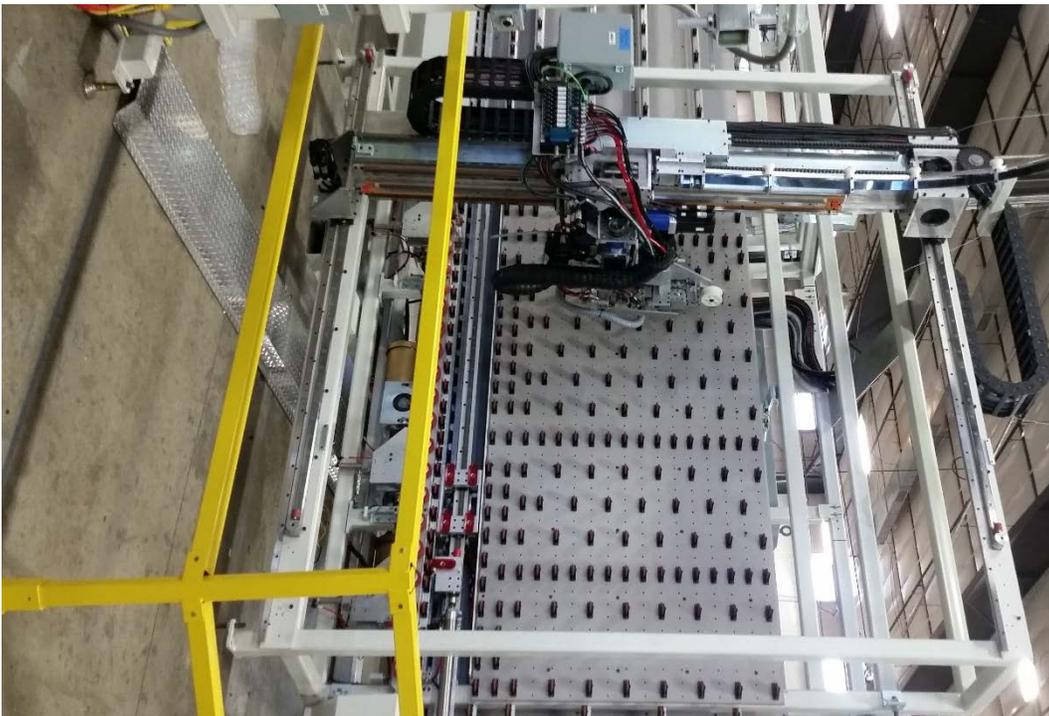
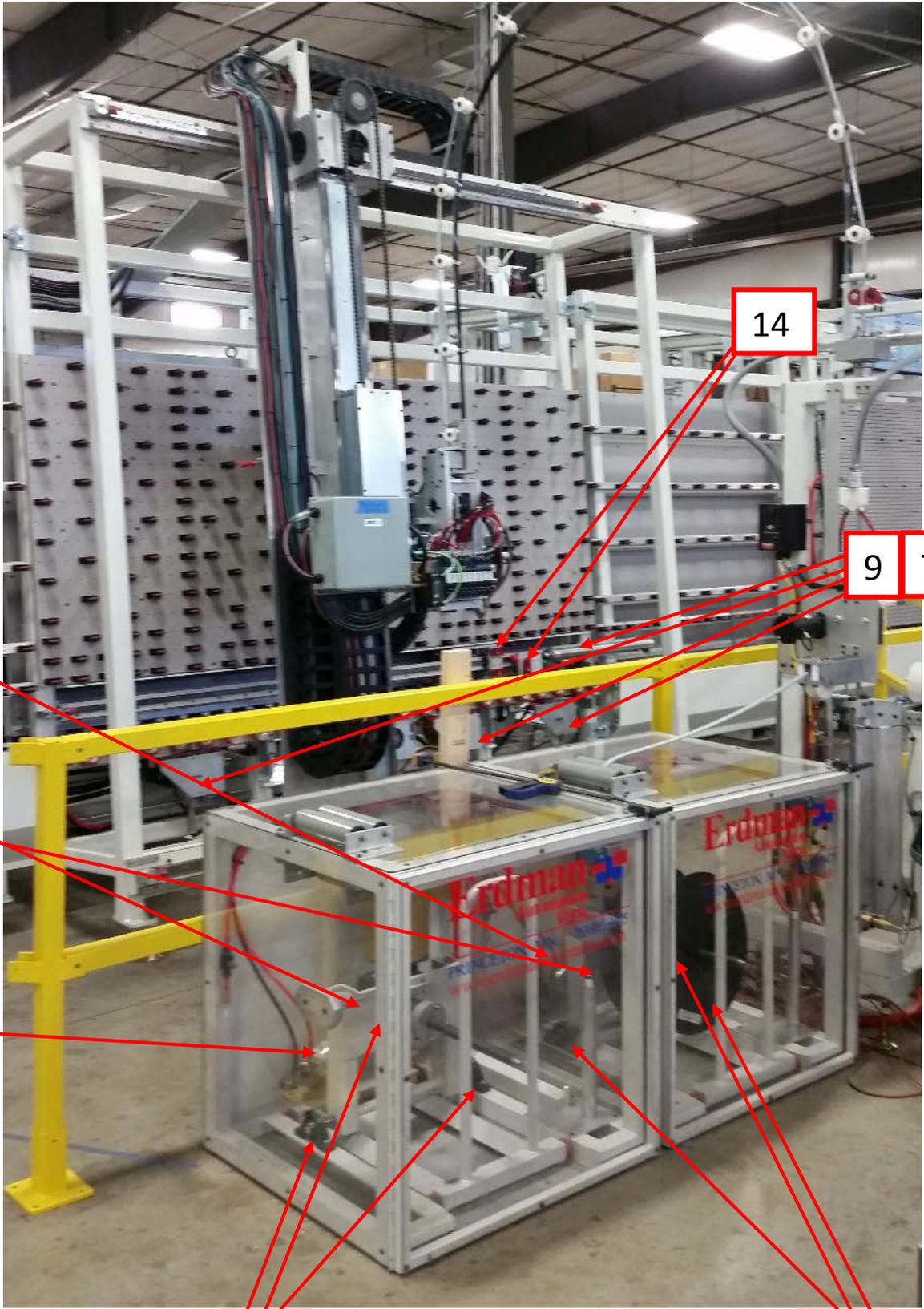


7500 SPACER APPLICATOR

MAINTENANCE INSTRUCTIONS





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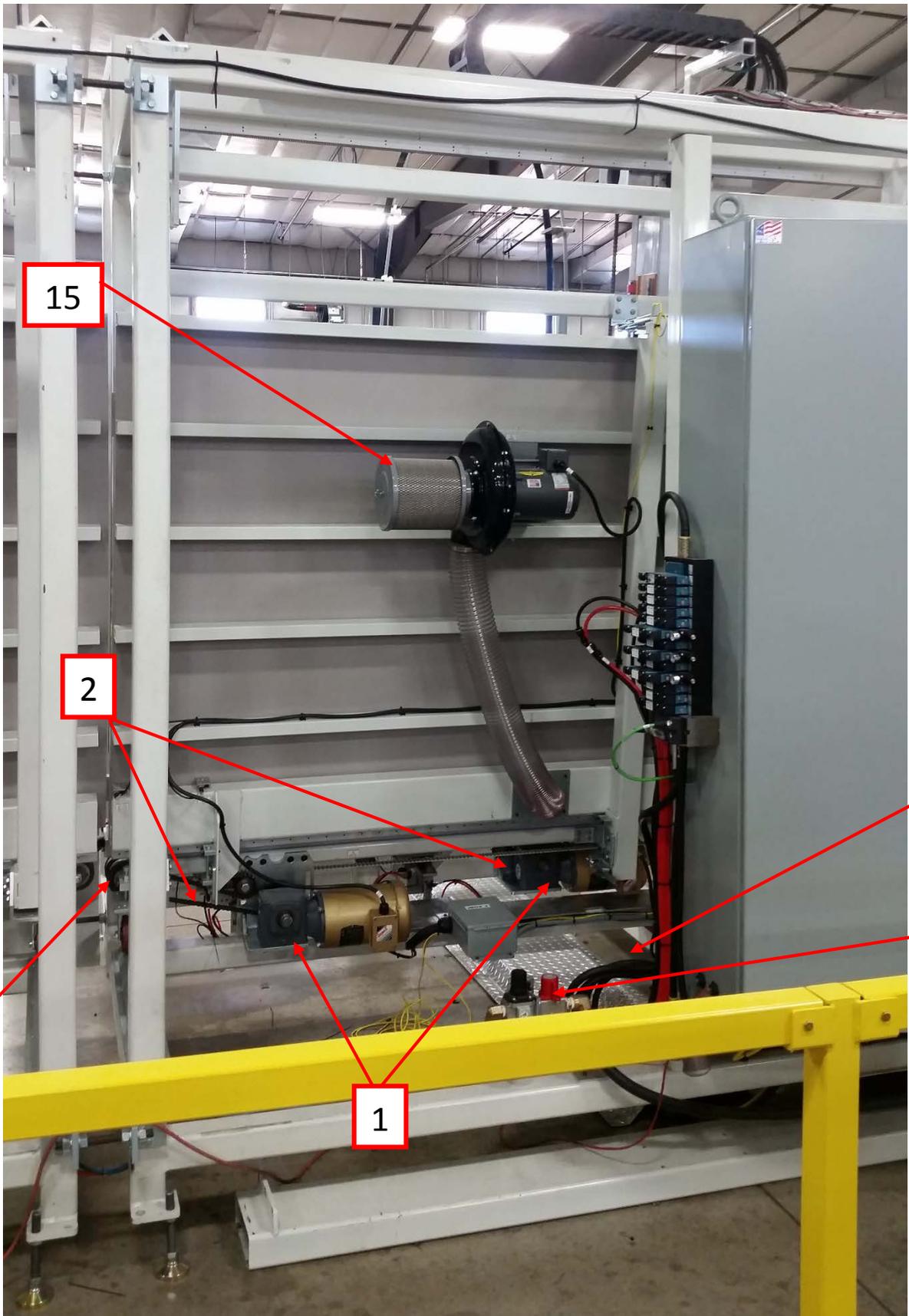
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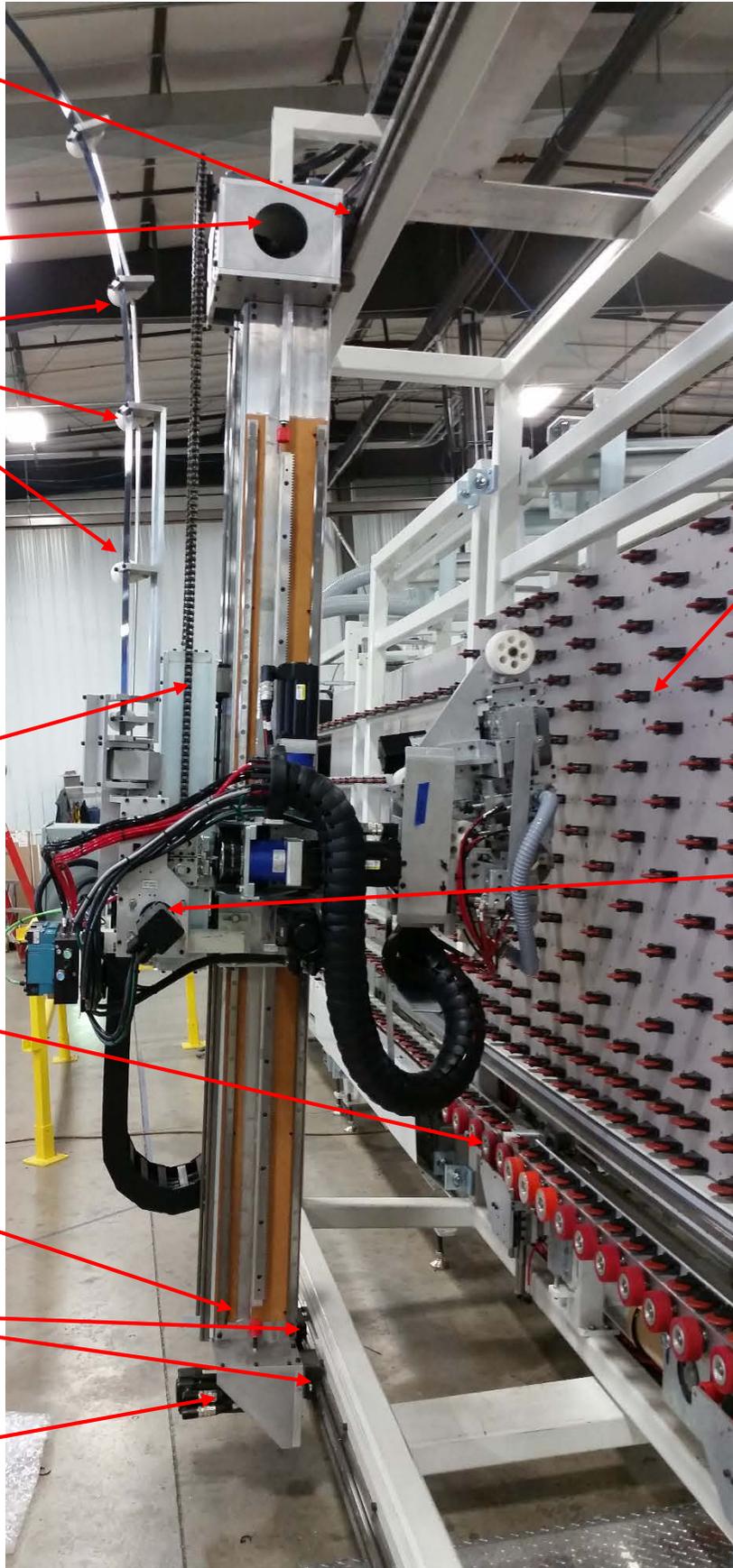
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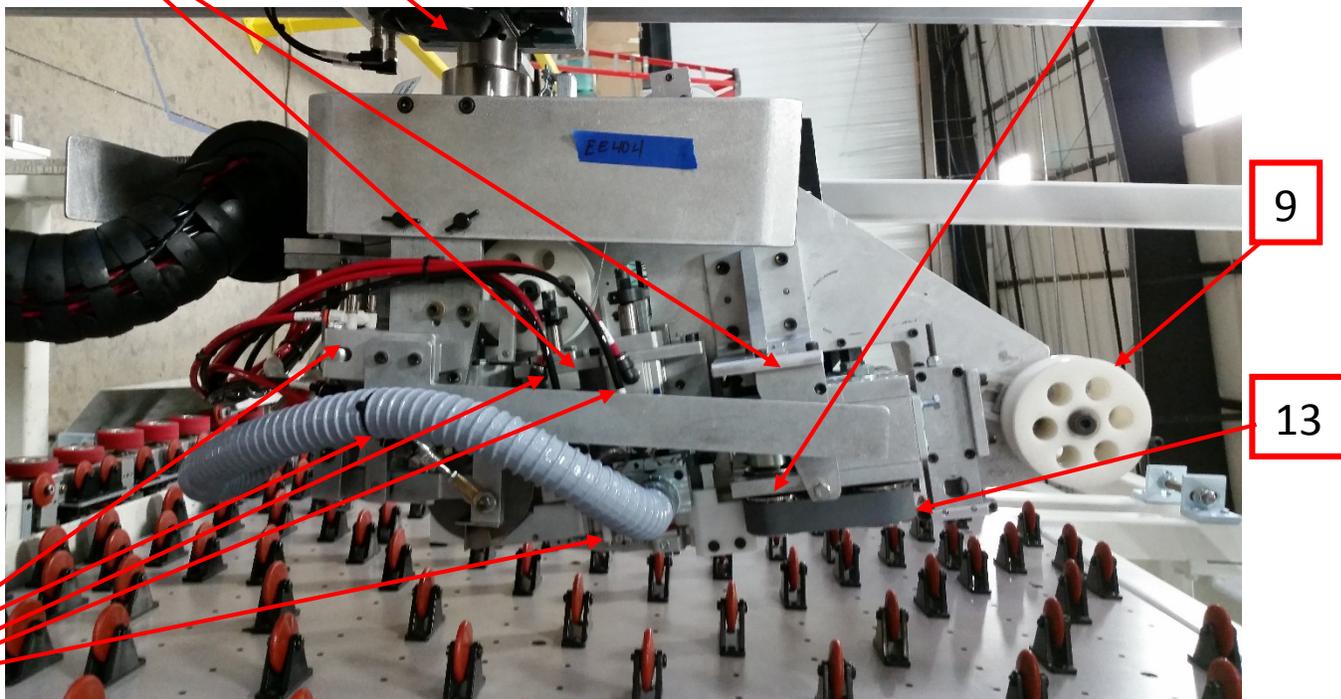
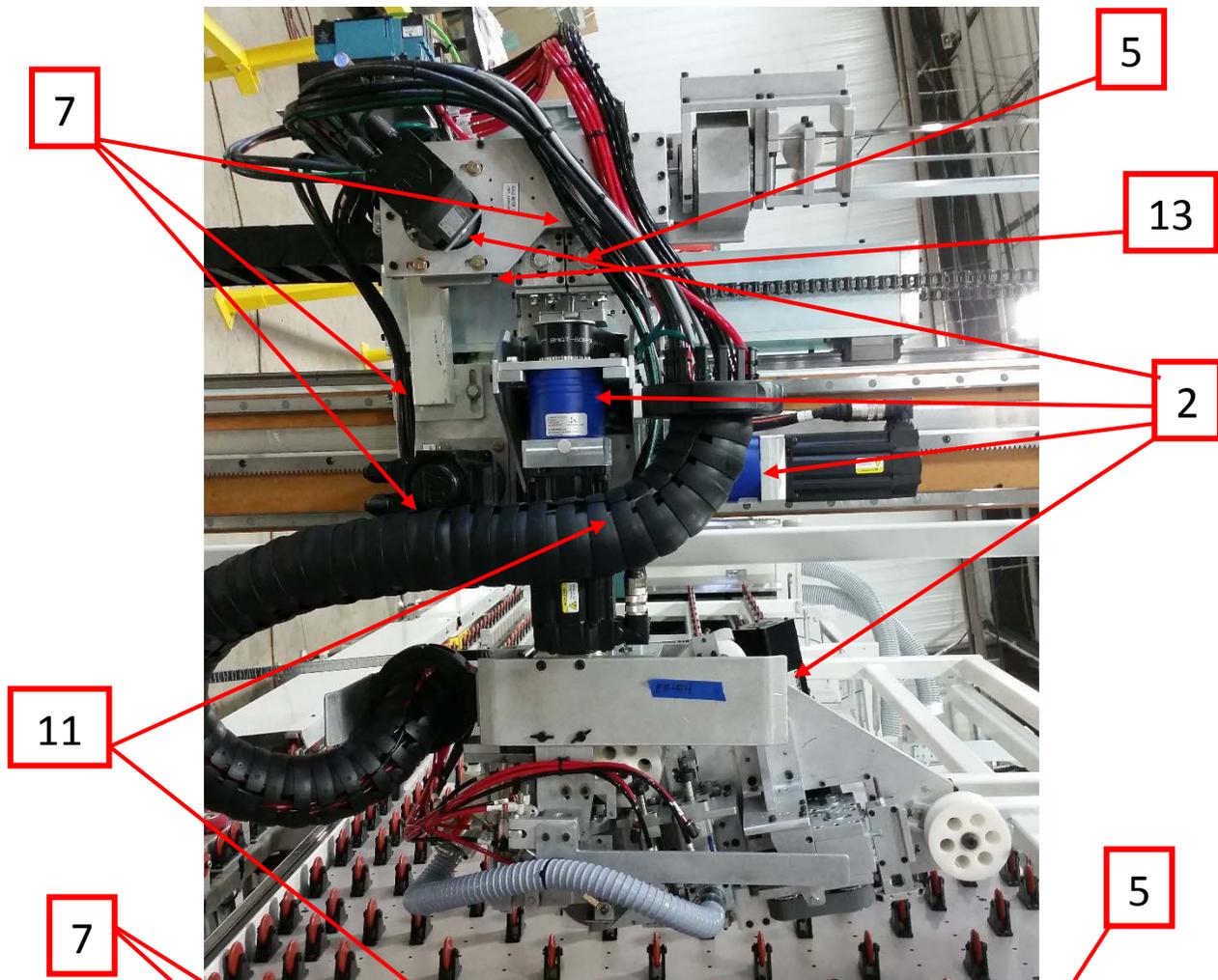
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1. Gear Box

- a. Location: Back, out feed end. Front and back shuttle, Roller box
- b. Type: ISO 460 Synthetic
- c. Frequency: Change oil every 6 months



2. Precision Gear Box

- a. Location: Gantry drive, applicator head drive, spacer powered feed drive (2), applicator head rotate, applicator head raise/lower, suction cup shuttle travel
- b. Lubricated for their service life by the manufacturer with a mineral oil-based lithium soap
- c. Inspect for leak and damage

3. Roller Chain



- a. Location: Conveyor drive, back, out feed end. Front and back shuttle, applicator head lift
- b. Inspection: Check for dust build up. Check for tension, wear, abrasions. Replace per manufacturer's instructions and recommendations
- c. Type: Crown 363115-001 Chain Lube
- d. Frequency: Inspect and lubricate once per month

4. Transfer Roller



- a. Location: Vertical bed surface
- b. Inspect and replace as needed

5. Bearing



- a. Location: Transfer belt pulleys, back shuttle. Transfer rollers, front shuttle, guide rollers spacer path
- b. Sealed and lubricated from the factory
- c. Inspect and replace as needed



6. One Way Needle Bearing

- a. Location: Transfer rollers, front shuttle
- b. Sealed and lubricated from the factory
- c. Inspect and replace as needed



7. THK bearings

- a. Location: Gantry travel, spacer feed guide
- b. Pay special attention to Blocks and Rails
- c. Wipe any contaminants such as dust or silicone from rail surfaces daily at minimum, between shifts is preferred
- d. Type: NLGI 2 EP Lithium
- e. Frequency: Grease every 20,000 units



8. Linear bearing, round shaft

- a. Location: Spacer dancer
- b. Wipe any contaminants such as dust or silicone from rail surfaces daily at minimum, between shifts is preferred
- c. No Lubrication required, replace as needed



9. Guide rollers Bushing

- a. Location: Guide rollers along spacer path
- b. Clean and replace as needed



10. Air cylinder

- a. Location: Roller box, suction cup shuttle, wheel shift, applicator head
- b. Wipe any contaminants such as dust or silicone from rod surface

11. Dodge bearings



- a. Location: Roller box, gantry, applicator head pivot,
- b. Type: NLGI 2 EP Lithium
- c. Frequency: Grease every 219,000 units

12. Conveyor Belt



- a. Location: back shuttle
- b. Clean with lukewarm cleaning solution and a soft cloth, dry with a soft cloth.
- c. Check for dust, silicone build up. Check for tension, wear, abrasions. Replace per manufacturer's instructions and recommendations

13. Silicone belt



- a. Location: Spacer powered drive
- b. Clean with lukewarm cleaning solution and a soft cloth, dry with a soft cloth.
- c. Check for dust, silicone build up. Check for tension, wear, abrasions. Replace per manufacturer's instructions and recommendations



14. Suction cups

- a. Location: Front shuttle
- b. Clean with lukewarm cleaning solution and a soft cloth, dry with a soft cloth.
- c. Replace when damaged



15. Air filter

- a. Location: Back, back shuttle blower motor
- b. Type: F885SP PAPER FILTER
- a. Frequency: Replace as needed



16. Pneumatic regulator

- a. Location: Back
- b. Check for water amount in collector
- c. Empty as needed



17. Vacuum pump

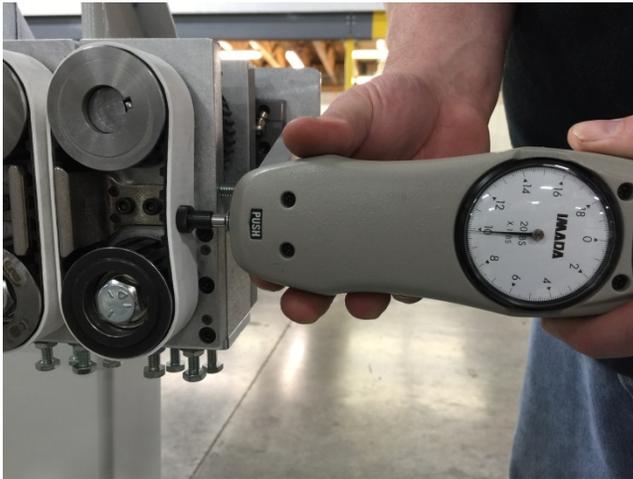
- a. Location: Back center
- b. Check filter for clogging
- c. Clean and replace as needed

TRACTOR DRIVE BELT TENSION INFORMATION

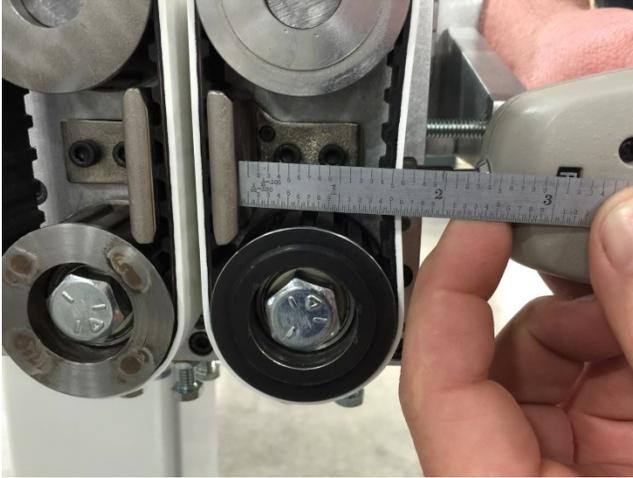
WHILE TENSIONING THE BELT TAKE A REFERENCE MEASUREMENT BETWEEN THE BELT AND BACK UP BRACKET



USING A PUSH GAGE APPLY 10 POUNDS OF FORCE NEAR CENTER OF THE BELT.



MEASURE THE AMOUNT OF BELT DEFLECTION WHILE APPLYING 10 POUNDS OF FORCE



COMPARE THE MEASURED AMOUNT TO THE REFERENCE MEASUREMENT TAKEN FIRST; THE DIFFERENCE SHOULD BE ABOUT .075

CONTINUE TO TENSION UNTILL THIS DIFFERENCE IS ACHIVED

CORNER KNIFE REFERENCE

GOOD CORNER KNIFE



GOOD CORNERS



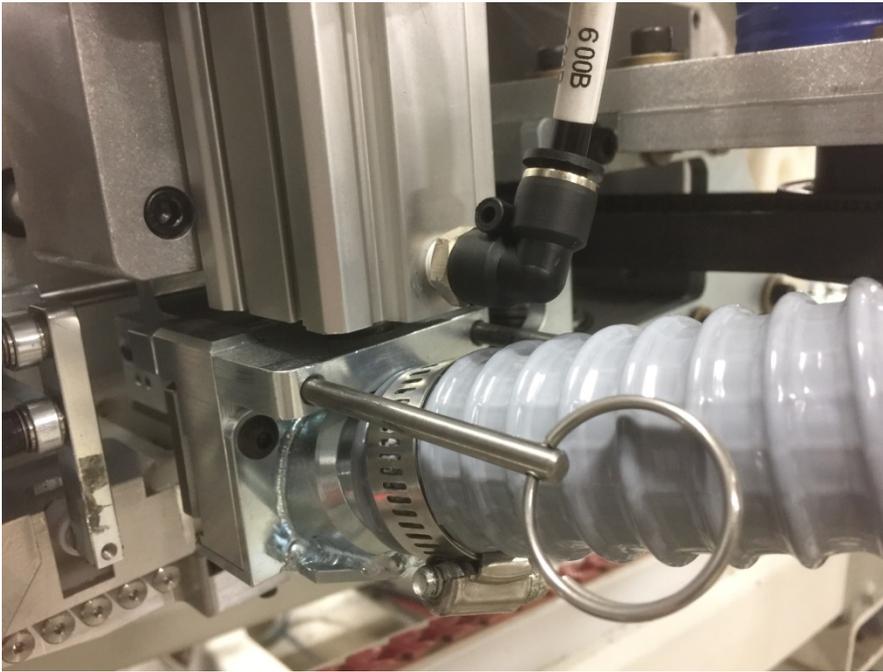
WORN / DAMAGED CORNER KNIFE



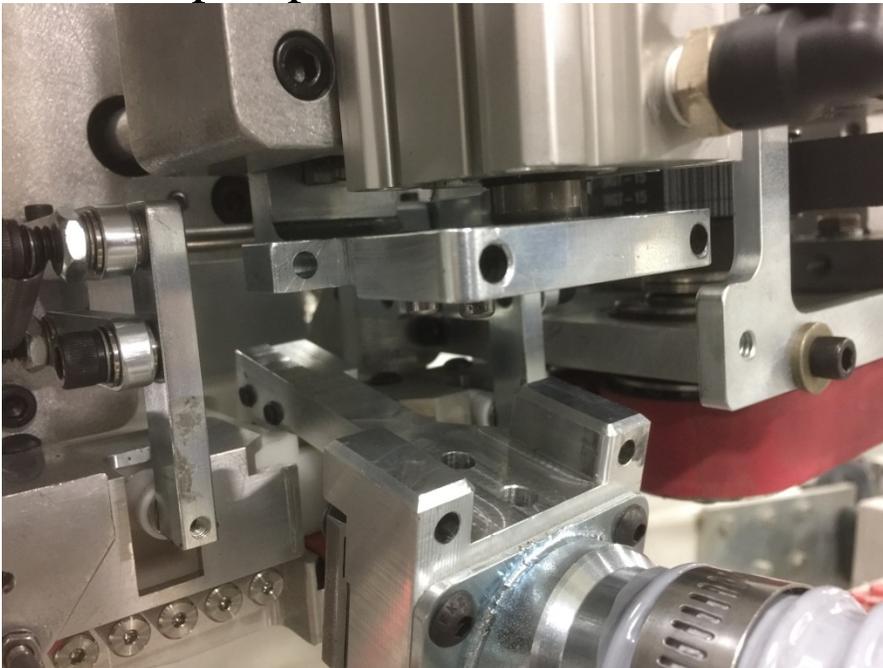
BAD CORNERS, NOT CUTTING COMPLETE



Knife removal and backer pad replacement



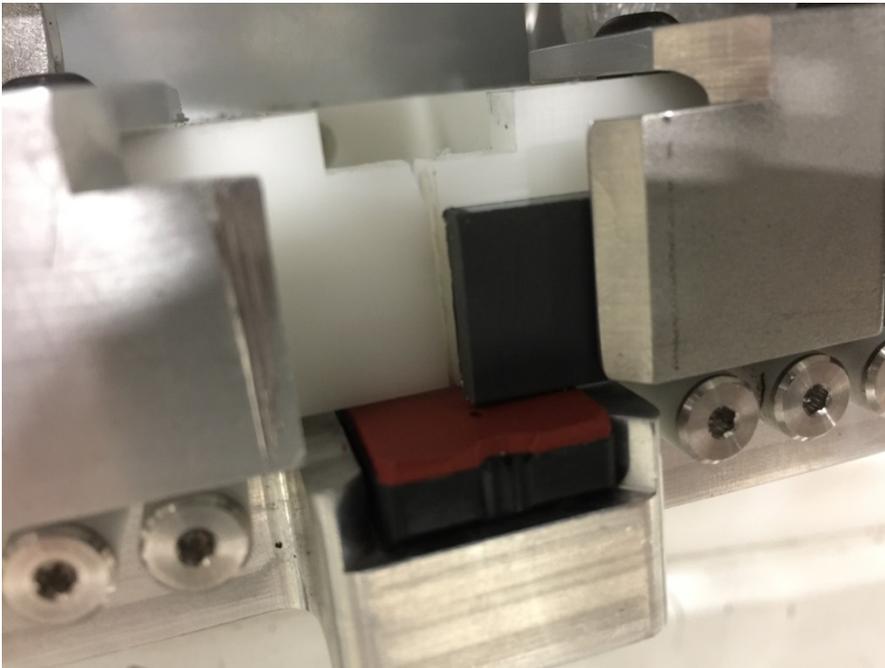
Remove pull pins



Lower knife assembly



Remove assemble



Note orientation of cutting pad before removal



Notch faces outward silicone side up

LENGTH TEST GAGE

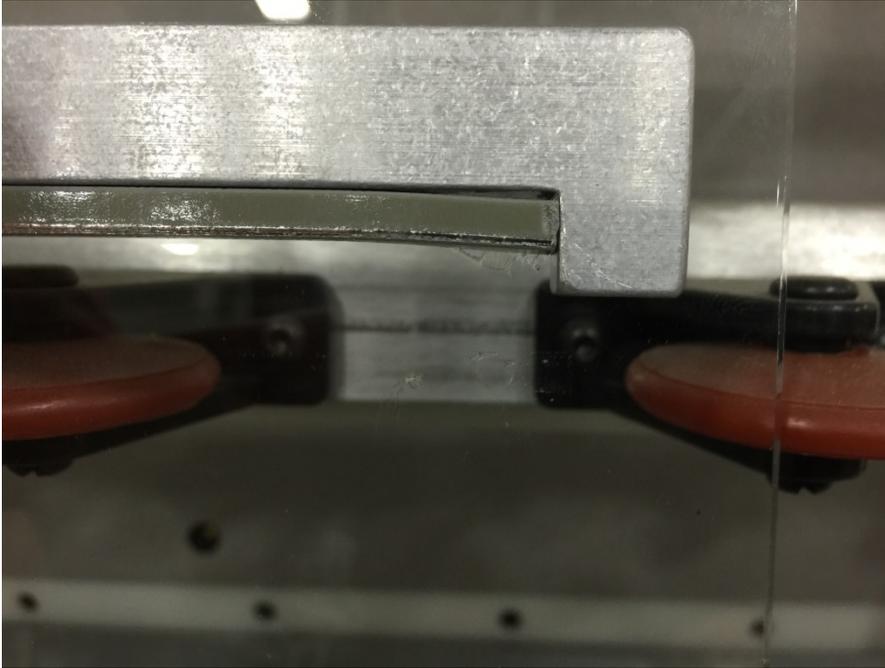
AFTER PERFORMING A LENGTH TEST USE THIS 18" GAGE TO VERIFY



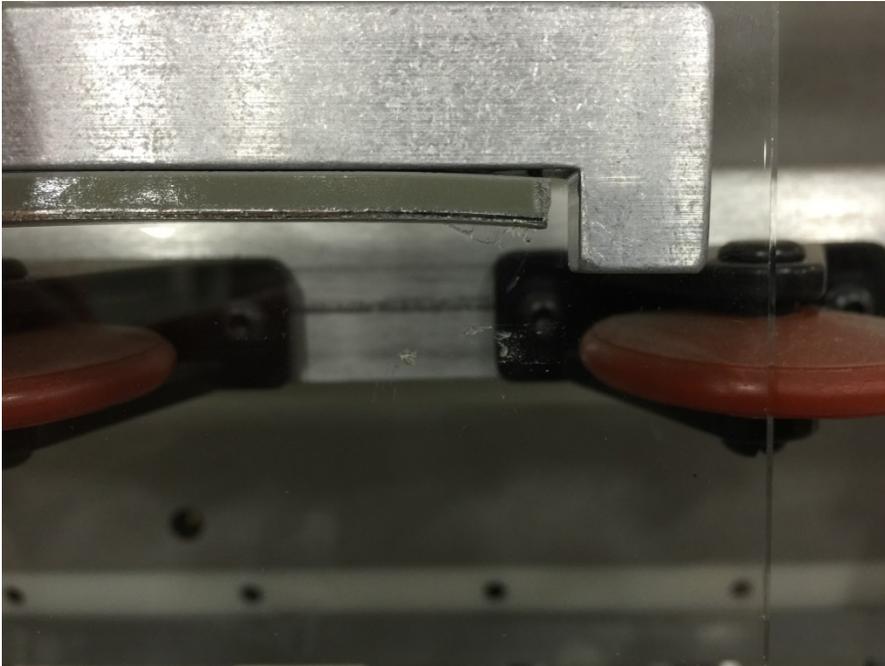
PLACE OVER LENGTH OF SPACER



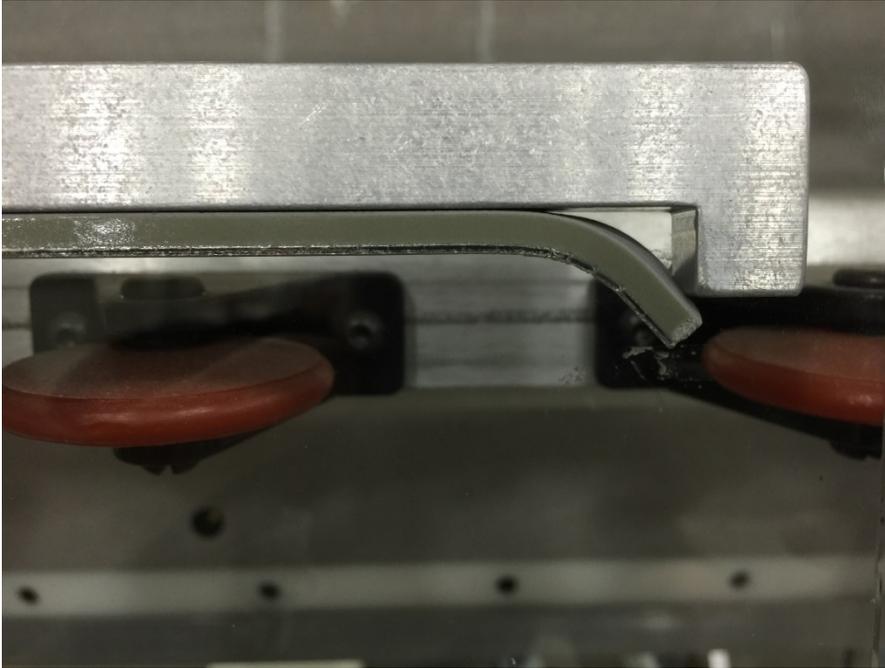
SPACER LENGTH SHOULD FIT IN GAGE SNUG



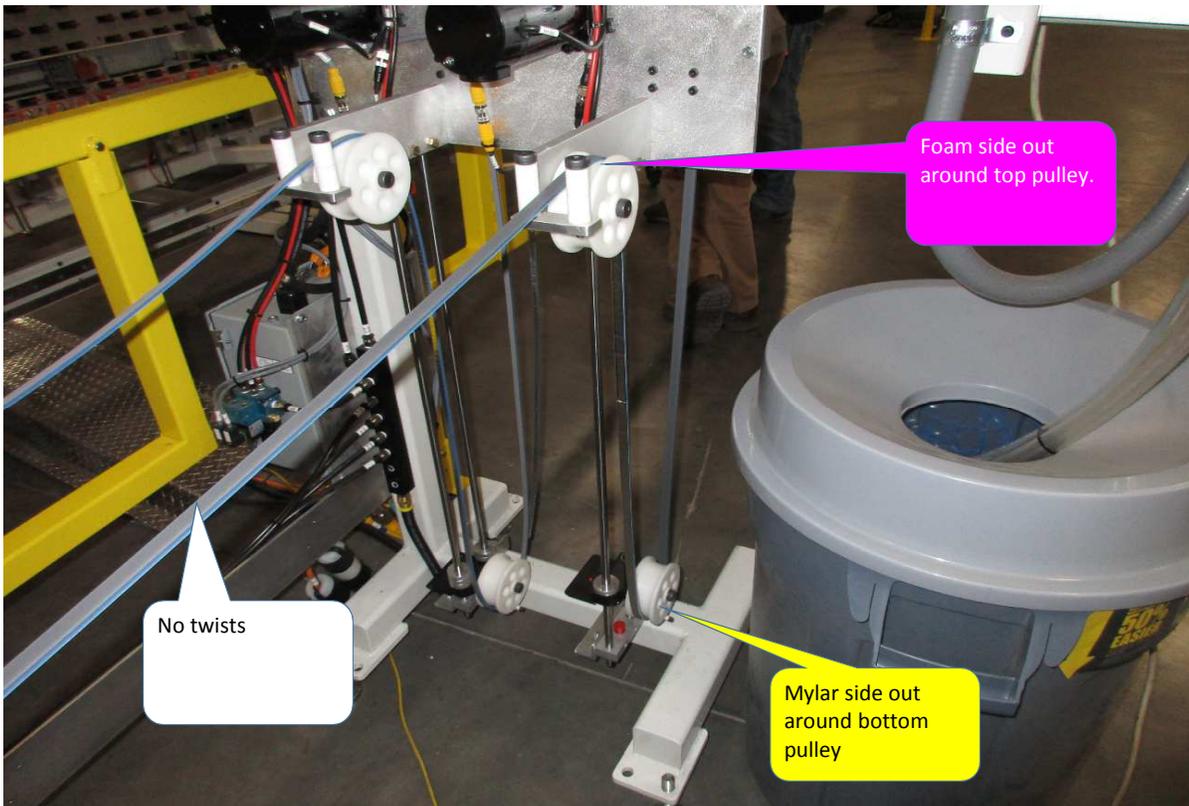
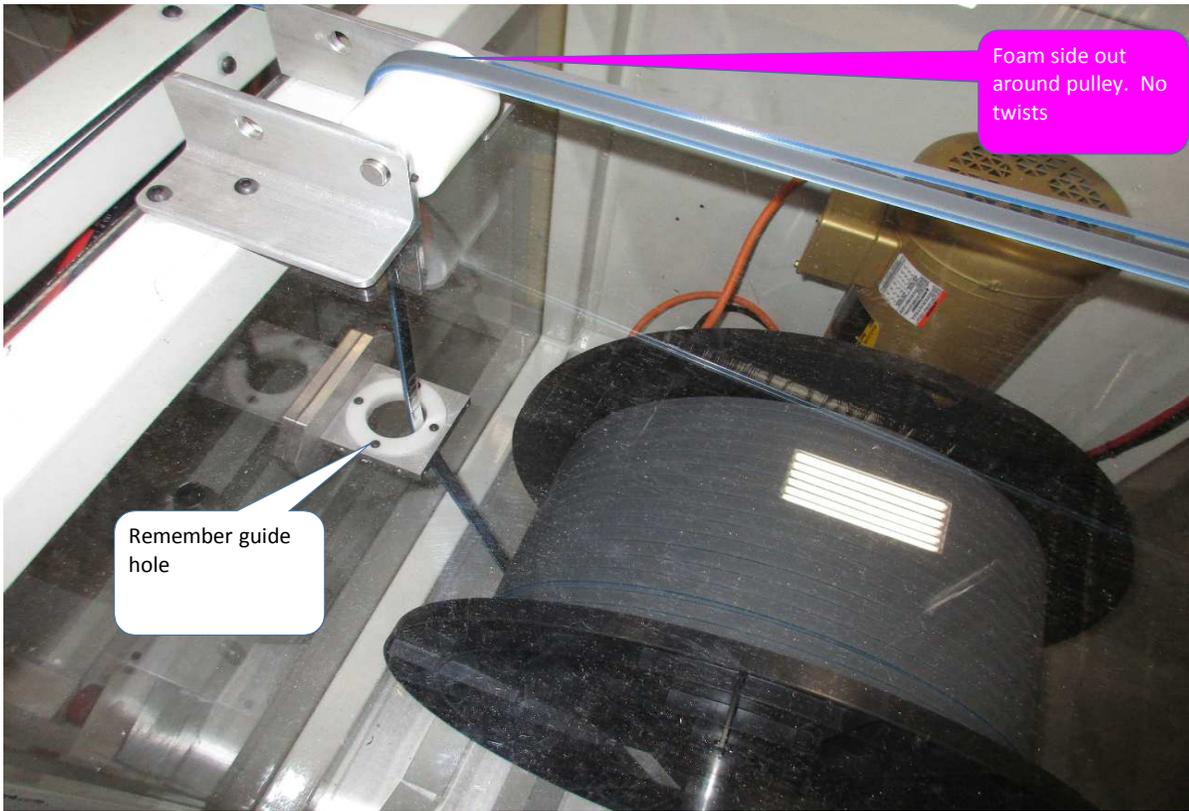
IF THE SPACER IS SHORT INCREASE THE FEED CONSTANT



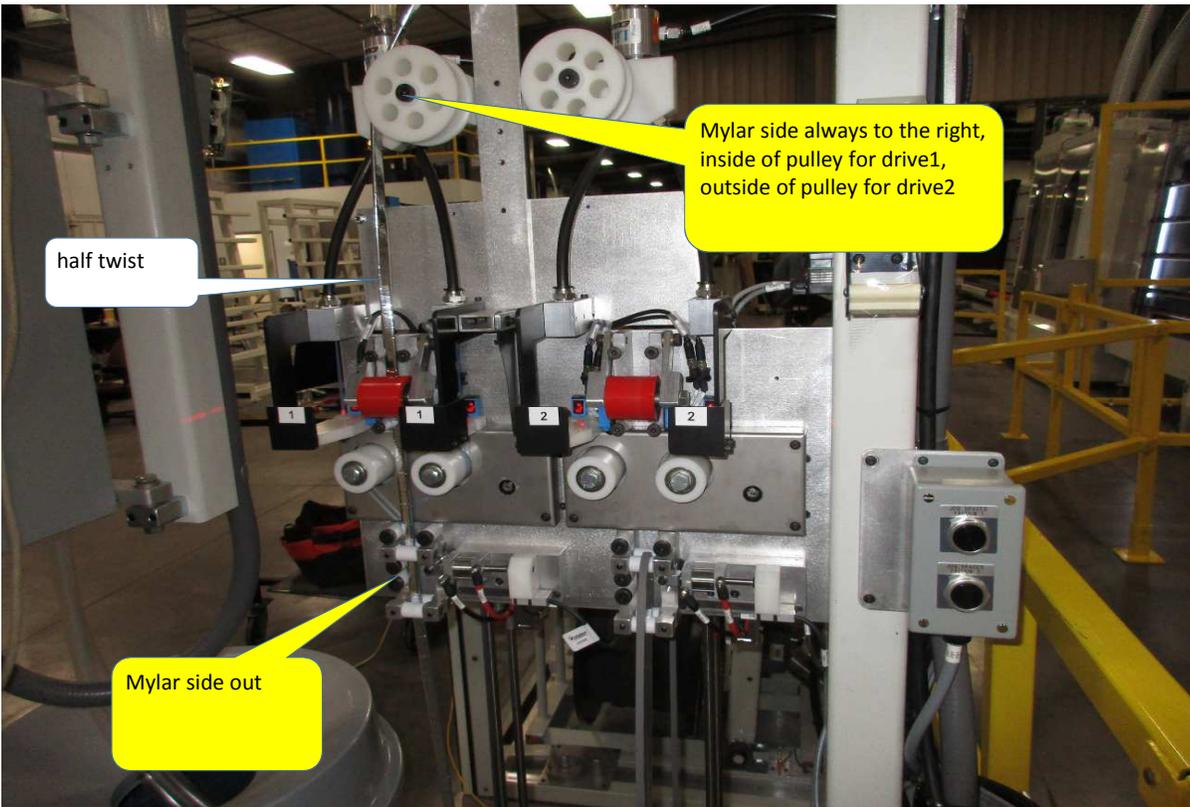
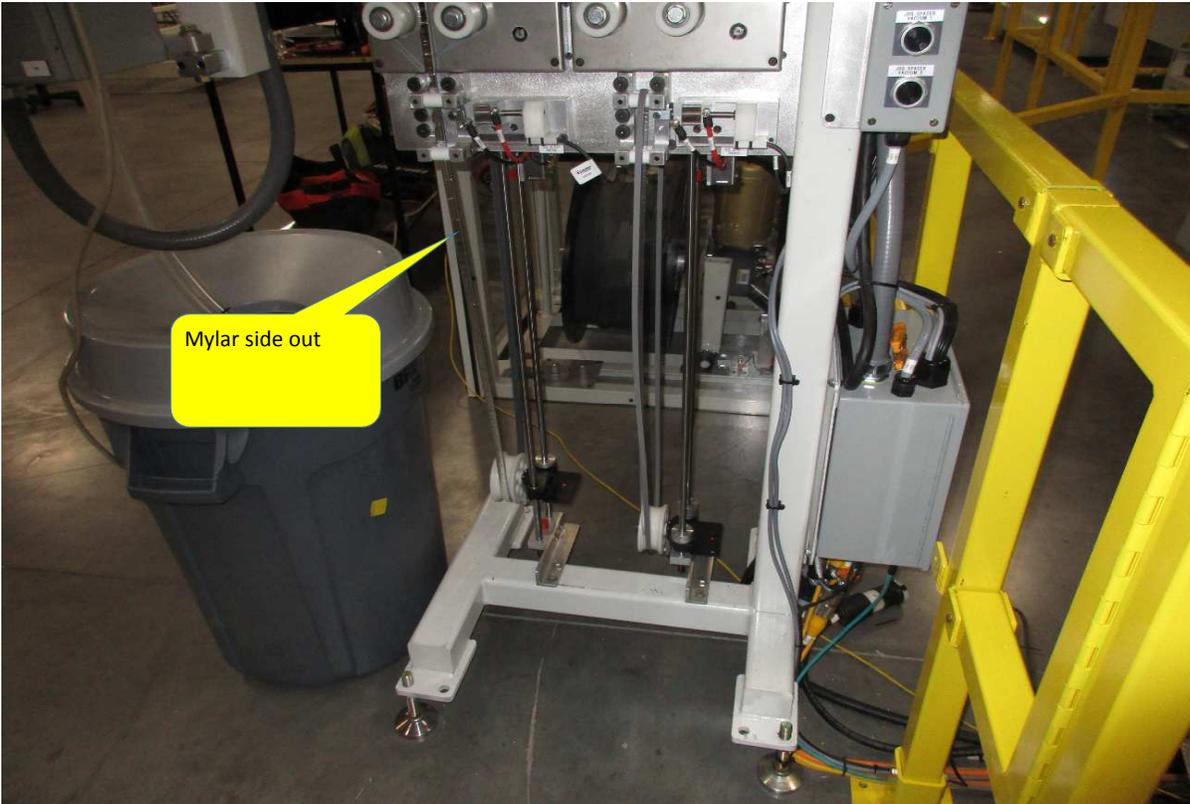
IF THE SPACER IS LONG DECREASE THE FEED CONSTANT



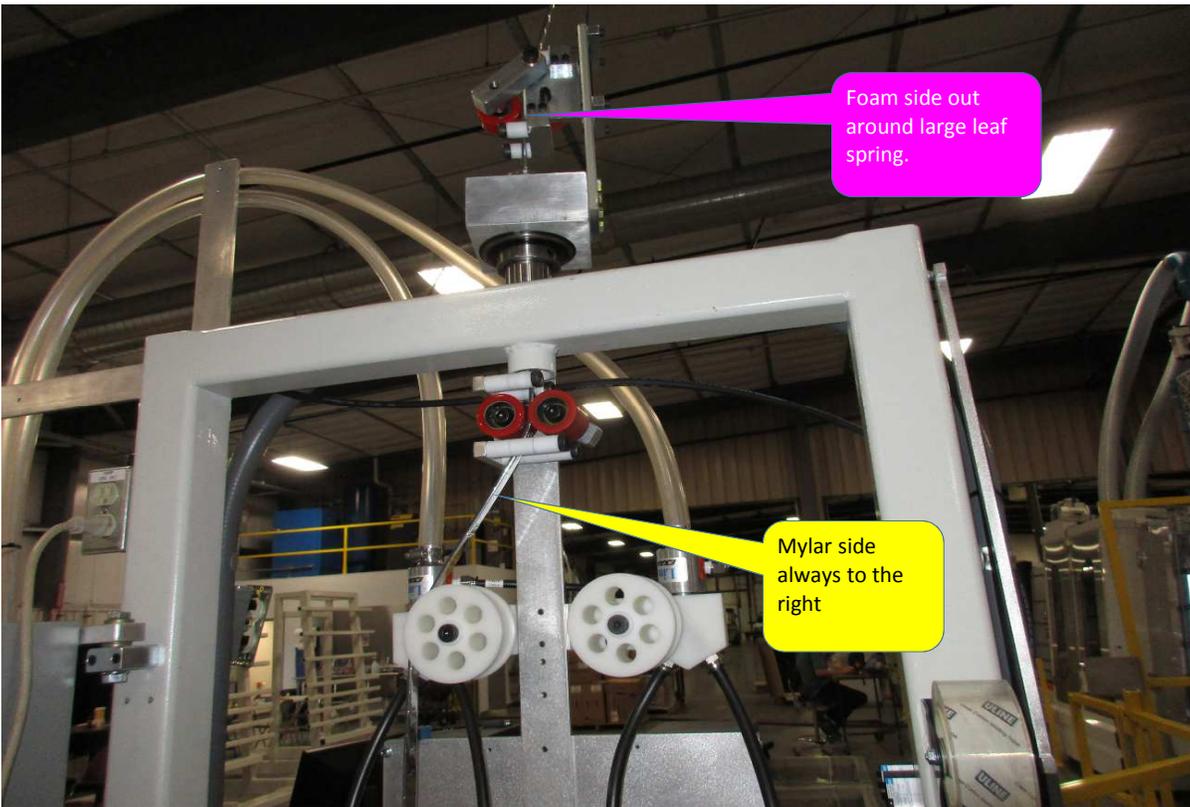
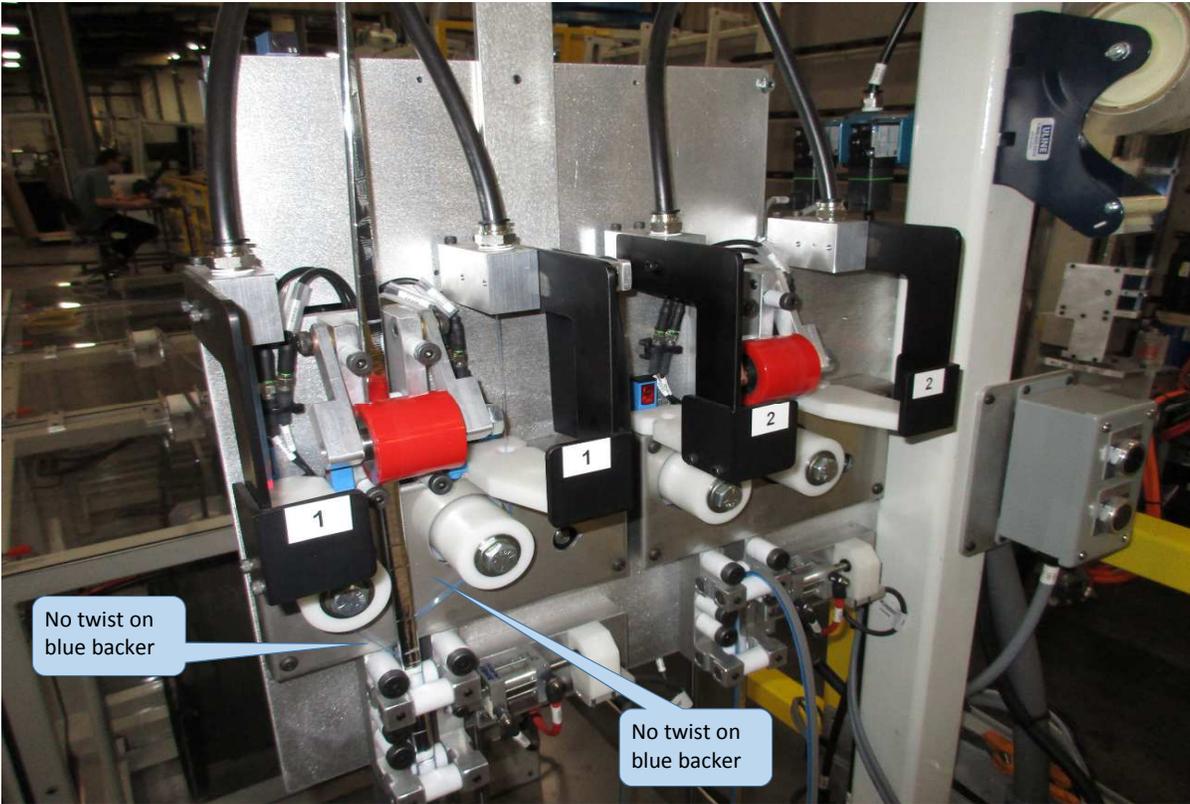
SAM Spacer Threading

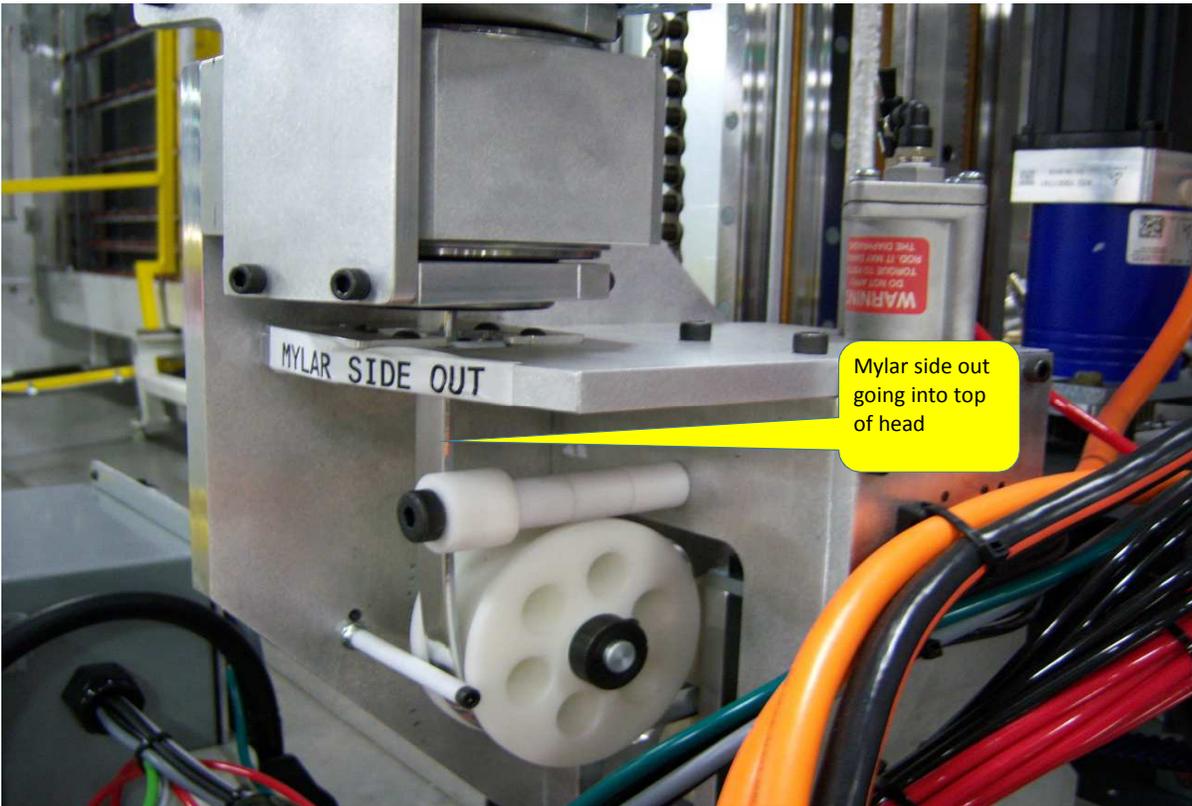
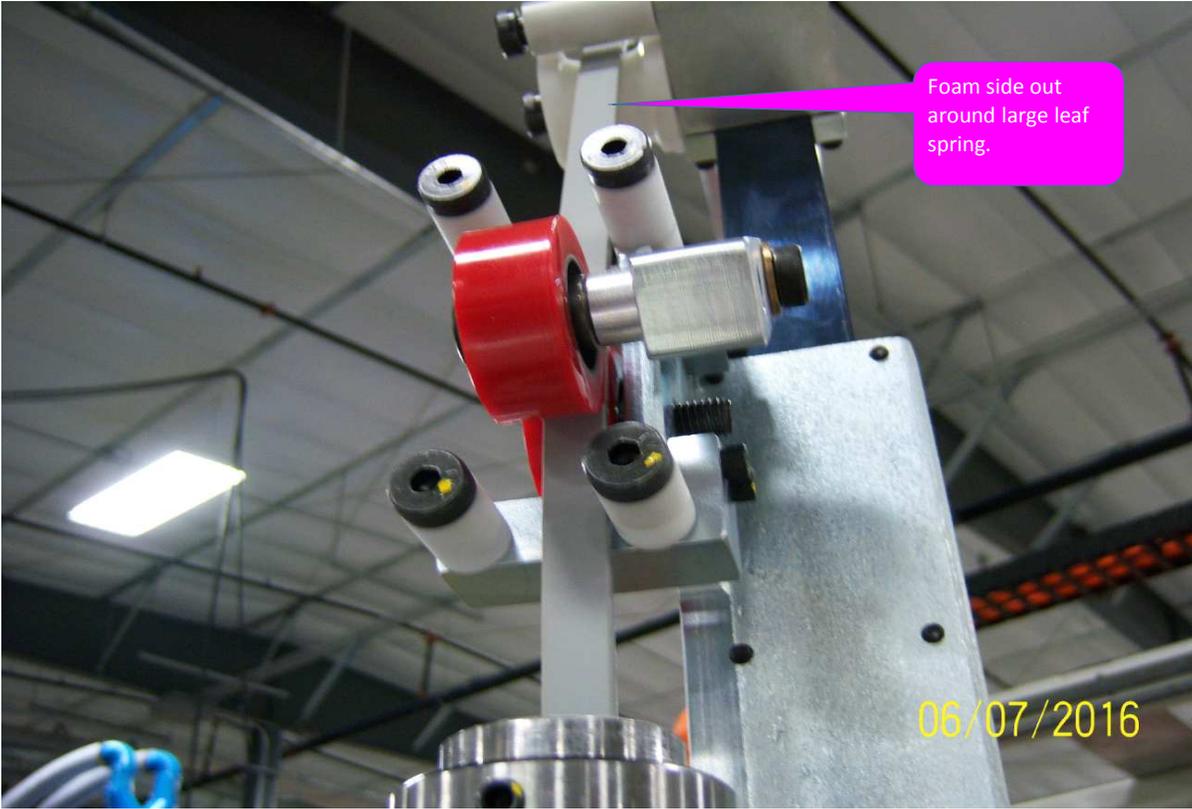


SAM Spacer Threading



SAM Spacer Threading





SAM Spacer Threading

