

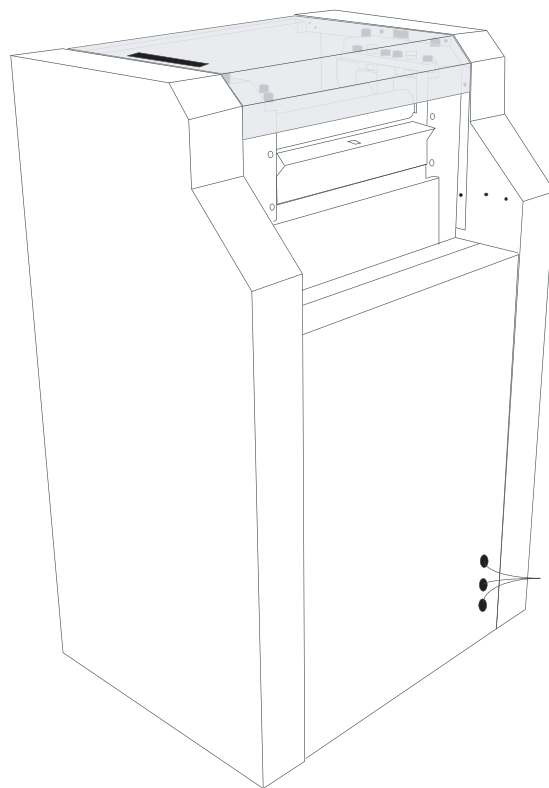
FORMAX[®]

2200-10

AutoSeal[®] Stand-Alone Pressure Sealer

INSTALLATION, MAINTENANCE & PARTS MANUAL
FOURTH EDITION

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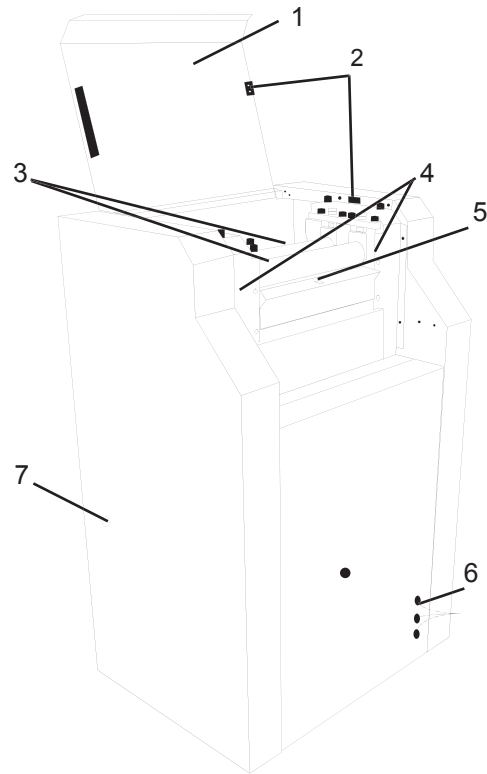


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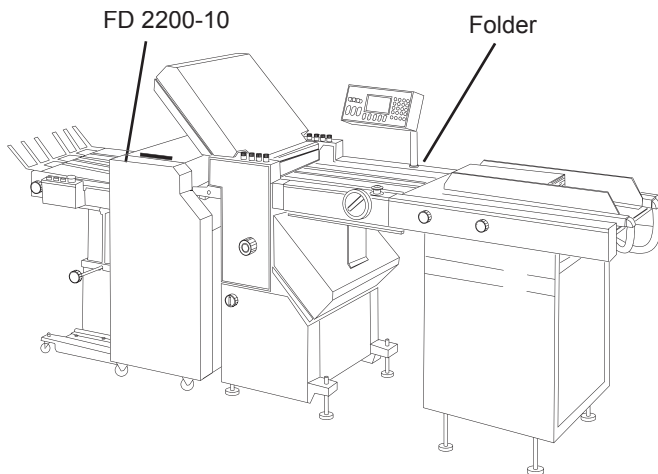
DESCRIPTION

Sealer Basic Components

- 1 - Plexi safety cover
- 2 - Top cover interlock sensor
- 3 - Sealing rollers
- 4 - Side-spacer covers
- 5 - Photo-eye
- 6 - Electrical output
- 7 - Circuit breaker (located on the back side)



The FD 2200-10 AutoSeal® High-End Pressure Sealer is specifically designed to work in-line with production folding systems to seal one-piece pressure sensitive mailers.

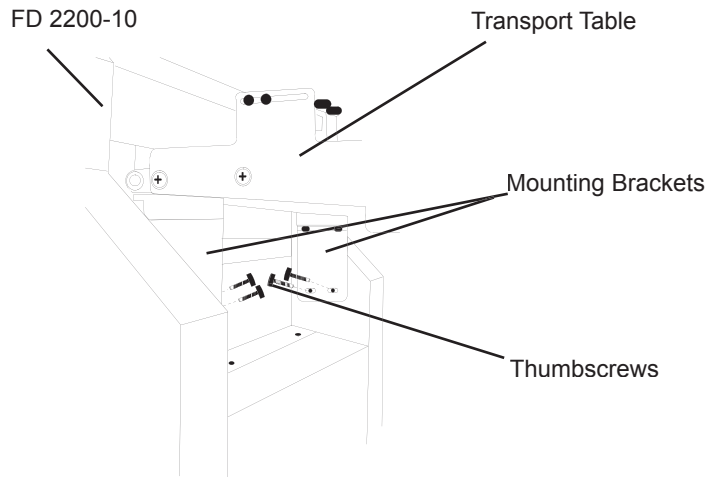


The FD 2200-10 in-line with the Sample Folder.

INSTALLATION

Connection of Sealer to Folder

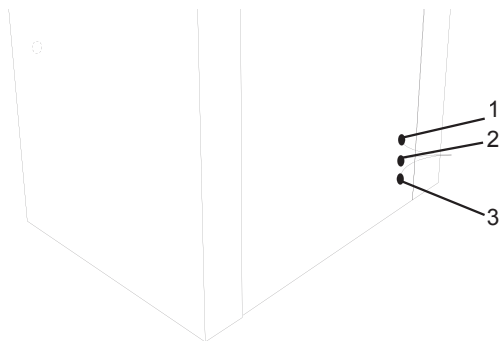
1. Align the FD 2200-10 with the folder transport table mounting brackets and secure it in position with the thumbscrews provided (Fig 1).



(Fig 1)

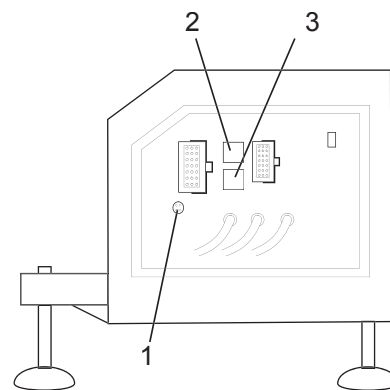
2. Once the sealer is in position plug the electrical cables from the sealer into the connectors located at the rear base of the folder (Fig 2a & 2b, this will vary for different folders).

Cords From Sealer



(Fig 2a)

Rear of sample folder



(Fig 2b)

- 1 - Fault Detector
- 2 - Power Interface
- 3 - Signal Interface

SERVICE

Motor Drive Belt Replacement

1. Unplug machine from power outlet.
2. Remove side spacer covers from the operator side of the sealer unit (Fig 29).
3. Loosen set screws on the motor drive pulley and the roller drive pulley (Fig. 29). Slide pulley, with drive belt, off their respective shafts.
4. Place a new belt on the pulleys and reverse procedures to reassemble.

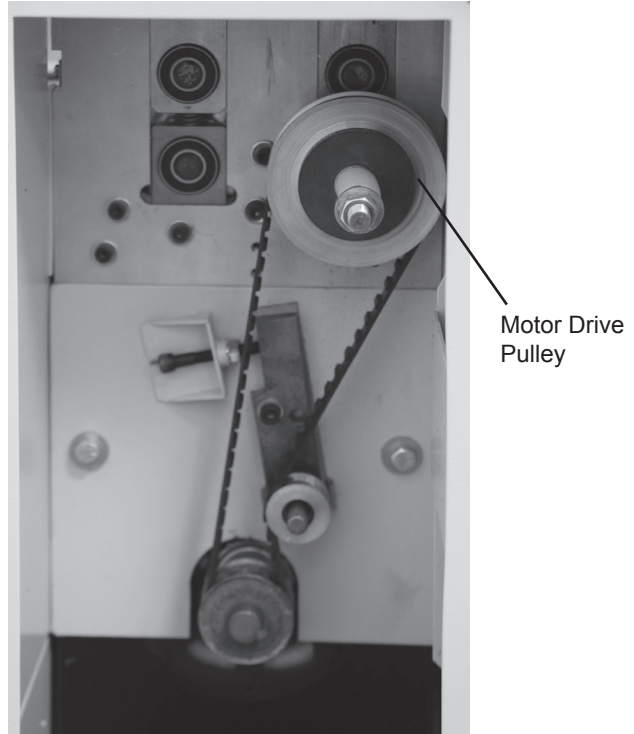


Fig. 29

Roller Drive Belt Replacement

1. Unplug machine from power outlet.
2. Remove the side space covers from the non-operator side of the sealer unit.
3. Loosen screws for the belt tension adjusting pulley and remove the belt. (Fig. 30)
4. Install new belt and reverse procedures to reassemble.

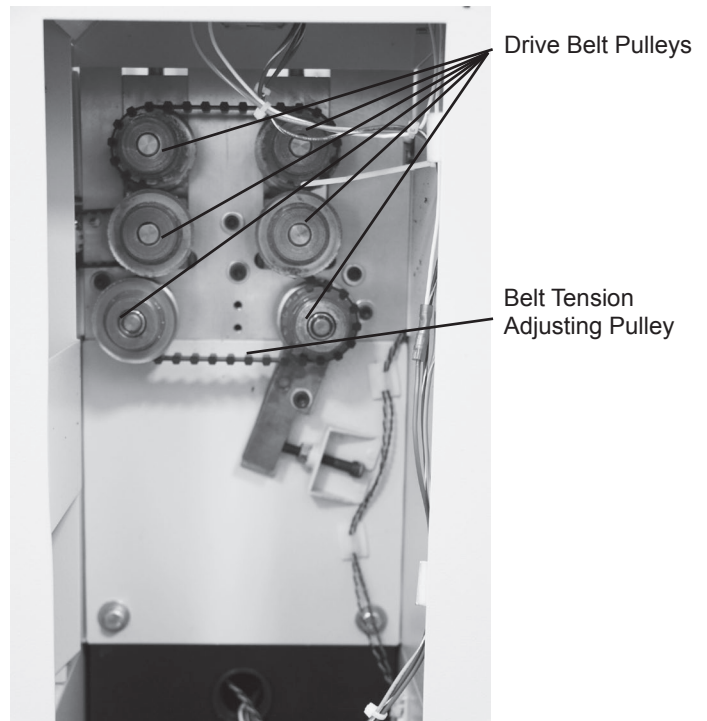
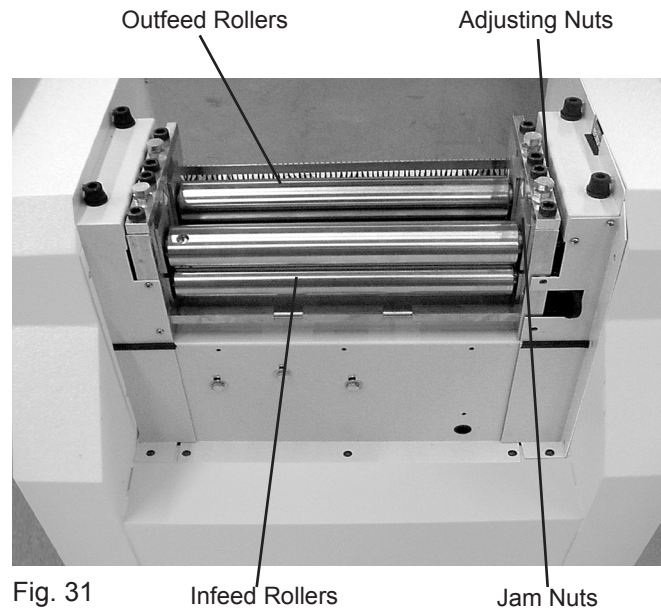


Fig. 30

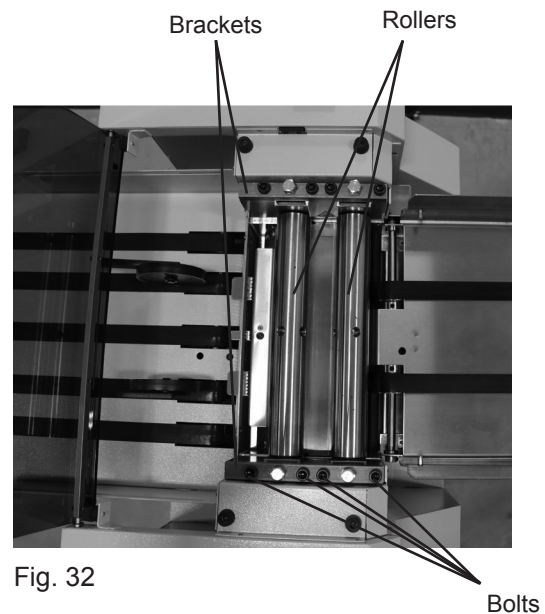
Sealer Roller Clearance Adjustment

1. Loosen jam nuts on the roller adjusting bolts.
2. Place a .004" feeler gauge between the infeed rollers and adjust the bolt so there is a moderate drag on the feeler gauge.
3. Place a .001" feeler gauge between the exit rollers and adjust the bolt so there is a moderate drag on the feeler gauge.
4. Tighten the jam nuts and recheck the clearance. Adjust as needed.



Replacing the Sealer Rollers

1. Unplug machine from power outlet.
2. Remove side space covers.
3. Loosen set screws on motor drive pulley and roller drive pulley.
4. Slide pulleys, with drive belt, off their respective shafts (Fig. 32), also see Fig. 26
5. Loosen screws for the belt tension adjusting pulley and remove the roller drive belt. (Fig. 30)
6. Remove the bolts that secure the side frame cap brackets (Fig. 32). Remove the bracket.
7. Remove the roller(s). To remove the bottom roller(s), it is necessary to remove the bolts that hold the respective cross member in place (Fig. 32).
8. Reverse procedure to install roller(s).



Sealer Motor Replacement

1. Unplug machine from power outlet.
2. Remove side spacer covers.
3. Remove screws and panel to gain access to the electrical components.
4. Remove the screws that hold the sealer to the cabinet.
5. Open the Plexiglas cover.
6. Tilt the sealer towards the back of the cabinet and prop it open with a suitable support.
7. Trace wiring from the sealer to the electrical components. Disconnect wiring- be sure to note the location of each wire.
8. Remove sealer from cabinet. CAUTION: Sealer is heavy. A second person may be needed.
9. Loosen set screws on motor drive pulley and roller drive pulley. Slide pulleys, with drive belt, off their respective shafts.
10. Remove bolts that hold the motor bracket to the sealer frame.
11. Remove motor and bracket from the sealer.
12. Remove bolts holding the motor to the bracket.
13. Reverse procedure to reassemble.

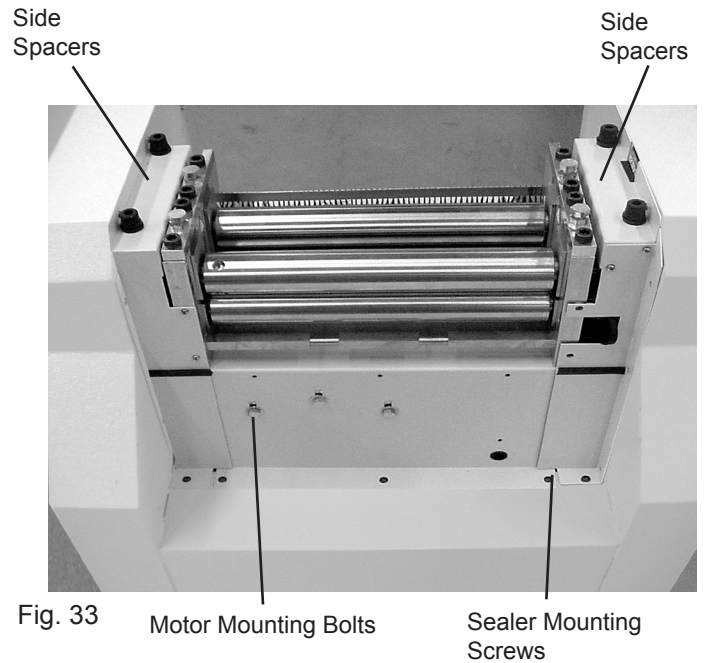


Photo-Eye Adjustment

1. Turn power switch off.
2. Gain access to the photo beam board (same side as the circuit breaker).
3. Turn "BEAM PWR" potentiometer (R9) fully clockwise.
4. Turn "DET GAIN" potentiometer (R30) fully counter- clockwise.
5. Suspend a white folded document 8/10th of an inch above the photo eye.
6. Turn power switch on.
7. Turn R30 clockwise until lights on the board change from low (red light) to good (green light). DO NOT ADJUST ANY HIGHER
8. Turn "delay" potentiometer (R41) fully counter-clockwise and leave it in that position.

Photo Eye Replacement

1. Perform "Sealer Motor Replacement" procedures steps 1 through 4.
2. Remove side spacer covers (Fig. 34).
3. Remove the roller drive belt.
4. Remove the lower left-hand pulley.
5. Remove large roller drive pulley (Fig 34).
6. Remove the six (6) screws that hold the infeed ramp in position.
7. Remove the bracket.
8. Remove the photo-eye.

Safety Cover Interlock Sensor Replacement

1. Unplug the machine from power outlet.
2. Remove transfer bridge from sealer unit.
3. Remove non-operator side spacer covers.
4. Remove screws and nuts that hold the switch to the cabinet.
5. Cut wires and remove the proximity sensor.
6. Install switch and connect wires with electrical butt connections.
7. Reverse procedures to reassemble.

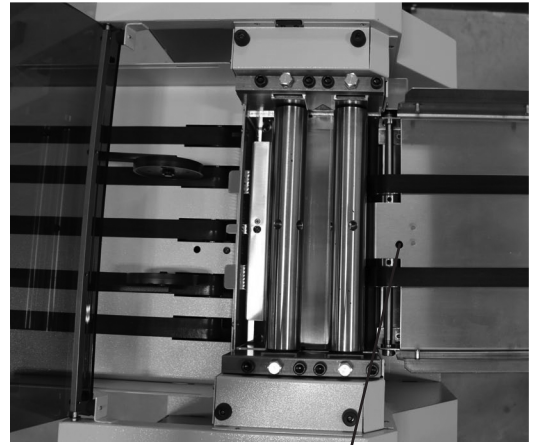


Fig. 34

Photoeye

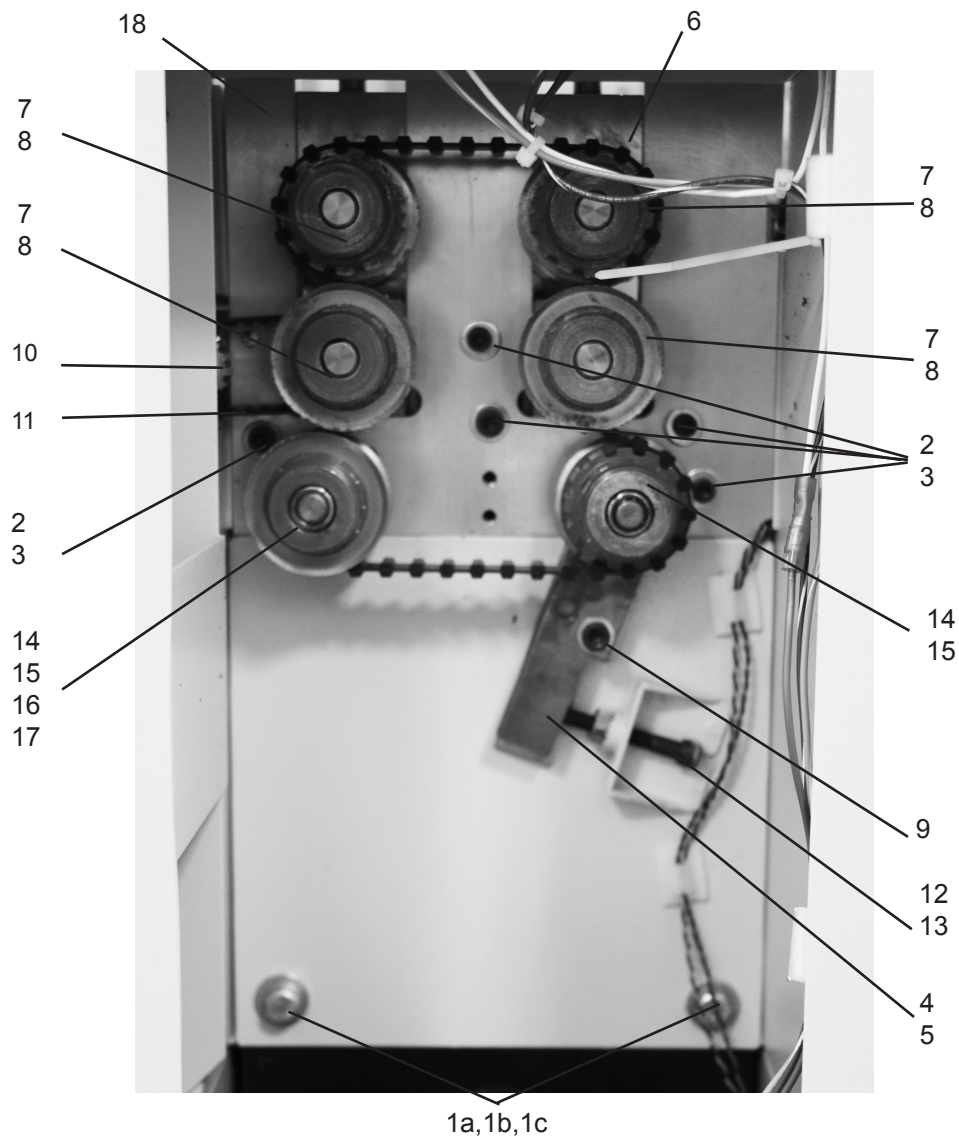
PARTS

SEALER CASING



#	Part #	Description	Qty
2	360-2010	COVER, ELECT ACCESS	1
1	373-0106	PPH, SCREW 10-32 SPL (WHITE)	14
2	360-2385	ACCESS DOOR	2
3	372-0105	CASTER, SWIVEL	2
4	372-0106	CASTER, SWIVEL 3" WITH BRAKE	2

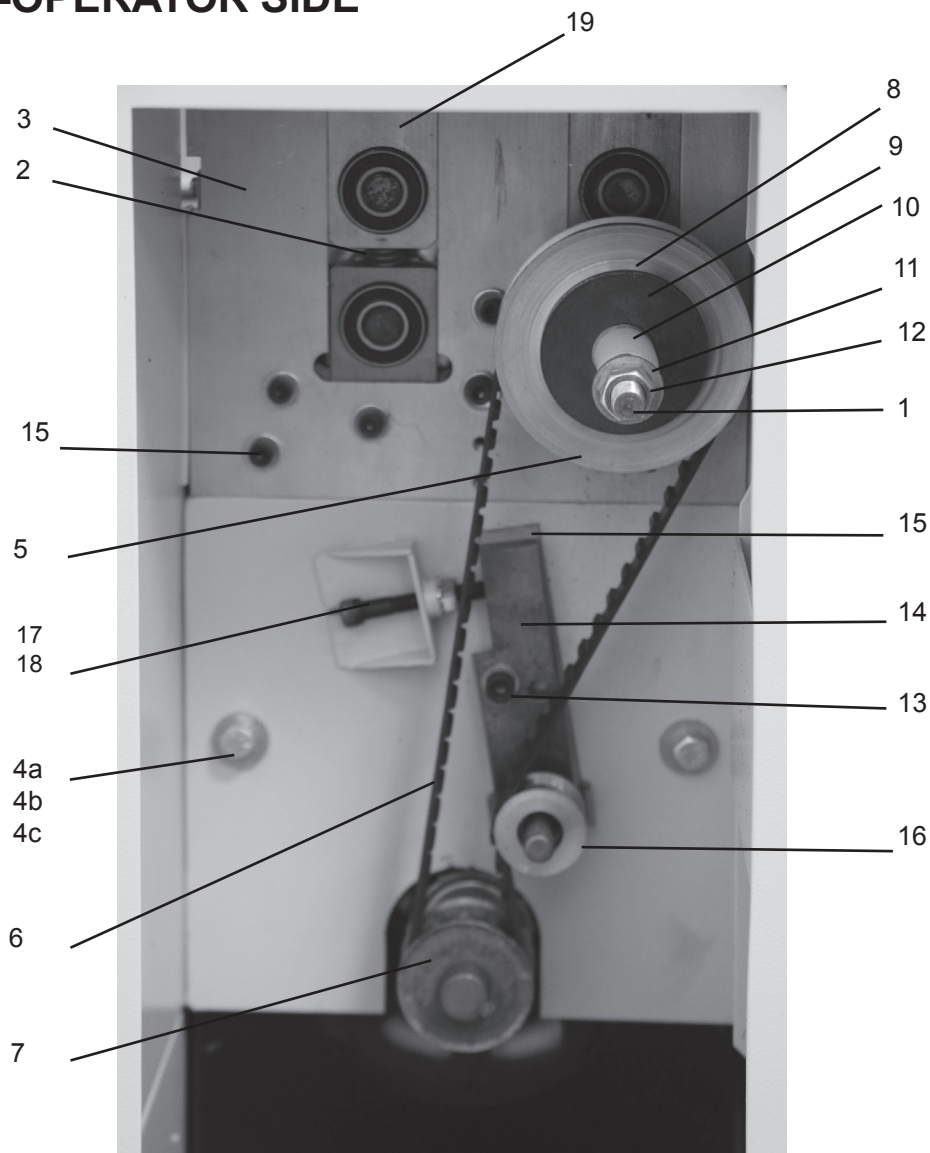
SEALER OPERATOR SIDE



#	Part #	Description	Qty
1a	375-0030	1/4-20 X 3/4 SCREW	2
1b	377-1813	1/4" WASHER	2
1c	377-2611	WASHER 1/4" SPLIT LOCK	2
2	374-0096	#10 -32 X 1.00, SOCKET HEAD SCREW	5
3	377-5298	# 10 FLAT WASHER	5
4	334-0371	IDLER ADJUST BRACKET	1
5	360-2101	IDLER ADJUST BRACKET SPACER	1
6	365-0146	TIMING BELT DOUBLE SIDED	1
7	365-0145	TIMING PULLEY 13T .38 PITCH (Serial # C193010 and below)	4
7	365-0253	TIMING PULLEY 13T 5/8 Bore (Serial # C193011 and above)	4
8	376-1874	1/4-20 X 3/16 SET SCREW	4

9	374-0096	#10 -32 X 1.00, SOCKET HEAD SCREW	2
10	365-0150	AUX DRIVE PULLEY (Serial # C193010 and below)	1
10	365-0256	AUX DRIVE PULLEY (Serial # C193011 and above)	1
11	365-0149	AUX DRIVE BELT, 1/5 PITCH	1
12	378-6549	1/4"x20 KEP NUT	2
13	374-5528	SCREW 1/4-20x 1 3/4 SOC HD CAP	2
14	395-0764	PULLEY 13T .38 PITCH MOD	2
15	377-6626	FLAT WASHER	2
16	375-0104	SCREW 1 1/8" 10-24 SOC. HD.	2
17	377-2809	WASHER #10 EXT STAR	8
18	334-0444	SIDE PLATE (Serial # C193010 and below)	1
18	334-0446	HD SIDE PLATE (Serial # C193011 and above)	1

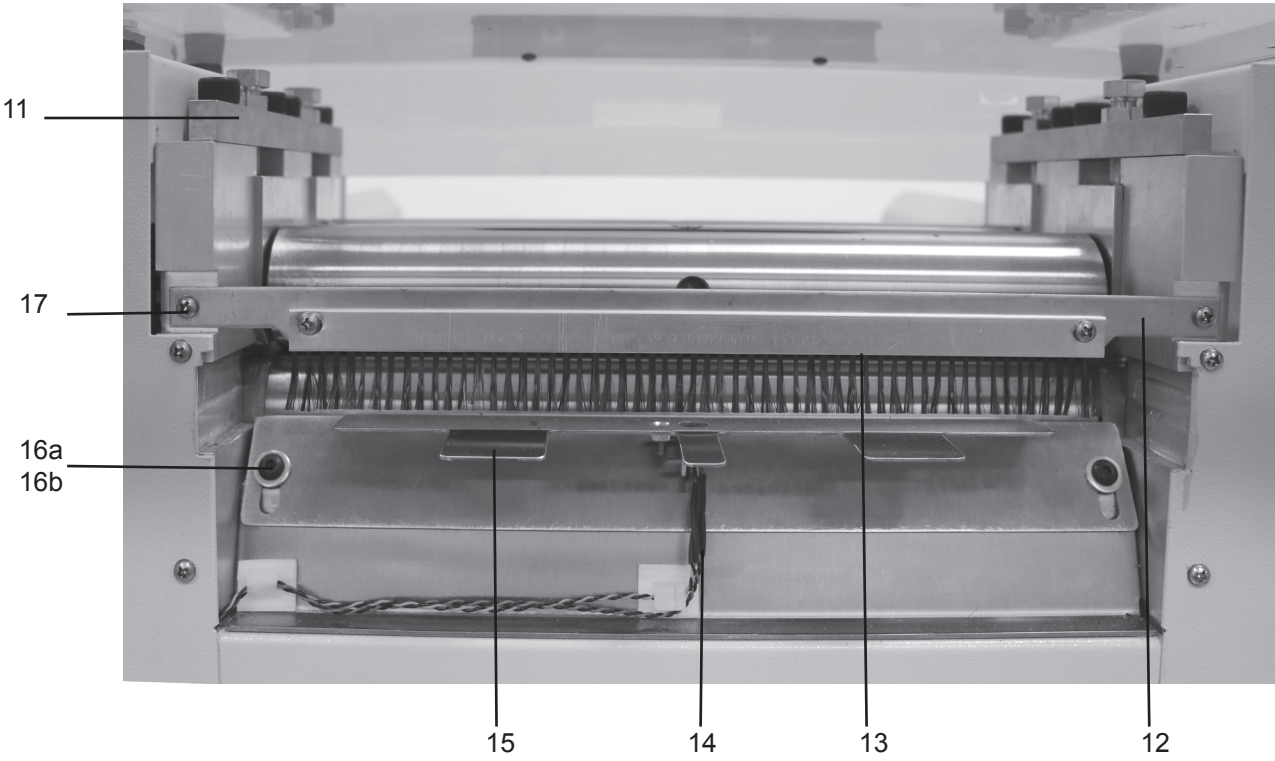
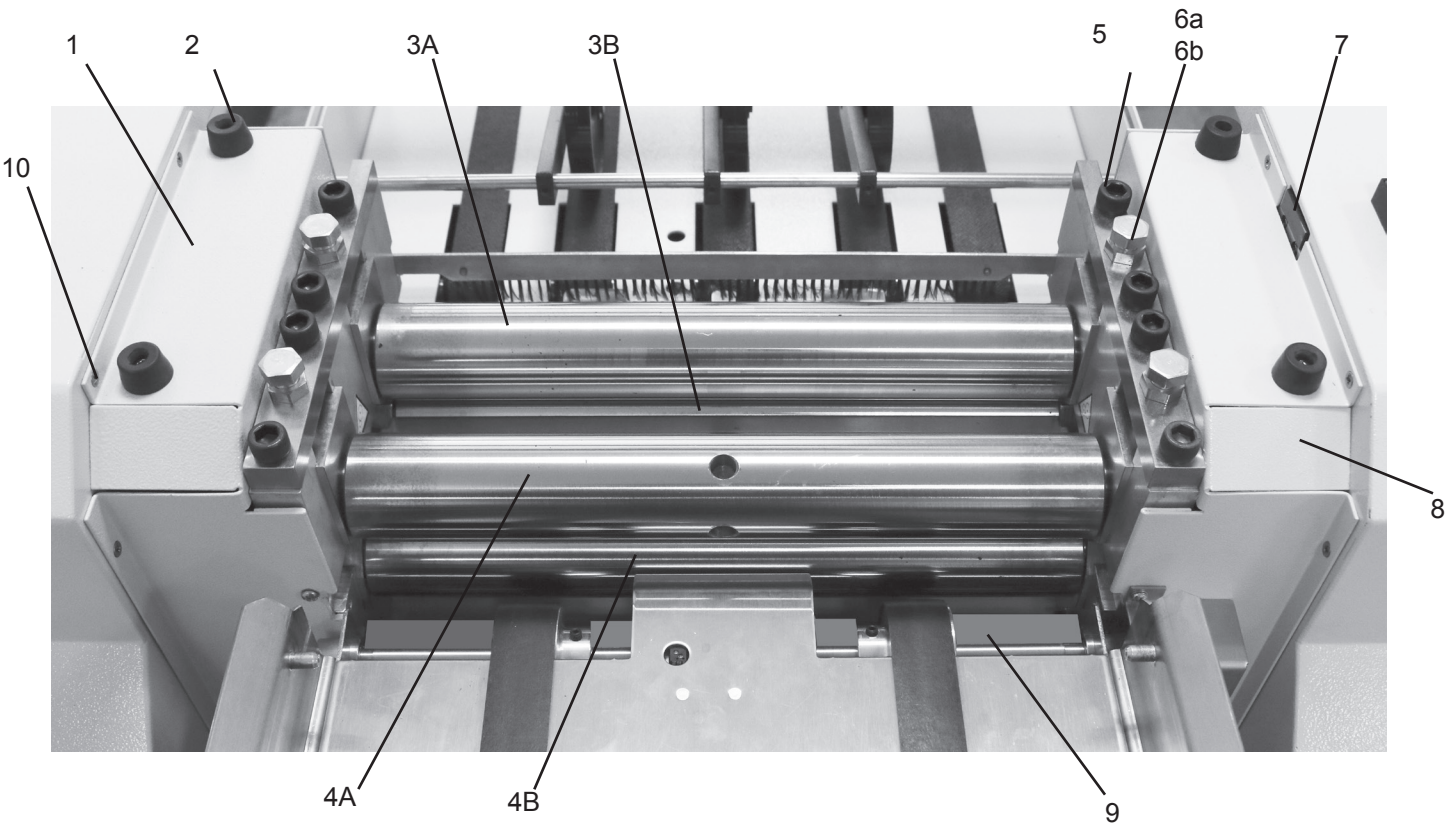
SEALER NON-OPERATOR SIDE



#	Part #	Description	Qty
1	395-1287	FRICTION DRIVE ROLLER ASSY (Serial # C193010 and below)	1
	395-1394	FRICTION DRIVE ROLLER ASSY (Serial # C193011 and above)	1
2	342-0063	COMPRESSION SPRING, 0.48 X .75	4
3	334-0443	SIDE PLATE DRIVE (Serial # C193010 and below)	1
3	334-0445	SIDE PLATE DRIVE (Serial # C193011 and above)	1
4a	375-0030	1/4-20 X 3/4 SCREW	2
4b	377-1813	1/4" WASHER	12
4c	377-2611	WASHER 1/4" SPLIT	4
5	395-1087	CLUTCHED PULLEY ASSY	1
6	365-5412	TIMING BELT 240 L 050	1

7	365-0123	TIMING PULLEY 12T 5/8 Bore (Serial # C193010 and below)	1
7	365-0253	TIMING PULLEY 13T 5/8 Bore (Serial # C193011 and above)	1
8	377-0079	WASHER, FRICTION DRIVE	2
9	334-0390	PRESSURE PLATE	2
10	342-0104	COMPRESSION SPRING .75X2.0	1
11	380-6547	SPACER WASHER FLAT	1
12	378-9548	LOCKNUT 3/8" -24	2
13	374-0096	#10 -32 X 1.00, SOCKET HEAD SCREW	2
14	395-1161	IDLER ADJUST BRACKET	1
15	360-2101	IDLER ADJUST BRACKET SPACER	1
16	395-1098	IDLER PULLEY ASSY	1
17	374-5528	1/4-20 X 1 3/4 SOC HD CAP	1
18	378-6549	1/4-20 KEP NUT	1
19	395-1393	HD BEARING BLOCK (Serial # C193011 and above only)	8

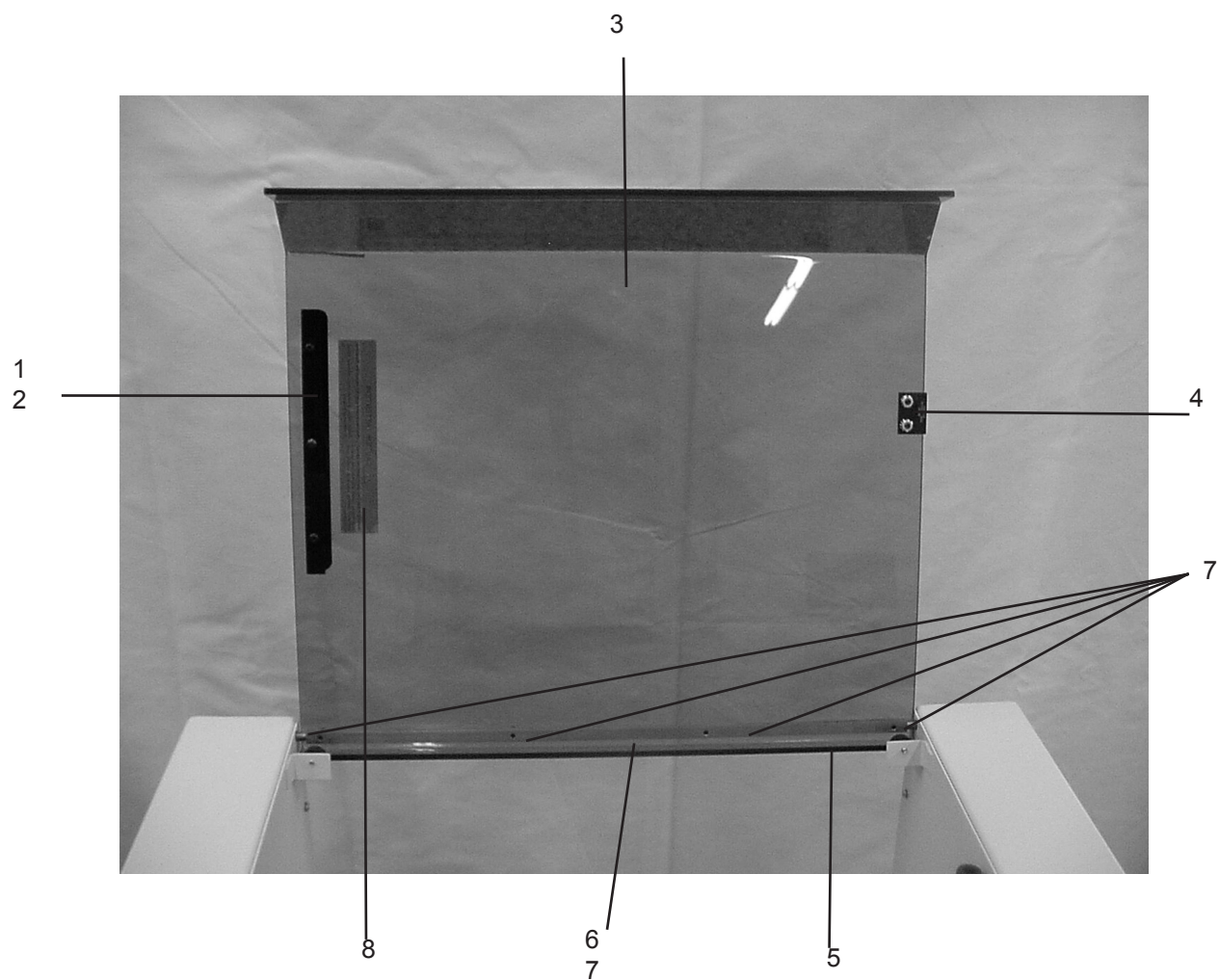
SEALER ROLLERS



SEALER ROLLERS

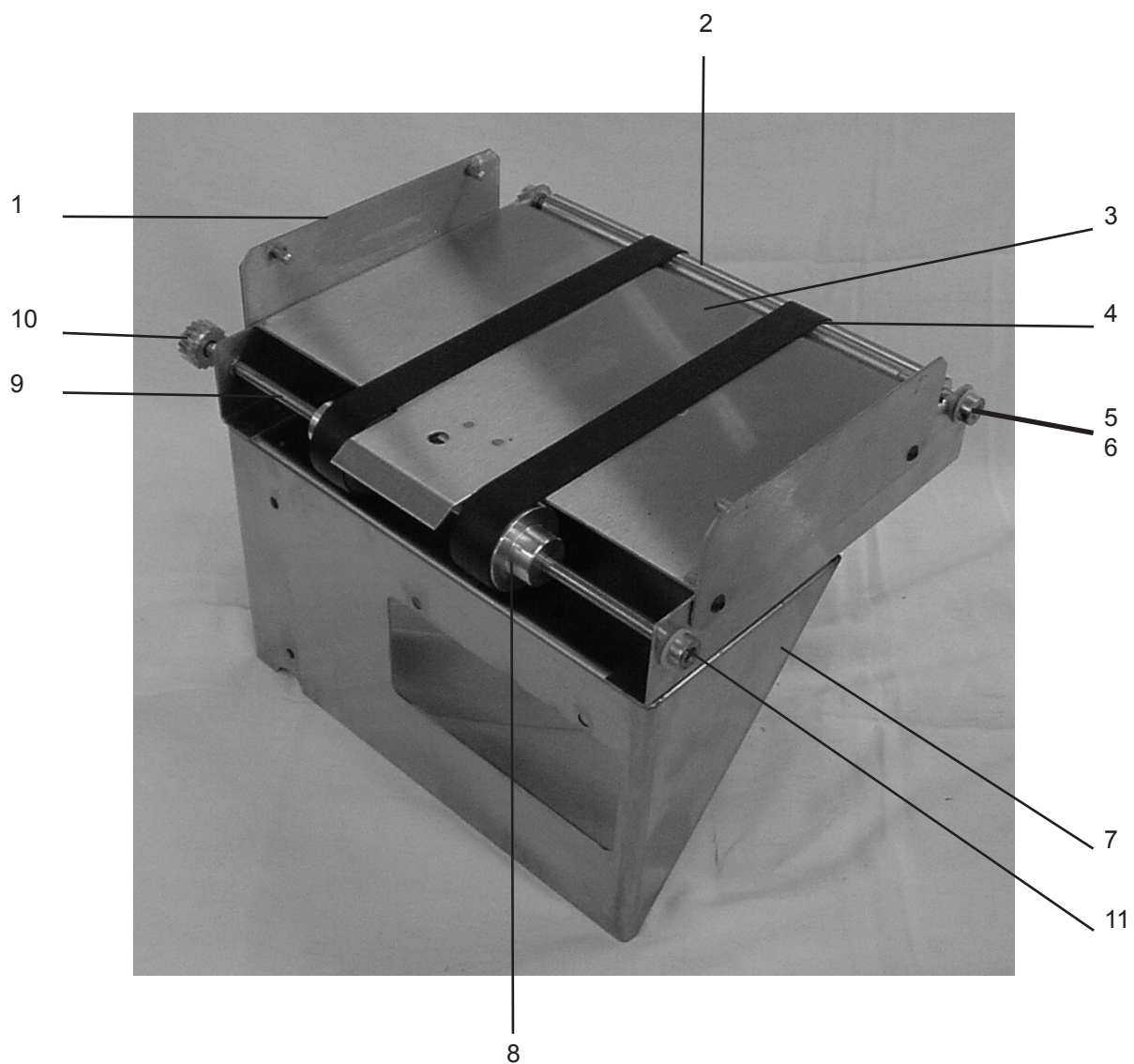
#	Part #	Description	Qty
1	360-2007	INNER COVER, LEFT	1
2	352-9576	SUPPORT BUMPER	4
3A	395-0767	UPPER INFEED ROLLER ASSY (Serial # C193010 and below)	1
3A	395-1395	DRIVEN ROLLER ASSY (Serial # C193011 and above) **Does not include Bearing Blocks: 395-1393 x 2	1
3B	395-0991	DRIVEN ROLLER ASSY (Serial # C193010 and below)	1
3B	395-1395	DRIVEN ROLLER ASSY (Serial # C193011 and above) **Does not include Bearing Blocks: 395-1393 x 2	1
4A	395-0785	UPPER ROLLER ASSY W/HOLES (Serial # C193010 and below)	1
4A	395-1396	UPPER ROLLER ASSY W/HOLES (Serial # C193011 and above) **Does not include Bearing Blocks: 395-1393 x 2	1
4B	395-1287	FRICTION DRIVE ROLLER ASSY (Serial # C193010 and below)	1
4B	395-1394	FRICTION DRIVE ROLLER ASSY (Serial # C193011 and above) **Does not include Bearing Blocks: 395-1393 x 2	1
5	375-0102	BOLT 3/8 x 1 1/4 SOC HD SCREW 8	1
6A	378-0118	3/8"-40 HEX JAM NUT	4
6B	375-0103	3/8" X 1 1/4' HEX HD	4
7	319-0213	PROXIMITY SENSOR	1
8	360-2005	INNER COVER, RIGHT	1
9	332-0093	CROSSBAR	2
10	375-6625	6-32 X 3/8" PHIL DRIVE FLAT HD	1
11	360-1283	BRACKET SIDE FRAME CAP	2
-	395-0947	STATIC BRUSH ASSEMBLY	1
12	360-2064	BRKT. STATIC BRUSH	1
13	316-0011	STATIC WAND	1
14	310-0134	PHOTO-EYE HARNESS	1
15	360-3049	INFEED RAMP	1
16A	375-5699	SCREW 10-32 X 1/4 BUTTON HD CA	8
16B	377-5298	#10 FLAT WASHER	2
17	373-5893	LONG INTERNAL 6 X 32	10
-	332-0141	JAM CLEARING TOOL	1

TOP COVER



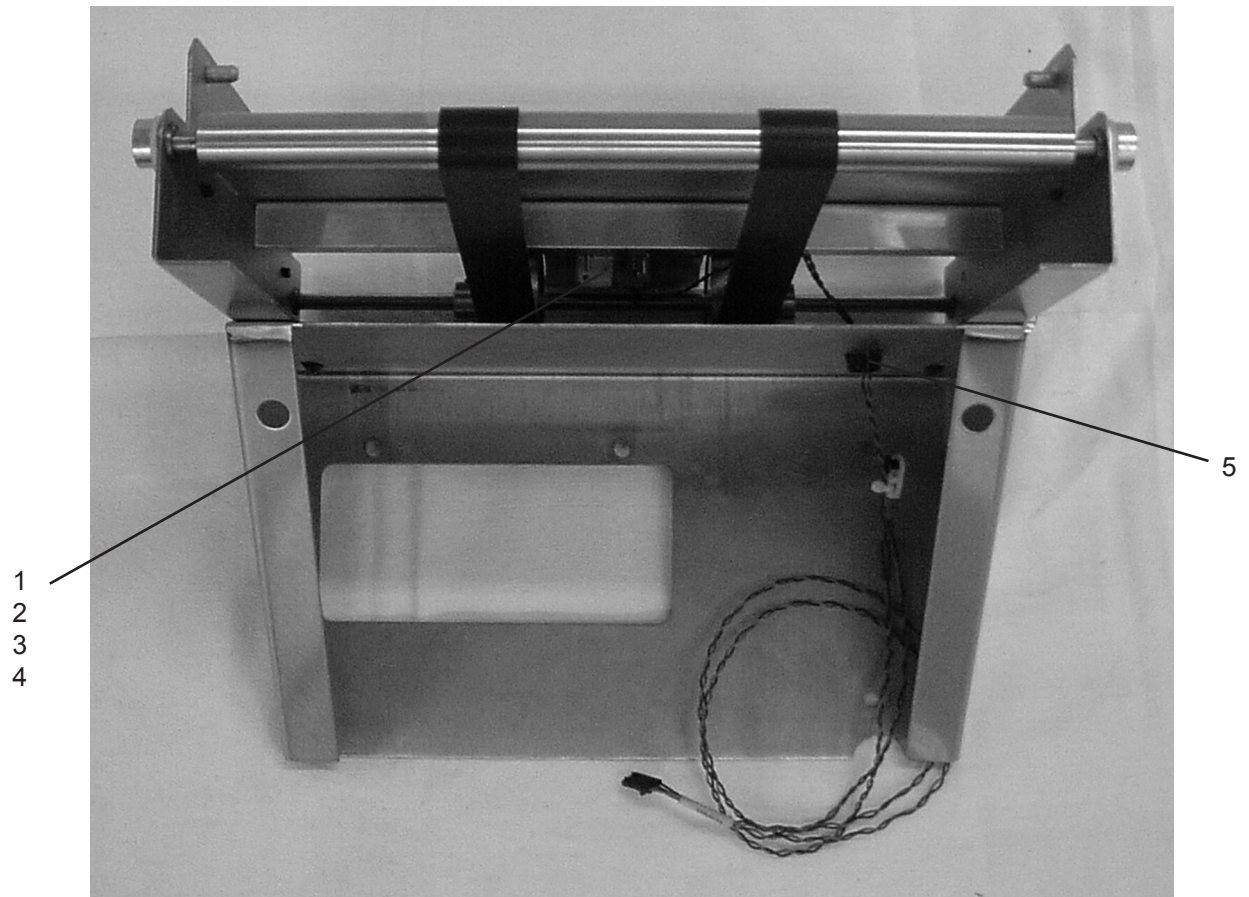
#	Part #	Description	Qty
1	360-0485	HANDLE TOP COVER 17"	1
2	375-5825	6-32 x 1/2 BUTTON HD SCREW	6
3	321-0108	TOP COVER FD 2092	1
4	319-0159	MAGNET, ACTUATOR	1
5	375-5825	6-32 x 1/2 BUTTON HD SCREW	6
6	332-0154	PIVOT ROD	1
7	375-5825	6-32 x 1/2 BUTTON HD SCREW	6
8	325-0152	CAUTION ENG/FRENCH-FD ROLLER	1

INFEEED TRANSPORT BALL DECK



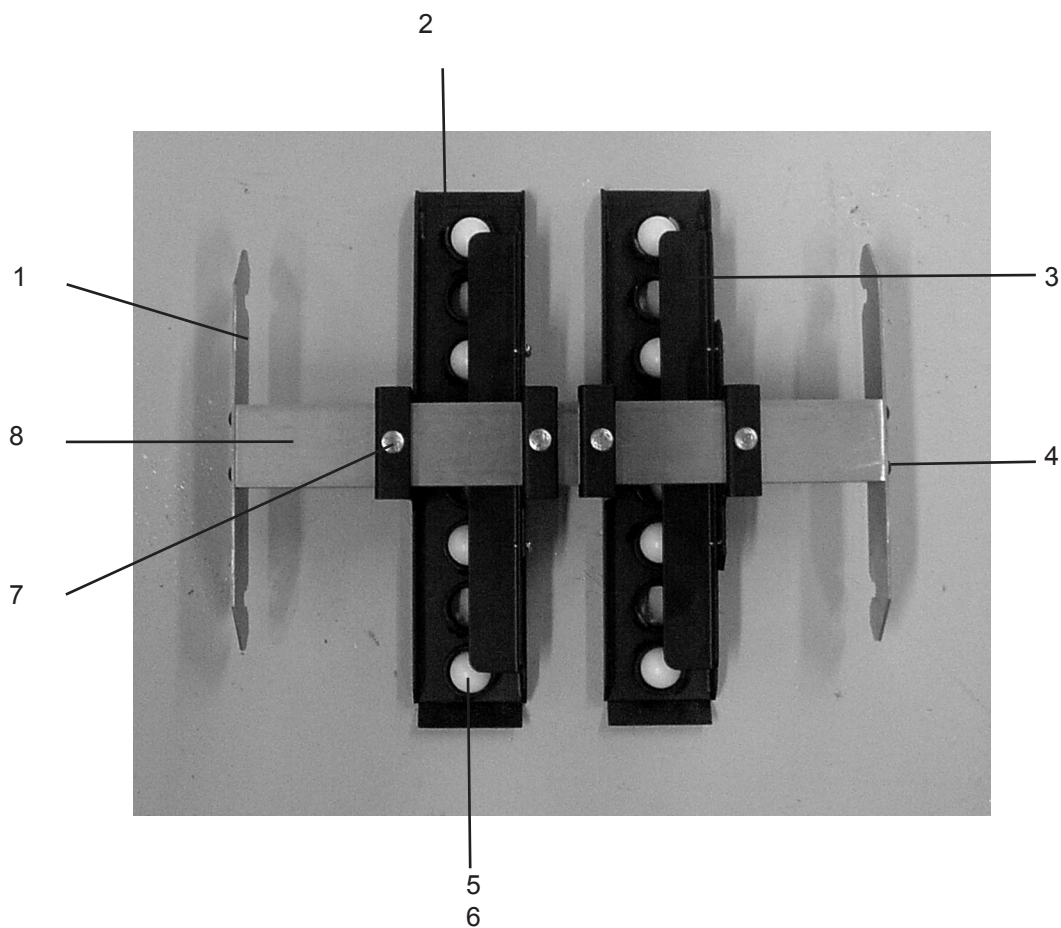
#	Part #	Description	Qty
1	360-2023	SIDE BRKT	2
2	331-0207	SHAFT, FRONT	1
3	360-2020	DECK, TRANSPORT	1
4	369-0029	BELT, TRANSPORT	2
5	381-0004	COLLAR 3/8"	1
6	370-0034	BRG ID .312 X OD .500	1
7	360-2021	BRACE, TRANSPORT	1
8	334-0410	SPOOL, LARGE BORE	2
9	331-0208	SHAFT, REAR	1
10	365-0150	AUX DRIVE PULLEY	1
11	370-0034	BEARING ID 10mm OD 19mm	4

INFEEED TRANSPORT BALL DECK CONT.



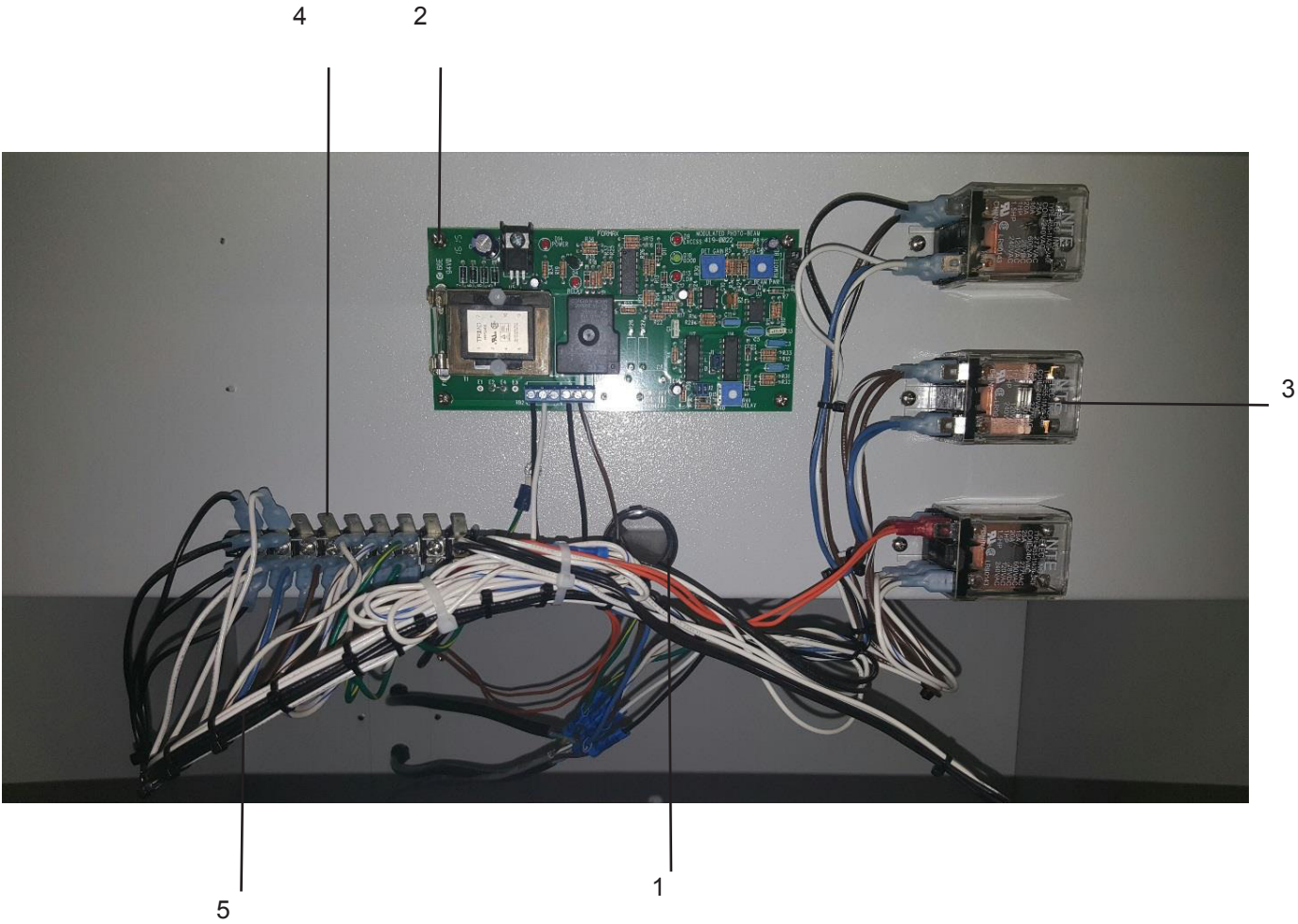
#	Part #	Description	Qty
1	310-0134	PHOTO EYE HARNESS	1
2	373-0010	SCREW PPH 4-40 x 1/2 LG	1
3	360-2034	BRKT, SENSOR	1
4	378-0001	4-40 HEX NUT	1
5	315-0041	SNAP BRUSHING, .562 DIA HOLE	1

INFEEED TRANSPORT BALL DECK CONT.



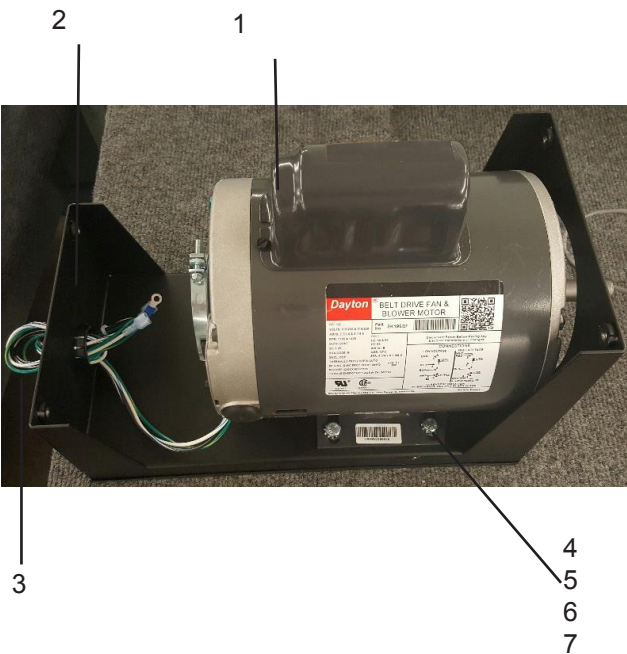
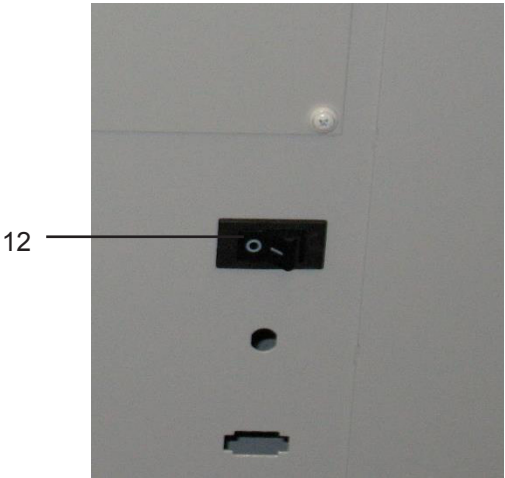
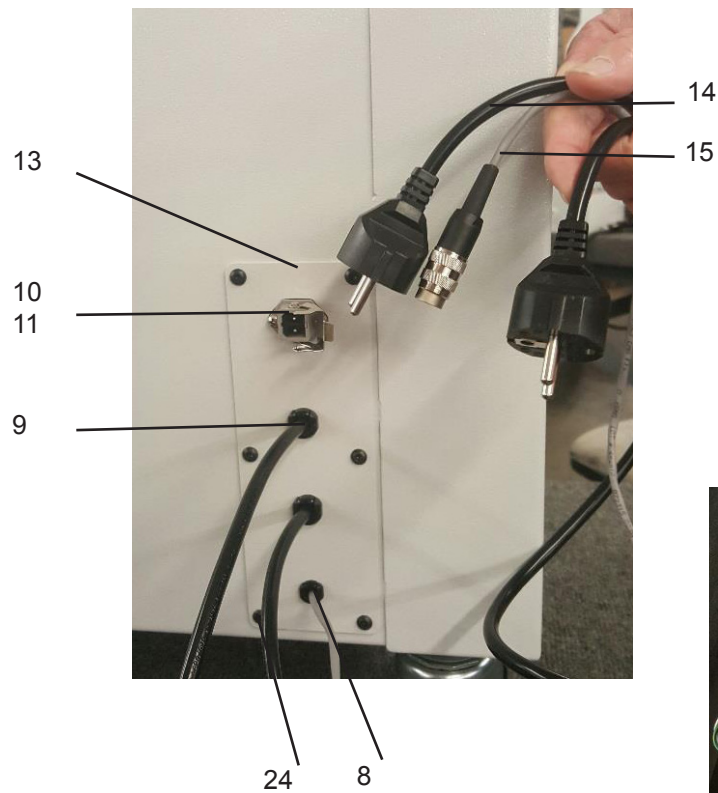
#	Part #	Description	Qty
1	360-2024	BRKT CROSS BAR	2
2	360-2025	SKI	2
3	360-2022	BALL RETAINER	2
4	375-5699	SCREW 10-32 X 1/2 BUTTON HD CA	4
5	370-0032	METAL BALL	6
6	370-0033	PLASTIC BALL	12
7	375-0093	8-32 THUMB SCREW	4
8	332-0155	CROSSBAR	1

ELECTRICAL



#	Part #	Description	Qty
1	315-0012	SNAP BRUSHING	2
2	395-0989	240 VAC MODULATED BEAM PCB	1
3	319-0187	RELAY 240 VAC	3
4	314-0114	TERNIMAL BLOCK WITHOUT JUMPERS	1
5	310-0212	WIRE HARNESS 240 VAC (EURO)	1

ELECTRICAL



#	Part #	Description	Qty
1	395-1133	240 VAC 1/2 HP MOTOR	1
2	360-2015	MOTOR BRKT	1
3	310-0218	WIRE HARNESS	1
4	375-0030	1/4-20 X 3/4 HEX HEAD SCREW	4
5	377-1813	1/4" WASHER	4
6	377-2808	LOCK WASHER	4
7	378-6549	1/4-20 KEP NUT	4
8	315-7721	HEYCO STRAIN RELIEF	1
9	315-0020	STRAIN RELIEF 6P3-4	2
10	314-0080	PANEL MOUNT CONNECTOR	1
11	373-5869	SCREW PPH 6-32 X 1/4 LG. INT STAR	2
12	317-0049	CIRCUIT BREAKER DBL POLE 240V/5AMP	1
13	360-3046	INTERFACE PLATE GBR FOLDER	1
14	310-0210	POWER CORD 240 VAC EURO	2
15	395-1361	INTERFACE CABLE, SIGNAL	1

The diagram illustrates the wiring for a 317-0049 Circuit Breaker, DBL POLE 240V/5AMP, interfaced with a 313-0054 120/240 VAC MOTOR. The system includes a 310-0134 PHOTO SENSOR and a 390-0659 P.C. BOARD (MODIFIED). The wiring is as follows:

- Power Input:** BLK 110 VAC and WHT 110 VAC lines enter the circuit breaker.
- Signal In:** BRN 110 VAC, YL/GN, and BLU 110 VAC lines are connected to the circuit breaker.
- Signal Out:** CLEAR 24 VAC, WT/BLU, and BLK lines are connected to the circuit breaker.
- Interlock Switch:** A 300 VAC INTERLOCK SWITCH (N.O.) is connected to the circuit breaker.
- Photo Sensor:** A 310-0134 PHOTO SENSOR is connected to the circuit breaker.
- Motor:** A 313-0054 120/240 VAC MOTOR is connected to the circuit breaker.
- Relays:** K1, K2, K3, K4, and K5 are used for various control functions.
- PC Board:** A 390-0659 P.C. BOARD (MODIFIED) is connected to the circuit breaker.

NOTE: PCB SET FOR LIGHT OPERATE DELAY ON