

MODEL AS22-2/3

SEMI-AUTOMATIC UNIFORM CARTON SEALER

Version 2.2_1018

OPERATION AND PARTS MANUAL

READ ALL INSTRUCTIONS BEFORE OPERATING THIS MACHINE

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We Value Our Customers

This is the BestPack® Packaging Systems equipment you ordered customized to meet your needs. This quality machine has been set up and tested successfully in the factory with brand name tapes to ensure your highest level of satisfaction.

If problems do occur when operating this equipment, please refer to the Troubleshooting section of this manual for help. If this does not resolve the problem and you need a service call or phone consultation, reference the Customer Service Section of this manual for contact information. Remember to lockout all energy sources (i.e. power down and shut off air supply) and release stored energy prior to servicing or moving the machine to prevent injury.

Replacement Parts, Order Form, Warranty Guidelines, and Warranty Registration

Please take note of the following important items in this manual:

- Recommended replacements parts suggested to keep on hand to minimize downtime
- Troubleshooting section listing the most common causes and simple solutions
- Customer Service Information provided for your support
- Parts Order Form for your convenience
- BestPack® 1-Year Warranty Program and Guidelines
- Warranty Registration Form to activate your warranty

We ask that you fill out the Registration Form provided at the back of this manual and send it in to activate your warranty.

FUTURE COMMODITIES INTERNATIONAL, INC.
BESTPACK® PACKAGING SYSTEMS
1425 S. Campus Ave
Ontario, CA 91761

OWNER'S SAFETY RESPONSIBILITY

Owners and operators of the AS carton sealer are responsible for maintaining an effective safety program. This program should be consistent with good management practices and meet all requirements of applicable laws, regulations, and ordinances. Employees must be aware of and trained to recognize the specific requirements, precautions, and hazards of the sealing machines.

SAFETY AWARENESS

Careful machine operation is the key to safe job performance. Reasonable care and good judgment in machine operation contribute to operator safety and safety of others. Failure to follow simple safety rules and precautions may result in an accident. Always be aware of what is going on in the work area. Recognize hazardous situations before they become an accident.

HAZARD COMMUNICATION STATEMENT AND PRECAUTIONS

Four indicator signal words appear throughout this manual to call your attention to special information, operating procedures, and safety precautions as described below.

- | | |
|-------------------|--|
| NOTE: | This indicator draws emphasis to special information about equipment operation and maintenance procedures. |
| IMPORTANT: | This indicator specifies special instructions or procedures meant to prevent damage to the equipment, associated components, or products. |
| ▲ CAUTION: | This indicator signals hazards or unsafe practices that could result in minor personal injury or property damage. |
| ▲ WARNING: | To prevent accidental start-up and personal injury during routine maintenance or when troubleshooting problems, always turn off the power to the machine first. Then disconnect the machine's electrical and compressed air lines from the main supply, and release all stored energy before commencing work. If the power is not turned off, accidental startup could result in injury. |
| ▲ DANGER: | This indicator signals hazards or unsafe practices that could result in severe personal injury or death, if the instructions are not followed. |

SAFETY PROCEDURES

1. Operators should read this manual prior to operating or making any adjustments on the machine.
2. Make sure machine power is turned off during the setup procedure while making adjustments to the machine. Be careful with the driving direction of the conveyor.
3. Machine should not be washed down or subjected to conditions causing moisture condensation on components and should be used in a dry, relatively clean environment at 40 to 105 degrees Fahrenheit with dry boxes.
4. To enhance safety, operators should be alert at all times while operating the machine. When packing products with toxic powders or chemicals, make sure packing area has good ventilation.
5. Remember to lockout all energy sources (i.e. power down and shut off air supply) and release stored energy prior to servicing or moving the machine to prevent injury.

CAUTION LABELS

1. This label shows the entry point of the boxes. [Fig 1-1]
2. This label shows the direction of the crank handle. [Fig 1-2]
3. This label shows that this area contains electrical components. Only authorized personnel are allowed to access these components. [Fig 1-3]
4. Warning label cautions to keep hands out of this area due to a moving part. [Fig 1-4]
5. Warning label cautions potential electrical shock. Unplug power before servicing the machine. [Fig 1-5]
6. Warning label cautions to keep hands out of this area because it contains a sharp knife. [Fig 1-6]

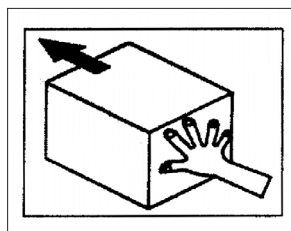


Fig 1-1

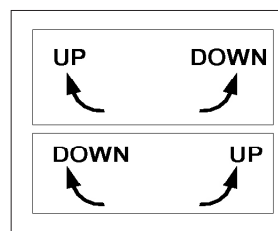


Fig 1-2

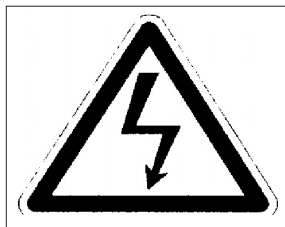


Fig 1-3



Fig 1-4



Fig 1-5



Fig 1-6

EQUIPMENT SAFETY

1. Do not alter, deface, or remove factory installed information signs that are attached to the equipment. If an information sign is damaged, replace it as soon as possible.
2. Never climb or work on equipment while it is operating nor allow anyone else.
3. Inspect all equipment components before each operation shift for damaged parts or parts suspected of sustaining damage. Repair or replace any damaged or defective components before starting or operating the equipment.
4. Before starting or operating equipment, perform a walk-around inspection of the workplace and the equipment. Make sure that no workers, tools, parts, or foreign objects are in, on, under, or around the equipment.
5. Do not operate equipment if safety gates are not in place. Check safety gates and other safety devices for proper installation and safe working condition.
6. Before starting equipment make sure that all personnel or visitors know that the equipment is going to be started.
7. When starting equipment, follow the manufacturer's recommended starting sequence.
8. Do not allow anyone to start or operate any equipment unless they have been trained in safe operating procedures.
9. Never leave equipment controls unattended. Either have a qualified operator relieve you or turn equipment off if you must leave your workstation.
10. When starting up equipment and while equipment is operating, be alert for improper readings, visual defects, abnormal odors, or unusual noises. These can be an indication of an equipment problem or warning of a possible hazard. At the onset of any of these conditions, immediately shut down the machinery following proper shutdown procedures.
11. Do NOT inspect, maintain, adjust, repair, or move the equipment until LOCKOUT procedures are implemented by trained, authorized personnel in accordance with state and federal laws. Authorized persons must shut down the power supply, shut down all energy sources, block moving parts, and release all stored energy to prevent injury.
12. Perform all equipment inspection, maintenance, lubrication, and adjustment procedures with caution and comply with manufacturer's recommended procedures.

ELECTRICAL SAFETY

1. Allow only qualified electricians or electronic technicians to work on electrical components or controls.
2. Always assume that an electrical circuit is “live” until proven otherwise by proper testing conducted by an authorized person.
3. Repair or replace frayed, cut, broken, or damaged electrical wires, cables, and connectors.
4. Check that electrical ground wires, motor plugs, and power cable connections are properly and securely connected before starting any equipment.
5. Know all locations of main electrical shut-off boxes in case of an emergency.

MACHINE DESCRIPTION & FEATURES



The BestPack® AS series are standard operator-free, carton-sealing machines designed to meet the needs of uniform in-line carton closure applications.

The units are two belt driven (two side belts driven), driven by three electric 110V UL approved motors. The AS series carton sealers are designed with a four column support structure. These units use 40-50 PSI and 4-5 CFM of air.

All systems incorporate our exclusive pop out pressure sensitive "High Speed" tape heads with patented tab adjustment.

Major Features

- In-line Carton Closure
- Adjustable Bed Height from 19.5" to 30.75"
- Reduced Cycle Time
- Rugged Construction
- Operator Free Design
- Cost Effective
- Height/Width Adjustments on either side of Machine
- Box Top Compression Unit
- Tape Roll Lengths: 1000 yd., 1500 yd., 2000 yd.
- Heavy Duty Frame
- UL Approved Electrical Parts
- Designed for Uniform Carton Applications
- Capable of Interchanging 2" or 3" Tape Heads
- Electrical on/off box can be mounted on either side of machine

Standard Features

- Exclusive Pop-out pressure sensitive "high speed" tape head with patented tab adjustment and noise reduction arm
- Exclusive Automatic Flap-Fold
- Adjustable Bed Height
- Upper Side Compression
- Operation Manual

Optional Features

- Spare Parts Kit
- High Speed Motor Upgrade (Up to 125 ft./mm.)
- Compatible Indexer: ARX model
- Interlock Safety Gates
- Stainless steel
- Locking Castors
- Infeed/Exit Conveyors w/ carton stabilizer
- Low or No Tape Sensor

Standard Features

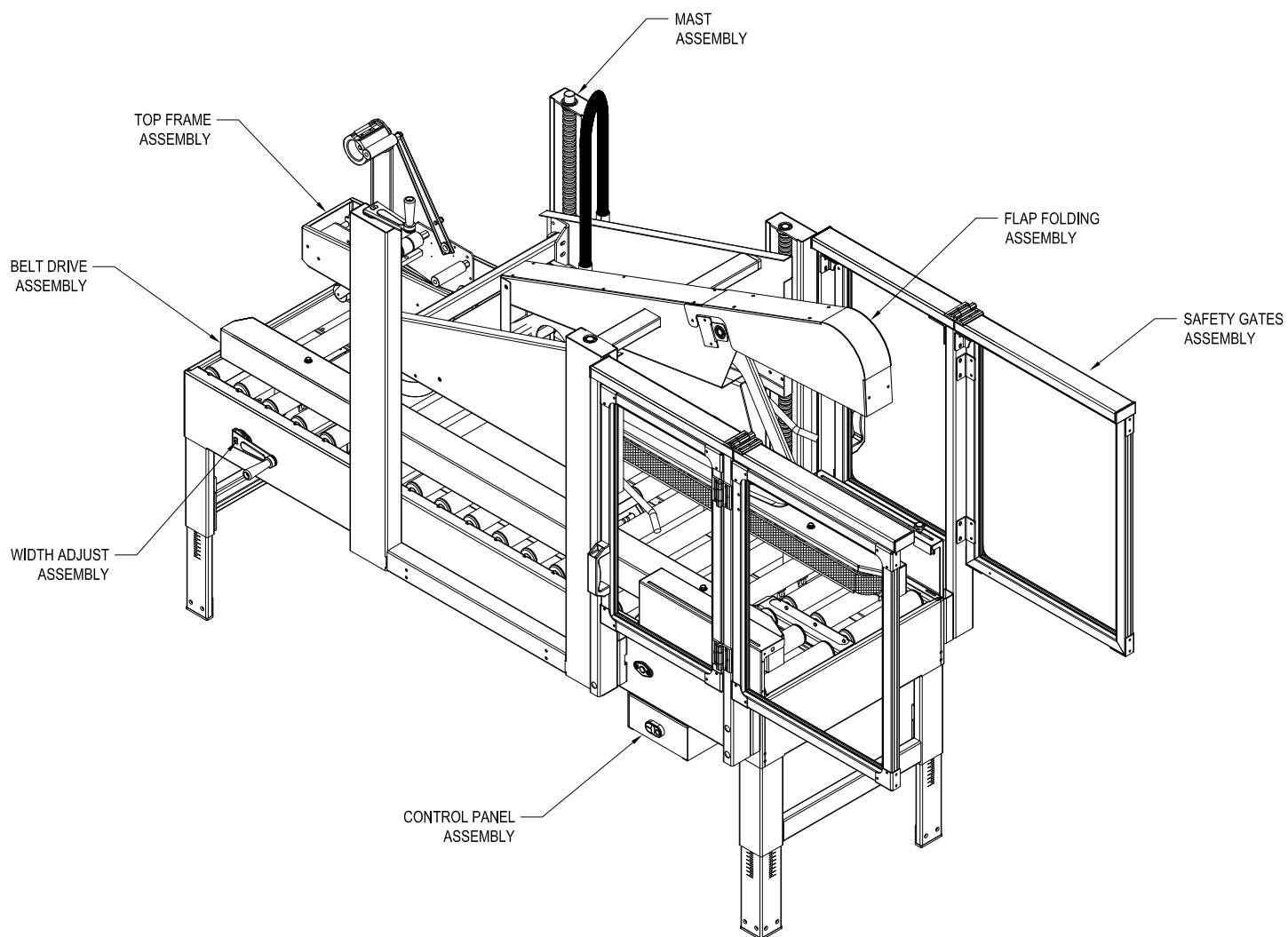
- Power Requirements: 110 Volts 60 Hz
- 45 - 60 PSI, 4 - 5 CFM
- Speed: Up to 35 cartons/minute
- Tape Head: Standard: 2", Available: 3"

Standard Features

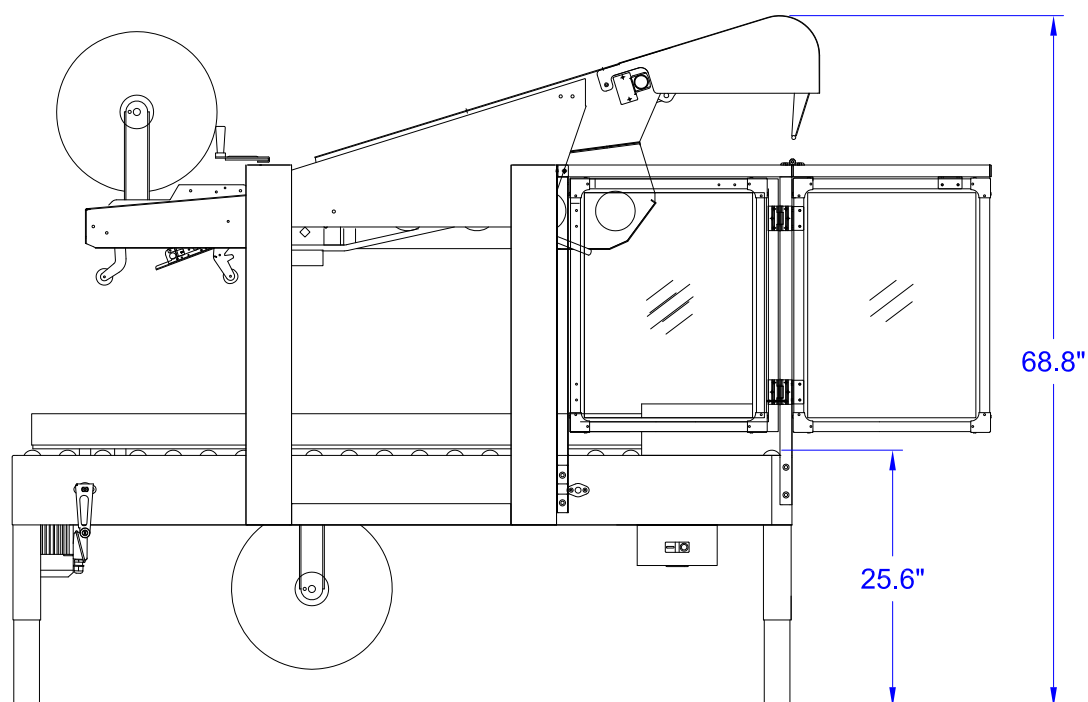
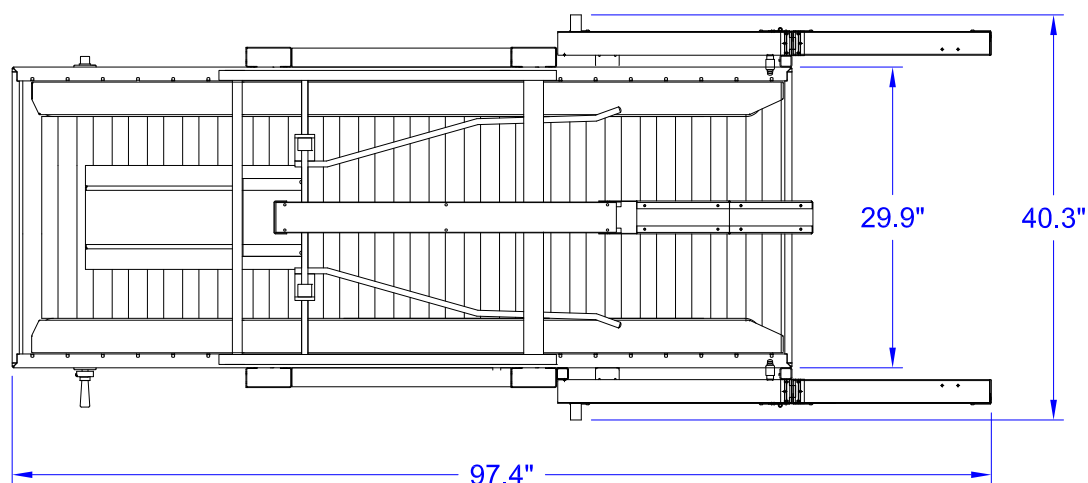
Model	Machine Dimensions	Carton Range	Cartons/Min.	Weight (lbs.)
AS 12-2 2" tape head	(70.75") x (26.5") x (68.0")	(6.0"-27.5) x (6.0"-14.6") x (4.5"-20.0")	Up to 35	500
AS 12-3 3" tape head	(70.75") x (26.5") x (68.0")	(6.0"-27.5) x (7.5"-14.6") x (4.5"-20.0")	Up to 35	500
AS 22-2 2" tape head	(78.0") x (33.8") x (73.0")	(6.0"-27.5) x (6.0"-21.0") x (4.5"-20.0")	Up to 35	585
AS 22-3 3" tape head	(78.0") x (33.8") x (73.0")	(6.0"-27.5) x (7.5"-21.0") x (4.5"-20.0")	Up to 35	585

* All specifications capable of customization or subject to change without notice

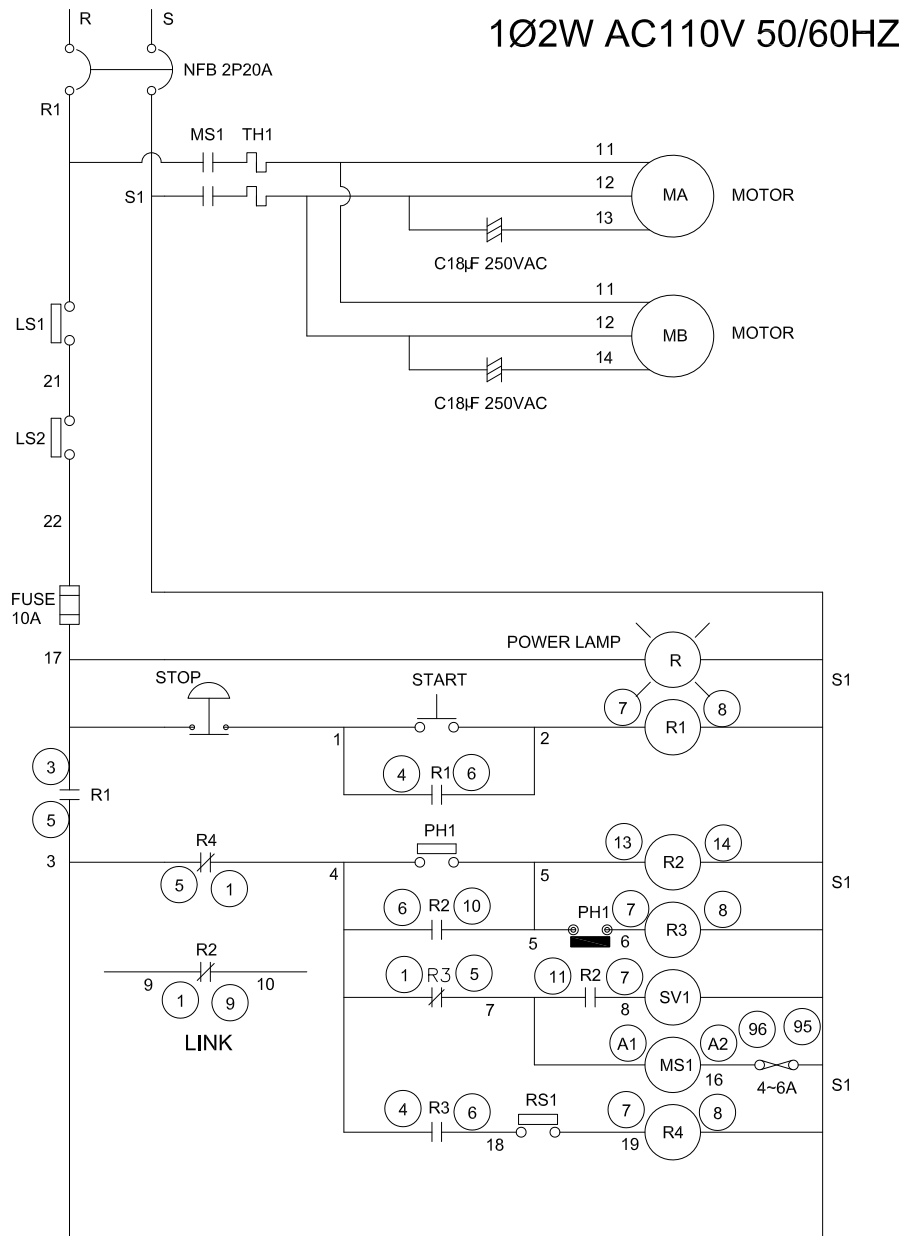
MACHINE MAJOR COMPONENTS



MACHINE DIMENSIONS



ELECTRICAL DIAGRAM



TERMINAL :

AC110V	9	10	R1	21	22	4	5	6	8	S1	18	19	11	12	13	11	12	14
CONNECTING EQUIPMENT																		
	LS1	LS2				PH1			SV1	RS1			MA					MB

INSTALLATION CHECKLIST

Power:	1PH 110vac 50/60Hz
Voltage fluctuation range:	95% - 105%
Temperature:	40 degrees to 105 degrees Fahrenheit
Relative humidity:	30% to 80% RH
Noise Level:	70 DECIBELS

MACHINE PACKING

The machine is secured on a pallet, wrapped with bubble wrap, covered with double wall corrugated box, then secured onto the pallet with two plastic straps.

UNCRATING PROCEDURES

1. Position the crate in a large, uncluttered area to unpack the machine.
2. Lift and remove the corrugated box.
3. Remove the bubble wrap.
4. Remove the shipping anchors on the four legs.
5. Lift the machine from the pallet using properly rated cord.
6. If the casters are attached, the machine can be moved manually and rolled to the proper location.

SETUP PROCEDURE

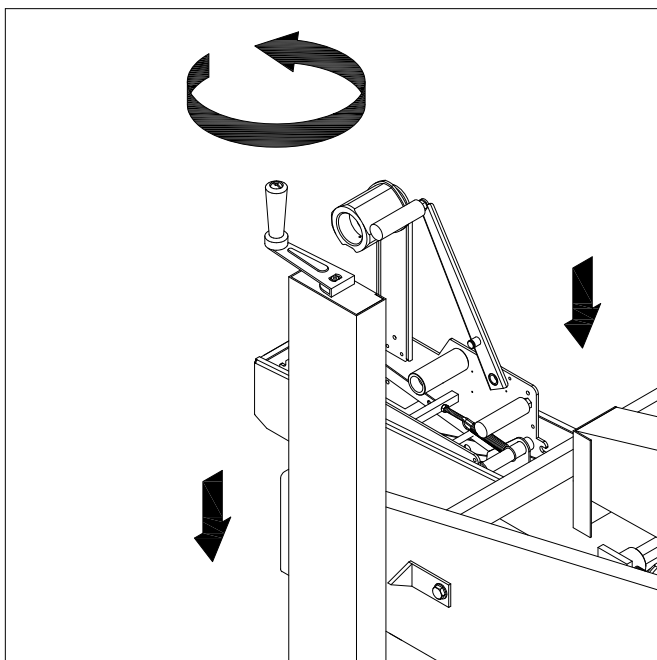
It is important that the AS series be set up and operated with the product prior to being subjected to the production environment where time for setup adjustment, and operator training is usually limited.

CAUTION: Make sure machine power is turned off.
Be careful with the driving direction of the conveyor.

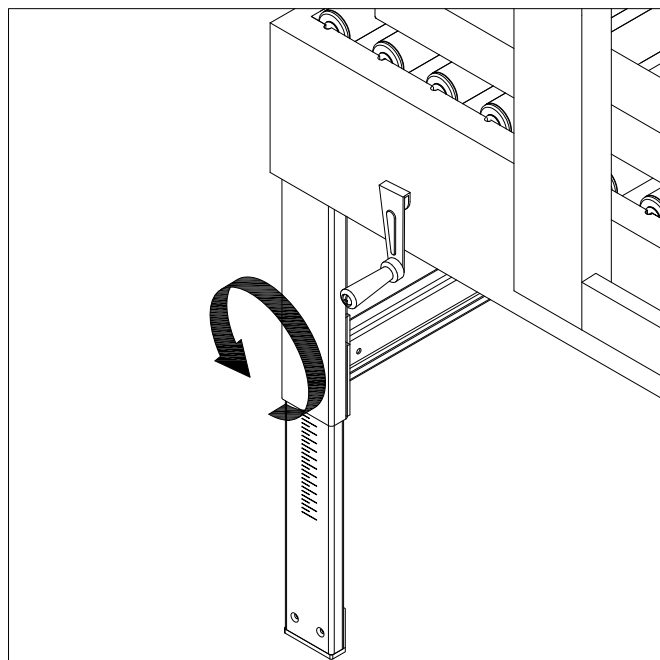
HEIGHT ADJUSTMENT: Once both tape heads are loaded with tape, the upper tape head can be positioned for the box height being sealed by means of the height adjustment crank. Turn handle clockwise to decrease height or counter-clockwise to increase height. [Fig. 2-1]

BOX SIZE SETUP: Place a closed box under the top drive frame. Lower the frame until all flaps are fully closed. Align box top flap center seam with center of the frame. [Fig. 2-1]

WIDTH ADJUSTMENT CRANK: Turn the handle clockwise for narrow and smaller packages; turn the handle counter-clockwise for wider and larger packages. [Fig. 2-2]



[Fig. 2-1]

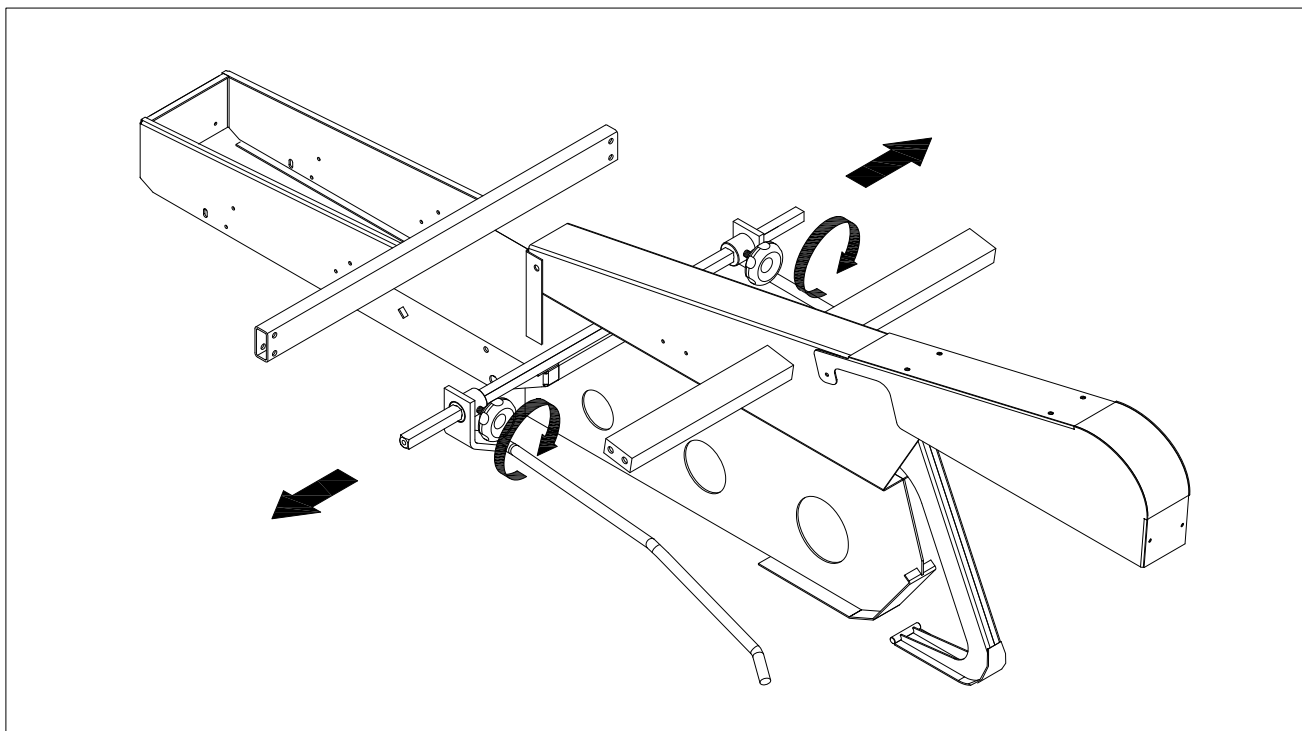


[Fig. 2-2]

COMPRESSION ROLLERS: Adjust the compression rollers against the top edge of the box and tighten the knobs to secure them in the operating position. [Fig. 2-3]

FRAME ADJUSTMENT: Turn electrical switch to the “ON” position to start the drive belts. Move the box forward under the top tape head frame until taken away by the drive belts. If the box is hard to move or is crushed, raise the frame slightly. If the box movement is erratic or stops under the frame, adjust width adjustment crank slightly to add more pressure between the box.

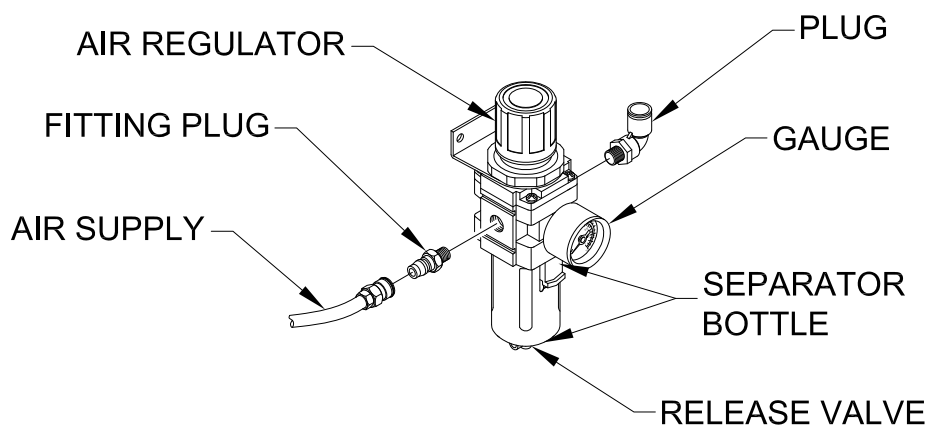
CAUTION: IF DRIVE BELTS ARE ALLOWED TO SLIP ON THE BOX, EXCESSIVE BELT WEAR WILL OCCUR.



[Fig. 2-3]

AIR INSTALLATION

1. Make sure air supply is dry. Flush all liquids out of your air lines before installation. If water from your air lines enters machine, this will deteriorate pneumatics and will void all warranty.
2. Polycarbonate bowls may be damaged and possibly fail if exposed to synthetic oils or thinner solvents. If used above atmosphere use metal bowl.
3. If water builds up in polycarbonate bowl, release the valve to drain.
4. Main regulator valve should always be in upright position.
5. Attach the main air supply source to coupler plug in main air regulator.



LUBRICATION



It is important to lubricate all moving parts on the machine to keep it in top operating condition. Lubricate the following areas with grease or oil (as indicated) every two months.

INDICATED GREASE POINTS

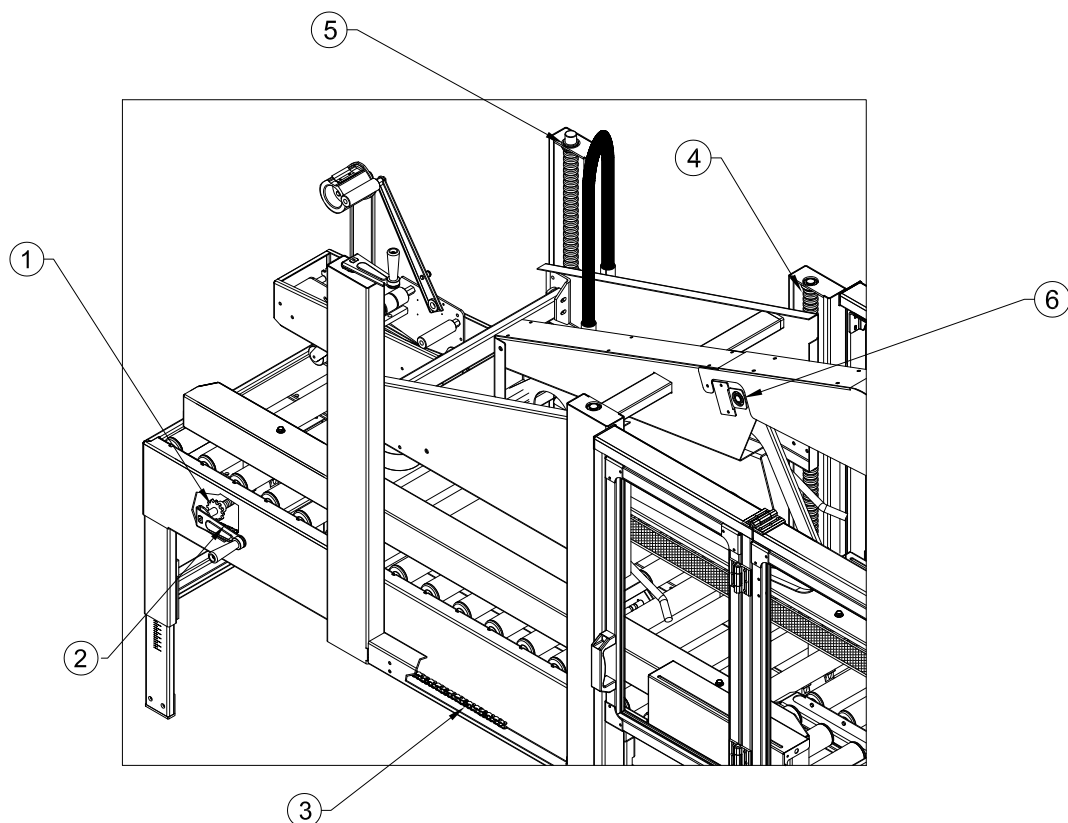


FIGURE 3-1

LUBRICATE THE FOLLOWING:

1. Chain drive mechanism for width adjustment
2. Spindle screw mechanism for width adjustment
3. Chain drive mechanism for height adjustment.
4. Spindle screw mechanism for height adjustment.
5. Bearing for spindle screw mechanism for width adjustment.
6. Bearing for flap folding arm assembly.

GREASE
GREASE
GREASE
GREASE
OIL
OIL

DAILY PREVENTATIVE MAINTENANCE

Two-Minute Maintenance (after every shift)

In order to maintain your BestPack® carton sealer in top operating condition, please take two minutes after every shift change to perform the following maintenance procedure.

1. Clean the Machine
 - a. Blow the machine down with dry air paying special attention to all moving parts.
 2. Clean the Blade
 - a. Wipe down the cutting blades with a clean rag making sure to remove any glue and plastic film that may have adhered to the blade.
 - (i) For stubborn accumulation, spray some solvent; i.e., WD-40 or Zylene, onto a rag to wipe the blade clean.

CAUTION ! Do NOT get WD-40 on the rubber rollers. Do NOT use any hard objects to scrape accumulation from the blade as it could damage the blade.

 - b. Wipe a thin layer of Vaseline onto the blade as your last cleaning step.
3. Water Reservoir (applicable if the machine uses air)
 - a. If your carton sealer uses air, check for moisture build-up in the water reservoir.
 - b. If there is water in the reservoir, bleed off any moisture that has accumulated in the water reservoir of the air regulator by pushing the button located at the bottom of the glass container on the main regulator.

IMPORTANT SAFETY REMINDER! Remember to lockout all energy sources (i.e. power down and shut off air supply) and release stored energy prior to servicing or moving the machine to prevent injury

TROUBLESHOOTING

Review SETUP PROCEDURE to ensure setup is correct. If correct, the troubleshooting chart below lists possible problems, causes, corrections, and reference guide.

** Denotes to reference your tape head manual*

PROBLEM	POSSIBLE CAUSES	CORRECTION
1. Drive belts do not convey boxes	Narrow boxes	Check machine specifications. Boxes are narrower than recommended causing slippage and premature belt wear.
	Worn drive belts	Replace drive belts
	Top flap compression rollers in too tight	Readjust compression rollers
	Top tape head does not apply enough pressure	Adjust the box height adjustment with the crank
2. Drive belts do not turn	Worn bearings, gears, or driving shaft	Replace ball bearing, gears, or driving shaft
	Drive belt tension too loose	Adjust belt tension screw
	Electrical disconnect	Check power and electrical plug
	Motor not running	Check the fuse, capacitor, and setting of thermal relay
3. Drive belts break	Worn belt	Replace belt
4. Light boxes tip back on exit	Top drive frame down too far	Carefully adjust top drive frame
5. Squeaking noise as boxes pass through machine	Dry belt plastic pulleys	Lubricate belt pulleys
	Driving idler rollers	Lubricate aluminum pulleys and replace, if defective

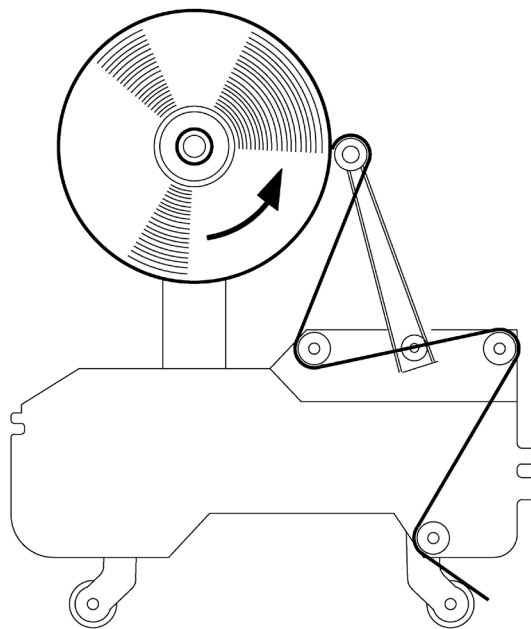
TROUBLESHOOTING (cont'd)

PROBLEM	POSSIBLE CAUSE	CORRECTION
6. Tape not centered on box	Tape drum not centered	Reposition tape drum *
	Top compression rollers not aligned with the tape head	Align the left and right compression roller to the tape head *
	Box flaps not of equal length	Check box specifications and adjust accordingly
7. Blade does not cut tape, or tape end is jagged or shredded	Blade is dull and/or has broken teeth	Replace blade *
	Tape tension is insufficient	Increase tape tension by adjusting the mandrel wheel *
	Adhesive has build-up on blade	Clean and adjust the blade *
	Blade not positioned properly	Check that the blade is bottomed out against the mounting bolts *
	Blade is dirty	Clean blade and lubricate the oiler pad on the blade guard *
	Blade in backwards	Mount the blade so that the beveled edge is away from the entrance end of the head *
	Blade spring guard	Replace the defective spring *

TROUBLESHOOTING (cont'd)

PROBLEM	CAUSE	CORRECTION
8. Tape is leaving a fold	There is excess tension on the tape mandrel assembly	Adjust the mandrel knurled wheel *
	Rollers in the tape path do not rotate freely	Clean adhesive deposits from the surface, ends, and shafts. Then lubricate roller shafts. Remove all lubricants from roller surfaces
	Blade not cutting tape properly	Refer to tape cutting problems; surface, ends, shafts, and the rollers *
	Tape threaded incorrectly	Re-thread the tape *

CORRECT TAPE THREADING PATH



PARTS REPLACEMENT & ORDERING

Replacement parts and prices are available from your local BestPack® distributor. Please contact your local BestPack® distributor for part availability.

A listing of our BestPack® representatives are located on our website at: <http://www.bestpack.com>

If you are unable to contact a local distributor near you, contact our BestPack® US office at the following location:

FUTURE COMMODITIES INT'L

BestPack® Packaging Systems

1425 S. Campus Ave

Ontario, CA 91761

TEL: (909) 987-4258

FAX: (909) 987-5189

RECOMMENDED SPARE PARTS

It is recommended that the following items be ordered and kept on hand:

AS recommended spare parts list

QTY	PART NUMBER	DESCRIPTION
2	27280031	BEARING, BALL 6003ZZ
2	27280091	BEARING, BALL 6202ZZ
2	2710033	BELT, 3700mm X 2" BLACK
2	L070S	RUBBER, COUPLER SPACER M35X12
2	A1122000	COUPLER, DRIVE SBLT

Black Tape Head recommended spare parts list

QUANTITY	2" PART #	DESCRIPTION	3" PART #
2	10117	BUMPER, RUBBER	
1	10122	CUTTER BLADE	10122-0
1	10315	CUSHION, BLADE	10315-0
1	AC232000	RUBBER ROLLER REAR	AC332000
1	AC231300	RUBBER ROLLER FRONT	AC331300
1	9510303	SPRING, FRONT ROLLER	
1	10096-1	MAIN SPRING (For Top Tapehead)	
1	10096-2	MAIN SPRING (For Bottom Tapehead)	
1	10507	WASHER, CLUTCH PLATE M40X2.5	
1	AC241000C	ROLLER, 1-WAY BRASS	AC341000C

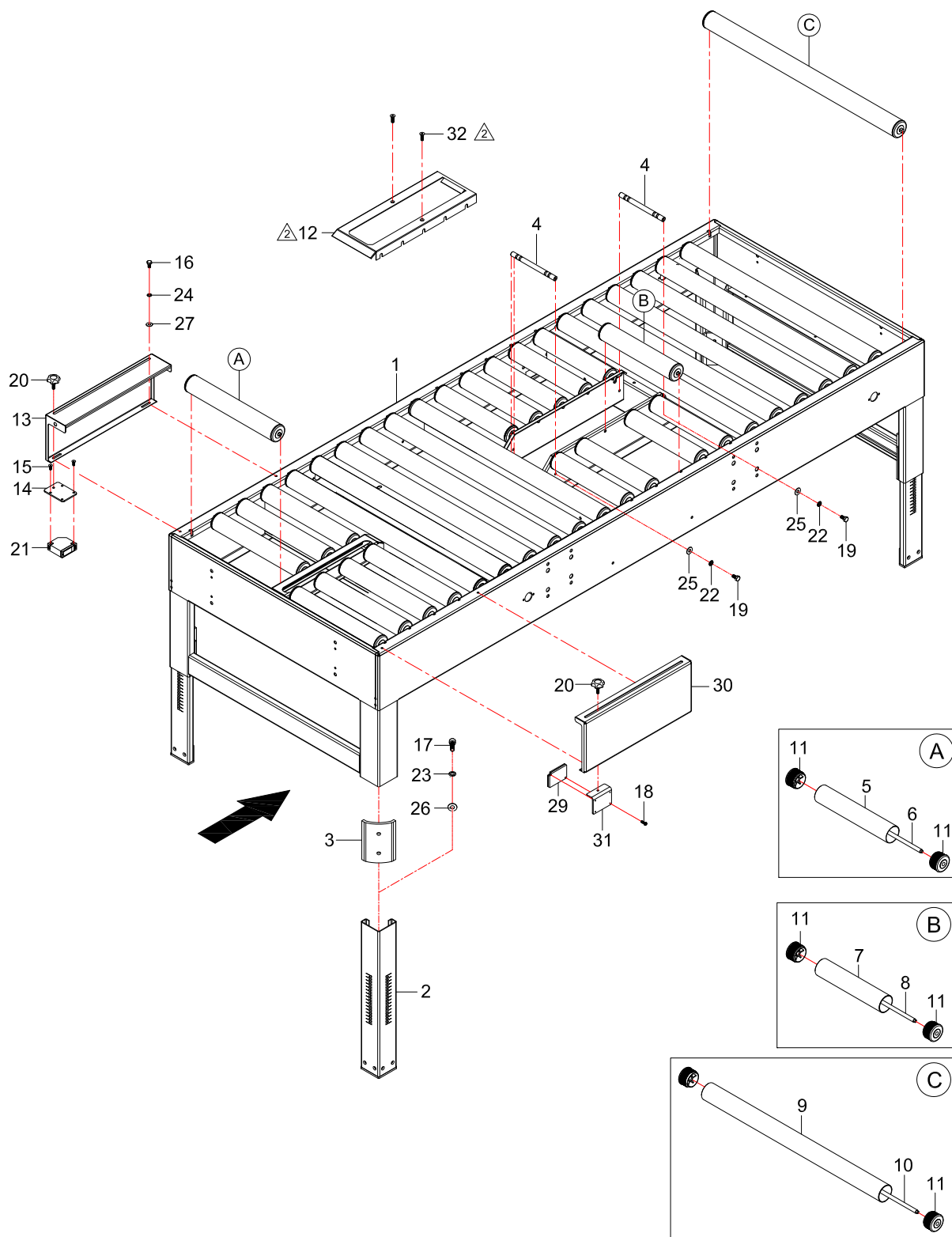
Note: Part Numbers, Descriptions, and Pricing are all subject to change without prior notification. Call for pricing.

TOOL KIT



A tool kit is provided with the purchase of a BestPack® machine. The tool kit contains the following items: the necessary open-ended wrenches 7mm, 8mm, 10mm, 12mm, and 14mm; set of Allen head wrenches; set of tape head and settle shaft springs; flat screwdriver and Phillips screwdriver; spanner (threading tool); oil applicator; and paintbrush.

The tool kit (Part # AC01A200 referenced above) is available as a stock item.

ROLLER BED ASSEMBLY



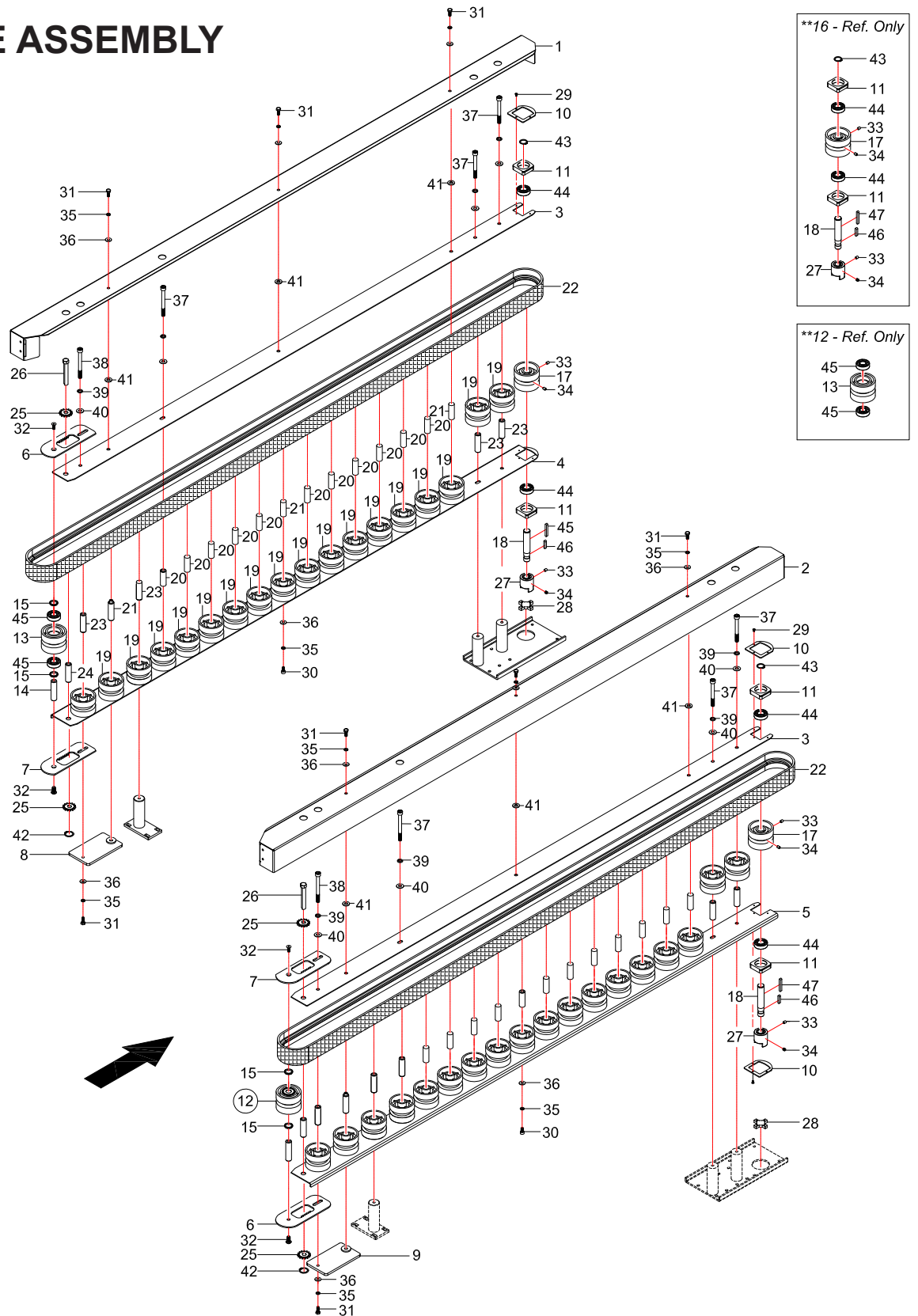
ROLLER BED PARTS LIST

KEY NO.	PART NO.	QTY	DESCRIPTION
1	10C040A1	1	FRAME, ROLLER BED AS22
2	C4104000	4	LEG, 18" EXTENSION M65X455
3	12554	4	BRACKET, EXTENSION M85X68X6
4	20008	2	SHAFT, T/HEAD M12X155 (BOLTED)
5	12453-2	8	ROLLER, ALUM M48X305
6	12452-13	8	SHAFT, ROLLER M9.5X330 RND/SLT
7	12453-1	10	ROLLER, ALUM M48X250
8	12452-4	10	SHAFT, ROLLER M9.5X275 SLTD
9	12453-10	13	ROLLER, ALUM M48X675
10	12534	13	SHAFT, ROLLER M9.5X700 RND/SL
11	C4129020	62	BUSHING, ROLLER CAP M45X30
 12	E3154006	1	PLATE, FRONT BOTTOM TAPE HEAD (2" CONFIG.)
13	K6146001	1	BRACKET, PHOTO EYE SENSOR
14	K6147000	1	PLATE, SENSOR MOUNT
15	2702009	2	SCREW, FLAT HD PHILIP M4X12
16	2700032	2	SCREW, HEX HD M5X12
17	2701023	8	SCREW, SOCKET HD M8X20
18	2703206	2	SCREW, OVAL HD PHILIP M4X12
19	2700002	4	SCREW, HEX HD M6X12
20	P0006161	2	SCREW, KNOB M6X20
21	2850013	1	SENSOR, PHOTO E3JK-5M2
22	2705202	8	WASHER, SPLIT LOCK M6
23	2705203	8	WASHER, SPLIT LOCK M8
24	2705201	4	WASHER, SPLIT LOCK M5
25	2705102	8	WASHER, FLAT M6
26	2705101	8	WASHER, FLAT M8
27	2705103	4	WASHER, FLAT M5
*28	N/A	-	
29	2850014	2	REFLECTOR, PHOTO EYE E39-R1
30	K6148000	1	BRACKET, SENSOR MOUNT M522X236
31	K6149000	1	PLATE, MOUNT REFLECTOR M65X77
 32	2702021	2	SCREW, FLAT PHILIP M5 x 16

* Item Removed

 - Used on X" Config. Only

BELT DRIVE ASSEMBLY



BELT DRIVE PARTS LIST

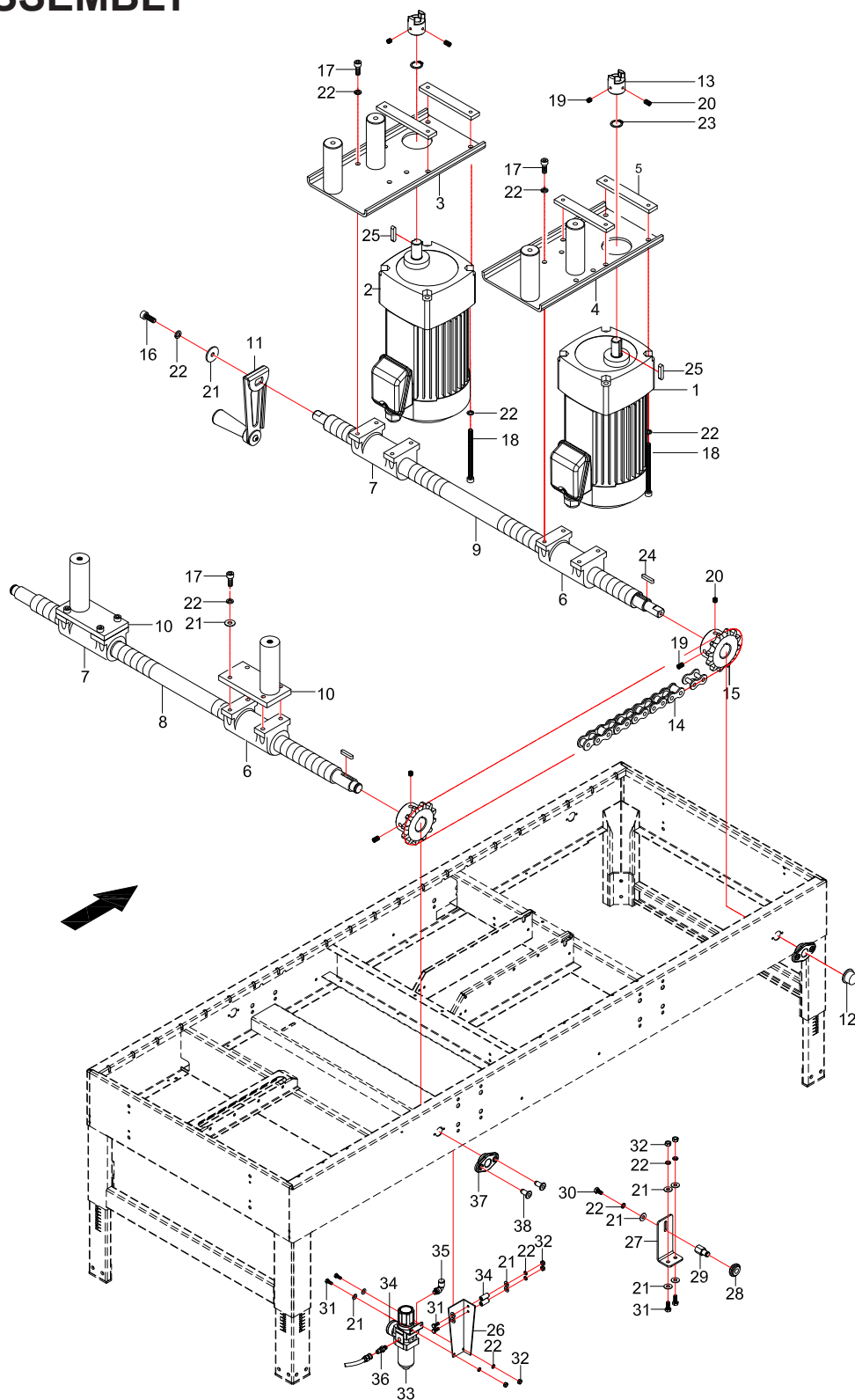
KEY NO.	PART NO.	QTY	DESCRIPTION
1	K2225A00	1	COVER, BELT LT 2041L
2	K2226A00	1	COVER, BELT RT 2041L
3	K2203002	2	PLATE, FIXED TOP 1730L
4	K2201002	1	PLATE, FIXED BOTTOM LT 1730L
5	K2202002	1	PLATE, FIXED BOTTOM RT 1730L
6	C4215000	2	PLATE, BELT TENSION (TOP)
7	C4214000	2	PLATE, BELT TENSION (BOTTOM)
8	L1209000	1	PLATE, SUPPORT LT BELT BRACKET
9	L1210000	1	PLATE, SUPPORT RT BELT BRACKET
10	C4235000	4	PLATE, SUPPORT MOUNT M62X58
11	K2224000	4	BRACKET, BEARING HOUSING 6003Z
**12	14082A	-	PULLEY, ALUM FOLLOWER ASSEMBLY
13	14082	2	PULLEY, ALUM FOLLOWER M65.5X50
14	K2236000	2	SHAFT, FOLLOWER PULLEY M15X60
15	K2237000	4	SPACER, FOLLOWER M21.7X15X5
**16	K2211A00	-	PULLEY, ALUM DRIVER ASSEMBLY W/ COUPLING
17	C4211000	2	PULLEY, ALUM DRIVER SBLT M65.5
18	K2213000	2	SHAFT, SIDE DRIVE SBT M17X97
19	14006	36	PULLEY, NYLON M65.5X48
20	14005	2	SHAFT, PLASTIC WHEEL M15X47
21	C4218000	6	SHAFT, IDLE ROLLER M15X60
22	2710033	2	BELT, 3700mmX2"
23	14021	8	BUSHING, METAL M15X54
24	C4222000	2	BUSHING, METAL M17.3X54
25	C4221000	4	SPROCKET, 15T BELT ADJ M2X15T
26	K2219000	2	SHAFT, BELT TENSION ADJ M12X77
27	A1122000	2	COUPLER, DRIVE SBLT M35X39
28	L070S	2	RUBBER, COUPLER SPACER M35X12
29	2702214	12	SCREW, FLAT HD M3X6
30	2701027	24	SCREW, SOCKET HD M6X12

** Sub-Assembly - Listed for reference only

BELT DRIVE PARTS LIST (cont'd)

KEY NO.	PART NO.	QTY	DESCRIPTION
31	2700002	6	SCREW, HEX HD M6X12
32	2702031	6	SCREW, FLAT HD M6X16
33	2704001	4	SCREW, SOCKET SET M6X6
34	2704002	4	SCREW, SOCKET SET M6X10
35	2705202	30	WASHER, SPLIT LOCK M6
36	2705102	30	WASHER, FLAT M6
37	2701018	6	SCREW, SOCKET HD M8X75
38	2701008	2	SCREW, SOCKET HD M8X80
39	2705203	8	WASHER, SPLIT LOCK M8
40	2705101	8	WASHER, FLAT M8
41	2705109	4	WASHER, FLAT M8X25X3t
42	2706002	2	RING, RETAINING M12
43	2706006	2	RING, RETAINING M17
44	27280031	4	BEARING, BALL 6003ZZ
45	27280094	4	BEARING, BALL 6202ZZ
46	2709001	2	KEY, M5X5X25
47	2709002	2	KEY, M5X5X40

WIDTH DRIVE ASSEMBLY



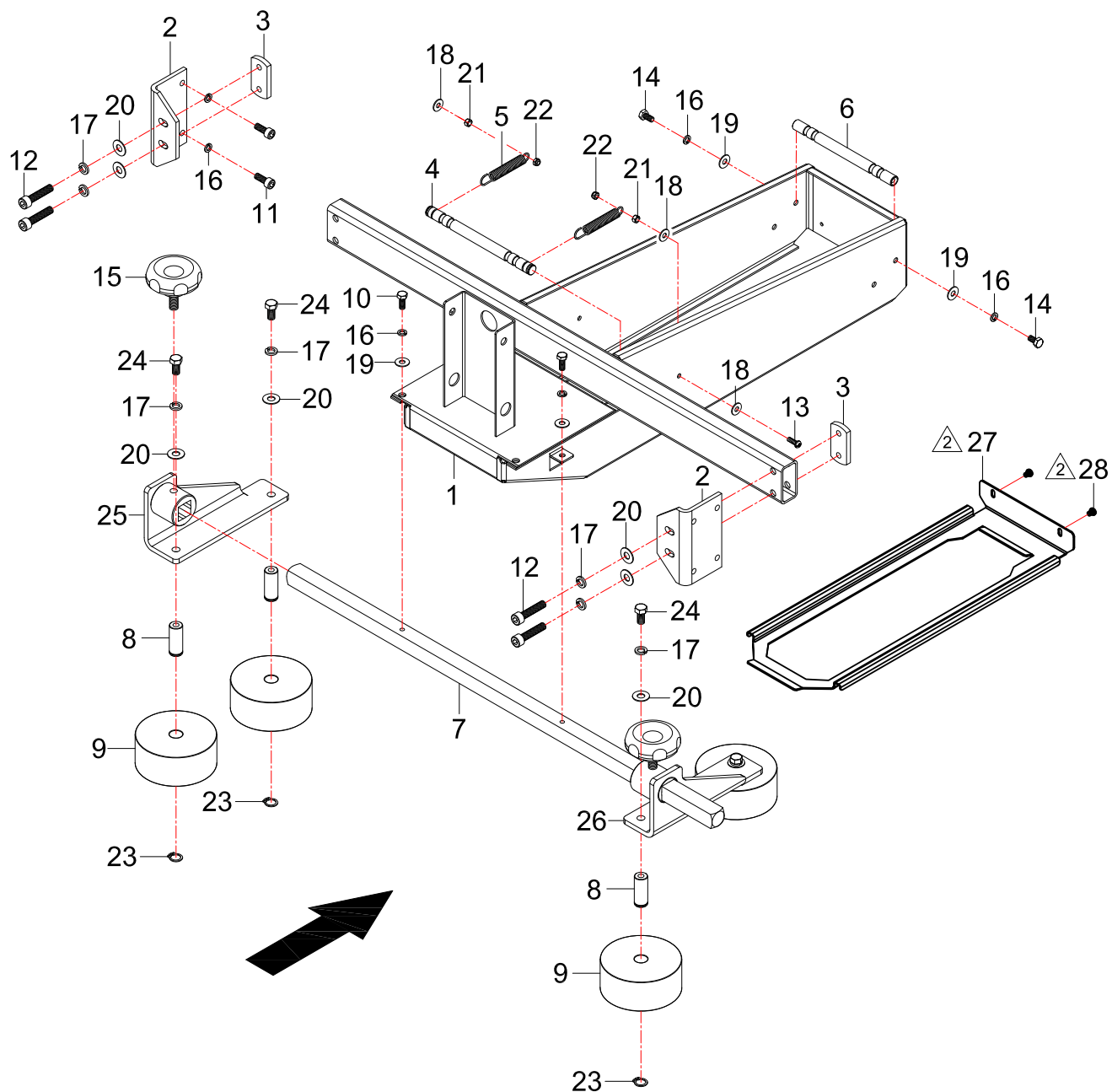
WIDTH DRIVE PARTS LIST

KEY NO.	PART NO.	QTY	DESCRIPTION
1	28110M17L	1	MOTOR, TH 110V 17:1 1/5HP LT
	(28110M10L)	1	MOTOR, TH 110V 10:1 1/5HP LT (HIGH SPEED CONFIG.)
2	28110M17R	1	MOTOR, TH 110V 17:1 1/5HP RT
	(28110M10R)	1	MOTOR, TH 110V 10:1 1/5HP RT (HIGH SPEED CONFIG.)
3	C4119000	1	PLATE, SBLT REAR MOUNT LH
4	C4120000	1	PLATE, SBLT REAR MOUNT RH
5	C8447000	4	PLATE, BRACKET MOUNT 112X16X6
6	C4111000	2	BLOCK, SLIDING TW1-6ACME (LH)
7	18006	2	BLOCK, SLIDING TW1-6ACME (RH)
8	A1109000	1	SHAFT, ADJ SCREW M25.2X772
9	A1110000	1	SHAFT, ADJ SCREW M25.2X804
10	A1118000	2	BLOCK, FRONT MOUNT M20 (L)
11	A1115000	1	HANDLE, STEEL ARM ASSEMBLY
12	C4133000	1	CAP, SCREW SHAFT
13	A1122000	2	COUPLER, DRIVE SBLT M35X39
14	K2106001	1	CHAIN, #35X258 W/ LINK
15	C4113000	2	SPROCKET, RS32X15TB
16	2701020	1	SCREW, SOCKET HD M6X16
17	2701021	16	SCREW, SOCKET HD M6X20
18	2701028	8	SCREW, SOCKET HD M6X80
19	2704002	4	SCREW, SOCKET SET M6X10
20	2704001	4	SCREW, SOCKET SET M6X6
21	2705102	10	WASHER, FLAT M6
22	2705202	25	WASHER, SPLIT LOCK M6
23	2706005	2	RING, RETAINING M16
24	2709008	2	KEY, M5X5X20
25	2709001	2	KEY, M5X5X25
26	12079	1	BRACKET, AIR REGULATOR MOUNT
27	K2147000	1	PLATE, ADJ WHEEL MOUNT
28	53337	1	ROLLER, CHAIN ADJUSTER M26X10
29	18029	1	SPACER, STANDOFF HEX H14X29.5
30	2700002	1	SCREW, HEX HD M6X12



WIDTH DRIVE PARTS LIST


KEY NO.	PART NO.	QTY	DESCRIPTION
31	2700020	1	SCREW, HEX HD M6X16
32	2707020	6	NUT, HEX M6
33	29101022	1	REGULATOR, AIR AW30-02B (MAIN)
34	2910550	1	GAUGE, PRESSURE 1/8"QPG40-11
35	29093211	1	FITTING, JPL 802
36	NT00167	1	FITTING, MALE QUICK 1/4"
37	C4101140	4	BUSHING, FLANGE NYLON
38	2883101	8	RIVET, BLIND M4X10 6-3

TOP FRAME ASSEMBLY

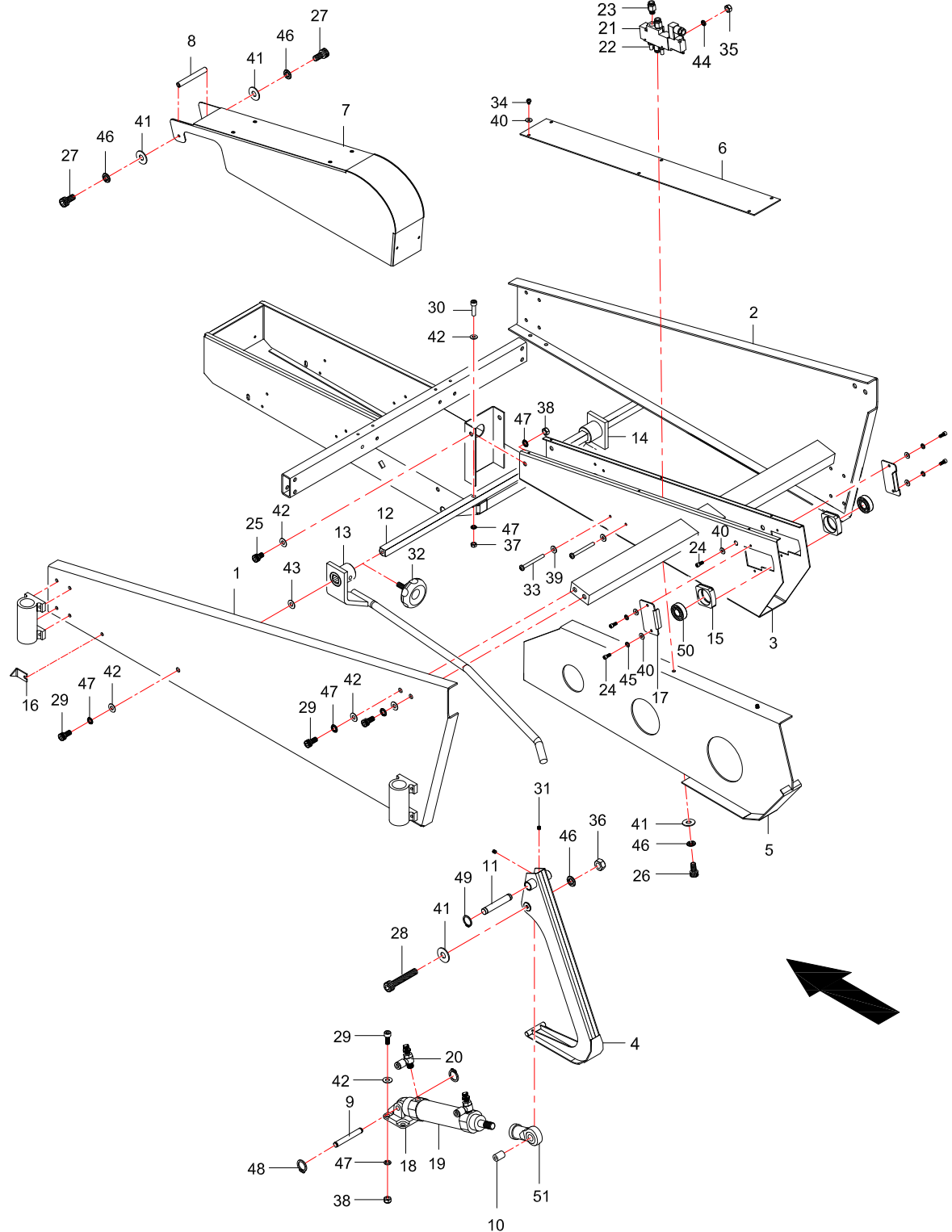


TOP FRAME PARTS LIST

KEY NO.	PART NO.	QTY	DESCRIPTION
1	K2401002	1	FRAME, TOP TAPEHEAD AS22
2	20058	2	PLATE, ANGLE MOUNT M102X100
3	18267	2	PLATE, MOUNT M25X50X6
4	20035	1	SHAFT, T/HEAD M12X163 (SPRING)
5	10115	2	SPRING, CUTTER BLADE ARM
6	20008	1	SHAFT, T/HEAD M12X155 (BOLTED)
7	L2417000	1	SHAFT, SQUARE COMP ROLLER 670L
8	20437	4	SHAFT, COMPRN ROLLER M15X38
9	20024-1	4	WHEEL, TOP COMPR'N GRAY
10	2700020	2	SCREW, HEX HD M6X16
11	2701021	8	SCREW, SOCKET HD M6X20
12	2701057	4	SCREW, SOCKET HD M8X40
13	2703202	2	SCREW, PAN HD PHILIP M5X15
14	2700002	2	SCREW, HEX HD M6X12
15	2702101	2	KNOB, LOCKING 3/8-13UNC
16	2705202	10	WASHER, SPLIT LOCK M6
17	2705203	4	WASHER, SPLIT LOCK M8
18	2705103	4	WASHER, FLAT M5
19	2705102	2	WASHER, FLAT M6
20	2705101	4	WASHER, FLAT M8
21	2707023	2	NUT, HEX M5
22	2707101	2	NUT, HEX JAM NYLOCK M5
23	2706004	4	RING, RETAINING M15
24	2700028	4	SCREW, HEX HD M8X16
25	L2409000	1	MOUNT, COMPRESSION LT
26	L2410000	1	MOUNT, COMPRESSION RT
 27	K2402000S	1	PLATE, SKID TOP M456X181X1.6 2" (2" CONFIG.)
 28	2701357	2	SCREW, OVAL HD M5X8 (2" CONFIG.)

 - Used on X" Config. Only

FLAP FOLDING ASSEMBLY



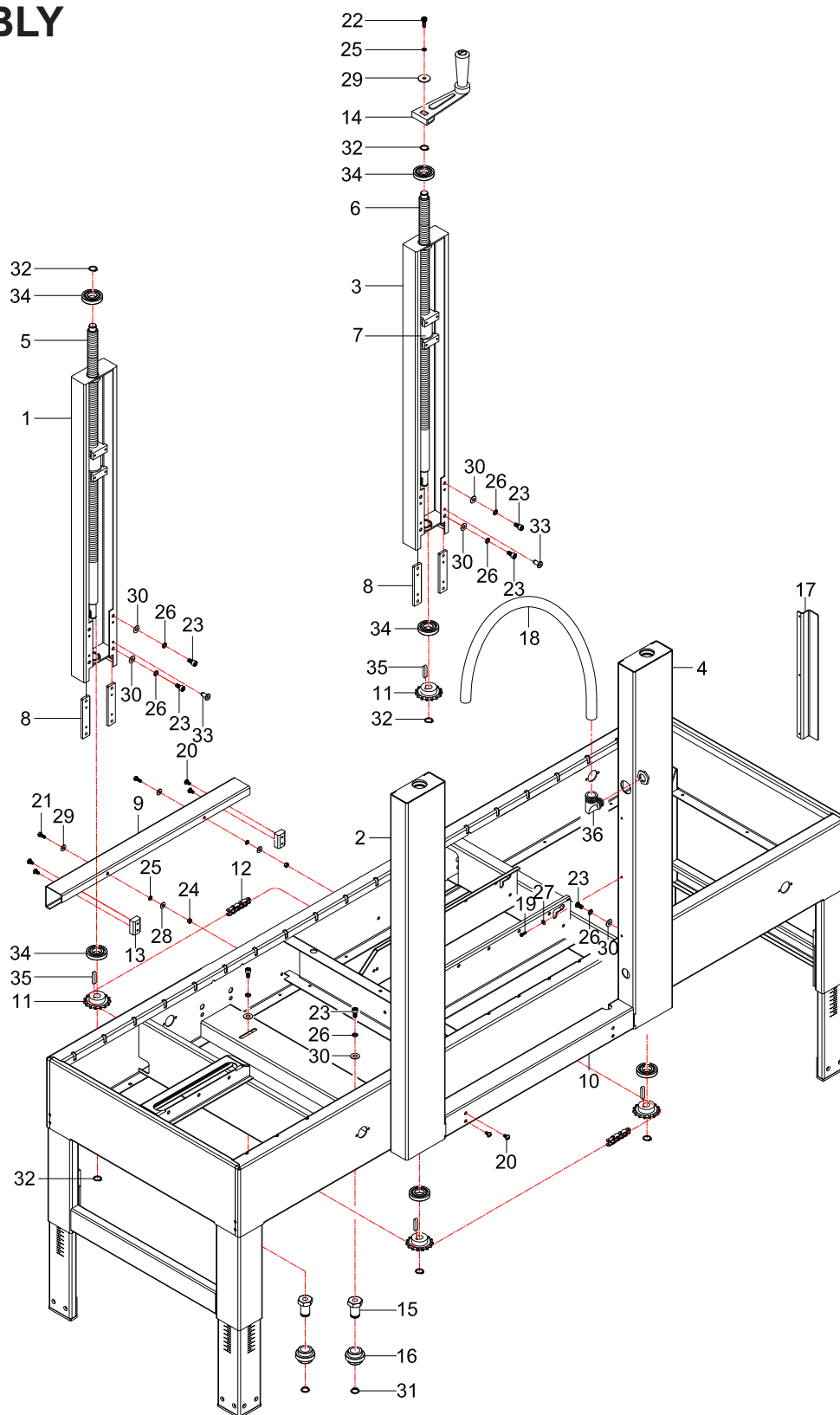
FLAP FOLDING PARTS LIST

KEY NO.	PART NO.	QTY	DESCRIPTION
1	K2509000	1	BOARD, PROTECTOR (LH)
2	K2510000	1	BOARD, PROTECTOR (RH)
3	K2501001	1	FRAME, MINOR FLAP FOLDER
4	K6503000	1	KICKER, ARM FLAP FOLDER
5	K2508000	1	PLATE, MINOR FLAP FOLDER
6	K2502000	1	COVER, MINOR FLAP FRAME M802X7
7	K2507000	1	COVER, KICKER
8	54437	1	SHAFT, KICKER COVER M10X79
9	K6505000	1	SHAFT, CYLINDER MOUNT M10X36
10	20402	1	SHAFT, BUSHING M14X20
11	N1504001	1	SHAFT, KICKER M15X84
12	54436-5	1	SHAFT, COMP'N ROLLER M744X5/8
13	K2517000	1	GUIDE, FLAP FOLD- LH
14	K2518000		GUIDE, FLAP FOLD- RH
15	A1224000	2	BRACKET, BEARING 42X42Xt11
16	18012	1	INDICATOR, HEIGHT
17	N1508000	2	COVER, PLATE BEARING
18	N1505000	1	BASE, CYLINDER MOUNT
19	2920051	1	CYLINDER, AIR CDM2C40-85A
20	2908015	2	VALVE, SPEED CONTROL JSC 602
21	2911903	1	VALVE, SOLENOID VQZ3121-3Y-02
22	2916001	2	SILENCER, SOLENOID PT 1/8
23	2909332	3	FITTING, STRAIGHT 1/4X6
24	2701034	4	SCREW, SOCKET HD M5X16
25	2701035	2	SCREW, SOCKET HD M5X20
26	2701027	3	SCREW, SOCKET HD M6X12
27	2701020	2	SCREW, SOCKET HD M6X16
28	2701045	1	SCREW, SOCKET HD M6X40
29	2701030	10	SCREW, SOCKET HD M8X16
30	2701043	2	SCREW, SOCKET HD M8X30

FLAP FOLDING PARTS LIST (cont'd)

KEY NO.	PART NO.	QTY	DESCRIPTION
31	2704001	2	SCREW, SOCKET SET M6X6
32	2702101	2	KNOB, LOCKING 3/8-13UNC
33	2703227	2	SCREW, OVAL HD M3X30
34	2703207	6	SCREW, OVAL HD PHILIP M5X6
35	2707045	2	NUT, HEX M3
36	2707020	1	NUT, HEX M6
37	2707022	2	NUT, HEX M8
38	2707103	6	NUT, HEX NYLOCK M8
39	2705125	2	WASHER, FLAT M3
40	2705103	12	WASHER, FLAT M5
41	2705102	6	WASHER, FLAT M6
42	2705101	14	WASHER, FLAT M8
43	2705109	2	WASHER, FLAT M8X25X3t
44	2705212	2	WASHER, SPLIT LOCK M3
45	2705201	4	WASHER, SPLIT LOCK M5
46	2705202	6	WASHER, SPLIT LOCK M6
47	2705203	15	WASHER, SPLIT LOCK M8
48	2706001	2	RING, RETAINING M10
49	2706004	2	RING, RETAINING M15
50	27280091	2	BEARING, BALL 6202ZZ
51	2728413	1	ROD END, PHS 14X1.5

MAST ASSEMBLY



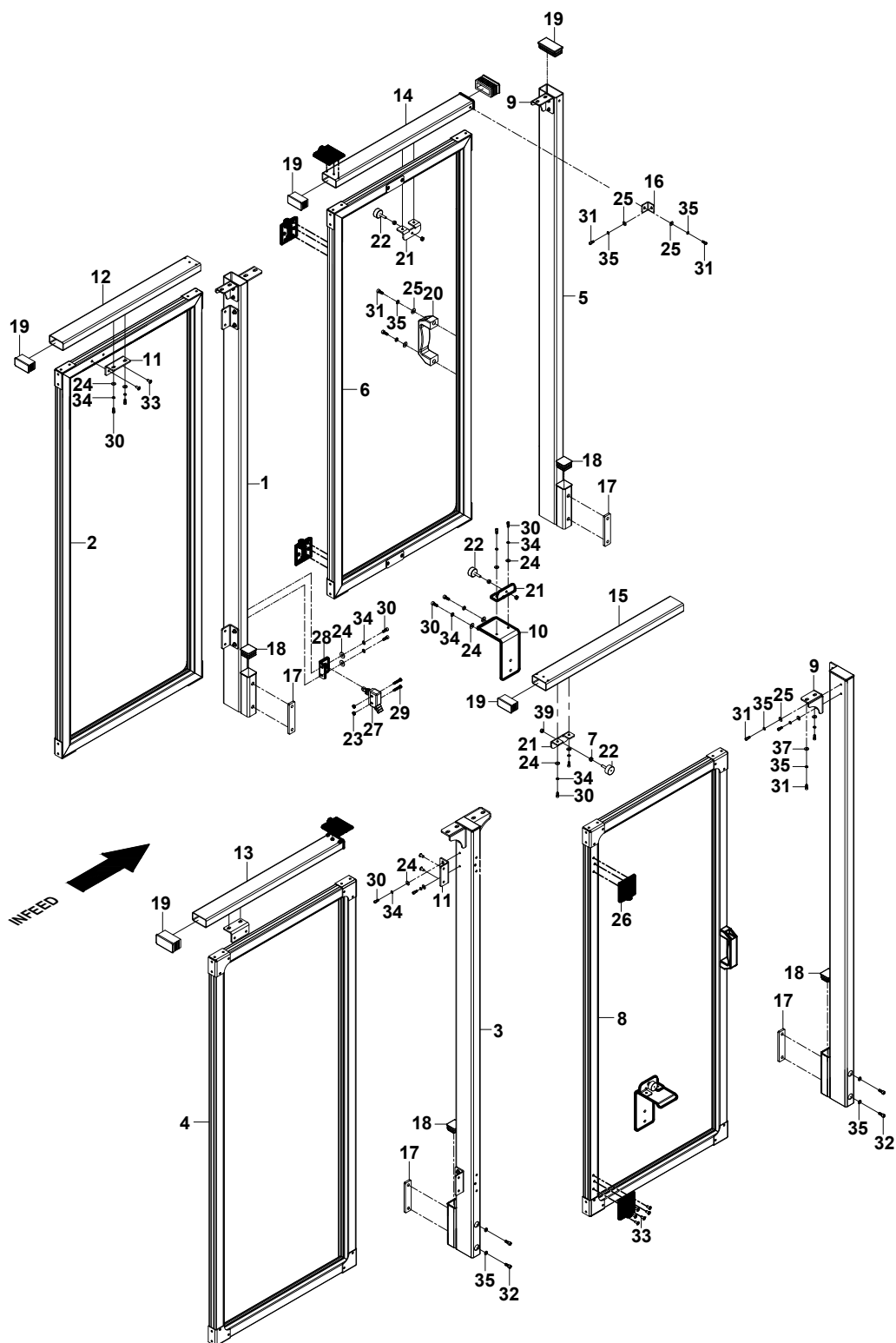
MAST PARTS LIST

KEY NO.	PART NO.	QTY	DESCRIPTION
1	K6301000	1	CASING, COLUMN SHAFT-LH
2	K6302000	1	CASING, COLUMN SHAFT-RH
3	K6303000	1	CASING, COLUMN SHAFT-REAR LH
4	K6304000	1	CASING, COLUMN SHAFT REAR RH
5	54307-1	2	SHAFT, ADJ SCREW M25.4X891
6	54306-1	2	SHAFT, ADJ SCREW M25.4X910
7	18006	4	BLOCK, SLIDING TW1-6ACME (RH)
8	A1167001	8	PLATE, MAST MOUNT M120X19X6
9	K6161000	1	COVER, SIDE CHAIN 554L (L)
10	K6162000	1	COVER, SIDE CHAIN 554L (R)
11	18151	4	SPROCKET, 1/2"X10TX17 SS41
12	K6217000	1	CHAIN, RS40X30
13	K6163000	4	PAD, CHAIN SUPPORT
14	A1115000	1	HANDLE, STEEL ARM ASSEMBLY
15	12355	2	SHAFT, STANDOFF 12.7X74
16	12356	2	ROLLER, CHAIN ADJ M24X16
17	53428-1	1	COVER, WIRING 320L
18	2860090	1	TUBE, COVER WIRE
19	2703203	3	SCREW, OVAL HD PHILIP M4X8
20	2701351	8	SCREW, OVAL PHILIP M6X12
21	2700020	4	SCREW, HEX HD M6X16
22	2701020	1	SCREW, SOCKET HD M6X16
23	2701030	18	SCREW, SOCKET HD M8X16
24	2707020	4	NUT, HEX M6
25	2705202	5	WASHER, SPLIT LOCK M6
26	2705203	18	WASHER, SPLIT LOCK M8
27	2705105	3	WASHER, FLAT M4
28	2705102	8	WASHER, FLAT M6
29	2705199	1	WASHER, FLAT FENDER M6.5X25X2
30	2705101	18	WASHER, FLAT M8

MAST PARTS LIST (cont'd)

KEY NO.	PART NO.	QTY	DESCRIPTION
31	2706002	2	RING, RETAINING M12
32	2706006	8	RING, RETAINING M17
33	2740000	16	RIVETS, 3/16" X1/4
34	27280141	8	BEARING, BALL 6903Z
35	2709001	4	KEY, M5X5X25
36	2860095	1	CONNECTOR, ELECTL CORD

SAFETY GATES ASSEMBLY



SAFETY GATES PARTS LIST

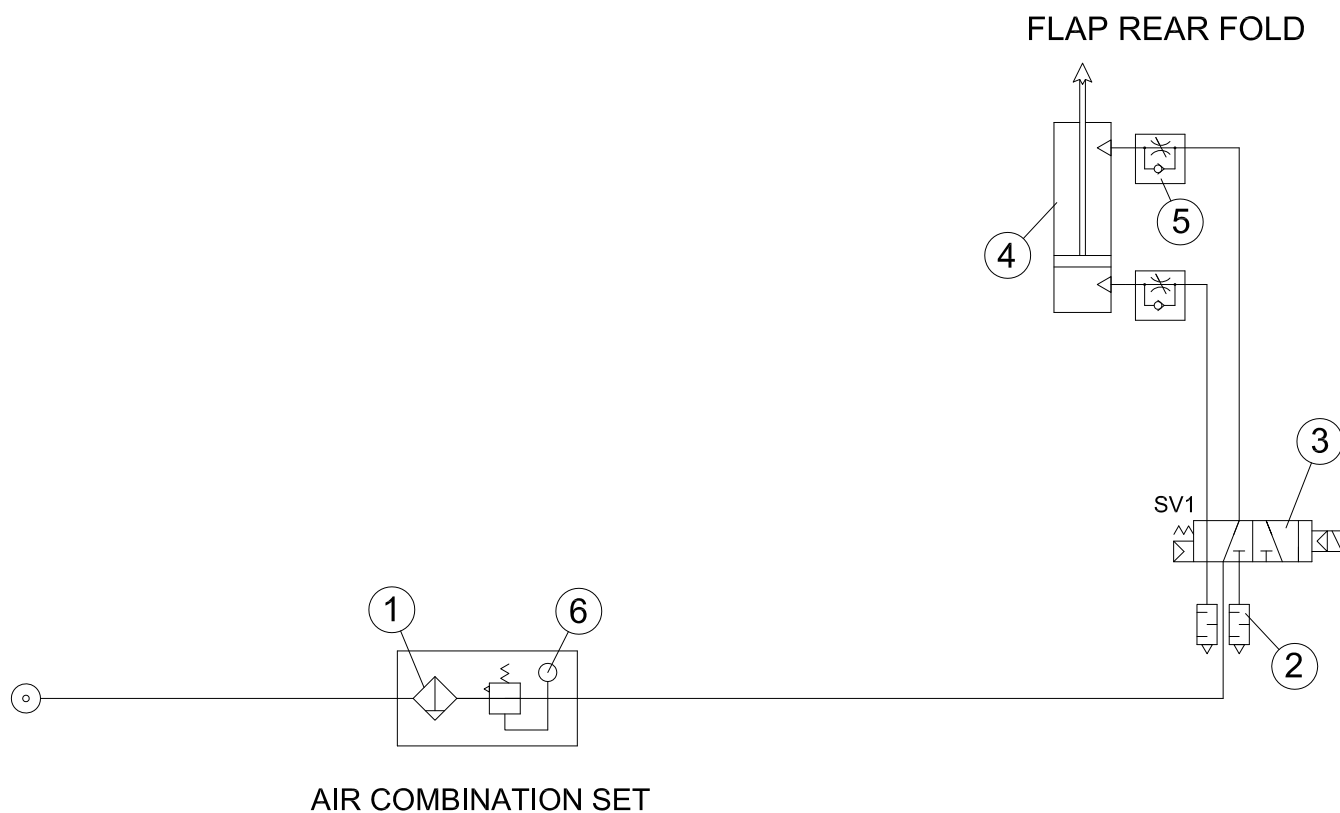
KEY NO.	PART NO.	QTY	DESCRIPTION
1	104019C1	1	GATEPOST, ASSY LEFT FRONT L829
2	106034CA	1	SAFETY DOOR SET LEFT FRONT 495 x 639 x t25
3	104019C2	1	GATEPOST, ASSY RIGHT FRONT L829
4	106034CB	1	SAFETY DOOR SET RIGHT FRONT 495 x 639 x t25
5	084023D3	2	GATEPOST, ASSY 30 x 90 x 849
6	106034CC	1	SAFETY DOOR SET 525 x 639 x t25
7	2707003	8	NUT, M5
8	106034CD	1	SAFETY DOOR SET 525x639xt25
9	05500910	6	PLATE, JOINT - BEAM L 100 x 77 x t3
10	10402408	2	PLATE, MOUNTING - LATCH 198 x 134 x t3
11	05500909	6	SAFETY DOOR SET PLATE, MOUNTING 60 x 54 x t3
12	08402326	1	TUBE, FLAT - L 60 x 30 x t3 x 497L
13	08402327	1	TUBE, FLAT - R 60 x 30 x t3 x 497L
14	10603401	1	TUBE, FLAT - L 30 x 60 x 591 x t2.3
15	10603402	1	TUBE, FLAT - R 30 x 60 x 591 x t2.3
16	08402336	2	PLATE, 60 x 30 x t3
17	05500915	4	BLOCK, MAST MOUNTING 90 x 20 x t5
18	27402042	4	CAP, COMPRESSION GUIDE COVER 30 x 30
19	27402041	4	CAP, COMPRESSION GUIDE COVER 30 x 60
20	2740201	2	HANDLE A-42-G 131 x 114
21	D2330000	4	PLATE, MAGNETIC MOUNTING 60 x 44 x t3
22	D2321000	4	MAGNETIC ASSY.
23	2707007	4	NUT, HEX M4
24	2705103	20	WASHER, FLAT M5
25	2705102	34	WASHER, FLAT M6
26	D2320000	6	REAR LATCH SET
27	28530061	2	SWITCH, LIMIT OMRON Z-15GQ22-B
28	18348	2	SAFETY SWITCH MOUNT 60 x 50 x t3
29	2703214	1	SCREW, ROUND HD M4 x 25
30	2701032	28	SCREW, SOCKET HD M5 x 10

SAFETY GATES PARTS LIST (con't)

KEY NO.	PART NO.	QTY	DESCRIPTION
31	2701020	20	SCREW, SOCKET HD M6X16
32	2701021	8	SCREW, SOCKET HD M6X20
33	2823099	60	RIVETS, GATES 6-4
34	2705201	20	WASHER, SPLIT LOCK M5
35	2705202	34	WASHER, SPLIT LOCK M6
36	2705103	20	WASHER, FLAT M5
37	2705102	34	WASHER, FLAT M6
*38	-	-	N/A
39	2707001	12	NUT, HEX JAM M5

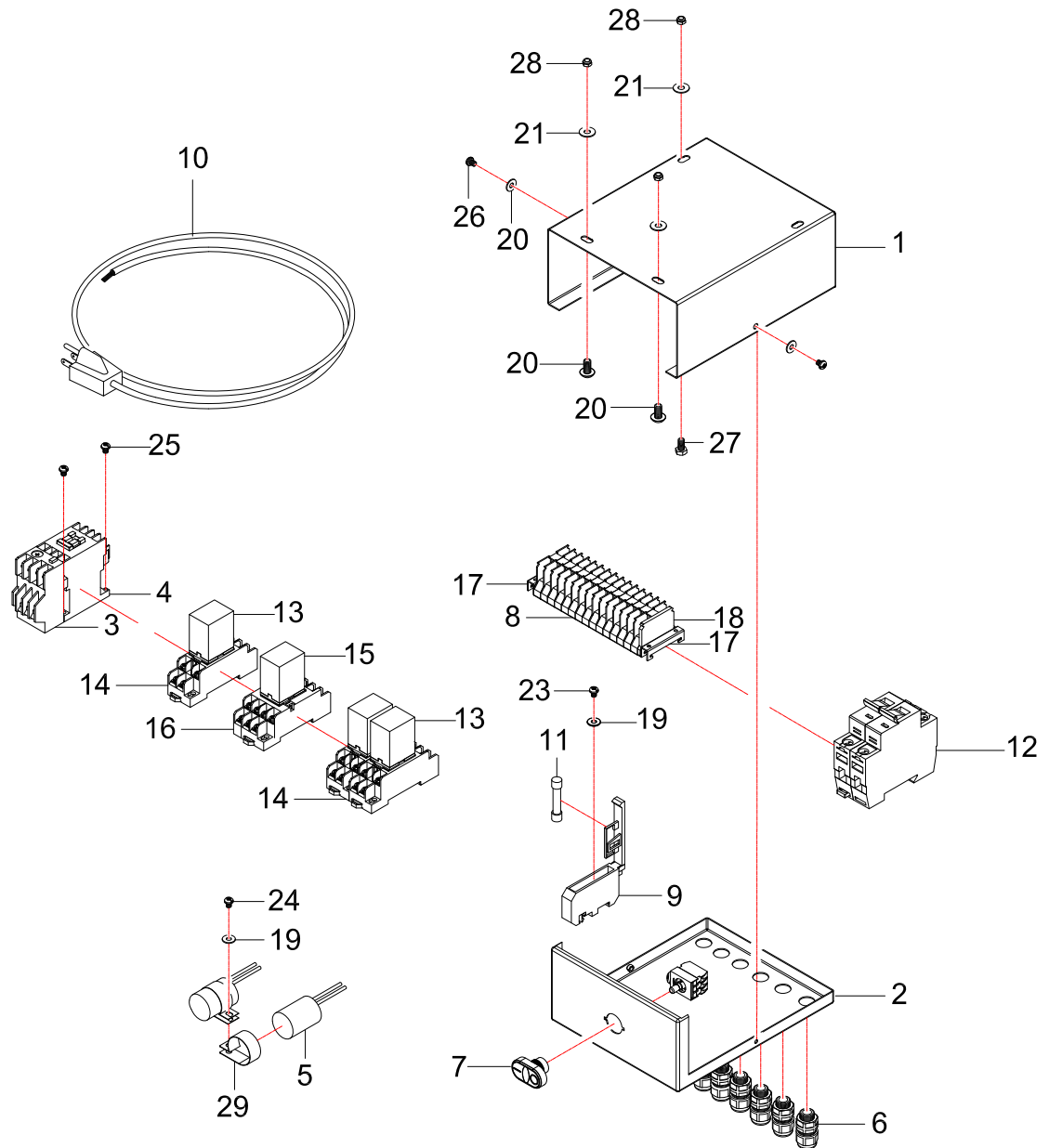
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AIR DIAGRAM



NO.	PART NO.	DESCRIPTION	SPECIFICATION	Q'TY	NOTES
1	291010221	REGULATOR, AIR MAIN	AW30-02B 1/4"	1	
2	2916001	SILENCER	1/8"	2	
3	2911903	VALVE, SOLENOID	VQZ3121-3Y-02	1	
4	2920051	CYLINDER, AIR	CDM2C40-85A	1	
5	2908015	CONTROLLER, SPEED	JSC 6-02	2	
6	2910550	GAUGE, PRESSURE	1/8" QPG40-11	1	

CONTROL PANEL ASSEMBLY



CONTROL PANEL PARTS LIST

KEY NO.	PART NO.	QTY	DESCRIPTION
1	K6802001	1	BOX, ELECTRICAL M302X200
2	K6801010	1	PLATE, ELECTRICAL DRAWER
3	2811190	1	RELAY, THERMAL 4.0-6.0AMPS
4	2810117	1	RELAY, MAGNETIC SC-03-4A 110V
5	2896307-2	2	CAPACITOR, 16uf 250VAC
6	2861020	6	CONNECTOR, STRAIGHT MG-16A-10B
7	28701851	1	SWITCH, POWER M22-SFNC W/CONTACT
8	2843201	15	TERMINAL, BLOCK ELECT
9	2890023	1	HOLDER, FUSE SF-111A
10	2882401	1	CORD, ELECTL W/ PLUG 1.25 3M
11	2890043	1	FUSE, GLASS 10AMP 30mm
12	2801820	1	CIRCUIT BREAKER, KM FAZ-2-B20
13	2830108	3	RELAY, OMRON LY2NJ 110V W/ NEO
14	2831204	3	SOCKET, RELAY LY2NJ- PTF-08AM
15	2830005	1	RELAY, OMRON MY4N 14 PIN
16	2831205	1	SOCKET, RELAY 14 PIN MY4N
17	2843207	1	BRACKET, TERMINAL BLOCK SBN-20
18	2843202	1	TERMINAL, CONNECTOR END PLATE
19	2705006	2	WASHER, FLAT M4
20	2705103	2	WASHER, FLAT M5
21	2705102	3	WASHER, FLAT M6
22	2701501	2	SCREW, OVAL HD M6X12
23	2703203	1	SCREW, OVAL HD PHILIP M4X8
24	2703225	1	SCREW, OVAL HD PHILIP M4X10
25	2703206	2	SCREW, OVAL HD PHILIP M4X12
26	2703207	2	SCREW, OVAL HD PHILIP M5X6
27	2700026	1	SCREW, HEX HD M6X12
28	2707102	3	NUT, HEX JAM NYLOCK M6
29	2896327	2	BAND FOR CAPACITORS (6.8.16.18µF) 30Ø

CUSTOMER SERVICE INFORMATION

Please contact us for your customer service needs Mon - Fri - 7am - 5pm PST

Customer Service
1.888.588.2378 ext. 2
sales@bestpack.com

Technical Support Service
1.888.588.2378 ext. 5
sales@bestpack.com

BESTPACK® CARTON SEALER WARRANTY

BestPack® Packaging Systems (BestPack®) brand carton sealers are warranted for a period of one year after the date of shipment to be free from defect in material and workmanship. Seller's and manufacturer's only obligation shall be to repair or replace, at their option, any mechanical part proven to be defective, provided the defect/failure occurs within the warranty period and the said part is returned prepaid, immediately, to the BestPack® factory or to an authorized service facility designated by the manufacturer. BestPack® will, at its sole discretion, repair or replace any defective components upon receipt of said defective component. Equipment replaced under the warranty shall have the same warranty as new equipment, but does not extend the warranty of the original equipment. Not covered by this warranty is the normal wear of components; such as, but not limited to: belts, chains, fuses, bulbs, turntable support, rollers, etc., or misuse or abuse of the machine or any components thereof. Parts returned without the prescribed paperwork will not be covered by this warranty. Labor to remove or repair any components is also not covered by this warranty. This warranty does not apply to equipment, which, in the opinion of BestPack, has been subjected to misuse, neglect, or has been repaired or altered by unauthorized personnel. Damage in transport is the responsibility of the carrier and is not covered under our warranty. BestPack's® obligation under this warranty will be to provide for repairs to defective components or replacement of parts FOB BestPack®.

Warranty is void if:

1. Failure is not reported to BestPack® Products within the one-year warranty period.
2. 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.
3. Failure is due to operations above the rated capacities or used in any other improper manner, either intentional or otherwise.
4. Failure is due to equipment that has been altered by anyone other than an authorized representative of BestPack Product Company.
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.
6. The warranty registration form is not completed and returned to Future Commodities Int'l, 1425 S. Campus Ave, Ontario, CA 91761

The above statements are made in lieu of all warranties, expressed or implied, including the implied warranties for merchantability and fitness for purpose. Neither seller nor manufacturer shall be liable either in tort or in contract for any loss or damage, direct, incidental, or consequential, arising out of the use of or the inability to use the BestPack brand equipment. No statement or recommendation not contained herein shall have any force effect unless in an agreement signed by an Officer of the seller and manufacturer.

BESTPACK® WARRANTY REGISTRATION FORM

DATE _____

END USER INFORMATION

COMPANY NAME _____ CONTACT NAME _____ TITLE _____

ADDRESS _____

CITY _____ STATE _____ ZIP _____

DISTRIBUTOR INFORMATION

COMPANY NAME _____ CONTACT NAME _____ TITLE _____

ADDRESS _____

CITY _____ STATE _____ ZIP _____

MACHINE INFORMATION

MODEL _____ SERIAL # _____ TYPE _____

DISPENSER _____ VOLTAGE _____ PLANT VOLTAGE (phase x voltage) _____

OTHER INFORMATION (optional)

DID THE MACHINE ARRIVE IN SATISFACTORY CONDITION? YES _____ NO _____

IS THIS YOUR FIRST BESTPACK® MACHINE?

DOES YOUR FACILITY USE OTHER BRANDS?

IF YES, PLEASE LIST: _____

*To activate warranty (warranty commences from product ship date), the Warranty Registration Form must be completed and sent to:
BestPack® Packaging Systems, Future Commodities Int'l, 1425 S. Campus Ave Ontario, CA 91761*