



Walker, Michigan, U.S.A. 49534-7564

USER'S OPERATION AND MAINTENANCE MANUAL

1808-D

AUTOMATED PACKAGING SYSTEM

1808-D

INDEX

<u>Section Description</u>	<u>Document No.</u>	<u>Page No.</u>
INTRODUCTION -----	1808S20051 -----	1-1
SAFETY INSTRUCTIONS -----	1808S20052 -----	2-1
Nameplates-----		2-4
DESCRIPTION/SPECIFICATIONS -----	1808S20053 -----	3-1
Description -----		3-1
Specifications-----		3-1
INSTALLATION INSTRUCTIONS -----	1808S20054 -----	4-1
Inspection -----		4-1
Uncrating -----		4-1
OPERATING INSTRUCTIONS -----	1808S20055 -----	5-1
CLEANING INSTRUCTIONS -----	1808S20056 -----	6-1
TRAY CARRIER (CUTOFF) CHANGE -----	1808S20057 -----	7-1
Changing to a tray carrier set with same cutoff as previous set -----		7-2
Changing to a tray carrier set with a different cutoff length than the previous set -----		7-3
MAINTENANCE -----	1808S20058 -----	8-1
RECOMMENDED SPARE PARTS -----	1808S20059 -----	9-1
TROUBLESHOOTING -----	1808S20060 -----	10-1
FRAME AND DRIVE ASSEMBLY -----	1808S20061 -----	11-1
Parts list -----		11-2
LEG ASSEMBLY -----	1808S20062 -----	12-1
Parts list -----		12-2
HEAT SEAL FRAME ASSEMBLY -----	1808S20063 -----	13-1
Parts list -----		13-2
HEAT SEAL ROLL ASSEMBLY (120V) -----	1808S20064 -----	14-1
Parts list -----		14-2
HEAT SEAL ROLL ASSEMBLY (208-240V) -----	1808S20064 -----	14-3
Parts list -----		14-4
DISCHARGE ASSEMBLY -----	1808S20065 -----	15-1
Parts list -----		15-2
FILM MANDREL ASSEMBLY -----	1808S20066 -----	16-1
Parts list -----		16-2

Continued

1808-D

ELECTRICAL ASSEMBLY (120V) -----	1808S20067 -----	17-1
Parts list -----		17-2
ELECTRICAL ASSEMBLY (208-240V) -----	1808S20067 -----	17-3
Parts list -----		17-4
WIRING DIAGRAM 1/60/120 -----	1808C12014 -----	18-1
WIRING DIAGRAM 2/50-60/208-240 -----	1808C12012 -----	19-1
WARRANTY -----	GEN 040225	
WARRANTY PROCEDURE-----	GEN 040226	
RETURNED PARTS POLICY -----	GEN 040227	

1808-D

INTRODUCTION

Thank you for purchasing your new line of packaging machinery from Oliver Products Company. Your new equipment was specifically designed and manufactured to meet your individual requirements and represents the quality, innovation, and attention to detail that Oliver provides as a continuing process of improving and expanding our products. Please let us know if there is any way we can better serve you or if there is an adaptation to our product that would make it more useful or convenient for your purpose.

1808-D**SAFETY INSTRUCTIONS**

VARIOUS SAFETY DEVICES AND METHODS OF GUARDING HAVE BEEN PROVIDED ON THIS MACHINE. IT IS ESSENTIAL HOWEVER THAT THE MACHINE OPERATORS AND MAINTENANCE PERSONNEL OBSERVE THE FOLLOWING SAFETY PRECAUTIONS. IMPROPER INSTALLATION, MAINTENANCE, OR OPERATION OF THIS EQUIPMENT COULD CAUSE SERIOUS INJURY OR DEATH.

1. Read this manual before attempting to operate your machine. Never allow an untrained person to operate or service this machine.
2. Connect the machine to a properly grounded electrical supply that matches the requirements shown on the electrical specification plate and follow all specifications of local electrical codes.
3. Disconnect and lockout the machine from the power supply before cleaning or servicing.
4. Check and secure all guards before starting the machine.
5. Observe all caution and warning labels affixed to the machine.
6. Use only proper replacement parts.
7. Do not wear loose fitting clothing or loose hair when working near this machine. Shirt tails should be tucked in.
8. Wear proper personal protective safety equipment.
9. Keep Hands away from the moving parts of this machine while it is in operation.
10. In addition to these general safety instructions, also follow the more specific safety instructions given for the different areas of the machine operating instruction manual.
11. Hazardous energy source: Electricity.



DO NOT USE FOR OTHER THAN ORIGINALLY INTENDED PURPOSE.

1808-D



DO NOT USE FOR OTHER THAN ORIGINALLY INTENDED PURPOSE.

Electrics-Theory of Operation

Power supply to machine is:

- 1 line, 1 neutral, 1 ground for 120V machine or
- 2line, 1 ground for 208-240V machine

Supply lines are protected by a:

- 1 pole circuit breaker for 120V machine or
- 2 pole circuit breaker for 208-240V machine

Various electrical control items are protected by fuses in the electrical enclosure.

Heater roll will only heat when **all** the conditions are met;

- Correct power is supplied to machine
- Emergency stop pushbutton released
- Discharge cover is closed
- In-feed gate in place
- Circuit breaker is in reset condition
- Heater roll selector is in the "I" on position
- Temperature control output contact is closed.

Conveyor is started only when **all** these conditions are met;

- Correct power is supplied to machine
- Emergency stop pushbutton released
- Discharge cover is closed
- Infeed gate is in place
- Circuit breaker is in reset condition
- Fuses are intact and in place
- Roll in lowered position (operating handle in sealing position)
- Start pushbutton is momentarily depressed

In the event of a power failure conveyor will only operate after all the above conditions are met. Conveyor will not automatically restart when power is restored.

Continued

1808-D

Heater roll will heat until **any** of the following conditions are met.

- Power supply interrupted
- Heater roll selector is in the “O” off position
- Emergency stop pushbutton depressed
- Discharge cover is opened
- In-feed gate is displaced
- Circuit breaker is in tripped (open) condition
- Fuses opened due to short circuit and/or over-current

Conveyor will operate until **any** of the following conditions are met.

- Power supply interrupted
- Roll in raised position (operating handle in idle position)
- Emergency stop pushbutton depressed
- Discharge cover is opened
- In-feed gate is displaced
- Circuit breaker is in tripped (open) condition
- Fuses opened due to short circuit and/or over-current

DECOMMISSIONING STATEMENT

Please dispose of all materials as suggested in the appropriate MSDS reports at the end of this manual, and as required by your state and local regulations.

Remember to always recycle when possible.

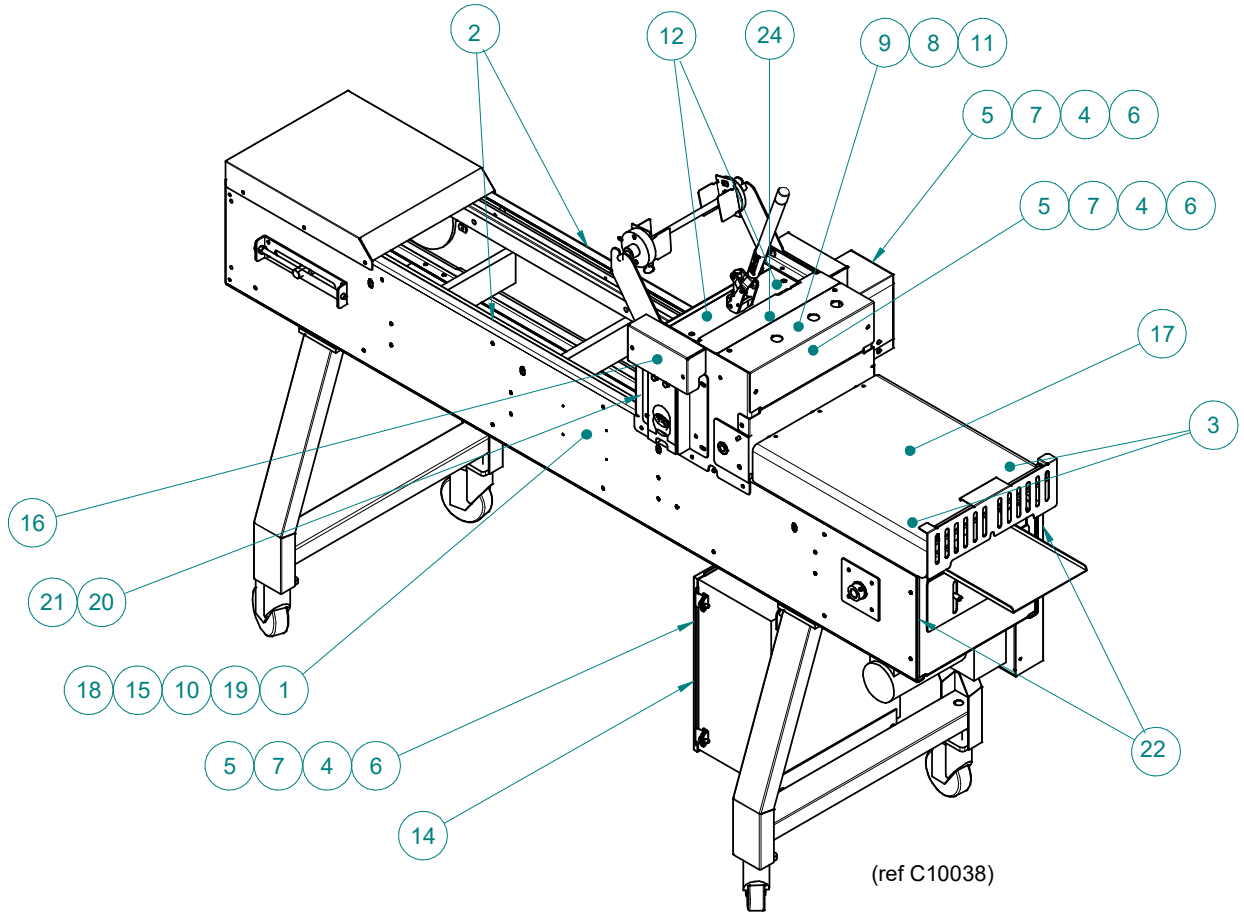


RECYCLE

Continued

1808-D

NAMEPLATES



Continued

1808-D

NAMEPLATES

Item	Part Number	Description	Qty
1	6401-5048	Nameplate-Oliver W/Elec(Print)	1
2	6401-9042	Stay Clear	2
3	6401-9043	Stay Clear	2
4	6400-3029	Consult Manual	3
5	6400-5009	Electrical Shock	3
6	6402-1028	Unplug Before Opening	3
7	6401-4020	No Access For Unauthorized Persons	3
8	6401-9041	Start Of Action	1
9	6400-5011	E-STOP (Yellow Background)	1
10	6402-0030	Possible Shock If Wet	1
11	6400-8010	Heated Roll	1
12	6400-8020	Hot Surface (Large)	4
13	6400-8021	Hot Surface (Small)	2
14	6400-6025	Feed	1
15	6401-3003	Made in USA	1
16	6400-6021	Film Threading Diagram	1
17	6400-4007	Danger Do Not Open	1
18	6400-3006	Caution Per Print	1
19	6401-6038	Maintenance Checklist	1
20	6402-3023	Caution Per Print	1
21	6400-3052	Nmplt-"Caution" Per Print, Sealer Infeed	1
22	6402-3053	Nmplt-"Caution" Per Print, Sealer Outfd M	2
23	6400-8024	Nameplate-Handle Stop Wrap	1
24	6400-8025	Nameplate-Handle Stop Instructions	1

1808-D

Description

The OLIVER Model 1808-D Tray Sealer has been designed and manufactured to provide a machine of very high quality, yet with a cost-effective approach to producing film lidded trays. The Model 1808-D Tray Sealer is designed to heat seal film to paperboard and thermoplastic trays at speeds of up to 25 trays per minute. The machine can be operated wherever an adequate power outlet is available (see power requirements). The machine consists of a continuous motion conveyor system, a film feed station, a heated sealing roll and a film cutter unit. The machine is supplied with casters for ease of relocating. Its design will provide years of efficient, trouble-free operation requiring a minimum of maintenance.

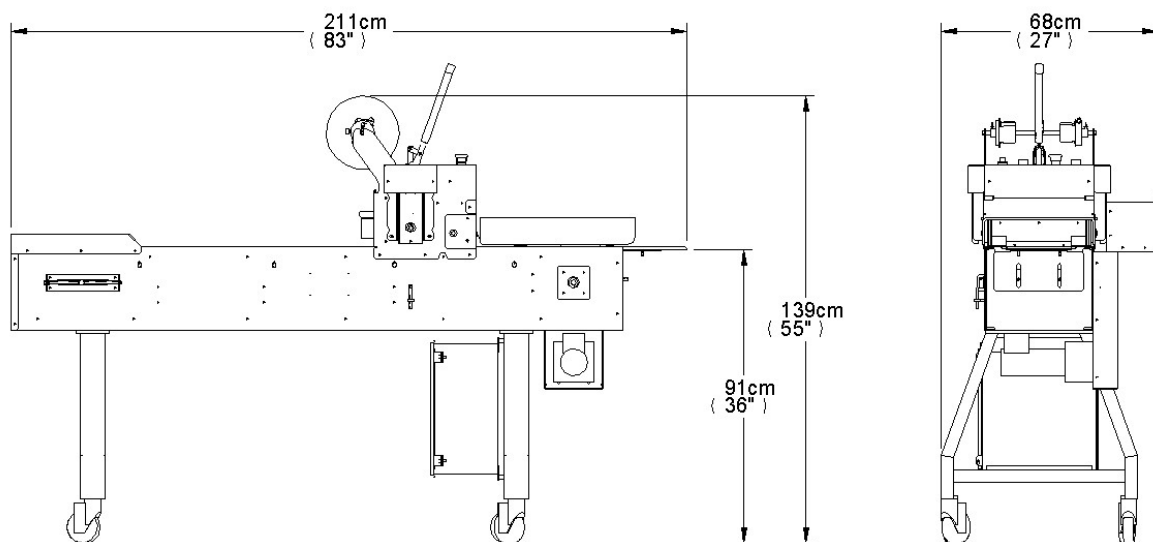
The Model 1808-D Tray Sealer is of stainless, plated, and painted steel construction for easy cleaning and maintenance.

Oliver Products Company, who has a reputation of serving the Food Industry for over 70 years, backs this equipment.

Specifications

Space Requirements:

Model 1808-D (All Dimensions are Approximate)



Continued

1808-D

Standard Electrical Options: (Others consult factory).

1 Phase, 60Hz, 120VAC, 11 Amps
or
1 Phase, 50-60Hz, 208-240VAC, 10 Amps

Net Weight

154 kg (340 lbs.) (approximate)

Shipping Weight

181 kg (400 lbs.) (approximate)

1808-D

INSTALLATION INSTRUCTIONS

INSPECTION

Upon receipt and prior to uncrating, inspect the exterior of the crate for damage. If damage is noted, indicate damage on the Freight Bill and immediately contact the Freight Carrier and notify them of the damage. Have a freight claim filed. This must be done at the Recipients location and not at the Shipper's location.

UNCRATING

Remove the tie-downs and any other materials used in attaching the machine to the skid. Lift the machine off the skid in a safe manner. Remove any tape and plastic tie bands that were used to secure parts for shipment.

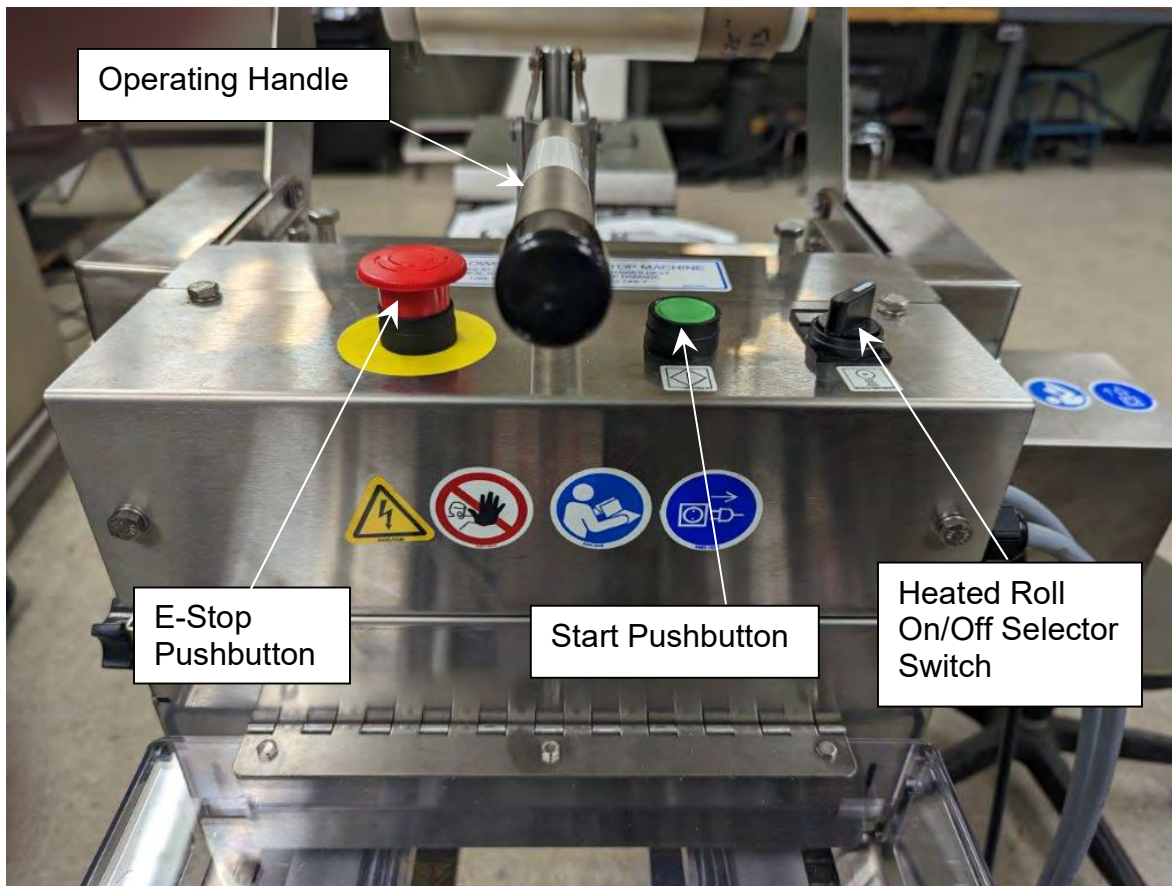
1808-D

OPERATING INSTRUCTIONS

NOTE: Conveyor motion can be stopped at any time by lowering the operating handle or pushing the E-Stop Pushbutton (Emergency only). The E-Stop button will also turn off power to heaters. Under normal operating conditions, conveyor is stopped by Lowering Operating Handle.

Before operating the machine Connect the machine to a properly grounded electrical supply that matches the requirements shown on the electrical specification plate and follow all specifications of local electrical codes.

Once the machine is plugged in, the conveyor can be run using the “Operating Handle” along with the “Start” pushbutton.



Continued

1808-D

The speed control knob is used to adjust the machine speed by turning clockwise to a higher number for higher speed and counterclockwise to a lower number for lower speed.



Before you are ready to run production, turn the Heated Roll “ON/OFF” (I/O) switch to the “ON” (I) position. This will supply power to the heater elements in the heat seal roll to bring it up to temperature. You should turn the power on approximately 20 minutes prior to the time you want to begin production. This will give the heat seal roll ample time to heat up. At the end of the day, turn the “ON/OFF” (I/O) switch to the “OFF” (O) position. **Be sure infeed gate is in place, discharge cover is closed, and E-stop is released for heat seal roll to be energized. Otherwise heat seal roll temperature will not rise and therefore will not seal properly.**

Continued

1808-D

(“OPERATING THE MACHINE “ CONTINUED)

The conveyor can be run while the heated roll “ON/OFF” switch is in the “OFF” position. This allows for cleaning the conveyor without having the heat seal on. It is also a good idea to unplug the machine when it will not be used for a lengthy period.

The machine will stop if the infeed gate interlock switch has been tripped, the discharge cover is opened, or the E-Stop button is pressed. When this situation occurs, set the infeed gate back to its proper position, close the discharge cover and make sure E-Stop button is released (turn anti-clockwise). If the infeed gate has been repositioned properly, the discharge cover is closed and E-Stop button is released (turn anti-clockwise), then the temperature controller display should be active, and machine will be able to operate.

The infeed gate can be removed by pushing forward on the handle and lifting up and out. To replace the guard, drop the guard fingers into the notches and pull the handle so the interlock engages. See the photo below for the location of the guard and interlock switch.

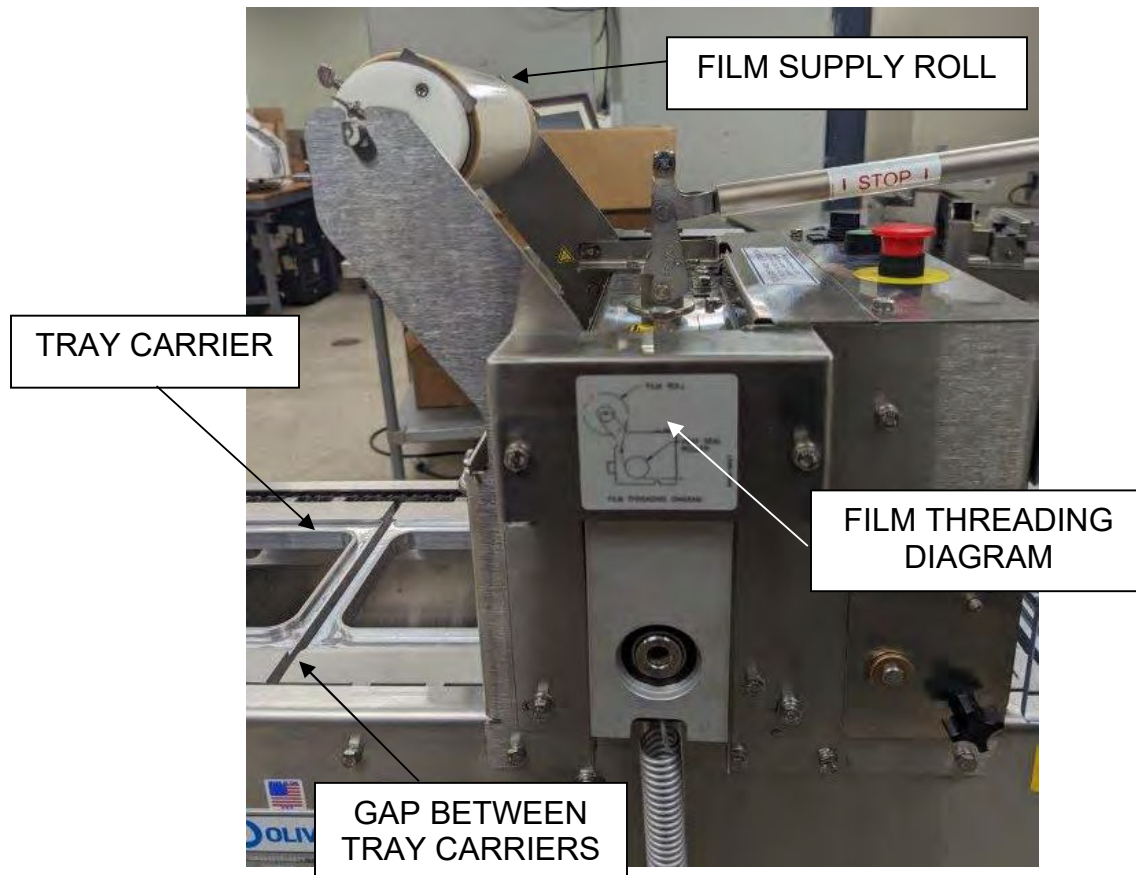


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1808-D

(“OPERATING THE MACHINE” CONTINUED)

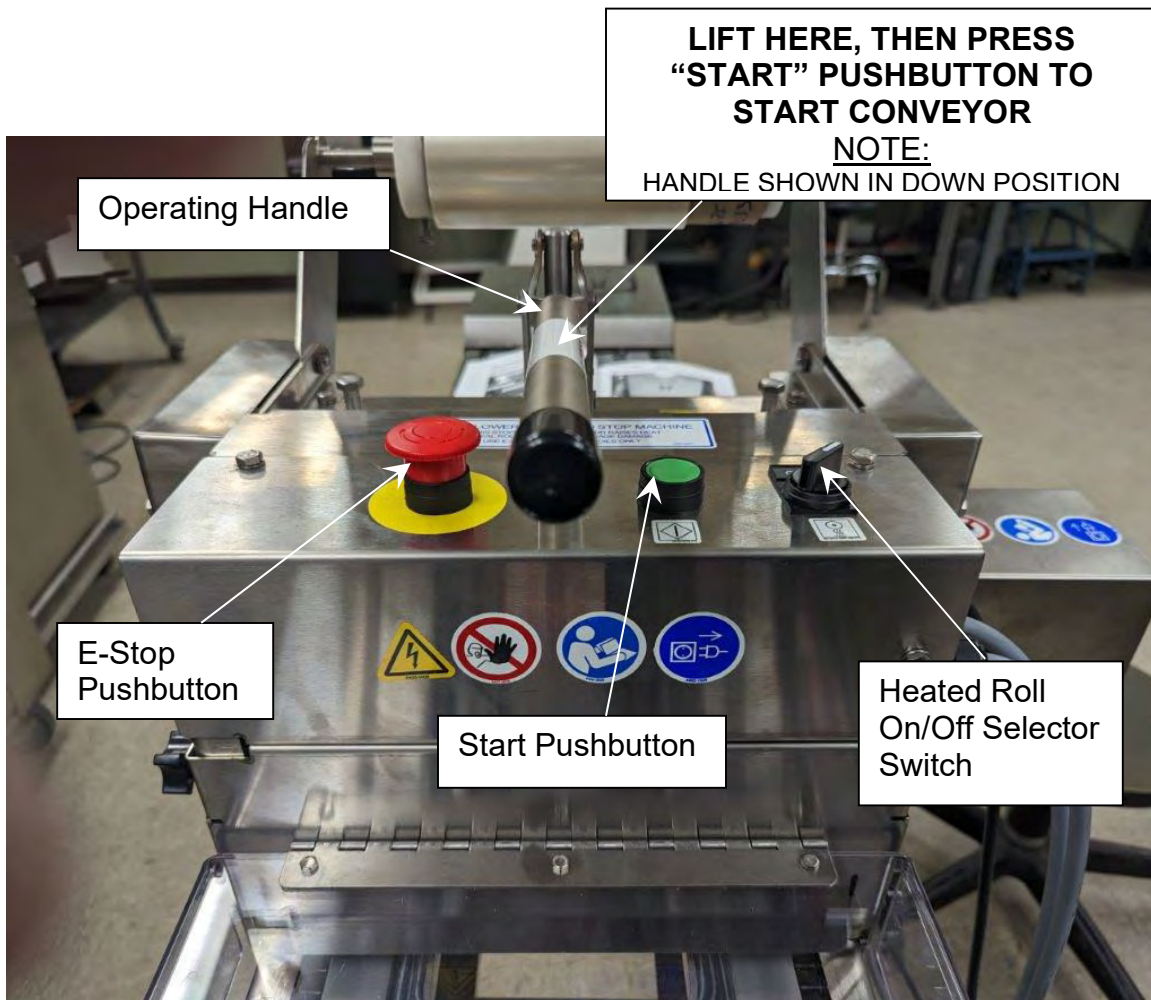
Filled trays are manually placed in the conveyor of the machine. Film is fed from the film supply roll which must be threaded onto the machine as illustrated on the “Film Threading Diagram” which is shown in the photo below. Pull enough film so the film can be pushed down in the gap between the tray carriers. The film should hang down through the carriers about 4 to 5 inches.



Continued

1808-D

The machine is started by lifting the operating handle and pressing the START “I” pushbutton. This should be done in a swift manner which allows the heat seal roll to come into contact with the tray and film quickly, as the conveyor starts moving. This procedure prevents voids in the seal area during and stopping. Also, when lowering the handle to stop the machine, it should be done in swift manner as well.



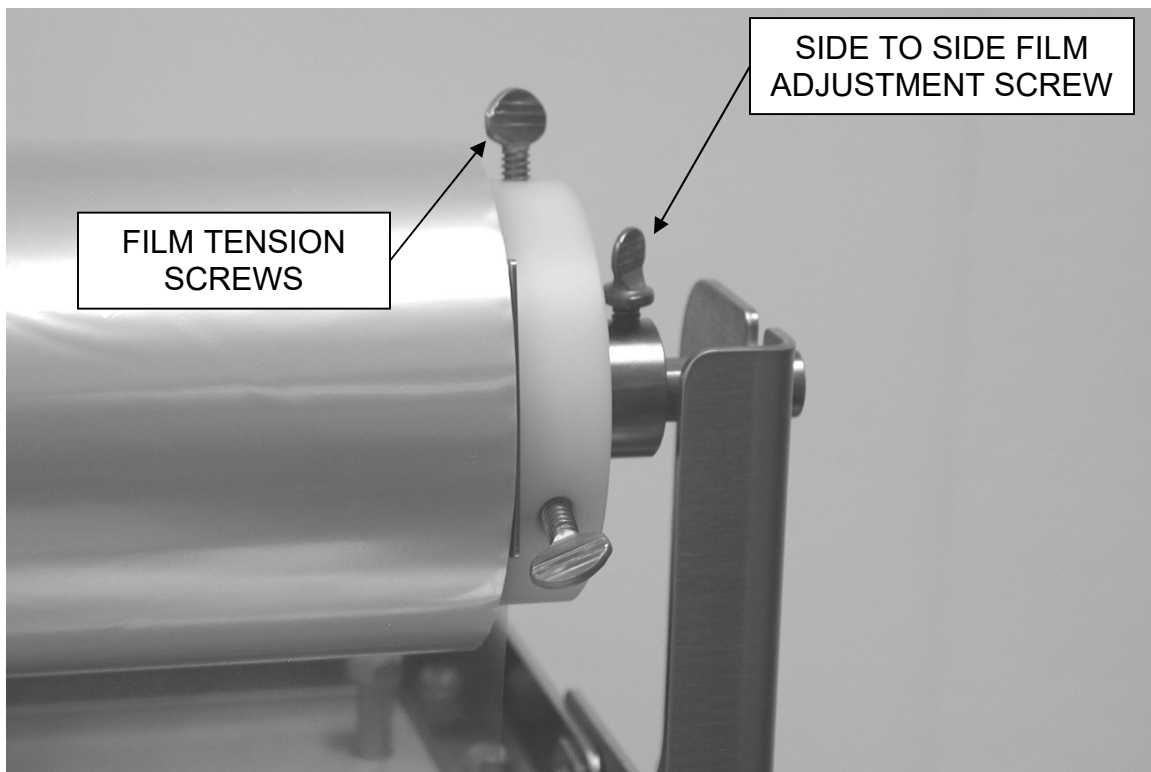
CAUTION

Avoid leaving the heater roll in the lowered position with the conveyor not moving. This will cause damage to the machine and any trays that are under the heated roll.

Continued

1808-D

After a few sealed trays have come off the end of the machine, check to see if the film is centered from side to side on the trays. If it is not, the film roll needs to be moved to one side or the other on the film mandrel. There are thumb screws in the stainless-steel collars on each side of the film mandrel. First loosen the thumb screw on the side which the film roll needs to move toward and move that collar about one half as far as you think the film is off center and tighten the thumb screw. Then loosen the thumb screw on the other collar and move the film roll holder up against the film roll core and tighten the screw. After getting the film centered on the trays, check to see if the film is sealing to the trays without excessive wrinkles. If there are excessive wrinkles, it might be that there is not enough tension on the film roll. This can be adjusted with the three thumb screws on the plastic film roll holder. Turning the screws clockwise will increase the film tension. If the film tension is too tight and the film comes off of the roll too hard, back the screws off by turning anti-clockwise.



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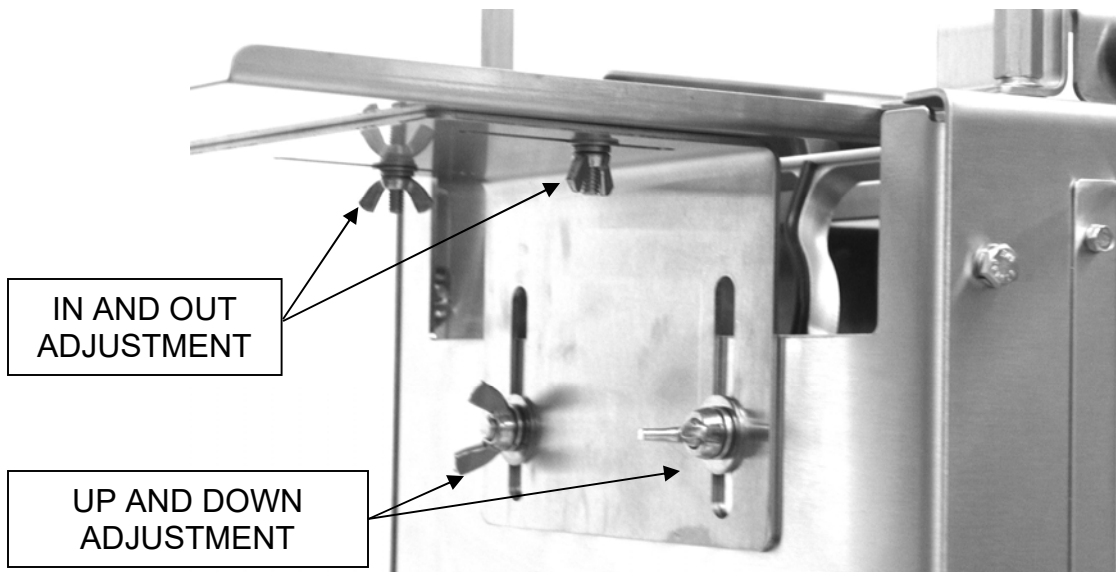
1808-D

As the trays come off the end of the machine, they are fed out of the tray carriers onto the discharge table. This table can be adjusted in and out and, up and down. These adjustments are shown in the photo below.

CAUTION

When making either of these adjustments, care must be taken to ensure that the discharge table does not get adjusted too close to the tray carriers. Doing so can cause damage to the machine.

The purpose of this adjustment is to get the trays to smoothly exit the machine as they make the transition from the tray carriers onto the table. After the trays are on the table, each tray will be pushed off the table by the next tray.



1808-D

CLEANING PROCEDURES

WARNING

DISCONNECT FROM POWER BEFORE CLEANING OR SERVICING.

CAUTION

This is not a wash-down machine! Do not directly spray any area of this machine. Clean machine areas by using only a damp rag or damp plastic scouring pad.

Clean the Heat Seal Assembly before cleaning the Conveyor because the debris that will be removed from the Heat Seal Assembly will fall onto the Conveyor.

Inspect the Heat Seal Roll for accumulation of debris (food Product). Clean off the debris with a damp plastic scouring pad such as "Scotch Brite" brand pads.

CAUTION

Always allow heated roller to cool before cleaning Heat Seal Assembly. Do not use metallic instruments such as screwdrivers or knives to clean the Heat Seal Roll, this will cause damage to the sealing surface. Also, do not spray the Heat Seal Roll. Use only damp rags or towels to remove the loosened debris from the rolls.

Tray carriers, if heavily soiled, can be removed for cleaning.

CAUTION

Only remove approximately one infeed section of the tray carriers at one time. Removing all the tray carriers and advancing the conveyor can cause severe damage to the machine.

Remove the infeed section of tray carriers, wash, replace, advance conveyor, and repeat until all tray carriers have been cleaned.

Check the corner areas of the frame for accumulation of debris that may have accumulated due to spills.

NOTE

These cleaning recommendations are not meant to replace or supercede plant standard manufacturing procedures or regulatory requirements.

If Plant procedures call for the use of sanitizing solutions, use a rag dampened with the sanitizing solution after cleaning is completed.

1808-D

TRAY CARRIER (CUTOFF) CHANGE PROCEDURES

WARNING

DISCONNECT FROM POWER BEFORE CLEANING OR SERVICING.

CAUTION

Only remove approximately one infeed section of the tray carriers at one time. Removing all the tray carriers and advancing the conveyor can cause severe damage to the machine.

TRAY CARRIER (CUTOFF) SIZE CHANGE

The machine is designed to run trays that require various cutoff lengths. The cutoff length is the dimension that the film is cut to in the machine (running) direction. The changeover between cutoff lengths consists of changing the tray carrier set and the cutter assembly.

1808-D

- **Changing to a tray carrier set with the same cutoff as the previous set**

Step 1. Remove the existing tray carrier set while at the same time installing the new tray carrier set. Proceeding in this manner ensures that the cutter assembly will be in time with the tray carriers and will not jam on the tray carriers. Tray carrier removal is accomplished by grasping one tray carrier in each hand while pushing on one tray carrier and pulling on the other. In doing this, the tray carriers will disengage from the pins on the conveyor chains and can be lifted out of the machine. As you remove existing tray carriers, replace them with the desired ones.

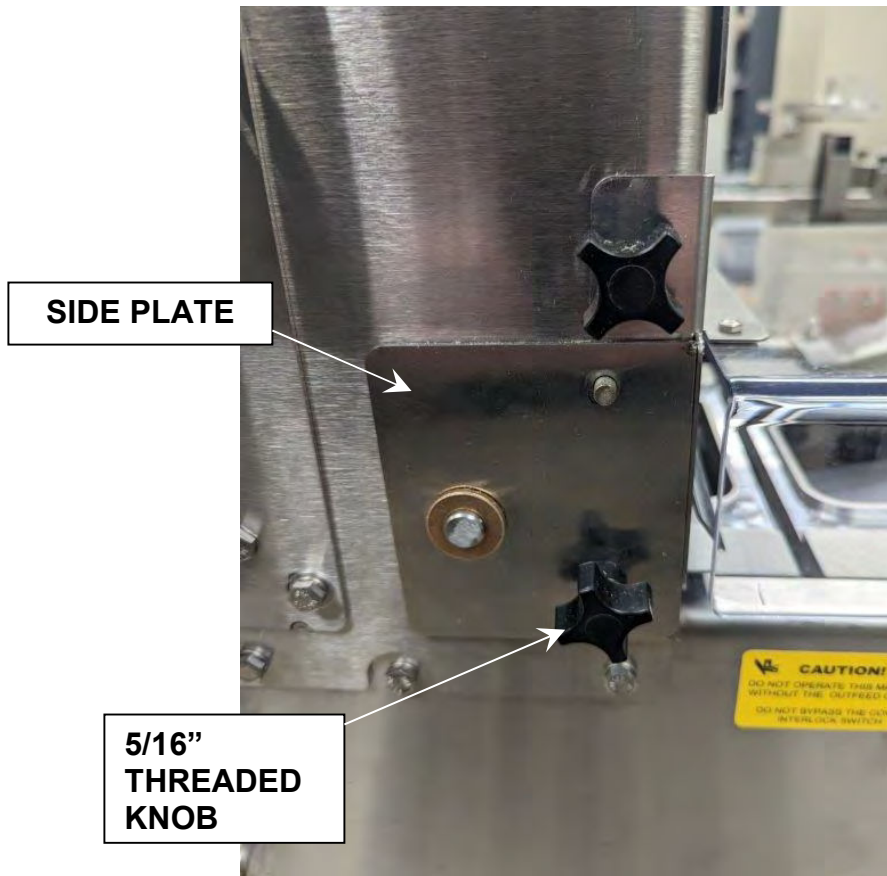


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1808-D

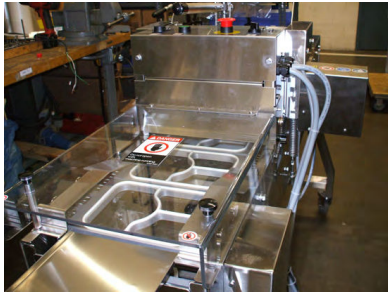
- **Changing to a tray carrier set with a different cutoff length than the previous set**

Step 1. Remove the cutter assembly. Do so by removing the hex bolt from the cutter assembly side plates on both sides of the machine. Then remove the side plates by pulling them off of the shaft.



1808-D

1808 CHANGING CUTTER UNIT ASSEMBLY



- Tray discharge end



- Remove the two knurled knobs for the plastic discharge cover



- Remove the two 1/4" threaded Knobs one on each side for the cutter cover



- Remove the plastic discharge cover



- Remove the two 5/16" threaded knobs one on each side of the cutter unit



- Remove the side plate on the sprocket side
Note: How the bushing is pressed in the plate

Continued

1808-D



- Hold the blade holder
Caution:
The blades are sharp



- Remove the side plate opposite the sprocket side Note: How the bushing is pressed in the



- Lift the cutter blade assembly out of the machine
Caution: The blades are sharp

Step 2. Remove the cutter assembly from the machine as shown in the photo below. Put the cutter in a safe place to prevent injury to personnel and to protect the cutter from damage.



Step 3. Replace the existing set of tray carriers with the new set of tray carriers.

1808-D

(See step one of “Changing to a tray carrier set with the same cutoff as the previous set” on page 7-2)

Step 4. Install the cutter assembly. **CAUTION!** You must install the cutter assembly so it is in time with the tray carriers or the blade will jam on the carriers. Run the machine slowly until a gap between tray carriers is approximately underneath the center of the cut-out in the side frame (see photo above). Insert the cutter assembly into the frame with the blade in the gap between the tray carriers. Replace the side plates and secure with the knobs.



- You can remove and install a different tray carrier set with the same cutter unit or a new one with a different cutoff
- Run the tray carriers until they are lined up with slot in the side frame as shown See Page 7
- Install new cutter unit with cutter blade between the slots in the tray carrier
Caution: The blades are sharp
See Page 7

1808-D



- Run the tray carriers until they are lined up with slot in the side frame as shown

1808-D



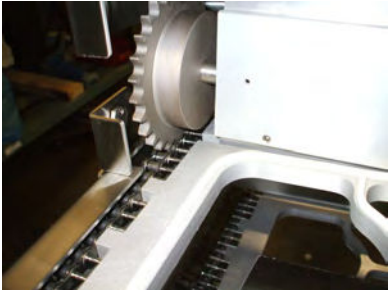
Cutter Blades
Between tray

- Install new cutter unit with the cutter blade between the slot in the tray carrier.
Caution: The blades are sharp

1808-D

CAUTION

THE CUTTER BLADES ARE VERY SHARP. HANDLE THEM CAREFULLY TO AVOID INJURY.



- Make sure the sprocket is in the tray carrier chain



- Install the side plate on the sprocket side
Note: How the bushing is pressed in the plate



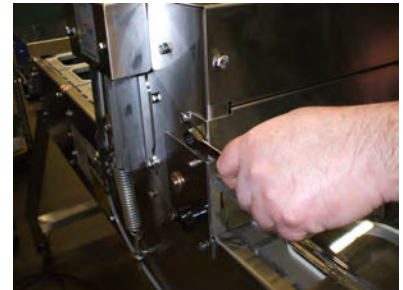
- Install the side plate on the opposite side of the sprocket
Note: How the bushing is pressed in the plate



- Secure using 5/16 knobs



- Install the plastic discharge cover



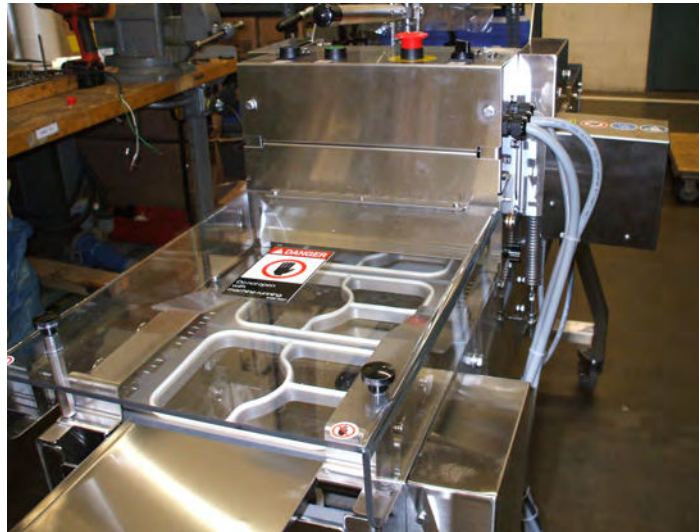
Secure using 1/4" knobs

Continued

1808-D



- Install the two knurled Knobs for the plastic discharge cover



NOTE:
AFTER INSTALLING THE NEW CUTTER UNIT OR
JUST INSTALLING THE ORIGINAL CUTTER UNIT.
RUN THE TRAY CARRIERS IN SLOW SPEED TO
CHECK THAT THE CUTTER BLADES ARE NOT
HITTING THE TRAY CARRIERS.

1808-D

MAINTENANCE PROCEDURES

WARNING

DISCONNECT FROM POWER BEFORE CLEANING OR SERVICING.

CAUTION

Only remove approximately one infeed section of the tray carriers at one time. Removing all the tray carriers and advancing the conveyor can cause severe damage to the machine.

LUBRICATION

The bearings used on the Model 1808 are of the type that do not require lubrication,

The conveyor main roller chains are rust resistant and an application of mineral oil or food grade chain lube periodically is recommended. Frequency varies with each application, the machine duty cycle and the operating environment.

WARNING

DO NOT ATTEMPT TO DO THE FOLLOWING STEP WHILE THE MACHINE IS RUNNING.

Open chains on the drive train should be coated with a good, heavy duty (FOOD CONTACT APPROVED) chain lube. Check chains monthly for lubrication.

CHAIN TENSION

The chains should be checked for proper tension weekly.

DRIVE CHAINS

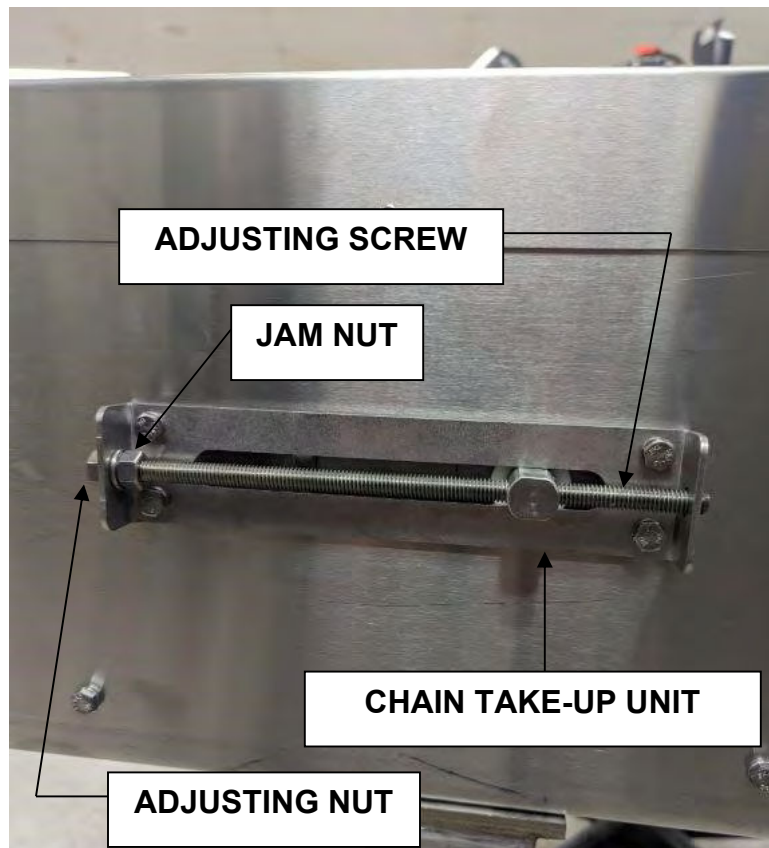
The drive chain should be taught so there is little or no backlash in the drive train. The drive chain and its tensioner are located underneath the guard at the discharge end of the machine.

MAIN CONVEYOR CHAINS

The main conveyor chains should be tight to prevent buckling of the chains as the tray carriers come around the bottom of the head shaft sprockets at the discharge end of the machine. If necessary, tighten the chains using the take-up units located at the in-feed end of the machine. If possible, try to tension both chains the same amount so that the chains will be in alignment with each other, and the tray carriers will run down the conveyor square to the frame.

1808-D

The main drive chains are tensioned by adjusting the chain take-up units located at the in-feed end of the machine (see photo below). To tighten the chains, loosen the jam nut on the adjusting screw. Turn the adjusting nut clockwise to tighten the chains. Turn the adjusting nut $\frac{1}{2}$ turn on one side of the machine and then $\frac{1}{2}$ turn on the other side of the machine and check chain for tension. Proper tension is when the return tray carriers on the bottom of the conveyor can be lifted off the chain rail about 1" without the chain feeling over tight. If the chain is very sloppy when lifted, it is too loose. After adjusting, tighten the jam nuts.



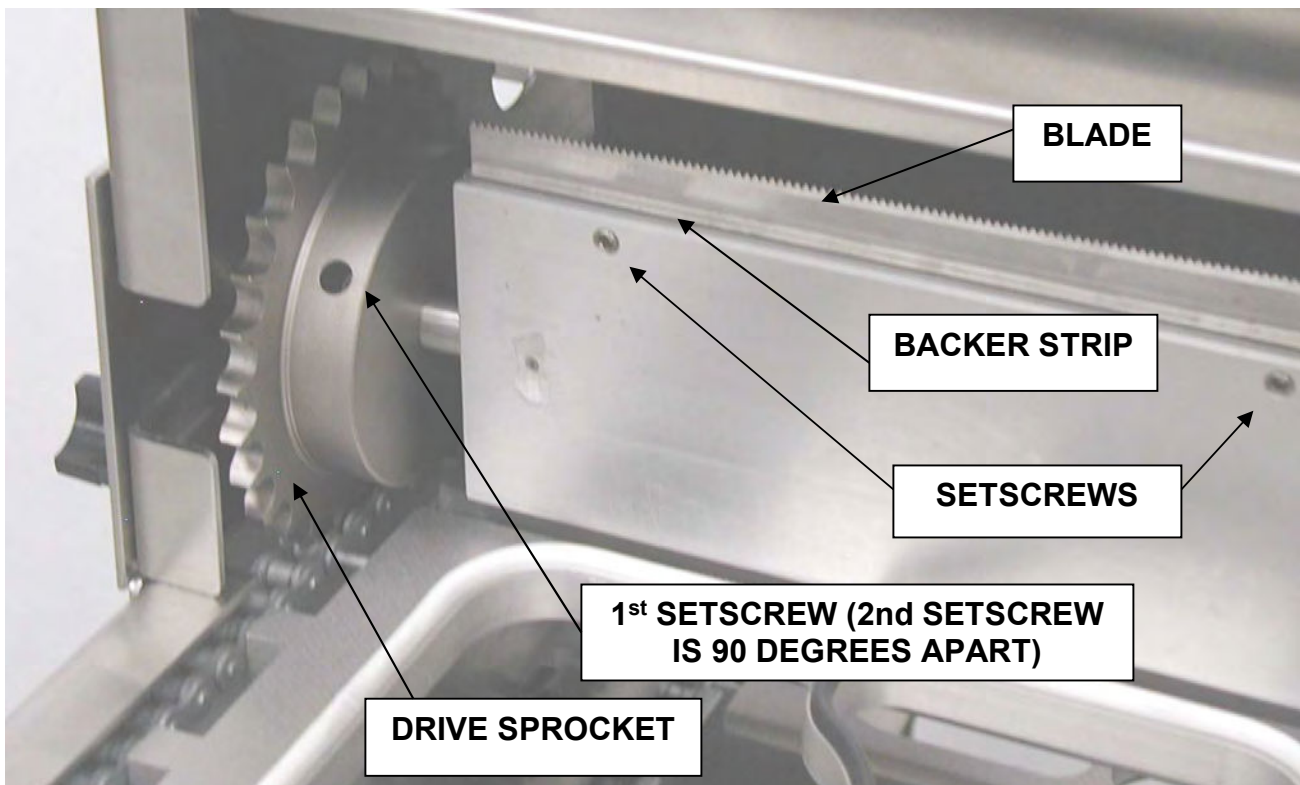
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1808-D

CUTTER ASSEMBLY

Check the cutter blades for sharpness and damage on a weekly basis. Replace blade(s) if necessary. The blades are easily replaced. The blades are held in place by two setscrews. Notice that the setscrews are pressing against a backer strip which in turn presses against the actual blade. The reason for this is that the blade material is very hard and if the setscrews were to press directly on the blade, the blade could possibly be cracked. So, it is important that the new blade be placed behind the backer strip and not next to the setscrews (see photo below). Loosen the two setscrews, remove the old blade, insert the new blade and tighten setscrews.

Should the cutter get out of time with the tray carriers, it can be re-timed by loosening the two setscrews in the drive sprocket and turning the cutter in the appropriate direction and tightening the setscrews (see photo below). The two setscrews are 90 degrees apart. Run the conveyor and stop in a position where you can get access to the first setscrew and loosen that screw. Then run the conveyor further until you have access to the second screw and loosen that screw. Now turn the cutter in the appropriate direction and tighten this screw. Run the conveyor until you have access to the first screw and tighten.



Continued

1808-D

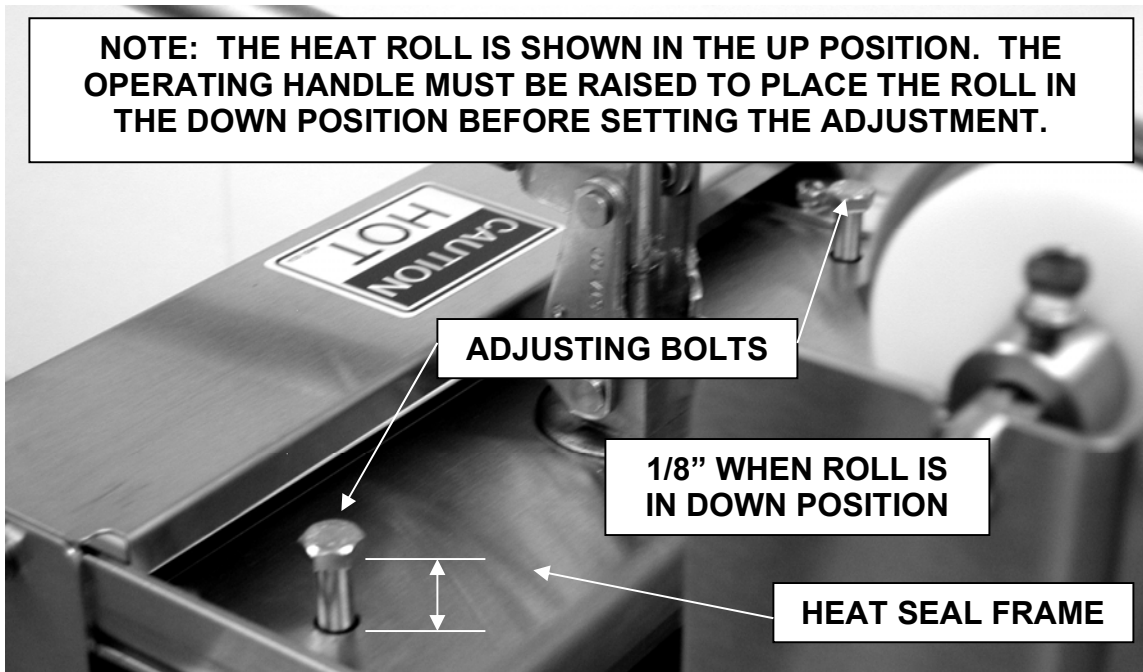
HEAT SEAL ROLL DOWN-STROKE ADJUSTMENT PROCEDURES

NOTE

Before conducting this procedure, make certain that the sleeve on the heat seal roll is clean and does not have any burnt-on food product on the surface.

Put an empty tray into the machine and run the machine until the tray is under the heat seal roll and stop the machine with the tray under the roll. Unplug the machine. Raise the operating handle and let the roll down onto the tray. There are two adjusting bolts that determine how far the heat seal roll can go down (see photo below). These bolts are there to prevent the roll from going down too far in the gap between the tray carriers or when there are no tray carriers in the machine. The dimension between the head of the bolts and the heat seal frame should be $1/8$ " when the roll is in the down position and resting on top of a tray. To adjust the bolts, the jam nut underneath the heat seal frame must be loosened. Tighten jam nut after adjusting.

NOTE: THE HEAT ROLL IS SHOWN IN THE UP POSITION. THE OPERATING HANDLE MUST BE RAISED TO PLACE THE ROLL IN THE DOWN POSITION BEFORE SETTING THE ADJUSTMENT.



Continued

1808-D

TEMPERATURE ADJUSTMENT

WARNING

ONLY AN AUTHORIZED SERVICE TECHNICIAN CAN ADJUST THE TEMPERATURE OF THE HEAT SEAL ROLL.

If the film is not sealing securely to the trays, it might be because the temperature is too low. Temperature of the heat seal roll is set to 215 degrees Celsius at the factory. Only an authorized Service Technician can adjust the temperature of the heat seal roll.

WARNING

NEVER ADJUST THE TEMPERATURE OF THE HEAT SEAL ROLL ABOVE 215 DEGREES CELSIUS.

ADJUSTING THE TEMPERATURE OF THE HEAT SEAL ROLL ABOVE 215 DEGREES CELSIUS CAN CAUSE A FIRE AND/OR SEVERE DAMAGE TO MACHINE.

NOTE

See TROUBLESHOOTING section of this manual before adjusting the temperature of the heat seal roll.

1808-D

RECOMMENDED SPARE PARTS

<u>Description</u>	<u>Part No.</u>	<u>Suggested Qty.</u>
Fuse 2.5 Amp (5 x 20mm)	5725-9569	2
Fuse 5 Amp (5 x 20mm)	5725-9572	2
Cartridge Heater (120V)	5730-1552	4
Cartridge Heater (208-240V)	5730-1564	4
Thermocouple	5712-0527	1
Cutter Blade	7107-7200	2
Sleeve – Heat Seal Roller	68811	1

1808-D

TROUBLESHOOTING

WARNING

DISCONNECT FROM POWER BEFORE CLEANING OR SERVICING.

WARNING

SERVICE ON THIS EQUIPMENT SHOULD ONLY BE PERFORMED BY A QUALIFIED SERVICE TECHNICIAN.

Should you experience problems with your machine, refer to the Trouble Shooting guide below. If you have attempted the remedies listed below and are still experiencing problems, contact Oliver Packaging & Equipment Company (USA) **1-800-253-3893**

SYMPTOM

Poor seal quality

CORRECTIVE ACTION

Check to see that the heated roll switch is in the “I” on position.

Check to see if the heat seal roll is dirty, if so, clean as detailed in the “CLEANING PROCEDURES”.

Check the fuses in the electrical enclosure to see if any fuse is open (no continuity), if it is open, replace it. (To be performed only by a Qualified Service Technician)

Check to see if one or more of the heater elements are burned out. There are four heater elements in the heat seal roll. This check requires the use of an amp meter to determine the condition of each individual heater element. (To be performed only by a Qualified Service Technician)

Check to see if heat seal roll is up to temperature. Compare set temp and actual on digital temperature control on side of electrical enclosure.

Continued

1808-D

SYMPTOM

Poor seal quality (continued)

Heat seal roll does not heat

CORRECTIVE ACTION

Make certain that the heat seal roll down stroke is adjusted correctly as explained in the “MACHINE ADJUSTMENTS” section of this manual.

Make certain the machine is plugged into an adequately rated electrical outlet.

Verify that there is power at the electrical outlet.

Check to see that the heated roll switch is in the “I” on position.

Check the E-stop button – must be in released position.

Check that Infeed gate is in place.

Check that Discharge cover is closed.

Check to see if heat seal roll is up to temperature. Compare set temp and actual on digital temperature control on side of electrical enclosure.

Check the fuses in the electrical enclosure to see if any fuse is open (no continuity), if it is open, replace it. (To be performed only by a Qualified Service Technician)

Check the circuit breaker in the electrical enclosure to see if it has tripped. If tripped, investigate cause and reset. (To be performed only by a Qualified Service Technician)

Continued

1808-D

Film does not cut

Check to see if a cutter blade is missing.

Check to see if cutter blade is dull

Replace as necessary!

Film is not centered on tray

Check to see if film roll is centered on the machine. If not, center the roll as explained in the "OPERATING THE MACHINE" section of this manual.

Machine does not run

Make certain the machine is plugged into an adequately rated electrical outlet.

Verify that there is power at the electrical outlet.

Check the E-stop button – must be in released position.

Check that Infeed gate is in place.

Check that Discharge cover is closed.

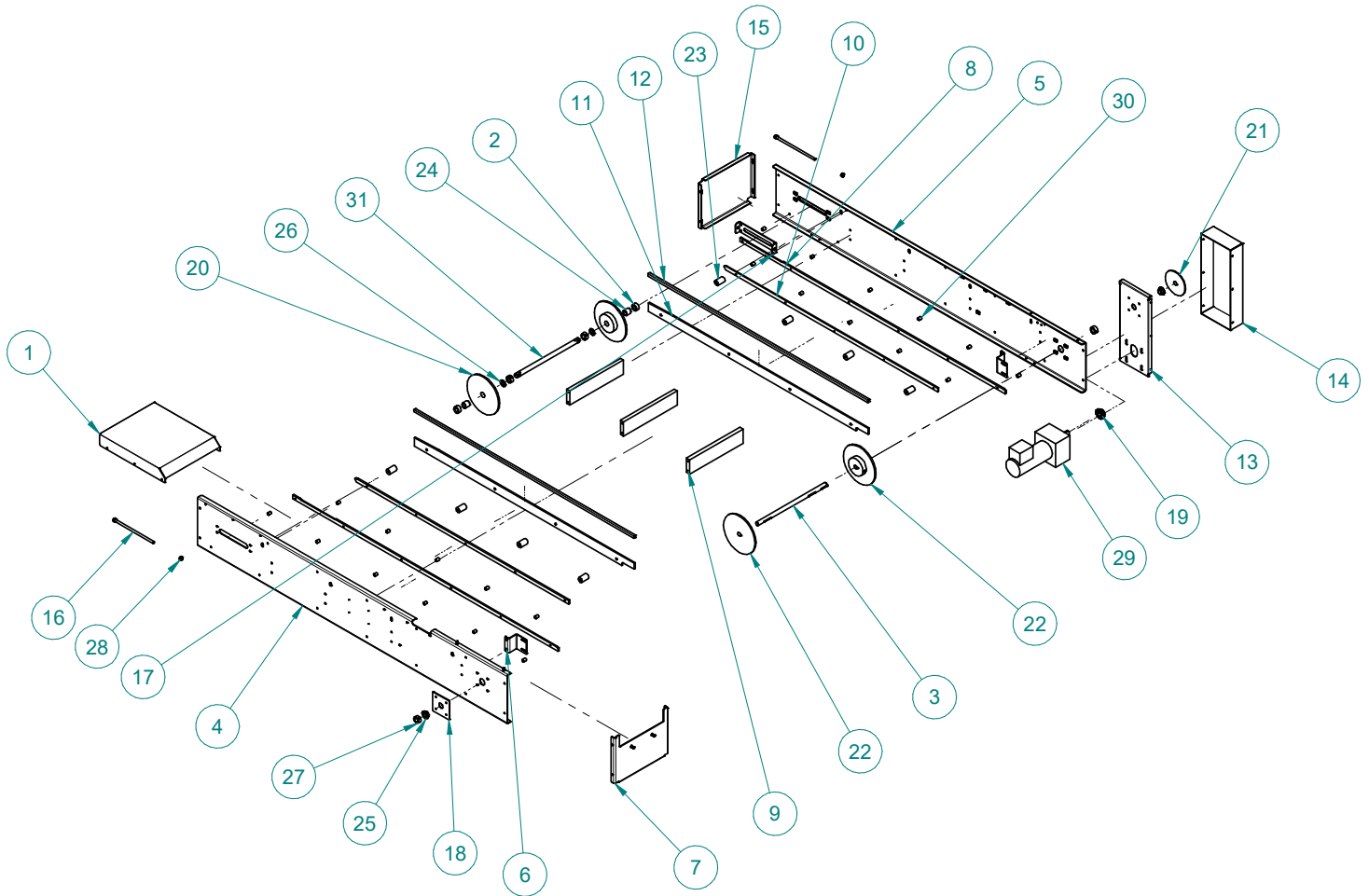
Check to see if heated roll is in sealing position (down).

Check the fuses in the electrical enclosure to see if any fuse is open (no continuity), if it is open, replace it. (To be performed only by a Qualified Service Technician)

Check the circuit breaker in the electrical enclosure to see if it has tripped. If tripped, investigate cause and reset. (To be performed only by a Qualified Service Technician)

1808-D

FRAME AND DRIVE ASSEMBLY



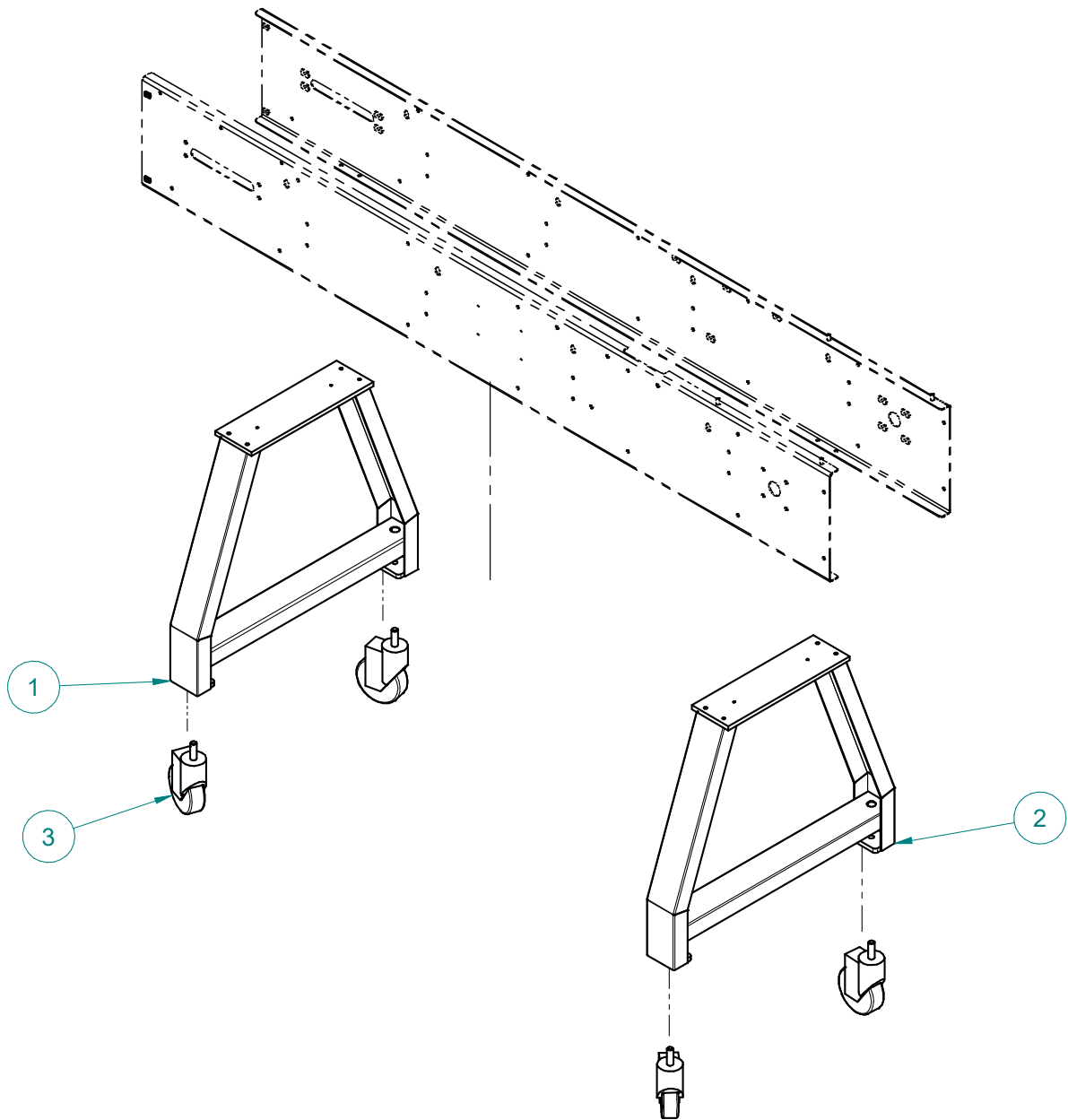
1808-D

FRAME AND DRIVE ASSEMBLY

Item	Part Number	Description	Qty	Item	Part Number	Description	Qty
1	1808-0026-003	GUARD-INFEED	1	20	4617-4048-3231	SPROCKET 40B48 TYPE B HUB NP	2
2	1808-0027	SPACER SPROCKET	2	21	4618-3540-2431	SPROCKET TYPE B HUB 35B40 3/4B	1
3	1808-0028	SHAFT-DRIVE	1				
4	1808-0054-003	FRAME-FRONT 75" LONG	1	22	4618-4048-2431	SPROCKET 40B48 3/4" FB PLATED	2
5	1808-0055-003	FRAME-REAR 75" LONG	1	23	52525	SPACER TRAY SUPPORT RAIL	8
6	1808-0056	SPACER DISCHARGE LIFT	2	24	5254-0322	BEARING-SINT BRZ SLV B1216-8	2
7	1808-0057	END PLATE	1	25	5254-3032	BEARING-SINT BRZ FLNG FF1011-2	2
8	1808-0090-002	SUPPORT CHAIN LOWER	2	26	5254-3514	BEARING-SN BRZ THRST OIL.TT1205	2
9	1808-0091	SPACER FRAME 13" WIDE	3	27	5806-7057	COLLAR 3/4"	4
10	1808-0092-002	SUPPORT CHAIN RAIL UPPER	2	28	5832-0522	NUT-HEX 3/8 STST	2
11	1808-0094-002	STRIP CARRIER SUPPORT	2	29	6310-0202	GEARMOTOR-PARALLEL SHAFT	1
12	1808-0106-001	STRIP-WEAR UHMW X 53-1/4" LONG	2	30	66240	SPACER-CHAIN SUPPORT 0.598 LONG	22
13	1808-0114	PLATE-GUARD BACKING	1	31	69327	SHAFT TAIL WIDE UNIT 13"	1
14	1808-0115	GUARD-DRIVE	1				
15	1808-0320	END PLATE INFEED	1				
16	1908-0005-001	SCREW TAKE-UP	2				
17	1908-0054-001	TAKE UP-FRAME 6" TRAVEL	2				
18	1908-0055	BLOCK-REAR BEARING	1				
19	4617-3514-2431	SPROCKET-TYPE B HUB 35B14 NP	1				

1808-D

LEG ASSEMBLY



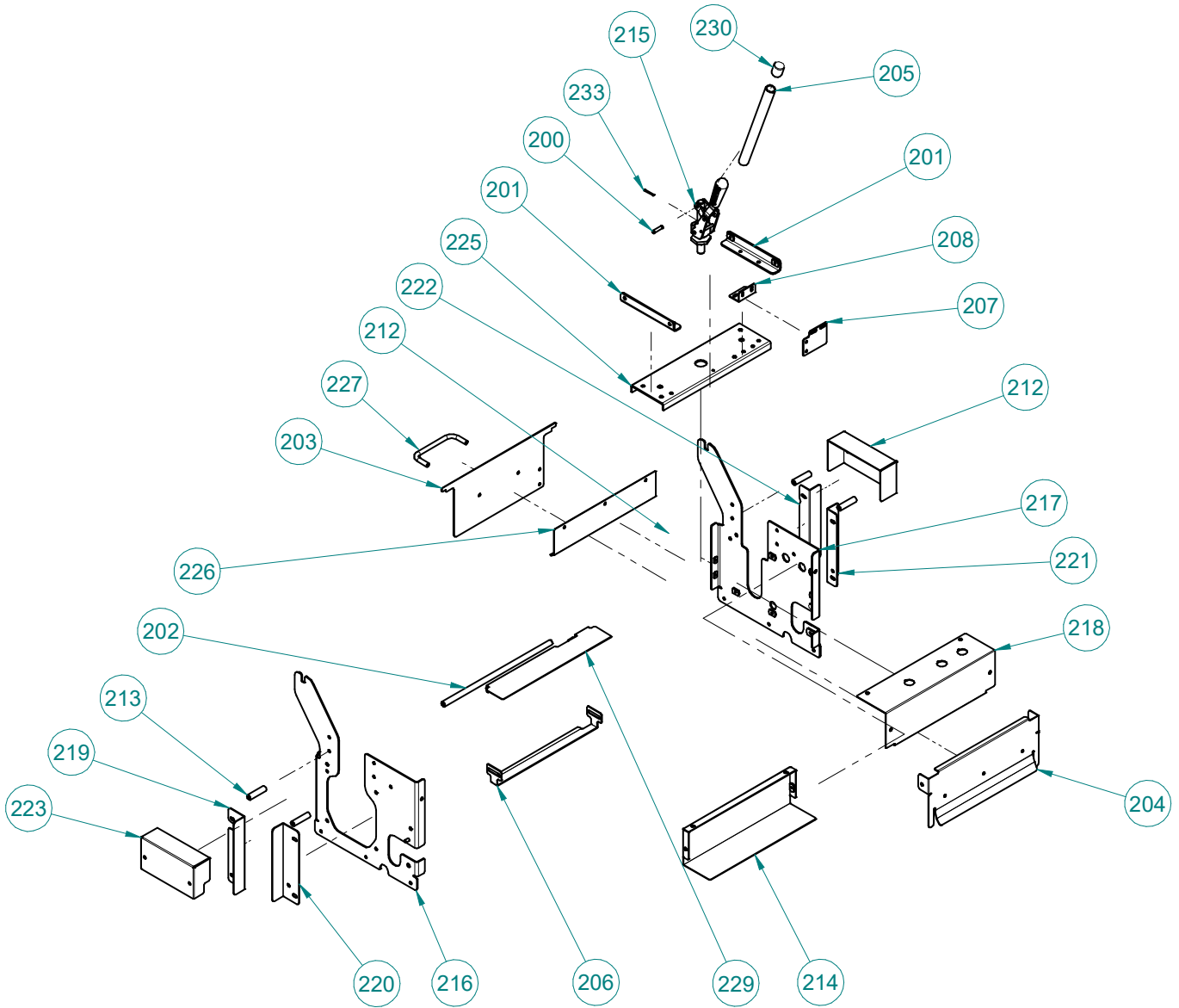
1808-D

LEG ASSEMBLY

Item	Part Number	Description	Qty
1	1808-0053	LEG-WIDE UNIT 13" W/CASTERS	1
2	1808-0053-001	LEG-WIDE UNIT 13" W/CASTERS-DISCHARGE	1
3	5902-2409	CASTER-STEM, 4" WHEEL 150LBS	4

1808-D

HEAT SEAL FRAME ASSEMBLY



1808-D

HEAT SEAL FRAME ASSEMBLY

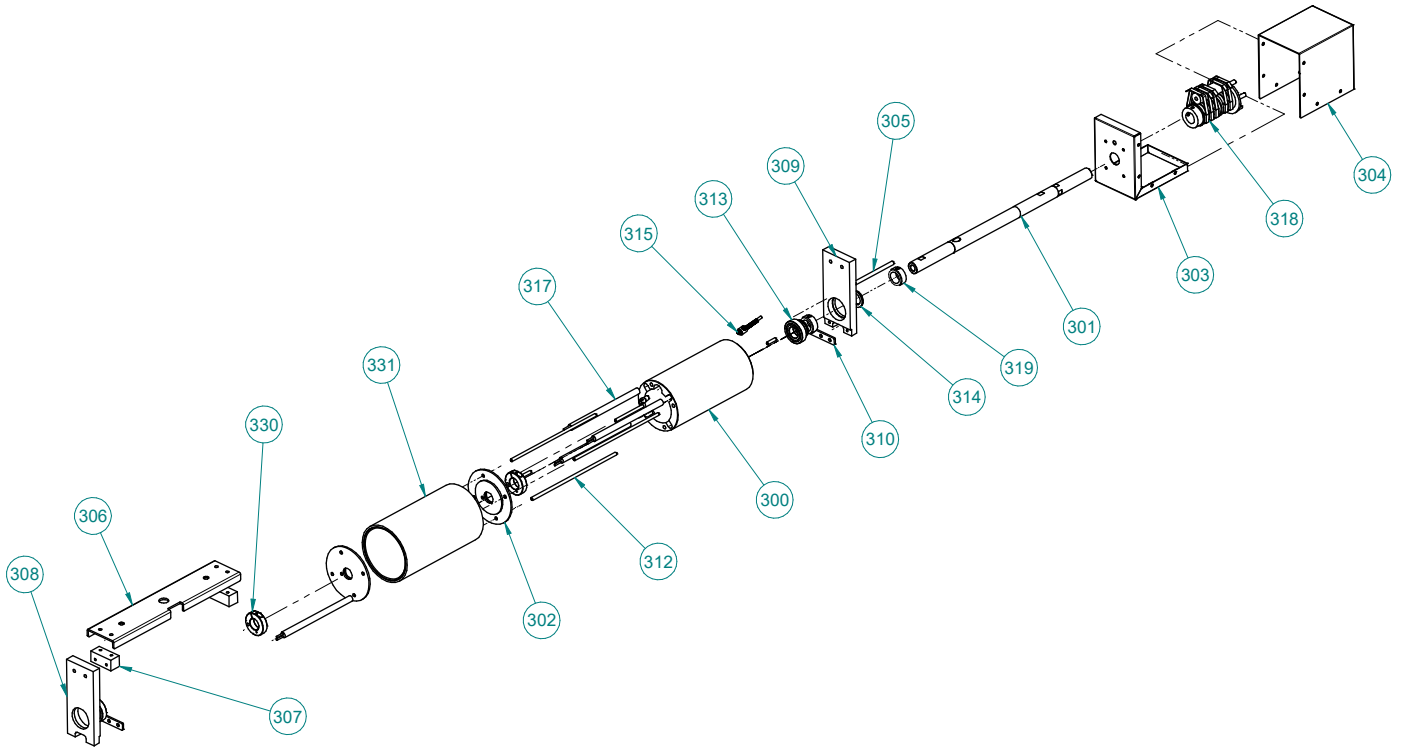
Item Number	Part Number	Description	Qty
200	1508-0048	PIN CLAMP PUSHER ROD	1
201	1808-0035	BRACKET ANGLE CLAMP	2
202	1808-0037	ROD FILM BREAKER	1
203	1808-0038-001	DOOR GUARD LIMIT SWITCH	1
204	1808-0044	GUARD FRONT HINGE	1
205	1808-0064	HANDLE 10" LONG	1
206	1808-0069	RETAINER TRAY	1
207	1808-0085	PLATE SWITCH MOUNTING	1
208	1808-0086	BRACKET SWITCH PLATE	1
209	1808-0087	SPACER	1
210	1808-0088-001	CAM SWITCH CE	1
211	1808-0089	STUD SPRING	1
212	1808-0124	COVER SIDE	1
213	1808-0125	SPACER COVER SIDE	4
214	1808-0129	COVER ELECTRICAL	1

Item Number	Part Number	Description	Qty
215	1808-0321	CLAMP TOGGLE WITH BUSHING	1
216	1808-0327	PLATE FRAME SIDE HEAT SEAL RH	1
217	1808-0328-001	PLATE FRAME SIDE HEAT SEAL LH	1
218	1808-0329-001	COVER TOP FRONT PUSHBUTTON	1
219	1808-0330	GUIDE ANGLE	1
220	1808-0331	GUIDE ANGLE	1
221	1808-0332	GUIDE ANGLE	1
222	1808-0333	GUIDE ANGLE	1
223	1808-0334	COVER SIDE	1
224	1808-0335	SPACER HOLD DOWN	2
225	1808-0337	BRACKET CLAMP CE	1
226	1808-0338	GUARD INSIDE CROSS BAR	1
227*	1808-0360	HANDLE	1
228	1808C10027	DWG HEAT SEAL ROLL ASSEMBLY	1
229	1908-0336	COVER TOP	1

Item Number	Part Number	Description	Qty
230	5105-5250	CAP PROTECTIVE VINYL	1
231	5757-7353	SWITCH LIMIT SPDT NEMA4 (CARD)	1
232	5832-0500	NUT-HEX 1/4, JAM, STST	1
233	5835-6788	PIN - SPRING 1/8 X 1-1/8" STST	1

1808-D

HEAT SEAL ROLL ASSEMBLY (120V)



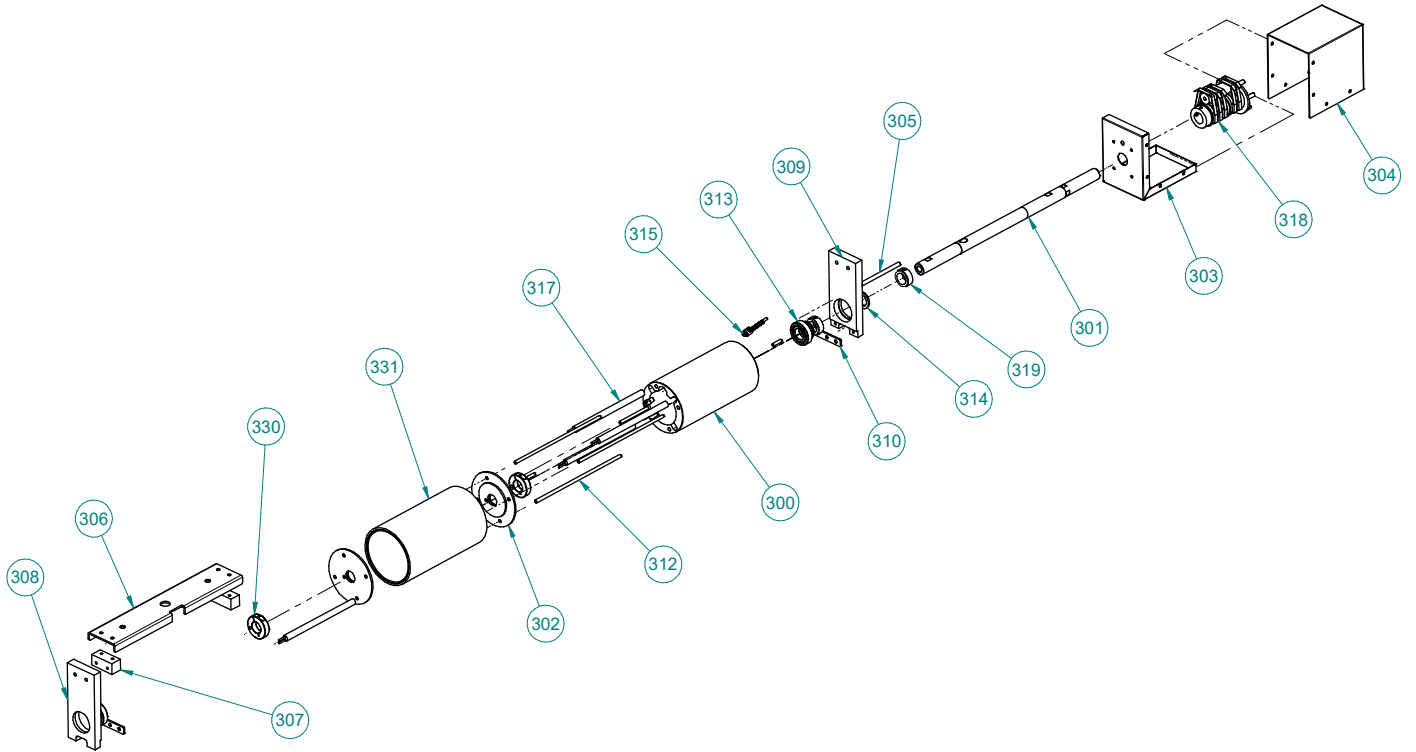
1808-D

HEAT SEAL ROLL ASSEMBLY (120V)

Item Number	Part Number	Description	Qty	Item Number	Part Number	Description	Qty	Item Number	Part Number	Description	Qty
300	1808-0008-002	CORE HEAT SEAL WITH 4 HEATERS	1	314	5254-3525	BEARING THRUST 1" ID X 1-1/2 OD X 1/8T	2	328	5851-9357	WASHER- LOCK 1/4 STST SPRING	20
301	1808-0009-002	SHAFT HEAT SEAL ROLLER	1	315	5712-0527	THERMOCOUPLE	1	329	5851-9358	WASHER-LOCK 5/16" STST 18-8	1
302	1808-0010-001	CAP RETAINER ROLL HEAT SEAL	2	316	5712-0597	ADAPTER BAYONET	1	330	68291	COLLAR-CLAMP TYPE 1" BORE	2
303	1808-0016-002	GUARD SLIP RING REAR	1	317	5730-1552	HEATER CARTRIDGE 1/2"D X 8"L 120V	4	331	68811	SLEEVE-HEAT SEAL	1
304	1808-0017-002	GUARD SLIP RING COVER	1	318	5752-1040	SLIP RING BODY WAMPFLER ES45	1				
305	1808-0120	RETAINER SLIP RING ROD	1	319	5806-7059	COLLAR - SET 1" BORE, STST	2				
306	1808-0322	CHANNEL UPPER CLAMP SUPPORT	1	320	5832-0520	NUT- HEX FULL 1/4-20NC FIN STST	8				
307	1808-0323	MOUNTING SUPPORT BLOCK	2	321	5832-0521	NUT- HEX FULL 5/16-18NC FIN STST	1				
308	1808-0324	BEARING BLOCK END FRONT	1	322	5843-1001	SCREW- HEX HD 1/4-20 X 1/2 STST	4				
309	1808-0325	BEARING BLOCK END REAR	1	323	5843-1002	SCREW- HEX HD 1/4-20 X 5/8 STST	4				
310	1808-0326	BAR SPRING RETAINER	2	324	5843-1006	SCREW- HEX HD 1/4-20 X 1-1/4 STST	4				
311	4475-0516-1	PIN-1/4 DIA X 1"	2	325	5843-1232	SCREW-HEX HD #10-24 X 1/2, STST	4				
312	4625-3608-10	STUD-THREADED 1/4-20 X 10"	4	326	5843-5372	SCREW-TRUSS HEAD 8-32 x 3/8 STST	8				
313	5250-0390	BRG-BALL 1" X 2" X 1/2" SEALED	2	327	5851-9355	WASHER - #10 STST SPRING LOCK	4				

1808-D

HEAT SEAL ROLL ASSEMBLY (208-240V)



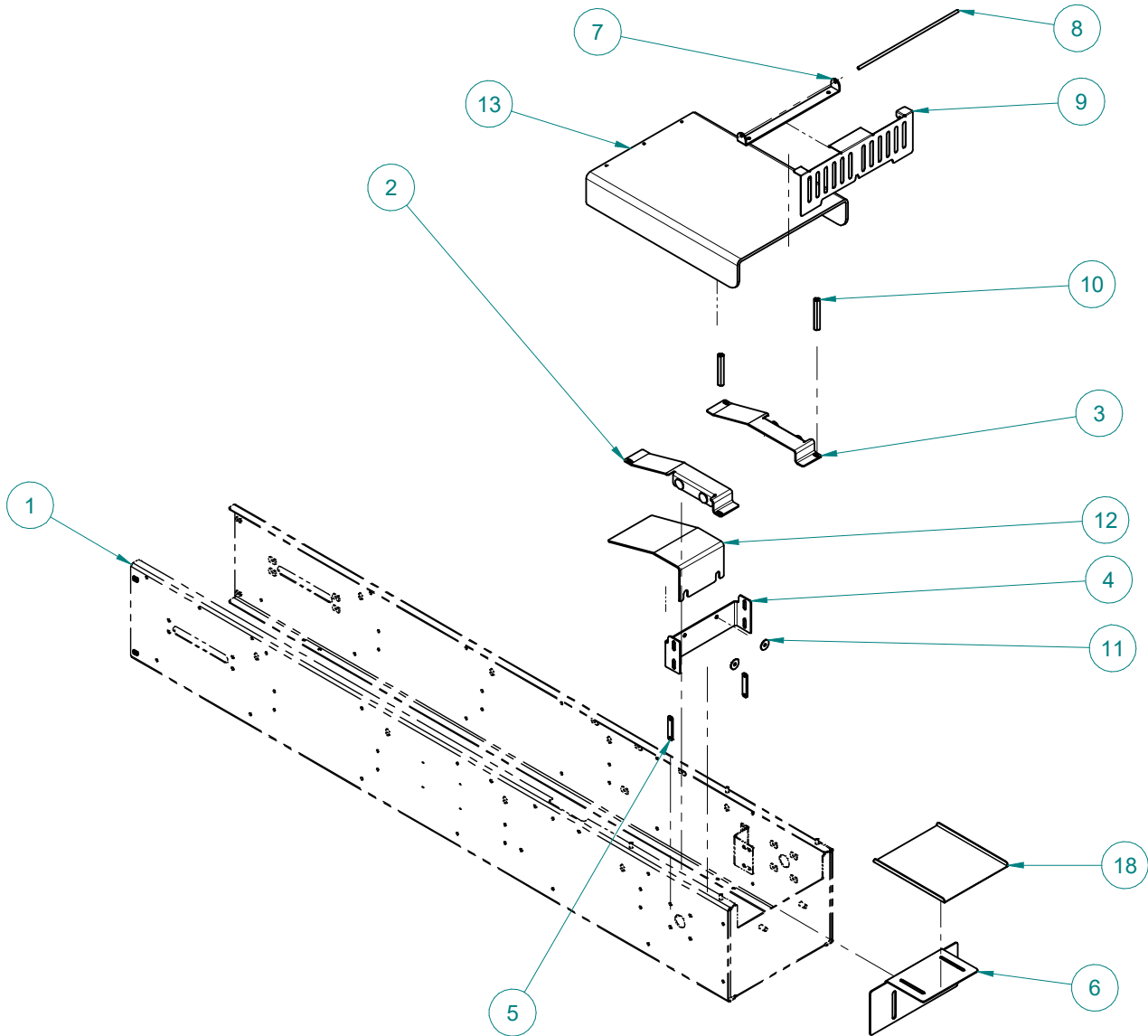
1808-D

HEAT SEAL ROLL ASSEMBLY (208-240V)

Item Number	Part Number	Description	Qty	Item Number	Part Number	Description	Qty	Item Number	Part Number	Description	Qty
300	1808-0008-002	CORE HEAT SEAL WITH 4 HEATERS	1	314	5254-3525	BEARING THRUST 1" ID X 1-1/2 OD X 1/8T	2	328	5851-9357	WASHER- LOCK 1/4 STST SPRING	20
301	1808-0009-002	SHAFT HEAT SEAL ROLLER	1	315	5712-0527	THERMOCOUPLE	1	329	5851-9358	WASHER-LOCK 5/16" STST 18-8	1
302	1808-0010-001	CAP RETAINER ROLL HEAT SEAL	2	316	5712-0597	ADAPTER BAYONET	1	330	68291	COLLAR-CLAMP TYPE 1" BORE	2
303	1808-0016-002	GUARD SLIP RING REAR	1	317	5730-1564	HEATER CARTRIDGE 1/2"D X 8"L	4	331	68811	SLEEVE-HEAT SEAL	1
304	1808-0017-002	GUARD SLIP RING COVER	1	318	5752-1040	SLIP RING BODY WAMPFLER ES45	1				
305	1808-0120	RETAINER SLIP RING ROD	1	319	5806-7059	COLLAR - SET 1" BORE, STST	2				
306	1808-0322	CHANNEL UPPER CLAMP SUPPORT	1	320	5832-0520	NUT- HEX FULL 1/4-20NC FIN STST	8				
307	1808-0323	MOUNTING SUPPORT BLOCK	2	321	5832-0521	NUT- HEX FULL 5/16-18NC FIN STST	1				
308	1808-0324	BEARING BLOCK END FRONT	1	322	5843-1001	SCREW- HEX HD 1/4-20 X 1/2 STST	4				
309	1808-0325	BEARING BLOCK END REAR	1	323	5843-1002	SCREW- HEX HD 1/4-20 X 5/8 STST	4				
310	1808-0326	BAR SPRING RETAINER	2	324	5843-1006	SCREW- HEX HD 1/4-20 X 1-1/4 STST	4				
311	4475-0516-1	PIN-1/4 DIA X 1"	2	325	5843-1232	SCREW-HEX HD #10-24 X 1/2, STST	4				
312	4625-3608-10	STUD-THREADED 1/4-20 X 10"	4	326	5843-5372	SCREW-TRUSS HEAD 8-32 x 3/8 STST	8				
313	5250-0390	BRG-BALL 1" X 2" X 1/2" SEALED	2	327	5851-9355	WASHER - #10 STST SPRING LOCK	4				

1808-D

DISCHARGE ASSEMBLY



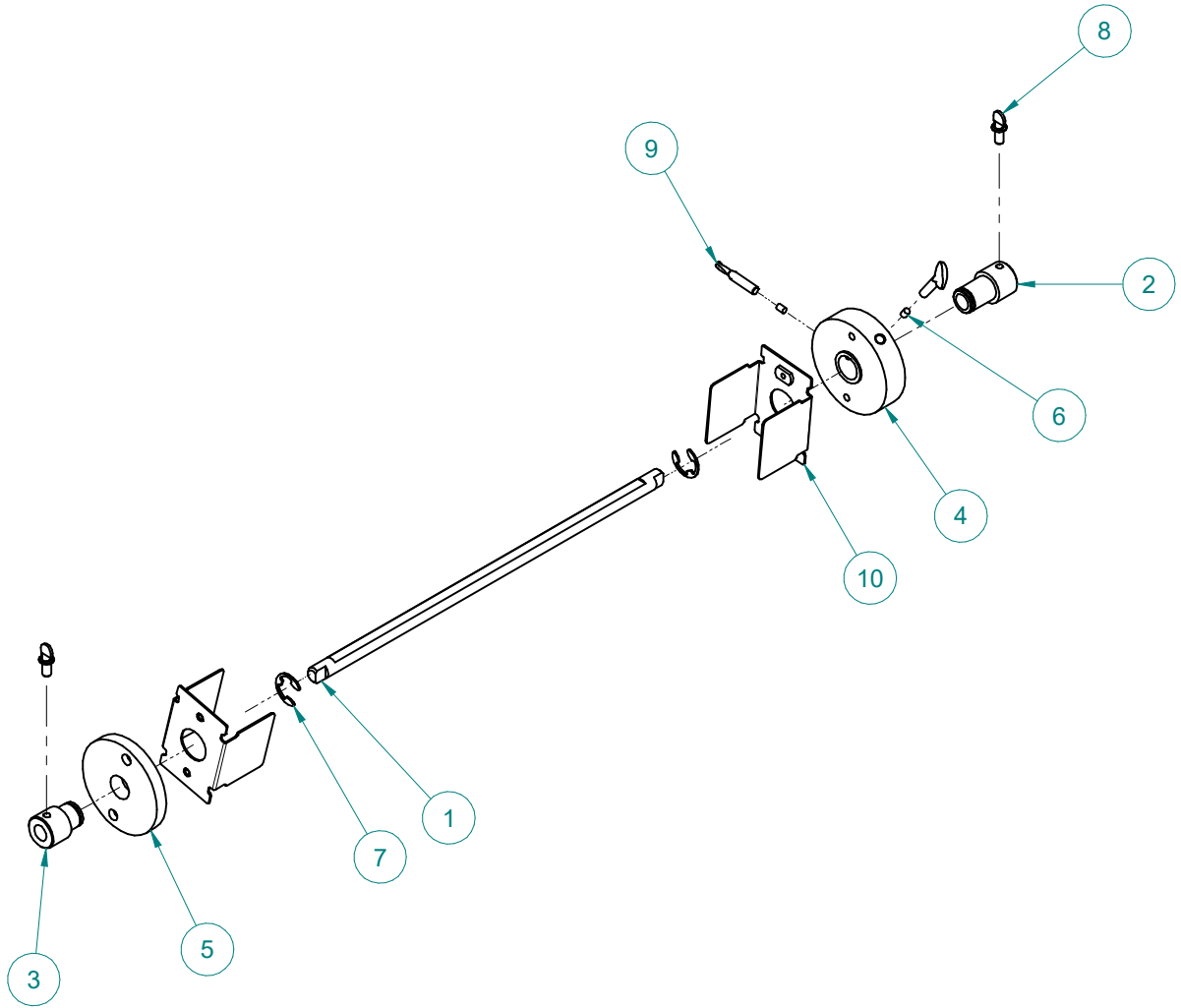
1808-D

DISCHARGE ASSEMBLY

Item	Part Number	Description	Qty
1	1808-0054-001	FRAME-FRONT 75" LONG	1
2	1808-0059	BASE LIFT TRAY GUIDE (R)	1
3	1808-0060	BASE LIFT TRAY GUIDE (L)	1
4	1808-0061	BRACKET SPACER	1
5	1808-0062	NUT BAR	2
6	1808-0063	SUPPORT SHELF	1
7	1808-0362-001	GUARD-MOUNT 1808	1
8	1808-0364	GUARD-ROD 1808	1
9	1808-0365	WELDMENT, DISCHARGE FLAP	1
10	1908-0058-002	SPACER-COVER 3-3/16 LONG	2
11	1908-0084	RETAINER-LIFT RAMP INSIDE	2
12	1908-0088	LIFT SENIOR MEALS TRAY	1
13	5500-5337	COVER DISCHARGE PER-PRINT	1
14*	5832-0590	NUT-ACORN 1/4-20	2
15*	5843-5413	SCREW-TRUSS HD SLTD 1/4-20 X 5/8 stst	2
16*	5851-9357	WASHER- LOCK 1/4 STST SPRING	2
17*	5902-2123	CAP	2
18	69043	ADJUSTABLE GUIDE SHELF	1

1808-D

FILM MANDREL ASSEMBLY



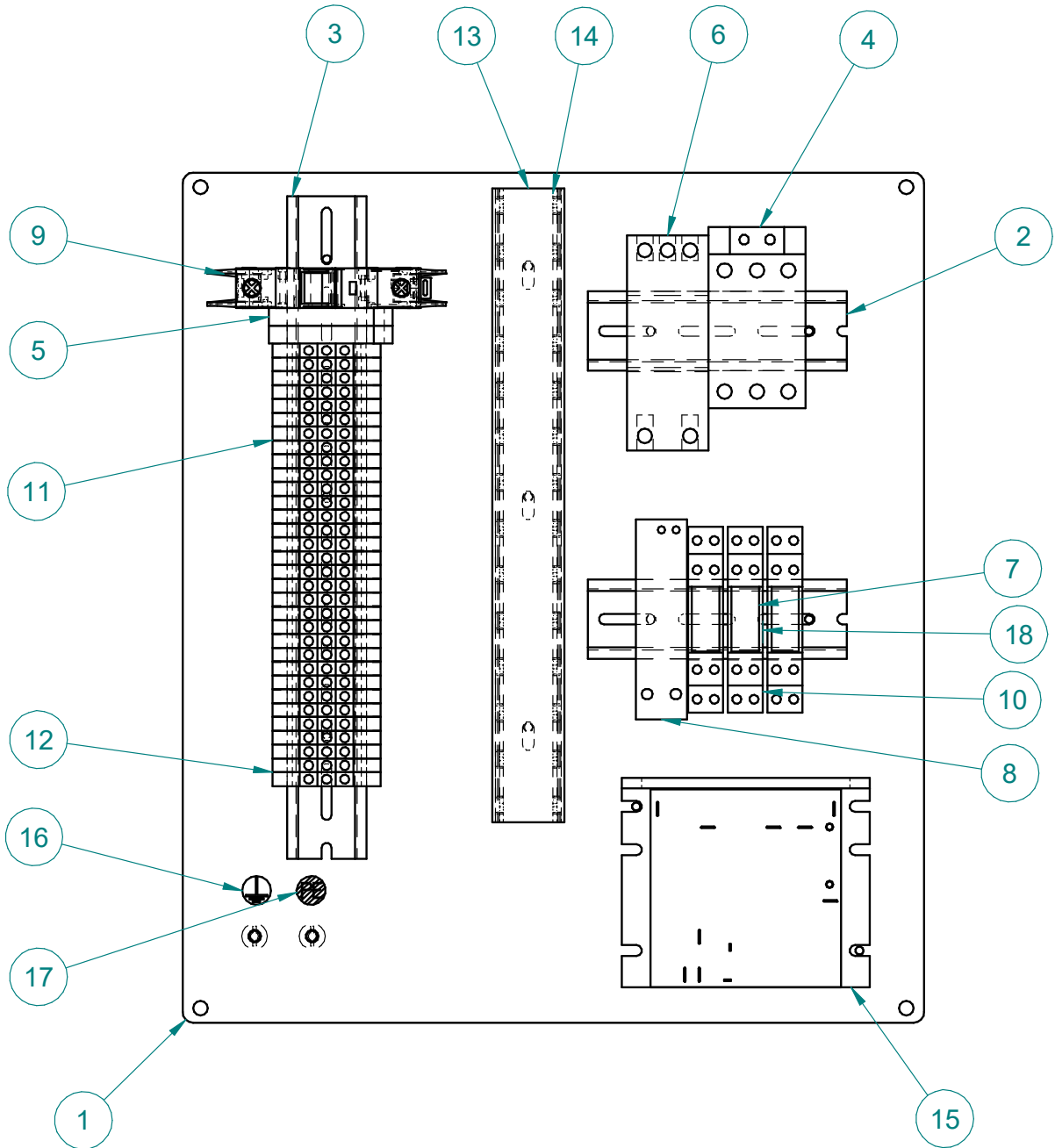
1808-D

FILM MANDREL ASSEMBLY

Item	Part Number	Description	Qty
1	1808-0001	MANDREL SHAFT	1
2	1808-0002	RETAINER FILM HOLDER LONG	1
3	1808-0002-001	RETAINER FILM HOLDER SHORT	1
4	1808-0003	HUB FILM HOLDER BRAKE	1
5	1808-0003-001	HUB FILM HOLDER	1
6	1808-0004	ROD BRAKE	2
7	5840-1287	RING-RETAINING (E-CLIP) 5133-75H	2
8	5843-0536	SCREW-THUMB 1/4-20 STST W/SHOULDER	2
9	5843-0538	SCREW-THUMB 1/4-20 X 1	2
10	69853	HOLDER FILM	2

1808-D

ELECTRICAL ASSEMBLY (120V)



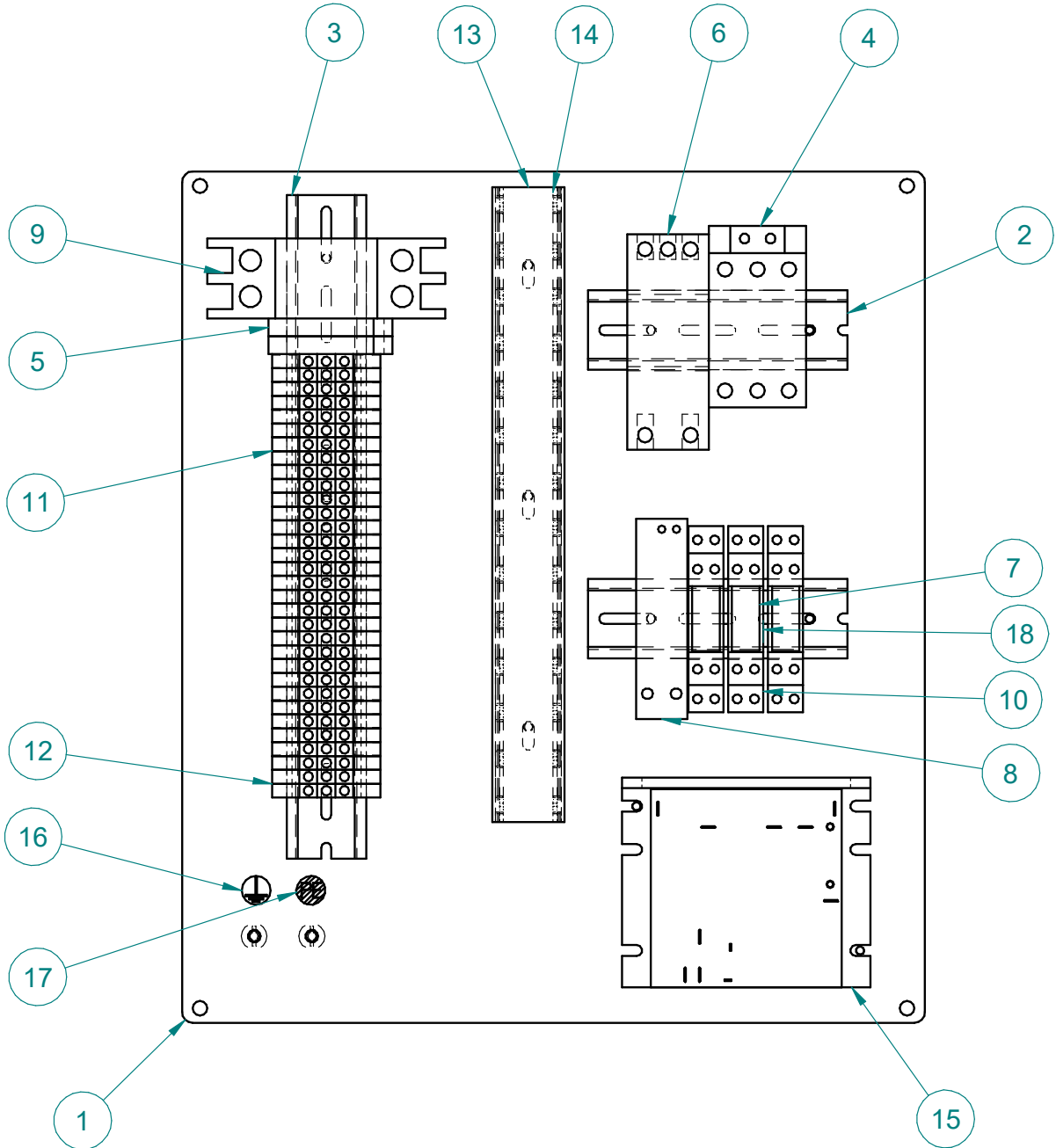
1808-D

ELECTRICAL ASSEMBLY (120V)

Item	Part Number	Description	Qty
1	1808-0121-003	PANEL-ELECTRICAL SUB	1
2	4516-3507-0036	RAIL-DIN MOUNTING 4.5"	2
3	4516-3507-0092	RAIL-DIN MOUNTING 11.5"	1
4	5713-0306	CONTACTOR-3 POLE 9A, 24VDC	1
5	5726-1251	HOLDER-FUSE DIN MOUNT	2
6	5746-5305	DC POWER SUPPLY, IDEC 60W, 24V	1
7	5749-5674	RELAY, DPDT, FINDER	3
8	5749-7029	RELAY-SOLID STATE 20A DC CONT.	1
9	5757-4327	CIRC. BRKR, 1 Pole, 13 AMP C	1
10	5770-2832	RELAY SOCKET-8 PIN	3
11	5770-7472	TERMINAL BLOCK, 10 GA.	29
12	5770-7473	TERMINAL BLOCK, 10 GA., GROUNDING	3
13	5771-6250	COVER-WIREDUCT 1" HI-TEMP	1
14	5771-6251	WIREDUCT 1 X 1.5 HI-TEMP	1
15	6309-6010	CONTROL-DC DR ADJ HP 115/230	1
16	6400-7002	SYMBOL-GROUND (EARTH)	1
17	6401-6040	NMPLT-PROTECTIVE EARTH (PE)	1
18	5749-5697	CLIP-RELAY HOLD-DOWN	3

1808-D

ELECTRICAL ASSEMBLY (208-240V)



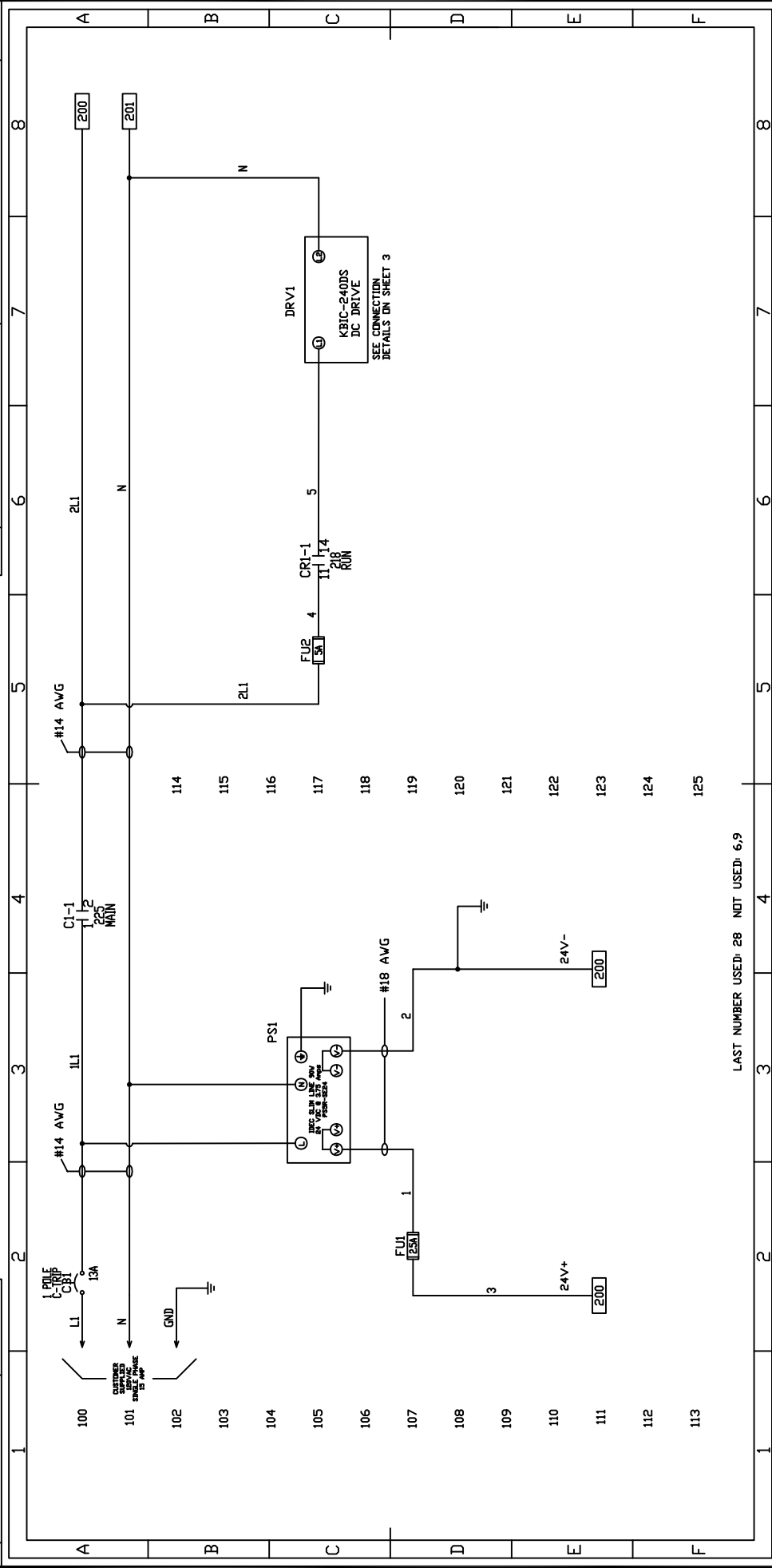
1808-D

ELECTRICAL ASSEMBLY (208-240V)

Item	Part Number	Description	Qty
1	1808-0121-003	PANEL-ELECTRICAL SUB	1
2	4516-3507-0036	RAIL-DIN MOUNTING 4.5"	2
3	4516-3507-0092	RAIL-DIN MOUNTING 11.5"	1
4	5713-0306	CONTACTOR-3 POLE 9A, 24VDC	1
5	5726-1251	HOLDER-FUSE DIN MOUNT	2
6	5746-5305	DC POWER SUPPLY, IDEC 60W, 24V	1
7	5749-5674	RELAY, DPDT, FINDER	3
8	5749-7029	RELAY-SOLID STATE 20A DC CONT.	1
9	5757-4346	CIRC. CBRKR, 2 POLE 10 AMP	1
10	5770-2832	RELAY SOCKET-8 PIN	3
11	5770-7472	TERMINAL BLOCK, 10 GA.	29
12	5770-7473	TERMINAL BLOCK, 10 GA., GROUNDING	3
13	5771-6250	COVER-WIREDUCT 1" HI-TEMP	1
14	5771-6251	WIREDUCT 1 X 1.5 HI-TEMP	1
15	6309-6010	CONTROL-DC DR ADJ HP 115/230	1
16	6400-7002	SYMBOL-GROUND (EARTH)	1
17	6401-6040	NMPLT-PROTECTIVE EARTH (PE)	1
18	5749-5697	CLIP-RELAY HOLD-DOWN	3

C1808C12014 SHEET 1 OF 3

TOOL NAME	NUMBER	ITEM	PART NUMBER	DESCRIPTION	QUAN.



LTR	CHANGE	DATE	BY	EC NO.	LTR	CHANGE	DATE	BY	EC NO.

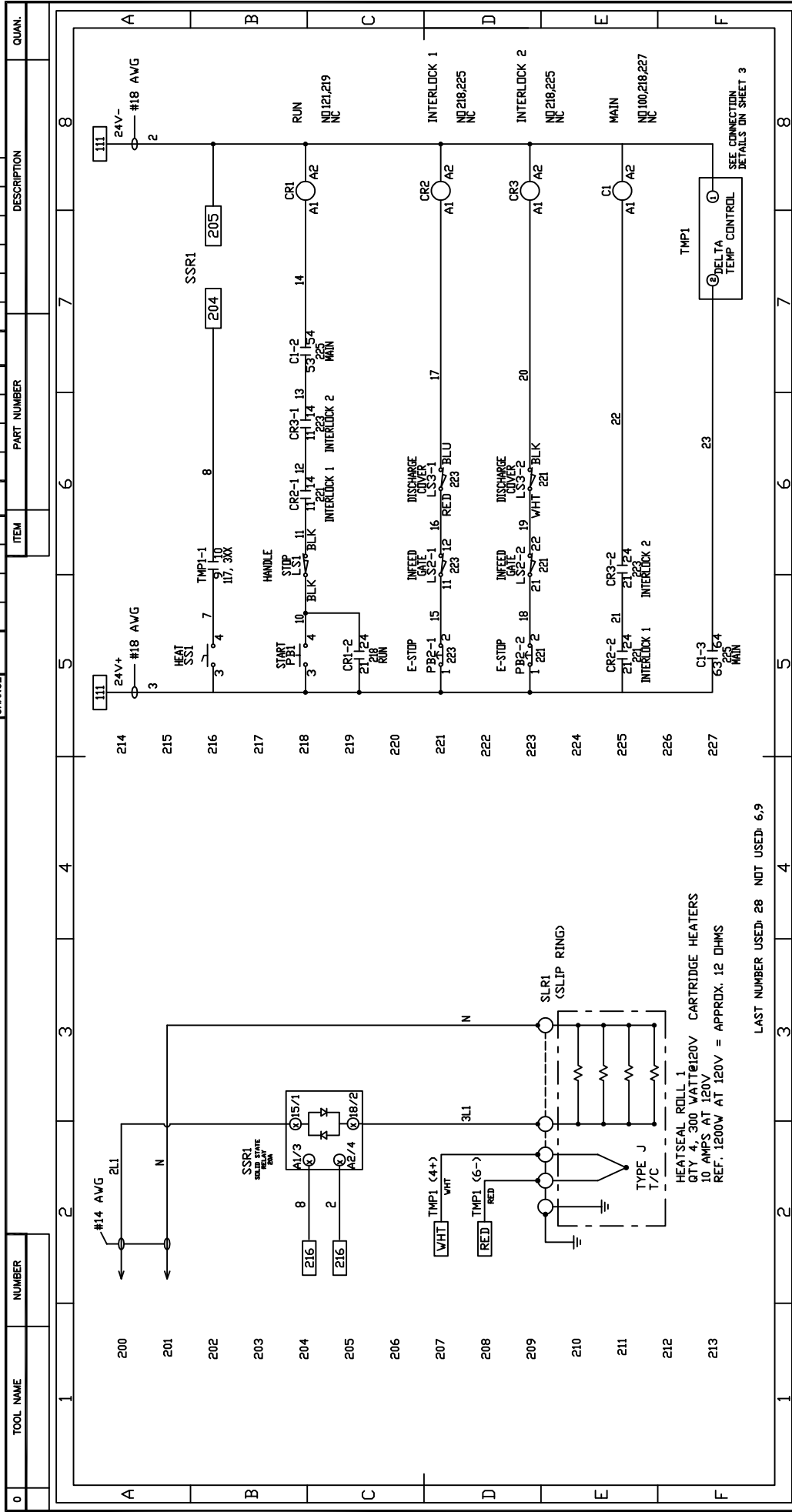
NAME: ELECTRICAL CONTROLS 1/50-60/120
 MAT'L: SEE LIST
 MAT'L NO.: SEE LIST
 DRAWN BY: V. MATZ
 DATE: 4-18-23
 SCALE: NONE
 FINISH: _____



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DO NOT SCALE THIS DRAWING. DIMENSIONAL TOLERANCES UNLESS SPECIFIED: FRACTIONAL ± 1/64; DECIMAL ± .005; ANGULAR ± 1°.


LAST NUMBER USED: 28 NOT USED: 6,9



CHANGE	TOOL NAME	NUMBER	ITEM	PART NUMBER	DESCRIPTION	QUAN.
1						
2						
3						
4						
5						
6						
7						
8						

LTR	CHANGE	DATE	BY	EC NO.	LTR	CHANGE	DATE	BY	EC NO.

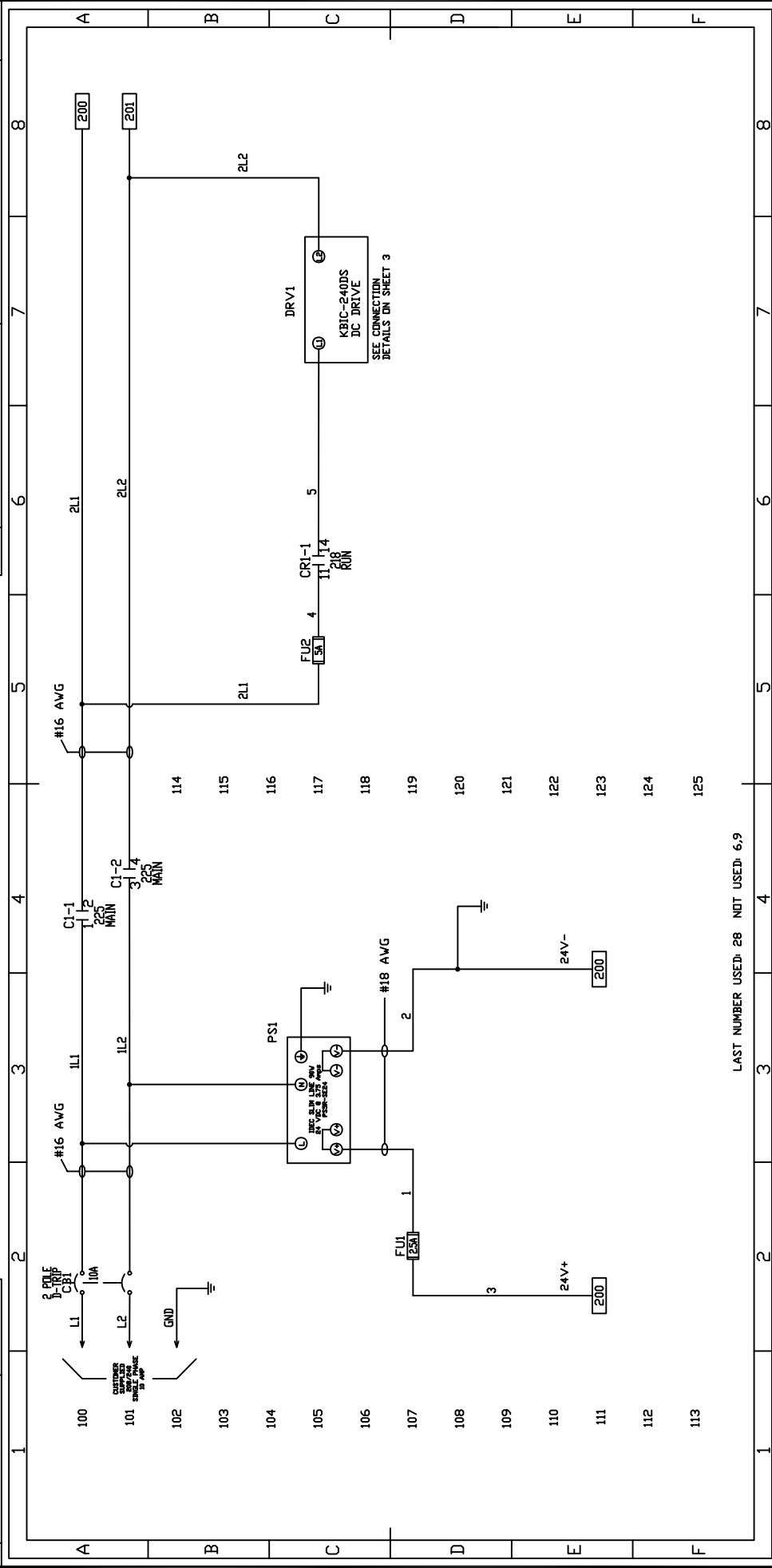
NAME	ELECTRICAL CONTROLS 1/50-60/120	
WTL	SEE LIST	
WTL NO.	SEE LIST	FINISH
DRAWN BY	V. MATZ	DATE 4-18-23 SCALE NINE
<small>EXAMPLE BARS & SHIP ERRS DIMENSIONAL TOLERANCES UNLESS SPECIFIED: FRACTIONAL ± 1/64; DECIMAL ± .005; ANGLAR ± 1°</small>		



WALKER, MICHIGAN, U.S.A. 49534

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TOOL NAME	NUMBER	DESCRIPTION	QUANTITY
CHANGE			
ITEM	PART NUMBER		



LTR	CHANGE	DATE	BY	EC NO.	LTR	CHANGE	DATE	BY	EC NO.

NAME: ELECTRICAL CONTROLS 1/50-60/208-240
 MATL: SEE LIST
 MATL NO: SEE LIST
 DRAWN BY: V. MATZ
 DATE: 1-25-23
 SCALE: NONE
 FINISH: _____

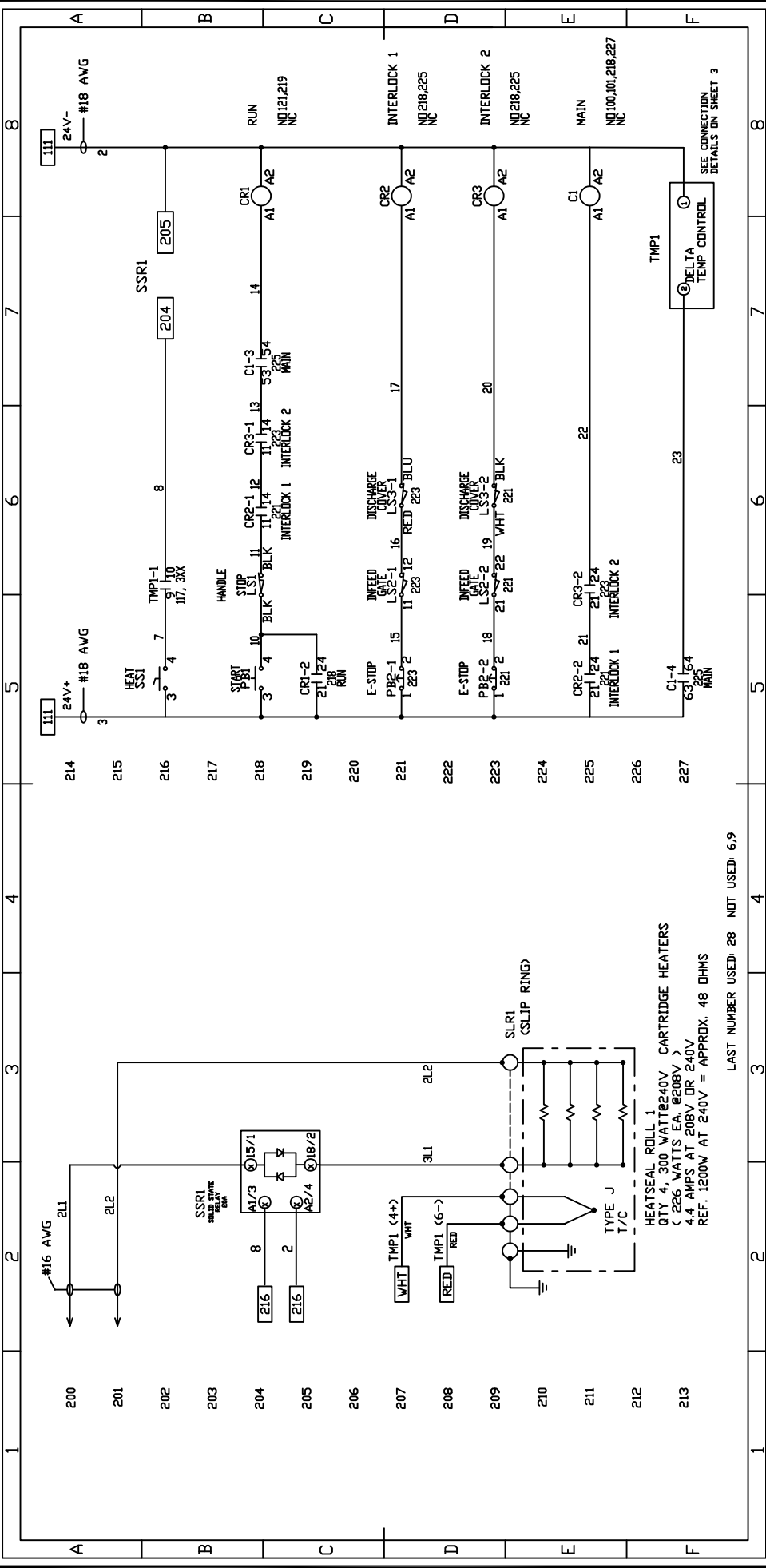


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DO NOT SCALE THIS DRAWING
 DIMENSIONAL TOLERANCES UNLESS SPECIFIED: FRACTIONAL ± 1/64; DECIMAL ± .005; ANGULAR ± 1°

LAST NUMBER USED: 28 NOT USED: 6,9

CHANGE	TOOL NAME	NUMBER	ITEM	PART NUMBER	DESCRIPTION	QUAN.
0						



LTR	CHANGE	DATE	BY	EC NO.	LTR	CHANGE	DATE	BY	EC NO.

NAME: ELECTRICAL CONTROLS 1/50-60/208-240
 MTL: SEE LIST
 MTL NO: SEE LIST
 DRAWN BY: V. MATZ
 DATE: 1-25-23
 SCALE: NINE
 FINISH: _____
 DO NOT SCALE THIS DRAWING
 DIMENSIONAL TOLERANCES UNLESS SPECIFIED: FRACTIONAL ± 1/64; DECIMAL ± .005; ANGULAR ± 1°

OLIVER
 SERVING WHAT MATTERS
 WALKER, MICHIGAN, U.S.A. 49534
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HEATSEAL ROLL 1
 QTY: 300 WATT @ 240V CARTRIDGE HEATERS
 (226 WATTS EA. @ 208V)
 4.4 AMPS AT 208V DR. 240V
 REF. 1200W AT 240V = APPROX. 48 OHMS
 LAST NUMBER USED: 28 NOT USED: 6,9

WARRANTY

PARTS

Oliver Packaging & Equipment Company warrants that if any part of the equipment (other than a part not manufactured by Oliver Packaging & Equipment) proves to be defective (as defined below) within one year after shipment, and if Buyer returns the defective part to Oliver Packaging & Equipment within one year, Freight Prepaid to Oliver Packaging & Equipment plant in Walker, MI, then Oliver Packaging & Equipment , shall, at Oliver Packaging & Equipment option, either repair or replace the defective part, at Oliver Packaging & Equipment 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) years and three (3) months from actual shipment date, whichever date comes first, will be repaired by Oliver Packaging & Equipment or an Oliver Packaging & Equipment Authorized Service Dealer, in accordance with Oliver Packaging & Equipment published Service Schedule.

For purposes of this warranty, a defective part or defective equipment is a part or equipment which is found by Oliver Packaging & Equipment to have been defective in materials workmanship, if the defect materially impairs the value of the equipment to Buyer. Oliver Packaging & Equipment has no obligation as to parts or components not manufactured by Oliver Packaging & Equipment, but Oliver Packaging & Equipment assigns to Buyer any warranties made to Oliver Packaging & Equipment 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 Packaging & Equipment Company 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 PACKAGING & EQUIPMENT COMPANY MAKES NO WARRANTY OF MERCHANTABILITY OR FITNESS FOR PURPOSE REGARDING THE EQUIPMENT COVERED BY THIS WARRANTY. Oliver Packaging & Equipment Company neither assumes nor authorizes any person to assume for it any other obligations or liability in connection with said equipment. OLIVER PACKAGING & EQUIPMENT COMPANY SHALL NOT BE LIABLE FOR LOSS OF TIME, INCONVENIENCE, COMMERCIAL LOSS, INCIDENTAL OR CONSEQUENTIAL DAMAGES.

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 Packaging & Equipment 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.



3236 Wilson Drive NW, Walker, MI 49534
800-253-3893 | 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