STEP ONE Pallet Wrapper

OPERATION   MANUAL

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TABLE OF CONTENT

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1. GENERAL

1.1 NOTICE OF INSTALLMENT

To make sure a safe and correct operation, please check conditions

below before install the machine:

1) Power source capacity must be equal of the machine need.

2) Machine standard power is 110v/230v (+- 10%)

3) Machine standard power Hertz is 50/60 Hz. (+- 2%)

4) Machine is workable under the temperature between O^0 and 45^0

5) Make sure the wire is tidy on the ground.

6) There should not have vibration beside the machine during

   the installment, and make sure to ground is flat.

7) Read and follow the instruction of the installment.

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1.2   NOTICE OF OPERATION

To have good protection for the operator, please make sure the
following conditions:

1) Before operating, please read the machine operational manual carefully.

2) Make sure there is no object put on the power cable.

3) Make sure there is no object put on the upper elevator unit.

4) Avoid any damp object or water around the electric parts.

5) Avoid film winded into the turntable.

6) Do not stand on or across the machine during operation.

7) When the problem occurs, please check the section of 5 Trouble shooting

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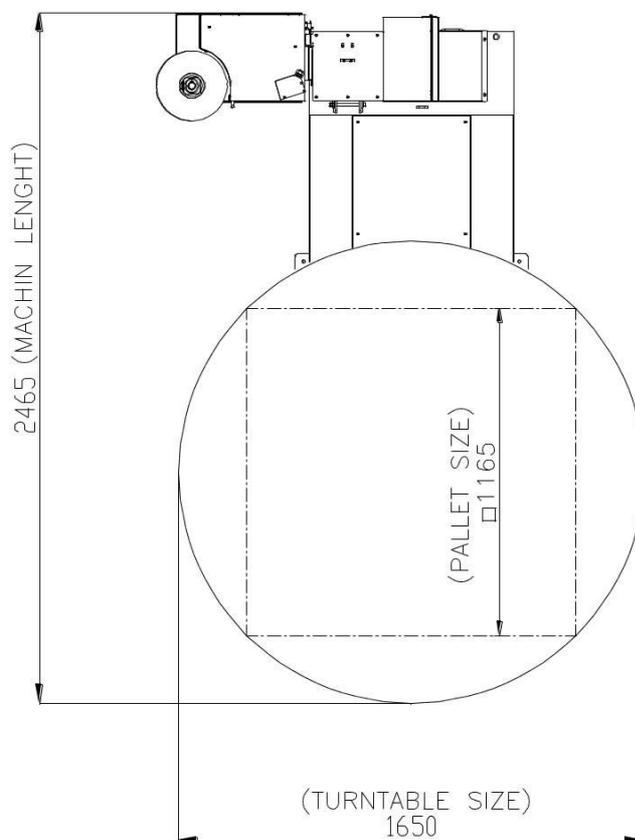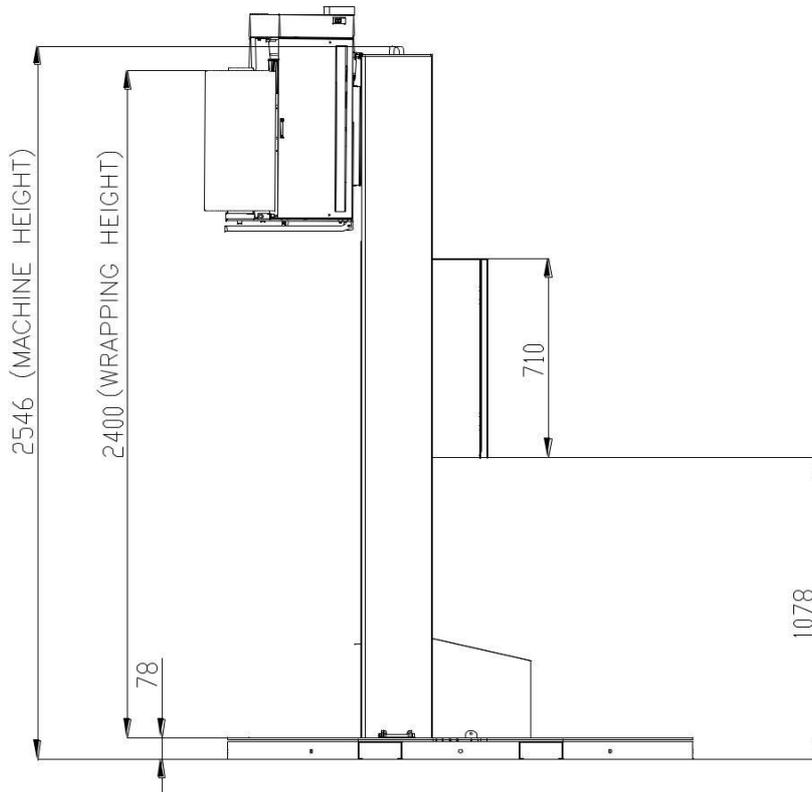support@sal-tech.com
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2. SPECIFICATION

2.1 SPECIFICATION TABLE

Model	TMD-P46P
Turntable Speed	12 RPM
Turntable dia.	1650mm
Max. Wrapping height	2400mm
Max. Wrapping size	1165x1165mm
Max. Loading weight	2000Kg
Film stretch (%)	150% ~ 300%
Max. film spec.	Ø250x500mm
Turntable height	76mm
Ramp (slope) spec.	1165x1000mm
Machine size	2465x1735x2546 mm
Machine net weight	394Kg

Standard option:

- Turntable diameter 1800mm

- Wraping height to 2.9 meters

- Turntable acces ramp

- Pit frame

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2.2   MACHINE DIMENSION

2546 (MACHINE HEIGHT)

2400 (WRAPPING HEIGHT)

710

1078

78

2465 (MACHIN LENGHT)

(PALLET SIZE)
□1165

(TURNTABLE SIZE)
1650

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2.3   Machine Description

CONTROL BOX

TOWER

CARRIAGE

MOTOR COVER

TURNTABLE

SEAT

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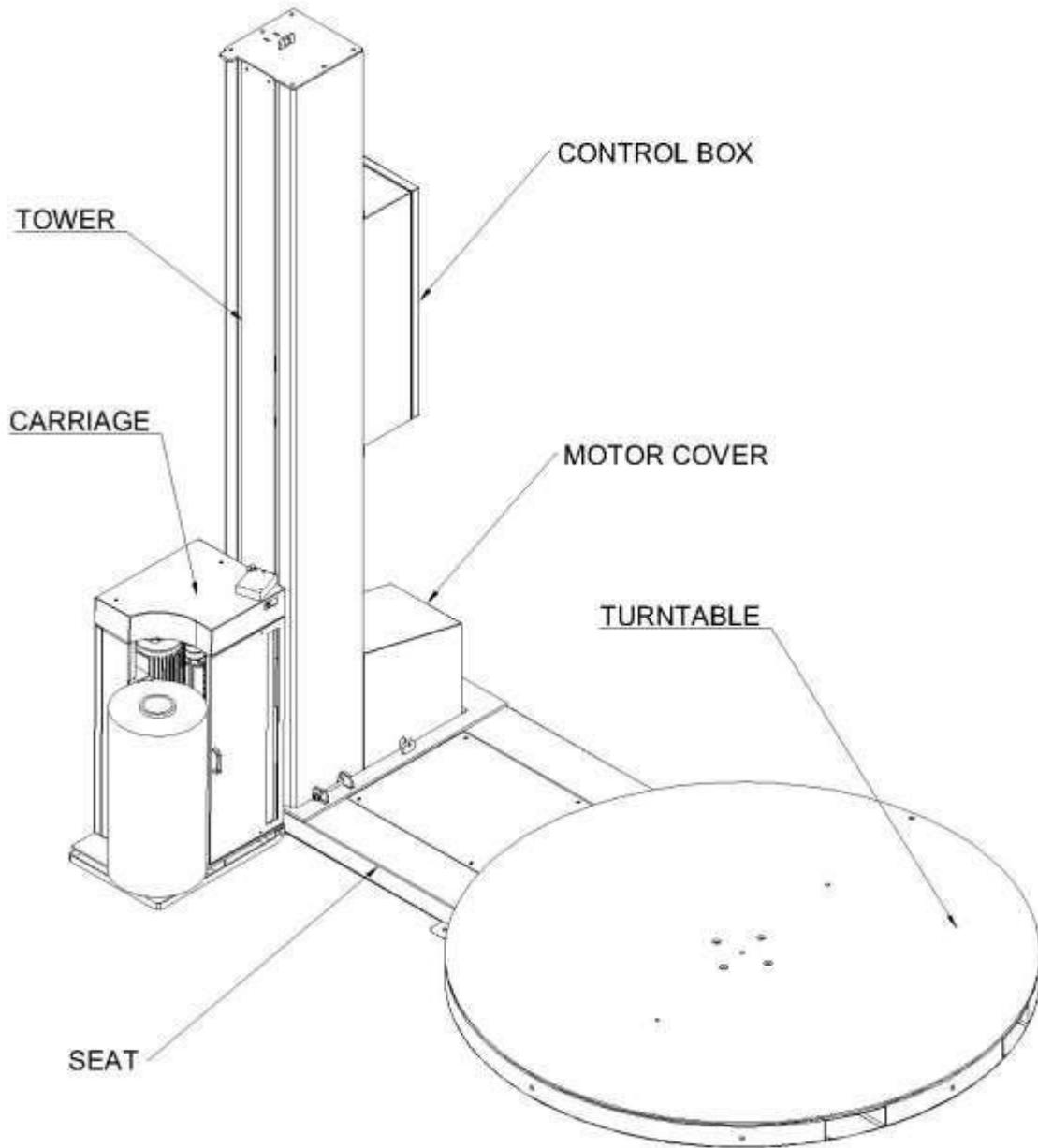
3. OPERATION DESCRIPTION

## 3.1 INSTALLMENT

1) Apart the wooden package. Avoid damaging the machine.

2) a) Loosing 4 screws at the end of masters。 (Do not unscrew the sliding shaft, leave inside the track).

   b) Lift up the master (Step 1).

   c) Sliding the master towards turntable, until the sliding shaft move into locking position (Step 2).

   d) Master is in position to be fully lifted and tighten all screws (Step 3).

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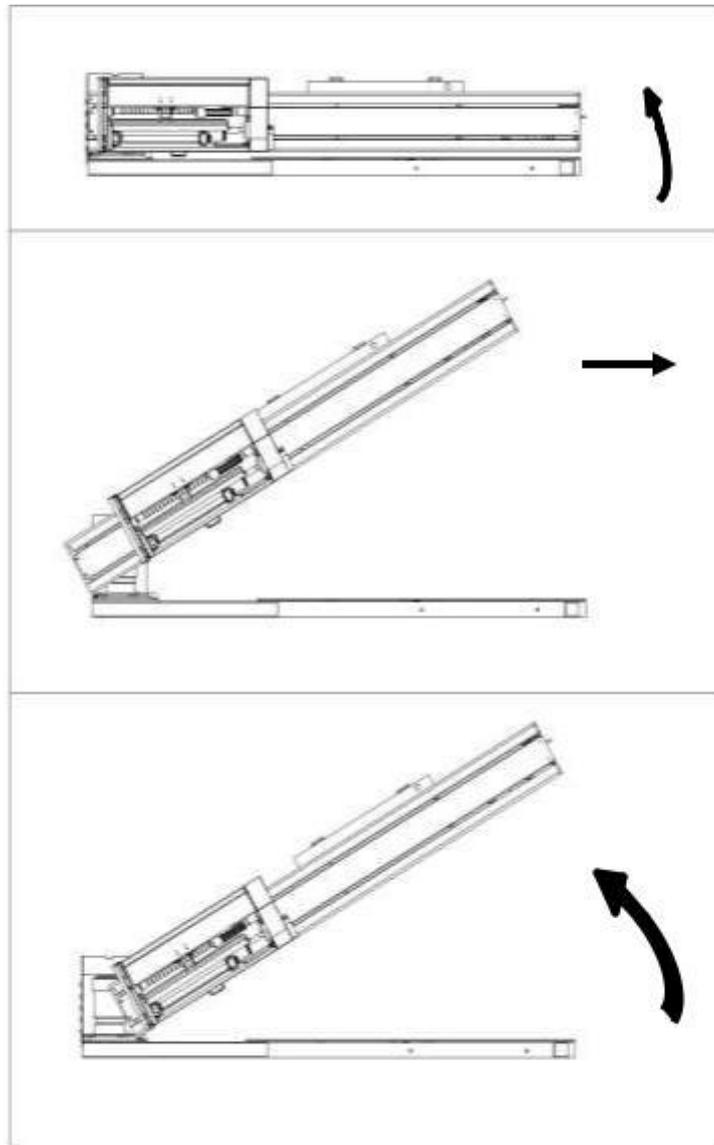
3) Connect the motor plug to the main control, by referring to the

diagram below. Machine is ready to be connecting to the power cable

with the socket by an 110V/230V power.

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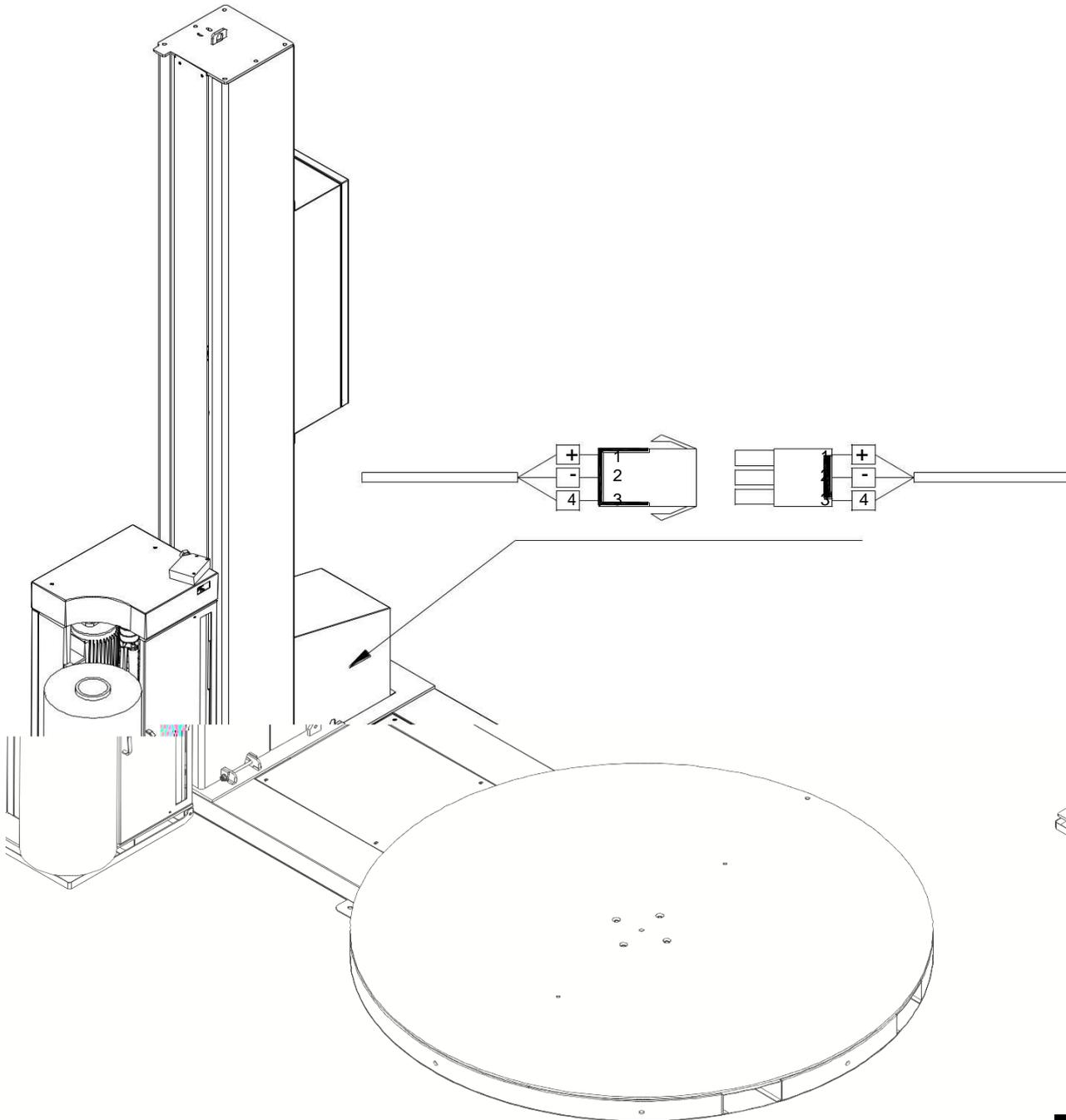
3.2 REMINDER OF INSTALLATION

Please pay attention on:

Tower Installation

When installing the tower, the engineers must make sure all 4 screws are properly

installed underneath the tower. 1 by carriage side, and 3 by the motor sides.

Motor Cover

After all the connections are complete, please carefully install the motor cover to

cover up all the wire connections and the motor on the base of the machines.

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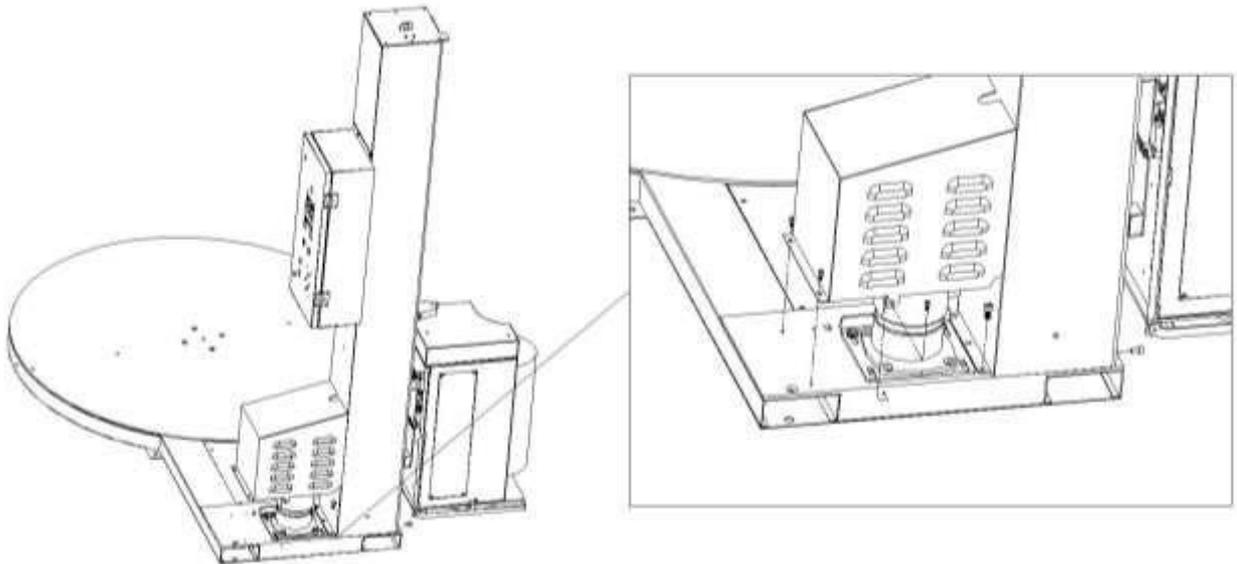
3.3 OPERATION OF CONTROL PANEL

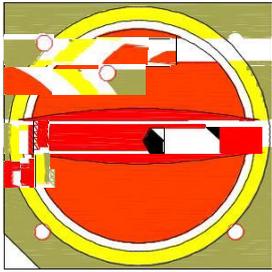Sal-Tech Easy Packaging
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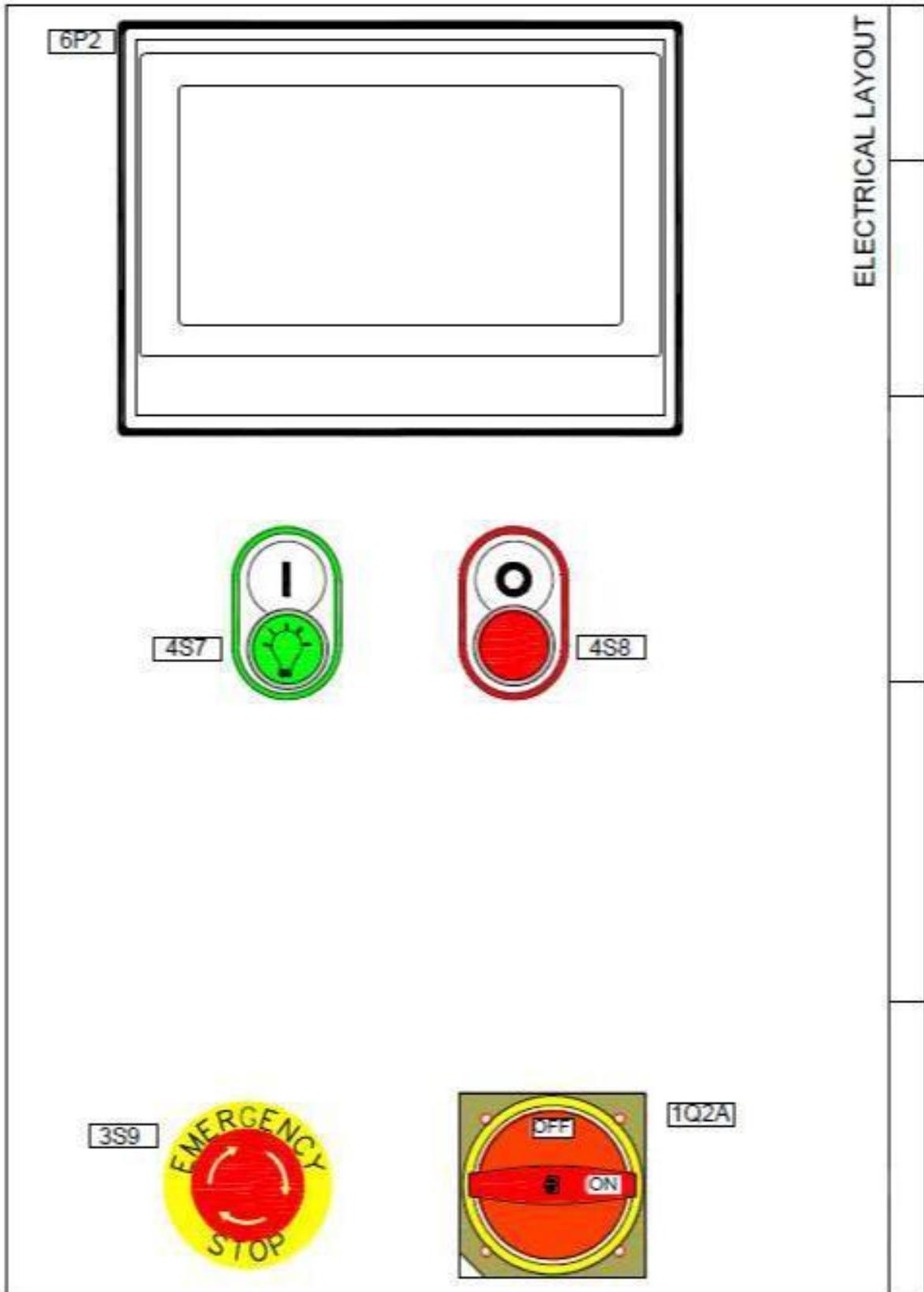
3.4   OPERATION DESCRIPTION

A. MAIN POWER

To switch ON and OFF the power
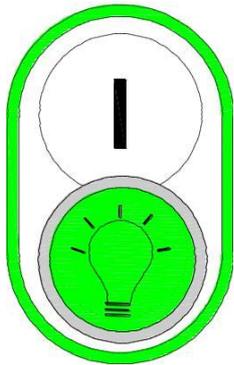
B. START

Press the button to get automatic or manual program running.
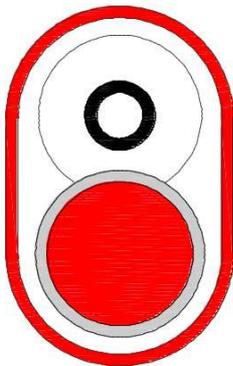
C. PAUSE

During the wrapping cycle, if the machine is required to be

stopped, press **C** button to pause the machine and press **B**

button to resume back to operation.

D. EMERGENCY STOP

Press the button for emergency stop. For security consideration,
the turntable will not be stopped instantly as the EMG. STOP switch
is pressed. As the turntable power is switched off, the break Will be
release too. Turntable will be stopped in 10 ∘ ~ 70∘ . It depends on
the weight load.

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3.5   PIN (Personal Identification No.) CODE

1. PIN:4682
2. Press "0000" to enter setting menu without PIN code.
3. Forgot PIN code: Contact your dealer for new PIN.

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3.6   OPERATION MODES.

Stand-by screen. Tap it to access main menu. If the machine is idle for more than 5 minutes, it will redirect itself to this screen.

- MAIN   MENU
  Touchscreen.

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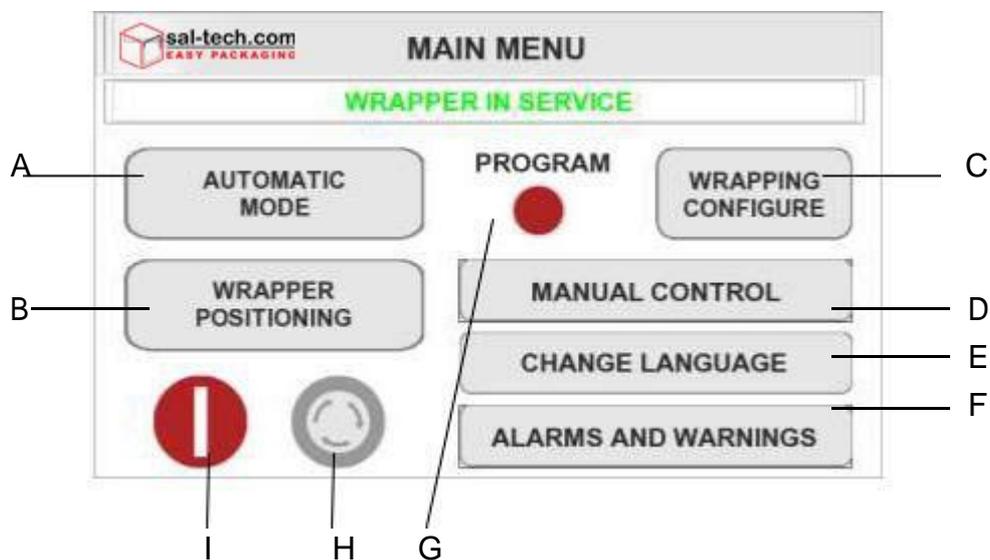
A- <u>AUTOMATIC MODE</u>.

Start automatic cycle.

Press "AUTOMATIC MODE" button. (Pos. A page 12)

Press green button on control panel to start cycle.
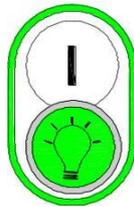
Automatic cycle will start after 5 seconds with an audible warning.

B- <u>POSITION WRAPPER</u>. (RESET)

Press "POSITION WRAPPER" button. (Pos. B page 12)

Press the green button on control panel to start positioning.
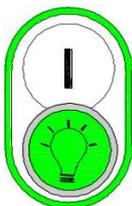
Positioning will start after 5 seconds with an audible warning.

C- <u>CONFIGURE WRAPPER SETTINGS</u>. (pos. C page 12) (See section C page 15)

Access to "CONFIGURE WRAPPER SETTINGS" screen to select desired program, configure the settings of the four programs or change the password.

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D- <u>MANUAL MOVEMENTS</u>. (pos. D page 12) (See section D page 20)

Access to manual movement screens to move the base and the reel carriage independently or wrap manually.

E- <u>CHANGE LANGUAGE</u>. (pos. E page 12)

Access change language screen.

F- <u>ALARMS AND WARNINGS</u>. (pos. F page 12) (See section F page 22)

Alarms and warnings indicator and access to visual alarms and warnings screen.

G- <u>PROGRAM</u>. (pos. G page 12)

Pre-selected program for automatic cycle.

Options:

H- <u>STOP/EMERGENCY</u>. (pos. H page 12)

Stop/Emergency indicator.

Disabled (grey)   Pressed (coloured)

I- <u>START/STOP</u>. (pos. I page 12)

Start/stop indicator.

Start (green)   Stop (red)

Wrapper in cycle or   Manual movements enabled

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C- <u>CONFIGURE WRAPPER SETTINGS</u>. (pos. C page 12)

Return to main menu.
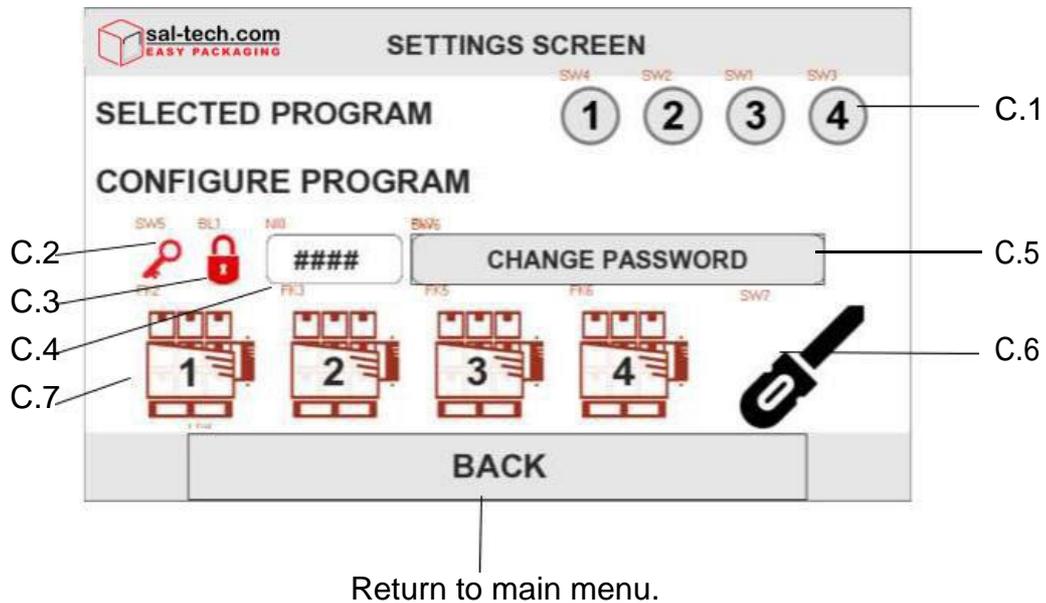
C.1- SELECTED PROGRAM.

Pre-select automatic wrapping program.

Press desired program to select it, it will be displayed in red.

C.2- LOCK BUTTON.

Button to lock access to change password and the configuring of the wrapping program settings.

C.3- LOCK INDICATOR.

Lock/unlock indicator for access to change password and the configuring of the wrapping program settings.

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C.4- KEYBOARD SCREEN.

Button to access keyboard and enter password. Once the correct password has been entered, an open padlock will appear on indicator C.3.

And this will allow access to change the password and configure the program settings.

C.5- PASSWORD SCREEN.

Button to access "CHANGE PASSWORD" screen.

"NOTE THAT YOU WILL ONLY HAVE ACCESS IF INDICATOR C.3 IS AN OPEN PADLOCK".
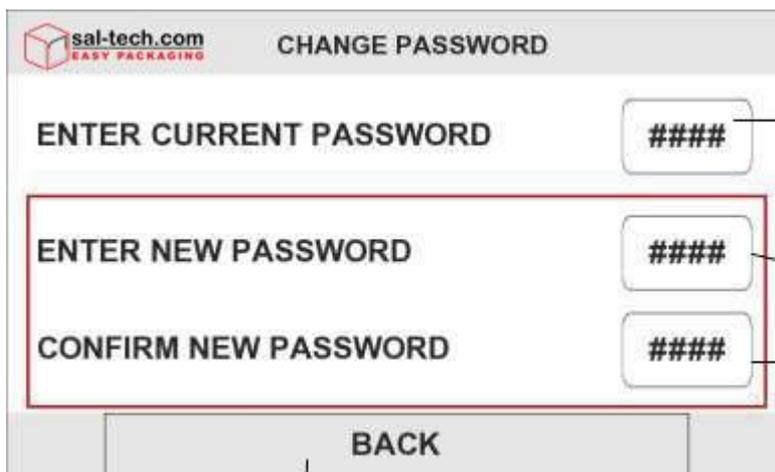
The user must enter the current password.
4682 (factory set) see page 11

User must enter the new password.

Use must enter the new password once again.

Return to C menu. Wrapper settings configuration.

C.6- AWL ACTIVATION.

When the user press this button, the awl will be activated to cut the film once the wrapping has been finished, in case that the machine owns an awl.

C.7- FOUR WRAPPING PROGRAMS.

4 buttons to configure the settings of the four wrapping programs. If we press one of the programs, we access its first settings configuration screen.

"NOTE THAT YOU WILL ONLY HAVE ACCESS IF INDICATOR C.3 IS AN OPEN PADLOCK".

See section "Wrapping program settings configuration"

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- <u>WRAPPER SETTINGS CONFIGURATION, SCREEN 1 of 4.</u>

Select single mode.

Select double mode.

Select cover on/off.

Height of the overlap.

Return to C menu. Wrapper settings configuration.   Go to next screen.

-<u>Select single mode</u>:

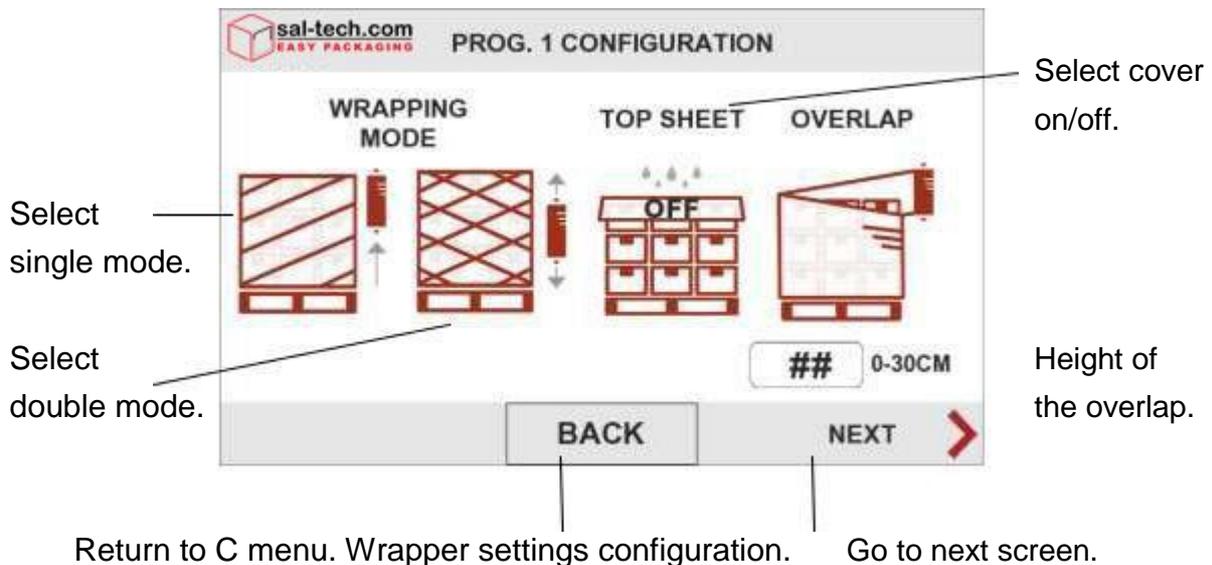Wrapper mode from the upper part to the lower part, including overlap (if applicable). When the wrapping cycle is completed, the carriage will be at the top and the operator must cut the film and do a reset so that the carriage returns to its starting position. (Lower part) -<u>Select double mode</u>:

Wrapper mode from the upper part to the lower part and return to lower part including overlap (if applicable). When the wrapping cycle is completed, the carriage will be at the bottom and the operator must cut the film to prepare for a new wrapping process.

-<u>Select cover ON/OFF</u>:

If the cover is enabled, the carriage will rise up to the upper part of the load, it will drop a few centimetres so that the operator can fit the upper plastic cover. Once fitted, the operator must press the green button on the control panel to proceed with the wrapping cycle.

The carriage will rise to cover the side part of the cover and it will finish wrapping if it is single or go down to the lower part if it is double. -<u>Height of the overlap.</u>

Height the user must define above the load so that the film covers its upper part. If no overlap is desired, the operator must leave the value at "0" or may define a height value up to 30 cm above the load.

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- WRAPPER SETTINGS CONFIGURATION, SCREEN 2 of 4.

Carriage
up speed.

Turntable
speed.

Carriage
down speed.

Back to previous screen.   Go to next screen.

Return to C menu. Wrapper settings configuration.
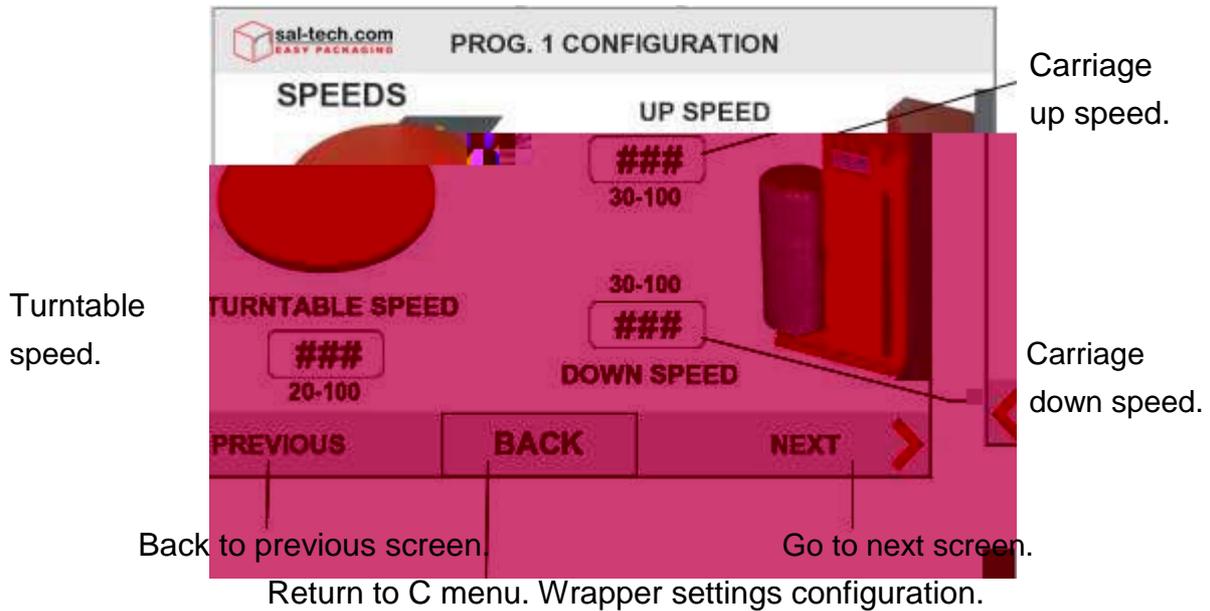
Screen where the operator can define the rotation speed of the turntable or the carriage raising/lowering speed. This speed can vary from 20 to 100, 20 being the slowest and 100 the fastest.

- WRAPPER SETTINGS CONFIGURATION, SCREEN 3 of 4.

Enable reinforc-
ement winds.
No. of winds on
upper part.

Height of
reinforcement
winds.

No. of reinforce-
ment winds.

No. of winds on
lower part.

Back to previous screen.   Go to next screen.

Return to C menu. Wrapper settings configuration.

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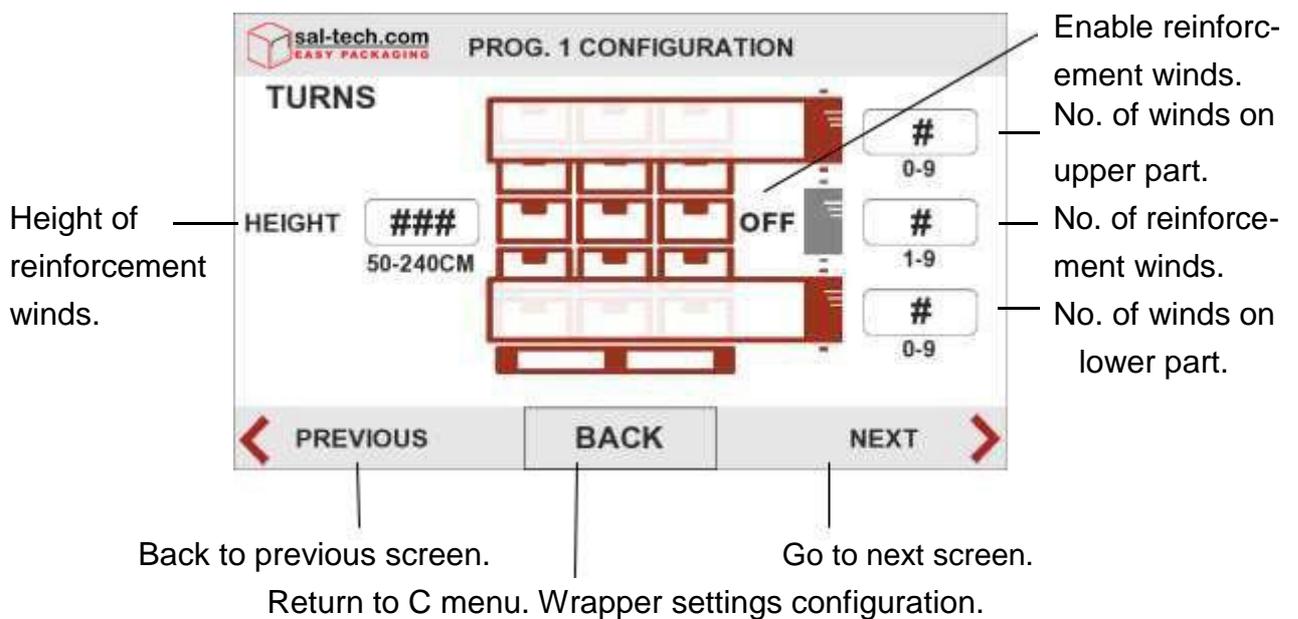
Screen where the user can select the number of wrapper winds on the upper and lower part and define whether reinforcement winds are required. If reinforcement winds are required one must press on the pallet diagram and the following image will be displayed:
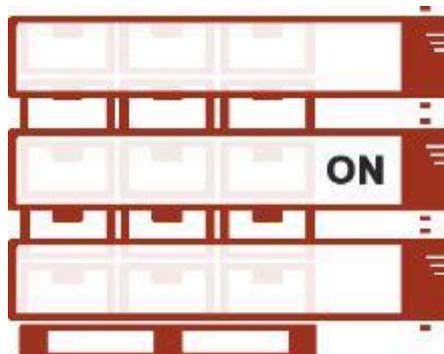
Once the reinforcement winds have been enabled, the user must define the height up to which these reinforcement winds are to be made entering a value from 50 cm up to 240 cm. If the entered value is greater than the height of the load, it will not make those reinforcement winds.

- WRAPPER SETTINGS CONFIGURATION, SCREEN 4 of 4.
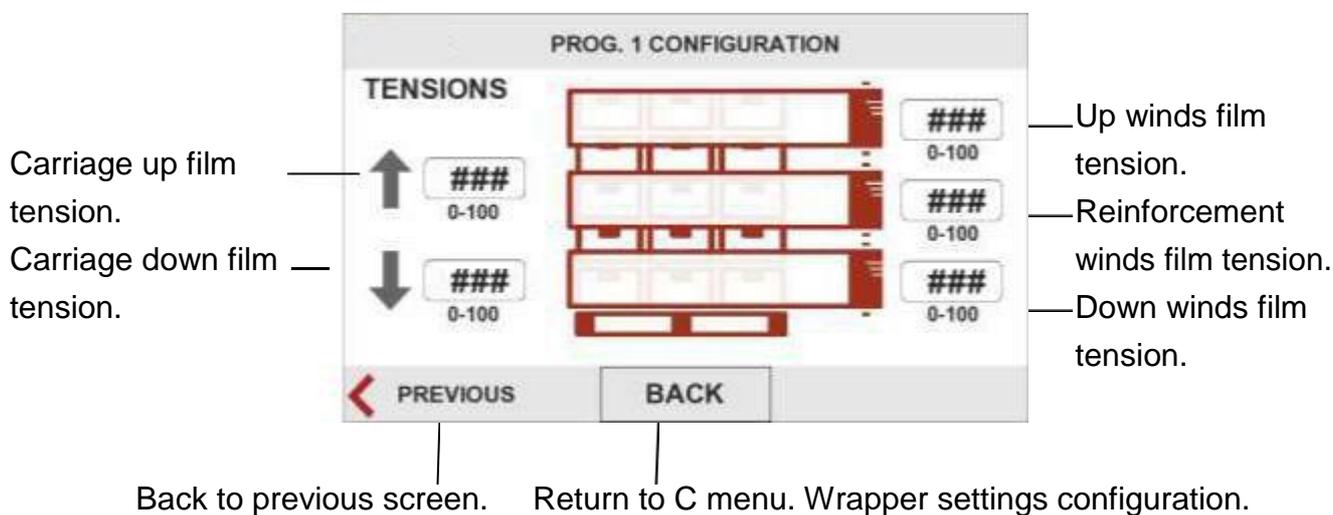
Screen from where the operator can select the 5 possible film tensions during the wrap winding process, the tension during the carriage going up, during it going down or in the three wind levels. If reinforcement winds have not been pre-selected, these will not be made even though a tension value has been set.

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D- <u>MANUAL MOVEMENTS</u>. (pos. D page 12)
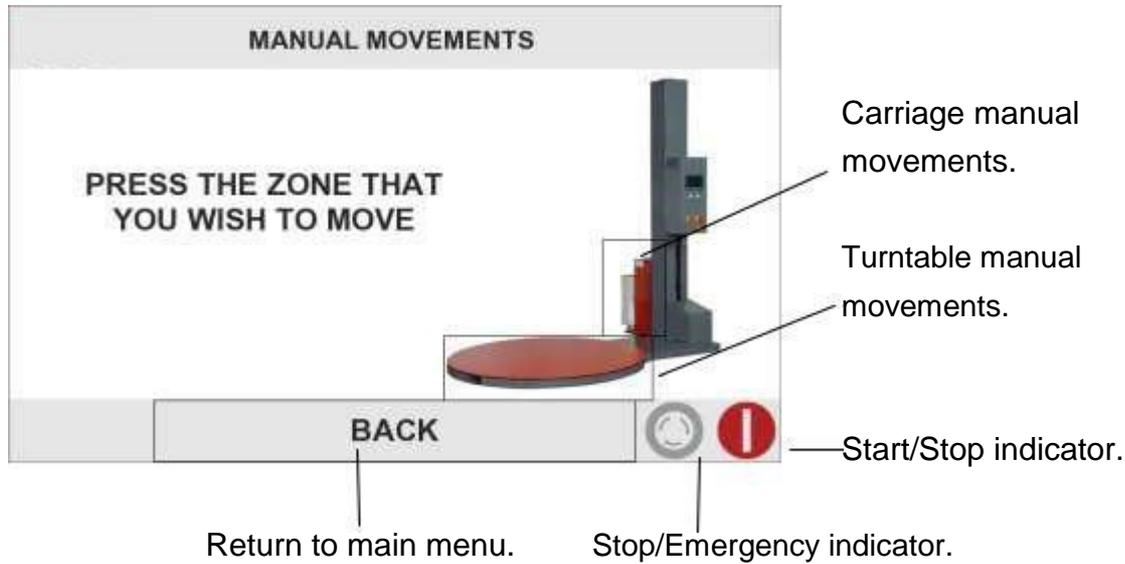
On this diagram the operator can go to both the turntable and carriage manual movement screens, by pressing on the respective parts of the diagram. The images show the areas where to press.

The indicators are to see whether the emergency is pressed and if the machine start is activated. Take into account that if start is not pressed, so the indicator will be green, one cannot proceed to manually move any of the components.

D.1- CARRIAGE MANUAL MOVEMENTS.

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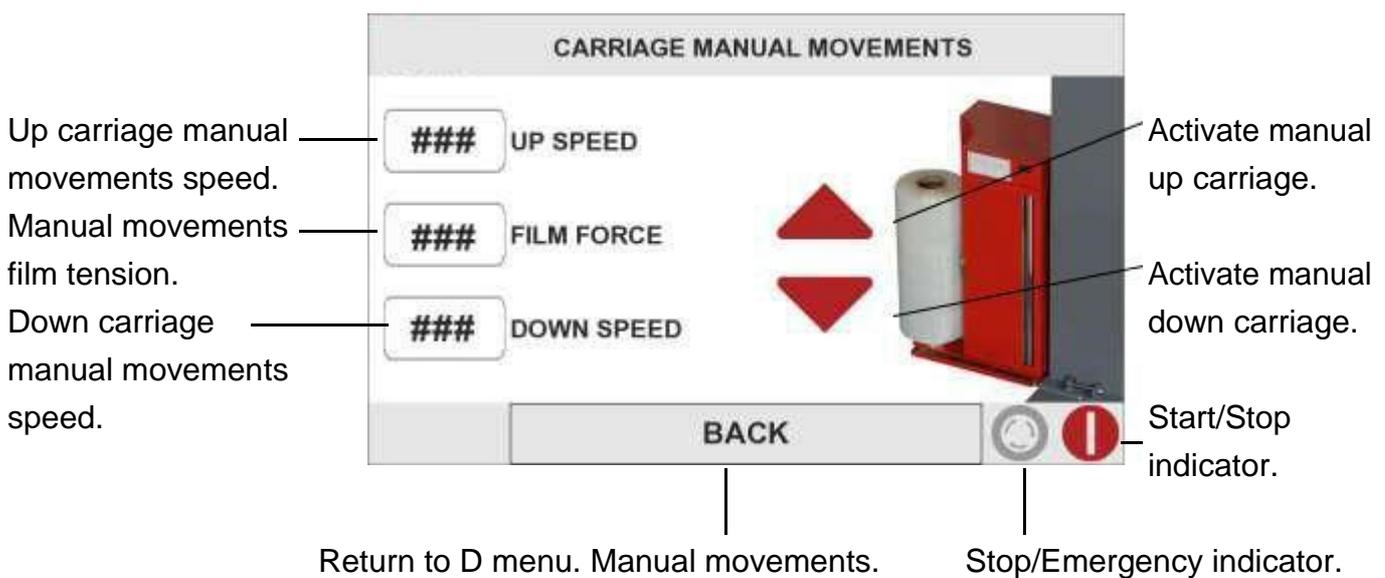
Screen where the operator can manually move the carriage. One can define the carriage up and down speed and also the film tension. To move the carriage up and down, the user must keep the carriage up/down activation arrows pressed.

The emergency stop and start/stop indicators display whether the emergency is activated and if start is activated, respectively. If the indicator is not green (start), no manual movement can be made.

D.2- <u>TURNTABLE MANUAL MOVEMENTS</u>.

TURNTABLE MANUAL MOVEMENTS

↺ TURN — Activate to manually rotate turntable.

↩ HOME — Activate to position/reset turntable.

SPEED — Manual movements turntable rotation speed.

BACK

Start/Stop indicator.
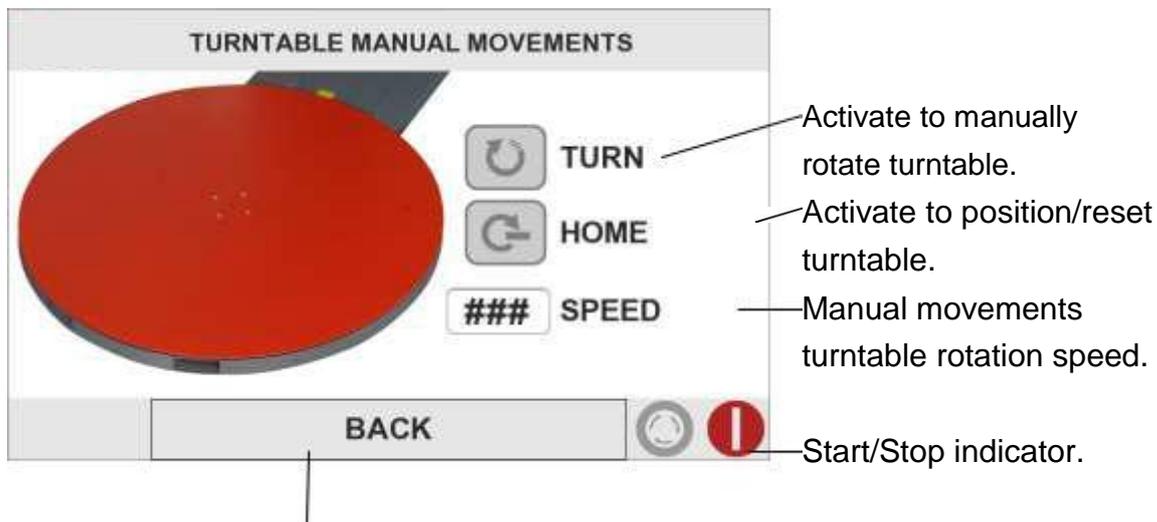
Return to D menu. Manual movements.　　　　　　　　indicator.

Screen where the user can make the turntable rotate manually. The user may select the turntable rotation speed, press the button to set it to the starting position or press the button to turn it.

The emergency stop and start/stop indicators display whether the emergency is activated and if start is activated, respectively. If the indicator is not green (start), no manual movement can be made.

D.3- <u>MANUAL WRAPPING</u>.

To perform manual wrapping, one can press the "Rotate" button and then go to carriage manual movements where one can manually raise and lower it. When one wishes to end the manual wrapping, one must press the turntable manual movements "Rotate" button so that it stops rotating.

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E- <u>CHANGE LANGUAGE</u>. (pos. E page 12)

Return to main menu.   Select language.

F- <u>ALARMS AND WARNINGS</u>. (pos. F page 12)

Return to main menu.   Go to next screen.

Screen where the operator can see the active alarms and warnings at all times. Information messages: (Green)

1. WRAPPER IN SERVICE: Wrapper ready for manual movements and automatic wrapping cycles.

Warnings: (Orange)

1. STARTING WRAPPER: Wrapper starting-up process time.

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Alarms: (Red)

1. FILM LACKING OR FILM BROKEN: The film has broken or run out during automatic wrapping, the cycle has been started without film.

2. TURNTABLE SENSOR DOES NOT DETECT: The turntable should be rotating but the sensor does not detect its position. It could be that the detector is not working even though the turntable is rotating or that the turntable transmission is not working and it does not rotate.

3. END OF UPPER AND LOWER TRAVEL PATH ACTIVATED: Upper and lower carriage detector. If this error appears it is because both detectors are activated.

4. FILM CARRIAGE HAS EXCEEDED RISING TIME: The carriage rising time in automatic mode has exceeded its time. If this warning appears it is probable that the carriage's upper travel path is broken and is not detected.

5. FILM CARRIAGE HAS EXCEEDED LOWERING TIME: The carriage lowering time in automatic mode has exceeded its time. If this warning appears it is probable that the carriage's lower travel path is broken and is not detected.

6. FOOT SAFETY DETECTOR IN FILM CARRIAGE: This message appears when there is something pressing on the foot safety detector under the carriage. Whenever this malfunction appears, a button immediately appears on the entire screen, which lets us raise the carriage by pressing anywhere on the screen, for safety. Once the problem ceases to be detected, this screen disappears.

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7. EMERGENCY STOP/CARRIAGE DOOR: This message will remain active when the emergency stop button is pressed or when the door of the film carriage is open.

ALARMS: TEXT
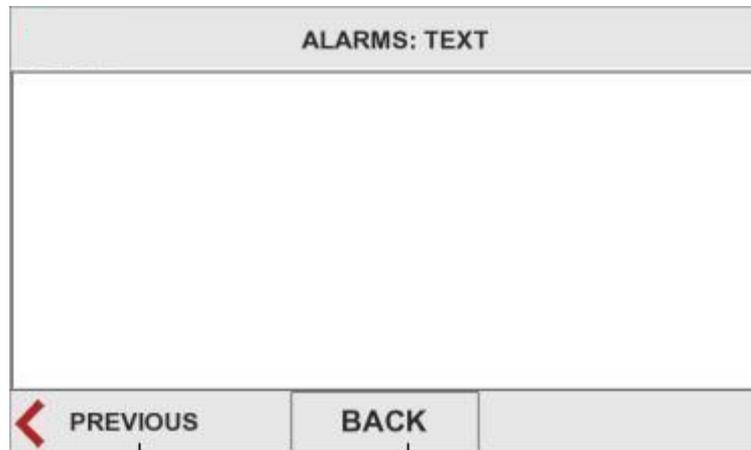
PREVIOUS   BACK

Back to previous screen.   Return to main menu.

Screen where the operator can see the history of the information messages, warnings and alarms that have appeared. Those that are still active are displayed in boldface.

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3.7   CARRIAGE FILM THREDING

Illustration for film threading

1. OPEN THE SECURITY DOOR FIRST.

2. FOLLOW THE TREADING DIAGRAM BELOW WITH THE DIRECTION OF CLING INSIDE OR OUTSIDE.

3. CLOSE THE CARRIAGE SECURITY DOOR
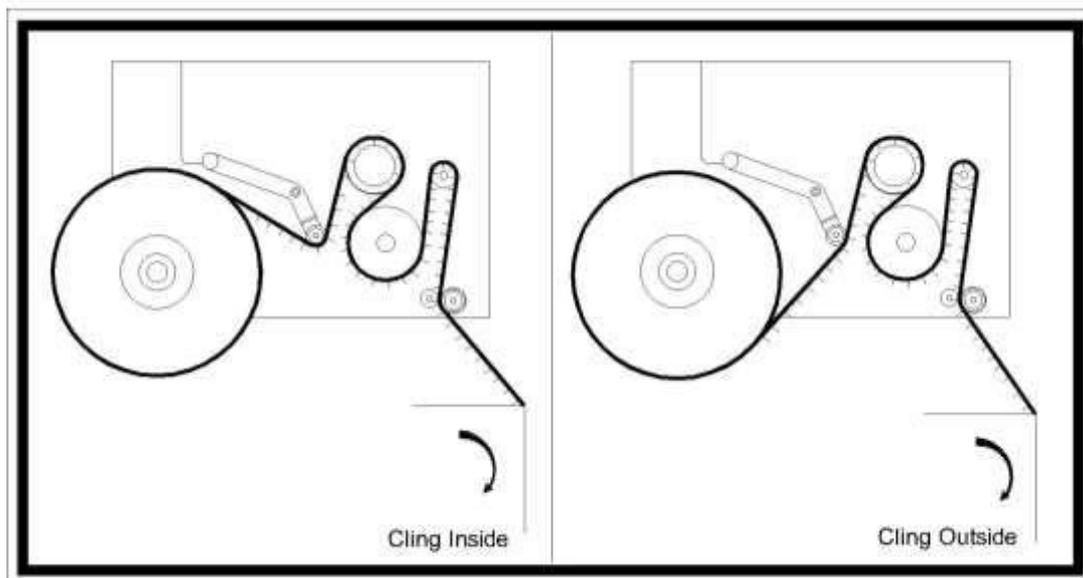
Illustration of Film Stretch Ratio Gear Change.

1. Before replacing gear, please make sure machine is off and power is unplugged.
2. Loose the screws from gear "(3)" and "(5)", and pull up to remove.
3. Replace gear with the preferred gear ration (see 6.3 CARRIAGE) and tighten the screws to secure gears.

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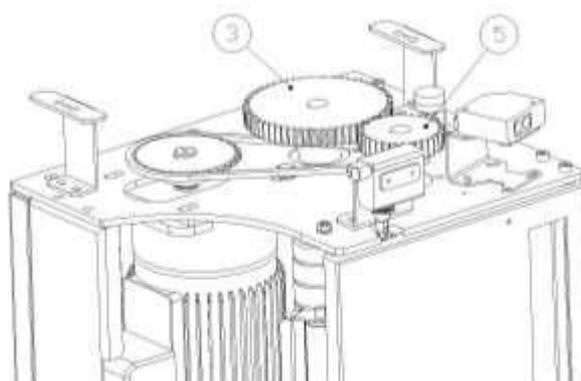
4.   ELETRIC
4.1   ELECTRIC CAPACITY

1) Electric consumption.

Pre-stretch motor	0.2 KW
Turntable motor	0.75 KW
Carriage Motor	0.4KW
Control & wiring box	DC 24V
Machine Power Use	1.37 KW
Power Socket need	1.5 KW

2) Power Cable   ----------------------   1.5 m^2

3) Machine input --------------------   110V / 230V 1-PHASE

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4.2(1) ELECTRIC PARTS LIST Sensor / limit switch location

KEY NO	PART NO	DESCRIPTION	Q'TY
3S9B	P0311-060001400	SAFETY SWITCH FILM CARRIAGE (ML-7312)	1
3S9C	P0311-060001400	CARRIAGE DOOR LIMIT(ML-7312)	1
4S2	P0311-060001210	TOP LIMIT (TZ-8108)	1
4S3	P0311-060001210	BOTTON LIMT (TZ-8108)	1
4B4	P0302-020000200	PHOTO EYE (A3R-2MX)	1
	P0319-10P46PT08	PHOTO EYE (A3R-2MX) W/ PLUG	1
4S5	P0302-010001200	TURNTABLE HOME SENSOR (PM12-04N-3M)	1
	P0319-10P46PT15	TURNTABLE HOME SENSOR (PM12-04N-3M) W/ PLUG	1
4S4	P0302-010003700	MOTOR PRE-STRETCH SENSOR (PL-05NB)	1
	P0319-10P46PT11	MOTOR PRE-STRETCH SENSOR (PL-05NB) W/ PLUG	1

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4.2(2) ELECTRIC   PARTS   LIST

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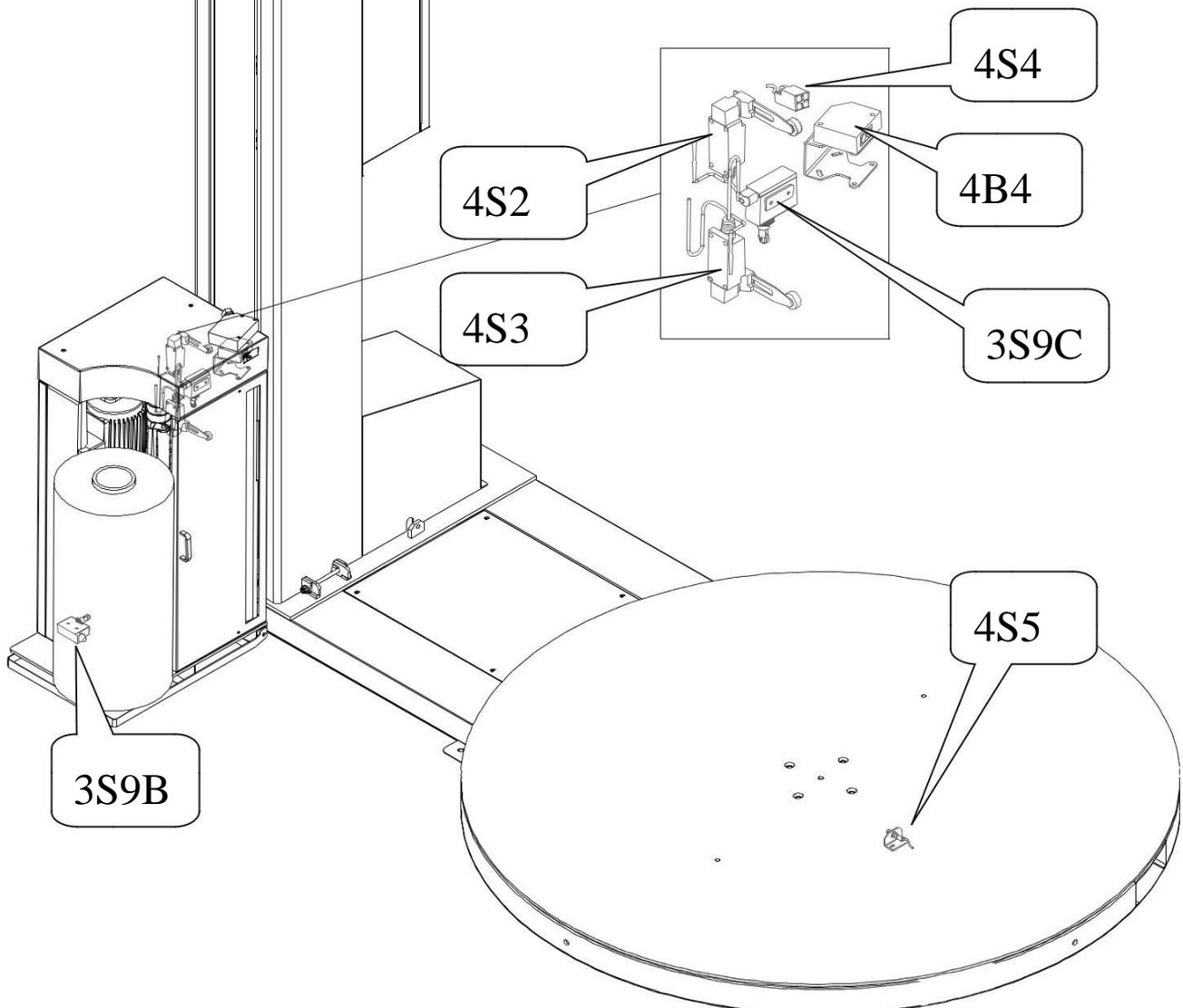
4.2(3) ELECTRIC   PARTS   LIST

KEY NO	PART NO	DESCRIPTION	Q'TY
1Q2	P0305-010001200	POWER FUSE (IK60N2PC16A)	1
1Q4	P0307-010000400	POWER 24Vdc (DR-4524 24Vdc-2A)	1
2U2	P0315-010003200	CV20-2S-0004G-037 INPUT:220V~240V 0.4kW	1
2U8	P0315-010003300	CV20-2S-0007G-037 INPUT:220V~240V 0.75kW	0
3U2	P0315-010003200	CV20-2S-0004G-037 INPUT:220V~240V 0.4kW	1
3K7	P0306-010000400	POWER CONTACTOR(LC1D18BL,DC24V)	1
4P1	P0308-010005100	PLC	1

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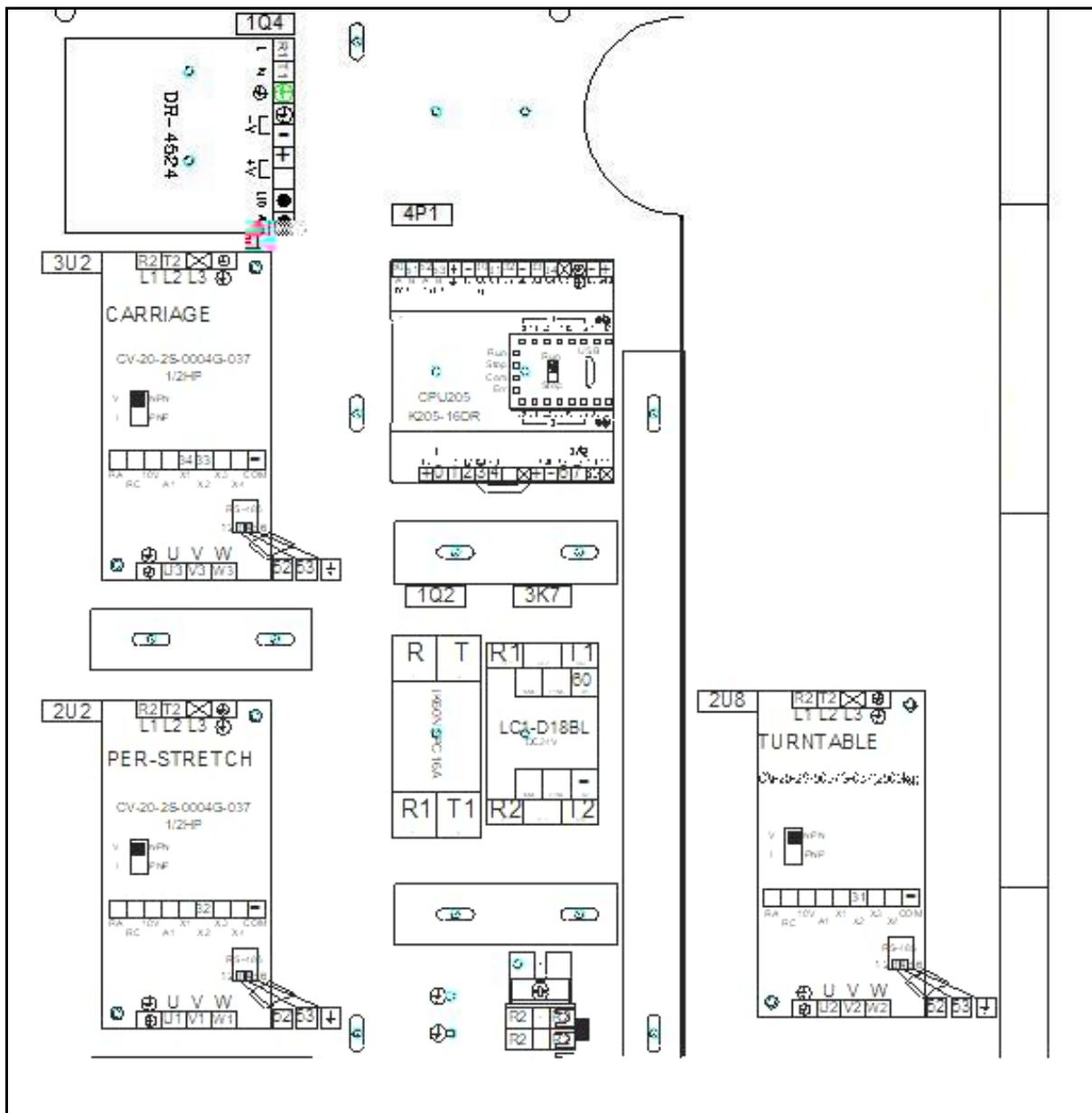
4.2(4) ELECTRIC   PARTS   LIST

KEY NO	PART NO	DESCRIPTION	Q'TY
1Q2A	P0311-010002800	POWER SWITCH (ZH-HD-48-BY)	1
3S9	P0313-020002800	EMERGENCY STOP (SKB2ES524-1B R) COVER+ CONTACT	1
4S7	P0313-020002900	START BUTTON (SKB2EW33B1) COVER+ CONTACT+ LAMP	1
4S8	P0313-020002600	STOP BUTTON (SKB2EA41-1A R) COVER+ CONTACT	1
6P2	P0327-010000700	TOUCH SCREEN (MT4434T(EN))	1

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Kinco
MODEL:MT4434T(EN)

COM0/COM2 USB SLAVE USB HOST Ethernet

DC24V GND FG

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4.3(1) CIRCUIT DIAGRAM

CIRCUIT DIAGRAM

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4.3(2) CIRCUIT DIAGRAM

CIRCUIT DIAGRAM

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4.3(3) CIRCUIT DIAGRAM

CIRCUIT DIAGRAM

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4.3(4) CIRCUIT DIAGRAM

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4.3(5) CIRCUIT DIAGRAM

CIRCUIT DIAGRAM

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4.3(6) DIAGRAMA ELECTRICO

CIRCUIT DIAGRAM

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5. TROUBLE SHOOTING

5.1 GENERAL ADJUSTMENT

Turntable belt adjust

Please see the illustration below and then loosen the motor seat M10 screw 4 pcs.

Turn the (M10) on the seat until get enough tension. Turn and tight the motor seat screw

4 pcs again.

Elevator unit driving chain adjusts:

Adjust the elevator to proper position and take off the cover tower

Adjust the M10 screw (Up and down) to proper tension

M10 BOLT

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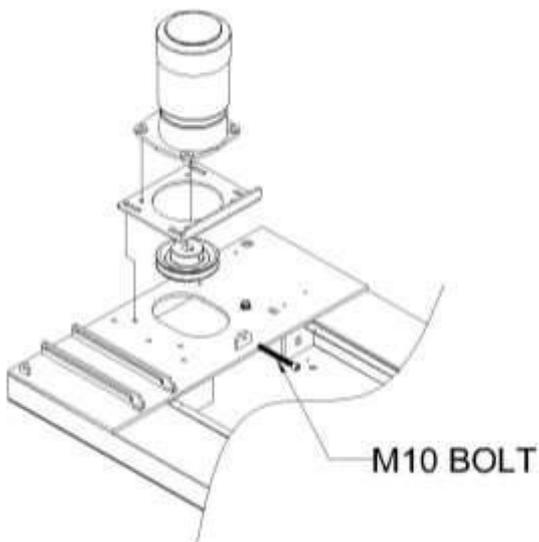
5.2 TROUBLE SHOOTING 1/2

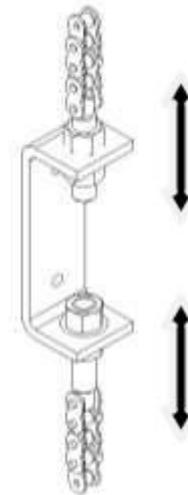| Machine trouble	Cause	Solution
Machine can not work	Power supply for motor is tripped Screen lamp not ON. Foot security is broken.	Activate the power switch. Check micro- processor board. Release the security s/w.
Turntable can not turn	Microprocessor board broken Motor stop turning	Change microprocessor board Check error message from inverter and refer to
Turntable can not Stop at home position.	Turntable proximity S/W is not working.	Check the proximity S/W sense. If it is no problem adjust the sensing plate.

CARRIAGE unit cannot move.	Microprocessor board broken
	Motor stop turning.
		Change microprocessor board
		1.Check the proximity S/W sense. If it is no problem
		   adjust the sensing plate.
		   4.3(4) ELECTRIC DIAGRAM (4S2)(4S3)

As doing AUTO RUN the
CARRIAGE unit goes up and over
the package height
	Photo eye gets sense from another material except package.
	Photo sensor gets sense from another light source.
		1.Move away other objects
		   Avoid the light source.
		2. Check the photo eye
		   4.3(4)ELECTRIC DIAGRAM (4B4)

As doing AUTO RUN but
CARRIAGE cannot goes up.
	1.Photo eye broken
	   Photo sensor cannot sense a black color
	   package.
	2. Photo eye broken
	   Photo eye cannot sense a package.
	3. Turntable proximity sensor is not working
		1. Change photo eye.
		   Avoid a black color package or use manual
		   operation.
		2. Check the photo eye
		   4.3(4)ELECTRIC DIAGRAM (4B4)
		3. Check sensor 4.3(4) ELECTRIC DIAGRAM (4B4)

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5.2 TROUBLE SHOOTING 2/2

Machine trouble	Cause	Solution
Pre-stretch motor cannot work	1. MOTOR PRE-STRETCH SENSOR FAULTY 2. PRE-STRETCH INVERTER FAULTY	1.CHECK PRE-STRETCH SENSOR 4.3(4)ELECTRIC DIAGRAM(4S4) 2.CHECK PRE-STRETCH INVERTER 4.3(2)ELECTRIC DIAGRAM(2U2)

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6. PART LIST

6.1 SEAT

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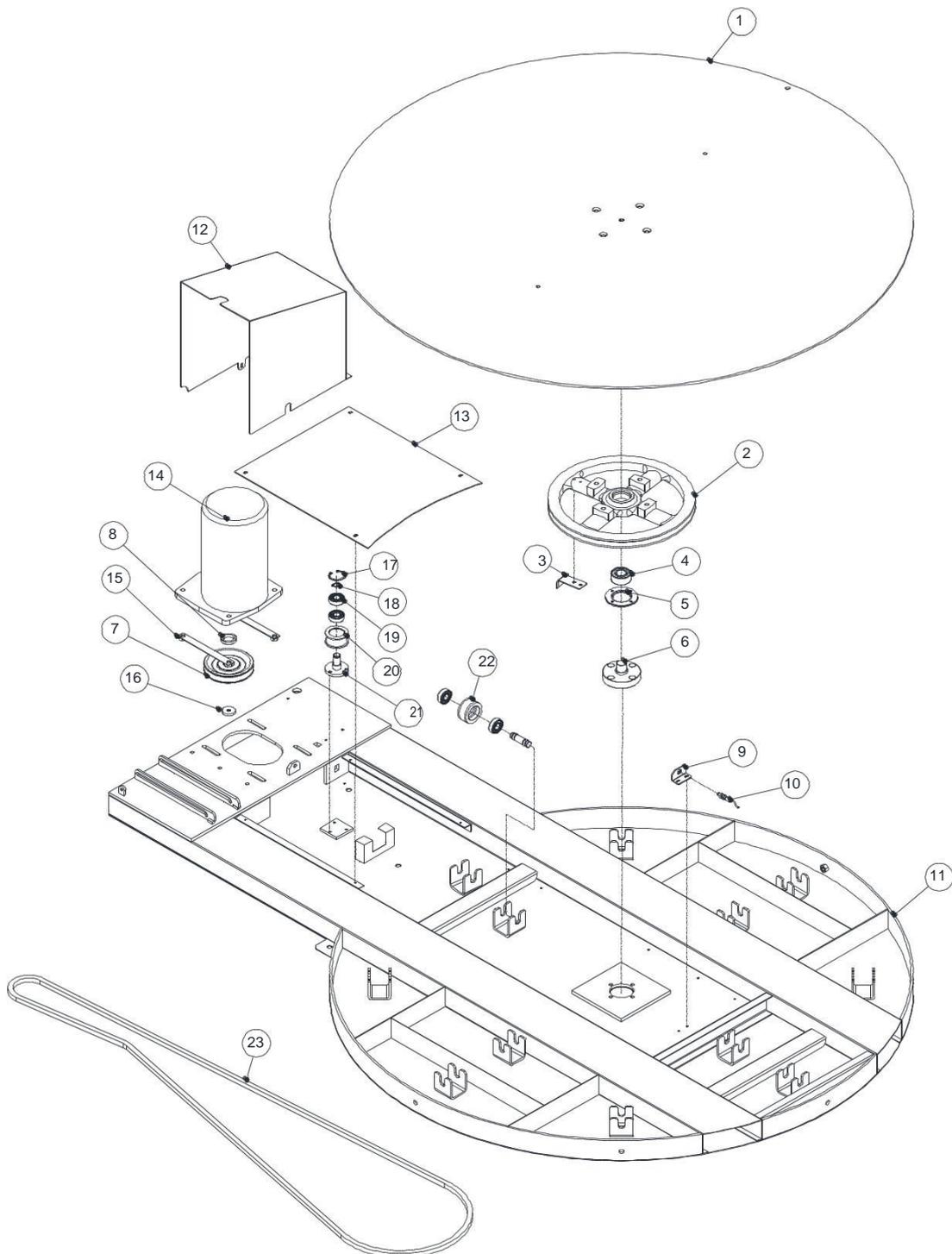
PART LIST

KEY NO	PART NO	DESCRIPTION	Q'TY
1	P01-0452000	1.65M	1
	P01-0510200	1.8M	1
2	P0703-000030A		1
3	P01-000040A		1
4	30312050		1
5	PJ12050A		1
6	P02-0303200		1
7	PJ100600		1
8	PJ101500		1
9	PJ100300		1
10		**IN 4.2(1)ELECTRIC PARTS LIST**	
11	P01-0452000	1.65M(2000KG)	1
	P01-051030A	1.8M(2000KG)	1
12	P01-044060A		1
13	P01-0440400		1
14	**P0502-0000600**	1HP,4P,1/50,12SV	1
15	PJ100500		2
16	KA1102310		1
17	11314200		1
18	11301700		1
19	30302030	6203ZZ	2
20	PJ101000		1
21	PJ101100		1
22	P06-0003410		14/18
	P02-0007000		(1.65M/ 1.8M)
23	P0902-0007100	1.65M	1
	P0902-0008500	1.8M	1

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6.2 TOWER

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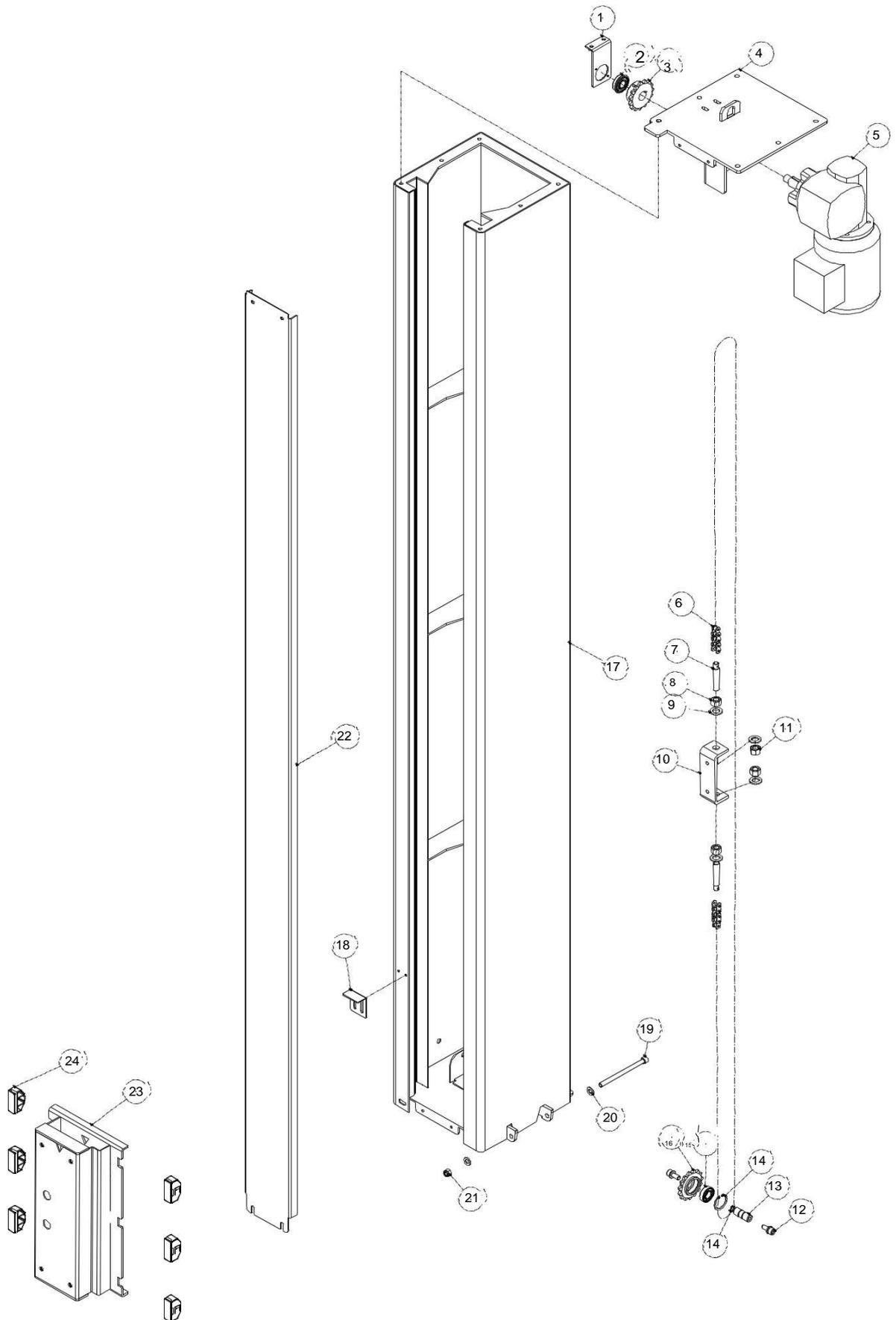
PART LIST

KEY NO	PART NO	DESCRIPTION	Q'TY
1	P01-0441100		1
2	3030202N	6202-2NR(CWB)	1
3	P0702-0009500		1
4	P01-0443200		1
5	P0502-0003100	40 50VEG1 1/2HP 3PHASE AC220V/380V 1/50	1
6	P0901-0011900	2.4M, #40*360	1
	P0901-0012200	3M, #40*462	1
7	PA312500		2
8	10301200		2
9	10501200		4
10	PD200800		1
11	10330600		2
12	10250820	M8x20L	2
13	P02-0289000		1
14	11313500		1
15	30300020	6002ZZ(CWB)	1
16	PJ201300		1
17	P01-0507300	2.4M	1
	P01-0510400	3M	1
18	P01-0458900		1
19	101008A2	M8x120L	1
20	10500800		2
21	10330800		1
22	P01-0510100	2.4M	1
	P01-0510500	3M	1
23	P01-044090A		1
24	P06-004730A		6

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6.3   ELEVATOR

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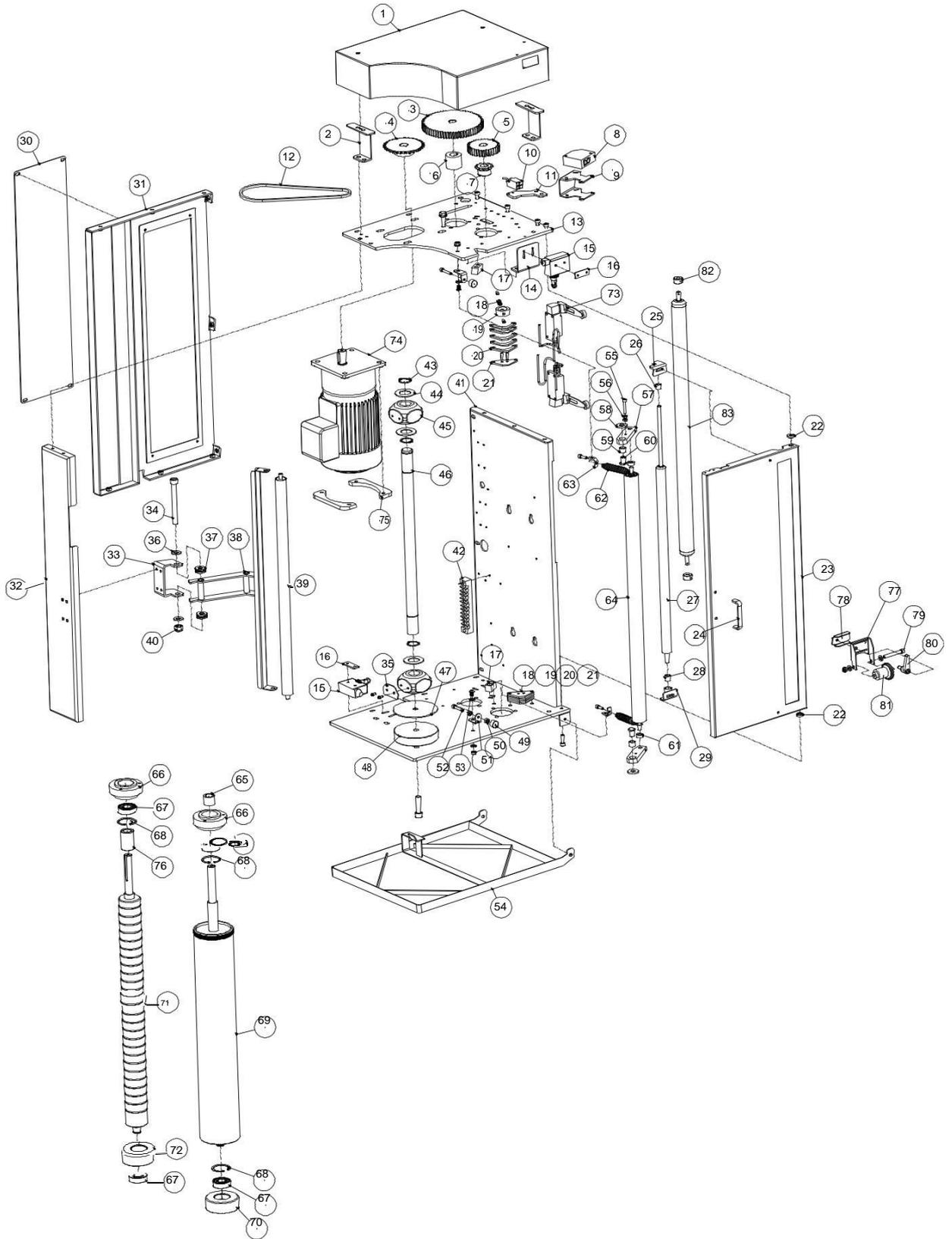
PART LIST

KEY NO	PART NO	DESCRIPTION	Q'TY
1	P01-0443300		1
2	P01-0443400		2
3	P06-004780A	300%	1
	P06-0052700	200%	1
4	P06-0047600		1
5	P06-0047700	300%	1
	P06-0052800	200%	1
6	P06-0049900		1
7	PJ303100		1
8		**IN 4.2(1)ELECTRIC PARTS LIST**	
9	P01-042170A		1
10		**IN 4.2(1)ELECTRIC PARTS LIST**	
11	P01-0453600		1
12	3240S352	#35x57	1
13	P01-044370B		1
14	P01-0443600		1
15		**IN 4.2(1)ELECTRIC PARTS LIST**	
16	PJ308600		2
17	PB202900		2
18	PB206400		2
19	PB206300		2
20	PB206100		10
21	PB206200		2
22	PB204100		2
23	P01-0444000		1
24	PA315200		1
25	P01-0444100		1
26	3034HK03	HK0810	1

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PART LIST

KEY NO	PART NO	DESCRIPTION	Q'TY
27	P08-000160A		1
28	3034HF08	HF0812	1
29	P01-044420A		1
30	P01-0452800		1
31	P01-044380A		1
32	P01-0444700		1
33	P01-001350A		1
34	101110A1	M10x110L	1
35	P01-0441400		1
36	HA010S	M10x20x2t	2
37	30371100	51100	2
38	P01-044480A		1
39	PB20550B		1
40	10331000		1
41	P01-044390C		1
42	P0304-010005600		1
43	11312400		3
44	P01-0441500		3
45	P06-004750A		2
46	P02-0288200		1
47	P06-0048300		1
48	P02-028830A		1
49	CE401000		2
50	10300500		4
51	P01-0452300		2
52	10100530	M5*30L	2
53	10170620	M6x20L	2
54	P01-0444600		1
55	10100530	M5*30L	1
56	10300500		2
57	P02-000490A		2

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PART LIST

KEY NO	PART NO	DESCRIPTION	Q'TY
58	PB202500		2
59	3034HK02	HK1010	2
60	PB202700		2
61	3E-02000-270		2
62	PB202800		2
63	PB202800-02		2
64	PB206500		1
65	P06-0047900		1
66	P02-0288400		3
67	30302030	6203ZZ(CWB)	4
68	11314200		3
69	P08-000400B		1
70	P02-0295200		1
71	PJ301410		1
72	P02-0288500		1
73		**IN 4.2(1)ELECTRIC PARTS LIST**	
74	**P0501-0014300**	**SV-A10-1/4A020 1/4HP, 3-PH AC220V/380V**	1
75	PJ311400		2
76	P06-004800A		1
77	P01-0457100		1
78	P01-0457200		1
79	10100860	M8x60L	1
80	91280002		1
81	P06-0052400		1
82	PB202100		2
83	P08-000120C		1

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6.4 CONTROL BOX

PART LIST FOR TMD-P46P

KEY NO	PART NO	DESCRIPTION	Q'TY
1	P01-045560A		1
2	P01-0512300		1
3	P01-0512200		1
4	PD400520		2

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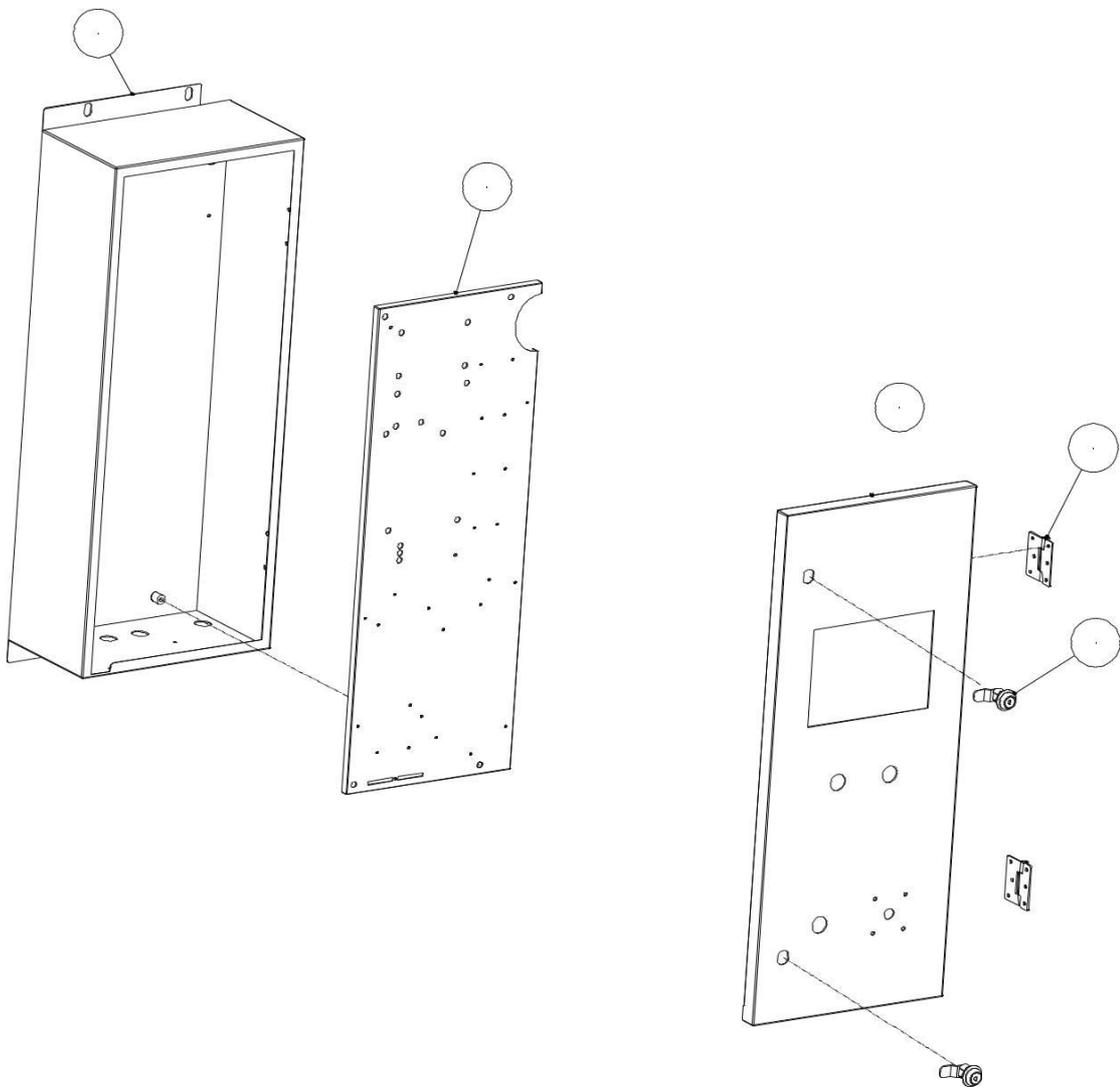
7. RECOMMENDED SPARE PART.

PART NUNBER	DESCRIPTION	QTD
P02-000700A	SUPPORTING PLASTIC WHEEL SHAFT	12
P0311-060001210	LINIT SWITCH	1
P0312-010000100	POWER LAMP	1
P06-0003410	SUPPORTING WHEEL	12
P06-004730A	SLIDING BLOCK	6
P0902-0007400	BELT BX-144(1.65M)	1