



11.0 Option Parts & Illustrations

INTRODUCTION

This section lists and illustrates the replaceable assemblies and parts of the Tray Box Former as manufactured by W. E. Plemons Machinery Services, Inc. Each parts list contains the component parts for that assembly.

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FIGURE 11-6

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PLATE MOUNTING
AUTO LIDDER

FIGURE 11-7

VACUUM PUMP ASSEMBLY
AUTO LIDDER

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11.2 PRELIMINARY ADJUSTMENTS

LIDDER CUP ARM ADJUSTMENT

RUN MANDREL IN UNTIL THE FRONT OF MANDREL IS 1" AWAY FROM BOX THATS IN COMPRES-
SION. AT THIS POINT, SET THE LIDDER CUP ARM CAM UNTIL THE ARM HAS JUST REACHED IT'S
BOTTOM POSITION (LEVEL WITH THE ANGLE RAILS).

LID HOLD DOWN FINGER CAM ADJUSTMENT

WITH THE MANDREL IN THE SAME POSITION AS IT IS TO ADJUST THE CUP ARM, ROTATE THE
FINGER CAM UNTIL THE FINGER HAS JUST PULLED DOWN (AT THE START OF THE CAM HIGH
POINT).

KICKER CAM ADJUSTMENT

RUN MANDREL IN PAST THE END OF IT'S FORWARD STROKE UNTIL IT STARTS BACK OUT
APPROXIMATELY 1" FROM THE END. AT THIS POINT, ROTATE THE KICKER CAM UNTIL IT JUST
STARTS TO MOVE THE KICKER CAM FOLLOWER LEVER. (KICKER SHOULD KICK JUST BEFORE
THE LIDDER CUP ARM COMES UP).

LIDDER VACUUM TIMING

WITH THE MANDREL AT THE END OF IT'S STROKE (MAXIMUM COMPRESSION) THE VACUUM
LEVER ON THE MAIN GEAR SHOULD JUST BE STARTING TO MOVE FORWARD (RELEASING
VACUUM). VACUUM SHOULD BE RELEASED BEFORE THE KICKER STARTS TO KICK.

11.3 Illustrated Parts

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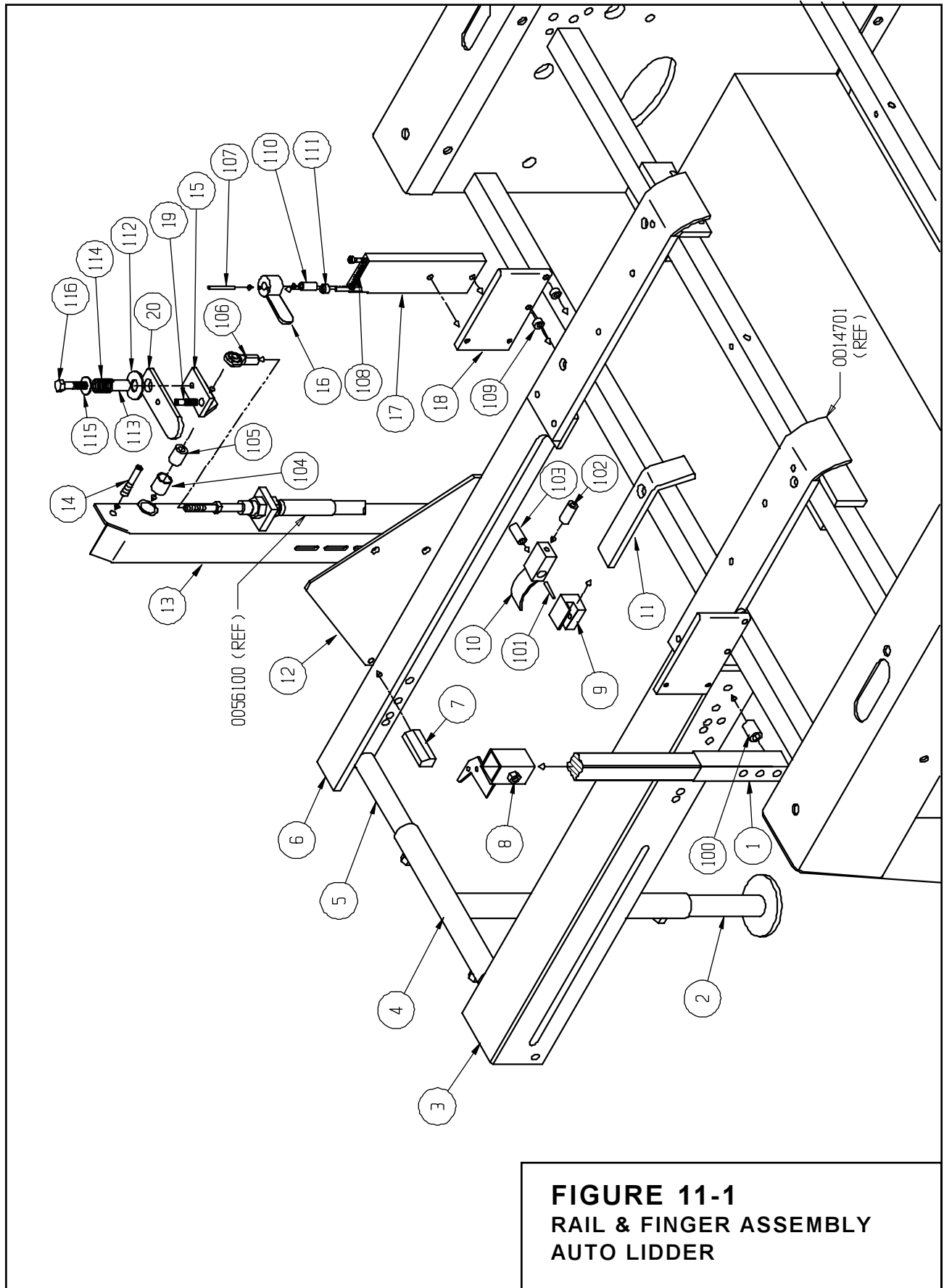
FIGURE 11-1
RAIL & FINGER ASSEMBLY
AUTO LIDDER

ITEM	PART NO.	DESCRIPTION	QTY.
1	0032700	BAR, LID HOPPER GUIDE MT	1
*	0032701	BAR, LID HOPPER GUIDE MT	1
2	0061300	SUPPORT PAD, LIDDER	1
3	0033800	LEFT RAIL, LONG LIDDER HOPPER	1
4	0061800	SUPPORT, LIDDER	1
5	0033700	SHAFT, HOPPER BRACE	2
6	0033801	RIGHT RAIL, LONG LIDDER HOPPER	1
7	0035100	STOP, BOX TUMBLER	1
8	0033300	FINGER, LIDDER STOP	1
9	0048700	MOUNT, LOWER FINGER	2
10	0048800	FINGER, LOWER	2
11	0022501	SHOE, CENTER FLANGE FORMING	1
12	0033400	PLATE, LIDDER GUIDE	1
13	0062300	MOUNT, LIDDER FINGER	1
14	0028401	STUD, BRAKE SHOE	1
15	0055401	FINGER BASE #2,	1
16	0033600	FINGER, LIDDER OPENER	1
17	0033500	PLATE, FINGER SUPPORT	1
18	0031501	PLATE, AUX. COMPRESSION	4
19	0053900	STUD-LATCH	1
20	0055402	FINGER #2 (MOVEABLE)	1
100	0203400	BUSHING	1
101	0700309	1/8 DIA. ROLL PIN	2
102	0206000	BUSHING	2
103	0205600	BUSHING	2
104	0202200	BUSHING, BRONZE	1
105	0205100	BUSHING	1
106	0501002	5/16 ROD END	1
107	0700308	5/32 DIA. ROLL PIN	2
108	1201501	SPRING	1
109	0200900	BUSHING	8
110	0201800	BUSHING	1
111	0201900	BUSHING	1
112	8036100	1/2" SAE FLAT WASHER	1
113	0200700	BUSHING	1
114	1200300	SPRING	1
115	8035800	5/16" SAE FLAT WASHER	1
116	8008500	5/16-18 X 1 1/2 HEX HD BOLT	1

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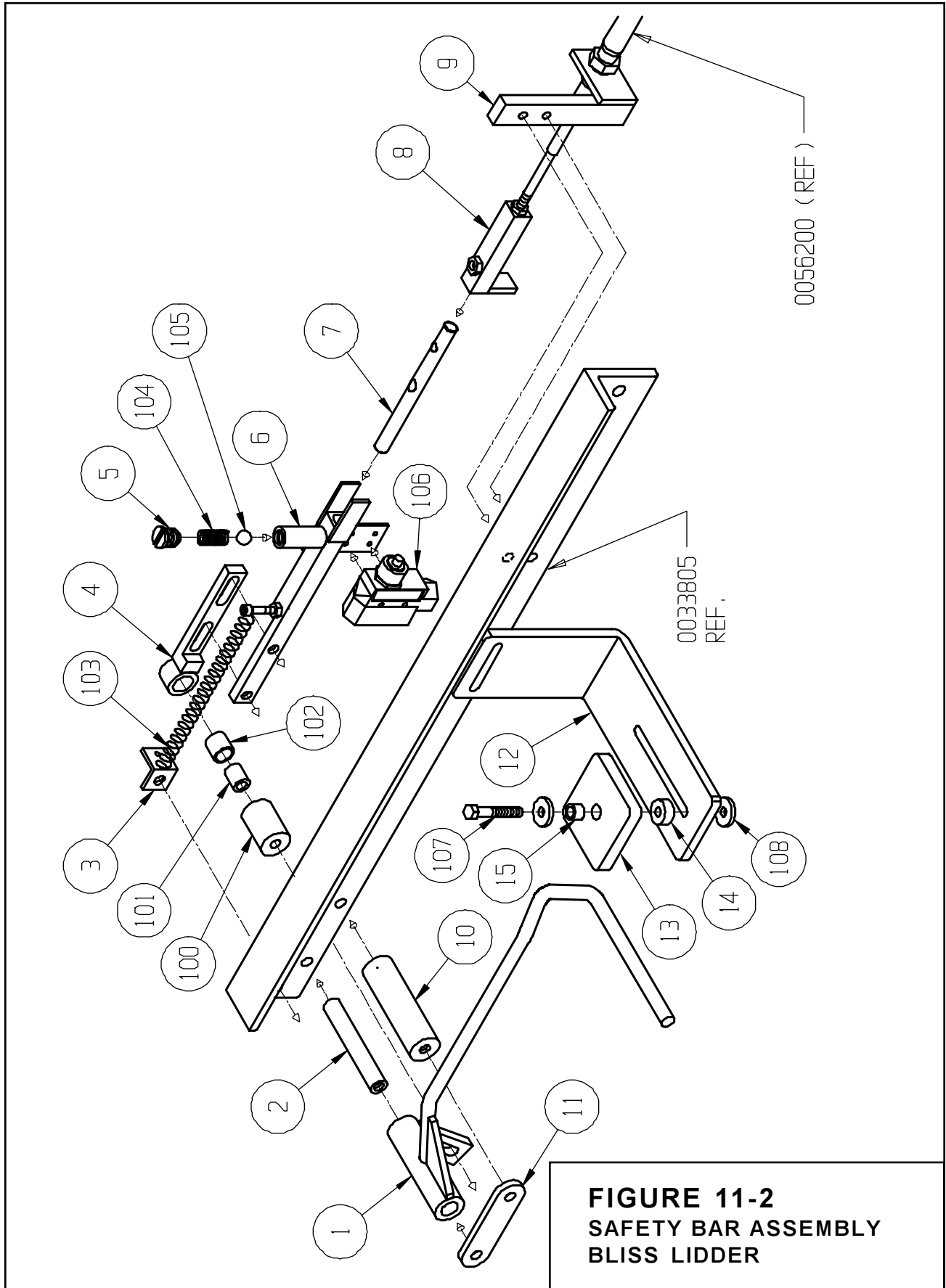


FIGURE 11-2
SAFETY BAR ASSEMBLY
BLISS LIDDER

ITEM	PART NO.	DESCRIPTION	QTY.
1	0034904	ARM, BOX TUMBLER	1
2	0035000	PIN, BOX TUMBLER ARM	1
3	0039400	BRACKET, SPRING RETURN	1
4	0039900	END ADJ BRACKET, LIDDER	1
5	0010401	PLUG, DETENT SPRING	1
6	0016203	BAR, LIDDER SAFETY	1
7	0016000	ROD, FEED LINKAGE	1
8	0061100	KICKER, SAFETY LIDDER	1
9	0061600	BRACKET, KICKER CABLE	
10	0051600	SPACER, TUMBLER	1
11	0051500	BAR, TUMBLER	1
12	0035103	STOP, MTG BRACKET	1
13	0035102	BUMPER STOP	1
14	0200300	BUSHING	1
15	0202300	BUSHING	1
100	0209500	BUSHING	1
101	0206400	BUSHING	1
102	0202200	BUSHING, BRONZE	1
103	1202500	SPRING, LIDDER	1
104	1201200	SPRING, BALL DETENT	1
105	0010301	BALL, DETENT SAFETY	1
106	0400202	MICRO SAFETY SWITCH	1
107	SCREW	5/16-18 HEX HD X 2" LG	1
108	1500102	WASHER	2



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FIGURE 11-3
HOPPER & CUP ASSEMBLY
AUTO LIDDER

ITEM	PART NO.	DESCRIPTION	QTY.
1	0037601	BRACE, LID HOPPER	1
2	0037700	SUPPORT, LONG END HOPPER	1
3	0020800	ROD, END HOPPER SPREADER	1
4	0032300	LEFT RAIL, LID HOPPER SIDE	1
5	0034300	PLATE, RAIL HOPPER CLAMP	1
6	0051702	MANIFOLD- 2 PORT	1
7	0035203	CUP HOLDER BAR	1
8	0035202	CUP MOUNT BRACKET	1
9	0034400	SHAFT, LIDDER SUCTION CUP	1
10	0035201	ARM, LIDDER CUP MTG	1
11	0037400	SHIM, LIDDER HOPPER	2
12	0032301	RIGHT RAIL, LID HOPPER SIDE	1
13	0062700	MOUNT, CUP CABLE LIDDER	1
14	0076700	BRACKET, SPRING MOUNT	1
15	0034501	ARM, LID OPEN CON ROD	1
16	0041800	MOUNT, SPRING ADJUSTING	1
17	0037904	TUBE #2- SUCTION CUP	1
18	0041801	BAR- SPRING TENSION ADJ.	
100	0100500	SET COLLAR, 3/4"	3
101	0208700	BUSHING, BRONZE	2
102	1804100	TUBE FITTING- 1/4 X 3/8	1
103	1804000	90 DEGREE ELBOW	3
104	0037300	3/8 POLY FLOW TUBING	3
105	0041607	VACUUM CUP, PIAB	1
106	1201900	SPRING	1
107	0501002	5/16 ROD END	1
108	0900201	3/16 SQUARE KEY	1
109	0100400	5/8 SET COLLAR	2
110	0056001	CABLE- LID CUP (WB)	1
*	0056000	CABLE- LID CUP (SB)	1
111	1502000	NEOPRENE WSHER	1
112	8036102	5/8 FLAT WASHER	2
113	1202100	SPRING	1
114	8025100	1/2 JAM NUT	1
115	0204100	BUSHING	1

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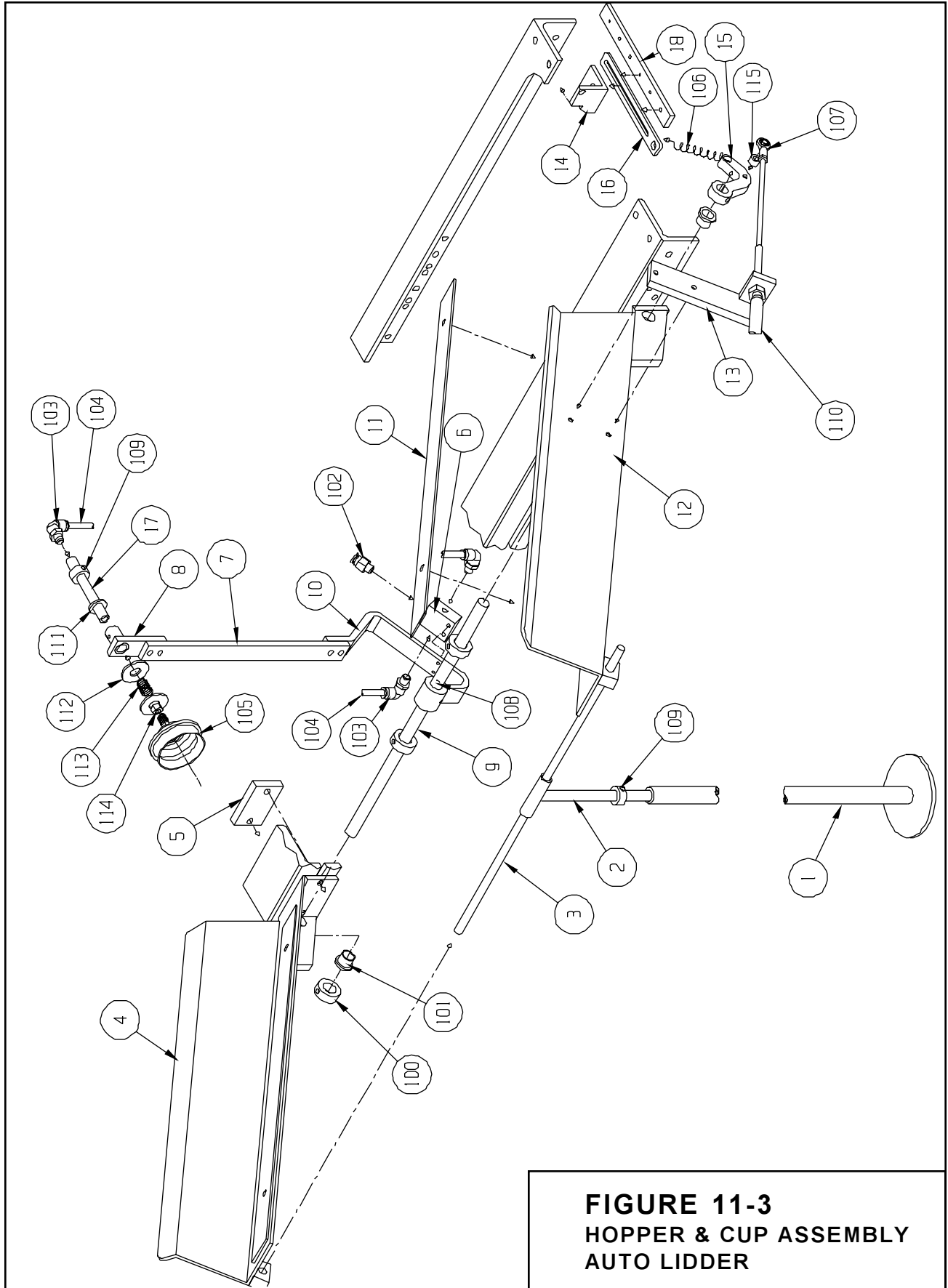


FIGURE 11-3
HOPPER & CUP ASSEMBLY
AUTO LIDDER

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FIGURE 11-4
HOPPER WEIGHT ASSEMBLY
AUTO LIDDER

ITEM	PART NO.	DESCRIPTION	QTY.
1	0026501	WEIGHT, END HOPPER	1
2	0063100	FINGER, BOX LIDDER PUSHER	1
3	0036100	ROLLER, WEIGHT LIDDER	1
4	0026602	ROD, LOWER WEIGHT LIDDER	1
5	0062900	MOUNT, WEIGHT LIDDER	1
6	0032400	GUIDE, LID HOPPER	1
7	0063000	MOUNT, UPPER WEIGHT LIDDER	1
8	0032600	BRACKET, HOPPER GUIDE	1
9	0033200	FINGER, LID FLAP OPENER	1
10	0033001	BAR, FINGER MOUNT	1
11	0033100	STRAP, FINGER MTG BAR	1
100	0207200	BUSHING	1
101	0047101	BEARING	2
102	0047201	RETAINER	2
103		5/8 SAE FLAT WASHER	2
104	1202600	SPRING	1
105	0206000	BUSHING	1
106	0100400	5/8 SET COLLAR	1
107	0700307	ROLL PIN 1.0" LG	1
108	0209900	BUSHING, ROLLER WEIGHT	1



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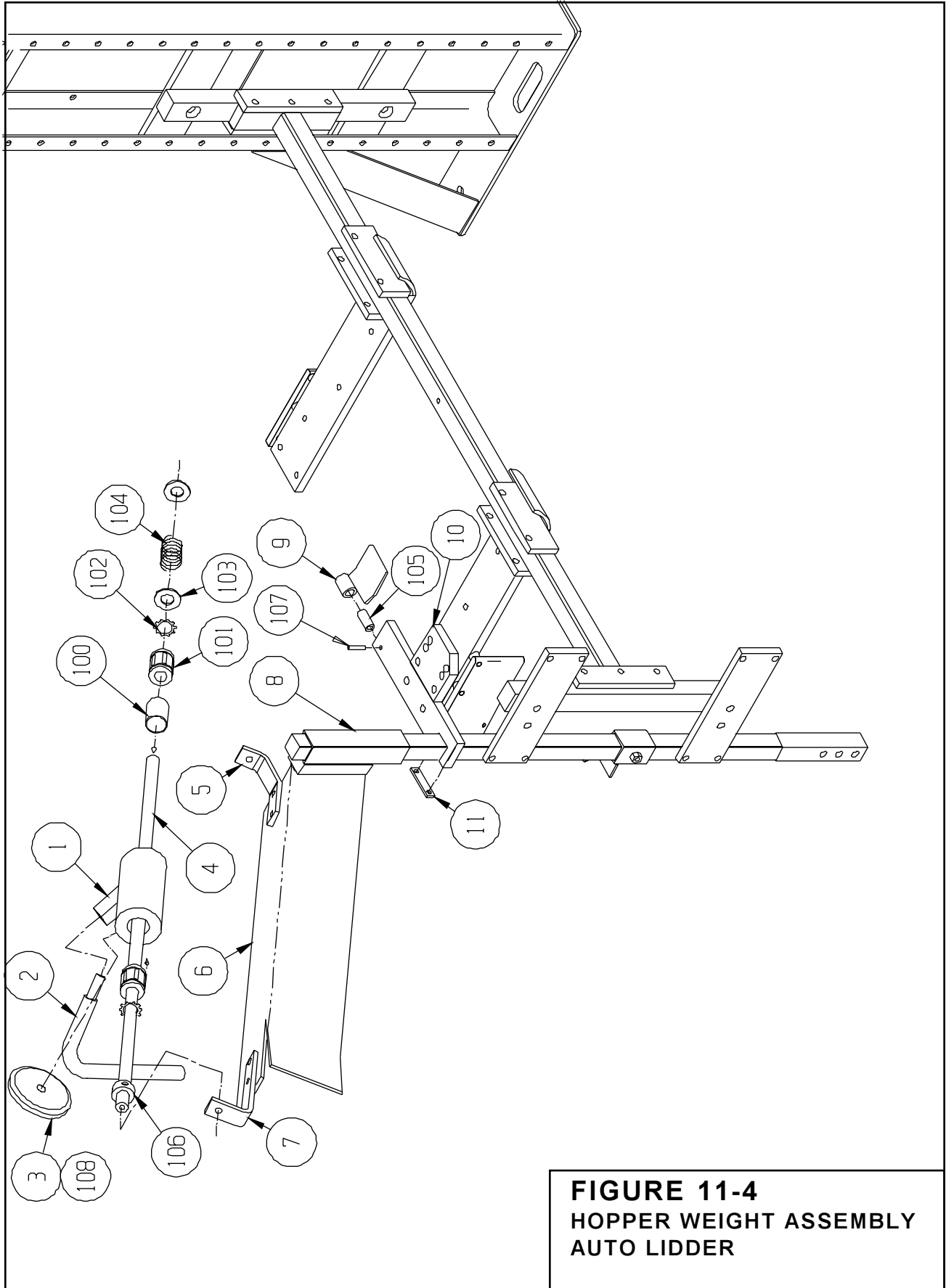


FIGURE 11-4
HOPPER WEIGHT ASSEMBLY
AUTO LIDDER

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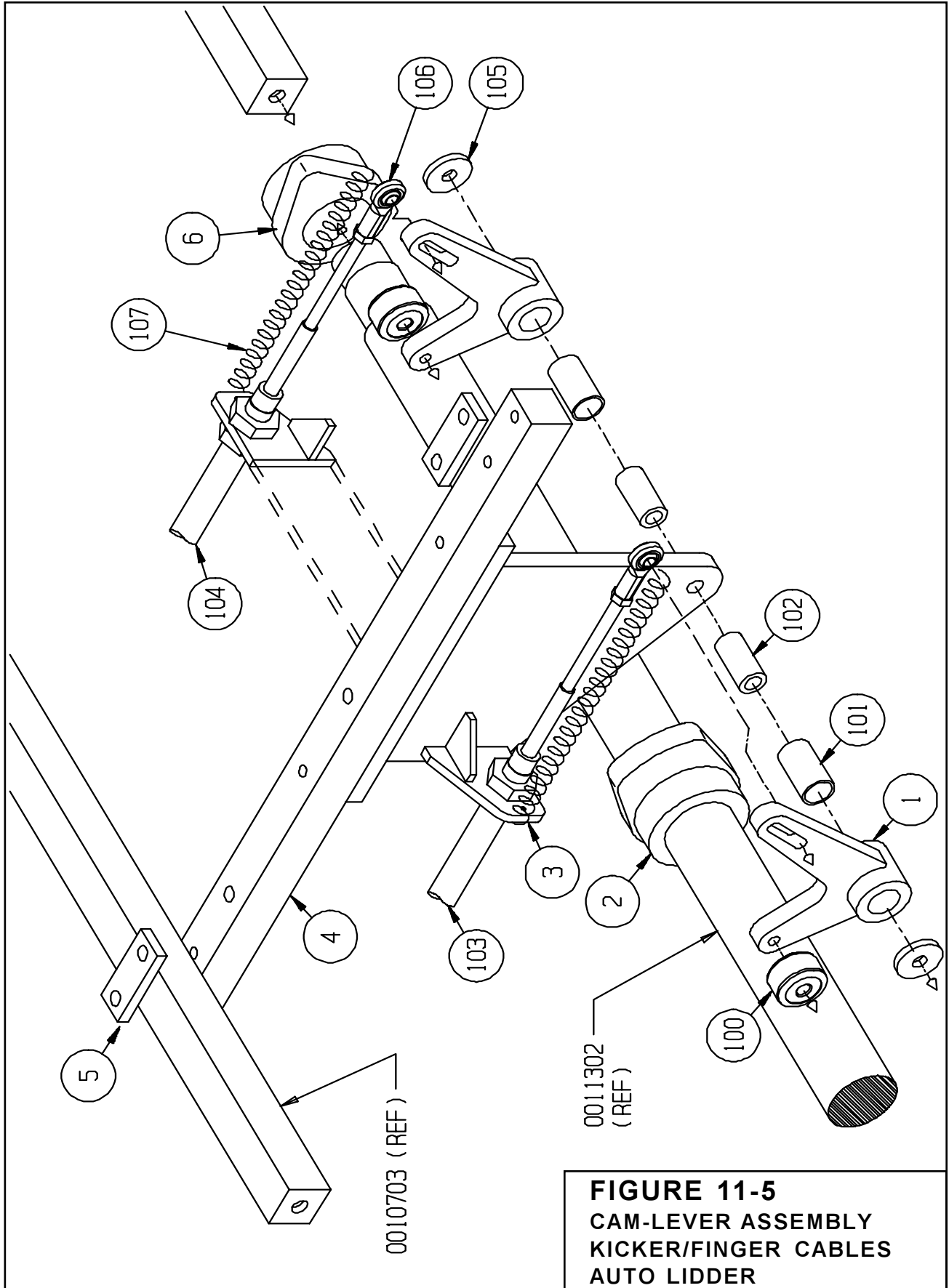


FIGURE 11-5
CAM-LEVER ASSEMBLY
KICKER/FINGER CABLES
AUTO LIDDER

ITEM	PART NO.	DESCRIPTION	QTY.
1	0061000	LEVER, CABLE PULL	2
2	0062100	CAM, FINGER CABLE	1
3	0040100	CABLE BRACKET, AUTO LIDDER	1
4	0061501	BAR, LOWER MOUNT	1
5	0012801	CLAMP	2
6	0062000	CAM, KICKER CABLE	1
100	0500700	CAM FOLLOWER, 1 3/8	2
101	0209200	BUSHING, SLEEVE	2
102	0074300	BUSHING, LEVER	2
103	0056100	CABLE, FINGER CLAMP	1
104	0056200	CABLE, KICKER	1
105	1500600	WASHER	2
106	0501002	5/16 ROD END	2
107	1202700	SPRING	2



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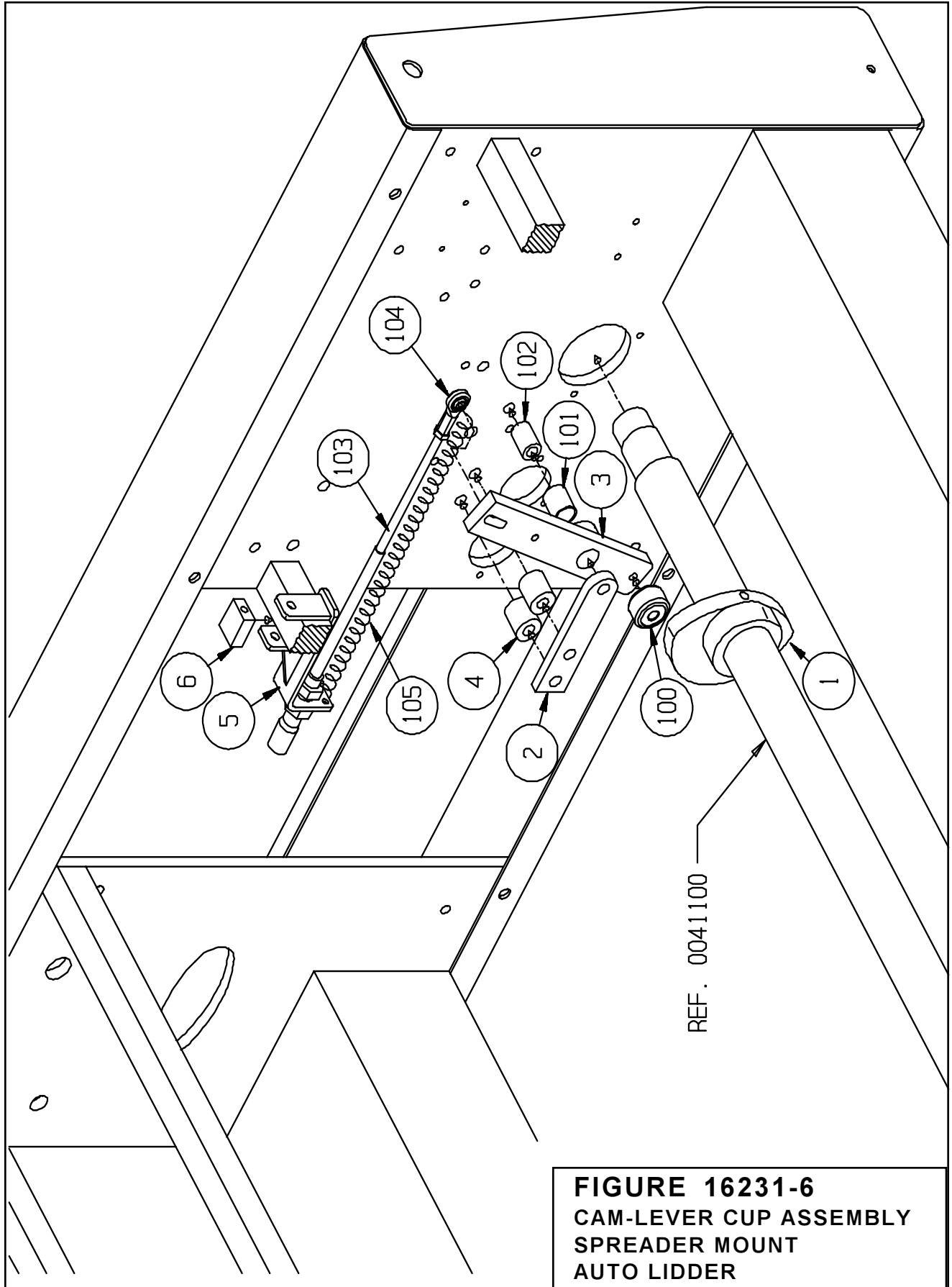


FIGURE 16231-6 CAM-LEVER CUP ASSEMBLY SPREADER MOUNT AUTO LIDDER

ITEM	PART NO.	DESCRIPTION	QTY.
1	0062200	CAM, CUP CABLE LIDDER	1
2	0040900	STRAP, PICK LEVER	1
3	0060900	LINKAGE, CAM ARM LIDDER	1
4	0040801	BLOCK, MATT PICK STRIP	2
5	0079201	BRACKET, CABLE	1
6	0079901	BLOCK, BOLTING	1
100	0500700	CAM FOLLOWER, 1 3/8	1
101	0200100	BUSHING, BRONZE	1
102	0203000	BUSHING	1
103	0056000	CABLE, LIDDER (SB)	1
	0056001	CABLE LIDDER (WB)	1
104	0501002	5/16 ROD END	1
105	1202700	SPRING	1



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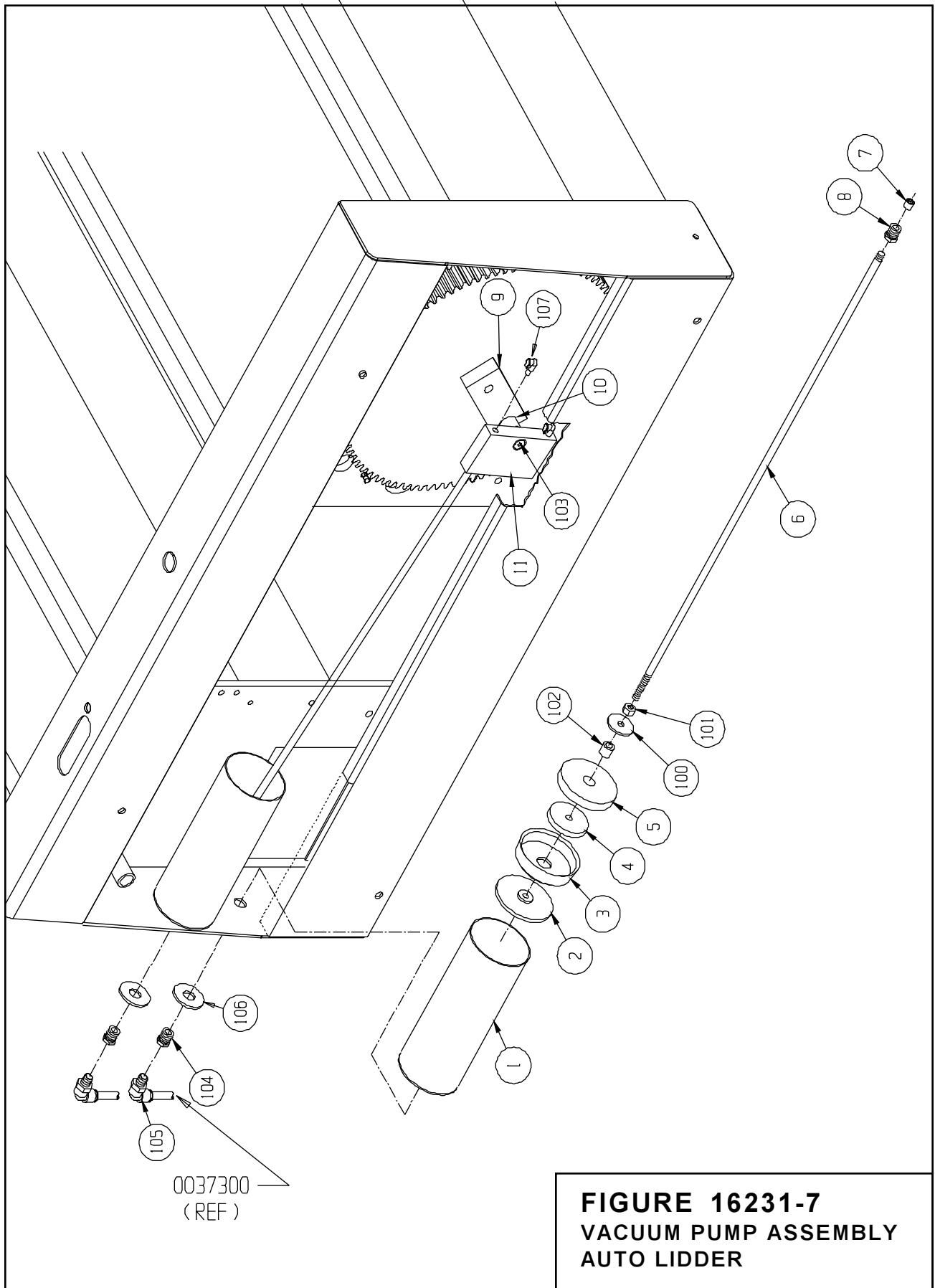


FIGURE 16231-7 VACUUM PUMP ASSEMBLY AUTO LIDDER

ITEM	PART NO.	DESCRIPTION	QTY.
1	0036300	CYLINDER, VACUUM LIDDER	2
2	0036400	PLATE, RUBBER CUP MTG	2
3	0036500	CUP, VACUUM CYLINDER	2
4	0036600	WASHER, CUP CLAMP	2
5	0037200	FELT, WASHER VACUUM CUP	2
6	0036700	ROD, CON SUCTION CUP	2
7	0036800	NUT, CUP CON ROD	2
8	0036900	SLEEVE	2
9	0037100	CRANK, SUCTION CUP	1
10	0037000	PIN, SUCTION CUP CRANK	1
11	0040300	BLOCK, SUCTION CUP	1
100	1500800	WASHER	2
101		3/8-24 STD HEX HD NUT	2
102	0200800	BUSHING	2
103	0202200	BUSHING, BRONZE	1
104	1808800	BUSHING, THREADED	2
105	1804000	90 DEGREE ELBOW	2
106		5/8 SAE FLAT WASHER	2
107	1808100	OIL CUP	2



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