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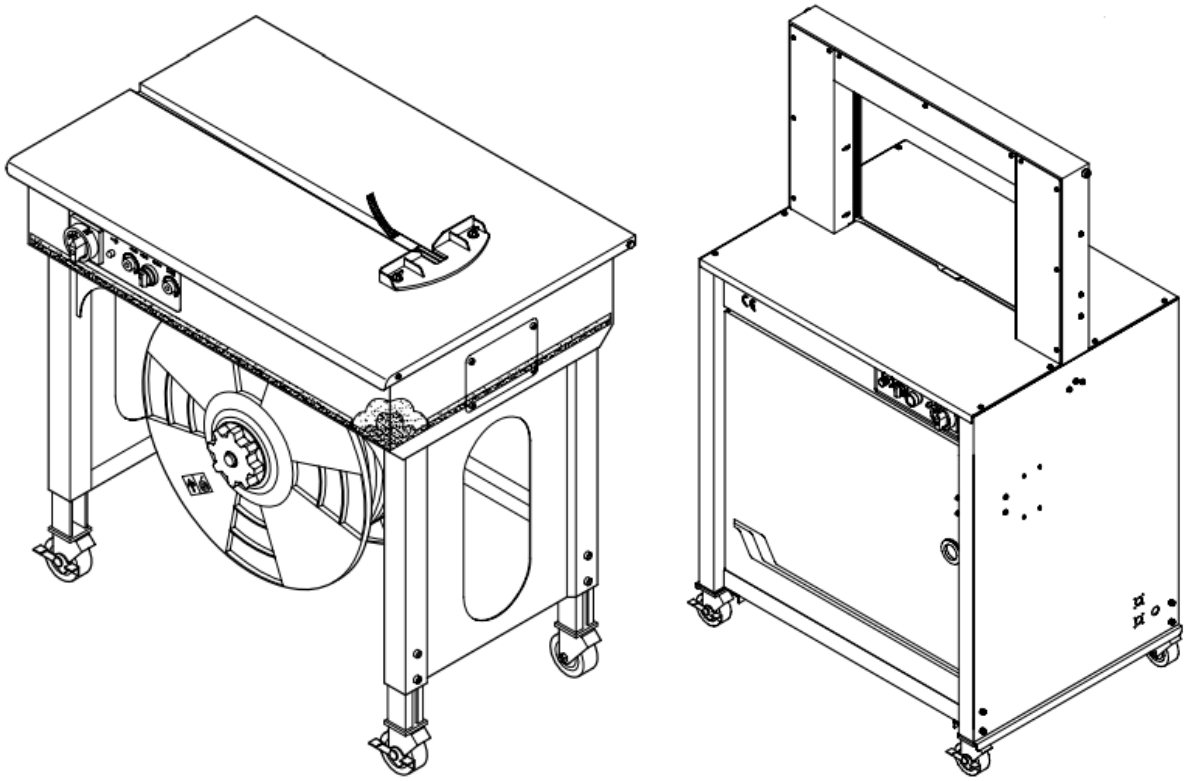
Heater Tongue (T7-1-12111)
Installation Guide
for
Polypropylene Strapping Machine

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General Information

This document is a guide for Heater Tongue Assembly. Listed below are the machines which are compatible to the T7-1-12111 Heater Tongue spare part:

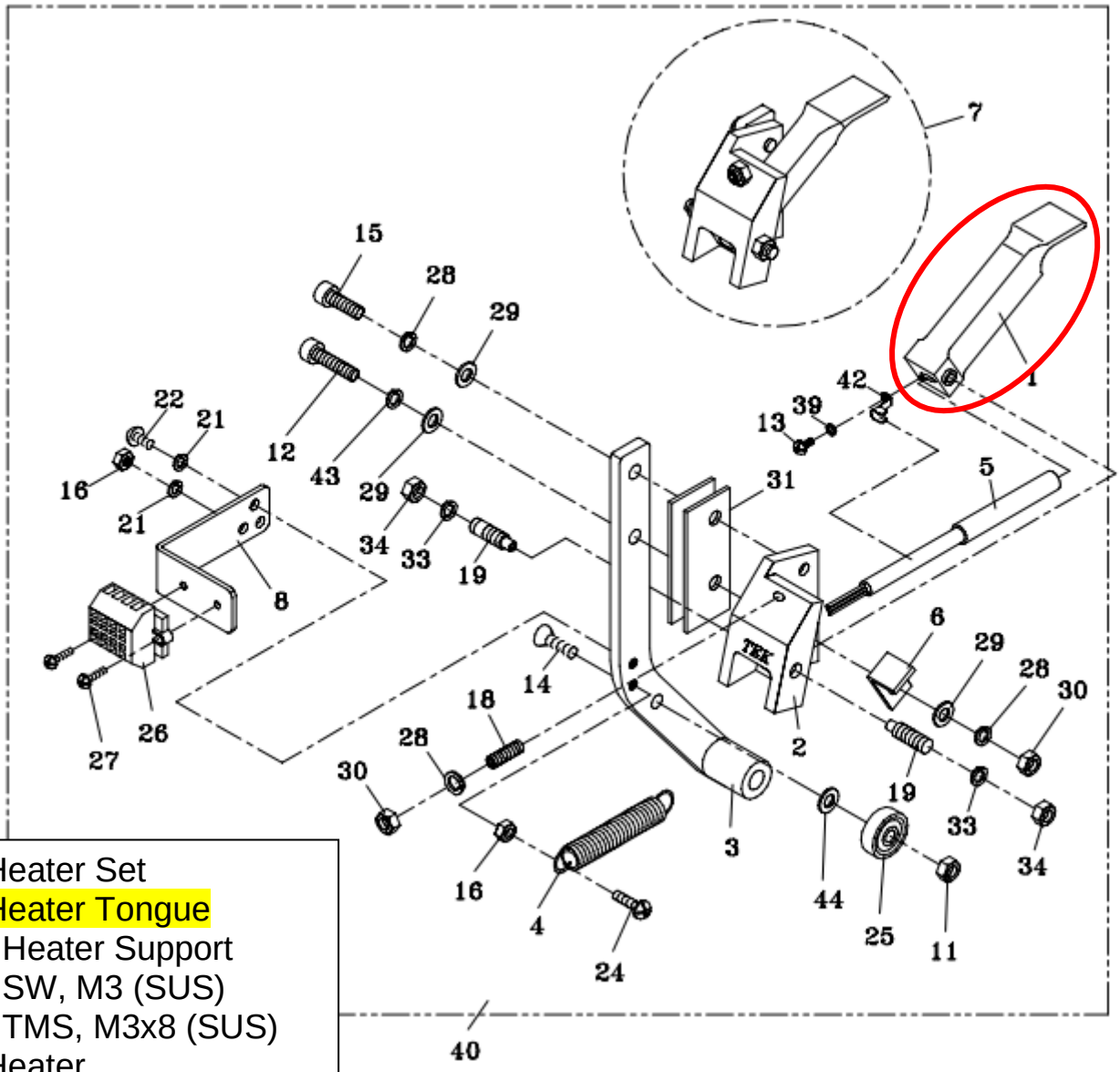
- TP-501
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Spare Parts Assembly

T7-1-12111 Heater Tongue is a part for the Cam Group in the Strapping Head Group of the Polypropylene Strapping Machine. The Heater Tongue is connected to the following spare parts:



7 – Heater Set
1 – Heater Tongue
42 – Heater Support
39 – SW, M3 (SUS)
13 – TMS, M3x8 (SUS)
5 – Heater
6 – Bracket
29 – PW, M5 (SUS)
30 – HN, M5 (SUS)
34 – HN, M6 (SUS)
33 – SW, M6 (SUS)
19 – Screw M6x20 (SUS)
2 – Heater Bracket
31 – Heater-Insulation
3 – Heater Arm
15 – HBS, M5x16 (SUS)
12 – HBS, M5x20 (SUS)

40 – Heater SUB Ass'y
43 – SW, M5
22 – PMS, M4x8
21 – SW, M4
16 – HN, M4
27 – PMS, M3x10
26 – Heater Terminal
8 – Terminal Bracket
28 – SW, M5 (SUS)
14 – FMS, M5x15

4 – Return Spring
24 – PMS, M4x20
11 – HN, M5
18 – HSS, M5x16 (SUS)
25 – Bearing, 635ZZ
32 – Smoke Fan Bracket
41 – Fan SUB Ass'y
44 – PW, M5

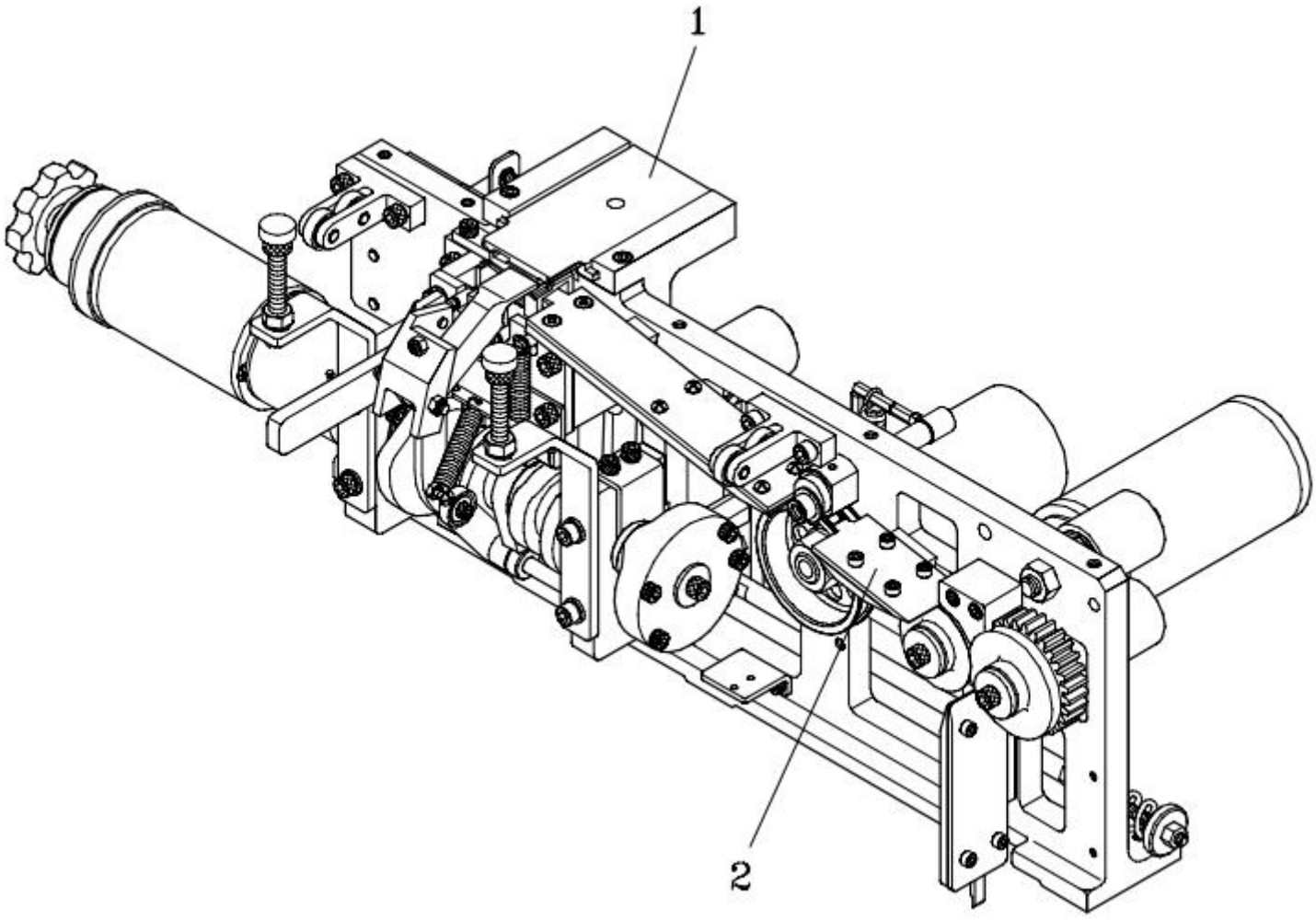
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T7-1-12111 Heater Tongue is installed and placed on Heater Set (T7-1-12170) and Heater SUB Ass'y (T7-1-12501). It is attached with the Heater (T5-1-12320).

Installing Heater Tongue

1. To install the Heater Tongue, secure that Power Switch is turned off before taking off the front and rear table plates.
2. It is required that the Heater Tongue is enabled to move back and forth freely, screw needs to be adjusted to get this done. Next is to secure that the horizontal movement of Heater Tongue is within 1mm. Take note that both side of the Heater Tongue shouldn't touch Heater Bracket. Tighten HNO6S's screw on the right-hand side of the Heater Tongue but leave left-hand side tight.
3. The M1 Motor Handle Wheel should be rotated to enable the Heater Tongue to go between Slide Table and Press Bar. Keep the rotating motion on the motor Handle Wheel up until the Heater Tongue is pressed between the Slide Table and Press Bar. After, tense or tighten both HBS0520S and HBS0516S of the Heater Bracket
4. The M1 Motor Handle Wheel needs to draw Heater Tongue and Slide table progressively apart. During the process where Heater Tongue is to be parted from the Slide Table, lift the Heater Tongue with right hand and use left hand to change the position of HSS0516S this is to make it touch the Heater Tongue a little bit. It is necessary that the top surface of the Heater Tongue is around 0.5mm higher than that of the bottom surface of the Slide Table. For last, tighten the HN05S screw.
5. Lift the Heater Tongue Bracket and change the position until it is very near the Heater Tongue.
6. Alter the position of the Heater Tongue until the top surface is around 2mm lower than that of the bottom surface of the Slide Table. Lock the Bracket in place with HN05S.
7. When Bracket is locked, turn on the Power and wait for the ready lamp to light up. Make sure to check the Heater Tongue, it should move freely back and forth and should be able to move horizontally within 1mm. If everything is done and in position, then it is time to tighten the HN06S on the Screw at the left-side of the Heater Tongue which was left in hand tight at STEP 3.

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Strapping Head Unit
1 –Strapping Head Group
2 – Feed Group

[Disclaimer: It is not the responsibility of HBC/STEP for the service you perform and the choice and securing of skills needed by person doing the service.]

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Images



[T7-1-12111 Heater Tongue Drawing]



[Actual Image]

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