



SERIES 800PM
POWERED MANUAL HORIZONTAL WINDER STRETCH
WRAP SYSTEM WITH VARIABLE TENSION



Shown with optional powered belt conveyors

OPERATORS
MANUAL

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Introduction

Congratulations! Your purchase of a Kalamazoo Series 800 Horizontal Winder Stretch Wrap System will provide you with years of efficient stretch wrapping service. Your investment will ensure that your products will arrive cleaner, with less damage and pilferage at their destination at a lower cost to you.

Kalamazoo Packaging Systems products carry a LIMITED LIFETIME WARRANTY on all K.P.S. manufactured components; all parts not manufactured by Kalamazoo Packaging Systems will be subject to the original manufacturer's warranty.

Warranty

Kalamazoo Packaging systems, Inc. (KPS) agrees to furnish the purchaser, without charge, F.O.B. the factory, any part found to be defective in either material or workmanship within one (1) year from date of shipment, provided the purchaser gives immediate notice of any defect and description of that defect to KPS. KPS reserves the right to inspect any defective part to verify the defect and to determine probable cause of same.

The liability of KPS under this warranty is limited to furnishing replacements for defective parts, and unless otherwise agreed to in writing, the purchaser shall bear the expense of installation.

Failure of equipment or parts due to abuse, misuse, neglect, incorrect operating techniques or power line drops or surges shall not constitute failure because of defective material or workmanship, and are expressly excluded from this warranty.

The above is the only warranty with no other guarantees which extend beyond the above and the seller disclaims any implications including but not limited to a warranty of merchantability.

Assembly

Your Horizontal Winder has been assembled and tested at our manufacturing plant and released for shipment by a qualified technician. If the unit was shipped via common carrier or by our truck it may not be crated. **Any damage done in transit should be reported to the carrier immediately.** All our shipments are sent F.O.B. Grand Rapids, Michigan, therefore; the customer is responsible to settle any damage claims with the transportation company. Kalamazoo Packaging Systems will do everything possible to assist you in these matters.

The machine and conveyors must be leveled and plumbed. Then they can be lagged to the floor. All powered conveyors must be wired into the junction boxes. Wire in the main power cord of the unit into a 230/1-3/60 see wiring diagram.

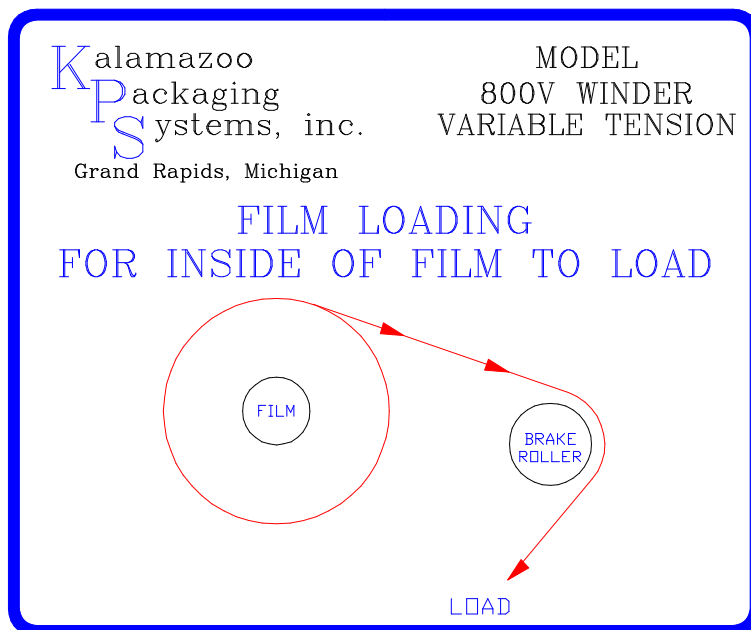
Air Source may be needed. If so use 80 P.S.I.

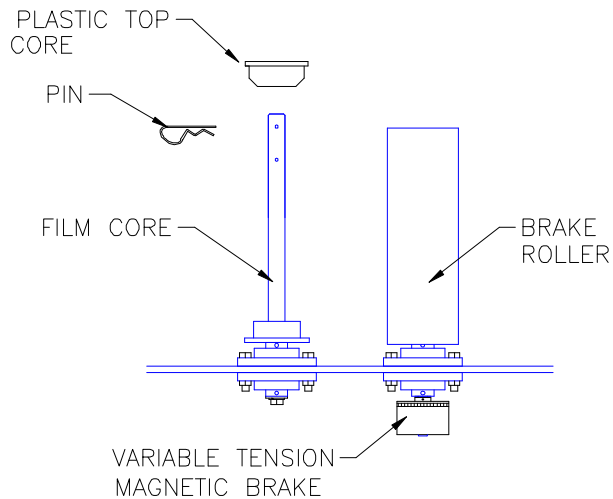
NOTE: The use of an extension cord may reduce the efficiency and life of the machine and is not recommended.

The System is now ready for operation.

Loading Film

Your wrapper is equipped with a Kalamazoo Variable Tension Film Delivery System. Place a roll of 10-12" or 20" stretch film on the film core holder and thread the film as shown on the diagram below. Once the film is loaded and the desire film tension is arrived at the film tension need not be adjusted again until the brand of film or the film thickness is changed.





FILM LOADING AND TENSIONING

Place a roll of 10-12" or 20" film onto the film holder so the film unwinds clockwise, than slide the plastic top core into place and install the pin into the hole.

(note: The film film core does not change the film tension.)

Thread the film as shown on the diagram.

Adjust the variable tension magnetic brake to the film tension you desire. Loosen the two set screws in the brake with a 5/64" allen wrench adjust the tension and retighten the set screws.

OPERATING CONTROLS

- 1 **Foot switch Control or selector switch.**
- 2 **Potentiometer to adjust ring speed.**

OPERATING INSTRUCTIONS

- 1 Place the product onto the infeed conveyor and/or table.
- 2 Slide Product into the winder.
(Once the product is loaded into the winder and the film is secure)
- 3 Push down on the FOOT SWITCH or turn the WINDER selector switch to ON.
- 4 Push the product thought the winder or turn ON the conveyors.
(Once the product has been completely wrapped with the proper overlap.)
- 4 Cut and secure the film.
- 5 Push the product out of the wider or turn on the "CONV. UNLOAD" button.
- 6 End of wrap cycle.

GENERAL MAINTENANCE

Warning!!

MAKE SURE THAT POWER SUPPLY IS DISCONNECTED BEFORE ATTEMPTING TO SERVICE ANY COMPONENTS. IF THE POWER DISCONNECT IS OUT OF SIGHT, LOCK IT IN THE OPEN POSITION AND TAG IT TO PREVENT UNEXPECTED APPLICATION OF POWER.

Cleaning

Periodically clean dirt accumulations from machine, especially around moving parts and drive components, preferably by vacuuming.

General

- Check and tighten any loose fasteners.
- check all electric connections and replace any worn or frayed cords.
- Check all fuses and DC controllers.

Lubrication

Bearings

- The bearings have been greased at the factory and are ready to run. It is recommended that all mounted bearings and support wheels be relubricated with #3 lithium base grease every three months.

Chains

- Clean, lubricate and adjust chains every month. Chain should be lubricated with a penetrating type commercial chain lube.

Gear Reducers

- For new reducers, change the oil 120 hours after the reducer starts operating (based on 8 hours per day of operation). After the first oil change, change oil every 2000 operating hours, or every six months, whichever occurs first.

Temperature	Lubricant
25° - 125° F	AGMA #8
15° - 60° F	AGMA #7

Certain conditions (dust, water, etc.) may require a change of lubricating periods as dictated by experience.

adjustments

Wrap Start Soft-Start Acceleration - Adjust the "Accel" trim pot on the wrap motor controller card with an insulated screwdriver. Clockwise to increase acceleration time (soft-start).

TOUBLESHOOTING

When any problem develops, review the operating instructions. Diagnose specific problems and review the options below.

Machine not running at all.

1. Check wall receptacle for power.
2. Check power cord for cut. (Fork Lift Trucks damage cords.)
3. Check all fuses.
4. Check AC drive for faults.
5. Check all limit switches for damage, sticking or internal shorts.
6. Open cabinet and check that all relays are firmly seated in their bases.
7. Visually inspect for loose wires and for any signs of arcing or burning of any of the components.
8. The film door must be shut before the winder will run.
9. Winder ring noises use taping wax around ring edge.
10. It is advisable to call for technical assistance at this time. (616) 534-2600.

Technical and Customer Service is available from Kalamazoo Packaging Systems, Inc., Monday thru Friday 7:30 A.M. to 4:00 P.M. (EST). Stock is maintained on parts to allow us to ship the same day on most orders.

If you have a problem, we want to know about it! Please call and report any difficulties you may encounter.

- **Local - (616) 534-2600**
- **National - (800) 253-4625**

AUTOMATION DIRECT GS-1 AC DRIVE PROGRAMMING

To change a parameter in the GS-1 or 2 AC Drive.

1. Press the PROG/ENTER key.
0- will appear.
2. Use the up/down arrow key to navigate through the 10 different parameter groups.
3. Press the PROG/ENTER key.
0-00 will appear.
4. Press the PROG/ENTER key.
230 will appear. This parameter is 0-00, 230 motor voltage.

If you would like to change the ACCELERATION TIME for the WINDER RING.
(Factory set at 5.0)

1. Press the PROG/ENTER key.
0- will appear.
2. Press the up arrow key until you get to 1-
3. Press the PROG/ENTER key
1-00 will appear.
4. Press the up arrow key until you get to 1-01
5. Press the PROG/ENTER key.
5.0 will appear Factory setting
6. Use the up or down arrow key to make changes.
7. After you have made the changes press the PROG/ENTER key.
8. The display will read END.
9. Press the DISPL/RESET until it reads H 0.0
10. Programming change is complete.

830PM- WINDER RING GS1 AC DRIVE

New AC drives only: Before changing parameter reset the drive to factory defaults (9-08 = 99)

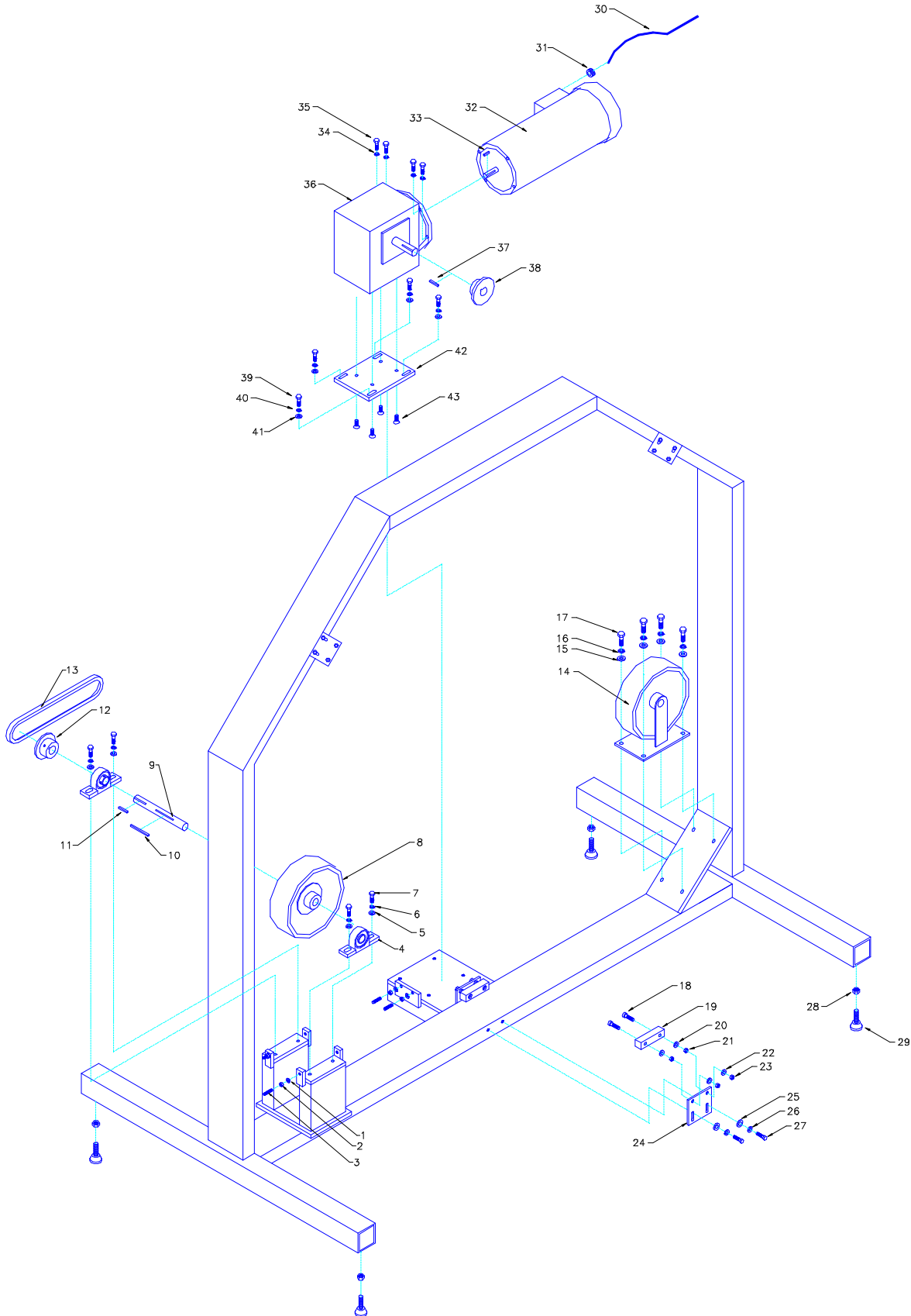
0-00	240	DEFAULT	MOTOR VOLTAGE
0-01	7.0	CHANGE	MOTOR AMP
0-02	60	DEFAULT	MOTOR FREQUENCY
0-03	1750	DEFAULT	MOTOR RPM
0-04	1750	DEFAULT	MOTOR MAX. FREG.
1-00	0	DEFAULT	RAMP TO STOP
1-01	5.0	CHANGE	ACCE. TIME 1
1-02	5.0	CHANGE	DEC. TIME 1
1-03	0	DEFAULT	ACCE. S-CURVE
1-04	0	DEFAULT	DEC. S-CURVE
1-05	10.0	DEFAULT	ACCE. TIME 2
1-06	30.0	DEFAULT	DEC. TIME 2
1-07	0	DEFAULT	METHOD TO USE
1-08	0.0	DEFAULT	ACCE 1-2 FREG.
1-09	0.0	DEFAULT	DEC 1-2 FREG.
1-10	0.0	DEFAULT	SKIP FREG.1
1-11	0.0	DEFAULT	SKIP FREG. 2
1-12	0.0	DEFAULT	SKIP FREG. 3
1-17	0.0	DEFAULT	SKIP FREG. BAND
1-19	0	DEFAULT	DC INJECTION LENEL
1-20	0.0	DEFAULT	DC INJECTION START-UP
1-21	0.0	DEFAULT	DC INJECTION STOPPING
1-22	0.0	DEFAULT	START PIONT DC INJECTION
2-00	0	DEFAULT	GENERAL PURPOSE
2-01	0.0	DEFAULT	SLIP COMP.
2-03	8	DEFAULT	MANUAL TORQUE BOOST
2-04	1.5	DEFAULT	MID-PIONT FREG.
2-05	10.0	DEFAULT	MID-PIONT VOLT
2-06	1.5	DEFAULT	MIN. OUTPUT FREG.
2-07	10.0	DEFAULT	MIN. OUTPUT VOLT
2-08	10	DEFAULT	PW/M CARRIER FREG.
3-00	2	CHANGE	EXTERNAL CONTROL TERMINALS,STOP DISABLED
3-01	0	DEFAULT	DI1-FWD./STOP DI2-REV/STOP
3-02	0	DEFAULT	MULTI-SPEED BIT 2
3-03	3	DEFAULT	MULTI SPEED BIT1
3-11	0	DEFAULT	AC DRIVE RUNNING
3-16	0.0	DEFAULT	DESIRED FREG.
3-17	0.0	DEFAULT	DESIRED CURRENT
4-00	2	CHANGE	EXTURNAL POT.
4-01	0	DEFAULT	NO OFFSET
4-02	0.0	DEFAULT	ANALOG INPUT OFFSET
4-03	100.0	DEFAULT	ANALOG INPUT GAIN
4-04	0	DEFAULT	ANALOG INPUT REV.
4-05	0	DEFAULT	LOSS OF ACI
5-00	6.0	DEFAULT	JOG
5-01	0.0	DEFAULT	MULITI SPEED 1
5-02	0.0	DEFAULT	MULTI SPEED 1
5-03	0.0	DEFAULT	MULTI SPEED 2
6-00			
THUR			
9-42		DEFAULT	

850PM- WINDER RING GS1 AC DRIVE

New AC drives only: Before changing parameter reset the drive to factory defaults (9-08 = 99)

0-00	240	DEFAULT	MOTOR VOLTAGE
0-01	7.0	CHANGE	MOTOR AMP
0-02	60	DEFAULT	MOTOR FREQUENCY
0-03	1750	DEFAULT	MOTOR RPM
0-04	1750	DEFAULT	MOTOR MAX. FREG.
1-00	0	DEFAULT	RAMP TO STOP
1-01	5.0	CHANGE	ACCE. TIME 1
1-02	5.0	CHANGE	DEC. TIME 1
1-03	0	DEFAULT	ACCE. S-CURVE
1-04	0	DEFAULT	DEC. S-CURVE
1-05	10.0	DEFAULT	ACCE. TIME 2
1-06	30.0	DEFAULT	DEC. TIME 2
1-07	0	DEFAULT	METHOD TO USE
1-08	0.0	DEFAULT	ACCE 1-2 FREG.
1-09	0.0	DEFAULT	DEC 1-2 FREG.
1-10	0.0	DEFAULT	SKIP FREG.1
1-11	0.0	DEFAULT	SKIP FREG. 2
1-12	0.0	DEFAULT	SKIP FREG. 3
1-17	0.0	DEFAULT	SKIP FREG. BAND
1-19	0	DEFAULT	DC INJECTION LENEL
1-20	0.0	DEFAULT	DC INJECTION START-UP
1-21	0.0	DEFAULT	DC INJECTION STOPPING
1-22	0.0	DEFAULT	START PIONT DC INJECTION
2-00	0	DEFAULT	GENERAL PURPOSE
2-01	0.0	DEFAULT	SLIP COMP.
2-03	8	DEFAULT	MANUAL TORQUE BOOST
2-04	1.5	DEFAULT	MID-PIONT FREG.
2-05	10.0	DEFAULT	MID-PIONT VOLT
2-06	1.5	DEFAULT	MIN. OUTPUT FREG.
2-07	10.0	DEFAULT	MIN. OUTPUT VOLT
2-08	10	DEFAULT	PW/M CARRIER FREG.
3-00	2	CHANGE	EXTERNAL CONTROL TERMINALS,STOP DISABLED
3-01	0	DEFAULT	DI1-FWD./STOP DI2-REV/STOP
3-02	0	DEFAULT	MULTI-SPEED BIT 2
3-03	3	DEFAULT	MULTI SPEED BIT1
3-11	0	DEFAULT	AC DRIVE RUNNING
3-16	0.0	DEFAULT	DESIRED FREG.
3-17	0.0	DEFAULT	DESIRED CURRENT
4-00	2	CHANGE	EXTURNAL POT.
4-01	0	DEFAULT	NO OFFSET
4-02	0.0	DEFAULT	ANALOG INPUT OFFSET
4-03	100.0	DEFAULT	ANALOG INPUT GAIN
4-04	0	DEFAULT	ANALOG INPUT REV.
4-05	0	DEFAULT	LOSS OF ACI
5-00	6.0	DEFAULT	JOG
5-01	0.0	DEFAULT	MULITI SPEED 1
5-02	0.0	DEFAULT	MULTI SPEED 1
5-03	0.0	DEFAULT	MULTI SPEED 2
6-00			
THUR			
9-42		DEFAULT	

MODEL 800PMV WINDER BASE



PARTS MANUAL: 800V HORIZONTAL WINDER

ITEM	PART #	GRAINGER #	DESCRIPTION	QTY
1	L48		5/16 USS WASHER	4
2	L47		5/16 LOCK WASHER	4
3	L54		5/16-18x 1-1/2" SET SCREW	4
4	121250	5X692	1" PILLOW BLOCK BEARING	2
5	L65		3/8 USS WASHER	4
6	L64		3/8 LOCK WASHER	4
7	L83		3/8-16x 1-1/2" HEX HEAD CAP SCREW	4
8	122809		10"x 3" DRIVE WHEEL w/ HUB	1
9	800V-DS		800V DRIVE SHAFT	1
10	L3		1/4"x 1/4"x 2-1/2" KEYWAY	1
11	L3		1/4"x 1/4"x 1" KEYWAY	1
12	SEE CHART		800 DRIVEN SPROCKET	1
13	108500	6L074	# 50 CHAIN	1
14	122800		10"x 3" IDLER WHEEL w/ TAPERED BEARINGS	1
15	L96		7/16 USS WASHER	4
16	L95		7/16 LOCK WASHER	4
17	L99		7/16-14 x 1-1/2" HEX HEAD CAP SCREW	4
18	L73		3/8-24 x 1-1/2" ALLEN HEAD CAP SCREW	16
19	250100		800 SLIDE	8
20	L48		5/16 USS WASHER	16
21	L61		3/8-24 NYLOCK JAM NUT	16
22	L48		5/16 USS WASHER	16
23	L61		3/8-24 NYLOCK JAM NUT	16
24	800S-HOLDER		800 SLIDE HOLDER	8
25	L65		3/8 USS WASHER	16

PARTS MANUAL: 800V HORIZONTAL WINDER

ITEM	PART #	GRAINGER #	DESCRIPTION	QTY
26	L64		3/8 LOCK WASHER	16
27	L71		3/8-24x 1-1/4" HEX HEAD CAP SCREW	12
28	L125		1/2-13 NUT	4
29	122851		1/2-13 RUBBER FEET	4
30	209905		14/4 STO CORD	1
31	210340	2A247	CORD GRIP	1
32	SEE CHART		800 WINDER MOTOR DC	1
33	L2		3/16"x 3/16"x 3/4" KEYWAY	1
34	L64		3/8 LOCK WASHER	4
35	L80		3/8-16 x 1" HEX HEAD CAP SCREW	4
36	SEE CHART		800 WINDER R/A REDUCER	1
37	L3		1/4"x 1/4"x 1" KEYWAY	1
38	SEE CHART		800 DRIVE SPROCKET	1
39	L82		3/8-16 x 1-1/2" HEX HEAD CAP SCREW	4
40	L64		3/8 LOCK WASHER	4
41	L65		3/8 USS WASHER	4
42	SEE CHART		800 MOTOR MOUNT	1
43	L50		5/16-18 x 1" FLAT HEAD	4

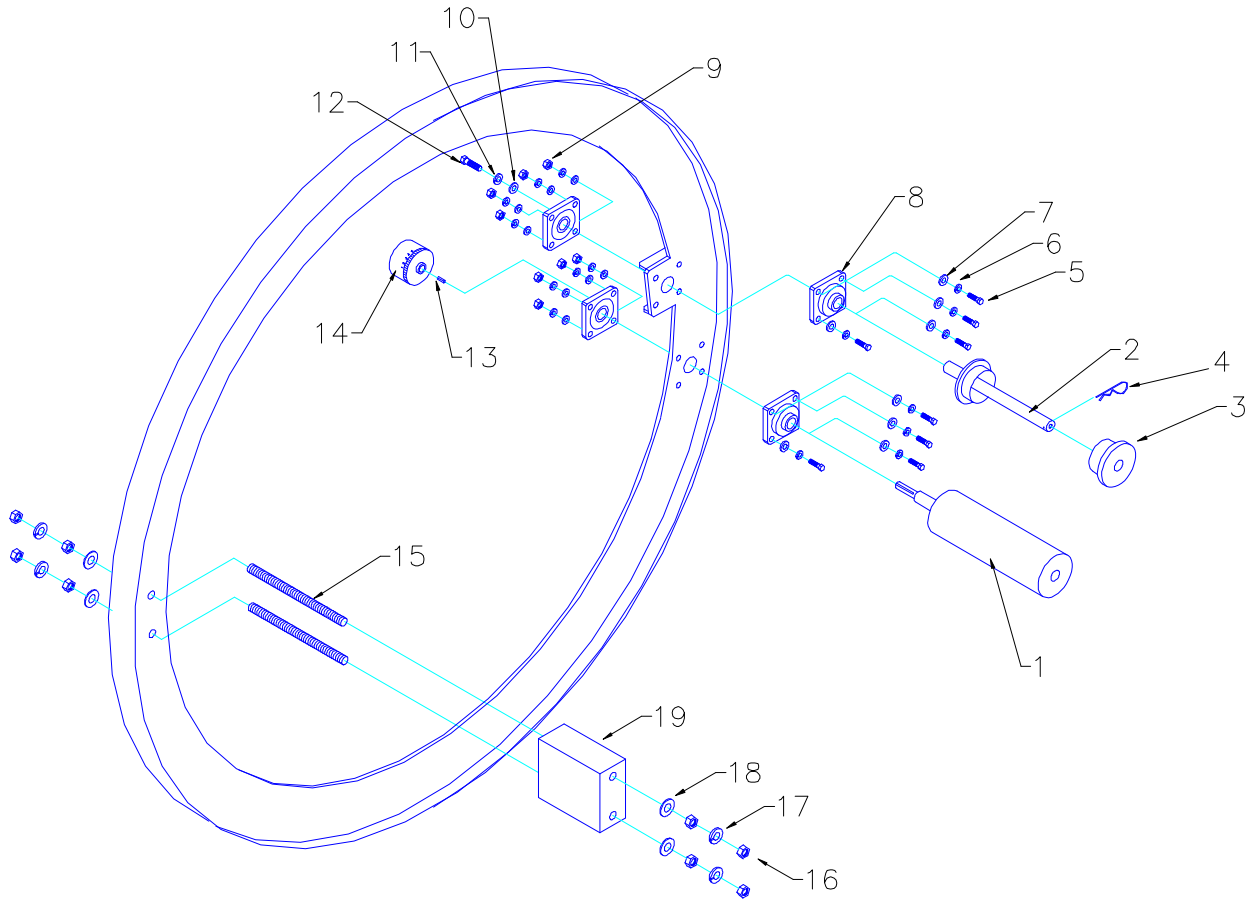
800 WINDER CHART FOR MOTOR, REDUCER, AND SPROCKETS

ITEM	PART #	GRAINGER #	DESCRIPTION	QTY
			(820PM WINDER 50 RPM)	
12	108124		50BT24 SPROCKET	1
12	108132		1610X1" BUSHING	1
32	105337	3N087	1hp 230v AC MOTOR 56C FACE	1
36	106595	1L291	5:1 R/A REDUCER 1.75CD 56C FACE	1
38	108118		50BT18 SPROCKET	1
38	108130		1610x7/8" BUSHING	1
			(826PM WINDER 44 RPM 830PM WINDER 40 RPM)	
12	108122		50BT22SPROCKET	1
12	108132		1610X1" BUSHING	1
32	105337	3N087	1hp 230v AC MOTOR 56C FACE	1
36	106595	1L291	5:1 R/A REDUCER 1.75CD 56C FACE	1
38	108115		50BT15PROCKET	1
38	108130		1610x7/8" BUSHING	1
			(840PM WINDER 35 RPM)	
12	108122		50BT22 SPROCKET	1
12	108132		1610X1" BUSHING	1
32	105337	3N087	1hp 230v AC MOTOR 56C FACE	1
36	106595	1L291	5:1 R/A REDUCER 1.75CD 56C FACE	1
38	108115		50BT15 SPROCKET	1
38	108130		1610x7/8" BUSHING	1
			(850PM WINDER 34 RPM)	
12	108120		50BT20 SPROCKET	1
12	108132		1610X1" BUSHING	1
32	105526	2R988	1-1/2hp 230v AC MOTOR 140TC FACE	1
36	106603	1L317	5:1 R/A REDUCER 2.06CD 140TC FACE	1
38	108116		50BT16 SPROCKET	1
38	108132		1610x1" BUSHING	1

800 WINDER CHART FOR MOTOR, REDUCER, AND SPROCKETS

ITEM	PART #	GRAINGER #	DESCRIPTION	QTY
			(860PM WINDER 34 RPM)	
12	108120		50BT20 SPROCKET	1
12	108132		1610X1" BUSHING	1
32	105527	2R992	2hp 230v AC MOTOR 140TC FACE	1
36	106603	1L317	5:1 R/A REDUCER 2.06CD 140TC FACE	1
38	108118		50BT18 SPROCKET	1
38	108132		1610x1" BUSHING	1
			(870PM WINDER 30 RPM)	
12	108120		50BT20 SPROCKET	1
12	108132		1610X1" BUSHING	1
32	105527	2R992	2hp 230v AC MOTOR 140TC FACE	1
36	106603	1L317	5:1 R/A REDUCER 2.06CD 140TC FACE	1
38	108116		50BT16 SPROCKET	1
38	108132		1610x1" BUSHING	1
			(880PM WINDER 29.5 RPM)	
12	108120		50BT20 SPROCKET	1
12	108132		1610X1" BUSHING	1
32	105535	2N650	3hp 230v AC MOTOR 56C FACE 1725RPM	1
36	106605	1L317	5:1 R/A REDUCER 2.06CD 140TC FACE	1
38	108119		50BT19SPROCKET	1
38	108132		1610x1" BUSHING	1
			(890PM WINDER 28.5 RPM)	
12	108120		50BT20 SPROCKET	1
12	108132		1610X1" BUSHING	1
32	105535	2N650	3hp 230v AC MOTOR 56C FACE 1725RPM	1
36	106603	1L317	5:1 R/A REDUCER 2.06CD 140TC FACE	1
38	108120		50BT20 SPROCKET	1
38	108132		1610x1" BUSHING	1

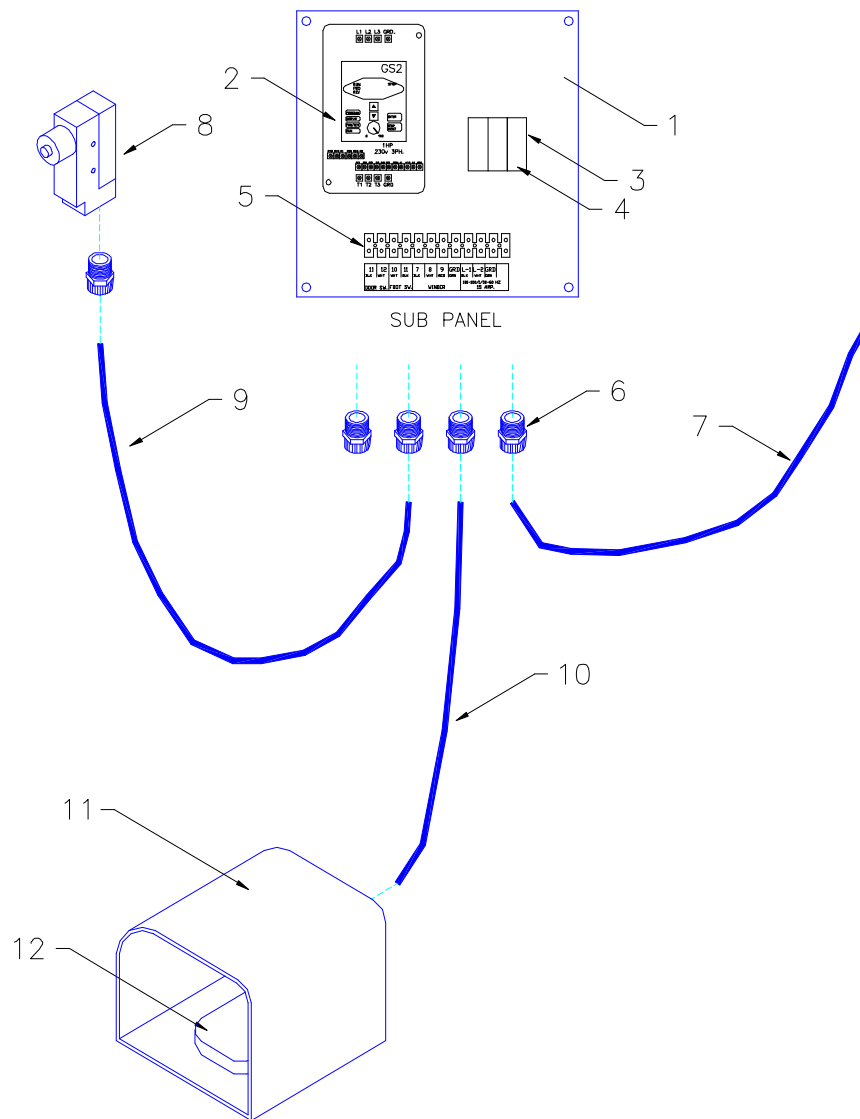
Kalamazoo Packaging Systems
Model #800PMV
Variable Tension Ring
w/ Pined Top Core



PARTS MANUAL: 800V WINDER RING with PIN

ITEM	PART #	DESCRIPTION	QTY
1	623070	800 12" WINDER VARIABLE TENSION 4" BRAKE ROLLER	1
1	623071	800 12" WINDER VARIABLE TENSION 2-1/2" BRAKE ROLLER	1
2	623072	800 10-12" WINDER VARIABLE TENSION FILM CORE w/ PIN	1
3	623078	3" PLASTIC TOP CORE	1
4	623079	3/16" HITCH PIN	1
5	L102	7/16-20 x 2-1/4" HHCS	8
6	L95	7/16 LOCK WASHER	8
7	L97	7/16 SAE WASHER	8
8	121140	1" 4-BOLT FLANGE BEARING	4
9	L165	7/16-20 NYLOCK NUT	8
10	L111	1/2" USS WASHER	1
11	L110	1/2" LOCK WASHER	1
12	L128	1/2-13 x 1" HHCS	1
13	L2	3/16"x 3/16"x 3/4" KEYWAY	1
14	130550	5/8" FINISH BORE MAGNETIC BRAKE	1
15	L162	3/4-10 x 11.0" THREADED ROD	2
16	L157	3/4-10 NUT	8
17	L158	3/4" LOCK WASHER	4
18	L159	3/4" USS WASHER	4
19	800CW-12	COUNTER WEIGHT	1

Kalamazoo Packaging Systems
Model # 800PM-AC
Control box: 115 volt and 230 volt



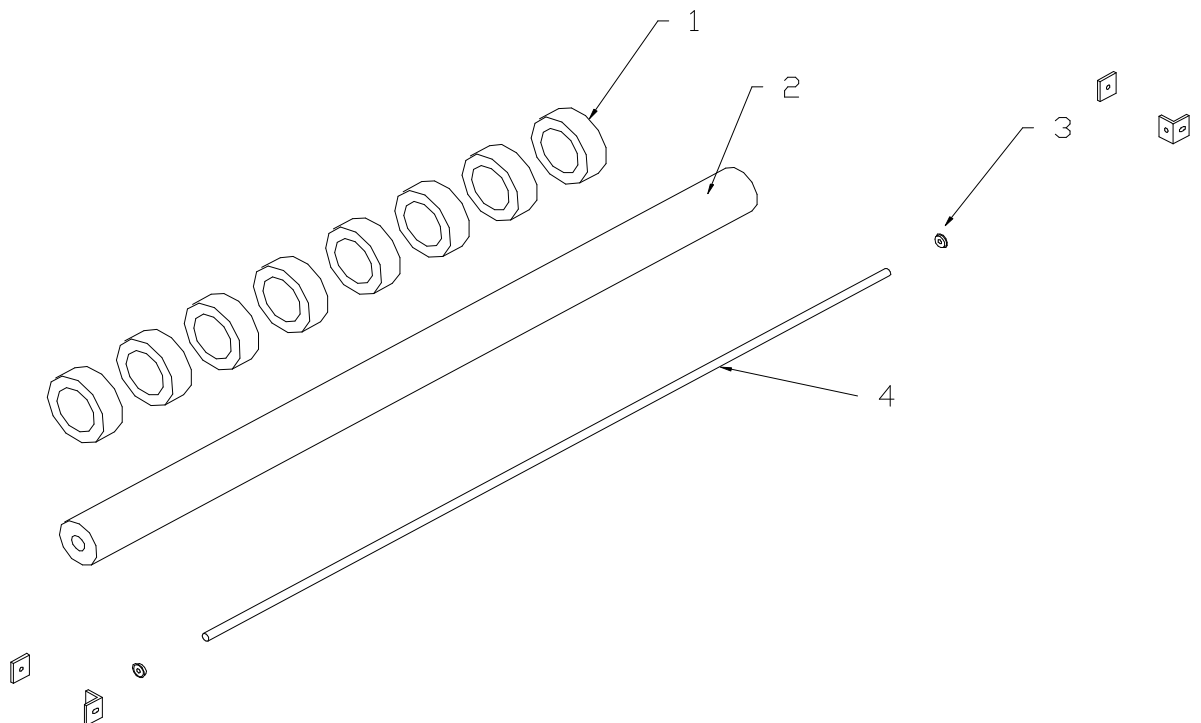
PARTS MANUAL: 800 HORIZONTAL WINDER CONTROL BOX

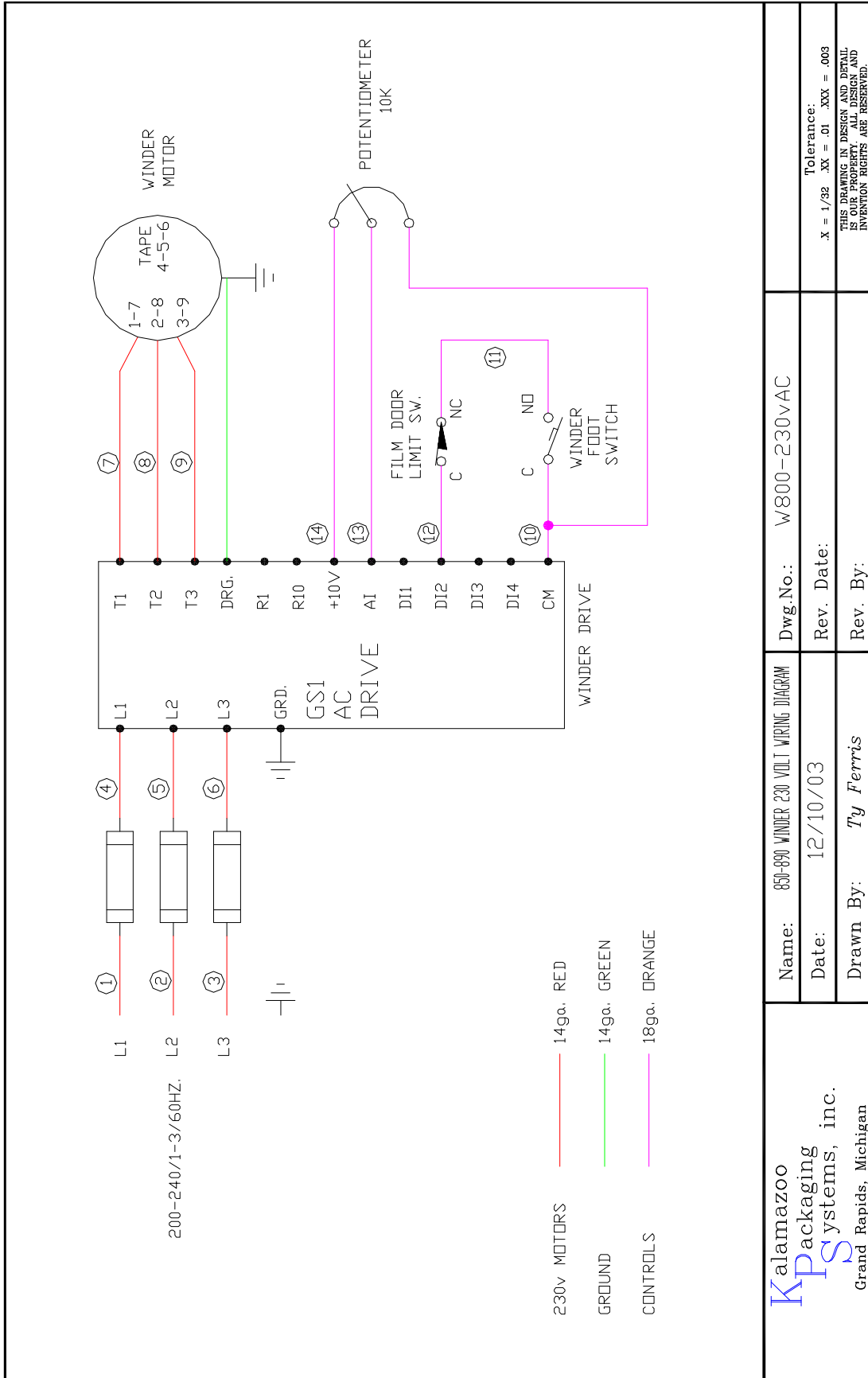
ITEM	PART #	GRAINGER #	DESCRIPTION	QTY
1	A12P12		12x12 SUB PANEL	1
2	131800		AC DRIVE 1HP. 3HP. 230V (830 & 840)	1
2	131809		AC DRIVE 2HP. 3HP. 230V (850, 860 & 870)	1
2	131810		AC DRIVE 3HP. 3HP. 230V (880 & 890)	1
3	210773		3-POLE FUSE HOLDER	1
4	210778		5 AMP. FUSE (830 & 840)	3
4	210781		8 AMP. FUSE (850)	3
4	210783		10 AMP. FUSE (860 & 870)	3
4	210786		15 AMP. FUSE (880 & 890)	3
5	209700		12 TERMINAL STRIP	1
6	210850		CORD GRIP	5
7	209905		14/4 STO CORD x 12' (YELLOW)	1
8	210852	2W938	LIMIT SWITCH (PLUNGER)	1
9	209850	1W661	16/3 SJ CORD x 10'	1
10	209850	1W661	16/3 SJ CORD x 10'	1
11	210710	2W811	FOOT SWITCH GUARD	1
12	210700	5X361	FOOT SWITCH	1
	206000		KPS NAME PLATE	1

PARTS MANUAL: 800 HORIZONTAL WINDER HOLD DOWN ROLLER

ITEM	PART #	DESCRIPTION	QTY
1	DWG.800-HDR	1"x 2"x 17.375 FOAM RUBBER GLUE & TAPED	Specify Model
2	800-HDR-850	4" PVC	2
3	120600	5/8x 1-3/8 FLANGE BEARING	4
4	800-HDR-850	5/8" ROUND SHAFT w/ 3/8-16 TAPED (Specify Model)	2
5	800-HDR	ROLLER HOLDER	2
6	800-HDR	ROLLER HOLDER PLATE	2
7	L81	3/8-16x 1" FHSCS	2
8	800095	KNOB 3/8-16	2

800PMW HOLD DOWN ROLLER





Kalamazoo Packaging Systems, inc. Grand Rapids, Michigan	Name: 850-890 WINDER 230 VOLT WIRING DIAGRAM	Dwg.No.: W800-230VAC
	Date: 12/10/03	Rev. Date:
	Drawn By: Ty Ferris	Rev. By:

Tolerance:
 .x = 1/32 .xx = .01 .xxx = .003
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