VASSOYO 4000A SN 11161

MECHANICAL TRAY ERECTOR OPERATION AND MAINTENANCE MANUAL

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INSTALLATION

Unpacking

1. Remove shipping container

2. Remove any ties, blocks or pads fastened on the machine.

3. Move machine to the designated are and reassembled parts that may have been removed for shipping.

Air connection

1. Connect up a flexible airline of suitable size with Manual shut-off valve to the main air inlet.

2. Your machine requires that air supply of 0.5 scfm per cycle. So a machine running at 22 cases per minute requires an air compressor that will supply 11 scfm at sea level.

3. The regulator data are on your machine should be set at 80psi.

Power connection

1. Electrical connections to machine should be done by a certified electrician and electrical service should be designed to the electrical requirements of you machine.

2. Copy of electrical schematic can be found in the control panel of your machine and in the back of this manual.

NOTE: when the above installation is completed, you rural the ready for our service and to complete the installation of your machine.

Attached to the front wall of your glue applicator, you will find a tag specifying the type of glue used and testing your machine. If the glue you are using is not compatible with glue used in testing you must flash that glue from this system. Please refer to the glue manual supplied with your system for procedure and Flushing you're unit.

SAFETY

It is the Employers responsibility to provide adequate supervision to determine that safe work methods are uses. It is also the responsibility of the employer to establish and follow a periodic and regular inspection of this machine to ensure that al parts, auxiliary equipment, and safe guards are in a safe operating condition and adjustment.

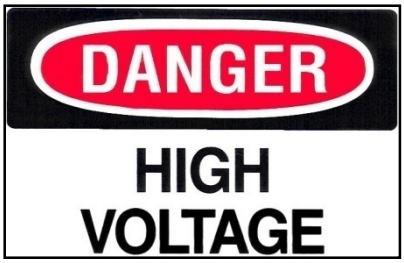
SAFETY SYMBOLS

The following are used to warn against dangers of possible sources of danger. Become familiar with them! Failure to heed a warning could lead to personal injury and/of damage to the machinery or other equipment.

CAUTION KEEP HANDS CLEAR: This sign indicates the presence of moving machinery and you should keep hands clear of these parts when machine is running.

DANGER DO NOT OPEN WHILE MACHINE IS IN OPERATION: This sign indicates that any access door should remain close while machine is in operation.

DANGER DO NOT OPERATE WITHOUT GUARDS: Indicates that all guards supplied with this machine should remain attached to machine and closed. All electric interlocks to door should remain in place and functioning. Any attempt to disable these switches could cause harm to operators and personnel involved with the operation of the equipment.



DANGER HIGH VOLTAGE: This sign indicates the presence of high voltage and all caution should be made when working in these areas. Turn off all electrical disconnects when working on the machine.

DANGER OPEN MACHINERY: These warning are located around the machine to worn operators and personnel that you are working in an area of the machine with working components. When this sign is viewed the machine should be turned off and power disconnected.

DANGER STARTS AUTOMATICALLY: This warring is located around the machine in areas where the machine maybe in Auto Idle. If the machine is on and running it will automatically start running when the discharge is clear of product. It is advised that you remain clear of these areas when the machine is in operation.

REMEMBER:

WHEN WORKING ON MACHINE TURN THE POWER OFF, FOR YOUR SAFETY AND THOSE AROUND YOU.

BEFORE STARTING THE MACHINE BE SURE TO YELL IN A LOUD MANNER, “POWER ON”, AND BE SURE PERSONNEL ARE CLEAR OF THE MACHINE BEFORE STARTING.

GENERAL SAFETY INFORMATION

This machine has been guarded for the safety of all personnel that are involved with the production process through the machine. When operating this equipment, all guard must be in place. Guards, safety switches, and interlocks should not be bypassed for any reason. Any change or modification to the safety equipment of this machine may produce a hazardous condition that could cause injury to persons working with the machine.

WARNING: DISCONNECTING OR BYPASSING THIS MACHINES SAFETY EQUIPMENT WILL VOID THE MANUFACTURERS WARRANTY.

SAFETY RULES:

1. No one should operate this equipment unless they have read the service manual and have been instructed on safety and operation of the machine.
2. All guard must be in their proper place before starting machine.
3. The operator should look to insure that the machine is clear before start-up, and call a warning, “CLEAR”, to alert other personnel that the machine is being started.
4. Do not reach into the machine until it has come to a complete stop.
5. Activate an **EMERGENCY STOP** prior to clearing jams and reaching into the machine.
6. Turn the main power disconnect **OFF** and attach a padlock to assure that the power to the machine remains **OFF** when performing maintenance on the machine.
7. Wear safety glasses and gloves when working on or around pressurized glue system.
8. Do not wear loose clothing or jewelry when operating this machine.
9. Personnel should stay clear of machines with **AUTO-IDLER, auto start function,** to avoid possible injury.
10. Personnel should be familiar with the location and function of the **EMERGENCY STOP SWITCH** on the machine.
11. Electrical cabinets and boxes should not be opened unless power has been disconnected.

MACHINE ORIENTATION

This section of the manual is intended to help those who may not be familiar with packaging machine terminology. All the parts mentioned can be found on the assembly drawing located in the back of this manual.

HOPPER SECTION

When standing facing the control panel of the machine you will see four aluminum bars protruding from the machine. These are the vertical hopper guides of the hopper. Here is where the knock down blanks are stacked for running through the machine.

BLANK PULL-DOWN

This is the mechanism that extracts one blank from the bottom of the blank hopper.

RAM ASSEMBLY

Section of the machine that forces the blank through the forming plows that fold the flaps into the blank and forming the finished tray.

FOLDING SECTION

This is the area of the machine where all the flaps are folded into the tray.

DISCHARGE

This is the area where the finished case will be ejected from the rear of the machine.

SEQUENCE OF OPERATION

1. Blank are loaded onto the waterfall hopper conveyor. Blanks are then fed into the blank hopper automatically keeping the hopper filled with blanks.

2. One blank will be extracted from the bottom of the blank hopper and pulled down onto the guide rails that support the blank. The blank will then be pushed into the drive rollers of the top dive assembly.

3. As the blank moves through the drive rollers glue is applied to all the appropriate flaps. The blank is then pushed forward and located under the ram assembly.

4. With the blank in place the ram mandrel will descend down forcing the blank through the folding section of the machine. Here the minor flaps are folded into the blank and around the mandrel. At the same time the lid lifter is pushed up with the lid lifter.

5. The blank is pushed out of the forming section by the ejector cylinders and dropped onto the discharge conveyor.

6. The finished tray will then travel to the end of the discharge conveyor. When the blank reaches the end it will be indexed onto the next conveyor.

STARTING THE MACHINE

NOTE: Your machine can be set up to run in two different modes of operation.
RUN MANUAL, and RUN AUTO. Running in manual mode the machine will continue to run uninterrupted until the operator manually stops the machine. Running in Auto mode will activate the auto idler photo cell at discharge of the machine. When a tray is seen by the eye for a continuous length of time the vacuum on the blank feed will turn off. This will stop blanks from being fed into the machine until the photo eye is cleared.

RUNNING THE MACHINE:

1. TURN ON GLUE UNIT AND ALLOW GLUE TO REACH OPERATING TEMPERATURE**. Glue will not dispense until ready light on glue unit is on.**
2. Switch the **Power** button to **ON,** located on the front of control panel, be sure that all the **Emergency Stop Buttons** are pulled out**.** Note: the **Power Switch** should be turned to the off position when machine is shut down at the end of shift or when the machine will be shut down for a long period of time.
3. Make sure hopper is loaded with blanks.
4. Press the **START** pushbutton to activate the main control relay.
5. Press the **FEED ON/OFF** button (on Operation Screen).
6. Turn the **GLUE ON/OFF** to the **ON** position
7. Press the **AUTO MODE** OR **MANUAL MODE** button on touch screen.
8. Press the **START** button, the machine will start and begin running blanks**.**

STOPPING THE MACHINE

NOTE: THERE ARE 2 DIFFERENT WAYS OF STOPPING THE MACHINE

By pushing the **STOP** button on touch screen, the machine will continue through a preset number of cycles to complete the product in process and then will stop completely. By pushing the **FEED ON/OFF** button the machine will stop feeding blanks but the machine will continue moving.

The **EMERGENCY STOP** should only be used to stop the machine in an emergence situation. By pressing this button the machine will stop in the middle of a cycle and will not complete the intended operations. Tray will have to be removed from the machine.

OPERATOR INTERFACE

The Operator Interface allows the user to perform machine functions and setup User Parameters to modify operation.

User Parameters are password protected.

1. SPLASH SCREEN

The Splash Screen is displayed on system start.

2. OPERATION SCREEN

The OPERATION SCREEN allows the operation of machine functions.

The top menu bar is common to many of the screens and allows the user to navigate to the OPERATION, CHANGE OVER, BATCH, TOOLS and SETTINGS screens.

The START button starts machine cycle. An audible alert is invoked prior to machine motion.

The STOP button stops the machine cycle after completing the product that is in progress.

The JOG FW and JOG REV button are used to jog the main drive to aid in the removal of a product jam.

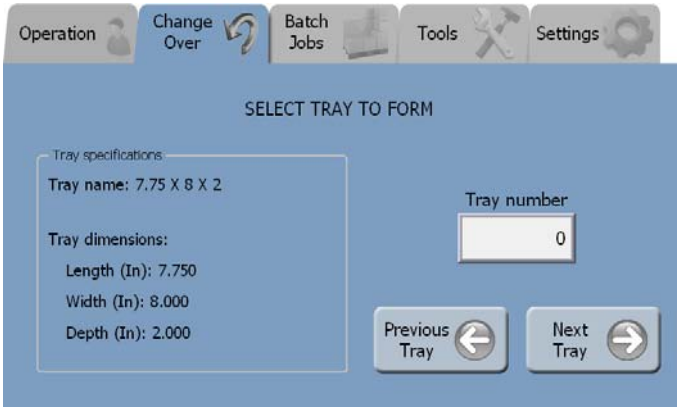
The MANUAL MODE/ AUTO MODE button is used to set the machine in manual or automatic mode. In Manual Mode. the Auto Idle sensor at the exit of the machine is ignored. The machine continues producing boxes even if cases are blocking the exit of the machine. If this button is pressed, the AUTO MODE is engaged. In this mode, the machine will stop cycling when the Auto Idle sensor at the exit of machine is blocked for a preset time. This prevents the machine from producing boxes into a blocked exit.

The FEED OFF/FEED ON button is used to turn OFF/ON the Blank Feed. If a cycle is in progress when this button is pressed, the machine will complete the cycle.

The GLUE OFF/GLUE ON button is used to turn OFF/ON the Glue Guns.

3. CHANGE OVER SCREEN

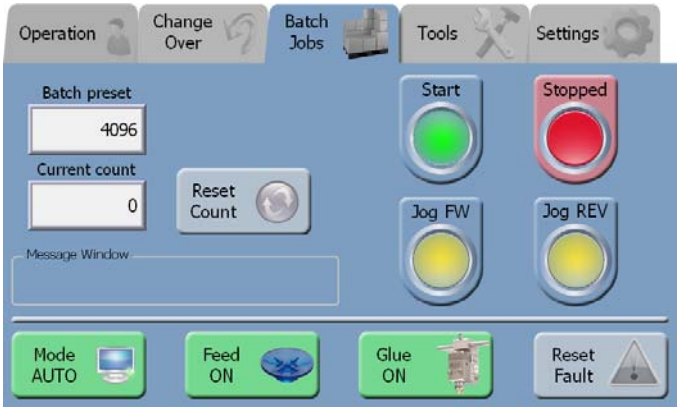
Enter this screen by pressing the CHANGE OVER tab on the Menu bar.



This screen allows selecting the tray to form and should be used after every change over. The Tray Number determines the operational settings of the machine for different case sizes. It is possible to modify the tray number by pressing the input box or using the Next Tray and Previous Tray buttons. To change the tray number, the machine must be stopped, since is not possible to change the tray size while the machine is running.

4. BATCH JOBS SCREEN

Enter this screen by pressing the BATCH JOBS tab on the Menu bar.



Before and after perform a batch job, is recommended to remove all the remaining boxes in the machine and put them with the rest of the product.

The BATCH PRESET field displays and allows entry of the desired preset count of products to be completed. Once the machine is started, this value cannot be modified unless COUNT RESET button is pressed. Entering a quantity of zero will run the machine cycles continuously until the STOP button is pressed.

The ACTUAL COUNT field displays the number of products currently completed. When COUNT RESET button is pressed, this value is set to zero.

The START button starts machine cycle. An audible alert is invoked prior to machine motion.

The STOP button stops the machine cycle after completing the product that is in progress.

The MANUAL MODE/ AUTO MODE button is used to set the machine in manual or automatic mode. In Manual Mode the Auto Idle sensor at the exit of the machine is ignored. The machine continues producing boxes even if cases are blocking the exit of the machine. If this button is pressed, the AUTO MODE is engaged. In this mode, the machine will stop cycling when the Auto Idle sensor at the exit of machine is blocked for a preset time. This prevents the machine from producing boxes into a blocked exit.

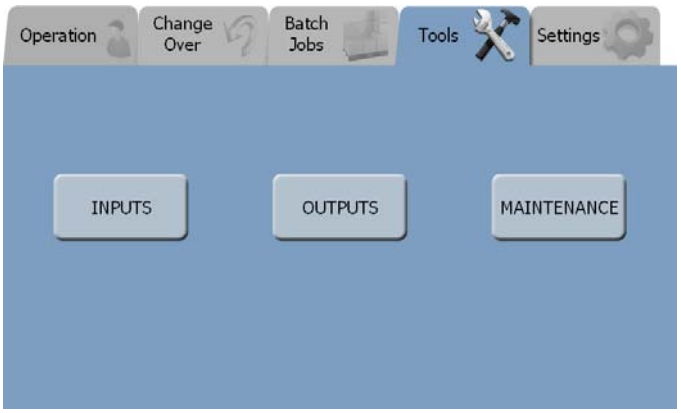
The FEED OFF/FEED ON button is used to turn OFF/ON the Blank Feed. If a cycle is in progress when this button is pressed, the machine will complete the cycle.

The GLUE OFF/GLUE ON button is used to turn OFF/ON the Glue Guns.

When the ACTUAL COUNT equals the BATCH PRESET the machine will automatically stop and a Batch Count complete message will be displayed. The RESET COUNT button will zero the Actual Count quantity and a new Batch is allowed to start.

5. TOOLS SCREEN

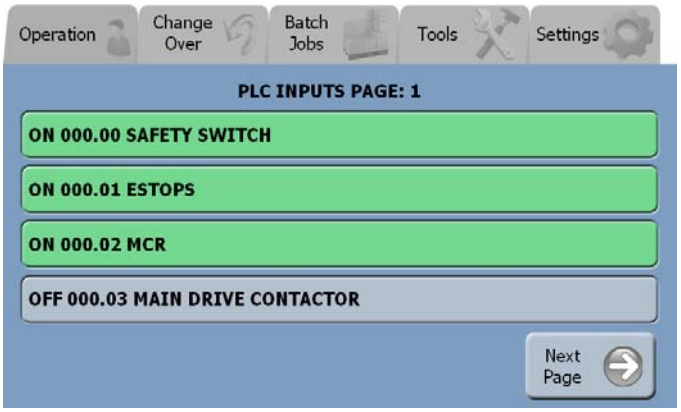
Enter this screen by pressing the TOOLS tab on the Menu bar.



This screen is very useful to diagnose the machine. The INPUTS and OUTPUTS button switches to the inputs and outputs screen respectively where all PLC inputs and output status are displayed. The MAINTENANCE button allows entry to the maintenance screen for troubleshooting purposes.

6. INPUTS SCREEN

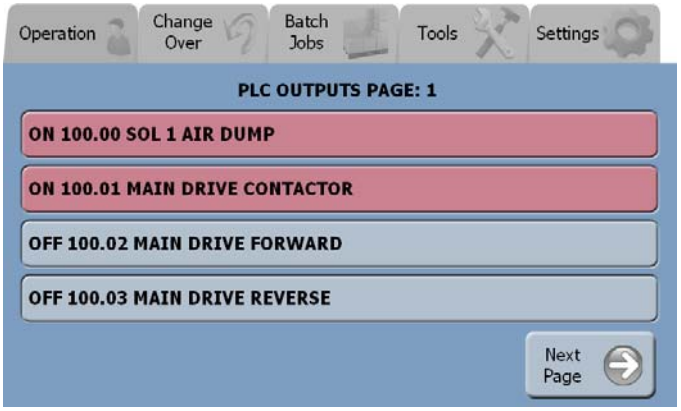
Enter this screen by pressing the TOOLS tab on the Menu bar and then press the INPUTS button.



The INPUTS SCREENS display the status of the PLC inputs.

7. OUTPUTS SCREEN

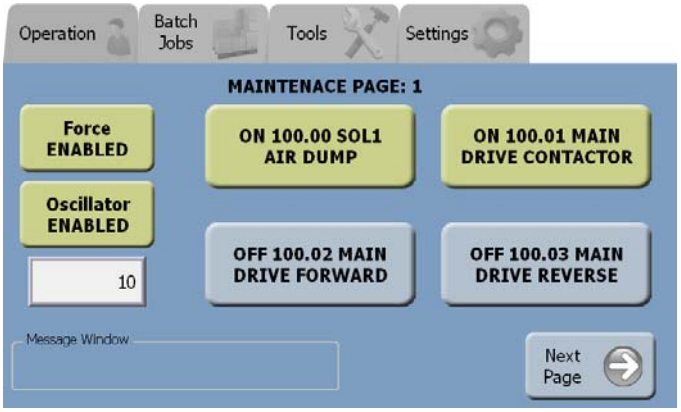
Enter this screen by pressing the TOOLS tab on the Menu bar and then press the OUTPUTS button.



The OUTPUTS SCREENS display the status of the PLC outputs.

8. MAINTENANCE SCREEN

Enter this screen by pressing the TOOLS tab on the Menu bar and then the MAINTENANCE button. When the MAINTENANCE button is pressed the Password screen is displayed. Once the correct password is entered the MAINTENANCE screen is displayed.



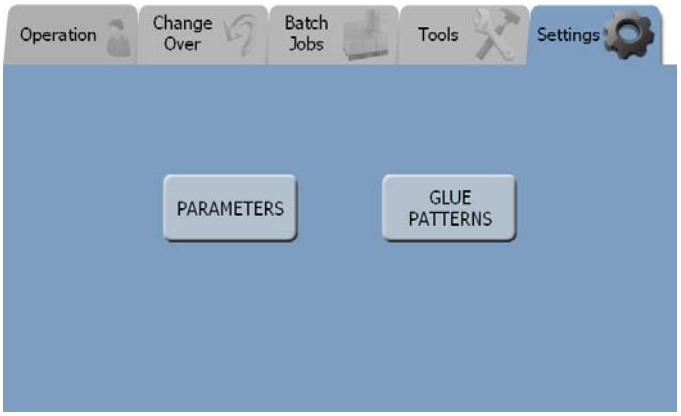
This screen allows authorized personnel to force machine outputs independently for troubleshooting purposes only. Use caution when using these functions all machine sequencing is bypassed.

To activate an output, the Force button must be ENABLED, then is possible to turn ON and OFF an output by pressing its respective button. The oscillator button allows turning ON/OFF an output automatically using a desired speed. All the outputs turned ON before activating the Oscillator will remain ON, only those outputs activated after activating the Oscillator will turn ON and OFF automatically.

Caution: Use extreme caution when using this machine mode.

9. SETTINGS SCREEN

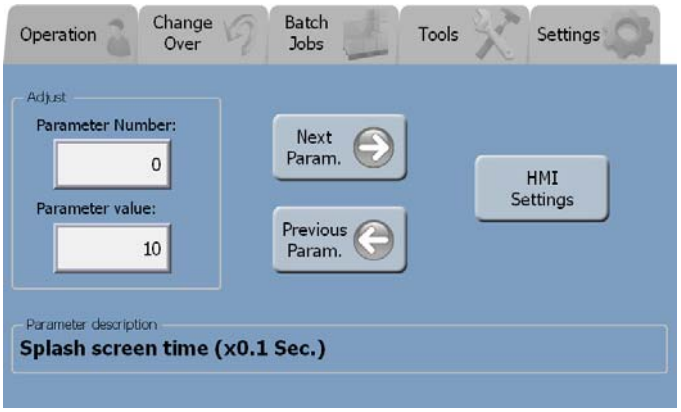
When the SETTINGS tab on the menu bar is pressed the Password screen is displayed. Once the correct password is entered the SETTINGS screen is displayed.



The SETTINGS button allows entry to the PARAMETERS and GLUE PATTERN screens.

10. PARAMETER SCREEN

Enter this screen by pressing the SETTINGS tab on the Menu bar, enter the correct password and then press the PARAMETER button on the SETTINGS screen.



The User Parameter screen is used to setup machine parameters. This screen is password protected.

Use the arrows to change the PARAMETER NUMBER field or press the corresponding input box. Press the PARAMETER VALUE input box and enter the new value. Press the ENTER key to save the new value.

The HMI Settings allow access to the HMI settings like backlight intensity and others.

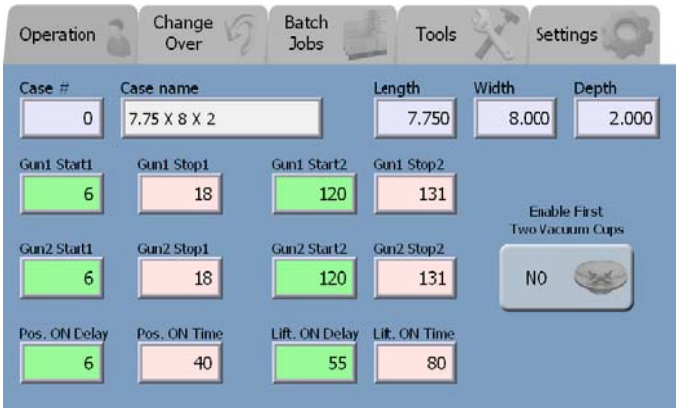
11. PARAMETER VALUES

P. No.	Description	Default Config.	Custom Set 1 Date:	Custom Set 2 Date:
0	SPLASH SCREEN TIME (x0.1SEC)	50		
1	MACHINE RUN DELAY TIME (x0.1SEC)	30		
2	MACHINE JOG DELAY TIME (x0.1SEC)	30		
3	JOG MODE DEACTIVATION TIME (x0.1SEC)	40		
4	AUTO IDLER ON DELAY (x0.1SEC)	15		
5	AUTO IDLER OFF DELAY (x0.1SEC)	5		
6	MACHINE SLEEP DELAY TIME (x0.1SEC)	600		
7	BUZZER TIME OUT (x0.1SEC)	100		
8	LOW HOPPER TIME (x0.1SEC)	20		
9	MACHINE START CYCLES	2		
10	MACHINE STOP CYCLES	2		
11	BLANK PULL DOWN RETRIES	3		
12	MAIN DRIVE START DELAY (x0.1SEC)	5		
13	MAIN DRIVE STOP DELAY (x0.1SEC)	19		
14	ROLLERS DRIVE START DELAY (x0.1SEC)	0		
15	ROLLERS DRIVE STOP DELAY (x0.1SEC)	10		
16	DELIVERY CONVEYOR START DELAY (x0.1SEC)	45		
17	DELIVERY CONVEYOR STOP DELAY (x0.1SEC)	50		
18	VACUUM ON DELAY (x0.01SEC)	0		
19	VACUUM OFF DELAY (x0.01SEC)	100		
20	EJECTOR ON DELAY (x0.01SEC)	60		
21	EJECTOR OFF DELAY (x0.01SEC)	50		
22	INDEXER DOWN DELAY (x0.1SEC)	4		
23	INDEXER HOME DELAY (x0.1SEC)	24		
24	INDEXER MACHINE STOP HOME DELAY (x0.1SEC)	120		
25	JAM AT GLUE PE ALARM DELAY (x0.1SEC)	10		
26	BLANK DETECTION SYSTEM (0 = OFF, 1 = ON)	1		
27	MAIN DRIVE SPEED (1-100%)	80		
28	ROLLER DRIVE SPEED (1-100%)	50		

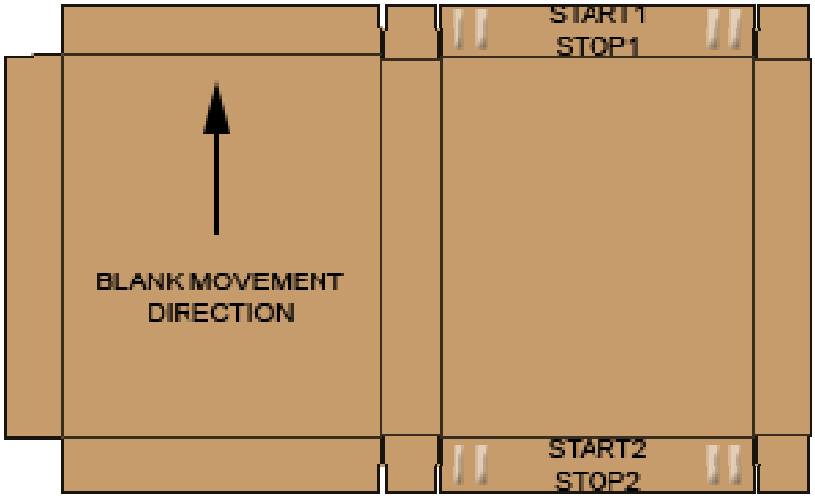
12. GLUE PATTERNS SCREEN

Access this screen by pressing the SETTINGS tab on the Menu bar, enter the correct password and then press the GLUE PATTERN button on the SETTINGS screen.

The first step working in this screen is enter the CASE # in the top left of the window, all the values of the screen are updated to this value.



Here is possible to configure the forming section for every kind of tray that will be erected in the machine. Each glue gun has two adjustable start and stop, creating two glue strips. This glue strips must be located in the lid. The glue pattern timing is adjusted in milliseconds. The positioners and lid lifter are adjusted in hundredth of seconds.



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13. GLUE PATTERNS VALUES

Case #:	Case name:	Length:	Width:	Depth:
0	7.75 x 8 x 2	7.75	8.0	2.0

Description	Default Config.	Custom Set 1	Custom Set 2
		Date:	Date:
Gun 1 Start 1	101		
Gun 1 Stop 1	113		
Gun 1 Start 2	289		
Gun 1 Stop 2	299		
Gun 2 Start 1	101		
Gun 2 Stop 1	113		
Gun 2 Start 2	289		
Gun 2 Stop 2	299		
Pos. ON delay	60		
Pos. OFF delay	120		
Lift. ON delay	120		
Lift. OFF delay	80		

Case #:	Case name:	Length:	Width:	Depth:
1	13.5 x 11.25 x 2	13.5	11.25	2.0

Description	Default Config.	Custom Set 1	Custom Set 2
		Date:	Date:
Gun 1 Start 1	107		
Gun 1 Stop 1	121		
Gun 1 Start 2	400		
Gun 1 Stop 2	414		
Gun 2 Start 1	107		
Gun 2 Stop 1	121		
Gun 2 Start 2	404		
Gun 2 Stop 2	416		
Pos. ON delay	65		
Pos. OFF delay	120		
Lift. ON delay	121		
Lift. OFF delay	80		

Case #: 2	Case name:	Length:	Width:	Depth:

Description	Default Config.	Custom Set 1 Date:	Custom Set 2 Date:
Gun 1 Start 1			
Gun 1 Stop 1			
Gun 1 Start 2			
Gun 1 Stop 2			
Gun 2 Start 1			
Gun 2 Stop 1			
Gun 2 Start 2			
Gun 2 Stop 2			
Pos. ON delay			
Pos. OFF delay			
Lift. ON delay			
Lift. OFF delay			

Case #: 3	Case name:	Length:	Width:	Depth:

Description	Default Config.	Custom Set 1 Date:	Custom Set 2 Date:
Gun 1 Start 1			
Gun 1 Stop 1			
Gun 1 Start 2			
Gun 1 Stop 2			
Gun 2 Start 1			
Gun 2 Stop 1			
Gun 2 Start 2			
Gun 2 Stop 2			
Pos. ON delay			
Pos. OFF delay			
Lift. ON delay			
Lift. OFF delay			

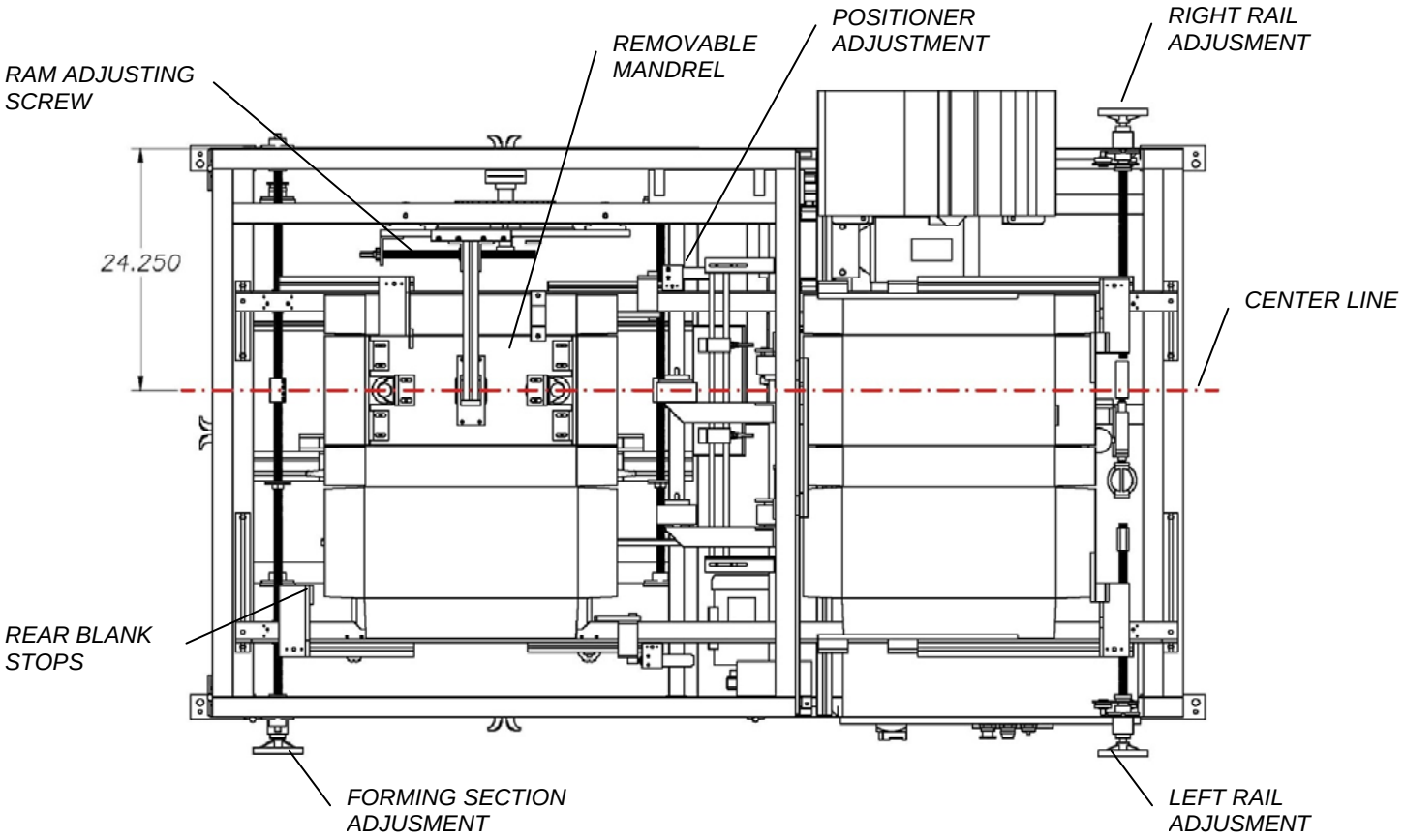
Case #: 4	Case name:	Length:	Width:	Depth:

Description	Default Config.	Custom Set 1 Date:	Custom Set 2 Date:
Gun 1 Start 1			
Gun 1 Stop 1			
Gun 1 Start 2			
Gun 1 Stop 2			
Gun 2 Start 1			
Gun 2 Stop 1			
Gun 2 Start 2			
Gun 2 Stop 2			
Pos. ON delay			
Pos. OFF delay			
Lift. ON delay			
Lift. OFF delay			

Case #: 5	Case name:	Length:	Width:	Depth:

Description	Default Config.	Custom Set 1 Date:	Custom Set 2 Date:
Gun 1 Start 1			
Gun 1 Stop 1			
Gun 1 Start 2			
Gun 1 Stop 2			
Gun 2 Start 1			
Gun 2 Stop 1			
Gun 2 Start 2			
Gun 2 Stop 2			
Pos. ON delay			
Pos. OFF delay			
Lift. ON delay			
Lift. OFF delay			

CHANGE OVER



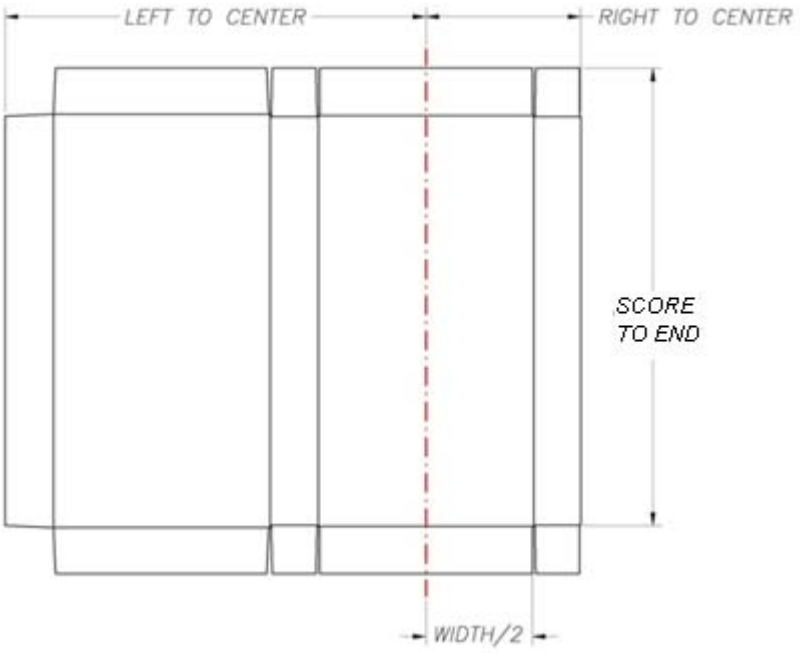
LOCATION OF CENTER LINES

The detail above shows the relationship of the blank to the machine. When changing over from one size tray to the other the blank must be located in the machine on the centerline as shown. The blank will always be located with the width centered to the mandrel on the ram assembly.

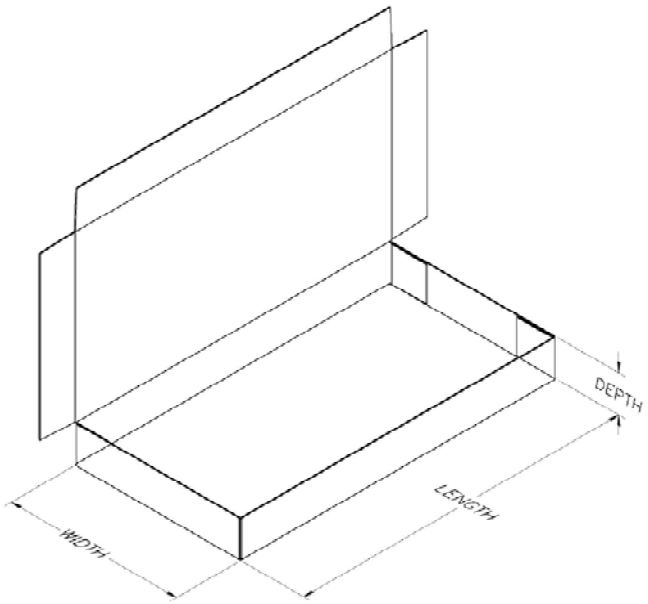
The following table shows the measurements needed to change from one size to the other. These dimensions should be used for the adjustments.

No.	ERECTED TRAY			BLANK		
	Length	Width	Depth	Right to center	Left to Center	Score to end
0	7 3/16	7 11/16 (7.688)	2	5 7/8 (5.875)	15 7/8 (15.875)	9 ½
1	13 7/16	11 3/16 (11.188)	2 ½	7 ½ (7.500)	20 ¾ (20.750)	15 13/16
2	13 7/16	11 3/16 (11.188)	2	7 7/8 (7.785)	21 11/16 (21.688)	15 3/16
3	19 5/16	11 3/16 (11.188)	2	7 ½ (7.500)	20.700	21 1/8
4	21 5/16	11 3/16 (11.188)	2 ½	8	21 ¾ (21.750)	23 5/8
5	21 5/16	11 3/16 (11.188)	2 ½	8	21 ¾ (21.750)	23 5/8

BLANK



ERECTED TRAY



WARNING

DO NOT MAKE ADJUSTMENTS TO THIS MACHINE WHILE THE MACHINE IS RUNNING. The machine should be turned off and the shutoff valve to the air line closed to assure the safety of the operator when making these adjustments.

The following procedure is ordered in a reasonable way but have in mind that when making the change over from the smallest tray to the largest or vice versa the order should be altered to avoid interference between the different assemblies and parts.
Examples:

- The step 7 should be done before the step 1 when changing from the smallest to the largest tray.
- The step 4 should be done before the step 1 when changing from the largest to the smallest tray.

1. RIGHT HOPPER GUIDE RAIL: Rotate the right handwheel until the dial indicator shows the **right to center** dimension of the desired tray.

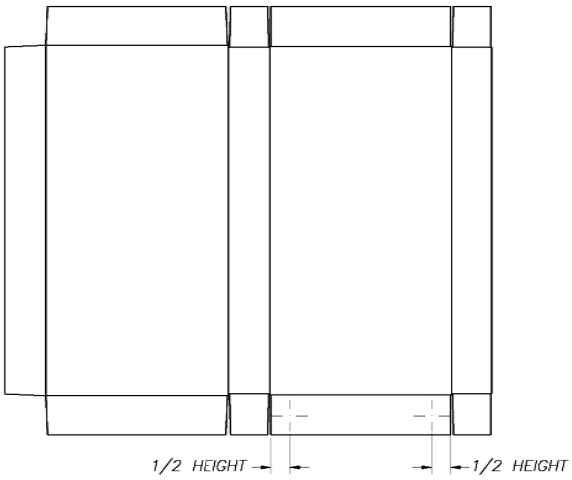
2. LEFT HOPPER GUIDE RAIL: Rotate the left handwheel until the dial indicator shows the **left to center** dimension of the desired tray.

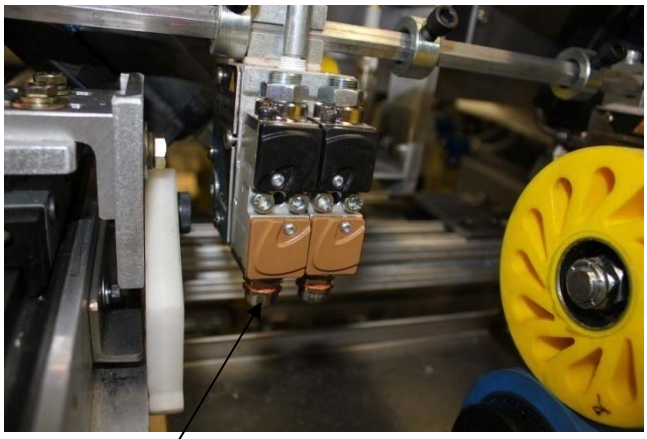
3. REAR HOPPER GUIDES: Release the locking handles of the rear guides and move them backwards. Locate a blank at the hopper between the side guides and touching the front guides. Move the rear guides to touch the rear end of the blank. Lock the handles.

4. VACUUM CUPS: Adjust the first set of vacuum cups so that they are close to the score of the rear panel on blank. Adjust the second set of vacuum cups to be at the center of the length of the blank. Adjust width of cups to contact blank on the side panels. For the smallest blank the first set will not be used and should be retired backwards so it will not interfere with the rear guides, then the second set should be located close to the score of the rear panel on blank.

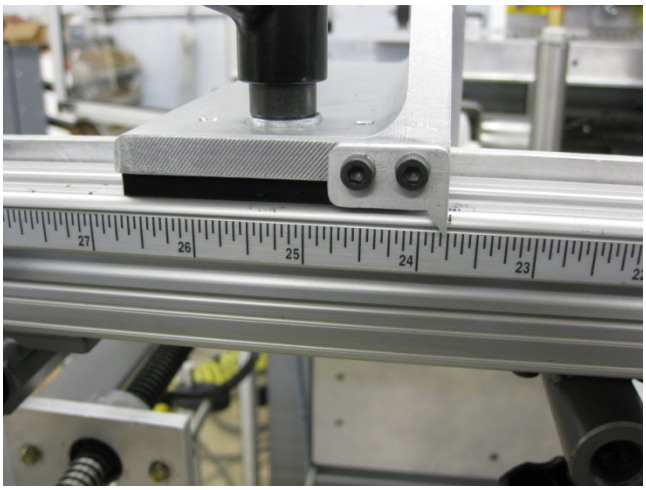
5. REAR BLANK PUSHER: Move the mandrel in reverse to its bottom position. Adjust the rear blank pusher to ½" from the rear of the blank when sitting flat on the guide rails.

6. GLUE GUNS: They should be located depending of the width of the erected tray so the tip of the nozzles are centered with the half of the height of the erected tray from the slot.

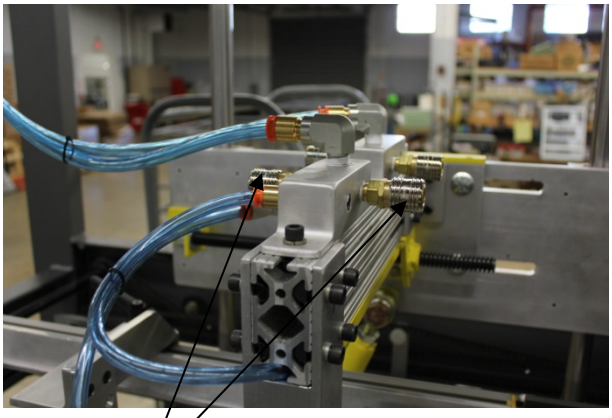




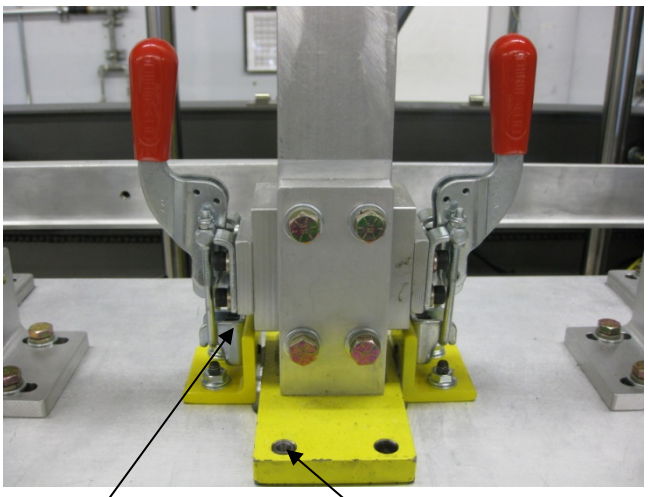
7. REAR BLANK STOP: Move the rear blank stops to locate them at the **score to end dimension** of the erected tray using the scales on both sides.



8. POSITIONER: The positioner on the right side should be move according to the **height** of the tray, the positioner on the left side does not have to be adjusted.
9. MANDREL ASSEMBLY: Remove existing mandrel assembly and replace with the next mandrel size. To do this, disconnect the air hoses from the manifold, release the clamps and extract the mandrel. Locate the desired mandrel using the guide pins and lock the handles. Connect the hoses.



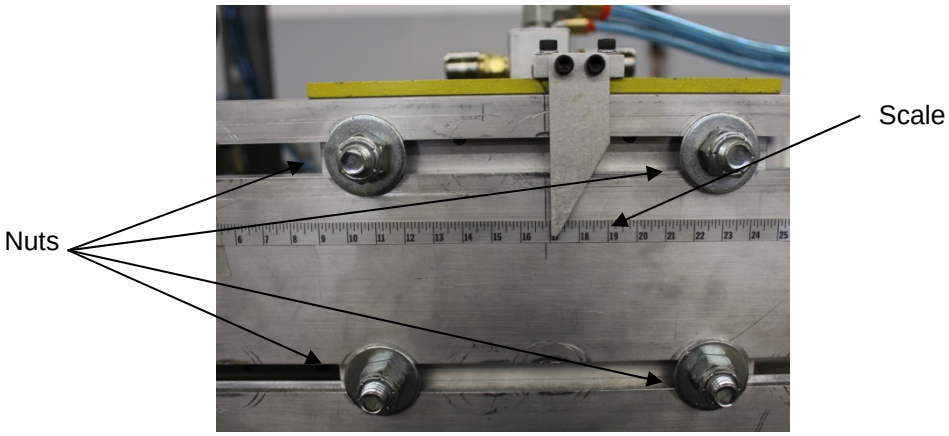
Hose quick disconnect couplings



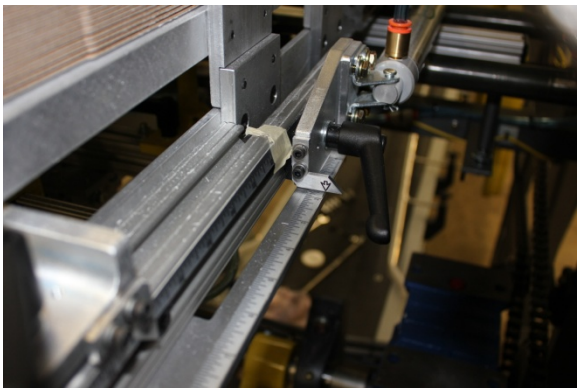
Clamps

Guide pins

10. MANDREL HORIZONTAL ADJUSTMENT: Loosen bolts on ram base and turn adjusting screw with ratchet handle so that edge of ram mounting plate is adjusted to the scale. Measure the **length** of erected tray and adjust ram arm plate to that dimension. Tight the nuts and retire ratchet handle.

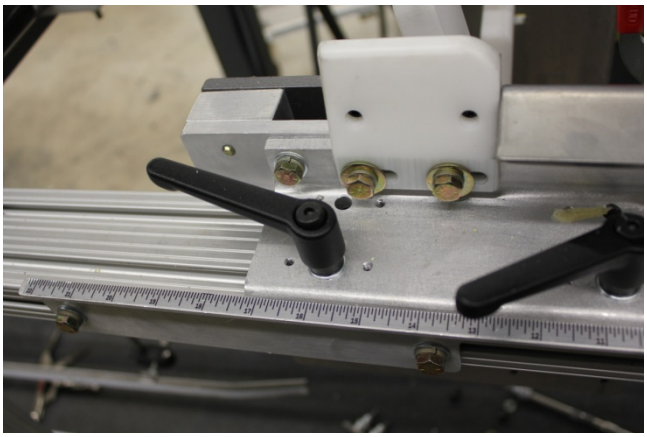


11. POSITIONER: The positioner located on the ram side need to be moved to match the scale with the height of the tray.

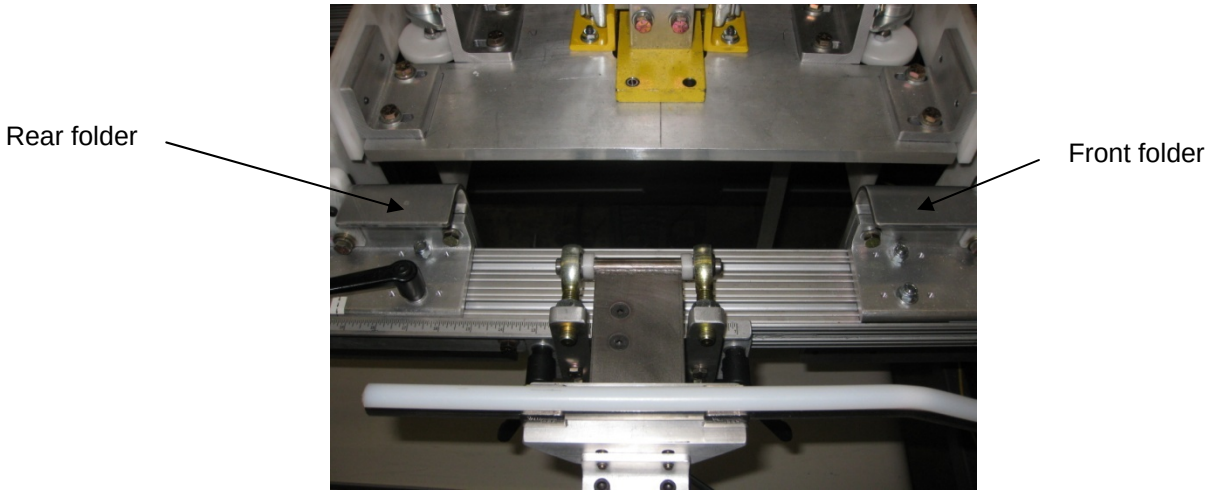


12. FORMING SECTION: Rotate the forming section hand wheel until the dial indicator shows the desired **width** of erected tray.

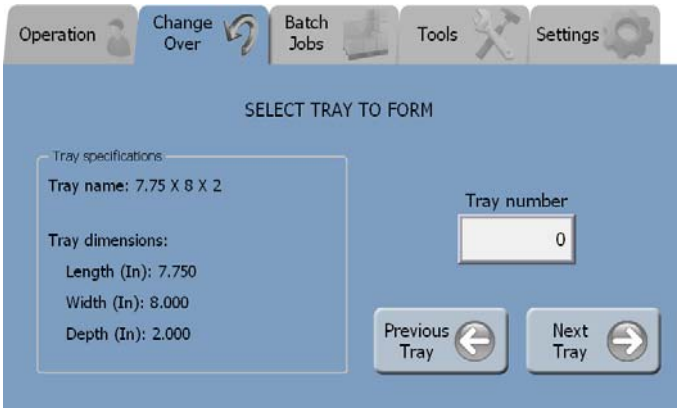
13. REAR CORNER FOLDERS: Measure **length** of tray and loosen corner formers at discharge end of machine and locate them at the desired length of the erected tray using the scales on the sides.



14. LID LIFTER: Move the lid lifter to be centered between the two rear and front folders.



15. Change the case number on the main screen to the number to be run.



MAINTENANCE

WARNING

BE SURE THAT POWER TO THE MACHINE IS TURNED OFF AND ISOLATED TO ENSURE THAT NO ACCIDENTAL START-UP CAN OCCUR.

AIR LINES

Check that the regulator on your machine is set to 80psi before operating your machine.

Check for water build up in filter canister and remove if required. Filter element may be cleaned with soap and water.

Check oil level in lubricator and fill if required. Use mist type oil rated 50-200 SSU (ISO Grade 7-46) as 100°F (38°C).

DAILY CHECK LIST

1. Check for loose nuts or bolt and retighten.
2. Check all airlines for cracks and leaks.
3. Check for loosen or broken electrical cables.
4. Check all doors are closed and secure to the machine. Be sure that all safety interlocks on the doors are functioning properly.
5. Clean all corrugated board pieces from the machine
6. Remove all excess glue from guide rails and folding bars.

WARNING

LEAVING PANELS OFF THE MACHINE OR OVERRIDING SAFETY INTERLOCKS COULD CAUSE INJURY TO OPERATOR OR BYSTANDERS NEAR THE MACHINE.

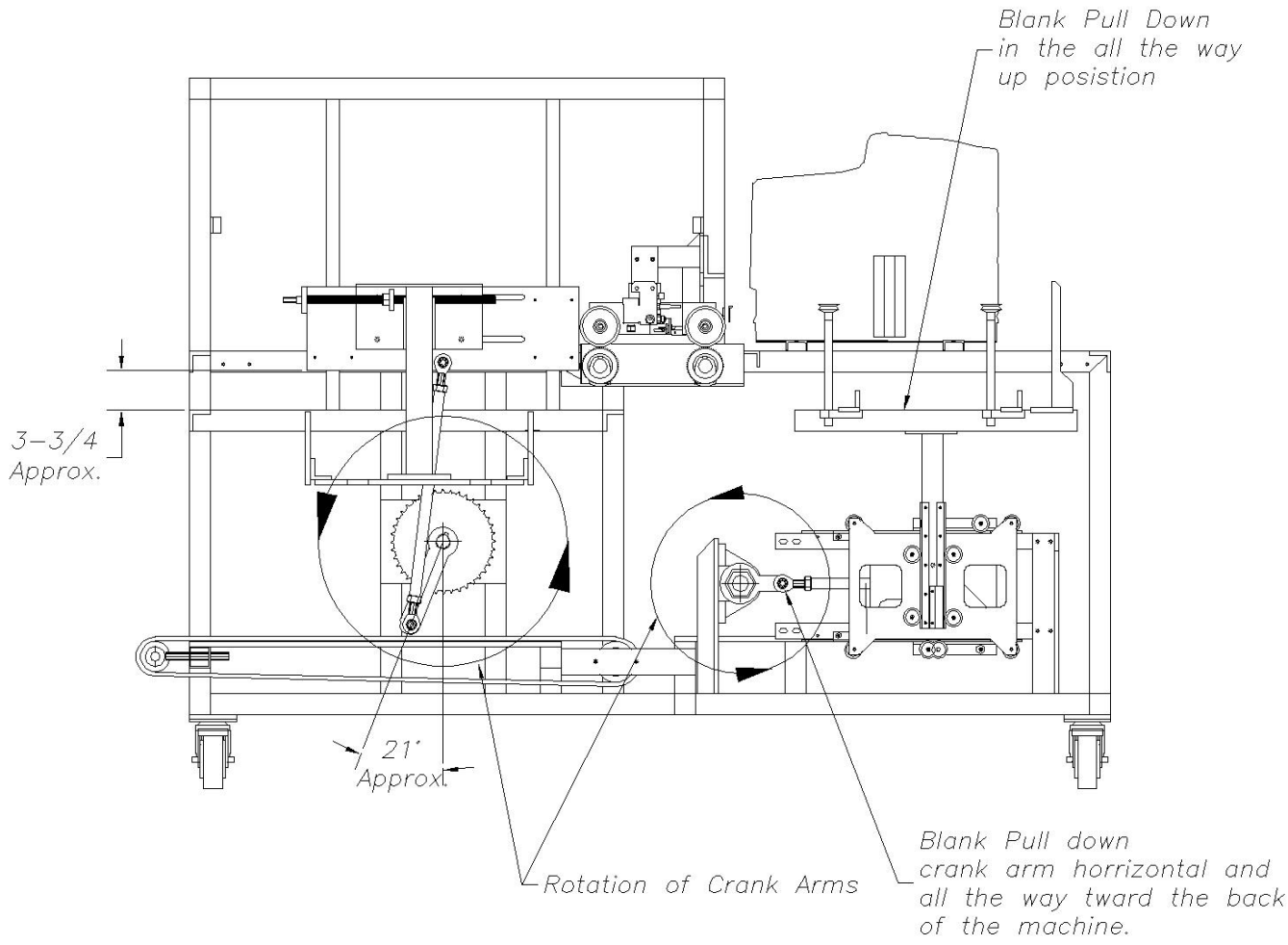
WEEKLY CHECK LIST

1. Check motor and gear reducer of drive for over heating.
2. Check and clean exterior of glue unit of all particles of glue (refer to user's manual for additional maintenance instructions.)
3. Check vacuum cups for wear and remove any particles of cardboard that may impede air blow. Check and clean vacuum filter located on the end of the vacuum generator.
4. Lightly oil all drive chains.

MONTHLY MAINTENANCE

1. Lubricate all rotary bearing with general-purpose grease.
2. Lightly oil the guide rods on Ram Assembly.
3. Lubricate and roller chain with lubricant. And also check chain tension; if chain sags or is loose retighten tension.

RAM AND VACUUM PULL DOWN TIMING



If at anytime it is required to remove the drive chain from the gear reducer and ram the above illustration will help in setting the timing back on the machine.

The ram and vacuum pull-down cranks move in a counter clock wise rotation when looking into the machine as shown. Using the supplied collars locate the bottom of the ram plate 3-3/4" from the top of the angle supporting the ram's guide rods. Next using the supplied hand wheel on the motor rotate the blank pull-down to the point where all vacuum cup are in there uppermost position as shown. This can also be done after the chain is replaced by adjusting the collar on Blank Pull Down crank.

When reattaching the chain to the ram and drive assembly, make sure that the ram crank is beginning it upward rotation. Remember to relocate and tighten the chain lightener on the chain.

TROUBLE SHOOTING

PROBLEM	PROBABLE SOLUTION
Blank does feed from hopper properly	1. Check that the blank feed switch is set to Auto. 2. Check guide rail adjustment, may be too loose or too tight. 3. Check for worn vacuum cups.
Tray not forming properly.	1. Check that mandrel is positioned properly 2. Check location of blank under blank mandrel and adjust blank stops being sure that blank is centered under mandrel. 3. Check to be sure that blank have proper score lines 4. Check rails for trash or glue build up. 5. Check adjustment on flap plows. If the plows are too close to the score line, the flaps will not fold properly.
Improper glue application For assistance with you glue problems please call **NORDSON®** **800-241-8777** They will assist you with any problem that may arise with your unit.	1. Check function of photo eye that activates glue gun. (See electrical schematic). 2. Check that glue switch is turned on. 3. Check glue unit that the proper glue setting is selected. 4. Check temperature on glue tank 5. Check air pressure to unit and glue gun.
Drive motor runs but components not operating.	1. Check air supply to the machine. 2. Check input from blank feed selector switch. Verify that PLC input is turned on.
Indexer not operating	1. Check air supply to the machine. 2. Check that indexer photo cell (PC-3) is operating properly and is set to see tray in place. 3. Check all air lines to indexer valve and air cylinder. 4. Check that air valve to indexer is operating properly.

SPARE PARTS AND SERVICE

For general information and parts contact:

EAGLE *Packaging Machinery LLC.*

4760 NW 128th St.
Miami, Florida 33054
Ph: 305-622-4070
Fax: 305-688-7772
www.eaglepm.com

It is necessary that before you contact EAGLE for parts or service, that you know the **Machine Model and Serial Number**. (VASSOYO Tray Erector model ATF4-009, SN 11161.)

1. Locate the assembly the part is being ordered for. At the end of this manual is a complete set of assembly drawings to assist you in finding these parts.
2. Once you have the assembly drawing, locate the item number of the part you want to order and write down the part number from the bill of materials.
3. When calling **EAGLE** for parts.
   a. Give machine model and serial number (VASSOYO, ATF4-009, SN 11161)
   b. Give assembly part number and description (ATF4-009-10, MANDREL # 1)
   c. Give item number, part number and description (Item #5, TC-331005, LATCH)

By following the procedures described above, you will assist us in supplying you with the correct parts for your machine and will eliminate any misunderstanding between your purchasing agent and our parts department.

SUGGESTED SPARE PARTS TF4000A

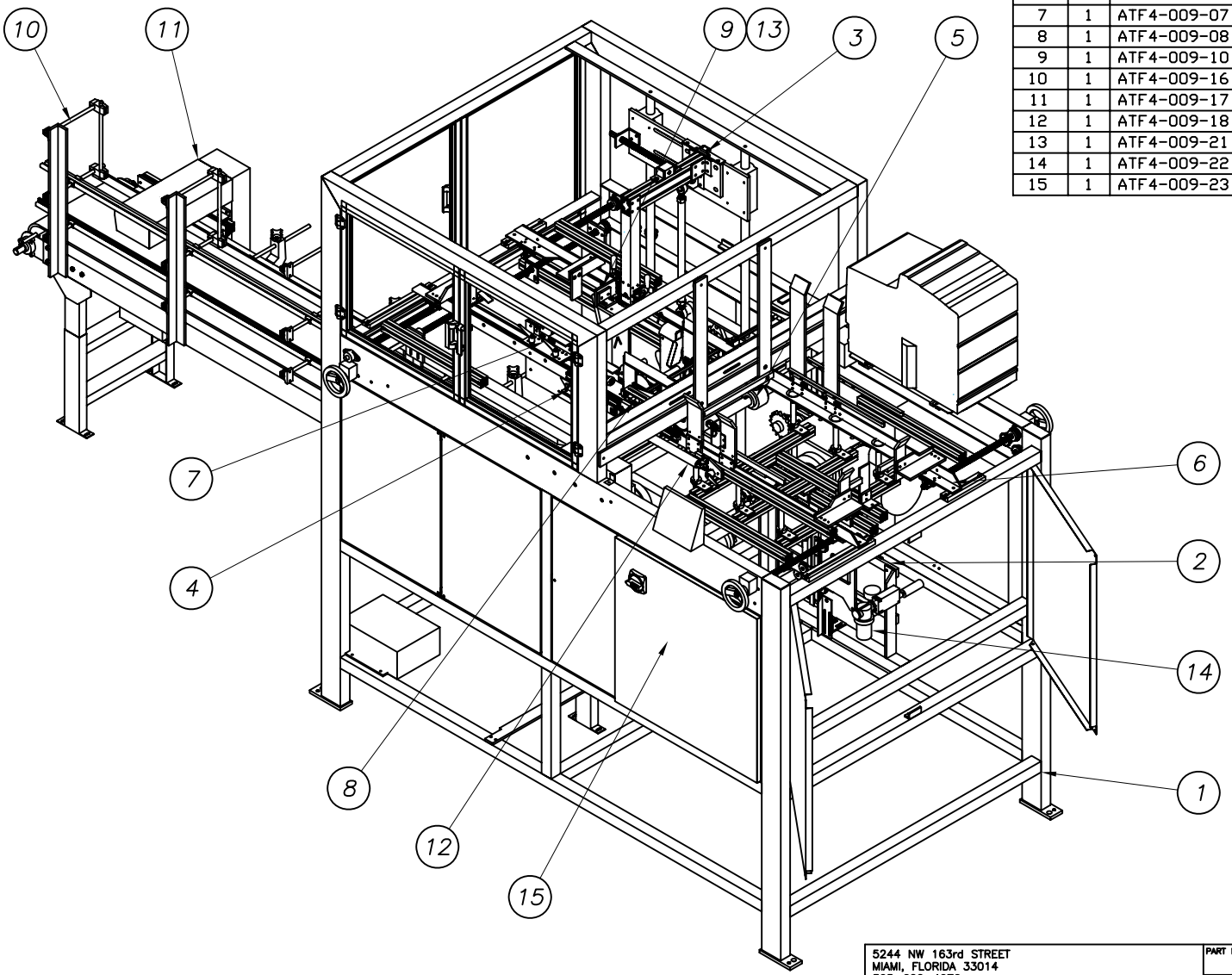
QTY	ITEM NUMBER	DESCRIPTION	Ordered
4	SUREBEAD DUAL .16	GLUE NOZZLE	
2	1095801	24VDC REPACEMENT VALVE	
6	4X2CRB	4” DIA YELLOW RUBBER ROLLER	
2	SY7000-5W-2POS-BODY	24VDC REPACEMENT VALVE	
16	VC32C-1	ACCORDIAN VACUUM CUP	
3	ADJDL-30	30A FUSES	
3	AD 20ACC	20A FUSES	
3	AD-15AFASTCC	15A FUSES	
3	AD-10AFASTCC	10A FUSES	
2	AD 5ACC	5A FUSES	
2	AD 4 ACC	4A FUSES	
4	TM-BLKLT	PUSH BUTTONS LED	
1	QS18VP6DQ5	PHOTO CELL	
1	PHQS18VP6LAFQ5	LASER PHOTO CELL	
1	C3PROXPNPN0	PROXIMITY SWITCH	
1	DW-AS-624-M18-002	PROXIMITY SWITCH	
1	360H100	DRIVE BELT TOP DRIVE	
1	300H100	DRIVE BELT IDLER	
1	22N9DCBV-24BVDC	2 WAY N.C., DIRECT ACTING VALVE	
1	FLT-I-90-100M	GLUE GUN FILTER	
2	ATF4-009-05-04	POLYURETHANE ROLLER	
2	SDR-20-6-BM	AIR CYLINDER	
1	CDR-24-3-BM	AIR CYLINDER	
2	UDR-20-10-BM	AIR CYLINDER	
1	SKIT-150	REPAIR KIT FOR 1-1/2 BORE AIR CYLINDERS	
2	E-2	VACUUM PUMP FILTER ELEMENT	

ASSEMBLY DRAWINGS AND ELECTRICAL DIAGRAMS

ATF4-009	MAIN ASSEMBLY
ATF4-009-02	BLANK PULL DOWN ASSEMBLY
ATF4-009-03	RAM ASSEMBLY
ATF4-009-04	FLAP LIFTER
ATF4-009-05	TOP DRIVE ASSEMBLY
ATF4-009-06	HOPPER ASSEMBLY
ATF4-009-07	FORMING SECTION ASSEMBLY
ATF4-009-08	GLUE GUN MOUNT ASSEMBLY
ATF4-009-10	MANDREL 1 ASSEMBLY
ATF4-009-16	CONVEYOR ASSEMBLY
ATF4-009-17	INDEXER ASSEMBLY
ATF4-009-18	POSITIONER ASSEMBLY
ATF4-009-21	MANDREL 2A ASSEMBLY
ATF4-009-22	PNEUMATIC SCHEMATIC

ASSEMBLY BILL OF MATERIALS

ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	ATF4-009-01	FRAME WELDMENT
2	1	ATF4-009-02	BLANK PULLDOWN ASSY
3	1	ATF4-009-03	RAM ASSEMBLY
4	1	ATF4-009-04	FLAP LIFTER ASSEMBLY
5	1	ATF4-009-05	TOP DRIVE ASSEMBLY
6	1	ATF4-009-06	HOPPER ASSEMBLY
7	1	ATF4-009-07	FORMING SECTION ASSEMBLY
8	1	ATF4-009-08	GLUE GUN MOUNT ASSEMBLY
9	1	ATF4-009-10	MANDREL 1 ASSEMBLY
10	1	ATF4-009-16	CONVEYOR ASSEMBLY
11	1	ATF4-009-17	INDEXER ASSEMBLY
12	1	ATF4-009-18	POSITIONER ASSEMBLY
13	1	ATF4-009-21	MANDREL 2A ASSEMBLY
14	1	ATF4-009-22	PNEUMATIC SCHEMATIC
15	1	ATF4-009-23	ELECTRICAL SCHEMATIC



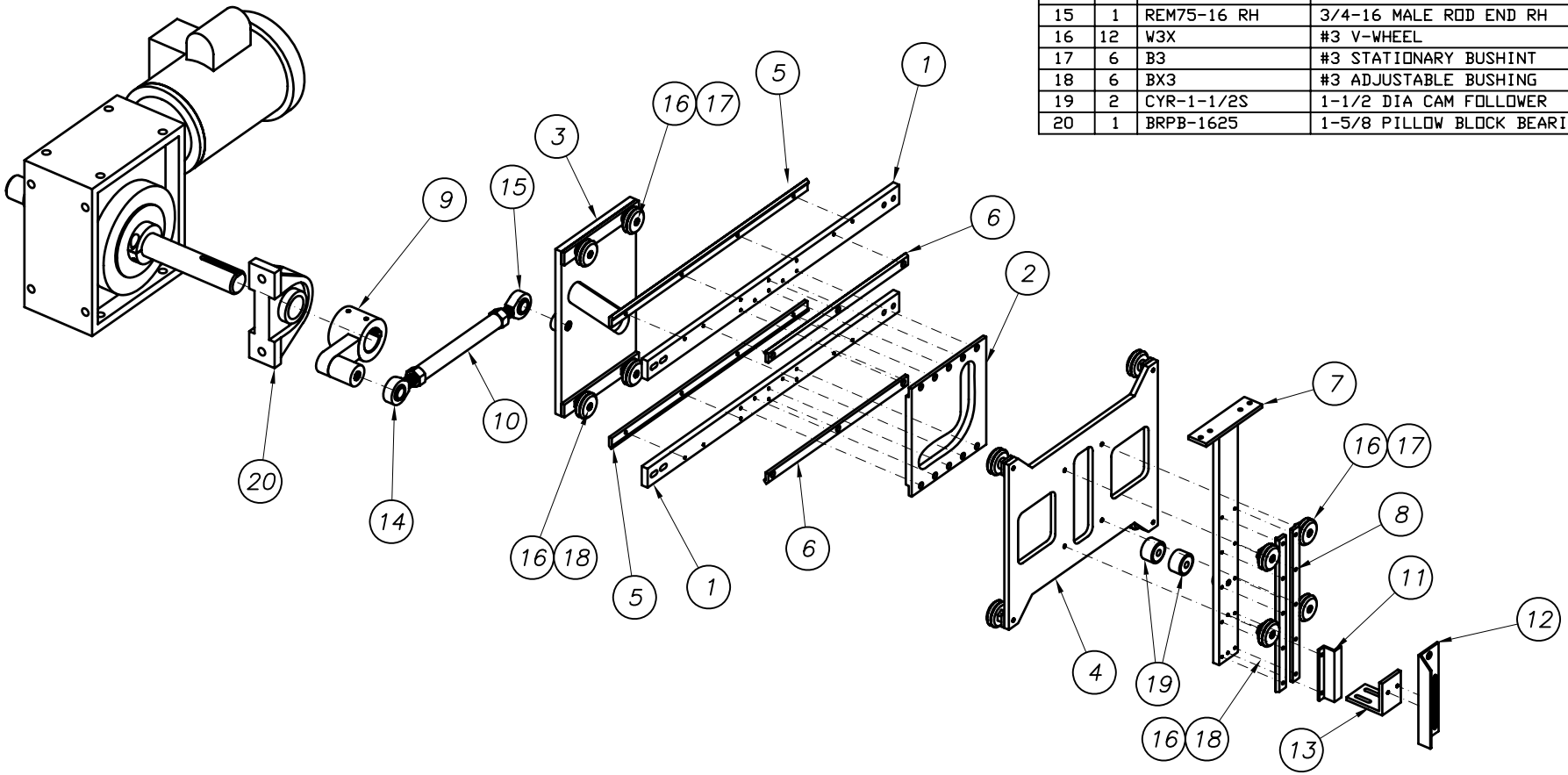
5244 NW 163rd STREET
MIAMI, FLORIDA 33014
305-622-4070

EAGLE
Packaging Machinery, LLC.

PART NAME	VASSOYO SN: 11161
MACHINE MODEL	VASSOYO
DWG NO.	ATF4-009
REV	-
DRAWN BY:	JFdez
DATE:	09/22/11
SHEET:	1 OF 1

ASSEMBLY BILL OF MATERIALS

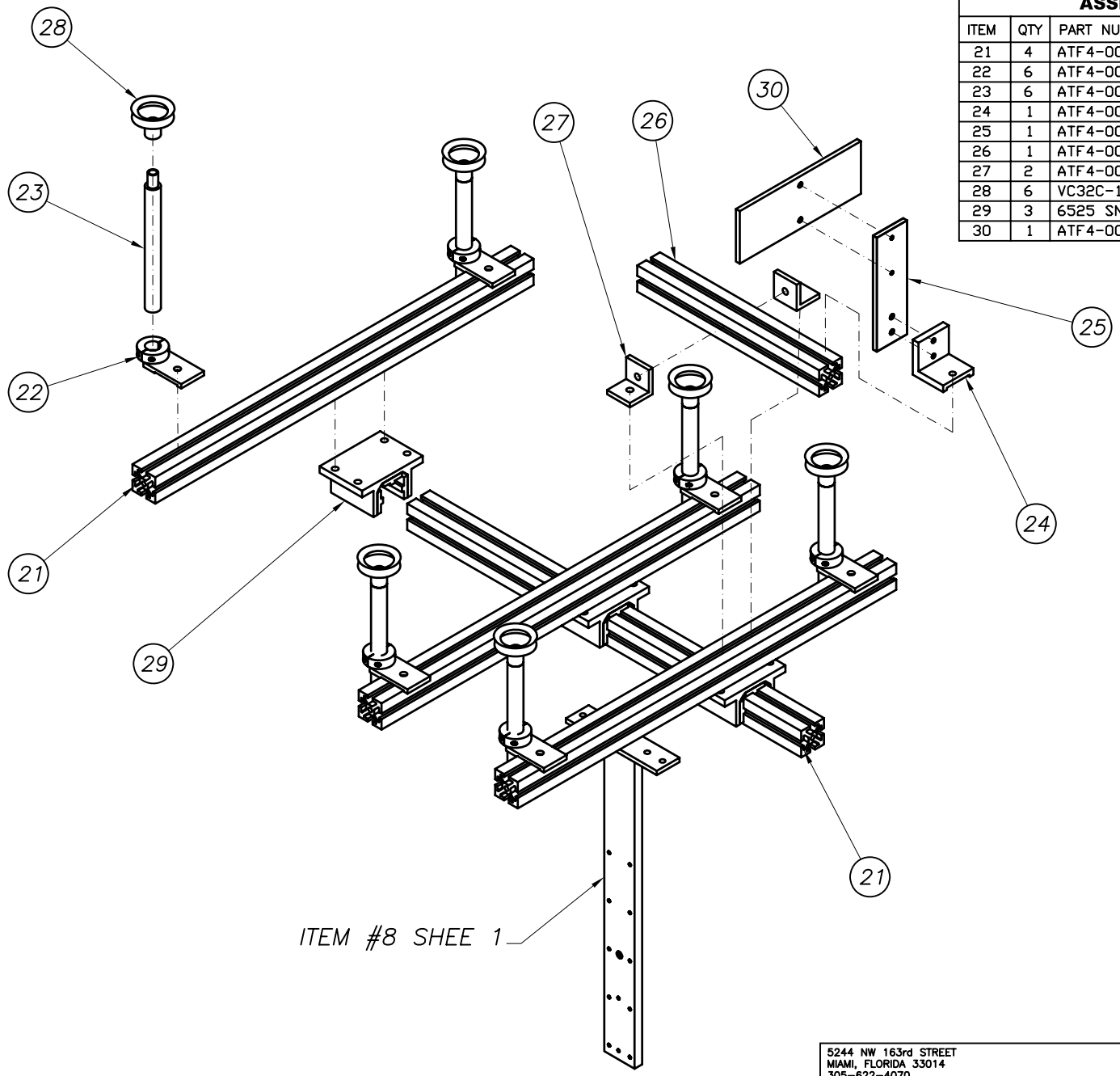
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	ATF4-009-02-01	CROSS BAR
2	1	ATF4-009-02-02	CAM PLATE
3	1	ATF4-009-02-03	MOVABLE CAM
4	1	ATF4-009-02-04	CARRIAGE
5	2	ATF4-009-02-05	V-TRACK BASE PLATE
6	2	ATF4-009-02-06	V-TRACK MOVEABLE CAM
7	1	ATF4-009-02-07	VERTICAL BEAM
8	2	ATF4-009-02-08	VERTICAL V-TRACK
9	1	ATF4-009-02-14	BPD CRANK
10	1	ATF4-009-02-16	TURNBUCKEL
11	1	ATF4-009-02-17	PROX SENSOR PLATE
12	1	ATF4-009-02-18	PROX MOUNT
13	1	ATF4-009-02-19	PROX SPACER ANGLE
14	1	REM75-16 LH	3/4-16 MALE ROD END LH
15	1	REM75-16 RH	3/4-16 MALE ROD END RH
16	12	W3X	#3 V-WHEEL
17	6	B3	#3 STATIONARY BUSHINT
18	6	BX3	#3 ADJUSTABLE BUSHING
19	2	CYR-1-1/2S	1-1/2 DIA CAM FOLLOWER
20	1	BRPB-1625	1-5/8 PILLOW BLOCK BEARING



5244 NW 163rd STREET
MIAMI, FLORIDA 33014
305-622-4070

EAGLE
Packaging Machinery, LLC.

PART NAME: **BLANK PULL DOWN ASSY**
MACHINE MODEL: VASSOYO
DWG NO.: ATF4-009-02 REV: -
DRAWN BY: JFdez DATE: 01/03/07 SHEET: 1 OF 2



ASSEMBLY BILL OF MATERIALS

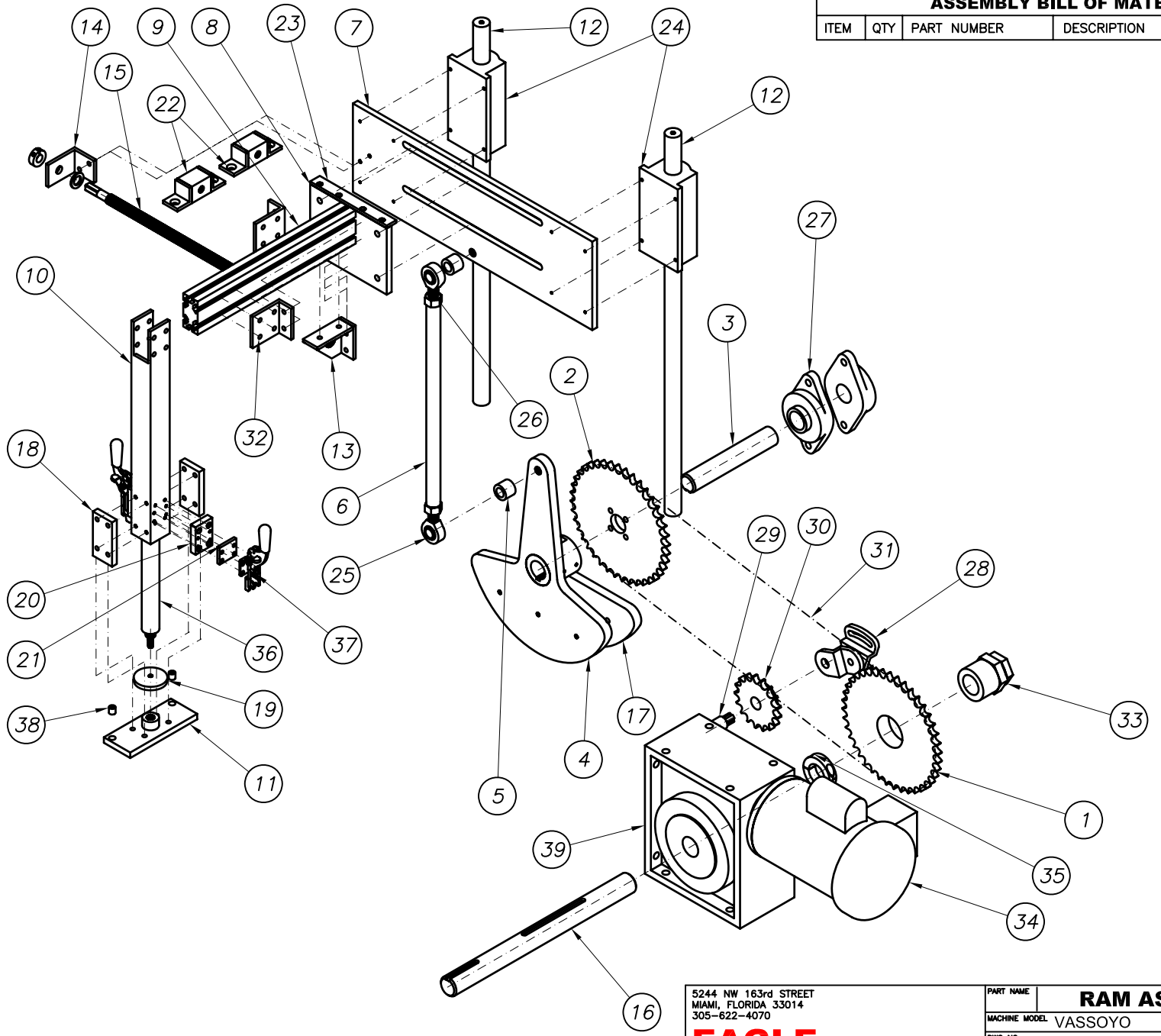
ITEM	QTY	PART NUMBER	DESCRIPTION
21	4	ATF4-009-02-09	BEAM
22	6	ATF4-009-02-11	VACUUM TUBE MOUNT
23	6	ATF4-009-02-12	VACUUM TUBE
24	1	ATF4-009-02-13	BLANK PUSHER SUPPORT
25	1	ATF4-009-02-15	BLANK PUSHER
26	1	ATF4-009-02-20	SLIDE
27	2	ATF4-009-02-21	SLIDE SUPPORT
28	6	VC32C-1	VACUUM CUP
29	3	6525 SNG LIN BRG	LINEAR BEARING
30	1	ATF4-009-02-22	PUSHER EXTENSION

5244 NW 163rd STREET
MIAMI, FLORIDA 33014
305-622-4070
EAGLE
Packaging Machinery, LLC.

PART NAME: **BLANK PULLDOWN**
MACHINE MODEL: VASSOYO
DWG NO.: ATF4-009-02
REV: -
DRAWN BY: JFdez
DATE: 03/19/10
SHEET: 2 OF 2

ASSEMBLY BILL OF MATERIALS

ITEM	QTY	PART NUMBER	DESCRIPTION



5244 NW 163rd STREET
MIAMI, FLORIDA 33014
305-622-4070

EAGLE
Packaging Machinery, LLC.

PART NAME	**RAM ASSEMBLY**
MACHINE MODEL	VASSOYO
DWG NO.	ATF4-009-03
REV	-
DRAWN BY:	JFdez
DATE:	03/25/10
SHEET:	1 OF 2

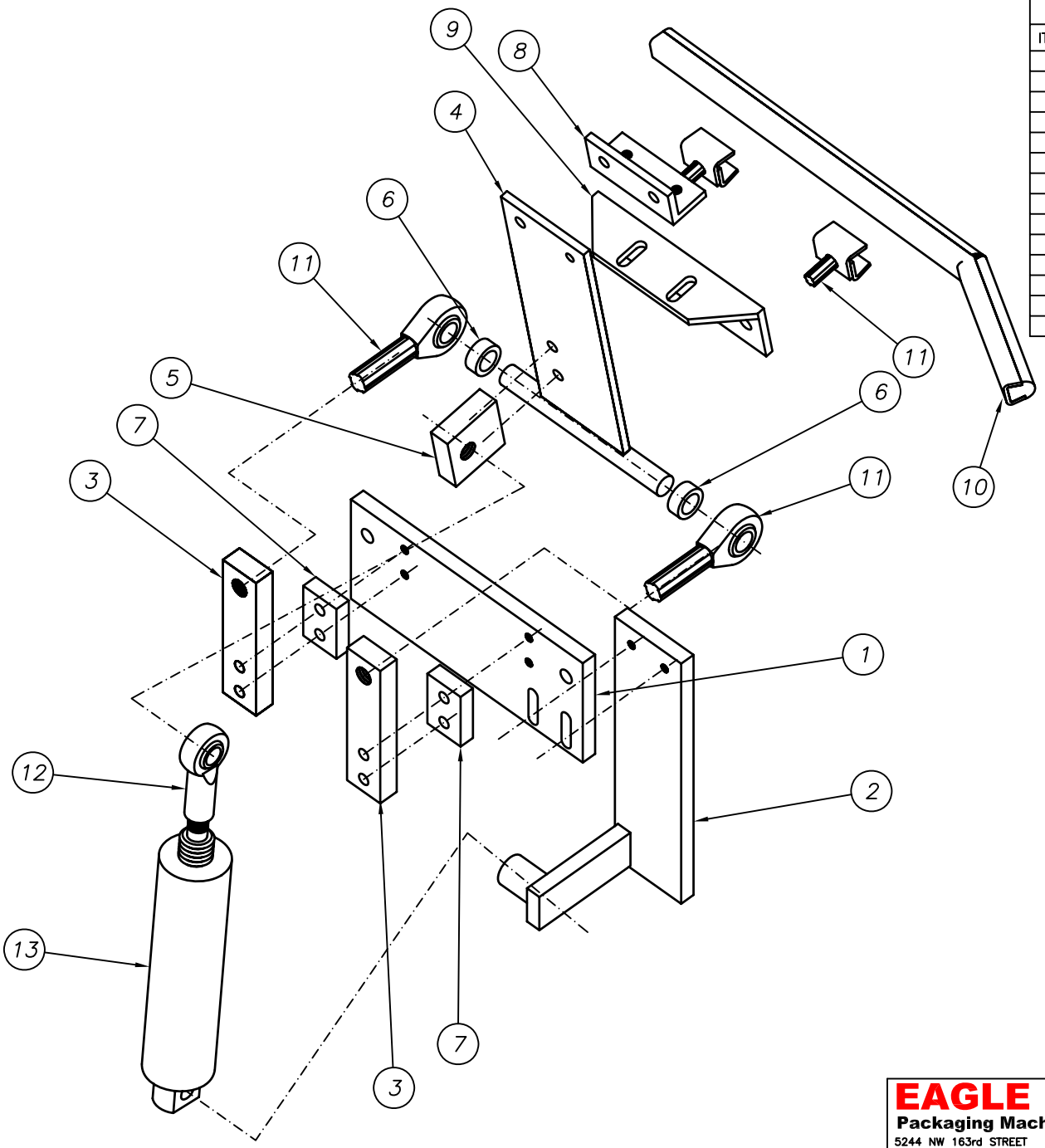
ASSEMBLY BILL OF MATERIALS

ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	ATF4-008-03-01	DRIVE SPROCKET MODIFICATION
2	1	ATF4-009-03-02	RAM SPROCKET MODIFICATION
3	1	ATF4-009-03-03	CRANK SHAFT
4	1	ATF4-009-03-04	RAM CRANK 9"
5	2	ATF4-009-03-05	SPACER
6	1	ATF4-009-03-06	RAM CRANK ARM
7	1	ATF4-009-03-07	RAM PLATE
8	1	ATF4-009-03-08	RAM ARM BASE PLATE
9	1	ATF4-009-03-09	RAM TOP BEAM
10	1	ATF4-009-03-10	RAM VERTICAL BEAM
11	1	ATF4-009-03-11	RAM END PLATE
12	2	ATF4-009-03-12	RAM GUIDE ROD
13	1	ATF4-009-03-13	RAM ADJUSTING NUT
14	1	ATF4-009-03-14	RAM ADJUSTING SHAFT ANDGLE
15	1	ATF4-009-03-15	RAM ADJUSTING SHAFT
16	1	ATF4-009-03-17	BOTTOM DRIVE SHAFT
17	1	ATF4-009-03-18	COUNTERWEIGHT
18	2	ATF4-009-03-19	BASE PLATE SUPPORT
19	1	ATF4-009-03-20	EJECTOR DISC
20	2	ATF4-009-03-21	CLAMP BASE
21	2	ATF4-009-03-22	CLAMP SPACER
22	2	ATF4-009-03-23	MANIFOLD
23	1	ATF4-009-03-26	RAM GUIDE PLATE
24	2	RJUI-11-XXTW	1-1/4 PILLOW BLOCK
25	1	REM75-16 LH	3/4-16 MALE ROD END LH
26	1	REM75-17 RH	3/4-16 MALE ROD END RH
27	2	BRF2-150	1-1/2 FLANGE BEARING
28	1	SM	CHAIN TIGHTENER
29	1	N2	TIGHTENER SHAFT
30	1	HN60B15	IDLER SPROCKET
31	1	#60	#60 CHX106-1/2" LG, 142 PITCHES
32	4	4375	INSIDE CORNER BRACKET
33	1	TRAN 1.62	1-5/8 TRANTOR1UE
34	1	VM3557T	1-1/2HP, 1140RPM, MOTOR
35	1	COL 1-5/8 2PC	COLLAR 1-5/8 2 PIECES
36	1	SDR-20-6-B	AIR CLYLINDER SINGLE ACTING
37	2	TC-331	PULL ACTION CLAMP
38	2	1/4 PIN LINER	DOWEL PIN LINER
39	1	NMRV110-40-180TC	40-1 GEAR REDUCER

5244 NW 163rd STREET
MIAMI, FLORIDA 33014
305-622-4070

EAGLE
Packaging Machinery, LLC.

PART NAME: **RAM ASSEMBLY**
MACHINE MODEL: VASSOYO
DWG NO.: ATF4-009-03 | REV: -
DRAWN BY: JFdez | DATE: 03/25/10 | SHEET: 2 OF 2



ASSEMBLY BILL OF MATERIALS

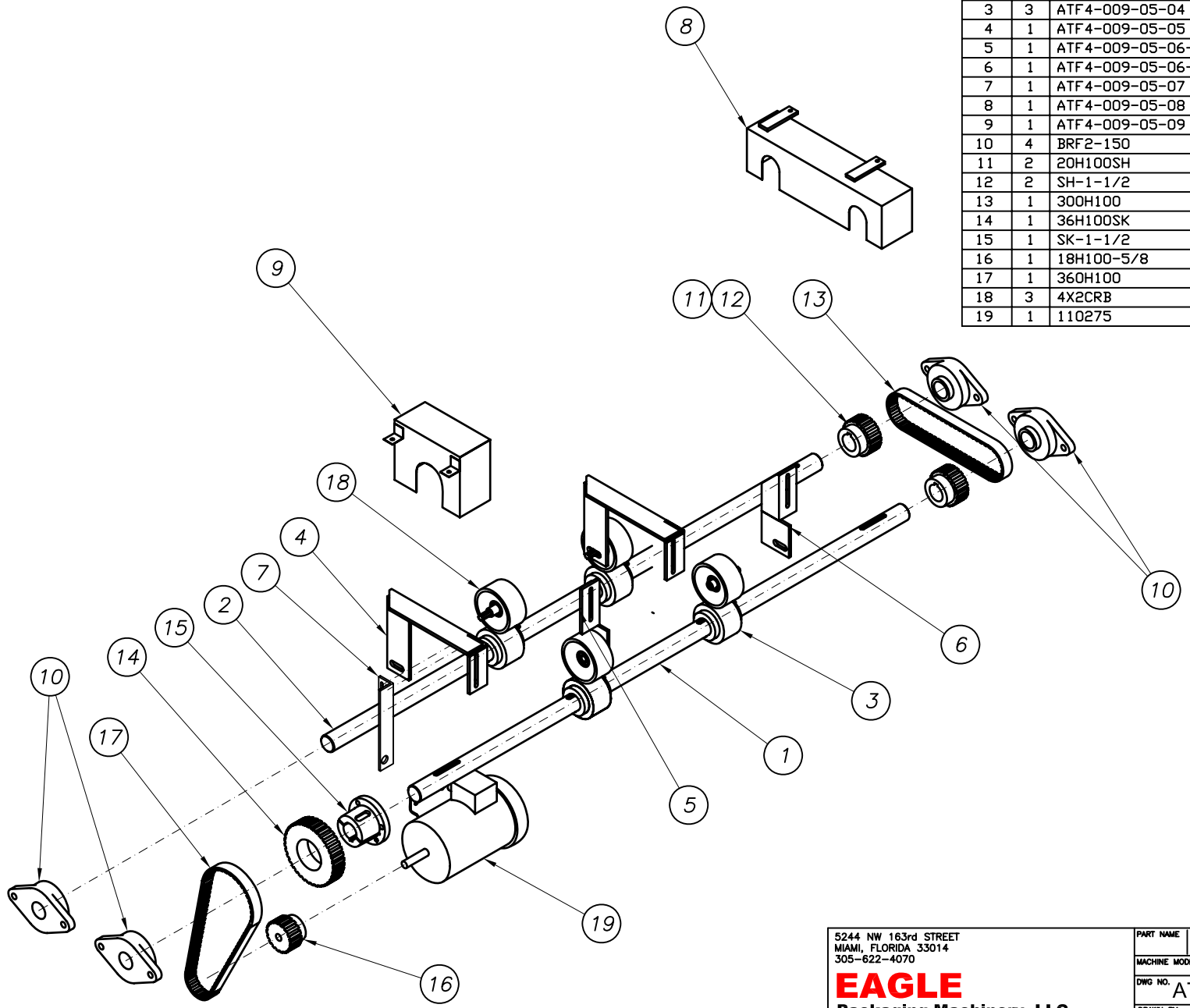
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	ATF4-009-04-01	BASE PLATE
2	1	ATF4-009-04-02	REAR CLYINDER MOUNT
3	2	ATF4-009-04-03	BEARING MOUNT
4	1	ATF4-009-04-04	FLAP LIFTER
5	1	ATF4-009-04-05	FRONT CYLINDER MOUNT
6	2	ATF4-009-04-06	SPACER
7	2	ATF4-009-04-07	BEARING SPACER
8	2	ATF4-009-04-08	SUPPORT ANGLE
9	2	ATF4-009-04-09	ADJUSTING ANGLE
10	2	ATF4-009-04-10	GUIDE
11	2	REM. 50-20	1/2-20 RH MALE ROD END BEARING
12	1	REF. 43-20	7/16-20 FEMALE ROD END BEARING
13	1	CDR-24-3-BM	1-1/2 X 3 AIR CYLINDER
13	2	VG-018-01	CLIP

EAGLE
Packaging Machinery, LLC.
5244 NW 163rd STREET
MIAMI, FLORIDA 33014
305-622-4070

PART NAME: **FLAP LIFTER ASSY**
MACHINE MODEL: VASSOYO
DWG NO.: ATF4-009-04 REV: -
DRAWN BY: MILONE DATE: 05/14/10 SHEET: 1 OF 1

ASSEMBLY BILL OF MATERIALS

ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	ATF4-009-05-02	TOP DRIVE SHAFT
2	1	ATF4-009-05-03	TOP IDLER SHAFT
3	3	ATF4-009-05-04	TOP DRIVE ROLLER
4	1	ATF4-009-05-05	CENTER ROLLER SUPPORT
5	1	ATF4-009-05-06-1	SIDE ROLLER SUPPORT
6	1	ATF4-009-05-06-2	SIDE ROLLER SUPPORT
7	1	ATF4-009-05-07	PHOTO EYE MOUNG
8	1	ATF4-009-05-08	GUARD RIGHT
9	1	ATF4-009-05-09	GUARD LEFT
10	4	BRF2-150	1-1/2 2-BOLT FLANGE BEARING
11	2	20H100SH	20 TOOTH TIMMING BELT PULLEY
12	2	SH-1-1/2	1-1/2 DIA SH BUSHING
13	1	300H100	1/2 PITCH X 1" WIDE GEAR BELT
14	1	36H100SK	36 TOOTH TIMMING BELT PULLEY
15	1	SK-1-1/2	1-1/2 SK BUSHING
16	1	18H100-5/8	18 TOOTH TIMMING BELT PULLEY
17	1	360H100	1/2 PITCH X 1" WIDE GEAR BELT
18	3	4X2CRB	4" RUBBER ROLLER
19	1	110275	3/4 HP, 1140 MOTOR



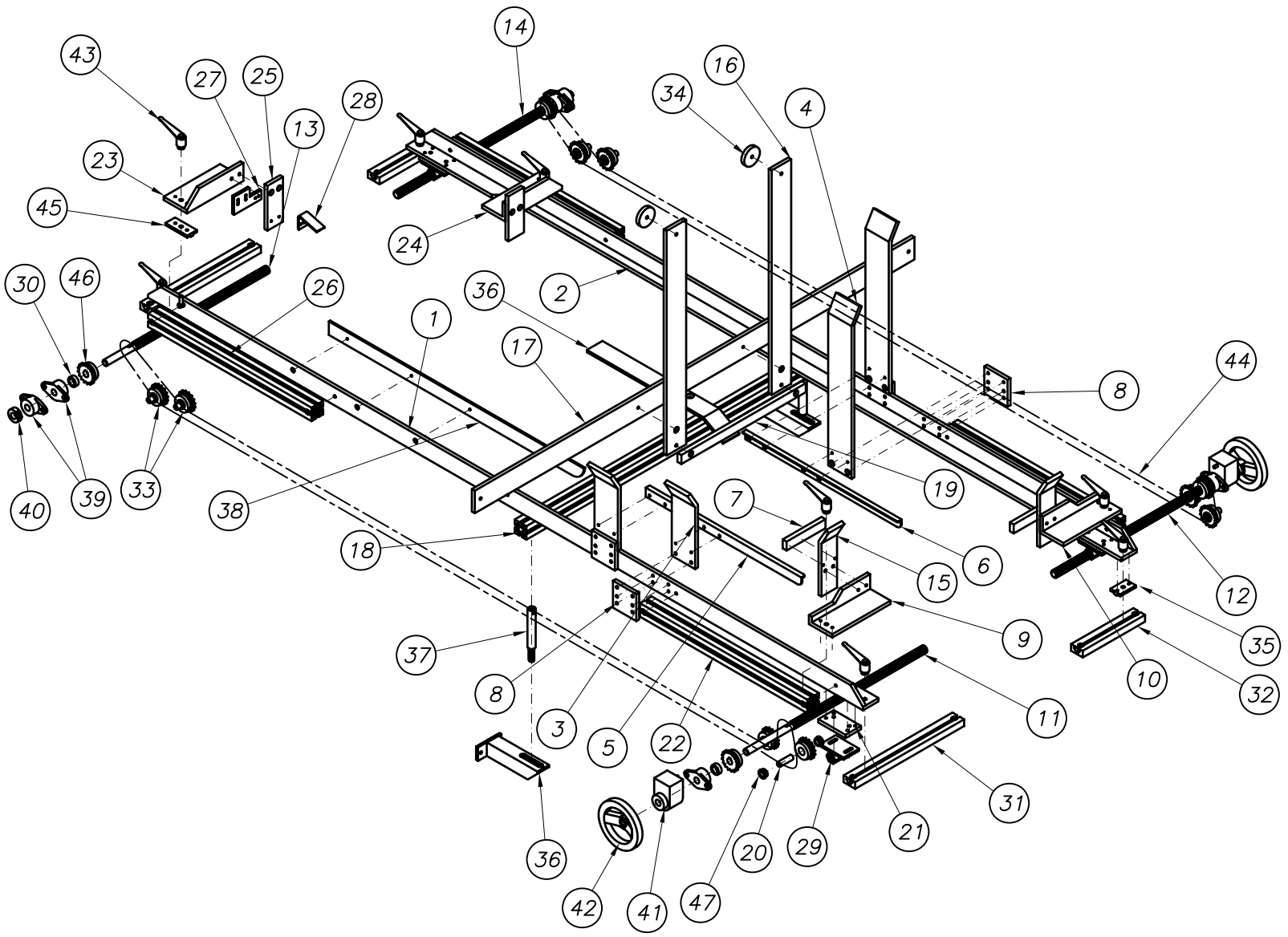
5244 NW 163rd STREET
MIAMI, FLORIDA 33014
305-622-4070

EAGLE
Packaging Machinery, LLC.

PART NAME	**TOP DRIVE ASSEMBLY**
MACHINE MODEL	VASSOYO
DWG NO.	ATF4-009-05
REV	-
DRAWN BY:	JFdez
DATE:	03/24/10
SHEET:	1 OF 1

ASSEMBLY BILL OF MATERIALS

ITEM	QTY	PART NUMBER	DESCRIPTION



5244 NW 163rd STREET
MIAMI, FLORIDA 33014
305-622-4070

EAGLE
Packaging Machinery, LLC.

PART NAME	**HOPPER ASSEMBLY**
MACHINE MODEL	VASSOYO
DWG NO.	ATF4-009-06
REV	-
DRAWN BY:	JFdez
DATE:	03/17/10
SHEET:	1 OF 2

ASSEMBLY BILL OF MATERIALS

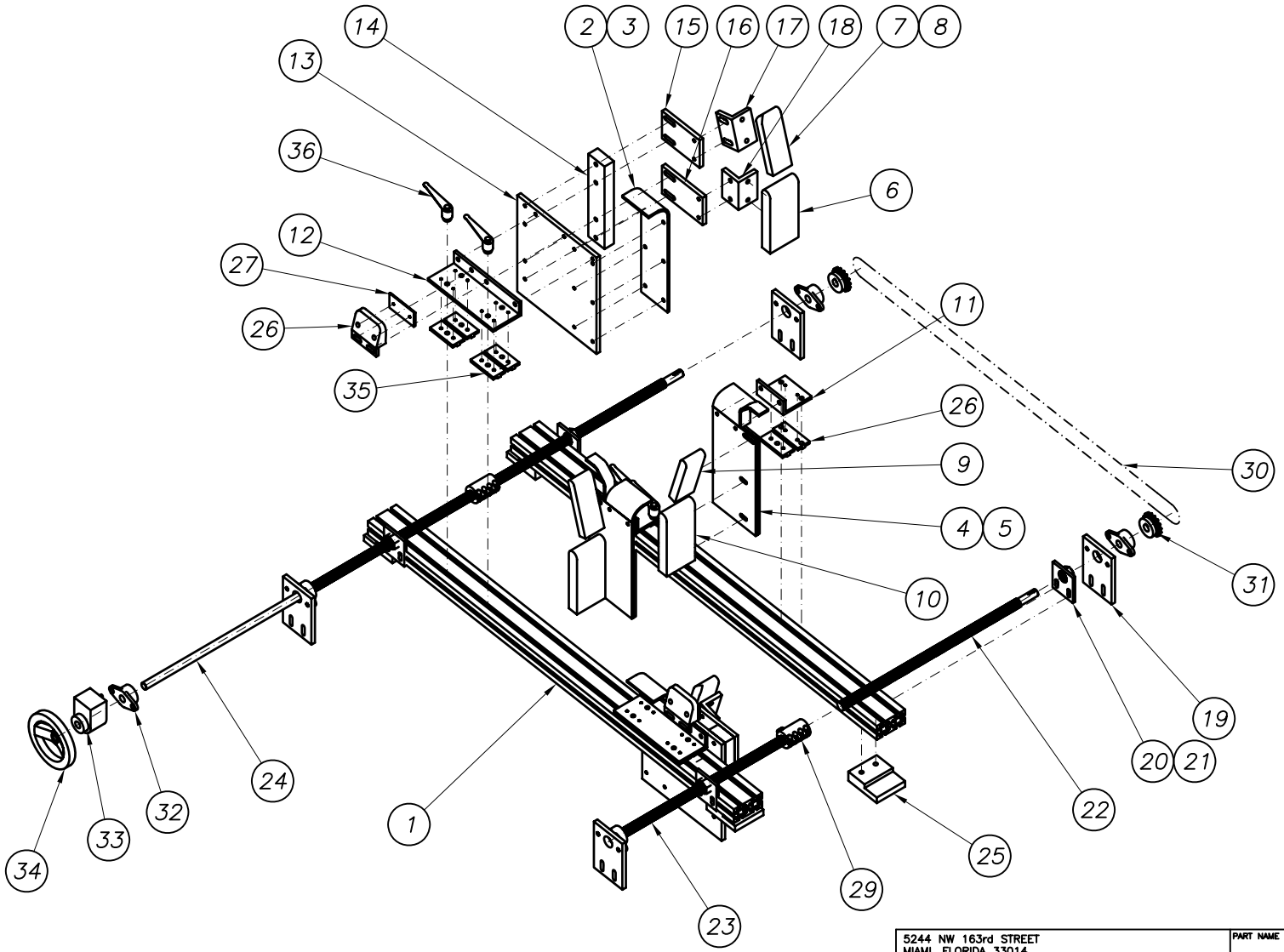
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	ATF4-009-06-01-1	GUIDE RAIL
2	1	ATF4-009-06-01-2	GUIDE RAIL
3	2	ATF4-009-06-02	VERTICAL GUIDE SHORT
4	2	ATF4-009-06-03	VERTICAL GUIDE LONG
5	1	ATF4-009-06-04-1	SIDE BOTTOM SUPPORT
6	1	ATF4-009-06-04-2	SIDE BOTTOM SUPPORT
7	1	ATF4-009-06-05	REAR BOTTOM SUPPORT
8	4	ATF4-009-06-06	VERTICAL GUIDE SUPPORT
9	1	ATF4-009-06-07-1	REAR GUIDE SUPPORT
10	1	ATF4-009-06-07-2	REAR GUIDE SUPPORT
11	1	ATF4-009-06-08	ADJUSTING SHAFT 1
12	1	ATF4-009-06-09	ADJUSTING SHAFT 2
13	1	ATF4-009-06-10	ADJUSTING SHAFT 3
14	1	ATF4-009-06-11	ADJUSTING SHAFT 4
15	2	ATF4-009-06-12	REAR GUIDE
16	2	ATF4-009-06-13	FRONT GUIDE
17	1	ATF4-009-06-14	FRONT GUIDE SUPPORT
18	1	ATF4-009-06-15	SUPPORT BEAM
19	1	ATF4-009-06-16	BOTTOM FRONT SUPPORT
20	8	ATF4-009-06-17	SPROCKET SHAFT
21	4	ATF4-009-06-18	NUT SPACER
22	2	ATF4-009-06-19	REAR GUIDE TRACK
23	1	ATF4-009-06-20-1	BACK STOP SUPPORT
24	1	ATF4-009-06-20-2	BACK STOP SUPPORT
25	2	ATF4-009-06-21	BACK STOP
26	2	ATF4-009-06-22	BACK STOP GUIDE
27	1	ATF4-009-06-23	BLANK END SUP BASE
28	1	ATF4-009-06-24	BLANK END SUPPORT
29	4	ATF4-009-06-25	ADJUSTING BRACKET
30	4	ATF4-009-06-26	SPACER
31	2	ATF4-009-06-27	RAIL GUIDE LONG
32	2	ATF4-009-06-28	RAIL GUIDE SHORT
33	8	ATF4-009-06-29	IDLER SPROCKET
34	2	ATF4-009-06-30	SPACER
35	4	ATF4-009-06-31	SLIDE MODIFICATION
36	2	ATF4-009-06-32	BEAM SUPPORT ANGLE
37	2	ATF4-009-06-33	BEAM SUPPORT
38	1	ATF4-009-06-34	LID TOP SUPPORT
39	6	HF3-625-B	BEARING
40	4	SETCOL-062	COLLAR 5/8 1PC
41	2	DIAL IND 1 CW	PART DISCRIPTION
42	2	HAND 5" PLAST	DIA 5" HANDWHEEL
43	8	5TA03K	LOCK HANDLE 5/16-18 FEMALE
44	2	35 CHAIN	#35 CHAIN X 489 PITCHES (183.75")
45	4	8020 6817	BEARING
46	4	35B16	DRIVE SPROCKET
47	16	05-075-038FLBU	1/2 FLANGE BEARING

5244 NW 163rd STREET
MIAMI, FLORIDA 33014
305-622-4070

EAGLE
Packaging Machinery, LLC.

PART NAME: **HOPPER ASSEMBLY**
MACHINE MODEL: VASSOYO
DWG NO.: ATF4-009-06 | REV: -
DRAWN BY: JFdez | DATE: 03/17/10 | SHEET: 2 OF 2

ASSEMBLY BILL OF MATERIALS			
ITEM	QTY	PART NUMBER	DESCRIPTION



5244 NW 163rd STREET
MIAMI, FLORIDA 33014
305-622-4070

EAGLE
Packaging Machinery, LLC.

PART NAME	FOLDING ASSEMBLY
MACHINE MODEL	VASSOYO
DWG NO.	ATF4-009-07
REV	-
DRAWN BY:	JFdez
DATE:	03/30/10
SHEET:	1 OF 2

ASSEMBLY BILL OF MATERIALS

ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	ATF4-009-07-01	SUPPORT BEAM
2	1	ATF4-009-07-02-1	LID SIDE FOLDER
3	1	ATF4-009-07-02-2	LID SIDE FOLDER
4	1	ATF4-009-07-03-1	FOLDER
5	1	ATF4-009-07-03-2	FOLDER
6	2	ATF4-009-07-04	LID SIDE PRESSURE PLATE
7	1	ATF4-009-07-05-1	LID SIDE END FOLDER
8	1	ATF4-009-07-05-2	LID SIDE END FOLDER
9	2	ATF4-009-07-06	END FOLDER
10	2	ATF4-009-07-07	PRESSURE PLATE
11	2	ATF4-009-07-08	SUPPORT ANGLE
12	2	ATF4-009-07-09	LID SIDE SUPPORT ANGLE
13	2	ATF4-009-07-10	FOLDING BASE
14	2	ATF4-009-07-11	SPACER
15	2	ATF4-009-07-12	TOP ADJSUTING PLATE
16	2	ATF4-009-07-13	BOTTOM ADJUSTING PLATE
17	2	ATF4-009-07-14	TOP ADJUSTING ANGLE
18	2	ATF4-009-07-15	BOTTOM ADJUSTING ANGLE
19	4	ATF4-009-07-16	BEARING SUPPORT
20	2	ATF4-009-07-17-1	ADJUSTING PLATE
21	1	ATF4-009-07-17-2	ADJUSTING PLATE
22	2	ATF4-009-07-18	ADJUSTING SHAFT #1
23	1	ATF4-009-07-19	ADJUSTING SHAFT #2
24	1	ATF4-009-07-20	ADJUSTING SHAFT #3
25	4	ATF4-009-07-21	BOTTOM SUPPORT
26	2	ATF4-009-07-22	SLIDE
27	2	ATF4-009-07-23	MINOR FOLDER
28	2	ATF4-009-07-24	BACKUP PLATE
29	2	35B16	SPROCKET 5/8 BORE WITH KEYWAY
30	1	#35 CHAIN	CHAIN #35 X 219 PITCHES (82-1/2")
31	2	075 COUPLING	DIA 3/4 COUPLING
32	5	HF3-625-B	BEARING
33	1	DIAL IND 1/2 CW	DIAL INDICATOR
34	1	4BE30/R	HANDWHEEL
35	10	8020 6817	LINEAR BEARING
36	4	5TA03K	LOCK HANDLE 5/16-18

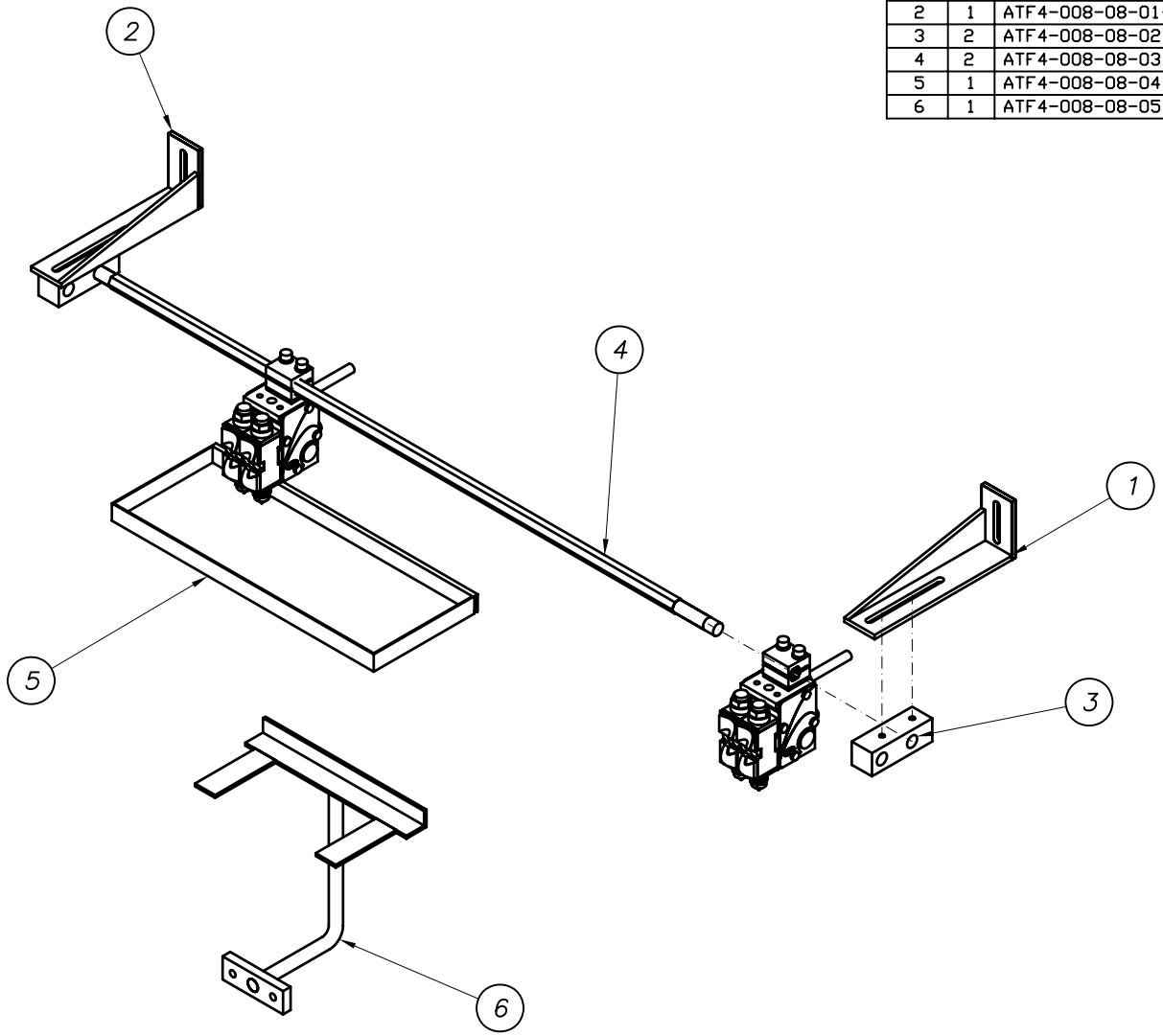
5244 NW 163rd STREET
MIAMI, FLORIDA 33014
305-622-4070

EAGLE
Packaging Machinery, LLC.

PART NAME: **FOLDING ASSEMBLY**
MACHINE MODEL: VASSOYO
DWG NO.: ATF4-009-07 | REV: -
DRAWN BY: JFdez | DATE: 03/30/10 | SHEET: 2 OF 2

ASSEMBLY BILL OF MATERIALS

ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	ATF4-008-08-01-1	GLUE GUN BRACKET
2	1	ATF4-008-08-01-2	GLUE GUN BRACKET
3	2	ATF4-008-08-02	GLUE GUN BLOCK
4	2	ATF4-008-08-03	GLUE GUN MTG BAR
5	1	ATF4-008-08-04	GLUE TRAY
6	1	ATF4-008-08-05	GLUE TRAY BRACKET

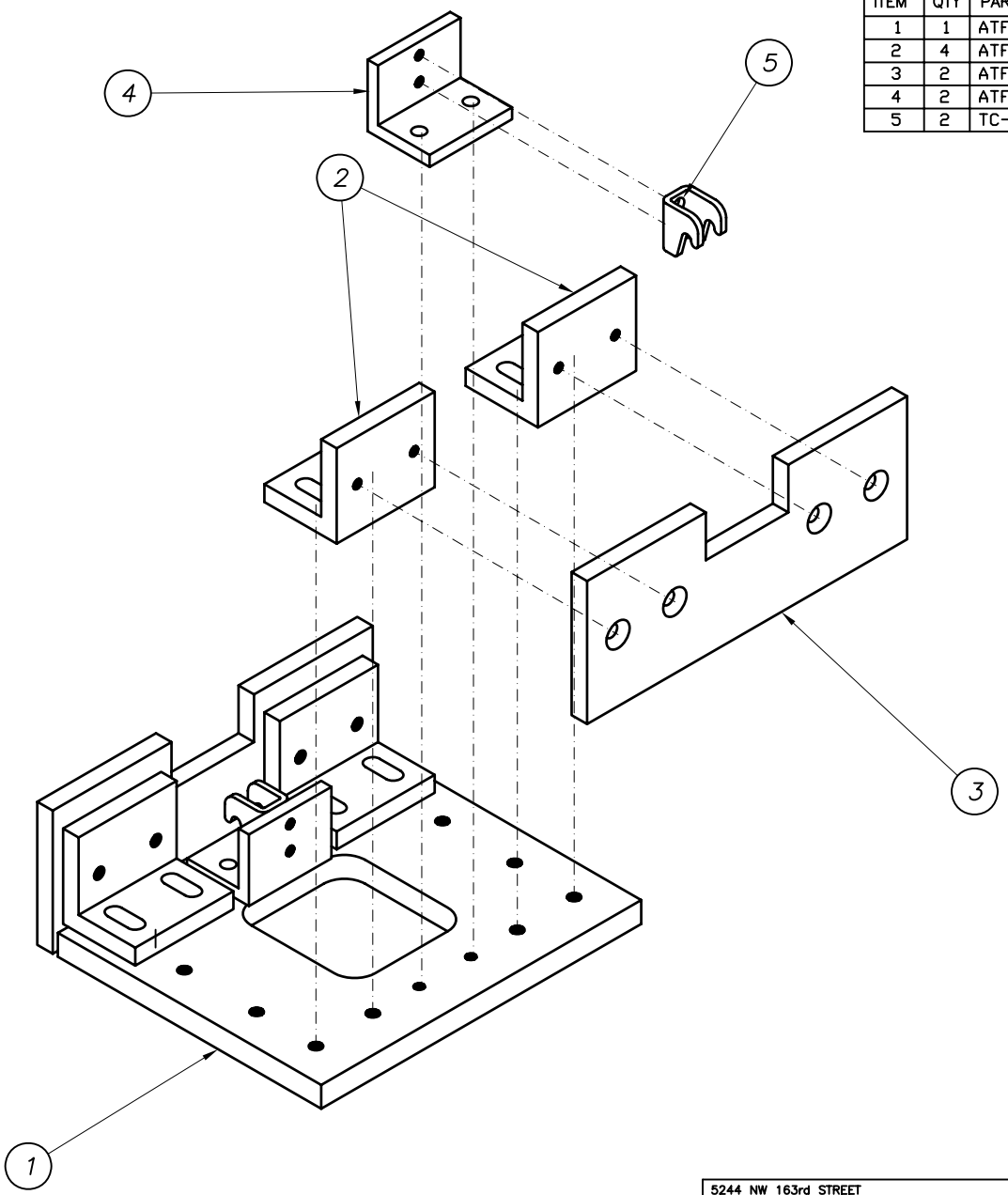


5244 NW 163rd STREET
MIAMI, FLORIDA 33014
305-622-4070
EAGLE
Packaging Machinery, LLC.

PART NAME: GLUE GUN ASSEMBLY
MACHINE MODEL: VASSOYO
DWG NO.: ATF4-009-08
REV: -
DRAWN BY: JFdez
DATE: 01/03/07
SHEET: 1 OF 1

ASSEMBLY BILL OF MATERIALS

ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	ATF4-009-10-01	MANDREL BASE
2	4	ATF4-009-10-02	WEAR PLATE SUPPORT ANGLE
3	2	ATF4-009-10-03	WEAR PLATE
4	2	ATF4-009-10-04	LATCH BASE
5	2	TC-331005	LATCH

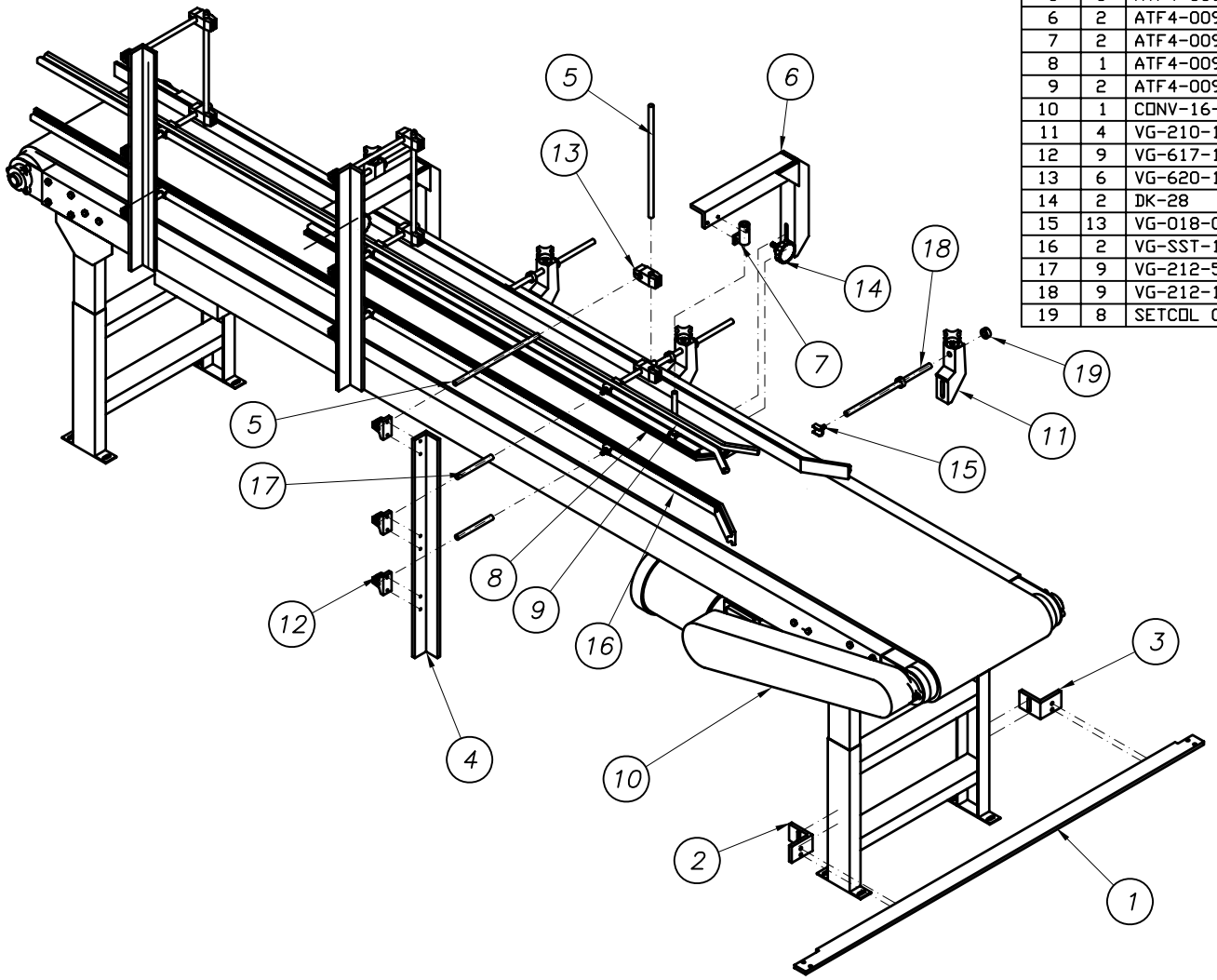


5244 NW 163rd STREET
MIAMI, FLORIDA 33014
305-622-4070
EAGLE
Packaging Machinery, LLC.

PART NAME: **MANDREL #1**
MACHINE MODEL: VASSOYO
DWG NO.: ATF4-009-10
REV: -
DRAWN BY: JFdez
DATE: 04/01/10
SHEET: 1 OF 1

ASSEMBLY BILL OF MATERIALS

ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	ATF4-009-16-01	CONVEYOR CONECTOR
2	2	ATF4-009-16-02-1	CONNECT ANGLE
3	1	ATF4-009-16-02-2	CONNECT ANGLE
4	3	ATF4-009-16-03	VERTICAL SUPPORT
5	6	ATF4-009-16-04	LONG BAR 1/2 X 13
6	2	ATF4-009-16-05	TOP GUIDE SUPPORT
7	2	ATF4-009-16-06	TOP GUIDE SUPPORT
8	1	ATF4-009-16-07	TOP GUIDE
9	2	ATF4-009-16-08	LID GUIDE
10	1	CONV-16-10	CONVEYOR
11	4	VG-210-12	RAIL BRACKET
12	9	VG-617-12	PART DISCRIPTION
13	6	VG-620-12-12	PART DISCRIPTION
14	2	DK-28	KNOB
15	13	VG-018-01	RAIL CLIP
16	2	VG-SST-1.60X10	RAIL
17	9	VG-212-5-516	GUIDE ROD
18	9	VG-212-12-516	GUIDE ROD
19	8	SETCOL 050	COLLAR

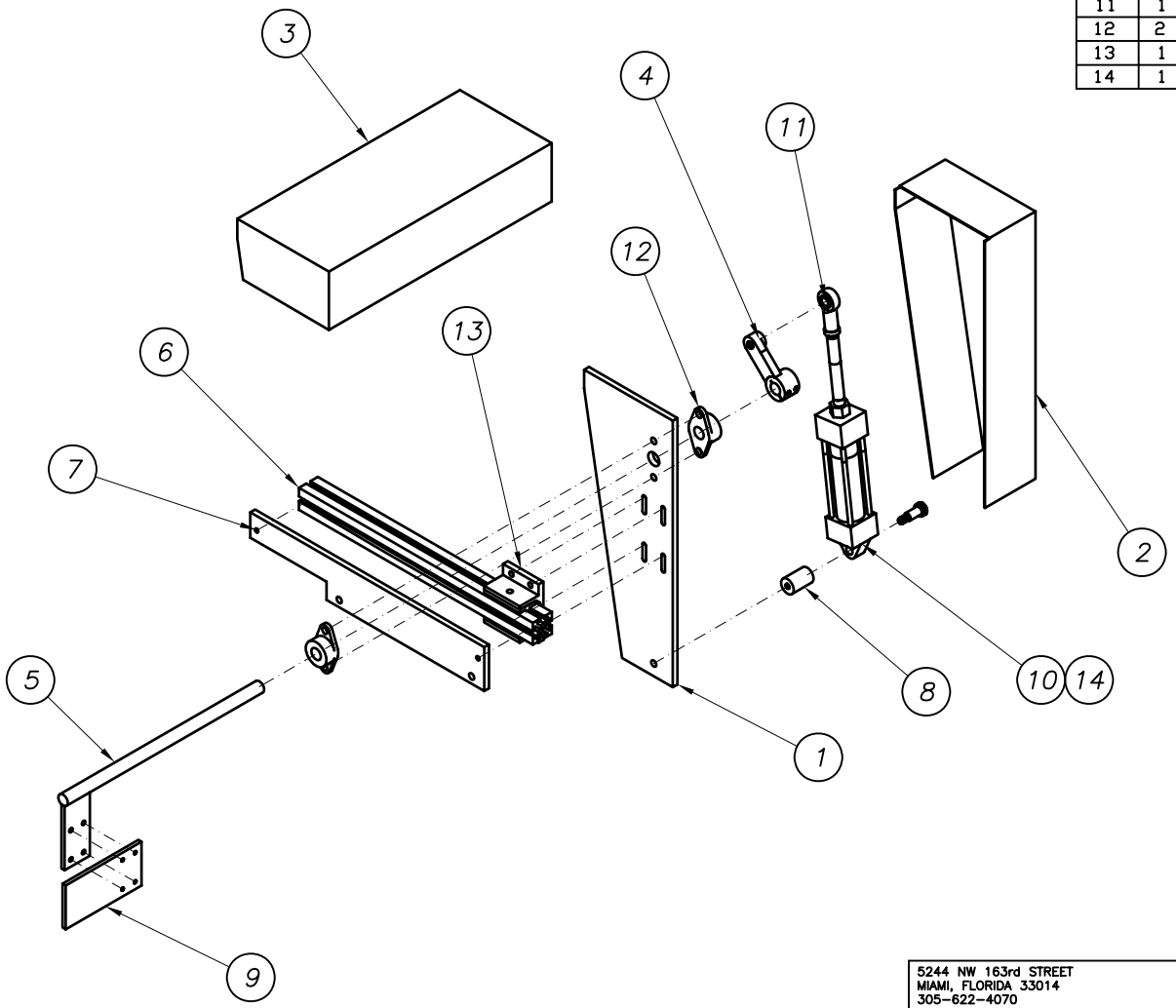


5244 NW 163rd STREET
MIAMI, FLORIDA 33014
305-622-4070
EAGLE
Packaging Machinery, LLC.

PART NAME: CONVEYOR ASSEMBLY
MACHINE MODEL: VASSOYO
DWG NO.: ATF4-009-16
REV: -
DRAWN BY: JFdez
DATE: 06/25/10
SHEET: 1 OF 1

ASSEMBLY BILL OF MATERIALS

ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	ATF4-009-17-01	CYLINDER BASE
2	1	ATF4-009-17-02	CYLINDER COVER
3	1	ATF4-009-17-03	TOP COVER
4	1	ATF4-009-17-04	CRANK
5	1	ATF4-009-17-05	STOPPER
6	1	ATF4-009-17-06	SLIDE
7	1	ATF4-009-17-07	SLIDE BASE
8	1	ATF4-009-17-08	CYLINDER PIVOT
9	1	ATF4-009-17-09	STOP PLATE
10	1	SACST15X4	AIR CYLINDER
11	1	REF-050-RH	ROD END BEARING
12	2	HF3-075-B	BEARING
13	1	8020 6525	LINEAR BEARING
14	1	NCA1-P150	EYE BRACKET

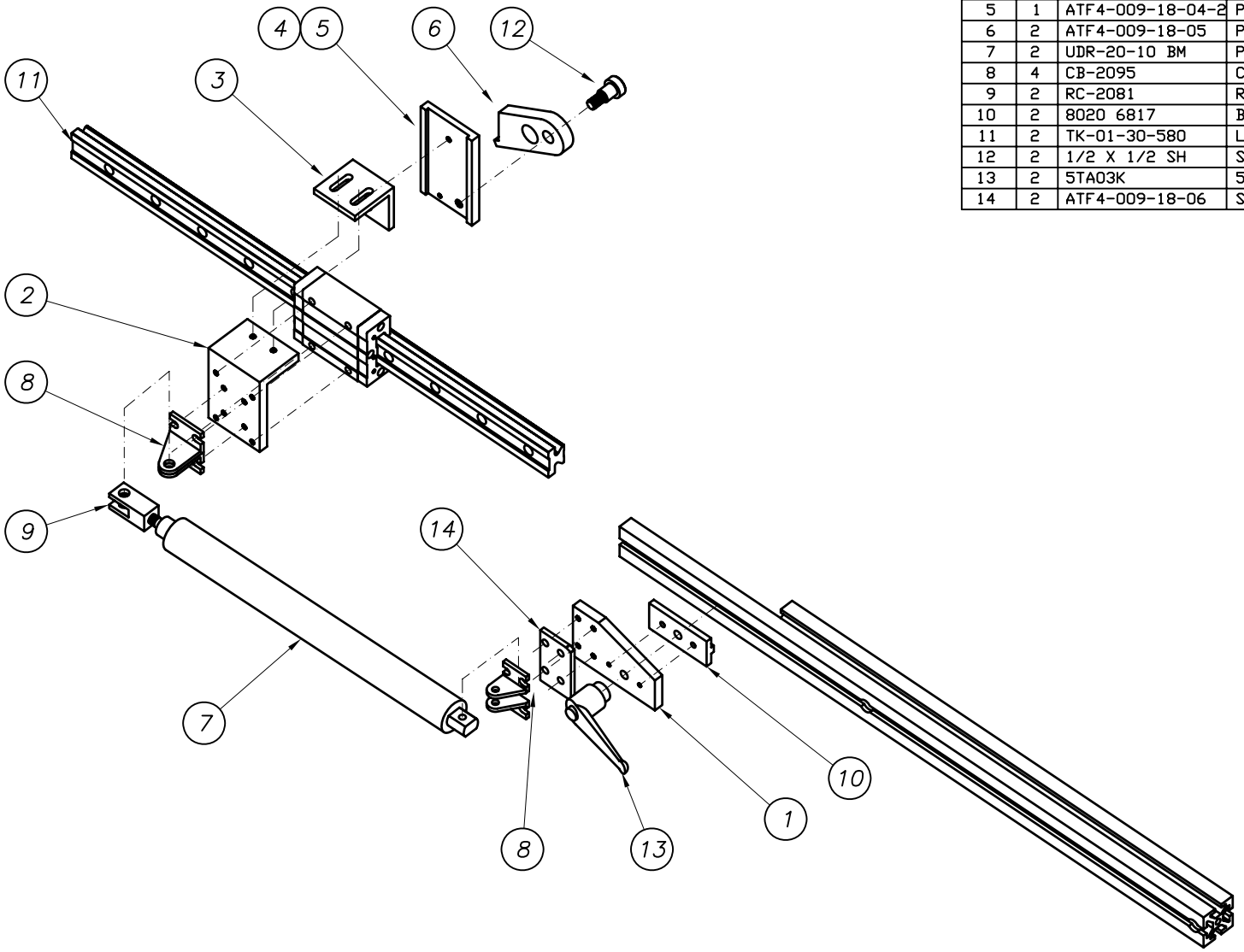


5244 NW 163rd STREET
MIAMI, FLORIDA 33014
305-622-4070
EAGLE
Packaging Machinery, LLC.

PART NAME	INDEXER ASSEMBLY
MACHINE MODEL	VASSOYO
DWG NO.	ATF4-009-17
REV	-
DRAWN BY:	JFdez
DATE:	06/26/10
SHEET:	1 OF 1

ASSEMBLY BILL OF MATERIALS

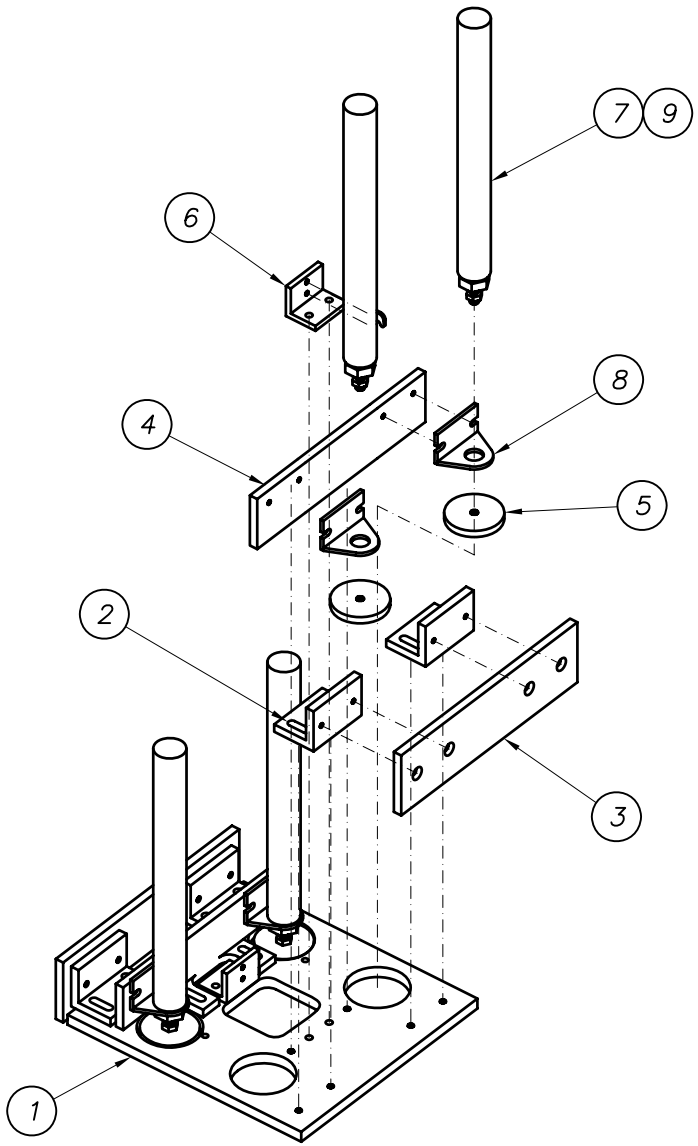
ITEM	QTY	PART NUMBER	DESCRIPTION
1	2	ATF4-009-18-01	REAR CYLINDER MOUNT
2	2	ATF4-009-18-02	BEARING PLATE
3	2	ATF4-009-18-03	ADJUSTING ANGLE
4	1	ATF4-009-18-04-1	POSITIONER MOUNT
5	1	ATF4-009-18-04-2	POSITIONER MOUNT
6	2	ATF4-009-18-05	POSITIONER
7	2	UDR-20-10 BM	PART DISCRIPTION
8	4	CB-2095	CLEVIS MOUNT
9	2	RC-2081	ROD CLEVIS
10	2	8020 6817	BEARING PAD
11	2	TK-01-30-580	LINEAR BEARING SET
12	2	1/2 X 1/2 SH	SHOULDER BOLT
13	2	5TA03K	5/16-18 LOCK HANDLE
14	2	ATF4-009-18-06	SPACER



5244 NW 163rd STREET
MIAMI, FLORIDA 33014
305-622-4070

EAGLE
Packaging Machinery, LLC.

PART NAME: **POSITIONER ASSEMBLY**
MACHINE MODEL: VASSOYO
DWG NO.: ATF4-009-18
REV: -
DRAWN BY: JFdez
DATE: 09/03/11
SHEET: 1 OF 1



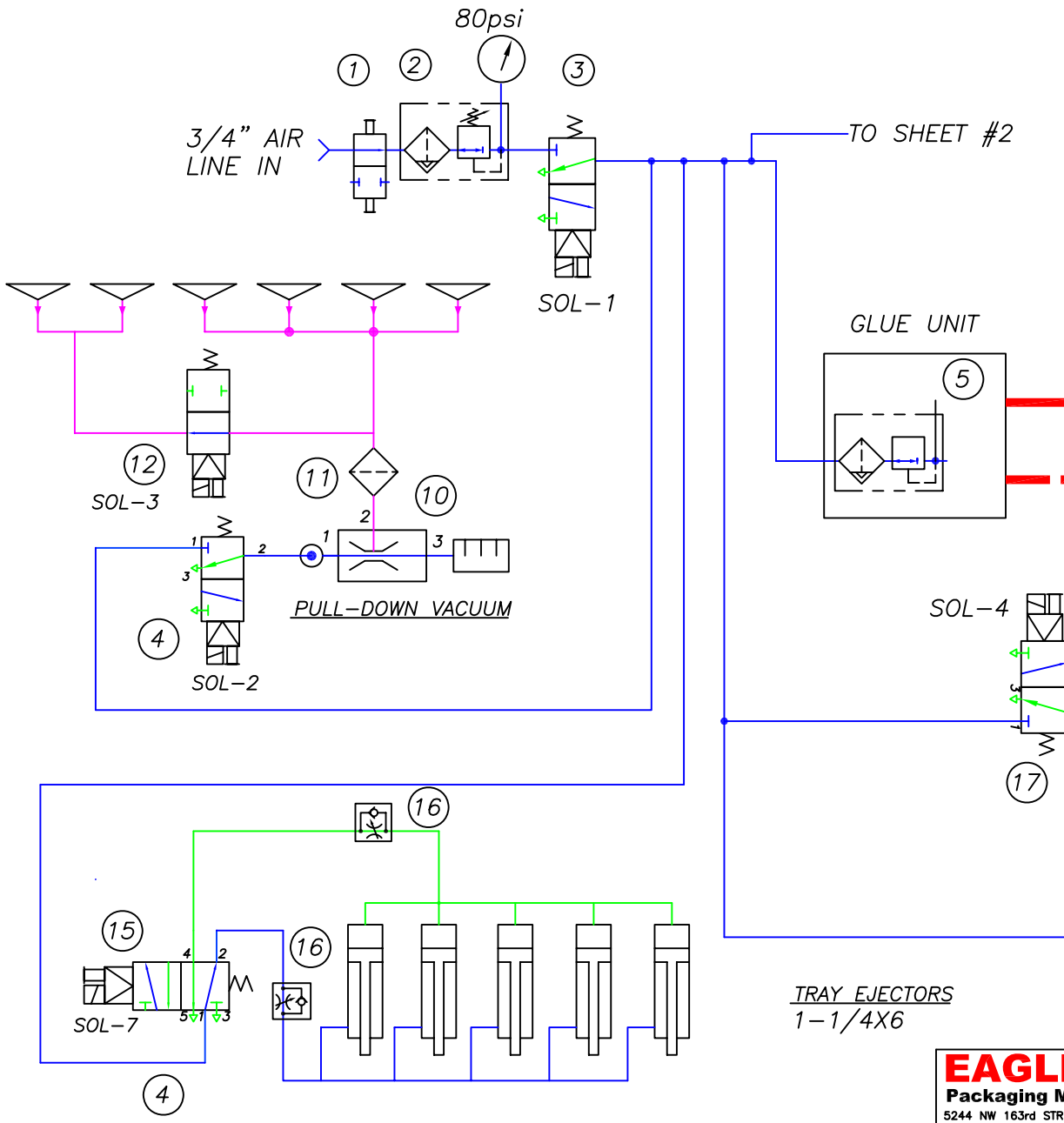
ASSEMBLY BILL OF MATERIALS

ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	ATF4-009-21-01	BASE
2	4	ATF4-009-11-02	WEAR PLATE SUPPORT ANGLE
3	2	ATF4-009-12-03	WEAR PLATE
4	2	ATF4-009-21-02	CYLINDER BASE
5	2	ATF4-009-11-03	EJECTOR DISC
6	2	ATF4-009-10-04	LATCH BASE
7	4	SDR-20-6-BM	AIR CYLINDER
8	4	FB-2491	CYLINDER FROM MOUNT ANGLE
9	4	3/8-24 JAM NUT	JAM NUT 3/8-24
10	2	TC-331005	LATCH

5244 NW 163rd STREET
MIAMI, FLORIDA 33014
305-622-4070

EAGLE
Packaging Machinery, LLC.

PART NAME	**MANDREL # 2-A**
MACHINE MODEL	VASSOYO
DWG NO.	ATF4-009-21
REV	-
DRAWN BY:	JFdez
DATE:	05/26/10
SHEET:	1 OF 1



ASSEMBLY BILL OF MATERIALS

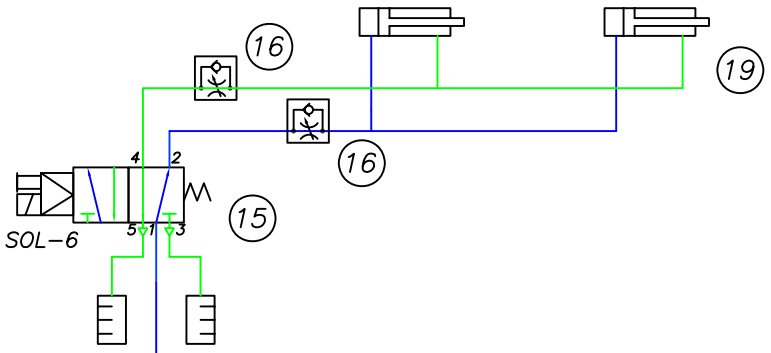
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	NVHS3500-N-03-X1	LOCK-OUT VALVE
2	1	NAW3000-N03G	FILTER REG WITH GAGE
3	1	NAV3000-N03-5G	SMOOTH START/DUMP
4	1	VQZ312-5YZ-02T	3-WAY 2-POS VALVE
5	1	1022234	ProBlue 10 GLUE UNIT
6	2	8517992	SUREBEAD GLUE GUN
7	1	274791	4' GLUE HOSE
8	1	274792	6' GLUE HOSE
9	2	274288	90 DEGREE FILTER GLUE
10	1	120L	VACUUM PUMP
11	1	FLTP 1/2 F	3/4 VAC FILTER
12	1	22N9DCBV-24BVDC	2 WAY N.C., DIRECT ACTING VALVE
13	2	NAS3/8X3/8UNFC	3/8T X 3/8 NPT FLOW CONTROL
14	4	NAS1/4X1/8UNFC	1/4T X 1/8 NPT FLOW CONTROL
15	4	SY7000-5W-2POS	5 WAY 2 POSITION VALVE BODY PORT
16	4	NAS3/8INLFC	3/8 INLINE FLOW CONTROL
17	2	1095801	SOLENOID VALVE

EAGLE
Packaging Machinery, LLC.
5244 NW 163rd STREET
MIAMI, FLORIDA 33014
305-622-4070

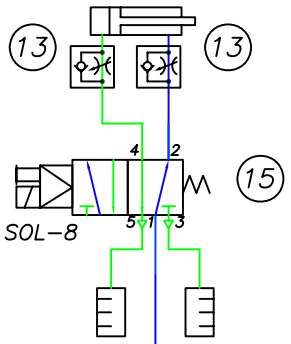
PART NAME: **PNEUMATIC SCHEMATIC**
MACHINE MODEL: VASSOYO
DWG NO.: ATF4-009-22
REV: -
DRAWN BY: MILONE
DATE: 05/08/10
SHEET: 1 OF 2

FROM SHEET #1

POSTIONER
1-1/16 X 10



INDEXER
1-1/2 X 4



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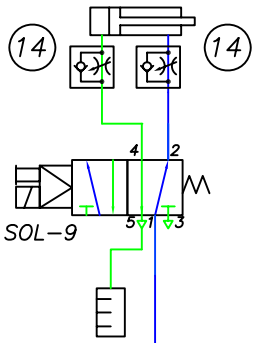
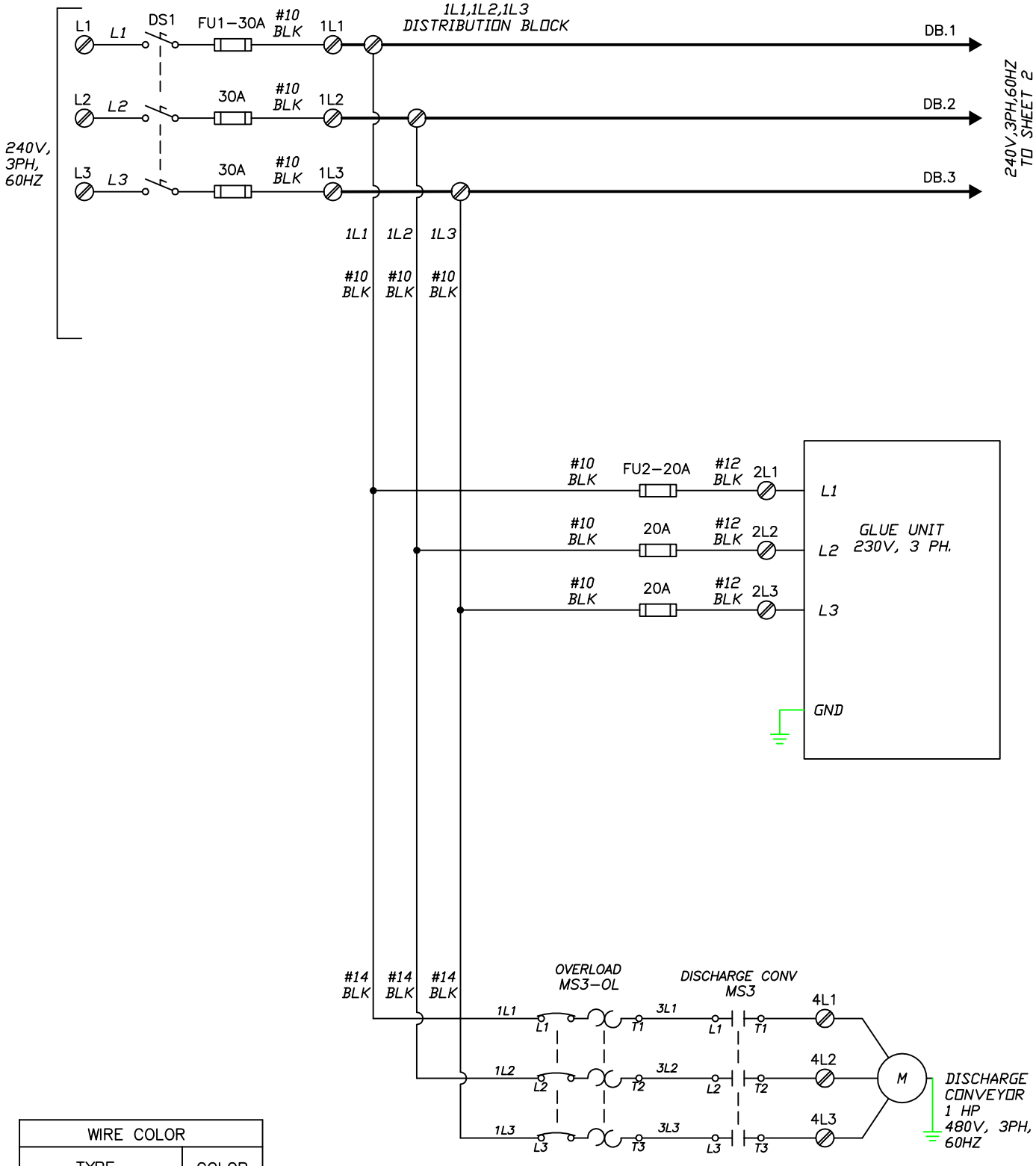


ASSEMBLY BILL OF MATERIALS

ITEM	QTY	PART NUMBER	DESCRIPTION

EAGLE
Packaging Machinery, LLC.
5244 NW 163rd STREET
MIAMI, FLORIDA 33014
305-622-4070

PART NAME	**PNEUMATIC SCHEMATIC**
MACHINE MODEL	VASSOYO
DWG NO.	ATF4-009-22
REV	-
DRAWN BY:	MILONE
DATE:	05/08/10
SHEET:	2 OF 2



WIRE COLOR	
TYPE	COLOR
24VDC+	BLUE
0VDC	BL/WH
24VDC SIGNAL	BLUE
230VAC	BLACK
GROUND	GREEN

S/N 11161

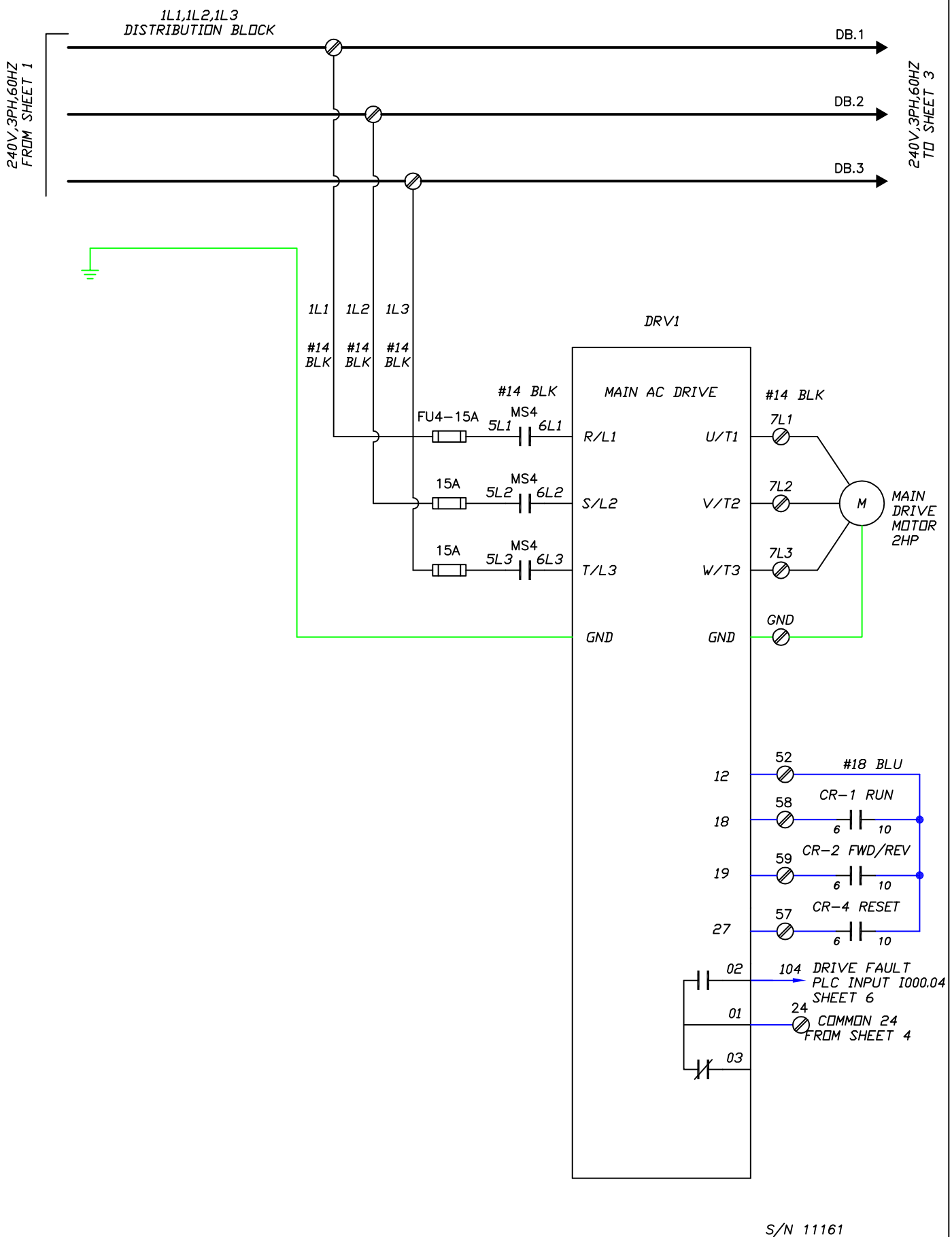
08/22/11

PRIMARY VOLTAGE:	CONTROL VOLTAGE:
240 VAC	24 VDC
SECONDARY VOLTAGE:	
N/A	

EAGLE
Packaging Machinery, LLC
4760 NW 128 Street
Miami, Florida, 33054
Phone: (305) 622–4070

ELECTRICAL SCHEMATIC
OMRON CP1L/MT6070iH

DRAWN BY:	DWG NO.	REV
J Damas	ATF4–009–18	
DATE: 08/19/11	SCALE: NONE	SHEET 1 OF 19



S/N 11161

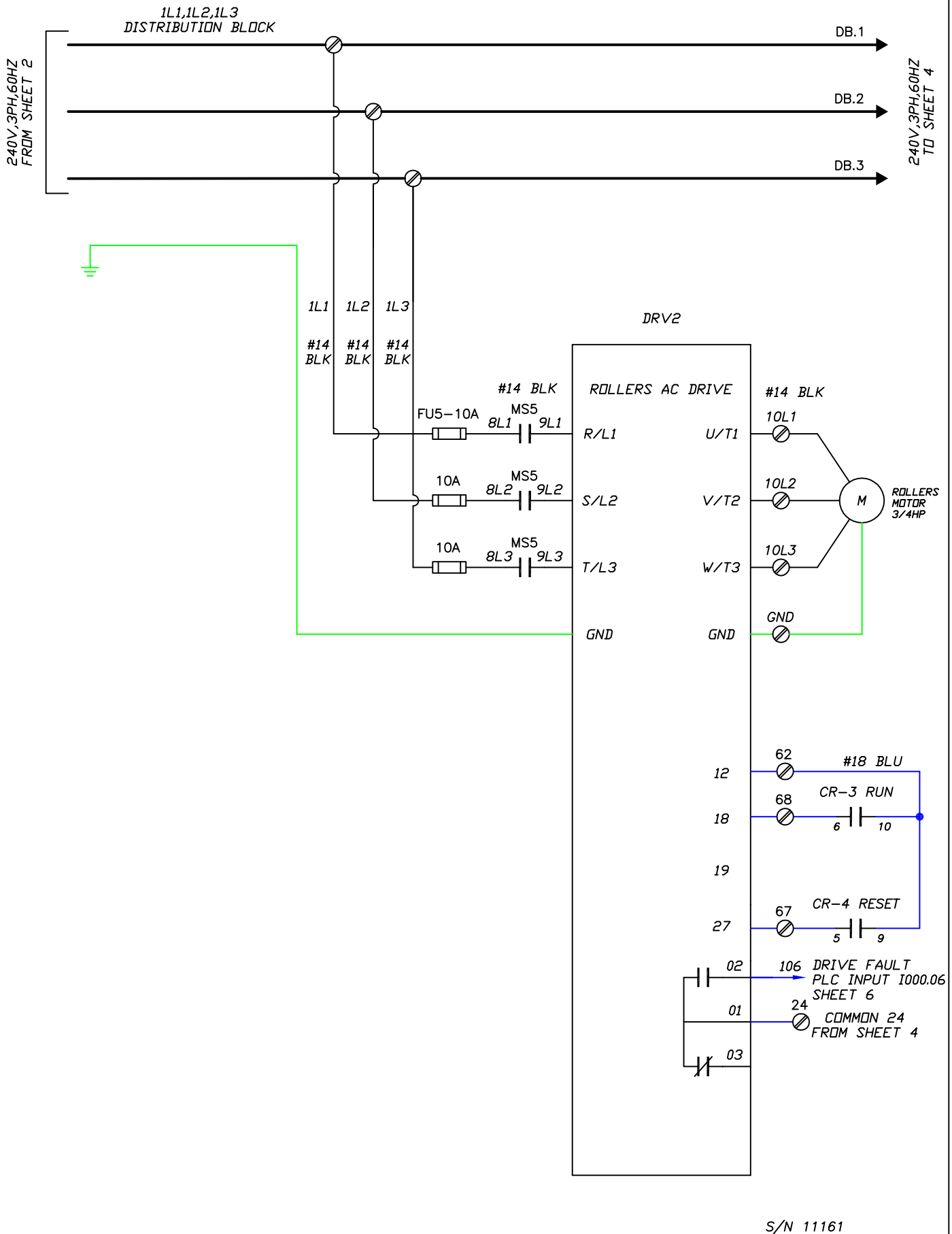
08/22/11

PRIMARY VOLTAGE:	CONTROL VOLTAGE:
240 VAC	24 VDC
SECONDARY VOLTAGE:	
N/A	

EAGLE
Packaging Machinery, LLC
4760 NW 128 Street
Miami, Florida, 33054
Phone: (305) 622-4070

ELECTRICAL SCHEMATIC
OMRON CP1L/MT6070iH

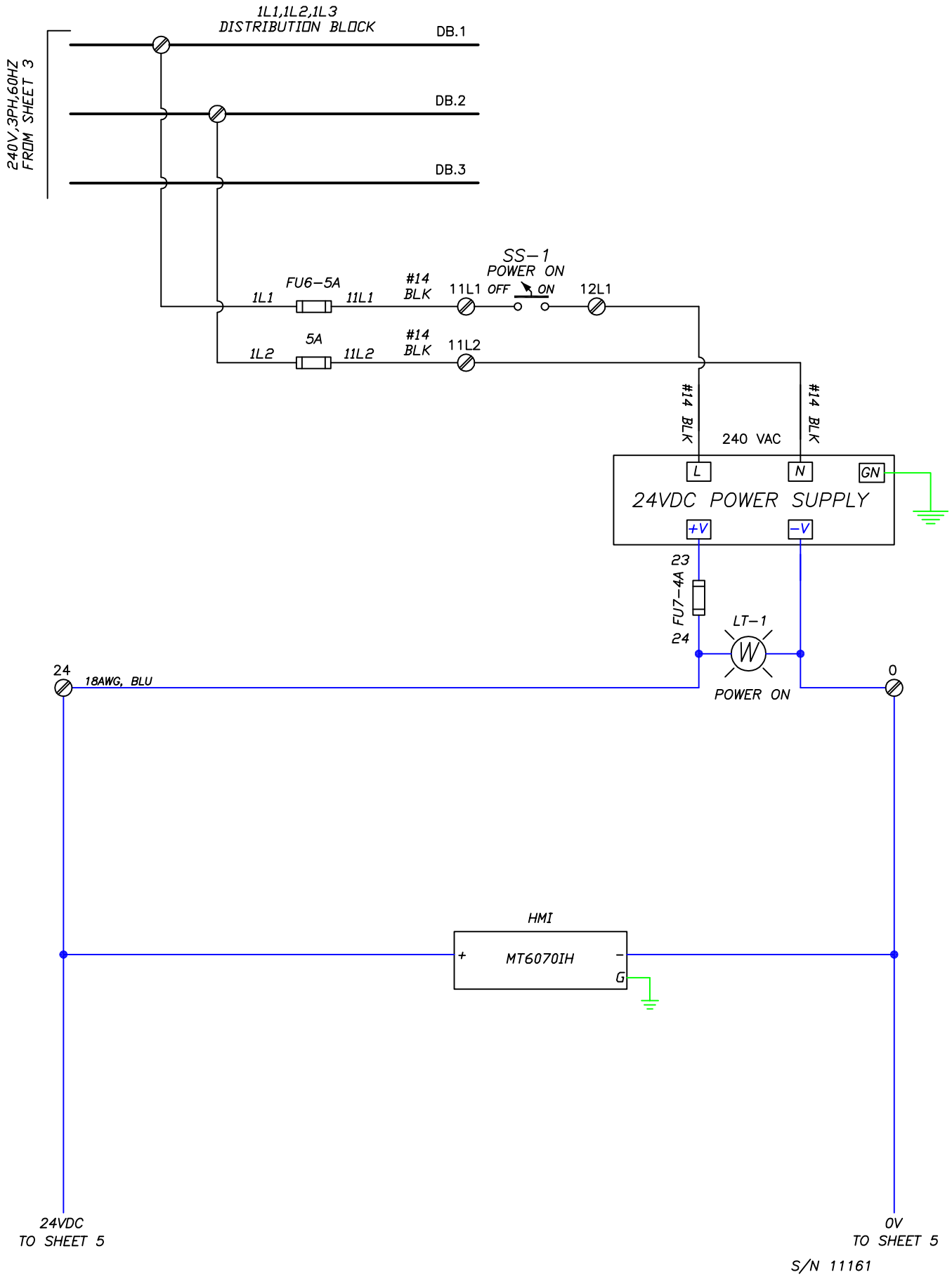
DRAWN BY:	DWG NO.	REV
J Damas	ATF4-009-18	
DATE: 08/19/11	SCALE: NONE	SHEET 2 OF 19



S/N 11161

08/22/11

PRIMARY VOLTAGE:	CONTROL VOLTAGE:			
240 VAC	24 VDC	**EAGLE** Packaging Machinery, LLC	**ELECTRICAL SCHEMATIC**	
SECONDARY VOLTAGE:		4760 NW 128 Street Miami, Florida, 33054 Phone: (305) 622-4070	OMRON CP1L/MT6070iH	
N/A			DRAWN BY: J Damas	DWG NO. ATF4-009-18 REV
			DATE: 08/19/11	SCALE NONE SHEET 3 OF 19



S/N 11161

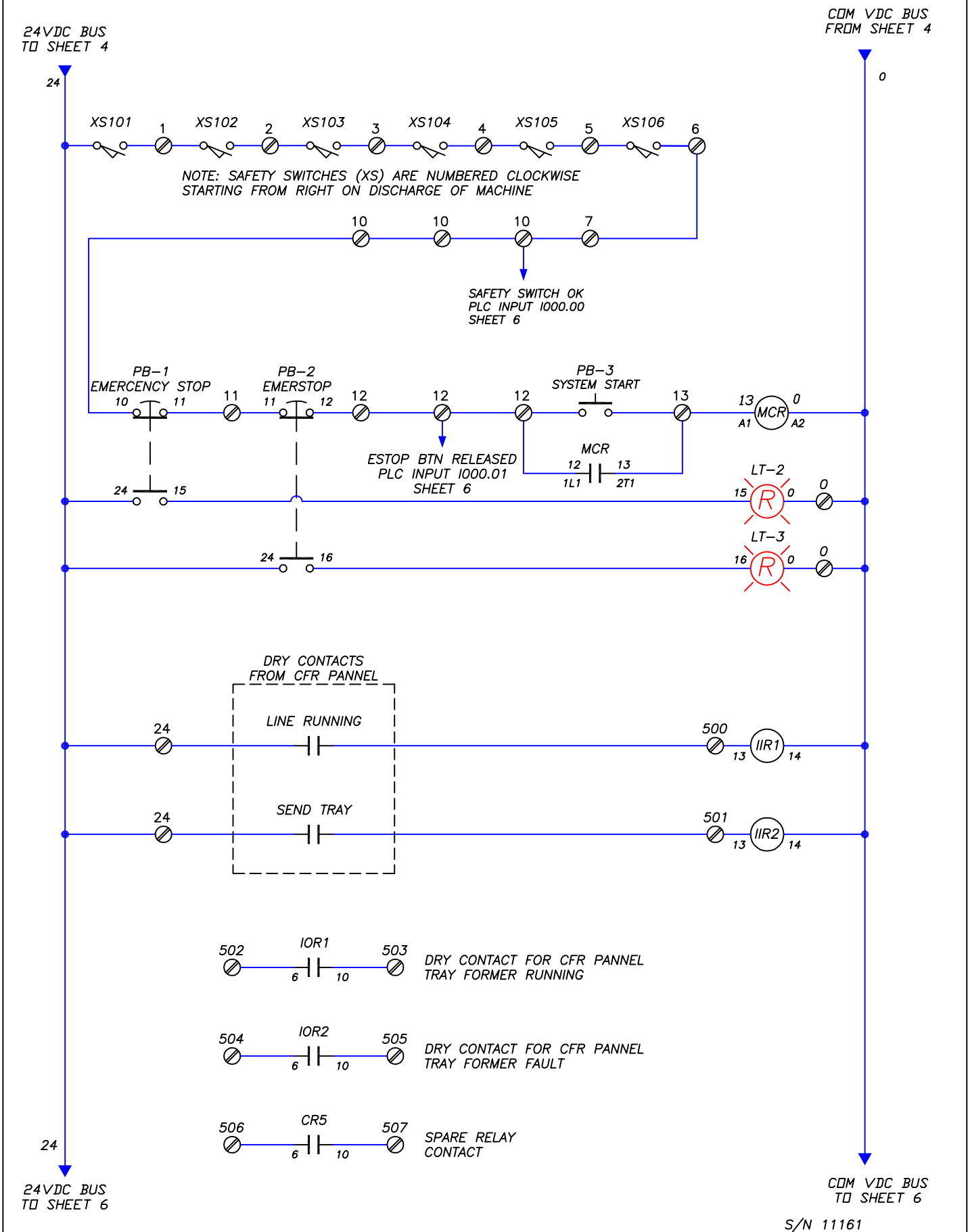
08/22/11

PRIMARY VOLTAGE:	CONTROL VOLTAGE:
240 VAC	24 VDC
SECONDARY VOLTAGE:	
N/A	

EAGLE
Packaging Machinery, LLC
4760 NW 128 Street
Miami, Florida, 33054
Phone: (305) 622-4070

ELECTRICAL SCHEMATIC
OMRON CP1L/MT6070iH

DRAWN BY:	DWG NO.	REV
J Damas	ATF4-009-18	
DATE: 08/19/11	SCALE: NONE	SHEET 4 OF 19



S/N 11161

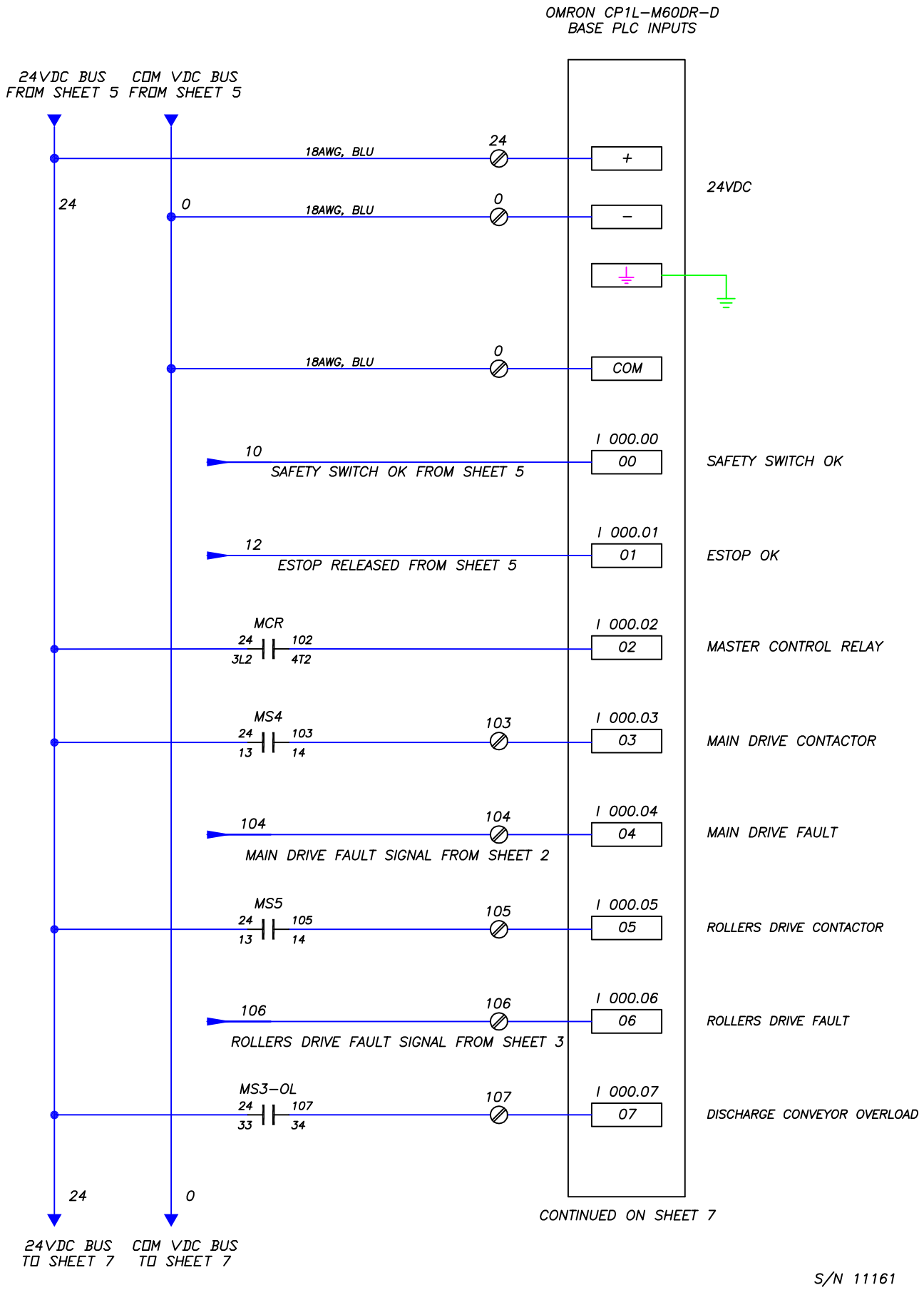
08/22/11

PRIMARY VOLTAGE:	CONTROL VOLTAGE:
240 VAC	24 VDC
SECONDARY VOLTAGE:	
N/A	

EAGLE
Packaging Machinery, LLC
4760 NW 128 Street
Miami, Florida, 33054
Phone: (305) 622-4070

ELECTRICAL SCHEMATIC
OMRON CP1L/MT6070iH

DRAWN BY:	DWG NO.	REV
J Damas	ATF4-009-18	
DATE: 08/19/11	SCALE: NONE	SHEET: 5 OF 19



S/N 11161

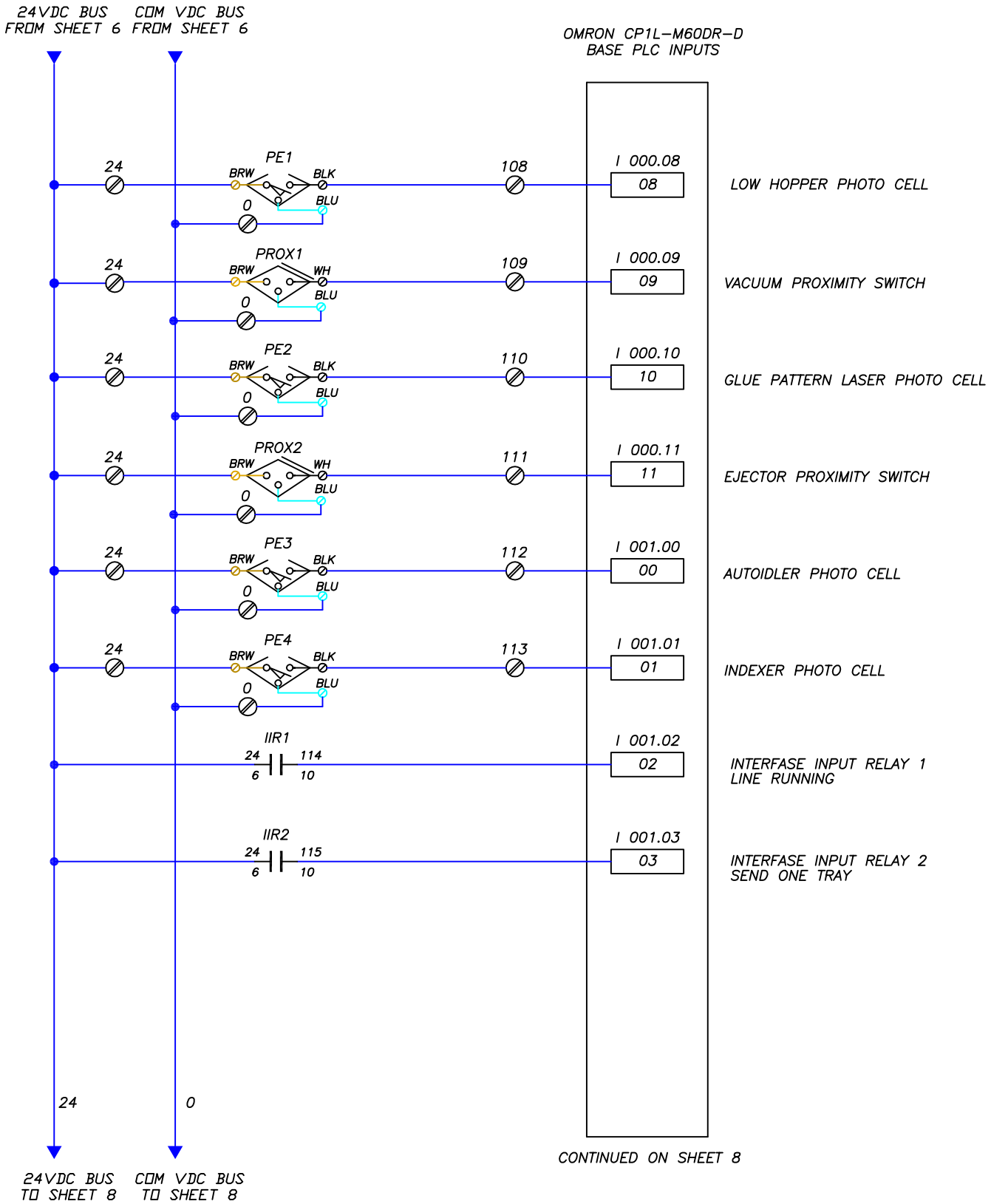
08/22/11

PRIMARY VOLTAGE:	CONTROL VOLTAGE:
240 VAC	24 VDC
SECONDARY VOLTAGE:	
N/A	

EAGLE
Packaging Machinery, LLC
4760 NW 128 Street
Miami, Florida, 33054
Phone: (305) 622-4070

ELECTRICAL SCHEMATIC
OMRON CP1L/MT6070iH

DRAWN BY:	DWG NO.	REV
J Damas	ATF4-009-18	
DATE: 08/19/11	SCALE: NONE	SHEET 6 OF 19



S/N 11161

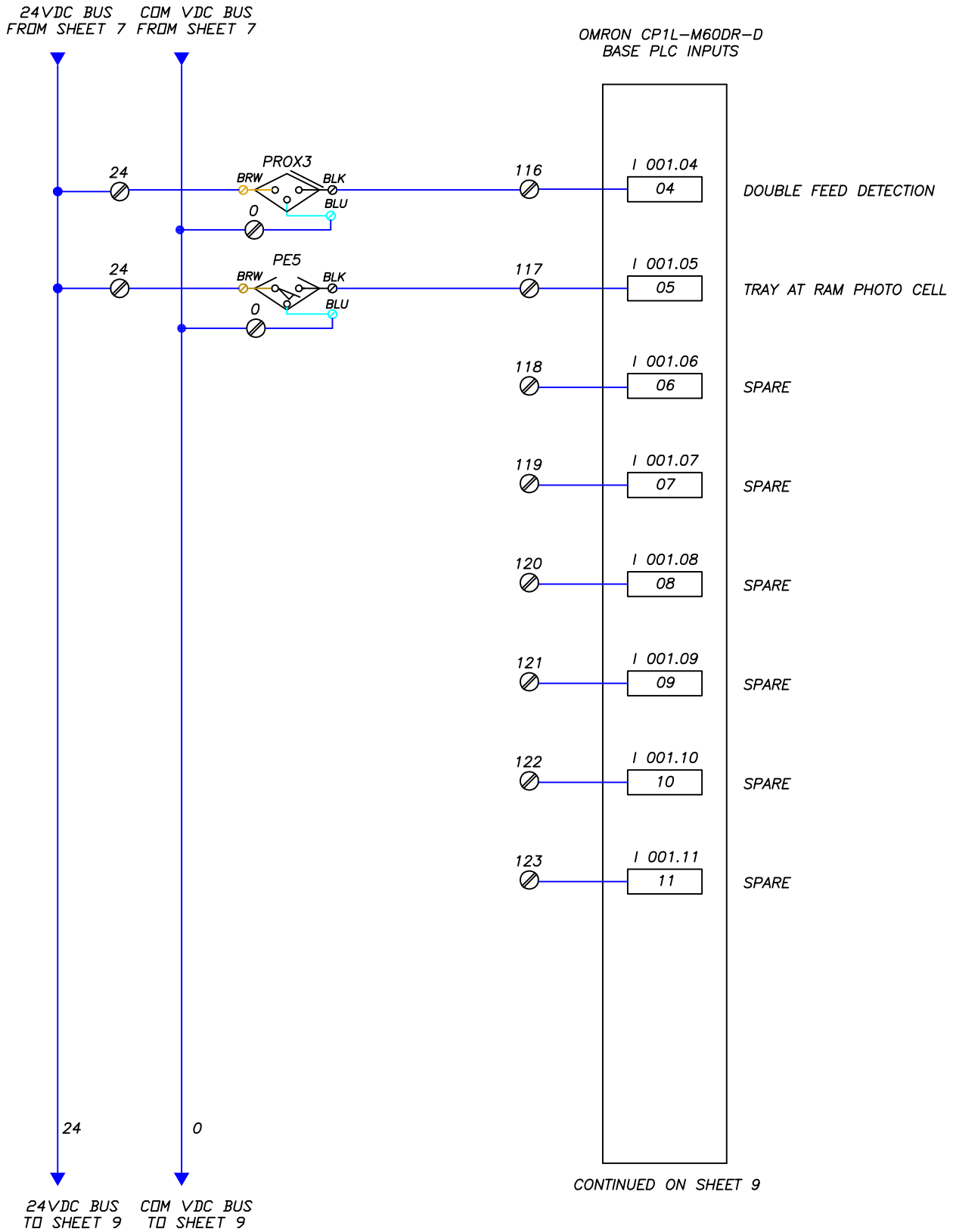
08/22/11

PRIMARY VOLTAGE:	CONTROL VOLTAGE:
240 VAC	24 VDC
SECONDARY VOLTAGE:	
N/A	

EAGLE
Packaging Machinery, LLC
4760 NW 128 Street
Miami, Florida, 33054
Phone: (305) 622-4070

ELECTRICAL SCHEMATIC
OMRON CP1L/MT6070iH

DRAWN BY:	DWG NO.	REV
J Damas	ATF4-009-18	
DATE: 08/19/11	SCALE: NONE	SHEET: 7 OF 19



S/N 11161

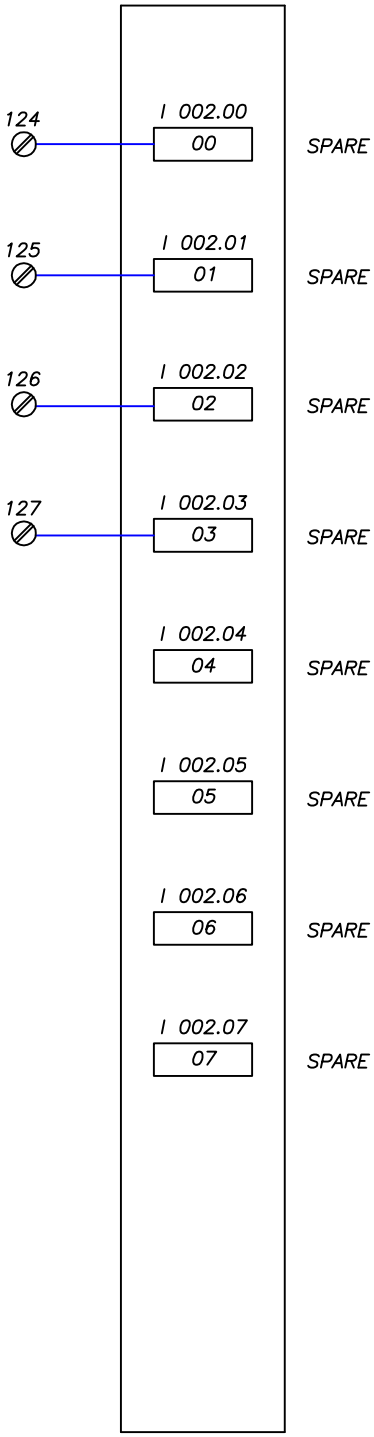
08/22/11

PRIMARY VOLTAGE:	CONTROL VOLTAGE:	EAGLE	ELECTRICAL SCHEMATIC	
240 VAC	24 VDC	Packaging Machinery, LLC	OMRON CP1L/MT6070iH	
SECONDARY VOLTAGE:		4760 NW 128 Street	DRAWN BY: J Damas	DWG NO. ATF4-009-18 REV
N/A		Miami, Florida, 33054	DATE: 08/19/11	SCALE NONE SHEET 8 OF 19
		Phone: (305) 622-4070		

24VDC BUS FROM SHEET 8

COM VDC BUS FROM SHEET 8

OMRON CP1L-M60DR-D
BASE PLC INPUTS



24

0

CONTINUED ON SHEET 10

24VDC BUS TO SHEET 10

COM VDC BUS TO SHEET 10

S/N 11161

08/22/11

PRIMARY VOLTAGE:	CONTROL VOLTAGE:	EAGLE	ELECTRICAL SCHEMATIC	
240 VAC	24 VDC	Packaging Machinery, LLC	OMRON CP1L/MT6070iH	
SECONDARY VOLTAGE:		4760 NW 128 Street Miami, Florida, 33054 Phone: (305) 622-4070	DRAWN BY: J Damas	DWG NO. ATF4-009-18 REV
N/A			DATE: 08/19/11	SCALE NONE SHEET 9 OF 19

24VDC BUS FROM SHEET 9

COM VDC BUS FROM SHEET 9

OMRON CP1L-M60DR-D
BASE PLC INPUTS

I 002.08	08	SPARE
I 002.09	09	SPARE
I 002.10	10	SPARE
I 002.11	11	SPARE

24

0

24VDC BUS TO SHEET 11

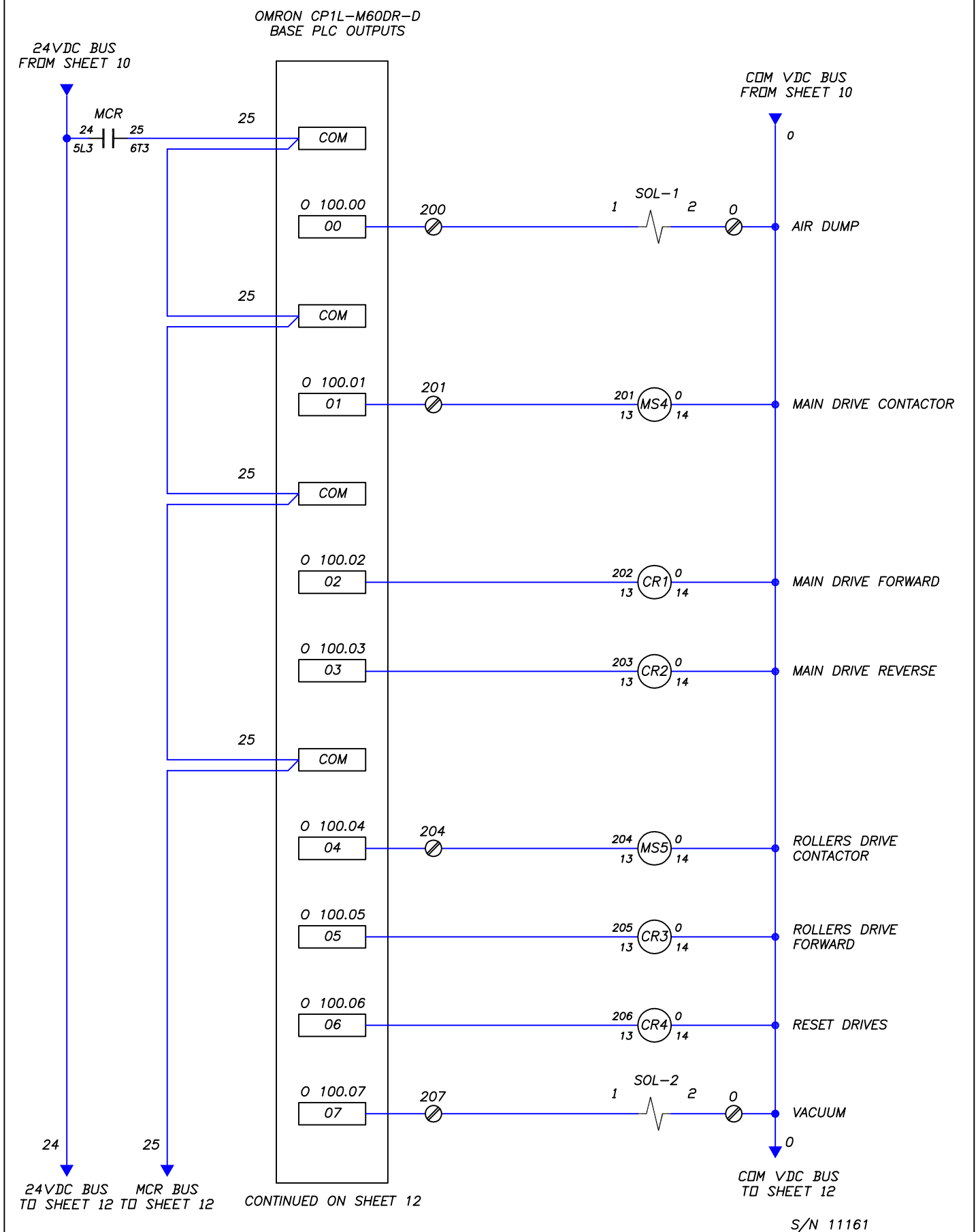
COM VDC BUS TO SHEET 11

CONTINUED ON SHEET 11

S/N 11161

08/22/11

PRIMARY VOLTAGE: 240 VAC	CONTROL VOLTAGE: 24 VDC	EAGLE Packaging Machinery, LLC	ELECTRICAL SCHEMATIC		
SECONDARY VOLTAGE: N/A		4760 NW 128 Street Miami, Florida, 33054 Phone: (305) 622-4070	OMRON CP1L/MT6070iH		
			DRAWN BY: J Damas	DWG NO. ATF4-009-18	REV
			DATE: 08/19/11	SCALE NONE	SHEET 10 OF 19



S/N 11161

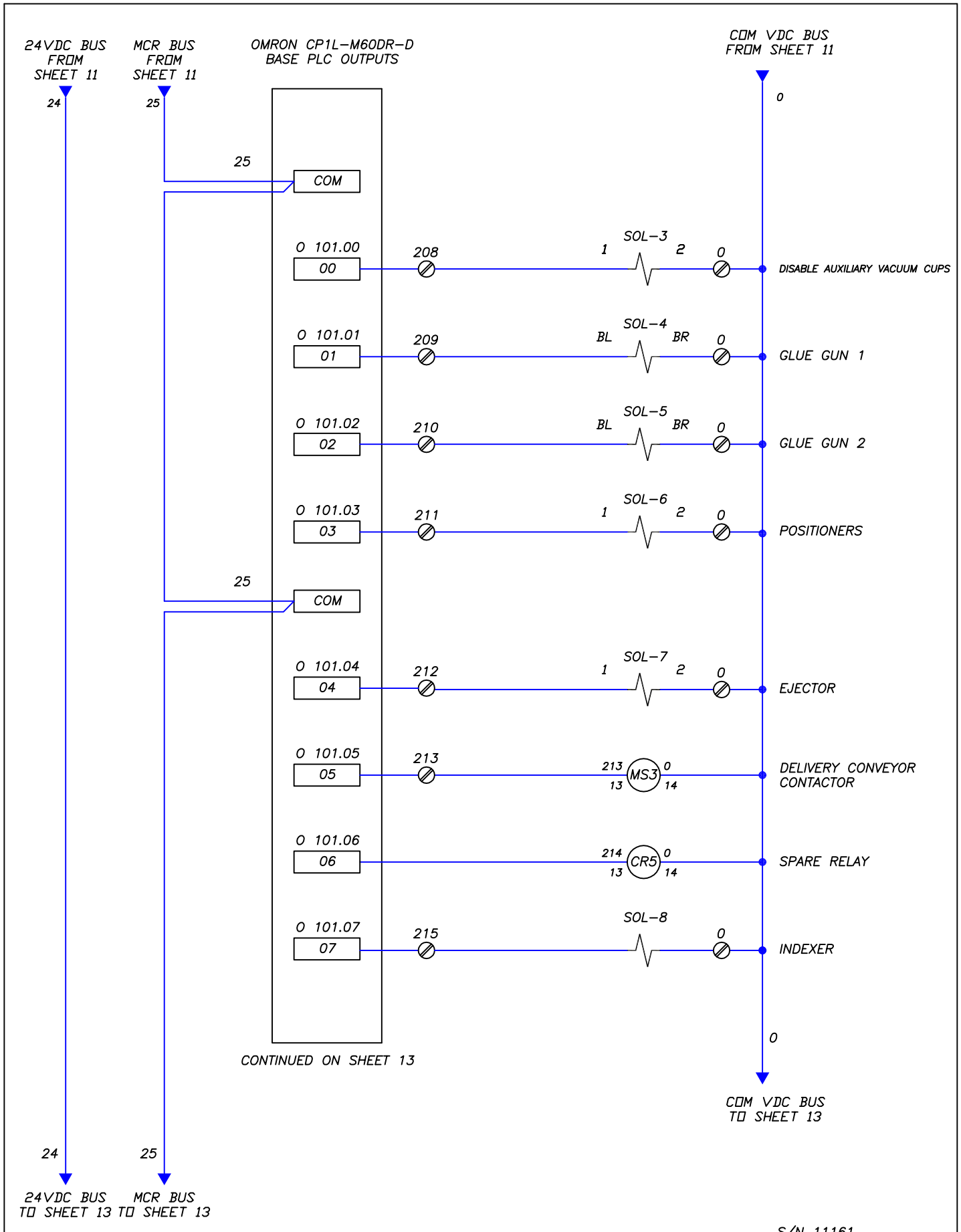
08/22/11

PRIMARY VOLTAGE:	CONTROL VOLTAGE:
240 VAC	24 VDC
SECONDARY VOLTAGE:	
N/A	

EAGLE
Packaging Machinery, LLC
4760 NW 128 Street
Miami, Florida, 33054
Phone: (305) 622-4070

ELECTRICAL SCHEMATIC
OMRON CP1L/MT6070iH

DRAWN BY:	DWG NO.	REV
J Damas	ATF4-009-18	
DATE: 08/19/11	SCALE: NONE	SHEET 11 OF 19



S/N 11161

08/22/11

PRIMARY VOLTAGE:	CONTROL VOLTAGE:
240 VAC	24 VDC
SECONDARY VOLTAGE:	
N/A	

EAGLE
Packaging Machinery, LLC
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Miami, Florida, 33054
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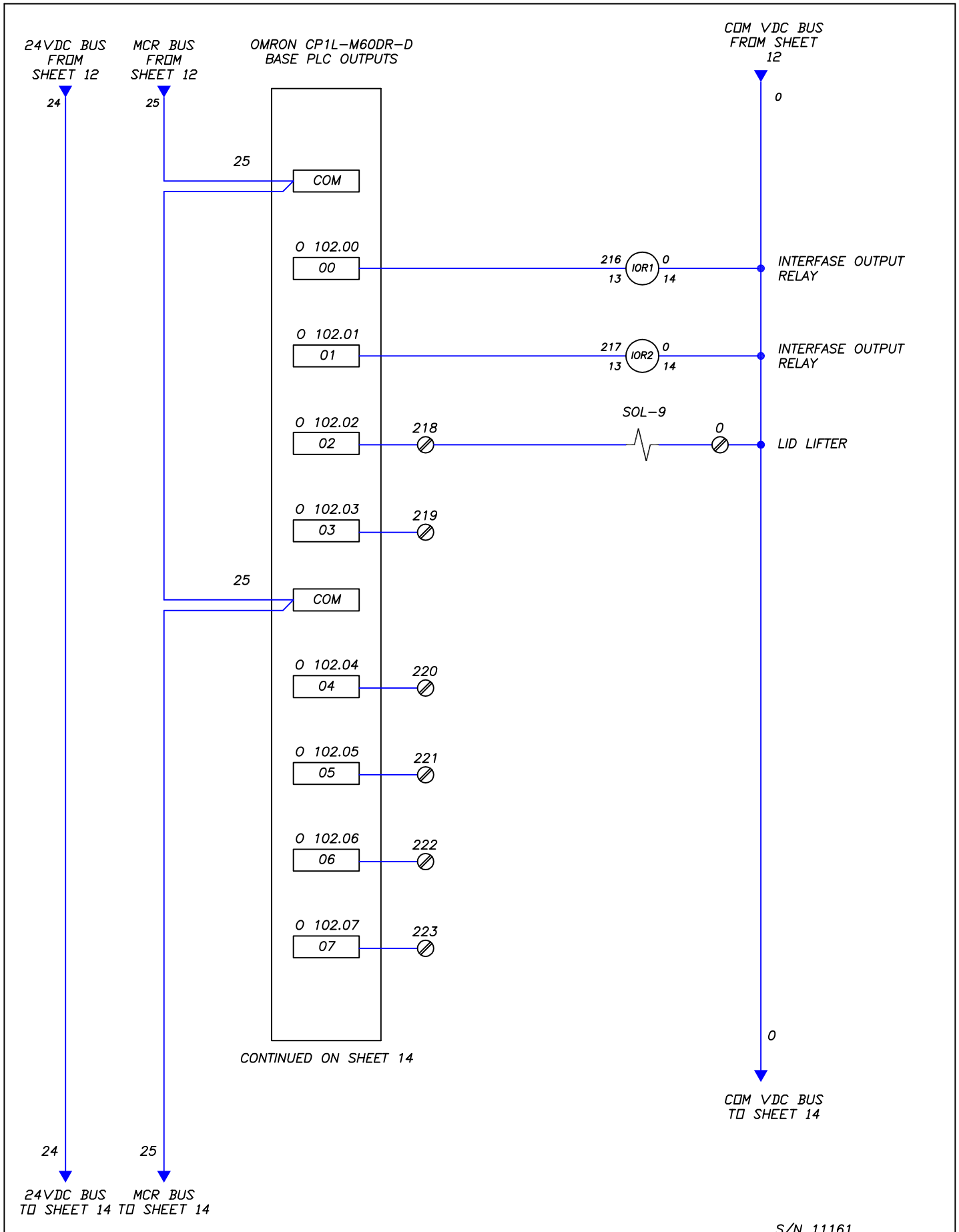
ELECTRICAL SCHEMATIC
OMRON CP1L/MT6070iH

DRAWN BY:	DWG NO.	REV
J Damas	ATF4-009-18	
DATE: 08/19/11	SCALE: NONE	SHEET 12 OF 19



S/N 11161

08/22/11

PRIMARY VOLTAGE:	CONTROL VOLTAGE:
240 VAC	24 VDC
SECONDARY VOLTAGE:	
N/A	

EAGLE
Packaging Machinery, LLC
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Miami, Florida, 33054
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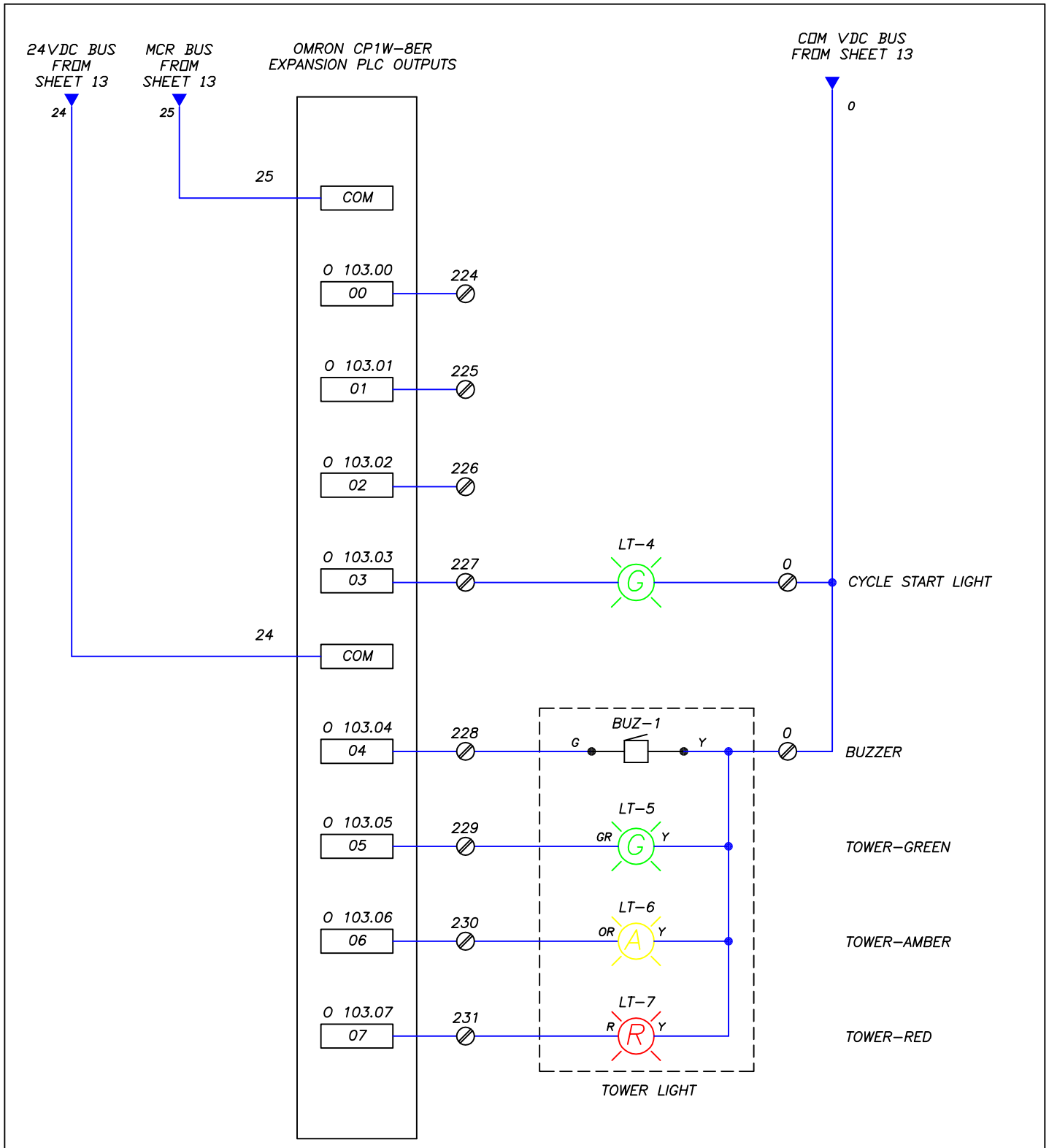
ELECTRICAL SCHEMATIC
OMRON CP1L/MT6070iH

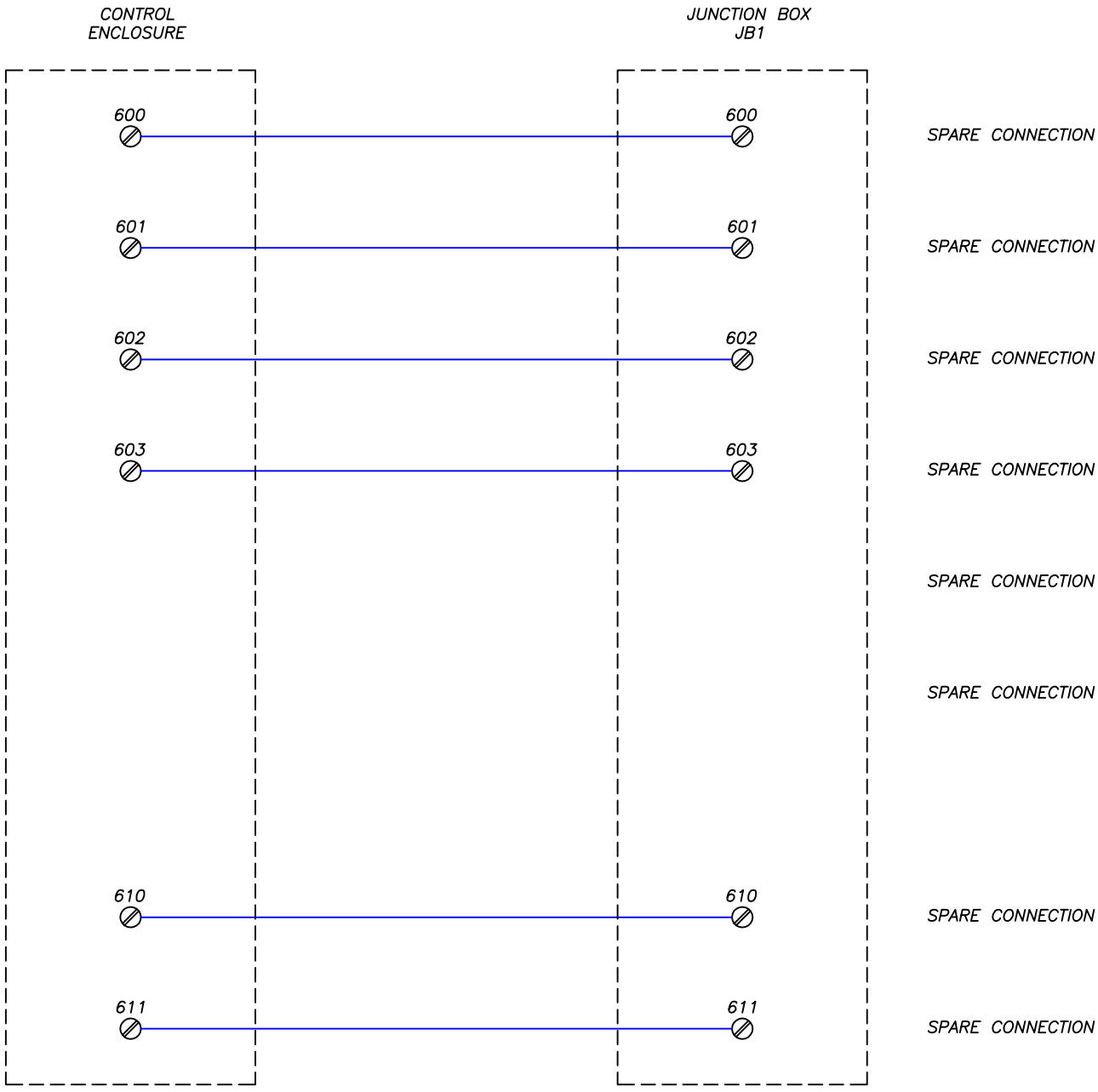
DRAWN BY:	DWG NO.	REV
J Damas	ATF4-009-18	
DATE: 08/19/11	SCALE NONE	SHEET 13 OF 19



S/N 11161

08/22/11

PRIMARY VOLTAGE: 240 VAC	CONTROL VOLTAGE: 24 VDC	EAGLE Packaging Machinery, LLC	ELECTRICAL SCHEMATIC
SECONDARY VOLTAGE: N/A		4760 NW 128 Street Miami, Florida, 33054 Phone: (305) 622-4070	OMRON CP1L/MT6070iH
			DRAWN BY: J Damas · DWG NO. ATF4-009-18 · REV
			DATE: 08/19/11 · SCALE NONE · SHEET 14 OF 19



S/N 11161

08/22/11

PRIMARY VOLTAGE:	CONTROL VOLTAGE:
240 VAC	24 VDC
SECONDARY VOLTAGE:	
N/A	

EAGLE
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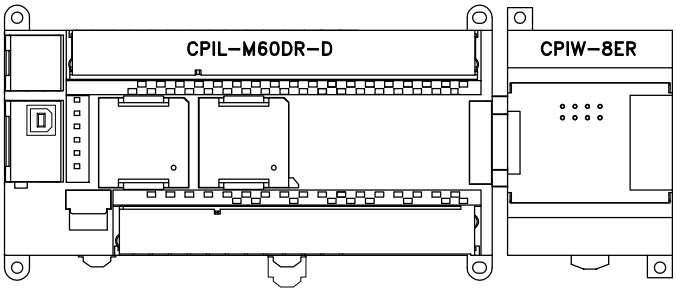
ELECTRICAL SCHEMATIC
OMRON CP1L/MT6070iH

DRAWN BY:	DWG NO.	REV
J Damas	ATF4-009-18	
DATE: 08/19/11	SCALE NONE	SHEET 15 OF 19

COM1/RS232		
POINT	SIGNAL	CABLE COLOR
3	TX	BR
2	RX	BK
5	GND	RD

HMI
MT6070iH

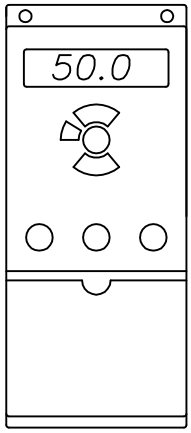
COMMCP1L6070 CABLE



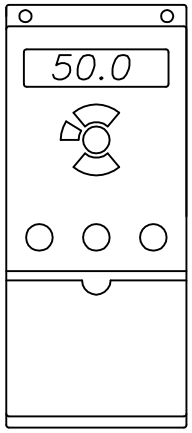
SERIAL PORT 1/RS232		
POINT	SIGNAL	CABLE COLOR
3	RD	BR
2	SD	BK
9	GND	RD

CP1W-CIF12 DIP SWITCHES		
PIN	DESCRIPTION	POSITION
1	TERMINATION RESISTANCE	ON
2	2 WIRE TYPE	ON
3	2 WIRE TYPE	ON
4	NOT USED	OFF
5	NO RS CONTROL FOR FD	OFF
6	WITH RS CONTROL FOR SD	ON

COM1/RS485		
POINT	SIGNAL	CABLE COLOR
1	RDA −	N/C
2	RDB +	N/C
3	SDA −	BK
4	SDB +	RD
5	FG	GR



DRV1



DRV2

BELDEN STRANDED CABLE

MODBUS ADDRESS 1		
POINT	SIGNAL	CABLE COLOR
69	N (RS485)	BK
68	P (RS485)	RD
61	FG	GR

MODBUS ADDRESS 2		
POINT	SIGNAL	CABLE COLOR
69	N (RS485)	BK
68	P (RS485)	RD
61	FG	GR

S/N 11161

08/22/11

PRIMARY VOLTAGE:	CONTROL VOLTAGE:
240 VAC	24 VDC
SECONDARY VOLTAGE:	
N/A	

EAGLE
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Miami, Florida, 33054
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ELECTRICAL SCHEMATIC
OMRON CP1L/MT6070iH

DRAWN BY:	DWG NO.	REV
J Damas	ATF4-009-18	
DATE: 08/19/11	SCALE NONE	SHEET 16 OF 19

ASSEMBLY BILL OF MATERIALS

ITEM	QTY	PART NUMBER	DESCRIPTION
ENCLOSURE	1	ENCRT30X30X8	MAIN ENCLOSURE
ENCLOSURE	1	ENCRT24X24X8	MAIN ENCLOSURE
DS1	1	SWL10-NJ030P3	FUSED DISCONECTED SWITCH
DS1	1	SWL10-R1	METAL OPERATING SHAFT
DS1	1	SWL10-HS4E	SWITCH HANDLE
FU1	3	ADJDL-30	FUSE 30 A
DB	1	MN1443400	POWER DISTRIBUTION BLOCK
DB	1	CC1413	POWER DISTRIBUTION BLOCK COVER
FU2, FU4, FU5	3	AA-FUSEHOLDERCC3P	FUSE HOLDER W/IND, 30A, 3P, 600V
FU2	3	AD 20ACC	TIME DELAY FUSE, 20A, 600 VAC
FU4	3	AD-15AFASTCC	FAST ACTING FUSE, 15A, 600 VAC
FU5	3	AD-10AFASTCC	FAST ACTING FUSE, 10A, 600 VAC
MS3 TO MS5; MCR	4	C3-300-S09N30ZC10	CONTACTOR
MS3-OL	1	1.6 TO 2.5 MOTOR PROTECTOR	MOTOR PROTECTOR 1.6 TO 2.5 A.
DRV1	1	132F0012	AC DRIVE 2HP, 240V, 3-PH, MICRO DRIVES
DRV2	1	132F0010	AC DRIVE 1HP, 240V, 3-PH, MICRO DRIVES
DRV1, DRV2	2	132B0101	132B0101 DANFOSS LPC CONTROL PANEL
CR1-5, IIR1-2, IOR1-2	9	14PINBASE	SOCKET 14 PIN
CR1-5, IIR1-2, IOR1-2	9	24VDC14PIN	24VDC, 5A RELAY
FU6	1	AD-FUSEHOLDERCC2P	FUSE HOLDER 2P, CLASS CC FUSES, 600 VDC, 30 A
FU6	2	AD 5ACC	2AMP TIME DELAY FUSE, 600 VDC, CC TYPE
FU7	1	AD-FUSEHOLDERCC1P	FUSE HOLDER W/IND, CLASS CC FUSES, 600 VDC, 30 A
FU7	1	AD 4ACC	4AMP TIME DELAY FUSE, 600 VDC, CC TYPE
PS	1	PG-DR120-24	POWER SUPPLY
SS-1	1	TM-SELSWIL	SELECTOR SWITCH WHITE- 2 POS, ILLUMINATED
PB-1, PB-2	2	TM-ESTOP	MUSHROOM BUTTON, RED - 40MM, ILLUMINATED
PB-3	1	TM-GREENPB	PUSH BUTTON, GREEN, MOMENTARY, ILLUMINATED

CONTINUED ON PAGE 18

S/N 11161

08/22/11

PRIMARY VOLTAGE:	CONTROL VOLTAGE:
240 VAC	24 VDC
SECONDARY VOLTAGE:	
N/A	

EAGLE
Packaging Machinery, LLC
4760 NW 128 Street
Miami, Florida, 33054
Phone: (305) 622-4070

ELECTRICAL SCHEMATIC
OMRON CP1L/MT6070iH

DRAWN BY:	DWG NO.	REV
J Damas	ATF4-009-18	
DATE: 08/19/11	SCALE NONE	SHEET 17 OF 19

ASSEMBLY BILL OF MATERIALS

ITEM	QTY	PART NUMBER	DESCRIPTION
SS-1, PB-1 THRU PB-3	4	TM-BLKCOLLAR	ELECTRICAL COMPONENT MOUNTING COLLAR
SS-1, PB-1 THRU PB-3	4	TM-BLKNO	CONTACT BLOCK, 1 NO, SCREW CLAMP
PB-1, PB-2	2	TM-BLKNC	CONTACT BLOCK, 1 NC, SCREW CLAMP
LT-1 THRU LT-4	4	TM-BLKLT	LIGHT MODULE, WHITE, PROTECTED LED 24V
SS-1	1	TM-TXTONOFF	LEGEND PLATE ON OFF
PB1, PB2	2	TM-ESTOPLP	LEGEND PLATE E-STOP ROUND
PB3	1	TM-RESET LP	LEGEND PLATE CYCLE START ENGRAVED
XS101 THRU XS106	6	SSSE115-12'	SAFETY SWITCH
HMI	1	MT6070IH	TOUCH SCREEN 7" COLOR TFT
HMI	1	COMMCP1L6070	OMRON CP1L - MT6070IH COMMUNICATION CABLE
PLC	1	CP1L-M60DR-D	OMRON PLC 60 I/O 24VDC POWER SUPPLY, RELAY OUTPUTS
PLC	1	CP1WCIF01	OMRON CP1L RS232C SERIAL MODULE
PLC	1	CP1WCIF12	OMRON CP1L RS485 SERIAL MODULE
PLC	1	CP1W-8ER	EXPANSION MODULE USED WITH CP1L, 8 RELAY OUTPUTS
PROX1, PROX 2	2	DW-AS-624-M18-002	PROXIMITY SWITCH
PROX 3	1	C3PROXPNPNO	PROXIMITY SWITCH
PE1, PE3 THRU PE5	4	QS18VP6DQ5	PHOTOCELL
PE1, PE3 THRU PE5	4	MTGBKTXQS18	PHOTOCELL MOUNTING BRACKET
PE2	1	PHQS18VP6LAFQ5	LASER PHOTOCELL
PE2	1	MTGBKTLASERPE	LASER PHOTOCELL MOUNTING BRACKET
PE1-4; PROX1-2	6	AD-5MEUROST	M12 Q/D CABLE, STRAIGHT FEMALE, DC PVC, 4PIN/4WIRE
TOWER LIGHT	1	PATL50MTGPOLE	POLE MOUNTING BRACKET
TOWER LIGHT	1	PATLT50BASE	TOWER LIGHT BASE AND SOUND MODULE
TOWER LIGHT	1	PATLT50AMBAR	TOWER LIGHT AMBAR MODULE
TOWER LIGHT	1	PATLT50RED	TOWER LIGHT RED MODULE
TOWER LIGHT	1	PATLT50GREEN	TOWER LIGHT GREEN MODULE
TERMINAL BLOCK	19	TB 249-16	END STOP FOR DIN 35 RAIL

CONTINUED ON PAGE 19

S/N 11161

08/22/11

PRIMARY VOLTAGE:	CONTROL VOLTAGE:
240 VAC	24 VDC
SECONDARY VOLTAGE:	
N/A	

EAGLE
Packaging Machinery, LLC
4760 NW 128 Street
Miami, Florida, 33054
Phone: (305) 622-4070

ELECTRICAL SCHEMATIC
OMRON CP1L/MT6070iH

DRAWN BY:	DWG NO.	REV
J Damas	ATF4-009-18	
DATE: 08/19/11	SCALE NONE	SHEET 18 OF 19

ASSEMBLY BILL OF MATERIALS

ITEM	QTY	PART NUMBER	DESCRIPTION
TERMINAL BLOCK	13	TB264-368	END AND INTERMEDIATE PLATE
TERMINAL BLOCK	110	TB 280-101	TERMINAL BLOCK AWG 28-14
TERMINAL BLOCK	6	TB 282-101	TERMINAL BLOCK AWG 28-12
TERMINAL BLOCK	20	TB 280-402	ADJACENT JUMPER INSULATED
TERMINAL BLOCK	9	TB 280-107	CONDUCTOR GROND (EARTH)
TERMINAL BLOCK	2	TB 282-107	CONDUCTOR GROND (EARTH)
WIRE DUCT	4	ADT1E1522W	WIRE DUCT W/COVER X 24-5/8IN. LONG
WIRE DUCT	2	ADT1E1522W	WIRE DUCT W/COVER X 26-3/4IN. LONG
DIM 35 RAIL	1	AAE-DIM-RAL-2M	DIM 35 RAIL X 12-1/4IN. LONG
DIM 35 RAIL	1	AAE-DIM-RAL-2M	DIM 35 RAIL X 18IN. LONG
DIM 35 RAIL	1	AAE-DIM-RAL-2M	DIM 35 RAIL X 24IN. LONG

S/N 11161

08/22/11

PRIMARY VOLTAGE: 240 VAC
SECONDARY VOLTAGE: N/A
CONTROL VOLTAGE: 24 VDC

EAGLE
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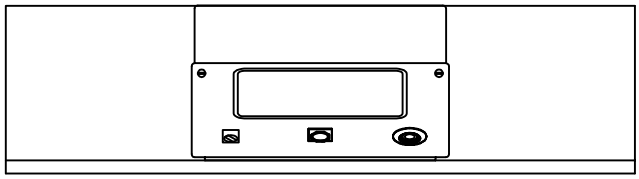
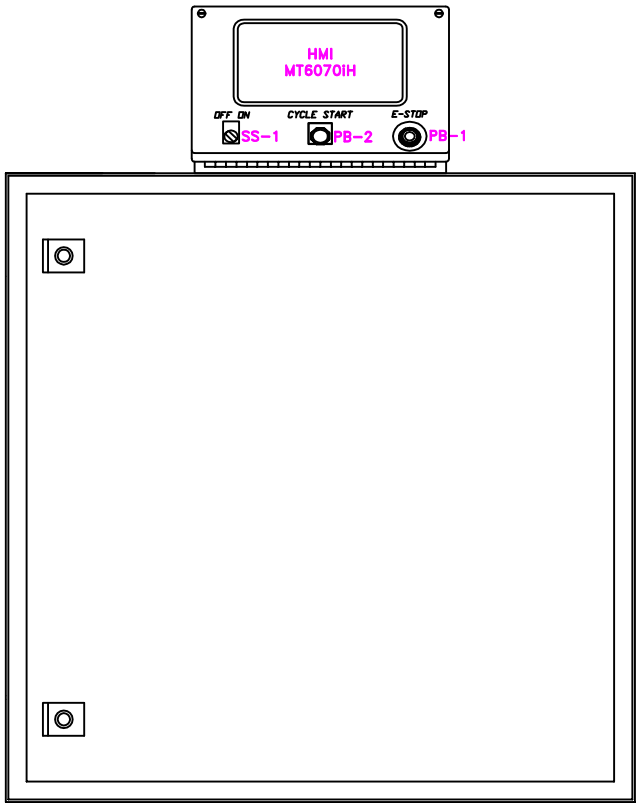
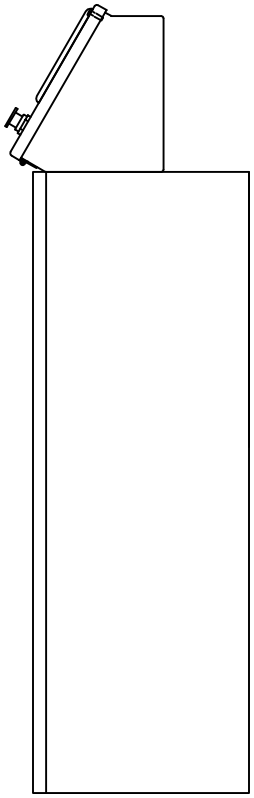
ELECTRICAL SCHEMATIC
OMRON CP1L/MT6070iH

DRAWN BY:	DWG NO.	REV
J Damas	ATF4-009-18	
DATE: 08/19/11	SCALE NONE	SHEET 19 OF 19







S/N 11161

08/22/11

PRIMARY VOLTAGE:	CONTROL VOLTAGE:
240 VAC	24 VDC
SECONDARY VOLTAGE:	
N/A	

EAGLE
Packaging Machinery, LLC
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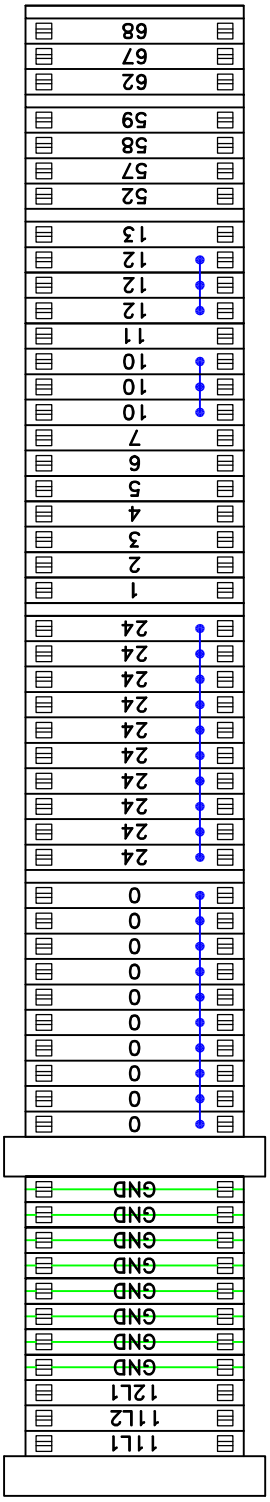
Phone: (305) 622-4070

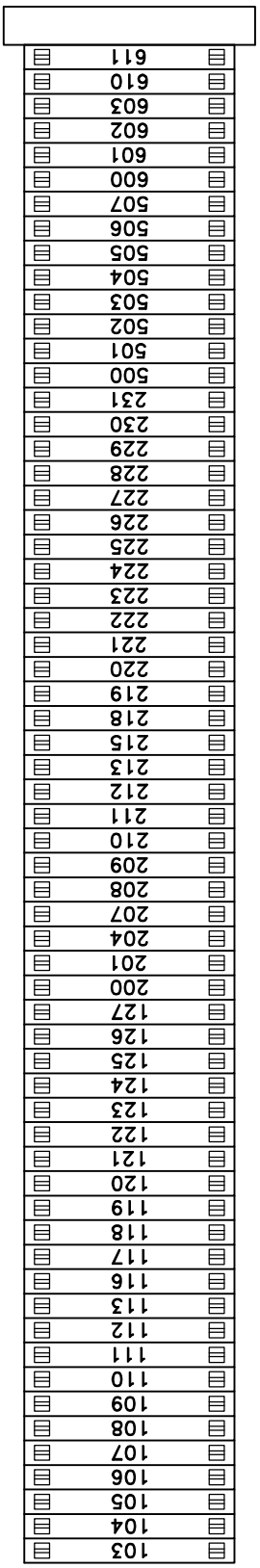
PANEL ASSEMBLY
OMRON CP1L/MT6070iH

DRAWN BY:	DWG NO.	REV
J Damas	ATF4-009-18	
DATE: 08/19/11	SCALE NONE	SHEET 1 OF 6

POWER TERMINAL BLOCKS



CONTROL TERMINAL BLOCKS

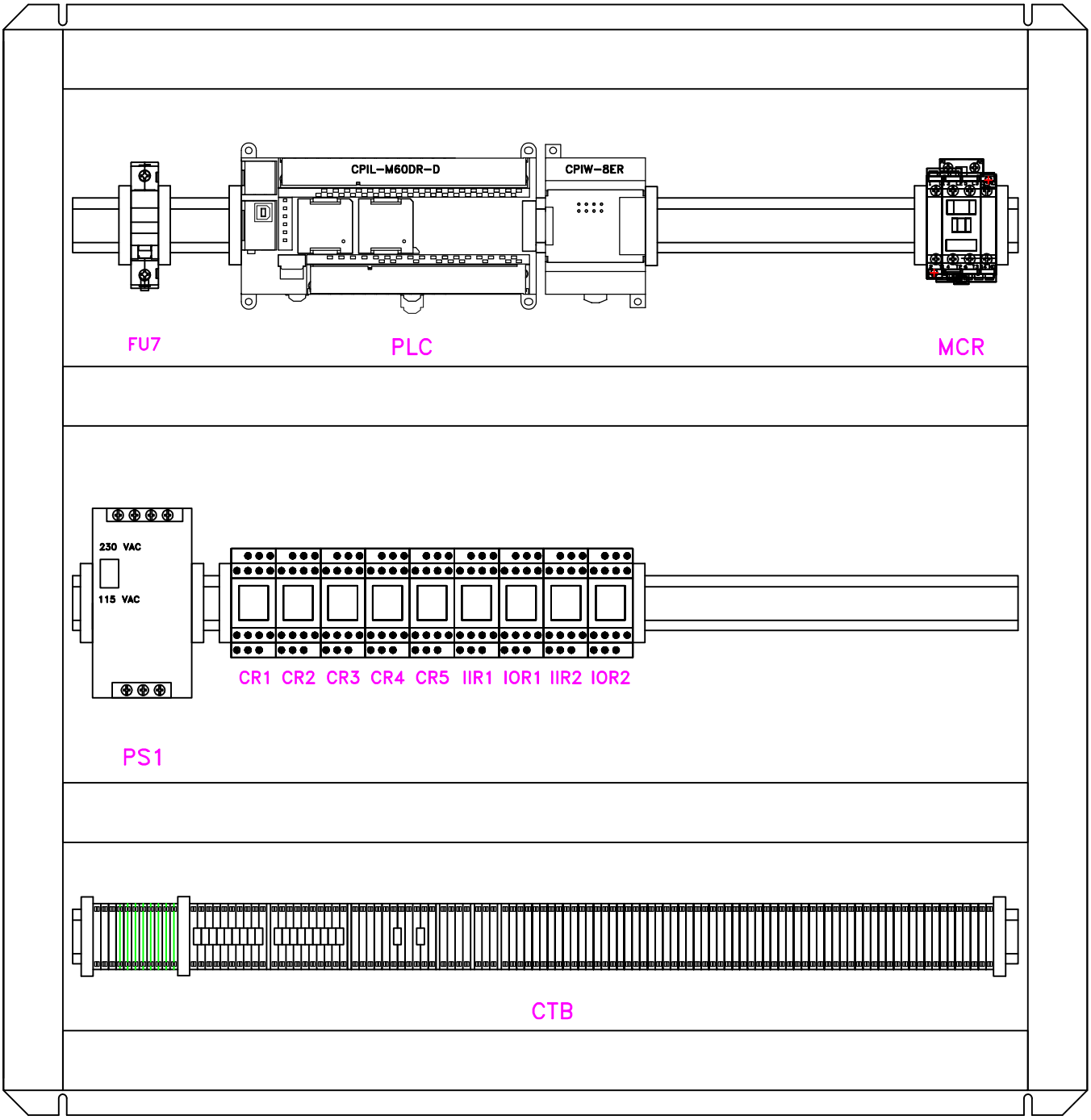


S/N 11161

08/22/11

PRIMARY VOLTAGE:	CONTROL VOLTAGE:			
240 VAC	24 VDC	**EAGLE** Packaging Machinery, LLC	**PANEL ASSEMBLY**	
SECONDARY VOLTAGE:		4760 NW 128 Street Miami, Florida, 33054 Phone: (305) 622-4070	OMRON CP1L/MT6070iH	
N/A			DRAWN BY: J Damas	DWG NO. ATF4-009-18 REV
			DATE: 08/19/11	SCALE NONE SHEET 2 OF 6

CONTROL ENCLOSURE



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08/22/11

PRIMARY VOLTAGE:	CONTROL VOLTAGE:
240 VAC	24 VDC
SECONDARY VOLTAGE:	
N/A	

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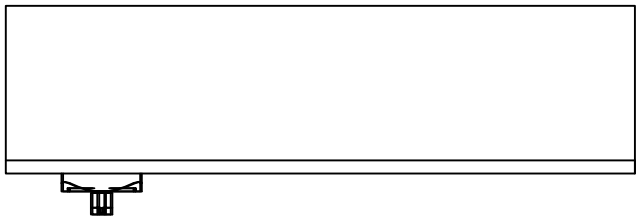
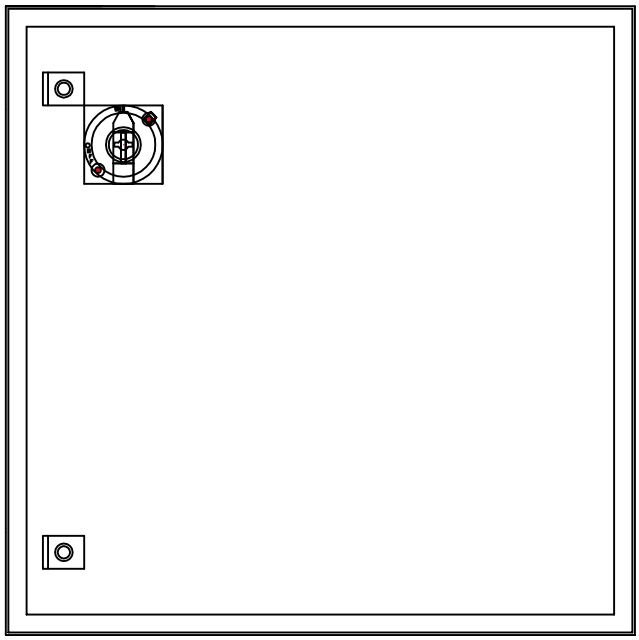
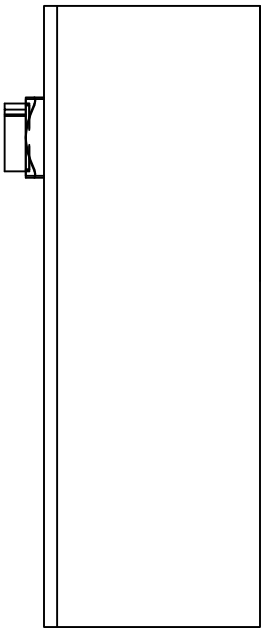
PANEL ASSEMBLY
OMRON CP1L/MT6070iH

DRAWN BY:	DWG NO.	REV
J Damas	ATF4-009-18	
DATE: 08/19/11	SCALE NONE	SHEET 3 OF 6







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08/22/11

PRIMARY VOLTAGE:	CONTROL VOLTAGE:
240 VAC	24 VDC
SECONDARY VOLTAGE:	
N/A	

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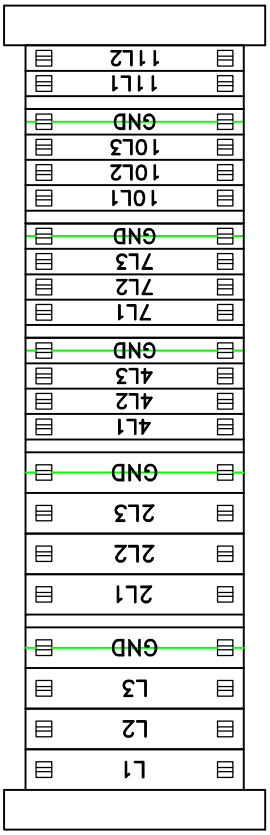
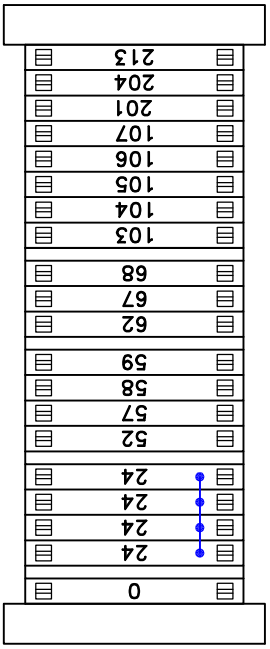
PANEL ASSEMBLY
OMRON CP1L/MT6070iH

DRAWN BY:	DWG NO.	REV
J Damas	ATF4-009-18	
DATE: 08/19/11	SCALE NONE	SHEET 4 OF 6

POWER
TERMINAL BLOCKS



CONTROL
TERMINAL BLOCKS

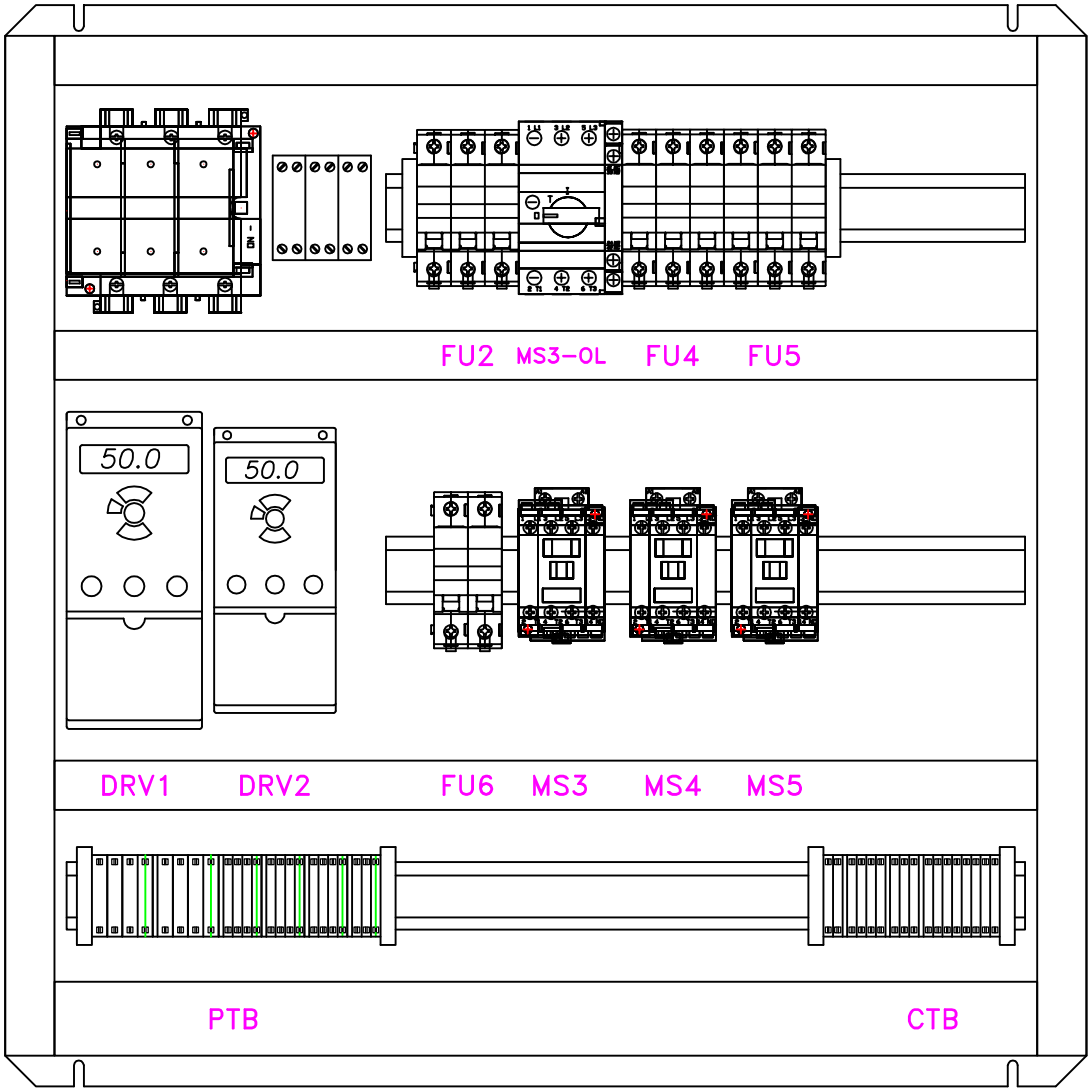


S/N 11161

08/22/11

PRIMARY VOLTAGE:	CONTROL VOLTAGE:	EAGLE	PANEL ASSEMBLY	
240 VAC	24 VDC	Packaging Machinery, LLC	OMRON CP1L/MT6070iH	
SECONDARY VOLTAGE:		4760 NW 128 Street Miami, Florida, 33054 Phone: (305) 622-4070	DRAWN BY: J Damas	DWG NO. ATF4-009-18 REV
N/A			DATE: 08/19/11	SCALE NONE SHEET 5 OF 6

POWER ENCLOSURE



S/N 11161

08/22/11

PRIMARY VOLTAGE:	CONTROL VOLTAGE:
240 VAC	24 VDC
SECONDARY VOLTAGE:	
N/A	

EAGLE
Packaging Machinery, LLC
4760 NW 128 Street
Miami, Florida, 33054
Phone: (305) 622-4070

PANEL ASSEMBLY
OMRON CP1L/MT6070iH

DRAWN BY:	DWG NO.	REV
J Damas	ATF4-009-18	
DATE: 08/19/11	SCALE NONE	SHEET 6 OF 6