



S74T4B-16R-AI
HEAT SHRINK TUNNEL

Product Documentation

Model Number:

Serial Number:






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Appendix A - Electrical Schematics

Appendix B – Mechanical Drawings

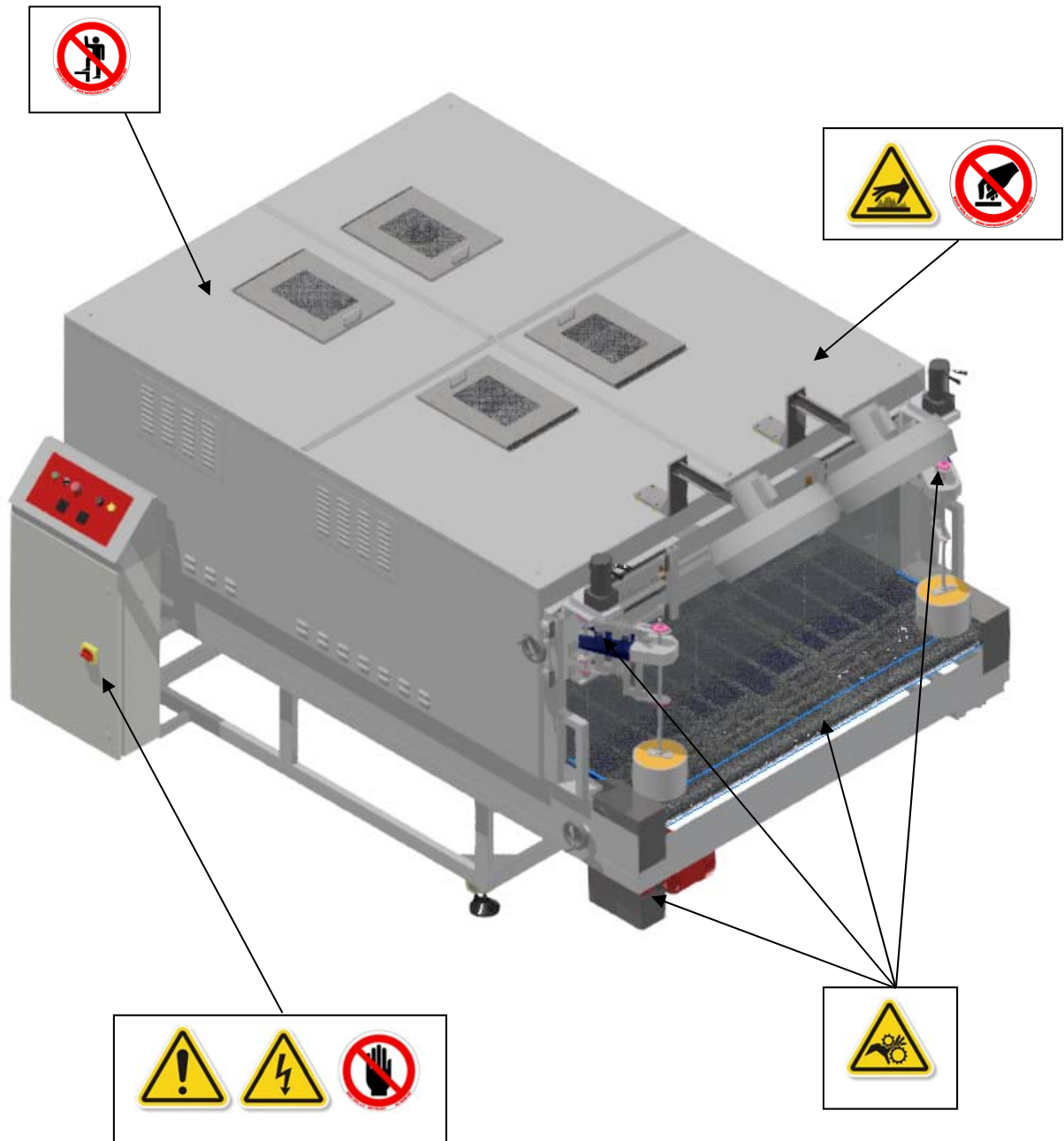
ISO SAFETY SYMBOLS – DEFINED

	<p style="text-align: center;"><u>Caution - General</u></p> <ul style="list-style-type: none"> • Do not operate machine until instruction manual has been read. • Be sure machine is connected to building electrical safety ground. • Be sure to disconnect the power before performing machine maintenance • Do not operate machine with guards removed • Do not operate machine in a manner for which it was not intended. • Do not touch heated surfaces.
	<p style="text-align: center;"><u>Caution - Heavy</u></p> <ul style="list-style-type: none"> • The machine requires a minimum of two people to move or lift. • There is a risk of personal injury if attempted to lift or move the machine alone.
	<p style="text-align: center;"><u>Caution – Pinch Hazard</u></p> <ul style="list-style-type: none"> • Be extremely careful when inserting bags into the in-feed rail. • The belt drive can grab loose clothing and/or bodily parts resulting in injury.
	<p style="text-align: center;"><u>Caution – Electrical</u></p> <ul style="list-style-type: none"> • High voltages present inside the control box enclosure. • To reduce the risk of fire or electrical shock, do not attempt to open the enclosure. • Refer servicing to qualified service personnel only.
	<p style="text-align: center;"><u>Caution – Moving Parts</u></p> <ul style="list-style-type: none"> • Moving parts contained behind guards. • Do not touch moving parts. • Severe pinching and/or dismemberment may occur.

	<p style="text-align: center;"><u>Caution – Stability Hazard</u></p> <ul style="list-style-type: none"> • This stand is not meant to be mounted in anyway other than specified. • The stand is designed to support the equipment in the way shown within the manual. • Modifications or use other than specified may result in equipment damage and personal injury.
	<p style="text-align: center;"><u>Caution – Slip Hazard</u></p> <ul style="list-style-type: none"> • If a spill or explosion occurs from a product it must be cleaned before the operator continues using the machine.
	<p style="text-align: center;"><u>Danger – Hot Surfaces</u></p> <ul style="list-style-type: none"> • Hot surfaces are present behind guards. • Temperatures can exceed 150°C during normal operation, do not touch. • Severe burns will result.
	<p style="text-align: center;"><u>Prohibited</u></p> <ul style="list-style-type: none"> • Do not attempt to open, touch, or proceed before referring to the manual.
	<p style="text-align: center;"><u>Prohibited</u></p> <ul style="list-style-type: none"> • Do not expose internal components to liquids of any kind. • Do not place liquids on top of control box. • These actions will result in damage to the equipment and may result in personal injury.
	<p style="text-align: center;"><u>Prohibited</u></p> <ul style="list-style-type: none"> • Do not use non approved lubricants on the machine as it can result in damage to the machine and void the warranty.

	<p style="text-align: center;"><u>Prohibited</u></p> <ul style="list-style-type: none"> • Do not attempt to stand or lean on the stand in anyway. • Equipment damage and personal injury may occur.
	<p style="text-align: center;"><u>Prohibited</u></p> <ul style="list-style-type: none"> • Surfaces near this label can reach temperatures sufficient to burn skin when machine is in operation or cooling down. • Do not touch, personal injury may occur.
	<p style="text-align: center;"><u>Mandatory</u></p> <ul style="list-style-type: none"> • Supporting documentation must be read before operating or maintaining the machine.
	<p style="text-align: center;"><u>Mandatory</u></p> <ul style="list-style-type: none"> • The machine requires a minimum of two people to move or lift.
	<p style="text-align: center;"><u>Mandatory</u></p> <ul style="list-style-type: none"> • The machine must be unplugged before proceeding.
	<p style="text-align: center;"><u>Mandatory</u></p> <ul style="list-style-type: none"> • The machine must be locked out before proceeding.

ISO SAFETY SYMBOLS – LOCATION



PLEXPACK

S74T4-16R-AI-EX

OPERATION MANUAL

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CAUTION:

To ensure the safe operation of this machine and the safety of the operator this manual must be read and understood before proceeding.



This document has been produced by:

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- The directives in this document are in accordance with the design and construction of the unit at the time it was released by the Plexpack production facility.

1.0 INTRODUCTION

1.1 GENERAL DESCRIPTION

The S74T4-16R-AI is a completely automatic high production shrink tunnel capable of accepting products on a continuous basis. The purpose of the shrink tunnel is to expose the film around the package to a flow of heated air (at a pre-set temperature) for a specific period of time. The temperature is thermostatically controlled so that once it has been set, there is no further heat adjustment required. The length of time a package spends within the heat chamber is determined by the speed of the shrink tunnel conveyor. This, too, can be set at whatever speed is required and that speed will be held constant.

An additional air uplift system helps extra film (due to smaller products being wrapped with wide film) fold over, reducing the overall bundle size. The discharge side rollers also help to further compress extra film to the product and enclose the side of the product.

1.2 SPECIFICATIONS

VOLTAGE	600 VAC
NUMBER OF PHASES	3
FREQUENCY	60 Hz
MAXIMUM AMPERAGE	65 A
MAXIMUM WATTAGE	56.3 kW
HEAT WATTAGE	52.8 kW
MAXIMUM SPEED	100 ft/min (30.5 m/min)
TEMPERATURE RANGE	320°F - 428°F (160°C - 220°C)
WEIGHT	4000 lbs (Crated) (1818 kg)
CHAMBER WIDTH	74" (188cm)
STANDARD CHAMBER HEIGHT	16" (41 cm)
OVERALL LENGTH	147" (373 cm)

TABLE - 1

1.3 MACHINE PARTS DIAGRAM

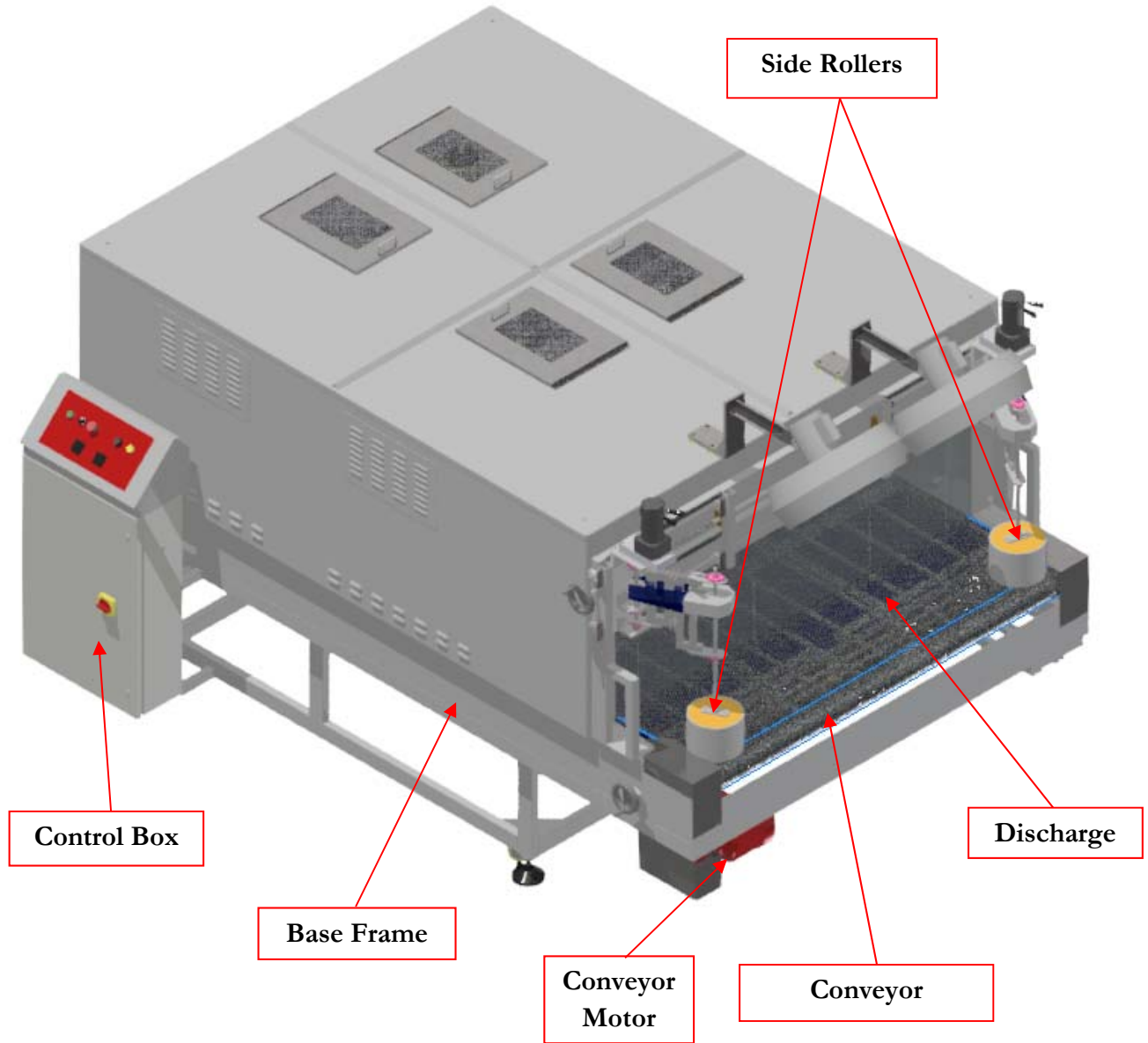


FIGURE - 1

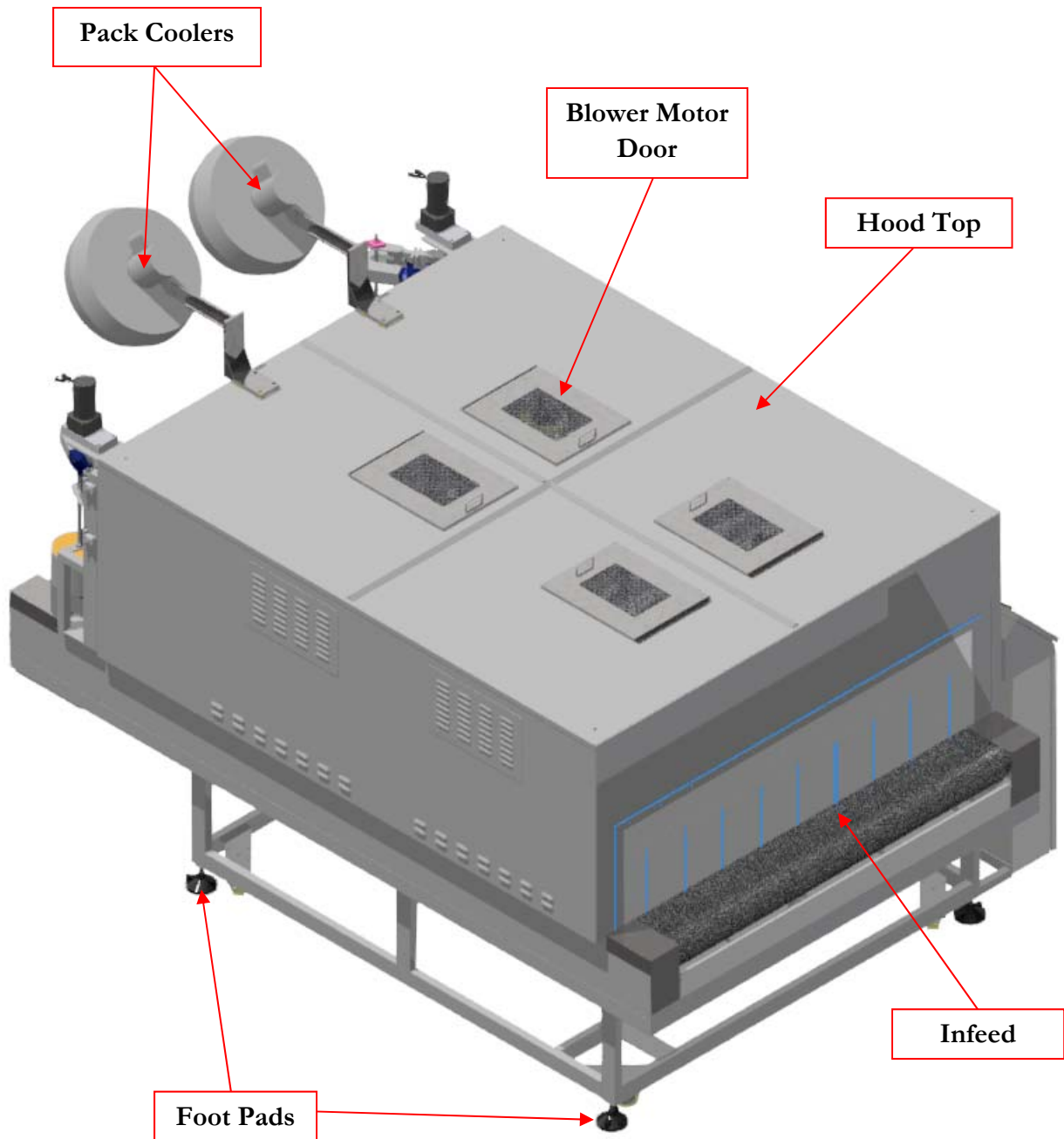


FIGURE - 2

1.4 DIMENSIONAL DIAGRAM

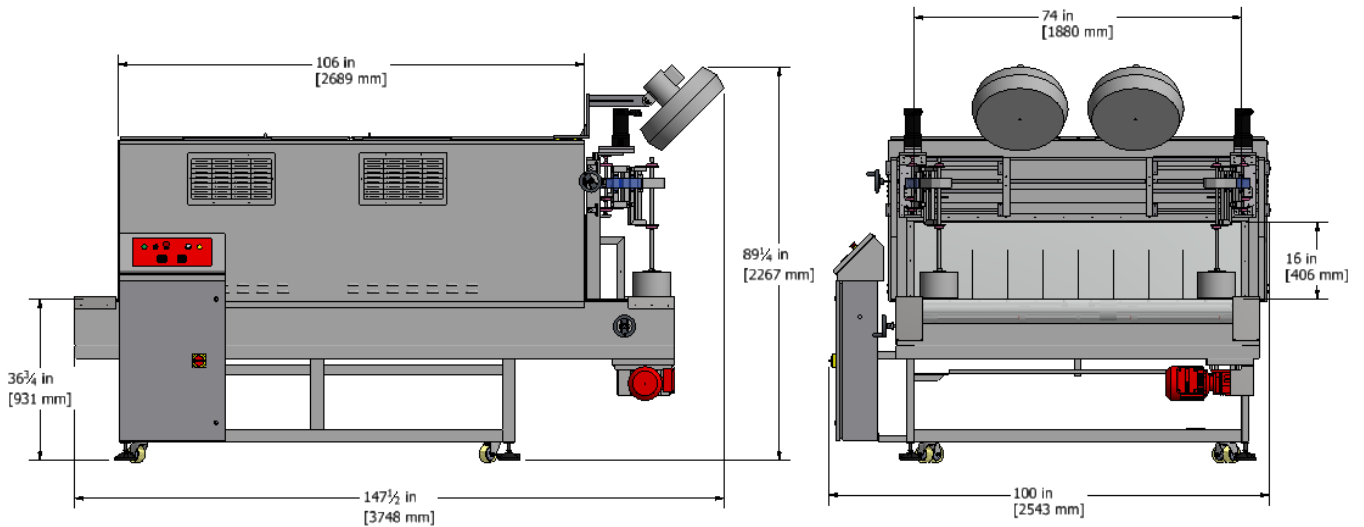


FIGURE - 3

2.0 UNPACKING AND ASSEMBLY

For convenience and safety reasons the S74T4-16R-AI heat tunnel is shipped fully assembled. Take caution when unloading and uncrating. Failure to follow proper procedures could result in serious injury.

Tools Required	Number of Persons Needed
1. Tin Snips or Cutters 2. Crow Bar or Pry Bar 3. Claw Hammer	2

TABLE - 2

- 1) Remove the wooden frame surrounding the machine and 2" x 4" blocks of wood that stop the base machine from moving.
- 2) Remove the first layer of plastic wrap to uncover the machine.
- 3) Use a pair of cutters or tin snips to cut the metal straps securing the machine to the skid. Take extreme caution after braces and straps are removed since the machine is no longer attached to the skid.

CAUTION: This assembly weighs in total over **3000 lbs**, please use a fork lift to remove this from the skid.



- 4) Casters should be on the machine already so that it can be rolled into position after being removed from the wooden skid.
- 5) Use a fork lift to remove the machine from the wooden skid. See lift points in Figure #4.

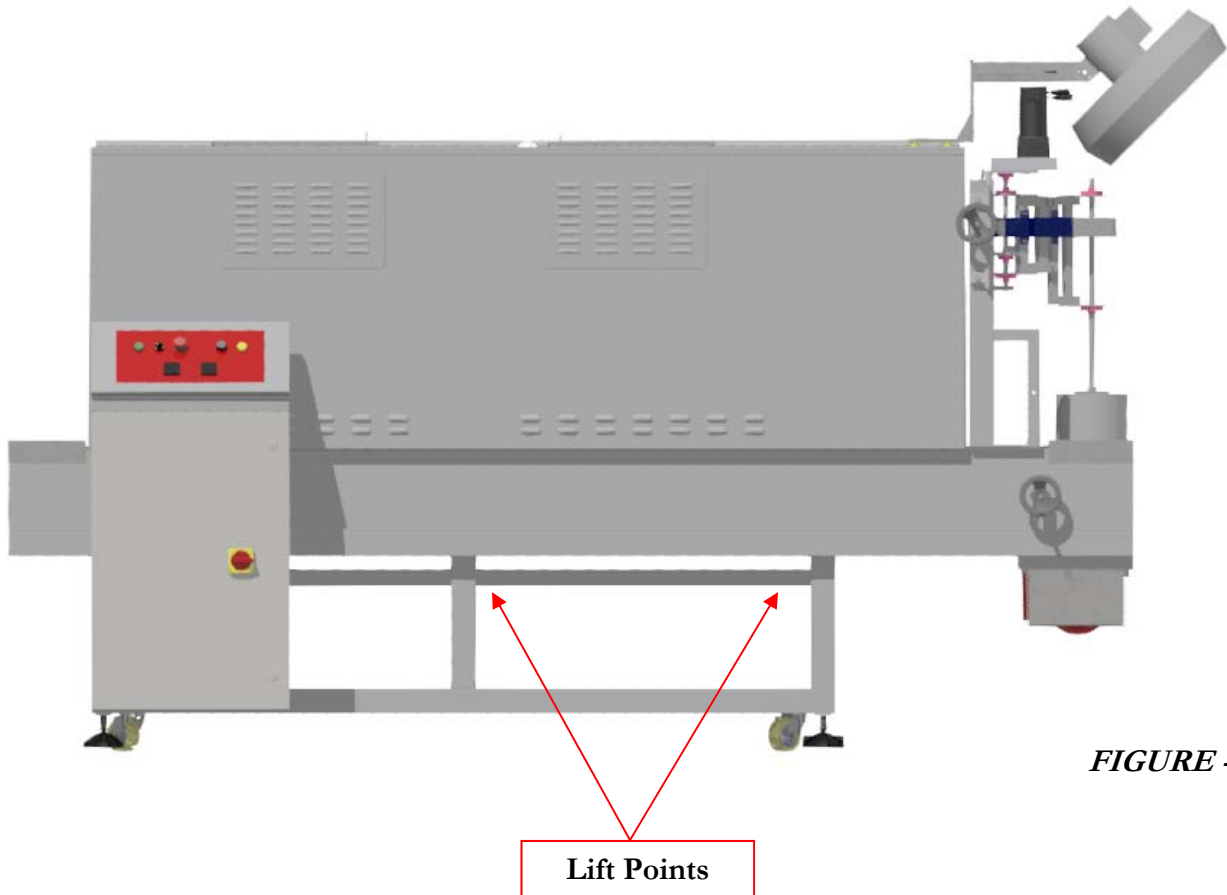


FIGURE - 4

- 6) Remove any spare parts ordered with the machine; they will be located inside of the tunnel.

3.0 CONTROL BOX FEATURES

S74T4-16R-AI heat tunnels are large production shrink tunnels; they are capable of accepting products on a continuous basis. The following describes the main machine features on the control box as seen in Figure #6 & 7:

- 3.1 **POWER ON LIGHT/BUTTON:** the Power On Light will illuminate when the machine is operational. Also, if the stop button has been pressed and the off-on switch is still in the ON position, this button must be pressed to start-up the machine again.
- 3.2 **ON-OFF SWITCH:** The off-on switch will start all machine functions. Turning this switch off will initiate the auto cool down cycle; turning the heat off while leaving the blowers and conveyor running. This will run for approximately 35 minutes.
- 3.3 **STOP BUTTON:** Stops all functions of the machine when pressed. This button should only be used to temporarily stop the machine, or when it is necessary to quickly stop all functions of the machine.
- 3.4 **PACK COOLER:** the on-off switch for the discharge pack coolers.
- 3.5 **CONVEYOR SPEED:** The speed pot used to set the desired speed of the shrink tunnel conveyor.
- 3.6 **AUTO SHUT DOWN:** The Auto Shot Down light will illuminate when the auto cool down cycle is activated. Turning the Off/On Switch to off will initiate the auto cool down cycle, turning the heat off while leaving the blowers and conveyor running. This will run for approximately 35 minutes.
- 3.7 **SIDE ROLLERS:** the speed pot used for the discharge side rollers speed.
- 3.8 **DISCONNECT:** Disconnects power when opening the control box. The disconnect lever also has a Lockout/Tagout (LOTO) feature when turned to the OFF position that allows for Lockout of the machine during maintenance.
- 3.9 **BYPASS:** on-off switch for enabling/disabling bypass mode. The tunnel heaters will be disabled in bypass mode while the conveyor will continue running at the desired speed to allow for product to pass through the tunnel not shrunk.

3.10 AIR UPLIFT TIMERS: timers used to turn on the air uplift and set the duration. The top timer will enable the air uplift after the set time has passed; the bottom timer will set the duration of time the air uplift is enabled.

3.11 TEMPERATURE CONTROLLERS: There are two separate temperature controllers on S64T4 tunnels. Zone 1 controls the temperature on the in-feed side of the tunnel and zone 2 controls the heat on the discharge side of the tunnel. There are four buttons that operate the digital temperature controller and two digital displays as shown in Figure #5. Please refer to Figure #6 for the location of the temperature controllers.

- 1) The Level key – Locked out. For maintenance use only.
- 2) Display key – Locked out. For maintenance use only.
- 3) The Up key – Move the set point value up.
- 4) The Down key – Move the set point value down.
- 5) The Process Value display - the current temperature at which the machine is running.
- 6) The Set Value display - the temperature that has been selected for operation.



FIGURE - 5

The temperature controller is an auto-tune PID type, which should keep temperature constant within a desired range. There is a lockout setting on the temperature controller to prevent users from changing the internal values of the temperature controller, if assistance is needed please get in touch with Plexpack Technical Support.

- 1) Press the arrow keys to either raise or lower the set point temperature to its desired value.
- 2) Once you have selected the desired temperature, the controller retains the displayed value.
- 3) The value in the “Process Value” screen will now change to match your selected temperature value. Once the “Process Value” matches the “Set Value,” the machine is ready to seal your product.

CAUTION: The machines control box should only be accessed by an authorized service representative.



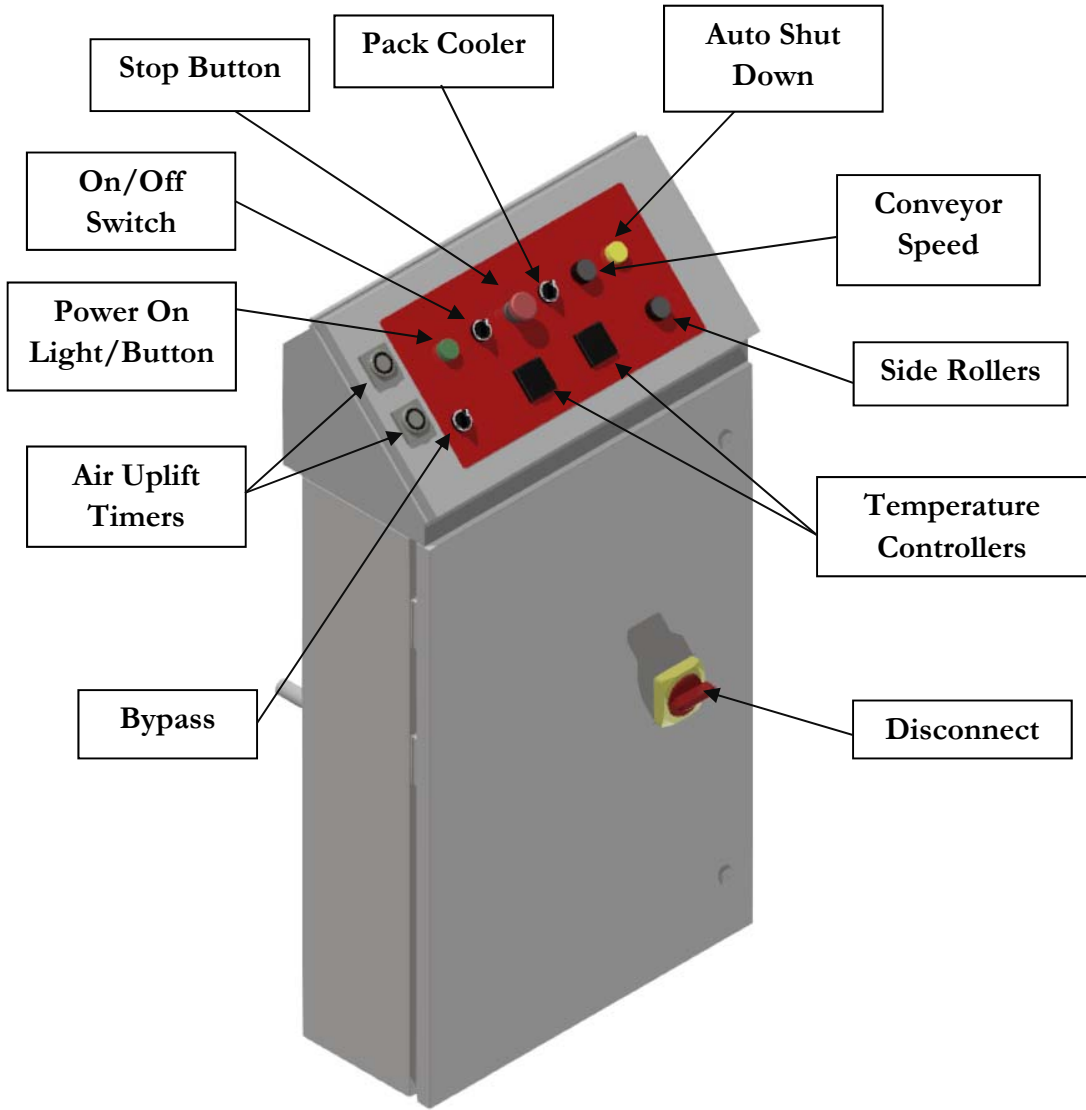


FIGURE - 6



FIGURE - 7

4.0 OPERATION

- 1) Have a qualified technician install 600VAC 3-phase to the control box disconnect.
- 2) Install a compressed airline to the regulator that is capable of reaching 70 psi at 10 CFM.
- 3) The first time the machine is to be used, check to ensure that the speed controller knob is turned to the most-left position. This is the off position of the conveyor. When this has been checked, the Off-On Switch can be turned to the “ON” position.
- 4) Next, the power on button must be pressed. The green light will illuminate and the blowers will start up.
- 5) Next, turn the conveyor knob slightly to the right until the conveyor moves. Allow the conveyor to run for approximately one minute, observing it to ensure all rollers are in place (in the case of the roller-type conveyor), or to make sure that there aren't any obstructions (in the case of the mesh belt conveyor). Listen for any noise caused by metal-on-metal contact. When the conveyor has finished one complete revolution safely without excessive noise, it can be assumed that the conveyor is free of obstructions and is ready for use.
- 6) Set the temperature controllers to a heat setting of 80°C (170°F). Carefully lift the curtains at the exit of the shrink tunnel to check if the heaters are operating. You should feel warm air escaping from the tunnel. The thermostat can now be set at operating temperature to prepare for operation.
- 7) It is recommended that the starting heat setting should be 150 to 180°C (300-355 °F).
- 8) A certain amount of trial and error should be expected in order to achieve optimum results. This trial and error process involves both temperature settings and conveyor speeds.
- 9) Basically, a shrink tunnel can be described as a heat chamber with a conveyor running through it. Because of the wide variety of films available, it is impossible for us to suggest exact settings for the controls. Outside influences can also affect the operation. Each film and/or package requires exposure to heat for a certain period of time. Some films respond better to low heat, some to higher temperatures.

- 10) To start up, it is advisable to set the heat control to 160°C (300°F) and set the conveyor speed control at the mid-point. Try a few packages and look closely at the results. An important point to remember when checking the results of finished packages is that if the film being used is polyethylene, it is the only film that continues to shrink after it exits the shrink tunnel. Therefore, it is advisable to let a package stand at room temperature for approximately thirty seconds before judging its acceptability.
- 11) If at that point, the package is loose or wrinkled, it is usually an indication of either too little heat or too little time in the shrink chamber. If the package has burn holes in the film, it is a result of either too much heat or too much time in the shrink tunnel. If either of these situations occurs the easiest course of action is to either slow down or speed up the conveyor speed. This should produce an attractive, tight package; if not, then an adjustment to the temperature, whether up or down, would be necessary.
- 12) The pack coolers can be used to quickly reduce the temperature of the package as it exits the tunnel. This is desirable if the package is to be handled by an operator directly after it exits the tunnel.
- 13) The air uplift can be used on smaller packages using wide film where the excess film wants to be blown towards the centre of the package, reducing the overall package size.
- 14) Once the final speed of the conveyor is known, match the side rollers to this speed using a tachometer.

5.0 RELEVANT MISUSE

The use of this machine for any other operation other than heat shrinking is strictly prohibited. Failure to comply with these terms will result in damage to the machine, possible injury to the operator and will void the warranty of the machine. Below are some examples of relevant misuse, please refrain from these actions or any other action which can harm the operator or damage the machine.

5.1 MISPLACED LIQUIDS

The DZ tunnels are not waterproof and should not have liquids of any kind placed on the equipment at any time.

CAUTION: *Electrical shock and damage to equipment will be a direct result of placing liquids on the machine.*



5.2 USE OF NON APPROVED LUBRICANTS

The S64T4 tunnels come from the factory containing specific lubricants on two separate parts of the machine; the conveyor chain and the pillow block bearings. Please use lubricants which meet or exceed the specifications of the factory installed lubricants shown in section 3.4 of the maintenance manual.

CAUTION: *Only qualified service personnel should attempt replacing the lubricants on this machine, please refer to the maintenance manual for procedures.*



5.3 STANDING ON THE MACHINE

The S64T4 tunnels are physically stable designs however by no means should one attempt to stand on the machine. Serious injury or damage to the machine could result from these actions. Do not attempt to place any other items on the machine.

CAUTION: *Do not attempt to stand, lean or place any other items on any part of the machine.*



6.0 MAINTENANCE

Please refer all maintenance of this machine to a qualified service technician, review the maintenance manual for procedures and safety information while performing maintenance.



PLEXPACK

S74T4-16R-AI

MAINTENANCE MANUAL

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Precaution

1.0 General Procedures

- 1.1 De-energizing and Lockout Procedure
- 1.2 Cooling Time
- 1.3 Removing Idler End Covers
- 1.4 Removing Drive End Covers
- 1.5 Removing Heating Element Cover
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- 1.7 Opening the Control Box (OFF position)
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- 1.9 Adjusting Blower Motor Speed

2.0 Maintenance

- 2.1 Replacing Fan Belt on Blower Motors
- 2.2 Conveyor Inspection and Lubrication

3.0 Preventative Maintenance

- 3.1 Surface Cleaning
- 3.2 Internal Cleaning
- 3.3 Micro Biological Materials
- 3.4 Conveyor Chain and Bearing Lubricants
- 3.5 Service Schedule

4.0 Trouble Shooting Guide

CAUTION:

To ensure the safety of the service technician this manual and the operator manual must be read and understood before proceeding.



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Canada

- The directives in this document are in accordance with the design and construction of the unit at the time it was released by the Plexpack production facility.

1.0 GENERAL PROCEDURES

1.1 DE-ENERGIZING AND LOCKOUT PROCEDURE

CAUTION: Risk of electrical shock if the machine has not been properly de-energized and locked out prior to performing maintenance procedures.



- 1) First the machine must be powered off using the main power switch on the left of the control box. Set the switch to the OFF position. Allow the machine to finish its proper cool down cycle before proceeding further.
- 2) Unplug the main power cord from the wall outlet or the back of the control box. To lockout the machine the main power cord must be COMPLETELY REMOVED and in the possession of the service technician at all times.

1.2 COOLING TIME

The heating elements of the S74T4-16R-AI tunnels operate between 160°C and 200°C which can cause serious burns if the surrounding metal is touched by the service technician. The table below shows average cooling time from the maximum temperature of 200°C over a time lapse of a 35 minute cool down cycle. After cool down is complete wait at least another 3 hours before attempting to touch any internal components.

CAUTION: Hot surfaces may be exposed. To prevent personal injury do not attempt to touch the internal components or surrounding areas while hot.



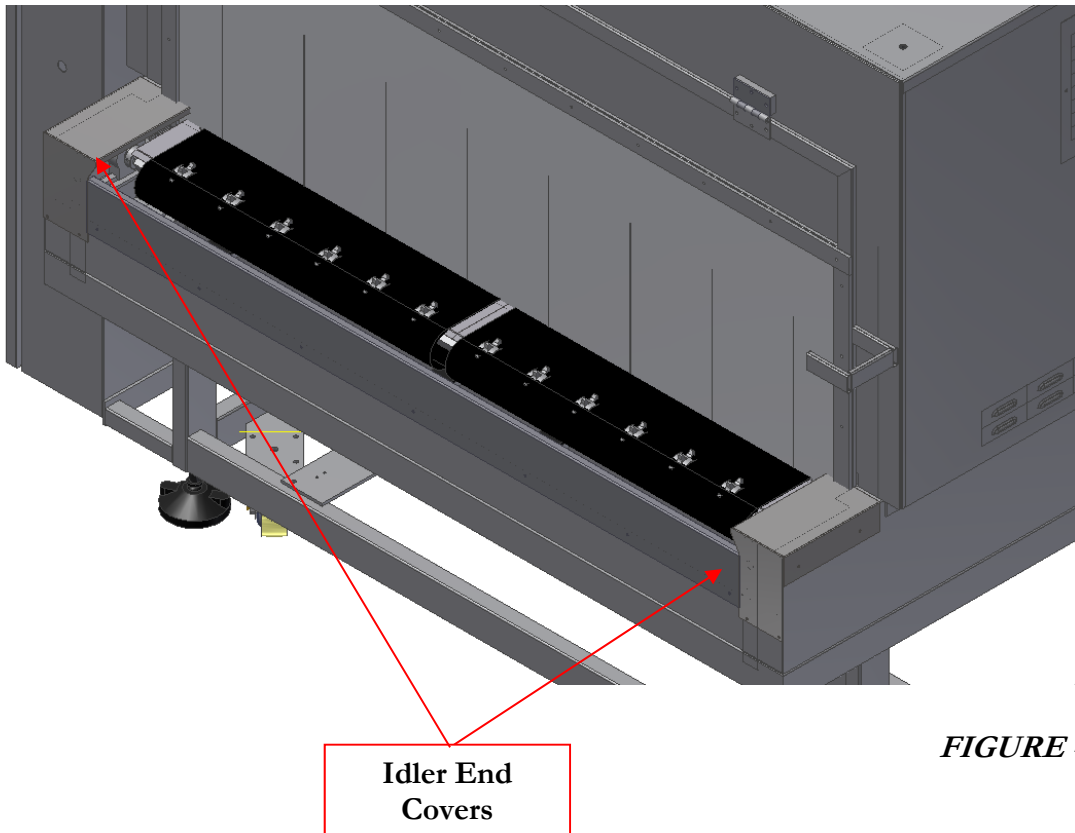
<u>TIME</u> (minutes)	<u>TEMPERATURE</u> (°C)
0	200
5	160
10	137
15	124
20	112
30	92
35	85

TABLE - 1

1.3 REMOVING IDLER END COVERS

Removal of the idler end covers allows for proper access to the take-up bearings supporting the idler shaft and tensioning the conveyor belt. This procedure must always be followed in order to reduce the risk of injury to the service technician.

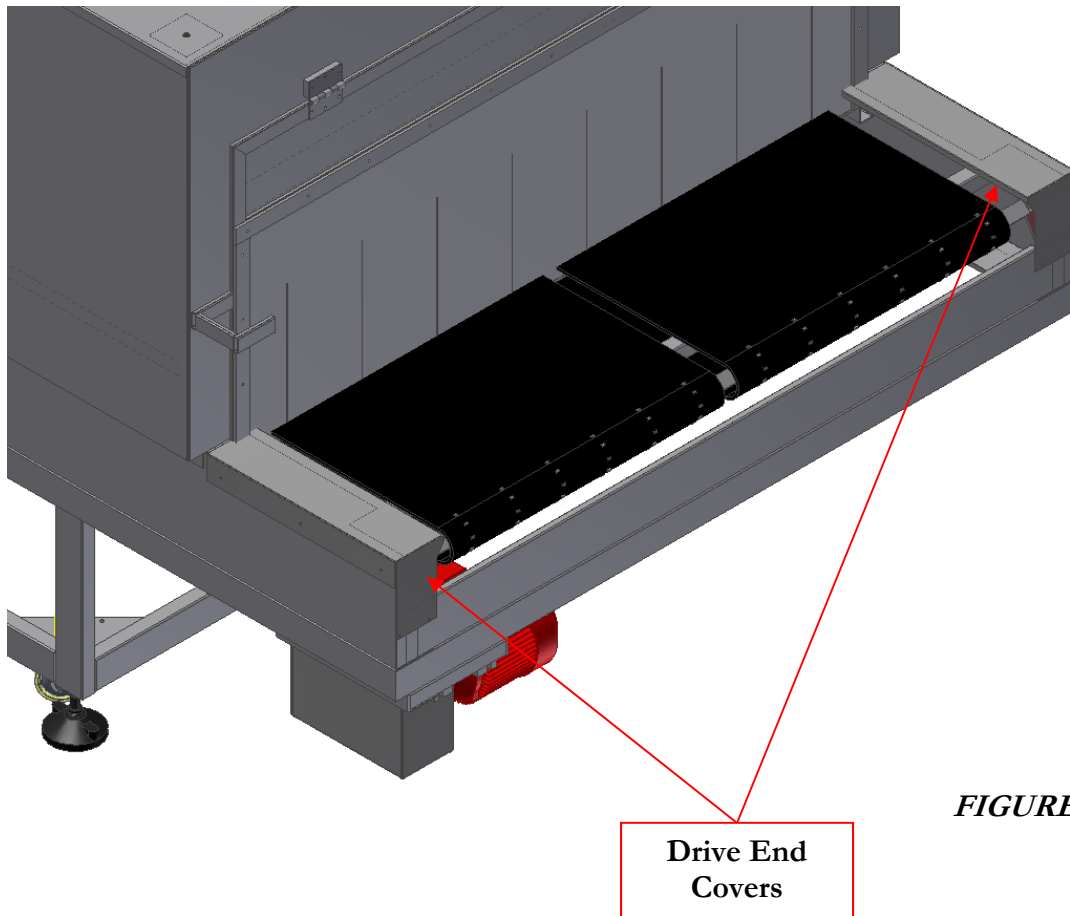
- 1) Once the machine has been locked out in a de-energized state it is now safe to loosen off the screws on each end cover as shown in Figure #1.
- 2) Proper access the inside the conveyor idler end is now available.

*FIGURE - 1*

1.4 REMOVING DRIVE END COVERS

Removal of the drive end covers allows for proper access to the pillow block bearings supporting the drive shaft and the drive chain for the conveyor. This procedure must always be followed in order to reduce the risk of injury to the service technician.

- 1) Once the machine has been locked out in a de-energized state it is now safe to loosen off the screws on each end cover as shown in Figure #2.
- 2) Proper access inside the conveyor drive is now available.

*FIGURE - 2*

1.5 REMOVING HEATING ELEMENT COVER

Removal of the heating element cover allows for access to the heating elements for the tunnel. This procedure must always be followed in order to reduce the risk of injury to the service technician.

- 1) Once the machine has been locked out in a de-energized state, ensure proper cool down time has passed. Refer to section 1.2.
- 2) Climb inside the tunnel and remove the heating element covers shown in Figure #3.
- 3) Proper access to the heating elements is now available.

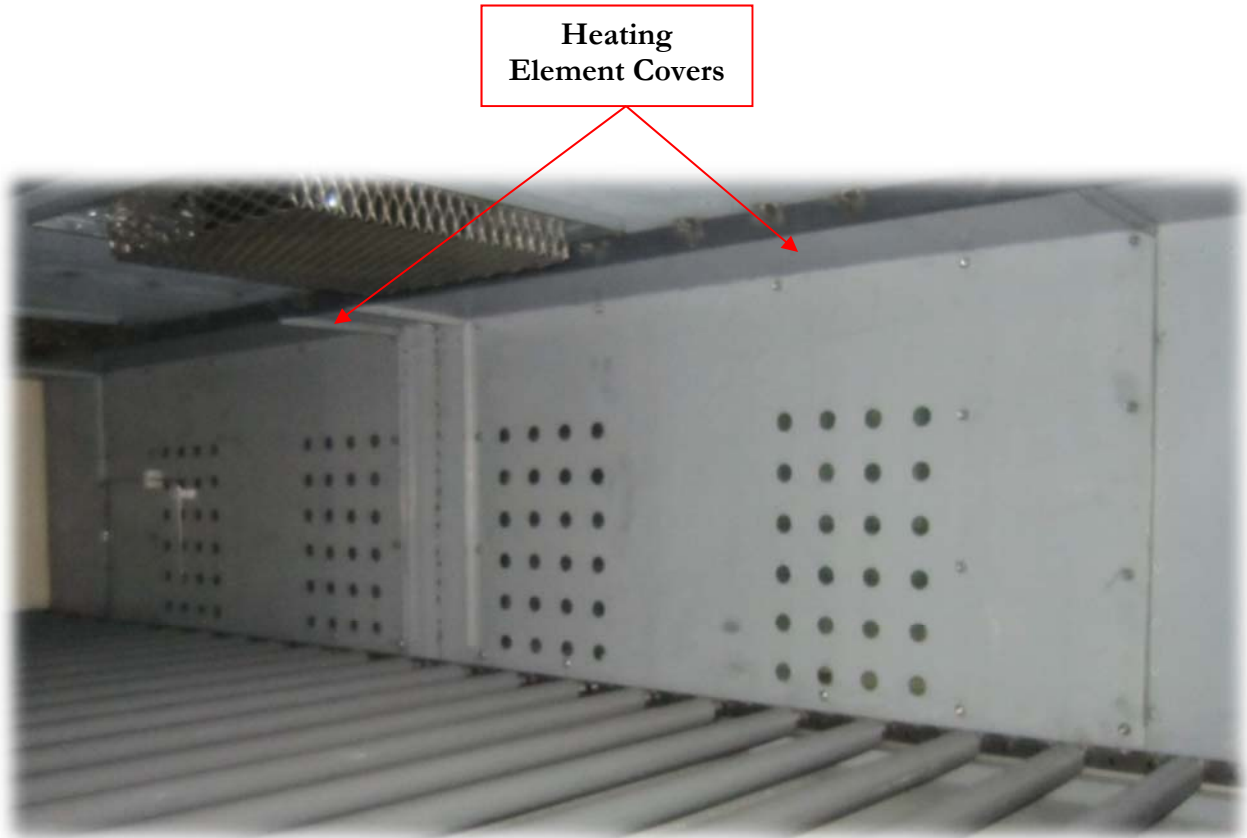
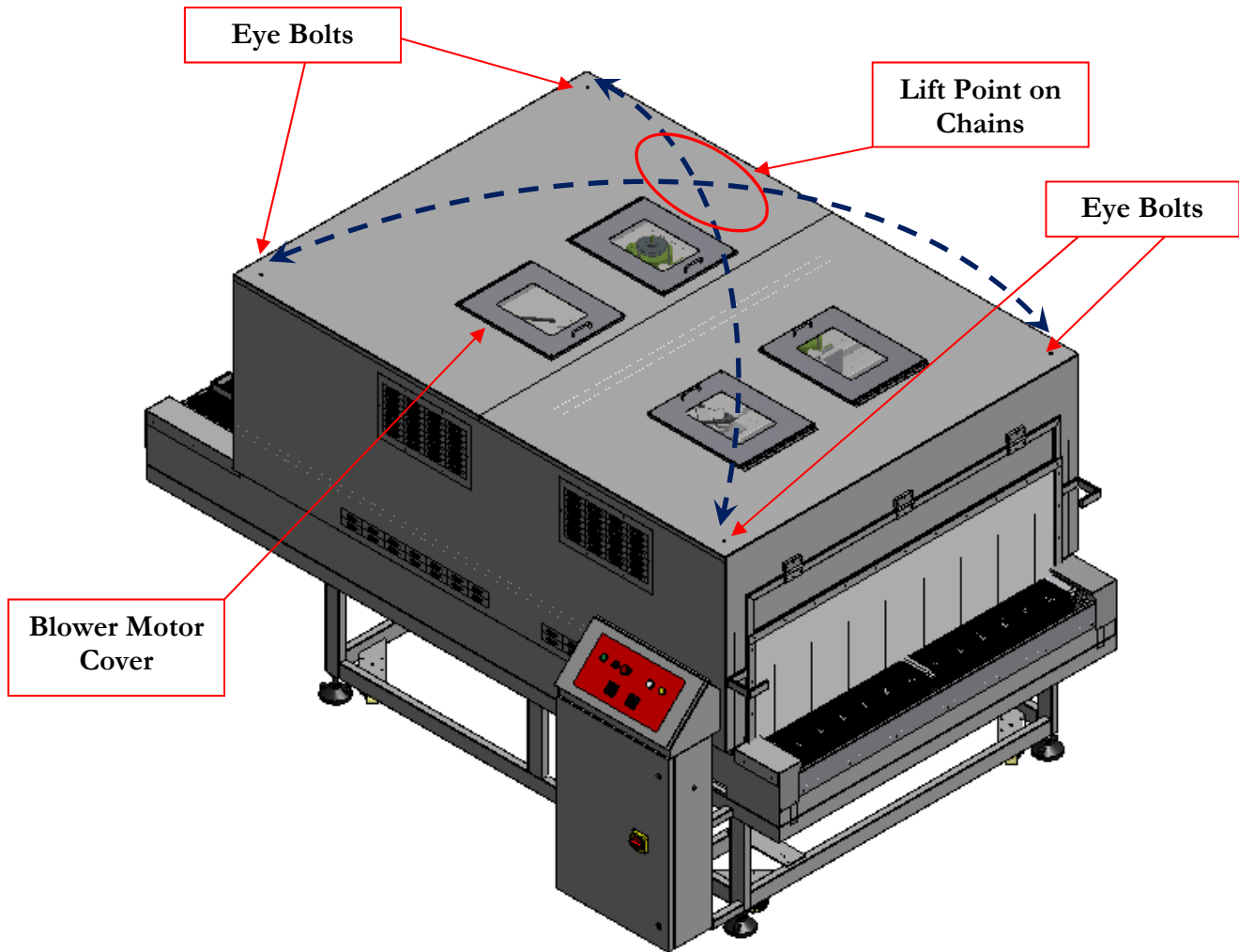


FIGURE - 3

1.6 REMOVING HOOD TOP

- 1) Once the machine has been locked out in a de-energized state it is now safe to remove the bolts holding the hood top in place.
- 2) Screw in four eyebolts on the top corners of the hood top.
- 3) Attach two chains to opposite corners on the hood top. Make sure that the chains cross each other in the center of the hood top.
- 4) Use a fork lift under both chains where they cross in the middle of the hood top to lift the hood top clear of the machine. Refer to Figure #4 for orientation.

*FIGURE - 4*

1.7 OPENING THE CONTROL BOX (OFF position)

For some trouble shooting and maintenance procedures it is necessary to open the control box. It is very important to ensure the machine is in a de-energized state and locked out before proceeding as all the electrical components are inside.

- 1) Once the machine has been locked out in a de-energized state it is now safe to open the control box as shown in Figure #5.
- 2) First, the door lock screw must be given a half-turn counter-clockwise.
- 3) The handle can now be turned counter-clockwise to the OFF position.

- 4) Once at the OFF position, the yellow switch must be pushed clockwise and held while pulling the door towards you and the door should open. Sometimes the door handle needs to be jiggled a bit to unhook it from the disconnect locking shaft.
- 5) When the handle is in the OFF position a small tab can be pulled out from the centre of the handle and used for LOTO for maintenance safety.

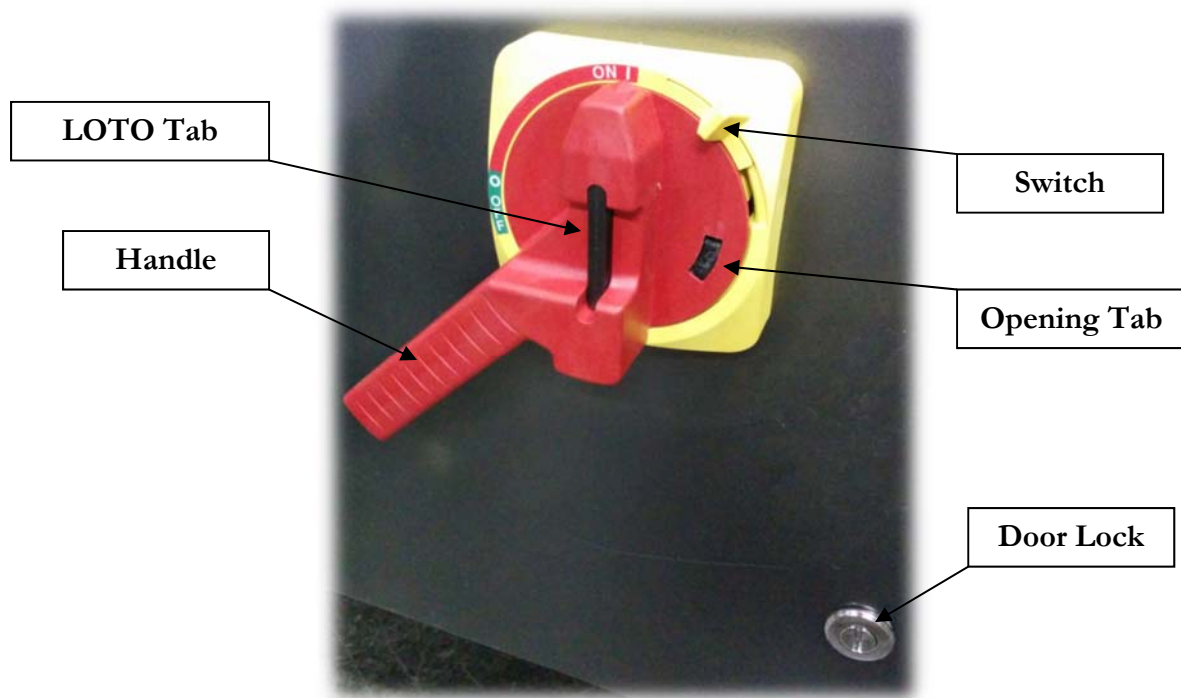


FIGURE - 5

1.8 OPENING THE CONTROL BOX (ON position)

For some trouble shooting procedures it is necessary to open the control box while the machine is still running. Please take extreme care as the wires are live and can cause extreme harm if touched incorrectly.

CAUTION: Exposure to live electrical components. Only qualified service technicians should attempt this procedure.



- 1) To open the control box while the machine is still running, first unlock the door by turning the door lock screw half a turn counter-clockwise shown in Figure #5.
- 2) Next, simply place a flathead screwdriver in the opening tab and push it down.
- 3) While pushing the tab down pull the handle towards you and the door will open.

1.9 ADJUSTING BLOWER MOTOR SPEED

To adjust the speed of the blower motor the DZ tunnel must running in normal operating conditions. Follow proper start-up and running procedures as outlined in the S74T4-16R-AI Operator manual.

- 1) Open the control box by following section 1.8.
- 2) Locate the AC drive in the top left of the control box.
- 3) Adjust the potentiometer to change the frequency to the desired range. (adjustment range is from 35-60 Hz) Location of the controls on the AC drive is shown in Figure #6.
- 4) After the blower motor has been adjusted to the desired speed close the door on the control box.



FIGURE - 6

2.0 MAINTENANCE

When performing maintenance procedures it is a good rule of thumb to inspect and lubricate rotating components to avoid downtime caused by component failure. Proper maintenance will help maintain consistent sealing for future products.

2.1 REPLACING FAN BELT ON BLOWER MOTORS

- 1) It is necessary to follow the lockout procedure 1.1, and be aware of section 1.2 which states the cooling times of the tunnel before continuing.

CAUTION: *Hot surfaces may be exposed. To prevent personal injury do not attempt to touch the internal metallic components or surrounding areas while hot.*



- 2) Next, you will need to open the blower motor door located on the top of the tunnel as shown in Figure #4.
- 3) After the door has been opened inspect the cooling fan belt for any cracks or wear, if so replace immediately.
- 4) Inspect the two bearings on the fan shaft for wear, if damaged or worn replace. Refer to Figure #7 location.
- 5) Repeat steps 1-4 for the other blower motor assemblies.

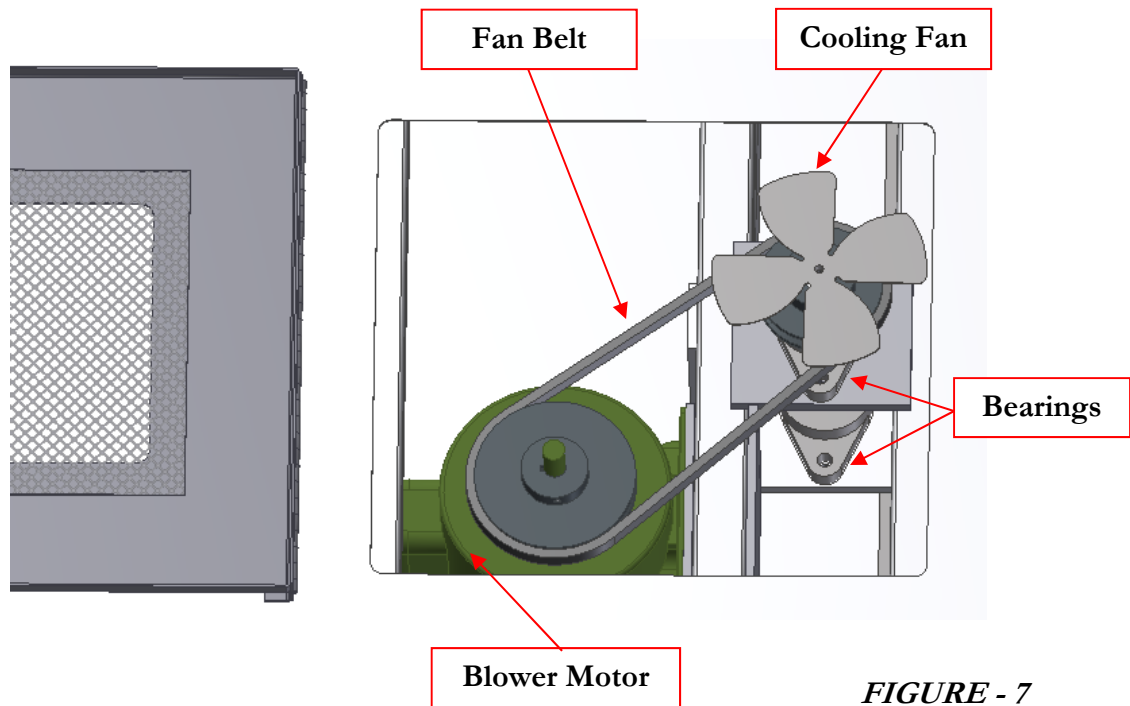


FIGURE - 7

2.2 CONVEYOR INSPECTION AND LUBRICATION

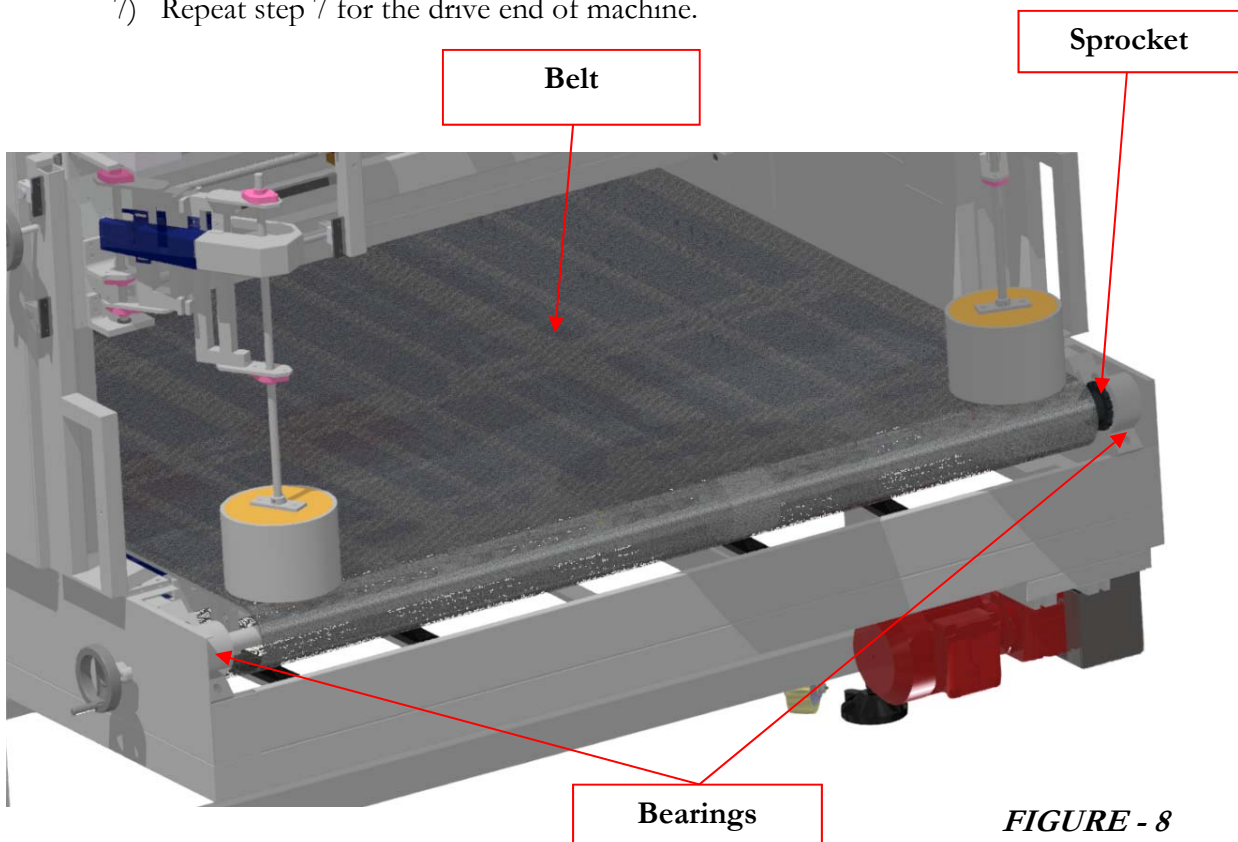
For conveyor inspection and lubrication follow the steps outlined below. Refer to Figure #8 for steps 4-8:

- 1) It is necessary to follow the lockout procedure 1.1, and be aware of section 1.2 which states the cooling times of the sealing bars before continuing.

CAUTION: Hot surfaces may be exposed. To prevent personal injury do not attempt to touch the internal metallic components or surrounding areas while hot.



- 2) Next, you will need to remove the idler end covers. Refer to section 1.3 for the procedure.
- 3) Next, you will need to remove the drive end covers. Refer to section 1.4 for the procedure.
- 4) Inspect the belt for wear, or damage, if so replace as necessary. This is also a good time to clean off any melted plastic from the belt.
- 5) Inspect the sprockets on both the drive and idler ends of the machine for wear or damage.
- 6) Inspect the bearings on either end the idler and drive shaft. Use light grade oil to lubricate bearings, as outlined in section 3.4.
- 7) Repeat step 7 for the drive end of machine.

**FIGURE - 8**

3.0 PREVENTATIVE MAINTENANCE

Routine cleaning and care will improve the running and extend the longevity of your machine. Frequency of cleaning is largely dependent upon your production environment; highly corrosive environments require more frequent cleaning than non-corrosive environments. The machine should be cleaned once every two weeks.

In the event that the machine must be cleaned, please ensure that the main power switch has been turned to the off position and the main power cord has been disconnected and locked out. Failure to comply may result in damage to the machine and /or personal injury.

CAUTION: Cleaning the machine while it is energized and/or running can result in entanglement and electric shock causing bodily harm. Do not attempt if loose clothing, jewellery and/or hair are present, they may become entangled.



3.1 SURFACE CLEANING

If liquid has been spilled on the surface of the machine but has not entered the internal areas of the machine proceed to wipe the area dry with a cloth or paper towel. Stubborn materials may be scrubbed off the surface of the machine with a damp cloth and a light cleaning solution if needed. Do not allow moisture from the cloth or the cleaning solution itself to enter the internal area of the machine as this can damage the electrical and mechanical components contained within.

CAUTION: All spills located on the floor directly in the operators foot print must also be immediately cleaned to prevent people from slipping and falling while operating the machine.



3.2 INTERNAL CLEANING

Never use corrosive solvents when cleaning a S64T4 tunnel. Water and light liquid detergents, along with a clean cloth are all that is needed to clean the interior of the machine.

***CAUTION:** Never subject this machine to a “wash-down” procedure or expose the internals of the machine to liquids of any kind. This will damage the electrical and mechanical components of the machine.*



3.3 MICRO BIOLOGICAL MATERIALS

In the event that the environment around the machine or the product being shrunk is a biohazard and has leaked, spilled or exploded on the machine do not attempt to clean. Please refer to plant safety protocol for handling such materials and the internal cleaning procedure shown above.



3.4 CONVEYOR CHAIN AND BEARING LUBRICANTS

The S64T4 tunnels come from the factory containing specific lubricants on two separate parts of the machine; the conveyor chain and the pillow block bearings. Please use lubricants which meet or exceed the specifications of the factory installed lubricants shown in Table #2 below.

CAUTION: Only qualified service personnel should attempt replacing the lubricants on this machine, please refer to the maintenance manual for procedures.



LOCATION	TYPE/SPECIFICATION
PILLOW BLOCK BEARINGS	<ul style="list-style-type: none"> • Multipurpose Lithium Soap Based grease • NLGI Grade 2 Lubricating grease
CONVEYOR CHAIN (On Roller Type Conveyor)	<ul style="list-style-type: none"> • Damark Shrink Tunnel Chain Lubricant

TABLE - 2

3.5 SERVICE SCHEDULE

TIME INTERVAL	PROCEDURE
Every 40 hours of usage	Lubricate conveyor chain (on roller type conveyors only) For procedure refer to section 2.2
Weekly	Check pillow block bearings for wear and check oil level. For procedure refer to section 2.2
Every 6 months	Check sprockets for wear. For procedure refer to section 2.2
	Check fan belt on blower motor for wear. For procedure refer to section 2.1

TABLE - 3

4.0 TROUBLE SHOOTING GUIDE

The following should be checked before trouble shooting this equipment:

- 1) All warnings listed in this manual should be read carefully and understood before attempting any trouble shooting procedures.
- 2) The voltage supplied to the machine should be stated on the machine nameplate.
- 3) Reference given schematic for fuses and contactors described below.

Fault	Probable Cause	Solution
1. Conveyor will not start	1.1 Speed controller set to zero	Set speed pot to a higher value
	1.2 Obstruction between rollers (on roller conveyor type)	Clear debris from rollers
	1.3 Motor is damaged	Call for support
	1.4 Conveyor and/or Speed Board fuse is blown	Check conveyor and speed board fuse
	1.5 Speed board is damaged	Call for support
2. Tunnel has insufficient or no air flow	2.1 There is a blockage on intake	Clear debris from fan intake
	2.2 Blower motor fuse blown	Check blower motor fuses
	2.3 Blower is overheated	Call for support
3. Heat zone will not reach desired temperature	3.1 Blowers are not working	See above section
	3.3 Heaters are not working	Test elements of continuity
	3.4 Temp controller is damaged	Replace temp controller
4. Heat stays on or overheating	4.1 Wrong voltage supplied	Check voltage to machine is correctly matched to the voltage on the serial plate
	4.2 Heat contactor welded shut	Check 1HC and 2HC for proper operation
	4.3 Temp controller internal relay is welded shut	Check relay output of heat controller to ensure it is operating properly
	4.4 Temp controller is damaged	Replace temp controller

If issue remains unresolved please contact a Plexpack service representative at

+1-416-291-8085.



S74T4-16R-AI SPARE PARTS LIST

ELECTRICAL

Part Number	Description	Recommend Qty.
PEM0101	Blower Motor 575VAC 3Ph 1/2HP	0
PEM0103	Conveyor Motor 575V 3Ph 1.5HP	0
PEB2003	AC Drive 600V 3PH 1HP 3A	0
PEB2004	AC Drive 600V 3PH 2HP 3A	0
PEB0041	Auto Shutdown Timer	1
PEB0046	Timer Base	0
PEP0003	Potentiometer 10kOhm	0
PHK1206	Pot Knob	0
PES1222	On-Off Switch	0
PES1207	Green Light Push Button	0
PES1211	Yellow Pilot Light	0
PES1202	Emergency Stop Button	0
PES1225	N/O Contact	0
PES1226	N/C Contact	0
PES1305	Bulb, 130V 2W	2
PEB0036	Temperature Control	1
PEF0039	Fuse 3A 250V T/D	4
PEF0041	Fuse 5A 250V T/D	2
PEF0043	Fuse 15A 250V One Time	1
PEF0044	Fuse 20A 250V One Time	1

PEF0062	Fuse 5A 250V One Time	1
PEF0067	Fuse 25A 600V One Time	3
PEF0068	Fuse 30A 600V One Time	3
PEF0079	Fuse 5A 600V T/D	3
PEF0083	Fuse 1A 600V T/D	2
PEF0086	Fuse 2A 600V T/D	6
PEF0089	Fuse 3A 600V T/D	6
PEF2079	Fuse 70A 600V One Time Blade	3
PER0008	Contactactor 21A 3Ph 110/600V	2
PER0017	Thermal Overloads 1.0A	0
PER0018	Thermal Overloads 1.7A	0
PER0019	Thermal Overloads 2.3A	0
PER0119	Contactactor 30A 3Ph 120V	1
PEO0031	Photoswitch Sensor	0

HEATING

PEE0024	Element 575VAC 1600W	15
PEE0051	Thermocouple	1
PBH2017	Flange Bearing 1"	0
PTW0320	Fan Belt	4
PTV4510	Fan Pulley 4.5"	0
PTV3501	Fan Pulley 3.5"	0
PHF0004	Cooling Fan	0
PHF1000	Blower Fan	0
M666-66	Blower Fan Shaft	0

CONVEYOR SYSTEM

PSM4000	Drive Sprocket	0
PHB1032	Drive Pillow Block Bearing 1-1/2"	0
PBH3016	Idler Take-Up Bearing 1"	0
M013108	Idler Shaft	0
M013109	Drive Shaft	0
M013133	Belt Support Guide	0
M857-70	Dead Plate Idler End	0
M857-74	Dead Plate Drive End	0
PTC7325	Stainless Steel Mesh Belt	0
PSM4006	Belt Splicing Kit	1

For Spare Parts and Service Inquires:

Inside Sales &

Customer Advocate: Julie Gastis

Toll Free: 800-265-1775 x 227

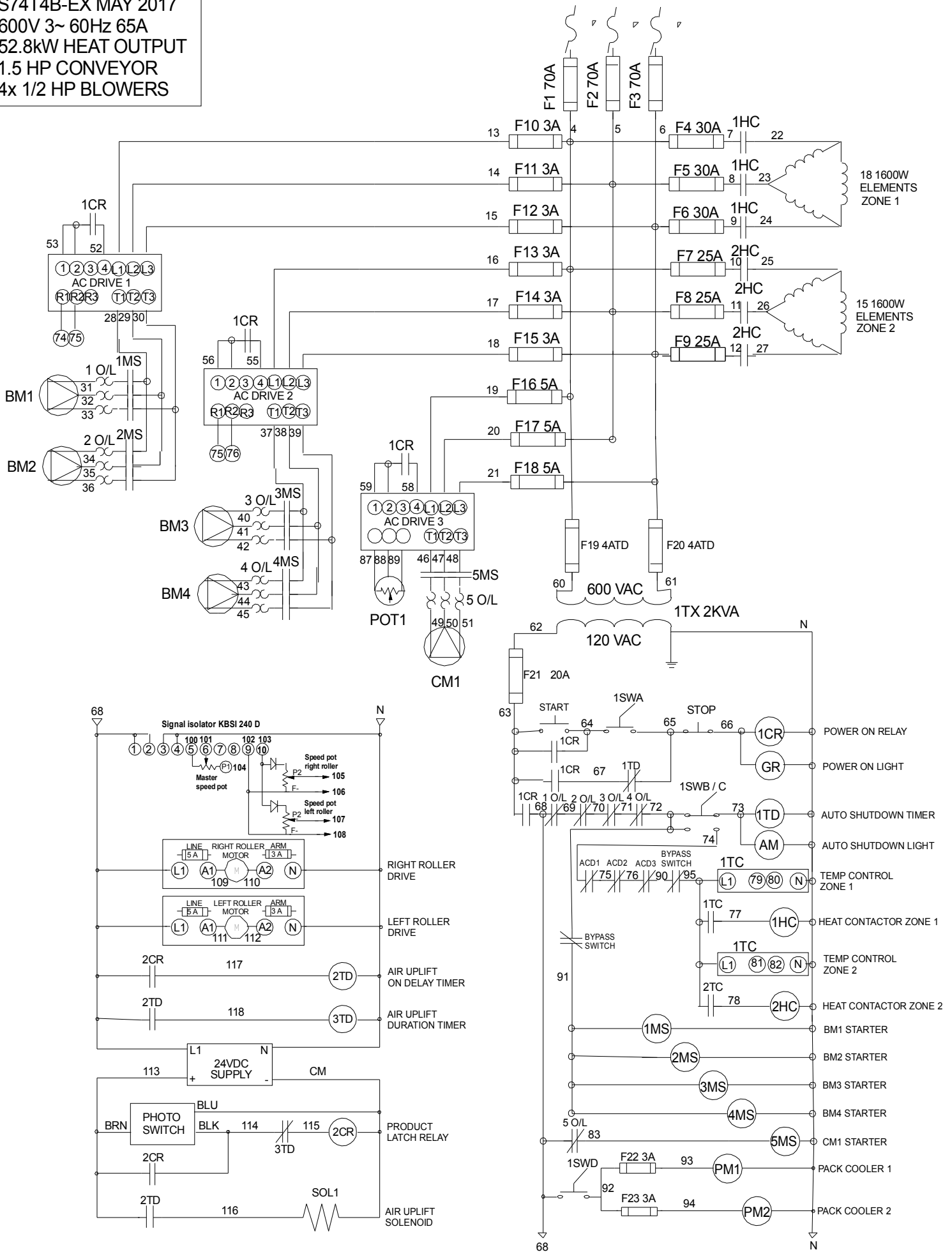
Email: Julieg@plexpack.com

Fax Number: 416-298-4328

General Info: info@plexpack.com

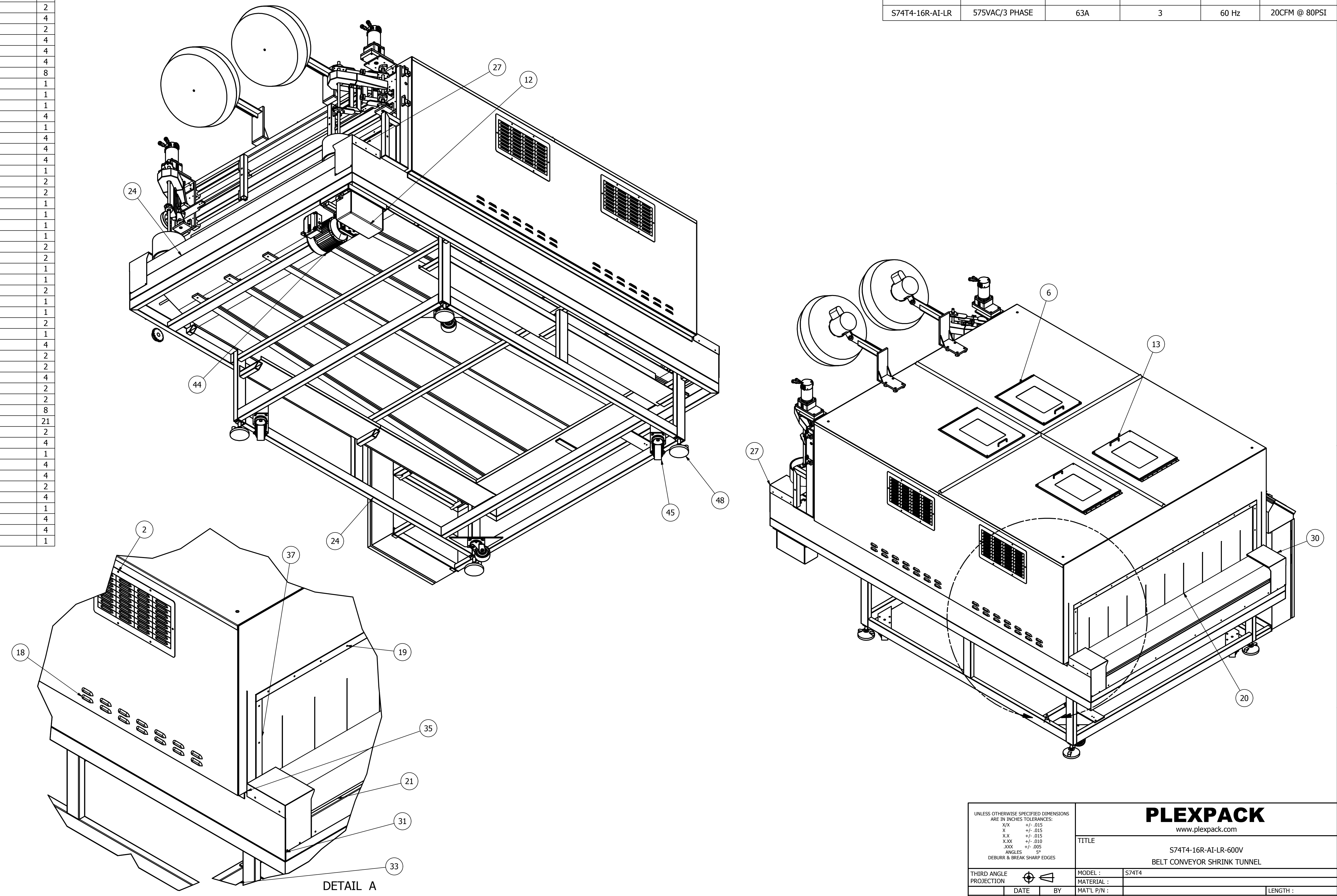
Website: www.plexpack.com

S74T4B-EX MAY 2017
 600V 3~ 60Hz 65A
 52.8kW HEAT OUTPUT
 1.5 HP CONVEYOR
 4x 1/2 HP BLOWERS

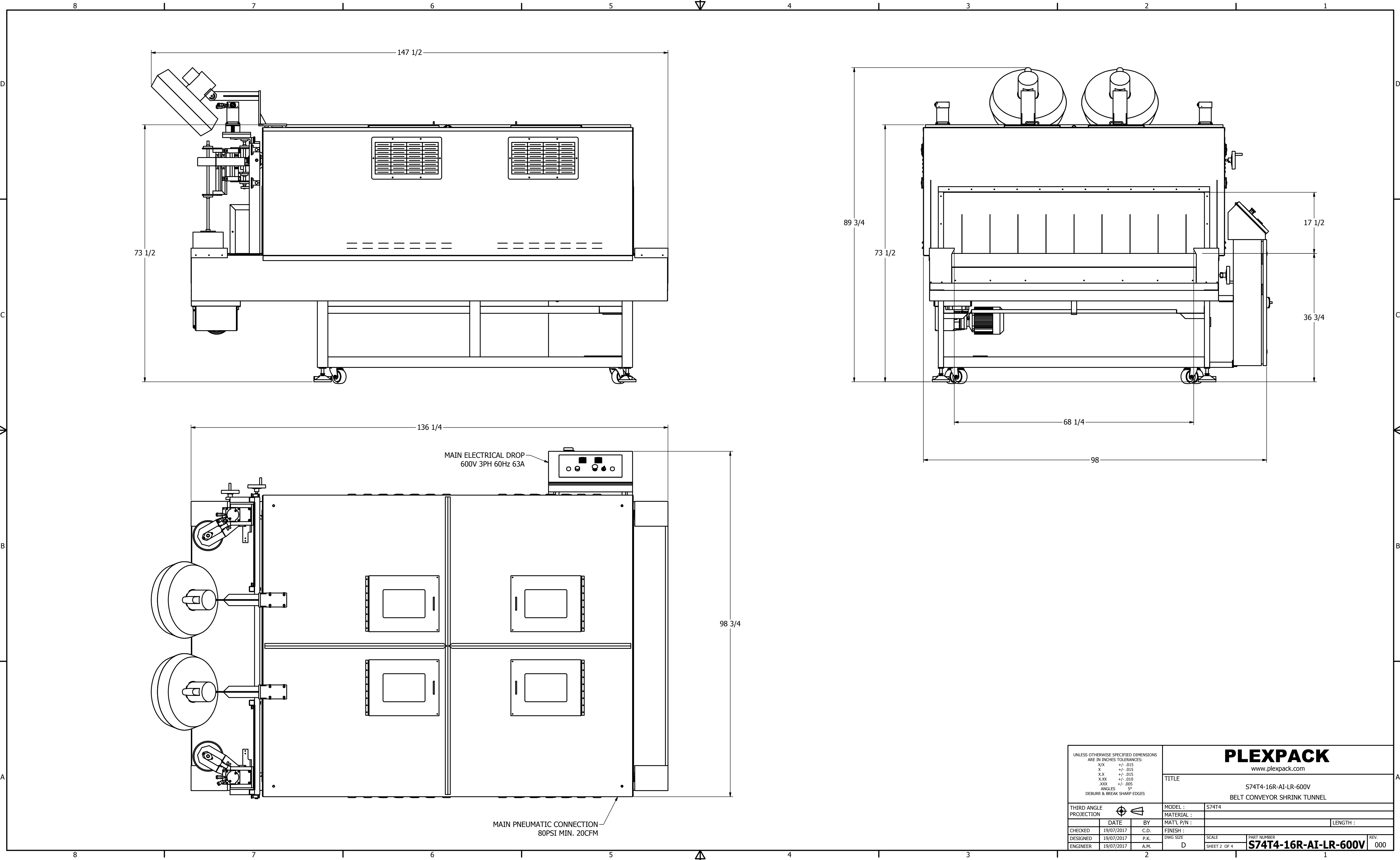


ITEM	PART NUMBER	TITLE	QTY
1	AI-74	AIR UPLIFT ASSEMBLY	1
2	M005108	LOUVRE PLATE	4
3	M005202	ANGLE OUTER SKIN	2
4	M005209	ANGLE OUTER SKIN	4
5	M005570	PROBE MTG BLOCK	2
6	M005593	DOOR - HOOD TOP	4
7	M005605	TOP SKIN STABILIZER	4
8	M005863	FAN COVER	4
9	M007887	FAN MOTOR MTG PLATE	8
10	M009454_863	SIDE OUTER SKIN RH	1
11	M009490_863	SIDE OUTER SKIN LH / RH	1
12	M009945	TUNNEL MOTOR COVER	1
13	M009947	D PULL HANDLE 3-1/2" CHROME	4
14	M009949	INFEED END CHAIN COVER R.H.	1
15	M010008	LOWER CONV. BELT SUPPORT	4
16	M010063	FAN PROTECTOR	4
17	M010084	4.5 INCH PULLEY	4
18	M012670	HOOD TOP	1
19	M012675	OUTER CURTAIN CLAMP STRIP-TOP PC	2
20	M012676	OUTER CURTAIN 77.5" X 22"	2
21	M012677	TUNNEL ENTR. SAFETY COVER	1
22	M012702	TOP SKIN - NOTCHED EXTENDED	1
23	M012703	TOP SKIN - NOTCHED	1
24	M012882	TUNNEL FRAME WELDMENT LR	1
25	M012954	OUTER CURTAIN 77.5" X 22"	2
26	M012957	TOP SKIN CENTRE	2
27	M012960	DISCHARGE END CHAIN COVER - RL	1
28	M012961	DISCHARGED END CHAIN COVER - LR	1
29	M012992	PACK COOLER FRAME	2
30	M013099	INFEED END CHAIN COVER RL	1
31	M013100	DISCHARGE END CHAIN COVER LR	1
32	M013105	BELT SUPPORT WELDMENT	2
33	M013110	FRAME WELDMENT	1
34	M666-66	FAN SHAFT	4
35	M678-46_863	SIDE OUTER SKIN LH / RH	2
36	M678-47_863	SIDE OUTER SKIN RH	2
37	M678-61	OUTER CURTAIN CLAMP STRIP-SIDE PC	4
38	M857-37-38	HEATER COVER LH & RH	2
39	M857-38	HEATER COVER RH - 16"	2
40	PBH2017	FLANGE BEARING	8
41	PEE0024	ELEMENT 575V 1600W	21
42	PEE0051	THERMOCOUPLE 6"X9"X3/16"X48"	2
43	PEM0101	MOTOR AC 575V 3PH 1/2HP 1800RPM	4
44	PEM0103	MOTOR AC 575V 1.5HP 130RPM	1
45	PHE0010	CASTER 1000LB 4" CAST IRON SWIVEL	4
46	PHF0004	6" DIA. BLADE FAN	4
47	PHF1000	FAN 10" TURBINE BLOWER WHEEL	2
48	PHG0005	ADJ. LEVELLING FT 3/4-10 X 8"	4
49	PSF6016	SPROCKET 60B14 X 1" BORE W/KEY	1
50	PTV3501	3.5 INCH PULLEY	4
51	PTW0320	BELT 4L260	4
52	SR-74-10	SIDE ROLLERS - 74"	1

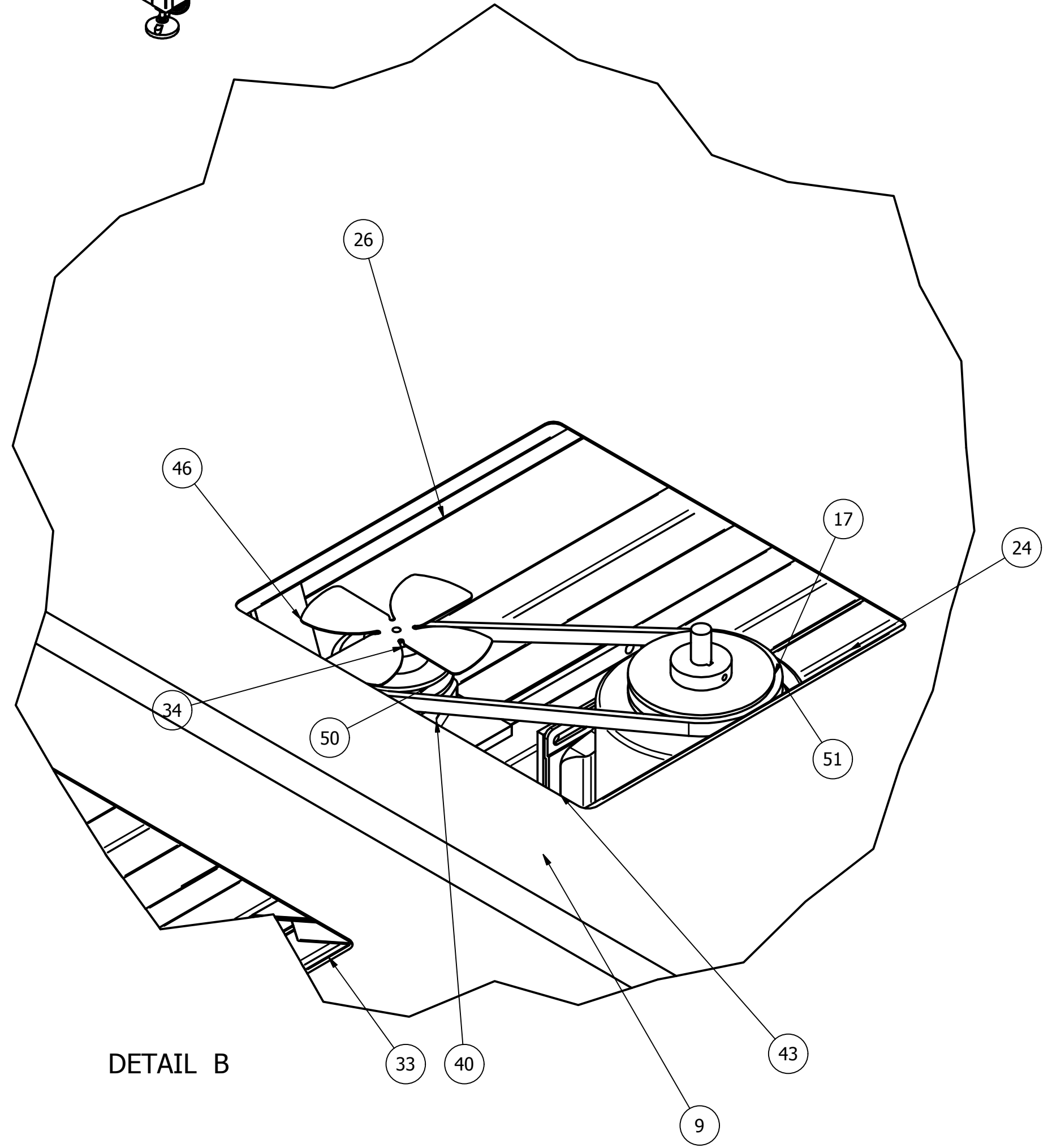
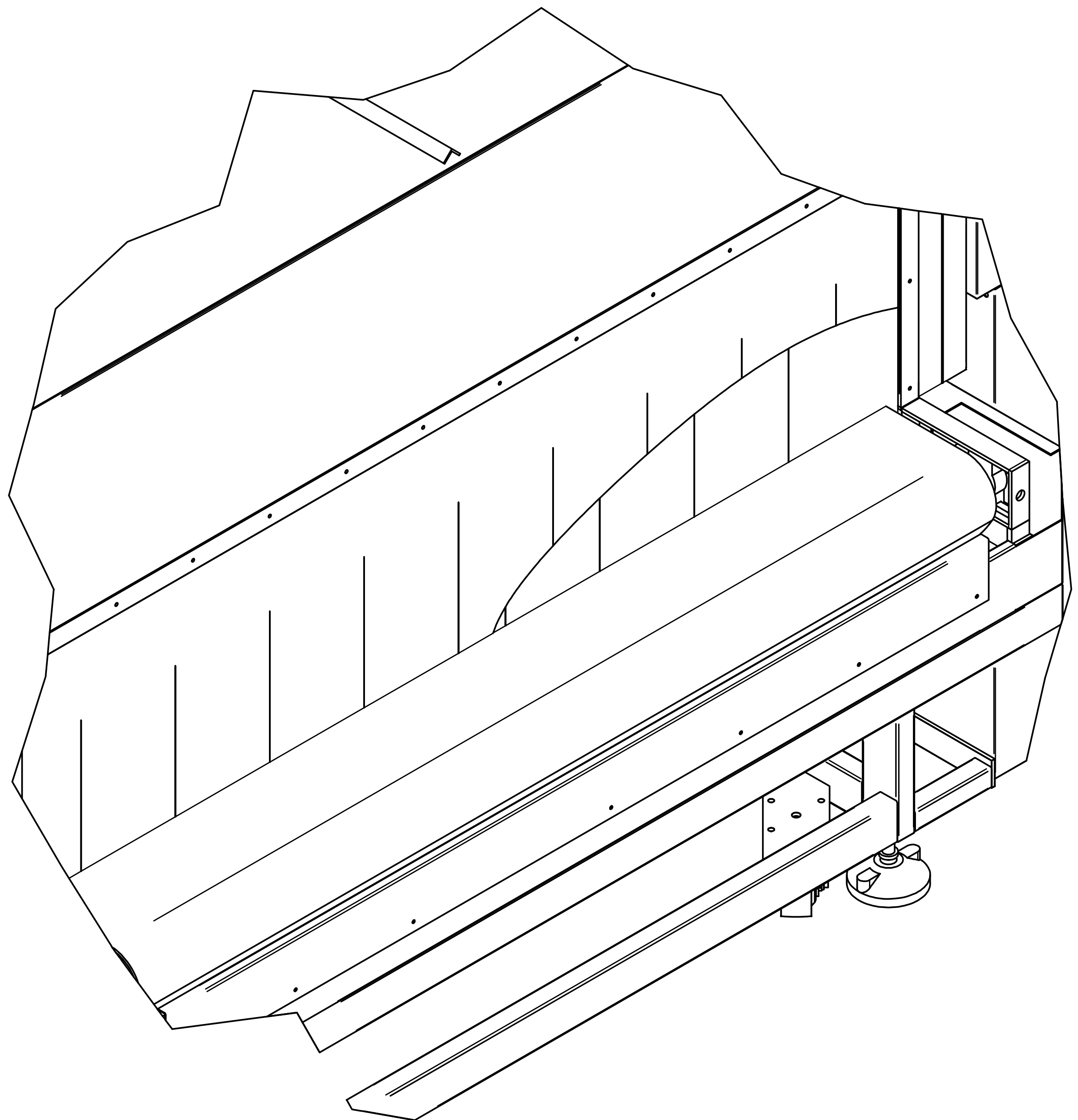
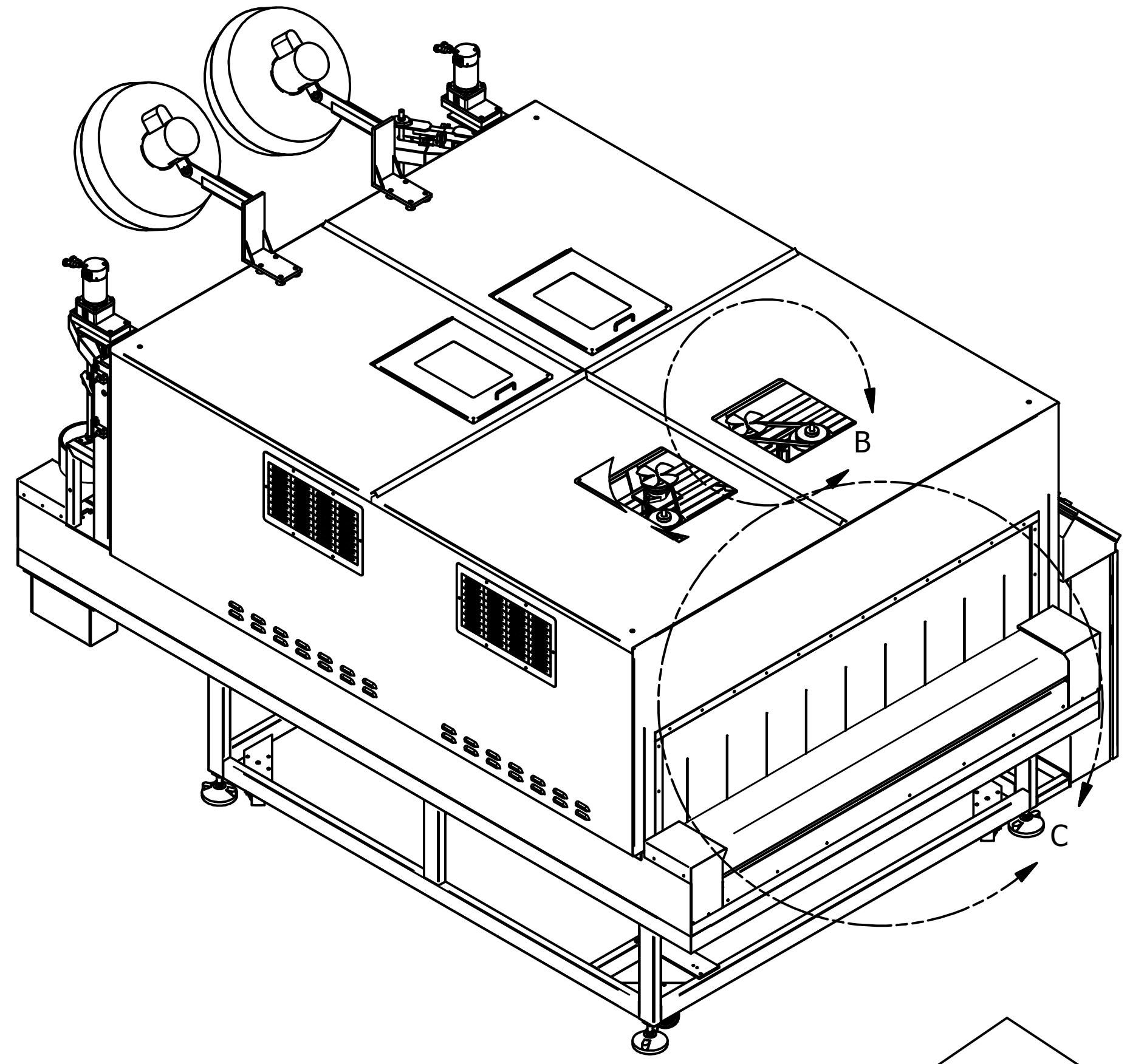
ELECTRICAL SPECIFICATIONS					
MODEL	SUPPLY VOLTAGE	MAX. AMPERAGE	NO. OF PHASES	FREQUENCY	AIR SUPPLY
S74T4-16R-AI-LR	575VAC/3 PHASE	63A	3	60 Hz	20CFM @ 80PSI



UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES:		PLEXPACK www.plexpack.com	
X	+/- .015	TITLE	
X.X	+/- .015	S74T4-16R-AI-LR-600V	
X.XX	+/- .010	BELT CONVEYOR SHRINK TUNNEL	
X.XXX	+/- .005	MODEL : S74T4	
ANGLES	9°	MATERIAL :	
DEBURR & BREAK SHARP EDGES		MATERIAL P/N :	
THIRD ANGLE PROJECTION		FINISH :	
CHECKED	19/07/2017	BY	C.D.
DESIGNED	19/07/2017	BY	P.K.
ENGINEER	19/07/2017	BY	A.M.
DATE		SCALE	
DATE		DWG SIZE	
DATE		SHEET 1 OF 4	
DATE		PART NUMBER	
DATE		REV.	
DATE		S74T4-16R-AI-LR-600V	
DATE		000	



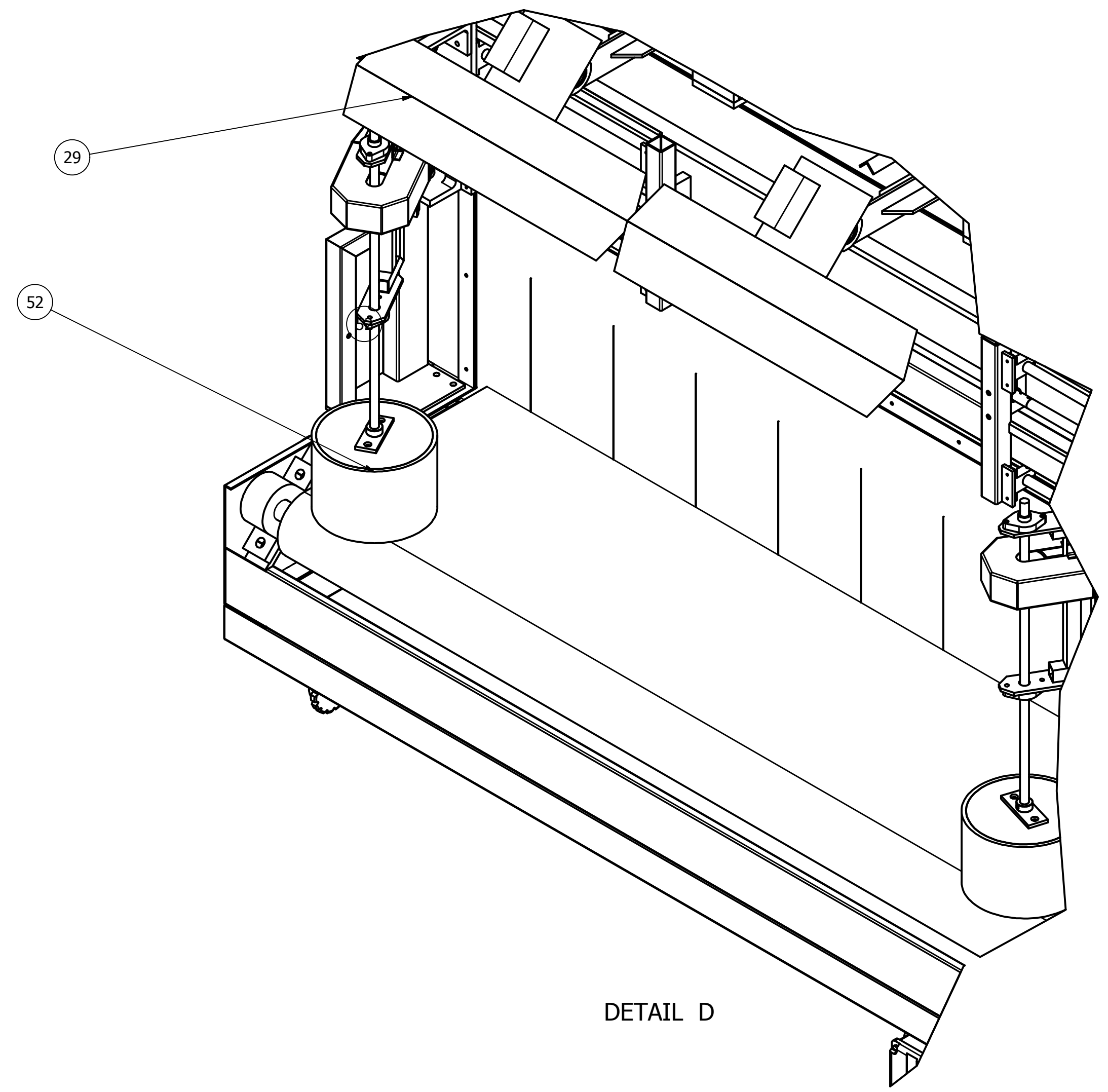
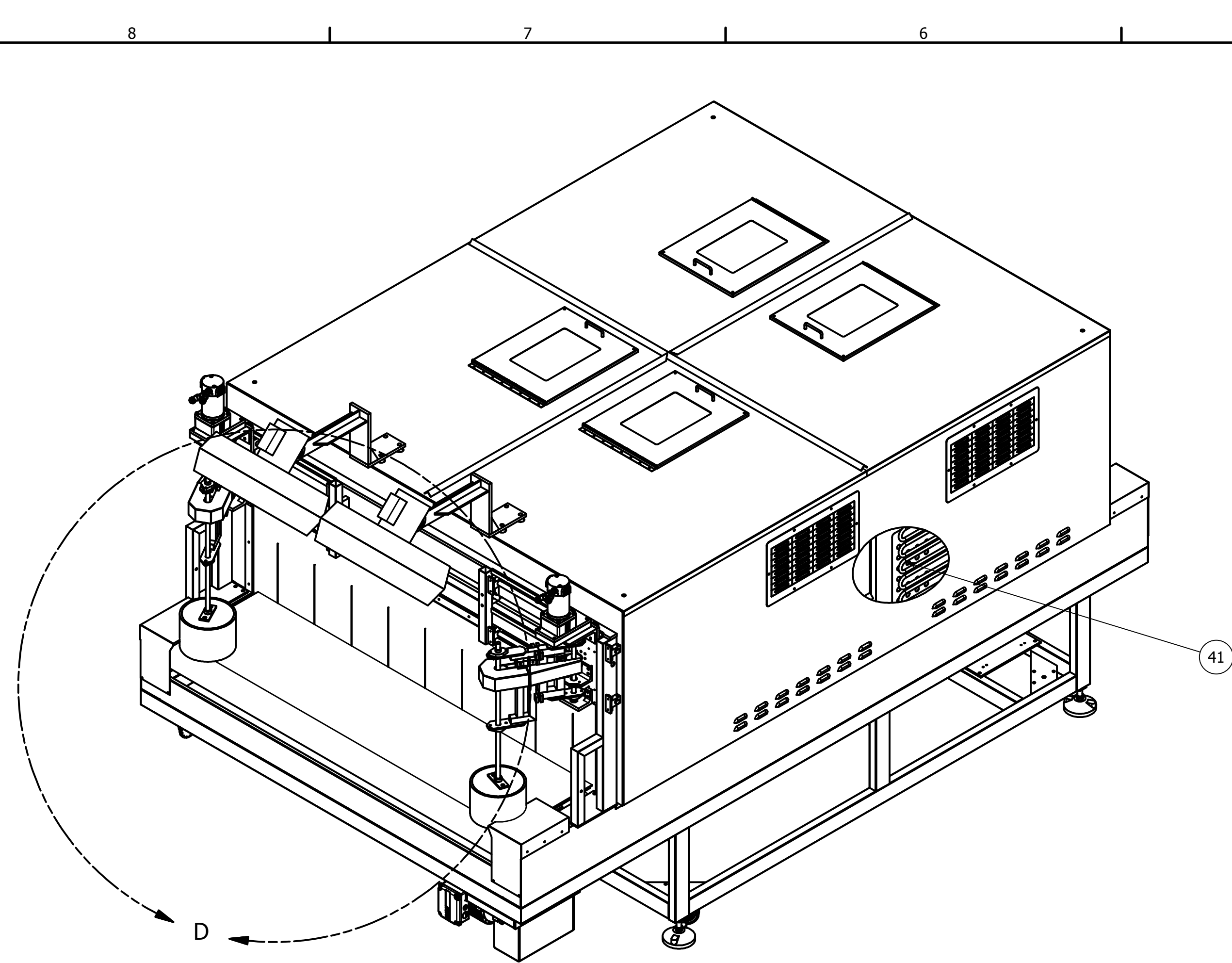
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<small>THIRD ANGLE PROJECTION</small>				TITLE S74T4-16R-AI-LR-600V BELT CONVEYOR SHRINK TUNNEL	
<small>MODEL :</small> S74T4		<small>MATERIAL :</small>		<small>LENGTH :</small>	
<small>CHECKED</small> 19/07/2017	<small>BY</small> C.D.	<small>MAT'L P/N :</small>	<small>FINISH :</small>		
<small>DESIGNED</small> 19/07/2017	<small>P.K.</small>	<small>DWG SIZE</small> D	<small>SCALE</small>	<small>PART NUMBER</small> S74T4-16R-AI-LR-600V	<small>REV.</small> 000
<small>ENGINEER</small> 19/07/2017			<small>SHEET 2 OF 4</small>	<small>REV.</small> 000	



DETAIL C

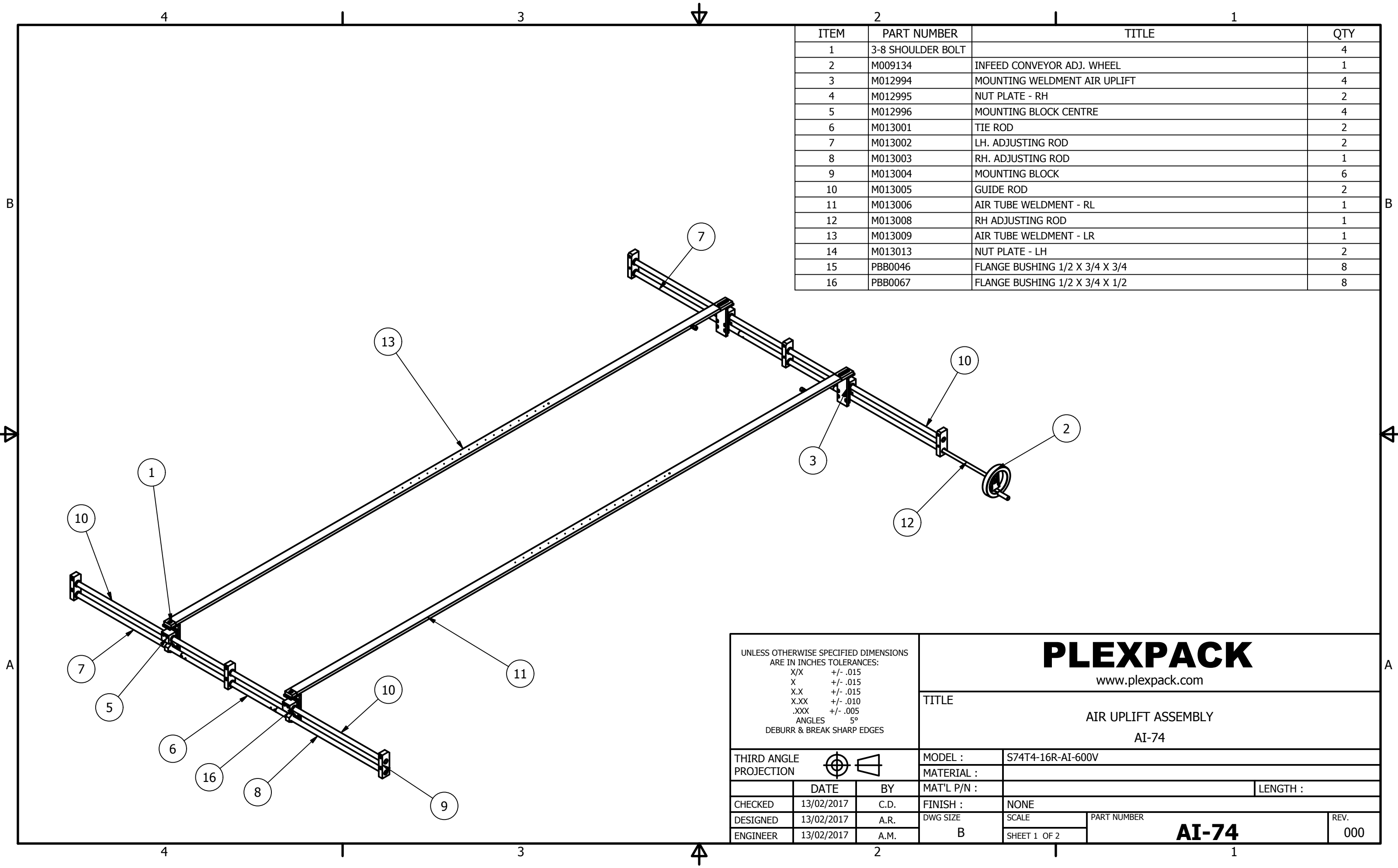
DETAIL B

<small>UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES: X.X +/- .015 X +/- .015 X.XX +/- .015 X.XX +/- .010 XXX +/- .005 ANGLES 9° DEBURR & BREAK SHARP EDGES</small>		PLEXPACK <small>www.plexpack.com</small>	
THIRD ANGLE PROJECTION		TITLE S74T4-16R-AI-LR-600V BELT CONVEYOR SHRINK TUNNEL	
MODEL : S74T4	MATERIAL :	MAT'L P/N :	LENGTH :
CHECKED 19/07/2017 C.D.	FINISH :	DWG SIZE :	SCALE :
DESIGNED 19/07/2017 P.K.	A.M.	SHEET 3 OF 4	PART NUMBER S74T4-16R-AI-LR-600V
ENGINEER 19/07/2017	D	REV. 000	



DETAIL D

<small>UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES: XX +/- .015 X +/- .015 .XX +/- .015 .XX +/- .010 .XXX +/- .005 ANGLES 9° DEBURR & BREAK SHARP EDGES</small>				PLEXPACK <small>www.plexpack.com</small>	
<small>THIRD ANGLE PROJECTION</small>				TITLE S74T4-16R-AI-LR-600V BELT CONVEYOR SHRINK TUNNEL	
<small>MODEL :</small> S74T4		<small>MATERIAL :</small>		<small>LENGTH :</small>	
<small>CHECKED</small> 19/07/2017 <small>DESIGNED</small> 19/07/2017 <small>ENGINEER</small>	<small>DATE</small> <small>BY</small> <small>P.K.</small>	<small>C.D.</small> <small>P.K.</small> <small>A.M.</small>	<small>FINISH :</small> <small>DWG SIZE</small> D	<small>SCALE</small> <small>SHEET 4 OF 4</small>	<small>REV.</small> S74T4-16R-AI-LR-600V <small>000</small>



ITEM	PART NUMBER	TITLE	QTY
1	3-8 SHOULDER BOLT		4
2	M009134	INFEED CONVEYOR ADJ. WHEEL	1
3	M012994	MOUNTING WELDMENT AIR UPLIFT	4
4	M012995	NUT PLATE - RH	2
5	M012996	MOUNTING BLOCK CENTRE	4
6	M013001	TIE ROD	2
7	M013002	LH. ADJUSTING ROD	2
8	M013003	RH. ADJUSTING ROD	1
9	M013004	MOUNTING BLOCK	6
10	M013005	GUIDE ROD	2
11	M013006	AIR TUBE WELDMENT - RL	1
12	M013008	RH ADJUSTING ROD	1
13	M013009	AIR TUBE WELDMENT - LR	1
14	M013013	NUT PLATE - LH	2
15	PBB0046	FLANGE BUSHING 1/2 X 3/4 X 3/4	8
16	PBB0067	FLANGE BUSHING 1/2 X 3/4 X 1/2	8

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES:
 X/X +/- .015
 X +/- .015
 X.X +/- .015
 X.XX +/- .010
 .XXX +/- .005
 ANGLES 5°
 DEBURR & BREAK SHARP EDGES

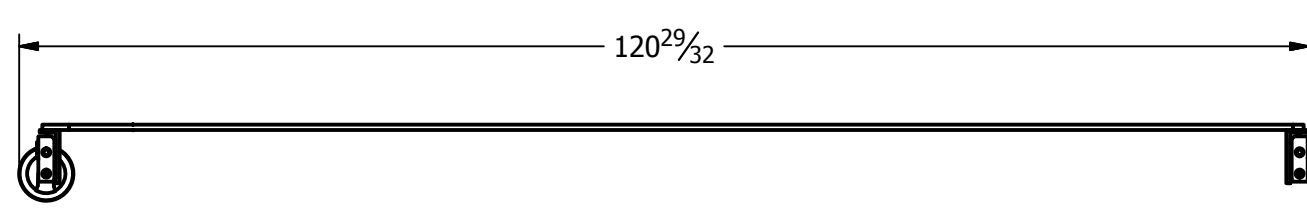
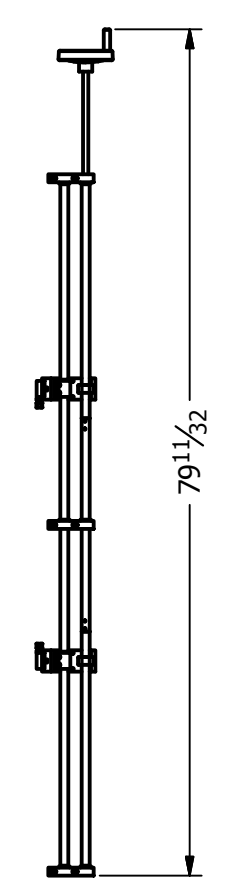
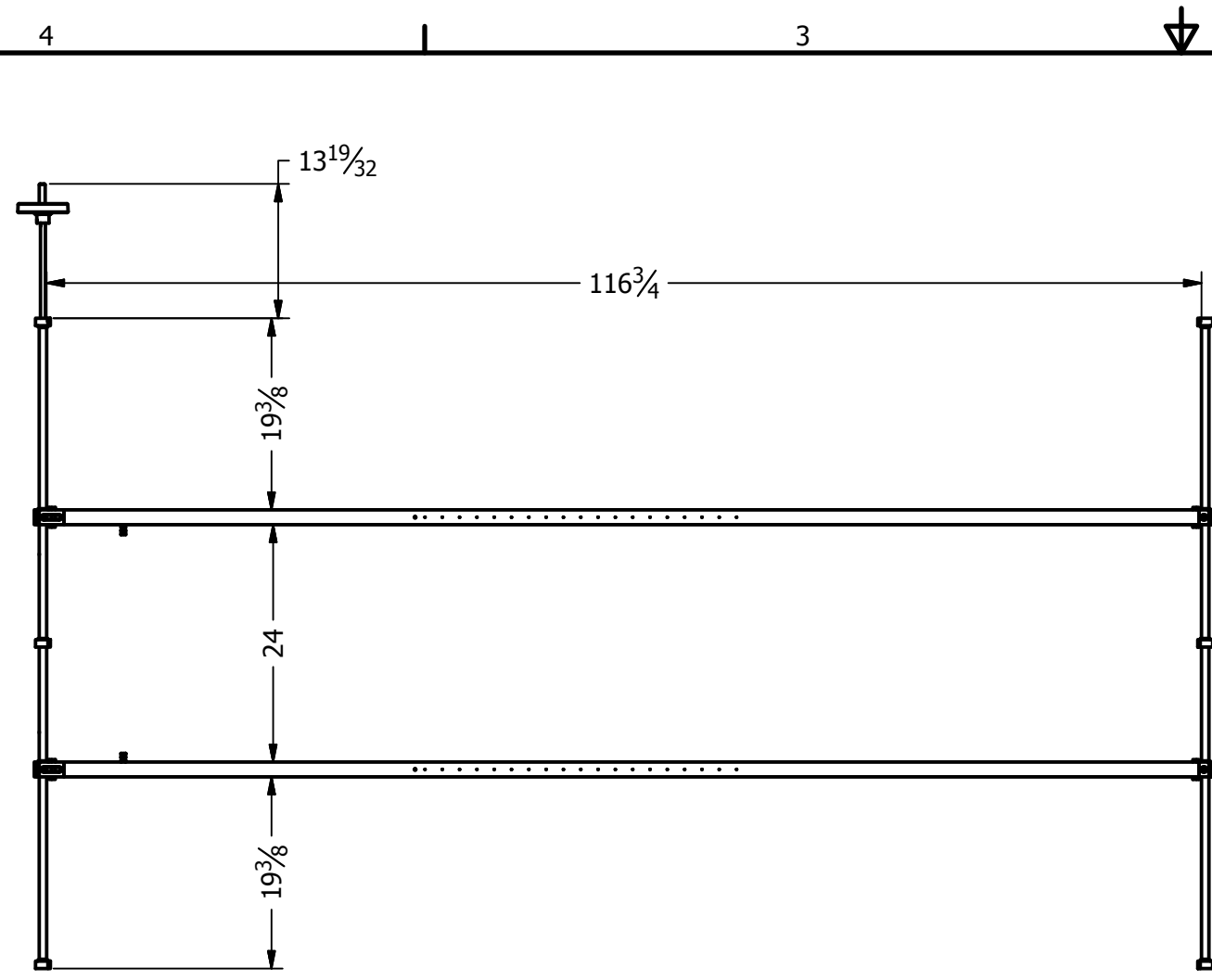
PLEXPACK
 www.plexpack.com

TITLE
 AIR UPLIFT ASSEMBLY
 AI-74

THIRD ANGLE PROJECTION

CHECKED	13/02/2017	C.D.
DESIGNED	13/02/2017	A.R.
ENGINEER	13/02/2017	A.M.

MODEL :	S74T4-16R-AI-600V		
MATERIAL :			
MAT'L P/N :			LENGTH :
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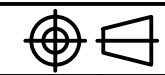


UNLESS OTHERWISE SPECIFIED DIMENSIONS
ARE IN INCHES TOLERANCES:
 X/X +/- .015
 X +/- .015
 X.X +/- .015
 X.XX +/- .010
 .XXX +/- .005
 ANGLES 5°
 DEBURR & BREAK SHARP EDGES

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TITLE
AIR UPLIFT ASSEMBLY
AI-74

THIRD ANGLE
PROJECTION



MODEL : S74T4-16R-AI-600V

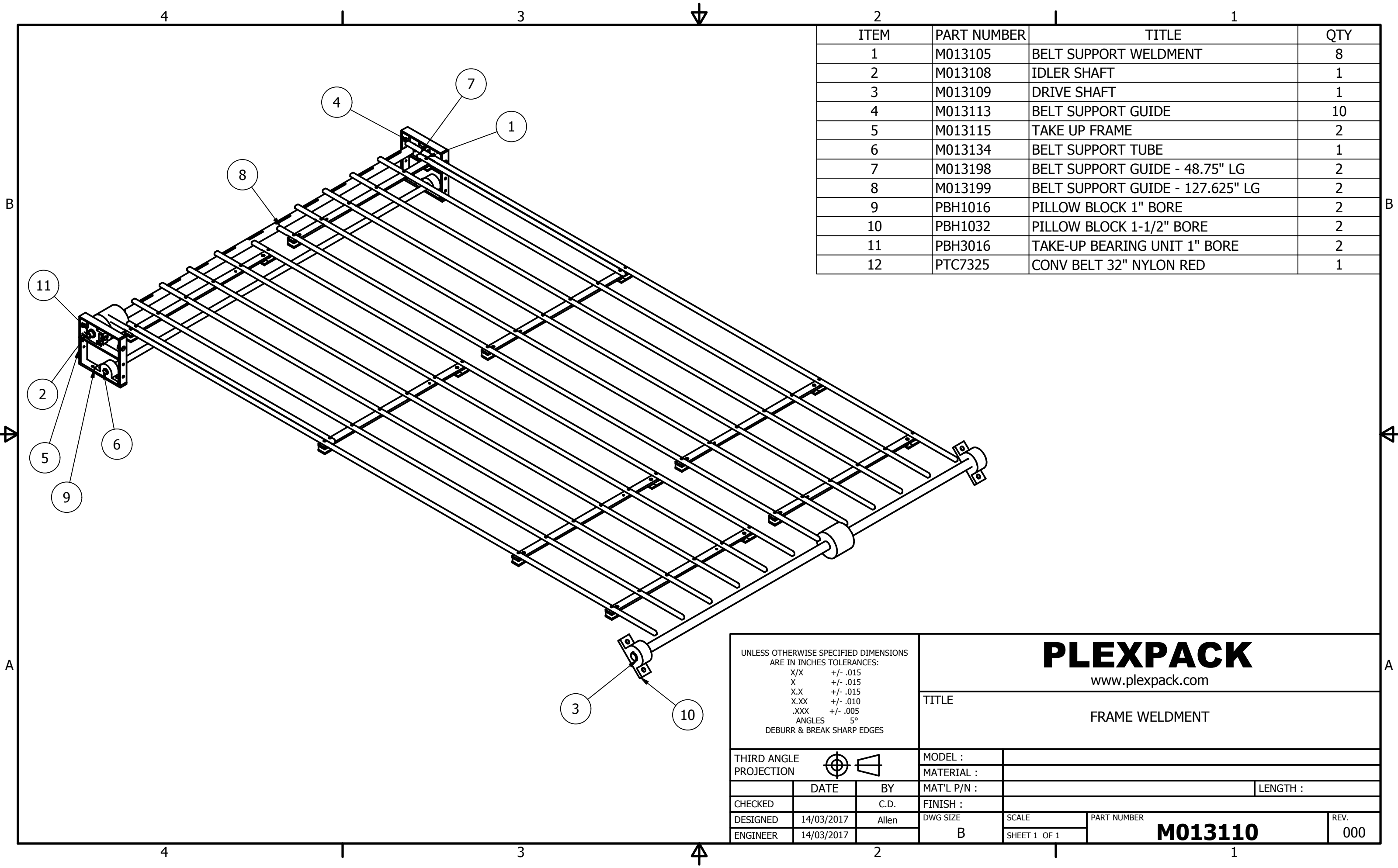
MATERIAL :

	DATE	BY
CHECKED	13/02/2017	C.D.
DESIGNED	13/02/2017	A.R.
ENGINEER	13/02/2017	A.M.

MAT'L P/N : LENGTH :

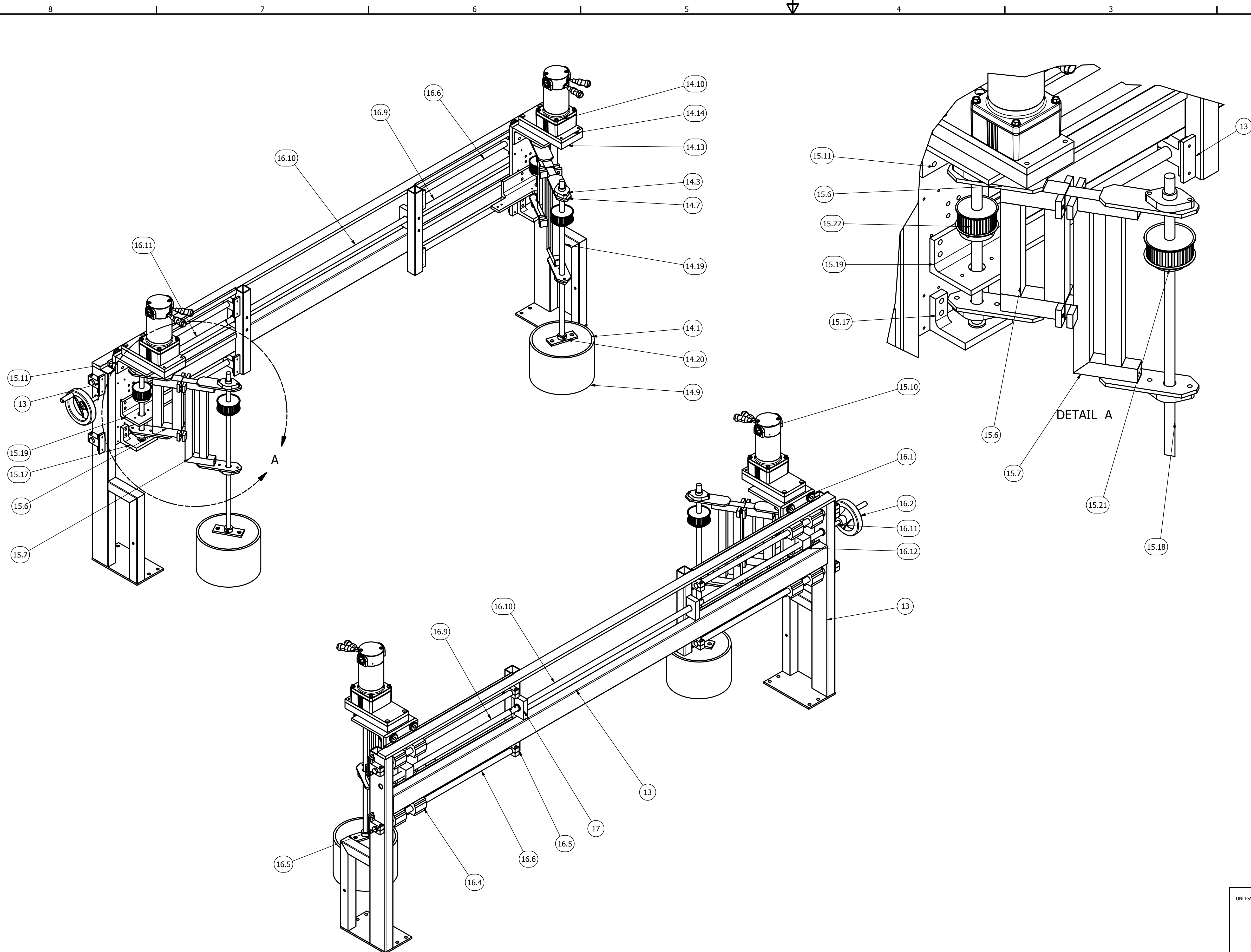
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DWG SIZE	SCALE	PART NUMBER	REV.
B	SHEET 2 OF 2	AI-74	000



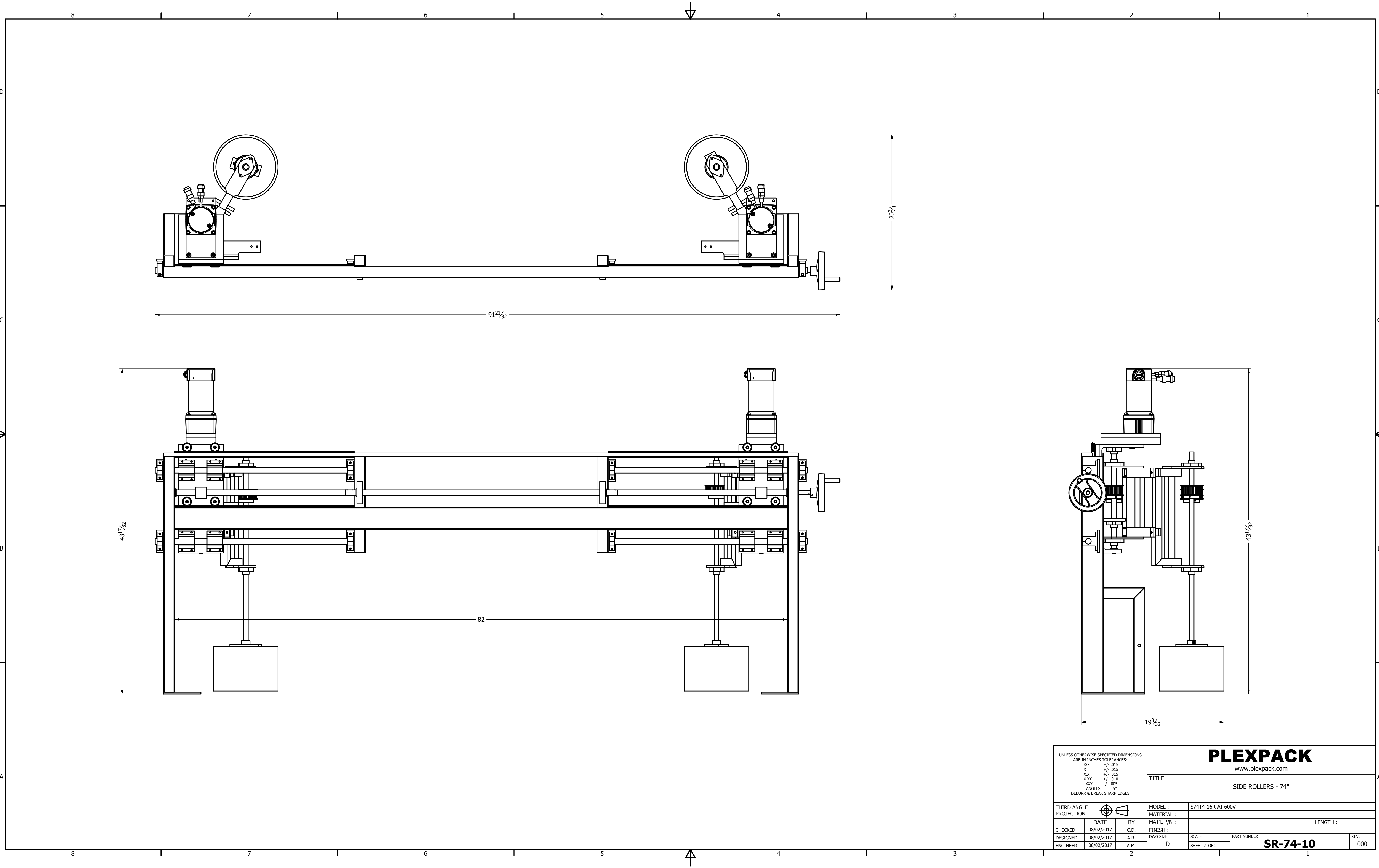
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1	M013105	BELT SUPPORT WELDMENT	8
2	M013108	IDLER SHAFT	1
3	M013109	DRIVE SHAFT	1
4	M013113	BELT SUPPORT GUIDE	10
5	M013115	TAKE UP FRAME	2
6	M013134	BELT SUPPORT TUBE	1
7	M013198	BELT SUPPORT GUIDE - 48.75" LG	2
8	M013199	BELT SUPPORT GUIDE - 127.625" LG	2
9	PBH1016	PILLOW BLOCK 1" BORE	2
10	PBH1032	PILLOW BLOCK 1-1/2" BORE	2
11	PBH3016	TAKE-UP BEARING UNIT 1" BORE	2
12	PTC7325	CONV BELT 32" NYLON RED	1

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES: X/X +/- .015 X +/- .015 X.X +/- .015 X.XX +/- .010 .XXX +/- .005 ANGLES 5° DEBURR & BREAK SHARP EDGES			<h1>PLEXPACK</h1> <p>www.plexpack.com</p>																														
THIRD ANGLE PROJECTION			TITLE																														
<table border="1"> <tr> <td>MODEL :</td> <td></td> </tr> <tr> <td>MATERIAL :</td> <td></td> </tr> <tr> <td>DATE</td> <td>BY</td> </tr> <tr> <td>CHECKED</td> <td>C.D.</td> </tr> <tr> <td>DESIGNED</td> <td>14/03/2017</td> </tr> <tr> <td>ENGINEER</td> <td>14/03/2017</td> </tr> </table>			MODEL :		MATERIAL :		DATE	BY	CHECKED	C.D.	DESIGNED	14/03/2017	ENGINEER	14/03/2017	FRAME WELDMENT <table border="1"> <tr> <td>MAT'L P/N :</td> <td></td> <td>LENGTH :</td> <td></td> </tr> <tr> <td>FINISH :</td> <td></td> <td></td> <td></td> </tr> <tr> <td>DWG SIZE</td> <td>SCALE</td> <td>PART NUMBER</td> <td>REV.</td> </tr> <tr> <td>B</td> <td>SHEET 1 OF 1</td> <td>M013110</td> <td>000</td> </tr> </table>			MAT'L P/N :		LENGTH :		FINISH :				DWG SIZE	SCALE	PART NUMBER	REV.	B	SHEET 1 OF 1	M013110	000
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ENGINEER	14/03/2017																																
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FINISH :																																	
DWG SIZE	SCALE	PART NUMBER	REV.																														
B	SHEET 1 OF 1	M013110	000																														



ITEM	PART NUMBER	TITLE	QTY
1	M005763-64	TIMING PULLY COVER	1
2	M005764	TIMING PULLY COVER	1
4	M007336	SIDE COVER LH & RH	1
5	M007337		1
8	M007366	BELT COVER - OUTSIDE	2
9	M007367	BELT COVER - INSIDE	2
10	M007368	INSIDE COVER - RH	1
11	M007370	LOWER INSIDE COVER - LH & RH	1
12	M007371		1
13	M012945	SR-74-10 FRAME WELDMENT	1
14	M012949	SIDE ROLLERS - 34 X 20	1
14.1	M005754	ROLLER END PLUG	2
14.3	PBH2011		6
14.6	M012941	SWING ARM - WELDMENT	1
14.7	M012943	SWING ARM EXTENSION WELDMENT	1
14.8	M012950	SWING ARM - MOUNT PLATE	1
14.9	M012951	SIDE SEAL ROLLER	1
14.10	4QS021	GEARMOTOR ASSEMBLY, MPS SEALER DC	1
14.11	M012959	TOP SUPPORT ANGLE	1
14.12	M012955	CENTER SUPPORT ANGLE - RL	1
14.13	M012974	GEAR HOUSING	1
14.14	M012975	MOTOR MOUNT PLATE	1
14.15	M012976	VERTICAL SHAFT	1
14.16	M012977	SPUR GEAR - .627" DIA	2
14.17	1P0326	THRUST BEARING	1
14.18	M012978	BOTTOM SUPPORT ANGLE	1
14.19	M012979	ROLLER SHAFT WELDMENT	1
14.20	M012987	CAPTIVE PLATE WELDMENT	1
14.21	M012998	PULLEY TIMING 20L100 5/8" BORE	1
14.22	M012999	PULLEY TIMING 24L100 5/8" BORE	1
15	M012949-LR	SIDE ROLLERS - 34 X 20	1
15.1	M005754	ROLLER END PLUG	2
15.3	PBH2011		6
15.6	M012941	SWING ARM - WELDMENT	1
15.7	M012943	SWING ARM EXTENSION WELDMENT	1
15.8	M012950	SWING ARM - MOUNT PLATE	1
15.9	M012951	SIDE SEAL ROLLER	1
15.10	4QS021	GEARMOTOR ASSEMBLY, MPS SEALER DC	1
15.11	M012959	TOP SUPPORT ANGLE	1
15.12	M012974	GEAR HOUSING	1
15.13	M012975	MOTOR MOUNT PLATE	1
15.14	M012976	VERTICAL SHAFT	1
15.15	M012977	SPUR GEAR - .627" DIA	2
15.16	1P0326	THRUST BEARING	1
15.17	M012978	BOTTOM SUPPORT ANGLE	1
15.18	M012979	ROLLER SHAFT WELDMENT	1
15.19	M012980	CENTER SUPPORT ANGLE - LR	1
15.20	M012987	CAPTIVE PLATE WELDMENT	1
15.21	M012999	PULLEY TIMING 24L100 5/8" BORE	1
15.22	M012998	PULLEY TIMING 20L100 5/8" BORE	1
16	M012952	ADJUSTING TABLE	1
16.1	PHW0001	GUIDE WHEEL .375" BORE	8
16.2	M009134	INFEED CONVEYOR ADJ. WHEEL	1
16.3	PB80046	FLANGE BUSHING 1/2 X 3/4 X 3/4	2
16.4	PBL1012	LINEAR BEARING 3/4" PILLOW BLK	8
16.5	PBL2012	LINEAR SHAFT SUPPORT 3/4" BLK	8
16.6	M012953	LINEAR SHAFT 3/4" - .26.5" LG	4
16.7	M012950	SWING ARM - MOUNT PLATE	2
16.8	M012967	STOP BLOCK LH THREAD	1
16.9	M012971	LH ADJUSTING ROD	1
16.10	M012972	TIE ROD	1
16.11	M012973	RH ADJUSTING ROD	1
16.12	M012985	STOP BLOCK RH THREAD	1
17	M012970	CRANK SHAFT MOUNTING BLOCK	2
18	PB80067	FLANGE BUSHING 1/2 X 3/4 X 1/2	2

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES: X.X +/- .015 X +/- .015 X.XX +/- .015 X.XXX +/- .010 XXX +/- .005 ANGLES 9° DEBURR & BREAK SHARP EDGES		PLEXPACK www.plexpack.com	
THIRD ANGLE PROJECTION		TITLE SIDE ROLLERS - 74"	
DATE	BY	MODEL :	S74T4-16R-AI-600V
CHECKED	08/02/2017	MATERIAL :	
DESIGNED	08/02/2017	MAT'L P/N :	
ENGINEER	08/02/2017	FINISH :	
		DWG SIZE	D
		SCALE	
		PART NUMBER	SR-74-10
		SHEET 1 OF 2	000



UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES:		PLEXPACK www.plexpack.com	
XXX	+/- .015		
XX	+/- .015	TITLE SIDE ROLLERS - 74"	
X	+/- .015		
XXX	+/- .015	MODEL : S74T4-16R-AI-600V	
XX	+/- .010		
XXX	+/- .005	MATERIAL : _____	
XXX	+/- .005		
ANGLES	9°	FINISH : _____	
DEBURR & BREAK SHARP EDGES			
THIRD ANGLE PROJECTION		SCALE : _____	
CHECKED	08/02/2017		
DESIGNED	08/02/2017	SHEET 2 OF 2	
ENGINEER	08/02/2017		