

WELDOTRON SUPPLEMENTARY BULLETIN

OPERATING INSTRUCTIONS FOR WELDOTRON MODEL 5300 SERIES CONSOLE SEALER.

TECHNICAL DOCUMENT NO. 659

Issued: February, 1973

I. INTRODUCTION:

This Supplementary Bulletin provides operating instructions for a Model 5300 Series. This Sealer, except for the information detailed below, is the same as described in Technical Document No. 421 - Instructions for Operation and Maintenance of Console Sealers, a copy of which accompanies this Bulletin.

2. POWERED FILM UNWIND AND FILM PLOW:

2.1. Mounting the Film on the Film Unwind.

- a. Select the proper width of centerfolded film for item being packaged, allowing for depth and height of package (add package height, package width, and 2-3/4" extra film on both film layers).
- b. Lift film support shaft out of film supply rack.
- c. Remove rear cone from film support shaft by loosening cam-lock lever and sliding cone off shaft.
- d. Place film supply reel on film support shaft so that open edge of folded film is toward the fixed cone.
- d. Replace rear cone on film support shaft. Press cone firmly into film core and tighten cam-lock lever.

2.2. Threading the Film on the Film Unwind.

- a. Refer to Figure 1 of this Supplement. Thread the film through the first set of rollers, through the slot in the film hole punch (if required adjust hole punch position as explained in paragraph 2.4 of this Supplement, over the powered film-feed roller (lifting the idler), under the dancer roller, and over the remaining roller as shown.

Pull out several feet of film (sufficient to reach far end of package out-feed conveyor) and place the upper film layer over the adjustable film support, under the upper pressure roller wheel and over the film opening rod. Then feed film thru the pinch rollers that mount to the base of the sealer. These rollers are adjustable in height and should be centered with the center of film plow and can be adjusted longitudinally on base of sealer when necessary. Make sure that film is properly aligned

laterally, so that top and bottom front edges of both film layers are in alignment with each other.

2.3. Film Plow Threading

To thread the film plow, proceed as follows, refer to Figure 2 of this Supplement:

- a. With the center-fold of the film positioned at the tip of the plow, pull a small quantity of film toward the infeed section.
- b. The top loose layer of film should be drawn over the top plow arm, the lower film loose layer under the bottom plow area.
- c. The top loose layer of film will then be threaded over and under the top plow arm, extending toward the sealer unit. The bottom loose layer of film will be threaded under and over the lower plow arm.
- d. The film has now been actually turned inside-out.
- e. Hold both ends of the top and bottom film layers in the right hand and the reversed center-fold side in the left hand, and gently pull in the direction of the seal unit, extending the film past the side seal of the sealing unit.
- f. The film is now in position to be sealed and cut-off by the seal unit, to provide an enclosed film envelope on two sides.
- g. Place a sample package to be sealed on the infeed unit, between the top and bottom layers of film. Position the package against the folded edge (rear) of film. Pull film containing the package into the seal area so that the package is almost touching the front and side pads. Check that film is positioned correctly to completely cover the package. Remove the sample package.

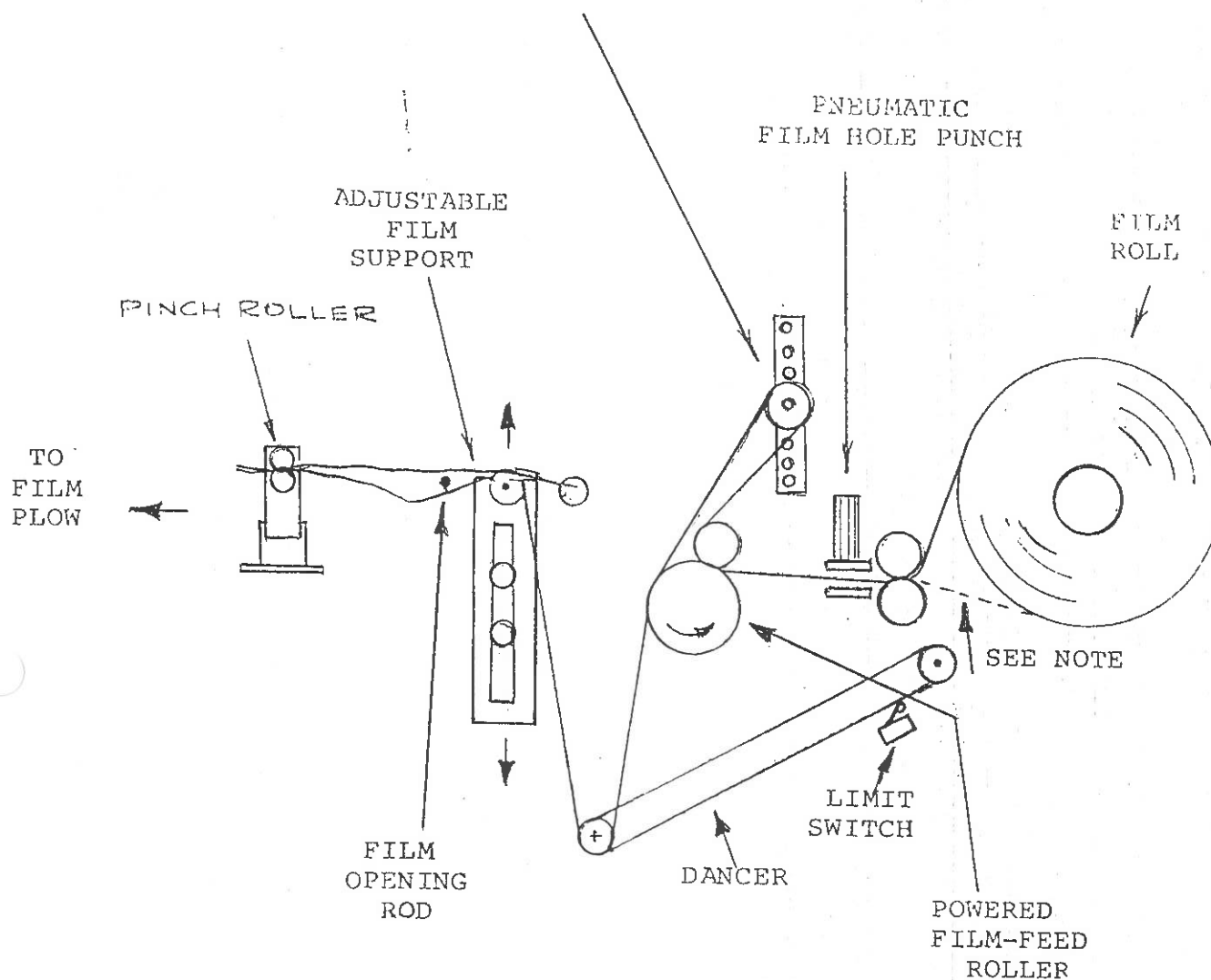
NOTE: The size of the package to be wrapped has a direct relation to the size of the Film Plow in use. The height of the package in particular is important. For best wrapping results the package should barely clear the top of the plow. The plow in use will also affect the width of the film to be used. Various size Film Plows are available, should it be desired, to wrap products where the in-use plow is not compatible. For information regarding Film Plow applications, contact the Weldotron Service Manager: Area Code 201) 752-6700.

2.4. Adjustment and Operation of Hole Punch

The pneumatic hole punch, with which this sealer is equipped, is mounted on the film roll rack, just to the left of the film supply roll. After the selection of the proper width of film for use with the package being wrapped, loosen the mounting wing-nut and push or pull the punch backward or forward on its track to position it so that the rear edge of the slot is approximately 1/2-inch from the rear edge of the packaging film. This will assure that the air-escape vent hole will be properly positioned across the width of the package. Make sure that the film is placed within the slot of the hole punch. Tighten the wing-nut.

Refer to the Film Threading Diagram of Figure 1 of this Supplement. The position at which the vent hole is punched along the length of the package may be adjusted by repositioning the indicated roller on its mounting bracket.

Reposition roller up or
down to move film vent hole
punch along length of package



NOTE: Dotted lines indicate alternate film-threading path
if centerfolded film is wound in opposite direction.

FIGURE 1. FILM THREADING DIAGRAM

PART NO: 53020100P1
DESCRIPTION: PLOW ASSY

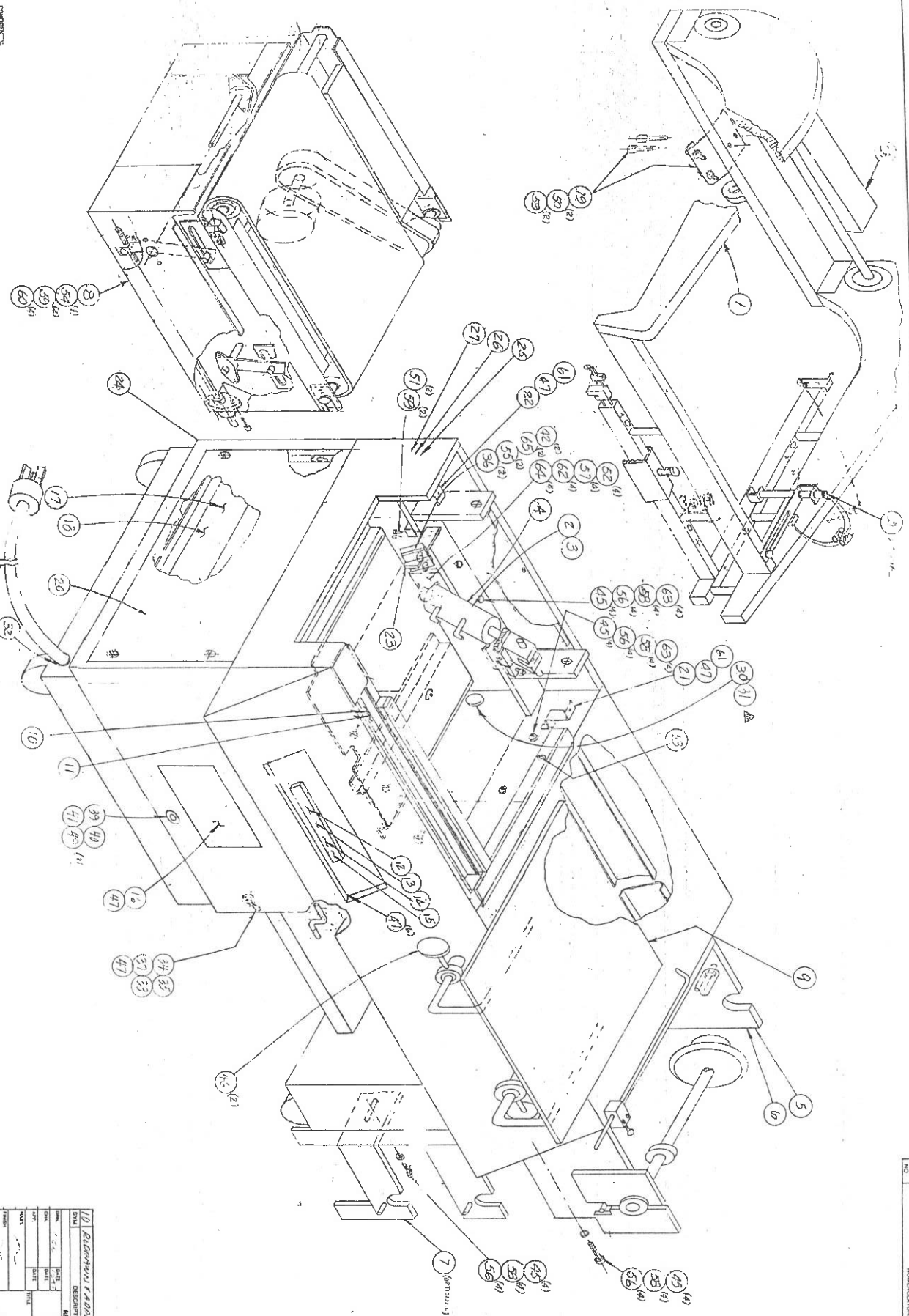
REV: 08/23/80
ACT: ROUTE: 1

ITEM	P/N	DESCRIPTION	QTY	U/M	RV	ACT	MD
1	53020101P12	PLOW WLD	1.0	EA			
2	53020102P12	PLOW WLD LOWER	1.0	EA			
3	58721258P8	PLOW HEAD 4.5 TO 5.25 INCH	1.0	EA			
4	SS0927	AAH,6.32X0.750LG SCREW FLAT HD	4.0	EA			
5	NT4722	AAF,6-32 NUT WING STEEL CP	4.0	EA			
6	SS0345	AAN,0.250-20X0.625 LG SCR THUMB CAD PL	1.0	EA			
7	WA1333	AAB,6 WASHER LOCK SPRING CP	4.0	EA			

PART NO.				NOTE:				MODEL USED ON				5800 5875		
PL 5800-004				ITEM NO. PRECEDED BY "A"				ASSY USED ON				5800 5875		
SHEET 2 OF 5				INDICATES SEPARATE PARTS LIST.				NO. REQ'D. PER ASSY.				1 1		
D 5800 - 004 1								P/N				P-1 P2		
ITEM	SIZE	DWG. NO. LET.		DESCRIPTION				FINISH	P/N	QTY	P/N	QTY		
29														
30	C	5800	- 427	3 BAR, MAIN SUPPORT					-	1	-	1		
31	C	5800	- 428	MOUNT, MOTOR					-	1	-	1		
32														
33	D	5800	- 429	3 PLATE SIDE (FRONT)					-	1	-	1		
34	D	5800	- 430	4. " " (REAR)					-	1	-	1		
35	B	5800	- 431	BLOCK, PRES. ROLLER					-	2	-	2		
36	B	E 60	- 155	SHAFT, FLEX. BALL										
A37	B	E 60	- 73	CORE, FILM, ADJ. END					-	1	-	1		
38	C	E 60	- 157	CORE, FILM, BRAKE END					-	1	-	1		
39		C N	- 1945	COUPLING FLEX 3/16 TO 1/2 BORE BRWNG #F2-1					-	1	-	1		
40		B G	- 1306	1 BEARING BALL FL. "KILIAN" #F175-3					-	8	-	8		
41		B G	- 0809	1 BEARING BALL "FED." #R8RR					-	2	-	2		
42		B G	- 0721	BEARING BALL "FED." #R8RR					-	2	-	2		
43		B U	- 1946	BUSHING, BR. BOSTON #B-1416-8					-	2	-	2		
44		B G	- 685	BEARING, LUBE-ALIGN #LA 1424-16										
45		S G	- 1615	1 SPRING, COMPRESSION					-	2	-	2		
46		S W	- 3579	SWITCH, MICRO #BA-2RYZ-AZ					-	1	-	1		
47		E N	- 1307	COVER, SWITCH MICRO #3PA1					-	1	-	1		
48	B	M R	- 1948	MOTOR VONWEISE MODEL #VW-1A					-	1				
49		M R	- 3875	MOTOR VONWEISE MODEL #VW-1A							-	1		
50		R G	- 1950	1 RING, RETAINING 3/8 DIA. NADES #5555-37AP					-	8	-	8		
51	B	5800	- 453	HOLE, PUNCH ASSY					P-1	1	P-1	1		
52		C Q	- 0052	CONNECTOR, CABLE CLAMP T+B #3302					-	1	-	1		
53		P N	- 1977	1 ROLL PIN, 3/16 DIA x 2 1/4 ESNA 52-040-187-2000					-	2	-	2		
54		P N	- 1576	2 ROLL PIN 1/4 DIA x 3/4 LG ESNA 52-048-250-0750					-	4	-	4		
55		S S	- 1296	SCREW, FLAT HD. #10-32 x 1/2 LG					-	2	-	2		
56		S S	- 1978	SCREW SOC. HD SHALD. 3/8 DIA x 3/4 LG					-	2	-	2		
REV	ECO	BY	DATE	REV	ECO	BY	DATE	REV	ECO	BY	DATE	REV	ECO	BY
1	508	MM		7	796	P		13	ADDED 3875	HB	8/73			
2	552	MM		8	810	P		14	1760	BB	2/5/73			
3	598	RE		9	829	P	11/68							
4	659	MM		10	828	P	11/68							
5	705	MM		11	933	TR	2/2/73							
6	795	P		12	1012	TR	1/4/73							

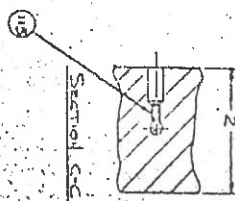
PART NO.				NOTE:				MODEL USED ON				5800				5875			
PL 5800-004				ITEM NO. PRECEDED BY "A" INDICATES SEPARATE PARTS LIST.				ASSY USED ON				5700				5875			
SHEET 5 OF 5								NO. REQ'D. PER ASSY.				1				1			
ITEM	SIZE	DWG. NO.	LET.	DESCRIPTION				FINISH	P.N.	QTY	P.N.	QTY	P.N.	QTY					
112		SS	-	2388	SCREW, HEX 5/16-18x1"														
113		NT	-	0199	NUT, 5/16-18														
114		WA	-	0837	WASHER, FLAT 5/16														
115		SS	-	0618	SCREW, SOC. SET #10-32, 3/8 LG														
116		WA	-	2389	WASHER, LOCK (SPRING) 5/16 DIA														
117																			
118	B E 5 8		-	195	FILM SPREADER ROD														
119	B 5 8 72		-	1195	BLOCK, FILM SPREADER ROD														
120	C 5 8 0 0		-	455	PINCH ROLLER BRACKET														
121	C 5 8 0 0		-	455	PINCH ROLLER BRACKET														
122	B 5 8 0 0		-	412	BLOCK STOP														
123	B 5 8 0 0		-	454	PINCH ROLLER ROD														
124		BU	-	2006	FILM ROD SUPPORT BRG														
125	B - E 6 0		-	155	FILM ROLL SHAFT														
126		BU	-	2007	FILM ROD, BEARING														
127		SS	-	1384	SCREW RD. HD. # 6-32x1/2 LG														
128		WA	-	1292	WASHER FLAT #6														
129	B 5 8 0 0		-	411	PAD STOP BLOCK														
130		CL	-	0325	COLLAR 5/8 I.D. x 1 1/8 O.D.														
131		WA	-	3220	THRUST BEARING WASHER														
132		RG	-	3219	RETAINING RING														
133		SS	-	3610	1/4-20x1" HEX. HD. MACH. SCREW														
134																			
4135	D 5 8 0 0		-	0100	GUIDE ROD ASSY														
136																			
137																			
138																			
139																			

This drawing contains proprietary information and is the property of WILCOX, Inc. Any disclosure of this information without written consent is prohibited.



PART NO.		QUANTITY	UNIT PRICE	TOTAL
10		1	1.00	1.00
WILCOX WILCOX, INC. 1001 N. 17th St. Phoenix, Arizona 85016 TEL: 602-944-1111 FAX: 602-944-1112				

ITEM NO.	DESCRIPTION	QTY.	UNIT PRICE	TOTAL
10	WILCOX WELDING TORCH	1	1.00	1.00

[illegible]

PAGE	NAME LIST	NOMENCLATURE
100		

PART NO: 53000001P1
DESCRIPTION: MAIN ASSEMBLY

REV:04 10/04/90
ACT: ROUTE: 1

ITEM	P/N	DESCRIPTION	QTY	U/M	RV	ACT	MD
1	E580007P1	SEALING HEAD ASSEMBLY	1.0	EA	05		AS
4	E580009	PNEUMATIC ASSEMBLY	1.0	EA			AS
8	E580014P1	CONVEYOR OUTFEED ASSY	1.0	EA	12		AS
9	E580017P1	LOADING TRAY ASSEMBLY	1.0	EA			AS
11	E580019-2P1	SCRAP REMOVAL ASSEMBLY	1.0	EA			AS
12	E580021-1	CONTROL PANEL ASSEMBLY	1.0	EA			AS
16	E580022	TIMER & LINE BREAKER ASY	1.0	EA			AS
17	E580023P1	CHASSIS ASSY ELECT	1.0	EA			AS
19	E580024	SWITCH ACTUATOR ASSEMBLY	1.0	EA			AS
20	E580028P1	ACCESS COVER (THIS DWG.)	1.0	EA			
21	E580117	ANGLE RH	1.0	EA			
22	E580118	ANGLE LH	1.0	EA			
23	E580196	SWITCH MOUNT	1.0	EA			
24	52000127P1	CONSOLE WELD ASSY	1.0	EA	01		
25	52000129	SLNG HEAD FRAME WELDMENT	1.0	EA			
28	E580121P1	CYLINDER COVER 8.75 X 32.25	1.0	EA			
30	PG17881	RCPT,277V,20A CSA LISTED	1.0	EA			
31	PG17882	PLUG,277V,20A,CSA	1.0	EA			
32	CQ0609	CONN BX 2 SCREW 3/4	1.0	EA			
34	SW1240	SWITCH TOGGLE DPDT	1.0	EA			
36	SW0202	SWITCH	2.0	EA			
38	LB6733	LABEL POLYETHYLENE NORMA	1.0	EA			
39	KB1100	KNOB,1 DIA	1.0	EA			
40	KB1101	KNOB	1.0	EA			
41	RH1102	TAP SWITCH,6POS,10-32-3/8 BND HD	1.0	EA			
42	SW0725A	ENCL SWITCH FOR SW0725	2.0	EA			
45	SS0190	AAA,0.250-20X1.000LG SCREW HEX HD CAP CP	16.0	EA			

PART NO: 53000001P1
DESCRIPTION: MAIN ASSEMBLY

REV:04 10/04/90
ACT: ROUTE: 1

ITEM	P/N	DESCRIPTION	QTY	U/M	RV	ACT	MD
46	SS0934	AAN,0 312-18X0.750 LG SCREW THUMB CAD PL	2.0	EA			
47	SS0335	AAG,8-32X0.500 LG SCR BIND HD MS PL	18.0	EA			
49	SS0272	AAG,10-32X0.375 LG SCR BIND HD MA CAD PL	3.0	EA			
50	SS0186	AAC,10-32X0.500 LG SCR SOC HD CAP CAD PL	2.0	EA			
51	SS0340	AAG,10-32X0.750 LG CAD PL	2.0	EA			
52	SS0051	AAA,0.375-16X1.250LG SCREW HEX HD CAP CP	4.0	EA			
53	SS0017	AAC,0.250-20X0.875LG SCR HD SOC CAP CP	8.0	EA			
54	SS4285	ABF,10-32X0.375 LG SCR BTN HD SOC	4.0	EA			
55	SS0266	AAG,6-32X2.500 LG SCR BIND HD MACH CAD	2.0	EA			
56	WA0361	AAA,0.250 WASHER FLAT SAE PLAIN CP	16.0	EA			
57	WA0260	AAA,0.375 WASHER FLAT CP	4.0	EA			
58	WA0619	ABB,0.250 WASHER	16.0	EA			
59	WA1003	AAB,10 WASHER LOCK SPRING	8.0	EA			
60	WA0351	ABA,10 WASHER	4.0	EA			
61	WA1334	AAB,8 WASHER LOCK SPRING CP	2.0	EA			
62	WA2374	ACB,0.375 WASHER LOCK SST	4.0	EA			
63	NT0627	AAA,0.250-20 NUT HEX CAD	10.0	EA			
64	NT2378	ACA,0.375-16 NUT HEX ST STL	4.0	EA			
65	NT0198	AAA,6-32 NUT HEX CAD PL	2.0	EA			
70	251B0010	VACUUM SYSTEM	1.0	EA	02		AS
72	53020001P1	MODIFICATION ASSY	1.0	EA	07		AS
73	LB20405	LABEL,CAUTION SAFETY FIRST	1.0	EA	01		
74	52000160	START-UP KIT FOR MODEL 5201	1.0	EA			AS
9001	5301AOPT/ACCESS	OPTIONS & ACCESSORIES 5301A	1.0	EA			P

WELDOTRON SUPPLEMENTARY BULLETIN

OPERATING INSTRUCTIONS FOR WELDOTRON

MODEL 5300 SERIES CONSOLE SEALER

Technical Document #659

Issued: February, 1973

Revised: July 1992

1. INTRODUCTION

This Supplementary Bulletin provides operating instructions for a Model 5300 Series. This Sealer, except for the information detailed below, is the same as described in Technical Document #421 - Instructions for Operation and Maintenance of Console Sealers, a copy of which accompanies this Bulletin.

2. POWERED FILM UNWIND AND FILM PLOW

2.1 Mounting the Film on the Film Unwind

- a. Select the proper width of centerfold film for item being packaged, allowing for depth and height of package (add package height, package width, and 2-3/4" extra film on both film layers).
- b. Lift film support shaft out of film supply rack.
- c. Remove rear cone from film support shaft by loosening cam-lock lever and sliding cone off shaft.
- d. Place film supply reel on film support shaft so that open edge of folded film is toward the fixed cone.
- e. Replace rear cone on film support shaft. Press cone firmly into film core and tighten cam-lock lever.

2.2 Threading the Film on the Film Unwind

- a. Refer to Figure 1 of this Supplement. Thread the film through the first set of rollers, through the slot in the film hole punch (if required adjust hole punch position as explained in paragraph 2.4 of this Supplement, over the powered film-feed roller (lifting the idler), under the dancer roller, and over the remaining roller as shown.

2.2 Threading the Film on the Film Unwind (cont'd)

Pull out several feet of film (sufficient to reach far end of package out-feed conveyor) and place the upper film layer over the adjustable film support, under the upper pressure roller wheel and over the film opening rod. Then feed film thru the pinch rollers that mount to the base of the sealer. These rollers are adjustable in height and should be centered with the center of film plow and can be adjusted longitudinally on base of sealer when necessary. Make sure that film is properly aligned laterally, so that top and bottom front edges of both film layers are in alignment with each other.

2.3 Film Plow Threading

To thread the film plow, proceed as follow, refer to Figure 2 of this Supplement:

- a. with the center-fold of the film positioned at the tip of the plow, pull a small quantity of film toward the infeed section.
- b. The top loose layer of film should be drawn over the top plow arm, the lower film loose layer under the bottom plow area.
- c. The top loose layer of film will then be threaded over and under the top plow arm, extending toward the sealer unit. The bottom loose layer of film will be threaded under and over the lower plow arm.
- d. The film has now been actually turned inside-out.
- e. Hold both ends of the top and bottom film layers in the right hand and the reversed center-fold side in the left hand, and gently pull in the direction of the seal unit, extending the film past the side seal of the sealing unit.
- f. The film is now in position to be sealed and cut-off by the seal unit, to provide an enclosed film envelope on two sides.
- g. Place a sample package to be sealed on the infeed unit, between the top and bottom layers of film. Position the package against the folded edge (rear) of film. Pull film containing the package into the seal area so that the package is almost touching the front and side pads. Check that film is positioned correctly to completely cover the package. Remove the sample package.

NOTE

The size of the package to be wrapped has a direct relation to the size of the Film Plow in use. The height of the package in particular is important. For best wrapping results the package should barely clear the top of the plow. The plow in use will also affect the width of the film to be used. Various size Film Plows are available, should it be desired, to wrap products where the in-use plow is not compatible. For information regarding Film Plow applications, contact the Weldotron Technical Services Department.

Phone: 908-752-6700

2.4 Adjustment and Operation of Hole Punch

The pneumatic hole punch, with which this sealer is equipped, is mounted on the film roll rack, just to the left of the film supply roll. After the selection of the proper width of film for use with the package being wrapped, loosen the mounting wing-nut and push or pull the punch backward or forward on its track to position it so that the rear edge of the slot is approximately 1/2-inch from the rear edge of the packaging film. This will assure that the air-escape vent hole will be properly positioned across the width of the package. Make sure that the film is placed within the slot of the hole punch. Tighten the wing-nut.

Refer to the Film Threading Diagram of Figure 1 of this Supplement. The position at which the vent hole is punched along the length of the package may be adjusted by repositioning the indicated roller on its mounting bracket.

PART NO: 53020003
 DESCRIPTION: FILM UNWIND ASSEMBLY

REV:08 10/04/90
 ACT: ROUTE: 1

ITEM	P/N	DESCRIPTION	QTY	U/M	RV	ACT	MD
40	BG1306	ABD,0.375 IDX0.906 FLANGED	10.0	EA			
41	BG0809	ABA,0.375 ID X 0.875 OD DS 2 RET RGS	2.0	EA			
42	BG0721	ABH,0.500IDX1.125OD DB SEAL DB SHIELD	2.0	EA			
44	BG0685	AEE,BEARING LUBE ALIGN	2.0	EA			
45	SG1615	SPRING,SST	2.0	EA	03		
46	SW3579	SWITCH	1.0	EA			
47	EN1307	TERMINAL ENCL	1.0	EA			
48	MR1948	MOTOR	1.0	EA			
50	RG1950	ABA,0.375 SHAFT RING	8.0	EA			
52	CQ0052	CONNECTOR 3/8" SCREW	1.0	EA			
53	PN1977	ABA,0.187 DIA X2.000 LG PIN ROLL	2.0	EA			
54	PN1576	ABA,PIN RL	4.0	EA			
55	SS1296	AAH,10-32X0.500 LG SCR FLAT HD MACH CP	2.0	EA			
56	SS1978	AAK,0.375X0.750LG SCR SHLDR SOC HD CP	2.0	EA			
62	NT1980	AAB,0.312-18 NUT HEX JAM	4.0	EA			
63	SS7293	ACA,10-32X0.500 LG SCR HEX HD SST	10.0	EA			
64	SS1981	AAA,10-32X0.625 LG SCR HEX HD MACH CP	16.0	EA			
65	SS0067	AAA,0.250-20X0.750 LG SCREW HEX HD CP	16.0	EA			
66	SS1982	AAC,0.250-20X2.000 LG SCR SOC HD CAP CP	6.0	EA			
67	SS0072	AAQ,6X0.500 LG SCR SHT MTL PAN HD A	2.0	EA			
69	WA0351	ABA,10 WASHER	28.0	EA			
70	WA0361	AAA,0.250 WASHER FLAT SAE PLAIN CP	17.0	EA			
71	SS1064	AAG,10-32X0.250 LG SCR BIND HD MACH CP	2.0	EA			
72	WA1003	AAB,10 WASHER LOCK SPRING	32.0	EA			
73	WA0619	ABB,0.250 WASHER	20.0	EA			
74	SS1155	ABN,0.250-20X1.000 LG SCREW THUMB	4.0	EA			
76	SS1299	AAA,0.375-16X1.000 LG SCREW HEX HD CP	2.0	EA			

PART NO: 53020003
 DESCRIPTION: FILM UNWIND ASSEMBLY

REV:08 10/04/90
 ACT: ROUTE: 1

ITEM	P/N	DESCRIPTION	QTY	U/M	RV	ACT	MD
77	WA0260	AAA,0.375 WASHER FLAT CP	2.0	EA			
78	WA0981	AAB,0.375 WASHER LOCK CP	2.0	EA			
79	SS0719	AAG,10-32X1.500 LG SCREW BH MS STL CP	2.0	EA			
80	NT0287	AAA,10-32 NUT HEX CAD PL	2.0	EA			
81	SS0329	AAG,6-32X0.250 LG SCR BIND HD MACH CP	4.0	EA			
82	SS2136	AAG,6-32X2.000 LG SCR BIND HD FULL THD	2.0	EA			
83	SS2151	AAK,0.375X1.250 LG SCR SOC SHLDR CP	1.0	EA			
84	SS2152	AAK,0.375X1.500 LG SCREW SHLDR CAD PL	1.0	EA			
85	BU0636	AGG,STRAIN RELIEF BUSHING	2.0	EA			
87	CR0434	LINE CORD 16/2 TYPE-SJ	11.0	FT			
88	CP0937	CLAMP CABLE	3.0	EA			
89	BU0153	AGG,0.500 OD SNAP LOCK	1.0	EA			
90	PG1663	PLUG	1.0	EA			
91	PG1662	PLUG	1.0	EA			
92	CQ0778	CONN-WIRE JOINT INSULATED	3.0	EA			
93	LG0775	TERM FORK INSULATED	2.0	EA			
96	NT0358	ABA,0.250-20 NUT HEX	4.0	EA			
99	58000440	HOLE PUNCH WASHER	1.0	EA			
100	LB1696	LABEL,WIRE MARKERS VINYL CLOTH	1.0	EA			
109	NT0627	AAA,0.250-20 NUT HEX CAD	4.0	EA			
115	SS0618	ABI,10-32X0.375 LG SCR SOC HD CUP PT	1.0	EA			
119	58721195	BLOCK FILM SPREAD ROD	1.0	EA	02		
120	58000455	PINCH ROLLER BRACKET	2.0	EA			
122	58000412	BLOCK STOP	1.0	EA			
123	58000454	PINCH BLOCK ROD	1.0	EA			
125	BU2007	AEB,0.635ID,0.740OD,0.437	2.0	EA			
127	SS1282	ABB,6-32X0.500 LG SCREW RD HD MACH	2.0	EA			

PARTS LISTS AND DRAWINGS

ASSEMBLY DRAWINGS DESCRIPTION AND PARTS LIST

DESCRIPTION	PARTS LIST NO.
FILM UNWIND ASSEMBLY	53020003
GUIDE ROD ASSY(DANCER ARM)	58000100

PART NO: 53020003
DESCRIPTION: FILM UNWIND ASSEMBLY

REV:08 10/04/90
ACT: ROUTE: 1

ITEM	P/N	DESCRIPTION	QTY	U/M	RV	ACT	MD
2	58000041	ROLLER MFG ASSY FILM DRIVE ROLLER	1.0	EA			
4	58000442	ROLL SUPP FILM UNWIND	2.0	EA			
6	58000432	CONN BOX FILM UNW MTR	1.0	EA			
7	58000433	COVER CONN BOX FLM UNW	1.0	EA			
9	58000418P2	SPACER 0.562 LONG	1.0	EA			
10	58000408	ROLLER FILM PRESSURE	1.0	EA			
11	58000409	SHAFT PRESSURE ROLLWR	1.0	EA			
12	58000410	BAR HOLE PUNCH TG	2.0	EA			
14	58000414P2	SHAFT 414	2.0	EA			
15	58000413	SHAFT FILM FEED ROLL	1.0	EA			
16	58000414P1	IDLER SHAFT	2.0	EA			
17	58000415	BLACK BEARING	2.0	EA			
18	58000416P1	STOP DANCER	1.0	EA			
19	58000416P2	STOP DANCER	1.0	EA			
21	58000418P1	SPACER 0.312 LONG	1.0	EA			
23	58000420	FRAME SUPP SHAFT	1.0	EA			
25	58000422	BAR LOWER SUPPORT	1.0	EA			
26	58000423	IDLER ROLLER	4.0	EA			
27	58000435	SPACER MICRO SWITCH	1.0	EA	01		
28	58000425	SHAFT SUPPORTING	1.0	EA			
31	58000428	MOTOR MOUNT	1.0	EA			
33	58000429	PLATE SIDE(FRONT)	1.0	EA	13		
34	58000430	PLATE SIDE(REAR)	1.0	EA	12		
35	58000431	BLOCK MTG PRES ROLL	2.0	EA			
36	E600215	SHAFT FILM ROLL	1.0	EA	01		
37	E600156	CORE ADJ	2.0	EA	09		
39	CN1945	COUPLING,FLEXIBLE,5/16&1/2 BORES	1.0	EA			

PART NO: 53020003
DESCRIPTION: FILM UNWIND ASSEMBLY

REV:08 10/04/90
ACT: ROUTE: 1

ITEM	P/N	DESCRIPTION	QTY	U/M	RV	ACT	MD
128	WA1292	AAA,6 WASHER PLAIN CP	6.0	EA			
129	58000411	PAD STOP BLOCK	1.0	EA			
130	CL0325	AAD,0.625ID W/SET SCR SHAFT LOCK	2.0	EA			
131	WA3220	AGF,0.625X1.000 WASHER THR MOLDED NYL	1.0	EA			
132	RG3219	ABA,0.625 SH.	2.0	EA			
135	58000100	GUIDE ROD ASSY(DANCER ARM)	1.0	EA			AS
9000	DWG53020003	DWG,FILM UNWIND MAIN ASSY	1.0	EA			D

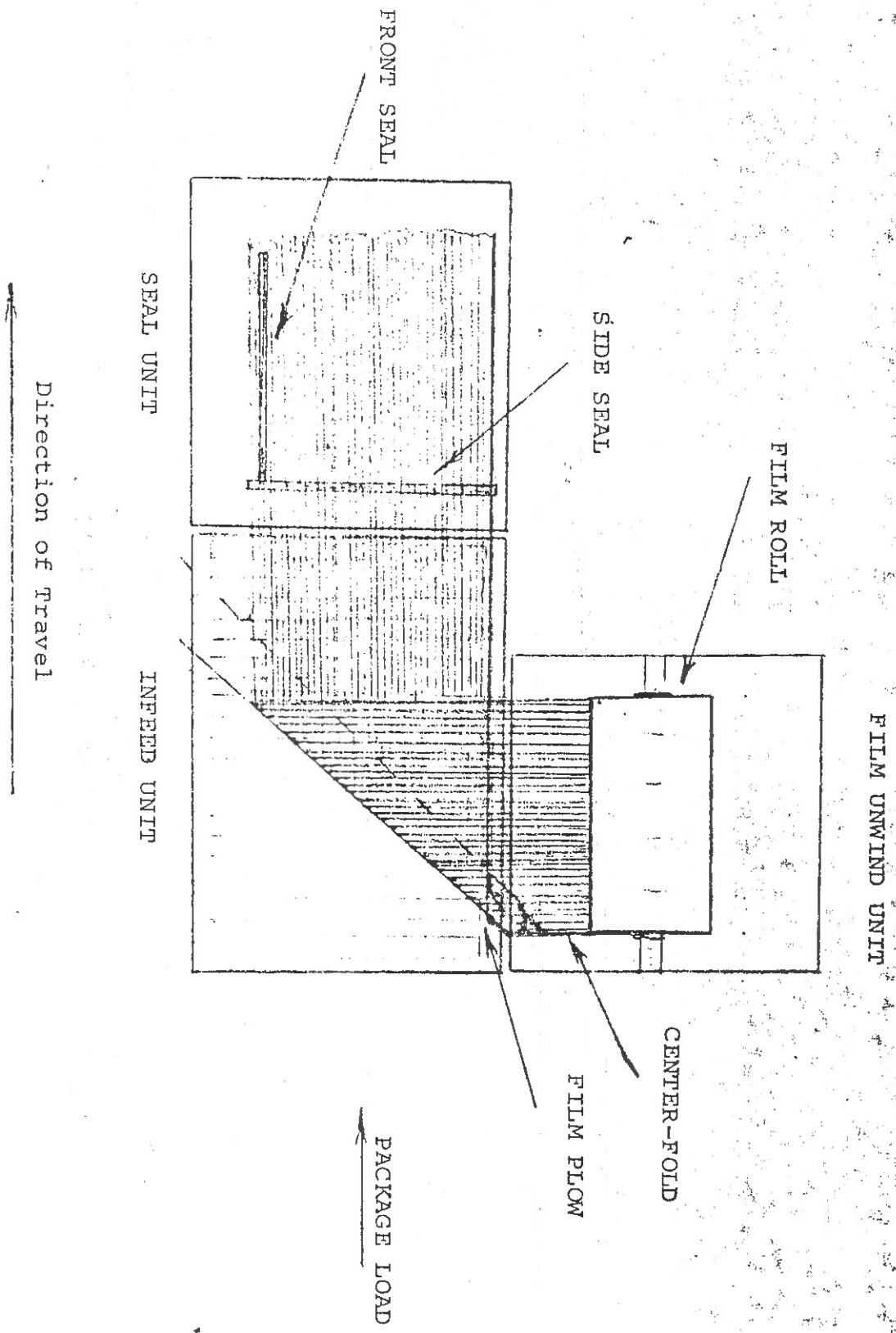
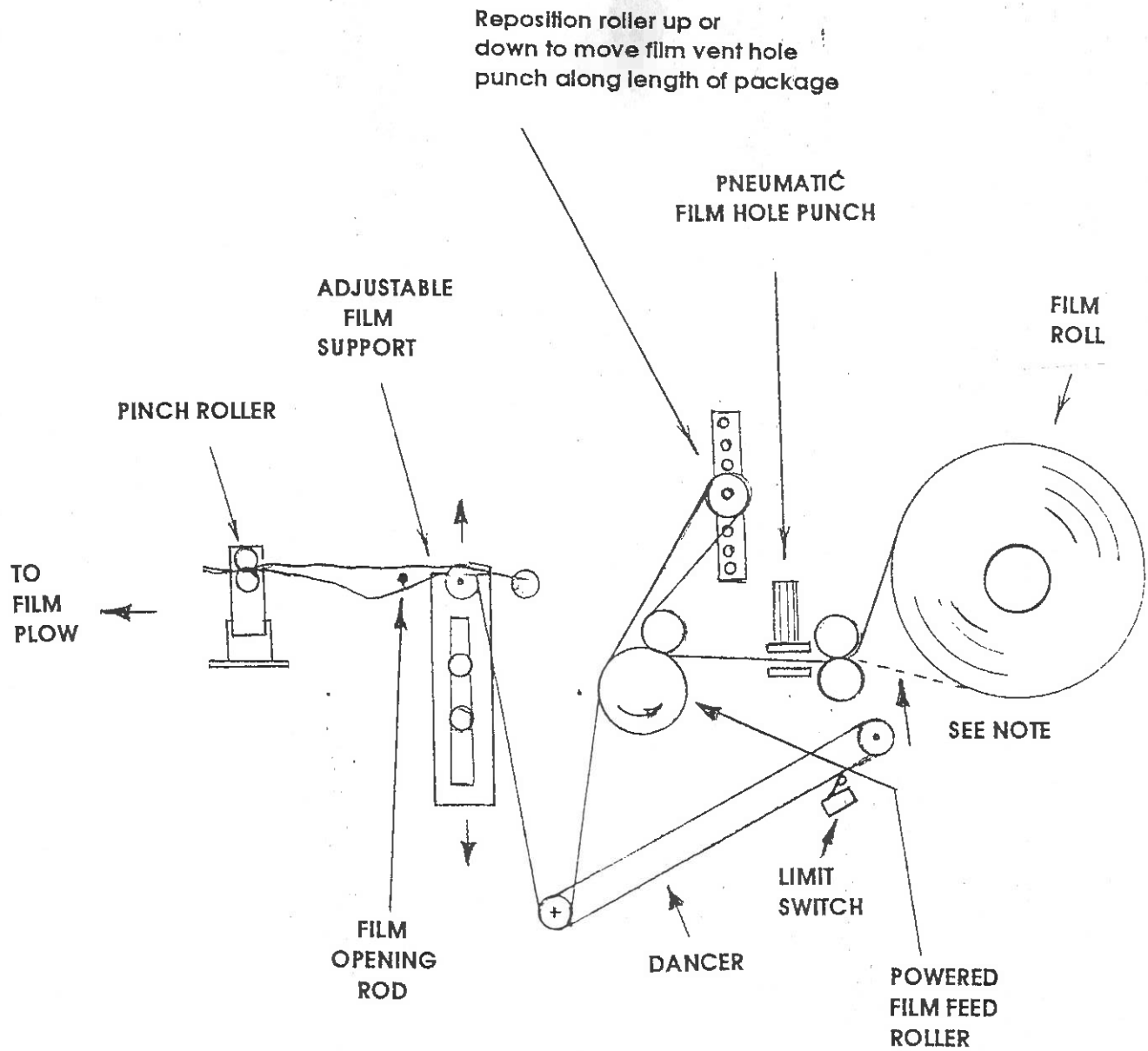


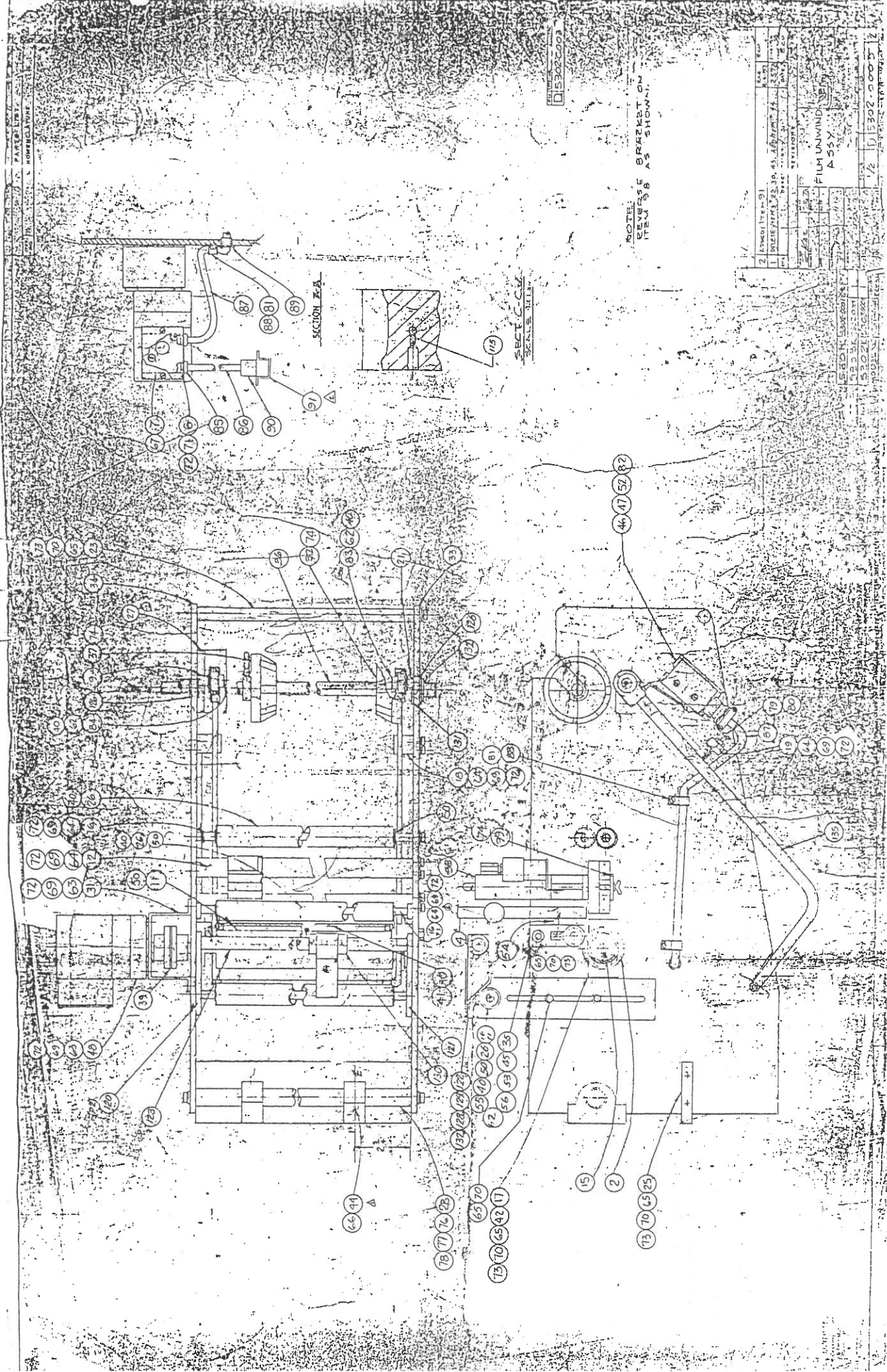
FIGURE 2 FILM PLOW THREADING



NOTE

Dotted lines indicate alternate film-threading path if centerfolded film is wound in opposite direction.

Figure 1 Film Threading Diagram



NOTE: REVERSE BRACKET ON ITEM 98 AS SHOWN.

DISC 2003

ITEM	QTY	DESCRIPTION	UNIT	REMARKS
1	1	DISC 2003		
2	1	DISC 2003		

FILM UNWINDING ASSY

ITEM	QTY	DESCRIPTION	UNIT	REMARKS
1	1	DISC 2003		
2	1	DISC 2003		

PART NO: 58000100
DESCRIPTION: GUIDE ROD ASSY(DANCER ARM)

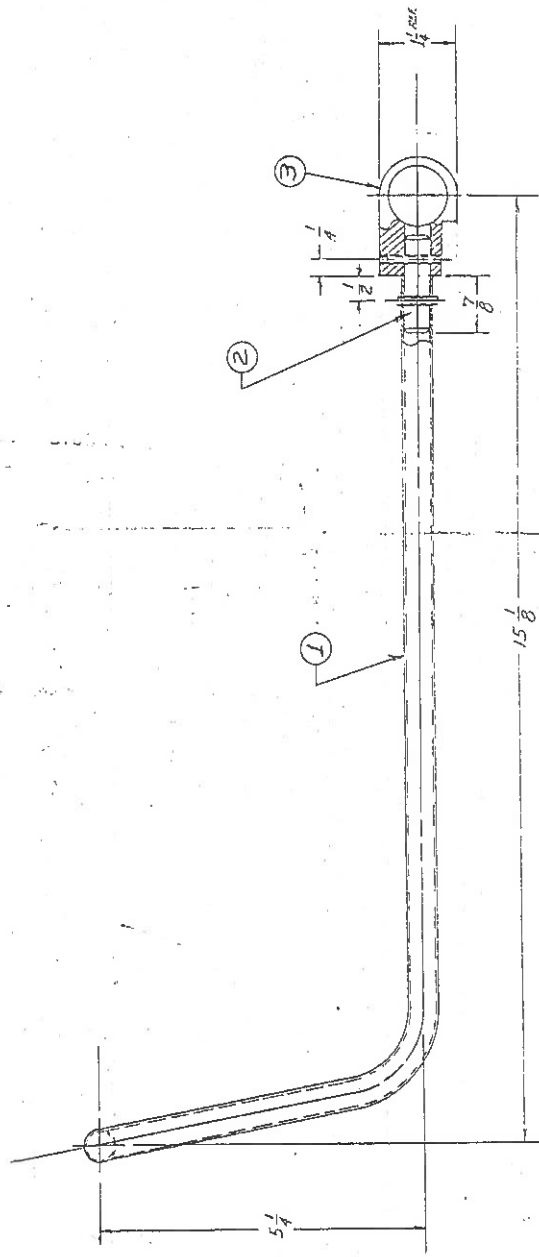
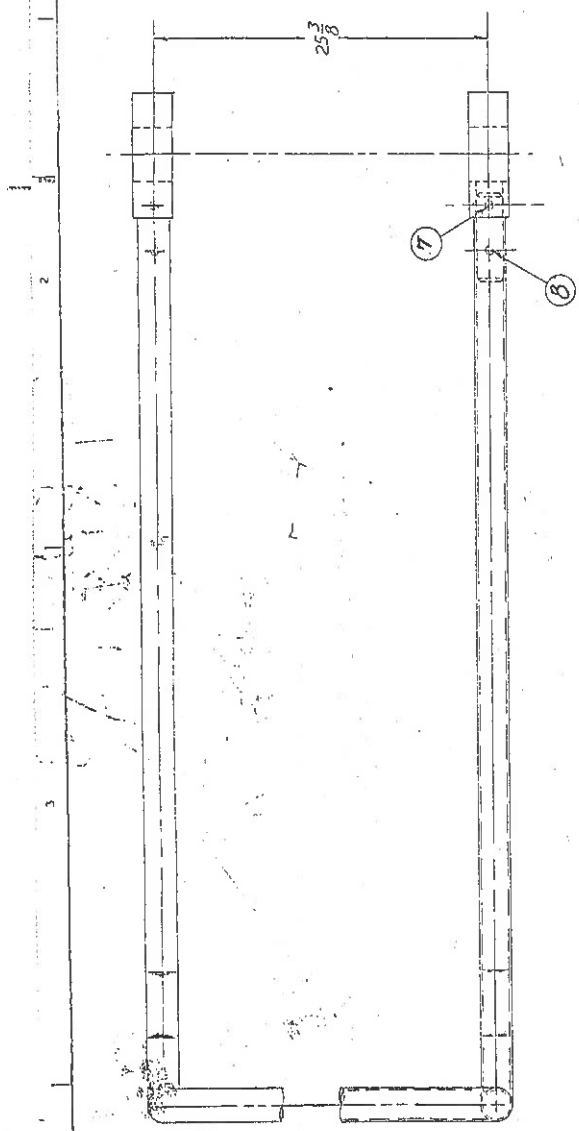
REV: 08/23/80
ACT: ROUTE: 1

ITEM	P/N	DESCRIPTION	QTY	U/M	RV	ACT	MD
1	58000469	GUIDE ROD	1.0	EA	03		
2	58000470	GUIDE PIN	2.0	EA			
3	58000471	BLOCK DANCER SUPP	2.0	EA			
7	PN0311	AAA,0.125 D X 1.000 LG PIN ROLL CP	2.0	EA			
8	PN0842	ABA,PIN RL	2.0	EA			
9000	DWG58000100	DWG,GUIDE ROD ASSY (DANCER ARM)	1.0	EA			D

REV	DATE	DESCRIPTION
1		INITIALS

REVISIONS
D5800-01001

CHANGED DRAWING NUMBER		REV	DATE	APP
DESCRIPTION				
GUIDE ROD				
ASSY				
(OVERALL)				
D5800-0100				



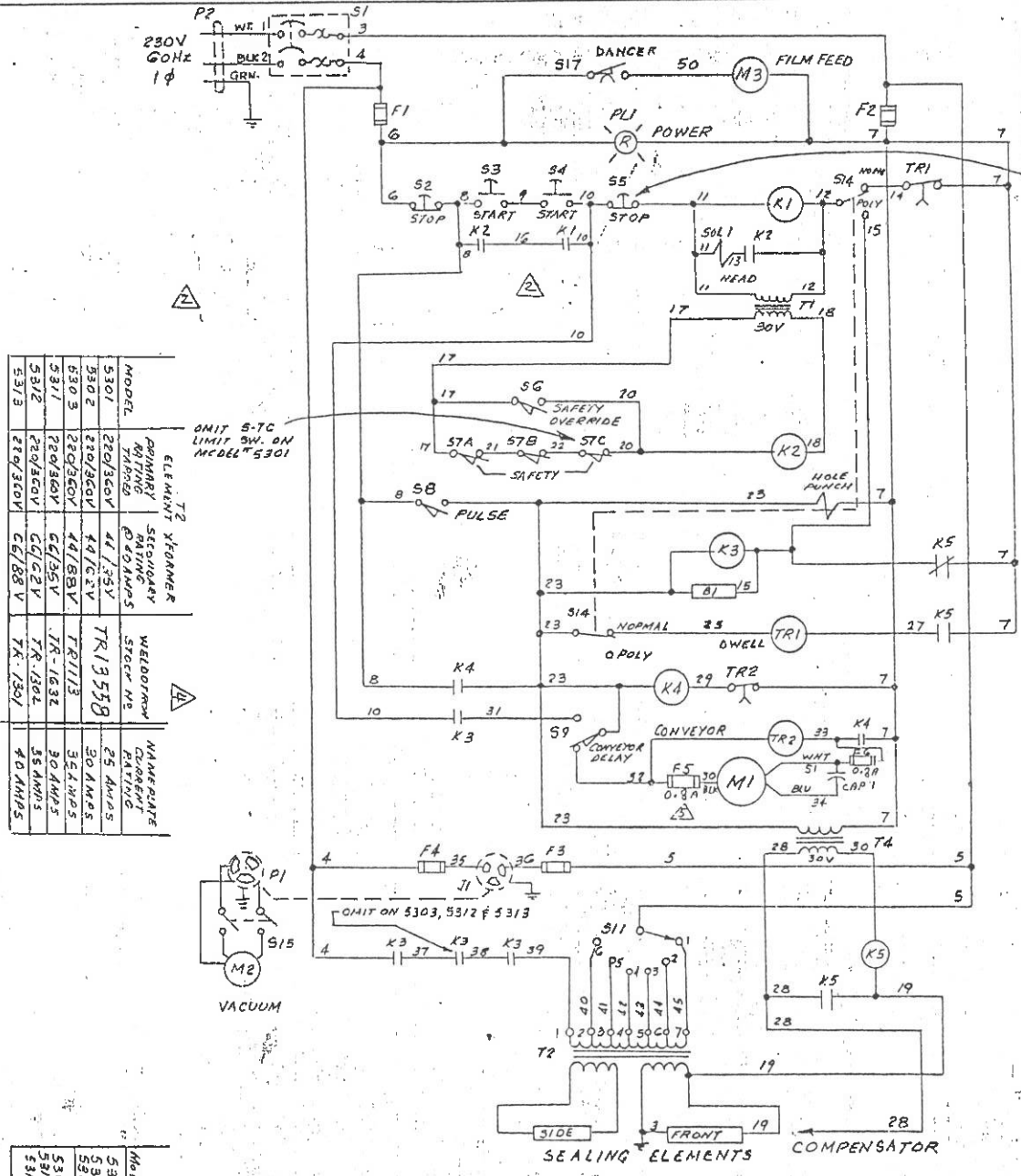
CONFIDENTIAL
This drawing contains information that is the property of the U.S. Government and is not to be distributed outside the U.S. Government without prior approval of the U.S. Government.

WAS D-4478-0101

This Drawing contains proprietary information notified to WELDONOTON manufacturing ONLY. Any replication of this material without authorized written consent is prohibited.

CONFIDENTIAL

FOR P-MODEL USE MR-1809 INSTEAD OF
MR1793 FOR CONVEYOR MOTOR.
LAST WIRE NUMBER USED: 50



MODEL	PRIMARY RATING	SECONDARY RATING	WELDING WIRE	WELDING WIRE	NAME PLATE
5301	220/360V	41.75V	TR1355B	TR1355B	25 AMPS
5302	220/360V	44.75V	TR1355B	TR1355B	30 AMPS
5303	220/360V	44.75V	TR1355B	TR1355B	35 AMPS
5311	220/360V	44.75V	TR1355B	TR1355B	30 AMPS
5312	220/360V	44.75V	TR1355B	TR1355B	35 AMPS
5313	220/360V	44.75V	TR1355B	TR1355B	40 AMPS

MODEL	WELDING WIRE	WELDING WIRE
5301	TR1355B	TR1355B
5302	TR1355B	TR1355B
5303	TR1355B	TR1355B
5311	TR1355B	TR1355B
5312	TR1355B	TR1355B
5313	TR1355B	TR1355B

ITEM NO.	DESCRIPTION	QTY	UNIT	REVISIONS
1	WELDONOTON	1	PCB	1
2	WELDONOTON	1	PCB	1
3	WELDONOTON	1	PCB	1
4	WELDONOTON	1	PCB	1
5	WELDONOTON	1	PCB	1
6	WELDONOTON	1	PCB	1
7	WELDONOTON	1	PCB	1
8	WELDONOTON	1	PCB	1
9	WELDONOTON	1	PCB	1
10	WELDONOTON	1	PCB	1
11	WELDONOTON	1	PCB	1
12	WELDONOTON	1	PCB	1
13	WELDONOTON	1	PCB	1
14	WELDONOTON	1	PCB	1
15	WELDONOTON	1	PCB	1
16	WELDONOTON	1	PCB	1
17	WELDONOTON	1	PCB	1
18	WELDONOTON	1	PCB	1
19	WELDONOTON	1	PCB	1
20	WELDONOTON	1	PCB	1
21	WELDONOTON	1	PCB	1
22	WELDONOTON	1	PCB	1
23	WELDONOTON	1	PCB	1
24	WELDONOTON	1	PCB	1
25	WELDONOTON	1	PCB	1
26	WELDONOTON	1	PCB	1
27	WELDONOTON	1	PCB	1
28	WELDONOTON	1	PCB	1
29	WELDONOTON	1	PCB	1
30	WELDONOTON	1	PCB	1
31	WELDONOTON	1	PCB	1
32	WELDONOTON	1	PCB	1
33	WELDONOTON	1	PCB	1
34	WELDONOTON	1	PCB	1
35	WELDONOTON	1	PCB	1
36	WELDONOTON	1	PCB	1
37	WELDONOTON	1	PCB	1
38	WELDONOTON	1	PCB	1
39	WELDONOTON	1	PCB	1
40	WELDONOTON	1	PCB	1
41	WELDONOTON	1	PCB	1
42	WELDONOTON	1	PCB	1
43	WELDONOTON	1	PCB	1
44	WELDONOTON	1	PCB	1
45	WELDONOTON	1	PCB	1
46	WELDONOTON	1	PCB	1
47	WELDONOTON	1	PCB	1
48	WELDONOTON	1	PCB	1
49	WELDONOTON	1	PCB	1
50	WELDONOTON	1	PCB	1
51	WELDONOTON	1	PCB	1
52	WELDONOTON	1	PCB	1
53	WELDONOTON	1	PCB	1
54	WELDONOTON	1	PCB	1
55	WELDONOTON	1	PCB	1
56	WELDONOTON	1	PCB	1
57	WELDONOTON	1	PCB	1
58	WELDONOTON	1	PCB	1
59	WELDONOTON	1	PCB	1
60	WELDONOTON	1	PCB	1
61	WELDONOTON	1	PCB	1
62	WELDONOTON	1	PCB	1
63	WELDONOTON	1	PCB	1
64	WELDONOTON	1	PCB	1
65	WELDONOTON	1	PCB	1
66	WELDONOTON	1	PCB	1
67	WELDONOTON	1	PCB	1
68	WELDONOTON	1	PCB	1
69	WELDONOTON	1	PCB	1
70	WELDONOTON	1	PCB	1
71	WELDONOTON	1	PCB	1
72	WELDONOTON	1	PCB	1
73	WELDONOTON	1	PCB	1
74	WELDONOTON	1	PCB	1
75	WELDONOTON	1	PCB	1
76	WELDONOTON	1	PCB	1
77	WELDONOTON	1	PCB	1
78	WELDONOTON	1	PCB	1
79	WELDONOTON	1	PCB	1
80	WELDONOTON	1	PCB	1
81	WELDONOTON	1	PCB	1
82	WELDONOTON	1	PCB	1
83	WELDONOTON	1	PCB	1
84	WELDONOTON	1	PCB	1
85	WELDONOTON	1	PCB	1
86	WELDONOTON	1	PCB	1
87	WELDONOTON	1	PCB	1
88	WELDONOTON	1	PCB	1
89	WELDONOTON	1	PCB	1
90	WELDONOTON	1	PCB	1
91	WELDONOTON	1	PCB	1
92	WELDONOTON	1	PCB	1
93	WELDONOTON	1	PCB	1
94	WELDONOTON	1	PCB	1
95	WELDONOTON	1	PCB	1
96	WELDONOTON	1	PCB	1
97	WELDONOTON	1	PCB	1
98	WELDONOTON	1	PCB	1
99	WELDONOTON	1	PCB	1
100	WELDONOTON	1	PCB	1

ITEM NO.	DESCRIPTION	QTY	UNIT	REVISIONS
1	WELDONOTON	1	PCB	1
2	WELDONOTON	1	PCB	1
3	WELDONOTON	1	PCB	1
4	WELDONOTON	1	PCB	1
5	WELDONOTON	1	PCB	1
6	WELDONOTON	1	PCB	1
7	WELDONOTON	1	PCB	1
8	WELDONOTON	1	PCB	1
9	WELDONOTON	1	PCB	1
10	WELDONOTON	1	PCB	1
11	WELDONOTON	1	PCB	1
12	WELDONOTON	1	PCB	1
13	WELDONOTON	1	PCB	1
14	WELDONOTON	1	PCB	1
15	WELDONOTON	1	PCB	1
16	WELDONOTON	1	PCB	1
17	WELDONOTON	1	PCB	1
18	WELDONOTON	1	PCB	1
19	WELDONOTON	1	PCB	1
20	WELDONOTON	1	PCB	1
21	WELDONOTON	1	PCB	1
22	WELDONOTON	1	PCB	1
23	WELDONOTON	1	PCB	1
24	WELDONOTON	1	PCB	1
25	WELDONOTON	1	PCB	1
26	WELDONOTON	1	PCB	1
27	WELDONOTON	1	PCB	1
28	WELDONOTON	1	PCB	1
29	WELDONOTON	1	PCB	1
30	WELDONOTON	1	PCB	1
31	WELDONOTON	1	PCB	1
32	WELDONOTON	1	PCB	1
33	WELDONOTON	1	PCB	1
34	WELDONOTON	1	PCB	1
35	WELDONOTON	1	PCB	1
36	WELDONOTON	1	PCB	1
37	WELDONOTON	1	PCB	1
38	WELDONOTON	1	PCB	1
39	WELDONOTON	1	PCB	1
40	WELDONOTON	1	PCB	1
41	WELDONOTON	1	PCB	1
42	WELDONOTON	1	PCB	1
43	WELDONOTON	1	PCB	1
44	WELDONOTON	1	PCB	1
45	WELDONOTON	1	PCB	1
46	WELDONOTON	1	PCB	1
47	WELDONOTON	1	PCB	1
48	WELDONOTON	1	PCB	1
49	WELDONOTON	1	PCB	1
50	WELDONOTON	1	PCB	1
51	WELDONOTON	1	PCB	1
52	WELDONOTON	1	PCB	1
53	WELDONOTON	1	PCB	1
54	WELDONOTON	1	PCB	1
55	WELDONOTON	1	PCB	1
56	WELDONOTON	1	PCB	1
57	WELDONOTON	1	PCB	1
58	WELDONOTON	1	PCB	1
59	WELDONOTON	1	PCB	1
60	WELDONOTON	1	PCB	1
61	WELDONOTON	1	PCB	1
62	WELDONOTON	1	PCB	1
63	WELDONOTON	1	PCB	1
64	WELDONOTON	1	PCB	1
65	WELDONOTON	1	PCB	1
66	WELDONOTON	1	PCB	1
67	WELDONOTON	1	PCB	1
68	WELDONOTON	1	PCB	1
69	WELDONOTON	1	PCB	1
70	WELDONOTON	1	PCB	1
71	WELDONOTON	1	PCB	1
72	WELDONOTON	1	PCB	1
73	WELDONOTON	1	PCB	1
74	WELDONOTON	1	PCB	1
75	WELDONOTON	1	PCB	1
76	WELDONOTON	1	PCB	1
77	WELDONOTON	1	PCB	1
78	WELDONOTON	1	PCB	1
79	WELDONOTON	1	PCB	1
80	WELDONOTON	1	PCB	1
81	WELDONOTON	1	PCB	1
82	WELDONOTON	1	PCB	1
83	WELDONOTON	1	PCB	1
84	WELDONOTON	1	PCB	1
85	WELDONOTON	1	PCB	1
86	WELDONOTON	1	PCB	1
87	WELDONOTON	1	PCB	1
88	WELDONOTON	1	PCB	1
89	WELDONOTON	1	PCB	1
90	WELDONOTON	1	PCB	1
91	WELDONOTON	1	PCB	1
92	WELDONOTON	1	PCB	1
93	WELDONOTON	1	PCB	1
94	WELDONOTON	1	PCB	1
95	WELDONOTON	1	PCB	1
96	WELDONOTON	1	PCB	1
97	WELDONOTON	1	PCB	1
98	WELDONOTON	1	PCB	1
99	WELDONOTON	1	PCB	1
100	WELDONOTON	1	PCB	1

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

1532 So. Washington Avenue
Piscataway, NJ 08855

	K3
5301	
5302	CX4158
5303	
5312	CX4159
5313	

FOR A MODEL USE MR-1939 INSTEAD OF
MR-1773 FOR CONVEYOR MOTOR.

LAST WIDE MINDED USE 0:50

PARTS LIST			
ITEM NO	FIELD NO	NOMENCLATURE	NO. REQ
F12	FZ033	FUSE - CONTROL CKT	2
S1	CW170	CIRCUIT BREAKER - MAIN CONTROL	1
S2,5	SW018A	SWITCH, PUSHBUTTON - STOP	2
	CK0118C	CONTACT BLOCK (N.C.) STOP PUSH BUTTON	2
S3,4	SW018B	SWITCH, PUSHBUTTON - START	2
	CK0118E	CONTACT BLOCK (N.O.) START PUSH BUTTON	2
S4,9	SW0202	SWITCH LIMIT - SAFETY O/R, PULSE CON. DELAY	3
STA6C	SW075B	SWITCH LIMIT - SAFETY SYSTEM	3
S11	RH102	SWITCH, TAP - ELEMENT CONTROL	1
S14	SW1240	SWITCH, TOGGLE - POLY	1
PL1	LT0606	PILOT LIGHT - POWER ON	1
B1	BZ0306A	BUZZER	1
SOL1	VA0574	VALVE SOLENOID - HEAD CONTROL	1
J1	PG1035	RECEPTACLE - VACUUM SYSTEM	1
K1	SW1195	RELAY (220V) CONTROL CIRCUIT	1
K2,K5	SW1123	RELAY (24V) SAFETY & COMPENSATOR CKT	2
K3		HEAT - CONTROL CIRCUIT (SEE CHART)	1
M1	MR1513	MOTOR - CONVEYOR DRIVE	1
CAP1	CC1944	CAPACITOR - CONVEYOR DRIVE MOTOR	1
TR1,2	TM3915	TIMER - DWELL, CONVEYOR	2
P1	PS0528	PLUG - VACUUM SYSTEM	1
P2	PS0508	PLUG - POWER	1
TR,4	TR9249	TRANSFORMER - SAFETY & COMPENSATOR CKT	2
T2		TRANSFORMER (SEE CHART)	1
K4	SW195	RELAY (220V) - CONTROL CIRCUIT	1
F3,4	FZ1553	FUSE 10A	2
HP	MP2734	HOLE PUNCH ASSY	1
S17	SW0725	LIMIT SWITCH - DANCER	1
M3	MR1940	MOTOR - FILM FEED	1

SIZE	PART NO	REV
C	5300-8211	1

3	DNIG. UPDATED	NO 500	Ref 5-12-79
2	REMOVED: 512 (SW-0015) FJ2 (PG-1561)	E179	AS 2-15-79
1	CHANGED RI.F2 FROM R2 1053 TO R2-1058, REMOVED SW 1504, PG-1550 NR-0591, DUE TO HIGH VAC. SPILLIN	1772	DC 1-17-79
SYM	DESCRIPTION	ECO NO.	DATE, gy
REVISIONS			
ORIN	FCB	DATE	1-1-79
CHG	DATE		
APP	DATE		
WFL	DATE		
FINISH	DATE		
FOR: LABELS, CAPTIONS FRA DEC AN-12 T-151 - RW - 10"			
C 5000-0011		3	