# CONAIR
# STRAW WRAPPER
# INSTRUCTIONS

⚠ **WARNING - Reliance on this Manual Could Result in Severe Bodily Injury or Death!**

This manual is out-of-date and is provided only for its technical information, data and capacities. Portions of this manual detailing procedures or precautions in the operation, inspection, maintenance and repair of the product forming the subject matter of this manual may be inadequate, inaccurate, and/or incomplete and cannot be used, followed, or relied upon. Contact Conair at info@conairgroup.com or 1-800-654-6661 for more current information, warnings, and materials about more recent product manuals containing warnings, information, precautions, and procedures that may be more adequate than those contained in this out-of-date manual.

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UGE024/0597

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# SET-UP INSTRUCTIONS

Examine the machine for possible damage which it could have received upon arrival.

Check the power supply. Your machine's power supply should be wired according to the specifications of your plant.

Set the machine up in an area that has a convenient electrical outlet. Also, for our machines with a Boxer unit there should be a supply of filtered-lubricated air.

*NOTE:* Position the conveyor (for machines with the conveyor attachment only), in a position which is at right angle to that of the wrapping machine. IMPORTANT: The wrapper at this time can be made secure to the floor. However, the conveyor should not be made secure at this time. The conveyor should not be secured until after the operation is set up and it is running for about one hour. This is done so that the customer can make sure that the straws are falling in the desired place on the conveyor. When this position is final, then the conveyor can also be secured to the floor.

Check the rotation of the wrapper and the conveyor.

THREADING PROCEDURE: REFER TO FIG. I.

The threading of the paper is as shown in Fig. I.:

Step 1. Place a spool of wrapping paper on the holder as shown in the drawing as Section A. This is done by removal of the thumb screw shown as item 1. Placing of the paper on the tension bracket and then placing the thumb screw back on over the paper and securing it in place.

Step 2. Following the procedure of the drawing, the paper should then be threaded around and in between the specified rollers. Section B on the drawing.

Step 3. After the paper has been threaded through Section B it is then threaded through the "fingers", shown as Section C. The paper is then carefully pulled up around roller (12) and brought through the CLINCH ROLLS.

Step 4. The clinch roll assembly is shown in a magnified drawing shown as Section D. The paper should be pulled through the folder assembly and finally through the space in between the clinch rolls.

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ADJUSTMENT OF THE (paper) ROLLERS: - REFER TO FIG. I.

Step 1. Roller numbered 3 & 4 in Section B are called "Top Rollers"; and they are adjusted by loosening the the opposite side of the roller and then turning the shaft either right or left in order for just enough of the roller to catch the print to print on the paper. The screws should then be tightened so that the rollers are secured in place. If the rollers exert too much pressure on the paper, they will tear the paper in the process of wrapping the straws.

Step 2. The roller shown as no. 6 is known as the "slide roller". It is only functional in a two color printing operation. If a two color printing operation is in effect the roller is adjusted by loosening the screw on the opposite side of the roller, and then by sliding the roller to a desired setting. The ideal setting of the roller should be such that both printing operations will be in time with each other. the screw on the back should then be tightened. The metal drive pully marked no. 7 will not have to be adjusted. Rubber roller no. 5 is used to aid Metal Roller No. 7. When threading paper, release cam handle on roller No. 5. Re-engage when threading is complete.

PREPARATION OF THE PRINTING OPERATION: REFER TO FIG. 1.

Step 1. The ink pots shown in drawing must be filled in a ratio of one part ink to three parts alcohol. The pot should be filled in such a way that the ink will only cover about 1/8" of the ink rolls shown in drawing as no. 10 & 11.

*NOTE*: The "Doctor Blade" shown inside the ink pot in Fig. 2 is for the purpose of cleaning the surface of the ink roll of excess ink. The blade should be adjusted by loosening the thumb screws on the front of the ink pot and sliding the blade to a desired setting. If the blade is not adjusted properly there will be an excess of ink on the ink roll which will eventually get on the other rollers and the print will be smeared.

Step 2. The impression rollers are adjusted by loosening the screws on the opposite sides and turning their shafts left or right until a desired position. The roller should be set so that there is just enough depression of the impression roller on the ink roller to pick up a small amount of ink. If there is too much depression, there will be too much ink on the roller and therefore the print will be smeared.

FIG. 1

THREADING PROCEDURE

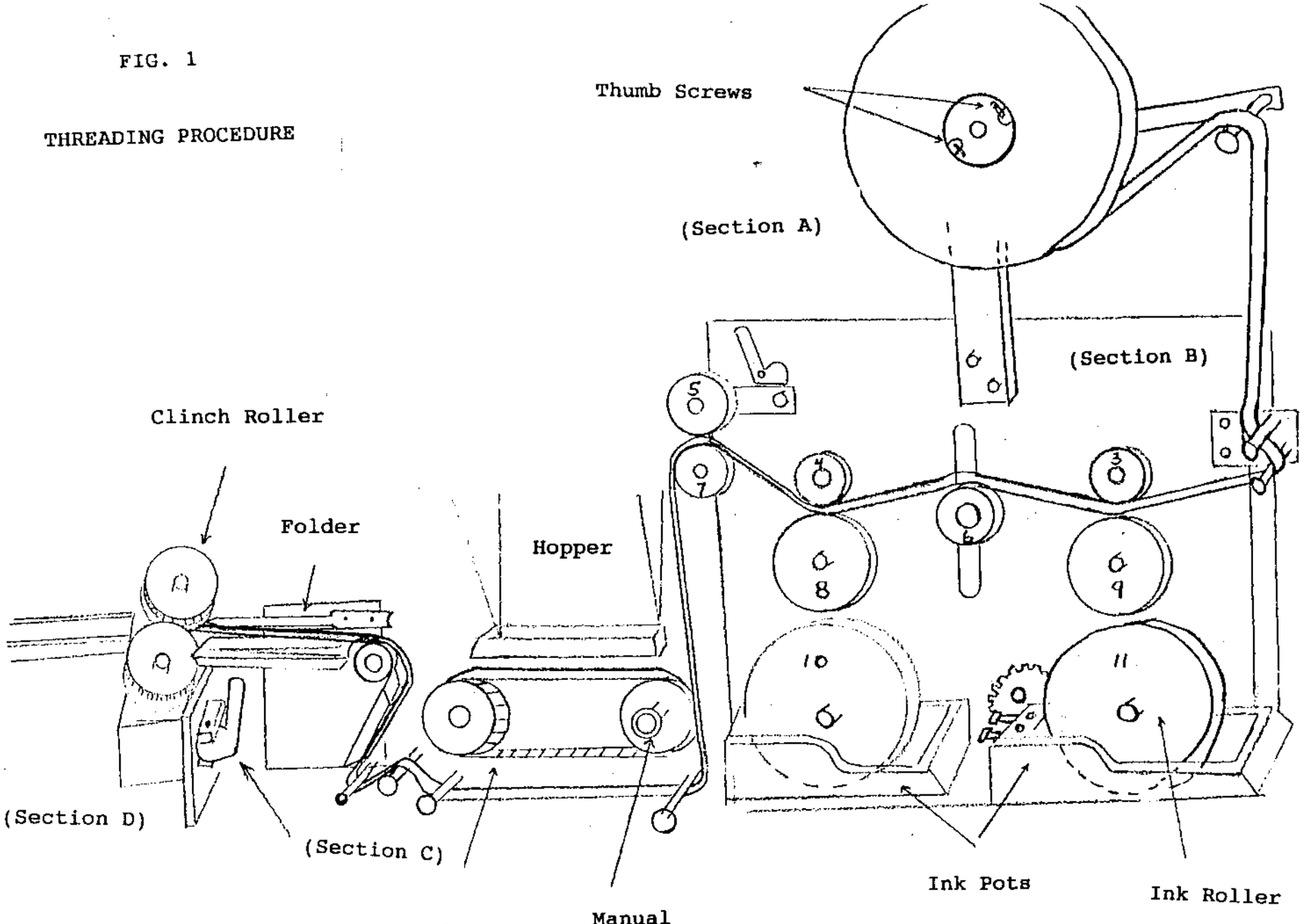


FIG. 2

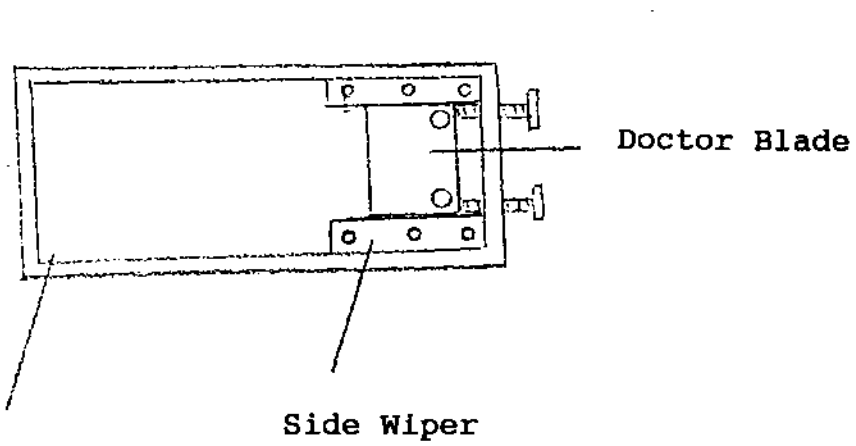
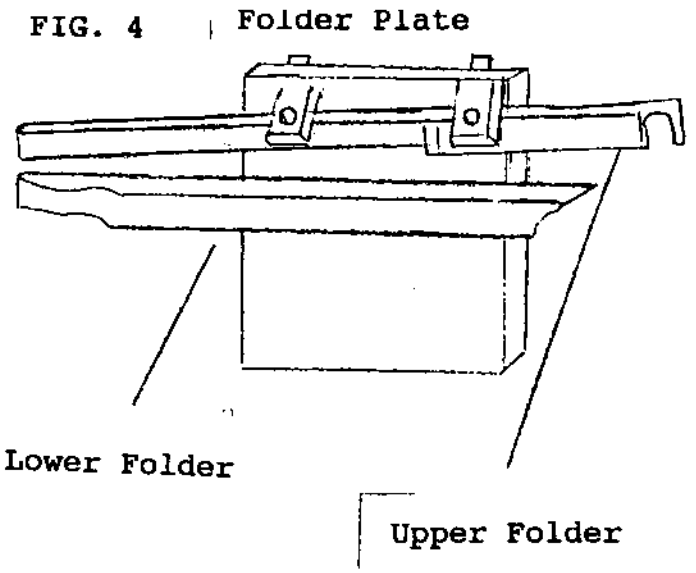



FIG. 4



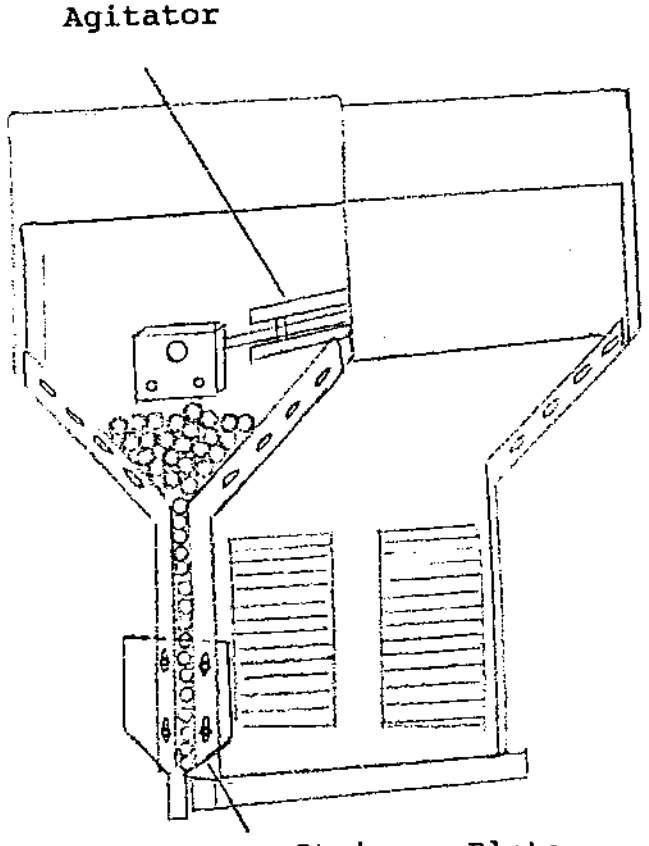




FIG.

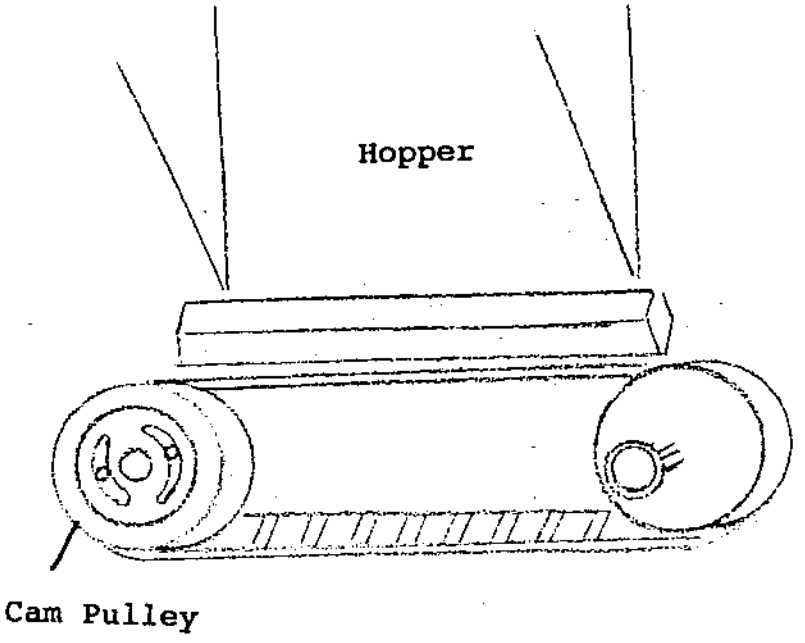



FIG. 5

ADJUSTMENT OF THE "FINGERS": - REFER TO FIG. 1.

The fingers are located in Section C of drawing. The function is to keep the paper from being caught by the FLAG BELT as shown. If the paper touches the flag belt, the fingers must be adjusted by releasing the screws on the front and turning each finger so that the paper is not touching the flag belt.

THE HOPPER: REFER TO FIG. 3

Step 1. The hopper as shown in Fig3. must be loaded with straws, in such a manner that the straws all face the Plexiglass side of the hopper (as shown).

*NOTE*: All straws must lie the same way. Also the straws should be as straight as possible to allow for an even wrap and to avoid the problem of jam-up in the folder assembly.

Step 2. To adjust Stripper Plate, the stripper plate is located in front of the hopper on the magazine. It is a piece of stainless steel fastened by four screws. The magazine should be loaded by jiggling the steel rod which hangs loose from the agitator rod in the hopper to the printer plate. Once the straws fill the magazine they start to come out the bottom of the magazine. Only one straw should come through at a time. Therefore to adjust this, the four screws on the stripper plate (as shown) should be loosened to let one straw come out of the magazine. As the second straw emerges, the stripper plate should cover about 1/3 of the second straw. If this level is maintained, there will always be a proper flow of straws. The screws on the plate should be tightened when the desired level is reached and then the stripper plate is secured in place.

*NOTE*: The agitator is set so that it will only allow for the clearance of one straw and a slight bit more. This is done so that if a straw is slightly bent it will be able to fit in between the agitator blades and there will be no jam-ups.

FOLDER PLATE ASSEMBLY SET-UP: REFER TO FIG. 4.

Step 1. Introduction - the folder plate assembly consists of the upper and lower folder plates which act to fold the paper around the straw as the straw comes out of the hopper and is carried into the folder plate. The straws are transported by means of the "Flag Belt", which is a drive belt containing three metal flags.

Step 2. The straw in the paper is then carried to the "CLINCH ROLL ASSEMBLY", where the paper is cut to size and the straw is sealed.

Step 3. The straws once sealed are transported to the ejector motor where they are ejected through the two rollers onto the conveyor.

MANUAL START-UP: REFER TO FIG. 1.

Once all the initial steps are completed, the next step is to perform a manual start-up. This is accomplished by turning the handle as labeled in Fig. 1 and start to wrap straws. This procedure is done to enable the customer to make sure that his set-up has been completed satisfactorily. If the straws are not being wrapped properly, the following trouble-shooting guide is to be followed.

TROUBLE-SHOOTING:

1. If in the manual start-up, the paper is not being cut, there might be something defective on the urethane piece on one of the clinch rollers. If a new piece of urethane is to be put on the machine, it should be exactly to the given specifications of the manufacturer. The specifications of the urethane are as follows: .045" th. x .187w. x 3/4" lg.

2. If the paper still does not cut, the blade on the opposite clinch roller will have to be changed. The procedure is done the same as in changing the urethane. The specifications of the blade are as follows: .025"th. x 5/16"w. x 3/4" lg.

3. If the machine does not seal, the spring on tension bar in front of the gear box will have to be checked and replaced if it does not give any tension.

FLAG BELT TIMING:

The concept behind this adjustment is so the straws will have an even wrap. To get an idea of what an even wrap means, refer to Fig. 5A. If the straws are uneven on the ends, the timing of the machine must be adjusted. This is accomplished by adjusting the timing device on the cam pulley. (refer to Fig. 5). This is done by loosening the two bolts on the pulley turning the device until the desired setting is made. The desired setting is when the straw is in the paper, there should be about 1/2" overhang of paper on either side of the straw. As the straw passes through the clinch rolls, the rear seal should only be made if the straw front is about one half the way through the rollers of the accelerator assembly.

*Note:* If the straws are passing too slow or too fast, this can be adjusted by the rollers on the accelerator assembly. (refer to Fig. 6) You can adjust the roller assembly by loosening the two bolts on the under side of the accelerator plate as shown.

FIG. 5A

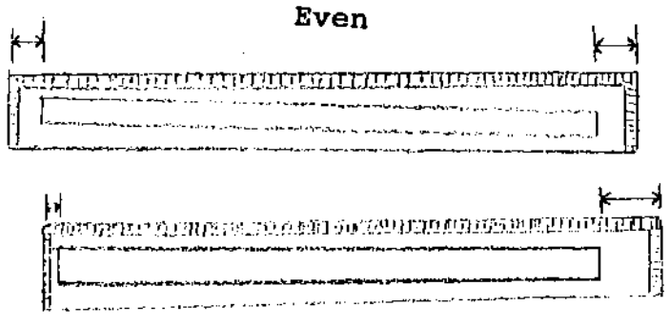



FIG. 7

Changing Flag Belt

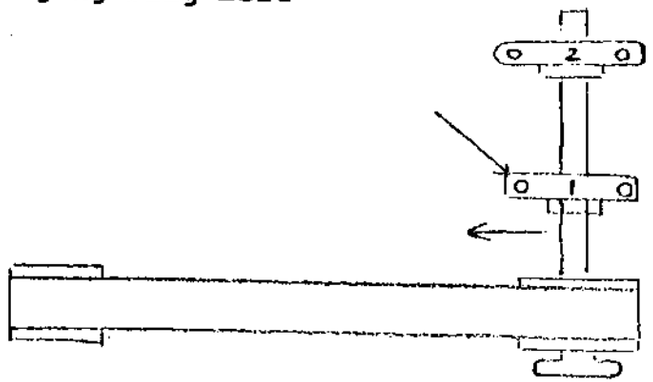
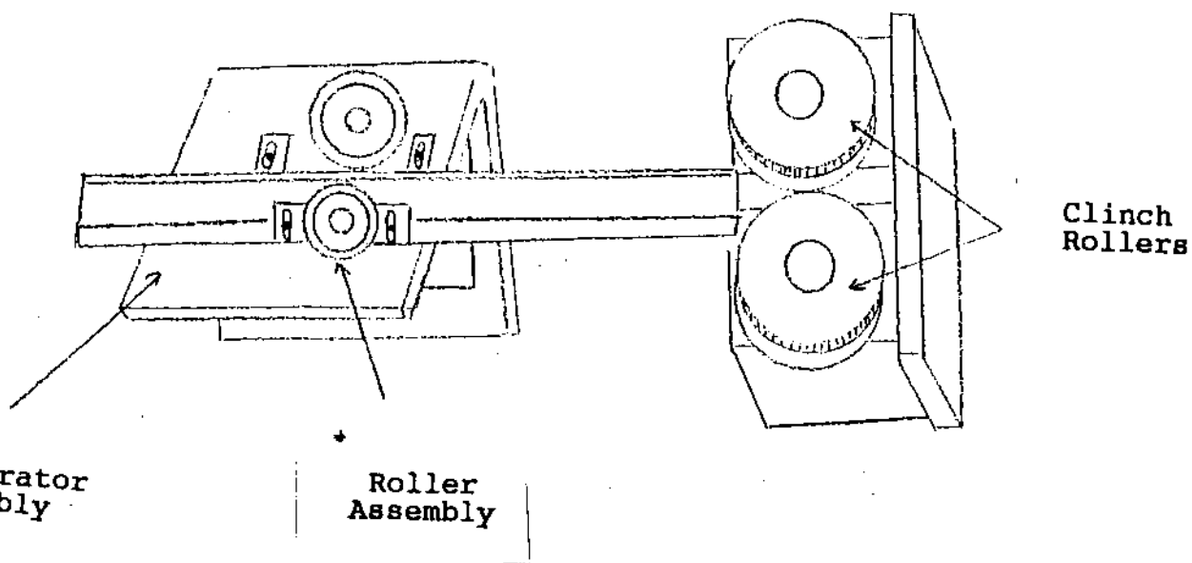


FIG. 6



ADJUSTMENT OF THE FOLDER PLATES: REFER TO FIG. 4

The upper and lower folder plates will have to be adjusted if the top crest of the sealed paper is uneven. (refer o Fig. 5B)

Step 1. If this is occurring, it means that the top folder plate is uneven. In this event, loosen the two bolts on back of the folder plate , push down on the top folder plate, or move the plate from one side to another until the unevenness is corrected.

Step 2. For a looser or tighter wrap, loosen the two bolts on the back of the folder plate and with the hand push down on the top plate in the front of the plate. This will decrease the size of the opening in the front of the folder assembly. Then check the looseness or tightness again and repeat the process until a desired wrap is reached. Then tighten the screws and secure top folder plate in place.

*NOTE*: The opening where the straw enters the folder plates should be 1/2". The front opening will vary according to the tightness or looseness of the wrap. Bottom folder plate should never be higher than the flag belt.

CHANGING THE FLAG BELT: Refer to Fig. 7

This is done by loosening the Hex Bolts on the first bearing holding the idler shaft. Slide the bearing forward and remove belt. Replace with new belt and pull bearing to desired tension. Re-tighten Hex Bolts.

*NOTE*: Important - If any belt in the drive Ass'y has to be replaced, the machine must be retimed.

ELECTRICAL POWER SUPPLY:

The AC power for the DC variable speed motor is single phase, 50 or 60 HZ. Power requirements are approximately 3 KVA. Connect the machine to plant power through a single phase fused disconnect. Make sure that the machine is grounded through the power cable to the plant electrical ground. In wet locations it is recommended that the machine be separately grounded.

The SCR single phase DC motor control module is available for 240 volts AC input only! For all other line voltages, a 3 KVA transformer will be required.

Power to the drive system is turned on via a circuit breaker on the control panel. The drive will not start until the speed potentiometer is rotated clockwise, and the start pushbutton depressed. Belt speed is controlled by the speed potentiometer. The drive may be halted at any time by depressing the stop pushbutton.

CAUTION !!! - The DC motor field energized at 200 volts DC when the circuit breaker is in the "on" position. If the drive is going to be stopped for any length of time, the circuit breaker must be placed in the "off" position.

* After all the adjustments are made, the machine can be started, along with boxer and conveyor units. After running the operation for about an hour, the conveyor can be secured in place.

BOXER SET UP:

- Filtered-lubricated air should be attached to the outlet on the BOXER face, as shown in fig. 8.

- To adjust the speed of the Boxer cylinders refer to fig. 8. On the face as you look at the drawing, there are two pneumatic controls marked A & B. These controls will control the speed of the Boxer by loosening or tightening the adjustment screws on the side of the controls (as shown).

*NOTE:* The speed of the boxer is preset at the factory. Excessive speed will result in premature wear of boxer components.

START UP:

- To start up, the on-off boxer switch on the wrapper panel should be pressed to the on position. At this time the drawer, marked as such on Fig. 8 is pushed into position so that the micro-switch is activated to start the machine.

CONVEYOR SET-UP AND OPERATION:

- As pointed out in step 1 of the wrapping machine instructions, the conveyor should not be secured until the operation of wrapping straws has been running for about an hour or long enough to make sure that the straws are falling on to the conveyor belt. The conveyor is to be set up at a right angle to the wrapper and is finally secured when the operation is set up to its maximum potential.

- Fig. 9 is a schematic of the CONVEYOR itself. The actual belt is shown as well as item A. The adjustment screw is used to loosen or tighten the belt depending on the desired performance. This should be the only adjustment which has to be made for the initial start up.

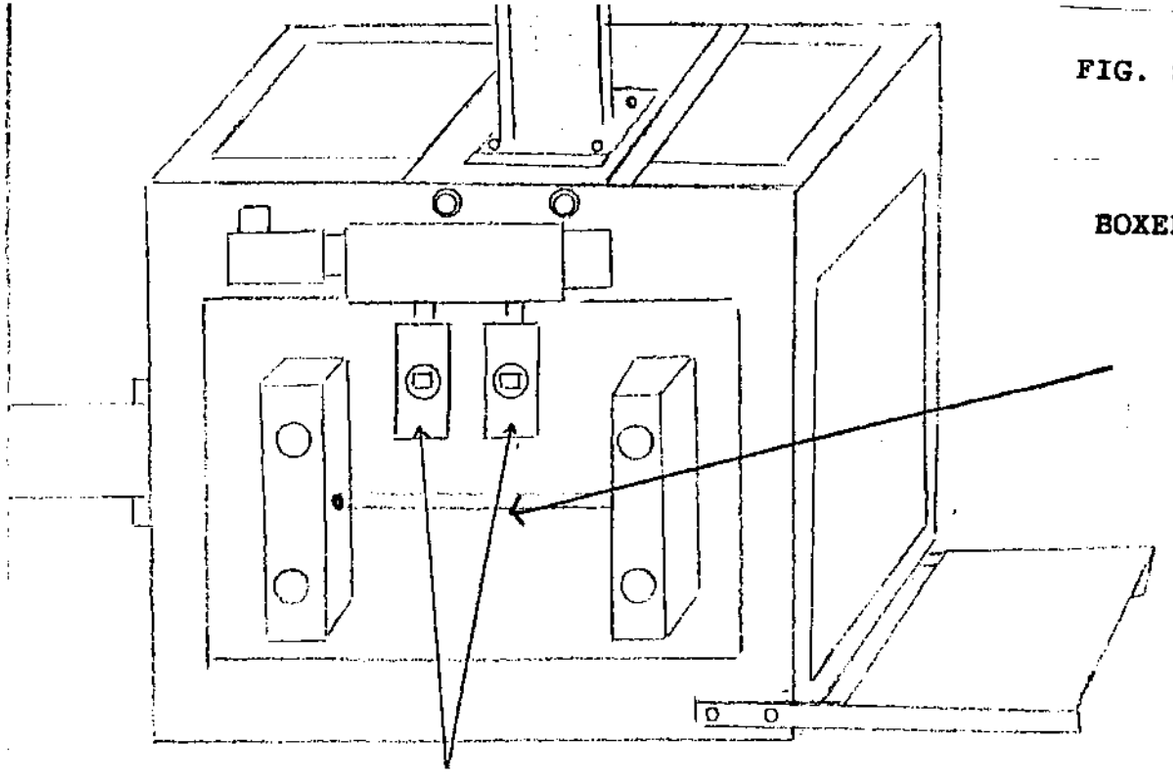



FIG. 8

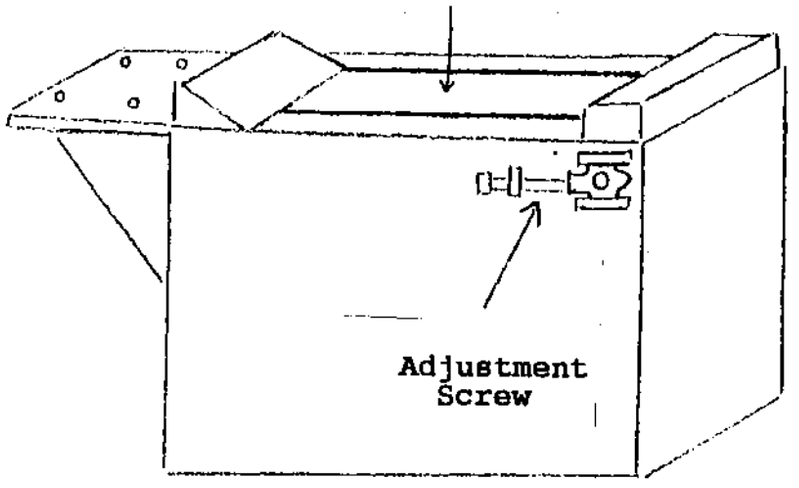



FIG. 9

CONVEYOR

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THE COUNTER:

The counter is located behind the vertical plate on the wrapper. Its function is to open and close the conveyor brush assembly when desired number of straws are counted. A magnet mounted on the timing pulley passes the reed switch, sending a signal to the counter. This magnet should be kept clean and adjusted to approximately 3/16" from the reed switch. Improper adjustment, or dirty magnet will cause counter malfunction.

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*CONAIR GATTO*

*STRAW WRAPPING MACHINE*

Drawings:

| | |
|---|---|
| D-SW-198 | Drive Assembly |
| C-SW-199 | Ejector Assembly |
| D-SW-200 | Clinch Roller Assembly |
| C-SW-20A | Folder Assembly |
| R-SW-202 | Straw Hopper Assembly |
| D-SW-324 | Vertical Plate Assembly |

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# SPARE PARTS LIST

| DESCRIPTION | PART NUMBER |
|---|---|
| Clinch Roll, 5 1/2" Straw | 0802-02246 |
| Clinch Roll, 6 1/4" Straw | 0802-02483 |
| Clinch Roll, 7 5/8" Straw | 0802-02823 |
| Clinch Roll, 8 1/4" Straw | 0802-00758 |
| Clinch Roll, 10 1/4" Straw | 0802-03064 |
| Clinch Roller Blade #9 | 3515-00223 |
| Urethane Back-Up Strip | 0802-07426 |
| 4-40 x 3/16 Set Screw | 4527-00519 |
| Felt For Clinch Wipers | 0802-03269 |
| Ink Pot Assembly - Complete | 0802-03994 |
| Ink Pot ONLY | 0802-01312 |
| Ink Pot - CORE | 0802-01339 |
| Doctor Blade | 0802-00065 |
| Side Wiper | 0802-00073 |
| Clinch Roll Wiper | 0802-03269 |
| Rubber Roller Assembly - Complete | 0802-00464 |
| Rubber Roller ONLY | 0802-00057 |
| Bearings For Roller ONLY | 3558-00316 |
| Motor For Brush | 1577-00766 |
| Pulley 12L050-5/8" | 0802-02122 |
| Pulley 24L05-3/4" | 0802-02149 |
| Flag Belt ONLY 270L100 | 3512-00141 |
| Complete Flag Belt | 0802-03439 |
| Flag (Stamping) | 0802-00251 |
| Ink Wheel Assembly | 0802-02777 |

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| DESCRIPTION | PART NUMBER |
|---|---|
| Paper Guide, 22MM Paper | 0802-00022 |
| Paper Guide, 27MM Paper | 0802-04648 |
| Paper Guide, 31MM Paper | 0802-04656 |
| Folder, Base - .187" Diameter | 0802-00367 |
| Folder, Base - .240" Diameter | 0802-04257 |
| Folder, Base - .312" and .325" Diameters | 0802-04265 |
| Folder - .187" Diameter | 0802-00456 |
| Folder - .240" Diameter | 0802-04303 |
| Folder - .312" Diameter | 0802-04281 |
| Exit Roller | 0802-00626 |
| Exit Guide | 0802-01096 |
| Straw Hold Down | 0802-01142 |
| Ball Bearing | 3558-00278 |
| O-Ring 1 1/4" x 1 1/2" x 1/8" | 5556-00265 |
| V-Belt | 3513-00374 |
| Motor - #3M-560 1/70 HP | 1577-00146 |
| Flag (Agitator Itself) | 0802-02081 |
| Connecting Rod (Agitator) | 0802-01509 |
| Rod End Bearing | 3509-00068 |
| Tampico Brush | 7503-00061 |
| Adjusto Speed Board For 1/2 HP Motor | 1575-00025 |
| Kleen-Tex Belt, 9 7/8" x 84 9/16" | 3510-00365 |
| Brush 10" Long, Braun 2749 | 0802-00189 |
| Proximity Sensor Bar | 0802-01568 |
| Clinch Roller Drive Shaft | 0802-00863 |
| Clinch Roller 4/81 Idler Shaft | 0802-00871 |