

SERIES 800PMW-AC
POWERED MANUAL HORIZONTAL WINDER STRETCH
WRAP SYSTEM WITH VARIABLE TENSION



OPERATORS
MANUAL

Table of Contents

Warranty.....	3
Assembly.....	4
Film Loading.....	4-5
Operating Controls.....	5
Operating Instructions.....	5
Maintenance.....	6
Adjustments.....	6
Trouble Shooting.....	7
AC Drive Programming GS1.....	8
Ac Drive Programming AVT31...9	
Parts Lists.....	10-21
Wiring Diagram GS1.....	22
Wiring Diagram ATV31.....	23

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.

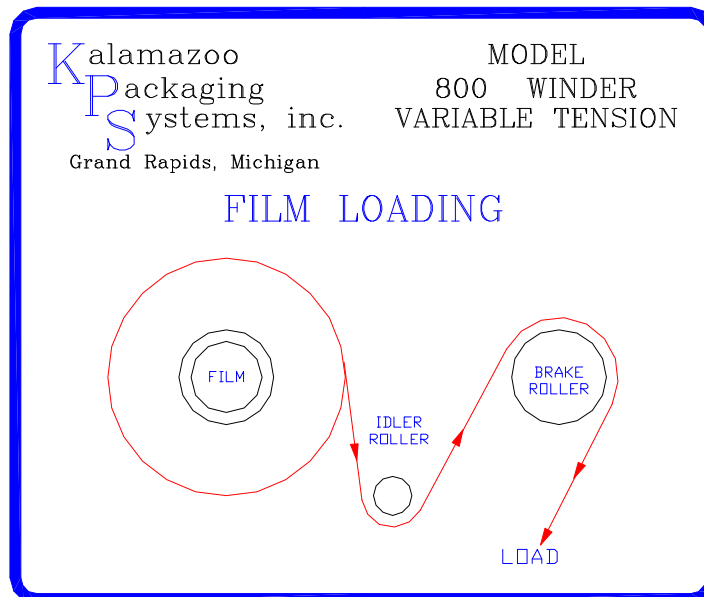
Air Source may be needed. If so use 80 P.S.I.

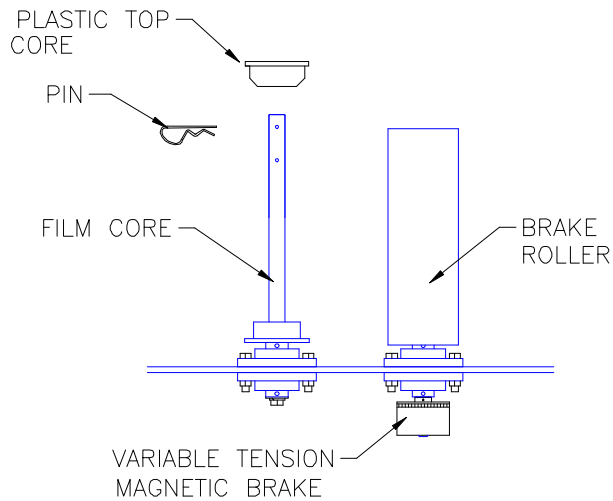
NOTE: The use of an extension cord may reduce the efficiency and life of the machine and is not recommended.

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 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 through 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 winder 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 breakers.

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 - See page 8 for programming the AC drive

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 and/or breakers.
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**

Telemecanique ATV31 AC Drive Programming

Winder

ACC. 3.0
dEC. 0.3
SFr 2.0
tCC. 2C
SP2 10HZ
rFr ENTER
tUn YES
UFr 50
UFt L
bFr 60

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	250200		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	250101		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	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
44	210852	2W938	LIMIT SWITCH (FILM DOOR)	1
45	250095		FOOT MOUNTING PLATE	4
46	L65		3/8 USS WASHER	16
47	L64		3/8 LOCK WASHER	16
48	L80		3/8-16 x 1" HEX HEAD CAP SCREW	16
49	L125		1/2-13 NUT	4
50	122851		1/2-13 RUBBER FEET	4
	122260		4" SWIVEL CASTER (not shown)	4
	129320		4" FLOOR LOCK (not shown)	4

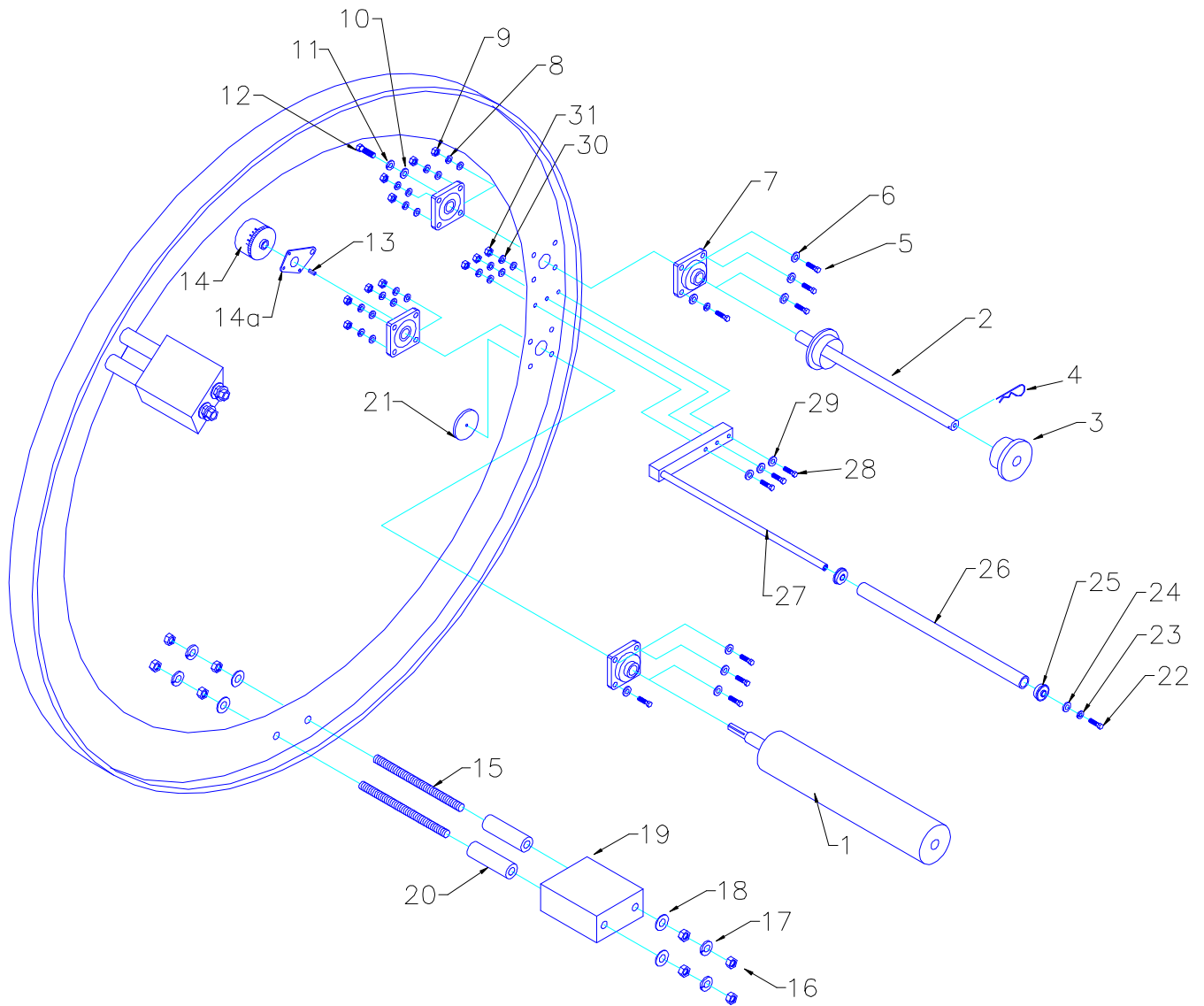
800 WINDER CHART FOR MOTOR, REDUCER, AND SPROCKETS

ITEM	PART #	DESCRIPTION	QTY
		(820PM WINDER 50 RPM)	
12	108127	50BT26 DRIVEN SPROCKET	1
12	108132	1610x1" BUSHING	1
32	105337	1hp 230v AC MOTOR 56C FACE	1
36	106595	5:1 R/A REDUCER 1.75CD 56C FACE	1
38	108120	50BT20 DRIVE SPROCKET	1
38	108130	1610x7/8" BUSHING	1
		(826PM WINDER 44 RPM—830PM WINDER 40 RPM)	
12	108122	50BT22 DRIVEN SPROCKET	1
12	108132	1610x1" BUSHING	1
32	105337	1hp 230v AC MOTOR 56C FACE	1
36	106595	5:1 R/A REDUCER 1.75CD 56C FACE	1
38	108117	50BT17 DRIVE SPROCKET	1
38	108130	1610x7/8" BUSHING	1
		(840PM WINDER 35 RPM)	
12	108122	50BT22 DRIVEN SPROCKET	1
12	108132	1610x1" BUSHING	1
32	105526	1-1/2hp 230v AC MOTOR 56C FACE	1
36	106595	5:1 R/A REDUCER 1.75CD 56C FACE	1
38	108116	50BT16 DRIVE SPROCKET	1
38	108130	1610x7/8" BUSHING	1
		(850PM WINDER 34 RPM)	
12	108120	50BT20 DRIVEN SPROCKET	1
12	108132	1610x1" BUSHING	1
32	105527	2hp 230v AC MOTOR 145TC FACE	1
36	106603	5:1 R/A REDUCER 2.0CD 140TC FACE	1
38	108120	50BT20 DRIVE SPROCKET	1
38	108132	1610x1" BUSHING	1

800 WINDER CHART FOR MOTOR, REDUCER, AND SPROCKETS

ITEM	PART #	DESCRIPTION	QTY
		(860PM WINDER 34 RPM)	
12	108120	50BT20 DRIVEN SPROCKET	1
12	108132	1610x1" BUSHING	1
32	105528	3hp 230v AC MOTOR 145TC FACE	1
36	106603	5:1 R/A REDUCER 2.0CD 140TC FACE	1
38	108118	50BT18 DRIVE SPROCKET	1
38	108132	1610x1" BUSHING	1
		(870PM WINDER 30 RPM)	
12	108120	50BT20 DRIVEN SPROCKET	1
12	108132	1610x1" BUSHING	1
32	105528	3hp 230v AC MOTOR 145TC FACE	1
36	106603	5:1 R/A REDUCER 2.0CD 140TC FACE	1
38	108118	50BT18 DRIVE SPROCKET	1
38	108132	1610x1" BUSHING	1
		(880PM WINDER 29.5 RPM)	
12	108120	50BT20 DRIVEN SPROCKET	1
12	108132	1610x1" BUSHING	1
32	105536	3hp 230v AC MOTOR 182TC FACE 1725RPM	1
36	106607	5:1 R/A REDUCER 2.3CD 180TC FACE	1
38	108119	50BT19 DRIVE SPROCKET	1
38	108133	1610x1-1/8" BUSHING	1
		(890PM WINDER 28.5 RPM)	
12	108120	50BT20 DRIVEN PROCKET	1
12	108132	1610x1" BUSHING	1
32	105536	3hp 230v AC MOTOR 182TC FACE 1725RPM	1
36	106607	5:1 R/A REDUCER 2.3CD 180TC FACE	1
38	108120	50BT20 DRIVE SPROCKET	1
38	108133	1610x1-1/8" BUSHING	1

Kalamazoo Packaging Systems
Model #800PM-RING
Variable Tension Ring
w/ Pined Top Core



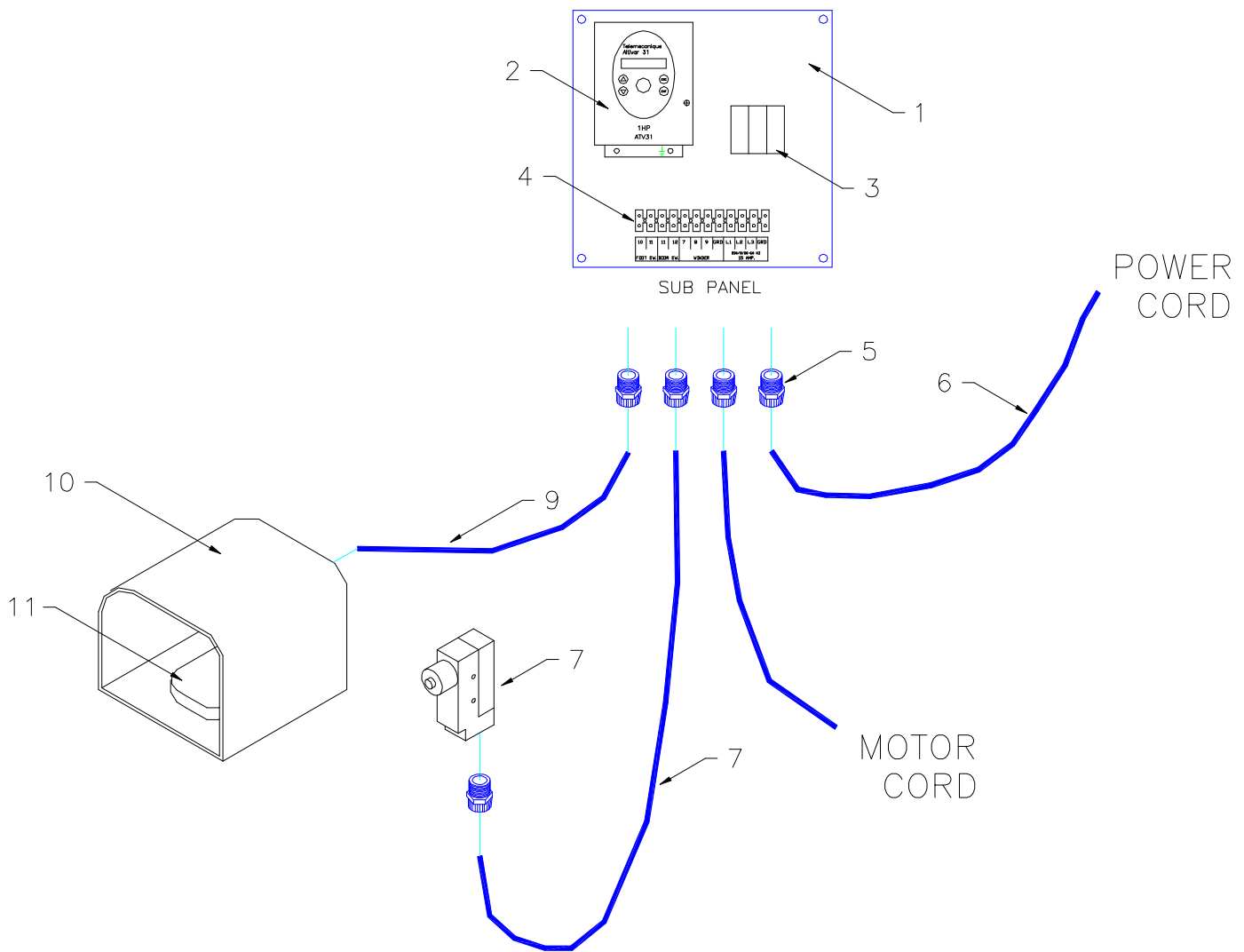
PARTS MANUAL: 800PM WINDER RING

ITEM	PART/DWG.#	DESCRIPTION	QTY
1	623070	4" DIA. x 12" WINDER VARIABLE TENSION BRAKE ROLLER	1
1	623074	4" DIA. x 20" WINDER VARIABLE TENSION BRAKE ROLLER	1
2	623072	12" WINDER VARIABLE TENSION FILM HOLDER w/ PINED TOP CORE	1
2	623076	20" WINDER VARIABLE TENSION FILM HOLDER w/ PINED TOP CORE	1
3	623078	3" PLASTIC TOP CORE	1
4	623079	3/16" STEEL HITCH PIN CLIP	1
5	L102	7/16-20 x 2-1/4" HHCS	8
6	L97	7/16 SAE WASHER	16
7	121140	1" 4-BOLT FLANGE BEARING	4
8	L95	7/16 LOCK WASHER	8
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 (MC 4)	1
14	130650	5/8" FINISH BORE MAGNETIC BRAKE (MC 5.5)	1
15	L162x11	3/4-10 x 11.0" THREADED ROD (12" FILM)	4
15	L162x19.5	3/4-10 x 19.5" THREADED ROD (20" FILM)	4

PARTS MANUAL: 800PM WINDER RING

ITEM	PART #/DWG. #	DESCRIPTION	QTY
16	L157	3/4-10 NUT	16
17	L158	3/4" LOCK WASHER	8
18	L159	3/4" USS WASHER	8
19	800CW-12	COUNTER WEIGHT (12" FILM)	2
19	800CW-20	COUNTER WEIGHT (20" FILM)	2
20	800CW-20	COUNTER WEIGHT SPACERS (20" FILM ONLY)	4
21	212383	3" PHOTO-EYE REFLECTOR	1
22	L80	3/8-16x 1" HHCS	1
23	L64	3/8" LOCK WASHER	1
24	L65	3/8" USS WASHER	1
25	120600	5/8" I.D. x 1-3/8" O.D. FLANGED BEARING	2
26	537125	PVC 1-1/4 TUBE sch.40 x 13-3/8" (12" FILM)	1
26	537125	PVC 1-1/4 TUBE sch.40 x 21-3/8" (20" FILM)	1
27	623075	12" BRAKE IDLER ROLLER MOUNT	1
27	623077	20" BRAKE IDLER ROLLER MOUNT	1
28	L57	5/16-18x 2" HHCS	3
29	L48	5/16 USS WASHER	6
30	L47	5/16" LOCK WASHER	3
31	L45	5/16-18 NYLOCK NUT	3

Kalamazoo Packaging Systems
 Model # 800PM-CB-230v-T
 Control box:
 230 volt with Telemecanique Drive



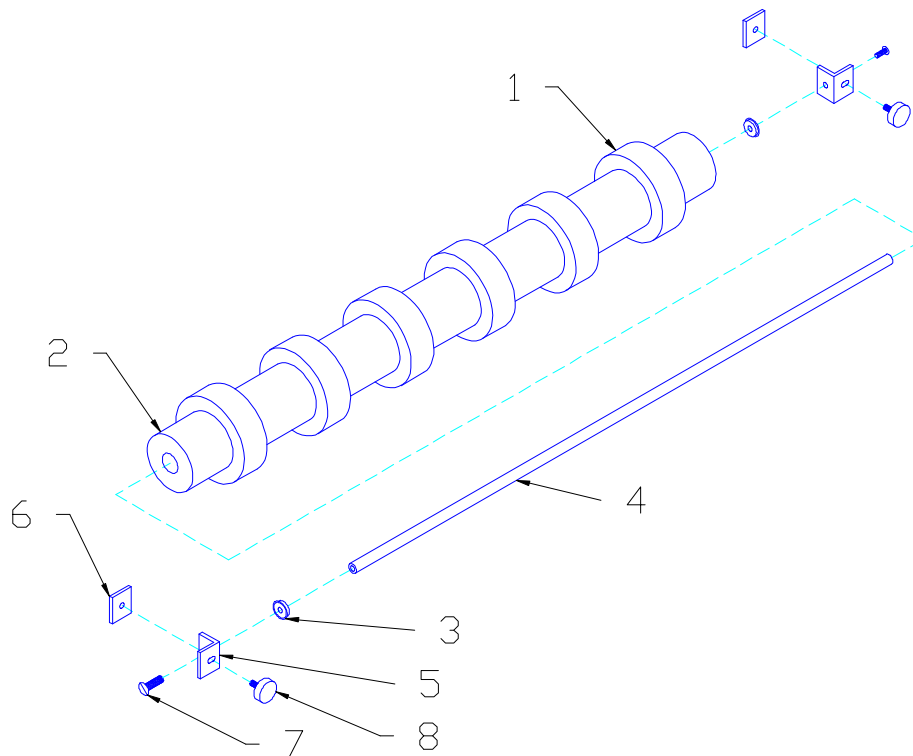
**PARTS MANUAL:
800PM HORIZONTAL WINDER CONTROL BOX
with Telemecanique AC Drives and Breakers**

ITEM	PART #	GRAINGER	DESCRIPTION	QTY
1	A12P12		12x12 SUB PANEL	1
2	131864		AC DRIVE 1hp. 230/1/60 IN 230/3/60 OUT (820 & 830)	1
2	131865		AC DRIVE 1hp. 230/3/60 IN 230/3/60 OUT (820 & 830)	1
2	131866		AC DRIVE 2hp. 230/1/60 IN 230/3/60 OUT (840 & 850)	1
2	131867		AC DRIVE 2hp. 230/3/60 IN 230/3/60 OUT (840 & 850)	1
2	131868		AC DRIVE 3hp. 230/1/60 IN 230/3/60 OUT (860, 870, & 880)	1
2	131869		AC DRIVE 3hp. 230/3/60 IN 230/3/60 OUT (860, 870, & 880)	1
3	211052		230/1/60 5 AMP. BREAKER (820 & 830)	1
3	211053		230/3/60 5 AMP. BREAKER (820 & 830)	1
3	211082		230/1/60 8 AMP. BREAKER (840 & 850)	1
3	211083		230/3/60 8 AMP. BREAKER (840 & 850)	1
3	211152		230/1/60 15 AMP. BREAKER (860, 870 & 880)	1
3	211153		230/3/60 15 AMP. BREAKER (860, 870 & 880)	1
4	209700		12 TERMINAL STRIP	1
5	210850		CORD GRIP	5
6	209905		14/4 STO POWER CORD x 12' (YELLOW)	1
7	210852	2W938	LIMIT SWITCH (PLUNGER)	1
8	209850	1W661	16/3 SJ FILM DOOR CORD x 10'	1
9	209850	1W661	16/3 SJ FOOT SWITCH CORD x 10'	1
10	210710	2W811	FOOT SWITCH GUARD	1
11	210700	5X361	FOOT SWITCH	1
	206000		KPS NAME PLATE	1

OPTIONAL PARTS : 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	4" PVC (Specify Model)	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

Kalamazoo Packaging Systems
Model # 800PM WINDER
Manually Adjustable Hold Downs



PARTS MANUAL: 800PMW WINDER CONVEYOR

ITEM	PART #	DESCRIPTION	QTY
1	121445	11/16" CONVEYOR SPRINGS	8
2	121401	2-1/2" CONVEYOR BEARINGS	16
3	800PMW-R	CONVEYOR ROLLER (Specify Model)	8
4	800PMW-RC-4	WINDER CONVEYOR SIDE FRAME (Specify Model)	4
5	800PMW-RC-4	2" sq. UPRIGHT (Specify Model)	2
6	800PMW-RC-4	1-3/4" UPRIGHT (Specify Model)	2

800PMW WINDER CONVEYOR

