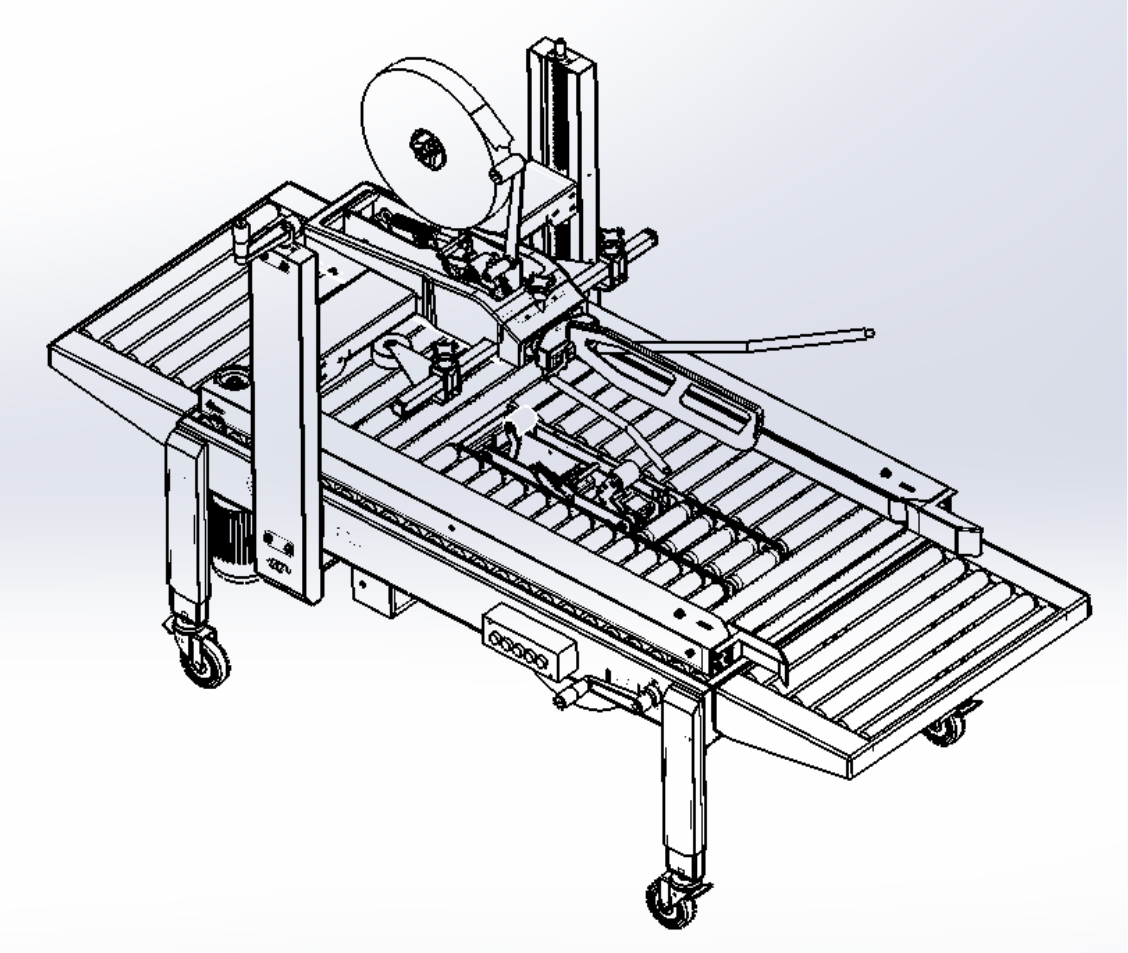
02 9452-3566
sales@getpacked.com.au

Extend the partnership

SEMI-AUTOMATIC

CARTON SEALING MACHINE

WITH TOP FLAP CLOSER



MODEL: 2-GPEXC-133SDN

OPERATION MANUAL

2025-01

EC Declaration of Conformity

According to the following EU Directives:

- Machinery Directive: 2006/42/EC
- Electromagnetic Compatibility Directive 2014/30/EU

We, **EXTEND GREAT INTERNATIONAL CORP.**

Add: 20F, No. 309, Sec. 2, Taiwan Blvd., Taichung, Taiwan R.O.C

Tel: +886-4-2326-5568 Fax: +886-4-2326-2268

Declare that the machines mentioned hereafter:

◎Product: Carton Sealing Machine

◎Model: EXC-133SDN

◎Serial No.:

◎Functions: They are designed and manufactured to be used for sealing of carton

The person who compile technical file established within the EU:

Name: SGS UK

Address: SGS United Kingdom Rossmore Business Park, Ellesmere Port, Cheshire CH65 3EN

They are designed and manufactured in compliance with the essential health and safety requirements of the Machinery Directive and Electromagnetic Compatibility Directive, and are based on the following European harmonized standards:

- EN ISO 12100: 2010 / Safety of Machinery - General principles for design / Risk Assessment and Risk reduction
- EN 60204-1:2006/AC:2010 / Safety of machinery - Electrical equipment of machines - Part 1: General requirements
- EN 415-3:1999+A1:2009 / Safety of packaging machines - Part 3: Form, fill and seal machines
- EN 415-10:2014 / Safety of packaging machines - Part 10: General Requirements
- EN ISO 13849-1:2008/AC:2009 /Safety of machinery — Safety-related parts of control systems Part 1: General principles for design
- EN 61000-6-2:2005 / Electromagnetic compatibility (EMC) - Part 6-2: Generic standards - Immunity for industrial environments
- EN 61000-6-4:2007/A1:2011 / Electromagnetic compatibility (EMC) - Part 6-4: Generic standards - Emission standard for industrial environments.

Authorized representative in European Community: (if applicable)

Representative : *Robert Lai / President*

Place / Date : *Taichung City, Taiwan. / April 22, 2016.*

1 GENERAL SAFETY INSTRUCTIONS

2 MACHINE INFORMATION

3 BEFORE OPERATING THE MACHINE

4 Adjustments

1. GENERAL SAFETY INSTRUCTIONS

1.1 Basic Operation

- The manual and the safety remarks are to be read before use. The operator manual should be kept with the machine at all times. Intervals for maintenance and inspections are to be adhered to.
- This machine was built with state of the art technology and rigid adherence to safety standards.
- Unless used properly, it can cause injury to operators or persons in close proximity to the machine. In addition, improper use can cause damage to the machine or property around the machine.

1.2 Basic Safety Precautions

- The user is to be instructed in all other generally applicable legal and other mandatory regulations relevant to accident prevention and environmental protection in addition to the operating instructions.
- For safety reasons, long hair must be tied back or otherwise secured, garments must be close fitting and no jewelry may be worn.
- Use protective equipment whenever required by circumstances or by law. 
- Carefully observe all safety instructions and warnings attached to the machine and make sure that they are always complete and perfectly legible.
- Always make certain that persons being trained and instructed in working on or with the machine are permanently supervised by an experienced person.
- Work on the electrical system and equipment of the machine is only to be carried out by a skilled electrician or by persons under the supervision and guidance of a skilled electrician and in accordance with the rules and regulations of electrical engineering.

1.3 Safety Instructions Governing Specific Operational Phases

- Avoid any operation mode that might be unsafe.
- All necessary precautions to ensure that the machine is only used being in a safe and reliable state are to be taken. The machine is only to be operated if all protective and safety devices, including removable safety devices, emergency shut-off equipment, noise-protection elements and exhaust systems are in right place and fully functional.
- The machine is to be checked for damage and defects at least once per work shift. Any changes including the working behavior of the machine are to be reported to competent persons immediately. If necessary, the machine is to be stopped and locked immediately.
- In case of any malfunction the machine must be stopped and locked until the defect has been eliminated.
- Generally make sure that nobody is at risk before starting up the machine.
- All personnel that will be operating this machine should be thoroughly trained in all phases of operation and safety.
- Always tighten unscrewed connections after maintenance and repair.
- After completing maintenance and repair all safety devices removed for setting up or repairing the machine must be reinstalled and checked for functionality prior to putting the machine back into service.
- To minimize the environmental impact all consumables and replaced parts must be disposed of safely.
- Before starting the machine check that the accessories have been stowed away safely.
- Do not attempt any operation that may be a risk to the stability of the machine.

1.4 Warning of Electrical Dangers 

- Immediately remove power to the machine in case of trouble in the electrical system.
- Replace a fuse with one with the same style and ratings; pay particular attention to matching the specified current.
- Any electrical work performed on the equipment must be conducted by a skilled electrician or under the supervision of a skilled electrician. All work must be observed good electrical engineering practice and follow safety rules and local wiring standards.
- Inspect the electrical equipment of the machine at regular intervals. Tighten any loose connections. Check wiring for scorch marks; replace scorched wiring and determine and correct the reason for the overheating.
- When working on live equipment, ensure that a second person is available to cut power in case of an emergency. When appropriate, secure the working area with safety tape and a warning sign. Use insulated tools for electrical work.
- Before working on high-voltage assemblies, turn off the power supply. Carefully discharge the supply cable and short-circuit any energy-storage components such as capacitors.
- If the equipment was moved, carefully refit and refasten all parts removed for transport before reapplying power.
- Before moving the machine, remember to disconnect the power cable.

1.5 Grounding Instructions Shall Include the Following

- This product must be grounded. In the event of an electrical short circuit, grounding reduces the risk of electric shock. This product is equipped with a cord that has a grounding wire and an appropriate grounding plug. The plug must be plugged into an outlet that is properly installed and grounded in accordance with all local codes and ordinances.
- If repair or replacement of the cord or plug is necessary, connect the ground wire to the ground terminal of the plug. The wire with green insulation (with or without yellow stripes) is the grounding wire.
- Check with a qualified electrician or service person if the grounding instructions are not clear or if in doubt about the proper grounding of the machine. Do not modify the plug provided; if it will not fit the power outlet, have the proper outlet installed by a qualified electrician.
- This product is designed for use on a nominal AC circuit and has a grounding plug.

DANGER!

Improper installation of the grounding can result in electrocution.

1.6 Before Operating

- Verify that the power line voltage is correct.
- The machine must be properly grounded to avoid a shock hazard. All wiring must be in accordance with local wiring standards.
- The Carton Sealing machine can only be operated with OPP tape.

1.7 During Operation

- The size of the package should be under dimension in specification list.
- While running, check the unit for any unusual sounds or smoke emissions.
- Keep away from the moving part like belt and blade of tape head. Do not put your hands or body around belt or blade of tape head when the machine is running.

1.8 After operating

- Remove dust and dirt from the unit
- Turn off the power when the machine is not in use.

1.9 Signs

	**Caution!** **Electric Shock Hazard.**
	**Caution!** **Hot Surface.**
	**Caution!** **Moving Parts Can Crush Hand.**
	**Caution!** **Pinch Point Entanglement**
	**Caution! Blade.** **Cutting of Fingers or Hand**
	**Wear Eye Protection**
	**Refer to Operator Manual**

2. MACHINE INFORMATION

2.1 Areas of Application

Packaging Limitation

It's not possible to pack:

- Products larger or heavier than that allowed.
- Wet Products
- Flammable products
- Explosive products
- Agri-foodstuffs
- Pharmaceuticals
- Hazardous products

2.2 Environmental Information

The strapping machine shall be installed in the following conditions:

- Supply voltage: +-10% nominal supply voltage
- Source frequency: +-10% nominal frequency
- Ambient temperature: 5°C - 40°C (41°F-104°F).
- Relative humidity: not exceed 35~85%RH
- Please provide a suitable illumination around the machine for safety operation.

Conditions For Use

Make sure there is room for easy application and maintenance

The machine must be installed in a closed, well-ventilated area where there are no explosions or fire hazards Position the machine in a place free of humidity, flammable materials, gas or explosives. Make sure that it is level.

Please do not spray water or wet wipe machine body.

Noise - characteristic values

The noise emission values determined according to EN ISO 3746 for the sound power level or EN ISO 11202 for the sound pressure level at the workplace on the basis of the working conditions are as below:

A measurement uncertainty allowance of K = 4 dB(A) applies to the stated emission values.

Sound power level L_{WA} = 88.7 dB(A)

Emission sound pressure level at the workplace L_{PA} = 75.3 dB(A)

To minimize the emission sound pressure level, machine is equipped with a timer standby mode that can be adjusted by technician.

Demolition and Waste Disposal

The machine does not contain dangerous components or substances which require special disposal procedure. For that which concerns material elimination, comply with the Standards in the country where the machine has been disassembled.

2.3 Machine Description

This machine is manually operated to sealing OPP tape onto carton boxes with top flap closer. The box will be driven into the machine by the transit belt system, and top flap closer unit will close the top flaps of box, and the tape head unit will tap tape onto box and then do sealing & cutting. It is suitable for single box with tape sealing to ensure the box is sealed well to avoid product falling off from the box.

2.4 Safety Devices

DANGER!

Operate the machine only when all safety devices are at their place and are functioning correctly.

The machine has been constructed in accordance with the applicable legal regulations.

The machine is reliable in operation. Nevertheless the machine may constitute a danger if it is operated in improper or undue condition.

Danger points that cannot be avoided due to equipment design are equipped with safety devices. If necessary, these points are marked on the machine with warning signs, and in the manual under working safety instructions.

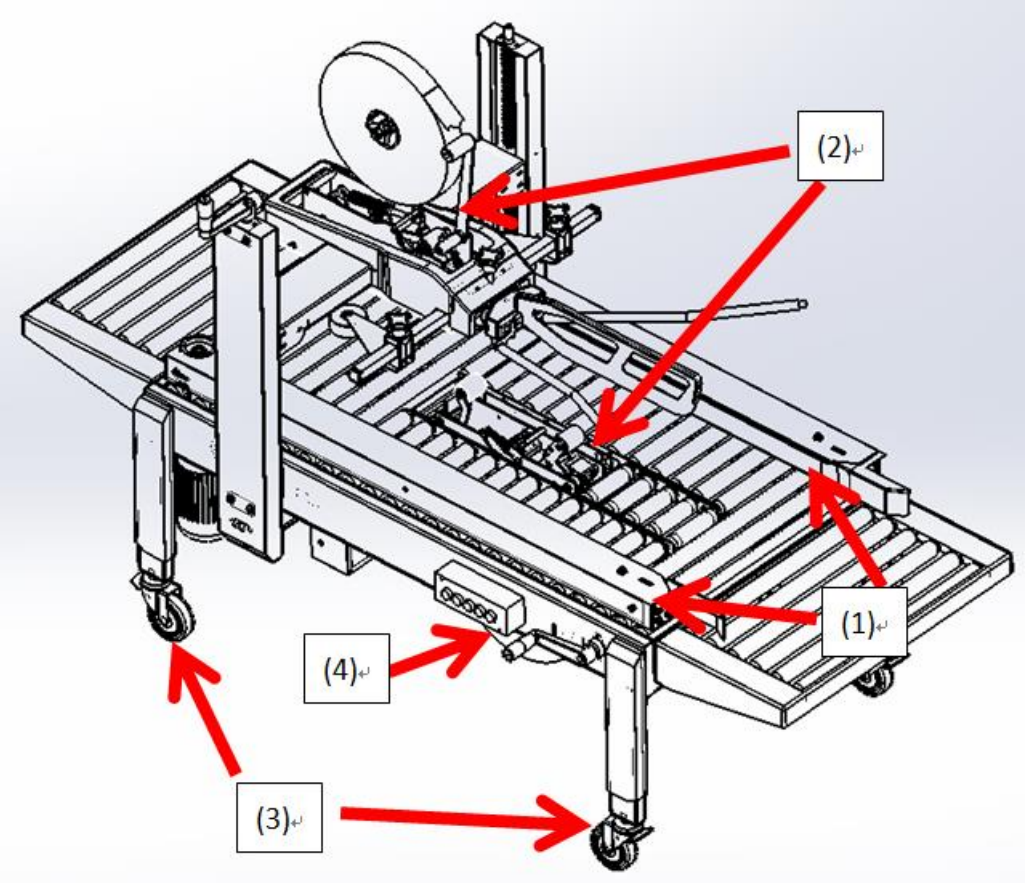
The machine is equipped with safety devices as:

- Warning labels
- Live parts are covered

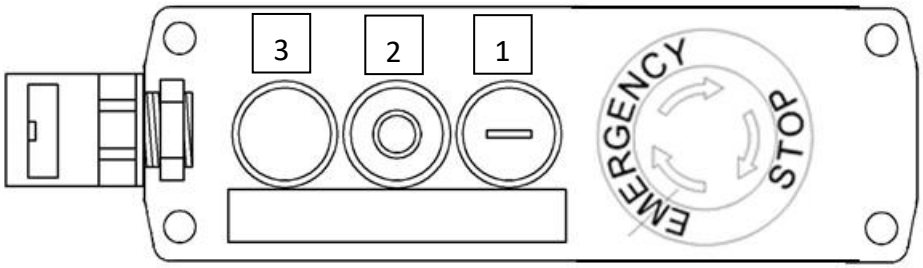
The belt system operates at a very high speed (23 meters/min) to transit boxes into machine to offer good efficiency of box taping performance.

The tape head unit operates with high efficiency with tape tapping, sealing and cutting. The blade is sharp to be able to reach good cutting behavior.

To prevent danger, avoid to touch the belt (1) and tape head (2) when machine is running.
To remove jammed box or tape, avoid to directly reach your hand into blade area though there is cover already cover around the blade area.
To move the machine, the four lockable casters (3) must be unlocked. Relock the four casters when the machine is in its new position.
In certain condition, you could press the emergency stop (4) with safety.



The machine is turned on when it is connected to AC power. Press START (1) to start machine, and press STOP (2) to stop machine. When the machine is running, the indicator light (3) will be ON, vice versa.



※ in cold temperature condition, it might take 2-3 minutes for motor to warm up for full speed.

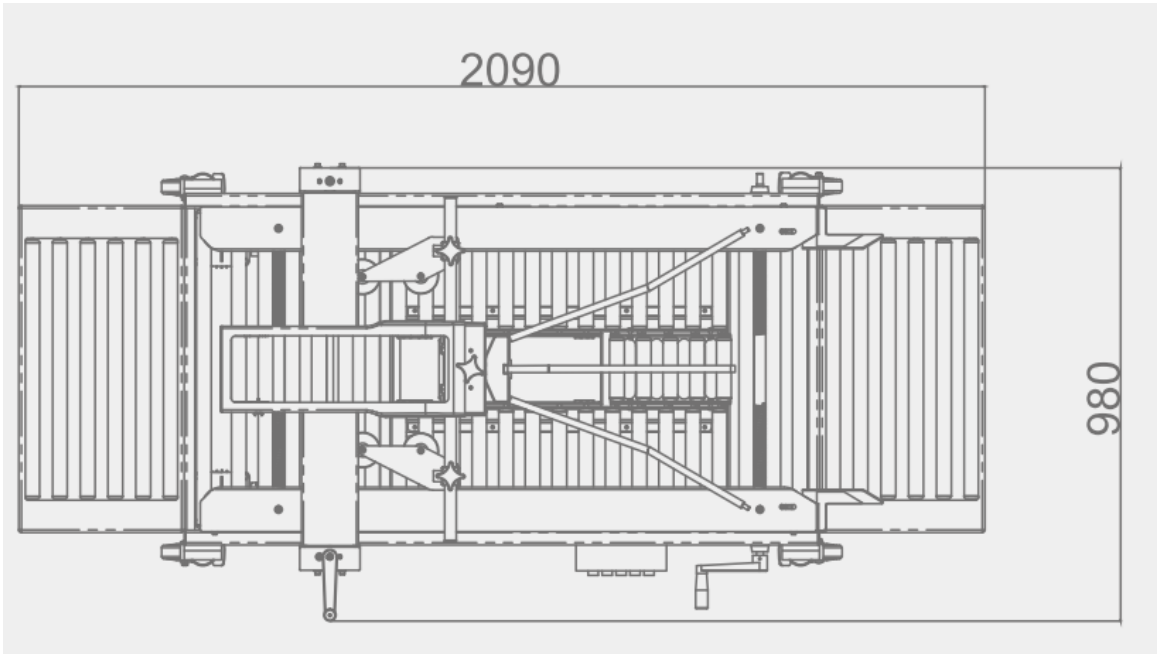
Caution!

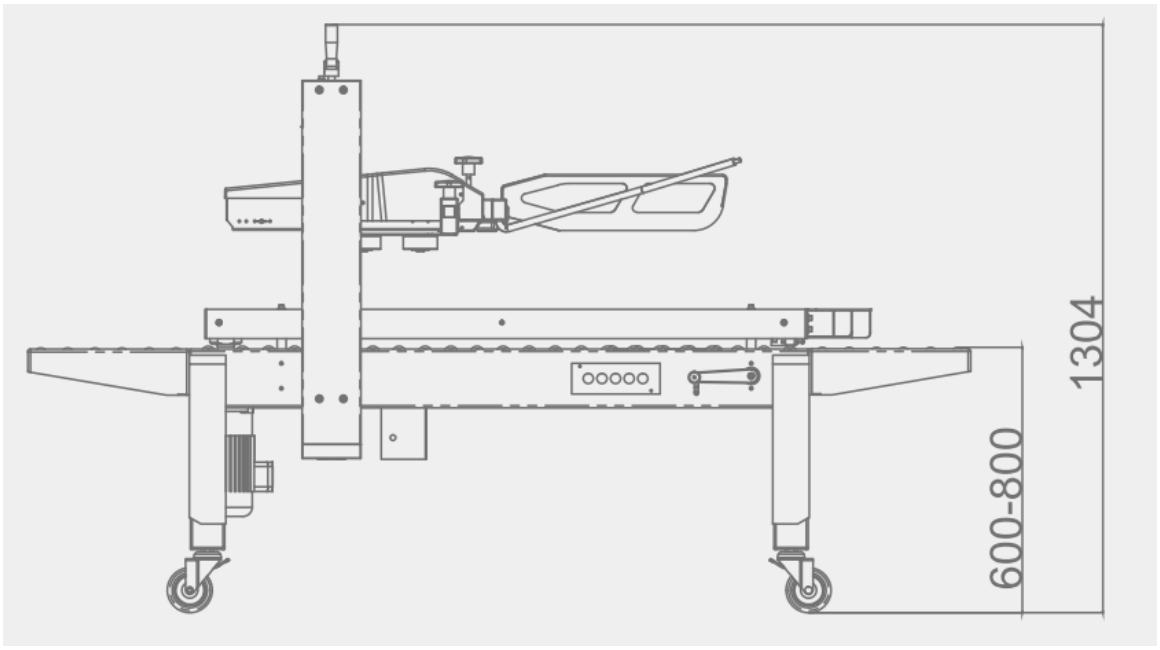
2.5 Technical Specification

2.5.1 Electrical Specification

System Configuration	L1+N+PE (GROUND)
Nominal Power	0.45kW
Rated Current	4.1/2.0/1.9 A
Rated Voltage	110V/220-230V/240V
Rated Frequency	50 /60Hz
Type of Current	AC- single phase

2.5.2 Technical information

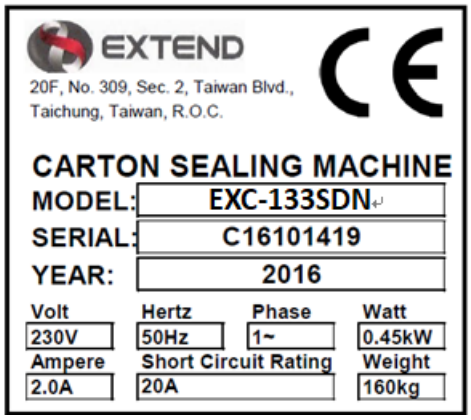




TAPE WIDTH	50 mm (2”) as standard 36 mm (1.5”) as option 75 mm (3”) as option
TAPE LEG LENGTH	50 mm tape : 50 ± 5 mm 75mm tape : 60 ± 5 mm
TAPE CORE DIAMETER	76.2 mm
TAPE OUTER DIAMETER	356 mm (14”)
BELT SPEED	23 meter/min
BOX CAPACITY	(MAX) L: unlimited W: 500mm H: 500mm (MIN) L: 120mm W: 110mm H: 120mm
BOX WEIGHT	0.5 Kg ~ 30 Kg
POWER CONSUMPTION	450 W
NOISE EMISSION	60 dB
AMBIENT TEMP.	5℃ - 40℃
WORKING HEIGHT	600~ 800mm (adjustable) OPTION WITH FLEXIBLE CONVEYOR
MACHINE SIZE	L: 2090mm (with outfeed roller table) W: 980mm (with hand crank) H: 1304mm (with hand crank)
MACHINE WEIGHT	172 Kg

2.6 Identification Data of the Machine

Each model is provided with a plate where it is easy to recover data which must be communicated to the manufacturer in case of problem or when requesting spare parts etc. (ref. 1-2-3-4) This plate also carries electrical technical data for installation of the machine. (ref. a-b-c-d-e-f-g).



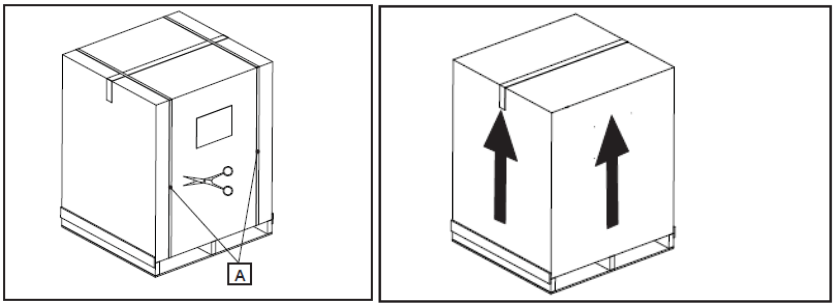
3. BEFORE OPERATING THE MACHINE

3.1 Shipping

The machine is delivered as a transport unit. The machine is loaded onto a wooden pallet with Polyester strap secured. Outside with carbon box also with Polyester strap secured.

3.2 Unload Machine from Pallet & Installation

Cut Polyester strap and then move the carbon box upward.

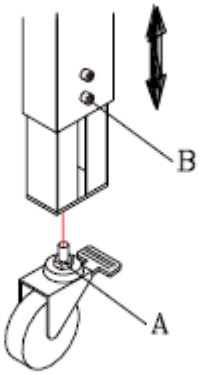


Remove polyester strap on machine, then assemble the casters onto EXC-133SD.

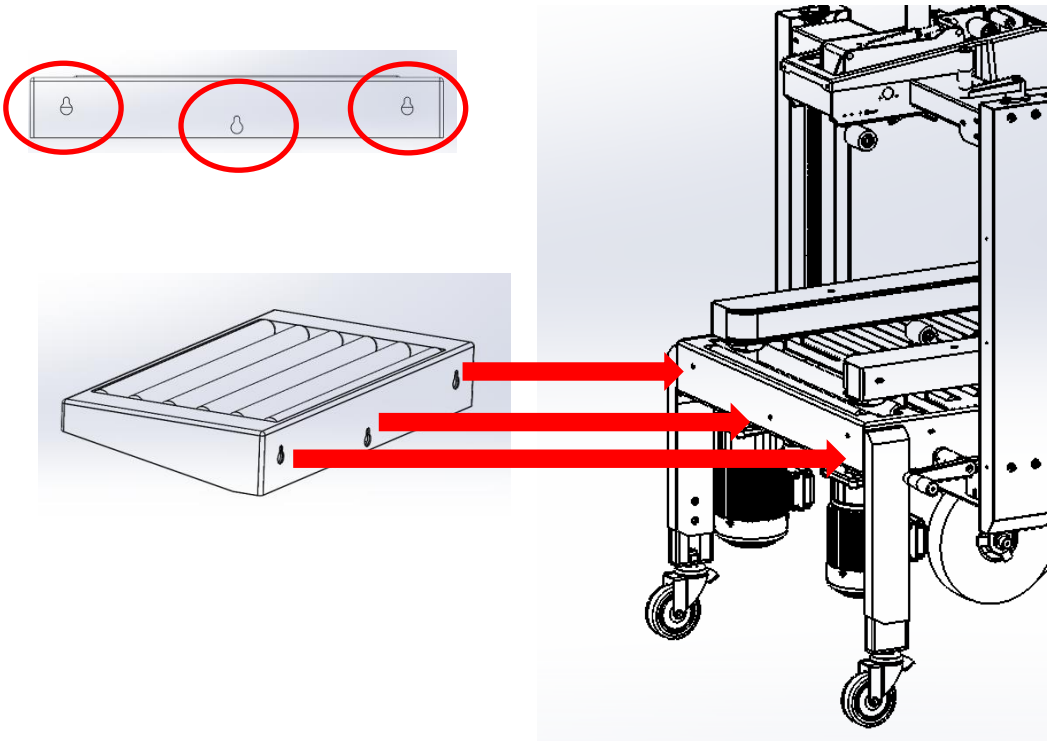
Fix caster thread (A) onto legs, then adjust two screws (B) to adjust table height.

※ Noted: Please ensure to lock the caster before assembling next caster

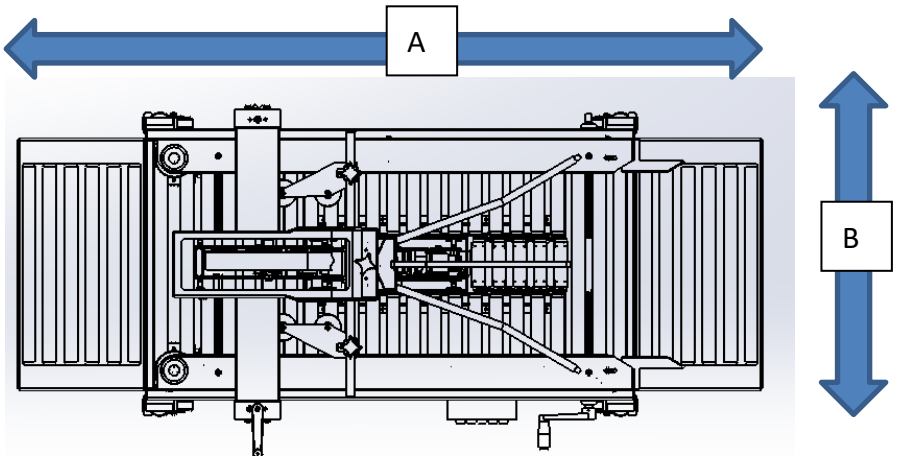
※ Noted: Please ensure to lock two screws (B) to avoid table sliding down



Assemble the out-feed roller table onto machine, there are three screws for easy mount.



3.3 Operation Space

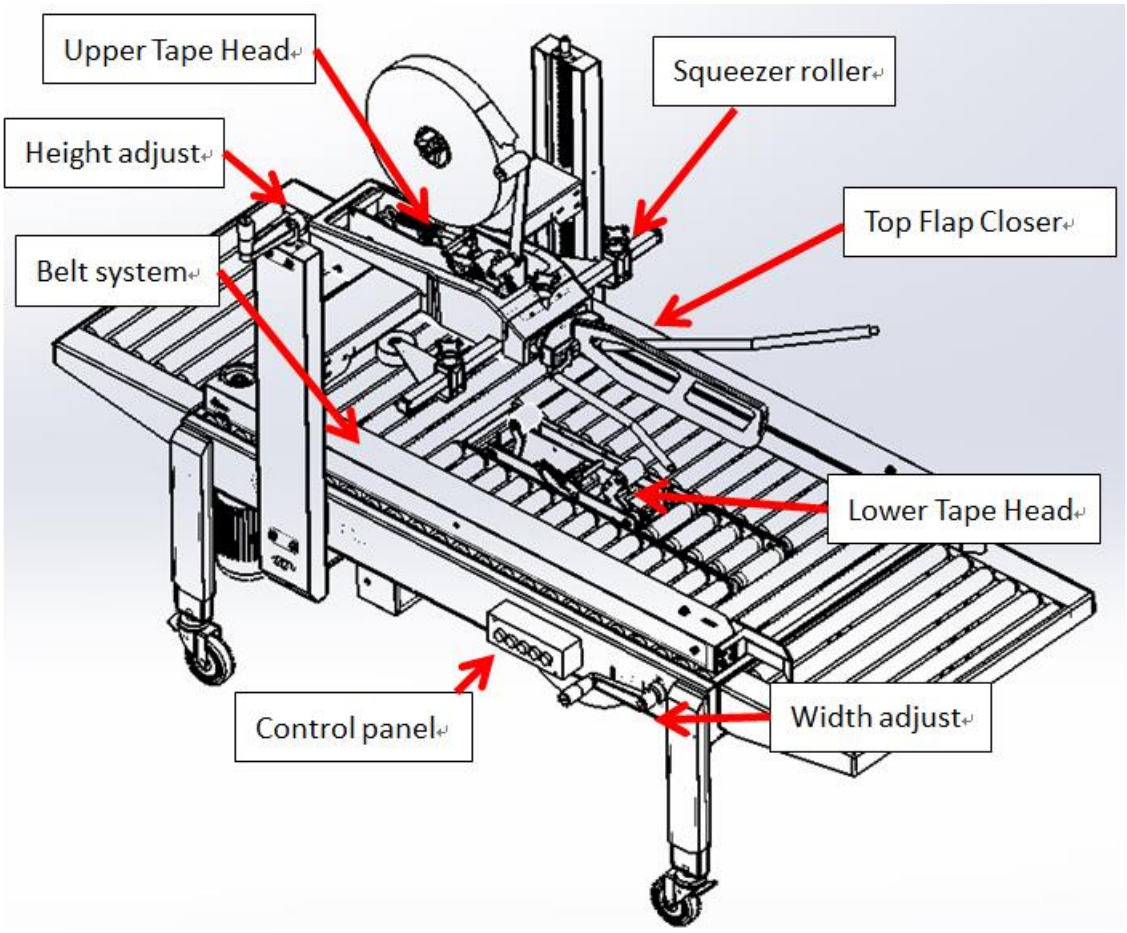


Keep the area (A) or (B) free for the operator.

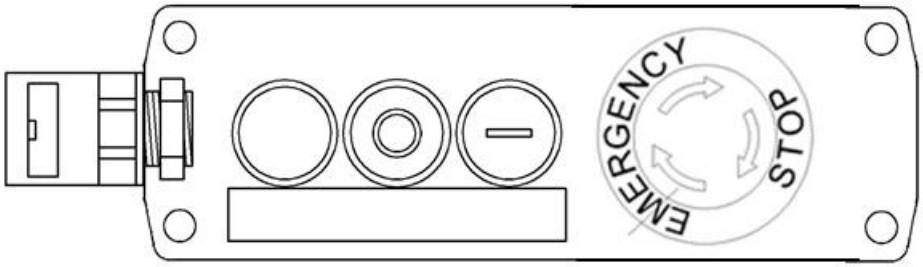
The area (A) is necessary for operating control system. (control box can change to both sides of machine)

The area (B) is necessary for feeding box into machine.

3.4 Construction and Units



3.5 Control Panel



The control panel is able to be switch between left and right sides of machine. Remove four screws on corners of control panel, and then switch to the other side.

a. Start Button: Press start button to start the motors and belts.

b. Stop button: Press stop button to stop the motors and belts.

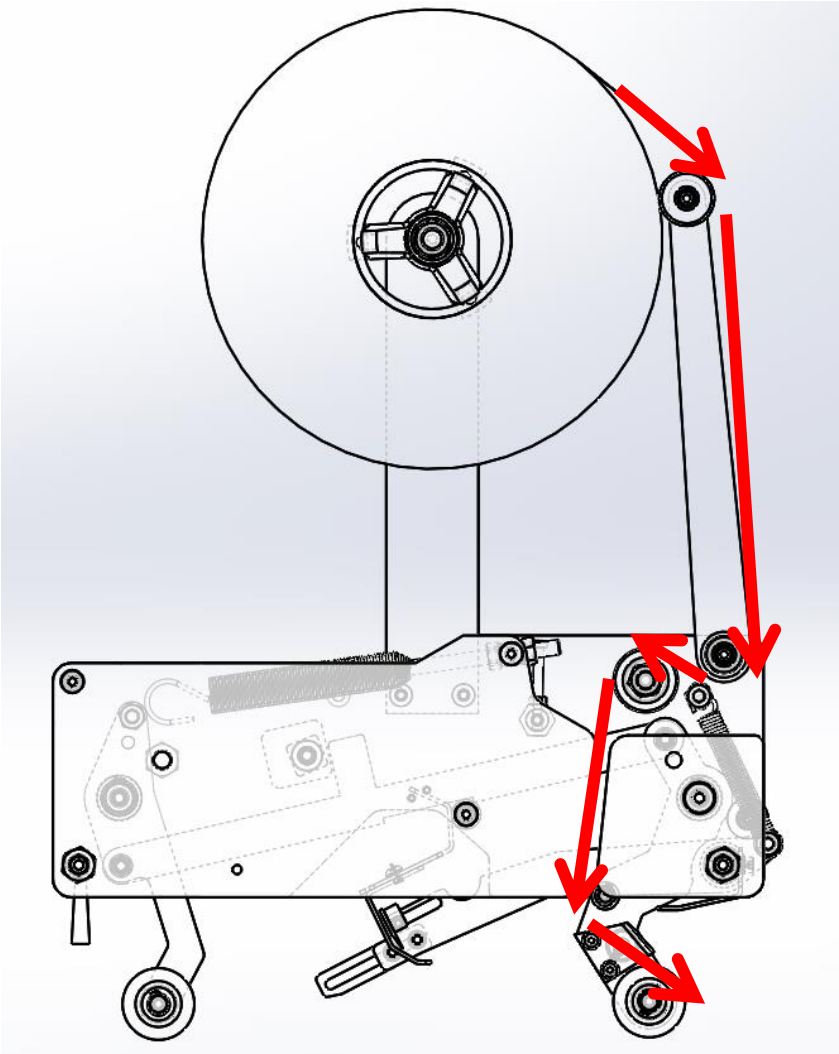
c. Indicator light: Light will be ON when machine is running, vice versa.

d. Emergency stop:

Circuit breaker with

- When overload, circuit breaker will be activated
- Press the Start button to reset the machine
- Or it will reset automatically after 60 seconds

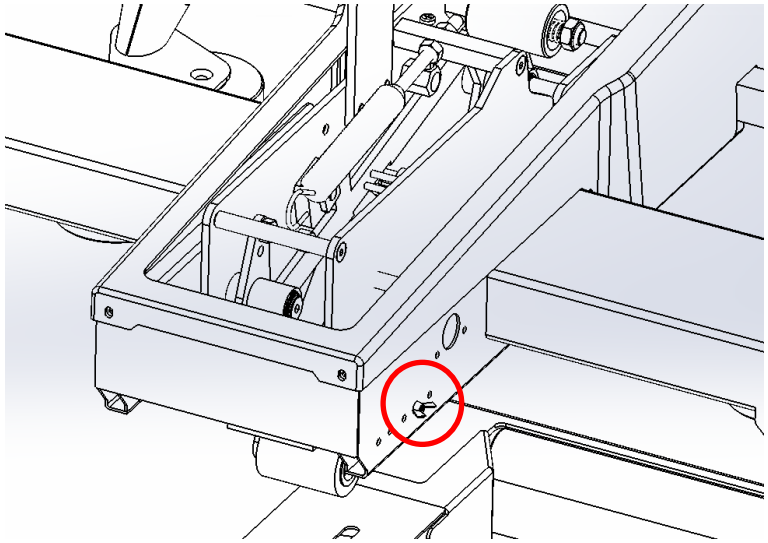
3.6 Tape Threading



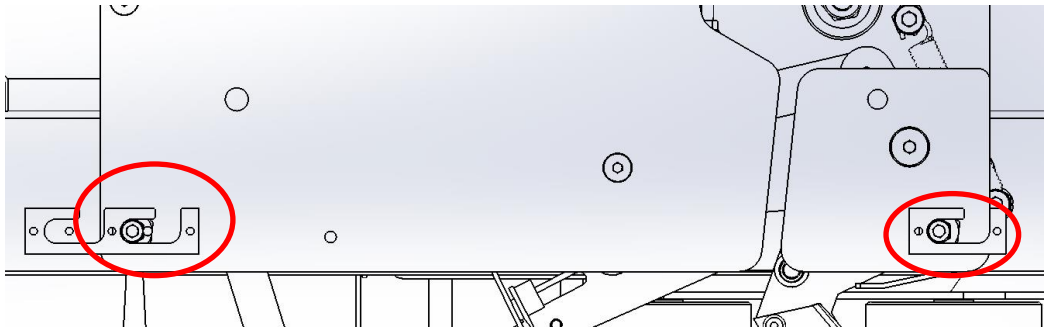
4. Adjustments

4.1 Change tape – upper

Release the screw



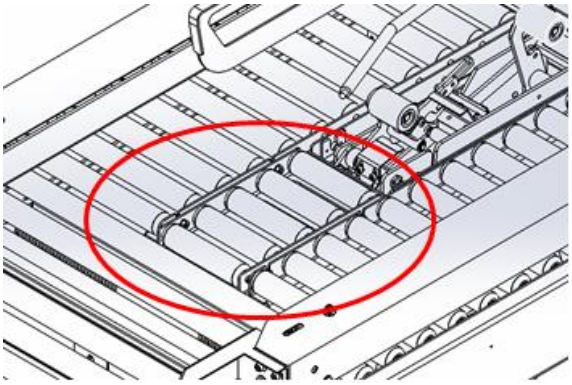
Move the upper tape head forward, until it's out of the mounting block, then you are able to lift the upper tape head off from the machine.

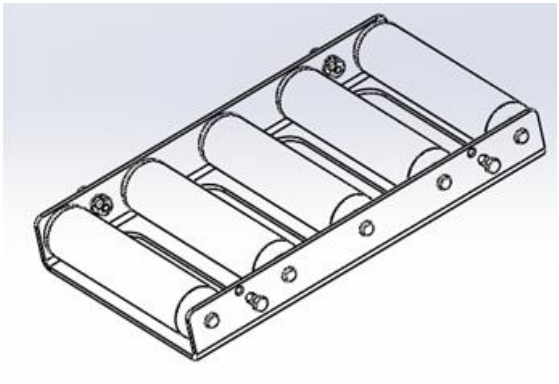


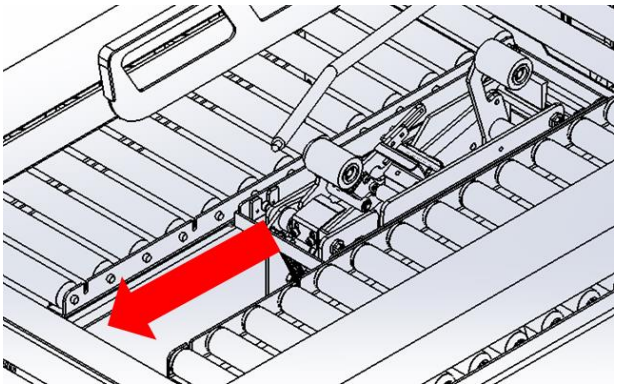
4.2 Change tape – lower

※This machine has patented design as drawer table for easy and fast change of lower tape head.

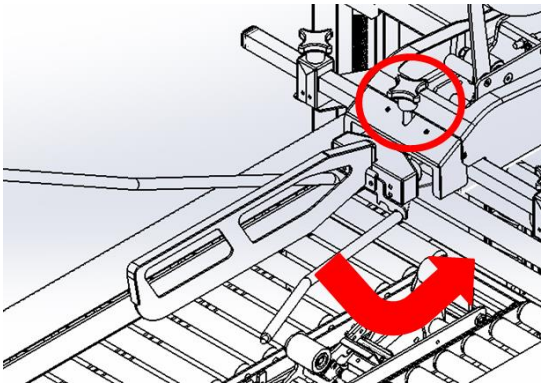
Remove the small roller unit, then you are able to pull the tape head unit to front position





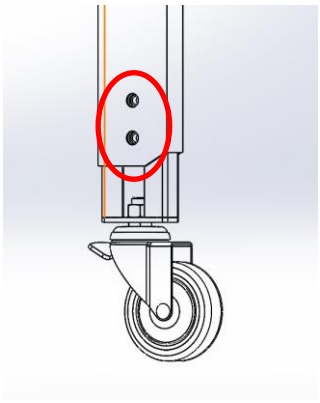


Loosen the knob, then rotate the top flap closer 90 degree, then you have enough space to take the bottom tape head



4.3 Table height adjustments

Loose screws then adjust the table height

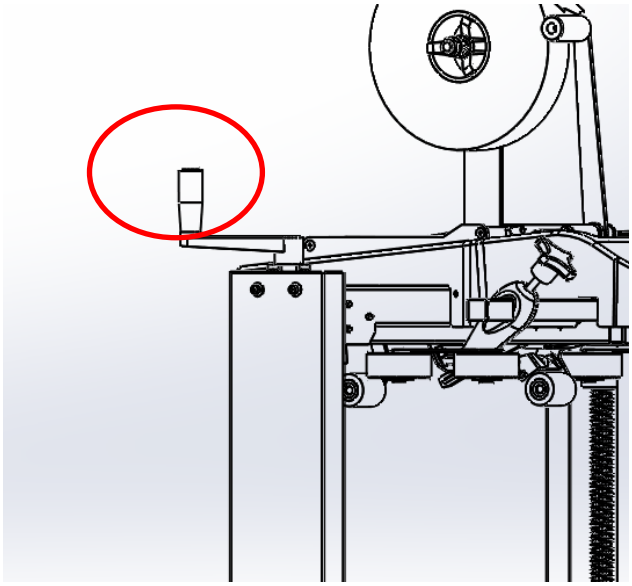


※ ***Please adjust legs one by one each time, be sure to tight the screw before moving forward to next leg adjustment.***

※ ***Be sure to hold the machine before loose the screw, or the machine could have risk to drop down in height then causing danger.***

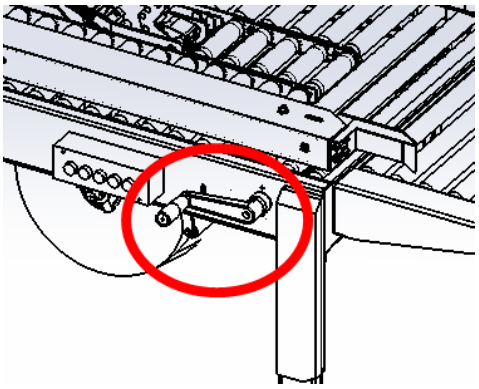
4.4 Box height adjustments

Adjust the height hand crank to make sure top seat is higher than box about 1-2mm



4.5 Box width adjustments

After adjust the height, open the side belts then place the box inside machine, then rotate width hand crank to close the side belts until the box can pass through smoothly.

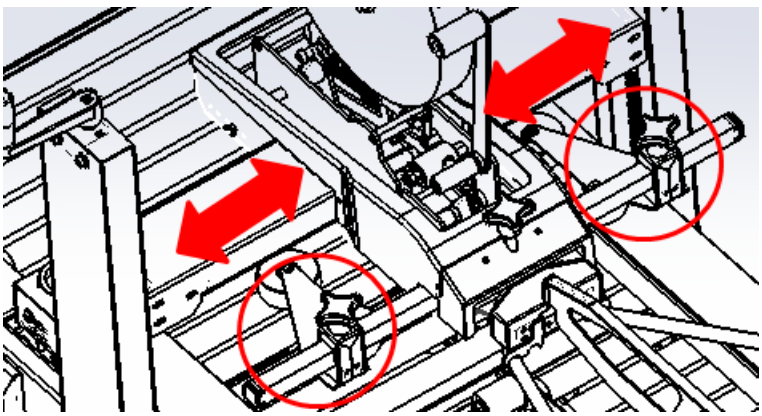


4.6 Squeezer roller adjustments

Before feeding box into the machine, release the knob and leave apart two squeezers.

Feed the box into machine and stop the machine when the box is in the squeezer roller position.

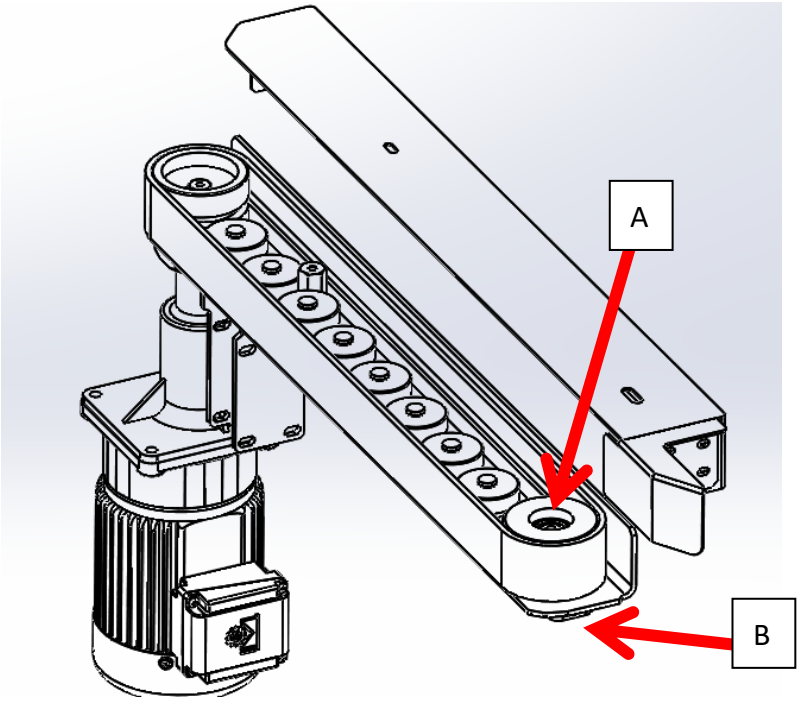
Move two squeezer come closer and touch with box with a little bit extra pressure, then tight the knob.



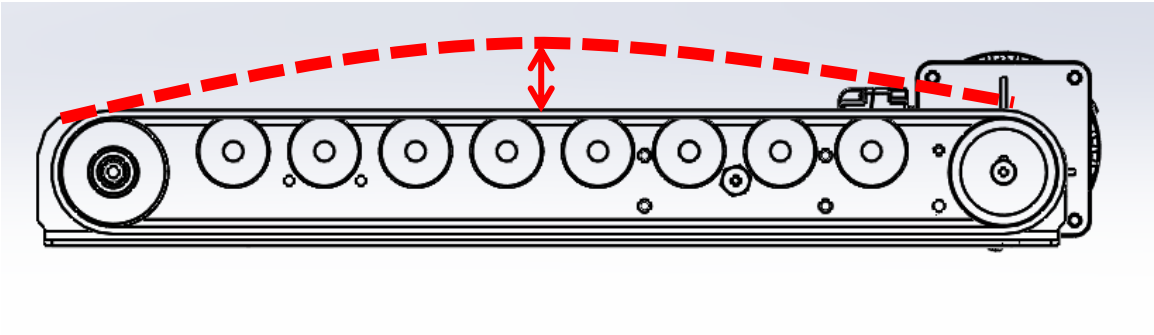
5. TROUBLE SHOOTING

- Belt tension adjustment:

  Remove belt cover, then loose screw (A), adjust the belt tension through screw (B)



Regarding to belt tension, make sure it's around 3Kg with 25mm gap pulled in the middle of belt



6. MAINTENANCE

Noted: Before doing any maintenance or service, please do switch off the main power on the machine, make sure there's no parts moving.

Warning:

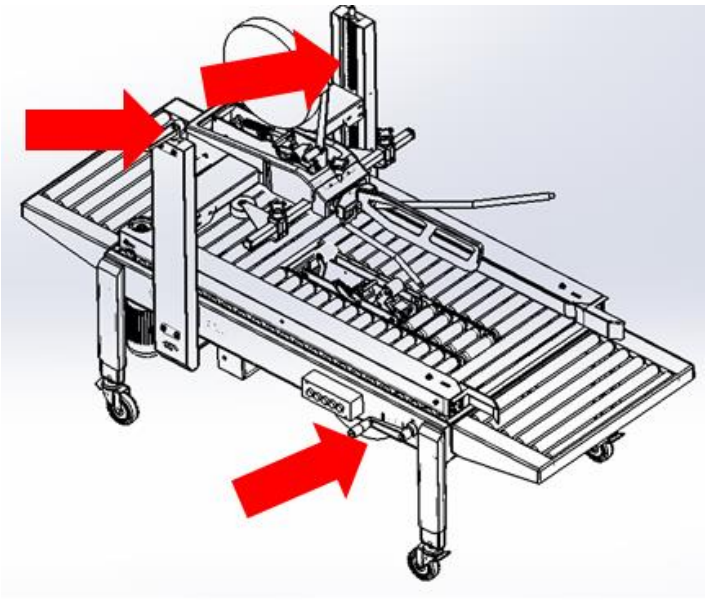
a. Wear safety glasses with side shields which conform to ANS Standard Z87.1
b. Failure to wear safety glasses could result in severe personal injury or blindness.
c. Wear Ear Protection.
d. Only trained personnel should service machine.
e. Unless specified, shut off and disconnect all electrical power.
f. Follow all service instructions.
g. Caution for moving parts can crush.
h. Caution for pinch point entanglement.
i. Caution for cutting of finger or hand from straight blade.
j. Use the correct tools.

Cleaning & Lubricate

- A weekly cleaning with dry rags or diluted detergents is necessary. Cardboard boxes produce a significant quantity of dust and paper chips when processed or handled in case sealing equipment. If this dust is allowed to build up on machine components, it can cause component wear and over-heating of drive motors. The dust buildup is best removed from the machine with a vacuum cleaner. Depending on the number of cartons processed, this cleaning should be done weekly. Excessive buildup that cannot be removed by vacuuming should be removed with a damp cloth.
- Should tape adhesive buildup occur, carefully wipe clean with oily cloth or brush. Oil prevents the buildup of tape adhesive
- Worm or damaged cutter blades much be replaced promptly in order to guarantee a perfect cut of the tape.

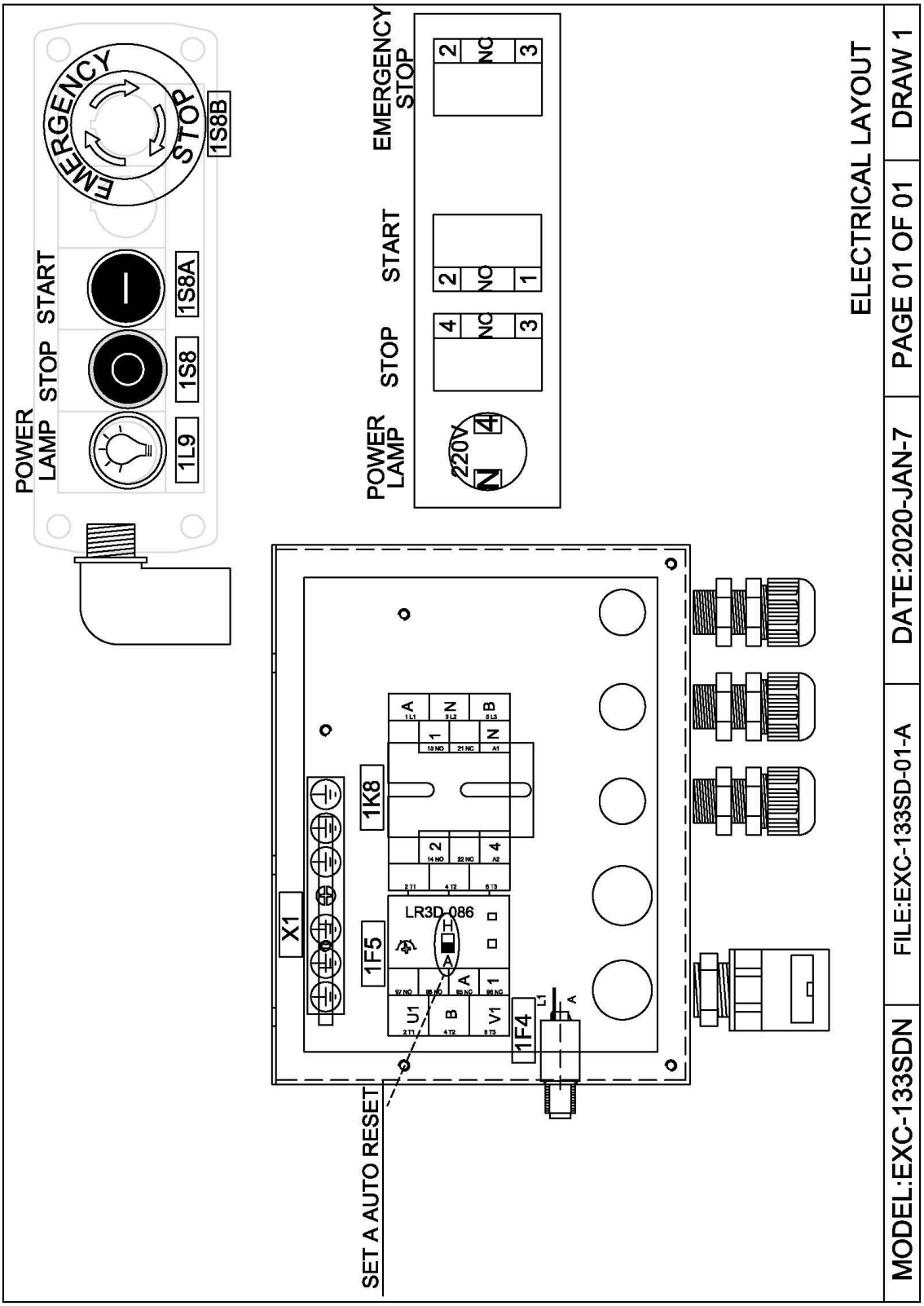
- Most of the machine bearings, including the drive motor, are permanently lubricated and sealed and do not require additional lubricant.

  For ***height adjustment hand crank***, ***width adjustment hand crank*** and the ***thread rods*** should be lubricated every 250 hours of operation. A small amount of silicone should be applied to the end of each spring where the loop is secured to an eyelet.



※ Wipe off excess silicone. It will attract dust which can cause premature equipment wear and jamming. Take care that silicone is not left on the surface of rollers around which tape is threaded, as it can contaminate the tape's adhesive

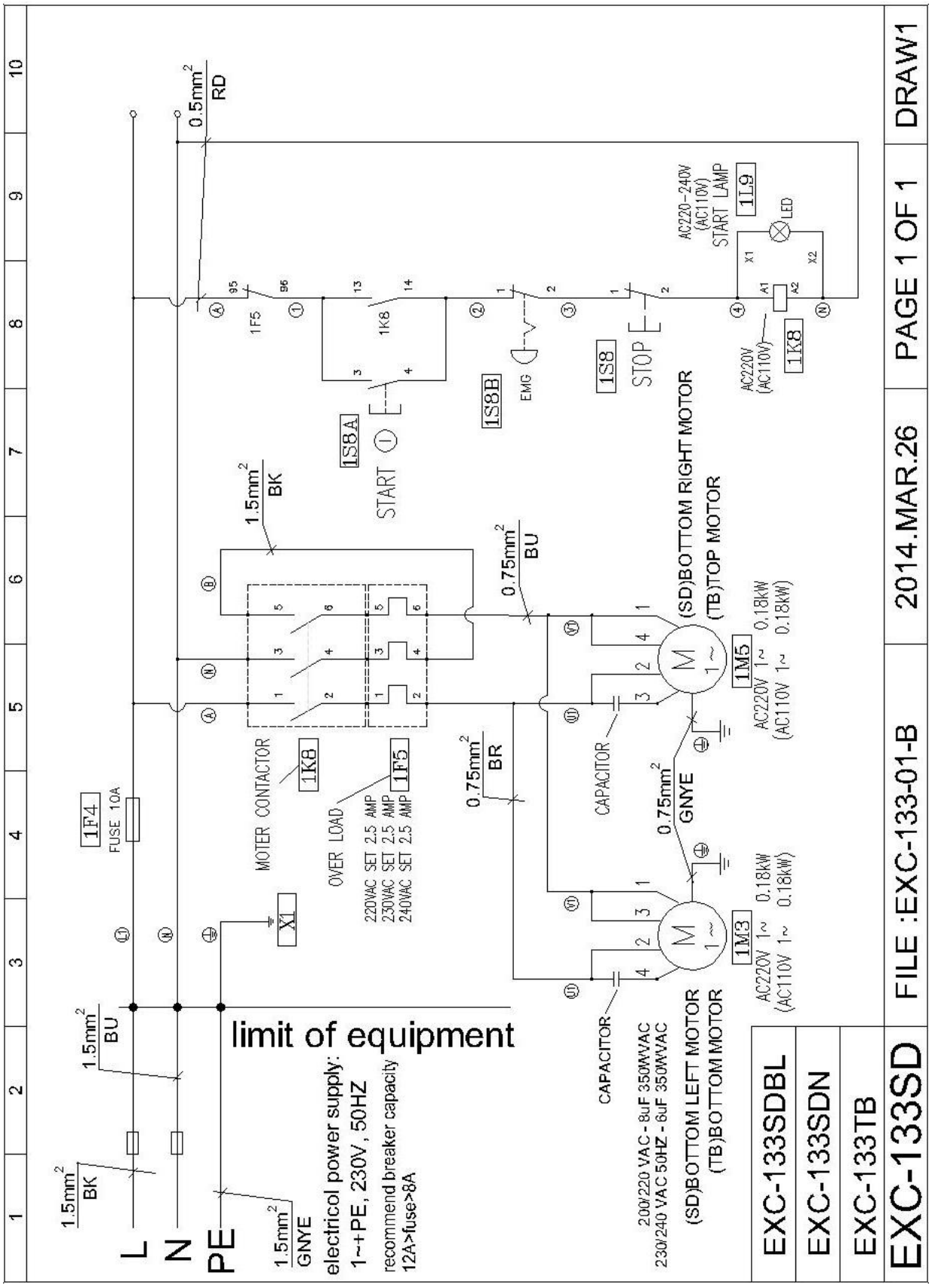
7. ELECTRIC WIRING DIAGRAM & PART



ELECTRIC PARTS LIST

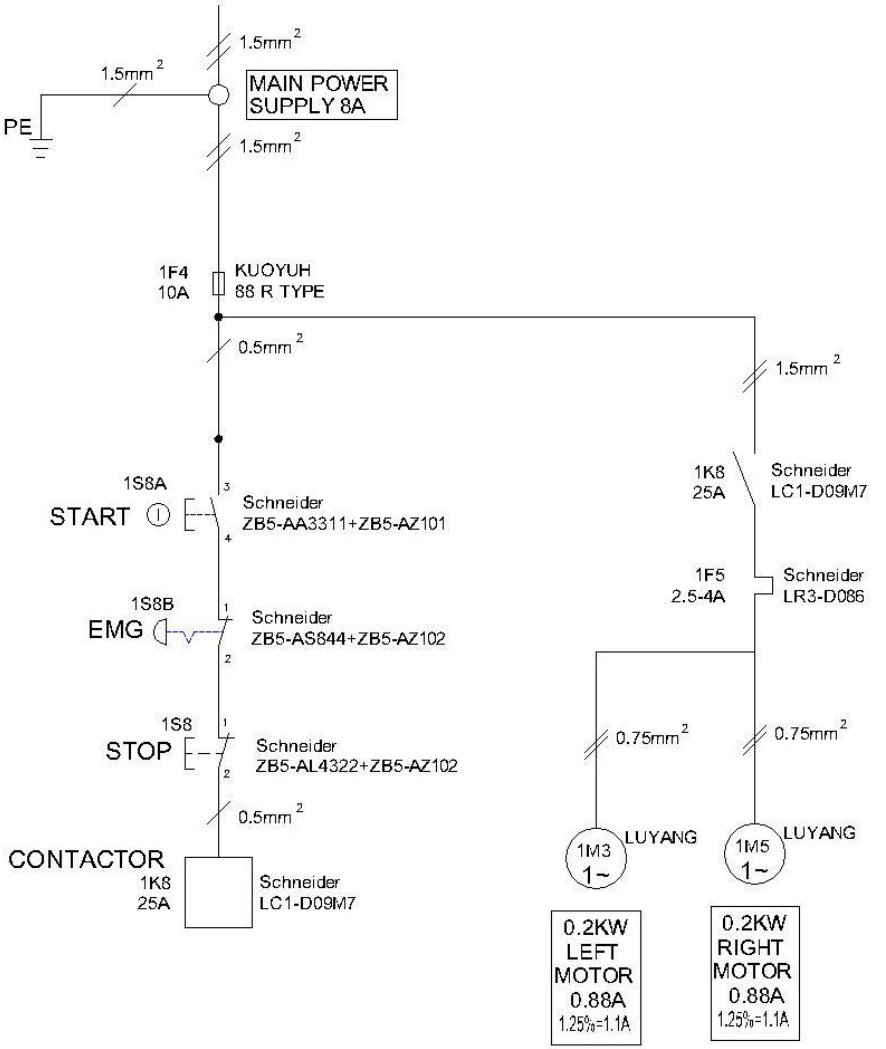
KEY NO	PART NO.	DESCRIPTION	Q'TY
1S8B	P0313-010004300 P0313-020000900 P1001-0001400	EMERGENCY STOP BUTTON ZB5-AS844 EMERGENCY STOP BUTTON SEAT CONTACT EMERGENCY STOP STICKER	1 1 1
2	P0401-0006000	1/2" CONNECTOR	1
3	P0316-040000500	1/2" PROTECT TUBE	1
4	P0401-0000500	1/2" 90° CONNECTOR	1
X1	P0304-010000100	TERMINAL BLOCKS TB6P	1
1K8	P0306-010000200 P0306-010000300	CONTACTOR LC1-D09M7 (220V) LC1D09F7(110V)	1 1
1F5	P0306-040000200 P0306-040000500	OVERLOAD PROTECTOR LR3-D086(2.5-4A)(220V) LR3D10(4-6A)(110V)	 1 1
1S8	P0313-010001100 P0313-020000900	BUTTON BUTTON SEAT CONTACT NCx1	1 1
1S8A	P0313-010001200 P0313-020000800	BUTTON CONTACTS NOX1	1 1
1L9	P0313-010006600 P0313-010006500	POWER LAMP XA2EVM1LC(220VAC) POWER LAMP XA2EVF1LC(110VAC)	1
1F4	P0305-030005900	NO FUSE BREAKER KMB-10AI	1
12	P0323-0000300	ON/OFF SWITCH BOX	1
13	P0326-010000900	CABLE FIXER	2

Wiring Diagram



INPUT POWER

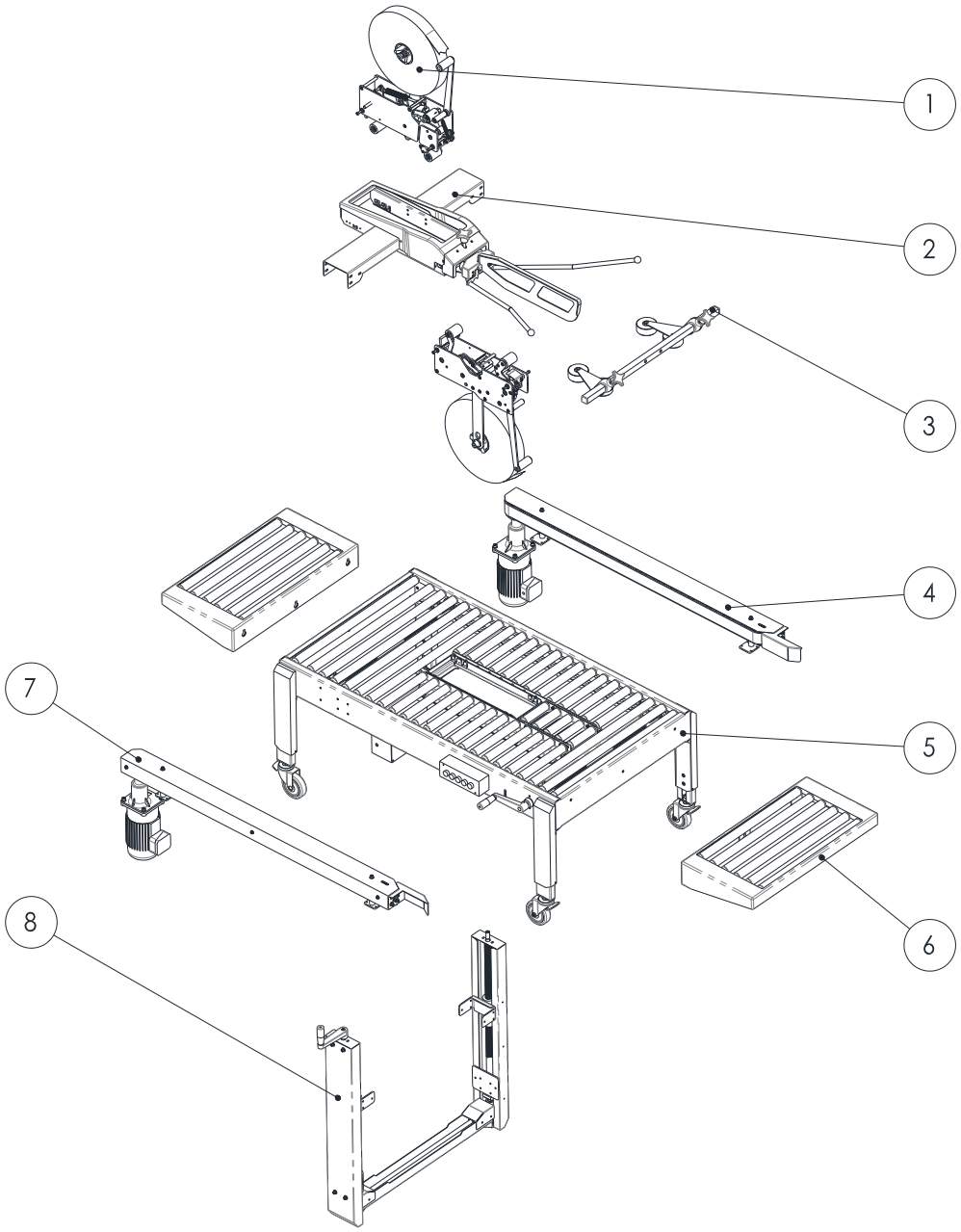
NOMINAL VOLTAGE RATING : N+1~+PE,230VAC
ALLOWABLE VOLTAGE DEVIATION :±10%
POWER FREQUENCY : 50/60Hz
ALLOWABLE FREQUENCY DEVIATION : ±1Hz
POWER IMPEDANCE : VOTAGE DEVATION DUE TO LOAD



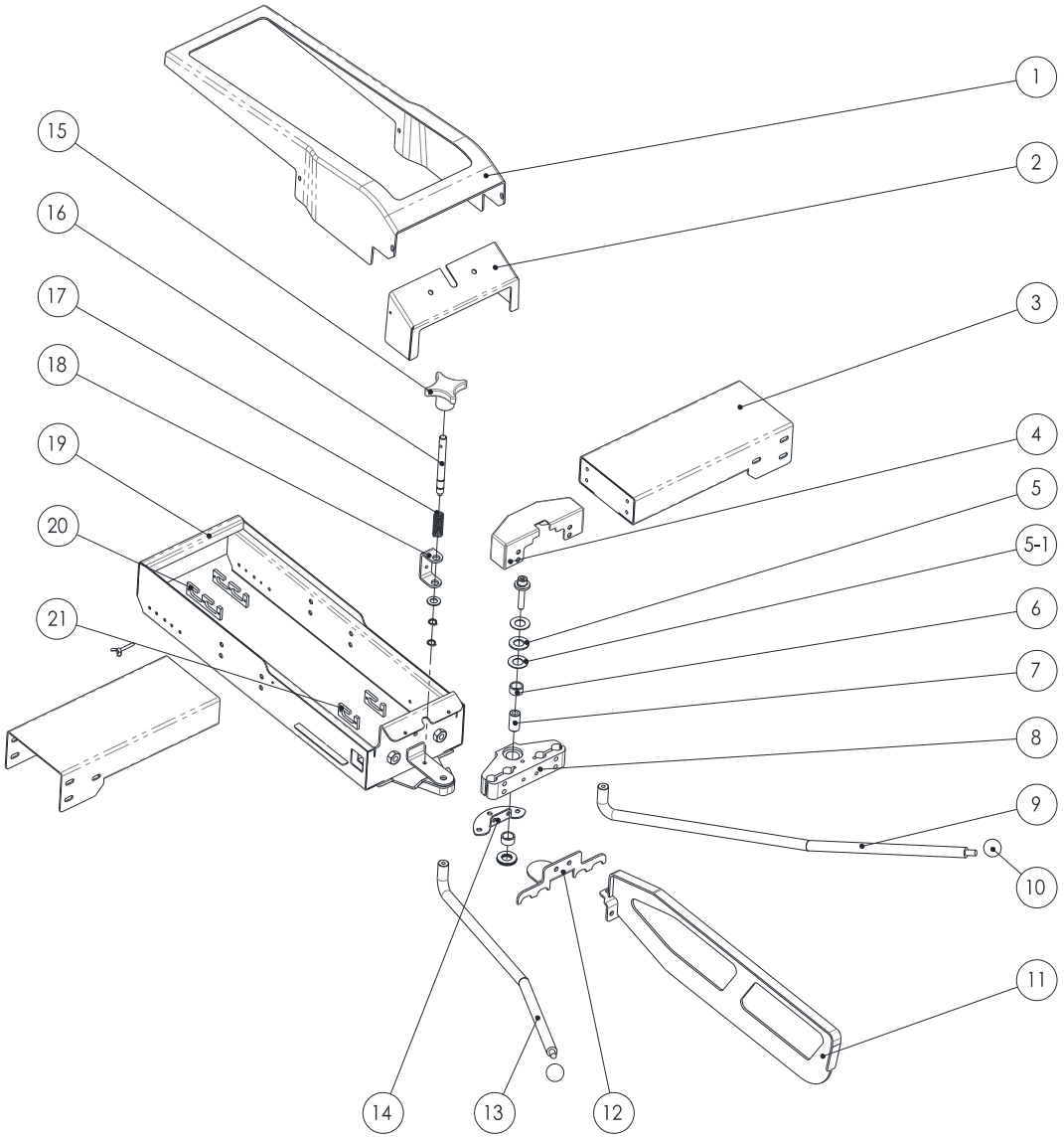
Block diagram

MODEL:EXC-133SD	FILM:EXC-133SD-02-D	DATE:2016.NOV.11	PAGE 01 OF 01	DRAW 1

8. PART LIST



EXC-133SDN		
#	ITEM	Q'TY
1	TAPE HEAD	2
2	TOP SEAT UNIT	1
3	SQUEEZER UNIT	1
4	BELT DRIVE UNIT (RIGHT)	1
5	FRAME UNIT	1
6	OUTFEED TABLE UNIT	2
7	BELT DRIVE UNIT (LEFT)	1
8	COLUMN UNIT	1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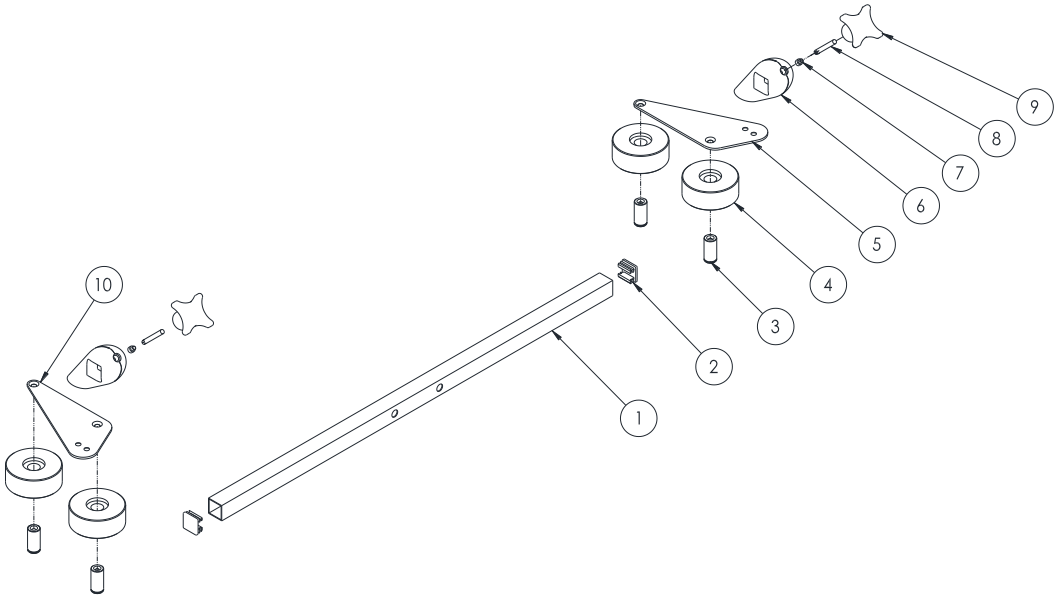
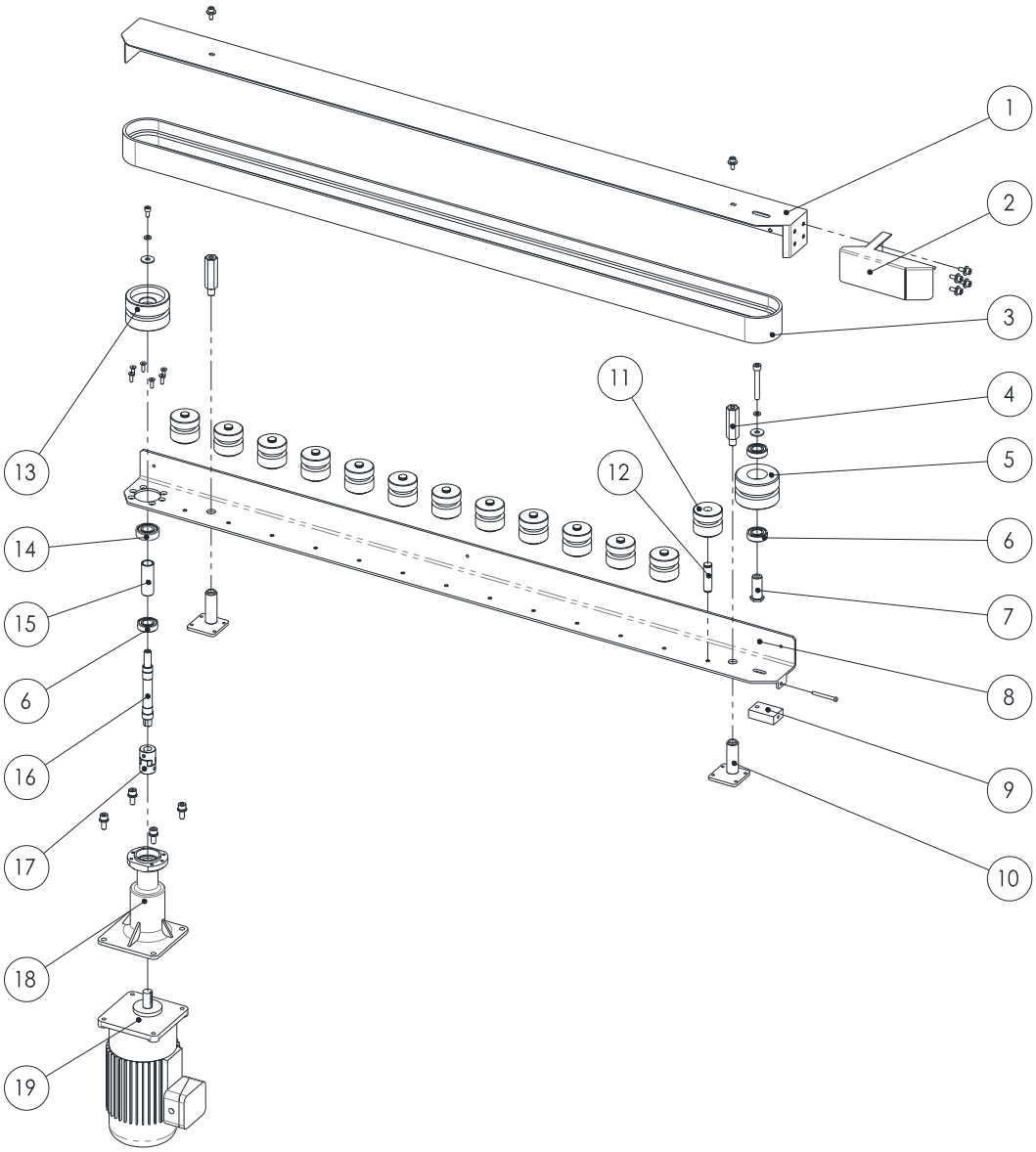
TOP SEAT UNIT			
#	PART NUMBER	ITEM	Q'TY
1	P06-007650A	TOP COVER	1
2	P01-0652600	FRONT COVER	1
3	P01-0652100	BRIDGE - RIGHT	2
4	P01-0652700	COVER	1
5	P1104-18AXK15280	BEARING AXK1528	2
5-1	P1104-19AS15280	WASHER AS1528	4
6	P1104-081519100	BUSHING 15x ∮ 19x10L	2
7	P02-0403300	PIVOT	1
8	P02-0418600	SEAT	1
9	P02-0059200	FLAP FOLDER - RIGHT	1
10	P1112-0001300	KNOB	2
11	P01-0651100	CENTER BLADE	1
12	P01-065250A	GUIDE	1
13	P02-0059300	FLAP FOLDER - LEFT	1
14	P01-0652300	FIX PLATE	1
15	P1113-0001500	NOV M10x63	1
16	P02-0403400	SHAFT	1
17	P1201-0011700	SPRING	1
18	P01-0652400	SUPPORT PLATE	1
19	P01-065180A	TOP SEAT	1
20	P01-0134500	MOUNTING BLOCK B	2
21	P01-0134400	MOUNTING BLOCK A	2



SQUEEZER UNIT			
#	PART NUMBER	ITEM	Q'TY
1		TUBE	1
2	P1114-010000300	FIX SEAT	2
3	P02-0299900	SHAFT	4
4	P06-0022400	ROLLER	4
5		SUPPORT - RIGHT	1
6	P06-0053900	SEAT	2
7	P06-0016400	PLASTIC CAP	2
8	P1101-0710060AB	THREAD	2
9	P1113-0001500	KNOB	2
10		SUPPORT - LEFT	1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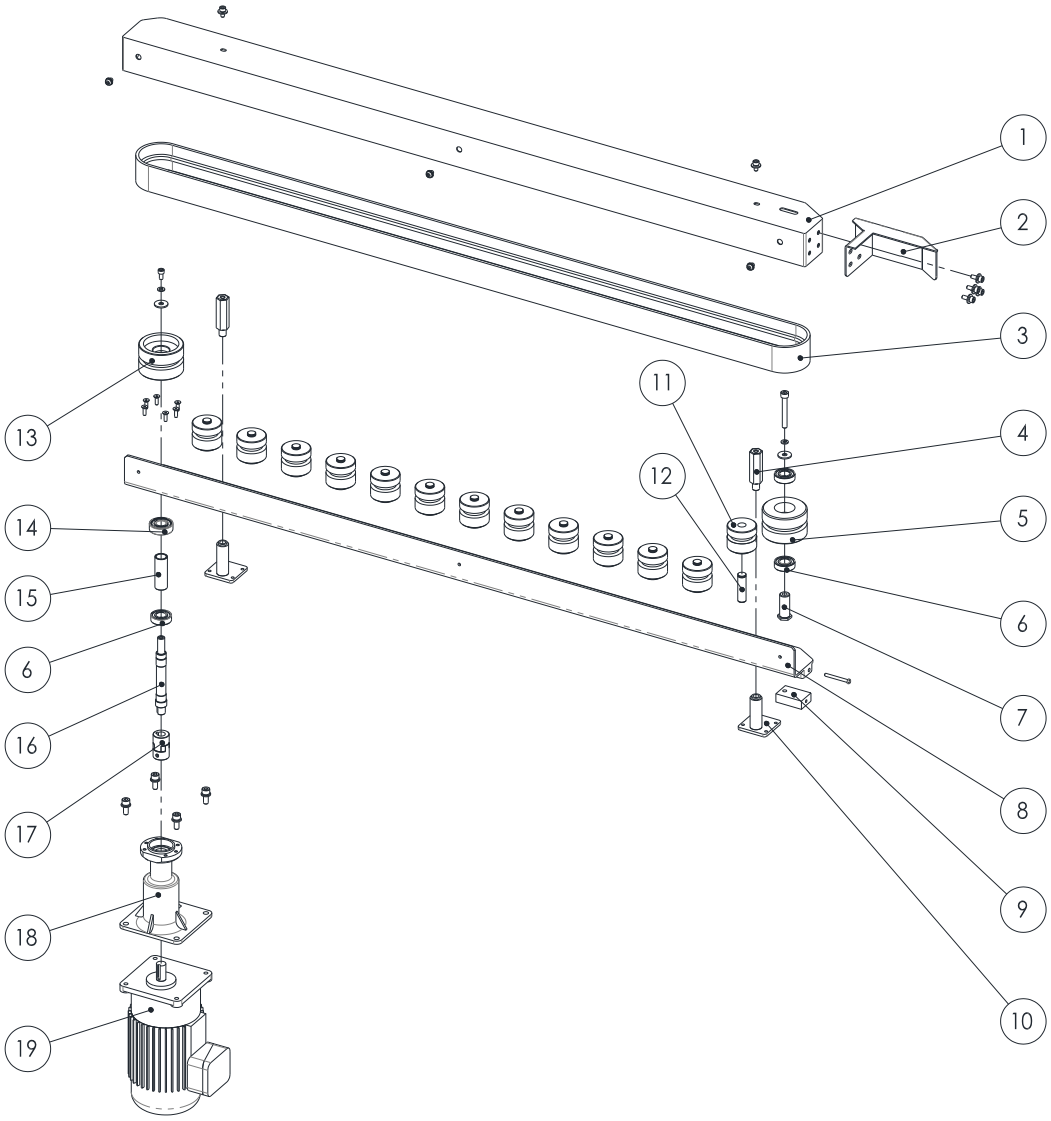
BELT DRIVE UNIT (RIGHT)			
#	PART NUMBER	ITEM	Q'TY
1	P01-0651200	BELT COVER - RIGHT	1
2	P01-0136700	GUIDE – RIGHT	1
3	P0902-0010800	BELT	1
4	P02-0080000	SUPPORT SHAFT	2
5	P0703-0003200	PULLEY	1
6	P1104-026003ZZ0	BEARING 6003ZZ(CWB)	3
7	P02-0079500	SHAFT	1
8	P01-0651500	BELT SEAT - RIGHT	1
9	P02-0080100	ADJUST BLOCK	1
10	P02-0079900	SUPPORT SEAT	2
11	P0703-0003200	PULLEY	13
12	P02-0079600	SHAFT	13
13	P0703-0003400	PULLEY	1
14	P1104-0262032RS0	BEARING 6203-2RS	1
15	P02-0080400	SPACER	1
16	P02-008020B	MOTOR SHAFT	1
17	P1121-0000100	COUPLING	1
18	P02-0080300	MOTOR SEAT	1
19	P0503-001120A	MOTOR - RIGHT	1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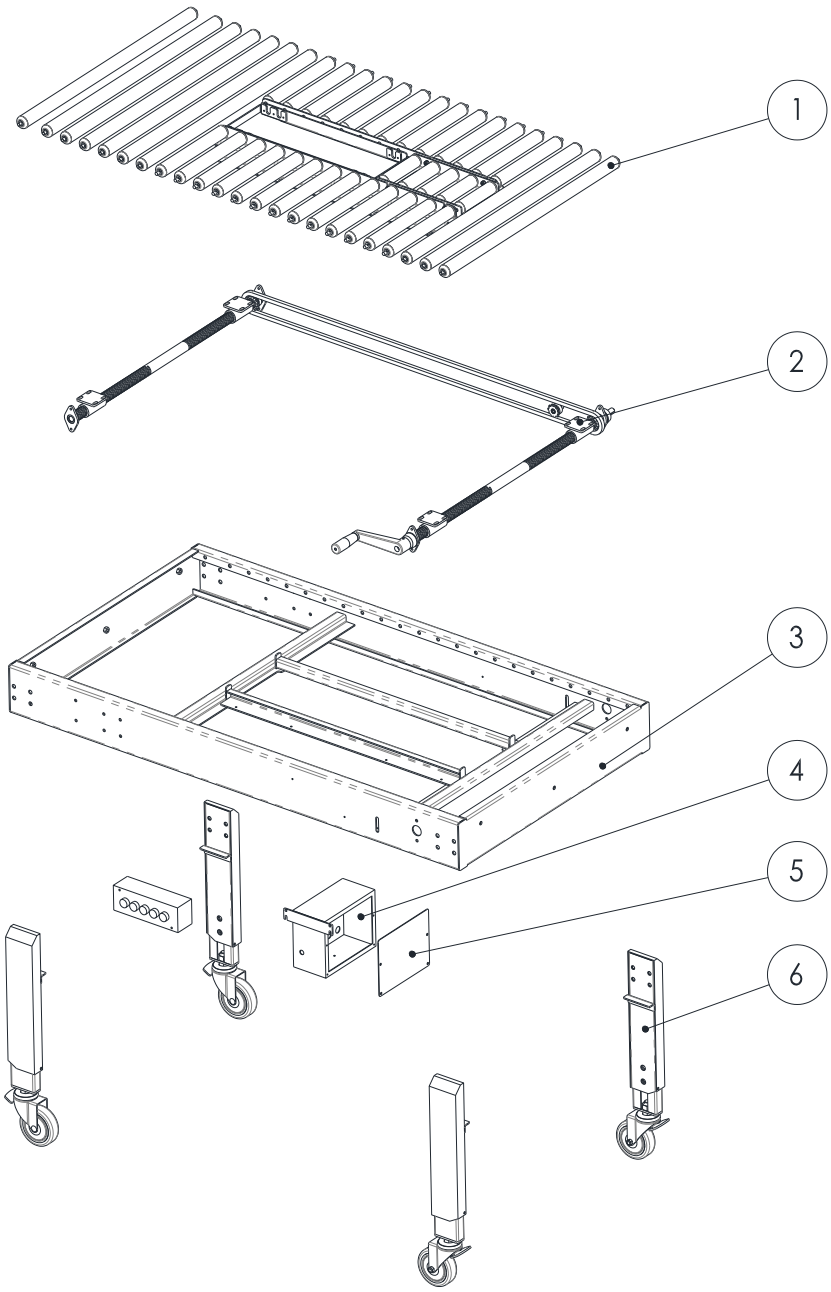
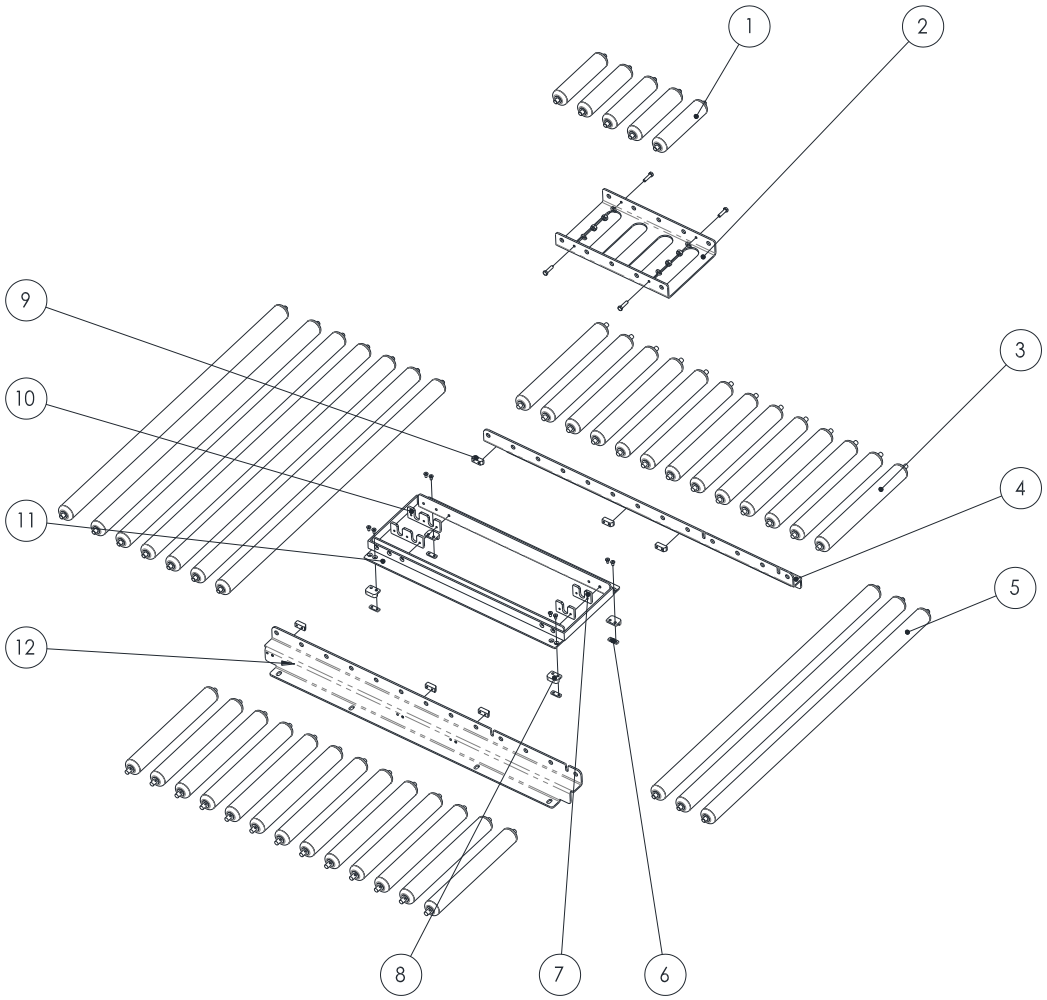
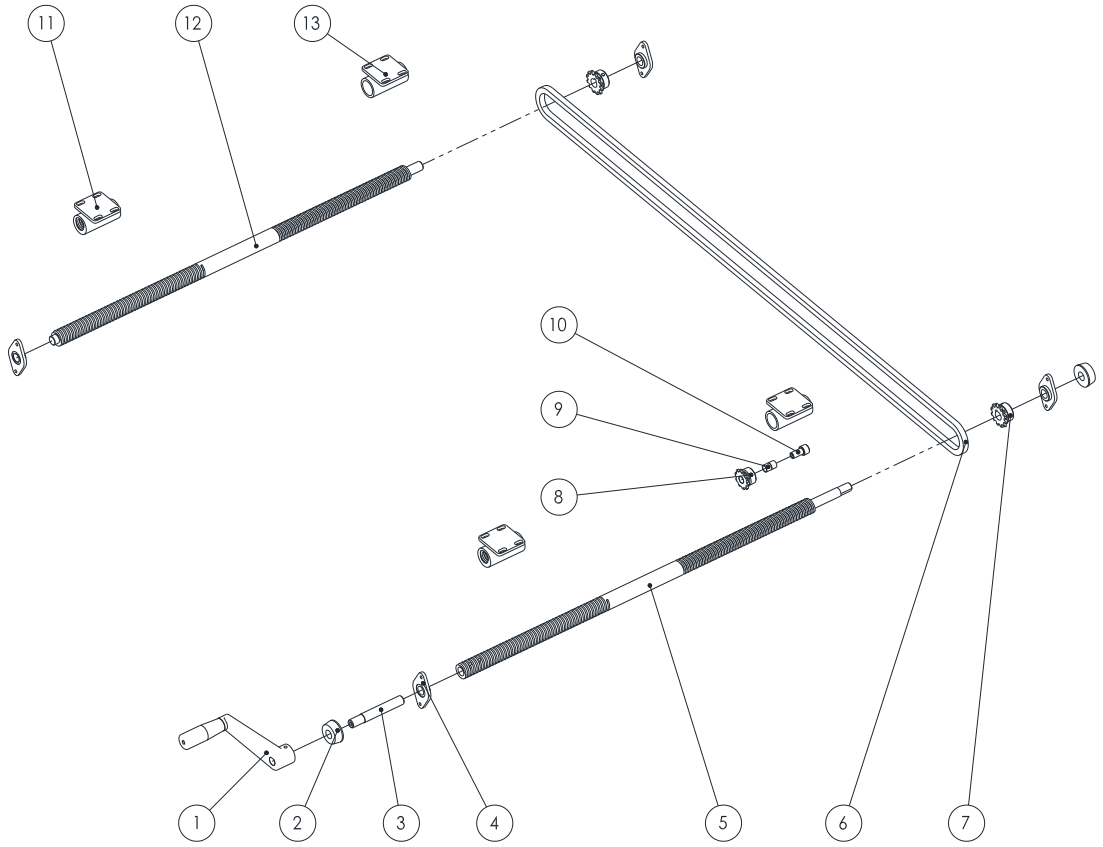
BELT DRIVE UNIT (LEFT)			
#	PART NUMBER	ITEM	Q'TY
1	P01-0651300	BELT COVER – LEFT	1
2	P01-0136600	GUIDE – LEFT	1
3	P0902-0010800	BELT	1
4	P02-0080000	SUPPORT SHAFT	2
5	P0703-0003200	PULLEY	1
6	P1104-026003ZZ0	BEARING 6003ZZ(CWB)	3
7	P02-0079500	SHAFT	1
8	P01-0651400	BELT SEAT – RLEFT	1
9	P02-0080100	ADJUST BLOCK	1
10	P02-0079900	SUPPORT SEAT	2
11	P0703-0003200	PULLEY	13
12	P02-0079600	SHAFT	13
13	P0703-0003400	PULLEY	1
14	P1104-0262032RS0	BEARING 6203-2RS	1
15	P02-0080400	SPACER	1
16	P02-008020B	MOTOR SHAFT	1
17	P1121-0000100	COUPLING	1
18	P02-0080300	MOTOR SEAT	1
19	P0503-001200A	MOTOR - LEFT	1



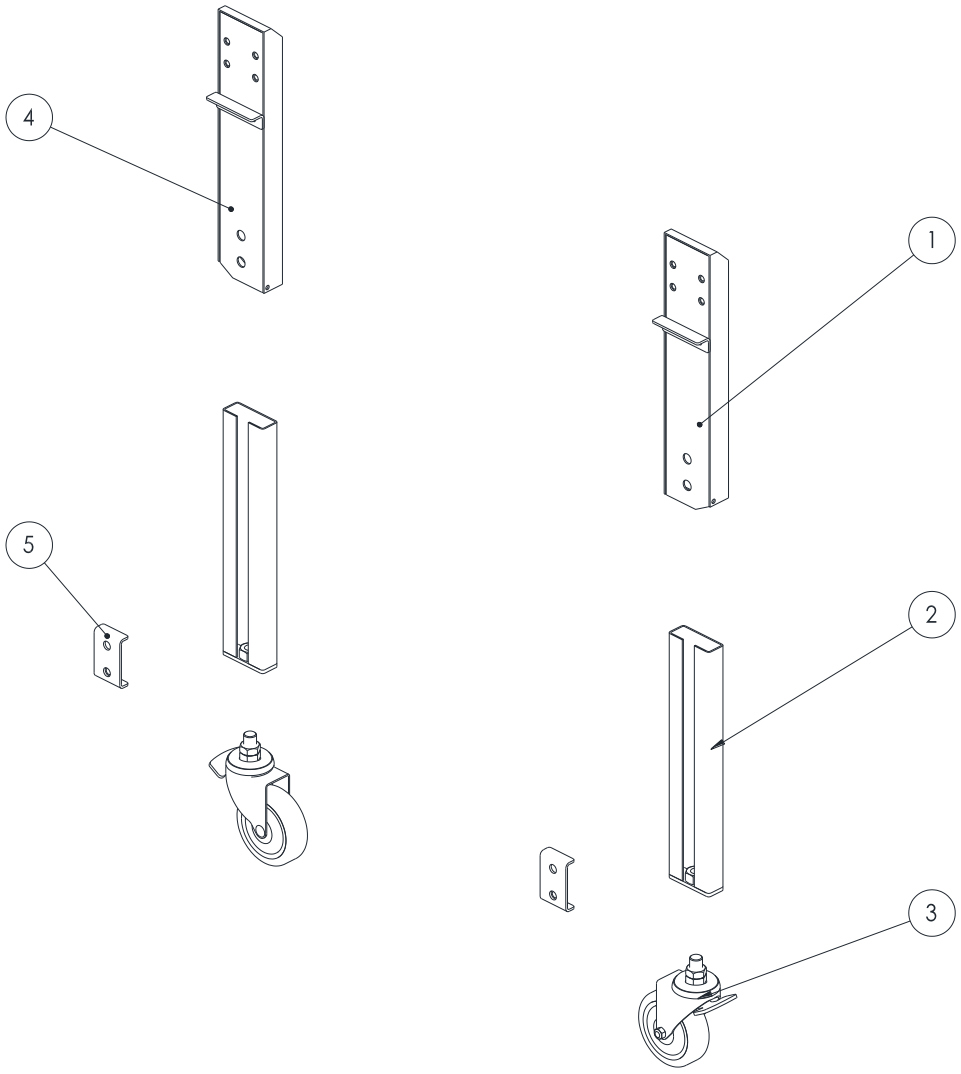
FRAME UNIT			
#	PART NUMBER	ITEM	Q'TY
1		ROLLER UNIT	1
2		THREAD ROD UNIT	1
3		BODY FRAME	1
4		ELECTRIC BOX	1
5		ELECTRIC BOX COVER	1
6		LEGS	4



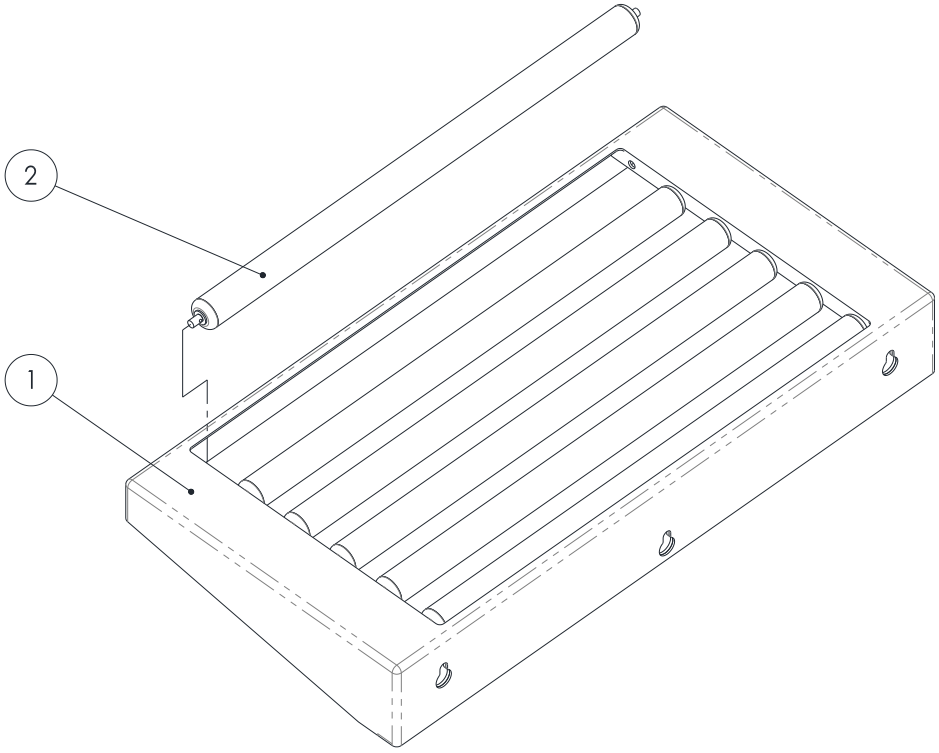
ROLLER UNIT			
#	PART NUMBER	ITEM	Q'TY
1	P08-0011100	ROLLER	5
2		TABLE	1
3	P08-0004900	ROLLER	26
4		ROLLER SEAT	1
5	P08-0011200	ROLLER	10
6		SPACER	4
7	P01-013510A	MOUNTING BLOCK A	2
8	P06-0079000	SLIDER	4
9	P06-0076400	SLIDER	6
10	P01-013520A	MOUNTING BLOCK B	2
11		BOTTOM SEAT	1
12		ROLLER SEAT	1



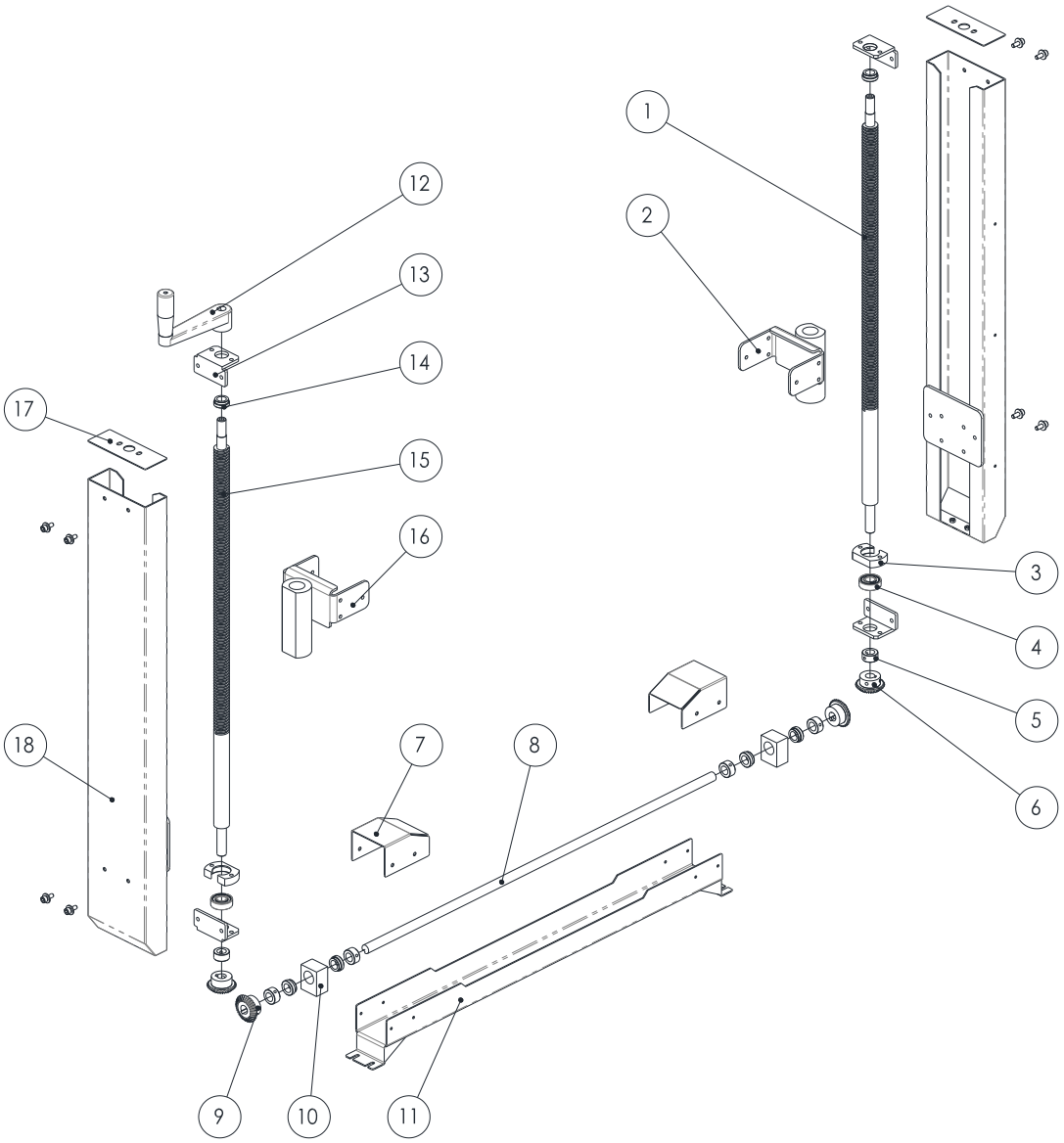
THREAD ROD UNIT			
#	PART NUMBER	ITEM	Q'TY
1	P1112-000060A	KNOB	1
2	P06-0022600	KNOB BUSHING	2
3	P02-007940A	EXTENSION SHAFT	1
4	P01-0135000	BUSHING SEAT	4
5	P02-007920A	THREAD ROD	1
6	P0901-0014800	CHAIN	1
7	P0702-0004800	SPROCKET	2
8	P0702-0004700	SPROCKET	1
9	P1104-081012100	BUSHING ∮ 10x ∮ 12x10L	2
10	P02-032530A	SHAFT	1
11	P02-0079700	THREAD SEAT - LEFT	2
12	P02-0079300	THREAD ROD	1
13	P02-0079800	THREAD SEAT - RIGHT	2



LEGS			
#	PART NUMBER	ITEM	Q'TY
1	P01-065160A	LEG	2
2	P01-046690A	ADJUST LEG	4
3	P1107-0003300	CASTER	4
4	P01-065170A	LEG	2
5	P01-046700A	FIX PLATE	4



OUTFEED TABLE UNIT			
#	PART NUMBER	ITEM	Q'TY
1	P08-0005100	ROLLER	6
2	P01-0466700	TABLE	1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COLUMN UNIT			
#	PART NUMBER	ITEM	Q'TY
1	P02-0307600	THREAD ROD – LEFT	1
2	P02-030770A	THREAD SEAT - LEFT	1
3	P06-0022500	BUSHING SEAT	2
4	P1104-026202ZZ0	BEARING 6202ZZ(CWB)	2
5	P02-0083500	SPACER	6
6	P0701-0003000	BEVER GEAR	2
7		GEAR COVER	2
8	P02-0403100	SHAFT	1
9	P0701-0004400	BEVER GEAR	2
10	P02-029880A	SUPPORT SEAT	2
11		FIX PLATE	1
12	P1112-000060A	KNOB	1
13		FIX PLATE	4
14	P02-0088800	BUSHING	6
15	P02-0307500	THREAD ROD – RIGHT	1
16	P02-030780A	THREAD SEAT – RIGHT	1
17		COVER	2
18		COLUMN	2