



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

USER'S OPERATING AND INSTRUCTION MANUAL

MODEL 1708-N

SELF-ACTUATING TRAY LIDDER



1708 SELF-ACTUATING LIDDER

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1708 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.

NOTE

- **DO NOT ACTUATE MACHINE WITHOUT A TRAY HOLDER IN PLACE.** Personal harm and damage to the machine may occur if the machine is actuated without a tray carrier in place.

CAUTION

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



- Always make sure the unit has been unplugged from power and air before cleaning or servicing.
- In addition to these general safety instructions, follow the specific instructions given throughout this manual.



1708 SELF-ACTUATING LIDDER

SET UP

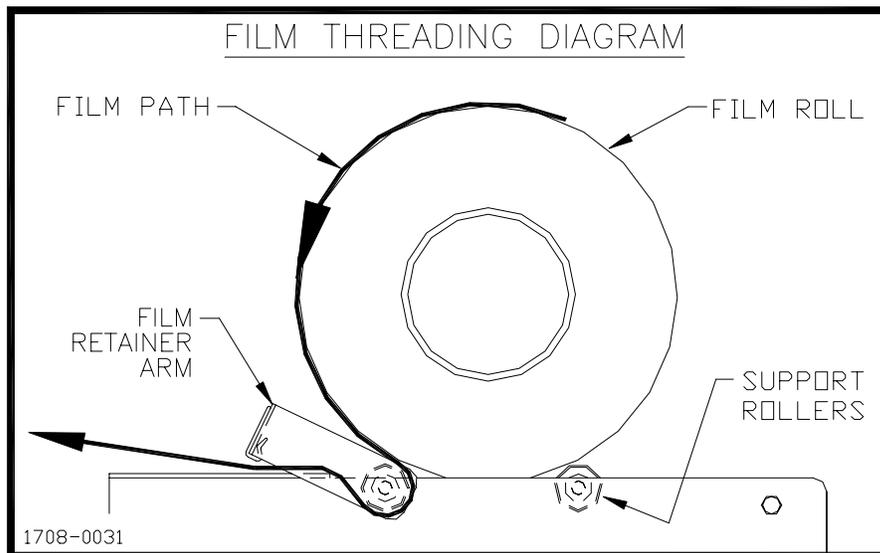
1. Unpack and carefully remove the *Self-Actuating Lidder*. Check for completeness of your order and that none of the items have been damaged during shipment. Save packing material for future shipping.
2. Place the *Self-Actuating Lidder* in a suitable location that provides adequate working space. The location must be sturdy, level, and capable of holding 175 lbs. per machine. For maximum efficiency of the *Self-Actuating Lidder* use the *Workstation Stand* option.
3. Use a quick detachable coupler with one way shut-off, connect air pressure to the 1/4" NPT female fitting located on the filter/regulator. The *Self-Actuating Lidder* requires a minimum of 1 CFM at 90 PSI. If needed an *Air Compressor* option is available for the *Self-Actuating Lidder*.

NOTE

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

NOTE

- **DO NOT CONNECT TO AIR PRESSURE ABOVE 150 PSI.**
4. Plug the power cord into a grounded electrical outlet. The *Self-Actuating Lidder* requires single phase 90 to 130 VAC, 60 Hertz with 10 ampere (minimum) circuit breaker protection.
 5. To install the tray carrier, completely extend the tray carrier supports to their locked position. Position the tray carrier over the tray carrier supports with the retractable pins facing up and the knob facing forward. Lower the tray carrier into position while locating the four tray carrier holes on the four tray carrier support pins.
 6. Load and thread lid dispenser as shown below.

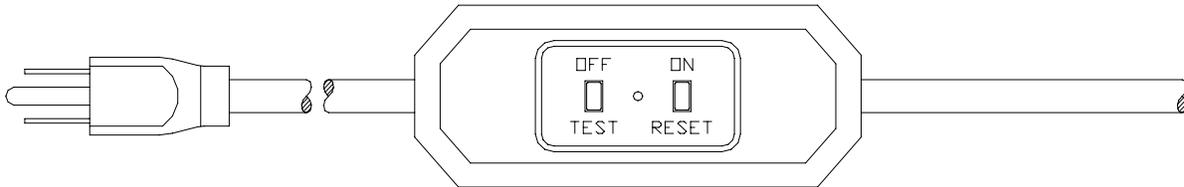




1708 SELF-ACTUATING LIDDER

OPERATING PROCEDURE

1. Switch the heater power switch on by firmly pressing the “ON/RESET” button located on the yellow power cord. A small yellow light in the center of the switch will illuminate indicating the power is on. Wait approximately 40 minutes to allow the heated upper platen time to stabilize at the working temperature.



2. Place a tray in the tray carrier and 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 against the tray.

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.
3. 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.
 4. Remove the lidded tray by rotating the knob on the front of the tray carrier.



1708 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

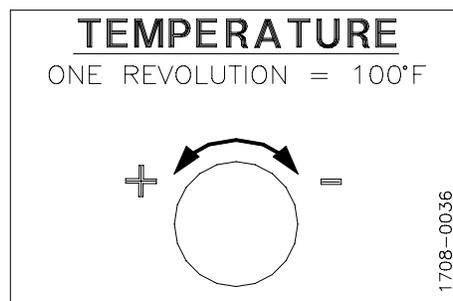
When checking for a good seal look for seal completeness and reasonable seal strength. A poor seal will occur if the product in the tray contaminates the tray flanges. Moisture will have the same negative affect. Trays that have irregular flanges or are deformed also seal poorly. Defective trays should 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 black knob on the top of the filter/regulator and rotate until the gauge shows the desired pressure (40 PSI min.). Push the black knob back down to lock. The knob may be removed to assure tamper resistance.

DWELL TIME: The dwell time adjustment knob is on the top of the control box located on the right side 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.

TEMPERATURE: The temperature of the heated upper platen can be adjusted through an access hole on the back side of the heater cover. Use a slotted blade screwdriver to make the adjustment.



NOTE

- **DO NOT** remove the adjusting sleeve or turn it in farther than necessary for the desired setting. This action will permanently damage the thermo-switch. 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.



1708 SELF-ACTUATING LIDDER

TECHNICAL SPECIFICATIONS

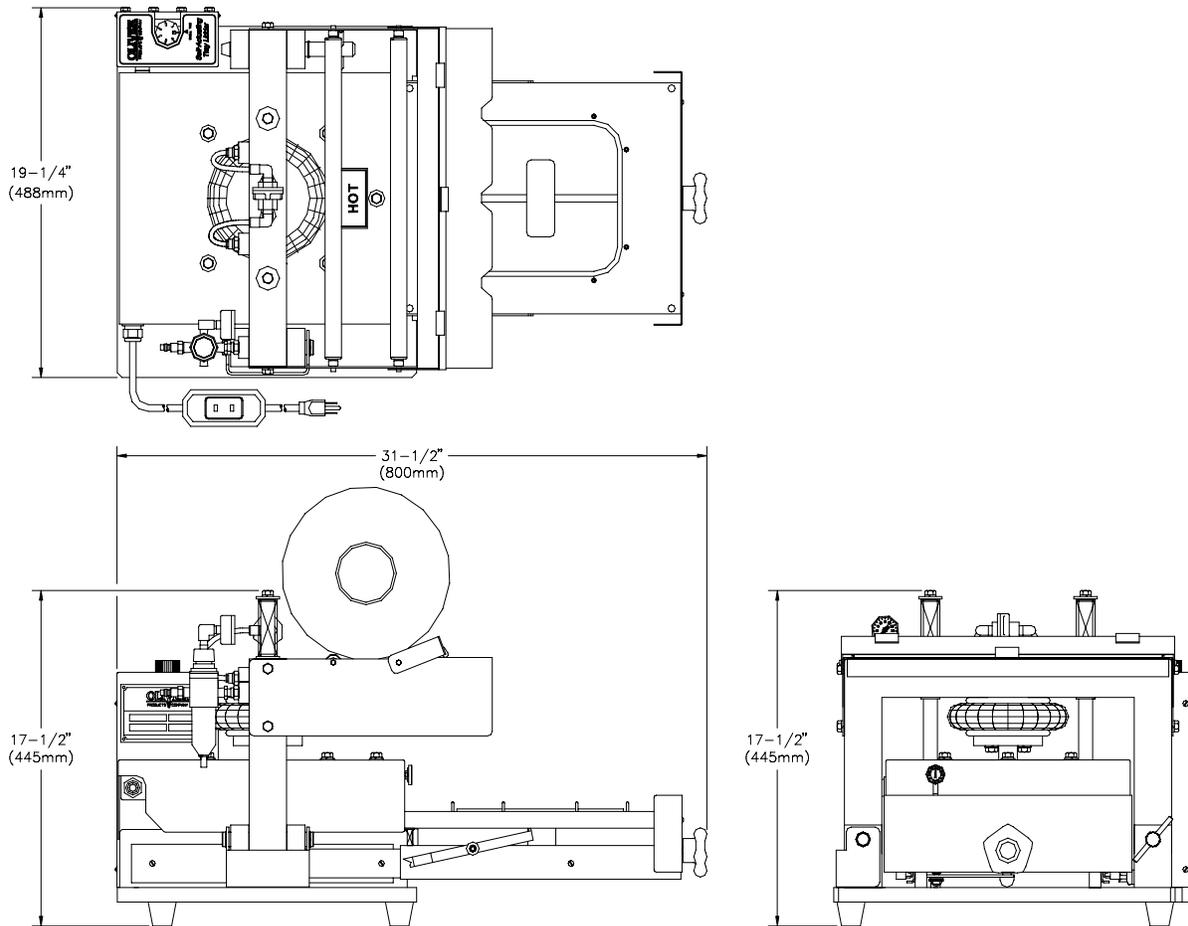
Tray Capacities:

10" (254mm) by 12" (305mm) maximum top outside-dimension tray.

Temperature Range:

50°F (10°C) to 400°F (204°C)

Machine Dimensions:



Weight:

155 lbs. (70.4 kg)

Electrical:

120 VAC, 9 Amps, Single Phase, 50/60 Hz **OR**
240 VAC, 5 Amps, Single Phase, 50/60 Hz Air:
100 PSI at 0.5 CFM minimum, 150 PSI maximum

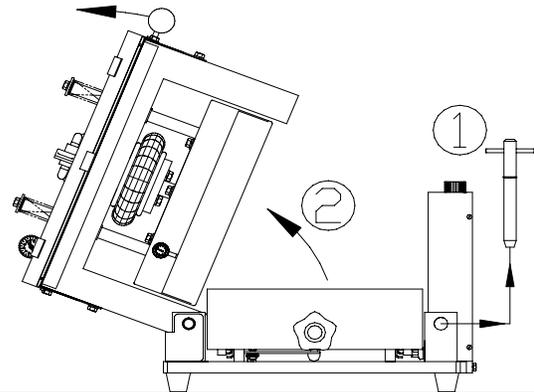


1708 SELF-ACTUATING LIDDER CLEANING

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

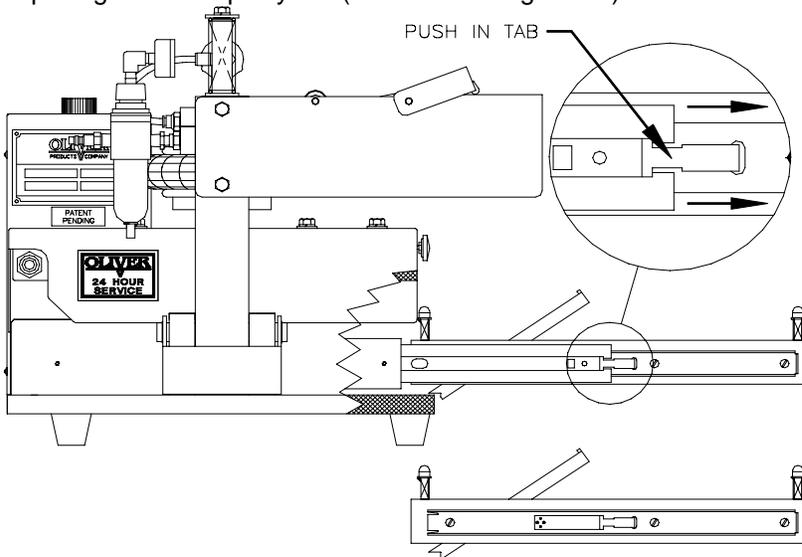
CAUTION

- **CAUTION HOT:** The heater cover and upper platen are very **HOT!** Caution must be used to protect yourself and others.
- 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 pin on the right side of the arch support and carefully rotate the entire arch assembly counter clockwise. Do not release the arch assembly until it is resting securely against the arch stop. A round knob on the right side of the arch support is provided as a handle specifically for this task. Be sure that the removable arch support pin is fully engaged when replacing it.



CAUTION

- **MAKE SURE UNIT IS SECURE AND WILL NOT TIP OVER**
- Use an abrasive scrubbing pad and a mild cleaner to clean the heated upper platen.
- To remove tray carrier slides for cleaning, remove tray carrier, press and hold the locking tab and pulling slide completely out (refer to drawing below).





1708 SELF-ACTUATING LIDDER

MAINTENANCE

- If the machine has been operating, allow the unit to cool before working on it.

CAUTION

- **CAUTION HOT:** The heater cover and upper platen are very **HOT!** Caution must be used to protect yourself and others.
- Always make sure the machine has been unplugged from power and air before servicing.
- The machine is to be serviced by authorized personnel only.
- Use only factory authorized replacement parts.
- To prevent damage to the pneumatic components drain the filter/regulator bowl frequently.

TROUBLE SHOOTING

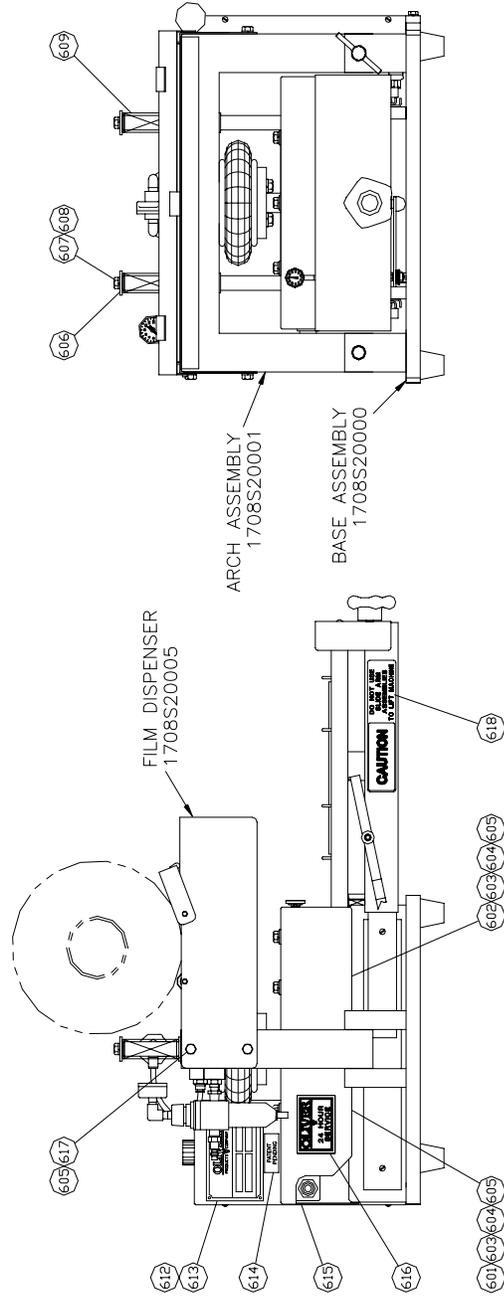
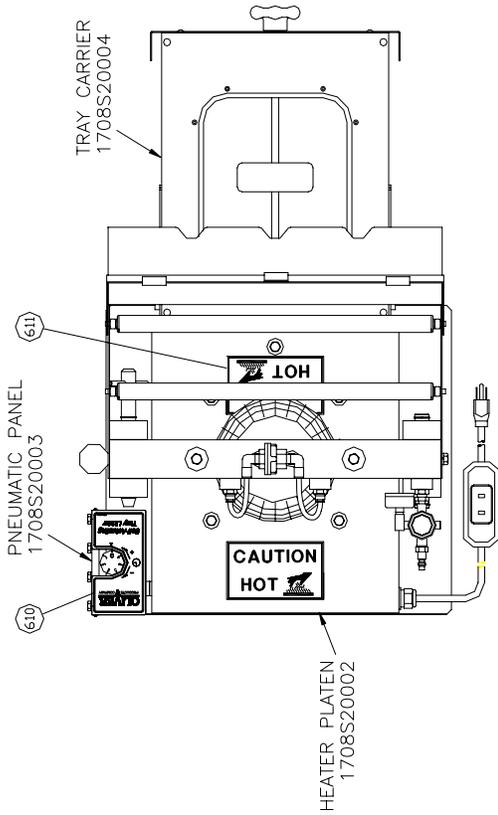
Symptom	Corrective Action
Heater won't power up	<ol style="list-style-type: none">1. Verify that the power cord is plugged in.2. Press "ON/RESET" on power cord switch3. Press Reset on Circuit Breaker
Heated upper platen won't cycle	<ol style="list-style-type: none">1. Verify that the air line is plugged in.2. Verify air pressure at the filter/regulator
Lid folding, shifting or sliding off in the machine	<ol style="list-style-type: none">1. Verify that the adhesive side of lid is down.2. Verify that the trays are not over filled.3. Clean the heated upper platen.
Poor seal quality	<ol style="list-style-type: none">1. Verify the regulated pressure setting.2. Verify the temperature setting.3. Verify the dwell time setting.4. Clean the heated upper platen.

Oliver Products Company 24 HR Emergency Service 1 800 554-5603



1708 SELF-ACTUATING LIDDER FINAL ASSEMBLY

ITEM	PART NUMBER	DESCRIPTION	QUANTITY
601	1708-0003-1002	BACK HEATER PLATEN SHIELD	1
602	1708-0003-1001	FRONT HEATER PLATEN SHIELD	1
603	5843-1031	SCREW-HEX HD 5/16-18 x 1-1/4	5
604	5851-9305	WASHER-FLAT 5/16	8
605	5851-9358	WASHER-LOCK 5/16	8
606	4555-0314-1001	WASHER-FLAT HEAVY	2
607	5841-9059	SCREW-HEX HD 3/8-16 x 1-3/4	2
608	5851-9359	WASHER-LOCK 3/8	2
609	7015-5201	SPRING-COMPRESSION	2
610	1708-0019	NAMEPLATE-MODEL 1708	1
611	6400-3017	LABEL-"CUATION HOT"	2
612	6401-5048	NAMEPLATE-TECHNICAL DATA	1
613	5840-3501	RIVET-1/8 STAINLESS	4
614	6401-6002	LABEL-"PATENT PENDING"	1
615	1708-0036-1	LABEL-"TEMPERATURE ADJUST"	1
616	6401-5066	NAMEPLATE-24HR. SERVICE NO.	1
617	5843-1026	SCREW-HEX HD 5/16-18 x 1-1/4	3
618	6400-3018	NMPLT-"CAUTION-DD NOT USE..."	1

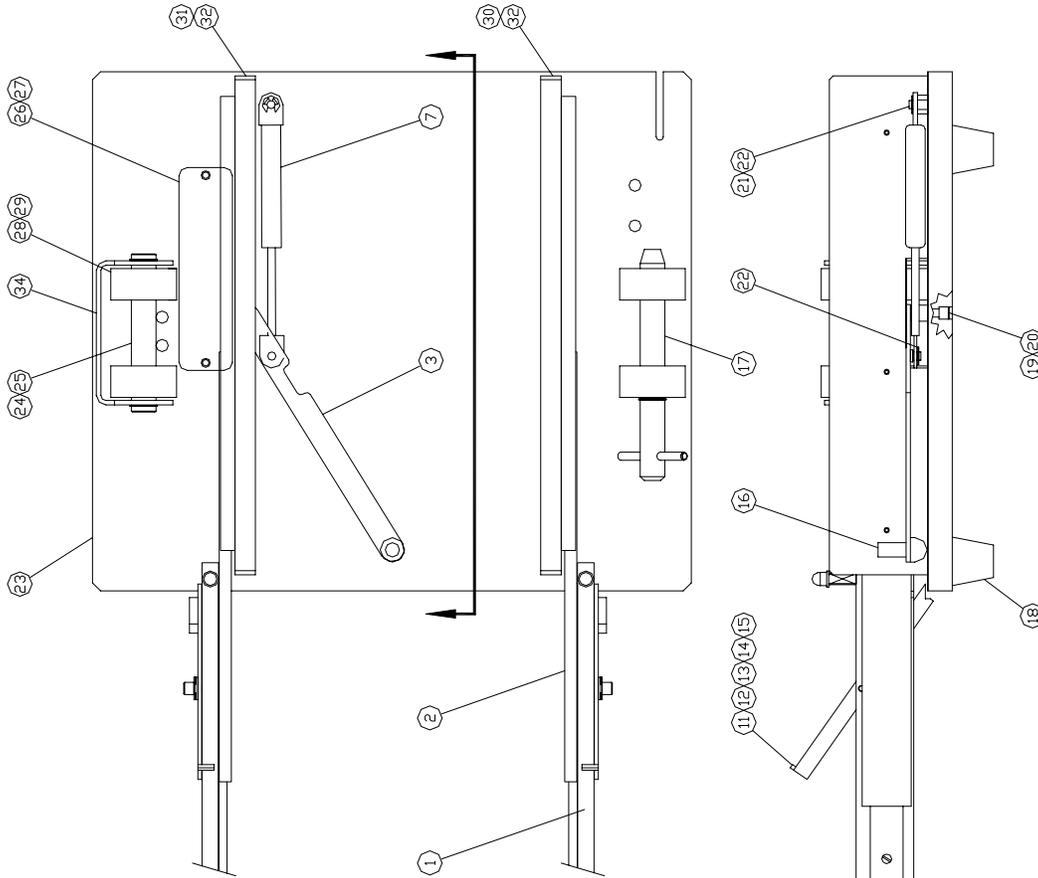


Rev. 11/5/96



1708 SELF-ACTUATING LIDDER

BASE ASSEMBLY



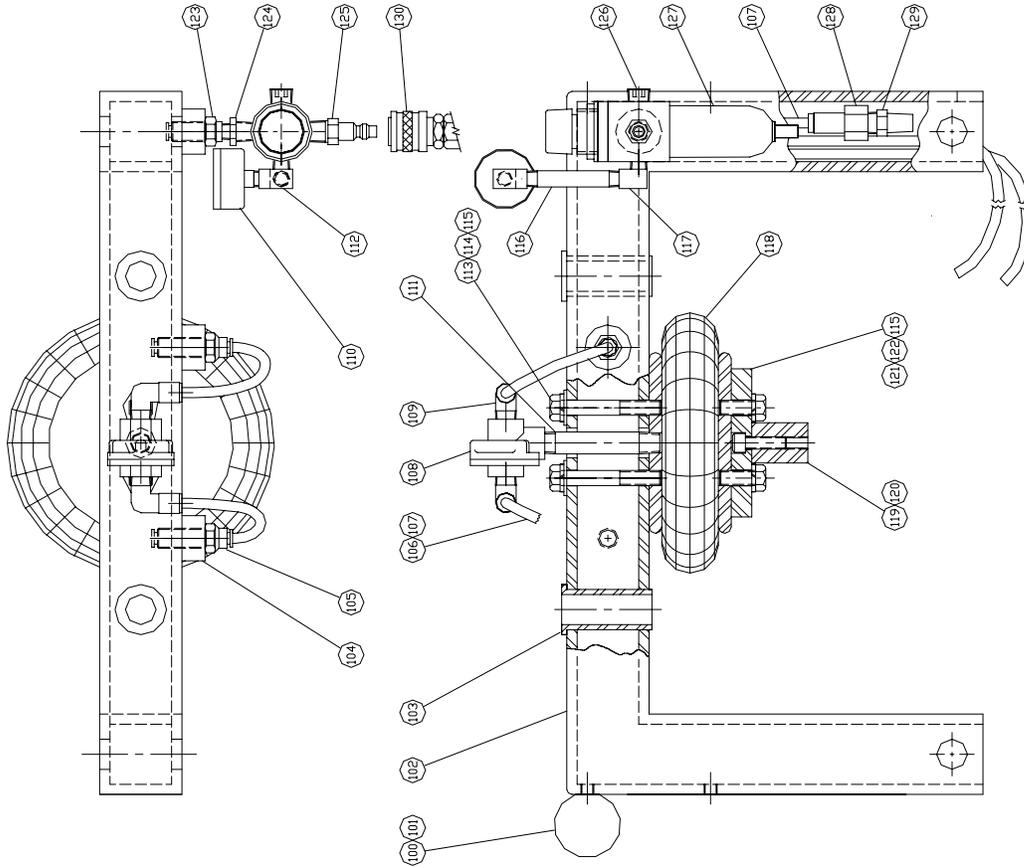
ITEM	PART NUMBER	DESCRIPTION	QUAN.
1	1708-0002	PLATE-OUTSIDE SLIDE	2
2	1708-0063	SLIDE-14" DRAWER (PAIR)	1PR
3	1708-0023	LEVER-TRAY HOLDER EJECT	1
7	6084-8704	SPRING-GAS SHOCK 13#	1
8	1708-0035	PIN-QUICK CHANGE	4
9	5851-9304	WASHER-FLAT 1/4"	4
10	7012-3006	SPRING-COMP. 0.3600D x .040 x 1-3/8	4
11	1708-0033-0001	SAFETY STOP-SLIDE (RIGHT)	1
12	1708-0033-0002	SAFETY STOP-SLIDE (LEFT)	1
13	5842-8947	SCREW-SHOULDER 1/4 DIA. x 1/4"	2
14	5851-8120	WASHER-NYLON 1/4"	2
15	5851-9304	WASHER-FLAT 1/4"	2
16	1708-0024	PUSHER-TRAY HOLDER EJECT	1
17	1708-0053	PIN-REMOVABLE	1
18	5918-6633	BUMPER-RUBBER	4
19	1708-0025	SPACER-LEVER	1
20	5842-8989	SCREW-SHOULDER 1/4 DIA. x 1"	1
21	1708-0026	SPACER-GAS SPRING	1
22	5840-1273	E-CLIP RETAINING RING	2
23	1708-0001	PLATE-BASE	1
24	0623-0014-1	PIN-STATIONARY	1
25	5840-1668	RING-RETAINING	2
26	1708-0034	COVER-PNEUMATIC TUBING	1
27	5843-5040	SCREW-FLAT HD #6-32 x 1/4"	2
28	1707-0012	BLOCK-ARCH MOUNTING	4
29	5843-1564	SCREW-HX SDC HD 3/8-16 x 1"	8
30	1708-0009-0001	PLATE-SLIDE MTG (RIGHT)	1
31	1708-0009-0002	PLATE-SLIDE MTG (LEFT)	1
32	1708-0009-0004	MODIFIED PLATE-SLIDE MTG (LEFT)	1
33	5843-1555	SCREW-HX SDC HD 5/16-18 x 1"	8
34	5843-2220	SCREW-SET #10-32 NLYN TIP	4
34	1708-0054	STOP-OPENED ARCH	1

*FOR LARGE DEEP TRAY OPTION



1708 SELF-ACTUATING LIDDER

ARCH ASSEMBLY

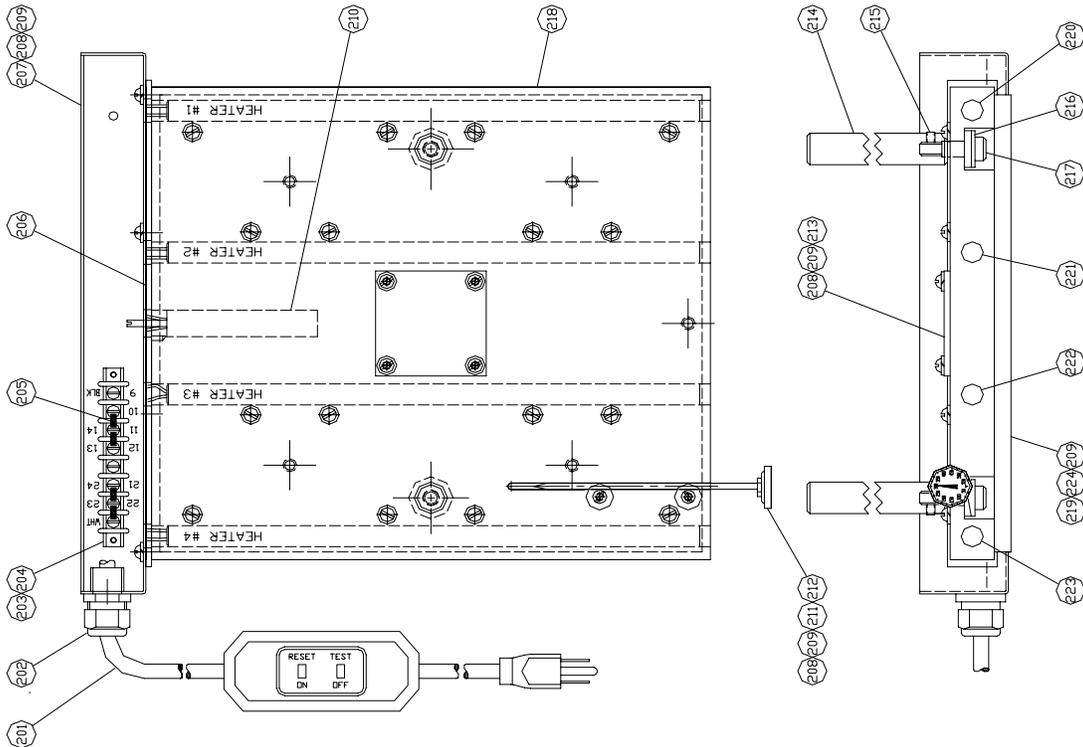
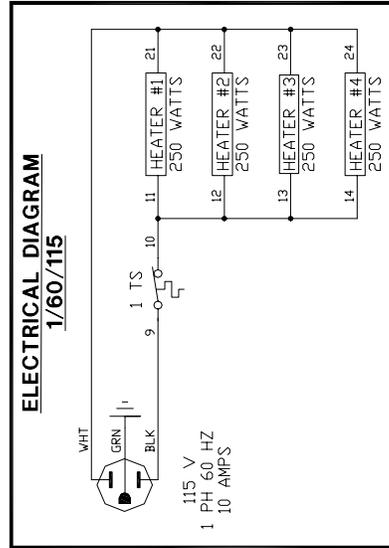


ITEM	PART NUMBER	DESCRIPTION	QUAN.
100	5911-7111	KNIB-BALL 1-5/8" REID #B29	1
101	5843-2058	SCREW-SUCSET 5/16-18 X 1.25	1
102	1708-0030	ARCH SUPPORT	1
103	1707-0007	BUSHING-GUIDE	2
104	1708-0042	SPACER-BULKHEAD FITTINGS	3
105	5115-1791	FITTING-BULKHD UNION 1/4 TUB'G	2
106	5146-9077	TUBING-5/32 DIA. X 4' LG	1
107	5146-9079	TUBING-1/4 DIA.	68'
108	5148-6612	VALVE-QUICK EXHAUST	1
109	5115-6295	ELBDW-90° 1/4NPT 1/4TUBE	2
110	5118-0533	GAUGE-1/8NPT (0-160 PSID)	1
111	5115-1621	NIPPLE-1/4 NPT X 3' LG	1
112	5115-1011	ELBDW-90° UNION 1/8NPT	1
113	5843-1061	SCREW-HEX HD 3/8-16X2-3/4	2
114	5851-9306	FLAT WASHER 3/8"	2
115	5851-9359	SPRING LOCK WASHER 3/8"	4
116	5115-1625	NIPPLE-1/8 NPT X 2-1/2 LG.	1
117	5115-1002	ELBDW-90° STREET 1/8NPT	1
118	5143-2000	SPRING-AIR BELLOW	1
119	1707-0010	PUSHER-UPPER PLATEN	1
120	5843-1555	SHCS 5/16-18 X 1"	1
121	1707-0009	PLATE-AIR BELLOW	1
122	5843-1055	HEX SCREW 3/8-16 X 1-1/4	2
123	5115-1795	FITTING-BULKHD 1/8NPT - 1/4 TUBE	1
124	5115-1450	REDUCER-1/4 NPT - 1/8 NPT	1
125	5136-4204	DISCONNECT COUPLER 1/4 NPT	1
126	5115-1427	PLUG-1/8 NPT HX SOCKET	1
127	5139-0807	FILTER/REGULATOR-1/4NPT	1
128	5115-1761	FITTING-1/4FNPT - 1/4 TUBE	1
129	5130-7035	MUFFLER-1/4 NPT	1
130	5142-9510	SOCKET-DISCONNECT COUPLER	1



1708 SELF-ACTUATING LIDDER HEATER PLATEN ASSEMBLY

ITEM	PART NUMBER	DESCRIPTION	QUAN
201	1708-0027-1	CORD-PWR W/GND FAULT	1
202	5770-4818	STRAIN RELIEF-GRIP 3/8-1/2	1
203	5770-7460	TERMINAL BLOCK-8 PDS	1
204	5831-9083	NUT-FLEXLOCK MACH. #6-32	2
205	5770-7461	TERMINAL JUMPER	4
206	5501-7930	INSULATOR PLATE	1
208	5843-5238	ENCLOSURE-ELECTRICAL	1
209	5851-9355	SCREW-RND HD #10-24 x 1/2	10
210	1708-0060	WASHER-SPRING LOCK #10	26
211	5920-6003	THERMOMETER	1
212	5851-9302	WASHER-FLAT #10	2
213	68839	PLATE-PUSHER	1
214	1707-0008	SHAFT-GUIDE	2
215	5843-2021	SCREW-SID SET CUPPT #10-24 x 1/4	2
216	5851-9403	WASHER-SPHERICAL	2
217	5842-8987	SCREW-SHLDR 3/8-16 x 3/4	2
218	1708-0006-1	PLATE-HEATER PLATEN	1
219	5843-5244	SCREW-RND HD #10-24 x 1-1/4	16
220	1708-0056	CARTRIDGE-HEATER #1	1
221	1708-0057	CARTRIDGE-HEATER #2	1
222	1708-0058	CARTRIDGE-HEATER #3	1
223	1708-0059	CARTRIDGE-HEATER #4	1
224	1708-0004	PLATE-UPPER PLATTEN (STD.)	1
	1708-0004-002	PLATE-UPPER PLATTEN (MAX.)	1



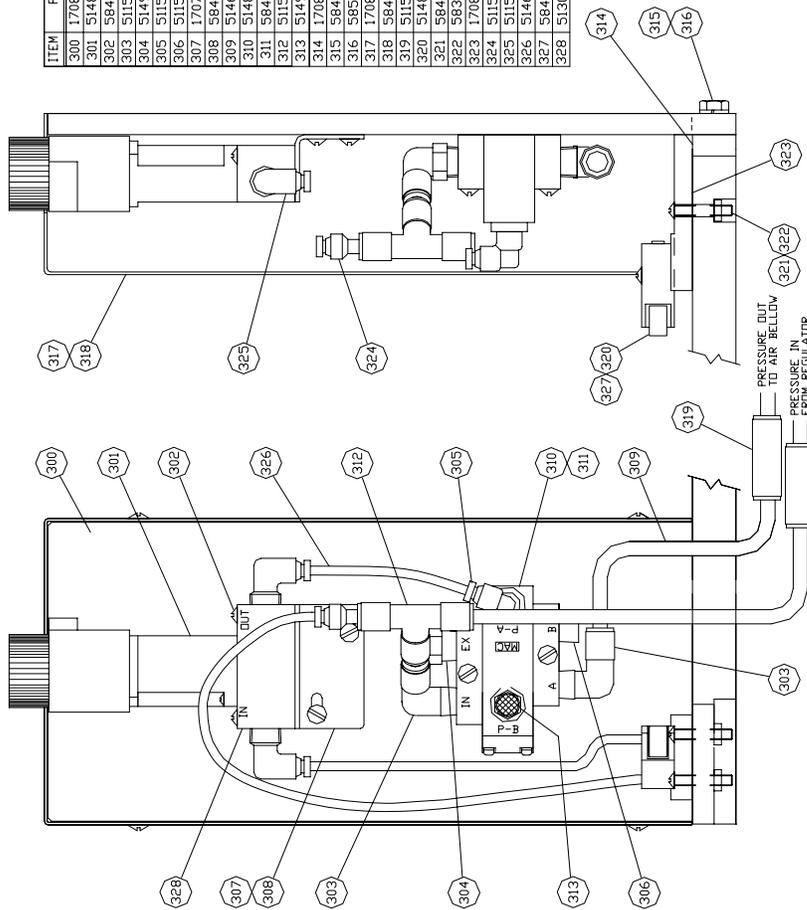
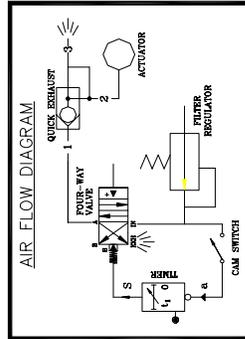
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1708 SELF-ACTUATING LIDDER

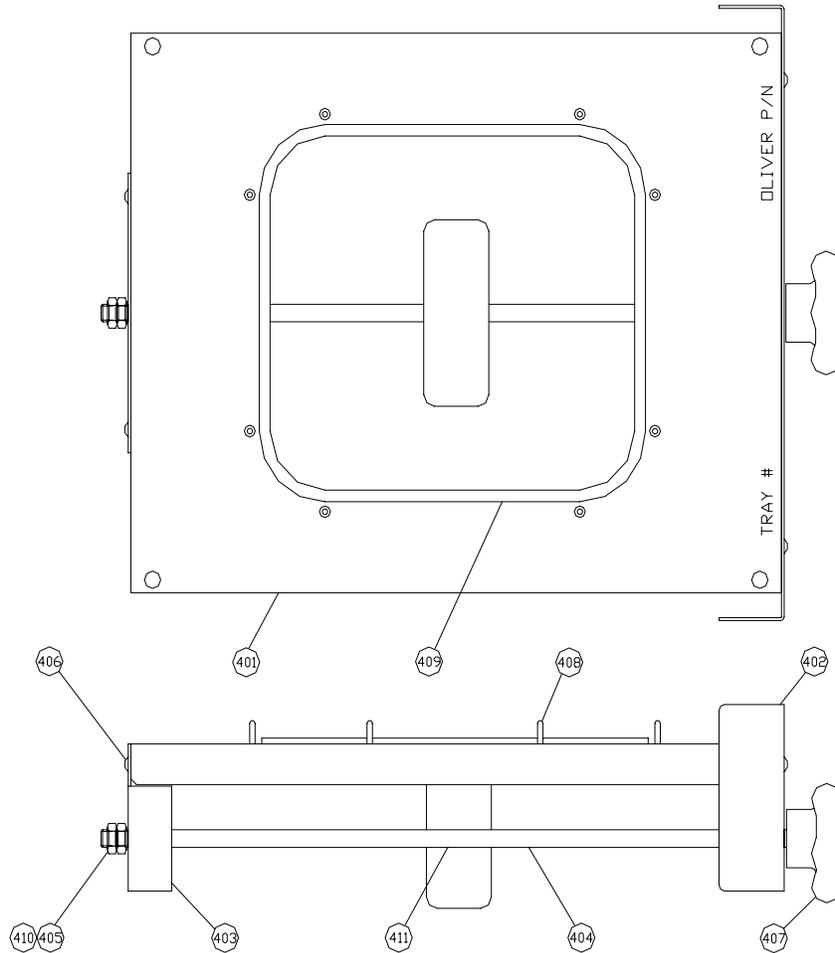
PNEUMATICS ASSEMBLY

ITEM	PART NUMBER	DESCRIPTION	QUAN.
300	1708-0010	PLATE-PNEUMATIC PANEL	1
301	5148-6510	TIMER-PNEUMATIC	1
302	5843-5233	SCREW-RND HD #8-32 x 1-1/4	2
303	5115-6295	ELBOW-90° 1/4NPT TO 1/4TUBE	2
304	5149-0203	BREATHER VENT-1/4NPT	1
305	5115-1767	ELBOW-90° 1/8NPT TO 5/32TUBE	1
306	5115-1767	PLUG-HX SOCKET 1/4NPT	1
307	1707-0004	BRACKET-PNEUMATIC TIMER	1
308	5843-5237	SCREW-RND HD #10-24 x 3/8	2
309	5146-9079	TUBING-POLYETHYLENE 1/4 DIA 60°	1
310	5148-7116	VALVE-4 WAY REMOTE	1
311	5843-5244	SCREW-RND HD #10-24 x 1-1/4	2
312	5115-1781	TEE-3 WAY UNION 1/4TUBE	1
313	5149-0202	BREATHER VENT-1/8NPT	1
314	1708-0022	SPACER-PNEUMATIC PANEL	1
315	5843-1006	SCREW-HEX HD 1/4-20 x 1-1/4	4
316	5851-9357	WASHER-SPRING LOCK 1/4"	4
317	1708-0048	COVER-PNEUMATIC PANEL	1
318	5843-5562	SCREW-TRS HD #8-32 x 3/8	4
319	5115-1760	UNION-STRAIGHT 1/4TUBE	2
320	5148-5339	LIMIT SWITCH-KNPP 5/32OD	1
321	5843-5242	SCREW-RND HD #10-24 x 1"	2
322	5831-8192	NUT-SQUARE #10-24	2
323	1708-0047	MOUNTING BRKT-LIMIT SWITCH ADJUST	1
324	5115-5517	REDUCER-1/4TUBE TO 5/32TUBE	1
325	5115-1774	ELBOW-90° 1/4NPT TO 5/32TUBE	2
326	5146-9077	TUBE-POLYETHYLENE 5/32 DIA 129"	1
327	5843-5227	SCREW-RND HD #8-32 x 3/4	2
328	5130-0021	MANIFOLD-TIMER	1





1708 SELF ACTUATING LIDDER TRAY CARRIER ASSEMBLY



ITEM	PART NUMBER	DESCRIPTION	QUAN.
401	1708-0020-XXX	TRAY HOLDER	1
402	1708-0005-XXX	SHIELD-TRAY HOLDER	1
403	1708-0011-XXX	PLATE-ROD SUPPORT	1
404	1708-0012-XXX	TRAY EJECTOR	1
405	5832-0502	NUT-JAM 3/8-16	1
406	5843-5224	SCREW 8-32x3/8 RND HD	5
407	6824-3068	KNOB 3/8-16 THD	1
408	1508-0033	STOP-LOCATING SPRING PIN	-
	6513-0615 (OR)	RUBBER-1/8 SILICONE SHEET	-
409	6513-0614 (OR)	RUBBER-1/16 SILICONE SHEET	-
	6514-0502	RUBBER-3/16DIA SILICONE CORD	-
	6516-0024	CUSHON EXTRUDED SILICON BLACK	-
410	5832-0522	NUT-FULL 3/8-16	1
411	5400-1817	SILICONE CUALK-CLEAR	-

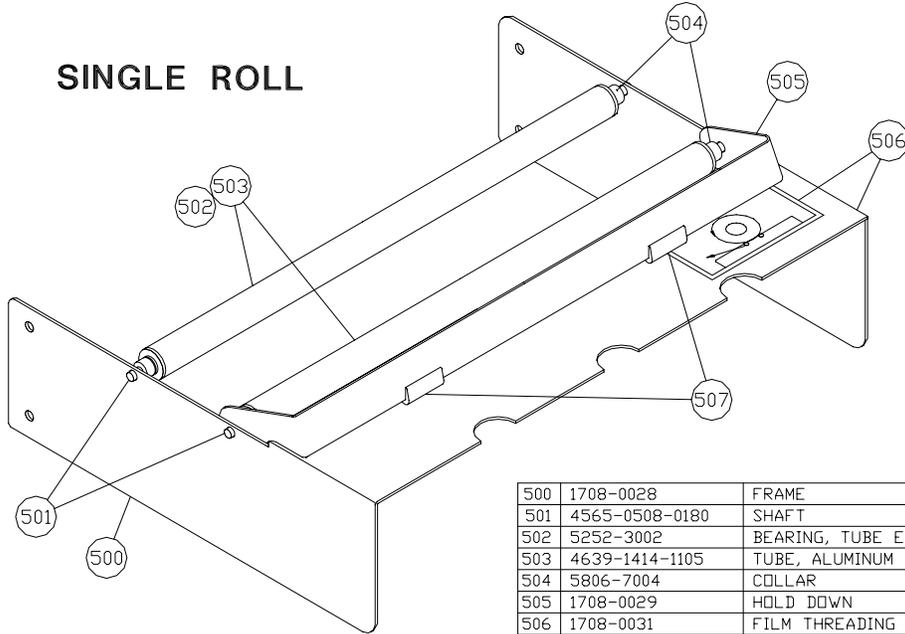
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1708 SELF-ACTUATING LIDDER

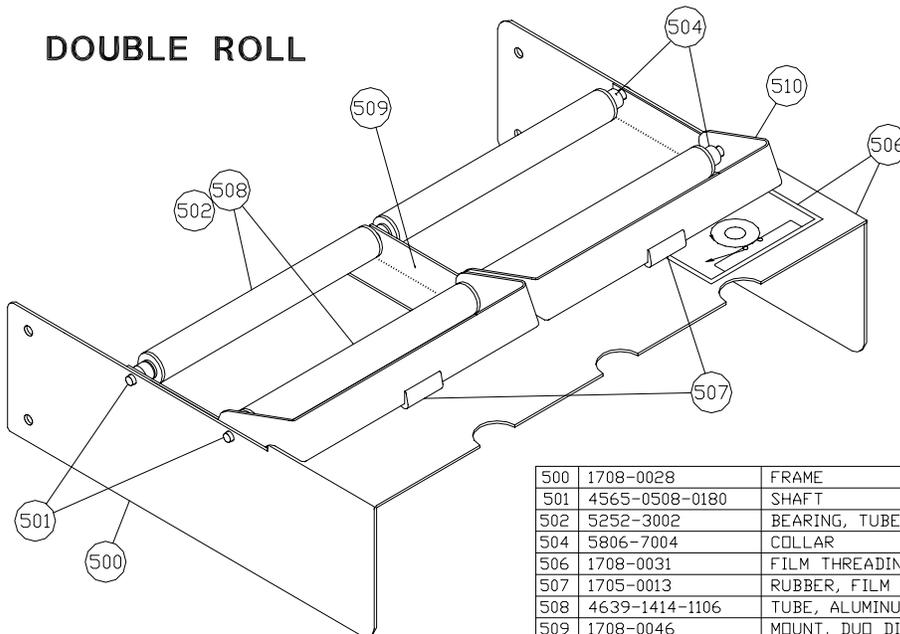
FILM ROLL DISPENSER ASSEMBLY

SINGLE ROLL



500	1708-0028	FRAME	1
501	4565-0508-0180	SHAFT	2
502	5252-3002	BEARING, TUBE ENDCAP	4
503	4639-1414-1105	TUBE, ALUMINUM	2
504	5806-7004	COLLAR	4
505	1708-0029	HOLD DOWN	1
506	1708-0031	FILM THREADING DIAGRAM	2
507	1705-0013	RUBBER, FILM HOLD	2

DOUBLE ROLL



500	1708-0028	FRAME	1
501	4565-0508-0180	SHAFT	2
502	5252-3002	BEARING, TUBE ENDCAP	8
504	5806-7004	COLLAR	4
506	1708-0031	FILM THREADING DIAGRAM	2
507	1705-0013	RUBBER, FILM HOLD	2
508	4639-1414-1106	TUBE, ALUMINUM	4
509	1708-0046	MOUNT, DUD DISPENSER	1
510	1708-0045	HOLD DOWN	2



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

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.



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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