

# **FORMAX<sup>®</sup>**

---

AutoSeal<sup>®</sup>

FD 1406 / FD 1506

FE 1406 / FE 1506

FK / FL SERIES

MAINTENANCE / PARTS MANUAL  
SECOND EDITION



# TABLE OF CONTENTS

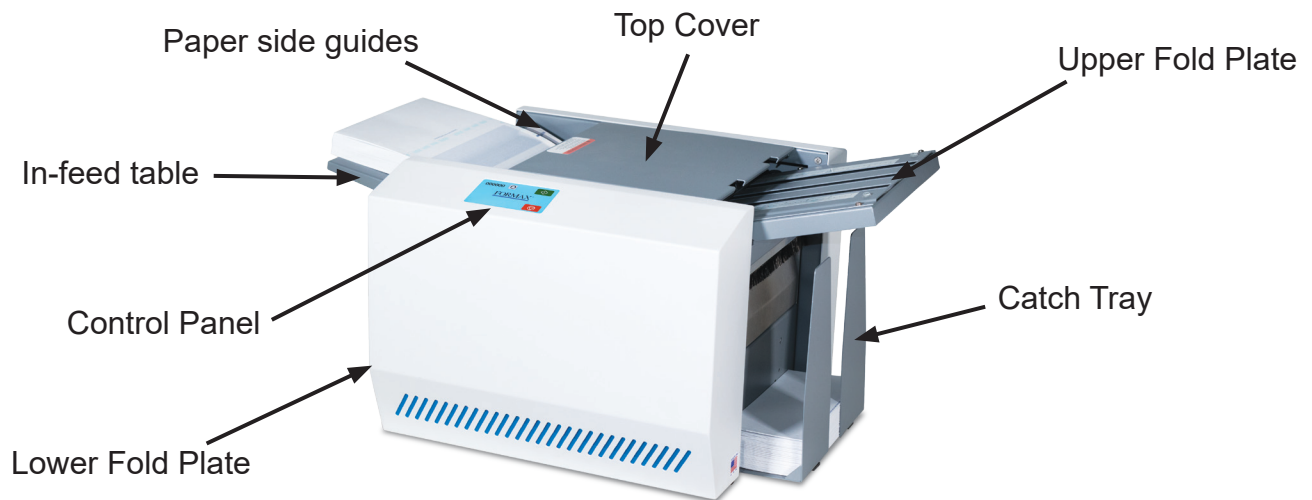


TOPIC	PAGE
SPECIFICATIONS, UNPACKING & SET-UP	1
CONTROL PANEL	2
OPERATION	2
FOLD PLATE INSTALLATION, ADJUSTMENT	3
SETTING CUSTOM FOLDS	4
DETERMINING FOLD TYPE	5
ERROR SCREENS	6
DAILY MAINTENANCE, TROUBLESHOOTING	7-11
SERVICE MODE	11
SEALER ROLLER CLEARANCE	12
REPLACING INFEED ROLLERS	12
REPLACING SINGULATOR PAD	13
REPLACING SEALER ROLLERS	13
REPLACING CORK PAD	14
REPLACING FOLD ROLLERS	14
BELT ADJUSTMENT AND REPLACEMENT	14
PHOTO EYE REPLACEMENT, SENSITIVITY ADJ	15
ELECTRICAL SCHEMATIC	16 - 17
PARTS LIST	18 - 29





# **SPECIFICATIONS**



## **FUNCTION:**

The 1406/1506 Pressure Sealer folds and seals many different configurations including C, V, Z and custom folds. It may also use several different sizes of forms. For configuration and/or paper sizes, see listing below.

Paper size:	Up to 8.5" W x 14" L
Fold styles:	C, Z, V and custom folds
Fixed speed:	FD1406: Up to 73 sheets per minute, based on 11" Z fold FD1506: Up to 100 sheets per minute, based on 11" Z fold
Hopper capacity:	FD 1406: Up to 160 sheets 20# FD 1506: Up to 200 sheets 20#
Weight:	82 lbs.
Dimensions:	24" L x 17" W x 13" H
Power supply:	120V, 50/60 Hz
Certifications:	UL, CE and CUL Approved

# **UNPACKING & SET-UP**

1. Check package for shipping damage. If there is shipping damage, do not discard the box.

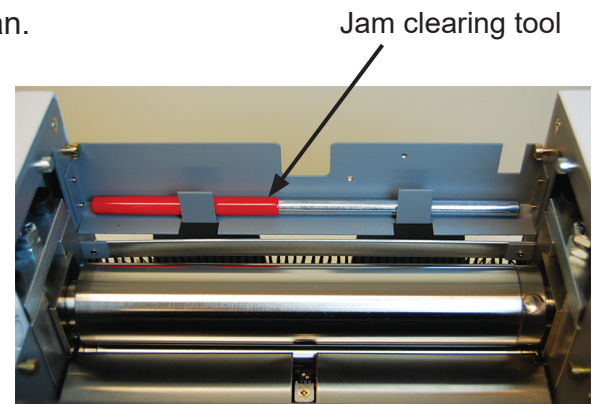
2. CAUTION: Two people are required to lift the machine out of the box.

3. Remove the paper tray and insert into rails on bottom pan.

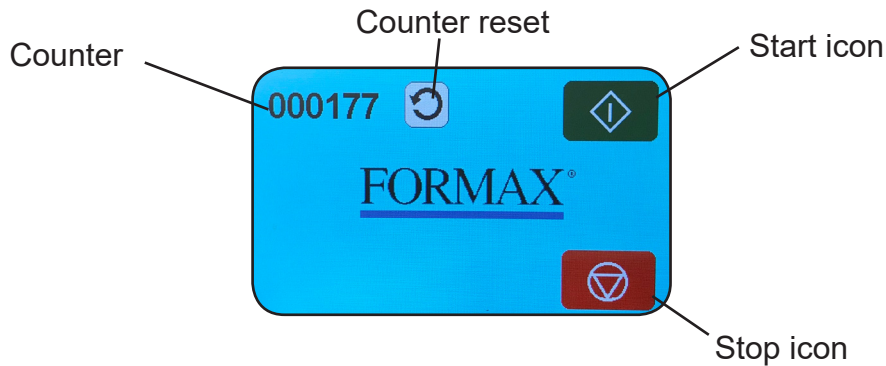
5. Install upper fold plate (refer to page 3 part 4 for proper installation).

4. Plug cord into machine and into wall outlet.

5. Place the jam clearing handle into the the holder which is mounted to the machine. This is the jam clearing handle's proper location (see picture, right).



# CONTROL PANEL



## OPERATION

1. Adjust fold plates to desired fold for length of paper (see fold plate adjustment on page 3). To do this, loosen the two thumbscrews (figure 3a & b) on each fold plate. Align center bar (figure 3a & b) so the marks on each side match up. For "V" folds remove the lower fold plate, turn around 180° and reinstall.
2. Make sure fold plates and cover are reinstalled properly (see page 3).
3. Plug in cord and turn power on (figure 1).
4. Test fold settings. Push the paper feed lever (figure 2) down, place one form onto the in-feed table and press the start button. Examine document and adjust fold plates if necessary (see fold plate adjustment on page 3).
5. Load forms. Push the paper feed lever down and load paper neatly stacked and squared on to the in-feed table. Paper can be stacked up to 300 sheets. Note: Standard "Z" fold forms can be loaded face up or down with the glue edge leading. All "C" fold forms must be loaded face up with glue edge leading.
6. Check that the ready light is green and press the start button to begin operation.



Figure 1

Power Switch

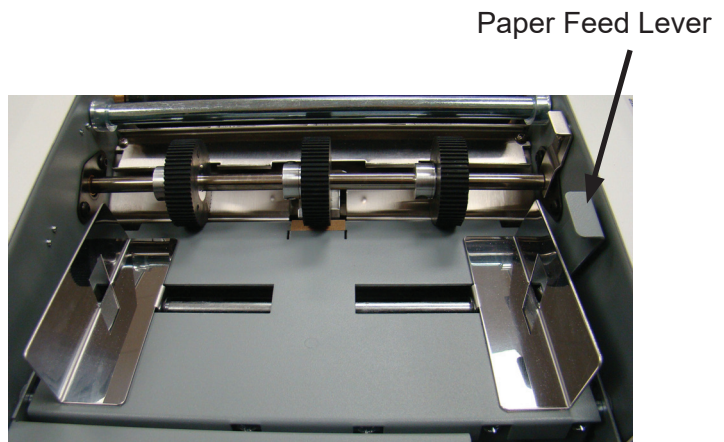


Figure 2

# FOLD PLATE ADJUSTMENT

## Upper Fold Plate

## Lower Fold Plate

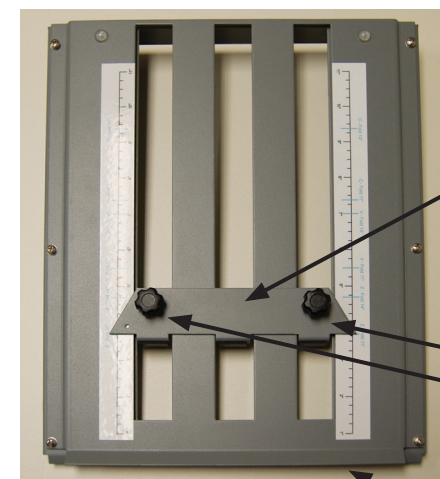


Figure 3a

Throat

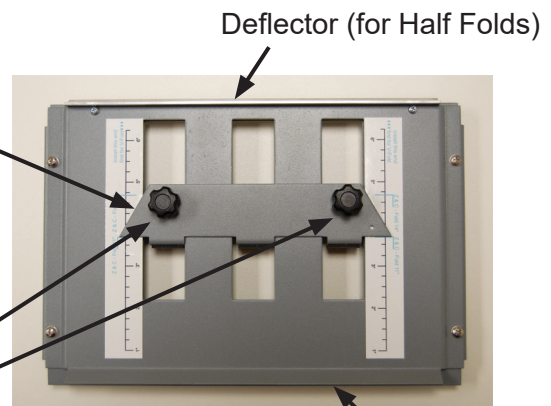


Figure 3b

Throat

1. To adjust the first fold remove the top cover to access the top fold plate. If the first fold is too long loosen the two thumbscrews on the upper fold plate and slide the bar down. If the fold is too short loosen the thumbscrews and slide the bar up.

**NOTE:** The bar should be on the same marks on each side.

2. To adjust the second fold remove the lower fold plate. If the second fold is too long loosen the two thumbscrews and slide the bar up. If the fold is too short loosen the thumbscrews and slide the bar down.

**NOTE:** The bar should be on the same marks on each side.

3. For quick setup of “C”, “Z” , Uneven “V” folds refer to the blue lines on the fold plate.

4. To reinstall the upper fold plate, slide the plate (with thumbscrews facing up and the throat toward the inside of the machine) until the grooves on the underside line up with the four pins on the machine (figure 4a & 4b).

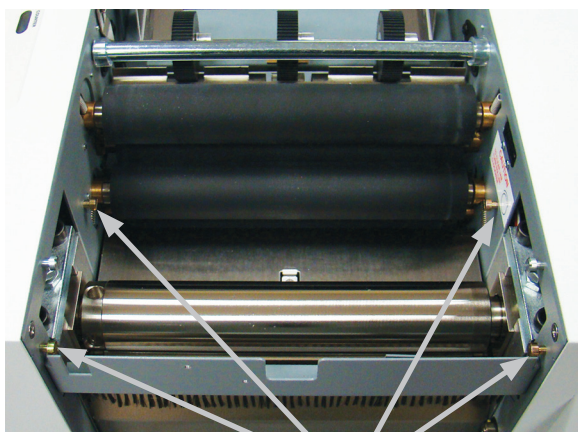


Figure 4a

Fold Plate Pins

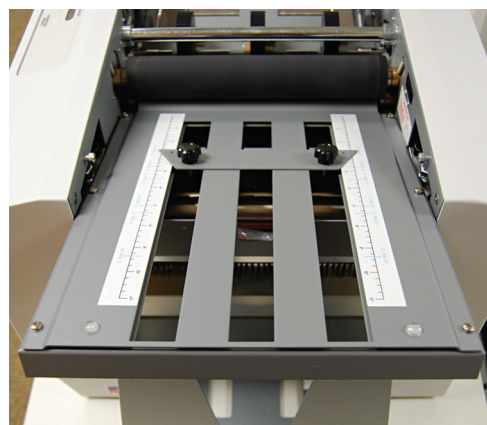


Figure 4b, correctly installed

5. To reinstall the lower fold plate, slide the plate (with the thumbscrews facing up and throat toward inside of machine, figure 5b) until it rests on the two silver bars (figure 5a) and locks into place (figure 5c).

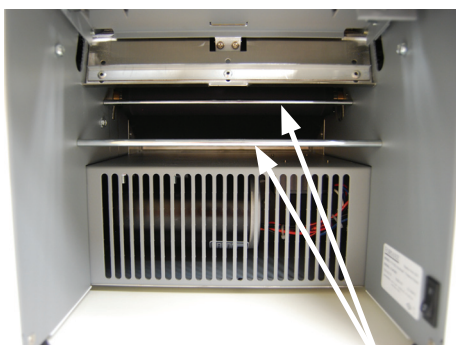


Figure 5a

Bars



Figure 5b

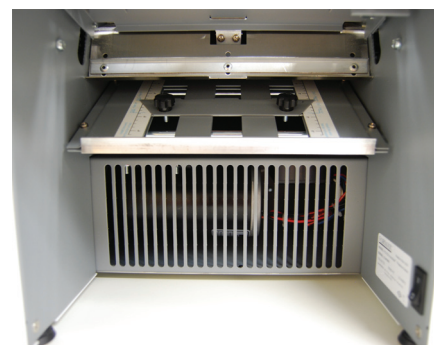
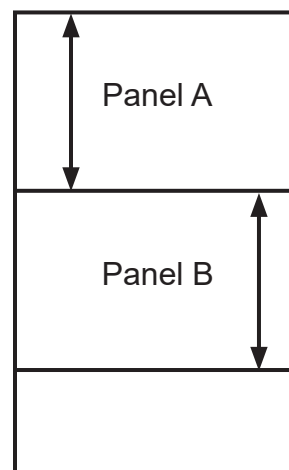


Figure 5c

## **SETTING CUSTOM FOLDS**

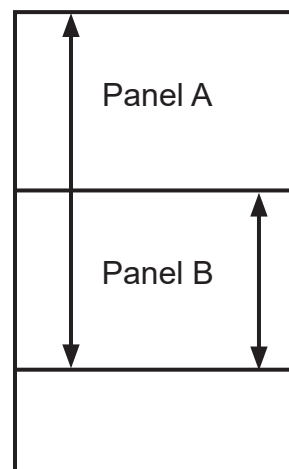
### **Eccentric “Z”**

1. Measure the length of panel “A”.
2. Adjust the upper fold plate so that the bar lines up with the measurements of panel “A”, for example: if panel “A” is 5 1/4” long move the bar up or down so that it lines up with the 5 1/4” mark on the fold plate.
3. Measure the length of panel “B”.
4. Adjust the lower fold plate so that the bar lines up with the measurements of panel “B”.
5. Load forms and press start (refer to OPERATION on page 2).



### **Uneven “C” / Return Mailer (FD 1506 only)**

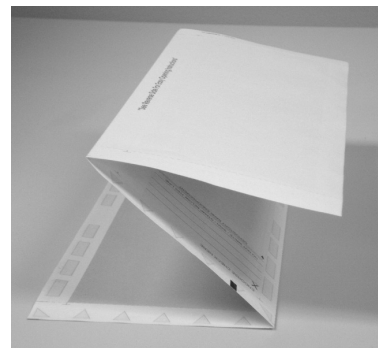
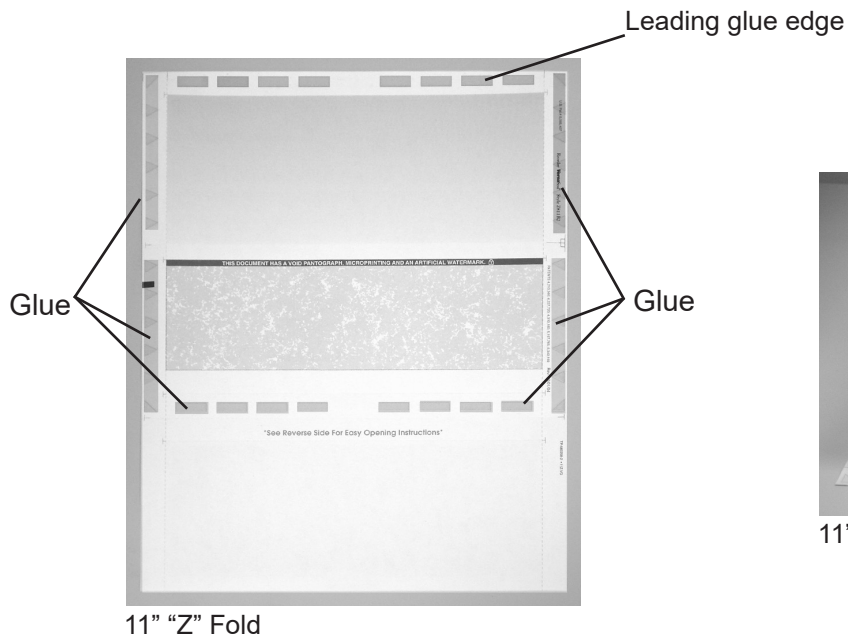
1. Measure the length of panel “A” & “B”.
2. Adjust the upper fold plate so that the bar lines up with the measurements of panel “A” & “B”, for example: if panel “A” + “B” is 10 1/2” long move the bar up or down so that it lines up with the 10 1/2” mark on the fold plate.
3. Measure the length of panel “B”.
4. Adjust the lower fold plate so that the bar lines up with the measurements of panel “B”.
5. Load forms and press start (refer to OPERATION on page 2).



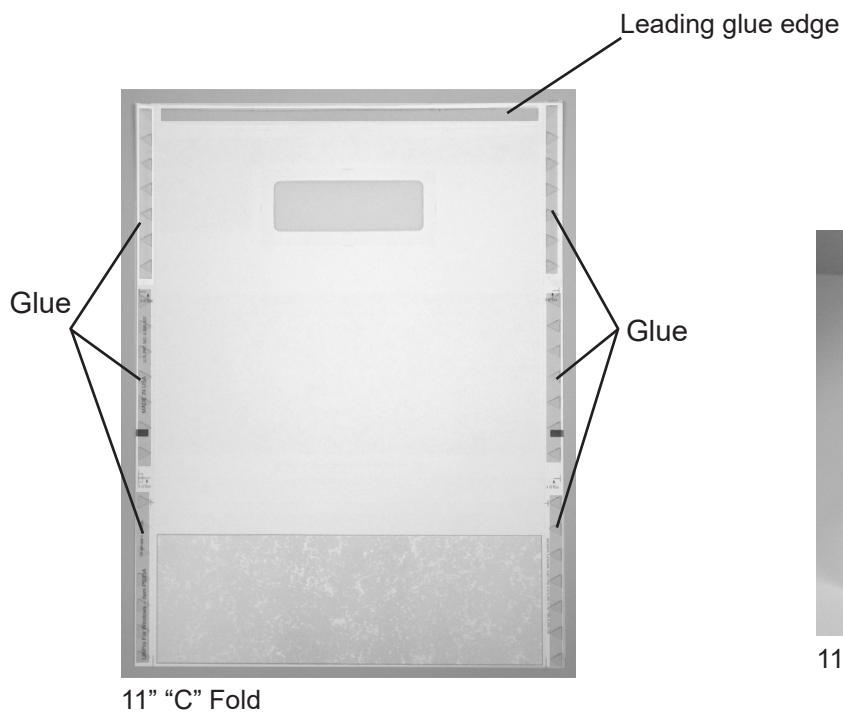


# DETERMINING FOLD TYPE

Two Standard Folds 11" "Z" & 11" "C"  
Refer to page 4 for custom fold setup.



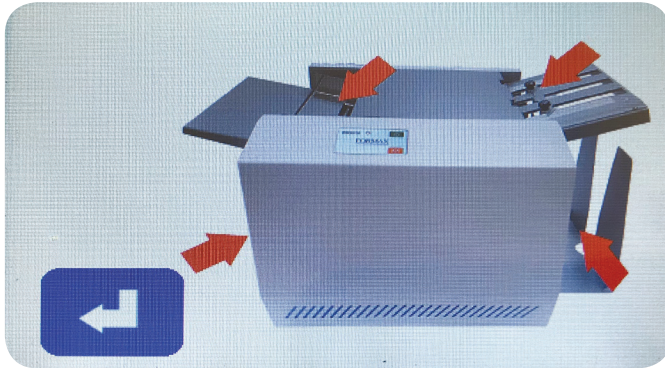
11" "Z" Fold





11" "C" Fold

# Error Screens

## Paper Out / Paper Mis-Feed / Paper Jam




1. The feeder is empty. Load paper into the feeder and press the “” icon to resume operation.

2. A mis-feed has occurred. Reset the stack of paper in the in-feed and press the “” icon to resume operation.

3. A Paper jam has occurred in one of the areas indicated. Turn the folder to the off position and unplug. Check the area indicated for paper and remove. Replace the fold plates and plug the folder in and the power on.

## Cover Open



The top cover is open. Close the top cover and press the “” icon to resume operation.

## **DAILY MAINTENANCE**

1. It is recommended to let forms cool for one-half hour, from the laser printer, before folding and sealing. This allows toner to set on the forms, and static electricity to discharge. A 402 Series Jogger is recommended for best results. The Jogger squares the forms and dissipates heat and static electricity created by laser printers.

2. If toner builds up on the metal sealer rollers, clean the rollers with a lint-free cloth dampened sparingly with a mild household cleaner.

3. Clean in-feed wheels and fold rollers with Formax-recommended roller cleaner & rejuvenator to remove paper dust and toner. A damp cloth with water is the best alternative.

**CAUTION:** Do not use any chemicals other than the roller cleaner & rejuvenator or water.

## **TROUBLESHOOTING**

### **A. Clearing Paper Jams:**

**WARNING:** Turn machine off and unplug cord from its receptacle.

1. If a jam occurs between the metal rollers remove any remaining forms from the hopper.
2. Open the top cover and remove the upper fold plate.
3. Remove the jam clearing handle (located under the upper fold table), apply the handle to the upper metal roller (figure 6) and turn clockwise until the paper jam is clear. **NOTE:** Do not turn the roller counter-clockwise to force the forms to exit: rollers may be damaged.
4. Remove the damaged form, return tool to holder and reinstall upper fold plate.
5. Reinstall cover and press the black breaker reset button (figure 7).

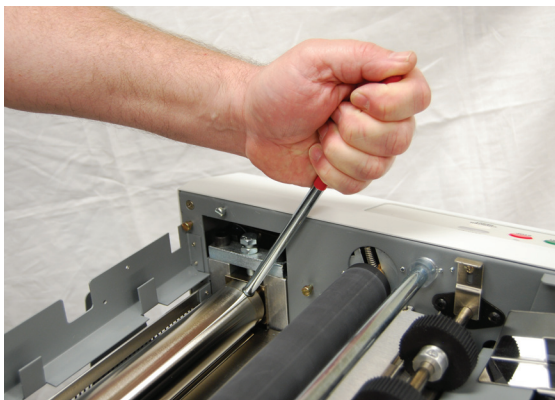


Figure 6

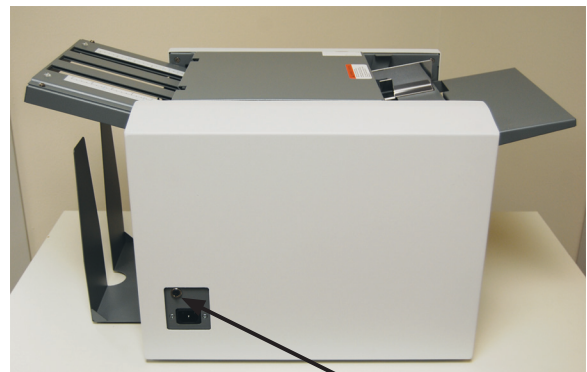


Figure 7

Breaker reset

If a jam occurs in the fold plates, remove fold plate and remove paper. Reinstall fold plate.

# **TROUBLESHOOTING**

## **B. Fold Quality Needs Improving:**

1. Make sure paper is squared and installed correctly. Side guides should be evenly balanced and snug against the paper.
2. If folds are still incorrect adjust fold plates (see fold plate adjustment on page 3).

### **B1. Fold Quality Is Still Incorrect: Adjust Fold.**

1. Take a piece of plain copy paper; mark the leading edge, (first edge of paper to feed into machine).
2. Run the paper through the machine.
3. Place a pressure seal form on the top cover of machine.
4. Place the piece of plain paper, just processed, on top of the pressure seal form aligning the leading edge of both forms (see diagram below).
5. Check to see if folds on the plain paper line up with the fold perforations of the pressure seal form (see figure 8, below). If the folds on the plain paper & fold perforations on the pressure seal forms do not line up, adjust the fold plates (see fold plate adjustment on page 3).
6. Once the adjustments have been made, take one pressure seal form and test it.
7. Tear open processed form and inspect to see if folds line up with the fold perforations.

**NOTE:** Repeat this process until the folds on plain paper line up with the perforations on the form.

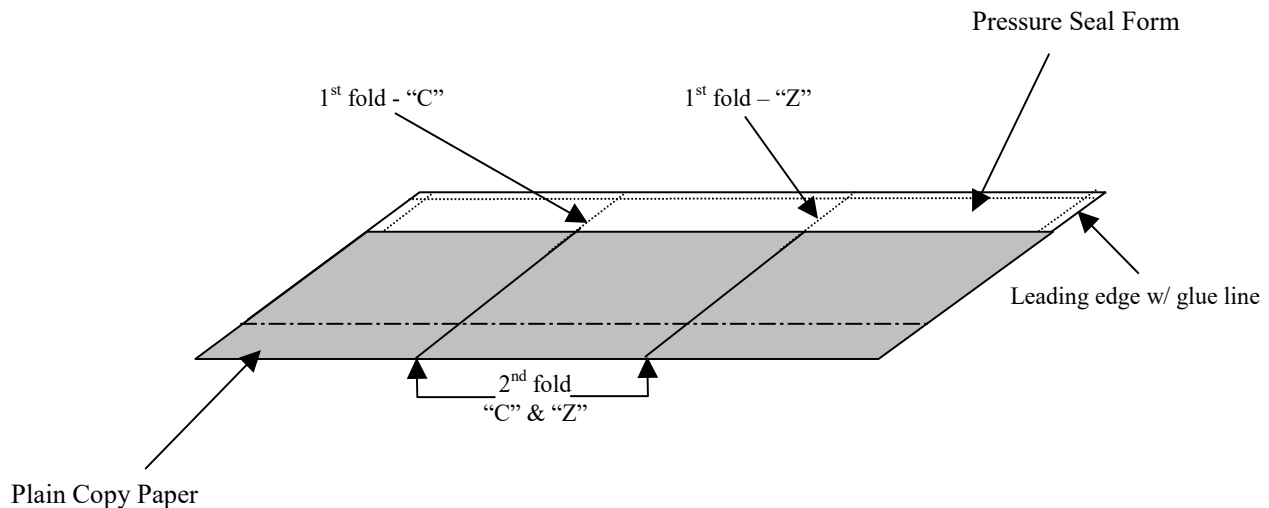


Figure 8



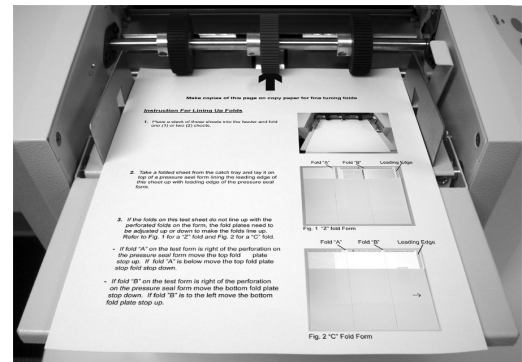
# Leading Edge



Make copies of this page on copy paper for fine tuning folds

## Instruction For Lining Up Folds

1. Place a stack of these sheets into the feeder and fold one (1) or two (2) sheets.



2. Take a folded sheet from the catch tray and lay it on top of a pressure seal form lining the leading edge of this sheet up with leading edge of the pressure seal form.

Fold "A" Fold "B" Leading Edge

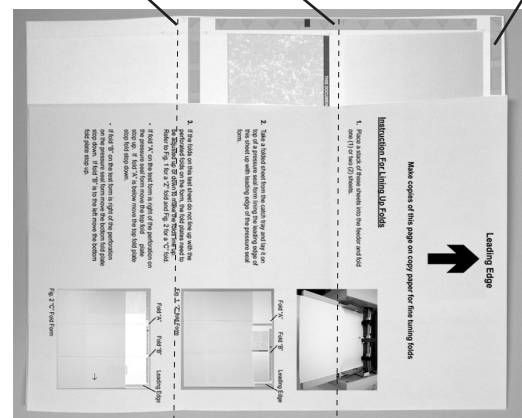


Fig. 1 "Z" fold Form

3. If the folds on this test sheet do not line up with the perforated folds on the form, the fold plates need to be adjusted up or down to make the folds line up. Refer to Fig. 1 for a "Z" fold and Fig. 2 for a "C" fold.

- If fold "A" on the test form is right of the perforation on the pressure seal form move the top fold plate stop up. If fold "A" is below move the top fold plate stop fold stop down.
- If fold "B" on the test form is right of the perforation on the pressure seal form move the bottom fold plate stop down. If fold "B" is to the left move the bottom fold plate stop up.

Fold "A" Fold "B" Leading Edge

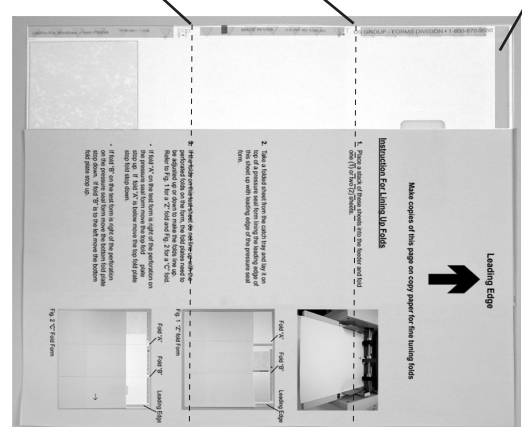


Fig. 2 "C" Fold Form

### C. Paper is not Folding Square (Skewing):



Figure 9

1. If paper pulls left or right adjust the skew. Turn the skew adjuster, located under the infeed tray, (Fig. 9) left or right until the paper is feeding correctly.

### D. Machine plugged in, no power

1. Turn machine on.
2. Make sure top cover is installed properly.
3. Reset the breaker by pressing the black button (fig. 7) near the power cord inlet.
4. Check wall outlet.
5. Remove operator cover check the fuse located on control board next to transformer.
6. Check all electrical connections.

### F. Double feeding / Mis-feeding

1. Clean feed wheel (soap and water)
  - a. Check center in-feed roller and singulator pad for wear. Replace the pad if it is cupped.
  - b. Check to see if center in-feed roller is centered on the gate tip.
2. Run a stack of plain paper, to check on proper feeding. If double feeding does not occur on the paper:
  - a. Check to be sure pressure seal forms are not sticking together. Jogging or hand separating may be necessary to determine this.
  - b. Hand separate about 50 forms, align and test run the forms. If no double feeding occurs proper forms handling is necessary.
3. If double feeding continues to occur, the next step is to check the gate tip pressure.
4. With the in-feed tray pushed down and free of forms, spin the center in-feed roller. You are looking for a minimal drag.
5. Make sure singulator mount is sitting straight on bracket. If crooked, loosen the two screws and adjust until straight.

6. To evaluate operation of the singulator/gate tip assembly:

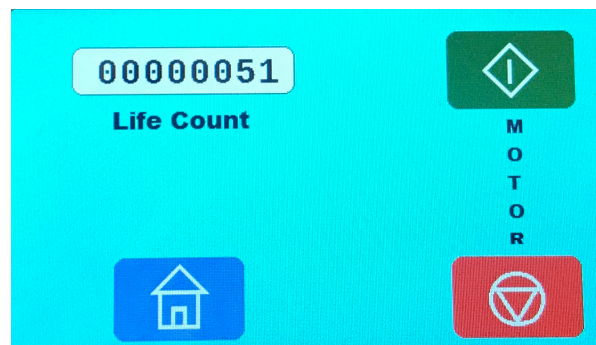
- a. Turn off machine and unplug.
- b. Remove lower fold plate.
- c. Reach hand up underneath paper feed tray. You will feel the gate tip adjusting screw; back off the screw about 3 turns.
- d. Press down on the gate tip and remove your finger. The gate tip should go down and spring up again. If it doesn't work smoothly, determine where it's binding and correct the problem.

**NOTE:** Increase the spring tension on the singulator assembly by moving the springs up one more notch.

7. After you have determined that the singulator assembly is operating smoothly, readjust the gate tip adjusting screw. Back off pressure on the gate-tip until it moves freely up and down. With paper in-feed tray in lowered position, turn screw to tighten until the gate-tip no longer moves up and down.
8. Reinstall the lower fold plate. Place a stack of unprinted forms on the feed tray and test run. You are looking for consistent feeding with no hesitation and no double feeding.
9. If needed, fine tune adjustments can be made by turning the gate tip adjusting screw in small increments until you get the desired results.

## **SERVICE MODE**

The service mode can be entered to test the motor operation and view the life count. To enter the service mode press and hold the center of the screen ("M" in FORMAX) for 10 seconds. When in service mode press the green start icon to start the motor and the red stop icon to stop the motor. To exit the service mode press the blue home icon.



Service mode screen

## ADJUSTING ROLLER CLEARANCE

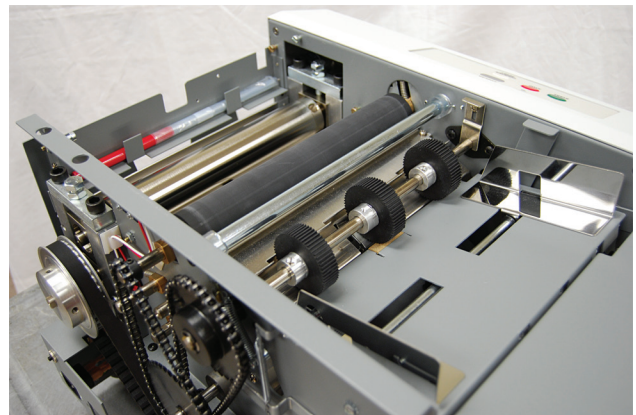
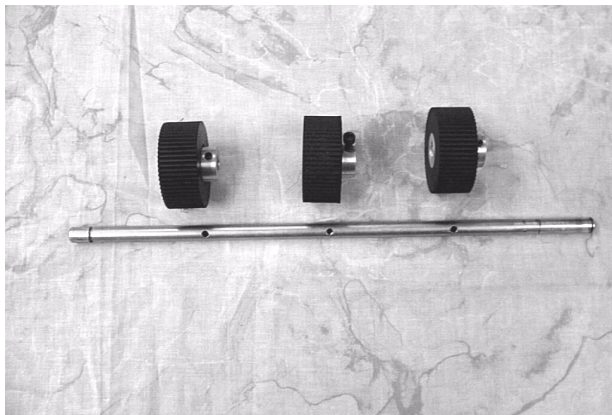


Figure 6

1. Turn power off and unplug power cord.
2. Loosen locking nuts on the top plates (fig. 6).
3. Insert a feeler gauge (0.001") into space between the rollers.
4. Turn adjusting bolts while checking clearance with the feeler gauge.
5. Tighten the locking nuts in place after proper clearance has been set.

**NOTE:** Double-check spacing with feeler gauge. Left to right fine-tuning is required.

## REPLACING IN-FEED ROLLERS



1. Turn power off and unplug the power cord.
2. Remove top cover and non-operator cover.
3. Loosen lock bolt inside top cover.
4. Pull up clamp.
5. Remove retaining ring on gear (see folder roller, page 13).
6. Remove gear and chain (see folder roller, page 13).
7. Loosen individual rollers (one screw each).
8. Pull roller bar through each roller in the direction of the removed gear.
9. To reassemble repeat above steps in reverse.



## TO REPLACE SINGULATOR PAD

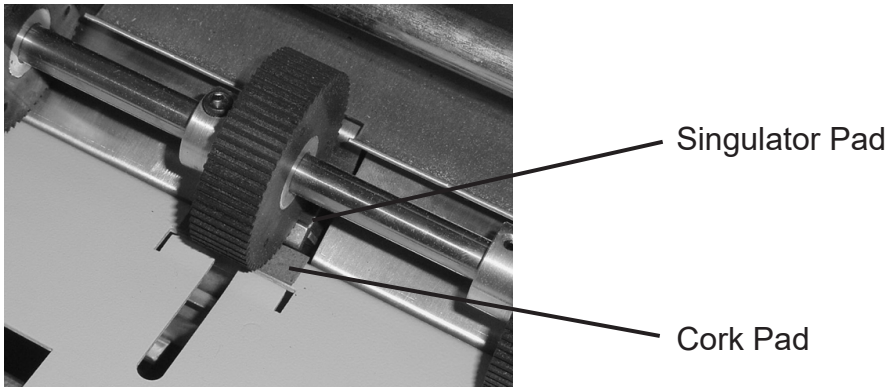
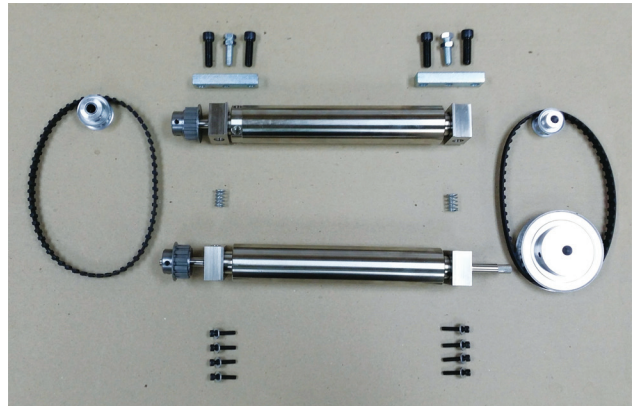
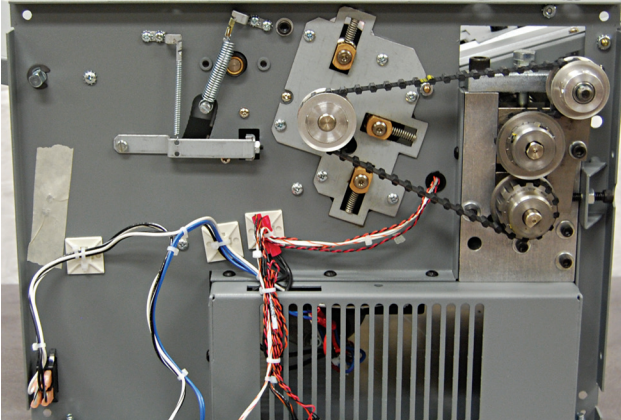


Figure 7

1. Remove in-feed rollers (see page 5).
2. Remove rubber singulator pad (fig. 7). A screwdriver or knife may be need to pry the pad off.
3. Clean singulator mount.
4. Apply super glue to singulator pad and singulator mount.
5. Apply singulator pad to singulator mount, let sit for at least five minutes before reinstalling in-feed rollers.
6. Reinstall in-feed rollers (see page 5).

## TO REPLACE SEALER ROLLERS

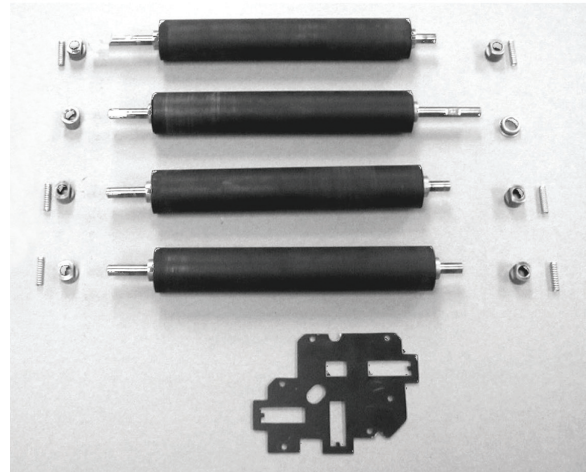
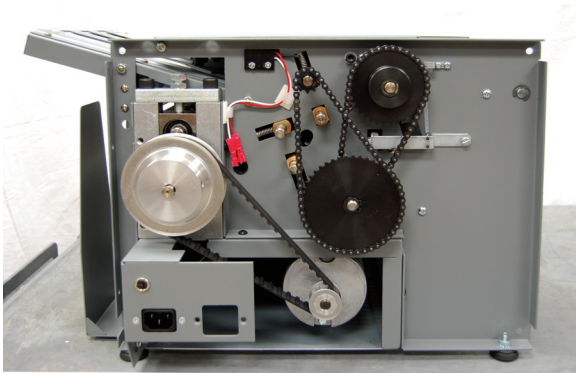


1. Turn power off and unplug power cord.
2. Remove covers and upper fold plate.
3. Remove belts (see belt replacement page 7).
4. Remove top plates by unscrewing four screws.
5. Loosen or remove the five lower screws on each side.
6. Remove first roller by lifting up and out of machine.
7. Remove the two springs.
8. To remove second roller tilt stainless steel center plate away from roller.
9. Remove second roller the same way as the first roller.
10. To reassemble repeat above steps in reverse.
11. Adjust belt tension (see belt replacement page 7).

## TO REPLACE CORK PAD

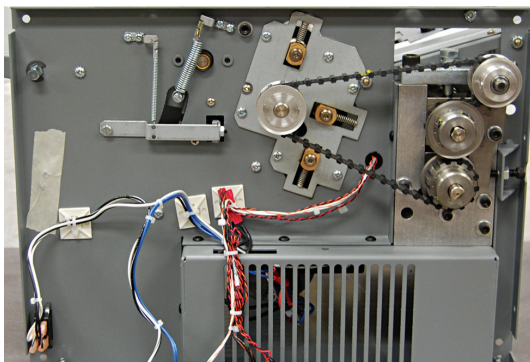
1. Lower in-feed tray.
2. Remove old cork pad (fig. 7). A screwdriver or knife may be needed to pry the pad off.
3. Clean area of removed pad.
4. Apply super glue to cork pad and in-feed tray.
5. Apply cork pad to in-feed table. Let sit for at least five minutes before operating the machine.

## TO REPLACE FOLDER ROLLERS



1. Turn power off and unplug power cord.
2. Remove covers and remove upper fold plate.
3. Remove control panel.
4. Remove belt (see belt replacement, below).
5. Remove sprocket and chain.
6. Remove bearing springs on both ends of rollers bearing plate (operator side).
7. Pull out rollers.
8. To reassemble, repeat above steps in reverse.

## BELT ADJUSTMENT AND REPLACEMENT



**NOTE:** Roller clearance must be set before adjusting belt tension.

1. Loosen pivot screw on idler lever.
2. Turn adjusting screw until belt is loose enough to remove.
3. Install new belt.
4. Turn adjusting screw until belt has 5/16" play, tighten pivot screw.

**NOTE:** Be sure not to over tighten belt, it will affect roller clearance

# PHOTO EYE REPLACEMENT

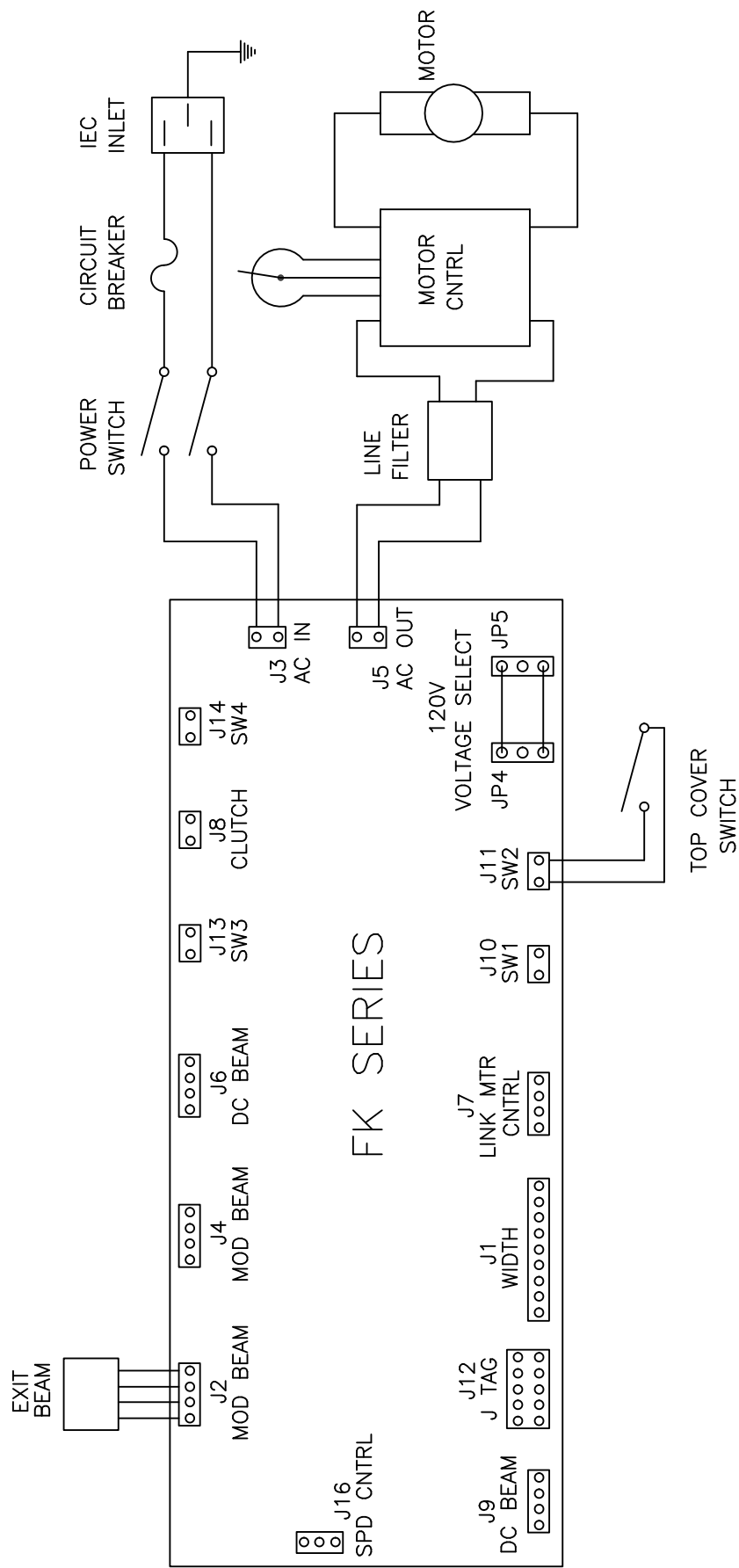


Figure 8

A single photo eye (fig. 8), located just before the pressure rollers, is used for counting, last form time out and fault/double feed detection.

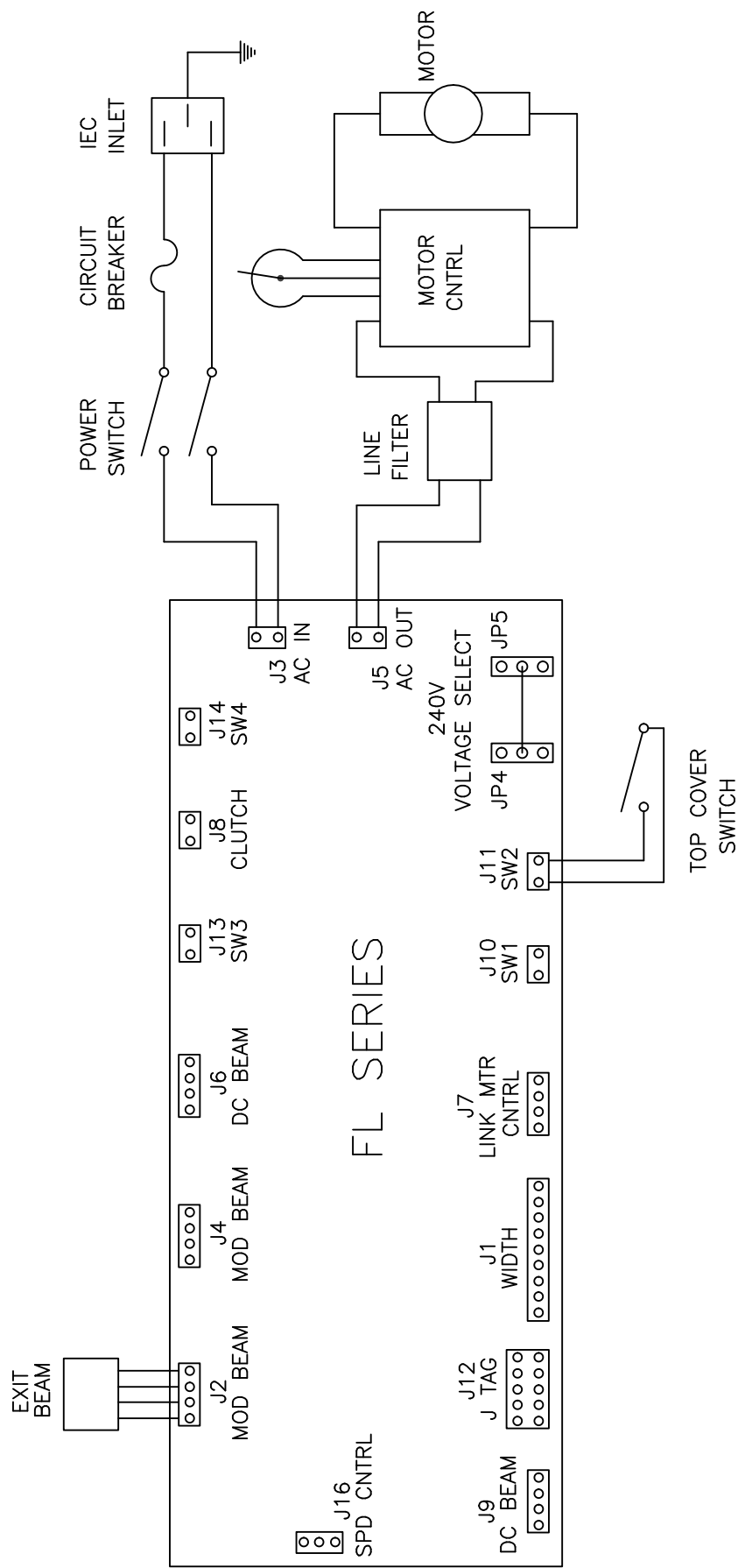
1. Loosen the screw on the guide plate.
2. Carefully remove the screw and the photo eye.
3. Unplug the wires and discard old photo eye.
4. Reverse the previous step to install the new photo eye.
5. Adjust the photo eye to 1/8" below the guide plate.
6. Tighten the screw to ensure the photo eye does not move.

FD 1406/1506 120V ELECTRICAL SCHEMATIC

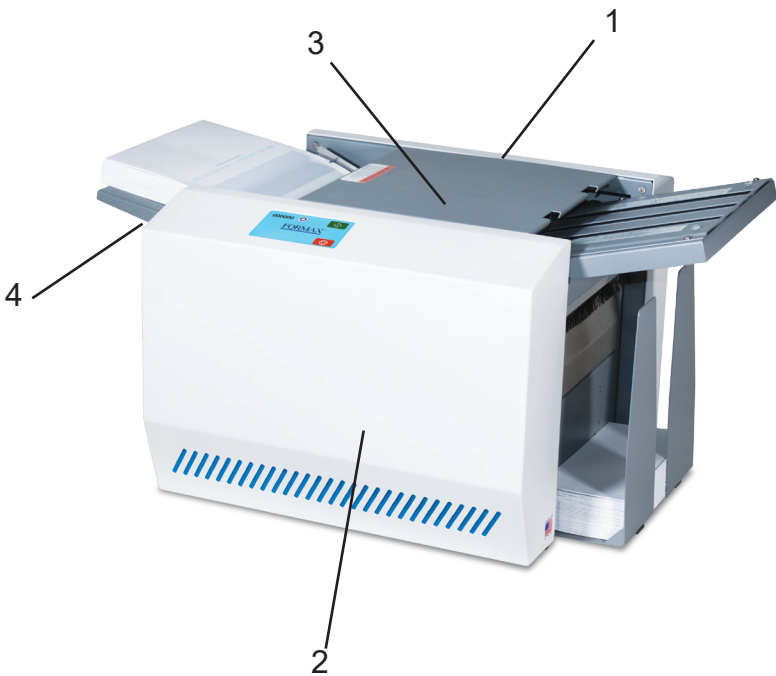




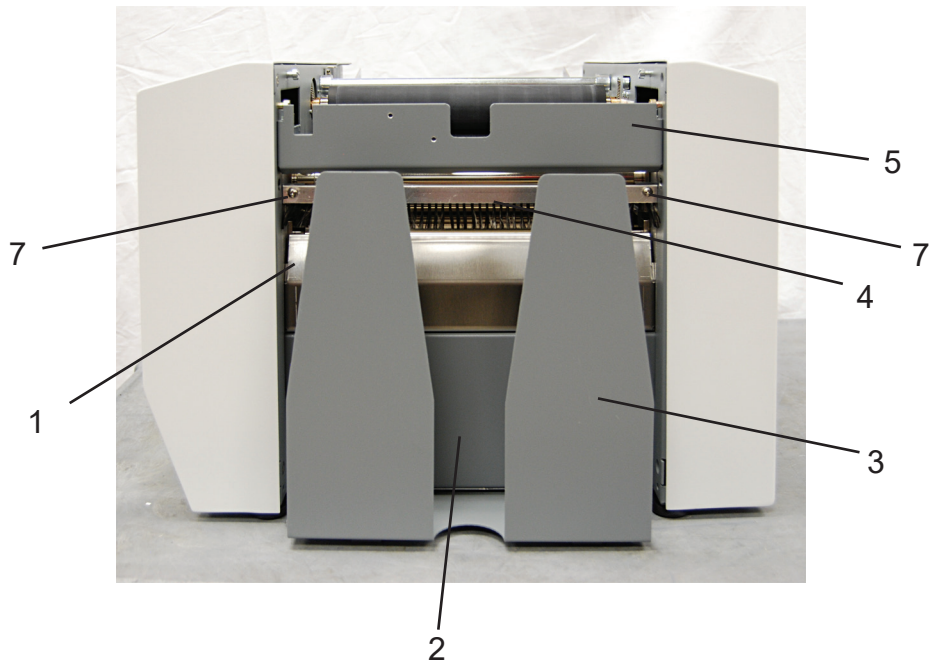
FE 1406/1506 220V ELECTRICAL SCHEMATIC



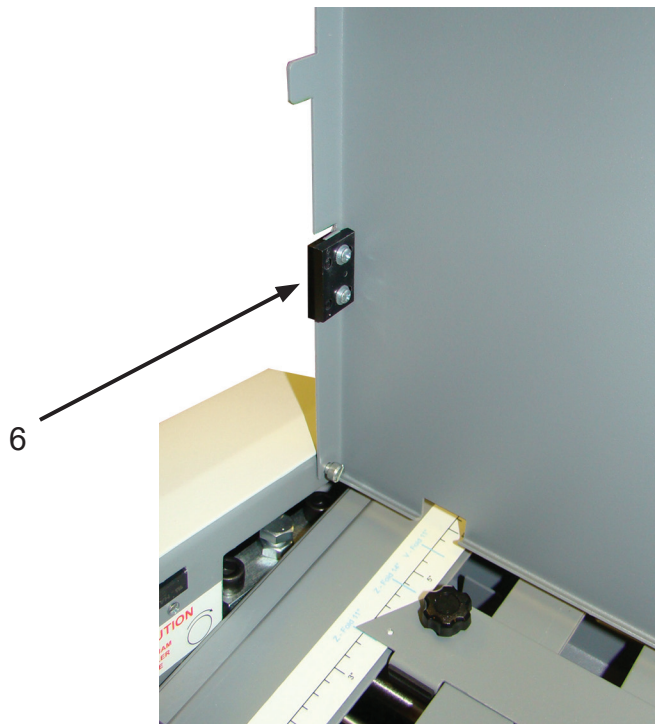
# PARTS LIST

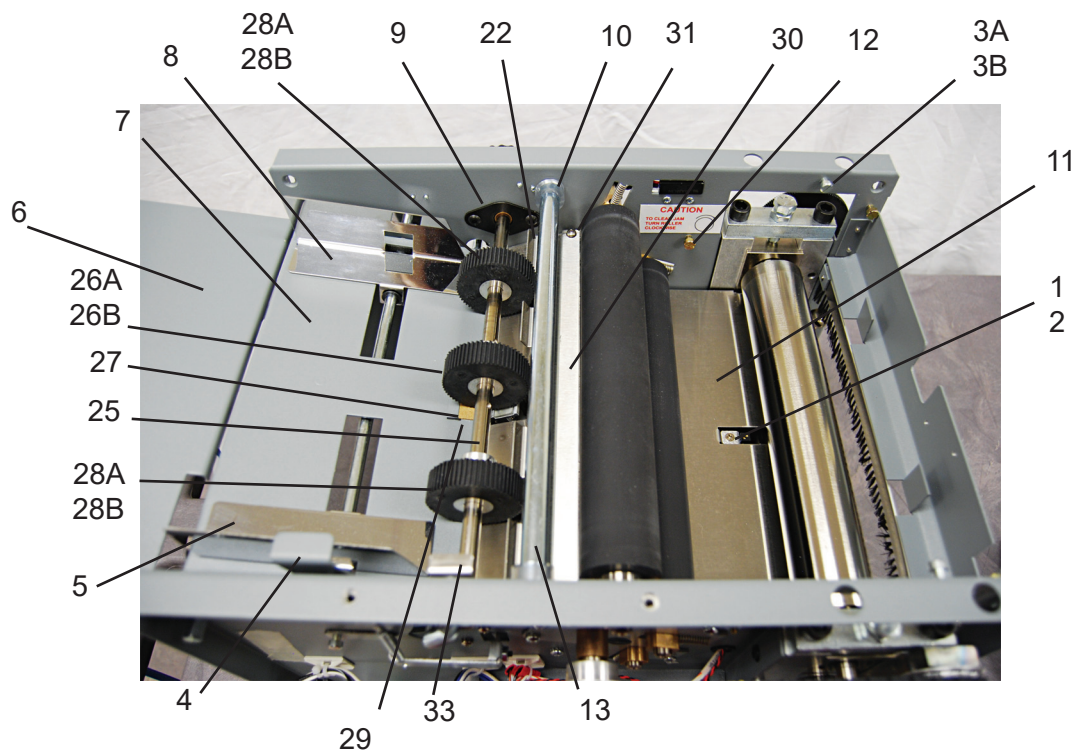


ITEM	PART	DESCRIPTION	QTY.
1	360-2950	NON-OPERATOR COVER	1
2	360-3084	OPERATOR COVER	1
3	360-3110	TOP COVER	1
4	360-2931	PAPER TRAY EXTENSION	1



ITEM	PART#	DESCRIPTION	QTY.
1	360-1686	CROSS-MEMBER, REAR	1
2	360-1388	BASE	1
3	395-0873	CATCH TRAY ASSEMBLY	1
4	316-0011	STATIC BRUSH	1
5	360-2801	ROLLER GUARD	1
6	319-0159	MAGNET, ACTUATOR	1
7	373-5869	STATIC BRUSH MOUNTING SCREWS	2

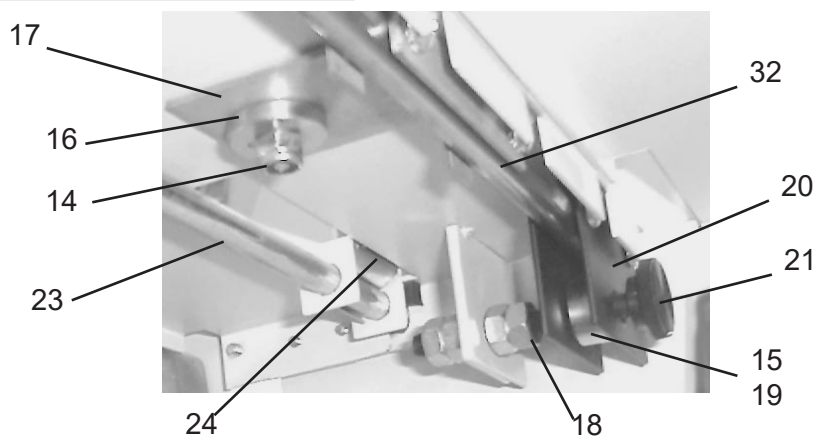




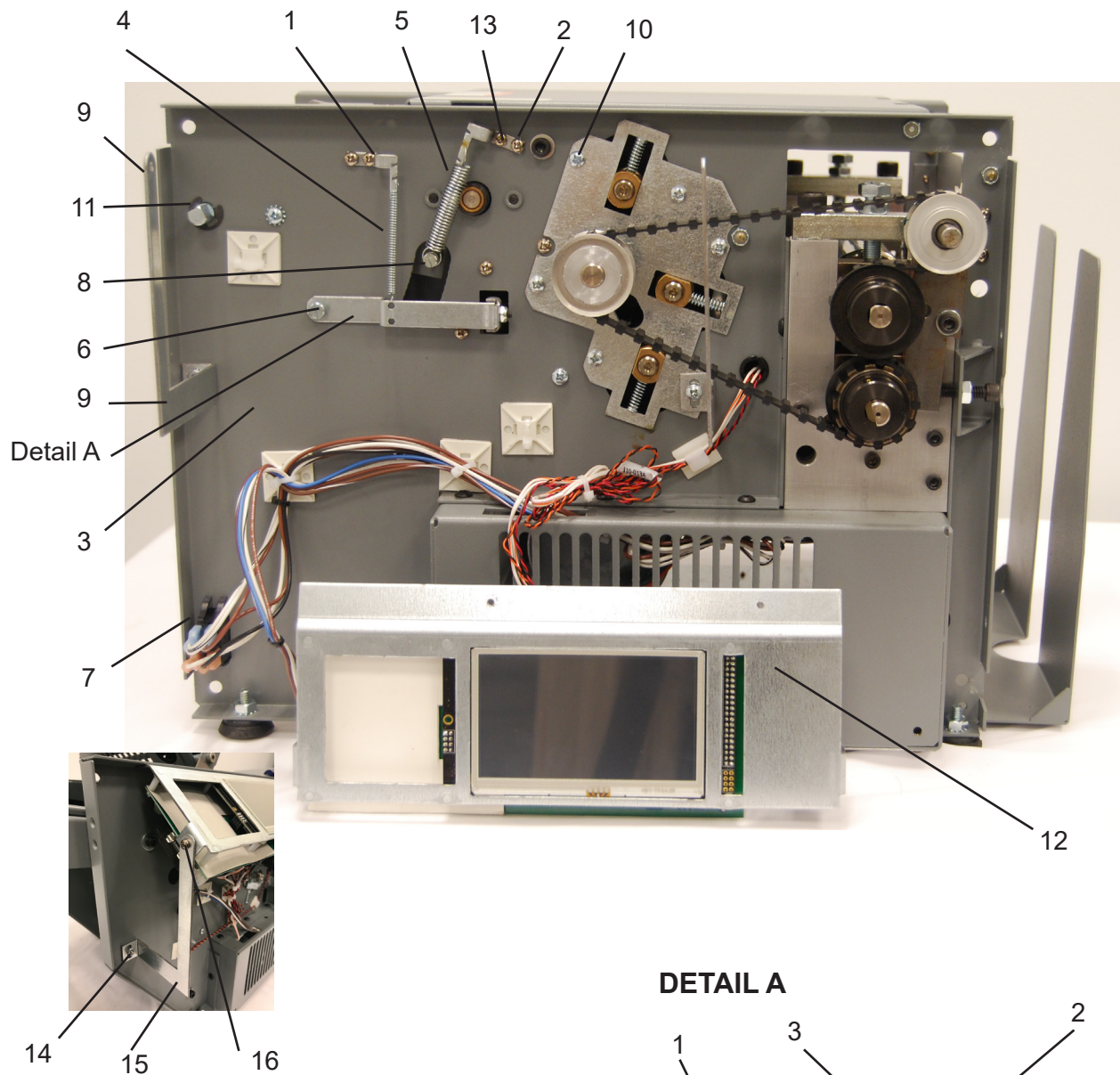
ITEM	PART #	DESCRIPTION	QTY.
1	310-0134	PHOTO SENSOR HARNESS	1
2	360-1700	SENSOR BRACKET	1
3A	375-0044	SHOULDER SCREW	4
3B	378-0115	SHOULDER SCREW NUT	4
4	360-2930	TRAY PUSH DOWN	1
5	395-0884	PAPER GUIDE OP SIDE ASSY	1
6	360-3110	PAPER TRAY EXTENSION *	1
7	395-1386	PAPER TRAY ASSY WITH CORK	1
8	395-0885	PAPER GUIDE DRIVE SIDE ASSY	1
9	371-0076	BUSHING SELF ALIGN	2
10	385-0060	VINYL BUSHING	2
11	360-1687	CROSS-MEMBER, FRONT	1
12	375-0144	YELLOW ZINC SHOULDER SCREW	4
13	332-0121	BRACE SHAFT	1
14	378-0115	NUT SELF LOCK 8-32	1
15	377-0057	CURVED WASHER	2
16	334-0359	SKEW PIVOT	1
17	360-1728	PIVOT BRKT.	1
18	378-0119	NUT 1/4 - 28	4

ITEM	PART #	DESCRIPTION	QTY.
19	330-0090	COLLAR .250	1
20	360-2928	SKEW PIVOT BRKT.	1
21	395-0886	SKEW ADJ THUMBSCREW	1
22	395-0881	FEEDER PAPER RAMP ASSY	1
23	395-1022	PAPER TRAY SHAFT	1
24	330-0087	SPRING PAPER GUIDE	2
25	331-0145	ROLLER ROD, FEED	1
26A	350-0081	GREY CENTER HARD-COMPOUND FEED WHEEL	1
26B	375-0107	CENTER FEED TIRE SCREW	1
27	352-0009	CORK PAD	1
28A	350-0099	BLACK SOFT-COMPOUND FEED WHEEL	2
28B	376-2805	FEED TIRE SET SCREW 8 - 32	2
29	373-5893	SCREW PPH 6-32 x 3/8	1
30	360-1685	PAPER RAMP GUIDE	1
31	375-5987	SCREWS FOR PAPER RAMP GUIDE	2
32	332-0131	SKEW ADJUSTMENT SHAFT	1
33	360-1846	FEED SHAFT LOCKING BRACKET	1

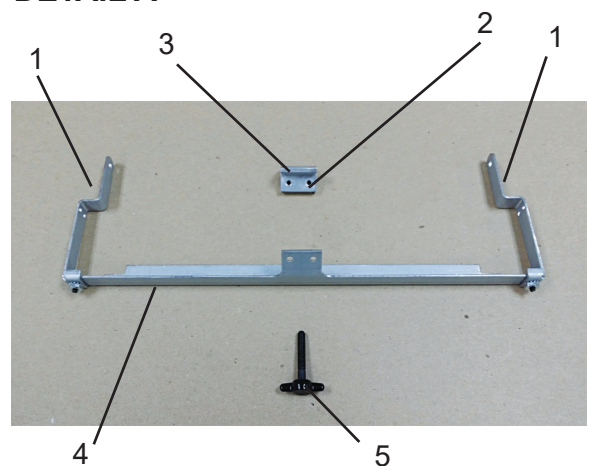
\* ITEM 6 - PAPER TRAY EXTENSION: S/N B182115 and up, part # is 360-3110





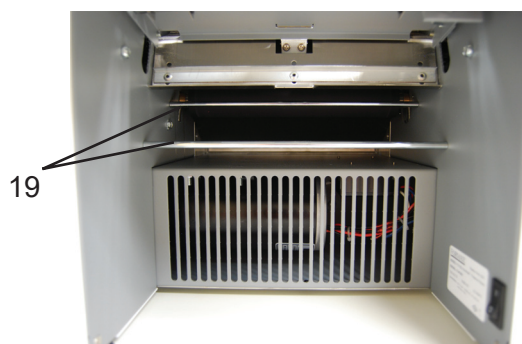
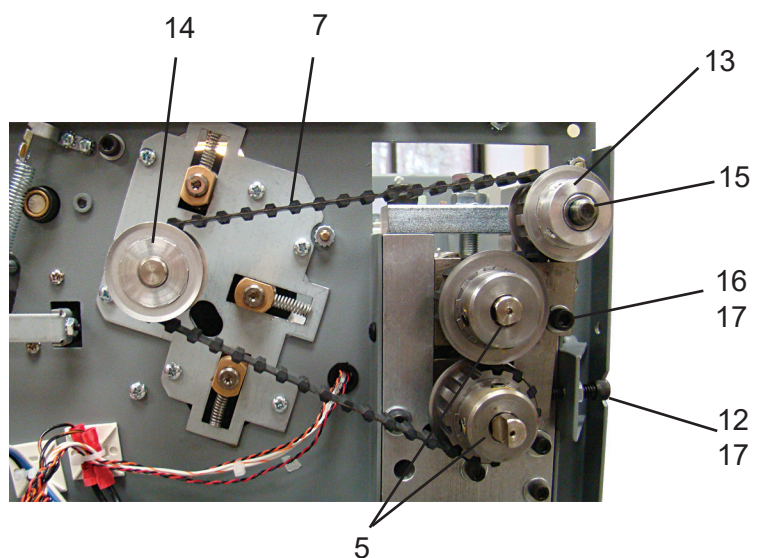
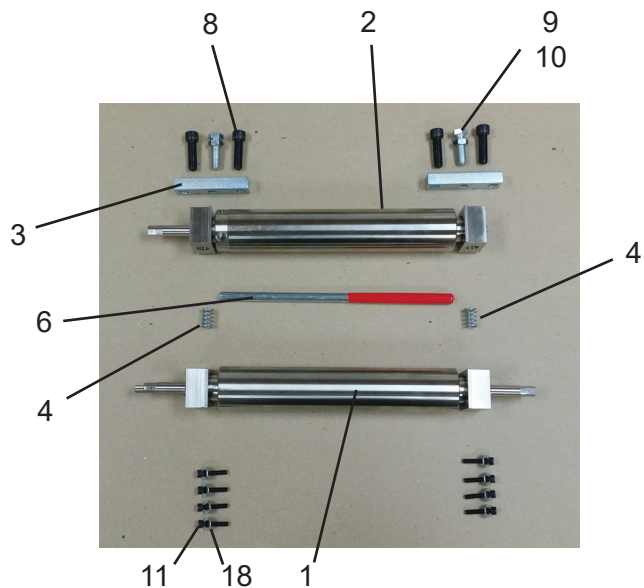


#### DETAIL A

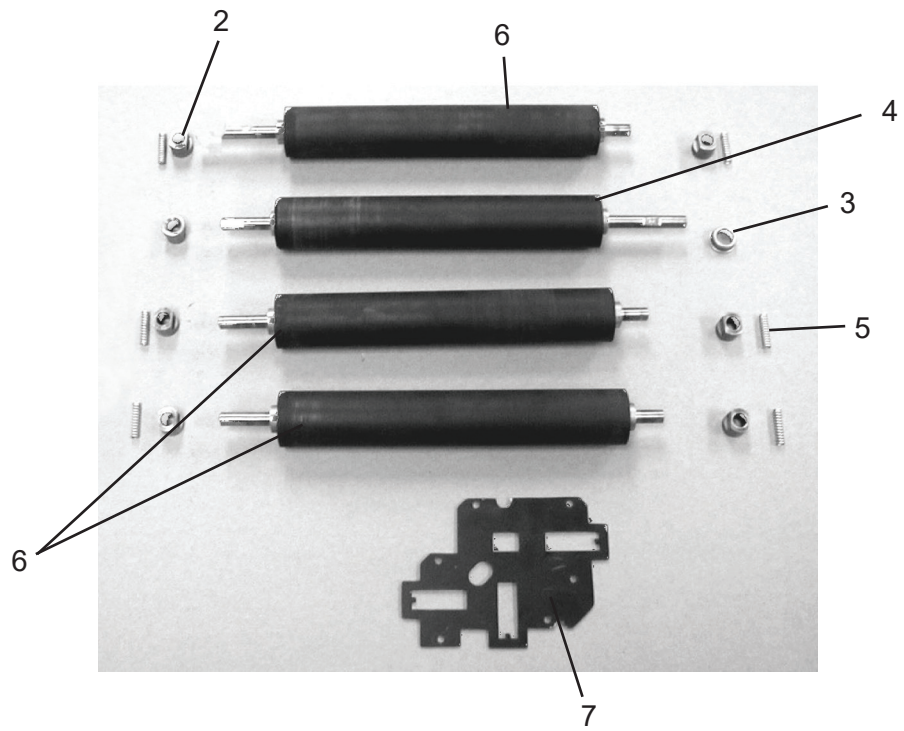


ITEM	PART #	DESCRIPTION	QTY.
1	360-1659	SPRING BRACKET - DR SIDE	1
2	360-1645	SPRING BRACKET - OP SIDE	1
3	360-2932	FRAME OP SIDE	1
4	342-0077	EXTENSION SPRING, 188 O.D.	2
5	342-0078	EXTENSION SPRING, 375 O.D.	2
6	375-0044	SHOULDER SCREW #8-32	2
7	311-0087	ROCKER SW D.P.S.T. (non-illuminated)	1
8	330-0084	OPX SHOULDER SCREW	1
9	360-3092	CONTROL PANEL BRACKET	2
10	375-0004	SOC. HD. CAP SCREW	1
11		E-RING	
12	395-1369	CONTROL PANEL ASSY. 120 V	1
12	395-1370	CONTROL PANEL ASSY. 240 V	1
13	375-5699	SCREW 10-32 x 1/4 BUTTON HD CA	4
14	378-9500	6-32 NUT W/STAR WASHER	1
15	360-3091	PCB BRACKET BRACE	2
16	373-5869	6-32X1/4" PPH SCREW W/ INT STAR	2

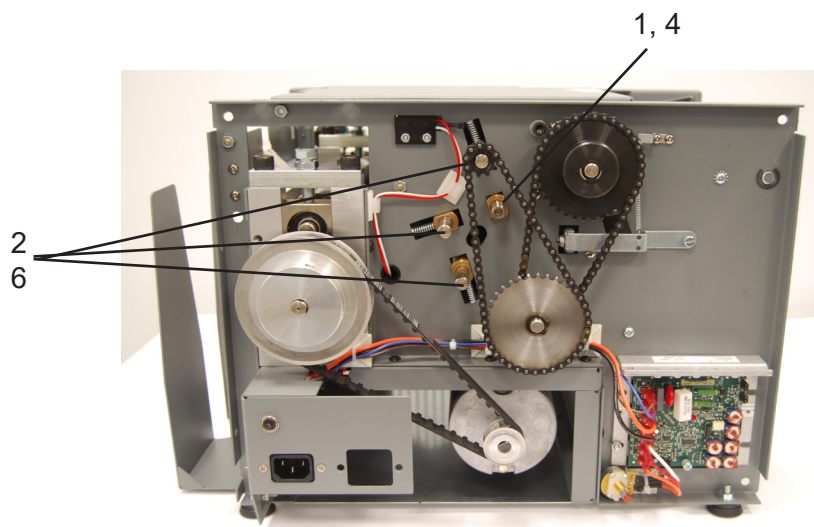
DETAIL A			
ITEM	PART #	DESCRIPTION	QTY.
1	360-1649	SINGULATOR ARM	2
2	352-0008	SINGULATOR PAD	1
3	334-0358	SINGULATOR MOUNT	1
4	360-1648	SINGULATOR BRACKET	1
5	395-0892	T KNOB	1
-	378-0127	FEED RAMP NUT FOR T KNOB	1



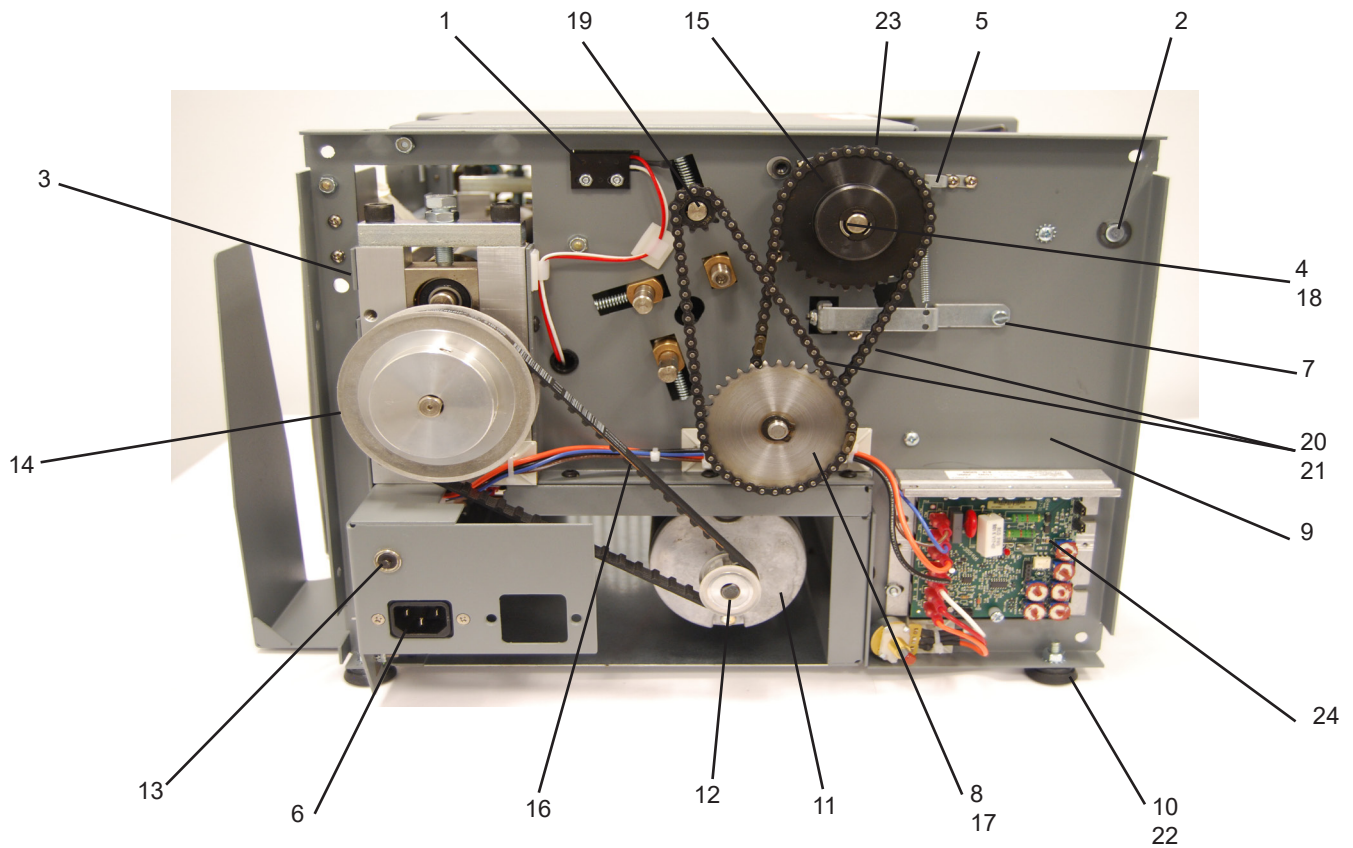
ITEM	PART #	DESCRIPTION	QTY.
1	395-0761	DRIVE ROLLER ASSY.	1
2	395-0878	ROLLER, UPPER ASSY.	1
3	334-0357	BRACKET SIDE, FRAME CAP.	2
4	342-0063	SPRING, BEARING BLOCK	2
5	365-0145	PULLEY, 13T .38 PITCH	2 PER
6	332-0141	JAM CLEARING TOOL	1
7	365-0146	TIMING BELT DOUBLE SIDED	1
8	375-0102	BOLT 3/8X1 1/4" SOC. HD. SC	4
9	375-0152	3/8" X 1 1/4" HEX HD.	2
10	378-0142	3/8"-40 HEX JAM NUT	2
11	374-0096	#10-32 X 1.00, SOC HD CAP	8
12	378-6549	1/4-20 KEP. NUT	1
13	395-1138	9T IDLER ASSY	1
14	365-0200	IDLER PULLEY, 11T.38 PITCH ASSY.	1
15	334-0371	BRACKET, IDLER ADJUST	1
16	377-2611	1/4 LOCK WASHER	1
17	374-5832	1/4-20 x 1 SOC.HD	2
18	377-5298	WASHER	8
19	332-0120	LOWER FOLD PLATE SUPPORTS	2
-	375-0088	SCREWS FOR LOWER FOLD PLATE SUPPORTS	4



ITEM	PART #	DESCRIPTION	QTY.
1	379-1073	3/8" RET. RING	4
2	371-0084	BUSHING FOLDER ROLLER	7
3	371-0090	FLANGE BUSHING	1
4	350-0093	DRIVE ROLLER	1
5	342-0081	COMP. SPRING	6
6	350-0092	FOLDER ROLLER	3
7	360-1843	BEARING PLATE	1



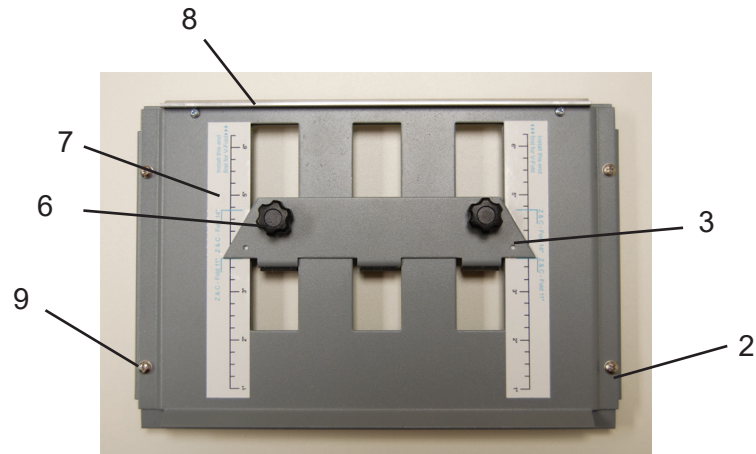




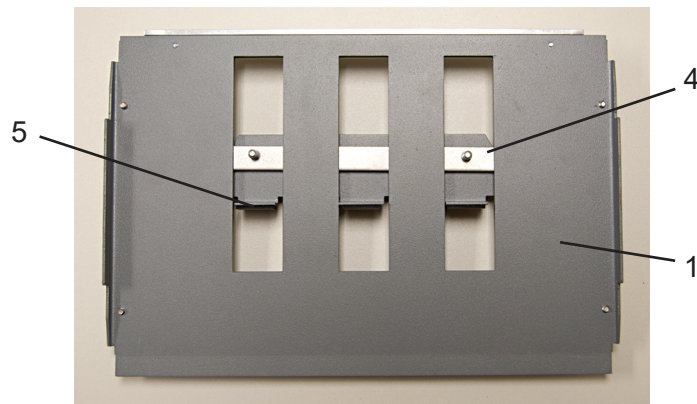
ITEM	PART #	DESCRIPTION	QTY.
1	319-0213	PROXIMITY SENSOR	1
2	379-0014	"E" CLIP	2
3	334-0356	SIDE PLATE	2
4	379-0008	RETAINING RING	1
5	360-1645	SPRING BRKT.	1
6	319-0096	IEC POWER RECEPTACLE	1
7	375-0044	SHOULDER SCREW 8-32	2
8	379-2839	RETAINING RING	2
9	360-2305	FRAME, DRIVE SIDE	1
10	372-6544	NON-SWIVEL GLIDE	4
11	313-8835	MOTOR	1
12	365-0163	PULLEY 9L050	1
13	317-0051	CIRCUIT BREAKER 2.5A (120/200 V)	1
14	365-0178	PULLEY 28L050	1
15	360-1659	SPRING BRKT.	1
16	365-0180	GEAR BELT 210 LO50	1
17	395-0879	COMBO SPROCKET	1
18	395-0877	35 T. SPROCKET ASSY.	1
19	367-4073	10 T. SPROCKET	1
20	367-0029	CHAIN ¼ PITCH	2
21	367-1092	MASTER LINK	2
22	378-6549	¼-20 KEP NUT	4
23	371-0082	BRASS SPACER, OILITE 3/8 X 7/16 X 5/8	1
-	319-0159	COVER MAGNET	1
24	395-1377	MOTOR CONTROL BOARD 120 V	1
24	395-1378	MOTOR CONTROL BOARD 240 V	1



## LOWER FOLD PLATE - FD 1406 / FD 1506



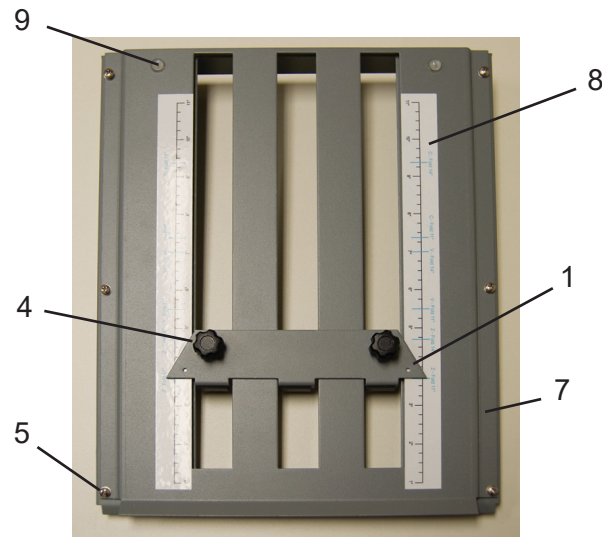
**LOWER FOLD PLATE**  
**Top View**



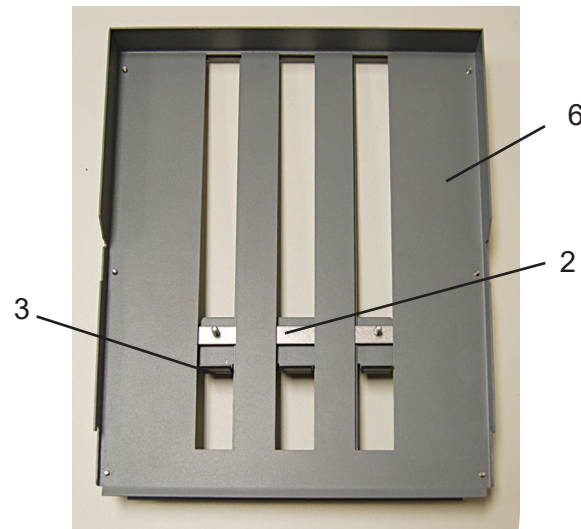
**LOWER FOLD PLATE**  
**Underside**

ITEM	PART	DESCRIPTION	QTY.
*	395-1313	LOWER FOLD PLATE ASSY.	1
1	360-2941	LOWER/LOWER FOLD PLATE	1
2	360-2942	LOWER/UPPER FOLD PLATE	1
3	360-2943	UPPER ADJUST PLATE	1
4	360-2946	LOWER ADJUST PLATE	1
5	352-0016	FOLD PLATE BUMPER	3
6	372-0124	CLAMPING KNOB	2
7	325-0400	LOWER FOLD PLATE DECAL	2
-	325-0550	LOWER FOLD PLATE DECAL (FE models only)	1
8	360-1641	FOLD DIVERTER	1
9	373-5869	SCREW PPH 6-32x3/8	3

## UPPER FOLD PLATE - FD 1406



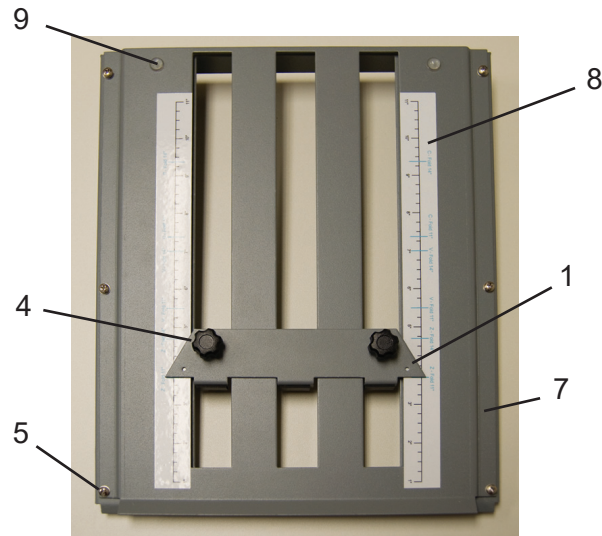
**Top View**



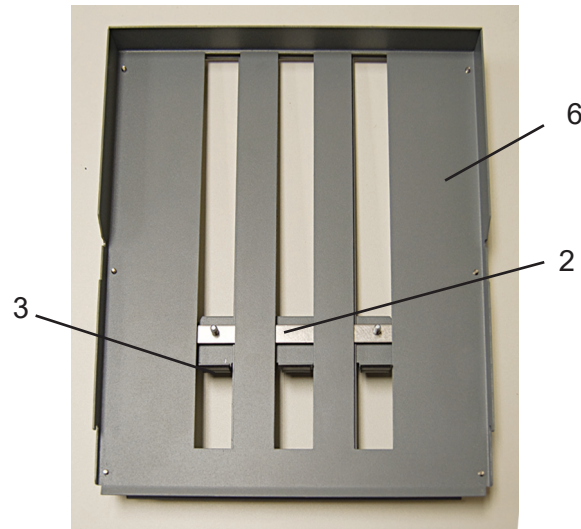
**Underside**

ITEM	PART	DESCRIPTION	QTY.
*	395-1311	UPPER FOLD PLATE ASSY. 1406	1
1	360-2943	UPPER ADJUST PLATE	1
2	360-2446	LOWER ADJUST PLATE	1
3	352-0016	FOLD PLATE BUMPER	3
4	372-0124	CLAMPING KNOB	2
5	373-5869	SCREW PPH 6-32x1/4	8
6	360-2944	UPPER/LOWER FOLD PLATE 12" 1406	1
7	360-2945	UPPER/UPPER FOLD PLATE 12" 1406	1
8	325-0459	UPPER FOLD PLATE DECAL 1406	2
-	325-0549	UPPER FOLD PLATE DECAL (FE models only)	2
9	352-0017	SELF-ADHESIVE BUMPER	2

## UPPER FOLD PLATE - FD 1506



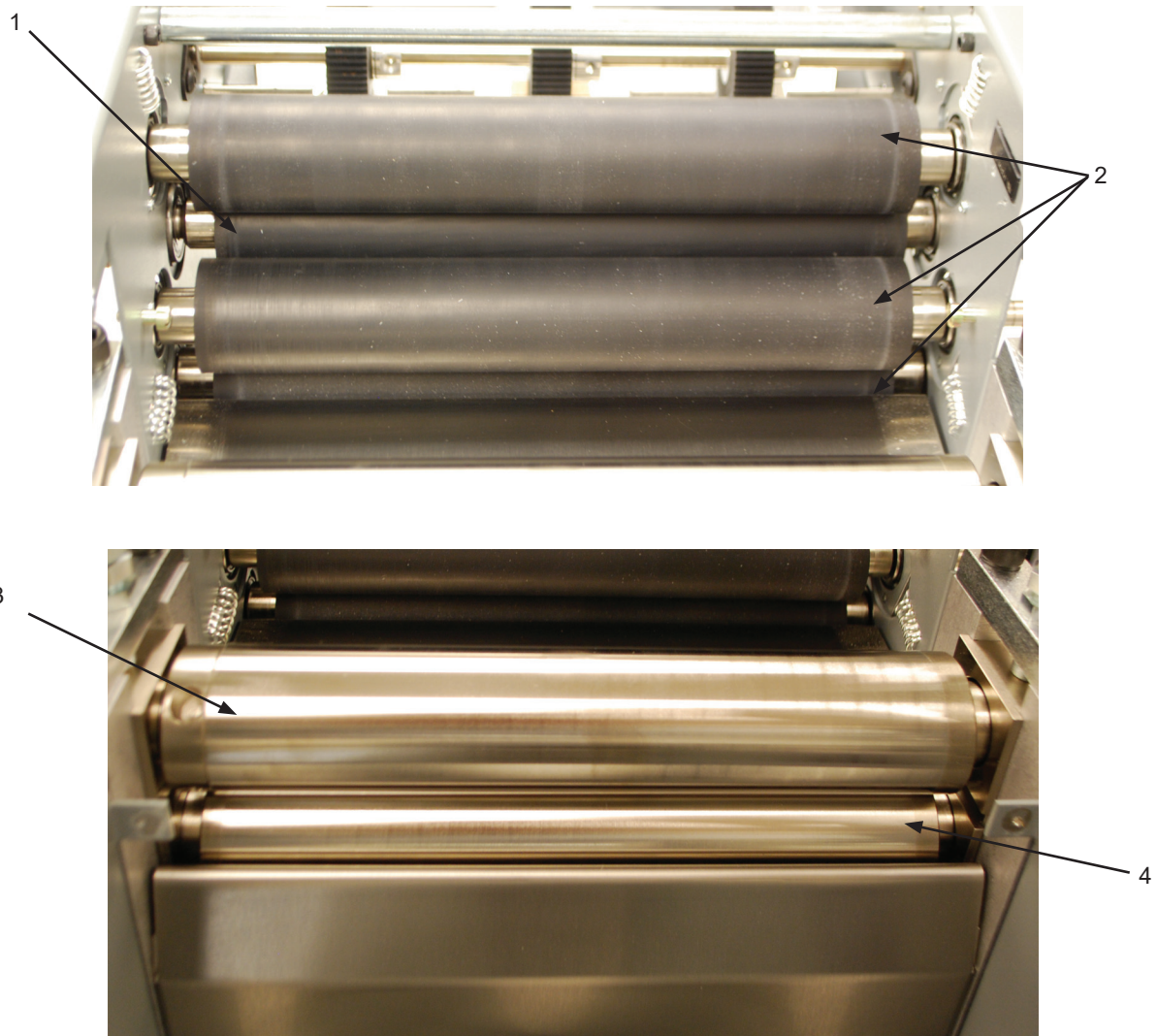
**Top View**



**Underside**

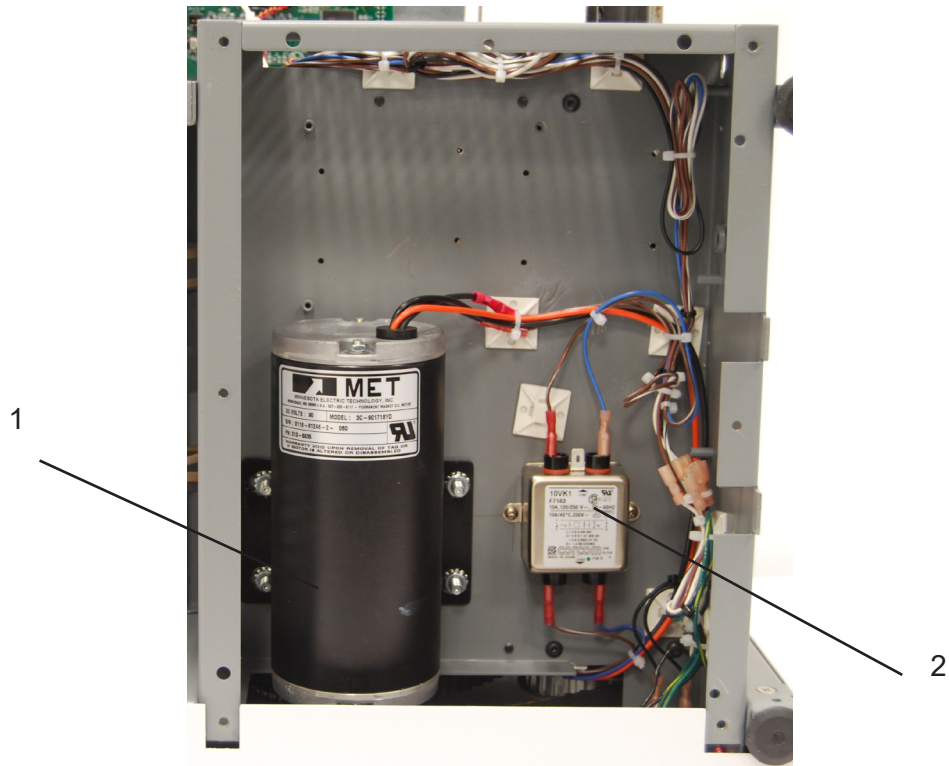
ITEM	PART	DESCRIPTION	QTY.
*	395-1312	UPPER FOLD PLATE ASSY. 1506	1
1	360-2943	UPPER ADJUST PLATE	1
2	360-2446	LOWER ADJUST PLATE	1
3	352-0016	FOLD PLATE BUMPER	3
4	372-0098	CLAMPING KNOB	2
5	373-5869	SCREW PPH 6-32x1/4	8
6	360-2947	UPPER/LOWER FOLD PLATE 1506	1
7	360-2953	UPPER/UPPER FOLD PLATE 1506	1
8	325-0459	UPPER FOLD PLATE DECAL 1506	2
-	325-0549	UPPER FOLD PLATE DECAL (FE models only)	2
9	352-0017	SELF-ADHESIVE BUMPER	2

## FOLD & SEAL ROLLERS

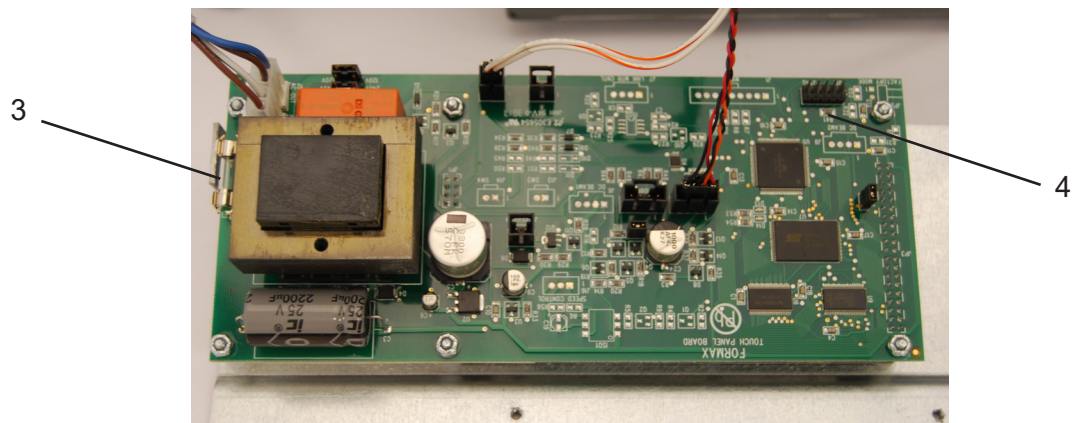


ITEM	PART	DESCRIPTION	QTY.
1	350-0075	DRIVE FOLD ROLLER	1
2	350-0077	FOLD ROLLER	3
3	395-0760	UPPER SEAL ROLLER ASSY	1
4	395-0761	DRIVE SEAL ROLLER ASSY	1
NS	342-0063	SPRING SEAL ROLLER BEARING BLOCK	2





ITEM	PART	DESCRIPTION	QTY.
1	313-8835	1/6 HP MOTOR	1
2	319-0078	LINE FILTER	1



ITEM	PART	DESCRIPTION	QTY.
3	317-0040	5 x 20 FAST BLOW FUSE	1
4	395-1369	TOUCHSCREEN ASSY. 120 V	1
4	395-1370	TOUCHSCREEN ASSY. 240 V	1