

FORMAX[®]

AutoSeal[®]

FD 2006IL / FE 2006IL

FI / FJ Series

MAINTENANCE / PARTS MANUAL
First Edition

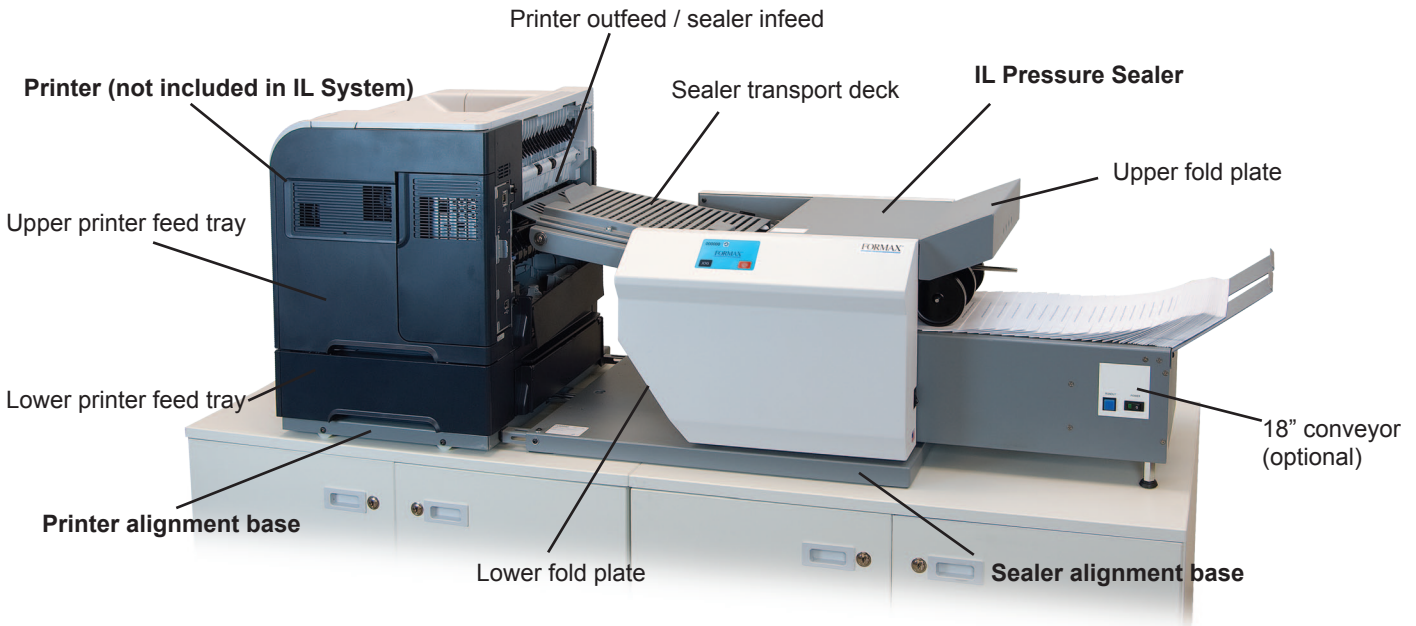
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DESCRIPTION

With the Formax FD 2006IL AutoSeal System operators can print, fold and seal all in one streamlined process. One-piece pressure sensitive forms are loaded into an existing laser printer where they're printed and fed directly into the IL Pressure Sealer where they're folded, sealed and output as a mail-ready piece.

FD 2006IL System



SPECIFICATIONS

Printer Compatibility:	Kyocera FS4200 / P3055 (requires FD 2000-46IL riser), w/one optional 500-sheet tray OKI B512 Laser Printer (requires FD 2000-47IL riser) OKI B721 / B731 (requires FD 2000-49IL riser) Consult your Formax dealer for an updated list of additional laser printers which are compatible with the FD 2006IL System.
Speed:	Printer dependent
Paper Size:	Up to 8.5" W x 14" L
Duty Cycle:	Up to 50,000 pieces per month
Power Requirements:	FD Model: 120 Volts AC, 50/60 Hz FE Model: 220 Volts AC, 50/60 Hz
Dimensions (closed) **:	19" W x 46" L x 23" H
Dimensions w/18" Conveyor (closed):	19" W x 65" L x 23" H
Tabletop Area Required:	20" W x 43" L
Tabletop Area Required w/18" Conveyor:	20" W x 69" L
Dimensions with Cabinets and 18" Conveyor:	20" W x 74" L x 48" H

** Dimensions include IL Pressure Sealer and IL Alignment Base.

UNPACKING

1. Check package for shipping damage. If there is shipping damage do not discard the box.
2. CAUTION: Two people must lift the Pressure Sealer out of the box.
3. Package should contain the IL Pressure Sealer and two piece IL Alignment Base.

SETUP

Alignment Base Setup

1. Place two parts of alignment base face up. (Figure 1).

Connecting slider

Alignment Base, Pressure Sealer Section



Fig. 1

Alignment Base, Printer Section

2. Extend connecting slider and slide into slot on sealer section of base, lining up the screw holes with the holes in the top of the base (Figure 2).

Insert the leading two screws first, do not tighten down at this point.

Align third screw hole in the slider with the top cover and insert screw.

Tighten all three screws into place.



Fig. 2

Sealer Setup

1. Align the 2006IL with the pins located on the alignment base and lower into position. (Figure 3)

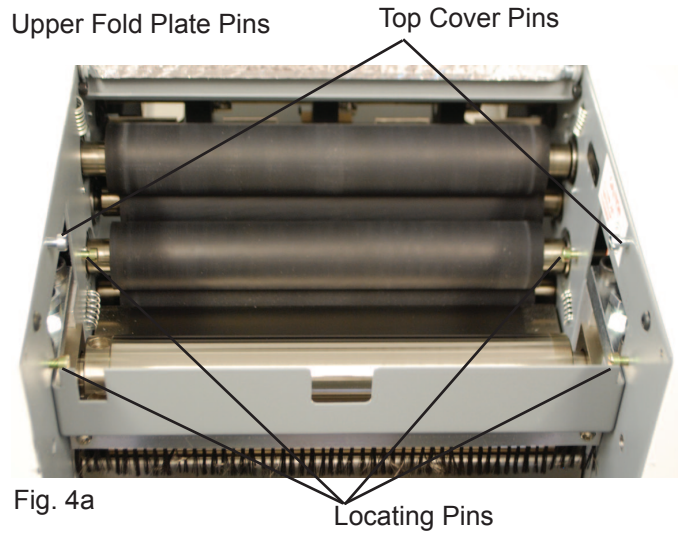
Caution: Two people should lift and lower the 2006IL.



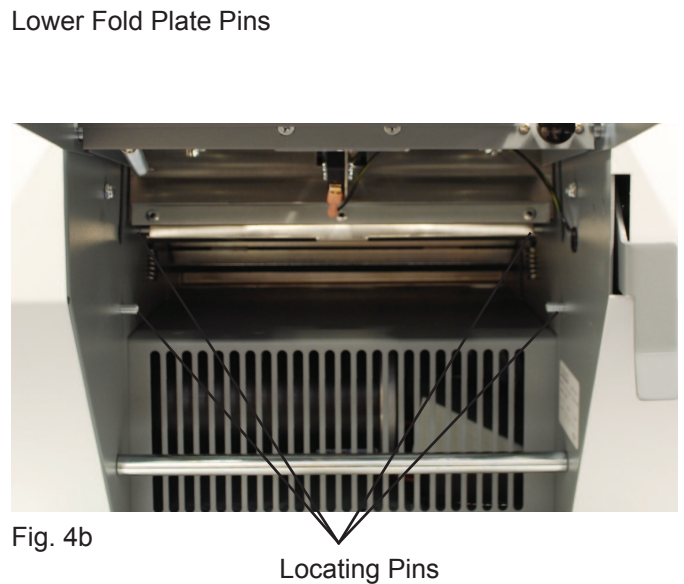
Fig. 3

Installing Upper and Lower Fold Plates, and Power Cord

1. Be sure the plate sets firmly on the locating pins (Fig 4a & 4b). Lift the top cover and slide the upper fold plate under the top cover pins onto the fold plate pins. Push down on the fold plate to lock it in position.



2. The lower fold plate is installed under the in-feed deck. Slide the bottom fold plate up and in until it meets the rear locating pins then push down to set in place.



3. Plug the power cord into the left receptacle on the back side of the machine (Fig 4c).



PRINTER ALIGNMENT BASE SETUP

The Printer Alignment Base comes with two sets of alignment pins.

The pins at the top in the photo below are used with the FD 2000-46IL and FD 2000-45IL risers for HP/Troy P2015 and Lexmark/Source T640 printers. The printer is then set on top of the riser, using the pins located on the riser itself (see page 5, figures 7a and 7b).

The left pin can be adjusted to properly align the riser and printer with the sealer.

1. Loosen the left pin using an adjustable wrench to hold the pin while using a 7/16" socket to loosen the nut.
2. To move the front outfeed corner of the printer forward toward the front edge of the alignment base, slide the pin forward.
3. To move the front corner of the printer back away from the edge of the alignment base, slide the pin backward. The printer will pivot on the right alignment pin (Fig. 5).

The bottom pins shown in Fig. 5 are used with HP/Troy P3005 printers. In this application, the top pins should be removed.

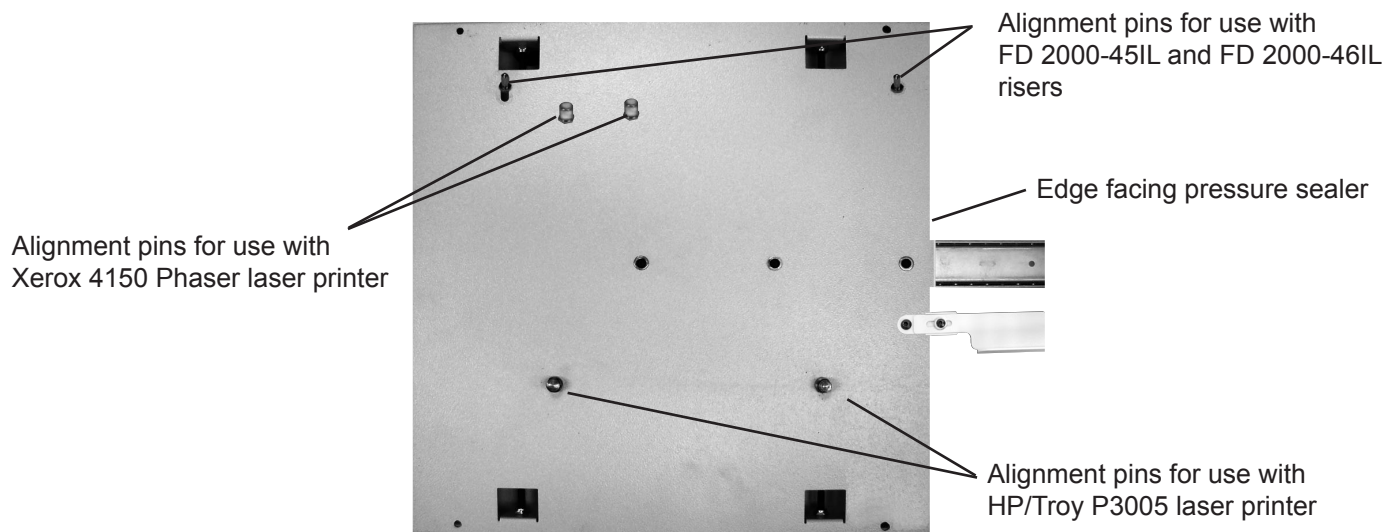


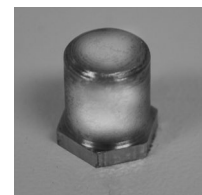
Fig. 5



Alignment pins for use with
FD 2000-45IL and FD 2000-46IL risers



Alignment pins for use with
HP/Troy P3005 laser printer



Alignment pins for use with
Xerox 4150 Phaser laser printer

Printer Setup: HP/Troy

1. Remove back door from the printer. Lower door, depress the side tabs to release and carefully pull the door out (Fig. 6).

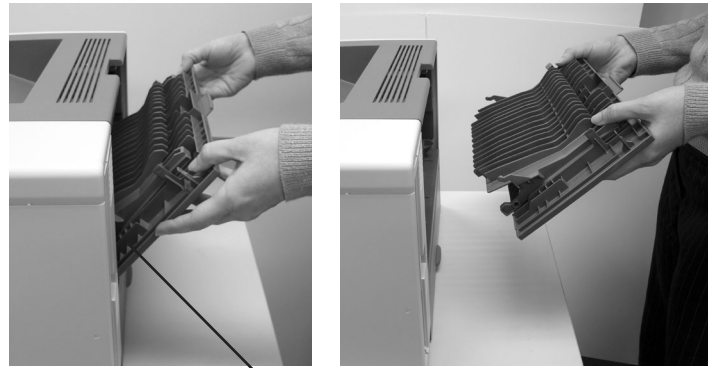


Fig. 6

Side tabs

Printer Setup: HP/Troy P3005

NOTE: Refer to page 4 for correct alignment pin placement based on your printer.

First align bottom feed tray with the pins on the printer alignment base and lower into position. Then align printer with the bottom feed tray pins and lower into place. (Fig. 7a)

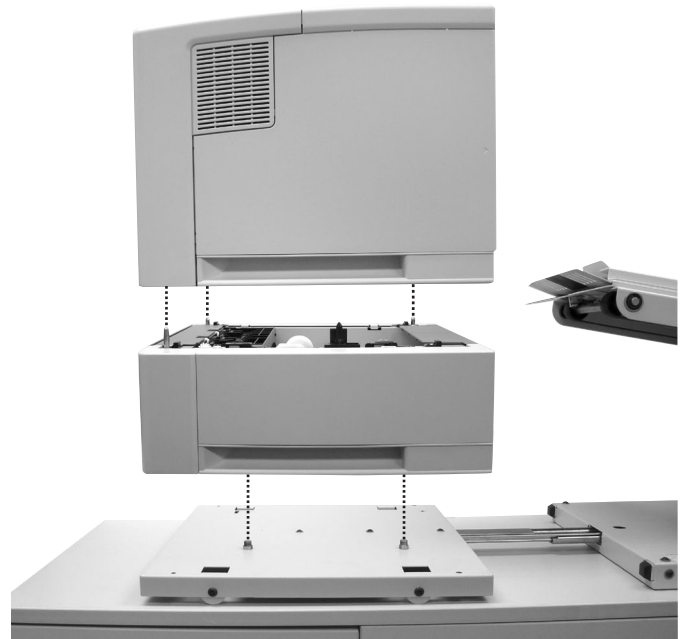


Fig. 7a

Printer Setup with Riser:

HP/Troy P2015 (use riser FD 2000-45IL)
Lexmark/Source T640 (use riser FD 2000-46IL)

NOTE: Refer to page 4 for correct alignment pin placement based on your printer.

Place riser on printer alignment base, with side opening facing right toward pressure sealer, matching alignment pins. Place printer on riser, matching alignment pins. (Fig. 7b)

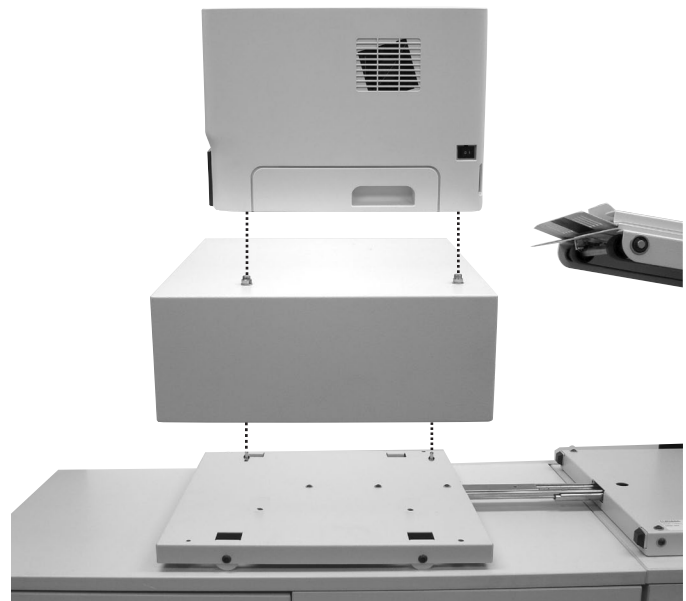


Fig. 7b (shown with HP/Troy P2015 laser printer)

Alignment Base Stoppers

The alignment base stoppers are used to keep the printer from making contact with the sealer infeed. The exit rollers of the printer and the sealer infeed throat should not come into contact during operation. There should be a gap of approximately 1/8" between the rollers and the sealer infeed throat.

1. Slide the printer up to the sealer infeed throat so that there is approximately a 1/8" gap between the printer outfeed and the sealer infeed throat. Using a 1/8" standard allen wrench, loosen the locking pin of each alignment base stopper. (Fig. 8)

2. Pull the stopper out from the pressure seal alignment base until it meets the edge of the printer alignment base, being sure to maintain the gap between the printer outfeed and the sealer infeed. (Fig. 9a & 9b)

3. Using the allen wrench, tighten both locking pins to hold the stopper into place. (Fig. 10) Now it's possible to slide the printer away from the 2006IL infeed throat and back into place without having to reset the position.

Repeat with the second stopper.



Fig. 8
Alignment base stopper Locking pins



Fig. 9a



Fig. 9b

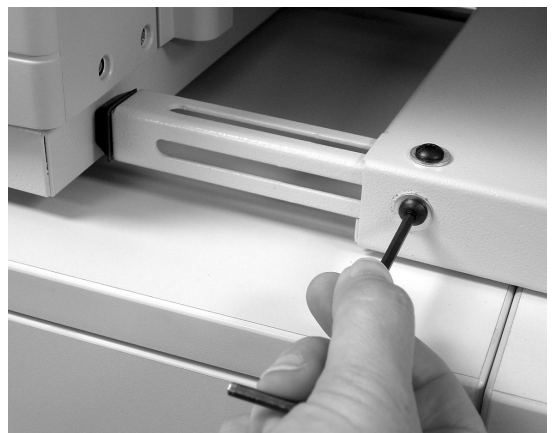


Fig. 10

Installing Optional Conveyor (additional instructions on page 37)

1. Assemble the conveyor. Attach the extension tray to the end of the conveyor using the three extension tray mounting screws (Fig 11a).



Fig. 11a

Mounting Screws

2. Insert power cord to receptacle on the underside of the conveyor (Fig 11b)



Fig. 11b

3. Remove catch tray and install the mounting shoulder bolts into the two screw holes (Fig 11c).



Fig. 11c

Shoulder Screws

4. Open the top cover of the sealer and remove the top fold plate. Then slide the conveyor into position aligning the keyholes on the back of the conveyor with the shoulder screws, slide in and down to lock into position.

5. Install the out-feed nip wheels into the two holes located at the out-feed of the sealer (Fig 11d). Insert the side of the rod with the spring first, push in and then insert the other side. Reinstall the top fold plate and close the top cover.

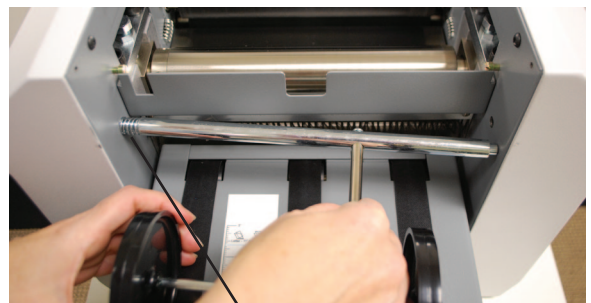


Fig. 11d

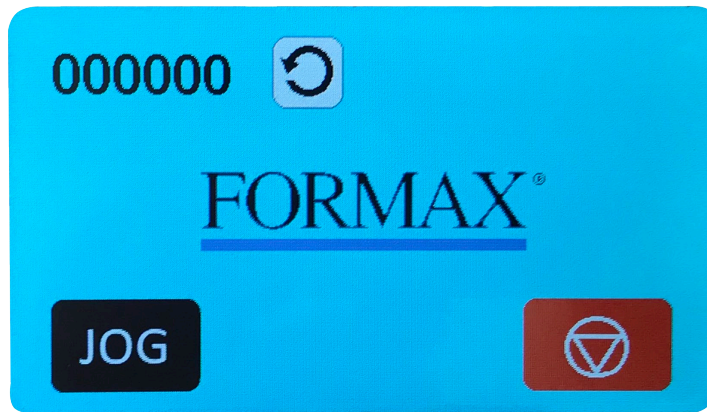
Spring




6. Plug the conveyor into the right receptacle on the back of the 2006IL (Fig 12).



Fig. 12

CONTROL PANEL



Stop Icon		Stops the sealer.
Jog Icon		Allows one form to feed at a time. Used for setting paper folds.
Counter Reset Icon		Resets the counter.
Counter		Shows the number of forms processed.

OPERATION

1. Place power switch in the “ON” position on both the sealer and the printer.
2. After determining the fold type (see pg 12 “Determining Fold Type”) set the Upper and Lower fold plates.

To set the fold stop position, squeeze the fold stop lever and move the fold stop to the desired location on the upper and lower fold plates (Fig 13). Align the pointed part of the stop plate with the desired marks on the decal and release the lever. Fine adjustments can be made with the adjustment knob at the end of the plate (Fig 14).

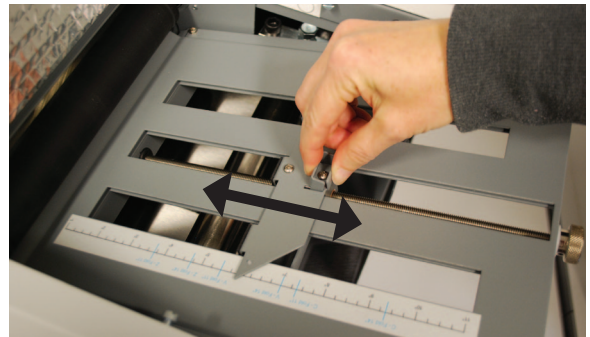


Fig. 13



Fig. 14

NOTE: When doing a “Half” fold, remove the bottom fold plate, turn it 180 degrees and insert with the fold deflector leading (Fig 15). The plate must be firmly reinstalled on the locating pins.

- 5a. Set the catch tray (See step 16b if using a conveyor). Slide the catch tray in or out to align the appropriate fold/form setting on the “Fold/form size decal” with the alignment decal located on the non-operator side frame (Fig 16a).
- 5b. Set the conveyor out feed wheels. Align the center of the out-feed stacker wheels with the appropriate fold/form setting on the “Fold/form size decal” (Fig 16b).



Fig. 15 Fold Deflector

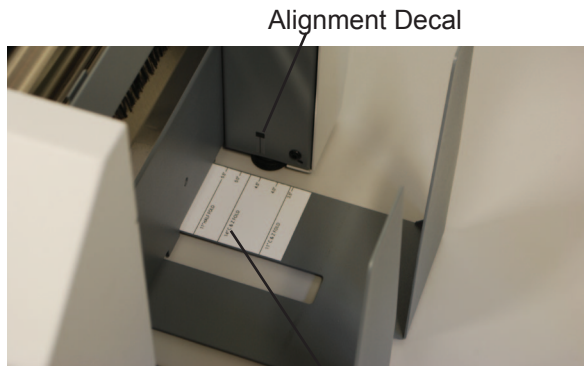


Fig. 16a Alignment Decal
Fold/Form Size Decal

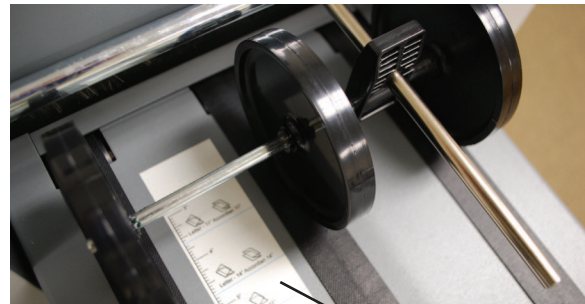


Fig. 16b Fold/Form Size Decal

- 6. Place pressure seal forms in printer paper tray. Paper should be loaded into the approved printers face down with the glue edge trailing.

Locate the paper orientation guide on the printer and load accordingly (Fig. 17). The print side glue edge is considered the top of the document.

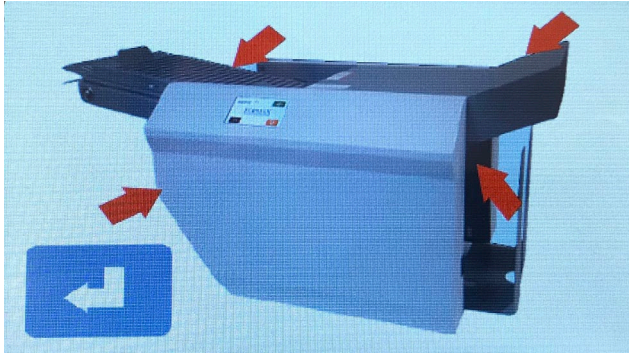
Once forms are loaded perform an offline print test to make sure the printer and sealer are aligned properly. If the print test is satisfactory begin online operation.




Fig. 17 Printer Paper Orientation Guide

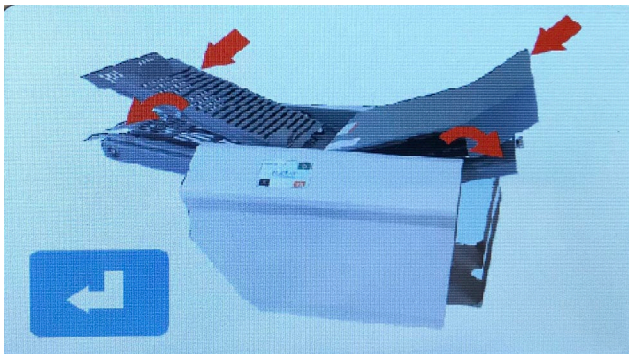
ERROR SCREENS


Paper Mis-Feed / Paper Jam



A mis-feed has occurred. Reset the stack of paper in the in-feed and press the “” icon to resume operation. A Paper jam has occurred in one of the areas indicated. Turn the folder to the off position and unplug. Check the area indicated for paper and remove. Replace the fold plates and plug the folder in and the power on.

Cover Open



The top cover is open. Close the top cover and press the “” icon to resume operation.

NORMAL OPERATING CONDITIONS

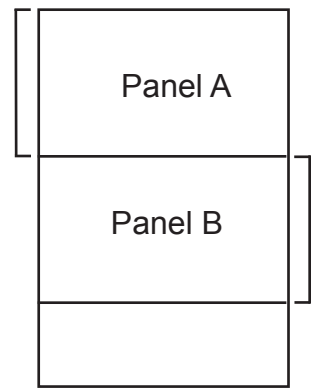
1. *Steam may be present when the form comes out of the printer and enters the sealer transport deck.* This is a normal operating condition if the transport deck is cool when operation begins. The steam should go away after 5 - 10 forms run through the system allowing the transport deck to warm up.

2. *Moisture present on the transport deck.* When forms are printed moisture is released from the forms. Due to the enclosed IL system setup the moisture is present on the transport deck; it should lessen as the transport deck warms up. Environmental conditions may also affect the amount of moisture present.

SETTING CUSTOM FOLDS

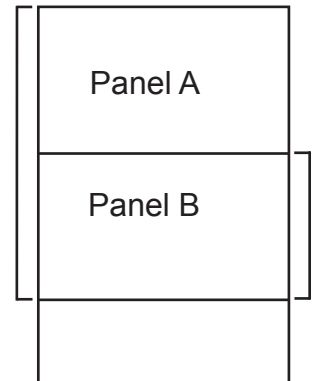
Example 1: Uneven “Z”

1. Measure the length of panel “A”
2. Adjust the upper fold plate so that the bar lines up with the measurements of panel “A” i.e. if panel “A” is 5 1/4” long move the bar up or down so that it lines up with the 5 1/4” mark on the fold plate.
3. Measure the length of panel “B”
4. Adjust the lower fold plate so that the bar lines up with the measurements of panel “B”.
5. Refer to OPERATION on page 8.



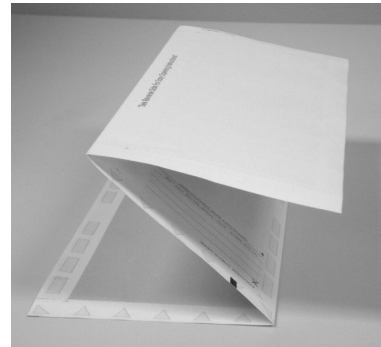
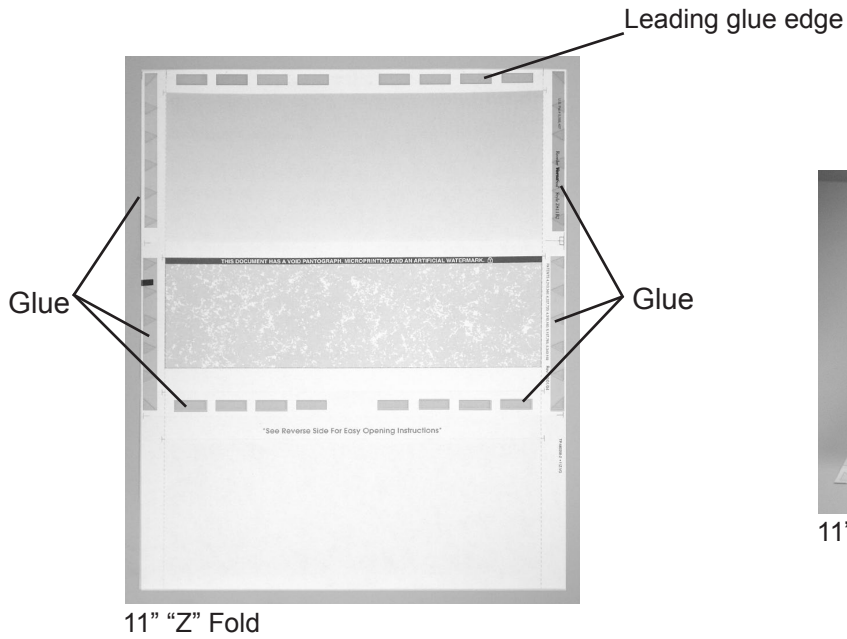
Example 2: Uneven “C”

1. Measure the length of panel “A” & “B”
2. Adjust the upper fold plate so that the bar lines up with the measurements of panel “A” & “B” i.e. if panel “A” & “B” are 10 1/2” long move the bar up or down so that it lines up with the 10 1/2” mark on the fold plate.
3. Measure the length of panel “B”
4. Adjust the lower fold plate so that the bar lines up with the measurements of panel “B”.
5. Refer to OPERATION on page 8.

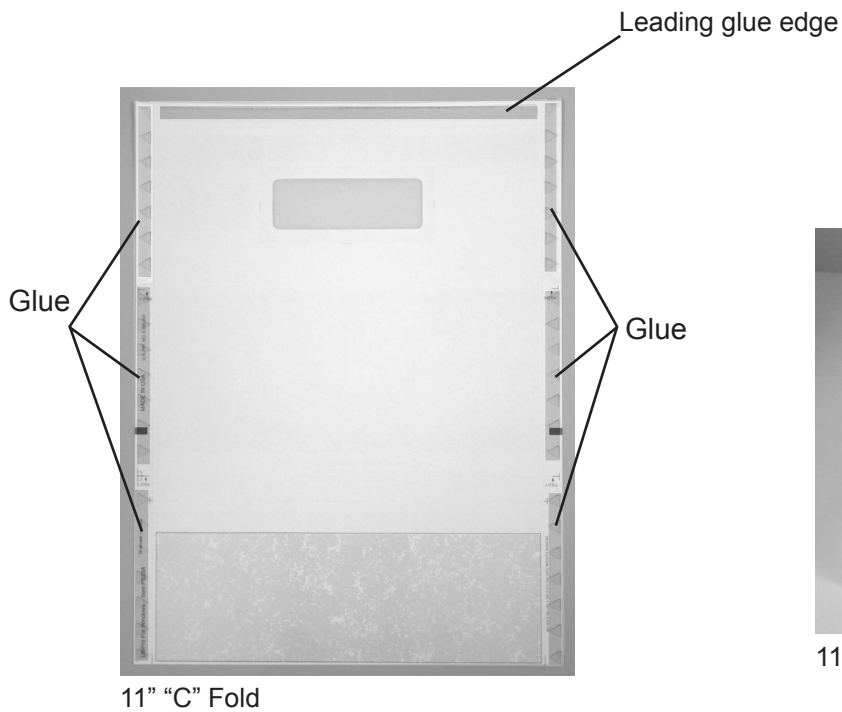


DETERMINING FOLD TYPE

Two Standard Folds: 11" "Z" & 11" "C"
Refer to page 10 for custom fold setup.



11" "Z" Fold



11" "C" Fold

Leading Edge



Make copies of this page on copy paper for fine tuning folds

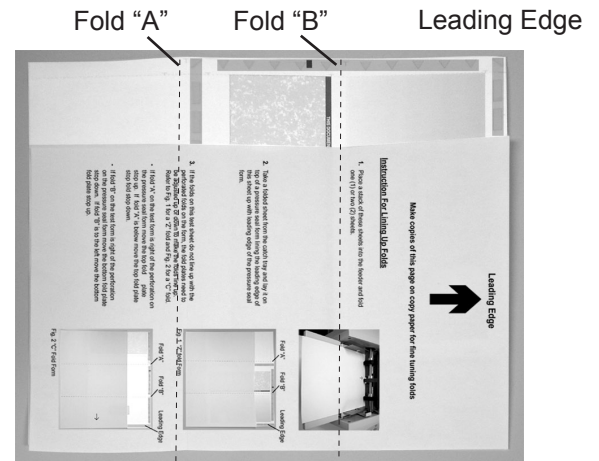
Instruction For Lining Up Folds

1. Place a stack of these sheets into the feed tray and fold one (1) or two (2) sheets.

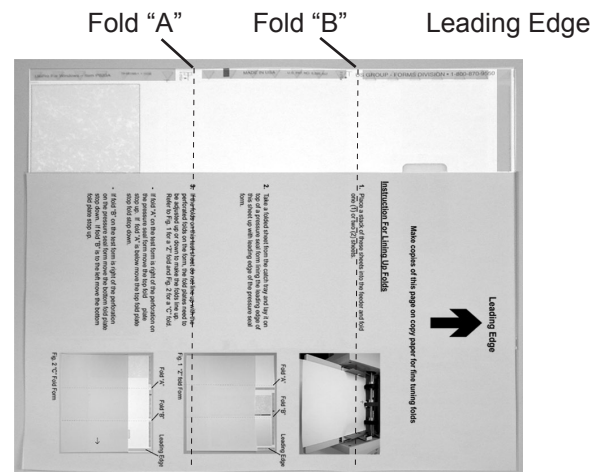
2. Take a folded sheet from the catch tray and lay it on top of a pressure seal form lining the leading edge of this sheet up with leading edge of the pressure seal form.

3. If the folds on this test sheet do not line up with the perforated folds on the form, the fold plates need to be adjusted up or down to make the folds line up. Refer to illustrations at right for "Z" fold and "C" fold.

- If fold "A" on the test form is right of the perforation on the pressure seal form move the top fold plate stop up. If fold "A" is below move the top fold plate stop fold stop down.
- If fold "B" on the test form is right of the perforation on the pressure seal form move the bottom fold plate stop down. If fold "B" is to the left move the bottom fold plate stop up.



"Z" fold Form



"C" Fold Form

TROUBLESHOOTING

TROUBLE	POSSIBLE CAUSE	REMEDY
Control panel is not illuminated.	<p>No power at the wall outlet.</p> <p>No power to the machine inlet.</p> <p>No power to the control panel.</p> <p>Internal electrical failure</p>	<p>Check wall outlet.</p> <p>Check power cord for frayed/broken wires.</p> <p>Press the black breaker reset button located on the backside of the sealer, (see page 15, Fig. 19).</p> <p>Call for service</p>
Sealer does not turn on when the form enters the throat of the sealer transport deck.	<p>Sealer is not turned on</p> <p>Sealer reset button has not been pressed after a paper jam</p> <p>Sealer breaker has popped</p> <p>Photo eye is not detecting the form</p>	<p>Check that the sealer is plugged in and turned to the on position.</p> <p>Press the “fault reset” button to reset the sealer</p> <p>Press the black breaker reset button located on the backside of the sealer, (see page 15, Fig. 19).</p> <p>Wipe sensor with dry cloth.</p> <p>Call for service.</p>
Forms are misfolding.	<p>Fold plate is not set properly</p> <p>Fold plates are not inserted correctly.</p> <p>Piece of paper or other material is stuck in the fold plate</p>	<p>Check to make sure the fold stop “bar” aligns with the correct fold setting on each fold plate. (See pages 8-9.)</p> <p>Fold plates may need to be moved up or down if the fold varies from the standard fold setting indicators.</p> <p>Remove and reinstall fold plates. Be sure they’re properly positioned.</p> <p>Remove object from the fold plate.</p>
“Cover Open” Error screen displayed.	<p>Cover is open</p> <p>Magnetic switch is broken.</p>	<p>Check that all covers are closed.</p> <p>Call for service.</p>

TROUBLESHOOTING

<p>Custom fold is misfolding</p>	<p>Wrong fold is selected</p> <p>Fold plates are not inserted correctly.</p> <p>Piece of paper or other material is stuck in the fold plate.</p> <p>Fold plate is not set properly</p>	<p>Check to make sure the fold “bars” line up with the correct fold settings. See page 10 for Custom Fold Settings.</p> <p>Remove and reinstall fold plates. Be sure they’re properly positioned.</p> <p>Remove object from the fold plate.</p> <p>Check that the fold settings match the actual fold lengths, (see page 10).</p>
<p>Paper Mis-feed/ Paper Jam LED is displayed</p>	<p>Paper misfeed between printer outfeed and sealer infeed</p> <p>Paper jammed in pressure sealer infeed deck</p> <p>Paper jammed at steel sealer rollers.</p>	<p>Slide printer back to gain access to the printer outfeed and remove forms. Lift top cover of printer, remove toner cartridge and remove forms. Reinstall toner, close printer cover, slide printer back into position and press the “fault reset” button on sealer to reset sealer.</p> <p>Slide printer back to gain access to sealer infeed. Lift transport deck cover and remove jammed document. With one hand hold transport deck, and with the other, release the transport deck release handle and slowly lower the cover back into place. (See page 15 for procedure.)</p> <p>Remove paper and press “fault reset” button, see pg 15 for clearing instructions.</p>
<p>Black marks on the folded forms.</p>	<p>Fold rollers and/or steel sealer rollers are dirty.</p>	<p>Clean the rollers with approved roller cleaner and rejuvenator.</p>
<p>Fold is skewed.</p>	<p>Printer and sealer are out of alignment.</p> <p>Transport deck belts are dirty</p>	<p>Check to be sure the printer and sealer are set properly on the alignment pins</p> <p>Adjust rear pin on the printer alignment base, (see pg 4 for adjustment procedure)</p> <p>Clean belts with approved cleaner</p>
<p>Transport table belts do not turn.</p>	<p>Broken drive belt, worn drive gear.</p>	<p>Call for service</p>
<p>Documents are wrinkled or crunched.</p>	<p>Fold plates are not inserted correctly.</p> <p>Piece of paper or other material is stuck in the fold plate.</p>	<p>Remove and reinstall fold plates. Be sure they’re properly positioned (see page 3).</p> <p>Remove object from the fold plate.</p>

A. Clearing paper jams from the steel pressure seal rollers:

WARNING: Turn off machine and unplug cord from its receptacle.

If a jam occurs between the metal sealing rollers open the top cover and remove the upper fold plate. Remove the jam-clearing tool (located under the top fold plate), apply the tool to the upper metal roller (Fig. 18) and turn clockwise until the paper jam is clear. (**Caution:** Do not apply excessive force or rollers may be damaged.) (**Caution:** Do not turn counter-clockwise and force the form(s) to exit the machine or the rollers may be damaged.) Remove the jammed form, return tool to holder and reinstall the upper fold plate. Reinstall cover and press the reset button.

Note: Press the black button (Fig. 19) near the power cord inlet to reset the breaker if necessary.



Fig. 18



Fig. 19

B. Clearing paper jams from the pressure seal infeed deck:

WARNING: Turn off machine and unplug cord from its receptacle.

If a jam occurs in the sealer infeed deck, slide printer back to gain access to infeed. Lift the transport deck cover (Fig. 20a) which will lock into place in the upright position. Remove jammed document.

To close, hold transport deck cover with one hand. With the other hand, slide the transport deck release handle (Fig. 20b) and slowly lower the cover back into place.

Note: Press the black button (Fig. 19) near the power cord inlet to reset the breaker if necessary.



Fig. 20a



Fig. 20b

OPERATOR MAINTENANCE

1. If toner builds up on the metal sealer rollers, clean the rollers with a lint-free cloth dampened sparingly with a mild household cleaner.
2. Clean in-feed tires and fold rollers with Formax recommended roller cleaner & rejuvenator to remove paper dust and toner. A Formax Cleaner Kit is available from your dealer. A damp cloth with water is the best alternative.

CAUTION: Do not use any chemicals other than the roller cleaner & rejuvenator or water.

METAL SEAL ROLLERS CLEANING PROCEDURE:

1. Make sure machine is turned off and unplugged.
2. Open the top cover and remove the upper fold plate to access the seal rollers (Fig. 21).
3. Using a mild household cleaner, spray a new cotton cloth until the cloth is saturated. Wipe the wet cloth in a back and forth motion and rotate the rollers by hand making sure to clean the entire surface of the seal rollers. Next use a dry cloth and wipe off excess toner. The cloth should be covered with black toner surplus from cleaning the rollers.
4. Run 10-15 sheets of blank copy paper through the folder/sealer to ensure all cleaner has been removed from the fold rollers. Running blank sheets will remove any excess residue of cleaner on the rollers.

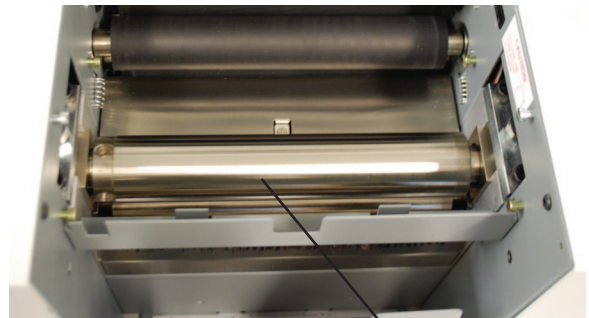


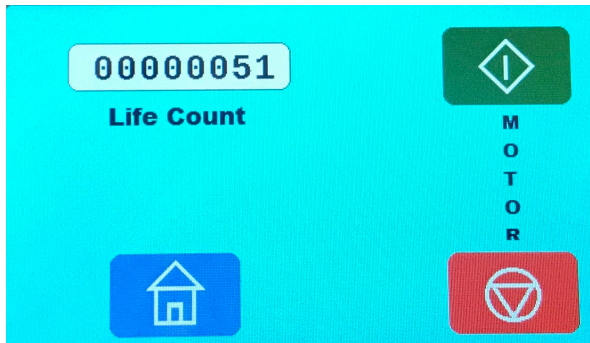
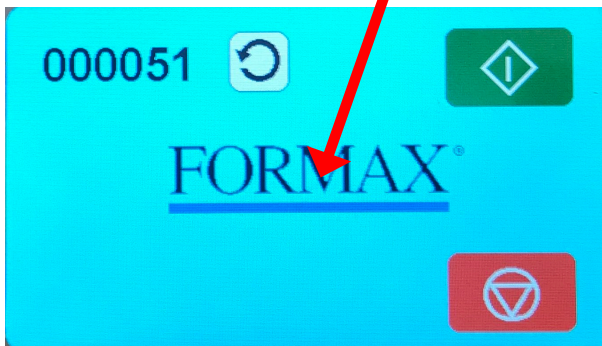
Fig. 21

Seal Rollers

SERVICE MODE

The service mode can be entered to test the motor operation and view the life count. To enter the service mode press and hold the center of the screen ("M" in FORMAX) for 10 seconds. When in service mode press the green start icon to start the motor and the red stop icon to stop the motor. To exit the service mode press the blue home icon.

Press here



Service mode screen

MAINTENANCE

SEALER ROLLER CLEARANCE

To adjust roller clearance for the steel sealer rollers, remove upper fold table, loosen locking nuts on the top plates and insert the feeler gauge (0.001") into the space between the rollers (Fig. 22). Adjust the clearance between rollers to a light drag on the high spot of the steel rollers. Tighten locking nuts on both sides while holding the adjusting bolt. Recheck and adjust as required.

NOTE: (Double-check spacing with feeler gauge. Left to right fine-tuning is required.)

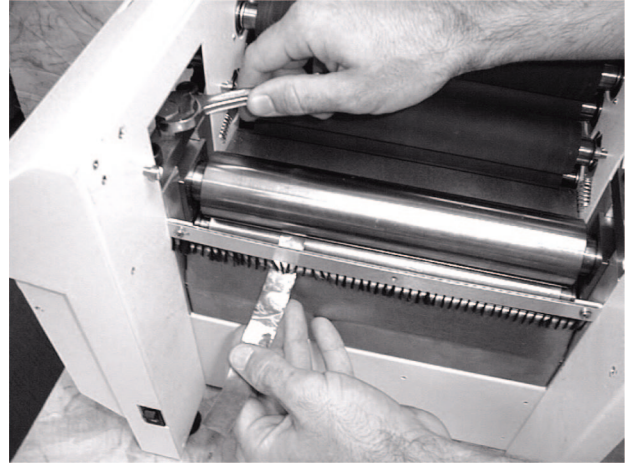
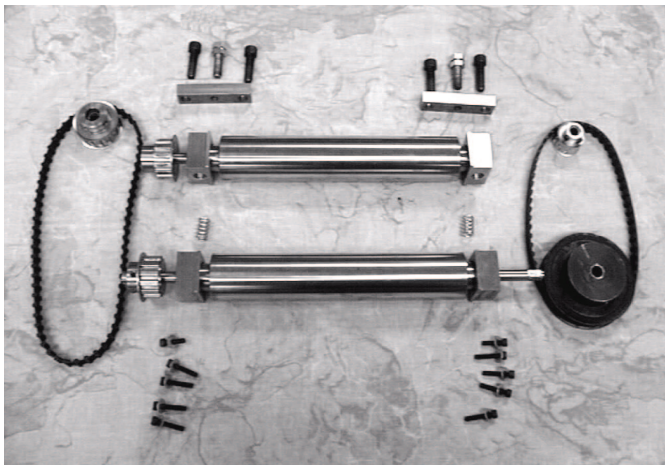


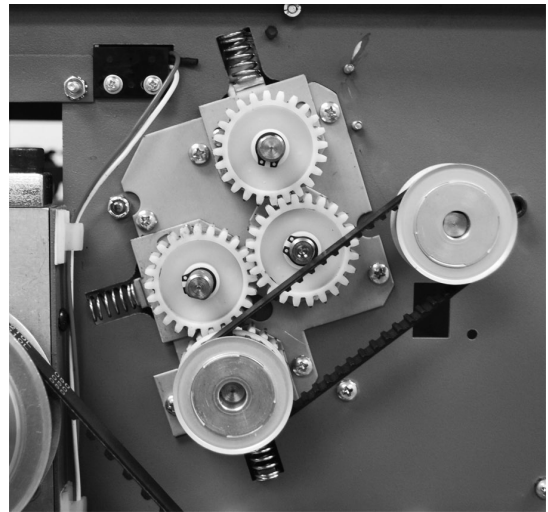
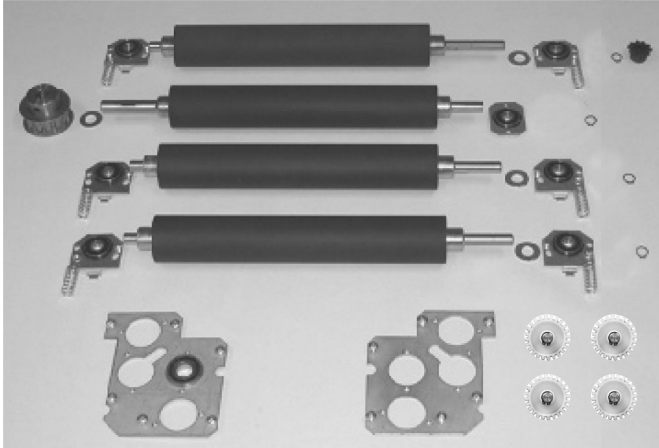
Fig. 22

SEALER ROLLER REPLACEMENT



1. Turn power off and unplug power cord.
2. Remove side covers and upper fold plate.
3. Remove belts. (See Belt Replacement, page 18.)
4. Remove top plates by unscrewing four screws.
5. Loosen or remove the five lower screws on each side.
6. Remove first roller by lifting up and out of machine.
7. Remove the two springs.
8. To remove second roller tilt stainless steel center away from roller.
9. Remove second roller the same way as the first roller.
10. To reassemble, repeat above steps in reverse.
11. Adjust belt tension. (See Belt Replacement, page 18.)

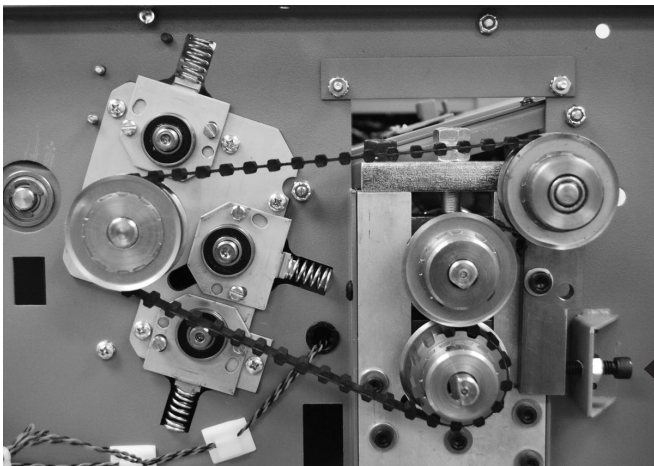
FOLDER (RUBBER) ROLLER REPLACEMENT



Non-Operator Side

1. Turn power off and unplug power cord.
2. Remove side covers and upper fold plate.
3. Remove control panel.
4. Remove belts. (See Belt Replacement, below.)
5. Remove “C” and “E” rings on gears and sprocket.
6. Remove sprocket and chain.
7. Remove plastic gears .
8. Remove bearing by unscrewing the two screws on each bearing assembly.
9. Remove the six screws for the guide panel.
10. Proceed to pull out the desired folder roller.
11. To reassemble, repeat above steps in reverse.

BELT ADJUSTMENT AND REPLACEMENT



Tighten or loosen allen screw to adjust belt

Operator Side

NOTE: Roller clearance must be set before adjusting belt tension.

To replace belt, loosen screw on the side of lever until belt is loose enough to remove.

To adjust belt first determine if belt is too tight, or too loose (belt should have no more than 5/16” play). Tighten or loosen the allen screw on the side of lever.

NOTE: Be sure not to over tighten belt, it will affect roller clearance.

PHOTO EYE REPLACEMENT - OUTPUT SIDE

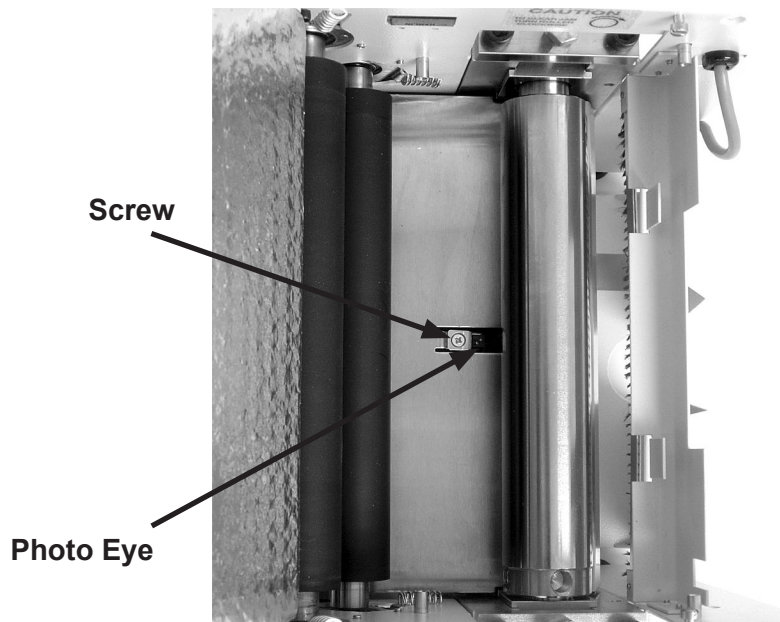


Fig. 23

1. To replace the photo eye, loosen the screw on the guide plate (Fig. 23). Carefully remove the screw and photo eye.
2. Unplug the wires and discard old photo eye.
3. Reverse the previous step to install the new photo eye.
4. Adjust the photo eye so it sits 1/8" below the guide plate, then tighten the screw to ensure the photo eye does not move.

PHOTO EYE REPLACEMENT - INFEED DECK

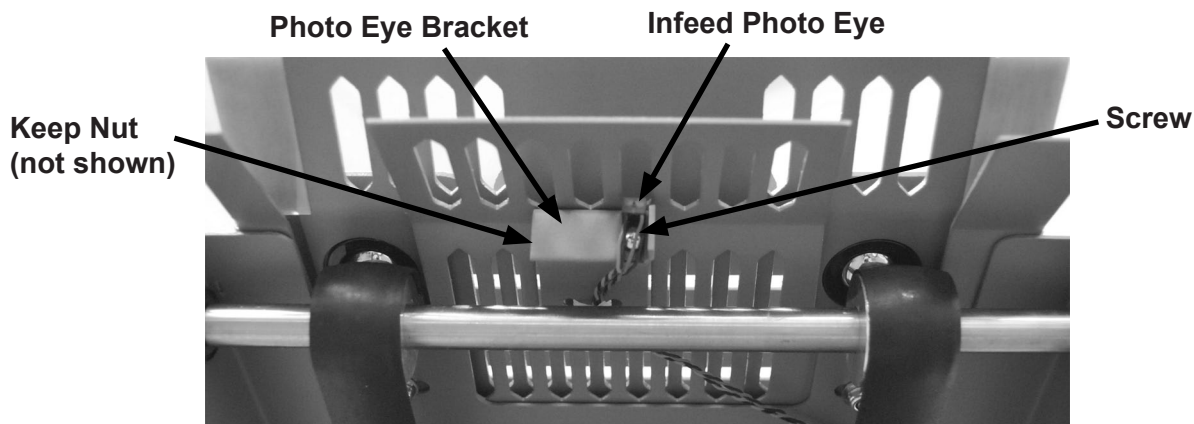
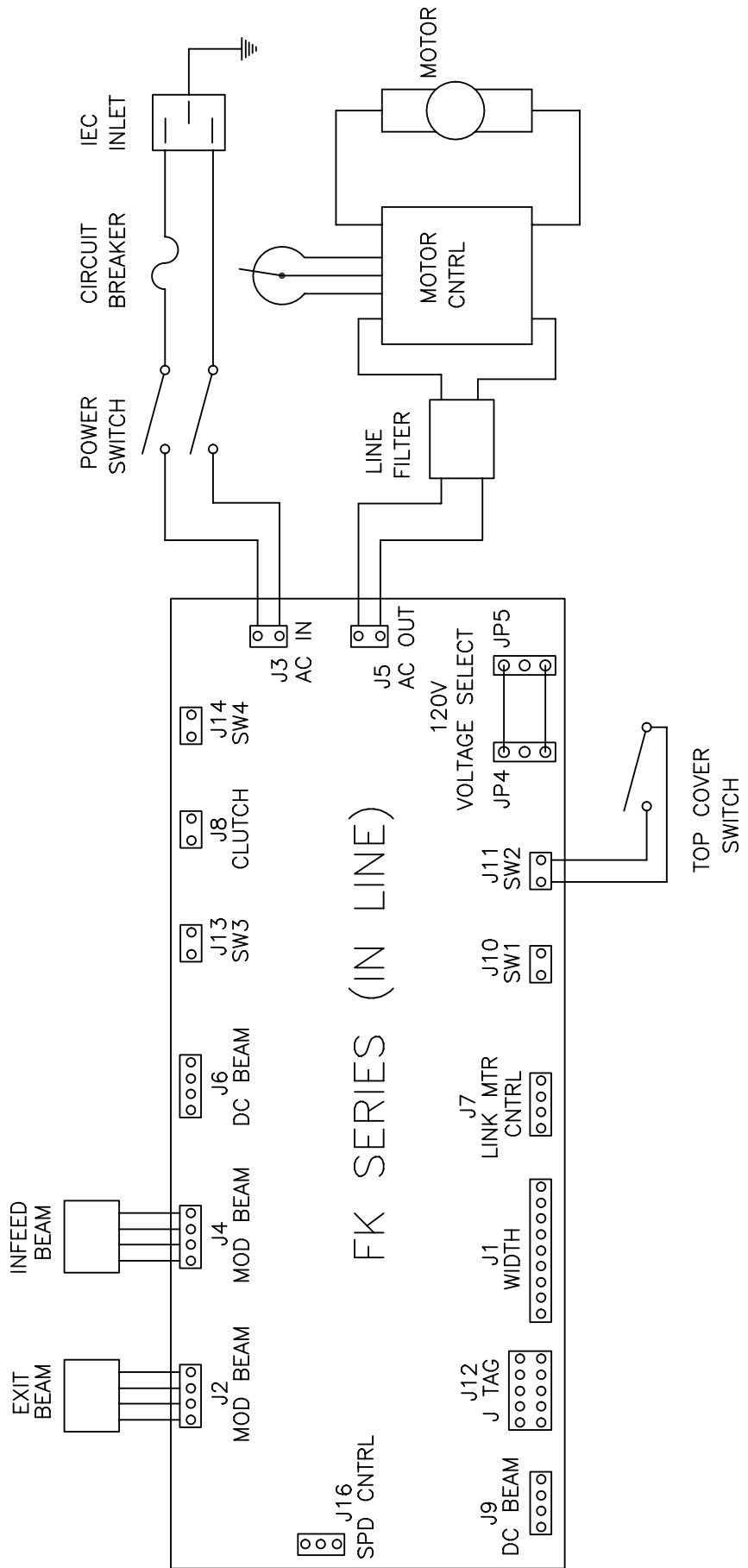
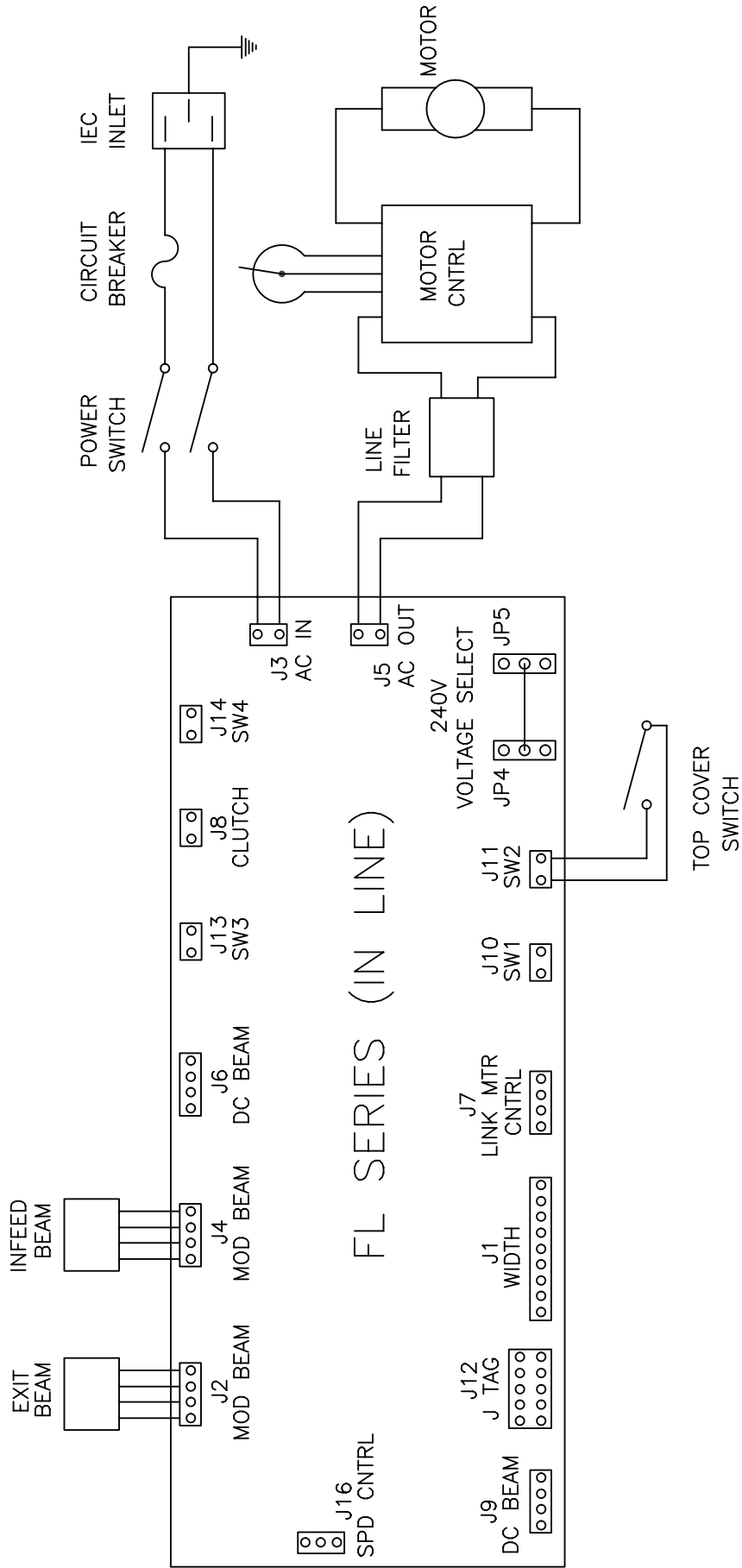


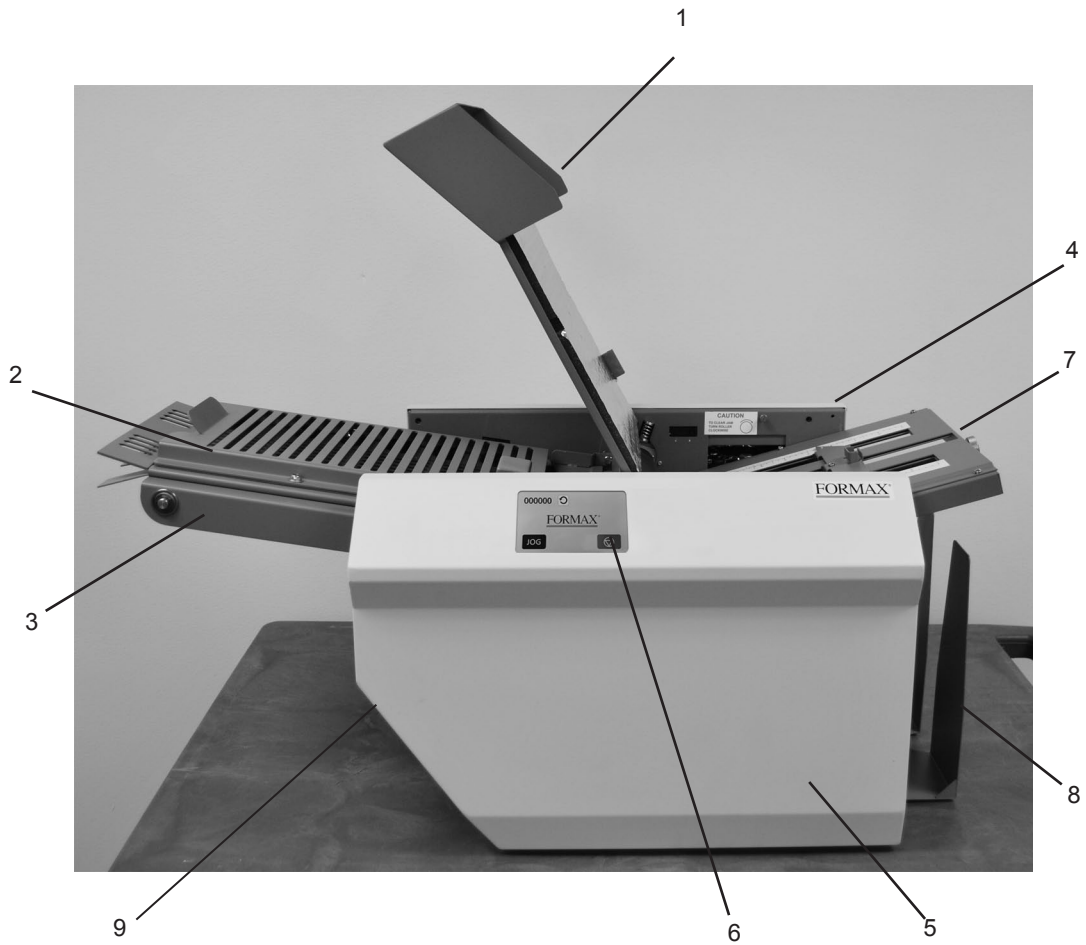
Fig. 24

1. To replace the photo eye, remove the screw that attaches the photo eye to the mounting bracket (Fig. 25).
2. Unplug the wires from the control board and discard old photo eye.
3. Reroute new photo eye harness and reconnect to the control board.
4. Align the photo eye sensor with the appropriate hole of the infeed deck (Fig. 24) and tighten screw to ensure the photo eye does not move.



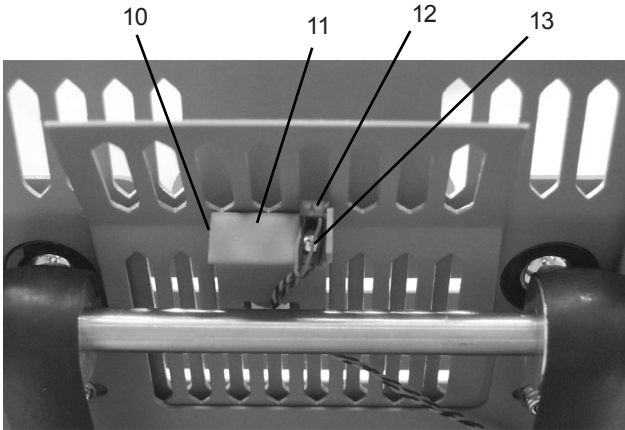
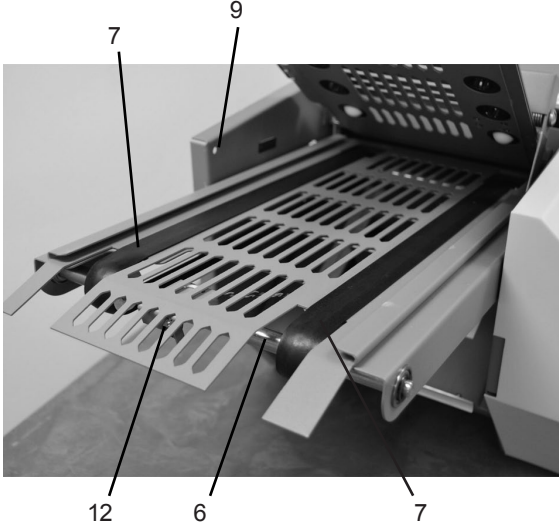
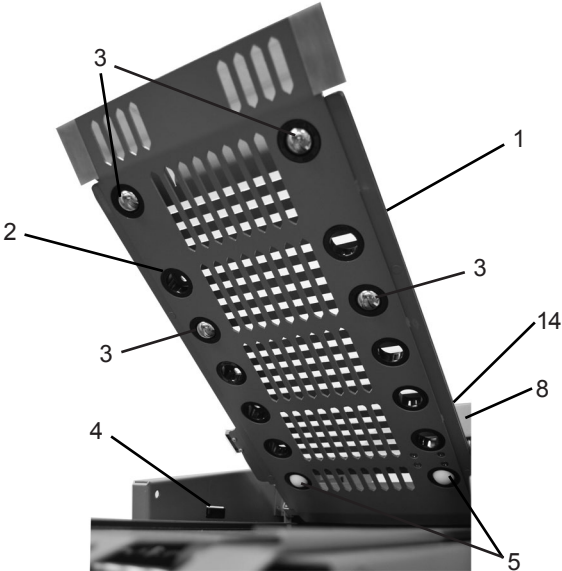


PARTS LIST



ITEM	PART #	DESCRIPTION	QTY
1	395-1280	TOP COVER ASSEMBLY	1
2	360-2862	INFEEDECK BALL COVER	1
3	360-2861	CROSS MEMBER 2006IL	1
4	395-1277	NON-OPER. SIDE COVER ASSY	1
	360-2790	NON-OPER COVER	1
5	395-1379	OPERATOR COVER ASSY.	1
	360-3086	OPERATOR COVER	1
	305-0043	ACOUSTIC FOAM OP COVER	1
6	395-1373	TOUCH SCREEN W/ COUNTER 120V	1
	395-1374	TOUCH SCREEN W/ COUNTER 240V	1
7	395-1283	UPPER FOLD TABLE ASSY	1
8	360-2802	CATCH TRAY ASSY	1
9	395-1282	LOWER FOLD TABLE ASSY	1

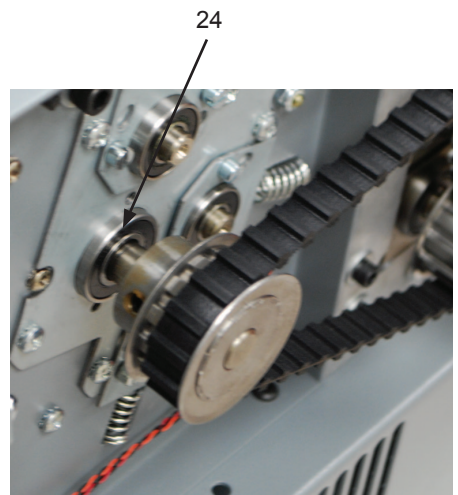
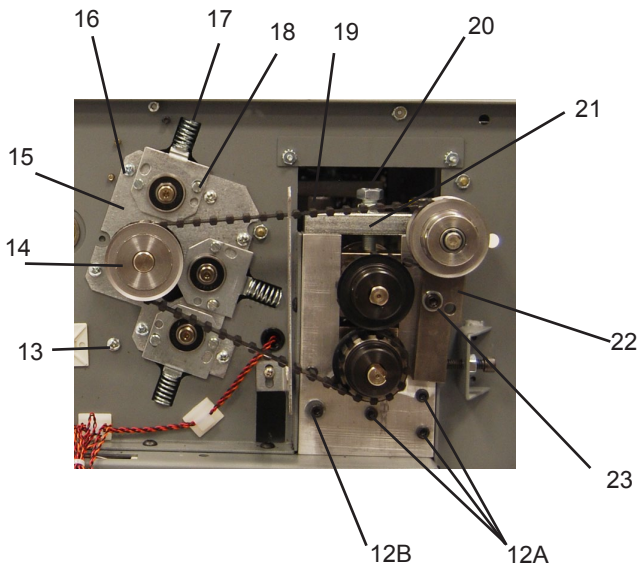
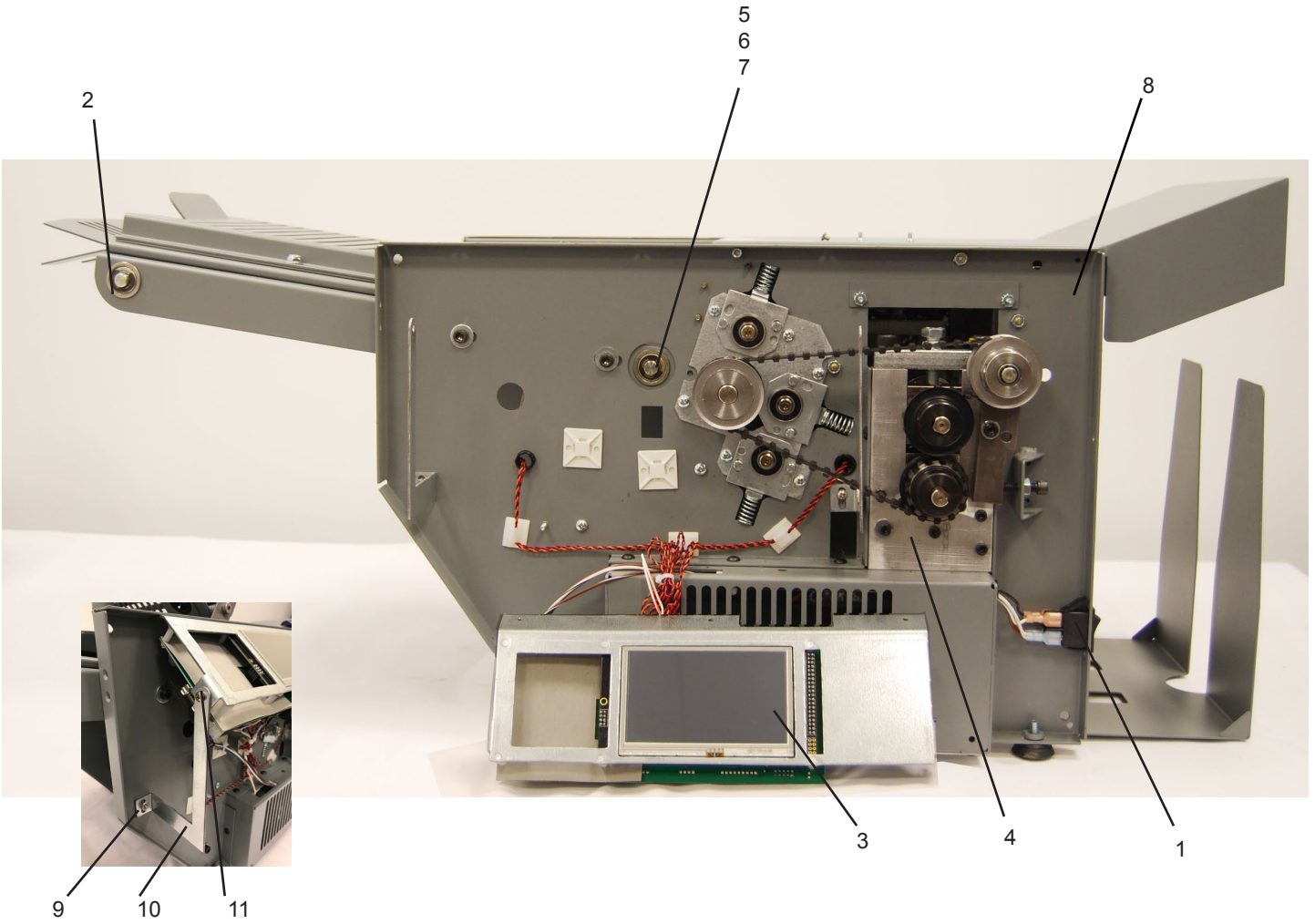
FEED DECK



FEED DECK

ITEM	PART #	DESCRIPTION	QTY.
1	360-2872	TOP COVER, 2006 INLINE	1
2	315-8329	HEYCO THRU BUSHING	14
3	370-0032	METAL BALL	4
4	319-0213	PROXIMITY SENSOR	1
5	370-0033	PLASTIC BALL	2
6	395-1091	DRIVE SHAFT ASSY	1
7	369-0033	TRANSPORT BELT, INLINE	2
8	360-2237	ROLLER GUARD, INLINE	1
9	375-5436	9/32 X 3/16 FLAT HD SC	4
10	378-9500	# 6 KEEPNUT (6-32) (not visible)	2
11	360-2236	SENSOR BRKT, INLINE	1
12	310-0134	INFEED PHOTO EYE	1
13	373-0014	SCREW PPH 4-40 X 1/4 LG	1
14	325-0295	FEED ROLLER WARNING DECAL	1

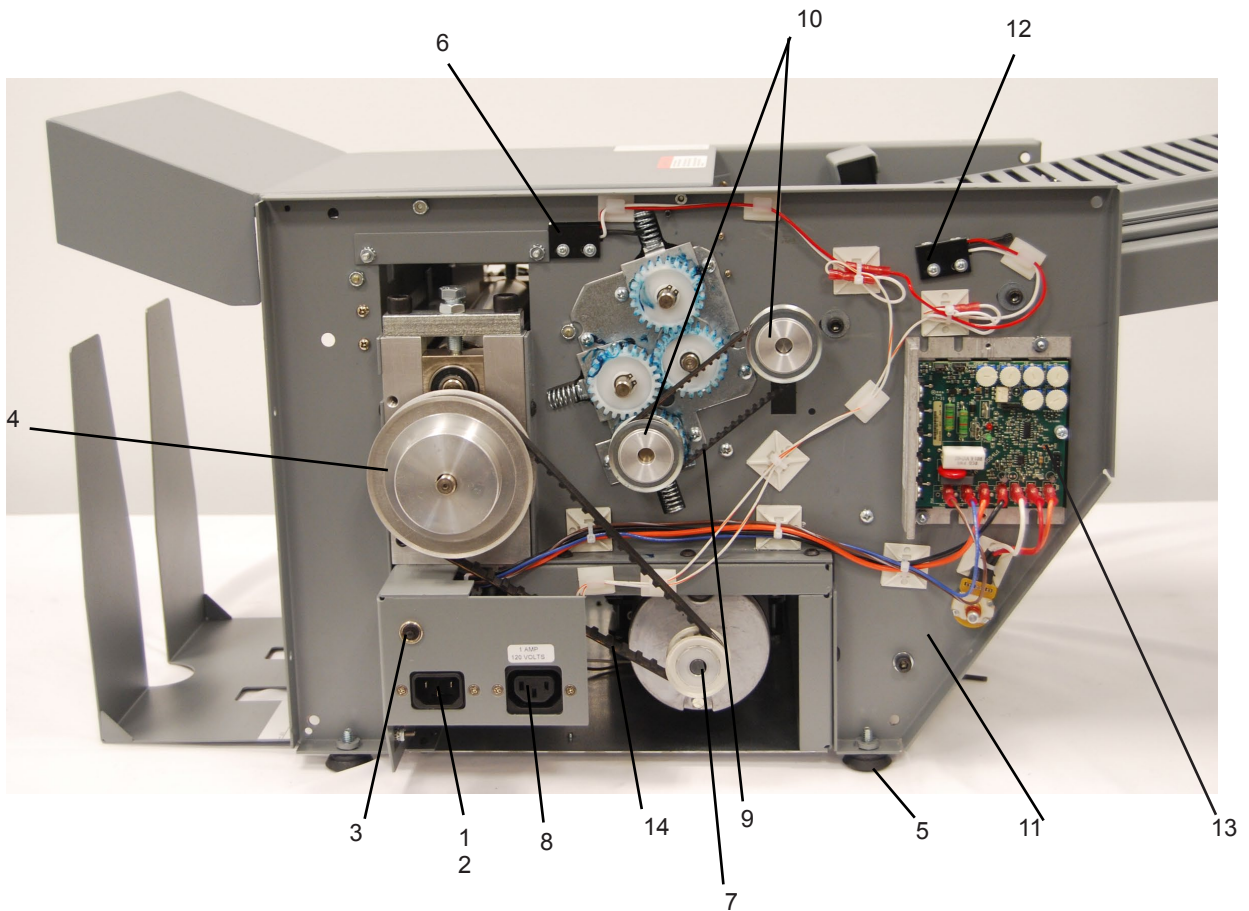
OPERATOR SIDE



OPERATOR SIDE

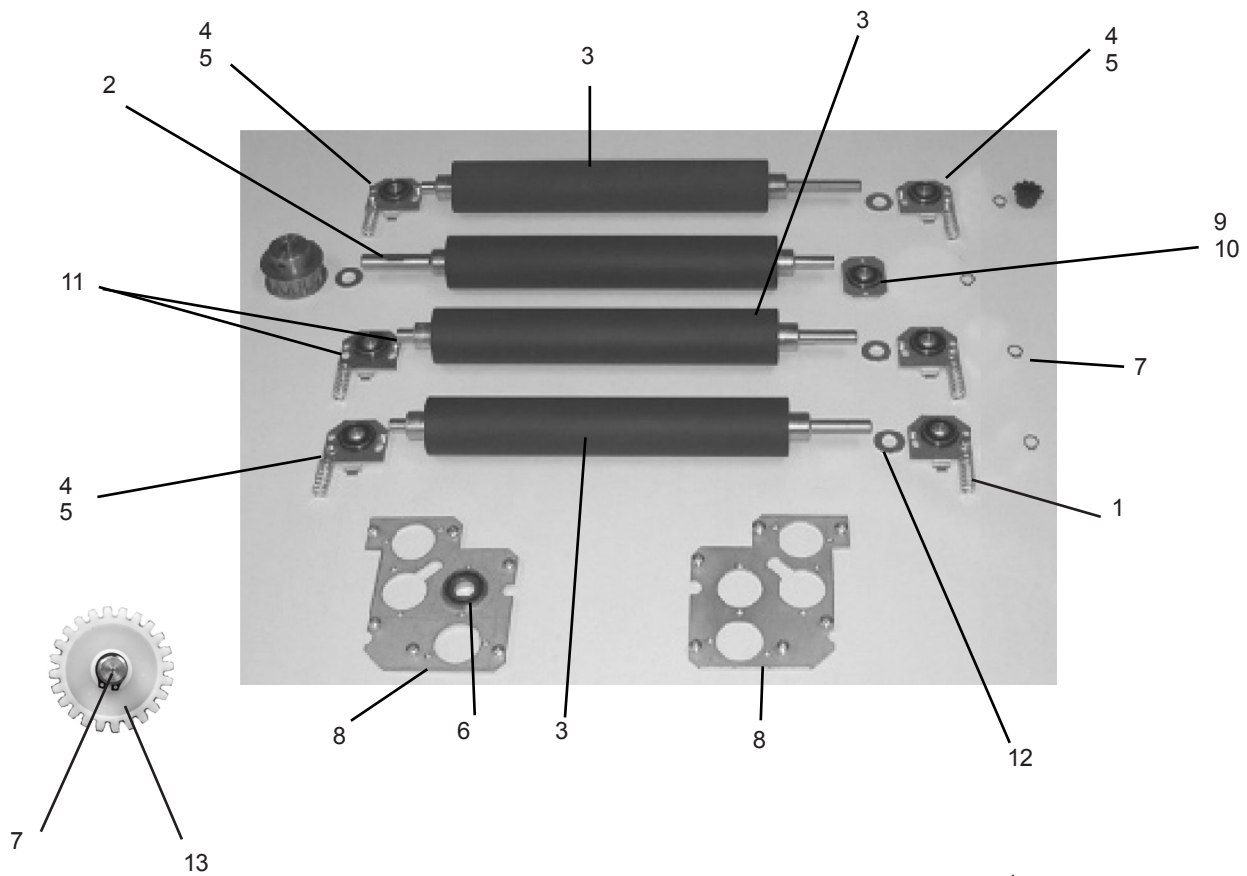
ITEM	PART#	DESCRIPTION	QTY.
1	311-0087	ROCKER SWITCH	1
2	395-1091	INFEEED DRIVER SHAFT ASSY	1
3	395-1373	2006IL TOUCHSCREEN ASSY 120V	1
	395-1374	2006IL TOUCHSCREEN ASSY 240V	1
4	334-0356	SIDE PLATE	1
5	395-1090	DRIVE SHAFT ASSY	1
6	379-0014	RETAINING RING	1
7	371-0041	BEARING	1
8	360-2870	FRAME, 2006 INLINE OP SIDE	1
9	378-9500	6-32 NUT W/STAR WASHER	1
10	360-3091	PCB BRACKET BRACE	2
11	330-0084	6-32X1/4" PPH SCREW W/ INT STAR	2
12A	374-0096	#10-32 X 1.00, SOC HD CAP	8
	377-5298	FLAT WASHER	10
12B	375-0106	10-32X 3/4 SOC HD CAP	2
13	373-0095	SCREW #8-32	4
14	365-0177	PULLEY, 13T .38 PITCH, MOD	1
15	360-1638	ROLLER SIDE BRACKET	2
16	360-1660	ROLLER SPRING BRACKET	6
17	342-0076	COMPRESSION SPRING	6
18	375-0116	SHOULDER SCREW	12
19	375-0102	3/8 X1 1/4" SOC. HD. SC.	4
20	375-0152	3/8" X1 1/4" HEX HD.	2
	375-0141	3/8" -40 HEX JAM NUT	2
21	334-0430	BRACKET SIDE, FRAME CAP	2
22	334-0371	BRACKET ADJ IDLER	1
23	374-5832	1/4-20 SOC. HD. CAP SCREW	2
	377-2611	1/4 LOCK WASHER	2
24	370-0026	BEARING ROLLER DOUBLE SEAL	1

NON-OPERATOR SIDE

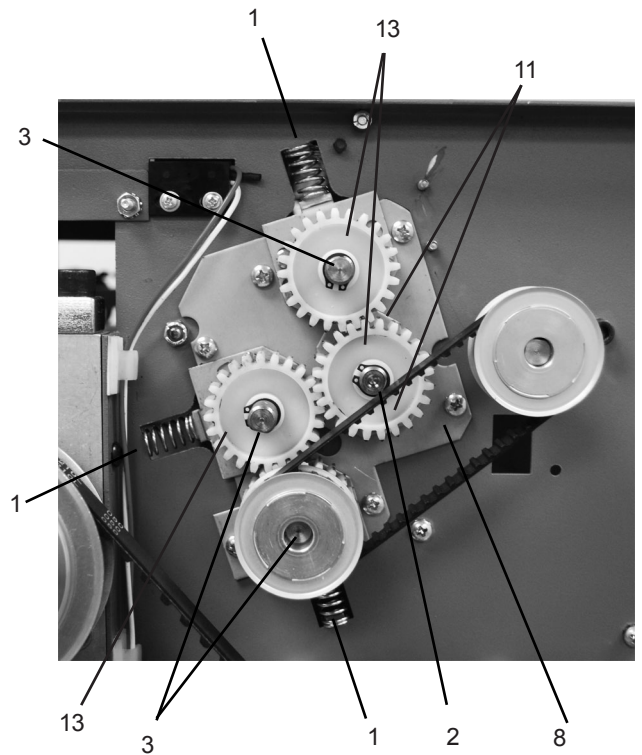


ITEM	PART#	DESCRIPTION	QTY.
1	310-0039	POWER SUPPLY CORD (NOT SHOWN)	1EA
2	319-0096	RECEPTACLE RECESSED POWER	1EA
3	317-0051	CIRCUIT BREAKER 2.5 AMP 120V & 240V	1
4	365-0178	PULLEY 3/8 PITCH 28LO50	1EA
5	372-6544	NON-SWIVEL ADJUST GLIDE (FOOT)	4EA
6	319-0213	PROXIMITY SENSOR	3EA
	319-0159	MAGNET, ACTUATOR NS	1
7	365-0163	TIMING PULLEY 9T X LO37 Y380	1EA
8	319-0109	IEC-320 POWER OUTLET	1EA
9	365-0198	TIMING BELT 120 X L037	1
10	365-0005	PULLEY 22XL037 3/8 BORE	2
11	360-2871	FRAME, INLINE NON-OP SIDE	1
12	319-0213	PROXIMITY SENSOR	1
13	395-1377	DC MOTOR CONTROL ASSY (120V)	1
	395-1378	DC MOTOR CONTROL ASSY (220V)	1
14	365-0180	GEAR BELT	1
	365-0233	DRIVE PULLEY, 11T L 3/8 BORE (FD2036)	1

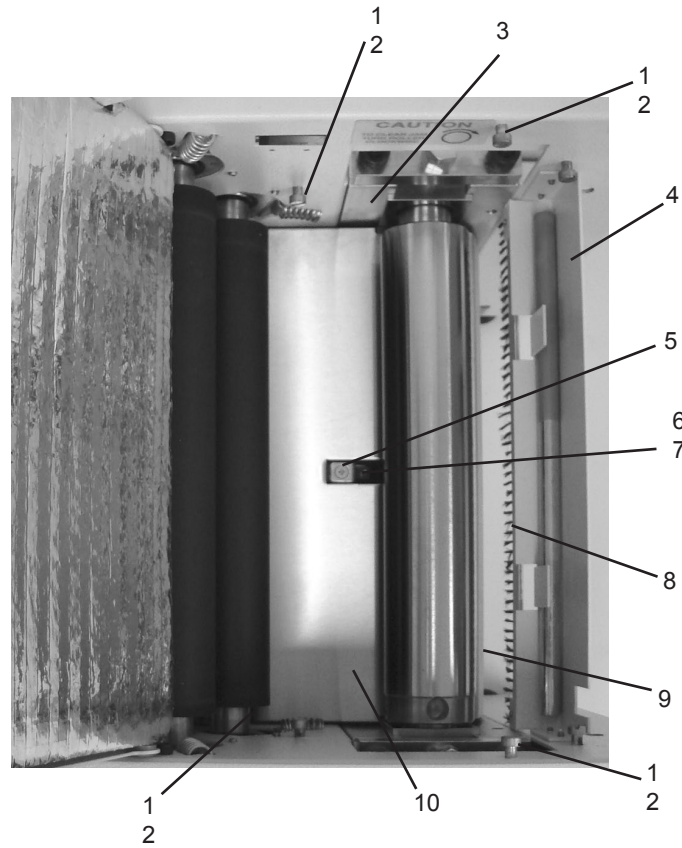
FOLD ROLLERS



ITEM	PART #	DESCRIPTION	QTY.
1	342-0076	COMPRESSION SPRING 0.0420 X	6
2	350-0075	DRIVE FOLDER LOWER, ROLLER	1
3	350-0077	FOLDER ROLLER	3
4	360-1660	ROLLER SPRING BRACKET	6
5	370-0025	ROLLER BEARING	7
6	370-0026	BEARING, ROLLER DOUBLE SEAL	1
7	379-1073	3/8" RET, RING TRUARC	5
8	360-1638	ROLLER SIDE BRACKET	2
9	360-1661	BEARING BRACKET	1
10	373-0088	PPH SCREW #8-32X.25	14
11	375-0116	SHOULDER SCREW #8-32	12
12	380-6547	SPACER WASHER FLAT 3/8 I.D	4
13	368-0063	24-TOOTH GEAR	4



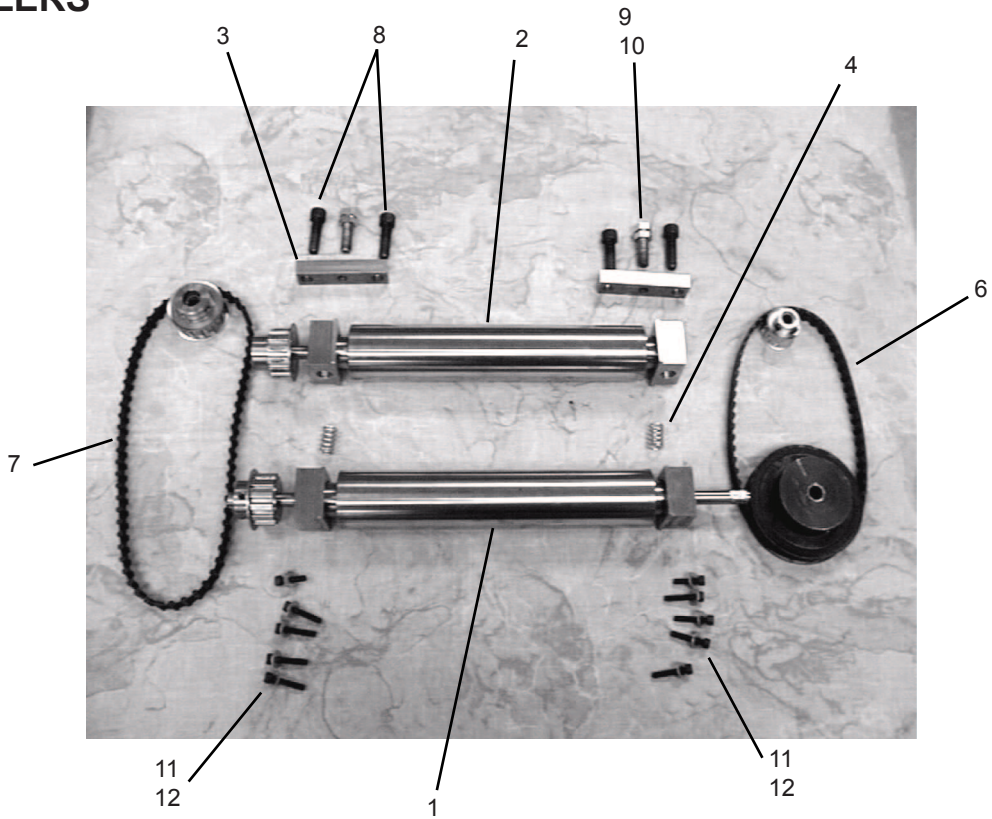
OUTPUT DECK



Top view, output side, cover open

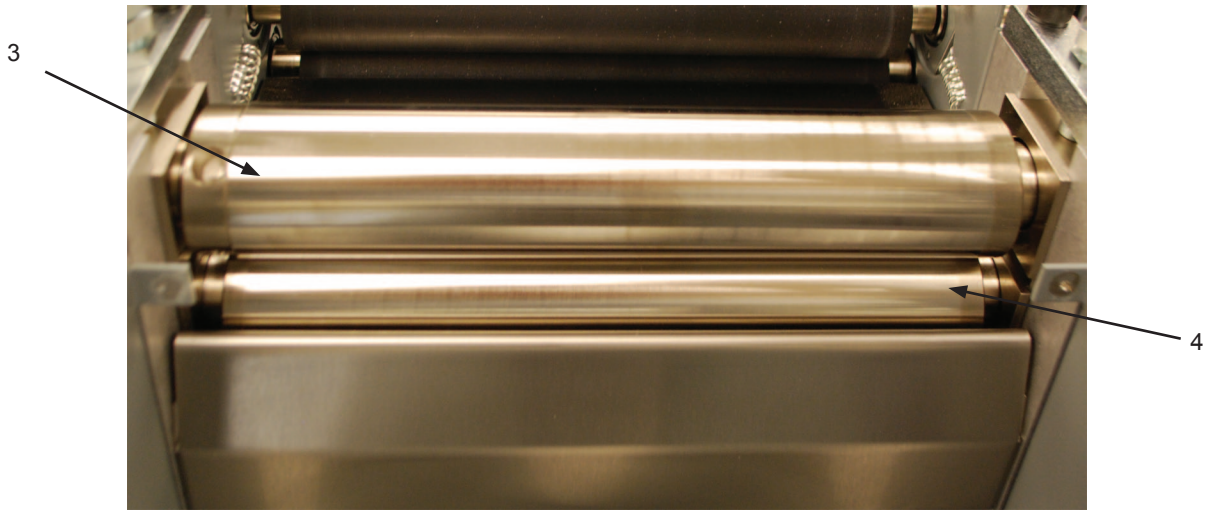
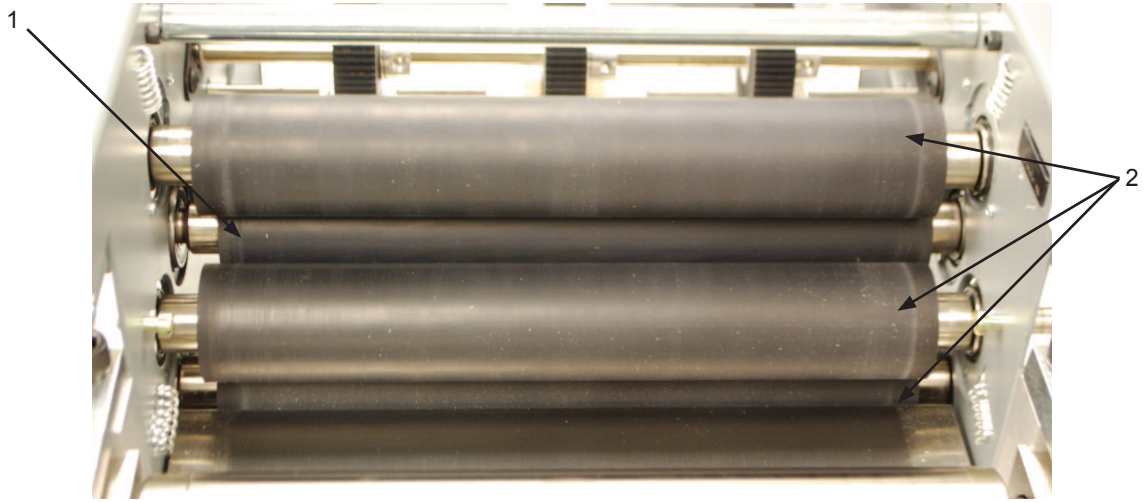
ITEM	PART #	DESCRIPTION	QTY
1	375-0044	SHOULDER SCREW # 8-32	6
2	378-0115	NUT SELF LOCK 8-32	6
3	360-1692	SEALER FRAME PLATE	2
4	360-2001	ROLLER GUARD	1
5	375-0070	6/32 X 1/4" SCREW	1
6	310-0134	PHOTO SENSOR HARNESS	1
7	360-1700	BRACKET, SENSOR	1
8	316-0011	STATIC WAND	1
9	360-1686	CROSS MEMBER REAR	1
10	360-1687	CROSS MEMBER FRONT	1

SEAL ROLLERS

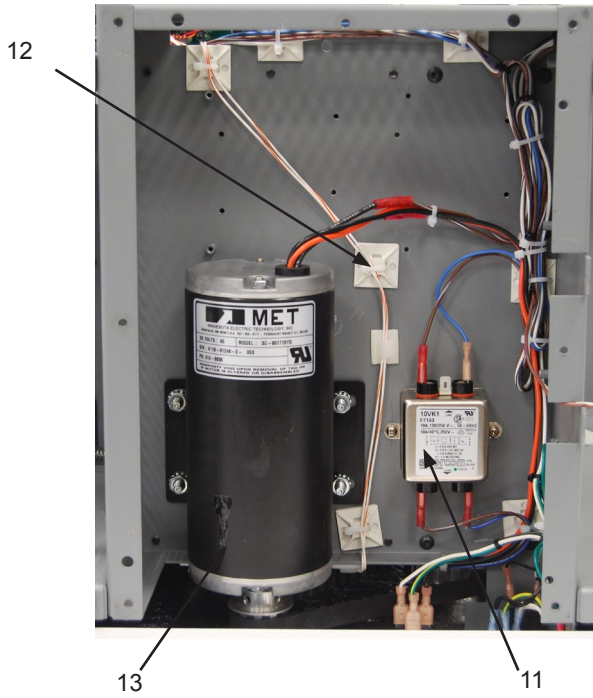
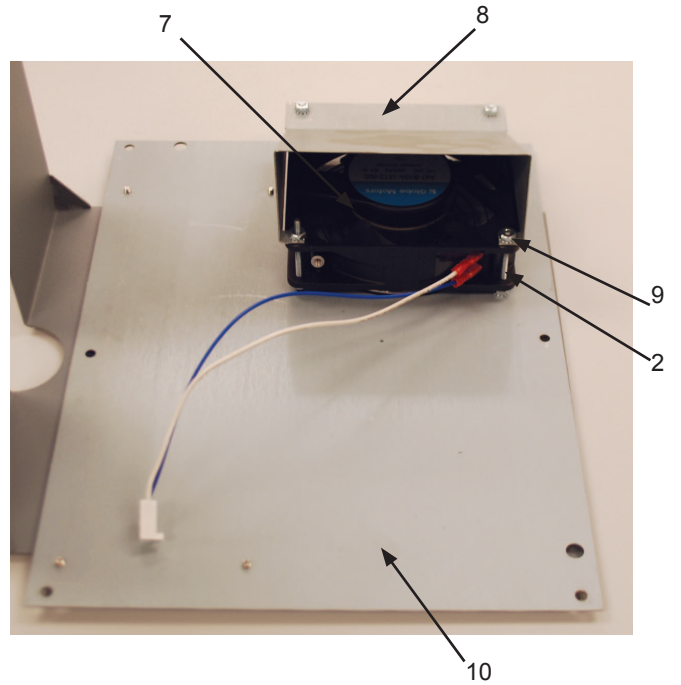
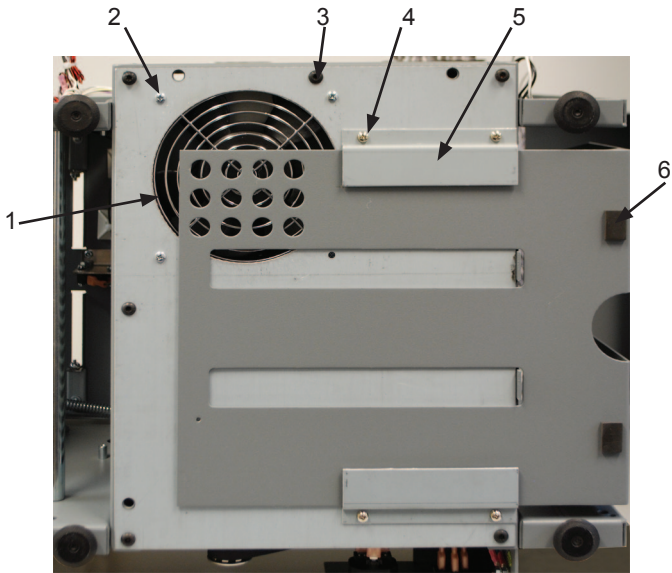


ITEM	PART #	DESCRIPTION	QTY.
1	395-0761	DRIVE ROLLER ASSY	1
2	395-0760	ROLLER, UPPER ASSY	1
3	334-0430	BRACKET SIDE, FRAME CAP.	2
4	342-0063	SPRING, BEARING BLOCK	2
5	365-0145	PULLEY, 13T .38 PITCH	2
6	365-0180	GEAR BELT, 210 L050	1
7	365-0179	TIMING BELT DOUBLE SIDED	1
8	375-0102	BOLT 3/8X1 1/4" SOC. HD. SC	4
9	375-0152	3/8" X 1 1/4" HEX HD.	2
10	378-0142	3/8"-40 HEX JAM NUT	2
11	374-0096	#10-32 X 1.00, SOC HD CAP	8
12	375-0106	10-32X 3/4 SOC HD CAP	2

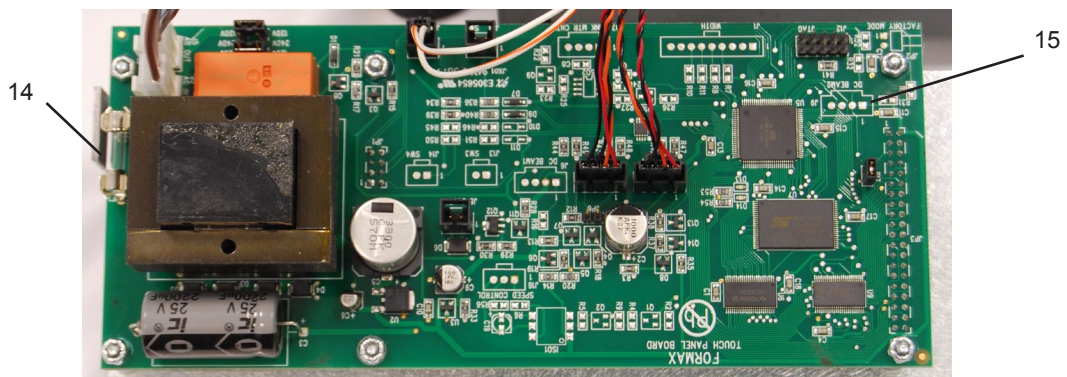
FOLD & SEAL ROLLERS



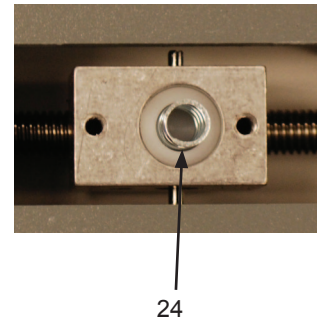
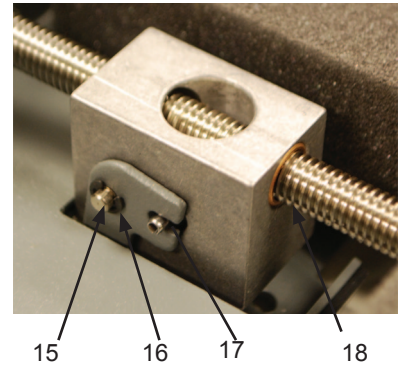
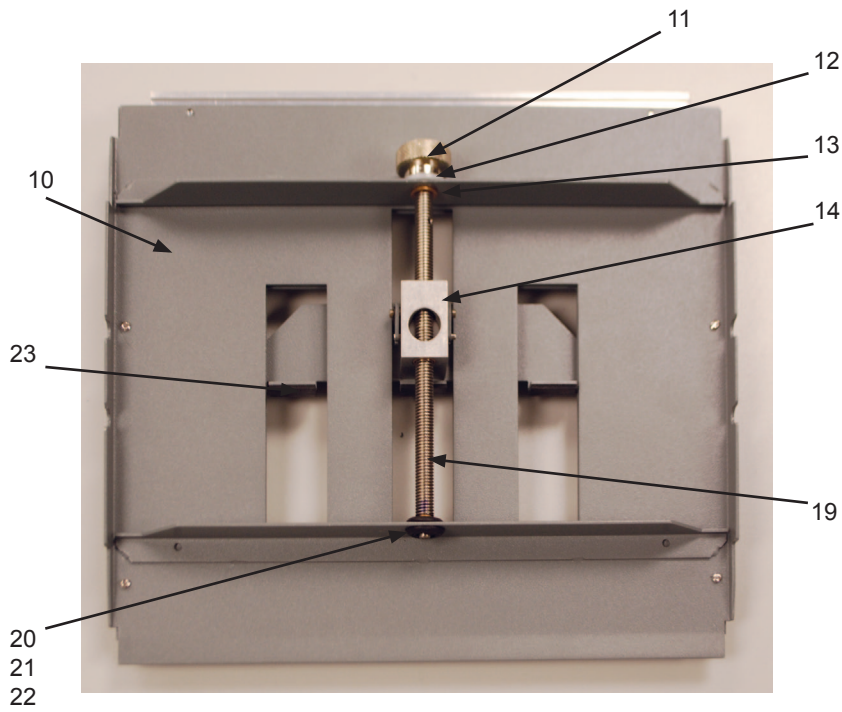
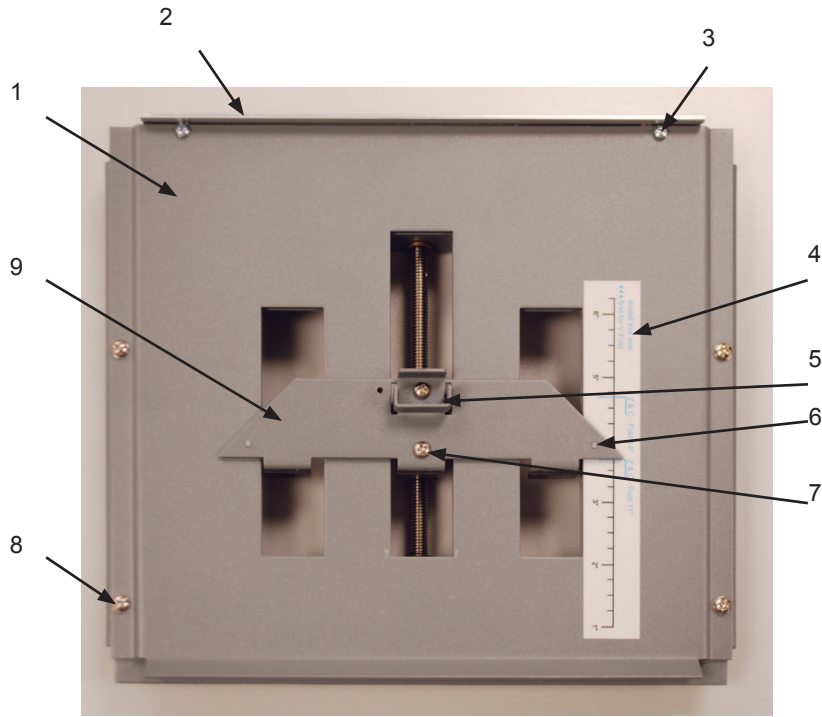
ITEM	PART	DESCRIPTION	QTY.
1	350-0075	DRIVE FOLD ROLLER	1
2	350-0077	FOLD ROLLER	3
3	395-0760	UPPER SEAL ROLLER ASSY	1
4	395-0761	DRIVE SEAL ROLLER ASSY	1
NS	342-0063	SPRING SEAL ROLLER BEARING BLOCK	2



ITEM	PART	DESCRIPTION	QTY.
1	341-0006	FAN GUARD	1
2	375-0098	6-32 X 1 1/2" PPH SCREW	4
3	375-5699	#10-32 x 1.00, SOCKET HEAD SCREW	6
4	373-5869	SCREW 10-32 X 1/4 BUTTON HD CA	4
5	360-1656	RAIL, CATCH TRAY	2
6	351-0013	SUPPORT PAD	3
7	313-0004	COOLING FAN 110 VAC	1
8	360-1490	FAN DUCT 209010	1
9	378-9500	6-32 NUT WITH STAR WASHER	4
10	360-1674	BOTTOM PAN	1
11	319-0078	LINE FILTER	1
12	315-5800	CABLE TIE MOUNT	5
13	313-8835	1/6 HP MOTOR 110VAC	1
14	317-0040	FUSE 250 AMP 5X20 FAST ACTING	1
15	395-1373	TOUCHSCREEN ASSY. (120V)	1
	395-1374	TOUCHSCREEN ASSY. (220V)	1



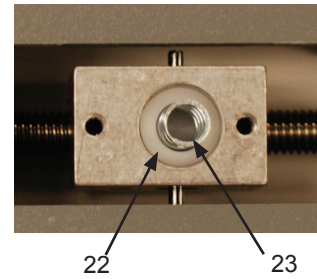
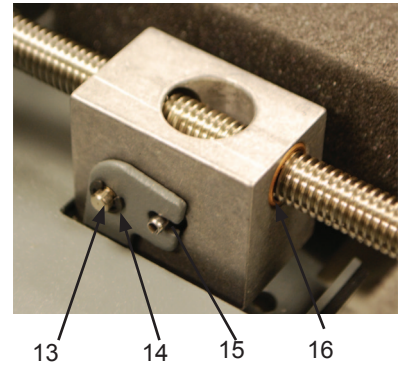
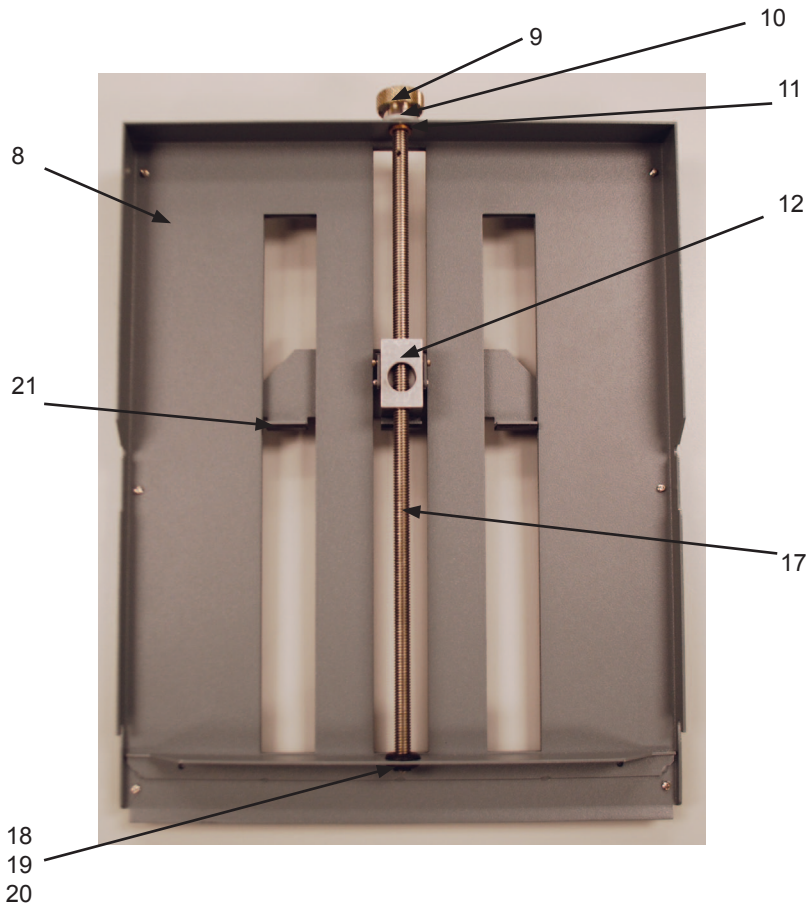
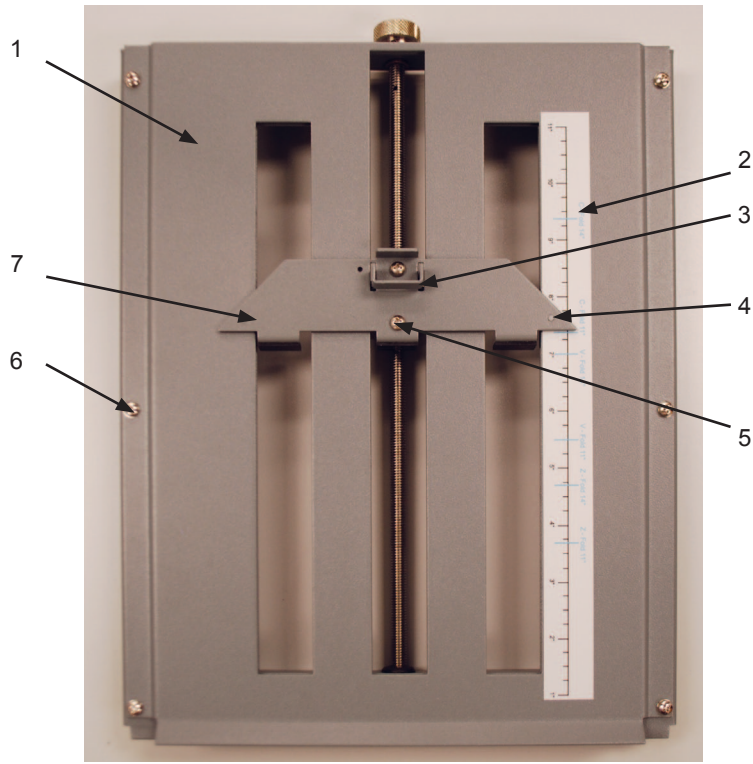
LOWER FOLD PLATE



LOWER FOLD PLATE

ITEM	PART	DESCRIPTION	QTY.
*	395-1282	LOWER FOLD PLATE ASSY.	1
1	360-2784	UPPER HALF, LOWER FOLD PLATE	1
2	360-1641	FOLD DIVERTER	1
3	373-0014	SCREW PPH 4-40 x 1/4 LG.	2
-	377-0084	WASHER, #4 FLAT MACHINE SCREW	2
4	325-0400	LOWER FOLD PLATE DECAL	
-	325-0549	LOWER FOLD PLATE DECAL (FE models only)	1
5	360-2663	RELEASE LEVER, FOLLOWER	1
6	381-0114	NYLON RIVET	2
7	373-0132	#6-32X1/4 PPH SCREW CHROME	2
8	373-5869	SCREW PPH 6-32x1/4	4
9	360-2664	PAPER STOP	2
10	360-2785	LOWER HALF, LOWER FOLD PLATE	1
11	334-0378	KNOB, FOLD PLATE ADJUSTMENT	1
12	377-0072	3/8 NYLON WASHER	1
13	371-0092	3/16X5/16X3/16 FLANGED BUSHING	1
14	334-0374	CAR	1
15	332-0148	RELEASE PIN, FOLD PLATE	1
16	379-0020	1/8" E TYPE RETAINING RING	2
17	381-0121	3/32 X 1 ROLL PIN	1
18	371-0096	.296 X 3/8 X 1/4 SLEEVE BUSHING	2
19	331-0224	LOWER LEAD SCREW	1
20	352-0014	GROMMET FLANGED RUBBER	1
21	371-0093	3/16 X 5/16 X 1/4 SLEEVE BUSHING	1
22	379-0009	RETAINING RING, 3/16 I.D.	1
23	352-0016	PAD, PAPER STOP	3
24	395-1384	NUT, RELEASE, FOLD PLATE + SPRING	1

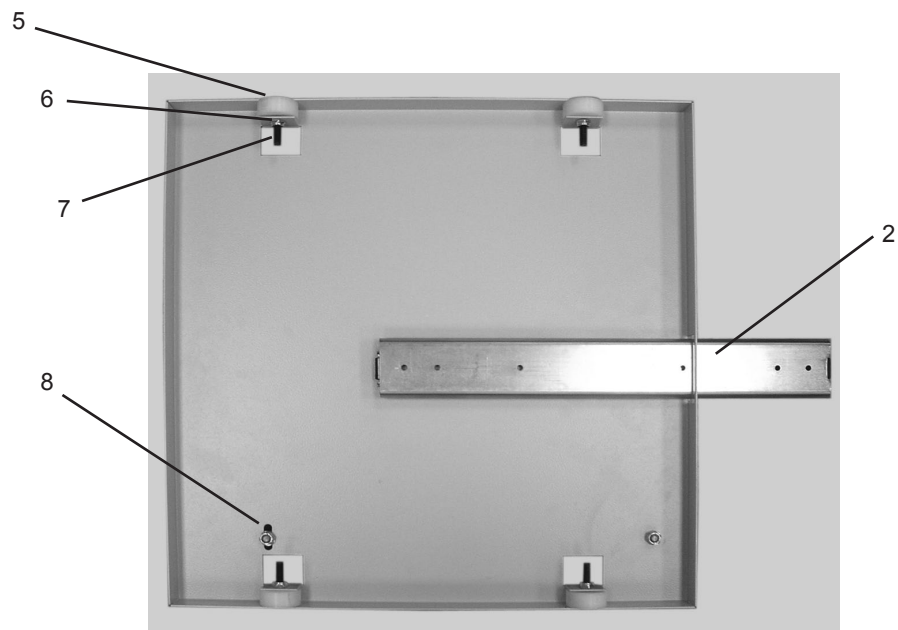
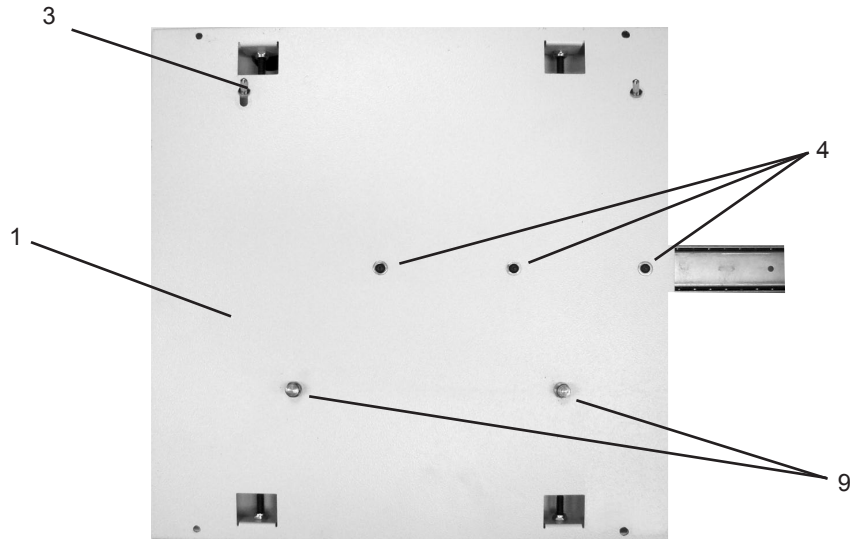
UPPER FOLD PLATE



UPPER FOLD PLATE

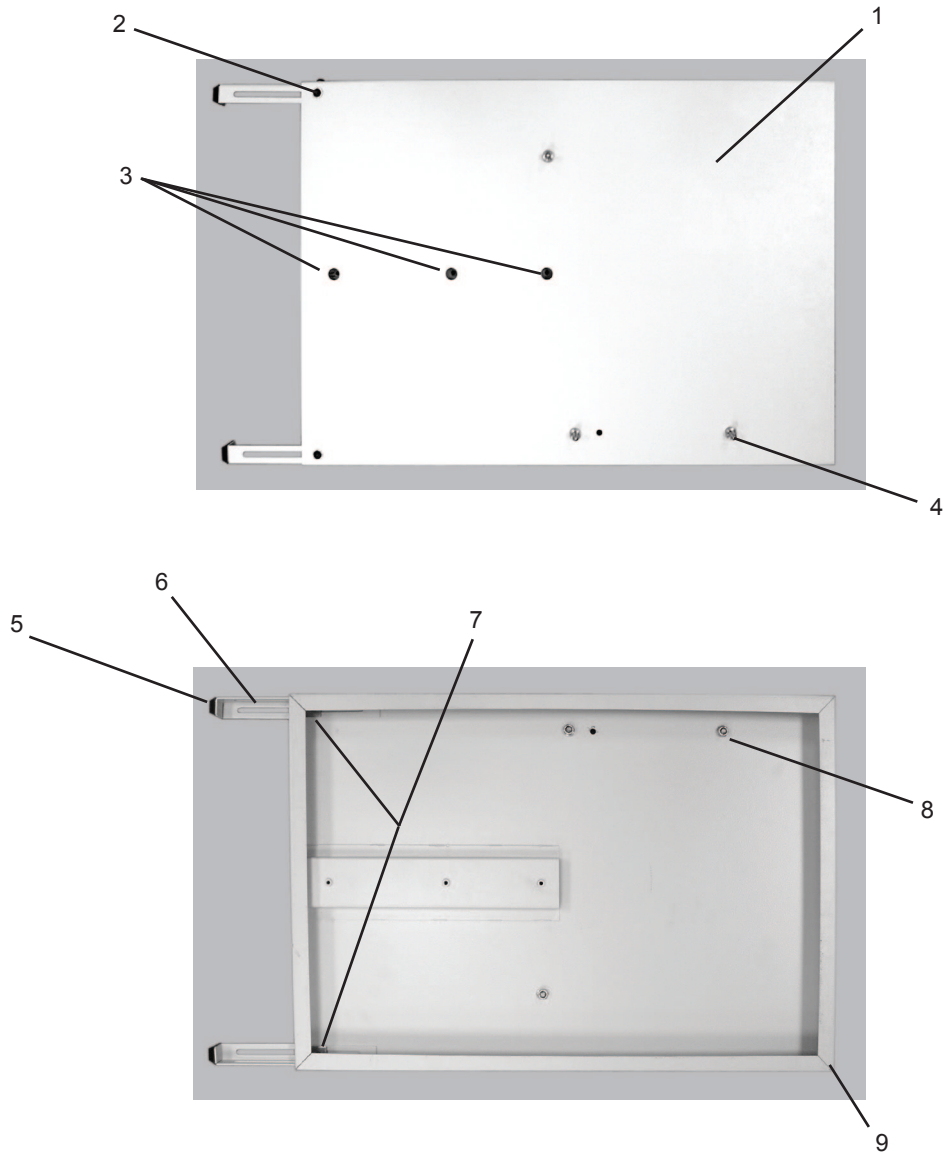
ITEM	PART	DESCRIPTION	QTY.
*	395-1283	UPPER FOLD PLATE ASSY.	1
1	360-2786	UPPER HALF, UPPER FOLD PLATE	1
2	325-0400	UPPER FOLD PLATE DECAL	
-	325-0549	UPPER FOLD PLATE DECAL (FE models only)	1
3	360-2663	RELEASE LEVER, FOLLOWER	1
4	381-0114	NYLON RIVET	2
5	373-0132	#6-32X1/4 PPH SCREW CHROME	2
6	373-5869	SCREW PPH 6-32x1/4	4
7	360-2664	PAPER STOP	2
8	360-2787	LOWER HALF, UPPER FOLD PLATE	1
9	334-0378	KNOB, FOLD PLATE ADJUSTMENT	1
10	377-0072	3/8 NYLON WASHER	1
11	371-0092	3/16X5/16X3/16 FLANGED BUSHING	1
12	334-0374	CAR	1
13	332-0148	RELEASE PIN, FOLD PLATE	1
14	379-0020	1/8" E TYPE RETAINING RING	2
15	381-0121	3/32 X 1 ROLL PIN <	1
16	371-0096	.296 X 3/8 X 1/4 SLEEVE BUSHING	2
17	331-0223	UPPER LEAD SCREW	1
18	352-0014	GROMMET FLANGED RUBBER	1
19	371-0093	3/16 X 5/16 X 1/4 SLEEVE BUSHING	1
20	379-0009	RETAINING RING, 3/16 I.D. >	1
21	352-0016	PAD, PAPER STOP	3
22	395-1384	NUT, RELEASE, FOLD PLATE	1
23	395-1384	COMPRESSION SPRING, FOLD PLATE	1

PRINTER ALIGNMENT BASE 395-1092



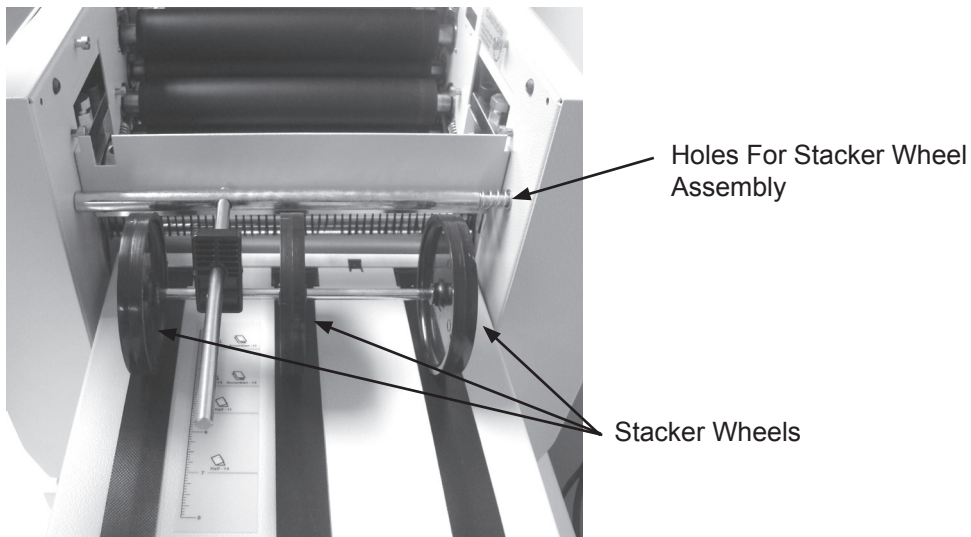
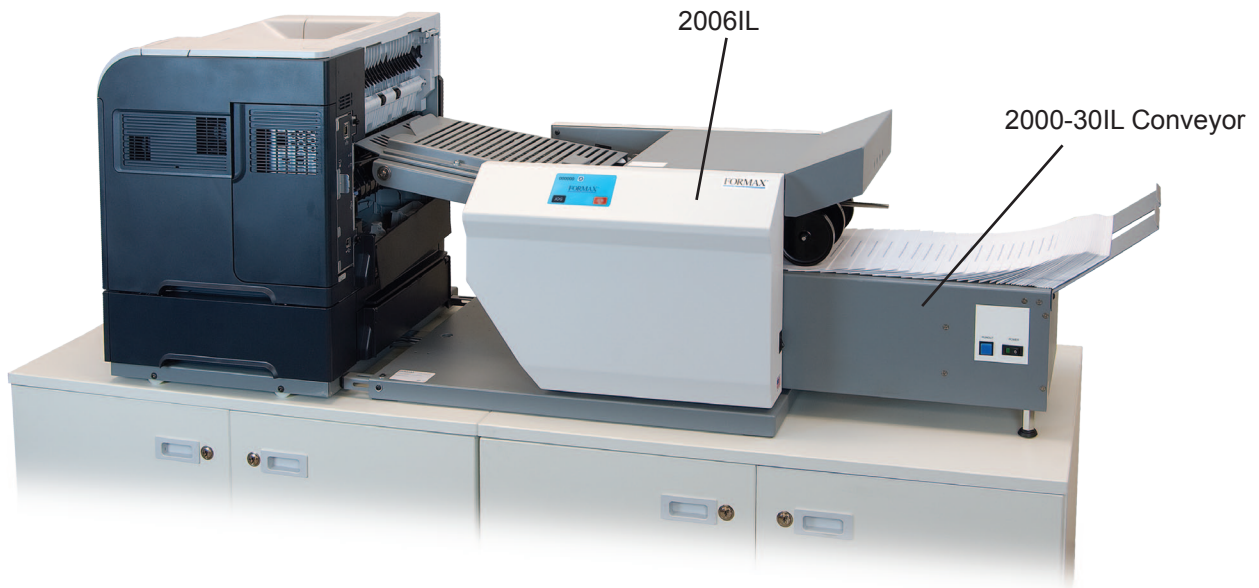
ITEM	PART #	DESCRIPTION	QTY.
1	360-2242	ALIGNMENT BASE, PRINTER	1
2	360-2240	SLIDE BRKT, INLINE	1
3	381-0134	GUIDE PIN	2
4	375-0014	8-32 X 3/8 SOC BUT HD	3
4	377-0001	FLAT WASHER	3
5	321-0111	WHEEL	4
6	378-0126	1/4-20 LOCK NUT	4
7	374-0020	1/4-20 X 1 SOC BUT HD	4
8	378-0126	1/4-20 LOCK NUT	1
8	377-2611	LOCK WASHER	1
9	381-0142	ALIGNMENT STUD	2

PRESSURE SEAL ALIGNMENT BASE: 395-1093



ITEM	PART #	DESCRIPTION	QTY.
1	360-2241	ALIGNMENT BASE, PRESSURE SEALER	1
2	375-5699	10-32 X 1/4 SOC BUT HD	4
2	377-5298	#10 FLAT WASHER	4
3	375-0014	8-32 X 3/8 SOC BUT HD	3
4	381-0134	GUIDE PIN	3
5	352-0001	BUMPER	2
6	360-2169	STOP BRACKET	2
7	360-2170	LOCK BRACKET, STOP	2
8	377-2611	LOCK WASHER	3
8	378-0126	1/4-20 LOCK NUT	3
9	351-0005	PAD	4

OPTIONAL CONVEYOR SETUP AND PARTS (additional instructions on page 7)



To install the 18" conveyor, follow these steps:

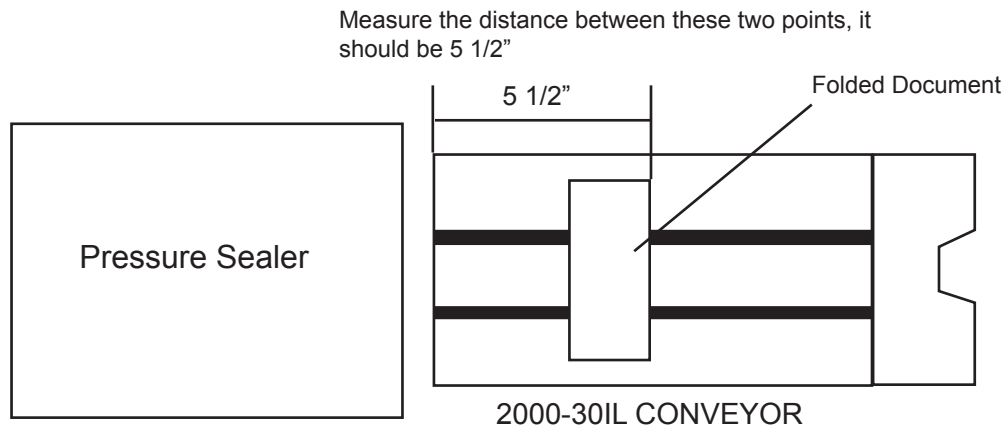
1. Unplug the 2006IL from the wall outlet.
2. Remove the catch tray from machine.
3. Remove the upper fold table.
4. Plug the power cord into the underside of the conveyor.
5. Attach the conveyor to the 2006IL.
6. Install the stacker wheel assembly into the holes indicated above.
7. Adjust the stacker wheels to conveyor decal.
8. Plug the conveyor power cord into the power outlet on the 2006IL.
9. Reinsert the upper fold table.
10. Plug the 2006IL into the wall outlet.

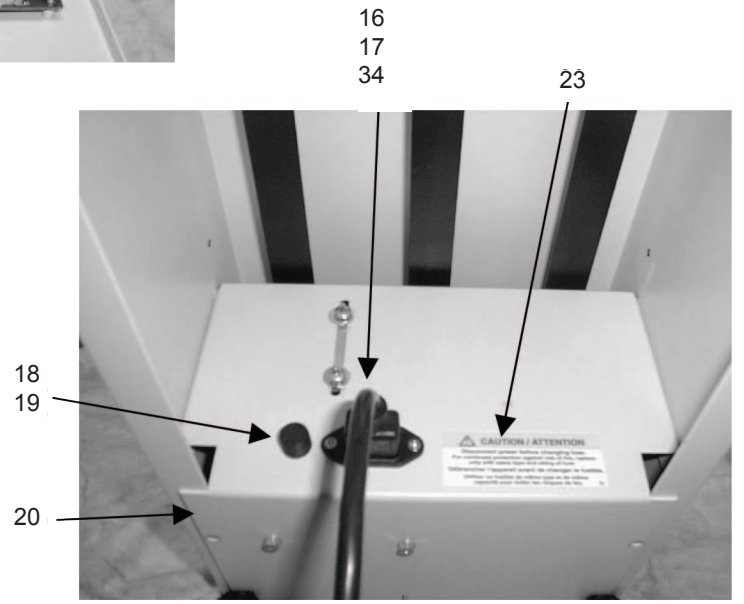
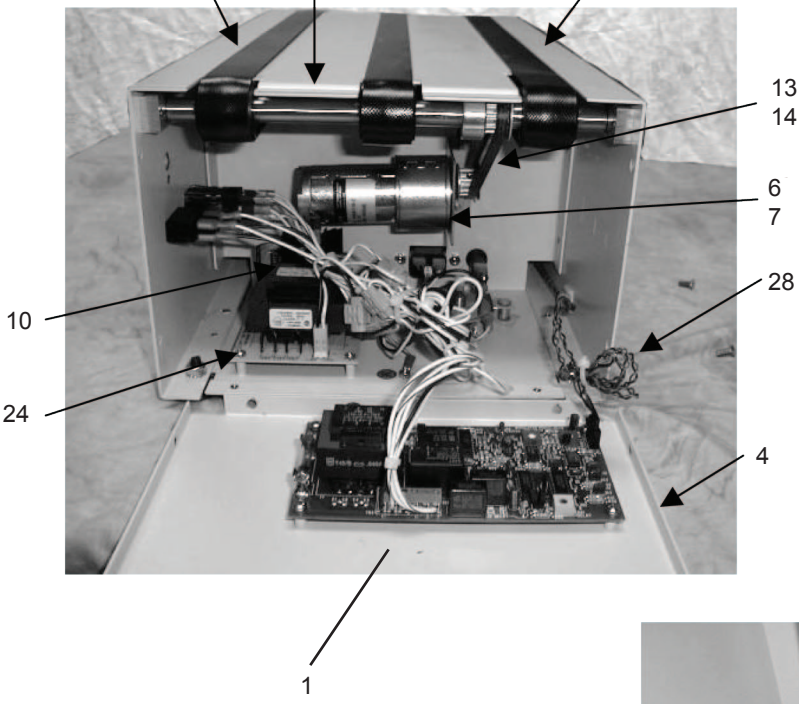
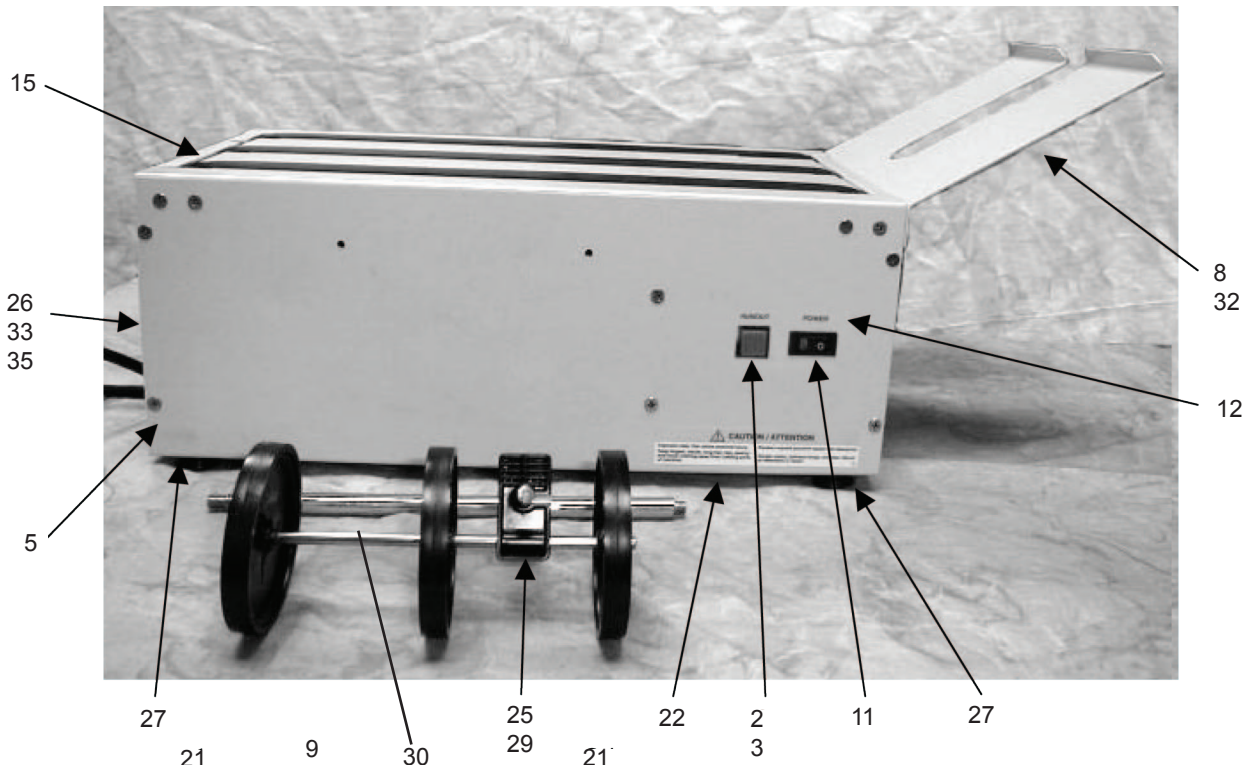
CONVEYOR PHOTO-EYE ADJUSTMENT

1. Turn power off.
2. Access the photo beam board.
3. Turn "BEAM PWR" potentiometer (R9) fully clockwise.
4. Turn "DET GAIN" potentiometer (R30) fully counter-clockwise.
5. Suspend a white folded document 8/10th of an inch above the photo-eye.
6. Turn power switch on.
7. Turn R30 clockwise until lights on the board change from low (red light) to good (green light). DO NOT ADJUST ANY HIGHER.

CONVEYOR TIME DELAY ADJUSTMENT

1. Turn power switch off
2. Turn "delay" potentiometer (R41) fully counter-clockwise.
3. Place folded document on the conveyor covering the photo-eye.
4. Turn power switch on.
5. Form will advance, when it stops, measure the distance it traveled. The distance should be 5 1/2" (see illustration below).
6. If the distance is less than required, turn "delay" potentiometer (R41) 1/8th of a turn clockwise and repeat steps 1,3,4, and 5. Continue this until the travel distance is 5 1/2".





ITEM	PART #	DESCRIPTION	QTY.
1	395-0835	MODULATED PHOTO BEAM ASSY	1
2	311-0023	SWITCH PUSH BUTTON	1
3	315-0005	CAP COLOR CODE BLUE	1
4	360-1762	END PANEL, STACKER	1
5	360-1764	DECK, CONVEYOR	1
6	313-0031	12 VDC MOTOR	1
7	360-1396	MOTOR MOUNT	1
8	360-1763	CATCH TRAY	1
9	395-0839	DRIVE SHAFT ASSY	1
10	310-0878	WIRING HARNESS	1
11	311-0060	SWITCH	1
12	325-0344	CONTROL PANEL DECAL	1
13	365-0165	PULLEY DRIVE	1
14	365-0059	BELT 110XLO37	1
15	395-0840	NON DRIVE SHAFT ASSY	1
16	319-0096	RECEPTACLE RECESSED POWER	1
17	310-0039	POWER SUPPLY CORD	1
18	317-0006	FUSE HOLDER	1
19	317-0013	1.5A 3AG FUSE	1
20	360-1765	BOTTOM PAN	1
21	369-0018	CARRIER BELT	3
22	325-0152	CAUTION ENG / FRENCH DECAL	1
23	325-5078	ELECTRICAL WARNING DECAL	1
24	390-0908	PC BOARD	1
25	395-0836	EXIT WHEEL ASSEMBLY	1
26	360-1761	END PANEL, INFEED	1
27	372-6544	NON-SWIVEL ADJUST GLIDE	1
28	310-0134	PHOTO-EYE HARNESS	1
29	320-0059	EXIT WHEEL BLOCK	1
30	332-0125	EXIT WHEEL ROD	1
31	370-0022	BEARING	2
32	374-0014	10-32 SOHEAD SCREW	1
33	373-0016	10-32 X 1/2" SCREW	1
34	310-0045	POWER CORD (CONVEYOR TO SEALER)	1
35	375-0066	SHOULDER SCREW (SECURES CONVEYOR TO SEALER)	2