



Grand Rapids, Michigan, U.S.A. 49504-5298

**USER'S OPERATING AND INSTRUCTION MANUAL**

**MODEL 1508-NLG**

**SELF-ACTUATING TRAY LIDDER**



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## 1508-NLG SELF-ACTUATING LIDDER

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### INDEX

SAFETY INSTRUCTIONS.....	1508S20002
SET UP.....	1508S20003
OPERATING PROCEDURE.....	1508S20004
ADJUSTMENTS.....	1508S20005
TECHNICAL SPECIFICATIONS.....	1508S20006
CLEANING.....	1508S20007
TROUBLE SHOOTING.....	1508S20012-1
PUSHER ADJUSTMENTS.....	1508S20012-2
ASSEMBLIES	
BASE ASSEMBLY.....	1508S20008
HEATER PLATTEN ASSEMBLY .....	1508S20009
MANIFOLD ASSEMBLY.....	1508S20010
FINAL ASSEMBLY.....	1508S20011
MACHINE EXCHANGE PROGRAM.....	GEN 050819
WARRANTY.....	GEN 040225
WARRANTY PROCEDURE.....	GEN 040226
RETURNED PARTS POLICY.....	GEN 040227



## 1508-NLG SELF-ACTUATING LIDDER

### SAFETY

Various safety devices and methods of guarding have been provided on this machine. It is essential, however, that machine operators and maintenance personnel observe the following safety precautions. Improper installation or operation of this equipment may cause injury to personnel or damage to equipment.

- Before operating the *Self-Actuating Lidder* read through this manual. Never allow an untrained person to operate this machine.

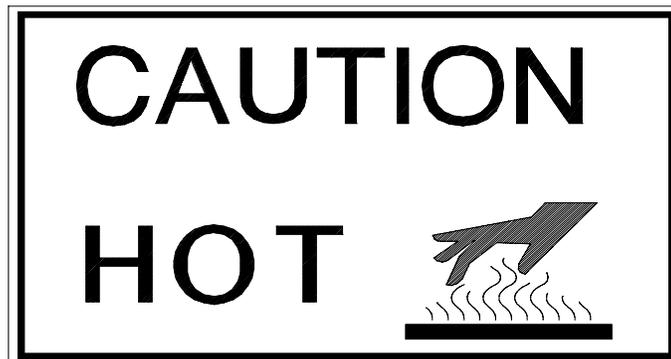
#### WARNING

- **WARNING PINCH POINT:** Keep hands out of machine. Always be sure the machine has been unplugged from power and air before cleaning or servicing.



#### CAUTION

- **CAUTION HOT:** The heater cover and upper platen are very **HOT!** Caution must be used to protect yourself and others.



- In addition to these general safety instructions, follow the specific instructions given through out this manual.

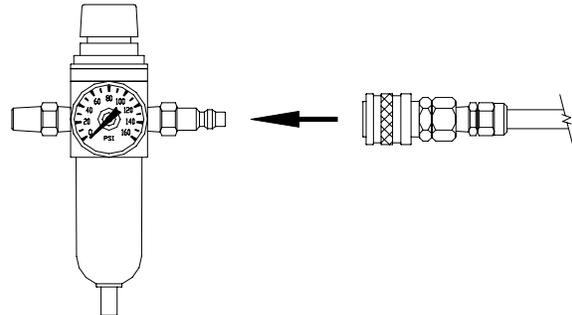


## 1508-NLG SELF-ACTUATING LIDDER

### SET UP

1. Unpack and carefully remove the *Self-Actuating Lidder*. Check for completeness of your order and that none of the items have been damaged during shipment.
2. Screw the four rubber feet in to place on the bottom of the machine.
3. Place the *Self-Actuating Lidder* in a suitable location that provides adequate working space. The location must be sturdy, level, and capable of holding 50 lbs. per machine.

4. Use the quick detachable coupler to connect air pressure to the filter/regulator. The *Self-Actuating Lidder* requires a minimum of 0.1 CFM at 90 PSI.



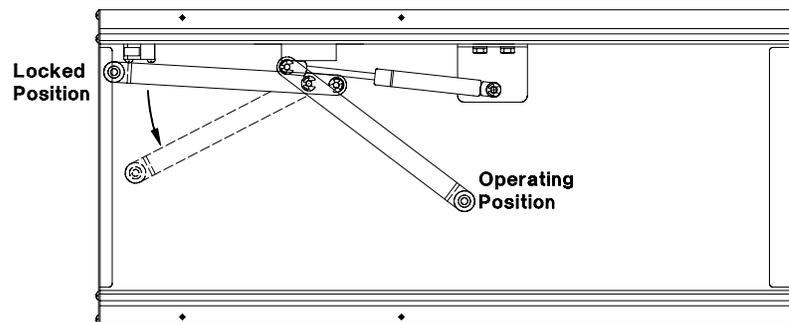
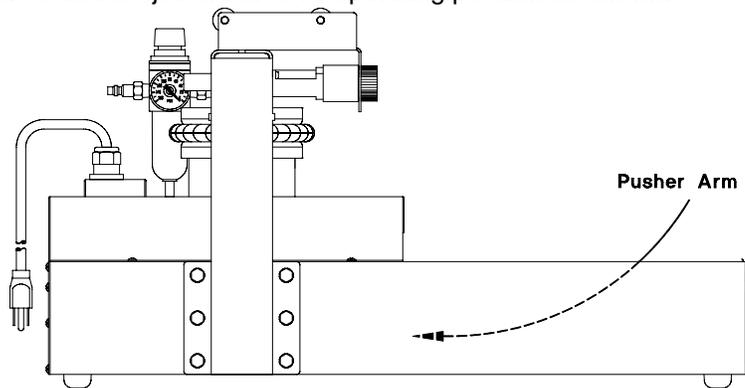
#### NOTE

- DO NOT USE AN OILER OR LUBRICATOR WITH THIS MACHINE.

#### NOTE

- DO NOT CONNECT TO AIR PRESSURE ABOVE 140 PSI.

5. Pull the ejector bar to its operating position as shown.

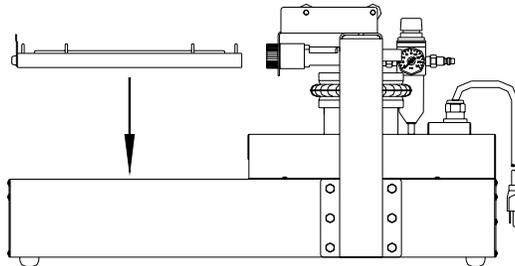




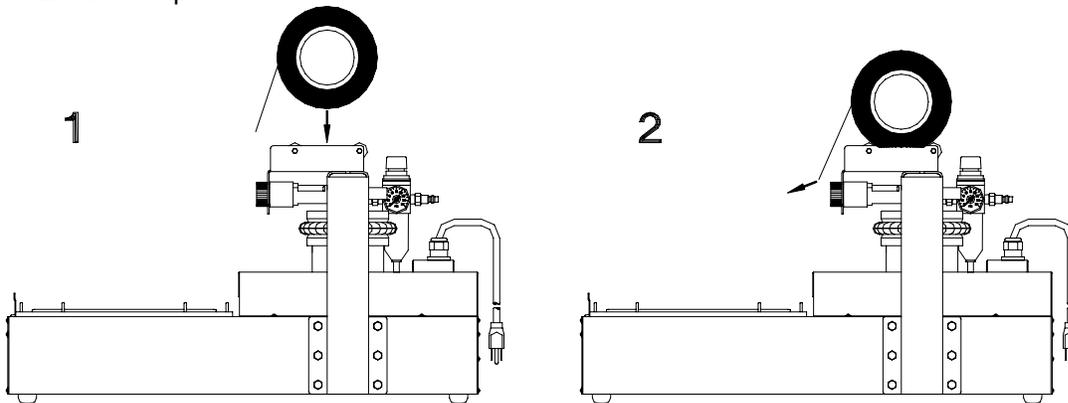
## 1508-NLG SELF-ACTUATING LIDDER

### 6. SET UP (continued)

6. Plug the power cord into a grounded electrical outlet. The *Self-Actuating Lidder* requires single phase 110 VAC, 60 Hertz with 10 ampere (minimum) circuit breaker protection.
7. Install the tray carrier:



8. Load lid dispenser:





## 1508-NLG SELF-ACTUATING LIDDER

### OPERATING PROCEDURE

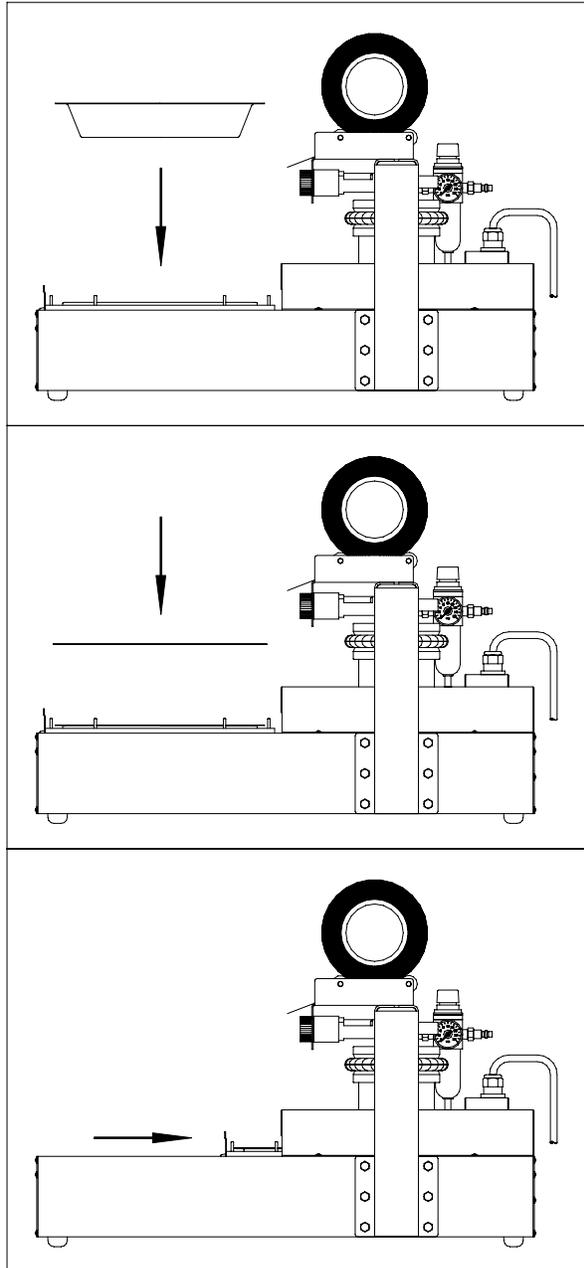
1. To turn the machine on plug in the power cord. **Wait 40 minutes** to allow the heated upper platen to reach temperature.
2. Place a tray in the tray carrier.
3. Position a single lid on the tray. Use the retractable pins on the tray carrier to center the lids over the tray. **Be sure the adhesive side of the lid is down.**

#### NOTE

- The adhesive side of the lid can be determined by pinching a fold and rubbing the lid material against itself. Test both sides of the lid. The rough or tacky side of the lid will be the adhesive side.
4. Push the tray carrier into the *Self-Actuating Lidder* until it stops. This will cycle the heated upper platen down, applying pressure on the film and tray flanges. As the heated upper platen lifts back to the open position, the tray carrier will automatically reopen.

#### NOTE

- Actuating machine with no tray or lid in place may cause the tray carrier to stick closed.
5. To remove the lidded tray push up on the bottom of the tray with your hand and lift from tray carrier.





## 1508-NLG SELF-ACTUATING LIDDER

# ADJUSTMENTS

Your *Self-Actuating Lidder* was tested at the factory, using the same trays and film as you will use. Regulated pressure, temperature, and dwell time were adjusted during this test to provide a good seal. Our test results indicate the following:

Regulated Pressure	_____	PSI
Temperature	_____	°F
Dwell Time	_____	Seconds

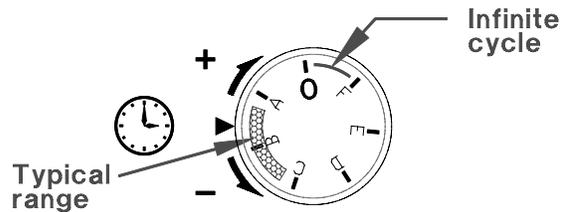
When checking for a good seal look for seal completeness and reasonable seal strength. A poor seal will occur if the product in the tray contaminates the tray flanges. Moisture will have the same negative affect. Trays that have irregular flanges or are deformed also seal poorly. Defective trays should be discarded.

Under different operating conditions, you may find it necessary to adjust one or all of the sealing parameters. When making adjustments; change only one parameter at a time, make small incremental adjustments, and record the change made. This is one situation where **"MORE IS NOT BETTER"**! In other words, more heat plus more pressure plus longer dwell time does not necessarily equal better seals.

**REGULATED PRESSURE:** To adjust the regulated pressure simply pull up the knob on the top of the filter/regulator and rotate until the gauge shows the desired pressure (40 PSI min.). Push the knob back down to lock.

**DWELL TIME:**

The dwell time adjustment knob is on the front of the machine. The dwell time can be adjusted from .1 seconds to 30 seconds. Rotate the knob between the "0" and "F" knob markings until the desired dwell time is found. The greater the angle (clockwise direction), the greater the dwell time setting.



**NOTE**

- **AVOID MAKING CHANGES TO THE TEMPERATURE SETTING.**

**TEMPERATURE:** The temperature of the heated upper platen can be adjusted through an access hole on the top of the electrical cover. Use a slotted blade screwdriver to remove the plug and make the adjustment.

Once the right combination of the three parameters is found, no further adjustments should be necessary - so long as you do not change the film or tray material.



## 1508-NLG SELF-ACTUATING LIDDER

# TECHNICAL SPECIFICATIONS

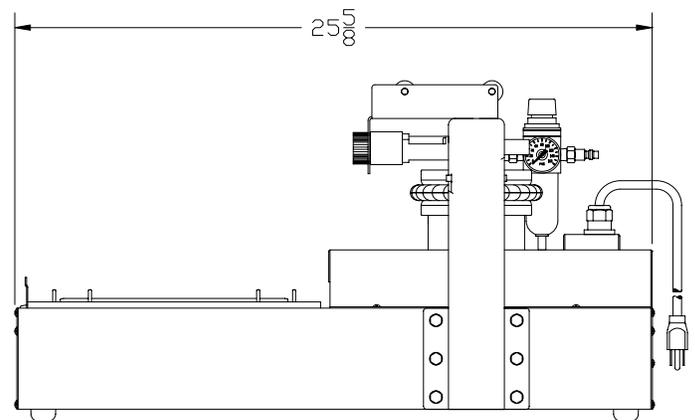
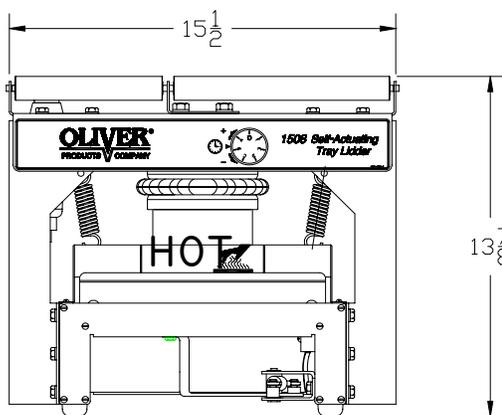
Tray Capacities:

8" (203mm) by 9.75" (248mm) maximum top-outside-dimension tray.

Temperature Range:

50°F (10°C) to 300°F (149°C)

Machine Dimensions:



Weight:

55 lbs. (22.7 kg)

Electrical:

115 VAC, 8 Amps, Single Phase, 50/60 Hz **OR**  
230 VAC, 4 Amps, Single Phase, 50/60 Hz



## 1508-NLG SELF-ACTUATING LIDDER

### CLEANING

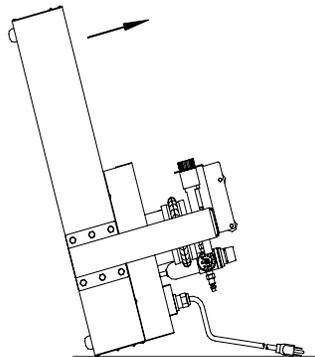
- If the machine has been operating, allow the unit to cool before cleaning.

#### **CAUTION**

- **CAUTION HOT:** The heater cover and upper platen are very **HOT!** Caution must be used to protect yourself and others.

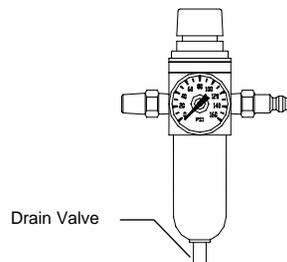
#### **WARNING**

- **WARNING PINCH POINT: Keep hands out of machine.** Always be sure the machine has been unplugged from power and air before cleaning or servicing.
- Make sure the unit has been unplugged from power and air before cleaning.
- Clean the *Self-Actuating Lidder* with a mild cleaner and a damp cloth.
- To clean or access the heated upper platen: remove the the tray carrier and lidding material, tip machine back, and rotate tray carrier return arm back to locked position (see setup).



#### **CAUTION**

- **MAKE SURE UNIT IS SECURE AND WILL NOT TIP OVER**
- Use a copper scouring pad to clean heated upper platen. Allow platen to cool before attempt to clean.
- Accumulated sludge and moisture should be drained from the filter/regulator. Sediment should not be permitted to fill above the filter element.





**1508-NLG SELF-ACTUATING LIDDER**

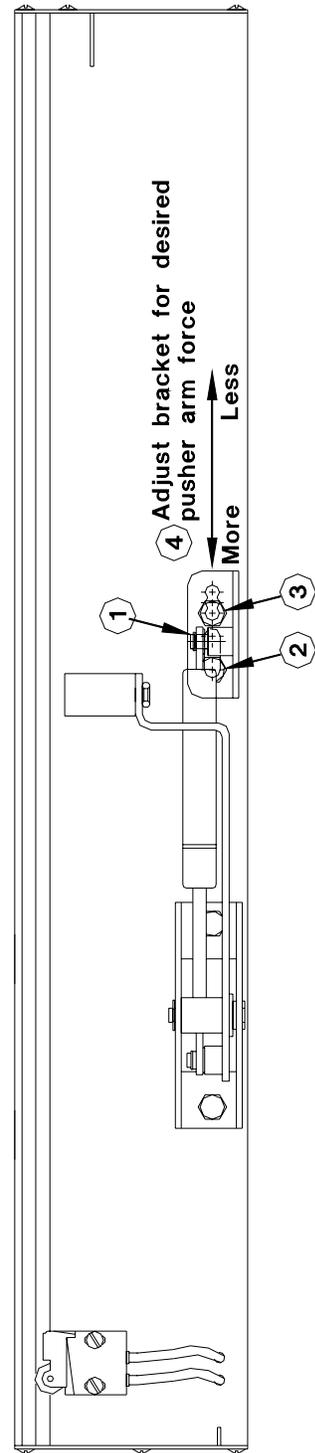
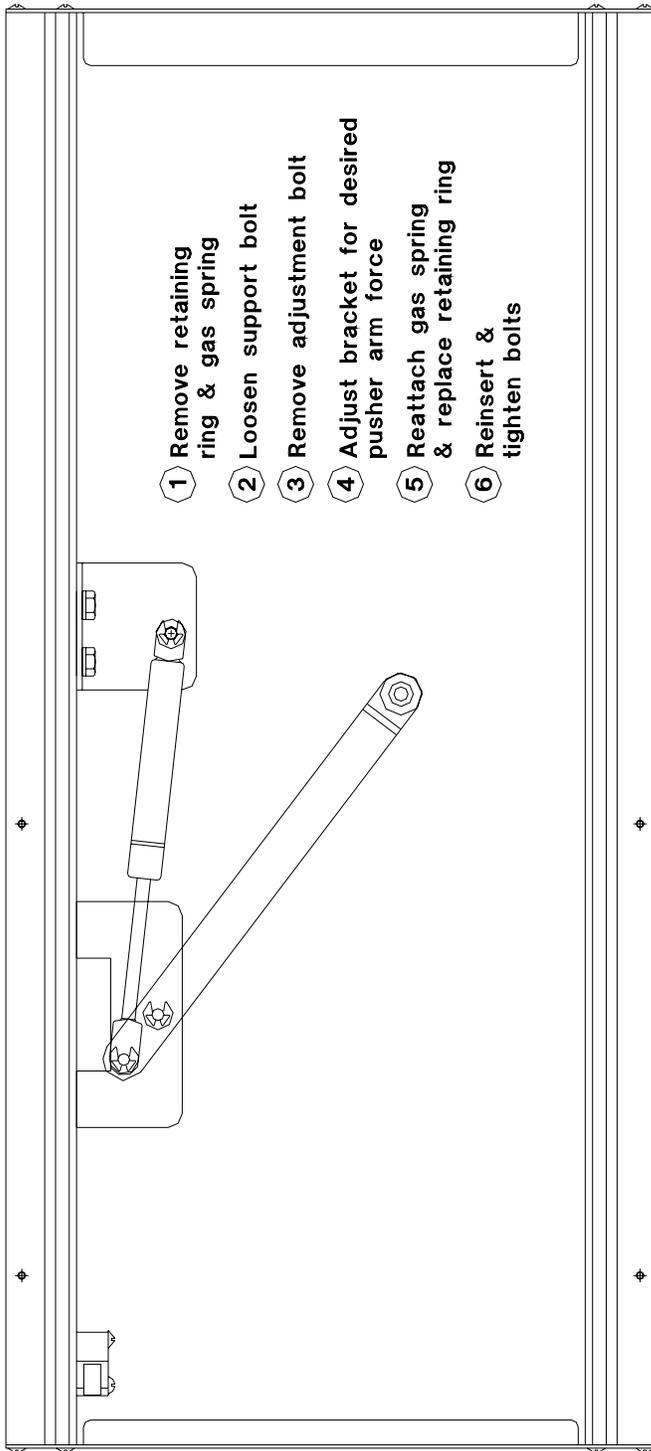
**TROUBLE SHOOTING**

SYMPTOM	CORRECTIVE ACTION
Heater will not power up	1. Verify that the power cord is plugged in 2. Press Reset on the circuit breaker
Heated upper platen won't cycle	1. Verify that the air line is plugged in 2. Verify that the air compressor is on 3. Verify air pressure at the filter/regulator
Lid folding, shifting or sliding off machine	1. Verify that the adhesive side of the lid is down 2. Verify that the trays are not over fillet 3. Clean the heated upper platen
Poor seal quality ↻ Allow seal to cool before checking quality	1. Verify the pressure setting (adjustments) 2. Verify the dwell time setting (adjustments) 3. Verify the temperature setting (adjustments) 4. Clean the upper platen (cleaning)
Upper platen will not release the tray carrier	1. Verify the dwell time setting (adjustments)
Tray does not eject properly	1. Take pusher arm out of Locked position (setup) 2. Wipe clean both the white nylon wear strips, and the matching wear surface on the tray carrier with a light mineral oil or vegetable oil 3. Make adjustment to gas spring bracket (see 1508S200012-2)

**Oliver Products Company 24 hr emergency service (800) 554-5603**



### 1508-NLG SELF-ACTUATING LIDDER



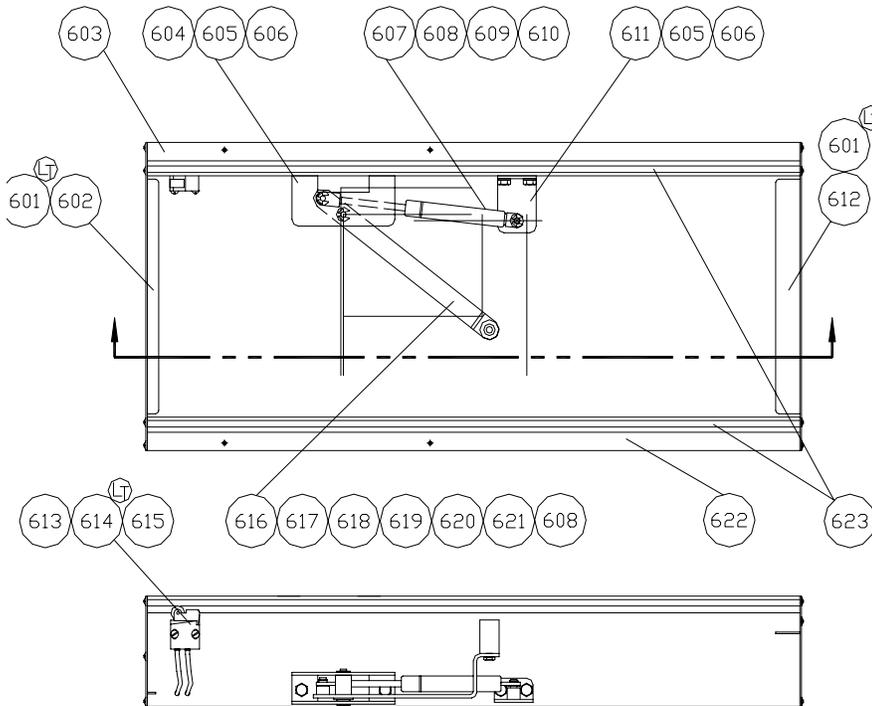


**1508-NLG SELF-ACTUATING LIDDER**

**BASE ASSEMBLY**

ITEM	PART NUMBER	DESCRIPTION	QUAN.	DWG
601	5843-5210	SCREW-RND HD 6-32x1/4	20	PUR
602	1508-0006-1	COVER - REAR	1	C
603	1508-0001-1001	BASE - RIGHT HAND	1	D
604	1508-0011-1	PIVOT BRACKET PUSHER	1	C
605	5843-1002	SCREW-HEX 1/4-20x5/8	4	PUR
606	5851-9357	WASHER-LOCK 1/4"	4	PUR
607	6084-8706	SPRING GAS 15# CYL.	1	C
608	5840-1273	RING-RETAINING TRUARC	3	PUR
609	1508-0007-1023	BUSHING HOUSING	1	C
610	5257-0205	BRNG-FLG NYLNR THDM	2	PUR
611	1508-0008-1	BRACKET-GAS SPRING	1	C
612	1508-0005-1	COVER - FRONT	1	C
613	5148-5339	VALVE-AIR ROLLER	1	B
614	5843-5227	SCREW-RND HD #8-32	2	PUR
615	6528-5505	TUBING-NYLON	46'	PUR
616	1508-0007-1	PUSHER ARM	1	C
617	1508-0028	PIN-HEX HINGE	1	C
618	1508-0010	ROLLER - PUSHER	1	C
619	5831-9113	NUT-FLX LK FLHT 10-24	1	C
620	5257-0574	BRNG-FLG NYLON BUNT	2	PUR
621	5842-8989	SCREW-SHOULDER 1/4x1"	1	PUR
622	1508-0001-1002	BASE - LEFT HAND	1	D
623	1508-0024-1	RDD SLD. 25-3/8" LONG	4	C

Ⓛ - REQUIRE LOCKTITE (THREADLOCKER 242)

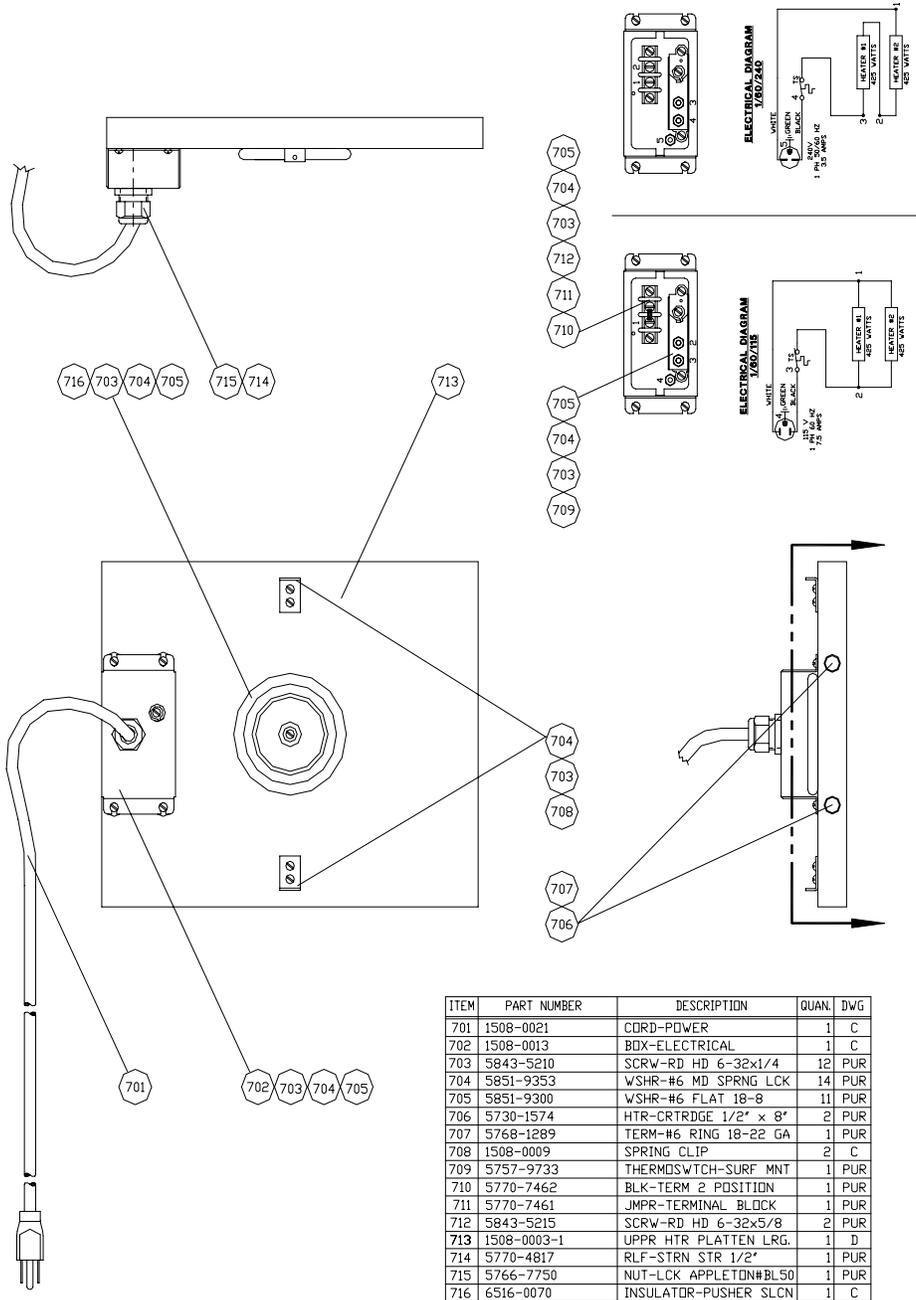


Rev. 8/15/05



1508-NLG SELF-ACTUATING LIDDER

HEATER PLATEN ASSEMBLY

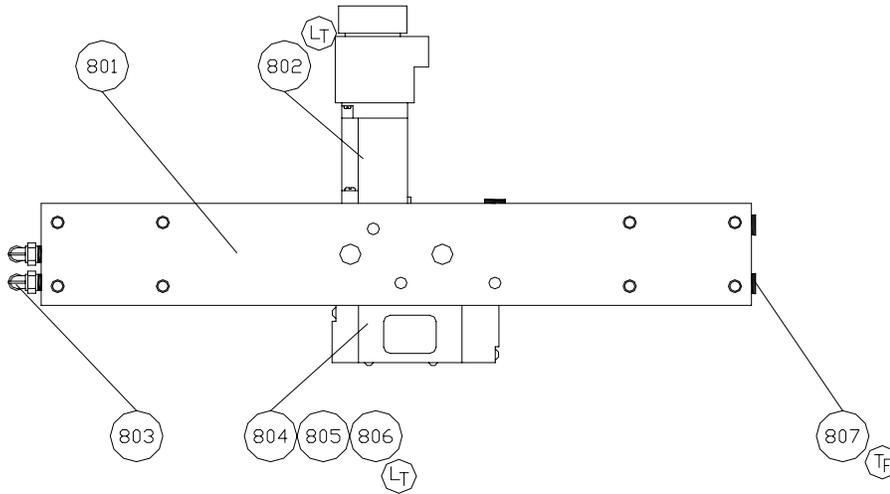


ITEM	PART NUMBER	DESCRIPTION	QUAN.	DWG
701	1508-0021	CORD-POWER	1	C
702	1508-0013	BXD-ELECTRICAL	1	C
703	5843-5210	SCRW-RD HD 6-32x1/4	12	PUR
704	5851-9353	WSHR-#6 MD SPRNG LCK	14	PUR
705	5851-9300	WSHR-#6 FLAT 18-8	11	PUR
706	5730-1574	HTR-CRTRDGE 1/2" x 8'	2	PUR
707	5768-1289	TERM-#6 RING 18-22 GA	1	PUR
708	1508-0009	SPRING CLIP	2	C
709	5757-9733	THERMOSWITCH-SURF MNT	1	PUR
710	5770-7462	BLK-TERM 2 POSITION	1	PUR
711	5770-7461	JMPR-TERMINAL BLOCK	1	PUR
712	5843-5215	SCRW-RD HD 6-32x5/8	2	PUR
713	1508-0003-1	UPPR HTR PLATTEN LRG.	1	D
714	5770-4817	RLF-STRN STR 1/2"	1	PUR
715	5766-7750	NUT-LCK APPLETON#BL50	1	PUR
716	6516-0070	INSULATOR-PUSHER SLCN	1	C



1508-NLG SELF-ACTUATING LIDDER

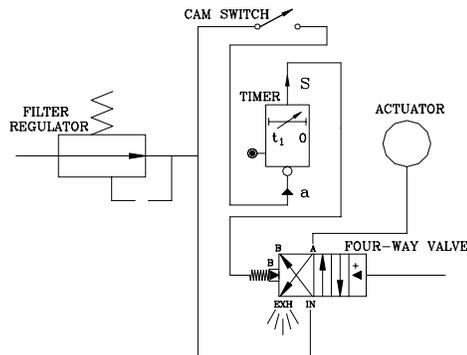
**MANIFOLD ASSEMBLY**



ITEM	PART NUMBER	DESCRIPTION	QUAN.	DWG
801	5130-0023	MNFLD-MAIN PNEUMATIC	1	PUR
802	5148-6510	TIMER- PNEUMATIC	1	PUR
803	5115-1775	FTNG-ELB 90 SVL	2	PUR
804	5148-5531	VALVE-4WAY PNL MNTE.D	1	PUR
805	6909-3006	O-RING #568-006	1	PUR
806	5843-5196	SCREW-RND HEAD	2	PUR
807	5115-1427	PLUG-PIPE BR CSNK 1/8	5	PUR
xxx	5130-7005	MUFFLER-EXHAUST1/8NPT	2	PUR

(LT) - REQUIRE LOCKTITE (REMOVABLE THREADLOCKER 242)

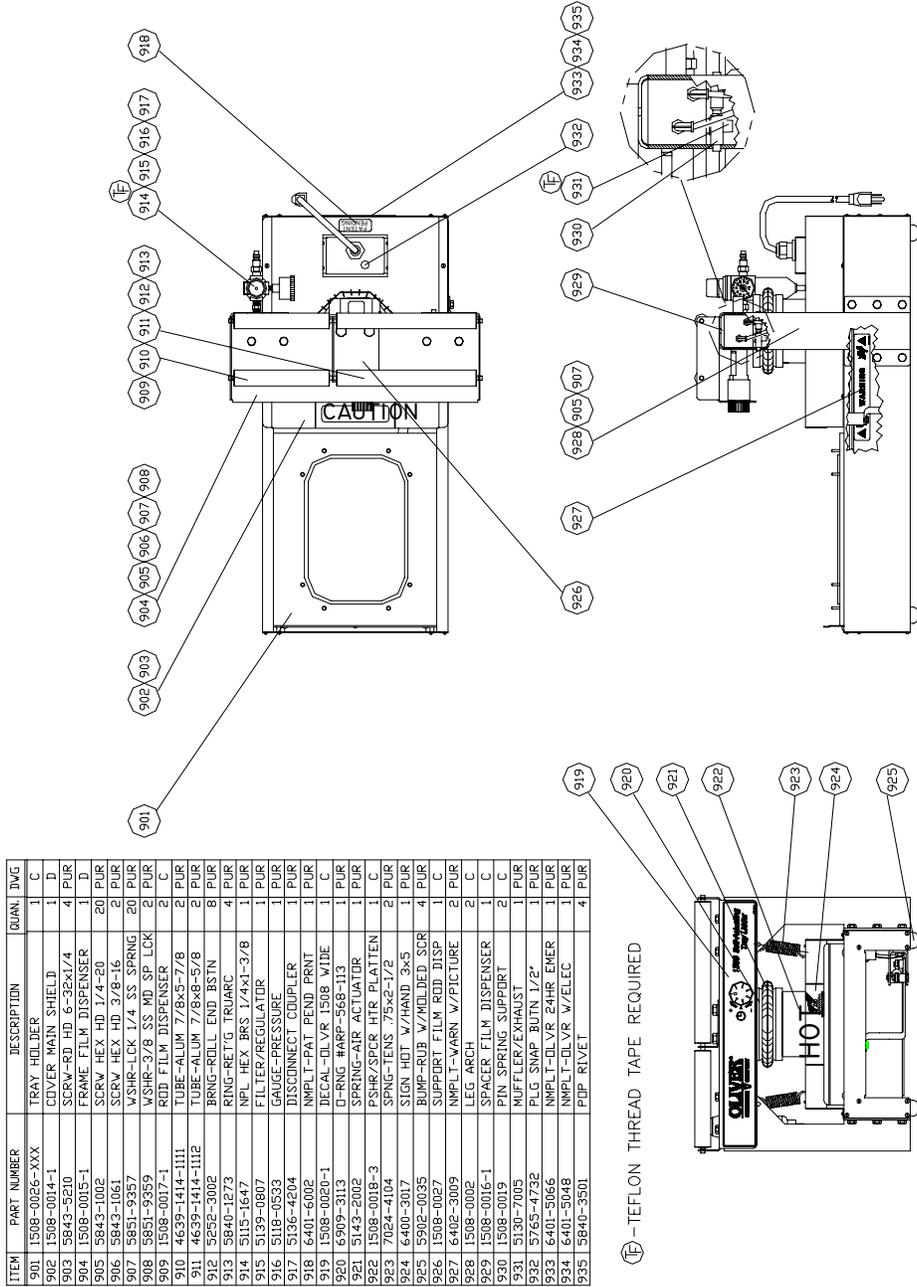
(TF) - REQUIRE TEFLON TAPE PNEUMATICS DIAGRAM





1508-NLG SELF-ACTUATING LIDDER

FINAL ASSEMBLY



ITEM	PART NUMBER	DESCRIPTION	QUAN.	IMG.
900	1508-0026-XXX	TRAY HOLDER	1	C
902	1508-0014-1	COVER MAIN SHIELD	1	D
903	5843-3520	SCRW-RD HD 6-32x1/4	4	PUK
904	1508-0015-1	FRAME FILM DISPENSER	1	D
905	5843-1002	SCRW HEX HD 1/4-20	20	PUK
906	5843-1061	SCRW HEX HD 3/8-16	2	PUK
907	5851-9357	WHR-LOCK 1/4 SS SPRNG	20	PUK
908	5851-9359	WHR-3/8 SS ND SP LCK	2	PUK
909	1508-0017-1	ROD FILM DISPENSER	2	C
910	4639-1414-1111	TUBE-ALUM 7/8x3-7/8	2	PUK
911	4639-1414-1112	TUBE-ALUM 7/8x8-5/8	2	PUK
912	5252-3002	BRNG-ROLL END B5TN	8	PUK
913	5840-1273	RING-RET'G TRIARC	4	PUK
914	5115-1647	NPL HEX BR3 1/4x1-3/8	1	PUK
915	5139-0807	FILTER-REGULATOR	1	PUK
916	5118-0533	GAUGE-PRESSURE	1	PUK
917	5136-4204	DISCONNECT COUPLER	1	PUK
918	6401-6002	NMPL-PAT PEND PRINT	1	PUK
919	1508-0020-1	DECAL-OLVR 1508 WIDE	1	C
920	6909-3113	O-RING #ARP-568-113	1	PUK
921	5143-2002	SPRING-AIR ACTUATOR	1	PUK
922	1508-0018-3	PSHR/SPCR HTR PLATTEN	1	C
923	7024-4104	SPNG-TENS .75x2-1/2	2	PUK
924	6400-3017	SIGN HOT W/HAND 3x5	1	PUK
925	5902-0035	BUMP-RUB W/MELDED SCR	4	PUK
926	1508-0027	SUPPORT FILM ROD DISP	1	C
927	6402-3009	NMPL-WARN W/PICTURE	2	PUK
928	1508-0002	LEG ARCH	2	C
929	1508-0016-1	SPACER FILM DISPENSER	1	C
930	1508-0019	PIN SPRING SUPPORT	2	C
931	5130-7005	MUFFLER/EXHAUST	1	PUK
932	5765-4732	PLG SNAP BUTN 1/2"	1	PUK
933	6401-5066	NMPL-OLVR 24HR EMER	1	PUK
934	6401-5048	NMPL-OLVR W/ELEC	1	PUK
935	5840-3501	PDP RIVET	4	PUK

REV 2/24/09



## WARRANTY

### PARTS

Oliver Packaging & Equipment Company (Oliver) warrants that if any part of the equipment (other than a part not manufactured by Oliver) proves to be defective (as defined below) within one year after shipment, and if Buyer returns the defective part to Oliver within one year, Freight Prepaid to Oliver's plant in Grand Rapids, MI, then Oliver, shall, at Oliver's option, either repair or replace the defective part, at Oliver's expense.

### LABOR

Oliver further warrants that equipment properly installed in accordance with our special instructions, which proves to be defective in material or workmanship under normal use within one (1) year from installation or one (1) year and three (3) months from actual shipment date, whichever date comes first, will be repaired by Oliver or an Oliver Authorized Service Dealer, in accordance with Oliver's published Service Schedule.

For purposes of this warranty, a defective part or defective equipment is a part or equipment which is found by Oliver to have been defective in materials workmanship, if the defect materially impairs the value of the equipment to Buyer. Oliver has no obligation as to parts or components not manufactured by Oliver, but Oliver assigns to Buyer any warranties made to Oliver by the manufacturer thereof.

This warranty **does not** apply to:

1. Damage caused by shipping or accident.
2. Damage resulting from improper installation or alteration.
3. Equipment misused, abused, altered, not maintained on a regular basis, operated carelessly, or used in abnormal conditions.
4. Equipment used in conjunction with products of other manufacturers unless such use is approved by Oliver Products in writing.
5. Periodic maintenance of equipment, including but not limited to lubrication, replacement of wear items, and other adjustments required due to installation, set up, or normal wear.
6. Losses or damage resulting from malfunction.

The foregoing warranty is in lieu of all other warranties expressed or implied AND OLIVER MAKES NO WARRANTY OF MERCHANTABILITY OR FITNESS FOR PURPOSE REGARDING THE EQUIPMENT COVERED BY THIS WARRANTY. Oliver neither assumes nor authorizes any person to assume for it any other obligations or liability in connection with said equipment. OLIVER SHALL NOT BE LIABLE FOR LOSS OF TIME, INCONVENIENCE, COMMERCIAL LOSS, INCIDENTAL OR CONSEQUENTIAL DAMAGES.



Oliver Packaging & Equipment Company  
511 Sixth Street NW • Grand Rapids, MI 49504

(800) 253-3893  
[www.oliverquality.com](http://www.oliverquality.com)

## WARRANTY PROCEDURE

1. If a problem should occur, either the dealer or the end user must contact the Parts and Service Department and explain the problem.
2. The Parts and Service Manager will determine if the warranty will apply to this particular problem.
3. If the Parts and Service Manager approves, a Work Authorization Number will be generated, and the appropriate service agency will perform the service.
4. The service dealer will then complete an invoice and send it to the Parts and Service Department at Oliver Products Company.
5. The Parts and Service Manager of Oliver Packaging and Equipment Company will review the invoice and returned parts, if applicable, and approve for payment.



Oliver Packaging & Equipment Company  
511 Sixth Street NW • Grand Rapids, MI 49504

(800) 253-3893  
[www.oliverquality.com](http://www.oliverquality.com)

## RETURNED PARTS POLICY

This policy applies to all parts returned to the factory whether for warranted credit, replacement, repair or re-stocking.

Oliver Packaging and Equipment Company requires that the customer obtain a Return Material Authorization (RMA) number before returning any part. This number should appear on the shipping label and inside the shipping carton as well. All parts are to be returned prepaid. Following this procedure will insure prompt handling of all returned parts.

To obtain an RMA number contact the Repair Parts Department toll free at (800) 253-3893.

Parts returned for re-stocking are subject to a **RE-STOCKING CHARGE**.

Thank you for your cooperation,

Repair Parts Manager  
Oliver Packaging and Equipment Company