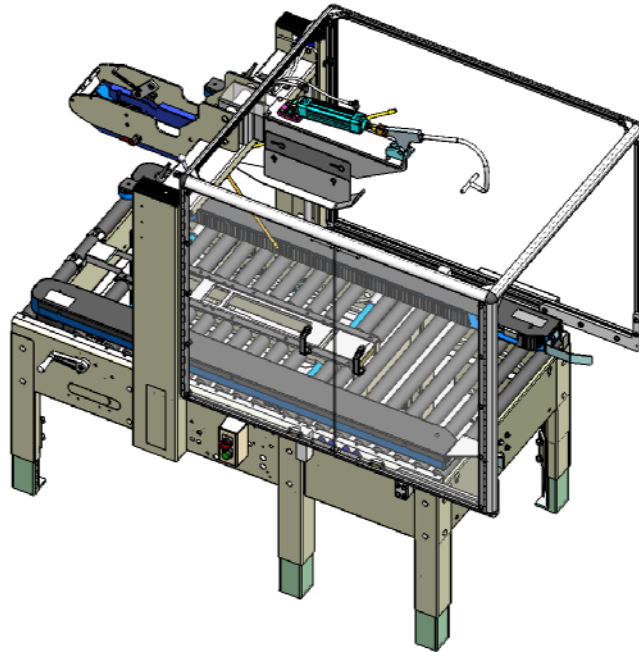




UA 262024 SB
METRIC CARTON SEALER
UM095TW / UM595TW
OPERATION MANUAL
&
PARTS LISTS



OPERATION MANUAL

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SERVICE INSTRUCTIONS

Service

This is the Interpack model UA262024 Carton Sealer Machine you ordered. It has been set up and tested in our factory with Intertape brand tapes. If any problems occur when operating this equipment and you desire a service call or phone consultation, please contact **Intertape**

Technical Support 
888-922-1622 WWW.IPACK.COM

Please provide the customer support coordinator with the machine model number and serial number. If you have a technical question that does not require an immediate response, you may fax it to


888-922-1622 WWW.IPACK.COM

Replacement Parts

Order parts by item number, part name and quantity required. Replacement parts are available from your Authorized Interpack Distributor exclusively.

Should you require assistance selecting the correct part, you may call:



PACKAGING

888-922-1622 WWW.IPACK.COM

MODEL: _____

SERIAL NUMBER: _____

DATE OF PURCHASE: _____

WARRANTY

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 Model Pneumatic Pack Table with the following warranty: All components 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 labour 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 failing due to inadequate cleaning, improper operating environment, improper utilities or operator error.

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.

MACHINE DESCRIPTION

1.1 Description

The UA262024 machine (figure1) is designed to fold and tape carton tops. It is easy to set-up and to operate. It can be adjusted to a wide range of carton sizes.

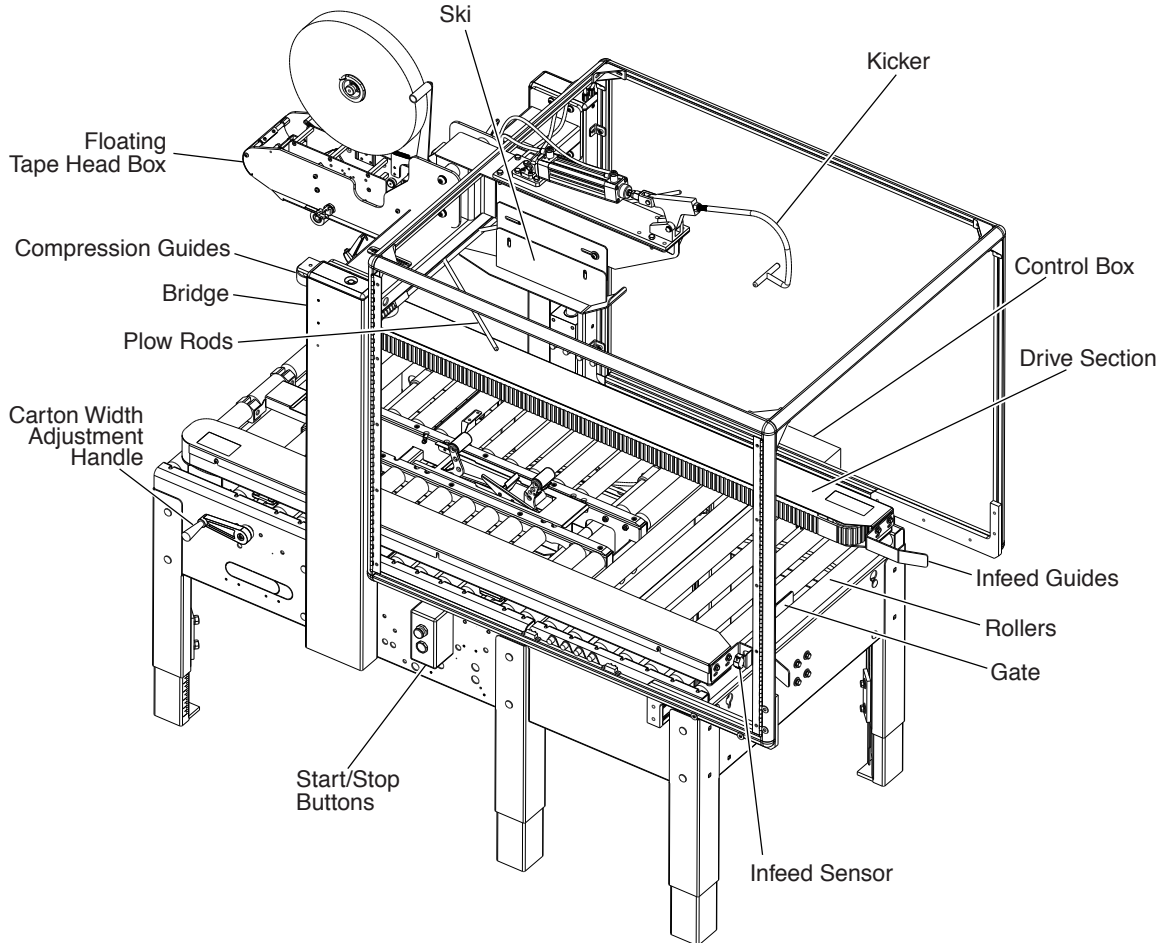


Figure 1

PART	FUNCTION
Start/Stop Buttons	Start and Stop (Emergency Stop) buttons
Rollers	Allows carton to slide through machine
Infeed Guides	Guide carton to feed belts
Gate	Stops carton to allow preceding carton to move forward
Infeed Sensor	Detects rear of carton, triggers gate and kicker action
Drive Sections	Carry carton through machine
Kicker	Folds rear minor flap
Ski	Folds front minor flap
Plow Rods	Fold major flaps
Compression Guides	Position major flaps before taping
Width Adjustment Handle	Adjusts Drive Section to obtain adequate pressure on carton
Bridge	Top moving part of machine.

1.2 How the UA262024 Works – Figures 2 & 3

When a new carton (item 1) reaches the Carton Sealer Machine rollers, it is pick-up by the Drive Sections (belts) (items 2) and carried forward into the machine. The sensor (item 3) detects carton which lowers the gate (item 4) to lets carton through. When sensor detects rear of carton, timer is turned on. When the time has elapsed, kicker (item 5) is triggered and folds rear minor flap. Front minor flap is folded by ski (item 6) as carton goes through. Major flaps are folded by plow rods (items 7) as carton is moved forward. Top and bottom flaps are taped simultaneously by top and bottom tape heads.

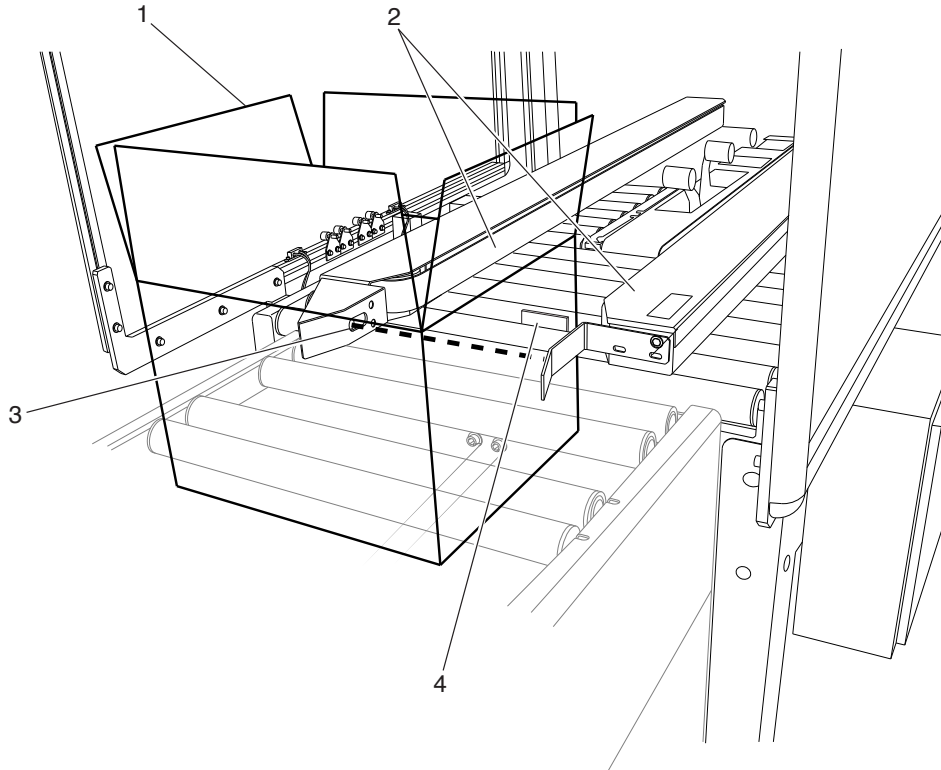


Figure 2

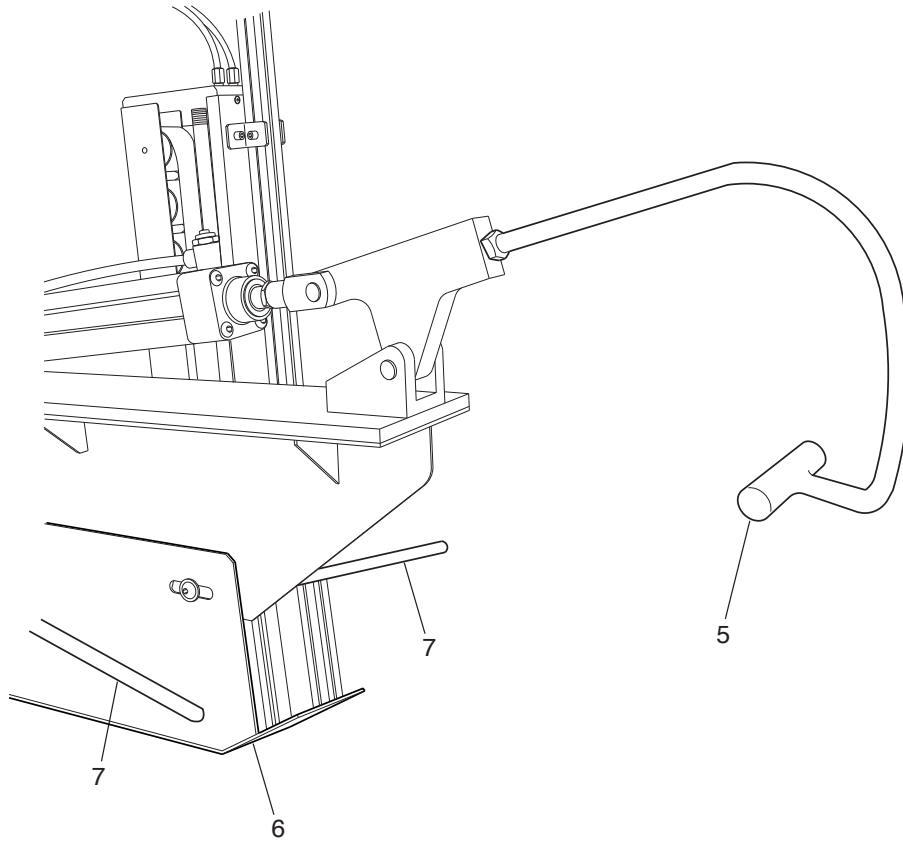


Figure 3

SAFETY

2.1 Safety Rules

The UA262024 has been designed to be extremely safe for operators and bystanders. Nevertheless, accident can happen. Therefore, it is important to follow safe work practice. The operator must read and follow these safety rules when working on or near machine.

- 1. Read this manual thoroughly before operating and safety instructions**
- 2. Only trained personnel are to operate, adjust or service machine**
- 3. Shut off machine in case of emergency. Machine is shut off by pressing emergency stop button (see figure 4)**
- 4. Shut off power before adjusting or servicing machine. Machine is shut off by pressing emergency stop button (see figure 4)**
- 5. Never wear loose clothing, jewels or tie when operating machine**
- 6. Do not modify the equipment in any way. Unauthorized modification may impair the function and/or safety and could affect the Life of the equipment.**
- 7. Carefully read all safety decals on the machine. If they are damaged and become illegible, replace them immediately. (see section 2.2 for safety decal location)**

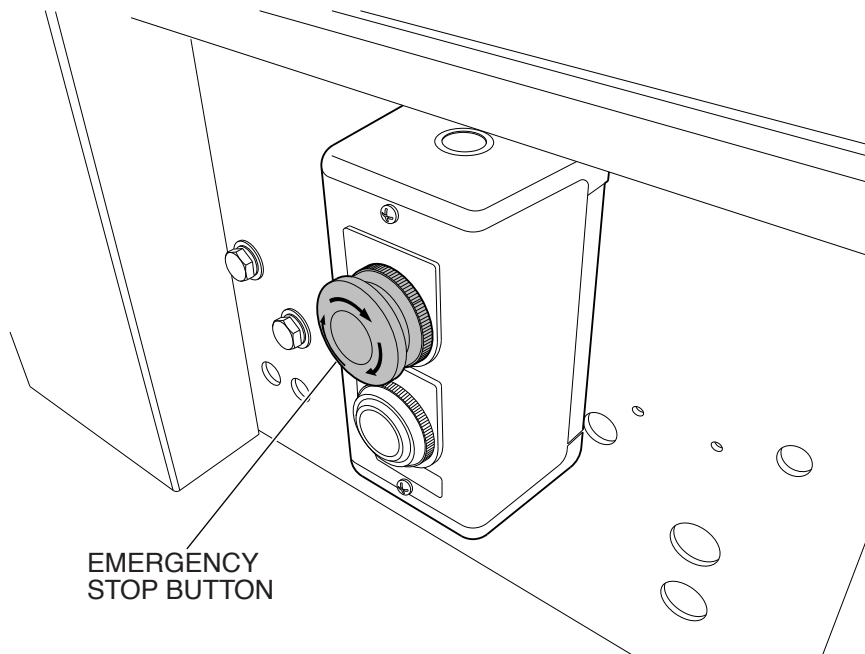


Figure 4 Emergency stop button

2.2 Safety decal location – Figure 5

The figure below shows where the safety decals are located on the machine. Replace any absent or illegible decal. Replacement decals can be found in the Parts section of this manual.

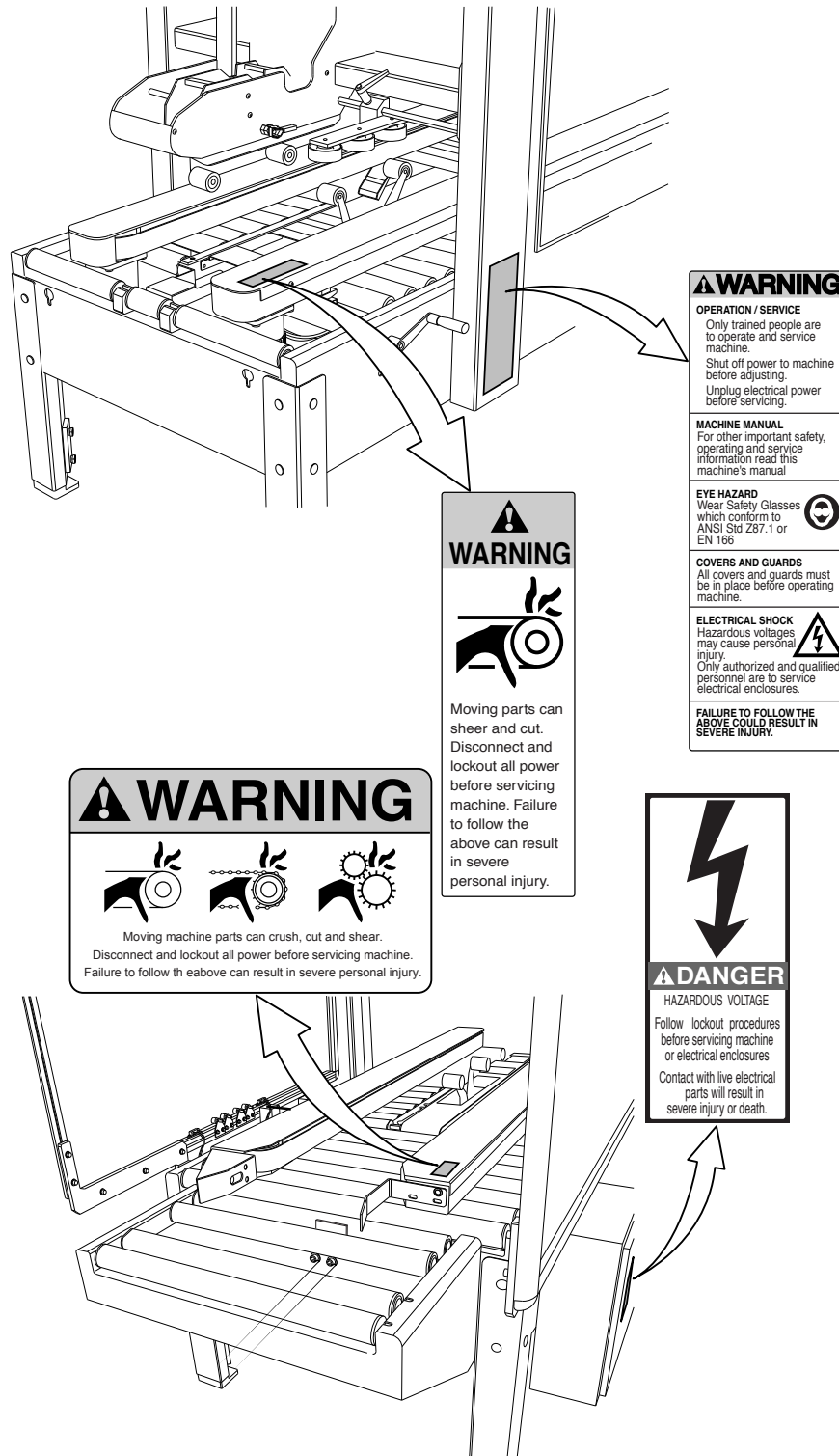


Figure 5 Safety Decal Location

SPECIFICATIONS

3.1 Overall Dimensions

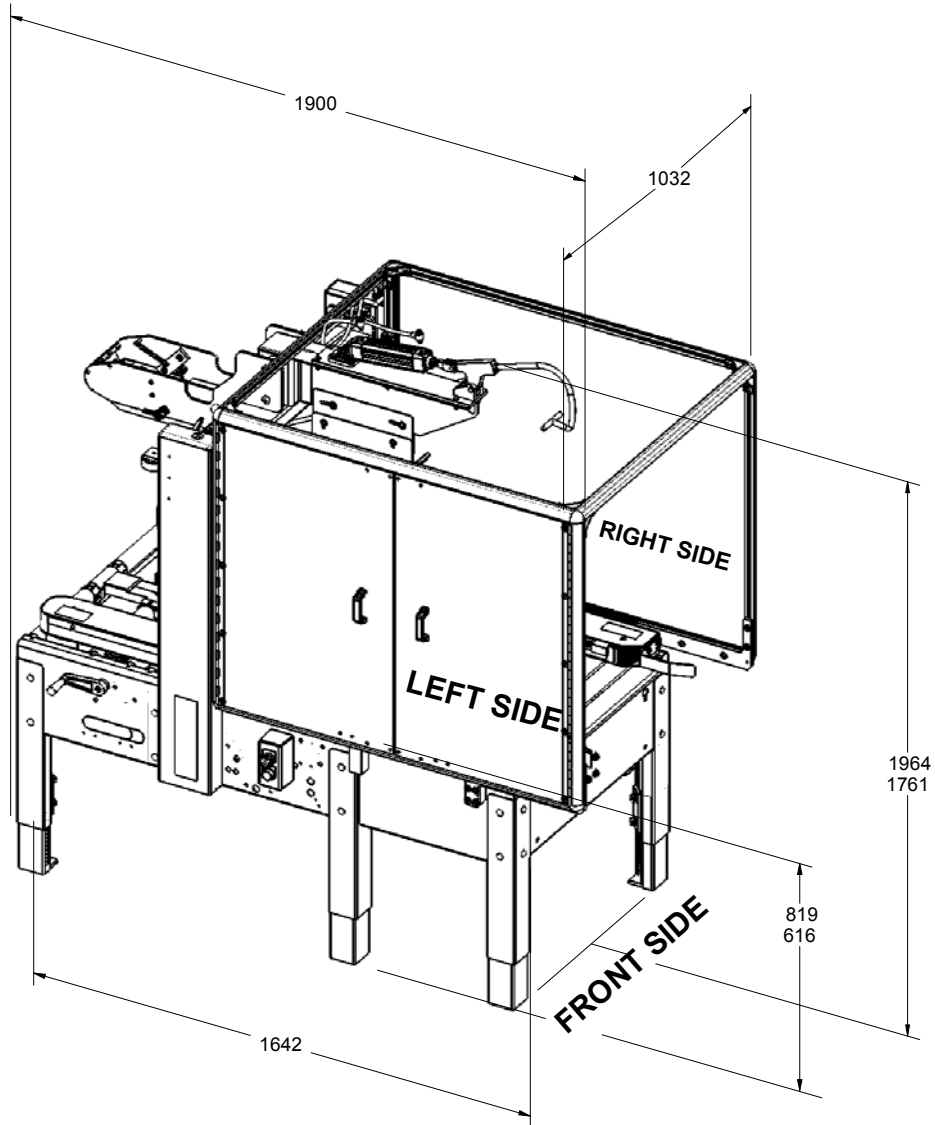


Figure 6 Machine Dimensions

3.2 Machine weight

Machine weight when shipped: 318 kg

3.3 Air requirements

The UA262024 machine requires clean and lubricated air to function properly.

Minimum air pressure: 4.1 bar6

Air intake fitting size: 3/8"

3.4 Power Requirement

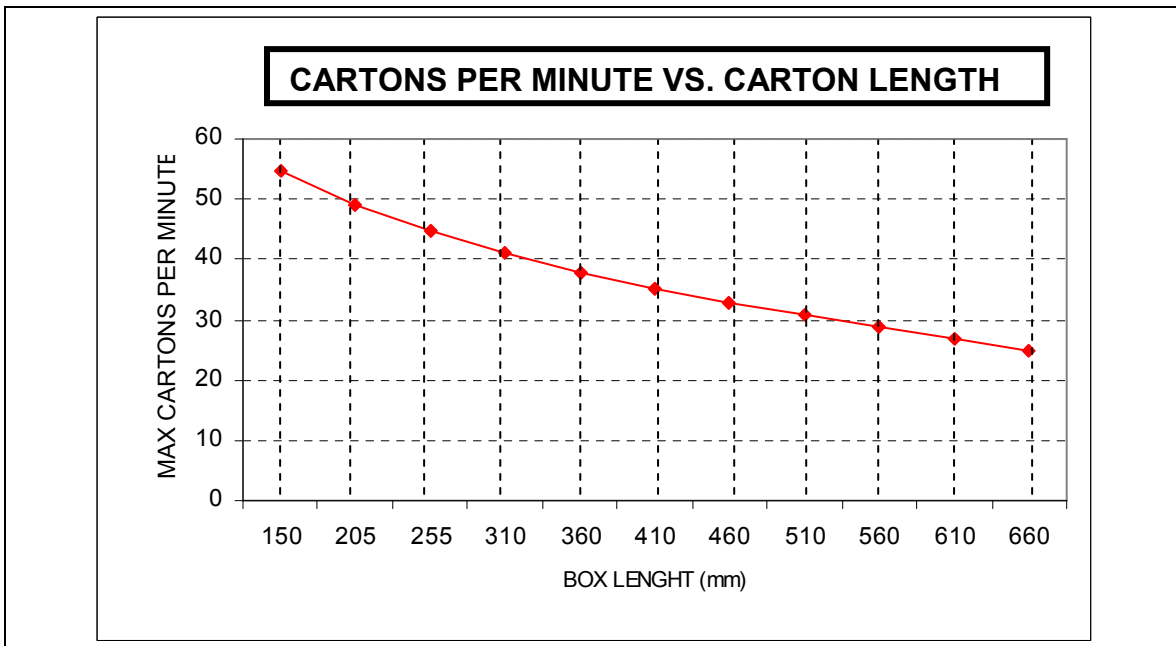
Electrical - 115 VAC, 60 HZ, 7.6 A (400 Watts)

This machine comes standard with a bottom gear motor, a top gear motor and an electrical box.

The electrical box contains a Start switch, the Emergency Stop switch, and a Starting Relay with a thermal over load and can be located on either side of the carton sealer for customer convenience (specify with order). A 1.8 meter standard three conductor power cord with plug is provided for 115V, 60HZ, 15 Amp service. The receptacle providing this service must be properly grounded. Before the machine is plugged into the receptacle, ensure that the switch is OFF and all materials are removed from the machine.

3.5 Operation speed

Actual production rate is dependent on operator’s dexterity and the case size mix. Boxes must be 305mm apart.



3.6 Operating conditions

Use in a dry, relatively clean environment at 40° to 105° F (5° to 40° C) with clean dry cartons.

Note: Machine should not be washed down or subjected to conditions causing condensation on components.

3.7 Tape specifications

Use **Intertape Brand** Pressure Sensitive Carton Sealing Tape.

The machine can accommodate 2 (48mm) or 3 inch (75mm) wide tape, depending on tape heads supplied.

A maximum tape roll diameter of 16 inches (405 mm) on a 3-inch (76.2 mm) diameter core can be installed on the tape head. (Accommodates all Intertape brand film tape machine roll lengths).

The standard Application Leg Length of 2.5 inches (+0.25", -0") (63.5 mm, +6.3 mm, -0 mm) is the factory set length. The tape head can be adjusted to an optional length of 2 inches (+0.25", -0") (50.8 mm, +6.3 mm, -0 mm). Refer to the Tape Head manual for adjustment of tape application leg length.

Note: For further specifications on the tape heads consult the tape head manual for your specific tape head.

3.8 Carton specifications

Type

Style: regular slotted containers (RSC)

Material

125 to 275 bursting test, single or double wall B or C flute

The carton sealer can accommodate most cartons within the size ranges listed above. However, if the box length (in direction of seal) to box height ratio is 0.75 or less, then several boxes should be test run to assure proper machine performance. The formula is as follows:

$$\text{Carton length} > 0.75 \text{ Carton height}$$

	Height (mm)	Width (mm)	Length (mm)
Minimum size	114.3	88.9 (50mm tape) 114.3 (75mm tape)	152.4
Maximum size	609.6	508	660.4

SET-UP PROCEDURES

4.1 Receiving and Handling

The machine is shipped in a box and bolted to a wooden pallet. Upon receiving the machine, follow these procedures handling when the machine.

1. Remove the strapping and the staples at the bottom of the box.
2. Lift and remove box
3. Remove the mounting bolts and nuts which secure the machine to the pallet
4. Lift the machine off the pallet and install it on your packaging line. Use a fork lift to lift and move the machine as shown in figure 7. **Be careful not to damage the control box.**

WARNING! Do not use a crane and chains to lift the machine. The machine could become unstable and cause material damage or serious injuries.

5. Remove all tie wraps and other shipping material from machine

NOTE: After unpacking the machine, look for any damage that may have occurred during shipping. Should the machine be damaged, file a claim with the transport company and notify your Intertape representative.

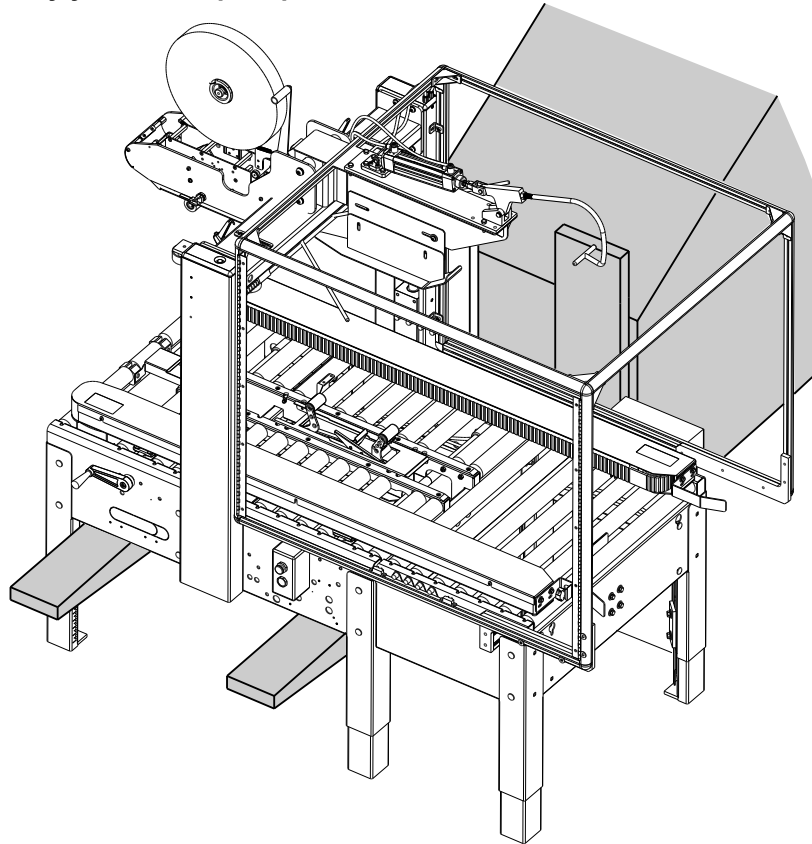


Figure 7 Use fork lift to handle machine

4.2 Machine Height Adjustment

Follow this procedure to adjust the height of machine:

- Make sure machine is installed on near level ground
- Use adjustable legs (figure 8) to adjust machine height and level. Machine height should be adjusted to incoming conveyor height.

To adjust leg height:

1. Loosen bolts (item 2)
2. Pull leg (item 1) to desirable length
3. Tighten bolts (item 2)

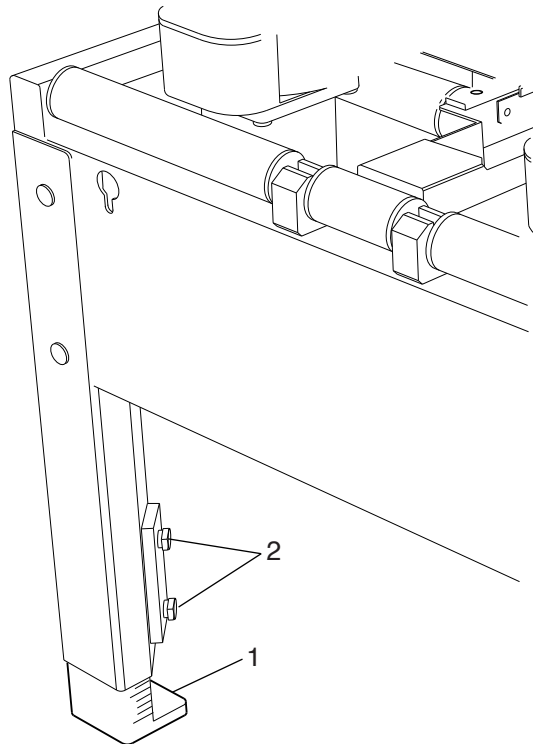


Figure 8 Adjustable legs

4.3 Pneumatic connection

This machine is pneumatically powered. An air supply must be connected to the Air Intake Filter/Regulator as shown in figure 9. Air must be clean and lubricated.

Minimum required air pressure: 60 psi (4.1 bar)

Air intake fitting size: 3/8"

To adjust air pressure:

1. Pull adjustment knob
2. Turn adjustment knob clockwise to increase pressure
3. Push back knob

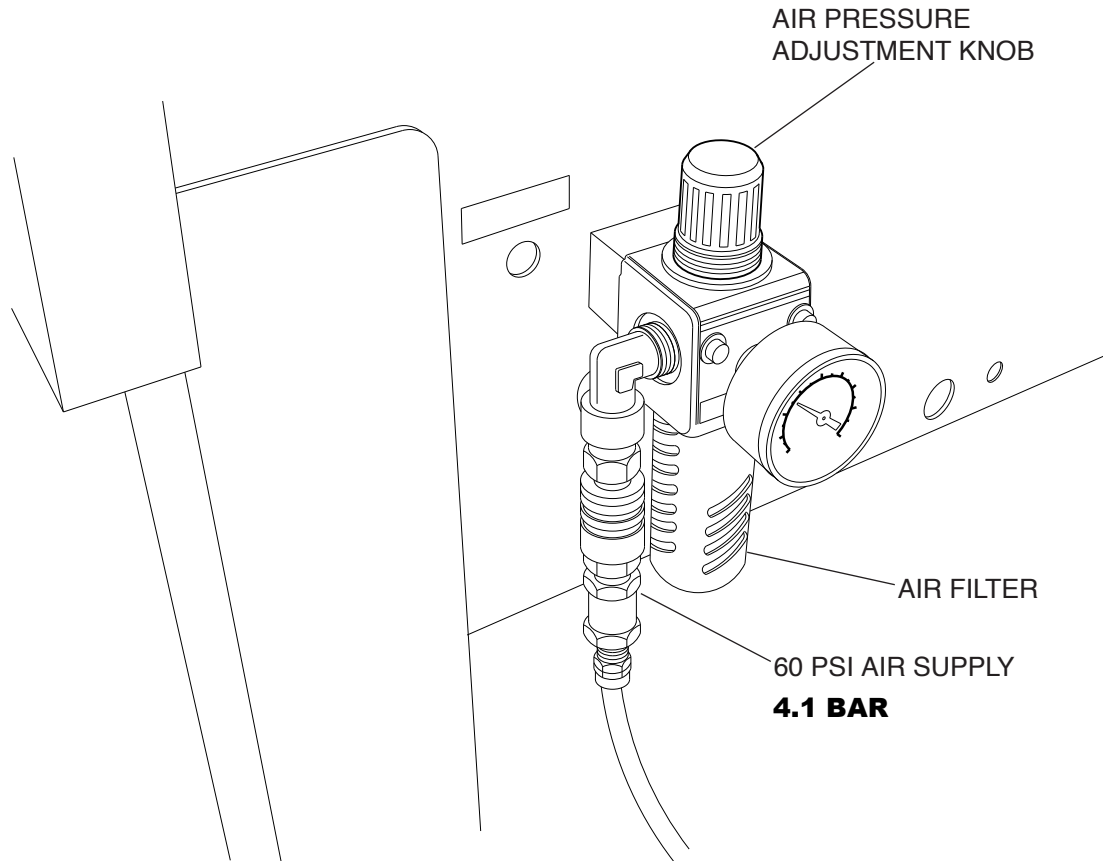


Figure 9 Pneumatic connection

4.4 Height and Width Adjustment

The UA262024 is designed to handle a full range of carton sizes. Follow these procedures to set-up the machine to the proper carton length and width.

Height adjustment:

- 1. Press the emergency stop button (figure 4) to shut-off machine.**
- 2. Unlock the bridge using the bridge lock lever (figure 10).**
- 3. Raise the bridge manually, enough to clear the height of a carton.**
- 4. Set a carton on the machine, as shown in figure 11. Make sure orientation of box is correct.**
- 5. If you plan on over-filling the cartons, unlock the floating mechanism on the tape head as shown in figure 11. Otherwise, make sure floating mechanism is locked.**

Note: The purpose of the floating head is to absorb the pressure caused by over-filled cartons.

- 6. Lower the bridge manually until it is well rested against the carton, without squeezing it down.**
- 7. Lock the bridge using the bridge lock lever (figure 10). Make sure to hold the bridge down while locking it.**

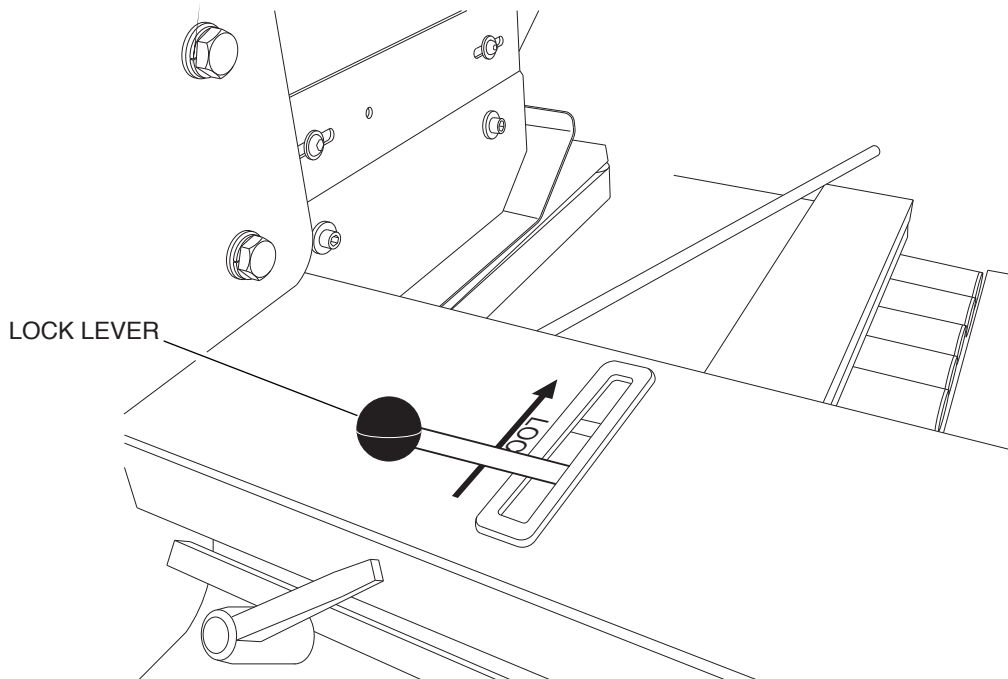


Figure 10

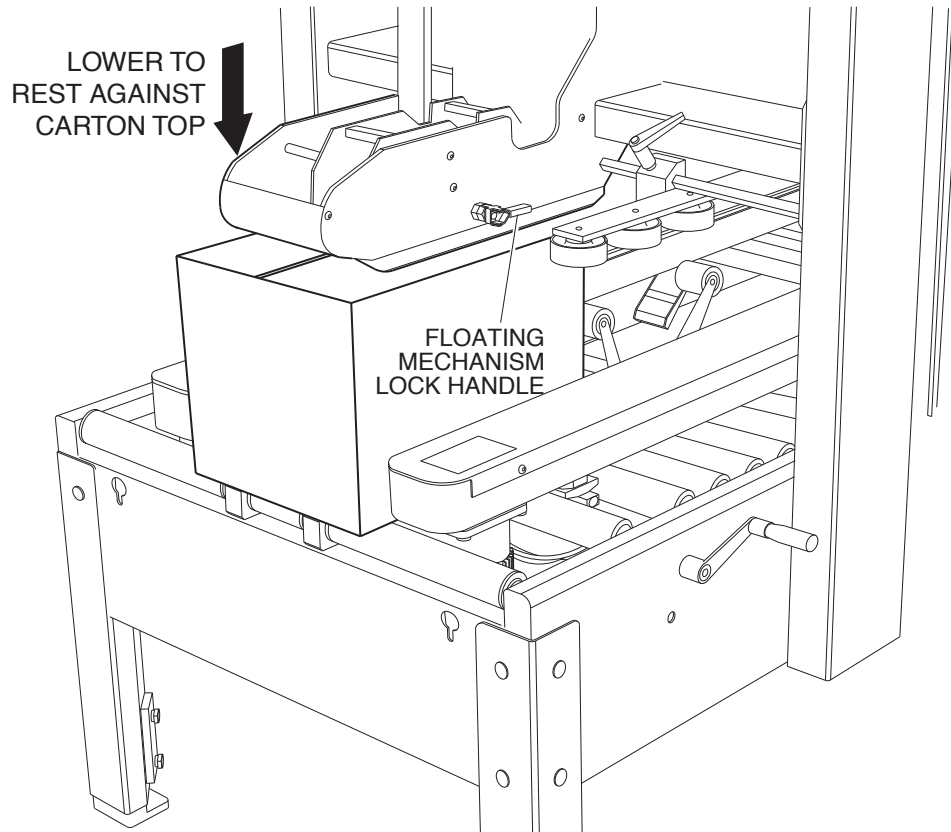


Figure 11

Width adjustment:

1. Press the emergency stop button (figure 4) to shut-off machine.
2. Use the width adjustment handle to spread the drive sections, enough to clear a carton.
3. Set a carton on the machine, as shown in figure 12.
4. Use the width adjustment handle to move the drive sections closer together until they lightly squeeze the carton, as shown in figure 12.

NOTE: The carton must only be slightly squeezed by the drive sections

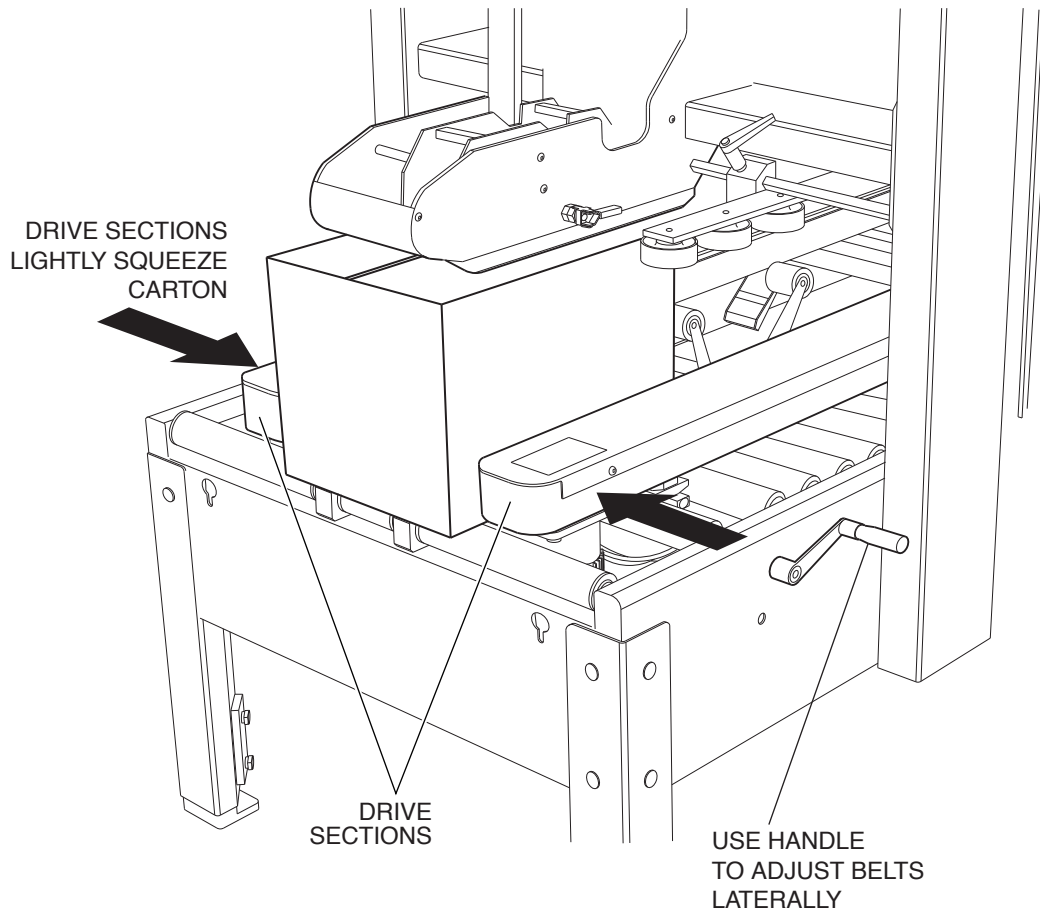


Figure 12 Width adjustment

NOTE: When width and length adjustments are completed, pull up emergency stop button to turn machine back on.

4.5 Compression Guides Adjustment (figure 13)

Compression guides (figure 13) must be adjusted to lightly squeeze the upper part of the carton. This allows the two major flaps to contact each other and therefore insures a better seal. To adjust, loosen the handle then slide guide laterally until pressed against box.

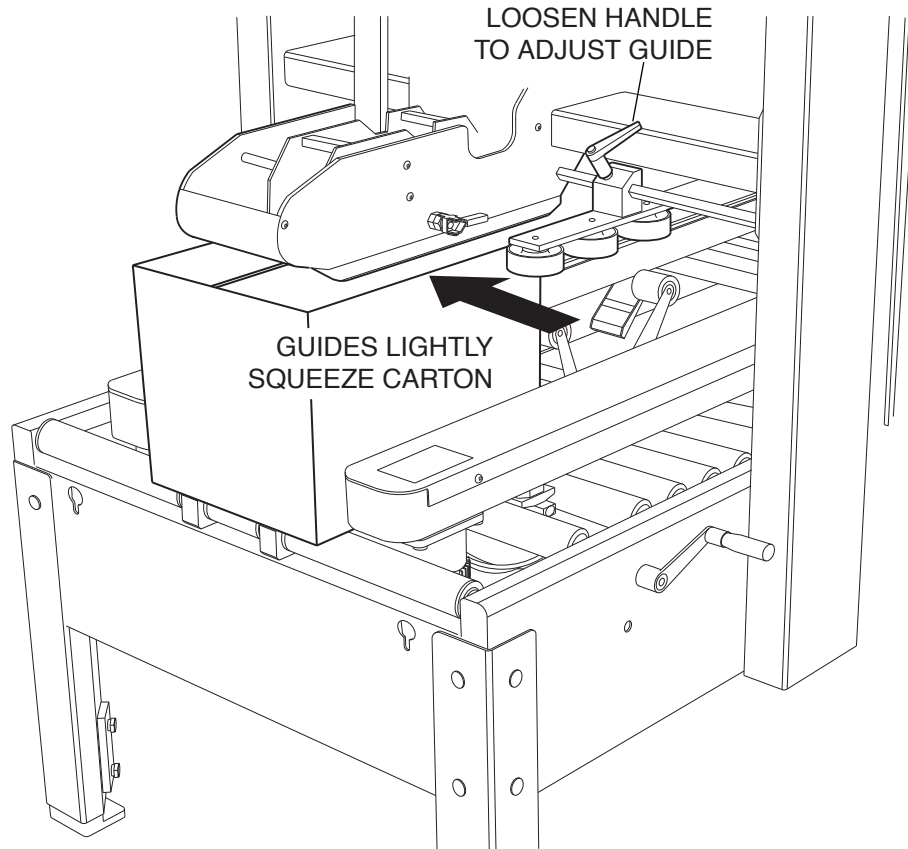


Figure 13

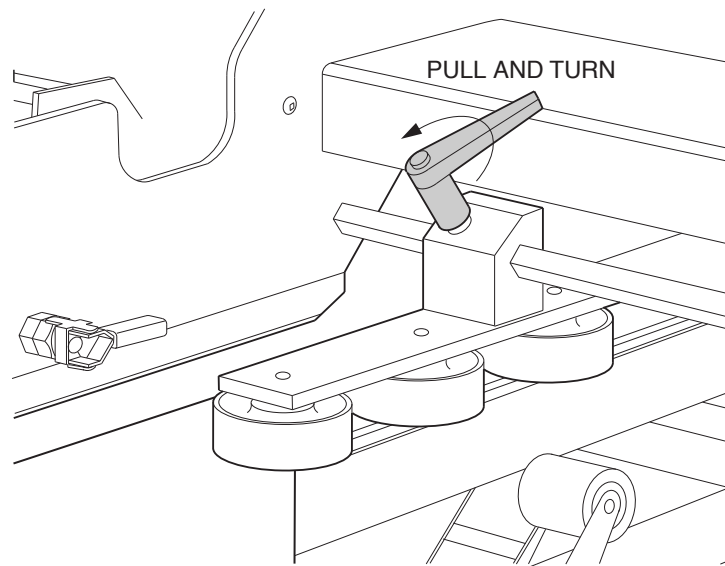


Figure 14

4.6 Kicker Adjustment (Figures 15 & 16)

Kicker must be adjusted so that rear minor flap is folded correctly. The kicker must be adjusted according to the flap length. The kicker is factory adjusted to work with an average size carton. If you are operating with longer flaps (20" cartons), the kicker must be shortened so it does not interfere with the carton waiting behind. Shorten if necessary as shown in figure 16.

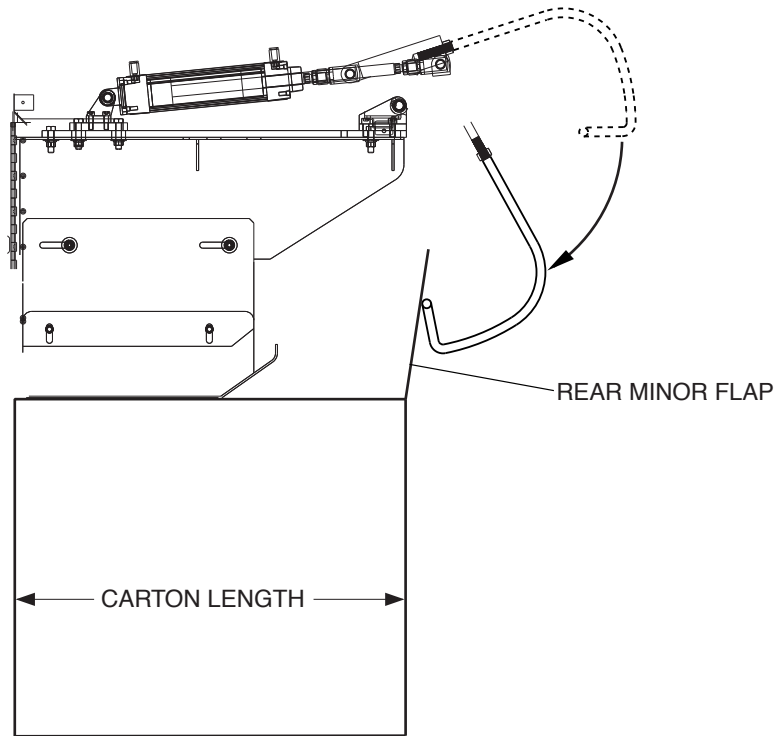


Figure 15

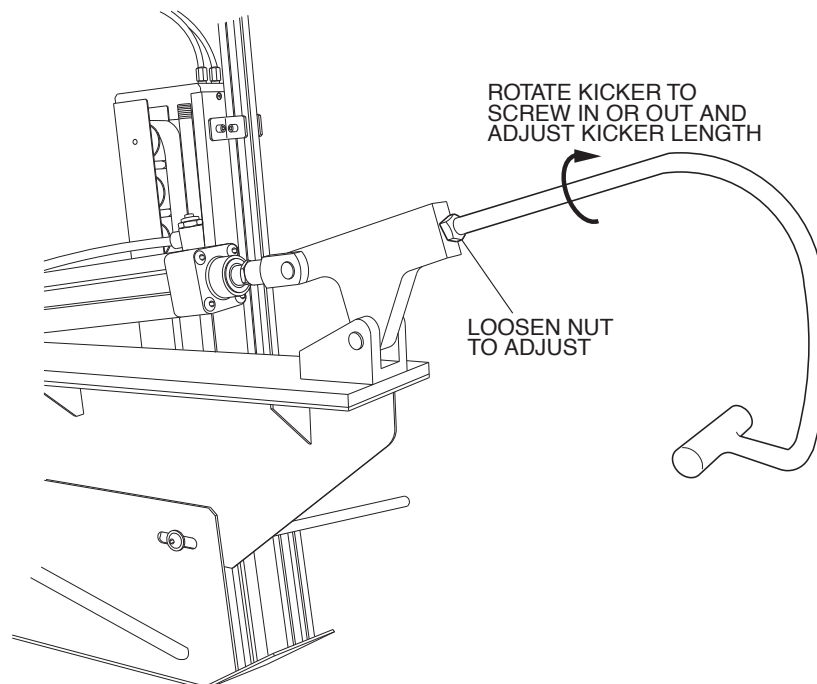


Figure 16

4.7 Plow Rod Adjustment

The plow rods are used for folding the major flaps. As the carton passes through the machine, the plow rods apply pressure to both flaps. The rods should be adjusted to obtain 90 degrees between each other, as shown in figure 17. For small cartons, reduce angle to approx. 70 degrees.

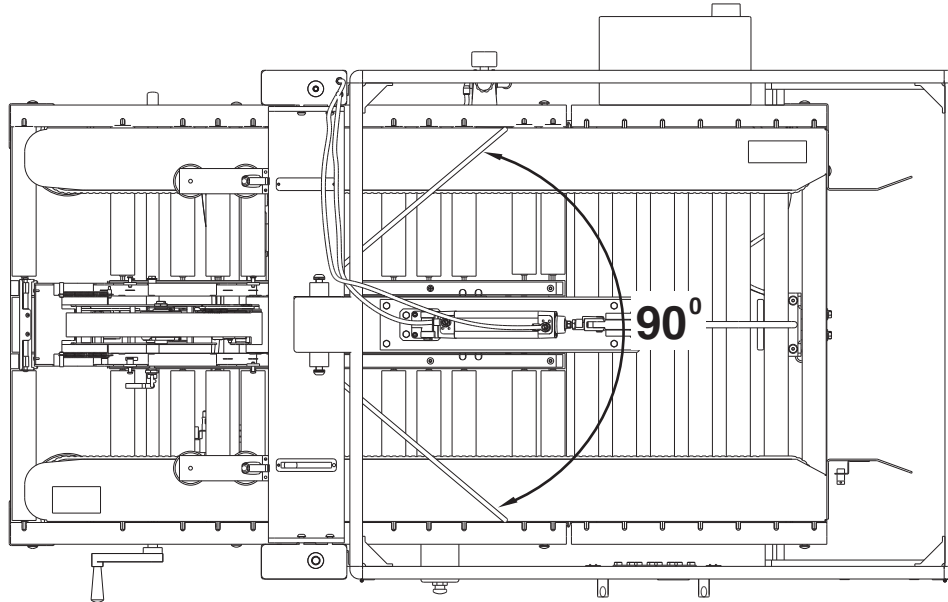


Figure 17 Plow Rod adjustment

4.8 Ski Adjustment (figure 18)

The ski is used for folding front minor flap. As the carton passes through the machine, the ski applies pressure to the front minor flap to fold it. The ski can be adjusted both vertically and horizontally. The vertical adjustment is done according to the carton height. The horizontal adjustment is done according to the carton width. For narrow boxes, move ski forward to allow rear flap to reach the ski.

To adjust ski vertically:

1. Raise ski enough to clear carton.
2. Set carton underneath ski.
3. Loosen the two screws and lower ski onto carton.
4. Tighten screws.

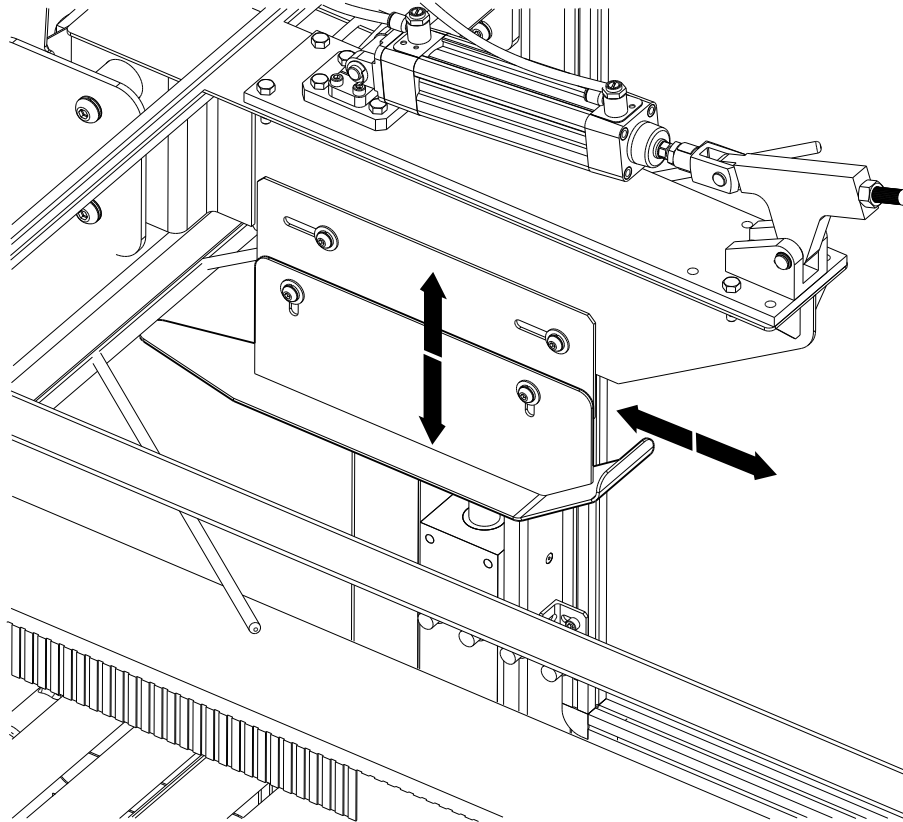


Figure 18 Ski adjustment

OPERATING INSTRUCTIONS

WARNING! For safe operation of the UA262024, you must be a qualified and authorized operator. To be qualified, you must read and understand the written instruction supplied in the Operator's manual and know the safety rules and regulations for the job.

NOTE: Use only new cartons on this machine. Old or used cartons may prevent the machine from working properly.

5.1 Start and stop

1. Press the START button (figure 19)
2. To stop machine, press the STOP button.

NOTE: The machine will not start until the STOP button is released. To release the STOP button, turn button clockwise and pull.

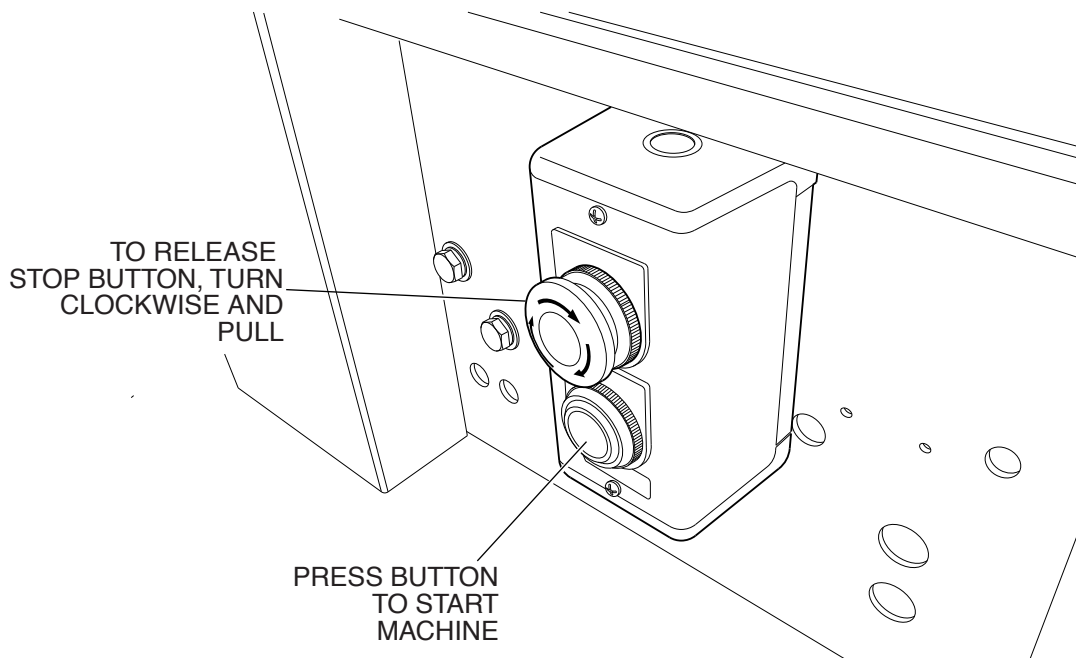


Figure 19 Start and stop buttons

5.2 Limit switches

The UA262024 is equipped with 3 limit switches (figure 20) located under the machine. As the carton width is modified (section 4.4), these preset limit switches, which are connected to the PC controller in the control box, will modify the delay (through timers) between the cartons. This delay affects the drive sections which move the cartons

forward and the kicker which folds the rear flap. You do not need to adjust these limit switches and it is strongly recommended NEVER to adjust the PC controller.

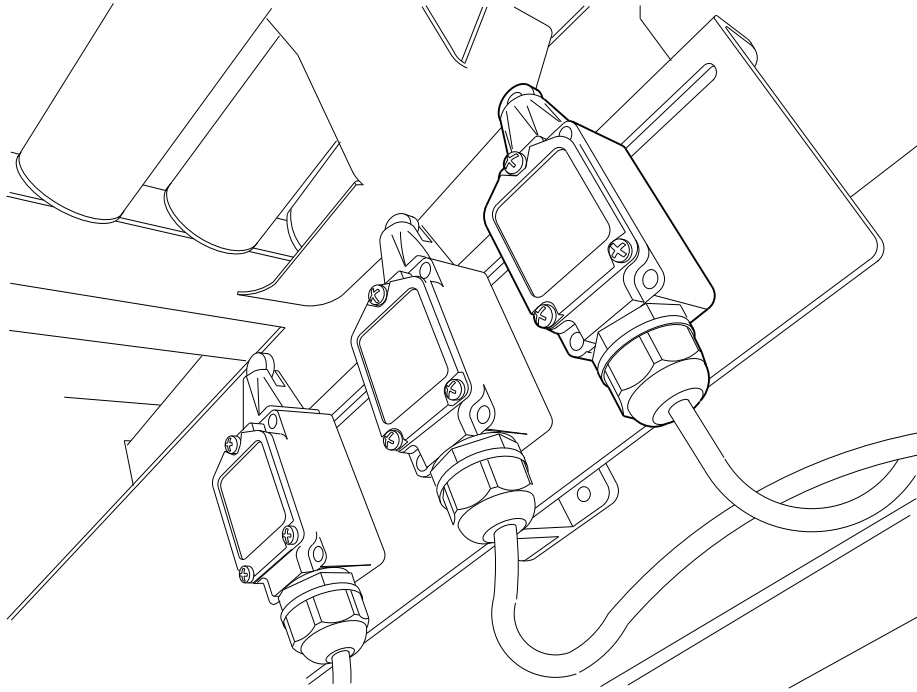


Figure 20 Limit Switches

MAINTENANCE

The UA262024 is a pneumatic machine and requires minimum maintenance. Bearings and cylinders are sealed and require no lubrication. The only maintenance required is listed below.

- Regularly clean the machine using pressured air to remove carton dust from the moving parts.
WARNING! Always wear safety glasses when using pressured air.

- Clean or change the air filter (figure 9) when necessary. Refer to the Spare Parts section of this manual for air filter part number.

- Replace conveyor belts (figures 21 & 22) when worn out or too loose. To replace a belt:
WARNING! ALWAYS TURN POWER OFF BEFORE REPLACING BELT

1. **Turn power off and disconnect power cord.**
2. Remove belt cover by loosening both screws (item 1) and lifting cover.
3. Remove belt manually (DO NOT loosen tension mechanism (item 2)).
NOTE: Remove belt first on motor side.
4. Install new belt. Install only bottom portion of belt as shown in figure 22. The spinning of the belt will automatically lower the belt in place.

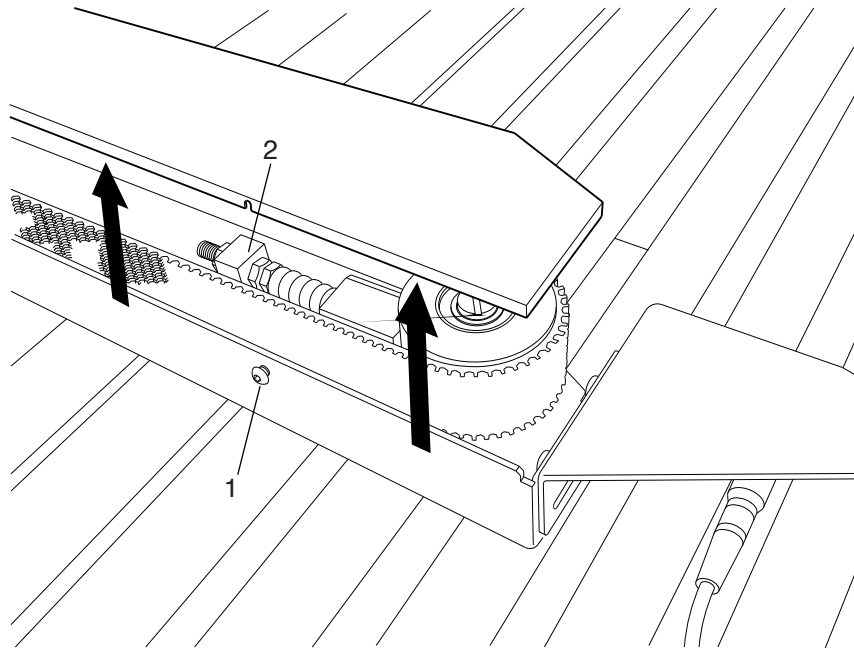


Figure 21 Remove Cover

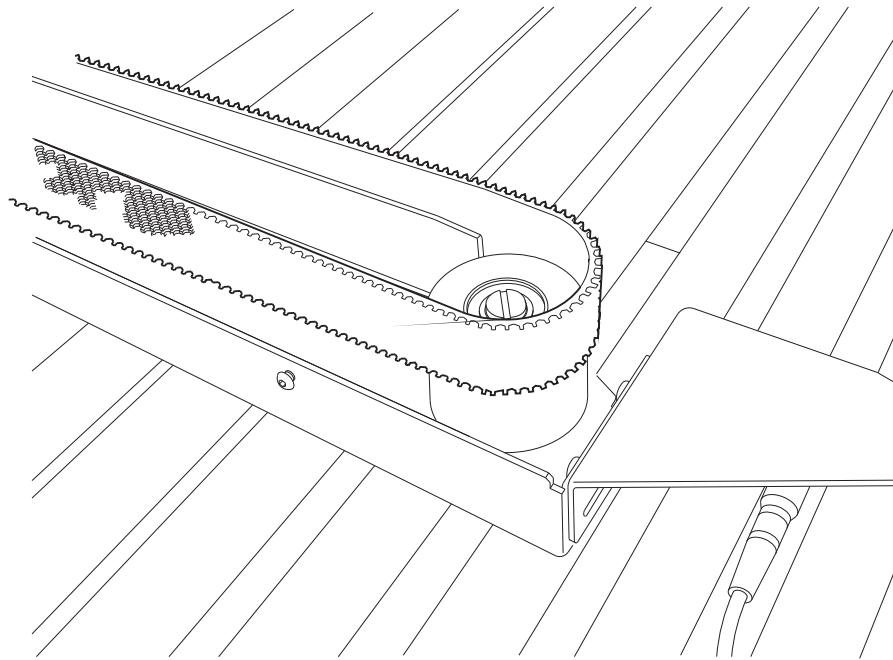


Figure 22 Install new belt

TROUBLESHOOTING

PROBLEM	POSSIBLE CAUSE AND SOLUTION
Nothing happens when carton reaches infeed conveyor	No air in system. Make sure air connection is made and air pressure is sufficient Emergency stop button pressed down. Pull up button.
Conveyor belts are working but carton is not moving	Belts are not adjusted to squeeze box sufficiently. Adjust conveyor belt width. Check doors. Make sure doors are closed.
Single Locking System is locked, still the Bridge of Top Tape Head Box is loose on one side	Brass pin is worn out and has lost contact with column shaft. Lock Tape Head Box at its maximum height, exceptionally with air supplied and at mode 3 (Hi-start). On loose side, under the bridge, remove socket completely from screw head, unscrew flange screw with 3/4" key, replace flange screw and re-insert socket. Refer to Figure 23.
Carton does not go through	Check ski adjustment (section 4.7) Check tape head box height (section 4.6)

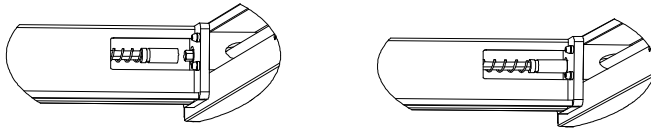


Figure 23

RECOMMENDED SPARE PARTS

We recommend that you stock the following spare parts:

DESCRIPTION	PART NUMBER	RECOMMENDED QUANTITY
Motor 1/3 hp, 115v 85 rpm universal	UPM7116	1
Belt, drive	UPM3544	2
Comp.spring swivel t.h. ass'y	UPM1068	2
Seal kit for 40mm iso cylinder	UPM3757	2
Filter for filter regulator unit	UPM3274	1
Fuse, 2 amps	UPM0002	1

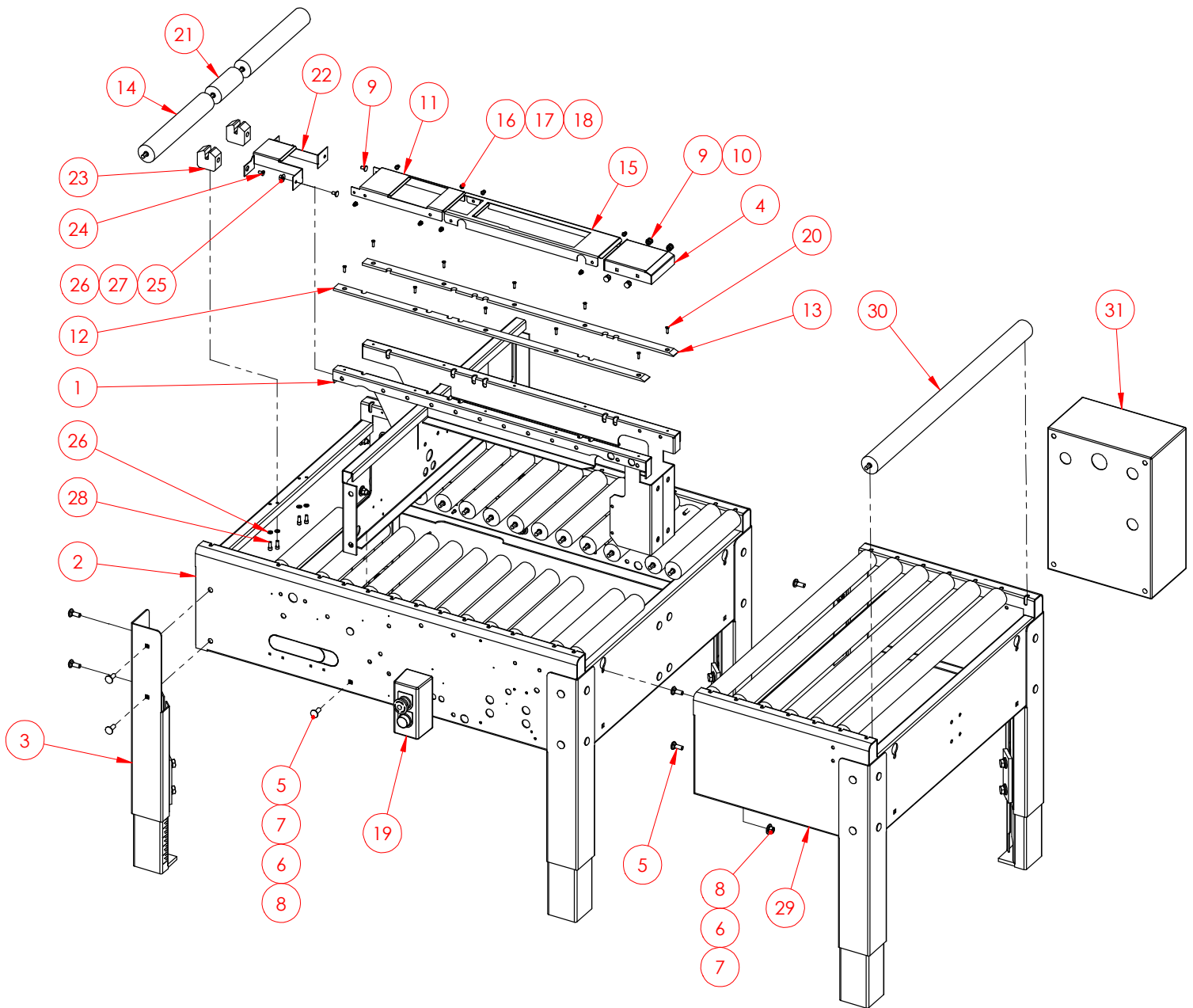
OPTIONAL EQUIPMENT

Model Number	Description	Item Number	Quantity Per Machine
	Feed/Exit Table 16" (.4 M)	UM894T	1 or 2
	Feed/Exit Table 24" (.6 M)	UM998T	1 or 2
	Feed/Exit Table 36" (.9 M)	UM898T	1 or 2
	Heavy Duty Casters, set of 6	UM708	1 set of 6
	Secondary E-Stop	UM9003	1

PARTS LISTS

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LEG ASSEMBLY	38
GATE ASSEMBLY	40
DRIVE SECTION RIGHT SIDE.....	42
DRIVE SECTION LEFT SIDE.....	44
COLUMN LEFT SIDE	46
COLUMN RIGHT SIDE.....	48
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LOCKING MECANISM.....	52
COMPRESSION GUIDE	54
KNOB C/W 5mm PIN	56
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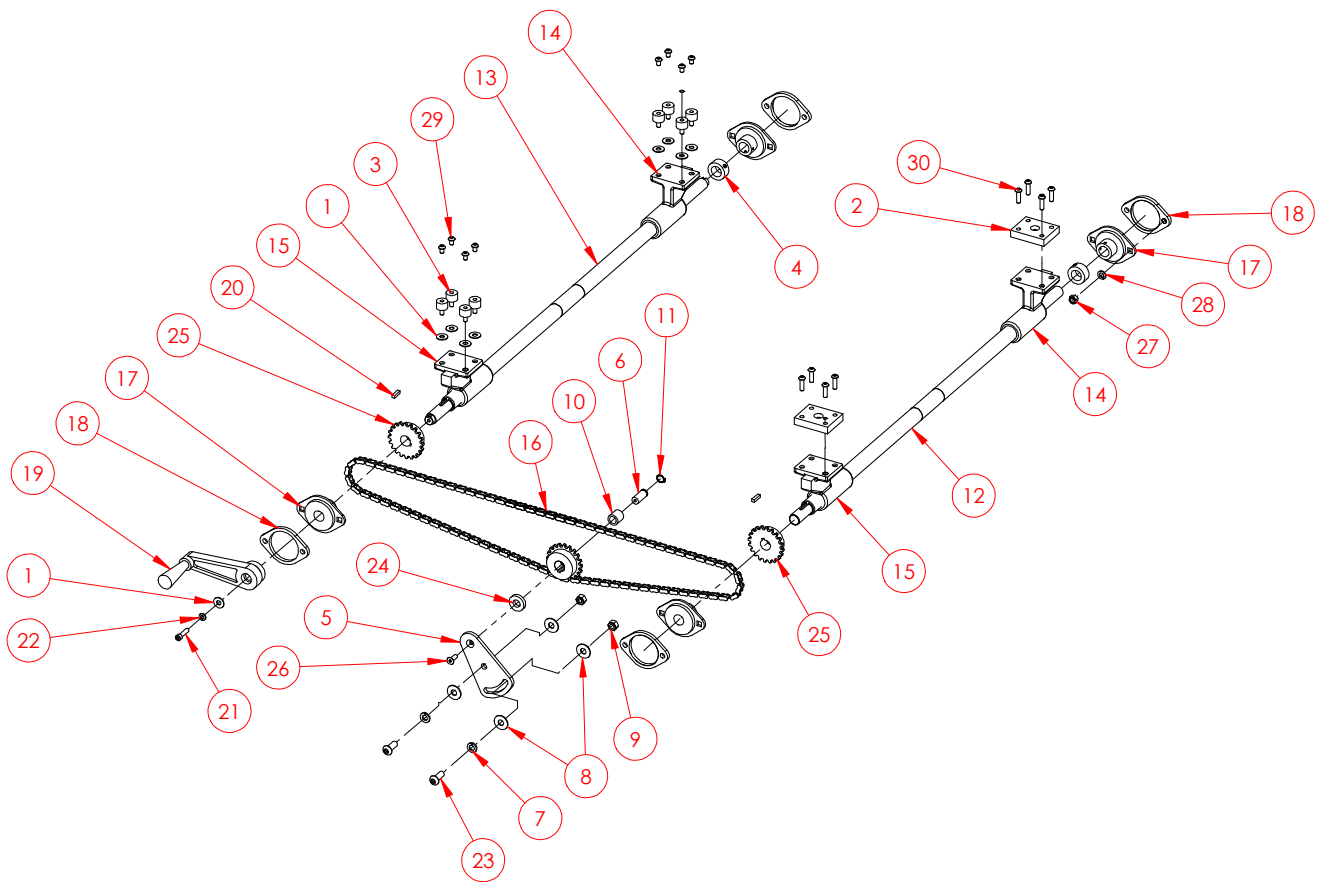
BASE ASSEMBLY (USM6104) OUTSIDE



BASE ASSEMBLY (USM6104) OUTSIDE

ITEM	PART #	DESCRIPTION	QTY.
1	UPM2522EV	INSIDE FRAME WELDMENT, BASE	1
2	UPM3287EV	OUTSIDE FRAME WELDMENT, BASE	1
3	UAM0275	LEG ASSEMBLY METRIC	6
4	UPM3229EV	INLET COVER	1
5	UF6392	CARRIAGE BOLT M10-1.5 X 25MM	12
6	UF6371	L.W. ZINC M10	12
7	UF3680	REG F.W. ZINC M10	12
8	UF6314	HNR M10-1.5	10
9	UF4251	CARRIAGE BOLT HK M6-1.0 X 20MM	6
10	UF5900	NYLON LOCK NUT M6-1.0	4
11	UPM3553EV	NEAR GAP FILLER UA2000	1
12	UPM0609EV	SLIDING PAD L.H.	1
13	UPM0606EV	SLIDING PAD R.H.	1
14	UPM3226	PVC ROL CHARCOAL DIA 1.9 X 12.00	26
15	UPM3235EV	ET T. H. INSERT 2" (OPTION)	1
16	UF0810	SHCS HK M6-1.0 X 8MM	12
17	UF6363	L.W. ZINC M6	8
18	UF3637	HNR M6-1.0	8
19	UAM0069EV	STOP/START ELECTR. BOX	1
20	UF4240	SELF TAPPING SCREW M5 X 16MM	10
21	UPM3227	PVC ROL CHARCOAL DIA 1.9 X 4.50	1
22	UPM3551EV	OUTLET COVER	1
23	UPM3234EV	OUTLET ROLLER BLOCK	2
24	UF5402	FHCS M6-1.0 X 20MM	2
25	UF1828	FW M6 ZINC	2
26	UF6363	L.W. ZINC M6	6
27	UF3637	HNR M6-1.0	2
28	UF0835	SHCS ZINC M6-1.0 X 20MM	4
29	UPM4154EV	INFEED TABLE 21"	1
30	UPM4173	PVC ROL CHARCOAL DIA 1.9 X 31.04	7
31	UPM3418EV	ELECTRICAL BOX 12" X 16"	1

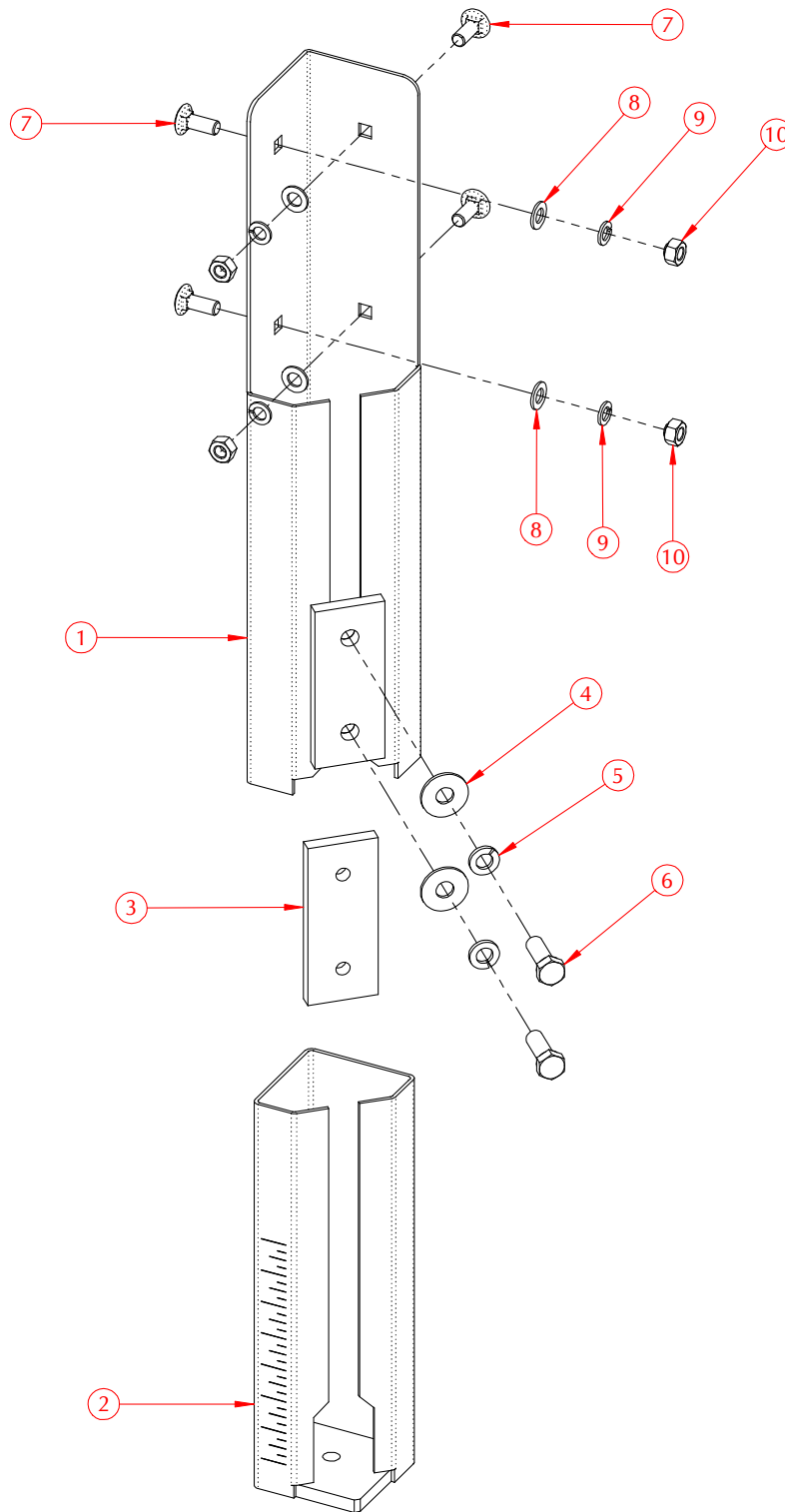
BASE ASSEMBLY (USM6104) MECHANISM



BASE ASSEMBLY (USM6104) MECHANISM

ITEM	PART #	DESCRIPTION	QTY.
1	UF1700	FW 1/4 ZINC	8
2	UPM3242EV	DRIVE SUPPORT SPACER	2
3	UPM0576	BUMPER	8
4	UF2231	SHAFT COLLAR W/SET SC-3/4" BORE	2
5	UPM0631EV	CHAIN TENSIONNER , BASE PLATE	1
6	UPM0640EV	CHAIN TENSIONNER , PIN	1
7	UF6371	L.W. M10	2
8	UF3680	REG F.W. M10	4
9	UF6314	HNR M10-1.5	2
10	UPM0639	SLEEVE BEARING 1/2ID 3/4OD 3/4LG	1
11	UF6300	RET'G RING EXT 12MM	1
12	UPM0573EV	ACME SHAFT, NO HANDLE	1
13	UPM0566EV	ACME SHAFT, FOR HANDLE	1
14	UPM0574EV	CASTING_MACH'D_1.0_SQUARE_RH	2
15	UPM0575EV	CASTING_MACH'D_1.0_SQUARE_LH	2
16	UPM0691	CHAIN 35 FOR USA 2024 SB2	1
17	UPM0523	FLANGE BEARING .75" DIA	4
18	UPM2198EV	BEARING SPACER	4
19	UPE0001EV	CRANK HANDLE	1
20	UF2210EV	SQUARE KEY ROUND END 5 X 5 X 20	2
21	UF0840	SHCS HK M6-1.0 X 25MM	1
22	UF6363	L.W. ZINC M6	1
23	UF6382	HHCS HK M10-1.5 X 25MM	2
24	UPM0641EV	CHAIN TENSIONNER SPACER	1
25	UPM0620EV	SPROCKET 35B20.75ID C/W 5MM KW	3
26	UF1192	FHCS HK M6-1.0 X 16MM	1
27	UF0866	HNR M8	2
28	UF0867	L.W. ZINC M8	2
29	UF1230	BHCS 1/4-20 X 3/8	8
30	UF1263	BHCS HK 1/4-20 X 1 1/4"	8
31	UF1828	FW M6	1

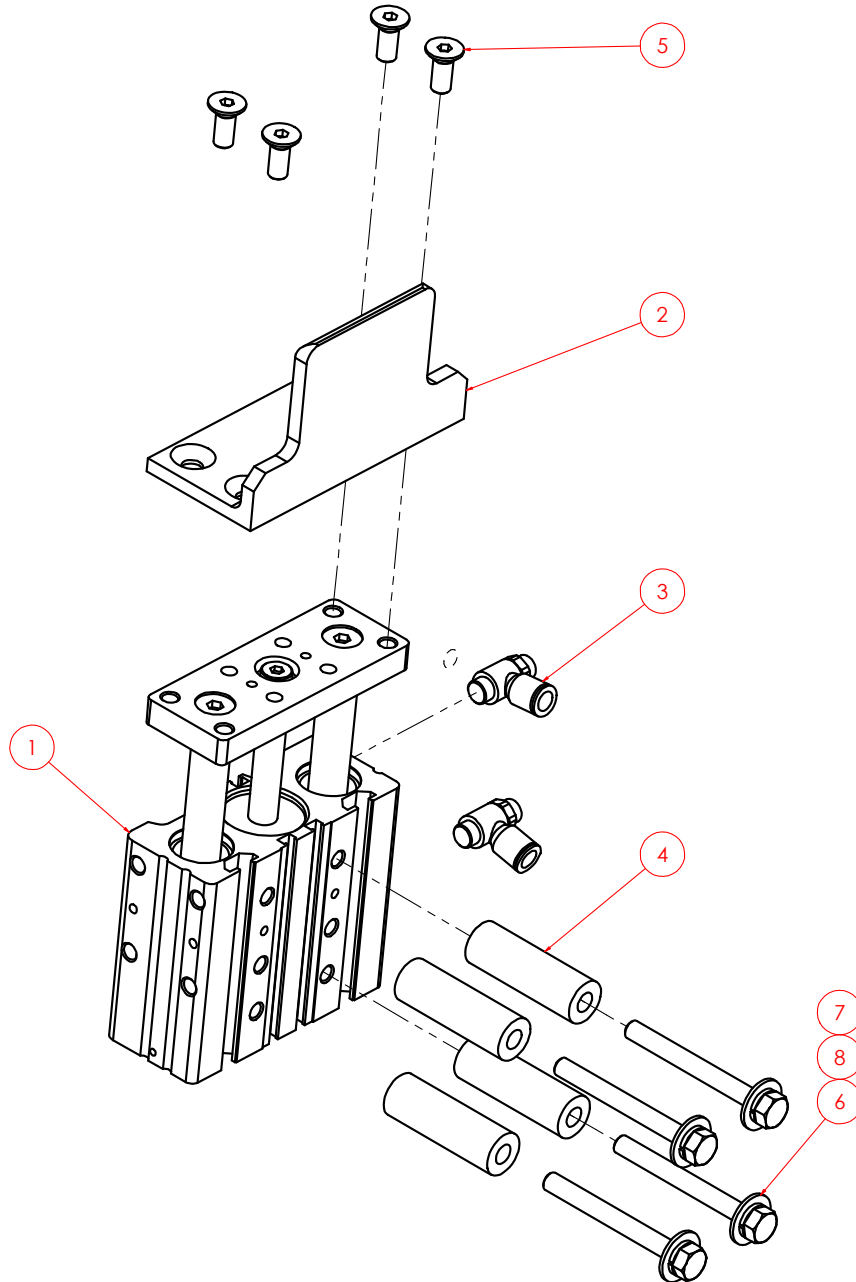
LEG ASSEMBLY (UAM0275)



LEG ASSEMBLY (UAM0275)

ITEM	PART #	DESCRIPTION	QTY.
1	UPM7640	LEG WELDMENT	1
2	UPM7641	LEG ADJUSTMENT	1
3	UPM7642	LEG FRICTION PLATE	1
4	UF4231	FW M12	2
5	UF4230	L.W. ZINC M12	2
6	UF6393	HHCS M12-1.75 x 35	2
7	UF6392	CARRIAGE BOLT M10-1.5 x 25	4
8	UF3680	FW M10	4
9	UF6371	L.W. M10	4
10	UF6314	HNR M10 x 1.5	4

GATE ASSEMBLY (USM6110)

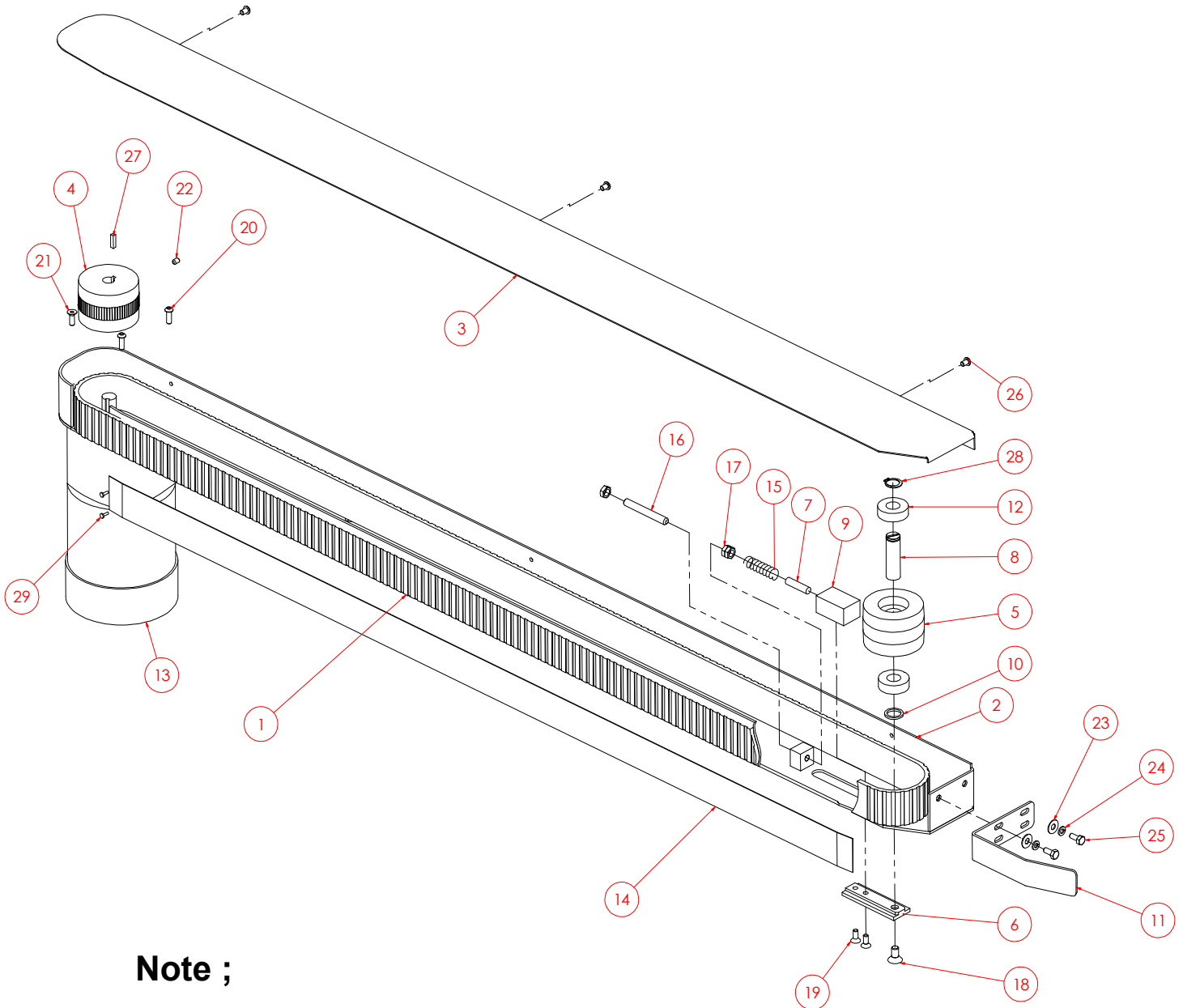


GATE ASSEMBLY

USM6110

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	UPM3804	GPC GUIDE CYLINDER 32mm X 50mm	1
2	UPM3854	GATE FOR BOSCH GUIDED CYL	1
3	UPM3787	FLOW CONTROL VALVE G 1/8 male 8mm tube	2
4	UPM3870EV	SPACER 20mm OD X 8.5mm ID X 57.1mm LG	4
5	UF1190	FHCS M8 - 1.25 x 20	4
6	UF1821	FW M8	4
7	UF0867	LW M8	4
8	UF0456	HHCS HK M8 X 75	4

DRIVE SECTION RIGHT SIDE USM6102



Note ;

Please order correct gear ratio ► see motor label

UPM7116 = 1/3 HP 21.4 TO 1 GEAR RATIO

UPM3327 = 1/3 HP 25 TO 1 GEAR RATIO

DRIVE SECTION RIGHT SIDE (USM6102)

ITEM	PART #	DESCRIPTION	QTY.
1	UPM3544	BELT ENDL. SAG 12E, 50mm X 3156mm	1
2	UPM3545EV, _3546EV	DRIVE BASE RIGHT SIDE/ LEFT SIDE	1
3	UPM3547EV, _3548EV	DRIVE BASE COVER RIGHT SIDE / LEFT SIDE	1
4	UPM0129EV	DRIVE PULLEY	1
5	UPM0259EV	IDLER PULLEY	1
6	UPM1879	TENSIONNER SLIDE	1
7	UPM0112	SPRING LOCATOR PIN	1
8	UPM1233EV	IDLER PULLEY SHAFT 50mm	1
9	UPM0101EV	TENSIONNER SPRING HOLDER	1
10	UPM0109	IDLER PULLEY SPACER	1
11	UPM0647EV	CARTON RETAINER	1
12	UPM0324EV	BEARING, PULLEY USA2324	2
13	UPM7116	MOTOR T 1/3 21.4 : 1	1
14	UPM0029	STRIP UHMW 2" X .03"THK	
15	UPM0038	DIE SPRING (DRIVE BASE)	1
16	UF1400	SSS HK 3/8-16 X 3	1
17	UF1540	HNR 3/8-16	3
18	UF6382	FHCS HK M10-1.5 X 25	1
19	UF1192	FHCS HK M6-1 X 16	2
20	UF3711	BHCS M6-1 x 30	3
21	UF3712	FHCS M6 - 1 x 30	1
22	UF6883	SSS M6-1 X 10	1
23	UF1828	FW M6	2
24	UF6363	L.W. ZINC M6	2
25	UF0454	HHCS G5Z M6-1 X 16	2
26	UF1210	BHCS HK M6-1 X 10	3
27	UF2210EV	SQUARE KEY, ZINC 5mm X 5 X 20	1
28	UF2220	EXT RET'G RING 3/4 SHAFT	1
29	UF3691	POP RIVET 4mm	4
30	UF5900	M6 LOCKNUT	4

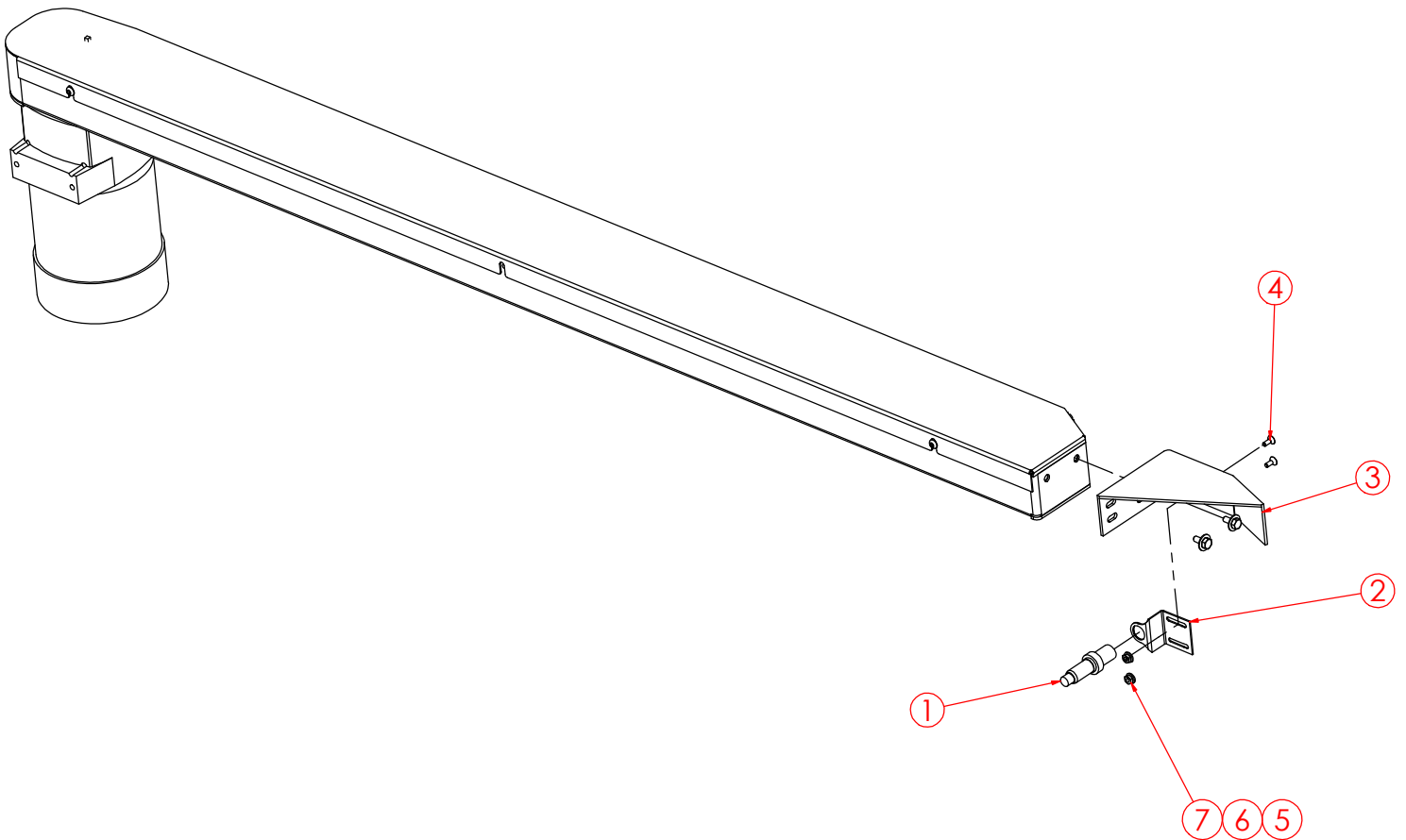
Note ;

Please order correct gear ratio ► see motor label

UPM7116 = 1/3 HP 21.4 TO 1 GEAR RATIO

UPM3327 = 1/3 HP 25 TO 1 GEAR RATIO

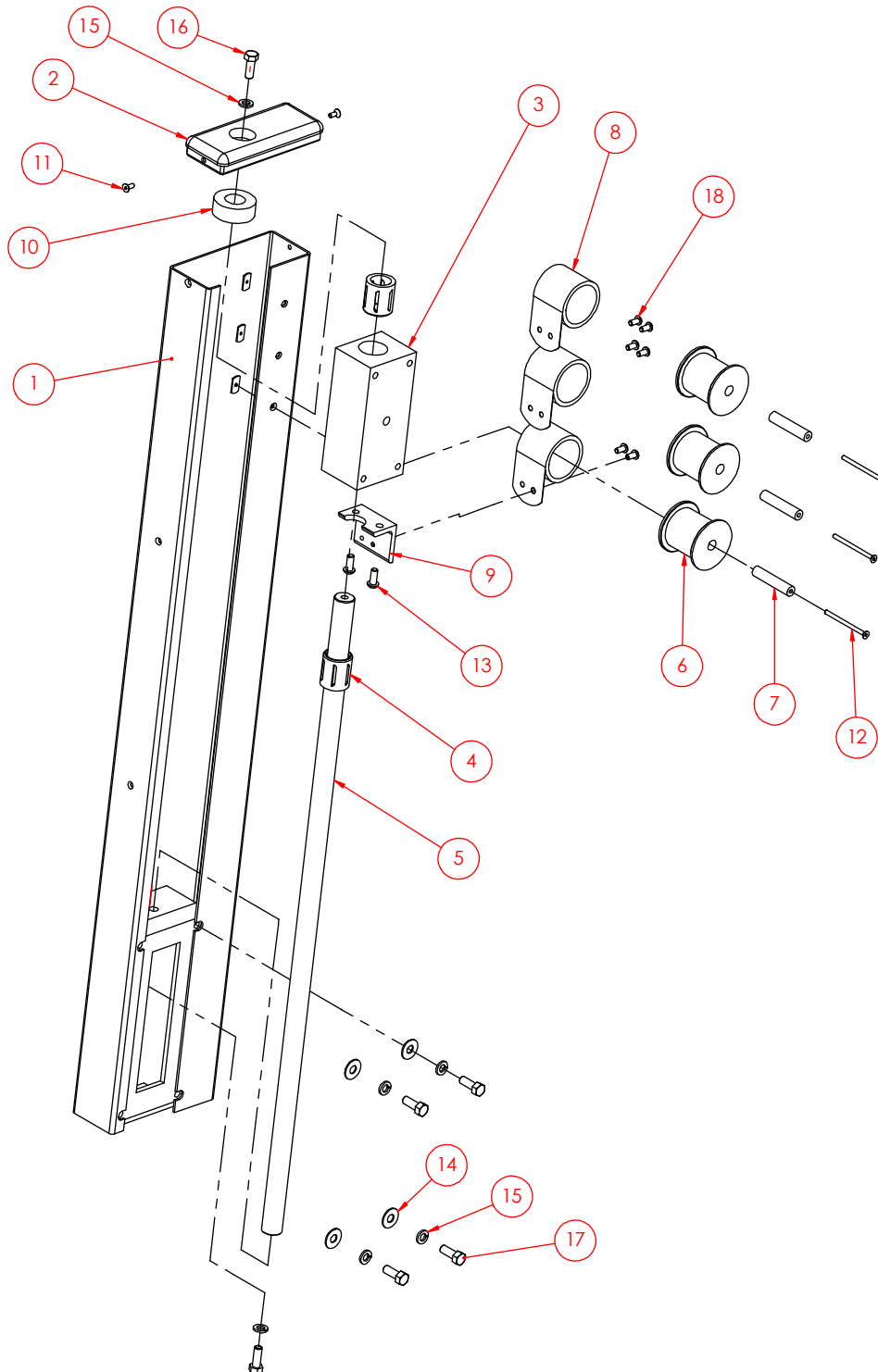
**DRIVE SECTION LEFT SIDE
(USM6103)
SAME AS USM6102, EXCEPT AS NOTED**



**DRIVE SECTION LEFT SIDE
(USM6103)
SAME AS USM6102, EXCEPT AS NOTED**

ITEM	PART #	DESCRIPTION	QTY.
1	UPM0317	PHOTOELECTRIC SENSOR	1
2	UPM3248EV	SENSOR SUPPORT	1
3	UPM3574EV	CARTON RETAINER	1
4	UF5404	FHCS M5-0.8 X 16	2
5	UF1827	REG F.W. ZINC M5	2
6	UF7023	L.W. ZINC M5	2
7	UF6307	HEX NUT M5-0.8	2

COLUMN ASSEMBLY LEFT SIDE (USM6100)

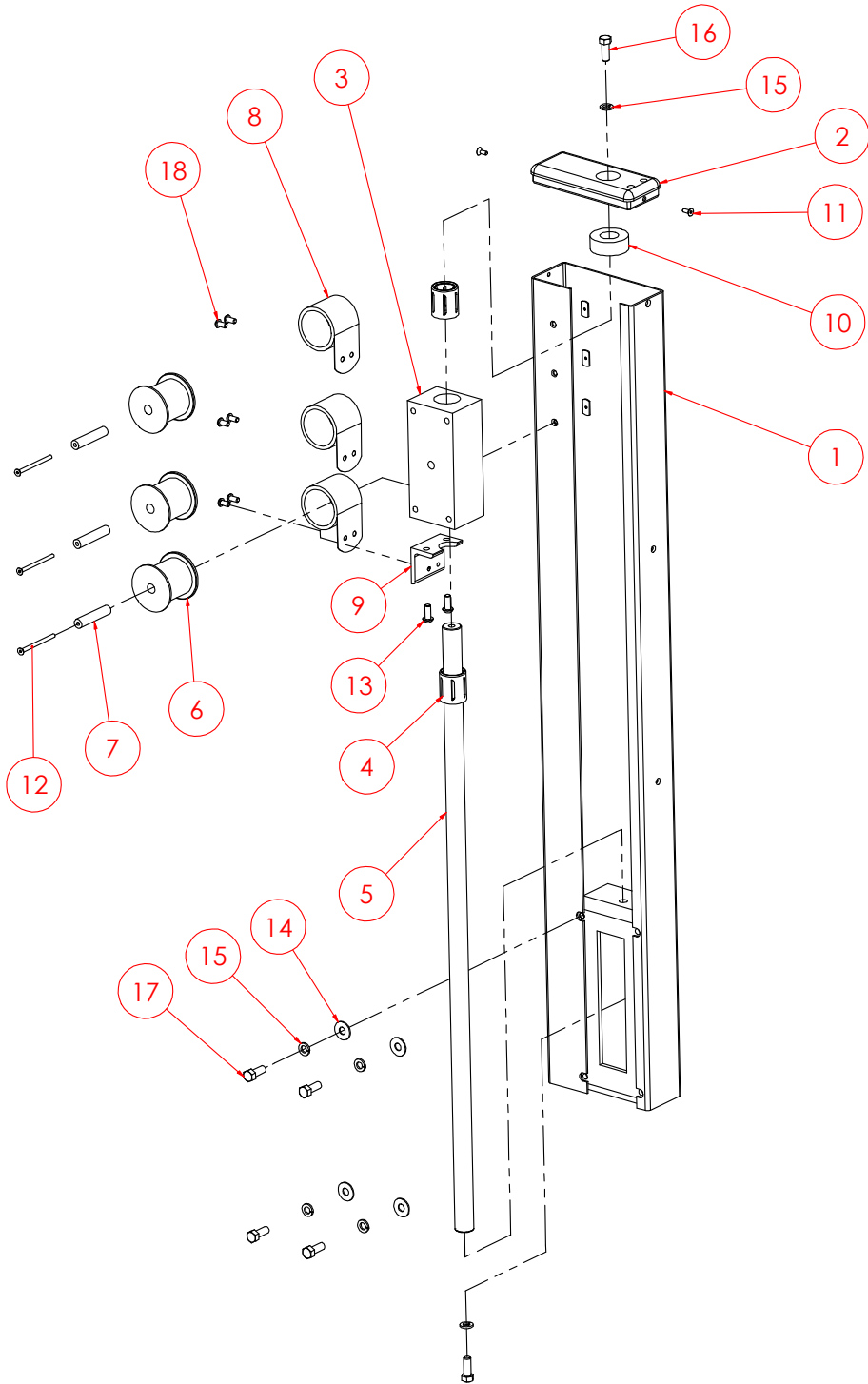


COLUMN ASSEMBLY LEFT SIDE

USM6100

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	UPM4428EV	COLUMN LEFT SIDE	1
2	UPM0741EV	COLUMN CAP LEFT SIDE	1
3	UPM0737EV	COLUMN BLOCK LEFT SIDE	1
4	LM 25UU	LINEAR BEARING 25 MM	2
5	UPM0738	COLUMN SHAFT	1
6	UPM0742	SPRING SPOOL	3
7	UPM0743	SPRING MANDREL SHAFT	3
8	UPM0740	CONSTANT FORCE SPRING 33 lbs	3
9	UPM3730EV	THIRD SPRING COLUMN BLOCK ANCHOR LEFT SIDE	1
10	UPM2251	SAFETY BUMPER	1
11	UF5400	FHCS M5-0.8 X 12	2
12	UF1157	FHCS M5 - 0.8 X 70	3
13	UF1318	BHCS HK M8-1.25 X 20	2
14	UF3680	REG F.W. M10	5
15	UF6371	L.W. ZINC M10	6
16	UF6382	HHCS G5Z M10-1.5 X 25	2
17	UF3647	HHCS G5Z M10-1.25 X 25	4
18	UF1206	BHCS HK M6-1.0 X 8	6

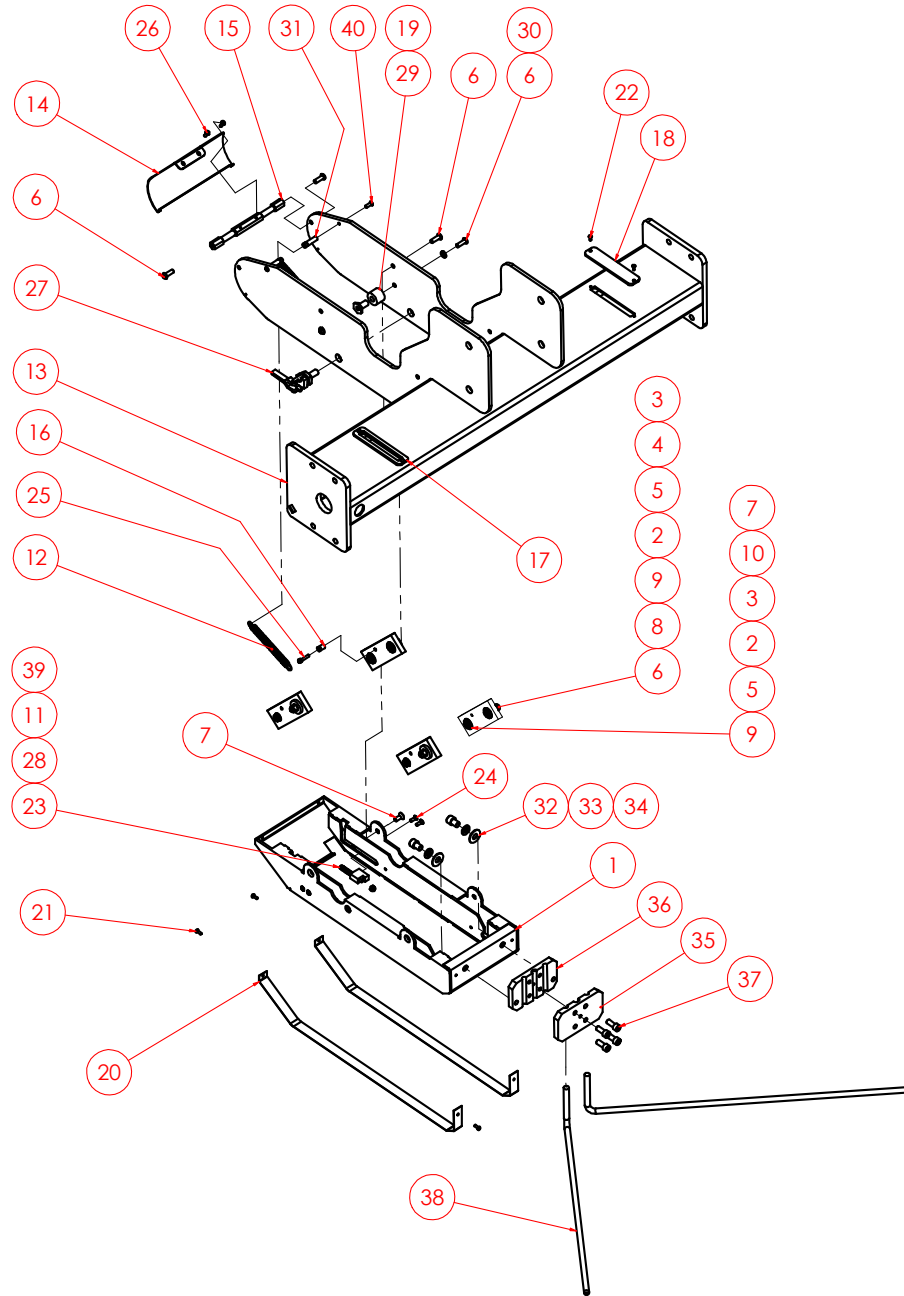
COLUMN ASSEMBLY RIGHT SIDE USM6101



COLUMN ASSEMBLY RIGHT SIDE (USM61010)

ITEM	PART #	DESCRIPTION	QTY.
1	UPM4429EV	COLUMN RIGHT SIDE	1
2	UPM4430EV	COLUMN CAP RS PNEUM	1
3	UPM0735EV	COLUMN BLOCK RIGHT SIDE	1
4	LM 25UU	LINEAR BEARING 25 MM	2
5	UPM0738	COLUMN SHAFT	1
6	UPM0742	SPRING SPOOL	3
7	UPM0743	SPRING MANDREL SHAFT	3
8	UPM0740	CONSTANT FORCE SPRING 33 lbs	3
9	UPM3731EV	THIRD SPRING COLUMN BLOCK ANCHOR RIGHT SIDE	1
10	UPM2251	SAFETY BUMPER	1
11	UF5400	FHCS M5-0.8 X 12	2
12	UF1157	FHCS M5 - 0.8 X 70	3
13	UF1318	BHCS HK M8-1.25 X 20	2
14	UF3680	REG F.W. M10	5
15	UF6371	L.W. ZINC M10	6
16	UF6382	HHCS G5Z M10-1.5 X 25	2
17	UF3647	HHCS G5Z M10-1.25 X 25	4
18	UF1206	BHCS HK M6-1.0 X 8	6

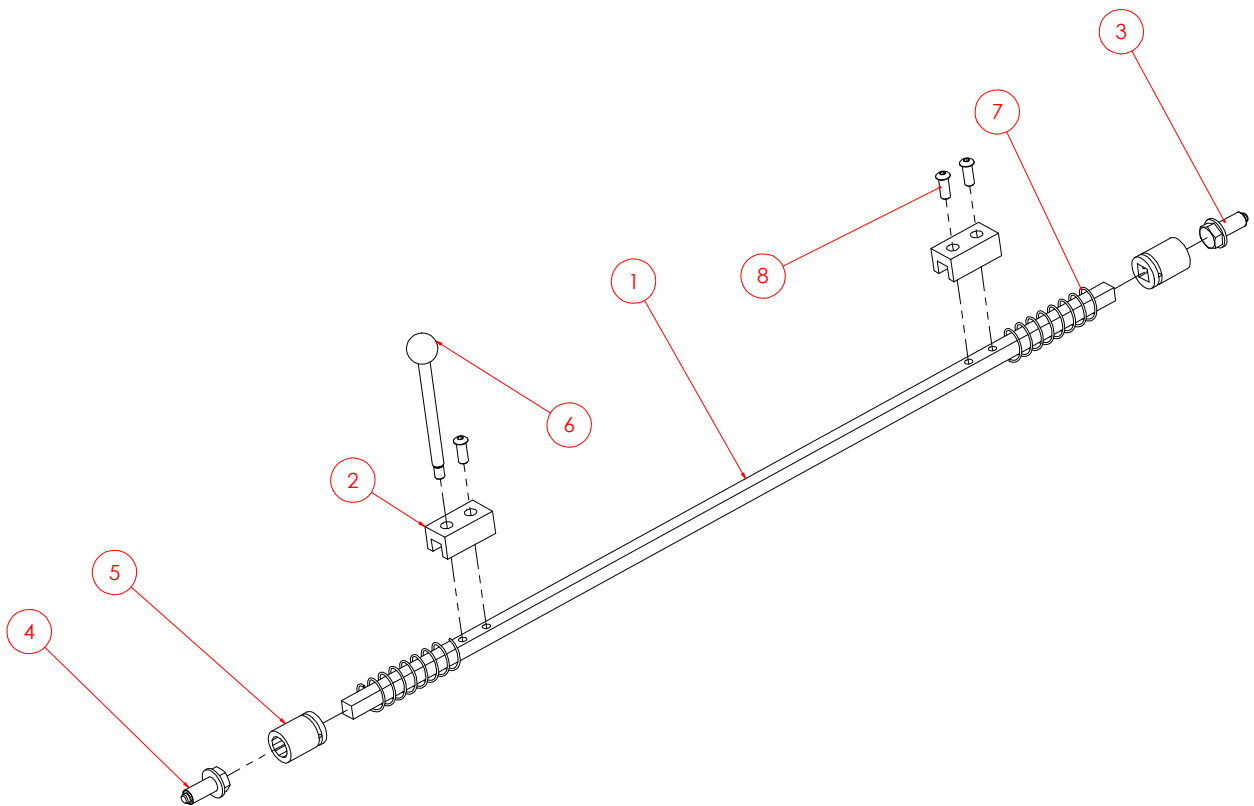
FLOATING TAPE HEAD BOX ASSEMBLY (USM6105)



FLOATING TAPE HEAD BOX ASSEMBLY (USM6105)

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	UPM3550EV	T.H.BOX	1
2	UPM1783EV	PIVOT PLATE FRONT	4
3	UPH0089EV	BEARING PERMAGLIDE D1210	8
4	UPM0968EV	PIVOT SHAFT T.H. BOX 222	4
5	UF6300	12mm RETAINING RING	8
6	UF1250EV	BHCS M6-1.0 X 16	8
7	UF1192	FHCS HK M6-1.0 X 16	4
8	UPM1158	PIVOT SHAFT SPACER	4
9	UF1940	F.W. NYLON 1/2IDx.772ODx.032TH	16
10	UPM2247EV	PIVOT SHAFT SHORT T.H. BOX 222	4
11	UPM1123EV	SPRING SUPPORT	2
12	UPM1042	PIVOT EXTENTION SPRING	2
13	UPM3549EV	BRIDGE, WELDMENT	1
14	UPM3292EV	REAR COVER GUARDING	1
15	UPM3291EV	HEXAGON SPACER BAR , REAR	1
16	UPM0962EV	SPRING RETAINER SHORT	2
17	UPM1011	BRIDGE PLATE COVER SLOTTED	1
18	UPM1008	BRIDGE PLATE COVER	1
19	UPM2168EV	STOP RETAINER T.H. BOX	2
20	UPM0029	STRIP, UHMW, 2" W X .03" THK	2
21	UF3691	POP RIVET 4mm	4
22	UPM2192	BLACK BELLY BUTTON	4
23	UF6375	SHCS HK M4-0.7 X 50	2
24	UF0902EV	FHCS M4-0.7 X 12	4
25	UF3646	SHCS HK M4-0.7 X 20	2
26	UF3649	BHCS M4-0.7 X 12	4
27	UPM2196	TOGGLE CLAMP	1
28	UPM1068	COMP.SPRING SWIVEL T.H. ASSY	2
29	UPM4449	FLOATING THB STOP	6
30	UF6363	L.W. ZINC M6	2
31	UPM0967EV	SPRING RETAINER LONG	2
32	UF3680	REG F.W. M10	2
33	UF6371	L.W. ZINC M10	2
34	UF3648	SHCS HK M10-1.5 X 16	2
35	UPM2287EV	PLOW BLOCK FRONT	1
36	UPM7207EV	PLOW BLOCK BACK	1
37	UF0864	SHCS HK M8-1.25 X 20	4
38	UPM3741	PLOW ROD 3FF	2
39	UF6376	NYLON LOCK NUT ZINC M4-0.7	2
40	UF3650	BHCS M4-0.7 X 16	2

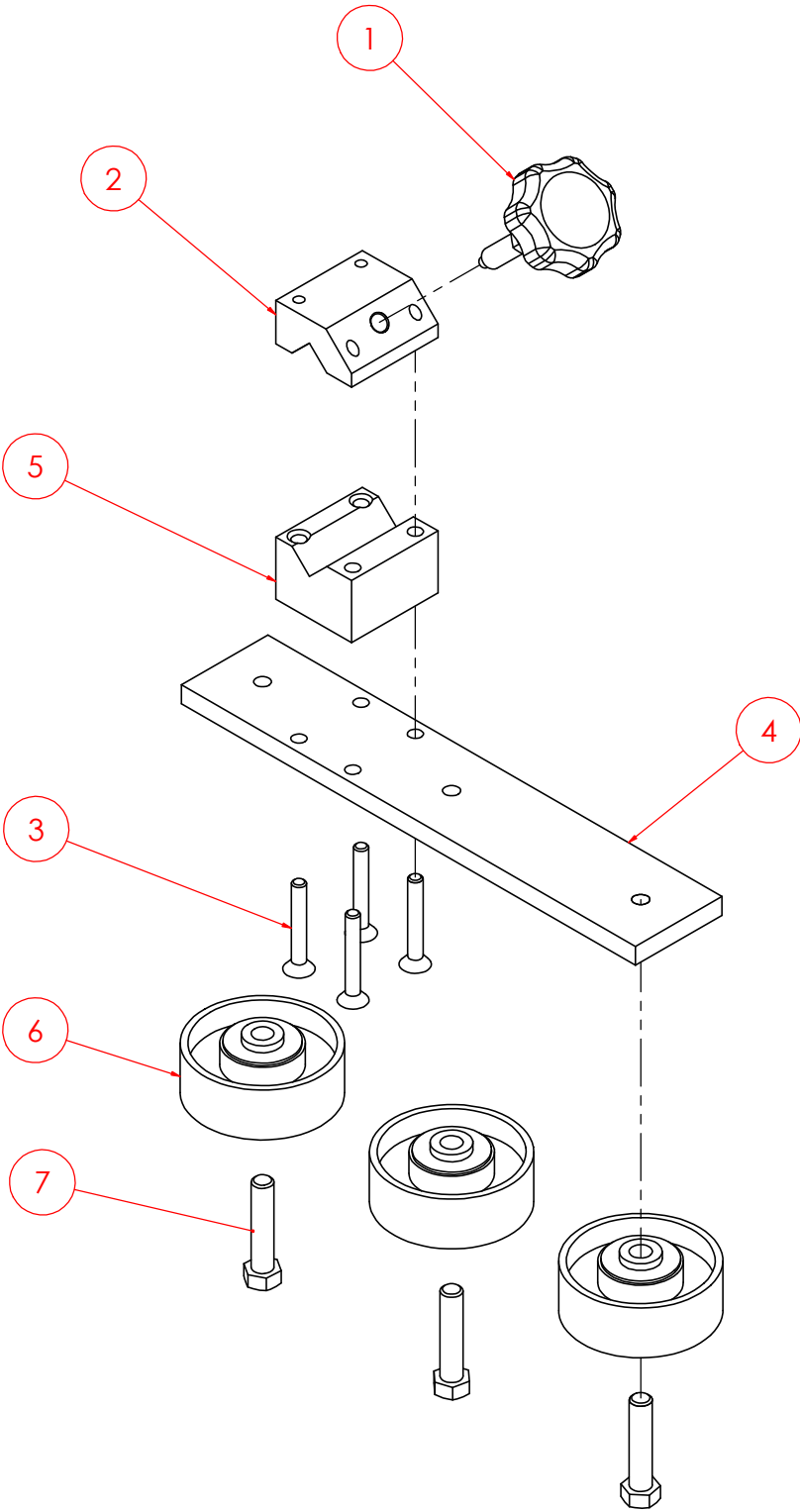
LOCKING MECHANISM (USM0391)



LOCKING MECANSM (USM0391)

ITEM	PART #	DESCRIPTION	QTY.
1	UPM2187	SQUARE BAR 0.50"	1
2	UPM0700	SINGLE LOCKING BLOCK	2
3	UPM0698	FLANGED SCREW 1/2-13 L.H.	1
4	UPM0699	FLANGED SCREW 1/2-13 R.H.	1
5	UPM0703	SHORT BOX 3/4", 1/2" DR, 12 PT	2
6	UPM0688	SINGLE LOCKING HANDLE	1
7	UPM2184	SPRING, C1100-065-4000-M	2
8	UF1318	BHCS M8-1.25 x 20 mm	3

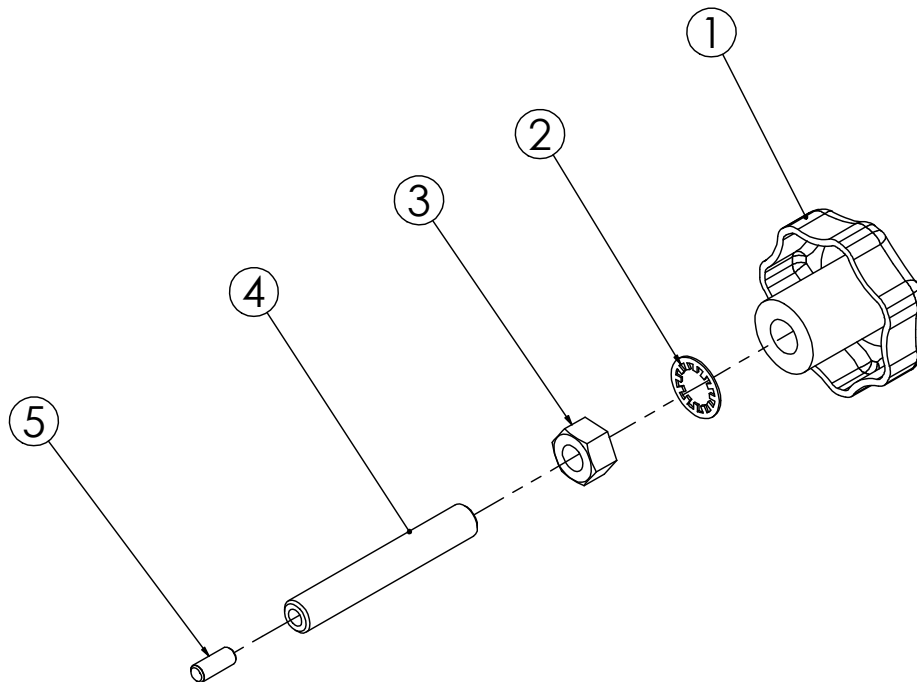
COMPRESSION GUIDE (USM6109)



COMPRESSION GUIDE (USM6109)

ITEM	PART #	DESCRIPTION	QTY.
1	UAM0288	KNOB CW 5mm PIN USA2324	1
2	UPM7538	GUIDE BLOCK TOP	1
3	UF4029	FHCS HK M6-1 X 50	4
4	UPM2173EV	WHEEL SUPPORT PLATE UA METRIC	1
5	UPM3285EV	GUIDE BLOCK	1
6	UPM1659	WHEEL 2-7/8"DIA.COMPR.GUIDE	3
7	UF0240	HHCS 3/8-16 x 1.75	3

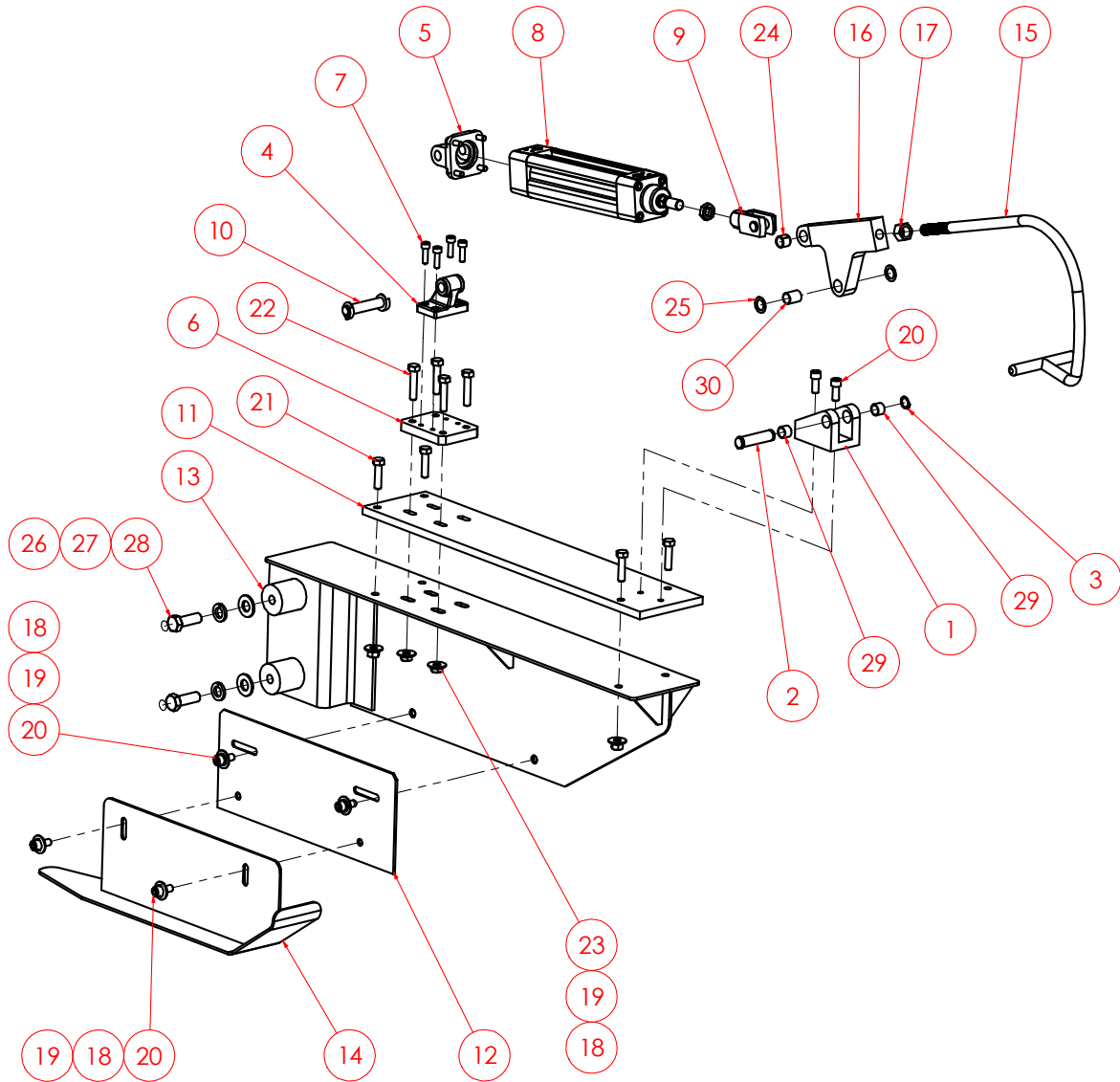
KNOB CW 5mm PIN (UAM0288)



**KNOB CW 5mm PIN
(UAM0288)**

ITEM	PART #	DESCRIPTION	QTY
1	UPM4506	Knob w 3/8-16unc Hole	1
2	UF9168	Internal Tooth LW 3/8"	1
3	UF1540	HNR 3/8-16	1
4	UF2136EV	Rod Zc 3/8-16 x 2" W/5mm Hole	1
5	UPM0131EV	Brass Pin 5mm	1

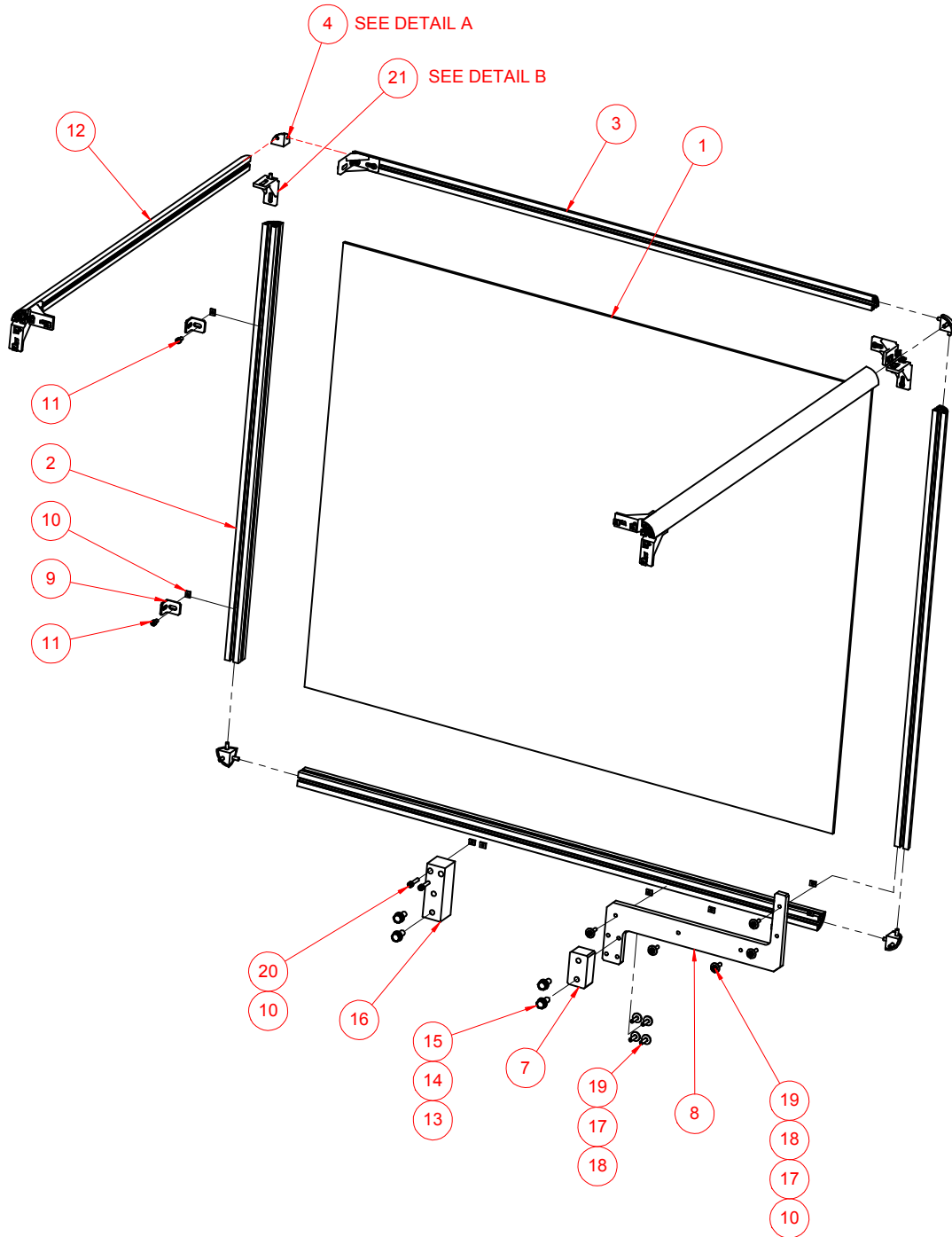
KICKER ASSEMBLY (USM6107)



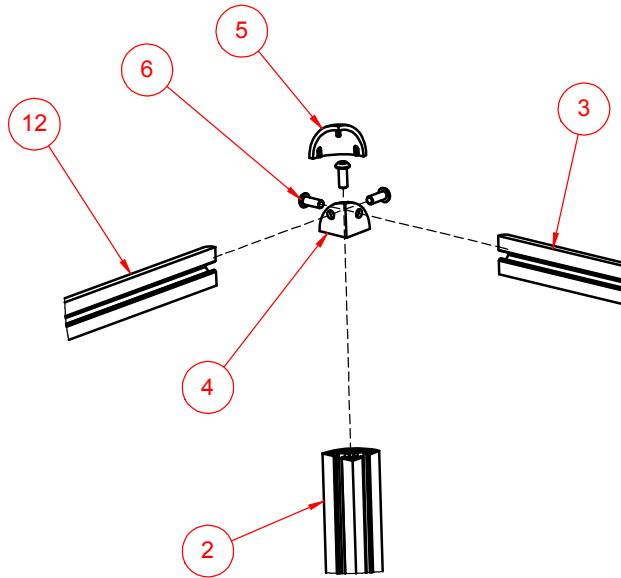
KICKER ASSEMBLY (USM6107)

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	UPM0380EV	KICKER CLEVIS	1
2	UPM3849EV	SS CLEVIS PIN 12mm	1
3	UF7017	SS 12MM RETAINING RING	2
4	UPM2900	BEARING BLK FOR 40mmCYL.	1
5	UPM2901	REAR CLEVIS, 40mmCYL.	1
6	UPM2917EV	CYLINDER ANCHOR BLOCK	1
7	UF0835	SHCS M6-1 X 20MM	4
8	UPM2899	AIR CYL. 40 X 130mm ISO	1
9	UPM2902	CLEVIS (P1) FOR ISO 40mm CYL.	1
10	UPM2903	PIVOT PIN-SNAP RING	1
11	UPM3874EV	KICKER MOUNTING PLATE	1
12	UPM4350EV	SKI MOUNTING PLATE	1
13	UPM4351EV	BRIDGE EXTENSION	1
14	UPM4352EV	SKI	1
15	UPM0383EV	KICKER UA MINI	1
16	UPM2918EV	KICKER BLOCK, METRIC	1
17	UF4234	HNR ZINC M12-1.75	1
18	UF1821	F.W. ZINC M8	10
19	UF0867	L.W. ZINC M8	10
20	UF5204	SHCS M8-1.25 X 20	2
21	UF6310	HHCS M8-1.25 X 25	2
22	UF4232	HHCS M8-1.25 X 40	4
23	UF0866	HNR M8-1.25	4
24	UPH0907	BEARING 12 x 14 x 12 LG.	1
25	UF1940	F.W. NYLON 1/2IDx.772ODx.032TH	2
26	UF4231	F.W. M12	4
27	UF4230	L.W. M12	4
28	UF3062	HHCS M12-1.75 X 25	4
29	UPH0089EV	BEARING GLYCODUR 12 X 14 X 10	2
30	UPM4451	BEARING 12 X 14 X 18	1

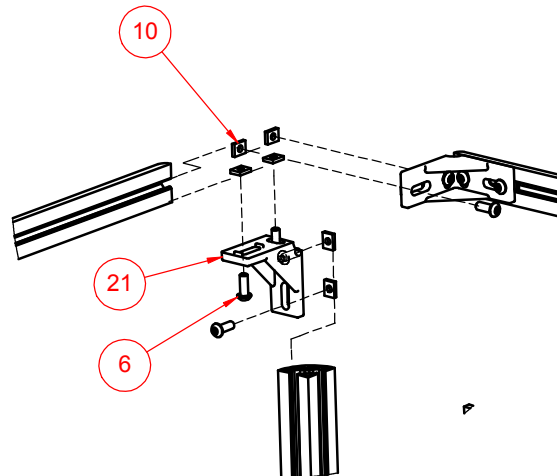
RIGHT GUARD ASSEMBLY (USM6108)



RIGHT GUARD ASSEMBLY (USM6108)



DETAIL A
CORNERS MOUNTING ARRANGEMENT

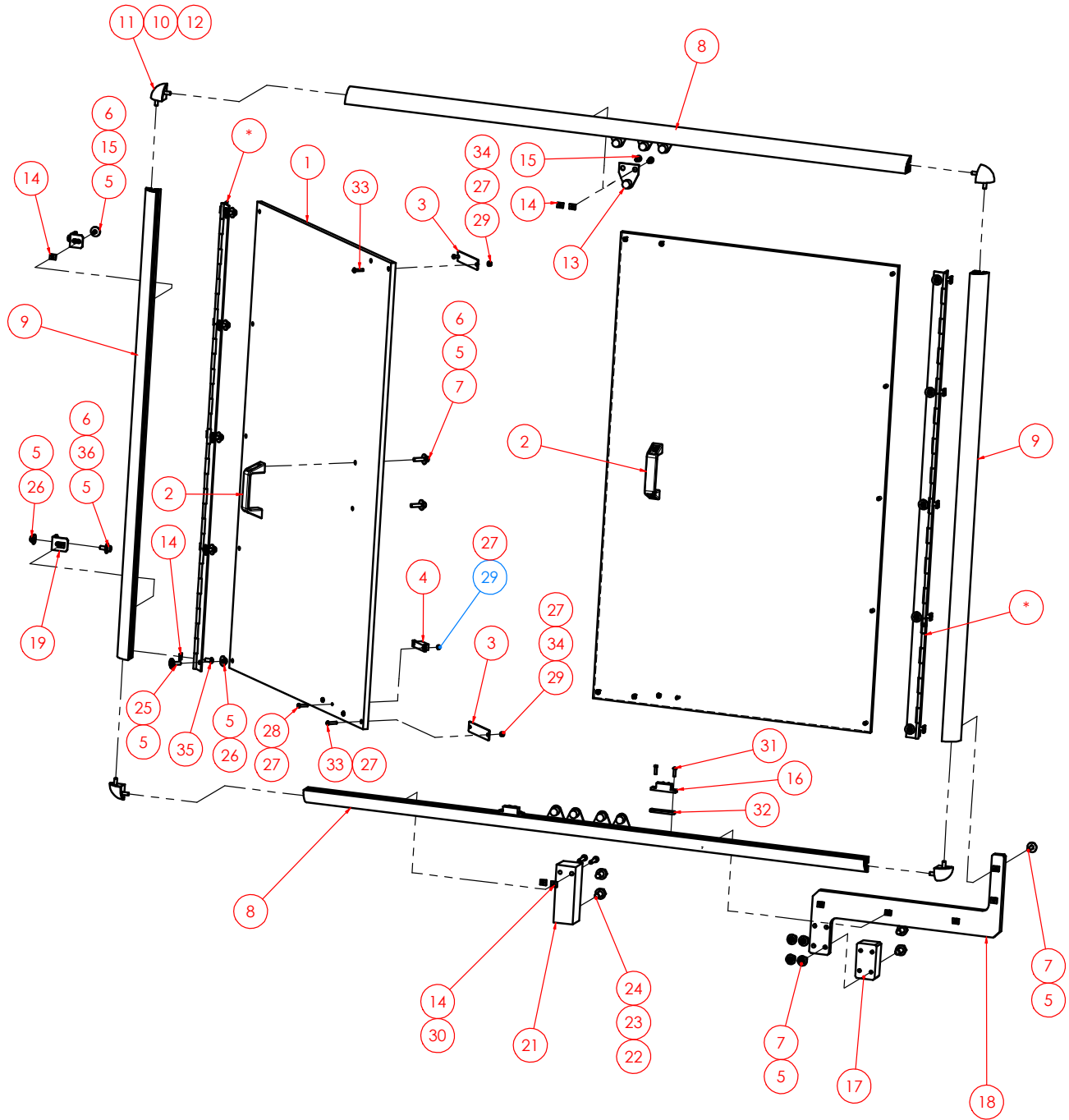


DETAIL B
INSIDE CORNERS MOUNTING ARRANGEMENT

RIGHT GUARD ASSEMBLY (USM6108)

ITEM	PART #	DESCRIPTION	QTY.
1	UPM3862EV	LEXAN 6mm X 955mm X 1180mm	1
2	UPM3864EV	VERTICAL EXTRUSION	2
3	UPM3865EV	HORIZONTAL EXTRUSION	2
4	UPM0614EV	CORNER BLOCK	4
5	UPM2922EV	CORNER CAP FINISHING	4
6	UF1250EV	BHCS M6-1 x 16 mm	52
7	UPM3852EV	DOOR SUPPORT MEMBER UA2024 METRIC	1
8	UPM3853EV	DOOR SUPPORT UA 2024 METRIC	1
9	UPM0732EV	UA FIXED GUARDING "L" BRACKET	2
10	UPM0687EV	DROP IN T-NUT M6	41
11	UF0820	SHCS M6-1 x 12	2
12	UPM4512EV	CROSS-OVER EXTRUSION	2
13	UF3680	FW M10	4
14	UF6371	L.W. M10	4
15	UF6382	HHCS M10-1.5 x 25 mm	4
16	UPM4452	2nd SUPPORT MEMBER UA2024 METRIC	1
17	UF1828	REG F.W. M6	9
18	UF6363	LW M6	11
19	UF0840	SHCS M6-1 X 25MM	9
20	UF4236	SHCS M6-1 X 30MM	2
21	UPM4398EV	INSIDE CORNER	8

OPENED DOOR ASSEMBLY (USM6108)

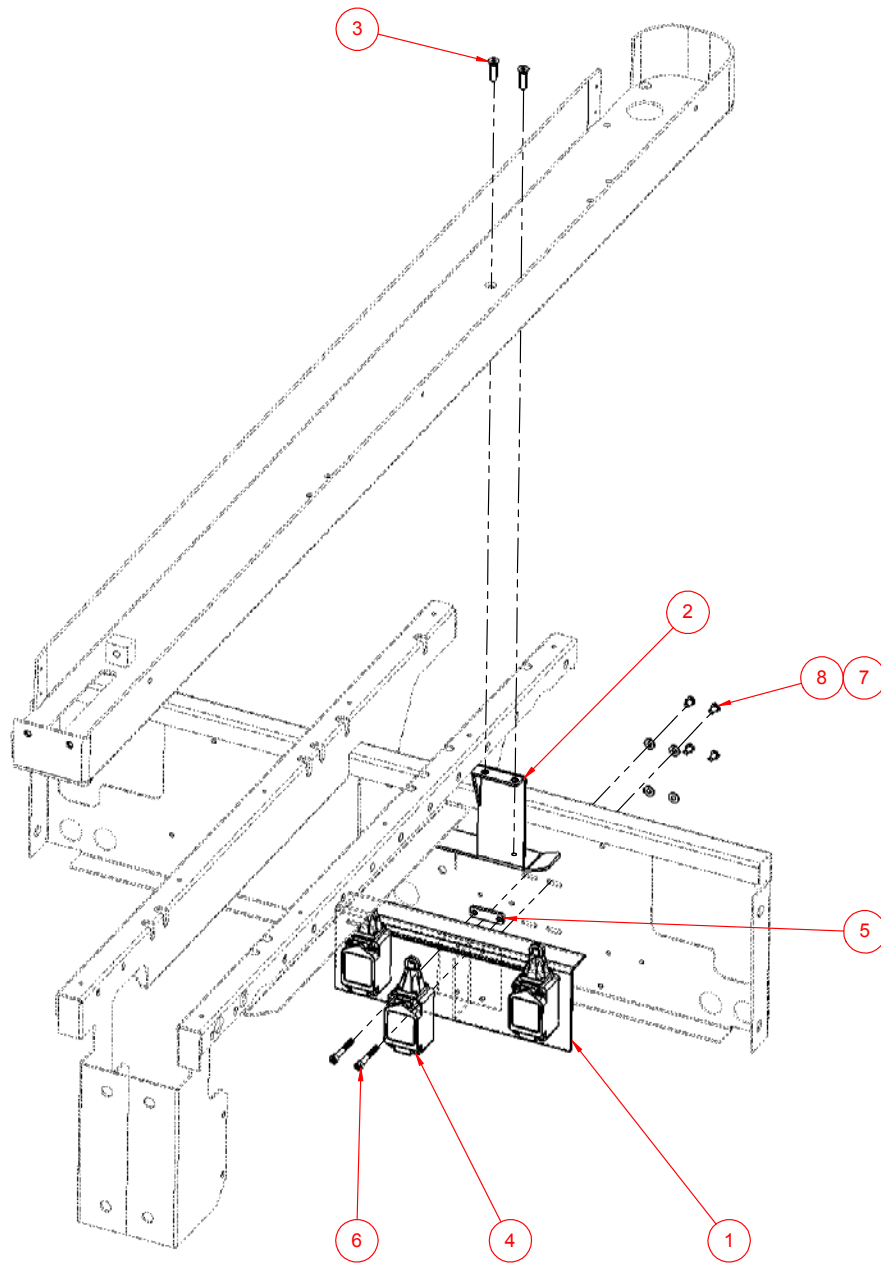


OPENED DOORS ASSEMBLY

(USM6108)

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	UPM3861EV	LEXAN 10.0mm X 575.0mm X 934.0mm	2
2	UPM0794EV	HANDLE	2
3	UPM4400EV	MAGNET PLATE	4
4	UPM4397EV	INTERLOCK, OMRON TYPE GLS-M1	2
5	UF1828	REG F.W. M6	39
6	UF6363	LW M6	16
7	UF0840	SHCS M6-1 X 25MM	13
8	UPM3865EV	HORIZONTAL EXTRUSION	2
9	UPM3864EV	VERTICAL EXTRUSION	2
10	UPM0614EV	CORNER BLOCK	4
11	UPM2922EV	CORNER CAP FINISHING	4
12	UF1250EV	BHCS M6-1 x 16 mm	12
13	UPM4399EV	MAGNET ASSY	8
14	UPM0687EV	DROP IN T-NUT M6	35
15	UF0820	SHCS M6-1 x 12	18
16	UPM4396EV	INTERLOCK, OMRON TYPE GLS-S1	2
17	UPM3852EV	DOOR SUPPORT MEMBER UA2024 METRIC	1
18	UPM3853EV	DOOR SUPPORT UA 2024 METRIC	1
19	UPM0732EV	UA FIXED GUARDING "L" BRACKET	2
20	UPM3857EV	HINGE PIANO 50mm	2
21	UPM4452	2nd SUPPORT MEMBER UA2024 METRIC	1
22	UF3680	FW M10	4
23	UF6371	L.W. M10	4
24	UF6382	HHCS M10-1.5 x 25 mm	4
25	UF1241EV	BHCS M6-1 x 20	10
26	UF5900	NYLON LOCK NUT M6-1.0	13
27	UF3710	FW M4	25
28	UF4238	PHCS M4-0.7 X 20mm	4
29	UF4237	HEX NUT M4-0.7	12
30	UF4236	SHCS M6-1 X 30MM	2
31	UF4239	PHCS M4-0.7 X 15mm	4
32	UPM4453	Omron Interlock Double Nut M4-0.7	2
33	UF4050EV	BHCS M4 - 0.7 x 20	8
34	UF3681	L.W. M4	8
35	UF1195	BHCS M6-1 x 12 mm	10
36	UF0830	SHCS M6-1 x 16 mm	2

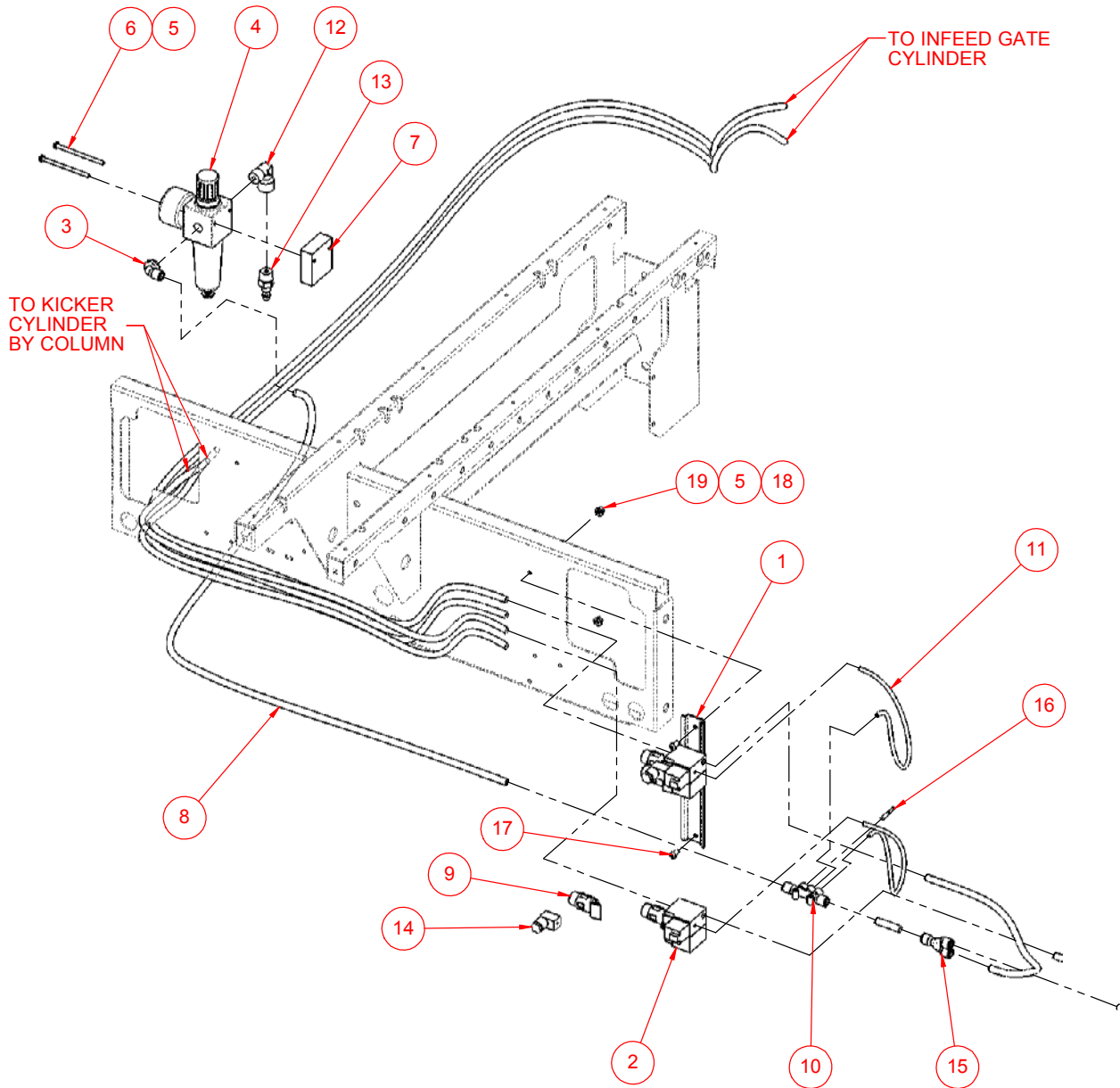
ELECTRIC CONTROLS



ELECTRIC CONTROLS

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	UPM4402EV	LIMIT SWITCH SUPPORT	1
2	UPM4401EV	LIMIT SWITCH BRACKET	1
3	UF1194	FHCS M6 - 1 x 25 mm	2
4	UPM4403EV	Omron WLD2-TS Limit Switch	3
5	UPM4424	Omron Switch Double Nut	3
6	UF4304	SHCS M5 x 0.8 x 40MM	6
7	UF1827	FW M5	4
8	UF3686	BHCS M5-0.8 X 10MM	4

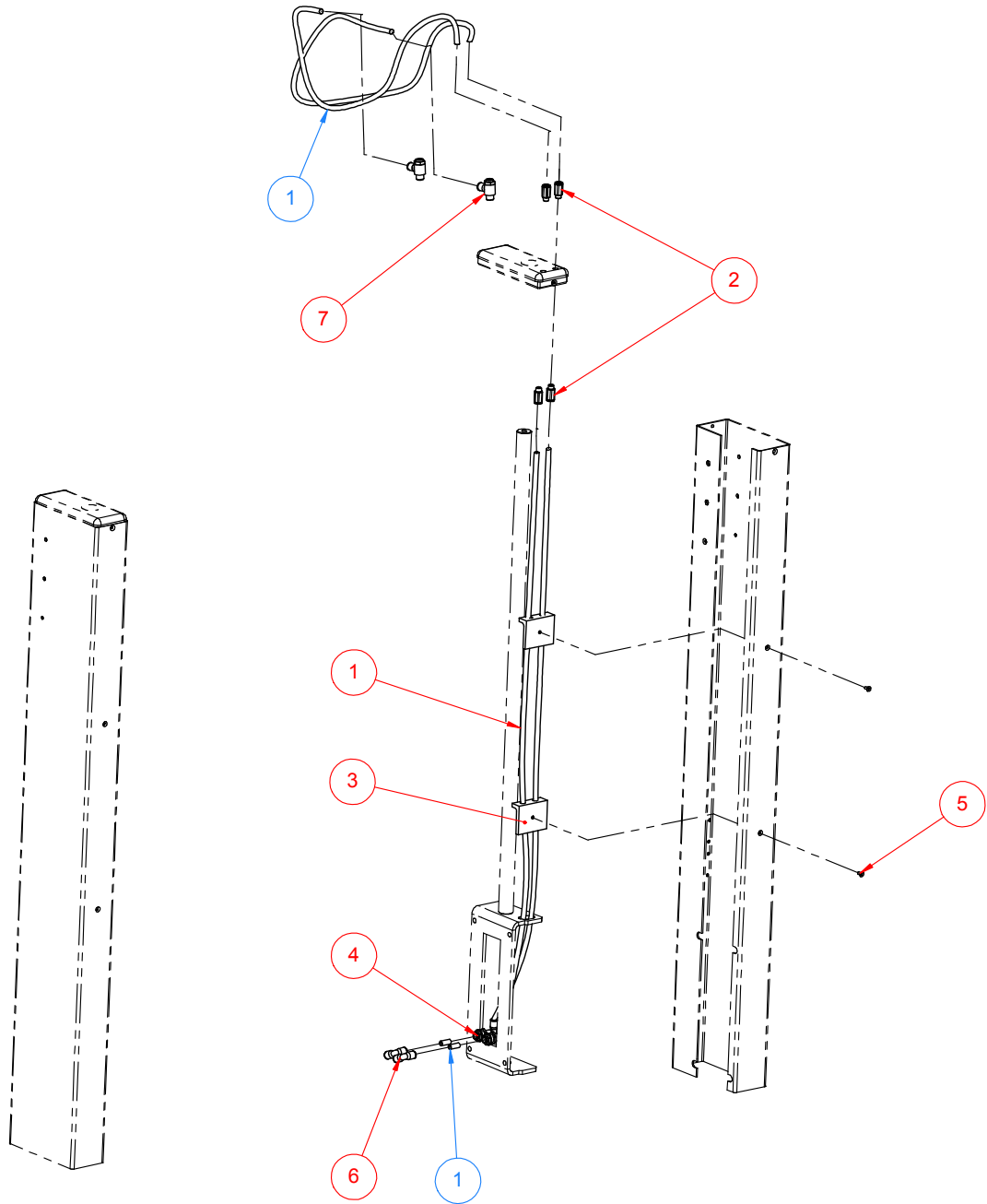
PNEUMATIC (USM6106)



PNEUMATIC (USM6106)

ITEM	PART #	DESCRIPTION	QTY.
1	UPM0407EV	DIN RAIL	1
2	UPM3394	VALVE 579 5/2 MONOSTABLE 24 VDC	2
3	UPM3179	ELBOW 3/8 MALE x 8mm TUBE	1
4	UPM3267	FILTER REGULATOR NL2 G3/8 0.2 BAR	1
5	UF	L.W. M5	2
6	UF4240	SHCS M5-0.8 X 80 MM	2
7	UPM3755EV	FILTER REG. (UPM3267) MOUNTING BRKT	1
8	UPM3411	TUBING 8mm X 1 BLUE SOFT	8.0 M TOTAL
9	UPM3391	SILENCER 579 VALVE	4
10	UPM3396	MULT T-CON 2 X 8mm TO 3 X 4mm	1
11	UPM3583	PLASTIC TUBE 4mm BLUE	0.8 M TOTAL
12	UPM3175	ELBOW BRSS NKL PLT G3/8M X G3/8F	1
13	UPM0436	FTG Q.D. 3/8 NPT MALE	1
14	UPM3392	ELECT. CONN WITH LED 579 VALVE	2
15	UPM4346	Y connector (8mm to 2 x 8mm)	1
16	UPM4385	PLUG TYPE LB 4 mm TUBE	1
17	UF3687	BHCS M5-0.8 X 12MM	2
18	UF1827	FW M5	2
19	UF6307	HEX NUT M5-0.8	2

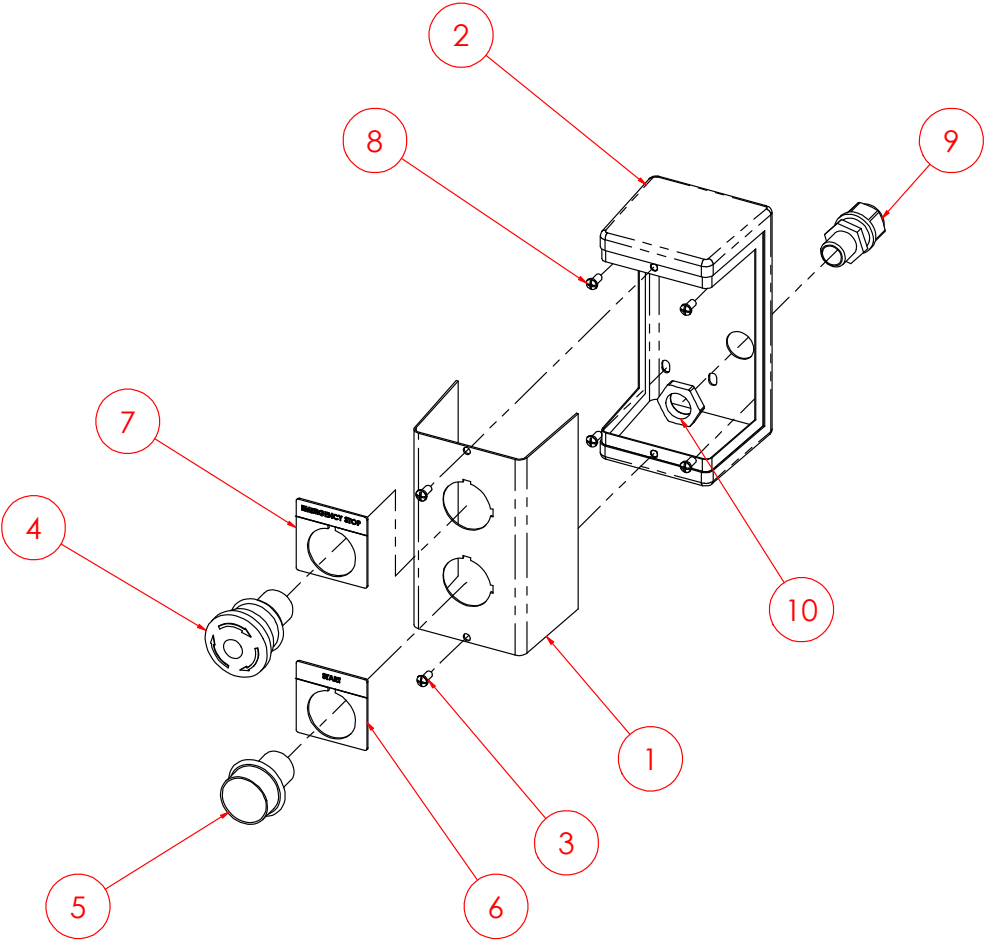
AIR TO COLUMN ASSEMBLY



AIR TO COLUMN ASSEMBLY

ITEM	PART #	DESCRIPTION	QTY.
1	UPM3411	8 mm TUBE	4.0 M TOTAL
2	UPM3182	FTG. STR 8mmTUBE 1/8NPT MALE	4
3	UPM3386EV	AIR TUBE GUIDE	2
4	UPM3336	ELBOW BULKHEAD CONNECTOR 8mm	2
5	UF6305	FHCS M5-0.8 X 10 MM	2
6	UPM3140	FTG "L" 8mm TUBE	2
7	UPM3132	FLOW CONTROL G 1/4 MALE X 8mm TUBE	2

STOP / START BOX (UAM1084)

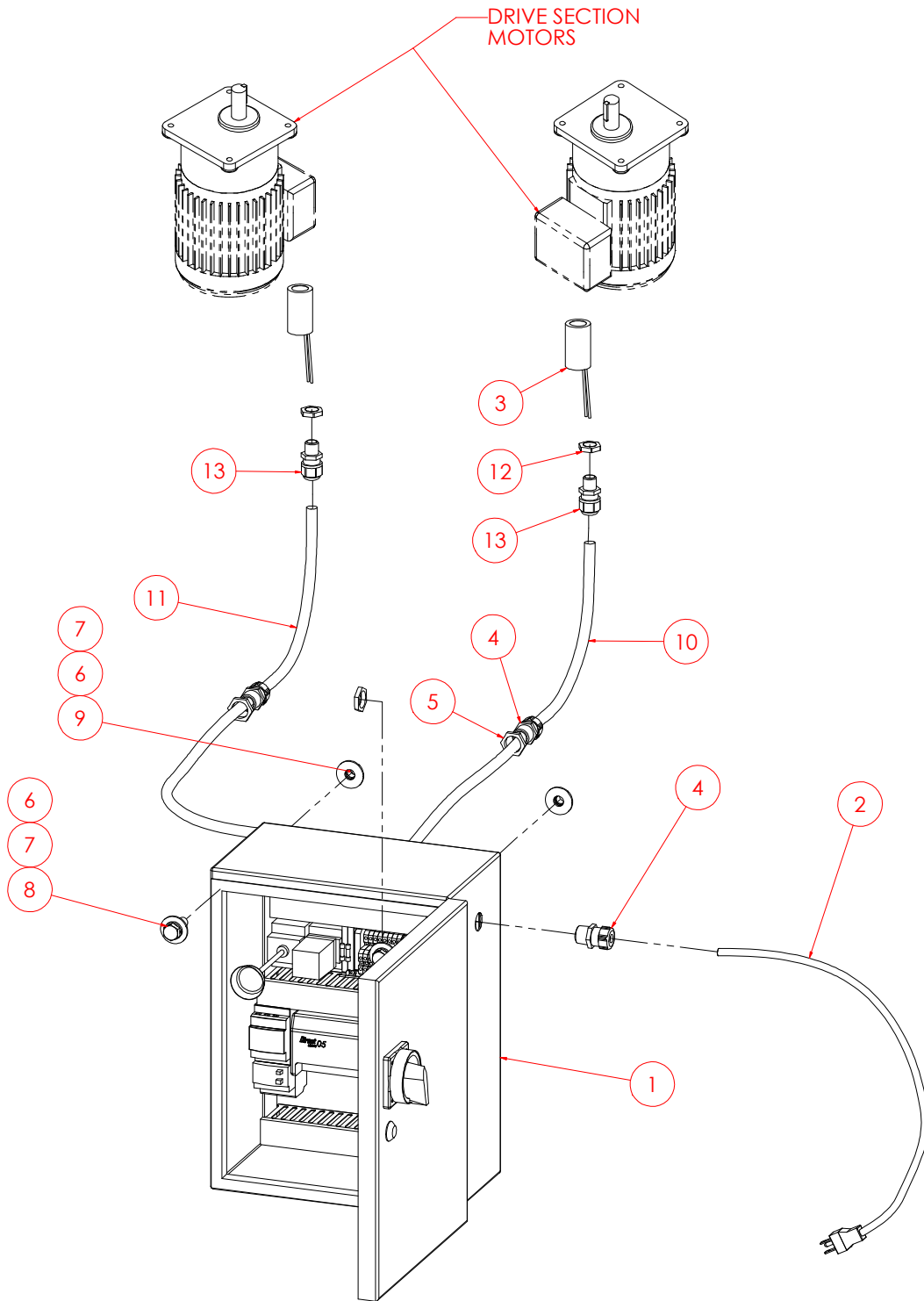


STOP / START BOX

(UAM1084)

ITEM	PART #	DESCRIPTION	QTY
1	UPM3962EV-it 1	COVER	1
2	UPM3962EV-it 2	BOX ELECT. 2 HOLES FOR BUTTON	1
3	UPM3962EV-it 3	PHCS M4-0.7 X 8mm	2
4	UPM0693EV	STOP BUTTON RED MUSH INC	1
5	UPM4514	ON/OFF GREEN BUTTON RSA	1
6	UPM0418	LEGEND PLATE "START"	1
7	UPM0419	LEGEND PLATE "EMERG.STOP"	1
8	UF9169	PHCS M4-0.7 X 8mm	4
9	UPM0197EV-16	STR.RELF METL.LIQDTGHT M16X1.5 (8-10mm)	1
10	UPM0341EV-16	LOCKNUT M16 X 1.5(FOR STRAIN RELF)	1

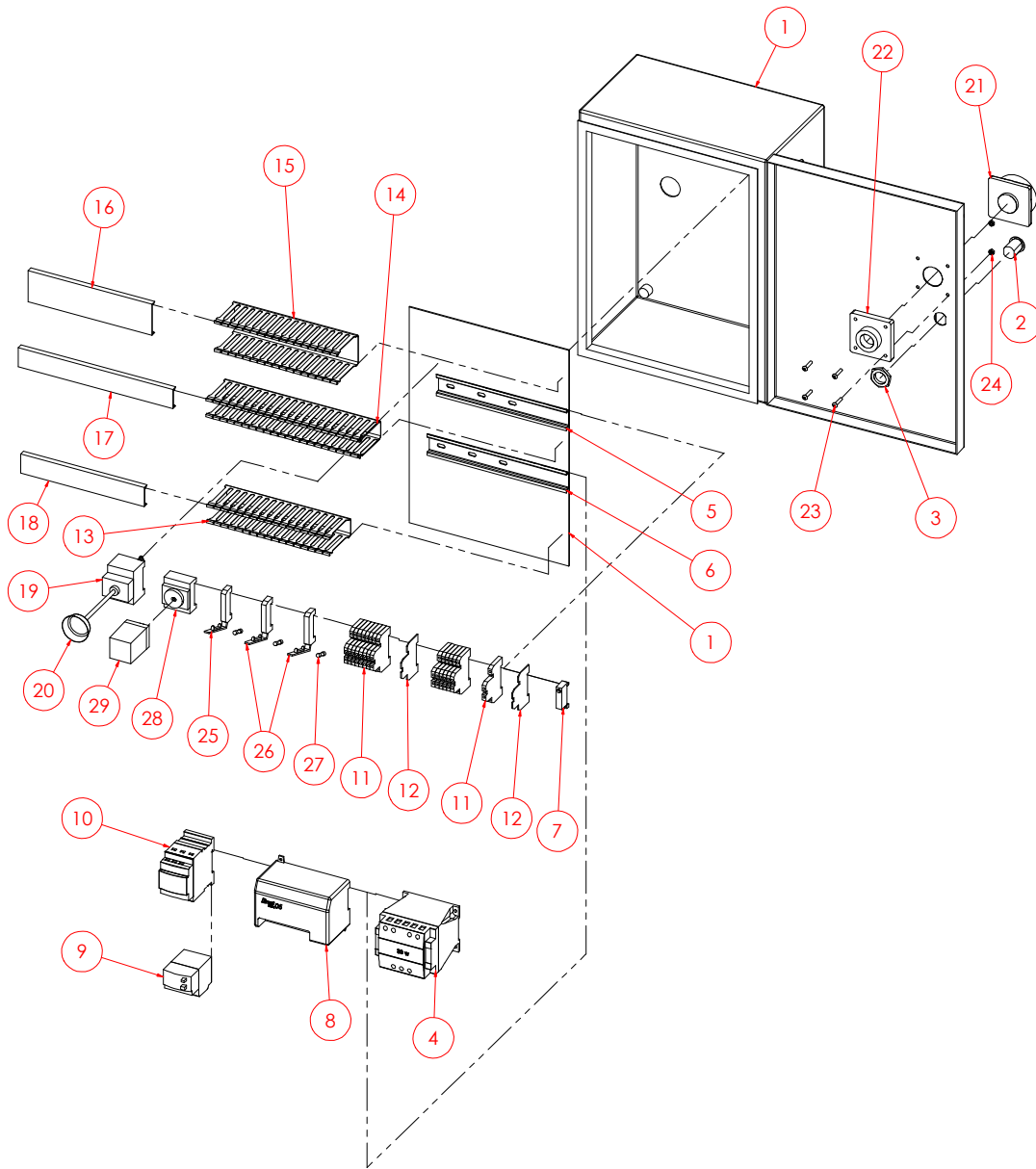
ELECTRIC BOX INSTALLED (USM0808)



ELECTRIC BOX INSTALLED (USM0808)

ITEM	PART #	DESCRIPTION	QTY.
1	UAM0295	ELECTRIC CONTROL BOX UA262024SB TW	1
2	UPM0209	POWER CORD, 14/3	1
3	UPM9719	CAPACITOR 16uF	2
4	UPM0197EV	STR.RELF METL.LIQDTGHT M20X1.5 (8-10mm)	3
5	UPM0341EV	LOCKNUT M20 X 1.5(FOR STRAIN RELF)	3
6	UF4231	FW M12	4
7	UF4230	L.W. ZINC M12	4
8	UF3062	HHCS M12-1.75 x 25	2
9	UF4234	HNR M12 x 1.75	2
10	UPM0225	CABLE 18/3 TYPE SJ	2.1m
11	UPM0225	CABLE 18/3 TYPE SJ	2.1m
12	UPM9728	LOCKNUT M16 X 1.5(FOR STRAIN RELF)	2
13	UPM9727	STR.RELF METL.LIQDTGHT M16X1.5 (8-10mm)	2

ELECTRIC BOX ASSEMBLY (UAM0295)

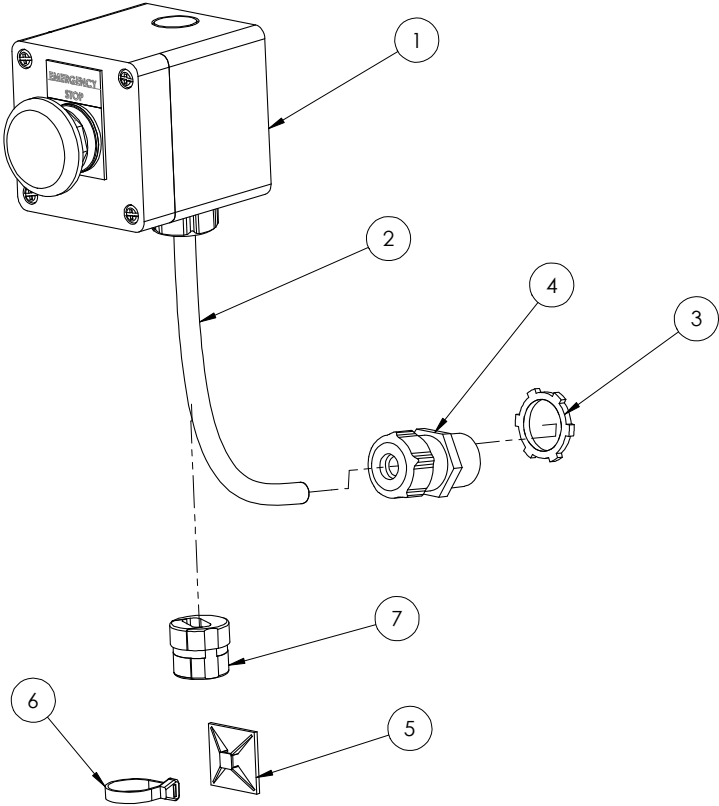


ELECTRIC BOX ASSEMBLY

(UAM0295)

ITEM	PART #	DESCRIPTION	QTY.
1	UPM3418EV	BOX ELECT. 400mm X 305mm X 150mm	1
2	UPM4465 it 1	CAM LOCK	1
3	UPM4465 it 2	UPM4465 LOCK NUT	1
4	UPM4458	POWER SUPPLY IDEC 1.3 A	1
5	UPM0407EV	DIN RAIL USA 2324	210mm
6	UPM0407EV	DIN RAIL USA 2324	225mm
7	UPM7440EV	TB END ANCHOR FOR DN SER	1
8	UPM3833	PLC KOYO 8IN VDC 6 OUT RELAY	1
9	UPM4505	MOTOR O/L TELEMEC 7-10A	1
10	UPM7524	MOTOR STARTER TELEMEC 110VAC	1
11	UPM2880EV	TERMINAL BLOCK DOUBLE TW	15
12	UPM2881EV	TERMINAL BLOCK DOUBLE END CAP	2
13	UPM226EV	WIRE WAY 30mm	200mm
14	UPM226EV	WIRE WAY 30mm	250mm
15	UPM254EV	WIRE WAY 50mm	200mm
16	UPM0255EV	COVER 50mm	200mm
17	UPM0177EV	COVER 30mm	250mm
18	UPM0177EV	COVER 30mm	200mm
19	UPM7211 it 1	ON / OFF SAF SWITCH CONT PANEL	1
20	UPM7211 it 2	UPM7211 EXTENSION ROD	1
21	UPM7211 it 3	UPM7211 POSITION INDICATOR S/A	1
22	UPM7211 it 4	UPM7211 CONNECTING S/A	1
23	UPM7211 it 5	BHCS M4 - 0.7 x 20	4
24	UPM7211 it 6	HEX NUT M4-0.7	4
25	UPM7428EV	FUSE TERMINAL BLOCK 5mm, WHITE LED	1
26	UPM4466	FUSE TERMINAL BLOCK 5mm, RED LED	2
27	UPM7120	FUSE 5mm X 20mm 1AMP/250V IEC	3
28	UPM9726	RELAY SOCKET	1
29	UPM4459	RELAY IDEC 24V 11 PINS	1

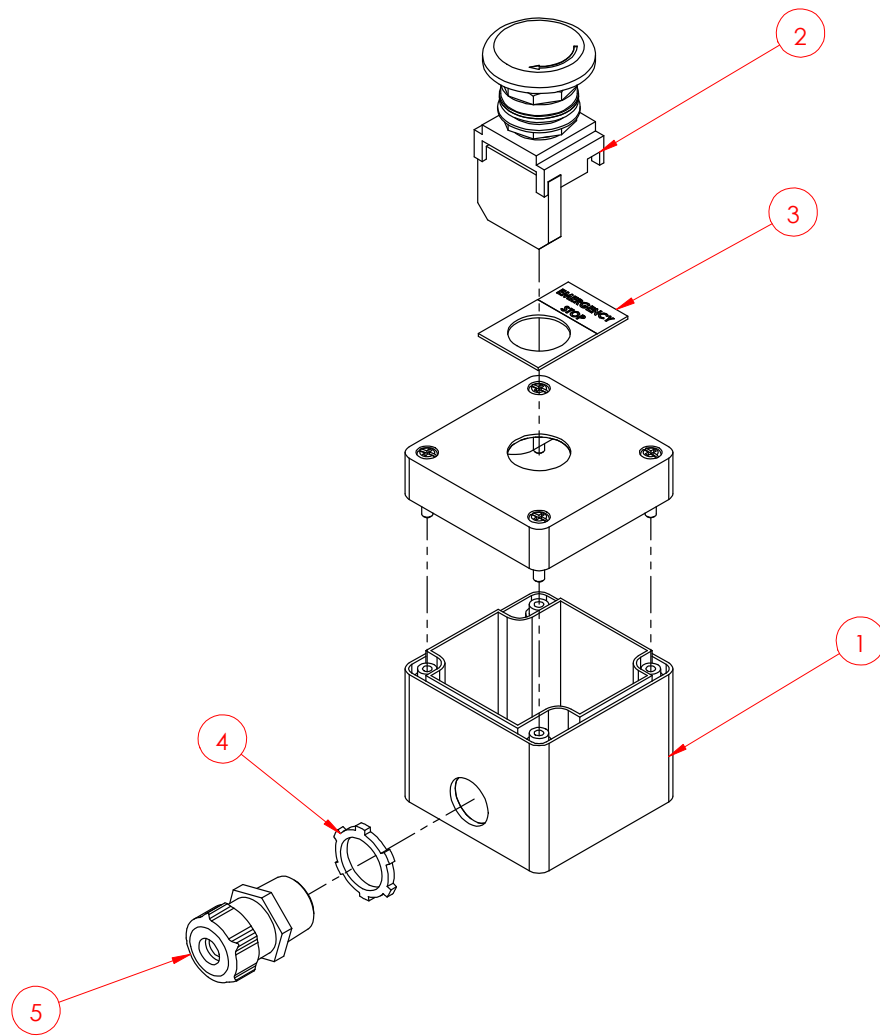
SECOND E-STOP INSTALLED (OPTIONAL) (UM9003)



SECOND E-STOP INSTALLED (OPTIONAL) (UM9003)

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	USM8075	SECOND E-STOP BOX FOR USA	1
2	UPM0225	CABLE 18/3 TYPE SJ	2.0 m
3	UPM0341	LOCKNUT 1/2"(FOR STRAIN RELF)	1
4	UPM0197	STR.RELF METL.LIQDTGHT 1/4-3/8	1
5	UPM0200	MTG. CLAMP,ADH.1.2"X1.2"	4
6	UPM0222	TY-RAP,5.5"X.14"	4
7	UPM0285	STRAIN RELIEF, NON-METAL	1

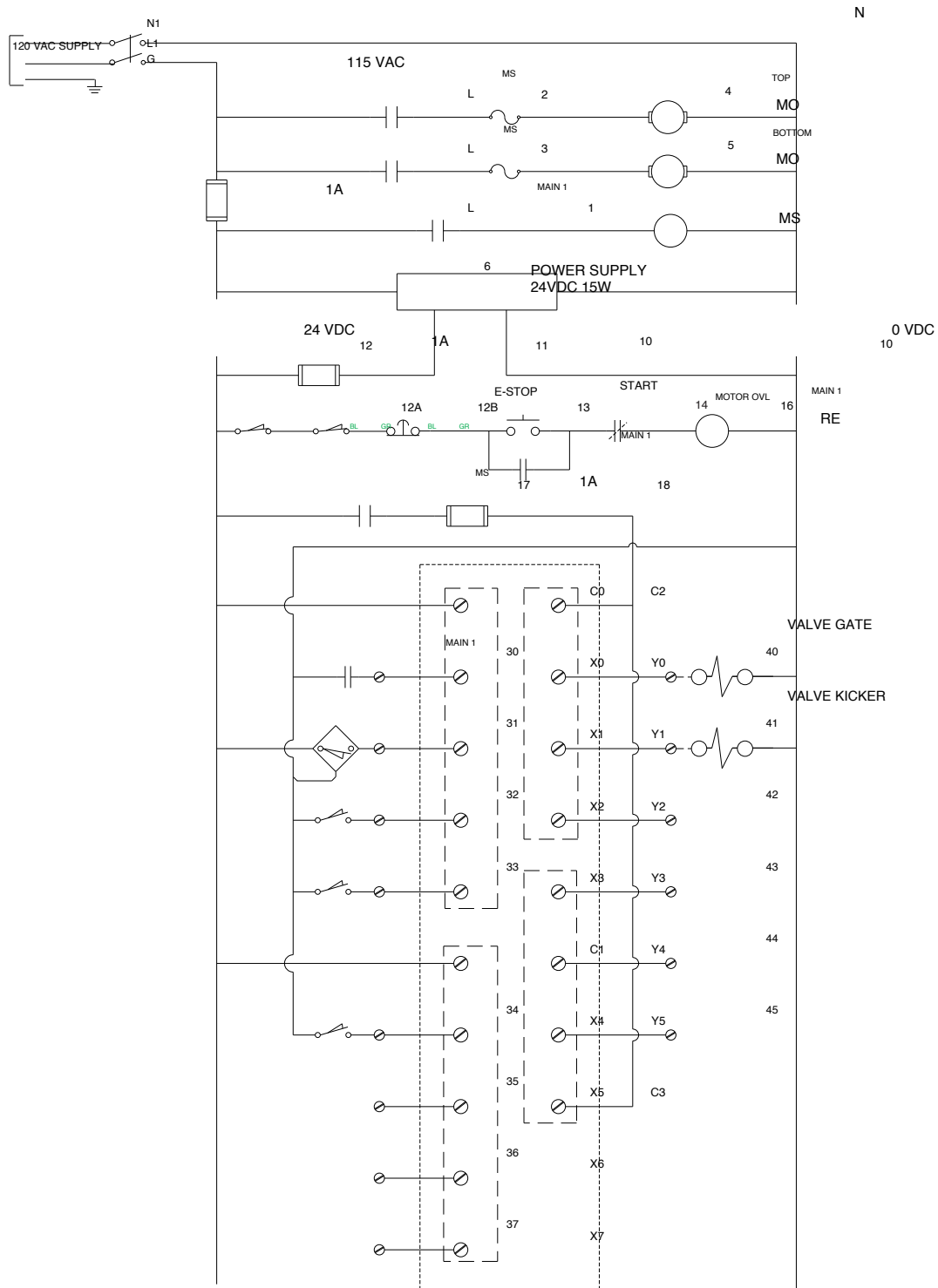
SECOND E-STOP BOX ASSEMBLY (OPTIONAL) (USM8075)



SECOND E-STOP BOX ASSEMBLY (OPTIONAL) (USM8075)

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	UPM7293	ENCLOS PB 1 HOLE NON METAL	1
2	UPM2211	BUTTON MUSHROOM 22MM 1 N.C.	1
3	UPM2209	LEGEND PLATE "E-STOP"	1
4	UPM0341	LOCKNUT 1/2"(FOR STRAIN RELF)	1
5	UPM0197	STR.RELF METL.LIQDTGHT 1/4-3/8	1

ELECTRIC DIAGRAM



PNEUMATIC DIAGRAM

