

# EM

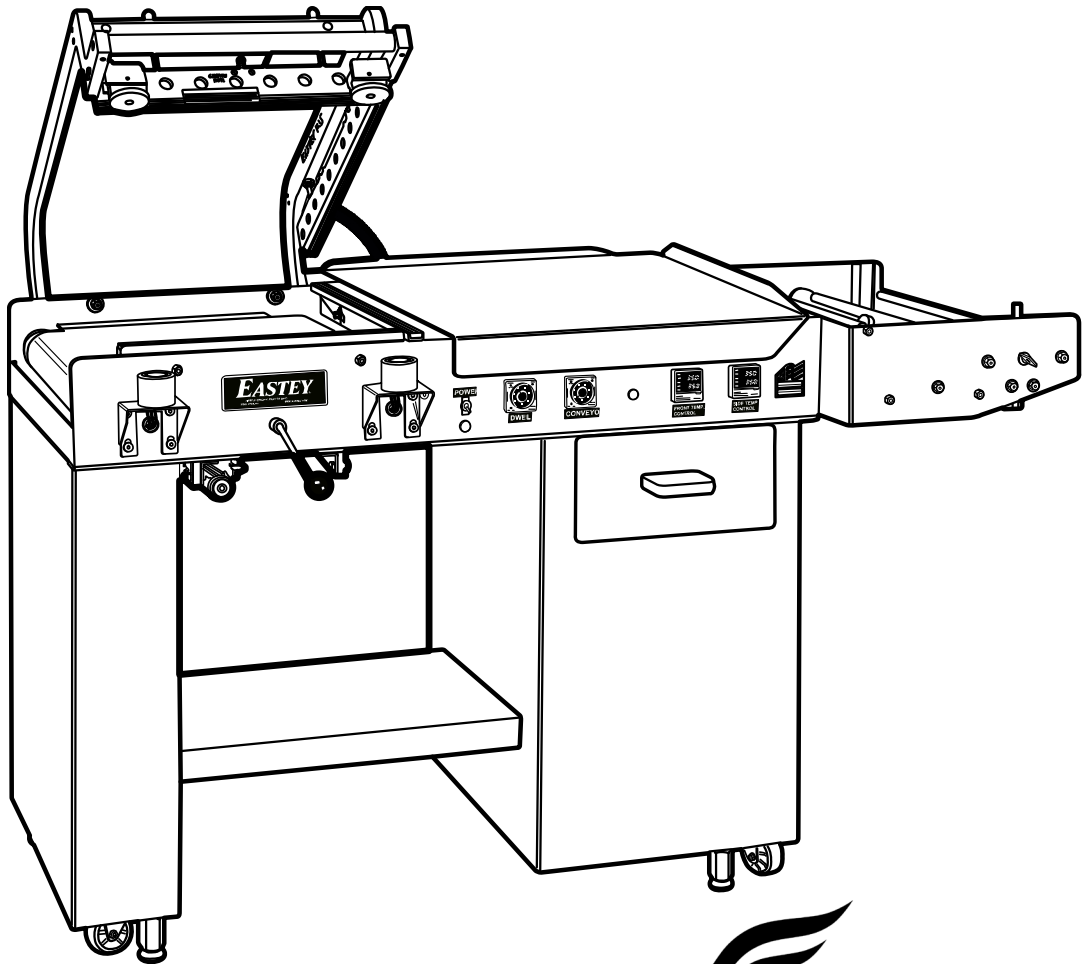
EM2016TK, EM2028TK, EM2040TK, EM2050TK, EM2070TK, EM2080TK,  
EM20100TK, EM3040TK, EM3050TK, EM3070TK, EM3080TK EM30100TK,  
EM4040TK, EM4050TK, EM4070TK, EM4080TK, EM40100TK, EM5050TK,  
EM5070TK, EM5080TK, and EM50100TK

---

---

## Professional Series Semi-Automatic L-Sealers

# User Guide



---

---



**EASTEY**<sup>®</sup>



# EM

EM2016TK, EM2028TK, EM2040TK, EM2050TK, EM2070TK, EM2080TK,  
EM20100TK, EM3040TK, EM3050TK, EM3070TK, EM3080TK EM30100TK,  
EM4040TK, EM4050TK, EM4070TK, EM4080TK, EM40100TK, EM5050TK,  
EM5070TK, EM5080TK, and EM50100TK

# Professional Series Semi-Automatic L-Sealers

## User Guide

Revised 08/02/2022

P/N EM001000 Rev B

### **Copyright and Trademarks**

Copyright ©2015-2022 Engage Technologies Corporation  
All rights reserved. All trademarks and brand names  
are the property of their respective owners.

Eastey  
7041 Boone Ave. N.  
Brooklyn Park, MN 55428

Phone: (763) 428-4846; Fax (763) 795-8867; 1-800-835-9344

**[www.eastey.com](http://www.eastey.com)**



# Contents

<b>Safety</b> .....	<b>7</b>
Safety Precautions .....	7
Explanation of Symbols .....	8
<b>Introduction</b> .....	<b>11</b>
EM Professional Series Semi-Automatic L-Sealer Overview .....	11
Specifications .....	13
Dimensions .....	17
<b>Unpacking</b> .....	<b>20</b>
<b>Installation</b> .....	<b>21</b>
Location Requirements .....	21
<b>Operation</b> .....	<b>25</b>
Control Panel .....	25
Product Tray and Takeaway Conveyor .....	26
Film Unwinder .....	26
Before operating the L-sealer .....	27
Mounting Film .....	27
Sequence of Operation .....	30
<b>Adjustments</b> .....	<b>32</b>
Element Pulse Switch Adjustment .....	32
Electromagnet Position Adjustment .....	33
Seal Pad Pressure Adjustment for Head Return Cylinder .....	33
Timer Adjustment for Dwell Time and Conveyor Run Time .....	34
Temperature Controller .....	35
To Change the Set Value .....	36
Sealer Temperature Controller Settings .....	38
<b>Maintenance</b> .....	<b>39</b>
Routine Maintenance .....	39
Cleaning .....	40
Silicone Rubber and Felt Seal Pad Replacement .....	41
Changing Hot Knife Inserts and Cutting Rules .....	41
Takeaway Conveyor Maintenance and Replacement .....	42
Tracking the Takeaway Conveyor Belt .....	47
Rollers .....	47
<b>Troubleshooting</b> .....	<b>48</b>
Common Issues .....	48
<b>Parts Lists</b> .....	<b>53</b>
Spare Parts .....	53
L-Sealers Parts Lists .....	54
Film Racks for Manual Film Feed Parts Lists .....	137
Powered Film Unwind (PFU) Parts Lists .....	141

Film Inverters Parts Lists.....	144
Electrical Boards .....	146
<b>Appendix A: Electrical Schematics .....</b>	<b>153</b>
Panel Layout.....	153
Electrical Schematic.....	154
Programmable Temperature Controller Connections.....	155
<b>Appendix B: Temperature Setting Specifications for Shrink-Wrap Plastics.....</b>	<b>156</b>
Mushroom Insert .....	156
<b>Appendix C: L-Sealer Size Estimating.....</b>	<b>157</b>
L-Sealer Center-Folded Film Size Estimating Table .....	157
16-inch Side Seal Package Size Estimation.....	158
20-inch Side Seal Package Size Estimation.....	159
30-inch Side Seal Package Size Estimation.....	160
40-inch Side Seal Package Size Estimation.....	161
<b>Warranty Statement .....</b>	<b>162</b>
<b>Customer Support.....</b>	<b>164</b>

# Safety

Read this manual carefully and make it available to everyone connected with the supervision, maintenance, or operation of this machine. Additional copies are available on request ([Eastey.com/contact-us](http://Eastey.com/contact-us)).

The development of a good safety program that is rigidly enforced is absolutely imperative when involved in the operation of industrial equipment. Our machinery is well designed and includes extremely important safety features. Proper installation, safe operation, and regular maintenance and upkeep are of far greater importance than our design. Only properly-trained individuals following rigidly enforced safety rules, as recommended by ANSI and OSHA should be allowed to operate these machines.

Be very careful when operating, adjusting, or servicing this equipment. If in doubt, stop and obtain qualified help before proceeding.

## Safety Precautions

Before installing, operating or servicing this equipment, please read the following precautions carefully:

- Always disconnect electrical power before attempting maintenance for any electrical or moving parts. Do not place hands, head, or any part of the body inside the confines of the machine unless the mechanism is securely fastened and the electrical supply is shut off.
- Do not tamper with electrical wiring. Use only the specified power-supply cable. Use only licensed electricians to check or repair electrical wiring.
- In order to prevent damage to the machinery or injury to personnel, do not increase the factory settings on either the electrical or mechanical overload safety devices. Do not operate a machine if such modifications have been made.
- Keep hands away from moving conveyors and moving parts. Conveyor belts that have become worn or frayed can be hazardous and should be replaced promptly.
- Never operate this or any moving equipment without all covers and guards in place. The internal mechanism of most packaging machinery contains numerous shear, pinch, and in-running nip points, many of which are capable of causing severe injury and permanent disfiguration.
- To minimize the potential for personal injury, always be sure that the machine operators and others working on the machinery are properly trained in the correct usage of the equipment and properly instructed regarding the safety procedures for operation.

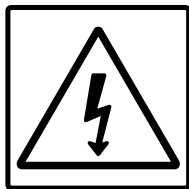
- Heat sealing arms and jaws on packaging machinery can become very hot after a period of use. Keep hands away while in operation and use caution if the machine has been running recently. If optional cutting blades have been installed, these can be very sharp. Exercise caution.
- Do not make any modifications to either the electrical circuitry or the mechanical assemblies of this machinery. Such modifications may introduce hazards that would not otherwise be associated with this machinery. Eastey will not be responsible for any consequences resulting from such unauthorized modification. Do not operate a machine if any modification has been made
- This equipment is designed for indoor operation in a typical clean, dry factory environment. Do not operate the machine in any extremely wet or oily environment that may exceed operating specifications.
- The use of certain types of plastic films in sealing and/or shrink-wrapping equipment may result in the release of hazardous fumes due to degradation of the film at high temperatures. Before using any plastic film in this equipment, the manufacturer or supplier of the film should be contacted for specific information concerning the potential release of hazardous fumes. Adequate ventilation should be provided at all times.
- Keep combustible materials away from this equipment. The equipment may be a source of ignition.
- Do not wear loose clothing such as ties, scarves, jewelry, etc. Long hair should be pulled back and/or covered while operating this machine.

## Explanation of Symbols

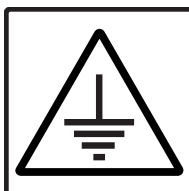


**Caution** sign or Safety Alert symbol. Indicates caution, be alert, Your safety is involved. Knowledge of safe operation is required.

Caution indicates a hazardous situation which, if not avoided, could result in minor or moderate injury or damage to equipment or surroundings.



**Electrical hazard.** Caution electrical shock. No user-serviceable parts inside. Allow only a trained electrician to open the door or cover of the electrical panel or enclosure. Shut off electrical power before attempting to open or perform work inside the electrical panel or enclosure, junction boxes, or other electrical components.



**Ground symbol.** Indicates electrical ground. Ensure that the L-sealer and feed unit are properly grounded. Incomplete grounding could result in electrical shock.





**Heat / burn hazard.** Indicates potentially hot surfaces capable of causing burn injury. Use caution and keep hands clear of hot surfaces such as the seal bars, which require heat to seal and cut the packaging material during operation.



**Electrical hazard.** Indicates potential electrical hazard capable of causing electrical shock or burn. Allow only a trained electrician to access electrical components. Shut off electrical power before attempting to open or perform work inside the electrical panel or enclosure, junction boxes, or other electrical components.



**Entanglement hazard.** Indicates potential for entanglement with moving machine parts capable of causing bodily injury. Keep hands clear of moving parts that can crush and cut.



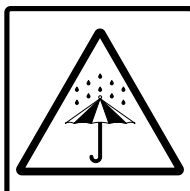
**Pinch hazard.** Keep hands clear. Keep hands clear of the sealing area, as sealing bars can crush hands or arms and cause burn injury.



**Fume hazard.** Fumes may present a health hazard with prolonged exposure. Ensure that the area where the L-sealer is operated has adequate ventilation. Avoid direct inhaling of fumes generated by heated plastic.



**Heavy Lifting hazard.** The L-sealer and power film unwind (PFU) are very heavy. Do not attempt to lift heavy machinery alone. Use proper equipment to lift heavy machinery when required.



**Moisture hazard.** Keep equipment dry. This equipment is designed for indoor operation in a clean, dry factory environment, protected from rain and moisture. Do not operate the machine in any extremely wet or oily environment that may exceed operating specifications.



**Eye Protection.** Wear eye protection when applicable. Use protective equipment whenever circumstances require or when required by regulation or law. Wear safety glasses when operating or servicing this machine requires eye protection.



**Refer to this User Guide** for important safety information and operating instructions to set up, operate, adjust, and maintain this L-sealer



**Warning** symbol. Indicates a hazardous situation which, if not avoided could result in death or serious injury.

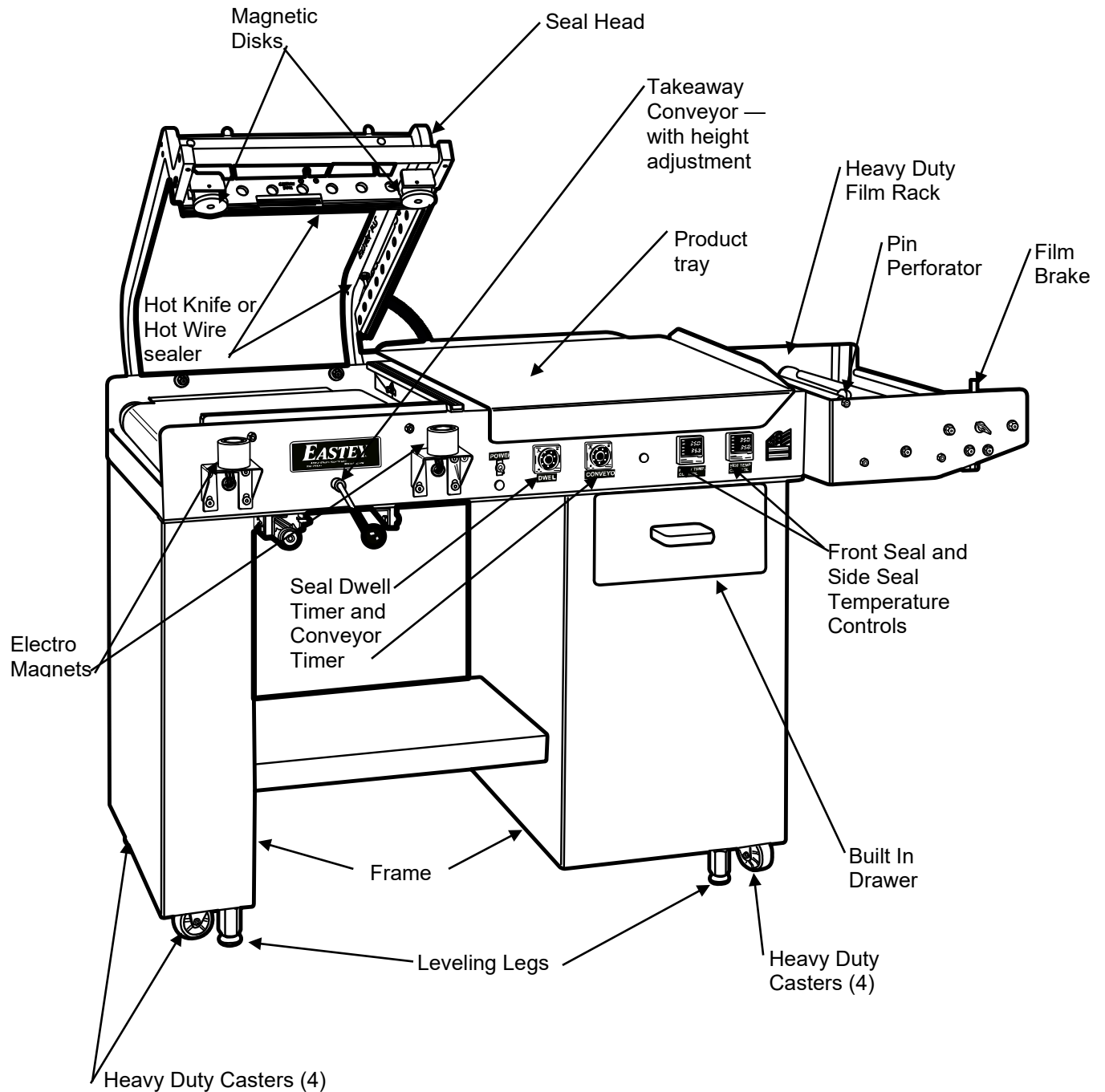
A warning indicates a situation or condition potentially more severe than indicated by a caution message but not imminent as a danger message.

Caution messages on the L-Sealer alert you to potential hazard conditions and are placed near where the hazard indicated exists.

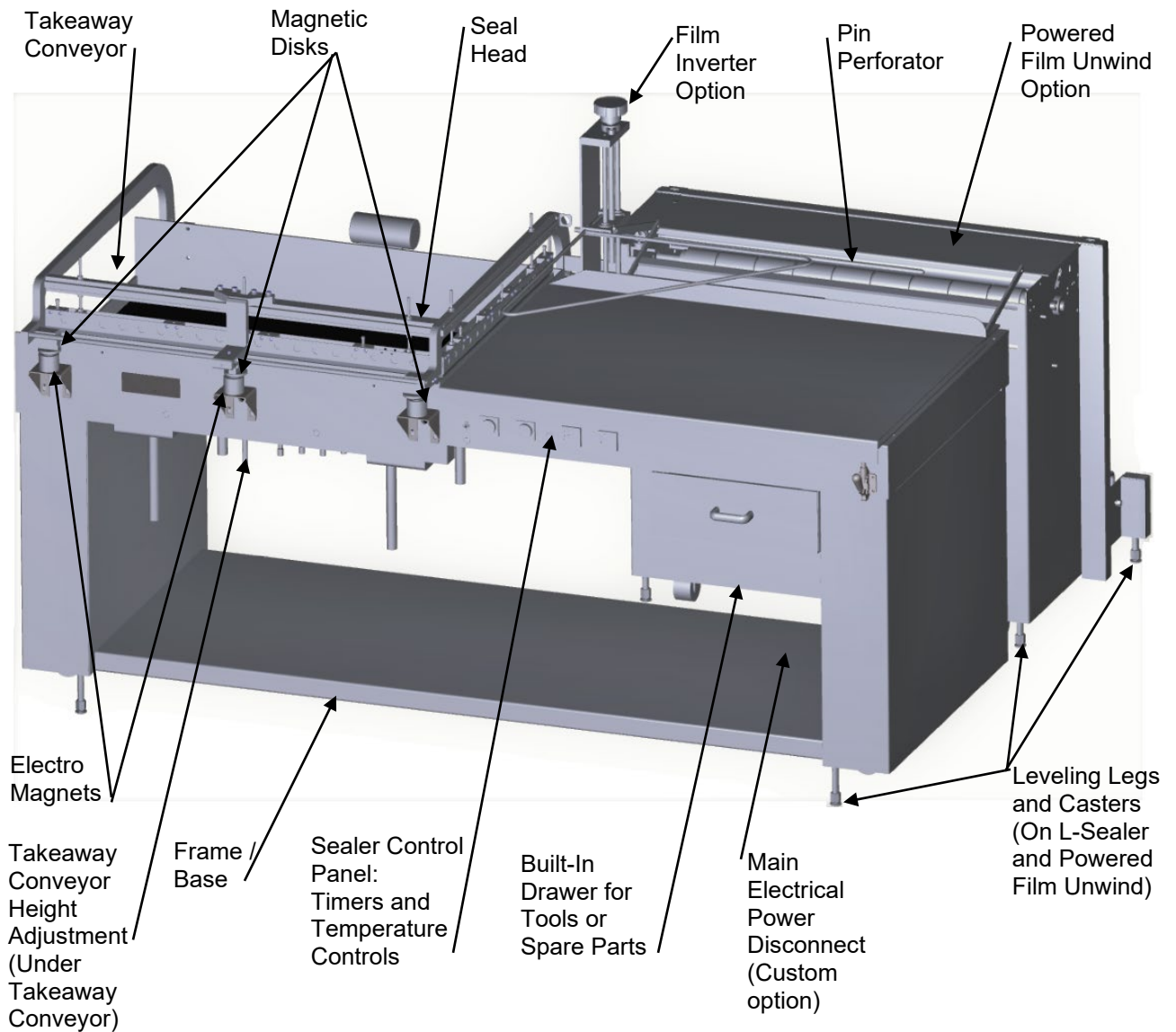
# Introduction

## EM Professional Series Semi-Automatic L-Sealer Overview

Refer to the following illustration to identify the primary functional sections and features of the L-Sealer.



The following illustration highlights the primary functional sections and features on a larger L-sealer model with powered film unwind and equipped with customized electrical options



## Specifications

Model Number	Seal Dimensions		Machine Dimensions			Standard Power			Net	Shipping
	Front (F)	Side (S)	Width (A)	Height (B)	Length (C)	Volts	Amps	Phase	Weight	Weight
EM2016TK	16 in. 41 cm	20 in. 51 cm	34 in. 86 cm	44 in. 112 cm	63 in. 160 cm	220/110	10/20	1	600 lbs. 272 kg	700 lbs. 317 kg
EM2028TK	28 in. 71 cm	20 in. 51 cm	34 in. 86 cm	44 in. 112 cm	84 in. 213 cm	220/110	10/20	1	700 lbs. 317 kg	800 lbs. 362 kg
EM2040TK	40 in. 102 cm	20 in. 51 cm	34 in. 86 cm	44 in. 112 cm	106 in. 269 cm	220	15	1	800 lbs. 362 kg	900 lbs. 408 kg
EM2050TK	50 in. 127 cm	20 in. 51 cm	34 in. 86 cm	44 in. 112 cm	126 in. 320 cm	220	20	1	900 lbs. 408 kg	1000 lbs. 453 kg
EM2070TK	70 in. 178 cm	20 in. 51 cm	34 in. 86 cm	44 in. 112 cm	167 in. 424 cm	220	25	1	1300 lbs. 589 kg	1400 lbs. 635 kg
EM2080TK	80 in. 203 cm	20 in. 51 cm	34 in. 86 cm	44 in. 112 cm	187 in. 474 cm	220	20	1	1500 lbs. 680 kg	1600 lbs. 725 kg
EM20100TK	100 in. 254 cm	20 in. 51 cm	34 in. 86 cm	44 in. 112 cm	227 in. 577 cm	220	20	1	1900 lbs. 861 kg	2000 lbs. 907 kg
EM3040TK	40 in. 102 cm	30 in. 76 cm	43 in. 109 cm	44 in. 112 cm	106 in. 269 cm	220	20	1	1200 lbs. 544 kg	1300 lbs. 591 kg
EM3050TK	50 in. 127 cm	30 in. 76 cm	43 in. 109 cm	44 in. 112 cm	126 in. 320 cm	220	20	1	1300 lbs. 591 kg	1400 lbs. 637 kg
EM3070TK	70 in. 177 cm	30 in. 76 cm	43 in. 109 cm	44 in. 112 cm	167 in. 424 cm	220	25	1	1600 lbs. 728 kg	1700 lbs. 774 kg
EM3080TK	80 in. 203 cm	30 in. 76 cm	43 in. 109 cm	44 in. 112 cm	187 in. 474 cm	220	25	1	1800 lbs. 819 kg	1900 lbs. 861 kg
EM30100TK	100 in. 254 cm	30 in. 76 cm	43 in. 109 cm	44 in. 112 cm	227 in. 577 cm	220	25	1	2100 lbs. 956 kg	2200 lbs. 997 kg
EM4040TK*	40 in. 101 cm	40 in. 101 cm	53 in. 135 cm	44 in. 112 cm	106 in. 269 cm	220	20	1	1700 lbs. 774 kg	1800 lbs. 819 kg
EM4050TK*	50 in. 127 cm	40 in. 101 cm	53 in. 135 cm	44 in. 112 cm	126 in. 320 cm	220	20	1	1900 lbs. 861 kg	2000 lbs. 907 kg
EM4070TK*	70 in. 177 cm	40 in. 101 cm	53 in. 135 cm	44 in. 112 cm	167 in. 424 cm	220	25	1	2100 lbs. 956 kg	2200 lbs. 997 kg
EM4080TK*	80 in. 203 cm	40 in. 101 cm	53 in. 135 cm	44 in. 112 cm	187 in. 474 cm	220	25	1	2300 lbs. 1043 kg	2400 lbs. 1092 kg
EM40100TK*	100 in. 254 cm	40 in. 101 cm	53 in. 135 cm	44 in. 112 cm	227 in. 577 cm	220	25	1	2600 lbs. 1179 kg	2700 lbs. 1229 kg
EM5050TK*	50 in. 127 cm	50 in. 127 cm	63 in. 160 cm	44 in. 112 cm	126 in. 320 cm	220	20	1	1900 lbs. 861 kg	2000 lbs. 907 kg
EM5070TK*	70 in. 177 cm	50 in. 127 cm	63 in. 160 cm	44 in. 112 cm	167 in. 424 cm	220	25	1	2100 lbs. 956 kg	2200 lbs. 997 kg
EM5080TK*	80 in. 203 cm	50 in. 127 cm	63 in. 160 cm	44 in. 112 cm	187 in. 474 cm	220	25	1	2300 lbs. 1043 kg	2400 lbs. 1092 kg
EM50100TK*	100 in. 254 cm	50 in. 127 cm	63 in. 160 cm	44 in. 112 cm	227 in. 577 cm	220	25	1	2600 lbs. 1179 kg	2700 lbs. 1229 kg

\*For larger-size L-Sealers (EM4040 and larger), a Power Film Unwind (PFU) is standard; for smaller size L-Sealers, EM2016 to EM30100, a manual film rack is standard.

## Explanation of Model Numbers

- E = Manufactured by Easteey, division of Engage Technologies.
- M = Manual (Semi-Automated) L-sealer operation. EM model Professional Series L-sealers incorporate an electromagnetic hold-down system that allows the operator to load the next package while the preceding package is being sealed, assuring uniform sealing pressure over the entire length of the seal bars to provide consistent sealing results.
- \_\_ = 20, 30, 40, or 50 — First two digits indicate length of sidebar or nominal maximum length of side seal in inches: 20, 30, 40, or 50-inch sidebars lengths are available.
- \_\_ or \_\_\_ = 16, 28, 40, 50, 70, 80, or 100 — Remaining two to three digits indicate length of front bar or nominal maximum length of front seal in inches: 16, 28, 40, 50, 70, 80, or 100-inch front bar lengths are available.
- T = Takeaway conveyor — Professional Series L-Sealers are typically equipped with a takeaway conveyor. (M = Manual takeaway is an alternative option.)
- K = Knife — Indicates hot knife seal bar. EM Professional Series Semi-Automatic L-Sealers are available in models that utilize hot band or hot knife seal technologies. The scope of this User manual covers the hot knife sealers.
- V \_ = Voltage and Phase. V1 = 220V AC single Phase. All models are available configured for 220 VAC single phase. The smallest models (EM2016T or EM2016TK and EM2028T or EM2028TK) are also available configured for V0 = 110 VAC single phase. See the following table for available AC voltages. Only single phase is offered.

### Voltage and Phase Designator Meaning

Voltage / Phase Designator	Volts	Phase
V0	110	1
V1	220	1

Voltage / Phase Designator	Volts	Phase
V3	380	1
V5	480	1

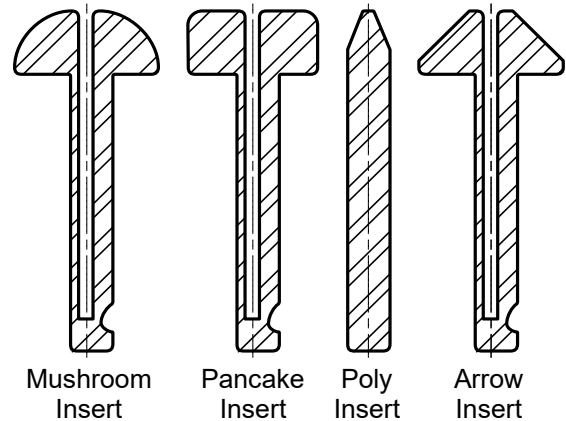
- For units indicated with an asterisk (\*), powered film unwind is included.

**Standard features**

- Designed to seal most polyolefin, polyethylene, and PVC shrink films
- All-welded main frame from ¼-inch cold-rolled steel
- Built in drawer for tools or spare parts
- Seal head casting equipped with head return cylinder
- Stainless steel film clamps hold film in place while sealing
- Available with hot wire or hot knife seal systems
- Hot knife seal systems available with mushroom (standard), pancake, or arrow inserts
- Dual locking magnet clamps apply even pressure across the seal-bar
- Adjustable dwell time for better seal control
- Solid state temperature control adjustable for a variety of films
- Adjustable product tray accommodates wide variety of product sizes
- Takeaway conveyor can be raised or lowered to center the seal with the product
- Automatic takeaway conveyor
- Heavy duty film rack allows for easy changeovers and adjustments
- Adjustable pin perforator provides air evacuation
- Side seal size from 20 in. to 50 in.; front seal size from 16 in. to 100 in.
- Maximum film roll width up to 44 inches
- Maximum film roll O.D. up to 12 inches; 10 inches with power film unwind
- Maximum film roll weight up to 150 lbs. for film rack; up to 100 lbs. each for PFU (PFU allows placement of 2 film rolls, 100 lbs. each, for 200 lbs. maximum combined weight)
- Custom two-part epoxy finish resists scratching
- Heavy duty casters for transportation within plant
- Available in 110V, 220V, or optional 480V
- Easy to use design requires minimal training and maintenance
- Made in the USA

## Options

- Power film unwind – Free-standing 2-roll film racks (10" Max. film O.D.)
- Film inverter — Allows the film to come from behind the machine and pre-opened  
When using an inverter with EM Series Sealers, you will lose 4-½" on the side seal
- Hot knife inserts — Available in mushroom (standard), pancake, or arrow styles (shown at right — check for availability)
- Extended seal bar (hot knife only)
- Variable-speed takeaway conveyor and/or conveyor assist for heavy products
- E-Stop with box and electrical / UL approved electrical and control box
- Product assist with photo eye
- Additional pin perforator wheel for film rack or PFU
- Stainless steel and left-hand models available
- Lower conveyor (2" maximum)
- Custom product guides and/or product tray



## Wear Parts and Consumables

As part of regularly scheduled maintenance of the EM Professional Series Semi-Automatic L-Sealer, it is expected that certain parts will undergo wear under normal use and require replacement at regular intervals.

- For example, electrical fuses are designed to self-destruct to help protect users and internal electrical components of the machine to interrupt the flow of electricity in the event of an electrical overflow or short-circuit. As such, it is expected that fuses will blow at some time and require replacement.
- Belts, PTFE tape and coatings and UHMW plastic components will see wear through daily use and require replacement at some time in the course of regular maintenance.
- Similarly, cutting rules and inserts and sponge rubber pads of the sealing area wear through normal use and will require replacing. Heater cartridges and heatsinks are also replacement items.

It is recommended to keep a supply of spare wear parts and replacement items to reduce the likelihood of long durations of machine downtime when time comes to replace them.



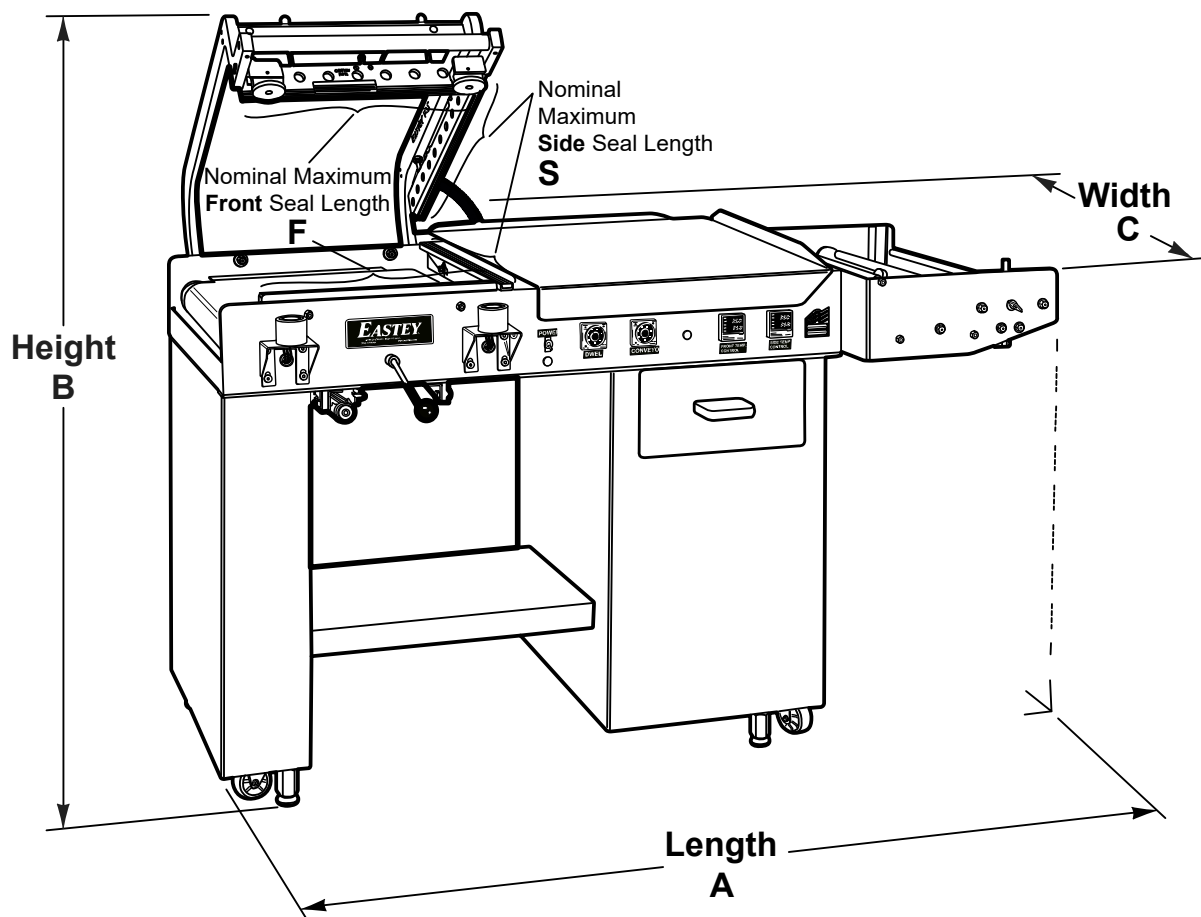
The following parts of the L-sealer are considered wear parts or consumables and it is recommended to keep spare items of these on hand.

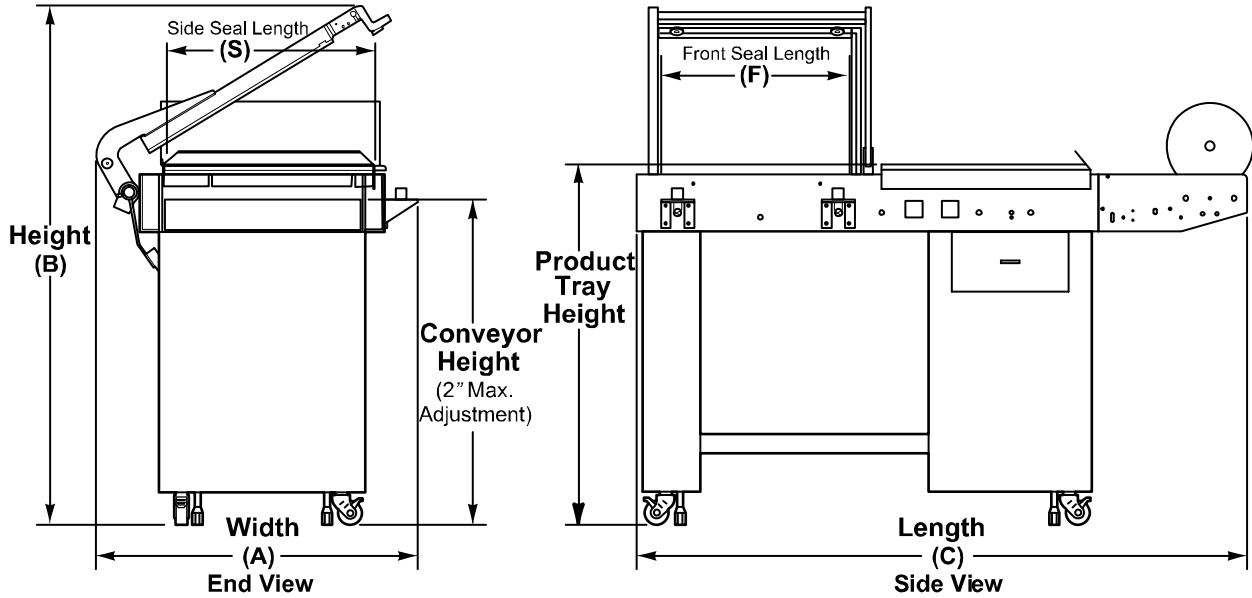
- Electrical fuses and heatsinks
- Hot knife cutting rules — specify L-sealer model number to determine knife cutting rule size / length when ordering
- Inserts (Mushroom, Pancake, Poly or Arrow) — specify L-sealer model number to determine insert type and size when ordering
- Sponge rubber pads for lower seal area — Available in 20 ft. rolls
- PTFE tape — Available in ½" 10 mil, ¼" 10 mil, and 2" 2 mil

More complete information about specific recommended spare parts can be found in the Parts section of this User Guide.

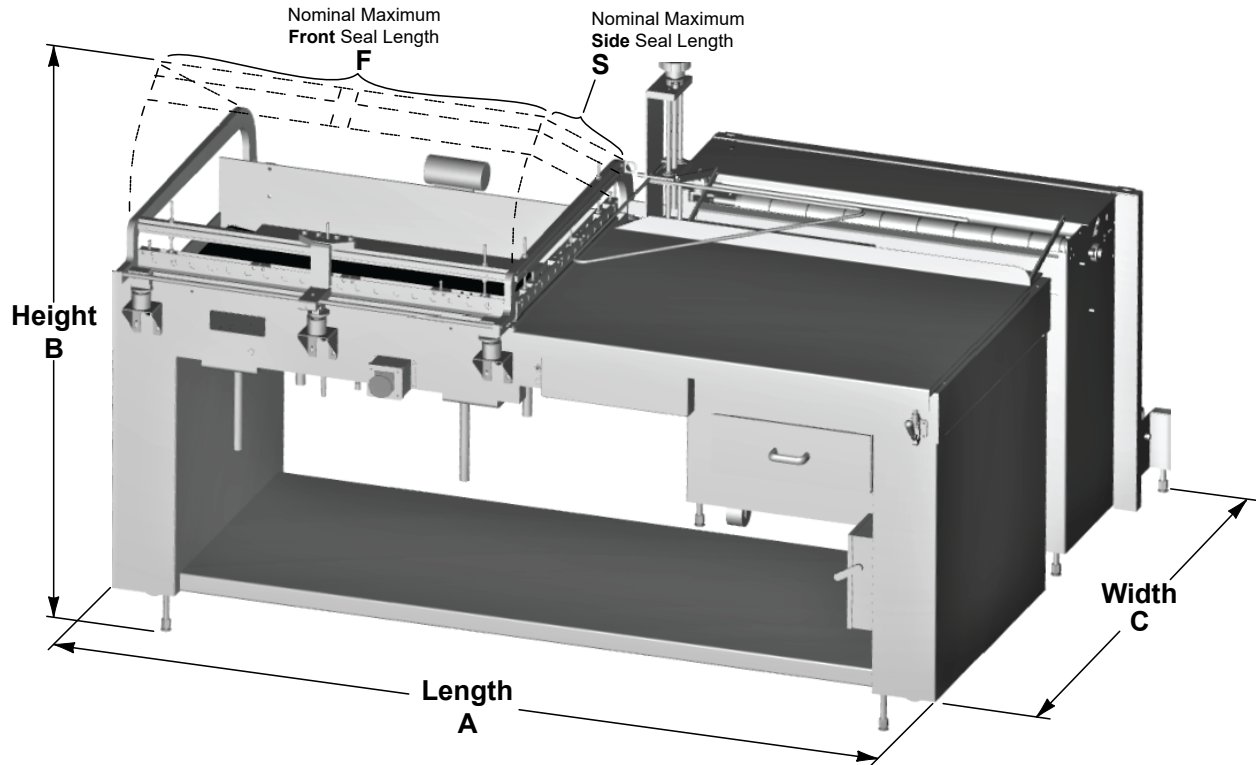
## Dimensions

See Machine Dimensions in Specifications table for overall machine width, height, and length. Drawings on the following pages show dimensions as they apply for L-sealer models of different sizes.



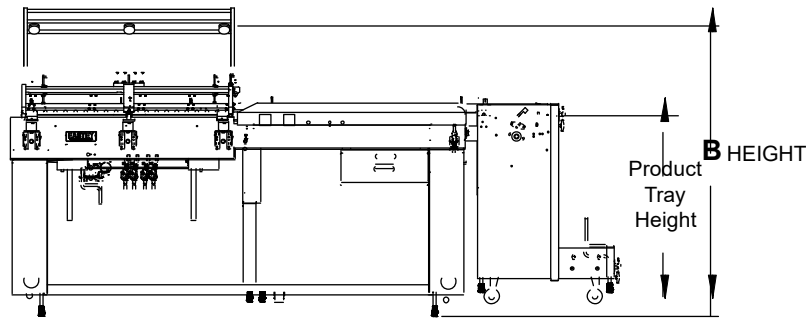
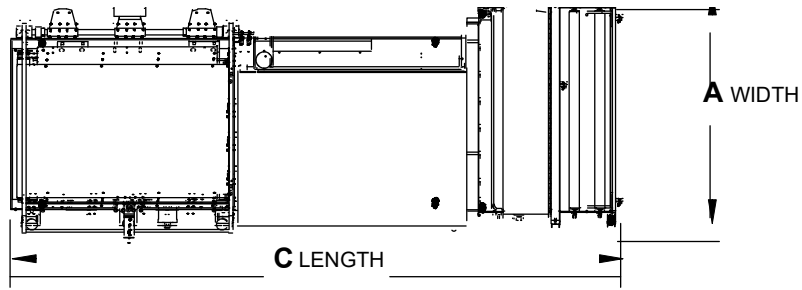


The following illustration and drawing show dimensions as they apply for intermediate and larger-size models of L-sealers, which are equipped with power film unwind (PFU). This example also shows a film-inverter that allows the film to make a right-angle turn off the PFU at the rear. When selecting an EM series L-sealer with an inverter, consider adding an additional 4-½ inches to the side seal for the film inverter.

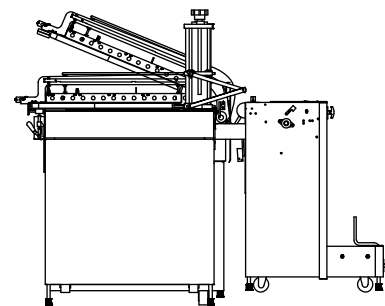
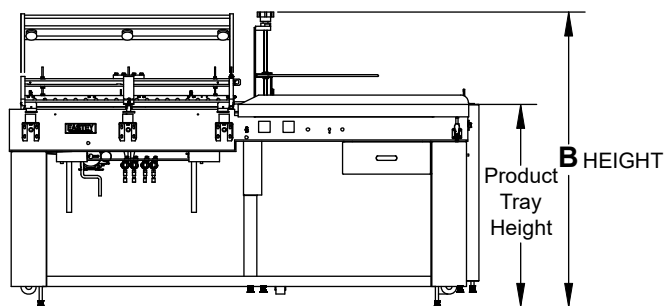
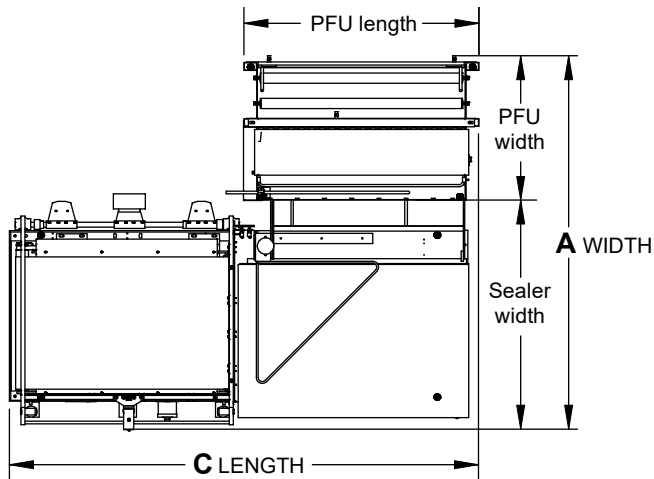


The following dimensional drawings show two configurations of the L-Sealer with PFU.

Configuration with PFU at end of L-Sealer Product Tray — Film Inverter Not Required



Configuration with PFU Behind L-Sealer Product Tray — Requires Film Inverter



# Unpacking

Thoroughly inspect the equipment and packaging immediately on arrival.

Carefully remove the outer protective shipping wrapper. Inspect the machine for any damage that may have occurred during transit. If goods are received short or in damaged condition, it is important that you notify the carrier's driver before they leave your company and insist on a notation of the loss or damage across the bill of lading. Otherwise no claim can be enforced against the transportation company. Please note that a copy of this document is attached to the outside of every crate.

If concealed loss or damage is discovered, notify your carrier at once and request, **insist**, on an inspection. This is absolutely necessary. A concealed damage report must be made within ten (10) days of delivery of shipment.

Unless you do this, the carrier will not entertain any claim for loss or damage. The agent will make an inspection and grant a concealed damage notation. If you give the transportation company a clear receipt for the goods that have been damaged or lost in transit, you do so at your own risk and expense.

We are willing to assist you in every reasonable manner to help you collect claims for loss or damage. However, this willingness on Eastey's part does not make Eastey or its parent or related companies responsible for collections or claims or replacement of equipment damaged or lost in transit.

## Loading and Unloading Instructions

- Air-Ride suspension and shipping straps are required for transportation of sealers.
- When transporting the sealer, roll the machine into the truck or trailer, and then when the machine is in position for shipping, lock the locking casters.
- Use shipping straps to restrain the sealer securely so it will not shift in transit.

# Installation

Lift the machine up and off of the shipping pallet.

**CAUTION!** The EM series L-sealer is heavy and will require a forklift, floor crane, or several people to move safely off the shipping pallet. Use proper equipment when lifting the L-sealer and ensure it is secure and will not shift while being moved off the shipping pallet.

Place the sealer in the desired location with the required electrical power source available. (See power requirements for the specific model in the Specifications table.) The L-sealer is shipped without a power cord, and a power cord (with optional electrical plug) must be supplied by the customer at installation and should be installed by a licensed electrician. Make sure the electrical wiring is adequate to provide the required voltage. If the voltage provided is too low, the equipment will not operate correctly.

Selecting the proper location is one of the most important considerations for initial setup. When selecting the location, take into consideration the following factors.

1. Adequate power supply nearby?
2. Where is the sealer in relation to the power source?
3. Where is the sealer in relation to the tunnel and any conveyor(s) necessary to move the wrapped product? (Alignment with packaging line.)
4. Convenience for the operator.
5. The surface on which equipment is located must allow level operation.

If there is any doubt, get qualified assistance with your initial installation.

## Location Requirements

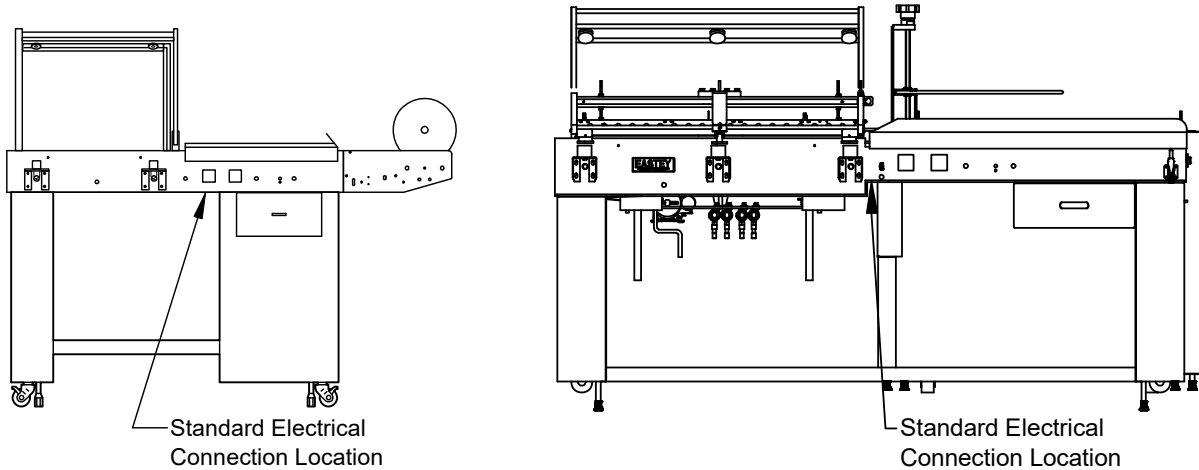
When installing the L-sealer please be aware of the following considerations:

1. The surface where the L-sealer is located must flat, level, and clear of debris.
2. Conveyor or packing table height.
3. Alignment with packaging line.

When the L-sealer is positioned in the operating location you will need access to:

1. Control panel switches: On/Off switch, dwell timer, conveyor timer.
2. Height and width adjustments.
3. Film unwinder.

Electrical connection for the L-sealer is located near the center of the machine, standard. The L-sealer is shipped without a power cord, and a power cord (with optional electrical plug) must be supplied by the customer at installation. Power cord length must be such that it will reach from the power outlet to connect at the center of the machine. Power must be installed by a licensed electrician.

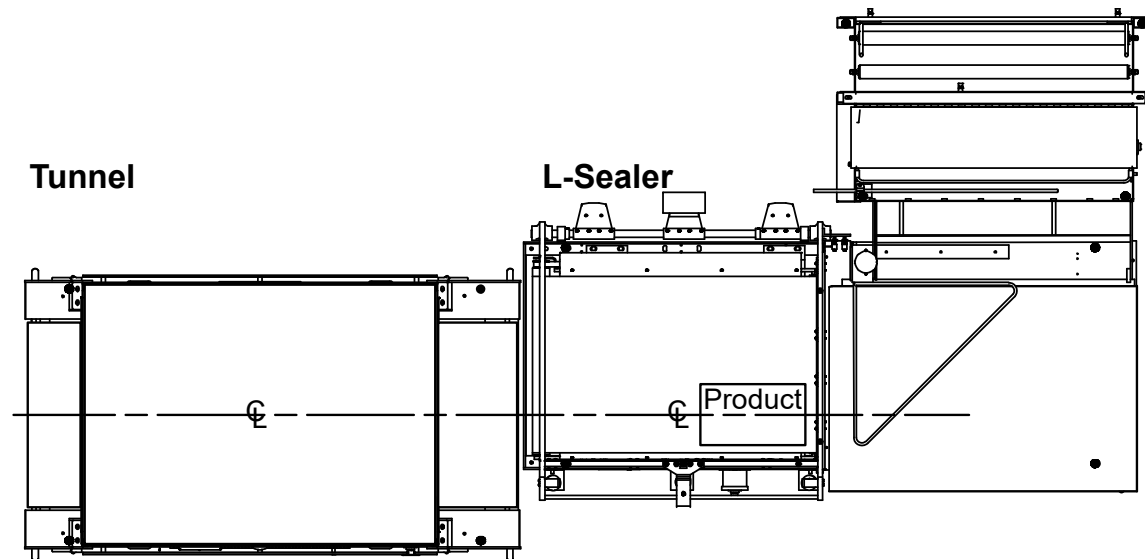


For units equipped with a takeaway conveyor at the exit of the L-sealer, provision should be made for exiting packages. For example, a table or bin where packages that have been sealed will be placed until they can be picked up, or a conveyor that will move them to the tunnel.

If the L-sealer is part of a longer packaging line, take into consideration the table and conveyor height in relation to adjacent machinery. In many applications, a tunnel will be placed so that the intake conveyor of the tunnel is fed directly from the takeaway conveyor of the L-sealer.

### **Correct tunnel placement to the L-sealer**

When planning for the location of the L-Sealer and tunnel, the tunnel must be placed at the exit of the takeaway conveyor, with the centerline of the tunnel aligned with the centerline of the takeaway conveyor. The L-sealer and tunnel conveyors need to have a small gap between them so they do not touch but must be placed close enough so product is transferred effectively from the takeaway conveyor to the tunnel conveyor, and does not fall through or become jammed between conveyors.



The machine should be placed on a flat, level floor so that it does not rock or move. We recommend that the machine be securely locked in place when used.

Set up the L-sealer and move it to its location. The casters allow easy movement over smooth flat surfaces. If you need to lift the unit to move it, you will need to use a pallet jack, floor crane, or forklift to move it to its location.

**CAUTION!** If the L-sealer must be lifted for moving, use proper equipment when lifting and moving it to ensure it is secure and will not shift.

When the L-sealer has been moved to its location, use the leveling legs to level the L-sealer and adjust it to its final height. The L-sealer must be level in both the machine direction and the transverse direction.

**VIDEO: Adjusting the leveling legs to level the L-sealer**

To see a video to guide you through adjusting the leveling legs to level the L-Sealer, click this link: <https://www.youtube.com/watch?v=0IzdKXEwekA> or scan the QR code at right using the camera app on your mobile device.



A power cord (with optional electrical plug) must be installed by a licensed electrician. Unless the L-sealer is equipped with an optional electrical control box, the standard electrical connection location is at the end of the control panel toward the conveyor, as shown in the illustration on the previous page.

**CAUTION!** Before operating, ensure the following.

1. All shipping ties are removed.
2. All personnel are clear of the equipment.
3. Electrician has stated that all electrical work is complete.
4. Adjust all controls according to the settings sheet.

If the L-sealer is to be equipped with a power film unwind (PFU), connect the PFU to the L-sealer.

**VIDEO: Connecting the Power Film Unwind to the L-sealer**

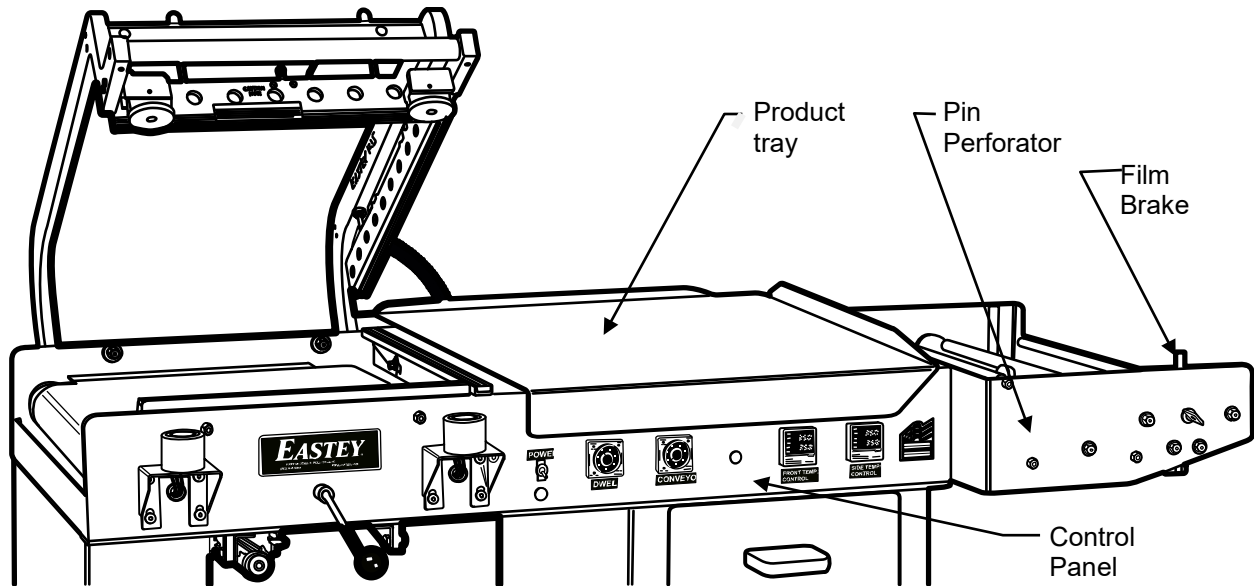
To see a video to guide you through connecting the PFU to the L-sealer, click this link: <https://youtu.be/5OeCngvxjHA> or scan the QR code at right using the camera app on your mobile device.



Follow instructions in the Operation section to power up and operate the machine and for shutting it down.



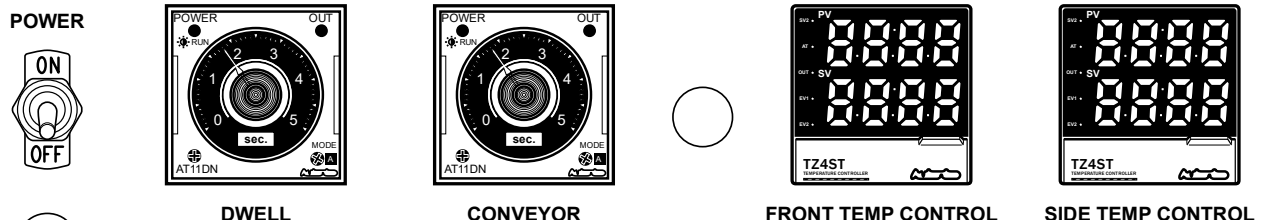
# Operation



## Control Panel

### VIDEO: L-Sealer Control Panel

To see a video explaining controls of the L-sealer control panel shown below, click this link: <https://youtu.be/bzbNQqwcAWg> or scan the QR code at right using the camera app on your mobile device.



Controls for the L-sealer are located along the front side of the frame under the product tray. Controls from left to right are listed below.

**Power** — Toggle switch to toggle L-Sealer power on or off.

**Dwell** — Timer setting for seal. (Duration of activation of seal arm electromagnets).

**Conveyor** — Timer setting for conveyor. (Length of time the conveyor will run for each item.)

**Front Temp Control** — Setting and current temperature display for front seal.

**Side Temp Control** — Setting and current temperature display for side seal.

**CAUTION!** When the power is turned on be aware of sealer hot surfaces and moving belts and rollers.

## Product Tray and Takeaway Conveyor

### Product Tray

The product tray is the adjustable metal platform used to separate the film and to facilitate insertion of the product between the bottom and top layers of film. It is adjustable to achieve proper depth equal to the total width of the package, thereby allowing the product to be placed precisely at the center-fold of the film each time.

### Takeaway Conveyor

The height of the takeaway conveyor is adjustable. To adjust the height of the takeaway conveyor, use the crank located along the front of the L-Sealer centered between the seal head actuating electromagnets.

#### **VIDEO: Product Tray and Conveyor Height Adjustment**

To see a video to guide you through adjustments of the product tray and takeaway conveyor of the L-sealer, click this link: <https://youtu.be/vSomykWk6IA> or scan the QR code at right using the camera app on your mobile device.



## Film Unwinder

### Pin Perforator

The pin perforator is located between the lower idler rollers of the film rack or at the top just before the pinch rollers of the power film unwind and is completely synchronized with the seal arm. It creates holes in the film (to allow air to escape during shrinking). The pin perforator is adjustable and must be properly placed in relation to the depth of the desired package. The positioning of the pin perforator should always be reviewed when changing the machine for a different size product or different size film. It is adjusted by the adjustment knob attached to the bottom of the film rack. The pin perforator is mounted inside the film rack of the machine to avoid dropping or damaging and so it is mounted out of the way.

### Film Brake

The film brake is positioned at the front end of the rack rollers and creates a drag that maintains tension on the film as the film is dispensed. The operator should from time to time re-check the setting of the film brake for proper tension. The film brake's purpose is to reduce overruns or slack in the film.

## Before operating the L-sealer

- Verify the electromagnets are functioning properly.
- Verify the cutting rule corner is set properly.
- Verify the cutting rules are coming up to temperature.

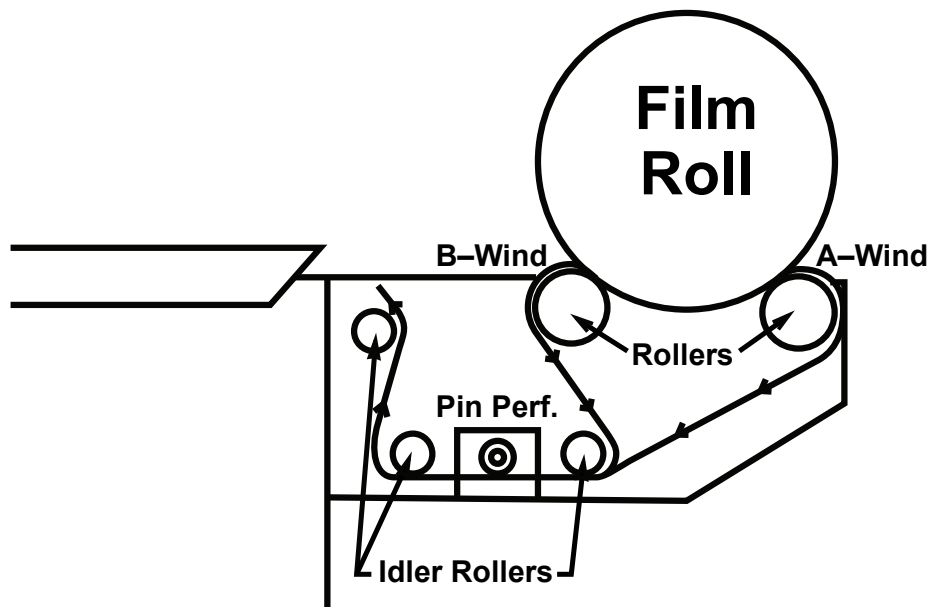
## Mounting Film

### Standard Rack-Mount (Unpowered) Film Unwinder

Select the proper width of center-fold film for the product being packaged, taking into account the width and height of the package. With the package properly positioned within the film in the sealing area, allow sufficient film to overlap the sealing bars so that a seal can easily be made without possibility of openings due to insufficient film coverage.

Place the film roll on the rollers of the rack-mount film unwinder. Place the center-fold away from the operator, to the back of the machine. Position the film roll on the rollers and tighten the upright bolts on the film rack collars to hold the film roll in position.

### Film Path for Standard Rack-Mount (Unpowered) Film Unwinder



Decide whether the film is an A or B wind, and then thread it through and around the idler rollers and the pin perforator. (See the following illustration.) When threading the film, make sure to pull excess film through the rollers, across the product tray and into the sealing area to ensure sufficient film to begin. When you have threaded the film, separate the top film from the bottom and insert the product tray between the film top

and bottom. Make sure that the center-fold of the film is at the back of the product tray. This allows the operator to insert product on the product tray between the top and bottom layers of film to prepare to move the product and film into the sealing area. Do not place product in the first few bags formed by the sealer: they will not have any perforation holes in them (because the sealer and pin perforator work together). Perforation is required to allow air to vacate when the product passes through the shrink tunnel.

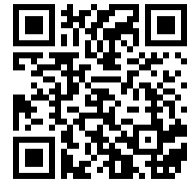
Begin inserting product into the film as soon as the film reaching the seal area has perforations in it. Place the product against the back of the film separator tray and then move product into the seal area. Be sure to leave the bag loose around the product when making the seal. This helps keep the seals from blowing out in the shrink tunnel. See Sequence of Operation, which follows, for more detailed instructions for operating the L-sealer.

### **Optional Powered Film Unwinder**

(With Double Film Rack for use with Inverting Head)

#### **VIDEO: Power Film Unwind Loading Film and Operation**

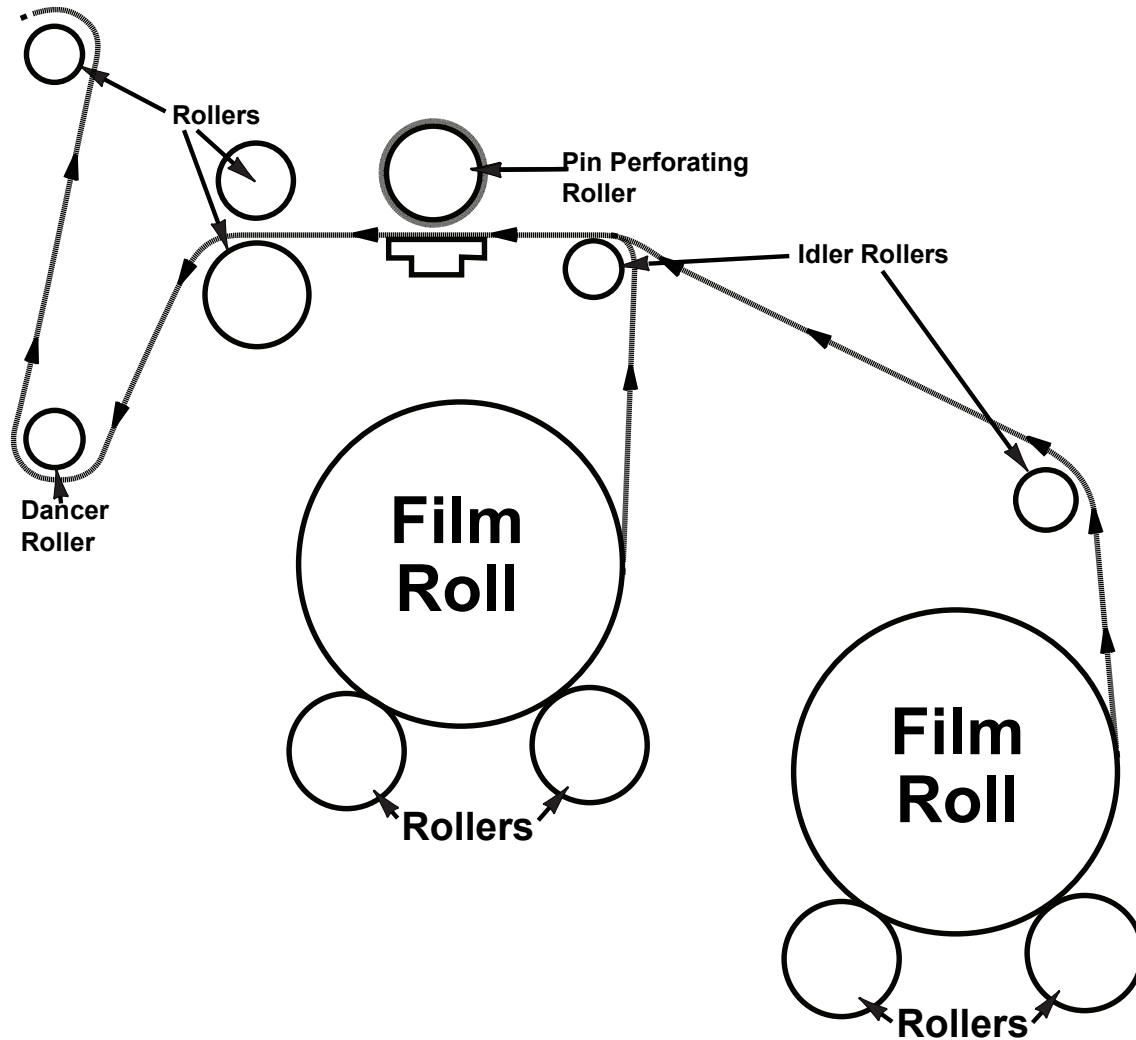
To see a video showing operation of the PFU with inverter on a similar sealer (in this example, part of a combo unit), click the following link: [https://www.youtube.com/watch?v=l3Wlmk0gv\\_I](https://www.youtube.com/watch?v=l3Wlmk0gv_I) or scan the QR code at right using the camera app on your mobile device.



Use the following steps when using the optional Eastey power film unwinder and inverter. These steps must be taken to ensure proper tracking of the film.

1. Set the inverting head to desired opening one-half inch (1/2") taller than the package. See the illustration on the following page. The final roller and film separator rod should automatically adjust the film direction toward the center of the inverting plow. For example, if the package is six inches (6") high, the film should be directed three inches (3") above the loading tray coming off the power film unwind.
2. Invert film around the inverting head. Standing in front, facing the machine, move the loading tray out of the way. Pull film toward you, feeding it off the unwinder with the folded edge on the right. (Put the bottom layer of film under lower inverting plate. Put top layer of film on top of upper inverting plate.) With your right hand, push film between inverting head plate and loading tray as it enters the seal area.
3. Adjust takeaway conveyor height so that the seal is in the center of the package top to bottom. The objective is to use equal amounts of film for the top and bottom. If the package is six inches (6") high, the takeaway conveyor should be three inches (3") below the lower seal pads.

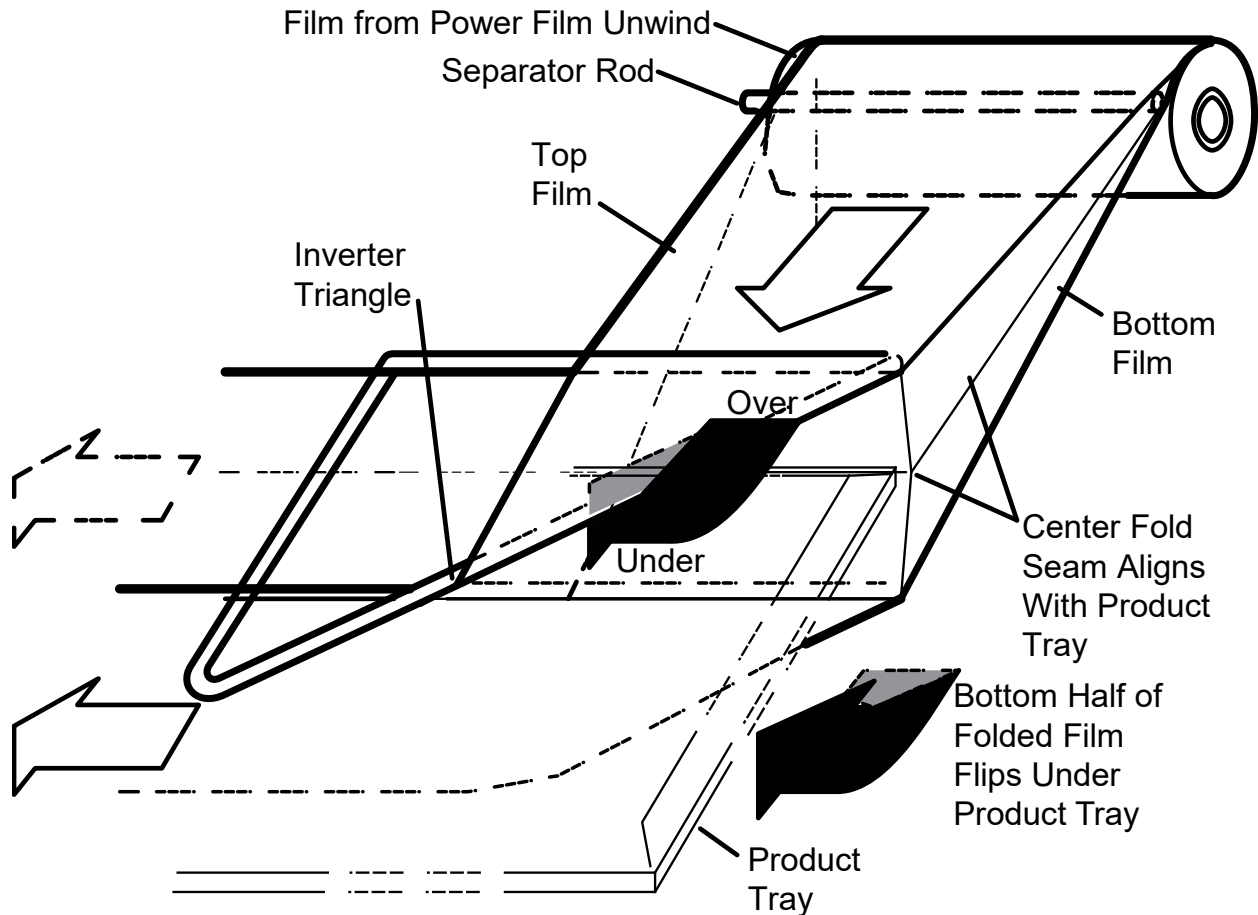
### Film Path for Optional Powered Film Unwinder



### Optional Film Inverter

The optional film inverter allows the power film unwind to be positioned behind the product tray of the L-sealer. Instead of being fed from the end past the product tray, the film is fed from the power film unwind in back of the product tray and the film is routed to fold over the product tray and film inverter triangle to, in effect, make a right-angle turn while inverting the film.

See the following illustration for how to invert the film around the inverter triangle and behind the product tray to make the right-angle turn required to route it into the sealing area.



## Sequence of Operation

With the film threaded according to the previous instructions for rack feed or power film unwind, allowing front and side seal bars to come up to temperature for the film type in use, visually verify the sealing corner is set correctly and compensator is functioning to keep the heating element sealing band or knife tight.

If an initial practice seal has not been made to form the leading seal for the bag, run a practice seal to check operation and create the leading seal.

1. Place the product on the product tray and with the left hand, slide the product to the upper left corner formed by the folded rear edge and previously-sealed edge at the left.
  - The product tray separates the film, allowing you to place the product between the upper and lower layers of film, with the film fold at the rear.
2. Still using the left hand, move the package and film into the lower right corner of the sealing area and then slightly back away from the corner formed by the sealing

bars to allow some slack film between the package and the sealing bars. Remove hands from the sealing area.

**Caution:**      **Move hands out of the seal head area! DO NOT rest hand on the lower seal surface or have arms or hands inside the sealing area while bringing the seal head down.**

3. With hands clear of the seal bars and seal head area, use the handle of the seal head pull the seal head down. Let go of the handle as soon as the magnets activate.

- The magnets hold the seal head down for the amount of time required to make the seal. The amount of time is adjustable from one (1) to five (5) seconds and is indicated on the Dwell timer indicator, which is located closest to the Power switch under the product tray.
- While the magnets are holding the seal head down, it is not necessary to wait. Prepare the next item to be sealed, placing it on the product tray between upper and lower layers of film.

**NOTE:**      **If there is too much tension on the film while the bag is being sealed, the seals will be more likely to be weak or blow out in the seal area while moving through the shrink tunnel.**

4. Once the seal is formed completely, the seal head automatically releases. The sealed product is removed by the takeaway conveyor, and the next Item can be moved into position for sealing.

- The takeaway conveyor runs for the specified amount of time required to move the sealed product onward out of the sealing area. The amount of time the conveyor runs is adjustable from one (1) to five (5) seconds and is set using the Conveyor timer dial, which is located next to the dwell timer indicator under the product tray.

**NOTE:**      **The takeaway conveyor runtime should be set so the conveyor runs for just long enough for the sealed package to clear the end of the conveyor before it stops running.**

# Adjustments

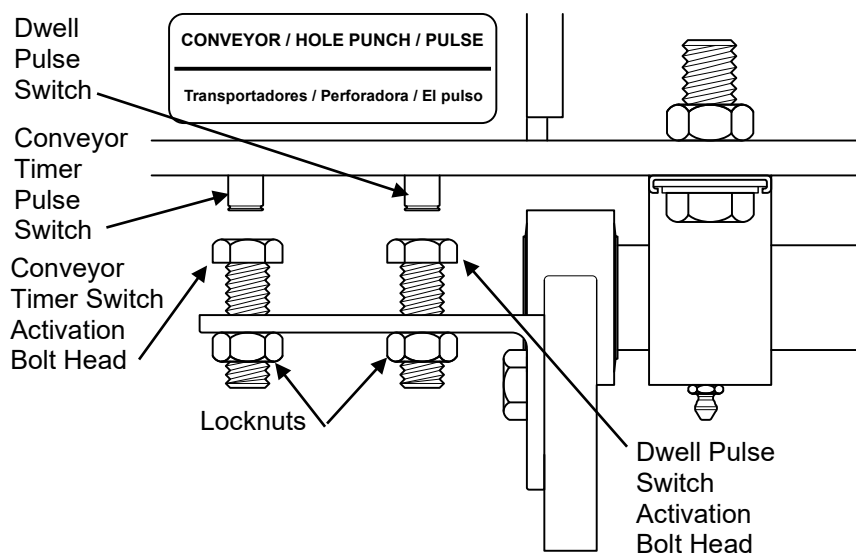
Shut off power and disconnect electrical connections before making any adjustments.



**WARNING:** Unless otherwise specifically stated, before performing any adjustments, maintenance, or repairs, power off the system, disable the power source, and do the same for all connected equipment consistent with logout/tagout best practices. See <https://www.osha.gov/control-hazardous-energy> or scan the QR code at right using the camera app on your mobile device.



## Element Pulse Switch Adjustment



The sealing cycle should not begin until the seal head is within one-eighth inch ( $\frac{1}{8}$ " or less of the film to be sealed. If the magnets energize before the head is within one-eighth inch of the film, loosen the locknut and turn the screw (located at the rear of the side seal bar) up slightly (counter-clockwise as viewed from above). Adjustment has been set correctly when the magnets are energizing just as the seal bar comes into contact with the lower magnet pads.



## Electromagnet Position Adjustment

### VIDEO: Magnet Position and Seal Head Pressure

To see a video to guide you through adjustments of the electromagnet position and seal head pressure, click this link: <https://youtu.be/KbRhI8BzkbA> or scan the QR code at right using the camera app on your mobile device.



All magnets have been factory adjusted for equal sealing pressure throughout the length of both the front and the side seal bars. If an adjustment is required, however, use the following procedure.

1. Disconnect the L-sealer power plug from the electrical power source.
2. Loosen the lower magnet screws on all of the lower magnets so the magnets settle to the lowest position in the mounting slots.
3. Lower the L-sealer operating handle fully and lift the lower magnets to within the thickness of a nickel from the holders.
4. Re-tighten the mounting screws securely to retain the proper adjustment.

## Seal Pad Pressure Adjustment for Head Return Cylinder

Uniform pressure between the sealing elements and the sealing pads must always be maintained in order to obtain an even seal and to prevent heating-element hotspots and premature burnout. The adjustment should be checked periodically and should always be checked when sealing gaps occur.

1. Disconnect the sealer power plug from the electrical power source.
2. Supporting the seal head in the up position, loosen the four set screws for the head return cylinder. Gently lower the seal head to rest on the lower seal pads.
3. With the seal head resting on the lower pads, shim up the film clamps so that the inserts are resting on the lower pads. Make sure there are no air gaps, and then tighten the head casting bolts.
4. Adjust magnets. (See **Electromagnet Position Adjustment**, above.)
5. Go to the rear of the L-sealer. Make sure the head cylinder is straight from front to back. Pull the air cylinder bracket the full length of the air cylinder. Tighten the  $\frac{5}{16}$ -inch set screws.
6. Cycle the seal head up and down. Adjust set screws on head return cylinders for proper head speed and cushion.

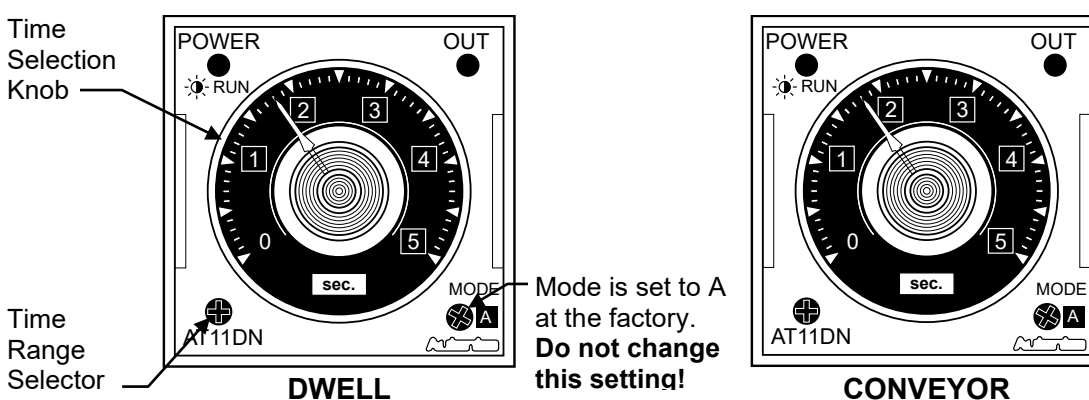
## Timer Adjustment for Dwell Time and Conveyor Run Time

### VIDEO: L-Sealer Dash Panel Controls

To see a video explaining controls of the L-sealer control panel shown below, click this link: <https://youtu.be/bzbNQgwcAWg> or scan the QR code at right using the camera app on your mobile device. The first two minutes of the linked video provides information about the timers and adjustments.



Timers for the seal head dwell time and conveyor run time are typically set for the application from the manufacturing facility, and do not require adjustment unless they require change for product size or film type or have somehow been moved out of adjustment.



Each of the speed control timers for the dwell and conveyor have an adjustable potentiometer. The adjustment knobs for the pots are transparent with the indicator needle visible attached inside and the numbers and fractional markings are visible inside through the face of the knob. Turn the knob to increase or decrease the speed as necessary, aligning the needle with the number of seconds for the timer to run, whether it is the dwell time for the seal head or run time for the takeaway conveyor.

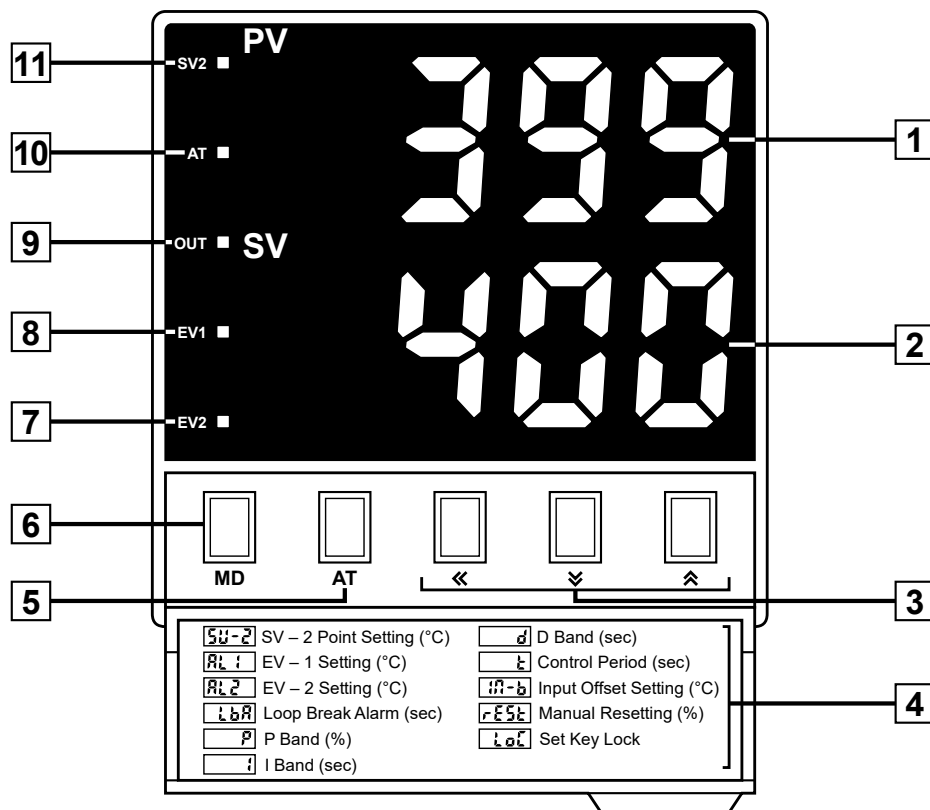
The time range, units (sec., min., hour, etc.), and range of numbers that appear in the dial, can also be changed if required for longer or shorter time intervals. The time range selector is the small adjustment at the lower left of the adjustment knob. It requires a small screwdriver to turn the time units/scale selector. Rotate the time range selector only in the clockwise direction. Time range can be set from 0.5 seconds, selectable from 0.05 to 0.5 seconds, minimum up to 10 hours, selectable from 1 to 10 hours. Most applications will typically be in the range between one and three seconds or one and four seconds.

Time Setting Range	Time Increments	Maximum Time Setting
0.05 – 0.5 sec	0.05 sec	0.5 sec
0.1 – 1.0 sec	0.1 sec	1.0 sec
0.5 – 5 sec	0.5 sec	5 sec

Time Setting Range	Time Increments	Maximum Time Setting
1 – 10 sec.	1 sec	10 sec
0.05 – 0.5 min	0.05 min (3 sec)	0.5 min
0.1 – 1.0 min	0.1 min	1.0 min
0.5 – 5.0 min	0.5 min	5 min
1 – 10 min	1 min	10 min
...	<b>hours &amp; 10s of hours</b>	...

The small adjustment at the lower right of the speed knob is the Mode selector. The mode selector is preset to A at the manufacturing facility and should not be changed. If the mode has been changed to any mode other than mode A, use a small screwdriver to turn the mode selection clockwise to return it to mode A.

## Temperature Controller



1. PV = Processing value (red in color).
2. SV = Setting value (green in color).
3. Back (←, shift display key), down (⇩), and up (⇧) keys.
4. Programming key access door — Open to access programming keys.

5. AT key: the mode key to execute Auto Tuning function.
6. MD key: the mode key to change items to be set, such as set value, etc.
7. EV2: Event 2 output signal lamp.
8. EV1: Event 1 output signal lamp.
9. OUT: Output signal lamp.
10. AT: Signal lamp flashes while unit is auto-tuning.
11. SV2: Signal lamp for SV2 set value.

## To Change the Set Value

1. Press the left-arrow (◀) button and a digit will begin to flash. The flashing digit indicates the digit whose value can be changed by pressing the down- (▼) or up-arrow (▲) buttons.
2. If necessary, press the left- (◀) or right-arrow (▶) to shift to the place of the digit that needs to be changed. (The digit to the left or right will begin flashing.)
3. Press up (▲) or down (▼), as required to change the flashing digit to the required value.
4. Repeat instructions 2 and 3 above as necessary until all digits have been set to the required value, and then press the MD button. No digits will be flashing, the new value entered is applied.

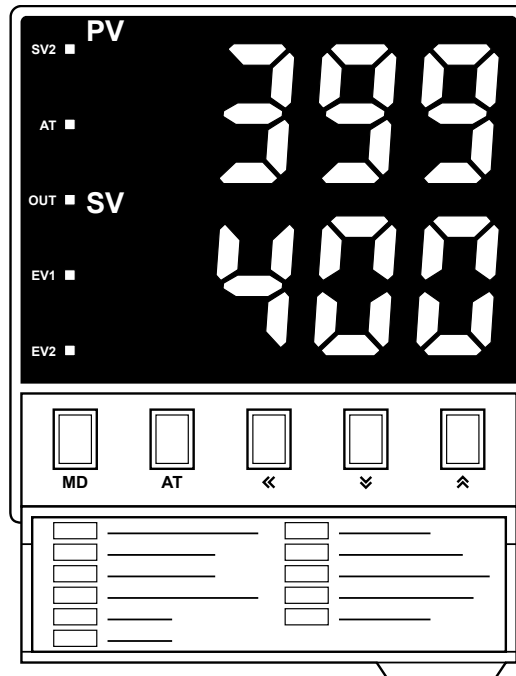
## To Change the Set Value for Over Temperature

Over temperature is factory set to 450° F, but can be adjusted if required for your sealing application.

PV, the Process Value is the actual temperature reading at the sealing elements. PV and SV are mentioned in this procedure, but they are only displayed at the beginning of the procedure.

1. Press and hold the MD button until SV-2 is displayed.
2. Press the MD button (do not hold it down) repeatedly to scroll through the menu until LOC is displayed.
3. Press the left-arrow (◀) button. (ON will begin flashing.)

4. Press the down-arrow button (⇩). (ON will turn to OFF and OFF will be flashing.)
5. Press the MD button. (OFF will stop flashing.)
6. Press MD again. (This will bring you back to SV-2.)
7. Press MD again until AL-1 is displayed.
8. AL-1 is set to 450°.



## Over Temperature Alarm Setting

1. Press and hold the MD button for approximately three (3) seconds.
  - IN-T is displayed.
2. Press and hold the MD button and up-arrow (⇧) buttons at the same time for three (3) seconds to activate the menu. Scroll to LOC and press the left-arrow (⇐) button. On will begin flashing. Press the down-arrow button (⇩). On will turn to Off and press the MD button until LOC appears, indicating that the Off setting is locked.
3. Press the MD button until EU-1 appears (Event 1). Below EU-1, AL-6 should appear. If not, use the up and down buttons to select AL-6.
4. Now return to LOC and change it to On.

5. Press and hold both the MD and up-arrow (⤴) buttons at the same time for three (3) seconds to access the other menu.
6. Scroll through the menu using just the MD button and turn LOC Off.
7. Scroll through the menu until AL-1 appears. This is your high alarm. The normal factory setting is 450°.
8. Return to LOC and change it to On.

## Sealer Temperature Controller Settings

Unless custom settings are required for a specific application, these are the default settings for the sealer that are set at Eastey before the unit is shipped. These settings are shown here for reference to allow returning the L-sealer to the factory default settings if any settings have been changed.

To view or change settings, press and hold the MD and up-arrow (⤴) buttons at the same time for three (3) seconds. This brings you to the first menu. Pressing MD cycles through each setting. To return to the main menu, press and hold MD for approximately 5 seconds. To access the second menu, press and hold MD for 5 seconds, and then press MD to cycle through each setting.

In-t=== JIC.H	SU-2=== 32
EU-1=== AL-6	AL1=== 450
EU-2=== AL-0	APHYS=== 2
AL-t=== AL-A	P=== 9.5
AT.t=== tun1	I=== 48
Pidt=== Pidt.F	D=== 12
o-Ft=== HEAT	t=== 4
Unit=== F	In-b=== -4
H-SC=== 450	Rest=== 0.0
L-SC=== 32	Loc=== on
Ramp=== off	
LoC=== On	

# Maintenance

The Eastey EM Professional Series Semi-Automatic L-Sealer will provide many hours of maintenance-free operation. There are a few items that may require attention from time to time.



**WARNING:** Unless otherwise specifically stated, before performing any adjustments, maintenance, or repairs, power off the system, disable the power source, and do the same for all connected equipment consistent with logout/tagout best practices. See <https://www.osha.gov/control-hazardous-energy> or scan the QR code at right using the camera app on your mobile device.



**CAUTION!** When cleaning the machine, use only a clean cloth, lightly dampened if necessary, to clean exterior surfaces. Use a ball of accumulated scrap sealing film to clean the seal heads occasionally as required.

**DO NOT splash water or other fluids on or into the machine. (The machine is not designed or built for waterproof function.) Do not use wire brushes, steel wool, wood blocks, etc., to attempt to clean the L-sealer. Using these will cause damage or premature wear and will VOID ALL WARRANTIES.**

## Routine Maintenance

Following are recommendations for routine maintenance, daily and monthly.

### Daily

- Clean the seal head hot bands or hot knife blades. Check upper and lower seal areas for melted or scrap film or dirt and clean as required.
- Ensure no parts are broken or missing from the upper and lower seal areas. Replace as needed.
- Check the conveyor for worn or torn belt or broken parts. Repair as needed.
- Check for smooth easy operation of seal head hinge mechanism. Apply grease to fittings to lubricate hinge bearings at rear of L-sealer as required.
- Check the conveyor height adjustment mechanism. Lubricate chain and screws as required.
- Check power cord and wiring for wear and loose connections.
- Check for loose fasteners.

## **Within First Two Weeks of Machine Installation or When Conveyor Has Been Replaced, and Then As Needed**

- Visually inspect the conveyor belt tracking. Adjust conveyor tracking screws if necessary to true the conveyor and bring it into alignment.

## **Monthly**

- Check the conveyor for worn or torn belt or broken parts. Repair as needed.
- Check power cord and wiring for wear and loose connections.
- Check upper and lower seal head parts for excessive wear. Replace worn or broken parts as required.
- Check conveyor belt for worn or torn belt or broken parts. Replace as required.

## **Cleaning**

The machine will require cleaning occasionally.

1. After daily operation, carefully wipe the sealing cutter clean with a ball of accumulated scrap sealing film.
2. When cleaning the machine, use only a clean cloth, lightly dampened if necessary, to clean exterior surfaces. Use a ball of accumulated scrap sealing film to clean the seal heads occasionally as required. DO NOT splash water or other fluids on or into the machine. (The machine is not designed or built for waterproof function.)
3. Avoid contact with liquid acid or gas, or other corrosives.

## **Cleaning Cutting Rules and Inserts**

### **VIDEO: Cleaning the Hot Knife Inserts and Cutting Rules**

To see a video to guide you through cleaning the cutting rules and inserts, click this link: <https://youtu.be/ewqetFAhh38> or scan the QR code at right using the camera app on your mobile device.



To clean the seal head cutting blades and inserts, the best material to use is accumulated scrap film. Clean the cutting rules and inserts while they are still hot, about 370° F (133° C). Form a handful of scrap film into a wad and rub it against the blade and insert and any bits of film or debris should stick to the scrap film.

Alternatively, if scrap film is unavailable, the next best option is to use a lightly-dampened clean cloth and use it in the same way to clean the blades and inserts when the seal head is cool.



Never use abrasives on the cutting rules or inserts, as these will cause premature wear or damage. The PTFE coating on the blades and surfaces is similar to the non-stick coating used on pots and pans and cooking utensils. If the coating is scraped off, the film will start sticking to the seal heads. The blades and inserts should be black in color. If you notice that they are silver, it is time to replace them.

## Silicone Rubber and Felt Seal Pad Replacement

Occasionally it will be necessary to replace the silicone rubber or felt sealing pads. Seal pads are designed with a channel to make them easy to install and replace. Seal pads should be replaced if the following symptoms are observed.

- Gaps in the seal
- Weak seals
- Improper film cutoff
- Excessive sealing pressure required

### VIDEO: Replacing the Lower Seal Pads

To see a video to guide you through replacing the lower seal pads, click this link: <https://youtu.be/P4M0Q2KmkE> or scan the QR code at right using the camera app on your mobile device.



To replace a silicone rubber or felt pad, pull the old pad out of the channel, and replace with the new silicone rubber or felt pad, pressing it into place in the channel. Take care to not stretch the silicone rubber while installing.

**NOTE:** Some silicone rubber pads come covered in talcum powder. If so, clean the pads with a mild solvent.

## Changing Hot Knife Inserts and Cutting Rules

### VIDEO: Changing the Hot Knife Inserts and Cutting Rules

To see a video to guide you through changing the hot knife inserts and cutting rules, click this link: <https://youtu.be/UupAgyfPh0Y> or scan the QR code at right using the camera app on your mobile device.



1. Disconnect the L-sealer power plug from the electrical power source.

**CAUTION!** Always be aware of the cutting edges while replacing the knife edges. Handle the knife blades carefully.

**CAUTION!** If the machine was in operation and the seal heads are hot, wait a few minutes to allow the blades to cool down.

2. Remove the #10-32 screws holding the inner side film clamp and remove the #10-32 screws holding the outer front film clamp.

**NOTE: One #10-32 screw is behind the aluminum arm casting. This does not need to be removed. Push the product tray in all the way. Swing the film clamp down and to the right over the product tray, then pull it out and rest the film clamp on the product tray.**

3. Remove the #8-32 flat head screw on both side-seal and front-seal bars.
4. Remove the insert and cutting rule, both at the same time.
5. Place the replacement cutting rules into the new inserts, both at the same time, ensuring that the beveled edge is in the corner. (When purchased as a subassembly, cutting rules are already installed.)

6. Push the beveled edges together.

**NOTE: The inside beveled edges of the cutting rule need to come together. The outsides do not. Be sure the cutting rules are touching.**

7. Install the #8-32 flat head screws, but do not tighten them at this point.
8. Heat the seal bar up to the set point.
9. Adjust insert and cutting rule if they separate at the corner.
10. Tighten the #8-32 flat head screws while the seal bars are hot.
11. Turn off heat and allow the sealer to cool down, and then reinstall film clamps.

## **Takeaway Conveyor Maintenance and Replacement**

From time to time, it will be necessary to disassemble the conveyor when it requires an adjustment for a different product size or if worn parts need to be replaced or for general maintenance. Instructions provided in this user guide are very general. If these generalized instructions do not address your specific conveyor issue, contact a certified representative of Eastey or contact Eastey directly ([Eastey.com/contact-us](http://Eastey.com/contact-us)).

### **Replacing the Takeaway Conveyor Motor**

**NOTE: This procedure requires an Allen or hex wrench, and a 7/16-inch box-end wrench.**

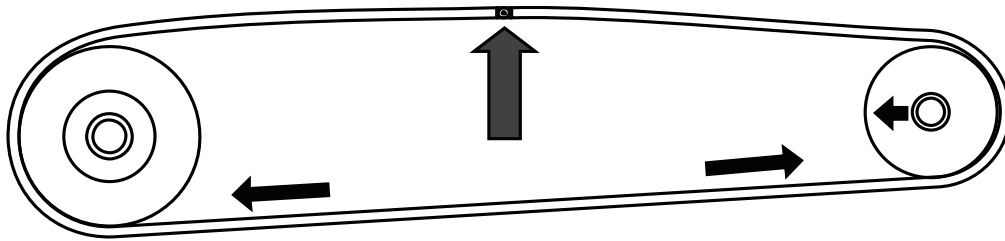
1. Turn off machine power; turn machine Power switch to Off position. Disconnect the L-sealer power plug from the electrical power source.
2. Disconnect wires # 14 and # 16 ground from inside the panel and pull them out. Note the color of wires and where they are connected.

**NOTE: Wiring color connections to the conveyor motor.**

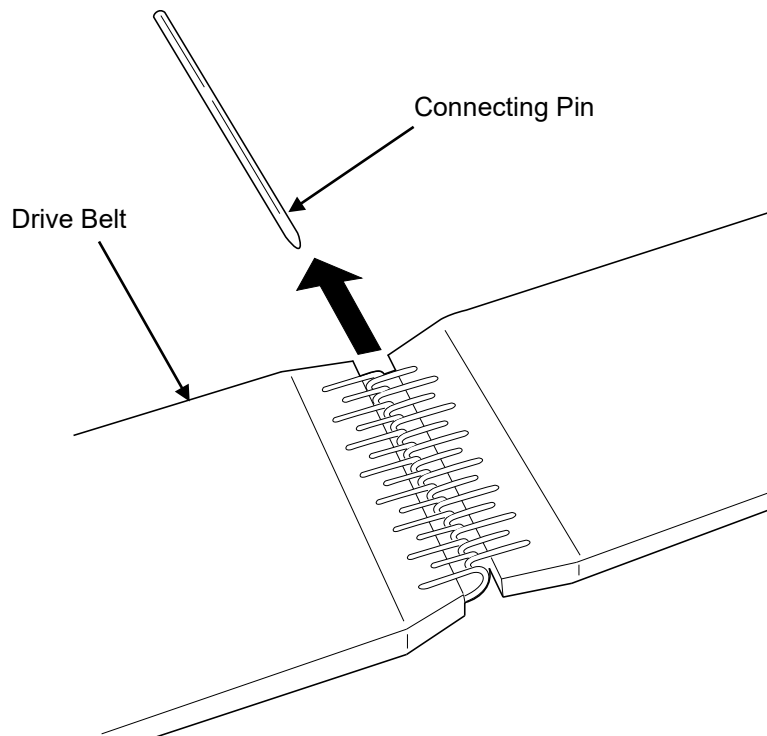
- Red and yellow are together and capped.
  - Brown, purple, and orange are together and capped.
  - Black is connected to black for power.
  - White is connected to white for power.
  - Green is connected to green to ground or motor ground.
3. Loosen the ¼-20 drive roller adjustment bolts and remove the timing belt. Remove the timing pulley from the motor (requires an Allen or hex wrench).
  4. Remove the three ¼-20 bolts. These hold the motor in place. As the last bolt is removed, hold onto the motor so it does not fall. (Bolt removal requires 7/16-inch box end wrench.)
  5. Place the new conveyor motor in place of the removed conveyor motor and install the ¼-20 bolts.
  6. Re-install the timing pulley. Make sure it is not rubbing against the conveyor frame, and then tighten both set screws.
  7. Reinstall the timing belt. Tighten the ¼-20 drive roller adjustment bolts. Reconnect the power wires #14 and # 16 ground. Refer to the wiring color connections note above to complete motor wiring connections.
  8. Refer to the instructions for Tracking the Takeaway Conveyor Belt that follow.

## **Replacing the Takeaway Conveyor Belt**

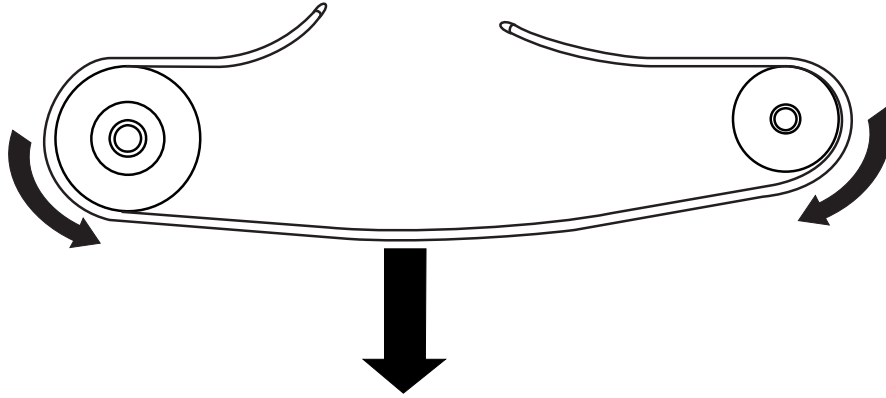
1. Disconnect the L-sealer power plug from the electrical power source.
2. Loosen the idler roller to release tension until the belt is loose.
3. Turn the conveyor belt to move the belt splice to the center of the conveyor.



4. With the belt loose, remove the connecting pin that holds the belt together.

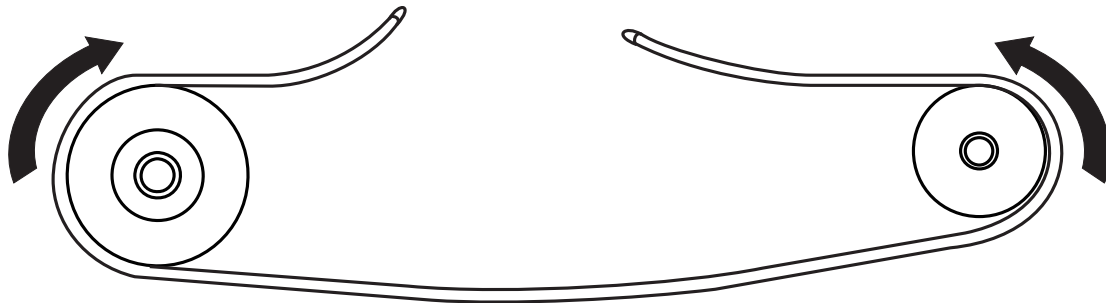


5. Take the belt off the conveyor rollers.

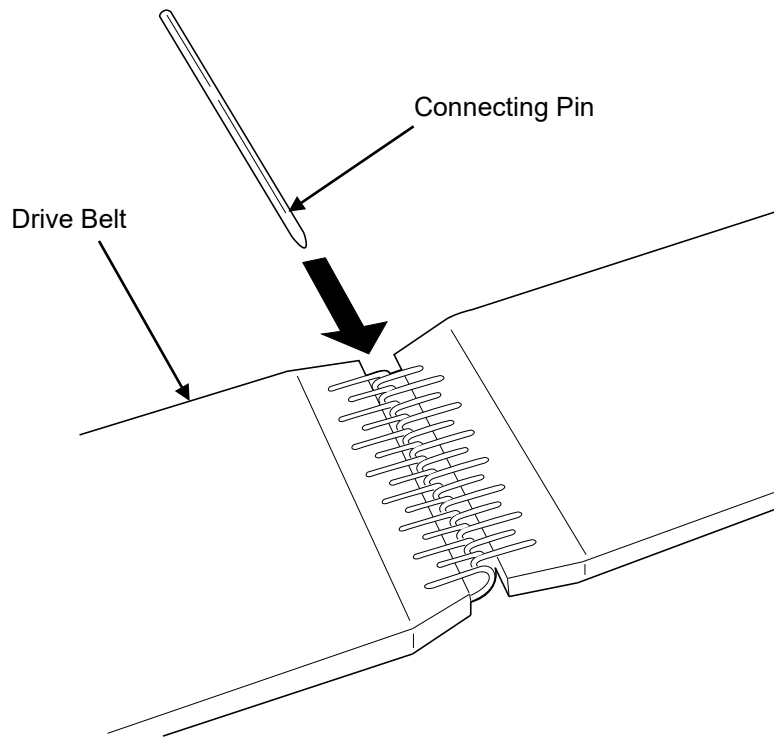


**NOTE:** At this point, you have completed the procedure for removing the belt. Instructions from here on explain how to install the new belt or reinstall the belt if still usable. If the conveyor support plate requires replacement, replace it before installing or reinstalling the belt.

6. Install the replacement belt around the drive and idler pulleys.



7. While the belt is still loose, start connecting the ends by lining up the edges of the belt. From the side of the belt, replace the connecting pin.

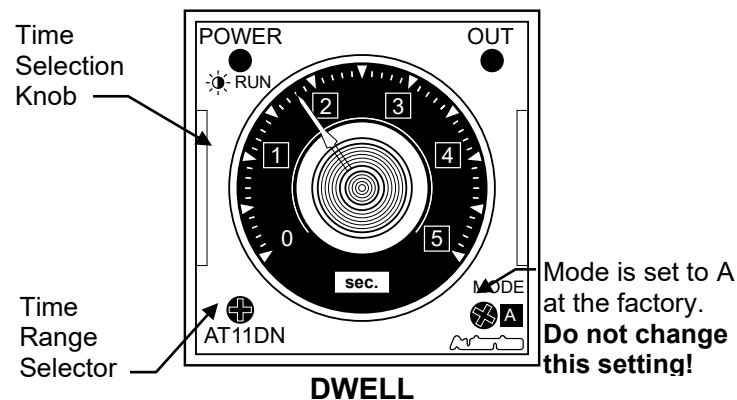


8. Re-tension the conveyor belt as required. Refer to the instructions for Tracking the Conveyor Belt that follow.

## Tracking the Takeaway Conveyor Belt

From time to time or whenever the takeaway conveyor belt has been replaced, it will be necessary to track or align the belt so that it stays in place on the rollers while moving and delivering the product. The procedure is simple, but can be time-consuming.

1. Identify the drive roller and the idler roller. The drive roller is the larger roller. The idler is smaller and has a crown (rounded surface that is higher at the middle and tapers outward to give the idler a slight “barrel” shape).
2. Place the belt on the rollers in the center and tighten each adjustment screw as evenly as possible.
3. Adjust the conveyor timer if required. See information in the Adjustments section. Do not change the setting for the Mode at the lower left. Mode is set to A.



4. Start the conveyor and observe the belt.
5. If the belt stays centered on the rollers during operation, no further adjustment is required. If the belt begins to pull towards the front or back, adjust it by turning the left-hand adjustment screw only. Turn the adjustment screw no more than one quarter turn at a time — attempting to make larger adjustments will only prolong the adjustment effort. Return the conveyor to normal operating speed when finished.

## Rollers

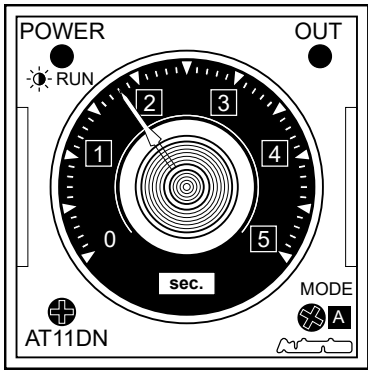
Make sure rollers stay clean and grease free. If you should have to clean the rollers, simply wipe them down with a clean lint free cloth. If a more thorough cleaning is necessary wipe the rollers down with a mild detergent and water and let dry. **Never use harsh or abrasive cleaners or chemical agents when cleaning the rollers.**

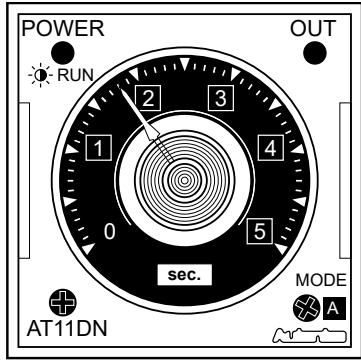
# Troubleshooting

## Common Issues

Problem	Solution
Inconsistent seals	<ul style="list-style-type: none"> <li>• Check seal pressure.</li> <li>• Check condition of seal pads. Adjust or replace as required.</li> <li>• Check condition of blades and inserts. Adjust or replace as required.</li> <li>• Check what type of film is being used.</li> <li>• Check the temperature setting. Is the temperature at the correct setting for the type of film used?</li> <li>• Check the dwell time. Is the dwell time set correctly?</li> </ul>
Magnets not releasing	<ul style="list-style-type: none"> <li>• Lower electromagnets position by approximately 1/8" or the approximate thickness of a nickel.</li> <li>• If cycling the machine power on and then off releases the L-bar magnets, then the dwell timer may be faulty. To verify, exchange the dwell timer with the conveyor timer (timers are electrically and functionally the same). If the problem changes to the conveyor, then replace the faulty timer.</li> </ul>
No heat to seal bars	<ul style="list-style-type: none"> <li>• Is the Power or Out light lit on the temperature controller?</li> <li>• Is the Out light lit on the SSR?</li> <li>• Is there voltage out to the heat element?               <ul style="list-style-type: none"> <li>- If not, check the over-temp relay.</li> </ul> </li> </ul>
Seal bar will not lift all the way up	<ul style="list-style-type: none"> <li>• Ensure set screws are tight and no slipping is occurring on the rear shaft.</li> <li>• Check the air cylinder, measure for 5 3/4" of stroke while L-Bar is in down position.</li> <li>• Ensure air cylinder is functioning correctly and there are no signs of damage.</li> </ul>



Problem	Solution
<p>No Element Heat</p>	<ul style="list-style-type: none"> <li>• Check to be sure sealer is plugged in and electrical power is present at the outlet.</li> <li>• Is the display for temperature on? If not, check main fuses.</li> <li>• The temperature controller will read “Open” when it does not have continuity to the thermocouple.</li> <li>• Is there 220V going out to the heat element? If there is 220V but there is no heat, replace the heater rod.</li> <li>• Is the green light on the solid-state relay on when the Out light on the temperature controller is on?</li> </ul>
<p>Conveyor Does Not Run</p>  <p style="text-align: center;"><b>CONVEYOR</b></p>	<ul style="list-style-type: none"> <li>• With the seal head up the light in the left-hand corner of the conveyor timer stays lit all the time. <ul style="list-style-type: none"> <li>- If the light is on, bring the seal head down. The light should start flashing once the dwell times out.</li> </ul> </li> <li>• Is the timer in “A” mode? <ul style="list-style-type: none"> <li>- Mode selector is to the lower right corner of the dial. This must be set to A.</li> </ul> </li> <li>• Inside the conveyor speed dial, is the setting between 0 and 5? <ul style="list-style-type: none"> <li>- Timer speed pot adjustment is to the lower left corner of the dial.</li> </ul> </li> <li>• At the bottom of the speed dial, is “sec” displayed? <ul style="list-style-type: none"> <li>- Units of time selected is displayed at center near the bottom of the dial.</li> </ul> </li> <li>• Is the limit switch on the back of the machine being fully actuated (pressed in)? <ul style="list-style-type: none"> <li>- Press the limit switch in by hand, and then let it go. When you let go, the conveyor should run.</li> <li>- Refer to Magnet Hold Down Not Operating on Magnet Sealers, below.</li> </ul> </li> </ul>

Problem	Solution
<p>Magnet Hold Down Magnets Not Operating on Magnet Sealers (Sealing head will not stay down, but sealer operates normally otherwise.)</p>  <p style="text-align: center;"><b>DWELL</b></p>	<ul style="list-style-type: none"> <li>• Is timer working properly? <ul style="list-style-type: none"> <li>- The timer is identical to the timer used for the Conveyor. See items to check on the conveyor timer for Conveyor Does Not Run troubleshooting on previous page.</li> </ul> </li> <li>• Turn off power and put the seal head down. With power off and the seal head down, there should be about a dime's-thickness of space between the upper and lower magnets. <ul style="list-style-type: none"> <li>- Is there dime-sized space between upper and lower magnets?</li> </ul> </li> <li>• Press the limit switch to activate it by hand. <ul style="list-style-type: none"> <li>- Does the limit switch work properly when operated by hand?</li> </ul> </li> </ul>
<p>Weak or Poor Seals</p>	<ul style="list-style-type: none"> <li>• Improper setting of temperature film cutoff controller. (Heat set too low.)</li> <li>• Improper operating technique. (See <b>Sequence of Operation</b> on page 30.)</li> <li>• Check the sealing heating element to see if it needs cleaning.</li> <li>• If the silicone-rubber seal pad is wavy, replace it. (See instructions on page 41.)</li> <li>• Seal pad pressure is incorrect. (See page 33.)</li> <li>• Hold-down pressure is uneven or incorrect on magnets.</li> </ul>

<b>Problem</b>	
Magnet Hold-Downs Stay Engaged When They Should Release	
<b>Solution</b>	
<ul style="list-style-type: none"> <li>• When you turn the power off, do the magnets release?                     <ul style="list-style-type: none"> <li>- If they do not, replace the magnets.</li> </ul> </li> </ul>	
<ul style="list-style-type: none"> <li>• Each of the timers for dwell time and conveyor run time are adjustable.                     <ul style="list-style-type: none"> <li>- Turning the selector clockwise at the lower left, you will see the units of time change inside the dial. Keep turning it until you adjust to 5 seconds. While turning this pot you will see the sec turn to min, hour, and 10hr. Factory setting is 5 seconds.</li> <li>- The mode selector at lower right must be set to mode A. If this setting has been changed to any other setting than mode A, which is the factory setting, use a small screwdriver to turn the selector clockwise (you will see the selector cycle through modes for other applications) until the mode A is set.</li> </ul> </li> <li>• When bringing the seal down, the power light on the top left should come on and the out light at the top right should flash. If this is not happening, switch the conveyor timer and the dwell timer. If the magnets start working, replace the nonfunctioning timer.</li> </ul>	

Problem	Solution
Excessive Film Drag	<ul style="list-style-type: none"> <li>• Check for proper film threading. (See Film Winding diagram on page 27 or 29.)</li> <li>• Loosen film roll brake. (See Film Winding diagram on page 27 or 29.)</li> </ul>
Excessive Film Winding or “Spill”	<ul style="list-style-type: none"> <li>• Tighten film roll brake.</li> </ul>

<b>Problem</b>	<b>Solution</b>
Charring of Film	<ul style="list-style-type: none"><li data-bbox="732 275 1406 380">• Improper setting of temperature film cutoff controller. (Too much heat.) Adjust temperature down.</li></ul>

# Parts Lists

## Spare Parts

### Wear Parts and Consumables

As part of regularly scheduled maintenance of the EM Professional Series Semi-Automatic L-Sealer, it is expected that certain parts will undergo wear under normal use and require replacement at regular intervals. For example, electrical fuses are designed to self-destruct to help protect users and internal electrical components of the machine to interrupt the flow of electricity in the event of an electrical overflow or short-circuit. As such, it is expected that fuses will blow at some time and require replacement. Belts, PTFE tape and coatings and UHMW plastic components will see wear through daily use and require replacement at some time in the course of regular maintenance. Similarly, cutting rules and inserts and sponge rubber pads of the sealing area wear through normal use and will require replacing. Heater cartridges and heatsinks are also replacement items. It is recommended to keep a supply of spare wear parts and replacement items to reduce the likelihood of long durations of machine downtime when time comes to replace them.

### Recommended Spare Parts

For recommended spare parts, look at the parts listings for part numbers and sizes or other applicable information for the following parts as required for your L-sealer.

- Cutting Rules
- Heater Cartridges
- Mushroom Inserts
- Conveyor Motor
- Head Return Cylinders
- Sponge Rubber

Similarly, for recommended spare electrical parts, look at the parts listing for the electrical board for your L-sealer. Note the part numbers and ratings of these electrical components.

- Fuses
- Contactors
- Relay Parts (Solid State and Top)
- Timers
- Temperature Controllers
- Microswitches
- Thermocouples (Temperature Sensors)

An Eastey technician can help you to determine and order the recommended spare parts during initial consultation for ordering your L-sealer.

## L-Sealers Spare Parts Kits

The following kits containing spare parts have been set up to aid in ordering spare parts for a specific size of L-Sealer. All spare parts kits have been set up with the part number prefix SUBK01000, with the dash number corresponding to the L-Sealer model number and size. In some cases, where a specific power voltage and phase is applicable, the voltage and phase are designated by a dash suffix, as shown in the table near the end of the Specifications section for Voltage and Phase Designator Meaning.

SPARE PARTS KIT	L-SEALER MODEL
SUBK01000-2016	EM2016TK Professional Series Semi-Auto L-Sealer
SUBK01000-2016-V0	EM2016TK Professional Series Semi-Auto L-Sealer, 110V, Single phase
SUBK01000-2028	EM2028TK Professional Series Semi-Auto L-Sealer
SUBK01000-2028-V0	EM2028TK Professional Series Semi-Auto L-Sealer, 110V, Single phase
SUBK01000-2040	EM2040TK Professional Series Semi-Auto L-Sealer
SUBK01000-2050	EM2050TK Professional Series Semi-Auto L-Sealer
SUBK01000-2070	EM2070TK Professional Series Semi-Auto L-Sealer
SUBK01000-2080	EM2080TK Professional Series Semi-Auto L-Sealer
SUBK01000-3040	EM3040TK Professional Series Semi-Auto L-Sealer
SUBK01000-3040-V5	EM3040TK Professional Series Semi-Auto L-Sealer, 480V, Single phase
SUBK01000-3050	EM3050TK Professional Series Semi-Auto L-Sealer
SUBK01000-3050-V5	EM3050TK Professional Series Semi-Auto L-Sealer, 480V, Single phase
SUBK01000-3070	EM3070TK Professional Series Semi-Auto L-Sealer
SUBK01000-3080	EM3080TK Professional Series Semi-Auto L-Sealer
SUBK01000-4040	EM4040TK Professional Series Semi-Auto L-Sealer
SUBK01000-4050	EM4050TK Professional Series Semi-Auto L-Sealer
SUBK01000-4070	EM4070TK Professional Series Semi-Auto L-Sealer
SUBK01000-4070-V5	EM4070TK Professional Series Semi-Auto L-Sealer, 480V, Single phase
SUBK01000-5050	EM5050TK Professional Series Semi-Auto L-Sealer
SUBK01000-5070	EM5070TK Professional Series Semi-Auto L-Sealer

Each spare parts kit contains a head return cylinder kit, head return ball joint, micro limit switch, fuse, timer, temperature control, thermocouple, fire rod cartridge, cutting rule and mushroom insert kit, and sponge rubber. The fuse and electronic components are rated for L-sealer electrical power specifications (as indicated by their -V number). Sealer mechanical spare parts are sized for seal head dimensions (as indicated by the EM model number).

## L-Sealer Cutting Rules and Mushroom Inserts Parts Kits

Similarly, kits have been set up containing only a set of cutting rules and mushroom inserts for the front and side. In some cases, where a cutting rule and mushroom insert parts kit is available for a left-hand version of the sealer, this is indicated by an L after the part number suffix. Each cutting rule and mushroom insert kit contains enough mushroom insert material and cutting rule length to replace the front and side hot knife inserts for the L-sealer.

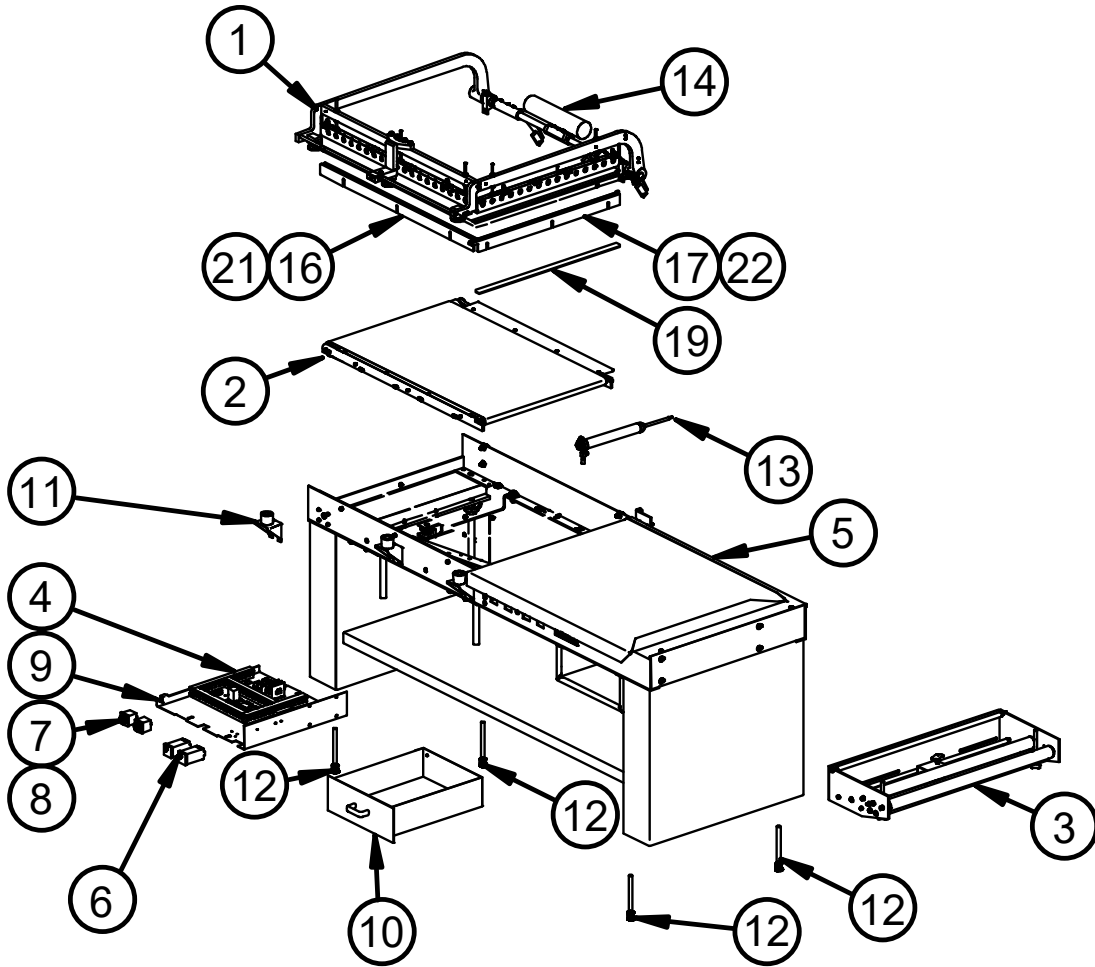
SEAL PARTS KIT	L-SEALER MODEL CUTTING RULES & MUSHROOM INSERTS
SUB00222-2016	EM2016TK Professional Series Semi-Auto L-Sealer
SUB00222-2016L	EM2016TK Professional Series Semi-Auto L-Sealer, Left-hand version
SUB00222-2028	EM2028TK Professional Series Semi-Auto L-Sealer
SUB00222-2028L	EM2028TK Professional Series Semi-Auto L-Sealer, Left-hand version
SUB00222-2040	EM2040TK Professional Series Semi-Auto L-Sealer
SUB00222-2050	EM2050TK Professional Series Semi-Auto L-Sealer
SUB00222-2070	EM2070TK Professional Series Semi-Auto L-Sealer
SUB00222-2080	EM2080TK Professional Series Semi-Auto L-Sealer
SUB00222-3040	EM3040TK Professional Series Semi-Auto L-Sealer
SUB00222-3040L	EM3040TK Professional Series Semi-Auto L-Sealer, Left-Hand version
SUB00222-3050	EM3050TK Professional Series Semi-Auto L-Sealer
SUB00222-3070	EM3050TK Professional Series Semi-Auto L-Sealer, Left-Hand version
SUB00222-3070	EM3070TK Professional Series Semi-Auto L-Sealer
SUB00222-3080	EM3080TK Professional Series Semi-Auto L-Sealer
SUB00222-3080L	EM3080TK Professional Series Semi-Auto L-Sealer, Left-Hand version
SUB00222-4040	EM4040TK Professional Series Semi-Auto L-Sealer
SUB00222-4050	EM4050TK Professional Series Semi-Auto L-Sealer
SUB00222-4070	EM4070TK Professional Series Semi-Auto L-Sealer
SUB00222-4080	EM4080TK Professional Series Semi-Auto L-Sealer
SUB00222-40100	EM40100TK Professional Series Semi-Auto L-Sealer
SUB00222-5050	EM5050TK Professional Series Semi-Auto L-Sealer
SUB00222-5070	EM5070TK Professional Series Semi-Auto L-Sealer
SUB00222-50100	EM50100TK Professional Series Semi-Auto L-Sealer

Each Cutting Rule and Mushroom Insert kit contains a mushroom insert and cutting rule sized for each cutting seal direction. For L-sealers where the seal head is of equal dimensions in width and length, one cutting rule and mushroom insert is provided for side or front seal replacement.

## L-Sealers Parts Lists

### EM20 Series L-Sealers

EM2016TK, EM2028TK, EM2040TK, EM2050TK, EM2070TK, EM2080TK & EM20100TK



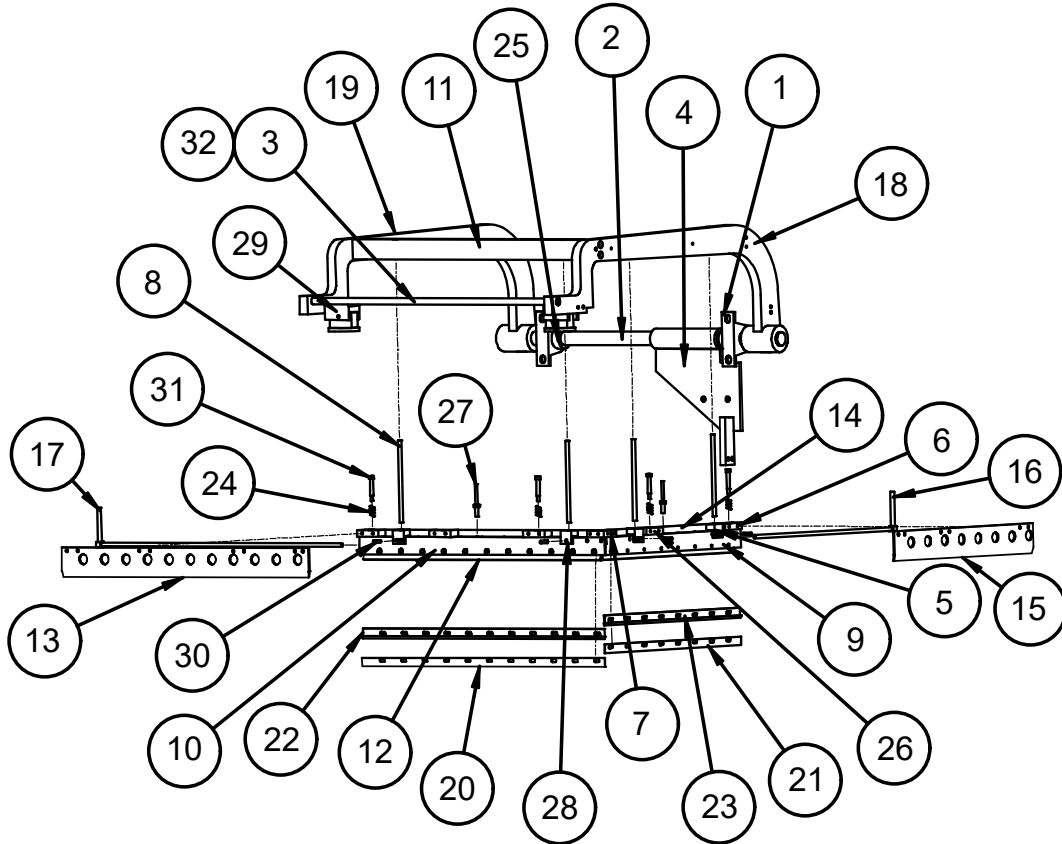


**EM2016TK Professional Series L-Sealer Main Assembly**

ITEM	PART NO.	DESCRIPTION	QUANTITY
1	SUBA0211-16	SEAL HEAD, HOT KNIFE EM2016 MUSHROOM PTFE/PFA	1
2	SUBA0036	CONVEYOR, TAKEAWAY EM2016	1
3	SUBA0032	FILM RACK 26" WITH PIN PERFORATOR	1
4	SUBA0222	ELECTRICAL BOARD EM2016 EM2028	1
5	EAST0142R	PRODUCT TRAY EM16 RH	1
	EAST0143	PRODUCT TRAY TUBE16/28/40	2
6	EAST0494*	TEMPERATURE CONTROL FOR SEAL BARS*	2
7	EAST1030*	TIMER DWELL/CONVEYOR 220VAC 5A DPDT TON*	2
8	ETC00002*	KNOB VELOCITY CONTROL*	1
9	ETC00309	SWITCH POWER ON / OFF TOGGLE	1
	ETC00310	SWITCH ON-OFF FACE PLATE	1
10	EAST0134-8	LEG LARGE DRAWER MM	1
	EAST1035	DRAWER PULL	1
11	SUBA0106	MAGNET & HOLDER LOWER	2
12	SUBA0105	LEVELING FOOT ASSY.5/8 7"	4
13	SUB01461*	HEAD RETURN CYLINDER KIT*	1
	EAST0438*	HEAD RETURN BALL JOINT*	1
14	EAST0526	COUNTERWEIGHT 15.25" EM16TK	1
15	EAST0512	HOT KNIFE ACTUATOR MM	1
16	EAST0008	SEAL BAR LOWR FRNT 16" MM	1
17	EAST0007	SEAL BAR LOWR SIDE 20" MM	1
18	EAST0840*	CONVEYOR CRANK HANDLE MM*	1
19	EAST0209*	SPONGE RUBBER 1/4" X 3/4"*	3.5 FT
20	EAST0075*	BUSHING CONVEYOR LIFT*	1
21	EAST0525	HOT KNIFE WIRE GUARD 16"	1
22	EAST0524	HOT KNIFE WIRE GUARD SIDE	1
23	EAST0238	WIRE HOLE BUSHING	3
24	EAST0320	CONNECTOR BUTT SEAM RING	1
25	EAST0319	CONNECTOR BUTT SEAM BLOCK	6
26	EAST0597	HOT KNIFE CONDUIT BRACKET	1
27	EAST0242	SPACER BAR SHORT EM16	1
28	EAST1019*	COLLAR-SET SCREW 3/8" ID*	2
29	EAST0363	HEAD SHIMS 16GA	2
30	EAST0156	SNAP RING 3/4"	2

\* One each of items marked with an asterisk (\*) are included in spare parts kit SUBK100-2016. Specify electrical power requirements (-V number) when ordering.

## SEAL HEAD, HOT KNIFE EM2016TK MUSHROOM PTFE/PFA – SUBA0211-16



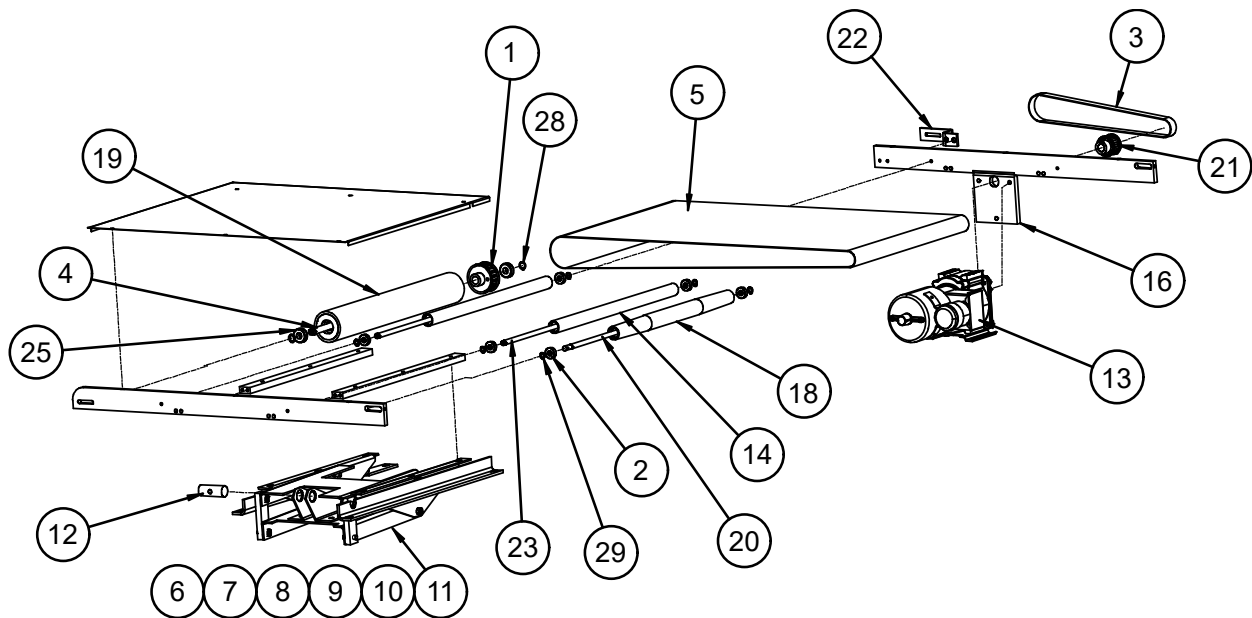
ITEM	PART NO.	DESCRIPTION	QUANTITY
1	EAST0022	PILLOW BLOCK 1"	2
2	EAST0047	REAR SHAFT 20" EM16 MM	1
3	EAST0148	HANDLE FOR SEALER EM16 MM	1
4	EAST0456	HEAD RETURN ARM MM	1
5	EAST0511	HOT KNIFE SADDLE W/SLOT MM	3
6	EAST0514	HOT KNIFE SPACER BLOCK MM	3
7	EAST0515	HOT KNIFE CORNER SPACER MM	1
8	EAST0560	HOT KNIFE THREADED ROD	4
9	EAST0516	HOT KNIFE SEAL BAR UP 20"	1
10	EAST0517	HOT KNIFE SEAL BAR UPPER	1
11	EAST0513	CROSS OVER BAR 16"	1
12	EAST0520	SAFETY SHIELD INNER 16" FRONT	1
13	EAST0521	SAFETY SHIELD OUTER 17" FRONT	1
14	EAST0522	SAFETY SHIELD INNER 20" SIDE	1
15	EAST0523	SAFETY SHIELD OUTER 20" SIDE	1

ITEM	PART NO.	DESCRIPTION	QUANTITY
16	EAST0496*	HEATER CARTRIDGE 220V 20"*	1
17	EAST0497*	HEATER CARTRIDGE 220V 16"*	1
18	EAST0507	HOT KNIFE ARM CASTING	1
19	EAST0508	HOT KNIFE ARM CASTING	1
20	EAST0816**	CUTTING RULE FRONT 16"***	1
21	EAST0815**	CUTTING RULE SIDE 20" MM**	1
22	EAST0919**	MUSHROOM INSERT FRONT 16"***	1
23	EAST0918**	MUSHROOM INSERT SIDE 20"***	1
24	EAST1007	SAFETY SHIELD SPRING	2
25	EAST1018	COLLAR 1"	2
26	EP000095	HOT KNIFE SPACER BLOCK	2
27	EP000535*	THERMOCOUPLE HOT KNIFE*	2
28	ESC00037	HOT KNIFE SADDLE CENTER	1
29	SUBA0065	MAGNET UPPER (NEW 3 PART)	2
30	XH348	SPLIT TENSION PIN 3/16	4
31	XH360	BOLT 1/4 X 1-1/4 SHOULDER	4
32	EAST0165	HANDLE GRIP MATERIAL	1.83 FT.

\* One each of items marked with an asterisk (\*) are included in spare parts kit SUBK100-2016. Specify electrical power requirements (-V number) when ordering.

\*\*One each of items marked with two asterisks (\*\*) are included in the cutting rule and mushroom insert kit SUBK00222-2016.

### CONVEYOR, TAKEAWAY EM2016TK – SUBA0036



ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	EAST0051	SPROCKET DRV ROLL 5/8BAND	1
2	EAST0052	BEARING FOR GUIDE ROLLERS	6
3	EAST0054	TIMING BELT EM16 BANDO	1
4	EAST0056	DRIVE ROLLER SHAFT 19.125"	1
5	EAST0057B	CONVEYOR BELT - BLACK	1
6	EAST0060-2	SCISSOR JACK TOP H	1
7	EAST0060-8	SCISSOR JACK RIGHT LEG W/	1
8	EAST0060-9	SCISSOR JACK LEFT LEG W/	1
9	EAST0060-10	SCISSOR JACK BOTTOM H W/	1
10	EAST0060-4L	SCISSOR JACK BRACKET SIDE	1
11	EAST0060-4R	SCISSOR JACK BRACKET SIDE	1
12	EAST0061*	BARREL NUT M/M*	1
13	EAST0063	MOTOR CONVEYOR SEALERS	1
14	EAST0065	CONVEYOR GUIDE ROLLER MM	2
15	EAST0069	CONVEYOR CROSS BAR 20"	2
16	EAST0640	CONV MOTOR MOUNT BACK	1
17	EAST0641	CONV SIDE BAR FRONT	1
18	EAST0187	DRIVE ROLLER ITSELF CONV	1
18	EAST0188	IDLER ROLLER ITSELF CONV	1
20	EAST0194	IDLER ROLLER SHAFT 18"	1
21	EAST0199	SPROCKET BANDO/STEEL TIMING	1
22	EAST0214	ADJUSTING BRACKET ON MM	1
23	EAST0243	CONV GUIDE ROLLER SHFT MM	2
24	EAST0062	CONVEYOR TRAY EM16 SS	1
25	EAST0254	BEARING FOR DRIVE ROLLER	2
26	EAST0604	DRIVE ROLLER END CAP	1
27	EAST0605	DRIVE ROLLER END CAP	1
28	EAST1013	SNAP RING 1/2" FOR DRIVE	2
29	EAST1014	SNAP RING 3/8"	6
30	EAST1004	ROMEX CONNECTOR 3/8"	1
31	ESC00563	POWER CORD 18-3 SO CORD	6.5 FT

\* One each of items marked with an asterisk (\*) are included in spare parts kit SUBK100-2016. Specify electrical power requirements (-V number) when ordering.

#### FILM RACK 26" WITH PIN PERFORATOR – SUBA0032

See the Film Rack section of this Parts section for the Film Rack parts breakdown.

## ELECTRICAL BOARD EM2016-TKV1 &amp; EM2028-TKV1 – SUBA0222

See the Electrical Board section of this Parts section for the Electrical Board Parts breakdown.

**EM2028TK Professional Series L-Sealer Main Assembly**

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	SUBA0211-28	SEAL HEAD, HOT KNIFE EM2028 MUSHROOM PTFE/PFA	1
2	SUBA0036A	CONVEYOR, TAKEAWAY EM2028	1
3	SUBA0032	FILM RACK 26" WITH PIN PERFORATOR	1
4	SUBA0222	ELECTRICAL BOARD EM2016 EM2028	1
5	EAST0261R	PRODUCT TRAY EM28 RIGHT	1
	EAST0143	PRODUCT TRAY TUBE16/28/40	2
6	EAST0494*	TEMPERATURE CONTROL FOR SEAL BARS*	2
7	EAST1030*	TIMER DWELL/CONVEYOR 220VAC 5A DPDT TON*	2
8	ETC00002*	KNOB VELOCITY CONTROL*	1
9	ETC00309	SWITCH POWER ON / OFF TOGGLE	1
	ETC00310	SWITCH ON-OFF FACE PLATE	1
10	EAST0134-8	LEG LARGE DRAWER MM	1
11	EAST1035	DRAWER PULL	1
12	SUBA0106	MAGNET & HOLDER LOWER	2
13	SUBA0105	LEVELING FOOT ASSY.5/8 7"	4
	SUB01461*	HEAD RETURN CYLINDER KIT*	2
14	EAST0438*	HEAD RETURN BALL JOINT*	2
15	RM000020	COUNTERWEIGHT	1
16	EAST0512	HOT KNIFE ACTUATOR MM	1
17	EAST0245	SEAL BAR LOWER FRONT 28"	1
18	EAST0007	SEAL BAR LOWER SIDE 20" MM	1
19	EAST0840*	CONVEYOR CRANK HANDLE MM*	1
20	EAST0209*	SPONGE RUBBER 1/4" X 3/4"*	4 FT
21	EAST0075*	BUSHING CONVEYOR LIFT*	1
22	EAST0554	HOT KNIFE WIRE GUARD FRT	1
23	EAST0524	HOT KNIFE WIRE GUARD SIDE	1
24	EAST0238	WIRE HOLE BUSHING	3
26	EAST0597	HOT KNIFE CONDUIT BRACKET	1
27	EAST0241	SPACER BAR LONG EM28 MM	1
28	EAST1019*	COLLAR-SET SCREW 3/8" ID*	2
29	EAST0363	HEAD SHIMS 16GA	2

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
30	EAST0156	SNAP RING 3/4"	2

\* One each of items marked with an asterisk (\*) are included in spare parts kit SUBK100-2028  
Specify electrical power requirements (-V number) when ordering.

## SEAL HEAD, HOT KNIFE EM2028TK MUSHROOM PTFE/PFA – SUBA0211-28

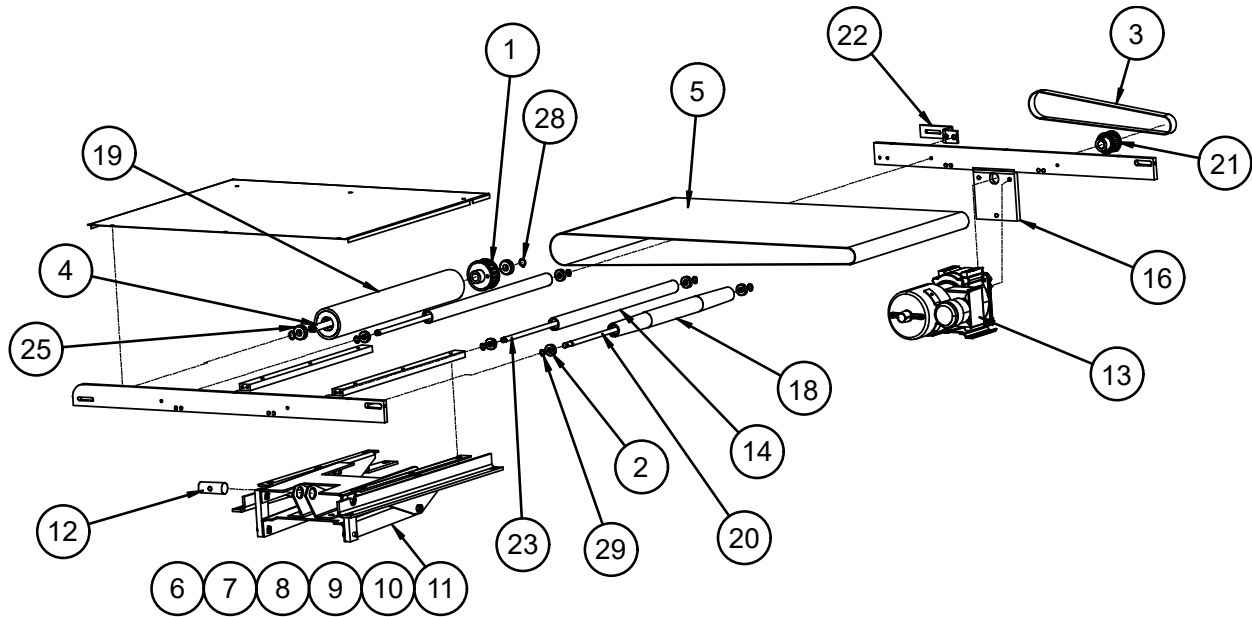
ITEM	PART NO.	DESCRIPTION	QUANTITY
1	EAST0022	PILLOW BLOCK 1"	2
2	EAST0048	REAR SHAFT 32" EM28 MM	1
3	EAST0246	HANDLE FOR SEALER EM28 MM	1
4	EAST0456	HEAD RETURN ARM MM	2
5	EAST0511	HOT KNIFE SADDLE W/SLOT MM	3
6	EAST0514	HOT KNIFE SPACER BLOCK MM	3
7	EAST0515	HOT KNIFE CORNER SPACER MM	1
8	EAST0560	HOT KNIFE THREADED ROD	4
9	EAST0516	HOT KNIFE SEAL BAR UP 20"	1
10	EAST0549	HOT KNIFE SEAL BAR UPPER	1
11	EAST0550	CROSS OVER BAR 28"	1
12	EAST0552	SAFETY SHIELD INFRNT 28"	1
13	EAST0553	SAFETY SHIELD OUTER 28" F	1
14	EAST0522	SAFETY SHIELD INNER 20" S	1
15	EAST0523	SAFETY SHIELD OUTER 20" S	1
16	EAST0496*	FIREROD CART 220V 20"	1
17	EAST0555	FIREROD CART 220V 28"	1
18	EAST0507	HOT KNIFE ARM CASTING	1
19	EAST0508	HOT KNIFE ARM CASTING	1
20	EAST0817	CUTTING RULE FRONT 28"	1
21	EAST0815	CUTTING RULE SIDE 20" MM	1
22	EAST0920	MUSHROOM INSERT FRONT 28"	1
23	EAST0918	MUSHROOM INSERT SIDE 20"	1
24	EAST1007	SAFETY SHIELD SPRING	4
25	EAST1018	COLLAR 1"	2
26	EP000095	HOT KNIFE SPACER BLOCK	3
27	EP000535*	THERMOCOUPLE HOT KNIFE*	2
28	ESC00037	HOT KNIFE SADDLE CENTER	1
29	SUBA0065	MAGNET UPPER (NEW 3 PART)	2
30	XH348	SPLIT TENSION PIN 3/16	4
31	XH360	BOLT 1/4 X 1-1/4 SHOULDER	4

ITEM	PART NO.	DESCRIPTION	QUANTITY
32	EAST0165	HANDLE GRIP MATERIAL	2.6 FT

\* One each of items marked with an asterisk (\*) are included in spare parts kit SUBK100-2028. Specify electrical power requirements (-V number) when ordering.

\*\*One each of items marked with two asterisks (\*\*) are included in the cutting rule and mushroom insert kit SUBK00222-2028.

### CONVEYOR, TAKEAWAY EM2028TK – SUBA0036A



ITEM	PART NO.	DESCRIPTION	QUANTITY
1	EAST0051	SPROCKET DRV ROLL 5/8BAND	1
2	EAST0052	BEARING FOR GUIDE ROLLERS	6
3	EAST0055	TIMING BELT EM28 & EM40	1
4	EAST0056	DRIVE ROLLER SHFT 19.125"	1
5	EAST0058B	CONVEYOR BELT BLACK	1
6	EAST0060-2	SCISSOR JACK TOP H	1
7	EAST0060-8	SCISSOR JACK RIGHT LEG W/	1
8	EAST0060-9	SCISSOR JACK LEFT LEG W/	1
9	EAST0060-10	SCISSOR JACK BOTTOM H W/	1
10	EAST0060-4L	SCISSOR JACK BRACKET SIDE	1
11	EAST0060-4R	SCISSOR JACK BRACKET SIDE	1
12	EAST0061*	BARREL NUT M/M*	1
13	EAST0063	MOTOR CONVEYOR SEALERS	1
14	EAST0065	CONVEYOR GUIDE ROLLER MM	2
15	EAST0069	CONVEYOR CROSS BAR 20"	2

ITEM	PART NO.	DESCRIPTION	QUANTITY
16	EAST0642	CONV MOTOR MOUNT BACK	1
17	EAST0643	CONV SIDE FRONT BAR	1
18	EAST0187	DRIVE ROLLER ITSELF CONV	1
19	EAST0188	IDLER ROLLER ITSELF CONV	1
20	EAST0194	IDLER ROLLER SHAFT 18"	1
21	EAST0199	SPROCKET BANDO/STEEL TIMING	1
22	EAST0214	ADJUSTING BRACKET ON MM	1
23	EAST0243	CONV GUIDE ROLLER SHFT MM	2
24	EAST0249	CONVEYOR TRAY EM28 SS	1
25	EAST0254	BEARING FOR DRIVE ROLLER	2
26	EAST0604	DRIVE ROLLER END CAP	1
27	EAST0605	DRIVE ROLLER END CAP	1
28	EAST1013	SNAP RING 1/2" FOR DRIVE	2
29	EAST1014	SNAP RING 3/8"	6
30	EAST1004	ROMEX CONNECTOR 3/8"	1
31	ESC00563	POWER CORD 18-3 SO CORD	8 FT
	EAST1025	BOLT 3/8D X 3/8L SHOULDER	8

\* One each of items marked with an asterisk (\*) are included in spare parts kit SUBK100-2028. Specify electrical power requirements (-V number) when ordering.

#### FILM RACK 26" WITH PIN PERFORATOR – SUBA0032

See the Film Rack section of this Parts section for the Film Rack parts breakdown.

#### ELECTRICAL BOARD EM2016-TKV1 & EM2028-TKV1 – SUBA0222

See the Electrical Board section of this Parts section for the Electrical Board Parts breakdown.

#### EM2040TK Professional Series L-Sealer Main Assembly

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	SUBA0211-40	SEAL HEAD, HOT KNIFE TK 40" MUSHROOM PTFE/PFA	1
2	SUBA0036B	CONVEYOR, TAKEAWAY EM2040	1
3	SUBA0032	FILM RACK 26" WITH PIN PERFORATOR	1
4	SUBA0223	ELECTRICAL BOARD EM2040	1
5	EAST0262R	PRODUCT TRAY EM40 RIGHT	1
	EAST0143	PRODUCT TRAY TUBE16/28/40	3
6	EAST0494*	TEMPERATURE CONTROL FOR SEAL BARS*	2



ITEM	PART NUMBER	DESCRIPTION	QUANTITY
7	EAST1030*	Timer Dwell/Conveyor 220VAC 5A DPDT TON*	2
8	ETC00002*	KNOB VELOCITY CONTROL*	2
9	ETC00309	Switch Power On / Off Toggle	1
	ETC00310	SWITCH ON-OFF FACE PLATE	1
10	EAST0134-8	LEG LARGE DRAWER MM	1
	EAST1035	DRAWER PULL	1
11	SUBA0106	MAGNET & HOLDER LOWER	3
12	SUBA0105	LEVELING FOOT ASSY.5/8 7"	4
13	SUB01461*	HEAD RETURN CYLINDER KIT*	3
	EAST0438*	HEAD RETURN BALL JOINT*	3
14	ECOS0120	COUNTERWEIGHT HOT KNIFE	1
15	EAST0512	HOT KNIFE ACTUATOR MM	1
16	EAST0255	SEAL BAR LOWER FRONT 40"	1
17	EAST0007	SEAL BAR LOWR SIDE 20" MM	1
18	EAST0840*	CONVEYOR CRANK HANDLE MM*	2
19	EAST0209*	SPONGE RUBBER 1/4" X 3/4"	5 FT
20	EAST0075*	BUSHING CONVEYOR LIFT*	2
21	EAST0627	HOT KNIFE WIRE GUARD FRONT	1
22	EAST0524	HOT KNIFE WIRE GUARD SIDE	1
23	EAST0238	WIRE HOLE BUSHING	4
26	EAST0597	HOT KNIFE CONDUIT BRACKET	1
27	EAST0468	SPACER BAR 30X40 39.875"	1
28	EAST1019*	COLLAR-SET SCREW 3/8" ID*	4
29	EAST0363	HEAD SHIMS 16GA	2
30	EAST0156	SNAP RING 3/4"	3

\* One each of items marked with an asterisk (\*) are included in spare parts kit SUBK100-2040. Specify electrical power requirements (-V number) when ordering.

#### SEAL HEAD, HOT KNIFE EM2040TK MUSHROOM PTFE/PFA – SUBA0211-40

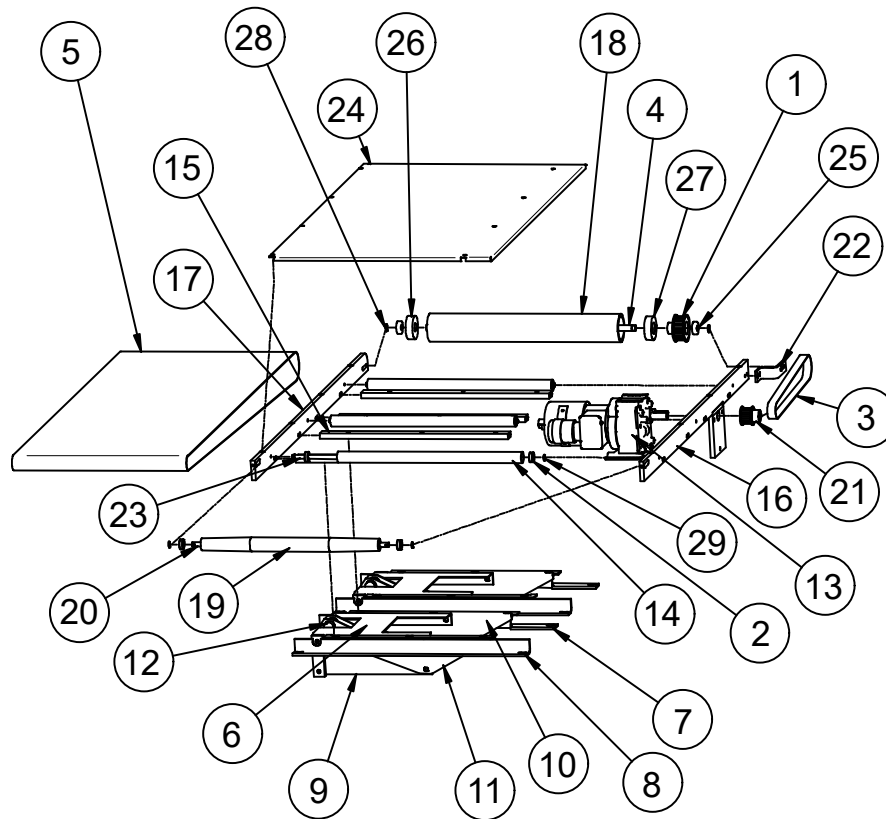
ITEM	PART NO.	DESCRIPTION	QUANTITY
1	EAST0022	PILLOW BLOCK 1"	2
2	EAST0049	REAR SHAFT EM30X40 & EM40	1
3	EAST0247	HANDLE FOR SEALER EM40	1
4	EAST0338	MAGNET HOLDER UP EM40 MM	1
5	EAST0456	HEAD RETURN ARM MM	3

ITEM	PART NO.	DESCRIPTION	QUANTITY
6	EAST0511	HOT KNIFE SADDLE W/SLOT MM	4
7	EAST0514	HOT KNIFE SPACER BLOCK MM	3
8	EAST0515	HOT KNIFE CORNER SPACER MM	1
9	EAST0560	HOT KNIFE THREADED ROD	5
10	EAST0516	HOT KNIFE SEAL BAR UP 20"	1
11	EAST0616	HOT KNIFE SEAL BAR UPPER	1
12	EAST0621	CROSS OVER BAR 30X40 MM	1
13	EAST0622	SAFETY SHIELD INNER 40" F	1
14	EAST0623	SAFETY SHIELD OUTER 40"	1
15	EAST0522	SAFETY SHIELD INNER 20" S	1
16	EAST0523	SAFETY SHIELD OUTER 20" S	1
17	EAST0629*	FIREROD CART 220V 40"	1
18	EAST0496*	FIREROD CART 220V 20"	1
19	EAST0507	HOT KNIFE ARM CASTING	1
20	EAST0508	HOT KNIFE ARM CASTING	1
21	EAST0810	HOT KNIFE MAGNET HOLDER	1
22	EAST0818	CUTTING RULE FRONT 40"***	1
23	EAST0815	CUTTING RULE SIDE 20" MM**	1
24	EAST0900	MAGNET HOLDER UPPER	1
25	EAST0901	MAGNET HOLDER UPPER PAD	1
26	EAST0916	MUSHROOM INSERT FRONT 40"***	1
27	EAST0918	MUSHROOM INSERT SIDE 20"***	1
28	EAST1007	SAFETY SHIELD SPRING	2
29	EAST1018	COLLAR 1"	2
31	EP000095	HOT KNIFE SPACER BLOCK	4
32	EP000535*	THERMOCOUPLE HOT KNIFE*	2
33	ESC00037	HOT KNIFE SADDLE CENTER	1
34	SUBA0065	MAGNET UPPER (NEW 3 PART)	2
35	XH348	SPLIT TENSION PIN 3/16	5
36	XH360	BOLT 1/4 X 1-1/4 SHOULDER	4
37	EAST0165	HANDLE GRIP MATERIAL	1.83 FT

\* One each of items marked with an asterisk (\*) are included in spare parts kit SUBK100-2040. Specify electrical power requirements (-V number) when ordering.

\*\*One each of items marked with two asterisks (\*\*) are included in the cutting rule and mushroom insert kit SUBK00222-2040.

## CONVEYOR TAKEAWAY EM2040TK – SUBA0036B



ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	EAST0051	SPROCKET DRV ROLL 5/8 BAND	1
2	EAST0052	BEARING FOR GUIDE ROLLERS	8
3	EAST0055	TIMING BELT EM28 & EM40	1
4	EAST0056	DRIVE ROLLER SHFT 19.125"	1
5	EAST0059	CONVEYOR BELT EM40 6403	1
6	EAST0060-2	SCISSOR JACK TOP H	2
7	EAST0060-8	SCISSOR JACK RIGHT LEG W/	2
8	EAST0060-9	SCISSOR JACK LEFT LEG W/	2
9	EAST0060-10	SCISSOR JACK BOTTOM H W/	2
10	EAST0060-4L	SCISSOR JACK BRACKET SIDE	2
11	EAST0060-4R	SCISSOR JACK BRACKET SIDE	2
12	EAST0061*	BARREL NUT M/M*	2
13	EAST0063	MOTOR CONVEYOR SEALERS	1
14	EAST0065	CONVEYOR GUIDE ROLLER MM	3
15	EAST0069	CONVEYOR CROSS BAR 20"	4
16	EAST0071	CONVEYOR MOTOR MOUNT BACK	1
17	EAST0072	CONVEYOR SIDE BAR FRONT	1

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
18	EAST0187	DRIVE ROLLER ITSELF CONV	1
19	EAST0188	IDLER ROLLER ITSELF CONV	1
20	EAST0194	IDLER ROLLER SHAFT 18"	1
21	EAST0199-MOD	SPROCKET BANDO/STEEL TIMING	1
22	EAST0214	ADJUSTING BRACKET ON MM	1
23	EAST0243	CONV GUIDE ROLLER SHFT MM	3
24	EAST0250	CONVEYOR TRAY EM40 SS	1
25	EAST0254	BEARING FOR DRIVE ROLLER	2
26	EAST0604	DRIVE ROLLER END CAP	1
27	EAST0605	DRIVE ROLLER END CAP	1
28	EAST1013	SNAP RING 1/2" FOR DRIVE	2
29	EAST1014	SNAP RING 3/8"	8
30	EAST1004	ROMEX CONNECTOR 3/8"	1
31	ESC00563	POWER CORD 18-3 SO CORD	13 FT
	EAST1025	BOLT 3/8D X 3/8L SHOULDER	16

\* One each of items marked with an asterisk (\*) are included in spare parts kit SUBK100-2040. Specify electrical power requirements (-V number) when ordering.

#### FILM RACK 26" WITH PIN PERFORATOR – SUBA0032

See the Film Rack section of this Parts section for the Film Rack parts breakdown.

#### ELECTRICAL BOARD EM2040-TKV1 – SUBA0223

See the Electrical Board section of this Parts section for the Electrical Board Parts breakdown.

#### EM2050TK Professional Series L-Sealer Main Assembly

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	SUBA0211-50	SEAL HEAD HOT KNIFE EM2050 MUSHROOM PTFE/PFA	1
2	SUBA1062	CONVEYOR TAKEAWAY EM2050	1
3	SUBA0032	FILM RACK 26" WITH PIN PERFORATOR	1
4	SUBA1064	ELECTRICAL BOARD EM2050, EM4050 & EM5050	1
5	EAST0360	PRODUCT TRAY 20X50	1
	EAST0143	PRODUCT TRAY TUBE 16/28/40	4
6	EAST0494*	TEMPERATURE CONTROL FOR SEAL BARS*	2
7	EAST1030*	Timer Dwell/Conveyor 220VAC 5A DPDT TON*	2
8	ETC00002*	KNOB VELOCITY CONTROL*	2

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
9	ETC00309	Switch Power On / Off Toggle	1
	ETC00310	SWITCH ON-OFF FACE PLATE	1
10	EAST0134-8	LEG LARGE DRAWER MM	1
	EAST1035	DRAWER PULL	1
11	SUBA0106	MAGNET & HOLDER LOWER	3
12	SUBA0105	LEVELING FOOT ASSY.5/8 7"	4
13	SUB01461*	HEAD RETURN CYLINDER KIT*	3
	EAST0438*	HEAD RETURN BALL JOINT*	3
15	EAST0512	HOT KNIFE ACTUATOR MM	1
16	EAST0252	SEAL BAR LOWER FRONT 50"	1
17	EAST0007	SEAL BAR LOWER SIDE 20" MM	1
18	EAST0840*	CONVEYOR CRANK HANDLE MM*	2
19	EAST0209*	SPONGE RUBBER 1/4" X 3/4"*	6 FT
20	EAST0075*	BUSHING CONVEYOR LIFT*	2
21	EAST0791	HOT KNIFE WIRE GUARD 50"	1
22	EAST0524	HOT KNIFE WIRE GUARD SIDE	1
23	EAST0238	WIRE HOLE BUSHING	4
26	EAST0597	HOT KNIFE CONDUIT BRACKET	1
27	EAST0606	SPACER BAR 50"	1
28	EAST1019*	COLLAR-SET SCREW 3/8" ID*	4
29	EAST0363	HEAD SHIMS 16GA	3
30	EAST0156	SNAP RING 3/4"	4

\* One each of items marked with an asterisk (\*) are included in spare parts kit SUBK100-2050. Specify electrical power requirements (-V number) when ordering.

#### SEAL HEAD, HOT KNIFE EM2050TK MUSHROOM PTFE/PFA – SUBA0211-50

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	EAST0022	PILLOW BLOCK 1"	3
2	EAST0046	REAR SHAFT 54"	1
3	EAST0745	HANDLE FOR SEALER EM50	1
4	EAST0338	MAGNET HOLDER UP EM40 MM	1
5	EAST0456	HEAD RETURN ARM MM	2
6	EAST0511	HOT KNIFE SADDLE W/SLOT MM	4
7	EAST0511E	HOT KNIFE SADDLE W/EXSLOT	1

## 70 Parts List

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
8	EAST0514	HOT KNIFE SPACER BLOCK MM	2
9	EAST0515	HOT KNIFE CORNER SPACER MM	1
10	EAST0560	HOT KNIFE THREADED ROD	6
11	EAST0516	HOT KNIFE SEAL BAR UP 20"	1
12	EAST0785	HOT KNIFE SEAL BAR UPPER	1
13	EAST0790	CROSS OVER BAR 50"	1
14	EAST0788	SAFETY SHIELD INNER 50" F	1
15	EAST0789	SAFETY SHIELD OUTER 50" F	1
16	EAST0522	SAFETY SHIELD INNER 20" S	1
17	EAST0523	SAFETY SHIELD OUTER 20" S	1
18	EAST0678*	FIREROD CART 220V 50"	1
19	EAST0496*	FIREROD CART 220V 20"	1
20	EAST0507	HOT KNIFE ARM CASTING	1
21	EAST0508	HOT KNIFE ARM CASTING	1
22	EAST0810	HOT KNIFE MAGNET HOLDER	1
23	EAST0837**	CUTTING RULE FRONT 50"***	1
24	EAST0815**	CUTTING RULE SIDE 20" MM**	1
25	EAST0900	MAGNET HOLDER UPPER	1
26	EAST0901	MAGNET HOLDER UPPER PAD	1
27	EAST0786**	MUSHROOM INSERT FRONT 50"***	1
28	EAST0918**	MUSHROOM INSERT SIDE 20"***	1
29	EAST1007	SAFETY SHIELD SPRING	4
30	EAST1018	COLLAR 1"	2
31	EP000095	HOT KNIFE SPACER BLOCK	4
32	EAST0514E	HOT KNIFE SPACER BLOCK	1
33	EP000535*	THERMOCOUPLE HOT KNIFE*	2
34	SUBA0065	MAGNET UPPER (NEW 3 PART)	2
35	XH348	SPLIT TENSION PIN 3/16	6
36	XH360	BOLT 1/4 X 1-1/4 SHOULDER	4
37	EAST0165	HANDLE GRIP MATERIAL	4 FT
38	EAST0810	HOT KNIFE MAGNET HOLDER	1

\* One each of items marked with an asterisk (\*) are included in spare parts kit SUBK100-2050. Specify electrical power requirements (-V number) when ordering.

\*\*One each of items marked with two asterisks (\*\*) are included in the cutting rule and mushroom insert kit SUBK00222-2050.

## CONVEYOR TAKEAWAY EM2050TK – SUBA0036B

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	EAST0051	SPROCKET DRV ROLL 5/8 BAND	1
2	EAST0052	BEARING FOR GUIDE ROLLERS	8
3	EAST0055	TIMING BELT EM28 & EM40	1
4	EAST0056	DRIVE ROLLER SHFT 19.125"	1
5	EAST0059	CONVEYOR BELT EM40 6403	1
6	EAST0060-2	SCISSOR JACK TOP H	2
7	EAST0060-8	SCISSOR JACK RIGHT LEG W/	2
8	EAST0060-9	SCISSOR JACK LEFT LEG W/	2
9	EAST0060-10	SCISSOR JACK BOTTOM H W/	2
10	EAST0060-4L	SCISSOR JACK BRACKET SIDE	2
11	EAST0060-4R	SCISSOR JACK BRACKET SIDE	2
12	EAST0061*	BARREL NUT M/M*	2
13	EAST0063	MOTOR CONVEYOR SEALERS	1
14	EAST0065	CONVEYOR GUIDE ROLLER MM	3
15	EAST0069	CONVEYOR CROSS BAR 20"	4
16	EAST0071	CONVEYOR MOTOR MOUNT BACK	1
17	EAST0072	CONVEYOR SIDE BAR FRONT	1
18	EAST0187	DRIVE ROLLER ITSELF CONV	1
19	EAST0188	IDLER ROLLER ITSELF CONV	1
20	EAST0194	IDLER ROLLER SHAFT 18"	1
21	EAST0199-MOD	SPROCKET BANDO/STEEL TIMING	1
22	EAST0214	ADJUSTING BRACKET ON MM	1
23	EAST0243	CONV GUIDE ROLLER SHFT MM	3
24	EAST0250	CONVEYOR TRAY EM40 SS	1
25	EAST0254	BEARING FOR DRIVE ROLLER	2
26	EAST0604	DRIVE ROLLER END CAP	1
27	EAST0605	DRIVE ROLLER END CAP	1
28	EAST1013	SNAP RING 1/2" FOR DRIVE	2
29	EAST1014	SNAP RING 3/8"	8
	EAST1004	ROMEX CONNECTOR 3/8"	1
	ESC00563	POWER CORD 18-3 SO CORD	13 FT

\* One each of items marked with an asterisk (\*) are included in spare parts kit SUBK100-2050. Specify electrical power requirements (-V number) when ordering.

**FILM RACK 26" WITH PIN PERFORATOR – SUBA0032**

See the Film Rack section of this Parts section for the Film Rack parts breakdown.

**ELECTRICAL BOARD EM2050-TKV1, 4050-TKV1 & 5050-TKV1 – SUBA1064**

See the Electrical Board section of this Parts section for the Electrical Board Parts breakdown.

**EM2070TK Professional Series L-Sealer Main Assembly**

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	SUBA0211-70	SEAL HEAD HOT KNIFE EM2070 MUSHROOM PTFE/PFA	1
2	SUBA1002	CONVEYOR TAKEAWAY EM2070	1
3	SUBA0032	FILM RACK 26" WITH PIN PERFORATOR	1
4	SUBA1073	ELECTRICAL BOARD EM2070 EM2080 EM20100 EM3070 EM3080 EM30100 EM4070 EM4080 EM5070 EM5080 EM50100	1
5	EAST0535	PRODUCT TRAY 20X70	1
	EAST0143	PRODUCT TRAY TUBE 16/28/40	5
6	EAST0494*	TEMPERATURE CONTROL FOR SEAL BARS*	2
7	EAST1030*	TIMER DWELL/CONVEYOR 220VAC 5A DPDT TON*	2
8	ETC00002*	KNOB VELOCITY CONTROL*	2
	ETC00210	KNOB ELECTRICAL PANEL	1
9	ETC00309	SWITCH POWER ON / OFF TOGGLE	1
	ETC00310	SWITCH POWER ON / OFF FACE PLATE	1
10	EAST0134-8	LEG LARGE DRAWER MM	1
	EAST1035	DRAWER PULL	1
11	SUBA0106	MAGNET & HOLDER LOWER	4
12	SUBA0105	LEVELING FOOT ASSY. 5/8 7"	8
13	SUB01461*	HEAD RETURN CYLINDER KIT*	4
	EAST0438*	HEAD RETURN BALL JOINT*	4
14	ECOS0120	COUNTERWEIGHT HOT KNIFE	1
	RM000020	COUNTERWEIGHT	1
15	EAST0512	HOT KNIFE ACTUATOR MM	1
16	EAST0529	SEAL BAR LOWER FRONT 70"	1
17	EAST0007	SEAL BAR LOWER SIDE 20" MM	1
18	EAST0840*	CONVEYOR CRANK HANDLE MM*	2
19	EAST0209*	SPONGE RUBBER 1/4" X 3/4"	8.5 FT
20	EAST0075*	BUSHING CONVEYOR LIFT*	2
21	EAST0792SP	WIRE GAURD FRONT SP 70"	1



ITEM	PART NUMBER	DESCRIPTION	QUANTITY
22	EAST0524SP	HOT KNIFE WIRE GUARD 20" SIDE SP	1
23	EAST0238	WIRE HOLE BUSHING	4
24	EAST0320	CONNECTOR BUTT SEAM RING	1
25	EAST0321	CONNECTOR BUTT SEAM RING	4
26	EAST0597	HOT KNIFE CONDUIT BRACKET	1
27	EAST0530	SPACER BAR 70"	1
28	EAST1019*	COLLAR-SET SCREW 3/8" ID*	4
29	EAST0363	HEAD SHIMS 16GA	9
30	EAST0156	SNAP RING 3/4"	5
31	ETC00117	IDLER ADJUST BOLT 5/16-18	2
32	EAST0029*	SWITCH LIMIT MICRO*	2
33	EP000207	PFU TERMINAL STRIP BOX	1
34	EAST0185	TERMINAL STRIP 10 PLACE	1
35	EAST0081	TERMINAL STRIP 5 PLACE	1
36	EP000543	STUD FILM UNWIND	1
37	EAST1004	ROMEX CONNECTOR 3/8"	2
38	EP000559	POWER CORD 18-4 SO CORD	5.5 FT

\* One each of items marked with an asterisk (\*) are included in spare parts kit SUBK100-2070. Specify electrical power requirements (-V number) when ordering.

#### SEAL HEAD, HOT KNIFE EM2070TK MUSHROOM PTFE/PFA – SUBA0211-70

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	EAST0022	PILLOW BLOCK 1"	4
2	EAST0532	REAR SHAFT EM70	1
3	EAST0747	HANDLE FOR SEALER EM70	1
4	EAST0338	MAGNET HOLDER UP EM40 MM	2
5	EAST0456	HEAD RETURN ARM MM	2
6	EAST0511	HOT KNIFE SADDLE W/SLOT MM	4
7	EAST0511E	HOT KNIFE SADDLE W/EXSLOT	2
8	EAST0514	HOT KNIFE SPACER BLOCK MM	3
9	EAST0515	HOT KNIFE CORNER SPACER MM	1
10	EAST0560	HOT KNIFE THREADED ROD	7
11	EAST0516	HOT KNIFE SEAL BAR UP 20"	1
12	EAST0762	HOT KNIFE SEAL BAR UP 70"	1
13	EAST0767	CROSS OVER BAR 70"	1
14	EAST0793	SAFETY SHIELD INNER 70" F	1
15	EAST0794	SAFETY SHIELD OUTER 70" F	1

## 74 Parts List

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
16	EAST0522	SAFETY SHIELD INNER 20" S	1
17	EAST0523	SAFETY SHIELD OUTER 20" S	1
18	ESC00580*	FIREROD CART 220V 35"	2
19	EAST0496*	FIREROD CART 220V 20"	1
20	EAST0507	HOT KNIFE ARM CASTING	1
21	EAST0508	HOT KNIFE ARM CASTING	1
22	EAST0256	ARM CASTING CENTER 20" HK	1
23	EAST0810	HOT KNIFE MAGNET HOLDER	2
24	EAST0820**	CUTTING RULE FRONT 70"	1
25	EAST0815**	CUTTING RULE SIDE 20" MM	1
26	EAST0900	MAGNET HOLDER UPPER	2
27	EAST0901	MAGNET HOLDER UPPER PAD	2
28	EAST0763**	MUSHROOM INSERT FRONT 70"	1
29	EAST0918**	MUSHROOM INSERT SIDE 20"	1
30	EAST1007	SAFETY SHIELD SPRING	5
31	EAST1018	COLLAR 1"	2
32	EP000095	HOT KNIFE SPACER BLOCK	4
33	EAST0514E	HOT KNIFE SPACER BLOCK	1
34	EP000535*	THERMOCOUPLE HOT KNIFE*	3
35	ESC00037	HOT KNIFE SADDLE CENTER	1
36	SUBA0065	MAGNET UPPER (NEW 3 PART)	2
37	WH209	SPLIT TENSION PIN 3/16 X	2
38	XH348	SPLIT TENSION PIN 3/16	7
39	XH360	BOLT 1/4 X 1-1/4 SHOULDER	5
40	EAST0165	HANDLE GRIP MATERIAL	6 FT

\* One each of items marked with an asterisk (\*) are included in spare parts kit SUBK100-2070. Specify electrical power requirements (-V number) when ordering.

\*\*One each of items marked with two asterisks (\*\*) are included in the cutting rule and mushroom insert kit SUBK00222-2070.

## CONVEYOR, TAKEAWAY EM2070TK – SUBA1002

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
2	EAST0053	DRIVE ROLLER EM16/28/	1
3	EAST0055	TIMING BELT EM28 & EM40	1
4	SUBA0360	SCISSOR JACK ASSEMBLY	2
5	EAST0527	CONVEYOR BELT EM20X70	1
6	EAST0484	MOTOR-110/230V 1PH 97RPM 1:15	1

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
7	SUBA0191	GUIDE ROLLER 20"	5
8	EAST0069	CONVEYOR CROSS BAR 20"	5
9	EAST0539	CONVEYOR MOTOR MOUNT SIDE	1
10	EAST0540	CONVEYOR SIDE BAR 20X70 &	1
12	EAST0198	IDLER ROLLER - ASSEMBELED	1
14	EAST0199	SPROCKET BANDO/STEEL TIMING	1
15	EAST0214	ADJUSTING BRACKET ON MM	1
17	EAST0537	CONVEYOR TRAY EM70 SS	1
	EAST1004	ROMEX CONNECTOR 3/8"	1
	ESC00563	POWER CORD 18-3 SO CORD	13 FT

\* One each of items marked with an asterisk (\*) are included in spare parts kit SUBK100-2070. Specify electrical power requirements (-V number) when ordering.

#### FILM RACK 26" WITH PIN PERFORATOR – SUBA0032

See the Film Rack section of this Parts section for the Film Rack parts breakdown.

ELECTRICAL BOARD EM2070-TKV1, EM2080-TKV1 & EM20100-TKV1, EM3070-TKV1, EM3080-TKV1 & EM30100-TKV1, EM4070-TKV1 & EM4080-TKV1, EM5070-TKV1, EM5080-TKV1 & EM50100 – SUBA1073-TKV1

See the Electrical Board section of this Parts section for the Electrical Board Parts breakdown.

#### EM2080TK Professional Series L-Sealer Main Assembly

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	SUBA0211-80	SEAL HEAD HOT KNIFE EM2080 MUSHROOM PTFE/PFA	1
2	SUBA1032	CONVEYOR TAKEAWAY EM2080	1
3	SUBA0032	FILM RACK 26" WITH PIN PERFORATOR	1
4	SUBA1073	ELECTRICAL BOARD EM2070 EM2080 EM20100 EM3070 EM3080 EM30100 EM4070 EM4080 EM5070 EM5080 EM50100	1
5	EAST0897R	PRODUCT TRAY EM80 RIGHT	1
	EAST0143	PRODUCT TRAY TUBE16/28/40	6
6	EAST0494*	TEMPERATURE CONTROL FOR SEAL BAR*	2

## 76 Parts List

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
7	EAST1030*	TIMER DWELL/CONVEYOR 220VAC 5A DPDT TON*	2
8	ETC00002*	KNOB VELOCITY CONTROL*	2
9	ETC00309	SWITCH POWER ON / OFF TOGGLE	1
	ETC0310	SWITCH POWER ON / OFF FACE PLATE	1
10	EAST0134-8	LEG LARGE DRAWER MM	1
	EAST1035	DRAWER PULL	1
11	SUBA0106	MAGNET & HOLDER LOWER	4
12	SUBA0105	LEVELING FOOT ASSY.5/8 7"	8
13	SUB01461*	HEAD RETURN CYLINDER KIT*	4
	EAST0438*	HEAD RETURN BALL JOINT*	4
14	ECOS0120	COUNTERWEIGHT HOT KNIFE	1
	TM130016	COUNTERWEIGHT MINI	1
15	EAST0512	HOT KNIFE ACTUATOR MM	1
16	EAST0892	SEAL BAR LOWER FRONT 80"	1
17	EAST0007	SEAL BAR LOWR SIDE 20" MM	1
18	EAST0840*	CONVEYOR CRANK HANDLE MM*	2
19	EAST0209*	SPONGE RUBBER 1/4" X 3/4"**	8.5 FT
20	EAST0075*	BUSHING CONVEYOR LIFT*	2
21	EAST0835	HOT KNIFE WIRE GUARD FRONT 80"	1
22	EAST0524SP	HOT KNIFE WIRE GUARD SIDE 20" SP	1
	ETC00233	DEFLECTOR SHIELD SPACER	2
23	EAST0238	WIRE HOLE BUSHING	4
24	EAST0320	CONNECTOR BUTT SEAM RING	1
25	EAST0321	CONNECTOR BUTT SEAM RING	4
26	EAST0597	HOT KNIFE CONDUIT BRACKET	1
27	EAST0898	SPACER BAR 80"	1
28	EAST1019*	COLLAR-SET SCREW 3/8" ID*	4
29	EAST0363	HEAD SHIMS 16GA	9
30	EAST0156	SNAP RING 3/4"	6
31	ETC00117	IDLER ADJUST BOLT 5/16-18	2
32	EAST0029*	SWITCH LIMIT MICRO*	2
35	EAST0081	TERMINAL STRIP 5 PLACE	1
37	EAST1004	ROMEX CONNECTOR 3/8"	2

\* One each of items marked with an asterisk (\*) are included in spare parts kit SUBK100-2080. Specify electrical power requirements (-V number) when ordering.

SEAL HEAD, HOT KNIFE EM2080TK MUSHROOM PTFE/PFA – SUBA0211-80

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	EAST0022	PILLOW BLOCK 1"	3
2	EAST0890	REAR SHAFT EM80 84"	1
3	EAST0748	HANDLE FOR SEALER EM80	1
4	EAST0338	MAGNET HOLDER UP EM40 MM	4
5	EAST0456	HEAD RETURN ARM MM	4
6	EAST0511	HOT KNIFE SADDLE W/SLOT MM	5
7	EAST0511E	HOT KNIFE SADDLE W/EXSLOT	2
8	EAST0514	HOT KNIFE SPACER BLOCK MM	4
9	EAST0515	HOT KNIFE CORNER SPACER MM	1
10	EAST0560	HOT KNIFE THREADED ROD	7
11	EAST0516	HOT KNIFE SEAL BAR UP 20"	1
12	EAST0858	HOT KNIFE SEAL BAR UPPER	1
13	EAST0857	CROSS OVER BAR 80"	1
14	EAST0859	SAFETY SHIELD INNER 80" F	1
15	EAST0860	SAFETY SHIELD OUTER 80" F	1
16	EAST0522	SAFETY SHIELD INNER 20" S	1
17	EAST0523	SAFETY SHIELD OUTER 20" S	1
18	EAST0629*	FIREROD CART 220V 40"	2
19	EAST0496*	FIREROD CART 220V 20"	1
20	EAST0507	HOT KNIFE ARM CASTING	1
21	EAST0508	HOT KNIFE ARM CASTING	1
22	EAST0256	ARM CASTING CENTER 20" HK	1
23	EAST0810	HOT KNIFE MAGNET HOLDER	2
24	EAST0824**	CUTTING RULE FRONT 80" SUP**	1
25	EAST0815**	CUTTING RULE SIDE 20" MM**	1
26	EAST0900	MAGNET HOLDER UPPER	2
27	EAST0901	MAGNET HOLDER UPPER PAD	2
28	EAST0916**	MUSHROOM INSERT FRONT 40"***	2
29	EAST0918**	MUSHROOM INSERT SIDE 20"***	1
30	EAST1007	SAFETY SHIELD SPRING	5
31	EAST1018	COLLAR 1"	2
32	EP000095	HOT KNIFE SPACER BLOCK	4
33	EAST0514E	HOT KNIFE SPACER BLOCK	1

## 78 Parts List

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
34	EP000535*	THERMOCOUPLE HOT KNIFE*	3
35	SUBA0065	MAGNET UPPER (NEW 3 PART)	2
36	ESC00037	HOT KNIFE SADDLE CENTER	1
37	WH209	SPLIT TENSION PIN 3/16 X	2
38	XH348	SPLIT TENSION PIN 3/16	7
39	XH360	BOLT 1/4 X 1-1/4 SHOULDER	5
40	EAST0165	HANDLE GRIP MATERIAL	6.75 FT

\* One each of items marked with an asterisk (\*) are included in spare parts kit SUBK100-2080. Specify electrical power requirements (-V number) when ordering.

\*\*One each of items marked with two asterisks (\*\*) are included in the cutting rule and mushroom insert kit SUBK00222-2080.

## CONVEYOR, TAKEAWAY EM2080TK – SUBA1032

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	EAST0051	SPROCKET DRV ROLL 5/8BAND	1
2	EAST0052	BEARING FOR GUIDE ROLLERS	14
3	EAST0055	TIMING BELT EM28 & EM40	1
4	EAST0056	DRIVE ROLLER SHFT 19.125"	1
5	EAST0601	CONVEYOR BELT EM20X80	1
6	EAST0060-2	SCISSOR JACK TOP H	1
7	EAST0060-8	SCISSOR JACK RIGHT LEG W/	1
8	EAST0060-9	SCISSOR JACK LEFT LEG W/	1
9	EAST0060-10	SCISSOR JACK BOTTOM H W/	1
10	EAST0060-4L	SCISSOR JACK BRACKET SIDE	1
11	EAST0060-4R	SCISSOR JACK BRACKET SIDE	1
12	EAST0061*	BARREL NUT M/M*	1
13	EAST0484	MOTOR-110/230V 1PH 97RPM 1:15	1
14	EAST0065	CONVEYOR GUIDE ROLLER MM	6
15	EAST0069	CONVEYOR CROSS BAR 20"	6
16	EAST0895	CONVEYOR MOTOR MOUNT SIDE	1
17	EAST0896	CONVEYOR SIDE FRONT BAR	1
18	EAST0187	DRIVE ROLLER ITSELF CONV	1
19	EAST0188	IDLER ROLLER ITSELF CONV	1
20	EAST0194	IDLER ROLLER SHAFT 18"	1
21	EAST0199	SPROCKET BANDO/STEEL TIMING	1
22	EAST0214	ADJUSTING BRACKET ON MM	1
23	EAST0243	CONV GUIDE ROLLER SHAFT MM	6
24	EAST0894	CONVEYOR TRAY EM80 SS	1

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
25	EAST0254	BEARING FOR DRIVE ROLLER	2
26	EAST0604	DRIVE ROLLER END CAP	1
27	EAST0605	DRIVE ROLLER END CAP	1
28	EAST1013	SNAP RING 1/2" FOR DRIVE	2
29	EAST1014	SNAP RING 3/8"	14
30	EAST1004	ROMEX CONNECTOR 3/8"	1
31	ESC00563	POWER CORD 18-3 SO CORD	13 FT

\* One each of items marked with an asterisk (\*) are included in spare parts kit SUBK100-2080. Specify electrical power requirements (-V number) when ordering.

### FILM RACK 26" WITH PIN PERFORATOR – SUBA0032

See the Film Rack section of this Parts section for the Film Rack parts breakdown.

ELECTRICAL BOARD EM2070-TKV1, EM2080-TKV1 & EM20100-TKV1, EM3070-TKV1, EM3080-TKV1 & EM30100-TKV1, EM4070-TKV1 & EM4080-TKV1, EM5070-TKV1, EM5080-TKV1 & EM50100-TKV1 – SUBA1073

See the Electrical Board section of this Parts section for the Electrical Board Parts breakdown.

### EM20100TK Professional Series L-Sealer Main Assembly

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	SUBA0211-80	SEAL HEAD HOT KNIFE EM2080 MUSHROOM PTFE/PFA	1
2	SUBA1032	CONVEYOR TAKEAWAY EM2080	1
3	SUBA0032	FILM RACK 26" WITH PIN PERFORATOR	1
4	SUBA1073	ELECTRICAL BOARD EM2070 EM2080 EM20100 EM3070 EM3080 EM30100 EM4070 EM4080 EM5070 EM5080 EM50100	1
5		PRODUCT TRAY 20 X 100	1
6	EAST0494*	TEMPERATURE CONTROL FOR SEAL BARS*	2
7	EAST1030*	TIMER DWELL/CONVEYOR 220VAC 5A DPDT TON*	2
8	ETC00002*	KNOB VELOCITY CONTROL*	2
	ETC00210	KNOB ELECTRICAL PANEL	1
9	ETC00309	SWITCH POWER ON / OFF TOGGLE	1
	ETC00310	SWITCH POWER ON / OFF FACE PLATE	1
10	EAST0134-8	LEG LARGE DRAWER MM	1
	EAST1035	DRAWER PULL	1

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
11	SUBA0106	MAGNET & HOLDER LOWER	5
12	SUBA0105	LEVELING FOOT ASSY.5/8 7"	4
13	SUB01461*	HEAD RETURN CYLINDER KIT*	4
	EAST0438*	HEAD RETURN BALL JOINT*	4
14	EAST0526	COUNTERWEIGHT 15.25" EM16TK	3
15	SP980003	HOT KNIFE ACTUATOR SP98	1
16	EAST0861	SEAL BAR LOWER FRONT 100"	1
17	EAST0007	SEAL BAR LOWR SIDE 20" MM	1
18	EAST0840*	CONVEYOR CRANK HANDLE MM*	2
19	EAST0209*	SPONGE RUBBER 1/4" X 3/4"*	9.25 FT
20	EAST0075*	BUSHING CONVEYOR LIFT*	2
21	EAST0830	WIRE GUARD 100" HOT KNIFE	1
22	EAST0524SP	HOT KNIFE WIRE GUARD 20" SIDE SP	1
23	EAST0238	WIRE HOLE BUSHING	5
24	EAST0320	CONNECTOR BUTT SEAM RING	4
25	EAST0321	CONNECTOR BUTT SEAM RING	4
26	EAST0597	HOT KNIFE CONDUIT BRACKET	1
27	EAST0862	SPACER BAR LOWER 100"	1
28	EAST1019*	COLLAR-SET SCREW 3/8" ID*	4
29	EAST0363	HEAD SHIMS 16GA	9
32	EAST0029*	SWITCH LIMIT MICRO*	2
	SA000006	LIMIT SWITCH COVER	1
33	EP000207	PFU TERMINAL STRIP BOX	1
34	EAST0185	TERMINAL STRIP 10 PLACE	1
37	EAST1004	ROMEX CONNECTOR 3/8"	3

\* One each of items marked with an asterisk (\*) are included in spare parts kit SUBK100-20100. Specify electrical power requirements (-V number) when ordering.

#### SEAL HEAD, HOT KNIFE EM20100TK MUSHROOM PTFE/PFA – SUBA0211-100

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	EAST0022	PILLOW BLOCK 1"	5
2	EAST0176	REAR SHAFT 104" EMXX100s	1
3	EAST0177	HANDLE FOR SEALER EM40100	1



ITEM	PART NUMBER	DESCRIPTION	QUANTITY
4	EAST0338	MAGNET HOLDER UP EM40 MM	1
5	EAST0456	HEAD RETURN ARM MM	2
6	EAST0511	HOT KNIFE SADDLE W/SLOT MM	4
7	EAST0511E	HOT KNIFE SADDLE W/EXSLOT	3
8	EAST0514	HOT KNIFE SPACER BLOCK MM	2
9	EAST0515	HOT KNIFE CORNER SPACER MM	1
10	EAST0560	HOT KNIFE THREADED ROD	8
11	EAST0656	HOT KNIFE SEAL BAR UP 100" FRONT	1
12	EAST0516	HOT KNIFE SEAL BAR UP 20" SIDE	1
13	EAST0659	CROSS OVER BAR 100"	1
14	EAST0658	SAFETY SHIELD INNER 100" FRONT	1
15	EAST0657	SAFETY SHIELD OUTER 100" FRONT	1
16	EAST0522	SAFETY SHIELD INNER 20" SIDE	1
17	EAST0523	SAFETY SHIELD OUTER 20" SIDE	1
18	EAST0678*	FIREROD CART 220V 50"	2
19	EAST0496*	FIREROD CART 220V 20"	1
20	EAST0507	HOT KNIFE ARM CASTING EXIT	1
21	EAST0508	HOT KNIFE ARM CASTING INFEED	1
22	EAST0256	ARM CASTING CENTER 20" HK	2
23	EAST0810	HOT KNIFE MAGNET HOLDER	3
24	EAST0839**	CUTTING RULE FRONT 101.5"***	1
25	EAST0815**	CUTTING RULE SIDE 20" MM**	1
26	EAST0900	MAGNET HOLDER UPPER	3
27	EAST0901	MAGNET HOLDER UPPER PAD	3
28	EAST0786**	MUSHROOM INSERT FRONT 50"***	2
29	EAST0918**	MUSHROOM INSERT SIDE 20"***	1
30	EAST1007	SAFETY SHIELD SPRING	5
31	EAST1018	COLLAR 1"	2
32	EP000095	HOT KNIFE SPACER BLOCK	5
33	EAST0514E	HOT KNIFE SPACER BLOCK	2
34	EP000535*	THERMOCOUPLE HOT KNIFE*	3
35	ESC00037	HOT KNIFE SADDLE CENTER	1
36	SUBA0065	MAGNET UPPER (NEW 3 PART)	2
37	WH209	SPLIT TENSION PIN 3/16 X	3
38	XH348	SPLIT TENSION PIN 3/16	8
39	XH360	BOLT 1/4 X 1-1/4 SHOULDER	5
40	EAST0165	HANDLE GRIP MATERIAL	8

\* One each of items marked with an asterisk (\*) are included in spare parts kit SUBK100-20100. Specify electrical power requirements (-V number) when ordering.

\*\*One each of items marked with two asterisks (\*\*) are included in the cutting rule and mushroom insert kit SUBK00222-20100.

### CONVEYOR, TAKEAWAY EM20100TK – SUBA0036M

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	EAST0051	SPROCKET DRV ROLL 5/8BAND	1
2	EAST0052	BEARING FOR GUIDE ROLLERS	16
3	EAST0055	TIMING BELT EM28 & EM40	1
4	EAST0056	DRIVE ROLLER SHFT 19.125"	1
5	EAST1107	CONVEYOR BELT EM100 BLACK	1
6	EAST0060-2	SCISSOR JACK TOP H	2
7	EAST0060-8	SCISSOR JACK RIGHT LEG W/	2
8	EAST0060-9	SCISSOR JACK LEFT LEG W/	2
9	EAST0060-10	SCISSOR JACK BOTTOM H W/	2
10	EAST0060-4L	SCISSOR JACK BRACKET SIDE	2
11	EAST0060-4R	SCISSOR JACK BRACKET SIDE	2
12	EAST0061*	BARREL NUT M/M*	2
13	EAST0063	MOTOR CONVEYOR SEALERS	1
14	EAST0065	CONVEYOR GUIDE ROLLER MM	7
15	EAST0069	CONVEYOR CROSS BAR 20"	6
16	EAST0660	CONVEYOR MTR MNT SIDE100"	1
17	EAST0661	CONVEYOR SIDE BAR FNT 100	1
18	EAST0187	DRIVE ROLLER ITSELF CONV	1
19	EAST0188	IDLER ROLLER ITSELF CONV	1
20	EAST0194	IDLER ROLLER SHAFT 18"	1
21	EAST0199	SPROCKET BANDO/STEEL TIMING	1
22	EAST0214	ADJUSTING BRACKET ON MM	1
23	EAST0243	CONV GUIDE ROLLER SHFT MM	7
24	EAST1109	CONVEYOR TRAY 20 X 100	1
25	EAST0254	BEARING FOR DRIVE ROLLER	2
26	EAST0604	DRIVE ROLLER END CAP	1
27	EAST0605	DRIVE ROLLER END CAP	1
28	EAST1013	SNAP RING 1/2" FOR DRIVE	2
29	EAST1014	SNAP RING 3/8"	16
30	EAST1004	ROMEX CONNECTOR 3/8"	1
31	ESC00563	POWER CORD 18-3 SO CORD	13 FT

\* One each of items marked with an asterisk (\*) are included in spare parts kit SUBK100-20100. Specify electrical power requirements (-V number) when ordering.

FILM RACK 26" WITH PIN PERFORATOR – SUBA0032

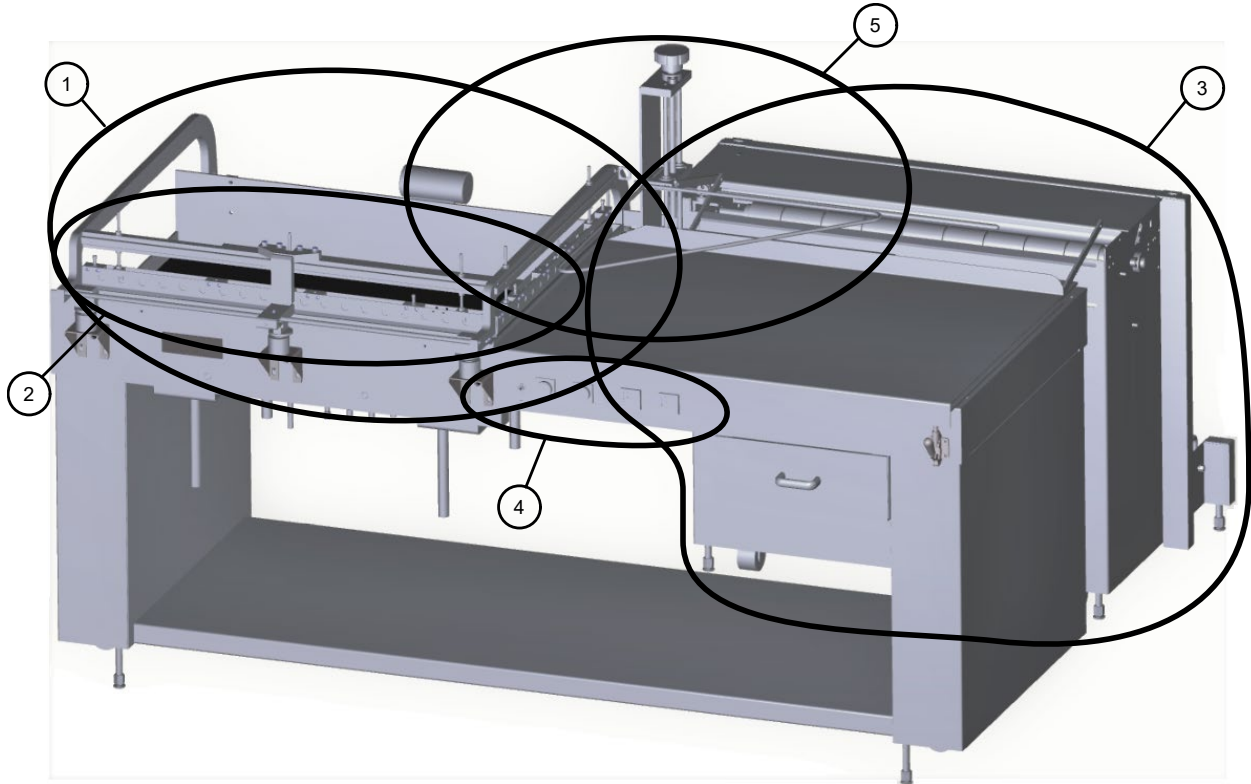
See the Film Rack section of this Parts section for the Film Rack parts breakdown.

ELECTRICAL BOARD EM2070-TKV1, EM2080-TKV1 & EM20100-TKV1, EM3070-TKV1, EM3080-TKV1 & EM30100-TKV1, EM4070-TKV1 & EM4080-TKV1, EM5070-TKV1, EM5080-TKV1 & EM50100-TKV1 – SUBA1073

See the Electrical Board section of this Parts section for the Electrical Board Parts breakdown.

## EM30 Series L-Sealers

### EM3040TK, EM3050TK, EM3070TK, EM3080TK & EM30100TK

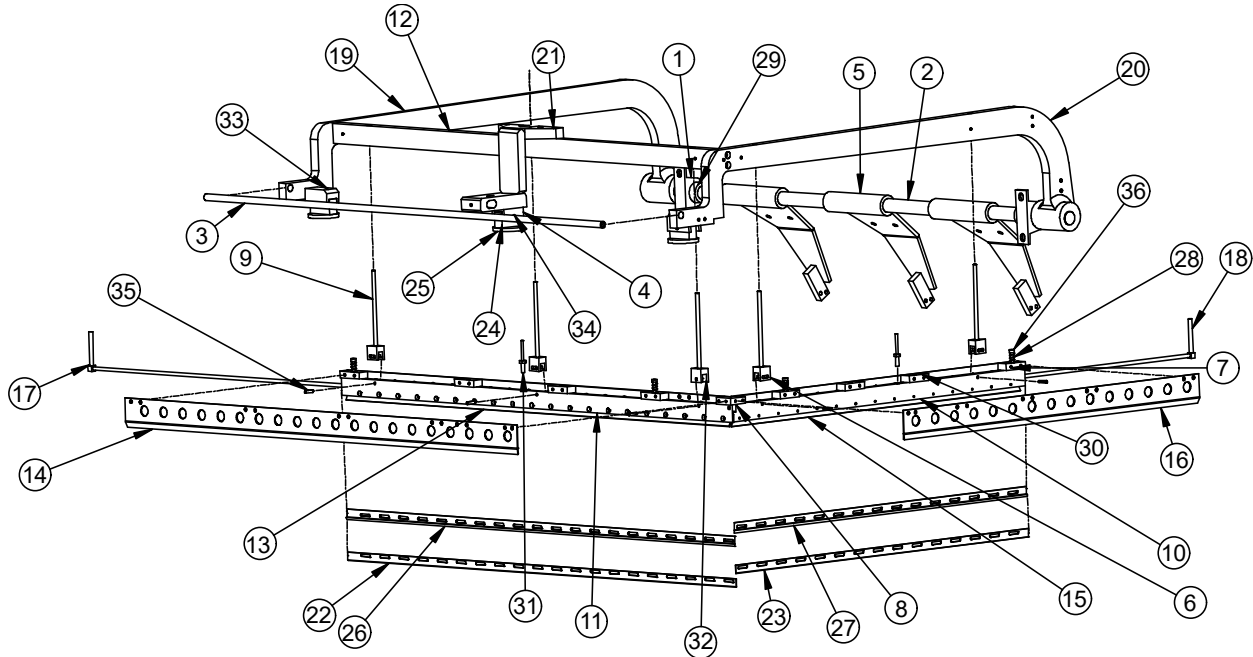


#### EM3040TK Professional Series L-Sealer Main Assembly

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	SUBA0211-3040	SEAL HEAD HOT KNIFE EM3040 MUSHROOM PTFE/PFA	1
2	SUBA0036C	CONVEYOR TAKEAWAY EM3040	1
3	SUBA0033	FILM RACK 36" WITH PIN PERFORATOR	1
4	SUBA0009	ELECTRICAL BOARD EM3040	1
	EAST0416	ELECTRIC PANEL GUARD30X40	1
5	EAST0332R	PRODUCT TRAY 30X40 RIGHT	1
	EAST0155	PRODUCT TRAY TUBES 30X40	3
6	EAST0494*	TEMPERATURE CONTROL FOR SEAL BARS*	2
7	EAST1030*	TIMER DWELL/CONVEYOR 220VAC 5A DPDT TON*	2
8	ETC00210	KNOB VELOCITY CONTROL	2
9	ETC00309	SWITCH POWER ON / OFF TOGGLE	1
	ETC00310	SWITCH ON-OFF FACE PLATE	1
10	EAST0168	DRAWER COMP 30 X 40 & 50	1
	EAST1035	DRAWER PULL	1

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
11	SUBA0106	MAGNET & HOLDER LOWER	3
12	SUBA0105	LEVELING FOOT ASSY.5/8 7"	4
13	SUB01461*	HEAD RETURN CYLINDER KIT*	4
	EAST0438*	HEAD RETURN BALL JOINT*	4
	EAST0459	AIR CYL BRACKET HK	1
14	ECOS0120	COUNTERWEIGHT HOT KNIFE	1
15	EAST0512	HOT KNIFE ACTUATOR MM	1
16	EAST0255	SEAL BAR LOWER FRONT 40"	1
17	EAST0330	SEAL BAR LOWER SIDE 30"MM	1
18	EAST0404	CONVEYOR S HANDLE 30X40	1
19	EAST0209*	SPONGE RUBBER 1/4" X 3/4"*	6 FT
20	ET000113	SPROCKET UNDERSIDE COMBO	4
	ET000012	SPROCKET MARTIN 41B12 1/2	1
	ET000077	UNDERSIDE CHAIN TIGHTNER	1
	ET000072	THRUST BEARING-NICE 603	1
	ET000073	THRUST BEARING NICE 607	4
	72000006	CHAIN #41 RIVETED DRIVE	9.25 FT
	72000007	CHAIN - MASTER LINK #41R	1
21	EAST0627	HOT KNIFE WIRE GUARD FRT	1
22	EAST0626	HOT KNIFE WIRE GUARD SIDE	1
23	EAST0238	WIRE HOLE BUSHING	4
24	EAST0319	CONNECTOR BUTT SEAM BLOCK	2
25	EAST0320	CONNECTOR BUTT SEAM RING	1
26	EAST0597	HOT KNIFE CONDUIT BRACKET	1
27	EAST0468	SPACER BAR 30X40 39.875"	1
29	EAST0363	HEAD SHIMS 16GA	5
30	EAST0156	SNAP RING 3/4"	3

\* One each of items marked with an asterisk (\*) are included in spare parts kit SUBK100-3040. Specify electrical power requirements (-V number) when ordering.



## SEAL HEAD, HOT KNIFE EM3040TK MUSHROOM PTFE/PFA – SUBA0211-3040

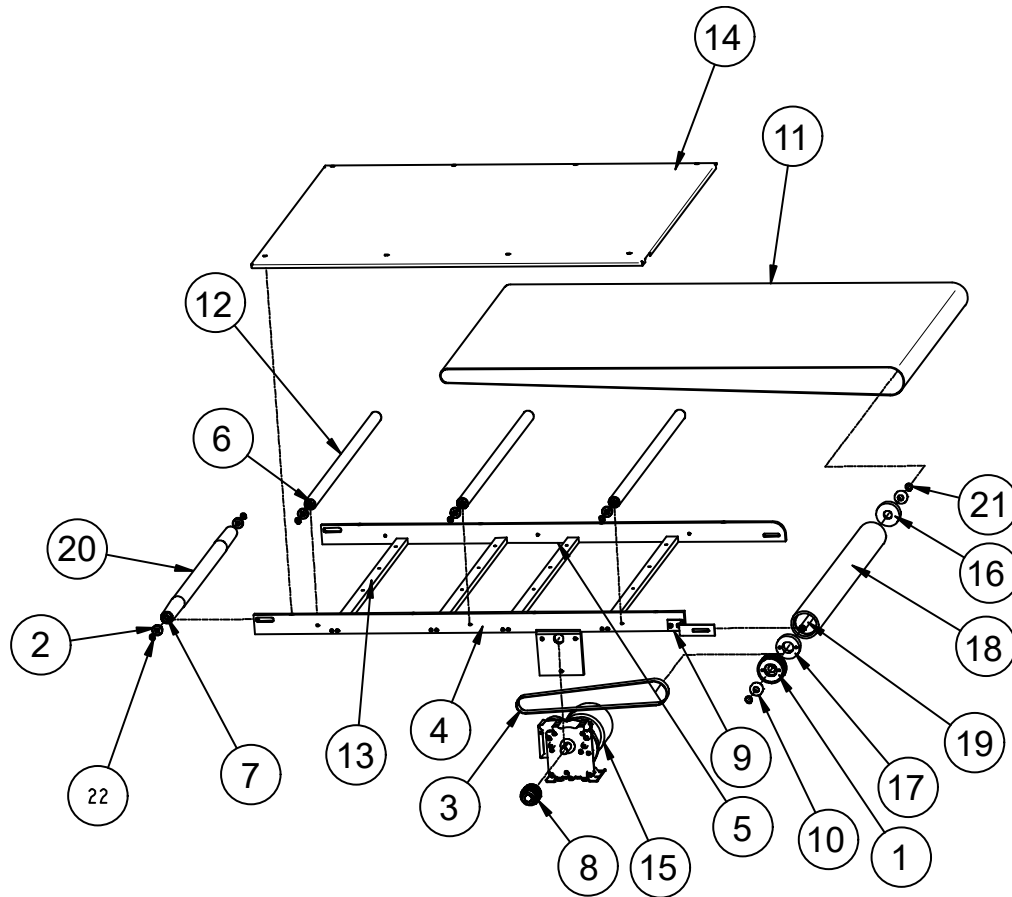
ITEM	PART NO.	DESCRIPTION	QUANTITY
1	EAST0022	PILLOW BLOCK 1"	2
2	EAST0049	REAR SHAFT EM3040 & EM40	1
3	EAST0247	HANDLE FOR SEALER EM40	1
4	EAST0338	MAGNET HOLDER UP M40 MM	1
5	EAST0456	HEAD RETURN ARM	3
6	EAST0511	HOT KNIFE SADDLE WITH SLOT	4
7	EAST0514	HOT KNIFE SPACER BLOCK	3
8	EAST0515	HOT KNIFE CORNER SPACER MM	1
9	EAST0560	HOT KNIFE THREADED ROD	5
10	EAST0615	HOT KNIFE SEAL BAR UPPER	1
11	EAST0616	HOT KNIFE SEAL BAR UPPER	1
12	EAST0621	CROSSOVER BAR EM3040	1
13	EAST0622	SAFETY SHIELD INNER 40"	1
14	EAST0623	SAFETY SHIELD OUTER 40"	1
15	EAST0624	SAFETY SHIELD INNER 30"	1
16	EAST0625	SHFETY SHIELD OUTER 30"	1
17	EAST0629*	HEATER CARTRIDGE 220V 40"*	1
18	EAST0630*	HEATER CARTRIDGE 220V 30"*	1
19	EAST0631	HOT KNIFE ARM CASTING OUT / EXIT	1
20	EAST0632	HOT KNIFE ARM CASTING IN / INFEEED	1

ITEM	PART NO.	DESCRIPTION	QUANTITY
21	EAST0810	HOT KNIFE MAGNET HOLDER	1
22	EAST0818**	HOT KNIFE CUTTING RULE FRONT40" **	1
23	EAST0819**	HOT KNIFE CUTTING RULE SIDE 30" **	1
24	EAST0900	MAGNET HOLDER UPPER	1
25	EAST0901	MAGNET HOLDER UPPER PAD	1
26	EAST0916**	MUSHROOM INSERT FRONT 40" **	1
27	EAST0917**	MUSHROOM INSERT SIDE 30" **	1
28	EAST1007	SAFETY SHIELD SPRING	4
29	EAST1018	COLLAR 1"	2
30	EP000095	HOT KNIFE SPACER BLOCK BLACK WITH HOLE	5
31	EP000535*	THERMOCOUPLE HOT KNIFE*	2
32	ESC00037	HOT KNIFE SADDLE CENTER	1
33	SUBA0065	MAGNET UPPER	2
34	WH209	SPLIT TENSION PIN	1
35	XH348	SPLIT TENSION PIN $\frac{3}{16}$ "	5
36	XH360	BOLT SHOULDER $\frac{1}{4} \times 1\frac{1}{4}$ "	4
37	EAST0165	HANDLE GRIP MATERIAL	3.5 FT.

\* One each of items marked with an asterisk (\*) are included in spare parts kit SUBK100-3040. Specify electrical power requirements (-V number) when ordering.

\*\*One each of items marked with two asterisks (\*\*) are included in the cutting rule and mushroom insert kit SUBK00222-3040.

## CONVEYOR, TAKEAWAY EM3040TK – SUBA0036C



ITEM	PART NO.	DESCRIPTION	QUANTITY
1	EAST0051	SPROCKET DRV ROLL 5/8BAND	1
2	EAST0052	BEARING FOR GUIDE ROLLERS	8
3	EAST0055	TIMING BELT EM28 & EM40	1
4	EAST0828	CONV DRIVE ROLLER SHAFT	1
5	EAST0331	CONVEYOR BELT EM30X40	1
6	EAST0051	SPROCKET DRV ROLL 5/8BAND	1
7	EAST0052	BEARING FOR GUIDE ROLLERS	8
8	EAST0055	TIMING BELT EM28 & EM40	1
9	EAST0828	CONV DRIVE ROLLER SHAFT	1
10	EAST0331	CONVEYOR BELT EM30X40	1
11	EAST0827	CONV DRIVE ROLLER ITSELF	1
12	EAST0829	CONV IDLER ROLLR/SAW+.125	1
13	EAST0193	CONV IDLER ROLLER SHAFT	1
14	EAST0199	SPROCKET BANDO/STEEL TIMI	1
15	EAST0214	ADJUSTING BRACKET ON MM	1



ITEM	PART NO.	DESCRIPTION	QUANTITY
16	EAST0190	CONV GUIDE ROLLER SHAFT	3
17	EAST0417	CONVEYOR TRAY 30X40 SS	1
18	EAST0254	BEARING FOR DRIVE ROLLER	2
19	EAST0604	DRIVE ROLLER END CAP	1
20	EAST0605	DRIVE ROLLER END CAP	1
21	EAST1013	SNAP RING 1/2" FOR DRIVE	2
22	EAST1014	SNAP RING 3/8"	8
	EAST1004	ROMEX CONNECTOR 3/8"	1
	ESC00563	POWER CORD 18-3 SO CORD	10 FT

\* One each of items marked with an asterisk (\*) are included in spare parts kit SUBK100-3040. Specify electrical power requirements (-V number) when ordering.

#### FILM RACK 36" WITH PIN PERFORATOR – SUBA0033

See the Film Rack section of this Parts section for the Film Rack parts breakdown.

#### ELECTRICAL BOARD EM3040-TKV1 – SUBA0009

See the Electrical Board section of this Parts section for Electrical Board Parts.

#### EM3050TK Professional Series L-Sealer Main Assembly

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	SUBA0211-3050	SEAL HEAD HOT KNIFE EM3050 MUSHROOM PTFE/PFA	1
2	SUBA1036E	CONVEYOR TAKEAWAY EM3050	1
3	SUBA0033	FILM RACK 36" WITH PIN PERFORATOR	1
4	SUBA1072	ELECTRICAL BOARD EM3050	1
	EAST0416	ELECTRIC PANEL GUARD30X40	1
5	EAST0482	PRODUCT TRAY 30X50	1
	EAST0155	PRODUCT TRAY TUBES 30X40	4
6	EAST0494*	TEMPERATURE CONTROL FOR SEAL BARS*	2
7	EAST1030*	TIMER DWELL/CONVEYOR 220VAC 5A DPDT TON*	2
8	ETC00002*	KNOB VELOCITY CONTROL*	2
9	ETC00309	SWITCH POWER ON / OFF TOGGLE	1
	ETC00310	SWITCH ON-OFF FACE PLATE	1
10	EAST0168	DRAWER COMP 30 X 40 & 50	1
	EAST1035	DRAWER PULL	1
11	SUBA0106	MAGNET & HOLDER LOWER	3
12	SUBA0105	LEVELING FOOT ASSY.5/8 7"	4

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
13	SUB01461*	HEAD RETURN CYLINDER KIT*	4
	EAST0438*	HEAD RETURN BALL JOINT*	4
	EAST0423	AIR CYLINDER BRACKET HK	1
14	ECOS0120	COUNTERWEIGHT HOT KNIFE	1
15	EAST0512	HOT KNIFE ACTUATOR MM	1
16	EAST0252	SEAL BAR LOWER FRONT 50"	1
17	EAST0330	SEAL BAR LOWER SIDE 30"MM	1
18	EAST0404	CONVEYOR S HANDLE 30X40	1
19	EAST0209*	SPONGE RUBBER 1/4" X 3/4"	6.5 FT
20	ET000113	SPROCKET UNDERSIDE COMBO	4
	ET000077	UNDERSIDE CHAIN TIGHTNER	1
	ET000012	SPROCKET MARTIN 41B12 1/2	1
	ET000072	THRUST BEARING-NICE 603	1
	ET000073	THRUST BEARING NICE 607	4
	72000006	CHAIN #41 RIVETED DRIVE	10.6 FT
	72000007	CHAIN - MASTER LINK #41R	1
21	EAST0791	HOT KNIFE WIRE GUARD 50"	1
22	EAST0626	HOT KNIFE WIRE GUARD SIDE	1
23	EAST0238	WIRE HOLE BUSHING	4
24	EAST0319	CONNECTOR BUTT SEAM BLOCK	2
25	EAST0320	CONNECTOR BUTT SEAM RING	1
26	EAST0597	HOT KNIFE CONDUIT BRACKET	1
27	EAST0606	SPACER BAR 50"	1
29	EAST0365	HEAD SHIMS 12GA	3
30	EAST0156	SNAP RING 3/4"	4

\* One each of items marked with an asterisk (\*) are included in spare parts kit SUBK100-3050. Specify electrical power requirements (-V number) when ordering.

#### SEAL HEAD, HOT KNIFE EM3050TK MUSHROOM PTFE/PFA – SUBA0211-3050

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	EAST0022	PILLOW BLOCK 1"	3
2	EAST0046	REAR SHAFT 54"	1
3	EAST0745	HANDLE FOR SEALER EM50	1
4	EAST0338	MAGNET HOLDER UP EM40 MM	1
5	EAST0456	HEAD RETURN ARM MM	3
6	EAST0511	HOT KNIFE SADDLE W/SLOT MM	4

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
7	EAST0511E	HOT KNIFE SADDLE W/EXSLOT	1
8	EAST0514	HOT KNIFE SPACER BLOCK MM	2
9	EAST0515	HOT KNIFE CORNER SPACER MM	1
10	EAST0560	HOT KNIFE THREADED ROD	6
11	EAST0615	HOT KNIFE SEAL BAR UPPER	1
12	EAST0785	HOT KNIFE SEAL BAR UPPER	1
13	EAST0790	CROSS OVER BAR 50"	1
14	EAST0788	SAFETY SHIELD INNER 50" F	1
15	EAST0789	SAFETY SHIELD OUTER 50" F	1
16	EAST0624	SAFETY SHIELD INNER 30" S	1
17	EAST0625	SAFETY SHIELD OUTER 30" S	1
18	EAST0678*	FIREROD CART 220V 50"	1
19	EAST0630*	FIREROD CART 220V 30"	1
20	EAST0631	HOT KNIFE ARM CASTING OUT	1
21	EAST0632	HOT KNIFE ARM CASTING IN-	1
22	EAST0810	HOT KNIFE MAGNET HOLDER	1
23	EAST0837**	CUTTING RULE FRONT 50"	1
24	EAST0819**	CUTTING RULE SIDE 30"	1
25	EAST0900	MAGNET HOLDER UPPER	1
26	EAST0901	MAGNET HOLDER UPPER PAD	1
27	EAST0786**	MUSHROOM INSERT FRONT 50"	1
28	EAST0917**	MUSHROOM INSERT SIDE 30"	1
29	EAST1007	SAFETY SHIELD SPRING	4
30	EAST1018	COLLAR 1"	2
31	EP000095	HOT KNIFE SPACER BLOCK	5
32	EAST0514E	HOT KNIFE SPACER BLOCK	1
33	EP000535*	THERMOCOUPLE HOT KNIFE*	2
34	ESC00037	HOT KNIFE SADDLE CENTER	1
35	SUBA0065	MAGNET UPPER (NEW 3 PART)	2
36	WH209	SPLIT TENSION PIN 3/16 X	1
37	XH348	SPLIT TENSION PIN 3/16	6
38	XH360	BOLT 1/4 X 1-1/4 SHOULDER	4
39	EAST0165	HANDLE GRIP MATERIAL	4 FT

\* One each of items marked with an asterisk (\*) are included in spare parts kit SUBK100-3050. Specify electrical power requirements (-V number) when ordering.

\*\*One each of items marked with two asterisks (\*\*) are included in the cutting rule and mushroom insert kit SUBK00222-3050.

CONVEYOR, TAKEAWAY EM3050TK – SUBA0036E

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	EAST0051	SPROCKET DRV ROLL 5/8BAND	1
2	EAST0052	BEARING FOR GUIDE ROLLERS	10
3	EAST0055	TIMING BELT EM28 & EM40	1
4	EAST0828	CONV DRIVE ROLLER SHAFT	1
5	EAST1027	CONVEYOR BELT EM30X50	1
6	EAST0484	MOTOR-110/230V 1PH 97RPM 1:15	1
7	EAST0333	CONV GUIDE ROLLER 30X40	4
8	EAST0334	CONV CROSS BAR 30X40	5
9	EAST0066	CONVEYOR MOTOR MOUNT SIDE	1
10	EAST0067	CONVEYOR SIDE BAR FRONT	1
11	EAST0827	CONV DRIVE ROLLER ITSELF	1
12	EAST0829	CONV IDLER ROLLR/SAW+.125	1
13	EAST0193	CONV IDLER ROLLER SHAFT	1
14	EAST0199	SPROCKET BANDO/STEEL TIMING	1
15	EAST0214	ADJUSTING BRACKET ON MM	1
16	EAST0190	CONV GUIDE ROLLER SHAFT	4
17	EAST0474	CONVEYOR TRAY 30X50 SS	1
18	EAST0254	BEARING FOR DRIVE ROLLER	2
19	EAST0604	DRIVE ROLLER END CAP	1
20	EAST0605	DRIVE ROLLER END CAP	1
21	EAST1013	SNAP RING 1/2" FOR DRIVE	2
22	EAST1014	SNAP RING 3/8"	10
	EAST1004	ROMEX CONNECTOR 3/8"	1
	ESC00563	POWER CORD 18-3 SO CORD	13 FT

\* One each of items marked with an asterisk (\*) are included in spare parts kit SUBK100-3050. Specify electrical power requirements (-V number) when ordering.

#### FILM RACK 36" WITH PIN PERFORATOR – SUBA0033

See the Film Rack section of this Parts section for the Film Rack parts breakdown.

#### ELECTRICAL BOARD EM3050-TKV1 – SUBA1072

See the Electrical Board section of this Parts section for Electrical Board Parts.

**EM3070TK Professional Series L-Sealer Main Assembly**

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	SUBA0211-3070	HOT KNIFE KT 30 X 70 MUSH	1
2	SUBA1012	CONVEYOR TAKEAWAY EM3070	1
3	SUBA0033	FILM RACK 36" W/PIN PERF	1
4	SUBA1073	ELECTRICAL BOARD EM3070TK	1
5	EAST0486	PRODUCT TRAY 30X70	1
	EAST0155	PRODUCT TRAY TUBES 30X40	5
6	EAST0494*	TEMPERATURE CONTROL FOR SEAL BARS*	2
7	EAST1030*	TIMER DWELL/CONVEYOR 220VAC 5A DPDT TON*	2
	ETC00210	KNOB ELECTRICAL PANEL	1
9	ETC00309	SWITCH POWER ON / OFF TOGGLE	1
	ETC00310	SWITCH POWER ON / OFF FACE PLATE	1
10	EAST0168	DRAWER COMP 30 X 40 & 50	1
	EAST1035	DRAWER PULL	1
11	SUBA0106	MAGNET & HOLDER LOWER	4
12	SUBA0105	LEVELING FOOT ASSY.5/8 7"	8
13	SUB01461*	HEAD RETURN CYLINDER KIT*	4
	EAST0438*	HEAD RETURN BALL JOINT*	4
	EAST0459	AIR CYL BRACKET HK	2
14	ECOS0120	COUNTERWEIGHT HOT KNIFE	2
15	EAST0512	HOT KNIFE ACTUATOR MM	1
16	EAST0529	SEAL BAR LOWER FRONT 70"	1
17	EAST0330	SEAL BAR LOWER SIDE 30"MM	1
18	EAST0404	CONVEYOR S HANDLE 30X40	1
19	EAST0209*	SPONGE RUBBER 1/4" X 3/4"*	8.5 FT
	ETC00185	MOTOR CONVEYOR DRIVE 1/8	2
20	ET000113	SPROCKET UNDERSIDE COMBO	4
	ET000077	UNDERSIDE CHAIN TIGHTNER	1
	ET000012	SPROCKET MARTIN 41B12 1/2	1
	EAST0668	CHAIN TENSIONER/GUIDE	0
	ET000072	THRUST BEARING-NICE 603	1
	ET000073	THRUST BEARING NICE 607	4
	72000006	CHAIN #41 RIVETED DRIVE	14 FT
	72000007	CHAIN - MASTER LINK #41R	1
21	EAST0792	HOT KNIFE WIRE GUARD 70" FRONT	1
22	EAST0626SP	HOT KNIFE WIRE GUARD 30" SIDE EXT	1
23	EAST0238	WIRE HOLE BUSHING	4

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
24	EAST0319	CONNECTOR BUTT SEAM BLOCK	4
25	EAST0320	CONNECTOR BUTT SEAM RING	1
	EAST0321	CONNECTOR BUTT SEAM RING	4
26	EAST0597	HOT KNIFE CONDUIT BRACKET	1
27	EAST0530	SPACER BAR 70"	1
29	EAST0363	HEAD SHIMS 16GA	13
30	EAST0156	SNAP RING 3/4"	5
32	EAST0029*	SWITCH LIMIT MICRO*	2
33	EP000207	PFU TERMINAL STRIP BOX	1
35	EAST0081	TERMINAL STRIP 5 PLACE	1
36	EP000543	STUD FILM UNWIND	1
37	EAST1004	ROMEX CONNECTOR 3/8"	1
38	EP000559	POWER CORD 18-4 SO CORD	7 FT

\* One each of items marked with an asterisk (\*) are included in spare parts kit SUBK100-3070. Specify electrical power requirements (-V number) when ordering.

#### SEAL HEAD, HOT KNIFE EM3070TK MUSHROOM PTFE/PFA – SUBA0211-3070

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	EAST0022	PILLOW BLOCK 1"	4
2	EAST0532	REAR SHAFT EM70	1
3	EAST0747	HANDLE FOR SEALER EM70	1
4	EAST0338	MAGNET HOLDER UP EM40 MM	2
5	EAST0456	HEAD RETURN ARM MM	4
6	EAST0511	HOT KNIFE SADDLE W/SLOT MM	4
7	EAST0511	HOT KNIFE SADDLE W/EXSLOT	2
8	EAST0514	HOT KNIFE SPACER BLOCK MM	3
9	EAST0515	HOT KNIFE CORNER SPACER MM	1
10	EAST0560	HOT KNIFE THREADED ROD	7
11	EAST0615	HOT KNIFE SEAL BAR UPPER	1
12	EAST0762	HOT KNIFE SEAL BAR UP 70"	1
13	EAST0767	CROSS OVER BAR 70"	1
14	EAST0793	SAFETY SHIELD INNER 70" F	1
15	EAST0794	SAFETY SHIELD OUTER 70" F	1
16	EAST0624	SAFETY SHIELD INNER 30" S	1

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
17	EAST0625	SAFETY SHIELD OUTER 30" S	1
18	ESC00580*	FIREROD CART 220V 35"	2
19	EAST0630*	FIREROD CART 220V 30"	1
20	EAST0631	HOT KNIFE ARM CASTING OUT	1
21	EAST0632	HOT KNIFE ARM CASTING IN-	1
22	EAST0264	ARM CASTING CENTER HK 30"	1
23	EAST0810	HOT KNIFE MAGNET HOLDER	2
24	EAST0820**	CUTTING RULE FRONT 70"	1
25	EAST0819**	CUTTING RULE SIDE 30"	1
26	EAST0900	MAGNET HOLDER UPPER	2
27	EAST0901	MAGNET HOLDER UPPER PAD	2
28	EAST0763**	MUSHROOM INSERT FRONT 70"	1
29	EAST0917**	MUSHROOM INSERT SIDE 30"	1
30	EAST1007	SAFETY SHIELD SPRING	4
31	EAST1018	COLLAR 1"	2
32	EP000095	HOT KNIFE SPACER BLOCK	5
33	EAST0514E	HOT KNIFE SPACER BLOCK	1
34	EP000535*	THERMOCOUPLE HOT KNIFE*	3
35	ESC00037	HOT KNIFE SADDLE CENTER	1
36	SUBA0065	MAGNET UPPER (NEW 3 PART)	2
37	WH209	SPLIT TENSION PIN 3/16 X	1
38	XH348	SPLIT TENSION PIN 3/16	2
39	XH360	BOLT 1/4 X 1-1/4 SHOULDER	5
40	EAST0165	HANDLE GRIP MATERIAL	6 FT

\* One each of items marked with an asterisk (\*) are included in spare parts kit SUBK100-3070. Specify electrical power requirements (-V number) when ordering.

\*\*One each of items marked with two asterisks (\*\*) are included in the cutting rule and mushroom insert kit SUBK00222-3070.

#### CONVEYOR TAKEAWAY EM3070TK – SUBA1012

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	EAST0051	SPROCKET DRV ROLL 5/8BAND	1
2	EAST0052	BEARING FOR GUIDE ROLLERS	12
3	EAST0055	TIMING BELT EM28 & EM40	1
4	EAST0828	CONV DRIVE ROLLER SHAFT	1
5	EAST0578	CONVEYOR BELT EM30X70	1
6	EAST0484	MOTOR-110/230V 1PH 97RPM 1:15	1
7	EAST0333	CONV GUIDE ROLLER 30X40	5

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
8	EAST0334	CONV CROSS BAR 30X40	6
9	EAST0539	CONVEYOR MOTOR MOUNT SIDE	1
10	EAST0540	CONVEYOR SIDE BAR 20X70 &	1
11	EAST0827	CONV DRIVE ROLLER ITSELF	1
12	EAST0829	CONV IDLER ROLLR/SAW+.125	1
13	EAST0193	CONV IDLER ROLLER SHAFT	1
14	EAST0199	SPROCKET BANDO/STEEL TIMING	1
15	EAST0214	ADJUSTING BRACKET ON MM	1
16	EAST0190	CONV GUIDE ROLLER SHAFT	5
17	EAST0487	CONVEYOR TRAY 30X70 SS	1
18	EAST0254	BEARING FOR DRIVE ROLLER	2
19	EAST0604	DRIVE ROLLER END CAP	1
20	EAST0605	DRIVE ROLLER END CAP	1
21	EAST1013	SNAP RING 1/2" FOR DRIVE	2
22	EAST1014	SNAP RING 3/8"	12
	EAST1004	ROMEX CONNECTOR 3/8"	1
	ESC00563	POWER CORD 18-3 SO CORD	13 FT

\* One each of items marked with an asterisk (\*) are included in spare parts kit SUBK100-3070. Specify electrical power requirements (-V number) when ordering.

### FILM RACK 36" WITH PIN PERFORATOR – SUBA0033

See the Film Rack section of this Parts section for the Film Rack parts breakdown.

ELECTRICAL BOARD EM2070-TKV1, EM2080-TKV1 & EM20100-TKV1, EM3070-TKV1, EM3080-TKV1 & EM30100-TKV1, EM4070-TKV1 & EM4080-TKV1, EM5070-TKV1, EM5080-TKV1 & EM50100-TKV1 – SUBA1073

See the Electrical Board section of this Parts section for Electrical Board Parts.

### EM3080TK Professional Series L-Sealer Main Assembly

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	SUBA0211-3080	SEAL HEAD HOT KNIFE EM3080 MUSHROOM PTFE/PFA	1
2	SUBA0042	CONVEYOR TAKEAWAY EM3080	1
3	SUBA0033	FILM RACK 36" WITH PIN PERFORATOR	1
4	SUBA1073	ELECTRICAL BOARD EM2070 EM2080 EM20100 EM3070 EM3080 EM30100 EM4070 EM4080 EM5070 EM5080 EM50100	1
5	EAST0875	PRODUCT TRAY 30X80	1



ITEM	PART NUMBER	DESCRIPTION	QUANTITY
	EAST0155	PRODUCT TRAY TUBES 30X40	6
6	EAST0486	TEMPERATURE CONTROL FOR SEAL BARS	2
7	EAST1030*	TIMER DWELL/CONVEYOR 220VAC 5A DPDT TON*	2
8	ETC00002*	KNOB VELOCITY CONTROL*	2
9	ETC00309	SWITCH POWER ON / OFF TOGGLE	1
	ETC00310	SWITCH POWER ON / OFF FACE PLATE	1
10	EAST0168	DRAWER COMP 30 X 40 & 50	1
	EAST1035	DRAWER PULL	1
11	SUBA0106	MAGNET & HOLDER LOWER	4
12	SUBA0105	LEVELING FOOT ASSY.5/8 7"	8
13	SUB01461*	HEAD RETURN CYLINDER KIT*	6
	EAST0438*	HEAD RETURN BALL JOINT*	6
	EAST0423	AIR CYLINDER BRACKET HK	2
14	ECOS0120	COUNTERWEIGHT HOT KNIFE	2
15	EAST0512	HOT KNIFE ACTUATOR MM	1
16	EAST0892	SEAL BAR LOWER FRONT 80"	1
17	EAST0330	SEAL BAR LOWER SIDE 30"MM	1
18	EAST0404	CONVEYOR S HANDLE 30X40	1
19	EAST0209*	SPONGE RUBBER 1/4" X 3/4"*	9.25 FT
20	ET000113	SPROCKET UNDERSIDE COMBO	4
	ET000077	UNDERSIDE CHAIN TIGHTNER	1
	ET000012	SPROCKET MARTIN 41B12 1/2	1
	EAST0668	CHAIN TENSIONER/GUIDE	2
	ET000072	THRUST BEARING-NICE 603	1
	ET000073	THRUST BEARING NICE 607	4
	72000006	CHAIN #41 RIVETED DRIVE	15.5 FT
	72000007	CHAIN - MASTER LINK #41R	1
21	EAST0835	HOT KNIFE WIRE GUARD 80"	1
22	EAST0626SP	HOT KNIFE WIRE GUARD 30" EXT	1
23	EAST0238	WIRE HOLE BUSHING	4
24	EAST0320	CONNECTOR BUTT SEAM RING	4
25	EAST0321	CONNECTOR BUTT SEAM RING	4
26	EAST0597	HOT KNIFE CONDUIT BRACKET	1
27	EAST0898	SPACER BAR 80"	1
29	EAST0363	HEAD SHIMS 16GA	9
30	EAST0156	SNAP RING 3/4"	6

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
33	EP000207	PFU TERMINAL STRIP BOX	1
34	EAST0185	TERMINAL STRIP 10 PLACE	2

\* One each of items marked with an asterisk (\*) are included in spare parts kit SUBK100-3080. Specify electrical power requirements (-V number) when ordering.

#### SEAL HEAD, HOT KNIFE EM3080TK MUSHROOM PTFE/PFA – SUBA0211-3080

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	EAST0022	PILLOW BLOCK 1"	4
2	EAST0890	REAR SHAFT EM80 84"	1
3	EAST0748	HANDLE FOR SEALER EM80	1
4	EAST0338	MAGNET HOLDER UP EM40 MM	2
5	EAST0456	HEAD RETURN ARM MM	4
6	EAST0511	HOT KNIFE SADDLE W/SLOT MM	4
7	EAST0511E	HOT KNIFE SADDLE W/EXSLOT	2
8	EAST0514	HOT KNIFE SPACER BLOCK MM	3
9	EAST0515	HOT KNIFE CORNER SPACER MM	1
10	EAST0560	HOT KNIFE THREADED ROD	7
11	EAST0615	HOT KNIFE SEAL BAR UPPER SIDE 30"	1
12	EAST0858	HOT KNIFE SEAL BAR UPPER FRONT 80"	1
13	EAST0857	CROSS OVER BAR 80"	1
14	EAST0859	SAFETY SHIELD INNER 80" F	1
15	EAST0860	SAFETY SHIELD OUTER 80" F	1
16	EAST0624	SAFETY SHIELD INNER 30" S	1
17	EAST0625	SAFETY SHIELD OUTER 30" S	1
18	EAST0629*	FIREROD CART 220V 40"	2
19	EAST0630*	FIREROD CART 220V 30"	1
20	EAST0631	HOT KNIFE ARM CASTING OUT	1
21	EAST0632	HOT KNIFE ARM CASTING IN-	1
22	EAST0264	ARM CASTING CENTER HK 30"	1
23	EAST0810	HOT KNIFE MAGNET HOLDER	2
24	EAST0824**	CUTTING RULE FRONT 80" SUP**	1
25	EAST0819**	CUTTING RULE SIDE 30"***	1
26	EAST0900	MAGNET HOLDER UPPER	2
27	EAST0901	MAGNET HOLDER UPPER PAD	2
28	EAST0916**	MUSHROOM INSERT FRONT 40"***	1
29	EAST0916IN**	MUSHROOM INSERT FRONT-IN 40"***	1
30	EAST0917	MUSHROOM INSERT SIDE 30"	1

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
31	EAST1007	SAFETY SHIELD SPRING	5
32	EAST1018	COLLAR 1"	2
33	EP000095	HOT KNIFE SPACER BLOCK	5
34	EAST0514E	HOT KNIFE SPACER BLOCK	1
35	EP000535*	THERMOCOUPLE HOT KNIFE*	3
36	ESC00037	HOT KNIFE SADDLE CENTER	1
37	SUBA0065	MAGNET UPPER (NEW 3 PART)	2
38	WH209	SPLIT TENSION PIN 3/16 X	2
39	XH348	SPLIT TENSION PIN 3/16	7
40	XH360	BOLT 1/4 X 1-1/4 SHOULDER	5
41	EAST0165	HANDLE GRIP MATERIAL	6.750 FT

\* One each of items marked with an asterisk (\*) are included in spare parts kit SUBK100-3080. Specify electrical power requirements (-V number) when ordering.

\*\*One each of items marked with two asterisks (\*\*) are included in the cutting rule and mushroom insert kit SUBK00222-3080.

#### CONVEYOR TAKEAWAY EM3080TK – SUBA1042

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	EAST0051	SPROCKET DRV ROLL 5/8BAND	1
2	EAST0052	BEARING FOR GUIDE ROLLERS	14
3	EAST0055	TIMING BELT EM28 & EM40	1
4	EAST0828	CONV DRIVE ROLLER SHAFT	1
5	EAST0698	CONVEYOR BELT EM30X80	1
6	EAST0484	MOTOR-110/230V 1PH 97RPM 1:15	1
7	EAST0333	CONV GUIDE ROLLER 30X40	6
8	EAST0334	CONV CROSS BAR 30X40	7
9	EAST0895	CONVEYOR MOTOR MOUNT SIDE	1
10	EAST0896	CONVEYOR SIDE FRONT BAR	1
11	EAST0827	CONV DRIVE ROLLER ITSELF	1
12	EAST0829	CONV IDLER ROLLR/SAW+.125	1
13	EAST0193	CONV IDLER ROLLER SHAFT	1
14	EAST0199	SPROCKET BANDO/STEEL TIMING	1
15	EAST0214	ADJUSTING BRACKET ON MM	1
16	EAST0190	CONV GUIDE ROLLER SHAFT	6
17	EAST0899	CONVEYOR TRAY 30X80 SS	1
18	EAST0254	BEARING FOR DRIVE ROLLER	2
19	EAST0604	DRIVE ROLLER END CAP	1
20	EAST0605	DRIVE ROLLER END CAP	1

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
21	EAST1013	SNAP RING 1/2" FOR DRIVE	2
22	EAST1014	SNAP RING 3/8"	14
	EAST1004	ROMEX CONNECTOR 3/8"	1
	ESC00563	POWER CORD 18-3 SO CORD	13 FT

#### FILM RACK 36" WITH PIN PERFORATOR – SUBA0033

See the Film Rack section of this Parts section for the Film Rack parts breakdown.

ELECTRICAL BOARD EM2070-TKV1, EM2080-TKV1 & EM20100-TKV1, EM3070-TKV1, EM3080-TKV1 & EM30100-TKV1, EM4070-TKV1 & EM4080-TKV1, EM5070-TKV1, EM508-TKV10 & EM50100-TKV1 – SUBA1073

See the Electrical Board section of this Parts section for Electrical Board Parts.

#### EM30100TK Professional Series L-Sealer Main Assembly

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	SUBA0211-30100	SEAL HEAD HOT KNIFE EM30100 MUSHROOM PTFE/PFA	1
2	SUBA0036K	CONVEYOR TAKEAWAY EM30100	1
3	SUBA0033	FILM RACK 36" WITH PIN PERFORATOR	1
4	SUBA1073	ELECTRICAL BOARD EM2070 EM2080 EM20100 EM3070 EM3080 EM30100 EM4070 EM4080 EM5070 EM5080 EM50100	1
5	EAST0911	PRODUCT TRAY 30X100	1
	EAST0155	PRODUCT TRAY TUBES 30X40	6
6	EAST04086	TEMPERATURE CONTROL FOR SEAL BARS	2
7	EAST1030*	TIMER DWELL/CONVEYOR 220VAC 5A DPDT TON*	2
8	ETC00002*	KNOB VELOCITY CONTROL*	2
9	ETC00309	SWITCH POWER ON / OFF TOGGLE	1
	ETC00310	SWITCH POWER ON / OFF FACE PLATE	1
10	EAST0168	DRAWER COMP 30 X 40 & 50	1
	EAST1035	DRAWER PULL	1
11	SUBA0106	MAGNET & HOLDER LOWER	5
12	SUBA0105	LEVELING FOOT ASSY.5/8 7"	8
13	EAST0831	HEAD RTN CYL 100-200LB	1
	EAST0832	HEAD RTN CYL 100-200LB	1
	EAST0438*	HEAD RETURN BALL JOINT*	6
	EAST0833	HEAD RTN CYL END FITTING	4
			2

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
15	EAST0512	HOT KNIFE ACTUATOR MM	1
16	EAST0861	SEAL BAR LOWER 100"	1
17	EAST0330	SEAL BAR LOWER SIDE 30"MM	1
18	EAST0404	CONVEYOR S HANDLE 30X40	1
19	EAST0209*	SPONGE RUBBER 1/4" X 3/4"**	9.25 FT
20	ET000113	SPROCKET UNDERSIDE COMBO	4
	ET000012	SPROCKET MARTIN 41B12 1/2	1
	ET000077	UNDERSIDE CHAIN TIGHTNER	1
	ET000072	THRUST BEARING-NICE 603	1
	ET000073	THRUST BEARING NICE 607	4
	72000007	CHAIN - MASTER LINK #41R	1
21	EAST0830	WIRE GUARD 100" HOT KNIFE	1
22	EAST0626SP	HOT KNIFE WIREGRD 30" EXT	1
23	EAST0238	WIRE HOLE BUSHING	4
24	EAST0320	CONNECTOR BUTT SEAM RING	4
25	EAST0321	CONNECTOR BUTT SEAM RING	4
26	EAST0597	HOT KNIFE CONDUIT BRACKET	1
27	EAST0862	SPACER BAR LOWER 100"	1
29	EAST0363	HEAD SHIMS 16GA	9
30	EAST0156	SNAP RING 3/4"	6
33	EP000207	PFU TERMINAL STRIP BOX	1
34	EAST0185	TERMINAL STRIP 10 PLACE	1

\* One each of items marked with an asterisk (\*) are included in spare parts kit SUBK100-30100. Specify electrical power requirements (-V number) when ordering.

#### SEAL HEAD, HOT KNIFE EM30100TK MUSHROOM PTFE/PFA – SUBA0211-30100

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	EAST0022	PILLOW BLOCK 1"	5
2	EAST0176	REAR SHAFT 104" EMXX100s	1
3	EAST0177	HANDLE FOR SEALER EM40100	1
4	EAST0338	MAGNET HOLDER UP EM40 MM	3
5	EAST0456	HEAD RETURN ARM MM	3
6	EAST0511	HOT KNIFE SADDLE W/SLOT MM	2
7	EAST0511E	HOT KNIFE SADDLE W/EXSLOT	5

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
8	EAST0514	HOT KNIFE SPACER BLOCK MM	2
9	EAST0515	HOT KNIFE CORNER SPACER MM	1
10	EAST0560	HOT KNIFE THREADED ROD	8
11	EAST0615	HOT KNIFE SEAL BAR UPPER SIDE 30"	1
12	EAST0656	HOT KNIFE SEAL BAR UP FNT 100"	1
13	EAST0659	CROSS OVER BAR 100"	1
14	EAST0658	SAFETY SHIELD INNER 100"	1
15	EAST0657	SAFETY SHIELD OUTER 100"	1
16	EAST0624	SAFETY SHIELD INNER 30" S	1
17	EAST0625	SAFETY SHIELD OUTER 30" S	1
18	EAST0678*	FIREROD CART 220V 50"	2
19	EAST0630*	FIREROD CART 220V 30"	1
20	EAST0631	HOT KNIFE ARM CASTING OUT	1
21	EAST0632	HOT KNIFE ARM CASTING IN-	1
22	EAST0264	ARM CASTING CENTER HK 30"	2
23	EAST0810	HOT KNIFE MAGNET HOLDER	3
24	EAST0839**	CUTTING RULE FRONT 101.5"	1
25	EAST0819**	CUTTING RULE SIDE 30"	1
26	EAST0900	MAGNET HOLDER UPPER	3
27	EAST0901	MAGNET HOLDER UPPER PAD	3
28	EAST0786**	MUSHROOM INSERT FRONT 50"	2
29	EAST0917**	MUSHROOM INSERT SIDE 30"	1
30	EAST1007	SAFETY SHIELD SPRING	6
31	EAST1018	COLLAR 1"	2
32	EP000095	HOT KNIFE SPACER BLOCK	4
33	EP000535*	THERMOCOUPLE HOT KNIFE*	3
34	ESC00037	HOT KNIFE SADDLE CENTER	1
35	SUBA0065	MAGNET UPPER (NEW 3 PART)	2
36	WH209	SPLIT TENSION PIN 3/16 X	3
37	XH348	SPLIT TENSION PIN 3/16	9
38	XH360	BOLT 1/4 X 1-1/4 SHOULDER	6
39	EAST0165	HANDLE GRIP MATERIAL	8 FT

\* One each of items marked with an asterisk (\*) are included in spare parts kit SUBK100-30100. Specify electrical power requirements (-V number) when ordering.

\*\*One each of items marked with two asterisks (\*\*) are included in the cutting rule and mushroom insert kit SUBK00222-30100.

## CONVEYOR TAKEAWAY EM30100TK – SUBA0036K

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
3	EAST0055	TIMING BELT EM28 & EM40	1
4	EAST0660	CONVEYOR MTR MNT SIDE100"	1
5	EAST0661	CONVEYOR SIDE BAR FNT 100	1
8	EAST0199	SPROCKET BANDO/STEEL TIMING	1
9	EAST0214	ADJUSTING BRACKET ON MM	1
11	EAST0691	CONVEYOR BELT EM30X100	1
12	SUBA0193	GUIDE ROLLER 30'	8
13	EAST0334	CONV CROSS BAR 30X40	9
14	EAST0873	CONVEYOR TRAY 30X100 SS	1
15	EAST0484	MOTOR-110/230V 1PH 97RPM 1:15	1
18	EAST0328	DRIVE ROLLER 30" CONV	1 ST
20	EAST0329	IDLER ROLLER 30X40 CONV	1
	EAST1004	ROMEX CONNECTOR 3/8"	1
	ESC00563	POWER CORD 18-3 SO CORD	13 FT

## FILM RACK 36" WITH PIN PERFORATOR – SUBA0033

See the Film Rack section of this Parts section for the Film Rack parts breakdown.

## ELECTRICAL BOARD EM2070, EM2080 &amp; EM20100, EM3070, EM3080 &amp; EM30100, EM4070 &amp; EM4080, EM5070, EM5080 &amp; EM50100 – SUBA1073

See the Electrical Board section of this Parts section for Electrical Board Parts.

**EM40 Series L-Sealers****EM4040TK, EM4050TK, EM4070TK, EM4080TK & EM40100TK****EM4040TK Professional Series L-Sealer Main Assembly**

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	SUBA0211-4040	SEAL HEAD HOT KNIFE EM4040 MUSHROOM PTFE/PFA	1
2	SUBA0036F	CONVEYOR TAKEAWAY EM4040	1
3	SUBA0952	POWER FILM UNWIND STANDALONE 50"	1
4	SUBA0224	ELECTRICAL BOARD EM4040	1
5	EAST0569R	PRODUCT TRAY EM40X40 RH	1
	EAST0573	PRODUCT TRAY TUBES 40X40	3
6	EAST0494*	TEMPERATURE CONTROL FOR SEAL BARS*	2
7	EAST1030*	TIMER DWELL/CONVEYOR 220VAC 5A DPDT TON*	2
8	ETC00002*	KNOB VELOCITY CONTROL*	2
9	ETC00309	SWITCH POWER ON / OFF TOGGLE	1
	ETC00310	SWITCH ON-OFF FACE PLATE	1
10	EAST0168	DRAWER COMP 30 X 40 & 50	1
	EAST1035	DRAWER PULL	1
11	SUBA0106	MAGNET & HOLDER LOWER	3
12	SUBA0105	LEVELING FOOT ASSY.5/8 7"	4
13	SUB01461*	HEAD RETURN CYLINDER KIT*	4
	EAST0438*	HEAD RETURN BALL JOINT*	4
	EAST0459	AIR CYL BRACKET HK	1
14	EAST0681	COUNTERWEIGHT HOT KNIFE	1
15	EAST0512	HOT KNIFE ACTUATOR MM	1
16	EAST0255	SEAL BAR LOWER FRONT 40"	1
17	EAST0572	SEAL BAR LOWER SIDE 40"	1
18	EAST0404	CONVEYOR S HANDLE 30X40	1
19	EAST0209*	SPONGE RUBBER 1/4" X 3/4"*	7 FT
20	ET000113	SPROCKET UNDERSIDE COMBO	4
	ET000012	SPROCKET MARTIN 41B12 1/2	1
	ET000077	UNDERSIDE CHAIN TIGHTNER	1
	ET000072	THRUST BEARING-NICE 603	1
	ET000073	THRUST BEARING NICE 607	4
	ECOS0087	BUSHING-SNAP-ECONO 3/8"ID	1
	72000006	CHAIN #41 RIVETED DRIVE	12.5 FT



ITEM	PART NUMBER	DESCRIPTION	QUANTITY
	72000007	CHAIN - MASTER LINK #41R	1
21	EAST0627	HOT KNIFE WIRE GUARD FRT	1
22	EAST0780	HOT KNIFE WIRE GUARD SIDE	1
23	EAST0238	WIRE HOLE BUSHING	4
26	EAST0597	HOT KNIFE CONDUIT BRACKET	1
27	EAST0468	SPACER BAR 30X40 39.875"	1
28	EAST1018	COLLAR 1"	6
29	EAST0363	HEAD SHIMS 16GA	2
30	ESC00563	POWER CORD 18-3 SO CORD	11.7 FT

\* One each of items marked with an asterisk (\*) are included in spare parts kit SUBK100-4040. Specify electrical power requirements (-V number) when ordering.

#### SEAL HEAD, HOT KNIFE EM4040TK MUSHROOM PTFE/PFA – SUBA0211-4040

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	EAST0022	PILLOW BLOCK 1"	2
2	EAST0049	REAR SHAFT EM30X40 & EM40	1
3	EAST0247	HANDLE FOR SEALER EM40	1
4	EAST0338	MAGNET HOLDER UP EM40 MM	1
5	EAST0456	HEAD RETURN ARM MM	3
6	EAST0511	HOT KNIFE SADDLE W/SLOT MM	5
7	EAST0514	HOT KNIFE SPACER BLOCK MM	3
8	EAST0515	HOT KNIFE CORNER SPACER MM	1
9	EAST0560	HOT KNIFE THREADED ROD	6
10	EAST0616	HOT KNIFE SEAL BAR UPPER FRONT 40"	1
11	EAST0775	HOT KNIFE SEAL BAR UP SIDE 40"	1
12	EAST0621	CROSS OVER BAR 30X40 MM	1
13	EAST0622	SAFETY SHIELD INNER 40" F	1
14	EAST0623	SAFETY SHIELD OUTER 40"	1
15	EAST0778	SAFETY SHIELD INNER 40" S	1
16	EAST0779	SAFETY SHIELD OUTER 40" S	1
17	EAST0629*	FIREROD CART 220V 40"*	2
18	EAST0781	HOT KNIFE ARM CASTING OUT	1
19	EAST0782	HOT KNIFE ARM CASTING IN	1
20	EAST0810	HOT KNIFE MAGNET HOLDER	1

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
21	EAST0818**	CUTTING RULE FRONT 40"***	1
22	EAST0867**	CUTTING RULE SIDE 40" SUP**	1
23	EAST0900	MAGNET HOLDER UPPER	1
24	EAST0901	MAGNET HOLDER UPPER PAD	1
25	EAST0916**	MUSHROOM INSERT FRONT 40"***	1
26	EAST0776**	MUSHROOM INSERT SIDE 40"***	1
27	EAST1007	SAFETY SHIELD SPRING	2
28	EAST1018	COLLAR 1"	2
29	EP000095	HOT KNIFE SPACER BLOCK	5
30	EP000535*	THERMOCOUPLE HOT KNIFE*	2
31	ESC00037	HOT KNIFE SADDLE CENTER	1
32	SUBA0065	MAGNET UPPER (NEW 3 PART)	2
33	WH209	SPLIT TENSION PIN 3/16 X	1
34	XH348	SPLIT TENSION PIN 3/16	6
35	XH310	BOLT 5/16-18 X 1 1/4 HEX	4
36	EAST0165	HANDLE GRIP MATERIAL	3.5 FT.

\* One each of items marked with an asterisk (\*) are included in spare parts kit SUBK100-4040. Specify electrical power requirements (-V number) when ordering.

\*\*One each of items marked with two asterisks (\*\*) are included in the cutting rule and mushroom insert kit SUBK00222-4040.

#### CONVEYOR TAKEAWAY EM4040TK – SUBA0036F

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
2	EAST0052	BEARING FOR GUIDE ROLLERS	2
3	EAST0055	TIMING BELT EM28 & EM40	1
4	EAST0071	CONVEYOR MOTOR MOUNT BACK	1
5	EAST0072	CONVEYOR SIDE BAR FRONT	1
6	EAST0752	CONV GUIDE ROLLER SHAFT	3
8	EAST0199	SPROCKET BANDO/STEEL TIMING	1
9	EAST0214	ADJUSTING BRACKET ON MM	1
11	EAST0231	CONVEYOR BELT EM40X40	1
12	EAST0751	CONV GUIDE ROLLER 40X40	3
13	EAST0750	CONV CROSS BAR 40X40	4
14	EAST0577	CONVEYOR TRAY 40X40 SS	1
15	EAST0484	MOTOR-110/230V 1PH 97RPM 1:15	1

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
18	EAST0728	DRIVE ROLLER 40X40 CONV	1
20	EAST0729	IDLER ROLLER 40X40 CONV	1
22	EAST1014	SNAP RING 3/8"	2
23	EAST0614	GUARD CONVEYOR DRIVE	1
	EAST1004	ROMEX CONNECTOR 3/8"	1
	ESC00563	POWER CORD 18-3 SO CORD	13 FT

### 50" POWER FILM UNWIND STANDALONE – SUBA0952

See the Power Film Unwind section of this Parts section for Power Film Unwind parts.

### ELECTRICAL BOARD EM4040-TKV1 – SUBA0224

See the Electrical Board section of this Parts section for Electrical Board Parts.

### EM4050TK Professional Series L-Sealer Main Assembly

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	SUBA0211-4050	SEAL HEAD HOT KNIFE EM4050 MUSHROOM PTFE/PFA	1
2	SUBA1036D	CONVEYOR TAKEAWAY EM4050	1
3	SUBA0952	POWER FILM UNWIND STANDALONE 50"	1
4	SUBA1064	ELECTRICAL BOARD EM2050, EM4050 & EM5050	1
5	EAST0570R	PRODUCT TRAY EM40X50 RH	1
	EAST0573	PRODUCT TRAY TUBES 40X40/	4
6	EAST0494*	TEMPERATURE CONTROL FOR SEAL BARS*	2
7	EAST1030*	TIMER DWELL/CONVEYOR 220VAC 5A DPDT TON*	2
8	ETC00002*	KNOB VELOCITY CONTROL*	2
9	ETC00309	SWITCH POWER ON / OFF TOGGLE	1
	ETC00310	SWITCH ON-OFF FACE PLATE	1
10	EAST0168	DRAWER COMP 30 X 40 & 50	1
	EAST1035	DRAWER PULL	1
11	SUBA0106	MAGNET & HOLDER LOWER	3
12	SUBA0105	LEVELING FOOT ASSY.5/8 7"	4
13	SUB01461*	HEAD RETURN CYLINDER KIT*	4

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
	EAST0438*	HEAD RETURN BALL JOINT*	4
	EAST0423	AIR CYLINDER BRACKET HK	1
14	EAST0683	COUNTERWEIGHT HOT KINFE	1
15	EAST0512	HOT KNIFE ACTUATOR MM	1
16	EAST0252	SEAL BAR LOWER FRONT 50"	1
17	EAST0572	SEAL BAR LOWER SIDE 40"	1
18	EAST0404	CONVEYOR S HANDLE 30X40	1
19	EAST0209*	SPONGE RUBBER 1/4" X 3/4"*	7.5 FT
20	ET000113	SPROCKET UNDERSIDE COMBO	4
	ET000012	SPROCKET MARTIN 41B12 1/2	1
	ET000077	UNDERSIDE CHAIN TIGHTNER	1
	ET000072	THRUST BEARING-NICE 603	1
	ET000073	THRUST BEARING NICE 607	4
	ECOS0087	BUSHING-SNAP-ECONO 3/8"ID	1
	72000006	CHAIN #41 RIVETED DRIVE	14 FT
	72000007	CHAIN - MASTER LINK #41R	1
21	EAST0791	HOT KNIFE WIRE GUARD 50"	1
22	EAST0780	HOT KNIFE WIRE GUARD SIDE	1
23	EAST0238	WIRE HOLE BUSHING	4
24	EAST0320	CONNECTOR BUTT SEAM RING	1
25	EAST0321	CONNECTOR BUTT SEAM RING	4
26	EAST0597	HOT KNIFE CONDUIT BRACKET	1
27	EAST0606	SPACER BAR 50"	1
28	EAST1018	COLLAR 1"	8
29	EAST0363	HEAD SHIMS 16GA	3
30	EAST0845	SEAL HEAD CORNER SUPPORT	2

\* One each of items marked with an asterisk (\*) are included in spare parts kit SUBK100-4050. Specify electrical power requirements (-V number) when ordering.

#### SEAL HEAD, HOT KNIFE EM4050TK MUSHROOM PTFE/PFA – SUBA0211-4050

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	EAST0022	PILLOW BLOCK 1"	3
2	EAST0046	REAR SHAFT 54"	1
3	EAST0745	HANDLE FOR SEALER EM50	1
4	EAST0338	MAGNET HOLDER UP EM40 MM	1
5	EAST0456	HEAD RETURN ARM MM	3
6	EAST0511	HOT KNIFE SADDLE W/SLOT MM	5

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
7	EAST0511E	HOT KNIFE SADDLE W/EXSLOT	1
8	EAST0514	HOT KNIFE SPACER BLOCK MM	2
9	EAST0515	HOT KNIFE CORNER SPACER MM	1
10	EAST0560	HOT KNIFE THREADED ROD	7
11	EAST0775	HOT KNIFE SEAL BAR UP 40"	1
12	EAST0785	HOT KNIFE SEAL BAR UPPER FRONT 50"	1
13	EAST0790	CROSS OVER BAR 50"	1
14	EAST0788	SAFETY SHIELD INNER 50" F	1
15	EAST0789	SAFETY SHIELD OUTER 50" F	1
16	EAST0778	SAFETY SHIELD INNER 40" S	1
17	EAST0779	SAFETY SHIELD OUTER 40" S	1
18	EAST0678*	FIREROD CART 220V 50"	1
19	EAST0629*	FIREROD CART 220V 40"	1
20	EAST0781	HOT KNIFE ARM CASTING	1
21	EAST0782	HOT KNIFE ARM CASTING	1
22	EAST0810	HOT KNIFE MAGNET HOLDER	1
23	EAST0837**	CUTTING RULE FRONT 50"	1
24	EAST0867**	CUTTING RULE SIDE 40" SUP"	1
25	EAST0900	MAGNET HOLDER UPPER	1
26	EAST0901	MAGNET HOLDER UPPER PAD	1
27	EAST0786**	MUSHROOM INSERT FRONT 50"	1
28	EAST0776**	MUSHROOM INSERT SIDE 40"	1
29	EAST1007	SAFETY SHIELD SPRING	4
30	EAST1018	COLLAR 1"	2
31	EP000095	HOT KNIFE SPACER BLOCK	5
32	EAST0514E	HOT KNIFE SPACER BLOCK	1
33	EP000535*	THERMOCOUPLE HOT KNIFE*	2
34	ESC00037	HOT KNIFE SADDLE CENTER	1
35	SUBA0065	MAGNET UPPER (NEW 3 PART)	2
36	EAST0845	SEAL HEAD CORNER SUPPORT	2
37	WH209	SPLIT TENSION PIN 3/16 X	1
38	XH348	SPLIT TENSION PIN 3/16	7
39	XH360	BOLT 1/4 X 1-1/4 SHOULDER	4
40	EAST0165	HANDLE GRIP MATERIAL	4 FT

\* One each of items marked with an asterisk (\*) are included in spare parts kit SUBK100-4050. Specify electrical power requirements (-V number) when ordering.

\*\* One each of items marked with two asterisks (\*\*) are included in the cutting rule and mushroom insert kit SUBK00222-4050.

## CONVEYOR TAKEAWAY EM4050TK – SUBA0036D

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
3	EAST0055	TIMING BELT EM28 & EM40	1
5	EAST0613	CONVEYOR BELT EM40X50	1
6	EAST0484	MOTOR-110/230V 1PH 97RPM 1:15	
7	SUBA0192	GUIDE ROLLER 40"	4
8	EAST0750	CONV CROSS BAR 40X40	5
9	EAST0066	CONVEYOR MOTOR MOUNT SIDE	1
10	EAST0067	CONVEYOR SIDE BAR FRONT	1
11	EAST0728	DRIVE ROLLER 40X40 CONV	1
12	EAST0729	IDLER ROLLER 40X40 CONV	1
13			
14	EAST0199	SPROCKET BANDO/STEEL TIMI	1
15	EAST0214	ADJUSTING BRACKET ON MM	1
16			
17	EAST0576	CONVEYOR TRAY 40X50 SS	1
23	EAST0614	GUARD CONVEYOR DRIVE	1
	ESC00563	POWER CORD 18-3 SO CORD	14.3 FT

## 50" POWER FILM UNWIND STANDALONE – SUBA0952

See the Power Film Unwind section of this Parts section for Power Film Unwind parts.

## ELECTRICAL BOARD EM2050-TKV1, EM4050-TKV1 &amp; EM5050-TKV1 – SUBA1064

See the Electrical Board section of this Parts section for Electrical Board Parts.

**EM4070TK Professional Series L-Sealer Main Assembly**

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	SUBA0211-4070	SEAL HEAD HOT KNIFE EM4070 MUSHROOM PTFE/PFA	1
2	SUBA1022	CONVEYOR TAKEAWAY EM4070	1
3	SUBA0952	POWER FILM UNWIND STANDALONE 50"	1
4	SUBA1073	ELECTRICAL BOARD EM2070 EM2080 EM20100 EM3070	1

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
		EM3080 EM30100 EM4070 EM4080 EM5070 EM5080 EM50100	
5	EAST0669	PRODUCT TRAY 40X70	1
	EAST0573	PRODUCT TRAY TUBES 40 X 40	5
6	EAST0494*	TEMPERATURE CONTROL FOR SEAL HEAD*	2
7	EAST1030*	TIMER DWELL/CONVEYOR 220VAC 5A DPDT TON*	2
8	ETC00210	KNOB ELECTRICAL PANEL	1
9	ETC00309	SWITCH POWER ON / OFF TOGGLE	1
	ETC00310	SWITCH ON-OFF FACE PLATE	1
10	EAST0168	DRAWER COMP 30 X 40 & 50	1
	EAST1035	DRAWER PULL	1
11	SUBA0106	MAGNET & HOLDER LOWER	4
12	SUBA0105	LEVELING FOOT ASSY.5/8 7"	8
13	SUB01461*	HEAD RETURN CYLINDER KIT*	5
	EAST0438*	HEAD RETURN BALL JOINT*	5
	EAST0459	AIR CYL BRACKET HK	2
14	EAST0693	COUNTERWEIGHT 70TK	1
15	EAST0512	HOT KNIFE ACTUATOR MM	1
16	EAST0529	SEAL BAR LOWER FRONT 70"	1
17	EAST0572	SEAL BAR LOWER SIDE 40"	1
18	EAST0404	CONVEYOR S HANDLE 30X40	1
19	EAST0209*	SPONGE RUBBER 1/4" X 3/4"**	11 FT
20	ET000113	SPROCKET UNDERSIDE COMBO	4
	ET000012	SPROCKET MARTIN 41B12 1/2	1
	ET000077	UNDERSIDE CHAIN TIGHTNER	1
	EAST0668	CHAIN TENSIONER/GUIDE	2
	ET000072	THRUST BEARING-NICE 603	1
	ET000073	THRUST BEARING NICE 607	4
	72000006	CHAIN #41 RIVETED DRIVE	17.6 FT
	72000007	CHAIN - MASTER LINK #41R	1
21	EAST0792SP	HK WIRE GAURD FRONT SP 70"	1
22	EAST0780SP	HOT KNIFE WIRE GUARD 40"	1
23	EAST0238	WIRE HOLE BUSHING	4
24	EAST0319	CONNECTOR BUTT SEAM BLOCK	2
25	EAST0320	CONNECTOR BUTT SEAM RING	5
	EAST0321	CONNECTOR BUTT SEAM RING	4
	EAST0323	CONNECTOR BUTT SPLICE 16	1
	EAST0324	CONNECTOR FEMALE	4
26	EAST0597	HOT KNIFE CONDUIT BRACKET	1

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
27	EAST0530	SPACER BAR 70"	1
28	ESC00586	COLLAR 1" SHAFT TWO PIECE	10
29	EAST0363	HEAD SHIMS 16GA	8
32	EAST0029*	SWITCH LIMIT MICRO*	2
33	EP000207	PFU TERMINAL STRIP BOX	1
34	EAST0185	TERMINAL STRIP 10 PLACE	1
35	EAST0081	TERMINAL STRIP 5 PLACE	1
37	EAST1004	ROMEX CONNECTOR 3/8"	2
38	ESC00563	POWER CORD 18-3 SO CORD	8 FT
39	SA000507	SO CORD 18-5 600 VOLT	8 FT
40	ETC00233	DEFLECTOR SHIELD SPACER	2
41	EAST0845	SEAL HEAD CORNER SUPPORT	2

\* One each of items marked with an asterisk (\*) are included in spare parts kit SUBK100-4070. Specify electrical power requirements (-V number) when ordering.

#### SEAL HEAD, HOT KNIFE EM4070TK MUSHROOM PTFE/PFA – SUBA0211-4070

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	EAST0022	PILLOW BLOCK 1"	4
2	EAST0532	REAR SHAFT EM70	1
3	EAST0747	HANDLE FOR SEALER EM70	1
4	EAST0338	MAGNET HOLDER UP EM40 MM	2
5	EAST0456	HEAD RETURN ARM MM	4
6	EAST0511	HOT KNIFE SADDLE W/SLOT MM	5
7	EAST0511E	HOT KNIFE SADDLE W/EXSLOT	3
8	EAST0514	HOT KNIFE SPACER BLOCK MM	3
9	EAST0515	HOT KNIFE CORNER SPACER MM	1
10	EAST0560	HOT KNIFE THREADED ROD	8
11	EAST0762	HOT KNIFE SEAL BAR UP 70"	1
12	EAST0775	HOT KNIFE SEAL BAR UP 40"	1
13	EAST0767	CROSS OVER BAR 70"	1
14	EAST0793	SAFETY SHIELD INNER 70" F	1
15	EAST0794	SAFETY SHIELD OUTER 70" F	1
16	EAST0778	SAFETY SHIELD INNER 40" S	1
17	EAST0779	SAFETY SHIELD OUTER 40" S	1
18	ESC00580*	FIREROD CART 220V 35""	2
19	EAST0629*	FIREROD CART 220V 40""	1



ITEM	PART NUMBER	DESCRIPTION	QUANTITY
20	EAST0781	HOT KNIFE ARM CASTING	1
21	EAST0782	HOT KNIFE ARM CASTING	1
22	EAST0559	ARM CASTING CENTER 40"	1
23	EAST0810	HOT KNIFE MAGNET HOLDER	2
24	EAST0820**	CUTTING RULE FRONT 70"***	1
25	EAST0867**	CUTTING RULE SIDE 40" SUP**	1
26	EAST0900	MAGNET HOLDER UPPER	2
27	EAST0901	MAGNET HOLDER UPPER PAD	2
28	EAST0763**	MUSHROOM INSERT FRONT 70"***	1
29	EAST0776**	MUSHROOM INSERT SIDE 40"***	1
30	EAST1007	SAFETY SHIELD SPRING	5
31	EAST1018	COLLAR 1"	2
32	EP000095	HOT KNIFE SPACER BLOCK	5
33	EAST0514E	HOT KNIFE SPACER BLOCK	1
34	EP000535*	THERMOCOUPLE HOT KNIFE*	3
35	ESC00037	HOT KNIFE SADDLE CENTER	1
36	SUBA0065	MAGNET UPPER (NEW 3 PART)	2
37	WH209	SPLIT TENSION PIN 3/16 X	2
38	XH348	SPLIT TENSION PIN 3/16	8
39	XH360	BOLT 1/4 X 1-1/4 SHOULDER	5
40	EAST0165	HANDLE GRIP MATERIAL	6 FT

\* One each of items marked with an asterisk (\*) are included in spare parts kit SUBK100-4070. Specify electrical power requirements (-V number) when ordering.

\*\*One each of items marked with two asterisks (\*\*) are included in the cutting rule and mushroom insert kit SUBK00222-4070.

#### CONVEYOR TAKEAWAY EM4070TK – SUBA1022

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
3	EAST0055	TIMING BELT EM28 & EM40	1
5	EAST1050	CONVEYOR BELT EM40X70	1
6	EAST0484	MOTOR-110/230V 1PH 97RPM 1:15	1
7	SUBA0192	GUIDE ROLLER 40"	5
8	EAST0750	CONV CROSS BAR 40X40	7
9	EAST0539	CONVEYOR MOTOR MOUNT SIDE	1
10	EAST0540	CONVEYOR SIDE BAR 20X70 &	1

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
11	EAST0728	DRIVE ROLLER 40X40 CONV	1
12	EAST0729	IDLER ROLLER 40X40 CONV	1
14	EAST0199	SPROCKET BANDO/STEEL TIMING	1
15	EAST0214	ADJUSTING BRACKET ON MM	1
17	EAST0807	CONVEYOR TRAY 40X70 SS	1
22	EAST1014	SNAP RING 3/8"	10
23	EAST0614	GUARD CONVEYOR DRIVE	1
	EAST1004	ROMEX CONNECTOR 3/8"	1
	ESC00563	POWER CORD 18-3 SO CORD	16 FT

#### 50" POWER FILM UNWIND STANDALONE – SUBA0952

See the Power Film Unwind section of this Parts section for Power Film Unwind parts.

ELECTRICAL BOARD EM2070-TKV1, EM2080-TKV1 & EM20100-TKV1, EM3070-TKV1, EM3080-TKV1 & EM30100-TKV1, EM4070-TKV1 & EM4080-TKV1, EM5070-TKV1, EM5080-TKV1 & EM50100-TKV1 – SUBA1073

See the Electrical Board section of this Parts section for Electrical Board Parts.

#### EM4080TK Professional Series L-Sealer Main Assembly

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	SUBA0211-4080	SEAL HEAD HOT KNIFE EM4080 MUSHROOM PTFE/PFA	1
2	SUBA1023	CONVEYOR TAKEAWAY EM4080	1
3	SUBA0952	POWER FILM UNWIND STANDALONE 50"	1
4	SUBA1073	ELECTRICAL BOARD EM2070 EM2080 EM20100 EM3070 EM3080 EM30100 EM4070 EM4080 EM5070 EM5080 EM50100	1
5	I0000798	INVERTER TRAY 40 X 80	1
6	EAST0494*	TEMPERATURE CONTROL FOR SEAL BARS*	2
7	EAST1030*	TIMER DWELL/CONVEYOR 220VAC 5A DPDT TON*	2
	ETC00210	KNOB ELECTRICAL PANEL	1
9	ETC00309	SWITCH POWER ON / OFF TOGGLE	1
	ETC00310	SWITCH POWER ON / OFF FACE PLATE	1
10	EAST0168	DRAWER COMP 30 X 40&50	1

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
	EAST1035	DRAWER PULL	1
11	SUBA0106	MAGNET & HOLDER LOWER	4
12	SUBA0105	LEVELING FOOT ASSY.5/8 7"	8
13	SUB01461*	HEAD RETURN CYLINDER KIT*	3
	EAST0438*	HEAD RETURN BALL JOINT*	3
	EAST0459	AIR CYL BRACKET HK	1
16	EAST0892	SEAL BAR LOWER FRONT 80"	1
17	EAST0572	SEAL BAR LOWER SIDE 40"	1
18	EAST0404	CONVEYOR S HANDLE 30X40	1
19	EAST0209*	SPONGE RUBBER 1/4" X 3/4"*	10 FT
20	ET000113	SPROCKET UNDERSIDE COMBO	4
	ET000012	SPROCKET MARTIN 41B12 1/2	1
	ET000077	UNDERSIDE CHAIN TIGHTNER	1
	EAST0668	CHAIN TENSIONER/GUIDE	2
	ET000072	THRUST BEARING-NICE 603	1
	ET000073	THRUST BEARING NICE 607	4
	72000006	CHAIN #41 RIVETED DRIVE	16.8 FT
	72000007	CHAIN - MASTER LINK #41R	1
21	EAST0835	HOT KNIFE WIRE GUARD 80"	1
22	EAST0780SP	HOT KNIFE WIRE GUARD 40"	1
23	EAST0238	WIRE HOLE BUSHING	5
24	EAST0319	CONNECTOR BUTT SEAM BLOCK	2
	EAST0320	CONNECTOR BUTT SEAM RING	5
25	EAST0321	CONNECTOR BUTT SEAM RING	4
	EAST0323	CONNECTOR BUTT SPLICE 16	1
	EAST0324	CONNECTOR FEMALE	4
26	EAST0597	HOT KNIFE CONDUIT BRACKET	1
28	EP000207	PFU TERMINAL STRIP BOX	1
33	EAST0185	TERMINAL STRIP 10 PLACE	1
	EAST1004	ROMEX CONNECTOR 3/8"	2
	EAST0399	POWER CORD 18-8 SO CORD	7 FT
38	ET000073	THRUST BEARING NICE 607	4
	ESC00563	POWER CORD 18-3 SO CORD	10.4 FT

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
	980028	UHMW 1/2" X 4' X 10'	0.6
	EINVT003	LINEAR BEARING 1/2" BORE	4
	ESC00549	HANDLE RATCHET	1
	I0000243	SLIDE SHIM FOR 36" SLIDE	5
	I0000136	SLIDE 36"	5
	SUBA0232A	INVERTER HEAD 39" ROD HEAVY DUT	1
	I0000007	INVERTER H.K. ACTUATOR	1
	I0000104	INVT ASSY MNT PLATE 50"	1

\* One each of items marked with an asterisk (\*) are included in spare parts kit SUBK100-4080. Specify electrical power requirements (-V number) when ordering.

#### SEAL HEAD, HOT KNIFE EM4080TK MUSHROOM PTFE/PFA – SUBA0211-4080

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	EAST0022	PILLOW BLOCK 1"	4
2	EAST0890	REAR SHAFT EM80 84"	1
3	EAST0748	HANDLE FOR SEALER EM80	1
4	EAST0338	MAGNET HOLDER UP EM40 MM	2
5	EAST0456	HEAD RETURN ARM MM	4
6	EAST0511	HOT KNIFE SADDLE W/SLOT MM	5
7	EAST0511E	HOT KNIFE SADDLE W/EXSLOT	2
8	EAST0514	HOT KNIFE SPACER BLOCK MM	3
9	EAST0515	HOT KNIFE CORNER SPACER MM	1
10	EAST0560	HOT KNIFE THREADED ROD	8
11	EAST0858	HOT KNIFE SEAL BAR UPPER FRONT 80"	1
12	EAST0775	HOT KNIFE SEAL BAR UP 40"	1
13	EAST0857	CROSS OVER BAR 80"	1
14	EAST0859	SAFETY SHIELD INNER 80" F	1
15	EAST0860	SAFETY SHIELD OUTER 80" F	1
16	EAST0778	SAFETY SHIELD INNER 40" S	1
17	EAST0779	SAFETY SHIELD OUTER 40" S	1
18	EAST0629*	FIREROD CART 220V 40"	3
19	EAST0781	HOT KNIFE ARM CASTING	1
20	EAST0782	HOT KNIFE ARM CASTING	1
21	EAST0559	ARM CASTING CENTER 40"	1
22	EAST0810	HOT KNIFE MAGNET HOLDER	2
23	EAST0824**	CUTTING RULE FRONT 80" SUP**	1
24	EAST0867**	CUTTING RULE SIDE 40" SUP**	1

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
25	EAST0900	MAGNET HOLDER UPPER	2
26	EAST0901	MAGNET HOLDER UPPER PAD	2
27	EAST0916**	MUSHROOM INSERT FRONT 40***	2
28	EAST0916L**	MUSHROOM INSERT FRONT 40***	1
29	EAST1007	SAFETY SHIELD SPRING	2.5
30	EAST1018	COLLAR 1"	2
31	EP000095	HOT KNIFE SPACER BLOCK	5
32	EAST0514E	HOT KNIFE SPACER BLOCK	1
33	EP000535*	THERMOCOUPLE HOT KNIFE*	3
34	ESC00037	HOT KNIFE SADDLE CENTER	1
35	SUBA0065	MAGNET UPPER (NEW 3 PART)	2
36	WH209	SPLIT TENSION PIN 3/16 X	2
37	XH348	SPLIT TENSION PIN 3/16	8
38	XH360	BOLT 1/4 X 1-1/4 SHOULDER	5
39	EAST0165	HANDLE GRIP MATERIAL	6.75 FT

\* One each of items marked with an asterisk (\*) are included in spare parts kit SUBK100-4080. Specify electrical power requirements (-V number) when ordering.

\*\*One each of items marked with two asterisks (\*\*) are included in the cutting rule and mushroom insert kit SUBK00222-4080.

#### CONVEYOR TAKEAWAY EM4080TK – SUBA1023

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
3	EAST0055	TIMING BELT EM28 & EM40	1
5	EAST1062	CONVEYOR BELT EM40X80	1
6	EAST0484	MOTOR-110/230V 1PH 97RPM 1:15	1
7	SUBA0192	GUIDE ROLLER 40"	6
8	EAST0750	CONV CROSS BAR 40X40	7
9	EAST0895	CONVEYOR MOTOR MOUNT SIDE	1
10	EAST0896	CONVEYOR SIDE FRONT BAR	1
11	EAST0728	DRIVE ROLLER 40X40 CONV	1
12	EAST0729	IDLER ROLLER 40X40 CONV	1
14	EAST0199	SPROCKET BANDO/STEEL TIMING	1
15	EAST0214	ADJUSTING BRACKET ON MM	1

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
17	EAST1075	CONVEYOR TRAY 40 X 80	1
22	EAST1014	SNAP RING 3/8"	10
23	EAST0614	GUARD CONVEYOR DRIVE	1
	EAST1004	ROMEX CONNECTOR 3/8"	1
	ESC00563	POWER CORD 18-3 SO CORD	16.9 FT

### 50" POWER FILM UNWIND STANDALONE – SUBA0952

See the Power Film Unwind section of this Parts section for Power Film Unwind parts.

ELECTRICAL BOARD EM2070-TKV1, EM2080-TKV1 & EM20100-TKV1, EM3070-TKV1, EM3080-TKV1 & EM30100-TKV1, EM4070-TKV1 & EM4080-TKV1 EM5070-TKV1, EM5080-TKV1 & EM50100-TKV1 – SUBA1073

See the Electrical Board section of this Parts section for Electrical Board Parts.

### EM40100TK Professional Series L-Sealer Main Assembly

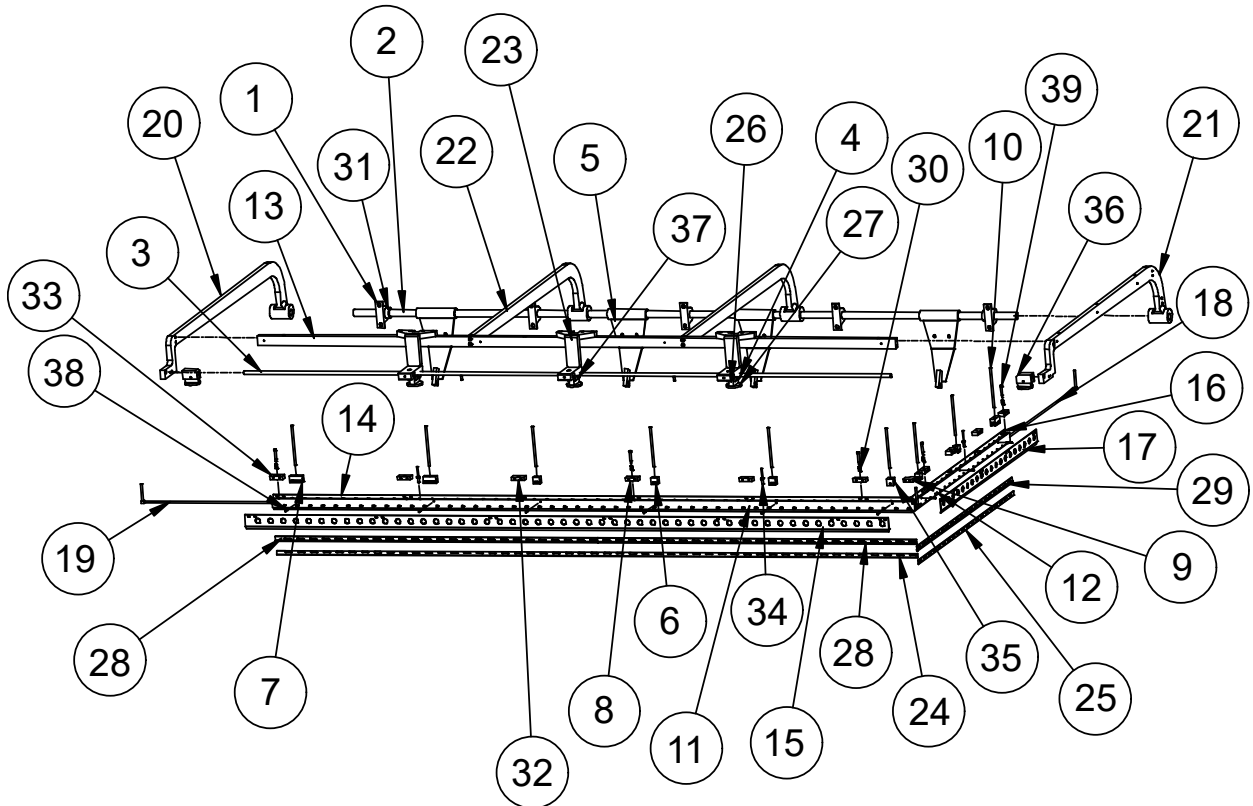
ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	SUBA0211-40100	SEAL HEAD HOT KNIFE EM40100 MUSHROOM PTFE/PFA	1
2	SUBA1036G	CONVEYOR TAKEAWAY EM4080	1
3	SUBA0952	POWER FILM UNWIND STANDALONE 50"	1
4	SUBA1078	ELECTRICAL BOARD EM40100	1
5	I0000115	INFEED TRAY 40X100	1
6	EAST0494*	TEMPERATURE CONTROL FOR SEAL BARS*	2
7	EAST1030*	TIMER DWELL/CONVEYOR 220VAC 5A DPDT TON*	2
	ETC00210	KNOB ELECTRICAL PANEL	1
9	ETC00309	SWITCH POWER ON / OFF TOGGLE	1
	ETC00310	SWITCH POWER ON / OFF FACE PLATE	1
10	EAST0168	DRAWER COMP 30 X 40&50	1
	EAST1035	DRAWER PULL	1
11	SUBA0106	MAGNET & HOLDER LOWER	5
12	SUBA0104	LEVELING FOOT ASSY. 1"	8
15	EAST0512	HOT KNIFE ACTUATOR MM	1
16	EAST0861	SEAL BAR LOWER 100"	1

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
17	EAST0572	SEAL BAR LOWER SIDE 40"	1
18	EAST0404	CONVEYOR S HANDLE 30X40	1
19	EAST0209*	SPONGE RUBBER 1/4" X 3/4"*	12 FT
20	ET000113	SPROCKET UNDERSIDE COMBO	4
	ET000012	SPROCKET MARTIN 41B12 1/2	1
	ET000077	UNDERSIDE CHAIN TIGHTNER	1
	ET000072	THRUST BEARING-NICE 603	1
	ET000073	THRUST BEARING NICE 607	4
	72000006	CHAIN #41 RIVETED DRIVE	20.87 FT
	72000007	CHAIN - MASTER LINK #41R	1
21	EAST0780SP	HOT KNIFE WIRE GUARD 40"	1
22	EAST0830	WIRE GUARD 100" HOT KNIFE	1
23	EAST0238	WIRE HOLE BUSHING	5
24	EAST0319	CONNECTOR BUTT SEAM BLOCK	2
25	EAST0320	CONNECTOR BUTT SEAM RING	5
	EAST0321	CONNECTOR BUTT SEAM RING	4
	EAST0323	CONNECTOR BUTT SPLICE 16-	1
	EAST0324	CONNECTOR FEMALE	4
26	EAST0597	HOT KNIFE CONDUIT BRACKET	1
27	EAST0862	SPACER BAR LOWER 100"	1
29	EAST0363	HEAD SHIMS 16GA	7
33	EP000207	PFU TERMINAL STRIP BOX	1
34	EAST0185	TERMINAL STRIP 10 PLACE	1
	EAST1004	ROMEX CONNECTOR 3/8"	2
	ESC00563	POWER CORD 18-3 SO CORD	10.4 FT
	EAST0399	POWER CORD 18-8 SO CORD	30 FT
	ECOS0089	POWER CORD 12-3	10 FT
	EINVT003	LINEAR BEARING 1/2" BORE	4
	ESC00549	HANDLE RATCHET	1
	EP000545	CLAMP STRAIGHT LINE	1
	I0000136	SLIDE 36"	5
	EP000522	RUBBER BUMPER CYLINDRICAL	1
	I0000007	INVERTER H.K. ACTUATOR	1
	I0000101	INVERTER PRODUCT TRAY 50"	1
	I0000104	INVT ASSY MNT PLATE 50"	1

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
	I0000105	INVT CENTER ROLLER BRKT50 TALL	1

\* One each of items marked with an asterisk (\*) are included in spare parts kit SUBK100-40100. Specify electrical power requirements (-V number) when ordering.

SEAL HEAD, HOT KNIFE EM40100TK MUSHROOM PTFE/PFA – SUBA0211-40100



ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	EAST0022	PILLOW BLOCK 1"	5
2	EAST0176	REAR SHAFT 104" EMXX100s	1
3	EAST0177	HANDLE FOR SEALER EM40100	1
4	EAST0338	MAGNET HOLDER UP EM40 MM	3
5	EAST0456	HEAD RETURN ARM MM	4
6	EAST0511	HOT KNIFE SADDLE W/SLOT MM	5
7	EAST0511E	HOT KNIFE SADDLE W/EXSLOT	3
8	EAST0514	HOT KNIFE SPACER BLOCK MM	3
9	EAST0515	HOT KNIFE CORNER SPACER MM	1
10	EAST0560	HOT KNIFE THREADED ROD	9
11	EAST0656	HOT KNIFE SEAL BAR UP FNT 100"	1
12	EAST0775	HOT KNIFE SEAL BAR UP 40"	1



ITEM	PART NUMBER	DESCRIPTION	QUANTITY
13	EAST0659	CROSS OVER BAR 100"	1
14	EAST0658	SAFETY SHIELD INNER 100"	1
15	EAST0657	SAFETY SHIELD OUTER 100"	1
16	EAST0778	SAFETY SHIELD INNER 40" S	1
17	EAST0779	SAFETY SHIELD OUTER 40" S	1
18	EAST0678*	FIREROD CART 220V 50"	2
19	EAST0629*	FIREROD CART 220V 40"	1
20	EAST0781	HOT KNIFE ARM CASTING	1
21	EAST0782	HOT KNIFE ARM CASTING	1
22	EAST0559	ARM CASTING CENTER 40"	2
23	EAST0810	HOT KNIFE MAGNET HOLDER	3
24	EAST0839**	CUTTING RULE FRONT 101.5"***	1
25	EAST0867**	CUTTING RULE SIDE 40" SUP**	1
26	EAST0900	MAGNET HOLDER UPPER	3
27	EAST0901	MAGNET HOLDER UPPER PAD	3
28	EAST0786**	MUSHROOM INSERT FRONT 50"***	2
29	EAST0776**	MUSHROOM INSERT SIDE 40"***	1
30	EAST1007	SAFETY SHIELD SPRING	5
31	EAST1018	COLLAR 1"	2
32	EP000095	HOT KNIFE SPACER BLOCK	6
33	EAST0514E	HOT KNIFE SPACER BLOCK	1
34	EP000535*	THERMOCOUPLE HOT KNIFE*	3
35	ESC00037	HOT KNIFE SADDLE CENTER	1
36	SUBA0065	MAGNET UPPER (NEW 3 PART)	2
37	WH209	SPLIT TENSION PIN 3/16 X	3
38	XH348	SPLIT TENSION PIN 3/16	9
39	XH360	BOLT 1/4 X 1-1/4 SHOULDER	5
40	EAST0165	HANDLE GRIP MATERIAL	8 FT

\* One each of items marked with an asterisk (\*) are included in spare parts kit SUBK100-40100. Specify electrical power requirements (-V number) when ordering.

\*\*One each of items marked with two asterisks (\*\*) are included in the cutting rule and mushroom insert kit SUBK00222-40100.

#### CONVEYOR TAKEAWAY EM40100TK – SUBA0036G

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
3	EAST0055	TIMING BELT EM28 & EM40	1

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
5	EAST0692	CONVEYOR BELT EM40100	1
6	ETC00185	MOTOR CONVEYOR DRIVE 1/8	1
7	SUBA0192	GUIDE ROLLER 40"	7
8	EAST0750	CONV CROSS BAR 40X40	7
9	EAST0660	CONVEYOR MTR MNT SIDE100"	1
10	EAST0661	CONVEYOR SIDE BAR FNT 100	1
11	EAST0728	DRIVE ROLLER 40X40 CONV	1
12	EAST0729	IDLER ROLLER 40X40 CONV	1
14	EAST0199	SPROCKET BANDO/STEEL TIMING	1
15	EAST0214	ADJUSTING BRACKET ON MM	1
17	EAST0178	CONVEYOR TRAY 40X100SS	1
23	EAST0614	GUARD CONVEYOR DRIVE	1
	EAST0697	ELECT BOX - TUNNEL MTRS	1
	ESC00563	POWER CORD 18-3 SO CORD	14 FT

#### 50" POWER FILM UNWIND STANDALONE – SUBA0952

See the Power Film Unwind section of this Parts section for Power Film Unwind parts.

#### ELECTRICAL BOARD EM40100-TKV1 – SUBA1078

See the Electrical Board section of this Parts section for Electrical Board Parts.

## EM50 Series L-Sealers

### EM5050TK, EM5070TK, EM5080TK & EM50100TK

#### EM5050TK Professional Series L-Sealer Main Assembly

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	SUBA0211-5050	SEAL HEAD HOT KNIFE EM5050 MUSHROOM PTFE/PFA	1
2	SUBA1036H	CONVEYOR TAKEAWAY EM5050	1
3	SUBA0952	POWER FILM UNWIND STANDALONE 50"	1
4	SUBA1064	ELECTRICAL BOARD EM2050, EM4050 & EM5050	1
5	EAST0171	PRODUCT TRAY 50X50	1
	EAST0179	PRODUCT TRAY TUBES 50 WIDE	4
6	EAST0494*	TEMPERATURE CONTROL FOR SEAL BARS*	2
7	EAST1030*	TIMER DWELL/CONVEYOR 220VAC 5A DPDT TON*	2
	ETC0210	KNOB ELECTRICAL PANEL	1
9	ETC00309	SWITCH POWER ON / OFF TOGGLE	1
	ETC00310	SWITCH ON-OFF FACE PLATE	1
10	EAST0168	DRAWER COMP 30 X 40&50	1
	EAST1035	DRAWER PULL	1
11	SUBA0106	MAGNET & HOLDER LOWER	3
12	SUBA0104	LEVELING FOOT ASSY. 1"	4
13	SUB01461*	HEAD RETURN CYLINDER KIT*	6
	EAST0438*	HEAD RETURN BALL JOINT*	4
	EAST0423	AIR CYLINDER BRACKET HK	1
14	EAST0683	COUNTERWEIGHT HOT KINFE	1
15	EAST0512	HOT KNIFE ACTUATOR MM	1
16	EAST0252	SEAL BAR LOWER FRONT 50"	1
17	EAST0965	SEAL BAR LOWER SIDE 50"	1
18	EAST0404	CONVEYOR S HANDLE 30X40	1
19	EAST0209*	SPONGE RUBBER 1/4" X 3/4"*	7.5 FT
20	ET000113	SPROCKET UNDERSIDE COMBO	4
	ET000012	SPROCKET MARTIN 41B12 1/2	1
	ET000077	UNDERSIDE CHAIN TIGHTNER	1
	ET000072	THRUST BEARING-NICE 603	1
	ET000073	THRUST BEARING NICE 607	4
	ECOS0087	BUSHING-SNAP-ECONO 3/8"ID	1
	72000006	CHAIN #41 RIVETED DRIVE	14 FT

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
	72000007	CHAIN - MASTER LINK #41R	3
21	EAST0791	HOT KNIFE WIRE GUARD 50"	1
22	EAST0962	WIRE GUARD 50" SIDE	1
23	EAST0238	WIRE HOLE BUSHING	4
24	EAST0320	CONNECTOR BUTT SEAM RING	1
25	EAST0321	CONNECTOR BUTT SEAM RING	4
26	EAST0597	HOT KNIFE CONDUIT BRACKET	1
27	EAST0606	SPACER BAR 50"	1
28	EAST1018	COLLAR 1"	8
29	EAST0363	HEAD SHIMS 16GA	3

\* One each of items marked with an asterisk (\*) are included in spare parts kit SUBK100-5050. Specify electrical power requirements (-V number) when ordering.

#### SEAL HEAD, HOT KNIFE EM5050TK MUSHROOM PTFE/PFA – SUBA0211-5050

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	EAST0022	PILLOW BLOCK 1"	3
2	EAST0046	REAR SHAFT 54"	1
3	EAST0745	HANDLE FOR SEALER EM50	1
4	EAST0338	MAGNET HOLDER UP EM40 MM	1
5	EAST0456	HEAD RETURN ARM MM	3
6	EAST0511	HOT KNIFE SADDLE W/SLOT MM	7
7	EAST0514	HOT KNIFE SPACER BLOCK MM	3
8	EAST0515	HOT KNIFE CORNER SPACER MM	1
9	EAST0560	HOT KNIFE THREADED ROD	8
10	EAST0785	HOT KNIFE SEAL BAR UPPER FRONT 50"	1
11	EAST0960	HOT KNIFE SEAL BAR UPPER 50" SIDE	1
12	EAST0790	CROSS OVER BAR 50"	1
13	EAST0788	SAFETY SHIELD INNER 50" FRONT	1
14	EAST0789	SAFETY SHIELD OUTER 50" FRONT	1
15	EAST0963	SAFTEY SHIELD INNER 50" SIDE	1
16	EAST0964	SAFTEY SHIELD OUTER 50" SIDE	1
17	EAST0678*	FIREROD CART 220V 50"	2
18	EAST0966	ARM CASTING HK OUT	1
19	EAST0967	ARM CASTING HK IN	1
20	EAST0810	HOT KNIFE MAGNET HOLDER	1
21	EAST0837**	CUTTING RULE FRONT 50"***	1
22	EAST0868**	CUTTING RULE 50" SIDE**	1

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
23	EAST0900	MAGNET HOLDER UPPER	1
24	EAST0901	MAGNET HOLDER UPPER PAD	1
25	EAST0786**	MUSHROOM INSERT FRONT 50"***	1
26	EAST0915**	MUSHROOM INSERT 50" SIDE**	1
27	EAST1007	SAFETY SHIELD SPRING	4
28	EAST1018	COLLAR 1"	2
29	EP000095	HOT KNIFE SPACER BLOCK	5
30	EAST0514E	HOT KNIFE SPACER BLOCK	1
31	EP000535*	THERMOCOUPLE HOT KNIFE*	2
32	ESC00037	HOT KNIFE SADDLE CENTER	1
33	SUBA0065	MAGNET UPPER (NEW 3 PART)	2
34	WH209	SPLIT TENSION PIN 3/16 X	1
35	XH360	BOLT 1/4 X 1-1/4 SHOULDER	4
36	XH348	SPLIT TENSION PIN 3/16	7
37	EAST0165	HANDLE GRIP MATERIAL	4 FT

\* One each of items marked with an asterisk (\*) are included in spare parts kit SUBK100-5050. Specify electrical power requirements (-V number) when ordering.

\*\*One each of items marked with two asterisks (\*\*) are included in the cutting rule and mushroom insert kit SUBK00222-5050.

#### CONVEYOR TAKEAWAY EM5050TK – SUBA0036H

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
2	ETC00008	BEARING 5/8 ID GENRL PURP	4
3	EAST0074	TIMING BELT EM5252	1
5	EAST0947	CONVEYOR BELT EM50X50	1
6	EAST0484	MOTOR-110/230V 1PH 97RPM 1:15	0
9	MB000291	MOTOR BOLT PLATE	1
11	EAST0969	DRIVE ROLLER 50 X 50	1
12	EAST0970	IDLER ROLLER 50 X 50	1
14	EAST0199	SPROCKET BANDO/STEEL TIMING	1
17	EAST0973	CONVEYOR PAN 50 X 50	1
	ESC00563	POWER CORD 18-3 SO CORD	14 FT

\* One each of items marked with an asterisk (\*) are included in spare parts kit SUBK100-5050. Specify electrical power requirements (-V number) when ordering.

### 50" POWER FILM UNWIND STANDALONE – SUBA0952

See the Power Film Unwind section of this Parts section for Power Film Unwind parts.

### ELECTRICAL BOARD EM2050-TKV1, EM4050-TKV1 & EM5050-TKV1 – SUBA1064

See the Electrical Board section of this Parts section for Electrical Board Parts.

### EM5070TK Professional Series L-Sealer Main Assembly

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	SUBA0211-5070	SEAL HEAD HOT KNIFE EM5070 MUSHROOM PTFE/PFA	1
2	SUBA1036R	CONVEYOR TAKEAWAY EM5070	1
3	SUBA0952	POWER FILM UNWIND STANDALONE 50"	1
4	SUBA1073	ELECTRICAL BOARD EM2070 EM2080 EM20100 EM3070 EM3080 EM30100 EM4070 EM4080 EM5070 EM5080 EM50100	1
5	EAST0999	PRODUCT TRAY 50 X 70	1
	EAST0179	PRODUCT TRAY TUBES 50 WIDE	5
6	EAST0494*	TEMPERATURE CONTROL FOR SEAL BARS*	2
7	EAST1030*	TIMER DWELL/CONVEYOR 220VAC 5A DPDT TON*	2
	ETC00210	KNOB ELECTRICAL PANEL	1
8	ETC00309	SWITCH POWER ON / OFF TOGGLE	1
	ETC00310	SWITCH POWER ON / OFF FACE PLATE	1
10	EAST0168	DRAWER COMP 30 X 40&50	1
	EAST1035	DRAWER PULL	1
11	SUBA0106	MAGNET & HOLDER LOWER	4
12	SUBA0105	LEVELING FOOT ASSY.5/8 7"	8
13	SUB01461*	HEAD RETURN CYLINDER KIT*	7
	EAST0438*	HEAD RETURN BALL JOINT*	5
	EAST0459	AIR CYL BRACKET HK	2
14	EAST0693	COUNTERWEIGHT 70TK	1
15	EAST0512	HOT KNIFE ACTUATOR MM	1
16	EAST0529	SEAL BAR LOWER FRONT 70"	1
17	EAST0965	SEAL BAR LOWER SIDE 50"	1
18	EAST0404	CONVEYOR S HANDLE 30X40	1
19	EAST0209*	SPONGE RUBBER 1/4" X 3/4"*	11 FT

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
20	ET000113	SPROCKET UNDERSIDE COMBO	4
	ET000012	SPROCKET MARTIN 41B12 1/2	1
	ET000077	UNDERSIDE CHAIN TIGHTNER	1
	EAST0668	CHAIN TENSIONER/GUIDE	2
	ET000072	THRUST BEARING-NICE 603	1
	ET000073	THRUST BEARING NICE 607	4
	72000006	CHAIN #41 RIVETED DRIVE	17.6 FT
	72000007	CHAIN - MASTER LINK #41R	1
21	EAST0792SP	WIRE GAURD FRONT SP 70"	1
22	EAST0962	WIRE GUARD 50" SIDE	1
	ETC00233	DEFLECTOR SHIELD SPACER	2
23	EAST0238	WIRE HOLE BUSHING	4
24	EAST0319	CONNECTOR BUTT SEAM BLOCK	2
25	EAST0320	CONNECTOR BUTT SEAM RING	5
	EAST0321	CONNECTOR BUTT SEAM RING	4
	EAST0323	CONNECTOR BUTT SPLICE 16	1
	EAST0324	CONNECTOR FEMALE	4
26	EAST0597	HOT KNIFE CONDUIT BRACKET	1
27	EAST0530	SPACER BAR 70"	1
28	ESC00586	COLLAR 1" SHAFT TWO PIECE	10
29	EAST0363	HEAD SHIMS 16GA	8
32	EAST0029*	SWITCH LIMIT MICRO*	2
33	EP000207	PFU TERMINAL STRIP BOX	1
34	EAST0185	TERMINAL STRIP 10 PLACE	1
35	EAST0081	TERMINAL STRIP 5 PLACE	1
	EAST1004	ROMEX CONNECTOR 3/8"	2
	ESC00563	POWER CORD 18-3 SO CORD	8 FT
	SA000507	SO CORD 18-5 600 VOLT	8 FT
	EAST0845	SEAL HEAD CORNER SUPPORT	2

\* One each of items marked with an asterisk (\*) are included in spare parts kit SUBK100-5070. Specify electrical power requirements (-V number) when ordering.

#### SEAL HEAD, HOT KNIFE EM5070TK MUSHROOM PTFE/PFA – SUBA0211-5070

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	EAST0022	PILLOW BLOCK 1"	4
2	EAST0532	REAR SHAFT EM70	1

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
3	EAST0747	HANDLE FOR SEALER EM70	1
4	EAST0338	MAGNET HOLDER UP EM40 MM	2
5	EAST0456	HEAD RETURN ARM MM	4
6	EAST0511	HOT KNIFE SADDLE W/SLOT MM	5
7	EAST0511E	HOT KNIFE SADDLE W/EXSLOT	3
8	EAST0514	HOT KNIFE SPACER BLOCK MM	3
9	EAST0515	HOT KNIFE CORNER SPACER MM	1
10	EAST0560	HOT KNIFE THREADED ROD	8
11	EAST0762	HOT KNIFE SEAL BAR UPPER 70" FRONT	1
12	EAST0960	HOT KNIFE SEAL BAR UPPER 50" SIDE	1
13	EAST0767	CROSS OVER BAR 70"	1
14	EAST0793	SAFETY SHIELD INNER 70" FRONT	1
15	EAST0794	SAFETY SHIELD OUTER 70" FRONT	1
16	EAST0963	SAFETY SHIELD INNER 50" SIDE	1
17	EAST0964	SAFETY SHIELD OUTER 50" SIDE	1
18	ESC00580*	FIREROD CART 220V 35"	2
19	EAST0678*	FIREROD CART 220V 50"	1
20	EAST0966	ARM CASTING HK OUT	1
21	EAST0967	ARM CASTING HK IN	1
22	EAST1058	ARM CASTING CENTER 50"	1
23	EAST0810	HOT KNIFE MAGNET HOLDER	2
24	EAST0820**	CUTTING RULE 70" FRONT**	1
25	EAST0868**	CUTTING RULE 50" SIDE**	1
26	EAST0900	MAGNET HOLDER UPPER	2
27	EAST0901	MAGNET HOLDER UPPER PAD	2
28	EAST0763**	MUSHROOM INSERT 70" FRONT**	1
29	EAST0915**	MUSHROOM INSERT 50" SIDE**	1
30	EAST1007	SAFETY SHIELD SPRING	5
31	EAST1018	COLLAR 1"	2
32	EP000095	HOT KNIFE SPACER BLOCK	5
33	EAST0514E	HOT KNIFE SPACER BLOCK	1
34	EP000535*	THERMOCOUPLE HOT KNIFE*	3
35	ESC00037	HOT KNIFE SADDLE CENTER	1
36	SUBA0065	MAGNET UPPER (NEW 3 PART)	2
37	WH209	SPLIT TENSION PIN 3/16 X	2
38	XH348	SPLIT TENSION PIN 3/16	8
39	XH360	BOLT 1/4 X 1-1/4 SHOULDER	5
40	EAST0165	HANDLE GRIP MATERIAL	6 FT



\* One each of items marked with an asterisk (\*) are included in spare parts kit SUBK100-5070. Specify electrical power requirements (-V number) when ordering.

\*\*One each of items marked with two asterisks (\*\*) are included in the cutting rule and mushroom insert kit SUBK00222-5070.

### CONVEYOR TAKEAWAY EM5070TK – SUBA0036R

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	EAST0199	SPROCKET BANDO/STEEL TIMI	1
3	EAST0074	TIMING BELT EM5252	1
5	EAST1073	CONVEYOR BELT 5070	1
6	EAST0484	MOTOR-110/230V 1PH 97RPM 1:15	1
9	MB000291	MOTOR BOLT PLATE	1
11	EAST0969	DRIVE ROLLER 50 X 50	1
12	EAST0970	IDLER ROLLER 50 X 50	1
17	EAST1072	CONVEYOR TAKEAWAY 50 X 70	1
21	ESC00658	SNAP RING 5/8"	2
23	EAST0697	ELECT BOX - TUNNEL MTRS	1
24	EAST0185	TERMINAL STRIP 10 PLACE	1
25	ETC00559	HOLE PLUG BUTTONS 7/8"	1
	EAST1004	ROMEX CONNECTOR 3/8"	1
	ESC00563	POWER CORD 18-3 SO CORD	14.3 FT

### 50" POWER FILM UNWIND STANDALONE – SUBA0952

See the Power Film Unwind section of this Parts section for Power Film Unwind parts.

ELECTRICAL BOARD EM2070-TKV1, EM2080-TKV1 & EM20100-TKV1, EM3070-TKV1, EM3080-TKV1 & EM30100-TKV1, EM4070-TKV1 & EM4080-TKV1, EM5070-TKV1, EM5080-TKV1 & EM50100-TKV1 – SUBA1073

See the Electrical Board section of this Parts section for Electrical Board Parts.

**EM5080TK Professional Series L-Sealer Main Assembly**

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	SUBA0211-5080	SEAL HEAD HOT KNIFE EM5080 MUSHROOM PTFE/PFA	1
2	SUBA1036N	CONVEYOR TAKEAWAY EM5080	1
3	SUBA0952	POWER FILM UNWIND STANDALONE 50"	1
4	SUBA1073	ELECTRICAL BOARD EM2070 EM2080 EM20100 EM3070 EM3080 EM30100 EM4070 EM4080 EM5070 EM5080 EM50100	1
5	EAST0186	PRODUCT TRAY 50X80	1
	EAST0179	PRODUCT TRAY TUBES 50 WIDE	4
6	EAST0494*	TEMPERATURE CONTROL FOR SEAL BARS*	2
7	EAST1030*	TIMER DWELL/CONVEYOR 220VAC 5A DPDT TON*	2
	ETC00210	KNOB ELECTRICAL PANEL	1
9	ETC00309	SWITCH POWER ON / OFF TOGGLE	1
	ETC00310	SWITCH ON-OFF FACE PLATE	1
10	EAST0168	DRAWER COMP 30 X 40&50	1
11	SUBA0106	MAGNET & HOLDER LOWER	3
12	SUBA0105	LEVELING FOOT ASSY.5/8 7"	8
13	SUB01461*	HEAD RETURN CYLINDER KIT*	4
14	EAST0438*	HEAD RETURN BALL JOINT*	4
15	EAST0423	AIR CYLINDER BRACKET HK	1
	EAST0512	HOT KNIFE ACTUATOR MM	1
16	EAST0892	SEAL BAR LOWER FRONT 80"	1
17	EAST0965	SEAL BAR LOWER SIDE 50"	1
18	EAST0404	Conveyor S Handle 30X40	1
19	EAST0209*	SPONGE RUBBER 1/4" X 3/4"*	10 FT
	EAST0209*	SPONGE RUBBER 1/4" X 3/4"*	7.5 FT
20	ET000113	SPROCKET UNDERSIDE COMBO	4
	ET000012	SPROCKET MARTIN 41B12 1/2	1
	ET000072	THRUST BEARING-NICE 603-	1
	ET000073	THRUST BEARING NICE 607	4
	72000006	CHAIN #41 RIVETED DRIVE	24 FT
	72000007	CHAIN - MASTER LINK #41R	3
21	EAST0835	HOT KNIFE WIRE GUARD 80"	1
22	EAST0962	WIRE GUARD 50" SIDE	1
23	EAST0238	WIRE HOLE BUSHING	4
24	EAST0320	CONNECTOR BUTT SEAM RING	1
25	EAST0321	CONNECTOR BUTT SEAM RING	4
26	EAST0597	HOT KNIFE CONDUIT BRACKET	1

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
28	EAST1018	COLLAR 1"	8
29	EAST0363	HEAD SHIMS 16GA	3
37	EAST0835	HOT KNIFE WIRE GUARD 80"	1

\* One each of items marked with an asterisk (\*) are included in spare parts kit SUBK100-5080. Specify electrical power requirements (-V number) when ordering.

#### SEAL HEAD, HOT KNIFE EM5080 MUSHROOM PTFE/PFA – SUBA0211-5080

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	EAST0022	PILLOW BLOCK 1"	5
2	EAST0890	REAR SHAFT EM80 84"	1
3	EAST0748	HANDLE FOR SEALER EM80	1
4	EAST0338	MAGNET HOLDER UP EM40 MM	2
5	EAST0456	HEAD RETURN ARM MM	4
6	EAST0511	HOT KNIFE SADDLE W/SLOT MM	53
7	EAST0511E	HOT KNIFE SADDLE W/EXSLOT	3
8	EAST0514	HOT KNIFE SPACER BLOCK MM	2
9	EAST0515	HOT KNIFE CORNER SPACER MM	1
10	EAST0560	HOT KNIFE THREADED ROD	9
11	EAST0858	HOT KNIFE SEAL BAR UPPER 80" FRONT	1
12	EAST0960	SEAL BAR UPPER 50" SIDE	1
13	EAST0857	CROSS OVER BAR 80"	1
14	EAST0859	SAFETY SHIELD INNER 80" FRONT	1
15	EAST0860	SAFETY SHIELD OUTER 80" FRONT	1
16	EAST0963	SAFTEY SHIELD 50" INNER SIDE	1
17	EAST0964	SAFTEY SHIELD 50" OUTER SIDE	1
18	EAST0629*	FIREROD CART 220V 40"	2
19	EAST0678*	FIREROD CART 220V 50"	1
20	EAST0966	HOT KNIFE ARM CASTING HK EXIT	1
21	EAST0967	HOT KNIFE ARM CASTING HK INFEEED	2
22	EAST1058	ARM CASTING CENTER 50"	1
23	EAST0810	HOT KNIFE MAGNET HOLDER	2
24	EAST0824**	CUTTING RULE FRONT 80" SUP**	1
25	EAST0868**	CUTTING RULE 50" SIDE**	1
26	EAST0900	MAGNET HOLDER UPPER	2
27	EAST0901	MAGNET HOLDER UPPER PAD	2
28	EAST0916**	MUSHROOM INSERT FRONT 40"***	2

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
29	EAST0915**	MUSHROOM INSERT 50" SIDE**	1
30	EAST1007	SAFETY SHIELD SPRING	2.5
31	EAST1018	COLLAR 1"	2
32	EP000095	HOT KNIFE SPACER BLOCK	5
33	EAST0514E	HOT KNIFE SPACER BLOCK	2
34	EP000535*	THERMOCOUPLE HOT KNIFE*	3
35	ESC00037	HOT KNIFE SADDLE CENTER	1
36	SUBA0065	MAGNET UPPER (NEW 3 PART)	2
37	WH209	SPLIT TENSION PIN 3/16 X	2
38	XH348	SPLIT TENSION PIN 3/16	9
39	XH360	BOLT 1/4 X 1-1/4 SHOULDER	5
40	EAST0165	HANDLE GRIP MATERIAL	8.5 FT

\* One each of items marked with an asterisk (\*) are included in spare parts kit SUBK100-5080. Specify electrical power requirements (-V number) when ordering.

\*\*One each of items marked with two asterisks (\*\*) are included in the cutting rule and mushroom insert kit SUBK00222-5080.

#### CONVEYOR TAKEAWAY 5080 – SUBA0036N

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
3	EAST0074	TIMING BELT EM5252	1
5	EAST1063	CONVEYOR BELT EM5080	1
11	EAST0969	DRIVE ROLLER 50 X 50	1
12	EAST0970	IDLER ROLLER 50 X 50	1
14	EAST0199	SPROCKET BANDO/STEEL TIMI	1
21	ESC00658	SNAP RING 5/8"	2
23	EAST0697	ELECT BOX - TUNNEL MTRS	1
24	EAST0185	TERMINAL STRIP 10 PLACE	1
25	ETC00559	HOLE PLUG BUTTONS 7/8"	1
	EAST1004	ROMEX CONNECTOR 3/8"	1
	ESC00563	POWER CORD 18-3 SO CORD	14 FT

**50" POWER FILM UNWIND STANDALONE – SUBA0952**

See the Power Film Unwind section of this Parts section for Power Film Unwind parts.

ELECTRICAL BOARD EM2070-TKV1, EM2080-TKV1 & EM20100-TKV1, EM3070-TKV1, EM3080-TKV1 & EM30100-TKV1, EM4070-TKV1 & EM4080-TKV1, EM5070-TKV1, EM5080-TKV1 & EM50100-TKV1 – SUBA1073

See the Electrical Board section of this Parts section for Electrical Board Parts.

**EM50100TK Professional Series L-Sealer Main Assembly**

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	SUBA0211-50100	SEAL HEAD HOT KNIFE EM50100 MUSHROOM PTFE/PFA	1
2	SUBA0036Q	CONVEYOR TAKEAWAY EM50100	1
3	SUBA0952	POWER FILM UNWIND STANDALONE 50"	1
4	SUBA1073	ELECTRICAL BOARD EM2070 EM2080 EM20100 EM3070 EM3080 EM30100 EM4070 EM4080 EM5070 EM5080 EM50100	1
5	EAST1517	PRODUCT TRAY 50X100	1
	EAST0179	PRODUCT TRAY TUBES 50 WIDE	8
6	EAST0494*	TEMPERATURE CONTROL FOR SEAL BARS*	2
7	EAST1030*	TIMER DWELL/CONVEYOR 220VAC 5A DPDT TON*	2
8	ETC00210	KNOB ELECTRICAL PANEL	1
9	ETC00309	SWITCH POWER ON / OFF TOGGLE	1
	ETC00310	SWITCH ON-OFF FACE PLATE	1
10	EAST0168	DRAWER COMP 30 X 40&50	1
11	SUBA0106	MAGNET & HOLDER LOWER	5
12	SUBA0105	LEVELING FOOT ASSEMBLY 5/8 7"	8
13	SUB01461*	HEAD RETURN CYLINDER KIT*	6
	EAST0423	AIR CYLINDER BRACKET HK	2
	EAST0438*	HEAD RETURN BALL JOINT*	6
14	EAST0098	COUNTERWEIGHT 100TK	1
15	EAST0512	HOT KNIFE ACTUATOR MM	1
16	EAST0861	SEAL BAR LOWER FRONT 100"	1
17	EAST0965EXT2	SEAL BAR LOWER SIDE 52"	1
18	EAST0404	CONVEYOR S HANDLE 30X40	1
19	EAST0209*	SPONGE RUBBER 1/4" X 3/4"*	10 FT
	EAST0209*	SPONGE RUBBER 1/4" X 3/4"*	7.5 FT
20	ET000113	SPROCKET UNDERSIDE COMBO	4
	ET000012	SPROCKET MARTIN 41B12 1/2	1
	ET000072	THRUST BEARING-NICE 603	1

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
	ET000073	THRUST BEARING NICE 607	4
	72000006	CHAIN #41 RIVETED DRIVE	24 FT
	72000007	CHAIN - MASTER LINK #41R	3
21	EAST0830	WIRE GUARD 100" HOT KNIFE	1
22	EAST0962	WIRE GUARD 50" SIDE	1
23	EAST0238	WIRE HOLE BUSHING	4
24	EAST0320	CONNECTOR BUTT SEAM RING	1
25	EAST0321	CONNECTOR BUTT SEAM RING	4
26	EAST0597	HOT KNIFE CONDUIT BRACKET	1
27	EAST0862	SPACER BAR LOWER 100"	1
28	EAST1018	COLLAR 1"	8
29	EAST0363	HEAD SHIMS 16GA	3
37	EAST1004	ROMEX CONNECTOR 3/8"	1

## SEAL HEAD, HOT KNIFE EM50100TK MUSHROOM PTFE/PFA – SUBA0211-50100

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	EAST0022	PILLOW BLOCK 1"	2
2	EAST0176	REAR SHAFT 104" EMXXX100s	1
3	EAST0177	HANDLE FOR SEALER EM40100	1
4	EAST0338	MAGNET HOLDER UP EM40 MM	2
5	EAST0456	HEAD RETURN ARM	2
6	EAST0511	HOT KNIFE SADDLE W/SLOT MM	6
7	EAST0511E	HOT KNIFE SADDLE W/EXSLOT	4
8	EAST0514	HOT KNIFE SPACER BLOCK MM	2
9	EAST0515	HOT KNIFE CORNER SPACER MM	2
10	EAST0560	HOT KNIFE THREADED ROD	6
11	EAST0960	HK SEAL BAR UPPER S 50"	1
12	EAST0656	HOT KNIFE SEAL BAR UP FNT	1
13	EAST0659	CROSS OVER BAR 100"	1
14	EAST0658	SAFETY SHIELD INNER 100"	1
15	EAST0657	SAFETY SHIELD OUTER 100"	1
16	EAST0963	SAFTEY SHEILD INNER S 50"	1
17	EAST0964	SAFTEY SHEILD OUTER S 50"	1
18	EAST0678*	FIREROD CART 220V 50"*	3
19	EAST0966	HOT KNIFE ARM CASTING TAKEAWAY EXIT	1
20	EAST0967	HOT KNIFE ARM CASTING PRODUCT INFEED	1
21	EAST1058	ARM CASTING CENTER 50"	2

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
22	EAST0810	HOT KNIFE MAGNET HOLDER	1
23	EAST0839**	CUTTING RULE FRONT 101.5***	1
24	EAST0868**	CUTTING RULE SIDE 50" EXT 2"***	1
25	EAST0900	MAGNET HOLDER UPPER	1
26	EAST0901	MAGNET HOLDER UPPER PAD	1
27	EAST0786**	MUSHROOM INSERT FRONT 50"***	2
28	EAST0915**	MUSHROOM INSERT 50" SIDE**	1
29	EAST1007	SAFETY SHIELD SPRING	5
30	EAST1017	COLLAR 1"	2
31	EP000095	HOT KNIFE SPACER BLOCK	7
32	EAST0514E	HOT KNIFE SPACER BLOCK	2
33	EP000535*	THERMOCOUPLE HOT KNIFE*	3
34	ESC00037	HOT KNIFE SADDLE CENTER	1
35	SUBA0065	MAGNET UPPER (NEW 3 PART)	2
36	WH209	SPLIT TENSION PIN 3/16 X	2
37	XH360	BOLT 1/4 X 1-1/4 SHOULDER	5
38	EAST0165	HANDLE GRIP MATERIAL	4 FT

## CONVEYOR TAKEAWAY EM50100TK – SUBA0036Q

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
3	EAST0074	TIMING BELT EM5252	1
5	EAST1519	CONVEYOR BELT 50X100 CNTR GUID	1
6	ETC00185	MOTOR CONVEYOR DRIVE 1/8	1
9	MB000291	MOTOR BOLT PLATE	1
11	EAST0969	DRIVE ROLLER 50 X 50	1
12	EAST0970	IDLER ROLLER 50 X 50	1
14	EAST0199	SPROCKET BANDO/STEEL TIMI	1
17	EAST1518	CONVEYOR TAKEAWAY 50X100	1
24	EAST0697	ELECT BOX - TUNNEL MTRS	1

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
26	ETC00559	HOLE PLUG BUTTONS 7/8"	1
	EAST1004	ROMEX CONNECTOR 3/8"	1
	ESC00563	POWER CORD 18-3 SO CORD	16.9 FT

**50" POWER FILM UNWIND STANDALONE – SUBA0952**

See the Power Film Unwind section of this Parts section for Power Film Unwind parts.

ELECTRICAL BOARD EM2070-TKV1, EM2080-TKV1 & EM20100-TKV1, EM3070-TKV1, EM3080-TKV1 & EM30100-TKV1, EM4070-TKV1 & EM4080-TKV1, EM5070-TKV1, EM5080-TKV1 & EM50100-TKV1 – SUBA1073

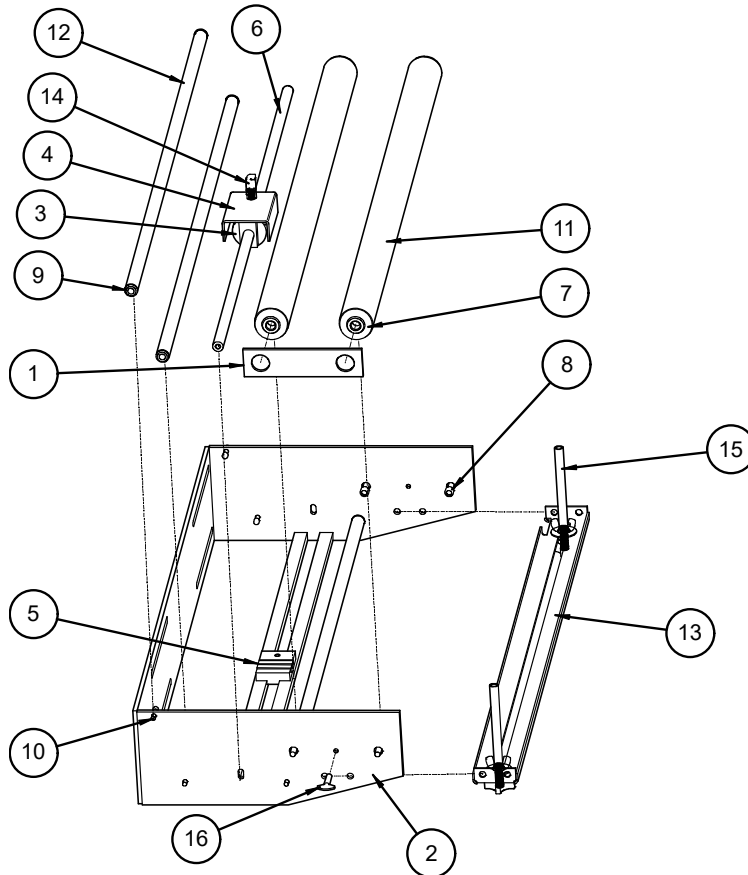
See the Electrical Board section of this Parts section for Electrical Board Parts.



## Film Racks for Manual Film Feed Parts Lists

### 26" Film Rack with Pin Perforator Wheel — SUBA0032

Standard For EM20 Models EM2016TK, EM2028TK, EM2040TK, EM2050TK, EM2070TK, EM2080TK & EM20100TK

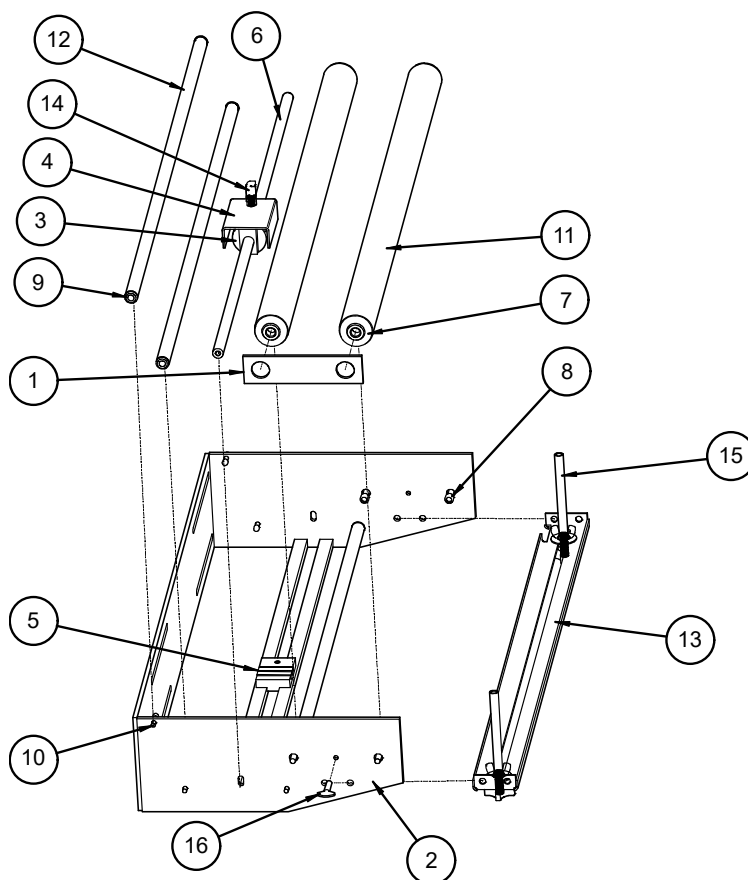


ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	EAST0240	FILM BRAKE 7" BRACKET M/M	1
2	EAST0266	FILM RACK COMPLETE	1
3	EAST0366	PIN PERF WHEEL	1
4	EAST0367	PIN PERF. GUARD M/M	1
5	EAST0368	PIN PERF LOWER PAD	1
6	EAST0369	PIN PERF SHAFT	1
7	EAST0378	BEARING FILM RACK LARGE ROLLER	4
8	EAST0379	FILM RACK ROLLER BOLTS LARGE	4
9	EAST0380	BEARING FILM RACK ROLLER BOLT SMALL	6
10	EAST0381	FILM RACK ROLLER BOLT SMALL	6
11	EAST0382	FILM RACK ROLLER LARGE	2
12	EAST0383	FILM RACK ROLLER SMALL	3

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
13	EAST0455	FILM RACK SIDE PLATE	1
14	ETC00210	KNOB ELECTRICAL PANEL	1
15	SUBA0123	FILM GUIDE BOLT ASSEMBLY	2
16	XH256	SCREW THUMB $5/16-18 \times 1-1/4$ "	1

### 36" Film Rack with Pin Perforator Wheel — SUBA0033

Standard for EM30 Series Models EM3040TK, EM3050TK, EM3070TK, EM3080TK & EM30100TK

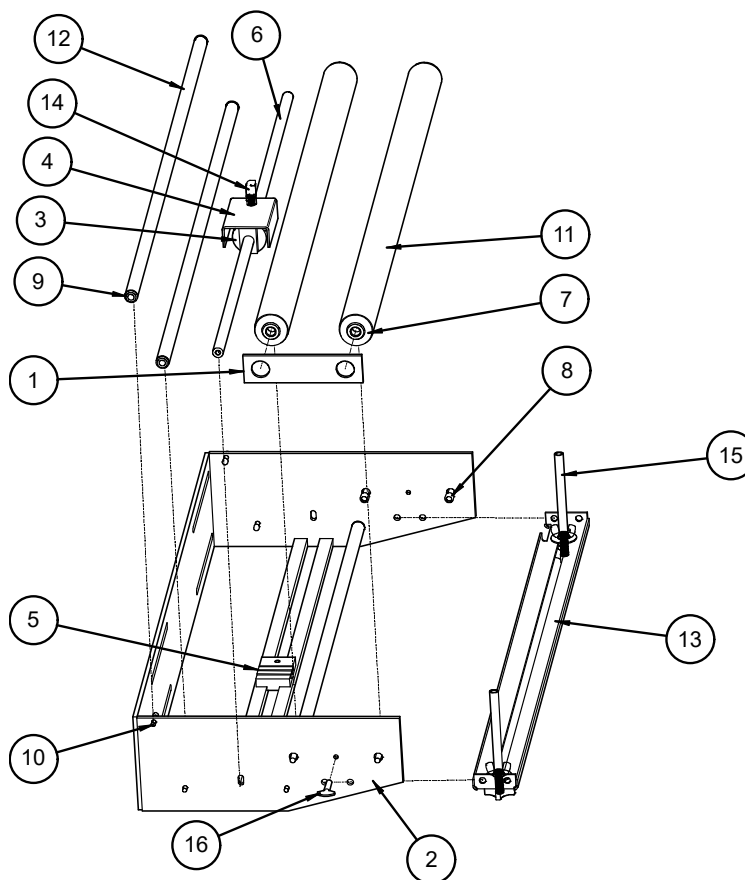


ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	EAST0240	FILM BRAKE 7" BRACKET M/M	1
2	EAST0303	FILM RACK COMPLETE "WIDE"	1
3	EAST0366	PIN PERF WHEEL	1
4	EAST0367	PIN PERF. GUARD M/M	1
5	EAST0368	PIN PERF LOWER PAD M/M	1
6	EAST0370	PIN PERF SHAFT	1
7	EAST0378	BEARING FILM RACK LARGE ROLLER	4

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
8	EAST0379	FILM RACK ROLLER BOLTS LARGE	4
9	EAST0380	BEARING FILM RACK ROLLER BOLT SMALL	6
10	EAST0381	FILM RACK ROLLER BOLT SMALL	6
11	EAST0413	FILM RACK ROLLER LARGE WIDE	2
12	EAST0414	FILM RACK ROLLER SMALL	3
13	EAST0473	FILM RACK SIDE PLATE WIDE	1
14	ETC00210	KNOB ELECTRICAL PANEL	1
15	SUBA0123	FILM GUIDE BOLT ASSEMBLY	2
16	XH256	SCREW THUMB 5/16-18 × 1-1/4"	1

### 46" Film Rack with Pin Perforator Wheel for EM40 Series — SUB00581

Optional for EM40 Series Models EM4040TK, EM4050TK, EM4070TK, EM4080TK & EM40100TK



ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	EAST0240	FILM BRAKE 7" BRACKET M/M	1
2	EAST0581	FILM RACK 46" WIDE COMPLETE	1

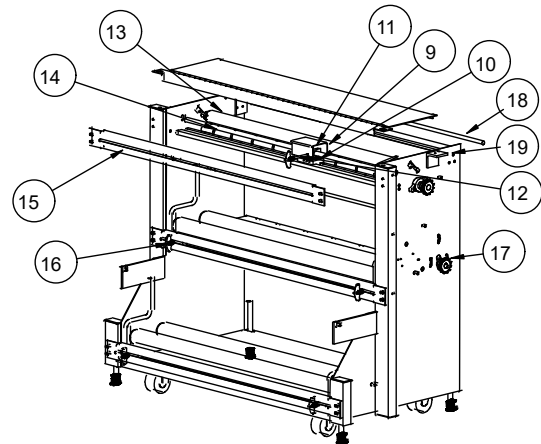
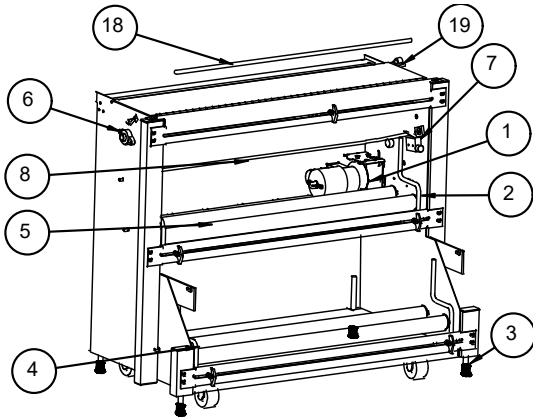
## 140 Parts List

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
3	EAST0366	PIN PERF WHEEL	1
4	EAST0367	PIN PERF. GUARD M/M	1
5	EAST0368	PIN PERF LOWER PAD	1
6	EAST0371	PIN PERF SHAFT X WIDE	1
7	EAST0378	BEARING FILM RACK LARGE ROLLER	4
8	EAST0379	FILM RACK ROLLER BOLTS LARGE	4
9	EAST0380	BEARING FILM RACK SMALL	6
10	EAST0381	FILM RACK ROLLER BOLT SMALL	6
11	EAST0583	FILM RACK ROLLER LARGE	2
12	EAST0584	FILM RACK ROLLER SMALL	3
13	EAST0454	FILM RACK SIDE PLATE	1
14	ETC00210	KNOB ELECTRICAL PANEL	1
15	SUBA0123	FILM GUIDE BOLT ASSEMBLY	2
16	XH256	SCREW THUMB $5/16$ -18 $\times$ 1- $1/4$ "	1

## Powered Film Unwind (PFU) Parts Lists

### 26" Powered Film Unwind, – SUBA0950 or SUBA0950-INV

Optional for EM20 Series Models EM2016TK, EM2028TK, EM2040TK, EM2050TK, EM2070TK, EM2080TK & EM20100TK



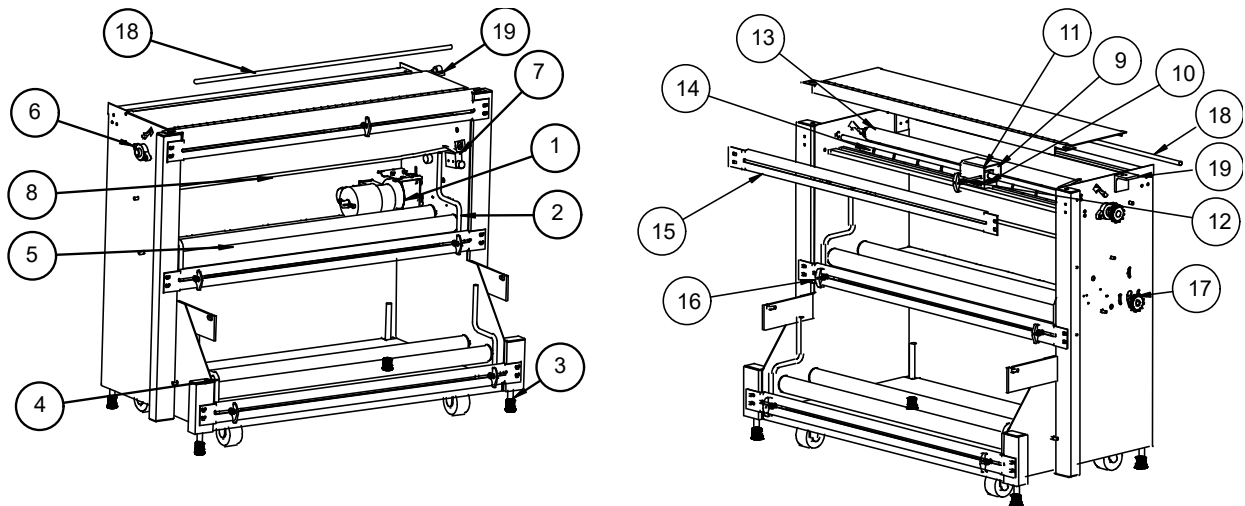
ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	EAST0063	GEAR MOTOR	1
2	EP000017	FILM GUIDE RIGHT	2
3	SUBA0105	LEVELING FOOT ASSEMBLY	4
4	EP000016	FILM GUIDE LEFT	2
5	EAST0382	FILM RACK ROLLER, LARGE	4
6	ETC00308	BEARING 5/8" FLANGED BALL	2
7	EP000561	SWITCH – LIMIT PFU	2
8	EP000011	DANCER BAR TUBE 26"	1
9	EP000205	PIN PERFORATOR SHIELD	1*
10	EAST0368	PIN PERFORATOR LOWER PAD	1*
11	EAST0366	PIN PERFORATOR WHEEL	1*
12	EP000543	STUD FILM UNWIND	1*
13	EP000005	PINCH ROLLER TUBE	1
14	EP000001	RUBBER DRIVE ROLLER	1
15	EP000208	FILM BACK GUIDE HOLDER	1
16	ETC00210	KNOB	1
17	ETC00301	SPROCKET DRIVE	2

Following parts are used only on SUBA0950-INV

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
18	I0000033	INVERTER SEPARATOR ROD 26"	1
19	I0000006	INVERTER SEPARATOR ROD BRACKET	1

### 35" Powered Film Unwind – SUBA0951 or SUBA0951-INV

Optional for EM30 Series Models EM2016TK, EM2028TK, EM2040TK, EM2050TK, EM2070TK, EM2080TK & EM20100TK



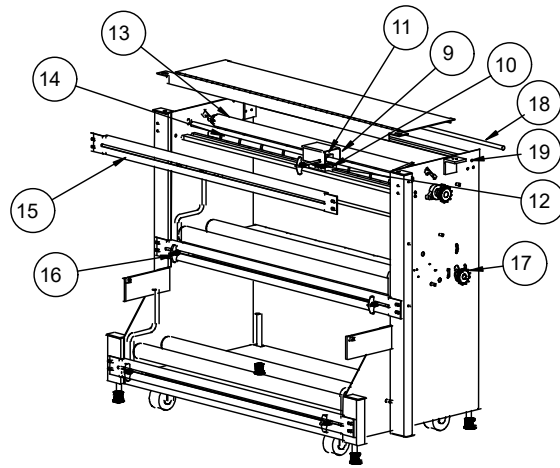
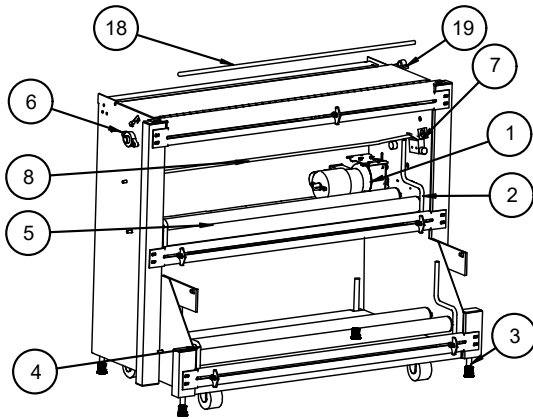
ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	EAST0063	GEAR MOTOR	1
2	EP000017	FILM GUIDE RIGHT	2
3	SUBA0105	LEVELING FOOT ASSEMBLY	4
4	EP000016	FILM GUIDE LEFT	2
5	EAST4006	FILM RACK ROLLER, LARGE	4
6	ETC00308	BEARING 5/8" FLANGED BALL	2
7	EP000561	SWITCH – LIMIT PFU	2
8	EAST4012	DANCER BAR TUBE 35"	1
9	EP000205	PIN PERFORATOR SHIELD	1*
10	EAST0368	PIN PERFORATOR LOWER PAD	1*
11	EAST0366	PIN PERFORATOR WHEEL	1*
12	EP000543	STUD FILM UNWIND	1
13	EAST4013	PINCH ROLLER TUBE	1
14	EP340001	RUBBER DRIVE ROLLER	1
15	EAST4004	FILM BACK GUIDE HOLDER	2
16	ETC00210	KNOB	1
17	ETC00301	SPROCKET DRIVE	2

Following parts are used only on SUBA0951-INV

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
18	I0000034	INVERTER SEPARATOR ROD 36"	1
19	I0000006	INVERTER SEPARATOR BRACKET	1

## 50" Powered Film Unwind – SUBA0952 or SUBA0952-INV

Standard for EM40 & EM50 Series Models EM4040TK, EM4050TK, EM4070TK, EM4080TK, EM40100TK, EM4050TK, EM4070TK, EM4080TK & EM40100TK

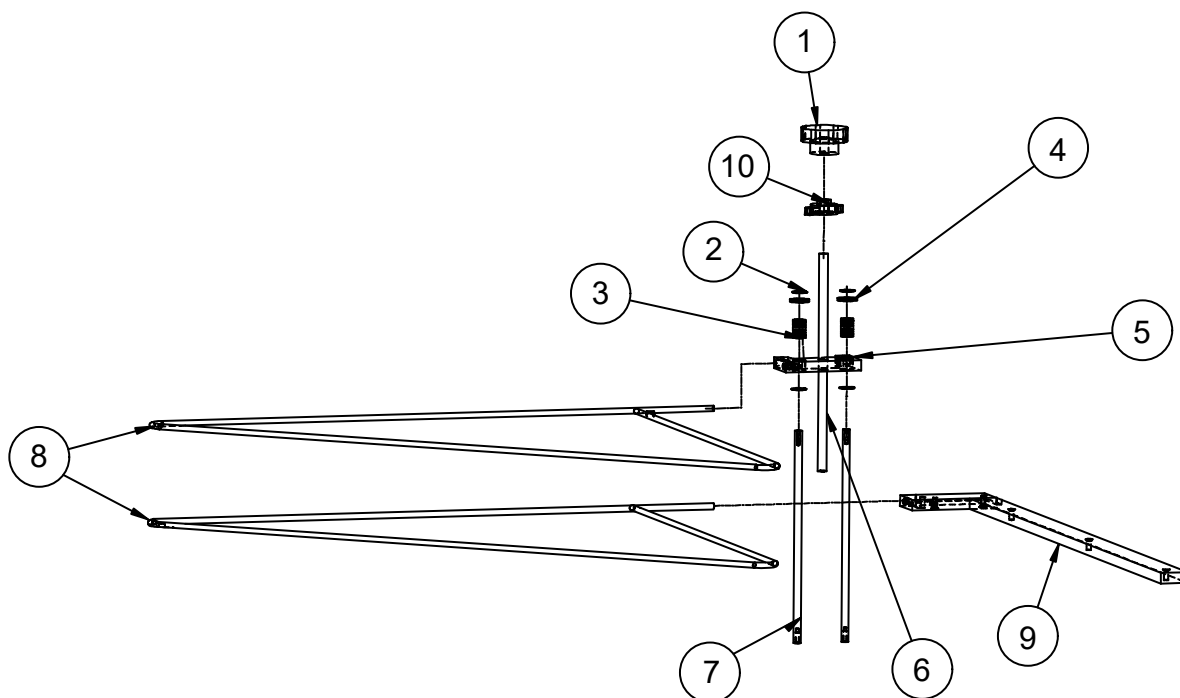


ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	EAST0063	GEAR MOTOR	1
2	EP000017	FILM GUIDE RIGHT	2
3	SUBA0105	LEVELING FOOT ASSEMBLY	4
4	EP000016	FILM GUIDE LEFT	2
5	EAST5012	FILM RACK ROLLER, LARGE	4
6	ESC00626	BEARING FLANGE 3/4"	2
7	EP000561	SWITCH – LIMIT PFU	2
8	EAST5010	DANCER BAR TUBE 50"	1
9	EP000205	PIN PERFORATOR GUARD	2*
10	EAST0368	PIN PERFORATOR LOWER PAD	2*
11	EAST0366	PIN PERFORATOR WHEEL	2*
12	EP000543	STUD FILM UNWIND	2
13	EAST5013	PINCH ROLLER TUBE	1
14	ES500007	RUBBER DRIVE ROLLER	1
15	EAST5003	FILM BACK GUIDE HOLDER	2
	EAST5004	FILM BACK GUIDE HOLDER	1
16	ETC00210	KNOB	2
17	ETC00301	SPROCKET DRIVE	1

Following parts are used only on SUBA0952-INV

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
18	LS50004	INVERTER SEPARATOR ROD 50"	1
19	I0000006	INVERTER SEPARATOR ROD BRACKET	1

## Film Inverters Parts Lists

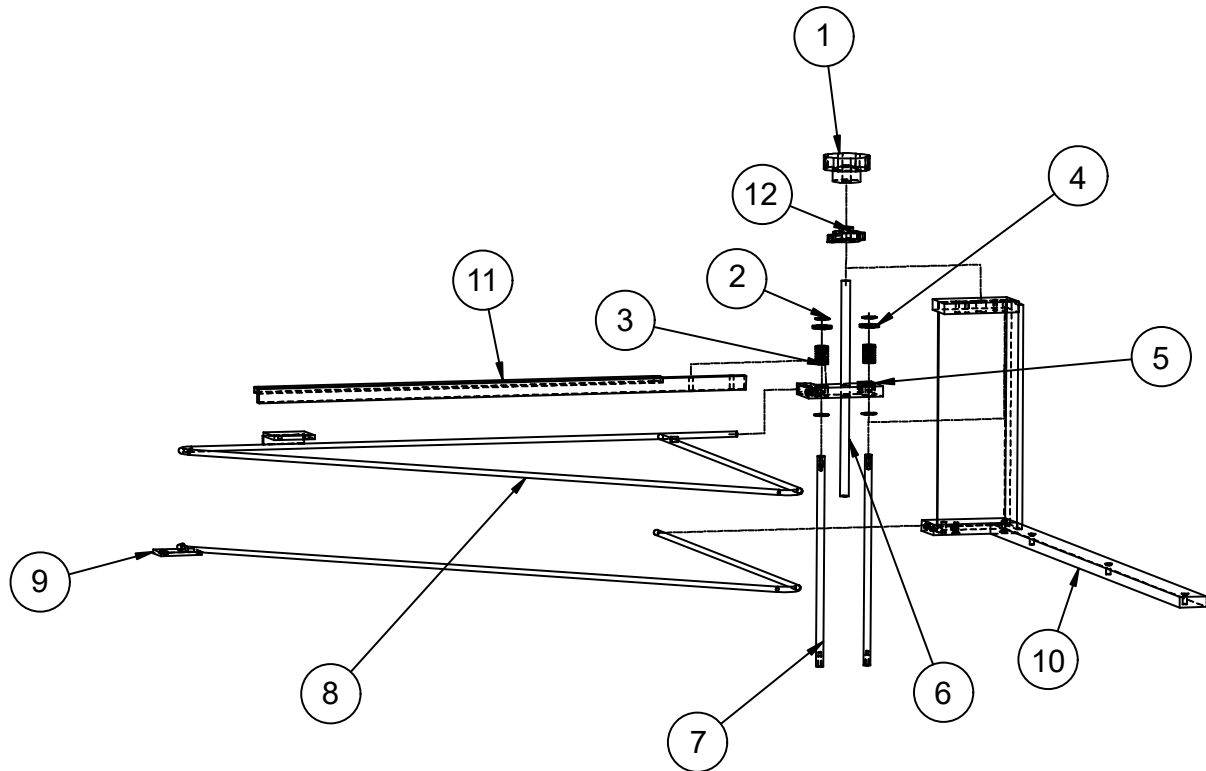


### Inverting Head 24" Only – SUB00189

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	EAST0446	KNOB FOR INVERTING HEAD	1
2	EAST1012	SNAP RING $\frac{7}{8}$ "	4
3	EINVT003	LINEAR BEARING $\frac{1}{2}$ " BORE	2
4	EINVT022	MACHINED BUSHING WASHER	2
5	EINVT126	INVERTING UPPER BLOCK	1
6	EINVT001	THREADED ROD $\frac{5}{8}$ " $\times$ 9- $\frac{1}{4}$	1
7	EINVT005	INVERTING HEAD HEIGHT ADJ. SHAFT	2
8	EINVT124	INVERTING ROD STYLE 24"	2
9	EINV002	LOWER INVERTING PLATE ADJUSTMENT	1
10	ETC00308	BEARING $\frac{5}{8}$ FLANGE BALL	1



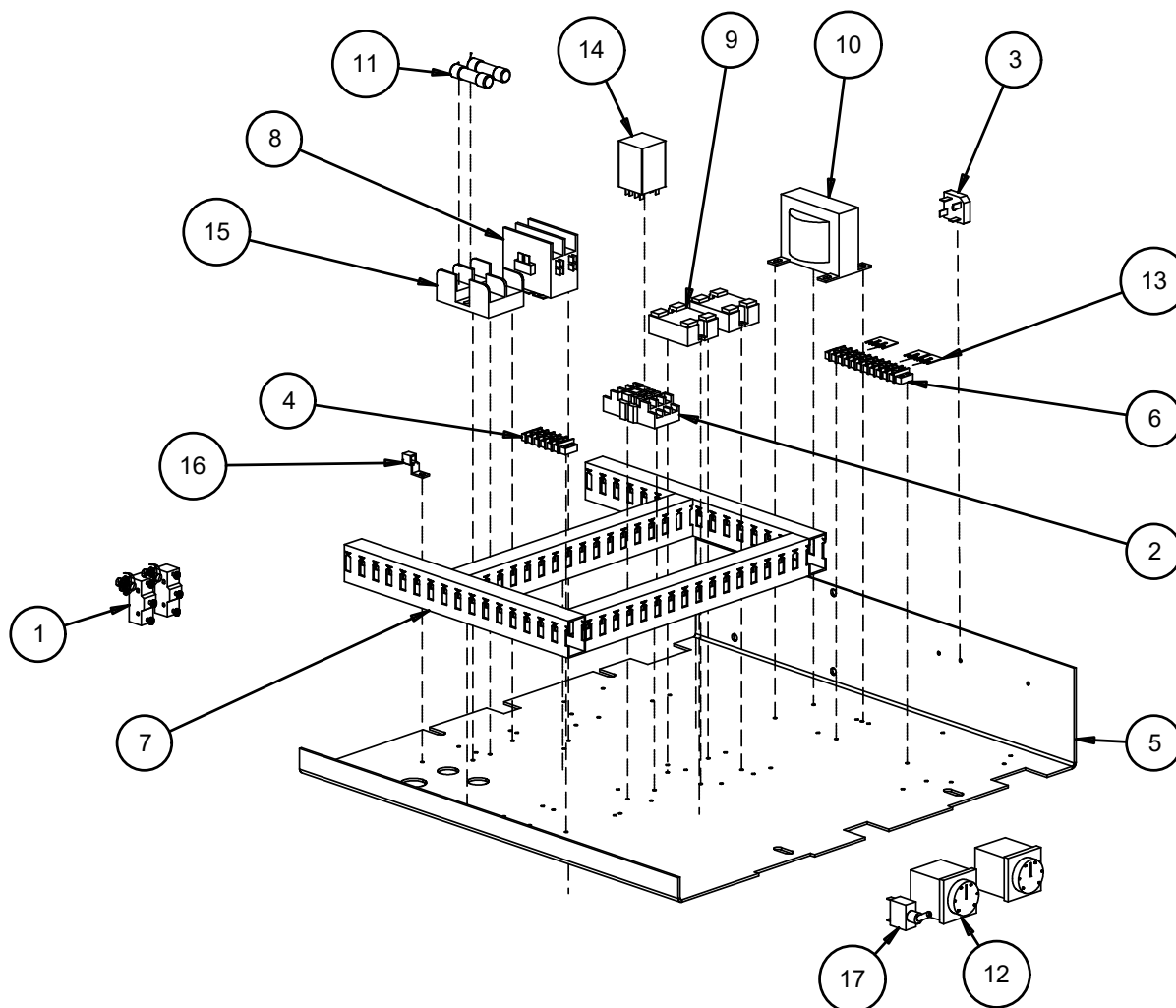
## Inverting Head 36" Rod Heavy Duty – SUBA0232



ITEM	PART NUMBER	DESCRIPTION	QUANTITY
1	EAST0446	KNOB FOR INVERTING HEAD	1
2	EAST1012	SNAP RING $\frac{7}{8}$ "	4
3	EINVT003	LINEAR BEARING $\frac{1}{2}$ " BORE	2
4	EINVT022	MACHINED BUSHING WASHER	2
5	EINVT126	INVERTING UPPER BAR	1
6	EINVT201	THREADED ROD $\frac{5}{8}$ "	1
7	EINVT205	INVERTING HEAD HEIGHT ADJ. SHAFT	2
8	EINVT236	INVERTING ROD 36" UPPER HEAVY DUTY	1
9	EINVT237	INVERTING ROD 36" LOWER HEAVY DUTY	1
10	EINVT250	INVERTER 15" TALL HEAVY DUTY	1
11	EINVT251	UPPER ROD BRACE	1
12	ETC00308	BEARING $\frac{5}{8}$ FLANGE BALL	1

## Electrical Boards

### ELECTRICAL BOARD FOR EM2016-TKV1 & EM2028-TKV1 SUBA0022



ITEM	DESIGNATOR	PART NUMBER	DESCRIPTION	QUANTITY
1	SWL	EAST0029*	SWITCH LIMIT MICRO*	2
2	RS3PDT10A	EAST0034	SOCKET-RELAY 3PDT 10A	1
3	BR	EAST0038	BRIDGE RECTIFIER	1
4	TS5	EAST0081	TERMINAL STRIP 5 PLACE	1
5	BEB	EAST0088	ELECTRICAL BOARD	1
6	TS10	EAST0185	TERMINAL STRIP 10 PLACE	1
7	WWDC	EAST0361	WIREWAY DUCT & COVER	4 FT
8	CT30A2P	EAST0421	CONTACTOR-30 AMP 220VAC 2POLE	1
9	RSS	EAST0495	RELAY-SOLID STATE HOT KNIFE	2
	RSC	EAST0032A	RELAY SPRING CLIP (POTTER)	1

ITEM	DESIGNATOR	PART NUMBER	DESCRIPTION	QUANTITY
10	TMP	EAST0663	TRANSFORMER MAGNET PRESSURE	1
11	F10A	ET000301*	FUSE 10 AMP 250 VOLT*	2
12	TI1&2	EAST1030*	TIMER-220VAC 5A DPDT TON*	2
13	J10P	ESC00552	JUMPERS 10 POLE	0.5
14	RDPDT	ET820016	RELAY-DPDT 240 V COIL 10A	1
15	FB30A	ETC00125	FUSE BLOCK 30 AMP 250VOLT	1
16	GL	ETC00203	GROUND LUGS ILSCO 14-6	1
17	SW1	ETC00309	SWITCH POWER ON/OFF	1
	WKPC	EAST6000	KIT-PRE-CUT WIRES FOR BOARDS	1

\* One each of items marked with an asterisk (\*) are included in spare parts kit SUBK100-2016 or SUBK100-2028. Specify sealer nominal maximum seal size (EM model number) and electrical power requirements (-V number) when ordering.

#### ELECTRICAL BOARD FOR EM2040-TKV1 – SUBA0223 (17 items)

ITEM	DESIGNATOR	PART NUMBER	DESCRIPTION	QUANTITY
1	SWL	EAST0029*	SWITCH LIMIT MICRO*	2
2	RS3PDT10A	EAST0034	SOCKET-RELAY 3PDT 10A	1
3	BR	EAST0038	BRIDGE RECTIFIER	1
4	TS5	EAST0081	TERMINAL STRIP 5 PLACE	1
5	BEB	EAST0088	ELECTRICAL BOARD	1
6	TS10	EAST0185	TERMINAL STRIP 10 PLACE	1
7	WWDC	EAST0361	WIREWAY DUCT & COVER	4 FT
8	CT30A2P	EAST0421	CONTACTOR-30 AMP 220VAC 2POLE	1
9	RSS	EAST0495	RELAY-SOLID STATE HOT KNIFE	2
10	TMP	EAST0663	TRANSFORMER MAGNET PRESSURE	1
11	F15A	ETL00200*	FUSE 15 AMP 250 VOLT*	2
12	TI1&2	EAST1030*	TIMER-220VAC 5A DPDT TON*	2
13	J10P	ESC00552	JUMPERS 10 POLE	1
14	RDPDT	ET820016	RELAY-DPDT 240 V COIL 10A	1
15	FB30A	ETC00125	FUSE BLOCK 30 AMP 250VOLT	1
16	GL	ETC00203	GROUND LUGS ILSCO 14-6	1
17	SW1	ETC00309	SWITCH POWER ON/OFF	1
	CBS	EAST0323	CONNECTOR BUTT SPLICE 16	1
	MAA2	EAST0100	DOUBLE MALE ADAPTER FOR	3

\* One each of items marked with an asterisk (\*) are included in spare parts kit SUBK100-2040. Specify electrical power requirements (-V number) when ordering.

## ELECTRICAL BOARD FOR EM2050-TKV1, EM4050-TKV1 &amp; EM5050-TKV1 – SUBA1064

ITEM	DESIGNATOR	PART NUMBER	DESCRIPTION	QUANTITY
1	SWL	EAST0029*	SWITCH LIMIT MICRO*	2
2	RS3PDT10A	EAST0034	SOCKET-RELAY 3PDT 10A	1
3	BR	EAST0038	BRIDGE RECTIFIER	1
4	TS5	EAST0081	TERMINAL STRIP 5 PLACE	1
5	BEB	EAST0088	ELECTRICAL BOARD	1
6	TS10	EAST0185	TERMINAL STRIP 10 PLACE	1
7	WWDC	EAST0361	WIREWAY DUCT & COVER	4 FT
8	CT30A2P	EAST0421	CONTACTOR-30 AMP 220VAC 2POLE	1
9	RSS	EAST0495	RELAY-SOLID STATE HOT KNIFE	2
10	TMP	EAST0663	TRANSFORMER MAGNET PRESSURE	1
11	F20A	EAST1009*	FUSE 20 AMP 250 VOLT*	2
12	TI1&2	EAST1030*	TIMER-220VAC 5A DPDT TON*	2
13	J10P	ESC00552	JUMPERS 10 POLE	1
14	RDPDT10A	ET820016	RELAY-DPDT 240 V COIL 10A	1
15	FB30A	ETC00125	FUSE BLOCK 30 AMP 250VOLT	1
16	GL	ETC00203	GROUND LUGS ILSCO 14-6	1
17	SW1	ETC00309	SWITCH POWER ON/OFF	1
	WKPC	EAST6000	KIT-PRE-CUT WIRES FOR BOARDS	1

\* One each of items marked with an asterisk (\*) are included in spare parts kit SUBK100-2050, SUBK100-4050, or SUBK100-5050. Specify sealer nominal maximum seal size (EM model number) and electrical power requirements (-V number) when ordering.

## ELECTRICAL BOARD FOR EM2070-TKV1, EM2080-TKV1 &amp; EM20100-TKV1, EM3070-TKV1, EM3080-TKV1 &amp; EM30100-TKV1, EM4070-TKV1 &amp; EM4080-TKV1, EM5070-TKV1, EM5080-TKV1 &amp; EM50100-TKV1 – SUBA1073

ITEM	DESIGNATOR	PART NUMBER	DESCRIPTION	QUANTITY
1	EE5H	EAST0533-1	ENCLOSURE WITH 5 HOLE DOOR	1
2	RS3PDT10A	EAST0034	SOCKET-RELAY 3PDT 10A	1
3	BR	EAST0038	BRIDGE RECTIFIER	1
4	TS5	EAST0081	TERMINAL STRIP 5 PLACE	1
5	IPS70	EAST0534	INNER PANEL FOR SEALER-70	1
6	TS10	EAST0185	TERMINAL STRIP 10 PLACE	4
7	WWDC	EAST0361	WIREWAY DUCT & COVER	3 FT
8	CT30A2P	EAST0421	CONTACTOR-30 AMP 220VAC 2POLE	1
9	RSS	EAST0495	RELAY-SOLID STATE HOT KNIFE	3
	RSC	EAST0032A	RELAY SPRING CLIP (POTTER)	1

ITEM	DESIGNATOR	PART NUMBER	DESCRIPTION	QUANTITY
10	TMP	EAST0663	TRANSFORMER MAGNET PRESSURE	1
11	F25A	63000093*	FUSE 25 AMP 250 VOLT*	2
12	TI1&2	EAST1030*	TIMER-220VAC 5A DPDT TON*	2
13	J10P	ESC00552	JUMPERS 10 POLE	1
14	R3PDT	ESC00520	RELAY-3PDT 240VAC	1
15	FB30A	ETC00125	FUSE BLOCK 30 AMP 250VOLT	1
16	GL	ETC00203	GROUND LUGS ILSCO 14-6	1
17	SW1	ETC00309	SWITCH POWER ON/OFF	1
18	SW1FP	ETC00310	SWITCH ON-OFF FACE PLATE	1
19	TC1&2&3	EAST0494*	TEMPERATURE CONTROL FOR SEAL BARS*	3
20	ZDNI	EAST0761-1	CABLE CLAMP	1
21	PHPP	EAST0761	PLUG FOR HOLE PUNCH	1
22	PHPR	EAST0760	RECEPTACLE FOR HOLE PUNCH	1
23	PC1	ESC00563	POWER CORD 18-3 SO CORD	15 FT
24	PC2	EP000559	POWER CORD 18-4 SO CORD	9 FT

\* One each of items marked with an asterisk (\*) are included in spare parts kit SUBK100-2070, SUBK100-2080, SUBK100-20100, SUBK100-3070, SUBK100-3080, SUBK100-30100, SUBK100-4070, SUBK100-4080, SUBK100-5070, SUBK100-5080 or SUBK100-50100. Specify sealer nominal maximum seal size (EM model number) and electrical power requirements (-V number) when ordering.

#### ELECTRICAL BOARD FOR EM3040-TKV1 – SUBA0009

ITEM	DESIGNATOR	PART NUMBER	DESCRIPTION	QUANTITY
1	SWL	EAST0029*	SWITCH LIMIT MICRO*	2
2	RS3PDT10A	EAST0034	SOCKET-RELAY 3PDT 10A	1
3	BR	EAST0038	BRIDGE RECTIFIER	1
4	TS5	EAST0081	TERMINAL STRIP 5 PLACE	1
5	BEB	EAST0088	ELECTRICAL BOARD	1
6	TS10	EAST0185	TERMINAL STRIP 10 PLACE	1
7	WWDC	EAST0361	WIREWAY DUCT & COVER	4 FT
8	CT30A	EAST0421	CONTACTOR-30 AMP 220VAC 2POLE	1
9	RSS	EAST0495	RELAY-SOLID STATE HOT KNIFE	2
10	TMP	EAST0663	TRANSFORMER MAGNET PRESSURE	1
11	F20A	EAST1009*	FUSE 20 AMP 250 VOLT*	2
12	TI1&2	EAST1030*	TIMER-220VAC 5A DPDT TON*	2
13	J10P	ESC00552	JUMPERS 10 POLE	0.5
14	RDPDT	ET820016	RELAY-DPDT 240 V COIL 10A	1

ITEM	DESIGNATOR	PART NUMBER	DESCRIPTION	QUANTITY
15	FB30A	ETC00125	FUSE BLOCK 30 AMP 250VOLT	1
16	GL	ETC00203	GROUND LUGS ILSCO 14-6	1
17	SW1	ETC00309	SWITCH POWER ON/OFF	1
	RSC	EAST0032A	RELAY SPRING CLIP (POTTER)	1
	WKPC	EAST6000	KIT-PRE-CUT WIRES FOR BOARDS	1

\* One each of items marked with an asterisk (\*) are included in spare parts kit SUBK100-3040. Specify electrical power requirements (-V number) when ordering.

### ELECTRICAL BOARD FOR EM3050-TKV1 – SUBA1072

ITEM	DESIGNATOR	PART NUMBER	DESCRIPTION	QUANTITY
1	SWL	EAST0029*	SWITCH LIMIT MICRO*	2
2	RS3PDT10A	EAST0034	SOCKET-RELAY 3PDT 10A	1
3	BR	EAST0038	BRIDGE RECTIFIER	1
4	TS5	EAST0081	TERMINAL STRIP 5 PLACE	1
5	BEB	EAST0088	ELECTRICAL BOARD	1
6	TS10	EAST0185	TERMINAL STRIP 10 PLACE	1
7	WWDC	EAST0361	WIREWAY DUCT & COVER	4
8	CT30A2P	EAST0421	CONTACTOR-30 AMP 220VAC 2POLE	1
9	RSS	EAST0495	RELAY-SOLID STATE HOT KNIFE	2
10	TMP	EAST0663	TRANSFORMER MAGNET PRESSURE	1
11	F20A	EAST1009*	FUSE 20 AMP 250 VOLT*	2
12	TI1&2	EAST1030*	TIMER-220VAC 5A DPDT TON*	2
13	J10P	ESC00552	JUMPERS 10 POLE	0.5
14	RDPDT	ET820016	RELAY-DPDT 240 V COIL 10A	1
15	FB30A	ETC00125	FUSE BLOCK 30 AMP 250VOLT	1
16	GL	ETC00203	GROUND LUGS ILSCO 14-6	1
17	SW1	ETC00309	SWITCH POWER ON/OFF	1
	WKPC	EAST6000	KIT-PRE-CUT WIRES FOR BOARDS	1

\* One each of items marked with an asterisk (\*) are included in spare parts kit SUBK100-3050. Specify electrical power requirements (-V number) when ordering.

## ELECTRICAL BOARD FOR EM4040-TKV1 – SUBA0224

ITEM	DESIGNATOR	PART NUMBER	DESCRIPTION	QUANTITY
1	SWL	EAST0029*	SWITCH LIMIT MICRO*	2
2	RS3PDT10A	EAST0034	SOCKET-RELAY 3PDT 10A	1
3	BR	EAST0038	BRIDGE RECTIFIER	1
4	TS5	EAST0081	TERMINAL STRIP 5 PLACE	1
5	BEB	EAST0088	ELECTRICAL BOARD	1
6	TS10	EAST0185	TERMINAL STRIP 10 PLACE	1
7	WWDC	EAST0361	WIREWAY DUCT & COVER	4
8	CT30A3P	EAST0421	CONTACTOR-30 AMP 220VAC 2POLE	1
9	RSS	EAST0495	RELAY-SOLID STATE HOT KNIFE	2
10	TMP	EAST0663	TRANSFORMER MAGNET PRESSURE	1
11	F20A	EAST1009*	FUSE 20 AMP 250 VOLT*	2
12	TI1&2	EAST1030*	TIMER-220VAC 5A DPDT TON*	2
13	J10P	ESC00552	JUMPERS 10 POLE	1
14	RDPDT10A	ET820016	RELAY-DPDT 240 V COIL 10A	1
15	FB	ETC00125	FUSE BLOCK 30 AMP 250VOLT	1
16	G	ETC00203	GROUND LUGS ILSCO 14-6	1
17	SW1	ETC00309	SWITCH POWER ON/OFF	1
	WKPC	EAST6000	KIT-PRE-CUT WIRES FOR BOARDS	1

\* One each of items marked with an asterisk (\*) are included in spare parts kit SUBK100-4040. Specify electrical power requirements (-V number) when ordering.

## ELECTRICAL BOARD FOR EM40100-TKV1 – SUBA1078

ITEM	DESIGNATOR	PART NUMBER	DESCRIPTION	QUANTITY
1	SWL	EAST0029*	SWITCH LIMIT MICRO*	2
2	RS3PDT10A	EAST0034	SOCKET-RELAY 3PDT 10A	6
3	BR	EAST0038	BRIDGE RECTIFIER	1
4	EE5H	EAST0533-1	ENCLOSURE WITH 5HOLE DOOR	1
5	IPS70	EAST0534	INNER PANEL FOR SEALER-70	1
6	TS10	EAST0185	TERMINAL STRIP 10 PLACE	4
7	WWD	TC000523	WIREWAY DUCT 1 1/2" X 1 1/2"	5 FT
	WWC	TC000524	WIREWAY COVER 1 1/2"	1.6 FT
8	ZWKPC	EAST0421	CONTACTOR-30 AMP 220VAC 2POLE	1
9	RSS	EAST0495	RELAY-SOLID STATE HOT KNIFE	3
	RSC	EAST0032A	RELAY SPRING CLIP (POTTER)	6
10	TMP	EAST0663	TRANSFORMER MAGNET PRESSURE	1

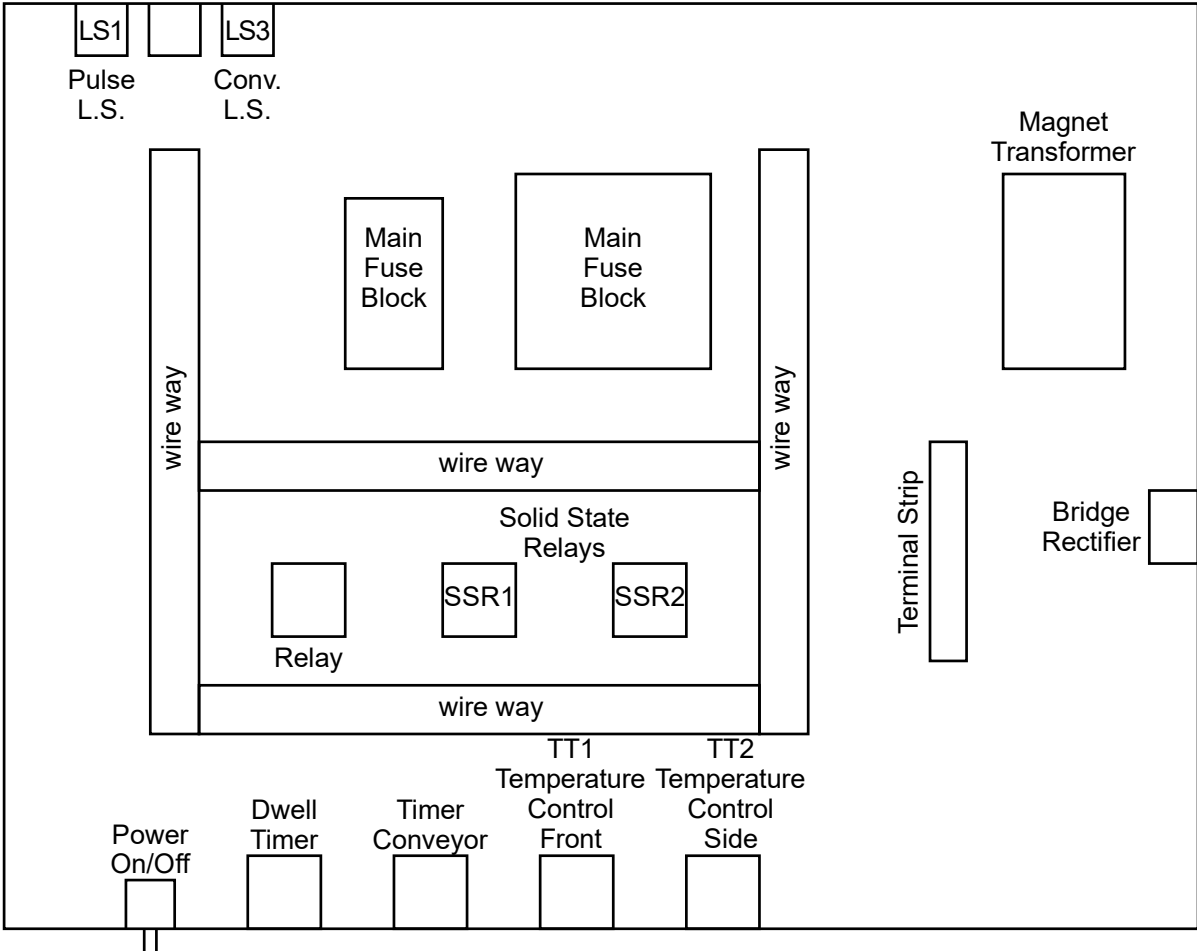
ITEM	DESIGNATOR	PART NUMBER	DESCRIPTION	QUANTITY
11	F25A	63000093*	FUSE 25 AMP 250 VOLT*	2
12	TI1&2	EAST1030*	TIMER-220VAC 5A DPDT TON*	4
13	J10P	ESC00552	JUMPERS 10 POLE	3
14	R3PDT	ESC00520	RELAY-3PDT 240VAC	1
15	FB30A	ETC00125	FUSE BLOCK 30 AMP 250VOLT	1
16	GL	ETC00203	GROUND LUGS ILSCO 14-6	1
17	SW1	ETC00309	SWITCH POWER ON/OFF	1
18	SW1FP	ETC00310	SWITCH ON-OFF FACE PLATE	1
19	TC1&2&3	EAST0494*	TEMPERATURE CONTROL FOR SEAL HEAD*	3
21	PHPP	EAST0761	PLUG FOR HOLE PUNCH	2
22	PHPR	EAST0760	RECEPTACLE FOR HOLE PUNCH	2
23	PC1	ESC00563	POWER CORD 18-3 SO CORD	29.9 FT

\* One each of items marked with an asterisk (\*) are included in spare parts kit SUBK100-40100. Specify electrical power requirements (-V number) when ordering.

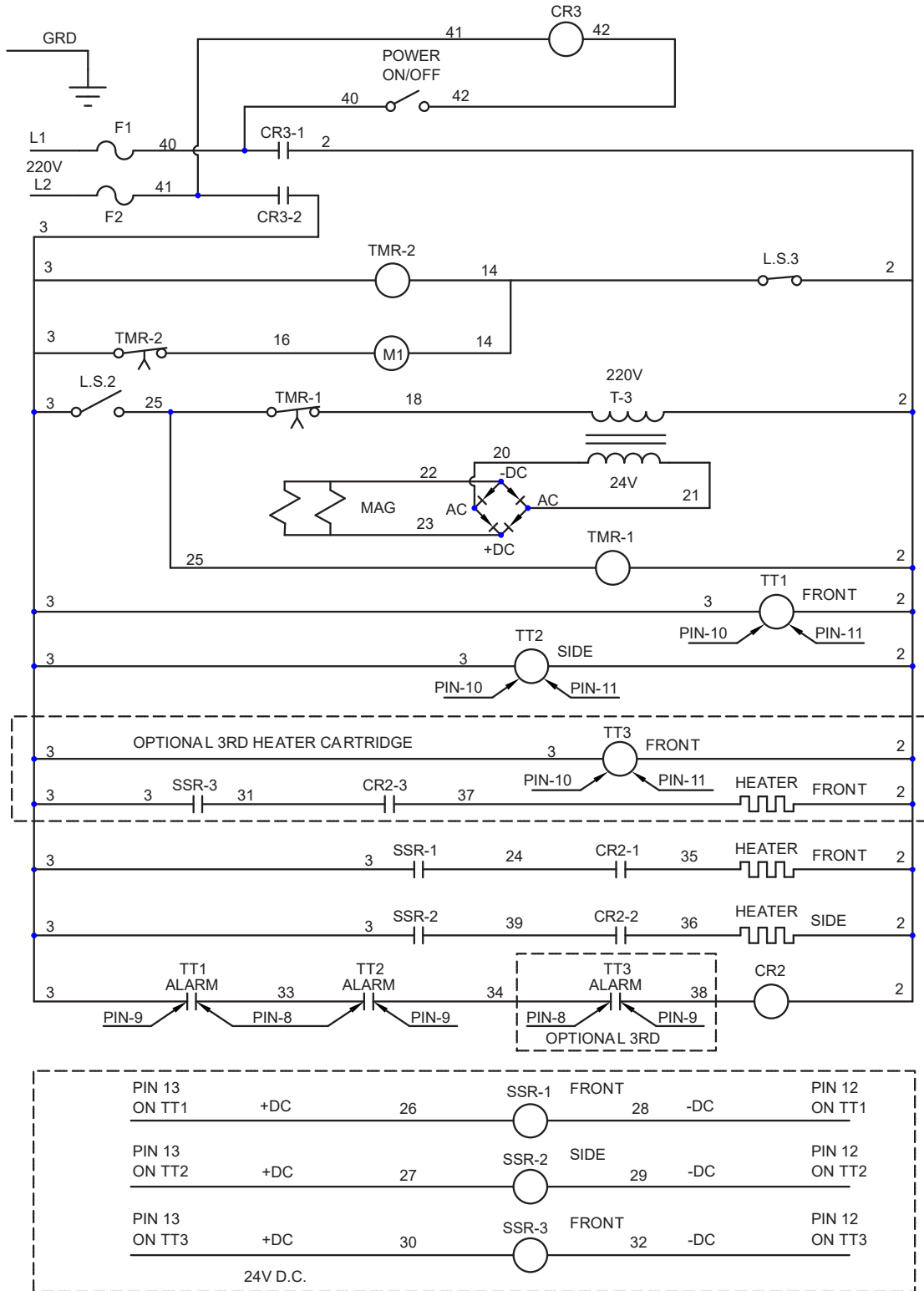


# Appendix A: Electrical Schematics

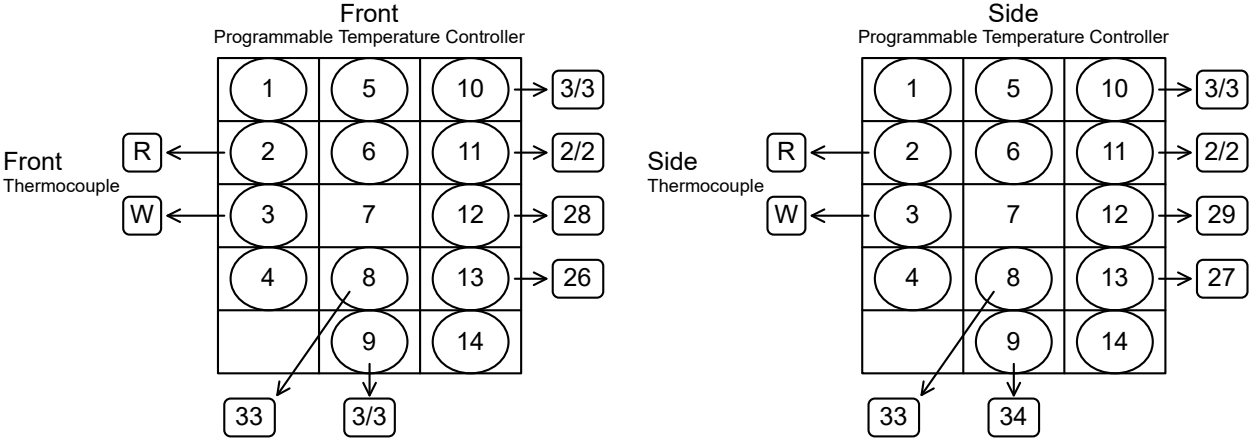
## Panel Layout



# Electrical Schematic



# Programmable Temperature Controller Connections



## **Appendix B: Temperature Setting Specifications for Shrink-Wrap Plastics**

### **Mushroom Insert**

PVC (Poly-Vinyl Chloride)	Temperature settings: Pad type: Dwell Time:	325° F front bar; 325° F side bar Felt Approximately 1 second
Polyolefin	Temperature settings: Pad type: Dwell Time:	335° F front bar; 335° F side bar Sponge rubber Approximately 1 second
Polyethylene	Temperature settings: Pad type: Dwell Time:	360° F front bar; 360° F side bar Sponge rubber Approximately 1.5 second

# Appendix C: L-Sealer Size Estimating

## L-Sealer Center-Folded Film Size Estimating Table

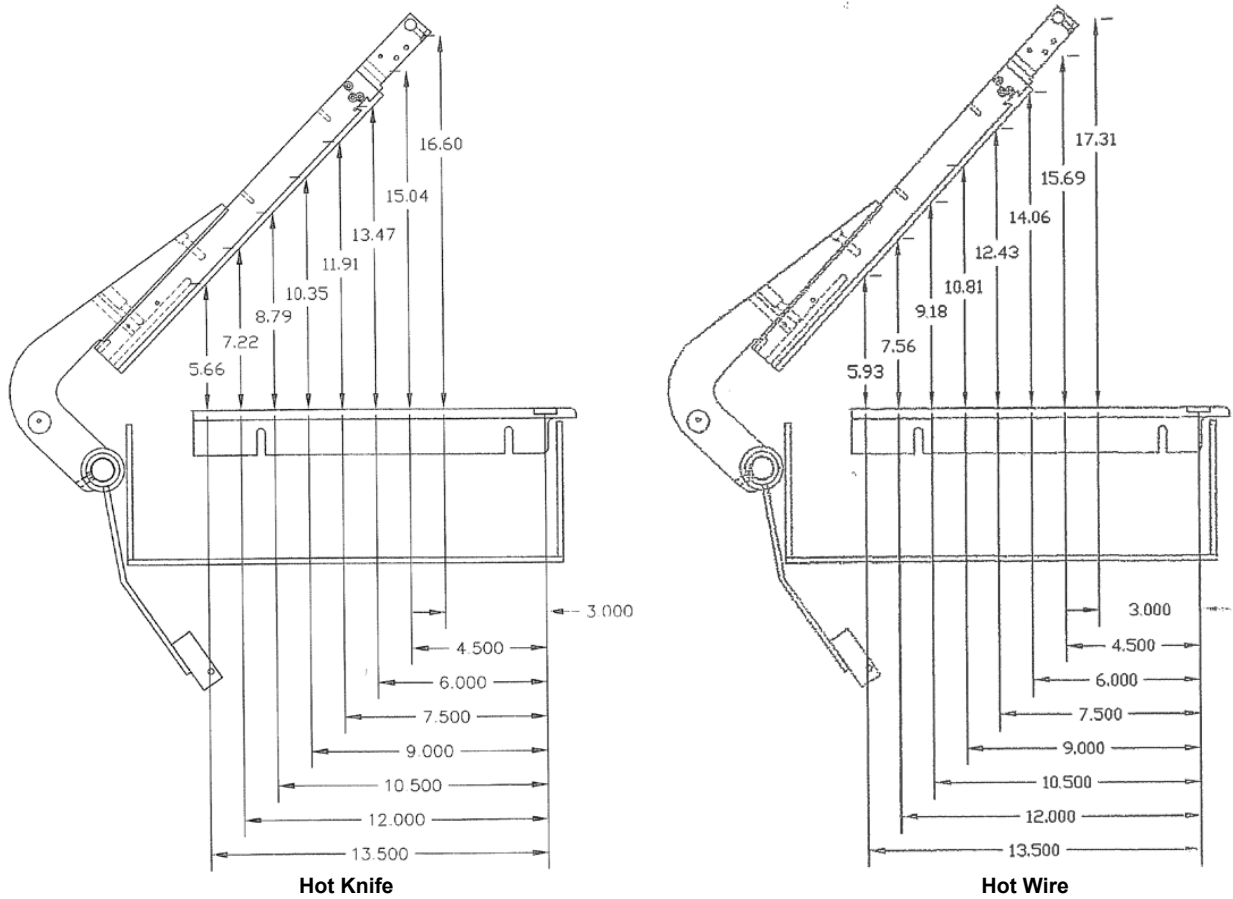
Package Height	*** Roll Width Sizes																												Maximum Film Widths:				
	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	Econo L-Sealers	- 19"															
8"	Are Rounded																												Econo L-Sealers	- 19"			
7.5"	Up To The Next																												20" Wide L-Sealers	- 24"			
7"	Inch Where																												30" Wide L-Sealers	- 34"			
6.5"	Necessary																												40" Wide L-Sealers	- 44"			
6"	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34													
5.5"	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34													
5"	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34											
4.5"	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34										
4"	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34									
3.5"	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34								
3"	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34							
2.5"	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34						
2"	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34				
1.5"	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34				
1"	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33				
	0	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30		

To calculate estimated per-package cost for manual and semi-automatic L-sealers, use the following formulas.

- 1) Center-Folded film – width of roll of film =
- 2) Cutoff Film length – film going across front seal bar =
- 3) Film usage – to calculate the amount of film used per package =
- 4) Per package cost

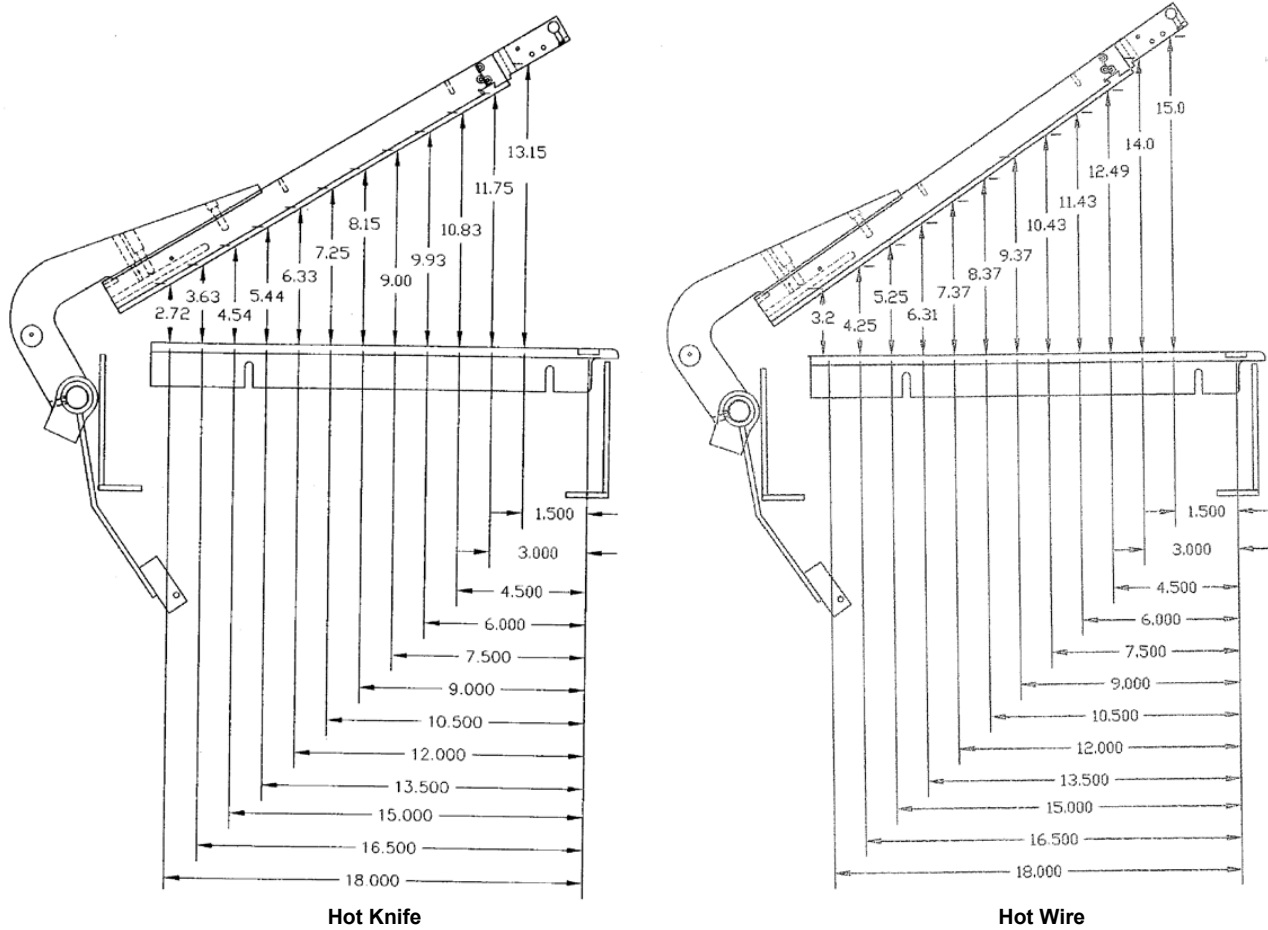
## 16-inch Side Seal Package Size Estimation

The following Eastey side seal bar size dimensions are provided to make sure your product will fit under the side seal bar. You will need to know your product height and width to use these figures effectively.



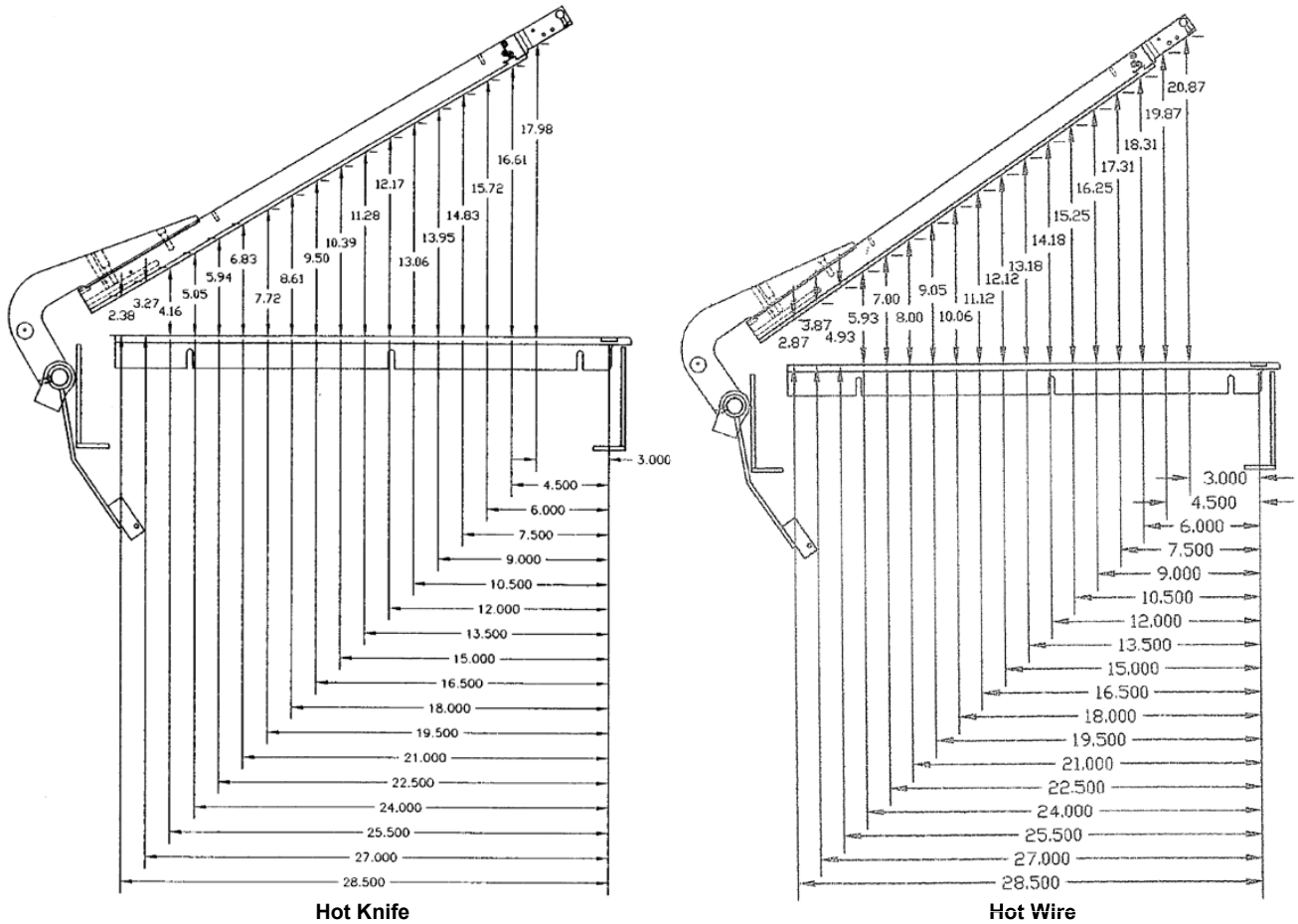
## 20-inch Side Seal Package Size Estimation

The following Eastey side seal bar size dimensions are provided to make sure your product will fit under the side seal bar. You will need to know your product height and width to use these figures effectively.



### 30-inch Side Seal Package Size Estimation

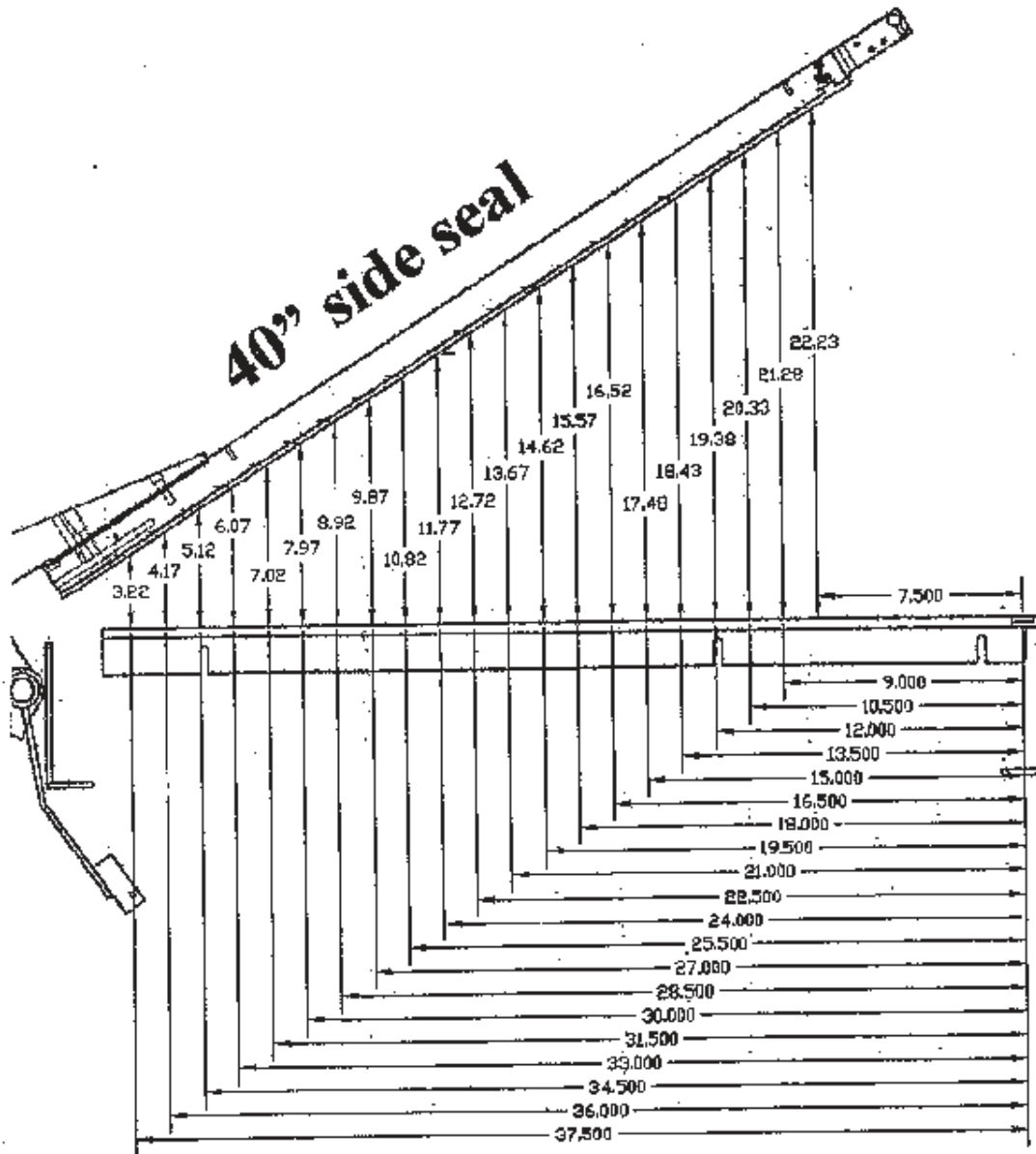
The following Eastey side seal bar size dimensions are provided to make sure your product will fit under the side seal bar. You will need to know your product height and width to use these figures effectively.





## 40-inch Side Seal Package Size Estimation

The following Eastey side seal bar size dimensions are provided to make sure your product will fit under the side seal bar. You will need to know your product height and width to use these figures effectively.



# Warranty Statement

## EM Professional Series Semi-Automatic L-Sealers

### Warranty Statement

Easteey warrants that all of the products it ships will be in good working order and free from defects in material and workmanship for a period of two (2) years from the date of shipment by Easteey and conforms to published specifications for that model.

### The following items are covered for a period of two (2) years

Structural components including machine metal frames, enclosures, and sheet-metal paneling

### The following items are covered for a period of one (1) year

Drive motor(s)	1 year
Wear rails	1 year
Caster wheels	1 year
Drive sprockets	1 year
Rollers (idler)	1 year

### The following items are covered for 90 days

All electrical components	90 days
Wiring	90 days
Printed circuit cards	90 days
Temperature controllers	90 days
Head return cylinders	90 days

### The following items are covered for 30 days

Curtains	30 days
----------	---------

### The following items are considered normal wear parts / consumables and are not covered under warranty

- Fuses
- Belts
- Hot knife cutting rules
- Inserts
- PTFE tape / coating
- UHMW components
- Sponge rubber pads
- Heat sinks

**Any of the following VOID ALL WARRANTIES**

- Non-OEM parts
- Abuse and / or neglect
- Inadequate maintenance
- Incorrect electrical / wire hookups
- Equipment used outdoors or in extremely corrosive or dirty environments
- Improper belt tracking or alignment
- Improper shutdown or start-ups

**Sealing Quality**

Sealing quality achieved in a given application is dependent on the installation, the material handling, and the maintenance provided. Eastey makes no warranty that the sealing quality achieved in an application will be the same as that achieved on a test piece in our demo facility.

**Shipping Policy**

Customer pays all incoming shipping. If the item is defective and under warranty, Eastey pays return shipping charges for least costly method. If expedited shipping is desired, customer must furnish his shipping account and shipping fees will be charged to that account.

**Warranty Verification**

If you conclude that a product may be defective and may be covered by warranty, obtain a Return Material Authorization number by calling our technical support number (toll free at 1-800-835-9344, or 763-428-4846 or Fax: 763-795-8867 or e-mail: info@eastey.com). Once an RMA number has been obtained, return the defective item to Eastey. Eastey will analyze the product and, if found to be defective, we will, at our option, replace or repair the item. If the item is found to not be eligible for warranty, you will be notified and may decide on disposition. Defective products will be replaced or repaired as promptly as possible.

**Warranty Eligibility**

The warranty provided by Eastey is only to the original buyer.

**Limited Warranty**

THE ABOVE WARRANTY IS EXCLUSIVE AND IN LIEU OF ALL OTHER WARRANTIES, WHETHER EXPRESSED OR IMPLIED, INCLUDING THE IMPLIED WARRANTIES OF MERCHANTABILITY, FITNESS FOR A PARTICULAR PURPOSE AND NONINFRINGEMENT.

**Disclaimer of Damages**

REGARDLESS OF WHETHER ANY REMEDY SET FORTH HEREIN FAILS OF ITS ESSENTIAL PURPOSE, IN NO EVENT WILL EASTEY BE LIABLE FOR ANY SPECIAL, CONSEQUENTIAL, INDIRECT OR SIMILAR DAMAGES, INCLUDING LOST PROFIT OR LOST OPPORTUNITIES OF ANY TYPE ARISING OUT OF THE USE OR INABILITY TO USE THESE PRODUCTS EVEN IF EASTEY HAS BEEN ADVISED OF THE POSSIBILITY OF SUCH DAMAGES.

# Customer Support

## Eastey Technical Service

For help setting up or operating the EM Professional Series L-Sealer, please contact Eastey Technical Service at one of the numbers listed below.

Toll-Free Phone	800-835-9344
Phone	763-428-4846
Fax	763-795-8867
E-mail	<a href="mailto:info@eastey.com">info@eastey.com</a>
Web	<a href="http://www.eastey.com">www.eastey.com</a>

Thank you again for your purchase of Eastey products. We are pleased to be a part of your packaging needs.



***EASTEY***®