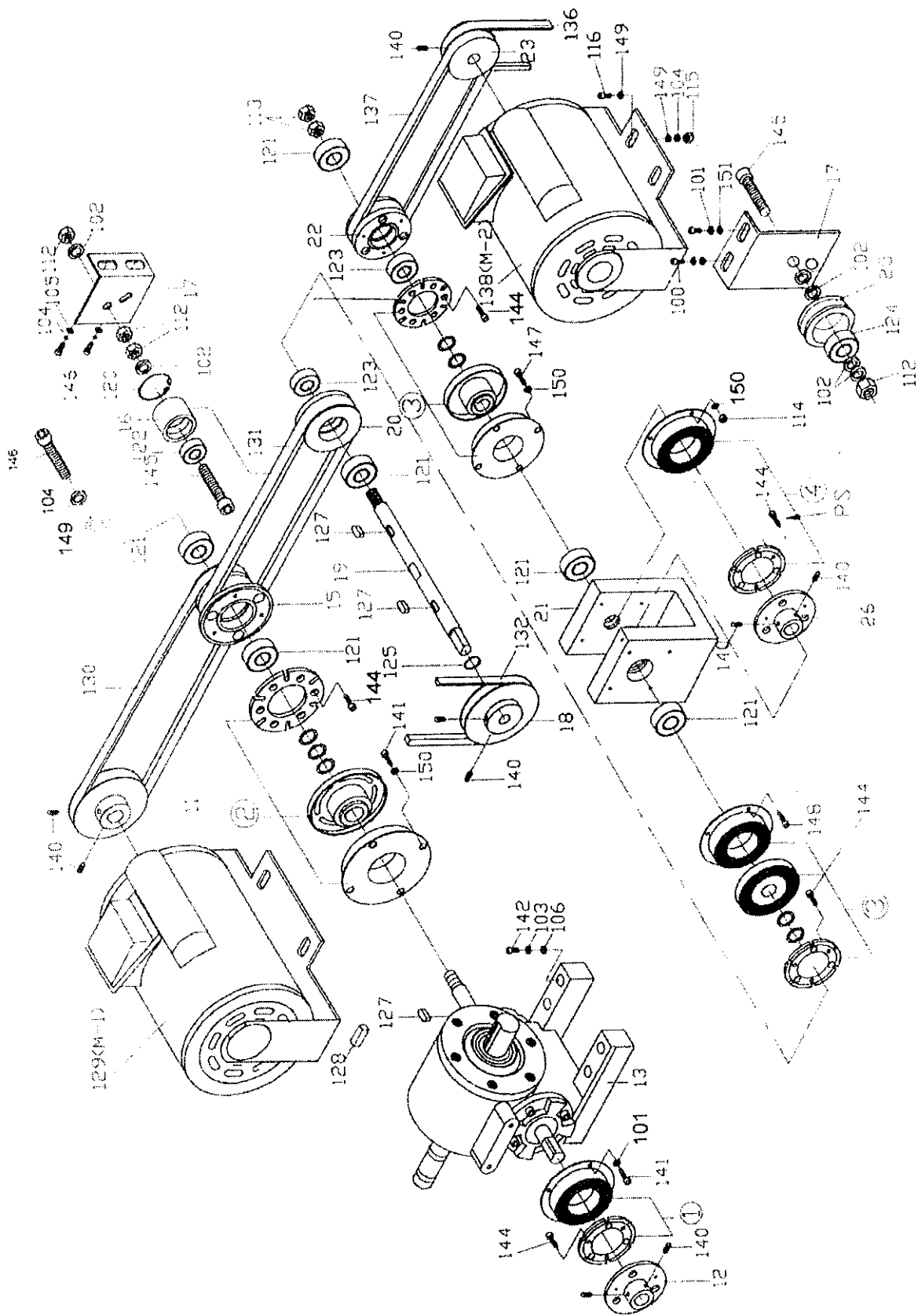


E:\09wqzobz\Fig 14-5

**PARTS LIST, FIGURE 15-2 DRIVE UNIT (SINGLE PHASE)**

**FPS-100-152**

KEY	Q'TY	PART NO.	DESCRIPTION
1	1	102G15	Magnetic brake CD-G-1.5
2	1	102F15	Magnetic clutch CD-F-1.5
3	2	102F06	Magnetic clutch CD-F-0.6
4	1	102G06	Magnetic brake CD-G-0.6
11	1	3-15000-110	Timing motor pulley A84
12	1	3-15000-120	Brake pulley, 08
13	1	3-15000-130	Gear box
15	1	3-15000-150	Gear box pulley
16	1	3-15000-160	Feeding roller (Single phase)
17	1	3-15000-170	Roller fixed seat (Single phase)
18	1	3-15000-180	Feed pulley $\phi$ 86
19	1	3-15000-190	Drive shaft $\phi$ 15X230
20	1	3-15000-200	Clutch pulley CP2
21	1	3-15000-210	Bearing fixed seat
22	1	3-15000-220	Clutch pulley CP1
23	1	3-15200-230	Pool motor pulley(double)
25	1	3-15000-250	Pulley
26	1	3-15000-260	Brake pulley, 06
100	2	200A05016	Socket head cap screw, M5*16
101	2	202B05	Lock washer, M5
102	6	202B10	Lock washer, M10
103	4	202B08	Lock washer
104	7	202B06	Lock washer, M6
105	2	202A061620	Plain washer, M6*16*2
106	4	202A0816	Plain washer, M8*16
112	4	201A10	Hex nut, M10
113	2	201A12	Hex nut, M12
114	4	201A04	Hex nut, M4
115	4	201A06	Hex nut, M6
116	4	200A06025	Socket head cap screw, M6*25
120	1	212AR30	Ring, R-30
121	6	210A6202ZZ	Ball bearing, 6202ZZ
122	1	210A6200ZZ	Ball bearing, 6200ZZ
123	2	210A6000ZZ	Ball bearing, 6000ZZ
124	1	210A6300ZZ	Ball bearing, 6300ZZ
125	1	212AR15	Ring, R-15
127	3	213A0505015	Key, 5*5*15
128	1	213A0707023	Key, 7*7*23
129	1	101A1160037	Motor, 1PH 110/220V60Hz 1/2HP
129		101A2350037	Motor, 1PH 220/230V50Hz 1/2HP
129		101A2450037	Motor, 1PH 240V50Hz 1/2HP
130	1	214B3260	Teeth belt, 3260
131	1	214B3340	Teeth belt, 3340
132	1	214AK019	V-belt, K-19
136	1	214AM042	V-belt, M-42 (JR)
137	1	214B2240	Teeth belt, 2240
138	1	101A1160025	Motor, 1PH 110/220V60Hz 1/3HP
138		101A2350025	Motor, 1PH 220/230V50Hz 1/3HP
138		101A2450025	Motor, 1PH 240V50Hz 1/3HP
140	9	200G06010	Socket head set screw, M6*10
141	8	200E04010	Phillips head machine screw, M4*10
142	4	200A08035	Socket head cap screw, M8*35
144	15	200E04010	Phillips head machine screw, M4*10
145	2	200B10050	Plating socket head cap screw, M10*50
146	3	200A06020	Socket head cap screw, M6*20
147	4	200E04030	Phillips head machine screw, M4*30
148	4	200A04016	Socket head cap screw, M4*16
149	9	202A062120	Plain washer, M6*21*2
150	16	202B04	Lock washer, M4
151	2	202A0512	Plain washer, M5*12



PS: KEY NO 1 & 12 ARE ADAPTED TO SPECIAL MACHINE ONLY

Fig. 15-2 DRIVE UNIT (SINGLE PHASE)



## CAUTION

Before plugging in, open the operating cover/table and take out the anti-rusty bag and the drier laid on the sealer unit

255S-101-EN01-0404