QUALITY PRACTIX MFG. - U.S.A. THROUGH INNOVATION

4400 Cantrell/Practix Road Acworth, GA 30101 (770) 974-1480

FAX (770) 974-1584

OK-405OIL 72" Rotary Transfer Machine

24" DIA DRUM

Operations Manual

Serial No._____ Voltage:_____

Purchaser:_____

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WARRANTY

Practix Mfg. LLC will replace free of charge, F. O. B. Purchaser's plant, within 365 days (1 year) from time of shipment to the original purchaser, any mechanical part, within six (6) months any electronic component, and within six months (6) on a prorated basis any belt found in our judgment to be defective. This Warranty is based on an eight (8) hour per day work/operating schedule.

This Warranty does not cover damage to the Machine or any part thereof found in our judgment to be the result of accident, negligence, or misuse. This warranty shall become ineffective if the product or component is altered by anyone other than Practix employees. Damage incurred in shipment should be reported to the designated carrier. It is his responsibility to ensure arrival in perfect condition.

This Warranty covers only labor and material. Expenses will be charged at cost. This warranty does not include installation of the product or component.

This Warranty is registered in the name of the original Purchaser and is non-transferable.

Practix Mfg. LLC will, in no case and under no circumstances, be liable for special or consequential damages, loss of profit or commission or for loss or delay in production.

Warranty will be non-redeemable if the balance on the Purchaser's account for the product is delinquent.

I have received and read this manual.

_____

Signature

PRACTIX MFG.
4400 Cantrell Road
Acworth, GA 30101
Phone: (770) 974-1480
Fax: (770) 974-1584

Mechanical Warranty Begins_____**through**_____

Electrical Warranty Begins_____**through**_____

WARNING!

At no time during the operation of the machine should any beverages or liquids be placed anywhere on the top of the Machinery to prevent injury from electric shock.

It is the responsibility of the Purchaser of this Machinery to train his personnel in the proper manner of operation.

It is further understood that Practix Mfg. Assumes no responsibility for injuries, disabilities, or death resulting from the improper operation of, removal from the Machinery, or bypassing of any electrical or mechanical safety devices incorporated in the design and manufacture of this Machinery.

NOTE: During the first few hours of operation the Machinery will release fumes due to the normal curing of coating materials.

PRACTIX MFG.
4400 Cantrell Road
Acworth, GA 30101

We at Practix Mfg. appreciate your purchase of our product. Your new machine is built to perform flawlessly for years to come.

This Operations Manual should be referred to for the installation, operation, and maintenance of this machine. Regular maintenance will ensure a long and trouble-free service life.

Design and development of Practix Machines are subject to constant improvement. There is no obligation on our part to carry out improvements, free of charge, on machines already delivered.

For further questions concerning machine maintenance call:

PRACTIX MFG.
4400 Cantrell/Practix Mfg.
Acworth, GA. 30101
770 974 1480

INSTALLATION

Position the machine on a solid, level section of the floor before removing it from the skid.

NOTE: Leave sufficient clearance around the machine and unwind and rewind units (if applicable) for material movement and maintenance personnel.

1. The electrical connections need to be made by a certified electrician in accordance
   with local standards and electrical codes for 240 Volt- 1 Phase industrial equipment

2. Bring the power supply to the wall adjacent to the machine. Install a breaker.

3. Connect to the main power distribution block on the electrical subpanel.

4. Bring air supply to the machine using hose or pipe.

In case of problems or questions, please contact Practix Mfg.

Leveling and squaring

1. Use a spirit level.

2. Place the level first on the top steel tubing on the front of the machine. Adjust the legs as necessary

3. Place the level on the top steel tubing on the rear of the machine. Adjust the legs as necessary.

4. Place the level across the top of the machine from front to back on the left side of the machine. Adjust the legs as necessary.

5. Place the level across the top of the machine from front to back on the right side of the machine. Adjust the legs as necessary.

WARNING LABELS

Voltage Indicator

This sticker is used to indicate voltage value.

Electrical Shock/Electrocution

This sticker is used to indicate a potential shock hazard from electricity in general area or behind door sticker is affixed to.

Grounding Point

This sticker is used to denote a grounding point.

Hand Crush/Force From Above

This sticker is used to indicate a potential danger of hand crushing from two pieces moving toward each other, i.e. platen pressing, tracking roller movement, or tension roller movement.

Hand Entanglement/Rotating Gears

This sticker is used to indicate a potential danger of hand crushing or entanglement from one or more rotating gears.

Hand Entanglement/Rollers

This sticker is used to indicate a potential danger of hand crushing or entanglement from one or more rotating rollers or shaft.

Burn Hazard/Hot Surface

This sticker is used to indicate a potential hazard from a hot surface.

Warning Risk of Electric Shock

This sticker is used to indicate a potential shock hazard from electricity. Please disconnect the machine from electricity before opening any doors or performing any service to the machine.

Warning/Read And Understand

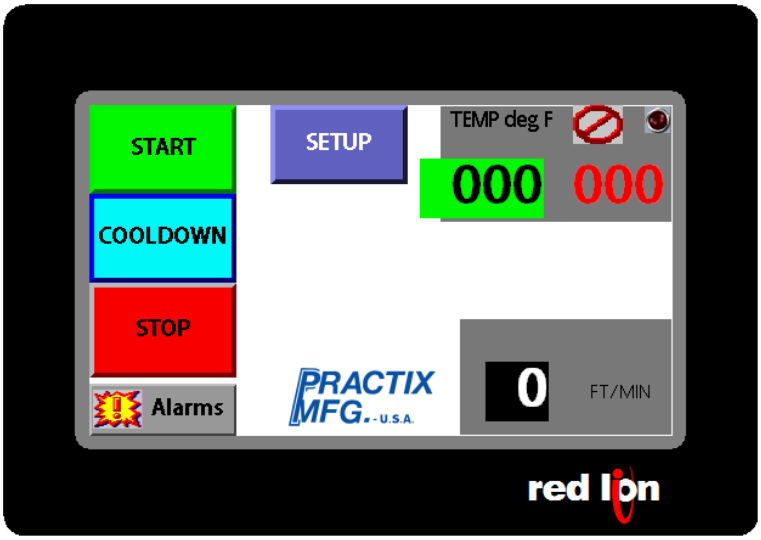
It is highly recommended that everyone who oversees and/or uses this machinery has read and understands this manual.

MACHINE OPERATION

To energize the rotary transfer machine, move the switch marked MAIN DISCONNECT SWITCH to the “ON” position by turning the handle clockwise until a click is heard. Make sure to turn on the compressed air to the machine. THE MACHINE WILL NOT START WITHOUT THE AIR TURNED ON.

Adjust the pressure regulator/filter/lubricator on the backside of the machine to 100 PSI. Next adjust the pressure regulator on the control panel. The pressure regulator should be set to according to the type of material being transferred printed or heat set.

The Practix PCC01 Control Module will be activated and will come to the main home screen as pictured below.



Start:
To start the belt, press the green START button (ITM2). The belt will start to move, and the tracking system will keep the belt centered on the machine. The temperature controller will start functioning and temperature controller ON/OFF indicator will disappear (ITM1).

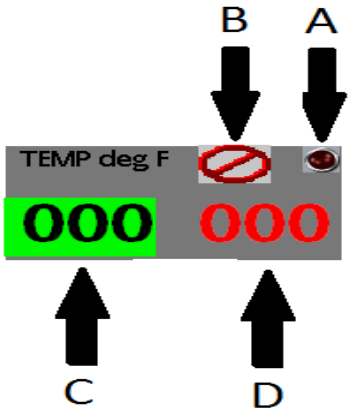
Speed:
Adjust the speed of the machine by pressing the “FT/MIN” button in the lower right corner of the screen. A numeric keypad will popup that will allow the desired speed to be entered. Press the enter button after the desired belt speed is set. Depending on the desired dwell time, the machine speed will vary according to the chart below.

Machine Model	Diameter Drum	Belt Speed w/ Dwell time of 40 seconds
OK-10	10”	2.4 ft/min
OK-12	12”	3 ft/min
OK-405R	24”	7.6 ft/min
OK-400R	40”	12.6 ft/min

To help facilitate faster heat up time of the drum, set the speed to a low setting.

Temperature:
To set the temperature press the green number that is located on the temperature button (ITEM C SHOWN BELOW). A numeric keypad will pop up that will allow the temperature set point to be entered. Press the enter button to accept the entered value for the set point. The red number on the same tab is the current temperature (process value) of the machine (ITEM D SHOWN BELOW). This number will increase or decrease dependent on your command of either running or cool down. The temperature display may vary as the drum rotates due to electrical noise from the commutator. This may be dampened using the line filter in the setup screen; however drum temperature responsiveness will also be decreased.

The temperature controller has been "tuned" for your specific machine to give the best-controlled temperature allowable on the machine at the factory. Tuning of the temperature controller can be performed if tighter temperature hysteresis is desired. Please see the SETUP page to perform an auto tune of the machine.

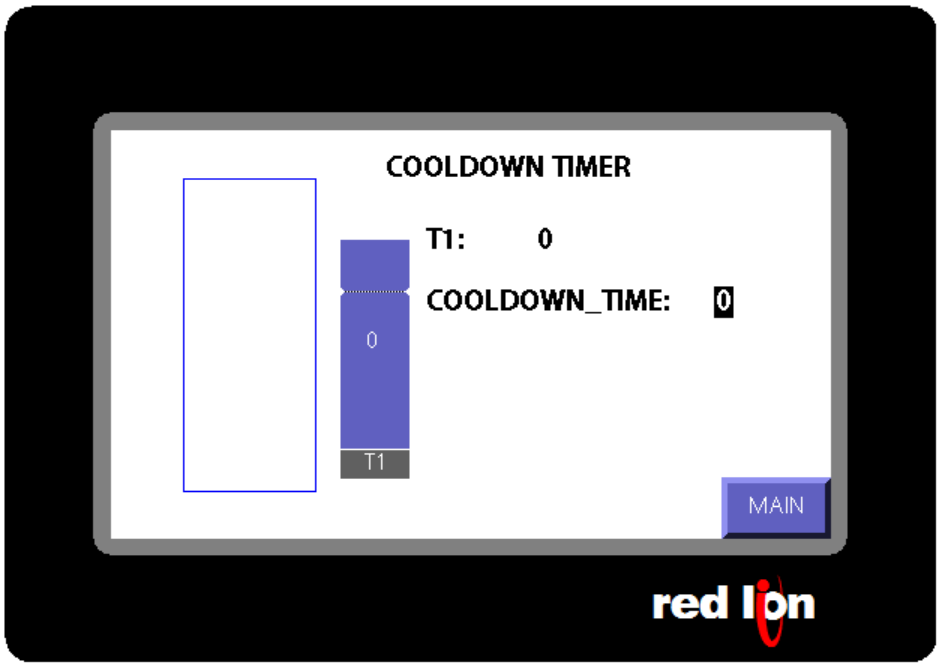


Please note that only when the belt is made operational can the heat control be activated. When the belt is not moving or during the cool down cycle, the off symbol (ITEM B) will be shown above the temperature.

When the machine reaches full temperature, the temperature controller indicator light (ITEM A) in the upper right corner will cycle on and off as the heat is cycled to maintain the desired temperature. If the heaters or temperature controllers do not energize properly consult the TROUBLESHOOTING section. After the machine has reached full temperature it is ready to be used for printing.

Cooldown:
This function is used to cool down the machine at the end of the work shift. Pressing the COOLDOWN button will take you to the COOLDOWN screen (shown below). The upper number (T1) will show the current timer value. The second number (COOLDOWN_TIME) indicates how long cooldown is set for this particular machine.

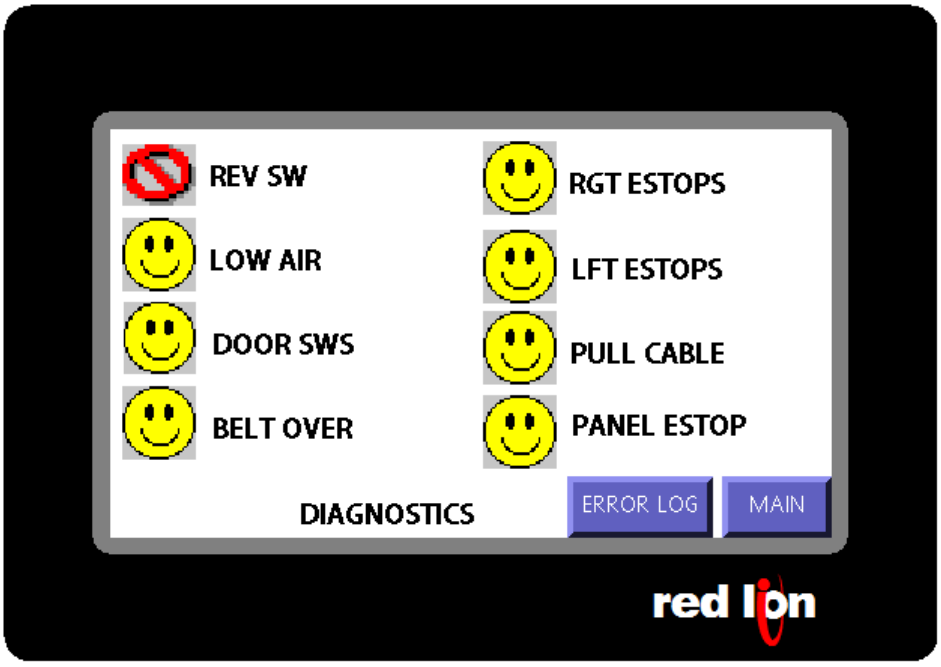
Press the MAIN button to return to the HOME screen. 



Stop:
Will stop all functions of the machine. However, please keep in mind the power is still connected.

Alarms:
Alarms button will begin flashing when there is a change from the original settings. All errors are shown on this page. Press the alarm button to be brought to the Diagnostics page where the activated alarm description will be marked red in the circle. Do the following to correct the issue and the red will be cleared.

- Left E Stops-One of the red emergency stop buttons on the left side of the machine has been activated. Pull the red emergency stop button up.
- Right E Stops- One of the red emergency stop buttons on the right side of the machine has been activated. Pull the red emergency stop button up.
- Doors-One of the two doors has been opened causing the machine to shut off. Close the doors.
- Pull cable-The pull cable at the entry of the machine been pulled and activated. Pull the blue reset button on the red pull cable housing located on the left front of the machine.
- No Air-The air has been disconnected or turned off causing the machine not to get the necessary air for proper functionality. Turn the air back on.
- Belt Over Travel-The belt is tracking off to the left or right. The automatic belt tracking will keep the belt in the center. If the belt over travels too far to one side the machine will shut itself down before any damage can occur to the belt. Slide the belt back into place.
- Reverse Switch-The reversing switch has been activated and the belt is going in the opposite direction. Release the reverse switch.

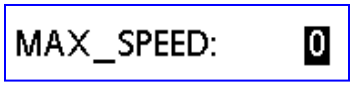


Setup:
These are the setup parameters with your particular machine for optimal performance. Initial parameters, temperature controller parameters, cool down timer and speed parameters are set on this page. They can be changed as needed.

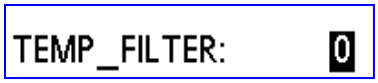
Username: TECH
Password: 111156

Temperature display offset- This is the value of offset for the temperature display in order to calibrate the temperature to an external standard.

Speed display multiplier constant -- Multiplies the speed display to show correct value for feet/minute speed



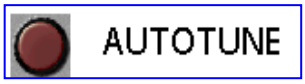
Max Speed -- This is the maximum speed value that can be set.



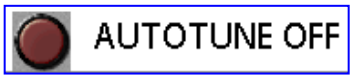
Line filter to stabilize the temperature signal from induced electrical noise.

Bypass pushbutton for the incoming air pressure switch. Will allow machine to run without air pressure switch input signal.

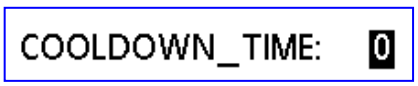
Bypass button for the door switches. Will allow the machine to run without the door switch being activated.



This will auto tune the temperature controller at temperature.

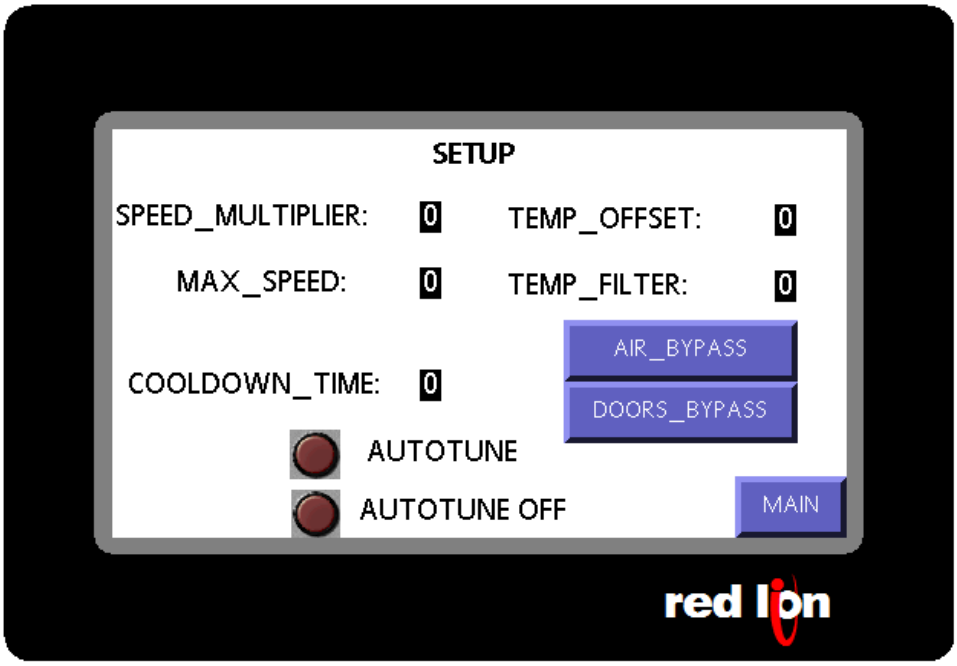


This will cancel the auto tune cycle.

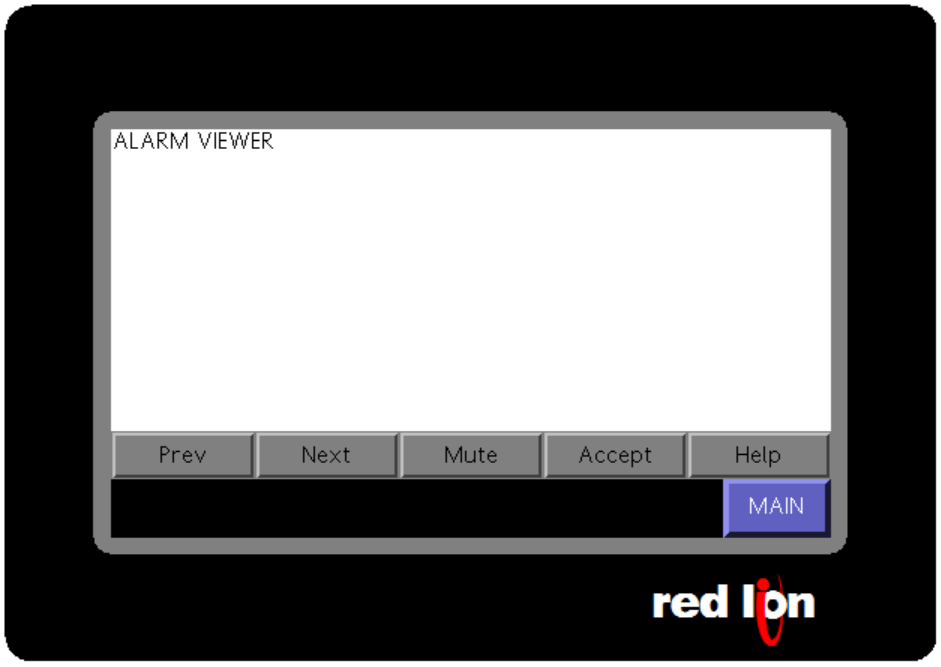


The cool down time amount is set here. 45-60 min

Setup Screen:



Error Log:
All errors for the machine can be seen on this page. They are date and time stamped. After viewing the errors can be erased by pressing the accept button. Move up or down the list using the Prev or Next button. All machine stop buttons will indicate an error, including belt over travel, door switches, low input air, cable stop, motor controller errors, and temperature controller error.



FIRST RUN

1. Run the machine cold.
2. Check the belt tracking.
3. Check speed regulation.
4. Turn on the heat and check the same functions.
5. If the machine is not functioning properly turn it off. Check the TROUBLESHOOTING section or the TRACKING section. If the problem cannot be corrected call Practix Mfg.

OPERATIONAL TESTING

The variety of speeds available with the OK-10 offers a higher production potential. The drum speed should be adapted to the lay-up rate. Heat and belt tension settings must be varied in proportion with the belt speed to obtain the proper printing quality. Although most print papers come with manufacturer's suggested printing specifications, a higher production rate and a more consistent product is usually obtainable by thorough testing.

A digital thermometer is designed to give an accurate reading of actual temperature on the drum. If there is a discrepancy between the actual drum temperature and the temperature controller shown temperature, then refer to the Temperature Controller Section of this manual. Temp Strips are also designed to provide a temperature test.

Suggested Digital Thermometer with Bow Probe

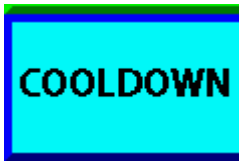
Practix Model No. 3879K83 (Digital Thermometer)
Practix Model No. 3863K91 (Bow Probe)

Temp Strips Selection Chart

Type	Temperature Range (^{0}C)	Order NO.
1	350-420	40-301

SHUTTING OFF THE MACHINE

At the end of each working day when the machine is to be turned off it should be run though 45-60 minute cool down with the speed at a high setting. To do this, press the COOLDOWN button on the home screen (shown below).



It is not necessary to move any other controls. With the machine in the “COOL DOWN” mode, the heaters are automatically de-energized with all remaining functions preserved. When the timer runs out, the machine will shut itself off completely. To restart the machine, press the HOME button to return to the HOME screen and press the START button.

SETUP OF UNWINDS AND REWINDS

Using the Unwind/Rewind Stations

Use the regulators on the front and rear of the machine to regulate the tension of the paper and fabric as it goes into the machine. As the paper goes through the heating process, it may become brittle and tend to tear. This may require the reduction of the pressure on the rewinds.

As the paper is unwound from either the rear or the optional front table, adjustment can be made to the adjust rollers found on top of the machine and on the optional front table. Move these rollers to remove any wrinkles in the paper.

IF THE PAPER WAS WOUND ONTO THE SPOOL LOOSELY OR NOT STRAIGHT, PROBLEMS SUCH AS WRINKLING MAY OCCUR AS THE FABRIC IS HEAT TRANSFER PRINTED.

ALSO, AS THE PAPER IS PRINTED ON AN INKJET PRINTER, THE PAPER MAY RETAIN LARGE AMOUNTS OF WATER (MOISTURE). THIS WILL BE SEEN AS WRINKLES AS THE PAPER IS PASSED THROUGH THE OK-10. THE PRINTED PAPER MAY NEED TO BE PASSED THROUGH THE OK-10 AT APPROX. 230^0F TO DRY IT BEFORE HEAT TRANSFER PRINTING IS ATTEMPTED.

NOTE: FOR PROPER ROLL PLACEMENT THROUGH THE MACHINE ON REWIND AND UNWIND RODS, PLEASE SEE THE NEXT PAGES. SEVERAL DIFFERENT SCENARIOS ARE SHOWN.

Using the Unwind Stations

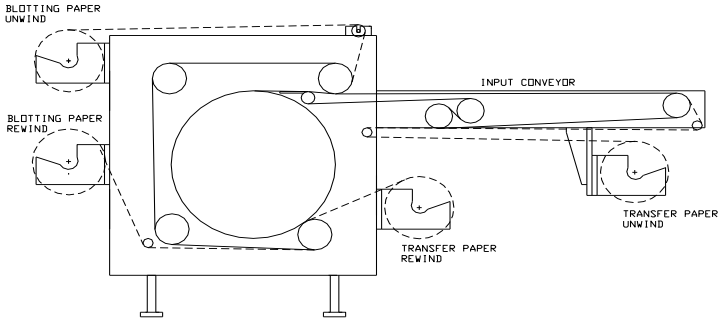
First start the blotting paper through the machine. It should unwind over the small gray rollers and into the printing area between the printing drum and the Nomex belt. Use the regulator on the rear of the machine labeled “UNWIND” to regulate the tension of the paper as it goes into the machine. The sublimation printing paper roll goes under the input conveyor onto the unwind shaft. The tension regulator is located on the left side front wall of the machine. Finally, the substrates to be printed goes on the front vertical unwind station. Use the regulator mounted in the front box to regulate the pressure of the material going in to the machine.

Using the Rewind Stations

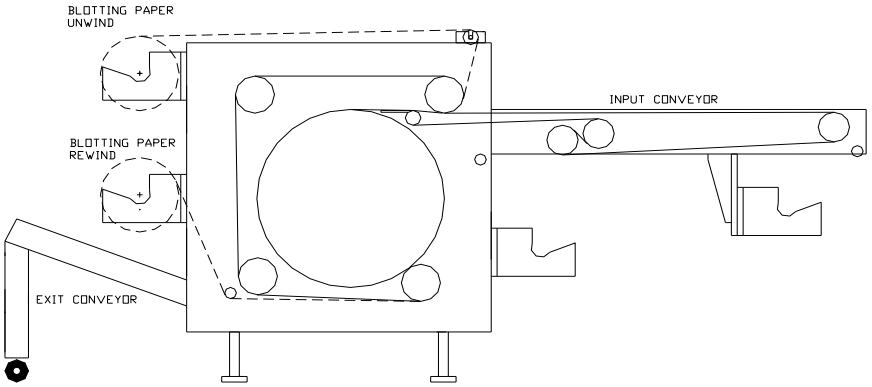
As the blotting paper comes through the machine, pull it around the punching roller and start it rewinding onto the rewind shaft. To increase the tension of the paper rewinding, use the regulator on the rear of the machine labeled “REWIND” to put tension on the paper as it comes through the machine. As the printed

material comes out from under the machine, begin rewind of the sublimation paper first and then the printed material. Hot sublimation paper can reprint back onto the sublimation paper.

ROLL TO ROLL PRINTING



PIECE GOODS PRINTING



BELT REPLACEMENT

Nomex Belt

1. **DISCONNECT THE POWER TO THE MACHINE!!!**

2. Remove the covers from the sides of the machine. Remove the slot covers that cover drum removal slots.

3. Make sure the Nomex belt tension is off. After this is done, remove the pivot bolt from the tracking roller.

4. Due to the weight of the rollers, the next few procedures will require the use of two or more people. Lifting both sides evenly, lift the tracking roller from its rests and slide it out of the machine through the drum removal slot.

5. Next slide the top rear idler roller out of its bearing housings. The roller will be removed again through the drum removal slots.

6. Remove the lower front main idler roller from the bottom of the belt. First, loosen the bolts that keep the roller from falling out. Next lower the roller underneath the machine and pull out from one side.

7. Lift the front top idler roller out of its housings and then out of the belt.

Install the replacement belt using the reversal of this procedure. Then read the Tracking Section of this manual to find out how to set the belt for the best results.

***When replacing the bottom main idler roller, do not tighten the bolts onto the bearing. These bolts should protrude in the bearing only enough to keep the roller from falling out. Tightening these bolts too much can cause premature bearing failure.

HEATER ROD REPLACEMENT

1. Open the side doors on the machine.

2. Remove the drum removal slot covers from both side of the machine. Next remove the circular covers above the main bearing housings.

3. **THIS PROCEDURE CAN BE EXTREMELY DANGEROUS. USE EXTREME CAUTION!!** Next with the power on, rotate the drum with the speed control. Rotate the drum until the heater that is to be replaced is in line with an opening in the machine frame.

4. **DISCONNECT POWER TO THE MACHINE!!!**

5. With a 3/8" or 10mm wrench, disconnect the burnt out heaters from the other heaters. TAKE NOTE OF HOW THE HEATERS ARE CONNECTED.

6. To remove a heater, the two set collars on the heater must also be removed. One is located on each end of the drum.

7. Slide out the old heater and replace it with a new heater of the same type.

8. Replace the set collars on the heater in the same location as they were on the old heater. MAKE SURE THE HEATER ENDS ARE IN LINE WITH OTHER HEATERS AND NOT STICKING OUT FARTHER THAN THE OTHERS.

9. Replace the wires if they seem brittle with new wires.

10. Replace all covers onto the machine and test the machine for proper operation.

THERMAL FLUID

CHECK THE LEVEL OF FLUID IN THE EXPANSION TANK ON A DAILY BASIS!!
There should be 2-3 inches of oil in the expansion tank when the machine is cold. The machine will evaporate or lose oil through pipe connections. Do not run the machine with a dry expansion tank. This will cause severe damage to the drum.

Analysis of the oil (Every 12 months)

The oil should be tested for proper composition on a yearly basis. A sample will need to be taken from the oil expansion tank and sent to us for examination. This test will determine the life of the oil and may show any other problems occurring with oil.

FILLING THE DRUM WITH NEW OIL

1. Rotate the drum so that the drain plug on the commutator side of the machine is in its top most position.
2. With the drain plug removed, fill the expansion tank with fluid.
3. Allow the fluid to drain into the drum.
4. Fill the drum until fluid flows from the drain plug. Immediately reinsert the drain plug and seal with high temp compound.
5. Fill the expansion tank so that there is 2-3 inches of fluid
6. Remove the drive latch relay from the subpanel in the left side of the machine. It is the small glass cube relay marked R1 on the drawing OK-12EL5 in the rear of this manual. This will allow you to heat the machine without having the drum rotating.
7. Turn the machine to run and set the heat to 250 degrees. Allow the machine to heat up. Let the machine heat at this temp for 15 minutes.
8. Reinsert the cube relay and allow the drum to turn for 2 revolutions. Again remove the relay when the drain is in the uppermost position.
9. Heat the machine to 300 degrees. Allow the machine to heat for 15 minutes. Replace the glass relay and set the speed for minimum.

The following steps can be performed only if the belt is off of the machine. If the belt is on the machine, plug the relay back in and heat the machine to 450 while running.

10. Heat the machine to 350 and allow the machine to heat for 15 minutes.
11. Heat the machine to 400 and allow the machine to heat for 15 minutes.
12. Heat the machine to 450 and allow the machine to heat for 15 minutes.
13. Cool the machine down to room temperature. Watch the level of fluid in the expansion tank. Be sure to have 2-3 inches in the bottom of the tank.
14. The next day, heat the machine in 100 degree intervals and allow the machine to turn for 15 minutes once the temperature has been reached.
15. Again cool the machine and check the oil level in the expansion tank.

TRACKING SYSTEM

A fiber optic sensor monitors the position of the Nomex belt. When the belt tracks too far in one direction the limit switch picks up the movement which induces an opposite variable motion in the tracking cylinder bringing into play the tracking roller shift.

NOMEX BELT: As the belt tracks to the left, the tracking cylinder pushes the left side of the tracking roller out, causing the belt to move right. This causes the belt to reverse its motion of travel to the opposite side. The tracking system is constantly adjusting to keep the belt on center.

Tracking Adjustment

The machine side door must be removed for access to the tracking system. The machine is sent from the factory with belt tracking set for optimum operation. This procedure should only performed if the nomex belt is replaced and the new belt does not track well.

1. Check to see that the machine is still level on the ground with the use of a spirit level.

2. After running the machine a few minutes, notice if the belt tracks to one side rapidly. If it does not, the belt does not need to be adjusted. Keep in mind, however, that the better the belt is adjusted, the less wear the cylinders will endure and also the chance of wrinkling the fabric is minimized.

3. If the belt tracks rapidly to one side, adjust the rear top idler roller bearing housing according. If the belt is tracking to the right side, loosen the four bolts that hold the bearing housing on the right side. Slide the bearing housing to the front of the machine. Move the housing in 1/8" (3mm) increments using push bolt. Tighten the bolts again and try the machine again.

4. After this is done, be sure to tighten all bolts that were loosened.

MAINTENANCE

NOTE: We recommend a regular maintenance plan as outlined below. These maintenance points are considered a very minimum. Additional maintenance is left to the Owner's discretion.

1. Daily Maintenance/Cleaning

   Vacuum or blow off any visible dust and lint.
   CHECK THE OIL LEVEL IN THE SIGHT GLASS

2. Weekly Maintenance

   A. Cleaning — Clean any buildup off the scraper and rollers.
   Remove any visible accumulation of dust, lint, or resin.

   B. Spot-check — Spot-check electrical and mechanical components.

   C. Lubrication — Lubricate the idler sprockets on both sides of the input conveyor.

3. Monthly Maintenance

   A. Cleaning — Remove thread and lint deposits
   Remove dust and lint accumulation from pivot points.

   B. Lubrication — Lubricate bearings with fittings using Hi-Temp grease. All other bearings are greased for life.
   Lubricate drive chain.
   Lubricate all roller slide guides with fittings using Hi-Temp grease.
   Lubricate drum bearings using high temp grease.

   C. Check expansion tank level.

BELT AND PNEUMATIC MAINTENANCE

Main Belt

1. Ink buildup on the Nomex belt should be avoided if possible since it may print back onto the fabric. Blotting paper should be positioned through the machine so that no printback occurs onto the nomex belt.

2. If the Nomex belt becomes worn or damaged, replacement may be necessary. Read the Belt Replacement section in this manual before attempting to change the belts.

Pneumatic System

1. Recommended pressure for the incoming airline is 100-110 psig.

2. The air actuated tracking pressure is displayed on the pressure gauge in the control panel. It works best at 80-90 psig pressure for proper tracking. Do not increase pressure above this level.

3. Set the pressure of the belt tension at approximately 80 psig. If the print is still “bleeding” then increase the pressure.

4. Check all air lines periodically for water and clean the main regulator/filter/lubricator weekly.

TROUBLESHOOTING

This section is provided for the identification and repair of items considered as field serviceable and is part of the maintenance of any machine. Problems falling outside the areas covered in this Manual should be first isolated as far as possible, then repaired only after consultation with your Dealer or our service department.

Problem	Check List
1. Main controls fail to energize	a. Electrical power supply b. Control fuses c. Incomplete circuit
2. Heaters fail to energize with main controls energized	a. main fuses b. Solid state relays c. Thermocouple probe d. Temperature controller e. Incomplete circuit
3. Heaters energize but fail to come up to temperature	a. Incorrect line voltage b. Thermocouple probe c. Temperature controller faulty d. Temperature controller calibration off e. Heater element f. Incomplete circuit
4. Incomplete Circuit	a. Drive motor fails to energize b. Motor power supply c. Motor speed setting d. Motor console fuse e. Motor
5. Belt fails to move with motor energized	a. Tension roller fails b. Chain drive
6. Belt fails to track properly	a. Bad solenoid b. Fuse c. Squaring of machine is off d. Leveling inadequate

PRACTIX OK-405OIL PARTS LIST

PART NO.	QUANTITY	DESCRIPTION
405/101	1	Transformer 150 VA
405/102	1	50W 24DC Power Supply
405/103	1	Solenoid Valve 3-way 1/8 NPT (Belt Tension)
405/104	1	Motor 1 1/2 HP 240VAC 3 PHASE
405/105	1	Speed Controller Frequency Inverter
405/106	1	Terminal Block
405/107	2	Octal Relay 11 Pin
405/108	2	Octal Base
405/109	1	Time Delay Plug-In Type
405/110	2	Mini Relay Square
405/111	2	Mini Relay Base
405/112	2	Fuse Block 3 POLE 200A
405/113	5	Fuse Block 2 POLE 30A
405/114	1	Fiber Optic Emitter 75mm
405/115	1	Fiber Optic Receiver 75mm
405/116	1	Power Distribution Block
405/117	1	Panel Fuse Holder
405/118	1	Main Switch Hand-Off-Auto
405/119	1	Start Switch w/ Light
405/120	2	Stop Button Mushroom Head
405/121	4	Toggle Switch On-Off
405/122	3	Temperature Controller OMRON
405/123	2	Regulator Panel NAR 2000 1/8 NPT
405/124	2	Regulator Unwind/Rewind NAR 1000 M5
405/125	2	Panel Gauge
405/126	1	Contactor 20A 2P
405/127	1	Contactor 175A 3P
405/128	6	Fuse 200 A
405/129	1	Fiber Optic Amplifier
405/132	6	Fuse 20 A
405/133	1	Panel Fuse Glass
405/134	1	Helical Speed Reducer
405/135	1	Filter/Lubricator/Regulator (Main Input to Machine)
405/136	1	Regulator w/gauge 35 PSI max (Unwind/Rewind Max)
405/137	15	Heater Rod Long
405/138	1	Commutator Unit 4P
405/139	3	Thermocouple Thermowell wWire
405/140	2	Axial Fan 5 ¼”
405/141	2	Main Roller Idler 5” DIA (top and bottom front)
405/142	1	Top Rear Idler Roller 4” DIA

405/143 complete	1	Bottom Rear Tracking Roller Idler 4” DIA
405/144	2	Bearing Housings for Tension Roller
405/145	2	Bearing Housing for Top Front Idler
405/146	2	Bearing Housing for Top Rear Idler
405/147	1	Left Pivot Housing for Tracking Roller
405/148	1	Right Pivot Housing for Tracking Roller
405/149	2	Bearing Housing for Main Drum
405/150	8	Rewind/Unwind Arm
405/151	8	Rewind/Unwind Arm Base Plate
405/152	8	Rewind/Unwind Bearing Holding Block
405/153	4	Rewind/Unwind Shaft
405/154	4	Rewind/Unwind Transmission Shaft
405/155	60	Rewind/Unwind Shaft Bearings R12
405/156	12	Rewind/Unwind Transmission Shaft Bearing
405/157	2	Blotting Paper Idler Roller w/ bearings
405/158	4	Bearings for Main Idler Rollers 1 ¼” I.D.
405/159	2	Bearings for Top Rear Idler Roller 1 ¼” I.D.
405/160	2	Bearings for Printing Drum 190mm
405/162	3	Unwind Brake Unit Pneumatic
405/163	2	Sprocket for Large Clutch Unit #35A32
405/164	2	Sprocket for Small Clutch Unit #35A32
405/165	2	Unwind Brake Rub Plate
405/166	1	Printing Drum
405/167	1	#40 ANSI Roller Chain 10 ft.
405/168	1	#35 ANSI Roller Chain 10 ft.
405/169	1	#80 ANSI Roller Chain 10 ft.
405/170	1	Sprocket #80B14
405/171	2	Sprocket #35B32 (transmission shaft)
405/172	1	Sprocket #80B42 (drum)
405/173	4	Sprocket #40B15 1” BORE
405/174	1	Sprocket #40B40 1 3/8” BORE
405/175		Sprocket #40B23 1” BORE.
405/176	1	Sprocket #40B15 1 ¼ BORE Input Conveyor
405/177	2	Sprocket #35B19 1 ¼ BORE Input Conveyor
405/178	1	Short Heater Assembly Holder Clamp
405/179	1	Long Heater Assembly Holder Clamp
405/180	1	Heater Holder Assembly
405/181	1	Heater Holder Assembly Shaft
405/182	1	Main Control Panel
405/183	1	Input Conveyor Finger Guide Round
405/184	1	Input Conveyor Drive Roller Short Journal
405/185	1	Input Conveyor Drive Roller Long Journal
405/186	1	Input Conveyor Guide Fingers
405/187	4	Casters
405/188	4	Leveling Feet
405/189	1	Nomex Belt
405/190	*	Input Conveyor Strip Belting

405/191	*	Exit Conveyor Strip Belting
405/192	1	Scraper Bar w/ Rod
405/193	3	Slide for Tension/Tracking Roller
405/194	6	Guides for Slide
405/195	2	Exit conveyor roller tensioner collar
405/196	1	Spool Valve
405/197	1	I/P Regulator OMRON
405/198	1	Oil Coalecsor Filter for I/P regulator