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**INTERPACK**

**PACKAGING SYSTEMS**

# USA 2024-SB

STAINLESS STEEL

UM075TW/575TW

SERIAL STARTING BY TM075.... or  
TM575....

OPERATION MANUAL

&

PARTS LISTS



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## SERVICE INSTRUCTIONS

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### Service

This is the Interpack Model USA 2024-SB Carton Sealing 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** 1-800-474-8273 ext. 4301.

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 1-514-631-7965.

### 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:



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## WARRANTY

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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 Model USA 2024-SB Carton Sealing Machine with the following warranties:

1. The HSD<sup>®</sup> 2000 Tape Heads' knife blades, springs and wipe down rollers will be free from all defects for a period of ninety (90) days. A lifetime warranty is available after delivery with an Annual Tape Agreement and completed Pioneering Protection Warranty form. Contact your Intertape representative for further details.
2. All other HSD<sup>®</sup> 2000 Tape Head parts will be free from all defects for one (1) year after delivery.
3. The Gear Motors will be free from defects for one (1) year after delivery.
4. All other 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.

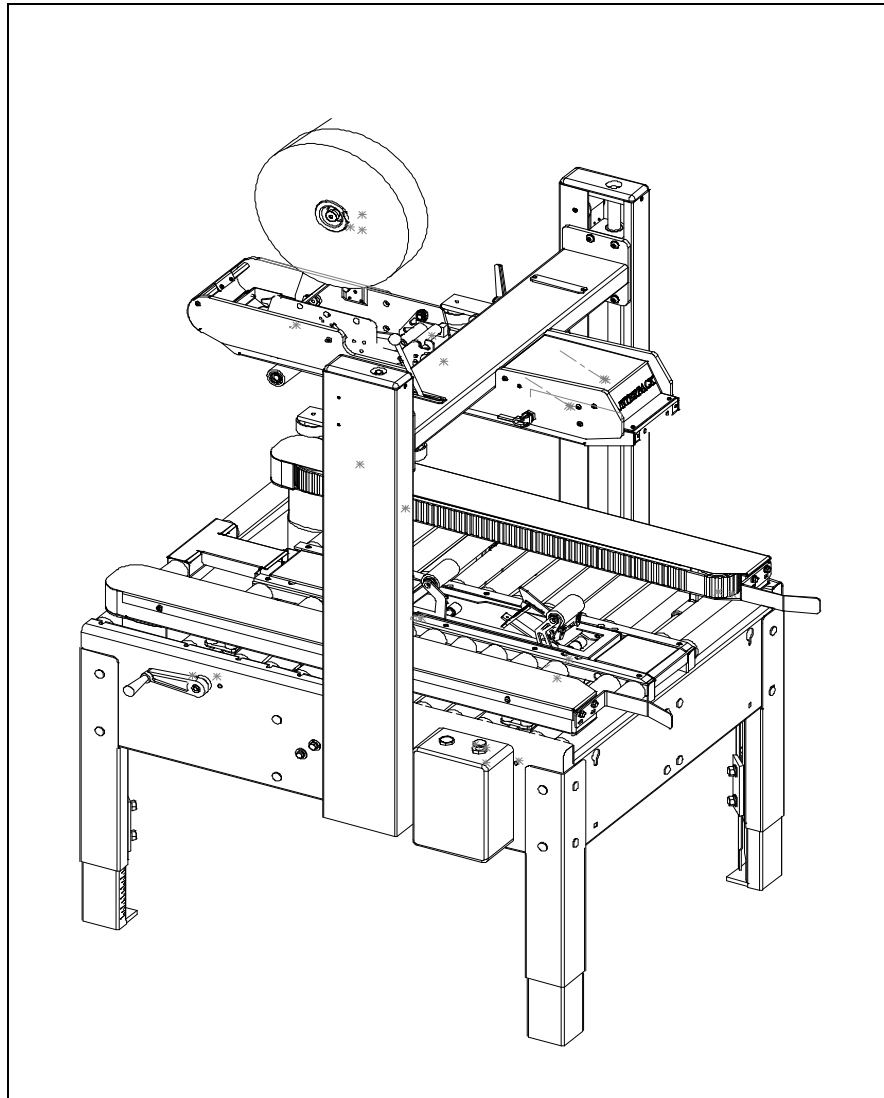
Intertape shall have no obligation to provide or pay for the labour required to install the repaired or replacement part. Intertape shall have no obligation to repair or replace (1) those parts failing due to operator misuse, carelessness, or due to any accidental cause other than equipment failure, 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.

## DESCRIPTION OF USA 2024-SB

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**Figure 1**

The Interpack USA 2024-SB Carton Sealing Machine with HSD<sup>®</sup> 2000 Tape Heads is designed to apply Intertape brand pressure sensitive carton sealing tape to the top and bottom centre seam of regular slotted corrugated cartons. The USA 2024-SB is manually adjustable to a wide range of carton sizes (see Carton Size Capacity, page 10) and permits processing of underfilled and overfilled applications by means of compression guides and a one-inch floating top tape head assembly. The self centring Side Belt Drive system makes carton width adjustment effortless. The USA 2024-SB Carton Sealer features mirror image controls to facilitate its adaption into an existing conveyor line.

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## **SAFETY ISSUES**

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There are a number of safety labels used on Interpack Carton Sealers. These labels are placed at different locations (refer to figure 2) on the machine to warn operators and service personnel of possible dangers. 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 and service machine.**
- ✓ **Wear safety glasses.**
- ✓ **Shut off power to machine before adjusting.**
- ✓ **Unplug electrical power before servicing.**
- ✓ **All covers and guards must be in place before operating.**
- ✓ **Stay clear of moving parts which can shear and cut.**
- ✓ **Never operate the Tape Heads with the Knife Guard removed.**
- ✓ **Turn electrical supply off before servicing the Tape Heads, including tape loading and threading.**

# SAFETY ISSUES

## PLACEMENT OF WARNING LABELS

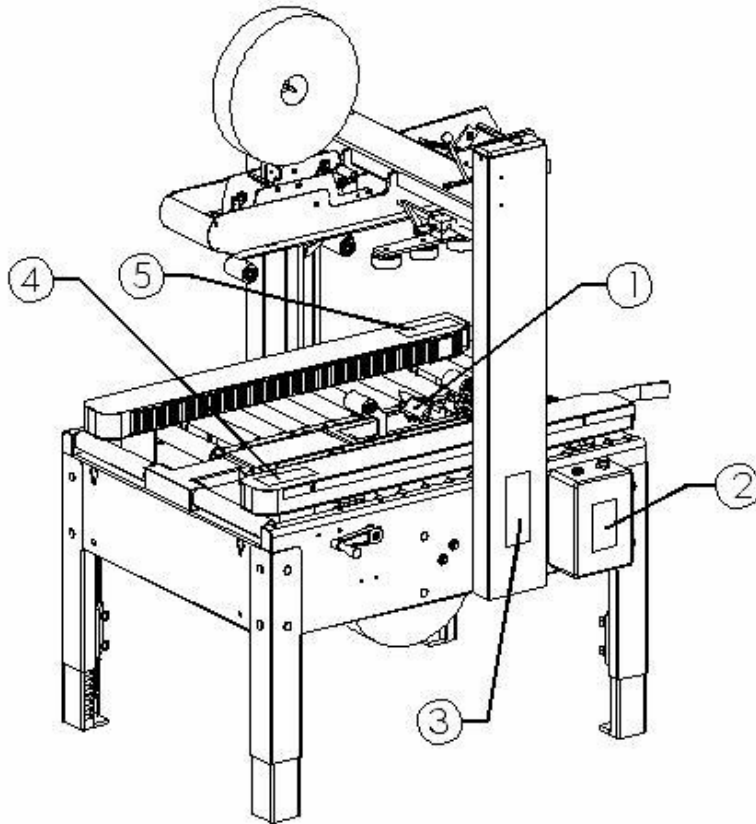


Figure 2

1)

**⚠ WARNING**

Sharp  
Cutting  
Blade

(The same label can be found on the top  
tape head as well)

2)





3)

**⚠ WARNING**

**OPERATION / SERVICE**

- Only trained people are to operate and service machine.
- Shut off power to machine before adjusting.
- Unplug electrical power before servicing.

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**MACHINE MANUAL**  
For other important safety, operating and service information read this machine's manual.

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**EYE HAZARD**  
Wear Safety Glasses which conform to ANSI Std. Z87.1 or EN 166 

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**COVERS AND GUARDS**  
All covers and guards must be in place before operating machine.

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**ELECTRICAL SHOCK**   
Hazardous voltages may cause personal injury.  
Only authorized and qualified personnel are to service electrical enclosures.

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**FAILURE TO FOLLOW THE ABOVE COULD RESULT IN SEVERE INJURY.**

4)

**⚠ WARNING**



Moving machine parts can crush, cut and shear.  
Disconnect and lockout all power before servicing machine.  
Failure to follow the above can result in severe personal injury.

5)

**⚠ WARNING**



Moving parts can shear and cut.  
Disconnect and lockout all power before servicing machine. Failure to follow the above can result in severe personal injury.

**Note: Should any of the safety labels shown in Figure 2 be damaged or destroyed, replacements are available.**

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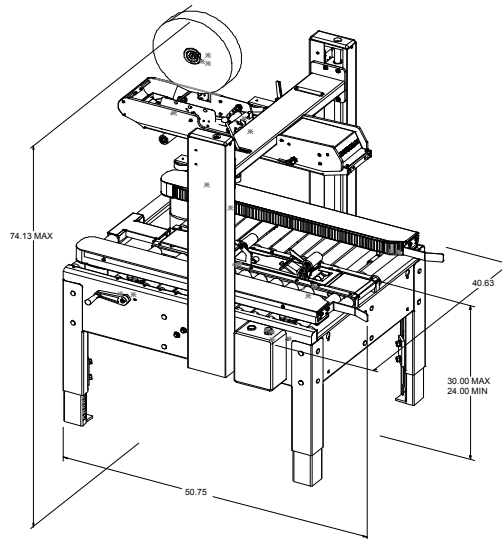
# SPECIFICATIONS

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## Machine Dimensions

Overall outside dimensions:

- Height: 74.13 inches maximum
- Length: 50.75 inches
- Width: 40.63 inches



**Figure 3**

## Machine Weight

The machine weighs 350 lbs.

## Power Requirements

Electrical - 115 VAC, 60 HZ, 9.6 A.

Standard electrical equipment:

- Two (2) 1/3 H.P. gear motors,
- A neoprene power cord, and
- A grounded plug.

Contact your Intertape representative for power requirements not listed above.

## Operating Speed

Belt speed is 82 feet per minute. Actual production rate is dependent on operator's dexterity and the case size mix.

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## **SPECIFICATIONS**

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### **Operating Conditions**

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

### **Tape**

**1) General**

Use Intertape brand Pressure Sensitive Carton Sealing Tape.

**2) Tape Width**

1.5 to 2 inch wide tape (36 to 48 mm) maximum.

**3) Tape Roll Diameter**

Maximum of 16 inches (405 mm) on a 3-inch (76.2 mm) diameter core.  
(Accommodates all Intertape brand film tape machine roll lengths).

**4) Tape Application Leg Length – Standard**

2.5 inches (+0.25", -0") (63.5 mm, +6.3 mm, -0 mm).

**5) Tape Application Leg Length – Optional**

2 inches (+0.25", -0") (50.8 mm, +6.3 mm, -0 mm). Refer to HSD® 2000  
Tape Head manual for adjustment of tape application leg length.

### **Box Board**

Style: regular slotted containers (RSC)  
125 to 275 psi bursting test, single or double wall B or C flute.

### **Carton Weight Capacity**

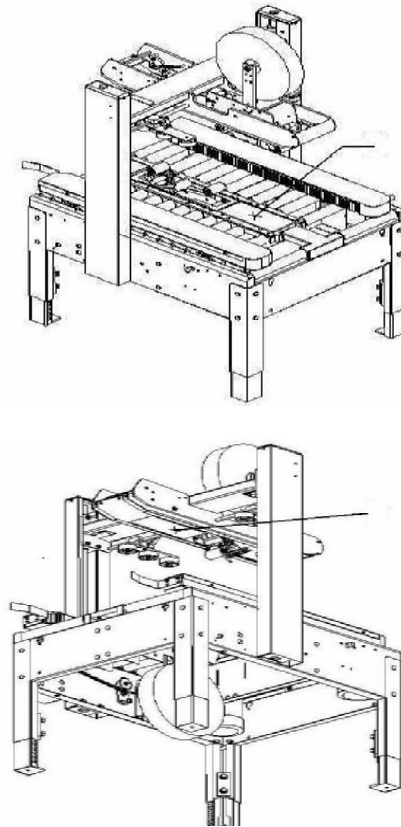
Up to 50 lbs.

# SPECIFICATIONS

## Carton Size Capacity

	Height (inches)	Width (inches)	Length (inches)	
<b>Standard</b>	<i>minimum</i>	4.5	4	6
	<i>maximum</i>	24	20	Infinite
<b>Optional</b>	<i>minimum</i>	2*	8	6
	<i>maximum</i>	24	20	Infinite

\*The optional carton size of 2 inches high by 8 inches wide is achieved by the offset design of the Tape Heads. Remove the gap filler plates to process these low cartons. (Refer to Figure 4)



**Figure 4**

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# SET-UP PROCEDURES

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## Receiving and Handling

The machine is shipped to the customer in a box and fixed to a pallet.

- Remove the strapping and the staples at the bottom of the box.
- Lift off the box cover and sleeve.
- Remove the mounting bolts and nuts, which secure the USA 2024-SB to the shipping pallet.
- Lift the machine off the pallet and install it on your packaging line.
- Remove all tie wraps and other shipping materials.

**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.*

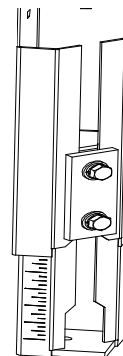
## Setting-up

### 1) General

The Carton Sealer must be installed on a near level ground.

Ensure that the machine is level and firmly on the ground (no rocking). Adjust the roller height with the four (4) telescopic adjustment legs to accommodate conveyor heights from 24 to 30 inches.

To adjust the Carton Sealer height, jack up the machine to give ample room to extend the legs. Using a 9/16" box end wrench, loosen the eight (8) 1/2" hex head bolts. Adjust the legs to the desired conveyor height and tighten the bolts. Etched scales on the legs facilitate proportionate levelling.



**Figure 5**

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## SET-UP PROCEDURES

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Customer supplied infeed and exit conveyors (or rollers) must be level with the machine, otherwise, the performance of the machine may be affected. The customer-supplied infeed conveyor (if used) should provide straight and level entry. The customer-supplied exit conveyor (if used) should be straight and declined no more than 1/4 inch per foot away from the machine.

### 2) Electrical Connection

The electrical control can be located on either side of the Carton Sealer for customer convenience. It contains the green "on" push button and the red "E-Stop" mushroom push button, which is to be used both for emergency stops as well as regular halting of the machine.



**Figure 6**

An eight (8) foot standard three conductor power cord with plug is provided for 115 V, 60 Hz, 15 amp electrical service. The servicing receptacle must be properly grounded. Before the machine is plugged into the receptacle, ensure that all materials are removed from the machine. The electrical control is protected with an automatic circuit breaker with resettable overload.

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## SET-UP PROCEDURES

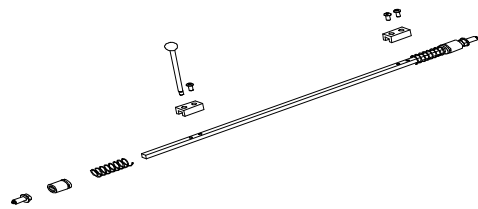
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### 3) Mirror Image Controls

Other than the electrical control box, there are three (3) other mirror image controls that can be placed on the right or the left hand side of the machine for easier operation.

#### 1) Single Locking System

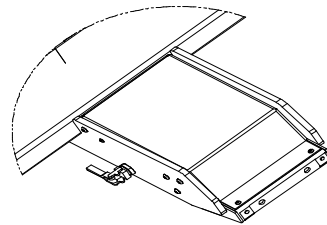
This system is located on the bridge of the Top Tape Head Box and is used to adjust the height of the Top Tape Head to the height of the carton. The lever is assembled on the left hand side. To change sides, simply remove the cap on the right, unscrew the lever and screw it back on the right side. Replace the cap on the left side.



**Figure 7**

#### 2) Locking Floating System

The lever for this system is located on the left side of the Top Tape Head Box. It has toggle clamp used to lock or unlock the floating system. For opposite side installation: remove red cover cap on right hand side, unscrew the toggle clamp with  $\frac{3}{4}$ " wrench, replace one with the other, secure the toggle's position with the locknut.



**Figure 8**

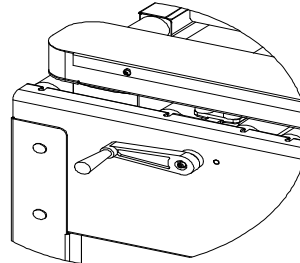
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## SET-UP PROCEDURES

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### 3) Width Adjustment Handle

The foldable handle that is used to adjust the width of the self-centering side rails is located on the left hand side of the machine. Unscrew and change sides.



**Figure 9**

### 4) **Tape Loading and Threading**

#### A) Tape Loading

**WARNING!** *TURN OFF ELECTRICAL POWER SUPPLY AND DISCONNECT THE POWER CORD FROM THE ELECTRICAL SUPPLY BEFORE BEGINNING TO WORK ON THE TAPE HEADS OR TO LOAD TAPE. IF POWER CORDS ARE NOT DISCONNECTED, SEVERE INJURY TO PERSONNEL COULD RESULT.*

The HSD2000<sup>®</sup> - 48 tape heads accommodate 2-inch wide tape rolls, while the optional HSD2000<sup>®</sup> - 75 tape heads accommodate 3-inch wide rolls. See the label on the side of the HSD2000<sup>®</sup> tape head for the loadable tape sizes.

Push the roll of tape onto the mandrel with the adhesive side up (refer to threading diagram on the HSD2000<sup>®</sup> tape head) until the core is set against the mandrel flange. This ensures the tape will be aligned when feeding into the tape head.



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## SET-UP PROCEDURES

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### B) Tape Threading

**WARNING!**     ***THE KNIFE CONTAINED IN THE TAPE HEAD IS EXTREMELY SHARP. USE CAUTION WHEN REMOVING THE BLADE GUARD AND THREADING THE TAPE TO AVOID PERSONNEL INJURY.***

To thread the tape in the upper Tape Head, you do not require any special tools.

- Push the Tape Head towards the front of the machine and lift up.
- Pull approximately twelve (12) inches of tape from the roll and fold in half lengthwise. This allows you to thread the tape without it adhering to the guide and clutch rollers inside the Tape Head.
- Follow the tape-threading diagram on the side plate of the HSD® 2000 Tape Head. Refer to your Tape Head manual for further information if required.
- Remove the blade guard from the knife in the Tape Head.
- Cut off the folded tape.
- Replace the upper Tape Head to its initial position.

To thread the lower Tape Head, no special tools are required.

- Lift the top Tape Head box to the uppermost position.
- Remove the lower Tape Head by grasping the tape application rollers and lifting straight up.
- Pull approximately twelve (12) inches from the roll and fold in half lengthwise. This allows you to thread the tape without it adhering to the guide and clutch rollers inside the Tape Head.
- Follow the tape-threading diagram on the side plate of the HSD® 2000 Tape Head. Refer to your Tape Head manual for further information if required.
- Remove the blade guard from the knife in the Tape Head.
- Cut off the folded tape.
- Replace the lower Tape Head to its initial position.

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## OPERATING INSTRUCTIONS

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Once the HSD<sup>®</sup> 2000 Tape Heads (both bottom and top) have been loaded with tape and threaded, the machine is ready to process regular slotted cartons. The following instructions are presented in the order recommended for processing cartons successfully through the USA 2024-SB Carton Sealing machine.

1. Unlock the Single locking System and raise the Top Tape Head Box to its maximum.
2. Turn the Width Adjustment Handle to open the drive base in order to allow an empty test carton to slide on the machine
3. Place an empty test carton with the flaps held in closed position under the bridge of the Top Tape Head Box.
4. Adjust the self-centering side rails by turning the Width Adjustment Handle.
5. Block the Floating System by pushing the toggle clamp to "lock".
6. Lower the Top Tape head Box until it touches the top of the carton. Lock the Single Locking System.
7. Adjust the Compression Guides on the side of the carton.
8. Remove the test carton from the machine.
9. Ensure that the electrical power is on.
10. Switch the machine "on" with the start push button.
11. Process the first carton with the flaps in the closed position.
12. When the carton exits the Carton Sealer, process the next carton.

**WARNING!**     **ENSURE THAT THE OPERATOR'S HANDS ARE AWAY FROM THE MOVING BELTS OF THE SIDE DRIVE BASE ASSEMBLY.**

**Note:** *Should any problem occur during processing that requires halting the machine, press the red "E-Stop" mushroom button.*

**Note:** *The machine should never be washed down or subjected to conditions causing condensation on components.*

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## **MAINTENANCE**

Depending on usage, grease acme shaft on a three months interval. Open up drive base by winding handle, apply grease to the acme shaft between the cast iron drive base supports, then close the drive base and repeat application to the outside of cast iron drive base supports. Recommended lubricants are: 1<sup>st</sup> Bacon 325 (ESSO brand), 2<sup>nd</sup> graphite base greases, 3<sup>rd</sup> standard ball-bearing grease.

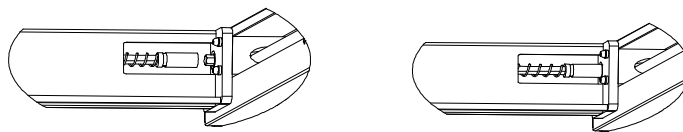
Spray column shaft once a month with a silicon based dry film lubricant. This won't attract dust and lint from the surroundings.

No other lubrication is necessary to operate the machine.

## TROUBLESHOOTING

Interpack Carton Sealers are fabricated with high quality components that provide trouble-free operation for a long period. However, should a problem occur, we recommend that you consult the following table. If the problem you encounter is not discussed in this table, call Intertape Customer Service Department (see page 2 of this document).

TROUBLE	POSSIBLE CAUSES	SOLUTIONS
Main power is turned "on" and nothing happens.	Overload protection by circuit breaker.	Check that all circuits are "on".
Cartons are not taped properly.	Tape Head is not adjusted correctly.	Refer to Tape Head manual.
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. On loose side, under the bridge, remove socket completely from screw head, unlock the Tape Head Box with the lever and re-insert socket. Refer to Figure 11



**Figure 11**

## RECOMMENDED SPARE PARTS LIST

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We recommend that you stock the following spare parts.

DESCRIPTION	ITEM NUMBER	RECOMMENDED QUANTITY
2-inch drive belts	UPM0663	2
Drive pulley	UPM0129EV	2
Bearing for pulley	UPM0324EV	2
Flanged screw ½-13 l.h.	UPM2844	1
Flanged screw ½-13 r.h.	UPM2846	1
Linear bearing	UPM2177EV	2
Locking handle for compression guide	UPM0037 & UF3535	1 & 1
Bumpers	UPM2861	16
Rollers	UPM3301	3
Rollers blind hole	UPM3300	6
Pivot extension spring	UPM2868	2

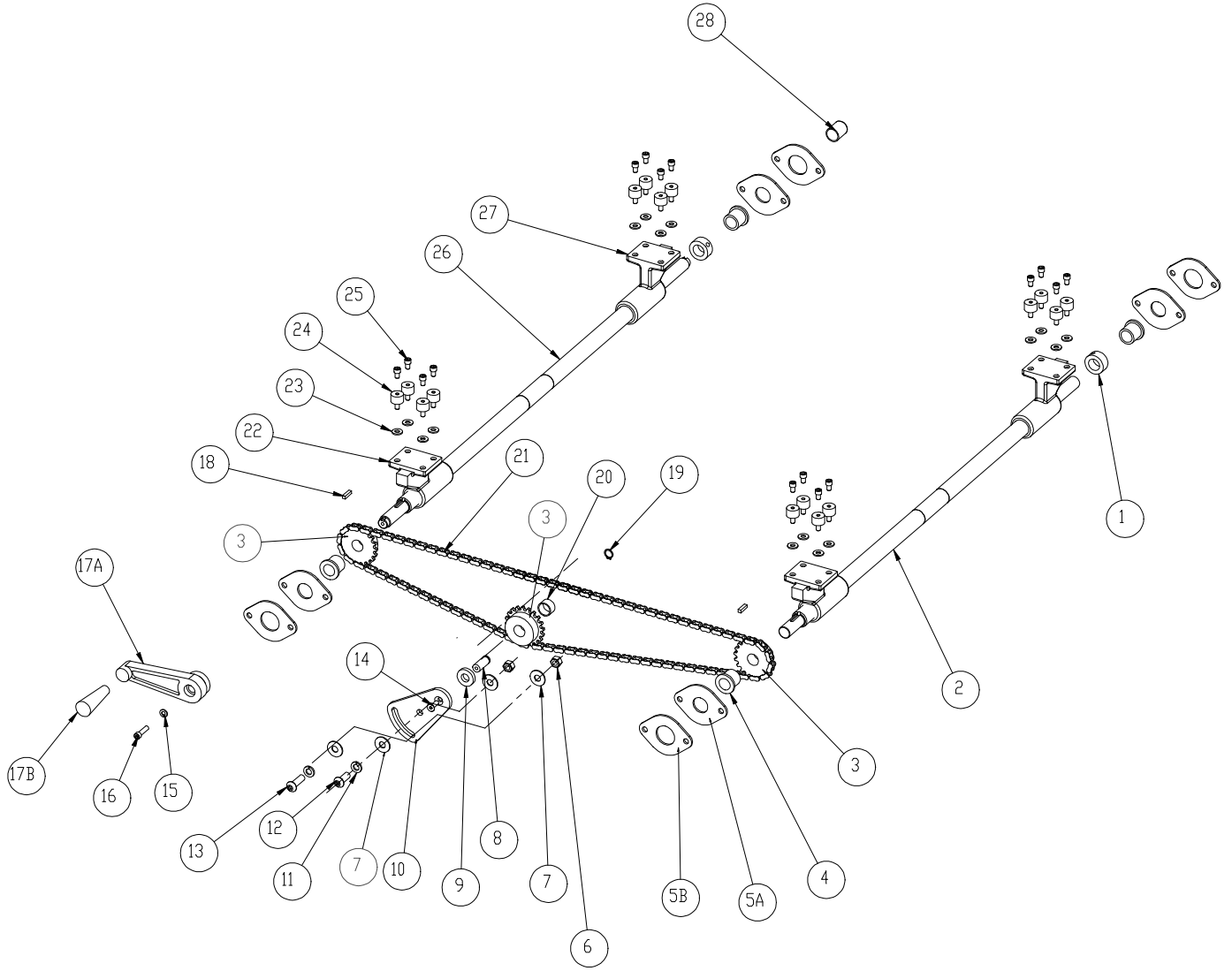


# APPENDIX A – ILLUSTRATIONS AND PARTS LISTS

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## APPENDIX CONTENTS

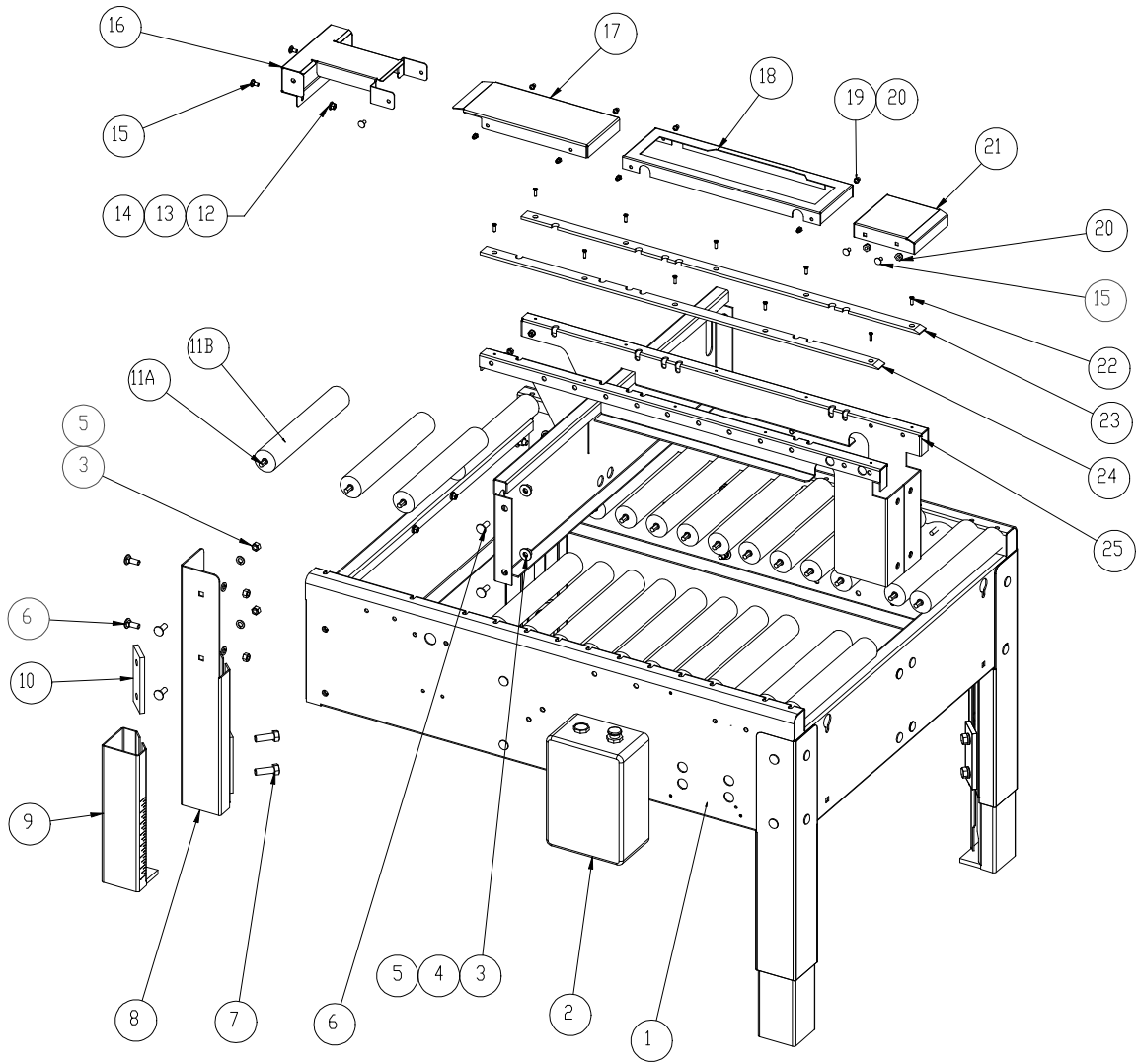
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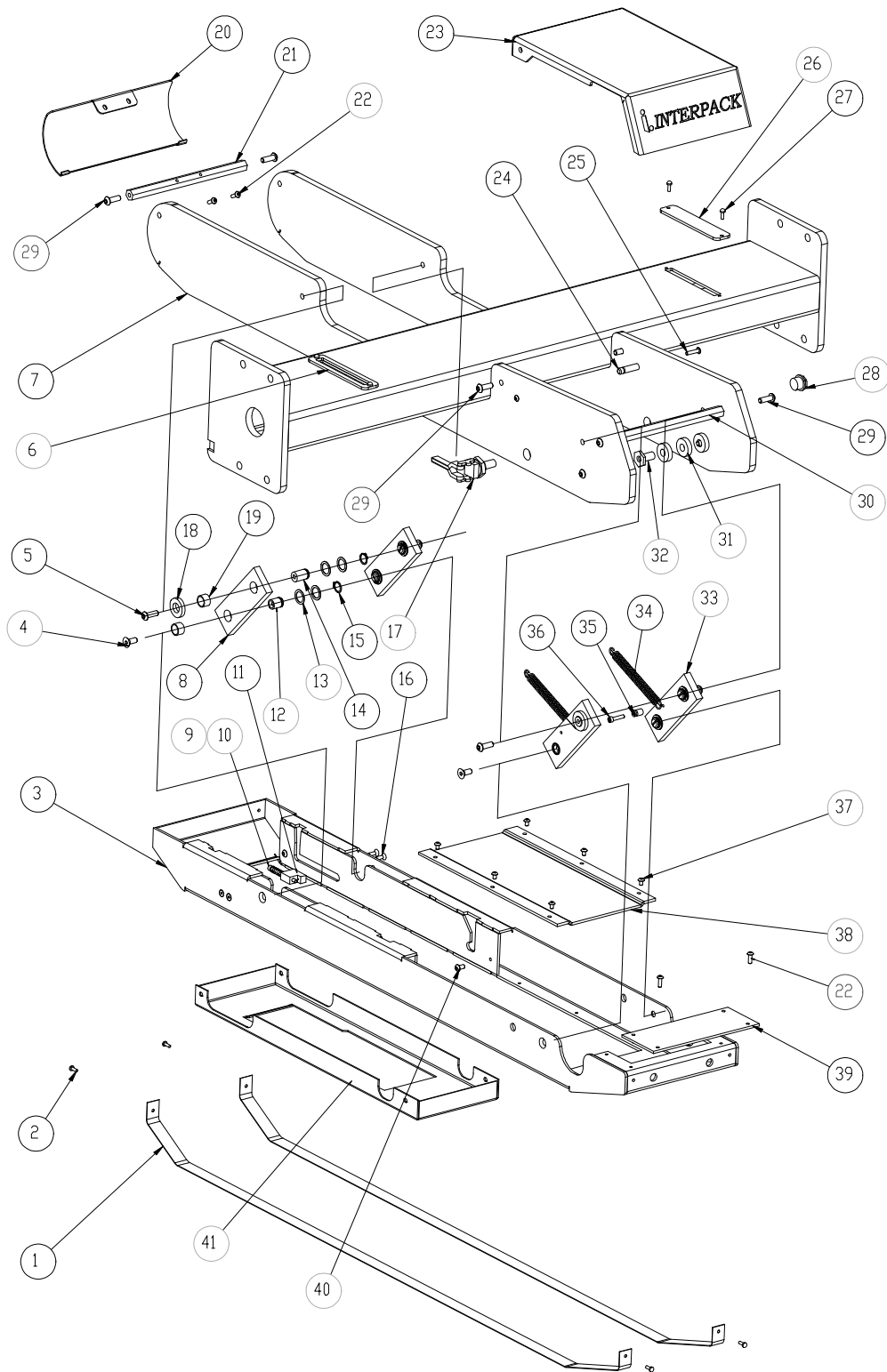
## CENTERING MECHANISM

ITEM NO.	QTY.	PART NO.	DESCRIPTION
1	2	UPM2919EV	SS Shaft collar w/set sc-3/4"bore
2	1	UPM2856EV	SS Acme shaft, no handle
3	3	UPM2779EV	SS Sprocket
4	4	UPM2895EV	Flange bearing lglide
5A	4	UPM2894	Bearing spacer 1.00 ID
5B		UPM2864	Bearing spacer1.26 ID
6	2	UF3377EV	SS Hex nut g5z 3/8-16
7	4	UF3398	SS Reg f.w. zinc 3/8 bs
8	1	UPM0640EV	Chain tensionner , pin
9	1	UPM2863	SS Chain tensionner spacer
10	1	UPM2862	SS Chain tensionner , base plate
11	2	UF3420	SS L.w. zinc 3/8
12	1	UF3304EV	SS Bhcs g5z 3/8-16 x 1.0
13	1	UF3317EV	SS Bhcs g5z 3/8-16 x 1.25
14	1	UF3240EV	SS Fhcs hk 1/4-20 x 3/4
15	1	UF3410	SS L.w. zinc ¼
16	1	UF3144EV	SS Shcs hk 1/4-20 x 1
17A	1	UPE0001	Handle foldable
17B	1	UPM2904	SS Retract handle
18	2	UF3570EV	SS Square key zinc 3/16 x 3/16 x 3/4
19	1	UF3565	SS Retaining ring 1/2
20	1	UPM0639	Brass bushing, .5 id x .75 od x .75 lg
21	1	UPM2780	SS Chain 35 for usa 2024 sb2
22	2	UPM2858	SS Casting_mach'd_1.0_square_lh
23	16	UF3445	SS F.w. 1/4 x 5/8 x .046 b1526
24	16	UPM2861	SS Bumper
25	16	UF3151	SS Shcs 1/4-28 x 3/8
26	1	UPM2855EV	SS Acme shaft, for handle
27	2	UPM2857	SS Casting_mach'd_1.0_square_rh
28	1	UPM2207	Cap vinyl black



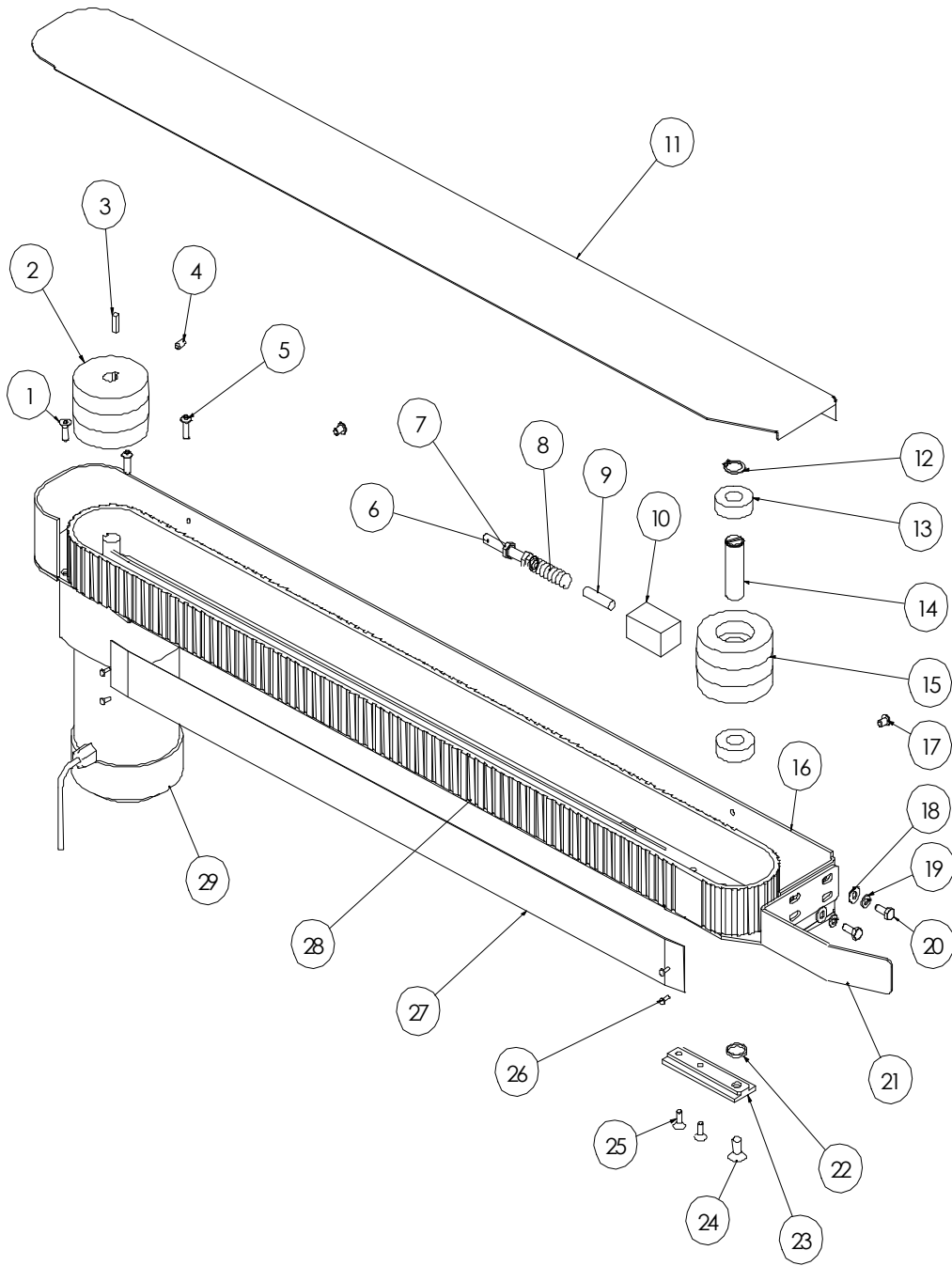
**BASE, STRUCTURE**

ITEM NO.	QTY.	PART NO.	DESCRIPTION
1	1	UPM2829EV	SS Outside frame weldment, base
2	1	UPM2214EV	Box elec. Abs 10" x 7"
3	10	UF3377	SS Hex nut g5z 3/8-16
4	24	UF3420	SS L.w. zinc 3/8
5	4	UF3398	SS Reg f.w. zinc 3/8 bs
6	23	UF4023	SS Carriage bolt 3/8-16 x 1
7	8	UF3050	SS Hhcs g5z 1/2-13 x 1-1/2
8	4	UPM2830	SS Leg base assy
9	4	UPM0548	SS Leg adjustment
10	4	UPM2832	SS Leg friction plate
11A	52	UPM3300	SS PVC Roll blind hole fastener
11B	26	UPM3301	PVC Roller
12	2	UF3385	SS Reg f.w. zinc 1/4 bs
13	4	UF3410	SS L.w. zinc 1/4
14	4	UF3376	SS Hex nut g5z 1/4-20
15	8	UF4022	SS Carriage bolt hk 1/4-20 x 1/2
16	1	UPM2165	Outlet cover
17	1	UPM2249	Rear gap filler
18	1	UPM2671	ET T.H insert 2"
19	4	UF3139	SS Shcs 1/4-20 x 3/8
20	8	UF3380	SS Nylon lock nut 1/4-20
21	1	UPM0605	Inlet cover
22	10	UF4223	SS Self tapping screw 10-32 x 5/8
23	1	UPM0606	Sliding pad r.h.
24	1	UPM0609EV	Sliding pad l.h.
25	1	UPM2831EV	SS Inside frame weldment, base



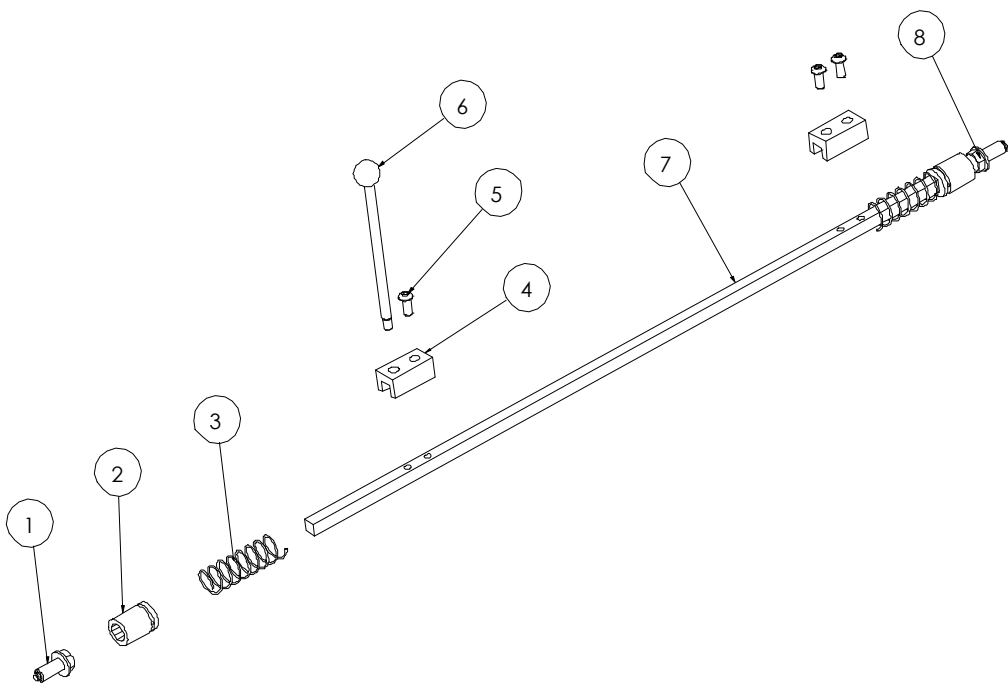
## FLOATING TOP HEAD

ITEM NO.	QTY.	PART NO.	DESCRIPTION
1	2	UPM0030	Strip, uhmw, 3/4" w x .03" thk x 45"L
2	4	UF3510EV	SS Pop rivet s-44
3	1	UPM2834EV	SS T.h.box usa 2024 s.b.
4	4	UF3230EV	SSFhcs hk 1/4-20 x 5/8
5	4	UF3298EV	SS Bhcs 1/4-20 x .75
6	1	UPM1011	Bridge plate cover slotted
7	1	UPM2841EV	SS Bridge, weldwent
8	2	UPM2837EV	SS Pivot plate
9	2	UPM2835	SS Comp.spring swivel t.h. assy
10	2	UF3107EV	SS Shcs hk 8-32 x 2"
11	2	UPM2836EV	SS Spring support
12	4	UPM2247EV	Pivot shaft short t.h. box
13	8	UF1940	Nylon f.w. 1/2 500-032
14	4	UPM0968EV	Pivot shaft t.h. box
15	8	UF3552EV	SS Retaining ring 1/2
16	4	UF3101EV	SS Fhcs #8-32 x 1/2
17	1	UPM2870	SS Toggle clamp
18	4	UPM1158	Pivot shaft spacer
19	8	UPM3368EV	SS Bearing glycodur .50 x .38 lg
20	1	UPM2867	SS Rear cover guarding
21	1	UPM2842EV	SS Hexagon spacer bar , rear
22	4	UF3311	SS Bhcs 8-32 x 1/2
23	1	UPM2284	Front cover guarding
24	2	UPM2840EV	SS Spring retainer long
25	2	UF3307EV	SS Bhcs 8-32 x 3/4" zinc
26	1	UPM1008	Bridge plate cover
27	4	UPM2192	Black belly button
28	1	UPM2237	Threaded plug
29	8	UF3288EV	SS Bhcs 1/4-20 x .75 zinc
30	1	UPM2843EV	SS Hex. Spacer bar, front
31	6	UPH133	Stop, knife arm, 15/16"d.ureth.
32	2	UPM2879EV	SS Stop retainer t.h. box
33	2	UPM2838EV	SS Pivot plate front
34	2	UPM2868	SS Pivot extention spring
35	2	UPM2833EV	SS Spring retainer short
36	2	UF3105EV	SS SHCS HK 8-32 x 3/4
37	6	UF3316EV	SS Bhcs 8-32 x 1/4
38	1	UPM2839	SS Filler
39	1	UPM1007	Front plate guarding
40	4	UF3306	SS Bhcs 10-32 x 3/8
41	1	UPM2670	ET TH top gap filler



**DRIVE BASE**

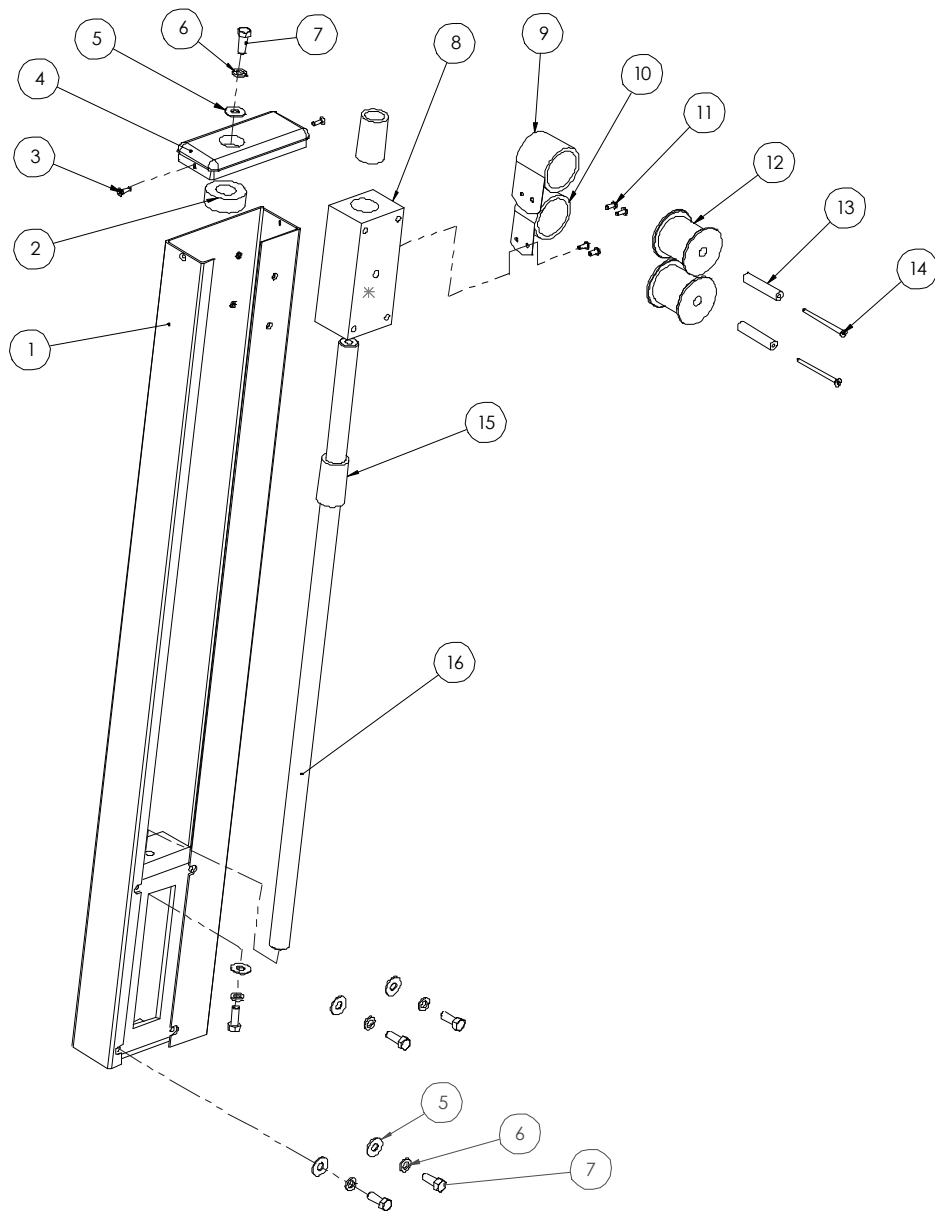
ITEM NO.	QTY.	PART NO.	DESCRIPTION
1	1	UF3260EV	SS fhcs 1/4-28 x 3/4
2	1	UPM0129EV	Drive pulley
3	1	UF3570EV	SS Square key zinc 3/16x 3/16x 3/4
4	1	UF3330EV	SS Sss hk 1/4-20 x 3/8
5	3	UF3339EV	SS Bhcs hk 1/4-28- x 3/4
6	1	UF3350	SS Sss hk 3/8-16 x 3
7	3	UF 3360	SS Hex jam nut zinc 3/8-16
8	1	UPM0048	SS Die spring (drive base)
9	1	UPM1237	SS Spring locator pin
10	1	UPM1234	SS Tensionner spring holder
11	1	UPM2783, UPM2785	SS Drive base cover right side / left side
12	1	UF3581	SS Snap ring (medal) sh0075pa
13	2	UPM0324EV	Bearing, pulley
14	1	UPM1233	SS idler pulley shaft
15	1	UPM0259EV	Idler pulley
16	1	UPM2782EV, UPM2793EV	SS Drive base right side/ left side
17	2	UF3294EV	SS Bhcs 1/4-20 x .38
18	2	UF3385	SS Reg f.w. zinc 1/4 bs
19	2	UF3410	SS L.w. zinc 1/4
20	2	UF2999EV	SS Hhcs g5z 1/4-20 x 5/8
21	1	UPM0647	Carton retainer
22	1	UPM0109	Idler pulley spacer
23	1	UPM2156	SS Tensionner slide
24	1	UF3280	SS Fhcs hk 3/8-16 x 3/4
25	2	UF3230	SS Fhcs hk 1/4-20 x 5/8
26	4	UF3510EV	SS Pop rivet s-44
27	1	UPM0029	Strip uhmw 2" x .03"thk
28	1	UPM0663	Belt, drive, 2"x83.0"
29	1	UPE0085EV	Motor 1/3 hp wdwn





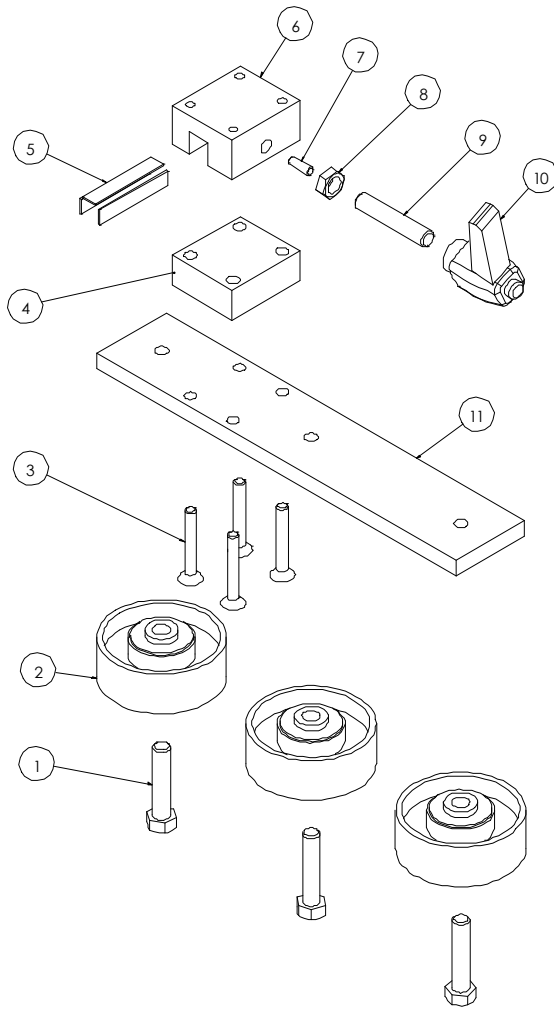
## SINGLE LOCKING

ITEM NO.	QTY.	PART NO.	DESCRIPTION
1	1	UPM2844	SS Flanged screw 1/2-13 l.h.
2	2	UPM0703	Short box 3/4", 1/2" dr, 12 pt
3	2	UPM2906	SS Spring, c0850-068-4000-S
4	2	UPM2866EV	SS Single locking block
5	3	UF3303	SS Bhcs hk 5/16-18 x 3/4
6	1	UPM2865	SS Single locking handle
7	1	UPM2869EV	SS Square bar 0.50"
8	1	UPM2846	SS Flanged screw 1/2-13 r.h.



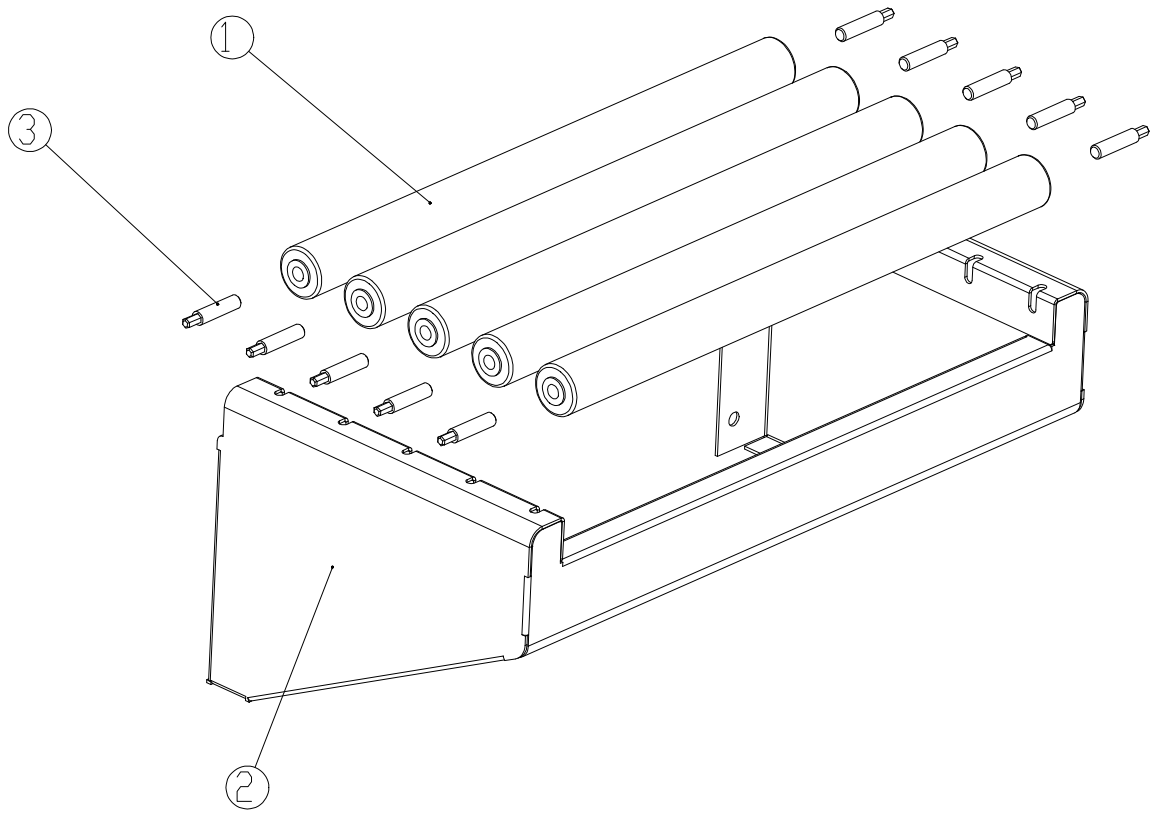
**COLUMN**

ITEM NO.	RIGHT SIDE		LEFT SIDE		DESCRIPTION
	QTY.	PART NO.	QTY.	PART NO.	
1	1	UPM2847EV	1	UPM2845EV	SS Column
2	1	UPM2251	1	UPM2251	Safety bumper
3	2	UF3194EV	2	UF3194EV	SS Fhcs 10-24 x 1/2" zinc
4	1	UPM2182EV	1	UPM0741EV	Column cap
5	6	UF3398	6	UF3398	SS Reg f.w. zinc 3/8 bs
6	6	UF3420	6	UF3420	SS L.w. zinc 3/8
7	6	UF3010EV	6	UF3010EV	SS Hhcs g5z 3/8-16 x 1.0
8	1	UPM0735EV	1	UPM0737EV	Column block
9	0	UPM2181	1	UPM2181	Constant force spring 24 lbs
10	2	UPM0740	1	UPM0740	Constant force spring 33 lbs
11	4	UF3305EV	4	UF3305EV	SS Bhcs 10-32 x 1/2"
12	2	UPM0742	2	UPM0742	Spring mandrel
13	2	UPM0743	2	UPM0743	Spring mandrel shaft
14	2	UF3212EV	2	UF3212EV	SS FHCS HK 10-32 x 2.75"
15	2	UPM2177EV	2	UPM2177EV	SS Linear bearing
16	1	UPM2853EV	1	UPM2853EV	SS Column shaft



## COMPRESSION

ITEM NO.	QTY.	PART NO.	DESCRIPTION
1	3	UF3024	SS Hhcs g5z 3/8-16 x 1.75
2	3	UPM1679	Plastic wheel 3"dia.compr.guide
3	4	UF3231EV	SS Fhcs 1.4-20 x 1.75
4	1	UPM2172	Mid plate
5	3	UPM2170	3/8 x 0.03'thk x 2.5 lg uhmw pad
6	1	UPM2171EV	Guide block
7	1	UPM0131	Brass pin
8	1	UF 3360	SS Hex jam nut zinc 3/8-16
9	1	UF3535	SS Rod w/hole zinc 3/8-16 x 2"
10	1	UPM0037	Handle
11	1	UPM2173	Wheel support plate



**TABLE (OPTIONAL)**

<b>ITEM NO.</b>	<b>QTY.</b>	<b>PART NO.</b>	<b>DESCRIPTION</b>
1	5	UPM3302	PVC roller 23.93" x 1.9"od
2	1	UPM2871	SS Table
3	10	UPM3300	SS PVC Roll blind hole fastener



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