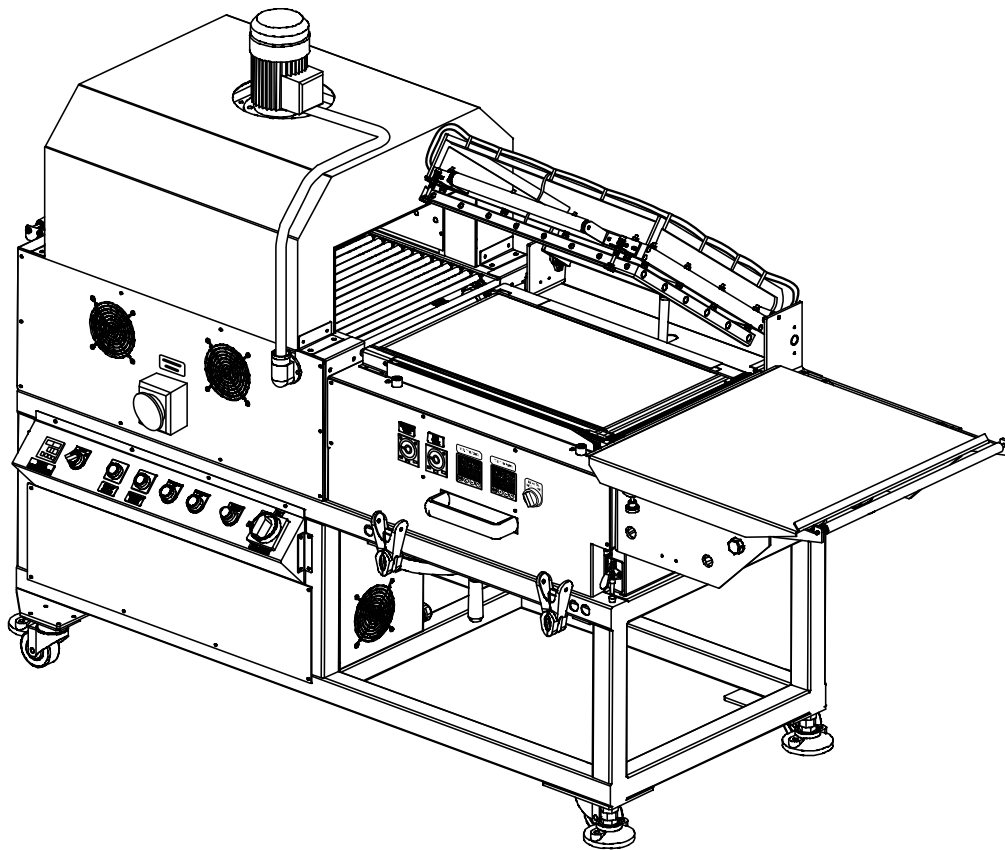


VS1620TK

**Hot-Knife L-Sealer & Tunnel Combo
Value Series**

User Guide



EASTEY[®]

VS1620TK

Hot-Knife L-Sealer & Heat Tunnel Combo Value Series

User Guide

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Safety

Always disconnect electrical power before attempting maintenance to any electrical or moving parts. Do not tamper with electrical wiring.

Keep hands away from moving conveyors and assemblies.

Never operate this or any moving equipment without all covers and guards in place.

Do not increase the factory settings on either the mechanical or electrical overload devices.

Do not make any modifications to either the electrical circuitry or the mechanical assemblies of this machinery.

Heat sealing equipment can become very hot after a period of use. Keep hands away from hot surfaces if the machine is in operation or has been running recently.

Adequate ventilation should be provided at all times. The use of certain types of plastic film in sealing or shrinking equipment may result in the release of hazardous fumes due to the result of degradation of the film at high temperatures. Before using any plastic film in this equipment, the manufacturer or supplier of the film should be contacted for specific information concerning the potential release of hazardous fumes.

Explanation of Symbols



Caution sign or Safety Alert symbol. Indicates caution, be alert, Your safety is involved. Knowledge of safe operation is required.



Ground symbol. Indicates ground. Use Class-3 (lower than 1000hms) cable to ground to earth. Incomplete grounding may lead to electrical shock.



Electrical hazard. Indicates electrical danger. Only a trained electrician can uncover the electrical panel or box.



Pinch hazard. Do not put your hands or any object on the moving mechanism. Shut down the machine before doing any maintenance, repair, or adjustment.



Crush hazard. Do not put your hands or any object on the moving mechanism. Shut down the machine before performing maintenance, repair, or adjustment.



High temperature hazard. Do not touch or place hands close to the heating source to avoid burns. Proceed with any maintenance only when the temperature of the heater or other heat source has cooled down to room temperature.



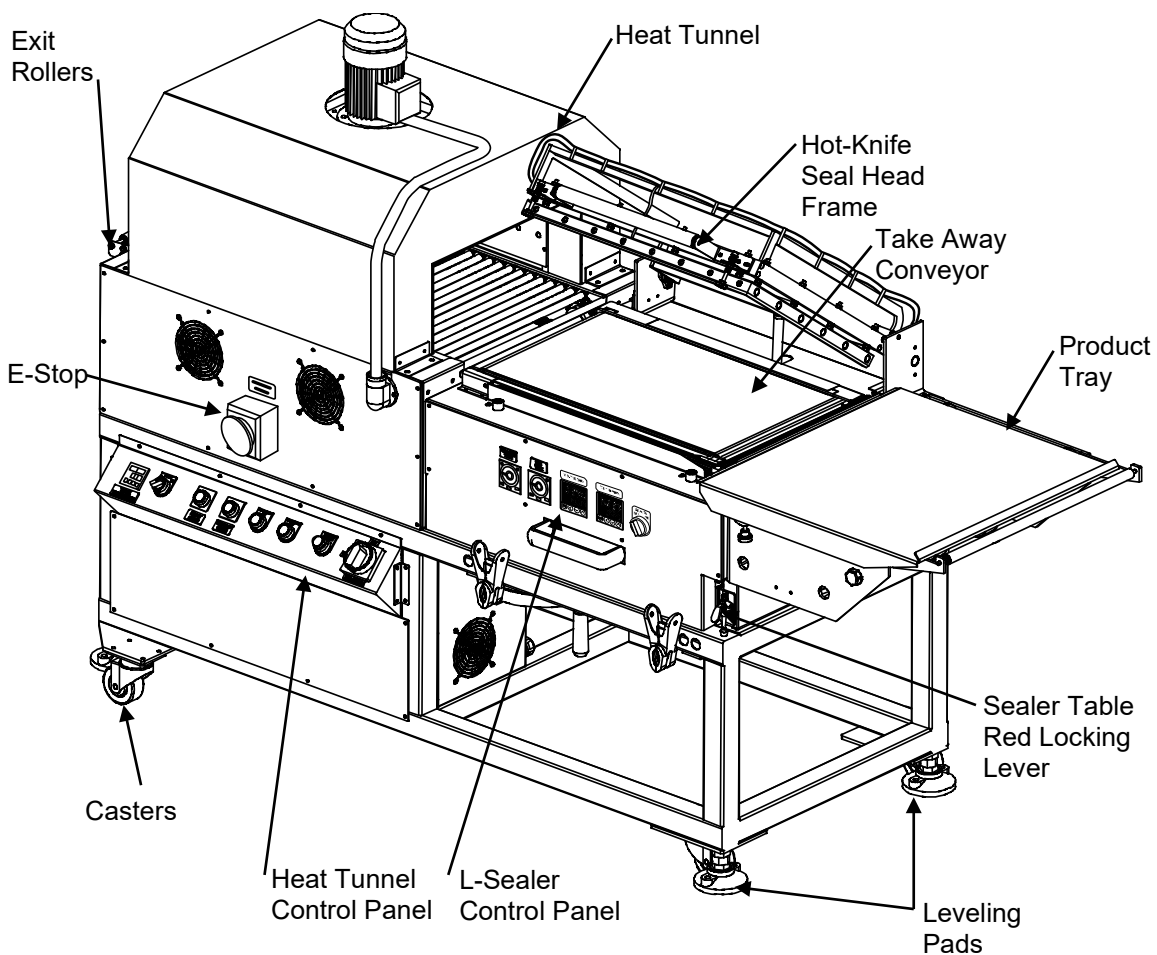
Moisture hazard. Keep equipment dry. This equipment is designed for indoor operation in a typical clean, dry factory environment, protected from rain and moisture. Do not operate the machine in any extremely wet or oily environment that may exceed operating specifications.

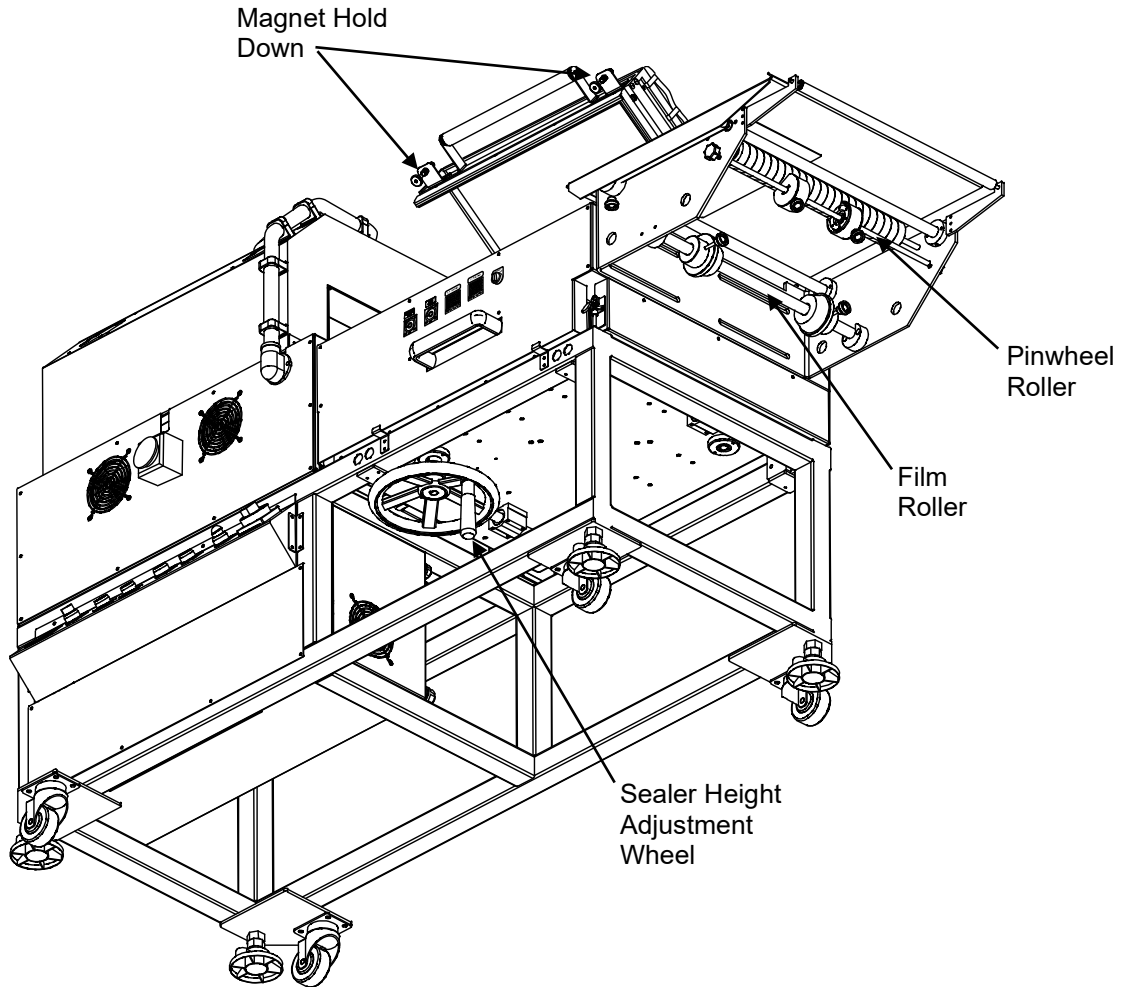
Introduction

VS1620TK Hot-Knife L-Sealer and Heat Tunnel Combo

The Easteys VS1620TK Hot-Knife L-Sealer and Heat Tunnel Combo will seal and shrink wrap a variety of products all on one frame. It is designed to be very easy to set up and operate.

System Overview



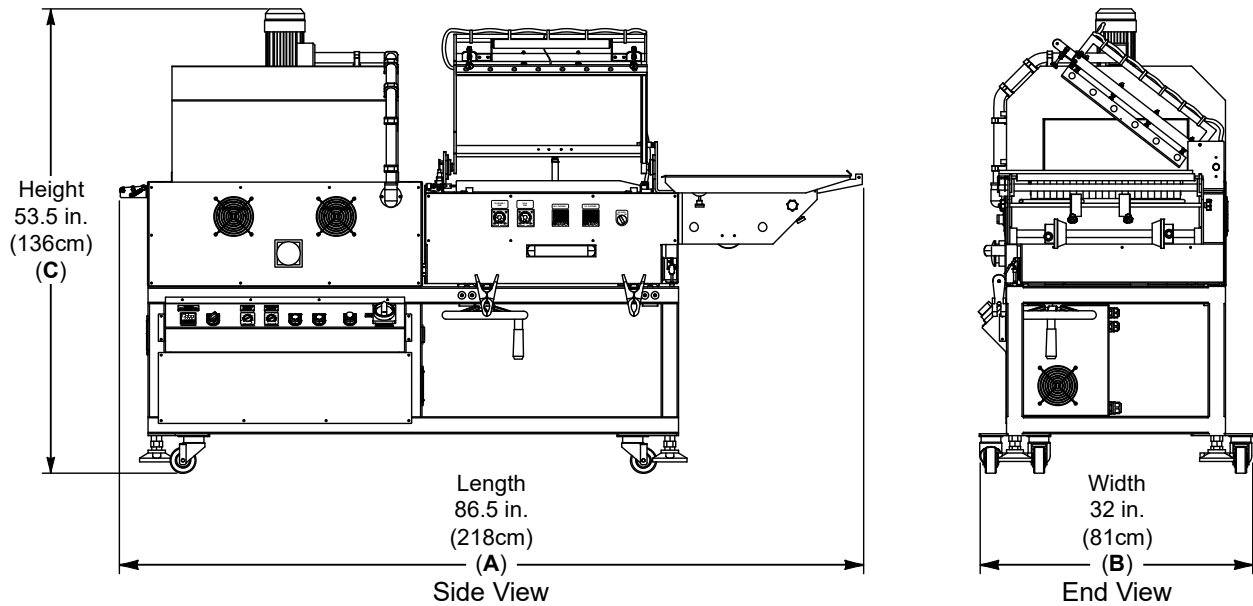


Specifications

Specification	Details
Film Material	Polyolefin, or PVC Shrink Film 8 in. (20cm) – 18 in. (45cm) width
Power Requirements	220VAC 50/60Hz 30 Amps Single Phase
Machine Weight	650 lbs. (295kg)
Shipping Weight	750 lbs. (340kg)

Dimensions

Dimensions are shown in inches (and centimeters).



Specification	Details
Machine Dimensions	Length (A) = 86.5 in (218cm) Width (B) = 32 in. (81cm) Height (C) = 53.25 in (134cm)
Tunnel Chamber Dimensions	Length = 26 in (66cm) Width = 16 in. (41cm) Height = 7 in (18cm)
Conveyor Dimensions	Length = 24 in. (61cm) Width = 13.5 in. (34cm)

Installation and Set Up

Unpacking

Carefully unpack the Eastey Hot-Knife L-Sealer and Heat Tunnel Combo unit from the shipping carton.

Remove the shipping bolts and straps that secure the L-Sealer and Heat Tunnel Combo unit to the shipping pallet. Remove the product tray and lift the L-Sealer and Heat Tunnel Combo unit off the pallet.

Attention! The Eastey L-Sealer and Tunnel Combo is a very heavy piece of equipment and will require a forklift or several people to move safely off the shipping pallet.

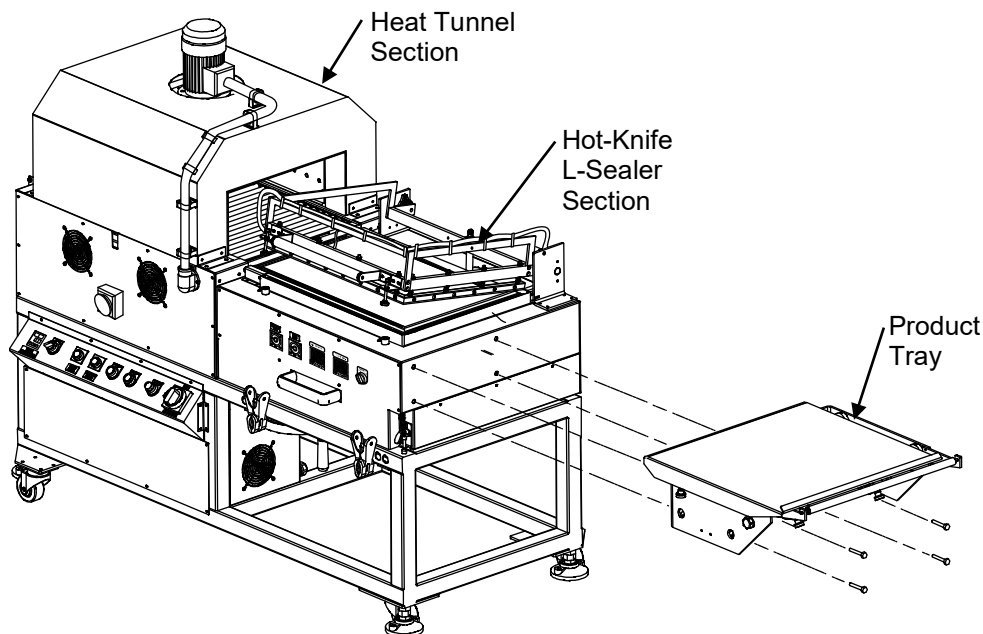
For shipping purposes, the product tray has been disassembled from the L-Sealer.

Assembly

The Eastey VS1620TK Hot-Knife L-Sealer and Heat Tunnel unit has been assembled at the factory and requires very little assembly.

Product Tray

The product tray contains both the film roller and the perforating pinwheel. The product tray has been disassembled from the sealer for shipping. There are four (4) bolts that are used to mount the product tray. Use the provided hardware to attach the product tray to the infeed end of the L-sealer.



Power Cord

The Eastey L-Sealer and Heat Tunnel combo can be used in a variety of locations. To allow the option of hard wiring the power cord into an existing electrical panel, the combo unit is shipped without a three-pronged plug attached to the power cord. If the combo unit is going to be used with a typical three-pronged outlet attach a certified and approved three-pronged plug to the power cord.

Attention! Ensure that any wiring complies with all electrical wiring codes and specifications that apply to the installation location.

Location Requirements

There are four casters located on the bottom of the L-sealer and heat tunnel combo unit to help in moving the machine. When the combo unit is in the operating location adjust the four leveling pads for correct height.

When installing the combo unit please be aware of the following considerations:

1. The mounting surface is flat and level.
2. Alignment with any existing packaging lines or conveyors.

The machine should be placed on a flat, level floor so that it does not rock or move. We recommend that the machine be securely locked in place when used.

When the Eastey L-Sealer and Heat Tunnel Combo unit is positioned in the operating location, you will need access to:

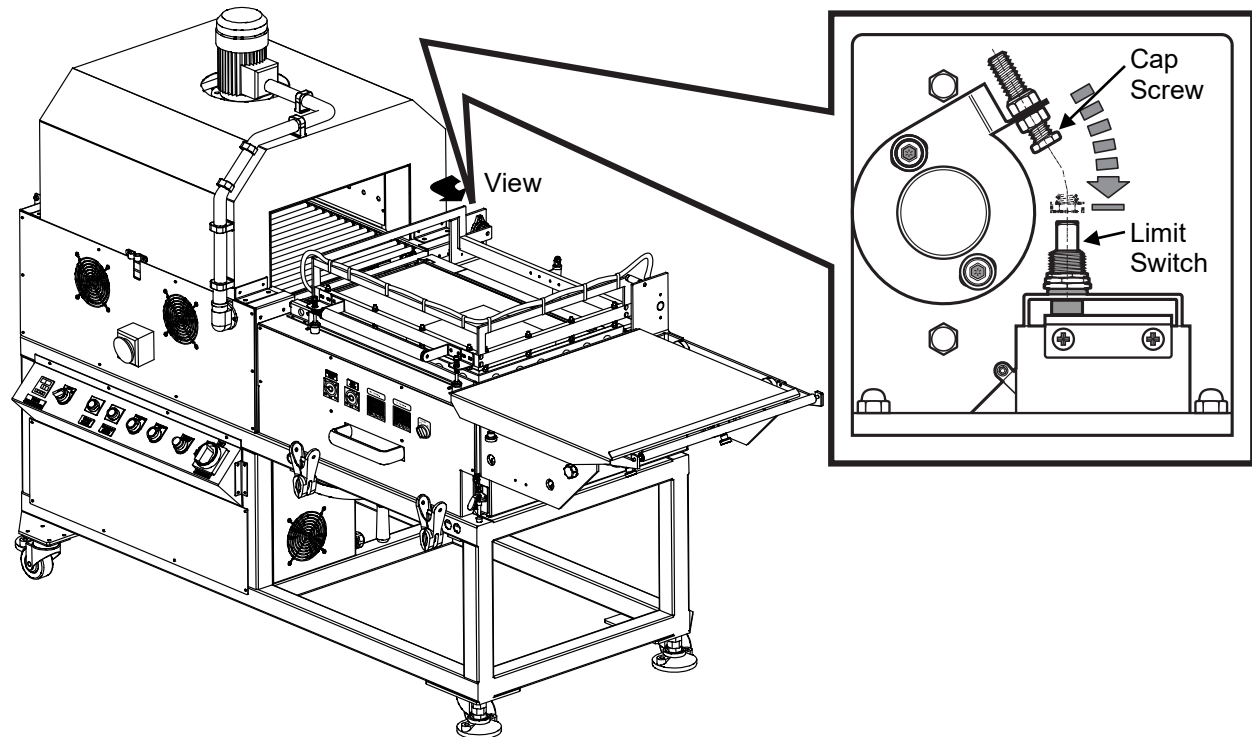
1. Both control panels: control panel for the sealer and control panel for the tunnel.
2. Seal head handle.
3. Sealer table height adjustment wheel.
4. Sealer table horizontal red locking lever.
5. Shrink film roller.
6. Pin perforation wheels.

These locations are generally accessible from the operator side of the machine. The film and pinwheel rollers are located under the product tray.

Aligning the Seal Head Limit Switch and Actuator

The seal head limit switch and limit switch actuator are located on the hinge upright angle closest to the heat tunnel.

Attention! Ensure the limit switch and cap screw that activates it are aligned and the cap screw adjusted so that the head will activate the limit switch when the front seal bar is approximately one-eighth to one-quarter inch from the seal surface.

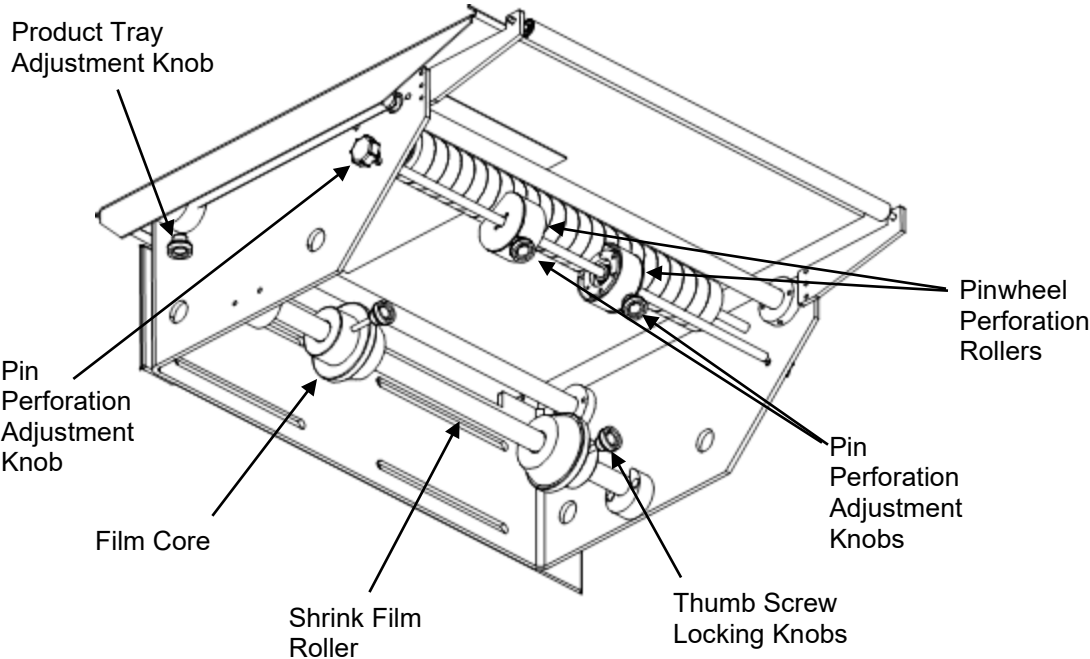


Loading the Film

Load the new roll of shrink film onto the film roller under the product tray. Install the film roll so the center fold is at the back of the machine (the operator side is considered the "Front" of the machine).

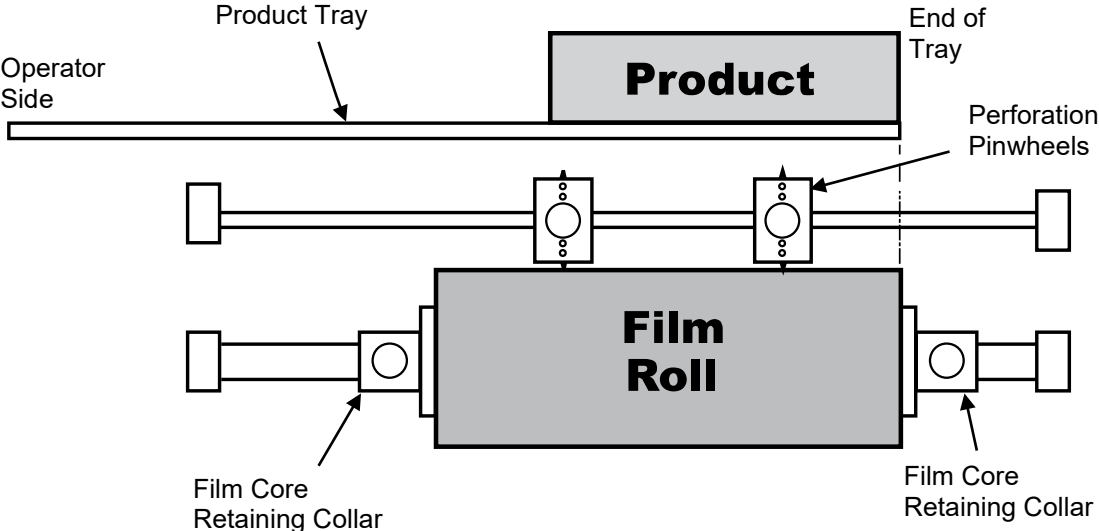
To load a roll of film:

- Lift the shrink film roller off the roller mounts located beneath the product tray.
- Loosen the locking knob on one of the film cores and slide it off the roller.
- Install the new roll of shrink film onto the film roller.
- Reinstall the film core.
- The film position is adjustable. Loosen the film core retaining collar lock knobs and position the shrink film roll according to the product size. Retighten the retaining collar locking knobs.



The pin perforation wheel punches small holes in the shrink wrap to allow air to evacuate while in the shrink tunnel. Loosen the pin perforation adjustment knobs at each end of the perforating wheel roller and move the perforation rollers away from the rubber roller. Position the pin perforation rollers according to the product size. After threading the film move the perforating wheels back to the operating position (against the rubber roller) and retighten the pin perforation adjustment knobs.

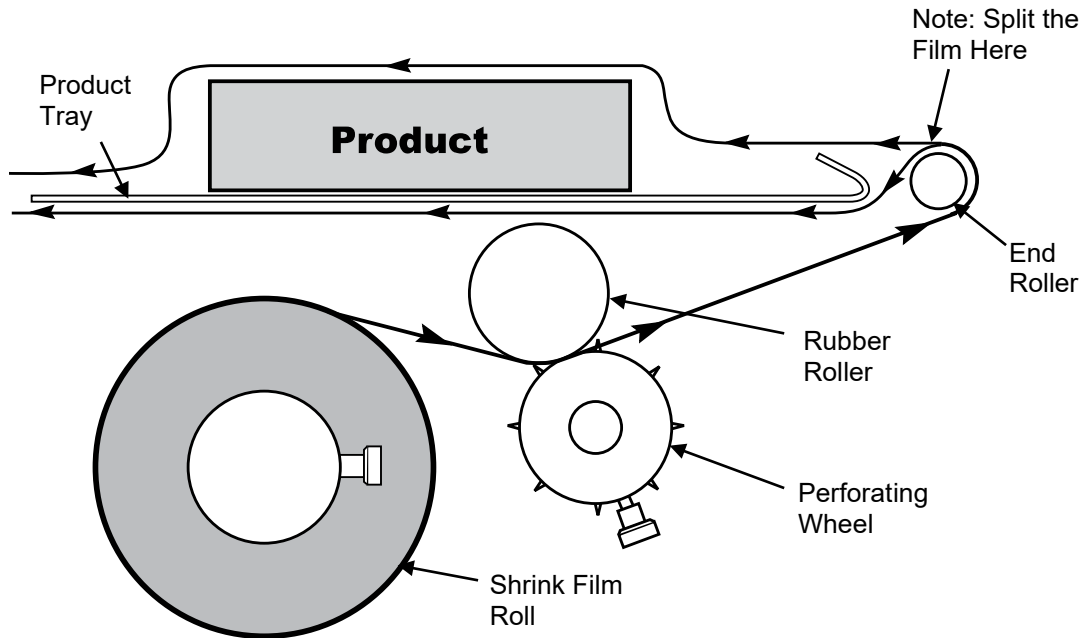
The product tray position is adjustable. Loosen the product tray adjustment knob and align the product tray with the center fold edge of the shrink film. Retighten the adjustment knob.



Film and Product Alignment Diagram

Threading the Shrink Film

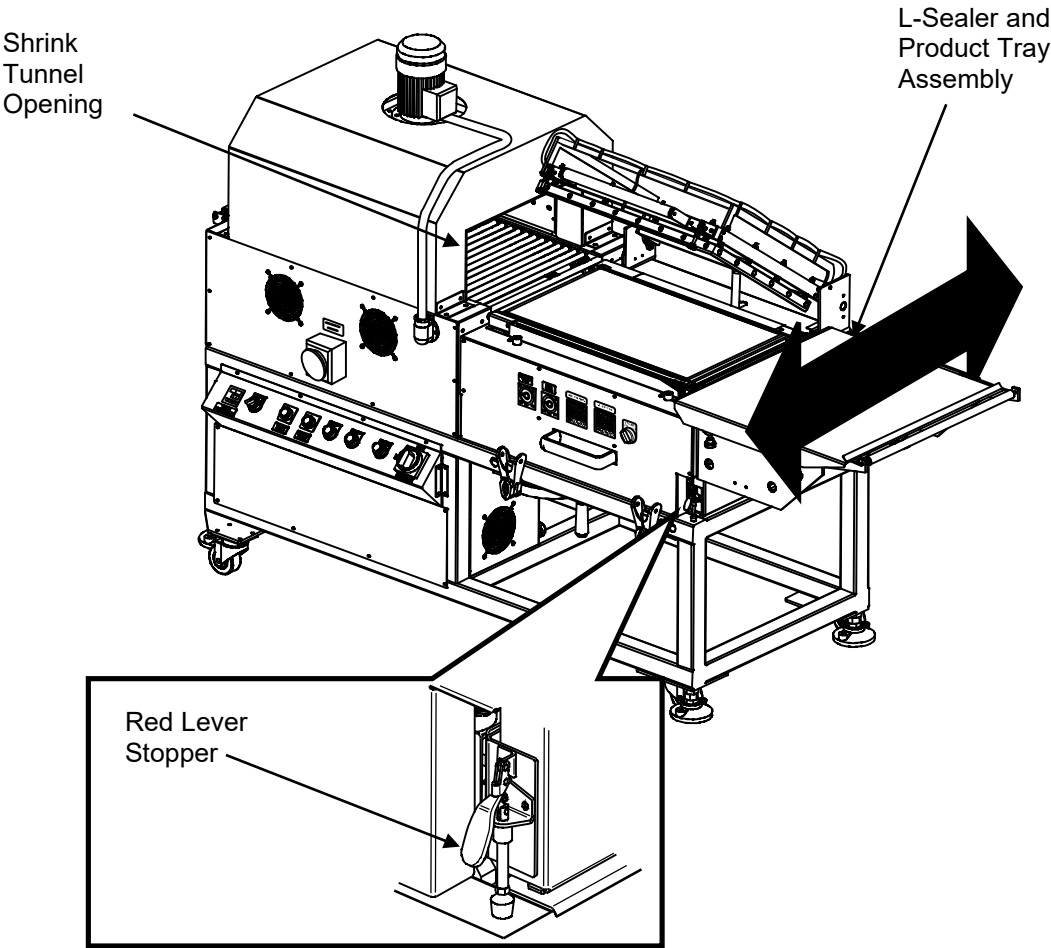
Thread the shrink film over the perforating wheel and around the end roller. Immediately after the end roller, separate the shrink film, with the top of the film traveling over the product tray and the bottom traveling underneath the product tray.



Film Threading Diagram

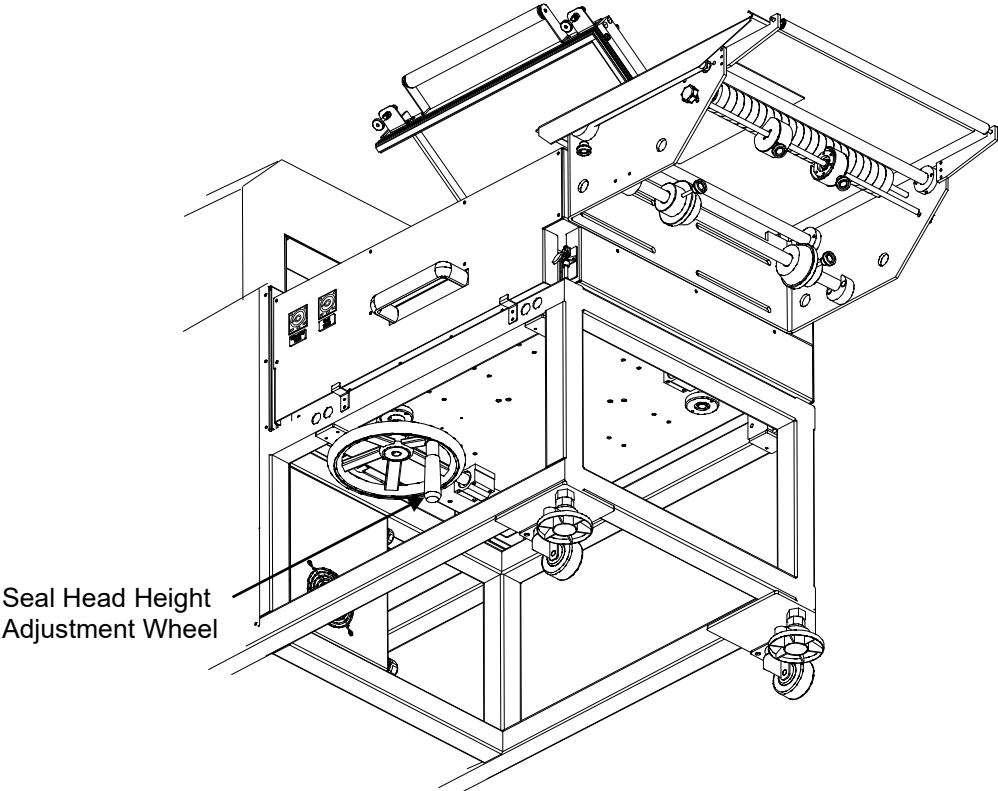
Aligning the Heat-Shrink Tunnel

When the film, product tray and product are correctly aligned, release the red lever stopper and position the entire L-sealer and product tray assembly in line with the heat shrink tunnel opening, centering the product with the center of the tunnel. Reset the red lever stopper to lock the L-sealer and product tray assembly in position.



Seal Head Height Adjustment

To adjust the vertical height of the L-sealer, use the height adjustment wheel located under the sealing assembly. Turn the wheel to move the L-sealer position up or down.



Position the center of the seal as near as possible to the center of the product to be sealed.

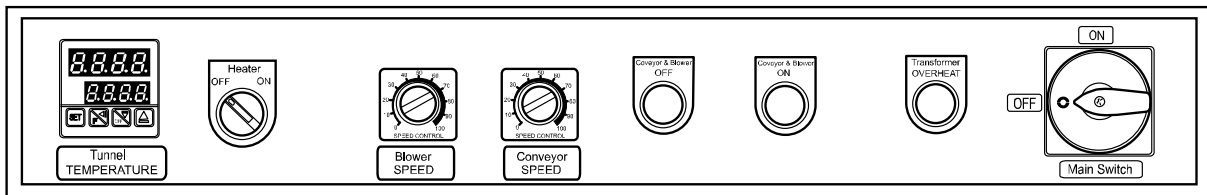


Operation

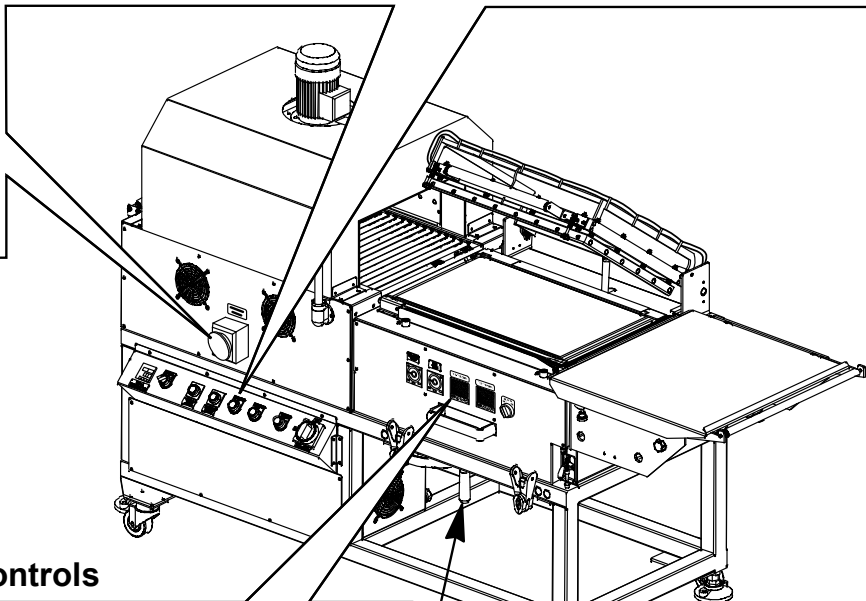
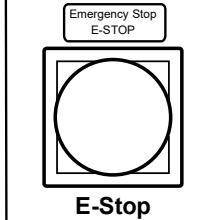
The Easteys VS1620TK Hot-Knife L-Sealer and Heat Tunnel Combo is very easy to operate. Become familiar with the control panels for the heat tunnel and L-sealer located on the operator side of the machine.

Sealer and Tunnel Operation

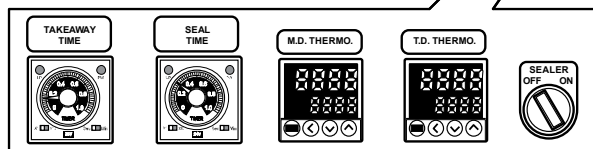
Tunnel Controls



Emergency Stop

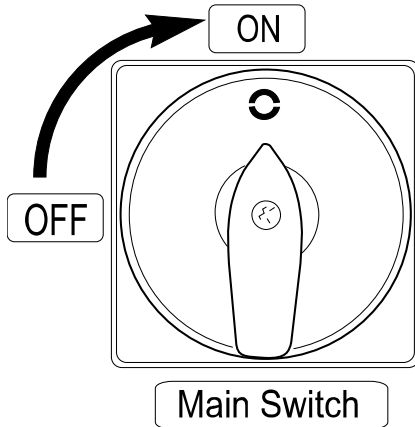


L-Sealer Controls



Handwheel for setting center of seal height

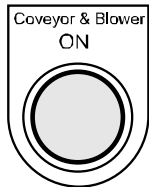
Main Power



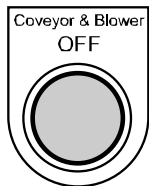
To begin operation, turn the Main Switch to the ON position.

The Main Switch controls power to both the tunnel and sealer.

Conveyor and Blower

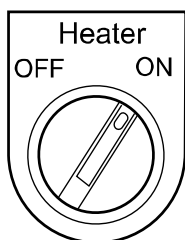


Press the Conveyor and Blower ON (green button) to start the conveyor and blower in the heat tunnel.



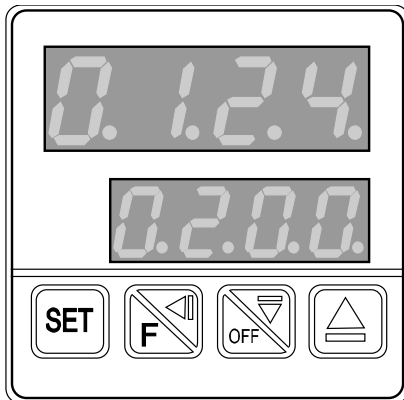
To turn the conveyor and blower off press the red Conveyor and Blower OFF button.

Tunnel Heater



Turn the tunnel Heater switch to the ON position.

Setting the Tunnel Temperature



**Tunnel
TEMPERATURE**

Use the programmable switch to set the temperature inside the heat-shrink tunnel. The programmable switch will display the current temperature inside the tunnel (top) and the temperature setting below.



Press the SET button to set the temperature.



Press this button to select the digit to change. The selected digit will begin to flash.



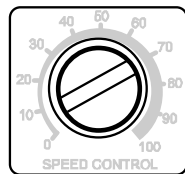
Press the Up or Down arrows to change the value of the selected digit.

Press the "SET" button to save the new values.

Attention! Do Not set the temperature higher than 350°F. Setting the temperature higher than 350°F will damage the machine and the product.

The output light will turn on while the tunnel is heating up.

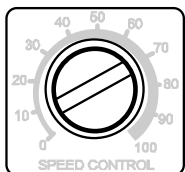
Blower Speed



Blower
SPEED

Use the Blower SPEED dial to set the air flow inside the shrink tunnel. The blower speed will vary according to the product dimensions and film properties.

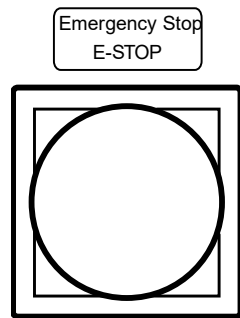
Conveyor Speed



Conveyor
SPEED

Use the Conveyor SPEED dial to set the conveyor speed through the shrink tunnel. The conveyor speed will vary according to the product dimensions and film properties.

E-Stop or Emergency Stop



A red E-Stop button is placed centrally above the heat tunnel control panel. In the event of an emergency, press the E-Stop button in. This brings the heat tunnel to a halt in a way to avoid damage or excessive film waste.

CAUTION! When the Heat Tunnel unit is stopped or turned off it will require some time to cool to ambient room temperature. Be aware of heat inside of the tunnel and hot surfaces, belts, or rollers.

When the E-Stop is pressed, the heat tunnel conveyor motor and heaters are turned off, but blower motors are allowed to continue to blow to allow the tunnel to cool down in a way to prevent damaging heat concentrations. Depending on heat settings, the time required for the system to cool down completely may vary.

To return the machine back to normal operation once the E-Stop has been pressed, verify the emergency condition has been cleared, then press and turn the E-Stop button a quarter-turn so it pops out to normal operating position.

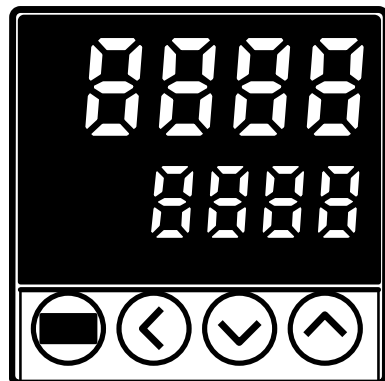
Sealer Operation

Seal Power Off / On



Turn on the power to the seal heads by turning the switch below the front seal head to the On position. The two seal bars that form the L-seal are at right angles to each other. The front seal which runs parallel to the long axis of the machine is sometimes referred to as the M.D. for Machine Direction seal, and the side seal which runs from the front to the back of the machine and perpendicular to the long axis is sometimes referred to as the T.D. for Transverse Direction seal.

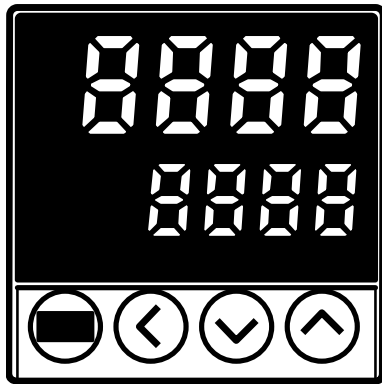
M.D. Thermo. — Machine Direction or Front Seal Temperature Control



Set the temperature for the front hot knife seal using the “M.D. Thermo” temperature controller. This temperature controller operates similar to the heat tunnel temperature controller.

- Press the first button to begin setting the temperature.
- Press the < button to select the digit to change. The selected digit will blink.
- Press the Up or Down direction arrows to increase or decrease the value of the selected digit.

T.D. Thermo — Transverse Direction or Side Seal Temperature Control

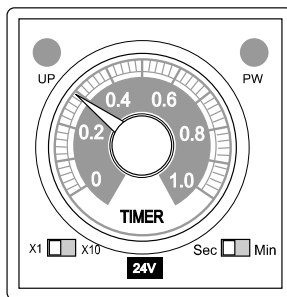


Set the temperature for the side hot knife seal using the “T.D. Thermo” temperature controller. This temperature controller operates same as the front seal temperature controller.

- Press the first button to set the temperature.
- Press the < button to select the digit to change. The selected digit will blink.
- Press the Up or Down direction arrows to increase or decrease the value of the selected digit.

Seal Time

Use the “Seal TIME” timer to set the seal time. The seal time is the amount of time that the magnets will hold the seal head down on the film. The seal time may vary according to the type of film in use.



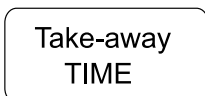
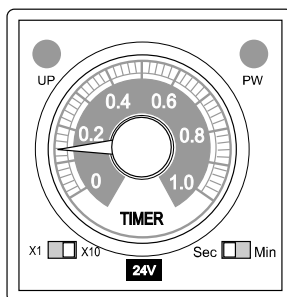
When the seal bar frame is pressed down onto the film, it will remain in position for the set time then automatically release. Do not hold the seal bar down onto the film.

Ensure that the timer sliding switches are in the times one (X1) and the second (Sec) positions. If the timing switches are in the X10 and or the minute positions it will result in a value that is far outside of the desired operating range.

Attention! Move the “Seal TIME” switch in very small increments.

Take Away Time

Use the “Take-away TIME” to set the amount of time the conveyor will run.



When the seal bar is released the conveyor will automatically move the product into the shrink tunnel according to the set time. The takeaway time will vary according to the product being sealed and the operator’s ability.

Ensure that the timer sliding switches are in the times ten (X10) and the second (Sec) positions. If the timing switches are in the X1 and or the minute positions it will result in a value that is far outside of the desired operating range.

Sealing the Product

Advance the film across the product tray. Remember the film is split with the bottom half going beneath the product tray and to top going over the product tray.

Note: For best results, the seal head should be cycled three to four times initially before sealing to warm up the upper seal head.

Pull a short length of film into the seal area and pull the seal bar down to create a leading seal.

Lift the top film and place the product to be sealed on the product table under the top layer of film.

Advance the product and film to the seal area on the takeaway conveyor.

Close the sealing bar using slight pressure and let go. The sealing bar will seal the product and release automatically according to the sealing time setting.

After the seal head has been released the takeaway conveyor will move the product into the heat shrink tunnel.

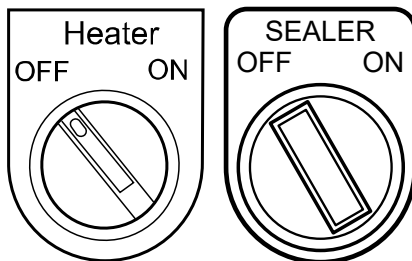
Repeat this process for the next package to be sealed.

As products are moved through the L-sealer, a long tail of scrap will accumulate on the operator side of the machine. Wind the scrap material around the two fixed holders.

Note: During the normal course of operation of the sealer, the seal heads will require cleaning from time to time. For best results, form a ball of accumulated scrap sealing film and keep this handy to use to wipe the seal blades when needed.

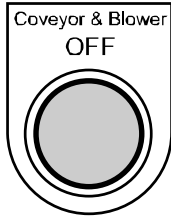
Shutting Down

When shutting down it is important to let the temperature inside the shrink tunnel cool down before turning off the main power. See the special notes about the tunnel shutdown sequence at the end of this section.

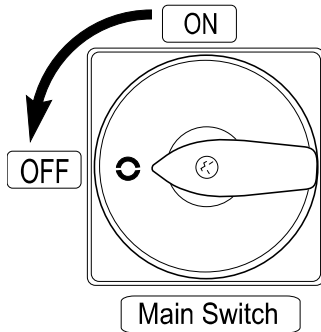


Turn switches for the sealer and for the tunnel heater to the OFF position.

Attention! Do not turn the conveyor and blower off until the shrink tunnel has cooled down considerably.



After the temperature in the tunnel has cooled to approximately 150°F or 66°C or cooler (this will be a considerable amount of time) turn the Conveyor and Blower off.



Turn Main Power switch to the OFF position.

Special Notes About the Tunnel Shutdown Sequence

- ▶ The sealer may be shut down at any time by switching the sealer power switch to the Off position and allow to cool to ambient room temperature. Shutting down the heat tunnel requires the following.
- ▶ When shutting down the tunnel, be sure to first turn the heater switch to Off.
- ▶ Once the heater switch is switched off, it will take some time (this will vary depending on heat settings) for the tunnel to cool down completely.
- ▶ When the tunnel cools down to approximately 150°F or 66°C or cooler, shut off the tunnel conveyor and blowers.
- ▶ Bringing the tunnel down this way helps prevent damage to the conveyor and internal components from excess prolonged exposure to heat inside the tunnel. Allow the tunnel to cool down completely to ambient room temperature before performing any servicing to avoid burn hazards.

Maintenance

The Eastey Hot-Knife L-Sealer and Heat Tunnel Combo will provide many hours of maintenance-free operation and requires very little maintenance for normal operation. There are a few items that may require attention from time to time.

Attention! Any maintenance beyond normal cleaning and lubrication should only be performed by trained and qualified personnel.

Sealer

Daily

- Clean the hot knife seal blade. Check the upper and lower seal areas for melted or scrap film or dirt and clean as required.
- Ensure no parts are broken or missing from the upper and lower seal areas. Replace as needed.
- Check conveyor belts for wear or damage. Check the takeaway conveyor for torn belt or excessive wear; check the tunnel conveyor for worn or broken parts. Repair or replace as needed.
- Check the conveyor height adjustment wheel. Lubricate chain and screws as needed.
- Check power cord and wiring for wear and loose connections.
- Check for loose fasteners.

Shrink Tunnel

Daily

- Inspect the silicone rollers. Repair or replace as needed.
- Check mesh belt for material stuck on or in belt. Clean if necessary.

Monthly

- Check and clean the air intake screens.
- Check the airflow holes inside the tunnel for debris and clean if necessary.
- Check and adjust the conveyor tension.
- Lubricate the drive chains.

Cleaning

The machine will require occasional cleaning.

1. After daily operation, carefully wipe the sealing cutter clean with a ball of accumulated scrap sealing film.
2. The machine is not designed or built for waterproof function. When cleaning the machine, use only a clean cloth, lightly dampened if necessary, to clean exterior surfaces. Use a ball of accumulated scrap sealing film to clean the seal heads occasionally as required. DO NOT splash water or other fluids on or into the machine.
3. Avoid contact with liquid acid or gas, or other corrosives.

Silicone Rubber Seal Pad Replacement

Occasionally it will be necessary to replace the silicone rubber seal pads. Seal pads are designed with a channel to make them easy to install and replace. Seal pads should be replaced if the following symptoms are observed.

- Gaps in the seal
- Weak seals
- Improper film cutoff
- Excessive sealing pressure required

To replace a silicone rubber seal pad, pull the old pad out of the channel and replace with the new silicone rubber seal pad, pressing it into place in the channel.

NOTE: Some silicone rubber seal pads come covered in talcum powder. If so, clean the pads with a mild solvent.

Changing Hot-Knife Inserts and Cutting Rules

1. Disconnect electrical power for the L-Sealer & Tunnel Combo unit from the electrical power source.

CAUTION! Always be aware of the cutting edges while replacing the knife edges. Handle the knife blades carefully.

2. Remove any hardware holding the inner side film clamp outer front film clamp.

NOTE: It may be possible to remove the film clamps without removing all hardware. Push the product tray in all the way. Swing the film clamp down and to the right over the product tray, then pull it out and rest the film clamp on the product tray.

3. Remove any hardware fastening the side-seal and front-seal bars.

4. Remove the insert and cutting rule, both at the same time.
5. Place the replacement cutting rules into the new inserts, both at the same time, ensuring that the beveled edge is in the corner.
6. Push the beveled edges together.

NOTE: The inside beveled edges of the cutting rule need to come together. The outsides do not. Be sure the cutting rules are touching.

7. Reinstall any attaching hardware removed earlier, but do not tighten at this point.
8. Heat the seal bar up to the set point.
9. Adjust insert and cutting rule if they separate at the corner.
10. Tighten the attaching hardware while the seal bars are hot.
11. Turn off heat and allow the sealer to cool down, and then reinstall film clamps.

Rollers

Make sure the rollers stay clean and grease free. If you should have to clean the rollers, simply wipe them down with a clean lint free cloth. If a more thorough cleaning is necessary, wipe the rollers down with a mild detergent and water and let dry. **DO NOT** splash water or other liquids into the machine. **Never use harsh or abrasive cleaners or chemical agents when cleaning this machine.**

Troubleshooting

Problem	Possible Cause	Solution
<p>Control power lamp does not light.</p> <p>No fuse breaker tripped.</p>	<ul style="list-style-type: none"> • Power not connected. • Fuse burned out. • Defective switch. • Disconnected wire. • Poor connection. • Electrical leakage. 	<ul style="list-style-type: none"> • Connect power; switch on. • Replace fuse. • Replace switch. • Check wire connections. • Check heating wire. • Check all wiring sections.
<p>Conveyor belt can be pushed by hand.</p> <p>Belt cannot be pushed by hand.</p> <p>Failure under Normal Status.</p>	<ul style="list-style-type: none"> • Belt tension too loose. • Belt tension too tight. • Defective motor gear head. • Driving chain tension too tight. • Disconnected wire. • Defective motor. • Defective contact plug. • Defective relay unit. • Defective limit switch. 	<ul style="list-style-type: none"> • Adjust belt tension screw. • Adjust belt tension screw. • Replace part. • Adjust driving chain. • Replace part.
<p>Material outfeed roller failure.</p> <p>Material moves</p>	<ul style="list-style-type: none"> • Disconnected wire. • Defective drive motor. • Defective relay unit. • Defective brake box. • Wrong material setting position. 	<ul style="list-style-type: none"> • Replace part. • Replace part. • Adjust material setting position.
<p>Zig-zag line.</p>	<ul style="list-style-type: none"> • Unbalanced material tension lever. • Wrong tension roller position. • Wrong triangle unfold angle. 	<ul style="list-style-type: none"> • Adjust item as required.
<p>Material does not move.</p>	<ul style="list-style-type: none"> • Film perforator does not allow film to roll out. 	<ul style="list-style-type: none"> • Adjust spring.

Problem	Possible Cause	Solution
Material does not move.	<ul style="list-style-type: none"> • Wrong RPM of material mounting roller. • Chain tension clamping is set too tight. • Chain tension clamping is set too loose. 	<ul style="list-style-type: none"> • Adjust to correct RPM. • Adjust chain clamping to correct tension. • Adjust chain clamping to correct tension
Sealing arm fails to move.	<ul style="list-style-type: none"> • Disconnected wire. • Defective relay unit. 	<ul style="list-style-type: none"> • Replace part. • Replace part.
Sealing arm rises too abruptly.	<ul style="list-style-type: none"> • Sealing time is set too short. 	<ul style="list-style-type: none"> • Adjust time of limit switch in safety device to lengthen sealing time.
Sealing arm lowers too abruptly	<ul style="list-style-type: none"> • Electronic sensors not aligned horizontally or vertically, or dirty. 	<ul style="list-style-type: none"> • Check alignment and adjust and clean as necessary.
Sealing heating temperature does not rise.	<ul style="list-style-type: none"> • Fuse burned out. • Disconnected heating wire. • Defective relay unit power of single phase. 	<ul style="list-style-type: none"> • Replace part as required.
Unable to adjust temperature.	<ul style="list-style-type: none"> • Defective temperature regulator. • Defective temperature sensor. 	<ul style="list-style-type: none"> • Replace defective part as required.
Safety device failure.	<ul style="list-style-type: none"> • Disconnected wire. • Defective limit switch. • Defective relay unit. • Insufficient air pressure. 	<ul style="list-style-type: none"> • Reconnect or replace wire. • Adjust or replace limit switch. • Replace part as required. • Check air pressure. Air pressure must meet specifications.
Sealer not forming an adequate seal.	<ul style="list-style-type: none"> • Hot knife defective. • Heating temperature too low. • Sealing time too short or air pressure too weak. • Hot knife heat is insufficient. 	<ul style="list-style-type: none"> • Replace with new hot knife. • Adjust to correct heating temperature. • Check and correct as required. Replace seal pads, if required. • Replace hot knife.

Parts List

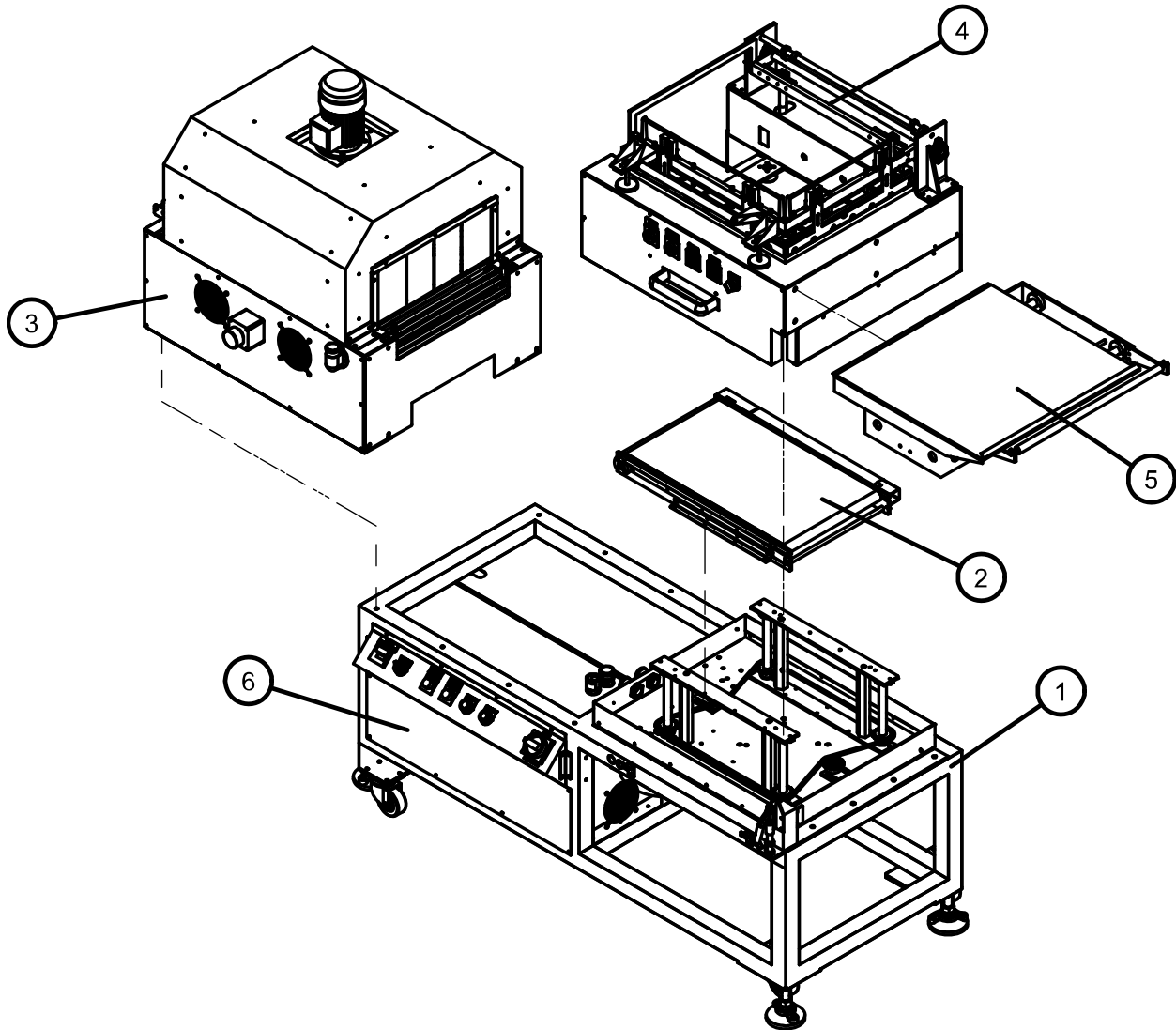
VS1620TK Spare Parts List

In addition to having on hand an extra set of hot cutting knives, seal pads, and typical wear items for the sealer, the following spare parts are recommended.

PART NO.	DESCRIPTION	REFERENCE	Q'TY
VSSA0009	SPRING COMPRESSION, COMPENSATOR	5EH1410X7.8X32X12N	2
VSSA0012	MACH-COMPENSATOR BUSHING	LTM504(ENG)EM04	2
VSSA0013	RED COMPENSATOR COVER	VSSA0013L OR VSSA0013R	2
VSSA0015	COMPENSATOR ROD	LTM504(ENG)EM04	1
VSSA0016	COMPENSATOR SHAFT COLLAR	LTM504(ENG)EM05	1
VSSA0317	TRANSVERSE DIRECTION (TD) CUTTER	HOT KNIFE TD	1
VSSA0318	MACHINE DIRECTION (MD) CUTTER	HOT KNIFE MD	1
VSCP0010	FUSE TIME DELAY 12 AMP	Fuse 1	2
VSCP0011	FUSE TIME DELAY 10 AMP	Fuse 2	2
VSCP0012	FUSE TIME DELAY 4 AMP	Fuse 4	2
VSCP0013	FUSE TIME DELAY 2 AMP	Fuse 3	2

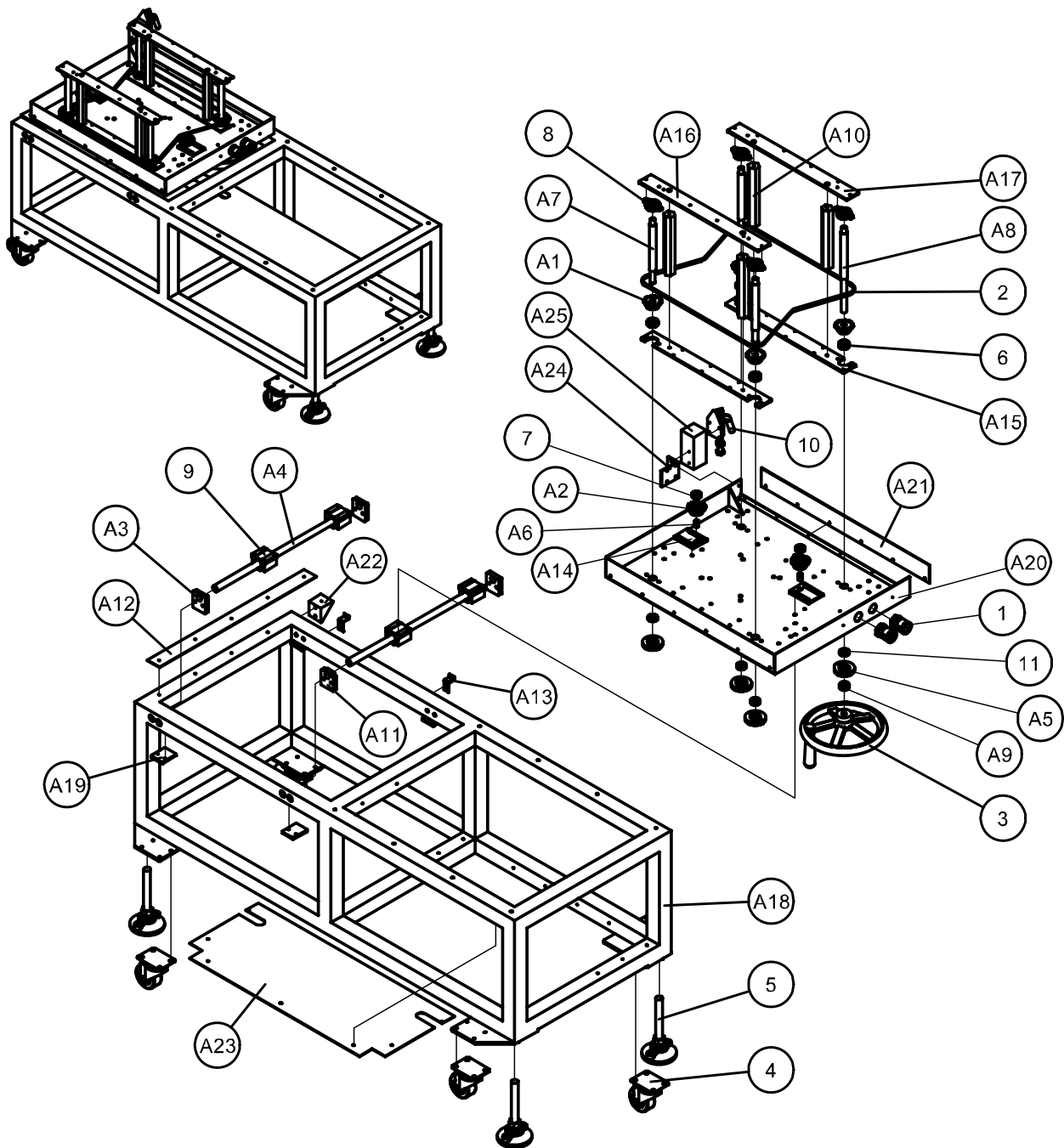
VS1620TK L-Sealer Tunnel Combo Unit

Main Assembly – VS1620-TKLR Live Roller (LTS504(ENG)X2-ALL)
 VS1620-TKMB Mesh Belt



ITEM	PART NO.	DESCRIPTION	REFERENCE	PAGE
1	VSSA0264	Base Frame with Takeaway Height Adjustment	LTS504(ENG)X2-A	33
2	VSSA0265	L-Sealer Takeaway Conveyor Assembly	LTS504(ENG)X2-B	35
3(a)	VSTA0069LR	Heat Tunnel Assembly – Live Roller Conveyor	LTS504(ENG)X2-D	37
3(b)	VSTA0069MB	Heat Tunnel Assembly – Wire Mesh Belt Conveyor		43
4	VSSA0266	L-Sealer and Frame W/ L-Sealer Control Panel	LTS504(ENG)X2-E	46
5	VSSA0267	Product Tray with Film Holder and Perforator	LTS504(ENG)X2-G	52
6	VSCP0038	Main Electrical Panel and Tunnel Control Panel	LTS504(ENG)X2-H	541

Base Frame with Takeaway Height Adjustment – VSSA0264
(LTS504(ENG)X2-A)



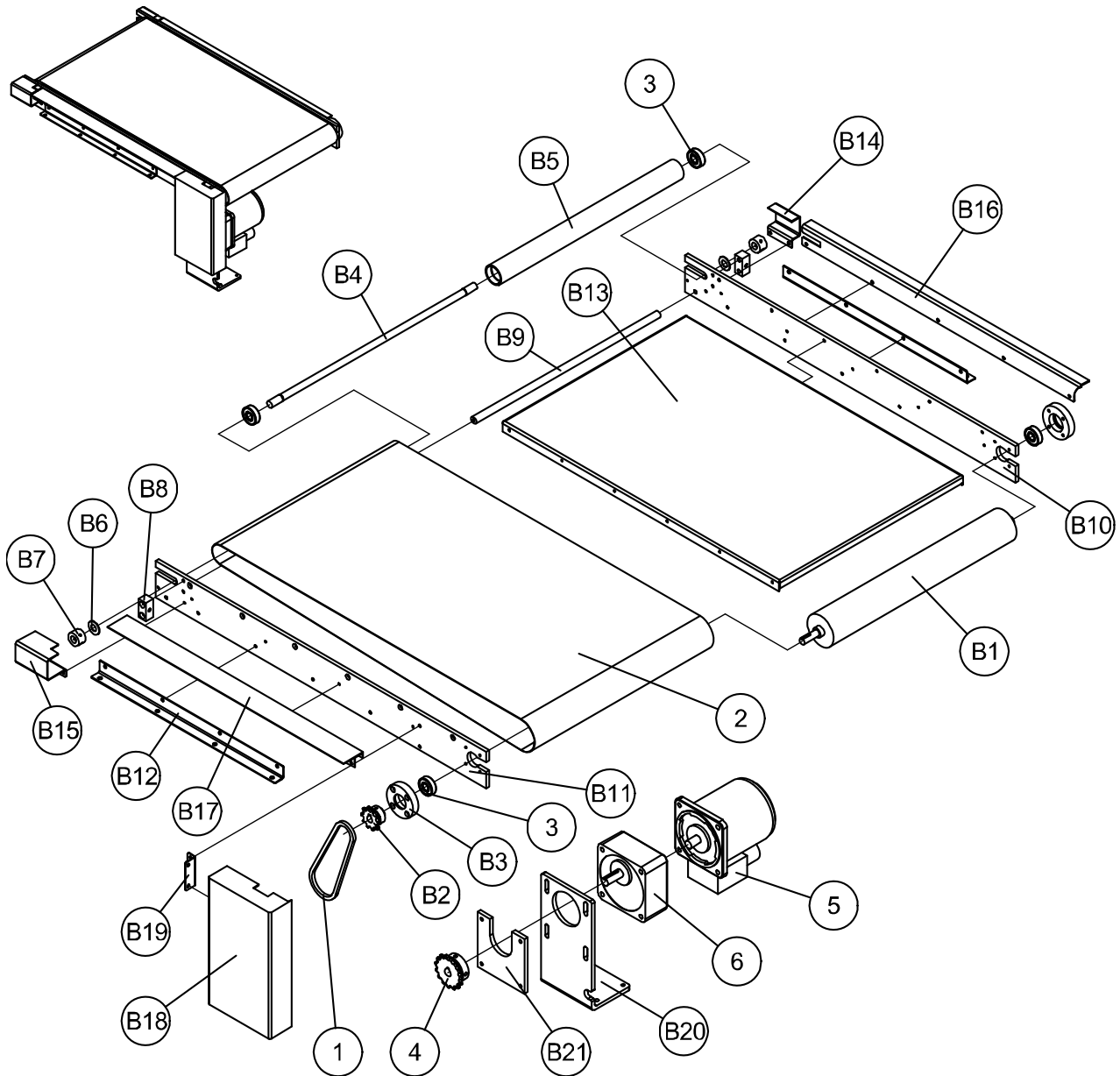
ITEM	PART NO.	DESCRIPTION	REFERENCE	Q'TY
A1	VSSA0193	SPROCKET	5BF01LTS504PAC01	4
A2	VSSA0198	IDLER	5BF01LTS504PAC02	2
A3	VSSA0270	GUIDE ROD FIXED SEAT	5HFLTS504(ENG)X2AM01	3
A4	VSSA0271	GUIDE ROD	5HFLTS504(ENG)X2AM02	2
A5	VSSA0272	SCREW SEAT	5HFLTS504(ENG)X2AM03	4

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ITEM	PART NO.	DESCRIPTION	REFERENCE	Q'TY
A6	VSSA0273	IDLER AXLE	5HFLTS504(ENG)X2AM04	2
A7	VSSA0274	DRIVEN LIFTING SCREW	5HFLTS504(ENG)X2AM05	3
A8	VSSA0275	LIFTING SCREW	5HFLTS504(ENG)X2AM06	1
A9	VSSA0276	SCREW FIXED RING	5HFLTS504(ENG)X2AM07	1
A10	VSSA0277	FIXED ROD	5HFLTS504(ENG)X2AM08	4
A11	VSSA0278	GUIDE ROD FIXED SEAT	5HFLTS504(ENG)X2AM09	1
A12	VSSA0279	PAD	5HFLTS504(ENG)X2AM10	1
A13	VSSA0280	CLIP BRACKET	5HELTS504(ENG)X2AP03	2
A14	VSSA0281	CHAIN ADJUSTMENT PLATE	5HELTS504(ENG)X2AP04	2
A15	VSSA0282	SUPPORT PLATE	5HELTS504(ENG)X2AP05	2
A16	VSSA0283	SUPPORT PLATE	5HELTS504(ENG)X2AP06	1
A17	VSSA0284	SUPPORT PLATE	5HELTS504(ENG)X2AP07	1
A18	VSSA0285	FRAME	5HELTS504(ENG)X2AP08	1
A19	VSSA0286	FIXED SEAT	5HELTS504(ENG)X2AP09	4
A20	VSSA0287	LIFTING BASE	5HELTS504(ENG)X2AP10	1
A21	VSSA0288	LIFTING BASE COVER	5HELTS504(ENG)X2AP11	2
A22	VSSA0289	FIXED SEAT	5HELTS504(ENG)X2AP13	1
A23	VSSA0290	COVER	5HELTS504(ENG)X2AP15	1
A24	VSSA0291	CLAMP FIXED SEAT	5HELTS504(ENG)X2EP26	1
A25	VSSA0292	CLAMP FIXED SEAT	5HELTS504(ENG)X2EP27	1

ITEM	PART NO.	DESCRIPTION	REFERENCE	Q'TY
1	VSSA0268	STRAIGHT CONNECTOR	5AI34BVNDP213GT	2
2	VSSA0200	ROLLER CHAIN	5BA0113X180	1
3	VSSA0194	ROTATING HANDWHEEL	5BC01KRN250X1+FR90	1
4	VSCP0033	WHEEL CASTER	5BD01075X25	4
5	VSCP0034	ADJUSTABLE FOOT	5BD31M20X180	4
6	VSSA0192	THRUST BEARING	5BE0151202	4
7	VSSA0199	BEARING	5BE016001ZZ	2
8	VSSA0205	BLOCK BEARING	5BE03UFL002	4
9	VSCP0035	LINEAR BEARING	5BE06SC20UU	4
10	VSSA0022	CLAMP	5EI07CH36092M	1
11	VSSA0269	BEARING	5BE016002ZZ	4

Takeaway Conveyor Assembly – VSSA0265 (LTS504(ENG)X2-B)



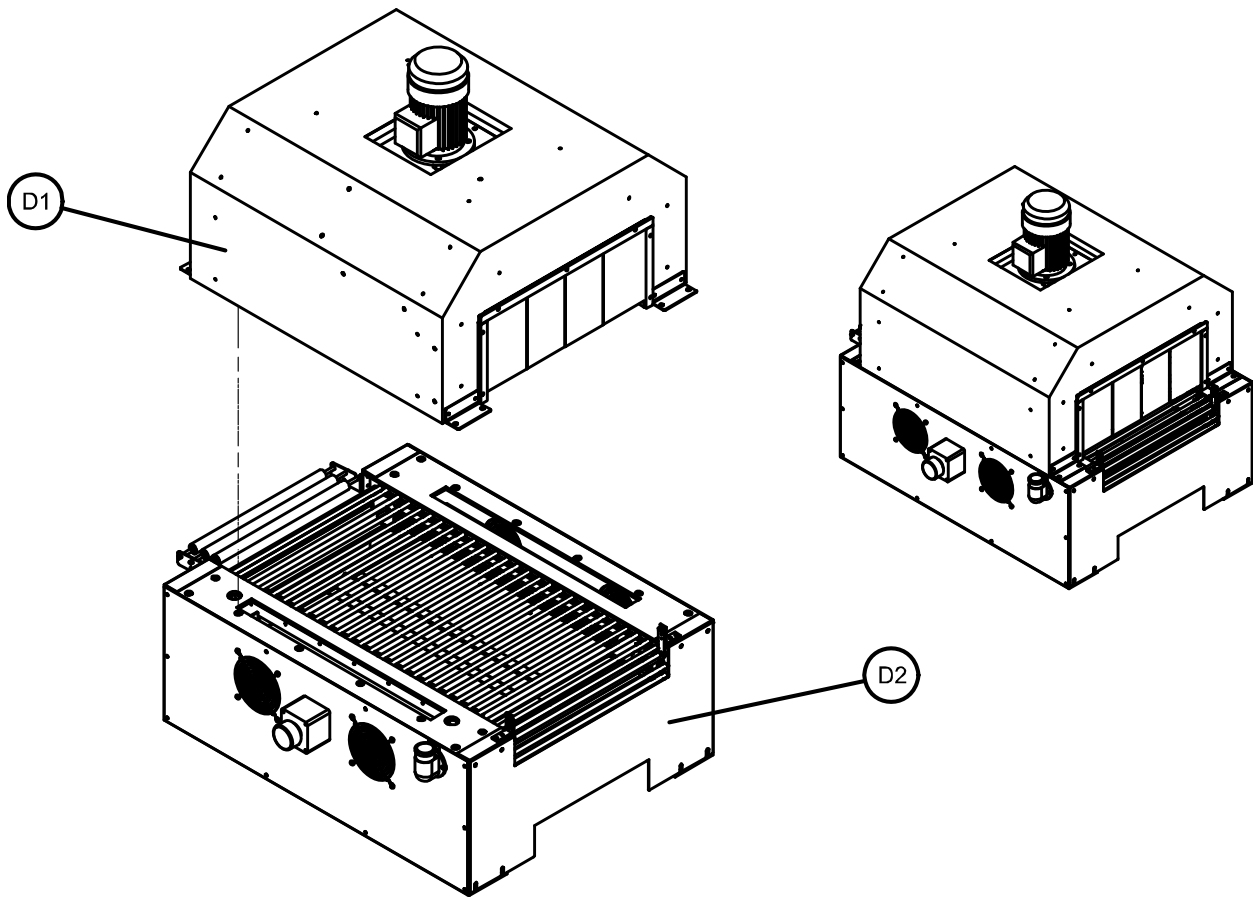
ITEM	PART NO.	DESCRIPTION	REFERENCE	Q'TY
B1	VSSA0293	DRIVE SHAFT	5HFQLTS504PBC01	1
B2	VSSA0294	SPROCKET	5BF01LTS504PBC02	1
B3	VSSA0295	FIXED SEAT	5HFLTS504(ENG)X2BM01	2
B4	VSSA0296	DRIVEN AXLE	5HFLTS504(ENG)X2BM02	1
B5	VSSA0297	DRIVEN ROLLER	5HFLTS504(ENG)X2BM03	1
B6	VSSA0298	WASHER	5HFLTS504(ENG)X2BM04	2
B7	VSSA0299	FIXED RING	5HFLTS504(ENG)X2BM05	2
B8	VSSA0300	ADJUSTMENT SEAT	5HFLTS504(ENG)X2BM06	2

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ITEM	PART NO.	DESCRIPTION	REFERENCE	Q'TY
B9	VSSA0301	FIXED ROD	5HFLTS504(ENG)X2BM07	1
B10	VSSA0302	FIXED PLATE (LEFT)	5HELTS504(ENG)X2BP01	1
B11	VSSA0303	FIXED PLATE (RIGHT)	5HELTS504(ENG)X2BP02	1
B12	VSSA0304	CONNECTION PLATE	5HELTS504(ENG)X2BP03	2
B13	VSSA0305	SUPPORT PLATE	5HELTS504(ENG)X2BP04	1
B14	VSSA0306	LEFT COVER	5HELTS504(ENG)X2BP05	1
B15	VSSA0307	RIGHT COVER	5HELTS504(ENG)X2BP06	1
B16	VSSA0308	CONVEYOR LEFT COVER	5HELTS504(ENG)X2BP07	1
B17	VSSA0309	CONVEYOR RIGHT COVER	5HELTS504(ENG)X2BP08	1
B18	VSSA0310	CHAIN COVER	5HELTS504(ENG)X2BP09	1
B19	VSSA0311	CONNECTION PLATE	5HELTS504(ENG)X2BP10	1
B20	VSSA0312	MOTOR SEAT	5HELTS504(ENG)X2BP11	2
B21	VSSA0313	MOTOR ADJUSTMENT PLATE	SHELTS504(ENG)X2BP12	1

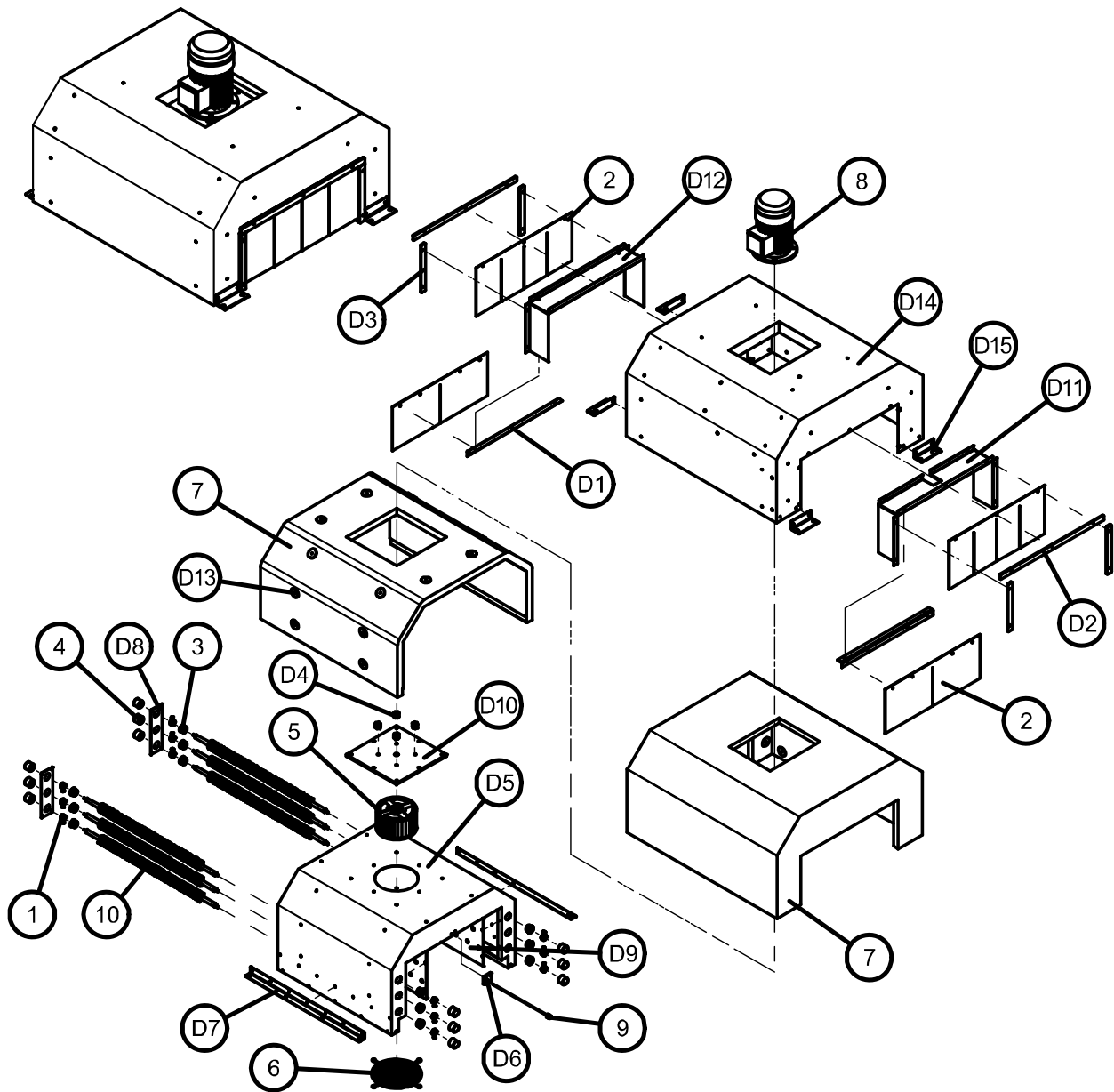
ITEM	PART NO.	DESCRIPTION	REFERENCE	Q'TY
1	VSSA0229	ROLLER CHAIN	5BA0113X036	1
2	VSSA0043	POLYURETHANE (PU) CONVEYER BELT	5BB01SL01X340X1275	1
3	VSSA0226	BEARING	5BE016000ZZ	4
4	VSSA0201	SPROCKET	5BF011B3X15T12M64	1
5	VSTA0003	INDUCTION MOTOR	5CH015IK40GNCT	1
6	VSTA0008	GEAR BOX	5CH615GN18K	1

Heat Tunnel Assembly with Live Roller Conveyor – VSTA0069LR (LTS504(ENG)X2-D)



ITEM	PART NO.	DESCRIPTION	REFERENCE	Q'TY
D1	VSTA0070	HEAT TUNNEL HOOD & HEATERS	LTS504(ENG)X2-D-1	1
D2	VSTA0071LR	HEAT TUNNEL CONVEYOR & SUPPORT WITH LIVE ROLLERS	LTS504(ENG)X2-D-2LR	1

Heat Tunnel Hood & Heaters – VSTA0070 (LTS504(ENG)X2-D-1)

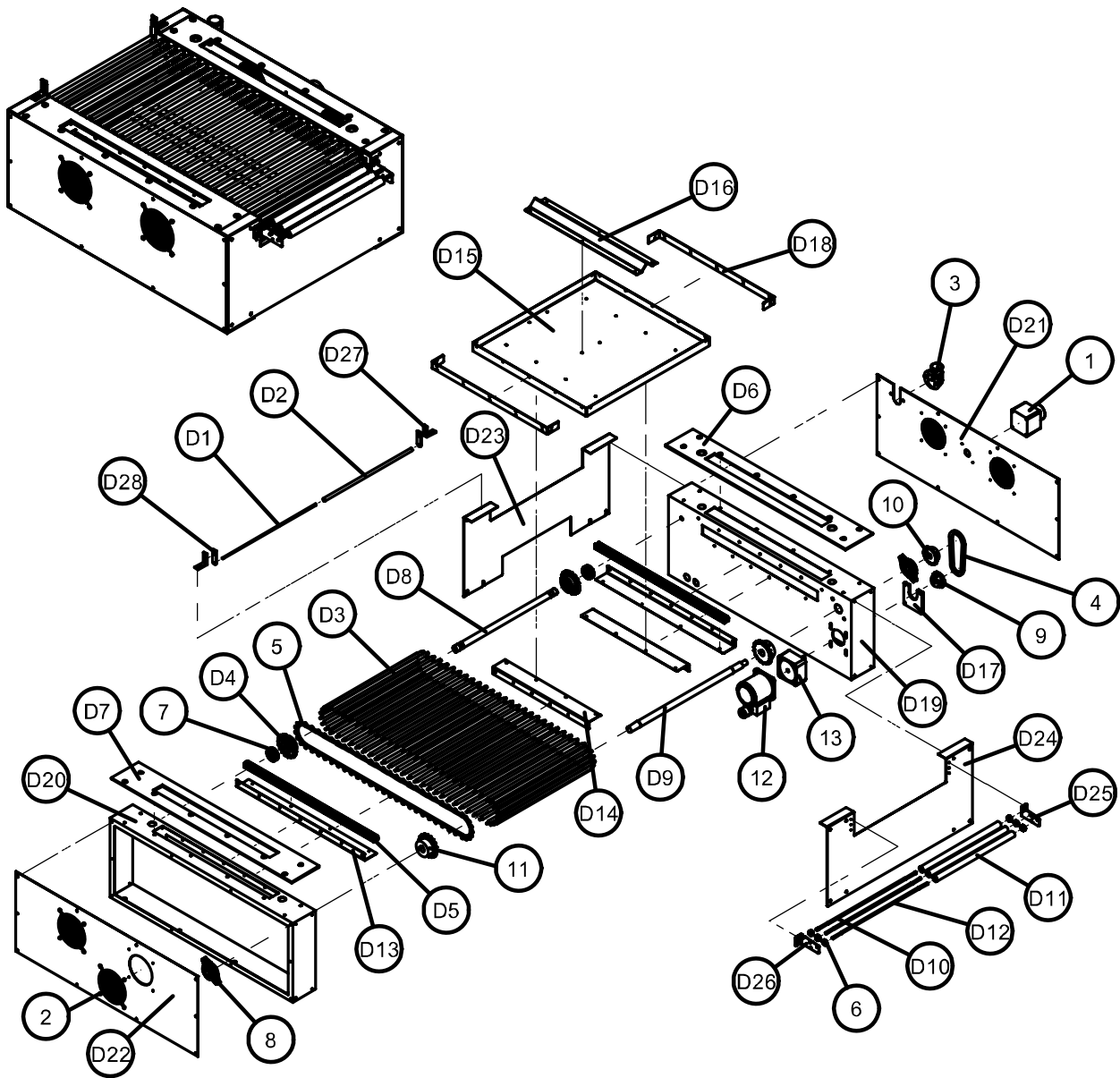


ITEM	PART NO.	DESCRIPTION	REFERENCE	Q'TY
D1	VSTA0077	FIXED PLATE	5HELTS504(ENG)X2AP14	2
D2	VSTA0078	BAKELITE A	5HFLTS504PDC05	2
D3	VSTA0079	BAKELITE B	5HFLTS504PDC06	4
D4	VSTA0080	CUSHION	5HFLTS504(ENG)X2DM06	4
D5	VSTA0081	INNER FURNACE	5HELTS504(ENG)X2DP06	1
D6	VSTA0082	FIXED PLATE	5HELTS504(ENG)X2DP07	1
D7	VSTA0083	CONNECTION BOARD	5HELTS504(ENG)X2DP08	2
D8	VSTA0084	FIXED PLATE	5HELTS504(ENG)X2DP09	2

ITEM	PART NO.	DESCRIPTION	REFERENCE	Q'TY
D9	VSTA0085	SHUTTER	5HELTS504(ENG)X2DP10	2
D10	VSTA0086	FIXED PLATE	5HELTS504(ENG)X2DP11	1
D11	VSTA0087	FURNACE DOOR (FRONT)	5HELTS504(ENG)X2DP13	1
D12	VSTA0088	FURNACE DOOR (REAR)	5HELTS504(ENG)X2DP14	1
D13	VSTA0089	WASHER	5HELTS504(ENG)X2DP15	48
D14	VSTA0090	FURNACE COVER	5HELTS504(ENG)X2DP23	1
D15	VSTA0091	CONNECTION BOARD	5HELTS504(ENG)X2DP24	4

ITEM	PART NO.	DESCRIPTION	REFERENCE	Q'TY
1	VSTA0072	FIXED RING	5AF92A4	12
2	VSTA0073	INSULATION CLOTH		4
3	VSTA0035	CERAMIC INSULATOR	5AF9112	12
4	VSTA0074	CERAMIC INSULATOR	5AF96A4	12
5	VSTA0036	CENTRIFUGAL FAN	5AG025X76X3	1
6	VSTA0075	FAN COVER	5AG1301	1
7	VSTA0076	CERAMIC FIBER COTTON	5Y2250X1	1
8	VSTA0034	TUNNEL HOOD FAN MOTOR	5Y2851	1
9	VSTA0007	THERMOMETER	5AA90BNSTM01	1
10	VSTA0002	HEATER	5AF02A40550X207	6

Heat Tunnel Support & Conveyor with Live Rollers – VSTA0071LR (LTS504(ENG)X2-D-2)



ITEM	PART NO.	DESCRIPTION	REFERENCE	Q'TY
D1	VSTA0096	CONNECTING AXLE	5HFLTS504(ENG)X2DC04	1
D2	VSTA0097	CONNECTING ROLLER	5HFLTS504(ENG)X2DC05	1
D3	VSTA0098	OUTPUT ROLLER	5BB319.5X430X410X4.3	63
D4	VSTA0055	SPROCKET	5BF01LTS504PDC01	2
D5	VSTA0099	TRACK	5BC80LTS504PDC02	2
D6	VSTA0100	BAKELITE A	5HFLTS504PDC03	1
D7	VSTA0101	BAKELITE B	5HFLTS504PDC04	1

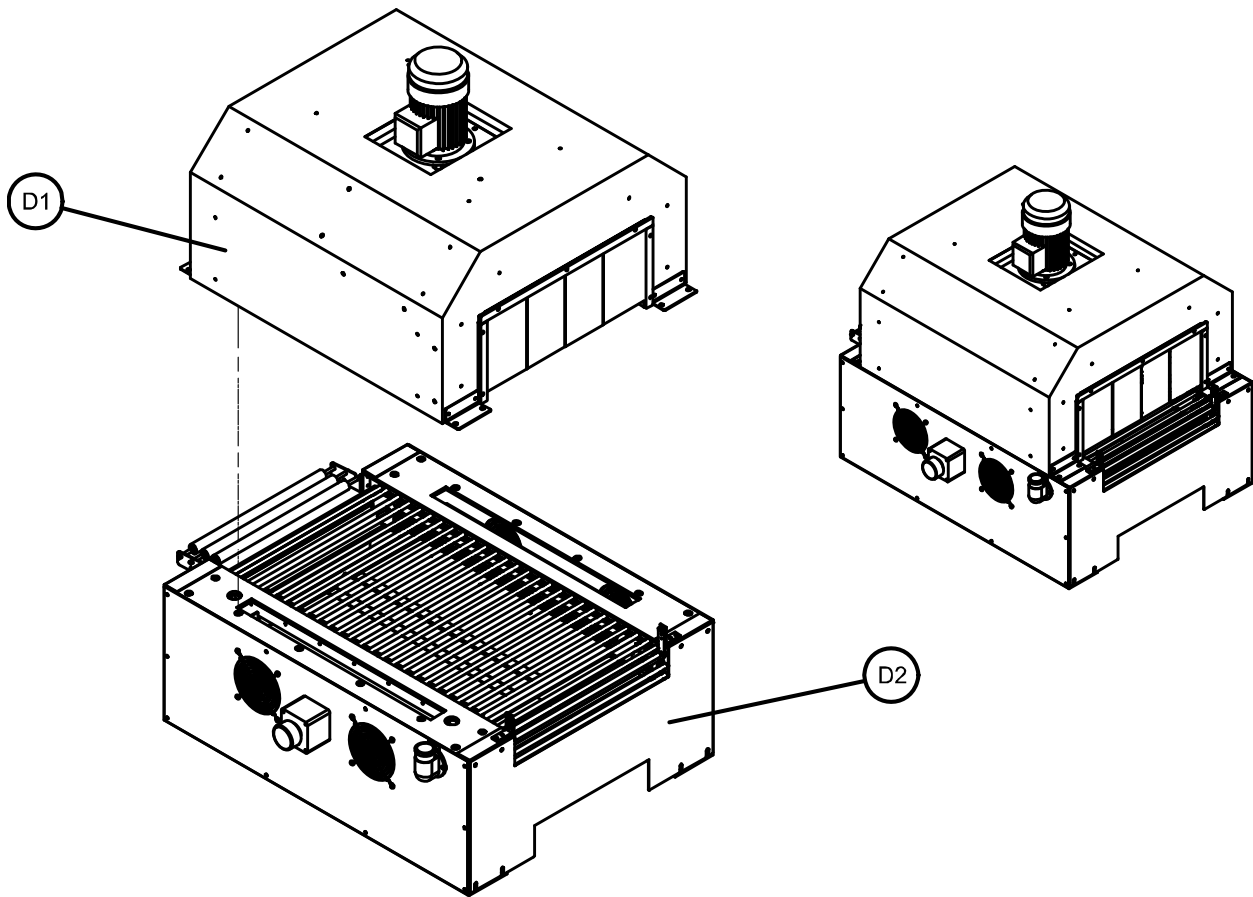
ITEM	PART NO.	DESCRIPTION	REFERENCE	Q'TY
D8	VSTA0102	DRIVEN SHAFT	5HFLTS504(ENG)X2DM01	1
D9	VSTA0103	DRIVING SHAFT	5HFLTS504(ENG)X2DM02	1
D10	VSTA0104	OUTPUT AXLE	5HFLTS504(ENG)X2DM03	1
D11	VSTA0105	OUTPUT ROLLER	5HFLTS504(ENG)X2DM04	3
D12	VSTA0106	OUTPUT AXLE-1	5HFLTS504(ENG)X2DM05	2
D13	VSTA0107	CONNECTION BOARD	5HELTS504(ENG)X2DP01	2
D14	VSTA0108	CONNECTION BOARD	5HELTS504(ENG)X2DP02	2
D15	VSTA0109	BOTTOM PLATE	5HELTS504(ENG)X2DP03	1
D16	VSTA0110	FIXED PLATE	5HELTS504(ENG)X2DP04	1
D17	VSTA0111	MOTOR FIXED PLATE	5HELTS504(ENG)X2DP05	1
D18	VSTA0112	CONNECTION BOARD	5HELTS504(ENG)X2DP12	2
D19	VSTA0113	FURNACE FRAME (LEFT)	5HELTS504(ENG)X2DP17	1
D20	VSTA0114	FURNACE FRAME (RIGHT)	5HELTS504(ENG)X2DP18	1
D21	VSTA0115	FRAME COVER (LEFT)	5HELTS504(ENG)X2DP19	1
D22	VSTA0116	FRAME COVER (RIGHT)	5HELTS504(ENG)X2DP20	1
D23	VSTA0117	FRAME COVER (FRONT)	5HELTS504(ENG)X2DP21	1
D24	VSTA0118	FRAME COVER (REAR)	5HELTS504(ENG)X2DP22	1
D25	VSTA0119	OUTPUT ROLLER SUPPORT-1	5HELTS504(ENG)X2DP25	1
D26	VSTA0120	OUTPUT ROLLER SUPPORT-2	5HELTS504(ENG)X2DP26	1
D27	VSTA0121	ROLLER FIXED PLATE	5HELTS504(ENG)X2DP27	2
D28	VSTA0122	ROLLER ADJUSTMENT PLATE	5HELTS504(ENG)X2DP28	2

ITEM	PART NO.	DESCRIPTION	REFERENCE	Q'TY
1	VSTA0092	EMERGENCY BUTTON	5AB13HY57B0213	1
2	VSTA0093	FAN COVER	5AG1301	4
3	VSTA0094	CONNECTOR	5AI35BVODP213GT	1
4	VSTA0064	ROLLER CHAIN	5BA0113X038	1
5	VSTA0059	CHAIN WITH ATTACHMENT	5BA02A4X063126	2
6	VSTA0014	BEARING	5BE010606ZZ	6
7	VSTA0056	BEARING	5BE016004ZZ	2
8	VSTA0054	BLOCK BEARING	5BE03UFL004	2
9	VSA00058	SPROCKET	5BF011B3X15T10M64	1
10	VSTA0058	SPROCKET	5BF011B3X18T15M65	1

42 Parts List

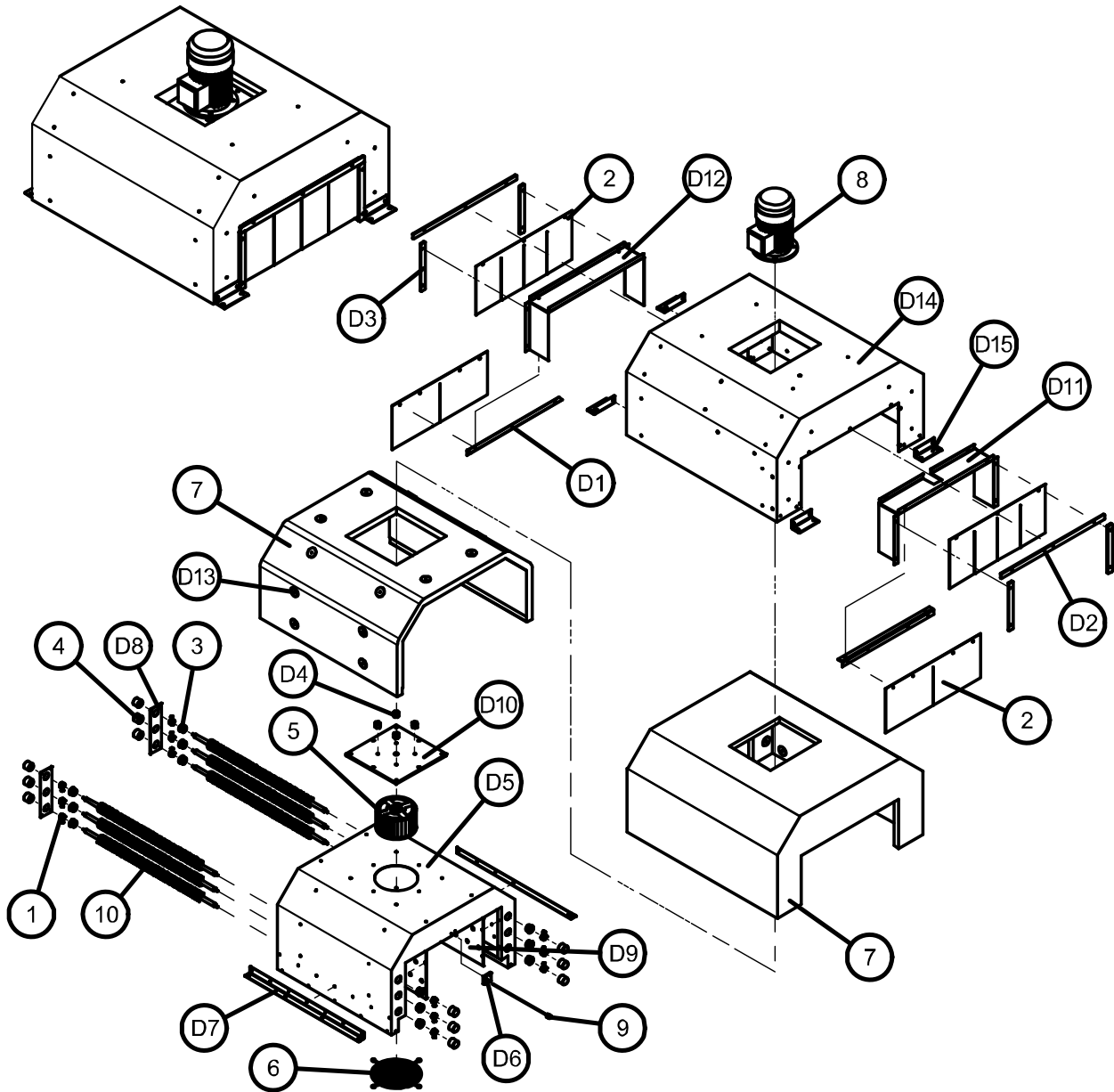
ITEM	PART NO.	DESCRIPTION	REFERENCE	Q'TY
11	VSTA0057	SPROCKET	5BF011B4X18T20M66	2
12	VSSA0006	INDUCTION MOTOR	5CH014IK25GNST	1
13	VSTA0095	GEAR BOX	5CH614GN36K	1

**Heat Tunnel Assembly with Wire Mesh Belt Conveyor – VSTA0069MB
(LTS504(ENG)X2-D)**



ITEM	PART NO.	DESCRIPTION	REFERENCE	Q'TY
D1	VSTA0070	HEAT TUNNEL HOOD & HEATERS	LTS504(ENG)X2-D-1	1
D2	VSTA0071MB	HEAT TUNNEL CONVEYOR & SUPPORT WITH WIRE MESH BELT CONVEYOR	LTS504(ENG)X2-D-2LR	1

Heat Tunnel Hood & Heaters – VSTA0070 (LTS504(ENG)X2-D-1)

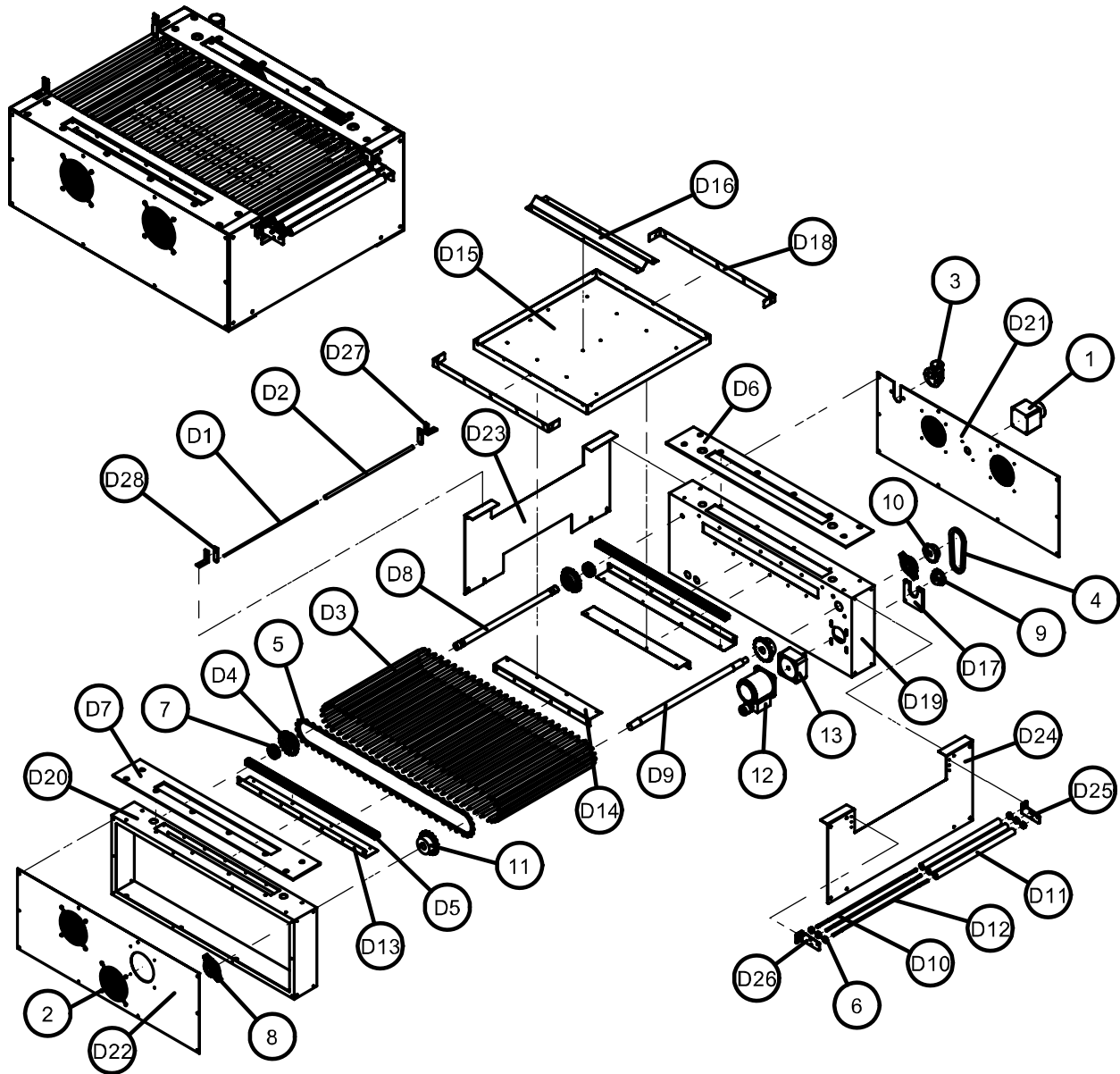


ITEM	PART NO.	DESCRIPTION	REFERENCE	Q'TY
D1	VSTA0077	FIXED PLATE	5HELTS504(ENG)X2AP14	2
D2	VSTA0078	BAKELITE A	5HFLTS504PDC05	2
D3	VSTA0079	BAKELITE B	5HFLTS504PDC06	4
D4	VSTA0080	CUSHION	5HFLTS504(ENG)X2DM06	4
D5	VSTA0081	INNER FURNACE	5HELTS504(ENG)X2DP06	1
D6	VSTA0082	FIXED PLATE	5HELTS504(ENG)X2DP07	1
D7	VSTA0083	CONNECTION BOARD	5HELTS504(ENG)X2DP08	2
D8	VSTA0084	FIXED PLATE	5HELTS504(ENG)X2DP09	2

ITEM	PART NO.	DESCRIPTION	REFERENCE	Q'TY
D9	VSTA0085	SHUTTER	5HELTS504(ENG)X2DP10	2
D10	VSTA0086	FIXED PLATE	5HELTS504(ENG)X2DP11	1
D11	VSTA0087	FURNACE DOOR (FRONT)	5HELTS504(ENG)X2DP13	1
D12	VSTA0088	FURNACE DOOR (REAR)	5HELTS504(ENG)X2DP14	1
D13	VSTA0089	WASHER	5HELTS504(ENG)X2DP15	48
D14	VSTA0090	FURNACE COVER	5HELTS504(ENG)X2DP23	1
D15	VSTA0091	CONNECTION BOARD	5HELTS504(ENG)X2DP24	4

ITEM	PART NO.	DESCRIPTION	REFERENCE	Q'TY
1	VSTA0072	FIXED RING	5AF92A4	12
2	VSTA0073	INSULATION CLOTH		4
3	VSTA0035	CERAMIC INSULATOR	5AF9112	12
4	VSTA0074	CERAMIC INSULATOR	5AF96A4	12
5	VSTA0036	CENTRIFUGAL FAN	5AG025X76X3	1
6	VSTA0075	FAN COVER	5AG1301	1
7	VSTA0076	CERAMIC FIBER COTTON	5Y2250X1	1
8	VSTA0034	TUNNEL HOOD FAN MOTOR	5Y2851	1
9	VSTA0007	THERMOMETER	5AA90BNSTM01	1
10	VSTA0002	HEATER	5AF02A40550X207	6

Heat Tunnel Support & Conveyor with Wire Mesh Belt- VSTA0071MB (LTS504(ENG)X2-D-2)



ITEM	PART NO.	DESCRIPTION	REFERENCE	Q'TY
D1	VSTA0096	CONNECTING AXLE	5HFLTS504(ENG)X2DC04	1
D2	VSTA0097	CONNECTING ROLLER	5HFLTS504(ENG)X2DC05	1
D3	VSTA0060	OUTPUT BELT WIRE MESH	5BB06S0395X1626	1
D4	VSTA0055	OUTPUT ROLLER	5BB319.5X430X410X4.3	3
D5	VSTA0099	SPROCKET	5BF01LTS504PDC01	2
D6	VSTA0100	TRACK	5BC80LTS504PDC02	2
D7	VSTA0101	BAKELITE A	5HFLTS504PDC03	1

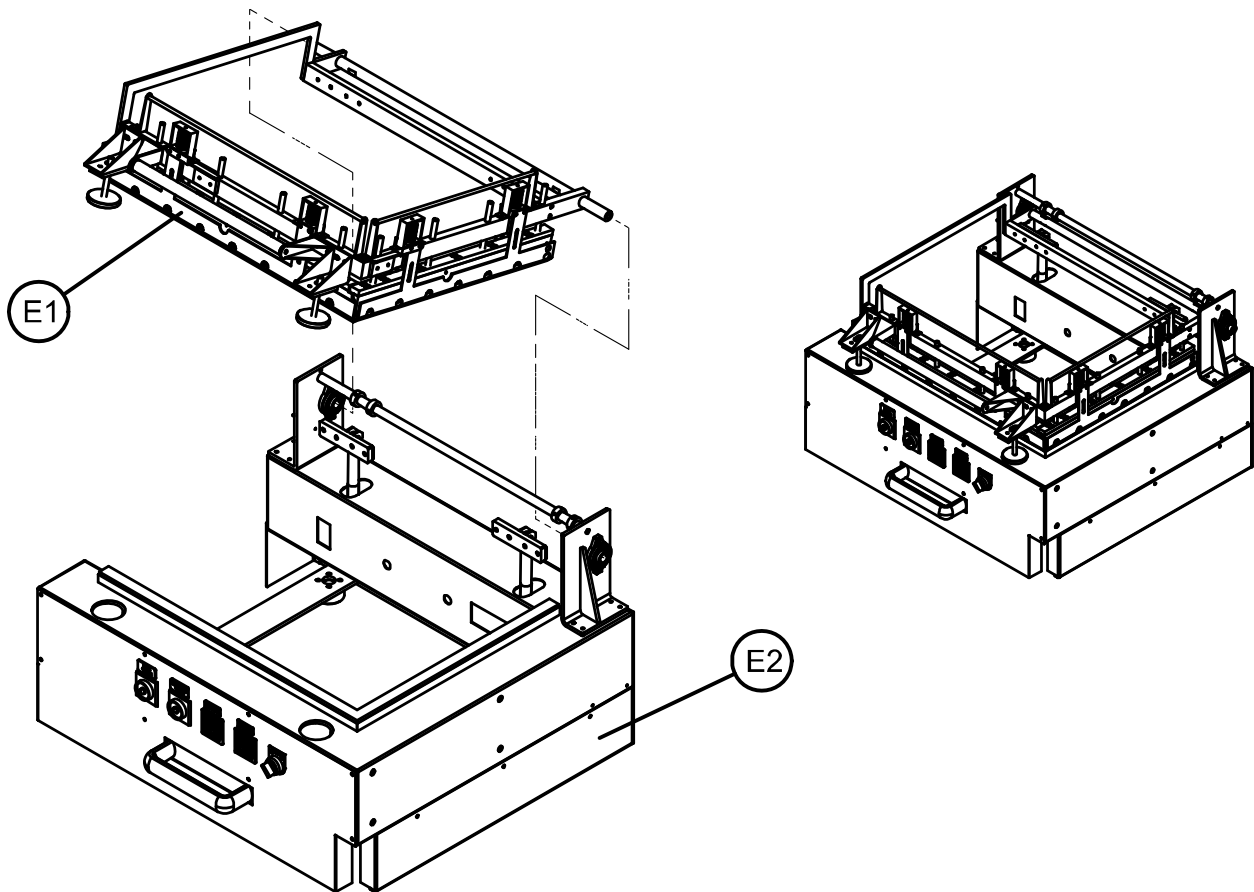
ITEM	PART NO.	DESCRIPTION	REFERENCE	Q'TY
D8	VSTA0102	BAKELITE B	5HFLTS504PDC04	1
D9	VSTA0103	DRIVEN SHAFT	5HFLTS504(ENG)X2DM01	1
D10	VSTA0104	DRIVING SHAFT	5HFLTS504(ENG)X2DM02	1
D11	VSTA0105	OUTPUT AXLE	5HFLTS504(ENG)X2DM03	1
D12	VSTA0106	OUTPUT ROLLER	5HFLTS504(ENG)X2DM04	3
D13	VSTA0107	OUTPUT AXLE-1	5HFLTS504(ENG)X2DM05	2
D14	VSTA0108	CONNECTION BOARD	5HELTS504(ENG)X2DP01	2
D15	VSTA0109	CONNECTION BOARD	5HELTS504(ENG)X2DP02	2
D16	VSTA0110	BOTTOM PLATE	5HELTS504(ENG)X2DP03	1
D17	VSTA0111	FIXED PLATE	5HELTS504(ENG)X2DP04	1
D18	VSTA0112	MOTOR FIXED PLATE	5HELTS504(ENG)X2DP05	1
D19	VSTA0113	CONNECTION BOARD	5HELTS504(ENG)X2DP12	2
D20	VSTA0114	FURNACE FRAME (LEFT)	5HELTS504(ENG)X2DP17	1
D21	VSTA0115	FURNACE FRAME (RIGHT)	5HELTS504(ENG)X2DP18	1
D22	VSTA0116	FRAME COVER (LEFT)	5HELTS504(ENG)X2DP19	1
D23	VSTA0117	FRAME COVER (RIGHT)	5HELTS504(ENG)X2DP20	1
D24	VSTA0118	FRAME COVER (FRONT)	5HELTS504(ENG)X2DP21	1
D25	VSTA0119	FRAME COVER (REAR)	5HELTS504(ENG)X2DP22	1
D26	VSTA0120	OUTPUT ROLLER SUPPORT-1	5HELTS504(ENG)X2DP25	1
D27	VSTA0121	OUTPUT ROLLER SUPPORT-2	5HELTS504(ENG)X2DP26	1
D28	VSTA0122	ROLLER FIXED PLATE	5HELTS504(ENG)X2DP27	2

ITEM	PART NO.	DESCRIPTION	REFERENCE	Q'TY
1	VSTA0092	EMERGENCY BUTTON	5AB13HY57B0213	1
2	VSTA0093	FAN COVER	5AG1301	4
3	VSTA0094	CONNECTOR	5AI35BVODP213GT	1
4	VSTA0064	ROLLER CHAIN	5BA0113X038	1
5	VSTA0059	CHAIN WITH ATTACHMENT	5BA02A4X063126	2
6	VSTA0014	BEARING	5BE010606ZZ	6
7	VSTA0056	BEARING	5BE016004ZZ	2
8	VSTA0054	BLOCK BEARING	5BE03UFL004	2
9	VSA00058	SPROCKET	5BF011B3X15T10M64	1
10	VSTA0058	SPROCKET	5BF011B3X18T15M65	1

48 Parts List

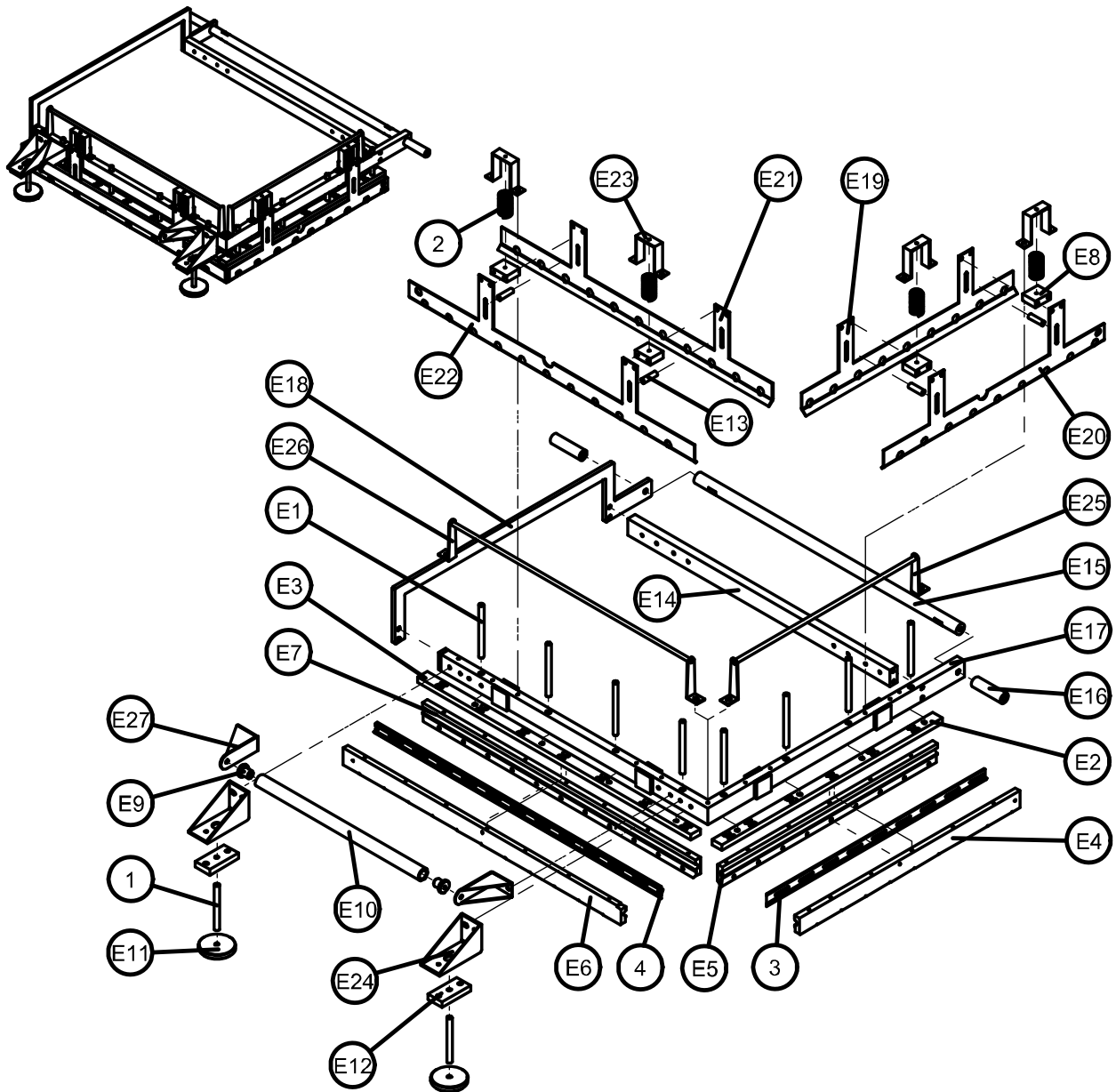
ITEM	PART NO.	DESCRIPTION	REFERENCE	Q'TY
11	VSTA0057	SPROCKET	5BF011B4X18T20M66	2
12	VSSA0006	INDUCTION MOTOR	5CH014IK25GNST	1
13	VSTA0095	GEAR BOX	5CH614GN36K	1

L-Sealer and Support with L-Seal Controls – VSSA00266
 (LTS504(ENG)X2-E)



ITEM	PART NO.	DESCRIPTION	REFERENCE	Q'TY
E1	VSSA0314	L-SEALER UPPER FRAME	LTS504(ENG)X2-E-1	1
E2	VSSA0315	L-SEALER MID FRAME W/ L-SEAL CONTROLS	LTS504(ENG)X2-E-2	1

L-Sealer Upper Frame – VSSA0314 (LTS504(ENG)X2-E1)

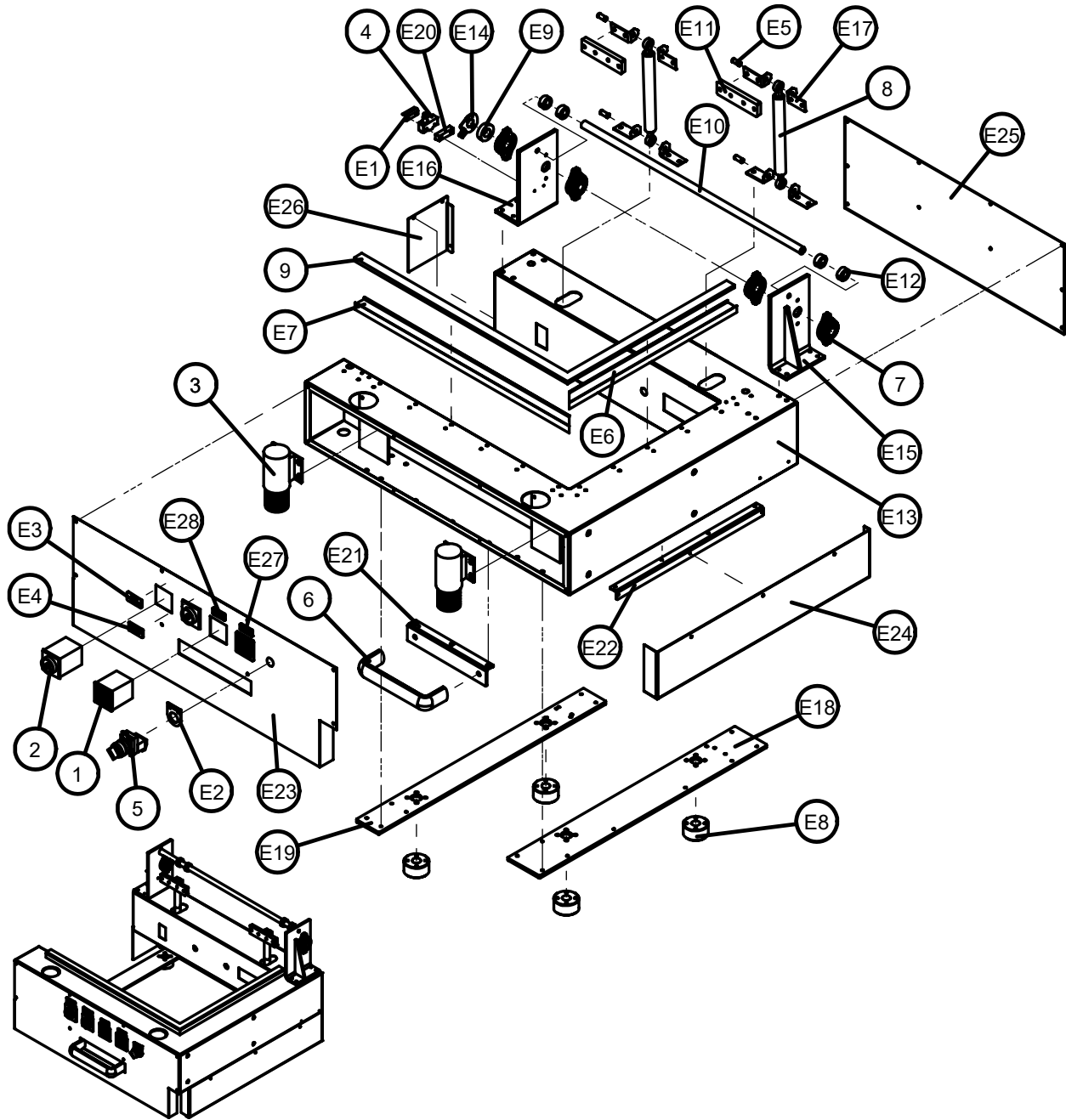


ITEM	PART NO.	DESCRIPTION	REFERENCE	Q'TY
E1	VSSA0319	SCREW	5HFLTS504(ENG)X2EM01	8
E2	VSSA0320	HORIZONTAL UPPER BOARD	5HFLTS504(ENG)X2EM02	1
E3	VSSA0321	VERTICAL UPPER BOARD	5HFLTS504(ENG)X2EM03	1
E4	VSSA0322	HORIZONTAL SEAL SEAT (FRONT)	5HFLTS504(ENG)X2EM04	1
E5	VSSA0323	HORIZONTAL SEAL SEAT (REAR)	5HFLTS504(ENG)X2EM05	1
E6	VSSA0324	VERTICAL SEAL SEAT (FRONT)	5HFLTS504(ENG)X2EM06	1
E7	VSSA0325	VERTICAL SEAL SEAT (REAR)	5HFLTS504(ENG)X2EM07	1

ITEM	PART NO.	DESCRIPTION	REFERENCE	Q'TY
E8	VSSA0326	FIXED SEAT	5HFLTS504(ENG)X2EM08	4
E9	VSSA0327	HANDLE SHAFT	5HFLTS504(ENG)X2EM09	2
E10	VSSA0328	HANDLE	5HFLTS504(ENG)X2EM10	1
E11	VSSA0329	PRESSURE PLATE	5HFLTS504(ENG)X2EM12	2
E12	VSSA0330	ADJUSTMENT SEAT	5HFLTS504(ENG)X2EM13	2
E13	VSSA0331	ISOLATION COLLAR	5HFLTS504(ENG)X2EM14	4
E14	VSSA0332	CROSSBAR	5HFLTS504(ENG)X2EM23	1
E15	VSSA0333	AXLE	5HFLTS504(ENG)X2EM24	1
E16	VSSA0334	AXLE	5HFLTS504(ENG)X2EM25	2
E17	VSSA0335	UPPER SEALING ARM	5HELTS504(ENG)X2EP01	1
E18	VSSA0336	LEFT SUPPORT BOARD	5HELTS504(ENG)X2EP02	1
E19	VSSA0337	HORIZONTAL INNER BOARD	5HELTS504(ENG)X2EP03	1
E20	VSSA0338	HORIZONTAL OUTER BOARD	5HELTS504(ENG)X2EP05	1
E21	VSSA0339	VERTICAL INNER BOARD	5HELTS504(ENG)X2EP06	1
E22	VSSA0340	VERTICAL OUTER BOARD	5HELTS504(ENG)X2EP07	1
E23	VSSA0341	LIMIT BOARD	5HELTS504(ENG)X2EP08	4
E24	VSSA0342	FIXED SEAT	5HELTS504(ENG)X2EP12	2
E25	VSSA0343	FIXED ROD-1	5HELTS504(ENG)X2EP13	1
E26	VSSA0344	FIXED ROD-2	5HELTS504(ENG)X2EP14	1
E27	VSSA0345	HANDLE SEAT	5HELTS504(ENG)X2EP15	2

ITEM	PART NO.	DESCRIPTION	REFERENCE	Q'TY
1	VSSA0315	HEX SOCKET SET SCREW	5EE63M08X70	2
2	VSSA0316	COMPRESSION SPRING (SUS)	5EH140.5X07X40X12N	4
3	VSSA0317	TRANSVERSE DIRECTION (TD) CUTTER	HOT KNIFE TD	1
4	VSSA0318	MACHINE DIRECTION (MD) CUTTER	HOT KNIFE MD	1

L-Sealer Mid Frame with L-Sealer Controls – VSSA0314 (LTS504(ENG)X2-E-2)



ITEM	PART NO.	DESCRIPTION	REFERENCE	Q'TY
E1	VSSA0349	FIXED PLATE	5HELTS504(ENG)X2AP02	1
E2	VSSA0350	INDICATOR-5	5FD01HNF	1
E3	VSSA0351	INDICATOR-9	5FD01ST	1

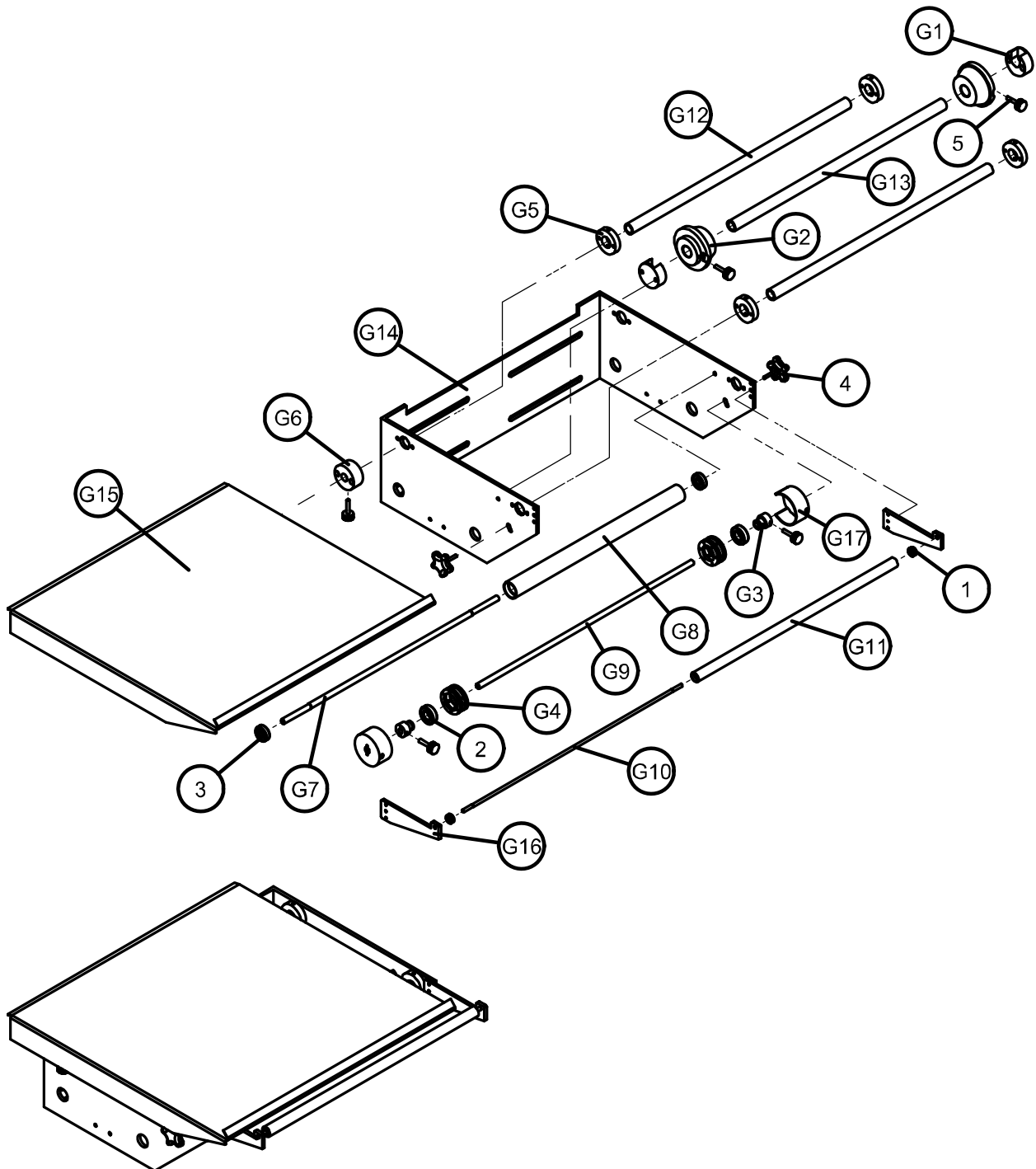
ITEM	PART NO.	DESCRIPTION	REFERENCE	Q'TY
E4	VSSA0352	INDICATOR-10	5FD01TAT	1
E5	VSSA0353	AXLE	5HFLTS504(ENG)X2EM11	4
E6	VSSA0354	HORIZONTAL SEAL SEAT	5HFLTS504(ENG)X2EM15	1
E7	VSSA0355	VERTICAL SEAL SEAT	5HFLTS504(ENG)X2EM16	1
E8	VSSA0356	SCREW SEAT	5HFLTS504(ENG)X2EM26	4
E9	VSSA0357	FIXED RING	5HFLTS504(ENG)X2EM27	1
E10	VSSA0358	BAR	5HFLTS504(ENG)X2EM28	1
E11	VSSA0359	SUPPORT PAD	5HFLTS504(ENG)X2EM29	2
E12	VSSA0360	LIMIT RING	5HFLTS504(ENG)X2EM30	4
E13	VSSA0361	SEALING BODY	5HELTS504(ENG)X2EP03	1
E14	VSSA0362	FRETTING PLATE	5HELTS504(ENG)X2EP09	1
E15	VSSA0363	FIXED SEAT (RIGHT)	5HELTS504(ENG)X2EP10	1
E16	VSSA0364	FIXED SEAT (LEFT)	5HELTS504(ENG)X2EP11	1
E17	VSSA0365	CYLINDER SEAT	5HELTS504(ENG)X2EP16	8
E18	VSSA0366	UPPER LIFTING BOARD 1	5HELTS504(ENG)X2EP17	1
E19	VSSA0367	UPPER LIFTING BOARD 2	5HELTS504(ENG)X2EP18	1
E20	VSSA0368	CUSHION	5HELTS504(ENG)X2EP19	1
E21	VSSA0369	FIXED PLATE	5HELTS504(ENG)X2EP20	1
E22	VSSA0370	FIXED PLATE	5HELTS504(ENG)X2EP21	1
E23	VSSA0371	PANEL	5HELTS504(ENG)X2EP22	1
E24	VSSA0372	COVER 1	5HELTS504(ENG)X2EP23	1
E25	VSSA0373	COVER 2	5HELTS504(ENG)X2EP24	1
E26	VSSA0374	COVER 3	5HELTS504(ENG)X2EP25	1
E27	VSSA0375	INDICATOR	5FD0160X40X12	1
E28	VSSA0376	INDICATOR	5FD0161X40X12	1

ITEM	PART NO.	DESCRIPTION	REFERENCE	Q'TY
1	4501340	TEMPERATURE CONTROLLER	5AA01C10T6DTD0100	2
2	VSCP0003	TIME RELAY	5AA09H5BM124V	2
3	VSSA0144	SOLENOIDS	5AA14CS40932B	2
4	VSSA0008	BASIC SWITCH	5AB06Z15GQB	1
5	VSSA0346	SELECTOR SWITCH	5AB61AC222P2A2B	1
6	VSSA0150	BOW TYPE HANDLE	5BC03AGS200	1

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ITEM	PART NO.	DESCRIPTION	REFERENCE	Q'TY
7	VSSA0149	LINEAR BUSHING	5BE03UFL003	4
8	VSSA0347	CYLINDER	5DA09GSS22096A	2
9	VSSA0348	SILICON PAD	CUSTOMER PARTS	1

Product Tray with Film Holder and Perforator – VSSA0267
 (LTS504(ENG)X2-G)



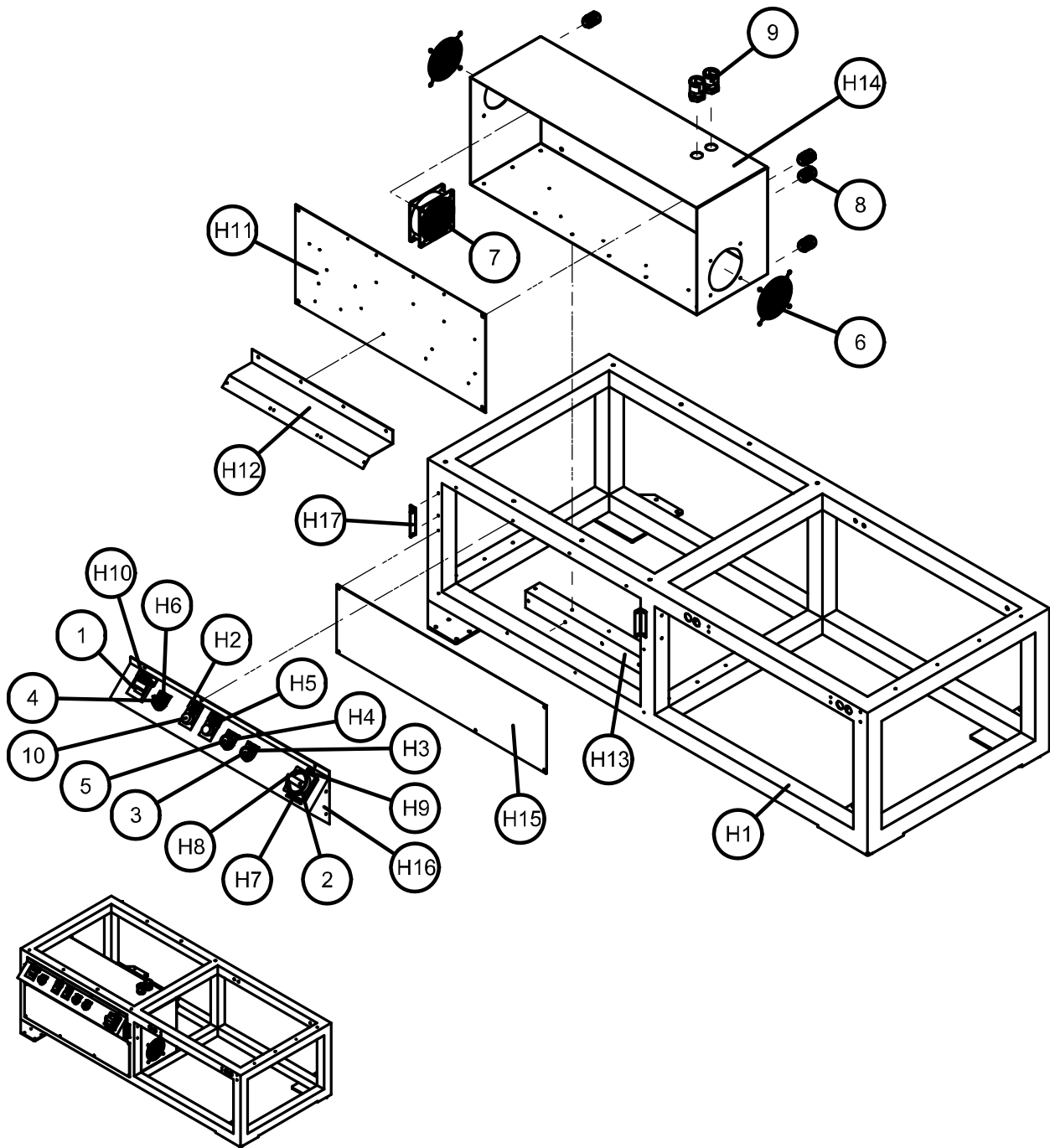
ITEM	PART NO.	DESCRIPTION	REFERENCE	Q'TY
G1	VSSA0377	FIXED SEAT	5HFLTS504(ENG)X2GM01	2
G2	VSSA0378	SHRINK WRAP FIXED BLOCK	5HFLTS504(ENG)X2GM02	2
G3	VSSA0379	PIN RING BUSHING	5HFLTS504(ENG)X2GM03	2

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ITEM	PART NO.	DESCRIPTION	REFERENCE	Q'TY
G4	VSSA0380	PIN RING	5HFLTS504(ENG)X2GM04	2
G5	VSSA0381	FIXED SEAT	5HFLTS504(ENG)X2GM05	4
G6	VSSA0382	FIXED SEAT-1	5HFLTS504(ENG)X2GM06	1
G7	VSSA0383	FEED ROLLER AXLE-1	5HFLTS504(ENG)X2GM07	1
G8	VSSA0384	FEED ROLLER-1	5HFLTS504(ENG)X2GM08	1
G9	VSSA0385	PIN RING AXLE	5HFLTS504(ENG)X2GM09	1
G10	VSSA0386	FEED ROLLER AXLE-2	5HFLTS504(ENG)X2GM10	1
G11	VSSA0387	FEED ROLLER-2	5HFLTS504(ENG)X2GM11	1
G12	VSSA0388	GUIDE ROD-1	5HFLTS504(ENG)X2GM12	2
G13	VSSA0389	GUIDE ROD-2	5HFLTS504(ENG)X2GM13	1
G14	VSSA0390	RACK	5HELTS504(ENG)X2GP01	1
G15	VSSA0391	MEMBRANE PLATE	5HELTS504(ENG)X2GP02	1
G16	VSSA0392	ROLLER SUPPORT	5HELTS504(ENG)X2GP03	2
G17	VSSA0393	PIN RING COVER	5HELTS504(ENG)X2GP04	2

ITEM	PART NO.	DESCRIPTION	REFERENCE	Q'TY
1	VSTA0014	BEARING	5BE010606ZZ	2
2	VSSA0251	BEARING	5BE016003ZZ	2
3	VLA00034	BEARING	5BE016200ZZ	2
4	4502389	PLUM HANDLE	5BC04GN01ST32M06X16	2
5	VSSA0250	EMBOSSING SCREW	5BC04801025M630	5

Main Electrical Panel and Tunnel Control Panel – VSCP0038 (LTS504(ENG)X2-H)



ITEM	PART NO.	DESCRIPTION	REFERENCE	Q'TY
H1	VSCP0044	MAIN FRAME	5HELTS504(ENG)X2AP08	1
H2	VSCP0045	INDICATOR-1	5FD01BS	1
H3	VSCP0046	INDICATOR-2	5FD01CBF	1
H4	VSCP0047	INDICATOR-3	5FD01CBN	1

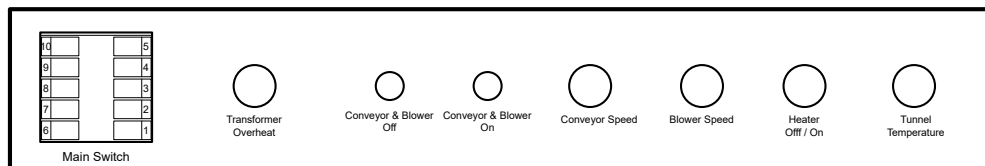
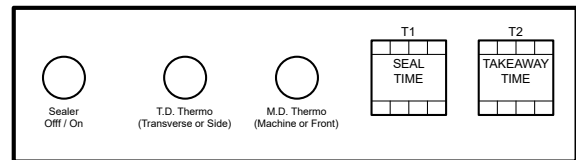
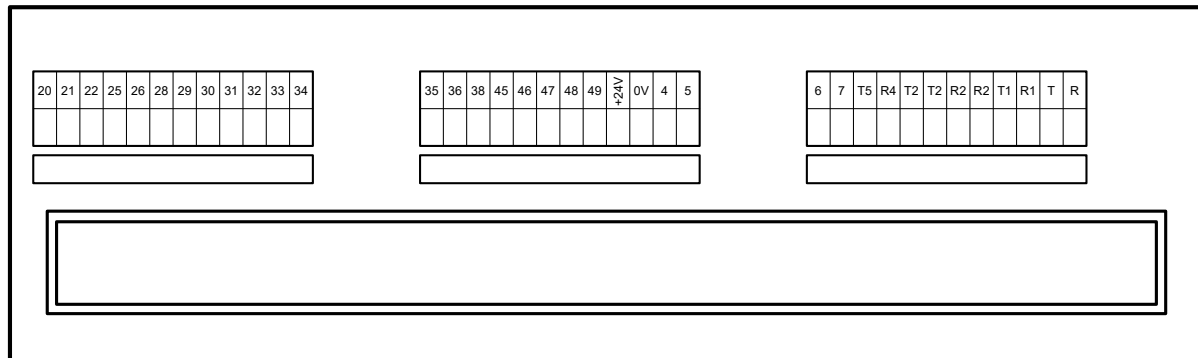
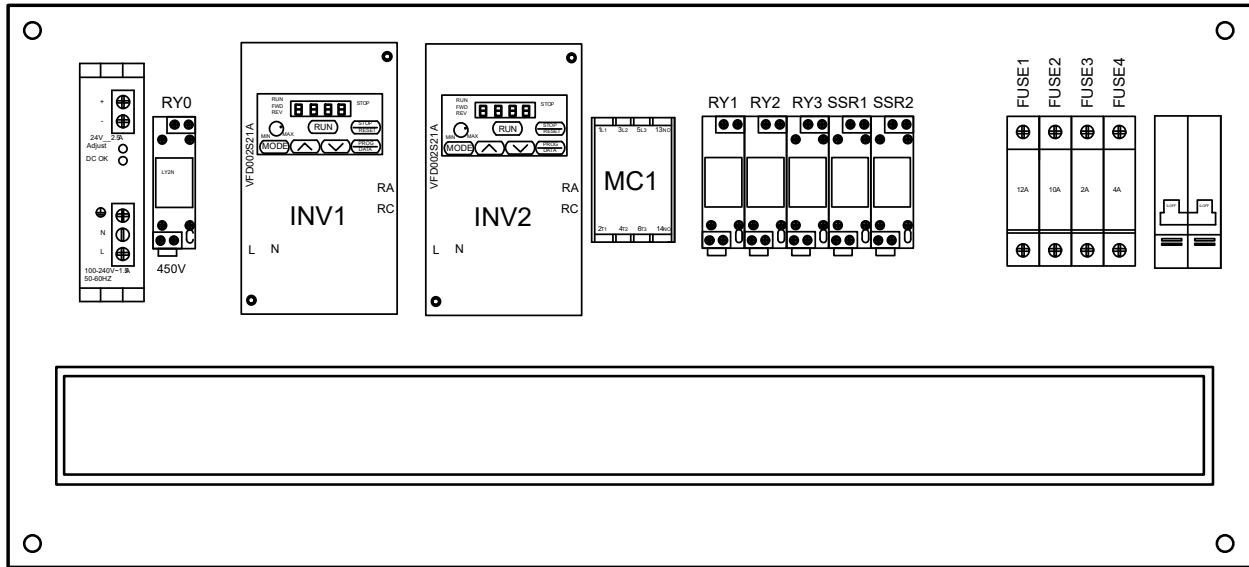
58 Parts List

ITEM	PART NO.	DESCRIPTION	REFERENCE	Q'TY
H5	VSCP0048	INDICATOR-4	5FD01CS	1
H6	VSCP0049	INDICATOR-5	5FD01HNF	1
H7	VSCP0050	INDICATOR-6	5FD01MS	1
H8	VSCP0051	INDICATOR-7	5FD01OF	1
H9	VSCP0052	INDICATOR-8	5FD01ON	1
H10	VSCP0053	INDICATOR-12	5FD01TT	1
H11	VSCP0054	SWITCHBOARD	5HELTS504(ENG)X2HP01	1
H12	VSCP0055	FIXED BOARD	5HELTS504(ENG)X2HP02	1
H13	VSCP0056	CONNECTION BOARD	5HELTS504(ENG)X2HP03	1
H14	VSCP0057	ELECTRIC BOX	5HELTS504(ENG)X2HP04	1
H15	VSCP0058	COVER	5HELTS504(ENG)X2HP05	1
H16	VSCP0059	OPERATION PANEL	5HELTS504(ENG)X2HP06	1
H17	VSCP0060	CONNECTION BOARD	5HELTS504(ENG)X2HP07	2

ITEM	PART NO.	DESCRIPTION	REFERENCE	Q'TY
1	VSTA0001	TEMPERATURE CONTROLLER	5AA01MT48RC	1
2	VSCP0018	MAIN SWITCH	5AB16GN32H	1
3	VSCP0039	PUSH BUTTON SWITCH	5AB31ABF221B2R	1
4	VSCP0040	SELECTOR SWITCH	5AB61AC222P2A2B	1
5	4501321	PUSH BUTTON SWITCH	5AB66ABLFS221A8G	1
6	VSCP0041	FAN COVER	5AG1301	2
7	4502361	FAN COVER	5AG1312X12X2	1
8	VSCP0042	NYLON CABLE END GLAND	5AI21CG20X1	4
9	VSCP0043	STRAIGHT CONNECTOR	5AI34BVNDP213GT	2
10	VSCP0008	POTENTIOMETER	5CC62VR20KY	2

Electrical

Electrical Panel



Electrical Parts List

DESIGNATOR	DESCRIPTION	PART NO.
POWER SUPPLY REIGNPOWER	POWER SUPPLY, 24 VDC REIGNPOWER, DRP024V060W1AZ	VSCP0006
MC1	CONTACTOR 1	VSCP0002
MC2	CONTACTOR 2	VSCP0001
FUSE 1	FUSE, 12 AMP	VSCP0010
FUSE 2	FUSE, 10 AMP	VSCP0011
FUSE 3	FUSE, 2 AMP	VSCP0013
FUSE 4	FUSE, 4 AMP	VSCP0012
RY1, RY2, RY3	RELAY 1, RELAY 2, RELAY 3; RELAY 24 VOLT DC	VSCP0016
RY5	RELAY 220 VOLT	VSCP0015
T1 – T2	TIMERS: CONVEYOR & MAGNET	VSSA0004

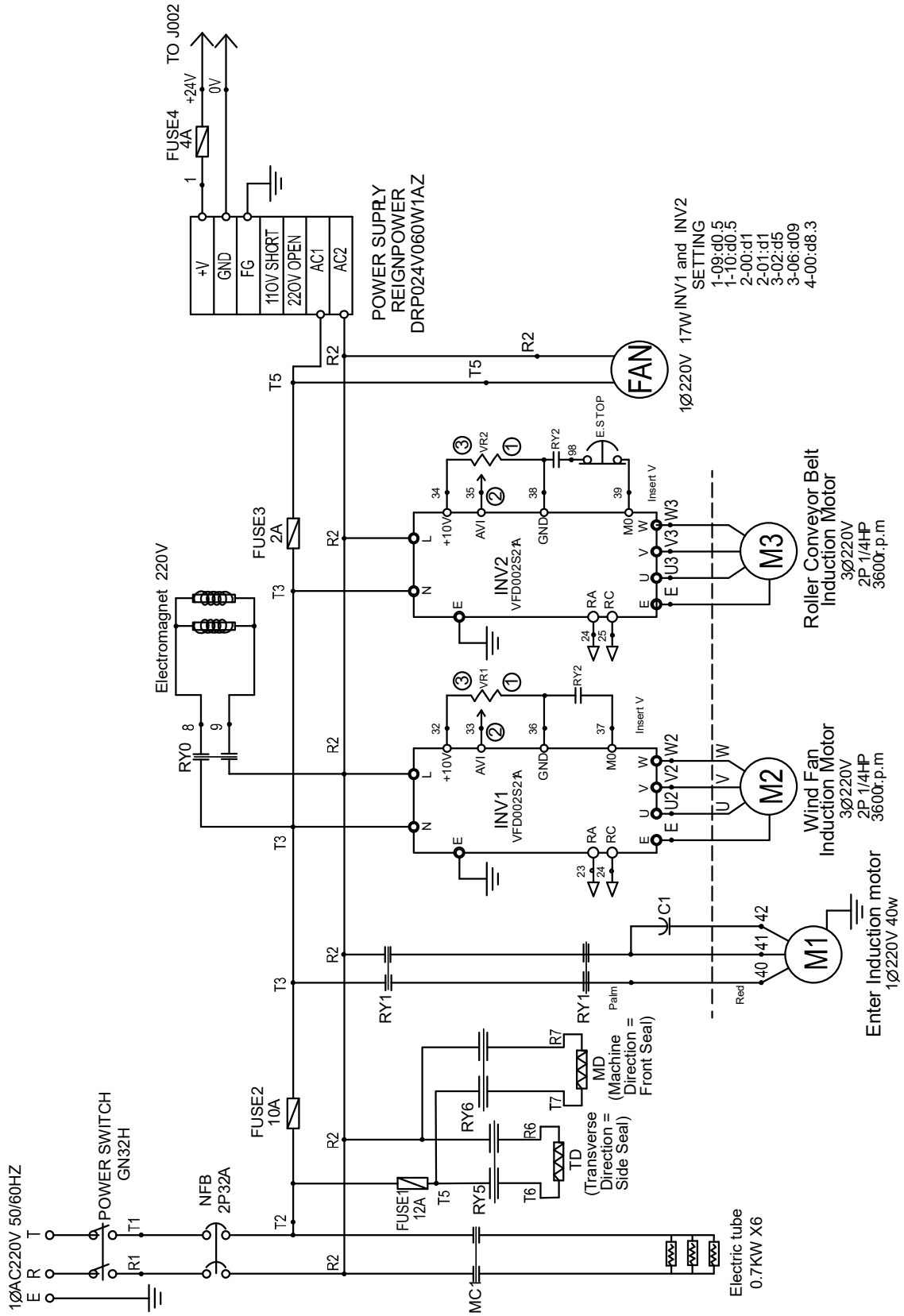
Items in the table above are shown in the Electrical Panel drawing on the previous page and the Electrical Schematics on the following pages.

DESIGNATOR	DESCRIPTION	PART NO.
HEATER 0.7 KW	HEATER ROD 0.7 KILOWATT W × 6 – 220V (TUNNEL)	VSTA0002
220V/45V	TRANSFORMER, 220V / 45V	VSCP0005
HOT KNIFE MD	MACHINE DIRECTION (MD) CUTTER / SEALER	VSSA0318
HOT KNIFE TD	TRANSVERSE DIRECTION (TD) CUTTER / SEALER	VSSA0317
M1	TAKE AWAY CONVEYOR MOTOR 1Φ 220V 40W	VSSA0006
M2	BLOWER MOTOR 3Φ 220V 2P-½ HP 3600 RPM	VSTA0005
M3	TUNNEL CONVEYOR MOTOR 3Φ 220V 25W	VSTA0003
TEMP. PROBE	TEMPERATURE PROBE	VSTA0007
L. S.	LIMIT SWITCH 250V 25A	VSSA0008
TEMP. CONTROLLER	TEMPERATURE CONTROLLER	VSTA0001

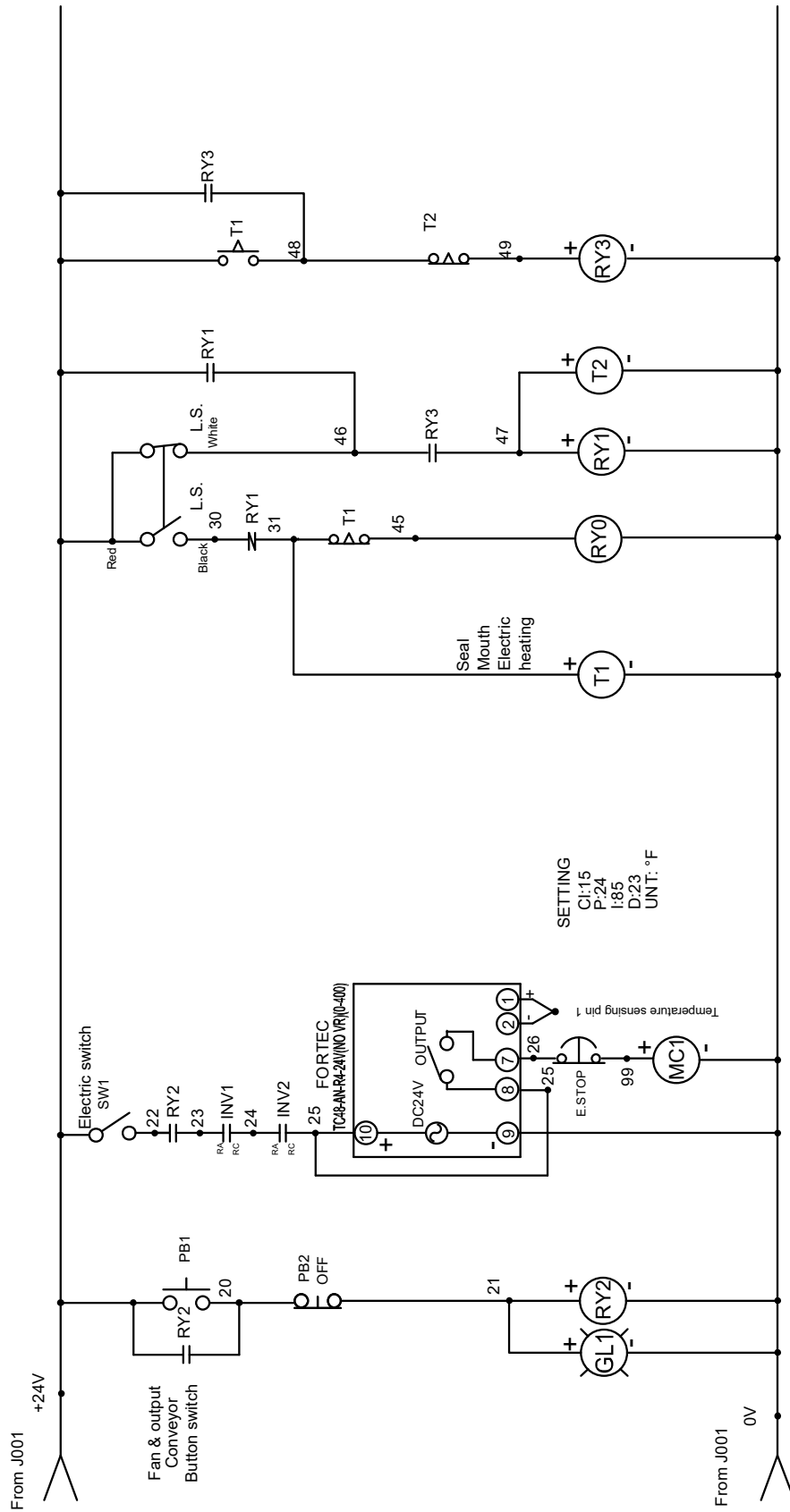
Items in the table above are shown in the Electrical Schematics on the following pages.

Appendix A

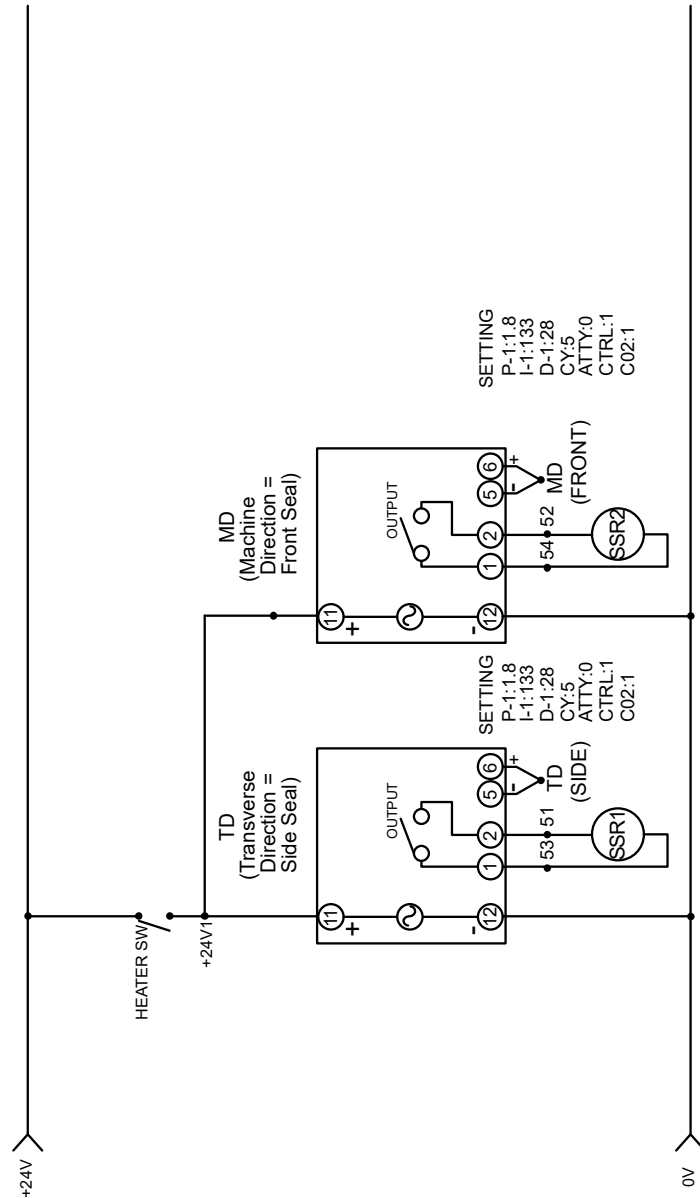
Electrical Schematic (Sheet 1 of 3)



Electrical Schematic (Sheet 2 of 3)



Electrical Schematic (Sheet 3 of 3)



Warranty Statement

Eastey Hot-Knife L-Sealer and Tunnel Combo

Warranty Statement

Eastey warrants that all of the products it ships will be in good working order and free from defects in material and workmanship for a period of one (1) year from the date of shipment by Eastey and will conform to the published specifications for that product.

Warranty Period — Specific Items

Drive motor(s): 1 year

End Curtains 30 days

All other parts: 1 year (Except for moving parts which are subject to normal wear, tear and replacement which are warranted to be free from defects in material and workmanship.)

Shipping Policy

Customer pays all incoming shipping. If the item is defective and under warranty, Eastey pays return shipping charges for least costly method. If expedited shipping is desired, customer must furnish his shipping account and shipping fees will be charged to that account.

Warranty Verification

If you conclude that a product may be defective and may be covered by warranty, obtain a Return Material Authorization number by calling our technical support number (toll free at 1-800-835-9344, or 763-428-4846 or Fax: 763-795-8867 or e-mail: info@eastey.com). Once an RMA number has been obtained, return the defective item to Eastey. Eastey will analyze the product and, if found to be defective, we will at our option, replace or repair the item. If the item is found to be not eligible for warranty, you will be notified and may decide on disposition. Defective products will be replaced or repaired as promptly as possible

Warranty Eligibility

The warranty provided by Eastey is only to the original buyer.

Limited Warranty

THE ABOVE WARRANTY IS EXCLUSIVE AND IN LIEU OF ALL OTHER WARRANTIES, WHETHER EXPRESSED OR IMPLIED, INCLUDING THE IMPLIED WARRANTIES OF MERCHANTABILITY, FITNESS FOR A PARTICULAR PURPOSE AND NONINFRINGEMENT.

Disclaimer of Damages

REGARDLESS OF WHETHER ANY REMEDY SET FORTH HEREIN FAILS OF ITS ESSENTIAL PURPOSE, IN NO EVENT WILL EASTEY BE LIABLE FOR ANY SPECIAL, CONSEQUENTIAL, INDIRECT OR SIMILAR DAMAGES, INCLUDING LOST PROFIT OR LOST OPPORTUNITIES OF ANY TYPE ARISING OUT OF THE USE OR INABILITY TO USE THESE PRODUCTS EVEN IF EASTEY HAS BEEN ADVISED OF THE POSSIBILITY OF SUCH DAMAGES.

Customer Support

Eastey Technical Service

For help installing or operating the Eastey Hot Knife L- Sealer and Tunnel Combo, please contact your authorized Eastey reseller or Eastey Technical Service at one of the numbers listed below.

Toll-Free Phone	800-835-9344
Phone	763-428-4846
Fax	763-795-8867
E-mail	eastey@eastey.com
Web	www.eastey.com

Thanks again for your purchase of Eastey products. We are pleased to be a part of your package sealing needs.



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