



19.0 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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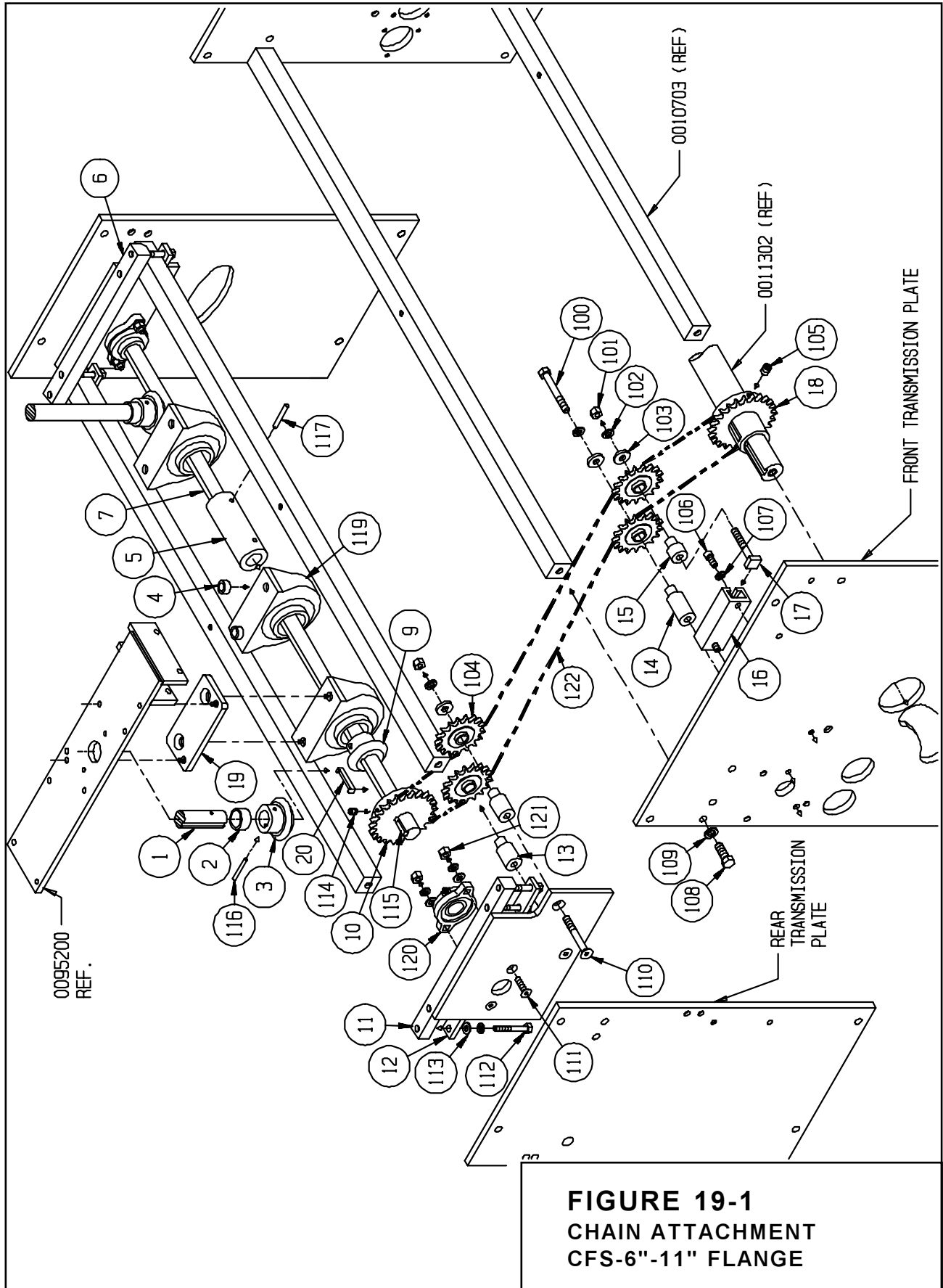
FIGURE 19-1
CHAIN ATTACHMENT ASSEMBLY
CFS-6" TO 11" FLANGE

ITEM	PART NO.	DESCRIPTION	QTY.
1	0094101	SHAFT, MAIN ROTATION	REF
2	0094200	SPACER, MAIN ROTATION	2
3	0085100	GEAR, TOP COMPRESSION ADJ	2
4	0203101	BUSHING, FLANGE BEARING	2
5	0094000	COUPLING	1
6	0096200	HANGER, SHAFT RH	1
7	0093301	SHAFT, HORIZONTAL (WB)	2
9	0093400	GEAR, BEVEL	2
10	0041000	SPROCKET, 1.00 BORE	1
11	0096300	HANGER, SHAFT LH	1
12	0012801	CLAMP	4
13	0093700	AXLE, IDLER PLATE SPROCKET	2
14	0093800	AXLE, IDLER TRANS SPROCKET	1
15	0093900	AXLE, IDLER ADJ SPROCKET	1
16	0093500	IDLER ADJUSTMENT	1
17	0093600	IDLER BOLT	1
18	0093200	SPROCKET, 1 7/8 BORE	1
19	2110400	MOUNT, BEARING	2
20	2106500	KEY FOLLOWER	2
100		3/8-16 HEX HD CAP SCR X 3 1/4 LG	1
101		3/8-16 STD HEX NUT	3
102		3/8 STD LOCK WASHER	4
103	1500200	WASHER	4
104	0300101	IDLER SPROCKET	4
105		7/16-14 CUP PT SET SCR X 5/8 LG	1
106		5/16-18 SCKT HD CAP SCR X 3/4 LG	2
107		5/16 STD LOCK WASHER	14
108		7/16-14 HEX HD CAP SCR X 1 1/4 LG	8
109		7/16 STD LOCK WASHER	8
110		3/8-16 SCKT FLT HD SCR X 3 LG	2
111		5/16-18 SCKT FLT HD SCR X 1 1/4 LG	4
112		5/16-18 HEX HD CAP SCR X 2 1/4 LG	8
113		5/16 SAE FLAT WASHER	12
114		5/16-18 CUP PT SET SCR X 1/2 LG	6
115	0900301	KEY, 1/4 X 1/4	3
116	0700600	ROLL PIN, 3/16 DIA.	2
117	0700400	ROLL PIN, 1/4 DIA.	2
119	0502300	BEARING, 1 3/4" DIA.	3
120	0501200	BEARING, 1" DIA.	2
121		5/16-18 STD HEX NUT	4
122	0800211	#40 CHAIN	1

Option Parts & Illustrations



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FIGURE 19-2 UPPER COMPRESSION ASSEMBLY CORNER FLANGE SEAL KWIK CHANGE-OPTIONAL

ITEM	PART NO.	DESCRIPTION	QTY.
1	0085300	SHAFT, TOP COMP ADJ-W.B.	1
2	0091702	BAR, TOP COMP SUPPORT-W.B.	1
3	0085100	GEAR, TOP COMP ADJ	2
4	0085800R/L	PLATE, TOP COMP SUPPORT	1/1
5	0085400R/L	SCREW, TOP COMP ADJ	1/1
6	0085900	BAR, TOP COMP PLATE GUIDE	2
7	0086300	BRACKET, BAR GUIDE MOUNT	6
8	0086100	STRIP WEAR	4
9	0086500	BAR, GIB HOLDER	4
10	0090100	SPACER, SUPP BEARING COMP	2
11	0090200R/L	SPACER, SUPPORT TOP COMP	1/1
12	0087200	BAR, COMP FRONT SUPPORT-W.B	1
13	0043003	AXLE, IDLE SPROCKET	1
100	0207700	BUSHING, BRASS	4
101	0100700	1" SET COLLAR	1
102	0700503	RIVOT	8
103		3/8-16 STD HEX NUT	6
104		3/8 STD LOCK WASHER	18
105		3/8-16 SCKT FLT HD X 1 1/2 SCR	6
106		1/4" X 1 5/8" LG ROLL PIN	2
108	0502200	CAM ROLLER	2
109		1/2 SAE FLT WASHER	2
110		1/2-20 HALF HEX NUT	2
111		3/8-16 HEX HD CAP SCR X 1 1/4	4
112		3/8-16 HEX HD CAP SCR X 1	8
113		3/8-16 SCKT FLT HD SCR X 1 3/4	1
114	0300101	IDLE SPROCKET	1
115	1501800	WASHER	1
116		3/8-16 SCKT FLT HD SCR X 3/4	1
117	0087600	WASHER, THRUST	2
118	1501400	WASHER	1

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Tray Box Former

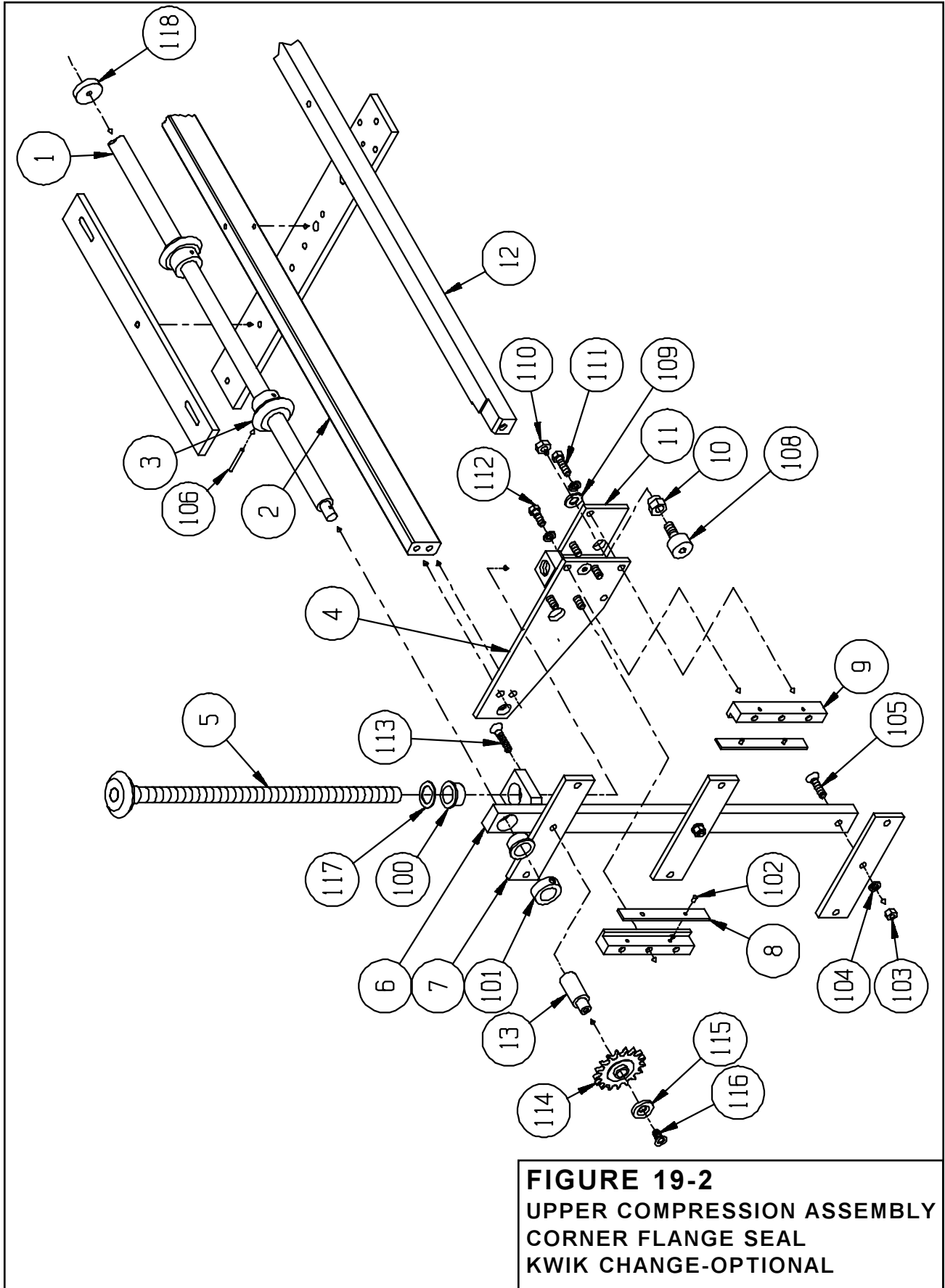


FIGURE 19-2
UPPER COMPRESSION ASSEMBLY
CORNER FLANGE SEAL
KWIK CHANGE-OPTIONAL

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FIGURE 19-3
MAIN ROTATION ASSEMBLY
CFS-6" TO 11" FLANGE

ITEM	PART NO.	DESCRIPTION	QTY.
1	9080800	SHAFT, MAIN ROTATION-41"	2
2	0099800	PLATE, PLOW ROTATION	4
3	9079100	ROLLER, TOP VERTICAL	4
4	0099700	ROD END	2
5	9078100R/L	PIVOT, FLAP	1/1
6	0092302R/L	PLOW, ROTATING	2/2
7	9078200R/L	FLAP, VERTICAL	2/2
8	0095600R/L	MOUNT, CABLE	1/1
9	9081300R/L	PLOW, COMBINATION	2/2
10	0095300	PLOW, VERTICAL	2
11	0093100	SHAFT, ROLLER	4
12	0091200	BLOCK, PLOW MOUNT	4
13	0091000	PLATE, VERTICAL MOUNT	4
14	0209400	BUSHING, VERTICLE BAR	8
15	9081200	BAR, VERTICLE SUPPORT-41"	2
100	0501200	1" FLANGE BEARING	4
101	0100700	1" SET COLLAR	6
102	0205700	BUSHING, BRONZE	4
103	0203500	BUSHING	8
104	0204600	BUSHING	4
105	0502400	ROLLER BEARING	4
106		KEY, 1/4 X 1/4 X 3/4 LG	4
107	1202700	SPRING	2
108	1502100	WASHER	4
109	0202700	BUSHING	2

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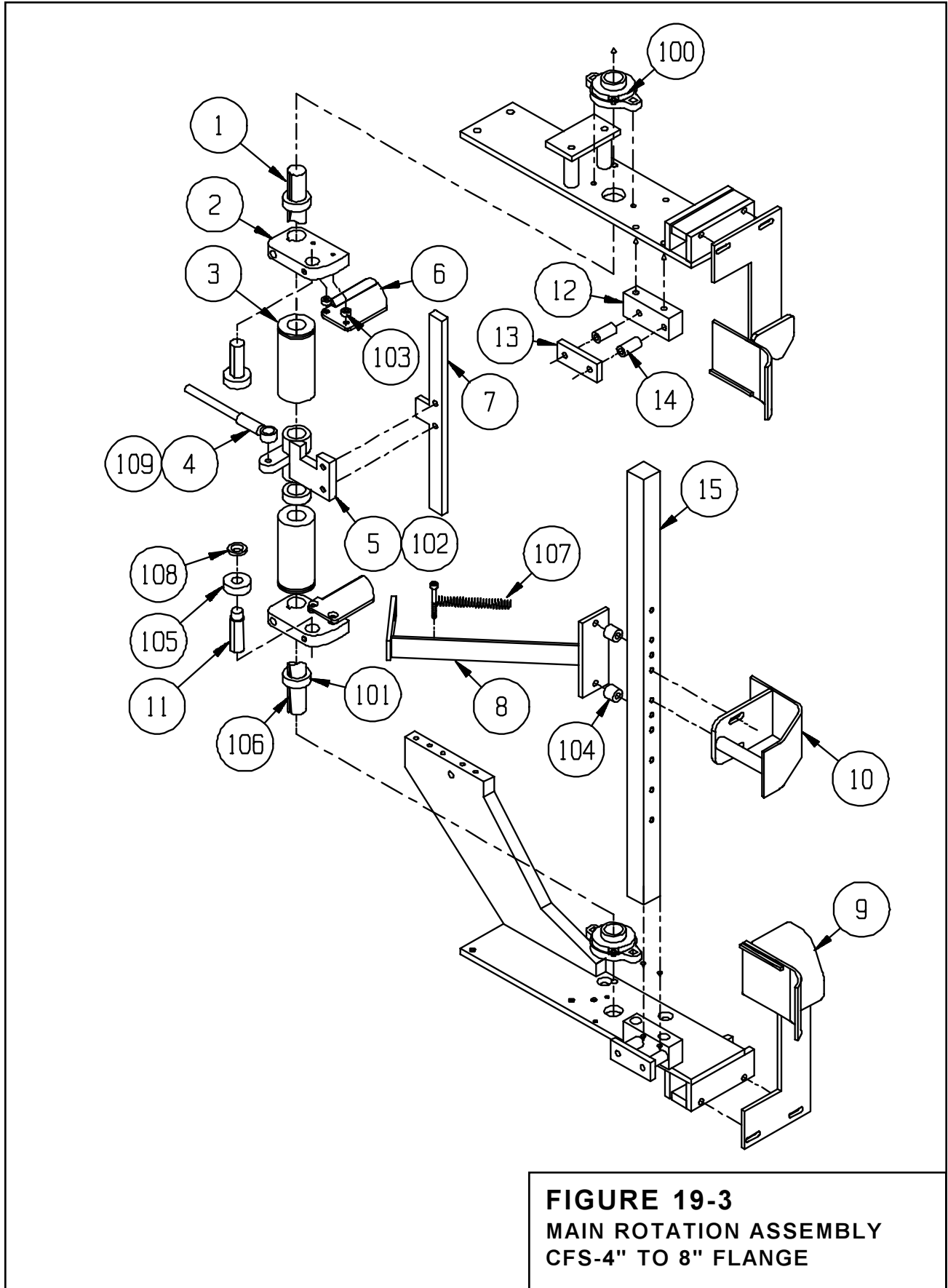


FIGURE 19-3
MAIN ROTATION ASSEMBLY
CFS-4" TO 8" FLANGE

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FIGURE 19-4
FLAP FOLDER-CAM LINKAGE ASSY
CORNER FLANGE SEAL

ITEM	PART NO.	DESCRIPTION	QTY.
1	0096400	BRACKET, CABLE	1
2	0094300	BAR, BRACKET MOUNT	1
3	0092000	CAM	1
4	0094600	BRACKET, FLAP FOLDER	1
5	0094700	PIVOT ARM BRACKET-REAR	2
6	0094801	PIVOT ARM BRACKET	2
7	0203000	BUSHING	4
8	0203700	BUSHING	4
9	0051502	LINK, FLAP LEVER	2
100	0090500	3/8 CABLE, 3-96	1
101	0096600	3/8 CABLE, 3-120	1
102		1/4-20 STD HEX NUT	1
103		3/8-16 HEX HD CAP SCR X 1 3/4 LG	4
104		3/8 STD LOCK WASHER	13
105		1/4-20 SCKT HD CAP SCR X 2 1/4 LG	1
106	1202700	SPRING	2
107		3/8-16 HEX HD CAP SCR X 2 1/2 LG	2
109	1500200	WASHER	12
110		3/8-16 STD HEX NUT	3
111		3/8-16 HEX HD CAP SCR X 1 1/2 LG	2
112		3/8-16 FIBER LOCK NUT	2
113	0209600	BUSHING-BRONZE	4
114	0200800	BUSHING	4
115	0200100	BUSHING-BRONZE	4
116		3/8-16 HEX HD CAP SCR X 4 LG	1
117	1501600	WASHER	4
118		7/16-14 HEX HD CAP SCR X 4 1/2 LG	2
119		3/8-16 HEX HD CAP SCR X 4 LG	1
120		3/8-16 HEX HD CAP X 2 1/2 LG	4
121	0500700	1 3/8" BEARING	1
122		3/8 SAE FLAT WASHER	1
123	1500600	WASHER	4
124		7/16 STD LOCK WASHER	2
125		7/16-14 STD HEX NUT	2
126	0501001	3/8 ROD END	2
127		3/8-24 STD HEX NUT	2

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Tray Box Former

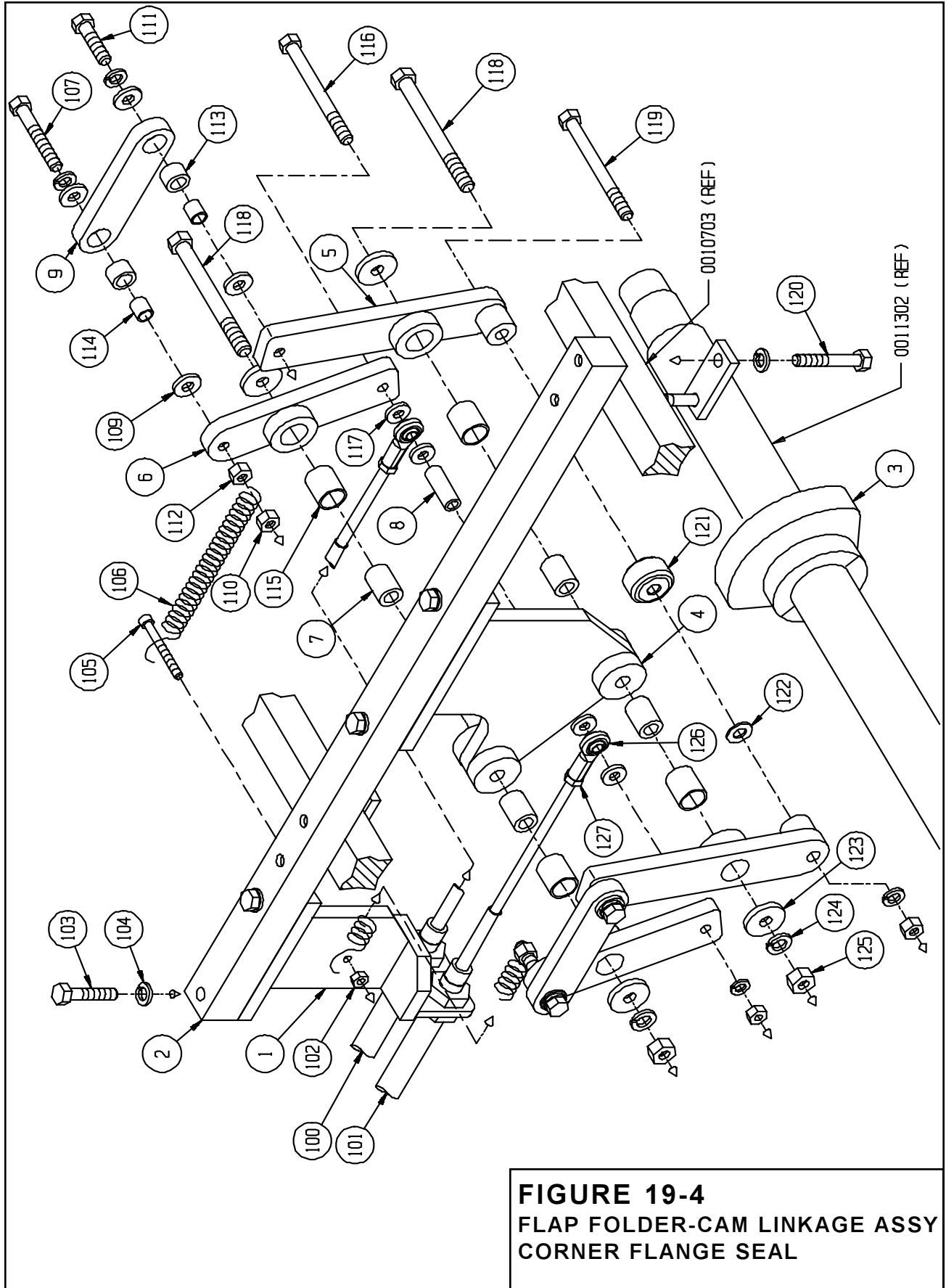


FIGURE 19-4
FLAP FOLDER-CAM LINKAGE ASSY
CORNER FLANGE SEAL

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Tray Box Former



FIGURE 19-5
CABLE STOP BRACKET ASSEMBLY
CFS-6" TO 11" FLANGE

ITEM	PART NO.	DESCRIPTION	QTY.
1	0091300	BAR, ROLLER MOUNT	4
2	0090800	ROLLER, HORIZONTAL	24
3	0090700	AXLE, ROLLER	24
4	0091400	BAR, INSIDE ROLLER MOUNT	4
5	9081400	PLATE, COMP ROLLERS	4
6	0095000R/L	ANGLE, ROLLER MOUNT	2/2
7	0096001R/L	WELDMT, STOP SUPPORT	1/1
*	9073800R/L	WELDMT, LOWER STOP SUPPORT	1/1
8	9076000R/L	BRACKET, CABLE STOP MOUNT	1/1
9	0092800	VERTICAL STOP	2
10	0096100R/L	STOP	1/1
11	2110600	SECONDARY FLAP GUIDE	4
12	0091800	SPACER-W.B.	4
13	0090900	PLATE, CLAMPING	2
14	2110500R/L	FLAP, GUIDE	2/2
16	0091702	BAR, SPREADER-W.B.	1
100	0501002	5/16 ROD END	2
101	0200100	BUSHING	2
102	0100500	3/4" SET COLLAR	2
103	0205200	BUSHING	2
105	1501100	WASHER	22
106	1502200	WASHER	4

* Not Shown



Tray Box Former

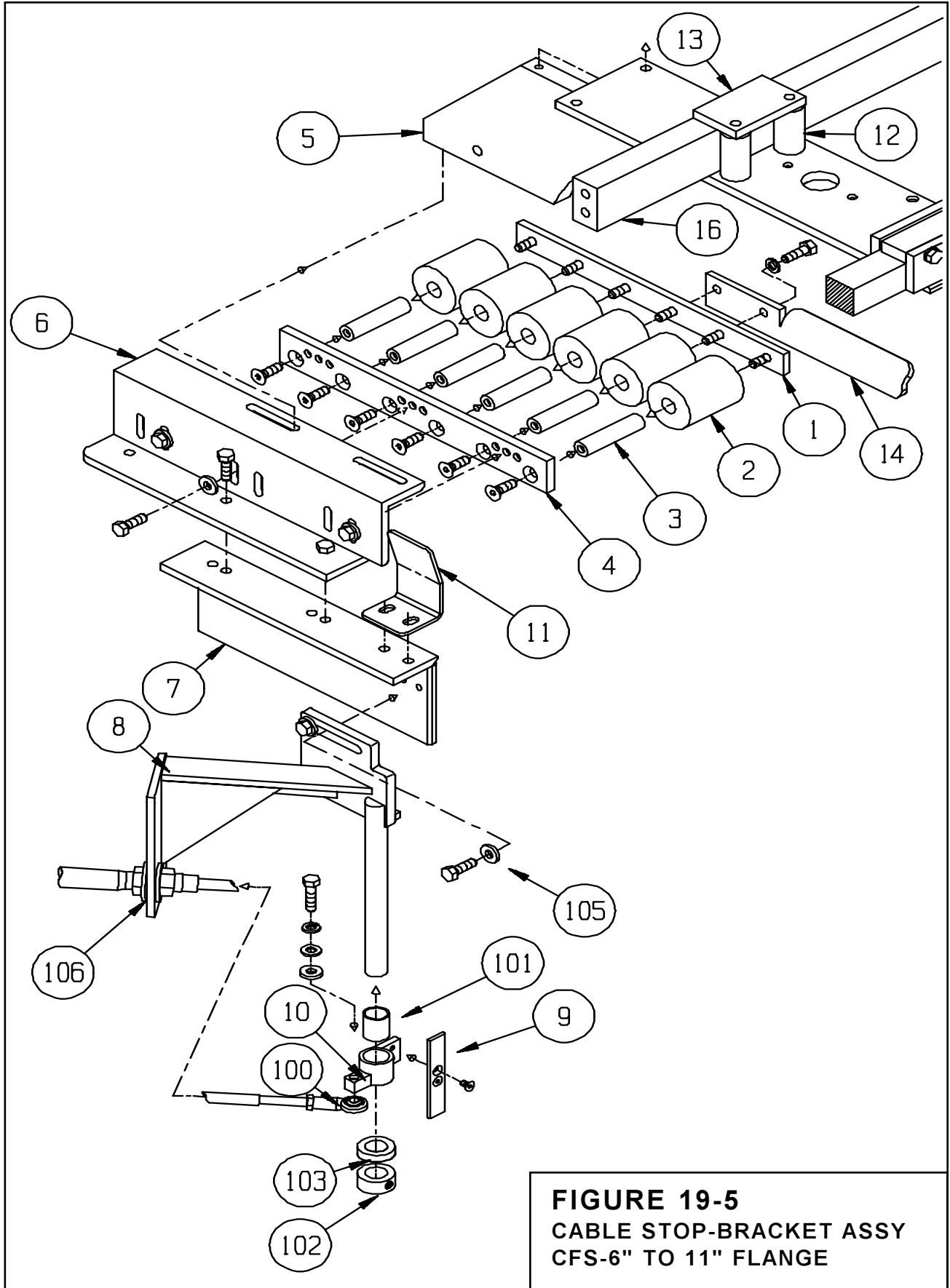


FIGURE 19-5
CABLE STOP-BRACKET ASSY
CFS-6" TO 11" FLANGE

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Tray Box Former

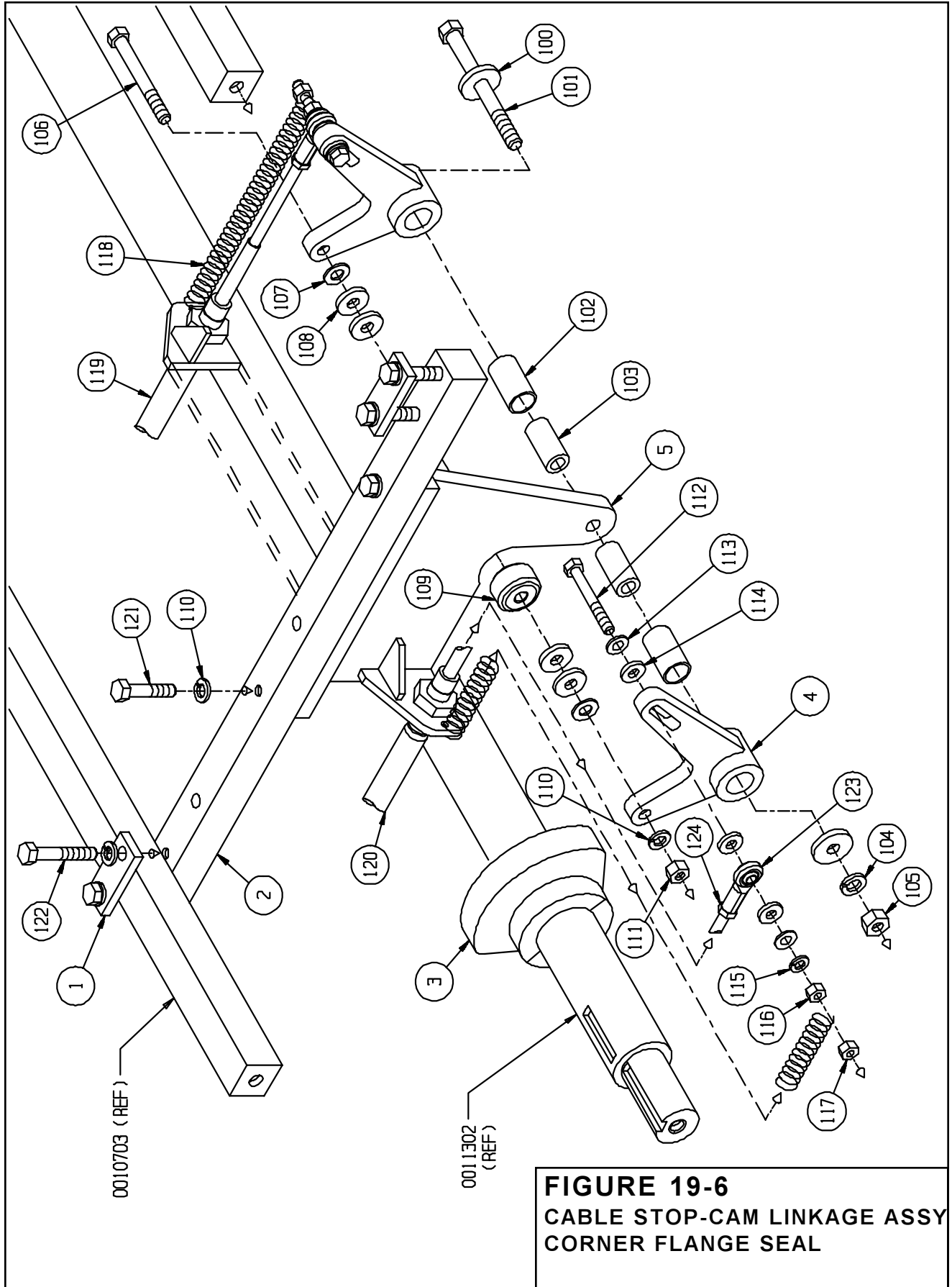


FIGURE 19-6
CABLE STOP CAM LINKAGE
CORNER FLANGE SEAL

ITEM	PART NO.	DESCRIPTION	QTY.
1	0012801	CLAMP	2
2	0061501	BAR, LOWER MOUNT	1
3	0092000	CAM	1
4	0061000	WELDMT, CABLE PULL LEVER	2
5	0095800	BRACKET, LEVER	1
100	1500600	WASHER	2
101		7/16-14 HEX HD CAP SCR X 4 1/2	1
102	0209200	BEARING, SLEEVE	2
103	0074300	BUSHING, LEVER	2
104		7/16 STD LOCK WASHER	1
105		7/16-14 STD HEX NUT	1
106		3/8-16 HEX HD CAP SCR X 3 1/4	1
107		3/8 SAE FLAT WASHER	2
108	1500101	WASHER	4
109	0500700	1 3/8 BEARING	1
110		3/8 STD LOCK WASHER	7
111		3/8-16 STD HEX NUT	1
112		5/16-18 HEX HD CAP SCR X 2 1/4	1
113		5/16 SAE FLAT WASHER	4
114	1501100	WASHER	6
115		5/16 STD LOCK WASHER	2
116		5/16-18 STD HEX NUT	2
117		5/16-18 FIBER LOCK NUT	2
118	1202700	SPRING	2
119	0090600	5/16 CABLE, 2-120	1
120	0056100	5/16 CABLE, 2-90	1
121		3/8-16 HEX HD CAP SCR X 1 3/4	4
122		3/8-16 HEX HD CAP SCR X 3 1/4	2
123	0501002	5/16 ROD END	2
124		5/16-24 STD HEX NUT	2



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FIGURE 19-7
STRIPPER MOUNT ASSEMBLY
CFS-6" TO 11" FLANGE

ITEM	PART NO.	DESCRIPTION	QTY.
1	9075600	PLATE, MOUNT SUPPORT	2
3	0095701	WELDMT, ACUATOR	4
4	0092600	ACUATOR	4
5	0091500	SUPPORT, SHOE	2
6	9080900	STANDOFF	6
7	0092900	SHOE, BOX FORMING	2
8	0092100	PLOW. CENTER	2
9	9081100	MOUNT, CENTER SHOE	2
10	00951102	PLATE, MOUNTING SHOE	2
11	00951101	PLATE, MOUNTING BAR	2
12	9078000	PLATE, ROLLER BRACE	2
100		5/16-18 HEX HD CAP SCR X 1 3/4	8
101		1/4-20 HEX HD CAP SCR X 3/4 LG	8
102		1/4 STD LOCK WASHER	8
103		1/4 SAE FLAT WASHER	8
104	1200300	SPRING	4
105		7/32 ROLL PIN X 1 1/4 LG	4
106		5/16-18 HEX HD CAP SCR X 1 1/4 LG	10
107		5/16 STD LOCK WASHER	30
108		5/16-18 STD HEX NUT	20
109		5/16-18 SCKT FLAT HD SCR X 1 LG	18
110	1501600	WASHER	4



Tray Box Former

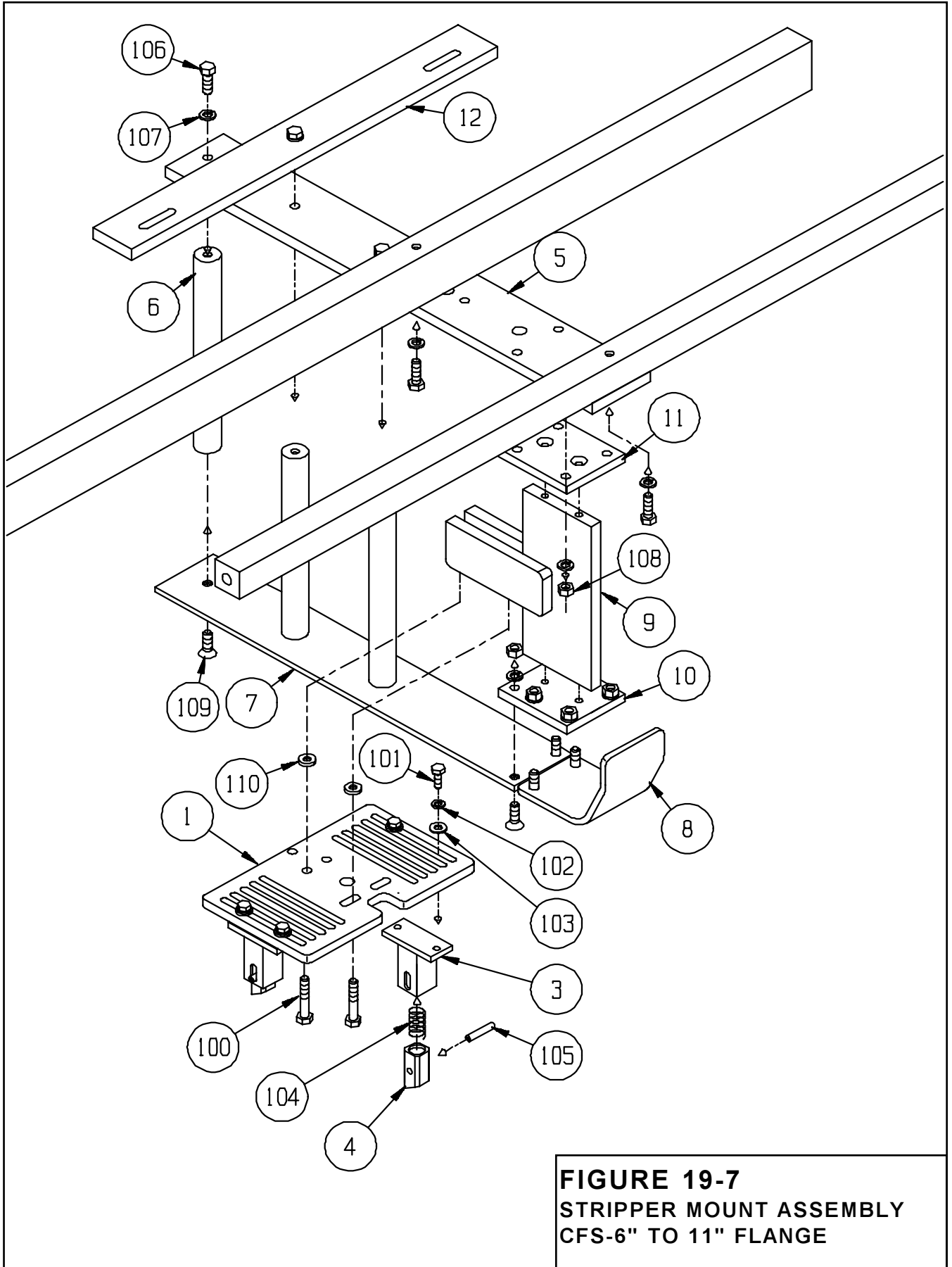


FIGURE 19-7
STRIPPER MOUNT ASSEMBLY
CFS-6" TO 11" FLANGE

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FIGURE 19-8
ELEVATED MANDREL ASSEMBLY
CFS-6" TO 11" FLANGE

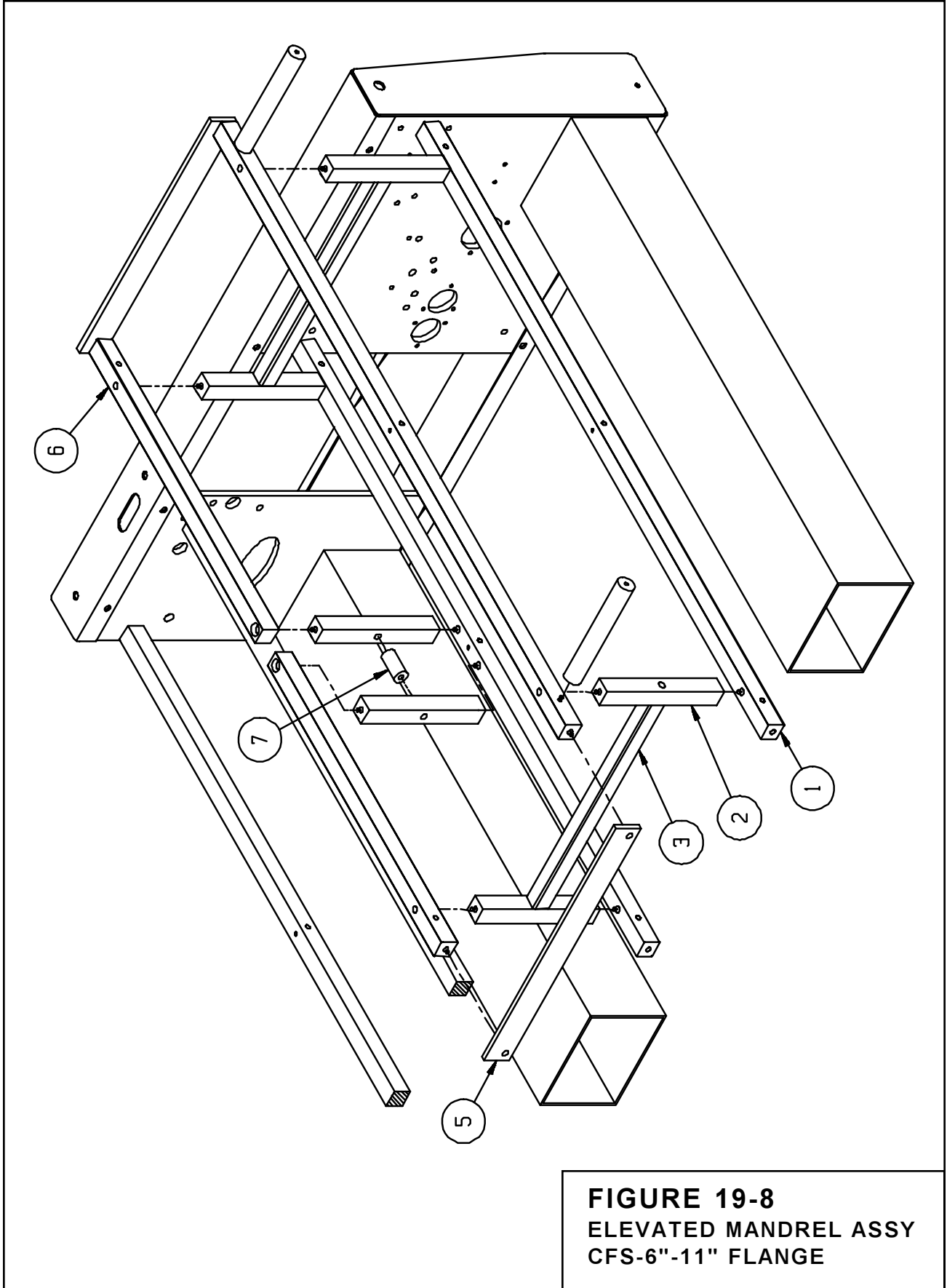
ITEM	PART NO.	DESCRIPTION	QTY.
1	0010705	SPREADER, FRAME-W.B.	5
2	9081000	POST-6" TO 11" FLANGE	6
3	2109900	SPACER BAR	2
5	2110000	PLATE BAR	2
6	2110101	SPREADER, REAR FRAME-W.B.	2
7	2110300	SPACER	1

Hardware Not Shown

Option Parts & Illustrations



Tray Box Former



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FIGURE 19-9
DUAL LOADING RAMP
VACUUM FEED

ITEM	PART NO.	DESCRIPTION	QTY.
1	0049100	PLATE, KNIFE MOUNTING BRACKET	2
2	0049000	BRACKET, KNIFE PLATE	2
3	0041900	SCREW, MATT SUPPORT	2
4	9060200	BRACKET, HOPPER SUPPORT	2
100		5/16-18 HEX HD CAP SCR X 1 LG	4
101		#10-32 STD HEX NUT	2
102		5/16 STD LOCK WASHER	8
103		5/16-18 HEX HD CAP SCR X 3/4 LG	8



Tray Box Former

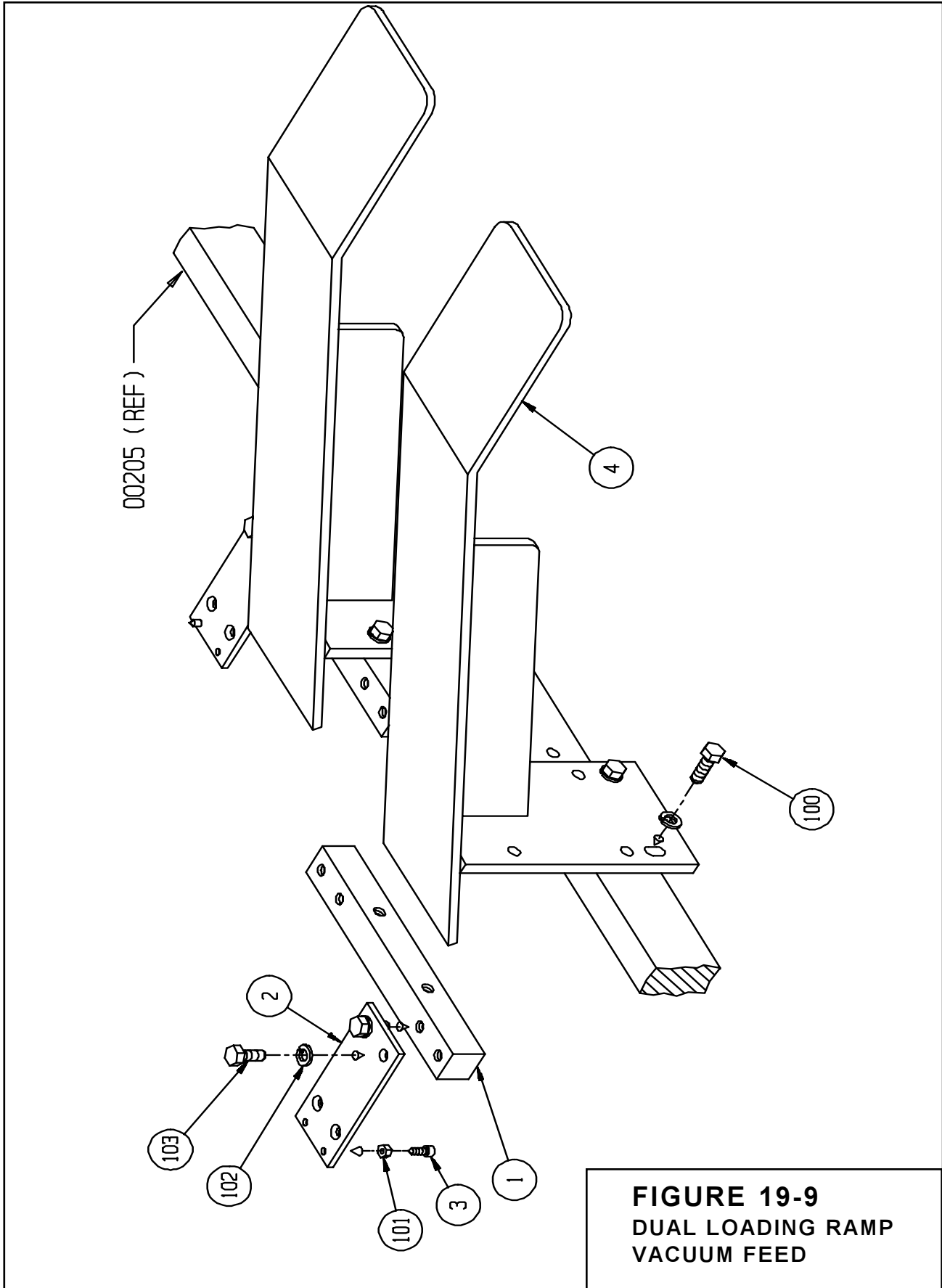


FIGURE 19-9
DUAL LOADING RAMP
VACUUM FEED

Tray Box Former



FIGURE 19-10
OFFSET FLAP
MATT GUIDE

ITEM	PART NO.	DESCRIPTION	QTY.
1	0039502R/L	GUIDE, OFFSET MATT	1/1
2	0207000	SPACER	4
3	0039501	GUIDE, MATT	2
4	0010502R/L	KNIFE, BLANK SUPPORT	2/2
100		#10 STD LOCK WASHER	4
101		#10-32 STD HEX NUT	4
102		5/16-18 HEX HD CAP SCR X 3/4 LG	2
103		5/16 SAE FLAT WASHER	2
104		#10-32 FIBER LOCK NUT	4
105		#10 SAE FLAT WASHER	12
106		#10-32 SCKT FLT HD SCR X 3/4 LG	4
107		#10-32 SCKT FLT HD SCR X 1 3/4 LG	4



Tray Box Former

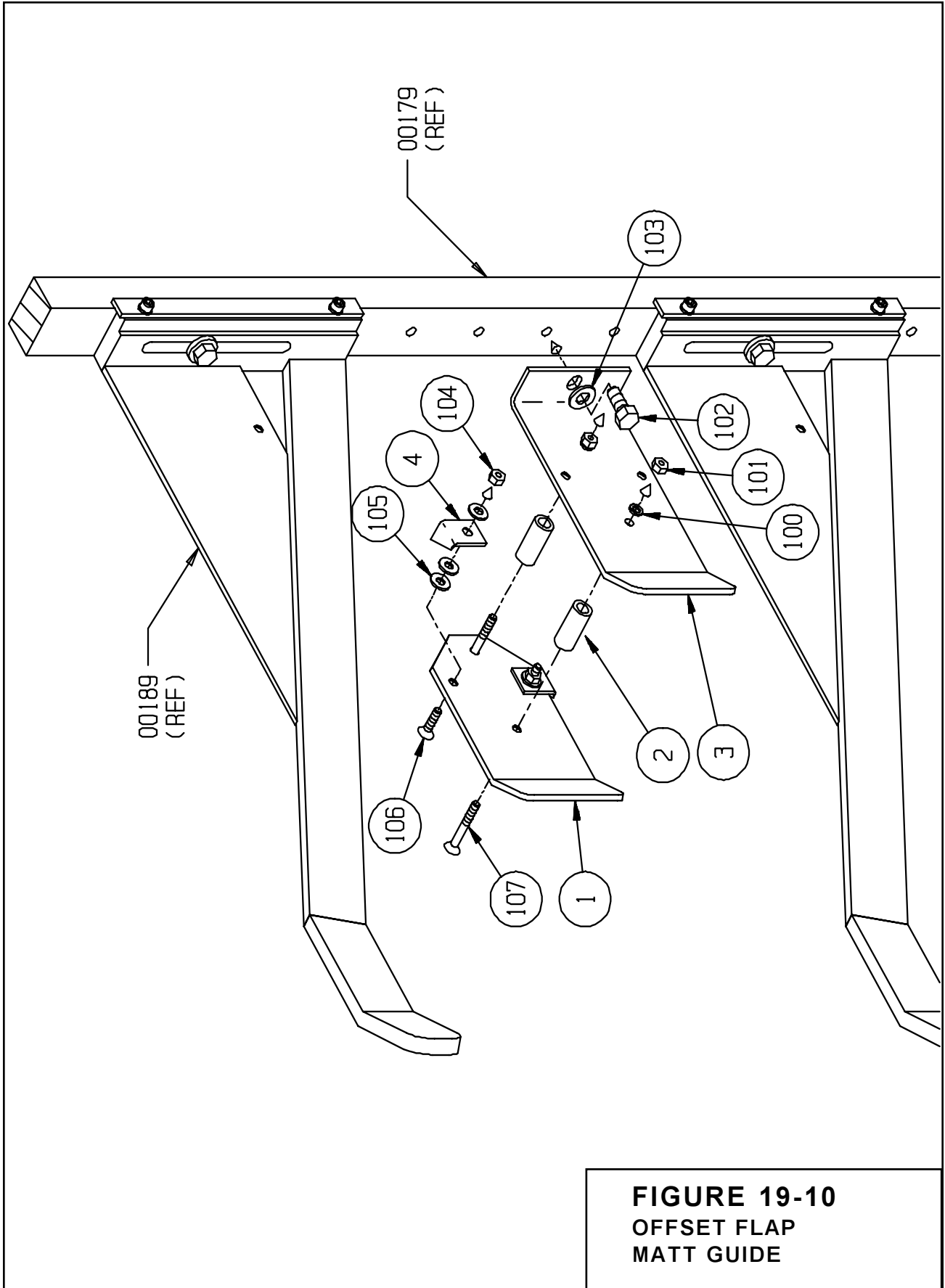


FIGURE 19-10
OFFSET FLAP
MATT GUIDE

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Tray Box Former



FIGURE 19-11
FEED POST ARM ASSEMBLY
CFS - 6" TO 11"

ITEM	PART NO.	DESCRIPTION	QTY.
1	0041301	FEED POST ARM	1
2	9086300	ROD, FORM PLUNGER	1
3	0205900	BUSHING, TUBE YOKE	2
100		1/2-13 HEX HD SCR X 1 1/4 LG	4
101		1/2 STD LOCK WASHER	4
102		3/8-16 HEX HD CAP SCR X 3 LG	1
103		3/8 SAE FLT WASHER	1
104		3/8 STD LOCK WASHER	1
105		3/8-16 HEX NUT	1
106	0100600	SET COLLAR, 7/8"	1



Tray Box Former

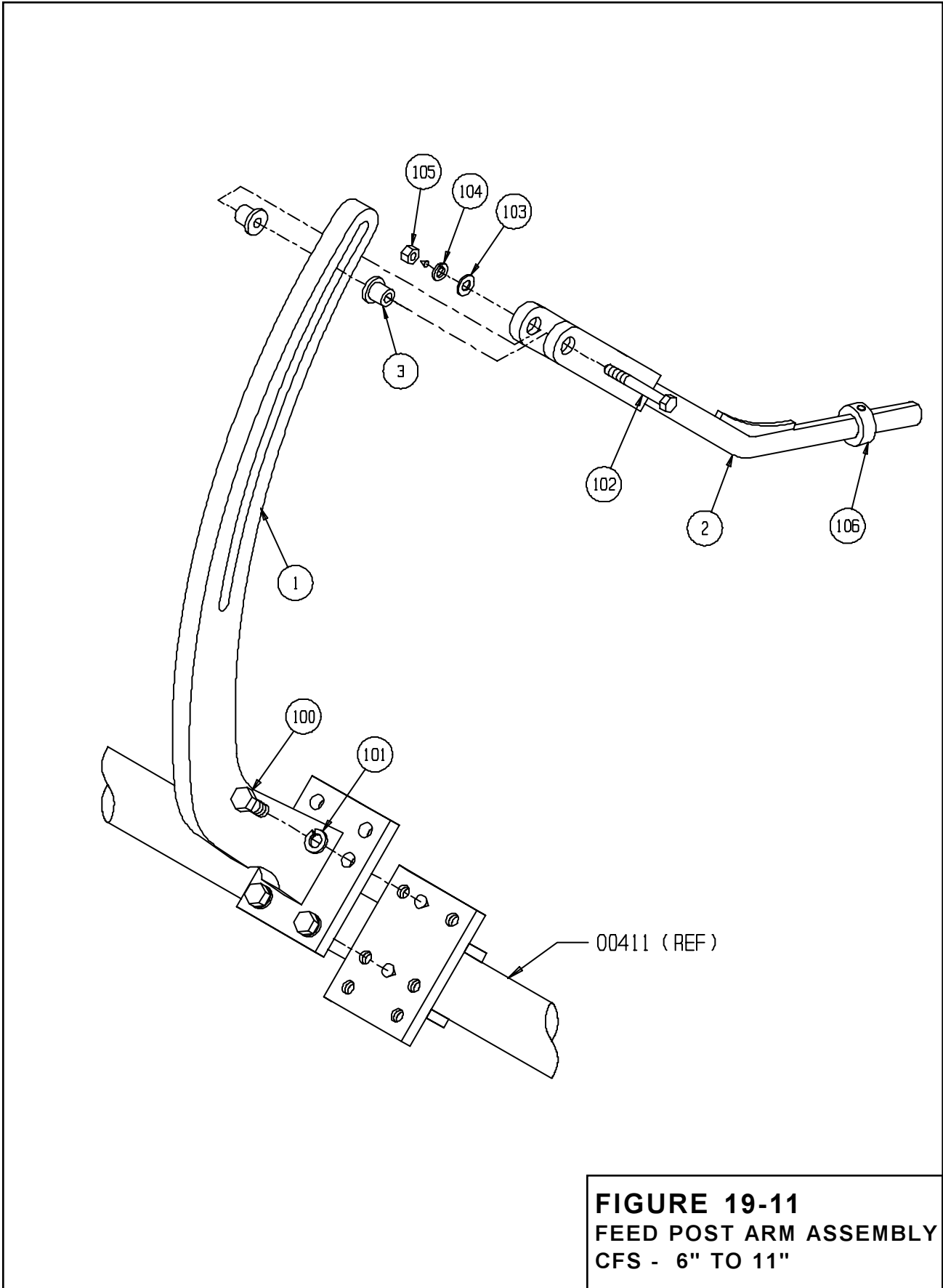


FIGURE 19-11
FEED POST ARM ASSEMBLY
CFS - 6" TO 11"

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