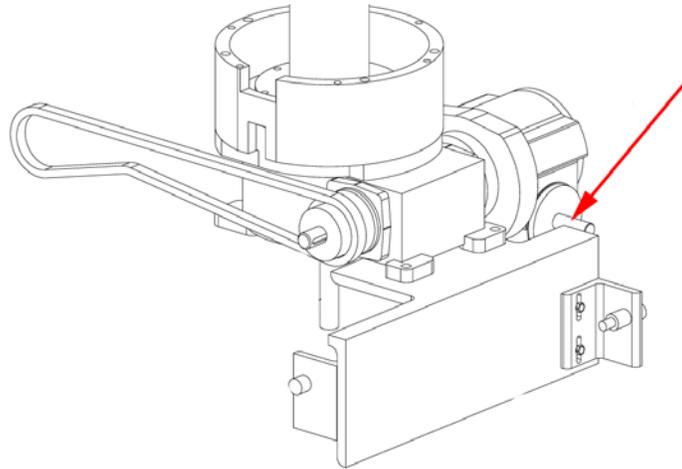
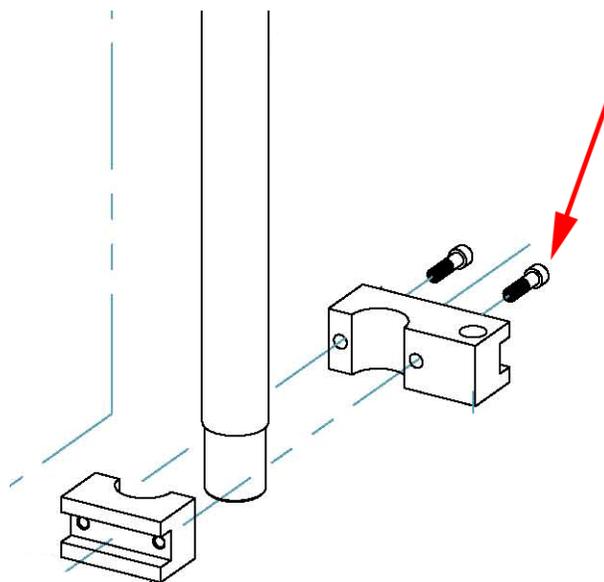


# Heat Seal Alignment Procedures

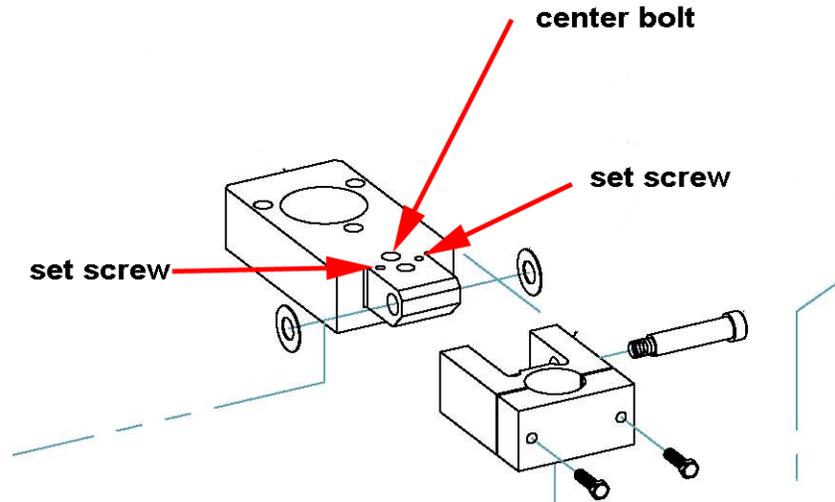
1. Ensure that Heater Head is cool and the machine is powered off and unplugged.  
**Note: Do not attempt this procedure if the heat seal surface is warmer than the room's ambient temperature.**
2. Remove Heater Head Safety cover.
3. Remove Left Side lower panel
4. Insert Camco Indexer Wrench over the unused shaft of the Camco Indexer.



5. Manually Turn the Camco Indexer Wrench counter-clock wise to advance the table until the table stops turning.
6. Manually turn the Camco Indexer Wrench counter-clock wise an additional 12 turns. This puts the machine into the center of the dwell cycle.
7. Loosen one of the Socket head bolts on the cam yoke half (005-0424 & 005-0425 under BOM 101-005-0003) under the table.

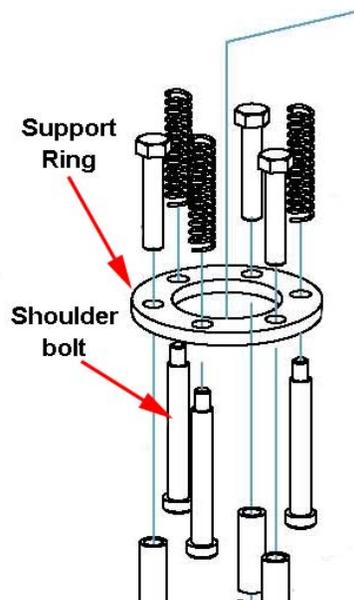


8. With the shaft now loose (it should be able to swivel left and right and lift up and down) raise the heater head assembly and then manually pull the table out of detent (home position). Lay the heater head assembly down to rest on the flat surface on the dial plate.
9. Verify that the heat ring surface is level and flat with the surface of the dial plate.
  - a. If it is not level and flat then loosen the center bolt over the heat seal plate (005-0535 on BOM 101-005-0003)



- b. Use the set screws to level the heat seal surface with the flat surface of the dial plate.
  - c. After leveling, tighten the center bolt. Recheck the level.
10. With the heat seal surface level with the table, lift the heat seal assembly and rotate the table back into detent (home position).
11. Apply the setting ring around the O.D. of the heat seal ring surface.
 

**NOTE: Do not attempt to place the setting ring around the heat seal ring if the heat seal ring is still hot! This will melt the setting ring.**
12. Guide the heater head into the dial plate cup pocket.
13. Once the heater head is resting comfortably into the dial plate pocket, Apply pressure to the top of the heater head assembly. (As you apply pressure you should see the springs compress and the heads of the shoulder bolts going through the springs should drop below the support ring (005-0452 on BOM 101-005-0003).



- 14.** With a gap between the shoulder bolts and the support ring, insert the heat seal setting shims in between the head of the bolt and the support ring.
- 15.** With the setting ring in place and the heat seal surface down into the cup pocket of the table the heat seal surface should now be centered over the pocket.
- 16.** With the shims in place the pressure should be set.
- 17.** Tighten the Socket head bolt on the cam yoke half (005-0424 & 005-0425 under BOM 101-005-0003) under the table that you loosened earlier.
- 18.** Double check that the other bolt is also tight. If both bolts are tight the table should no longer be able to move up or down.
- 19.** Manually turn the Camco Indexer Wrench clock wise until the heater head reaches its highest point above the table.
- 20.** Remove the 3 shims from between the heads of the shoulder bolts and the support ring.
- 21.** Make sure the table is still in detent.
- 22.** Double check all your work to make sure that nothing has been left loose.
- 23.** Manually index the table, with the Camco Indexer Wrench, through all six pockets to ensure that everything clears.
- 24.** Reattach all safety devices and covers.