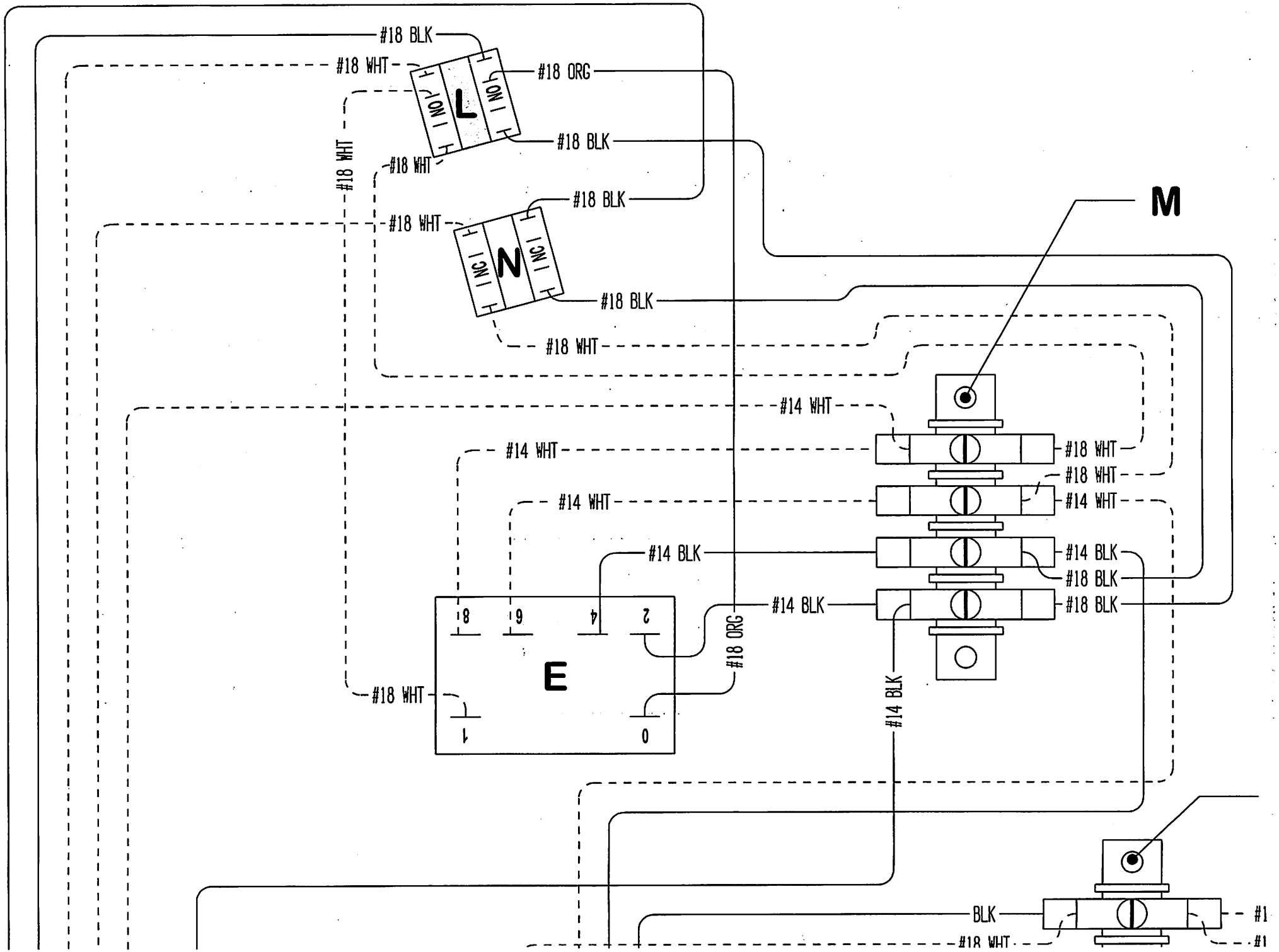
XL44
POUCH LAMINATOR
110V

15AMP

ASSEMBLY
PROCEDURES

APRIL 2002, UPDATED AUGUST 2008

NOVEMBER 1, 2016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XL44 POUCH 110V

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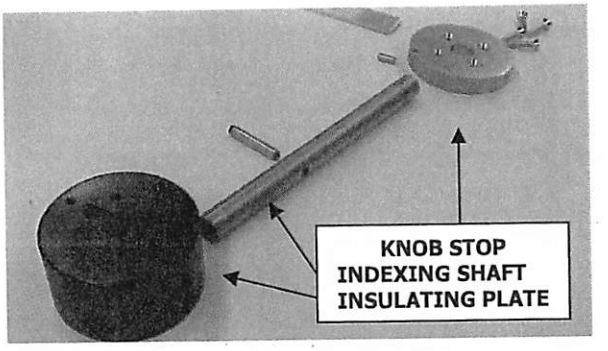
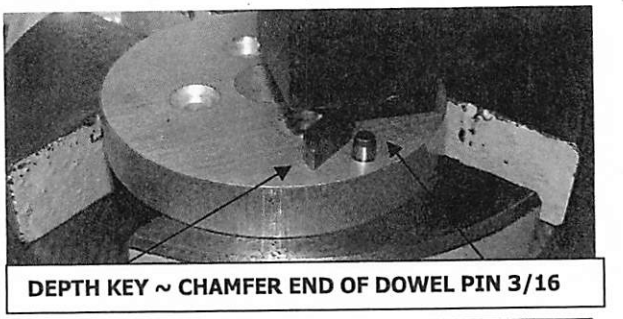
XL44 INDEXING HANDLE ASSEMBLY

1) *AS OF 2014* THE MACHINE SHIP WILL ARBOR PRESS A ¼ X 1 ½ DOWEL PIN EVENLY INTO INDEXING SHAFT (XL44 019.4) RACK 5. A VERY SNUG FIT.

2) ARBOR PRESS A 3/16 X ½ DOWEL PIN INTO KNOB STOP (XL44 018.4) RACK 5 *EXPOSED ON COUNTERSUNK SIDE, WITH UNDERCUT/CHAMFER SHOWING OUTWARD*. USE 3/16 KEY FOR DEPTH.

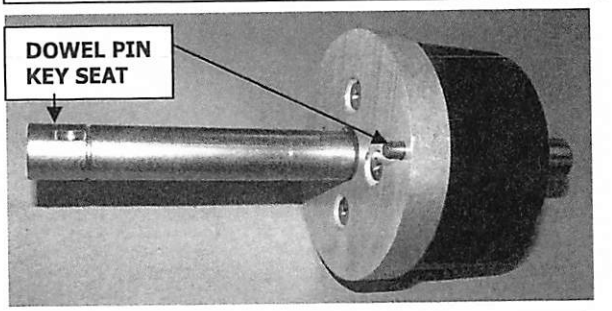


3) ASSEMBLE COMPONENTS PER DIAGRAM #2 AND #3. NOTE ORIENTATION OF WOODRUFF KEYSEAT TO 3/16" DOWEL PIN IS CRITICAL. CONNECT KNOB STOP TO HANDLE INSULATING PLATE (XL44 020.4A) RACK 5 WITH (4) 10-32 X 1 FH.



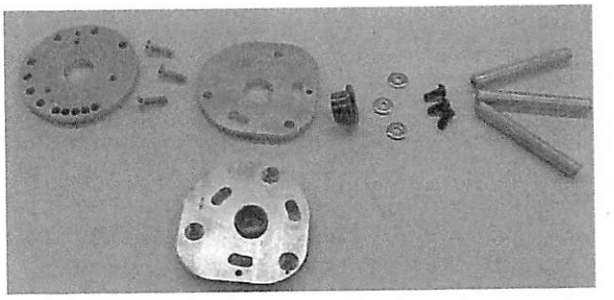
4) REFER TO 2ND ASSEMBLY DIAGRAM FOR THE FOLLOWING STEPS.

5) ARBOR PRESS OILITE BUSHING (PRB025) RACK 5 INTO INDEXING PLATE MOUNTING PLATE (XL44 016.5) RACK 5. *FLANGE POSITION OPPOSITE COUNTERSUNK SIDE*. REAM WITH .625.

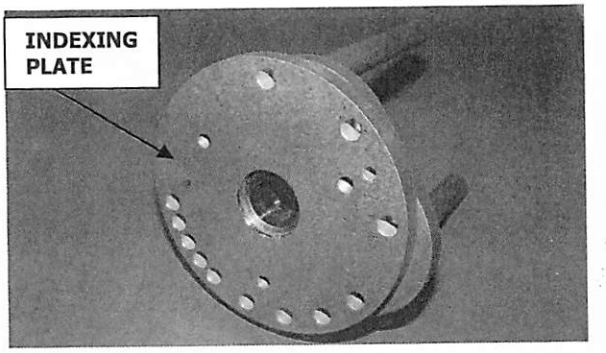


6) ATTACH (3) STANDOFFS (XL44 015.4) RACK 5 TO COUNTERSUNK HOLES ON INDEXING PLATE MOUNTING PLATE. USE LOCTITE ON (3) 10-32 X ¾ FH.

7) CHECK ORIENTATION AND SLIDE INDEXING PLATE (XL44 017.4) RACK 5 ONTO OILITE SHAFT IN INDEXING PLATE MOUNTING PLATE ASSEMBLY.



8) LIGHTLY SNUG (3) 10-32 X ½ BH EACH WITH A #10 WASHER INTO INDEXING PLATE, THEY WILL BE ADJUSTED LATER. NOTE THE ORIENTATION OF INDEXING PLATE TO MOUNTING PLATE IS CRITICAL. REFER TO DIAGRAM #2. HELPFUL HINT: INSERT A 1/8 X 2" DOWEL PIN THROUGH THE 1/8" HOLE IN THE MOUNTING PLATE (RIGHTHAND CENTER POSITION) AND THEN THROUGH THE 1/8" HOLE IN THE INDEXING PLATE. BHSH SCREWS WILL BE ADJUSTED AND TIGHTENED LATER.



9) REFER TO 3RD ASSEMBLY DIAGRAM FOR THE FOLLOWING STEPS.

10) PLACE (2) 5/8" SNAP RINGS (PRR196) RACK 19 IN INDEXING SHAFT GROOVES.

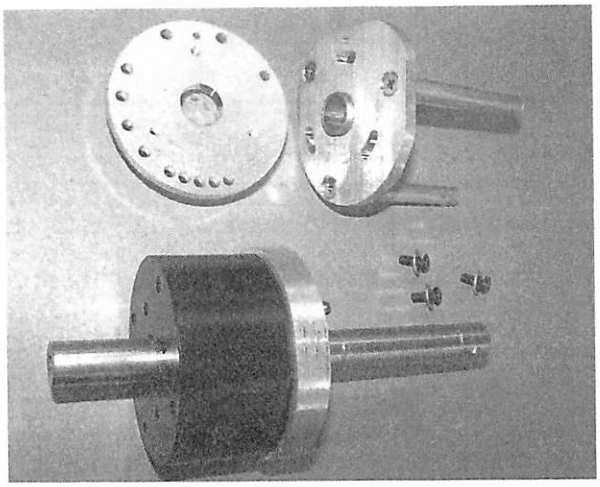
11) INSERT WOODRUFF KEY (.MI213) AS13 INTO KEYSEAT OF INDEXING SHAFT.

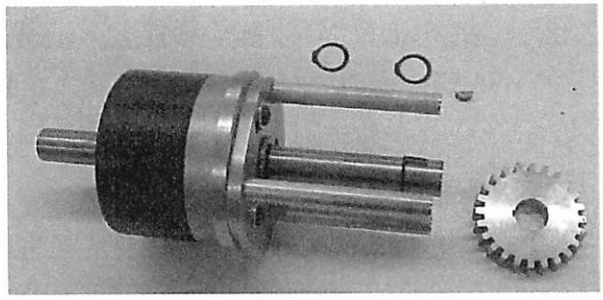
12) ADJUST ASSEMBLY SO INDEXING DOWEL (3/16 X ½ DOWEL PIN) IS INSERTED INTO SECOND INDEXING HOLE (COUNTERCLOCKWISE FROM LOWER LEFT OF HOLE PATTERN AS VIEWED FROM THE FRONT OF THE INDEXING PLATE).

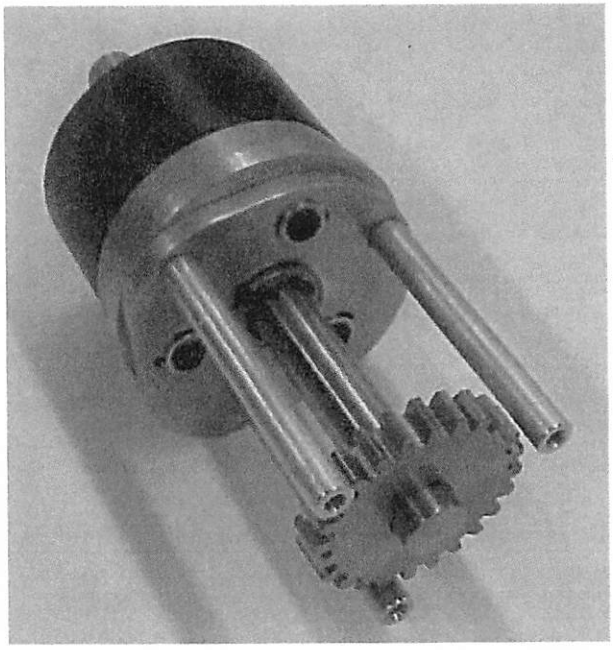
13) SLIDE 24 TOOTH SPUR GEAR (PRGO24T) RACK 5 OVER WOODRUFF KEY (MI213) AND SEAT AGAINST SNAP RING.

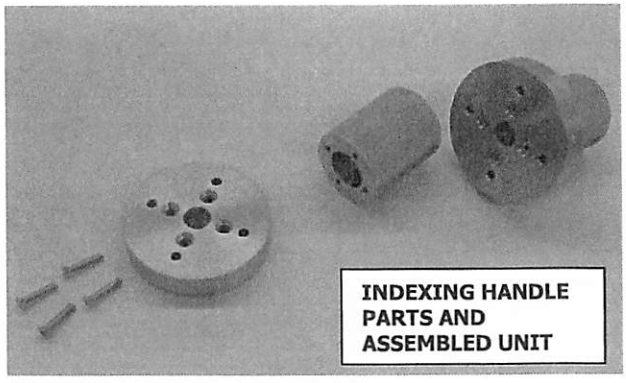
14) PREPARE INDEXING KNOB (XL44 020.4C) RACK 5 AND INDICATOR WHEEL (XL44 020.4B) RACK 5 CONNECTING WITH (4) 10-32 X 1 FH. USE LOCTITE.

15) PLACE BOTH SUB-ASSEMBLIES ASIDE UNTIL NEEDED.









INDEXING HANDLE PARTS AND ASSEMBLED UNIT

XL44 LEFT TRUNION

1) REFER TO DIAGRAM FOR COMPONENT ORIENTATION INFORMATION.

2) ARBOR PRESS ROLLER BEARING R1622 (PRB085) AS15 INTO BEARING CARRIER (XL44 042.4A) AS10. DO NOT TO DAMAGE THE SHEILDS ON THE BEARING FACES.

3) THREAD (2) ¼-28 HEX NUTS ONTO EACH OF (2) SPRING STUDS (XL44 045.4) AS10.

4) PLACE LOCTITE ON THE FIRST THREADS OF THE SPRING STUDS AND THREAD INTO THE BEARING CARRIER UNTIL IT SEATS AGAINST THE BALL BEARING. TIGHTEN WITH WRENCH.

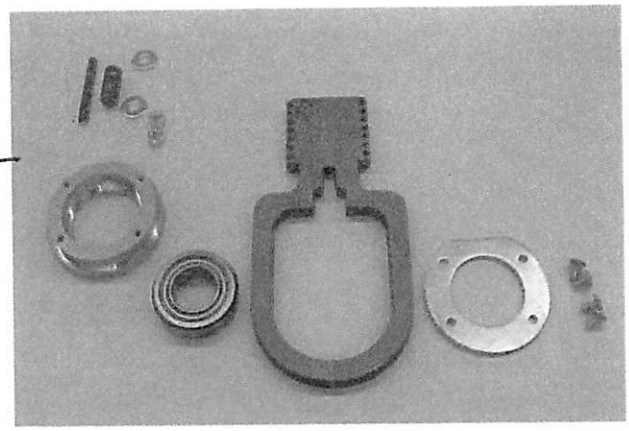
5) TIGHTEN THE LOWER HEX NUT AGAINST THE BEARING CARRIER UNTIL THE FLAT OF THE HEX NUT IS ALIGNED WITH THE SURFACE OF THE BEARING CARRIER.

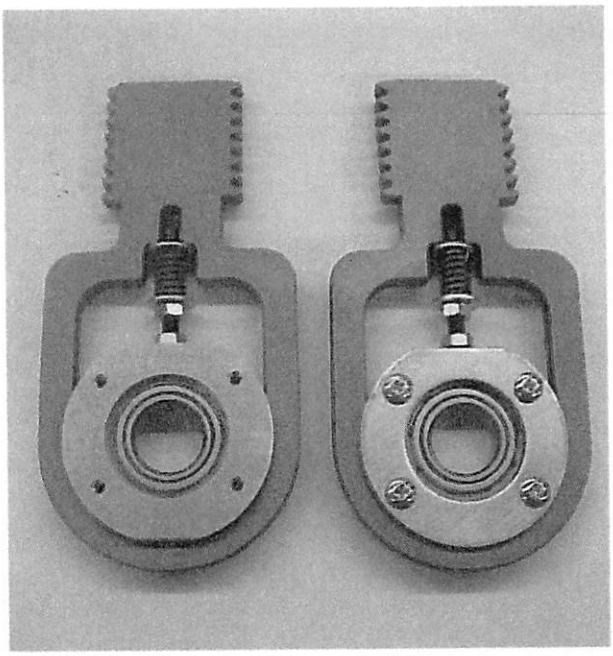
6) ASSEMBLE (1) ¼ FLAT WASHER SAE ONTO THE STUD AS SHOWN. ADD SUSPENSION SPRING (PRS060) AS10 AND SECOND FLAT WASHER.

7) INSERT BEARING CARRIER INTO TRUNION PLATE (XL44 041.4) AS07. POSITION OF TRUNION IS CRITICAL, *OFFSET FACES REAR OF MACHINE*. SEE DIAGRAM DETAIL"A" FOR CORRECT OFFSET PLACEMENT.

8) ATTACH BEARING RETAINER (XL44 042.4B) AS10 WITH (4) 10-32 3/8 TH.

9) ADJUST UPPER ¼-28 HEX NUT SO THAT ¾" SETTING EXISTS BETWEEN ¼ WASHERS. GAUGE SHOULD SLIDE BETWEEN WASHERS WITH SLIGHT DRAG.





ASSEMBLED TRUNION: LOWER UPPER TOOTH TOWARD REAR, SCREWS FACE INWARD

XL44 NRTL RIGHT TRUNION

1) REFER TO DIAGRAM FOR COMPONENT ORIENTATION INFORMATION.

2) ARBOR PRESS A ROLLER BEARING (PRB085) AS08 INTO BEARING CARRIER (XL44 042.4A) RACK 5. TAKE CARE NOT TO DAMAGE THE SHIELDS ON THE BEARING FACES.

3) THREAD (2) ¼-28 HEX NUTS EACH ONTO (2) SPRING STUDS (XL44 045.4) RACK 5.

4) PLACE A DROP OF LOCTITE ON THE FIRST THREADS OF THE STUDS AND THREAD INTO THE BEARING CARRIER UNTIL IT SEATS AGAINST THE BALL BEARING. TIGHTEN WITH WRENCH.

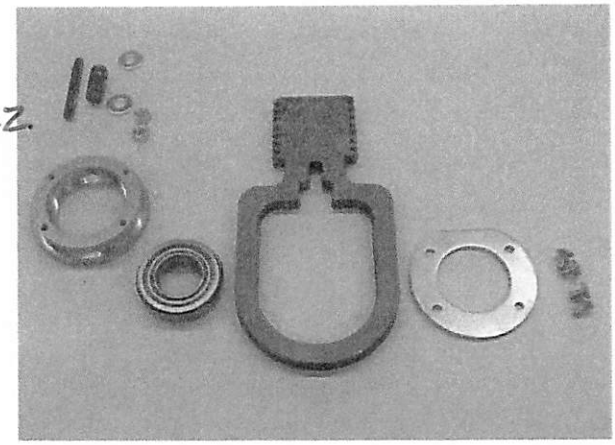
5) TIGHTEN THE LOWER HEX NUT AGAINST THE BEARING CARRIER UNTIL THE FLAT OF THE HEX NUT IS ALIGNED WITH THE SURFACE OF THE BEARING CARRIER.

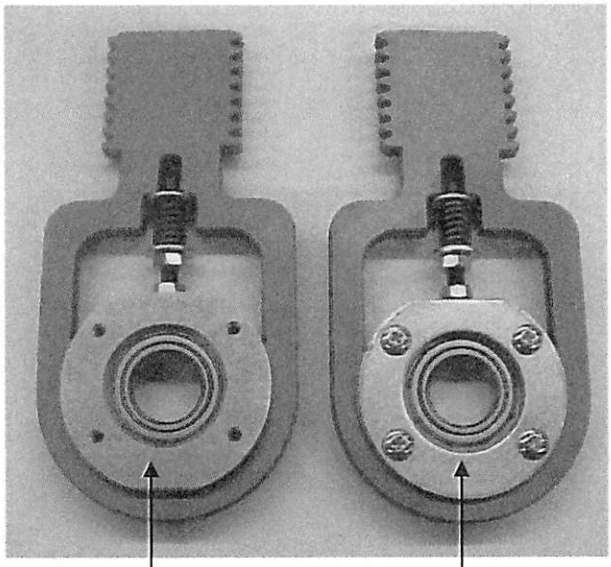
6) ASSEMBLE (1) ¼ FLAT WASHER SAE ONTO THE SPRING STUD AS SHOWN. ADD SUSPENSION SPRING (PRS060) RACK 5 AND A SECOND ¼ FLAT WASHER AS SHOWN IN DIAGRAM.

7) INSERT BEARING CARRIER INTO TRUNION PLATE (XL44 041.4) LOFT 1, AFTER ORIENTING THE UPPER TRUNION PORTION SO THE LOWER, OFFSET TRUNION TOOTH, WHICH IS CRITICAL, *FACES REAR OF MACHINE WHEN ASSEMBLED*. SEE DIAGRAM DETAIL "A" FOR CORRECT OFFSET PLACEMENT. THE OFFSET IS THE LOWER TOOTH.

8) ATTACH BEARING RETAINER (XL44 - 42.4B) RACK 5 TO BEARING CARRIER SECURING WITH (4) 10-32 X 3/8 TH.

9) ADJUST UPPER ¼-28 HEX NUT SO THAT A ¾" THICK SETTING GAUGE SLIDES BETWEEN ¼ WASHERS WITH SLIGHT DRAG.





XL44 LEFT SIDE PANEL

1) INSPECT LEFT SIDE PANEL (XL44 090.4L) LOFT 1. 110 VOLT SHOWN.

2) ARBOR PRESS (2) OILITE BEARINGS (PRB048B) RACK 8 INTO PANEL WITH FLANGES OUTWARD.

3) ATTACH A HEAT SHIELD PIVOT ANGLE (XL44 014.4) RACK 5 TO INNER SIDE PANEL, USE (2) 10-32 X ¼ PHMS.

4) ADHERE A RUBBER BUMPER (PRR266) RACK 5 ONTO PIVOT ANGLE.

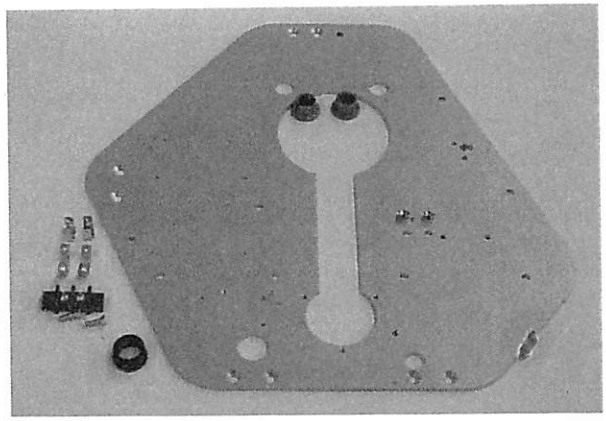
5) SNAP IN BUSHING (PRB064) AS07 FOR WIRING EXIT, FLANGE OUTWARD.

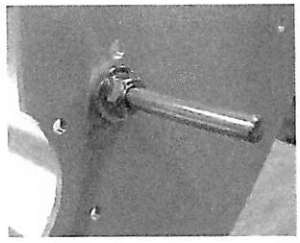
6) FROM RACK 5 PREPARE A TERMINAL BLOCK (PRT326) WITH (2) 180 DEGREE TERMINALS (PRT332), (2) 90 DEGREE TERMINALS (PRT334) AND (2) 45 DEGREE TERMINALS (PRT333). SECURE TO PANEL WITH (2) 8-32 X 5/8 FHMS.

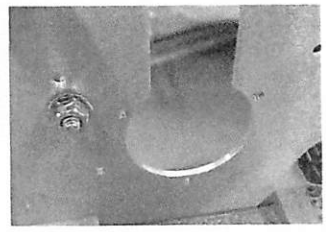
7) ADHERE AN INTERNATIONAL GROUND LABEL (LAB06) WB09, ABOVE REAR EXIT TABLE APERTURE.

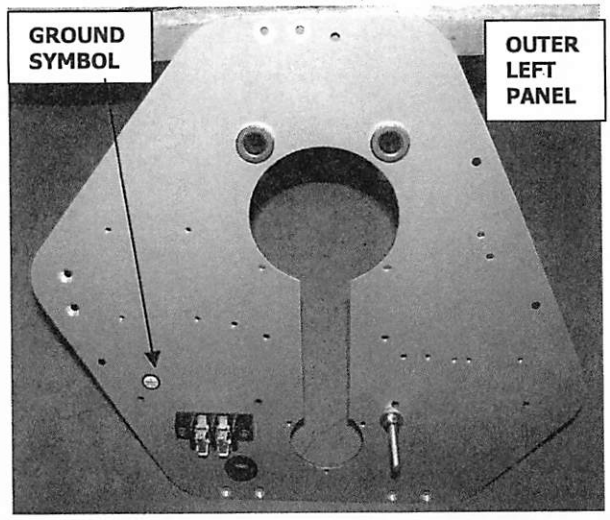
8) THREAD A 10-32 X ½ THMS FROM INSIDE BELOW DRIVE ROLL POSITION FLUSH WITH OUTSIDE. USE LOCTITE.

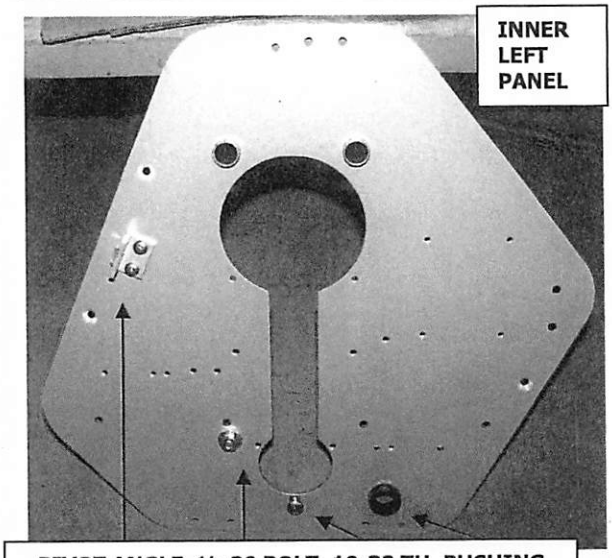
9) CUT HEAD OFF ¼-20 X 2 ½ HHCS BOLT AS13 AND SAND END. RUN ¼-20 HEX NUT TO END OF THREADS, ADD ¼ X 5/8 X 1/8 WASHER AND INSERT THREADS FROM OUTSIDE PANEL. PLACE ANOTHER WASHER AND HEX NUT ON INSIDE AND TIGHTEN BOTH WITH 7/16 WRENCH.



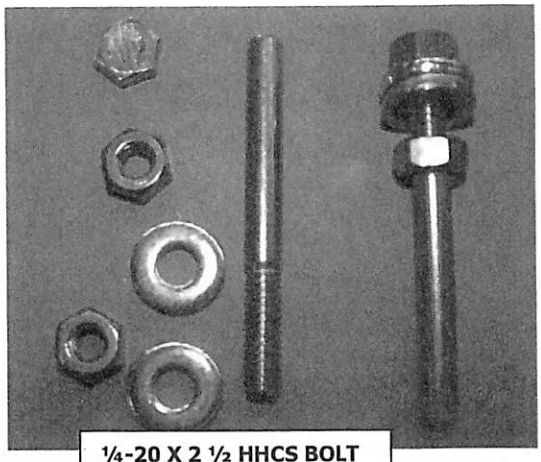








PIVOT ANGLE, ¼-20 BOLT, 10-32 TH, BUSHING



¼-20 X 2 ½ HHCS BOLT

XL44 RIGHT SIDE PANEL

1) INSPECT PANEL TO BE SURE YOU ARE WORKING WITH THE RIGHT SIDE PANEL (XL44 090.4R) LOFT 1.

2) ARBOR PRESS (2) OILITE BEARINGS (PRB048B) RACK 8 AND (1) WORKED OILITE BEARING (PRB026) RACK 5 INTO RIGHT SIDE PANEL SO FLANGES ARE FACING OUTWARD. BE CAREFUL NOT TO CRUSH THE BEARINGS.

3) USE A .625 REAMER AND TRIM (PRB026) BEARING.

4) FROM RACK 5 ASSEMBLE (2) TERMINAL BLOCKS (PRT326) WITH (4) 45 DEGREE TERMINALS (PRT333), (4) 90 DEGREE TERMINALS (PRT334) AND (1) 180 DEGREE TERMINAL (PRT332). LOCATE THE 180 DEGREE ON RIGHT SIDE OF RIGHT/REAR TERMINAL POST.

5) ATTACH TERMINAL BLOCKS TO SIDE PANEL WITH (4) 8-32 X 5/8 FHMS.

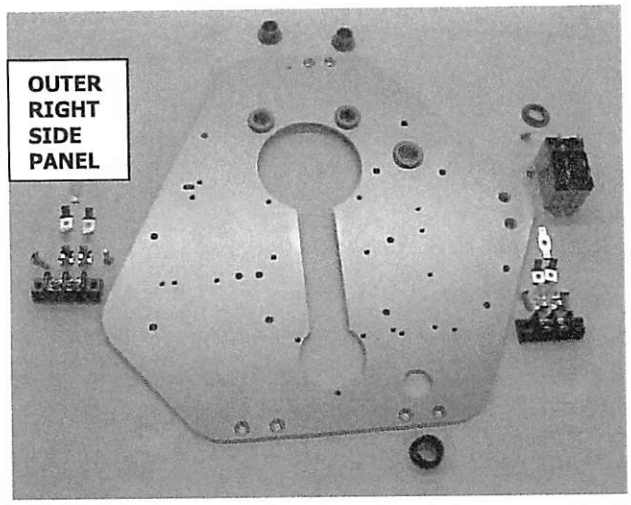
6) ATTACH 110V RELAY (PRR150) RACK 12 WITH DOUBLE POSTS TO THE REAR, USE (2) 8-32 X ¼ RHMS FOR 110 VOLT.

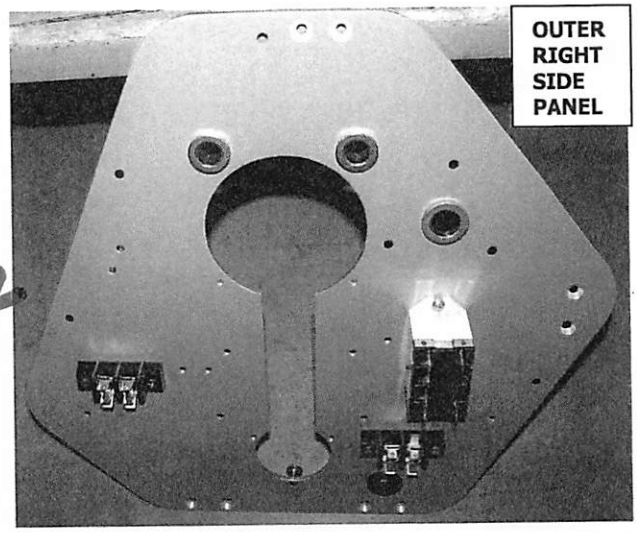
7) ON INNER PANEL ATTACH A HEAT SHIELD PIVOT ANGLE (XL44 014.4) RACK 5 WITH (2) 10-32 X ¼ PHMS FOR COVER REST.

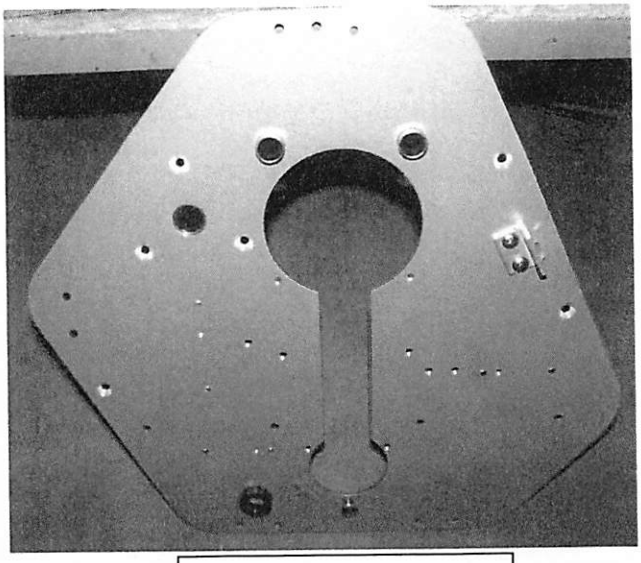
8) INSERT 10-32 X ½ THMS FROM INSIDE TO BOTTOM DRIVE ROLL POSITION FLUSH WITH OUTSIDE, USE LOCTITE.

9) INSERT SNAP BUSHING (PRB064) AS07 WITH FLANGE FACING OUTWARD.

10) STORE COMPLETED SIDE PANEL UNTIL NEEDED.







INNER RIGHT SIDE PANEL

XL44 110 VOLT LEFT AND RIGHT CONTROL PANELS

1) HOLD RIGHT CONTROL PANEL PLATE (XL44 048.4) RACK 5 WITH COUNTERSINKS FACING YOU AND STRAIGHT CORNERS TO THE LEFT. ATTACH (4) STANDOFFS (LC25 010.4) LD09 WITH (4) 4-40 X 3/8 FHMS.

2) ADHERE XL44 POUCH CONTROL PANEL DECAL (LAB46R) RACK 5. TRIM EDGES.

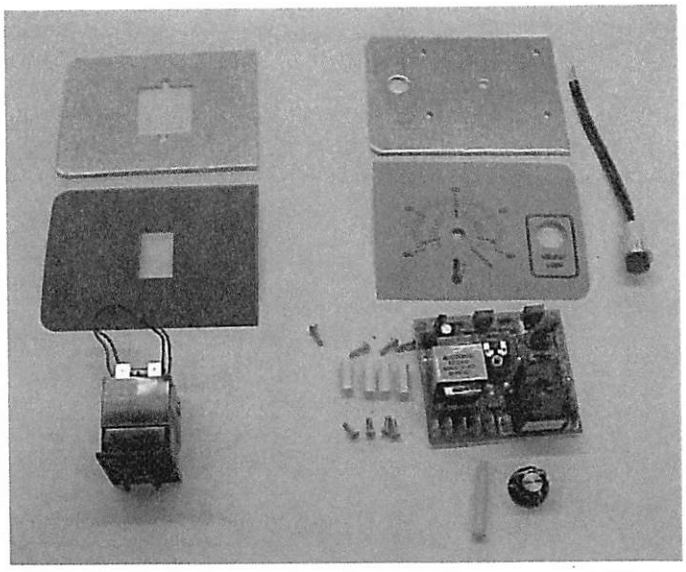
3) SNAP POTENTIOMETER STEM (PRC213A) RACK 5 INTO BACK OF TRAKSTAT CONTROL (PRC212) LD04. SECURE TRAKSTAT TO STANDOFFS ON PANEL PLATE WITH TERMINAL POSTS ON TOP, USE (4) 4-40 3/8 PHMS.

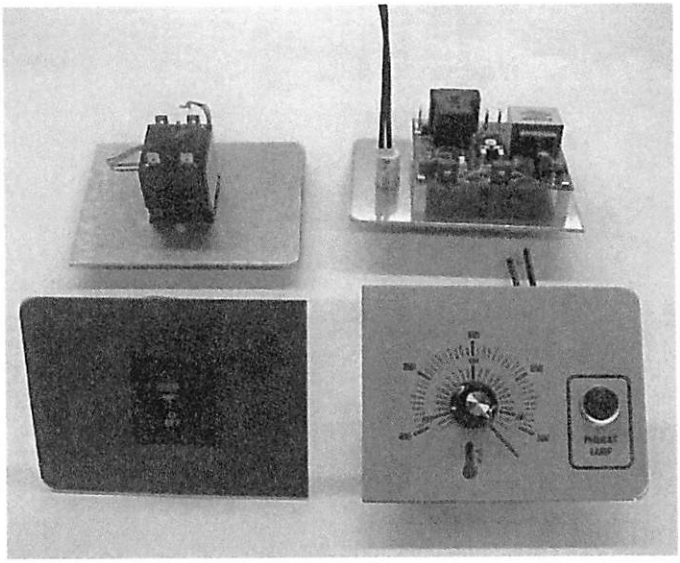
4) ATTACH ROUND KNOB (PRK180) LD05 TO POTENTIOMETER STEM, SET TO FIRST MARK ON RIGHT OF LABEL.

5) SNAP IN RED INDICATOR LIGHT (PRL194) LD01 AND CRIMP (2) QC FEMALE FASTONS (PRT331) ONTO WIRES. THE 220 VOLT MACHINES USE THE RED INDICATOR LIGHT (PRL199) LOFT 0.

6) ADHERE GREEN POUCH CONTROL PANEL DECAL (LAB46L) RACK 5 TO LEFT CONTROL PANEL PLATE (XL44 047.4B) RACK 5. TRIM SWITCH APERTURE.

7) WITH STRAIGHT CORNERS OF PANEL PLATE TO RIGHT, SNAP IN 15AMP SWITCH (PRS291) RACK 5 TO READ "ON/OFF". THE 220 VOLT MACHINES USE A 20 AMP BREAKER (PRS287) RACK 21 AND THE PANEL PLATE (XL44 047.4) RACK 5.





XL44 HOT ROLL: RED SENSOR 2015

1) REMOVE (4) SHCS FROM OPEN BORE END OF XL44 HOT ROLL (XL44 040.4A) LOFT 4. THIS JOURNAL HAS (3) 6-32 TAPPED THREADS AND A SENSOR OPENING.

2) CAREFULLY REMOVE JOURNAL FROM HOT ROLL BODY. USE PLASTIC MALLET IF NESSECARY.

3) INSERT HEATER (PRH181) LOFT 1 FOR 110 VOLT MACHINE AND RED SENSOR (PRC2121) LD00 INTO ROLL CORE AND SENSOR OPENING. ***WARNING: DO NOT FORCE THEM INTO THE BORE***. IF NESSECARY, CLEAN BORE WITH BORE SWAB TOOL. CHECK CARTRIDE HEATER FOR PROPER VOLTAGE BEFORE INSERTING. USE METER ON "OMS" TO TEST HEATER AT 200, SHOULD READ 10 AND SENSOR AT 2K, SHOULD READ 1.08. STAKE SENSOR AND HEATER. HEATER (PRH187) LOFT 1 IS FOR 220 VOLT.

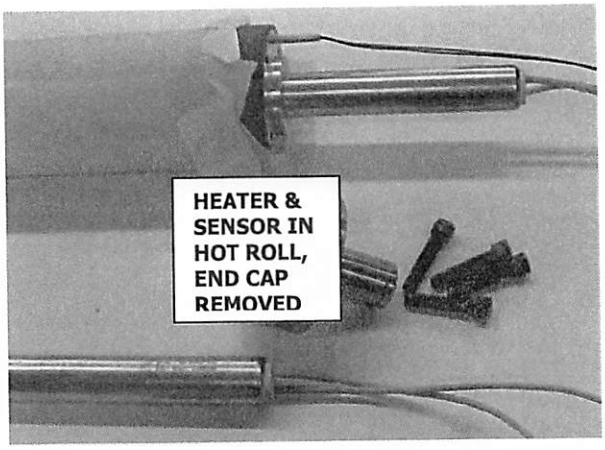
4) ADD LOCTITE SILICONE SEALANT CAB1 AROUND CERAMIC AREA OF HEAT CARTRIDGE, INCLUDING AROUND WIRES.

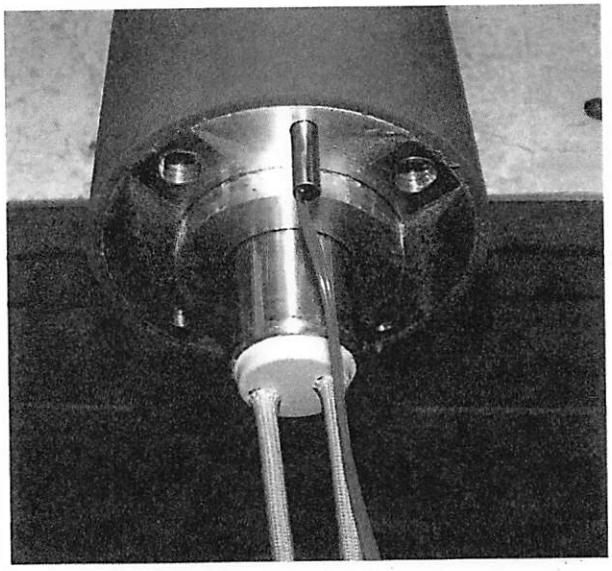
5) FROM CAB 1 PLACE 3" EACH OF 1/8" TUBING (PRI162) OVER SENSOR WIRES AND 3/16 (PRI165) OVER HEATER WIRES. SHRINK TUBING. COVER BUNDLE WITH 3" OF 3/8" TUBING (PRI164) AND SHRINK.

6) THREAD LEADS THROUGH JOURNAL BORE AND ALIGN WIRES INSIDE JOURNAL FACE TO CORRESPOND WITH SENSOR LEADS. REATTACH JOURNAL ONTO CORE USING 5/16-18 X 1 ¼ SHCS. ***WARNING: DO NOT PINCH THE LEADS AGAINST THE INSIDE OF THE ASSEMBLY.***

7) CAREFULLY TRIM LEADS 3 ½" LONG PAST THE END OF THE JOURNAL.

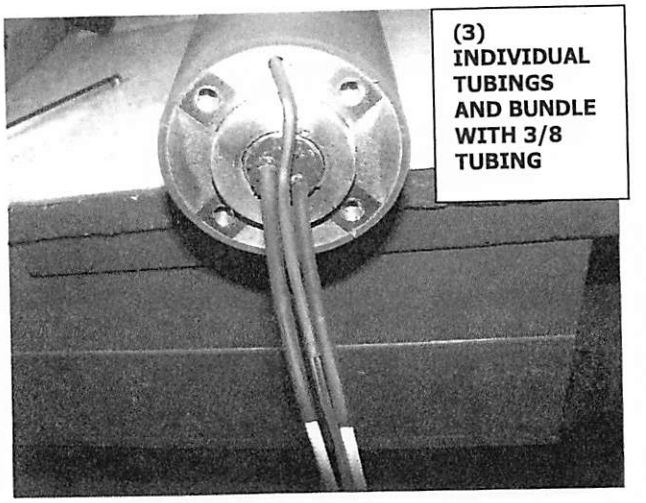
8) TERMINATE ALL FOUR LEADS AS SHOWN IN THE PHOTO, USING FEMALE FASTONS (PRT310) ON SENSOR WIRES AND (PRT284 FLAGS) ON HEATER WIRES. ***WARNING: GREAT CARE MUST BE TAKEN WHEN STRIPPING WIRES AND***

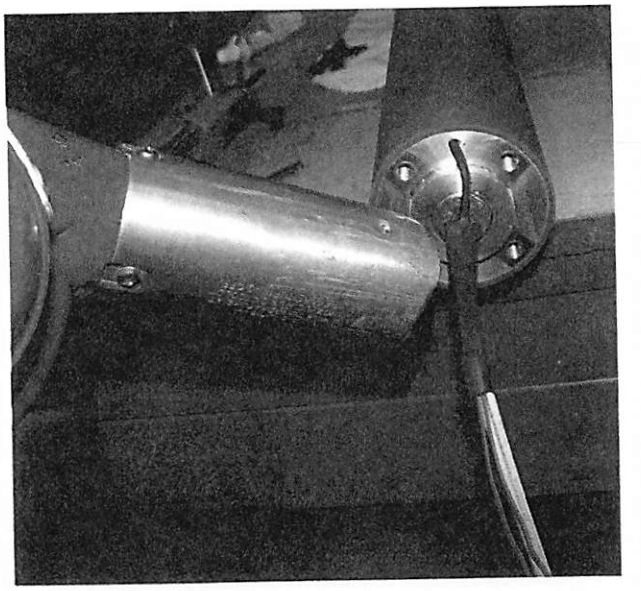


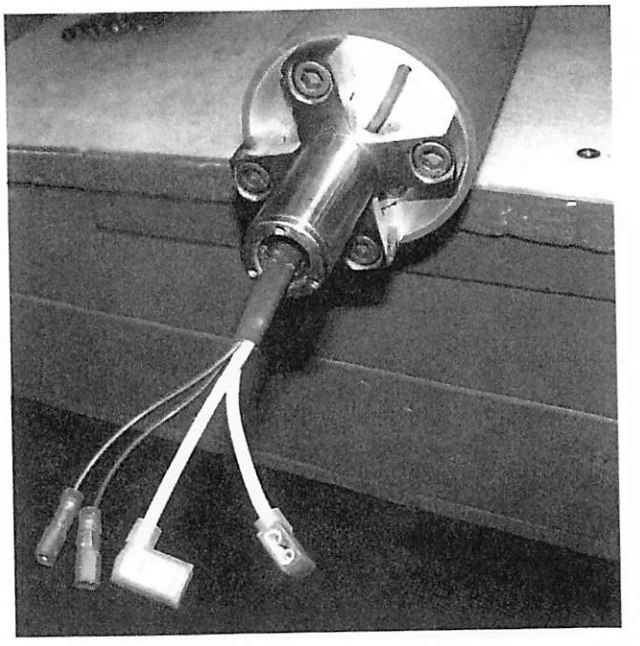


TERMINATING. IF CUT TO SHORT THE HEATER\|SENSOR WILL BE SCRAPPED. MAKE ABSOLUTELY SURE THAT ALL CRIMP CONNECTIONS ARE SECURE.

9) **STORE HOT ROLL SUB-ASSEMBLY SO AS NOT TO INCURR ANY DAMAGE UNTIL READY TO ASSEMBLE INTO MACHINE.**



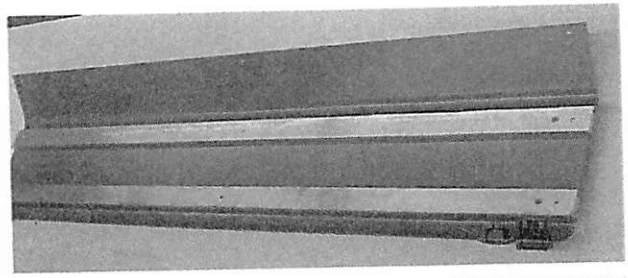




XL44 BOTTOM COVER 110 VOLT

010.4

1) INSPECT BOTTOM COVER (XL44 [redacted]) LOFT 1 TO BE SURE YOU ARE WORKING WITH THE CORRECT VOLTAGE VERSION. THIS REPRESENTATION IS A 110 VOLT COVER.

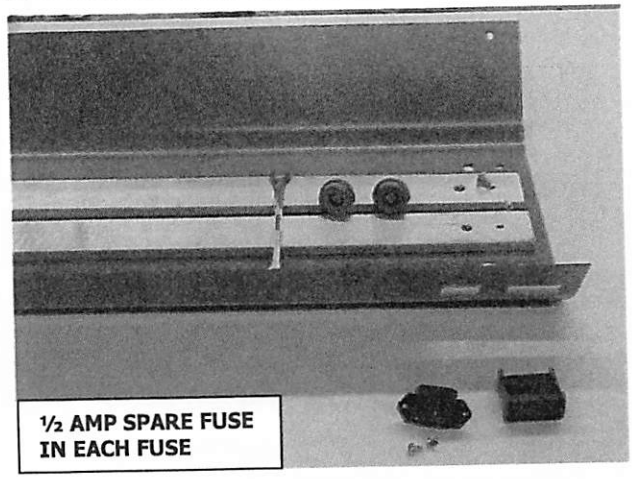


2) MOUNT (2) BOTTOM CROSS BARS (XL44 003.4) LOFT 1 TO THE INSIDE BOTTOM COVER USING (6) 10-32 X 3/8 TH.

3) THREAD (4) RUBBER LEVELER FEET (PRR228) RACK 5 INTO THE BOTTOM CROSS BARS. TIGHTEN WITH WORKED 3/8 OPEN END WRENCH.

4) INSERT (2) FUSE HOLDERS (PRF145) RACK 12 INTO MATCHING HOLES IN THE REAR OF THE MOTOR COVER.

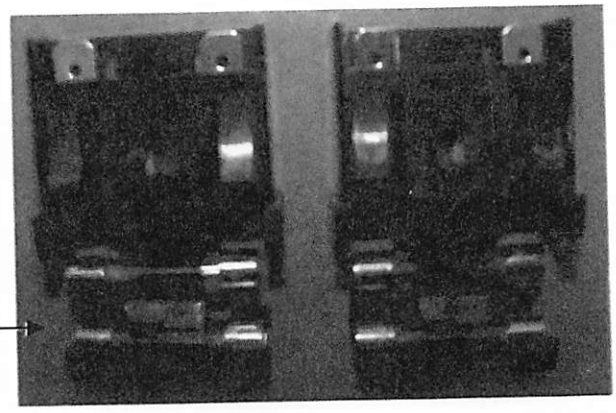
5) INSERT (4) ½ AMP FAST-ACTING FUSES (PRF136) AS07, TWO EACH INTO THE FUSE HOLDERS, EACH HAS A SPARE.

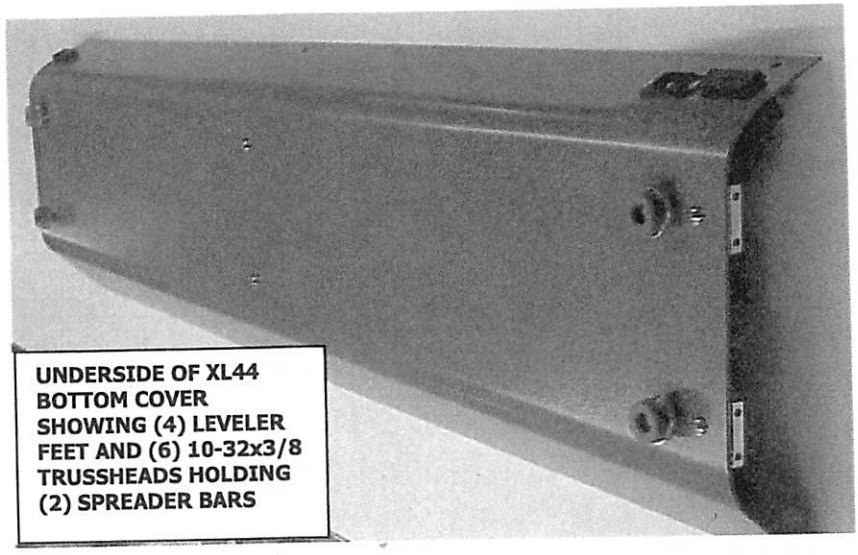


½ AMP SPARE FUSE IN EACH FUSE

6) INSTALL CORD RECEPTACLE (PRC117) AS07 FOR ***110 VOLT*** MODELS USING (2) 6 X 3/8 TH SMS ORIENTED WITH SINGLE TERMINAL POST DOWNWARD. USE POWER CORD (PRC220) AS02 WITH STRAIN RELIEF BUSHING (PRB066) AS02 FOR ***220 VOLT*** MODELS.

FUSE WITH SPARE



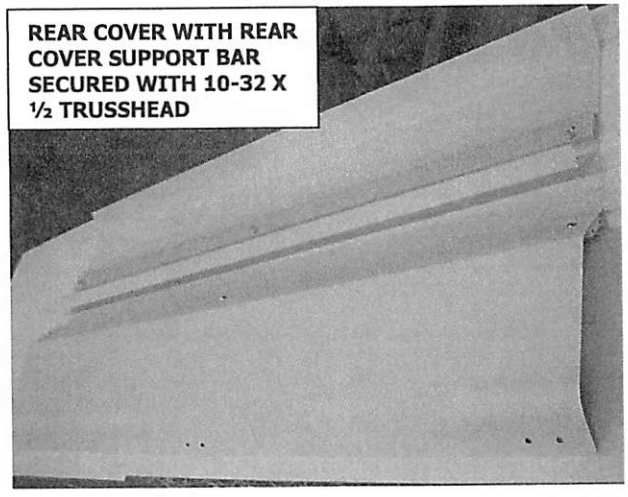


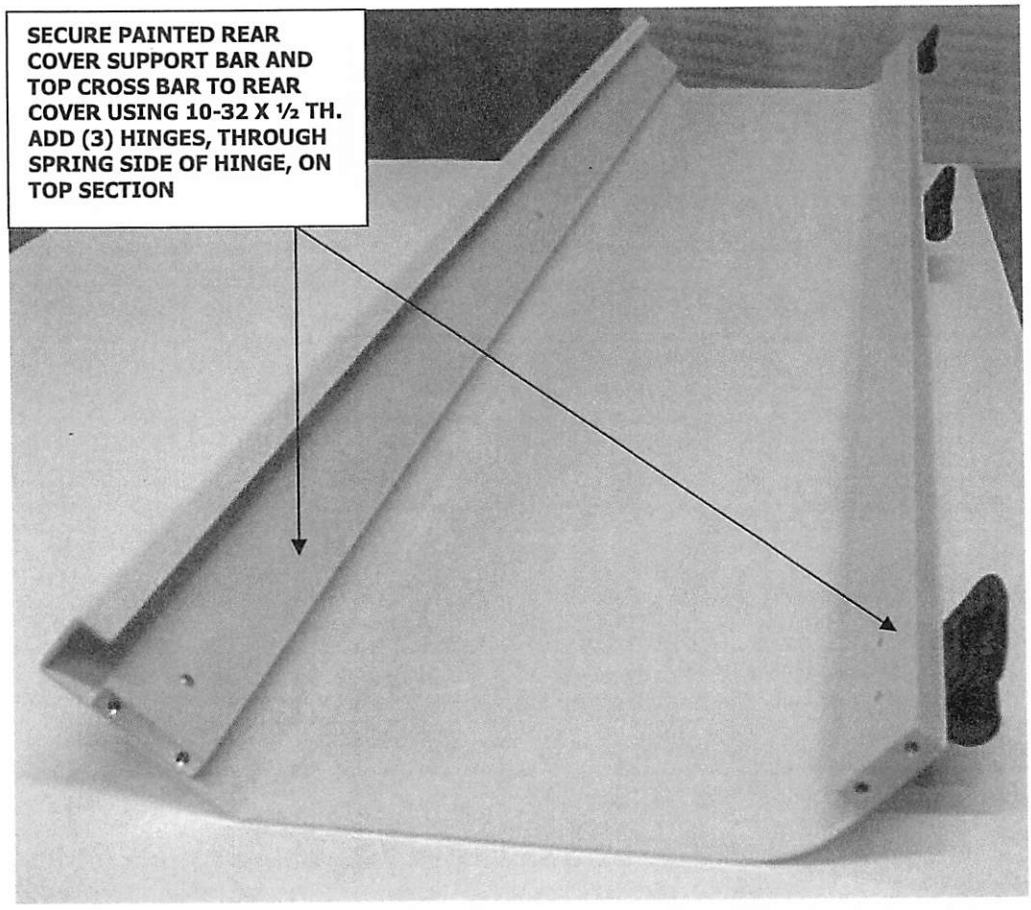
UNDERSIDE OF XL44 BOTTOM COVER SHOWING (4) LEVELER FEET AND (6) 10-32x3/8 TRUSSHEADS HOLDING (2) SPREADER BARS

XL44 REAR COVER

1) ATTACH REAR COVER SUPPORT BAR (XL44 007.4) LOFT 1 TO INNER BOTTOM REAR COVER (XL44 009.4) LOFT1, USE (3) 10-32 X ½ TH.

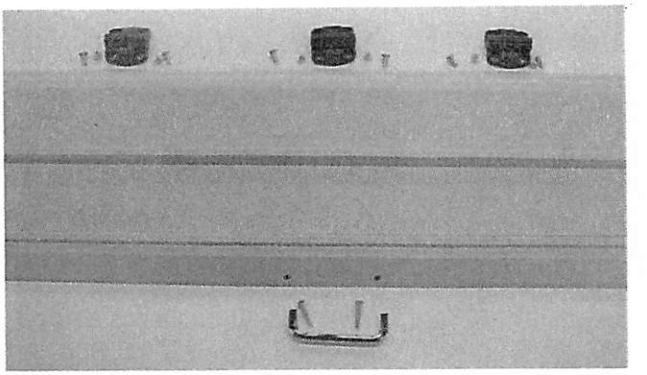
2) THE TOP CROSS BAR (XL44 008.4) LOFT 1 CAN BE ATTACHED TO COVER NOW OR BETWEEN SIDE PANELS WITH COVER PLACED ON LATER. IF ATTACHING NOW, USE (3) DOOR HINGES (PRH001) RACK 5 THROUGH COVER INTO TOP CROSS BAR. THE DARK HINGE SCREWS FACE THE BACK OF MACHINE. USE (6) 10-32 X ½ TH.





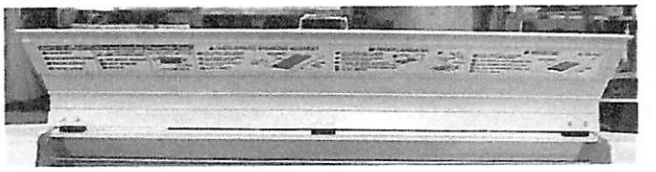
XL44 FRONT COVER

1) PLACE THE FRONT COVER (XL44 009A.4) LOFT 1 ON A WORKING SURFACE. FROM HANDLE PACKET (PRH141R) AS09 SECURE HANDLE TO COVER WITH SCREWS PROVIDED OR 8-32 X ½ PH.

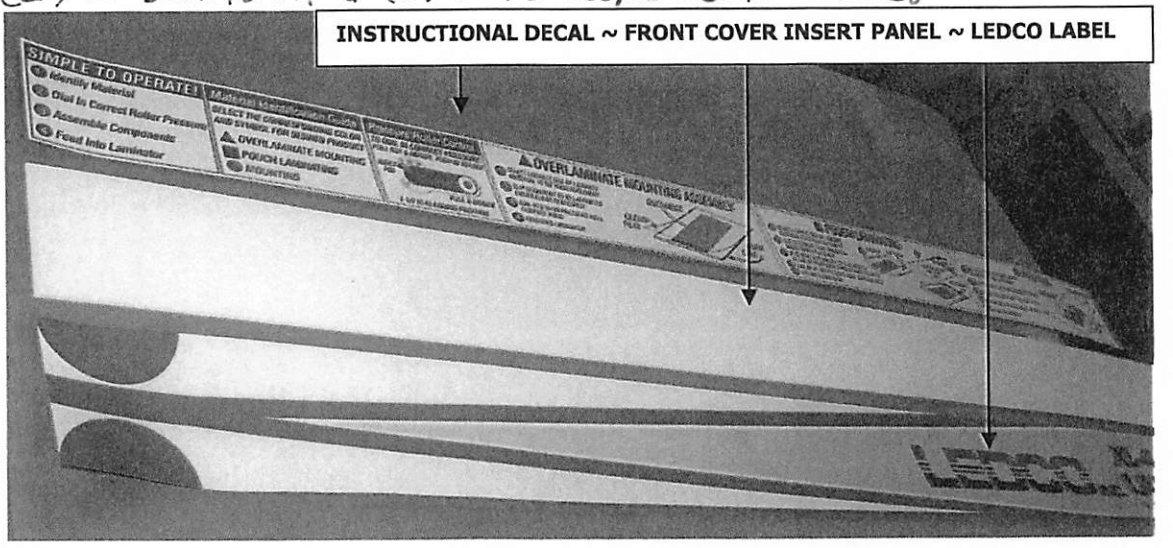


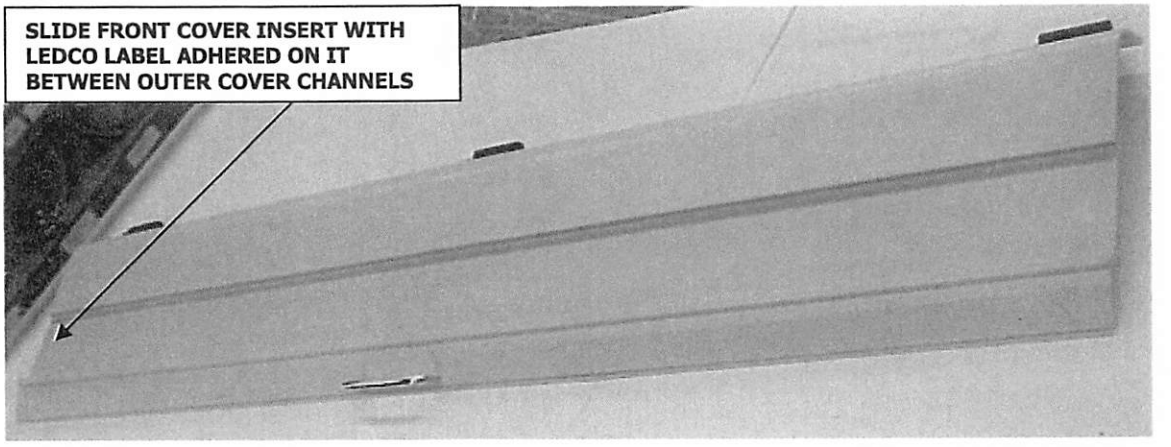
2) TURN COVER OVER, ALIGN AND ADHERE INSTRUCTIONAL DECAL (LAB48) LOFT 1 TO THE UNDERSIDE, SO IT CAN BE READ WHEN COVER IS LIFTED UP ON MACHINE.

3) CLEAN FRONT COVER INSERT PANEL (XL44 012.4) LOFT 1 AND ADHERE LEDCO LABEL (LAB46 CENTER) LOFT 1, TRIM EXCESS LABEL. SLIDE LABEL INTO OUTER COVER CHANNEL, STAKE ENDS.



4) (6) 10-32 x ½ TH & (2) #10 Keps hex nuts





XL44 BASIC CHASSIS

1) PLACE BOTTOM MOTOR COVER ASSEMBLY ON AN ASSEMBLY CART.

2) MOUNT LEFT AND RIGHT SIDE PANEL ASSEMBLIES TO BOTTOM CROSS BAR ENDS USING (8) 10-32 X ½ FH PHILLIPS SCREWS.

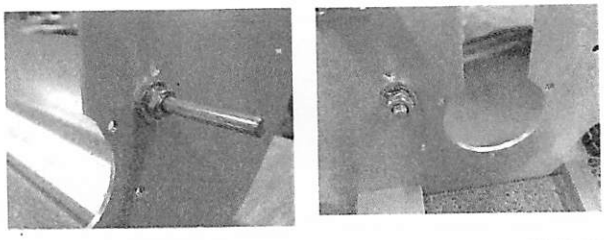
3) INSTALL DRIVE ROLL (XL44 002.5) FLOOR INTO CHASSIS BY CAREFULLY PASSING ONE END OF THE ROLL THROUGH THE UPPER CLEARANCE HOLE IN THE SIDE PANEL AND THEN GENTLY LOWERING THE ROLL TO THE BOTTOM OF THE PANEL SLOTS BETWEEN EXPOSED 10-32 X ½ TH. ***IMPORTANT NOTE: LONGER ROLLER JOURNAL WITH (2) #10 THREADS SHOULD BE INSTALLED INTO LEFTHAND SIDE OF THE CHASSIS.***

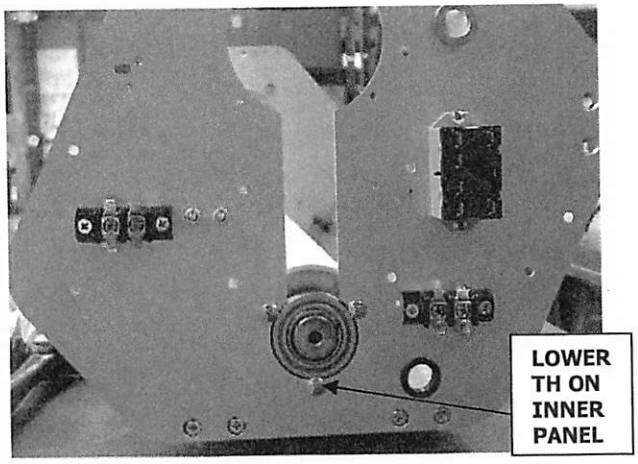
4) SLIDE A R16ZZ BALL BEARING (PRB085) AS07 OVER EACH JOURNAL. LIFT EACH END OF THE ROLL AND SLIDE BEARING INTO THE PANEL OPENING. SECURE EACH WITH (2) 10-32 X ¼ TH PER SIDE. IF THE BEARINGS DO NOT SLIDE IN EASILY, TAP VERY CAREFULLY WITH A PLASTIC MALLET. ***DO NOT FORCE THEM IN OR DAMAGE THE BEARING SEALS !***

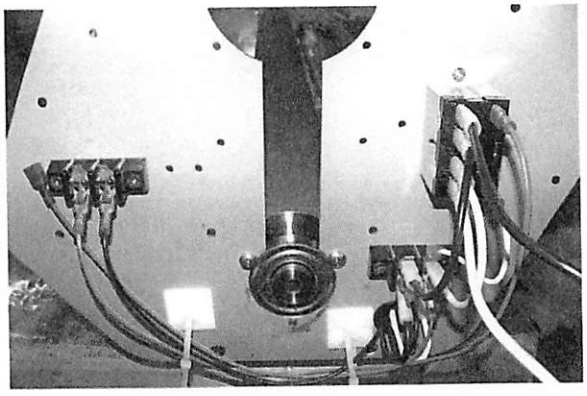
5) INSTALL WIRING HARNESS (PRW350UL) LOFT 1 FOR 110 VOLT. CONNECT WIRES INSIDE BOTTOM COVER; LONGER BLACK AND WHITE PAIR TO RECEPTACLE, WHITE INWARD. BLUE PAIR BY POWER, LONGER WIRE INWARD. BLACK PAIR ON RIGHT SIDE FUSE, LONGER OUTWARD.

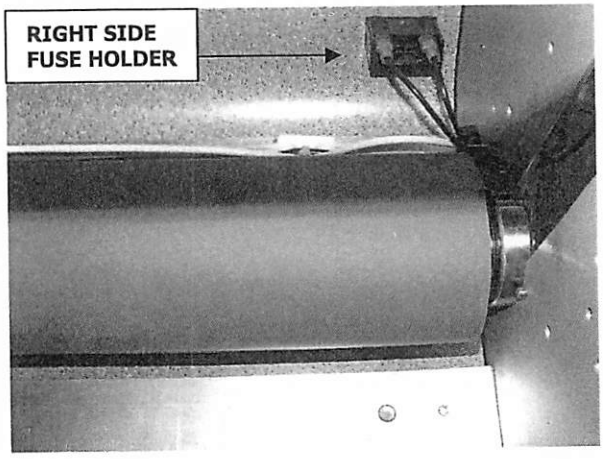
6) USE (3) PRESS CLIPS AND CABLE TIES ALONG REAR BOTTOM CROSS BAR TO HOLD LONGEST BLACK AND WHITES .

7) MOUNT FEED TABLE (XL44 004.4) LOFT 1 EXTRUSION BETWEEN FRONT SIDE PANELS WITH (4) #10 X ½ PH SMS AND ATTACH TO BOTTOM COVER WITH (3) 10 X 3/8 PH SMS.







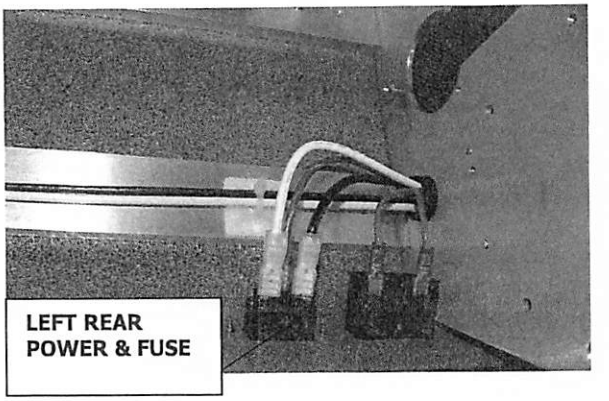


8) MOUNT EXIT TABLE (XL44 005.4) LOFT 1 BETWEEN REAR SIDE PANELS WITH (4) 10 X ½ SMS AND TO BOTTOM COVER WITH (3) 10 X 3/8 PH SMS.

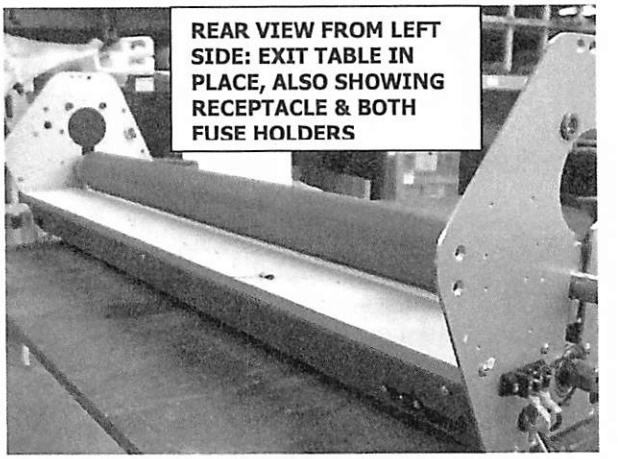
9) INSTALL HOT ROLL ASSEMBLY WITH WIRES ON RIGHT SIDE. SLIDE ON HOT ROLL GUIDE BUSHING (PRB027A) RACK 5 ON EACH JOURNAL ***LONGER SIDE OUTBOARD.*** USE THE SAME TECHNIQUE AS THE DRIVE ROLL INSTALLATION. THE GUIDE BUSHINGS MUST SLIDE SMOOTHLY IN THE SIDE PANEL SLOTS.

10) SLIDE (2) INDEXING SHAFTS (XL44 013.4) LOFT 1 THROUGH THE OILITE BUSHINGS IN THE TOP OF EACH PANEL. ***HELPFUL HINT*** TWISTING SHAFT WHILE HOLDING PANEL WITH YOUR OTHER HAND WILL EASE INSTALLATION.

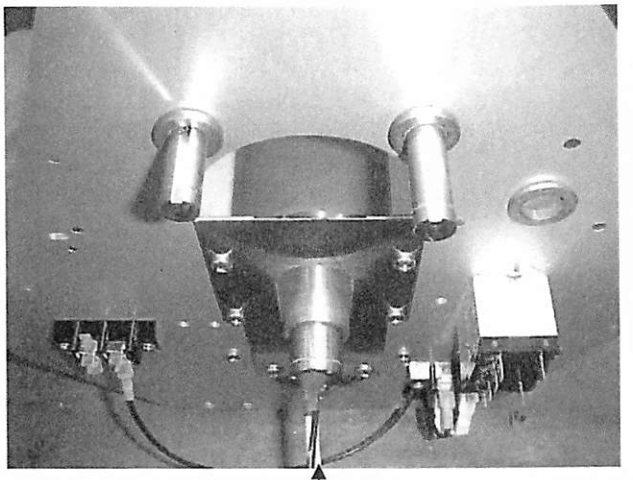
11) REFER TO GEAR INSTALLATION SHEET FOR FURTHER INSTRUCTIONS.



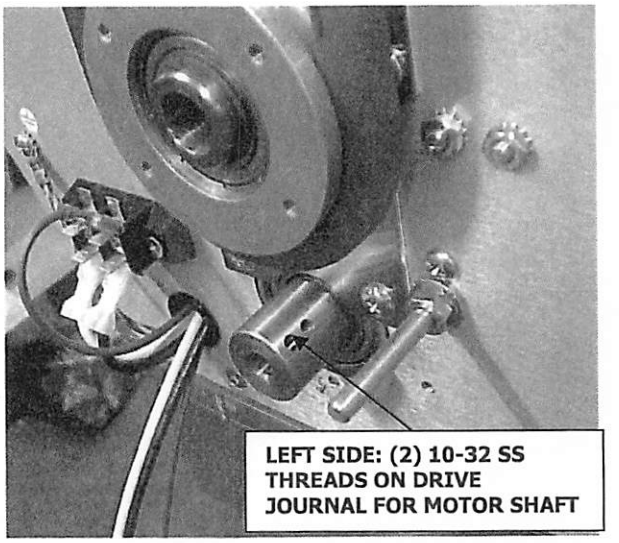
LEFT REAR POWER & FUSE



REAR VIEW FROM LEFT SIDE: EXIT TABLE IN PLACE, ALSO SHOWING RECEPTACLE & BOTH FUSE HOLDERS

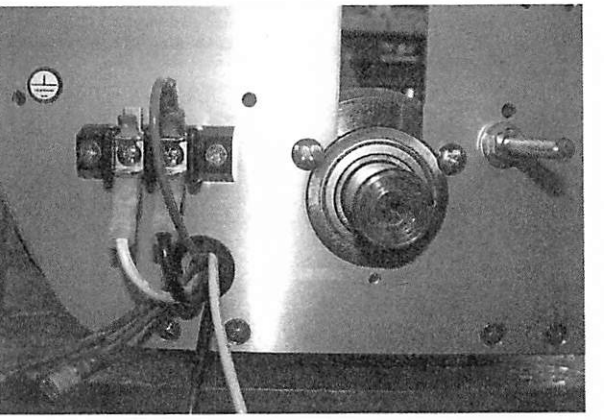


RIGHT SIDE: INNER WIRE CONNECTIONS & COOLING SHIELDS



LEFT SIDE: (2) 10-32 SS THREADS ON DRIVE JOURNAL FOR MOTOR SHAFT

LEFT SIDE: INNER WIRE CONNECTIONS



XL44 GEAR AND TRUNION INSTALLATION

1) FACE RIGHT SIDE PANEL AND ROTATE BOTH INDEXING GEAR SHAFTS SO THE LEFT KEY SEAT IS FACING STRAIGHT UPWARD AND THE RIGHT KEY SEAT IS ONE TOOTH LEFT OF STRAIGHT.

2) PLACE A 1/8 X 1/8 X ¾ LONG MACHINE KEY (MI125KEY) ~~RACK 5~~ INTO THE KEY SEAT OF EACH INDEXING GEAR SHAFT.

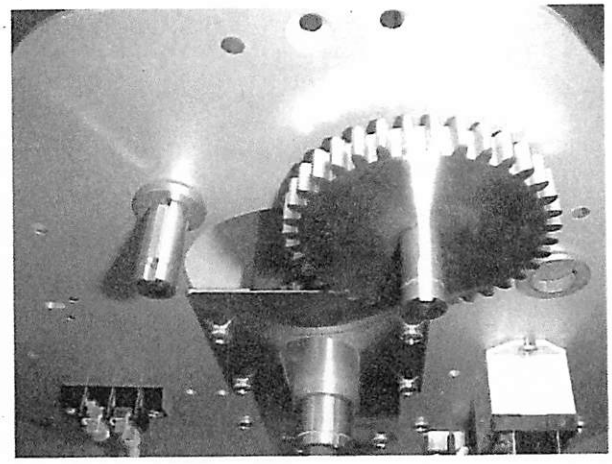
A502

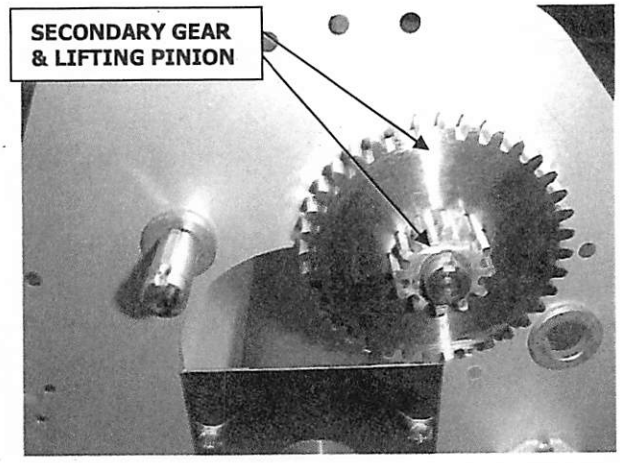
3) SLIDE A SECONDARY GEAR (PRG036T) RACK 5 ON EACH SHAFT AND A LIFTING PINION (PRG012T) RACK 5 OVER THE KEYS AND AGAINST THE OILITE BUSHING FLANGES. ***WARNING: DO NOT FORCE THEM ONTO THE SHAFT.*** SECURE THEM ONTO THE SHAFT WITH (2) RETAINING RINGS (PRR191) LD06. TEST FIT OF TRUNION BETWEEN GEARS ON RIGHT AND LEFT SIDE USING SAMPLE TRUNION MARKED R AND L.

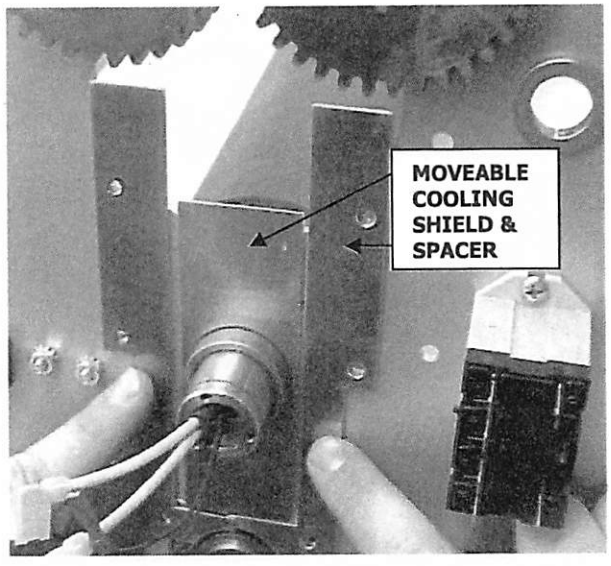
4) ON BOTH SIDE PANELS REMOVE THE TWO LOWER TRUSSHEAD SCREWS THAT RETAIN THE ROLLER BEARING AND SET THEM ASIDE. FROM RACK 5 ON EACH SIDE, SLIDE A MOVEABLE COOLING SHIELD (XL44 028.4) OVER THE HOT ROLL GUIDE BUSHING, ALIGN (2) COOLING SHIELD SPACERS (XL44 030.4) AND A COOLING SHIELD (XL44 029.4) AND SECURE BY REPLACING THE PREVIOUSLY REMOVED TRUSSHEAD SCREWS AND ADDING (4) 10-32 X ¼ PH SCREWS INTO THE REMAINING HOLES. THE MOVEABLE SHIELD MUST BE FREE.

5) ON RIGHT SIDE, POSITION ASSEMBLED TRUNION WITH ***OFFSET TOWARD BACK*** OF MACHINE MAKING CERTAIN KEYS HAVE NOT MOVED FROM FIRST INSTRUCTION AND ARE STILL UPRIGHT.

6) FACE BEARING RETAINER SCREWS INWARD AND OFFSET TOWARD THE BACK OF MACHINE. GENTLY TAP RIGHT

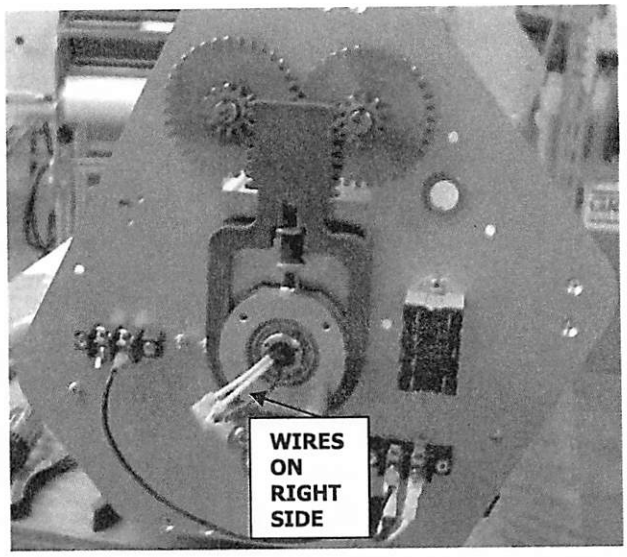


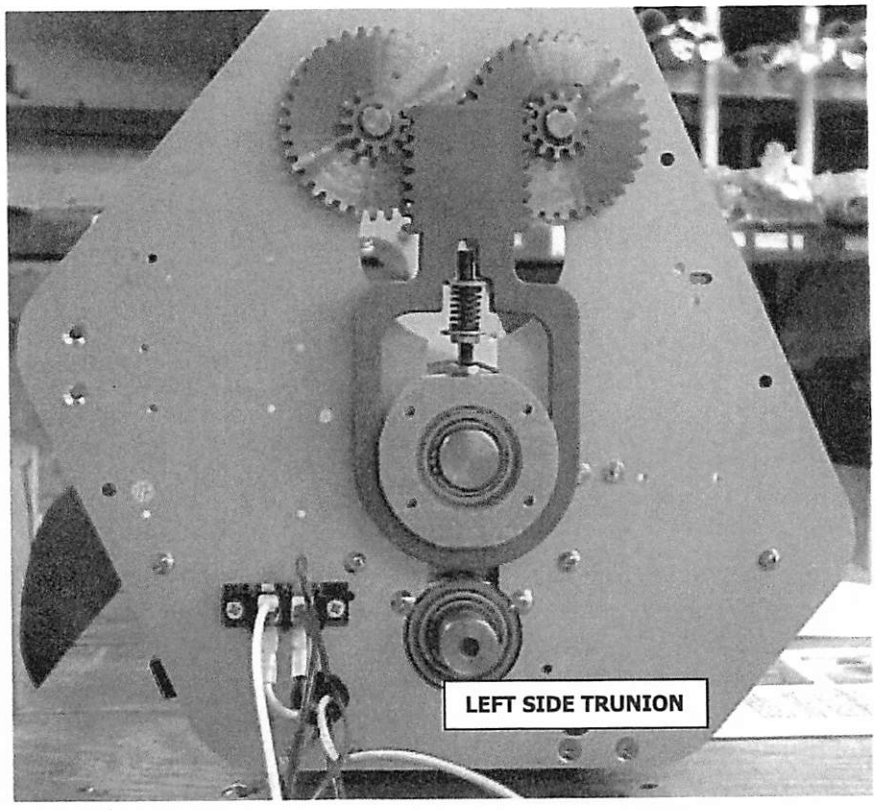




TRUNION BETWEEN LIFTING PINIONS WITH ROLLER BEARING OVER HOT ROLL JOURNAL. SECURE TRUNION ON HOT ROLL JOURNAL WITH 1" EXTERNAL SNAP RING (PRS008) RACK 5.

7) REPEAT PROCEDURE ON LEFT SIDE. SECURE WITH 1" EXTERNAL SNAP RING. IF THERE IS EXCESS "PLAY" ON JOURNAL, ADD A 1" EXTERNAL SNAP RING BETWEEN TRUNION AND GROOVE.





XL44 NRTL SLIP RING ROTATING CONNECTOR

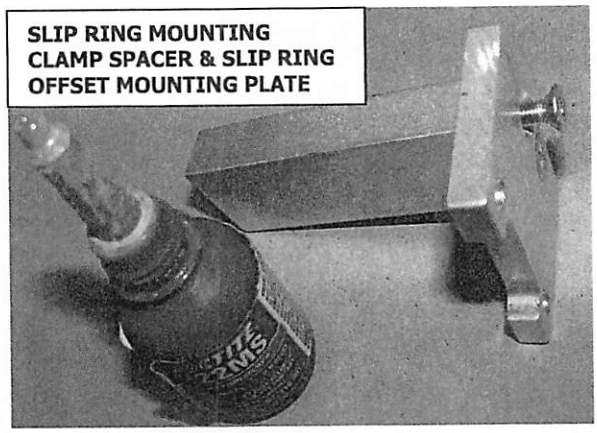
1) ON RIGHT SIDE HOT ROLL JOURNAL ATTACH SLIP RING DRIVER (XL44 025.4) RACK 5 TO THREADED JOURNAL WITH (3) 6-32 X 3/16 PH, NOTCH TO THE LEFT.

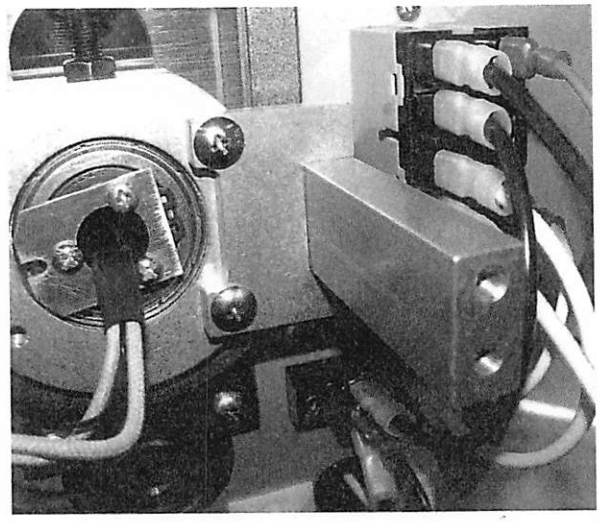
2) SECURE THE SLIP RING MOUNTING CLAMP SPACER (XL44 044.4A) RACK 5 TO THE SLIP RING OFFSET MOUNTING PLATE (XL44 023.4) RACK 5 THROUGH THE COUNTERSUNK HOLES, USING (2) 10-32 X ¾ FH WITH LOCTITE.

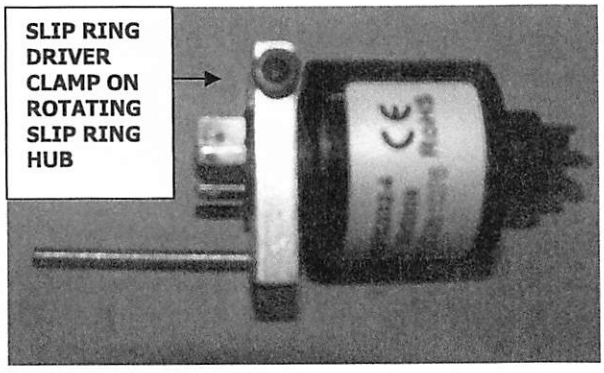
3) SECURE OFFSET MOUNTING PLATE TO REAR THREADS ON BEARING CARRIER USE (2) 10-32 X ½ TH.

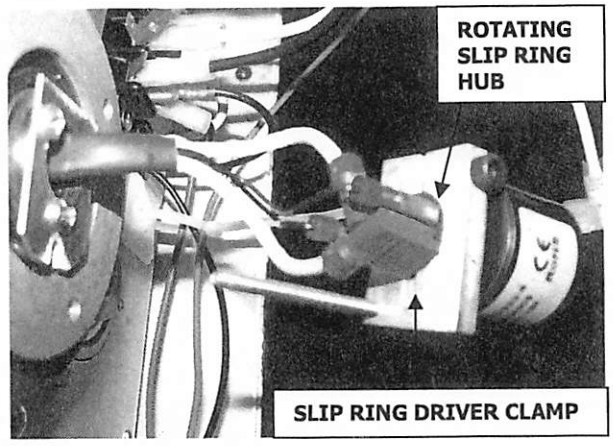
4) THREAD A 6-32 X 1 ¾ PH INTO THE SLIP RING DRIVER CLAMP (XL44 024.4) RACK 5. SLIDE SLIP RING DRIVER CLAMP OVER *ROTATING HUB* OF SLIP RING (PRS001A) AS08. SECURE SLIP RING DRIVER CLAMP WITH 8-32 X ¾ SHCS, SNUG BUT NOT TIGHT ENOUGH TO CRUSH HUB.

5) CRITICAL, ONE TIME ONLY: SECURE SENSOR AND HEATER WIRES ONTO ROTATING HUB.







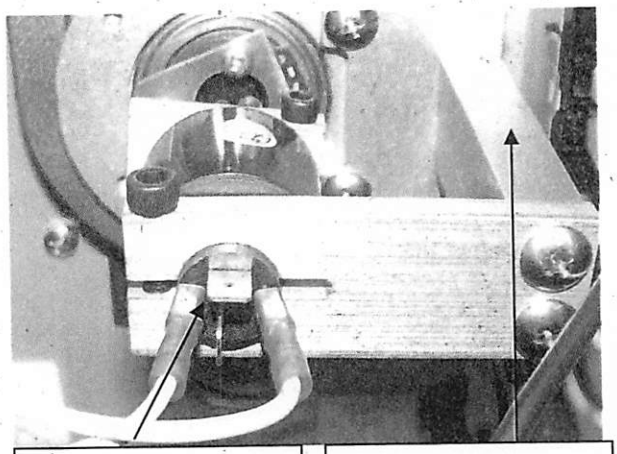


XL44 NRTL SLIP RING CLAMP

1) START A 10-32 X ¾ SHCS INTO THE UPPER THREADS ON A SLIP RING CLAMP (XL44 022.4A) RACK 5 DO NOT TIGHTEN. SLIDE SLIP RING CLAMP OVER OUTER, ***STATIONARY*** HUB OF THE SLIP RING. THE SHCS IS UPWARD AND THE OUTER HEATER POST SHOULD BE UPWARD AND HORIZONTAL.

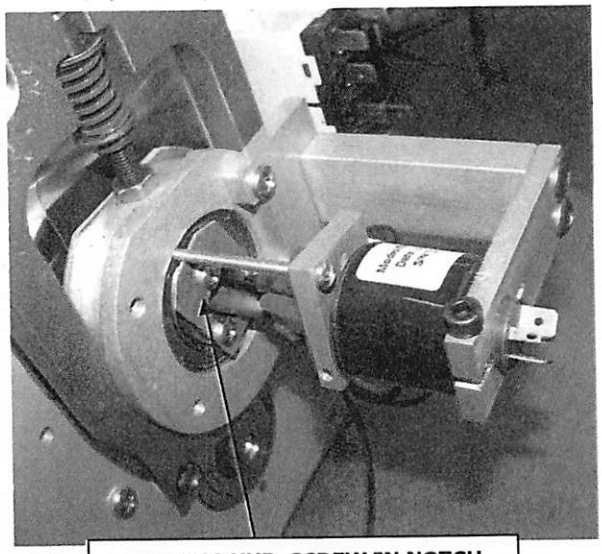
2) INSERT (2) 10-32 X ¾ TH, WITH LOCTITE, THROUGH THE CLEARANCE HOLES IN THE SLIP RING CLAMP AND SECURE INTO THE SLIP RING MOUNTING CLAMP SPACER (XL44 044.4A) RACK 5.

3) ADJUST SLIP RING ALIGNMENT SO THE 6-32 X 1 ¾ SCREW FITS INTO SLIP RING DRIVER NOTCH, BUT DOES NOT TOUCH ROLLER BALL BEARING WHEN ROLLS ARE TURNING. TIGHTEN THE SHCS ON THE SLIP RING CLAMP.

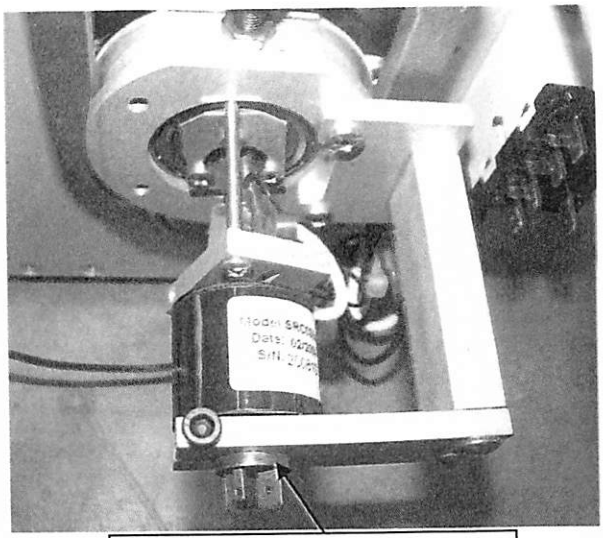


SLIP RING HEATER POST UPWARD & FLAT

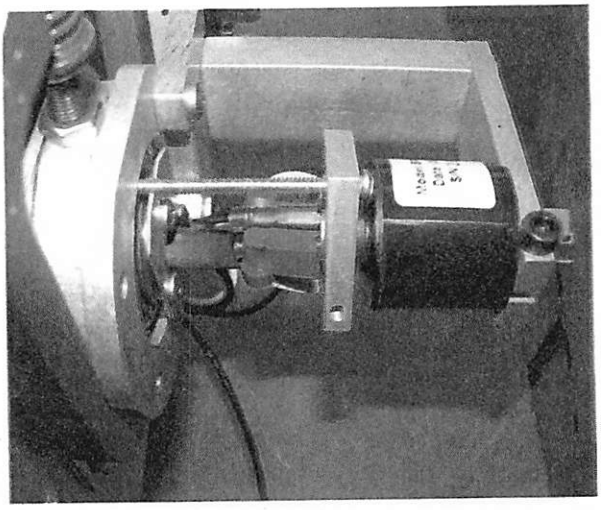
SLIP RING MOUNTING CLAMP SPACER



ROTATING HUB, SCREW IN NOTCH



STATIONARY HUB ON SLIP RING



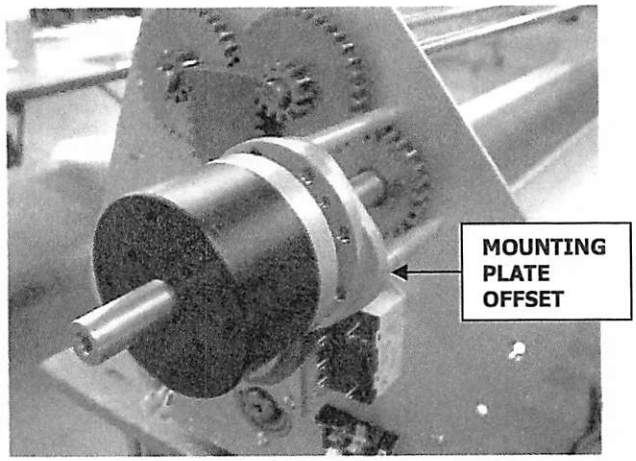
XL44 INDEXING HANDLE CALIBRATION

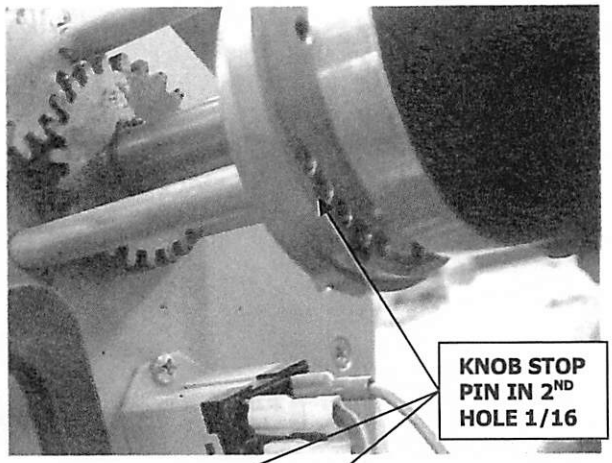
1) ON RIGHT SIDE PANEL ATTACH INDEXING HANDLE ASSEMBLY WITH MOUNTING PLATE OFFSET TOWARD REAR OF MACHINE. ALIGN SECONDARY AND INDEXING SHAFT GEARS. SECURE FROM INNER PANEL WITH (3) 10-32 X ¾ FH, LOCTITE THREADS.

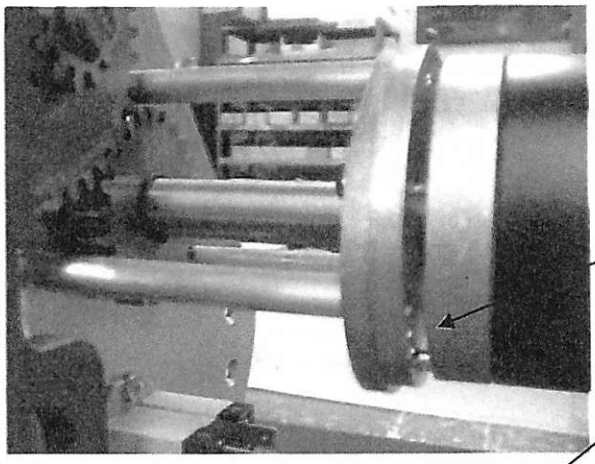
2) LOOSEN (3) BH ON MOUNTING PLATE WITH 1/8 ALLEN WRENCH AND ROTATE INDEXING PLATE UNTIL KNOB STOP PIN SLIDES IN AND OUT OF 1/16 HOLE FREELY, WITHOUT PRESSURE.

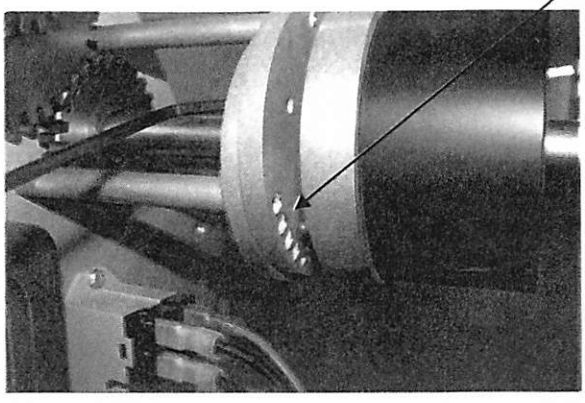
3) SNUG ALL THREE BUTTONHEADS TO SEAT, THEN TIGHTEN THEM.

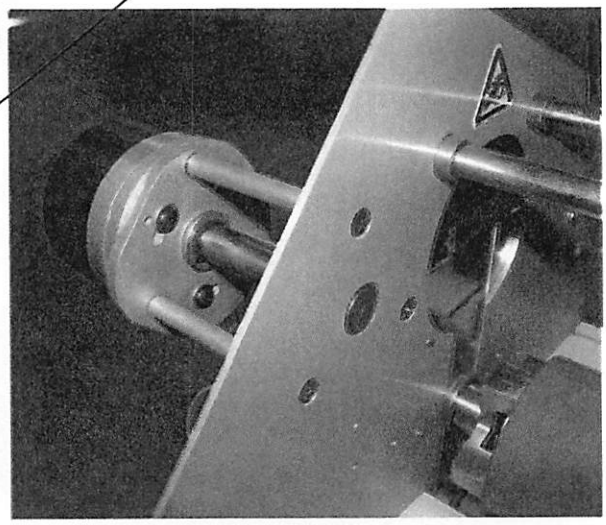
4) TEST FUNCTION OF HANDLE BY MOVING KNOB STOP TO EACH OF THE HOLES, THUS RAISING HOT ROLL. CHECK EVENESS OF HOT ROLL PRESSURE AGAINST DRIVE ROLL.





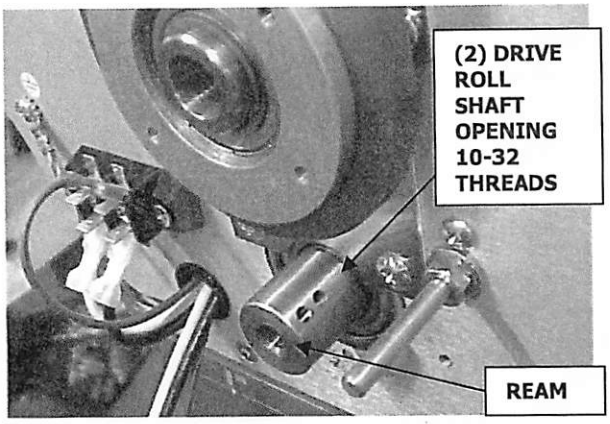






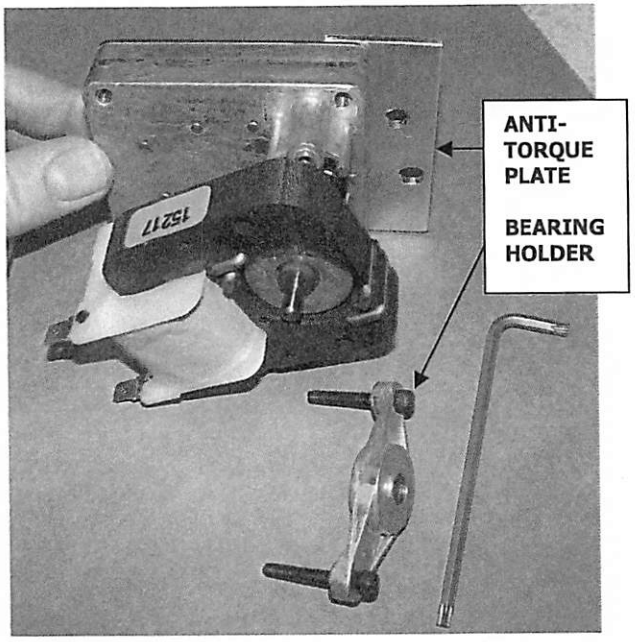
XL44 MOTOR (PRM202) INSTALLATION 2017

1) ATTACH ANTI-TORQUE PLATE (XL44 032.4) RACK 5 TO 2017 UPDATED DAYTON MOTOR (PRM202) RACK 5 WITH (2) 10-32 X 3/8 UCFLMS INTO COUNTERSINKS, ON NIPPLE SIDE.

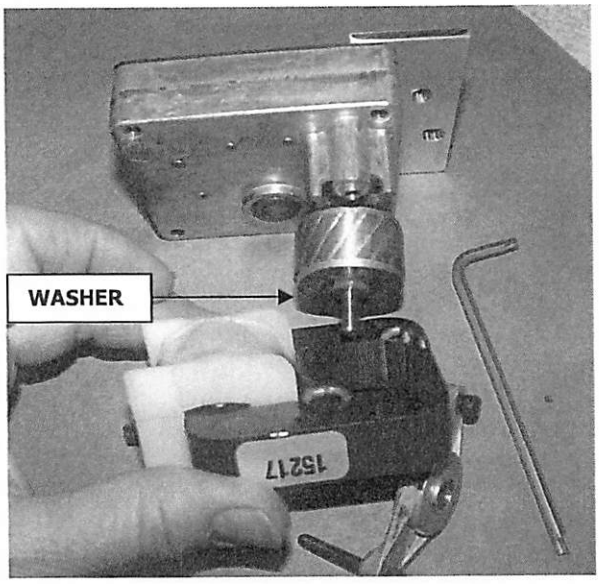


2) REAM LEFT SIDE DRIVE ROLL SHAFT WITH 5/16 .3125 REAMER. BRUSH ANTI-SEIZE ON MOTOR SHAFT. BEGIN A 10-32 X 3/8 SET SCREW IN BOTH OF THE THREADED DRIVE ROLL SHAFT OPENINGS.

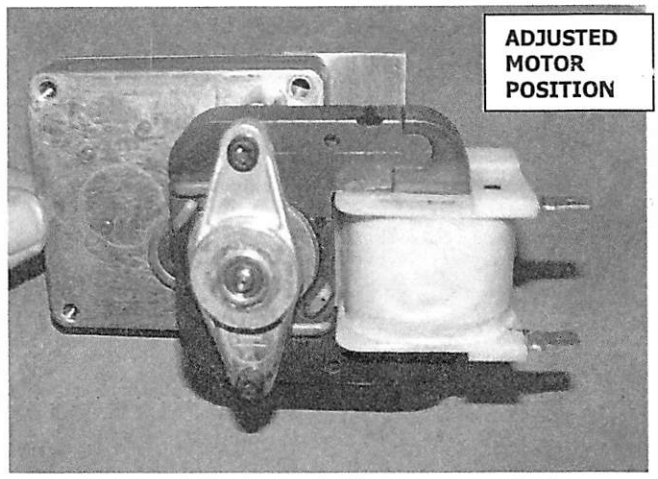
3) USE A T20 TORX ALLEN TO REMOVE (2) SHCS ON BEARING/SCREW HOLDER AND ROTATE MOTOR 180 DEGREES, SO THE TERMINAL POSTS WILL FACE THE FRONT OF XL44 WHEN INSTALLED. ** *DO NOT MISPLACE THE WASHER ON MOTOR SHAFT*. THE TERMINALS POSTS ARE NOW ON THE SAME SIDE AS THE ANTI-TORQUE PLATE. REPLACE THE BEARING HOLDER OVER MOTOR AND SECURE WITH THE SHCS.

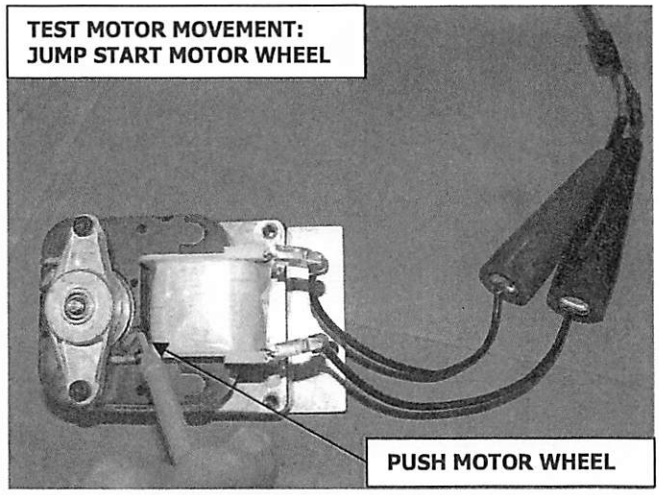


4) THE BLACK WIRES MAY BE LEFT ON THE TERMINAL POSTS WHILE ADJUSTING THE MOTOR LOCATION.

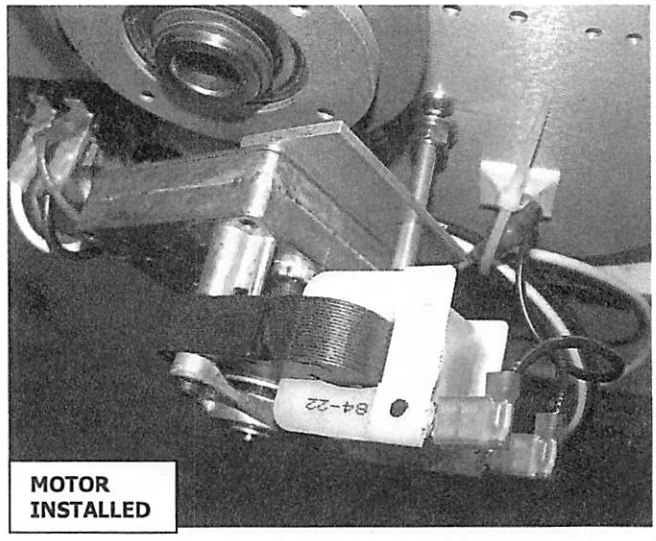


5) BEFORE MOTOR INSTALLATION, USE A TEST CORD WITH CLAMPS ON THE MOTOR WIRES, TO RUN MOTOR. SOME MOTORS NEED A MANUAL JUMP START DUE TO COLD MOTOR GREASE RESTRICTING MOVEMENT OR BECAUSE THE MAGNETS HAVE MISALIGNED WHILE ADJUSTING THE MOTOR POSITION. ONCE THE MOTORS HAVE RUN FOR SOME TIME, THEY TEND TO START REGULARLY THEREAFTER.



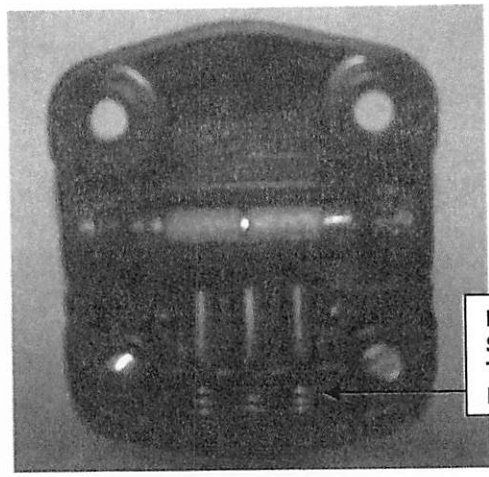


6) ALIGN THREADS ON DRIVE ROLL SHAFT WITH FLAT SIDE OF MOTOR SHAFT. ADD ANTI-SEIZE TO MOTOR SHAFT. SLIDE MOTOR SHAFT INTO DRIVE ROLL SHAFT. USE (2) 10-32 X 3/8 SET SCREW TO SNUG. LOOSEN SET SCREW, PULL OUT SHAFT, CHECK SCREW INDENTATION ON FLAT FOR ALIGNMENT, SECURE.



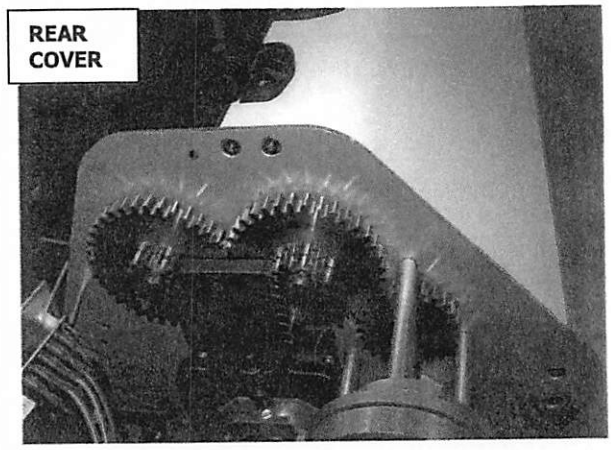
XL44 NRTL CHASSIS COMPLETION

1) AFTER THE INDEXING HANDLE IS SECURED, THE REAR COVER ASSEMBLY CAN BE PLACED BETWEEN THE RIGHT AND LEFT SIDE PANELS FROM THE BACK OF MACHINE. SECURE BACK COVER WITH (4) 10-32 X ½ FH ON EACH SIDE PANEL THROUGH COUNTERSUNK OPENINGS INTO TOP CROSS BAR AND REAR SUPPORT BAR. DO NOT SCRATCH SIDE PANELS.



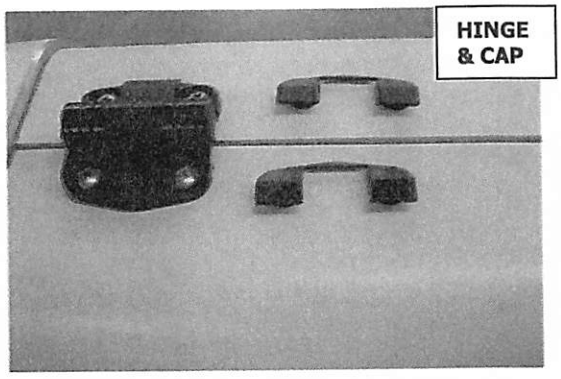
2) EXAMINE THE (3) DOOR HINGES (RH001) RACK 5 AND SECURE THROUGH BACK COVER INTO TOP CROSS BAR WITH THE DARK HINGE *SPRINGS FACING THE REAR* OF THE MACHINE. USE (6) 10-32 X ½ TH.

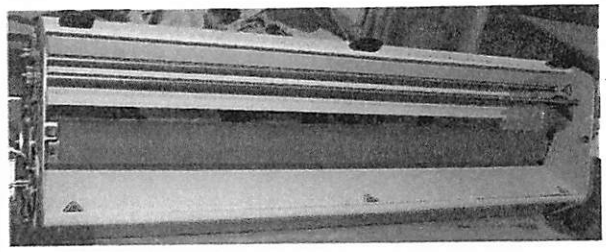
3) FROM THE FRONT OF MACHINE ATTACH FRONT COVER ASSEMBLY TO HINGES OF REAR COVER WITH (6) 10-32 X ½ TH AND (6) 10-32 KEPS HEX NUTS ON UNDERSIDE. USE NUT DRIVER TO TIGHTEN.

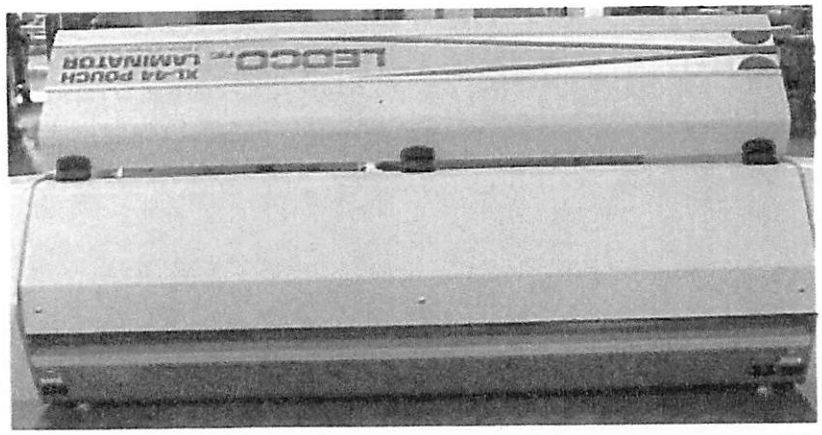


4) SNAP HINGE CAPS TO COVER SCREWS.

5) TEST COVER UP AND DOWN FOR MOTION.



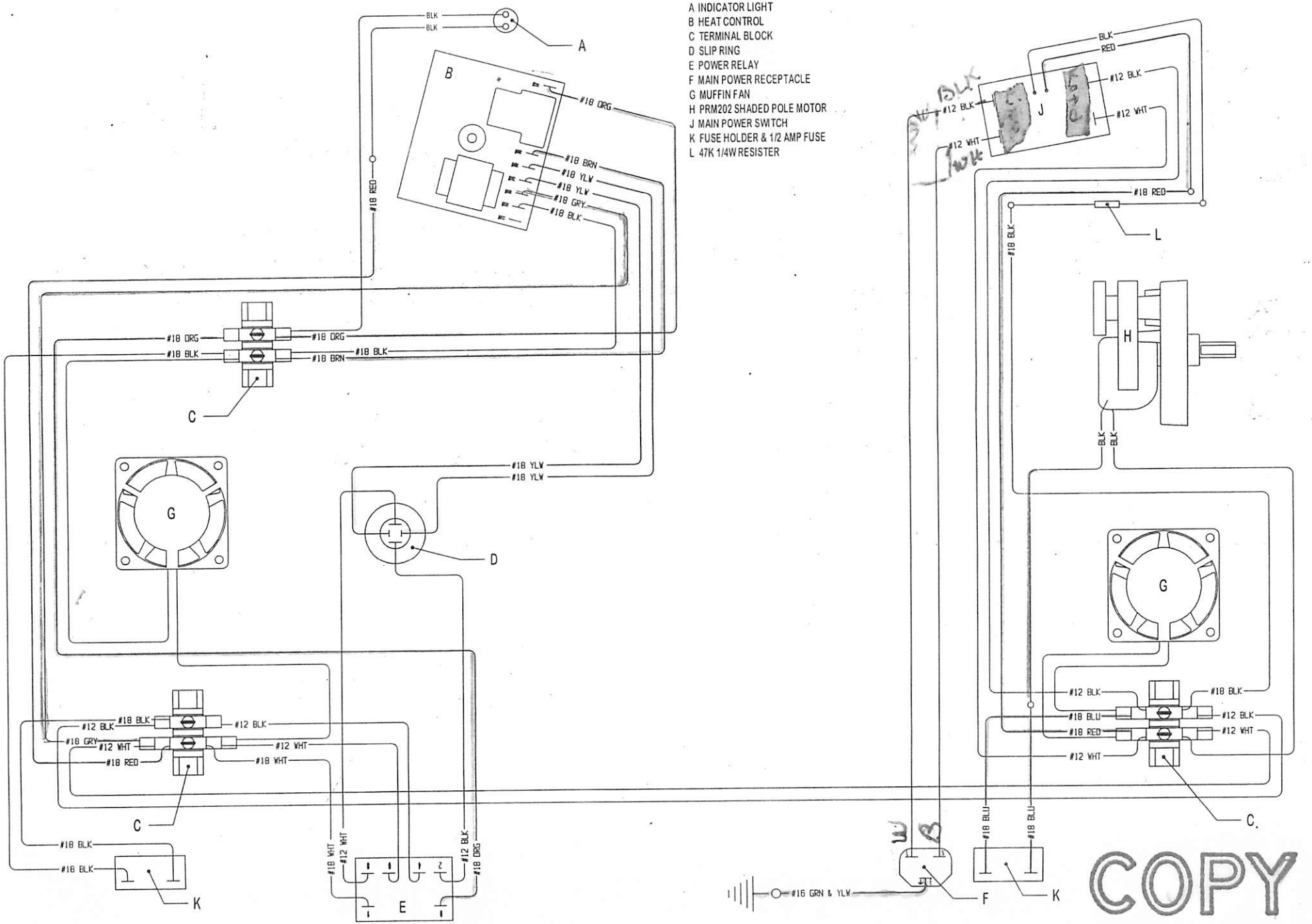




XL44 POUCH LAMINATOR 110V WIRING DIAGRAM

LEGEND

A INDICATOR LIGHT
B HEAT CONTROL
C TERMINAL BLOCK
D SLIP RING
E POWER RELAY
F MAIN POWER RECEPTACLE
G MUFFIN FAN
H PRM202 SHADED POLE MOTOR
J MAIN POWER SWITCH
K FUSE HOLDER & 1/2 AMP FUSE
L 47K 1/4W RESISTER



XL44 WIRING AND TYING 2017

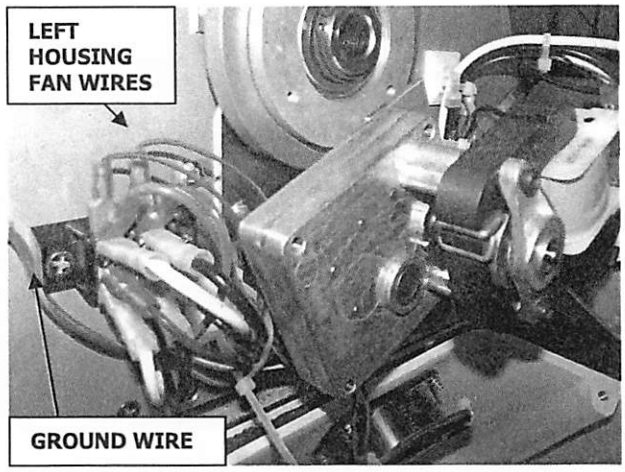
1) ON LEFT SIDE PANEL REMOVE SCREW BY INTERNATIONAL GROUND LABEL SECURING EXIT TABLE. ADD GROUND WIRE AND A #10 STAR WASHER. SECURE GROUND WIRE BY REPLACING SCREW, ANGLED TO AVOID INTERFERECE WHEN HOUSING IS ATTACHED. TERMINATE REMAINING WIRES FROM INSIDE MACHINE ONTO TERMINAL BLOCK AND BREAKER. FOLLOW DIAGRAM AND PHOTOS.

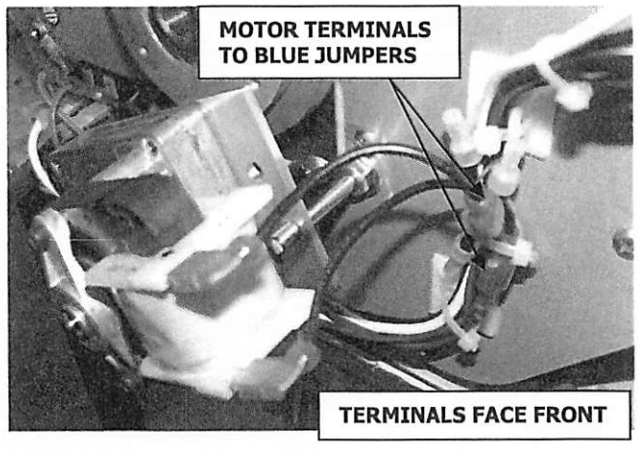
2) PREPARE 2017 UPGRADED MOTOR WIRES BY UNITING WITH BLUE JUMPERS. BOTTOM WIRE TO 6" JUMPER CONTINUING TO TERMINAL BLOCK 3A. THE TOP MOTOR WIRE CONNECTS WITH BLUE JUMPER CONTINUING TO FUSE IN BOTTOM MOTOR COVER. USE PRESS CLIPS AND CABLE TIE WIRES TO LEAVE ROOM FOR THE HOUSING FAN IN THE HOUSING. ALIGN WIRES AND TIE SO THERE WILL BE NO STRESS ON CONNECTIONS OR PINCHING.

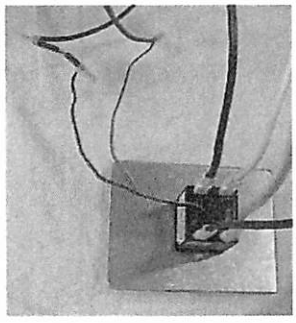
3) FROM THE WIRING HARNESS TAKE THE 12" RED AND BLACK 18 GAUGE WIRES WITH OPEN ENDS. THE OTHER END OF THE WIRES HAS A COVERED FEMALE ON EACH. THE RED WIRE ON THE 15 AMP BREAKER ON/OFF SWITCH PLATE ASSEMBLY IS CLEAR CAPPED (PRT289) WITH THE 12" RED 18 GAUGE WIRE. ATTACH THE RED WIRE TO 1B TERMINAL POST. TWO 18 GAUGE BLACK PLASTIC SHIELDS ARE ADDED TO THE EXPOSED WIRE OF RESISTER (PRR263) RACK 5. ONE END OF RESISTER IS CLEAR CAPPED WITH BLACK ON/OFF SWITCH WIRE AND THE OTHER END IS CLEAR CAPPED WITH THE 12" BLACK 18 GAUGE, ATTACH TO 4A ON TERMINAL BLOCK.

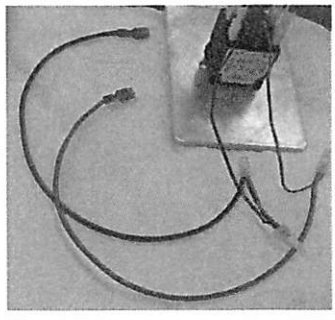
4) FAN WIRES IN HOUSING ARE ATTACHED TO THE UPPER 180 DEGREE TERMINALS.

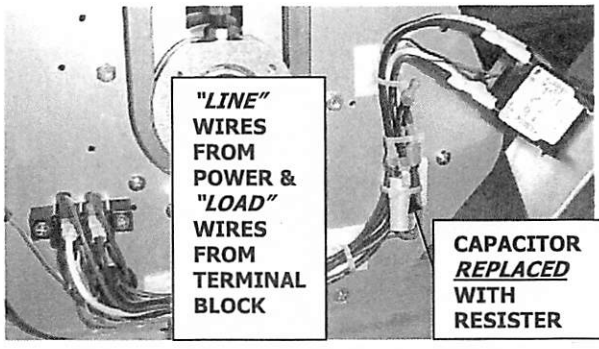
5) ON THE BREAKER THE LOWER BLACK AND WHITE POWER 12 GAUGE WIRES ARE THE "LINE" AND THE UPPER BLACK





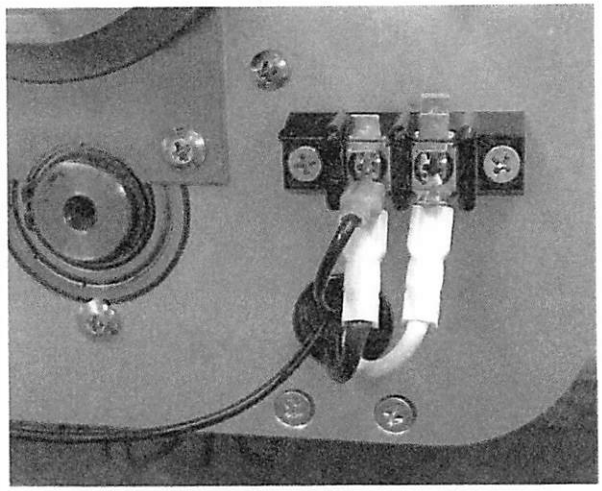




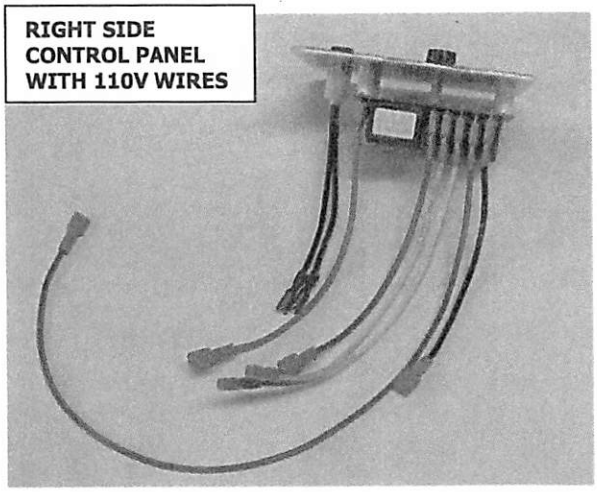


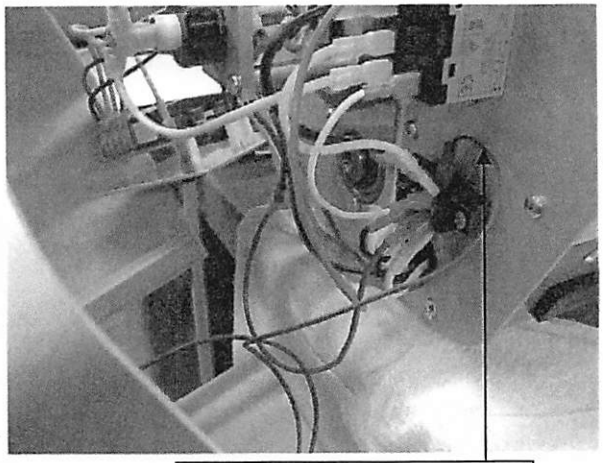
AND WHITE 12 GAUGE TERMINAL BLOCK WIRES ARE "LOAD" upper posts CONNECTING TO ON/OFF SWITCH.

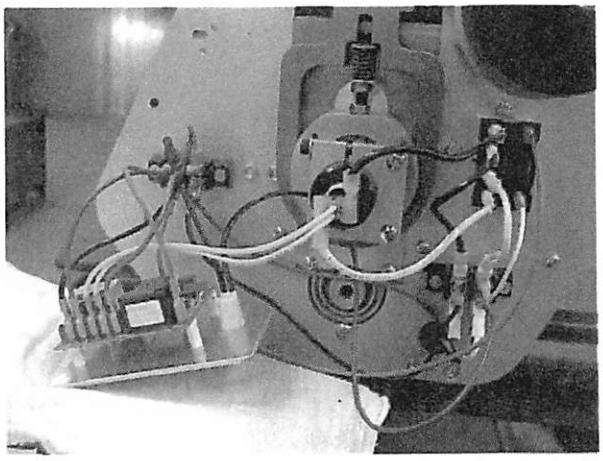
6) WIRE ACCORDING TO 110V OR 220V DIAGRAMS. TIE WIRES, SECURE WITH PRESS CLIPS. KEEP WIRES FROM MOVING PARTS OR HOUSING.



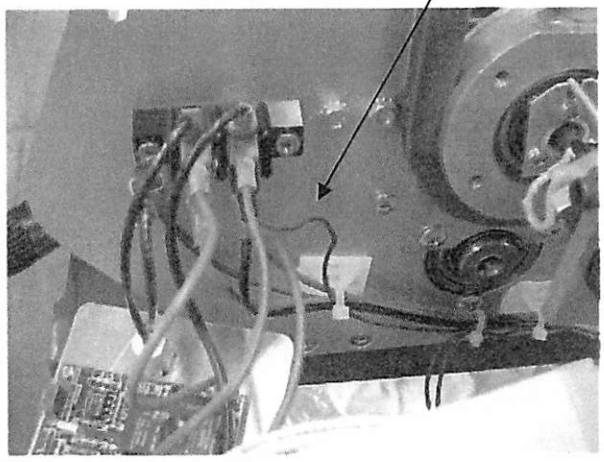
RIGHT SIDE CONTROL PANEL WITH 110V WIRES

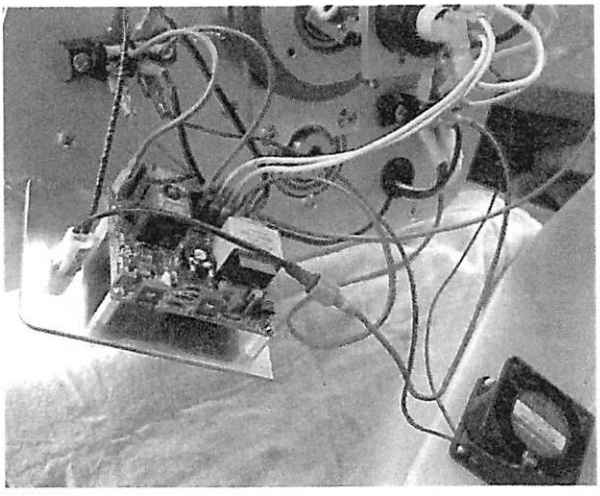






RIGHT HOUSING FAN WIRES





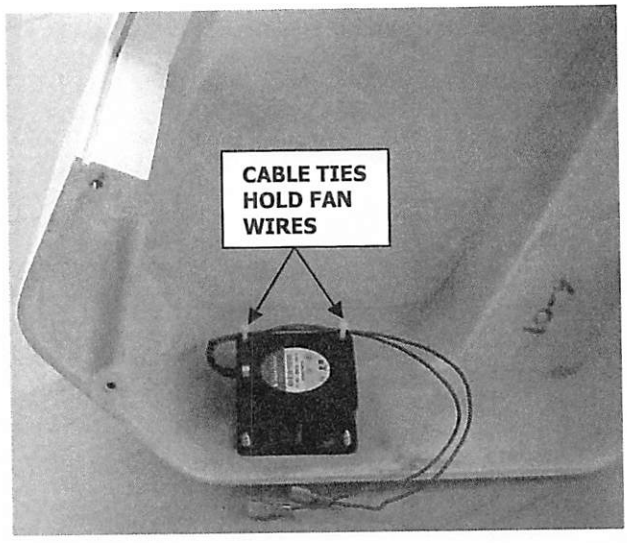
XL44 LEFT HOUSING

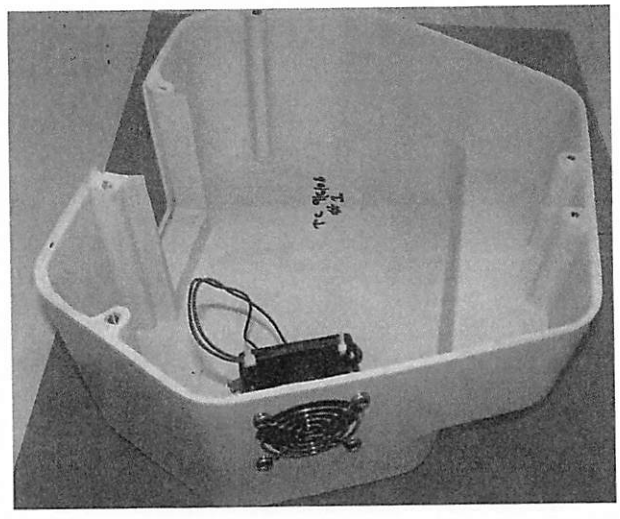
1) CHECK LEFT HOUSING (XL44 094.5L) LOFT 1 FOR SCRATCHES. THREADS CAN RE RETAPPED WITH A #10 IF PAINT HAS CORRUPTED THEM.

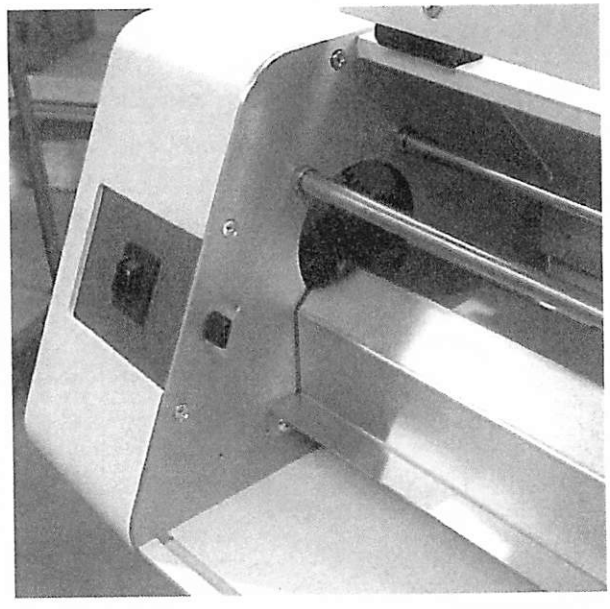
2) ATTACH WIRE FAN GRILL (PRF144) AS09 AND MINI FAN (PRF143) AS09 TO HOUSING USING (4) 10 X ¾ PH SMS. OIL HELPS SMS THREADING. RAISED SIDE OF GRILL SHOULD BE AWAY FROM HOUSING. *AIRFLOW INWARD* AND FAN WIRES FACING CONTROL BOARD, TO INSIDE. NOTE (2) CABLE TIES HOLDING WIRES ON FAN FROM GETTING PINCHED BY SIDE PANEL.

3) CRIMP (2) RED FULLY INSULATED FEMALE FASTONS (PRT331) RACK 20 ONTO FAN WIRES AND CONNECT TO TERMINAL BLOCK.

4) ATTACH HOUSING TO SIDE PANELS BY SLIDING IN CONTROL BOARD. CHECK THAT NO WIRES WILL BE TOUCHED AS YOU SECURE WITH (4) 10-32 X 7/16 FH. THREE SCREWS IN FRONT AND ONE IN REAR BY EXIT TABLE.







XL44 RIGHT HOUSING
FAN AND WIRE FAN GRILL

1) USE #10 HAND TAP TO OPEN THREADS ON RIGHT HOUSING (XL44 094.5R) LOFT1 IF NECESSARY.

2) INSERT INDICATOR APETURE ANGLE (XL44 034.4) ~~AS10~~ INTO HOUSING ALIGNING HOLES ON INSIDE.

3) SECURE INDICATOR APETURE ANGLE TO HOUSING WITH (2) 8-32 X ½ PH FROM THE OUTSIDE AND (2) #8 KEPS HEX NUTS ON THE INSIDE HOUSING.

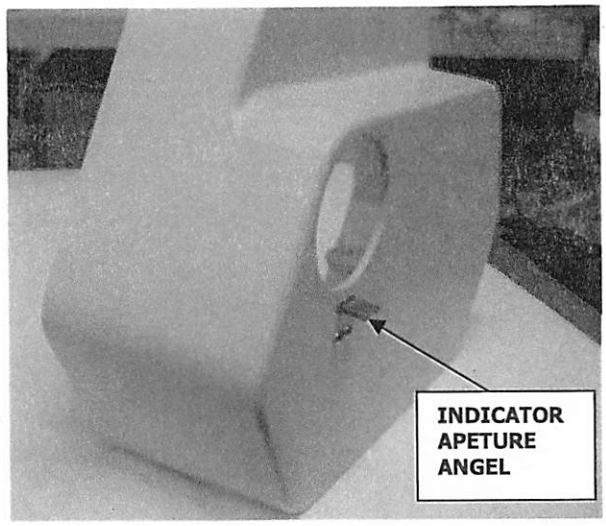
4) ATTACH WIRE FAN GRILL (PRF144) ~~AS21~~ AND MINI FAN (PRF143) ~~AS22~~ TO HOUSING USING (4) 10 X ¾ PH SMS. OIL HELPS THREADING. RAISED GRILL SIDE IS AWAY FROM HOUSING AND FAN WIRES FACE CONTROL BOARD NSIDE.

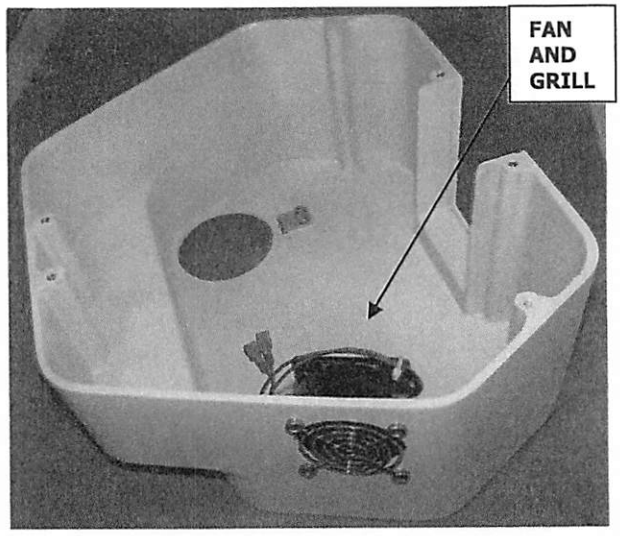
5) CRIMP (2) RED FIF FASTONS (PRF331) ONTO FAN WIRES.

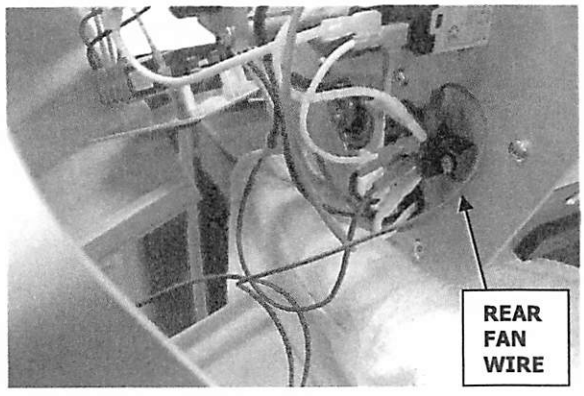
6) CONNECT ONE WIRE TO EACH TERMINAL BLOCK. KEEP WIRES FROM TOUCHING HOUSING OR MOVING PARTS.

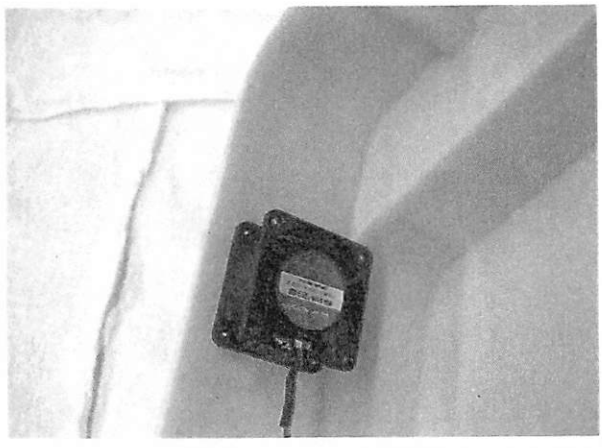
7) CHECK INDEX HANDLE TO <u>CONFIRM KNOB STOP IS IN SECOND (1/16) HOLE</u> (SEE CALIBRATION PICTURE) BEFORE SECURING HOUSING.

8) ATTACH HOUSING BY SLIDING IN CONTROL BOARD AND SECURING WITH (4) 10-32 X 7/16 FH, THREE IN FRONT AND ONE IN REAR BY EXIT TABLE.







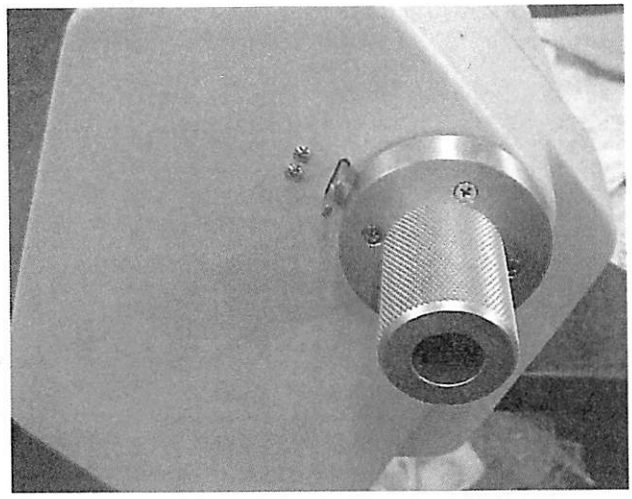


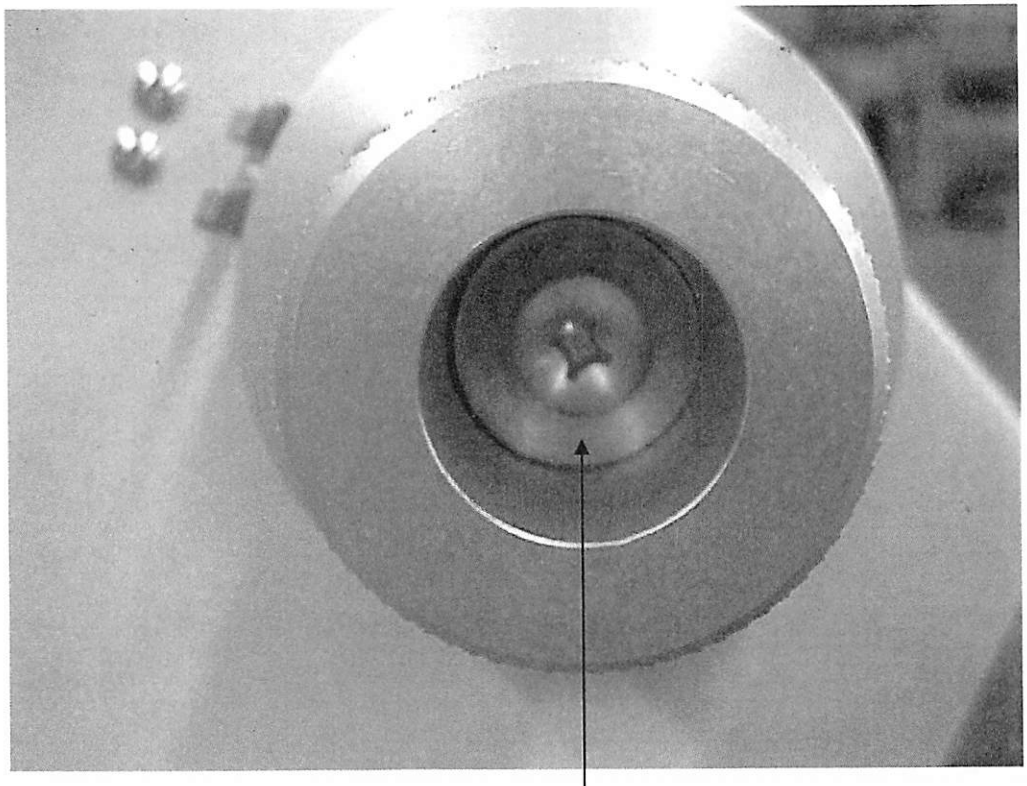
XL44 INDEXING HANDLE INSTALLATION

1) ATTACH INDEXING KNOB ASSEMBLY OVER RIGHT HOUSING USING (4) 10-32 X 1 ¼ FH. SNUG TWO OPPOSING SCREWS, THEN TIGHTEN ALL FOUR.

2) INSERT HANDLE TENSION SPRING (PRS061) RACK 5 INTO OPEN END OF INDEXING KNOB.

3) SECURE HANDLE TENSION SPRING WITH ¼-20 X ¾ TRUSSHEAD AND (1) ¼ X 1 FENDER WASHER .250KKF01 AS12.

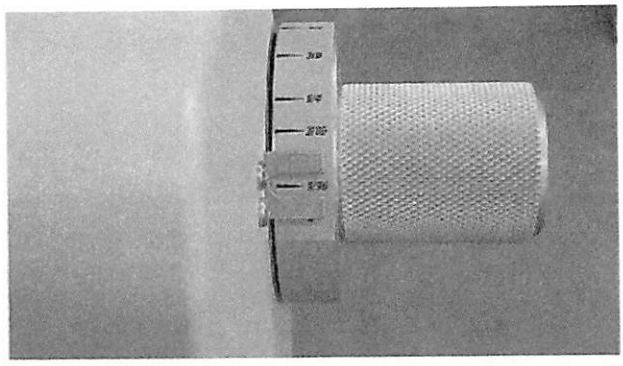




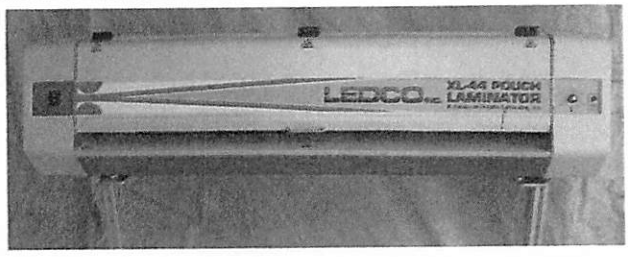
HANDLE TENSION SPRING UNDER FENDER WASHER

XL44 NRTL LABELS

1) ALIGN AND ADHERE POUCH ROLL POSITIONING LABEL (LAB47) RACK 5 ONTO INDEXING HANDLE, WITH KNOB STOP LOCATED IN SECOND HOLE (1/16). CENTER SO 1/16 IS IN APETURE ANGLE.



2) OPEN AND CLOSE FRONT COVER TO CHECK INSTRUCTION AND CENTER LABELS. LAB046 HAS THREE PARTS; RIGHT AND LEFT FOR CONTROL PANELS AND THE CENTER.



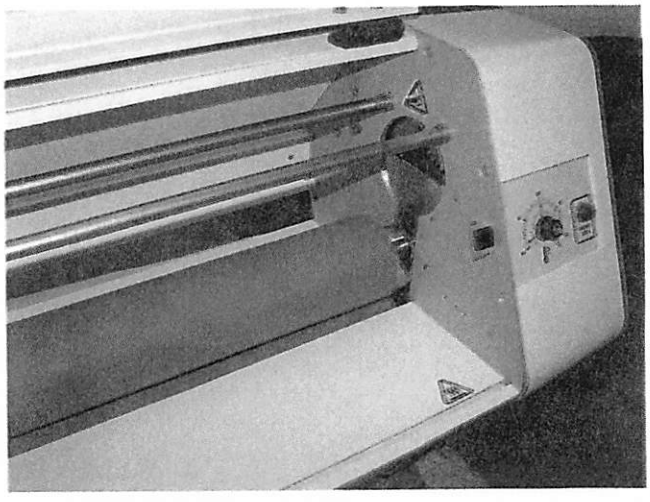
3) ADHERE (6) INTERNATIONAL "HOT" WARNING LABELS (LAB100) AS09, (3) ALIGNED WITH COVER HINGES ON FRONT COVER, ONE INCH BELOW HINGE; AND (3) ON OUTER FEED TABLE BY CHANNEL.

4) ADHERE A WHITE/BLACK ETL LABEL ABOVE THE POWER CORD RECEPTACLE.

5) ADHERE XL44 SERIAL TAG (LAB49) WITH JOB TO REAR BOTTOM COVER LEFT OF RECEPTICLE.

6) ADHERE (2) ½ AMP FUSE LABELS (LAB109) RACK 5 ABOVE FUSE HOLDERS ON BOTTOM COVER.

7) ADHERE MADE-IN-AMERICA LABEL (XS33) LD06 RIGHT OF FUSE HOLDER BY RIGHT SIDE PANEL, ON BOTTOM COVER.



8) ADHERE (2) "DANGER ROTATING GEARS" LABEL (LAB52A) AS09 ABOVE CIRCULAR INNER SIDE PANEL OPENINGS WHICH ALLOW ACCESS TO INNER HOUSING GEARS.

9) CENTER A STICK ON RUBBER BUMPER (PRR266) RACK 5 OVER PIVOT ANGLE HOLE.

XL44 TESTING

1) SET PRESSURE AT 1/16. CONFIRM VOLTAGE AND PLUG IN LAMINATOR.

2) INITIATE ON/OFF ROCKER SWITCH ON LEFT: GREEN SWITCH LIGHT AND RIGHT RED INDICATOR LIGHT WILL RESPOND.

3) SET TEMPERATURE AT 350 DEGREES. CHECK DRIVE ROLL MOVEMENT.

4) WARM UP TIME IS APPROXIMATELY 45 MINUTES. WHEN RED INDICATOR LIGHT GOES OUT SET TEMPERTURE IS REACHED. USE PYROMETER TO RECORD (5) HOT ROLL TEMPERATURES ON INSPECTION SHEET. TEST AREAS SHOULD NOT EXCEED 30 DEGREE VARIANCE.

5) SET HANDLE AT POUCH HEIGHT (3/16). PREPARE TEST MATERIAL. PLACE THE "LEDCO TEST LAMINATION SHEET" AND OTHER TEST MATERIAL UNDER TEST BOARD COVER. THE CLOSED END OF BOARD GOES INTO LAMINATOR FIRST WITH SHEET UPWARD. ROLLS ACCEPT MATERIAL EASIER IF YOU TILT END OF BOARD UPWARD WHILE HOLDING.

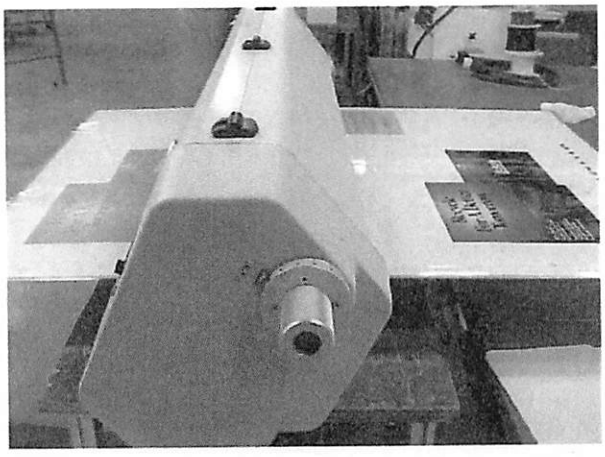
6) COOL LAMINATE. CHECK ADHESION ON EDGE AND CORNERS. RUN "X" TEST. TRIM "LEDCO TEST LAMINATE."

7) CHECK AUTOMATIC HEAT CYCLING BY TURNING OFF WHEN TEMPERATURE IS REACHED AND TURNING ON WHEN TEMPERATURE DROPS.

8) TURN OFF HEAT. PLACE HOT ROLL IN THE UP POSITION. CLEAN MACHINE, INCLUDING ROLLS. CAUTION, VERY HOT!! TURN OFF POWER AND UNPLUG. LEAVE HOT ROLL UP.

9) PLACE 110V POWER CORD (PRC118) LD08, XL44 MANUAL (XS83) AS07, TRIMMED TEST SHEET AND PAPERWORK ON FEEDTABLE. ALSO INCLUDE A STRIP OF BOARD TO SEPARATE ROLLS DURING FREIGHT.

PLUG FOR 110V POUCH LAMINATOR



XL44 220V NRTL
HIGH POT TESTING

1) TO COMPLY WITH 2/2009 U.S. ETL FOR U.S. CERTIFICATION THE 220V XL44 NRTL MUST PASS A HIGH POT TEST FOR POWER LEAKAGE AND GROUNDING. THE PROCEDURES FOR THE HIGH POT TEST ARE AS FOLLOWS.

2) WITH HIGH POT TESTER POWER SWITCH IN "OFF" POSITION CONNECT <u>TESTER POWER/GROUND CORD</u> BETWEEN THE "INPUT" INLET ON TESTER AND A 110 VOLT POWER SOURCE. THE WHITE "TESTER GROUND" LAMP GLOWS AMBER IF GROUND IS SATISFACTORY. THIS INDICATES THE <u>TESTER</u> IS GROUNDED.

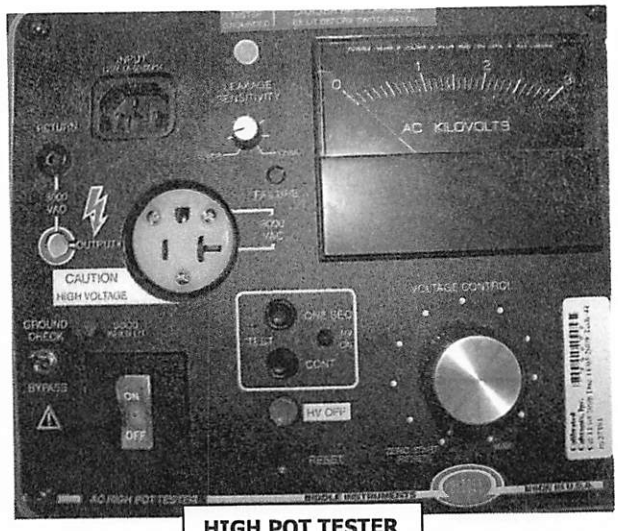
3) ***CLEAR THE AREA!! DO NOT TOUCH THE MACHINE OR THE CORD WHILE HIGH POT TESTING, AS SEVERE SHOCK MAY OCCUR IF MACHINE FAILS TEST.***

4) WITH "GROUND CHECK" SWITCH *UPWARD*, PLUG THE TESTER <u>MACHINE GROUND CORD</u> BETWEEN THE "RETURN" INLET ON TESTER AND THE PIVOT ANGLE LOCATED ON THE INNER LEFT SIDE PANEL. CLAMP THE TOOTHED END OF THE <u>MACHINE GROUND CORD</u> ONTO PIVOT ANGLE. THE PIVOT ANGLE IS HELD BY SCREWS INTO THE SIDE PANEL AND THAT GENERALLY CONDUCTS A GOOD GROUND.

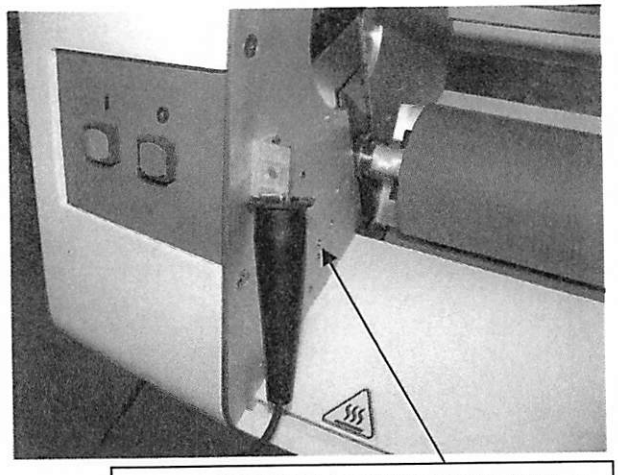
5) PLUG THE <u>XL44 POWER CORD</u> BETWEEN THE XL44 RECEPTACLE AND "OUTPUT" INLET ON THE HIGH POT.

6) PRESS HIGH POT ROCKER SWITCH TO "ON" POSITION. THE GREEN "GOOD WHEN LIT" LIGHT GLOWS WHEN MACHINE IS GROUNDED.

7) WITH "ZERO/START" ON "VOLTAGE CONTROL" DIAL, PRESS THE BLACK "RESET" BUTTON.



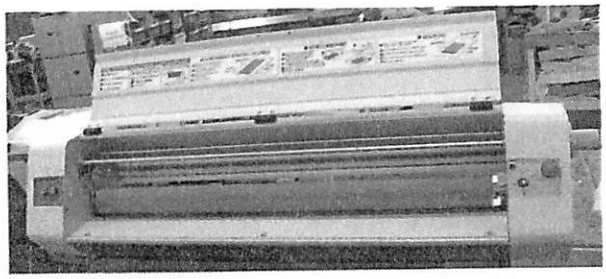
HIGH POT TESTER


TESTER MACHINE GROUND CORD ON XL44

INSERT XL44 POWER CORD INTO RECEPTACLE

8) **PRESS THE BLACK "CONT" BUTTON. THE RED "HV" LIGHT COME ON.**

9) **WITH "VOLTAGE CONTROL" STILL AT ZERO/START, INCREASE AC KILOVOLT DIAL CLOCKWISE TO 1.6 AC KILOVOLTS ON THE REGISTER SCREEN. <u>MAINTAIN 1.6 AC KILOVOLTS FOR TWO SECONDS</u>. A *HIGH POT TEST FAILURE* REGISTERS WITH AN AMBER "FAILURE" LIGHT AND A "BEEP" SOUND.**



10) **TO END THE HIGH POT TEST, RETURN THE "VOLTAGE CONTROL" DIAL TO "ZERO/START," PRESS THE "HV OFF" BUTTON, "HV ON" LIGHT GOES OUT.**

11) **TURN "OFF" THE HIGH POT TESTER ROCKER SWITCH, <u>UNPLUG "INPUT" POWER CORD FIRST</u>, THEN THE UNPLUG REMAINING CORDS.**

XL44 GROUND, TESTER POWER/GROUND, XL44 POWER CORD

Obsolete 4/2019 See 14" Crating manual

XL44 POUCH LAMINATOR PACKING & CRATING 2014

1) PREPARE THE XL44 CRATING PLATFORM WITH STANDARD 2X4 BOARDS. USE THE FOLLOWING PIECES FOR LENGTH, ENDS AND MIDDLE SUPPORT CONNECTIONS:
(2) 66" PIECES FOR LENGTH
(4) 20" PIECES FOR ENDS **WITH OSB BOARD BETWEEN END PIECES
(4) 15" PIECES FOR MIDDLE SUPPORT
(2) 20" OSB BOARDS FOR SEPARATION OF END PIECES-THE OSB BOARDS FULLFILL THE 3 ½" REQUIRED SKID HEIGHT.

2) THE BOX USED FOR THE XL44 POUCH LAMINATOR IS A TRI-WALL CARTON (XS81) WAREHOUSE.

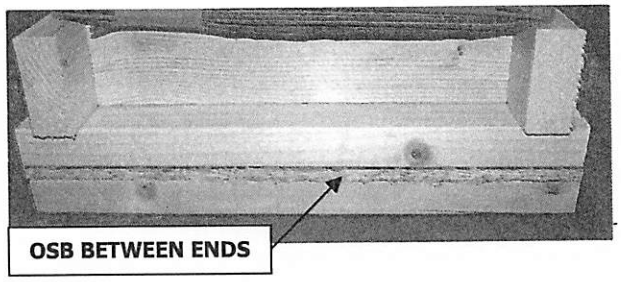
3) USE (2) 14 3/8 X 15 ½ SIDE CUSHIONS FROM KIT. THE RIGHT SIDE HAS TO HAVE A HOLE DRILLED OUT TO ACCOMMODATE THE INDEX HANDLE.

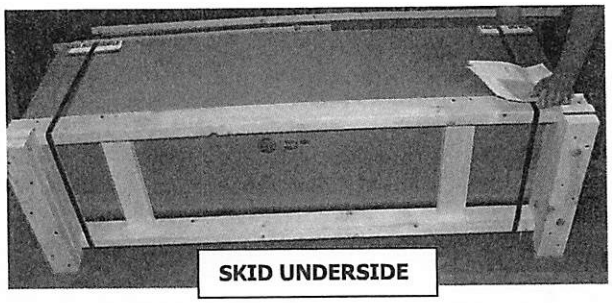
4) RAISE HOT ROLL AND INSERT FOAM BOARD BETWEEN HOT AND DRIVE ROLLS TO PREVENT FLAT SPOTS ON ROLLS. YOU CAN USE THE FOAM BOARD FROM DISCARDED TEST PIECES.

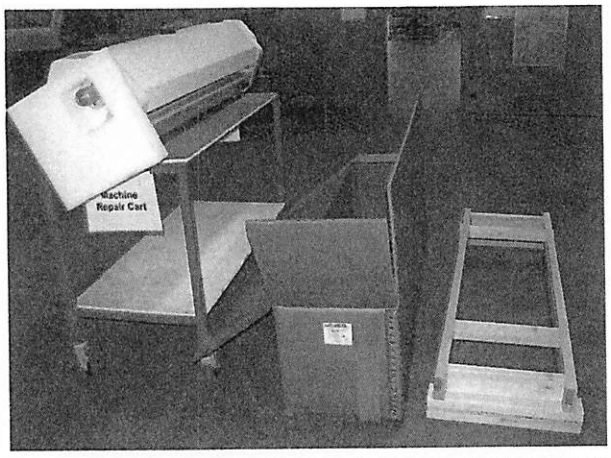
5) PLACE TOP COVER IN CLOSED POSITION. MOVE LAMINATOR ON CART NEXT TO BOX, LOCK CASTERS. PUT LAMINATOR IN CARTON. THIS IS A ***TWO-PERSON*** JOB DUE TO WEIGHT OF MACHINE.

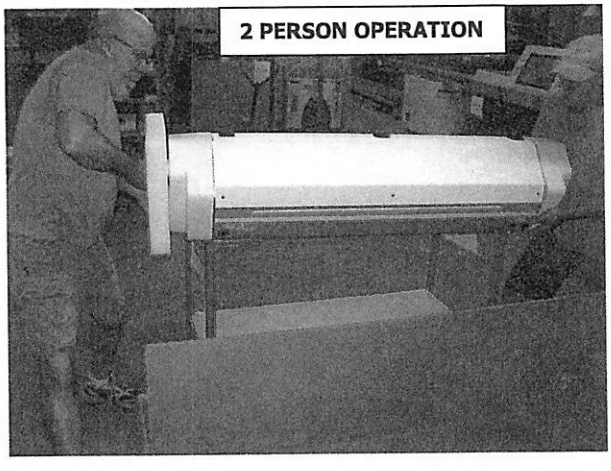
6) PLACE XL44 MANUAL (XS83), REMOVABLE CORD (PRC118), XL44 CD, WARRANTEE CARD AND SAMPLE LAMINATE WITH TESTER'S NAME, EMPLOYEE NUMBER AND DATE ON IT IN CARTON.

7) THE CUSHIONS FROM THE KIT SHOULD BE ON BOTH SIDES OF LAMINATOR, WITH THE HOLE OVER THE HANDLE. CLOSE CARTON, TAPE SHUT AND SECURE WITH (2) BANDS.







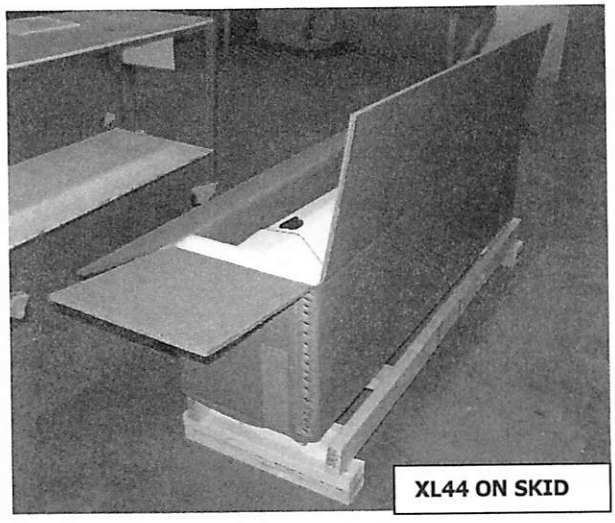


8) INDICATE ON (2) LEDCO XL44 IDENTIFICATION LABELS THE LAMINATOR'S SERIAL NUMBER AND VOLTAGE. 220 VOLT MACHINES CAN USE RED INK MARKERS, THE 110 VOLT MACHINES USE BLACK MARKER INK. ADHERE THE XL44 IDENTIFICATION LABEL TO BOTH UPPER ENDS OF THE CARTON.

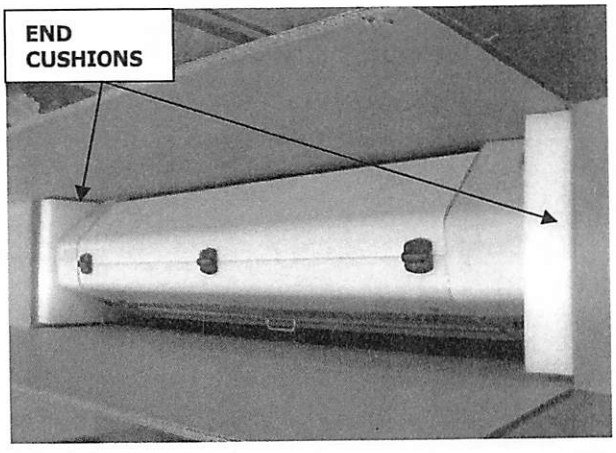
9) ADHERE (2) RED AND WHITE "FRAGILE" LABELS TO THE UPPER TOP ENDS OF THE CARTON.

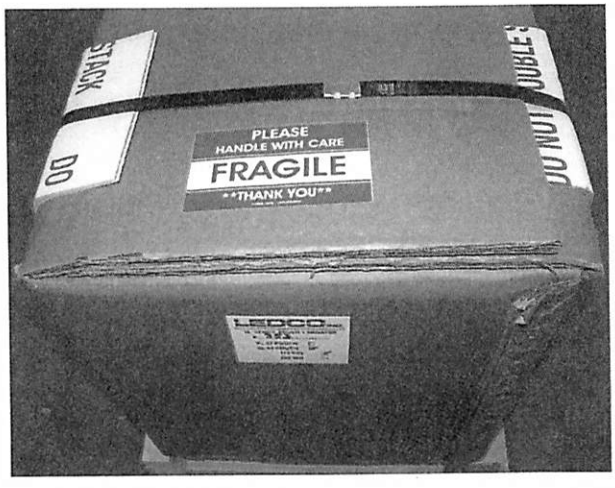
10) THE XL44 POUCH LAMINATOR SKID PLATFORM DIMENTIONS ARE 68" LONG BY 18" WIDE. THE SKID IS BANDED ON BOTH ENDS.

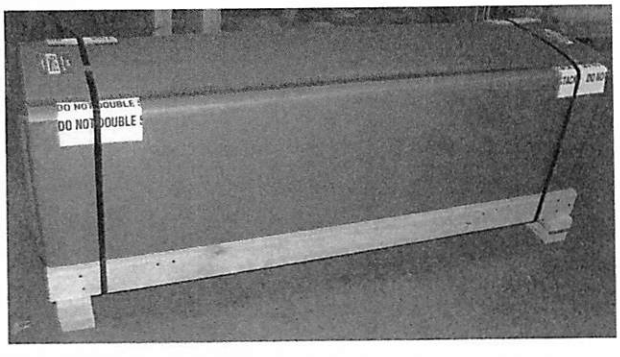
11) THE XL44 IS NOW READY FOR SHIPPING.

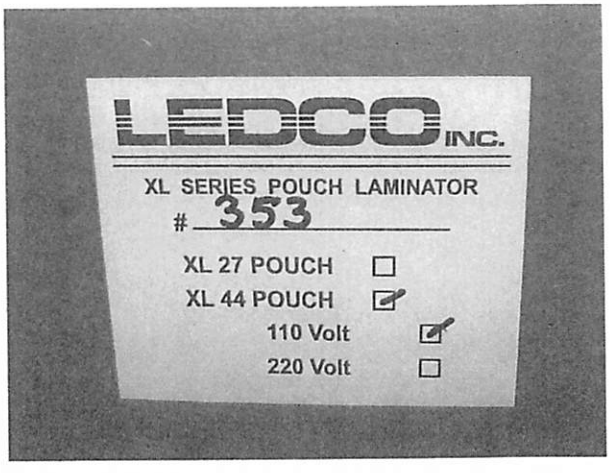


XL44 ON SKID







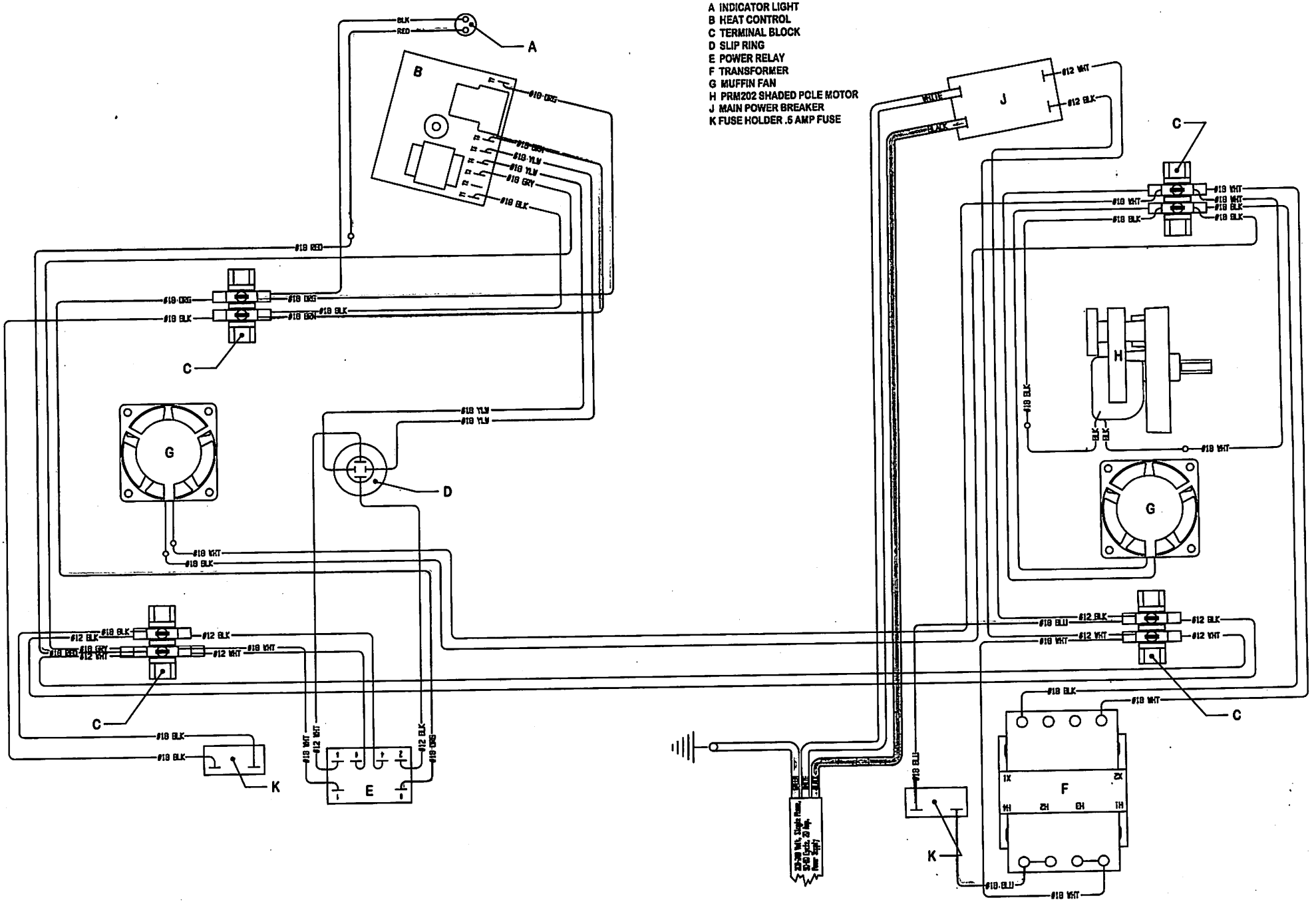


XL44 POUCH LAMINATOR 208V-250V WIRING DIAGRAM W/FAN

OLD

LEGEND

A INDICATOR LIGHT
B HEAT CONTROL
C TERMINAL BLOCK
D SLIP RING
E POWER RELAY
F TRANSFORMER
G MUFFIN FAN
H PRM202 SHADED POLE MOTOR
J MAIN POWER BREAKER
K FUSE HOLDER .5 AMP FUSE



XL44 220 VOLT CONVERSION

1) CHANGES TO CONVERT AN XL44 110 VOLT POUCH LAMINATOR TO A 220 VOLT FOLLOW. THE REMAINDER OF ASSEMBLY IS THE SAME AS 110V.

2) THE 110 VOLT BOTTOM COVER HAS TO BE REWORKED IN THE SHOP; A PLATE IS POP RIVITED IN PLACE TO FILL THE 110 VOLT RECEPTACLE OPENING. AN OPENING PUNCHED LEFT OF PLATE TO ACCOMMODATE 220 VOLT POWER CORD. DEBUR CORD OPENING.

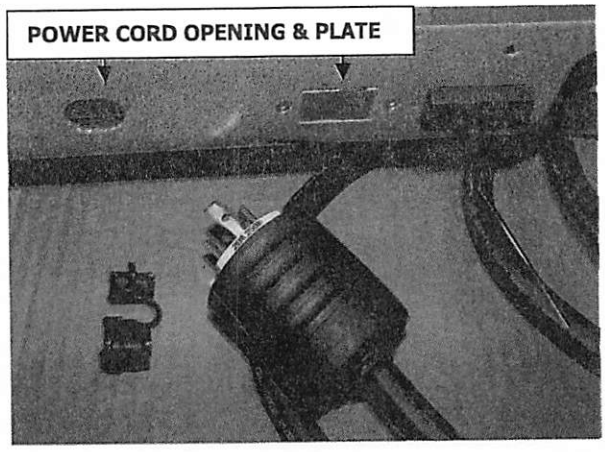
3) PREPARE THE XL44 HOT ROLL BY INSERTING A 220 VOLT HEATER (PRH180) AS07. ADD SEALANT TO THE CERAMIC HEATER END. USE THE SAME SENSOR AS ON THE 110 VOLT. STAKE HEATER AND SENSOR.

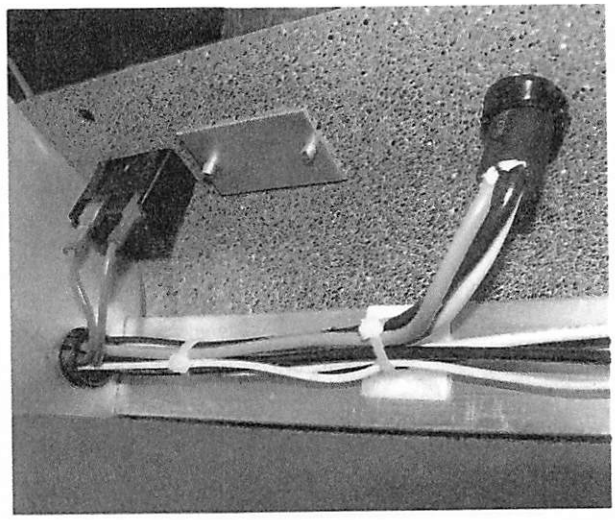
4) ON THE RIGHT SIDE PANEL, SECURE THE 220 VOLT RELAY (PRR231D) CP01. USE (2) 8-32 X ¼ RH.

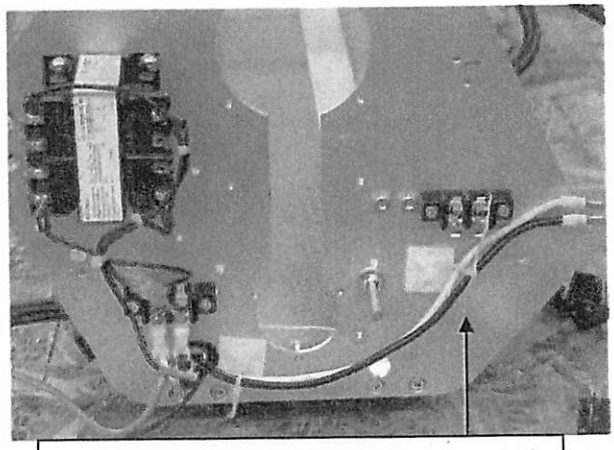
5) STRIP 19" OF BLACK SHEATHING OFF POWER CORD (PRC220) AS03. INSERT POWER CORD INTO BOTTOM COVER, SECURE WITH STRAIN RELEASE (PRB066) AS03.

6) CAREFULLY EXIT POWER CORD WIRES THROUGH BOTTOM MOTOR COVER THROUGH LEFT SIDE SNAP BUSHING. THE GREEN GROUND WIRE IS SHORTENED AND CONNECTS TO THE REAR EXIT TABLE SCREW DURING CHASSIS WORK. USE A #10 STAR WASHER BETWEEN GROUND RING CONNECTOR AND SIDE PANEL AND A PRESS CLIP TO LOOP AND SECURE GROUND WIRE TO SIDE PANEL.

7) RUN 60" EACH OF 18 GAUGE WHITE AND BLACK WIRE THROUGH MACHINE, ALONG WITH BLACK AND WHITE 12 GAUGE IN WIRING HARNESS. USE (3) BRADY PRESS CLIPS AND TIE. ON







LEFT SIDE: EXTRA TERMINAL BLOCK & 220V POWER CORD WIRES EXTEND FOR BREAKER

MOTOR SIDE CRIMP (PRT331) FEMALES ONTO 18 GAUGE WIRE. ATTACH TO ~~RIGHT~~ left, FRONT TERMINAL BLOCK; WHITE 18 GAUGE ON 2A, BLACK 18 GAUGE ON 3A. LEAVE ENOUGH WIRE FOR A COMFORTABLE TIE.

8) AN ADDITIONAL TERMINAL BLOCK (PRT326) AS10 IS ADDED TO THE FRONT LEFT SIDE PANEL. IT HAS (2) 90 AND 45 DEGREE TERMINAL POSTS.

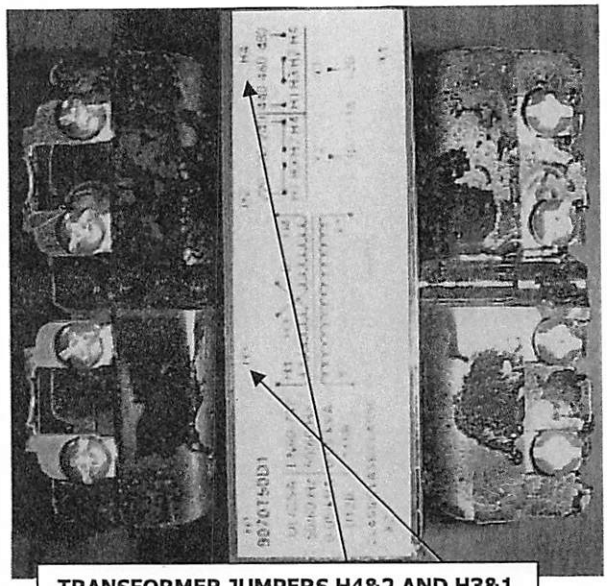
9) CUT 16" OF BLUE 18 GUAGE WIRE. CONNECT ONE SIDE TO OUTER FUSE HOLDER TERMINAL POST BY THE SIDE PANEL USING FEMALE (PRT331). THE OTHER END WILL CONNECT TO H4 ON TRANSFORMER USING SPADE CONNECTOR (PRT294).

10) ATTACH TRANSFORMER (PRT324) AS08 WITH (4) 8-32 X ¼ TH AND (4) #8 WASHERS. H4 WILL BE UPPER LEFT. ADD (2) BAGGED JUMPERS CONNECTING H2 AND H4 AND CONNECTING H3 AND H1. USING (4) SPADE CONNECTORS (PRT294) WIRE TRANSFORMER AS FOLLOWS: CONNECT H4 TO LONGER BLUE 18 GAUGE COMING FROM FUSE. CONNECT H1 TO 9" OF 18 GAUGE WHITE WITH OTHER END CONNECTING TO LEFT TERMINAL 1B. CONNECT X1 WITH 20" OF BLACK 18 GAUGE CONTINUING TO ~~RIGHT~~ front TERMINAL 3B. CONNECT X2 WITH 17" OF WHITE 18 GAUGE CONTINUTING TO ~~RIGHT~~ front TERMINAL 4B.

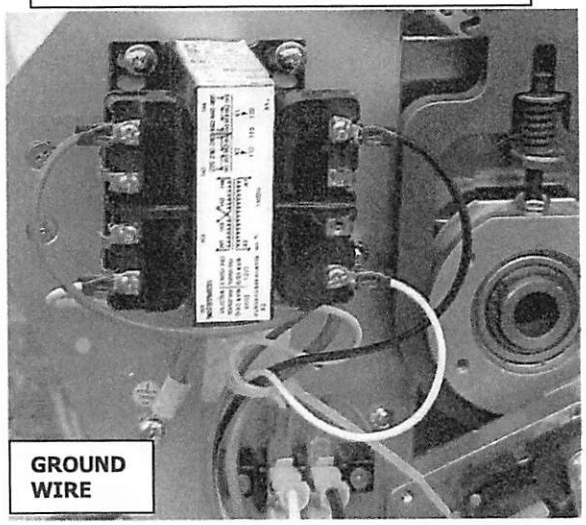
11) PREPARE 20 AMP BREAKER (PRS287) AS01 AS02 BY INSERTING INTO CONTROL PANEL PLATE (XL44 047.4) AS10 AND SECURING WITH (2) 6-32 X 3/8 FH. THEN ADD GREEN LABEL. NOTE: "OFF" POSITION IS ON TOP WITH ***STRAIGHT SIDE OF PANEL PLATE TO THE RIGHT***.

12) ATTACH BLACK AND WHITE POWER CORD WIRES, IDENTIFIED AS "LINE" TO UPPER INDICATED AREAS. ATTACH BLACK AND WHITE 12 GAUGE "LOAD" WIRES FROM LEFT TERMINAL BLOCK.

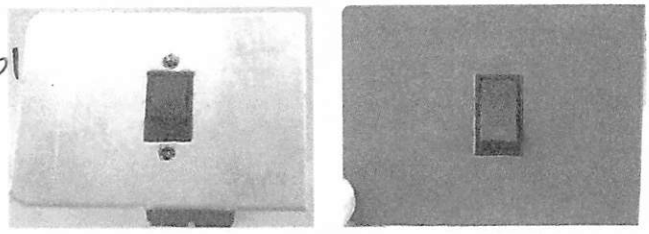
13) USE .3125 REAMER ON LEFT SIDE DRIVE ROLL AND ATTACH THE MOTOR SAME AS

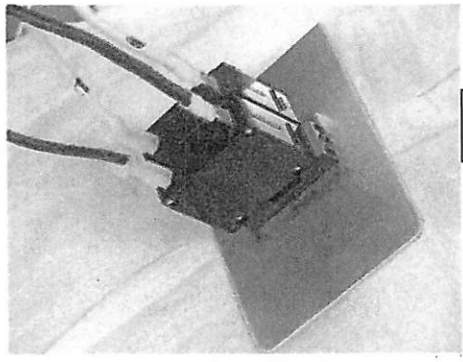


TRANSFORMER JUMPERS H4&2 AND H3&1



GROUND WIRE



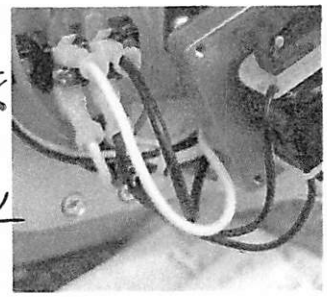


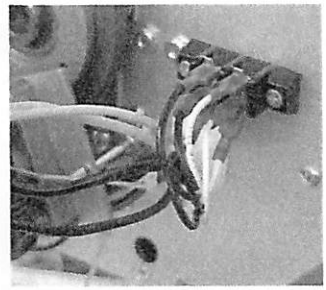
20 AMP BREAKER

ON XL44 110 VOLT. USING COVERED MALE AND FEMALE CONNECTORS ADD 9" OF BLACK 18 GAUGE WIRE TO TOP, front MOTOR WIRE, THEN CONNECT TO RIGHT TERMINAL 1A. ATTACH BOTTOM MOTOR WIRE WITH 8" OF WHITE 18 GAUGE WIRE, CONNECT TO RIGHT TERMINAL 4A.

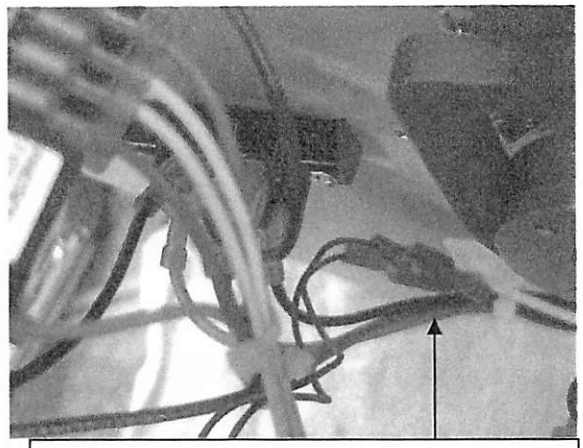
9"

front





14) ON RIGHT SIDE PANEL TRIM AND TERMINATE BLACK AND WHITE 18 GAUGE WIRES THAT RUN THROUGH THE BODY OF THE MACHINE WITH MALE TERMINALS (PRT330) TO A LENGTH THAT CONNECTS WITH FAN WIRES AND TIES LEFT OF TRUNION.



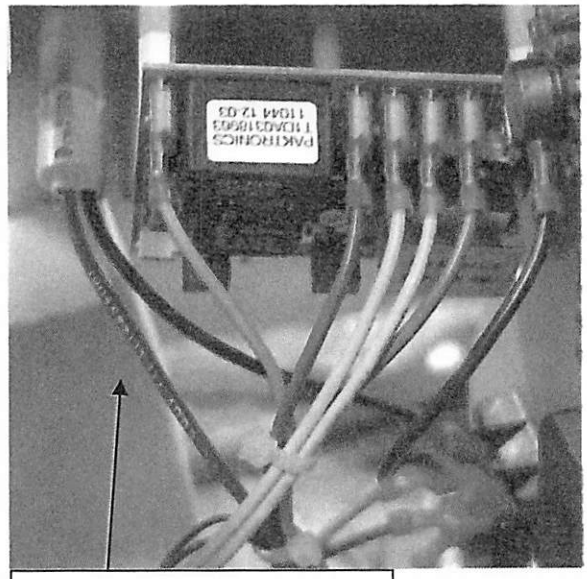
RIGHT SIDE: THIN FAN WIRES CONNECT TO WHITE & BLACK THROUGH BOTTOM COVER

15) WHEN PREPARING THE HEAT CONTROL PANEL PLATE, WIRE THE HEAT CONTROL PANEL THE SAME AS THE 110 VOLT EXCEPT THE BLACK WIRE ATTACHES TO THE END POST, T1. ALSO THE RED INDICATOR LIGHT (PRL199) LDP1 IS USED INSTEAD OF THE 110 VOLT RED LIGHT. CONNECT THE RED LIGHT WIRE WITH THE RED WIRE FROM WIRING HARNESS BAG TO RIGHT SIDE TERMINAL 4A.

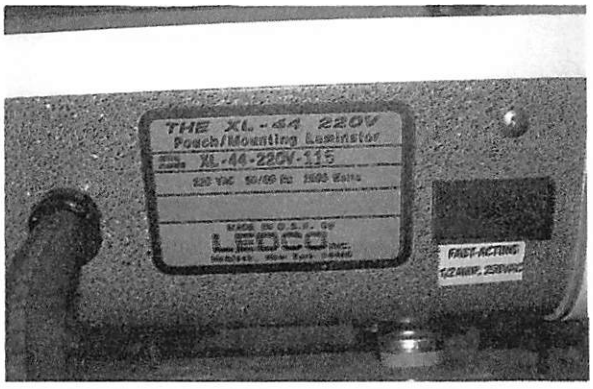
left 0

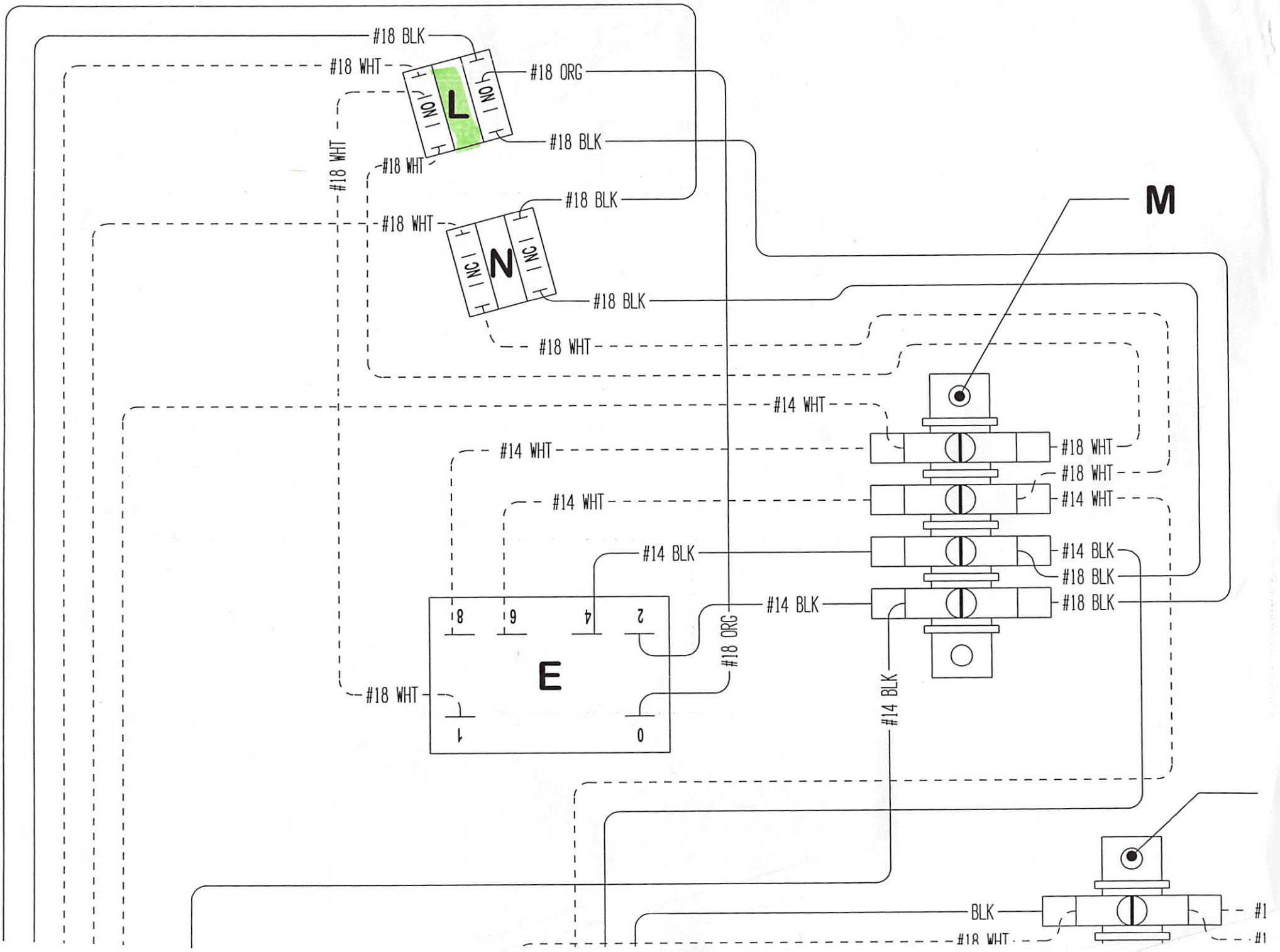
16) TO TEST, ADD A 20A ADAPTOR CORD PLUGED INTO A 60HZ OUTLET.

17) THE SERIAL TAG COVERS PLATE AND THE FUSE LABEL ADHERES BELOW FUSE.



RED WIRE ON (PRL199) LIGHT




#18 BLK
#18 WHT
#18 ORG
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