

SSL-250



OPERATIONS MANUAL

Receiving and Unloading Instructions



NOTE: It is the customer's responsibility to notify the shipping company and file a claim in the event that equipment has been lost or damaged in transit.

Before the carrier leaves your facility:

1. As each item is removed from the vehicle, compare it with the carrier's bill of lading.
2. Ensure that all items and weights agree with the carrier's bill of lading.
3. If anything is missing or damaged register a claim BEFORE signing for the shipment.
4. Carefully remove all equipment and materials from the shipping container.
5. Compare all items with the packing list.
6. Contact Sleeve Seal if items do not match the packing list.



WARNING

Make certain any lifting or moving equipment is rated for the weight of the load. Moving or lifting heavy equipment or large crates without an adequate equipment is dangerous for personnel and equipment. ONLY authorized and trained personnel should operate lifting and moving equipment according to the lifting and moving equipment manufacturer's recommendations and instructions.

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Preface



This Owner's Manual contains important information, tips, suggestions and warnings about using the SSL-250 Sleeve Labeler. This manual must be read in full prior to operation to insure both operator and equipment safety.

The SSL-250 Sleeve Labeler's design features allow it to stand out in it's class. The stainless steel and polarized aluminum alloy construction creates a strong, durable, and corrosive resistant product. The modular component design aides in fast and simple product changeover on a wide array of container sizes. The operator interface is both simple and intuitive making the "on the fly" adjustments painless. The following information will help you get the most out of these features.



WARNING

Do not attempt to operate the SSL-250 until you have read thoroughly and understand completely all instructions, rules and guidelines in this manual. Failure to comply can result in accidents including fire, electric shock, serious personal injury, and/or voiding of warranty. Keep the Operation Manual with the SSL-250 and review frequently for continuous safe operation.

1.1 General Safety Guidelines

1.1.1 Know your machine.

It is important to learn all aspects of your machine, including application, limitations as well as potential hazards.

1.1.2 Keep guards in place.

For your safety and the safety of the equipment, ensure guards remain in place and in good condition.

1.1.3 Keep area clean.

Keep the areas surrounding the machine clean and free of clutter. Inspect the area regularly for items that may prevent the machine from functioning as intended (i.e. tools, extra containers, etc.).

1.1.4 Operate in a safe environment.

Operate only in a dry and well lit area.

1.1.5 Authorized personnel only.

Only trained personnel should operate and perform maintenance on the labeler. All others should be kept at a safe distance from the work area.

1.1.6 Operate at the designed rate.

Exceeding the design rate will cause failures and can damage the labeler.

1.1.7 Use the right tools.

Always use the right tool for the job. This will make changeover and maintenance faster, easier and safer.

1.1.8 Wear proper apparel.

Wear eye protection and non-slip footwear as well as any protective garments required by the plant. Loose clothing, neckties, rings, and other jewelry can be caught in the moving parts and should not be worn.

1.1.9 Perform all regular maintenance.

Lubrication and worn part replacement will keep the labeler operating safely.

WARNING

1.1.10 Disconnect power before service.

The power supply should be disconnected before servicing motors, accessories, or replacing parts.

1.1.11 Use only recommended accessories.

Only use parts and accessories supplied or recommended by the manufacturer.

1.1.12 Always TURN POWER OFF for the following.

- Leaving the labeler unattended.
- Clearing jams.
- Accessing any door of the labeler.

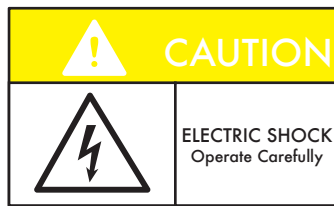
1.1.13 Warning Stickers

The labeler has series of stickers indicating specific dangers to operators and maintenance personnel. Do not remove these stickers.

1.2 Warning Sticker Glossary



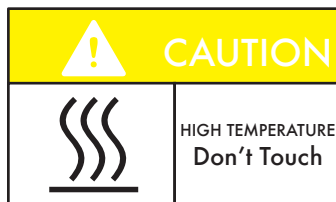
CAUTION:
DANGEROUS
DON'T TOUCH



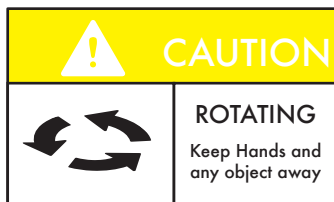
CAUTION:
ELECTRIC SHOCK
OPERATE CAREFULLY



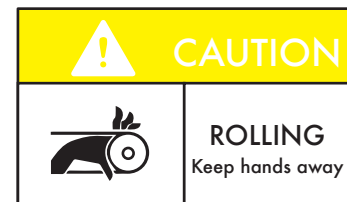
CAUTION:
CUT
KEEP HANDS AWAY



CAUTION:
HIGH TEMPERATURE
DON'T TOUCH



CAUTION:
ROTATING
KEEP HANDS AND
ANY OBJECTS AWAY



CAUTION:
ROLLING
KEEP HANDS AWAY

2 Details



2.1 Machine Specifications

Model SSL-250
Power source 480VAC/3PH
Production speed 80cpm @ 250mm Cut Length
Main Motor 700W
Supported Label Materials PVC , PET ,OPS
Machine Dimensions 980x1190x2110mm

2.2 Noise Levels

Declared A-Weighted Emission Sound Pressure Level, L_{pAd} , in dB re 20 μ Pa, at the operator's position. Idling = 68 / Operating = 73

Declared A-Weighted Sound Power Level, L_{ward} , in dB re 1pW.
Idling = 81 / Operating = 86

The emission sound pressure level at the operator station is determined in accordance with EN ISO 11204.

The sound power level is determined in accordance with EN ISO 3746.
Constant K = 4dB.

The noise levels indicated above do not guarantee safe work levels. The figures can be used in conjunction with the other noise factors (i.e. other equipment, exposure time, etc.) in the area to determine whether more precautions are required.

2.3 Function

The SSL-250 is designed to be a fully automated shrink label applicator. The machine will accommodate PVC, PET, and OPS label materials and will work on a variety of container shapes (square, round, etc.). It is only suitable to apply shrink labels; the manufacturer will not support any other use.

2 Details - *Continued*



2.4 Section Descriptions

2.4.1 Labeler Body:

Stainless steel frame supporting and protecting the labeler's components and conveyor.

2.4.2 Back Plane:

The Back Plane is the mounting point for the applicator components. This includes the Drive Section, Mandrel, Cutter Box, and Insert Section. The back plane moves the applicator components up and down in unison to accommodate varying container sizes.

2.4.3 Cutter Box:

Six blade, Servo Motor driven label cutting system. Labels are cut to the predetermined length here for application.

2.4.4 Drive Section:

The Drive Section is a series of Servo Motor driven rubber rollers. These rollers are responsible for pulling the labels onto the mandrel, driving labels through the cutter box, and forcing the indexed label into the insert wheels.

2.4.5 Feed Screw:

The Feed Screw separates incoming containers. The gap created guarantees the minimum distance between containers required for accurate label insertion.

2.4.6 Side Belts:

Two horizontal timing belts mounted to the sides of the main conveyor belt. The belts can be adjusted vertically and horizontally (to squeeze the container). While not always used, these can aid in precisely applying a label that does not cover the base of the container. They can also stabilize an unstable container.

2.4.7 Label Detect Sensor:

The Label Detect Sensor sends the signal to the control system indicating a full label index after a label has been applied. This, in conjunction with the manually entered label length, determines when to trigger the cutter box.

2.4.8 Label Tension Assembly:

A series of spring loaded rollers compress during operation to prevent slack from building up between the Label Feed Motor and the mandrel. Slack in this area can cause label failure.

2 Details - *Continued*



2.4 Section Descriptions - *Continued*

2.4.9 Label Feed Motor:

The Label Feed Motor controls the amount of uncut label material is in the Label Tension Assembly.

2.4.10 Conveyor Frame:

Two Conveyor Frames are provided with splice connection points on the infeed and discharge of the labeler. Designed to carry and return the customers conveyor chain.

2.4.11 Container Detect Sensor:

The Container Detect Sensor sends a signal to the control system to apply a label. This is the system trigger.

2.4.12 Insert Section - Sleeve Propellant

The Insert Section is the area below the cutter box on the mandrel. During operation the Insert Wheels spin constantly and apply the label to the container when triggered.

2.4.13 Vertical Label Tension Assembly:

The Vertical Label Guide is a set of spring tensioned rollers designed to ensure the label is being fed onto the Mandrel from directly above it.

2.4.14 Brush Section:

The Brush Section is an assembly of short rubber rods on both sides of the conveyor that rotate to tap the label down. This ensures the label is at the lowest desired point on the container.

2.4.15 Mandrel:

The Mandrel opens up the flat label to the shape of the container. It is supported in the system by the Drive Section and the Insert Section.

2.4.16 Infeed & Discharge Sensors:

The Infeed & Discharge Sensors (not shown in diagram) are photo eyes to be mounted on the customer conveyor. The Infeed Sensor will stop the Feed Screw if there are too few containers available. The Discharge Sensor will stop the Feed Screw if containers are no longer passing it.

3 Installation



3.1 Location Guidelines

- 3.1.1 Environment provides an operating temperature between 5°C-40°C (41°F-104°F). NOTE: Labels must be stored in less than 75°
- 3.1.2 Environment provides a relative humidity of less than 50%.
- 3.1.3 Area should be free of excessive noise.
- 3.1.4 Area should be free of excessive vibration.
- 3.1.5 Area should be well lit.
- 3.1.6 A minimum of 1000mm / 3.28 feet of free space on each side of the machine.
- 3.1.7 Must be installed on a level concrete floor.

3.2 Lifting

- 3.2.1 Only an experienced forklift driver should attempt to move equipment.
- 3.2.2 Use a forklift capable of lifting 8000lbs.
- 3.2.3 Make sure load is balanced on the forks.
- 3.2.4 Forks must be longer than the equipment is deep. Forks must be visible on both sides of the machine while lifting.
- 3.2.5 Use a second person as a lift spotter and a guide.
- 3.2.6 **ONLY LIFT FROM THE BOTTOM OF MACHINE**

3.3 Machine Leveling

The labeler must be installed on a solid and level concrete floor with enough space surrounding it for the operator to handle the machine and the materials associated. Once the labeler is in place, use the threaded leveling foot pads provided to level the cabinet and adjust to the specified conveyor elevation - see *2.4 Machine Diagram*.

3.5 Power Connection

- 3.5.1 Only qualified electrical personal should perform electrical connections.
- 3.5.2 Consult electrical drawings provided with your labeler to confirm voltage, phase, and amps required for connection.
- 3.5.3 Connect power wires L1, L2, and L3 and the ground wire. Improper grounding can cause machine failure.
- 3.5.4 Power on labeler and test conveyor direction. If conveyor is moving the wrong direction have a qualified electrician interchange the lead wires from the power supply.

3 Installation - *Continued*



3.6 Temporary Storage

Should the labeler need to be stored for an amount of time prior to installation, make sure the labeler is in an area free of moisture and is protected from the elements.

3.7 Cleaning

Prior to start up it is important to clean the dust and dirt that has built up during transportation. With a clean cloth, wipe down all non-lubricated surfaces. Add a small amount of lubrication to the marked lubrication points - see *10.5 Lubrication Points*.

4 Photo Sensors



4.1 Setting the Label Registration Sensor

While this sensor will be set up by the technician during the installation, product and label design may change. These changes may require a change in the angle of the sensor and a change in the sensitivity. *SICK Registration Sensor Manual is attached for reference.*

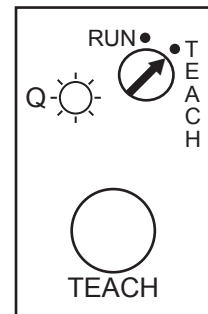
4.1.1 Change the mode to TEACH

4.1.2 Move label so that the label is in front of the sensor then press TEACH 1~3 times until the Q signal flashes quickly.

4.1.3 Move the label so that the section of the label that you would like to use as the trigger is in front of the sensor and press TEACH 1 time and the Q signal will flash slowly.

4.1.4 Move the label until the reflective tape is visible to the sensor and press TEACH 1 time; Q signal will stay on.

4.1.5 Return to RUN mode for normal operation.

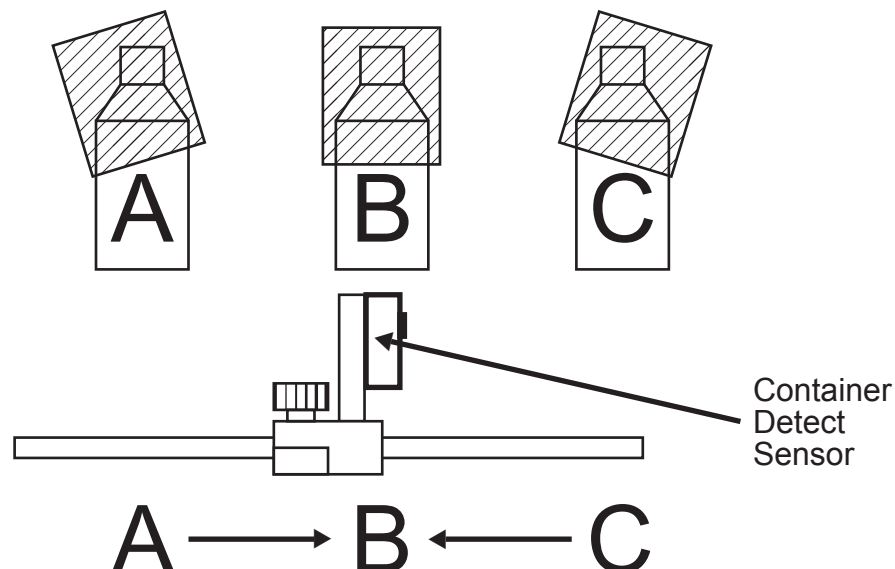


4.2 Setting the Container Detect Sensor

Like the Label Detect Sensor, the Container Detect Sensor will be set by the technician during installation but horizontal and vertical adjustments may be required for different containers.

4.2.1 Horizontal adjustment:

- If label application resembles "A", adjust the sensor and the reflector to the right.
- If label application resembles "C", adjust the sensor and the reflector to the left.

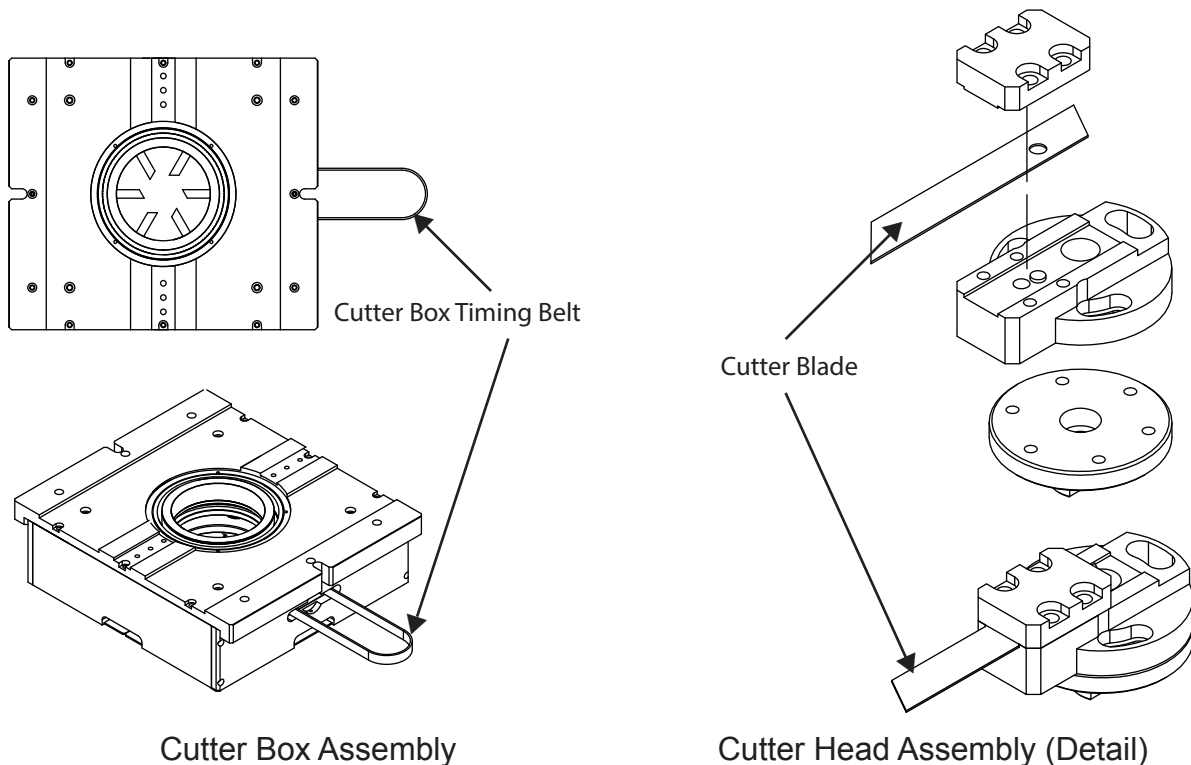


5 Cutter Box



5.1 Changing Blades

- 5.1.1 Press E Stop and open the cabinet door.
- 5.1.2 Loosen the Drive Rollers and remove the Mandrel.
- 5.1.3 Remove the cutter box from the Labeler.
 - Use the belt tensioning knob that moves the servo motor and the drive pulley to move them towards the cutter box. This is enough slack in the cutter box timing belt to move it off of the drive pulley.
 - Then push the timing belt into the cutter box.
 - Loosen the thumb screws that hold the cutter box in place.
 - Slide the cutter box out.
- 5.1.4 Remove screws from bottom guard plates.
- 5.1.5 Hold the cutter box timing belt to prevent the blades from rotating when working on the blades.
- 5.1.6 Referring to the diagram below, remove the four screws from the blade retaining plate and remove.
- 5.1.7 Count the segments of the old blade and break new blade to match.
- 5.1.8 Put new blade in place and reinstall the blade retaining plate.
- 5.1.9 Repeat this process for the remainder of the blades.
- 5.1.10 Reinstall the blade guard plate.
- 5.1.11 Reinstall the cutter box and the mandrel into the labeler.



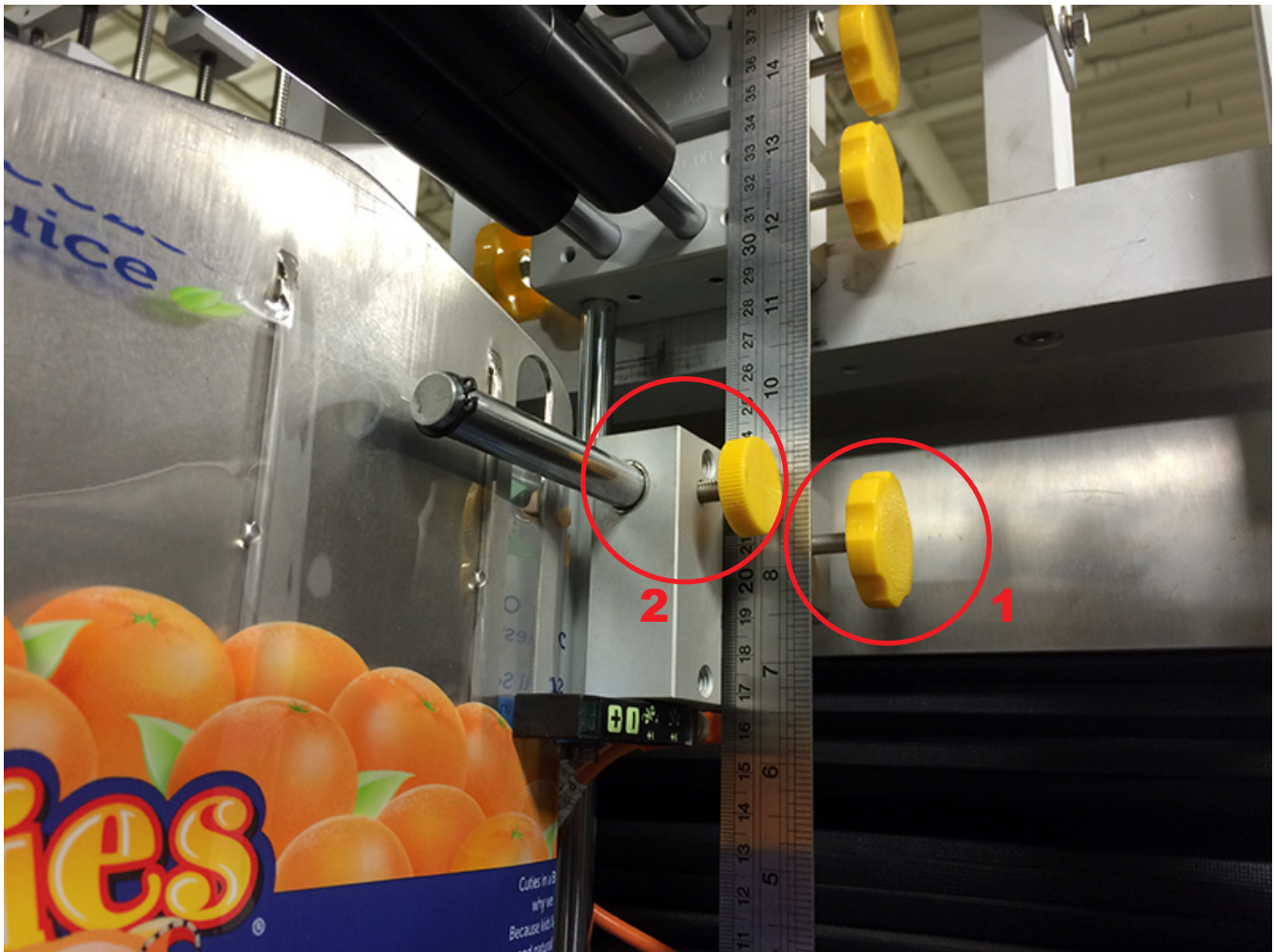
6 Adjustments



6.4 Label Sensor Section

This is a view of the controls dedicated to the Label Sensor section of the labeling machine and their relationship to one another. *See image below*

1. Label Registration Sensor Up/Down Adjuster
2. Label Registration Sensor In/Out Adjuster



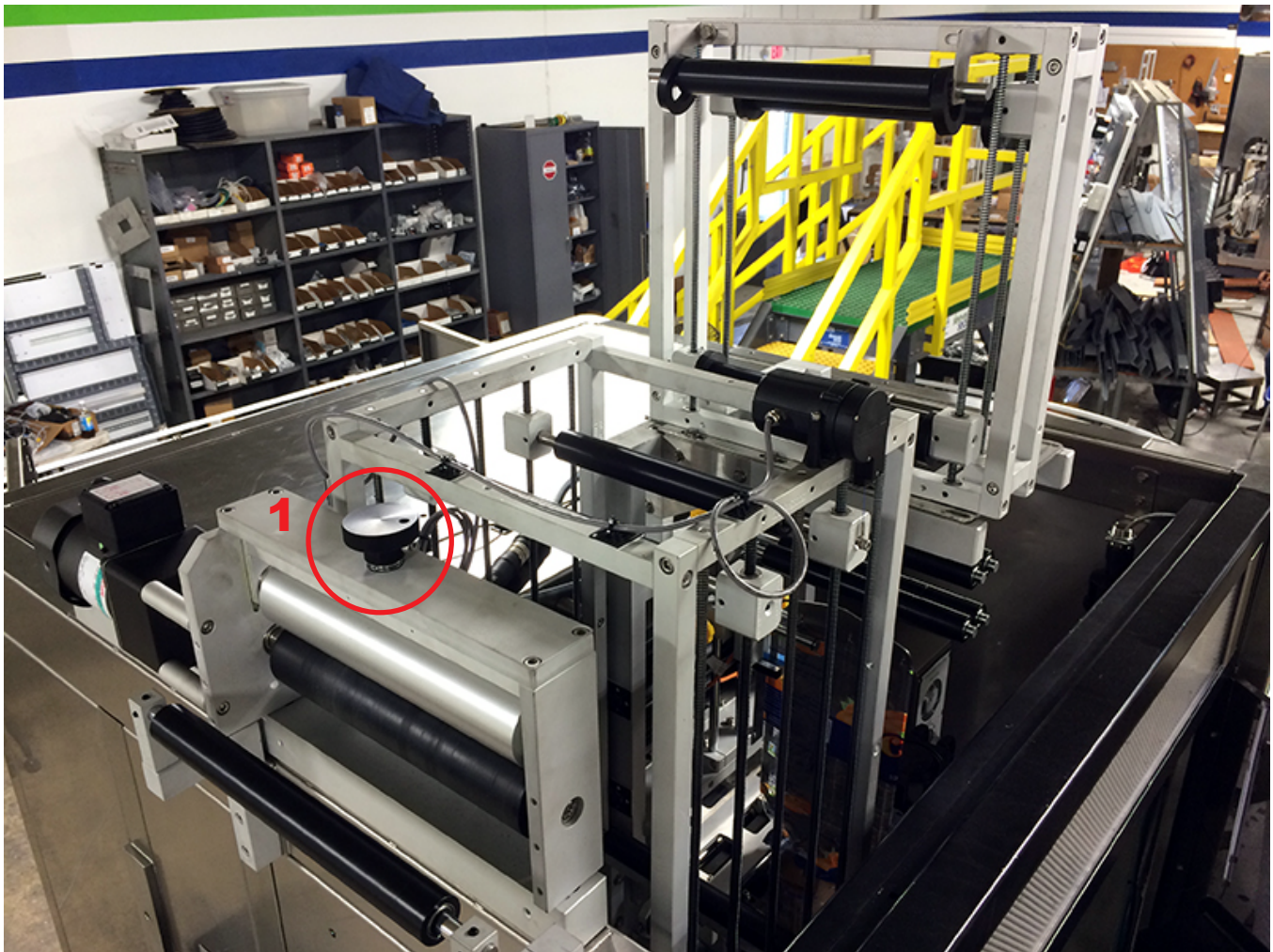
6 Adjustments - *Continued*



6.4 Infeed Motor

This is a view of the controls dedicated to the Infeed Motor of the labeling machine and their relationship to one another. *See image below*

1. Infeed Motor Roller Film Tension Adjuster



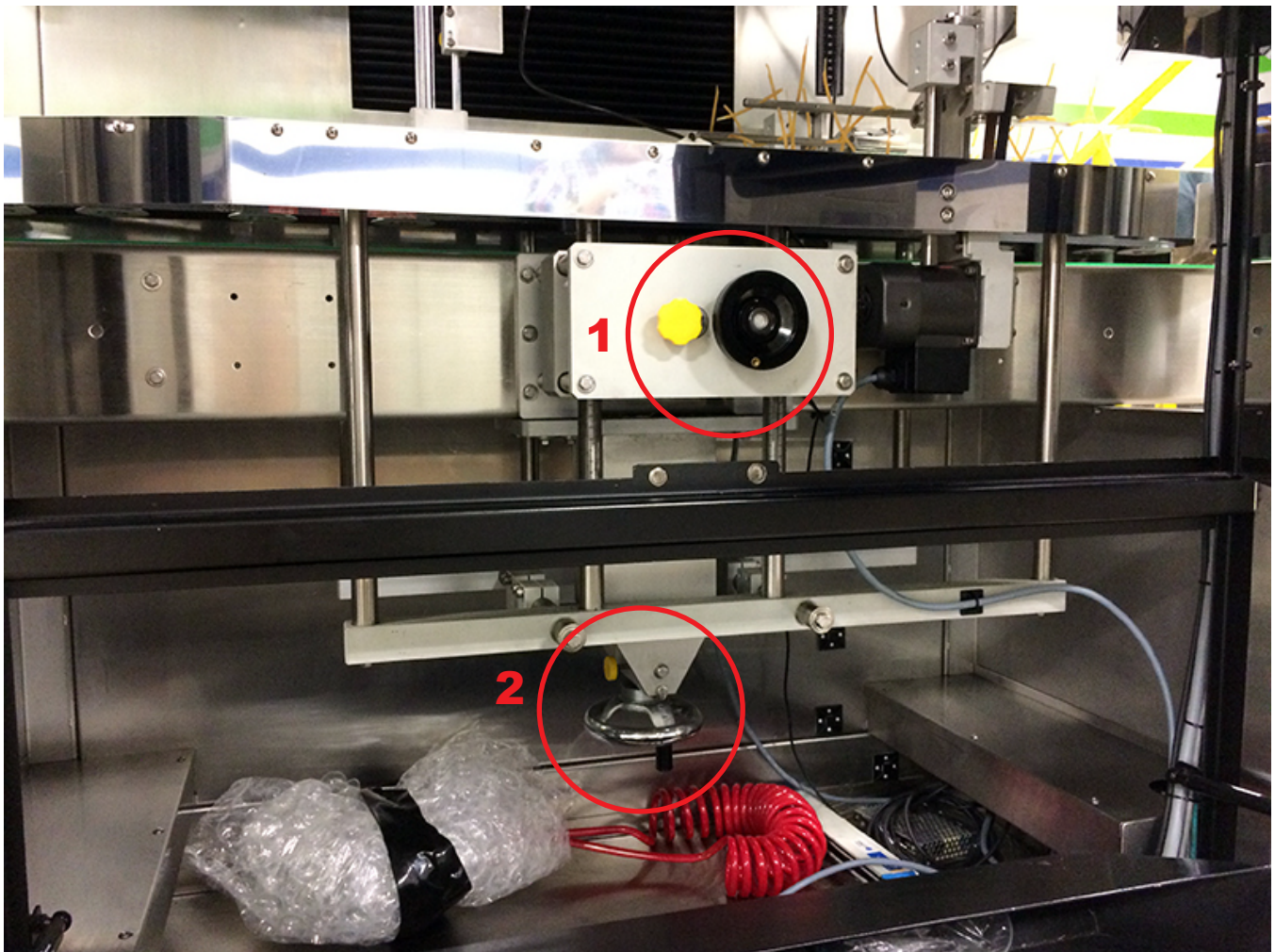
6 Adjustments - *Continued*



6.2 Hugger Belt Section

This is a view of the controls dedicated to the Hugger Belt section of the labeling machine and their relationship to one another. *See image below*

1. Hugger Belt Section In/Out Adjuster
2. Hugger Belt Section Up/Down Adjuster



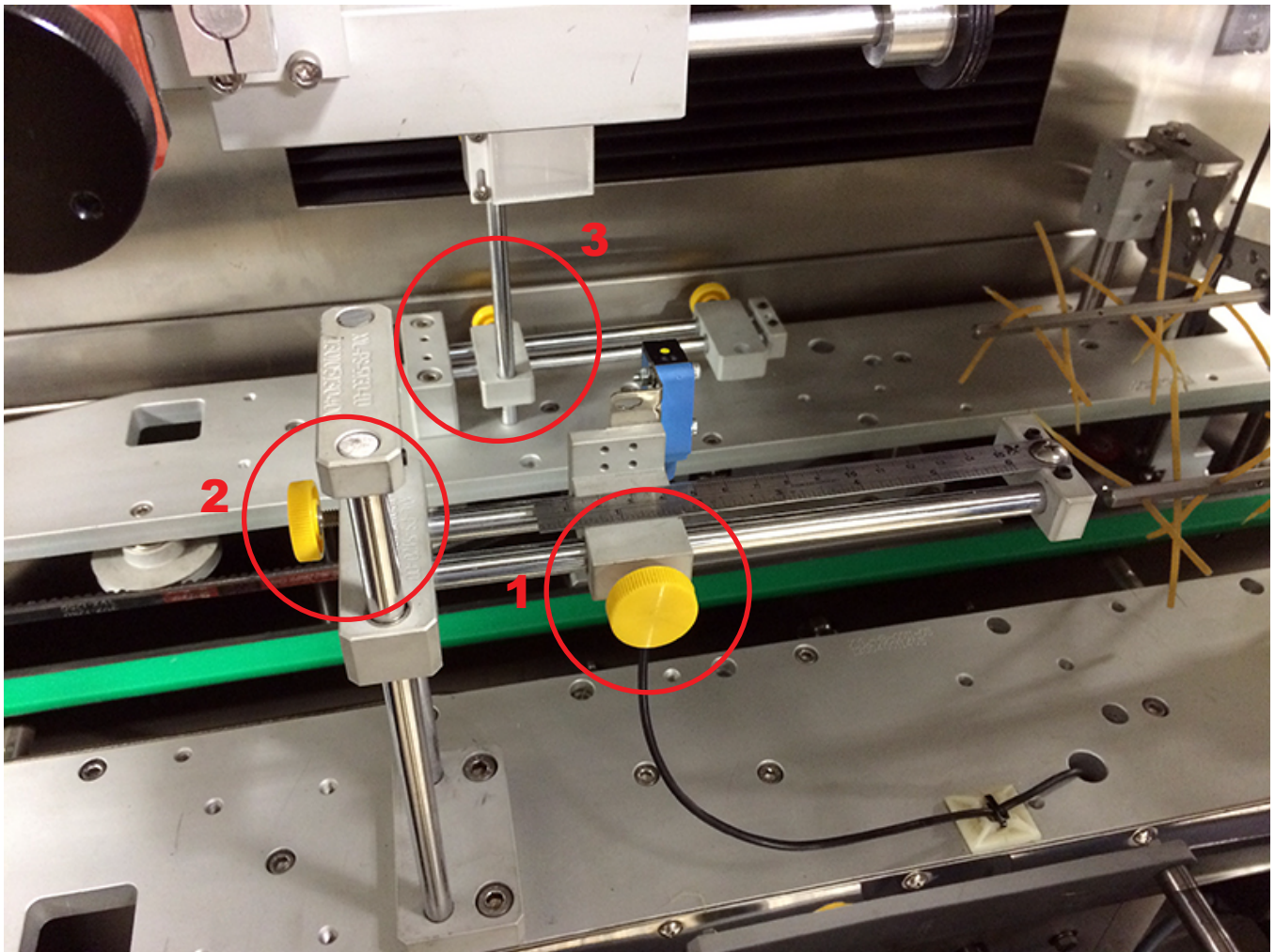
6 Adjustments - *Continued*



6.3 Label Sensor Section

This is a view of the controls dedicated to the Label Sensor section of the labeling machine and their relationship to one another. *See image below*

1. Label Sensor Section Left/Right Adjuster
2. Label Sensor Section Up/Down Adjuster
3. Label Reflector Left/Right Adjuster



7 Trouble Shooting



7.1 Trouble shooting by location of problem

Label	Q: Is the label lay flat sufficient to fit over the container? Q: Is the label thickness accurate? A: Measure the label and change roll if needed.
Bottle	Q: Are the bottles deformed? A: Visually assess and remove deformed containers. Q: Do the containers match the label? A: Change containers.
Conveyor Motor	Q: Is the conveyor motor sufficient in HP for the conveyor? A: Check motor specifications. Q: Does the rate of reducer match the speed of production line? A: Contact Sleeve Seal if speed is insufficient.
Conveyor Chain	Q: Is there too much sag in the chain? A: Inspect chain, adjust if slack. Q: Does the belt fit properly in the carry way track? A: Inspect chain, replace if worn.
Conveyor Frame	Q: Is the inside of the conveyor frame free of interferences? A: Check that the return path is clear of screws. Q: Are the return rollers in good working order? A: Check that the return rollers are straight.
Feed Screw	Q: Is the container unstable when in the feed screw? A: Adjust the screw vertically to stabilize the container (the proper height range is between 5~8mm). Q: Does the RPM of the feed screw match the conveyor speed and match the speed indicated on the touch screen? A: Contact SleeveSeal if a problem exists.
Insert Section	Q: Are both insert wheels touching the mandrel bearings? A: Check that the mandrel is installed squarely. Q: Are the insert wheels and mandrel bearings in line? A: Move insert wheels in line. Q: Are the insert wheels spinning? A: Check that the insert drive belt is properly engaged.

8 Lubrication and Maintenance



Note: Always turn off the labeler before performing the maintenance tasks

The maintenance in this section should only be performed by properly trained maintenance personnel. Regular maintenance and lubrication will maximize the life span of the labeler.

8.1 Lubrication Schedule - *Refer to chart below and pages 22-23 for areas to be lubricated*

Lubrication for certain components are scheduled weekly, monthly, biannually, and annually. Machine gears and bearings require a period to bed in naturally during run-in, i.e. in the first 300 hours of service.

8.2 Should a component begin to rust, immediately clean the part and inspect for damage. If undamaged, re-lubricate. If damaged, replace the part.

8.3 Do not set or store anything on or above the conveyor.

8.4 Check belts and pulleys weekly for signs of wear. Keep spare belts ready.

Item	Weekly	Monthly
Machine	Lubrication as needed	Lubrication as needed
Mandrel	Surface inspection and cleaning	Bearing inspection
Insert Section	Rubber wheel inspection	Rubber wheel inspection
Drive section	Rubber wheel inspection	Rubber wheel inspection
Cutter Box	Blade inspection	Blade change, bearing and belt inspection
Conveyor	Belt inspection	Belt adjustment
Motor		Gear box inspection
Hugger Belt	Belt inspection	Belt adjustment
Label Tension Assembly	Linear slider inspection	Linear slider inspection
Label Accumulation Cabinet	Surface inspection and cleaning	Brake system inspection

Item	Biannually	Annually
Machine		
Mandrel	Bearing replacement	Bearing replacement
Insert Section	Belt inspection	Gear and bearing check
Drive section	Bearing inspection	Gear and bearing check
Cutter Box	Gear inspection	Bearing check
Conveyor	Bearing inspection	
Motor	Function test	Function test
Hugger Belt		Belt replacement
Label Tension Assembly		
Label Accumulation Cabinet	Brake system inspection	

* Sleeve Seal suggests frequent inspection and maintenance for all labeling machines. The guidelines shown here may vary with application of each machine.

9 Electrical



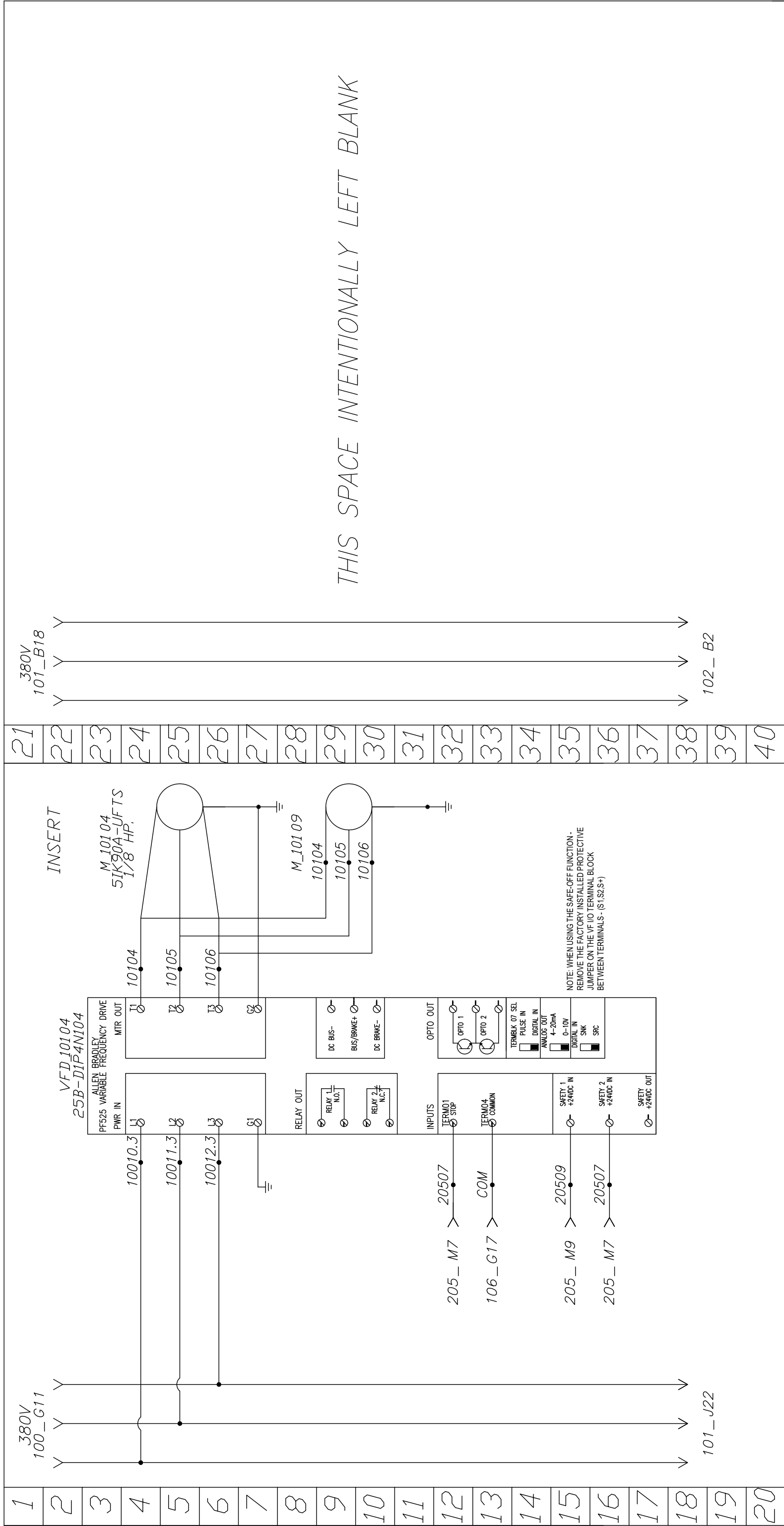
9.1 Electrical Safety

Always follow electrical safety procedures. All maintenance done on machine should be performed with the power off or disconnected. Any electrical work on machine should be performed by a certified electrician.

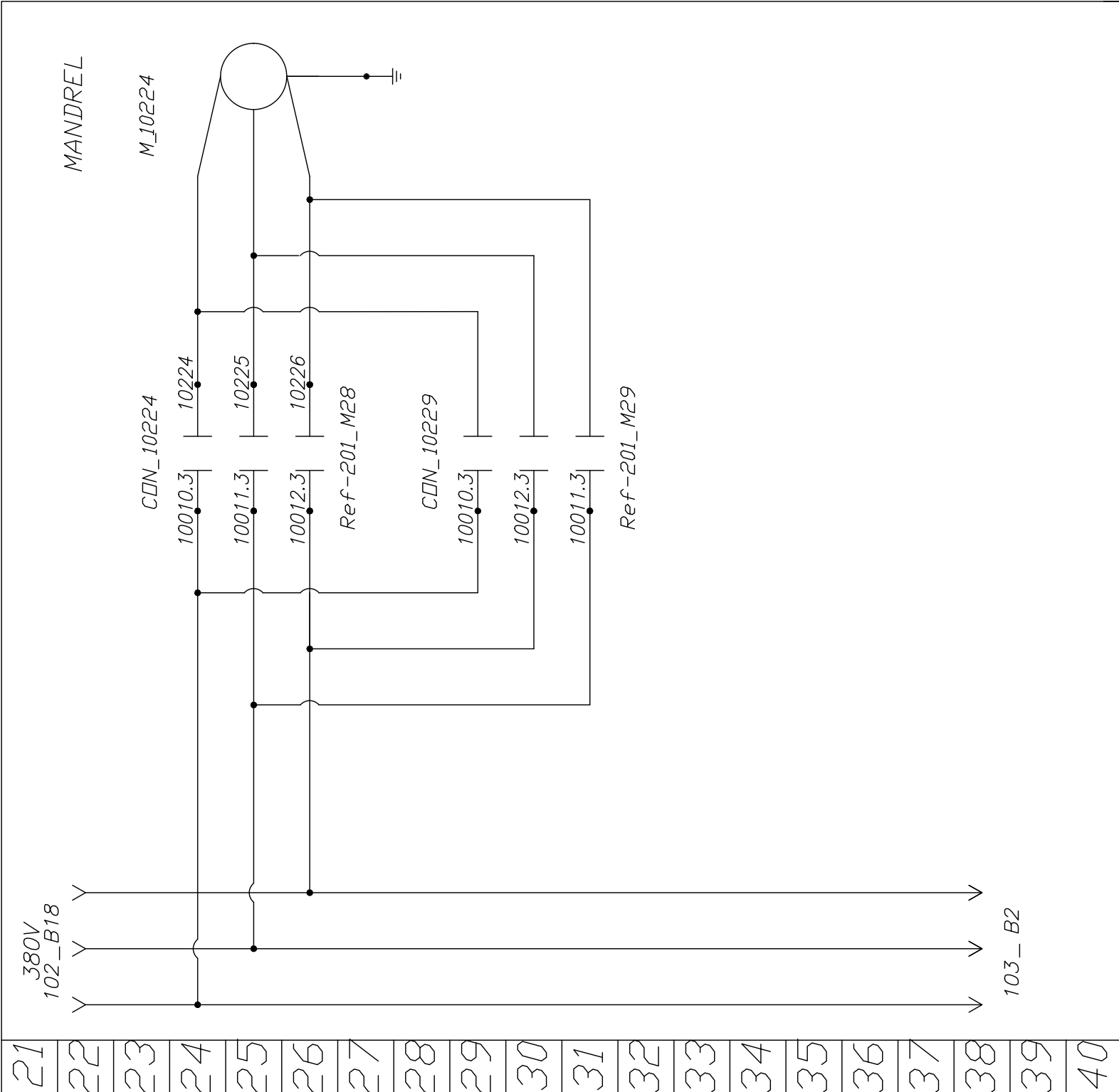
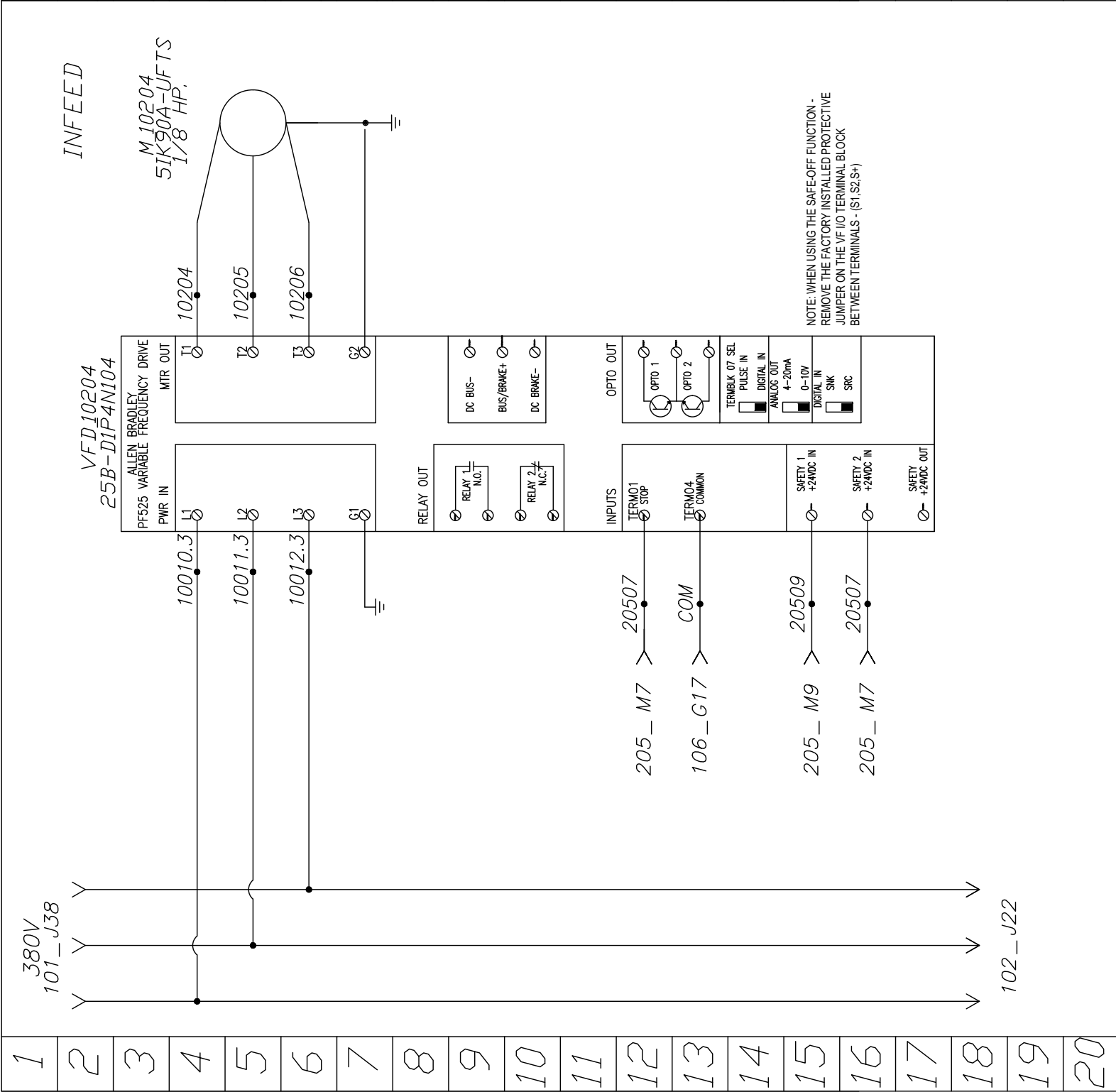
9.2 Electrical Drawings

Refer to attached detailed electrical schematics and drawings.

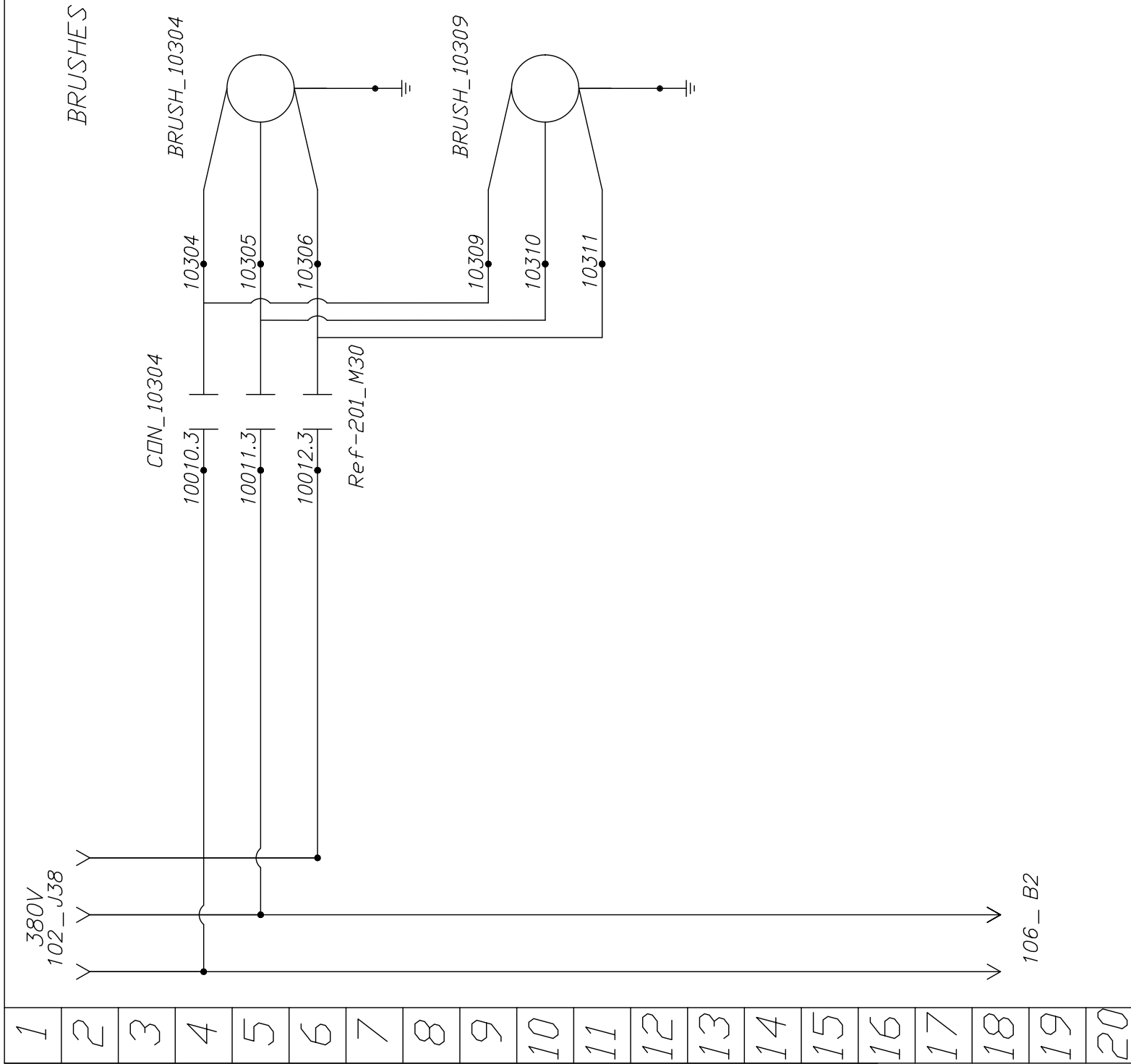
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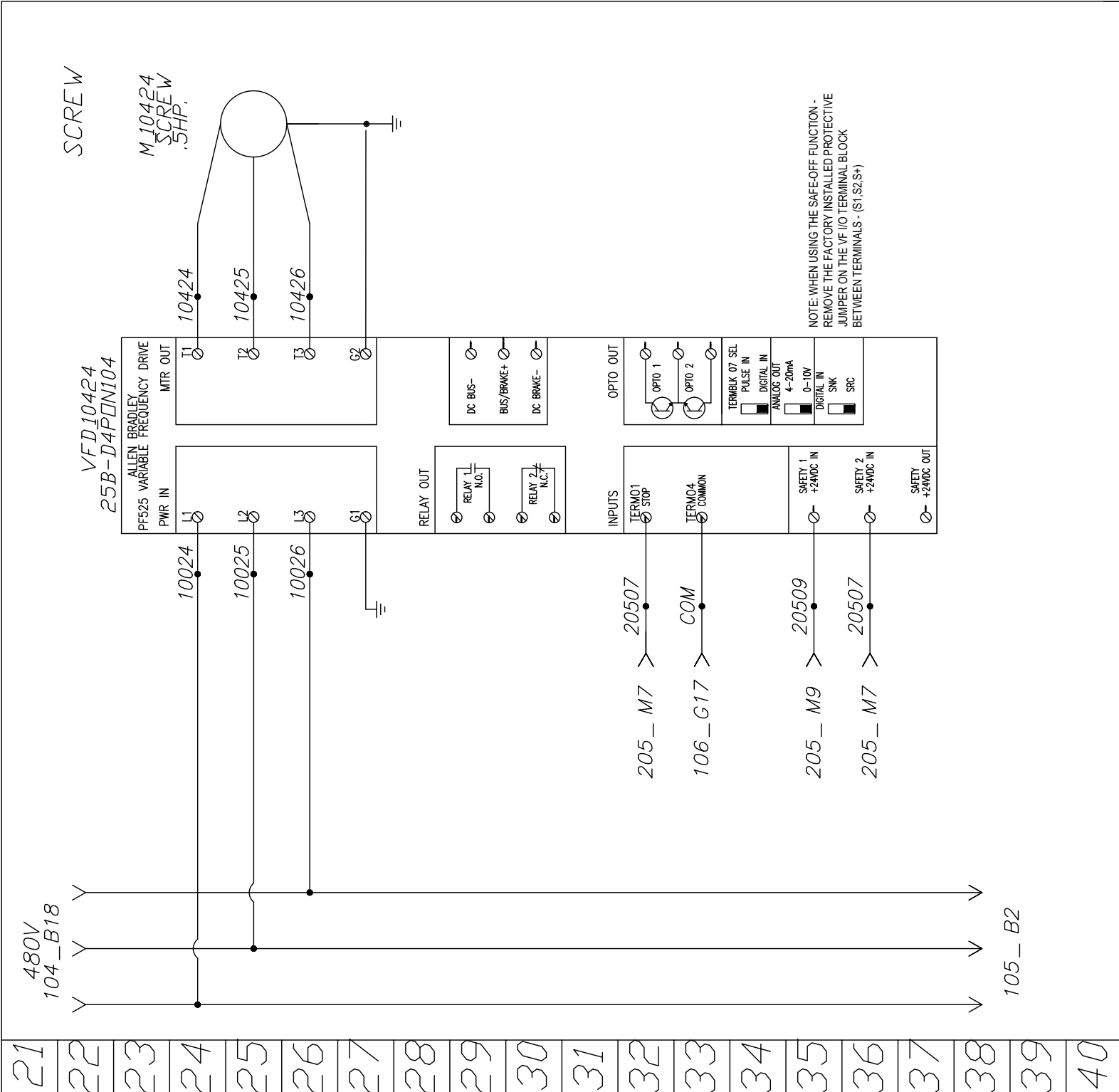
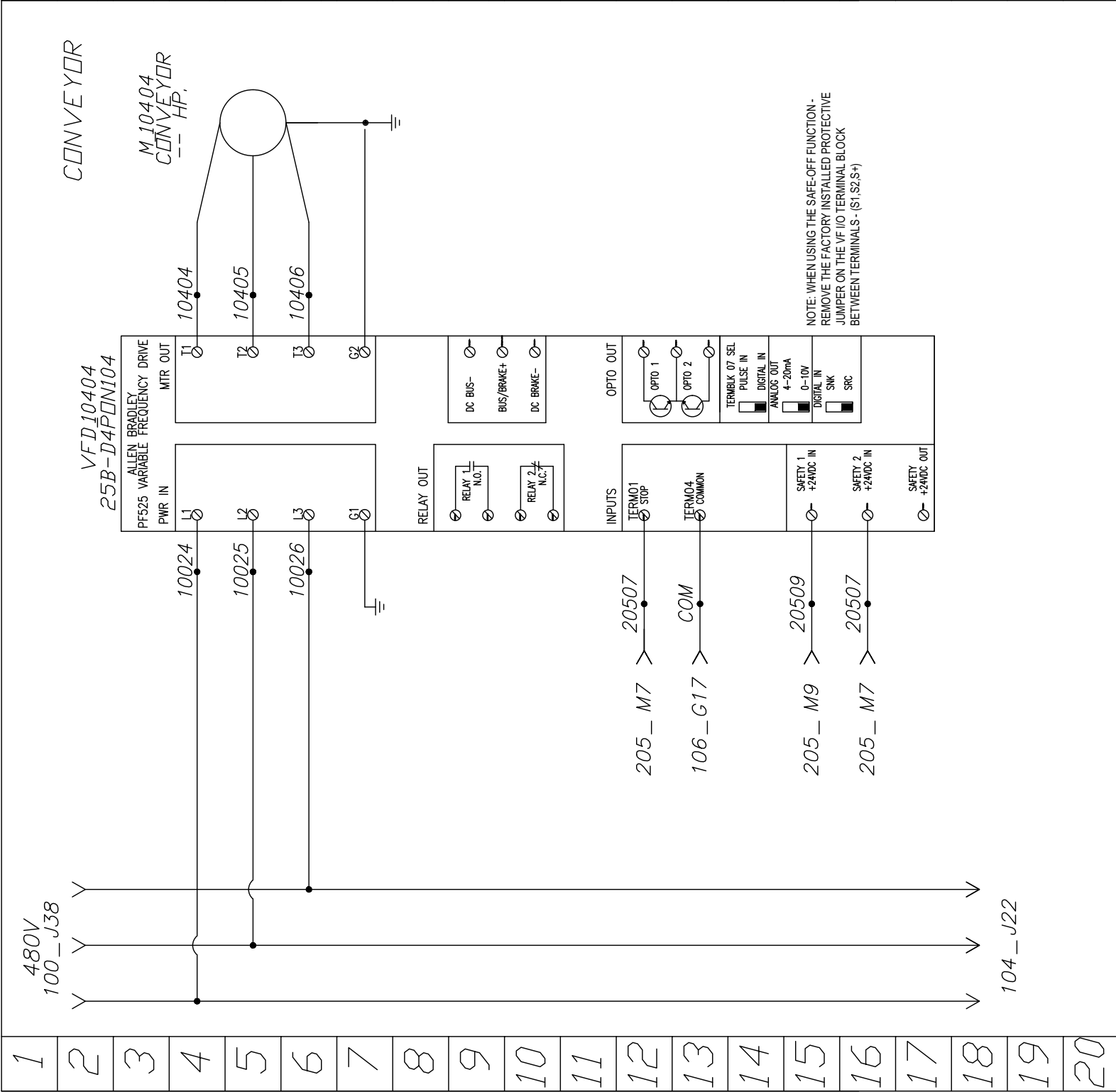


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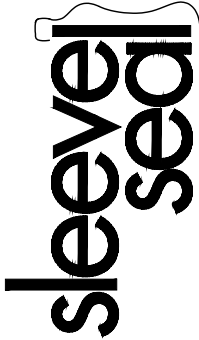


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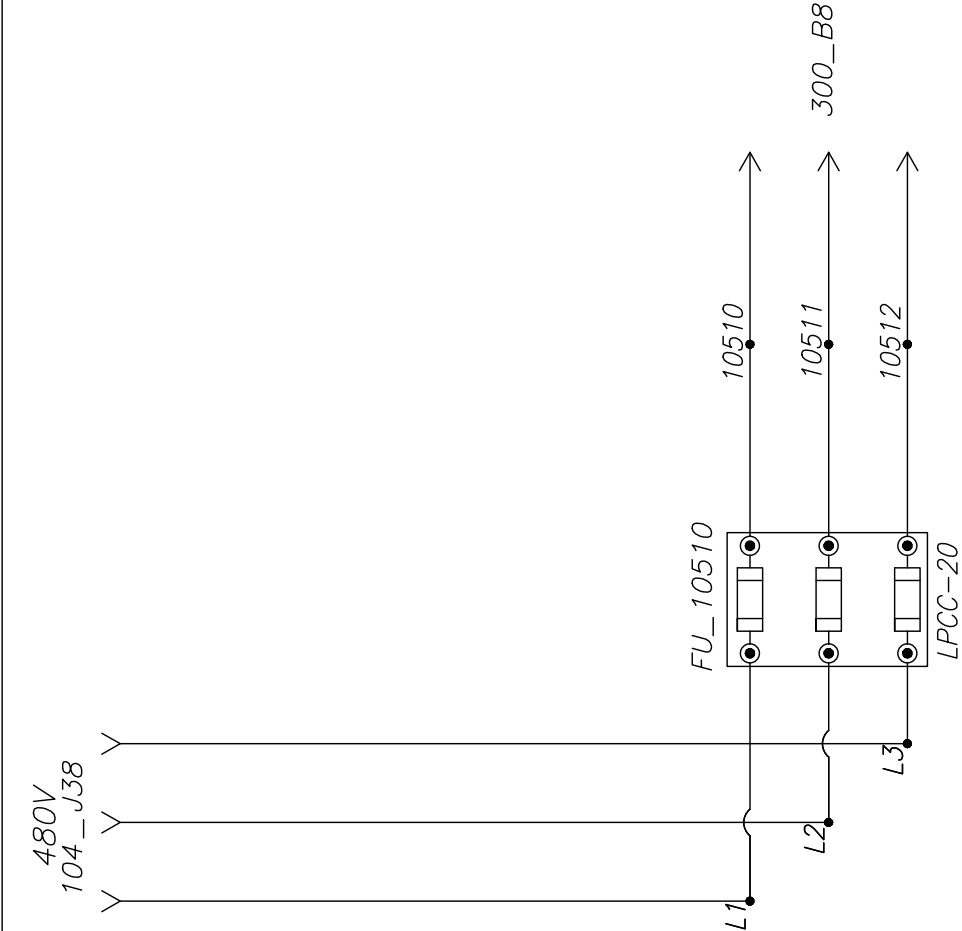
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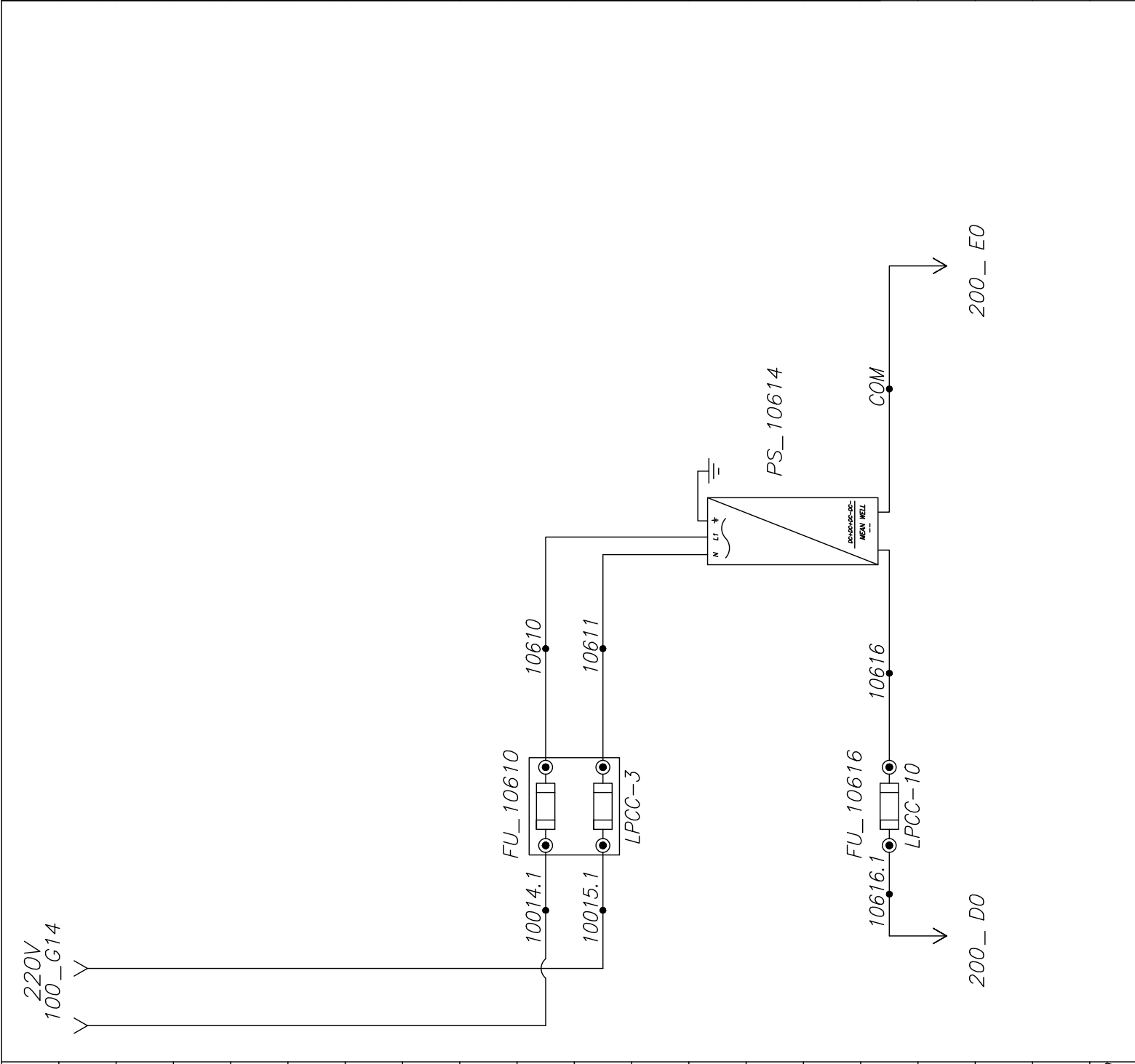


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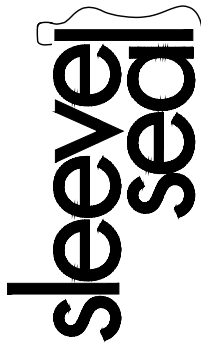
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DATE: 8/2020

DRAWN BY:GG

APP.

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LEGEND

POWER TERMINAL, 600V

CONTROL TERMINAL, 600V

FUSE

NUMBERED WIRE

WIRE IN ENCLOSURES

OTHER WIRING

This Product is Listed by
UNDERWRITERS LABORATORIES, INC.
and Bears the Mark:

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NOTES

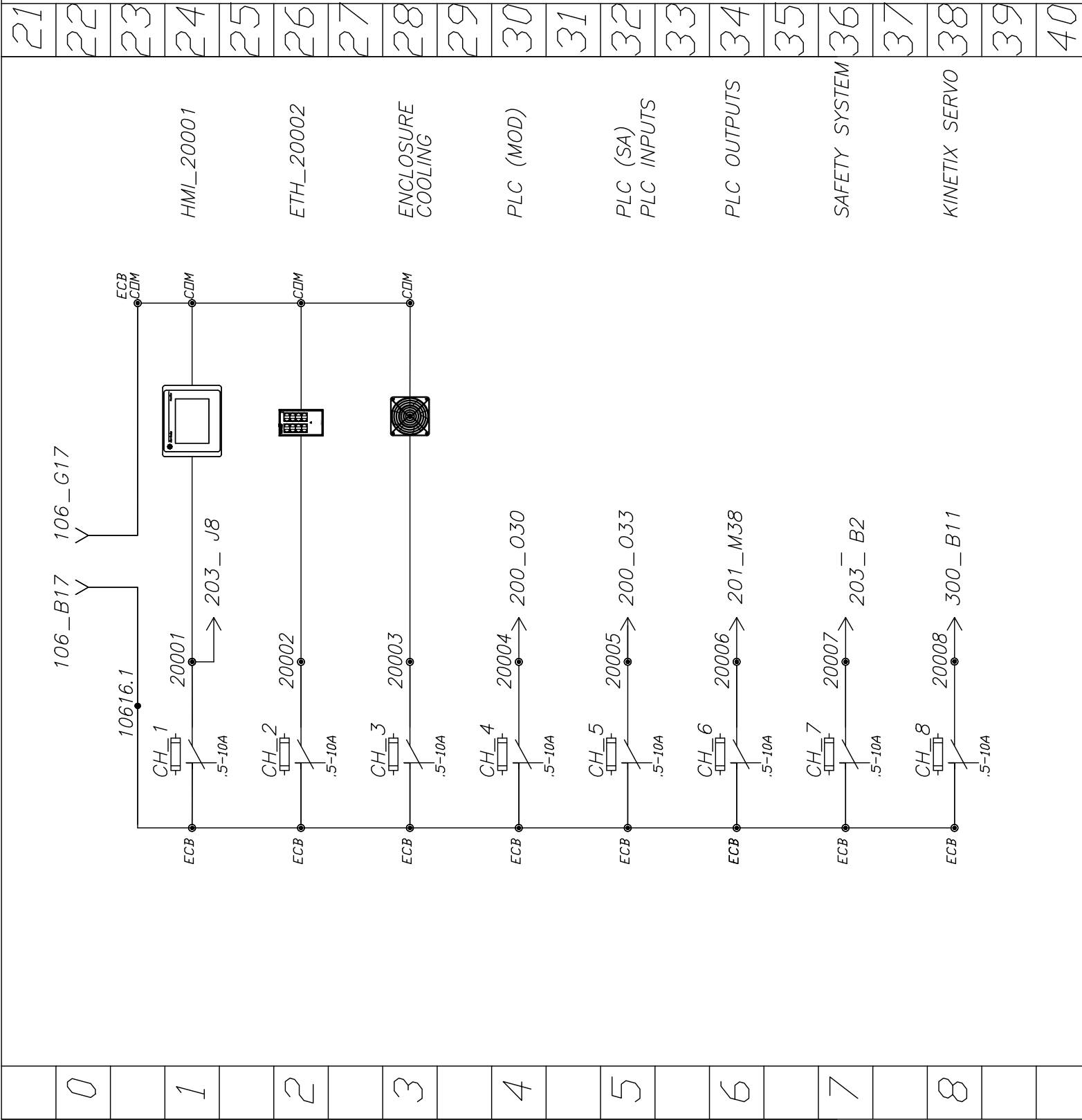
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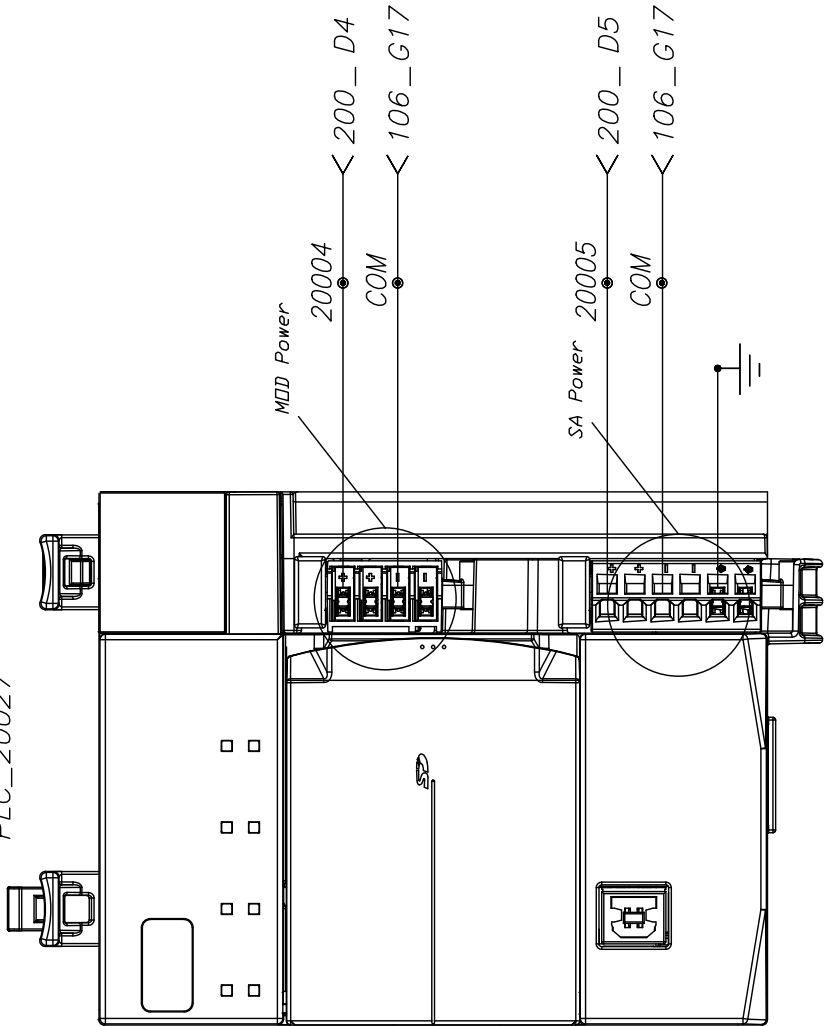
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NOTES

1. POWER WIRING IS BROWN,ORANGE,YELLOW

This Product is Listed by
UNDERWRITERS LABORATORIES, INC.
and Bears the Mark:



LEGEND

-  POWER TERMINAL, 600V
-  CONTROL TERMINAL, 600V
-  FUSE
-  NUMBERED WIRE
-  WIRE IN ENCLOSURES
-  OTHER WIRING

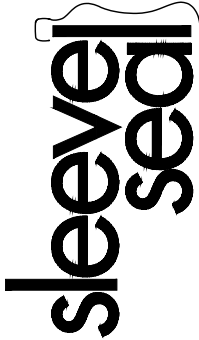
SCALE:NONE

DATE: 8/2020

DRAWN BY:GG

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Inc., and that it shall be returned upon demand.



TITLE:

24VDC

SSL-250

Blue Marble

Indianapolis,IN

JOB# 03141810

PAGE# 200

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NOTES

1. POWER WIRING IS BROWN, ORANGE, YELLOW

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This Product is Listed by
UNDERWRITERS LABORATORIES, INC.
and Bears the Mark:



LEGEND

- POWER TERMINAL, 600V
- CONTROL TERMINAL, 600V
- FUSE
- NUMBERED WIRE
- WIRE IN ENCLOSURES
- OTHER WIRING



TITLE:

SCALE: NONE DRAWN BY: GG
DATE: 8/2020 APP.

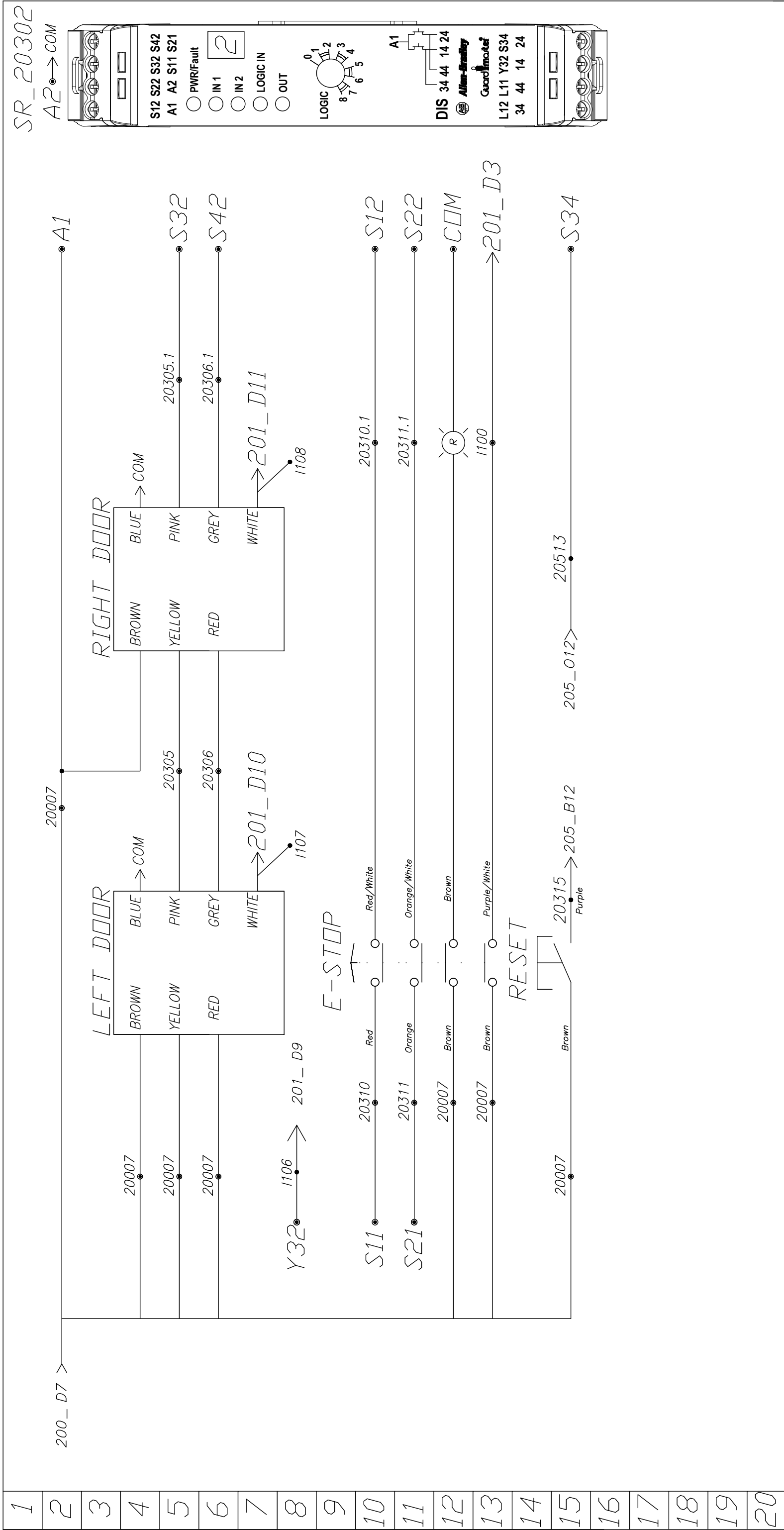
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SSL-250

Blue Marble

Indianapolis, IN

JOB# 03141810 PAGE# 202



A	B	C	D	E	F	G	H	I	J	K	L	M	N	O	P														
This Product is Listed by UNDERWRITERS LABORATORIES, INC. and Bears the Mark: c(UL)US						LEGEND —●— POWER TERMINAL, 600V —●— CONTROL TERMINAL, 600V —□— FUSE —●— NUMBERED WIRE — WIRE IN ENCLOSURES -- OTHER WIRING						sleeve! seal						SCALE: NONE						DRAWN BY: GG					
																		DATE: 8/2020						APP.					
																		This drawing is the property of Sleeve Seal, LLC Inc. It is loaned upon the express condition that it shall not be copied or reproduced in any manner, that it shall not be submitted to others for examination without the consent of this company, that it shall not be used in any other way detrimental to the interest of Sleeve Seal LLC Inc., and that it shall be returned upon demand.											
TITLE: 440R-SAFETY SSL-250 Blue Marble Indianapolis, IN																		JOB# 03141810						PAGE# 203					

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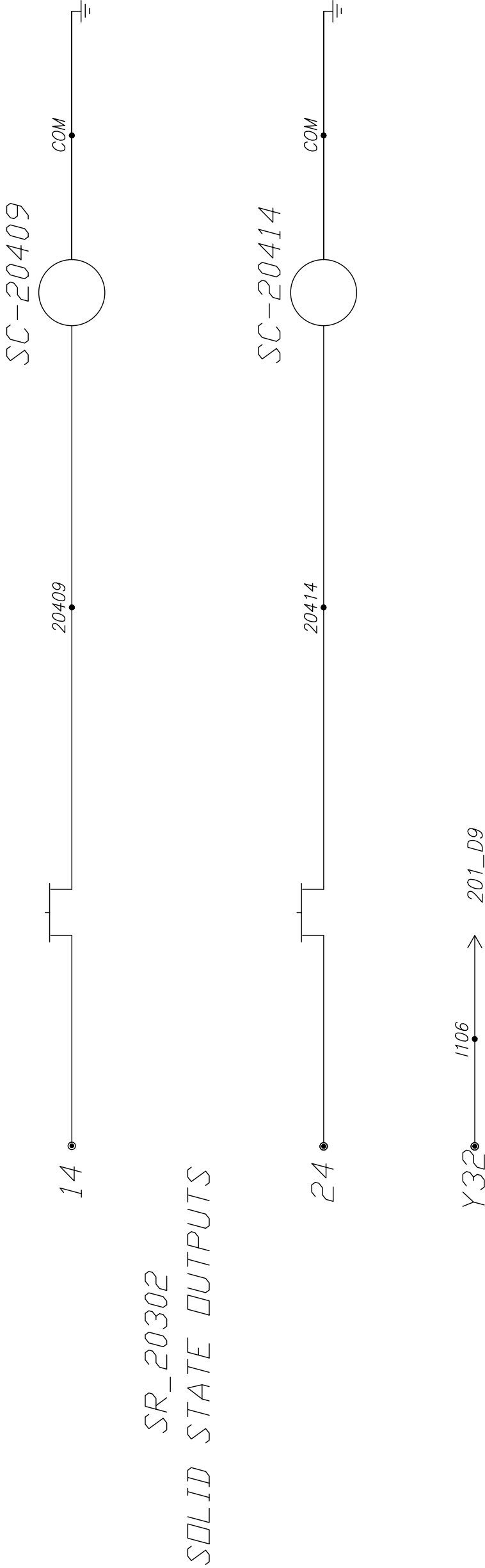
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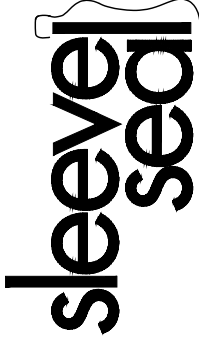
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DRAWN BY:GG

DATE: 8/2020

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LEGEND

POWER TERMINAL, 600V

CONTROL TERMINAL, 600V

FUSE

NUMBERED WIRE

WIRE IN ENCLOSURES

OTHER WIRING

This Product is Listed by
UNDERWRITERS LABORATORIES, INC.
and Bears the Mark:

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Brown/White

RESET LIGHT



COM



203_H15

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NOTES

This Product is Listed by
UNDERWRITERS LABORATORIES, INC.
and Bears the Mark:



LEGEND

- POWER TERMINAL, 600V
- CONTROL TERMINAL, 600V
- FUSE
- NUMBERED WIRE
- WIRE IN ENCLOSURES
- OTHER WIRING

SCALE:NONE

DRAWN BY:GG

DATE: 8/2020 APP.

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TITLE: 700S-SAFETY

SSL-250

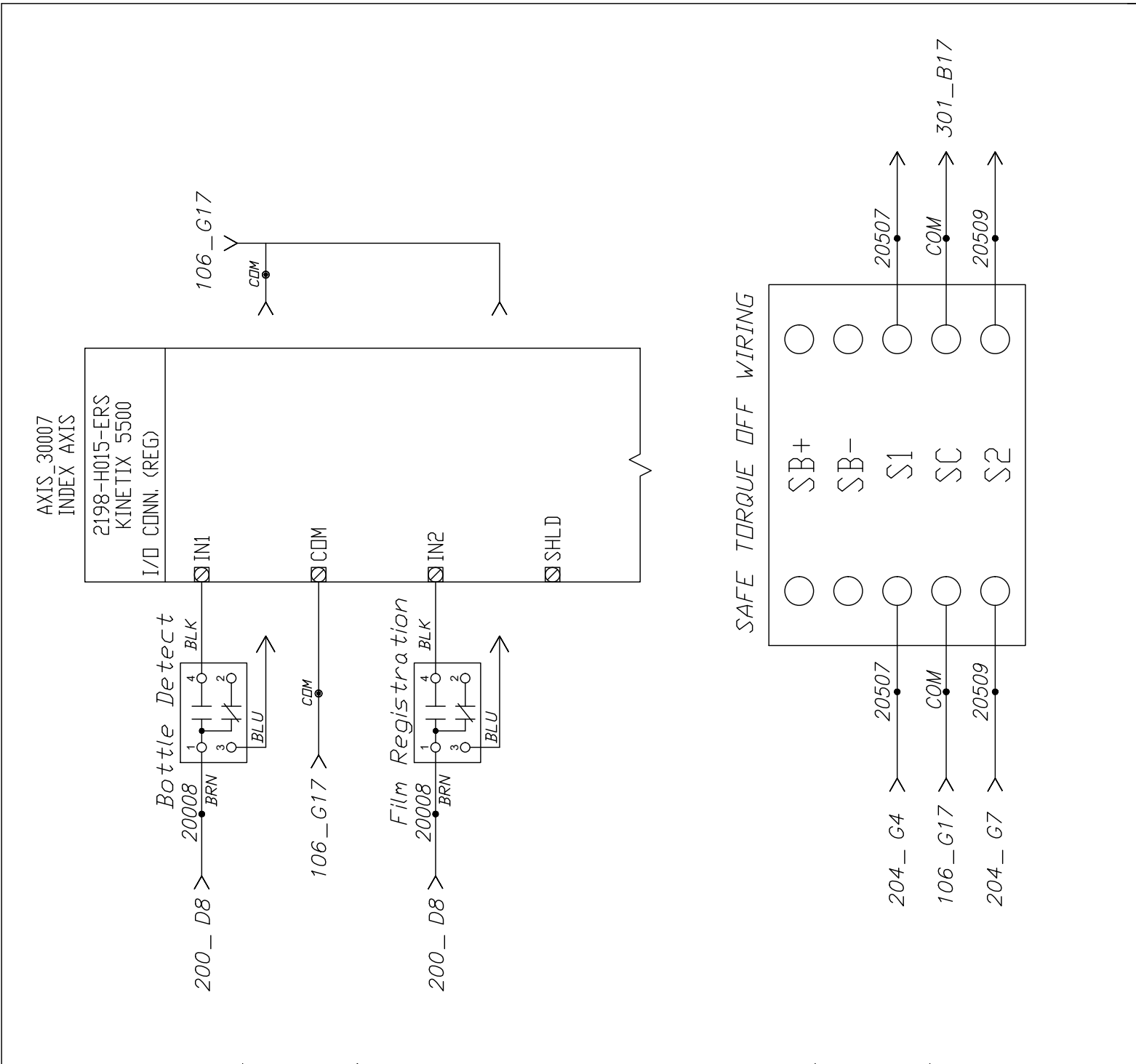
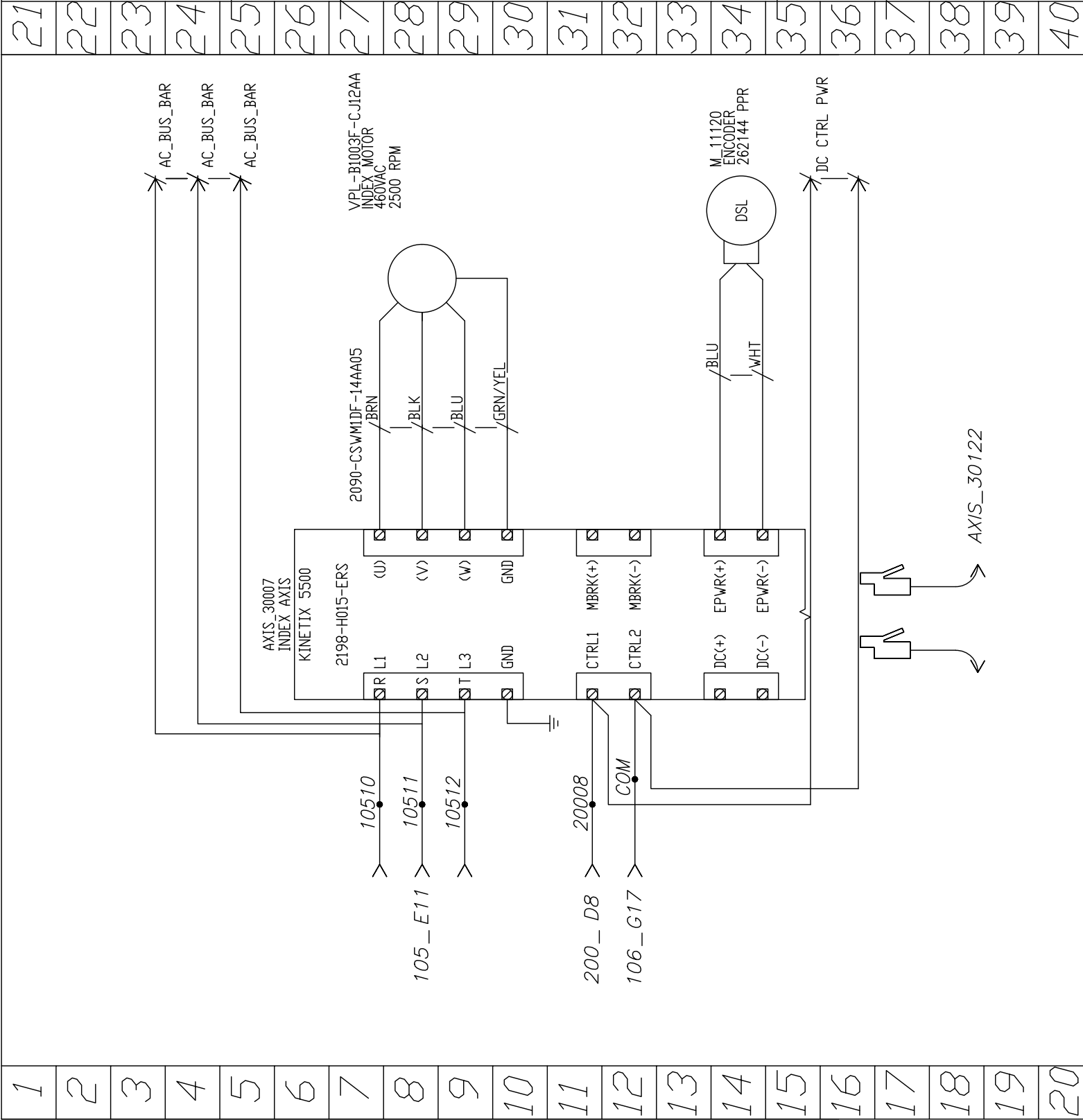
Blue Marble

Indianapolis,IN

JOB# 03141810

PAGE#

205



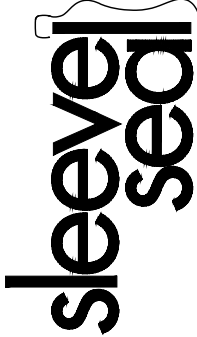
NOTES

1. POWER WIRING IS BROWN, ORANGE, YELLOW

This Product is Listed by
UNDERWRITERS LABORATORIES, INC.
and Bears the Mark:

LEGEND

- POWER TERMINAL, 600V
- CONTROL TERMINAL, 600V
- FUSE
- NUMBERED WIRE
- WIRE IN ENCLOSURES
- OTHER WIRING



SCALE: NONE

DRAWN BY: GG

DATE: 8/2020

APP.

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TITLE:

KINETIX

SSL-250

Blue Marble

Indianapolis, IN

JOB# 03141810

PAGE# 300

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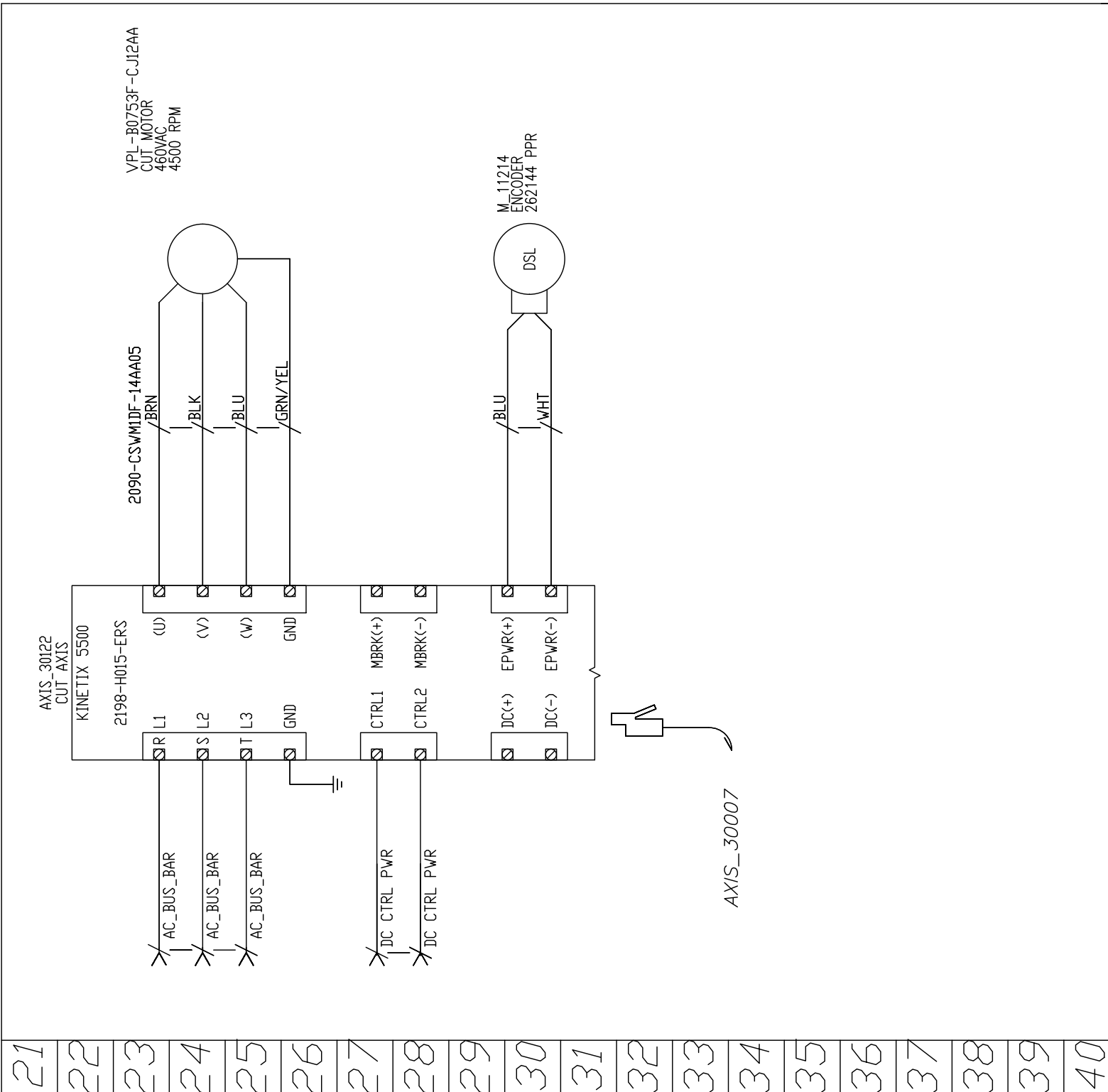
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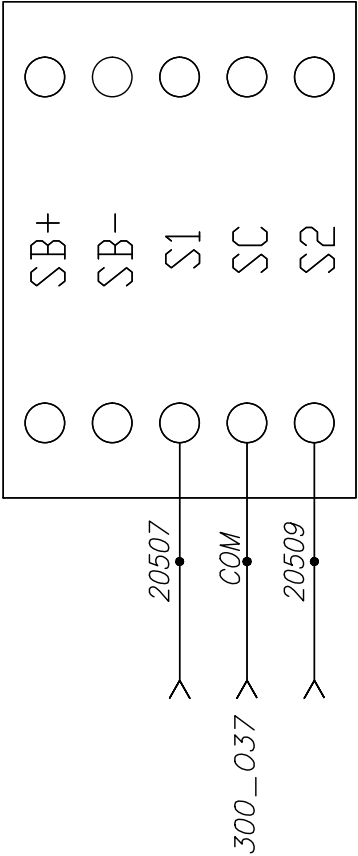
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SAFE TORQUE OFF WIRING



NOTES

1. POWER WIRING IS BROWN,ORANGE,YELLOW

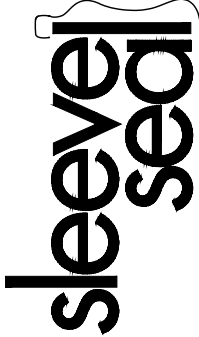
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This Product is Listed by
UNDERWRITERS LABORATORIES, INC.
and Bears the Mark:



LEGEND

- POWER TERMINAL, 600V
- CONTROL TERMINAL, 600V
- FUSE
- NUMBERED WIRE
- WIRE IN ENCLOSURES
- OTHER WIRING



SCALE:NONE

DATE: 8/2020

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TITLE:

KINETIX

SSL-250

Blue Marble

Indianapolis,IN

JOB# 03141810

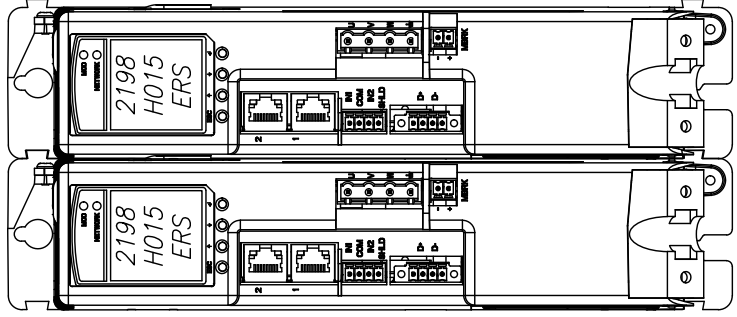
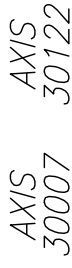
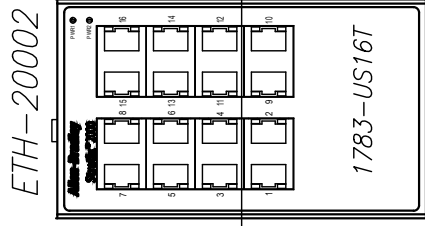
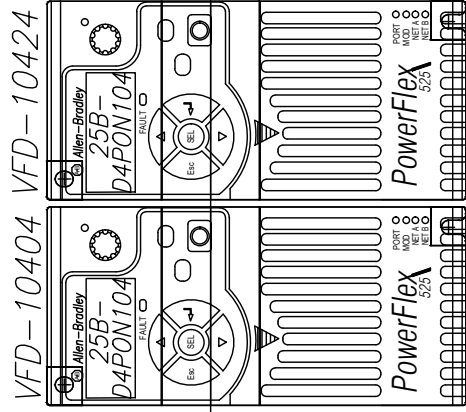
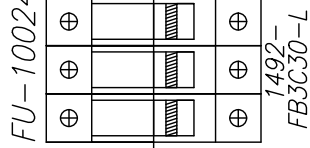
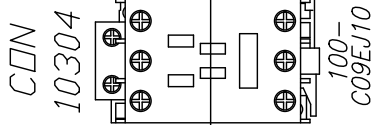
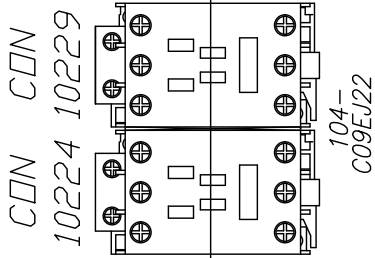
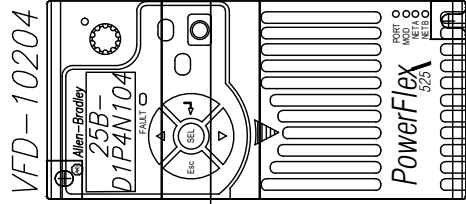
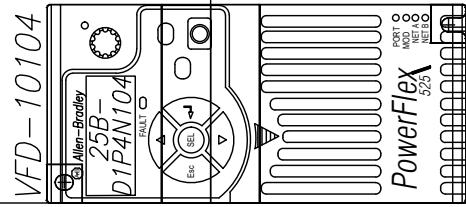
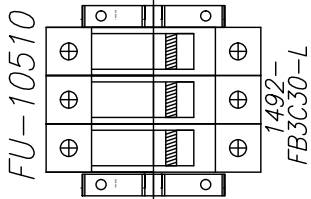
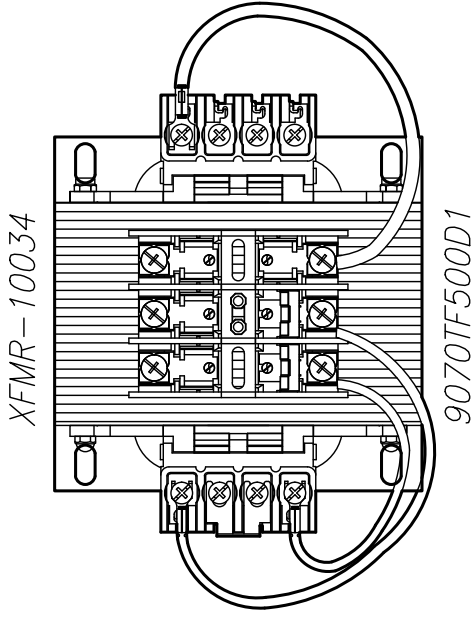
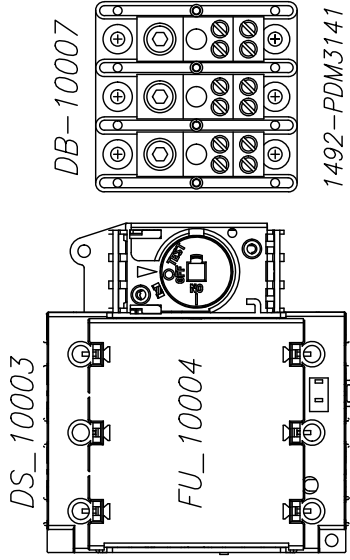
PAGE#

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NOTES					This Product is Listed by UNDERWRITERS LABORATORIES, INC. and Bears the Mark: cUL US		LEGEND POWER TERMINAL, 600V GROUND TERMINAL, 600V CONTROL TERMINAL, 600V FUSED TERMINAL, 300V NUMBERED CONTROL WIRE WIRE IN ENCLOSURES OTHER WIRING		sleeve seal		SCALE: NONE DRAWN BY: GG		TITLE:	
											DATE: --		APP.	
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					JOB# 03141810		PAGE#		MTRL 1					

Item	Qty.	Description	Part #	Manf.
1	1	NEMA 4X DISCONNECT	194R-C30-1753S-PYS2	AB
2	1	XFMR-10010	16768010037	LI-NENG
3	2	3-POLE FUSE HOLDER	1492-FB3C30-L	AB
4	1	2-POLE FUSE HOLDER	1492-FB2C30-L	AB
5	1	1-POLE FUSE HOLDER	1492-FB1C30-L	AB
6	1	PS-10614	1606-XLB240E	AB
7	1	SR-20302	440R-D22S2	AB
8	1	DB-10007	1492-PDM3141	AB
9	1	ETH-20002	1783-US16T	AB
10	3	1/2 HP. VFD <480>	25B-D1P4N104	AB
11	1	2 HP. VFD <480>	25B-D4P0N104	AB
12	1	EB-20000	2905744	PC
13	1	C0N 10224,10229	104-C09EJ22	AB
14	1	C0N-10304	100-C09EJ10	AB
15	1	HMI-20001	2711P-T7C21D8S	AB
16	2	SERVO DRIVE <Axis 30007-30122>	2198-H015-ERS	AB
17	2	SERVO POWER CABLE	2090-CSWM1DF-14AA05	AB
18	1	INDEX MOTOR	VPL-B1003C-PJ12AA	AB
19	1	CUT MOTOR	VPL-B0753F-CJ12AA	AB
20				AB

NOTES	1. 2. 3. 4. 5. This Product is Listed by UNDERWRITERS LABORATORIES, INC. and Bears the Mark: UL US	LEGEND POWER TERMINAL, 600V GROUND TERMINAL, 600V CONTROL TERMINAL, 600V FUSED TERMINAL, 300V NUMBERED CONTROL WIRE WIRE IN ENCLOSURES OTHER WIRING	sleeve seal	SCALE: NONE DRAWN BY: GG		TITLE:	Material SSL-250 Blue Marble Indianapolis, IN JOB# 03141810 PAGE# MTRL2		
				DATE: -- -- APP.					
						This drawing is the property of Sleeve Seal, LLC Inc. It is loaned upon the express condition that it shall not be copied or reproduced in any manner, that it shall not be submitted to others for examination without the consent of this company, that it shall not be used in any other way detrimental to the interest of Sleeve Seal LLC Inc., and that it shall be returned upon demand.			
				Item	Qty.	Description		Part #	Manf.
				1	2	DOOR SWITCHES		440N-Z21SS3PH	AB
				2	2	SAFETY CONTACTORS		700S-CF530EJC	AB
				3	1	ENCLOSURE		8017603	RITTAL
				4	1	TRANSFORMER		9070TF500D1	SQUARED
				5	1	PLC		5069-L306ERM	AB
				6	1	INPUT MODULE		5069-IB16	AB
				7	1	OUTPUT MODULE		5069-OB16	AB
				8	1	RFID CARD READER		RDR-805W1AKB-P	RFIDEAS
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NOTES

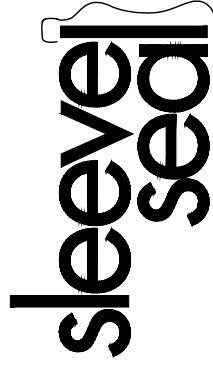
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*This Product is Listed by
UNDERWRITERS LABORATORIES, INC.
and Bears the Mark:*



LEGEND

	POWER TERMINAL, 600V
	GROUND TERMINAL, 600V
	CONTROL TERMINAL, 600V
	FUSED TERMINAL, 300V
	NUMBERED CONTROL WIRE
	WIRE IN ENCLOSURES
	OTHER WIRING



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SCALE: NONE	DRAWN BY: GG
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TITLE:

DATE: -- --	APP.
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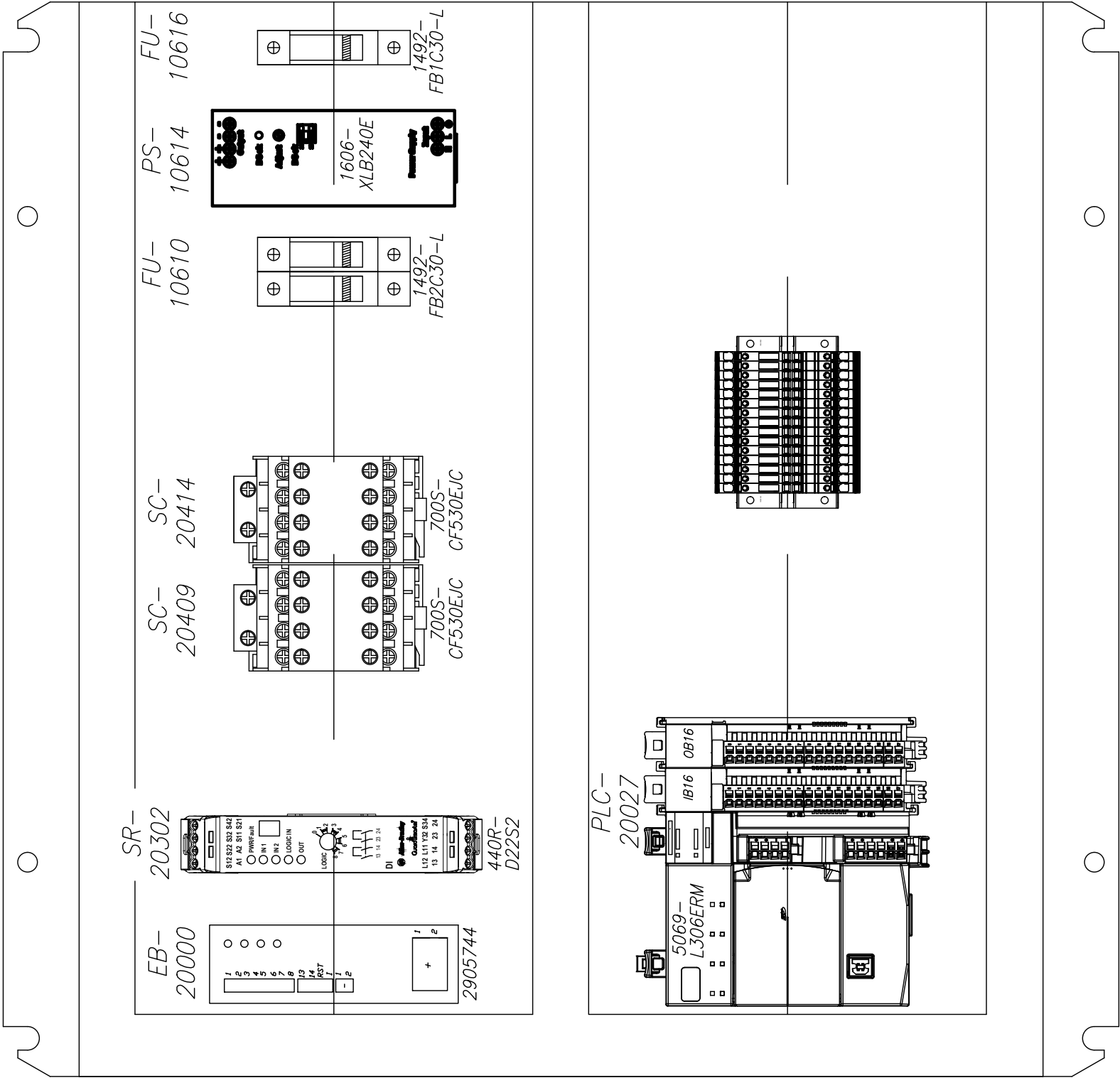
HV PAVEL

SS1-250

Blue Marble

Indianapolis, IN

JOB# 03141810	PAGE# PNL1
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NOTES

This Product is Listed by
UNDERWRITERS LABORATORIES, INC.
and Bears the Mark:



LEGEND

- POWER TERMINAL, 600V
- GROUND TERMINAL, 600V
- CONTROL TERMINAL, 600V
- FUSED TERMINAL, 300V
- NUMBERED CONTROL WIRE
- WIRE IN ENCLOSURES
- OTHER WIRING

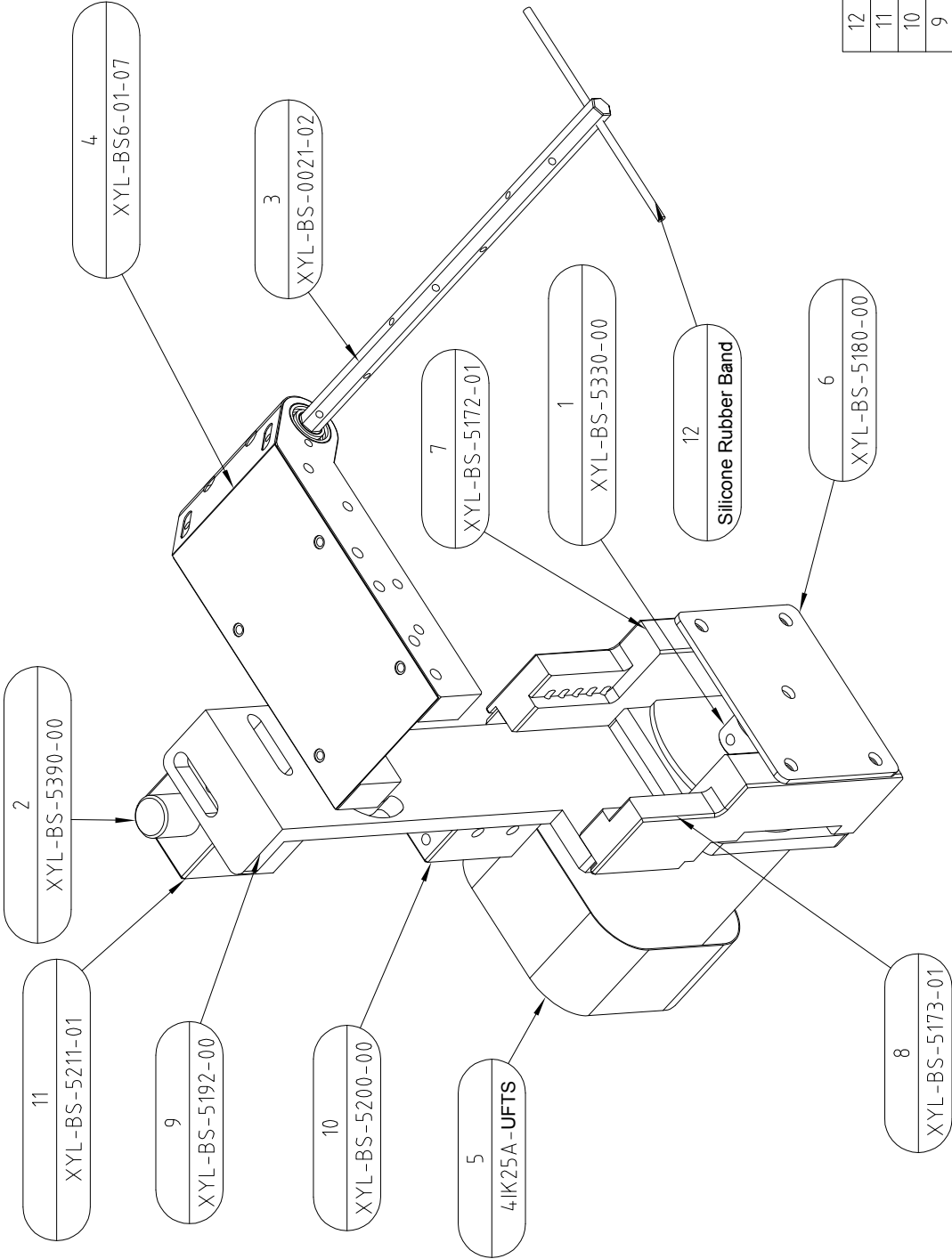


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TITLE:

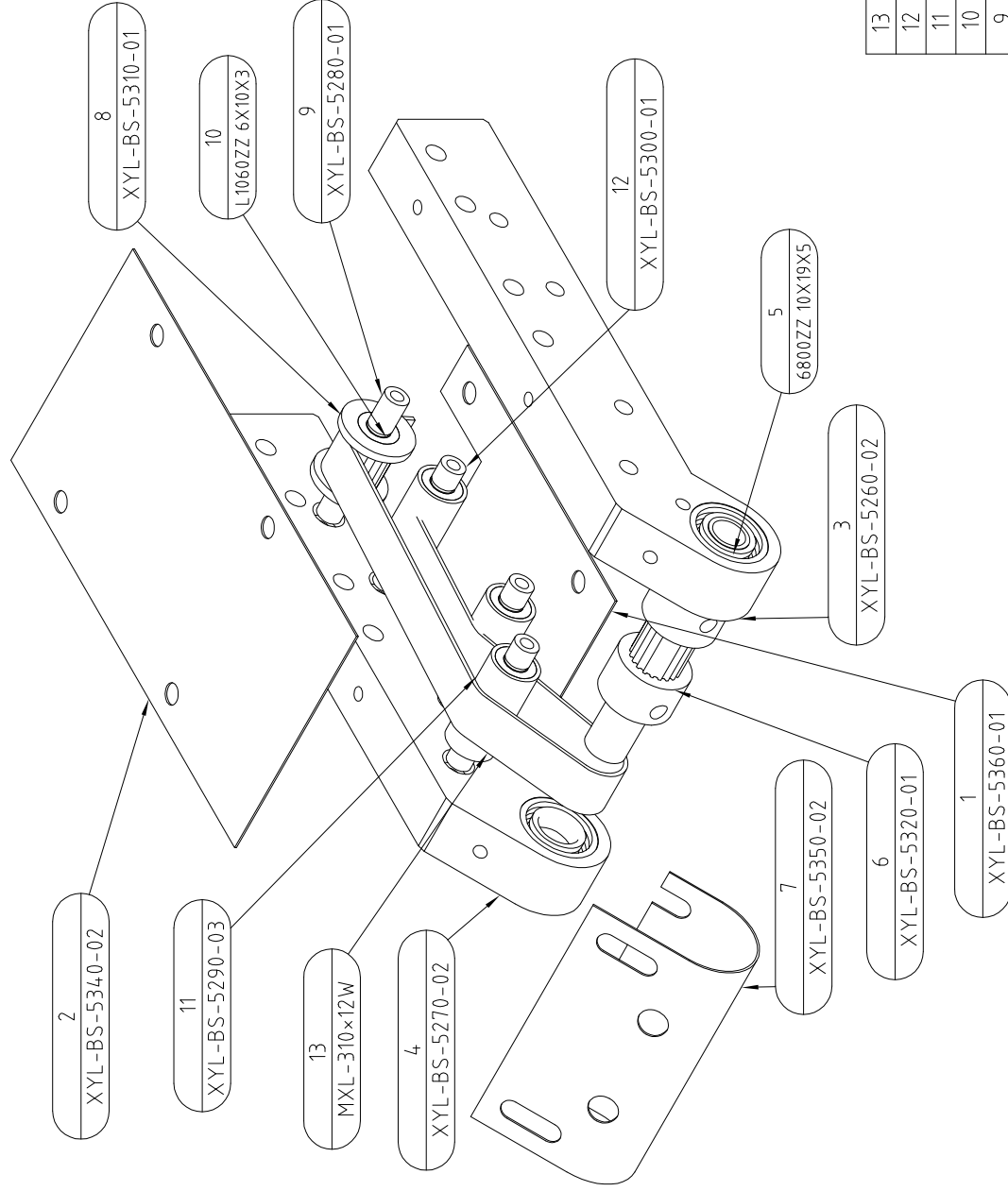
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LV PANEL
SSL-250
RITTAL
8017600

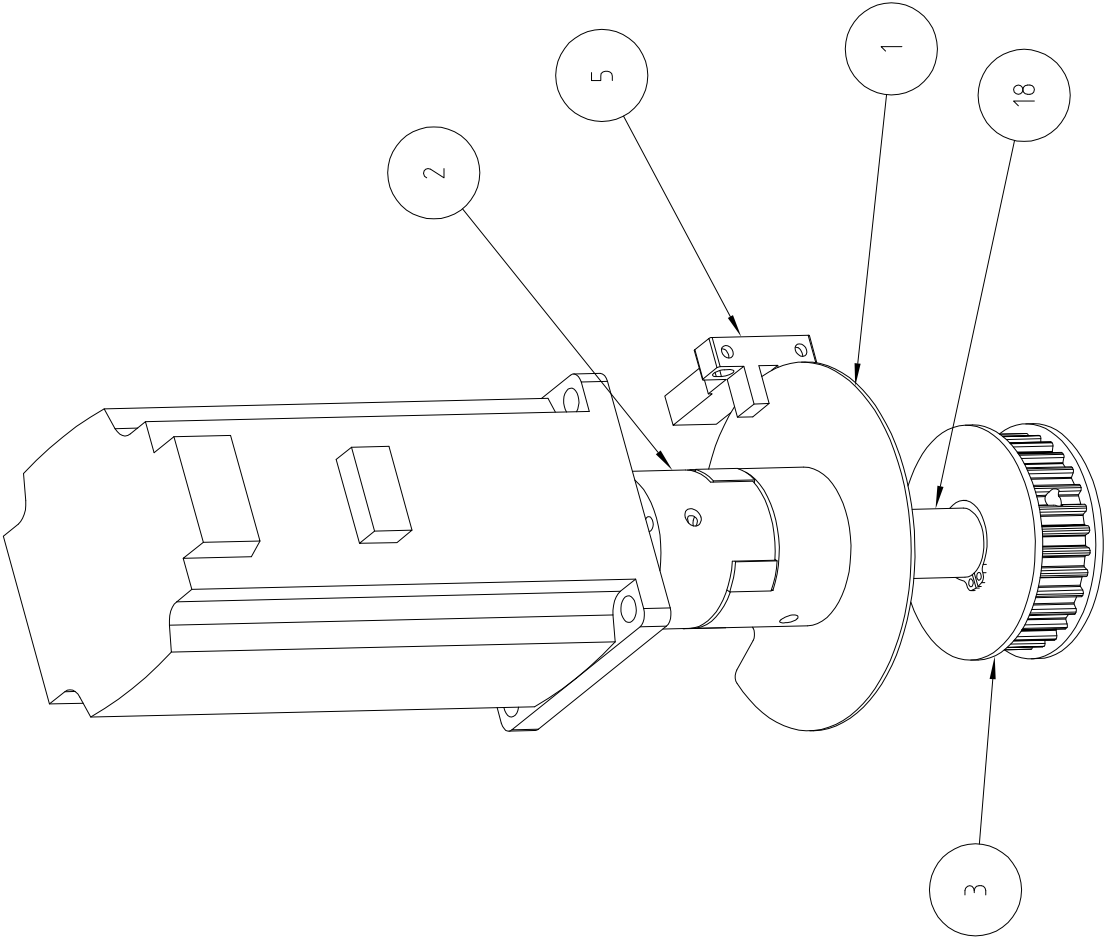


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11	XYL-BS-5211-01	130075211401	1
10	XYL-BS-5200-00	130075200400	1
9	XYL-BS-5192-00	132075192400	1
8	XYL-BS-5173-01	130075173401	1
7	XYL-BS-5172-01	130075172401	1
6	XYL-BS-5180-00	132075180400	1
5	4IK25A-UFTS	16760140008	1
4	XYL-BS6-01-07	Machine Module	1
3	XYL-BS-0021-02	132070021402	1
2	XYL-BS-5390-00	132075390400	1
1	XYL-BS-5330-00	130075330400	1

Brush Section

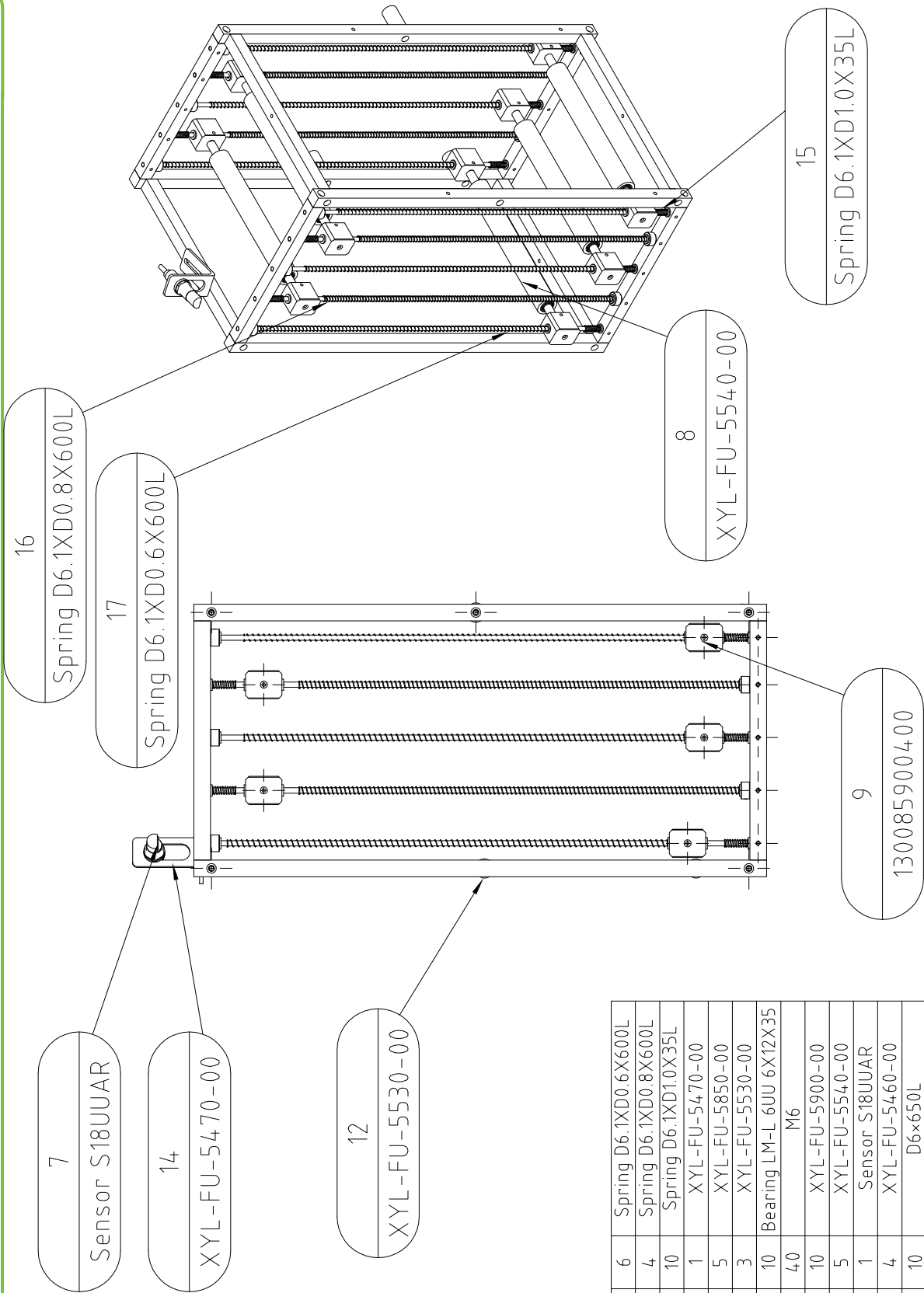


REF #	Specifics	Part Number	QTY
13	MXL-310-12W	16640030001	1
12	XYL-BS-5300-01	132075300401	3
11	XYL-BS-5290-03	133075290403	3
10	L1060ZZ 6X10X3	16641180009	8
9	XYL-BS-5280-01	132075280401	1
8	XYL-BS-5310-01	132075310401	1
7	XYL-BS-5350-02	132075350402	1
6	XYL-BS-5320-01	132075320401	1
5	6800ZZ 10X19X5	16641000029	4
4	XYL-BS-5270-02	130075270402	1
3	XYL-BS-5260-02	130075260402	1
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1	XYL-BS-5360-01	132075360401	1



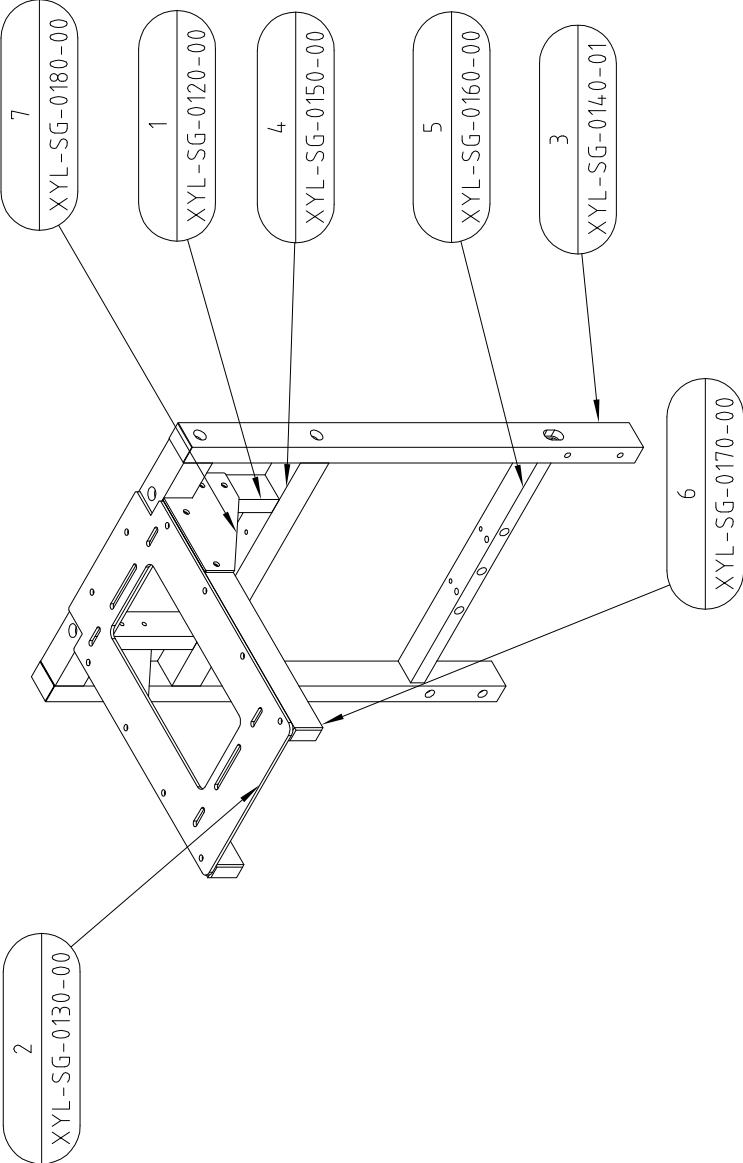
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REF #	QTY	Specifcs	Part Number

Dancer Assembly



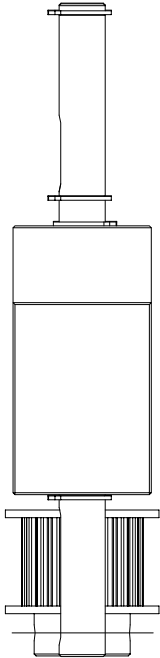
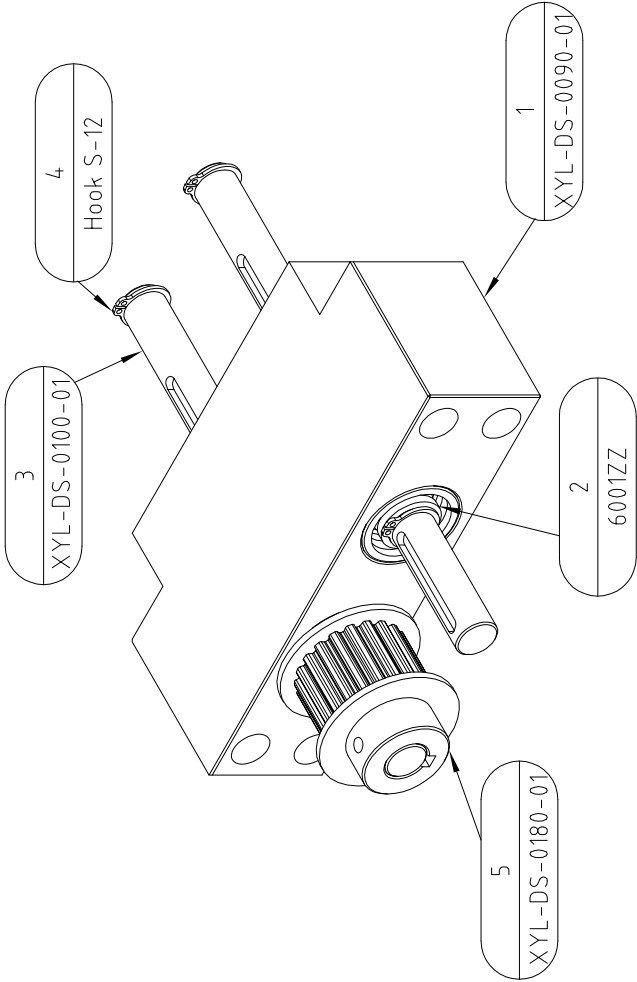
Part Number	REF #	QTY	Specifics
16648010013	17	6	Spring D6.1XD0.6X600L
16648010019	16	4	Spring D6.1XD0.8X600L
16648010021	15	10	Spring D6.1XD1.0X35L
132085470400	14	1	XYL-FU-5470-00
132085850400	13	5	XYL-FU-5850-00
132085530400	12	3	XYL-FU-5530-00
16641020007	11	10	Bearing LM-L 6UU 6X12X35
B0300080	10	40	M6
130085900400	9	10	XYL-FU-5900-00
133085540400	8	5	XYL-FU-5540-00
16762040001	7	1	Sensor S18UUAR
130085460000	6	4	XYL-FU-5460-00
B0700013	5	10	D6x650L
130085780400	4	2	XYL-FU-5870-00
130085890400	3	4	XYL-FU-5890-00
130085820400	2	1	XYL-FU-5820-00
16641000030	1	20	6801ZZ 12X21X5

Dancer Support

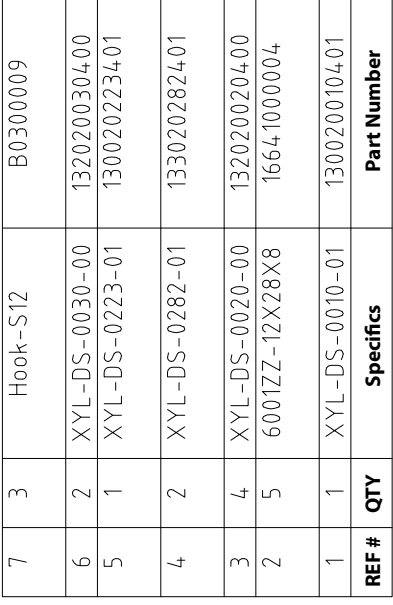


REF #	QTY	Specifics	Part Number
7	2	XYL-SG-0180-01	131120180401
6	2	XYL-SG-0170-00	130120170400
5	1	XYL-SG-0160-00	130120160400
4	2	XYL-SG-0150-01	130120150401
3	2	XYL-SG-0140-01	130120140001
2	1	XYL-SG-0130-00	131120130400
1	2	XYL-SG-0120-01	130120120401
REF # QTY Specifics			Part Number

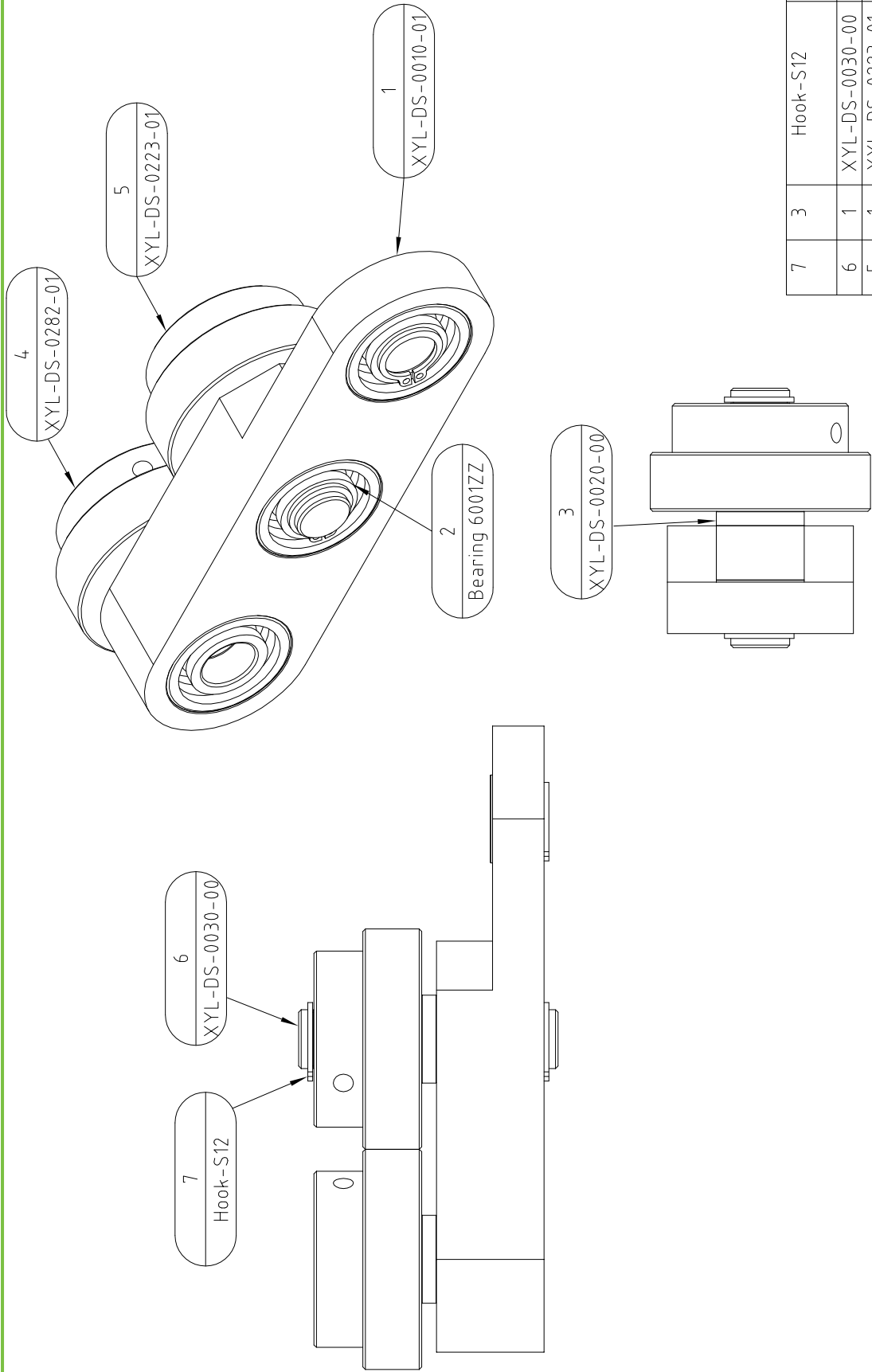
Drive Section 2



5	1	XYL-DS-0180-01	130020180001
4	8	Hook-S12	B0300009
3	2	XYL-DS-0100-01	132020100401
2	4	6001ZZ-12X28X8	16641000004
1	1	XYL-DS-0090-01	130020090401
REF #	QTY	Specifics	Part Number

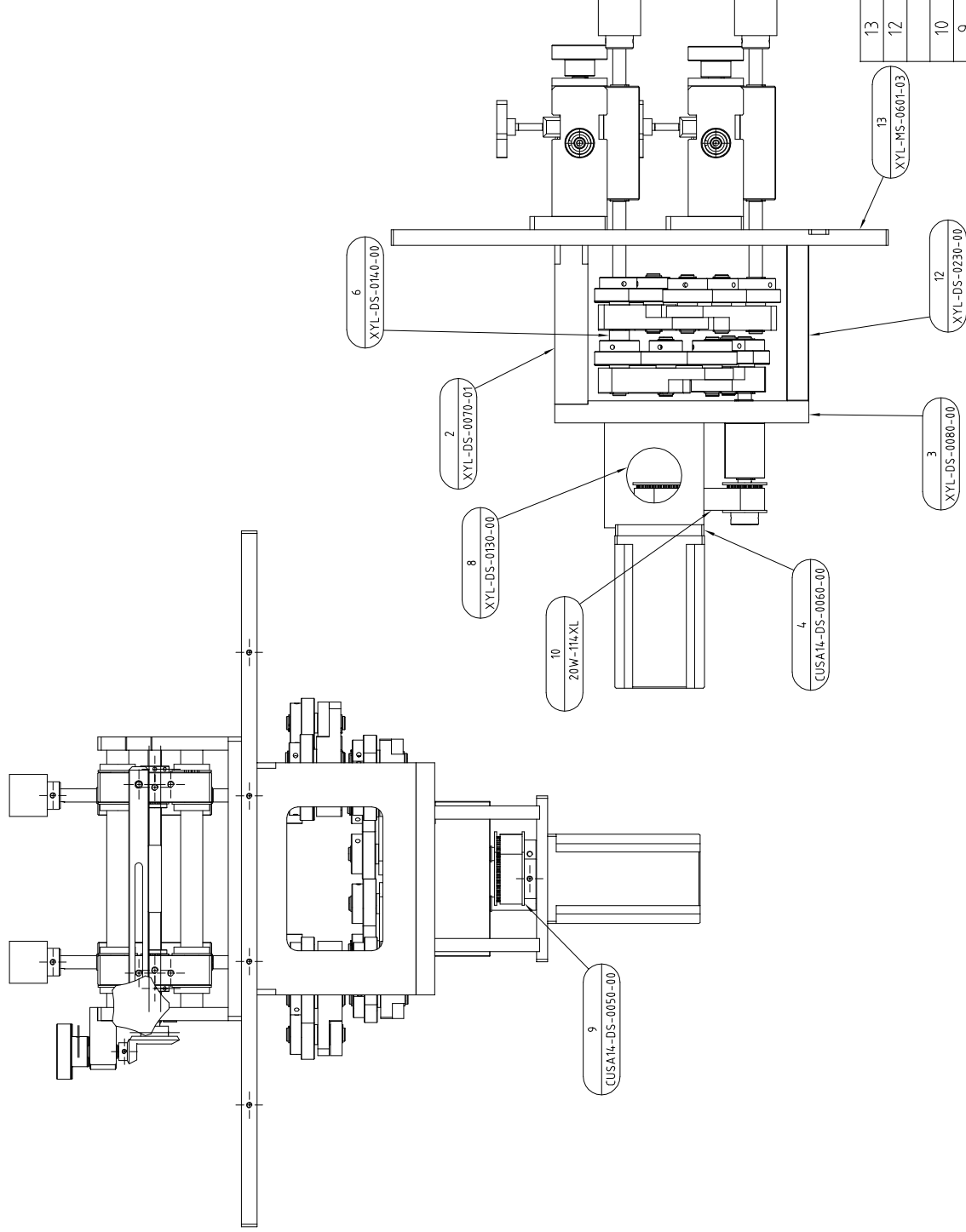


Drive Section 4



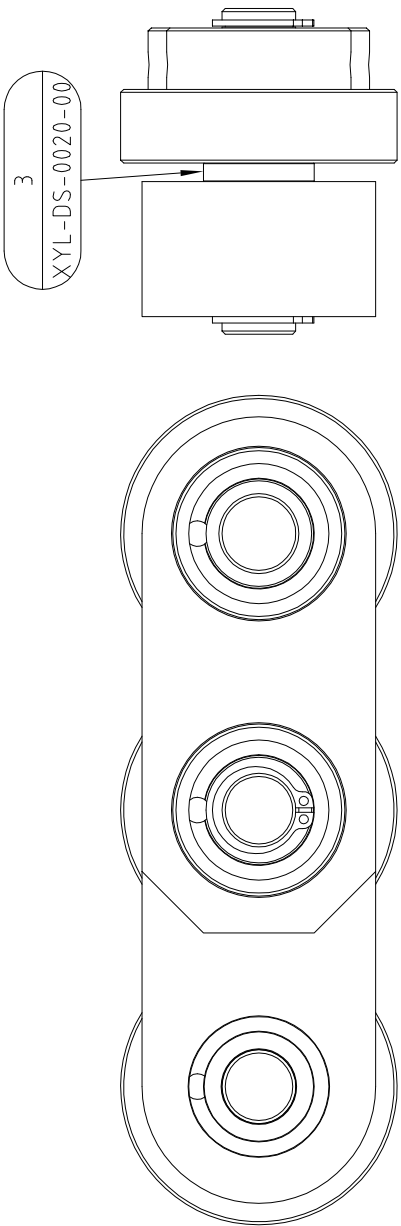
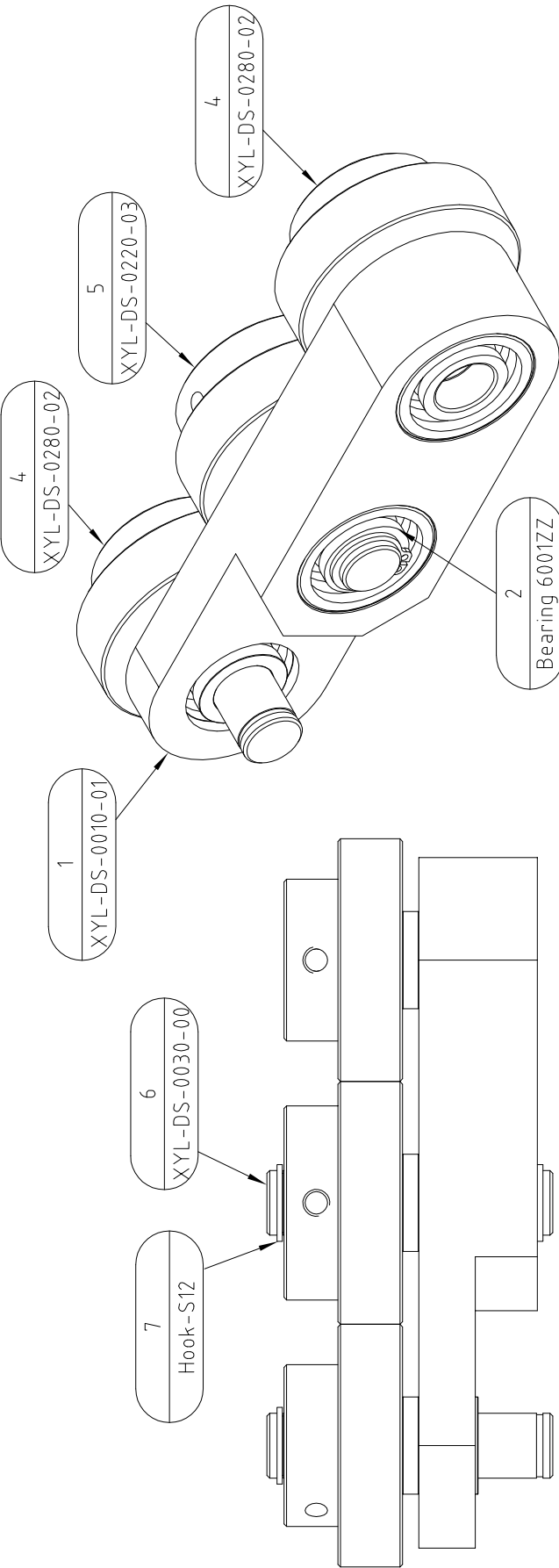
REF #	QTY	Specifics	Part Number
7	3	Hook-S12	B0300009
6	1	XYL-DS-0030-00	132020030400
5	1	XYL-DS-0223-01	130020223401
4	1	XYL-DS-0282-01	133020282401
3	3	XYL-DS-0020-00	132020020400
2	5	6001ZZ-12X28X8	16641000004
1	1	XYL-DS-0010-01	130020010401

Drive Section 5

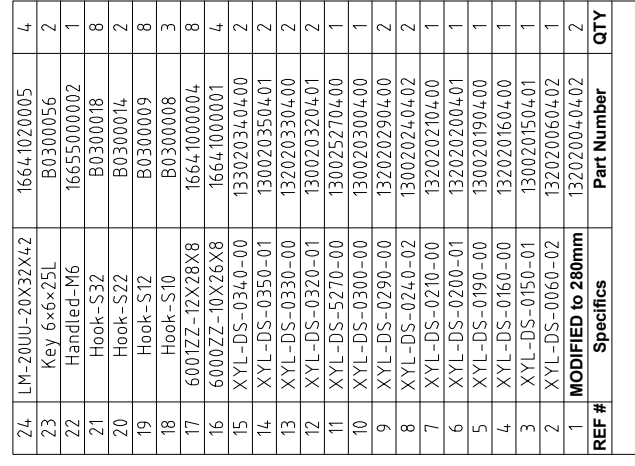


REF #	Specifcs	Part Number	QTY
13	XYL-MS-0601-03	1300106014.03	1
12	XYL-DS-0230-00	1300202304.00	2
10	20W-114XL	1664.0010005	1
9	CUSA14-DS-0050-00	1300200502A14	1
8	XYL-DS-0130-00	1300201304.00	2
6	XYL-DS-0140-00	1320201404.00	2
4	CUSA14-DS-0060-00	1300200602A14	1
3	XYL-DS-0080-00	1300200804.00	1
2	XYL-DS-0070-01	1300200704.01	1

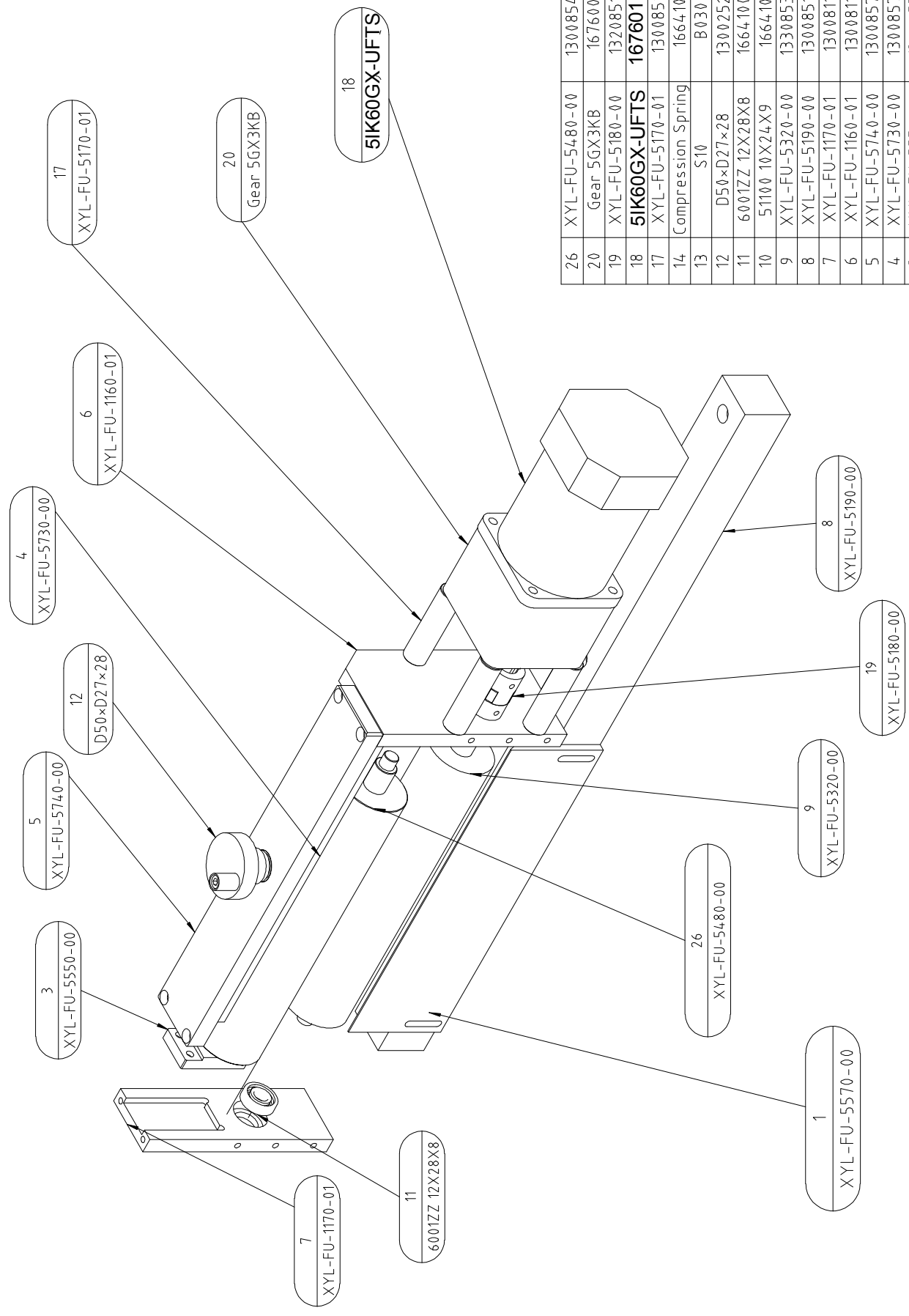
Drive Section 6



REF #	QTY	Specifics	Part Number
7	3	Hook-S12	B0300009
6	2	XYL-DS-0030-00	132020030400
5	1	XYL-DS-0220-03	130020220403
4	2	XYL-DS-0280-02	133020280402
3	4	XYL-DS-0020-00	132020020400
2	5	6001ZZ-12X28X8	16641000004
1	1	XYL-DS-0010-01	130020010401

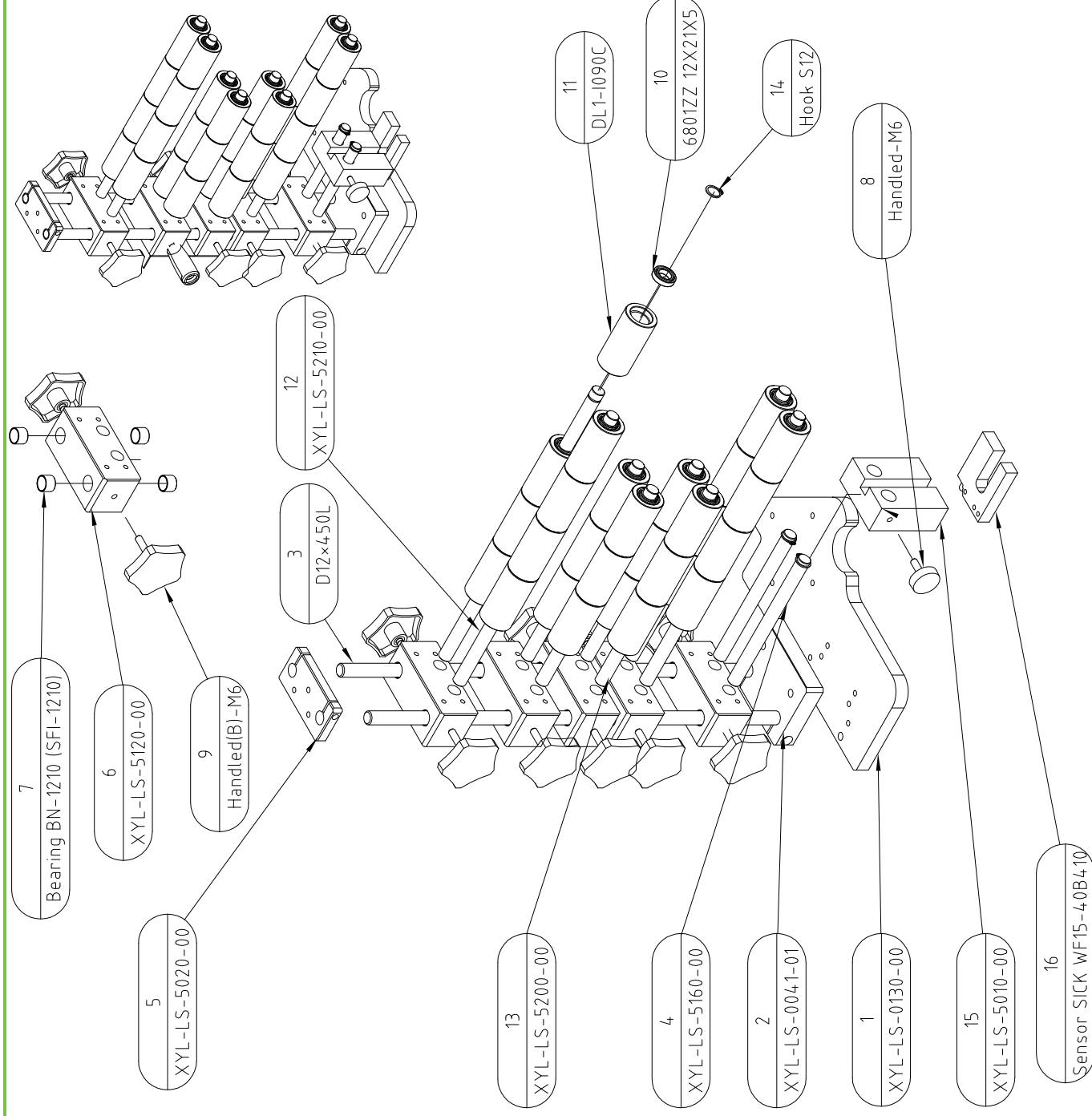


Feed Motor



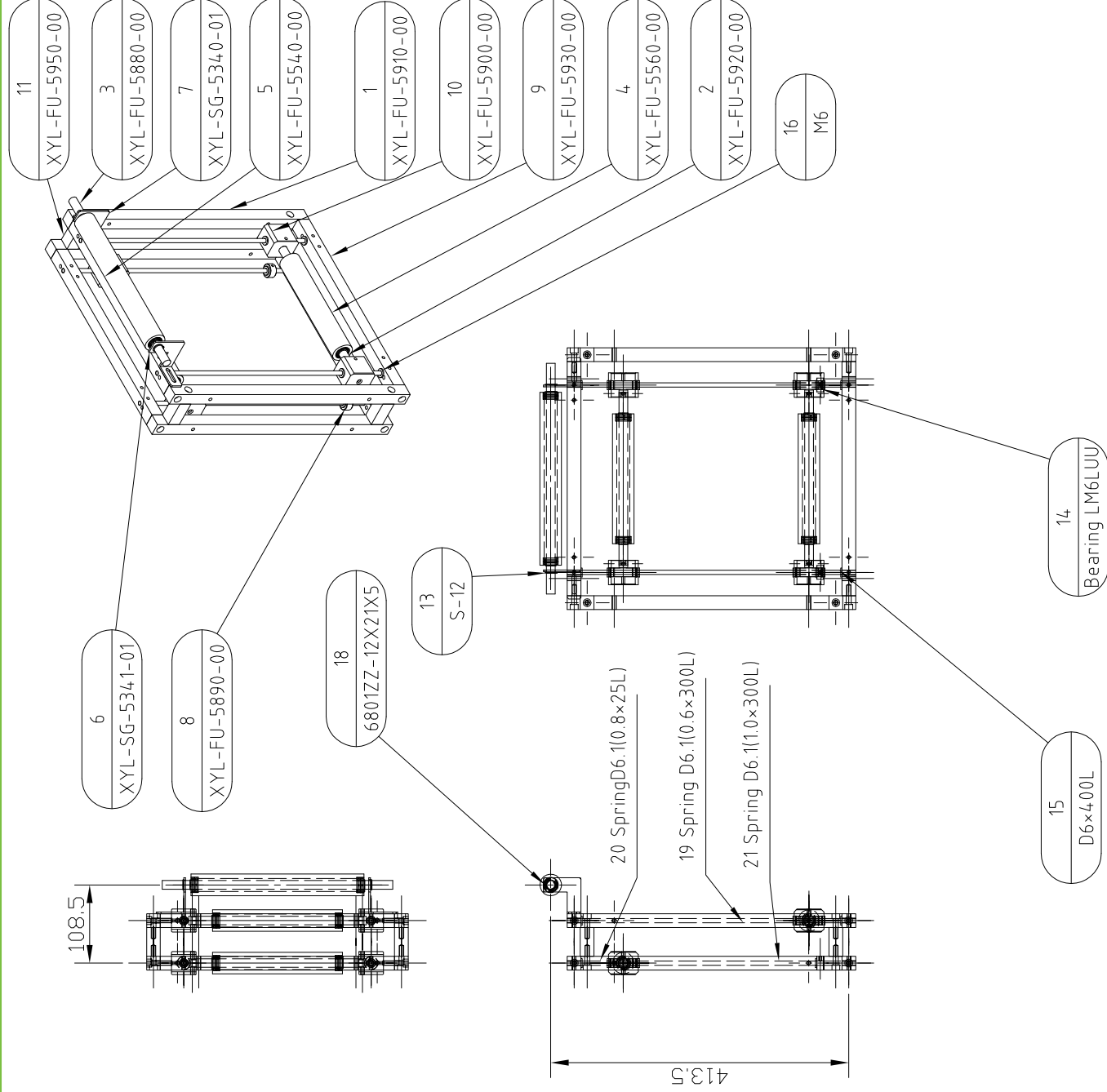
REF #	Specifics	Part Number	QTY
26	XYL-FU-5480-00	130085480400	1
20	Gear 5GX3KB	16760050013	1
19	XYL-FU-5180-00	132085180400	1
18	5IK60GX-UFTS	16760150050	1
17	XYL-FU-5170-01	130085170401	4
14	Compression Spring	16641010001	6
13	S10	B0300008	1
12	D50xD27x28	130025270400	1
11	6001ZZ 12X28X8	166410000003	4
10	51100 10X24X9	16641010001	2
9	XYL-FU-5320-00	133085320400	1
8	XYL-FU-5190-00	130085190400	1
7	XYL-FU-1170-01	130081170401	1
6	XYL-FU-1160-01	130081160401	1
5	XYL-FU-5740-00	130085740400	1
4	XYL-FU-5730-00	130085730400	1
3	XYL-FU-5550-00	130085550400	2
2	XYL-FU-5650-00	132085650400	1
1	XYL-FU-5570-00	130085570400	1

Label Sensor

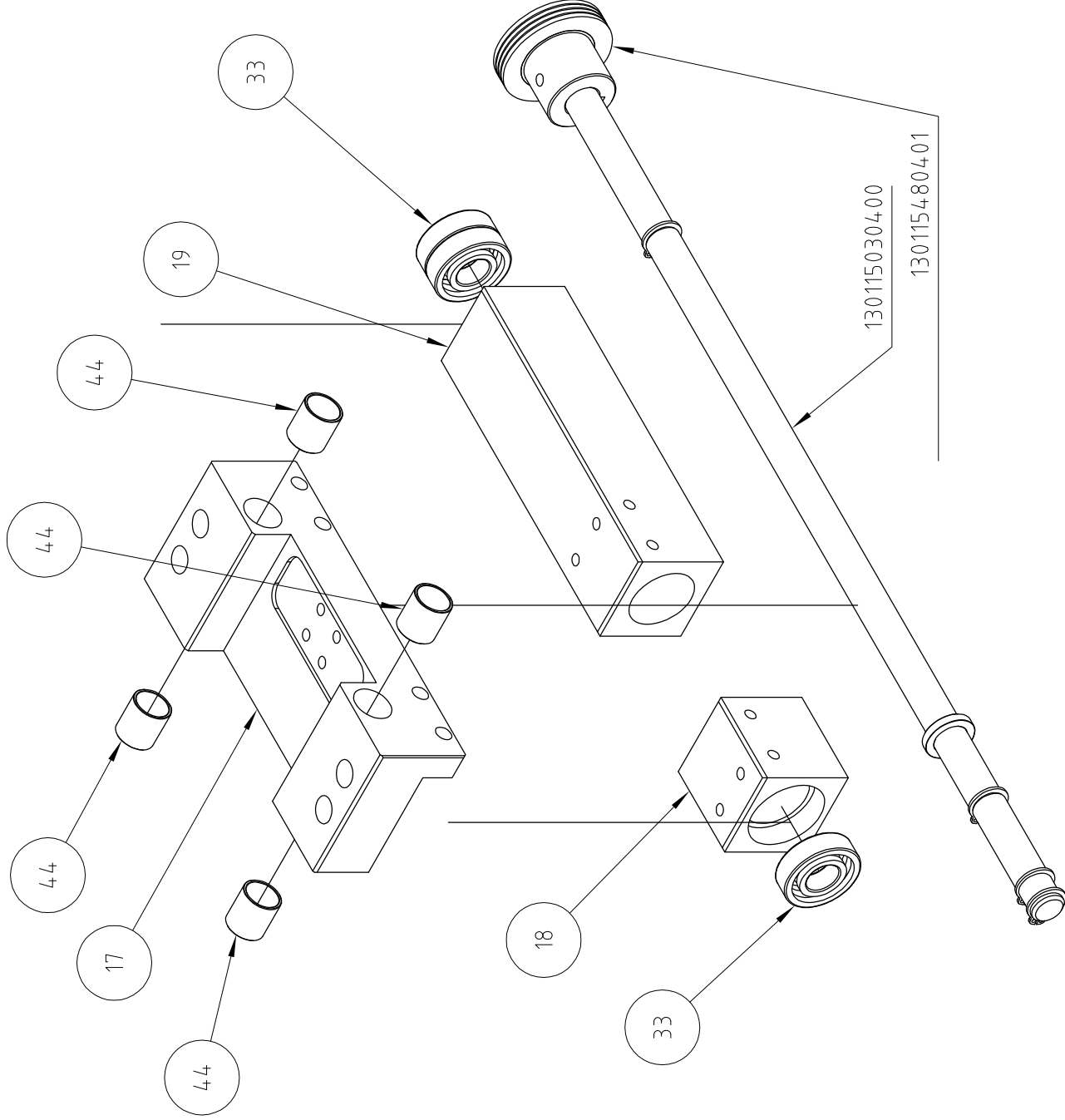


REF #	QTY	Specifics	Part Number
16	1	Sensor SICK WF15-40B410	16762050001
15	1	XYL-LS-5010-00	130065010000
14	18	Hook S12	B03000009
13	4	XYL-LS-5200-00	132065200000
12	4	XYL-LS-5210-00	132065210400
11	28	XYL-LS-5110-00	133065110400
10	56	6801ZZ 12X21X5	16641000030
9	10	Handled(B)-M6	16655000002
8	1	Handled-M6	16655000003
7	24	Bearing BN-1210 (SFI-1210)	16641140001
6	5	XYL-LS-5120-00	130065120400
5	1	XYL-LS-5020-00	130065020400
4	2	XYL-LS-5160-00	132065160400
3	2	D12x450L	B07000029
2	1	XYL-LS-0041-01	130060041401
1	1	XYL-LS-0130-00	130060130000

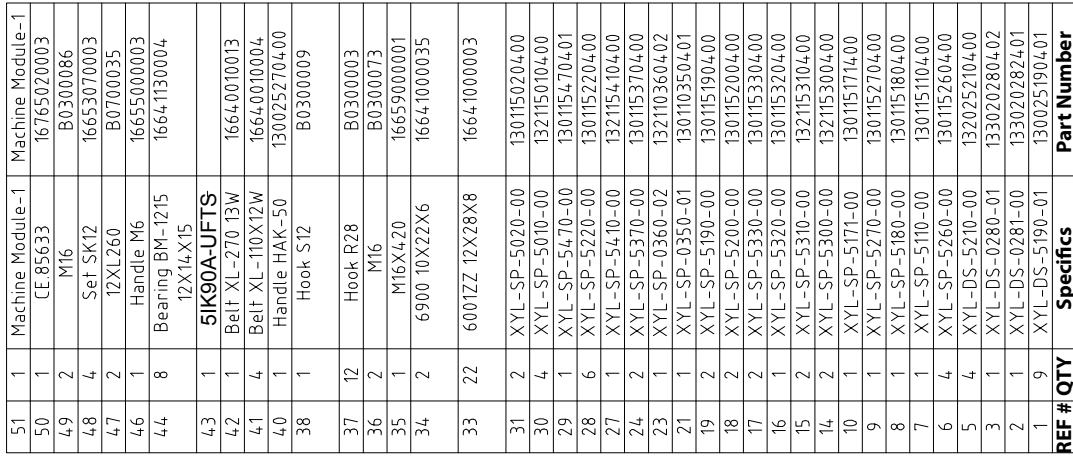
Sleeve Guider

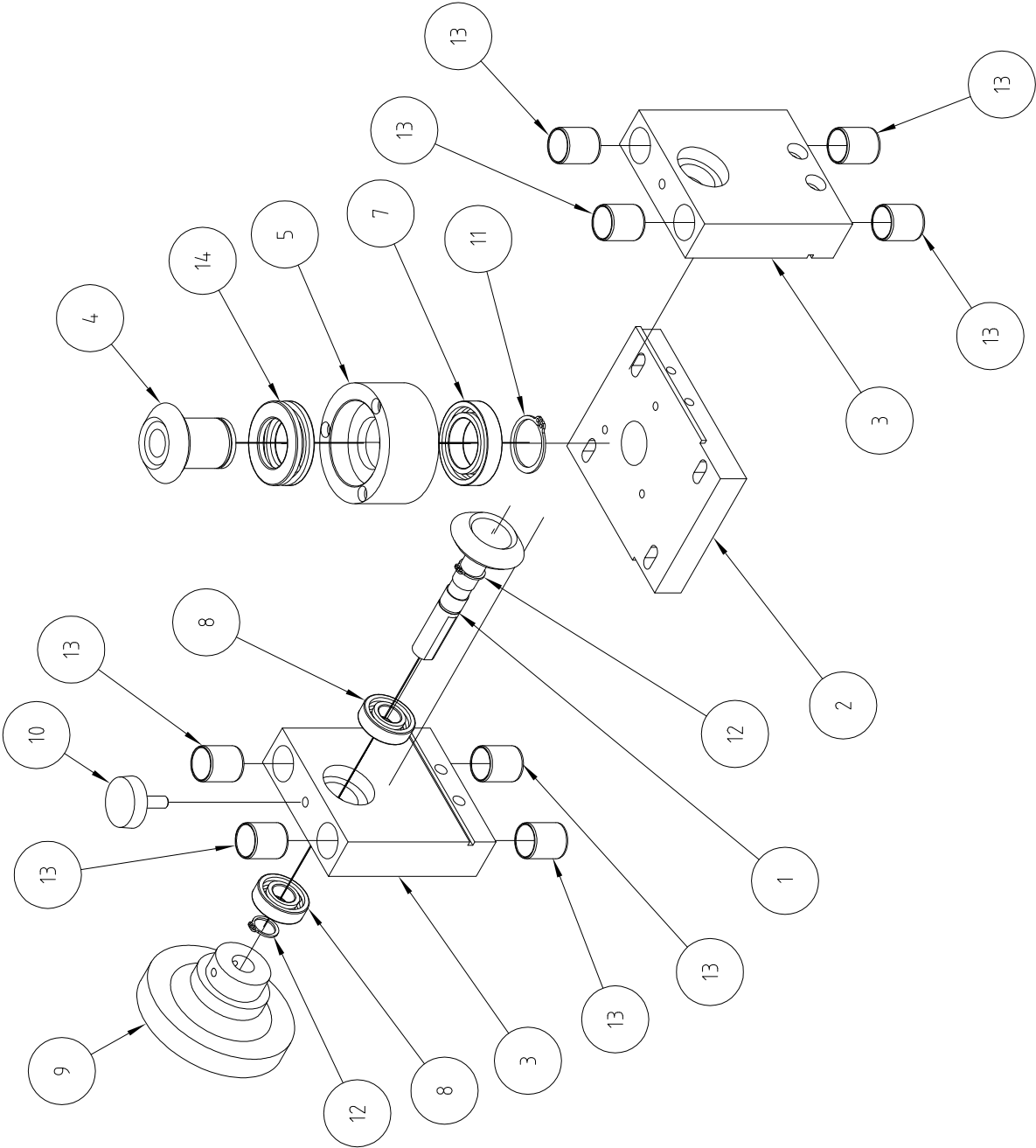


Sleeve Propellant - 2

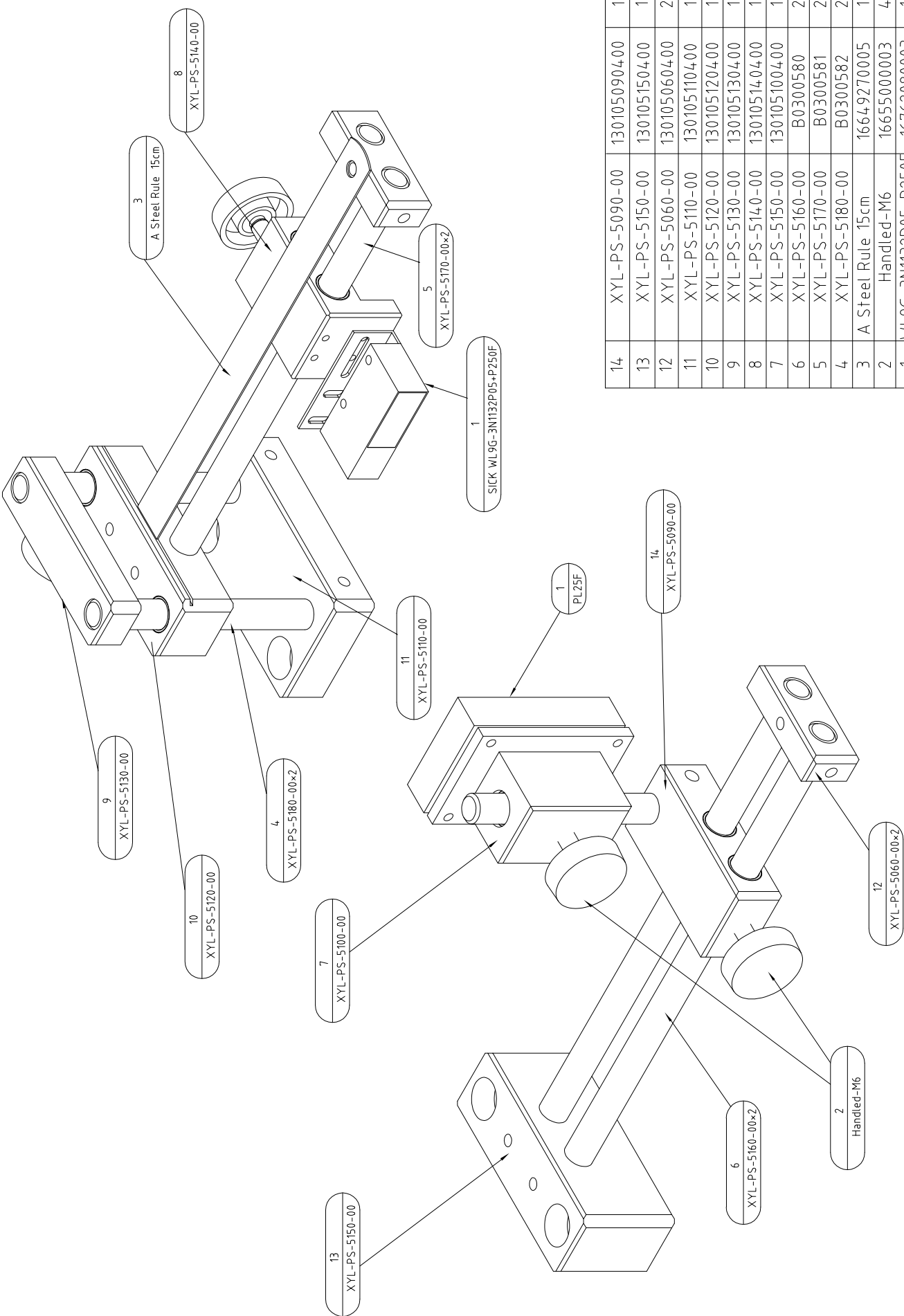


REF #	Specifics	Part Number	QTY
51	XYL-SP0-10-00	Sub Module	1
50	CE.85633	16765020003	1
49	Nut M16	B0300086	2
48	Set SK12	16653070003	4
47	12XL260	B0700035	2
46	Handle M6	16655000003	1
44	BM-1215 12X14X15	16641130004	8
43	Motor 5IK90A-SF	16760150024	1
42	Belt XL-270 13W	16640010013	1
41	Belt XL-110X12W	16640010004	4
40	Handle HAK-50	130025270400	1
38	Hook S-10	16644010002	1
37	Hook R-28	B0300003	12
36	M16	B0300073	2
35	M16X420	16659000001	1
34	6900 10X22X6	16641000035	2
33	6001ZZ 12X28X8	16641000003	22
31	XYL-SP-5020-00	130115020400	2
30	XYL-SP-5010-00	132115010400	4
29	XYL-SP-5470-01	130115470401	1
28	XYL-SP-5220-00	130115220400	6
27	XYL-SP-5410-00	132115410400	1
24	XYL-SP-5370-00	130115370400	2
23	XYL-SP-0360-03	132110360403	1
21	XYL-SP-0350-01	130110350401	1
19	XYL-SP-5190-00	130115190400	2
18	XYL-SP-5200-00	130115200400	2
17	XYL-SP-5330-00	130115330400	2
16	XYL-SP-5320-00	130115320400	1
15	XYL-SP-5310-00	132115310400	2
14	XYL-SP-5300-00	132115300400	2
10	XYL-SP-5170-00	130115170400	1
9	XYL-SP-5270-00	130115270400	1
8	XYL-SP-5180-00	130115180400	1
7	XYL-SP-5110-01	130115110401	1
6	XYL-SP-5260-00	130115260400	4
5	XYL-DS-5210-00	132025210400	4
3	XYL-DS-0280-02	133020280402	1
2	XYL-DS-0282-01	133020282401	1
1	XYL-DS-5190-01	130025190401	9



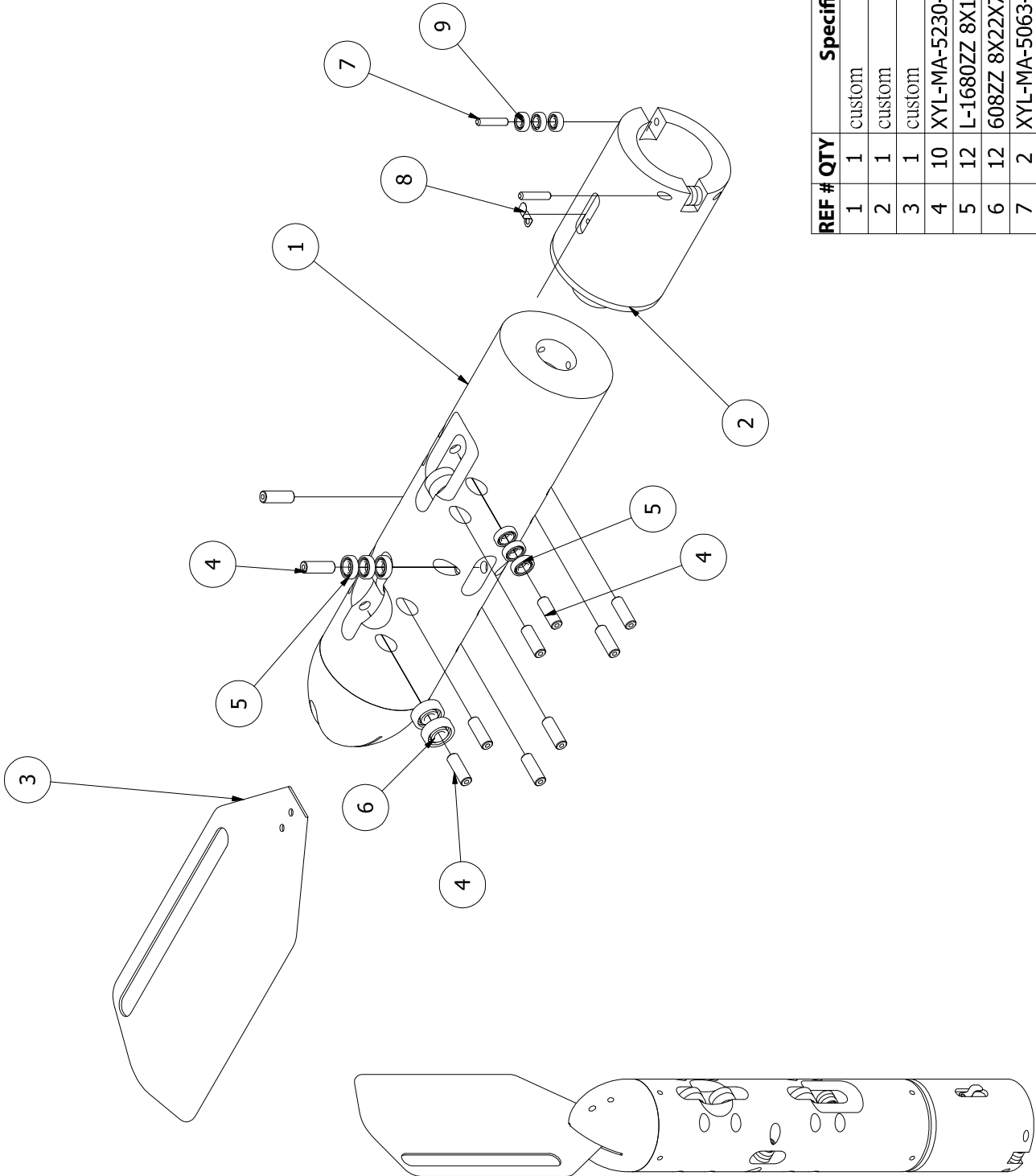


REF #	Specifics	Part Number	QTY
14	51105 25X42X11	16641010006	1
13	Bearing Sleeve BM-1620 16X18X20	16641130006	8
12	Clip S-12	16644010003	2
11	Clip S-25	16644010010	1
10	Handle M6	16655000003	1
9	Handle KRA1(80X12)	16655000006	1
8	6001ZZ-12X28X8	16641000003	2
7	6905ZZ 25X42X9	16641000041	1
5	XYL-SP-5070-00	130115070400	1
4	XYL-SP-5060-00	132115060400	1
3	XYL-SP-5100-01	130115100401	2
2	XYL-SP-5080-01	130115080001	1
1	XYL-SP-5090-02	132115090402	1



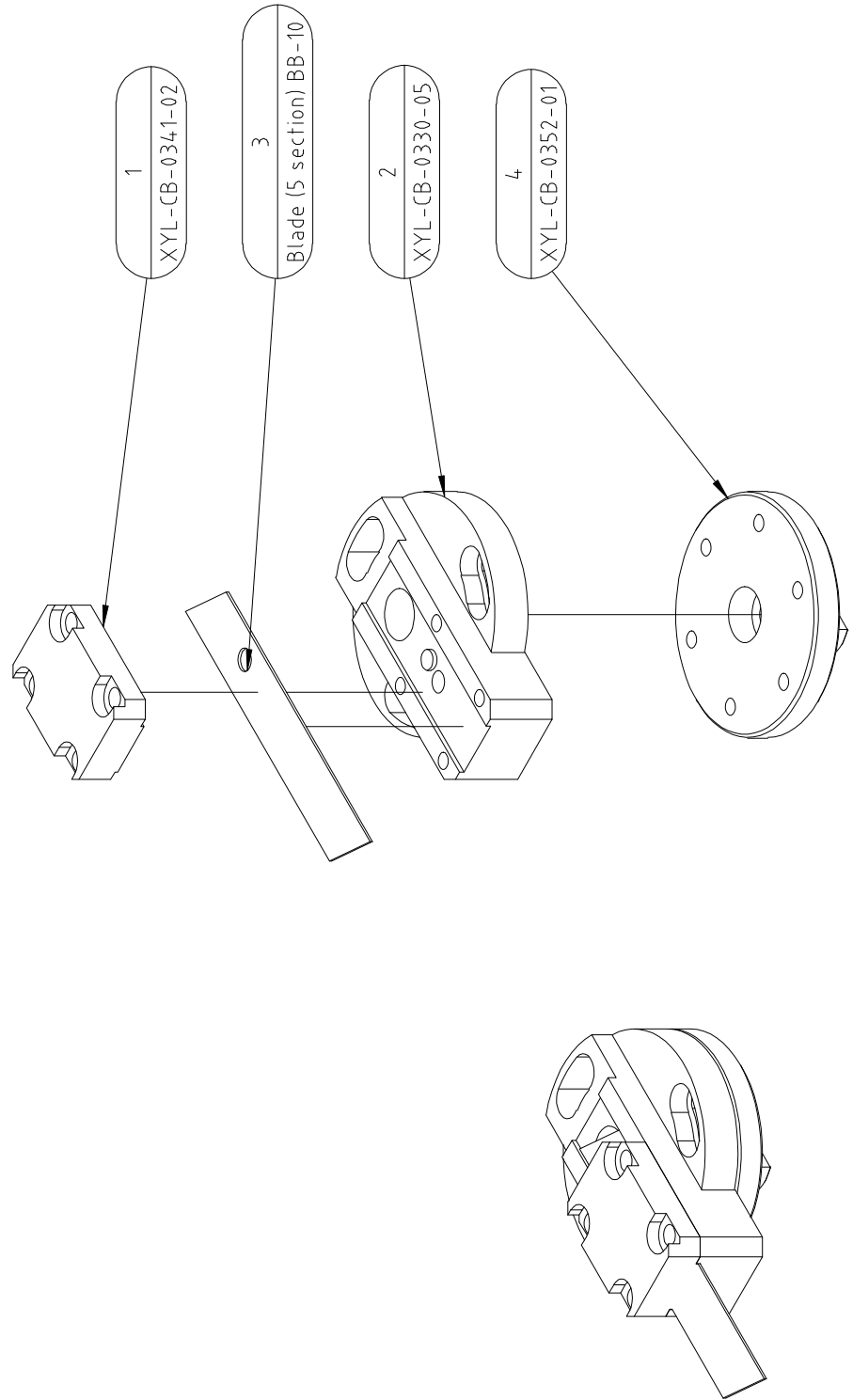
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14	XYL-PS-5090-00	130105090400	1
13	XYL-PS-5150-00	130105150400	1
12	XYL-PS-5060-00	130105060400	2
11	XYL-PS-5110-00	130105110400	1
10	XYL-PS-5120-00	130105120400	1
9	XYL-PS-5130-00	130105130400	1
8	XYL-PS-5140-00	130105140400	1
7	XYL-PS-5150-00	130105100400	1
6	XYL-PS-5160-00	B0300580	2
5	XYL-PS-5170-00	B0300581	2
4	XYL-PS-5180-00	B0300582	2
3	A Steel Rule 15cm	16649270005	1
2	Handled-M6	16655000003	4
1	WL9G-3N1132P05+P250F	16762080003	1

Mandrel - FS1, SSL-100, SSL-250, SSL-450, SSL-600, SSL-600i



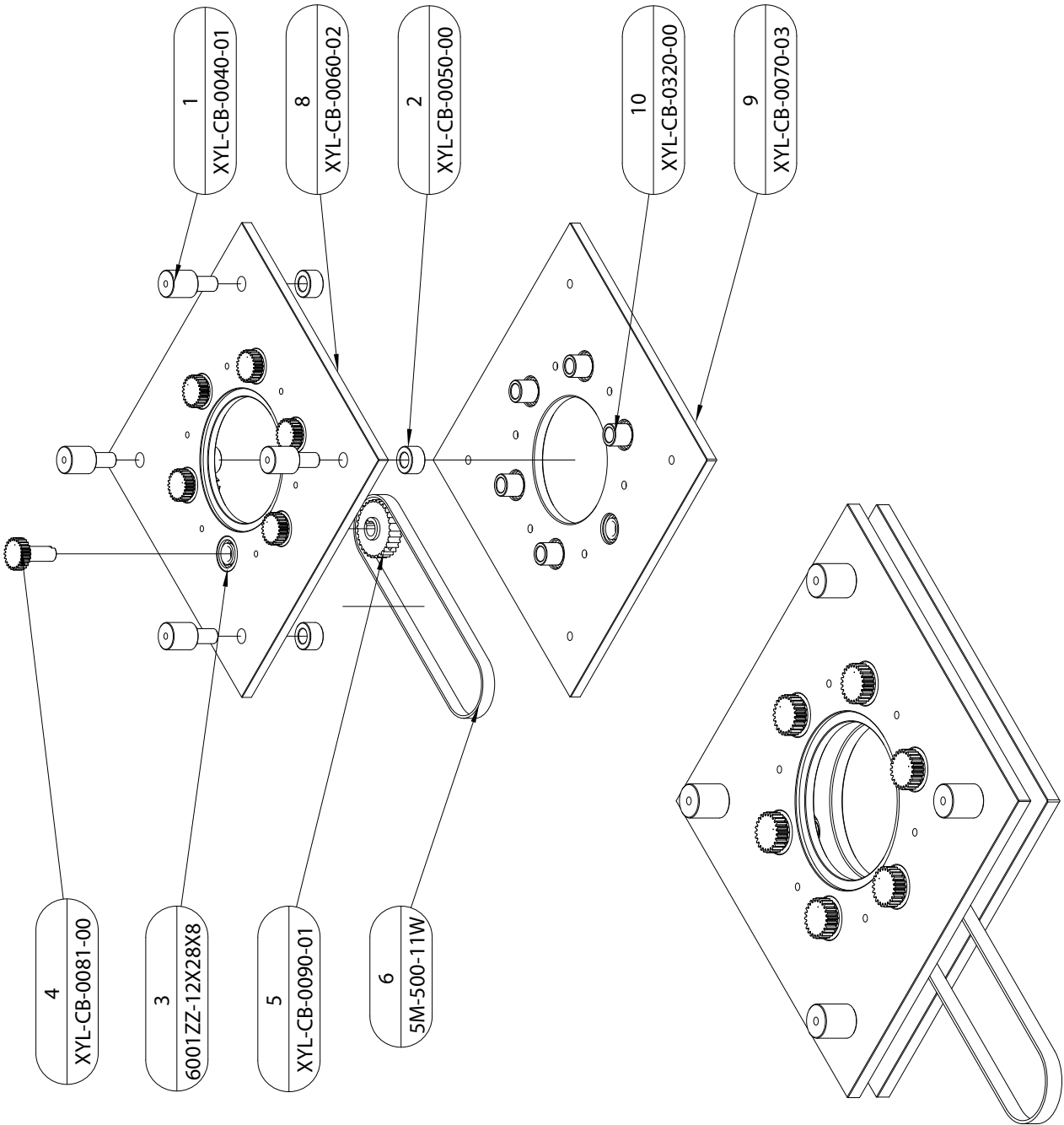
REF #	QTY	Specifics	Part Number
1	1	custom	custom
2	1	custom	custom
3	1	custom	custom
4	10	XYL-MA-5230-01	132055230401
5	12	L-1680ZZ 8X16X5	16641180006
6	12	608ZZ 8X22X7	16641000013
7	2	XYL-MA-5063-00	132055063400
8	2	XYL-MA-5250-00	131055250400
9	6	695 5X13X4	16641170001

Cutter Box - Blade Assembly



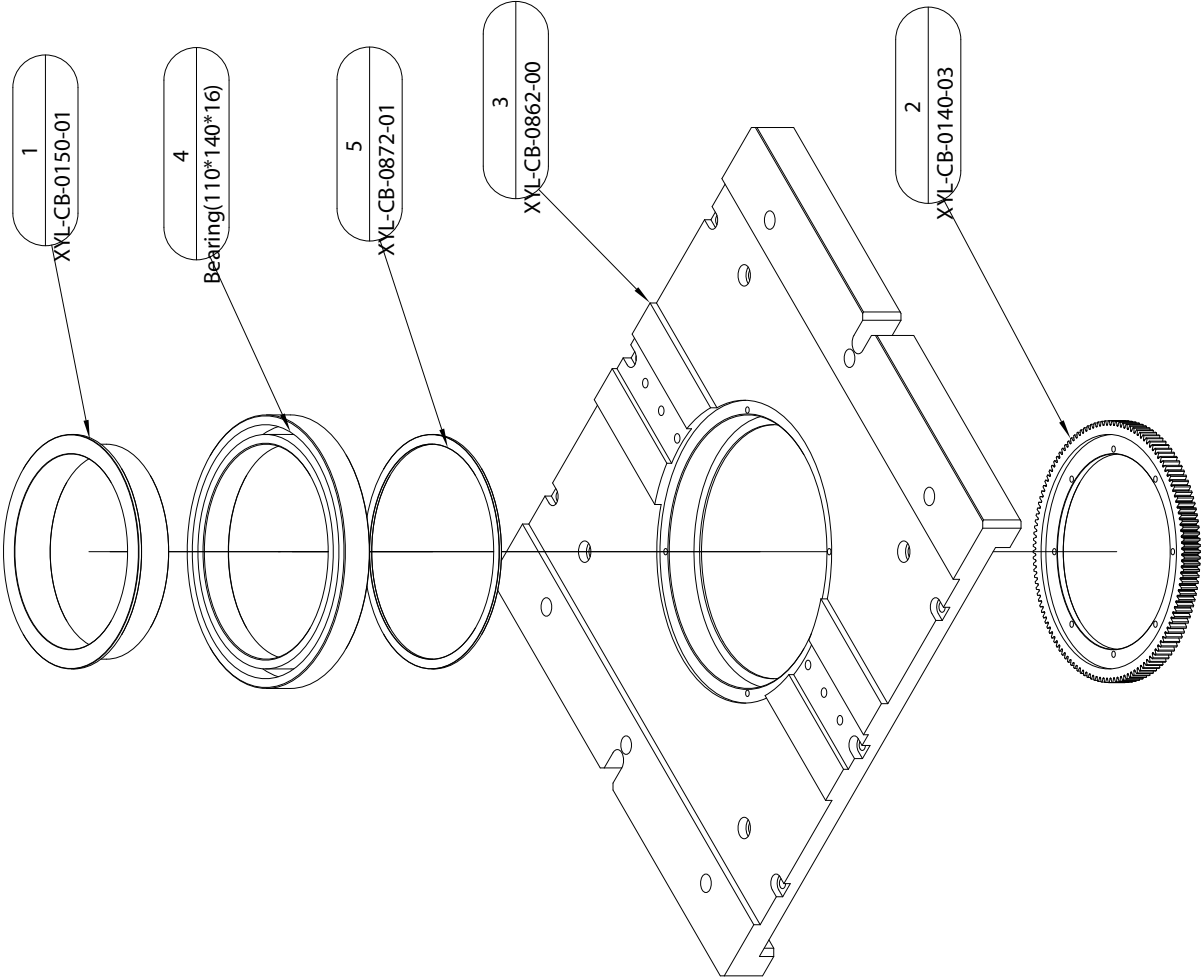
4	1	XYL-CB-0352-01	132090352001
3	1	Blade (5 section) BB-10	16651180007
2	1	XYL-CB-0330-05	132090330405
1	1	XYL-CB-0341-02	132090341402
REF #		QTY	Part Number

Cutter Box 13



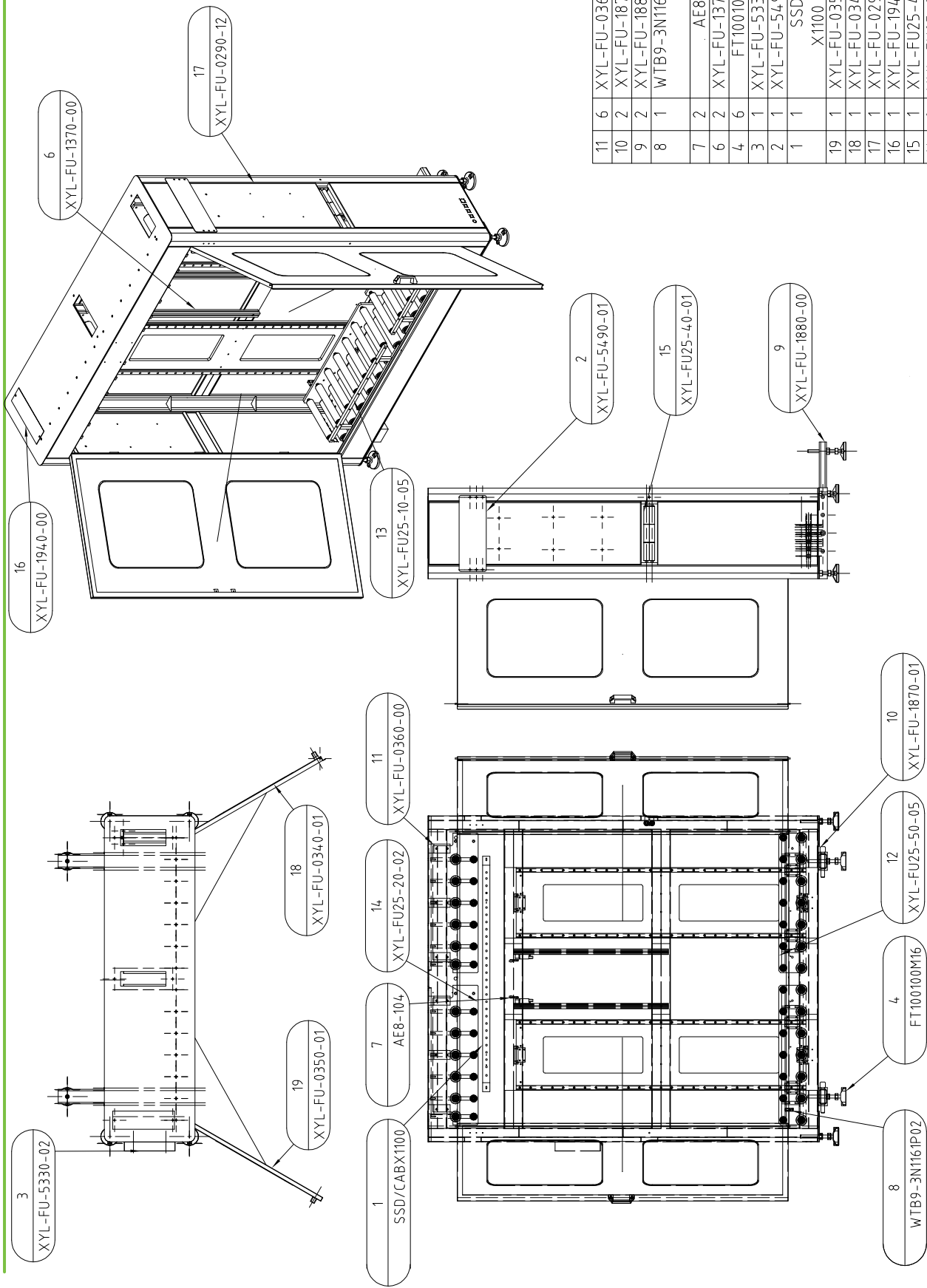
10	5	XYL-CB-0320-00	130090320400
9	1	XYL-CB-0070-03	130090070403
8	1	XYL-CB-0060-02	130090060402
7	1	KEY 4-4-15L	B0300042
6	1	5M-500-11W	16640040005
5	1	XYL-CB-0090-02	130090090402
4	6	XYL-CB-0081-00	132090081400
3	12	6001ZZ-12X28X8	16641000004
2	4	XYL-CB-0050-00	130090050400
1	4	XYL-CB-0040-01	132090040401
REF #	QTY	Specifics	Part Number

Cutter Box 13



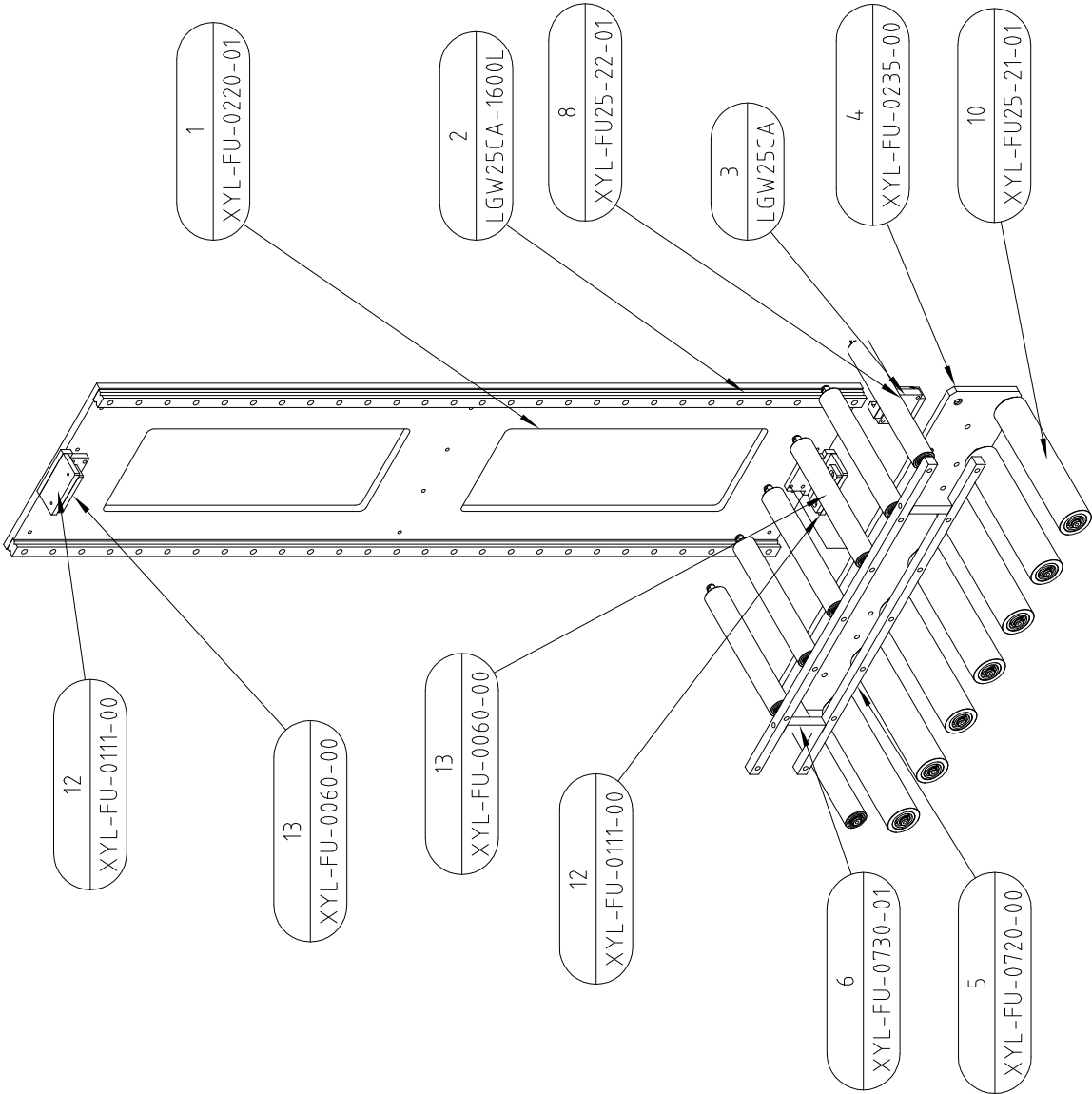
5	1	XYL-CB-0872-01	130090872001
4	1	Bearing(110*140*16)	16641000033
3	1	XYL-CB-0862-00	130090862000
2	1	XYL-CB-0140-03	132090140403
1	1	XYL-CB-0150-01	132090150401
REF #	QTY	Specifcs	Part Number

60M Cabinet FU25-00-13



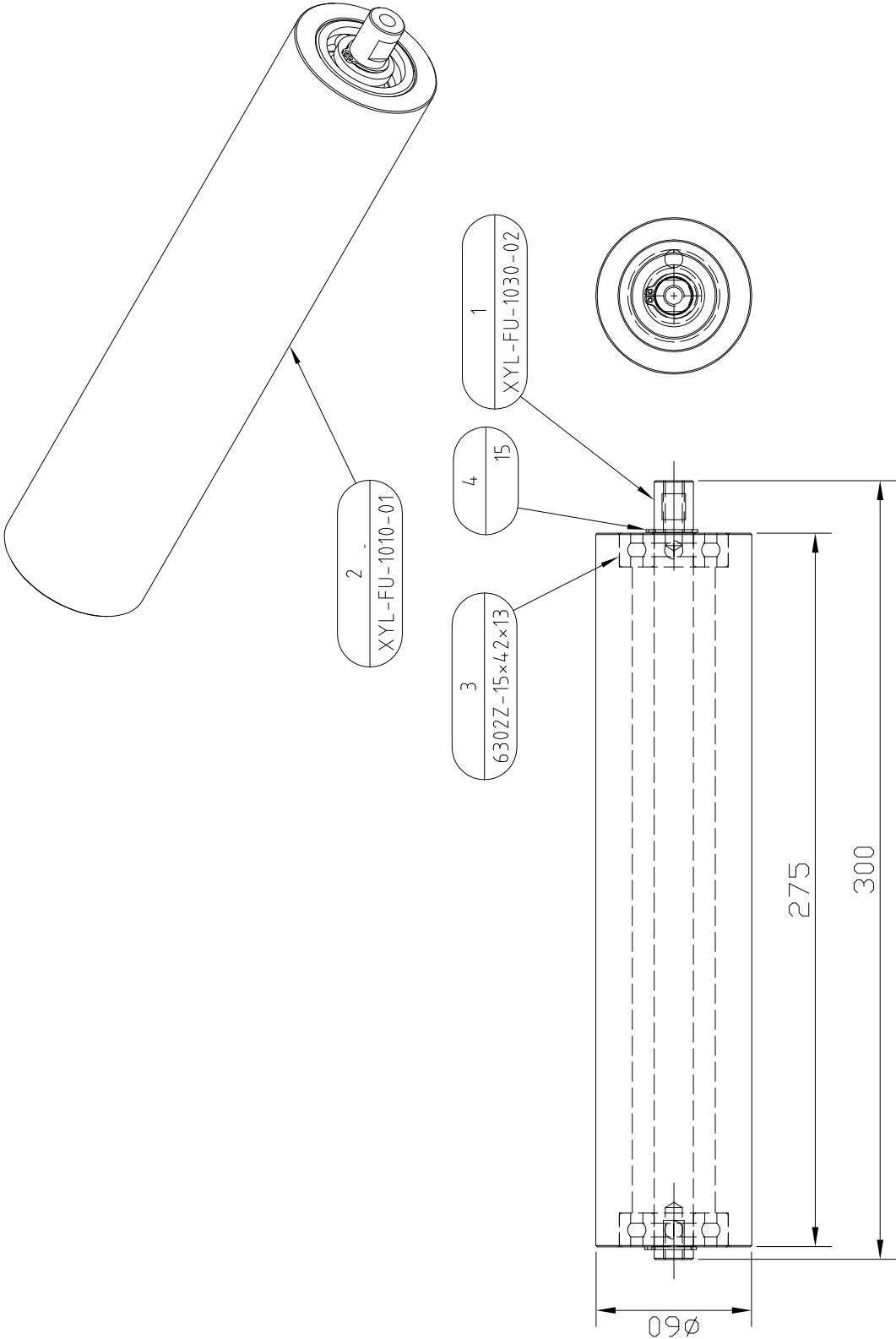
REF	QTY	Part Number	Specifics
11	6	XYL-FU-0360-00	130080360400
10	2	XYL-FU-1870-01	132081870001
9	2	XYL-FU-1880-00	132081880000
8	1	WTB9-3N1161P02	16762080004
7	2	AE8-104	16762020001
6	2	XYL-FU-1370-00	130081370400
4	6	FT100100M16	1665600008
3	1	XYL-FU-5330-02	132085330402
2	1	XYL-FU-5490-01	132085490401
1	1	SSD/CAB X1100	16768280022
19	1	XYL-FU-0350-01	132080350001
18	1	XYL-FU-0340-01	132080340001
17	1	XYL-FU-0290-12	132080290012
16	1	XYL-FU-1940-00	132081940000
15	1	XYL-FU25-40-01	
14	2	XYL-FU25-20-02	
13	1	XYL-FU25-10-05	
12	1	XYL-FU25-50-05	

60M Cabinet FU25-10-05



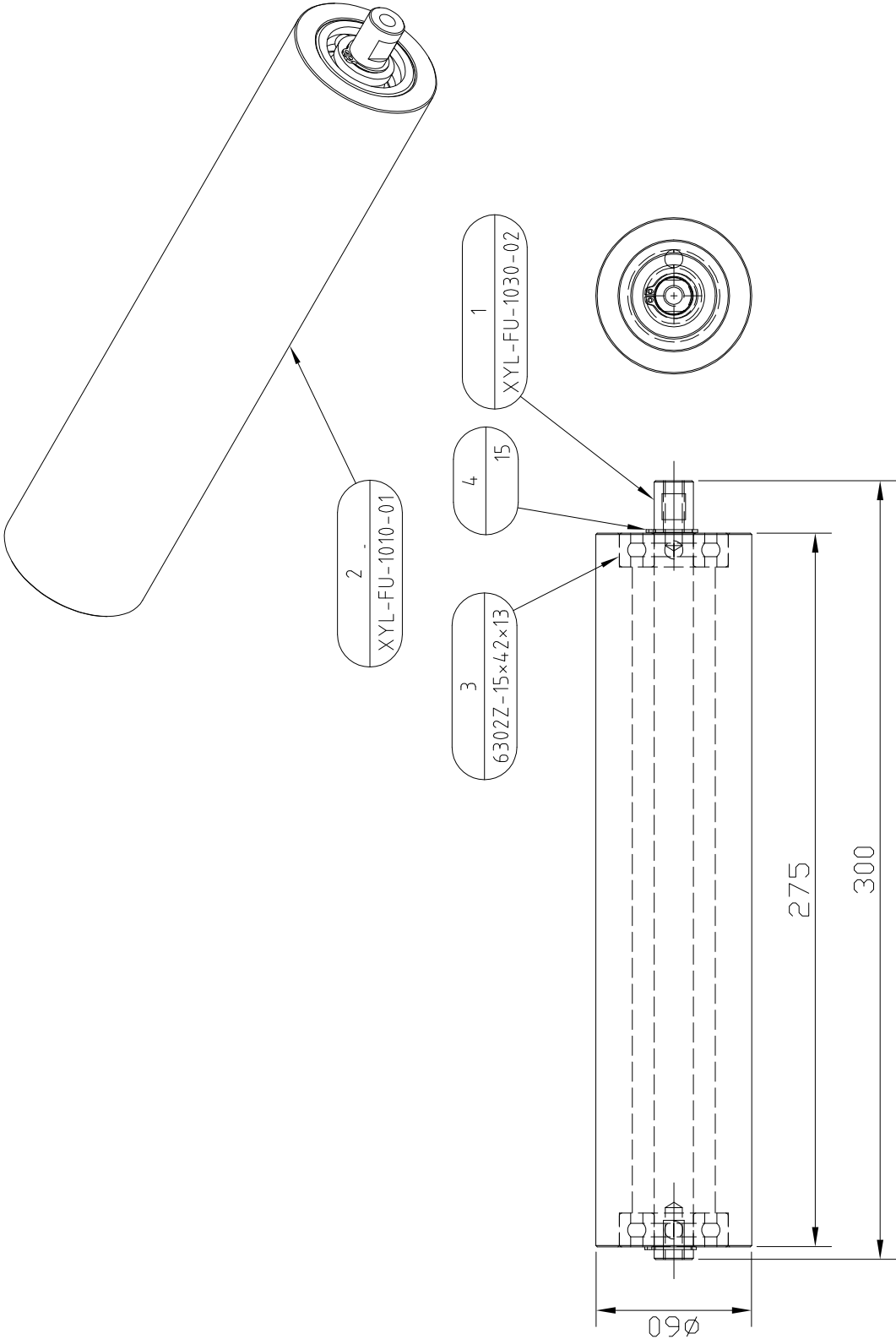
REF #	QTY	Specifics	Part Number
13	2	XYL-FU-0060-00	1330800604.00
12	2	XYL-FU-0111-00	1320801114.00
10	7	XYL-FU25-21-01	
8	7	XYL-FU25-22-01	
6	2	XYL-FU-0730-01	130080730001
5	2	XYL-FU-0720-00	130080720000
4	1	XYL-FU-0235-00	130080235000
3	2	LGW25CA	16657010002
2	2	LGW25CA-1600L	16657000002
1	1	XYL-FU-0220-01	1320802204.01

60M Cabinet FU25-21-01



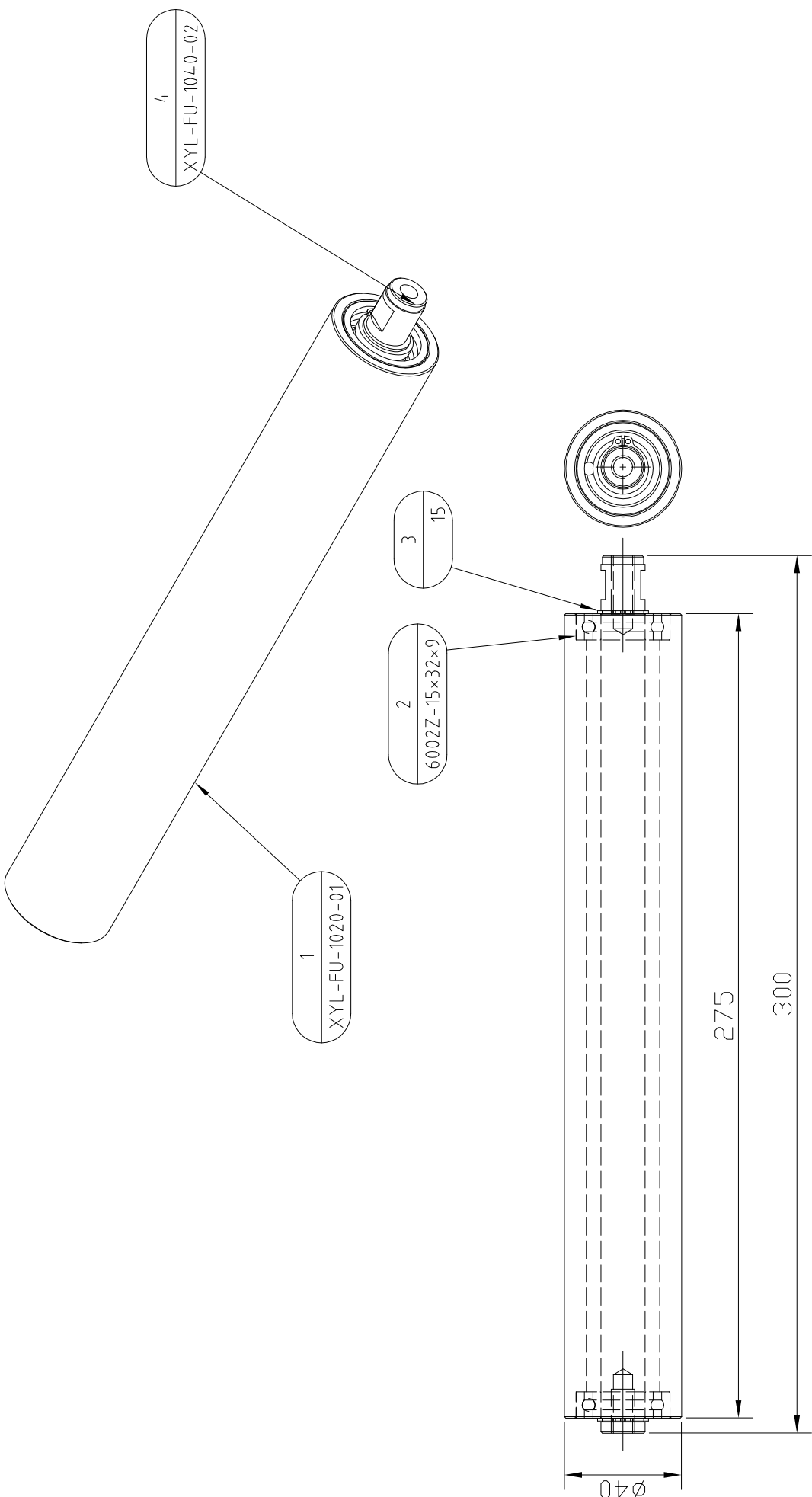
2	4	15	B0300010
2	3	6302Z-15x42x13	16641000027
1	2	XYL-FU-1010-01	133081010401
1	1	XYL-FU-1030-02	132081030402
REF #	QTY	Specifics	Part Number

60M Cabinet FU25-21-01



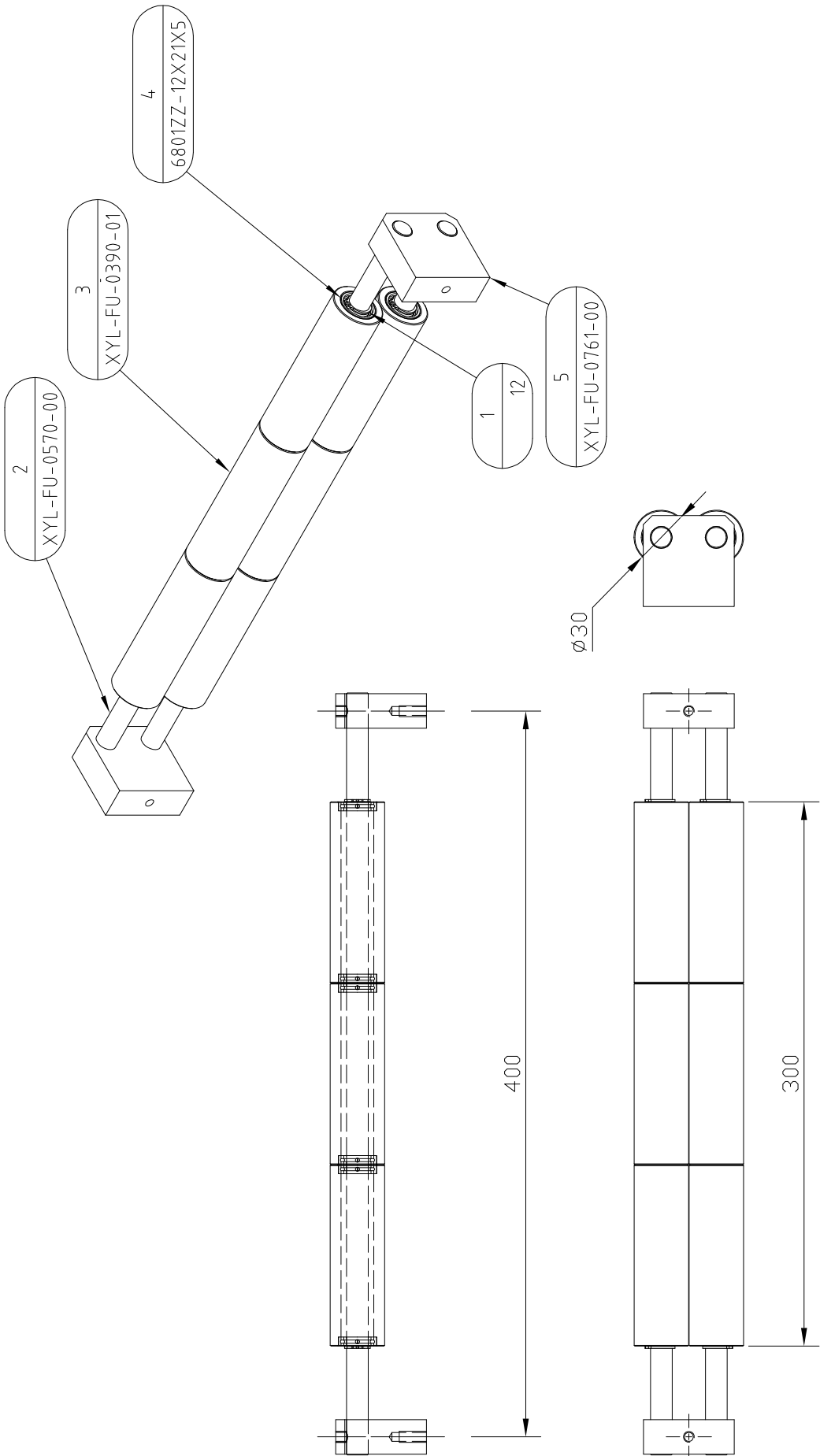
2	4	15	B0300010
2	3	6302Z-15x42x13	16641000027
1	2	XYL-FU-1010-01	133081010401
1	1	XYL-FU-1030-02	132081030402
REF #	QTY	Specifics	Part Number

60M Cabinet FU25-22-01



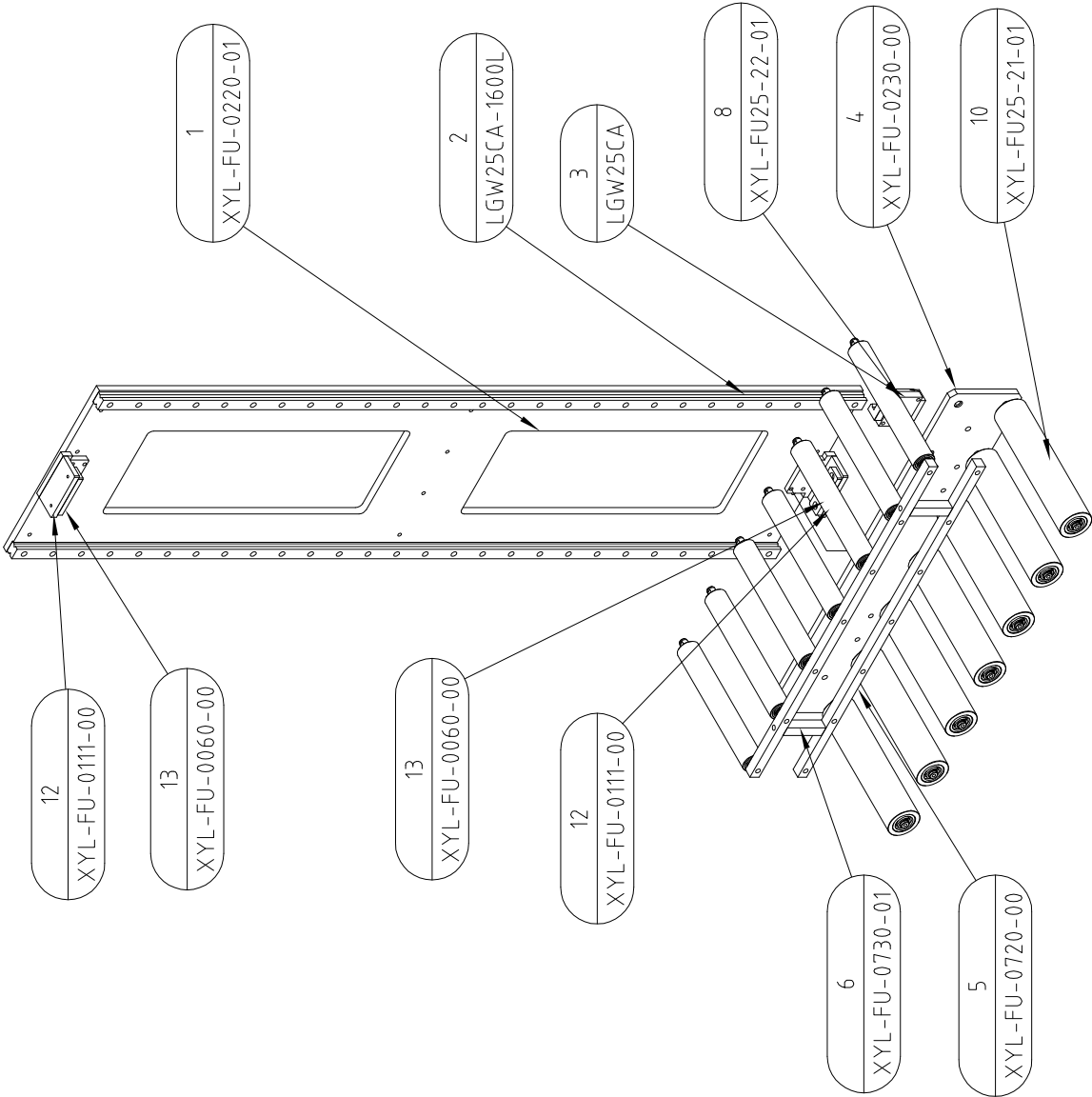
4	1	XYL-FU-1040-02	132081040402
3	2	15	B0300010
2	2	6002Z-15x32x9	16641000083
1	1	XYL-FU-1020-01	133081020401
REF #		QTY	Part Number

60M Cabinet FU25-40-01



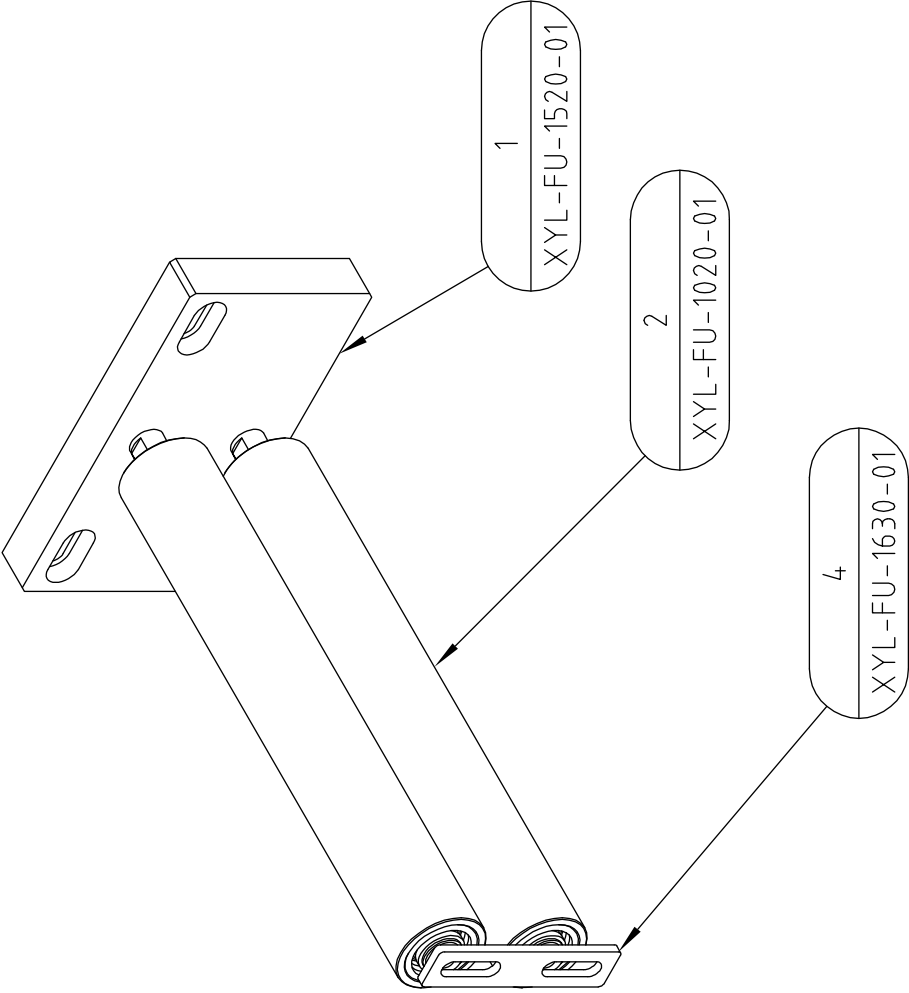
REF #	QTY	Specifics	Part Number
5	2	XYL-FU-0761-00	130080761000
4	12	6801ZZ-12X21X5	1664 1000031
3	6	XYL-FU-0390-01	133080390401
2	2	XYL-FU-0570-00	132080570400
1	4	12	B0300009

60M Cabinet FU25-50-05



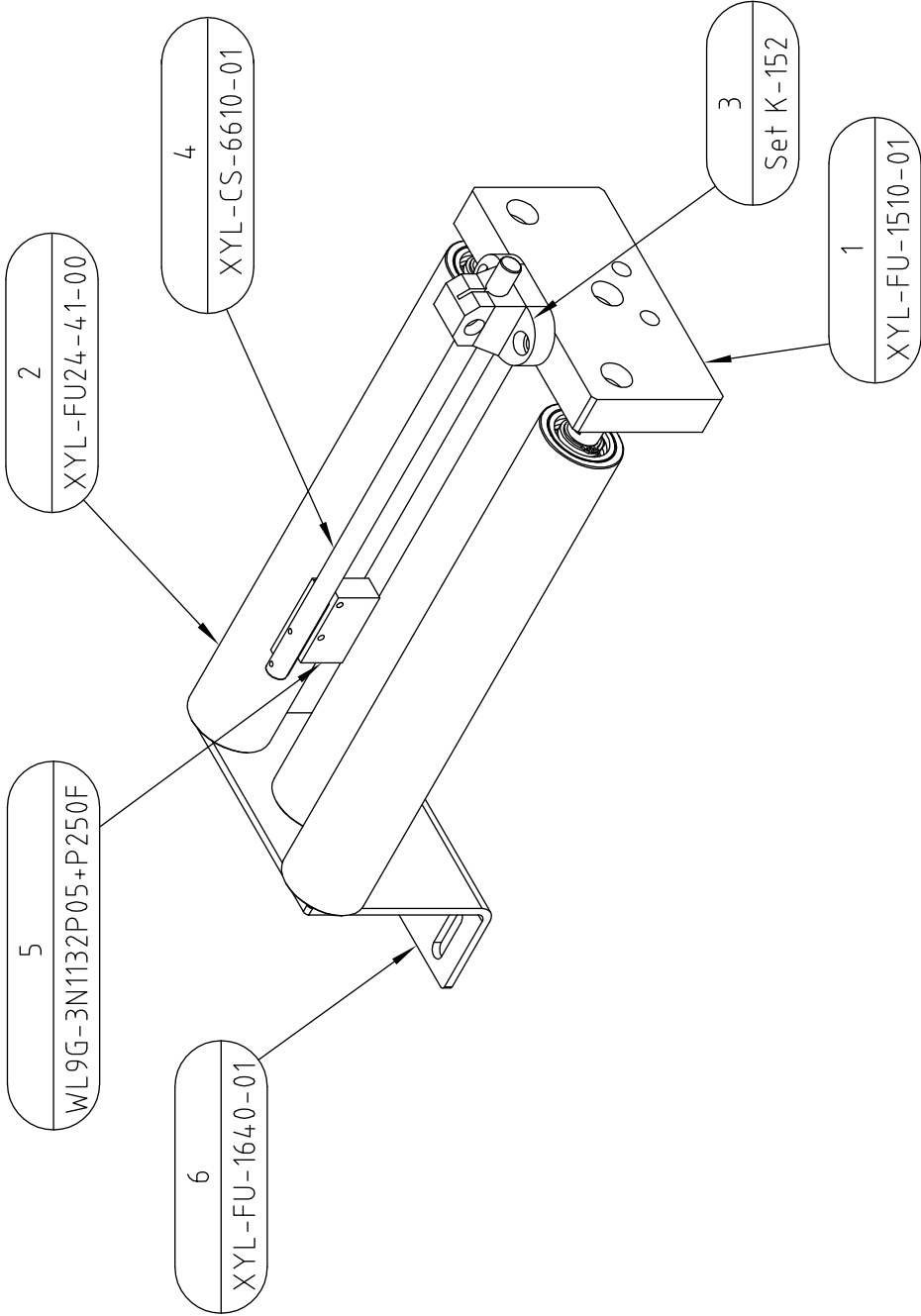
REF #	QTY	Specifcs	Part Number
13	2	XYL-FU-0060-00	13308000604.00
12	2	XYL-FU-0111-00	1320801114.00
10	7	XYL-FU25-21-01	/
8	7	XYL-FU25-22-01	/
6	2	XYL-FU-0730-01	130080730001
5	2	XYL-FU-0720-00	130080720000
4	1	XYL-FU-0230-00	132080230000
3	2	LGW25CA	16657010002
2	2	LGW25CA-1600L	16647000002
1	1	XYL-FU-0220-01	1320802204.01

Two Reel Cabinet 1



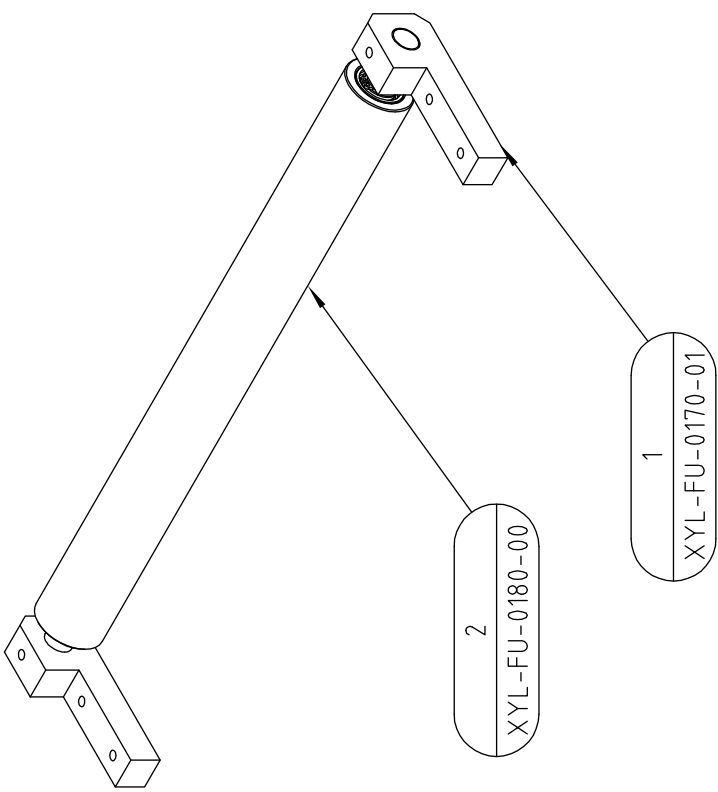
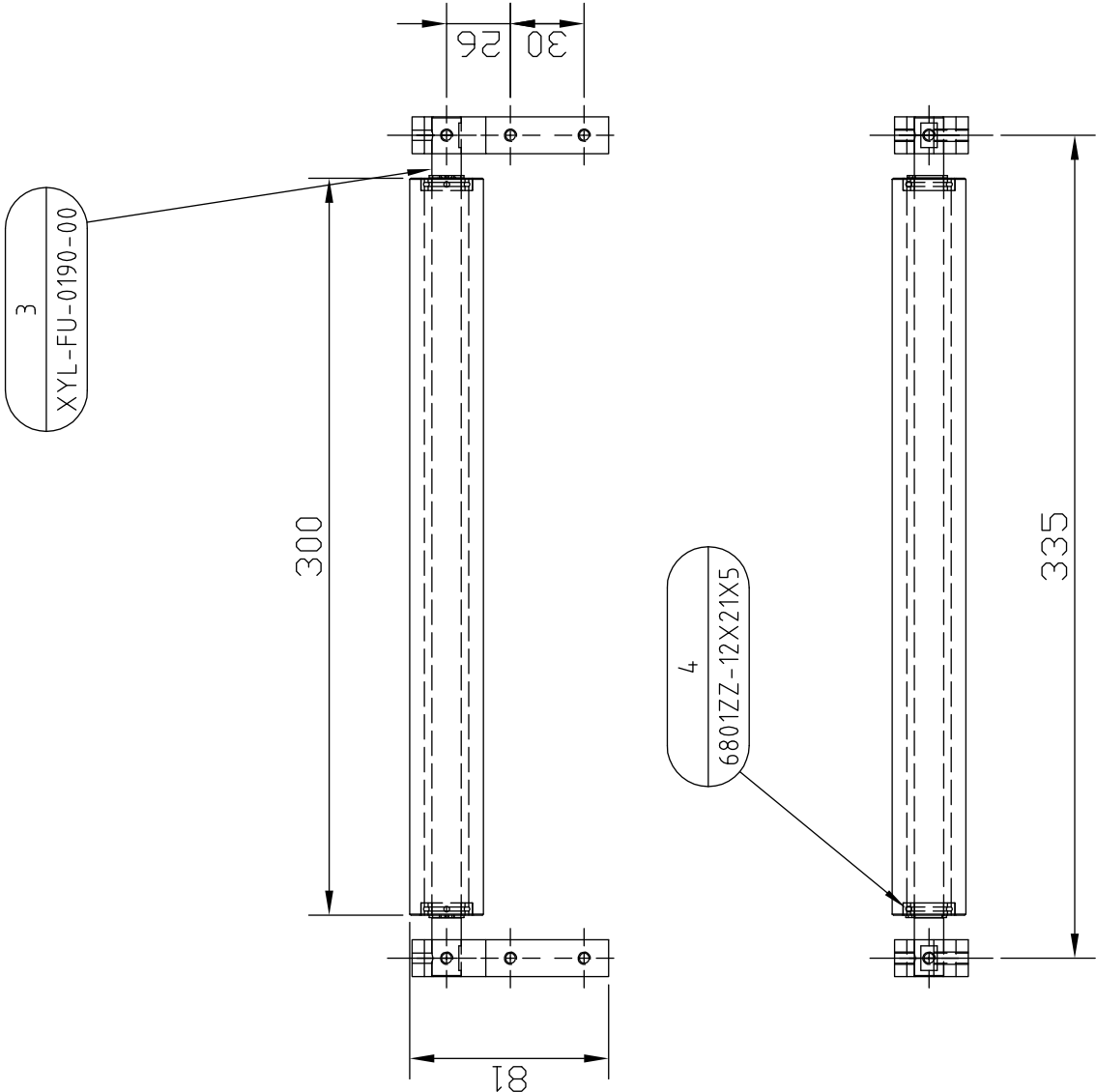
4	1	XYL-FU-1630-01	132081630401
2	2	XYL-FU-1020-01	133081020401
1	1	XYL-FU-1520-01	132081520401
REF #	QTY	Specifics	Part Number

Two Reel Cabinet 2



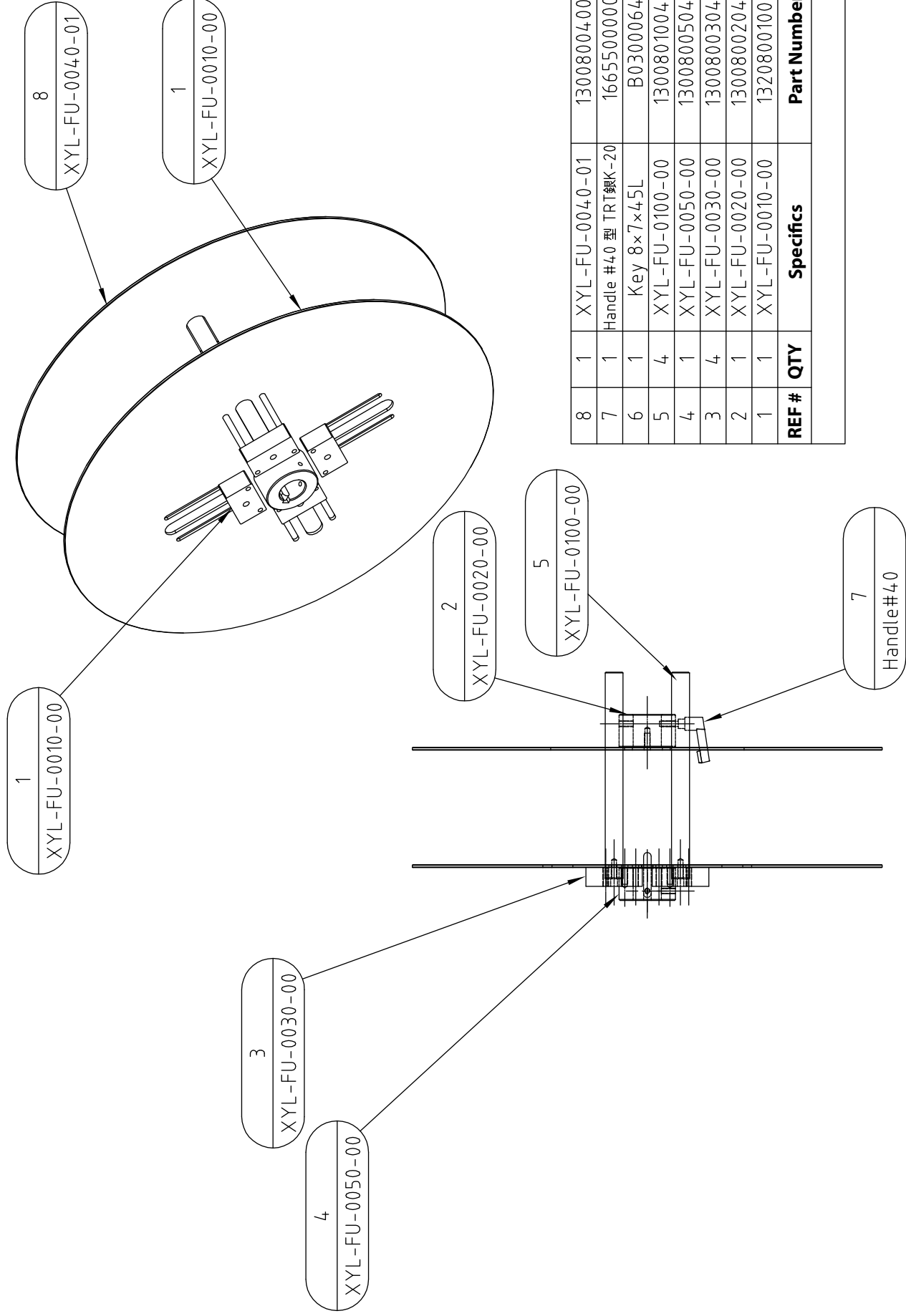
6	1	XYL-FU-1640-01	132081640401
5	1	WL9G-3N1132P05+P250F	16762080003
4	1	XYL-CS-6610-01	132196610401
3	1	Set K-152	16653070001
2	3	XYL-FU-1020-01	133081020401
1	1	XYL-FU-1510-01	130081510401
REF #	QTY	Specifics	Part Number

Two Reel Cabinet 3



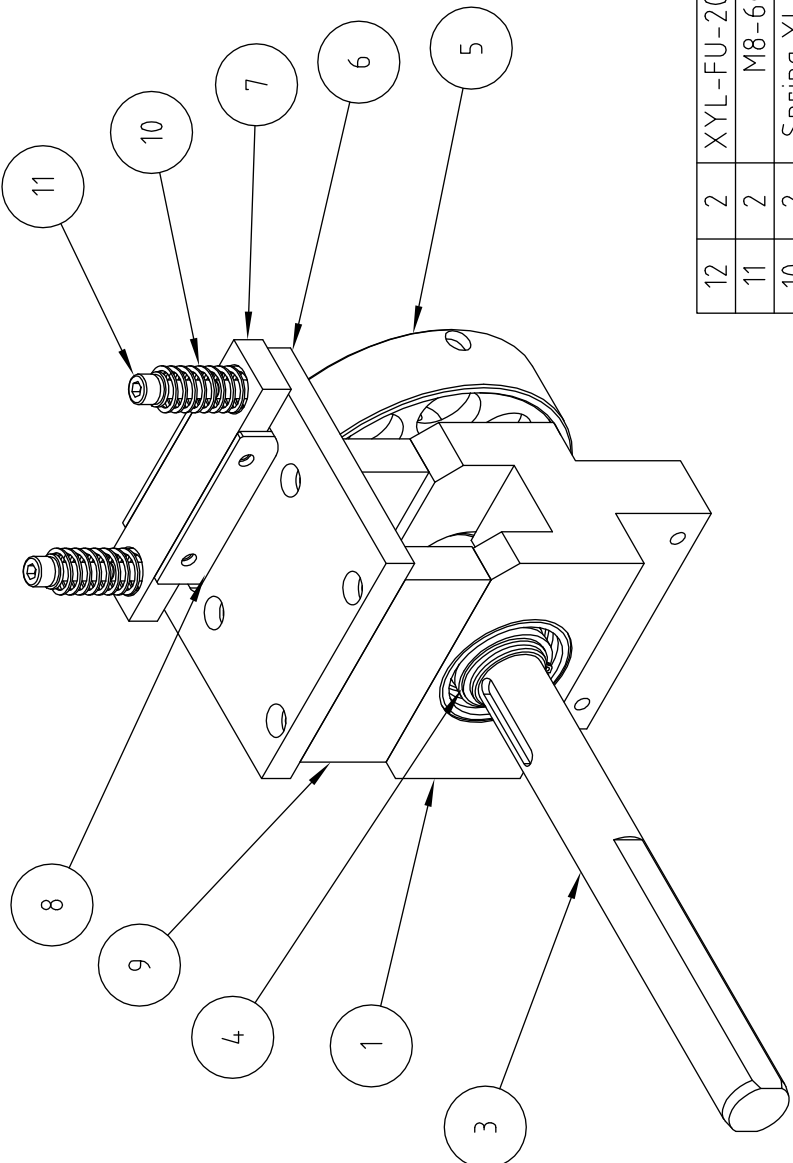
REF #	QTY	Specifics	Part Number
5	2	Hook S-12	B0300009
4	2	6801ZZ-12X21X5	16641000030
3	1	XYL-FU-0190-00	132080190400
2	1	XYL-FU-0180-00	133080180401
1	2	XYL-FU-0170-01	130080170001

Two Reel Cabinet 4



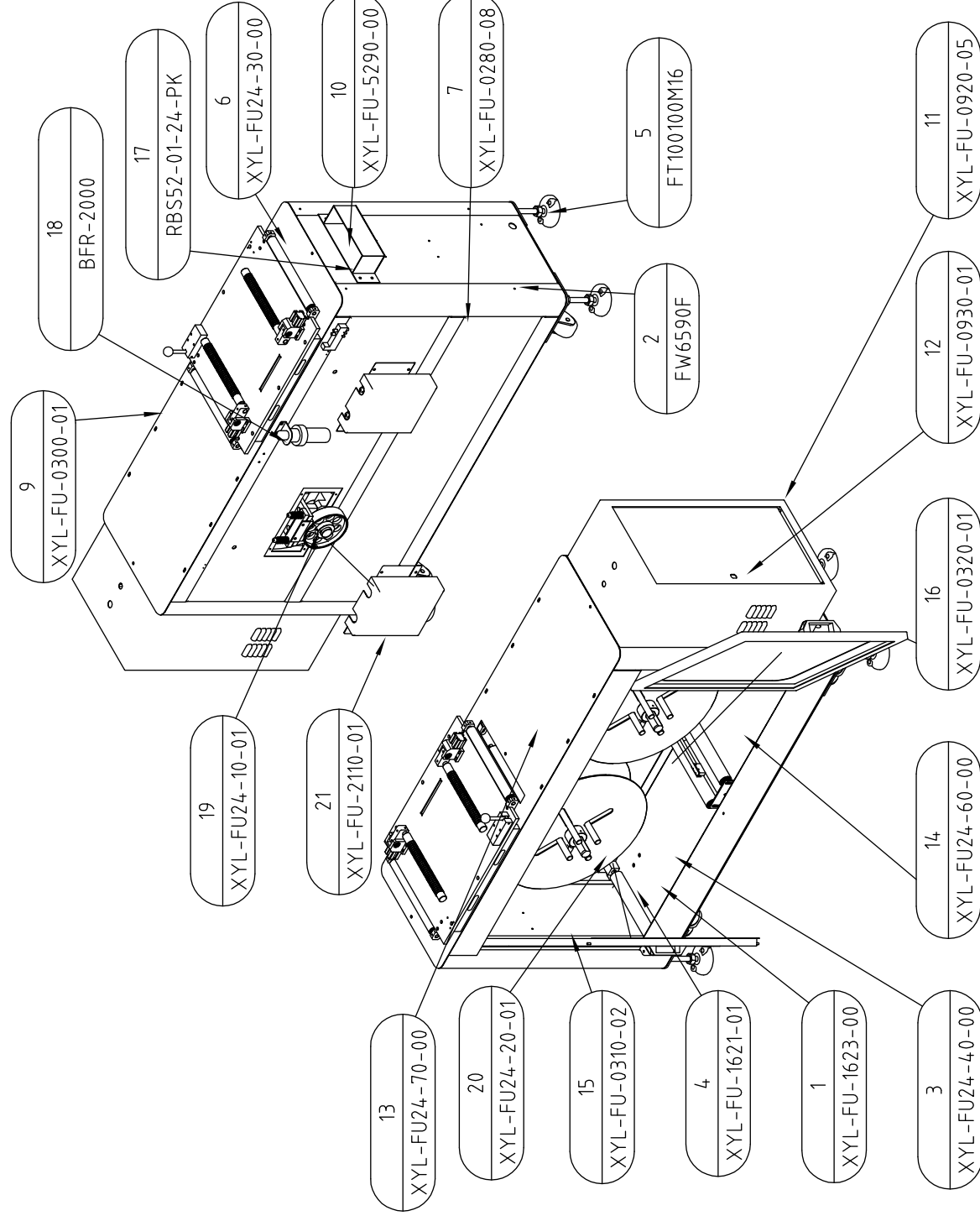
REF #	QTY	Specifics	Part Number
8	1	XYL-FU-0040-01	130080040001
7	1	Handle #40 型 TRT銀K-20	16655000005
6	1	Key 8x7x45L	B03000064
5	4	XYL-FU-0100-00	130080100400
4	1	XYL-FU-0050-00	130080050400
3	4	XYL-FU-0030-00	130080030400
2	1	XYL-FU-0020-00	130080020400
1	1	XYL-FU-0010-00	132080010000

Two Reel Cabinet 5

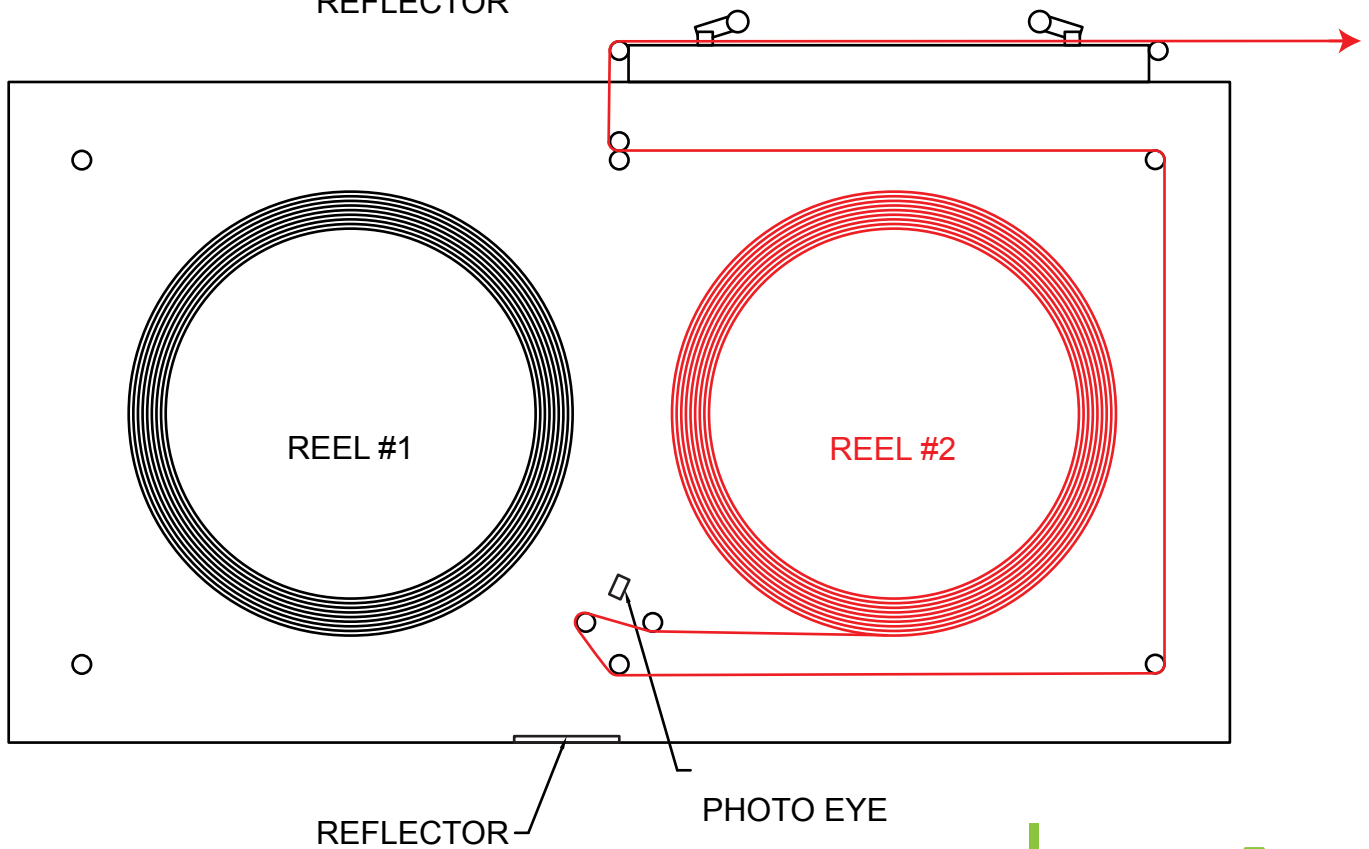
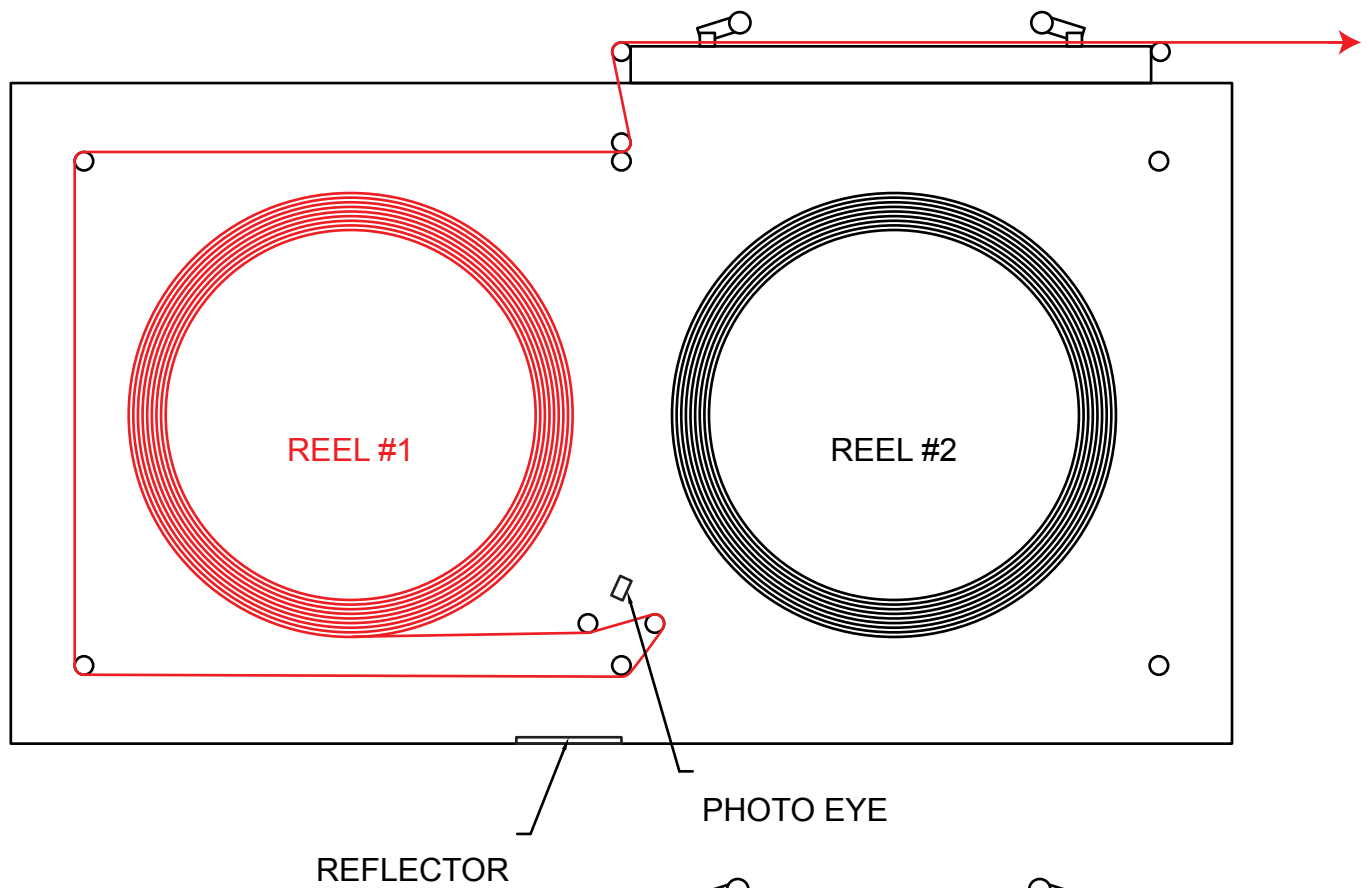


12	2	XYL-FU-2082-00	132082082400
11	2	M8-60L	B0100105
10	2	Spring YL-2050	16648030001
9	2	XYL-FU-2100-00	XYL-FU-2100-00
8	1	XYL-FU-2092-00	132082092000
7	1	XYL-FU-2081-01	132082081401
6	1	XYL-FU-2070-00	130082070400
5	1	XYL-FU-2060-00	132082060400
4	2	Hook-S35	B0300019
3	1	XYL-FU-0092-00	132080092400
2	2	Bearing 6007ZZ - 35 X 62 X 14	16641000011
1	1	XYL-FU-0071-01	132080071401
REF #	QTY	Specifics	Part Number

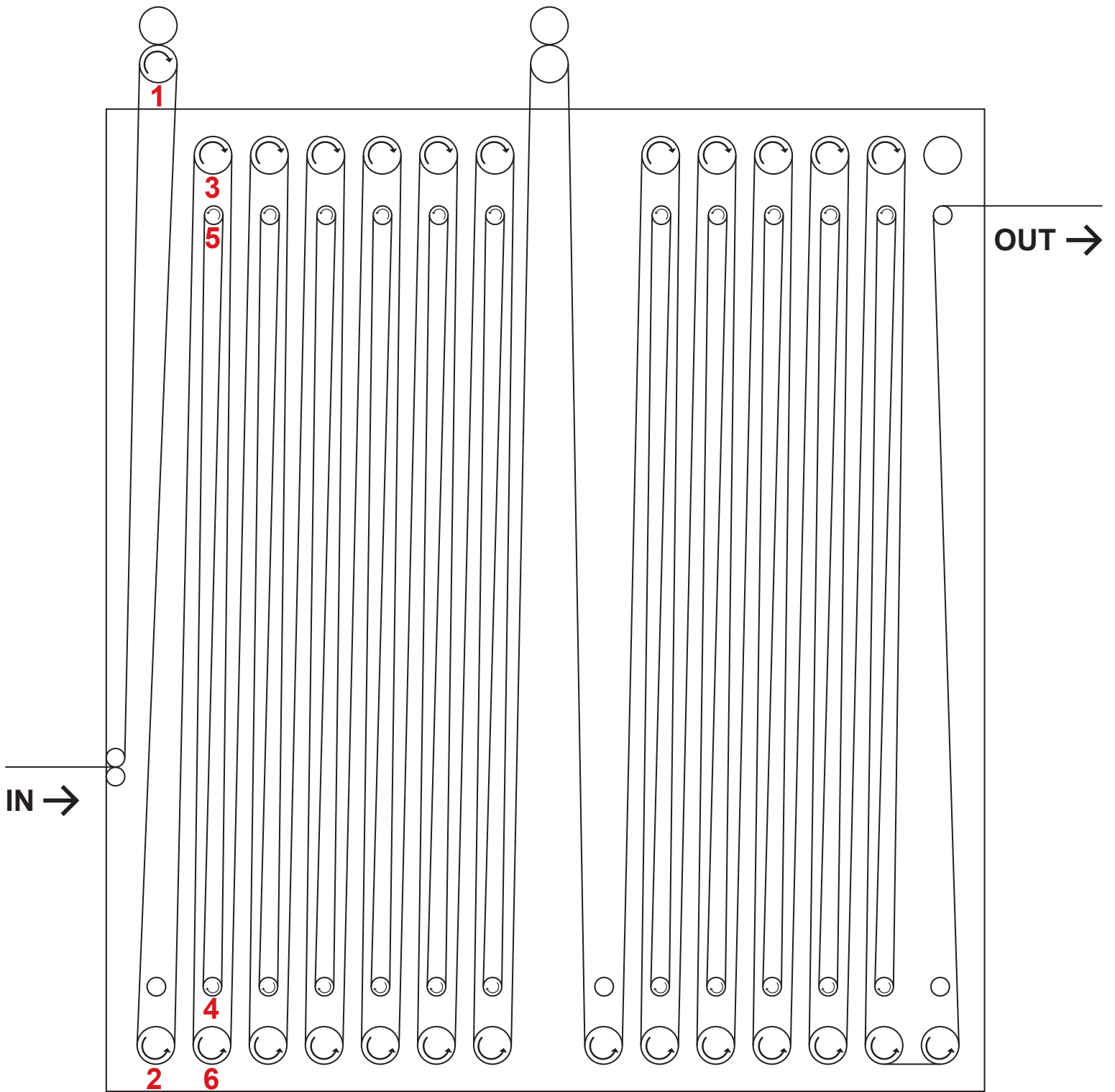
Two Reel Cabinet 6



REF #	Specifics	Part Number	QTY
21	XYL-FU-2110-01	132082110401	2
20	XYL-FU24-20-01	Machine Module	2
19	XYL-FU24-10-01	Machine Module	2
18	BFR-2000	16650010001	1
17	RBS52-01-24-PK	16650020003	1
16	XYL-FU-0320-01	132080320001	1
15	XYL-FU-0310-02	133080310001	1
14	XYL-FU24-60-00	Machine Module	1
13	XYL-FU24-70-00	Machine Module	1
12	XYL-FU-0930-01	132080930401	1
11	XYL-FU-0920-05	132080920405	1
10	XYL-FU-5290-00	132085290400	1
9	XYL-FU-0300-01	132080300001	1
8	XYL-FU-0940-01	132080940401	1
7	XYL-FU-0280-08	132080280008	1
6	XYL-FU24-30-00	Machine Module	1
5	FT100100M16	16656000032	4
4	XYL-FU-1621-01	132081621001	2
3	XYL-FU24-40-00	Machine Module	4
2	FW6590F	16656010005	4
1	XYL-FU-1623-00	132081623400	4

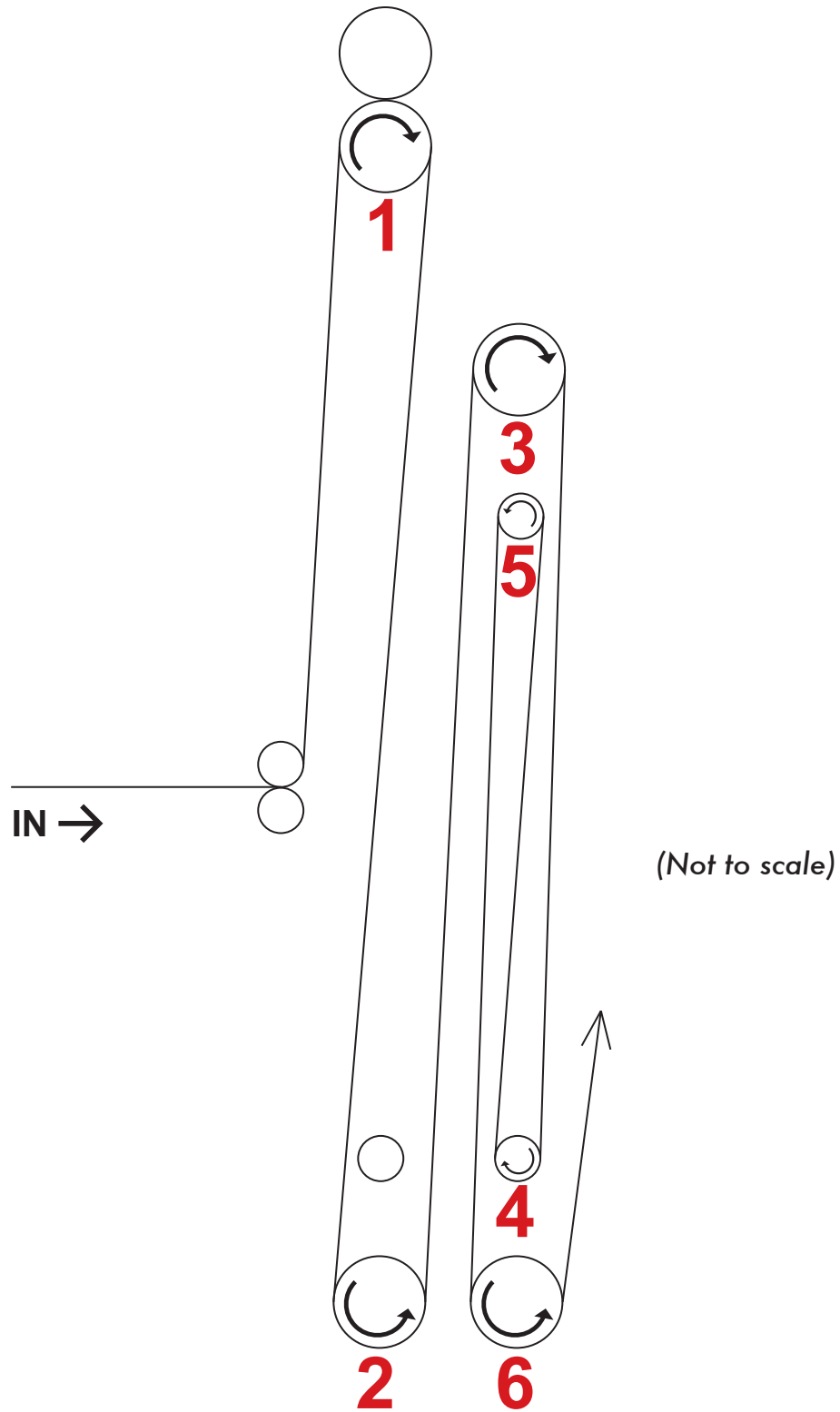


Two Reel Accumulation Cabinet
Lacing Diagram



SSA-1 Label Accumulation Cabinet
Lacing Diagram





SSA-1 Label Accumulation Cabinet
Lacing Diagram - *Detail*