TABLE OF CONTENTS

TABLE OF CONTENTS

LIST OF ILLUSTRATIONS

1. INTRODUCTION

1.1 GENERAL DESCRIPTION OF MACHINES

The Weldotron L-Sealers Series utilize advanced sealing techniques to completely wrap any item, using most heat shrinkable or non-shrinkable films. When used with shrinkable films and a hot air tunnel, a tight contour fit is obtained for complete product visibility, sales appeal, and protection.

1.1.1 The 6000 Series

This is a simple and reliable series, available in two sizes, at a lower cost than other L-Sealers previously available. Of deluxe construction and features, the 6000 Series utilizes impulse-radiant sealing techniques and is intended for applications such as are found in the printing industry, or others, in which a lower production rate is acceptable. Straightforward, easy manual operation is employed.

1.1.2 The 6100 Series

This is the original and improved L-Sealer Series, featuring reliable operation in the impulse-radiant (or, optionally, THERMOLINE^{tm} constant heat) operating mode to provide a very efficient means for manually-operated packaging and is available in a wide range of sizes for most packaging applications.

1.1.3 The 6300 Series

This series, otherwise similar to the 6100 Series, incorporates a unique electromagnetic (MAGNA-LOK^{tm}) sealing head hold-down system. This frees the operator to load another package while the preceding one is being sealed, and assures uniform sealing pressure over the full length of the sealing boars (up to 100 inches long) and provides consistent sealing results from package to package.

1.1.4 The 6400 Series

Available in two sizes, with all of the features of the 6100 and 6300 Series, this series provides the added flexibility and utility of a motorized package take-away conveyor for highest-speed manual sealing operations.

1.2 THE OPERATING AND MAINTENANCE MANUAL

This Operating and Maintenance Manual has been carefully prepared by our Technical Publications Department to provide the user with all information needed to properly install, operate, and maintain the Weldotron Sealer. In addition to this manual, regional Sales/Service Centers provide complete maintenance facilities, if required.

Please read this manual carefully and refer to it for information on the care and use of your Weldotron machine. It is recommended that additional copies be ordered for use by production, maintenance, and supervisory personnel. Although the design of this sealer incorporates safeguards to protect personnel, care should be used in operating, adjusting, and servicing.

1.3 IMPORTANT WARRANTY NOTICE

Attention is directed to the Standard Weldotron Parts and Service Warranty which accompanies all new Weldotron machines. The terms and conditions of this warranty apply only to unmodified units. Any unauthorized modifications to the equipment automatically invalidate this warranty.

1.4 PATENT NOTICE

The purchase, use, or possession of any Weldotron machine gives no license express or implied, under any letters patent. This equipment is protected by one or more of the following patents and patents pending:

UNITED STATES PATENTS:

3047991, 3135077, 3191356, 3200561, 3116394, 3222800, 3243330, 3253122, 3262833, 3291963, 3299251, 3316653, 3321353

BRITISH PATENTS:

953490, 984587, 971422

FRENCH PATENTS:

1338356, 1326937, 1397917, 1332396

ITALIAN PATENTS:

671769, 691457, 673104

CANADIAN PATENTS:

756064

GERMAN PATENTS:

1209046

2. UNPACKING

Remove sealer from shipping crate and inspect for possible damage. **IF ANY DAMAGE IS NOTED, CONTACT CARRIER IMMEDIATELY. DO NOTHING FURTHER UNTIL CARRIER'S AGENT HAS MADE AN INSPECTION OF THE DAMAGE TO THE UNIT.**

If no damage is evident, check for the presence of the following items:

1. Operating and Maintenance Manual.
2. Four extra sets of elements.
3. Two extra lengths of Fiberglas Teflon tape.
4. Fuses, line, F1 and F2 (see Replacement Parts List for Part No.).

If any of the above items are missing, contact manufacturer immediately.

3. SPECIFICATIONS

3.1 6000 SERIES

MODEL	SEAL AREA W"	SEAL AREA L"	VOLTS*	AMPS**	OVERALL SIZE W"	OVERALL SIZE L"	APPROX. SHIP. WGT (LBS)
6081	20	16	220	7	30	47	230
6082	20	28	220	9	30	71	295
6001	20	16	110	14	30	47	230

All units are 50/60 cycle, 1 phase.

* Other voltages available on special order.

** At listed voltage (peak current while sealing, not steady drain).

CONTROLS:

Automatic sealing temperature compensator; adjustable loading tray; adjustable-height package support tray; lateral and vertical positioning adjustment of film separator rod.

3.2 6100 SERIES

MODEL	SEAL AREA W"	SEAL AREA L"	VOLTS*	AMPS**	OVERALL SIZE W"	OVERALL SIZE L"	APPROX. SHIP. WGT (LBS)
6100	13	13	110	25	25	41	180
6101	20	16	220	17	30	47	235
6102	20	28	220	23	30	71	300
6103	20	40	220	28	30	95	400
6113	30	40	220	33	40	95	400

All units are 50/60 cycle, 1 phase.

* Other voltages available on special order.

** At listed voltage (peak current while sealing, not steady drain).

CONTROLS:

Automatic sealing temperature compensator; synchronous timer heat control tap switch; adjustable loading tray; adjustable-height package support tray; adjustable film roll friction brake. Sealer with Thermoline Optional feature Thermoline/Impulse mode selector switch.

3.3 6300 SERIES

MODEL	SEAL AREA		VOLTS*	AMPS**	OVERALL SIZE		APPROX. SHIP. WGT (LBS)
	W"	L"			W"	L"	
6300	13	13	110	25	25	41	200
6301	20	16	220	17	30	47	255
6302	20	28	220	23	30	71	320
6303	20	40	220	28	30	95	420
6304	20	70	220	44	30	155	470
6305	20	80	220	48	30	175	520
6306	20	90	220	52	30	195	570
6307	20	100	220	56	30	215	620
6313	30	40	220	33	40	95	420
6314	30	70	220	48	40	155	470
6315	30	80	220	52	40	175	520
6316	30	90	220	56	40	195	570
6317	30	100	220	60	40	215	620

All units are 50/60 cycle, 1 phase.

* Other voltages available on special order.

** At listed voltages (peak current while sealing, not steady drain).

CONTROLS:
Automatic sealing temperature compensator; synchronous timer heat control tap switch; adjustable loading tray; adjustable-height package support tray; adjustable film roll friction brake. Sealer with Thermoline Optional feature Thermoline/Impulse mode selector switch.

3.4 6400 SERIES

MODEL	SEAL AREA		VOLTS*	AMPS**	OVERALL SIZE		APPROX. SHIP. WGT (LBS)
	W"	L"			W"	L"	
6401	20	16	220	18	30	47	300
6402	20	28	220	24	30	71	365

All units are 50/60 cycle, 1 phase.

* Other voltages available on special order.
* At listed voltage (peak current while sealing, not steady drain).

CONTROLS:
Automatic sealing temperature compensator; synchronous timers for heat & conveyor; other features similar to 6300 Series. Sealer with Thermoline optional feature Thermoline/Impulse mode selector switch.

4. ORDERING INSTRUCTIONS

In order to avoid delay in filling orders for parts, customers should follow the procedure recommended below:

1. State the machine name, model number, and serial number.
2. List the part number, part name, and part description of required part exactly as shown on the Replacement Parts List at the rear of this manual.
3. Specify the quantity desired.
4. Specify when needed.
5. Specify desired shipping method: Parcel Post, Truck, Air Freight, etc.

5. ASSEMBLY AND INSTALLATION

5.1 ASSEMBLY OF 70, 80, 90, AND 100-INCH SEALERS

The shorter units are one-piece machines, but, due to their length, the 70-inch, and longer, seal units (see page 3-2 for listing) are shipped in two sections. To assemble, proceed as follows:

a. Align both machine halves next to each other. Using bolts supplied in envelope, bolt the two halves of the sealer together. Insert rear head-shaft into bearing, fastening by means of bolts and shims supplied.

b. Plug the two power plugs into the two corresponding-type power sockets on the rear of the sealer.

c. Using the bolts supplied, mount the two legs and the lower cross-brace. Tighten all bolts securely.

d. Place assembled sealer in desired operating position.

5.2 INSTALLATION OF ALL MODELS

Locate the sealer in the desired position with the required electric power source available*. Make sure electric wiring is adequate to guard against low voltage. If the voltage is too low the power company can frequently adjust it to the proper level if the wiring capacity is adequate.

* See power requirements for each model in the charts of pages 3-1 & 3-2.

SAFETY REQUIREMENTS
&
RECOMMENDATIONS

CAUTION

DO NOT ATTEMPT TO INSTALL, ADJUST, OR OPERATE THIS MACHINE WITHOUT FIRST READING THE CONTENTS OF THIS MANUAL. ALTHOUGH THE DESIGN OF THIS EQUIPMENT INCORPORATES SAFEGUARDS TO PROTECT OPERATING AND MAINTENANCE PERSONNEL, CARE SHOULD BE USED IN OPERATING, ADJUSTING, AND SERVICING.

WHEN MACHINE IS UNPACKED, INSPECT CAREFULLY FOR POSSIBLE SHIPPING DAMAGE. IF ANY IS FOUND, CONTACT CARRIER IMMEDIATELY AND DO NOTHING FURTHER WITH MACHINE UNTIL CARRIER'S AGENT HAS MADE INSPECTION, REPORT, ETC.

The design of this machine includes safety features required to eliminate potential hazards during operation or maintenance.

Applicable OSHA, ANSI, NEMA, and NEC standards have been followed as guidelines in the design and construction of this machine. References are made in this text to special areas of CAUTION. It is strongly recommended that you familiarize yourself with these CAUTION statements.

Tampering with or removing safety devices and/or improper operation or maintenance can result in exposing personnel to possible injury.

Please become familiar with this machine and follow the recommendations for safe operation, maintenance, and sanitation in the following page.

WELDOTRON CORPORATION SAFETY RECOMMENDATIONS

SAFETY IS ENGINEERED INTO ALL WELDOTRON EQUIPMENT; CERTAIN PRACTICES AND MINOR ALTERATIONS BY THE USER COULD INCREASE THE POTENTIAL TO ACCIDENTS AND/OR INJURY. IN THE INTEREST OF SAFE INSTALLATION, OPERATION AND MAINTENANCE, THE FOLLOWING RECOMMENDATIONS SHOULD BE STRICTLY ADHERED TO:

1. WARNING

Do not attempt to start or operate the machine until all safety items, installation instructions, operator/s guide & maintenance procedures have been followed & understood.

2. CAUTION

Adjustments, repairs or lubrication should be performed only by qualified maintenance personnel and by following the instructions in this manual and the LOCKOUT/TAGOUT PROCEDURE.

3. WARNING

Operator must keep fingers, hands, clothing or long hair away from the machine while it is in operation.

4. CAUTION

Do not place or leave tools, parts or other objects in or on the machine.

5. ALWAYS

Disconnect the main electrical power supply before performing any electrical work or removing any electrical component.

6. ALWAYS

Keep the machine clean & lubricated and in good operating condition.

WELDOTRON SUPPLEMENTARY BULLETIN

AUXILIARY INSTRUCTIONS FOR 6400 Series Magna-Lok Sealers

TECHNICAL DOCUMENT NO.661
February, 1973

I. INTRODUCTION:

This Supplementary Bulletin provides Auxiliary Operating Instructions for the 6400 Series Magna-Lok Sealers. The 6400 Series Sealers are equipped with a powered package take-away conveyor. With the exception of the powered conveyor and the following information, the Sealer is the same as described in Technical Document No. 408-Operating and Maintenance Instructions for L-Series Sealers. A copy of which accompanies this Sealer.

II. OPERATING INSTRUCTIONS:

2-1 Refer to T.D. No. 408 paragraph 7 (starting on page 7-1) and make all adjustments and settings required.

2.2 Initially, set the CONVEYOR TIMER to approximately 1 second on its scale.

2.3 To operate the Sealer, press the sealing handle down. Immediately release hand pressure. The sealing head will remain down for the duration of the time set on the HEAT timer and will then rise. As the sealing head rises, the package take-away conveyor will transport the package away from the sealing area, making room for the next package and the next sealing operation.

2.4 In order to achieve maximum sealing speed and efficiency in production use of the sealer, the CONVEYOR timer setting should be set to move the package the minimum distance necessary to permit loading and sealing of the next package. It is not necessary to have each sealed package move entirely off the conveyor after sealing is completed. The package need move away from the sealing area only a distance sufficient to provide space for the next package to be properly sealed. To do this, experiment with different settings of the CONVEYOR timer until the desired package spacing is obtained.

III. CONVEYOR BELT ADJUSTMENT:

3-1 To adjust conveyor tracking and belt tension, turn the two adjustment bolts located at the shaft-ends on the right side of the conveyor (package infeed side) until correct tension and tracking is achieved.

6. FILM LOADING

NOTE

Refer to Figure 6.1 throughout for 6000 Series Sealers; refer to Figure 6.2 throughout for 6100, 6300, or 6400 Series Sealers.

6.1 MOUNTING THE FILM

a. Select the proper width of centerfold film for the item being packaged, allowing for width and height of package. With the package properly positioned within the film in the sealing area, allow sufficient film to overlap the sealing bars so that a seal can readily be made without any possibility of open areas due to insufficient film.

b. Lift film support shaft out of film supply rack.

c. Remove rear cone from film support shaft by loosening the locking lever and sliding cone off shaft.

d. Place film roll on film support shaft so that open edge of folded film is toward front of sealer.

e. Replace rear cone on film support shaft. Press cone firmly into film core and tighten cone's locking lever.

6.2 PACKAGE SUPPORT TRAY ADJUSTMENT

a. Place the package in the sealing position, on the support tray (in the case of the 6400 Series units, on the package conveyor).

b. Turn the height-adjustment knob (located on the front panel) until center-line of the package is even with the top surface of the front and side sealing pads. This will insure that the seal occurs along the center-line of the package.

6.3 THREADING THE FILM

a. Refer to either Figure 6.1 or 6.2 (see note at top of this page). Thread film under the roller and pull out several feet of film (sufficient to reach far end of package support tray).

b. Place sample package to be sealed between top and bottom layers of film. Position package against the folded (i.e., rear) edge of the film. Place package in the sealing position. Pull film containing package toward the front right-hand corner so package is almost touching both the front and side sealing pads.

c. Hold package within film in position on package support tray with left hand. With right hand, turn film supply reel to take up slack in film.

d. On all series except the 6000 Series, the lateral positioning of the film supply rack may be adjusted by tipping the rack slightly to the right and pushing or pulling the rack forward or backward until the rear edge of the film roll is in line with the rear edge of the package in the sealing position on the package-support tray. Remove package.

e. Loosen the film separator rod's lateral adjustment and position rod so rear end of rod is about 1 inch forward of folded (rear) edge of film. Tighten lateral adjustment.

f. Position adjustable loading tray so its rear edge is in line with rear end of film separator rod.

g. Open the film and slip the film separator rod and the adjustable loading tray between the upper and lower layers of film.

h. On 6000 Series Sealers, the film separator rod height is adjusted by means of the vertical-adjustment bolt (shown in Figure 6.1). Rod height should be as low as possible consistent with the height of the package being wrapped, in order to prevent excessive drag on the film. On 6100, 6300, and 6400 Series Sealers, the film separator rod height is adjusted by lifting and tipping the film roll rack to the right while raising or lowering the rubber-tipped height-adjusting bolt at the rear side of the roll rack. As with the 6000 Series, the rod should be kept as low as possible, as explained above.

i. As film is being pulled off the film roll of 6100, 6300, or 6400 Series Sealers, the friction brake should not touch the front cone of the reel. The brake should touch the cone when film is not being pulled off the roll. To increase braking turn the brake adjustment screw clockwise; to decrease braking turn screw counter-clockwise. Test action and readjust as required (see Figure 6.2).

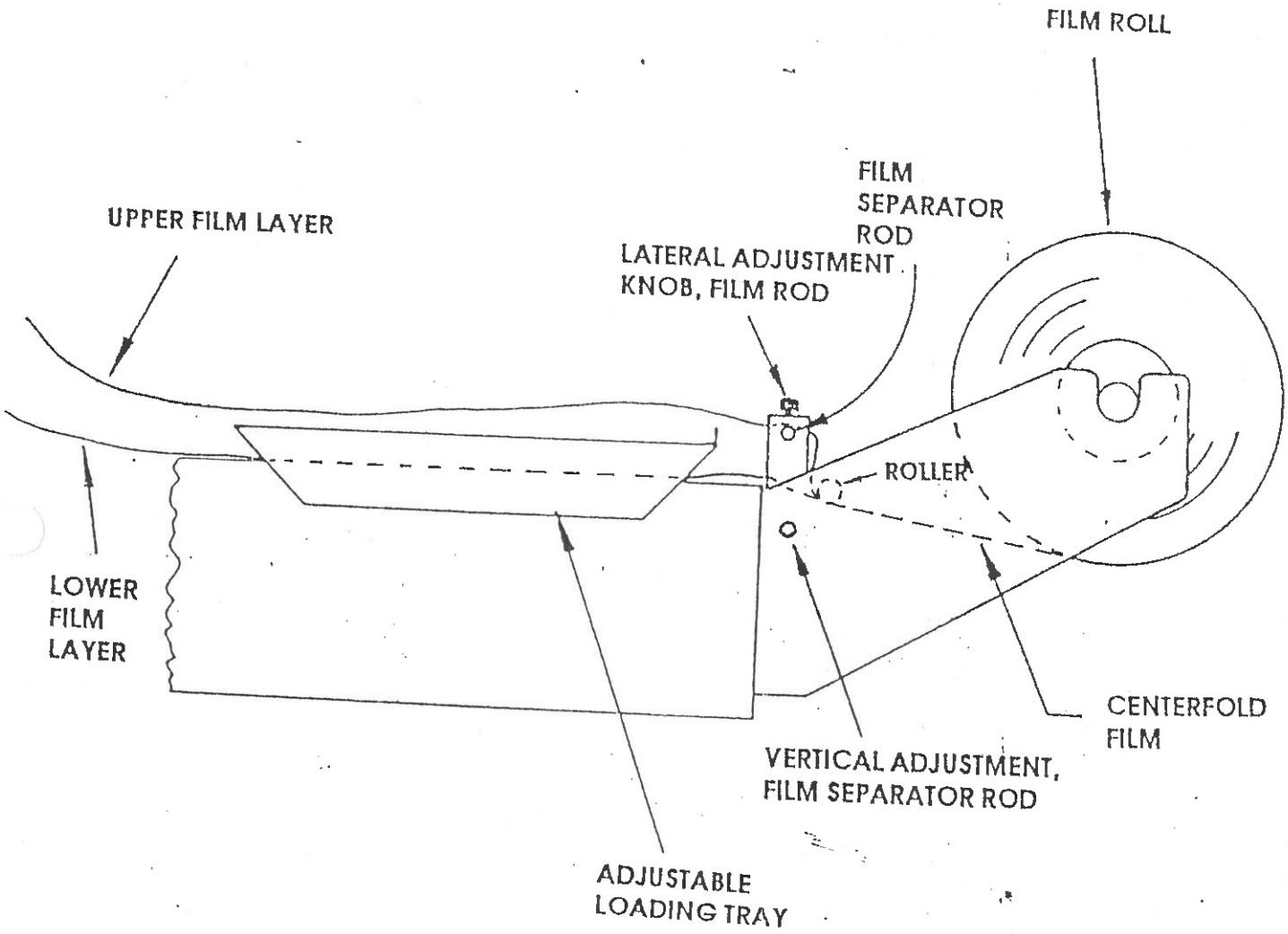


Figure 6.1 Film Threading Diagram, 6000 L-Sealer Series

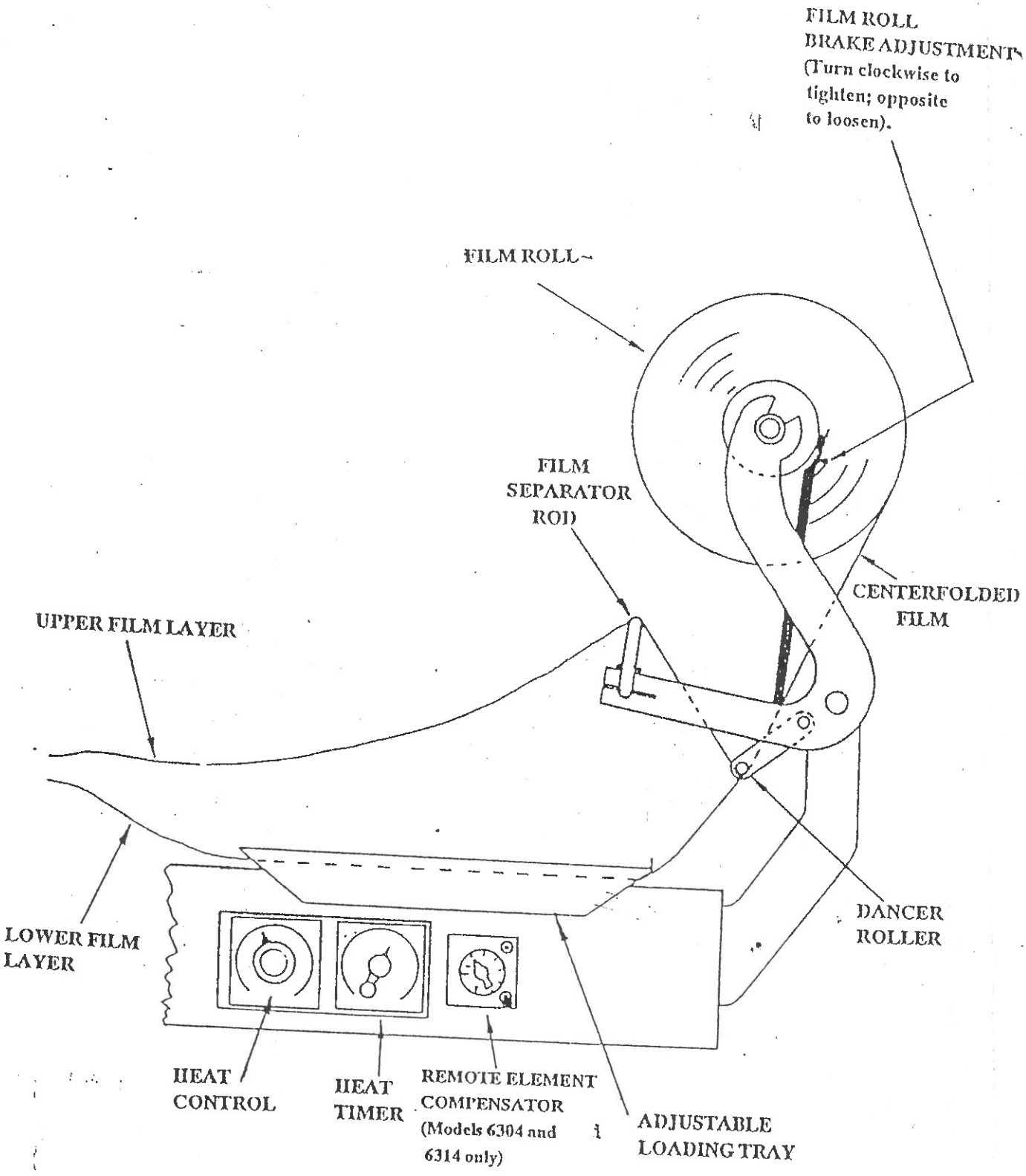


Figure 6.2 Film Threading Diagram, 6100, 6300, 6400 Series

7. OPERATION OF 6000 SERIES SEALERS

After performing film threading as described in paragraph 6, and as shown in Figure 6.1, plug the sealer's power cord into the proper power source as shown in the listing of paragraph 3.1.

Because of the importance of the adjustment of the Element Compensator to the successful operation of the sealer, the following explanation of its theory of operation is given.

THEORY OF OPERATION OF ELEMENT COMPENSATOR

Heat produced by the resistance of a wire to the passage of an electrical current causes the wire to increase in length. In as much as the expansion of the wire is in direct proportion to its length, and to its resistance to the passage of current, its increase in length due to heating can be used to actuate an electrical switch to shut off power to the wire, thus controlling its degree of heating. Refer to the appropriate paragraph below for specific adjustment instructions.

7.1 ADJUSTMENT OF ELEMENT COMPENSATOR FOR ALL FILMS EXCEPT POLYETHYLENE

Refer to Figure 10.1. (At the rear of Section 10 of this manual). Adjust the Element Compensator (located at the left end of the front sealing bar of View "A") by loosening the wing-nut and turning the knurled-head screw until a 1/32" air gap exists. With folded film (i.e., two layers of film) in the sealing position, bring down the sealing head. Hold the head down, in the sealing position, until about 1 second after the buzzer stops sounding, then raise. Examine the seal. Ordinarily, it will not be possible to obtain a satisfactory seal with the 1/32" gap setting. Experimentally, in small increments, increase the Element Compensator air gap setting until a setting is obtained which yields a satisfactory seal and film cut-off. It is important to remember that the smallest air gap at which a satisfactory seal and film cut-off is obtained is the correct setting, with the exception that the air gap may have to be increased slightly in order to produce a light brown residue at the seal point when using PVC films.

7.2 ADJUSTMENT OF ELEMENT COMPENSATOR FOR POLYETHYLENE FILM

Refer to Figure 10.1. (At the rear of Section 10 of this manual). On the Element Compensator, loosen the wing-nut and turn the knurled-head screw until a 1/16" air gap exists. Tighten the wing-nut. With folded film (i.e., two layers of film) in the sealing position, bring down the sealing head. Hold the head down, in the sealing position, until the buzzer stops sounding, then raise immediately. (On Magnalok Sealers, head will raise automatically). Examine the seal. Ordinarily, it will not be possible to obtain a satisfactory seal with the 1/16" gap setting. Experimentally; in small increments, increase the Element Compensator air gap setting until a setting is obtained which yields a satisfactory seal and film cutoff. It is important to remember that the smallest air gap at which a satisfactory seal and film cutoff is obtained is the correct setting.

7.3 INSTRUCTIONS FOR PRODUCTION OPERATION OF SEALER

After setting the Element Compensator for the film type in use (as in paragraph 7.1 or 7.2), proceed as follows:

a. With the film extended to the left, past the side seal bar, make an initial film seal on the roll of film intended for production use. Hold the film open with the left hand. With the right hand, slide the package into the upper left hand corner of the film (i.e., corner formed by folded rear edge of film and previously sealed left edge of film).

b. Using both hands, move package and film into lower right corner of sealing area and then slightly back, away from the corner formed by the sealing bars. This will allow some slack film between the package and the sealing bars.

c. Press sealing handle down. Buzzer will sound; indicating the heating (or sealing) cycle. Continue to hold operating handle down for about one second after the buzzer stops sounding in order to allow some cooling (or setting) time.

IMPORTANT

When sealing polyethylene, raise operating handle immediately after buzzer stops. Do Not allow for setting time with this material (exept the very briefest setting time if required, and as explained in paragraph 7.2).

d. Raise operating handle and pull off sealed and cut section of film. Remove sealed package from sealing area, ready for next package to be placed in the sealing position. This completes the description of operation for the 6000 Series Sealers.

8. OPERATION OF 6100, 6300, 6400 SERIES SEALERS

(See Section 7 for operation of 6000 Sealers Series).

NOTE

The instructions which follow are for machines which were factory-equipped for use in the Impulse Sealing mode. Instructions for operation of machines which were factory-equipped for Thermoline Sealing are given in paragraph 8.4.

8.1 PRELIMINARY

a. Refer to Figure 6.2. Before plugging in the sealer to its power source, turn the front-panel toggle switch to its "IMPULSE" sealing position (to prevent immediate continuous heating of the sealing elements).

b. After performing film threading as described in Section 6, and as shown in Figure 6.2, set controls as follows:

FILM MATERIAL	HEAT CONTROL TAP NUMBER	HEAT TIMER	CONVEYOR TIMER* (on 6400 Series)
PVC	3	0.5 SEC.	0 SEC. (FULL LEFT)*
POLYPROPYLENE	4	0.5 SEC.	0 SEC. (FULL LEFT)*
D-925	6	0.5 SEC.	0 SEC. (FULL LEFT)*
POLYETHYLENE	6	0.25 SEC.	0 SEC. (FULL LEFT)*

* See paragraph 8.3 for production use setting instructions.

8.2 ELEMENT COMPENSATOR ADJUSTMENT

Because of the importance of the adjustment of the Element Compensator to the successful operation of the sealer, the following explanation of its theory of operation is given.

THEORY OF OPERATION OF ELEMENT COMPENSATOR

Heat produced by the resistance of a wire to the passage of an electrical current causes the wire to increase in length. In as much as the expansion of the wire is in direct proportion to its length, and to its resistance to the passage of current, its increase in length due to heating can be used to actuate an electrical switch to shut off power to the wire, thus controlling its degree of heating. Refer to the appropriate paragraph below for specific adjustment instructions.

8.2.1 Element Compensator Adjustment for All Films Except Polyethylene on All But 70-Inch or Longer Machines

Refer to Figure 10.1 (at the rear of Section 10). Adjust the Element Compensator (located at the left end of the front sealing bar of View "A") by loosening the wing-nut and turning the knurled-head screw until a 1/32" air gap exists. With folded film (i.e., two layers of film) in the sealing position, bring down the sealing head. In the case of 6100 Series units, hold the head in sealing position until about 1 second after the buzzer stops sounding. In the case of 6300 and 6400 Series units, release hand pressure on the sealing head operating handle. The head will remain down for the proper time and then will rise. Examine the seal. Ordinarily, it will not be possible to obtain a satisfactory seal with the 1/32" gap setting. Experimentally, in small increments, increase the Element Compensator air gap setting until a setting is obtained which yields a satisfactory seal and film cutoff. It is important to remember that the smallest air gap at which a satisfactory seal and film cutoff is obtained is the correct setting, with the exception that the air gap may have to be increased slightly in order to produce a light brown residue at the seal point when using PVC films.

8.2.2 Element Compensator Adjustment for Polyethylene Film on All But 70-Inch or Longer Machines

Refer to Figure 10.1 (at the rear of Section 10). On the Element Compensator, loosen the wing-nut and turn the knurled-head screw until a 1/16" air gap exists. Tighten wing-nut. With folded film (i.e., two layers of film) in the sealing position, bring down the sealing head. Hold the head down, in the sealing position, until the buzzer stops sounding, then raise immediately. (On Console and Magnalok Sealers head will raise automatically). Examine the seal. Ordinarily, it will not be possible to obtain a satisfactory seal with the 1/16" gap setting. Experimentally, in small increments, increase the Element Compensator air gap setting until a setting is obtained which yields a satisfactory seal and film cutoff. It is important to remember that the smallest air gap at which a satisfactory seal and film cutoff is obtained is the correct setting.

8.2.3 Element Compensator Adjustment for All Films Except Polyethylene on 70-Inch or Longer Machines

On the 70" and longer seal length machines, the Element Compensator (located at the right on the sealer's control panel) is adjusted for use with all types of film except polyethylene in the following manner:

a. Actuate and hold the Element Compensator's toggle switch while turning the Compensator knob clockwise until the pilot light comes on.

b. Release the toggle switch. Pilot light will go out.

c. The Compensator is now set at zero effect. Turn the movable dial scale (not the knob) until zero on the dial scale coincides with the position of the pointer on the knob.

d. Set the sealer's front panel timer to maximum time (30). Turn the Compensator knob counterclockwise one-half of a scale increment. With folded film (i.e., two layers of film) in the sealing position, bring down the sealing head, then release hand pressure on the operating handle. The head will remain down for the proper time and then will rise. Examine the seal and film cutoff obtained. If not satisfactory, turn the Compensator knob counterclockwise an additional one-half of a scale increment. Make a seal. If required, repeat until satisfactory film seal and cutoff is obtained.

e. Notice that every time the sealer is pulsed to make a seal, the Element Compensator pilot light will light at the end of the seal (or heat) cycle to indicate the length of the dwell period during which the sealing head is retained in its downward position. Note, also, that since these are Magna-Lok machines, the length of the dwell period may be varied by changing the setting of the front panel timer.

8.2.4 Element Compensator Adjustment for Polyethylene Film on 70-Inch or Longer Machines

On the 70" and longer seal length machines, the Element Compensator (located at the right on the sealer's control panel) is adjusted for use with polyethylene film in the following manner:

a. Actuate and hold the Element Compensator's toggle switch while turning the Compensator knob clockwise until the pilot light comes on.

b. Release the toggle switch. Pilot light will go out.

c. The Compensator is now set at zero effect. Turn the movable dial scale (not the knob) until zero on the dial scale coincides with the position of the pointer on the knob.

8.2.4 Element Compensator Adjustment for Polyethylene Film on 70-Inch or Longer Machines (cont'd)

d. Set the sealer's front panel timer to maximum time (30). Turn the Compensator knob counterclockwise one-half of a scale increment. With folded film (i.e., two layers of film) in the sealing position, bring down the sealing head, then release hand pressure on the operating handle. The head will remain down for the proper time and then will rise. Examine the seal and film cutoff obtained. If not satisfactory, turn the Compensator knob counterclockwise and additional one-half of a scale increment. Make a seal. If required, repeat until satisfactory film seal and cutoff is obtained.

e. Notice that every time the sealer is pulsed to make a seal, the Element Compensator pilot light will light at the end of the seal (or heat) cycle. The sealing head should raise immediately.

8.3 INSTRUCTIONS FOR PRODUCTION OPERATION OF SEALERS

After setting the heat timer and the heat control tap switch as described in paragraph 8.1, and the Element Compensator as described in the proper sub-paragraph of Section 8.2 for the sealer and film in use, proceed as follows:

a. With the film extended to the left, past the side seal bar, make an initial film seal on the roll of film intended for production use. Hold the film open with the left hand. With the right hand, slide the package into the upper left corner of the film (i.e., corner formed by folded rear edge of film and previously sealed left edge of film).

b. Using both hands, move package and film into lower right corner of sealing area and then slightly back, away from the corner formed by the sealing bars. This will allow some slack film between the package and the sealing bars.

NOTE

Steps c. and d., which follow, apply only to 6100 Series (manual) Sealers, not to 6300 & 6400 Series (Magna-Lok) Sealers.

c. Bring sealing handle down. Buzzer will sound, indicating the heating (i.e., sealing) cycle. Continue to hold operating handle down for about one second after the buzzer stops sounding in order to allow some cooling (or setting) time.

IMPORTANT

WHEN SEALING POLYETHYLENE, RAISE OPERATING HANDLE IMMEDIATELY AFTER BUZZER STOPS. DO NOT ALLOW FOR SETTING TIME WITH THIS MATERIAL.

d. Raise operating handle and pull off sealed and cut section of film. Remove sealed package from sealing area, ready for next package to be placed in the sealing position.

NOTE

The steps which follow apply only to 6300 & 6400 Series (Magna-Lok) Sealers, not to 6100 Series (manual) Sealers.

e. Press sealing handle down. Immediately release hand pressure. The sealing head will remain down for the duration of the time set on the heat timer. The cooling period is the time difference between the Compensator-set sealing heat application time and the over-all heat timer setting. To raise or lower cooling time, vary the setting of the heat timer.

IMPORTANT

WHEN SEALING POLYETHYLENE:

1. THROW "IMPULSE-THERMOLINE" SWITCH TO IMPULSE.

f. During the time the sealing head is being held down by the action of the Magna-Lok electromagnets (the operator having removed his hand from the operating handle), it is not necessary to wait. The operator can load the next package into the package loading area, thus speeding up sealing operation.

g. On 6300 Series Sealers, as soon as the sealing head rises, move the first package away from the sealing area and place the second package in position for sealing. Another package is then placed in the loading area and inserted in the film while the sealing operation is occurring on the previous package.

h. On 6400 Series Sealers, initially set the CONVEYOR timer to approximately 1 second on its scale. Continuing from step f. above, as the sealing head rises, the package take-away conveyor will transport the package away from the sealing area, making room for the next package and the next sealing operation.

8.3 INSTRUCTIONS FOR PRODUCTION OPERATION OF SEALERS (cont'd)

i. In order to achieve maximum sealing speed and efficiency in production use of 6400 Series Sealers, the CONVEYOR timer setting should be set to move the package the minimum distance necessary to permit loading and sealing of the next package. It is not necessary to have each sealed package move entirely off the conveyor after sealing is completed. The package need move away from the sealing area only the minimum distance needed to provide space for the next package to be properly sealed. To do this, experiment with different settings of the CONVEYOR timer until the desired package spacing is obtained.

8.4 INSTRUCTIONS FOR OPERATION IN THERMOLINE SEALING MODE

NOTE

The instructions which follow are for machines which were factory-equipped for use in the Thermoline Sealing mode.

This is an optional feature.

a. Refer to Figure 6.2. Before plugging in the sealer to its power source, temporarily throw the front-panel toggle switch to its "IMPULSE" sealing position (to prevent immediate continuous heating of the sealing elements).

b. Refer to Figure 10.1 (at the rear of Section 10). Adjust the Element Compensator (located at the left end of the front sealing bar of View "A") by loosening the wing-nut and turning the knurled-head screw until the maximum possible air gap exists. Tighten the wing-nut.

c. Turn the front panel HEAT CONTROL tap switch to tap no. 4.

d. Set the HEAT timer to about 1/4-th second.

e. Turn the "IMPULSE" - "THERMOLINE" toggle switch to its "THERMOLINE" position.

f. Plug in the sealer to the power source. The sealing elements will now become continuously heated as long as the sealer is plugged in and the toggle switch is in the "THERMOLINE" position.

g. Thread film as described in paragraph 6, and as shown in Figure 6.2, of this manual.

h. Extend the film to the left, past the side seal bar. To make an initial film seal on a 6100 Series (manual) sealer, bring down the operating handle and hold down for the duration of the buzzer sound. Immediately raise the handle when the buzzer stops sounding. To make an initial film seal on a 6300 or 6400 Series (Magna-Lok) sealer, bring down the operating handle. Immediately release hand pressure. The sealing head will remain down for the duration of the time set on the HEAT timer.

8.4 INSTRUCTIONS FOR OPERATION IN THERMOLINE SEALING MODE (cont'd)

i. After the sealing head is up, inspect the seal. If not satisfactory, readjust the HEAT timer setting slightly and/or the HEAT CONTROL tap switch setting, experimentally, until good seals are obtained. No exact setting instructions can be given, as exact settings will vary depending upon the various gauges and types of film which may be used.

j. When a satisfactory initial film seal has been made, hold the film open with the left hand. With the right hand, slide the package into the upper left corner of the film (i.e., corner formed by folded rear edge of film and previously sealed left edge of film).

k. Using both hands, move package and film into lower right corner of sealing area and then slightly back, away from the corner formed by the sealing bars. This will allow some slack film between the package and the sealing bars.

l. Depress the operating handle. On 6100 Series units hold down for the duration of the buzzer sound and immediately raise handle when buzzer stops sounding. On 6300 and 6400 Series units, after bringing down the operating handle, immediately release hand pressure. The sealing head will remain down for the duration of the time set on the timer.

m. Remove sealed package from sealing area, ready for next package to be placed in the sealing position.

n. Continue production sealing operations, using the operating techniques described in paragraphs 8.3 f., g., h., and i. above.

CAUTION

When the sealer is not in use, be sure to throw toggle switch to the "IMPULSE" position, as the sealing elements would be on continuously if left in the "THERMOLINE" position.

9. SERVICE ADJUSTMENTS

9.1 ELEMENT COMPENSATOR ADJUSTMENT

Adjustment of the Element Compensator may be required under the following conditions:

a. During continuous use. After about 15 minutes of sealer operation, check seal quality and, if required, reset Compensator. This may be needed as a result of heat build-up in the sealing head and in the sealing element wire.

b. After installing new sealing elements.

c. If charring of film is noted (too much heat).

d. If sealing is incomplete (too little heat).

To adjust the Element Compensator, refer to the adjustment instructions given in paragraph 7 or 8, as applicable to the specific sealer-type in use.

9.2 SEALING ELEMENT CLEANING

Seal quality is greatly affected by dirt or deposit build-up. Some plastic films have a tendency to produce deposits on the sealing elements. This build-up can be inhibited by the application of a release agent, such as type 2250 Weldotron "Therm-O-Seal", to the sealing elements. If build-up is severe, * the elements may be cleaned by applying several passes of a fine-bristled brass brush. Never use steel wool for sealing element cleaning. Cleaning is easier when the elements are hot. Momentarily pulse the sealer (by pressing and releasing the pulse switch located near the rear end of the side sealing bar) to heat up the elements, then clean immediately. Do Not use the brush on the elements when the pulse switch is depressed.

Severe film residue build-up may indicate improper Element Compensator adjustment. Use the procedure described in paragraph 7 or 8 which applies to the machine in use.

LOCKOUT/TAGOUT PROCEDURE (OSHA Standard 1910.147) (THE CONTROL OF HAZARDOUS ENERGY)

WARNING

This standard covers the servicing and maintenance of machines and equipment in which the unexpected energization or start up of the machines or equipment, or release of stored energy could cause injury to employees. This standard establishes minimum performance requirements for the control of such hazardous energy.

APPLICATION

This standard applies to the control of all energy during servicing and/or maintenance of Weldotron machines and equipment.

PURPOSE

This procedure establishes the minimum requirement for the lockout or tagout of energy isolating devices. It shall be used to ensure that the machine or equipment is isolated from all potentially hazardous energy and locked out or tagged out before employees perform any servicing or maintenance activities.

RESPONSIBILITY

Appropriate employees (Maintenance employees and Machine set-up employees) must be instructed in the safety significance of the lockout (tagout) procedure. Each person transferred or newly hired into such positions shall be trained at time of hire or transfer.

PREPARATION FOR LOCKOUT/TAGOUT

Identify all isolating devices to be certain which switches, valves, or other energy isolating devices apply to the equipment to be locked or tagged out.

1. Electrical boxes - Power off, remove fuses.
2. Air - disconnect air.
3. Placing a tag on machine, indicates the machine is disconnected from power and out of service.

SEQUENCE OF LOCKOUT OR TAGOUT SYSTEM PROCEDURE

1. Notify all affected employees that a lockout or tagout system is going to be utilized and the reason therefore, i.e.: Foreman and operator.

2. Shut down equipment by normal stopping procedure.

3. Open switch, disconnect air, and unplug equipment isolating it from its energy source. Stored energy (such as that in springs, elevated machine members, rotating flywheels, hydraulic systems, and air, gas, or water pressure, etc.) must be dissipated or restrained by methods such as repositioning, blocking, bleeding down, etc.

4. Lockout and/or tagout the energy isolating devices with assigned individual locks or tags. In the case of a disconnect switch tagout and/or lockout. In the case of a plug, unplug, and tagout.

5. After ensuring that no personnel are exposed and as a check on having disconnected the energy sources, operate the pushbutton or other normal operating controls to make certain the equipment will not operate.

> **CAUTION**
>
> Return operating controls to "NEUTRAL" or "OFF" position after test.

6. The equipment is now in a lockout and /or tagout condition.

RESTORING MACHINE OR EQUIPMENT TO NORMAL PRODUCTION OPERATIONS

1. After servicing and/or maintenance is complete and equipment is ready for normal use, check the area around the machine or equipment to ensure that no one is exposed.

2. After all tools have been removed from the machine or equipment, guards have been reinstalled and employees are in the clear, remove all lockout or tagout devices. Reinstall fuses and undo any other energy isolating devices to restore energy to the machine or equipment.

PROCEDURE INVOLVING MORE THAN ONE PERSON

In the preceding steps, if more than one person is required to lockout or tagout equipment, each shall place his or her own personal lockout device or tagout device on the energy isolating device. Maintenance personnel will use multiple locks. When mechanic and electrician work together, each will tagout the plug and no one but the person installing the tag can remove it and equipment is not to be plugged in with any tagout on it.

BASIC RULES FOR USING LOCKOUT OR TAGOUT SYSTEM PROCEDURE

All equipment must be locked out or tagged out to protect against accidental or inadverted operation when such operation could cause injury to personnel. Do not attempt to operate any switch, valve, or other energy isolating device where it is locked or tagged out.

10. MAINTENANCE

10.1 SEALING ELEMENT REPLACEMENT

The sealing elements are subject to constant wear, and will eventually require replacement. To replace sealing elements, proceed as described below. Refer to Figures 10.1, 10.5, and 10.6.

10.1.1 Front Element

a. Refer to view "A" of Figure 10.1. Remove heat sink by removing screws "A". Remove old sealing element by pushing it out to the left.

b. Referring to view "A", loosen the knurled-head nut on the right termination unit. Straighten the hook at the top of the old sealing element and pull the element out toward the bottom.

c. To install a new element, use a pair of long-nose pliers to form a small loop at the end of the element having about a two-inch long area of polished material. Insert the element into the left termination unit, from the left, so the element extends to the right.

d. With the left hand, compress the left termination unit fully inward toward the right. Using the right hand, depress the element compression-retaining pin. Release left-hand pressure on the left termination unit. The unit is now held compressed by the compression-retaining pin.

e. With the sealing element's left-end loop firmly pressed into the left termination unit after insertion as in c. above, lay the element in the ceramic bead track and, at the point on the element at which it intersects the hole in the crossover bead, mark the element with a pencil.

f. Using the long-nose pliers, grip the element at the point where the pencil mark was inscribed and bend the element upward 90 degrees at this point.

g. Insert the upward-bent right end of the element into the hole in the crossover bead, making sure to insert the wire to the left of the side sealing element.

h. With the right end of the element inserted into the hole in the crossover bead so that the end of the element protrudes above the top of the sealing bar, tighten the knurled-head nut moderately with a screwdriver so as not to damage the wire. Make sure the element is firmly and properly positioned in the bead track for the entire length. Pull up on the element compression-retaining pin. Element is now securely in place, under tension, in the ceramic bead track. Using the long-nose pliers, form a small hook in the right end of the element, as shown in View "A" of Figure 10.1.

i. Replace heat sink by means of screws "A". Make sure heat sink is flat and is in firm contact with the sealing element.

10.1.2 Side Element

a. Refer to View "B" of Figure 10.1. Remove heat sink by removing screws "A". Remove old sealing element by pushing it out to the rear of the sealer.

b. Referring to View "B", loosen the wing-nut and pull out the other piece of the old element.

c. Using a pair of long-nose pliers, form a small loop at the end of the new sealing element which has about a two-inch long area of polished material. Insert the element into the rear element termination unit, from the rear, so the element extends toward the front of the sealer.

d. Referring to View "B" of Figure 10.1, compress the rear termination unit fully inward, toward the front of the sealer. Depress the element compression-retaining pin. Release hand pressure on the rear termination unit. The unit is now held compressed by the compression-retaining pin.

e. With the element's rear-end loop pressed firmly against the rear termination unit, lay the element in the ceramic bead track and insert the front end of the element into the hole in the front termination unit. Tighten the wing-nut on the front termination unit securely, using hand pressure. Make sure the element is firmly and properly positioned in the bead track for its entire length. Pull up on the element compression-retaining pin. The element is now securely in place under tension.

f. Replace heat sink by means of screws "A". Make sure heat sink is flat and is in firm contact with the sealing element.

IMPORTANT

After replacing sealing elements, be sure to adjust the setting of the Element Compensator, as described in the applicable procedure of paragraph 7 or 8.

10.2 TAPE REPLACEMENT

The item most subject to wear on the sealer is the Teflon-Fiberglas tape used to cover the silicone sponge rubber sealing bar. This tape should never be permitted to burn through so much that the thinner tape underneath can cut through. To replace tape, proceed as follows:

a. Strip off old tape.

b. Cut off proper length of new Teflon-Fiberglas tape, peel off white backing, and press new tape into position.

10.3 SILICONE RUBBER SEALING PAD REPLACEMENT

Occasionally it will be necessary to replace the silicone rubber sealing pads. This should be done if the following effects are noted:

Gaps in the seal.

Weak seals.

Improper film cut-off.

If excessive sealing pressure is required.

To replace the rubber, proceed as follows:

a. Refer to Figure 10.2. Using an allen-wrench, loosen all four screws "A" and remove both sealing bars from the sealer.

b. Strip off the two-inch wide and the 3/8-inch wide tapes.

c. Lay proper length of rubber in place. If one piece of the proper length is not available, it is perfectly satisfactory to use several short sections to make up the required length.

d. Replace the old tapes with new lengths of both types.

e. Replace the sealing bars on screws "A". Perform the sealing bar pressure adjustment described in paragraph 10.4 below.

10.4 SEALING PAD PRESSURE ADJUSTMENT

Uniform pressure between the sealing elements and the sealing pads must always be maintained for proper sealing uniformity, and to prevent element hot-spots and premature burn-out. This adjustment should be checked periodically, and should always be checked when sealing gaps occur. Proceed as follows:

a. Disconnect the sealer's power plug from the power source. Referring to Figure 10.2, loosen all four screws "A" just enough to maintain a moderate sliding pressure.

10.4 SEALING PAD PRESSURE ADJUSTMENT (cont'd)

b. Cut six strips of film, each about 3" x 6". Lay three of them across the front sealing bar, and the other three across the side sealing bar, with the 6" length extending.

c. Grasp the sealer's operating handle at its exact center and hold down firmly. Push up on the sealing bars. Inspect visually. There should be no light visible between the sealing pads and the sealing head. Tighten all four screws "A".

d. With the sealing head still down, pull the film strips back and forth. All should have the same resistance or "drag". If not, repeat steps a., b., and c. until uniform pull is obtained on all film strips.

10.5 ELEMENT PULSE SWITCH ADJUSTMENT

The sealing cycle should not begin until the sealing head has made proper contact with the film to be sealed and with the sealing pad. If the buzzing sound, indicating the beginning of the sealing cycle, is heard before the head is fully down onto the film, loosen the wing-nut and turn the screw (located at the rear end of the side seal bar) up slightly (counterclockwise as viewed from above). The correct adjustment has been obtained when slight additional hand pressure on the operating handle produces a normal sealing-cycle buzzing sound. If the sound is not heard, turn the screw down slightly (clockwise as viewed from above). When adjustment is correct, tighten the wing-nut.

10.6 CONTACTOR CR-1 CONTACT CLEANING AND REPLACEMENT

If the contacts of contactor CR-1 (used for element pulsing) should require cleaning or replacement due to pitting or burning, proceed as follows:

a. Disconnect sealer's power plug from power source socket. Remove package loading tray, and unscrew and remove the sheet metal retaining screws from the electrical chassis top cover plate (located under the package loading tray).

b. Refer to Figure 10.3. Remove the two screws "A" and lift off contactor CR-1's top cover plate.

c. Press down on spring retainer "B" and slide off along slot.

d. Remove spring "C" and plate "D".

e. Remove contact plate "E".

10.6 CONTACTOR CR-1 CONTACT CLEANING AND REPLACEMENT (cont'd)

f. Using a soft brush, saturate contacts (including the stationary ones on the contactor itself) with carbon tetrachloride. Allow to dry. A soft cloth may be used but make sure no threads are left on the contacts. Do not touch or scrape surface of contacts.

CAUTION

Never use emery cloth or anything that may abrade contact surfaces.

g. To replace contacts (or install new ones if contacts are badly pitted), place contact plate "E" back on stud, replace plate "D", replace spring "C" (with small end upward) and replace spring retainer "B".

h. Replace contactor cover plate and screws "A".

NOTE

Although scraping or filing of contacts is not recommended, a fine file may be used to clean badly pitted contacts, as a temporary measure only, until new contacts have been installed. After filing, clean contacts with carbon tetrachloride to remove any loose particles.

10.7 ADJUSTMENT OF MAGNA-LOK MAGNETS FOR CORRECT SEALING PRESSURE

In order to obtain the full advantages of increased accuracy and uniformity of sealing pressure possible with the Magna-Lok feature of the 6300 Sealers Series, all magnets have been factory-adjusted for equal holding pressure and correct and uniform distribution of sealing pad pressure throughout the length of both the front and the side seal bars. If, however, adjustment is ever required, proceed as follows:

a. Disconnect the sealer's power plug from the power source.

b. Refer to Figure 10.4. Loosen the lower magnet screws on all lower magnets so that the magnets settle to their lowest position in their mounting slots.

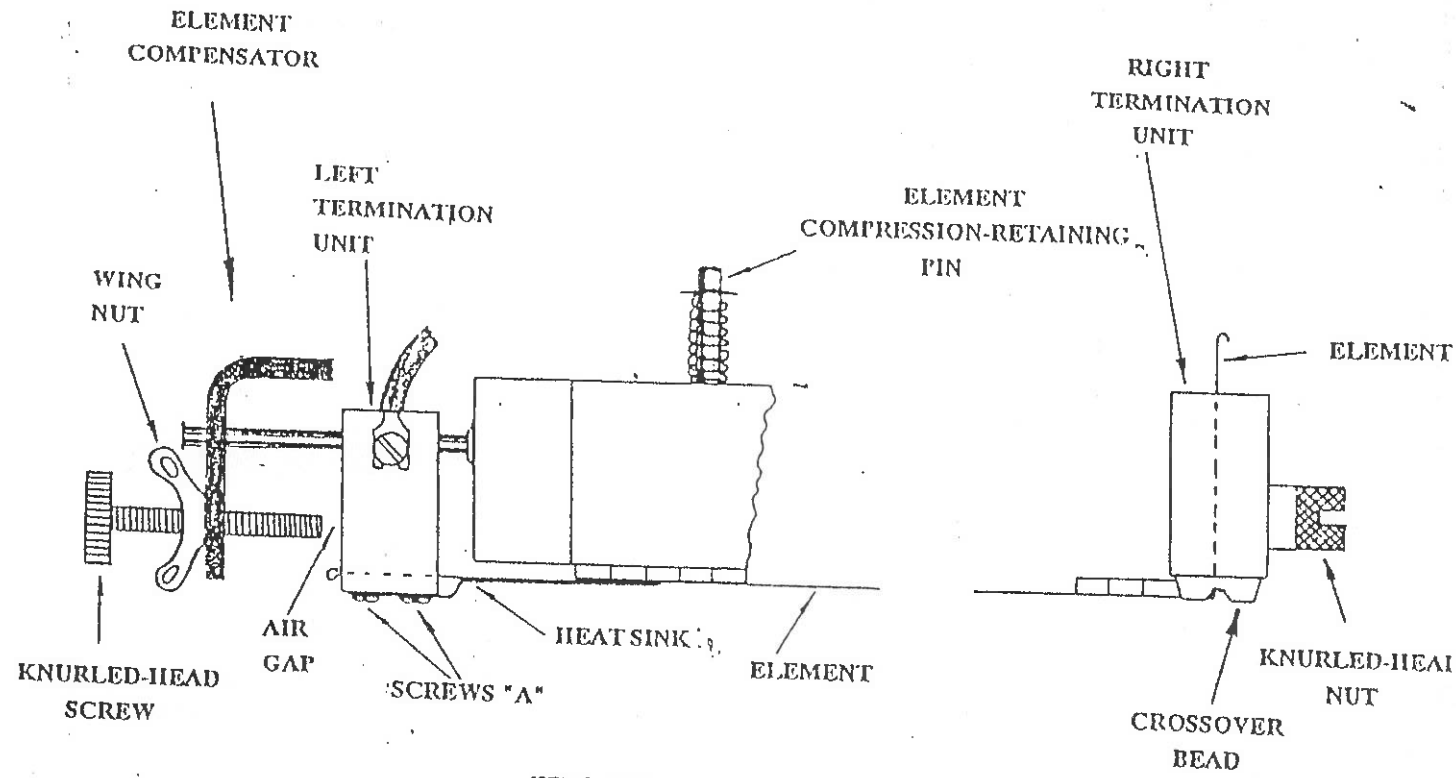
c. Lower the sealer's operating handle fully and hang the special weight* onto the operating handle, centered at the middle of the handle.

d. With the weight in place on the handle, raise the vertical positioning of all lower magnets until they just contact the bottom surface of the upper magnets. Tighten the mounting screws securely to retain the proper adjustment.

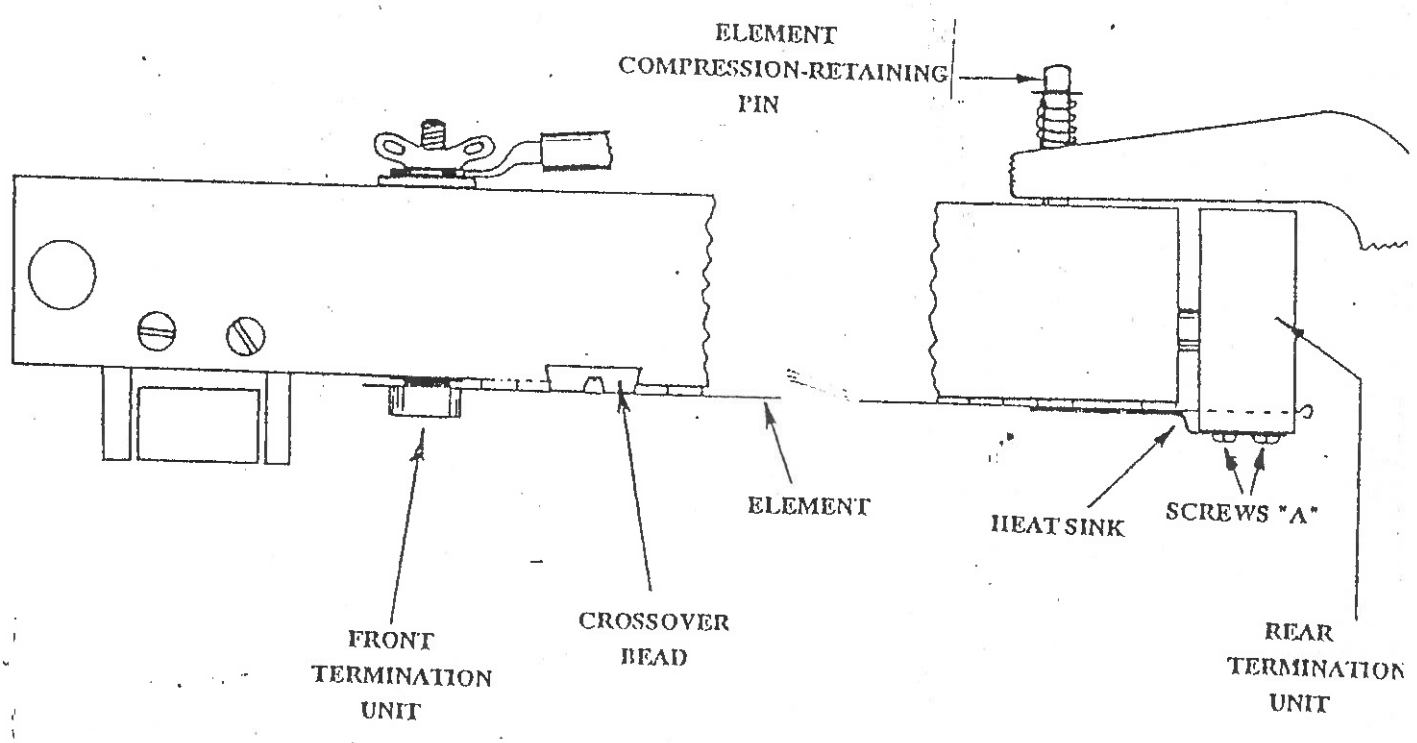
* As shown on Figure 10.4, the special weight should be fabricated from a piece of cold-rolled steel 3" x 3" x 11-3/4" with the mounting hooks spaced 9 inches apart and centered equally from the ends of the steel bar.

NOTE

This represents the type of weight acutally used for factory adjustment but any type of weight may be used provided it clears the front of the machine and is hung either from one point at the center of the operating handle, or from two points equidistant fr` ` `the center of the handle.



VIEW "A", FRONT SEALING BAR



VIEW "B", SIDE SEALING BAR

Figure 10.1 Compensator Air Gap Adjustment, and Element Replacement

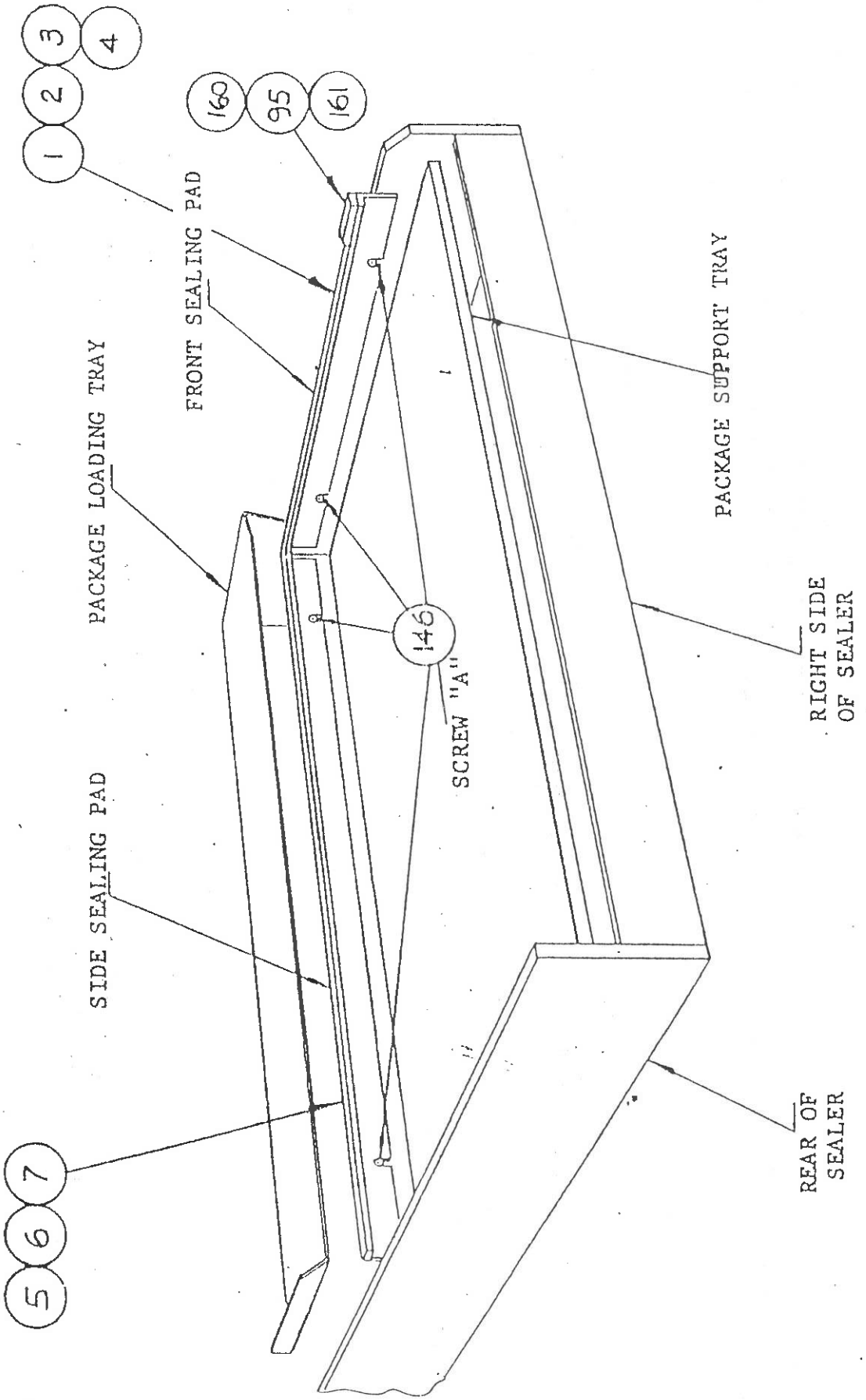


Figure 10.2 Sealing Pad Maintenance

TOP VIEW OF CONTACTOR

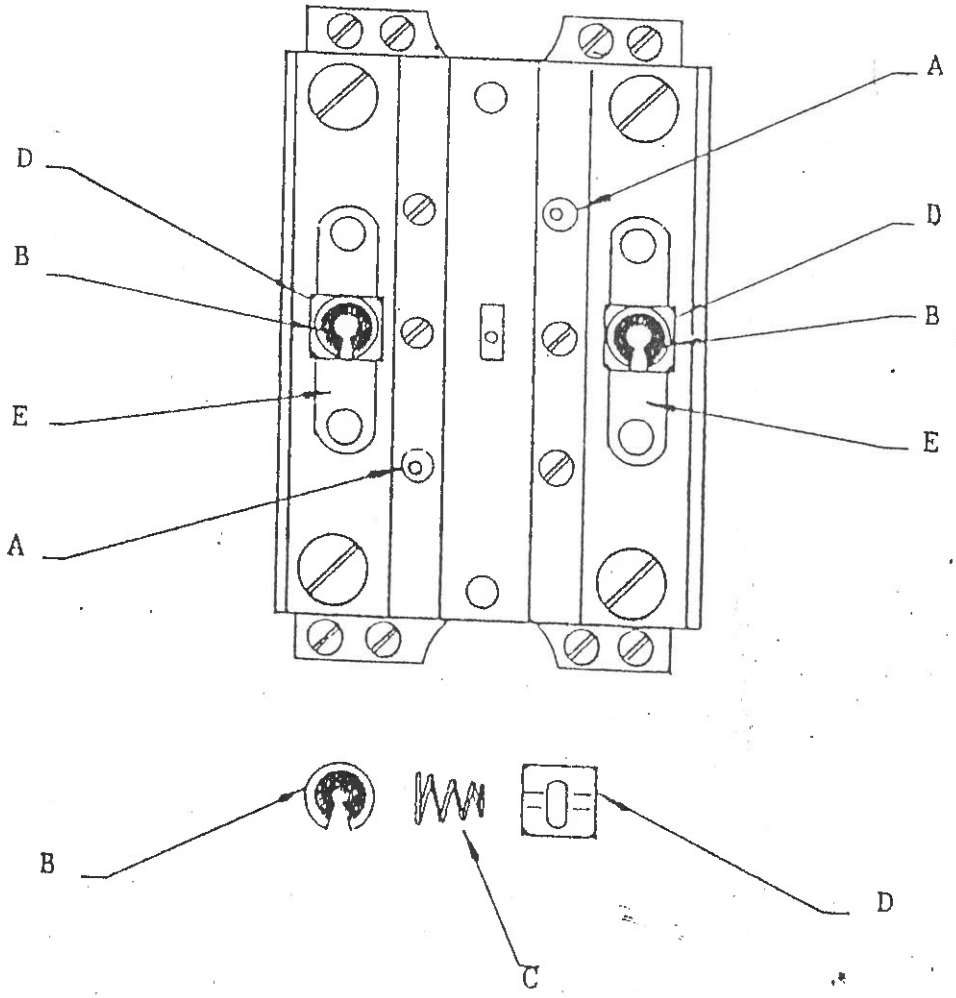


Figure 10.3 Contactor CR-1 Contact Cleaning and Replacement

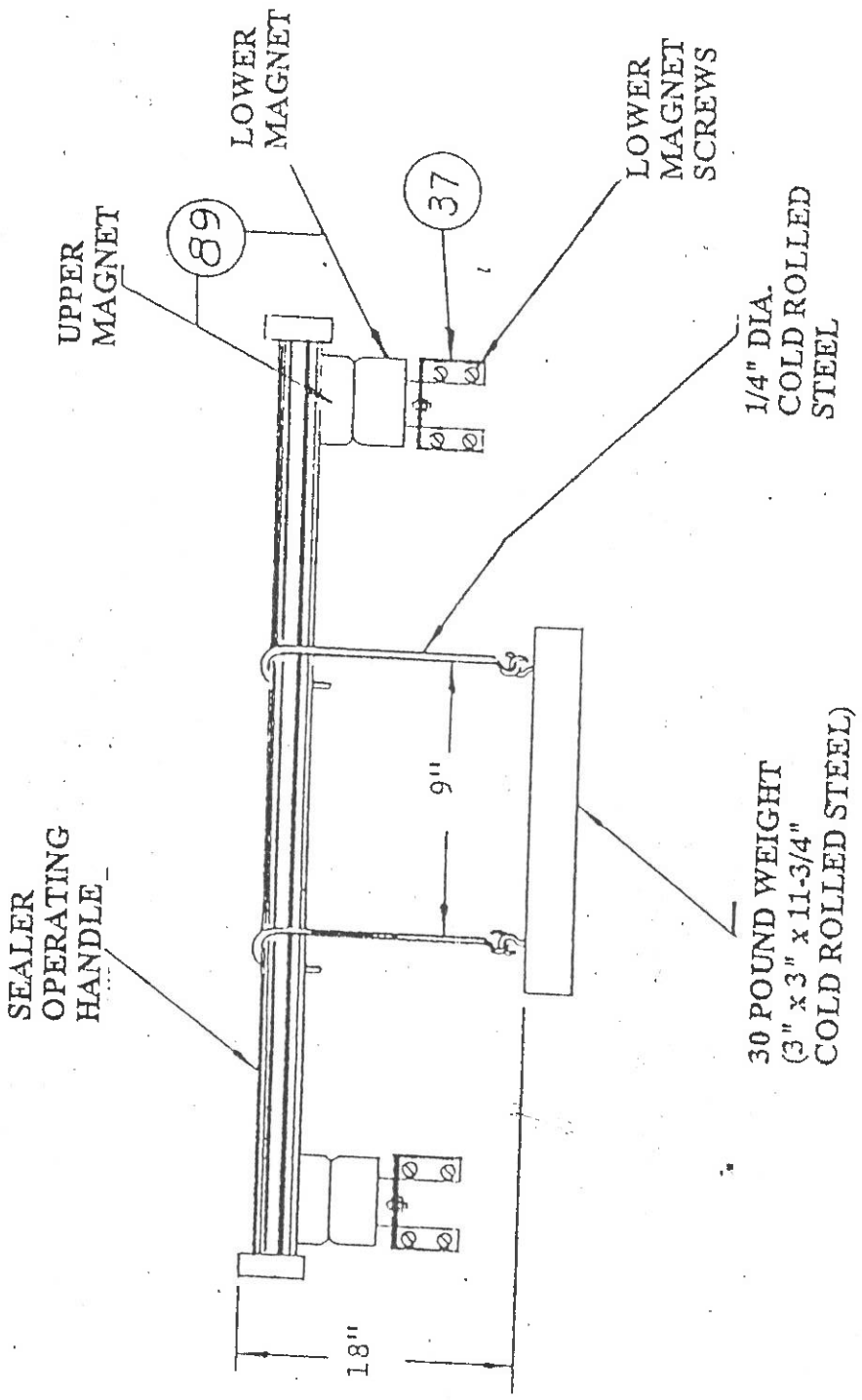


Figure 10.4 Adjustment of Magna-Lok Sealing Pressure

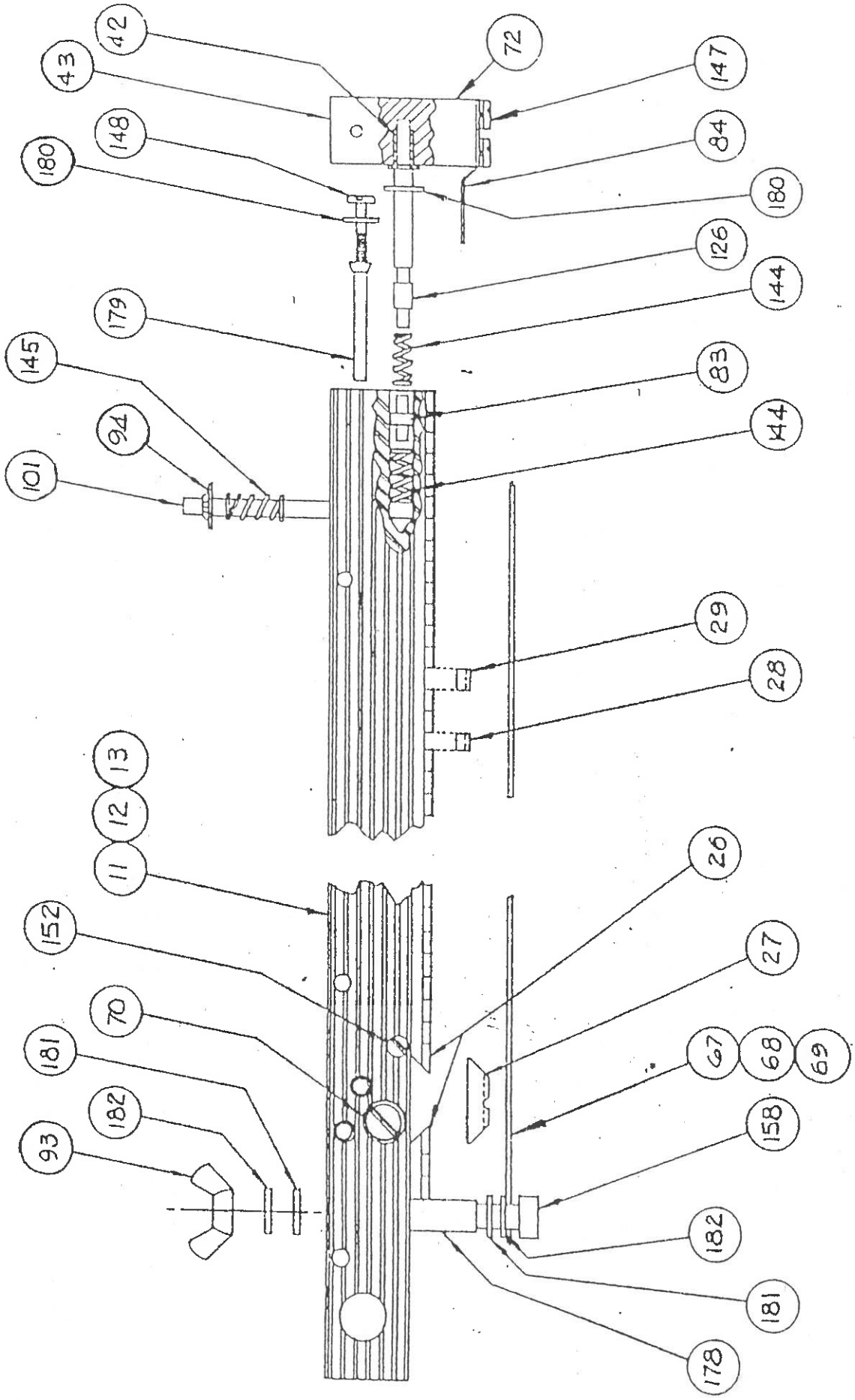


Figure 10.6 Electrode Bar Assembly, Complete, Side (Item 18, 19, 20)

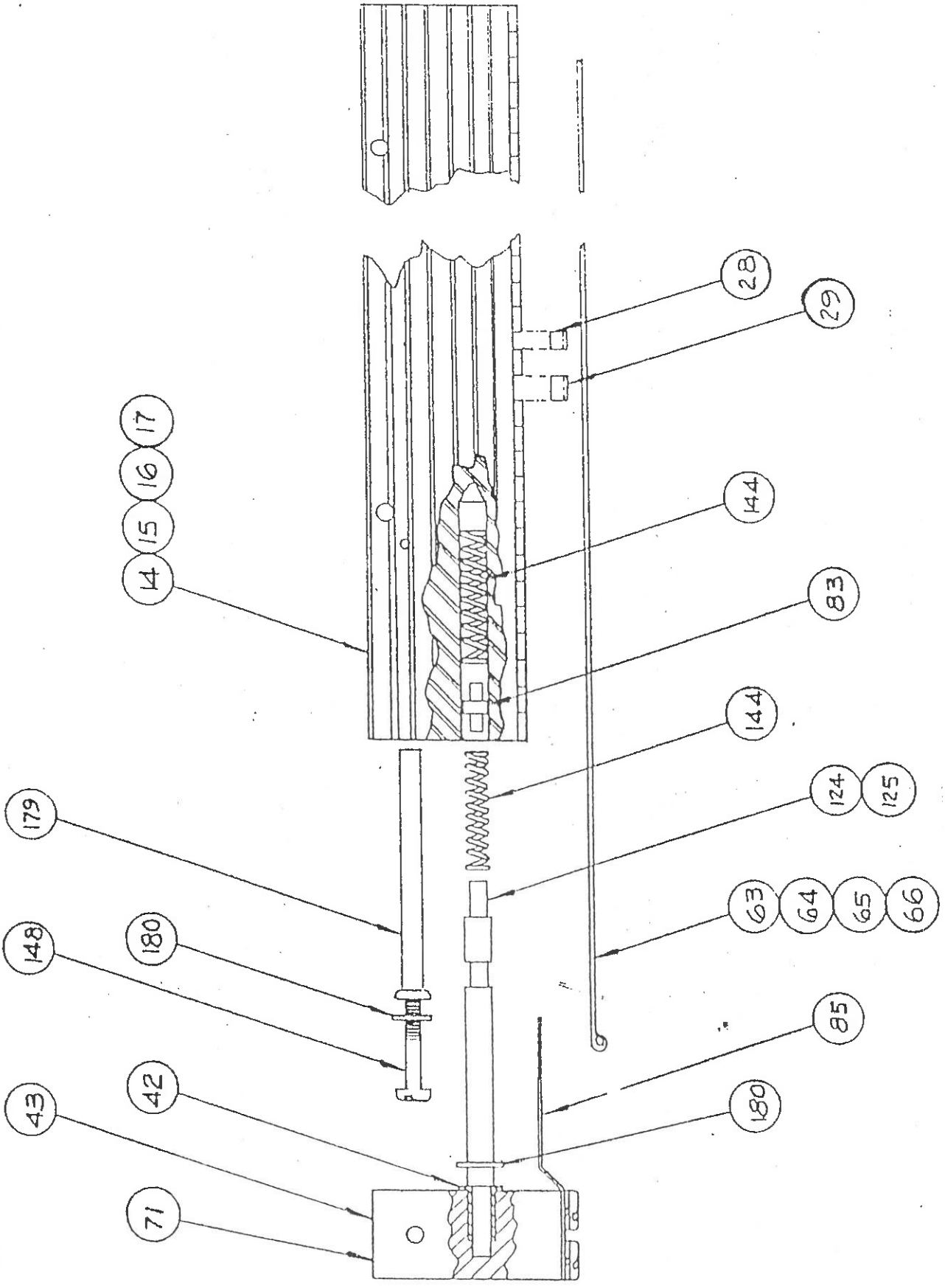


Figure 10.5 Electrode Bar Assembly, Complete, Front (Item 21, 22, 23, 24)

11. TROUBLESHOOTING CHART

The following troubleshooting chart is provided to aid in determining the source of any operating difficulties which may develop. In performing the tests and checks which follow, carefully inspect for any loose components, broken or loose wires, poor electrical connections, etc. while testing the various switches, controls, relays, transformers, and so on. For checking electrical troubles the use of test equipment such as a neon test light, continuity buzzer, and a small voltohmmeter is required.

NOTE

While troubleshooting, use caution to avoid danger of electrical shock. When power is not required for checking for the presence or value of voltages used, always disconnect the sealer's power plug from the power source.

Refer to Figure 11.1, 11.2, 11.3, 11.4, or 11.4A, for the location of parts on the electrical chassis, Figures 13.1, 13.2, 13.3, or 13.4 for the electrical schematic diagrams, and to other referenced illustrations or paragraphs listed in the chart which follows.

TROUBLE	PROCEDURE
1. No element heat and no buzzer sound.	a. Check that sealer is plugged in and that power is present at power socket.
	b. Check element pulse switch adjustment as in paragraph 10.5. Also, press switch by hand - if no click is heard, replace.
	c. Check fuses F1 & F2.
	d. Check circuit continuity through normally closed switch contacts of timer TR-1. Timer to be set above zero (0) time on dial.
	e. Check circuit continuity through normally closed contact CR-2.
2. No element heat, buzzer sound is present.	a. Check for operation of contactor CR-1.
	b. Check circuit continuity through operated contacts of contactor CR-1. If required, clean or replace contacts as in paragraph 10.6.
	c. Check Element Compensator setting as in paragraph 7 or 8.
	d. Check continuity through heat control tap switch S-1.
	e. Check for voltage present at both secondaries of transformer T-2 as per values shown in chart of Figure 11.5.
	f. Check for continuity from T2 secondaries through wiring to front and side sealing elements.
	g. Check for continuity through sealing elements and replace if open circuit.

TROUBLE	PROCEDURE
3. Unbalanced heat from front and side sealing elements.	a. Check if two different diameter elements are in use. Replace with same diameter elements.
	b. Check for poor connections to one or the other element.
4. Short element life.	a. Too high heat timer setting. Should be approximately as shown in paragraph 8.1 B.
	b. Check Element Compensator setting as per applicable sub-paragraph of paragraph 7 or 8.
	c. Improper element installation. Check if installed as per paragraph 10.1.
	d. Weak spring at element termination (left end of front element; rear end of side element). If doubtful, replace.
	e. Check if heat sink in firm, flat contact with element. If deformed, straighten or replace heat sink.
5. Weak seals and/or poor film cutoff.	a. Improper setting of heat timer, heat control tap switch, or Element Compensator. Check settings as per paragraphs 7 and 8.
	b. Improper operating technique. Check instructions of paragraph 7 or 8.
	c. Check sealing element cleaning as per paragraph 9.2.
	d. Wavy silicone rubber sealing pad. Replace as per paragraph 10.3.
	e. Sealing pad pressure incorrect. Adjust as per paragraph 10.4.
	f. Hold-down pressure uneven or incorrect on Magna-Lok units. Adjust as per paragraph 10.7.
6. Magnetic hold-down magnets not operating on Magna-Lok sealers (sealing head will not stay down). Sealer operates normally otherwise.	a. Check for 220 volts (nominal) to primary of transformer T-3.
	b. If voltage is present to primary, check for open primary winding of T-3.
	c. Check for 55 (nominal) volts AC output from secondary of transformer T-3.
	d. Check for 55 (nominal) volts DC output from + and - terminals of REC-1. If no DC voltage, replace REC-1.
	e. Check wire circuit continuity to hold-down magnets from REC-1.
	f. Check for circuit continuity through windings of hold-down magnets.
7. Excessive film drag.	a. Check for proper film threading as per paragraph 6.3 and Figure 6.1 or 6.2.
	b. Loosen film roll brake, as per paragraph 6.3 i.
8. Excessive film winding or "spill".	a. Tighten film roll brake, as per paragraph 6.3 i.
9. Excessive film build-up on sealing elements.	a. Clean sealing elements as per paragraph 9.2.
	b. Adjust controls and Element Compensator as per paragraph 7 or 8.
10. Film sticks to sealing elements during high-speed sealing operations.	a. Vary adjustment of controls and Element Compensator slightly from settings of paragraph 7 or 8 and as mentioned in paragraph 9.1.
	b. Clean sealing elements, as per paragraph 9.2.
	c. Check need for sealing pad replacement per paragraph 10.4.

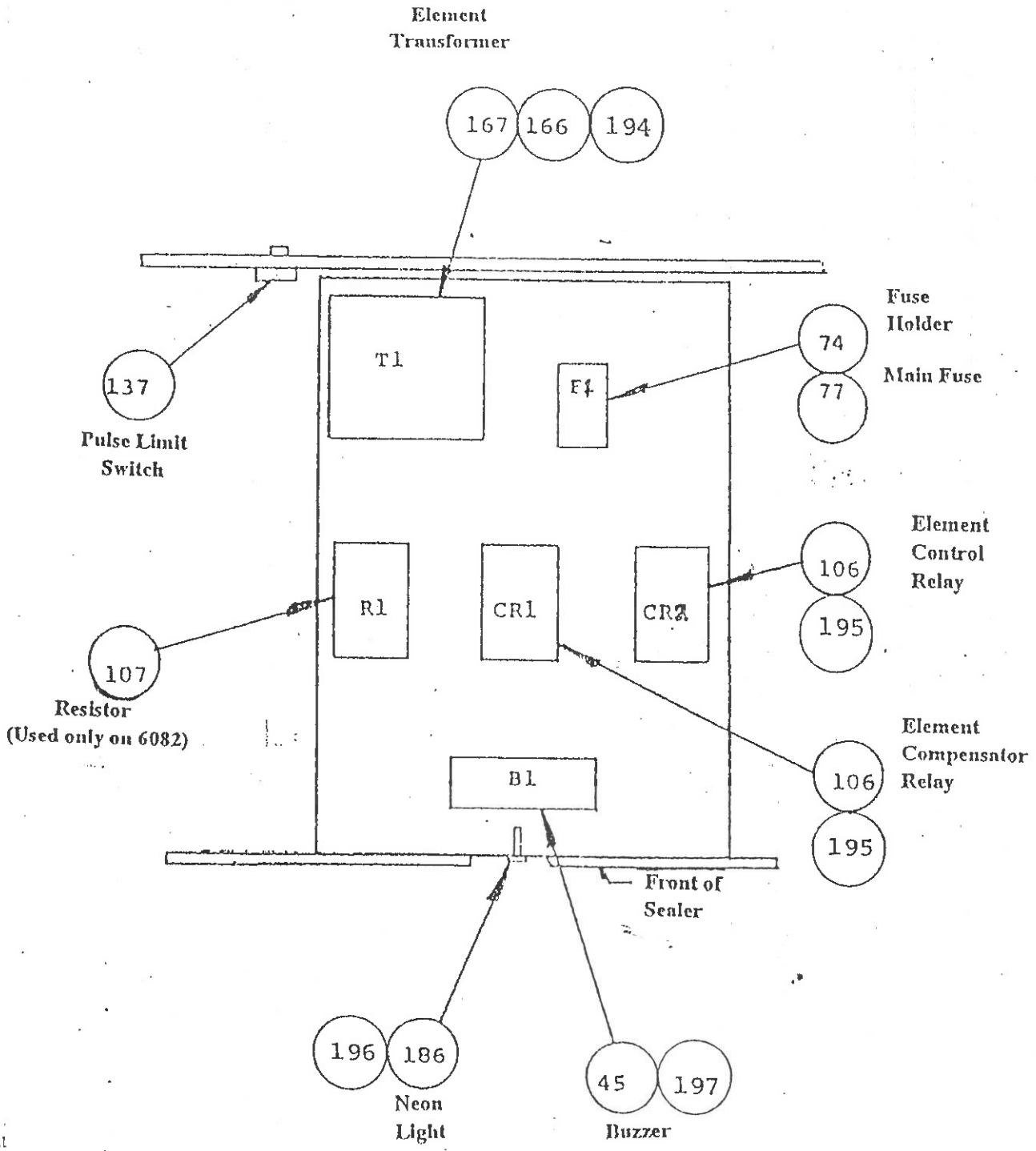


Figure 11.1 Parts Location, Electrical Chassis
Models 6081, 6082, 6001

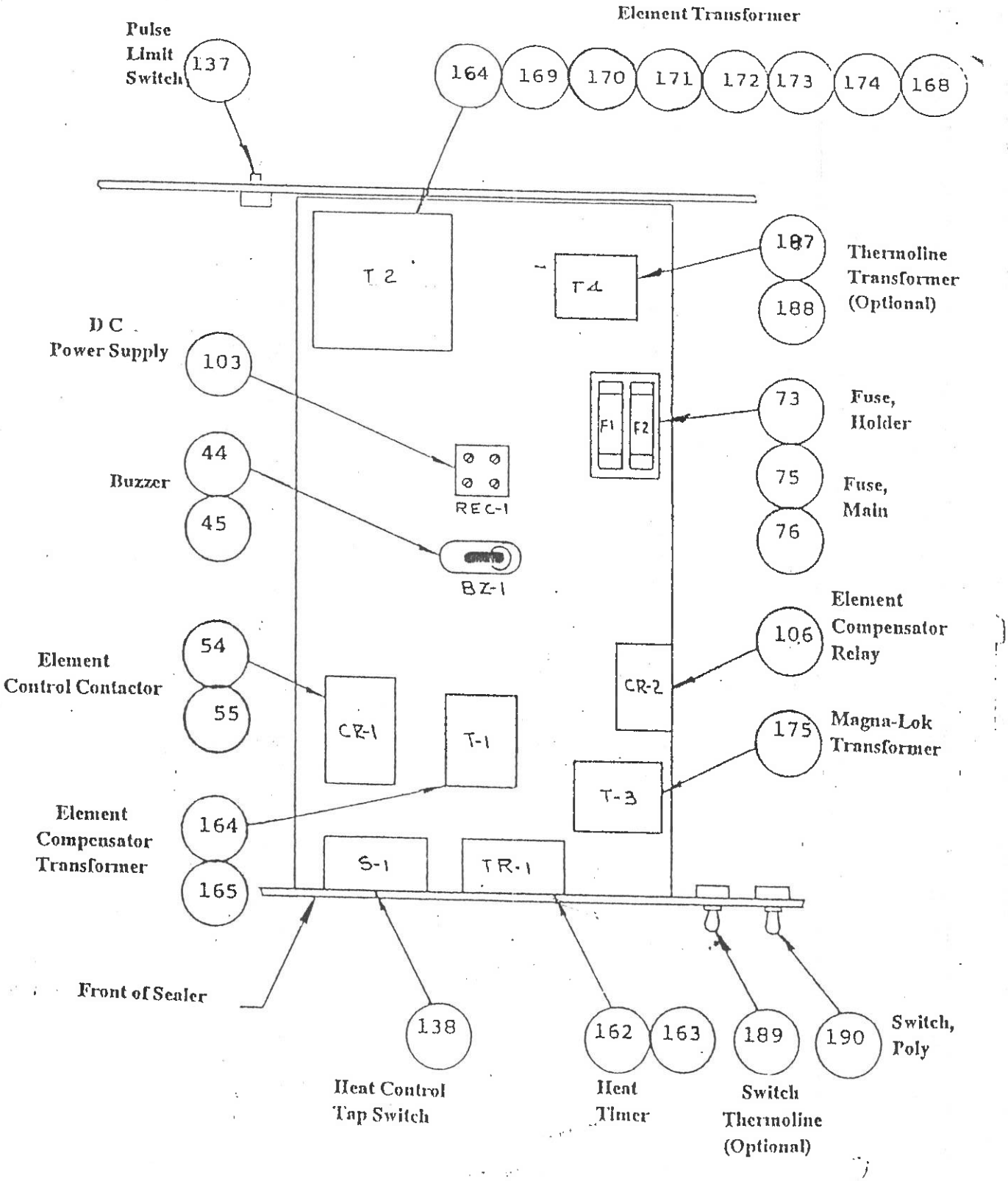


Figure 11.3 Parts Location, Electrical Chassis
Model 6300 Series

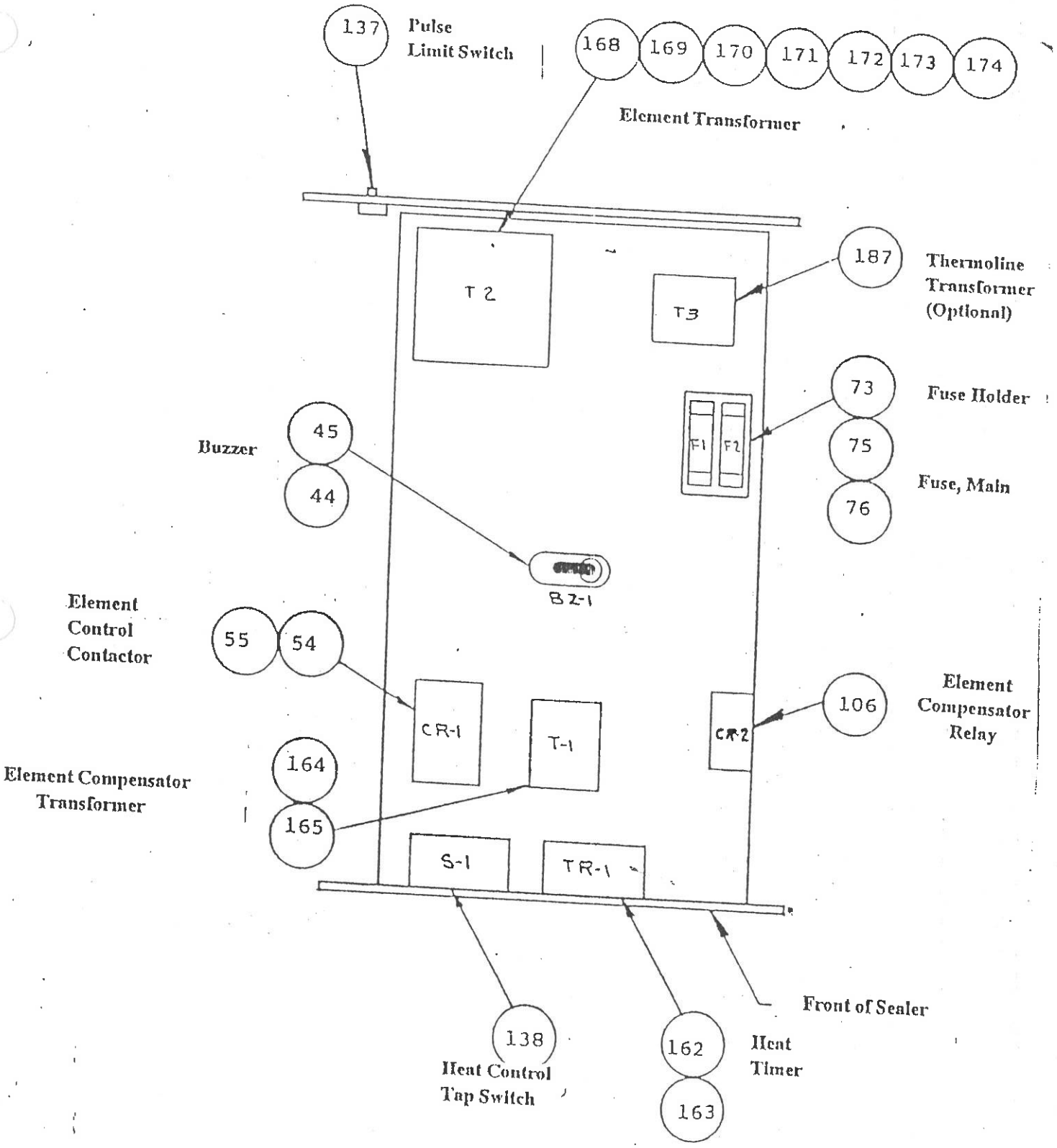


Figure 11.2 Parts Locations, Electrical Chassis
Model 6100 Series

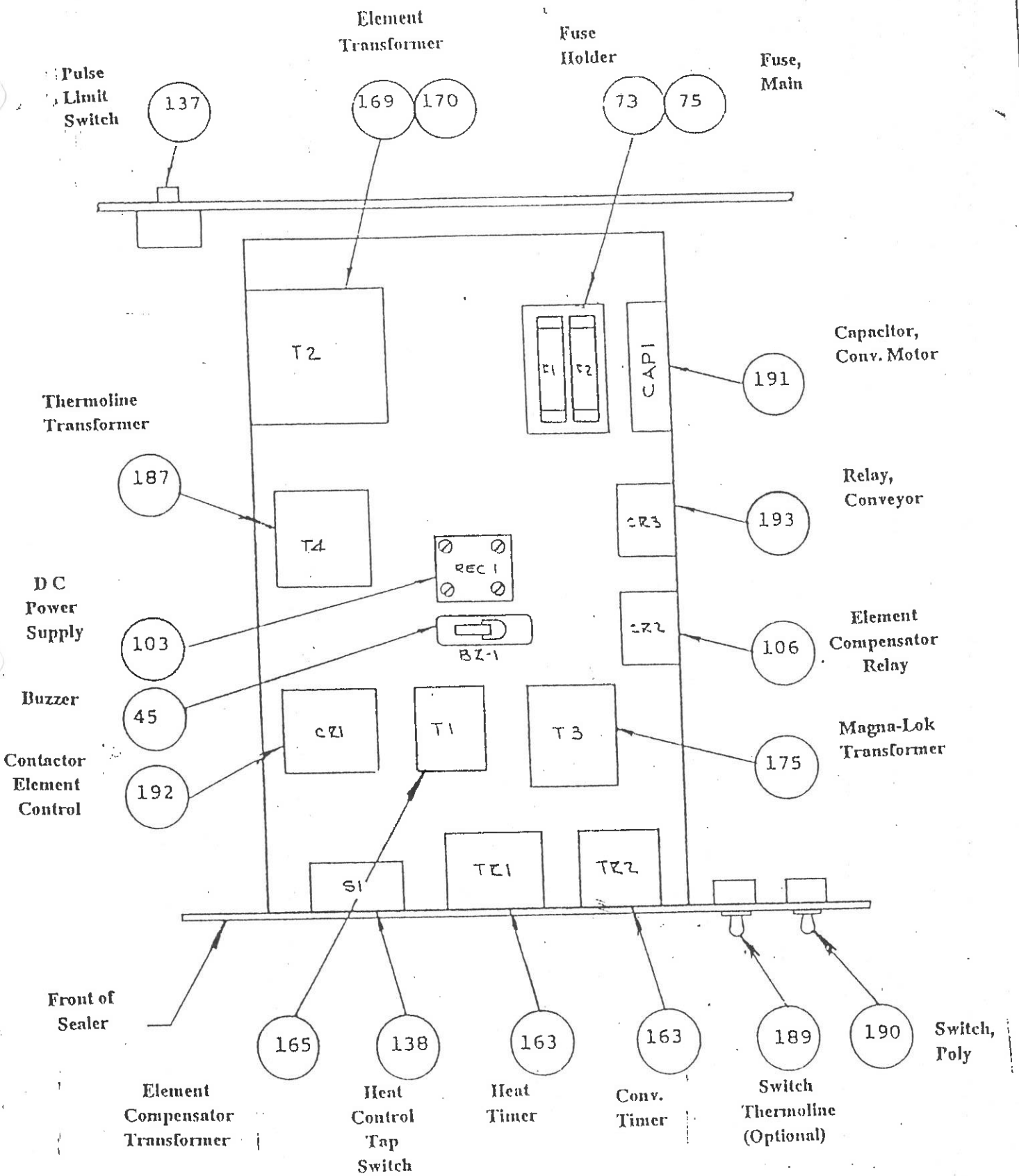


Figure 11.4 Parts Location, Electrical Chassis
Models 6401 and 6402

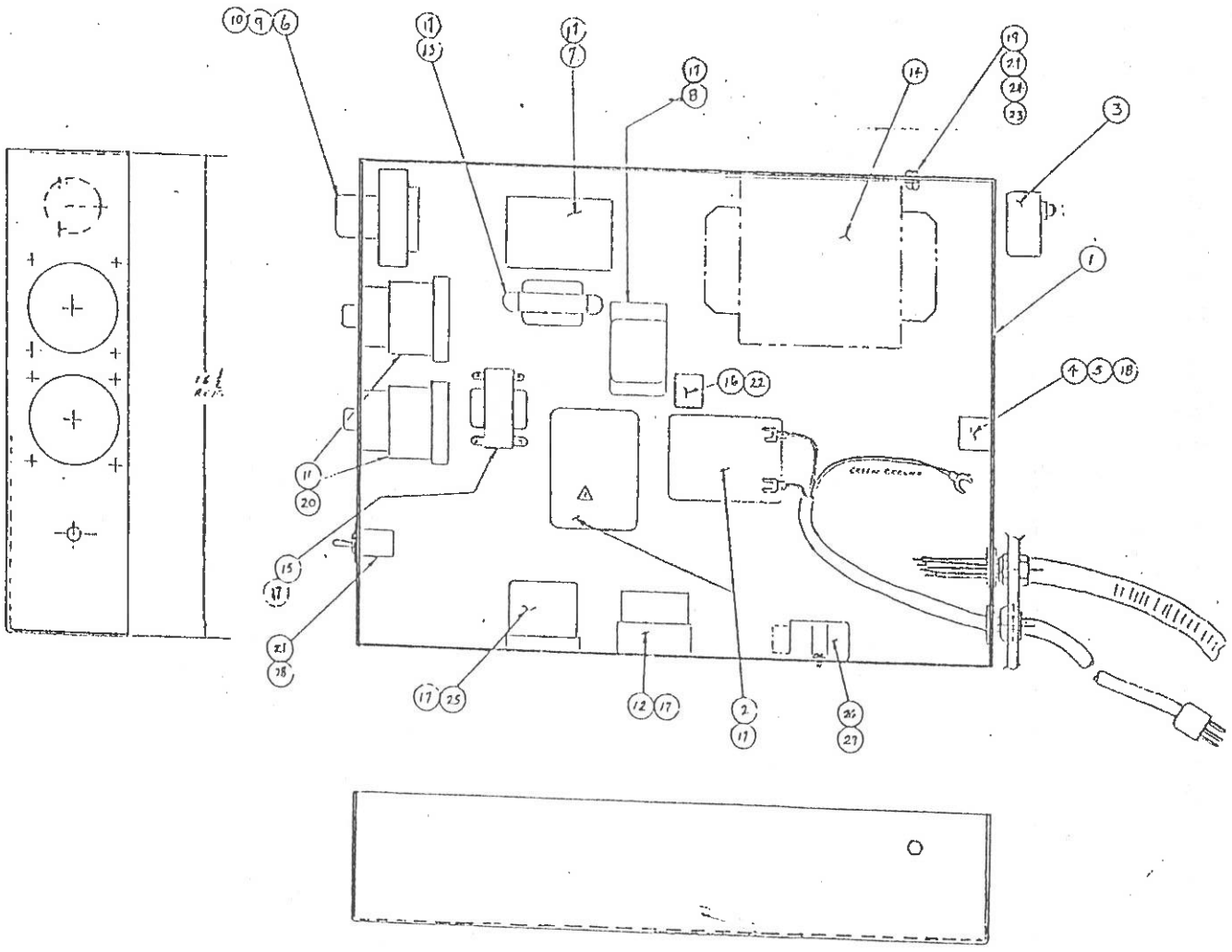


Figure 11.4A Parts Location, Electrical Chassis
Model 6400A Series

L-SEALER MODEL	T-1 TRANSFORMER PART NUMBER	SEALING ELEMENT SECONDARY VOLTAGES:	
		SIDE	FRONT
6081	TR-3207	28	24
6082	TR-3208	28	40
6001	TR-6011	16	20

L-SEALER MODEL	MAGNA-LOK MODEL	T-2 TRANSFORMER PART NUMBER	SEALING ELEMENT SECONDARY VOLTAGES:	
			SIDE	FRONT
6100	6300/6400	TR-0710	30	28
6101	6301/6401	TR-1125	44	35
6102	6302/6402	TR-1112	44	62
6103	6303/6403	TR-1113	44	88
6104	6304/6404	MS-0395	44	166
6113	6313/6413	TR-1301	66	88
6114	6314/6414	B-2635-900	69	161

Figure 11.5 Chart Secondary Voltages From Element Transformer.

WELDOTRON CORPORATION

Replacement Parts List

6000, 6100, 6300, 6400, 6400A, Series Sealers:

The replacement Parts List on the pages which follow has been prepared to assist in the ordering and stocking of parts needed for normal replacement purposes.

When ordering parts, state the part number, part description, and machine model number, on which the part is to be used. Specify the quantity desired, when needed, and desired shipping method.

ITEM NO.	PART NO.	DESCRIPTION	USED ON
1	C-E60-137-1	Angle, Front Pressure	6081 6101 6301 6401 6401A
2	C-E60-137-2	Angle, Front Pressure	6082 6102 6302 6402 6402A
3	C-E60-137-3	Angle, Front Pressure	6103 6303 6313
4	C-E60-137-4	Angle, Front Pressure	6100 6300
5	C-6300-213-1	Angle, Side Pressure	6100 6300
6	C-6300-213-2	Angle, Side Pressure	6081 6082 6101 6102 6103 6301 6302 6303 6401 6401A 6402 6402A

ITEM NO.	PART NO.	DESCRIPTION	USED ON
7	C-6300-213-3	Angle, Side Pressure	6313
8			
9			
10			
11	D-E60A-405-1	Bar, Electrode, Side, Stripped	6100 6300
12	D-E60A-405-2	Bar, Electrode, Side, Stripped	6081 6082 6101 6102 6103 6301 6302 6303
13	D-E60A-405-3	Bar, Electrode, Side, Stripped	6113 6313
14	D-E60A-404-1	Bar, Electrode, Front, Stripped	6100 6300
15	D-E60A-404-2	Bar, Electrode, Front, Stripped	6081 6101 6301
16	D-E60A-404-3	Bar, Electrode, Front, Stripped	6082 6102 6302
17	D-E60A-404-4	Bar, Electrode, Front, Stripped	6103 6113 6303
18	6100-9005	Bar, Electrode, Side, Complete	6100 6300

ITEM NO.	PART NO.	DESCRIPTION	USED ON
19	6100-9006	Bar, Electrode, Side, Complete	6081 6082 6101 6102 6103 6301 6302 6303 6401 6401A 6402 6402A
20	6100-9007	Bar, Electrode, Side, Complete	6113 6313
21	6100-9008	Bar, Electrode, Front, Complete	6100 6300
22	6100-9009	Bar, Electrode, Front, Complete	6081 6101 6301 6401 6401A
23	6100-9010	Bar, Electrode, Front, Complete	6082 6102 6302 6402 6402A
24	6100-9011	Bar, Electrode, Front, Complete	6103 6113 6303 6313
25	E60A-403-A	Bar, Outfeed	6100 6300
26	BD-0746	Bead, Ceramic, 15deg Level	All
27	BD-1720	Bead, Ceramic, Crossover	All
28	BD-0630A	Bead, Ceramic	All
29	BD-2257	Bead, Ceramic, .250" long	All

ITEM NO.	PART NO.	DESCRIPTION	USED ON
30	BL-3503 BL-19996	Belt, Endless 16" x 39 1/2 Belt, Endless	6401 6401A
31	BL-3504 BL-20058	Belt, Endless 16" x 62 1/4 Belt, Endless	6402 6402A
32	BL-2572 BL-19590	Belt, Timing Belt, Timing	6401 6401A
33	BL-1921 BL-19590	Belt, Timing Belt, Timing	6402 6402A
34			
35	B-6300-201	Bracket, Compensator	All Except 6100 6300
36	B-6300-222	Bracket, Compensator	6100 6300
37	B-6300-210	Bracket, Magnet, Support	All 6300 6400 Series
38	B-E60A-410	Bracket, Adj. Pulse Switch	All
39	B-E60-188	Bracket, Front Electrical	6103 6113 6303 6313
40	HA-0458	Brush, Brass, Element Cleaning	All
41	BU-1154	Bushing 5/8 I.D. Nylon	All
42	BU-2285	Bushing, Nylon	All
43	B-6300-206	Block, Terminal 15	All
44	BZ-0002	Buzzer, 110V	6100
45	BZ-0306	Buzzer, 220V	All Except 6100

ITEM NO.	PART NO.	DESCRIPTION	USED ON
46	BU-2350	Bushing, Nylon	All
47	E-E60-406-1	Casting, Outfeed Head	6081 6082 6101 6102 6103 6301 6302 6303 6401 6401A 6402 6402A
48	E-E60-406-2	Casting, Outfeed Head	6113 6313
49	D-E60-125S-1	Casting, Hinges	6100 6300
50	D-E60-125-1	Casting, Hinges	All Except 6100 6300
51	CL-1153	Collar, 7/8" Shaft	All
52	CB-0256	Cord, Line	All Except 6100 6300
53	FG-1118	Connector	All
54	CX-4157	Contactor, CR-1 (110V)	6100 6300
55	CX-4156	Contactor, CR-1, (220V)	All Except 6100 6300
57	B-E60-73	Core, Film Roll, Adjustable	All 6100 6300 6400 Series

ITEM NO.	PART NO.	DESCRIPTION	USED ON
58	C-E60-157	Core, Film Roll, Brake	All 6100 6300 6400 Series
59	B-6300-230	Cam, Back Stop	All 6300 6400 Series
60	C-E60-156	Adj. Film Core Assembly	6081 6082
61	6100-9013	Film Shaft Assembly	6101 6102 6103 6301 6302 6303 6401 6401A 6402 6402A
62	6200-9014	Film Shaft Assembly	6113 6313
63	C-WE0926	Electrode Wire, Front	6100 6300
64	A-WE0926	Electrode Wire, Front	6081 6101 6301 6401 6401A
65	B-WE0926	Electrode Wire, Front	6082 6102 6302 6402 6402A
66	D-WE0926	Electrode, Wire, Front	6103 6113 6303 6313

ITEM NO.	PART NO.	DESCRIPTION	USED ON
67	C-WE0926	Electrode Wire, Side	6100 6300
68	A-WE0926	Electrode Wire, Side	6081 6082 6101 6102 6103 6301 6302 6303 6401 6401A 6402 6402A
69	B-WE0926	Electrode Wire, Side	6113 6313
70	1521-007 5800-612	KNURLED NUT Element, Hold Down	All
71	6300-9015	Element Termination Assy Complete, Front Bar	All
72	6300-9017	Element Termination Assy Complete, Side Bar	All
73	FZ-0983	Fuse Holder, Double	All
74	FZ-2601	Fuse Holder, Single	All
75	FZ-0379	Fuse, F1, F2	All Except 6000 6100 6300
76	FZ-0061	Fuse, F1, F2	6100 6300
77	FZ-1658	Fuse, F1	6081 6082
78	D-6300-004-1	Film Unwind Assembly	6300

ITEM NO.	PART NO.	DESCRIPTION	USED ON
79	D-6300-004-2	Film Unwind Assembly	6301 6302 6303 6401 6401A 6402 6402A
80	D-6300-004-3	Film Unwind Assembly	6313
81	D-E60-07	Film Unwind Assembly	All 6100 Series
82	D-E60-75	Film Unwind Assembly	6081 6082
83	E-58-235	Guide	All
84	E60-144P1	Heat Sink, Side Element	All
85	E60-144P2	Heat Sink, Front Element	All
86	IS-2628	Insulator, Compensator	6100 6300
87	IS-2629	Insulator, Compensator	All Except 6100 6300
88	MP-2651	Laminate Strip for Electrode Bar, 3ft. Strip Thermoline	All
89	MP-2215	Magnet	All 6300 6400 Series
90	MR-2763	Motor	6401 6402
	MR-20059	Motor	6401A 6402A
91	NT-1374	Nut, Wing	All

ITEM NO.	PART NO.	DESCRIPTION	USED ON
92	NT-1138	Nut, Wing	All
93	NT-1435	Nut, Wing	All
94	NT-1671	Nut, Pal.	All
95	RU-1683	Pad, Silicone Sponge (Sold per foot only)	All
96	BG-0685	Pillow Block	All
97	PN-2414	Pin, Roll, Upper Magnet	All
98	PN-0278	Pin, Roll, 3/16" Dia. 1" long	All
99	PN-2119	Pin, Roll	All
100	PN-2014	Pin, Roll	All
101	B-5800-615	Pin, Lock, Front Bar	All
102	A-6300-209	Pin, Lock, Side Bar	All
103	TB-4097	Power Supply, DC, Rec. 1	All 6300 6400 Series
104	B-6400-107 6400-111	Pulley, Driving Roller	6401 6402 6401A 6402A
105	B-6400-108 PY19332	Pulley, Motor	6401 6402 6401A 6402A
106	SW-1123	Relay, 24V Compensator Circuit	All
107	RE-3209	Resistor, Variable	6082
108	RG-2750	Ring, Retaining 7/8" Shaft	6401 6402
109	RG-0534	Ring, Retaining 1/2" Shaft	6401 6402

ITEM NO.	PART NO.	DESCRIPTION	USED ON
110	RG-0823 RG-1950	Ring, Retaining 3/8"	6401 6402 6401A 6402A
111	RG-2711 BG-0809	Ring, Retaining 1 1/8" Housing	6401 6402 6401A 6402A
112	B-6300-401-1	Rod, Film Spreader	6300
113	B-6300-401-2	Rod, Film Spreader	6301 6302 6303 6401 6401A 6402 6402A
114	B-6300-401-3	Rod, Film Spreader	6313
115	C-E60-159-3	Rod, Film Spreader	6100
116	C-E60-159-1	Rod, Film Spreader	6081 6082 6101 6102 6103
117	C-E60-159-2	Rod, Film Spreader	6113
118	B-6400-105 6401-1006	Roller, Driving	6401 6402 6401A 6402A
119	B-6400-114 6401-1007	Roller, Idler	6401 6402 6401A 6402A
120	C-E60-127-4	Shaft, Hinge	6100 6300

ITEM NO.	PART NO.	DESCRIPTION	USED ON
121	C-E60-127-1	Shaft, Hinge	6081 6101 6301
122	C-E60-127-2	Shaft, Hinge	6082 6102 6302 6402 6402A
123	C-E60-127-3	Shaft, Hinge	6103 6113 6303 6313
124	B-6300-204-1	Shaft, Lock, Front	6100 6300
125	B-6300-204-2	Shaft, Lock, Front	All Except 6100 6300
126	B-5800-616-1	Shaft, Lock	All
127	B-E60-155-3	Shaft, Film Roll	6100 6300
128	B-E60-155-2	Shaft, Film Roll	6113 6313
129	B-E60-0215	Shaft, Film Roll	6081 6082
	B-E60-155-1	Shaft, Film Roll	6101 6102 6103 6301 6302 6303 6401 6401A 6402 6402A

ITEM NO.	PART NO.	DESCRIPTION	USED ON
130	B-6400-106 6401-1005	Shaft, Driving Roller	6401 6402 6401A 6402A
131	B-E60-146	Shim, Sealing Head	All
132	FG-2058	Screw, Plug	6313
133	SS-1169	Screw, Thumb 3/8-16 x 2 1/2"lg	All
134	B-6300-231	Stop, Strap	6300 Series
135	A-6300-211	Support, Top Magnet	All 6300 6400 Series Except 6303 6313
136	B-6300-223	Support, Top Magnet	6303 6313
137	SW-0202	Switch, Limit, Pulse (LS-1)	All
138	RH-1102	Switch, Tap, Heat Control	All
139	SG-1143	Spring, Torsion	All
140	SS-1171	Stop, Bumper	All 6100 6300 6400 Series
141	SV-2349	Sleeve, Nylon	All
142	SV-1132	Sleeve, Nylon, Headed	All
143	SG-2410	Spring, Compression, Termination Lock, Six Bar	All
144	SG-1988	Spring, Element Compression	All
145	SG-1987	Spring, Compression, Termination Lock, Front Bar	All

ITEM NO.	PART NO.	DESCRIPTION	USED ON
146	SS-2112	Screw Socket Hd. Cap.	All
147	SS-1732	Screw, Heat Sink	All
148	SS-2013	Screw, Bind Hd. #10-32 x 2 1/2"lg	All
149	SS-1813	Screw, Bind Hd. #8-32 X 3/8"lg	All
150	SS-0343	Screw, Bind Hd. #10-32 x 3/4"lg	All
151	SS-1190	Screw, Thumb #10-32 x 1 1/2"lg	All
152	SS-2098	Screw, Button Hd. #8-32 x 1/2"lg	All
153	B-6300-232	Support Block	All 6300 Series
154	SS-1225	Screw, Soc. Hd. Cap #5/16-18 x 3/4" long	All
155	TL-0752	Terminal Contact Section	All
156	TL-0753	Terminal End Section	All
157	WE-3468	Teflon Coated Element Wire/ft	All
158	B-6300-207	Tie, Post, Terminal Lock	All
159	6100-9021	Teflon Fiberglass Fabric .003 Thick, sq yd	All machines w/ Thermoline feature
160	TA-0366	Tape, Fiberglass Teflon 1/2"x.010x10yds Pressure Sensitive	All
161	TA-0467	Tape, Fiberglass Teflon 2" x .003" x 10yds	All
162	TM-3916	Timer, Heat, TR-1 (110 Volt)	6100 6300
163	TM-3915	Timer, Heat, TR-1 (220 Volt) (Also TR-2 on 6400)	All Except (110V) 6100 6300

ITEM NO.	PART NO.	DESCRIPTION	USED ON
164	TR-0722	Transformer, Element Comp. (T2)	6100 6300
165	TR-0949	Transformer, Element Comp	All Except 6100 6300
166	TR-3207	Transformer, Element Comp. (T1)	6081
167	TR-3208	Transformer, Element Comp. (T1)	6082
168	TR-0710	Transformer, Element Pulse (T2)	6100 6300
169	TR-13558	Transformer, Element Pulse (T1)	6101 6301 6401 6401A
170	TR-13558	Transformer, Element Pulse (T1)	6102 6302 6402 6402A
171	TR-1113	Transformer, Element Pulse (T1)	6103 6303
172	TR-1632	Transformer, Element Pulse (T1)	
173	TR-1302	Transformer, Element Pulse (T1)	
174	TR-1301	Transformer, Element Pulse (T1)	6113 6313
175	TR-2344	Transformer, Magna-Lok Power (T3)	
176	B-6400-055	Tray Pivot, Right	6401 6401A 6402 6402A
177	B-6400-056	Tray Pivot, Left	6401 6401A 6402 6402A

ITEM NO.	PART NO.	DESCRIPTION	USED ON
178	SV-2349	Tubing, Insulating, Front Termination, Side Bar .252"I.D.	All
	1521-029		
179	SV-2350	Tubing, Insulating .194" I.D.	All
180	WA-2348	Washer, Nylon .195" I.D.	All
181	WA-2347	Washer, Nylon .255" I.D.	All
182	WA-2346	Washer, Flat	All
183	WA-1003	Washer, Lock, Split #10	All
184	WA-0692	Washer, Flat #8	All 6300 6400 Series
185	WA-2749	Washer, Spacer	6401 6401A 6402 6402A
186	LT-0606	Neon Light	6081 6082
187	TR-2648	Transformer, Thermoline	6100 Series
188	TR-2747	Transformer, Thermoline	6303 6313*
189	SW-2145	Switch, Thermo/Impulse	All 6300 6400 Series
190	SW-1240	Switch, Poly	All 6300 6400 Series
191	CC-3512	Capacitor, Conveyor Motor	6401 6401A 6402 6402A

* Machines with Optional Thermoline Feature only.

ITEM NO.	PART NO.	DESCRIPTION	USED ON
192	CX-2471	Contactor, Element Control	6401 6401A 6402 6402A
193	SW-1195	Relay, Conveyor	6401 6401A 6402 6402A
194	TR-6011	Transformer	6001
195	SW-10303	Relay, Power	6001
196	LT-0699	Light	6001
197	BZ-0002	Buzzer	6001

PART NO: 64000803
DESCRIPTION: MOUNT CHASSIS COMPONENTS

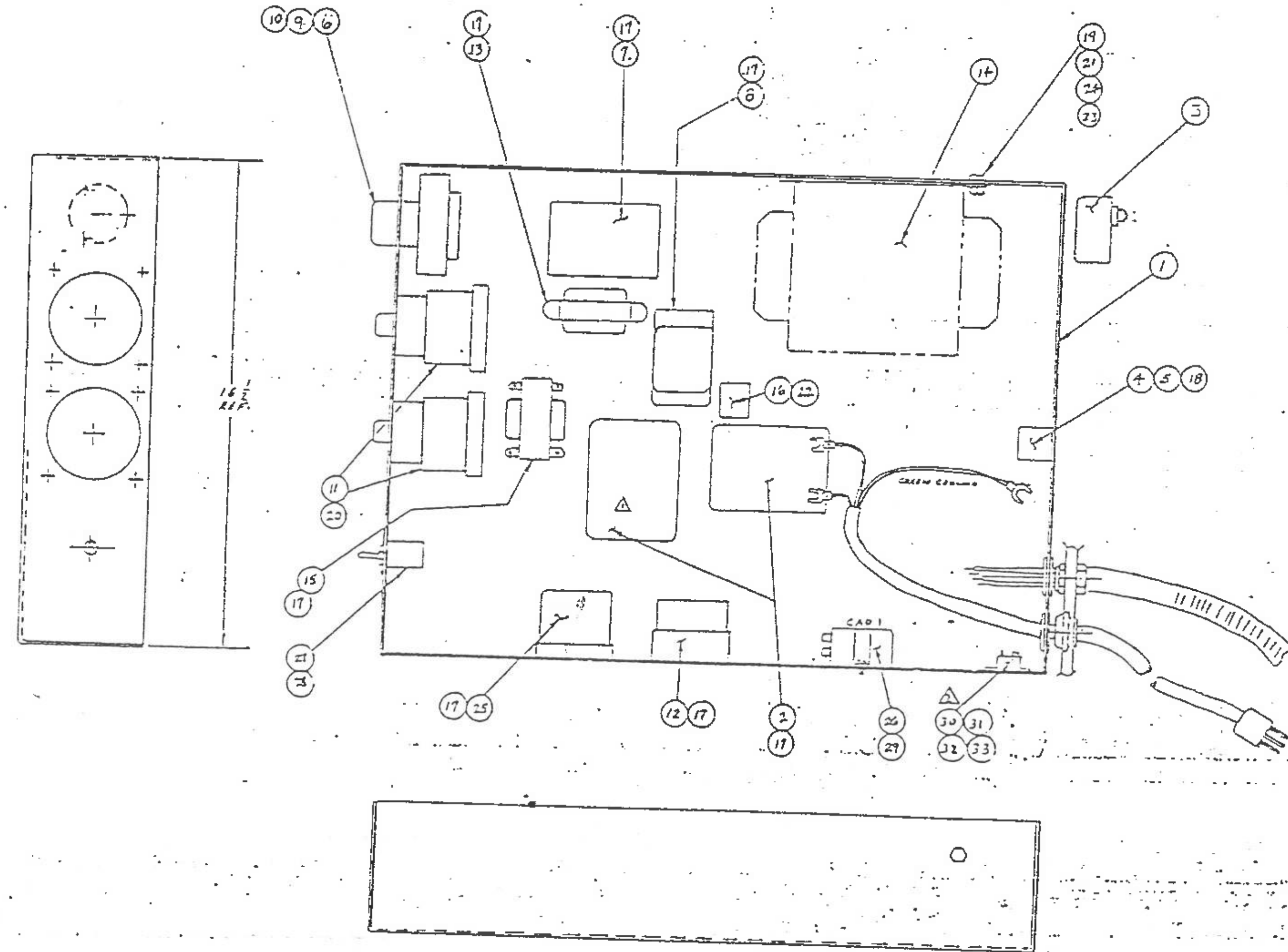
REV:04 03/08/94
ACT: ROUTE: 1

ITEM	P/N	DESCRIPTION	QTY	U/M	RV ACT	ND
1	E600149P1A	SUB CHASSIS WELDMENT	1.0	EA	01	
2	FZ0983	FUSE HOLDER,250V,30A	2.0	EA		
3	SW0202	SWITCH	1.0	EA		
4	TL0752	TERMINAL BLOCK	5.0	EA		
5	TL0753	MOUNT END	1.0	EA		
6	RH1102	TAP SWITCH,6POS,10-32-3/8 BND HD	1.0	EA		
7	CX4156	CONTACTOR,2POLE,25AMP,208/240V	1.0	EA		
8	BZ0306A	BUZZER MC 220V AC W/COVER	1.0	EA		
9	KB1100	KNOB,1 DIA	1.0	EA		
10	KB1101	KNOB	1.0	EA		
11	TM3915	TIMER,220V,.25 TO 5.0 SEC	2.0	EA		
12	SW1123	RELAY,24V AC,25A DPDT	1.0	EA		
13	TR0949	TRANSFORMER	1.0	EA		
14	TR13558	XFMR,220/360V,6TAPS,PR 35V	1.0	EA		
15	TR2344	XFMR,110/220V. SPLIT PRI. 55V.@ VA.SEC	1.0	EA		
16	TB7025	RECTIFIER	1.0	EA		
17	SS0335	AAG,8-32X0.500 LG SCR BIND HD MS PL	18.0	EA		
18	SS1411	ACG,8-32X0.375LG SCR BD HD MS 316/304SST	2.0	EA		
19	SS0080	AAG,0.250-20X0.750LG SCR HD BD MACH SST	4.0	EA		
20	SS1732	ABG,6-32X0.250 LG SCR BIND HD MACH	9.0	EA		
21	NT0627	AAA,0.250-20 NUT HEX CAD	4.0	EA		
22	SS0244	AAG,6-32X1.000 LG SCR BIND HD MACH CP	1.0	EA		
23	WA0918	ABB,0.250 WASHER LOCK INTL	1.0	EA		
24	WA1739	ACB,0.250 LOCK WASHER SST	4.0	EA		
25	SW1195	SWITCH,25A 230V AC COIL	1.0	EA		
27	SW1240	SWITCH TOGGLE DPDT	1.0	EA		
28	LB6733	LABEL POLYETHYLENE NORMA	1.0	EA		

PART NO: 64000803
DESCRIPTION: MOUNT CHASSIS COMPONENTS

REV:04 03/08/94
ACT: ROUTE: 1

ITEM	P/N	DESCRIPTION	QTY	U/M	RV	ACT	MD
29	BT1930	BRACKET (OVAL)	1.0	EA	01		
30	PG1662	PLUG,FEMALE,4 TERM, PANEL MOUNT	1.0	EA			
31	SS1321	AAB,6-32X0.375 LG SCREW RD HD MACH CP	2.0	EA			
32	WA2228	AAB,6 WASHER LOCK CP	2.0	EA			
33	NT0198	AAA,6-32 NUT HEX CAD PL	2.0	EA			
9000	DWG64000803	DWG,MNT CHASSIS COMPONENTS	1.0	EA	02		D



	6402	6400-0805	1
	6401	6400-0806	1

2	ADD ITEMS 30, 31, 32 & 33		
1	30760 FUSE HOLDER		

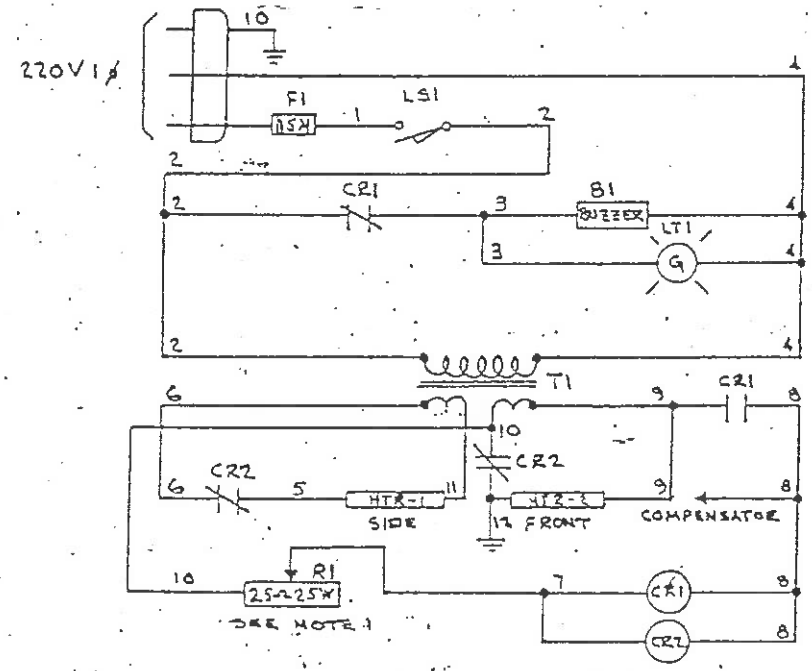
REVISIONS

ELECTRICAL CHASSIS SUBASSEMBLY 6401 & 6402

PART LIST

KLOOTRON Corporation

D 6400-0803



LAST WIRE NO. USED #10

1. SET RESISTOR TO GET 24 TO 27 VOLTS ACROSS RELAY COILS CR1 & CR2.
2. MODEL 6081 14" LONG X 20" SIDE
   MODEL 6082 28" LONG X 20" SIDE

SIZE B | PART NO 6081-8000 | REV 4

WELDOTRON CODE NO.	ITEM	DESCRIPTION	REQ'D
BE0306	B1	BUZZER 230V COIL	1
SW1123	CR1	RELAY 1 N.C., 1 N.O. CONTACT 24V COIL	1
SW1123	CR2	RELAY 1 N.C. CONTACT 24V. COIL	1
FZ-1685	F1	FUSE 15 A 250V	1
SW0202	LS1	LIMIT SWITCH	1
LT 606	LT1	NEON LIGHT	1
PG-0588	P1	PLUG	1
RE3209	R1	RESISTOR (VARIABLE) USED ON MODEL 6081 6082	1
	T1	TRANSFORMER (SEE TABLE)	1
	HTR2	HEATER (036 01A HEATER WIRE) SEE NOTE 3	1
	HTR1	HEATER 20" LG. (036 01A HEATER WIRE)	1

	MODEL	TOTAL LENGTH HTR1 & HTR2	TRANSFORMER SECONDARY VOLTAGE
14 AMPS	6081	36"	
18 AMPS	6082	48"	
		(T1) TRANSFORMER	
	6081	TR-6011	32V, 40V
	6082	TR-6012	56V, 40V

SYM.	DESCRIPTION	ECO NO.	DATE/BY
4	ADDITION OF RESISTOR FOR 6081	1537	4/3/79 D CHAM
3	SEE ECO 1533		5/13/74 D CHAM
2	SEE ECO 882		10/29/69 TAM
1	ADDED T1 TAP INFO & RESISTOR INFO; PART #s FOR R, T1		6/11/69 DJS

REVISIONS

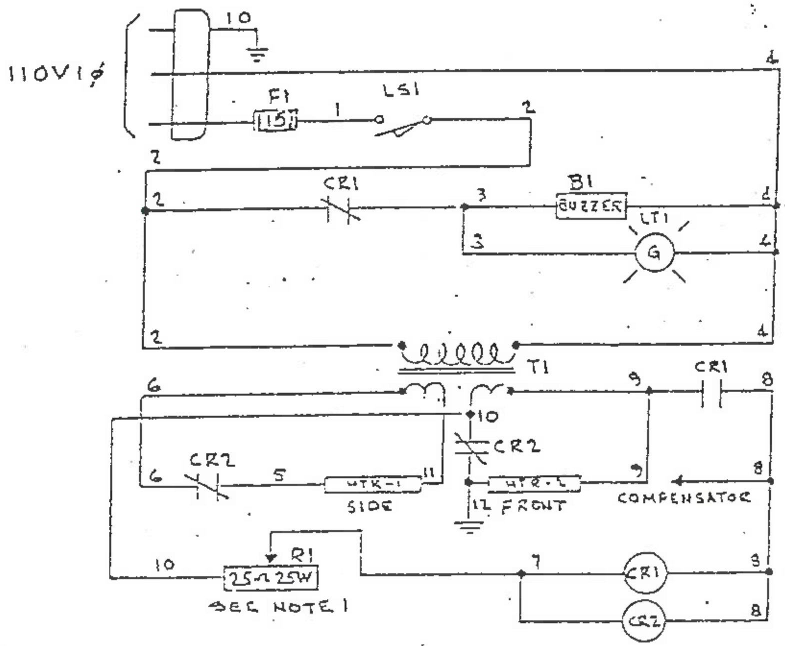
DRAWN T. DIMARTINO DATE 10/29/69
CHECKED DATE
APP'D DATE
MATERIAL
FINISH
TOL UNLESS SPECIFIED FRA. ± 1/64 DEC. ± .005 ANGLES ± 1°

TITLE: SCHEMATIC ECONOMY "L" SEALER

WELDOTRON Corporation NEWARK, N.J.

SCALE — | SIZE B | PART NO 6081-E8000 | 4

PART NO.	MODEL NO.	NEXT ASSEMBLY	NO. REQ'D PER MACH.



REV.	WELDOTRON CODE NO.	ITEM	DESCRIPTION	
1	BE0002	B1	BUZZER 110V COIL	1
	SW10303	CR1	RELAY 1N.C., 1N.O. CONTACT 12V COIL	1
	SW10303	CR2	RELAY 1N.C. CONTACT 12V COIL	1
	FE1339	F1	FUSE 15A	1
	SW0202	LS1	LIMIT SWITCH	1
	LT0699	LT1	NEON LIGHT	1
	PG-0007	P1	PLUG	1
	RE3209	R1	RESISTOR (VARIABLE) USED ON MODEL 6081	1
	TR6011	T1	TRANSFORMER	1
		HTR.2	HEATER (.036 DIA HEATER WIRE) SEE NOTE 3	1
		HTR.1	HEATER 20" LG. (.036 DIA HEATER WIRE)	1

SIZE B | PART NO. 6001-8000

	MODEL	TOTAL LENGTH HTR1 & HTR2	TRANSFORMER SECONDARY VOLTAGE
14AMPS	6001	36"	
		(T1) TRANSFORMER	
	6001	TR 6011	16V E 20V @ 115 Pri.

LAST WIRE NO. USED #10

1. SET RESISTOR TO GET 24 TO 27 VOLTS ACROSS RELAY COILS CR1 & CR2
2. MODEL 6081 * 16" LONG X 20" SIDE

CONFIDENTIAL

SYM.	DESCRIPTION	ECO NO.	DATE/BY
2	Changed T1 to TR6011, CR1&2 to SW10303	2339	RS/4-7
1	CHANGED: DWG. No 6001-8000 WAS 6081-8000	~	RAG 10-12-78

REVISIONS

DRAWN W.W. DATE 7/5/hy | CHECKED | APP'D | MATERIAL | FINISH

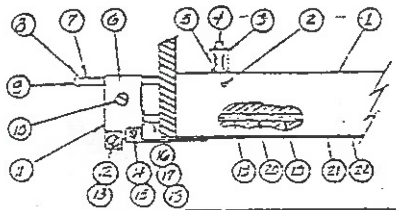
TITLE: SCHEMATIC ECONOMY "L" SEALER

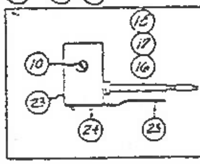
WELDOTRON Corporation NEWARK, N.J.

TOL. UNLESS SPECIFIED: FRAC. ±1/64, DEC. ±.005, ANGLE ±1/2°

SCALE —/— | SIZE B | PART NO. 6001-8000 | 2

PART NO. | MODEL NO. | NEXT ASSEMBLY





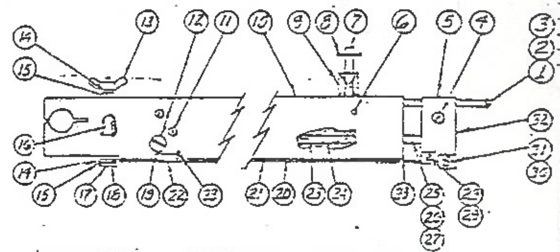
TERMINATION ASSEMBLY AS SHOWN WILL NOT BE AVAILABLE AS AN ASSEMBLY. USE TERMINATION ASSEMBLY SHOWN ABOVE, ITEM No. 11 AS A REPLACEMENT ASSEMBLY. ALL PARTS EXCEPT ITEM No. 23 WILL BE AVAILABLE AS REPLACEMENT PARTS

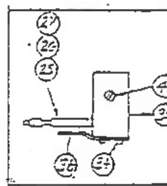
COMPLETED BAR AS SHOWN ABOVE	
MODEL No.	PART No.
6300 AIR TYPE BAR	6300-3007
6100, 6300, 6400	6100-3008
6301 AIR TYPE BAR	6300-3001
6101, 6201, 6301, 6401	6100-3009
6302 AIR TYPE BAR	6300-3002
6102, 6202, 6302, 6402	6100-3010
6303 AIR TYPE BAR	6300-3003
6103, 6113, 6303, 6313	6100-3011

FRONT ELECTRODE BAR
MODEL'S: 6100, 6300, 6400
6101, 6102, 6103, 6113
6081, 6082
6301, 6302, 6303
6401, 6402

PARTS LIST FRONT BAR			
ITEM No.	NOMENCLATURE	MODEL No.	QTY.
1	ELECTRODE BAR STRIPPED (AIR TYPE) SERIAL No. 6126 & LOWER PART No. D-6300-214-1	6300	1
	ELECTRODE BAR STRIPPED PART No. D-6100-404-1	6100, 6300 & 6400	1
	ELECTRODE BAR STRIPPED (AIR TYPE) SERIAL No. 6125 & LOWER PART No. D-6300-214-2	6301	1
	ELECTRODE BAR STRIPPED PART No. D-6100-404-2	6201, 6101, 6301, 6401	1
	ELECTRODE BAR STRIPPED (AIR TYPE) SERIAL No. 6125 & LOWER PART No. D-6300-214-3	6302	1
	ELECTRODE BAR STRIPPED PART No. D-6100-404-3	6082, 6102, 6302, 6402	1
	ELECTRODE BAR STRIPPED (AIR TYPE) SERIAL No. 6125 & LOWER PART No. D-6300-214-4	6303	1
	ELECTRODE BAR STRIPPED PART No. D-6100-404-4	6103, 6113, 6303, 6313	1
2	ROLLPIN # PN-2014	ALL	1
3	NUT # NT-1671	ALL	1
4	LOCK PIN # 6500-615	ALL	1
5	SPRING # SG-1257	ALL	1
6	TERMINAL BLOCK # 6500-614	ALL	1
7	SLEEVE # SV-2017	ALL	1
8	WASHER # WA-2346	ALL	1
9	SCREW # SS-2012	ALL	1
10	SCREW # SS-1411	ALL	1
11	TERMINATION ASSEMBLY PART No. 6300-2016 INCLUDES ITEMS No. 6, 10, 12, 13, 14, 15, 16, 17 & 18	6100 6300 6400	1
	TERMINATION ASSEMBLY PART No. 6300-2015 INCLUDES ITEMS No. 4, 10, 12, 13, 14, 15, 16, 17 & 16	ALL OTHERS	1
12	CLAMP # 6500-611	ALL	1
13	SCREW # SS-1411	ALL	1
14	BRUSH # EGG444	ALL	1
15	SCREW # SS-1732	ALL	1
16	SHAFT, LOCK # 6300-204-1	6100, 6300 & 6400	1
	SHAFT, LOCK # 6300-204-2	ALL OTHERS	1
17	WASHER # WA-2347	ALL	1
18	BUSHING # SV-2285	ALL	1
19	SPRING # SG-1333	ALL	2
20	GUIDE # ESB-235	ALL	1
21	BEAD .250 LG. # BD-2257	ALL	[illegible]
22	BEAD .250 LG. # BD-0630A	ALL	2
23	TERMINAL BLOCK USE ITEM # 6	ALL	1
24	SCREW # SS-1732	ALL	2
25	BRUSH # 6300-205-2	ALL	1

PARTS LIST, SIDE BAR			
ITEM No.	NOMENCLATURE	MODEL No.	QTY.
1	SCREW # SS-2013	ALL	1
2	WASHER # WA-2346	ALL	1
3	SLEEVE # SV-2017	ALL	1
4	SCREW # SS-1411	ALL	1
5	TERMINAL BLOCK # 6500-614	ALL	1
6	ROLLPIN # PN-2014	ALL	1
7	LOCKPIN # 6300-203	ALL	1
8	NUT # NT-1671	ALL	1
9	SPRING # SG-2410	ALL	1
10	ELECTRODE BAR STRIPPED (AIR TYPE) SERIAL No. 6125 & LOWER PART No. 6300-215-1	6300	1
	ELECTRODE BAR STRIPPED PART No. 6100-405-1	6100, 6300, 6400	1
	ELECTRODE BAR STRIPPED (AIR TYPE) SERIAL No. 6125 / LOWER PART No. 6300-215-2	ALL 20" SIDE SEAL WITH AIR TYPE BARS	1
	ELECTRODE BAR STRIPPED PART No. 6100-405-2	ALL 20" SIDE SEAL WITHOUT AIR BARS	1
	ELECTRODE BAR STRIPPED (AIR TYPE) SERIAL No. 6125 / LOWER PART No. 6300-215-3	ALL 30" SIDE SEAL WITH AIR TYPE BARS	1
	ELECTRODE BAR STRIPPED PART No. 6100-405-3	ALL 30" SIDE SEAL WITHOUT AIR BARS	1
11	SCREW # SS-2037	ALL	2
12	ELEMENT HOLD-DOWN # 6300-612	ALL	1
13	WING NUT # NT-1425	ALL	1
14	WASHER, STEEL # WA-2346	ALL	2
15	WASHER, NYLON # WA-2347	ALL	2
16	SLEEVE # SV-23	ALL	1
17	POST, TERMINAL # 6300-207	ALL	1
18	POST ASSEMBLY # 6100-2018 INCLUDES ITEMS # 13, 14, 15, 16 & 17	ALL	1
19	BEAD 15" # BD-0746	ALL	2
20	BEAD .250 LG. # BD-2257	ALL	[illegible]
21	BEAD .250 LG. # BD-0630A	ALL	[illegible]
22	CROSS OVER BEAD # BD-1720	ALL	1
23	SPRING # SG-1398	ALL	2
24	GUIDE # ESB-235	ALL	1
25	SHAFT LOCK # 6300-616-1	ALL	1
26	BUSHING # SV-2285	ALL	1
27	WASHER # WA-2347	ALL	1
28	BRUSH # EGG444	ALL	1
29	SCREW # SS-1732	ALL	1
30	CLAMP # 6500-611	ALL	1
31	SCREW # SS-1411	ALL	1
32	TERMINAL ASSY. # 6300-2017 INCLUDES # 4, 5, 25, 26, 27, 28, 29, 30 & 31	ALL	1
33	SCREW # SS-0300	ALL	2
34	SCREW # SS-1732	ALL	2
35	TERMINAL BLK. USE ITEM # 5	ALL	1
36	BRUSH # 6300-205-1	ALL	1

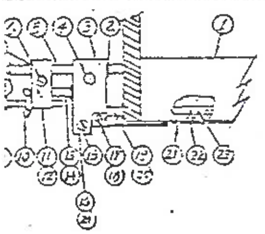




TERMINATION ASSEMBLY AS SHOWN WILL NOT BE AVAILABLE AS AN ASSEMBLY. USE TERMINATION ASSEMBLY SHOWN ABOVE, ITEM No. 32 AS A REPLACEMENT ASSEMBLY. ALL PARTS EXCEPT ITEM No. 35, WILL BE AVAILABLE AS A REPLACEMENT PART

COMPLETED BAR AS SHOWN ABOVE	
MODEL No.	PART No.
6300 AIR TYPE BAR	6300-3004
6100, 6300, 6400	6100-3005
6301, 6302, 6303 AIR TYPE BARS	6300-3005
6101, 6102, 6103, 6082, 6301, 6302, 6303, 6081, 6401, 6402	6100-3006
6311, 6312, 6313 AIR TYPE BARS	6300-3006
6111, 6112, 6113, 6311, 6312, 6313	6100-3007

SIDE ELECTRODE BAR
MODEL'S: 6100, 6300, 6400
6101, 6102, 6103, 6301, 6302
6303, 6401, 6402, 6081, 6082
6111, 6112, 6113, 6311, 6312, 6313



COMPLETED BAR AS SHOWN ABOVE	
MODEL No.	PART No.
L-12FC	MS-331
L-20FC, L-3016FC	MS-440
L-28FC, L-3028FC	MS-441
L-40FC, L-3040FC	MS-442

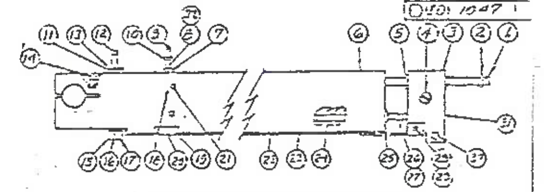
PARTS LIST FRONT BAR			
ITEM No.	NOMENCLATURE	MODEL No.	QTY.
1	ELECTRODE BAR STRIPPED PART No. EGO-1314	L-12FC	1
	ELECTRODE BAR STRIPPED PART No. EGO-1311	L-20FC L-3016FC	1
	ELECTRODE BAR STRIPPED PART No. EGO-1312	L-28FC L-3028FC	1
	ELECTRODE BAR STRIPPED PART No. EGO-1313	L-40FC L-3040FC	1
2	BUSHING # SV-1131	ALL	1
3	TERMINAL BLOCK # EGO-136	ALL	1
4	SCREW # SS-1411	ALL	1
5	ROLLPIN # PN-1613	ALL	1
6	SCREW # SS-1411	ALL	1
7	BUSHING # SV-1132	ALL	1
8	RETAINING RING # RG-1727	ALL	1
9	SCREW # SS-2576	ALL	1
10	WING NUT # NT-2523	ALL	1
11	CLAMP # EGO-120	ALL	1
12	COMPENSATOR ASSEMBLY PART No. MS-435 INCLUDES ITEMS # 2, 7, 9, 10, 11 & 13	ALL	1
13	PIN # PN-1612	ALL	1
14	BUSHING # SV-1212	ALL	1
15	SCREW # SS-1413	ALL	1
16	TERMINAL BLOCK ASSEMBLY PART No. MS-443 INCLUDES ITEMS 2, 3, 4, 15, 17, 18, 19	ALL	1
17	SCREW # SS-1732	ALL	1
18	BRUSH # EGO444	ALL	1
19	PIN ROLL # PN-1614	ALL	1

PARTS LIST, FRONT BAR			
ITEM No.	NOMENCLATURE	MODEL No.	QTY.
20	BUSHING # SV-1130	ALL	1
21	BEAD .250 LG. # BD-2257	ALL	[illegible]
22	BEAD .250 LG. # BD-0630A	ALL	4
23	SPRING # SS-1740	ALL	1
24	TERMINATION / COMPENSATOR ASSY. PART No. MS-444 INCLUDES ITEMS 12, 14 & 16	ALL	1

FRONT ELECTRODE BAR
MODEL'S: L-12, L-20, L-28, L-40(FC)
L-3016, L-3028, L-3040(FC)

PARTS LIST, SIDE BAR			
ITEM No.	NOMENCLATURE	MODEL No.	QTY.
1	ROLLPIN # PN-1613	ALL	1
2	RETAINING RING # RG-1727	ALL	1
3	TERMINAL BLOCK # EGO-136	ALL	1
4	SCREW # SS-1411	ALL	1
5	BUSHING # SV-1131	ALL	1
6	ELECTRODE BAR STRIPPED PART No. EGO-132-3	L-12 FC W/ 12" BAR	1
	ELECTRODE BAR STRIPPED PART No. EGO-132-1	ALL UNITS W/ 18" SIDE SEAL	1

PARTS LIST SIDE BAR			
ITEM No.	NOMENCLATURE	MODEL No.	QTY.
6	ELECTRODE BAR SIDE STRIPPED PART No. [illegible]	[illegible]	1
7	SLEEVE # SV-1135	ALL	1
8	POST # TL-1252	ALL	1
9	SCREW # SS-1412	ALL	1
10	NUT # NT-1427	ALL	1
11	SLEEVE # SV-1134	ALL	2
12	SCREW # SS-1411	ALL	1
13	RETAINING RING # RG-1255	ALL	1
14	SCREW # SS-1412	ALL	1
15	POST # TL-1341	ALL	1
16	SCREW # SS-2120	ALL	1
17	TERMINAL POST ASSY. # MS-312 INCLUDES ITEMS [illegible]	ALL	1
18	SCREW # SS-2126	ALL	1
19	BEAD 15" # BD-0746	ALL	2
20	CROSS OVER BEAD # BD-0645	ALL	1
21	SCREW # SS-1730	ALL	2
22	BEAD .250 LG. # BD-0630A	ALL	4
23	BEAD .250 LG. # BD-2257	ALL	[illegible]
24	SPRING # SG-1740	ALL	1
25	SCREW # SS-0300	ALL	1
26	PIN # PN-1614	ALL	1
27	BUSHING # SV-1130	ALL	1
28	BRUSH # EGO444	ALL	1
29	SCREW # SS-1732	ALL	1
30	SCREW # SS-1413	ALL	1
31	TERMINAL ASSEMBLY # MS-133 INCLUDES ITEMS # 3, 4, 5, 26, 27, 28, 29, 30	ALL	1
32	POST ASSEMBLY # MS-211 INCLUDES ITEMS # 7, 8, 9 & 10	ALL	1



COMPLETED BAR AS SHOWN ABOVE	
MODEL No.	PART No.
L-12FC	MS-300
L-20FC, L-28FC, L-40FC	MS-443
[illegible]	MS-44[illegible]

SIDE ELECTRODE BAR
MODEL'S: L-12, L-20, L-28, L-40(FC)
L-3016, L-3028, L-3040(FC)

ITEM	DESCRIPTION	ECO	DATE	PART	NO. MODEL	NO. NEXT ASSY.
1	[illegible]	5410	[illegible]			

REVISIONS

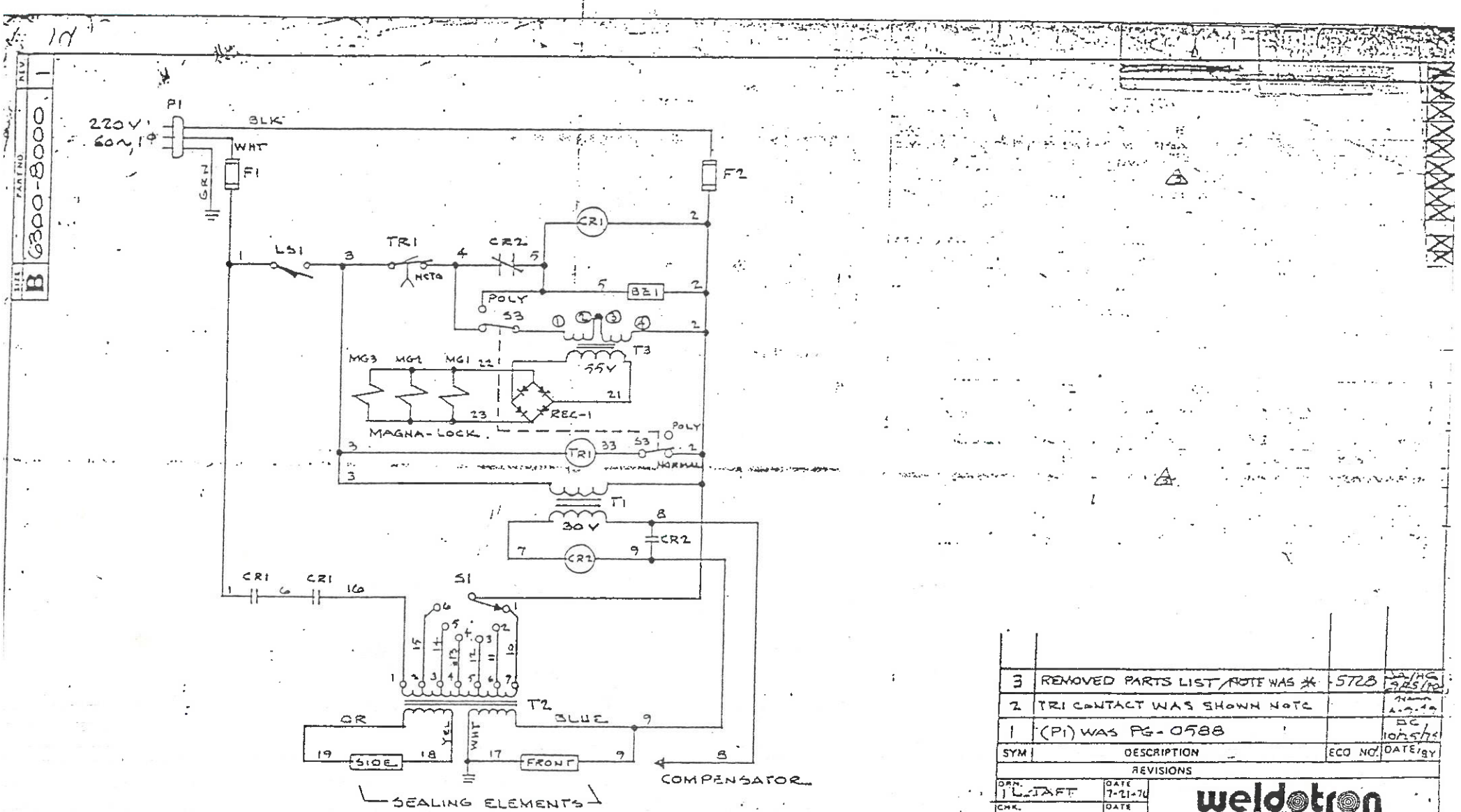
"L" SEALER ELECTRODE BARS FROM JUNE 1964 TO PRESENT DAY

ELDOTRON Corporation
NEWARK, N.J.

101 IO 1047

C-4

CONFIDENTIAL



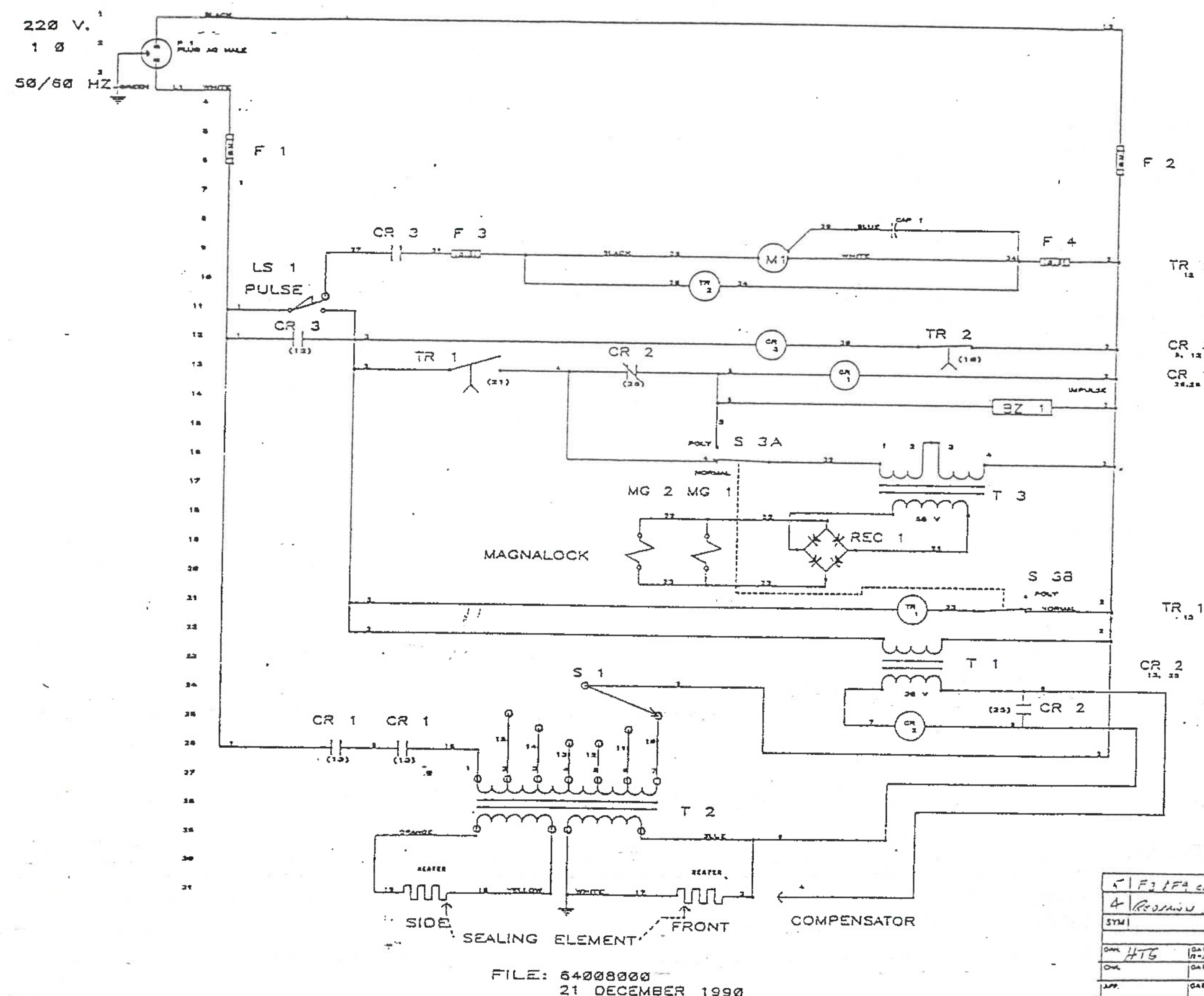
A NOTE: MAGNETIC HOLD DOWN MG3 SHALL BE USED ON MODELS # 6303 & 6313 (3 MAGNETIC REQ'D). ALL OTHER MODELS WILL USE 2 MAGNETIC HOLD DOWNS

SYM	DESCRIPTION	ECO NO.	DATE/BY
3	REMOVED PARTS LIST / NOTE WAS *	5728	9/25/70
2	TR1 CONTACT WAS SHOWN NOTE		4-9-70
1	(P1) WAS PG-0588		10/5/70

REVISIONS

DRN. L. TAFT	DATE 7-21-70	weldotron corporation
CHK.	DATE	
APP. D. CHAUDHURI	DATE 7-29-70	TITLE SCHEMATIC 6300 SERIES 220V, 60 C/S, 1 PH.
MAT'L		
FINISH		
TOL. UNLESS SPECIFIED FRA. ± DEC. ± ANGLE ±		SCALE / SIZE B / PART NO. 6300-8000 / REV. 3

PART NO.	MODEL NO.	NEXT ASSEMBLY	NO. REQ'D PER MACH.



FILE: 64008000
21 DECEMBER 1990

PARTS LIST

ITEM NO.	NOMENCLATURE	NO. REQ.

SYM	DESCRIPTION	ECO NO.	DATE/BY
5	F3 & F4 chg. from 5 amp to 1 amp	5902	
4	Redrawn Add F3 & F4	5820	

REVISIONS

DWN. HTG DATE
CHK. DATE
APP. DATE
MAT'L
FINISH

weldotron corporation

TITLE
SCHEMATIC
6400 SERIES
220V,1 Ø,50/60 HZ.

TOL. UNLESS SPECIFIED: FRA. ±1/64, DEC. ±.005, ANGLE ±1/2°

SCALE	SIZE	PART NO.	REV.
—	C	6400-8000	5

PART NO. | MODEL NO. | NEXT ASSEMBLY | NO. REQ. PER ASSEM.