

4 REPLACEMENT AND ADJUSTMENT

DANGER

- Before opening the control panel cover, turn the main power OFF. Failure to do so can result in electrical shock.

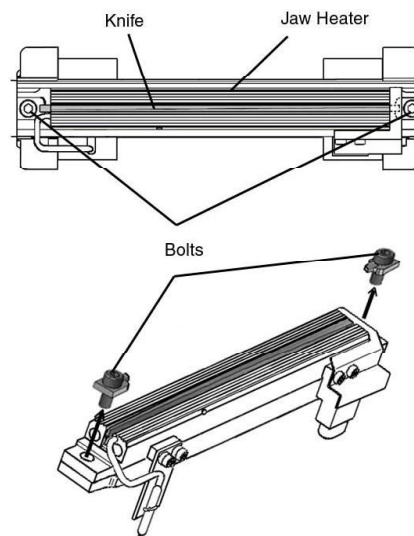
4.1 End Seal Unit

4.1.1 Replacing the Jaw Knife Blade

CAUTION

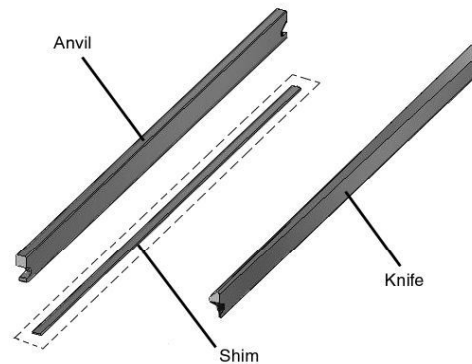
Be careful when removing the knife blade. It is hot.

1. Turn the main power OFF.
2. Open the front cover.
3. Pull the handle forward, and swing the back seal unit out.
4. Remove 2 bolts at both sides, and then the knife fixing hardware.



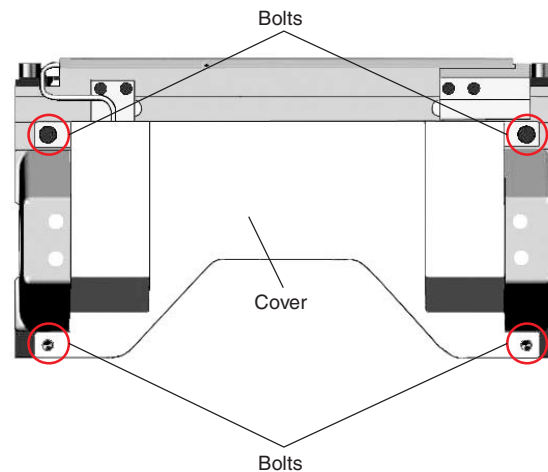
⚠ WARNING

- When the anvil is removed from the rear side, there may be a height adjustment shim on the lower side of the anvil. Be careful not to lose the shim, which has a 0.1 mm thickness.
- In principle, the height adjustment shim is not located under the front side knife blade.

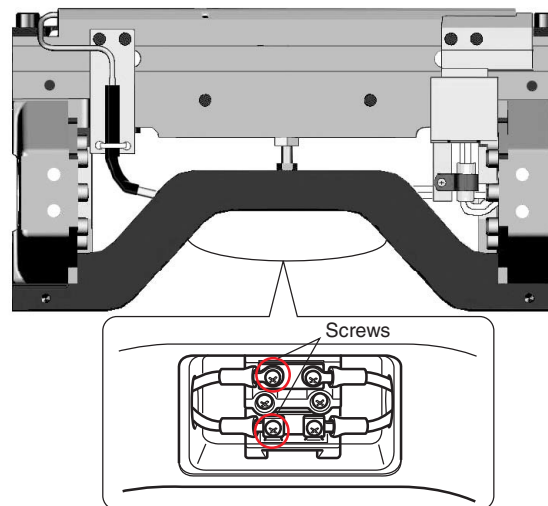


4.1.2 Replacing the Jaw Faces

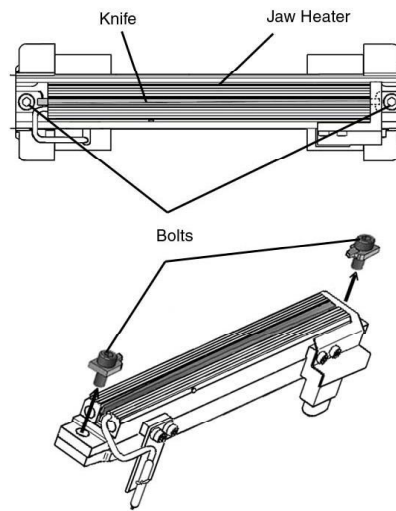
1. Turn the main power OFF.
2. Open the front cover.
3. Pull the handle forward, and swing the back seal unit out.
4. Remove 4 bolts at both sides and then the cover.



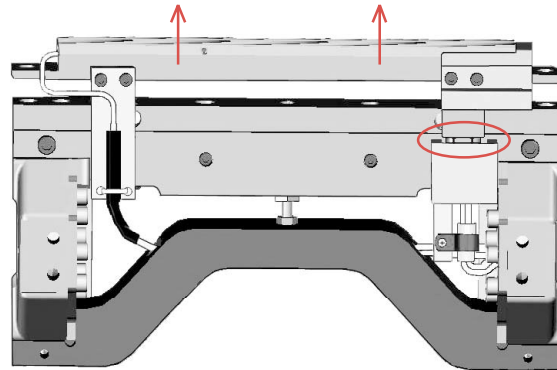
5. Remove 2 screws from the terminal block.



6. Remove 2 bolts at both sides, knife fixing hardware, and then the knife blade.



7. Remove the heart connector and then jaw faces.
8. Mount new jaw faces reversing the removal procedure.



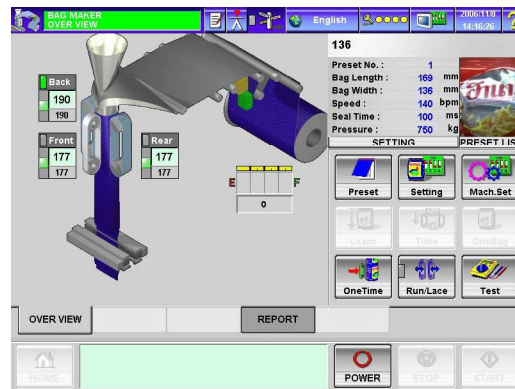
4.1.3 Jaw Alignment

NOTE

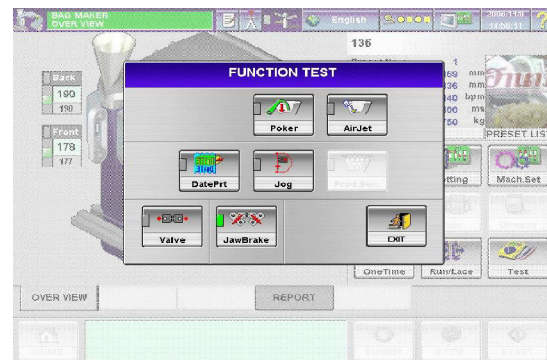
- Before performing jaw alignment, remove the Clumb Collar. Stripper Plate Unit.
- Jaw alignment should be basically performed at the front jaw side.

1. Turn the main power ON.


2. Touch the  key on the main screen.

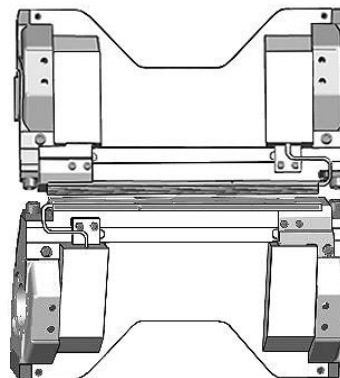


3. Touch the  key on the function test screen.

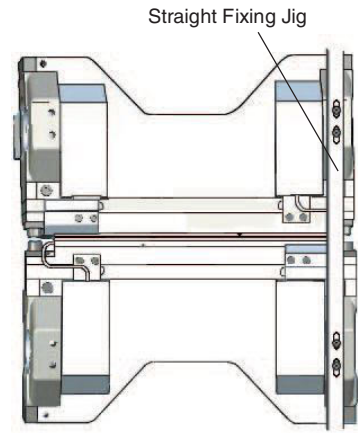


4. The jaw unit starts to rotate slowly. When the jaw unit has become horizontal, touch the

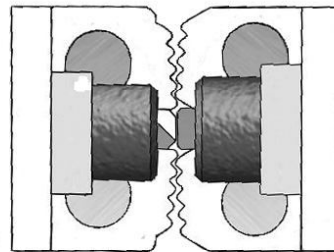
 key to stop the unit.



5. Turn the main power OFF.
6. Open the front cover.
7. Attach a straight fixing jig to keep jaw horizontal.

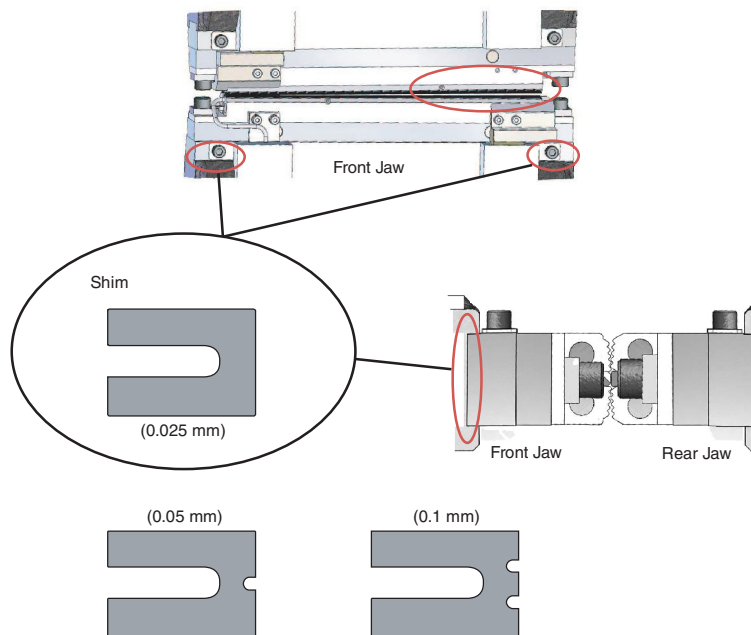


8. The right figure shows the optimum jaw alignment at that time.
If the jaw is misaligned, readjustment is required.



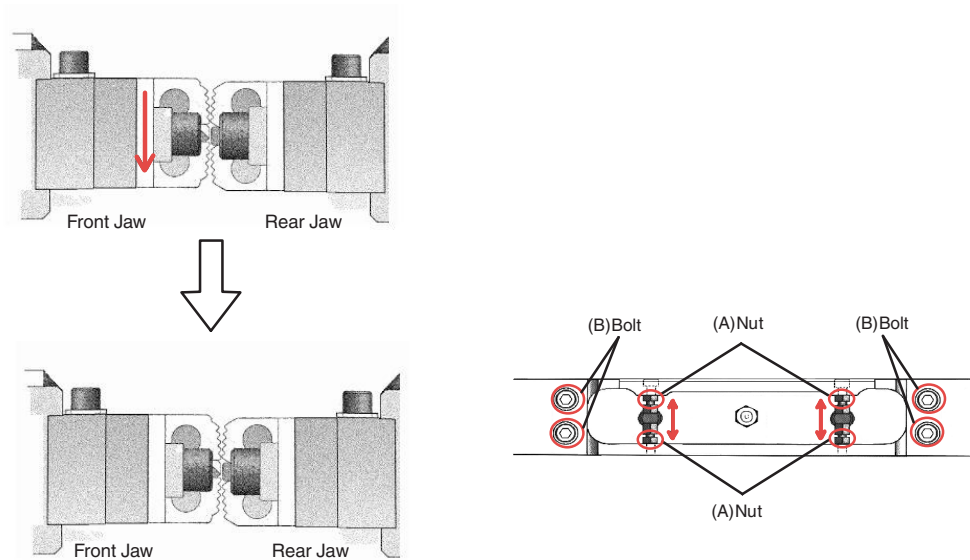
Right or Left adjustment

Right or left adjustment should be performed at the front jaw side.
Insert the shim in the following location for adjustment.



*There are three types of shim thickness: 0.025 mm, 0.05 mm, and 0.1 mm.

Top and Bottom adjustment



- For top and bottom adjustment, use the adjustment screw located on the front jaw.
1. Loosen the bolt B (4pcs) securing the jaw heater.
 2. Loosen the nut A (4pcs) for top and bottom adjustment to adjust the top and bottom of the jaw heater, and then secure the nuts.
 3. Secure the bolt B (4pcs).

NOTE

- When perform jaw alignment, confirm that the jaw alignment on the opposite was performed.
Ex. After adjust the top on a set of jaw, counterturn the jaw unit to confirm and adjust the jaw on the opposite side.