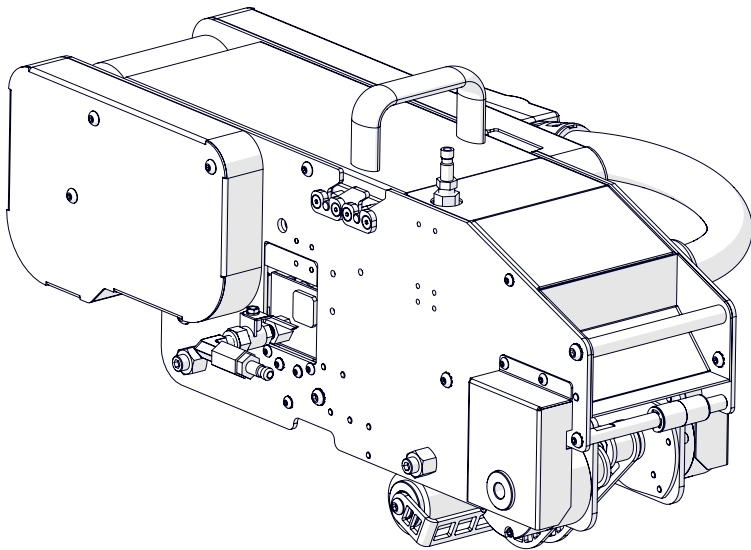




# USER MANUAL WAT TOP TAPE HEAD 24V



For Serial Numbers:  
W130 XXX XXX



[www.itape.com](http://www.itape.com)  
800-474-8273

intertape  
polymer  
group®



# User Notes

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# TECHNICAL ASSISTANCE

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This is the Interpack Model **AUTO H2O Top Tape Head 24v** you ordered. It has been set up and tested in our factory with Intertape manufactured water activated tapes. If any problems occur when setting up or operating this equipment, please contact the authorized distributor from where you purchased this item.

If contact with the authorized distributor is not possible, **IPG Machinery Support** is available. Should the need to contact **IPG Machinery Support** arise, **please have the equipment model and serial number available prior to contact**. This information can be found on the nameplate of the tape head as well as on the machine, both sets of information may be necessary to assist. A section at the bottom of this page is available to write this information down. **IPG Machinery Support** is available during normal business hours (M-F 8am-5pm) Eastern Time.

Phone: 813-345-3070

Email: [machsupp@itape.com](mailto:machsupp@itape.com)

## Replacement Parts

Thank you for participating in the Beta Trials for this newly designed tape head. Should you need any replacement parts please contact IPG Machinery Support 813-345-3070

Please use this area to enter the detailed information on your Case Sealer and Tape Heads. This should be filled out at the time of install. This information can be found on the nameplate of the machine, typically on the side the electrical box is on. On pressure sensitive tape the nameplate is located on the same side the tape is loaded from. On the WAT Tape Heads serial information can be found on the side frame.

### Machine

Model

Serial

Distributor  
Name

Phone/Email

### Tape Head Top

Model

Serial

### Tape Head Bottom (if applicable)

Model

Serial

Date of Purchase

Date of Install



# FIELD SERVICE ASSISTANCE

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Your Interpack Case Sealer and Tape Heads are designed to provide years of trouble free operation. This is not without proper preventative maintenance. A recommended schedule can be located in the maintenance section of this manual, performed by then end user of the equipment. If any problems arise with this machine during the normal course of operation, your properly trained and qualified internal service personnel should be able to repair any issues after consulting the troubleshooting section of this manual in conjunction with phone and/or email support from IPG Machinery Support.

Field Service Support is available from your IPG Authorized Distributor at additional cost if the problem cannot be remedied after consulting the troubleshooting section of this manual.

IPG offers comprehensive programs that help keep your equipment up and running.

Proactive maintenance efforts help to prevent equipment failures and costly emergency repairs. Keeping your machine in optimal working condition also enhances employee safety, reduces facility downtime and efficiently allocates internal resources.

Please contact your IPG Representative to discuss the best options for your IPG equipment.

# WARRANTY INFORMATION

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**EQUIPMENT WARRANTY AND LIMITED REMEDY:** The following warranty is made in lieu of all other warranties, express or implied, including, but not limited to, the implied warranty of merchantability, the implied warranty of fitness for a particular purpose, and any implied warranty arising out of a course of dealing, a custom or usage of trade:

Intertape sells its Interpack Tape Heads, Case Tapers and Case Erectors with the following warranties:

1. The IPG Pressure Sensitive Tape Heads' knife blades, springs and wipe down rollers will be free from all defects for a period of ninety (90) days.
2. All other IPG Pressure Sensitive Tape Head parts will be free from all defects for one (1) year after delivery.
3. Water Activated Tape Heads' blades will be free from defects for ninety (90) days after delivery.
4. Drive Belts will be free from defects for ninety (90) days after delivery.
5. The Gear Motors will be free from defects for one (1) year after delivery.
6. All other components for Case Tapers and Case Erectors will be free from defects for one (1) year after delivery.

If any part is proven defective within its warranty period, then the exclusive remedy and Intertape's and the seller's sole obligation shall be, at Intertape's option, to repair or replace the part, provided the defective part is returned immediately to Intertape's factory or an authorized service station designated by Intertape.

A part will be presumed to have become defective after its warranty period unless the part is received or Intertape is notified of the problem no later than five (5) calendar days after the warranty period.

If Intertape is unable to repair or replace the part within a reasonable time, then Intertape, at its option, will replace the equipment or refund the purchase price. Intertape shall have no obligation to install the repaired or replacement part.

Intertape shall have no obligation to provide or pay for the labor required to install the repaired or replacement part.

Intertape shall have no obligation to repair or replace (1) those parts failing due to: operator misuse, carelessness, or due to any accidental cause other than equipment failure, or (2) parts

1. Failure or damage is due to misapplication, lack of proper maintenance, abuse, improper installation or abnormal conditions such as temperature, moisture, dirt or corrosive matter, etc.
2. Failure due to inadequate cleaning, improper operating environment, improper utilities or operator error.
3. Failure due to operations above the rated capacities, or in any other improper manner, either intentional or otherwise.
4. Failure is due to equipment, which has been altered by anyone other than an authorized representative of Intertape Polymer Group.
5. Failure is due to an attempt by the purchaser to correct alleged defective equipment. In this event the purchaser is responsible for all expenses incurred.

**LIMITATION OF LIABILITY:** Intertape and seller shall not be liable for direct, indirect, special, incidental or consequential damages based upon breach of warranty, breach of contract, negligence, strict liability or any other legal theory.

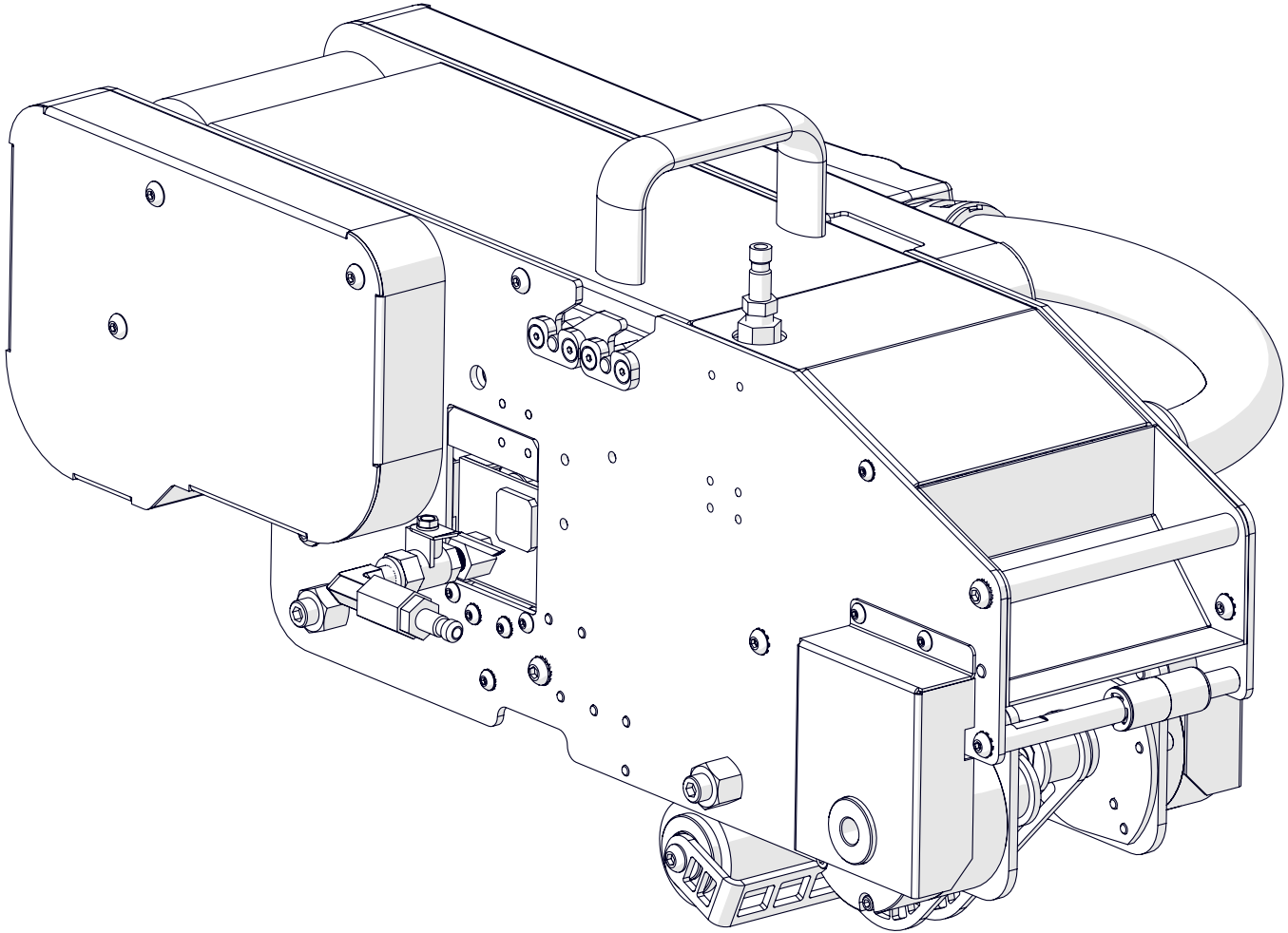
The foregoing Equipment Warranty and Limited Remedy and Limitation of Liability may be changed only by written agreement signed by authorized officers of Intertape and seller.

# GENERAL INFORMATION

## Description of WAT Tape Head Top 24v

The Interpack WAT Tape Heads are designed to apply Intertape brand WAT carton sealing tape to the top and/or bottom center seams of regular slotted corrugated (RSC) cartons. It can be configured into all Interpack WAT case sealers.

These are designed to be direct drop in replacements for the first generation of WAT Tape Heads.



**Figure 1: WAT Top Tape Head**

## Definitions

Common terms that will be used throughout this manual.

**WAT** – Intertape Branded Water Activated Tape

**Tape Head** – This will refer to the WAT Tape Heads for the remainder of this manual

**Case Sealer** – Refers to IPG manufactured Case Sealers

**Machine System** – Refers to the fully assembled Case Sealer with the Tape Head(s) installed

**User/Operator** – The individual who has been trained on the daily use of the Machine System

**Maintenance Champion** – The individual(s) who work for the end user of the Machine System who are responsible for conducting general and preventative maintenance

# IMPORTANT SAFEGUARDS

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There are a number of safety labels used on the WAT Top Tape Head. These labels are placed at different locations on the tape head to warn operators and service personnel of possible dangers (refer to Figure 3). Please read the labels on the machine and the following safety precautions before using the machine.

**Read this manual for other important safety operating and service information.**

**Only trained personnel are to operate machine.**

**Only fully qualified technicians are to service this tape head.**

**Wear safety glasses.**

**Shut off power to machine before adjusting machine or loading & threading Tape Heads.**

**Disconnect electrical power and compressed air (where applicable) before servicing.**

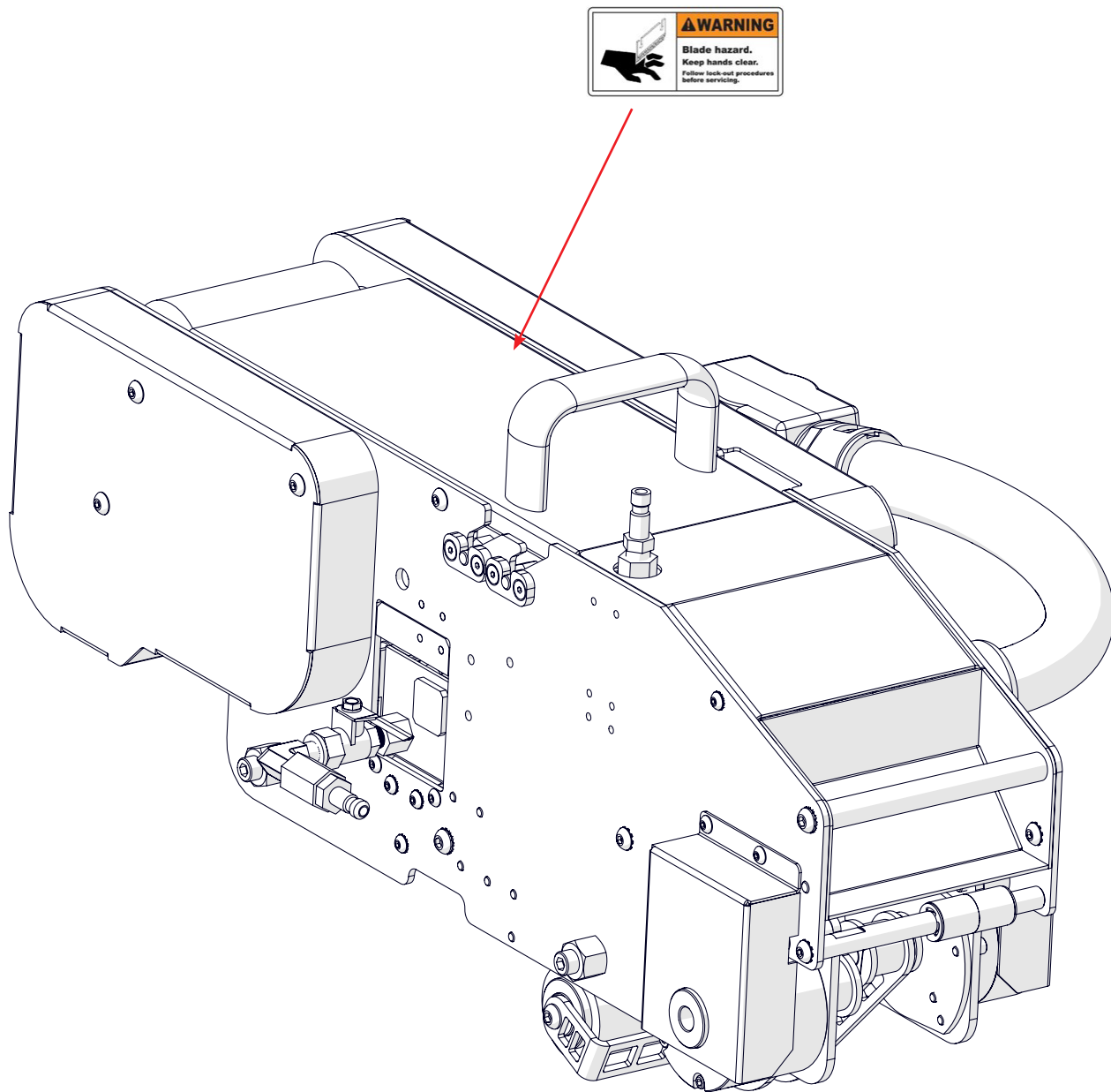
**Follow Lock Out / Tag Out Procedures BEFORE servicing any machinery.**

**All factory installed covers and guards must be in place before operating.**

**Stay clear of moving parts which can shear and cut.**

Should any of the safety labels on the WAT Top Tape Head be damaged or destroyed, replacements can be ordered through your distributor.

# SAFETY LABEL PLACEMENT



**Figure 2: Safety Label Placement**

# SAFETY LABEL DESCRIPTIONS

The label shown is affixed to the upper tape head assembly on both sides of the machine.

It warns operators and service personnel of the presence of the cutting blade that may not be visible. Caution should be exercised when approaching this area.



**Figure 3: Blade Hazzard**

Should any of the safety labels on the Case Sealer be damaged or destroyed, replacements can be ordered through your distributor.

# IMPORTANT SAFEGUARDS

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## Explanation of Signal Word Consequences



**WARNING: INDICATES A POTENTIALLY HAZARDOUS SITUATION, WHICH IF NOT AVOIDED COULD RESULT IN DEATH OR SERIOUS INJURY OR PROPERTY DAMAGE**



**CAUTION: INDICATES A POTENTIALLY HAZARDOUS SITUATION, WHICH IF NOT AVOIDED COULD RESULT IN MINOR OR MODERATE INJURY OR PROPERTY DAMAGE**



### **WARNING**

1. **To reduce the risk associated with mechanical, pneumatic, and electrical hazards:**
  - Read, understand, and follow all safety and operating instructions before operating or servicing the Case Sealer and/or Tape Head(s)
  - Allow only properly trained and qualified personnel to operate and service this equipment
2. **To reduce the risk associated with pinches, entanglement, and hazardous voltage:**
  - Turn electrical supply off and disconnect before performing any adjustments, maintenance, or servicing the Case Sealer or Tape Head
3. **To reduce the risk associated with pinches and entanglement hazards:**
  - Do not leave the Case Sealer running while unattended
  - Turn the Case Sealer off when not in use
  - Never attempt to work on any part of the Case Sealer, Tape Head, load tape, or remove jammed boxes from the Case Sealer while the machine is running
4. **To reduce the risk associated with hazardous voltage**
  - Position electrical cord away from foot traffic and vehicle traffic
  - Do not operate the Case Sealer with a damaged power cord
5. **To reduce the risk associated with sharp blades hazards:**
  - Keep hand and fingers away from the tape cutoff blades, the blades are very sharp
6. **To reduce the risk associated with fire and explosion hazards:**
  - Do not operate this equipment in potentially flammable and/or explosive environments
7. **To reduce the risk associated with muscle strain:**
  - Use the appropriate rigging and material handling equipment when lifting or repositioning this equipment
  - Use proper body mechanics when removing or installing Tape Heads that are moderately heavy or may be considered awkward to lift
8. **To reduce the risk associated with mechanical, pneumatic, and electrical hazards:**
  - Allow only properly trained and qualified personnel to operate and service this equipment



### **CAUTION**

1. **To reduce the risk associated with pinch hazards:**
  - Keep hands clear of the upper head support assembly as boxes are transported through the Case Sealer
  - Keep hands, hair, loose clothing, and jewelry away from box compression rollers, moving belts, and Tape Heads
  - Always feed boxes into the Case Sealer by pushing only from the end of the box



**PROPER LOCK OUT TAG OUT IS COMPLETED BY DISCONNECTING THE TAPE HEAD FROM ALL ENERGY SOURCES.**



# IMPORTANT SAFEGUARDS

## Operator Skill Level Descriptions

These descriptions and levels are uniform across all IPG Case Sealers

### **Skill “A” Machine Operator**

This operator is trained to use the Case Sealer with the machine controls, to feed cases into the machine, make adjustments for different case sizes (USA series machines), to change tape, to start, stop, and restart production, and to clear jams and perform basic troubleshooting.

**Important:** *The end user area supervisor must ensure that the operator has been properly trained on all machine functions before operating the machine.*

### **Skill “B” Mechanical Maintenance Technician**

Also referred to as the Maintenance Champion, this technician, is trained to use the Case Sealer as the Operator is able and in addition is able to work with the safety protection disconnected to check and adjust mechanical components, to perform maintenance operations and repair the Case Sealer. A skill “B” operator is not allowed to work on live electrical components.

### **Skill “C” Electrical Maintenance Technician**

This technician is trained to use the Case Sealer as the Operator is able and in addition is able to work with the safety protection disconnected, to check and adjust mechanical components, to perform maintenance operations and repair the Case Sealer. A skill “C” operator is allowed to work on live electrical panels, terminal blocks, and control equipment.

### **Skill “D” Manufacturer Technician**

Skilled technician sent by the manufacturer or its agent (distributors) to perform complex repairs of modifications, when agreed with the customer.

### **Operators skill level required to perform the following tasks on the Machine System**

OPERATION	MACHINE CONDITION	OPERATOR SKILL LEVEL	NUMBER OF OPERATORS
Tape Roll Replacement	Stopped by pressing the Emergency Stop Button	A	1
Blade Replacement	Electrical Power Disconnected	B	1
Ordinary Maintenance and Preventative Maintenance	Electrical Power Disconnected	B	1
Extraordinary Mechanical Maintenance	Running with Safety Protections Disabled	C	1
Extraordinary Electrical Maintenance	Running with Safety Protections Disabled	D	1
Machine Installation & Set-Up	Running with Safety Protections Disabled	B & C	2

**Proper Electrical Disconnect is achieved when the machine is unplugged from the electrical socket.**

# SPECIFICATIONS

## WAT Top Tape Head Dimensions

Tape Head Weight: 36 lbs. (16kg)

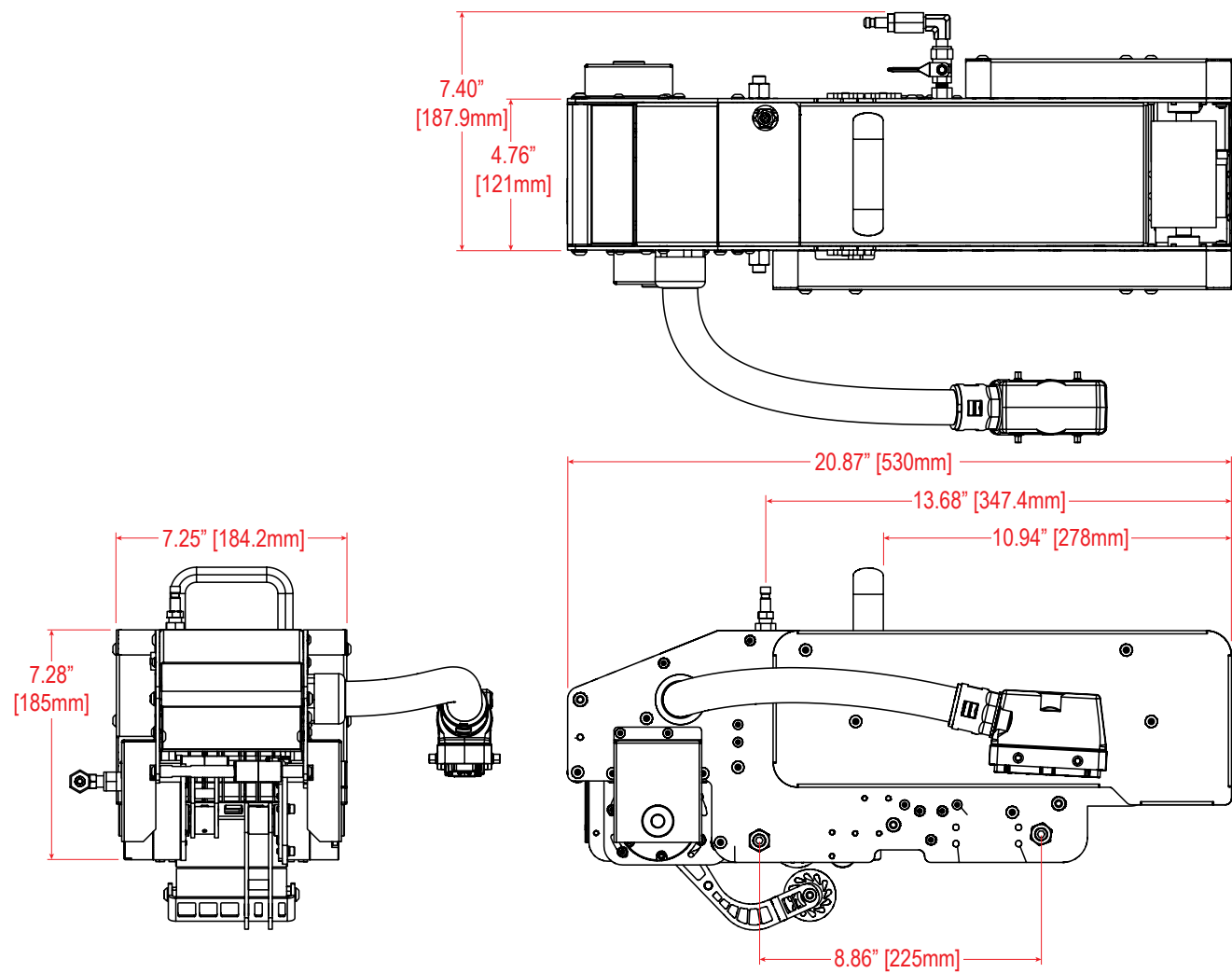
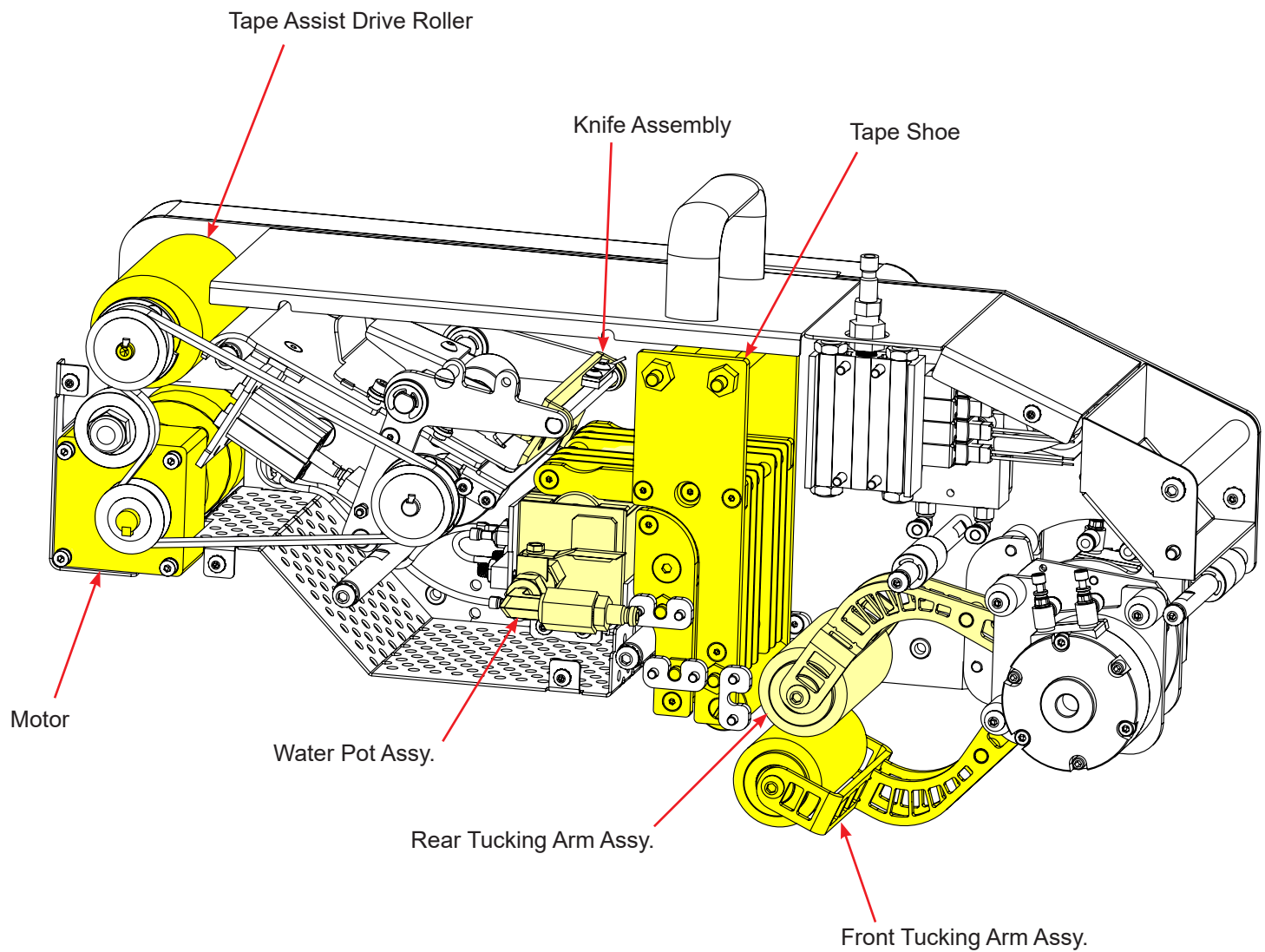


Figure 4: WAT Top Tape Head Dimensions

# SPECIFICATIONS

## Machine Components



**Figure 5: Major Components**

# **SPECIFICATIONS**

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## **Power Requirements**

Electrical: **24v, 5A (120 Watts) DC Supplied from Machine**

This tape head comes standard with a BLDC motor, four pneumatic actuators, and a 24v 60W heater.

Power is supplied through an industrial 16 pin connector.

## **Pneumatic Requirements**

Compressed Air: 9CFM at 75 PSI (28.3 Liter/min at 517 kPa) Supplied From Machine

This tape head comes standard with two regulators, three pneumatic solenoid valves, and three pneumatic actuators.

Air must be clean and dry. If moisture enters the system valves can begin to degrade and lines slowly clog. This can cause reduced flow resulting in undesired machine behavior.

## **Operating Speed**

IPG Machine belt speed is 82 ft/min unless otherwise specified. All WAT Tape Head information is based off of standard IPG WAT Case Sealer information.

## **Tape Specifications**

Use only **IPG Water-Activated Tape**. IPG Machines can accommodate tape widths of 3 in. (70 - 75mm).

Consult the machine manual for additional tape specifications.

## **Operating Conditions**

Use in a dry, relatively clean environment at 40° to 105° F (5° to 40° C) with clean dry cartons. Maximum sound pressure level is less than 70dBA.



**CAUTION: TAPE HEAD SHOULD NOT BE WASHED DOWN OR SUBJECTED TO CONDITIONS CAUSING CONDENSATION ON COMPONENTS.**



**CAUTION: TO PREVENT INJURY KEEP AN AREA OF SPACE CLEAR, CLEAN, AND DRY ON THE OPERATOR AND CONTROL BOX SIDES OF THE MACHINE. CONSULT THE MACHINE MANUAL FOR MORE SPECIFIC INFORMATION.**

## **Carton Specifications**

Please consult the User Manual for the machine your tape head is installed into for all carton specifications.

However, if the box length (in the direction of the seal) to box height ratio is 0.75 or less, several boxes should be test run to assure proper machine performance. The formula is as follows:

$$\frac{\text{Carton Length in direction of seal}}{\text{Carton Height}} > 0.75$$

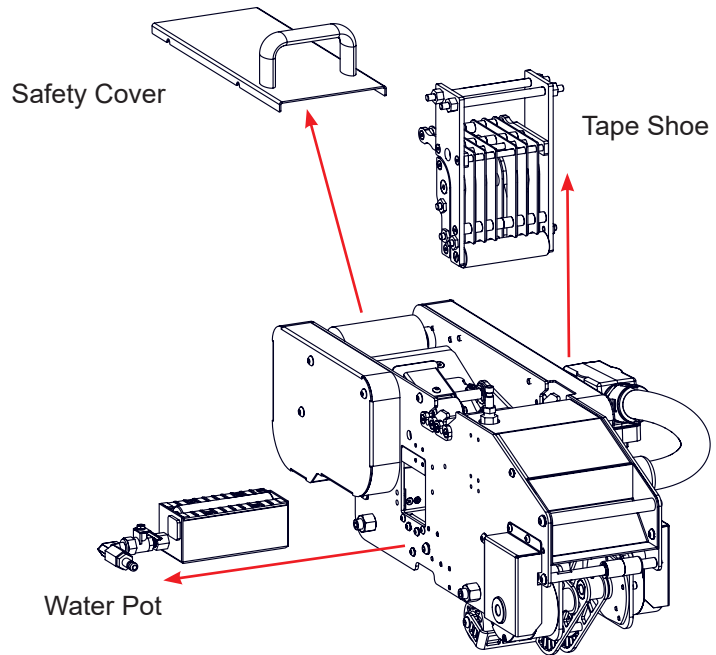
# PREVENTATIVE MAINTENANCE

## Cleaning and Changing the Blade

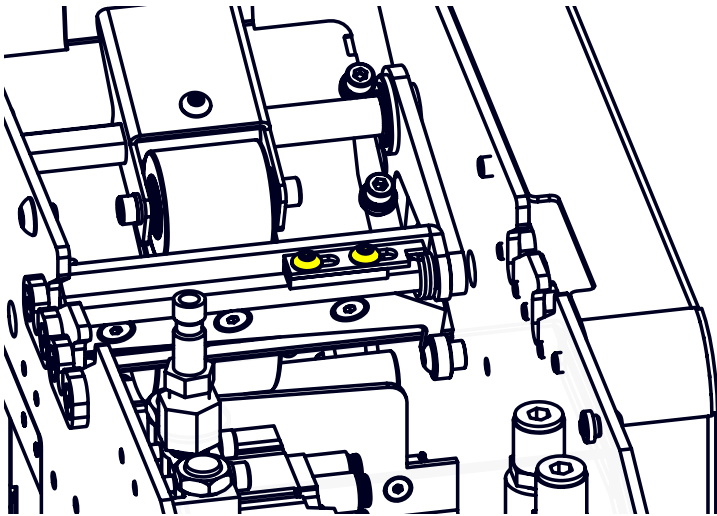
1. Disconnect the machine and tape head from all energy sources
2. Remove the safety cover
3. Remove the water pot
4. Remove the tape shoe
5. Loosen the two (2) screws securing the torsion spring in place
6. Remove the right side cover
7. Using the access hole unscrew the blade shaft
8. Remove the blade shaft (use caution not to lose the torsion spring)
9. Lift the blade assembly out from the tape head
10. Remove the three (3) screws securing the blade **USE CAUTION AS THE BLADE CAN STILL BE SHARP**



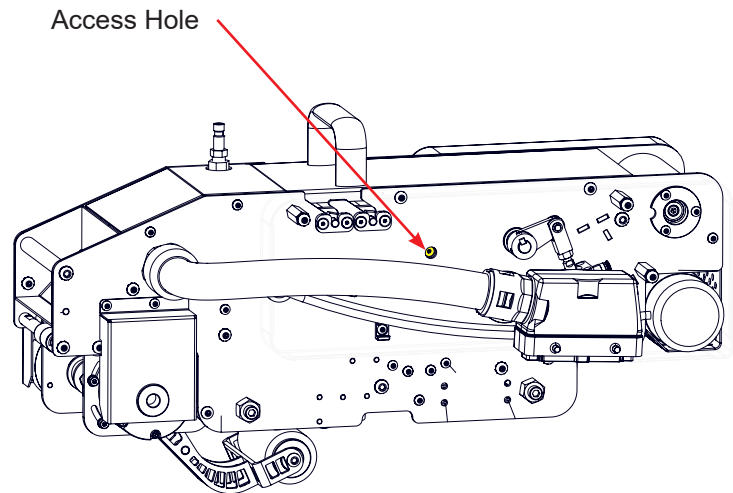
**WARNING: THE KNIFE CONTAINED IN THE TAPE HEADS IS EXTREMELY SHARP. USE CAUTION WHEN THREADING THE TAPE OR PERFORMING MAINTENANCE TO AVOID INJURY.**



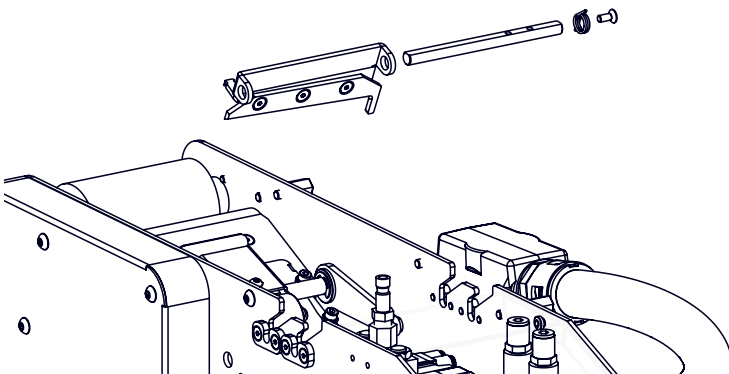
**Figure 6: Component Removal**



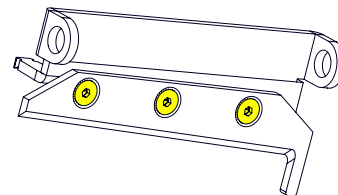
**Figure 7: Torsion Spring Retainer**



**Figure 8: Blade Access Port**



**Figure 9: Blade Removal**



**Figure 10: Blade**

# PREVENTATIVE MAINTENANCE

## Cleaning and Changing the Application Rollers

1. Disconnect the machine and tape head from all energy sources
2. Without air pressure the rollers will hang freely
3. Remove the two (2) screws securing the roller to the arm, these will need to be done simultaneously.
4. Once removed the black roller is easily separated from the internal shaft and spacers.
5. The roller can now be replaced or thoroughly cleaned using soap and water

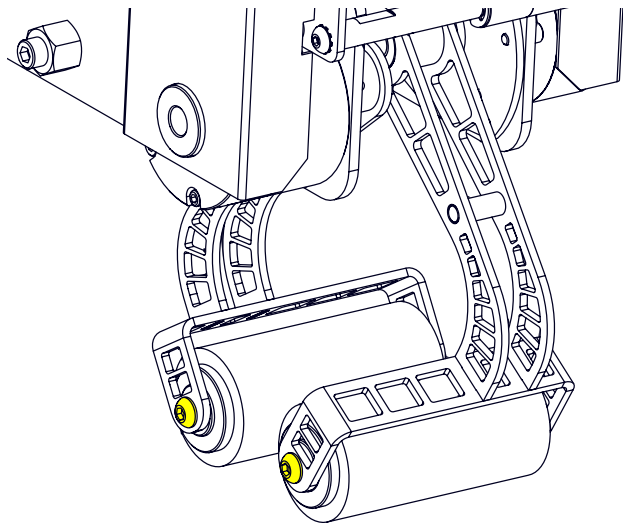


Figure 11: Application Roller Screws

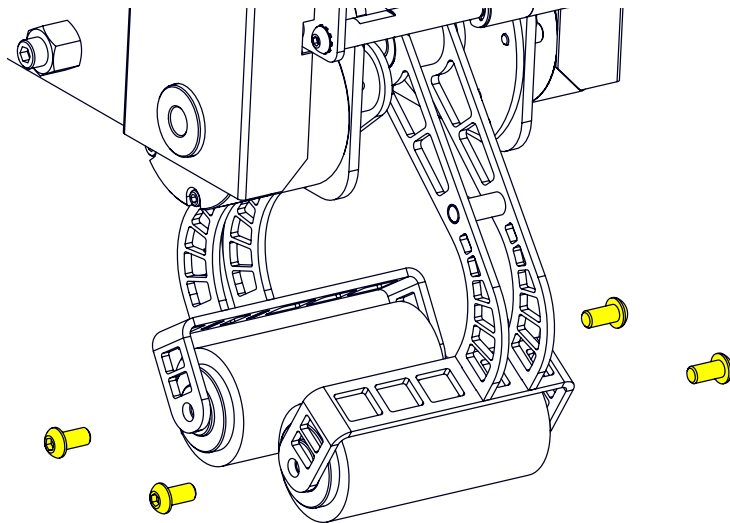


Figure 12: Application Screw Removal

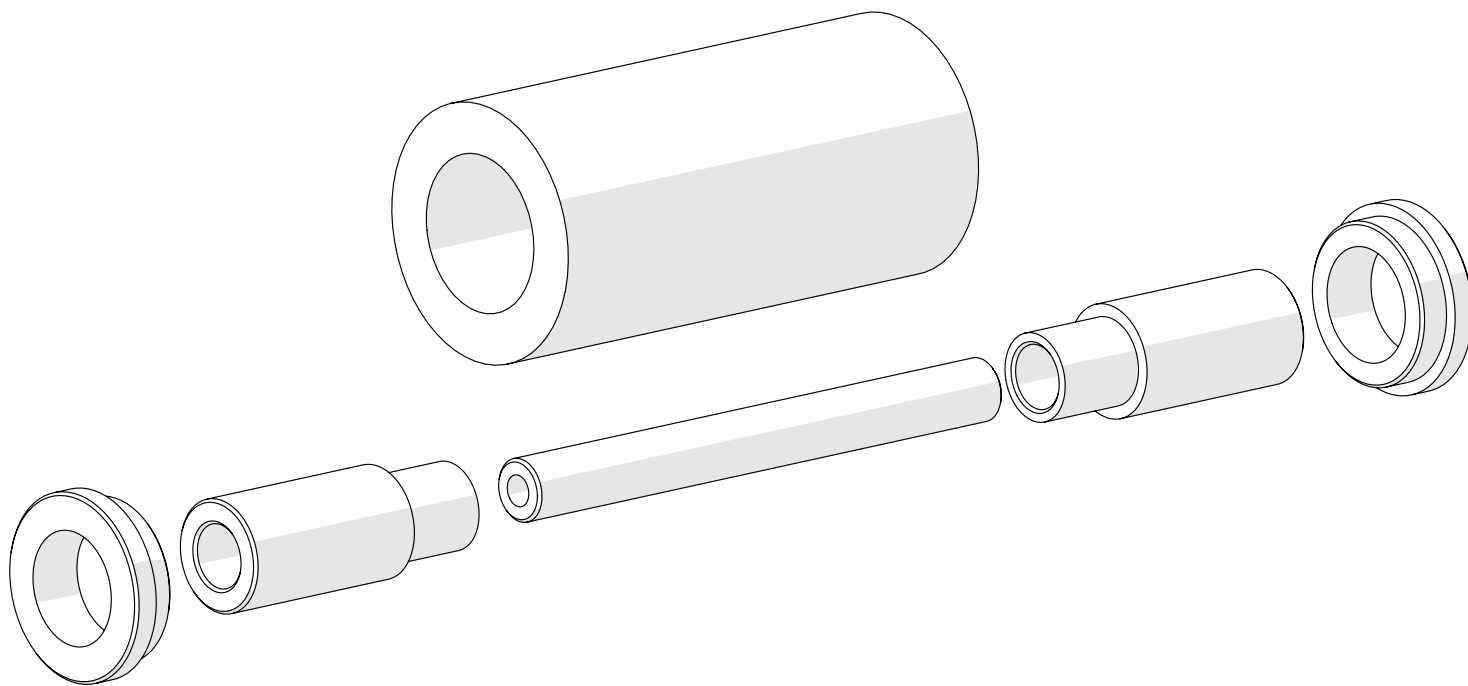


Figure 13: Application Roller Shaft

# TROUBLESHOOTING

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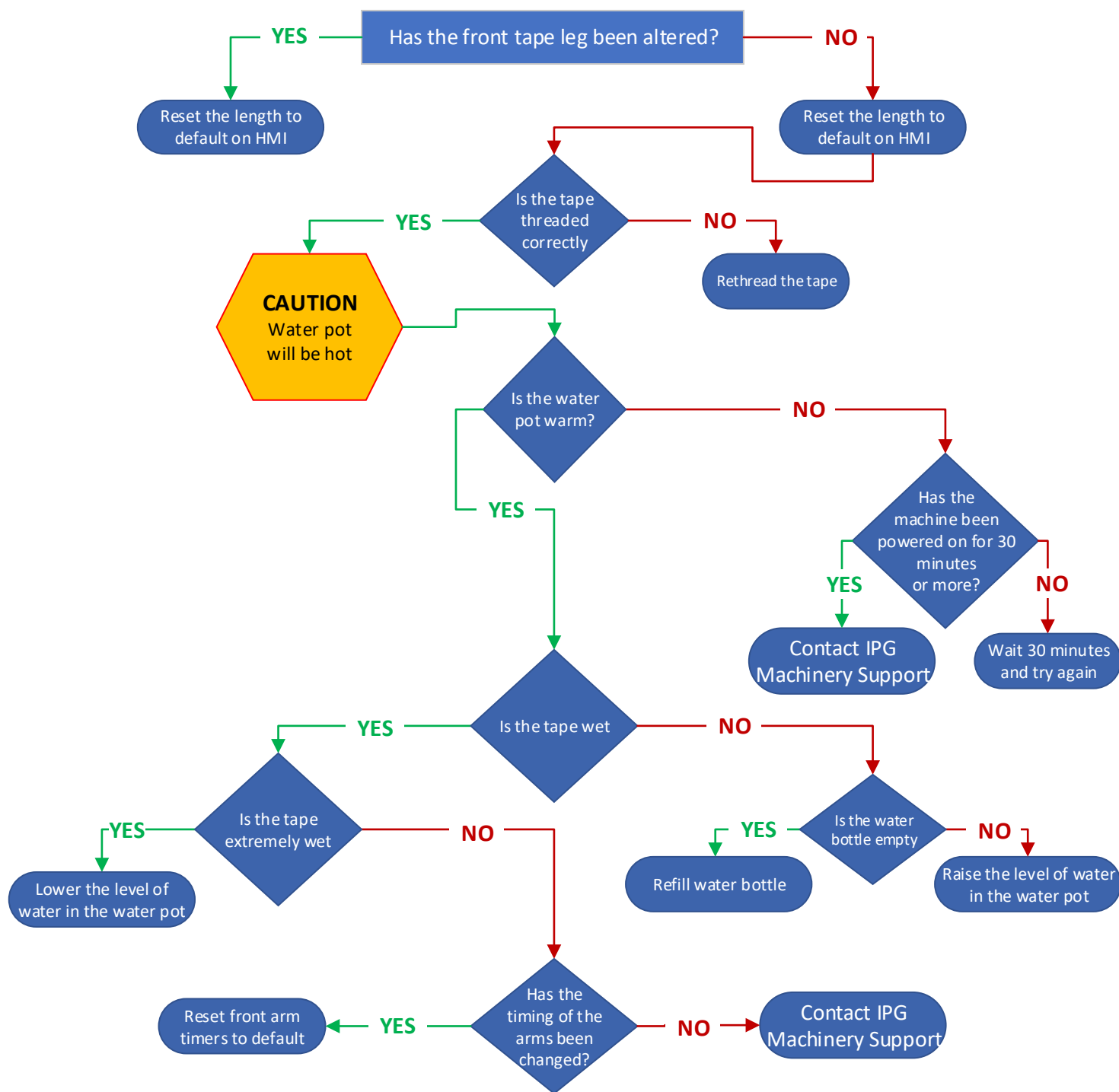
The WAT Top Tape Head is fabricated with high quality components that provide trouble-free operation for a long period of time. However, should a problem occur, we recommend that you consult the following guide. If the problem you encounter is not discussed in this guide, call Interpack Technical Support.

Most troubleshooting can be accomplished over the phone with IPG technical support and will require access to the machine's HMI screen.

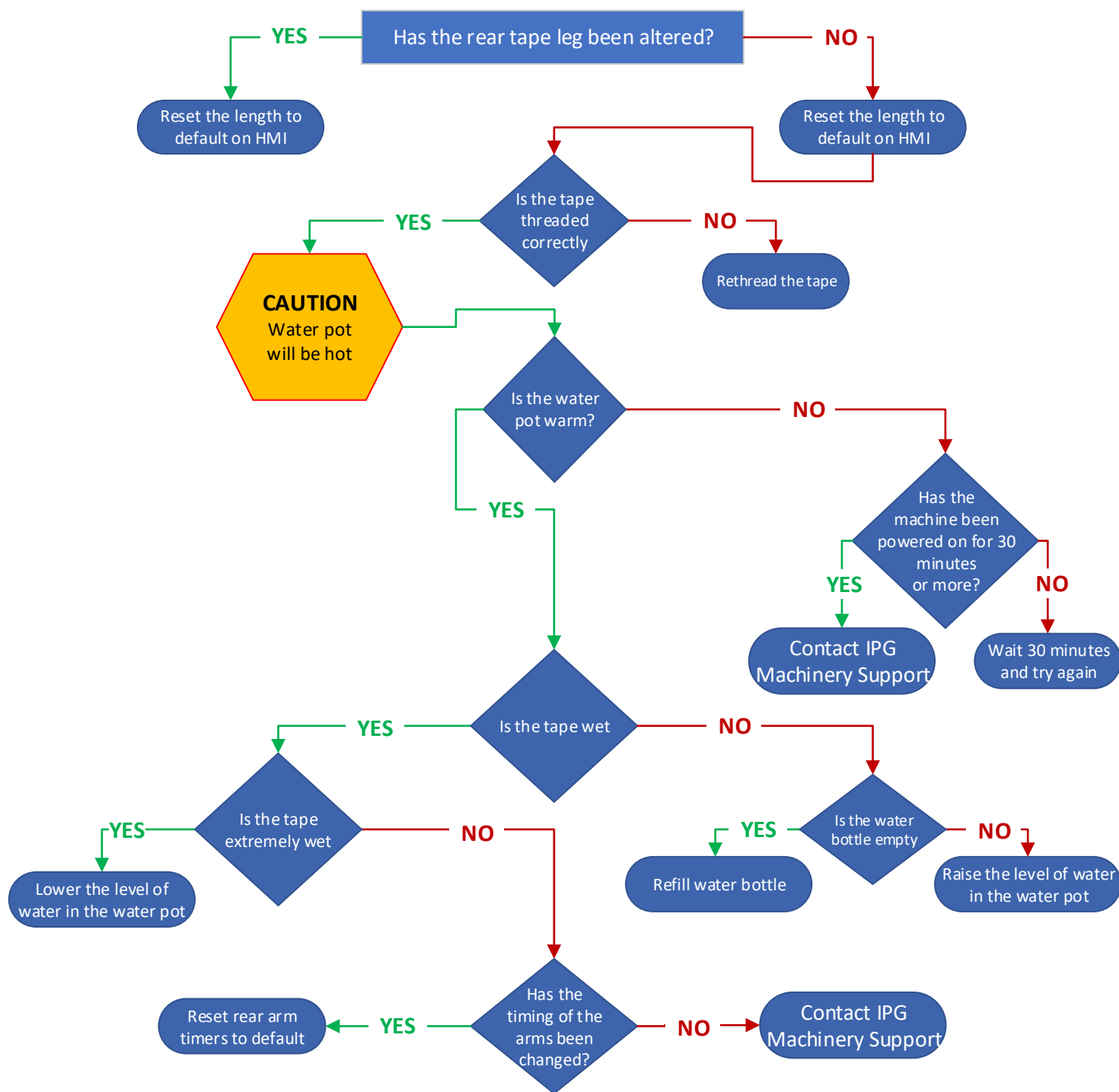
Should this WAT Tape Head be adapted into any machine that is not manufactured by IPG there may be discrepancies in the following guides.



## Front Tape Leg Not Sticking

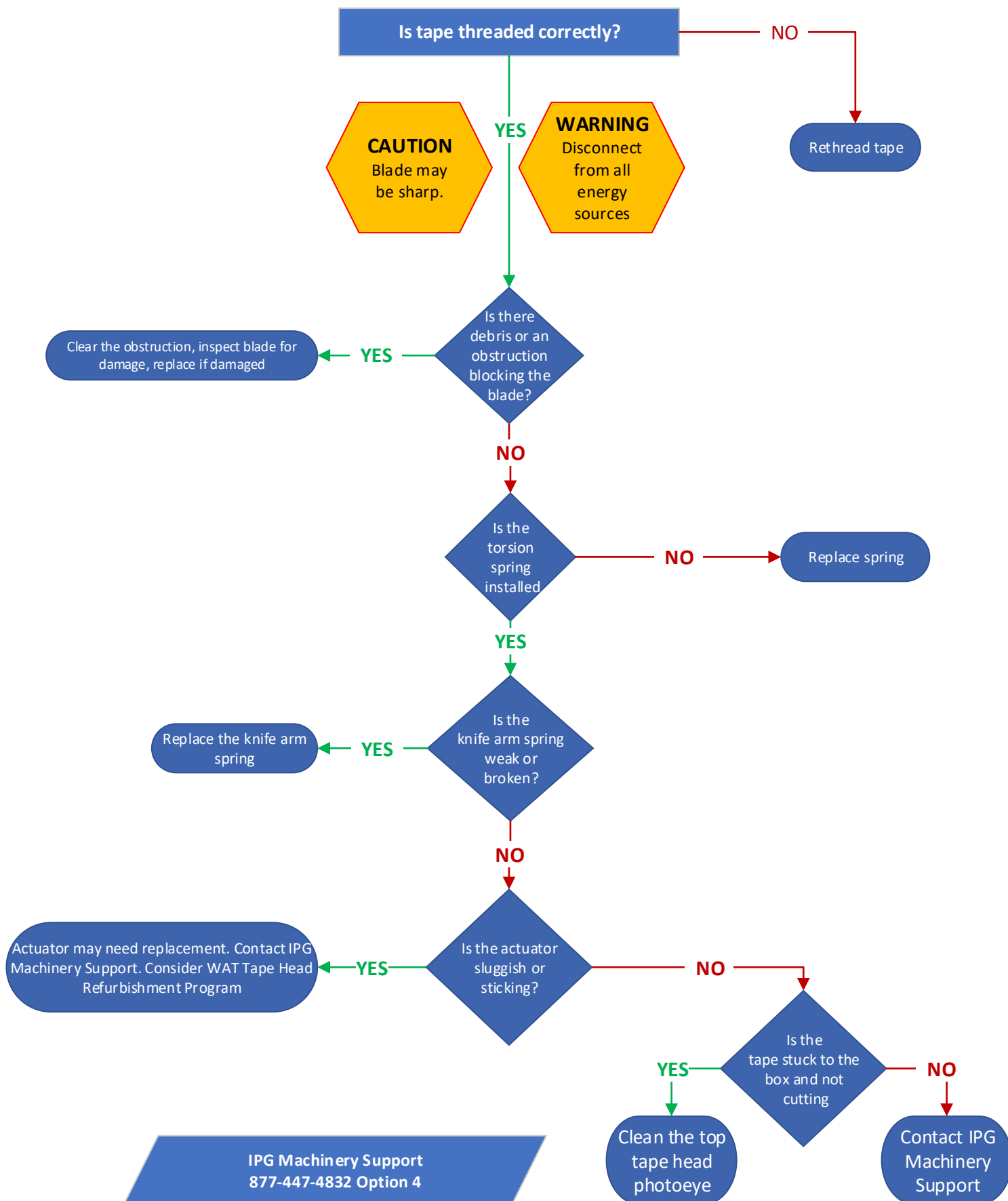


## Rear Tape Leg Not Sticking

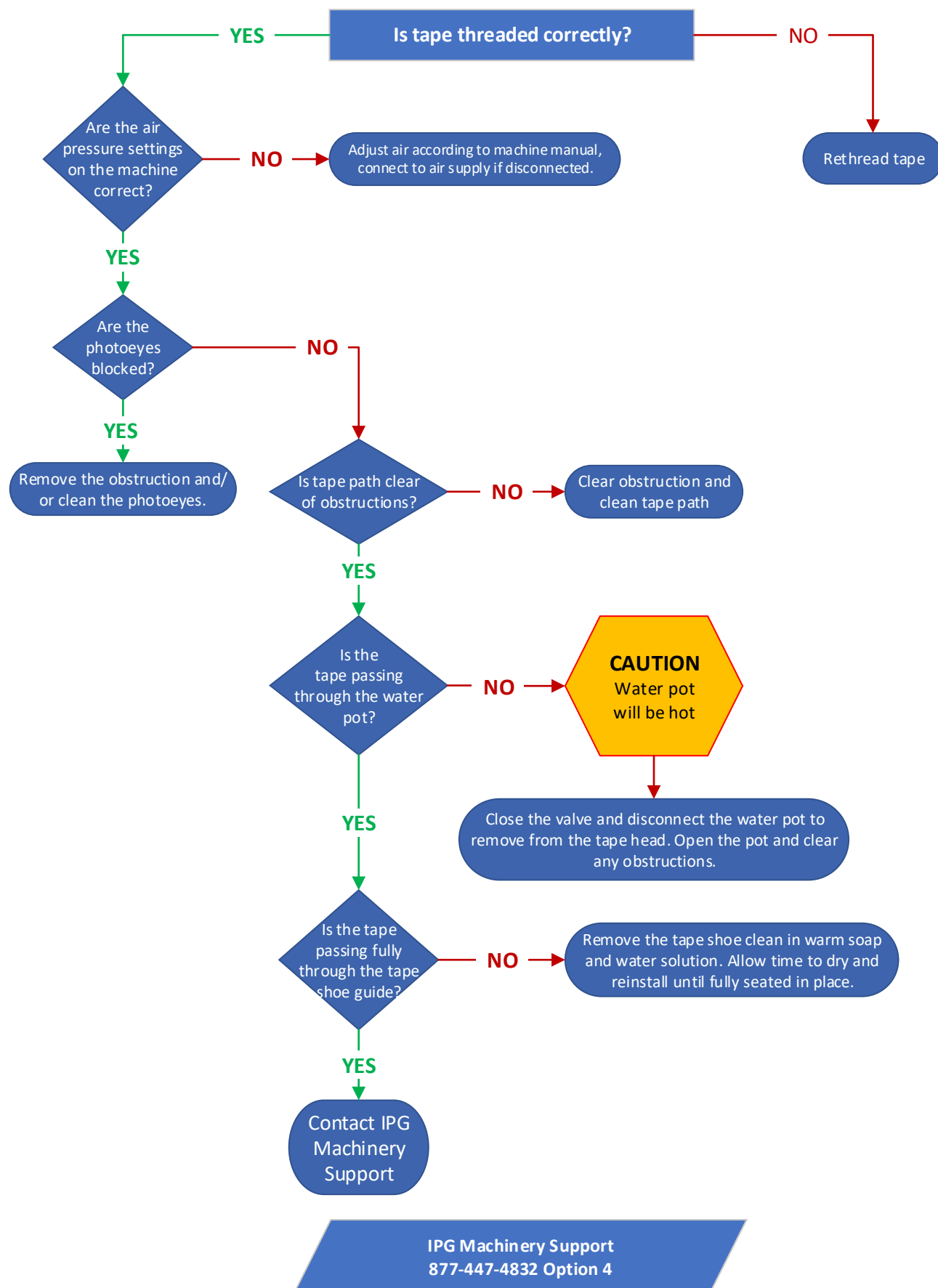


IPG Machinery Support  
877-447-4832 Option 4

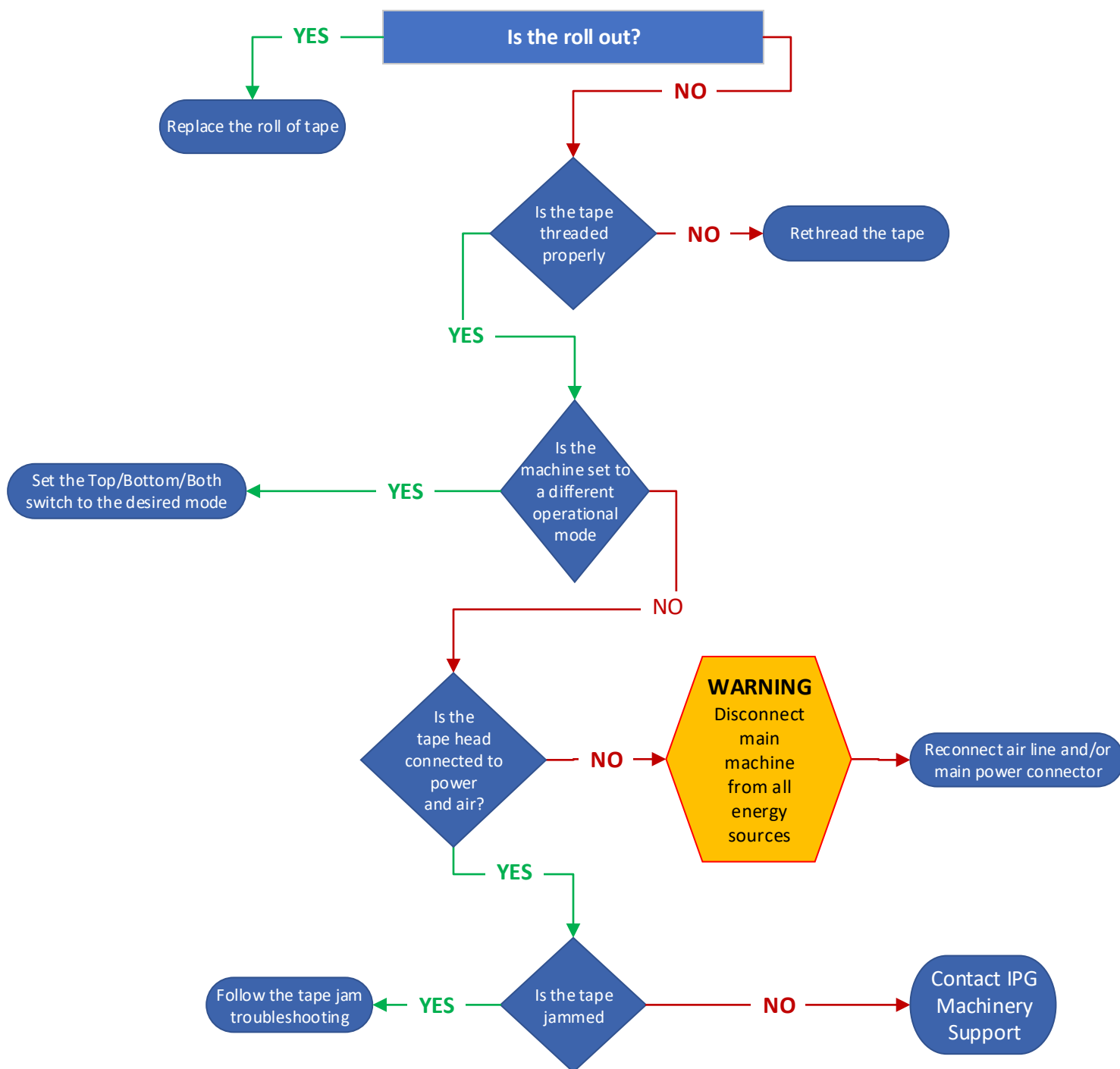
## Tape Does Not Cut



## Tape Jam

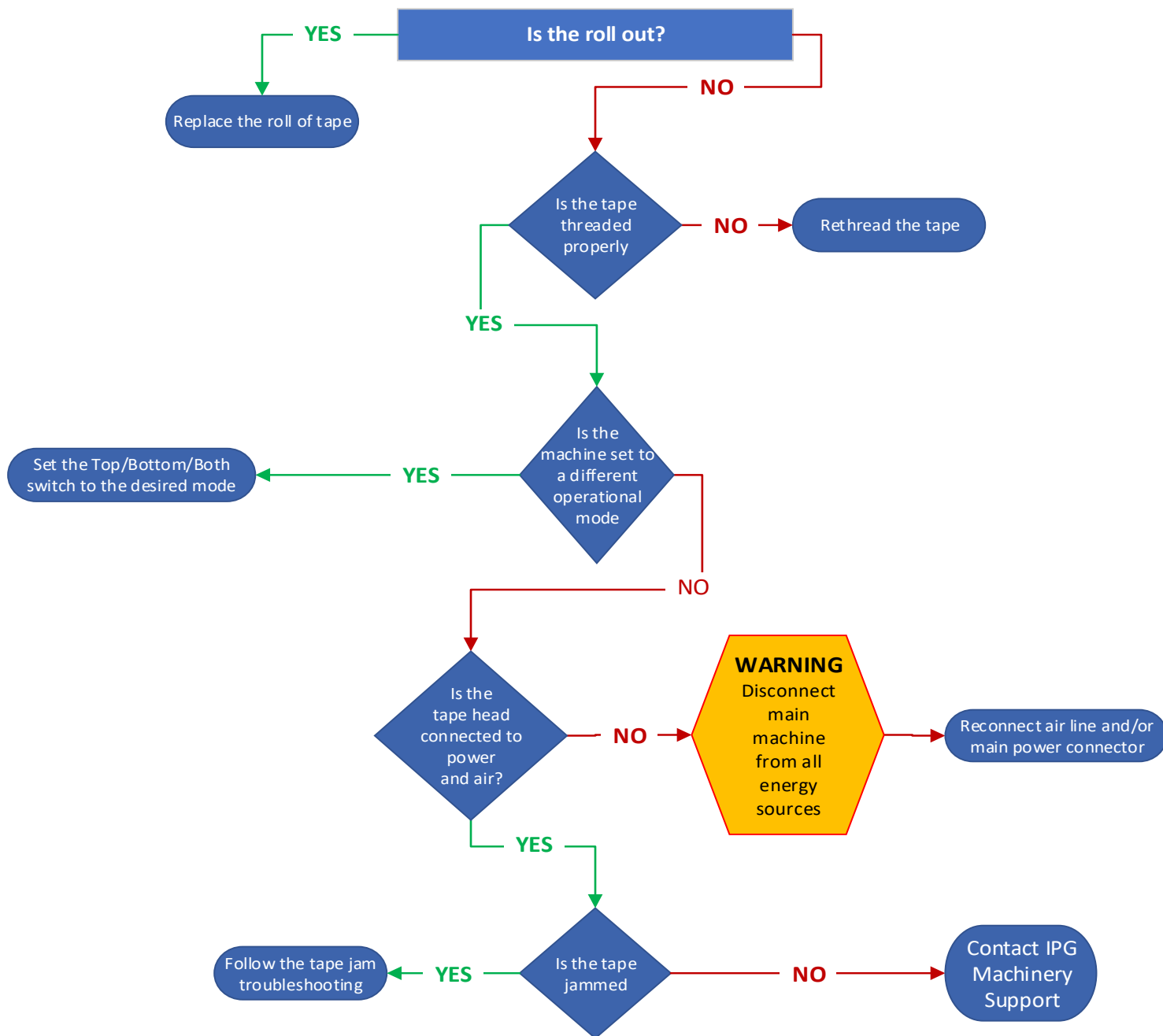


## Wrinkles in the Tape



IPG Machinery Support  
877-447-4832 Option 4

## Tape Not Dispensed



IPG Machinery Support  
877-447-4832 Option 4

# MAINTENANCE

The WAT Top Tape Head has been designed and manufactured with the finest components to provide long, trouble-free performance. General preventive maintenance will improve performance and prolong the life of the case sealer. Review the illustrations and chart below for information regarding machine maintenance.



**WARNING: TURN OFF ELECTRICAL POWER AND LOCK OUT THE ELECTRICAL SUPPLY BEFORE CLEANING OR MAINTENANCE. IF POWER CORDS ARE NOT DISCONNECTED, SEVERE INJURY TO PERSONNEL COULD RESULT.**

## Lubrication:

No lubrication is necessary to operate the tape head.

## Cleaning:

Cartons produce a sizable amount of dust and paper chips when processed or handled. If this dust is allowed to build up in the machine, it may cause component wear and overheating of motors. Remove the accumulated dust with a shop vacuum. Avoid using compressed air to remove the dust as this may cause the dust to penetrate into parts.

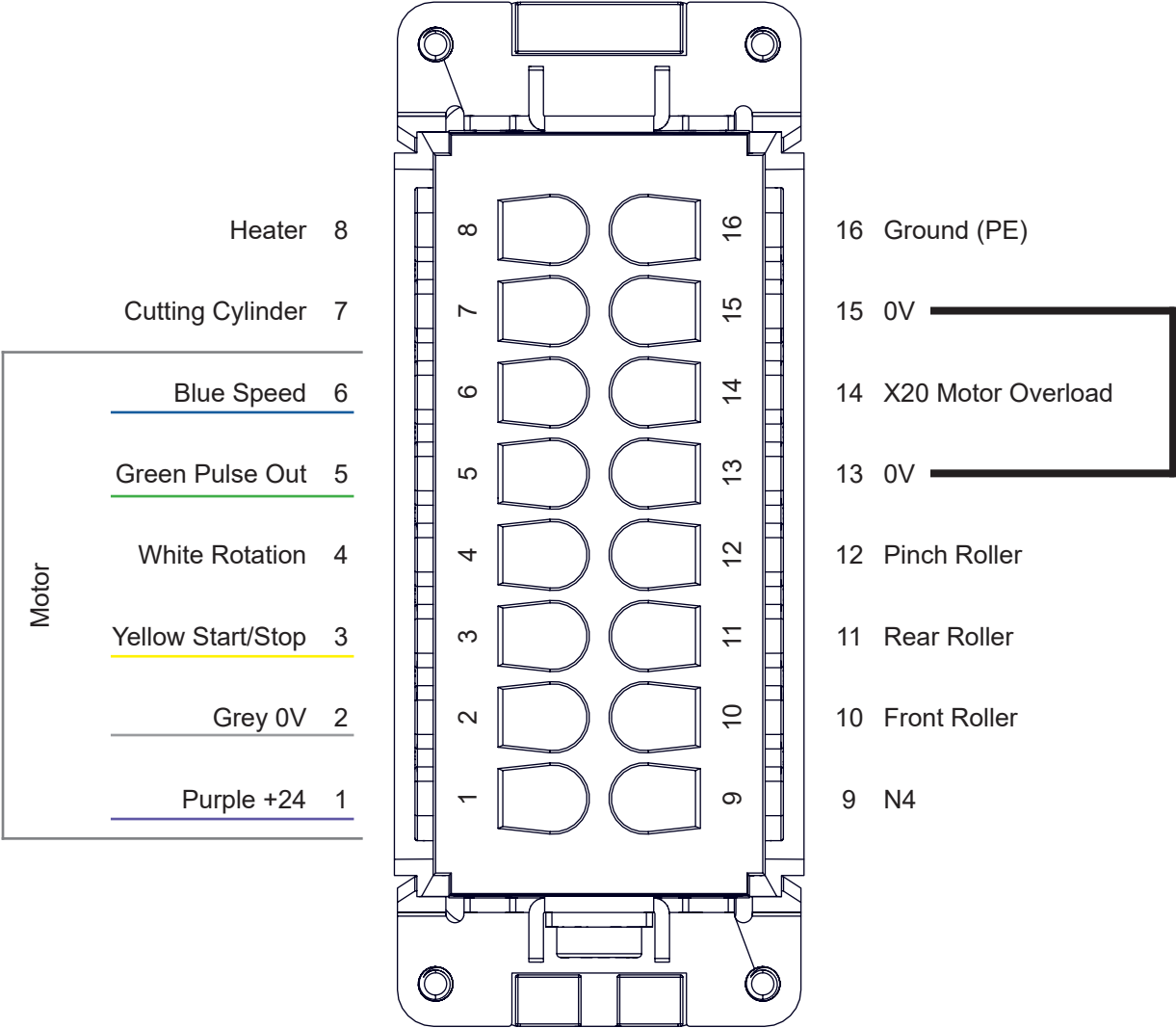
The below chart has been designed for IPG WAT Case Sealers, specifics related to the WAT Tape Head are highlighted.

Item	Action Required	Material	Frequency		
			Weekly	Monthly	Quarterly
Carton Dust In/On Machine	Blow off machine externally and internally, pay attention to drive base centering chain	Air Hose	X		
Hardware	Re-tighten any loose hardware, replace any missing hardware			X	
Column Shafts	Lubricate	Dry PTFE		X	
Cross Shafts	Lubricate	Dry PTFE		X	
Centering Chain	Lubricate	Chain Lubricant		X	
Air Regulator Filter	Clean filter	Water, Mild Detergent		X	
Tape Path	Clean to remove adhesive	Water	X		
Water Pot/Reservoir	Rinse out thoroughly			X	
Wetting Roller	Clean roller	Water, Mild Detergent			
Wipe Down Drive Rollers	Remove dust	Air Hose	X		
Tape Head Assist Roller	Clean roller	Water, Mild Detergent	X		



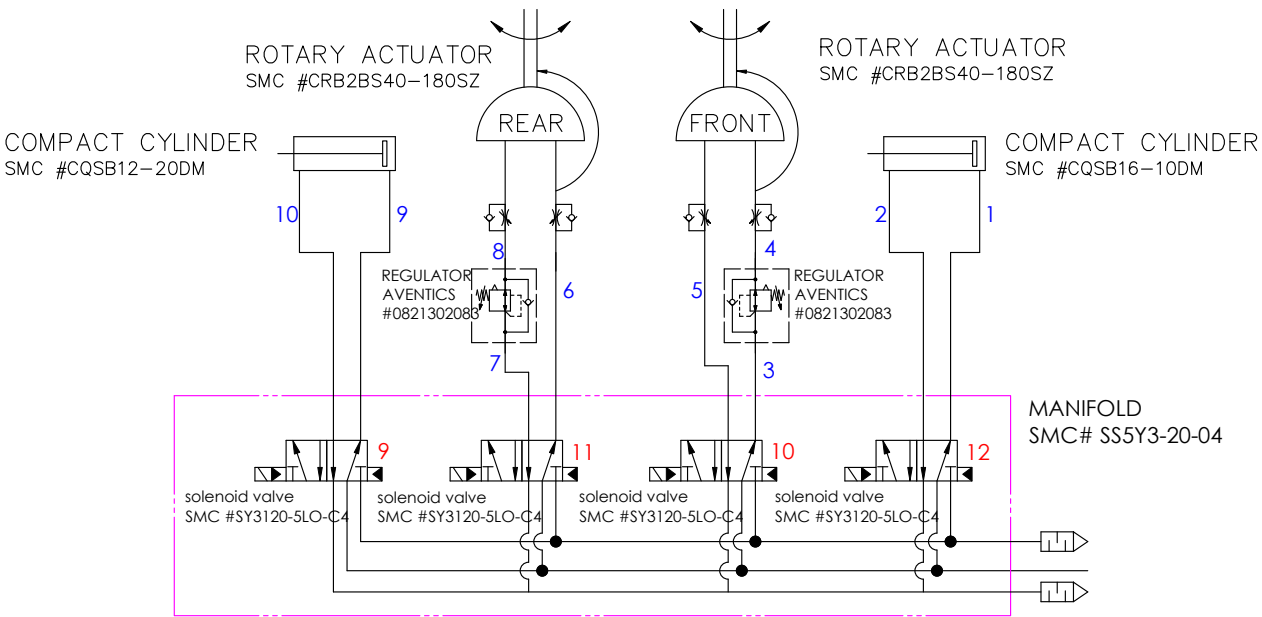
# APPENDIX A - MACHINE DRAWINGS

## Electrical Connector Pins



# APPENDIX A - MACHINE DRAWINGS

## Pneumatic Drawing



NOTES:  
4mm OD TUBING  
APPLY LABEL OF TUBE # ON EACH END OF TUBE

TUBE LENGTHS		
1	19.25"	(485mm)
2	19.25"	(485mm)
3	5.25"	(130mm)
4	7.25"	(180mm)
5	7"	(175mm)
6	9.5"	(240mm)
7	5.5"	(140mm)
8	5.5"	(140mm)
9	19.25"	(485mm)
10	19.25"	(485mm)

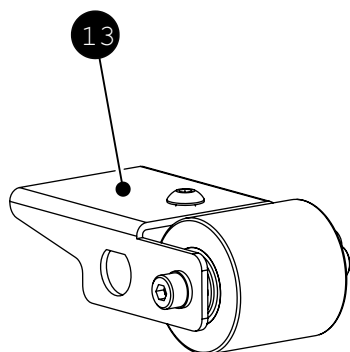
APPLY LABELS TO SOLENOID VALVES  
PER ASSEMBLY DRAWING  
  
SEE ASSEMBLY DRAWING FOR VALVE POSITION ON MANIFOLD

DO NOT SCALE DIMENSIONS ARE MILLIMETERS [INCHES] AND APPLY AFTER FINISH. BREAK AND DEBURR ALL EDGES.		intertape polymer group	
STANDARD TOLERANCES INCHES ARE REFERENCE ONLY X [XXX] ± 0.75 [± 0.030] .X [XXX] ± 0.25 [± 0.010] .XX [XXX] ± 0.13 [± 0.005] ANGLES: ± 1°		machinery division	
THIRD ANGLE PROJECTION		DRAWING NO. PN0001070	PART NO. N/A
B SIZE		TITLE 24V TOP WAT TH PNEUMATIC DWG	
SCALE N/A		SURFACE FINISH (PRE-COATING): (UNLESS OTHERWISE SPECIFIED): MACHINED PARTS: 1.6 Ra µm [63 Ra µin] MAX SHEET METAL: No. 4 SATIN MAX	
DRAWN BY DWG		DATE 5/16/23	APPROVED KJZ
		DATE 6/1/23	REV. A
		SHEET OF	

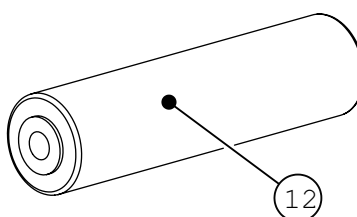
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Rear Wipedown Arm Assembly	50
Front Wipedown Arm Assembly	51

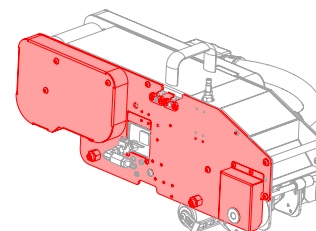
Items with black balloon call outs are assemblies (made of more than one individual part).



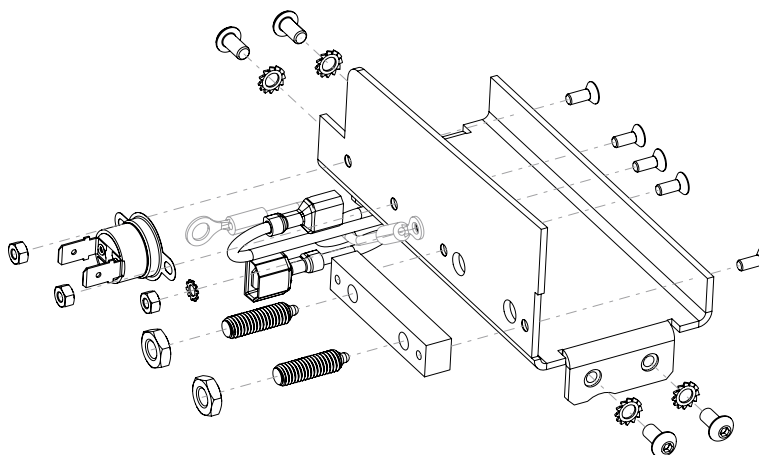
Items with white balloon call outs are single parts.



The top right of each page with a parts breakdown will show a red highlighted section of the machine that is being broken out into more detail.



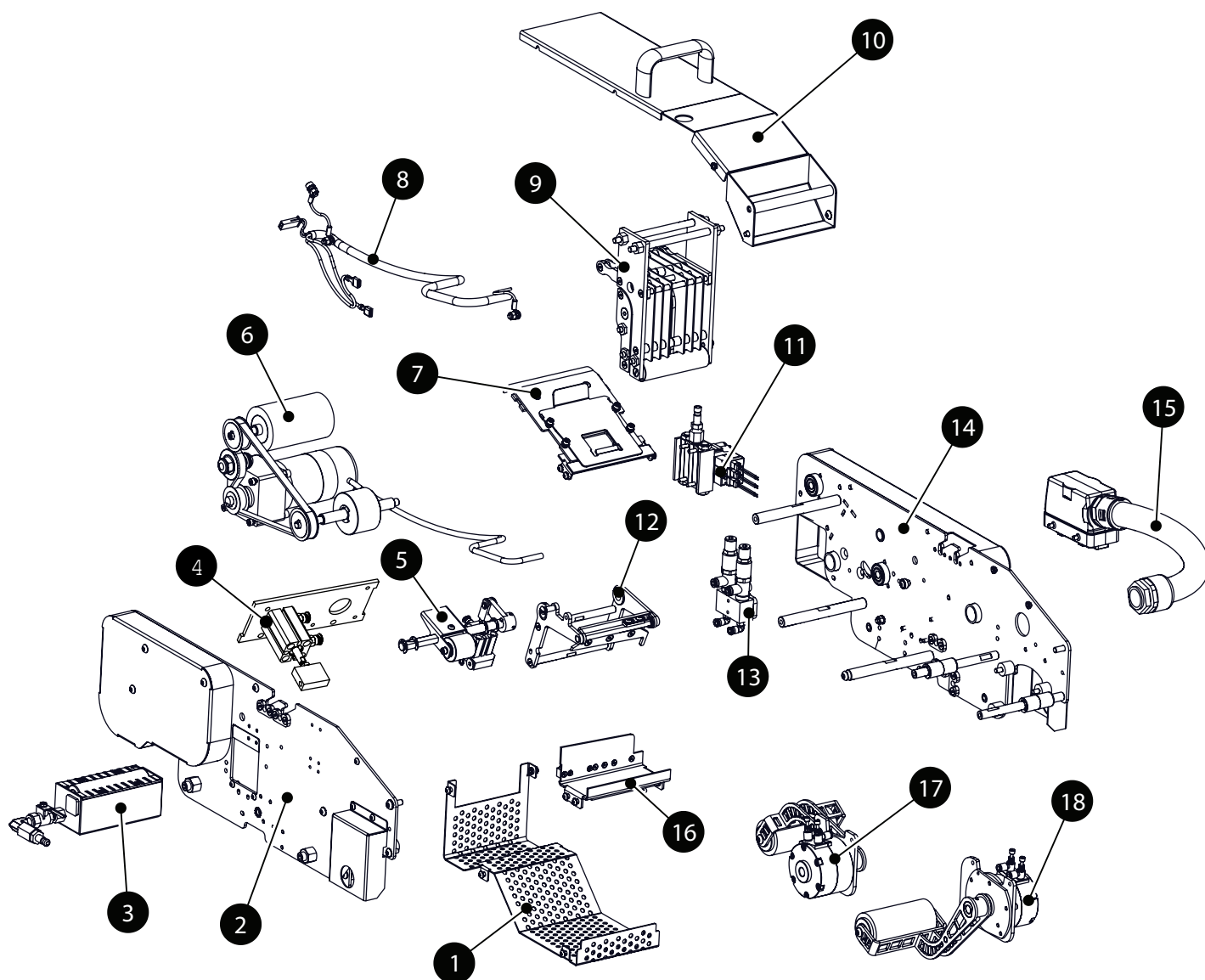
Some breakdowns will include components that are grayed out. These are from other assemblies and will assist as visual aids.



Not all assemblies are sold as assemblies please consult IPG Machine Support for details.

# APPENDIX B - MACHINE PARTS LIST

## Tape Head Assemblies

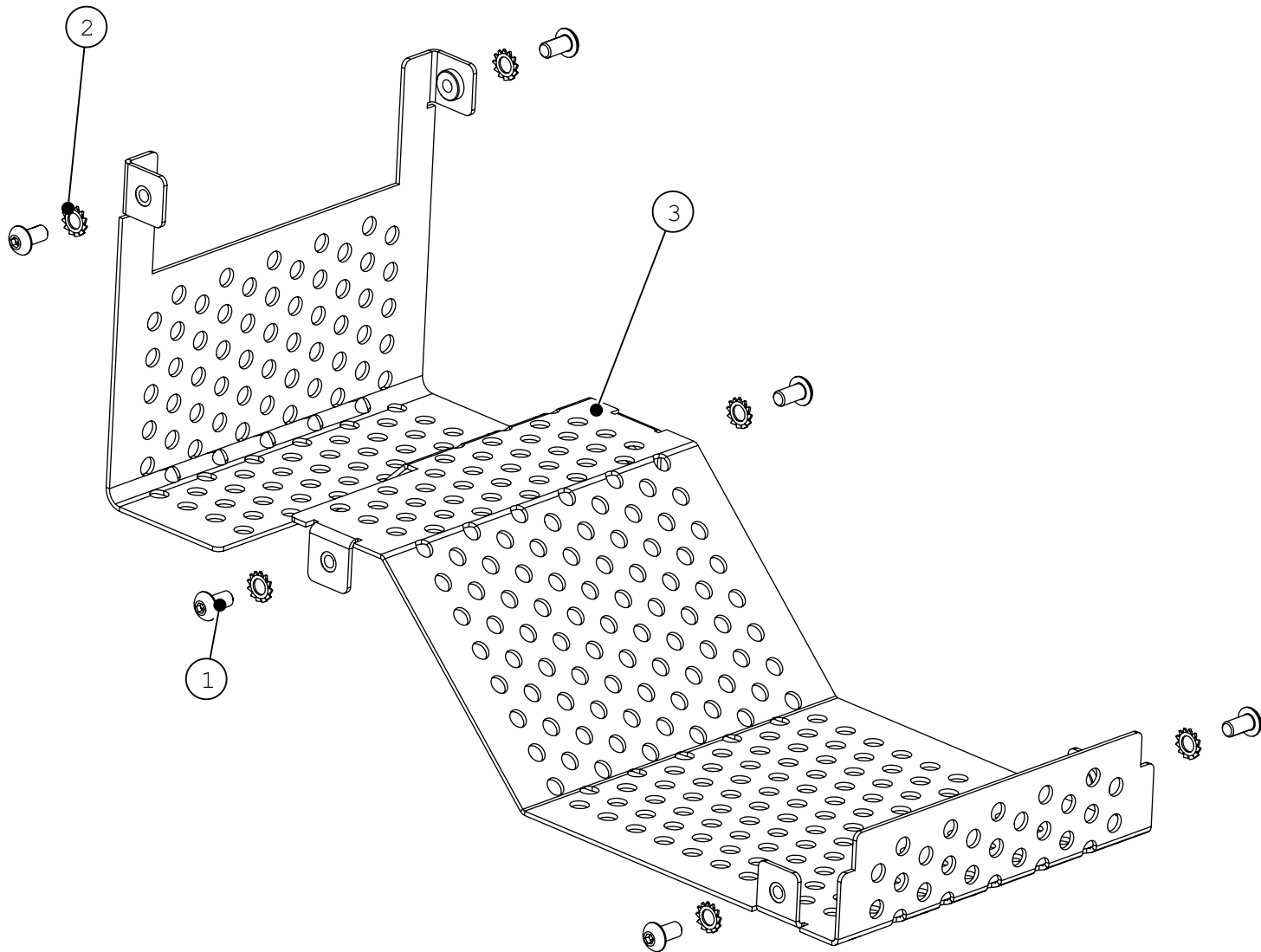
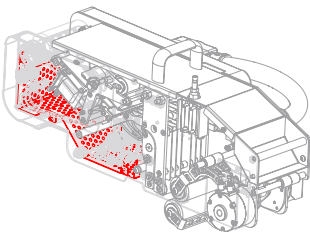


ITEM	DESCRIPTION
1	BOTTOM COVER
2	LEFT FRAME ASSEMBLY
3	TOP WATER POT
4	CUTTER ACTUATOR SHELF
5	PINCH ROLLER ASSEMBLY
6	MOTOR DRIVE ASSEMBLY
7	UPPER AND LOWER TAPE PLATES
8	TOP TAPE HEAD WIRE HARNESS
9	TOP TAPE CHUTE
10	TOP COVERS

ITEM	DESCRIPTION
11	PNEUMATIC VALVE ASSEMBLY
12	KNIFE ARM ASSEM
13	REGULATOR ASSEMBLY
14	RIGHT FRAME ASSEMBLY
15	CORD ELECTRICAL CONNECTION
16	WATER POT SHELF
17	REAR WIPEDOWN ARM ASSEMBLY
18	FRONT WIPEDOWN ARM ASSEMBLY

# APPENDIX B - MACHINE PARTS LIST

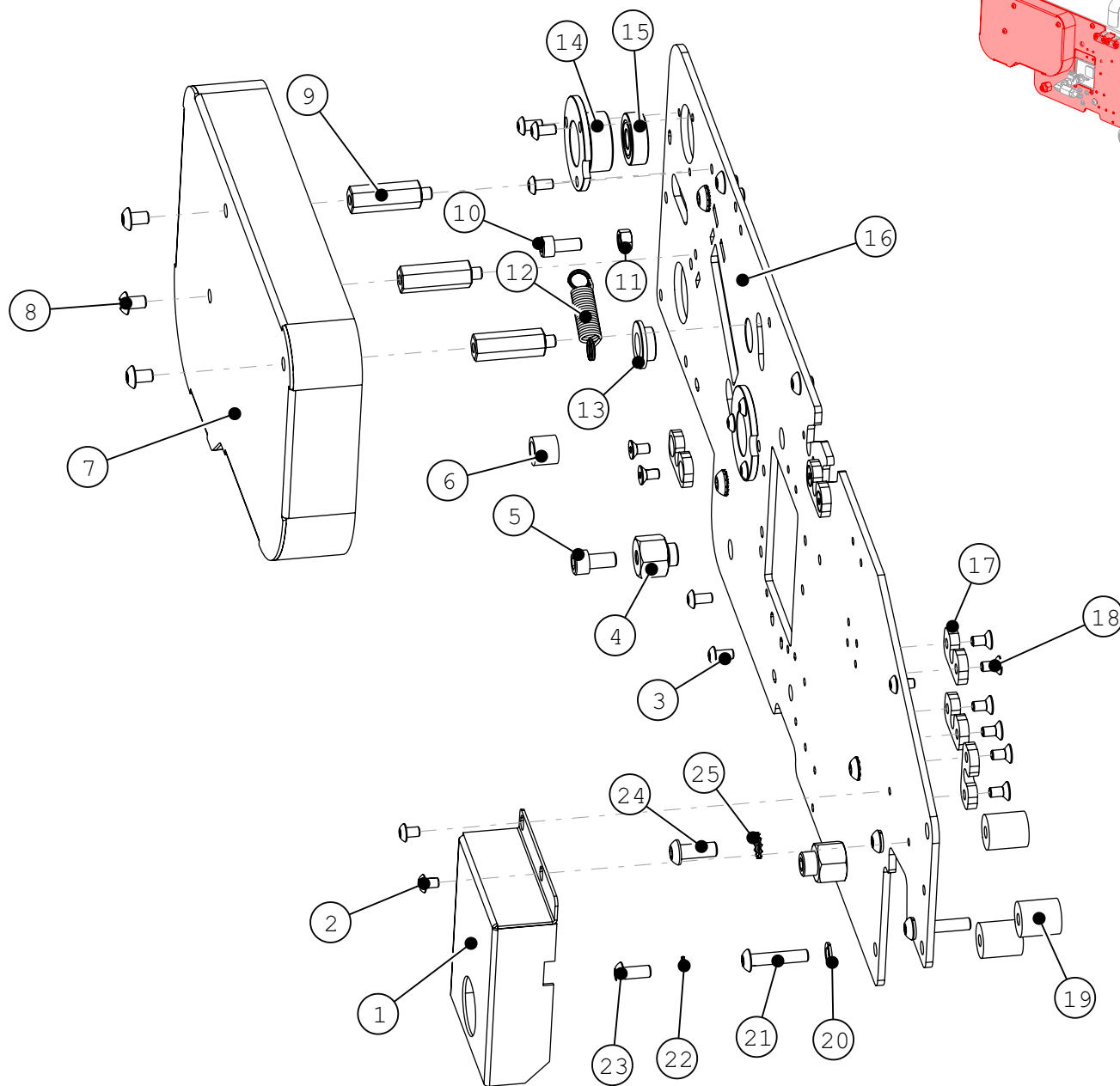
## Bottom Cover



ITEM	PART NUMBER	DESCRIPTION	QTY
1	UF7009	M4-0.7 x 8 BHCS	6
2	UF0166	SS External Tooth LW M4	6
3	WET0320	BOTTOM COVER	1

# APPENDIX B - MACHINE PARTS LIST

## Left Frame Assembly

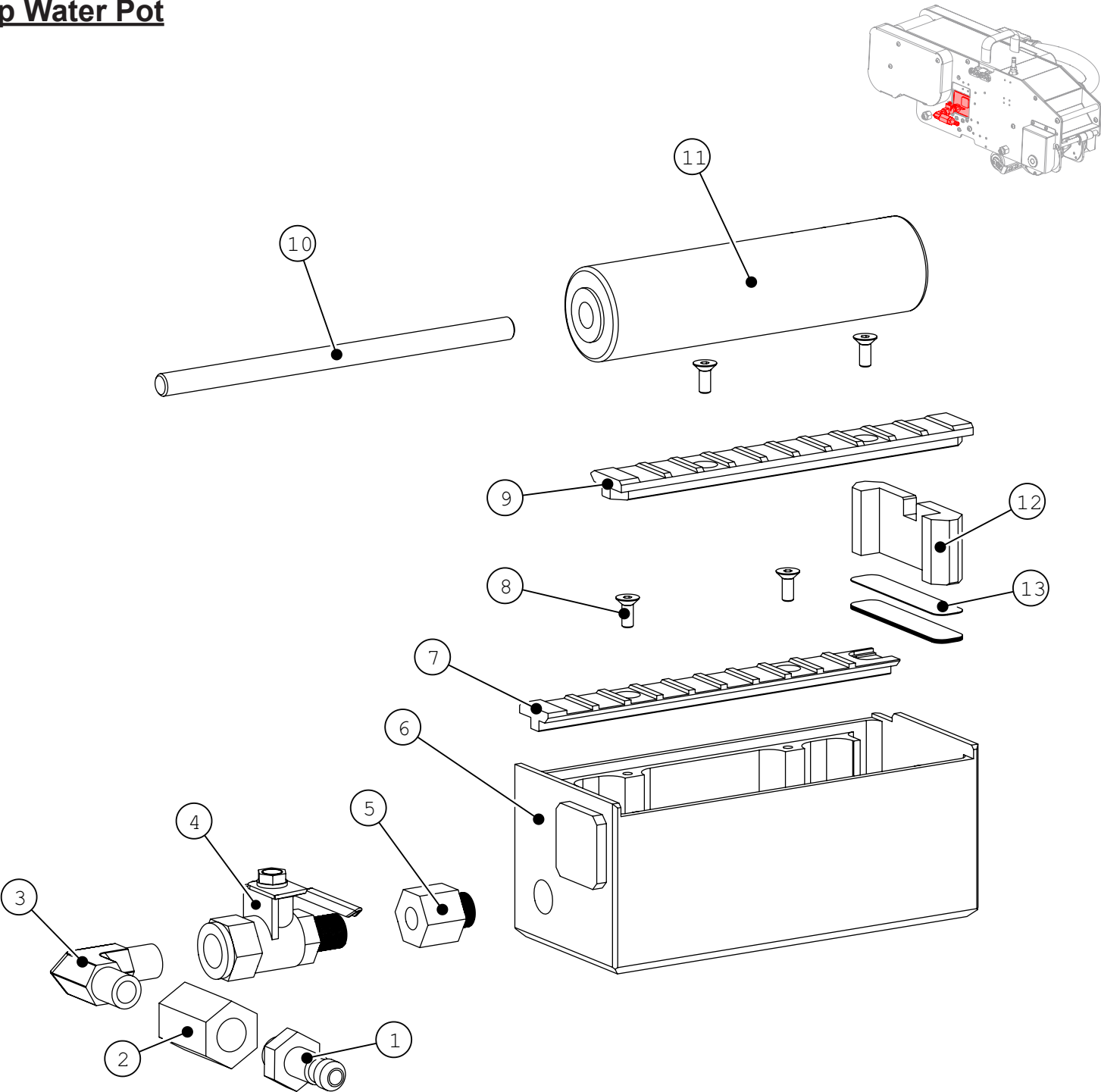


ITEM	PART NUMBER	DESCRIPTION	QTY
1	WET0323	FLOW CONTROL COVER	1
2	UF7008	M4-0.7 x 6 BHCS	2
3	UF7009	M4-0.7 x 8 BHCS	8
4	WET0215	ADAPTOR, 12L	2
5	UF3183	M6-1 x 12 SHCS	2
6	WET0355	DRIVE SHAFT SPACER	1
7	WET0321	TOP TAPEHEAD RIGHT COVER	1
8	UF7010	M5-0.8 x 8 BHCS	3
9	WET0216	ADAPTOR, 30L	3
10	UF7003	SHCS M5 - 0.8 x 12	1
11	UF6307	M5-0.8 HEX NUT	1
12	WET0164	EXTENSION SPRING	1
13	WPT0004	OILITE FLANGE BEARING 10mm	1

ITEM	PART NUMBER	DESCRIPTION	QTY
14	WET0253	BEARING MOUNT	2
15	WET0341	BALL BEARING 608ZZ	2
16	WET0313	TOP RIGHT FRAME PLATE	1
17	WET0255	TAPE CHUTE DETENT	5
18	UF3274	M4-0.7 x 8 FHCS	10
19	WET0316	TOP REAR WIPEDOWN SPACER	3
20	UF7021	M5 LW	3
21	UF3279	M5-0.8 x 25 BHCS	3
22	UF7022	SS EXTERNAL TOOTH LW M5	2
23	UF7011	M5-0.8 x 12 BHCS	2
24	UF6414	M6-1 x 16 BHCS	3
25	UF0168	SS EXTERNAL TOOTH LW M6	3

# APPENDIX B - MACHINE PARTS LIST

## Top Water Pot



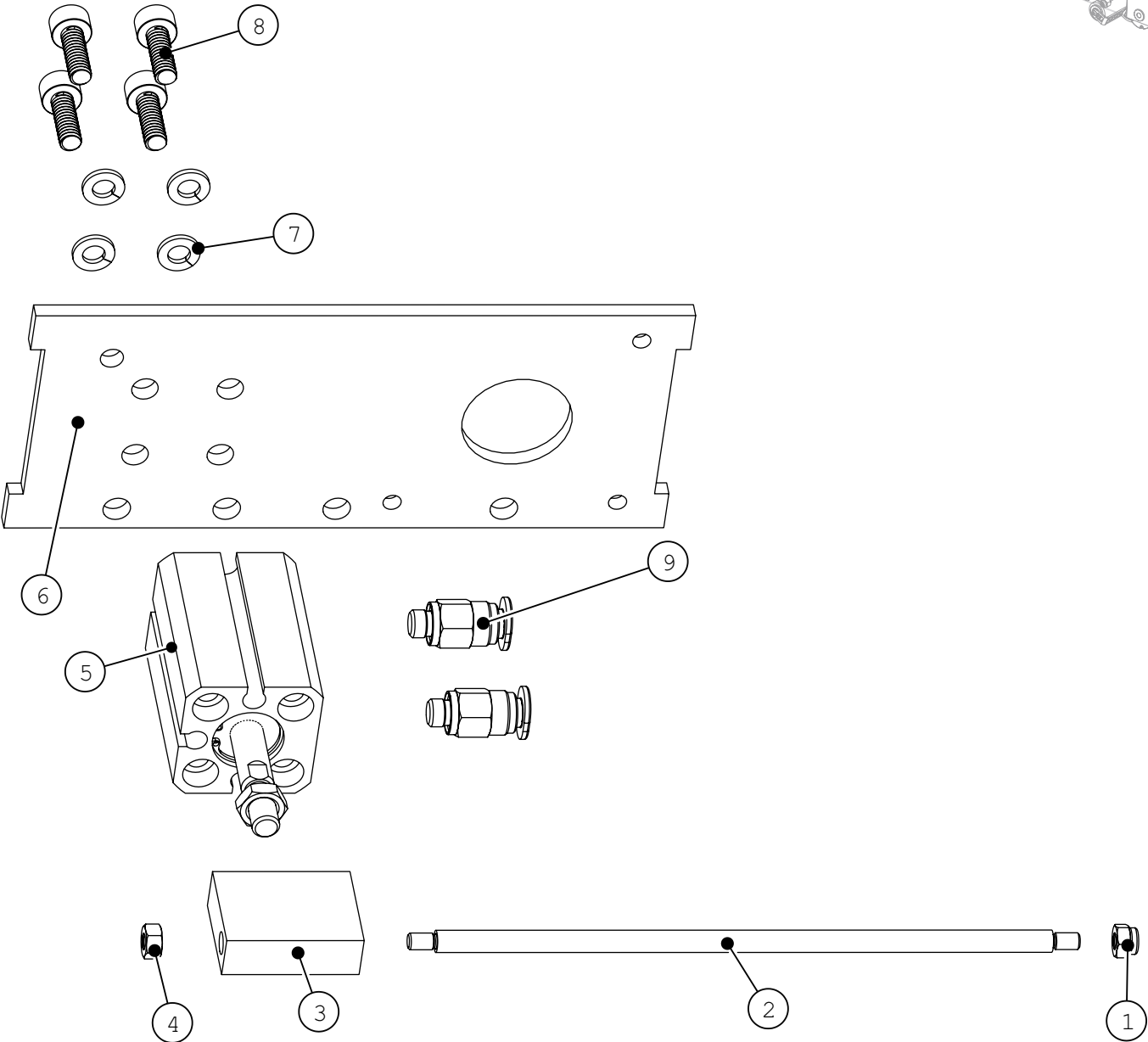
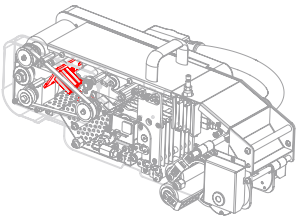
ITEM	PART NUMBER	DESCRIPTION	QTY
1	UPH1500	QUICK COUPLING PLUG	1
2	UPH1499	REDUCER	1
3	UPH1498	ELBOW FITTING	1
4	UPH1497	BALL VALVE	1
5	UPH1496	REDUCER	1
6	WET0301	WATER POT BASE	1
7	WET0303	WATER POT FRONT GUIDE	1

ITEM	PART NUMBER	DESCRIPTION	QTY
8	UF6350	M3-0.5 x 8 FHCS	4
9	WET0304	WATER POT REAR GUIDE	1
10	WET0207	SHAFT, 6mm	1
11	WET0071	ROLLER	1
12	WET0302	WATER POT INSERT	2
13	WET0359	WATER POT SHIM	10



# APPENDIX B - MACHINE PARTS LIST

## Cutter Actuator Shelf

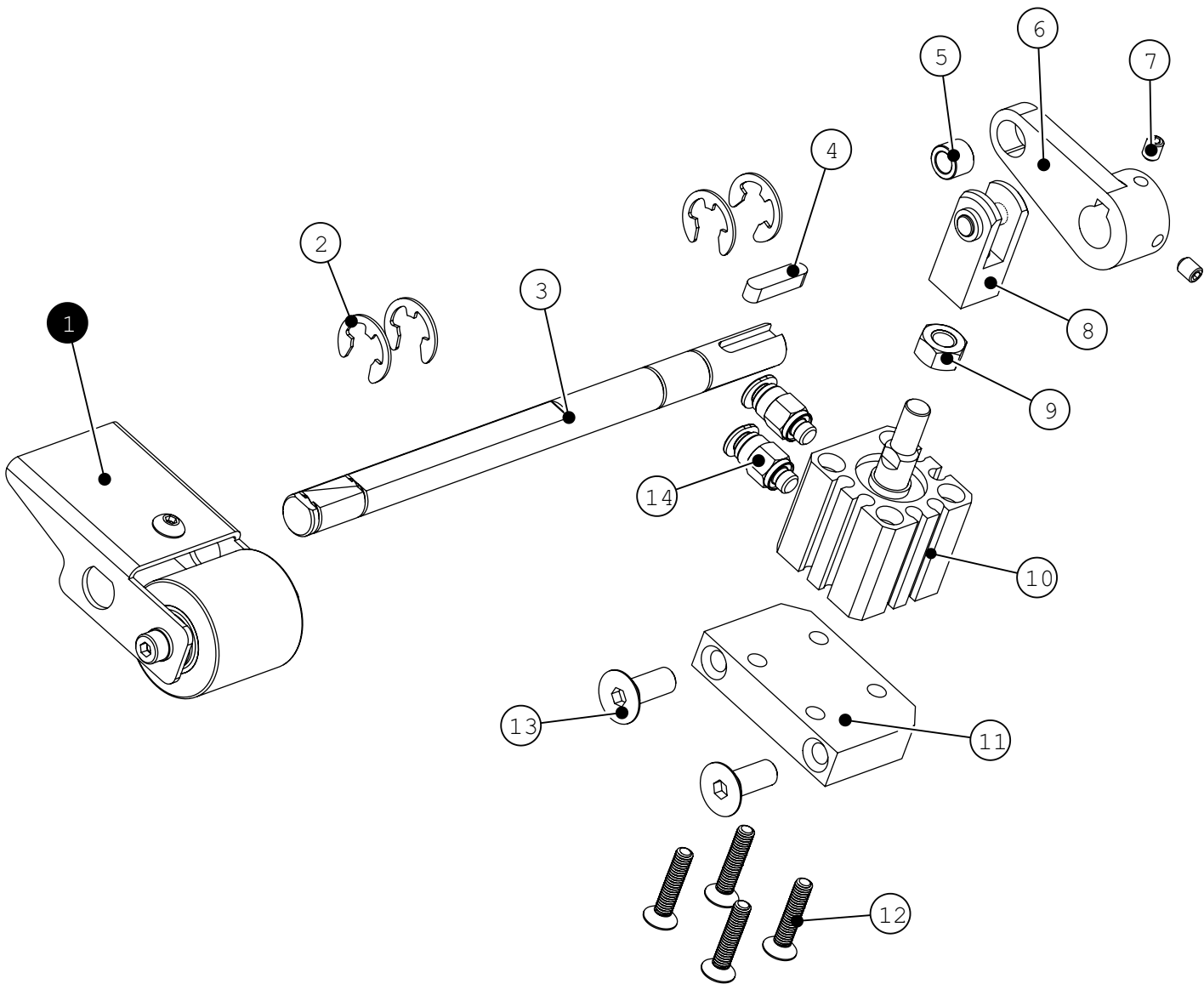
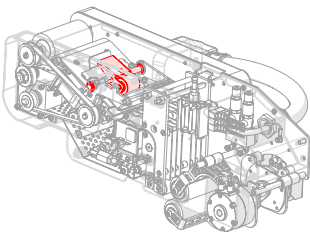


ITEM	PART NUMBER	DESCRIPTION	QTY
1	UF0165	SS M3-0.5 LOCK NUT	1
2	WET0277	SOLENOID COUPLING PIN	1
3	WET0373	CUTTER YOKE	1
4	UF3717	SS HEX NUT M3-0.5	1
5	WET0375	CYLINDER 12mm X 20mm	1

ITEM	PART NUMBER	DESCRIPTION	QTY
6	WET0274	SOLENOID MOUNT	1
7	UF3749	SS LW M4	4
8	UF3801	M4-0.7 x 12 SHCS	4
9	UPH4906	M5 x 4mm STRAIGHT FITTING	2

# APPENDIX B - MACHINE PARTS LIST

## Pinch Roller Assembly

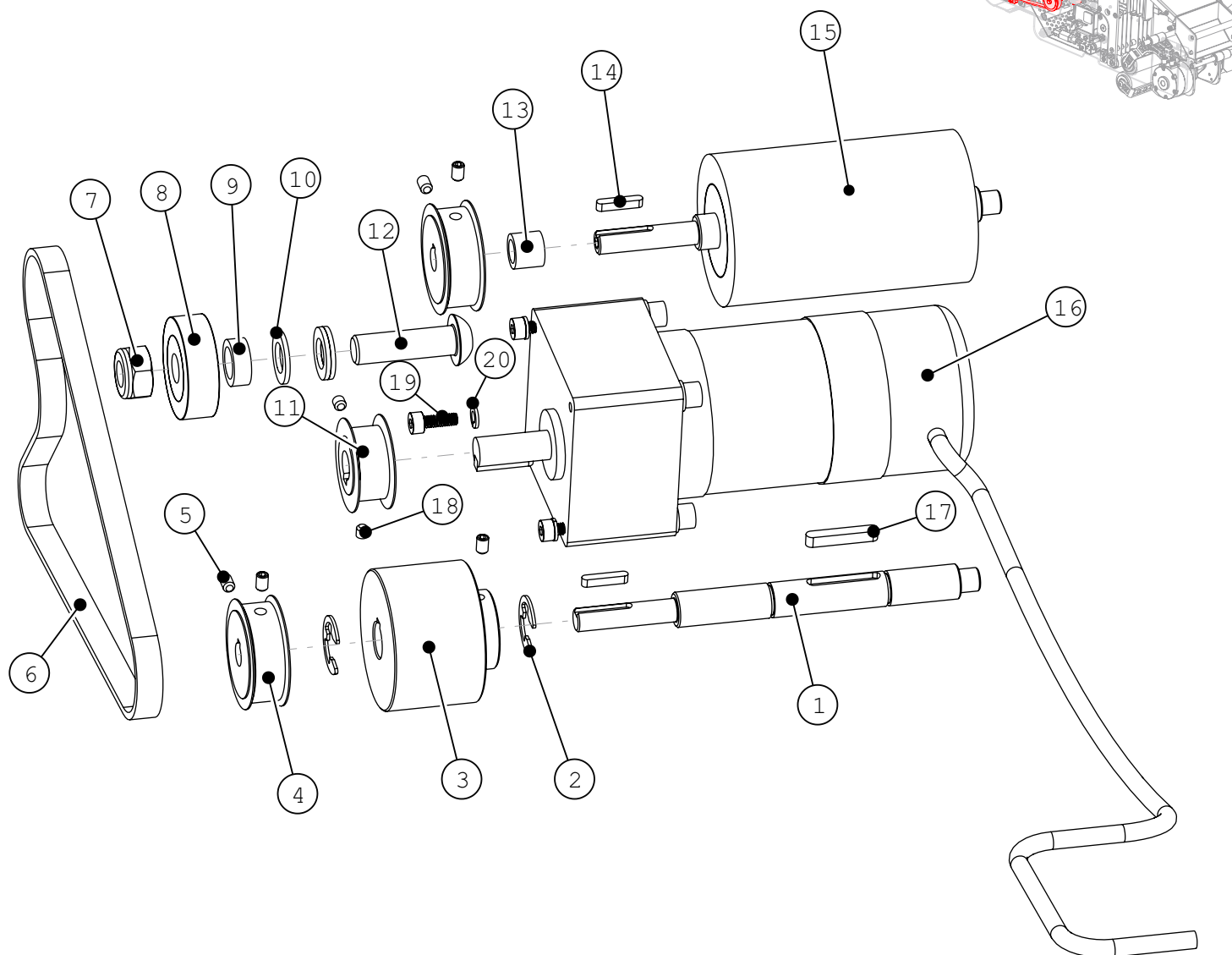


ITEM	PART NUMBER	DESCRIPTION	QTY
1	WST0073	PINCH ROLLER ASSEM	1
2	UF7019	RETAINING RING	4
3	WET0276	PINCH ROLLER PIVOT SHAFT	1
4	UF0172	KEY - M4 X 18L	1
5	UPM4495	8OD x 5ID x 6 BUSHING	1
6	WET0282	TOP PIVOT ARM	1
7	UF0171	M4-0.7 SSS	2
8	WET0152	CLEVIS	1

ITEM	PART NUMBER	DESCRIPTION	QTY
9	UF3638	M6-1.0 HNR	1
10	WET0151	CYLINDER	1
11	WET0280	CYLINDER SUPPORT	1
12	UF0169	M4-0.7 x 20 FHCS	4
13	UF3261	M6-1 x 16 FHCS	2
14	UPH4906	M5 x 4mm STRAIGHT FITTING	2

# APPENDIX B - MACHINE PARTS LIST

## Motor Drive Assembly

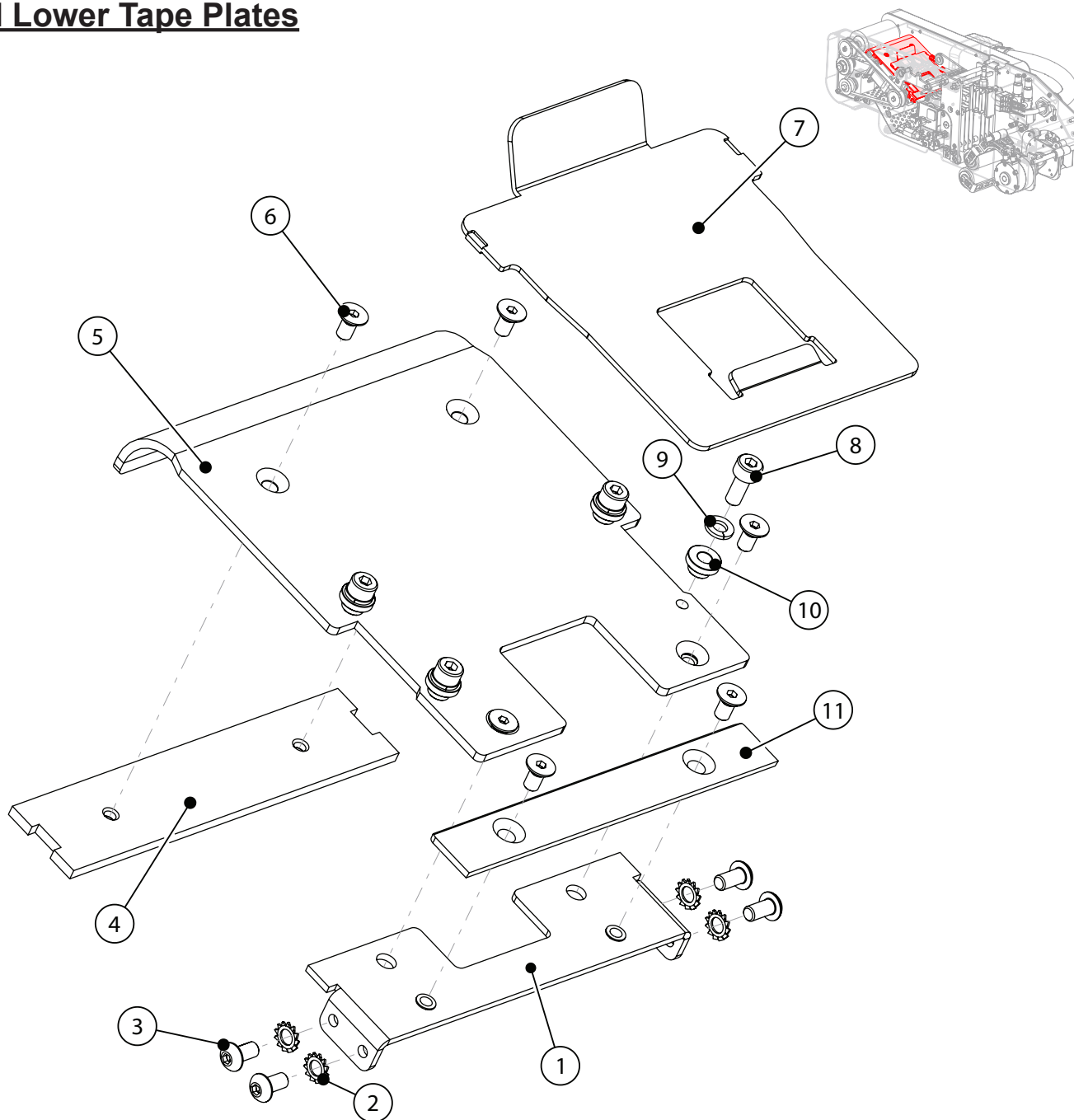


ITEM	PART NUMBER	DESCRIPTION	QTY
1	WET0262	DRIVE SHAFT	1
2	UF0189	E-RING 12MM	2
3	WET0354	DRIVE ROLLER	1
4	WET0360	36 TOOTH TIMING BELT PULLEY	2
5	UF6413	SSS M4-0.7 x 6	5
6	WET0250	TIMING BELT 477-3M-9	1
7	UF0224	M10-1.5 LOCK-NUT	1
8	UPH4919	BALL BEARING, 10ID, 35OD	1
9	WET0194	SPACER, DIA 16,6L	1
10	UF0175	M10 FW	3
11	WET0248	27 TOOTH TIMING BELT PULLEY	1

ITEM	PART NUMBER	DESCRIPTION	QTY
12	UF0072	M10 - 1.5 x 35 BHCS	1
13	WET0355	DRIVE SHAFT SPACER	1
14	UF0248	KEY - M3 X 16L	2
15	WST0113	ASSIST ROLLER	1
16	WET0247	WAT TAPEHEAD MOTOR	1
17	UF0167	KEY - M4 X 25L	1
18	UF0132	SSS M4-0.7 x 4	2
19	UF3801	M4-0.7 x 12 SHCS	3
20	UF3749	M4 LW	3

# APPENDIX B - MACHINE PARTS LIST

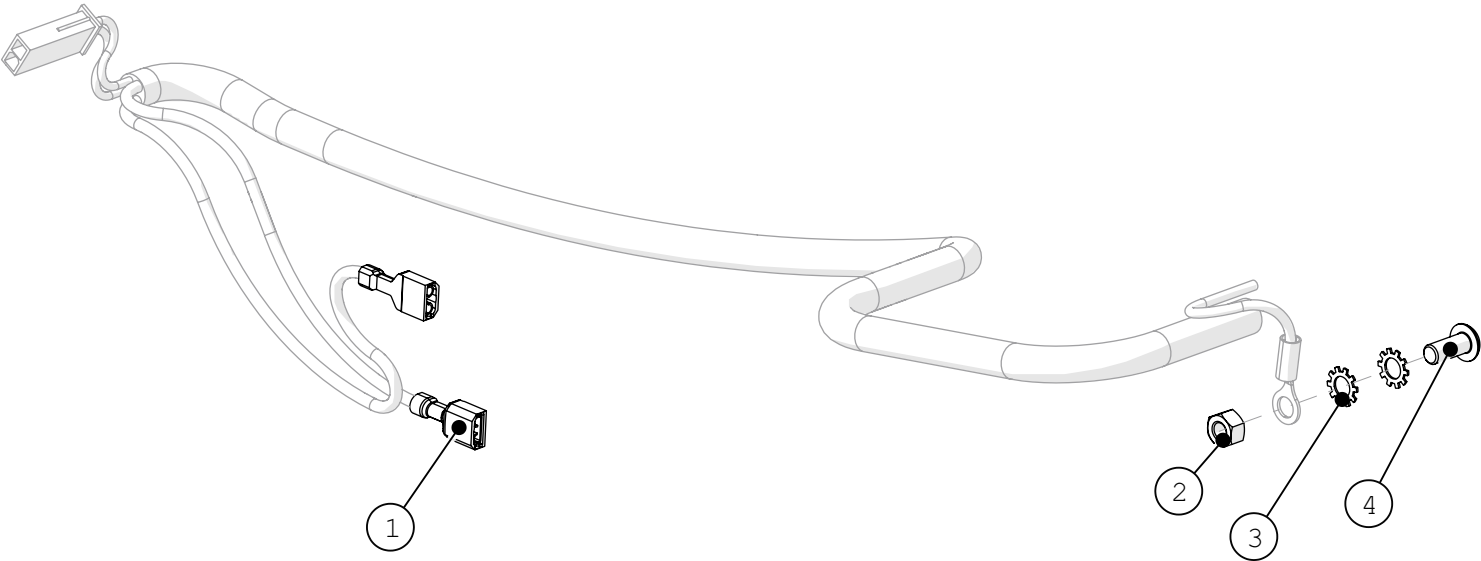
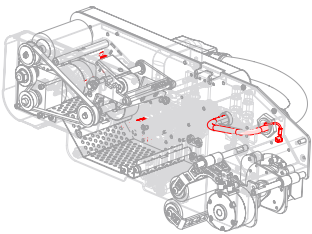
## Upper and Lower Tape Plates



ITEM	PART NUMBER	DESCRIPTION	QTY
1	WET0353	TAPE GUIDE SUPPORT	1
2	UF0166	SS EXTERNAL TOOTH LW M4	4
3	UF7009	M4-0.7 x 8 BHCS	4
4	WET0270	REAR TAPE GUIDE SUPPORT	1
5	WET0312	TOP TAPE GUIDE	1
6	UF3274	M4-0.7 x 8 FHCS	6
7	WET0273	TAPE HOLD DOWN	1
8	UF3759	M4-0.7 x 10 SHCS	4
9	UF3749	M4 LW	4
10	WET0272	TAPE HOLD DOWN RETAINER	4
11	WPT0044	STRIKER PLATE	1

# APPENDIX B - MACHINE PARTS LIST

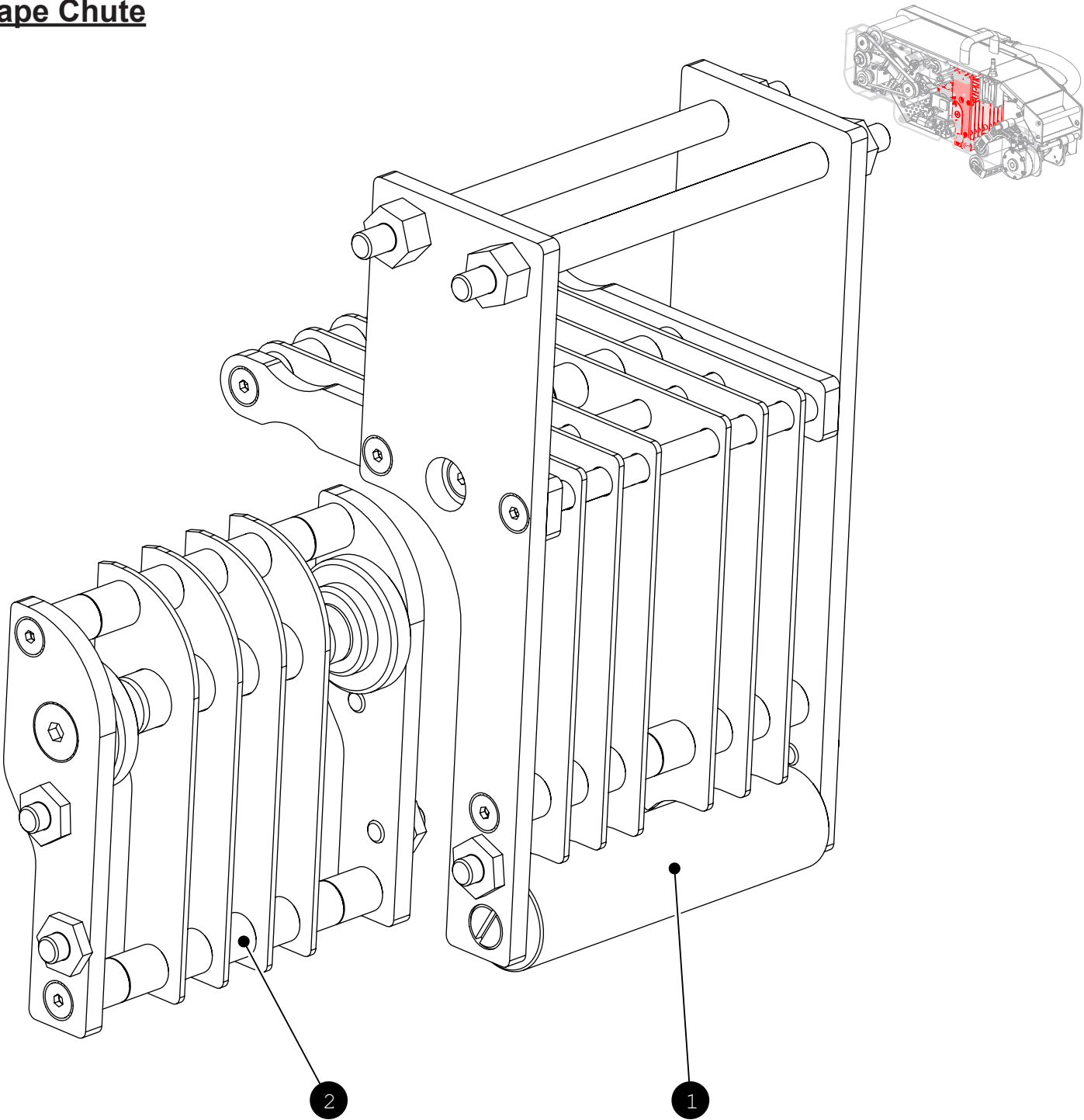
## Wire Harness



ITEM	PART NUMBER	DESCRIPTION	QTY
1	WET0335	FEMALE QUICK DISCONNECT	2
2	UF6307	M5-0.8 HEX NUT	1
3	UF7022	SS EXT. TOOTH LW M5	2
4	UF7011	M5-0.8 x 12 BHCS	1

# APPENDIX B - MACHINE PARTS LIST

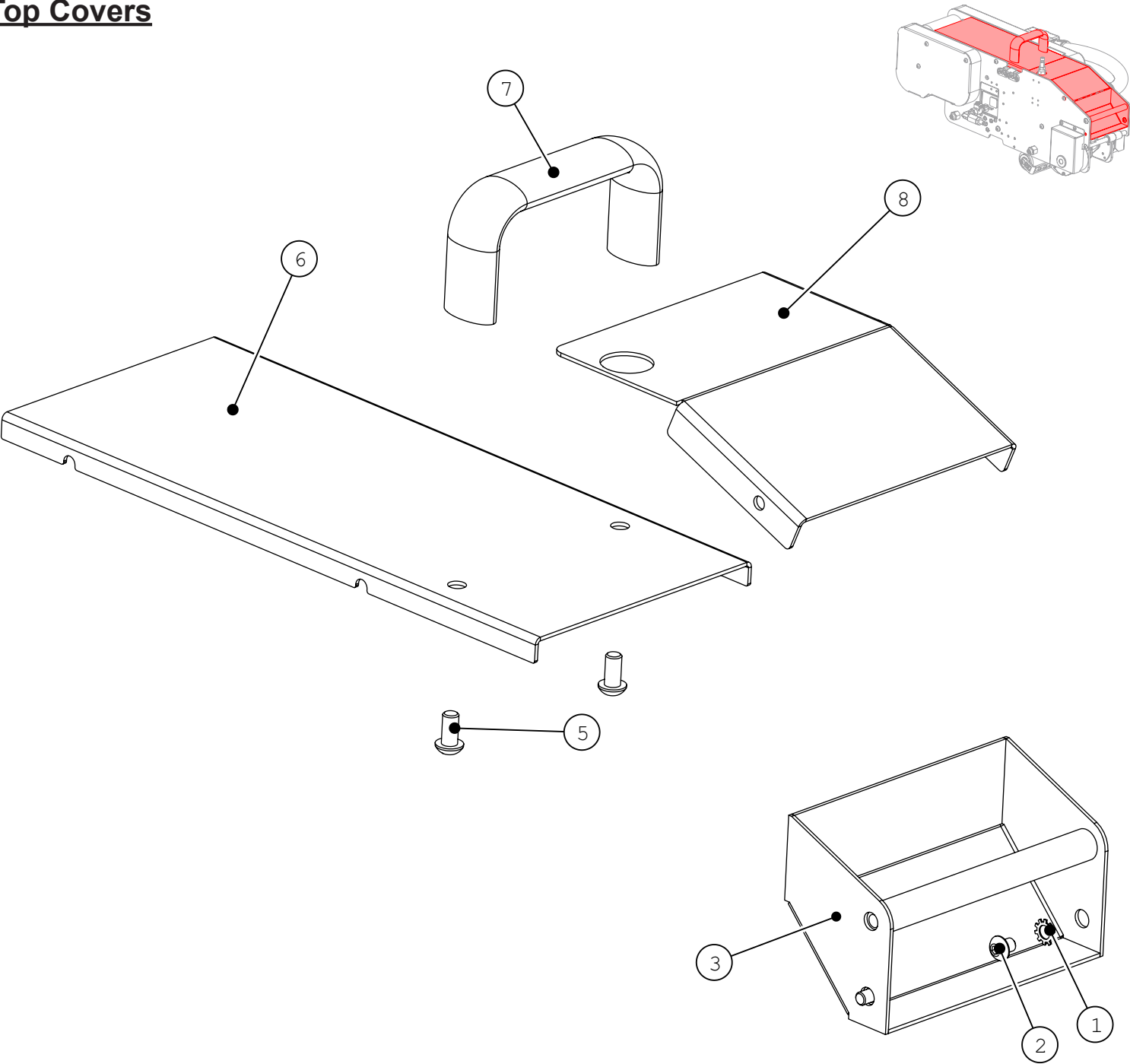
## Top Tape Chute



ITEM	PART NUMBER	DESCRIPTION	QTY
1	WST0103	TOP OUTER TAPE CHUTE	1
2	WST0102	TOP INNER TAPE CHUTE	1

# APPENDIX B - MACHINE PARTS LIST

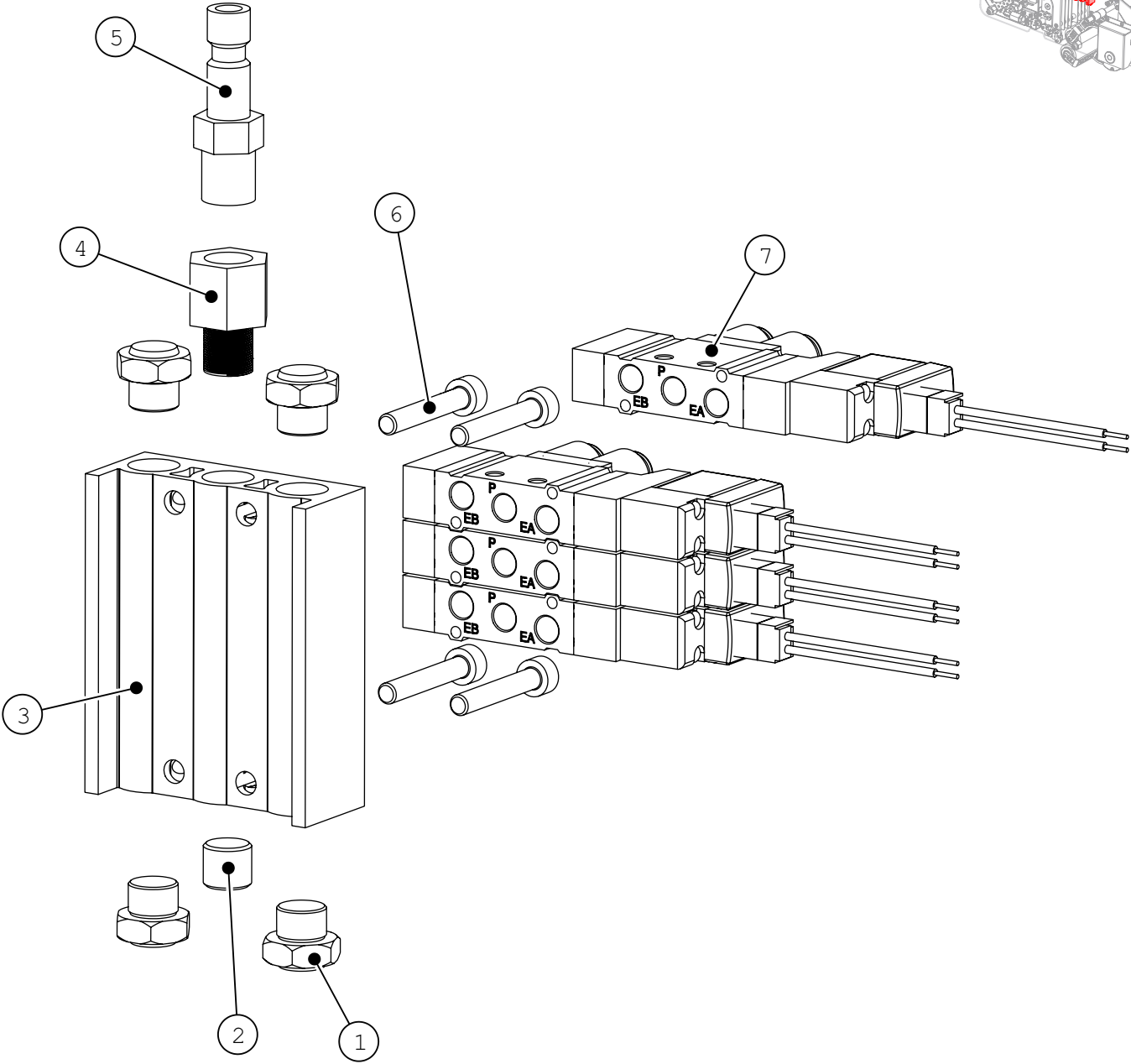
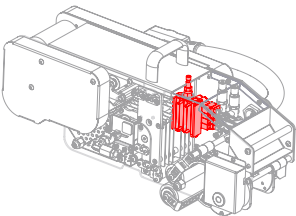
## Top Covers



ITEM	PART NUMBER	DESCRIPTION	QTY
1	UF7022	SS External Tooth LW M5	2
2	UF3276	M5-0.8 x 6 BHCS	2
3	WET0222	COVER	1
5	UF1195	M6-1 x 12 BHCS	2
6	WET0334	TOP COVER	1
7	WET0234	HANDLE	1
8	WET0350	TOP FRONT COVER	1

# APPENDIX B - MACHINE PARTS LIST

## Pneumatic Valve Assembly



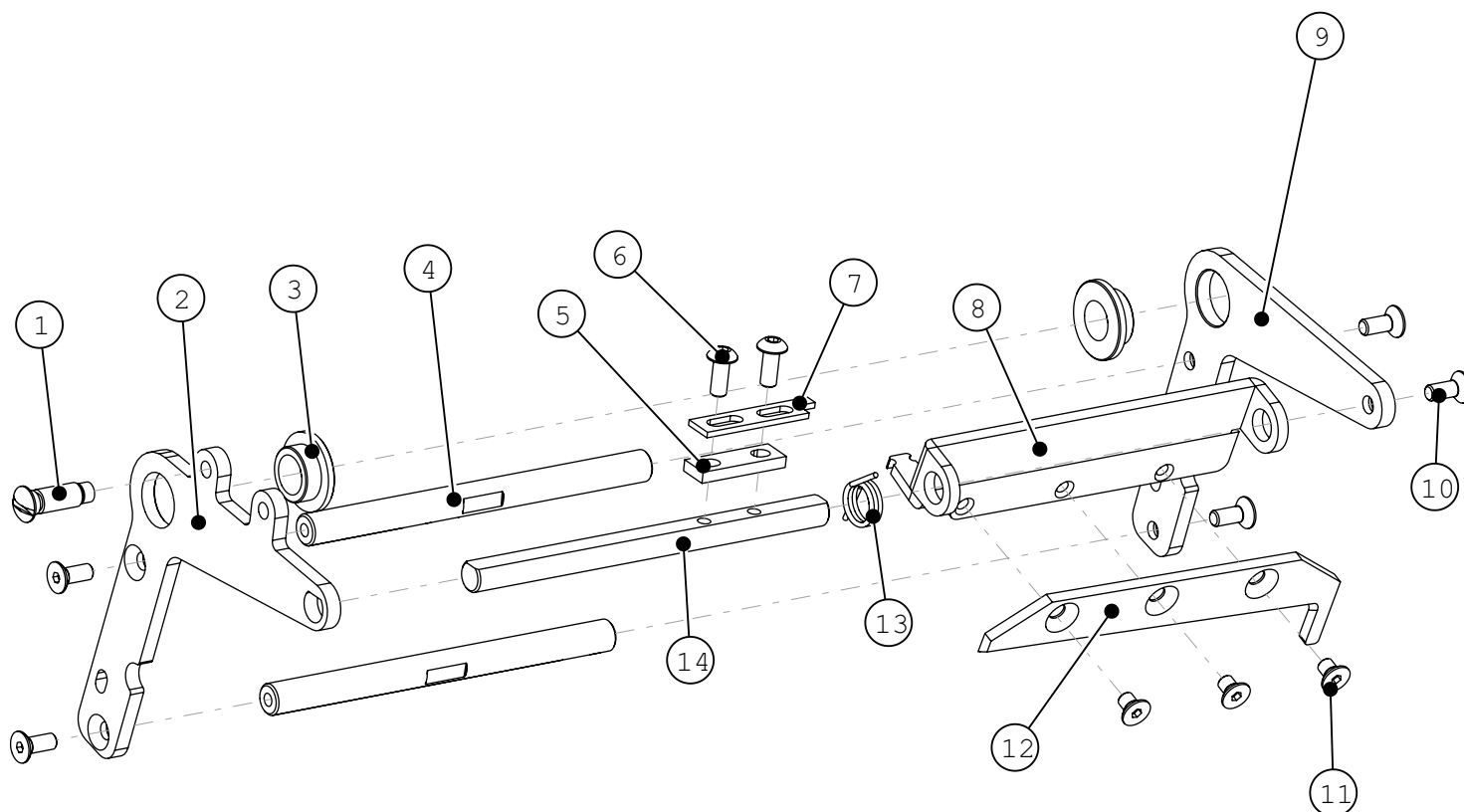
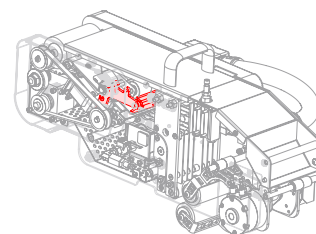
ITEM	PART NUMBER	DESCRIPTION	QTY
1	UPH4903	FLAT MUFFLER G1/8	4
2	UPM8001	PLUG, 1/8" BSPT	1
3	WET0374	MANIFOLD 4 POS	1
4	UPH1496	REDUCER	1

ITEM	PART NUMBER	DESCRIPTION	QTY
5	UPH1504	COUPLING PLUG	1
6	UF3758	M4-0.7 x 25 SHCS	4
7	WET0344	VALVE	4



# APPENDIX B - MACHINE PARTS LIST

## Knife Arm Assembly

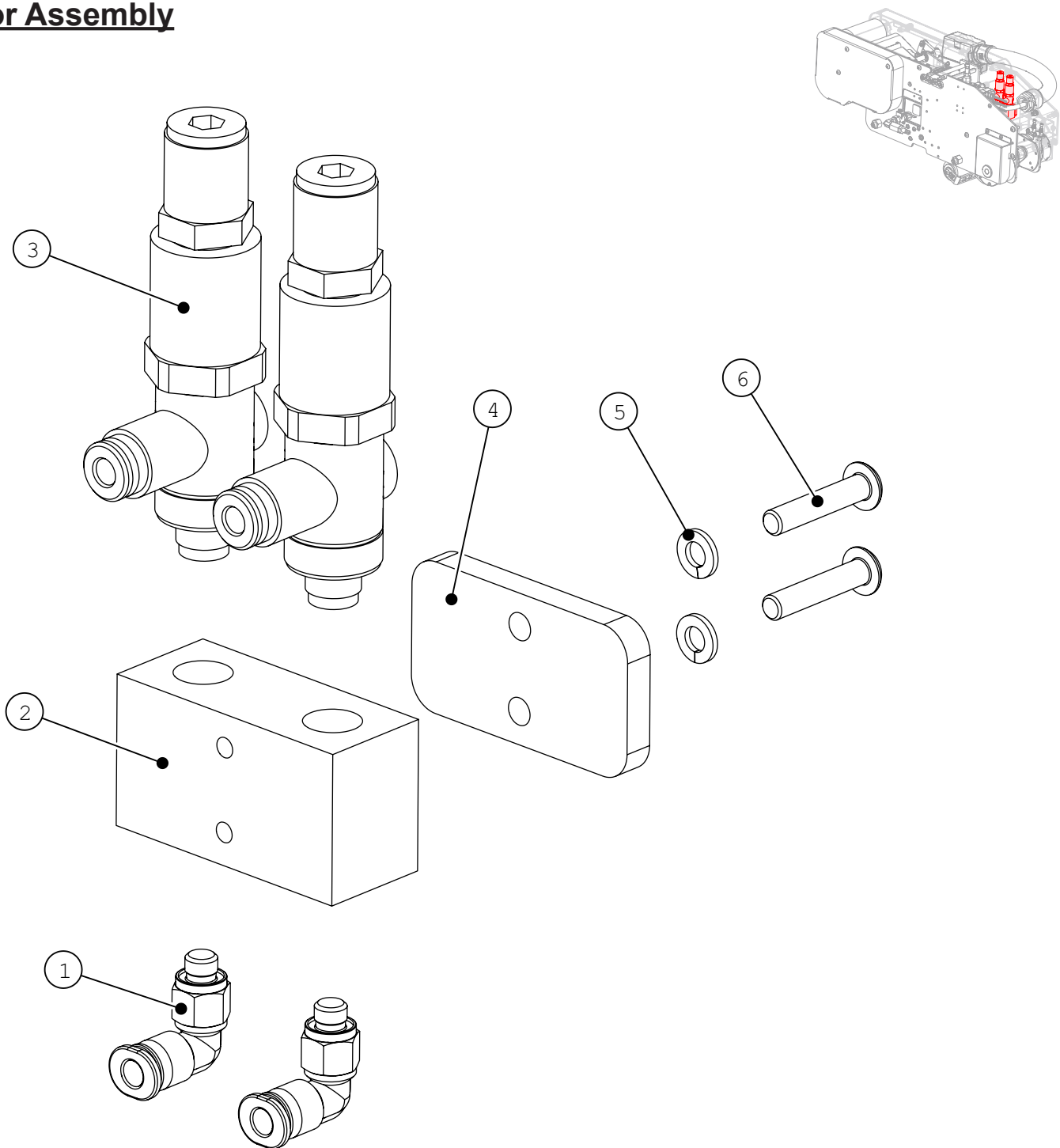


ITEM	PART NUMBER	DESCRIPTION	QTY
1	UF0021	SHOULDER SCREW M5 x 15L	1
2	WET0267	LEFT KNIFE ARM	1
3	WPT0004	OILITE FLANGE BEARING 10mm	2
4	WET0266	KNIFE ARM CROSS SHAFT	2
5	WET0268	TORSION SPRING STOP SPACER	1
6	UF6364	M4-0.7 x 10 BHCS	2
7	WET0269	TORSION SPRING STOP	1
8	WPT0049	WT CUTTER BLADE SUPPORT	1

ITEM	PART NUMBER	DESCRIPTION	QTY
9	WET0264	RIGHT KNIFE ARM	1
10	UF4514	M4-0.7 x 10 FHCS	5
11	UF6351	M4-0.7 x 6 FHCS	3
12	WPT0050	WT CUTTER BLADE	1
13	WET0347	TORSION SPRING	1
14	WET0265	KNIFE ARM TORSION SHAFT	1

# APPENDIX B - MACHINE PARTS LIST

## Regulator Assembly

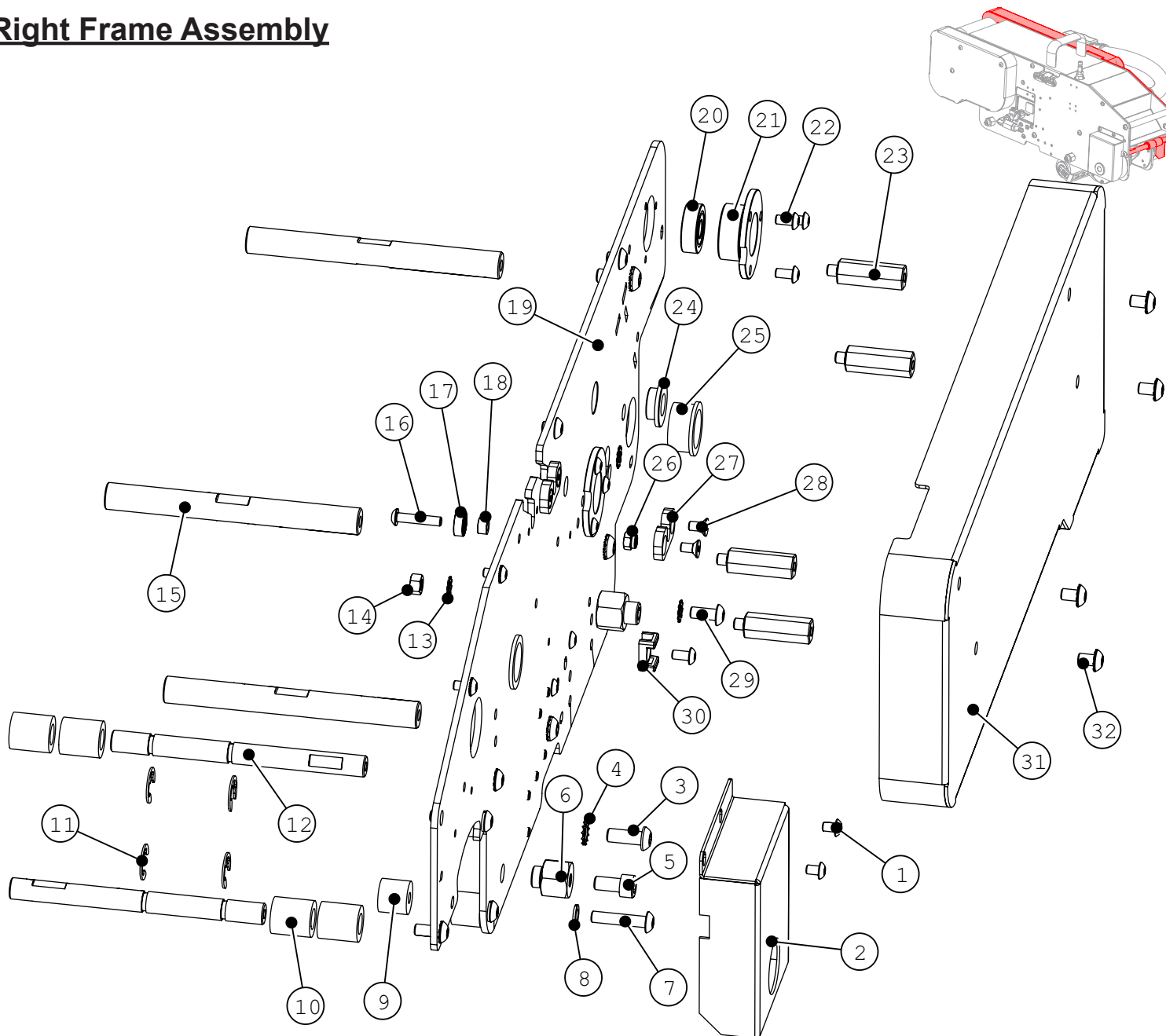


ITEM	PART NUMBER	DESCRIPTION	QTY
1	UPH4905	M5 x 4mm ELBOW FITTING	2
2	WET0210	MANIFOLD	1
3	WET0211	PRESSURE REGULATOR	2
4	WET0228	PLATE	1

ITEM	PART NUMBER	DESCRIPTION	QTY
5	UF3749	SS LW M4	2
6	UF4323	M4-0.7 x 20 BHCS	2

# APPENDIX B - MACHINE PARTS LIST

## Right Frame Assembly

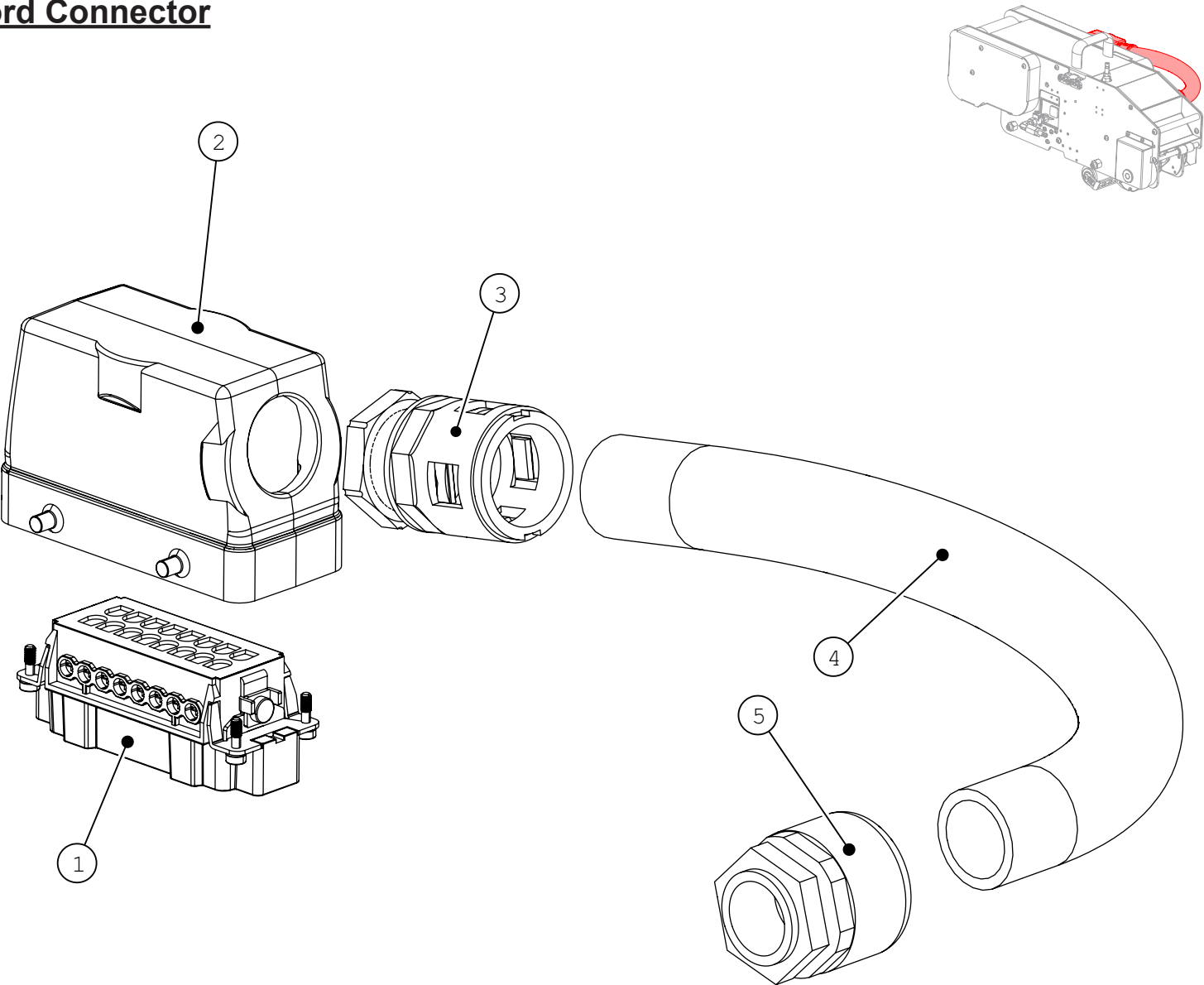


ITEM	PART NUMBER	DESCRIPTION	QTY
1	UF7008	M4-0.7 x 6 BHCS	2
2	WET0323	FLOW CONTROL COVER	1
3	UF6414	M6-1 x 16 BHCS	4
4	UF0168	SS EXTERNAL TOOTH LW M6	4
5	UF3183	M6-1 x 12 SHCS	2
6	WET0215	ADAPTOR, 12L	2
7	UF3279	M5-0.8 x 25 BHCS	3
8	UF7021	M5 LW	3
9	WET0319	TOP FRONT WIPEDOWN SPACER	3
10	WET0218	SPACER, 18L	4
11	UF7019	RETAINING RING 10mm	4
12	WET0311	ROLLER ARM STOP	2
13	UF7022	EXTERNAL TOOTH LW M5	9
14	UF6307	M5-0.8 HEX NUT	1
15	WET0256	CROSS BRACE SHAFT	3
16	UF4323	M4-0.7 x 20 BHCS	1
17	UPH1501	BALL BEARING 11 X 4 X 4	1

ITEM	PART NUMBER	DESCRIPTION	QTY
18	UPH1502	SPACER	1
19	WET0310	TOP LEFT FRAME PLATE	1
20	WET0341	BALL BEARING 608ZZ	2
21	WET0253	BEARING MOUNT	2
22	UF7009	M4-0.7 x 8 BHCS	10
23	WET0216	ADAPTOR, 30L	4
24	WPT0004	OILITE FLANGE BEARING 10mm	1
25	WET0346	BUSHING SB-22	2
26	UF4324	M4-0.7 LOCK-NUT	1
27	WET0255	TAPE CHUTE DETENT	5
28	UF3274	M4-0.7 x 8 FHCS	10
29	UF7011	M5-0.8 x 12 BHCS	3
30	UPM6808	CABLE TIE MOUNT	1
31	WET0322	TOP TAPEHEAD LEFT COVER	1
32	UF7010	M5-0.8 x 8 BHCS	4

# APPENDIX B - MACHINE PARTS LIST

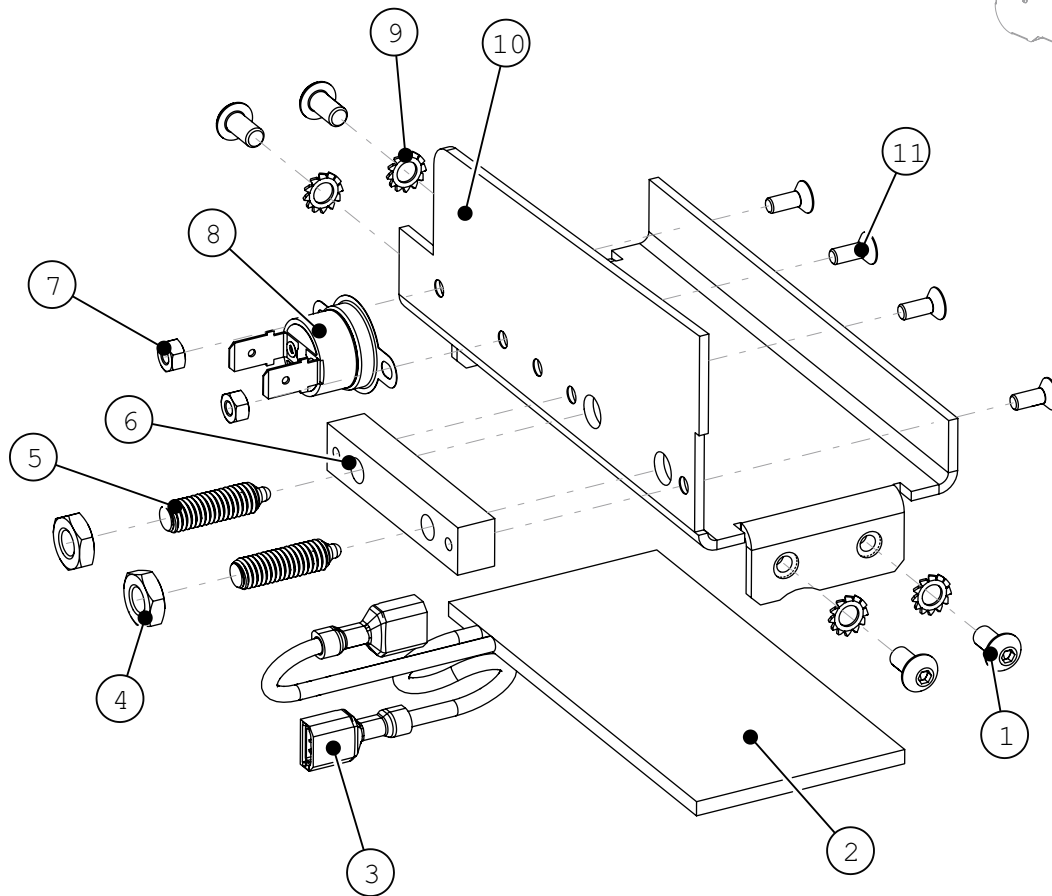
## Cord Connector



ITEM	PART NUMBER	DESCRIPTION	QTY
1	WET0340	CONNECTOR 16 POS	1
2	WET0339	CONNECTOR HOUSING 16 POS	1
3	UPM4905	CORD GRIP	1
4	UPM6231	CORD	1
5	WET0241	CORD GRIP	1

# APPENDIX B - MACHINE PARTS LIST

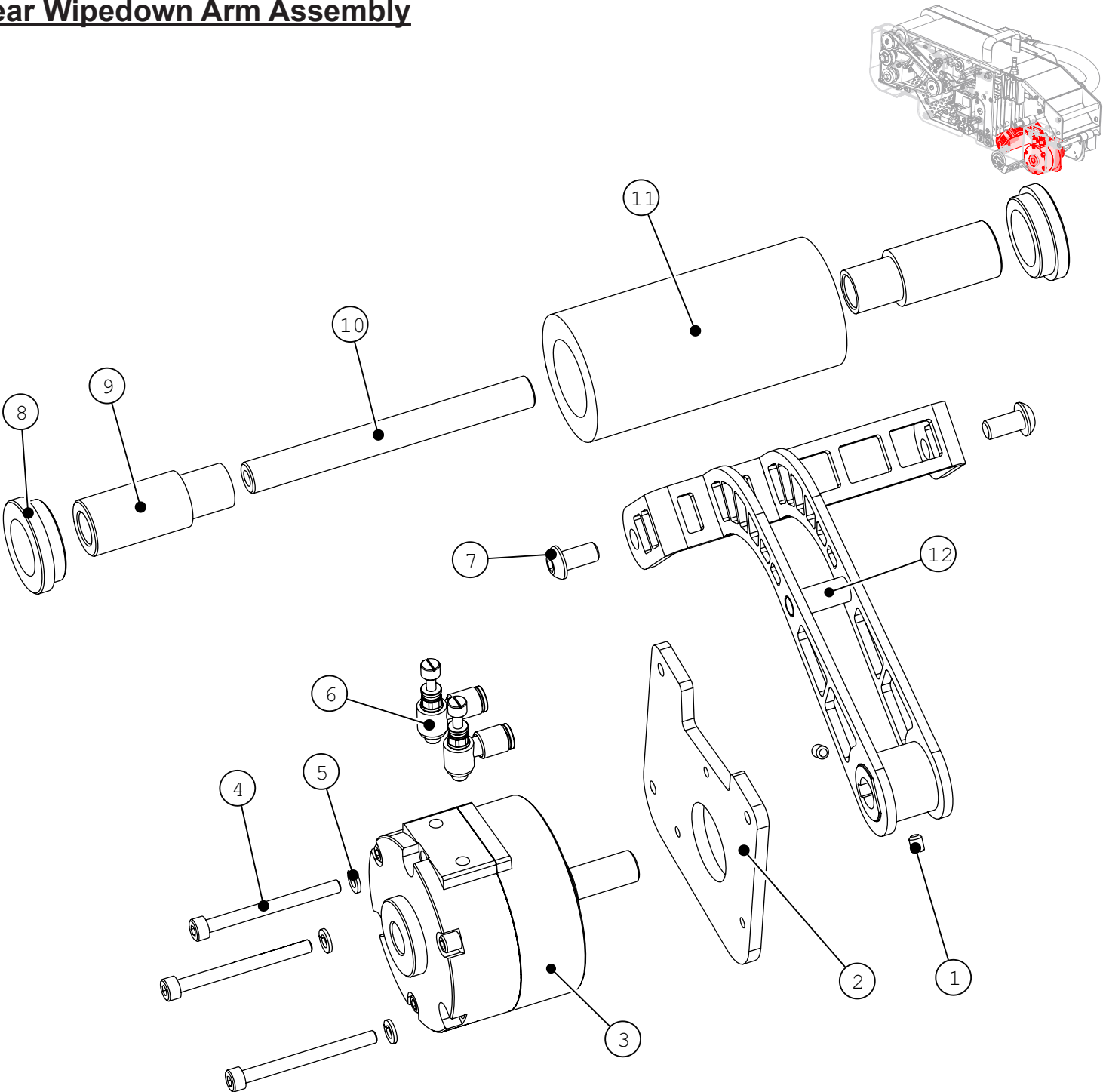
## Water Pot Shelf



ITEM	PART NUMBER	DESCRIPTION	QTY
1	UF7009	M4-0.7 x 8 BHCS	4
2	WET0371	HEATER 24V	1
3	WET0335	FEMALE QUICK DISCONNECT	2
4	UF3361	M6 x 1 HNJ	2
5	WET0342	LONG-NOSE SPRING PLUNGER	2
6	WET0260	SPRING PLUNGER MOUNT	1
7	UF3717	M3-0.5 HNR	2
8	WET0185	THERMOSTAT	1
9	UF0166	SS EXTERNAL TOOTH LW M4	4
10	WET0259	WATER POT SUPPORT	1
11	UF6350	M3-0.5 x 8 FHCS	4

# APPENDIX B - MACHINE PARTS LIST

## Rear Wipedown Arm Assembly

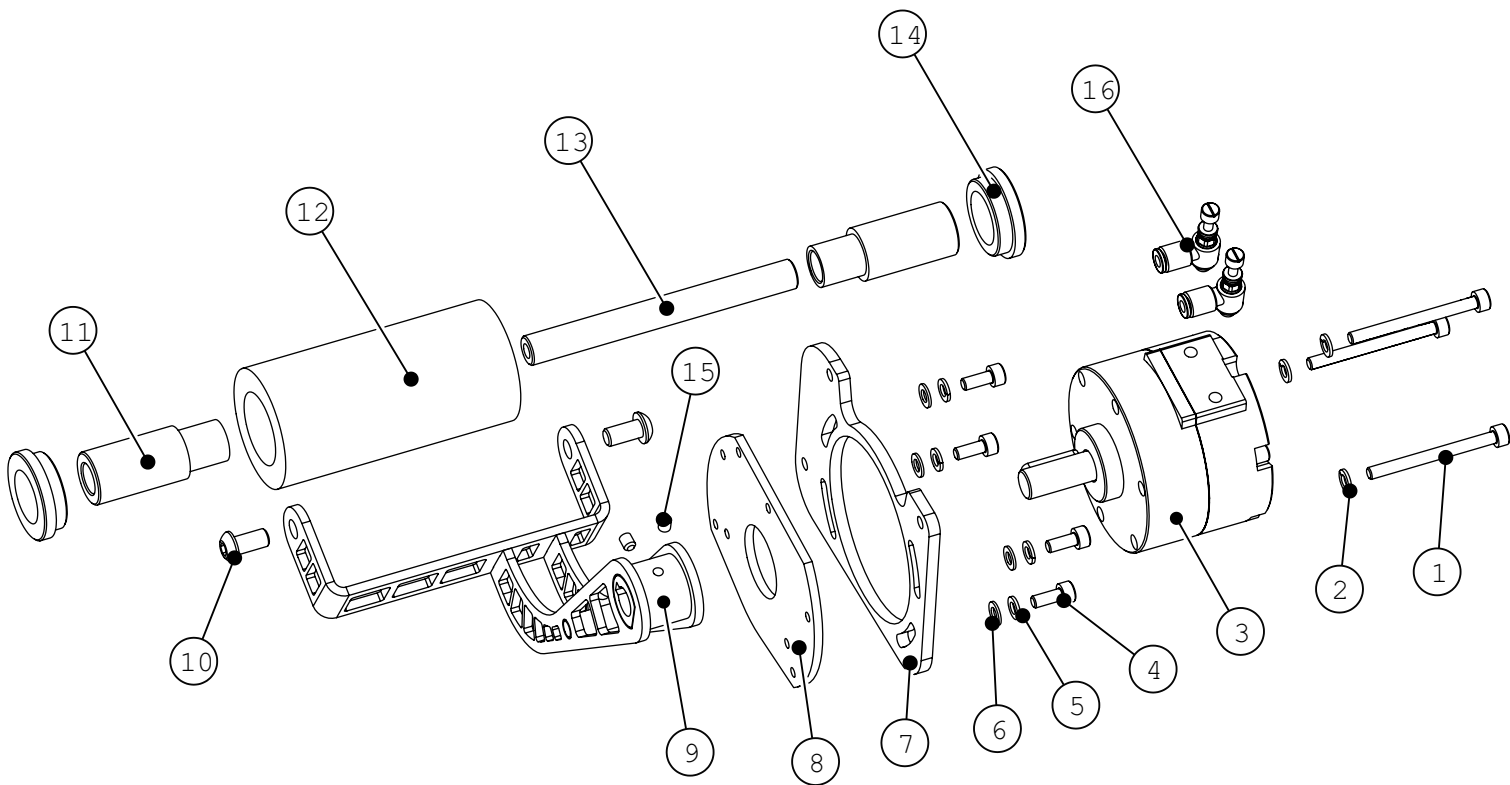
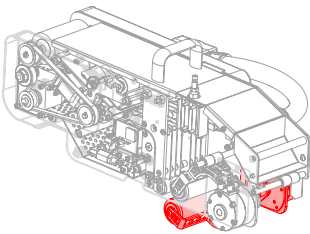


ITEM	PART NUMBER	DESCRIPTION	QTY
1	UF0171	SSS M4-0.7 x 12	2
2	WET0314	TOP REAR WIPEDOWN MOUNT	1
3	WET0343	ROTARY ACTUATOR	1
4	UF0173	M4-0.7 x 45 SHCS	3
5	UF3749	M4 LW	3
6	UPH4904	M5 x 4mm OD, FLOW CONTROL	2
7	UF3278	M6-1 x 12 BHCS	2

ITEM	PART NUMBER	DESCRIPTION	QTY
8	WET0202	COLLAR	2
9	WET0201	ROLLER CORE	2
10	WET0203	SHAFT, dia 10	1
11	WET0005	WIPE ARM ROLLER REAR	1
12	WET0315	TOP ROLLER ARM	1

# APPENDIX B - MACHINE PARTS LIST

## Front Wipedown Arm Assembly



ITEM	PART NUMBER	DESCRIPTION	QTY
1	UF0173	SHCS M4-0.7 x 45	3
2	UF3749	M4 LW	3
3	WET0343	ROTARY ACTUATOR	1
4	UF3759	M4-0.7 x 10 SHCS	4
5	UF3749	M4 LW	4
6	UF6339	M4 FW	4
7	WET0317	TOP FRONT WIPEDOWN MOUNT	1
8	WET0318	TOP FRONT ARM ACTUATOR MOUNT	1
9	WET0315	TOP ROLLER ARM	1

ITEM	PART NUMBER	DESCRIPTION	QTY
10	UF3278	M6-1 x 12 BHCS	2
11	WET0201	ROLLER CORE	2
12	WET0005	WIPE ARM ROLLER	1
13	WET0203	SHAFT, dia 10	1
14	WET0202	COLLAR	2
15	UF0171	SSS M4-0.7 x 12	2
16	UPH4904	M5 x 4mm OD, FLOW CONTROL	2

