

**OPERATING & MAINTENANCE
INSTRUCTIONS
FOR
WELDOTRON MODEL 1205D
TRAY WRAP SEALER**

Technical Document #4005

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CAUTION

THE SAFETY OF PERSONNEL INVOLVED IN THE OPERATION OF INDUSTRIAL EQUIPMENT CAN ONLY RESULT FROM A WELL-CONCEIVED AND RIGIDLY ENFORCED SAFETY PROGRAM DEVELOPED BY THE USER OF SUCH EQUIPMENT. WHILE WELL-DESIGNED EQUIPMENT INCLUDING PERSONNEL SAFETY FEATURES IS EXTREMELY IMPORTANT, OF EQUAL OR EVEN GREATER IMPORTANCE IS THE ROLE PLAYED BY USER MANAGEMENT INVOLVING PROPER INSTALLATION, GOOD MAINTENANCE PROCEDURES BY TRAINED PERSONNEL AND RIGIDLY ENFORCED SAFETY RULES FOLLOWING THE PRACTICES RECOMMENDED BY SUCH ORGANIZATIONS AS A.N.S.I. AND O.S.H.A.

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SAFETY REQUIREMENTS & RECOMMENDATIONS

CAUTION

DO NOT ATTEMPT TO INSTALL, ADJUST, OR OPERATE THIS MACHINE WITHOUT FIRST READING THE CONTENTS OF THIS MANUAL. ALTHOUGH THE DESIGN OF THIS EQUIPMENT INCORPORATES SAFEGUARDS TO PROTECT OPERATING AND MAINTENANCE PERSONNEL, CARE SHOULD BE USED IN OPERATING, ADJUSTING, AND SERVICING.

WHEN MACHINE IS UNPACKED, INSPECT CAREFULLY FOR POSSIBLE SHIPPING DAMAGE. IF ANY IS FOUND, CONTACT CARRIER IMMEDIATELY AND DO NOTHING FURTHER WITH MACHINE UNTIL CARRIER'S AGENT HAS MADE INSPECTION, REPORT, ETC.

The design of this machine includes safety features required to eliminate potential hazards during operation or maintenance.

Applicable OSHA, ANSI, NEMA, and NEC standards have been followed as guidelines in the design and construction of this machine. References are made in this text to special areas of CAUTION. It is strongly recommended that you familiarize yourself with these CAUTION statements.

Tampering with or removing safety devices and/or improper operation or maintenance can result in exposing personnel to possible injury.

Please become familiar with this machine and follow the recommendations for safe operation, maintenance, and sanitation in the following page.

WELDOTRON CORPORATION SAFETY RECOMMENDATIONS

SAFETY IS ENGINEERED INTO ALL WELDOTRON EQUIPMENT; CERTAIN PRACTICES AND MINOR ALTERATIONS BY THE USER COULD INCREASE THE POTENTIAL TO ACCIDENTS AND/OR INJURY. IN THE INTEREST OF SAFE INSTALLATION, OPERATION AND MAINTENANCE, THE FOLLOWING RECOMMENDATIONS SHOULD BE STRICTLY ADHERED TO:

1. WARNING

Do not attempt to start or operate the machine until all safety items, installation instructions, operator/s guide & maintenance procedures have been followed & understood.

2. CAUTION

Adjustments, repairs or lubrication should be performed only by qualified maintenance personnel and by following the instructions in this manual and the LOCKOUT/TAGOUT PROCEDURE.

3. WARNING

Operator must keep fingers, hands, clothing or long hair away from the machine while it is in operation.

4. CAUTION

Do not place or leave tools, parts or other objects in or on the machine.

5. ALWAYS

Disconnect the main electrical power supply before performing any electrical work or removing any electrical component.

6. ALWAYS

Keep the machine clean & lubricated and in good operating condition.

Welcome to the Weldotron Family!

Weldotron is a recognized leader in the industrial packaging industry. Whether you own or lease your Weldotron packaging system, you are assured the highest quality in design, workmanship, and performance of any packaging system available.

The purpose of this manual is to familiarize you with the Model 1205D Tray Wrap Sealer and to provide instructions for the operation, maintenance and, if necessary, repair of the system. This manual also includes a complete set of parts lists and assembly drawings to facilitate maintenance and repair.

If certain unique installation requirements arise, or if there are any questions concerning your Weldotron packaging system which are not answered by this manual, one of our courteous Customer Service representatives will be happy to assist you.

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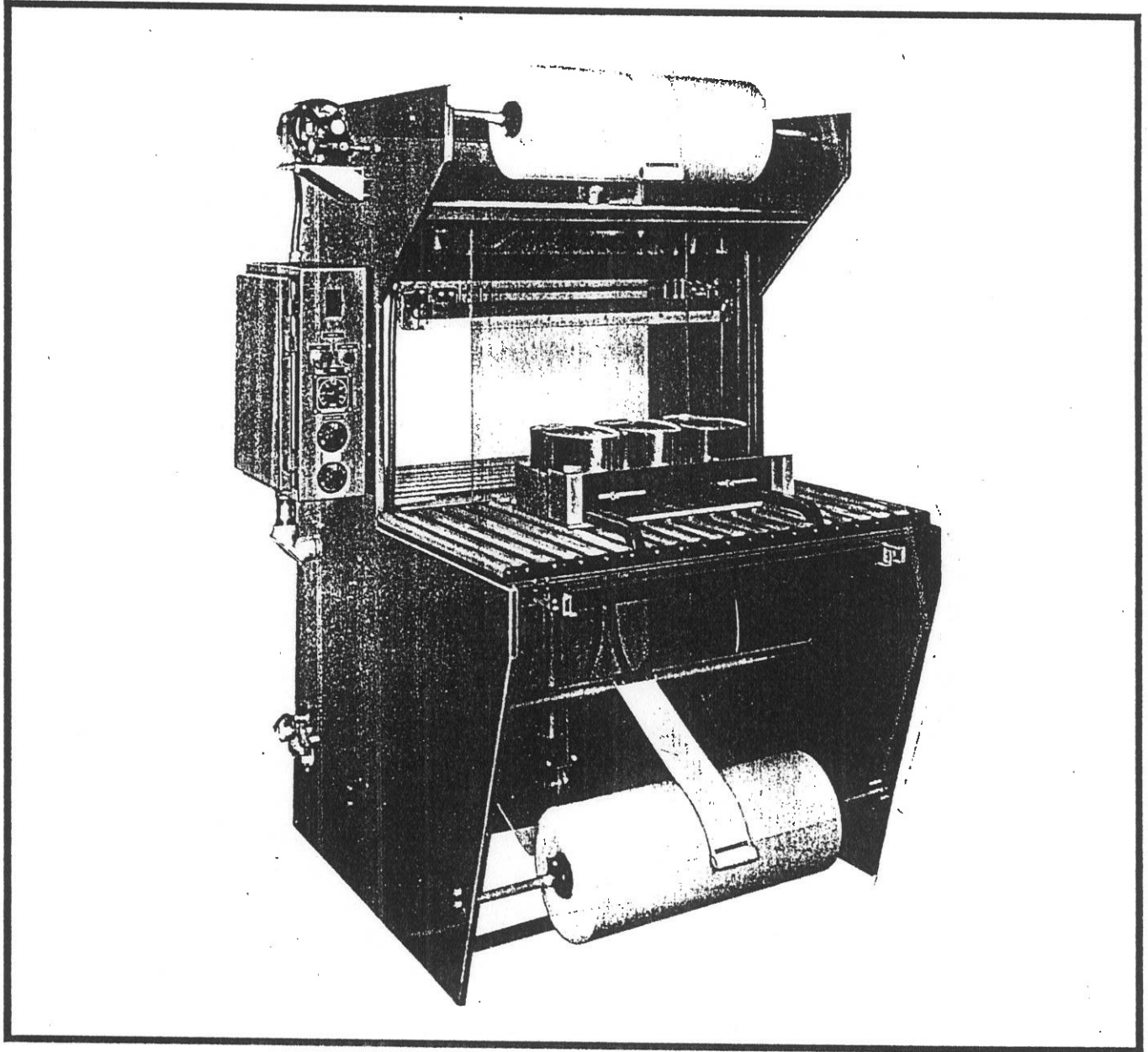
Limited Warranty and Disclaimer

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1. INTRODUCTION

The Model 1205 Automatic Tray Wrap Sealer is designed for use in heavy duty handling and case packing applications in which a heavy gauge film sleeve wrap is applied around heavy merchandise. When used with a shrink tunnel, a skin-tight clear plastic protective sleeve wrap is produced. Power assisted film feed is employed for the top and bottom film supply. The Sealer is equipped with a Precision Temperature Controlled (PTC) sealing system which provides extremely strong seals with all shrink films.



2. UNPACKING

Remove the sealer from shipping crate and inspect for possible damage.

**IF ANY DAMAGE IS NOTED, CONTACT CARRIER IMMEDIATELY. DO NOTHING FURTHER
UNTIL CARRIER'S AGENT HAS MADE AN INSPECTION OF THE DAMAGE.**

3. SPECIFICATIONS

Overall Dimensions	:	70 Inches high x 50 inches long x 42 inches wide
Electrical Requirements	:	230 Volts, 1 Phase, 60 Cycles, 10 Amperes (Other voltages available on special order)
Air Requirements	:	12 cfm free air, 80 psi nominal pressure
Maximum Film Width	:	30 inches
Maximum Package Height	:	14 inches

(Maximum package width depends on amount of film required to lock ends of product)

4. ORDERING INSTRUCTIONS

To avoid unnecessary delays in filling orders for replacement parts, follow the procedures recommended below:

1. State the machine name, model number, F.W.O. number and serial number.
2. List the part number and part name required, exactly as shown on parts list.
3. Specify the quantity desired.
4. Specify when needed.
5. Specify desired shipping method: Parcel Post, Truck, Express, Air, etc.

CAUTION

DO NOT attempt to install, adjust, or operate this machine without first reading the contents of this manual. Although the design of this machine incorporates safeguards to protect operating and maintenance personnel, care should be used in operating, adjusting, and servicing to prevent injury.

5. INSTALLATION

Place the sealer in the desired location with required electrical power* and air supply* sources available. Align and locate properly in respect to shrink tunnel.

* See SPECIFICATION section for proper electric and air requirements.

6. INITIAL OPERATION

A.

Connect sealer to proper electric and air supplies (air intake fitting is located at the rear of the unit).

B.

Adjust the air pressure regulator to a nominal 80 psi on the air gauge (located next to the air intake fitting).

C.

Refer to Figure 6.1, Page 6-2 and thread both film supplies as shown in the film threading diagram.

CAUTION

Switch Main Circuit Breaker to "POWER OFF" when removing and installing film rolls.

D.

Refer to Figure 6.2, Page 6-3 on the sealer control panel, throw the main power circuit breaker to its "ON" position. Set the "DWELL" timer to about one second.

NOTE

The setting of the "DWELL" timer may be varied experimentally to obtain the best seals.

E.

To make an initial film seal, manually pull film from both film rolls to a position past the seal bar. Depress and release the "HEAD DOWN" control panel button. The Sealing Head will come down, make the seal, and rise. Inspect the seal.

F.

Position a package of the size which will be used in production, behind the package pusher (located on the infeed section). By means of the slotted guides, adjust the package stop to center the package in the film. With the package against the stop, and centered in the film, tighten the slotted guide lock screws. Remove the package from the infeed section.

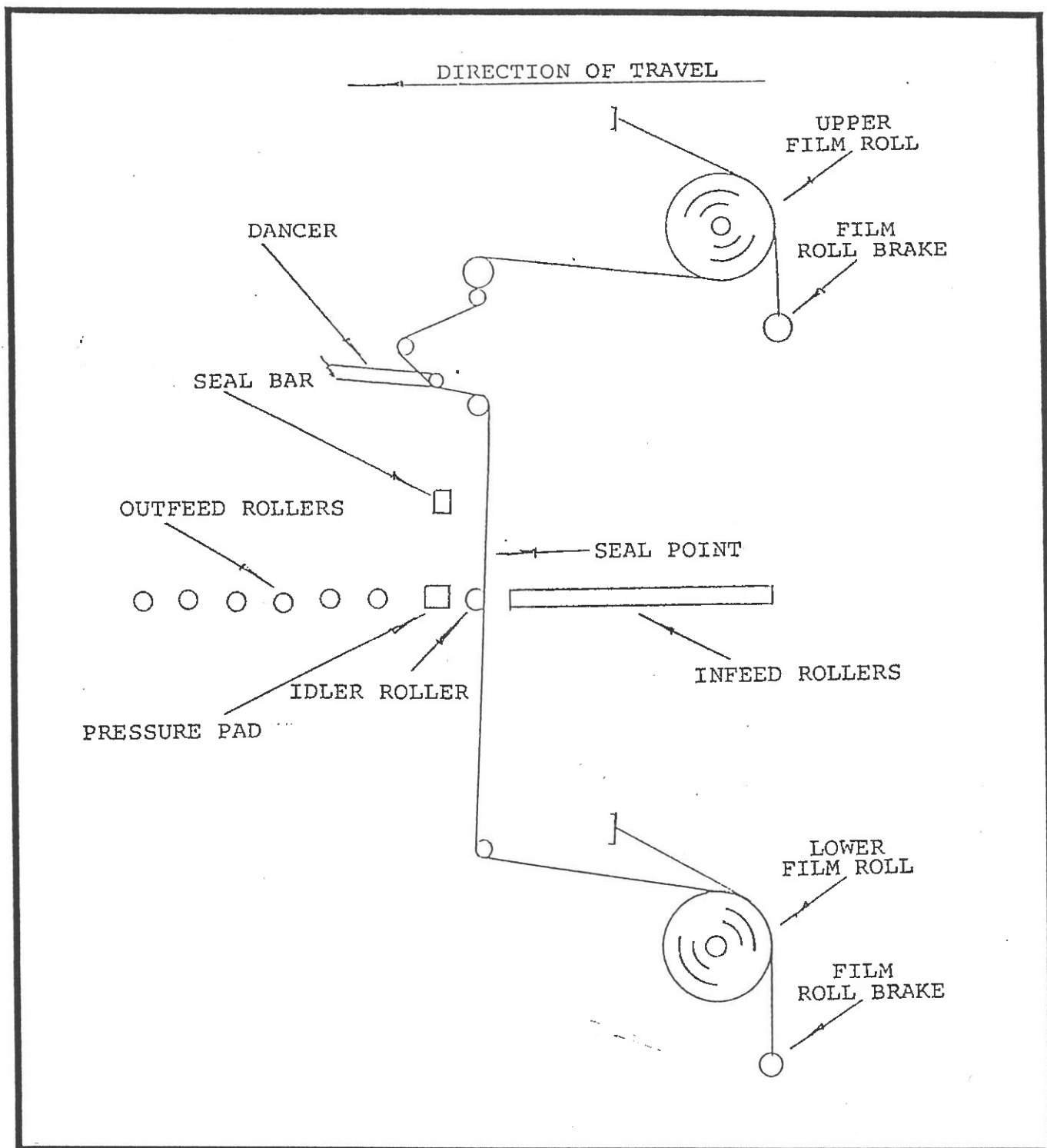


Figure 6.1 Film Threading

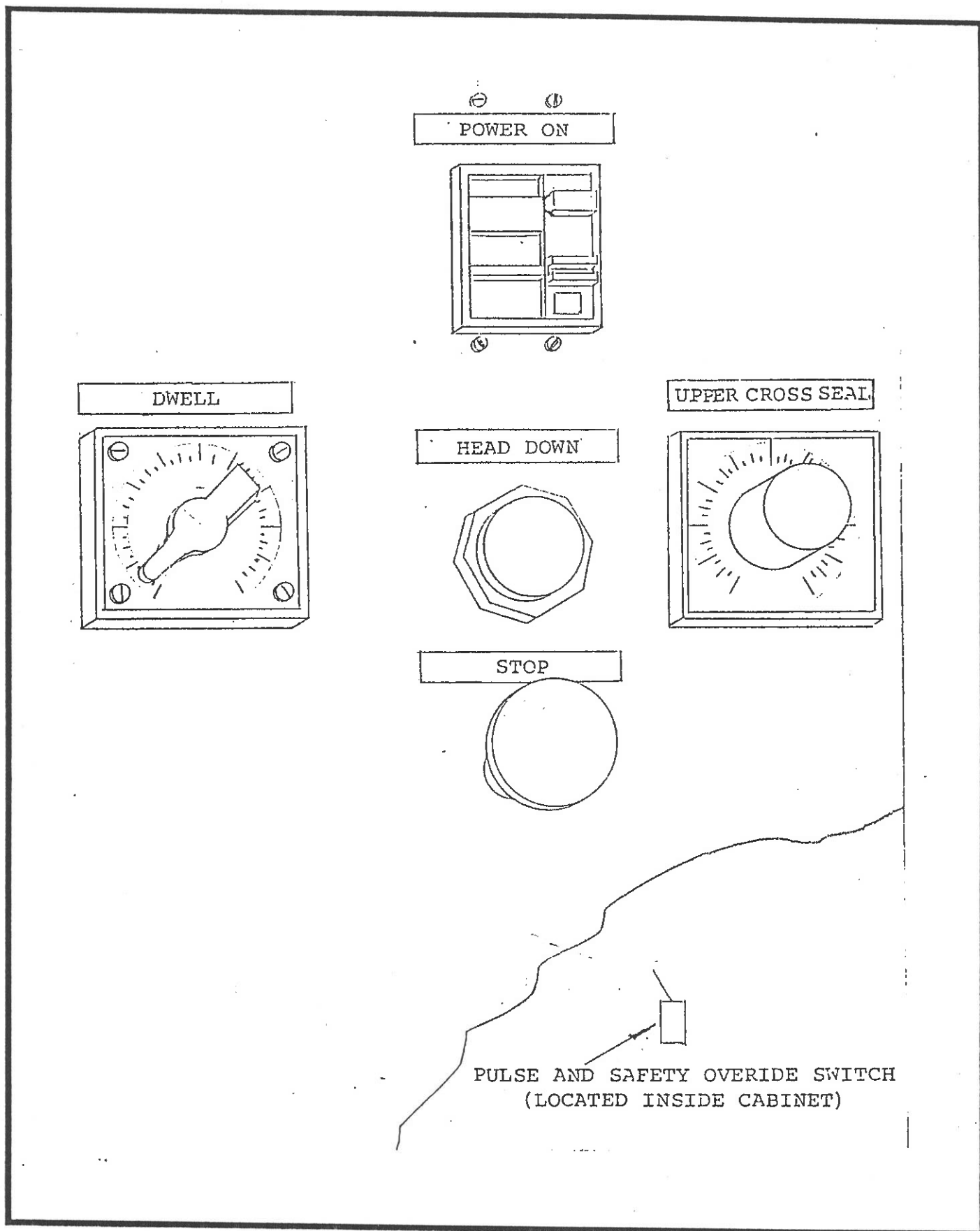


Figure 6.2 Sealer Controls

7. PRODUCTION OPERATION

After a satisfactory seal has been made, production operation may begin.

A.

Place a package to be wrapped on the infeed rollers, and manually move the package into position behind the package pusher and against the package stop.

B.

Using the hand grip on the pusher, manually push the package forward into the film curtain and onto the sealing area. (It will be noted that the package will require more film from the upper film supply, due to the fact that the upper film wrap goes around the front, top and rear of the package, whereas the lower film covers only the bottom of the package. To assure ease of operation, a film feed motorized power assist is provided for the upper film roll.

C.

With the package in the sealing area, pull the package pusher back to the load position. As the pusher comes back, a normally open limit switch will be closed, the seal bar will come down and the sealing cycle will begin.

D.

After the seal is made, the "DWELL" timer will time out and the seal bar will rise. The machine is now ready for subsequent package sealing.

E.

As the next package is manually pushed into the sealing area, it will push the previously sealed package onto the outfeed rollers, where it may be removed or transported into the shrink tunnel as desired.

LOCKOUT/TAGOUT PROCEDURE (OSHA Standard 1910.147)
(THE CONTROL OF HAZARDOUS ENERGY)

WARNING

This standard covers the servicing and maintenance of machines and equipment in which the unexpected energization or start up of the machines or equipment, or release of stored energy could cause injury to employees. This standard establishes minimum performance requirements for the control of such hazardous energy.

APPLICATION

This standard applies to the control of all energy during servicing and/or maintenance of Weldotron machines and equipment.

PURPOSE

This procedure establishes the minimum requirement for the lockout or tagout of energy isolating devices. It shall be used to ensure that the machine or equipment is isolated from all potentially hazardous energy and locked out or tagged out before employees perform any servicing or maintenance activities.

RESPONSIBILITY

Appropriate employees (Maintenance employees and Machine set-up employees) must be instructed in the safety significance of the lockout (tagout) procedure. Each person transferred or newly hired into such positions shall be trained at time of hire or transfer.

PREPARATION FOR LOCKOUT OR TAGOUT

Identify all isolating devices to be certain which switches, valves, or other energy isolating devices apply to the equipment to be locked or tagged out.

1. Electrical boxes - Power off, remove fuses.
2. Air - disconnect air.
3. Placing a tag on machine, indicates the machine is disconnected from power and out of service.

SEQUENCE OF LOCKOUT OR TAGOUT SYSTEM PROCEDURE

1. Notify all affected employees that a lockout or tagout system is going to be utilized and the reason therefore, i.e.: Foreman and operator.
2. Shut down equipment by normal stopping procedure.
3. Open switch, disconnect air, and unplug equipment isolating it from its energy source. Stored energy (such as that in springs, elevated machine members, rotating flywheels, hydraulic systems, and air, gas, or water pressure, etc.) must be dissipated or restrained by methods such as repositioning, blocking, bleeding down, etc.
4. Lockout and/or tagout the energy isolating devices with assigned individual locks or tags. In the case of a disconnect switch tagout and/or lockout. In the case of a plug, unplug, and tagout.
5. After ensuring that no personnel are exposed and as a check on having disconnected the energy sources, operate the pushbutton or other normal operating controls to make certain the equipment will not operate.

CAUTION

Return operating controls to "NEUTRAL" or "OFF" position after test.

6. The equipment is now in a lockout and/or tagout condition.

RESTORING MACHINES OR EQUIPMENT TO NORMAL PRODUCTION OPERATIONS

1. After servicing and/or maintenance is complete and equipment is ready for normal use, check the area around the machine or equipment to ensure that no one is exposed.
2. After all tools have been removed from the machine or equipment, guards have been reinstalled and employees are in the clear, remove all lockout or tagout devices. Reinstall fuses and undo any other energy isolating devices to restore energy to the machine or equipment.

PROCEDURE INVOLVING MORE THAN ONE PERSON

In the preceding steps, if more than one person is required to lockout or tagout equipment, each shall place his or her own personal lockout device or tagout device on the energy isolating device. Maintenance personnel will use multiple locks. When mechanic and electrician work together, each will tagout the plug and no one but the person installing the tag can remove it and equipment is not to be plugged in with any tagout on it.

BASIC RULES FOR USING LOCKOUT OR TAGOUT SYSTEM PROCEDURE

All equipment must be locked out or tagged out to protect against accidental or inadvertent operation when such operation could cause injury to personnel. Do not attempt to operate any switch, valve, or other energy isolating device where it is locked or tagged out.

8. MAINTENANCE

8.1 PTC SEAL BAR REPLACEMENT

- a. Place MAIN CIRCUIT BREAKER in the "OFF" position.
- b. Disconnect wiring plugs.
- c. Remove and replace PTC Seal Bar Assembly (Reference drawing B-306-0002 Seal Bar Assembly).

8.2 SAFETY OVERRIDE SWITCH ADJUSTMENT

The Safety Override switch functions to assure that the sealing cycle will be interrupted and the sealing head immediately returns to its normal upward position if a package should stop or be misplaced under the sealing head. To test the action of the Safety Override Switch, place a 1/4 inch thick stack of corrugated cardboard under the sealing head and operate the sealer to perform a sealing cycle. The sealing head will rise.

The Safety Override switch is also factory adjusted and any field adjustment would only pertain to the setting of the Pulse Limit Switch LS/2 and the Safety Override Switch LS/1.

8.3 SEALING HEAD CYLINDER ADJUSTMENT

For sealing head speed and smoothness, turn the upward and downward cylinder-operating flow-control exhausters (located in the inlet of the solenoid valve). The desired cushioned action is controlled by adjustment screws located at either end of cylinder.

8.4 AIR LINE LUBRICATOR OIL LEVEL FOR CYLINDER PISTON

Proper oil level must be maintained in the air line lubricator jar (located outside the cabinet where the air supply enters) to assure proper sealing head operating piston lubrication. To maintain proper oil level inspect jar. The oil should be within approximately 1/4 inch of the top of the jar. If required, add oil by unscrewing the oil-replacement cap on top of the unit. Replenish ONLY with SAE #10 NON-DETERGENT motor oil.

8.5 THE CONVEYOR ROLLER AND FILM ROLLER BEARINGS SHOULD BE LUBRICATED PERIODICALLY USING LIGHT OIL.

NOTE

No other points on this machine require periodic lubrication as all bearings are permanently lubricated for the life of this machine.

9. OPERATION OF SAFETY CIRCUIT

To prevent injury to personnel, or damage to products being packaged, a safety circuit is incorporated into the design of these sealers. To check the operation of the safety circuit, proceed as described below.

A.

With the Sealer's circuit breaker in the "OFF" position, check that nothing is resting on the top surface of the Sealer or package infeed conveyor areas. **KEEP HANDS AWAY FROM THESE AREAS.**

B.

Place 1/4-inch thick corrugated cardboard across the sealing pad.

C.

Turn the sealer's circuit breaker to the "ON" position.

D.

Depress and release the "HEAD DOWN" button. The sealing head will come down until contact is made with the cardboard. The sealing head should immediately return to its top position without damage to the cardboard. If not, refer to paragraph 9.1 for corrective action.

E.

At the conclusion of this test, return the sealer's circuit breaker to the "OFF" position.

9.1 IF THE SEALER DOES NOT OPERATE AS DESCRIBED IN PARAGRAPH 9, OPERATION OF SAFETY CIRCUIT, PERFORM THE FOLLOWING TESTS FOR EACH LISTED TROUBLE.

A. Sealing Head Does Not Cycle

If the sealing head does not cycle down when the "HEAD DOWN" button is pressed, one of the switches located on the sealing head cover bar may not be making good contact. To check this (with the head in the raised position), cycle each switch manually approximately ten times by pushing the clamping bar on the electrode head and releasing. When manually cycling these switches, their snap action should be heard. If not, check the condition of these switches and, if necessary, adjust or replace. After manually cycling each of these switches, repeat the test of safety circuit operation of paragraph 9.

NOTE

BE SURE to push the "HEAD DOWN" button for each test.
The sealing head will come down.

- b. Sealing head cycles down, but returns immediately upon contacting lower sealing pad.

If the sealing head cycles down but immediately returns to the raised position upon contact with the lower sealing pad, proceed with the following corrective action:

Make sure nothing is laying on the sealing pads which could cause the safety bars and safety switches to be prematurely actuated. If nothing seems to be in the way and the head continues to return to the raised position the Safety Override Switch should be inspected for proper operation. With the sealing head in the raised position, turn "OFF" the circuit breaker. The Safety Override Switch is located on the right, inside the lower cabinet section, as viewed from the front of the machine. The switch housing contains both the Safety Override Switch and the Element Pulse switch, both being operated by a single rod lever arm. Manually operate this lever arm. Two distinct audible clicks should be heard. The first indication would be the Safety Override operation, the second would be the Pulse switch. These switches are factory adjusted for correct position and proper operation, however, in absence of an audible click continuity tests for switch operation should be made. These checks should determine whether or not the arm is being mechanically actuated by the seal bar motion. This can be done by turning "ON" the circuit breaker, depressing the "HEAD DOWN" button and visually observing the mechanical operation of the switch. When a malfunction is corrected, the sealing head should be recycled to check if it will stay in the down position to complete the sealing cycle. After the head is cycling properly, check out the safety circuit following instructions outlined in paragraph 9.

- c. Sealing head does not return immediately when safety circuit is being checked.

If the sealing head does not immediately return when the 1/4-inch thick stack of corrugated cardboard is placed on the lower bar to check out the safety circuit, the Safety Override should be inspected for proper operation. With the sealing head in the raised position, turn "OFF" the circuit breaker. The Safety Override switch is located on the right, inside the lower cabinet section, as viewed from the front of the machine. The switch housing contains both the Safety Override and the Element Pulse switch, both being operated by a single rod lever arm. Two distinct audible clicks should be heard. The first indication would be the Safety Override operation, the second would be the Pulse switch. These switches are factory adjusted for correct position and proper operation, however, in absence of an audible click, continuity tests for switch operation should be made. These checks should determine whether or not the switch should be replaced. Check too, for possible damage to the lever arm and/or whether or not the arm is being mechanically actuated by the seal bar motion. This can be done by turning "ON" the circuit breaker, depressing the "HEAD DOWN" button and visually observing the mechanical operation of the switch. When a malfunction is corrected, the safety circuit should be rechecked by placing the stack of cardboard on the sealing pad and cycling the head to see if it will return upward automatically.

10. TROUBLESHOOTING CHART

This Troubleshooting Chart has been prepared to assist users of the Weldotron Model 1205 Automatic Tray Wrap Sealer in determining the source and cure of operating difficulties which may occur. In performing the tests and checks which follow, carefully inspect for wire breakage, loose wires, poor electrical connections, loose terminals, broken or cracked hoses, fitting, hose clamps, etc., while testing the various switches, valves, fittings, controls, relays and transformers. For checking any electrical troubles, simple test equipment such as neon test light, continuity buzzer, and a small multimeter, is required.

Refer to Figure 6.1, Page 6-2 for location of controls and adjustments and to the various operating, service and maintenance paragraphs of this manual. Refer also to the electrical schematic diagram included with the Sealer.

CAUTION

In performing the troubleshooting test and checks which follow, use caution to avoid contact with the voltages and the moving parts of the Sealer. Power should be on only when needed for testing. Ohmmeter or electrical continuity test of electrical components should, of course, be done only with the Sealer turned off.

PROBLEM	REMEDY
a. Pilot light does not light.	1. Check if power source is supplying power.
	2. Check if sealer is wired in properly.
	3. Test fuse FU-1.
	4. Check operation and circuit continuity through circuit breaker.
	5. Check sealer's power wiring.
b. Sealing head will not come down and relays do not click when "HEAD DOWN" button is depressed.	1. Check that safety switches on seal bar are functioning. (Paragraph 9).
	2. Check for defective CR-2 relay.
	3. Check for defective T2 transformer.

10. TROUBLESHOOTING CHART

PROBLEM	REMEDY
c. Sealing head will not come down although relays click when "HEAD DOWN" button is depressed.	1. Check for free movement of safety bars.
	2. Check and inspect wiring and connections to safety bar switches.
	3. Check for defective relay CR-2.
	4. Check for defective transformer T2.
	5. Manually operate each safety switch. A click should be heard.
	6. Check for open circuit in "HEAD DOWN" button. Check circuit continuity with button depressed.
	7. Check for defective solenoid valve SOL-1. A hum should be heard when "HEAD DOWN" button is depressed.
d. Sealing head comes down but immediately returns to up of this position.	1. Check safety circuit adjustment as shown in paragraph 8 of this manual.
	2. Check if safety override switch LS-1 is defective.
	3. If relay CR-2 will not remain energized, check for low line voltage.
e. Sealing head comes down but will not rise.	1. Check for defective solenoid valve SOL-1.
	2. Check to see that "HEAD DOWN" switch is open.
	3. Check that seal bars are not binding.
f. Weak Sales	1. Check cross seal bar temperature.
	2. Check pressure pads.

11. PARTS LISTS AND DRAWINGS

<u>ASSEMBLY</u>	<u>DRAWING NO.</u>	<u>PARTS LIST NO.</u>
FINAL ASSEMBLY MODEL 1205D	1205B-0001	1205D0001
DANCER ASSEMBLY	1205-0012	12050012
FILM DRIVE ASSEMBLY	12050070	12050070
OUTFEED CONVEYOR ASSY	12050040	12050040
ROLLER ASSY OUTFEED		12051097
PRESSURE BAR ASSY (BOTTOM)	12050034	12050034
INFEEED CONVEYOR ASSEMBLY	12050031	13050031
SUPPORT ASSY SEAL BAR	12050036	12050036P1
STANDOFF ASSY	12970713	12970713
SLIDE SUB ASSEMBLY	3060001	3060002
UPPER PTC SEAL BAR ASSY	3060010	3060010
HEATED BAR ASSY	3060101	3060101
PRESSURE PAD ASSY	3060020	3060020
MAIN PNEUMATIC ASSY	3060085	3060085
SLIDE SUB ASSEMBLY	1209A0027	1209A0027P1
ROLLER ASSEMBLY	12050017	12050017
SLIDE SUB ASSEMBLY		1209A0027P2
LABEL AND COMPONENT ASSY	12051116	12050810
PANEL LAYOUT		12058012
PANEL LAYOUT		12058005
AIR HOSE	12050015	12050015P1
AIR HOSE		12050015P2
ELECTRICAL ASSEMBLY	12050803	12060803
LEVELING PAD ASSEMBLY	72210305	72210305

PART NO: 1205D0001
 DESCRIPTION: FINAL ASSEMBLY MODEL 1205D

REV:04 05/15/91
 ACT: ROUTE: 1

ITEM	P/N	DESCRIPTION	QTY	U/M	RV	ACT	MD
1	12050010P1	MAIN FRAME WELDMENT	1.0	EA			
4	12050012	DANCER ASSY	1.0	EA			AS
11	12050070	FILM DRIVE ASSEMBLY	1.0	EA			AS
12	12051017	BAR SEAL HEAD	1.0	EA			
13	12050040	OUTFEED CONVEYOR ASSY	1.0	EA			AS
15	12050034	PRESSURE BAR ASSY BOTTOM	1.0	EA			AS
16	12050031	INFEED CONVEYOR ASSEMBLY	1.0	EA			AS
17	12051016	CORE	4.0	EA	01		
18	12050036P1	SUPPORT ASSY SEAL BAR	1.0	EA			AS
20	3060002	SEALING BAR ASSEMBLY	1.0	EA			AS
23	1209A0027P1	SLIDE SUB-ASSY	1.0	EA			AS
24	12050017	ROLLER ASSY	1.0	EA			AS
25	1209A0027P2	SLIDE SUB-ASSY	1.0	EA			AS
26	12051030P1	CYLINDER SUPPORT	1.0	EA			
27	12051030P2	CYLINDER SUPPORT	1.0	EA			
31	12051114	ENCLOSURE MTG PLATE	2.0	EA			
32	12051034	FILM ROLL SHAFT	2.0	EA			
33	12051022	ROLLER	5.0	EA			
34	12051120	ROLLER	1.0	EA			
38	2770326	DANCER ARM WGHT	2.0	EA			
39	58000415	BLACK BEARING	2.0	EA			
41	12051006	FILM DRIVE SHAFT	1.0	EA	05		
44	12051042	ROLLER SHAFT	5.0	EA			
45	12051041	DANCER PIVOT	2.0	EA			
46	12051019	CYLINDER CLIP	1.0	EA			
47	SS0622	AAC,0.375-16X1.000LG SCR HD SOC CAP CP	4.0	EA			
48	SS5056	ABA,0.375-16X0.625 LG SCREW HEX HD MACH	4.0	EA			

PART NO: 1205D0001

DESCRIPTION: FINAL ASSEMBLY MODEL 1205D

REV:04 05/15/91
ACT: ROUTE: 1

ITEM	P/N	DESCRIPTION	QTY	U/M	RV	ACT	MD
49	12051037	SPACER	12.0	EA			
50	12050810	LABEL AND COMPONENT ASSY	1.0	EA			AS
51	12051051	DANCER ARM STOP	1.0	EA			
55	12051047	SWITCH ACTUATOR	1.0	EA			
58	12051054	WEIGHT	2.0	EA			
59	12051055	BELT HOLD UPPER	1.0	EA			
60	12051056P1	BELT	1.0	EA			
61	12051056P2	BELT	1.0	EA			
63	12051061	SLIDE BRACE	2.0	EA			
64	12051062	SEAL BAR BRACE	2.0	EA			
67	12051010	SHAFT	1.0	EA			
68	12051011	BOTTOM PRESS BAR SPT	2.0	EA			
73	12051073	BRAKE BAND	5.0	EA			
76	12050015P1	AIR HOSE	1.0	EA			AS
77	12050015P2	AIR HOSE ASSEMBLY	1.0	EA			AS
78	12050803	ELECTRICAL ASSEMBLY	1.0	EA			AS
84	52001076	BRACKET-FIL-REG & LUB	1.0	EA			
85	FG0583	ADA,0.250NPT STREET EL BRAS S	4.0	EA	01		
86	FG0585	CDJ,0.250 X 0.250 FTG HOSE	1.0	EA			
87	FG0762	ADE,N.C.,0.250 BRASS	3.0	EA			
88	FG0583	ADA,0.250NPT STREET EL BRAS S	1.0	EA	01		
89	FG1237	ADE,0.250NPT NIPPLE BRASS	2.0	EA			
96	RG1950	ABA,0.375 SHAFT RING	10.0	EA			
97	RG1320	ACA,0.500 SH DIA GRIP RING EXT SST	2.0	EA			
98	NT0716	AAB,0.500-13 NUT HEX JAM CP	4.0	EA			
100	NT3967	ABB,0.375-24 NUT HEX JAM HD	12.0	EA			
101	SS1039	AAK,0.375X1.000 LG SCREW SHLDR CAD PL	4.0	EA			

PART NO: 1205D0001
 DESCRIPTION: FINAL ASSEMBLY MODEL 1205D

REV:04 05/15/91
 ACT: ROUTE: 1

ITEM	P/N	DESCRIPTION	QTY	U/M	RV	ACT	MD
102	SS3968	ABF,0.500-13X1.000 LG SCREW BTN HD HEX *	2.0	EA			
103	SS1155	ABN,0.250-20X1.000 LG SCREW THUMB	4.0	EA			
110	SS1029	AAI,8-32X0.250LG SCR SOC HD FLAT PT CP	1.0	EA			
112	72210305	LEVELING PAD ASSY	4.0	EA			AS
113	SW3392	UNIT SWITCH	1.0	EA			
114	BG1306	ABD,0.375 IDX0.906 FLANGED	10.0	EA			
117	BG0721	ABH,0.500IDX1.125OD DB SEAL DB SHIELD	2.0	EA			
118	BG3975	AEG,DELFIN 0.500 X 0.902 OD PLAST	2.0	EA			
119	SG3976	EXTENSION	2.0	EA			
126	SG3520	SPRING	2.0	EA			
130	SW1837	SWITCH	2.0	EA			
131	SW1830	SWITCH CLASS 9007	2.0	EA			
132	SW1839	CONTROL ARM	2.0	EA			
133	SW3567	SWITCH CONTROL	3.0	EA			
140	AC3957	CYL CABLE	1.0	EA			
144	BG7421	ABH,0.750 ODX0.375 SHFT BRG CAM ROLL	12.0	EA			
145	VA0574A	VALVE,4 WAY,120V	1.0	EA			
146	CO0577	REGULATOR 1/4" W/MNTG BKT	1.0	EA			
147	VA2149	EXHAUST RESTRICTOR	2.0	EA			
148	LB1817	SPEC.& PATENT NAMEPLATE	1.0	EA	07		
149	12051100	SKID	1.0	EA			
152	SS1296	AAH,10-32X0.500 LG SCR FLAT HD MACH CP	12.0	EA			
153	SS0390	AAF,0.250-20X0.750 LG	16.0	EA			
155	SS0024	AAF,0.250-20X0.500LG SCREW BTN HD SOC CP	12.0	EA			
156	SS2426	AAF,0.312-18X0.750LG SCR HD BTN SOC CAD	12.0	EA			
157	SS0341	AAF,10-32X0.750 LG SCR BTN HD CAD PL	20.0	EA			
158	SS3987	ABF,10-32X0.500LG SCREW BTN HD SOC	50.0	EA			

PART NO: 1205D0001
 DESCRIPTION: FINAL ASSEMBLY MODEL 1205D

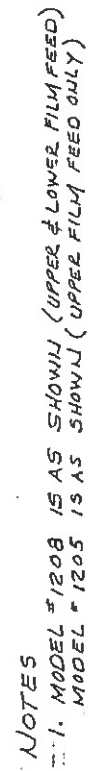
REV:04 05/15/91
 ACT: ROUTE: 1

ITEM	P/N	DESCRIPTION	QTY	U/M	RV	ACT	MD
159	SS1028	AAG,10-32X1.000 LG SCR BIND HD MACH CP	4.0	EA			
160	SS1282	ABB,6-32X0.500 LG SCREW RD HD MACH	2.0	EA			
161	WA1739	ACB,0.250 LOCK WASHER SST	32.0	EA			
162	WA2232	AAB,0.312 WASHER LOCK CP	4.0	EA			
164	WA0361	AAA,0.250 WASHER FLAT SAE PLAIN CP	4.0	EA			
166	SS1366	AAA,0.375-16X0.750LG SCR HD HEX CAP CAD	4.0	EA			
167	WA0981	AAB,0.375 WASHER LOCK CP	12.0	EA			
168	WA1423	ACB,10 WASHER LOCK SPLIT ST STL	28.0	EA			
169	SS0270	AAA,0.312-18X1.500LG SCR HD HEX MACH CP	1.0	EA			
170	NT0287	AAA,10-32 NUT HEX CAD PL	12.0	EA			
171	NT0627	AAA,0.250-20 NUT HEX CAD	14.0	EA			
172	NT0199	AAA,0.312-18 NUT HEX CAD PL	4.0	EA			
173	NT0243	AAA,10-24 NUT HEX CAD PL	2.0	EA			
175	NT0709	AAB,0.375-16 NUT HEX JAM CP	8.0	EA			
176	WA0351	ABA,10 WASHER	20.0	EA			
177	PN0060	ABA,0.125 DIA X1.500 LG PIN ROLL	1.0	EA			
179	RV15217	RIVET POP DOME HD	4.0	EA			
180	12050302	START-UP KIT	1.0	EA			AS
181	LB20405	LABEL,CAUTION SAFETY FIRST	1.0	EA	01		
182	TD12341000P2	LABEL,CAUTION	1.0	EA			
183	TD12341000P3	LABEL,CAUTION DISCONNECT	1.0	EA			
9000	DWG1205B0001	DWG,MAIN ASSEMBLY	1.0	EA	02		R
9001	1205DOPT/ACCESS	OPTIONS & ACCESSORIES 1205D	1.0	EA			P

PART NO: 12050012
DESCRIPTION: DANCER ASSY

REV: 08/23/80
ACT: ROUTE: 1

ITEM	P/N	DESCRIPTION	QTY	U/M	REV	ACT
1	12051012	BLOCK DANCER	2.0	EA		
3	12051014	GUIDE ROD	1.0	EA		
5	PN0311	AAA 0.125 DIA X 1.000 LGPIN ROLL CP	2.0	EA		
9000	DWG12050012	DWG,DANCER ASSEMBLY	1.0	EA		



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PART NO: 12050070
DESCRIPTION: FILM DRIVE ASSEMBLY

REV: 08/26/85
ACT: ROUTE: 1

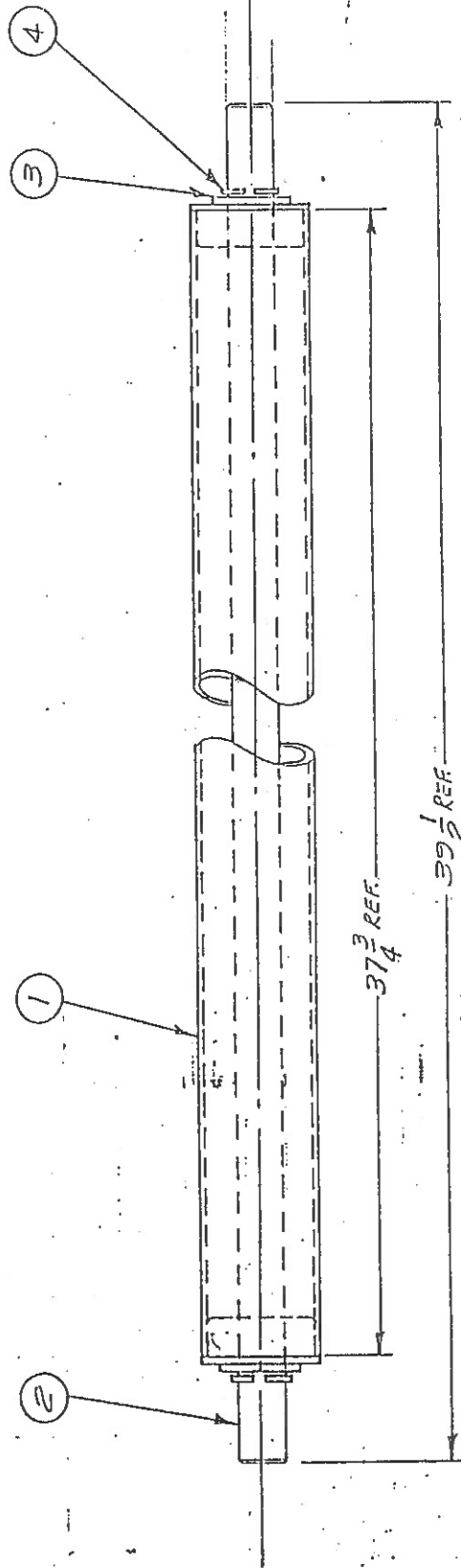
ITEM	P/N	DESCRIPTION	QTY	U/M	REV	ACT
1	MR0071	1/8HP 115 VDC 1725RP	1.0	EA		
3	HA6887	KEYSTOCK 3/16 SQUAREX12	1.0	FT		
6	12071052	MOTOR MOUNT	1.0	EA		
7	12051117	COUPLING - MODIFIED	1.0	EA		
8	CN2487	COUPLING, UNIV, LOVEJOY #LU-0 50 1/2X5/8 B*	1.0	EA		
9	SS0067	AAA 0.250-20X0.750 LG SCR EW HEX HD CA*	4.0	EA		
10	SS0292	AAA 0.250-20X1.250 LG SCREW HEX HD CA*	4.0	EA		
11	WA0361	AAA, 0.250 WASHER FLAT SAE P LAIN CP	12.0	EA		
12	WA0352	AAB 10 WAS HER LOCK INT*	8.0	EA		
13	NT0627	AAA, 0.250-20 NUT HEX CAD	8.0	EA		
9000	DWG12050070	DWG, FILM DRIVE ASSEMBLY	1.0	EA		

PART NO: 12050040

DESCRIPTION: OUTFEED CONVEYOR ASSY

REV: 08/23/80
ACT: ROUTE: 1

ITEM	P/N	DESCRIPTION	QTY	U/M	REV	ACT
1	12051027	OUTFEED CONV BRACKET	1.0	EA		
2	12051095	BRACKETT-OUTFEED CONVEY. L.	1.0	EA		
3	12051035	SPRING CLIP H.	1.0	EA		
4	12051096	RETAINER	1.0	EA		
6	12051097	ROLLER ASSY OUTFEED	8.0	EA		
10	NT0243	AAA,10-24 NUT HEX CAD PL	2.0	EA		
11	SS2287	ABR 0.187X-.000 LG SCR	2.0	EA		
12	SS3987	ABF 10-32X0.500 LG SCR	7.0	EA		
13	WA1423	ACB,10 WASHER LOCK SPLIT ST	7.0	EA		
9000	DWG12050040	DWG,OUTFEED CONVEYOR ASSEMB LY	1.0	EA		



1	37 3/4 DIA. W/ 35"	ECO 225	9/8/72
X	NEW RELEASE	ECO 1215	8/22/72
SYM	DESCRIPTION	ECO NO.	DATE/BY

REVISIONS			
DATE	DATE	DATE	DATE
DRN. P.P.	2/2/72		
CHK.			
APP.			
MATL.			
FINISH			
TOL. UNLESS SPECIFIED			
FRA. 1/16"	DEC. 1/2"	ANG. 1/2"	

Weldotron Corporation			
TITLE	ROLLER SUB-ASSY	SCALE	SIZE
	(OUTFEED CONVEYOR)		
PART NO.	1205	PART NO.	1205
REV.	1	REV.	1

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PART NO: 12051097

DESCRIPTION: ROLLER ASSY OUTFEED

REV: 08/23/80
ACT: ROUTE: 1

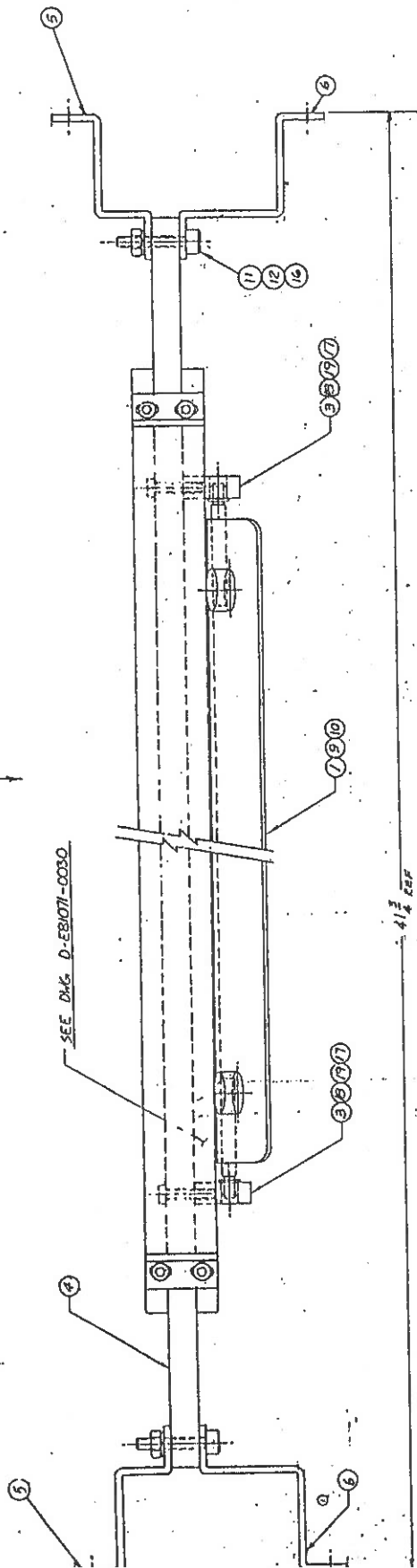
ITEM	P/N	DESCRIPTION	QTY	U/M	REV	ACT
300	BG1306	ABD 0.375 ID X 0.906 FLANGE D KILLIAN #F*	2.0	EA		
305	RG1950	ABA 0.375 SHAFT WALDES #555 5-37PP RING	2.0	EA		
310	12051021	ROLLER SHAFT	1.0	EA		
315	12051022	ROLLER	1.0	EA		
9000	DWG12051097	DWG, ROLLER ASSY OUTFEED CON VEYOR	1.0	EA		

2

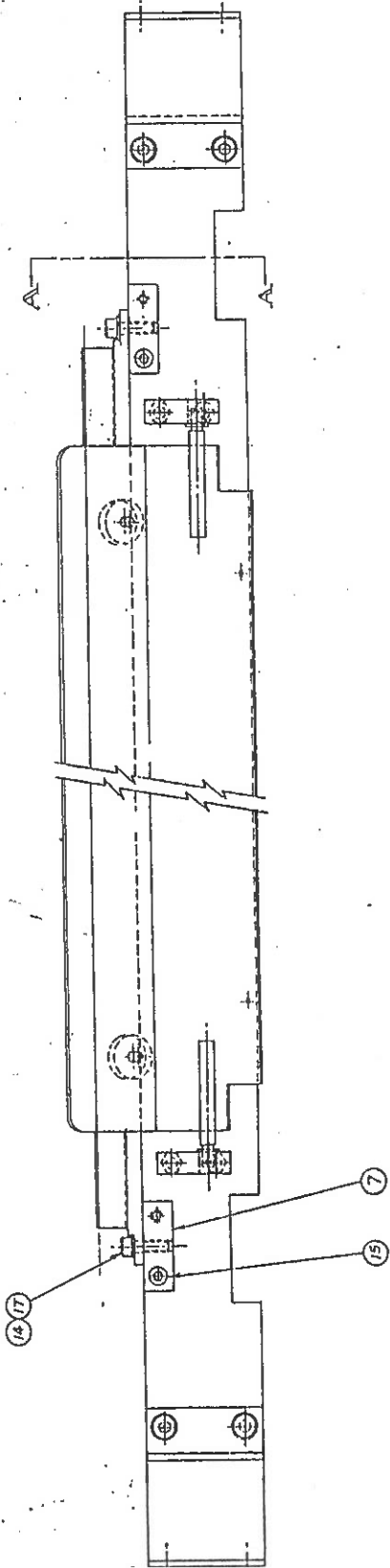
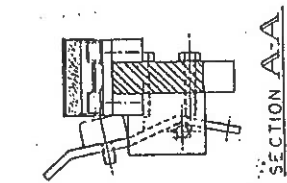
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INFEED

SEE Dwg. D-EB1071-0030.



41 1/2 REF



D/1205-0034

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PART NO: 12050034

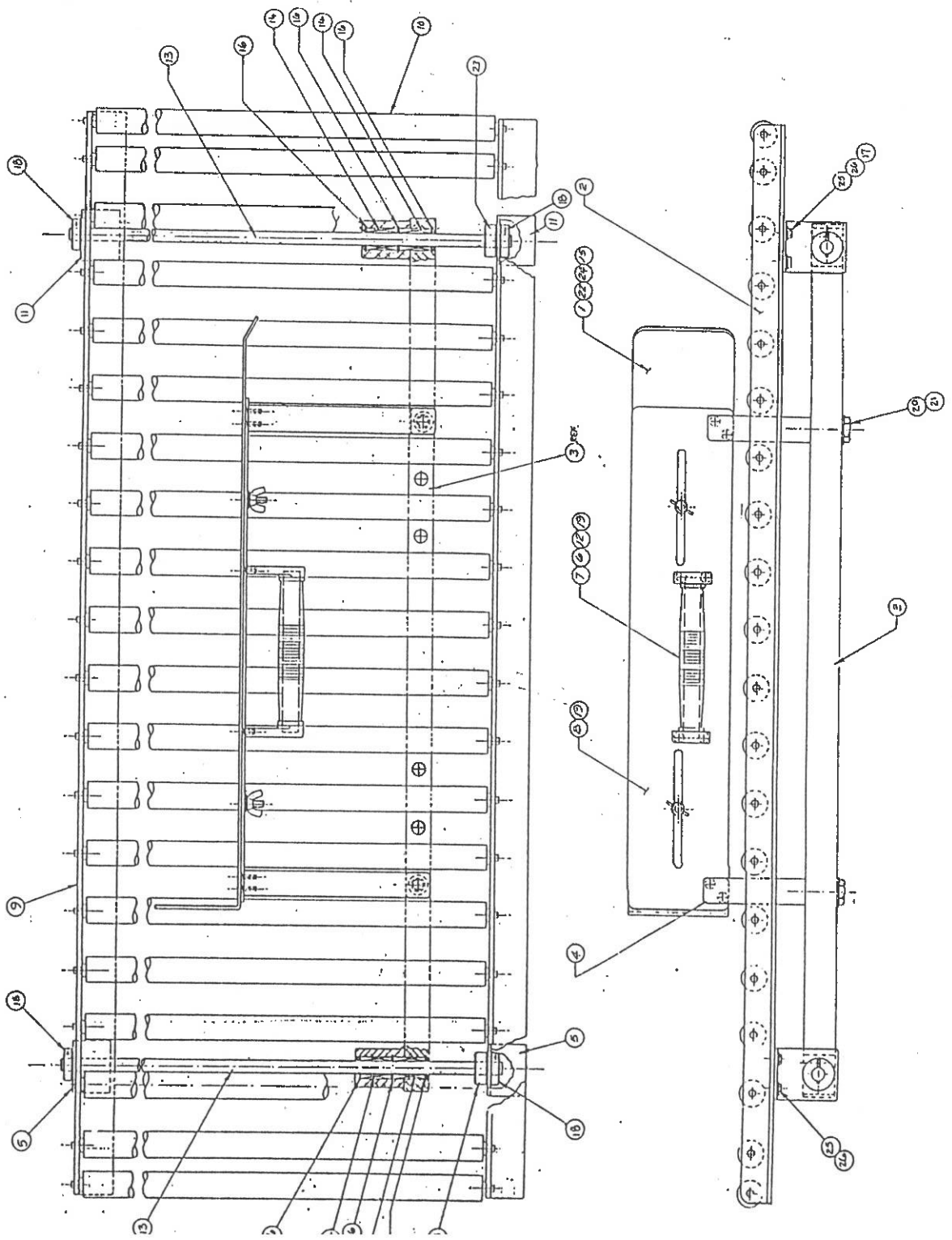
REV: 09/26/84

DESCRIPTION: PRESSURE BAR ASSEMBLY (BOTTOM)

ACT: ROUTE: 1

ITEM	P/N	DESCRIPTION	QTY	U/M	REV	ACT
1	12050014	PRODUCT STOP	1.0	EA		
3	12051048	PIVOT (PROD.STOP)	2.0	EA		
4	12051110	BOTTOM PRESS BAR SUPPORT	1.0	EA		
5	12051106	BRACKET PRESS BAR SUPPOR	2.0	EA		
6	12051107	BRACKET, PRESS BAR SUPPOR	2.0	EA		
7	12051099	BRACKET	4.0	EA		
11	SS0018	AAC 0.250-20X1.250 LG SCR EW SOC HD CA*	4.0	EA		
12	NT0627	AAA,0.250-20 NUT HEX CAD	4.0	EA		
14	SS0982	AAC 10-32X0.625 LG SCR EW SOC HD CA*	4.0	EA		
15	SS0343	AAC 10-32X1.000 LG SCR EW SOC HD CA*	4.0	EA		
16	WA1739	ACB,0.250 LOCK WASHER STAIN LESS STEEL	4.0	EA		
17	WA1423	ACB,10 WASHER LOCK SPLIT ST STL	4.0	EA		
18	BG3980	ADG 0.187X0.312 OD BRNZ BOS TON #FB35-2	2.0	EA		
19	SS0960	AAA,10-32X0.750 LG	4.0	EA		
9000	DWG12050034	DWG,PRESSURE BAR ASSEMBLY (BOTTOM)	1.0	EA		

PARTS LIST
NOMENCLATURE



DATE	11/1/50	REVISED	11/1/50
BY	J. J. KELLY	DESCRIPTION	INVERTED CONVEYOR ASSEMBLY
CHKD		REVISED	
APP		DATE	
DESIGNED BY		CHECKED BY	
DRAWN BY		DATE	
PART NO		12050 0001	
MODEL		NO REVISIONS	
PART NO		12050 0001	
MODEL		NO REVISIONS	
PART NO		12050 0001	
MODEL		NO REVISIONS	
PART NO		12050 0001	
MODEL		NO REVISIONS	

PART NO: 12050031
DESCRIPTION: INFEED CONVEYOR ASSEMBLY

REV: 01/16/90
ACT: ROUTE: 1

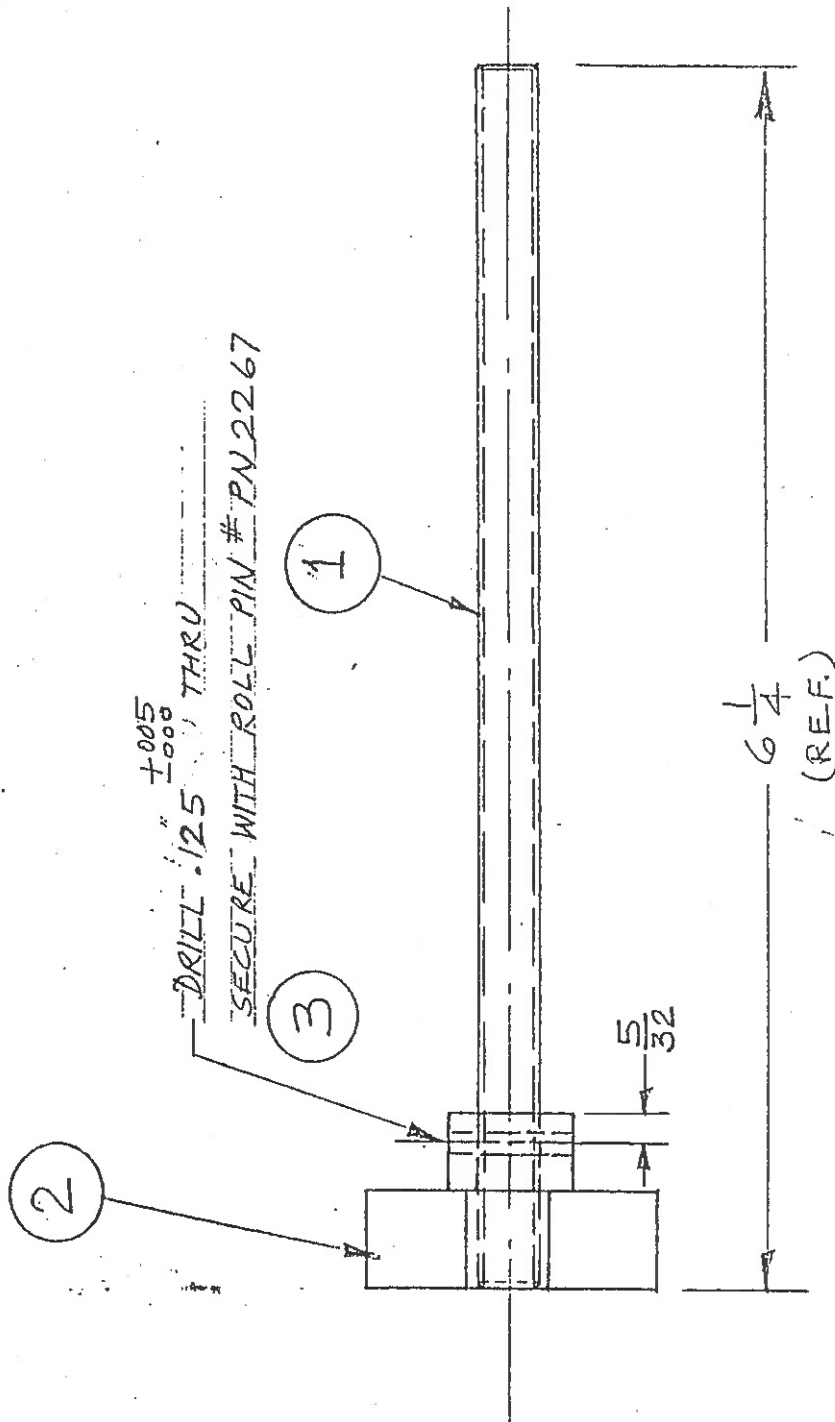
ITEM	P/N	DESCRIPTION	QTY	U/M	REV	ACT
1	12051018	PUSHER	1.0	EA		
2	12051025	INFEED CONV BRACK	1.0	EA	4	
3	12050301	SLIDING BAR WELDMENT	1.0	EA		
4	12051043	PUSHER ARM	2.0	EA		
5	12053001	MOUNTING BRACKET FIXED	2.0	EA		
6	12051059	HANDLE CORE	1.0	EA		
7	12051063	HANDLE HOLDER	2.0	EA		
8	12051071	PUSHER PLATE	1.0	EA		
9	12051031	BRACKET	1.0	EA	4	
10	RO4420	RLR ASSY 23-1/2 LG PER DWG A-RO4420	20.0	EA		
11	12053002	MOUNTING BRACKET ADJ	2.0	EA		
12	HL3986	FLEX GRIP HNDL AIRCO FIB10- 5.7	1.0	EA		
13	ST20119	SHAFT, 1060STL. CASE HARD. 6 0/65RC	2.0	EA		
14	BB7745	BALL/BU#L-8-MM 1/2BORE SEAL ED BARDEN	4.0	EA		
15	NT1435	AAF, 0.250-20 NUT WING CP	2.0	EA		
16	RG2352	ABB 0.875DIA TRUARC #N5000- 87	6.0	EA		
17	WA0351	ABA 10	8.0	EA		
18	CL18976	AAB, 0.500 ID STAFFORD #8L S PLIT	4.0	EA		
19	SS1581	AAH 8-32X0.500 LG SCR	8.0	EA		
20	SS4340	ABA 0.500-13X1.750 LG SCR EW FLAT HD M*	2.0	EA		
21	WA1919	AAB 0.500 WAS HER SPLIT LO*	2.0	EA		
22	WA0361	AAA, 0.250 WASHER FLAT SAE P LAIN CP	2.0	EA		
23	WA2706	AGA 0.500X1.250X0.500 WAS HER SOLID UR*	2.0	EA		
24	WA1739	ACB, 0.250 LOCK WASHER STAIN LESS STEEL	2.0	EA		
25	SS0121	AAA 10-32X0.500 LG SCREW HE X HD MA*	16.0	EA		
26	WA5418	AAB 10 WAS HER LOCK SPL*	16.0	EA		
9000	DWG12050031	DWG, INFEED CONVEYOR ASSEMBL Y	1.0	EA		

PART NO: 12050036P1
DESCRIPTION: SUPPORT ASSY SEAL BAR

REV: 08/23/80
ACT: ROUTE: 1

ITEM	P/N	DESCRIPTION	QTY	U/M	REV	ACT
1	12051039	TOP SEAL BAR SUPPORT	1.0	EA		
2	12970713	STANDOFF ASSY	2.0	EA		
5	12051057P2	CONNECTION BOX	1.0	EA		
6	12051058	CONNECTION BOX	2.0	EA		
8	12051057P1	CONNECTING BOX	1.0	EA		
13	12051118	RACEWAY-WIRE	1.0	EA		
15	BU0153	AGG, 0.500 OD HEYCO SNAP LOC K NO. SB-500*	2.0	EA		
16	BU0175	AGG, 0.687 OD HEYCO SNAP LOC K NO. SB-687*	2.0	EA		
21	SS1372	AAQ 8-32X0.500 LG SCR EW SHT MET P*	4.0	EA		
22	SS2419	ABG 10-32X0.375 LG SCR EW BIND HD S*	4.0	EA		
26	WA1425	ACA 0.312 WAS HER FLAT ST *	2.0	EA		
9000	DWG12050036	DWG, SUPPORT ASSY SEAL BAR	1.0	EA		

A-1297-0713



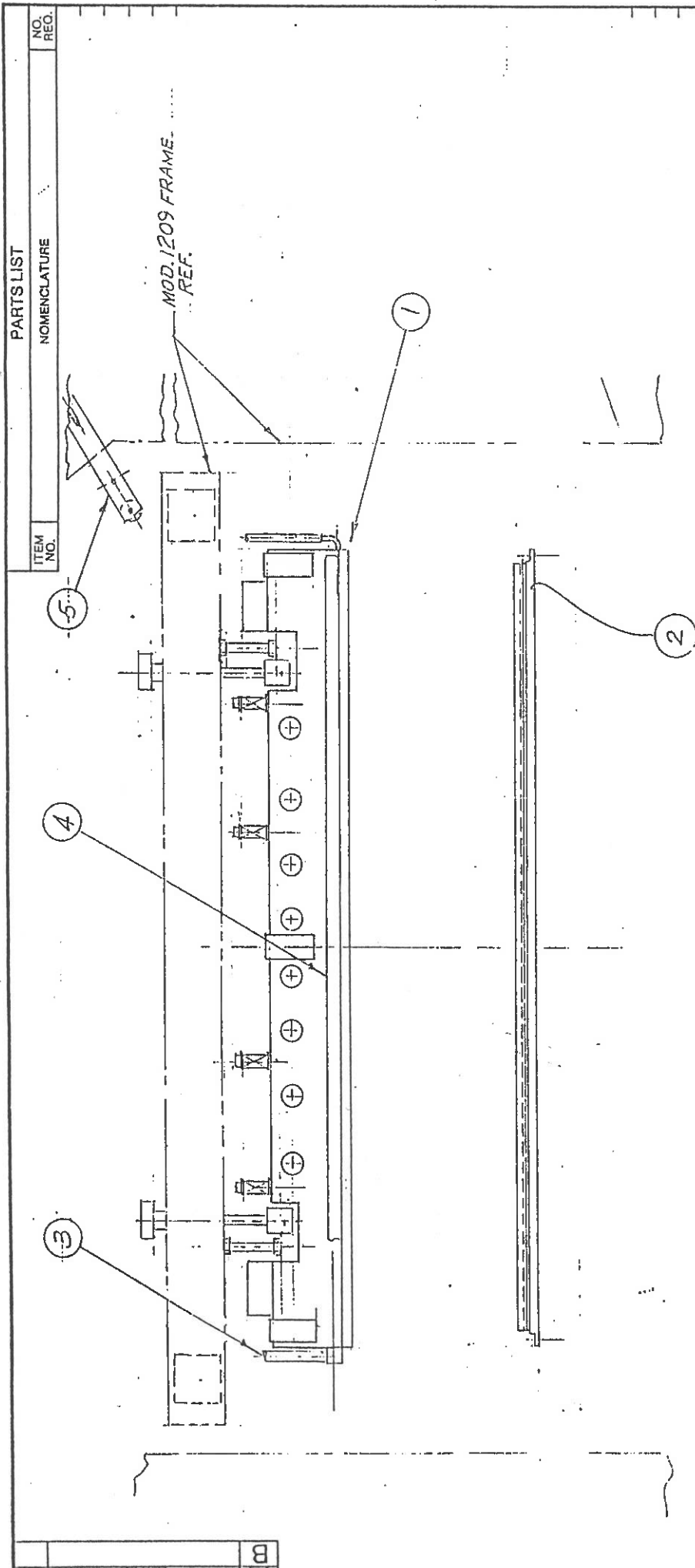
REV.	ECO	BY
TITLE STAND OFF		
SIZE A	PART NO. 1297-0713	REV.
DRN. PCT	CHECK BY APP.	SCALE 1:1
NO. REQ'D PER MACH.	2	
MODEL NO. 1297	NEXT ASSY E1297-0070	
FINISH NONE		
MATERIAL SEE P/L		

weldotron
CORPORATION

PART NO: 12970713
DESCRIPTION: STANDOFF ASSY

REV: 08/23/80
ACT: ROUTE: 1

ITEM	P/N	DESCRIPTION	QTY	U/M	REV	ACT
1	12977084	THREADED ROD	1.0	EA		
2	KB5434	KNOB ALUMINUM REIDS STT-5T	1.0	EA		
3	PN2267	ABA	1.0	EA		
		PIN				
		RL ESNA 70-*				
9000	DWG12970713	DWG,STANDOFF ASSEMBLY	1.0	EA		



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PART NO: 3060002
DESCRIPTION: SEALING BAR ASSEMBLY

REV: 12/30/85
ACT: ROUTE: 1

ITEM	P/N	DESCRIPTION	QTY	U/M	REV	ACT
1	3060010	UPPER PTC SEAL BAR ASSEMBLY	1.0	EA		
2	3060020	PRESSURE PAD ASSEMBLY	1.0	EA		
4	3060085	MAIN PNEUMATIC ASSEMBLY	1.0	EA		
9000	DWG3060001	DWG, SEALING BAR ASSEMBLY	1.0	EA		

PART NO: 3060010

DESCRIPTION: UPPER PTC SEAL BAR ASSEMBLY

REV: 12/30/85
ACT: ROUTE: 1

ITEM	P/N	DESCRIPTION	QTY	U/M	REV	ACT
29	WA1073	AGF	8.0	EA		
30	WA1421	ACB 6	4.0	EA		
31	3061015	STUD, ADJUSTMENT	2.0	EA		
32	3061016	KNOB, MODIFIED	2.0	EA		
33	WA0260	AAA 0.375	4.0	EA		
34	NT0979	AAA,0.375-16 NUT HEX CAD PL	2.0	EA		
9000	DWG3060010	DWG,UPPER PTC SEAL BAR ASSE MBLY	1.0	EA		

PART NO: 3060010
 DESCRIPTION: UPPER PTC SEAL BAR ASSEMBLY

REV: 12/30/85
 ACT: ROUTE: 1

ITEM	P/N	DESCRIPTION	QTY	U/M	REV	ACT
1	3060101	HEATED BAR ASSEMBLY	1.0	EA		
2	3060102	FILM CLAMP WELDMENT	1.0	EA		
3	3061002	CLEVIS, FIXED	1.0	EA		
4	3060108	AIR DISTRIBUTION TUBE WELDM ENT	2.0	EA		
6	3061004	TOP CLAMP SPACER	4.0	EA		
7	3061005	SIDE CLAMP SPACER	8.0	EA		
8	3061006	THERMOCOUPLE CLIP	1.0	EA		
9	RG5390	BCA 0.312 SH..WALDES #5100- 31H OR EQUIV.	4.0	EA		
10	SS9174	ACB 6-32X0.250 LG SCR EW RD HD MAC*	12.0	EA		
11	WA11020	ACB,SPLIT LOCK WASHER #6 S. S.	14.0	EA		
12	SS9271	ACB 6-32X0.375 LG SCR EW RD HD ST *	2.0	EA		
13	SS7468	ACH 6-32X0.375 LG SCR EW FLT HD SO*	16.0	EA		
14	NT8074	ACG,0.250-28 NUT LOCK	4.0	EA		
15	WA1424	ACA 0.250 WAS HER FLAT ST *	8.0	EA		
16	SS7916	ACI 10-32X0.375 LG SCR EW SOC CUP P*	1.0	EA		
17	3061003	PIN FOR CLEVIS	2.0	EA		
18	SS2186	AAA 0.312-18X2.250 LG SCR EW HEX HD CA*	2.0	EA		
19	NT6159	ACA,0.312-18 NUT HEX ST STL	2.0	EA		
20	TA0467	TAPE TEFLN M-281-3 2"W X10Y DS .003TK OR*	5.5	FT		
21	HT16466	HEATER CARTRIDGE,AS PER DWG B-HT16466	1.0	EA		
22	TP16088	THERMOCOUPLE LOVE #187814 T YP J PER A-T*	1.0	EA	6	
23	3061017	CLEVIS, SLIDING	1.0	EA		
24	SG3520	SPRING LEE LC-042E-14SS	4.0	EA		
25	SW0758	SWITCH MICRO #BZ2RD	2.0	EA		
26	SW0725A	ENCLOSURE 5PA2PLASTIC MICRO SWITCH	2.0	EA		
27	SS1705	ACD 6-32X1.125 LG SCR EW PAN HD ST*	4.0	EA		
28	NT1426	ACA,6-32 NUT,316 OR 304 SST	4.0	EA		

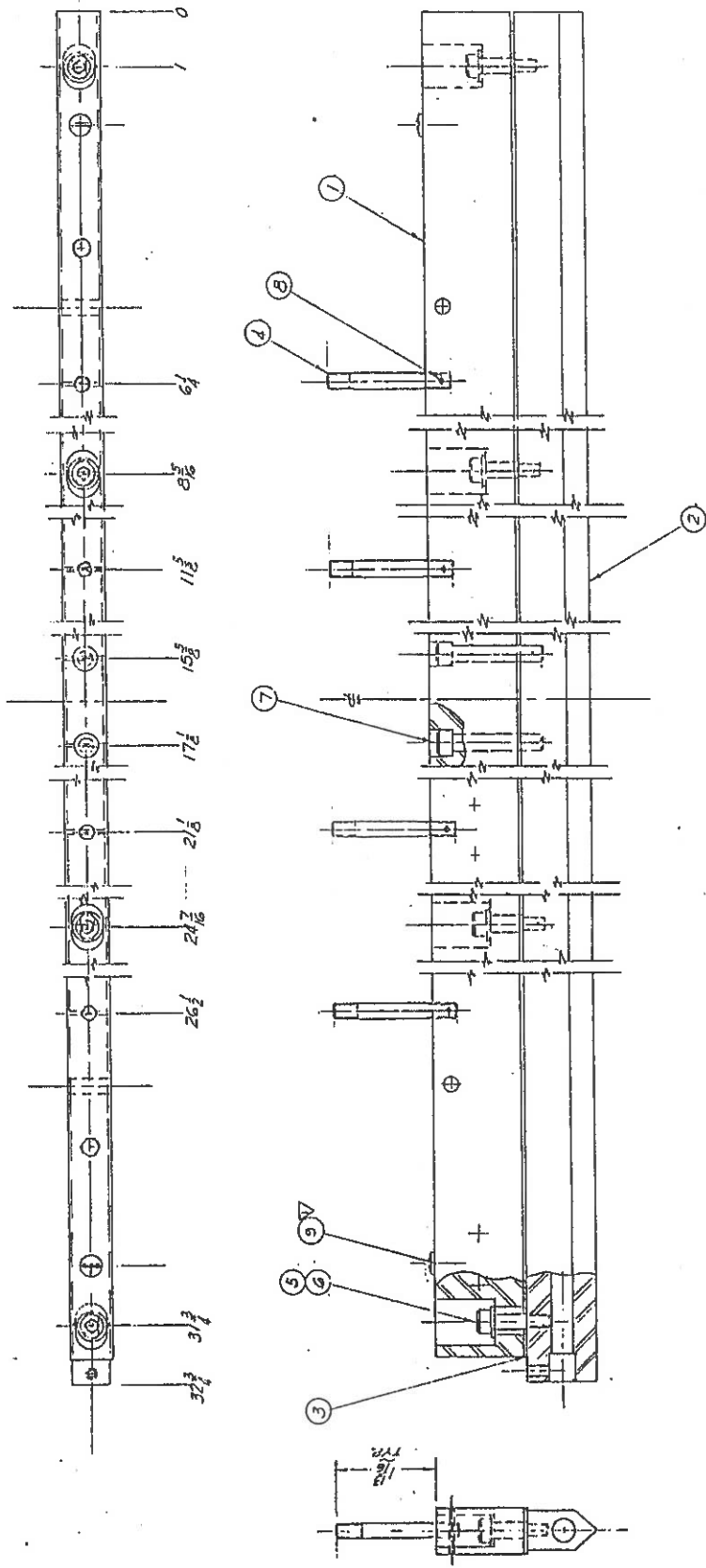
HEATED BAR ASSEMBLY

weldatron

1 ADDED ITEM 5
DESCRIPTION
ITEM 1

1/12/59 1/12/59
1/12/59 1/12/59
1/12/59 1/12/59

ITEM	DESCRIPTION
1	ADDED ITEM 5

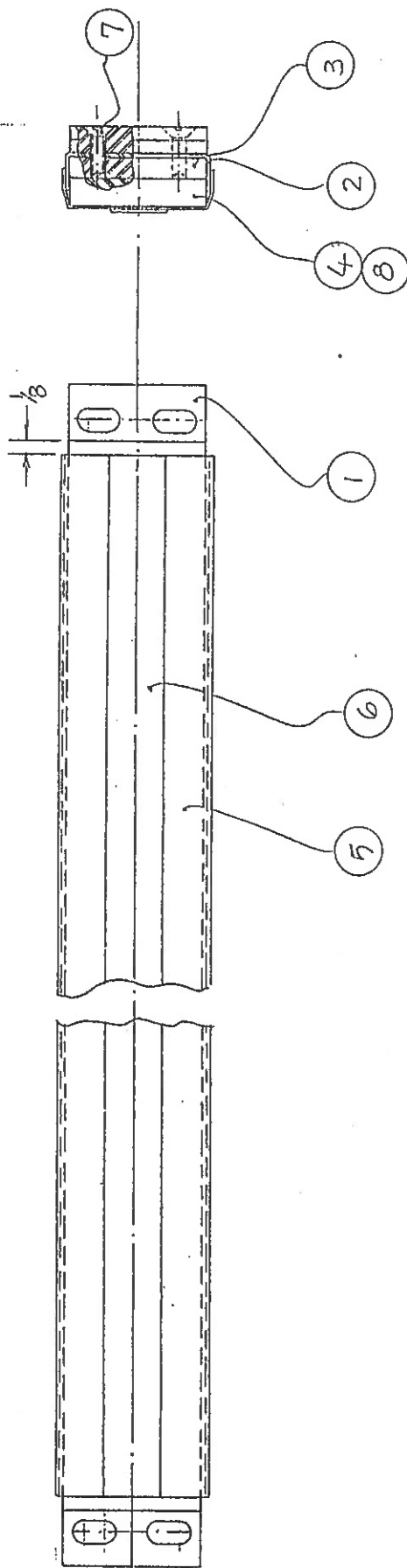


PART NO: 3060101
DESCRIPTION: HEATED BAR ASSEMBLY

REV: 12/30/85
ACT: ROUTE: 1

ITEM	P/N	DESCRIPTION	QTY	U/M	REV	ACT
1	3061011	UPPER BACK UP BAR	1.0	EA		
2	3061012	SEALING BLADE	1.0	EA		
3	3061013	INSULATING STRIP	2.0	EA		
4	3061014	STUD	4.0	EA		
5	WA6076	ACA 0.250IDX0.500ODX0.06WAS HER BOST-188*	4.0	EA		
6	SS4724	ACK 0.250X0.625 LG SCR EW SHLDR ST *	4.0	EA		
7	SS7891	ACC 0.250-20X1.500 LG SCR EW SOC HD CA*	2.0	EA		
8	PN9439	ACC 0.093 DIA X 0.750 LGPIN GROOVE SS T*	4.0	EA		
9	SS2125	ACG 10-32X0.375 LG SCR EW BIND HD S*	2.0	EA		
9000	DWG3060101	DWWG, HEATED BAR ASSEMBLY	1.0	EA		

PARTS LIST	
ITEM NO.	NOMENCLATURE
NO. REQ.	



SYM	DESCRIPTION	ECONO.	DATE/REV
REVISIONS			
ORIN.	DATE		
CHK.	DATE		
APP.	DATE		
MATL.	DATE		
FINISH	DATE		
TITLE			
Weldotron corporation			
PRESSURE PAD ASSY.			
FOR PTC SEAL BRG.			
TOL. UNLESS SPECIFIED	SCALE	SIZE	REV.
FRA. DEC. ANGLE	1/1	B	306-0020
± 1/64 ± .005 ± 1/2°			

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PART NO.	MODEL NO.	NEXT ASSEMBLY	NO. REQ'D PER MACH
506	8-506-0001	1	

PART NO: 3060020
DESCRIPTION: PRESSURE PAD ASSEMBLY

REV: 12/30/85
ACT: ROUTE: 1

ITEM	P/N	DESCRIPTION	QTY	U/M	REV	ACT
1	12977202	SUPPORT PADS	1.0	EA		
2	3062001	RETAINER - RUBBER PAD	1.0	EA		
3	3062002	SUPPORT, RUBBER PAD	1.0	EA		
4	3062003	RUBBER STRIP	1.0	EA		
5	TA0467	TAPE TEFLN M-281-3 2"W X10Y DS .003TK OR*	2.8	FT		
6	TA0366	TAPE TEFLN FIBRGLS M281-10 1/2"W X .010*	2.8	FT		
7	SS0332	AAH 8-32X0.375 LG SCR EW FLAT HD 8*	6.0	EA		
8	AH0469	ADHESIVE RTV-102-SEALANT-SI LICONE RUBBE*	1.0	EA		
9000	DWG3060020	DWG,PRESSURE PAD ASSY FOR P TC SEAL BAR	1.0	EA		

PART NO: 3060085
 DESCRIPTION: MAIN PNEUMATIC ASSEMBLY

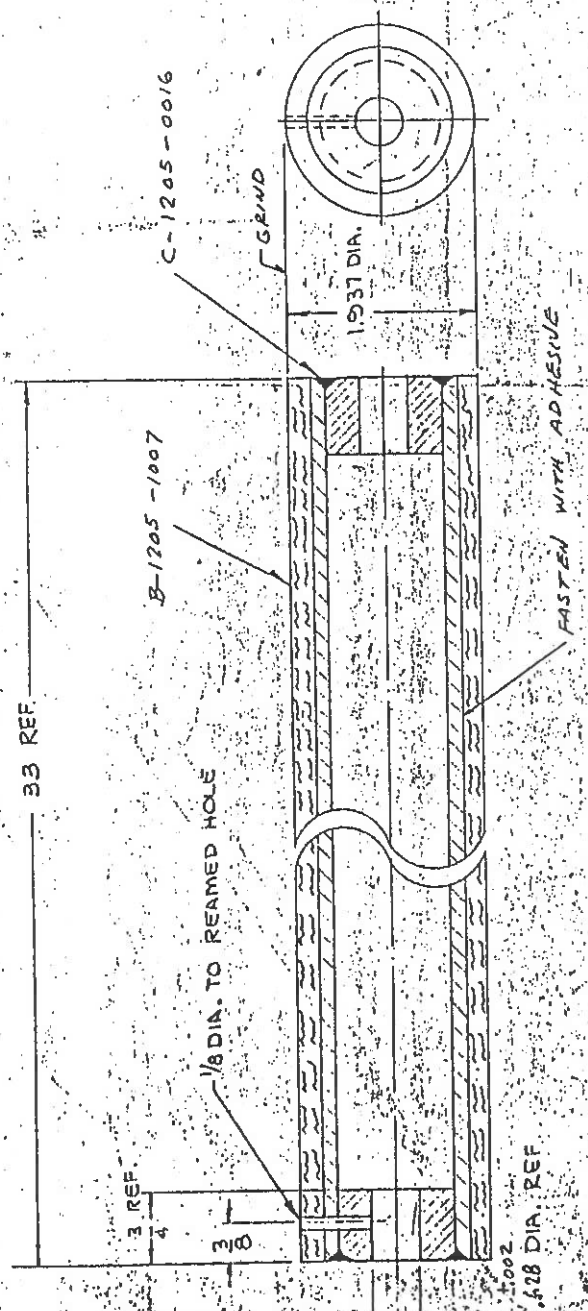
REV: 12/30/85
 ACT: ROUTE: 1

ITEM	P/N	DESCRIPTION	QTY	U/M	REV	ACT
1	3061031	HOSE ANCHOR BLOCK	1.0	EA		
2	3061032	HOSE ANCHOR BLOCK	1.0	EA		
3	52001076	BRACKET-FIL-REG & LUB	1.0	EA		
4	CO2353	REG WILKERSON R00-02-000 GR P-95-734 GRP*	1.0	EA		
5	TU9621	TUBING CLEAR 1/4 NYCOIL # 6 2440	11.0	FT		
6	FG12468	ADA 0.250NPT X 0.250TUBE KN OTTS CO 2022*	3.0	EA		
7	FG12470	ADD 0.250NPT X 0.250TUBE KN OTTS CO#2021*	2.0	EA		
8	FG2210	ADB 0.250 X 0.250 TEE BRA SS IMP EASTM*	1.0	EA		
9	FG9615	ADD 0.250 X 0.125 STR CON N VFP #2001-*	5.0	EA		
17	SS7293	ACA,10-32X0.500 LG SCREW HE X HD ST STL	2.0	EA		
18	SS2364	ACC 10-32X1.250 LG SCR EW SOC HD CA*	2.0	EA		
19	WA1423	ACB,10 WASHER LOCK SPLIT ST STL	6.0	EA		
20	NT2380	ACA,10-32 NUT HEX ST STL	4.0	EA		
21	SS2753	ACA 10-32X1.500 LG SCR EW HEX HD MA*	2.0	EA		
9000	DWG3060085	DWG,MAIN PNEUMATIC ASSEMBLY	1.0	EA		

PARTS LIST

ITEM NO.	QUANTITY	DESCRIPTION	DATE	APPROVED
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NONDECLASSIFIED



NOTE:
1. 1.628 DIA. ± 1.937 DIA. TO BE CONCENTRIC WITHIN .003 T.I.R.

RELEASED FOR PRODUCTION

REV.	DESCRIPTION	DATE	APPROVED
1	ROLLER ASSEMBLY FILM DRIVE	12/16/66	W. S. S. S.
2	1208 E-1208-0004		
3	1205 E-1205-0001		
4	MODEL NO. NEXT ASSY		

W. S. S. S. CORPORATION
NEWARK, N.J.

DATE: 12/16/66
APPROVED: W. S. S. S.

ROLL: C-1205-0017

CONFIDENTIAL

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PART NO: 12050017
DESCRIPTION: ROLLER ASSY

REV: 08/23/80
ACT: ROUTE: 1

ITEM	P/N	DESCRIPTION	QTY	U/M	REV	ACT
1	12050016	ROLL WELDMT FILM DRIVE	1.0	EA		
2	12051007	FILM FEED ROLLER	1.0	EA		
9000	DWG12050017	DWG,ROLLER ASSEMBLY	1.0	EA		

PART NO: 1209A0027P1

DESCRIPTION: SLIDE SUB-ASSY

REV: 08/23/80

ACT: ROUTE: 1

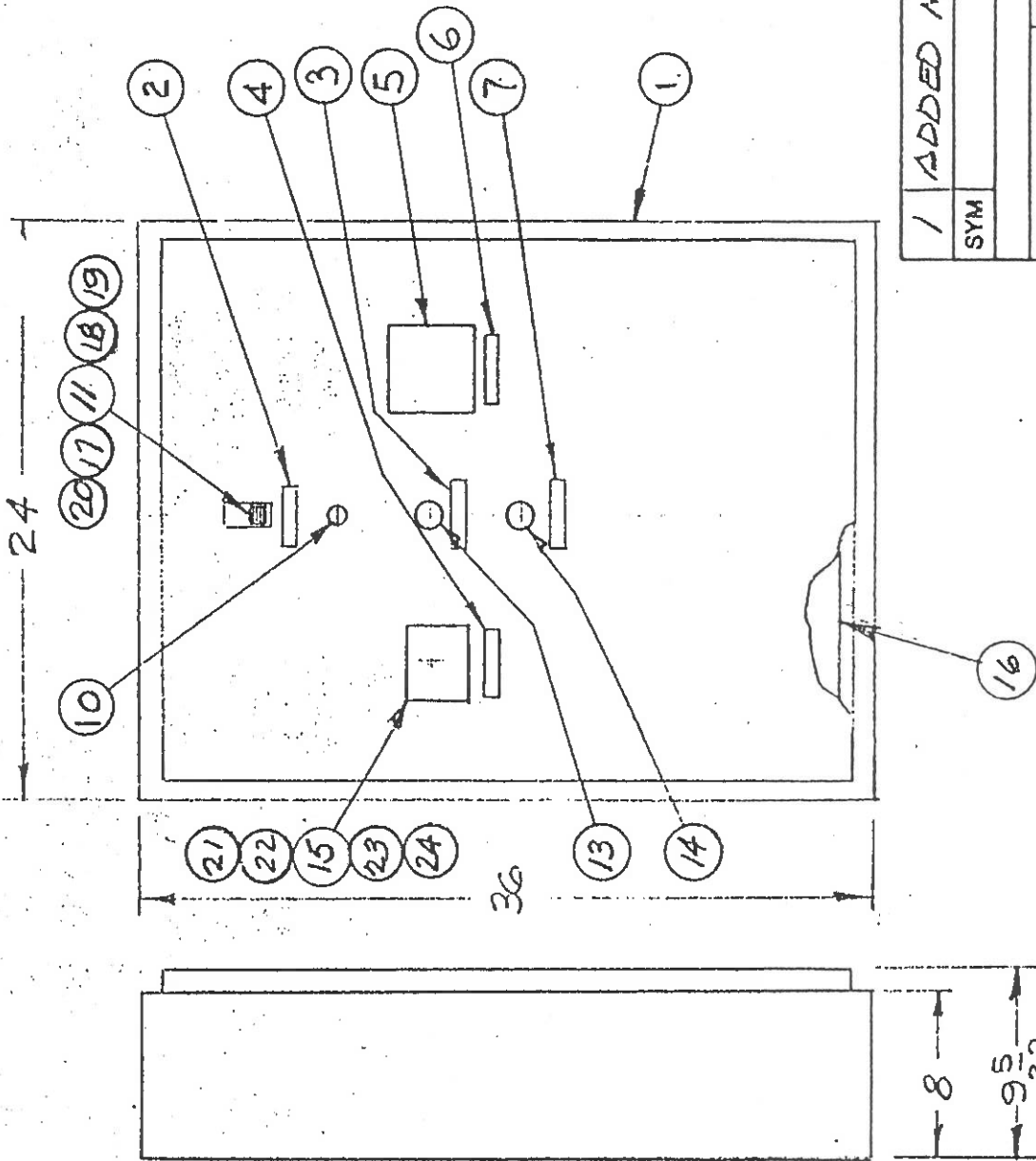
ITEM	P/N	DESCRIPTION	QTY	U/M	REV	ACT
1	12091109	WEAR PLATE	1.0	EA		
2	12091102	CARRIER-WEAR STRIP	1.0	EA		
3	12091110	BAR SLIDE	1.0	EA		
4	12091105	WEAR STRIP	1.0	EA		
6	12091108	GUIDE FRONT & REAR	2.0	EA		
9	SS1225	AAC 0.312-18X0.750 LG SCR	2.0	EA		
10	SS0340	EW SOC HD CA* AAG, 10-32X0.750 LG CAD PLAT E	6.0	EA		
11	WA1003	AAB 10 WAS	6.0	EA		
12	WA0351	ABA 10 HER LOCK SPR*	6.0	EA		
9000	DWG1209A0027	DWG, SLIDE SUB-ASSEMBLY	1.0	EA		

PART NO: 1209A0027P2
DESCRIPTION: SLIDE SUB-ASSY

REV: 08/23/80
ACT: ROUTE: 1

ITEM	P/N	DESCRIPTION	QTY	U/M	REV	ACT
1	12091109	WEAR PLATE	1.0	EA		
2	12091102	CARRIER-WEAR STRIP	1.0	EA		
3	12091110	BAR SLIDE	1.0	EA		
4	12091105	WEAR STRIP	1.0	EA		
6	12091108	GUIDE FRONT & REAR	2.0	EA		
9	SS1225	AAC 0.312-18X0.750 LG SCR	2.0	EA		
10	SS0340	EW SOC HD CA* AAG,10-32X0.750 LG CAD PLAT	6.0	EA		
11	WA1003	E AAB 10 WAS	6.0	EA		
12	WA0351	HER LOCK SPR* ABA 10	6.0	EA		
9000	DWG1209A0027	DWG,SLIDE SUB-ASSEMBLY	1.0	EA		

A 1205-1116



1		ADDED MODEL 1205C REF.		4224	11/11/85
SYM	DESCRIPTION	ECONO.		DATE	BY
REVISIONS					
DRN.	CKH	DATE	DATE		
CHK		7-84			
APP.		DATE			
MATL					
FINISH					
TOL. UNLESS SPECIFIED					
FRA	DEC.	ANGLE			
± 1/84	± .005	± 1/2°			
1205C		1205C-0001		1	
1205B		E-1205B-0001		1	
MODEL NO.		NEXT ASSEMBLY		NO REQ'D PER MACH	
PART NO.		1205-1116		REV.	
SCALE		SIZE		REV.	
A		A		1	

weldotron
corporation

LABEL & COMPONENT ASS'Y

PART NO: 12050810

DESCRIPTION: LABEL AND COMPONENT ASSY

REV: 12/30/85
ACT: ROUTE: 1

ITEM	P/N	DESCRIPTION	QTY	U/M	RV	ACT	MD
1	12058004	ENCLOSURE MODIFICATION	1.0	EA			
2	LB3958	LABEL BLK W/WHITE LET	1.0	EA			
3	LB3959	LABEL BLK W/WHITE LT STOP	1.0	EA			
4	LB3960	LABEL BLK W/WHITE LET DWELL	1.0	EA			
5	CO16114	TEMP. CONTROLLER	1.0	EA			
6	LB12324	LABEL, "UPPER CROSS SEAL"	1.0	EA			
7	LB3963	LABEL BLAK W/WHITE LET HEAD DOWN	1.0	EA			
10	LT0699	LIGHT PILOT RED	1.0	EA			
11	CU17484	CKT BR, 2 POLE	1.0	EA			
13	SW3389	PUSH BUTTON	1.0	EA			
14	SW3390	PUSH BUTTON	1.0	EA			
15	TM3916	TIMER TEMPO MODEL 651491B 1 15V .25 TO 5*	1.0	EA			
16	12058012	PANEL LAYOUT	1.0	EA			AS
17	SS2098	ACF, 8-32X0.500 LG SCREW BTN HD SOC SST	10.0	EA			
18	WA2222	AAA, 8 WASHER FLAT CP	4.0	EA			
19	WA1334	AAB, 8 WASHER LOCK SPRING CP	4.0	EA			
20	NT0356	AAA, 8-32 NUT HEX CAD PL	4.0	EA			
21	SS3913	ABF, 6-32X0.500 LG SCREW BTN HD SOC	4.0	EA			
22	WA2221	AAA, 6 WASHER FLAT CP	4.0	EA			
23	WA1333	AAB, 6 WASHER LOCK SPRING CP	4.0	EA			
24	NT0198	AAA, 6-32 NUT HEX CAD PL	4.0	EA			
9000	DWG12051116	DWG, LABEL & COMPONENT ASSY	1.0	EA			A
9001	12058025	SCHEMATIC	1.0	EA	01		C

PART NO: 12058012
DESCRIPTION: PANEL LAYOUT

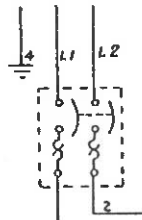
REV: 12/30/85
ACT: ROUTE: 1

ITEM	P/N	DESCRIPTION	QTY	U/M	REV	ACT
1	12058005	PANEL LAYOUT	1.0	EA		
2	TL3584	TERM BLOCK CONNECTRON #NFT-	10.0	EA		
3	TL3585	3 3 CKTS BLO* MTG CHANNEL ST STL	1.0	FT		
4	TR3405	CONTROL TRN 0.5 KVA 208/240	1.0	EA		
5	FZ3384	/480V PRIMAR* MARATHON FUSE BLK 3 POLE 30	1.0	EA		
6	FZ7083	A 250V F30A3 FUSE HOLDER FOR 13/32 BY 1-	4.0	EA		
7	FZ7144	1/2" FUSE FUSE BUSS #FNM10 250V 10A 0	2.0	EA		
8	SW12410	R EQUAL RELAY SOLID STATE GORDOSGA5	1.0	EA		
9	SW3119	-6D25 OR GB1* A-B RELAY #AB700N400A24	1.0	EA		
10	SW3117	A-B RELAY #AB700N400A1	1.0	EA		
11	FZ17486	FUSE 250V 3A BUSS #FNM3	2.0	EA		
13	TB7025	RECTIFIER EDI #PA40	1.0	EA		
14	LG1054	LUG T&B #B14 250A FLAG #B2	4.0	EA		
15	FZ1033	52G FUSE 5A BUSS TYP FUSETRON#F	1.0	EA		
16	FZ3865	RN5 OR CHASE* FUSE BUSS 1.6AMP 250V FRN 1	1.0	EA		
17	FZ2773	-6/10 OR EQU* FUSE 2AMP 250V TUBULAR FUSE	1.0	EA		
18	SS0954	TRON FRN2 OR* AAE 10-32X0.625 LG SCR	16.0	EA		
19	SS2098	EW FILLISTER* ACF 8-32X0.500 LG SCR	22.0	EA		
20	WA0351	EW BTN HD SO* ABA 10	16.0	EA		
21	WA0352	AAB 10 WAS	16.0	EA		
22	WA2222	HER LOCK INT* AAA,8 WASHER FLAT CP	22.0	EA		
23	WA1334	AAB,8 WASHER LOCK SPR*	22.0	EA		
24	SS3913	ABF 6-32X0.500 LG SCR	1.0	EA		
25	WA1333	EW BTN HD SOC AAB 6 WAS	1.0	EA		
26	TR6897	HER LOCK SPR* XFORMER 460-230V 0-20 3V-15	1.0	EA		
27	RE5990	0VA 80 C DWG* VARISTOR	1.0	EA		
28	TR6334	120V-28V X264A PERTR6334	1.0	EA		

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CURRENT RATING - 15 AMPS
LAST WIRE NO. USED - 218

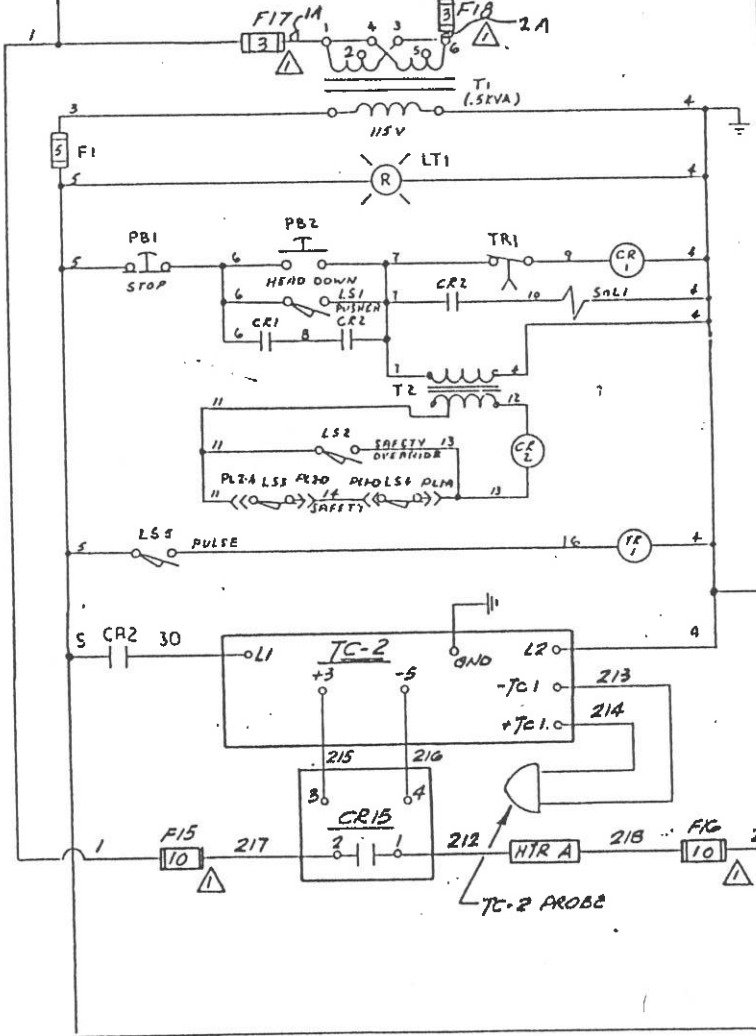
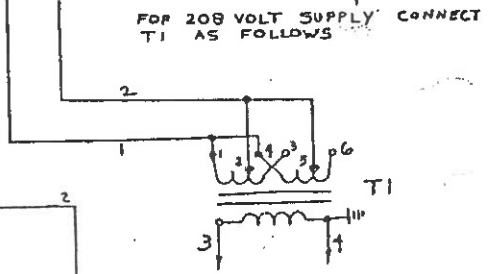
230V, 60W, 1φ



CBI 15AMP

208V, 60W, 1φ

FOR 208 VOLT SUPPLY CONNECT T1 AS FOLLOWS



POWER ON

CYCLE START
HEAD DOWN

SAFETY

DWELL

FILM SPEED

REV	DATE	DESCRIPTION	BY	CHK	APP	COPIES	REVISIONS
1	4/20/84	CHANGE FUSE AND CIRCUIT	4303	1/2/84			
2	4/20/84	REWORK FUSES	4224	1/2/84			
3	4/20/84	NEW RELEASE C 1205-8025	4224	1/2/84			
4	4/20/84	SUPPLIES C 1205-8025	4224	1/2/84			
5	4/20/84	REWORK FUSES	4224	1/2/84			
6	4/20/84	REWORK FUSES	4224	1/2/84			
7	4/20/84	REWORK FUSES	4224	1/2/84			
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9	4/20/84	REWORK FUSES	4224	1/2/84			
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100	4/20/84	REWORK FUSES	4224	1/2/84			

Weldotron

SCHEMATIC
MODEL 1205C
AUTO SEWE WRAP CASE PAK
230V/208V 1φ 60HZ

COORDINATION

REV NO. DATE

REV NO. DATE

REV NO. DATE

REV NO. DATE

REV NO. DATE

REV NO. DATE

REV NO. DATE

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REV NO. DATE

REV NO. DATE

REV NO. DATE

REV NO. DATE

PART NO: 12050015P1
DESCRIPTION: AIR HOSE

REV: 08/23/80
ACT: ROUTE: 1

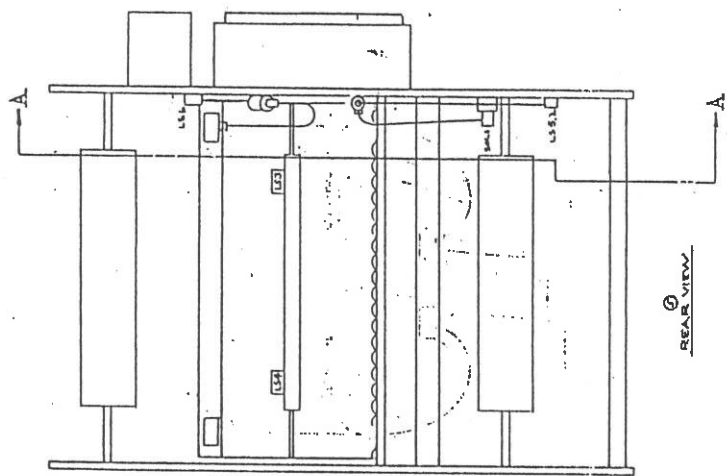
ITEM	P/N	DESCRIPTION	QTY	U/M	REV	ACT
1	HS0586	AIR HOSE 1/4 ID X 1/2 OD RE D NEOPRENE S*	1.0	FT		
4	FG0585	CDJ 0.250 X 0.250 FIT HOS E BARB IMP#K*	4.0	EA		
5	CP0587	MINI CLAMPS AERO SEAL	4.0	EA		
9000	DWG12050015	DWG,AIR HOSE	1.0	EA		

PART NO: 12050015P2
DESCRIPTION: AIR HOSE ASSEMBLY

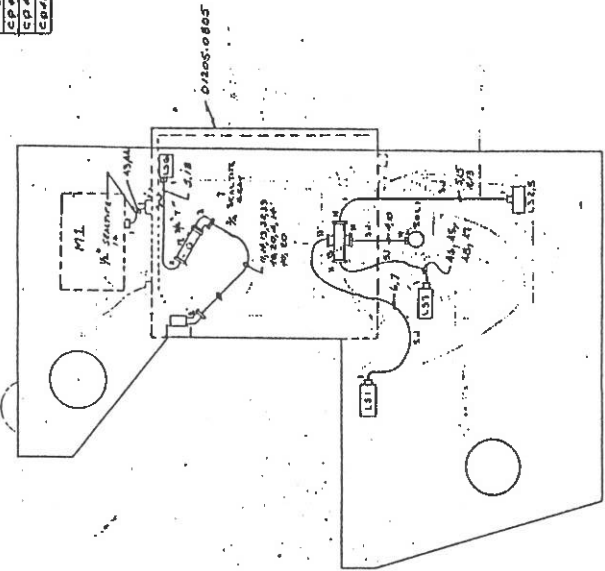
REV: 08/23/80
ACT: ROUTE: 1

ITEM	P/N	DESCRIPTION	QTY	U/M	REV	ACT
2	HS0586	AIR HOSE 1/4 ID X 1/2 OD RE D NEOPRENE S*	1.0	FT		
4	FG0585	CDJ 0.250 X 0.250 FIT HOS E BARB IMP#K*	4.0	EA		
5	CP0587	MINI CLAMPS AERO SEAL	4.0	EA		
9000	DWG12050015	DWG,AIR HOSE	1.0	EA		

PARTS LIST	
ITEM	DESCRIPTION
1	1/2" TRANSISTOR CONNECTOR - 1/2" DIA. 1/2" LONG
2	1/2" TRANSISTOR CONNECTOR - 1/2" DIA. 1/2" LONG
3	1/2" TRANSISTOR CONNECTOR - 1/2" DIA. 1/2" LONG
4	1/2" TRANSISTOR CONNECTOR - 1/2" DIA. 1/2" LONG
5	1/2" TRANSISTOR CONNECTOR - 1/2" DIA. 1/2" LONG
6	1/2" TRANSISTOR CONNECTOR - 1/2" DIA. 1/2" LONG
7	1/2" TRANSISTOR CONNECTOR - 1/2" DIA. 1/2" LONG
8	1/2" TRANSISTOR CONNECTOR - 1/2" DIA. 1/2" LONG
9	1/2" TRANSISTOR CONNECTOR - 1/2" DIA. 1/2" LONG
10	1/2" TRANSISTOR CONNECTOR - 1/2" DIA. 1/2" LONG
11	1/2" TRANSISTOR CONNECTOR - 1/2" DIA. 1/2" LONG
12	1/2" TRANSISTOR CONNECTOR - 1/2" DIA. 1/2" LONG
13	1/2" TRANSISTOR CONNECTOR - 1/2" DIA. 1/2" LONG
14	1/2" TRANSISTOR CONNECTOR - 1/2" DIA. 1/2" LONG
15	1/2" TRANSISTOR CONNECTOR - 1/2" DIA. 1/2" LONG
16	1/2" TRANSISTOR CONNECTOR - 1/2" DIA. 1/2" LONG
17	1/2" TRANSISTOR CONNECTOR - 1/2" DIA. 1/2" LONG
18	1/2" TRANSISTOR CONNECTOR - 1/2" DIA. 1/2" LONG
19	1/2" TRANSISTOR CONNECTOR - 1/2" DIA. 1/2" LONG
20	1/2" TRANSISTOR CONNECTOR - 1/2" DIA. 1/2" LONG
21	1/2" TRANSISTOR CONNECTOR - 1/2" DIA. 1/2" LONG
22	1/2" TRANSISTOR CONNECTOR - 1/2" DIA. 1/2" LONG
23	1/2" TRANSISTOR CONNECTOR - 1/2" DIA. 1/2" LONG



REAR VIEW



VIEW A-A

REVISIONS
D 1205-0805

REVISIONS	
NO.	DESCRIPTION
1	SEE ECO 1007
2	SEE ECO 1203
3	SEE ECO 1260
4	SEE ECO 1260
5	SEE ECO 1260
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100	SEE ECO 1260

REVISIONS
D 1205-0805

PART NO: 12050803

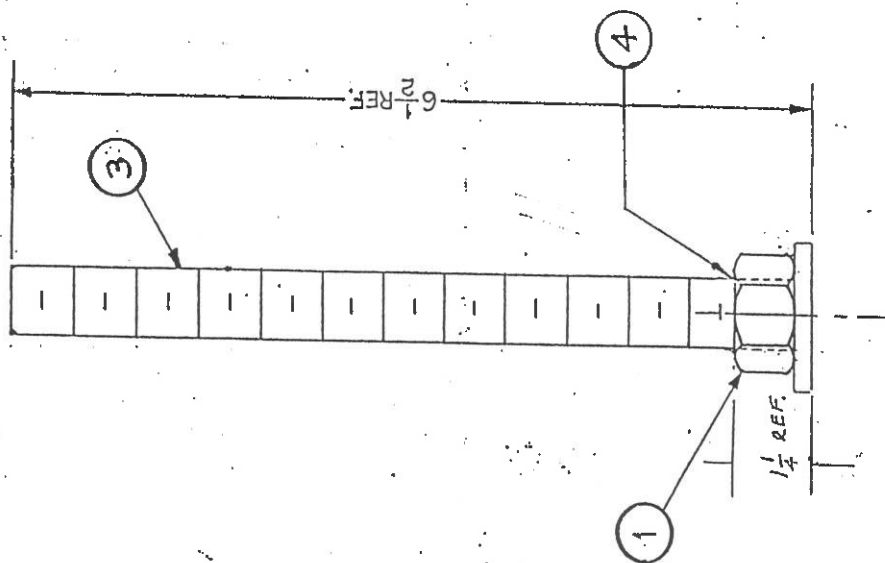
DESCRIPTION: ELECTRICAL ASSEMBLY

REV: 08/23/80

ACT: ROUTE: 1

ITEM	P/N	DESCRIPTION	QTY	U/M	REV	ACT
1	FG1118	BAD 0.500-13 CONNECTOR T&B #5233 LIQ-TI*	6.0	EA		
2	CD6516	CONNECTOR 45 3/4" T+B	1.0	EA		
3	CD3168	APPLETON 3/4" 90 CONNECTOR #ST9075	1.0	EA		
4	CD3167	APPLETON 3/4" STRAIGHT CONN ECTOR #ST75	2.0	EA		
7	CD3177	3/4" SEALTITE, FLEXIBLE CON D.	4.0	FT		
8	WE0130	WIRE 16 GA 3 COND SJ 300 V CSA APPROVED	16.0	FT		
11	CQ0052	CONNECTOR 3/8" T&B 3302 2 S CREW	6.0	EA		
12	CD3143	APPLETON 3/4" T-#T75M	1.0	EA		
13	CD3796	APPLETON UNILET X-50M	1.0	EA		
14	CD3150	3/4" NIPPLE, CLOSE, CONDUIT	1.0	EA		
15	CD5120	NIPPLE CONDUIT 1/2 X 2 LONG	1.0	EA		
16	CD11454	FLEXIBLE CONDUIT STEEL	1.0	FT		
17	CD3160	COVER APPLETON #HK75 3/4	1.0	EA		
18	CD3161	GASKET, APPLETON 3/4" #GKN7 5	1.0	EA		
19	CD3440	GASKET APPLETON GK-50-N OR EQUIV	1.0	EA		
20	CD3441	APPLETON K50-CM COVER OR EQ	1.0	EA		
21	CQ4680	AMPHENOL CONNECTOR #3108B-1 8-11P	2.0	EA		
22	CQ4681	AMPHENOL CONNECTOR #3102A-1 8-11S	2.0	EA		
23	CQ4682	AMPHENOL CABLE CLAMP #MS305 7-10A	2.0	EA		
9000	DWG12050803	DWG, ELECTRICAL ASSEMBLY	1.0	EA		

ITEM NO.	NOMENCLATURE	NO. OF P.C.
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SYN	DESCRIPTION	ECONO.	DATE
3	DELETED ITEM #2 1 TACK WELDING ADDO ITEM #4 DELETED, FIN. WAS CAP. PL.	3422	11-23-55 J.D.
2	ADDED SAVVIEL HUT ASSY. 1	1105	5-21-71
1	ADD 7100 \$ 7010 MODEL NUS.	860	5-13-67

DATE 3-5-63		DATE 4-7-63		DATE		TITLE		SCALE		SIZE		PART NO.		REV	
ORIGIN CHB		CHK NO		APP.		MATERIAL ~		FINISH NONE .A.				1/1 B		7221-0305 3	
Weldobon corporation LEVELING PAD ASSEMBLY SCALE 1/1 SIZE B PART NO. 7221-0305 REV 3															

	7400	7400-0133	4
	5872	5872-0100	1
	7100 SERIES	7121-0001	4
	7010	7010-0205	-
	7200 SERIES; MODEL NO.	7221-0030	4
PART NO.		NEXT ASSEMBLY	NO REQ'D

CONFIDENTIAL

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PART NO: 72210305
DESCRIPTION: LEVELING PAD ASSY

REV: 08/23/80
ACT: ROUTE: 1

ITEM	P/N	DESCRIPTION	QTY	U/M	REV	ACT
1	MP4431	PAD, SWIVEL	1.0	EA		
3	72213040	STUD LEVELING PAD	1.0	EA		
4	AH13922	ADHESIVE LOCTITE #271-21RED COLOR HIGH *	0.0	EA		
9000	DWG72210305	DWG,LEVELING PAD ASSY	1.0	EA		

11. REPLACEMENT PARTS LIST:

This list of Replacement Parts has been prepared to provide a convenient reference list for the ordering of those parts used for normal repair or preventive maintenance purposes. When ordering parts, state the part number and part description. Specify the quantity desired, when needed, and desired shipping method: Parcel Post, Truck, Express, Air Express, etc.

Electrical Replacement Parts List - Refer to Drawing C-1205C-8025 or applicable electrical schematic listed.

<u>ITEM NO.</u>	<u>PART NO.</u>	<u>DESCRIPTION</u>	<u>QTY.</u>
F1	FZ-1033	Fuse, Control 5 Amp-250V	2
F2	FZ-3865	Fuse, Film Feed Motor 1-6/10 Amp-250V.	1
LS3,4	SW-0758	Limit Switch, Safety System	2
LS2/5	SW-3571	Limit Switch, Safety Override, Pulse	1
LS1,6	SW-1837	Limit Switch, Film Feed, Package Pusher	2
TR1	TM-3916	Timer, Dwell	1
CR2	SW-3119	Relay, 24V, Safety	1
CR1	SW-3117	Relay, 115V, Control	1
CB1	CU-17484	Circuit Breaker, Main	1
SOL1	VA-0574A	Solenoid Valve, Head, 120V	1
M1	MR-0071	Motor, Film Feed	1
PB2	SW-3389	Switch, Pushbutton, Head Down	1
PB1	SW-3390	Switch, Pushbutton, Stop	1
REC1	TB-7025	Diode	1
LT1	LT-0699	Pilot Light	1
T1	TR-3405	X'Former	1
PL1,2	CQ-4680	Plug	2
RECP1,2	CQ-4681	Receptacle	2
	CQ-4682	Clamp	2
D1	RE-5990	Varistor	1
T2	TR-6334	Transformer	1
F15,16	FZ-7144	Fuse Heater	2
F17,18	FZ-17486	Fuse, Main, 3 Amp	2
CR15	SW-12410	Relay, 280V, Heater	1

1205K
TD #1564

1 of 2
Issued: 3/86

1205K
SPARE PARTS KIT

<u>PART NO.</u>	<u>DESCRIPTION</u>	<u>QTY.</u>
CX-3879	CONTACTOR	1
FZ-1033	FUSE 3A	2
FZ-1849	FUSE	2
SG-2031	SPRING, COMP.	2
SG-3520	SPRING	2
SG-5556	SPRING	2
SV-1132	SLEEVES HEADED	2
SV-2033	SLEEVE, HEADED NYLON	2
SW-0758	MICROSWITCH	2
SW-1123	RELAY	1
TA-0365	TAPE TEFLON FIBERGLASS	1
TA-0366	TAPE TEFLON FIBERGLASS	1
TA-0461	TAPE TEFLON 7/32 X .010	1
TA-0467	TAPE TEFLON 2"W	1
WE-0926B	WIRE RED .036 DIA 1/2 HD	3
267-0704	WIRE CLAMP CUT-OFF	1
267-0708	TERMINAL BLOCK	1
E690-0709	TERMINAL BLOCK	1
E690-1001	PIN	2
E690-1002	PIN COMPENSATOR	1
E690-1003	SCREW COMPENSATOR	1
E690-1004	SCREW HEIGHT ADJ.	2
E690-7021P1	ELECTRIC SUPPORT	1
E690-7022P1	ELECTRIC SUPPORT	1

1205K
TD #1564

2 of 2
Issued: 3/86

1205K
SPARE PARTS KIT

<u>PART NO.</u>	<u>DESCRIPTION</u>	<u>QTY.</u>
E690-7067P1	PLATE	1
E690-7068	PIN, TAKE-UP	2
E690-7074	PIVOTING BRACKET	1
E690-7075	PIVOTING WIRE TERMINAL	1
1297-0708P1	ELEMENT, RIBBON	8
1297-7065	TERMINAL BLOCK	1
1297-7066	INSULATION	1
1297-7071	PIN, TAKE-UP	1
1297-7073	INSULATOR	2
1297-7076	SCREW, SPRING	1

NOTE

The selection of spare parts for this kit is reviewed by our Technical Services Department. The contents of this kit (but not the total dollar value) may vary. Substitutions will be made without notice and will represent an optimum selection of parts at the time the kit is prepared.

LIMITED WARRANTY AND DISCLAIMER

WELDOTRON CORPORATION warrants to the original Buyer that, except as to expendable items such as elements, tapes, fuses, etc., all equipment and parts manufactured by WELDOTRON shall be free from defects in material of workmanship for a period of one year (1) from the date of shipment (the "warranty period"). The extent of WELDOTRON'S liability under this warranty is limited solely to the repair or replacement of any such defective part at no charge to Buyer, except for the costs of freight and installation which shall be borne by Buyer and provided that Buyer shall, if Weldotron so requests, return any such defective part to WELDOTRON, freight prepaid, for inspection and determination by WELDOTRON as to the nature of the defect.

Notwithstanding the foregoing, WELDOTRON shall be relieved of all liability and obligations under the warranty set forth herein if:

- a. The equipment is used, operated or maintained in any manner other than in accordance with Weldotron's instructions and recommended maintenance procedures as set forth in the operating manual which shall be shipped with the equipment;
- b. The equipment is misused, abused or neglected in any way;
- c. The equipment is altered, modified or changed, or any additional part is installed, unless WELDOTRON shall have previously consented in writing to such alteration, modification, change or installation;
- d. The equipment is operated with any additional accessory or part, whether or not WELDOTRON is the manufacturer thereof unless WELDOTRON shall have previously consented in writing to the operation of the equipment with such accessory or part;
- e. Any materials, packages, containers, pallets or loads which are to be conveyed and/or wrapped are not in a condition to permit their being properly handled by the equipment.
- f. The equipment is serviced or repaired by any person not previously approved by WELDOTRON in writing or,
- g. The Buyer fails to notify WELDOTRON in writing of any defect, breakdown, accident or malfunction of the equipment within seven (7) days of the discovery of such defect or the occurrence of such breakdown, accident or malfunction.

THE FOREGOING WARRANTY IS APPLICABLE SOLELY TO PARTS AND/OR EQUIPMENT MANUFACTURED BY WELDOTRON. WITH RESPECT TO COMPONENT PARTS NOT MANUFACTURED BY WELDOTRON AND AS TO WHICH WELDOTRON IS THE BENEFICIARY OF ANY WARRANTY, BUYER SHALL HAVE, FOR A PERIOD OF ONE (1) YEAR FROM THE DATE OF SHIPMENT OF THE EQUIPMENT TO BUYER, WHATEVER RIGHTS AND REMEDIES, IF ANY, THAT ARE AVAILABLE TO WELDOTRON WITH RESPECT TO SUCH WARRANTY, PROVIDED THAT BUYER SHALL FULLY REIMBURSE WELDOTRON FOR ALL COSTS OF ENFORCING SUCH WARRANTY.

Except for the express warranty set forth above that the equipment shall be free of any defects in material or workmanship during the warranty period:

- a. No affirmation of fact or promise by WELDOTRON with respect to the capacity, suitability or performance of the equipment, whether or not such affirmation or promise is set forth herein, shall constitute any type of warranty as to the equipment, and
- b. THERE ARE NO ADDITIONAL WARRANTIES, EXPRESSED OR IMPLIED, INCLUDING ANY WARRANTIES OF MERCHANT ABILITY OR OF FITNESS FOR A PARTICULAR PURPOSE.

Except as specified by WELDOTRON in writing, WELDOTRON does not warrant that the equipment, as manufactured, conforms to any particular insurance regulations or electrical codes or that the equipment contains any particular safety features. Buyer assumes full responsibility for compliance with all applicable statutes, codes and regulations, whether federal, state or local.

Under no circumstances shall WELDOTRON have any liability for any type of incidental or consequential damages arising from the use, loss of use or defective performance of the equipment. WELDOTRON'S liability is expressly limited to the repair or replacement of defective parts.

The Limited Warranty extends only to the original buyer and is not transferable to subsequent owners, purchasers or possessors of the equipment.

weldotron
corporation

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Piscataway, NJ 08855