

PRE-MASK (EP25) TAPE APPLICATOR

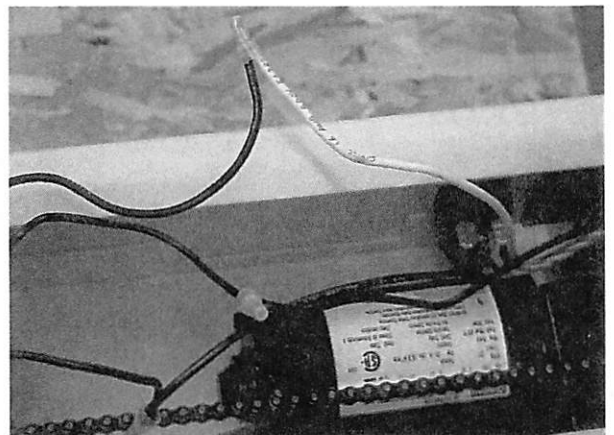
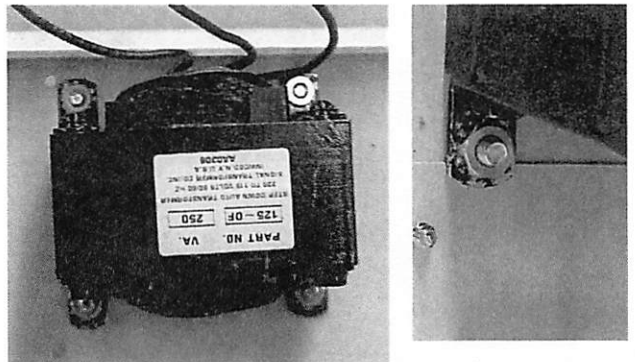
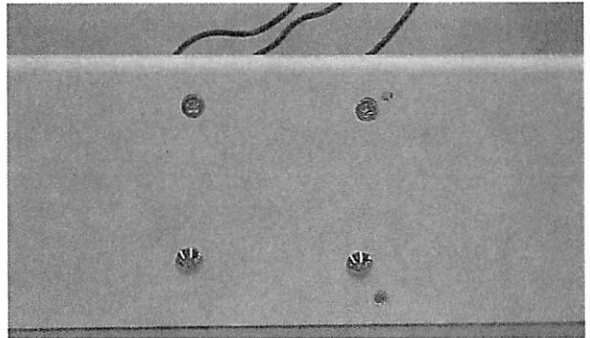
ASSEMBLY PROCEDURES

FEBRUARY 2013 UPDATE OF MAY 2003 VERSION

PRE-MASK 25

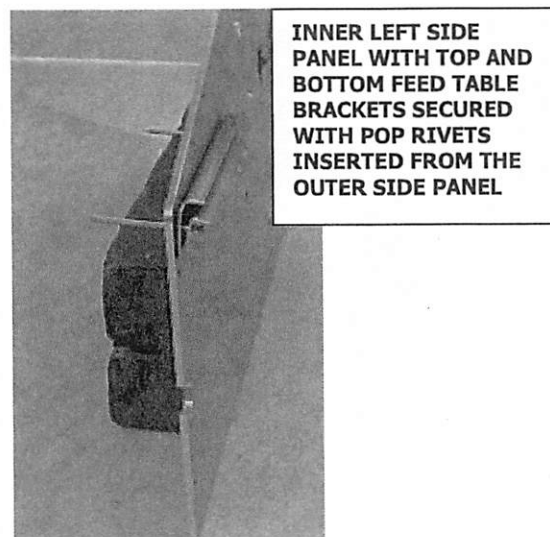
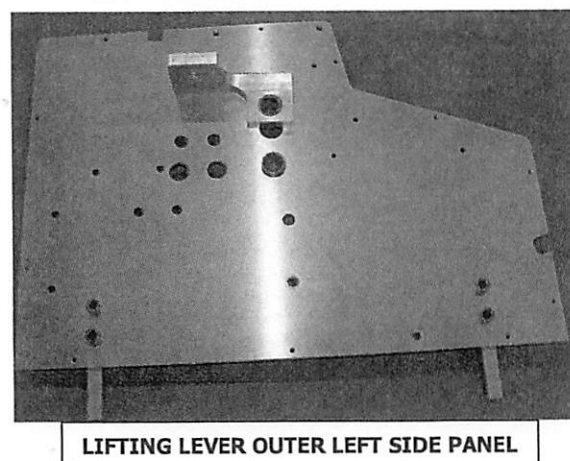
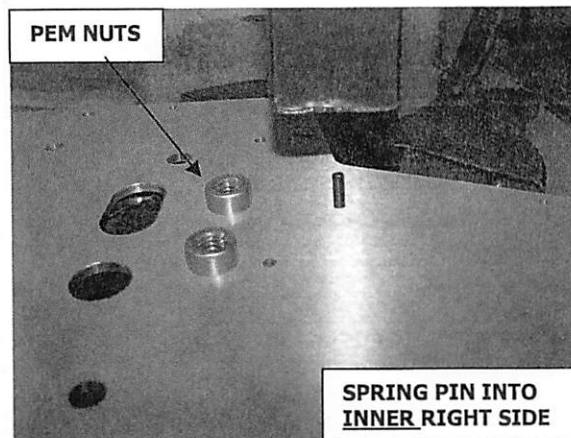
220 VOLT ASSEMBLY & WIRING

- 1) FOLLOW 110 VOLT ASSEMBLY *EXCEPT* FOR THE FOLLOWING CHANGES.
- 2) SEPARATE AND IDENTIFY THE (3) WIRES ON THE TRANSFORMER (PRT321) AS19. ATTACH TRANSFORMER TO BACK COVER, WIRES UPWARD, WITH (2) 10-32 X 7/8 FH AND (2) 10-32 X 1/2 TH, SECURED WITH (4) #10 KEPS HEX ON INSIDE. ****DO THIS BEFORE ATTACHING COVER TO BRACKETS. TRANSFORMER MUST BE TIGHTENED AS CLOSE TO UPPER COVER AS POSSIBLE, SO BOTTOM COVER FITS.**
- 3) WIRE TRANSFORMER AS FOLLOWS:
0=SPLICE WITH 18" OF WHITE 18 GAUGE WIRE USING A CLEAR CAP (PRT289). TWIST TOGETHER WHITE WIRE FROM MOLEX AND WHITE JUMPER FROM "0" ON TRANSFORMER. CRIMP WHITE WIRES TOGETHER WITH A BLUE FLAG (PRT284). CONNECT WHITE WIRE TO RECEPTICLE POST BY SIDE PANEL.
115=SPLICE WITH 20 1/2" OF BLACK 18 GAUGE WIRE USING A CLEAR CAP. CRIMP A FEMALE (PRT302) ONTO THE OPEN END OF 115 JUMPER WIRE AND TERMINATE ON UPPER FUSE POST, OUTER RIGHT SIDE PANEL.
230=SPLICE WITH 21" OF BLACK 18 GAUGE WIRE USING A CLEAR CAP. CRIMP A BLUE FLAG CONNECTOR (PRT284) ONTO OPEN END OF 230 JUMPER WIRE AND TERMINATE ON INNER RECEPTICLE POST.
- 4) USE AN ADAPTER AND TEST ON A 220 VOLT POWER SOURCE. BEFORE SHIPPING, CUT OFF PLUG END OF CORD (INSERTS INTO POWER SOURCE).
- 5) PREPARE PAPER WORK: JOB SHEET, INSPECTION FINAL TEST AND CHECK LIST, MANUAL.

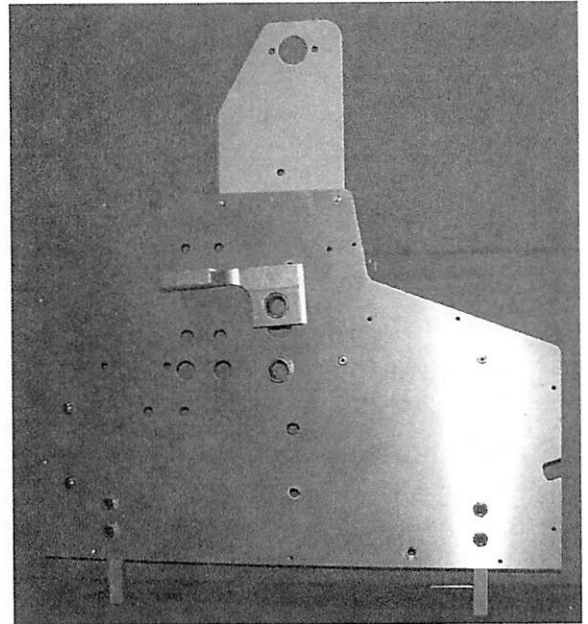
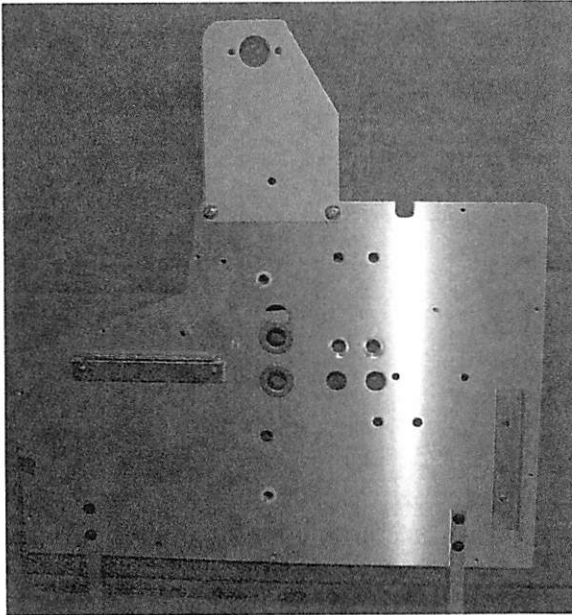


PRE-MASK TAPE APPLICATOR SIDE PANEL ASSEMBLY 2013

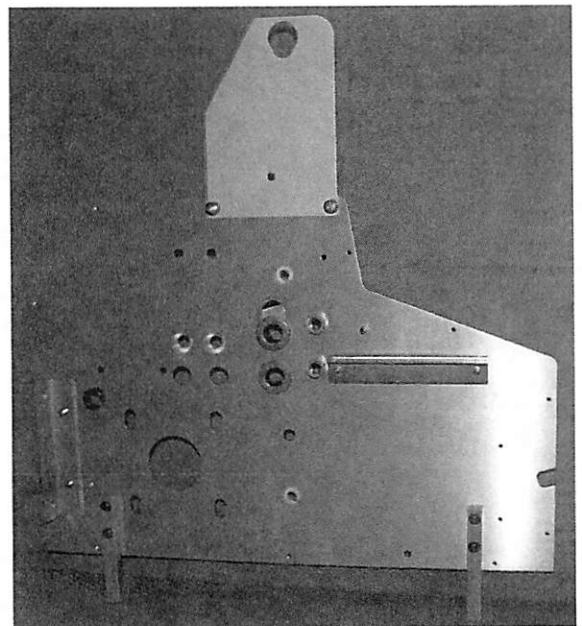
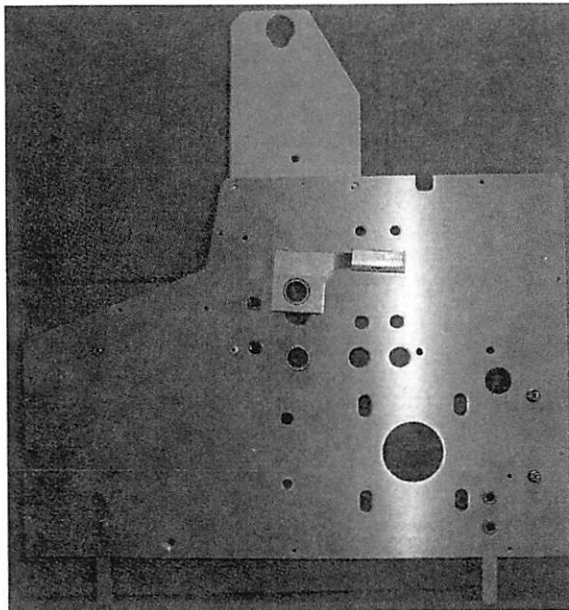
- 1) PRESS 1/8 X 1/2 SPRING PIN (.125J008) INTO *INNER* RIGHT AND LEFT SIDE PANELS (EP25 090.5R AND EP25 090.4L) AS05 TO BE FLUSH ON OUTER SIDE PANEL. SPRING PINS STOP THE SAFETY SHIELD, LOCATE IN LINE WITH UPPER PEM NUT.
- 2) INSERT (4) NYLINERS (PRB057) RACK 9 INTO TOP AND BOTTOM IDLER HOLES FROM INNER PANELS, FLANGE INWARD.
- 3) INSERT OILITE BEARING (PRB049) RACK 9 FLANGE *INWARD*, INTO TOP RUBBER ROLL CHANNELS. PRESS LIFTING LEVERS (EP25 112.4R AND EP25 112.4L) RACK 9 ONTO OUTER BEARING SHAFT. LIFTING LEVERS MUST SLIDE IN CHANNEL, NOTCH GOES UNDER NYLINER BEARING.
- 4) INSERT OILITE BEARING (PRB048) AS08 FLANGE *INWARD* INTO ****LEFT SIDE** PANEL UNDER PRB049 AND OILITE BEARING (PRB051) RACK 9 INTO CORRESPONDING ****RIGHT SIDE** PANEL. OPEN BEARINGS WITH A .505 REAMER.
- 5) ON INNER PANELS THREAD (4) LEGS (EP25 048.4) RACK 9 USING 8-32 X 3/4 BHCS AND 8-32 KEPS HEX NUTS ON OUTER PANEL.
- 6) SECURE (2) BACK COVER MOUNTING BRACKETS (0285 091.4) RACK 9 WITH 10-32 X 3/8 RH, WITH BREAK TO THE REAR.
- 7) SECURE REWIND BRACKETS (EP25 047.4R, EP25 047.4L) RACK 9 TO INNER SIDE PANELS WITH (4) 10-32 X 1/4 PH. LONG SIDE FORWARD, NOTCH ON RIGHT SIDE.
- 8) ATTACH FEED TABLE BRACKETS (LC25 098.4T AND LC25 098.4B) LD09 WITH 1/8 X 3/8 DIA FH POP RIVETS .125B0Q06.
- 9) INSERT SNAP BUSHING (PRB062) AS079 BEHIND MOTOR, FOR WIRES ON RIGHT SIDE PANEL, FLANGE OUTWARD.



LEFT INSIDE AND LEFT OUTSIDE

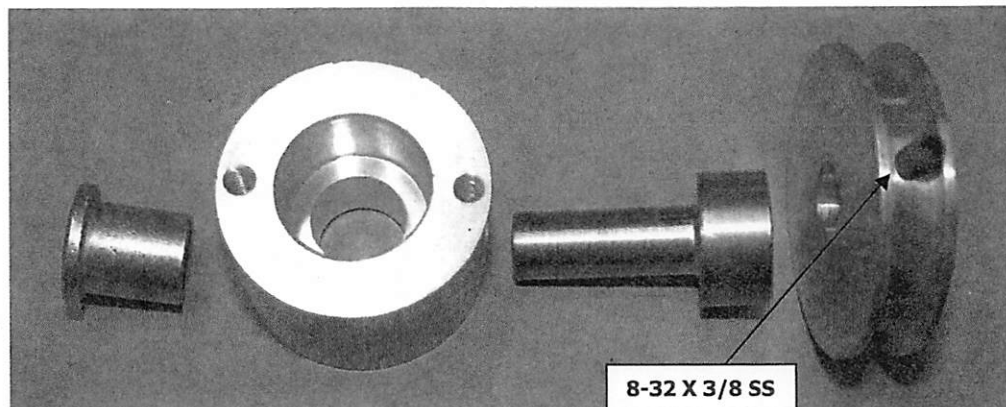
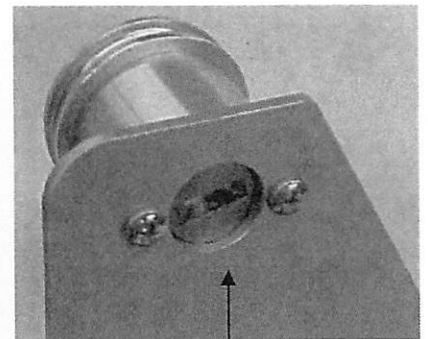
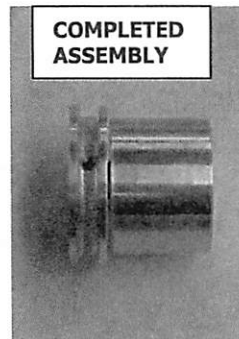
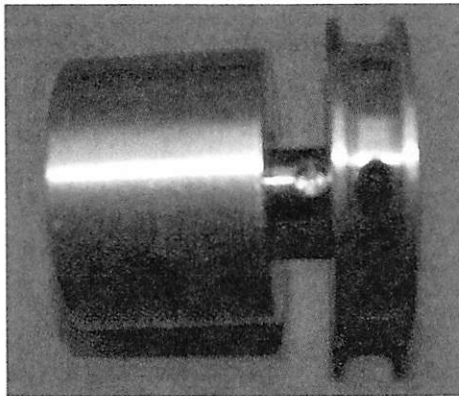
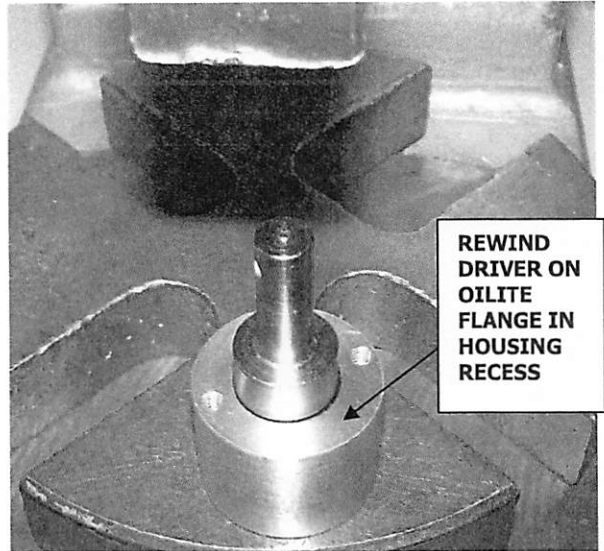


RIGHT OUTSIDE AND INSIDE



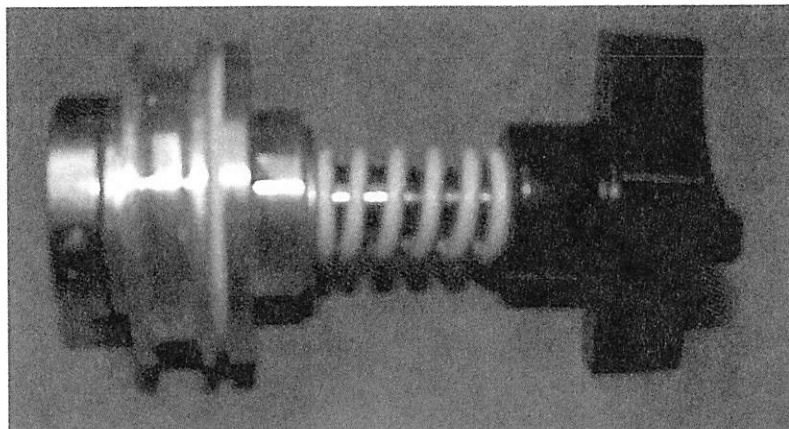
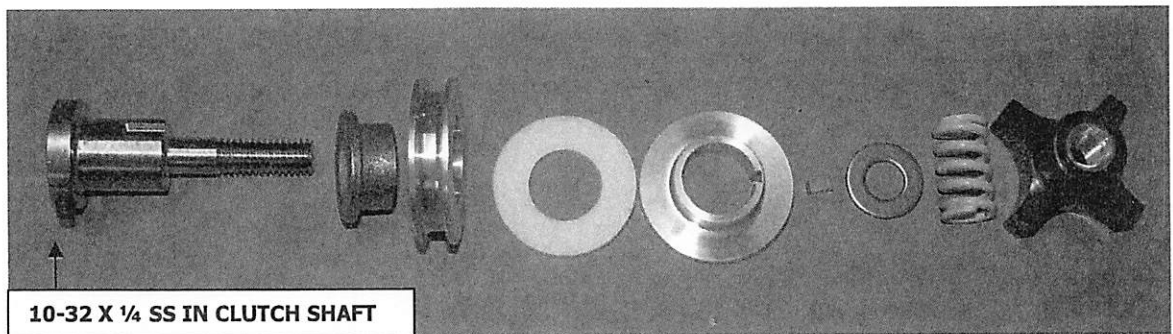
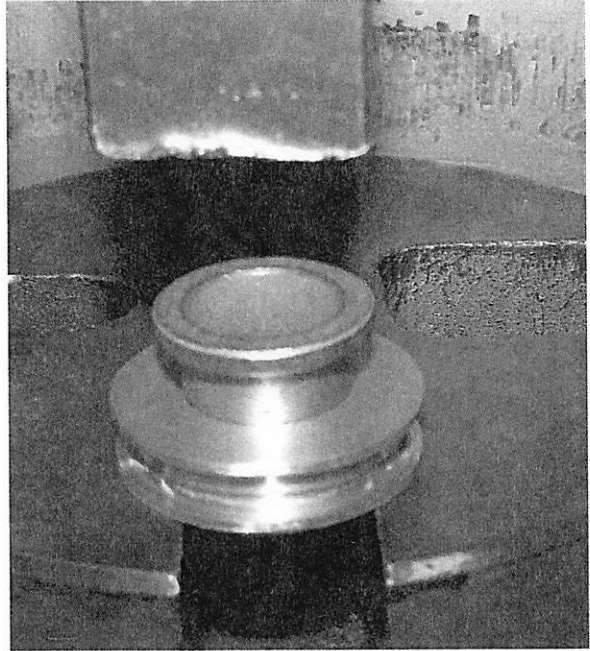
PRE-MASK TAPE APPLICATION TOP PULLEY ASSEMBLY

- 1) PRESS OILITE BEARING (PRB047) RACK 9 INTO RECESS OF REWIND DRIVER HOUSING (EP25 046.4) RACK 9 WITH THE FLANGE IN RECESS. USE REWIND DRIVER WHEN PRESSING IN BEARING.
- 2) INSERT THE SHAFT OF THE REWIND DRIVER (EP25 045.4) RACK 9 INTO REWIND DRIVER HOUSING.
- 3) SECURE REWIND PULLEY (EP25 044.4) RACK 9 TO DEPRESSION ON REWIND DRIVER SHAFT USING AN 8-32 X 3/8 SS. **THE THINNER PULLEY SET SCREW SIDE ORIENTS TOWARD REWIND DRIVER.



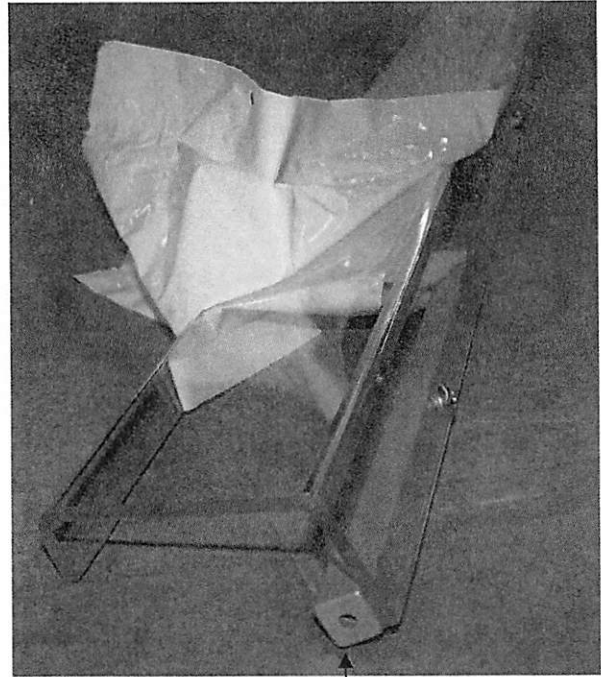
PRE-MASK TAPE APPLICATOR REWIND CLUTCH ASSEMBLY 2013

- 1) FROM RACK 9 PRESS OILITE BEARING (PRB092) ONTO CLUTCH PULLEY C (EP25 043.4).
- 2) SLIDE FLANGE SIDE OF PULLEY ONTO CLUTCH SHAFT (EP25 041.4) RACK 9. THREAD A 10-32 X 1/4 SS INTO CLUTCH SHAFT. ADD FRICTION WASHER-TEFLON (EP25 004.4) RACK 9 NEXT TO PULLEY.
- 3) INSERT A 1/8 SQ X 1/4 LG STRAIGHT KEY (H850 178.4) RACK 9 INTO CLUTCH SHAFT KEYWAY.
- 4) SLIDE FLAT SIDE OF CLUTCH PRESSURE PLATE (EP25 007.4) RACK 9 OVER KEY AND ADD A 3/8 FLAT WASHER AS12.
- 5) ADD A ROUND WIRE SPRING (PRS229) RACK 9. SECURE WITH A KNOB (PRK170) SUPPLY ROLL CART.



PRE-MASK TAPE APPLICATOR SAFETY SHIELD ASSEMBLY

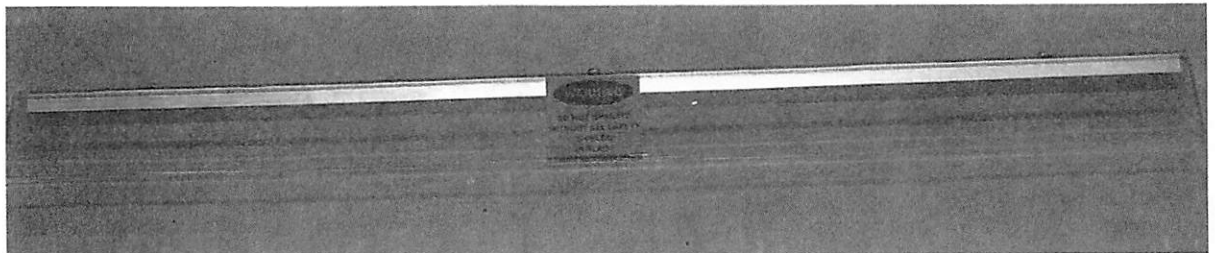
- 1) PEEL PLASTIC OFF SAFETY SHIELD (EP25 074.4) AS05 TO EXPOSE (3) SCREW OPENINGS. ATTACH SAFETY SHIELD MOUNTING BRACKET (EP25 075.4) AS05 TO UNDERSIDE THROUGH OPENINGS WITH (3) 8-32 X 3/8 RH. START ALL SCREWS BEFORE TIGHTENING ANY.
- 2) TRIM A SMALL WARNING LABEL (LAB21) RACK 7 1/16" ON TOP AND 3/16" ON THE BOTTOM. CENTER LABEL ON OUTER FLAT AREA OF SAFETY SHIELD UNDER MIDDLE SCREW.



SAFETY SHIELD MOUNTING BRACKET

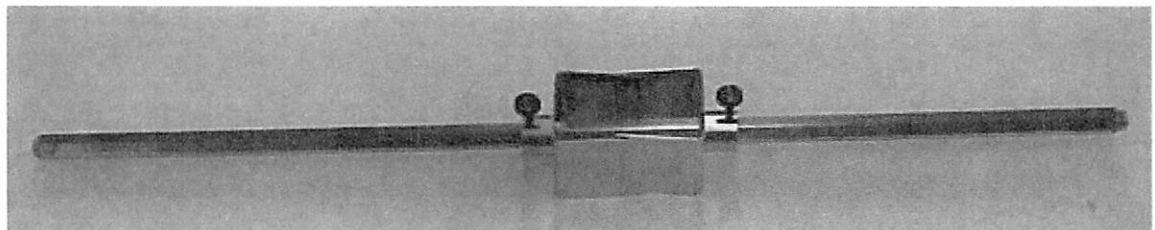
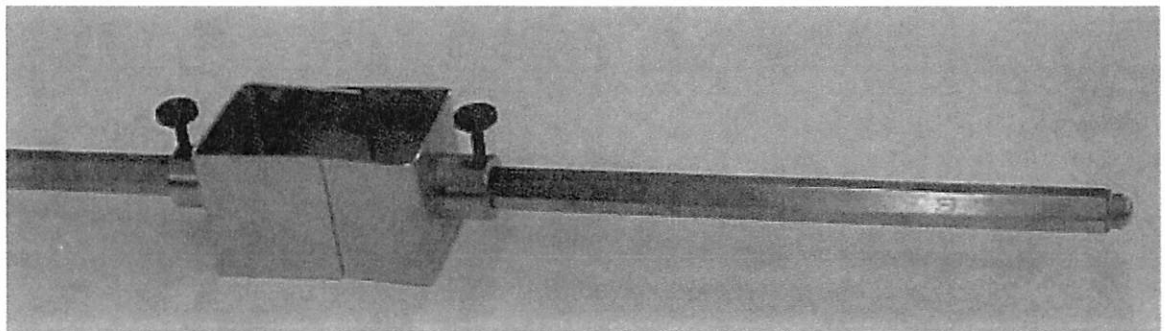
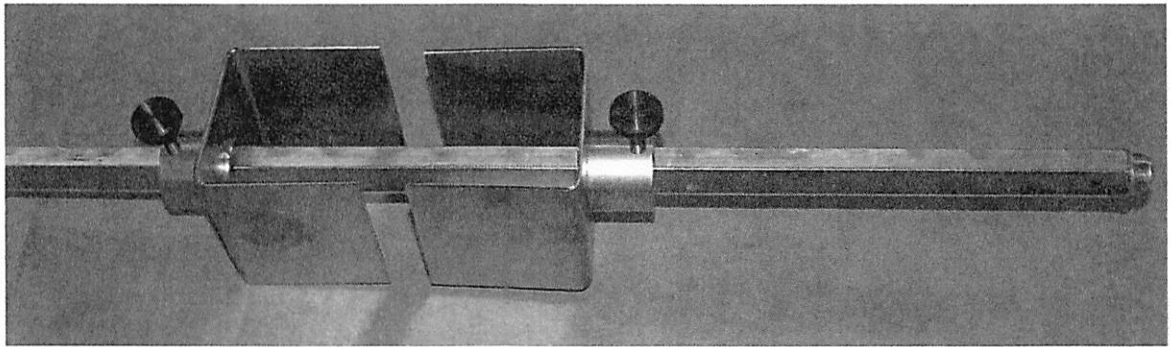
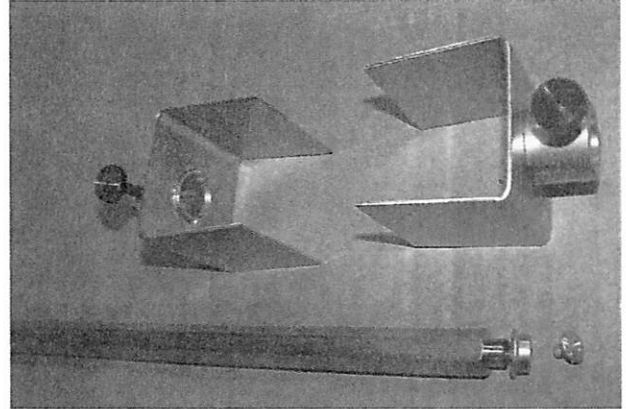


TRIM WARNING LABEL



PRE-MASK TAPE APPLICATOR SCRAP REWIND BAR

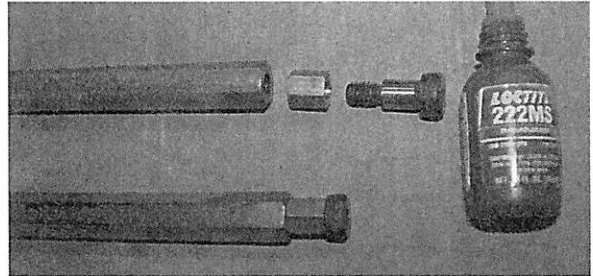
- 1) PLACE AN OILITE BEARING (PRB046A) RACK 21 ON ROUND END OF SCRAP REWIND SHAFT (EP25 056.4) AS05 WITH FLANGE INWARD. SECURE BEARING WITH A 10-32 X 1/4 TH. USE LOCTITE ON SCREW THREADS.
- 2) SLIDE (2) CORE GRIPPERS (E850 207.6B) RACK 1 ONTO SCRAP REWIND SHAFT AND SECURE GRIPPERS WITH (2) SPI 3/4" SCREWS (PRK178) AS08.



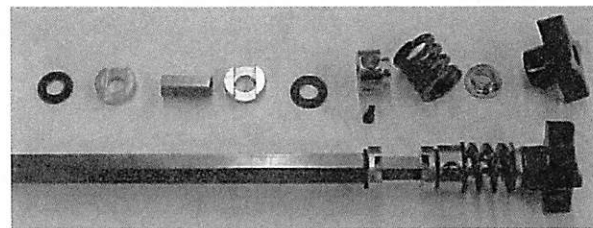
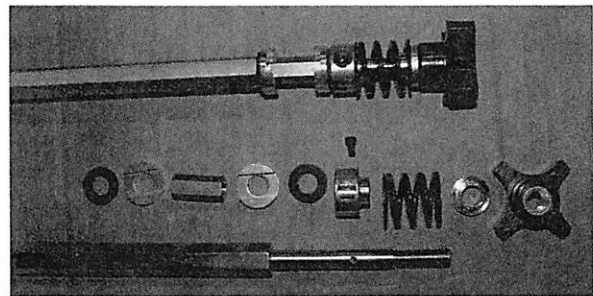
PRE-MASK TAPE APPLICATOR SUPPLY ROLL ASSEMBLY

1) THE PRE-MASK USES TWO SUPPLY ROLLS PER MACHINE.

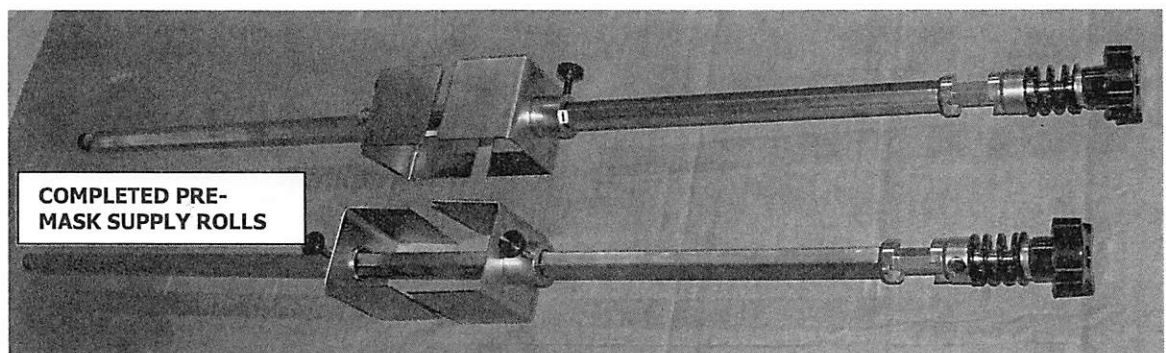
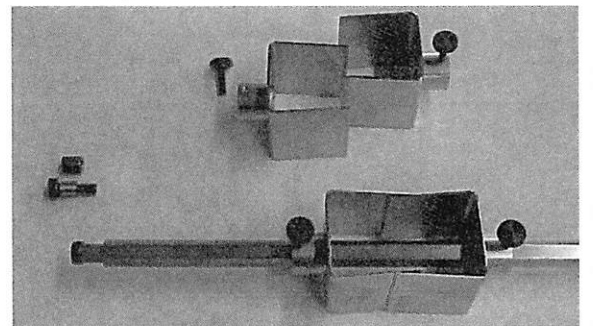
2) SLIDE A SUPPLY ROLL HEX ADAPTOR (0285 023.4) MACH SHOP ON A 3/8 X 1/2 SHOULDER BOLT (*TURN DOWN HEX*). LOCTITE THREADS AND TIGHTEN ON SHORT END OF SUPPLY ROLL SHAFT (EP25 011.4) AS05. HEX SPINS FREELY.



3) ON LONG THREADED END OF SUPPLY ROLL SHAFT SLIDE ON A FIBER WASHER (PRW334) RACK 9, SUPPLY ROLL FRICTION PLATE C (0285 025.4) SUPPLY ROLL CART, SUPPLY ROLL HEX BUSHING (EP25 023.4) RACK 9 *(*HEX BUSHING MAY NEED TO BE TURNED DOWN*) ANOTHER SUPPLY ROLL FRICTION PLATE C, ADD ANOTHER FIBER WASHER. WITH THE FLAT SIDE *INWARD*, ADD A SUPPLY ROLL FRICTION PLATE B (0285 005.4) RACK 9, AND SECURE FRICTION PLATE WITH 6-32 X 1/4 SHCS INTO SHAFT – THERE WILL BE MOVEMENT. FROM SUPPLY ROLL CART ADD A SUPPLY ROLL TENSION SPRING (PRS234), SUPPLY ROLL SPRING BUSHING (0285 026.4), BRUSH ANTI-SEIZE ONTO END THREADS AND ADD A SUPPLY ROLL KNOB (PRK170).

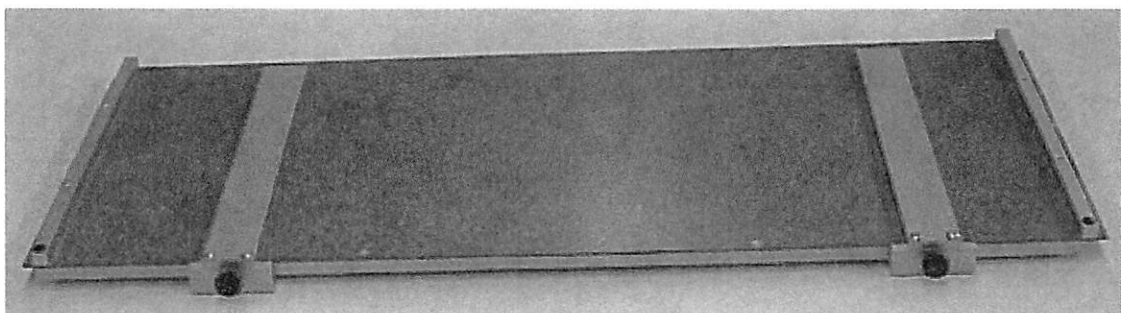
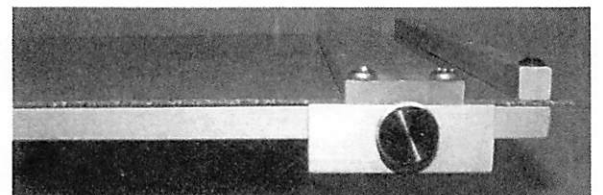
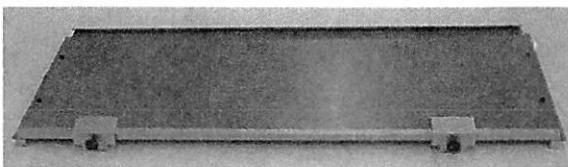
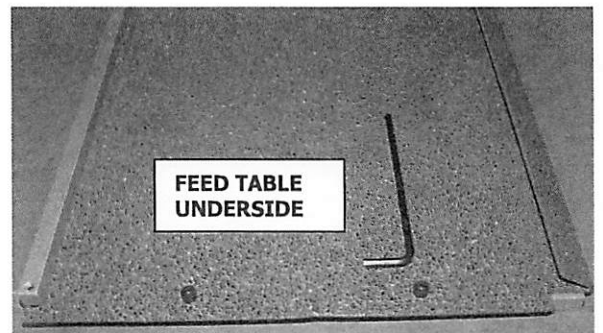
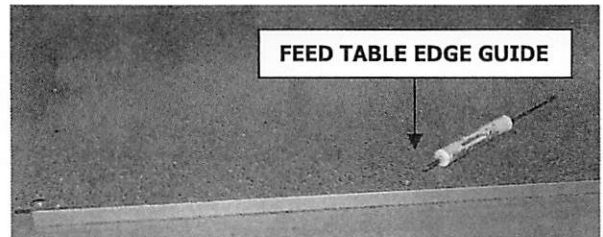
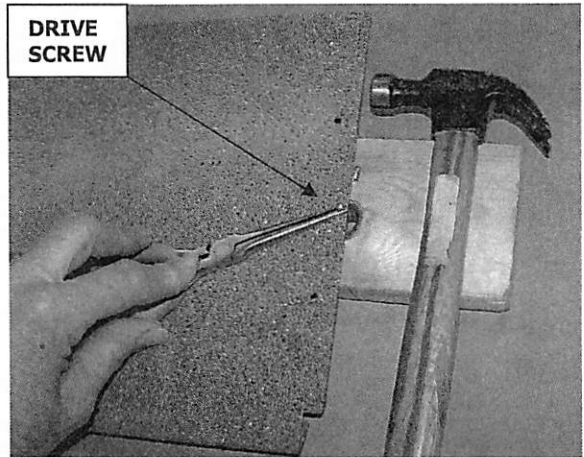


4) SLIDE (2) CORE GRIPPERS (E850 207.6B) RACK 1 ONTO SUPPLY ROLL SHAFT, WITH HUB *OUTWARD* AND SECURE WITH (2) SPI 3/4" SCREWS (PRK178) AS08.



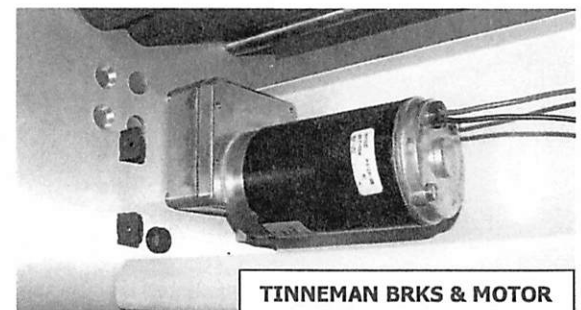
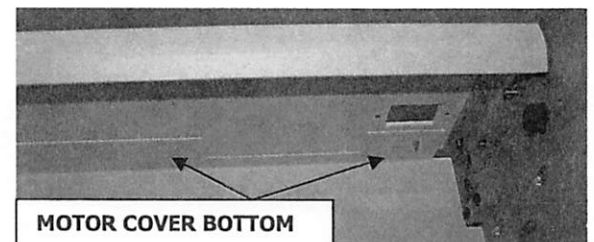
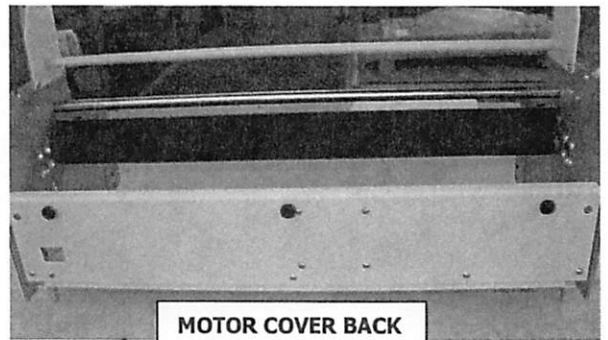
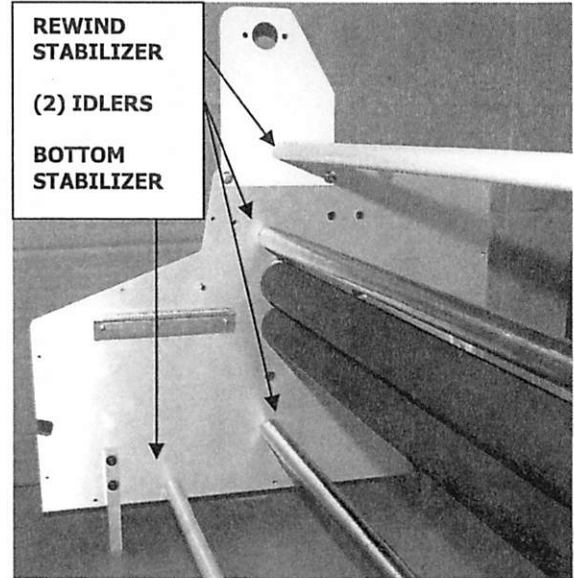
PRE-MASK TAPE APPLICATOR FEED TABLE ASSEMBLY

- 1) TAP (2) 2 X ¼ DRIVE SCREW ^{AS11} LD00 INTO FEED TABLE (EP25 096.4) AS05 SIDES.
- 2) ATTACH FEED TABLE EDGE GUIDE (EP25 099.4) AS05 TO FRONT UNDERSIDE WITH (2) 4-40 X ¼ FH INTO TOP COUNTERSUNK HOLES, USE LOCTITE.
- 3) ATTACH (2) FEED TABLE SIDE GUIDES (EP25 098.4) RACK 9 TO UPPER SIDES LOOSELY IN FRONT WITH (2) 8-32 X ¾ BSH INTO EDGE GUIDE ENDS. FROM THE UNDERSIDE TIGHTEN SIDE GUIDES WITH (4) 8-32 X ¼ SHCS. THEN, TIGHTEN THE BUTTON HEADS ON TOP.
- 4) SLIDE (2) FEED TABLE MATERIAL GUIDE MOUNTING BLOCKS (EP25 100.4) RACK 9 ONTO EDGE GUIDE WITH THREADS FACING UPWARD. ATTACH (2) FEED TABLE MATERIAL GUIDES (EP25 097.4) RACK 9 TO GUIDE MOUNTING BLOCKS WITH (4) 8-32 X ½ PH. SECURE GUIDE MOUNTING BLOCKS TO EDGE GUIDE WITH (2) SPI ½" SCREW (PRK177) AS08.



PRE-MASK TAPE APPLICATOR CHASSIS ASSEMBLY 2013

- 1) INSERT (2) RUBBER ROLLS (0500 040.4) LD BETWEEN OILITE BEARINGS IN SIDE PANELS, WITH JOURNAL FLAT ENDS ON RIGHT SIDE.
- 2) INSERT (2) IDLERS (0500 052.4) AS05 THROUGH NYLINER BEARINGS.
- 3) SECURE LONGER, PAINTED BOTTOM STABILIZER C (0500 110.4) AS05 BEHIND FRONT LEGS USING (2) 10-32 X 3/8 FH UC.
- 4) SECURE REWIND STABILIZER C (EP25 057.4) AS05 BETWEEN REWIND BRACKETS USING (2) 10-32 X 3/8 TH.
- 5) SECURE MOTOR COVER BACK (3500 093.4BK) AS05 TO BACK COVER MOUNTING BRACKETS, WITH LIP INWARD AND UPWARD. USE (2) 10-32 X 3/8 FH UC ON TOP AND (2) 10-32 X 3/8 RH LOWER. ON 110V FILL IN (4) TRANSFORMER THREADS WITH 10-32 X 3/8 RH. ADD (3) EQUIDISTANT 1/2" SPI KNOBS (PRK177) AS08 ALONG THE OUTER TOP.
- 6) SECURE BOTTOM MOTOR COVER (EP25 092.4B) AS05 TO BACK COVER, BREAK INWARD, WITH (3) 8 X 3/8 SMS.
- 7) SECURE THE 90VDC MOTOR (PRM220) AS23 TO THE RIGHT SIDE PANEL, UPWARD IN CHANNELS WITH CYLINDER OFFSET TOWARD BACK COVER. USE (4) 10-32 X 3/4 BH WITH (4) 1/4 X 5/8 X 1/8 WASHERS ON OUTER PANEL AND ON INNER PANEL USE (4) 1/4 FLAT WASHERS BETWEEN SIDE PANEL AND MOTOR.
- 8) SECURE (4) TINNEMAN BRACKETS (PRT 319) LD09 TO INNER PANELS TO HOLD TOP COVERS. USE (4) 8 X 1/2 PH SMS.
- 9) *LOOSELY* ATTACH (4) GUIDE BLOCKS (EP25 111.4) RACK 9 TO OUTER SIDE PANELS, WITH LIFTING LEVER THREADS BETWEEN GUIDE BLOCKS, USING (4) 1/4-20

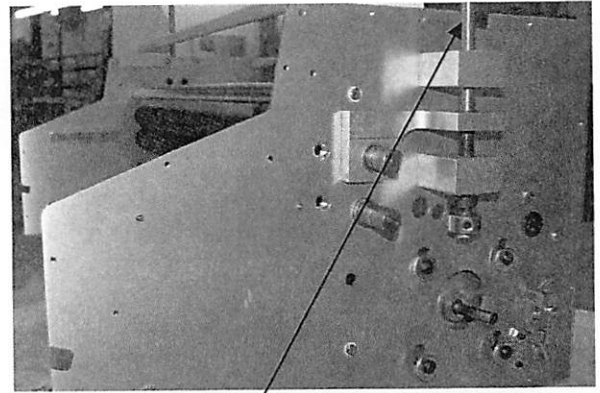


USE PRM 300 MOTOR ↗
6-19-17 MASTER

X 1/2 BHCS ON TOP AND (4) 1/4-20 X 1/2 FHCS ON BOTTOM.

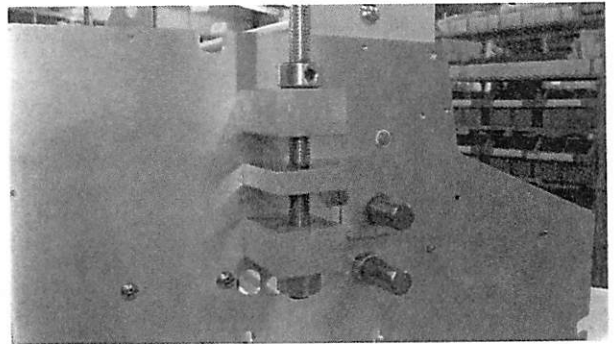
Closer to center cut

- 10) BRUSH ANTI-SEIZE ONTO THE THREADS OF THE FLAT CUT END PORTION OF (2) TENSION ADJUSTMENT RODS (EP25 109.4) RACK 9 FOR THE RIGHT AND LEFT SIDE. CONTINUE ADDING ANTI-SEIZE UP THE THREADS APPROXIMATELY 3". INSERT THIS END OF THE TENSION ADJUSTMENT RODS DOWNWARD THRU THE TOP GUIDE BLOCK AND THREAD INTO THE RIGHT AND LEFT LIFTING LEVERS. USE CHANNEL LOCKS TO TURN IF THREADS ARE TIGHT. EXTEND TENSION ADJUSTING ROD THROUGH LOWER GUIDE BLOCK.



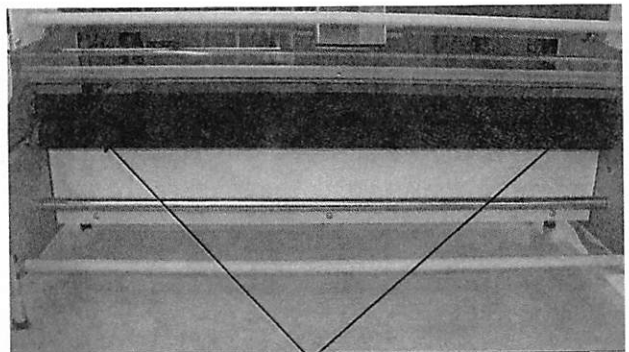
RIGHT SIDE: TENSION ADJUSTMENT ROD THRU GUIDE BLOCK, LIFTING LEVER & GUIDE BLOCK

- 11) SLIDE A FIBER WASHER (PRW333) AS08 UP THE LOWER TENSION ADJUSTING ROD THREADS AND SECURE WITH A 3/8" SHAFT STOP COLLAR (PRC095) LD03 ALIGNING THE SET SCREW ON THE FLAT CUT SECTION OF THE TENSION ADJUSTMENT ROD. TEST THREADING MOTION OF TENSION ADJUSTMENT ROD UP AND DOWN THROUGH LIFTING LEVER. TIGHTEN LOWER GUIDE BLOCK SCREWS, TEST AGAIN. RAISE TENSION ROD UNTIL WASHER AND SHAFT COLLAR ARE JUST TOUCHING LOWER GUIDE BLOCK. TIGHTEN UPPER GUIDE BLOCK SCREWS.



LEFT SIDE: TENSION ADJUSTMENT ROD ASSEMBLY & 1/2 SHAFT STOP COLLARS

- 12) PLACE A FIBER WASHER (PRW333) AS08 ON UPPER TENSION ADJUSTING RODS ABOVE TOP GUIDE BLOCK. SET A 3/8" SHAFT COLLAR (PRC095) LD03 ON TOP RODS NEXT TO FIBER WASHER; TIGHTEN STOP COLLAR ON FLAT OF TENSION ROD.

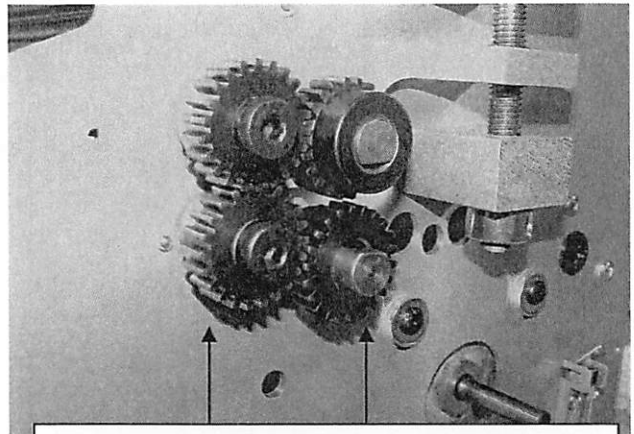


LOOK AT NIP OF RUBBER ROLLS. CLOSE GAP EQUALLY AT ENDS. TEST AT ONE 360 DEGREE TURN AFTER BOTH ROLL ENDS TOUCH

- 13) FACE THE CROWNED RUBBER ROLLS FROM THE FRONT. ADJUST FOR SMALL GAP AT ROLL ENDS. THREAD THE RIGHT AND LEFT SIDE TENSION ADJUSTMENT RODS UNTIL BOTH RUBBER ROLL ENDS ARE JUST TOUCHING. FOR TESTING PURPOSES, TIGHTEN ONE ADDITIONAL 360 DEGREE TURN ON BOTH SIDES.

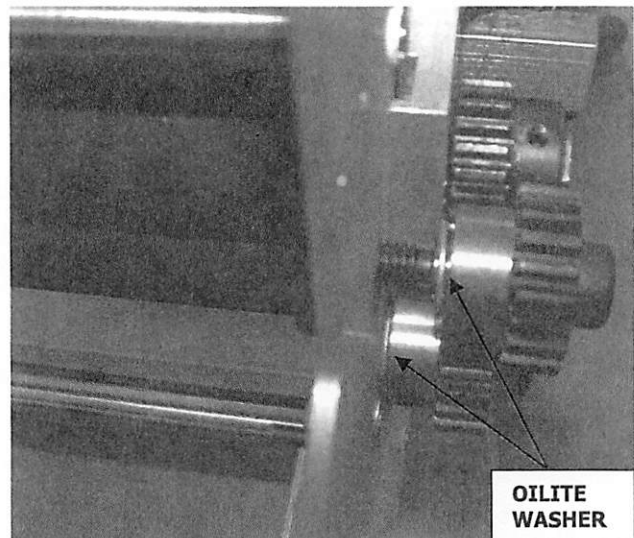
PRE-MASK TAPE APPLICATOR GEARING 2013

- 1) ON RIGHT SIDE OF PRE-MASK PLACE (1) BLACK FELT WASHER (PRW331) RACK 9 ON THE TOP RUBBER ROLL SHAFT, *ADD A DROP OF OIL TO THE FELT WASHER. PUSH BOTTOM ROLL TO FAR RIGHT. ALIGN RUBBER ROLL JOURNAL FLATS TO FRONT. ADD (2) GEARS (PRG144) RACK 9 TO RUBBER ROLL JOURNALS; TOP GEAR HUB *OUTWARD*, BOTTOM GEAR HUB *INWARD*. SNUG GEARS TO TOP FELT WASHER AND BOTTOM BEARING. TIGHTEN GEARS WITH 10-32 X 1/4 SET SCREWS ON FLAT OF JOURNAL. THESE GEARS DO NOT MESH, BUT WILL CATCH THE NEXT TWO GEARS WHEN ADDED.



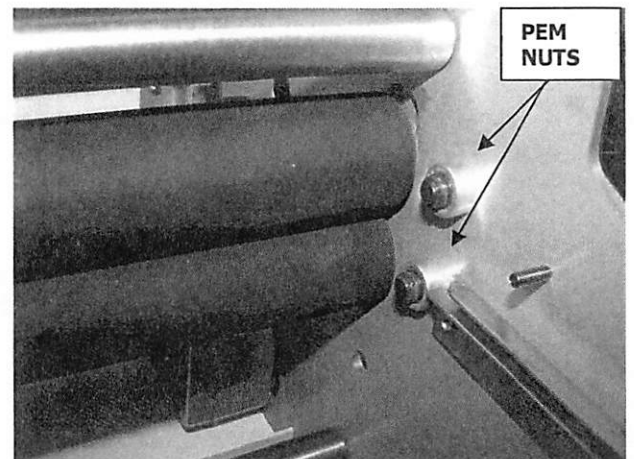
PEM NUT GEARS IN FRONT, ROLL GEARS IN REAR

- 2) PLACE (2) 1/2" GEARS WITH BUSHINGS (PRG145) RACK 9 ONTO (2) 3/8 X 7/8 SHOULDER BOLTS, BOTH WITH GEAR TEETH BY SHOULDER BOLT HEAD. ADD AN OILITE WASHER (PRW229) RACK 9 ONTO SHOULDER BOLT. THREAD THE BOTTOM GEAR FIRST, INTO LOWER PEM NUT AND MESH GEAR WITH LOWER RUBBER ROLL GEAR. **THE OILITE WASHER MUST RIDE ON THE SHOULDER BOLT AND NOT BE PINCHED BETWEEN SHOULDER BOLT AND SIDE PANEL. SECURE TOP GEAR INTO TOP PEM NUT.



OILITE WASHER

- 3) SLIDE AN 18 TOOTH 25B18 SPROCKET (PRS249) LD13 HUB INWARD, ON THE BOTTOM RUBBER ROLL SHAFT, SNUG TO GEAR. SECURE SPROCKET ON FLAT OF JOURNAL WITH SET SCREW.



PEM NUTS

- 4) SLIDE A 21 TOOTH 25B21 SPROCKET (PRS253A) LD03 HUB INWARD, ONTO MOTOR SHAFT. ALIGN SPROCKETS WITH STRAIGHT EDGE. TIGHTEN 10-32 X 3/8 SET SCREW ON FLAT OF MOTOR SHAFT.

4-28

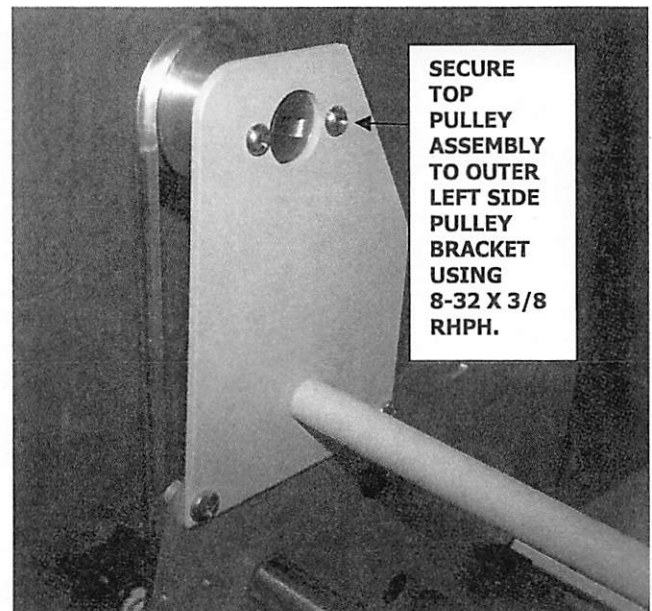
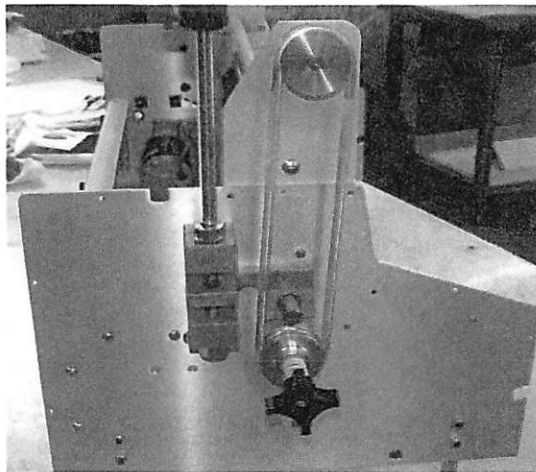
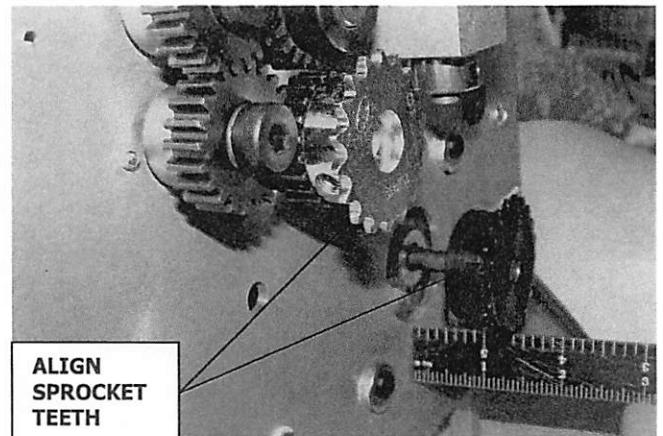
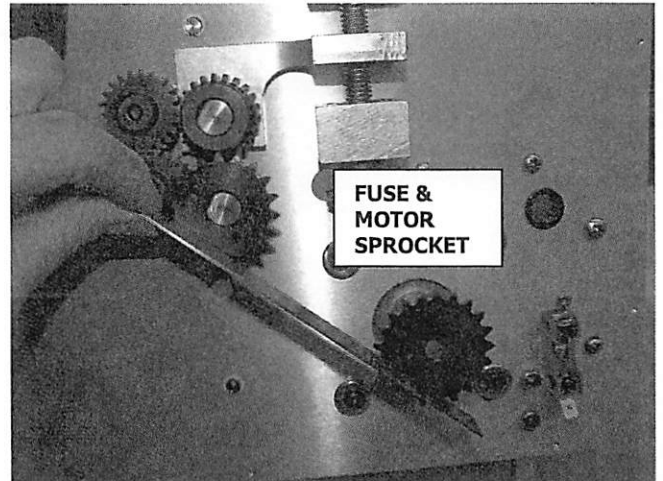
5) SECURE A FUSE HOLDER (PRF126) AS08 VERTICALLY, RIGHT OF MOTOR SPROCKET, USING A 6-32 X 1/4 PH.

6) INSERT A 3/4 (.75) AMP FUSE (PRF141) LD02 INTO FUSE HOLDER.

7) ON OUTER LEFT REWIND BRACKET SECURE THE TOP PULLEY ASSEMBLY USING (2) 8-32 X 3/8 RH.

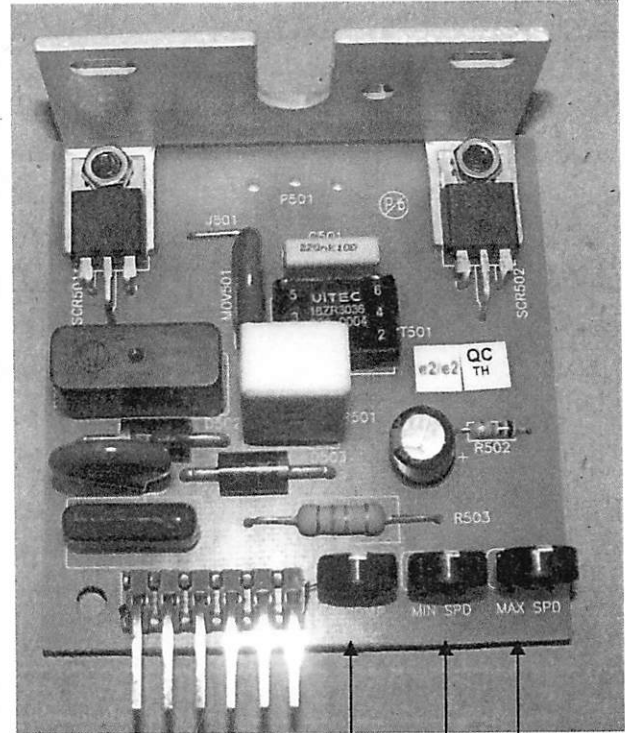
8) SLIDE REWIND CLUTCH ASSEMBLY ONTO LEFT SIDE BOTTOM RUBBER ROLL SHAFT. ALIGN PULLEYS AND SECURE REWIND CLUTCH TO JOURNAL USING 10-32 X 1/4 SS.

9) PLACE AN O-RING (PRR2391) RACK 9 OVER CHANNELS IN TOP AND BOTTOM PULLEYS. TEST MOVEMENT.

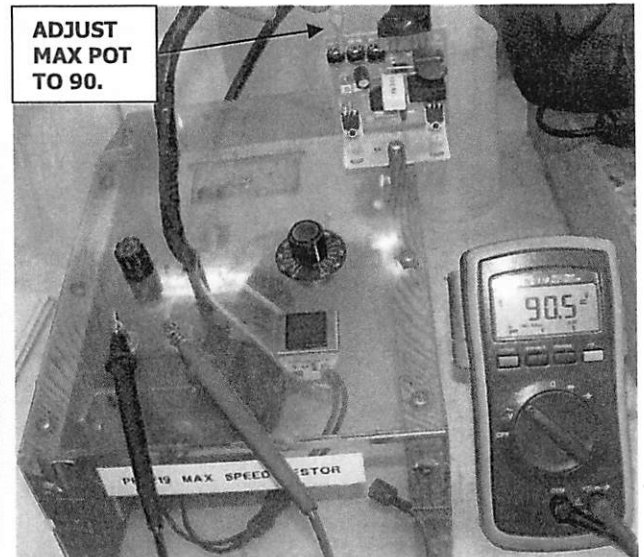
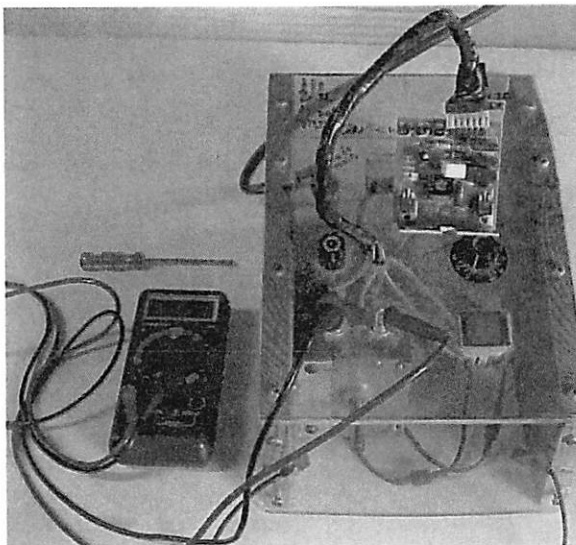


SETTING MINARIK SPEED CONTROL

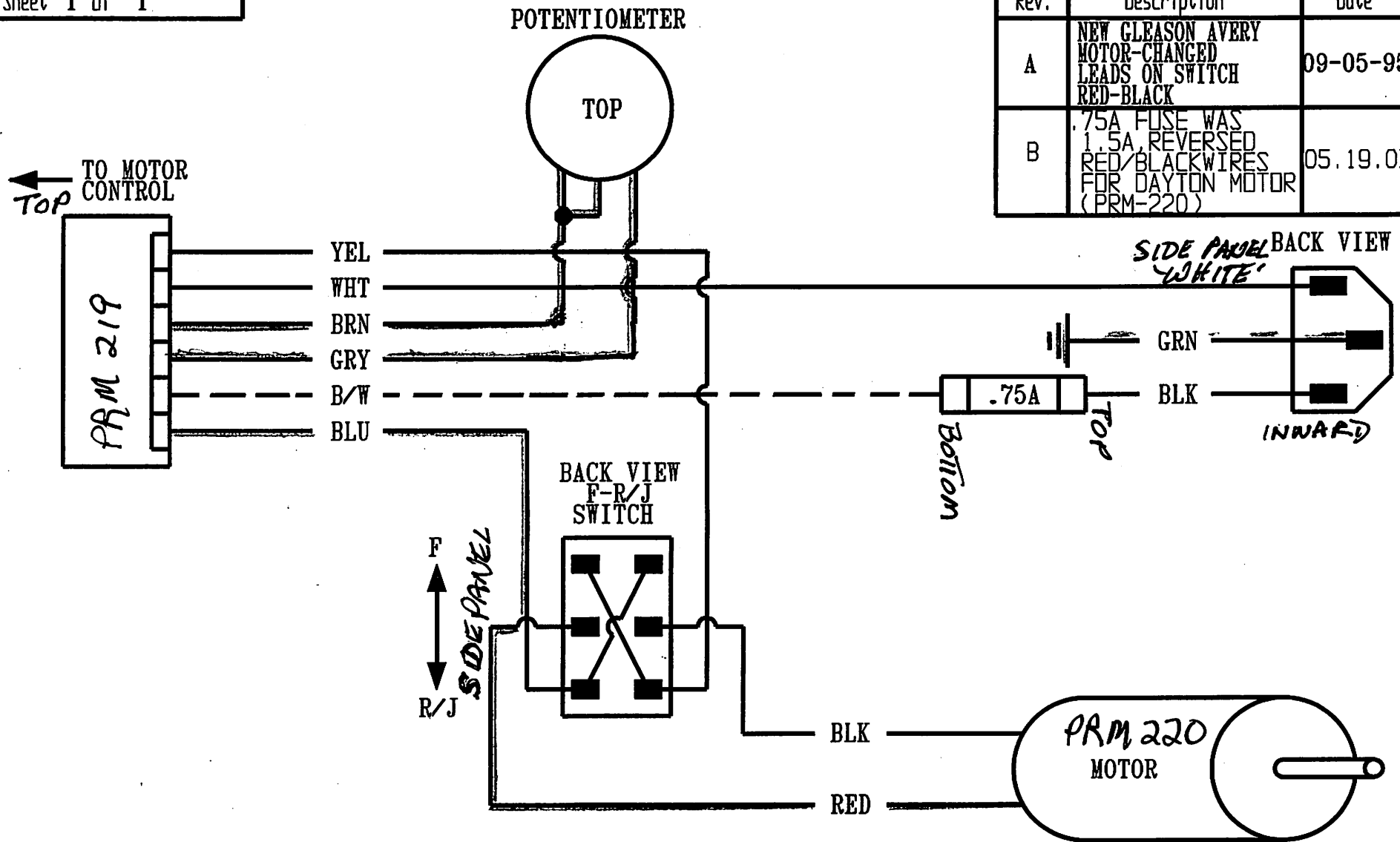
- 1) PLUG "IN HOUSE" SPEED CONTROL TESTER WB09 INTO 110 VOLT OUTLET.
- 2) ATTACH NEGATIVE AND POSITIVE TEST LEADS BETWEEN MULTIMETER AND THE TESTER CORRESPONDING SPRINGS.
- 3) CONNECT TESTER MOLOX TO SPEED CONTROL BOARD (PRM219) AS08 TERMINALS, *EITHER WAY*. TURN MULTIMETER TO DIRECT CURRENT AND TESTER CONTROL DIAL TO LOWEST "0" READING. DEPRESS "ON" BUTTON (RED LIGHT GOES OUT). TURN CONTROL DIAL TO MAXIMUM "100" READING. THE OPTIMUM SETTING IS 90.0: WITH TOGGLE STICK REDUCE MINIMUM SPEED POT AS LOW AS IT WILL GO. SET MAXIMUM SPEED POT READING 90. TOUCHY BOARDS CAN PASS AT 90.3



IR COMP ~ MIN SPD ~ MAX SPD



Rev.	Description	Date	App. By
A	NEW GLEASON AVERY MOTOR-CHANGED LEADS ON SWITCH RED-BLACK	09-05-95	KRW
B	.75A FUSE WAS 1.5A, REVERSED RED/BLACK WIRES FOR DAYTON MOTOR (PRM-220)	05.19.03	RCM



Tolerances Unless Otherwise Specified

Basic Dimension	UP TO 6.000	6.000 TO 24.000	ABOVE 24.000	$\pm 0^\circ \pm 10'$
2 Place Din.	$\pm .005$	$\pm .010$	$\pm .031$	✓
3 Place Din.	$\pm .002$	$\pm .005$	$\pm .010$	

Finish Specs:

LEDCO INC.

4265 N. Main St., Henlock N.Y. 14466
Ph # 585-367-2392 Fax # 585-367-2978

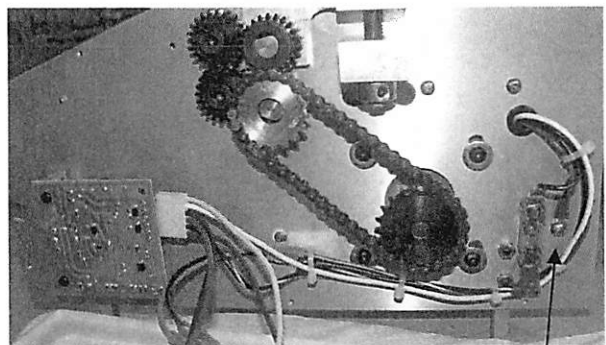
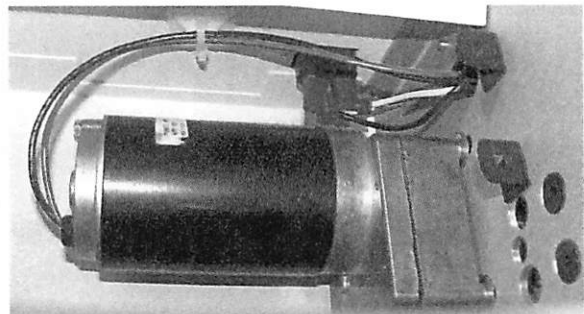
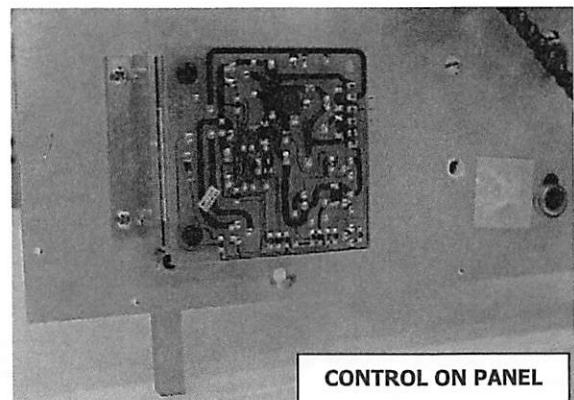
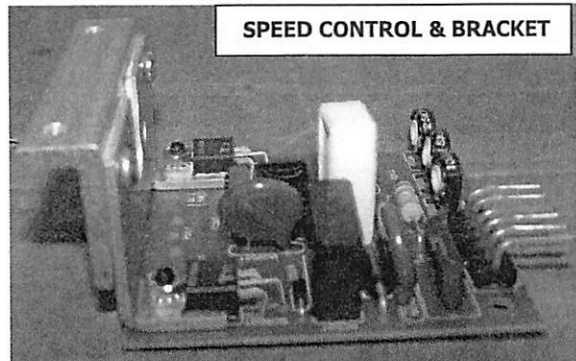
Material Specs:

Drawn By: KEITH R. WOERNER App. By

Date

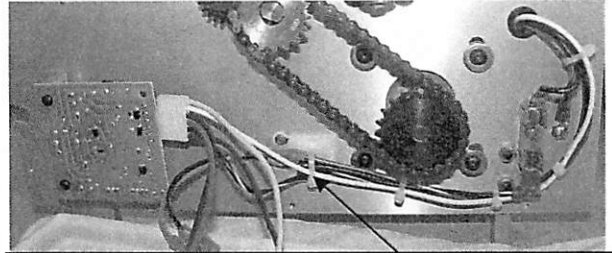
PRE-MASK TAPE APPLICATOR WIRING 2013

- 1) CUT #25 CHAIN CCT FOR MOTOR MEASURING JR PLUS ONE LINK. FROM AS07 CONNECT (1) CONNECTING LINK (PRC084), AN OFFSET LINK (PRC085) AND SECURE CHAIN ON SPROCKET TEETH WITH ANOTHER CONNECTING LINK. LOOSEN MOTOR SCREWS, ADJUST CHAIN TENSION AND SECURE MOTOR.
- 2) ATTACH PRESET MINARIK SPEED CONTROL TO THE THREADED BREAK IN MOUNTING BRACKET (3285 170.4) RACK 9 USING (2) 6-32 X 1/4 PH.
- 3) ATTACH CONTROL BRACKET ASSEMBLY TO RIGHT SIDE PANEL WITH TERMINALS FACING THE REAR, USE (2) 6-32 X 1/4 PH.
- 4) FROM PRE-MASK HARNESS (PRW361) RACK 9 CONNECT THE MOLEX WIRES TO SPEED BOARD WITH THE YELLOW WIRE UPWARD. FROM BOARD: BLACK/WHITE WIRE CONNECTS TO LOWER FUSE TERMINAL POST. INSERT WHITE, OPEN ENDED WIRE THROUGH SNAP BUSHING. CRIMP A BLUE FLAG CONNECTOR ON IT. THE BROWN, GRAY, YELLOW AND BLUE WILL TERMINATE ON THE HOUSING.
- 5) WIRE CORD RECEPTACLE PANEL MOUNT (PRC117) AS07 ***BEFORE*** SECURING TO BACK COVER WITH 6-32 X 1/4 PH. TERMINATE OUTER RECEPTACLE POST (BY PANEL) WITH WHITE FROM BOARD. THE BLACK WIRE FROM HARNESS BAG CONNECTS TO INNER POST. THE GREEN GROUND CONNECTS TO LOWER POST.
- 6) EXIT BLACK RECEPTACLE WIRE AND GREEN GROUND WIRE THROUGH SNAP BUSHING. TERMINATE BLACK WIRE ON UPPER FUSE POST. GREEN GROUND WIRE CONNECTS RIGHT OF FUSE BY



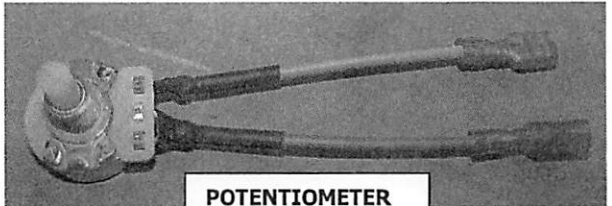
ADDING A #10 STAR WASHER TO THE LOWER BACK COVER BRACKET PH SCREW.

- 7) EXIT THE RED AND BLACK MOTOR WIRES THROUGH THE SNAP BUSHING. FROM THE BAG CONNECT THE RED AND BLACK WIRES WITH BUTT CONNECTORS TO THE RED AND BLACK MOTOR WIRES. MOTOR WIRES LATER TERMINATE ON THE FORWARD/REVERSE SWITCH.



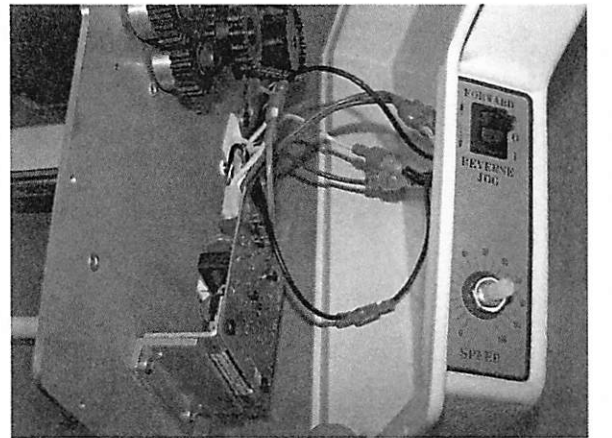
RED & BLACK MOTOR WIRES WITH BUTT CONNECTS

- 8) WITH POTENTIOMETER STEM FACING YOU AND TERMINAL POSTS UPWARD, UNITE MIDDLE AND RIGHT POST. PLACE 3/4" INSULATION TUBING ON GRAY AND BROWN WIRES. SOLDER BROWN WIRE TO DOUBLE POSTS AND GRAY WIRE TO SINGLE POST. SHRINK TUBING OVER SOLDERED POSTS AND CONNECTIONS.

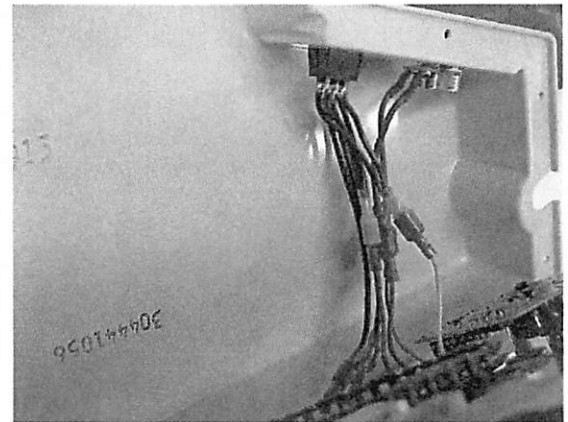


POTENTIOMETER

- 9) ON RIGHT HOUSING (EP25 094.4R) AS05 ADHERE PT-JR SWITCH LABEL (LAB02) RACK 9. INSERT HARNESS DRIVE SWITCH INTO HOUSING, PRINTING OUTWARD. BEND OFF POTENTIOMETER TAB, ADD A 3/8 FLAT WASHER ON STEM AND INSERT INTO HOUSING, WITH WIRES UPWARD. SECURE TO OUTER HOUSING WITH TOOTHED WASHER AND HEX NUT. ADD ROUND KNOB (PRK180) LD05 ON STEM.

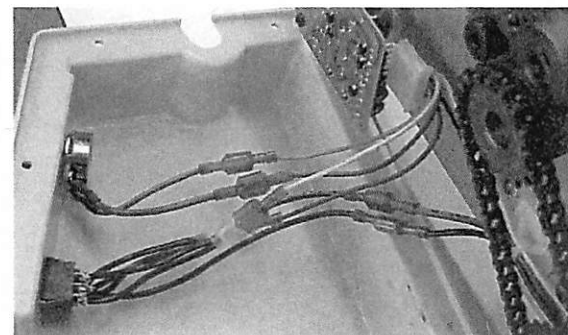


- 10) FROM MOTOR: CONNECT RED WIRE TO INNER MIDDLE FORWARD/REVERSE AND BLACK WIRE TO OUTER MIDDLE F/R. CONNECT BOARD: YELLOW WIRE TO INNER FRONT, OUTER BACK PAIR AND BLUE WIRE TO INNER REAR, OUTER FRONT PAIR ON FORWARD/REVERSE. CONNECT SPEED WIRES BROWN TO BROWN AND GRAY TO GRAY.



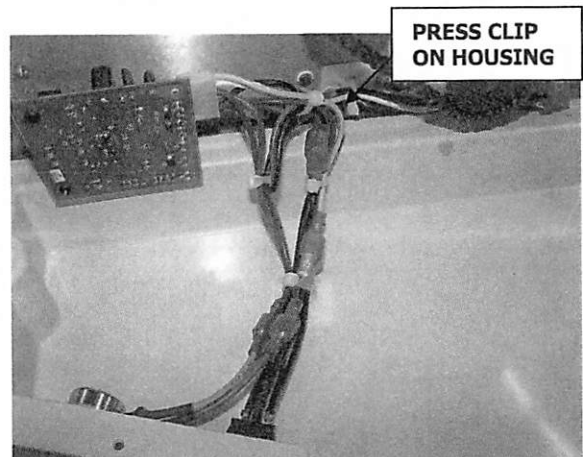
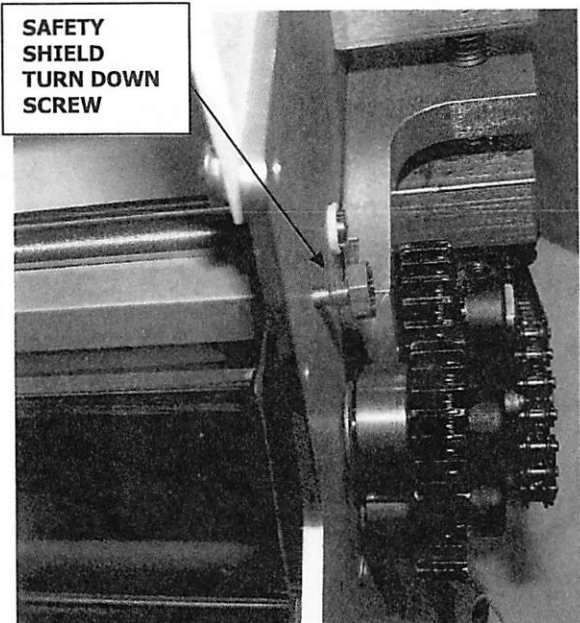
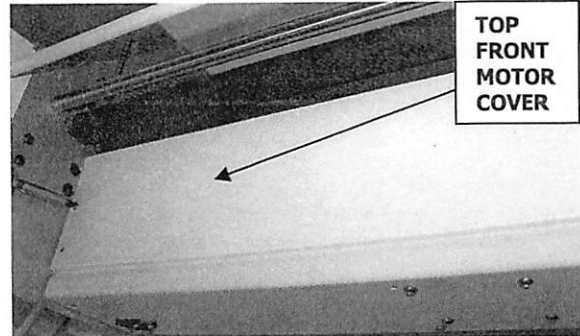
- 11) WITH SWITCH OFF, SPEED DOWN INSERT REMOVABLE CORD (PRC118) LD05. PLUG IN, TURN ON, TEST DIRECTION & SPEED.

- 12) OIL CHAIN AND GEARS, AVOID WIRES.

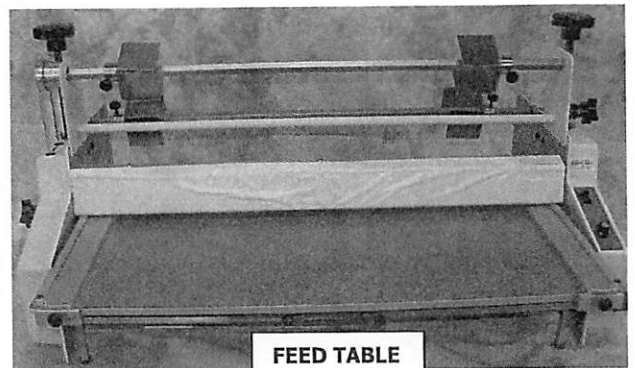
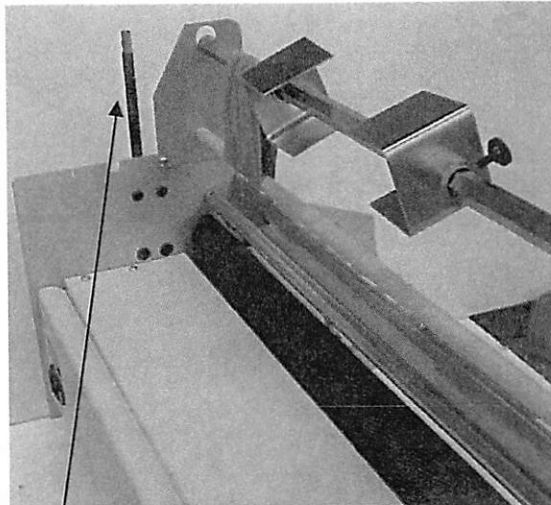
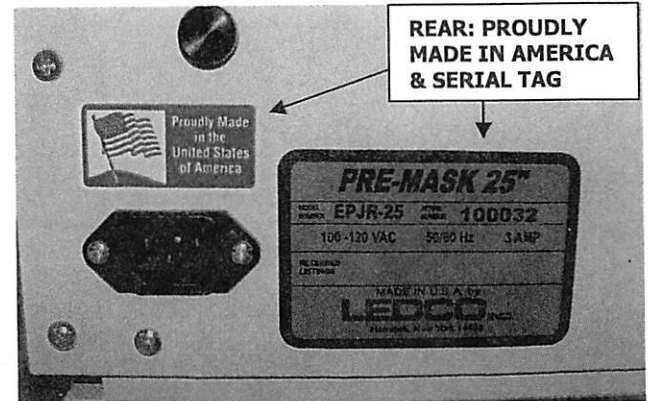
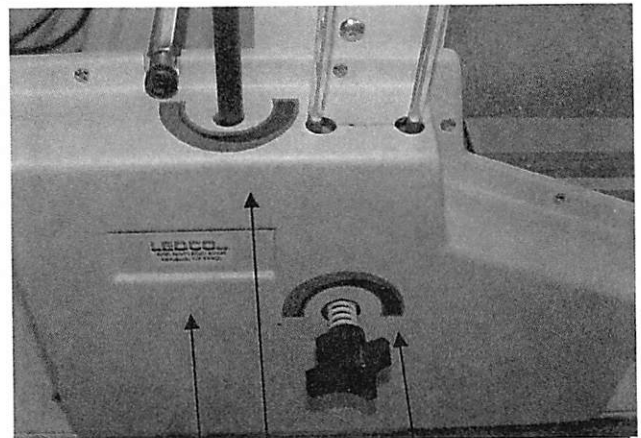
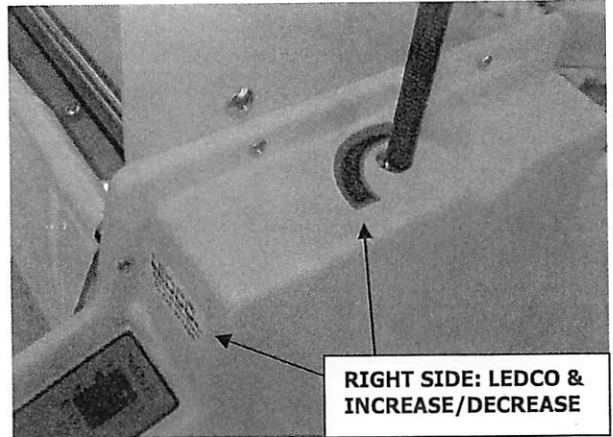


PRE-MASK TAPE APPLICATOR CHASSIS TRIM & LABELS 2013

- 1) FROM THE REAR, SLIDE TOP FRONT MOTOR COVER (EP 25 092.4TF) AS05 TO ALIGN OVER TINNERMAN BRACKETS AND BOTTOM MOTOR COVER. SECURE TOP WITH (4) 8 X 1/2 PH SMS AND BOTTOM WITH (3) 8 X 3/8 PH SMS.
- 2) SECURE SAFETY SHIELD IN FRONT OF TOP IDLER USING (2) LDM TURN DOWN SCREWS (PRS281) RACK 9, WITH LOWER SAFETY SHIELD RESTING ON SPRING PINS. TIGHTEN WITH NUT DRIVER.
- 3) ON LEFT HOUSING (EP25 094.4L) AS05 ADHERE SMALL LEDCO LABEL (LAB04) RACK 9 CENTERED IN SIDE HOUSING RECESS. ADHERE DECREASE/INCREASE LABEL (LAB41A) RACK 9 CENTERED ABOVE REWIND CLUTCH OPENING.
- 4) REMOVE REWIND CLUTCH KNOB. PULL O-RING THROUGH UPPER OPENINGS IN LEFT HOUSING. SLIDE OVER TENSION ROD, PLACE O-RING IN LOWER PULLEY CHANNEL AND UPPER PULLEY CHANNEL. REPLACE CLUTCH KNOB. SECURE HOUSING WITH (11) 6-32 X 3/16 PH.
- 5) SLOWLY SLIDE UPPER RIGHT HOUSING OVER TENSION ROD. ARRANGE WIRES TO FIT AWAY FROM CHAIN AND GEARS.
- 6) TIE AND ADHERE HOUSING WIRES TO AVOID INTERFERING WITH SPEED BOARD OR MOVING CHAIN. ATTACH RIGHT HOUSING WITH 6-32 X 3/16 PH.
- 7) SLIDE 4 7/8" OF 3/8" INSULATION TUBING (PRI164) AS09 OVER BOTH TENSION ADJUSTMENT RODS, SNUG TO SAFT COLLAR. HEAT SHRINK TUBING.
- 8) SECURE CAM SHAFT KNOB (PRK175) LD05 TO UPPER TENSION ROD, USING A 1/4-20 X 3/8 SET SCREW.

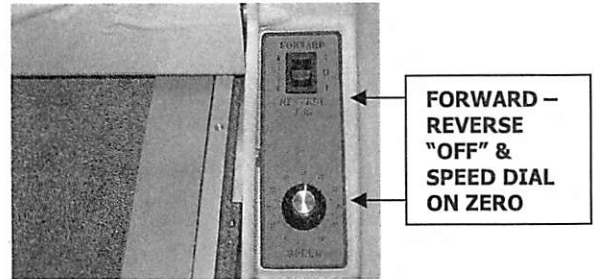


- 9) ADHERE A LEDCO LABEL (LAB04) RACK 9 ABOVE SWITCH LABEL ON RIGHT HOUSING. TRIM INCREASE/DECREASE LABEL (LAB042A) RACK 10 TO FIT BY TENSION ROD, ADHERING THE INCREASE PART TO THE FRONT, TOP HOUSING AROUND ROD. ADHERE FULL INC/DEC LABEL (LAB042A) TO LEFT HOUSING BY TENSION ROD.
- 10) PLACE CHASSIS ON ITS BACK AND SECURE (4) RUBBER FEET (PRR226) RACK 9 TO LEG THREADS WITH (4) 6-32 X 3/8 TH. RETURN TO UPRIGHT POSITON.
- 11) INSERT FEED TABLE TO ASSURE FIT.
- 12) ATTACH SERIAL TAG LABEL WITH JOB RIGHT OF RECEPTACLE AND "MADE IN AMERICA" LABEL (XS33) RACK 7 CENTERED ABOVE RECEPTACLE.

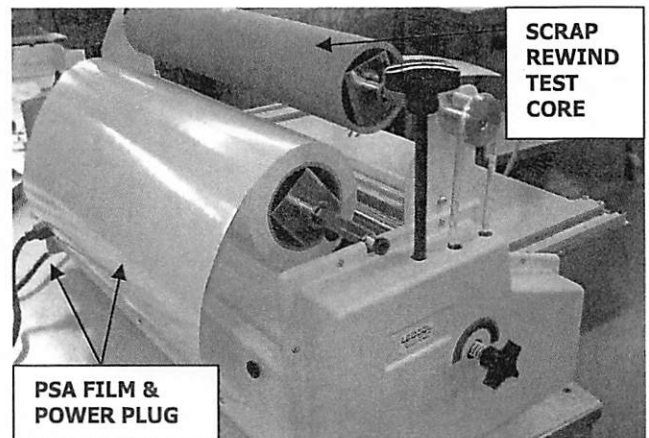


PRE-MASK TAPE APPLICATOR TESTING 2013

- 1) SET THE SPEED KNOB ON "ZERO" AND FORWARD/REVERSE SWITCH IN "OFF" POSITION. PLUG REMOVABLE CORD (PRC118) LD05 INTO PRE-MASK RECEPTACLE AND 110V POWER SOURCE.

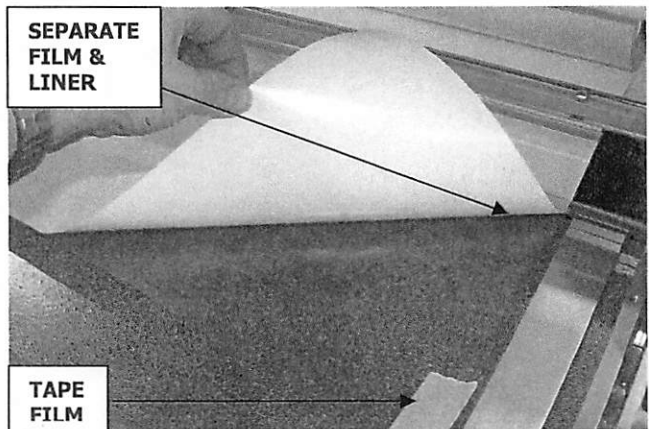


- 2) PLACE TEST CORE ON SCRAP REWIND AND CENTER WITH GRIPPERS. SECURE BETWEEN SCRAP REWIND BRACKETS.



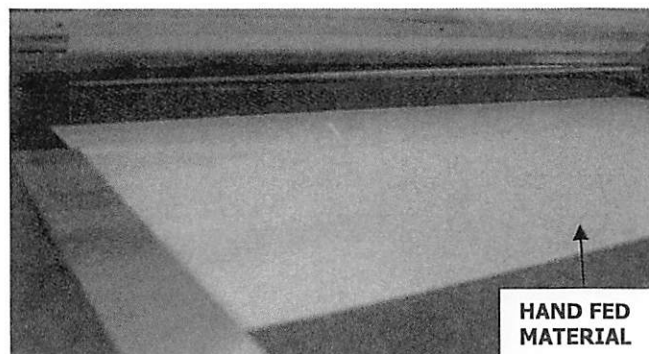
- 3) LOAD PRESSURE SENSITIVE FILM ON TOP SUPPLY ROLL; FILM FALLS TO THE REAR, SUPPLY ROLL KNOB ON THE RIGHT. THREAD FILM UNDER TOP IDLER, ONTO FEED TABLE. SEPARATE STICKY FILM FROM LINER. TAPE STICKY FILM TO FEED TABLE, TEMPORARILY. THREAD FILM LINER BACK UNDER SAFETY SHIELD AND UP TO REWIND CORE. TAPE LINER TO CORE IN FRONT.

- 4) INTRODUCE FEED BOARD (XS100) LD00 TO STICKY FILM AS EVENLY BY ROLLER NIP AS POSSIBLE. ADVANCE SLOWLY THROUGH ROLLERS.



- 5) ADD MATERIAL TO BE LAMINATED, EITHER HAND FED OR FROM BOTTOM SUPPLY ROLL, TO STICKY SIDE OF FILM AS CLOSE TO FEED BOARD AS POSSIBLE.

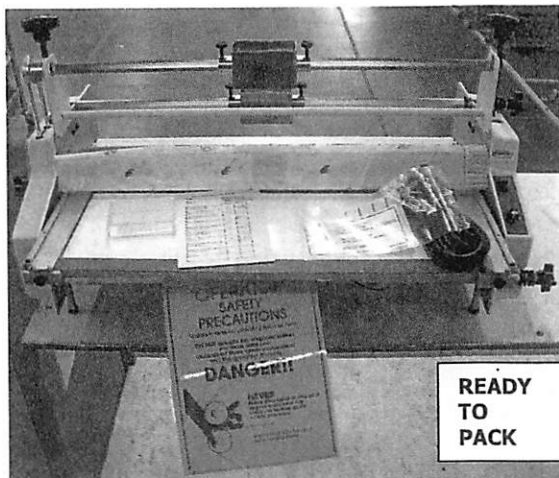
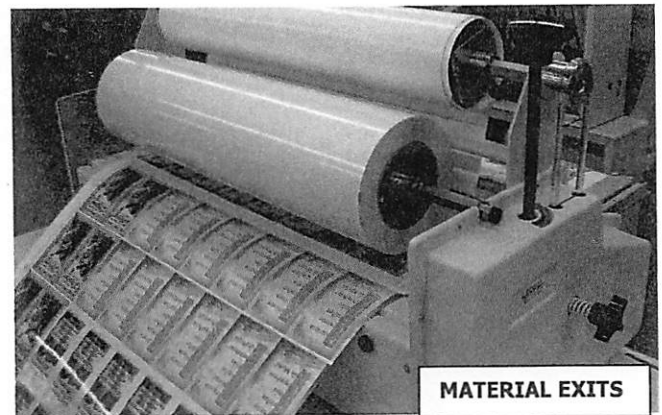
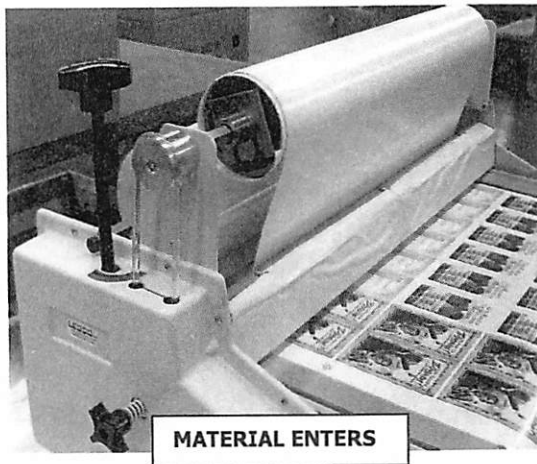
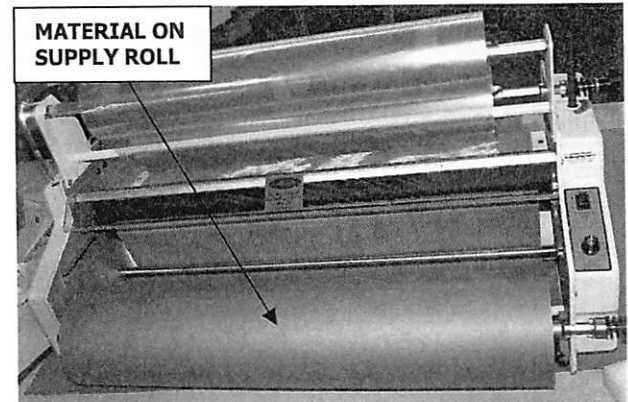
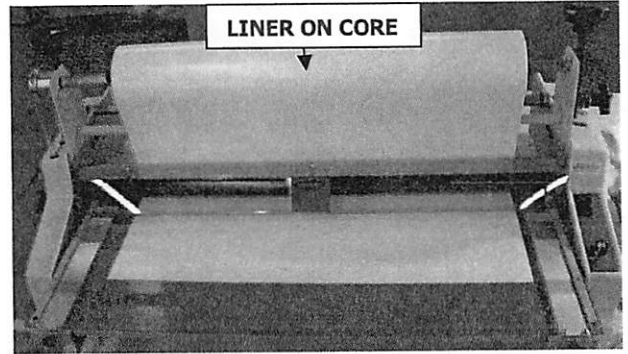
- 6) SLOWLY ADVANCE MATERIAL THROUGH RUBBER ROLLS. ADJUST THE CLUTCH TENSION FOR FILM SEPARATION AT THE IDLER TUBE. ADJUST SUPPLY ROLL TENSION FOR SIDE WRINKLES AND ADJUST RIGHT/LEFT TENSIONING ADJ. RODS TO STRAIGHTEN MATERIAL.



- 7) GIVE MATERIAL TIME TO SMOOTH OUT BY STOPPING MACHINE AND CHECKING FRONT AND BACK, MAKING THESE

ADJUSTMENTS AND RESUMING LAMINATION.

- 8) **FILL OUT THE "FINAL TEST & INSPECTION CHECK LIST" AFTER PERFORMING THE HIGH POT TEST.**
- 9) **PREPARE A SPARE FUSE KIT BY INSERTING A $\frac{3}{4}$ (.75) AMP FUSE (PRF141) LD03 IN A SMALL BAG AND ADHERING A PRF141 LABEL LD04 ON THE BAG. INSERT A SPARE FUSE LABEL (LAB126) AS09 AND THE .75 AMP FUSE INTO A LARGER CLEAR BAG AND USE A CABLE TIE TO SECURE THE LARGER BAG WITH THE SPARE FUSE KIT TO A REMOVABLE POWER CORD.**
- 10) **PLACE PAPERWORK, POWER CORD, FUSE KIT AND FEED BOARD (XS100) LD00 ON FEEDTABLE. SECURE ORANGE OPERATOR SAFETY PRECAUTIONS (LIT010) AS05 TO LOWER STABILIZER WITH LANYARD.**



PRE-MASK TAPE APPLICATOR HIGH POT TESTING 2013

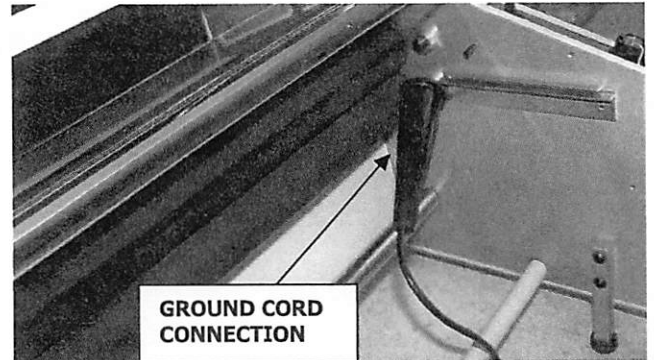
1) START TESTING PROCEDURES WITH ALL SWITCHES IN THE "OFF" POSITION.

2) CONNECT THE GROUND CORD FROM HIGH POT TESTING CART BETWEEN EP-25 PEM NUT BOLT THREADS ON INNER RIGHT SIDE PANEL, AND "RETURN" PORT ON THE HIGH POT.



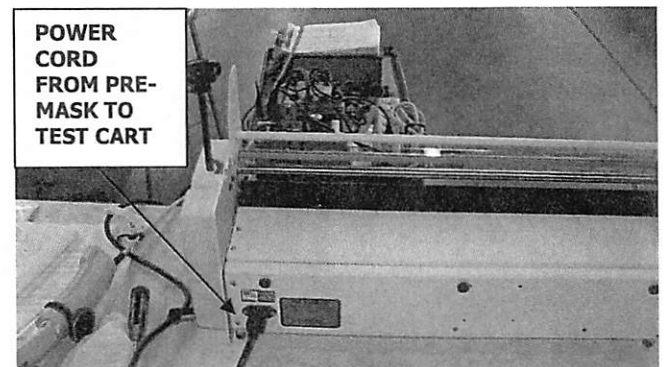
3) PLUG 110V POWER CORD BETWEEN EP-25 RECEPTACLE AND HIGH POT "HIGH VOLTAGE" INPUT.

4) CONNECT CORD ON POWER STRIP TO 110V POWER SOURCE.



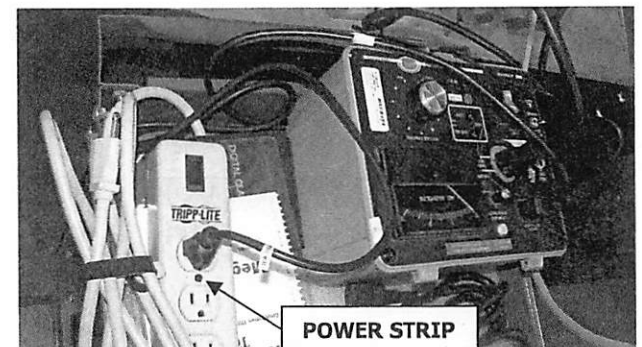
5) CONNECT "INPUT" CORD BETWEEN POWER STRIP AND HIGH POT.

6) TURN ON POWER STRIP SWITCH.

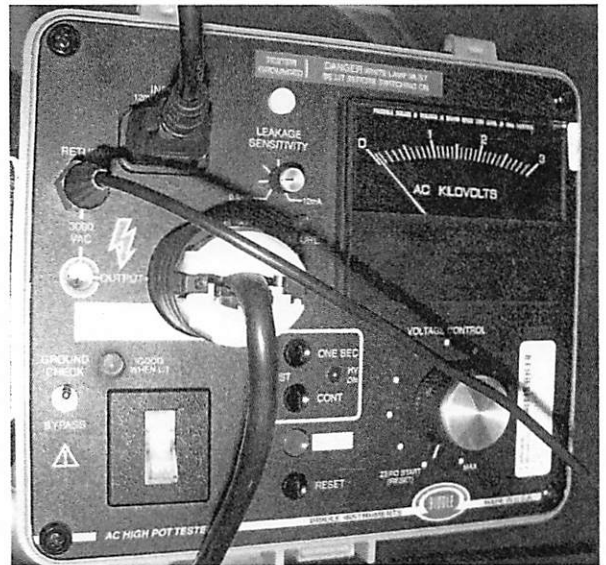


7) TURN ON HIGH POT "ON/OFF" SWITCH. THE SWITCH WILL LIGHT UP GREEN AND AN AMBER POWER LIGHT WILL COME ON.

8) WITH THE "GROUND CHECK" SWITCH UPWARD (NOT ON BYPASS) A "GOOD WHEN LIT" GREEN LIGHT WILL COME ON IF THERE IS A GOOD GROUND CONNECTION BETWEEN THE HIGH POT AND THE EP-25 PRE-MASK.



- 9) WITH THE "VOLTAGE CONTROL" DIAL ON ZERO, DEPRESS THE "CONT" TEST BUTTON. A RED TEST LIGHT COMES ON. INCREASE "VOLTAGE CONTROL" DIAL TO 1 1/2 AC KILOVOLTS AND HOLD THAT MARK FOR ONE SECOND, RETURN DIAL TO ZERO.
- 10) DEPRESS THE RED "HV OFF" BUTTON ON THE HIGH POT. TURN OFF HIGH POT POWER SWITCH. TURN OFF POWER STRIP SWITCH. UNPLUG POWER CORD.
- 11) THE HIGH POT TEST IS COMPLETE. DISCONNECT THE GROUND TEST CORD AND RETURN CORDS TO HIGH POT CART. RETURN HIGH POT CART TO LOFT 2 LOCATION.



HIGH POT TESTER

AC KILOVOLTS AT 1.5

