

Parts Catalog

4180 And 418HE Bag Machines

SAFETY INSTRUCTIONS

We, as a manufacturer, and you, as an owner or operator, share a common responsibility to exert every effort to insure that our equipment be installed, operated, and maintained with a maximum degree of safety to personnel and property.

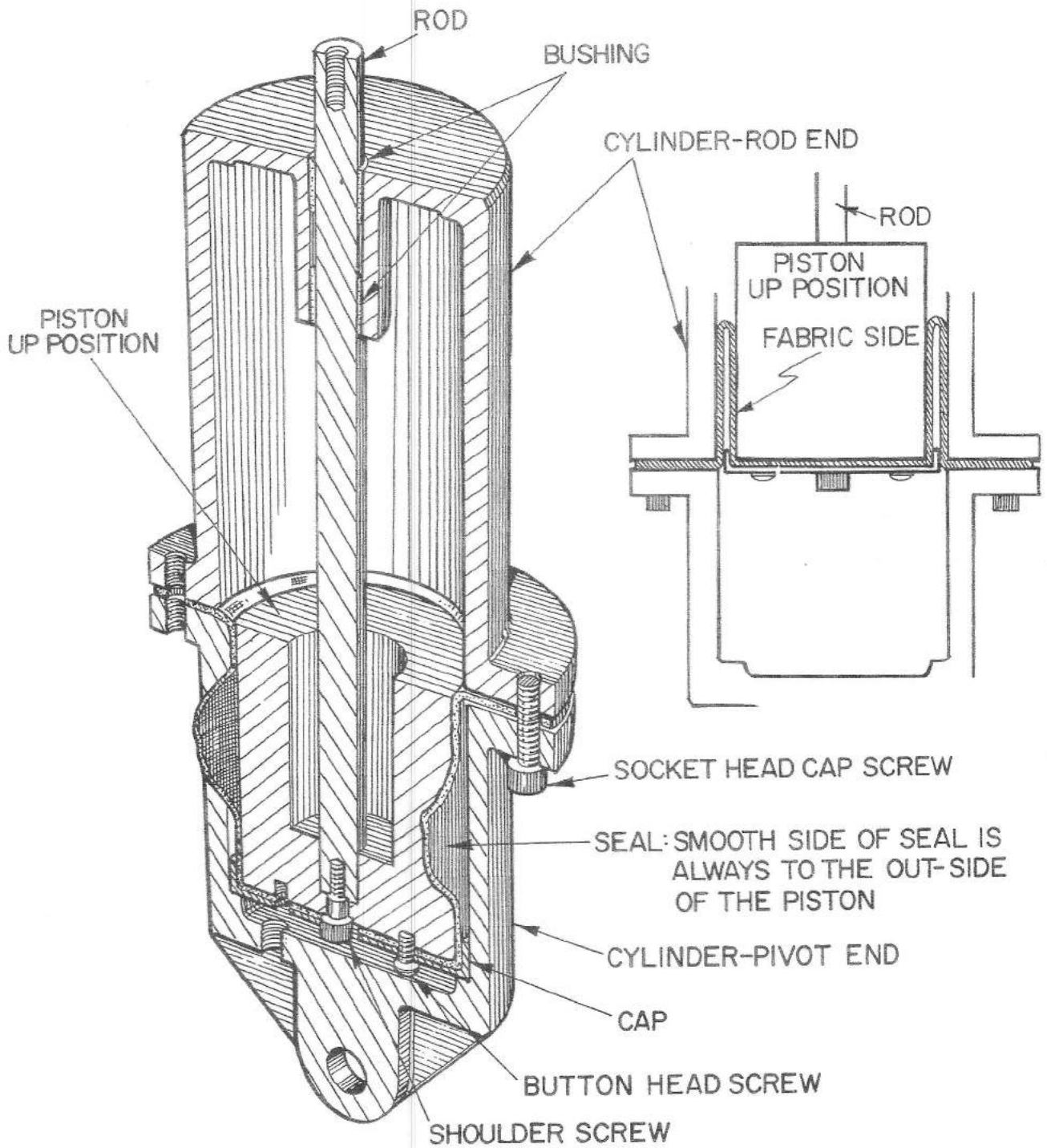
The safety instructions provided with this equipment should be given to the individuals responsible for plant safety - design - installation - operation and maintenance. Additional copies are available upon request.

In addition it is advisable that all other equipment supplied by Gloucester undergo a periodic safety inspection to determine that guards, safety markings and safety cables are installed and in working order.

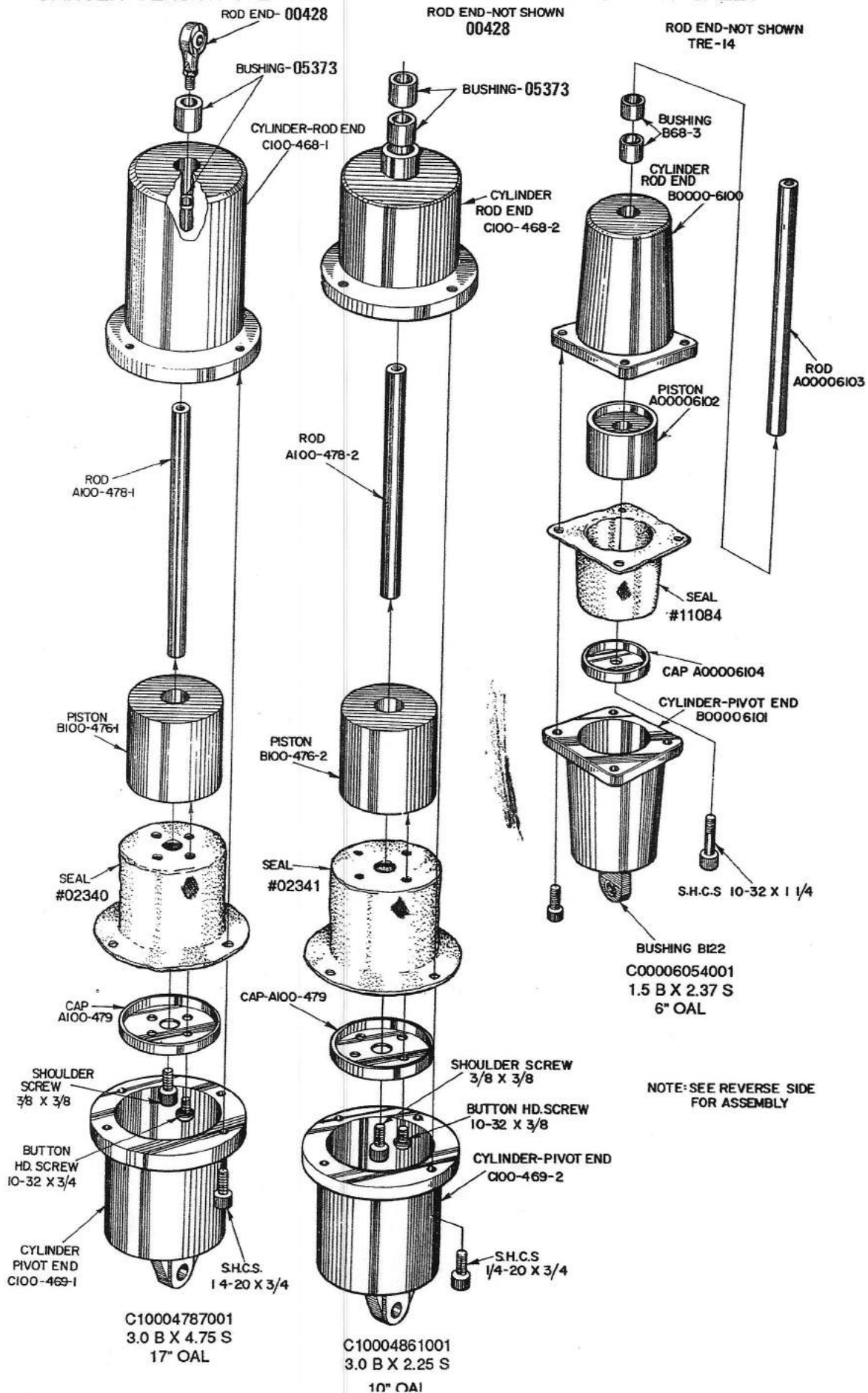
Battenfeld 
Gloucester

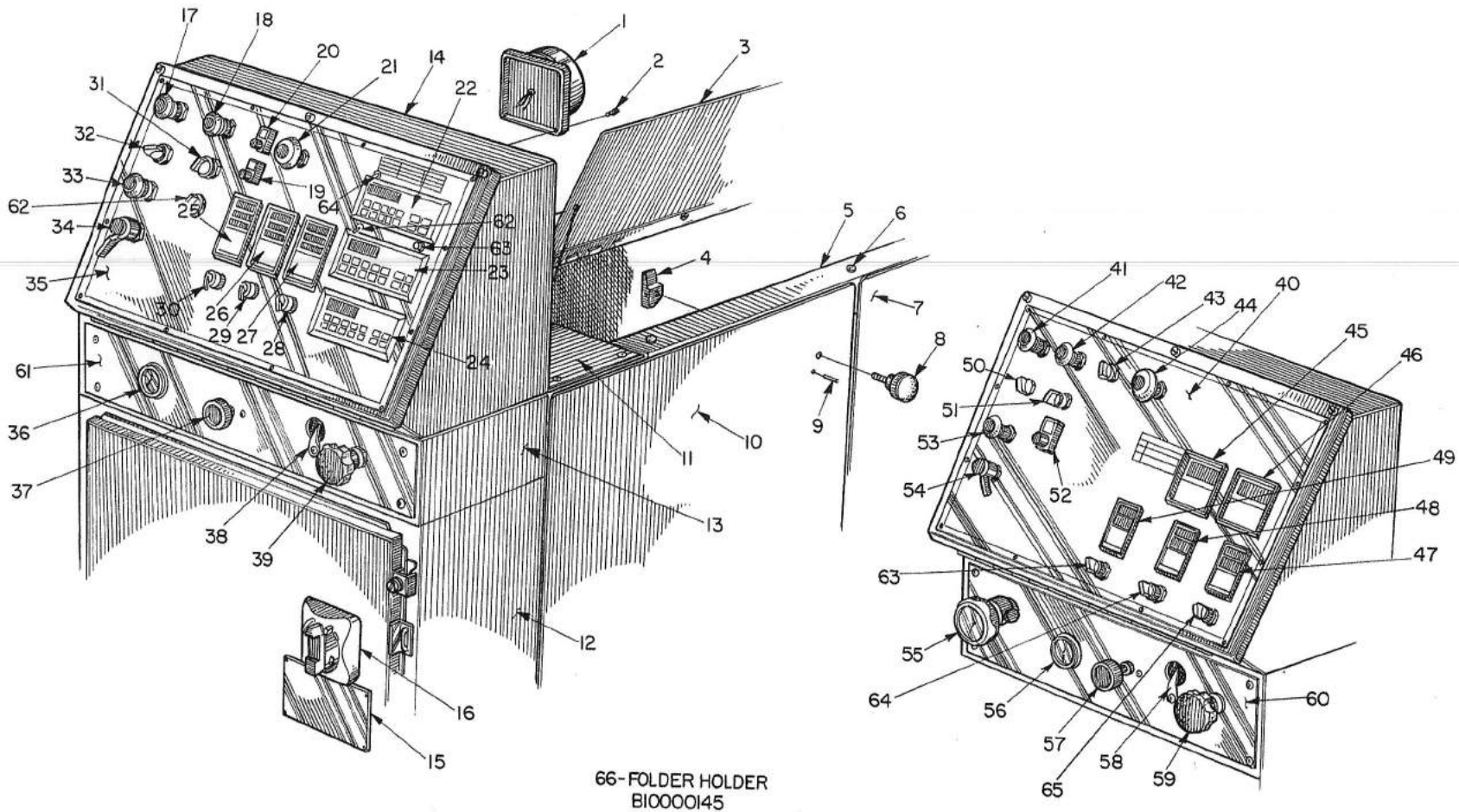
DANCER TENSION CYLINDER-ASSEMBLY DRAWING

TYPICAL DRAWING-NOT FOR REORDERING PARTS



DANCER TENSION CYLINDER PARTS CATALOG & ASSEMBLY SHEET

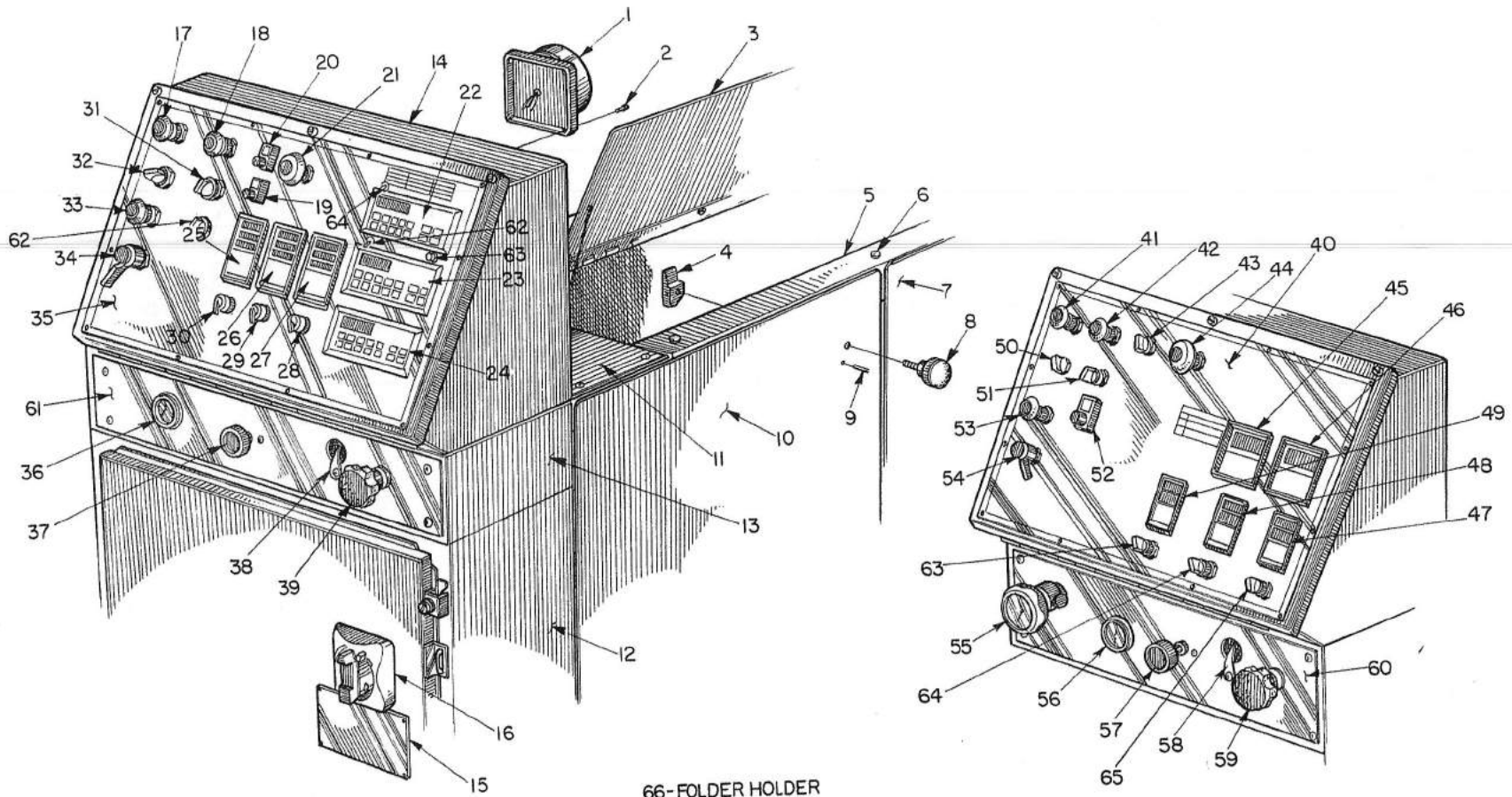




List 1 Controls

Key No.	Description	Part No. 4180	Part No 418HE	Part No 4180/418HE
1	Bell Gong			03864/3901
2	SHCS (F10087006-030)			10-32X3/4
3	Cover - RH			D10108453
4	Latch - RH			A00040001-001
	Latch - LH			A00040001-002
5	Bracket			D10110466
6	Rubber Bumper			02424
7	Door			C10064225
8	Knob (washer 04801)			02545
9	Roll Pin (F10087262-060)			1/8 X 1
10	Door			E10120235
11	Plate			E10110470
12	Cabinet			D10110464
13	Brace			D10110465
14	Console			D10108449
15	Name Plate	05986		
16	Switch, Dics.	38640		
17	Switch Push/Pull	08545		
18	Switch Push/Pull	08545		
19	Pot (dial 33989)	31072		
20	Pot (Dial Pot 33989)	00139		
21	Switch Push/Pull	38643		
22	Counter	39286		
23	Counter	39286		
24	Counter	31040		
25	Controller	36188		
26	Controller	36188		
27	Controller	36188		
28	Selector Switch	31077		
29	Selector Switch	31077		
30	Selector Switch	31077		
31	Selector Switch	02956		
32	Pot	06013		
33	Push/Pull Switch	01383		
34	Selector Switch	01383		
35	Controls Plate	D40051067		
36	Gage			02255
37	Pressure Regulator			02312
38	But. Hd. Screw			A04180364
	Pointer Shaft			A04180363
	Knob			02540
	Bushing			A04180291
	Hex Nut			A04180794
	Shaft			A04180387

Needs to be programmed before shipping



66-FOLDER HOLDER
BI0000145

List 1 Controls continued

Key No.	Description	Part No. 4180	Part No 418HE	Part No 4180/418HE
40	Panel		D40051071	
41	Push/Pull Switch		08545	
42	Push/Pull Switch		08545	
43	Selector Switch		02956	
44	Push/Pull Switch		38643	
45	Meter		36473	
46	Counter		36472	
47	Controller		36188	
48	Controller		36188	
49	Controller		36188	
50	Pot (Name Plate 05519)		05862	
51	Selector Switch		02956	
52	Pot (Dial 33989)		00139	
53	Switch - Push/Pull		08201	
54	Selector Switch		01383	
55	Controller		B04180132	
56	Gauge - 0-60			02255
57	Regulator (See #38-39)		02313	02313
58	Pointer (See #38-39)		A04180363	A04180363
60	Gage Plate		D10109665	
61	Plate	D10109665		
62	Selector Switch	02956		
63	Selector Switch		02956	
64	Toggle Switch		39641	
65	Selector Switch		02956	
66	Folder Holder			B10000145

Plate 2 Hydraulic Assembly

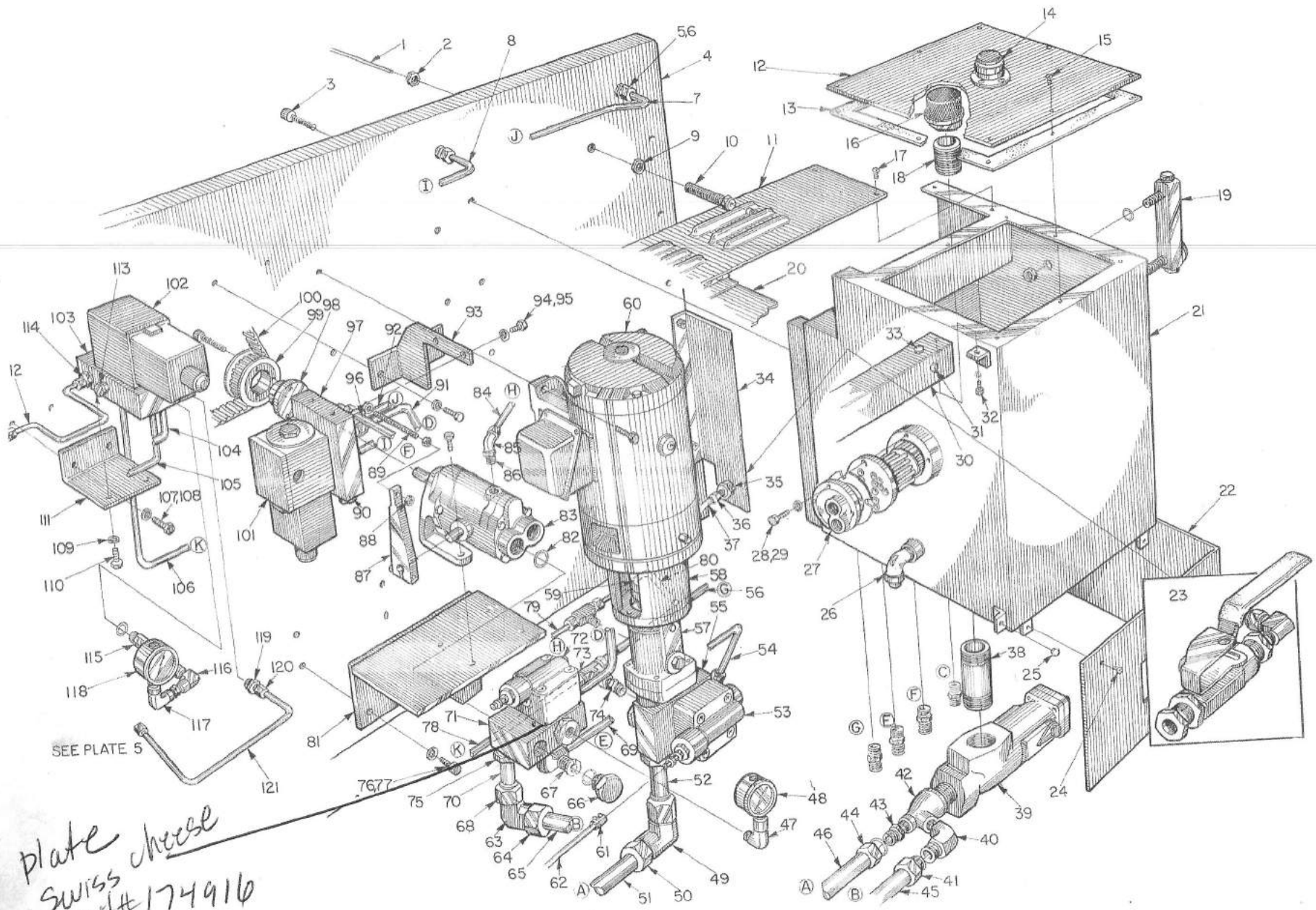


plate case
swiss
part# 174916

SEE PLATE 5

List 2 Hydraulic Assembly

Key No.	Description	Part No. 4180	Part No. 418HE	Part No 4180/418HE
1	Wire Rope			8221
2	Hex Nut (F10087192-100)			1/2 - 13
3	SHCS (F10087011-060)			3/8-16X1 1/4
4	Frame R.H.	E10110600		
5	Fitting			37523
6	Fitting			37530
7	Pipe #1	C10117203		
8	Pipe #2	C10117202		
9	Rear Skirt		E101104671	
10	Screw Cable Adj.			A10052027
11	Cover			E10110470
12	Tank Cover			C10108417
13	Gasket			C10108418
14	Oil Filler Cap			02095
15	But. Hd. Screw (F10087066-030)			10-32X1/2"
16	Oil Tank Screen			37114
17	But. Hd. Screw (F10087066-020)			10-32X3/8"
18	Nipple	2" X Close		H10090839
19	Gage Level		08225	
20	Door			D10108453
21	Tank			E10108353
22	Skirt Rear RH			E10110467
23	Valve			36338
24	But. Hd. Screw (F10087066-030)			10 - 32 X 1/2.
25	Rubber Bumper			02424
26	Elbow (plug) 3/4	3/4		3/4" St E1
27	Heat Exchanger			11294
28	Hex Hd. Screw (F10087075-080)			5/16 - 18 X 1 1/2
29	Lock Washer (F10087187-020)			5/16
30	Brkt. Top R.H.			D10110466
31	Bumper			02424
32	SHCS (F10087007-020)			1/4 - 20 X 1/2
33	Rubber Bumper			02424
34	Air Inlet Bracket			C10110471
35	Bulkhead Connector			A04180706
36	Fitting			1/4 Poly X 1/4
37	Line		Pipe	1/4 Poly
38	Nipple	2 X 6		H10090839
39	Filter (paper element #1686)			02193 (complete filter)
40	Elbow			37526
41	Fitting			37531
42	Coupling (Nipple 2X close)	2 X 1 X 1		Bell Reducer (2" X 1" X 1")

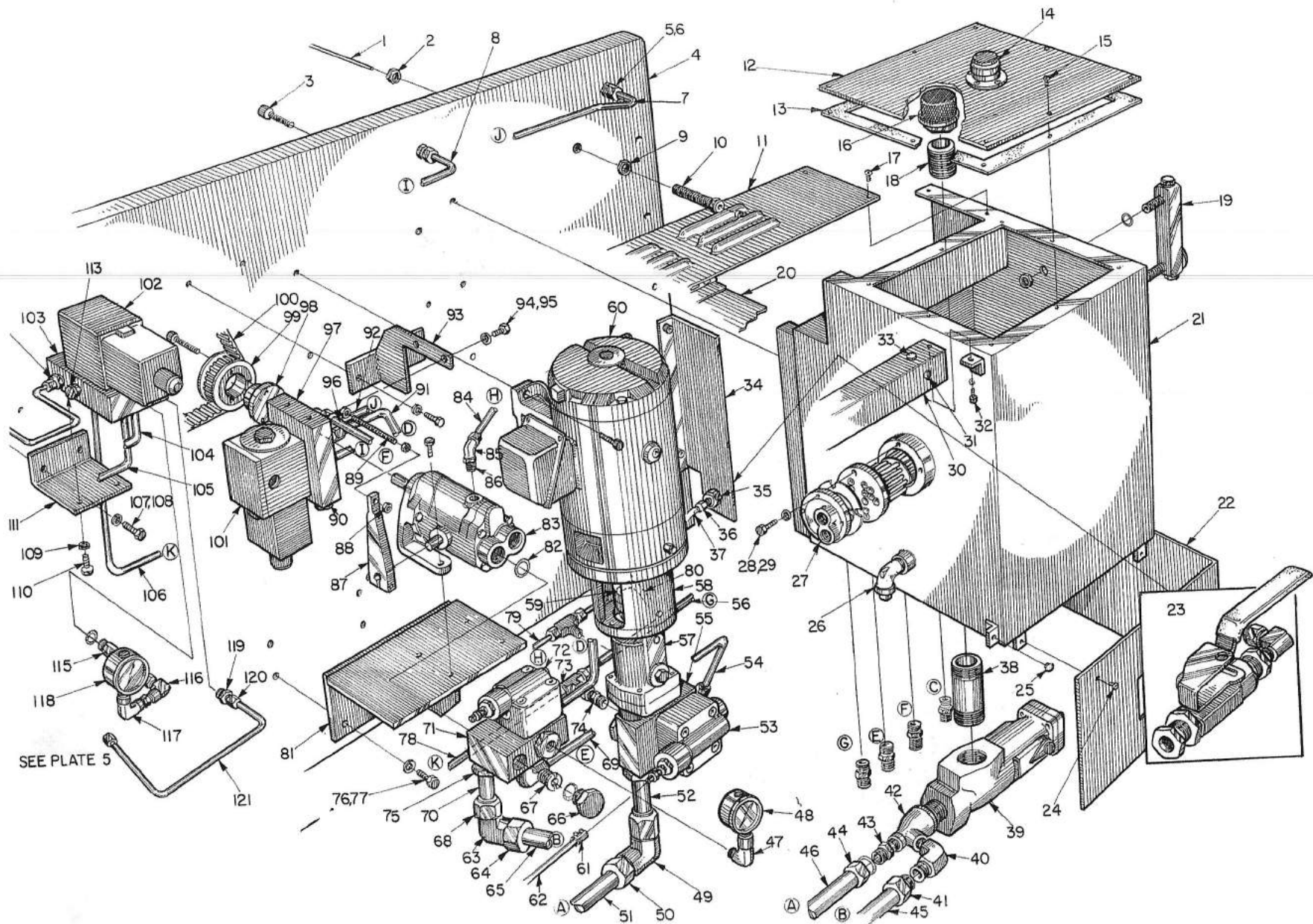


Plate 2 Hydraulic Assembly Continued

List 2 Hydraulic Assy. cont.

Key No.	Description	Part No. 4180	Part No 418HE	Part No 4180/418HE
43	Fitting			37521
44	Fitting			37531
45	Pipe	C10117537		
46	Pipe	C10117538		
47	Elbow (Plub w/Tap/A04180547)			1/4 Male X 1/4 Female
48	Gage			13469
50	Fitting			37531
51	Pipe	C10117538		
52	Plug Fitting			A10070517
53	Valve-Relief			02378
54	Line #5	D10117206		
55	Plate Sub (Relief Valve)			C04180030
56	Line #4			C10112747
57	Head Pump			A10021111
58	Motor (Part of #60)			21656
59	Coupling			05400
60	Motor			21656
61	Coupling			A04180289
62	Cable (casing A10020255)			B04180420-33
63	Elbow			37528
64	Fitting			37531
66	Plug	A04180547		
67	Screw, Sub Plate			A04180029
68	Fitting			37531
69	Line #7	C10112745		
70	Plug Fitting			A10070517
71	Plate Sub (Relief Valve)			C04180030
72	Valve - Relief			02378
73	Tee Fitting			37527
74	Fitting			37523
75	Fitting (Part of #70)			A10070517
76	Hex Hd Screw (F10087076-070)		3/8 - 16 X 1 1/2	
77	Washer (F10087187-030)		3/8	
78	Line #3	D10117207		
79	Line #13	B10088864		
80	Line #14	C10112746		
81	Shelf - Pump	C10115780		
82	O-Ring			01206
83	Pump Shuttle			A10021212
84	Line #13	B10088864		
85	Elbow			37524
86	Fitting (Part of 85)			37524
87	Adjusting Arm	B04000080	B04000080	

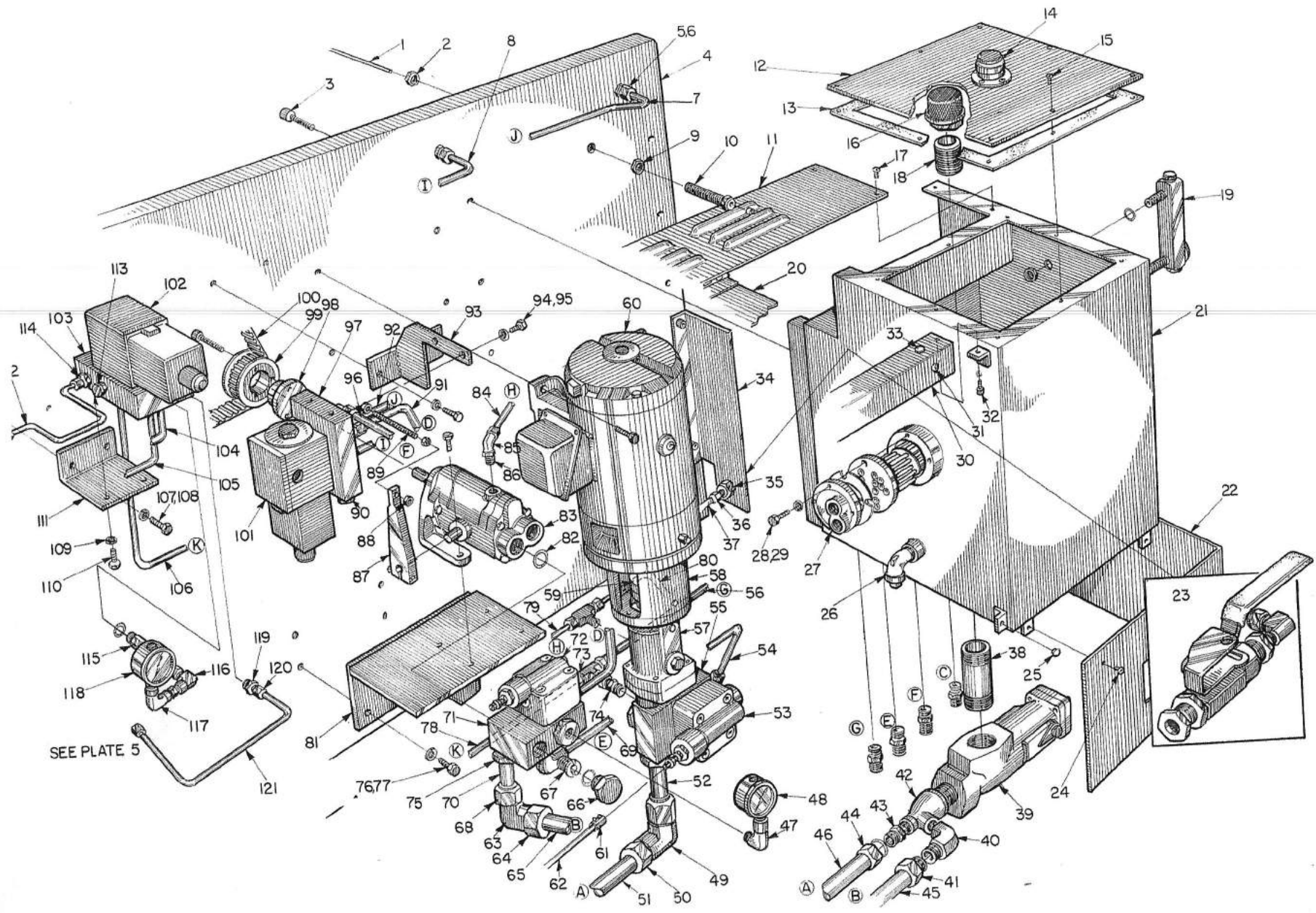


Plate 2 Hydraulics Assembly Continued

List 2 Hydraulics cont.

Key No.	Description	Part No. 4180	Part No 418HE	Part No 4180/418HE
98	Bushing		A10005994	
99	Pulley			00922
100	Belt (750H100)			0110
101	Valve	19955		
102	Valve	19955		
103	Plate Sub Hdy. Line #4 to Fitting G (C10112747)	D10115778		
104	Line #9	C10120468		
105	Line #10	C10120469		
106	Line #3	D10117207		
107	Hex Hd. Bolt (F10087076-050)	3/8 - 16 X 1"		
108	Washer Lock (F10087187-030)	3/8		
109	Washer Lock (F10087187-030)	3/8		
110	Hex Hd. Bolt (F10087076-050)	3/8 - 16 X 1"		
111	Bracket	C10117201		
112	Line #12	C10119712		
113	Plug	A04180424		
114	Fitting	01531		
115	Fitting	A10115652-002		
116	Elbow	PH 1/4 CD-S		
117	Elbow	PH 1/4 CD-S		
118	Gage			13468
119	Fitting			31409
120	Fitting (Part of 119)			31409
121	Tubing (Line #11)	C10119711		

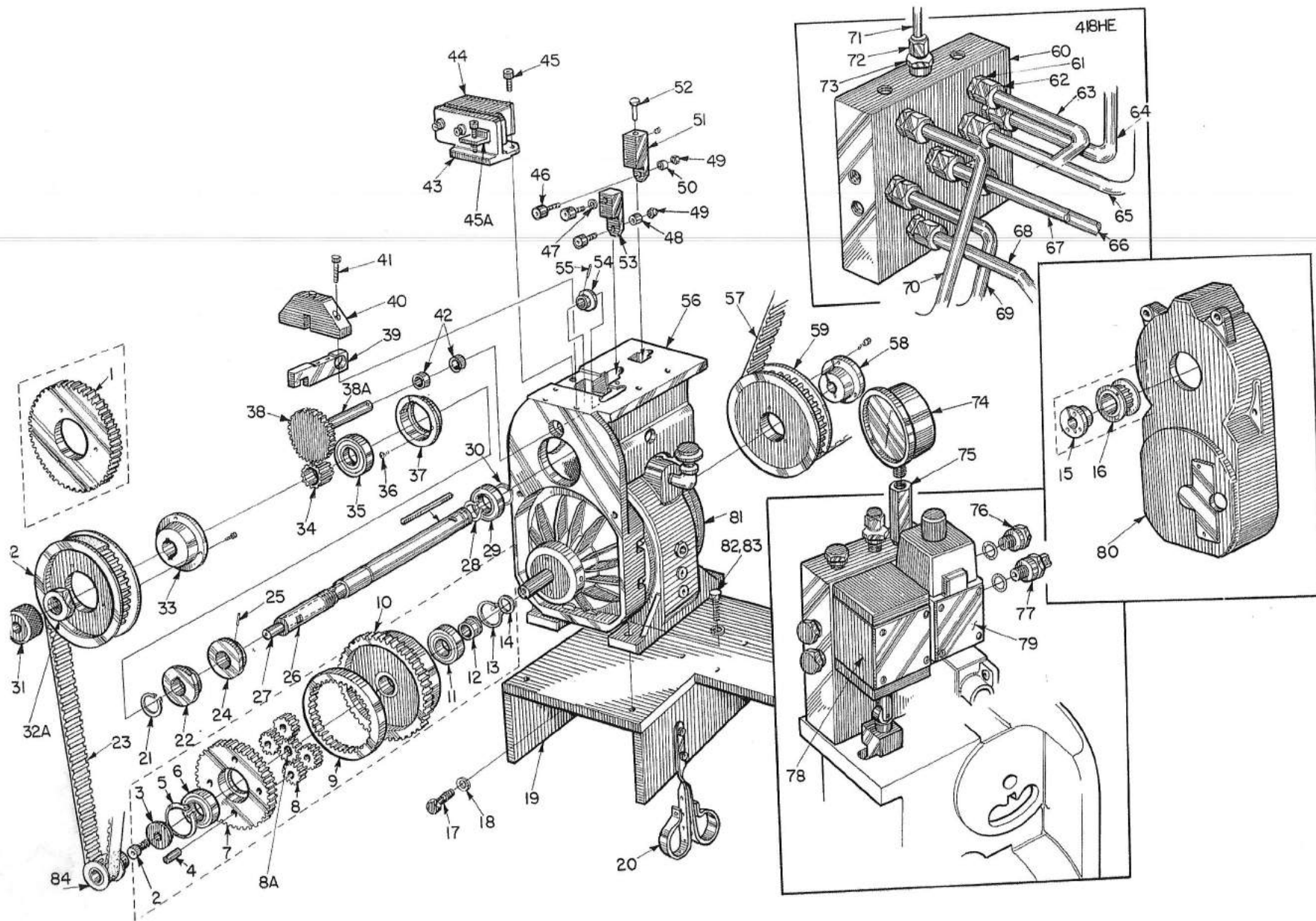


Plate 3 Camshaft Drive/Register Control

List 3 Camshaft Drive/Register Control

Key No.	Description	Part No. 4180	Part No 418HE	Part No 4180/418HE
1	Gear		B04180192	
2	SHCS (F10087011-030)		3/8 - 16 X 3/4	
3	Sleeve		A04180185	
4	Dowel Pin (F10087277-030)		1/2 X 1 1/4	
5	Retaining Ring		04739	
6	Bearing		25051	
7	Gear		B04180786	
8	Gear		A04180186	
8A	Gear		A04180188	
9	Gear	B04180189		
10	Gear	B04180191		
11	Bearing		25051	
12	Sleeve		A04180184	
13	Retaining Ring		04739	
14	Thrust Washer		A10000360	
15	Bushing		00507	
16	Pulley		00926	
17	Hex Hd. Bolt (F10087076-060)		3/8 - 16 X 1 1/4	
18	Lock Washer (F10087187-030)		3/8	
19	Shelf-Pump		C10115780	
20	Clamp Bracket		S00025369	
21	Retaining Ring		01337	
22	Cam - Head		B04180616	
23	Belt		01059	
24	Cam - Shuttle		C04180008	
25	Roll Pin (F10087265-120)		1/4 X 2"	
26	Shaft		C04180552	
27	Shaft		A04180554	
28	Retaining Ring		01279	
29	Bearing		00336	
30	Retaining Ring		01279	
31	Knob		A04180081	
32	Pulley		B04180555	
33	Bushing		B04180563	
34	Pinion		A04180410	
35	Bearing		00336	
36	But. Hd. Screw (F10087060-020)		1/4 - 20 X 1/2	
37	Bearing Retainer		B04180562	
38	Gear		B04180409	
38A	Shaft		A04180413	
39	Slide		A04180560	
40	Bracket		A04180559	
41	SHCS (F10087007-050)		1/4 - 20 X 7/8	
42	Bearing		00272	

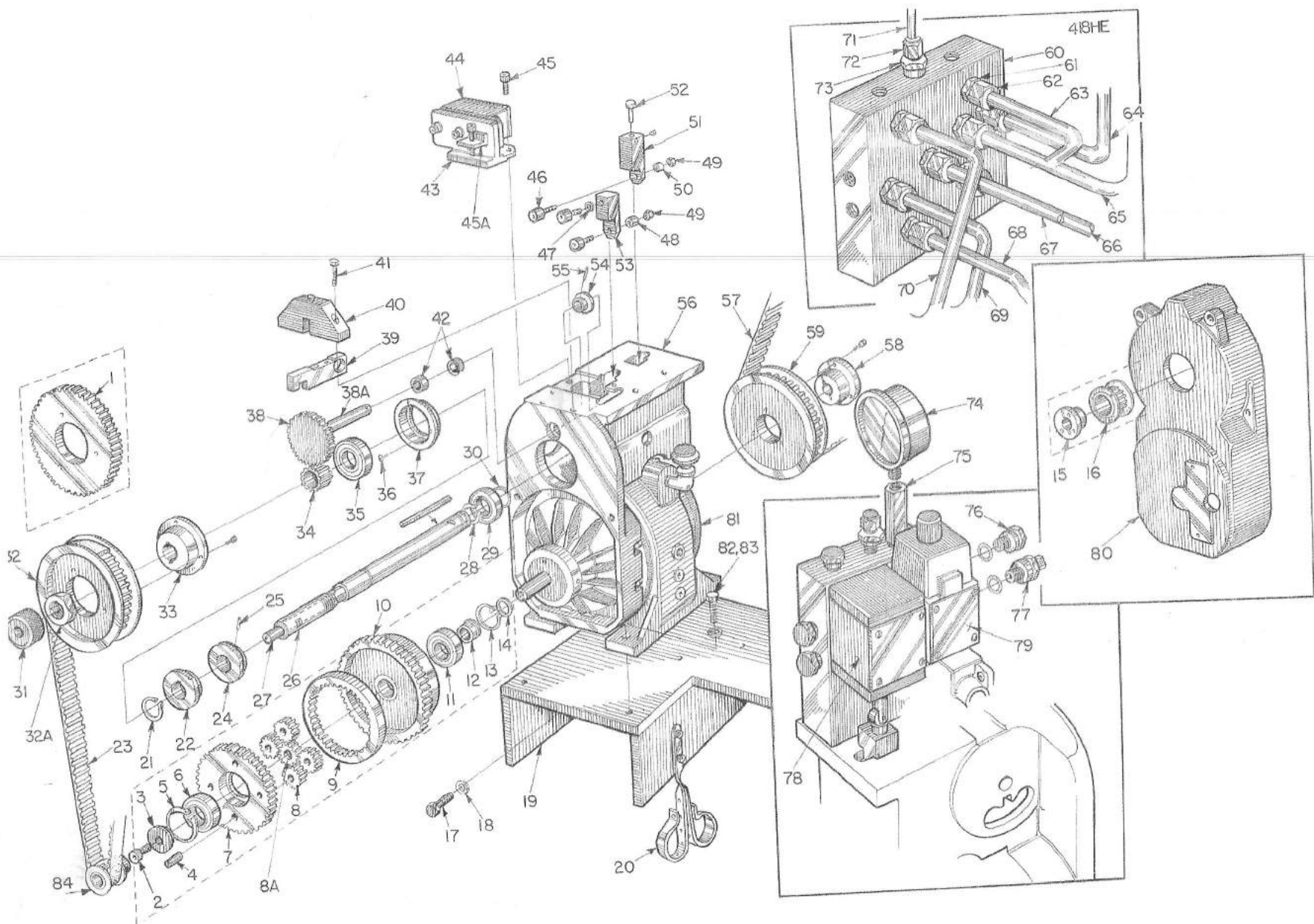
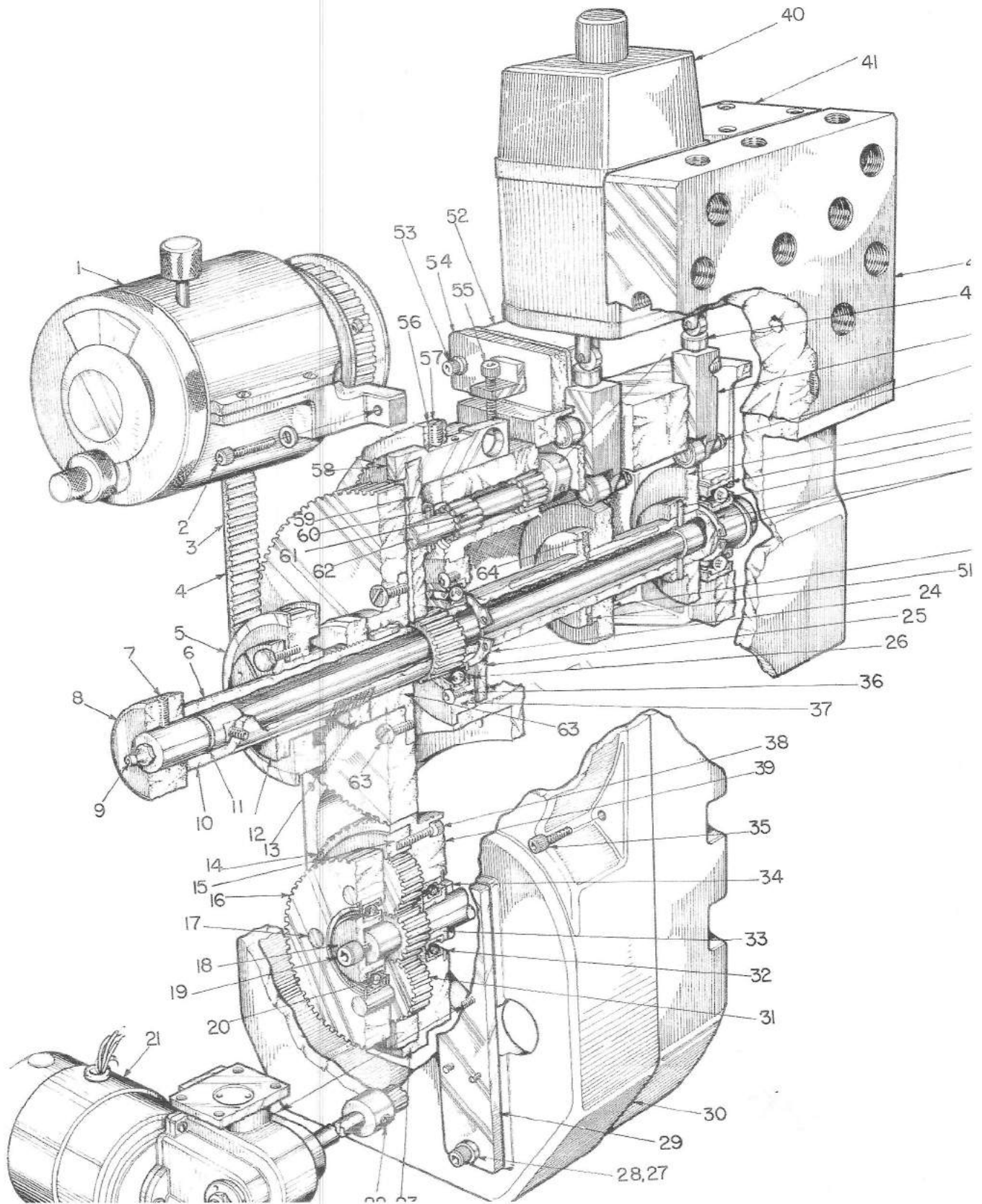


Plate 3 Camshaft Drive/ Register Control Continued

List 3 Camshaft Drive/Register Control cont.

Key No.	Description	Part No. 4180	Part No 418HE	Part No 4180/418HE
43	Bracket		B04180607	
44	Switch (Limit)		02944	
45	SHCS (F10087007-040)		1/4 - 20 X 3/4"	
46	Cam-Roll		00215	
47	Washer Lock (F10087187-010)		1/4"	
48	Spacer		B00050001-028	
49	Stop Nut		11817	
50	Spacer		B00050001-028	
51	Plunger - Shuttle		A04180557	
52	Pin, Plunger Adjustment		A04180558	
53	Plunger, Head		A04180615	
54	Cam - Skip Cycle		C04180418	
55	Roll Pin (F10087262-050)		1/8 X 3/4	
56	Housing		E04180495	
57	Belt		01092	
58	Bushing SDS - 3/4		05063	
59	Pulley 48L050		00954	
60	Sub Plate		A04180021	
61	Fitting			37523
62	Fitting - Nut			37530
	Pipe #8		C10000024	
64	Pipe #1		D10000022	
65	Pipe #2		D10000021	
66	Pipe #6		C10112752	
67	Pipe #5		D10000020	
68	Pipe #3		D10000024	
69	Pipe #9		C10000023	
70	Pipe #10		C10000022	
71	Pipe 5/16"		C10119711	
72	Fitting			Part of 73
73	Fitting			31409
74	Gauge			02255
75	Adapter		A10115652-002	
76	Fitting - Plug			A04180424
77	Fitting			31409
78	Valve - Directional Shuttle		A10022779	
79	Valve - Directional Head		A10080408	
80	Housing Cover		D04180454	
31	Variator		B04180128	
32	Hex Hd. Screw (F10087076-050)		3/8 - 16 X 1"	
	Washer (F10087187-070)		3/8	
	Pulley		A04180659-3	
35	Variator Oil		5904	

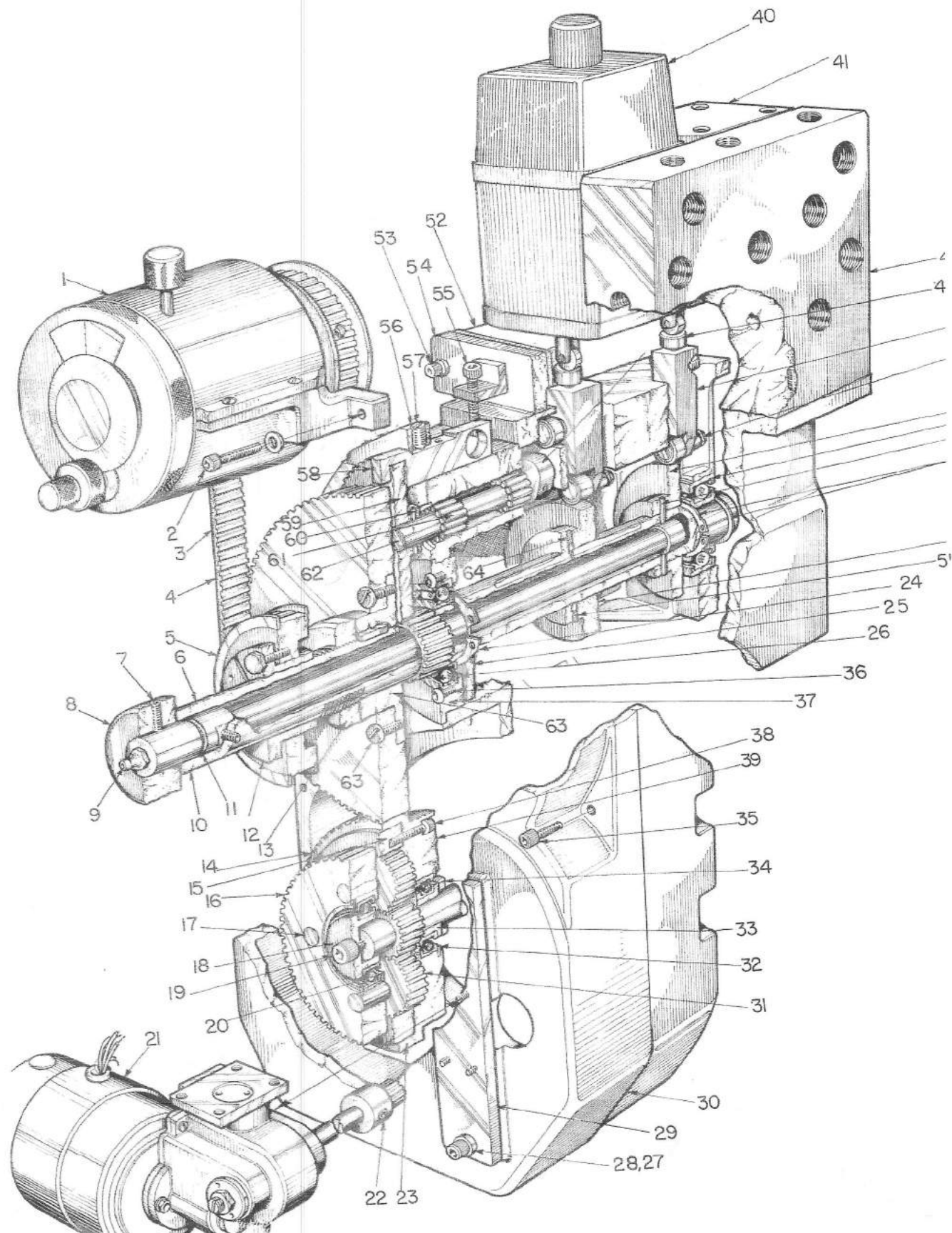
Plate 4 Camshaft - Register Control



List 4 Camshaft - Register Control

Key No.	Description	Part No. 4180	Part No 418HE	Part No 4180/418HE
1	Selector Switch		29884	
2	SHCS (F10087007-080)		1/4 - 20 X 1 1/2	
3	Belt		1048	
4	Belt			
5	Pulley		B04180555	
6	Shaft		C04180552	
7	SSS (F10087101-050)		1/4 - 20 X 1/2	
8	Knob		A04180081	
9	Fitting		1/4 - 28	
10	Shaft		C04180552	
11	O-Ring		2-14 #1166	
12	Bushing		B04180563	
13	Nut		1 1/4 X 12	
14	Gear		B04180189	
15	Gear		B04180191	
16	Gear		B04180786	
17	Dowel Pin (F10087277-030)		1/2 X 1 1/4	
18	Sleeve		A04180185	
19	SHCS (F10087011-030)		3/8 - 16 X 3/4	
20	Bearing		25051	
21	Motor		15127	
22	Gear		A0418-0784	
23	Gear		B04180191	
24	Retaining Ring		01337	
26	Bearing		00336	
27	SHCS (F10087007-040)		1/4 - 20 X 3/4	
28	Washer (F10087185-050)		1/4	
29	Plate		A04180209	
30	Housing Cover		D04180454	
31	Gear (Center Gear A04180188)		A04180186	
32	Bearing		25051	
33	Retaining Ring		04739	
34	Thrust Washer		A10000360	
35	SHCS		Use Key No.	
36	BHCS (F10087060-020)		1/4 - 20 X 1/2	
37	Retainer		B04180562	
38	SHCS (F10087006-050)		10 - 32 X 3/4	
39	Gear		B04180191	
40	Valve		A10080408	
41	Valve		A10022779	
42	Sub Plate		D04180021	
43	Pin		A04180558	
44	Plunger		A04180557	

Plate 4 Camshaft - Register Control Continued



List 4 Camshaft - Register Control Cont.

Key No.	Description	Part No. 4180	Part No 418HE	Part No 4180/418HE
45	Stop Nut		11817	
46	Cam - Shuttle		C04180008	
47	Bearing		00336	
48	Roll Pin (F10087265-120)		1/4 X 2	
49	Retaining Ring		01279	
50	Cam - Head		B04180616	
51	Roll Pin (F10087262-050)		1/8 X 3/4	
52	Switch		02944	
53	S. Shoulder Screw (F10087173-010)			5/16 X 1/4
54	Bracket		B04180607	
55	SHCS		Use Key No.	
56	Bracket		A04180559	
57	SSS (F10087101-090)		1/4 - 20 X 1	
58	Slide		A04180560	
59	Gear		B04180409	
60	Pin (F10087262-050)		1/8 X 3/4	
61	Bearing		00270	
62	Shaft		A04180413	
63	Bushing (Screw)		B04180563	
64	Cam		C04180418	

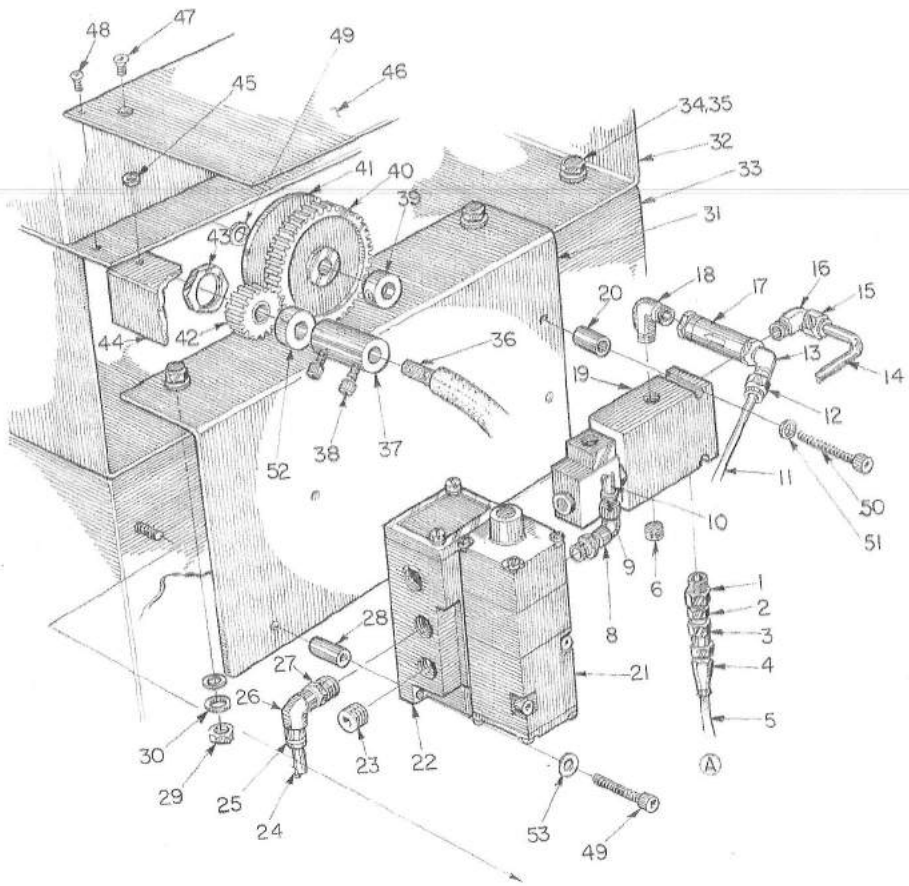


Plate 5 Control Side - Rear

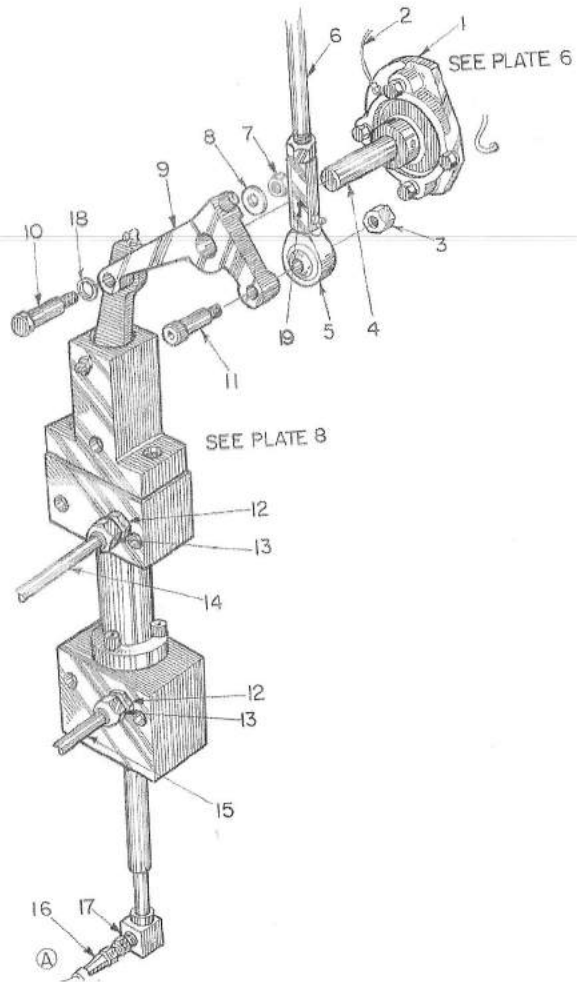


Plate 5A Head Lift Assembly R.S.

List 5 Control Side - Rear

Key No.	Description	Part No. 4180	Part No 418HE	Part No 4180/418HE
1	Fitting, Reducer			1/4 to 1/8
2	Fitting			34905
3	Fitting			34905
4	Fitting			34905
5	Hose			A10026174
6	Plug Pipe			1/4
7	Part of #8			
8	Elbow			1/4 to 1/4
9	Part of #8			
10	Poly-Flo			3/8" (4097)
11	Hydraulic Line 5/16 Dia.	C10119711		
12	Part of #13			
13	Elbow (4180) Fitting (418HE)	30463		
14	Hydraulic Line 5/16 Dia.	C10119712		
15	Part of # 16			
16	Fitting			30463
17	Valve Republic			02373
18	Fit. MP1/4NPTM EL 90 STL			31416
19	Valve			36772
20	Split Pin (F10087269-010)			1/2 X 1
21	Valve			30923
22	Valve Base			30924
23	Plug			1/4
24	Tubing (1/4" Poly Flow)			1/4 (5008)
25	Part of 26			
26	Elbow			1/4 to 1/4
27	Part of 26			
28	Split Pin (F10087267-020)			3/8 X 1
29	Nut (Hex Hd 1/4 - 20 X 1)			1/4 - 20
30	L Washer (Flat wash. 1/4) (F10087187-010)			1/4
31	Plate			C10112384
32	Brace			D10110465
33	Cabinet			D10110464
34	Washer			1/4
35	Hex Screw (Nut 1/4 - 20)			1/4 - 20 X 5/8
36	Cable (w/ seal title)			B04180420-033
37	Connector			A04180419
38	SHCS (F10087007-020)			1/4 - 20 X 1/2
39	Collar			F10087179-040
40	Gear (also used with #37)			03921
41	Dial			B04180720
42	Pinion Gear			A04180423
43	Nut			A04180794

Plate 5A Head Lift Assembly R.S. Continued

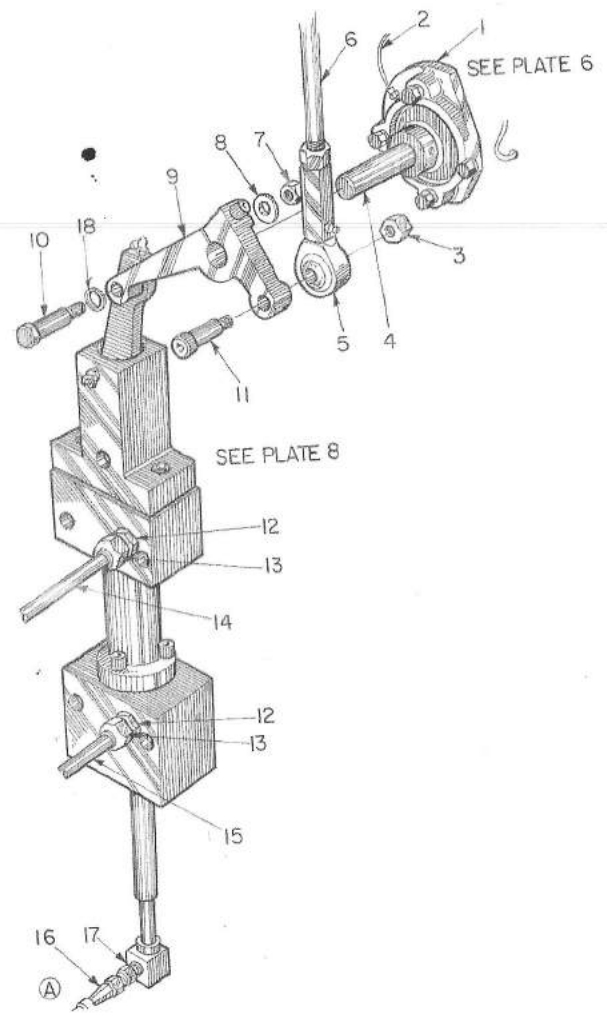
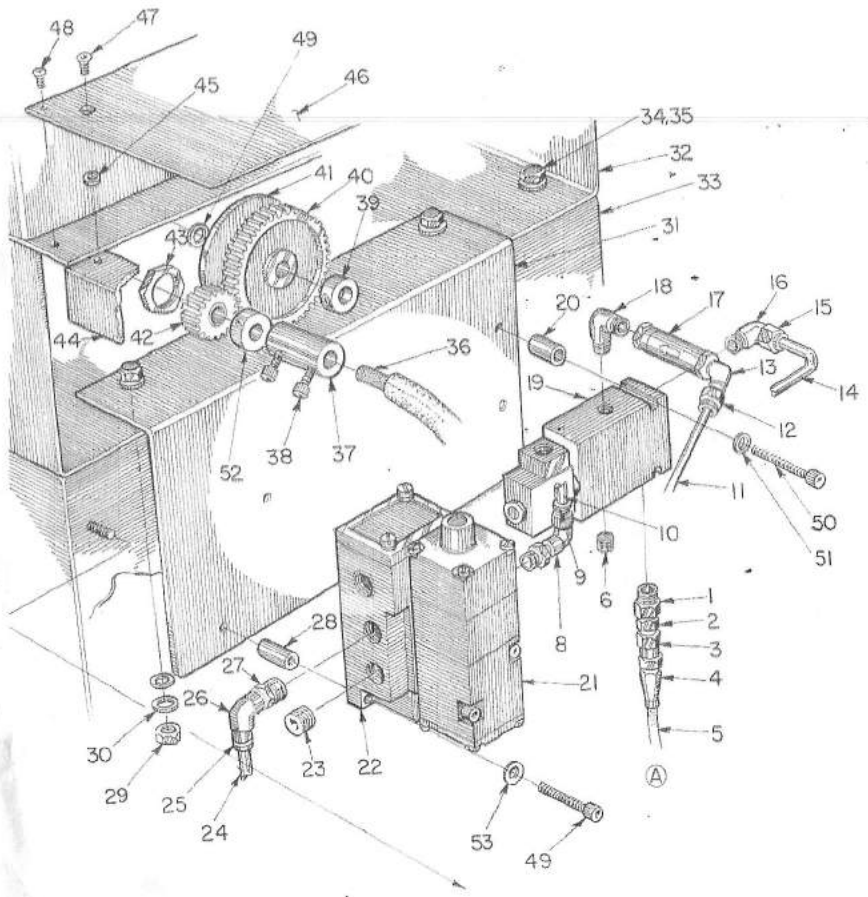


Plate 5 Control Side - Rear Continued



List 5 Control Side - Rear

Key No. Description

* Give key number

Part No.
4180

Part No
418HE

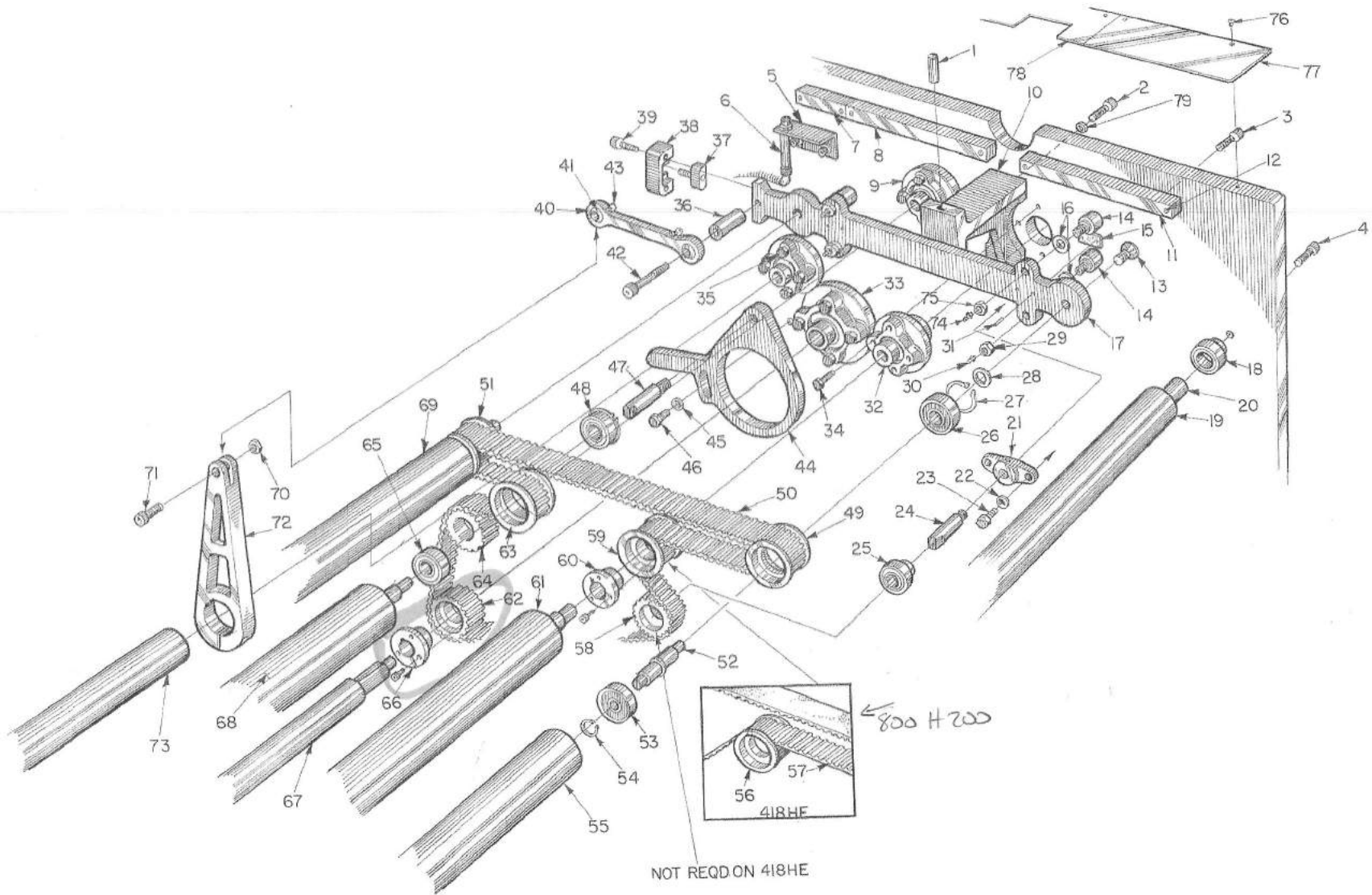
Part No
4180/418HE

Key No.	Description	Part No. 4180	Part No 418HE	Part No 4180/418HE
45	Washer			B00050001-013
46	Cover			E10110470
47	Flat Hd. Screw (F10087040-040)			1/4 - 20 X 3/4
48	But. Hd. Screw(F10087060-030)			1/4 - 20 X 5/8
49	SHCS (F10087006-100)			10 - 32 X 1 3/4
50	Hex Hd. (F10087074-150)			1/4 - 20 X 2 3/4
51	Lock Washer (F10087187-010)			1/4
52	Collar			#10
53	Lock Washer (F10087187-009)			#10

List 5A Head Lift Assembly R.S.

Key No.	Description	Part No.	Part No	Part No
1	Bearing			A04180268
2	Tubing*			19391
3	Elastic Stop Nut			08974
4	Shaft *			A04180157
5	Bearing		36672	
6	Rod		B10108207	
7	Hex Nut (Elastic)			08972
8	Washer (F10087185-070)			3/8
9	Pivot Arm		C10108202	
10	Shoulder Bolt (F10087175-080)			1/2 X 1 1/2
11	Shoulder Bolt (F10087290-090)			5/8 X 1 1/2
12	Fitting			37523
13	Fitting			37530
14	Tubing	C10120469		
15	Tubing	C10120468		
16	Fitting			A10026174
17	Fitting (Part of #16)			
18	Washer			B00050001-187
19	Pin Roll 1/8 X 7/8			

Plate 6 Shuttle Assembly



List 6 Shuttle Assembly

Key No. Description

*Give machine width

Part No.
4180

Part No
418HE

Part No
4180/418HE

Key No.	Description	Part No. 4180	Part No 418HE	Part No 4180/418HE
1	Dowel Pin (F10087277-070)			1/2 X 2 1/2
2	SHCS (F10087011-080)			3/18 - 16 X 1 3/4
3	SHCS (F10087009-060)			5/16 - 18 X 1"
4	SHCS (F10087011-060)			3/8 - 16 X 1 1/4
5	Bracket	B10116585		B10116585
6	Sensor	35315		
7	Guide - Way			A04180271
8	Shuttle - Way			A04180076
9	Bearing			A04180362
10	Platen Bracket R.S.			B04180053
11	Shuttle - Way			A04180076
12	Roll Pin (F10087265-050)			1/4 X 1
13	Flat Head Screw			A10021493
14	Cam Roller			06352
15	Wear Pad - L.S. #2 - R.S. # 1			A04180004
16	Spacer			A04000014
17	Shuttle Frame R.S. Shuttle Frame L.S.			C10082739 C10082740
18	Bearing			00267
19	Idler*			B10000095
20	Girt Shaft*			B04180168
21	Support	13551		13551
22	L. Washer (F10087187-030)			3/8
23	Hex Hd. Screw (F10087076-060)			3/8 - 16 X 1 1/4
24	Shaft			A04180089
25	Bearing			00242
26	Bearing			00519
27	Retaining Ring			06507
28	Spacer			A04180003
29	Hex Nut (F10087194-060)			7/16 - 20
30	Grease Fitting			01493
31	Roll Pin (F10087262-040)			1/8 X 5/8
32	Bearing			00292
33	Bearing			A10000406
34	Hex Hd. Screw (F10087075-080)			5/16 - 18 X 1 1/2
35	Hex Hd. Screw (F10087075-080)			5/16 - 18 X 1 1/2
36	Spacer			B006-001-6
37	Coupling			A04180130
38	Coupling			A04180131
39	SHCS (F10087007-070)			1/4 - 20 X 1 1/4
40	Link			A04000053
41	Bearing			00354
42	SHCS (F10087013-110)			7/16 - 14 X 2 1/2
43	Grease Fitting			29356

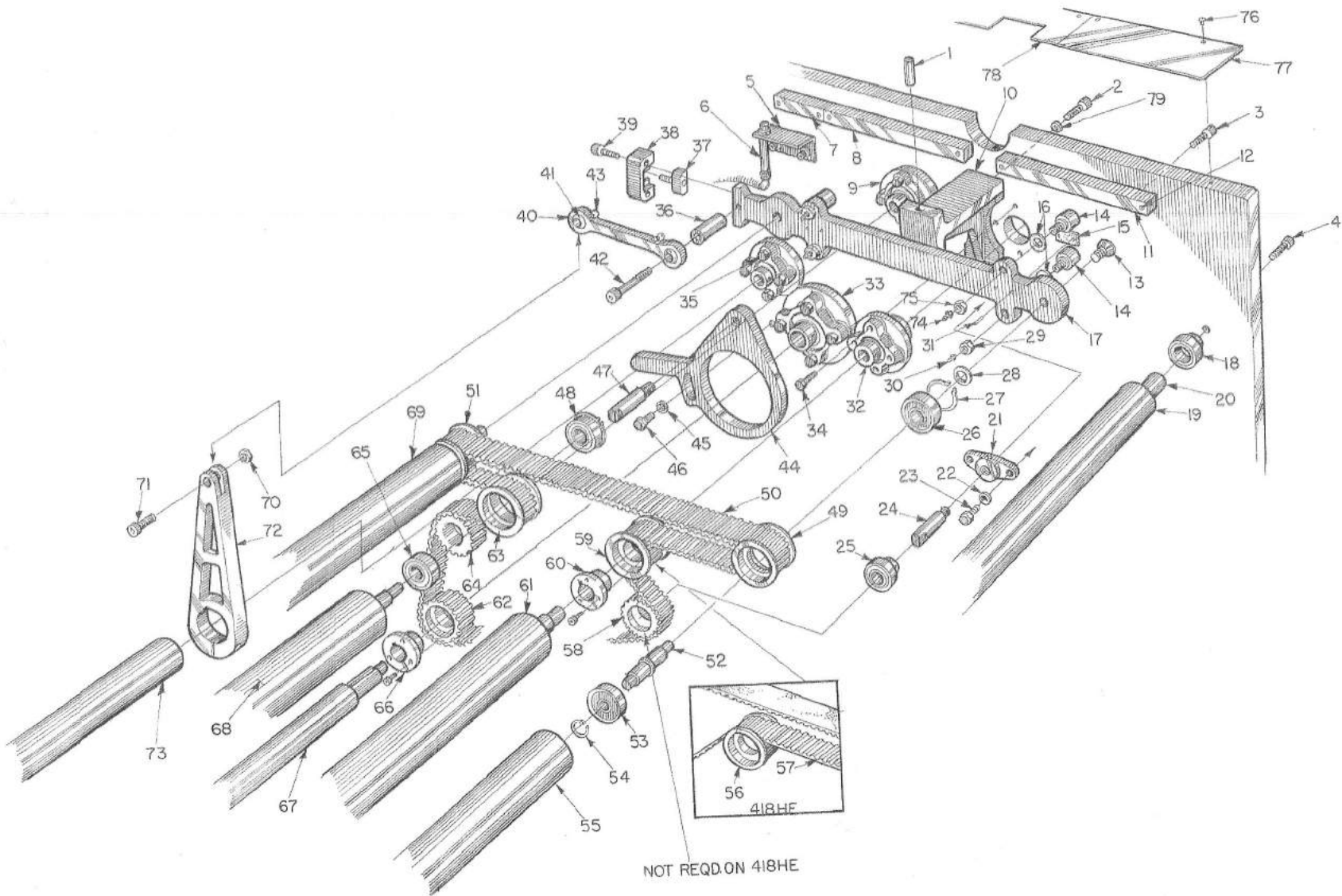


Plate 6 Shuttle Assembly Continued

List 6 Shuttle Assembly cont.

Key No.	Description	Part No. 4180	Part No 418HE	Part No 4180/418HE
	*Give machine width			
44	Bracket			B04180087
45	Washer			B005001-2
46	Hex Hd. Screw (F10087076-070)			3/8 - 16 X 1 1/2
47	Shaft			A04180089
48	Bearing			00242
49	Pulley			A04180005
50	Belt			01114
51	Pulley		A04180005	
52	Stub Shaft		B04180002	
53	Bearing		04144	
54	Retaining Ring		01276	
55	Roll*		D041800001	
56	Pulley		A04180061	
57	Belt		01114	
58	Sprocket Shuttle Idler			B10001338
59	Pulley Timing	25183		
60	Bushing Taper Lock	37761		
61	Chrome Roll*	C10111518	C04180025	
62	Pulley	06100		
63	Sprocket	B10001338		
64	Sprocket			B10001338
65	Bearing			
66	Bushing		00570	00242
67	Drive Shaft*		A04180156	
68	Chrome Roll*	C10111518	C04180025	
69	Shuttle Roll*		D041800001	
70	Hex Nut (F10087192-080)		3/8 - 16	
71	SHCS (F10087011-070)		3/8 - 16 X 1 1/2	
72	Pivot Arm		B04180055	
73	Shaft Shuttle		A04180155	
74	Grease Fitting		01493	
75	Hex Nut (F10087194-060)		7/16 - 20	
76	But. Hd. Screw (F10087060-020)			1/4 - 20 X 1/2
77	Guard - Front			B04180312
78	Guard - Center			B04180311
	Guard - Rear			B04180310
	Guard - L.S.			B04180175
79	Washer			B00050001-001

*2012 Bushing, 1 3/16" bore
26 Tooth, H(.5) pitch, 2" wide
timing belt*

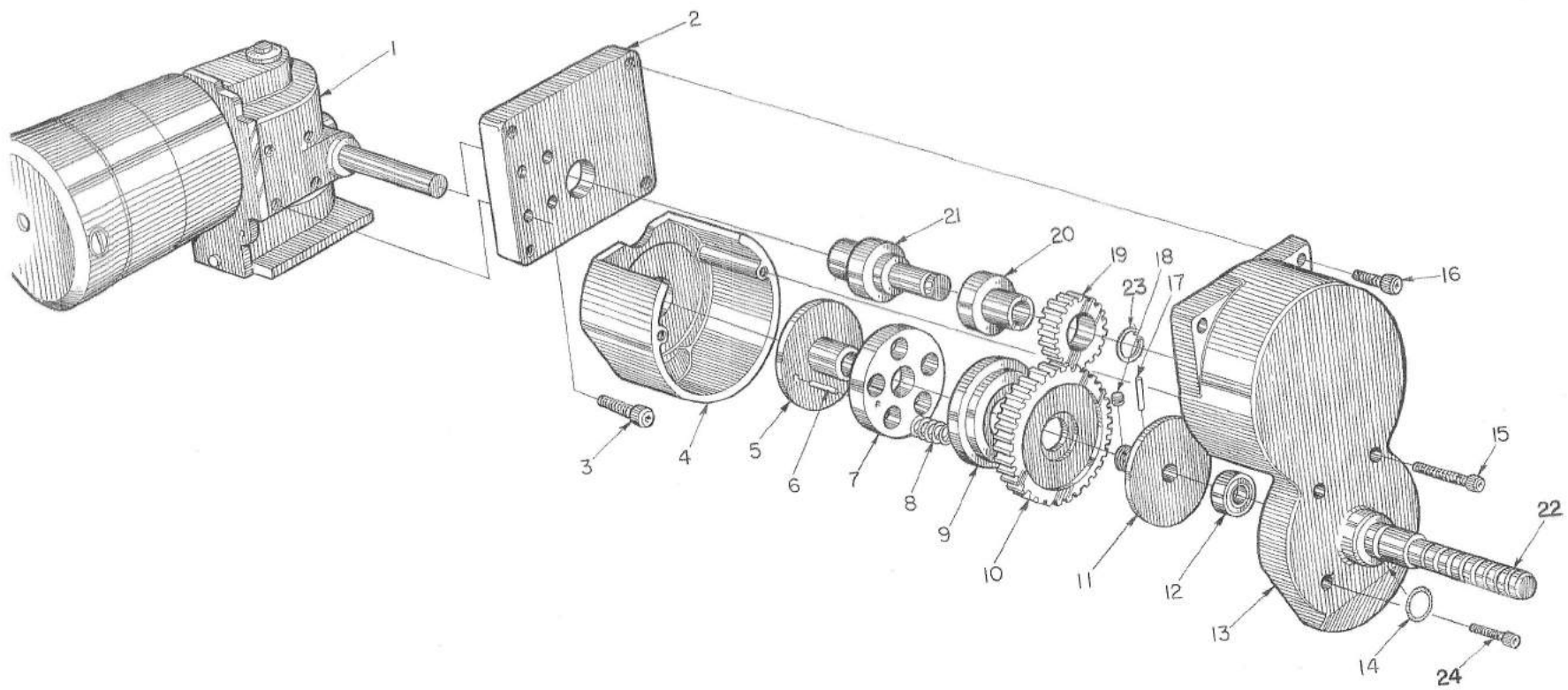


Plate 7 Variator Auto Speed Control

List 7 Variator Auto Speed Control

Key No. Description	Part No. 4180	Part No 418HE	Part No 4180/418HE
1 Motor/Gear Box			15127
2 Plate			B10034653
3 SHCS (F10087006-030)			10-32 X 1/2
4 Cover			B04180708
5 Sleeve			A04180712
6 Roll Pin (F10087262-060)			1/8 X 1
7 Retainer			A04180717
8 Spring			04588
9 Pressure Plate			A04180716
10 Gear			A04180713
11 Extension Shaft			B04180711
12 Seal			01356
13 Housing			C04180707
14 "O" Ring			01169
15 SHCS (F10087006-050)			10 - 32 X 3/4
16 SHCS (F10087006-050)			10 - 32 X 3/4
17 Tapered Pin			No. 1 X 3/4
18 S.S.S. (F10087101-020)			1/4 - 20 X 1/4
19 Pinion			A10034652
20 Bushing			A10034651
21 Sleeve (Set Screw Inc.)			A10034650
22 Shaft			10508

List 8 Head Lift Cylin

No. Description	Part No. 4180	Part No 418HE	Part No 4180/418HE
1 SHCS (F10087007-020)			1/4 - 20 X 1/2
2 Connector w/ O-Ring #1165			A04180088
3 Spacer			A10000133
4 Cartridge			2097
5 SHCS (F10087011-120)			3/8 - 18 X 2 1/4
6 Block	D10120284	C04180033-3	
7 Cover	A04180035	B10120291	
8 SHCS (F10087007-040)			1/4 - 20 X 3/4
9 O-Ring			1187
10 Spring			04558
11 Poppet			A10041833
12 Key			A04180129
13 Roll Pin (F10087265-010)			1/4 X 1/2
14 O-Ring		1187	
15 O-Ring		1182	
16 Block		C04180033-3	
17 Piston			B10059024
18 Seal			02338
19 SHCS (F10087007-040)			1/4 - 20 X 3/4
20 O-Ring			1184
21 Tube			B04180034-1
22 SHCS (F10087007-040)			1/4 - 20 X 3/4
23 Block	D10120285	C04180033-4	
24 O-Ring			1189
25 Slide	B10120289	A04180198	
26 Bearing			0355
27 Clevis	B10120290	A04180197	
28 Dowel Pin (F10087277-020)	1/2 X 1	3/8 X 1	
29 Bearing	0355	0353	
30 Link	C10120286	B04180196	
31 Grease Fitting			01476
32 Guard	C10120288		
33 Grease Fitting	01476		
34 SHCS (F10087007-060)	1/4 - 20 X 1		
35 Guard		B04180199	

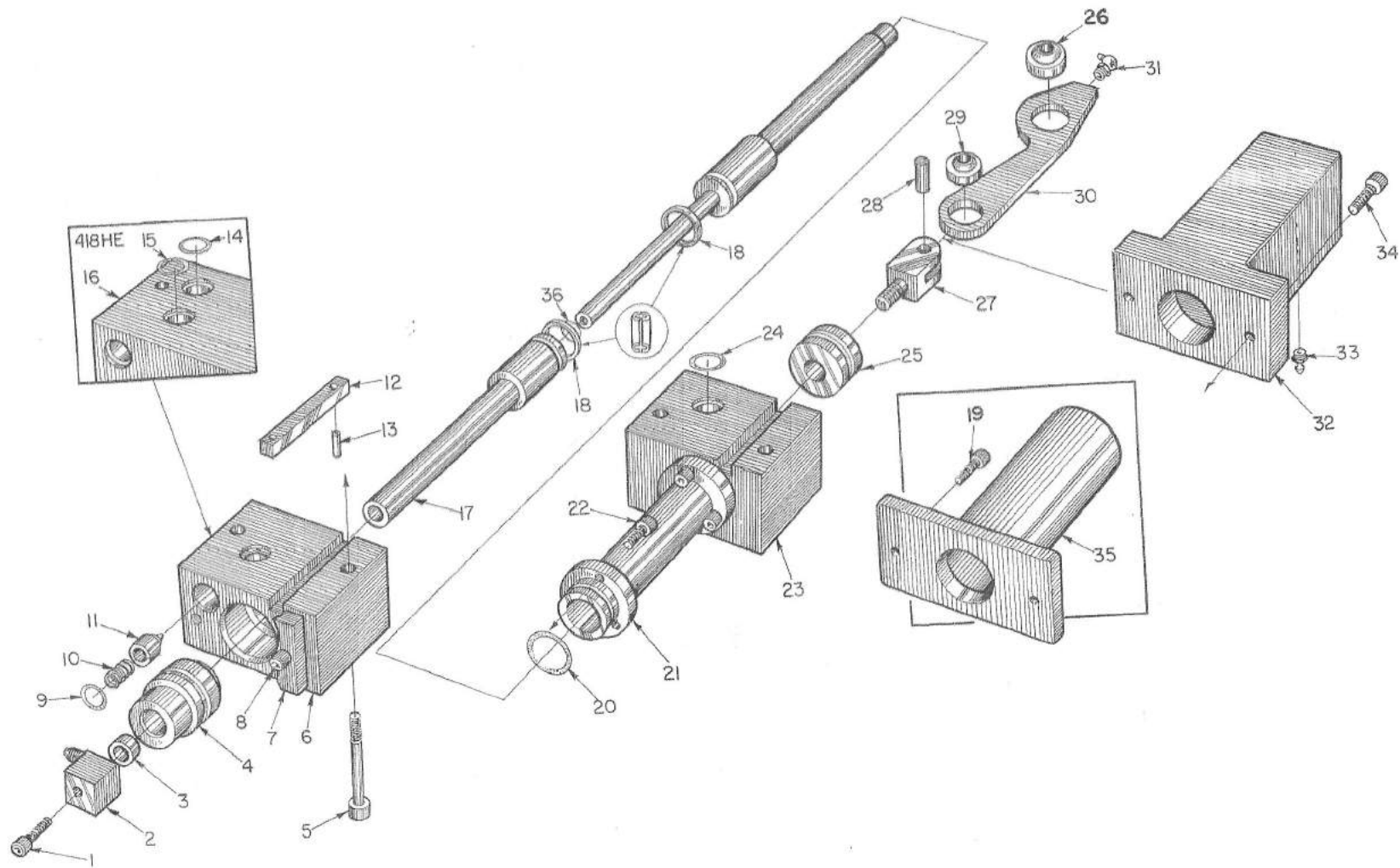
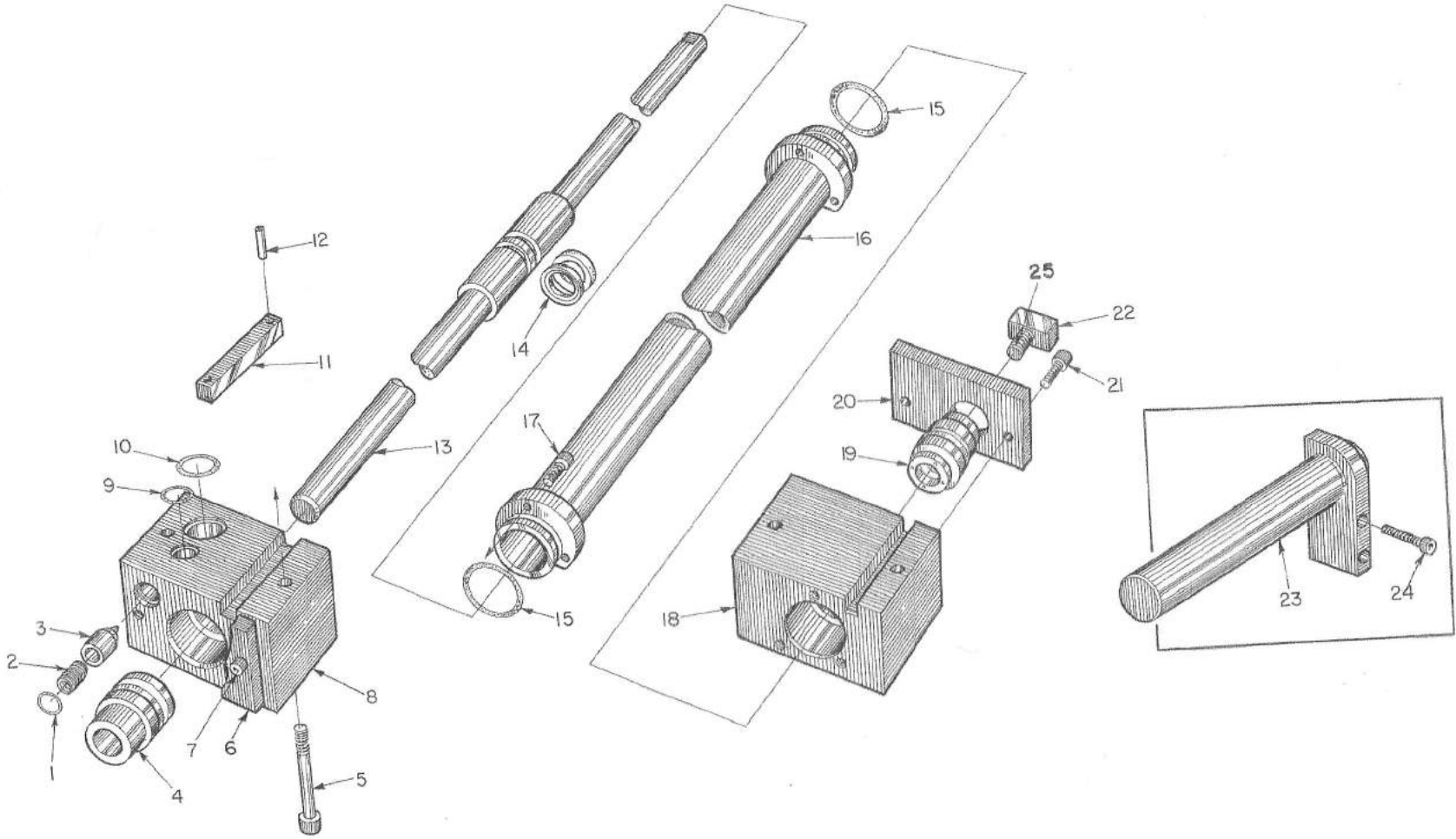


Plate 8 Head Lift Cylinder

Plate 9 Shuttle Cylinder



List 9 Shuttle Cylinder

Key No. Description

Part No.
4180

Part No
418HE

Part No
4180/418HE

1

O-Ring

1187
04558
A10041833

Q2097

3/8 - 16 X 2 1/4

1180-20 X 3/4

1180-20 X 3/4

List 10 Nip Roll Assembly

Key No.	Description	Part No. 4180	Part No 418HE	Part No 4180/418HE
1	Rubber Roll			C10002960
2	Rubber Roll			C10002960
3	Bearing			03922
4	Bushing			A04180062
5	Spherical Bearing			00356
6	Shld. Bolt (F10087290-070)			5/8 X 1
7	SHCS (F10087011-030)			3/8 - 16 X 3/4
8	SHCS (F10087011-030)			3/8 - 16 X 3/4
9	Mounting Bracket			B10102589
10	Hex Nut			1 3/8 X 12
11	Spacer			A04180125
12	Rod End			B10102588
13	Nip Roll Arm			A04180147
14	Connecting Pin			A04180096-001
15	Connecting Pin			A04180096-002
16	Air Cylinder			33526
17	Elbow			3/8P / 3/8T
18	Fitting (part of #17)			
19	Tubing			3/8
20	T-Fitting			1/4M X 3/8 X 3/8T
21	Fitting (part of 20)			
22	Link			B04180385
23	Eccentric Shaft			A04180386
24	Dowel Pin (F10087277-040)			1/2 X 1 1/2
25	Shld Bolt (F10087175-040)			1/2 X 3/4
26	SHCS (F10087011-060)			3/8 - 16 X 1 1/4
27	Shld Bolt (F10087174-020)			3/8 X 3/8

Plate 10 Nip Roll Assembly

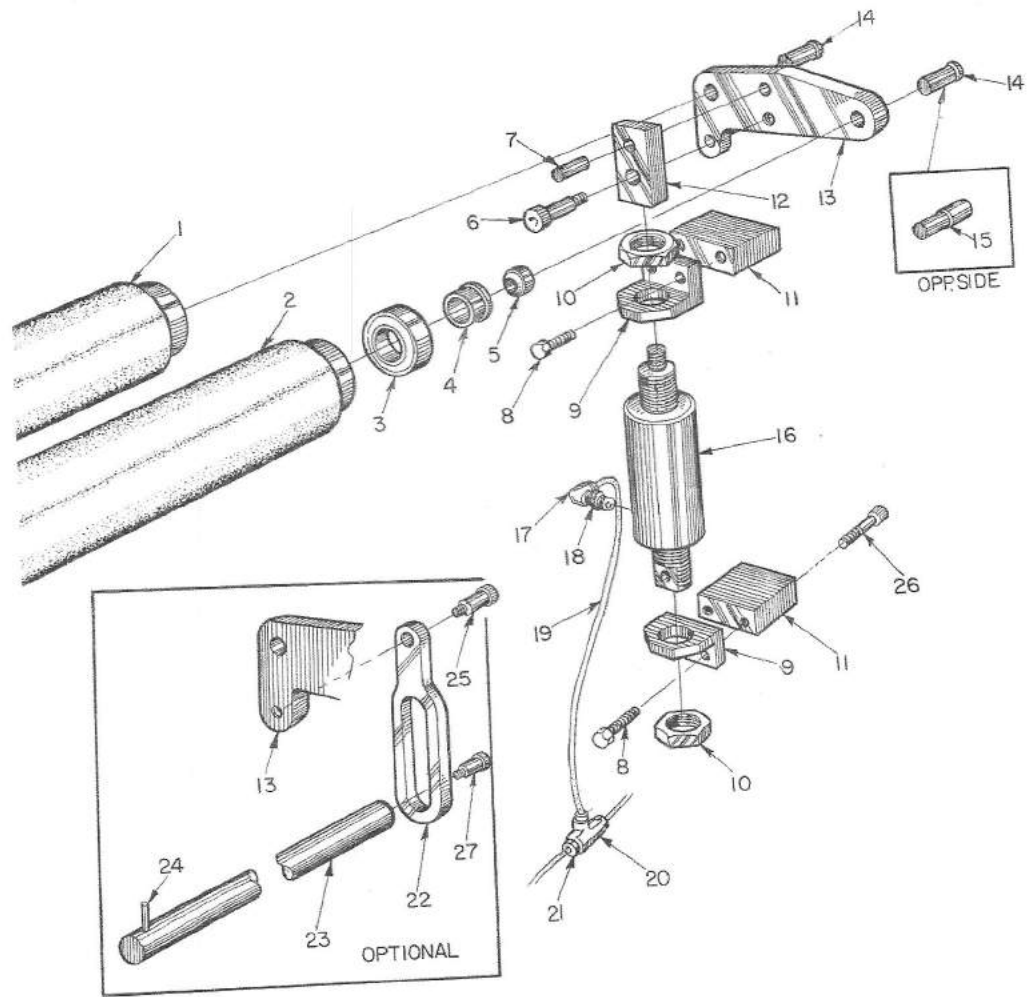
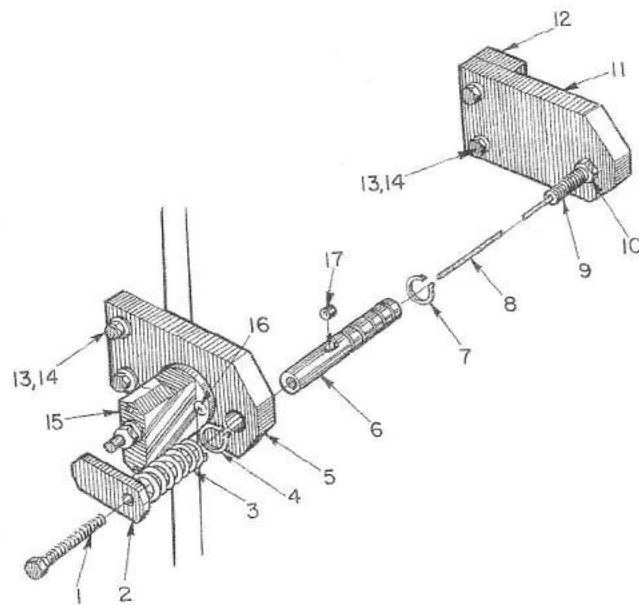


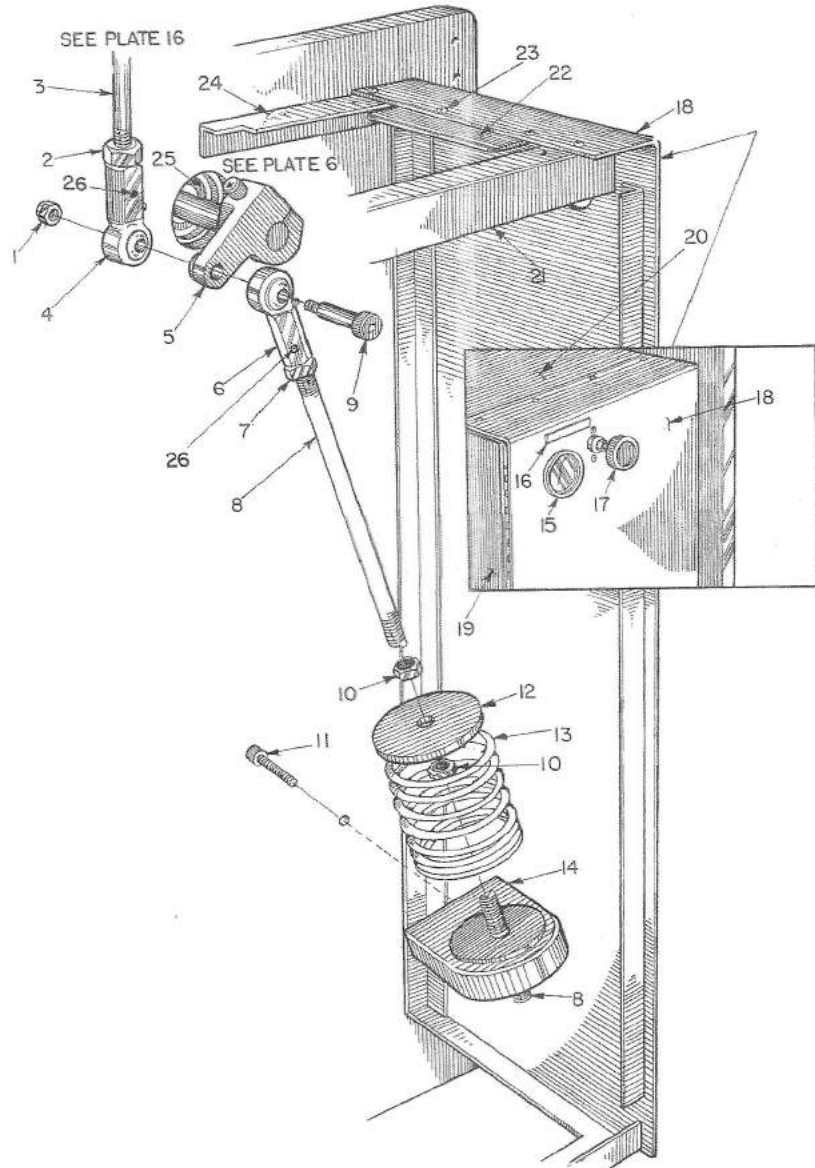
Plate 10A Safety Switch Assembly



List 10A Safety Switch Assembly

Key No.	Description	Part No. 4180	Part No 418HE	Part No 4180/418HE
1	SHCS (F10087011-050)			3/8 - 16 X 1
2	Pad			A00002224
3	Spring			11967
4	Retaining Ring			00225
5	Bracket			A10012675
7	Retaining Ring			00225
8	Wire Rope			08221
9	Cable Adjusting Screw			A10052027
10	Hex Nut (F10087192-100)			1/2 - 13
11	Bracket			A10012675
12	Spacer			A10124930
13	Hex H.C.S. (F10087076-080)			3/8 - 16 X 1 3/4
14	Washer (F10087185-070)			3/8
15	Switch			02945
16	SHCS (F10087006-060)			10 - 32 X 7/8
17	Sleeve			08002

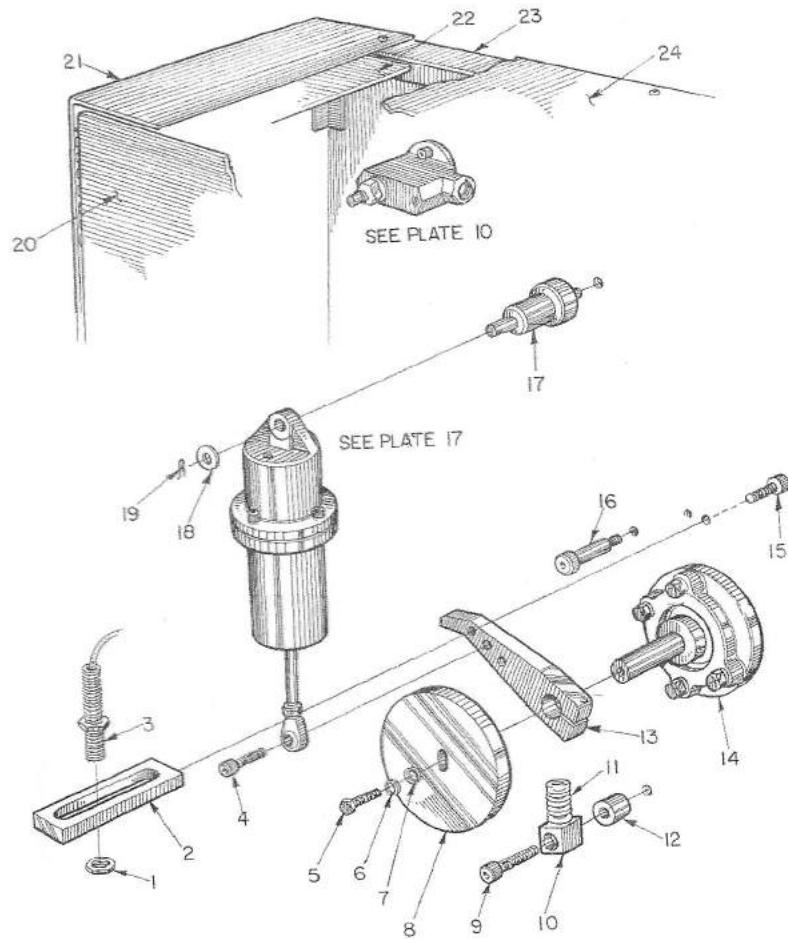
Plate 11 Head Lift Assembly



List 11 Head Lift Assembly

Key No.	Description	Part No. 4180	Part No 418HE	Part No 4180/418HE
1	Hex El. Stop Nut			09845
2	Hex Nut (F10087194-080)			5/8 - 18
3	Rod			B10108207
4	Rod End			36672
5	Pivot Arm L.H.			C10110893
6	Rod End			36672
7	Hex Jam Nut (F10087195-060)			5/8 - 18
8	Rod			B10108199
9	Shoulder Bolt (F10087290-050)			5/8 X 2 1/4
10	Hex Nut (F10087194-080)			5/8 - 18
11	SHCS (F10087011-060)			3/8 - 16 X 1 1/4
12	Cap			B10108200
13	Spring - as per mach.			B04180360
14	Head Spring Bracket			B10108201
15	Gauge			02255
16	Plate - Input Tension			A04180229
17	Regulator			2313
18	Front Enclosure			C10117489
19	Front Door - Top			C10064225-3
20	Top Cover			D04180116
21	Brace - Top (Bottom B04180123-002)			B04180121-002
22	Plate			A04180137
23	BHSCS (Nut 1/4 - 20) (F10087060-030)			1/4 - 20 X 5/8
24	Brace			A04180136-2
25	Bearing			A04180362
26	Pin Roll	1/8 X 7/8		

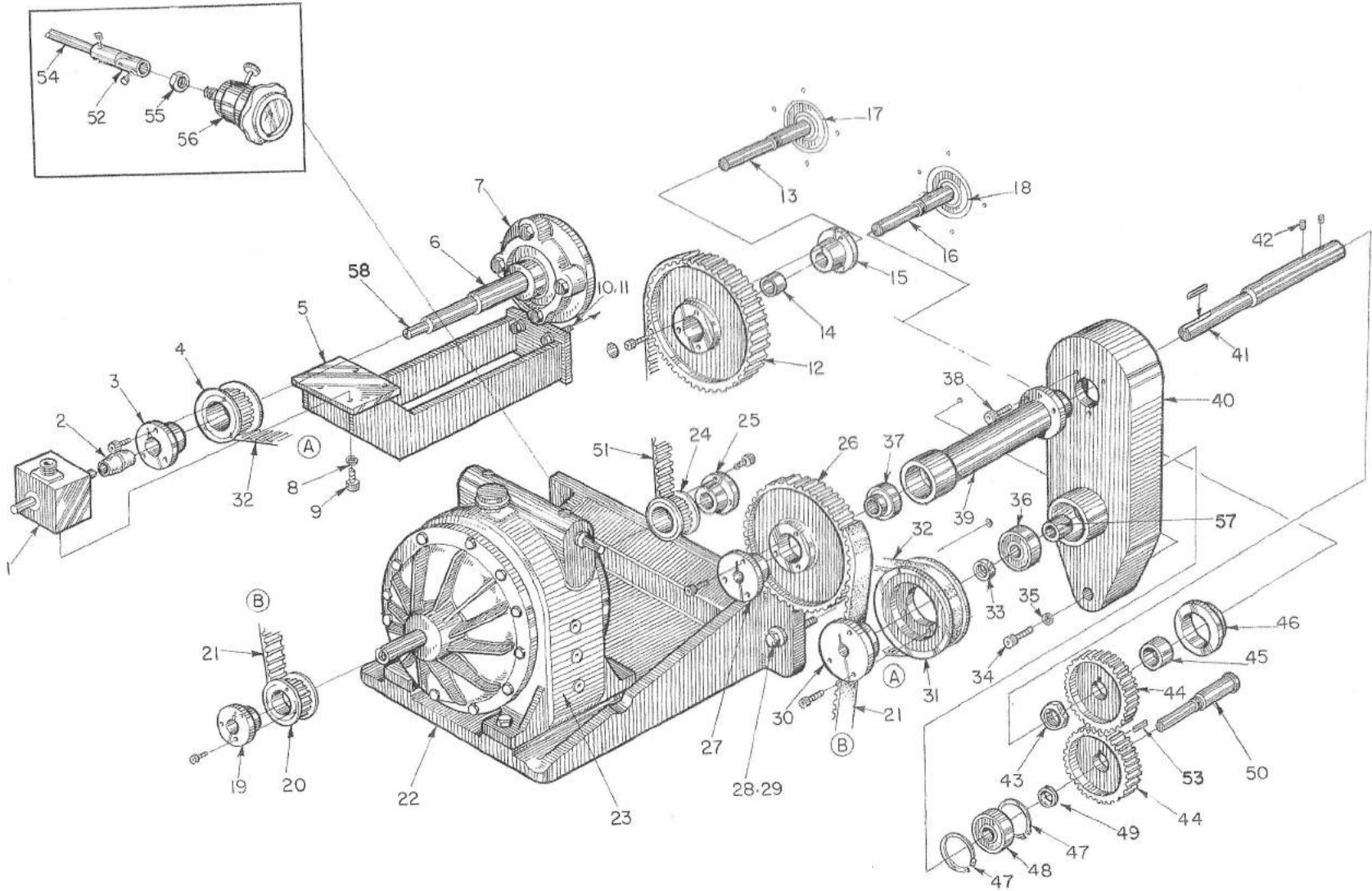
Plate 11A Bellofram Assembly



List 11A Bellofram Assembly

Key No.	Description	Part No. 4180	Part No 418HE	Part No 4180/418HE
1	Part of #3			
2	Mount Sensor Adj.			A10101055
3	Sensor Proximity Induct			27721
4	SHCS (F10087011-050)			3/8 - 16 X 1
5	Hex Hd. Bolt (F10087076-080)			3/8 - 16 X 1 3/4
6	Washer Lock (F10087187-030)			3/8
7	Washer (F10087185-070)			3/8
8	Cam			B10092637
9	SHCS (F10087015-120)			1/2 - 13 X 2 3/4
10	Bracket			A01000171
11	Spring			4539
12	Spacer			B00060001-005
13	Dancer Arm			B01000058
14	Bearing			00293
15	SHCS (F10087007-060)			1/4 - 20 X 1
16	Shoulder Bolt (F10087290-070)			5/8 X 2
17	Stand Off			B01000169-1
18	Washer Flat (F10087185-090)			1/2
19	Cotter Pin (F10087181-050)			3/32 X 1
20	Rear Door			3100 64225-4
21	Rear Enclosure			C10064222
22	Bractlet			A-4180137
23	Brace			B04180135-1
24	Top Cover			D04180116

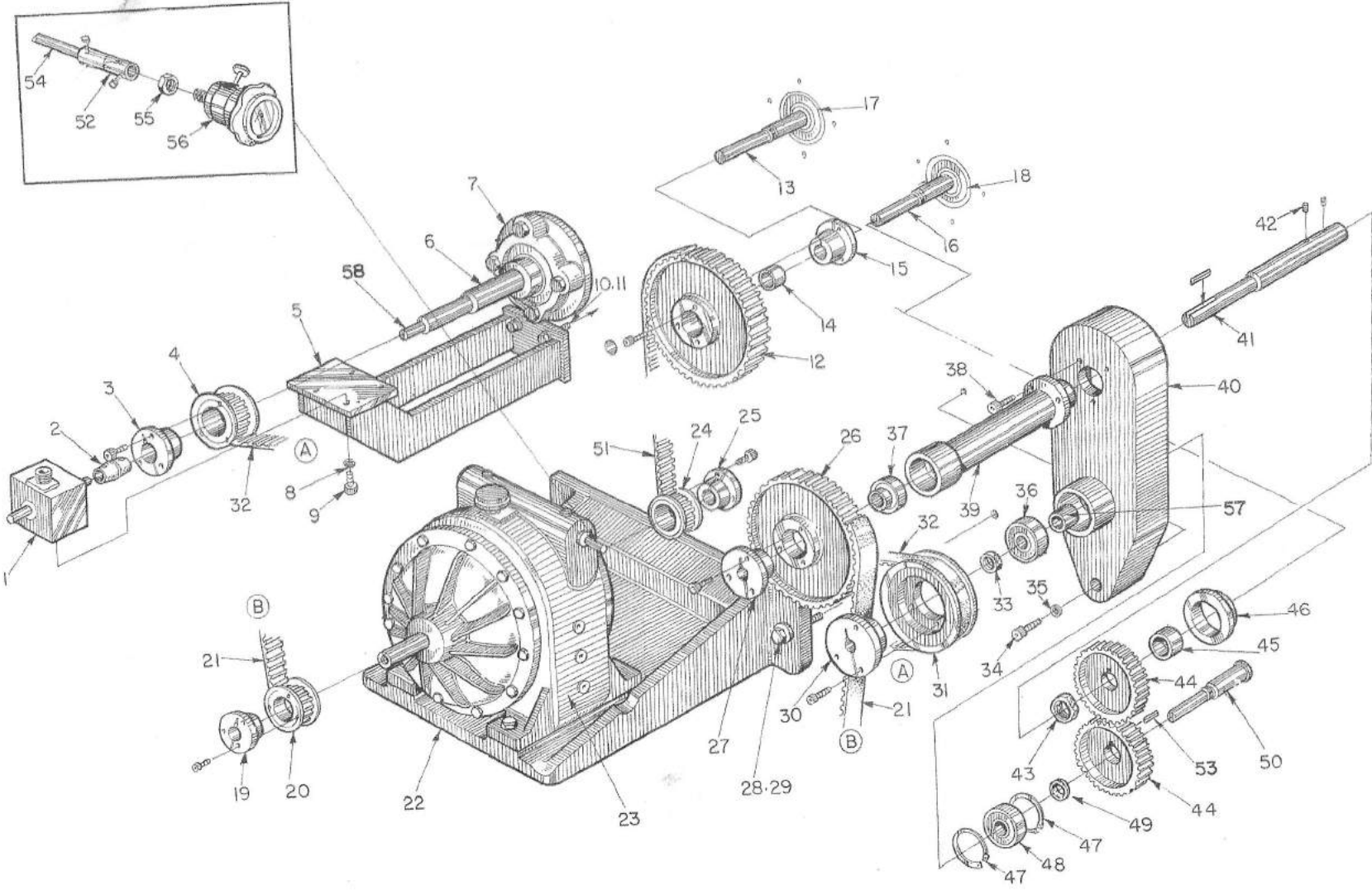
Plate 12 Drive Assembly LS - Nip Reversing Transmission



List 12 Drive Assy. LS - Nip Reversing Transmission

Key No.	Description	Part No. 4180	Part No 418HE	Part No 4180/418HE
1	Encoder			
2	Coupling		36474	
3	Bushing		36824	
4	Pulley		25279	
5	Bracket		33601	
6	Shaft		D10108119	
7	Bearing		A04180156	
8	Washer (F10087185-010)		00293	
9	SHCS (F10087002-030)		#6	
10	SHCS (F10087007-060)		6 - 32 X 1/2	
11	Washer (F10087185-050)		1/4 - 20 X 1	
12	Pulley		1/4	
13	Shaft* (Chrome Roll)		00960	
14	Bushing		C04180025	
15	Bushing		A04180443	
16	Shaft* (Chrome Roll)		00522	
17	Bearing		C04180025	
18	Bearing		A04180362	
19	Bushing		A04180362	
20	Pulley		00503	
21	Timing Belt		00140	
22	Mounting Bracket		01086	
23	Variator		C04180167	
24	Pulley		14641	
25	Bushing		00140	
26	Pulley		00503	
27	Bushing		00960	
28	SHCS (F10087011-050)		00522	
29	Washer		3/8 - 16 X 1	
30	Bushing		B005-001-13	
31	Pulley		00568	
32	Timing Belt		00931	
33	Hex Nut		01074	
34	SHCS (F10087007-130)		A10088863	
35	Washer		1/4 - 20 X 2 3/4	
36	Bearing		B00050001-020	
37	Bearing		00090	
38	SHCS (F10087007-040)		00241	
39	Bearing		1/4 - 209 X 3/4	
40	Gearbox		B04180170	
41	Shaft		C04180012	
42	SSS (F10087101-040)		B04180171	
43	Hex Nut		1/4 - 20 X 3/8	
44	Gear		A10088863	
			A04180027	

Plate 12 Drive Assembly LS - Nip Reversing Transmission Cont.



List 12 Drive Assy. LS - Nip Reversing Transmission cont.

Key No.	Description	Part No. 4180	Part No 418HE	Part No 4180/418HE
45	Spacer Brg.		A04000140-1	
46	Pivot Bushing		A04180126	
47	Retaining Ring		01262	
48	Bearing		00090	
49	Spacer Brg.		A04000140-2	
50	Stub Shaft		A04180028	
51	Timing Belt		01086	
52	Universal Joint		A10000506	
53	Key		1/4 X 1/4 X 7/16	
54	Shaft		A10086089-004	
55	Jam Nut (F10087195-110)		1-14	
56	Variator Control		B04180132	
57	Spacer Brg.		A04000140-1	
58	Dowel Pin (F10087275-080)		3/8 X 2	

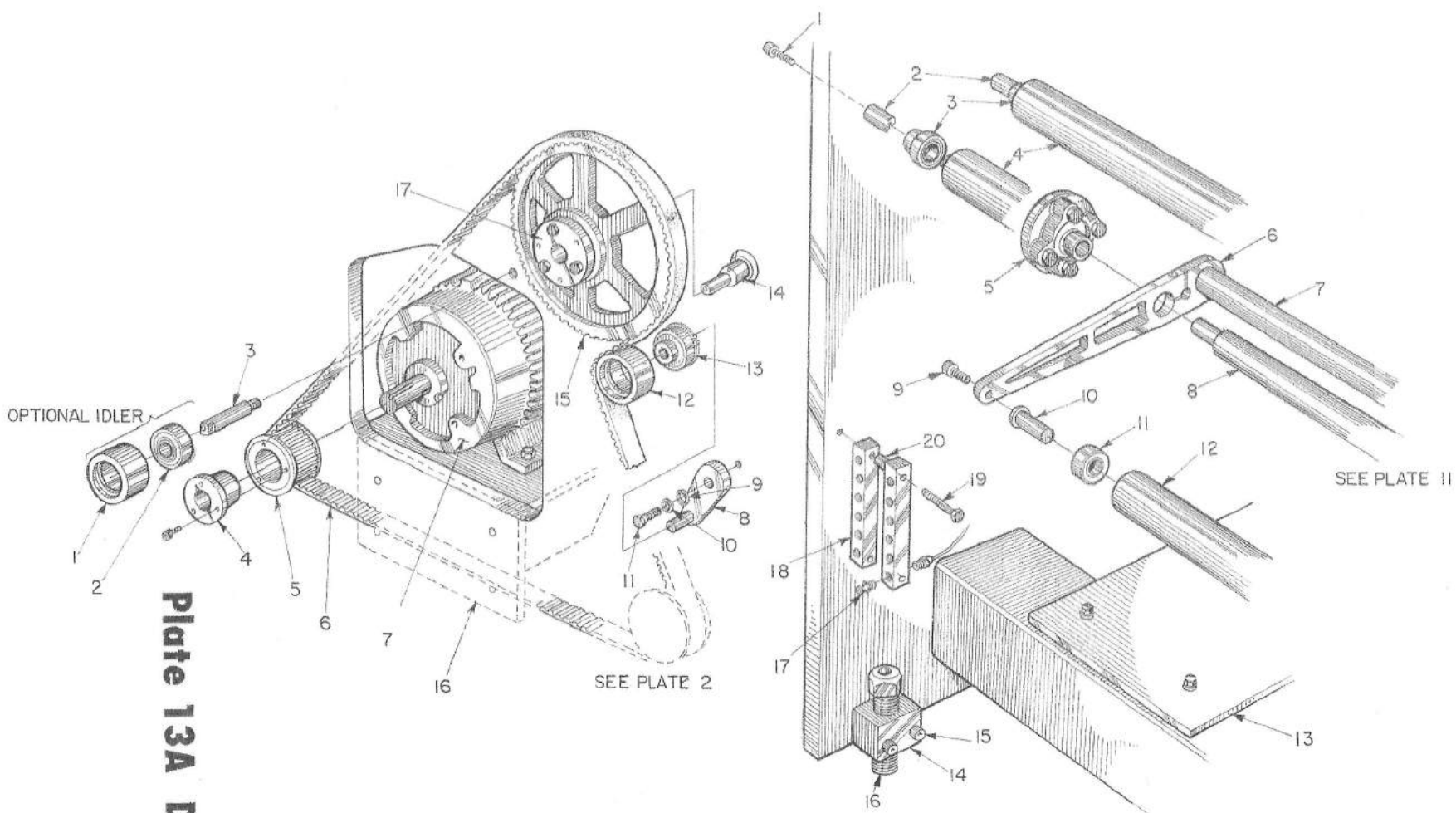


Plate 13A Drive Assemb

Plate 13 Dancer Assembly

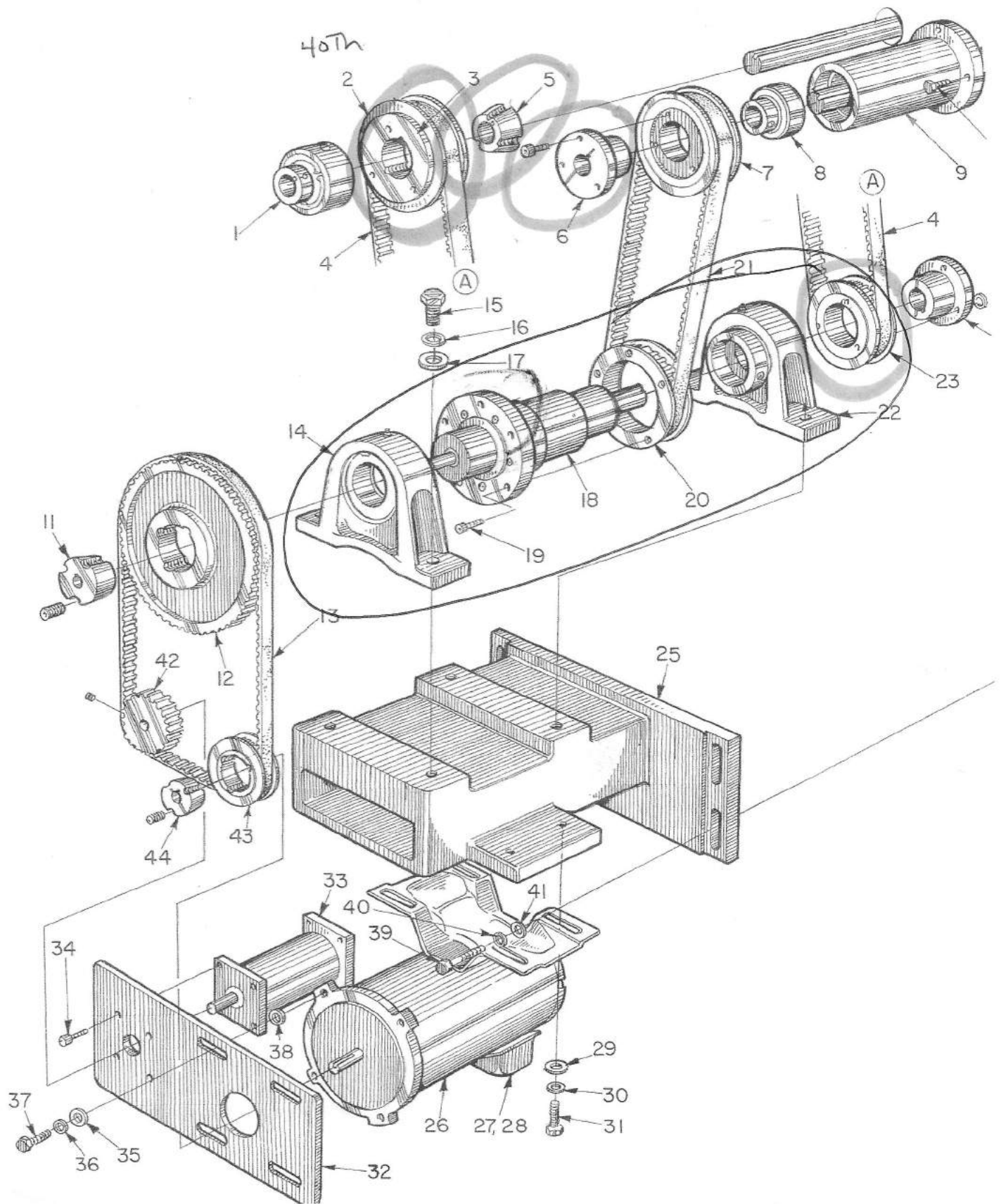
List 13 Dancer Assembly

Key No.	Description	Part No. 4180	Part No 418HE	Part No 4180/418HE
	Give machine width			
1	SHCS (F10087011-060)		3/8 - 16 X 1 1/4	
2	SHaft*		A10051799	
3	Bearing (Collar 1 1/2)		00267	
4	Idler Roll*		B10000095	
5	Bearing		00293	
6	Dancer Arm		B01000113	
7	"C" Weight*		A04180333	
8	Shaft*		B10036331	
9	SHCS (F10087011-070)		3/8 - 16 X 1 1/2	
10	Stub Shaft		A01000175	
11	Bearing		12429	
12	Idler Roll*		B10000095	
13	Mounting Plate		A10076525	
14	Leveling Block		B01000154	
15	SHCS (F10087015-100)		1/2 - 13 X 2 1/4	
16	Leveling Screw		A400120-001	
17	Grease Fitting		05739	
18	Manifold		29629	
19	Hex Hd. Screw		1/4 - 20 X 2 1/2	
	(double, F10087074-150)		(single 1 1/4 F10087074-070)	
20	Spacer		1/2	

List 13A Drive Assembly

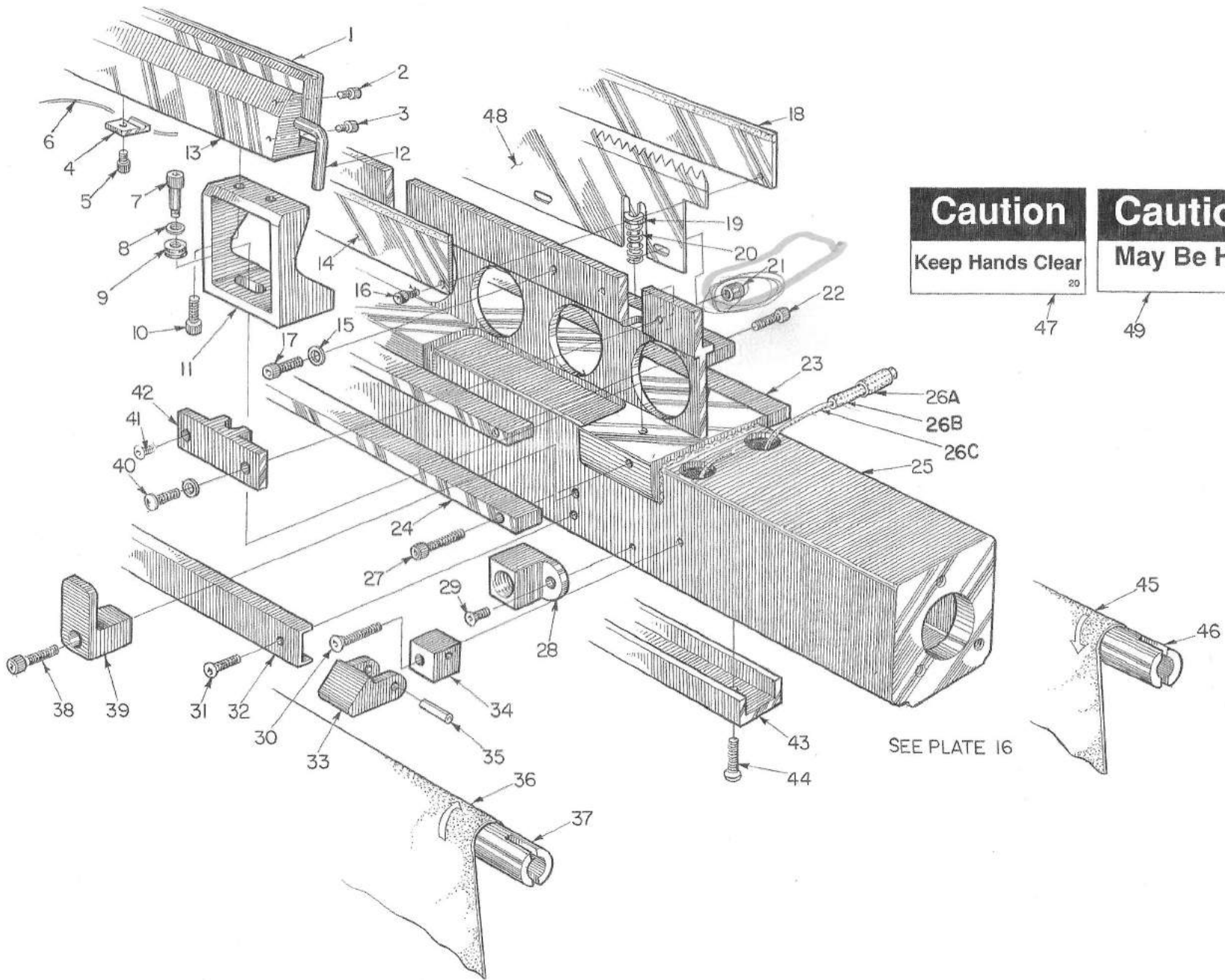
1	Idler (Belt 01110)		A10000109	
2	Bearing		02540	
3	Idler Shaft		13494	
4	Bushing		As per	
5	Pulley		As per	
6	Belt		As per	
7	Drive Motor		See motor	
8	Idler Bracket		B04000083-006	
9	Washer, Lock (F10087187-050)		1/2	
10	Washer, Flat (F10087185-090)		1/2	
11	Hex Hd. Scr. (F10087078-050)		1/2 - 13 X 1 1/4	
12	Idler		A10000109	
13	Bearing		00241	
14	Shaft*		A04180156	
15	Pulley		00972	
16	Mounting Bracket	C10116805		
17	Bushing (Key 00289)		A04180371	

Plate 14 Harmonic Drive



List 14 Harmonic Drive

Key No.	Description	Part No. 4180	Part No 418HE	Part No 4180/418HE
1	Torque Limiter \$140 USED.	37764	HELLAND Torg-Tender -	Zero Max
2	Pulley	36881		
3	Part of #2			
4	Belt	21606		
5	Bushing	25182	2012-13/4	
6	Bushing	00537		
7	Pulley	12443		
8	Bearing	0241		
9	Housing	C10111516		
10	Hex Hd. Scr. (Elas St. Nut 08973)	5/16-18X3 (F10087075-140)		
11	Bushing	37630		
12	Pulley	37631		
13	Belt	01085		
14	Bearing/Block	35298		
15	Hex Hd. Scr. (F10087075-095)	5/8 - 11 X 1 3/4		
16	Lock Washer (F10087187-060)	5/8		
17	Washer, Flat (F10087185-100)	5/8		
18	Drive Harmonic	37685		
19	SHCS (F10087006-040)	10 - 32 X 5/8		
20	Pulley	C10108981		
21	Belt	19567		
22	Bearing Block	35298		
23	Pulley	32922		
24	Bushing	00537		
25	Mounting Bracket	E10111335		
26	Motor - Ge. Tack	27330		
27	Part of #26			
28	Part of #26			
29	Flat Washer (F10087185-060)	5/16		
30	Lock Washer (F10087187-020)	5/16		
31	Hex Hd. Bolt (F10087075-040)	5/16 - 18 X 3/4		
32	Plate	C10117323		
33	Tack	37637		
34	SHCS (F10087004-010)	8-32 X 3/8		
35	Flat Washer (F10087185-070)	3/8		
36	Lock Washer - H Collar	3/8 (F10087188-030)		
37	Hex Hd. Scr. (F10087076-040)	3/8 - 16 X 7/8		
38	Washer	B005001-177		
39	Hex Hd. Scr. (F10087076-060)	3/8 - 16 X 1 1/4		
40	Lock Washer (F10087187-030)	3/8		
	Flat Washer (F10087185-070)	3/8		
42	Pulley	B10112666		
43	Pulley	36922		
44	Bushing	26066		



Caution
Keep Hands Clear
20

Caution
May Be Hot
31

Plate 15 Head Assembly

SEE PLATE 16

List 15 Head Assembly

Key No. Description

Part No.

Part No

Part No

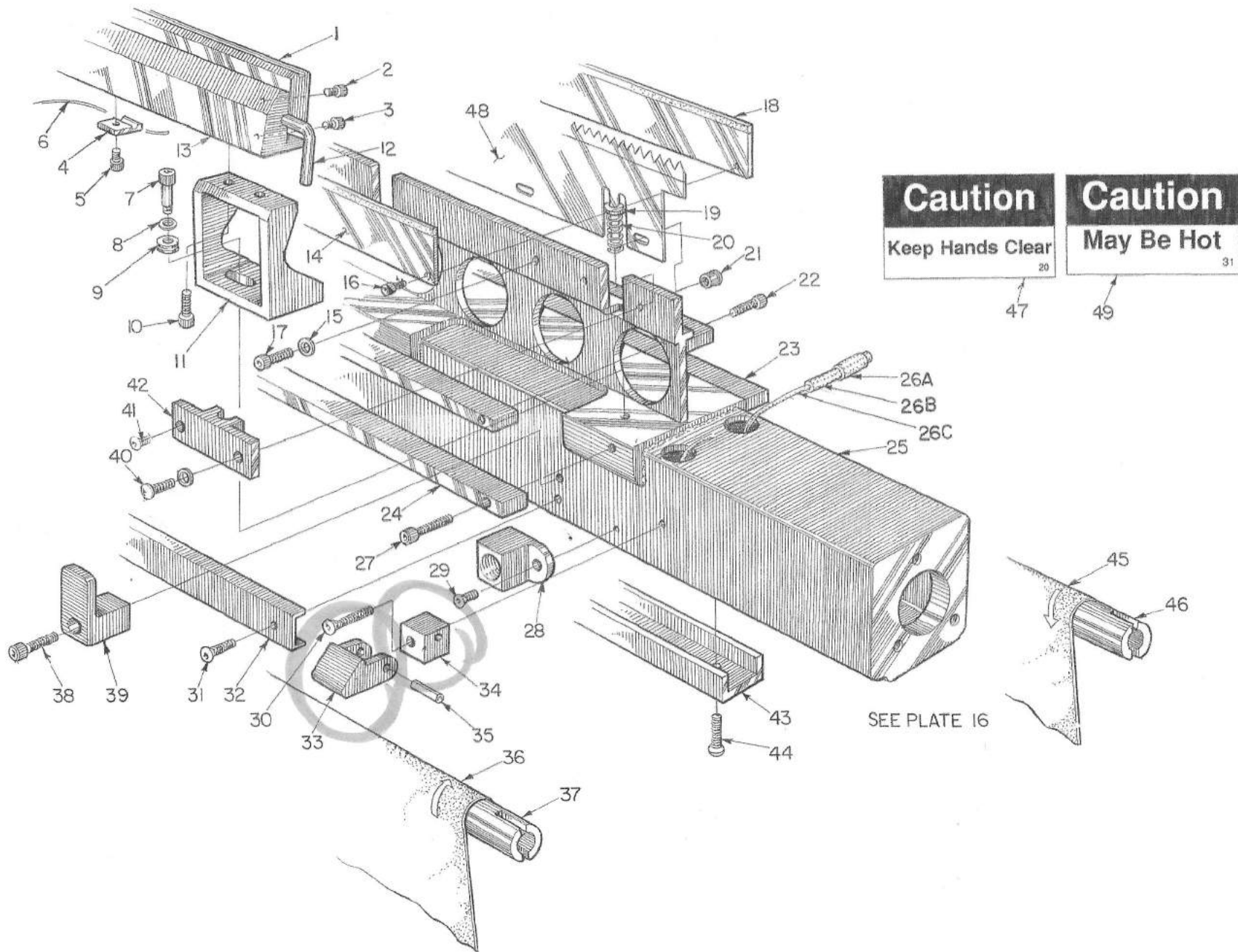
Give machine width

4180

418HE

4180/418HE

Key No.	Description	Part No.	Part No	Part No
	Give machine width	4180	418HE	4180/418HE
1	Heat Seal Bar			See Chart
2	SHCS (F10087004-030)			8 - 32 X 1/2
3	SHCS (F10087004-040)			8 - 32 X 5/8
4	Clamp			A10070865
5	SHCS (F10087006-030)			10 - 32 X 1/2
6	T/C Seal Bar			B10069278
7	Shoulder Bolt (F10087173-030)			5/16 X 3/8
8	Bellville Washer			03367
9	Bellville Washer			03367
10	SHCS (F10087006-040)			10 - 32 X 5/8
11	Bracket (B04180144 Wide Seal Bar)			B10065181
12	Heating Element* (Nut - use key no.)			A04180256
13	Mounting Bar**			C04180007
14	Stripper Plate			B10104562
15	Washer (F10087187-008)			#8
16	SHCS (F10087002-015)			6 - 32 X 5/16
17	SHCS (F10087004-030)			8 - 32 X 1/2
18	Stripper Plate			B10104563
19	Washer (F10087187-007)			#6
20	Spring			03454
21	Allen Nut			30120
22	SHCS (F10087004-040)			8 - 32 X 5/8
23	Bobbin Support*			B10015768
24	Bobbin Support*			B10015769
25	Head			D10116205-2
26	Boot (Connector A04180148)			A04180109
27	SHCS (F10087004-040)			8 - 32 X 5/8
28	Junction Box			A04180036
29	Button Hd. Scr. (F10087060-050)			8 - 32 X 1/2
30	Flat Hd. Screw (F10087040-045)			1/4 - 20 X 7/8
31	SHCS (F10087004-050)			8 - 32 X 3/4
32	Cover*			B04180293
33	Stop Bobbin			A04180247
34	Stop Bracket			A04180246
35	Roll Pin (F10087262-050)			1/8 X 3/4
36	Tape*			2687
37	Bobbin*			A04180066
38	SHCS (F10087007-030)			1/4 - 20 X 5/8
39	Tape Stop			A04180260
40	BHCS (F10087058-040)			8 - 32 X 5/8
41	BHCS (F10087058-020)			8 - 32 X 3/8
42	Spring Seat			C10116212
43	Wire Cover			B04180294



Caution
Keep Hands Clear
20

Caution
May Be Hot
31

SEE PLATE 16

Plate 15 Head Assembly Continued

List 15 Head Assembly

Key No. Description

Give machine width

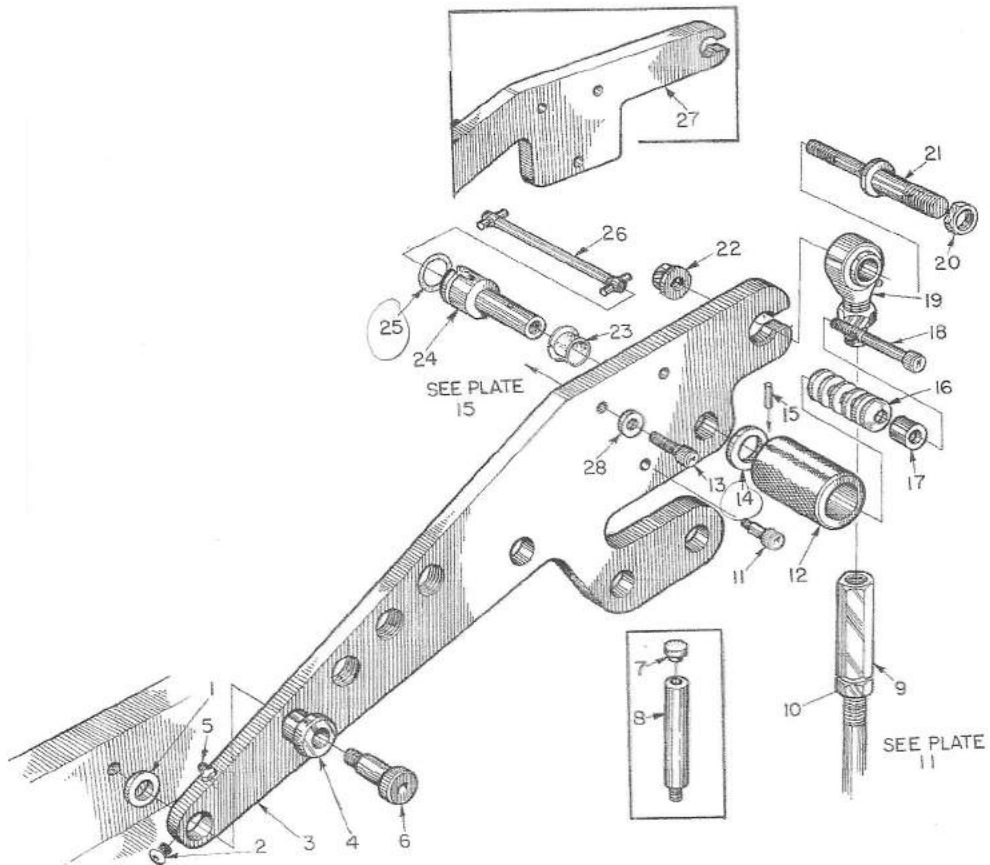
**Part No.
4180**

**Part No
418HE**

**Part No
4180/418HE**

Key No.	Description	Part No. 4180	Part No 418HE	Part No 4180/418HE
44	SHCS (F10087004-050)			8 - 32 X 3/4
45	Curtain 36" X M.S.			02687
46	Bobbin*			A04180066
47	Caution Label			#20
48	Perf. Blade			See Chart

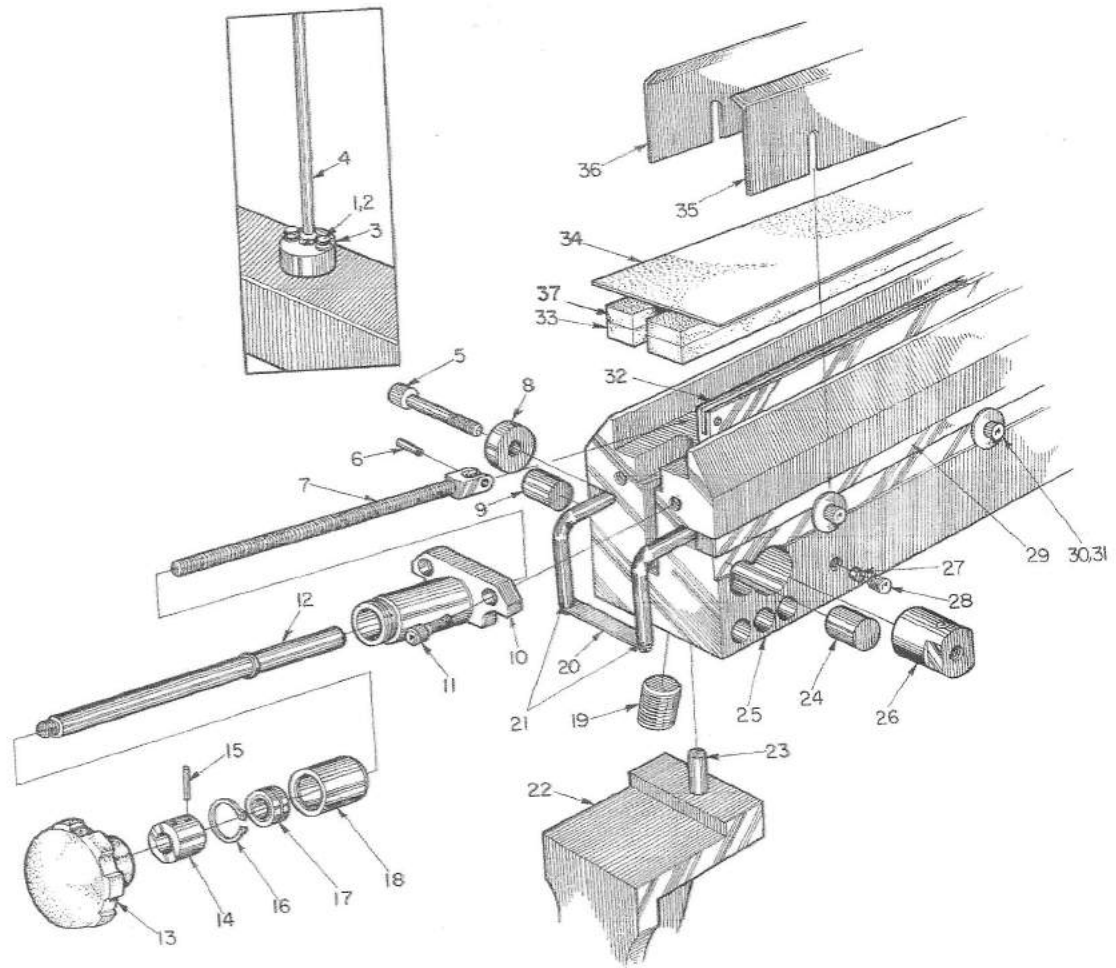
Plate 16 Head Arm Assembly



List 16 Head Arm Assembly

Key No.	Description	Part No. 4180	Part No 418HE	Part No 4180/418HE
1	Thrust Washer			03364
2	SSS (Button Head) (F10087058-0100)			8 - 32 X 1/4 10 - 32 X 1/4
3	Arm			D04180161
4	Bushing			A04180102
5	Fitting			05739
6	Shoulder Bolt			16784
7	Bumper, Rubber			1108
8	Stop, Head			A04180176
9	Turnbuckle			B10108208
10	Hex Jam Nut (F10087195-060)			5/8 - 18
11	SHCS (Shoulder Bolt) (F10087174-030)			3/8 X 1/2
12	Knob			A04180210
13	SHCS (F10087009-070)			5/16 - 18 X 1 1/4
14	Washer			A04180143
15	Roll Pin (F10087262-030)			.125 X .562
16	Belleville Washer			4795
17	Sleeve			A04180212
18	SHCS (F10087007-040)			1/4 - 20 X 3/4
19	Bearing			36673
20	Nut (F10087194-080)			5/8 - 18
21	Stud			B10108206
22	Flange Nut			05780
23	Bearing			00002
24	Shaft			A04180211
25	O-Ring			01182
26	Shaft w/ Pins			A04180067
27	Arm (For automatic tape advance)			D04180063

Plate 16A Platen Assembly



List 16A Platen Assembly

Key No. Description

**Part No.
4180**

**Part No
418HE**

**Part No
4180/418HE**

Give machine width

Key No.	Description	Part No. 4180	Part No 418HE	Part No 4180/418HE
1	Hex Hd. Screw (F10087075-100)			5/16 - 18 X 2
2	Washer (F10087185-060)			5/16
3	Block			A10100213
4	Support Rod			A04180262
5	SHCS			A04180094
6	Pin (Split) (F10087264-040)	3/16 X 3/4		
7	Adjusting Rod			A10003544
8	Washer			A04180097
9	Pin			A04180093
10	Bracket			B10003551
11	SHCS (F10087007-040)			1/4 - 20 X 3/4
12	Adjusting Rod			B10003550
13	Knob			2540
14	Collar			A10011258
15	Roll Pin (F10087262-060)			1/8 X 1
16	Retaining Ring			5321
17	Bearing			354
18	Bearing Sleeve			A10003541
19	Set Screw			A04180160
20	Plate			A10094052
21	Heating Element*			04012
22	Platen Bracket L.S.			B04180054
23	Dowel Pin (F10087277-070)			1/2 X 2 1/2
24	Pin			A04180093
25	Platen*			D04180077
26	Washer w/ Set Screw			A04180100
27	Brass Plug			A10002995
28	SSS (F10087101-050)			1/4 - 20 X 1/2
29	Square Key			A10018694
30	SHCS (F10087006-030)			10 - 32 X 1/2
31	Washer			B00050001-199
32	Platen Insert* (State gap width)			C10052433/ C418-158
33	Rubber# (Soft)			02673
34	Teflon Tape*			02686
35	Hold Down*			B10019855
36	Hold Down*			B10019855
37	Rubber Hard			02674