

Bedford Roll N Close® Applier model 55-A and 55-F





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Safety

Read this section before using the equipment. This section contains recommendations and practices applicable to the safe installation, operation, and maintenance of the product described in this document. Additional safety information, in the form of task-specific safety alert messages, appears as appropriate throughout this document.

Be sure the following safety instructions are read, understood, and become a part of daily practice when operating or maintaining the closure equipment.

1. Do not attempt to operate the closure equipment until you understand its function.
2. Keep all foreign material away from the drive system.
3. Keep fingers out of the stamping block and feed roller area.
4. Disconnect the power cord before making any equipment adjustments or maintenance. All moving parts must be completely stopped.
5. After any adjustment, cycle the equipment by hand to ensure proper adjustment has been made. Immediately cycling under power may damage the unit and/or product.

Responsibilities of the Equipment Owner

Equipment owners are responsible for managing safety information, ensuring that all instructions and regulatory requirements for use of the equipment are met, and for qualifying all potential users.



1.0 Specifications

1.1 Closure

- A. The Roll N Close® Applier machine is a tabletop machine designed to apply a Roll N Close® closure to a bag or other product.
- B. The Roll N Close® Applier model 55-A uses .50” (1.27cm) material, and comes in 1,500 ft spools.
- C. the Roll N Close® Applier model 55-F uses .315” (0.80cm) material and comes in 2,000 ft spools.

1.2 Principal of Operation

- A. The machine is electronically controlled by a PLC. The PLC is equipped with an HMI touchscreen that allows the operator to run various tie length, adjust clamp time, and count the number of closures that have been applied.
- B. After the bag is inserted into the slot in the front of the Applier, depress the foot switch. The tie is cut to the desired length and applied to the bag.
- C. Then a set of feed rollers advance the tie material off the spool and into the guide blocks. The release liner on the tie material is removed and collected on the spool located on the lower front of the machine.
- D. Once this process of cutting and applying the closure is complete, the applier is then ready for another bag to be inserted.



2.0 Installation

2.1 Machine Inspection

- A. Remove machine from shipping container and examine for damage. If damaged, notify carrier immediately.
- B. Remove loose parts and service manual from shipping container.

2.2 Power Requirements

- A. Standard electrical specifications for the Roll N Close® Applier model 55-A and model 55-F machines are: 120 VAC, 15 Amp, 1 phase, 60 Hz
(Optional electrical specifications are: 240 VAC, 15 Amp, 1 phase, 50-60 Hz)
- B. Be sure machine is connected to building electrical safety ground to avoid shock hazard.

2.3 Machine Set Up

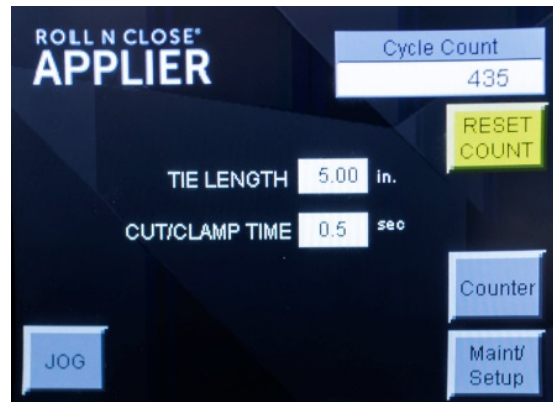
- A. Add 0.1 oz. (3ml) of light mineral oil to Wicked Oiler. Do not overfill. *(Reference Section 4.2)*
- B. Connect machine to a compressed air supply of at least 90 psi. Total compressed air consumption is 0.11 cfm.
- C. Plug machine into properly grounded 3-wire outlet.
- D. Locate the power switch on the front of the control panel and turn it to the ON position.
- E. Install Bag Tray Assembly to the front of the machine. *(Reference Section 3.3)*

3.0 Operation

3.1 HMI Touchscreen Operation

A. HMI Main Screen

1. The touch screen has 3 settings that the operator can access from the Main Screen. There are also 3 function buttons available on the Main Screen.





Main Screen

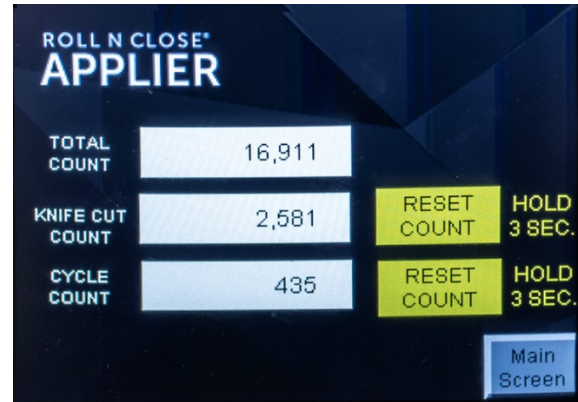
B. Settings

1. **CYCLE COUNT:** records the number of cycles the machine has made during the last production run, or since the last reset.
 - i. Reset the Cycle Count before you start your production run.
 - ii. Press and hold the yellow **RESET COUNT** button for three seconds, or until the counter resets to zero.
2. **TIE LENGTH:** set the Tie Length for the length of tie closure you want to use.
 - i. Press the white numeric entry button next to "TIE LENGTH". A new screen with a keypad will appear. The current tie length setting is shown at the bottom right of the screen.
 - ii. Use the keypad to enter the desired tie length. You must enter three digits (5-0-0 = 5.00"). Your new tie length will appear in the top right of the screen.
 - iii. Press the **Enter** button to set your tie length and return to the Main Screen.
3. **CLAMP TIME:** change the amount of time that pressure is applied to the tie closure. Default is 0.7 seconds.
 - i. Press the white numeric entry button next to "CUT/CLAMP TIME". A new screen with a keypad will appear. The current clamp time setting is shown at the bottom right of the screen.
 - ii. Use the keypad to enter the desired clamp time. You must enter two digits (0-7 = 0.7 seconds).
 - iii. Press the **Enter** button to set your tie length and return to the Main Screen.

C. Function buttons

1.  JOG button: Press and hold the Jog button to feed tie off the spool. Use this to string up the Applier machine.

2.  COUNTER button: Use to access the Counter Screen.
 - i. TOTAL COUNT: Total machine cycles: This cannot be changed.
 - ii. KNIFE COUNT: Total cycles for knife and anvil. Reset this after replacing knife and anvil.
 - iii. CYCLE COUNT: Total cycles for current production run. Reset as needed. This can also be accessed from the Main Screen.



Counter Screen

3.  MAINT/SETUP button: For factory diagnostics. Security code required.

3.2 String Up Procedure

Load the machine with Bedford Roll N Close[®] tie material. Peel off the release liner and spool it up on the Release Liner Spooler (Figure 3.1)

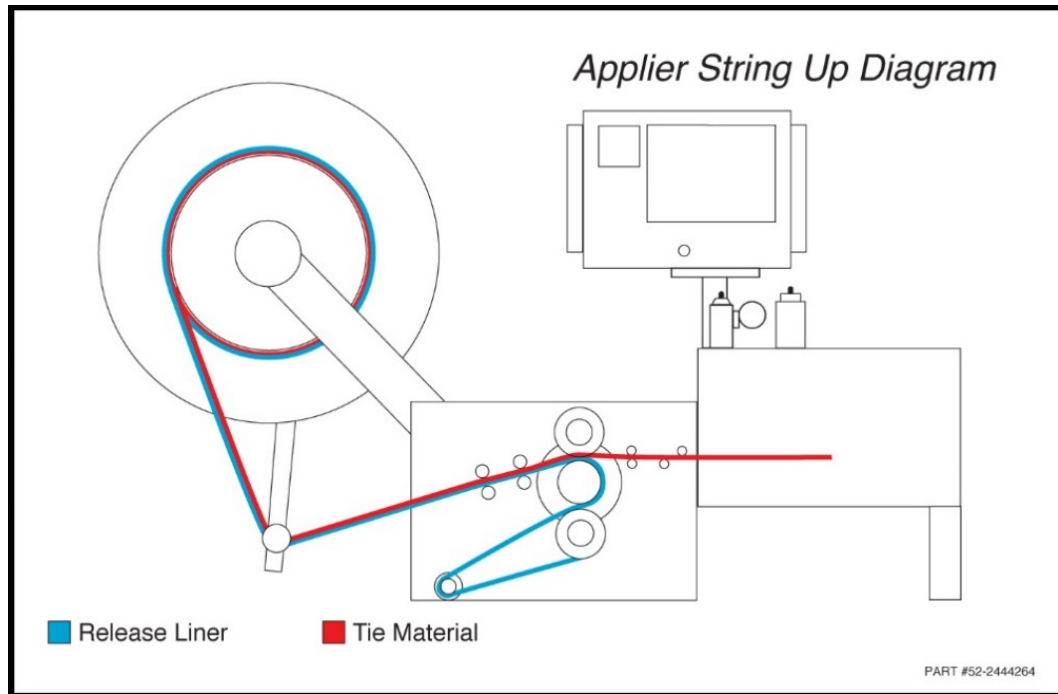


Figure 3.1 (String up Diagram)

- A. Turn the power off and load a spool of Bedford Roll N Close[®] tie material onto the Spool Adapter.
1. Remove the Adapter Flange from the Spool Adapter.
 2. Place the spool on the Spool Adapter so the tie material pulls off the left side (Figure 3.2)
 3. Put the Adapter Flange back on the Spool Adapter.
 4. Pull approximately 12" (30 cm) of tie material off the spool.
 5. Feed the tie through the hole in the Payout Guide.

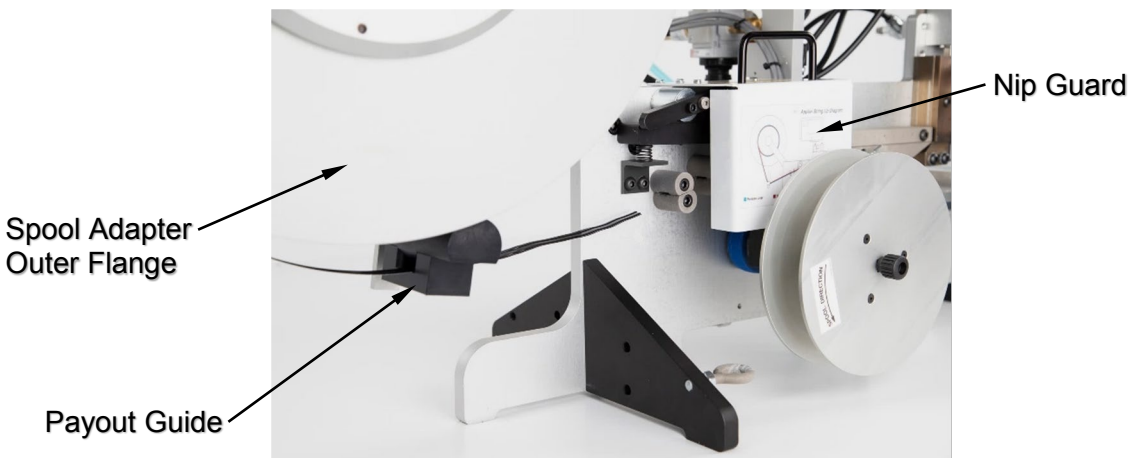
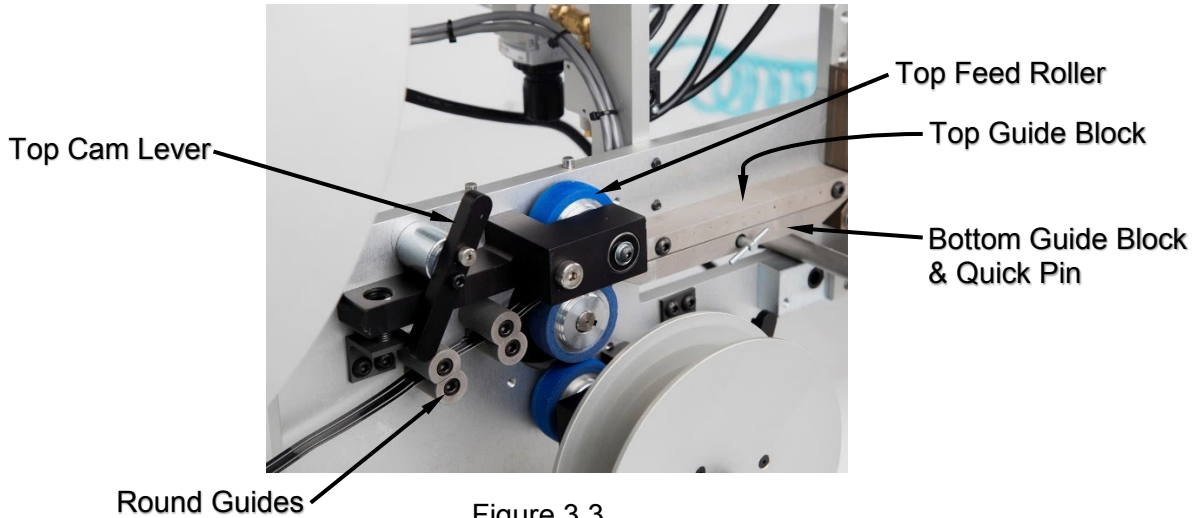
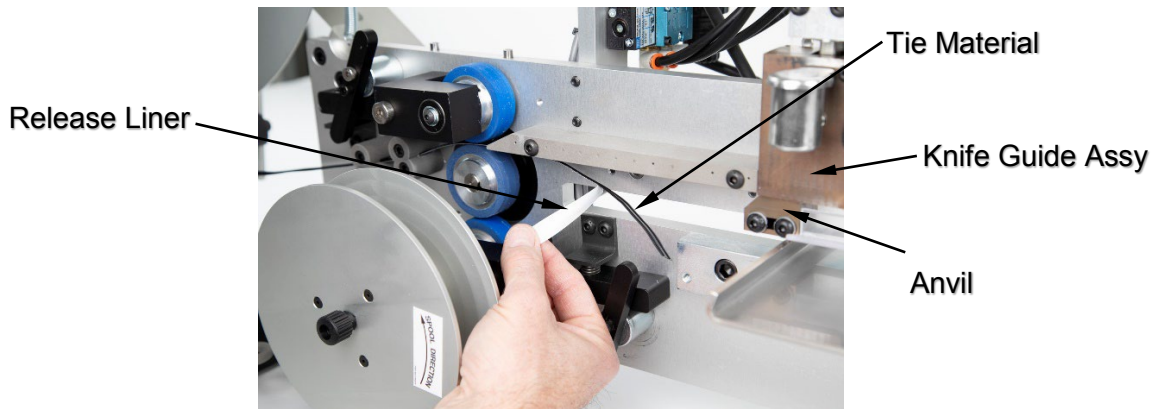


Figure 3.2

- B. Remove the Nip Guard so the feed rollers and guides are visible. **WARNING:** Nip Guard must be back in place before operating the machine.
- C. Turn the Top Cam Lever counterclockwise to open the Top Feed Roller.
- D. Pull the Quick Pin to release the Bottom Guide Block. The Quick Pin and the Bottom Guide Block should come out together.
- E. Feed the tie through the two sets of Round Guides and push it into the feed rollers.
- F. Put a slight downward bend on the end of the tie before you push it through the feed rollers. This will help guide the tie under the Top Guide Block.



- G. Turn the Spool Adapter so that more tie material is presented.
- H. Peel the release liner from the tie material. Push the end of the tie into the slot in the Knife Guide Assembly, just above the Anvil. (Figure 3.4)



- I. Turn the Bottom Cam Lever counterclockwise to open the Bottom Feed Roller. Pull the release liner tightly around the Middle Feed Roller (Figure 3.5). Then turn the Bottom Cam Lever back (clockwise) to close the Bottom Feed Roller.
- J. Turn the Top Cam Lever back (clockwise) to close the Top Feed Roller.



Figure 3.5

- K. Make sure the tie is sitting in the groove of the Top Guide Block (Figure 3.5). Replace the Bottom Guide Block and Quick Pin.
- L. Replace the Nip Guard and turn the power on. Push and hold the **JOG** button on the touchscreen so that more tie material feeds through the machine. Be sure to pull the release liner to the left as you do this. You will need about 18" of release liner. (Figure 3.6)
- M. Thread the release liner through the Eyelet Bolt. Unscrew the Thumb Knob on the front of the Release Liner Spooler and remove the Spooler Flange.

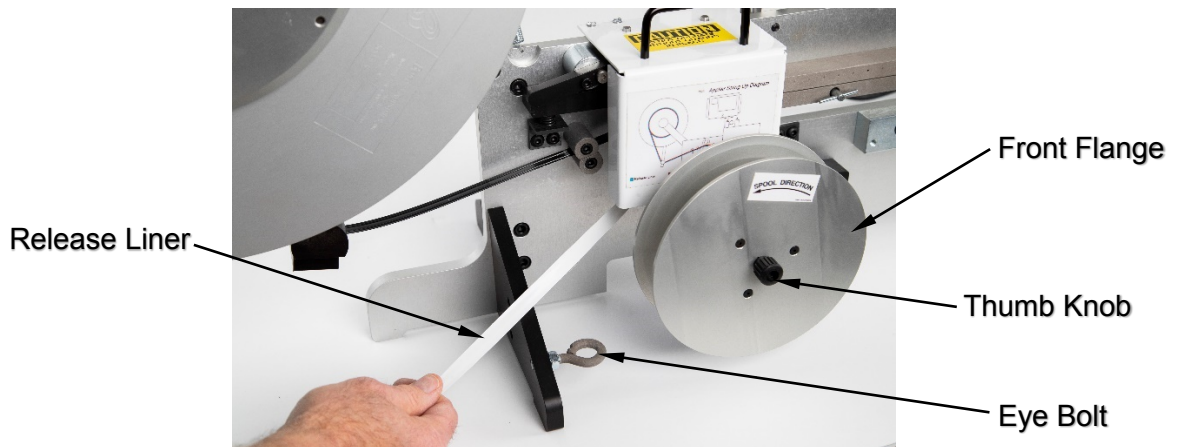


Figure 3.6

- N. Place the release liner in the notch on the Spooler Flange. (Figure 3.7)
- O. Replace the Spooler Flange, pinching the release liner between the two flanges. Replace the Thumb Knob and tighten it against the Spooler Flange. (Figure 3.8)

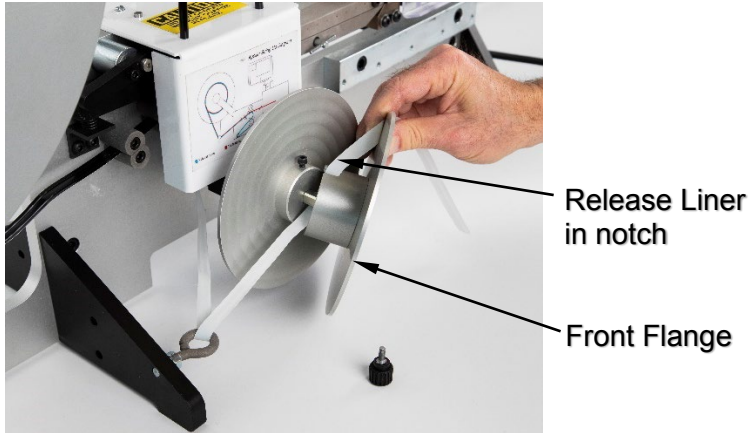


Figure 3.7

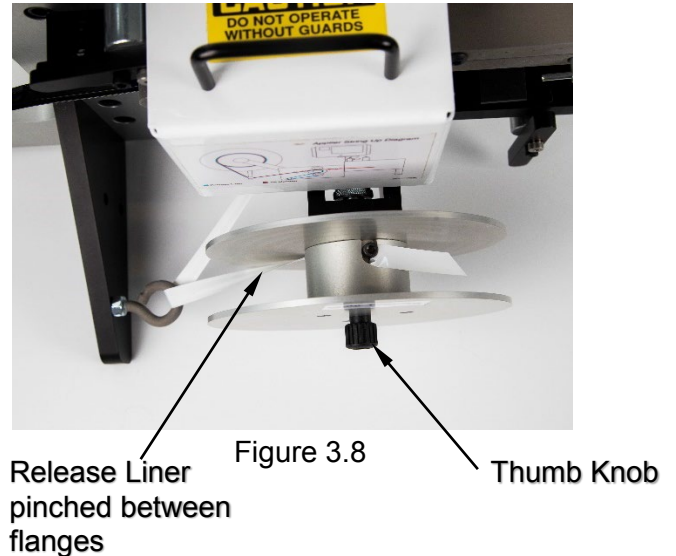
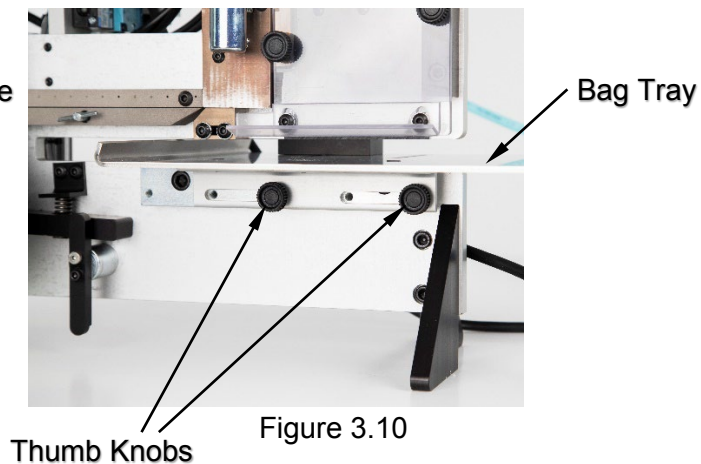
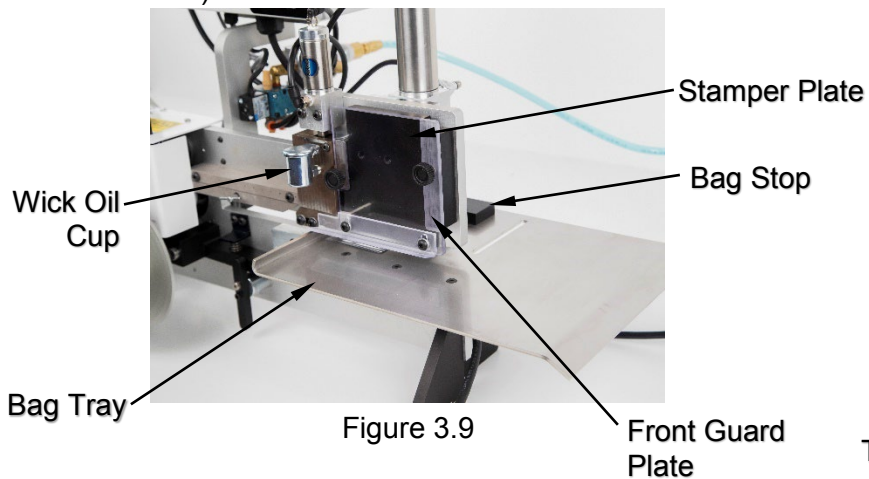


Figure 3.8

- P. Turn the spool counterclockwise until the release liner is tight.
- Q. Check the touch screen and make sure the "TIE LENGTH" is set for the desired tie length (refer to section **3.1 HMI Touchscreen Operation**)
- R. Place a bag or other material under the Stamper Plate.
- S. Cycle the machine three times by depressing the footswitch. Three cycles will allow the machine to adjust to the correct "TIE LENGTH".
- T. Measure the length of the last tie you just cut. Verify that it is cut to the correct length.
- U. If the tie is not cut to the correct length, then adjust the "TIE LENGTH".

3.3 Bag Stop Set Up

- A. Once you have strung up the Applier with machine with Bedford Roll N Close® tie material, and you have set the “TIE LENGTH”, you are ready to set up the machine for your bag.
- B. The top end of the bag is placed against the left side of the Bag Tray. The black Stamper Plate is located above the Bag Tray. The black Bag Stop is mounted on the backside of the Bag Tray. (Figure 3.9)



- C. Bag Tray: used to place the tie closure the desired distance from the top of the bag.
 - 1. Loosen the two Thumb Knobs on the bottom front side of the Applier machine, under the Bag Tray. (Figure 3.10)
 - 2. The distance from the Anvil to the left side of the Bag Tray determines how far the tie closure will be from the top end of the bag.
 - 3. Move the Bag Tray left or right so the left side of the Bag Tray is set at the desired distance from the Anvil.
 - 4. Tighten the two Thumb Knobs to lock the Bag Tray in place.

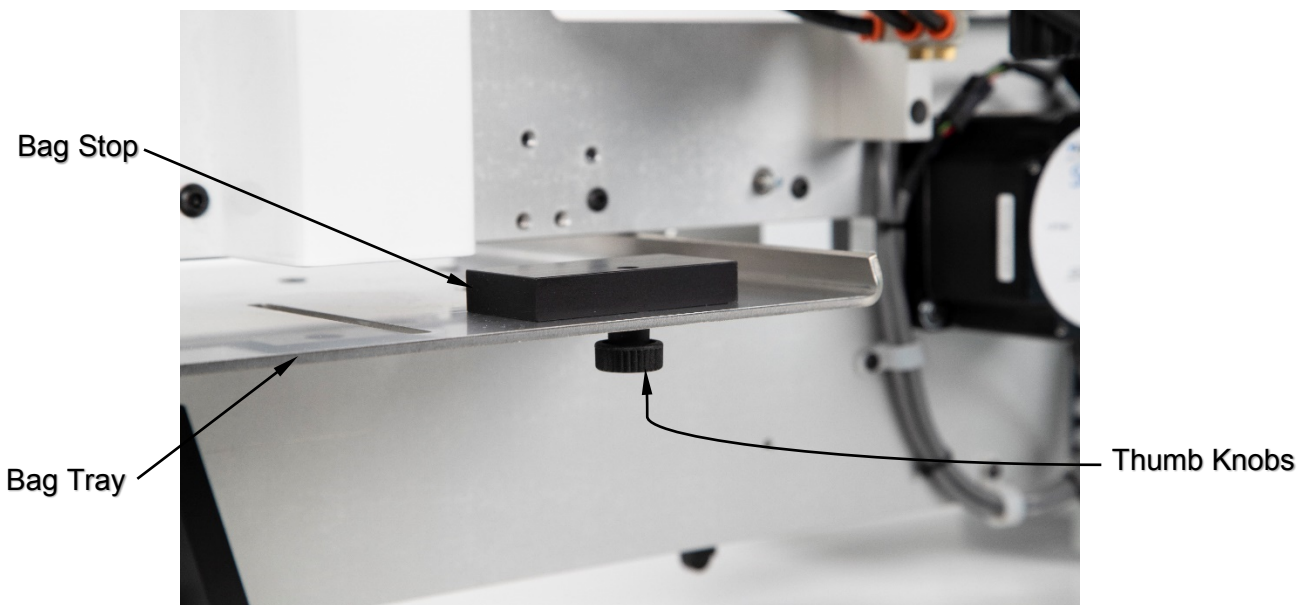


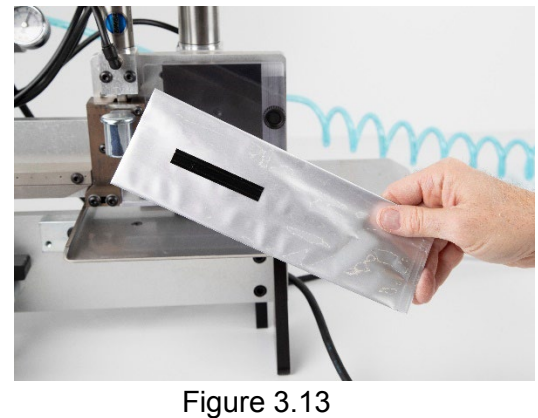
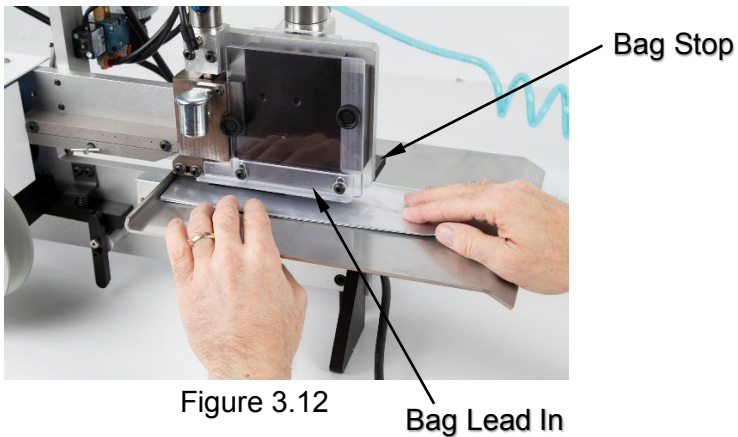
Figure 3.11

D. Bag Stop: used to position the bag under the tie closure before the Stamper Plate places the tie closure onto the bag.

1. Loosen the thumb knob on the bottom of the Bag Stop. (Figure 3.11)
2. Slide the Bag Stop in or out to the desired position.
3. Tighten the thumb knob to lock the Bag Stop in place.

3.4 Machine Operation

- A. Make sure the machine is connected to the proper power supply (refer to section **2.0 Installation**). Connect machine to air supply and make sure the pressure regulator is set at 90 psi. Make sure the Nip Guard is in place.
- B. String up the machine with Bedford Roll N Close® tie material and set the machine up for the desired tie length (refer to section **3.2 String Up Procedure**).
- C. Applying tie closure to an empty bag.
 1. Place the bag on the Bag Tray. Slide the bag to the left until it comes into contact with the left edge of the Bag Tray. (Figure 3.12)
 2. Slide the bag forward, under the Bag Lead In, until it touches the Bag Stop.
 3. Depress the foot switch to cycle the machine and apply the tie closure.
 4. Slide the bag out of the machine. The Applier is ready for another bag. (Figure 3.13)



- D. When starting a new spool, apply tie to three bags and check the length of the tie closure.
 1. Check the placement of the tie closure on the bag.
 2. If the tie is cut to the proper length, and it is placed in the correct position on the bag, then the machine is ready for operation.

4.0 Maintenance

CAUTION: Power should be disconnected before performing any maintenance.

4.1 Parts Inspection

Inspect all tie guides and knife components for wear and adhesive build up (*Reference Figure 4.1*). Adhesive build up can cause the tie material to jam or affect the knife's ability to cut the material.

A. Silicone Feed Rollers

1. Remove Nip Guard by pulling up on handle.
2. Release pressure on Feed Rollers by turning the Cam Levers on the top and bottom rollers.
3. Turn feed rollers by hand and inspect for adhesive build up. If needed, clean by applying 3M Adhesive Remover to a clean rag and wipe down rollers.
4. Inspect the Feed Rollers for cuts or grooves worn in the outer silicone layer. Check the inner silicone layer to see that it is not separating from the metal hub.

B. Round Guides

1. Remove the bolts that hold the two top Round Guides. You can leave the bottom guides in place.
2. Clean all four Round Guides by applying 3M Adhesive Remover to a clean rag and wiping down the parts.
3. Inspect the non-stick coating in the grooves of all four Round Guides.
4. Replace Round Guides if there is excessive wear.

C. Bottom Guide Block

1. Pull the Quick Pin to release the Bottom Guide Block. The Quick Pin and the Bottom Guide Block should come out together.
2. Clean the Bottom Guide Block by applying 3M Adhesive Remover to a rag and wiping down the part.
3. Inspect the non-stick coating on the Bottom Guide Block.
4. Replace the Bottom Guide Block if there is excessive wear.

D. Top Guide Block

1. You can either leave the Top Guide Block in place, or remove it by removing the two bolts holding it to the machine base.
2. Clean the groove in the Top Guide Block by applying 3M Adhesive Remover to a rag and wiping it down.
3. Inspect the non-stick coating in the groove of the Top Guide Block.
4. Replace the Top Guide Block if there is excessive wear.

E. Knife Assembly

1. To access the Knife Assembly, remove the two bolts holding the Knife Plate.
2. Inspect the Knife Assembly and the back of the Knife Plate for adhesive build up. Remove any adhesive by applying 3M Adhesive Remover to a rag and wiping it down.
3. Inspect the Knife and Anvil for excessive wear. Replace these parts if needed.
4. The Knife Assembly needs to be lubricated in order to work properly. Apply a few drops of light mineral oil to the Knife Assembly before replacing the Knife Plate.

F. Stamper Assembly

1. Remove the Front Cover Plate by removing the two thumbscrews.
2. Clean the front side and bottom side of the Stamping Block by applying 3M Adhesive Remover to a rag and wiping them down.
3. Clean all sides of the Front Cover Plate with 3M Adhesive Remover. Then re-attach to the machine using the thumbscrews.

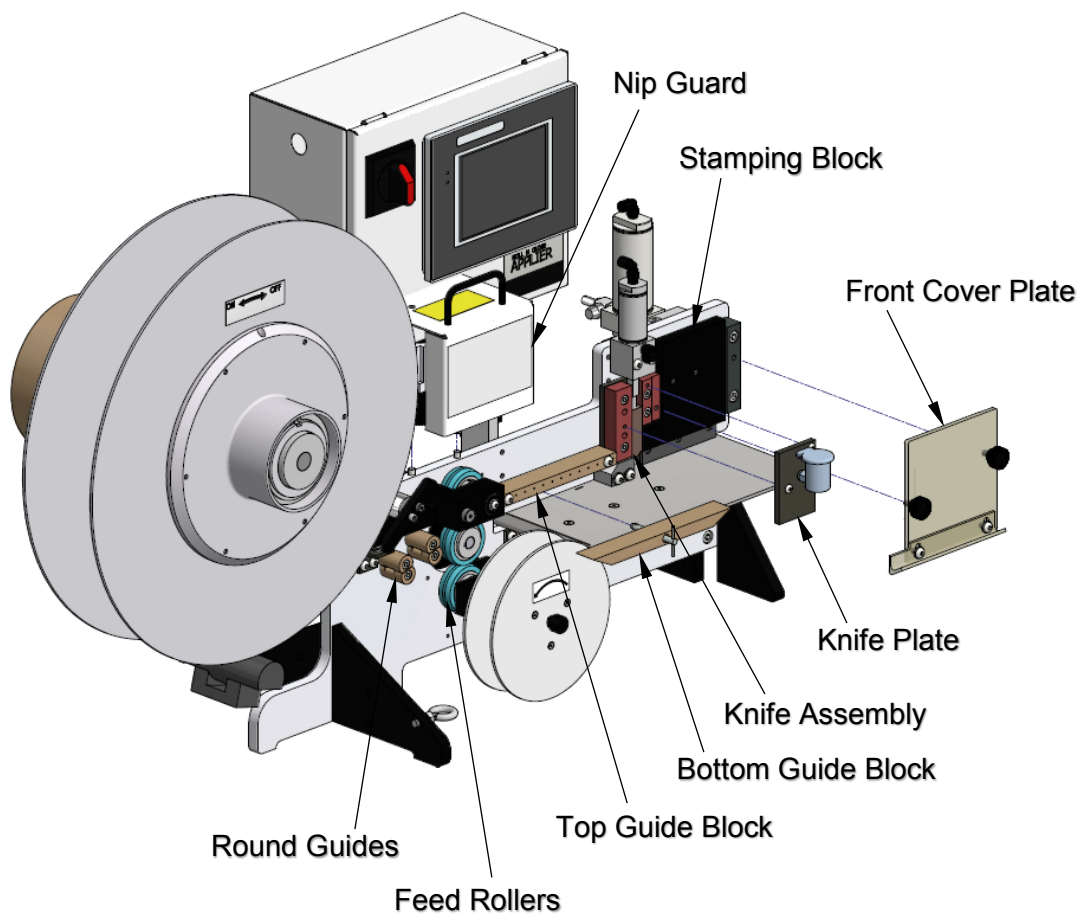


Figure 4.1

4.2 Lubrication

A. Wicked Oiler

1. Check the oil level in the Wick Oil Cup every 6 months. Make sure it has a small amount of light mineral oil in it.
2. The Wick Oil Cup requires only 0.1 oz (3 ml) of light mineral oil. Just enough to cover the bottom of the oil cup. **Do Not Overfill.**

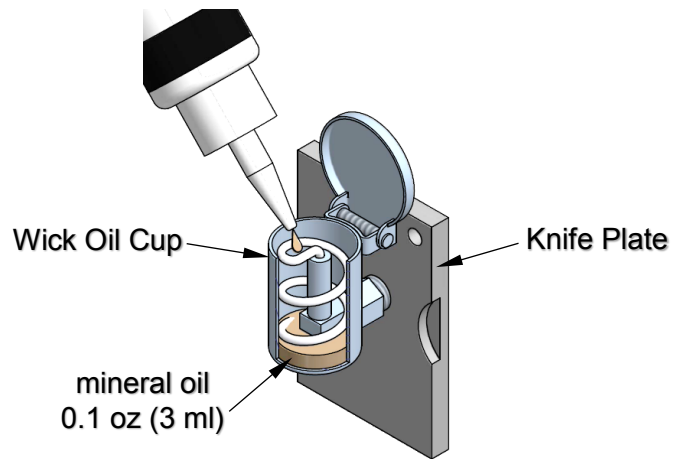


Figure 4.2

5.0 Troubleshooting

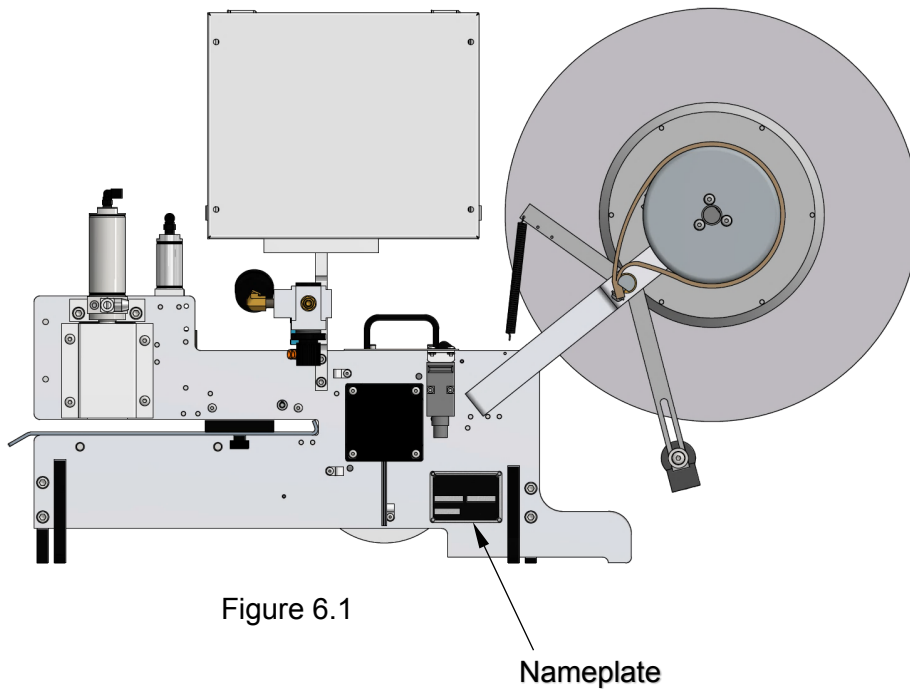
Problem	Possible Cause	Corrective Action
Machine does not run	No power No air Amperage overload	Check power cord and circuit breaker Check air supply Check fuse in control panel
Machine does not cut	Adhesive build up on knife assembly Air pressure is too low Knife or Anvil is dull	Clean with 3M Adhesive Remover Increase air pressure on regulator (min 90 psi) Replace or re-sharpen knife and anvil
Tie material does not feed	Feed rollers are open Tie material is not strung up correctly Tie material is tangled on spool adapter Adhesive build up on the tie guides	Turn cam levers to close the feed rollers Refer to section 3.2 Untangle the tie material Clean the guides with 3M Adhesive Remover
Machine does not cut the correct length	Tie Length is not set correctly Tie material is not strung up correctly Tie material is tangled on spool adapter	Adjust Tie Length on the HMI screen. Refer to section 3.1 Refer to section 3.2 Untangle the tie material
Tie closure does not stick to bag	The "CUT/CLAMP TIME" is not long enough Air pressure is too low Front guard plate is not in place Tie bounced off stamper block	Refer to section 3.1 and increase clamp time (minimum of 0.7 sec) Increase air pressure on regulator (minimum 90psi) Put front guard plate in place Change the timing of the air cylinders by adjusting the set screw on the back of the flow control valve
Left end of tie closure is bent up	Adhesive build up on knife assembly Stamper plate moves before tie is cut	Clean with 3M adhesive remover Change the timing of the air cylinders by adjusting the set screw on the back of the flow control valve
Tie closure is bowed down	Bottom guide block is not in place Too much pressure on the top feed roller	Put bottom guide block in place Adjust set screw on top arm assembly (no more than 1 ½ turns total)
Release liner breaks	Adhesive build up on the feed rollers	Clean with 3M adhesive remover

	Adhesive build up on the tie guides Too much pressure on the bottom feed roller Too little pressure on the bottom feed roller	Clean with 3M adhesive remover Loosen set screw on bottom arm assembly tighten set screw on bottom arm assembly
Release liner does not spool up	Bottom feed roller is open Clutch on bottom arm assembly is not working	Turn cam lever to close feed roller Increase tension on clutch, or replace clutch

6.0 Mechanical Drawings

The Roll N Close[®] Applier assembly drawing shows all of the parts and where they are located on the machine. The other drawings are of common replacement parts and the sub-assemblies where they are found.

When ordering parts, locate the machine nameplate on the back of the machine (example shown in Figure 6.1) and provide the model number and serial number with your request for parts. This information will aid in providing quick and accurate service from Bedford Industries or any machine distributor that provides parts for the Bedford Roll N Close[®] Applier machine.



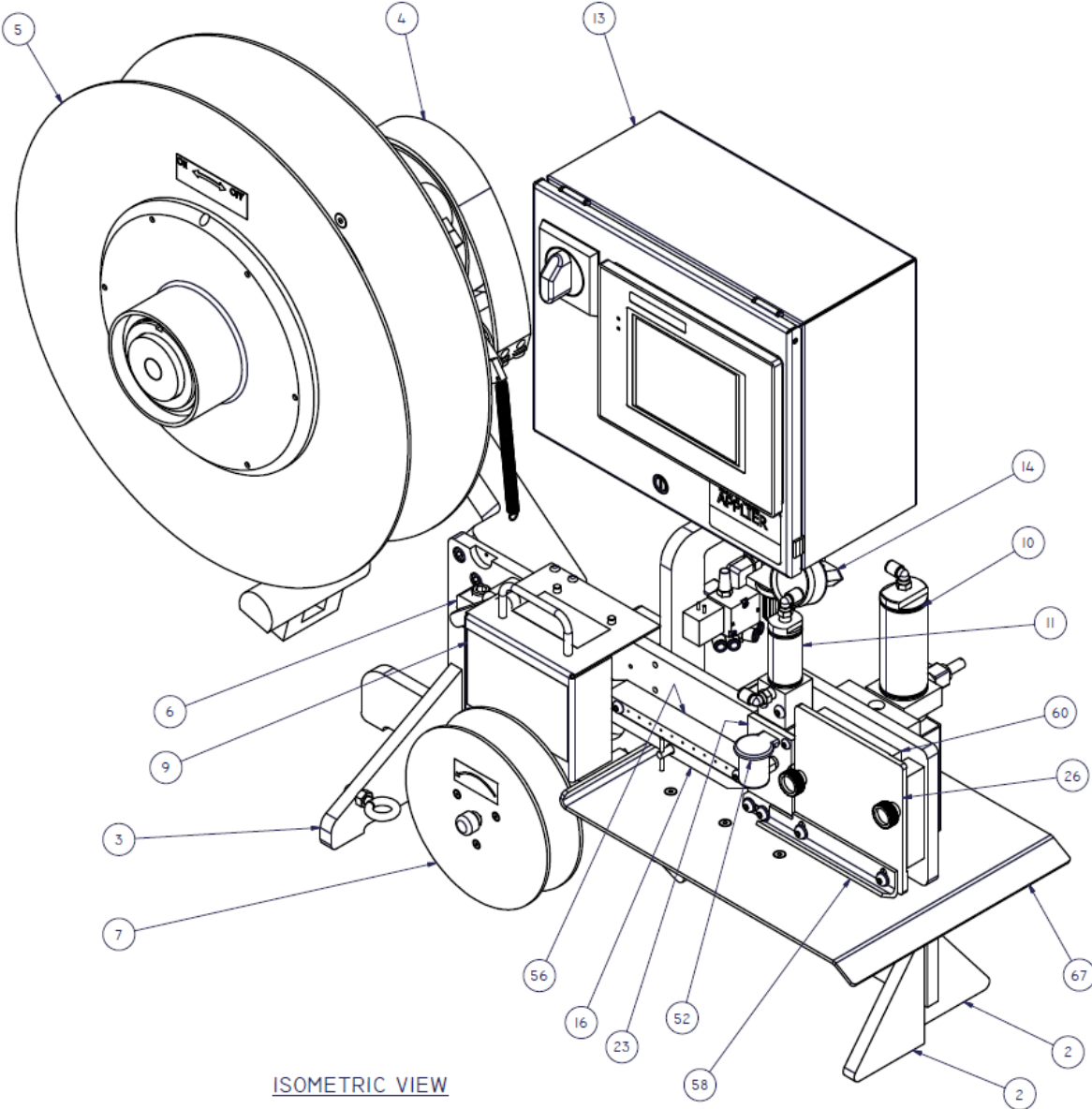
Model Number _____ Serial Number _____

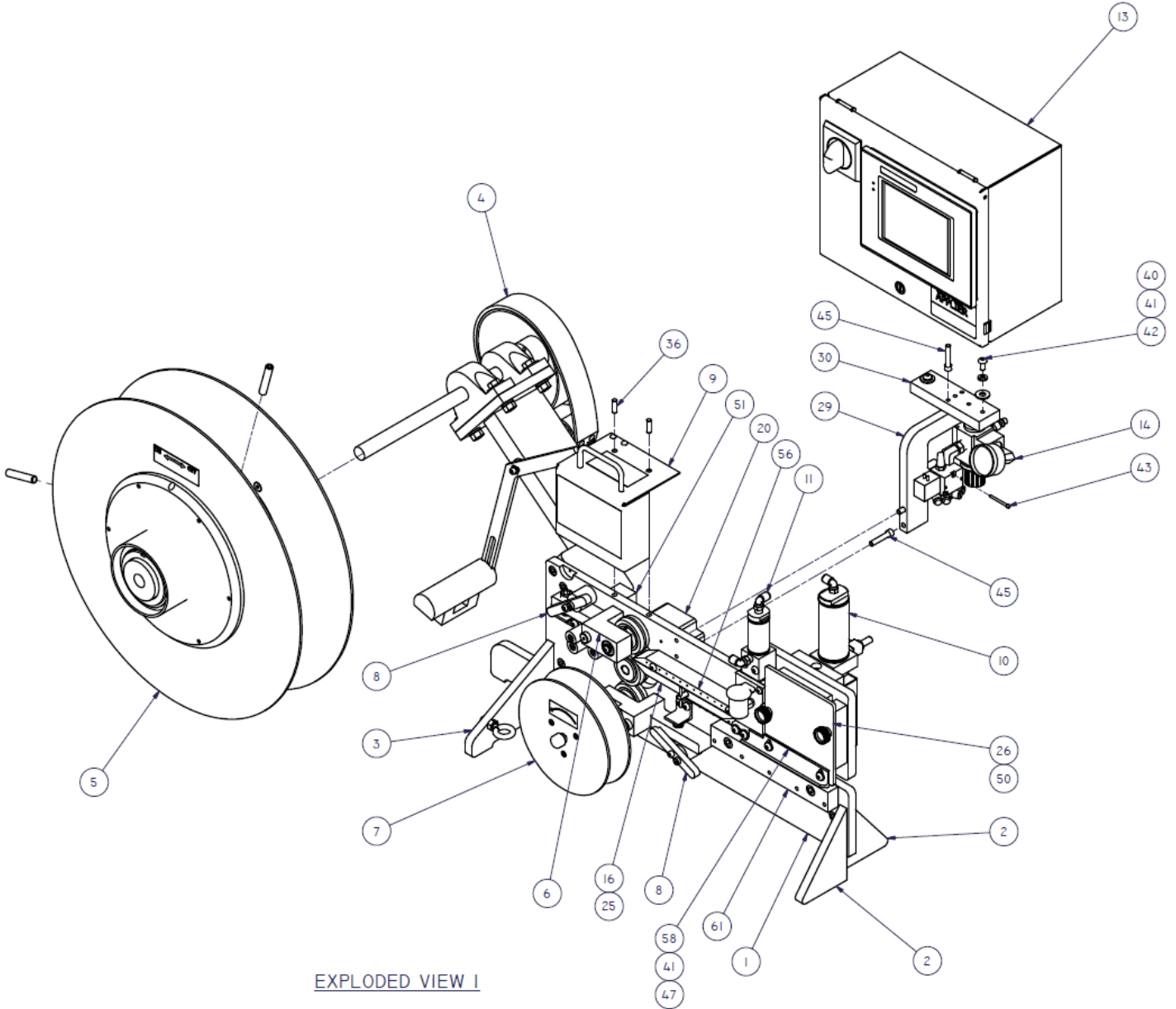


6.1 Machine Assembly Drawings for Model 55-A

Assembly Part Number: 55-2019016000 .50 Roll N Close Applier Assembly, Model 55-A

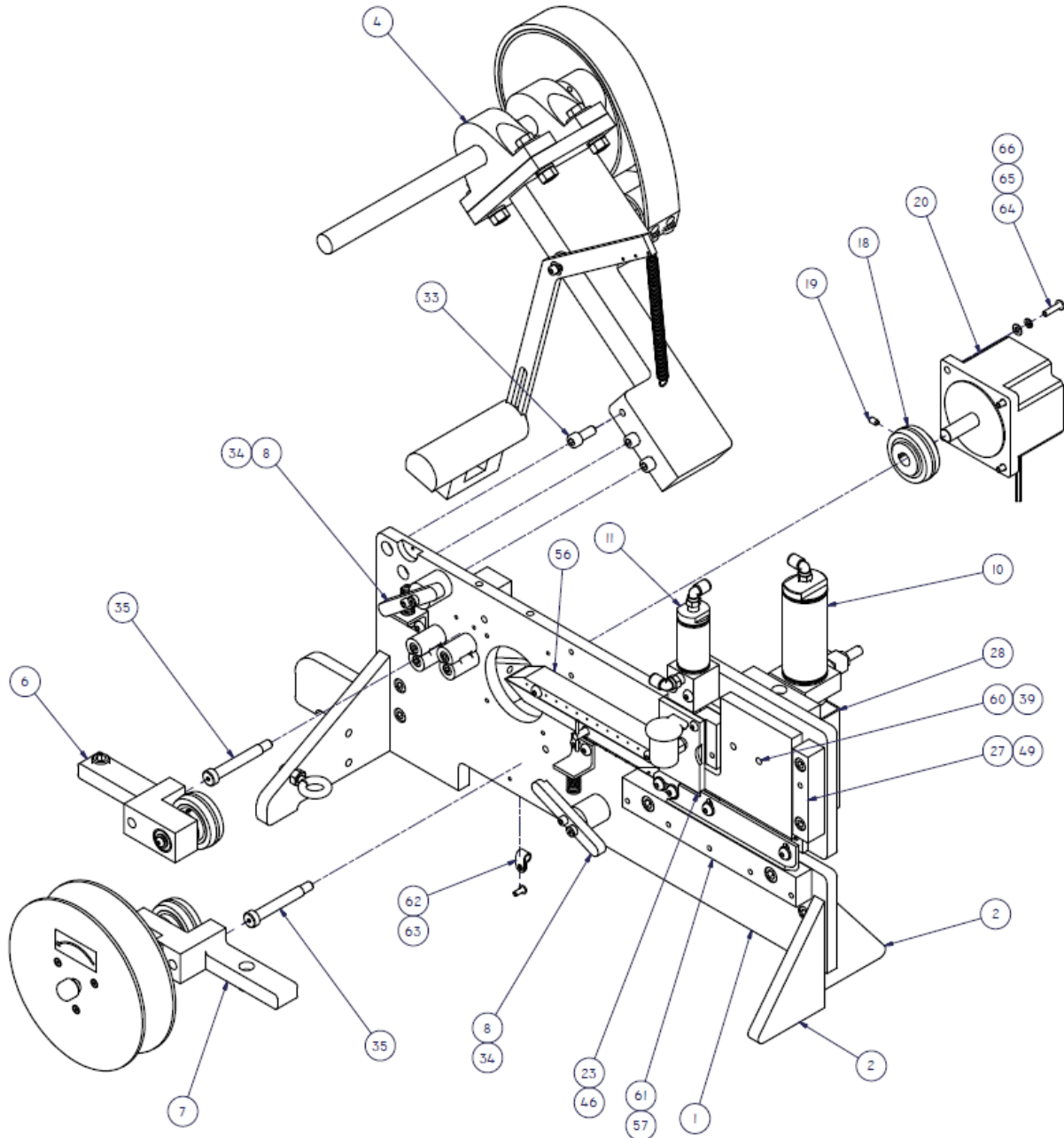
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	55-2019016001	BASEPLATE, RNC APLIER
2	2	52-2444138	SMALL LEG
3	2	52-2743024	FRONT LEG
4	1	52-2743180	SPOOL PAYOUT ASSY, APPLIER
5	1	52-2743030	SPOOL ADAPTER, APPLIER 6" CORE, 18" FLANGE
6	1	52-2743205	TOP ARM ASSEMBLY, APPIER
7	1	52-2743219	BOTTOM ARM ASSEMBLY, APPIER
8	2	52-2743217	CAM LEVER ASSEMBLY, APPLIER
9	1	52-2743263	NIP GUARD ASSEMBLY, APPLIER
10	1	55-2515001	CYLINDER ASSY, STAMPING BLOCK
11	1	52-2743350	KNIFE CYLINDER ASSY
12	1	55-2019016070	KNIFE GUIDE ASSY 1/2", RNC APPLIER
13	1	55-2019016E01	CONTROL PANEL ASSY
14	1	55-2019016060	PNEUMATIC ASSEMBLY, RNC APPLIER
15	1	52-2444293	EYELET BOLT
16	1	55-2019016002	BOTTOM GUIDE BLOCK 1/2", RNC APPLIER
17	4	55-2019016012	ROUND GUIDE 1/2", RNC APPLIER
18	1	52-2743025	SILICONE FEED ROLLER, APPLIER
19	1	52-1032516SS	HEXAGON SOCKET SET SCREW - FLAT POINT
20	1	52-STP-MTR-34066	STEPPER MOTOR
21	2	52-2444121	SPRING STOP
22	2	52-S1530	COMPRESSION SPRING
23	1	52-2444407	KNIFE PLATE
24	1	52-2743241	ANVIL, APPLIER
25	1	52-FPD110	QUICK PIN
26	1	55-2019016003	FRONT GUARD PLATE, RNC APPLIER
27	1	52-2743221	STAMP HOUSING SPACER, APPLIER
28	1	55-2515035	CYLINDER GUARD
29	1	55-2019016015	VERTICAL MOUNT, RNC APPLIER
30	1	55-2019016016	BASE SUPPORT, RNC APPLIER
31	1	52-8491A232	DRILL BUSHING
32	8	52-5161812CH	HEXAGON SOCKET HEAD CAP SCREW
33	7	52-5161834CH	HEXAGON SOCKET HEAD CAP SCREW
34	2	52-90298A546	SHOULDER SCREW, 1/4 x 1-1/2, 10-24 THREAD
35	2	52-90298A633	SHOULDER SCREW, 3/8 x 2-1/4, 5/16-18 THREAD
36	2	52-1434DP	PIN - UNHARDENED GROUND DOWEL
37	2	52-1420134BH	SCREW, BUTTON HEAD SOCKET
38	4	52-14201CH	SCREW, SOCKET HEAD CAP 1/4-20 x 1
39	2	52-51618112CH	HEXAGON SOCKET HEAD CAP SCREW
40	2	52-14FW	PLAIN WASHER
41	6	52-14LW	REGULAR HELICAL SPRING LOCK WASHER
42	10	52-142012BH	HEXAGON SOCKET BUTTON HEAD CAP SCREW
43	2	52-440114CH	CAP HEAD 4-40x1-1/4
44	4	52-142012BH	HEXAGON SOCKET BUTTON HEAD CAP SCREW
45	8	52-1420114CH	HEXAGON SOCKET HEAD CAP SCREW
46	4	52-102412BH	HEXAGON SOCKET BUTTON HEAD CAP SCREW
47	2	52-142038BH	HEXAGON SOCKET BUTTON HEAD CAP SCREW
48	3	52-83238BH	HEXAGON SOCKET BUTTON HEAD CAP SCREW
49	2	52-516181CH	CAP HEAD 516-18 x 1
50	4	52-JCL515	THUMB KNOB
51	1	52-AZ1711ZK	SAFETY SWITCH
52	1	52-1223K2	WICK OIL CUP
53	1	52-138915	BEDFORD NAMEPLATE
54	4	52-91654A076	SCREW NAIL, #2 x 3/16, S.S.
55	2	52-836114CH	HEXAGON SOCKET HEAD CAP SCREW
56	1	55-2019016010	TOP GUIDE BLOCK ASSY 1/2"
57	2	52-38161CH	SCREW, SOCKET HEAD CAP
58	1	55-2019016004	BAG LEAD-IN TOP, RNC APPLIER
59	1	55-2019016006	LINEAR SLIDE BACK, RNC APPLIER
60	1	55-2019016020	STAMPER ASSY 1/2", RNC APPLIER
61	1	55-2019016022	ELEVATED STOP, RNC APPLIER
62	3	52-7625K	1/4" CABLE CLAMP
63	3	52-83238BH	HEXAGON SOCKET BUTTON HEAD CAP SCREW
64	4	52-102434BH	HEXAGON SOCKET BUTTON HEAD CAP SCREW
65	4	52-10LW	REGULAR HELICAL SPRING LOCK WASHER
66	4	52-10FW	PLAIN WASHER
67	1	55-2019016030	BAG TRAY ASSY, RNC APPLIER
68	1	55-2019016034	BAG COVER PLATE
69	4 ft	52-1B-048-01	TUBING PE BLACK .250 OD X .170ID





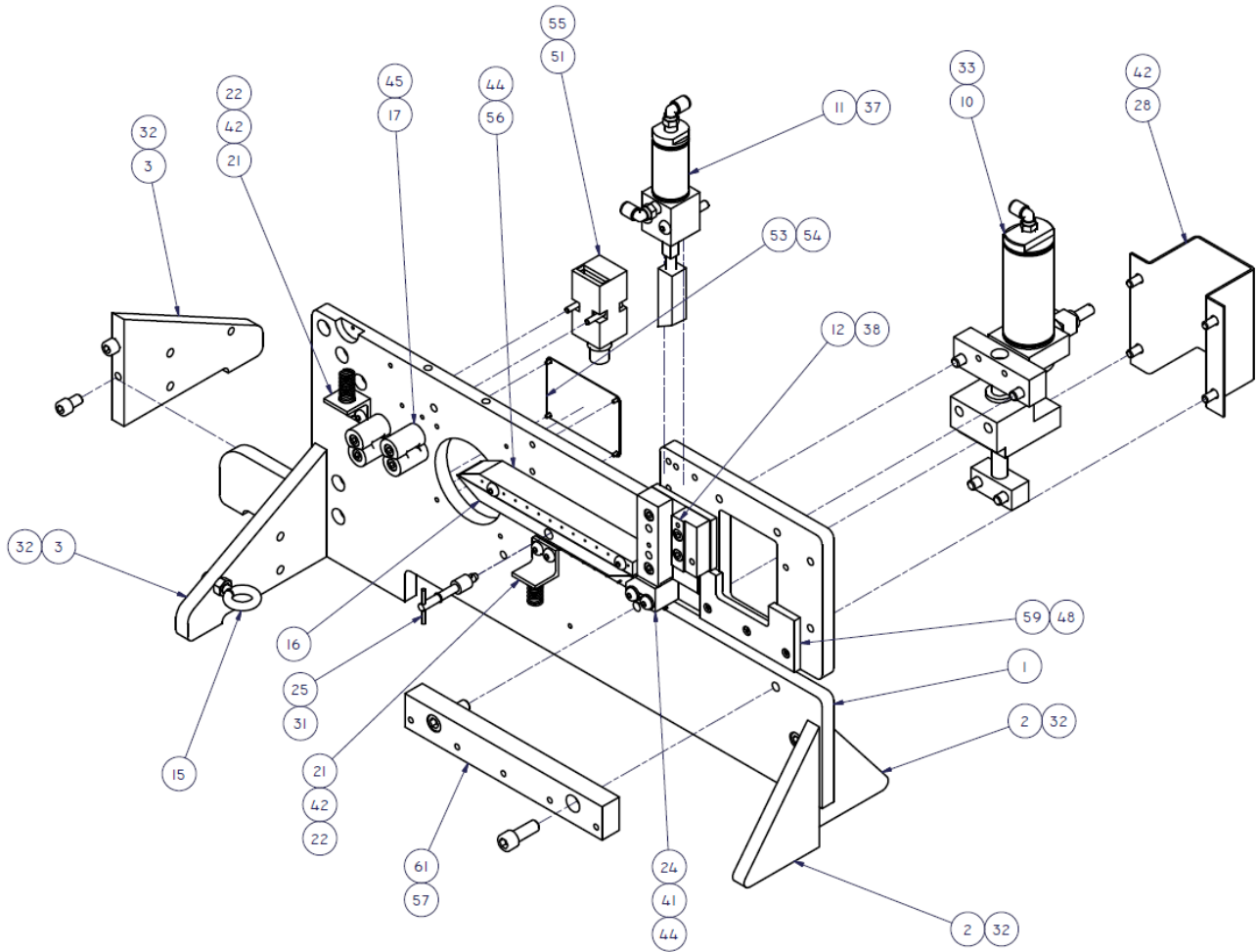
EXPLODED VIEW I

Assembly Part Number: 55-2019016000 .50 Roll N Close Applier Assembly, **Model 55-A**



EXPLODED VIEW 2

Assembly Part Number: 55-2019016000 .50 Roll N Close Applier Assembly, **Model 55-A**



EXPLODED VIEW 3

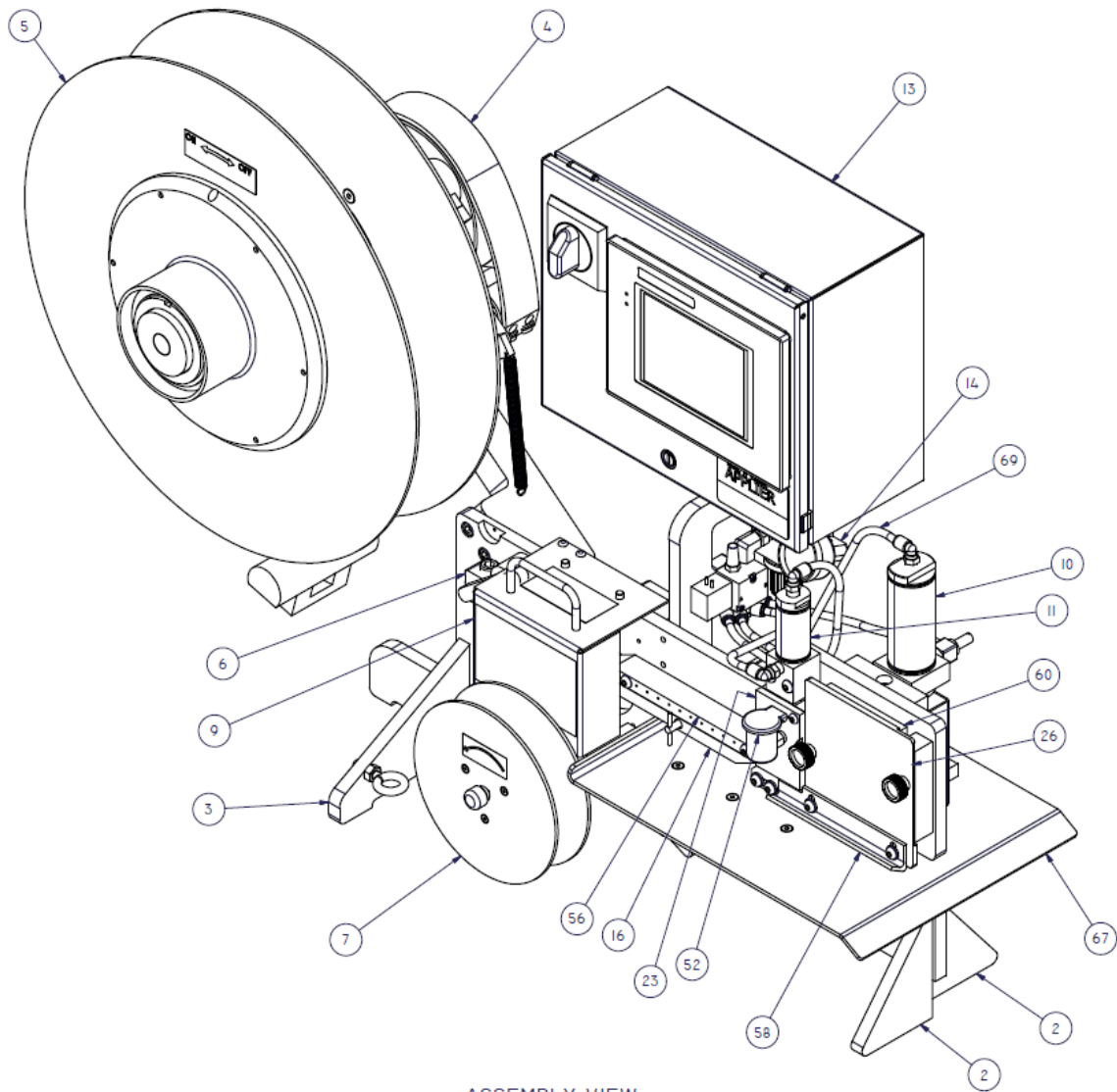


6.2 Machine Assembly Drawings for Model 55-F

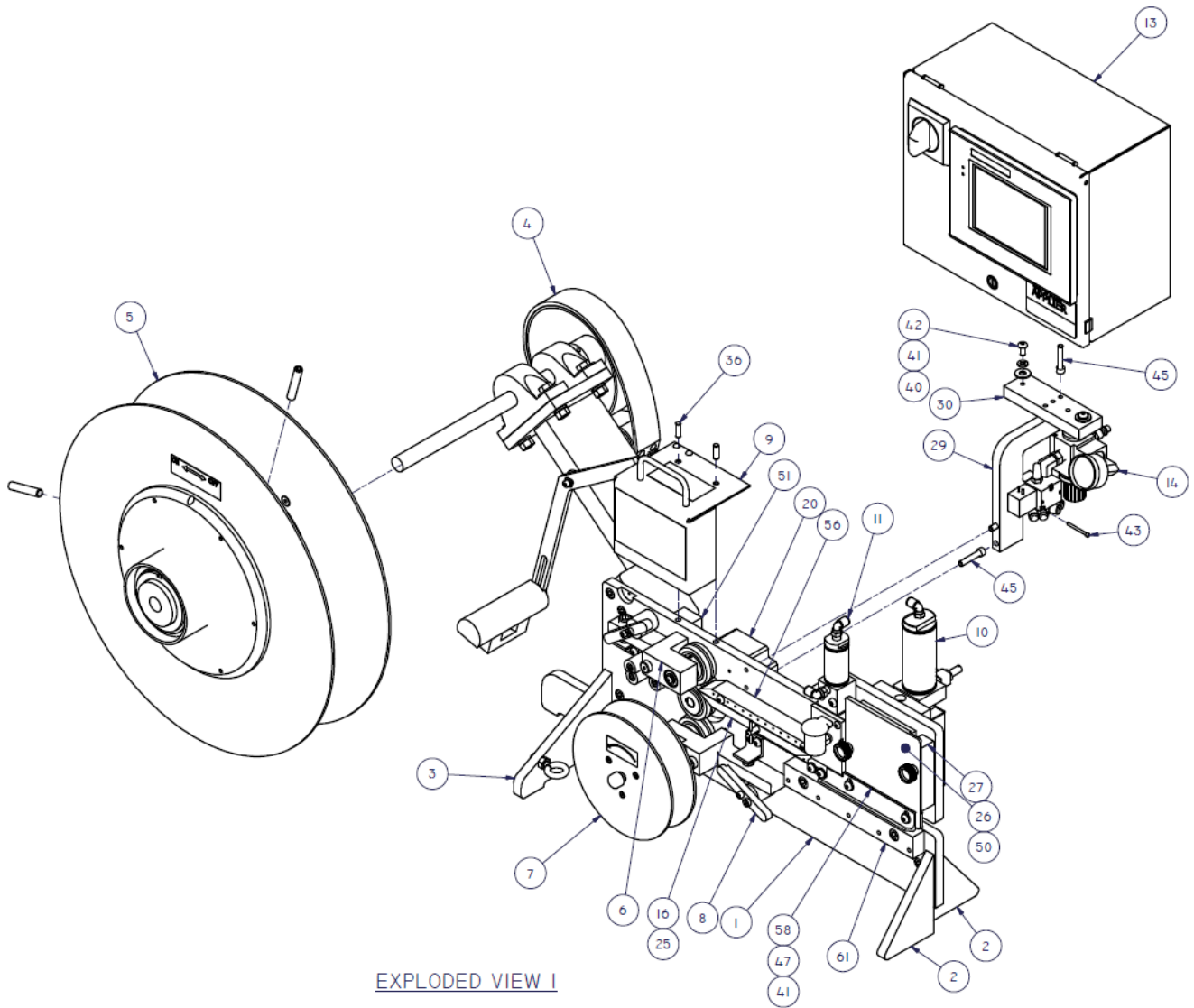
Assembly Part Number: 55-2019016800 .315 Roll N Close Applier Assembly, Model 55-F

ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	55-2019016001	BASEPLATE, RNC APLIER
2	2	52-2444138	SMALL LEG
3	2	52-2743024	FRONT LEG
4	1	52-2743180	SPOOL PAYOUT ASSY, APPLIER
5	1	52-2743030	SPOOL ADAPTER, APPLIER 6" CORE, 18" FLANGE
6	1	52-2743205	TOP ARM ASSEMBLY, APPIER
7	1	52-2743219	BOTTOM ARM ASSEMBLY, APPIER
8	2	52-2743217	CAM LEVER ASSEMBLY, APPLIER
9	1	52-2743263	NIP GUARD ASSEMBLY, APPLIER
10	1	55-2515001	CYLINDER ASSY, STAMPING BLOCK
11	1	52-2743350	KNIFE CYLINDER ASSY
12	1	52-2743050	KNIFE GUIDE ASSY .315" RNC APPLIER
13	1	55-2019016E01	CONTROL PANEL ASSY
14	1	55-2019016060	PNEUMATIC ASSEMBLY, RNC APPLIER
15	1	52-2444293	EYELET BOLT
16	1	55-2019016002	BOTTOM GUIDE BLOCK 1/2", RNC APPLIER
17	4	52-2743018	ROUND GUIDE .315" RNC APPLIER
18	1	52-2743025	SILICONE FEED ROLLER, APPLIER
19	1	52-1032516SS	HEXAGON SOCKET SET SCREW - FLAT POINT
20	1	52-STP-MTR-34066	STEPPER MOTOR
21	2	52-2444121	SPRING STOP
22	2	52-S1530	COMPRESSION SPRING
23	1	52-2444407	KNIFE PLATE
24	1	52-2743241	ANVIL, APPLIER
25	1	52-FPD110	QUICK PIN
26	1	55-2019016803	FRONT GUARD PLATE .315" RNC APPLIER
27	1	52-2743221	STAMP HOUSING SPACER, APPLIER
28	1	55-2515035	CYLINDER GUARD
29	1	55-2019016015	VERTICAL MOUNT, RNC APPLIER
30	1	55-2019016016	BASE SUPPORT, RNC APPLIER
31	1	52-8491A232	DRILL BUSHING
32	8	52-5161812CH	HEXAGON SOCKET HEAD CAP SCREW
33	7	52-5161834CH	HEXAGON SOCKET HEAD CAP SCREW
34	2	52-90298A546	SHOULDER SCREW, 1/4 x 1-1/2, 10-24 THREAD
35	2	52-90298A633	SHOULDER SCREW, 3/8 x 2-1/4, 5/16-18 THREAD
36	2	52-1434DP	PIN - UNHARDENED GROUND DOWEL
37	2	52-1420134BH	SCREW, BUTTON HEAD SOCKET
38	4	52-14201CH	SCREW, SOCKET HEAD CAP 1/4-20 x 1
39	2	52-51618112CH	HEXAGON SOCKET HEAD CAP SCREW
40	2	52-14FW	PLAIN WASHER
41	6	52-14LW	REGULAR HELICAL SPRING LOCK WASHER
42	10	52-142012BH	HEXAGON SOCKET BUTTON HEAD CAP SCREW
43	2	52-440114CH	CAP HEAD 4-40x1-1/4
44	4	52-1420112BH	HEXAGON SOCKET BUTTON HEAD CAP SCREW
45	8	52-1420114CH	HEXAGON SOCKET HEAD CAP SCREW
46	4	52-102412BH	HEXAGON SOCKET BUTTON HEAD CAP SCREW
47	2	52-142038BH	HEXAGON SOCKET BUTTON HEAD CAP SCREW
48	3	52-83238BH	HEXAGON SOCKET BUTTON HEAD CAP SCREW
49	2	52-516181CH	CAP HEAD 516-18 x 1
50	4	52-JCL515	THUMB KNOB
51	1	52-AZ1711ZK	SAFETY SWITCH
52	1	52-1223K2	WICK OIL CUP
53	1	52-138915	BEDFORD NAMEPLATE
54	4	52-91654A076	SCREW NAIL, #2 x 3/16, S.S.
55	2	52-836114CH	HEXAGON SOCKET HEAD CAP SCREW
56	1	55-2019016810	TOP GUIDE BLOCK ASSY .315" APPLIER
57	2	52-38161CH	SCREW, SOCKET HEAD CAP
58	1	55-2019016004	BAG LEAD-IN TOP, RNC APPLIER
59	1	55-2019016806	LINEAR SLIDE BACK .315" RNC APPLIER
60	1	55-2019016820	STAMPER ASSY .315" RNC APPLIER
61	1	55-2019016022	ELEVATED STOP, RNC APPLIER
62	3	52-7625K	1/4" CABLE CLAMP
63	3	52-83238BH	HEXAGON SOCKET BUTTON HEAD CAP SCREW
64	4	52-102434BH	HEXAGON SOCKET BUTTON HEAD CAP SCREW
65	4	52-10LW	REGULAR HELICAL SPRING LOCK WASHER
66	4	52-10FW	PLAIN WASHER
67	1	55-2019016830	BAG TRAY ASSY .315" RNC APPLIER
68	1	55-2019016034	BAG COVER PLATE
69	4 ft	52-1B-048-01	TUBING PE BLACK .250 OD X .170 ID

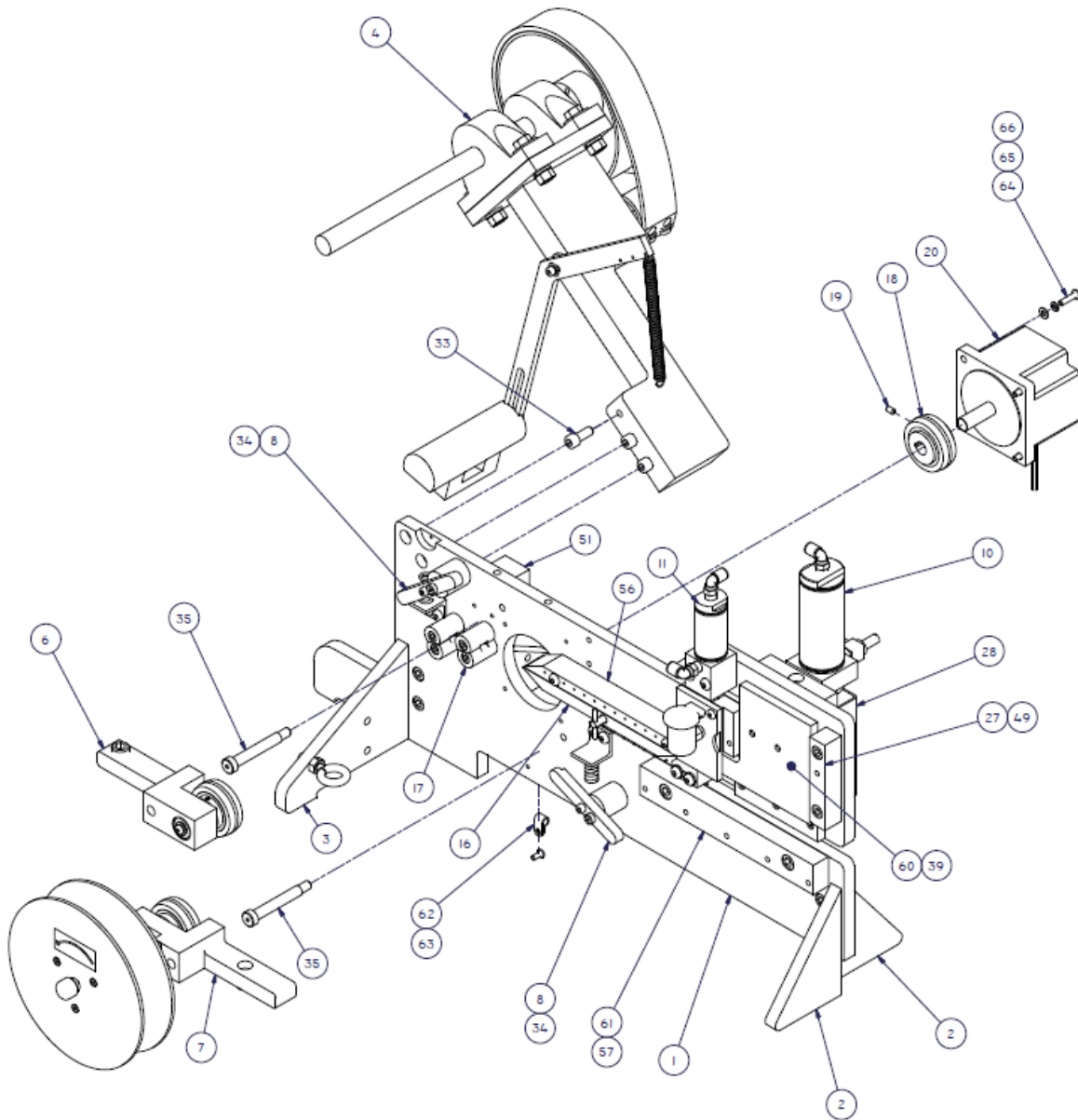
Assembly Part Number: 55-2019016800 .315 Roll N Close Applier Assembly, Model 55-F



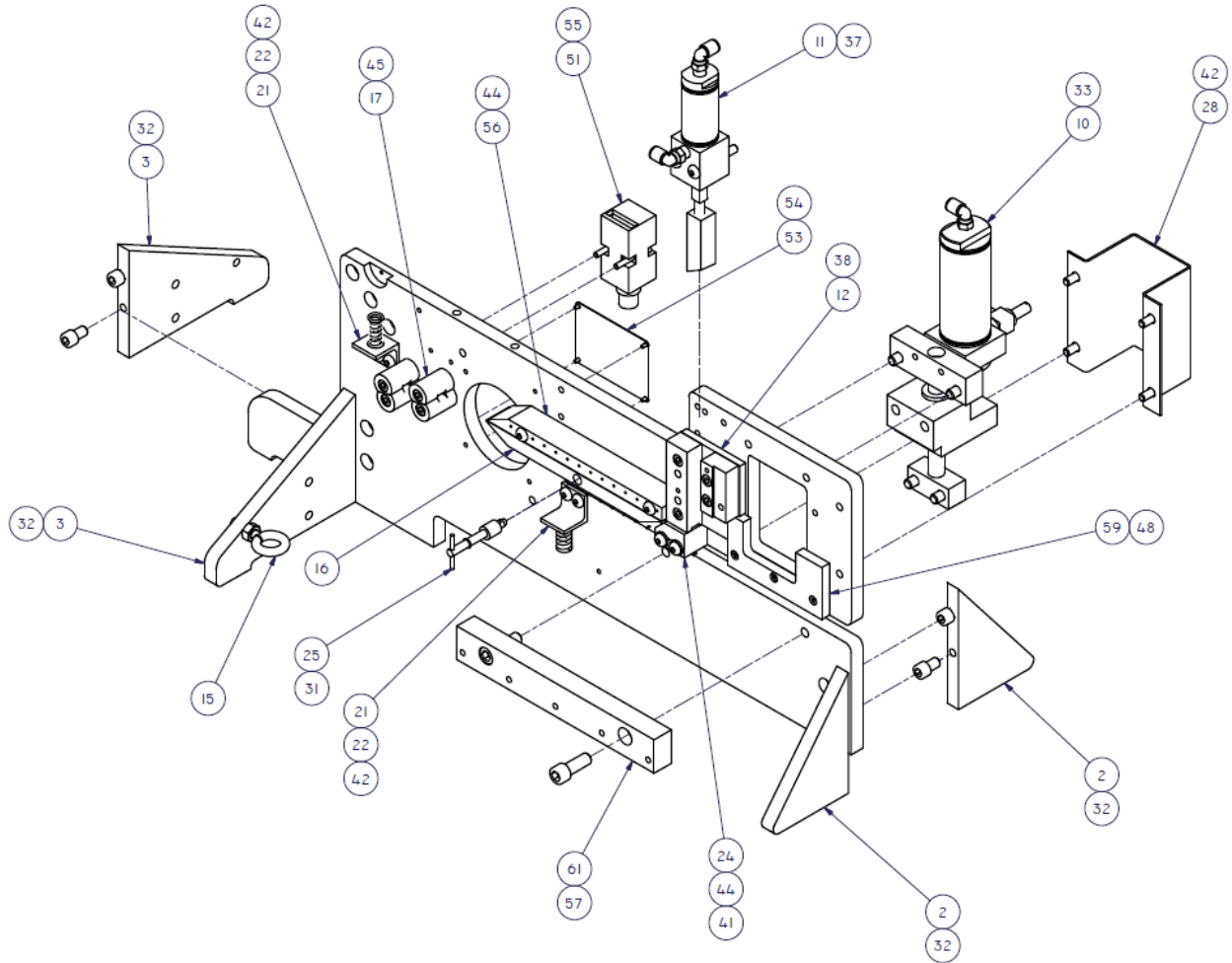
ASSEMBLY VIEW



Assembly Part Number: 55-2019016800 .315 Roll N Close Applier Assembly, **Model 55-F**

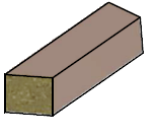


EXPLODED VIEW 2

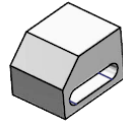


EXPLODED VIEW 3

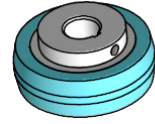
6.2 Parts and Sub-Assembly Drawings



Knife
52-2444248



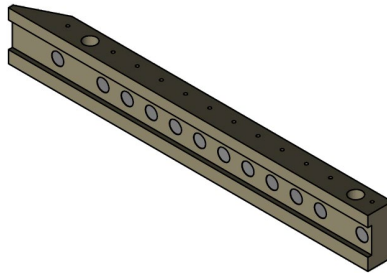
Anvil
52-2743241



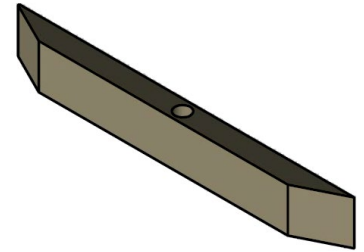
Silicone Feed Roller
52-2743025



Round Guide
55-2019016012 model 55-A
52-2743018 model 55-F



Top Guide
55-2019016010 model 55-A
55-2019016810 model 55-F



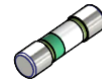
Bottom Guide
55-2019016002



Clutch
52-T251642S

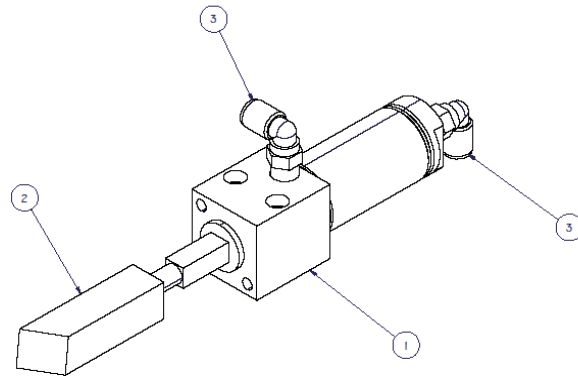


Bearing
52-S3PP

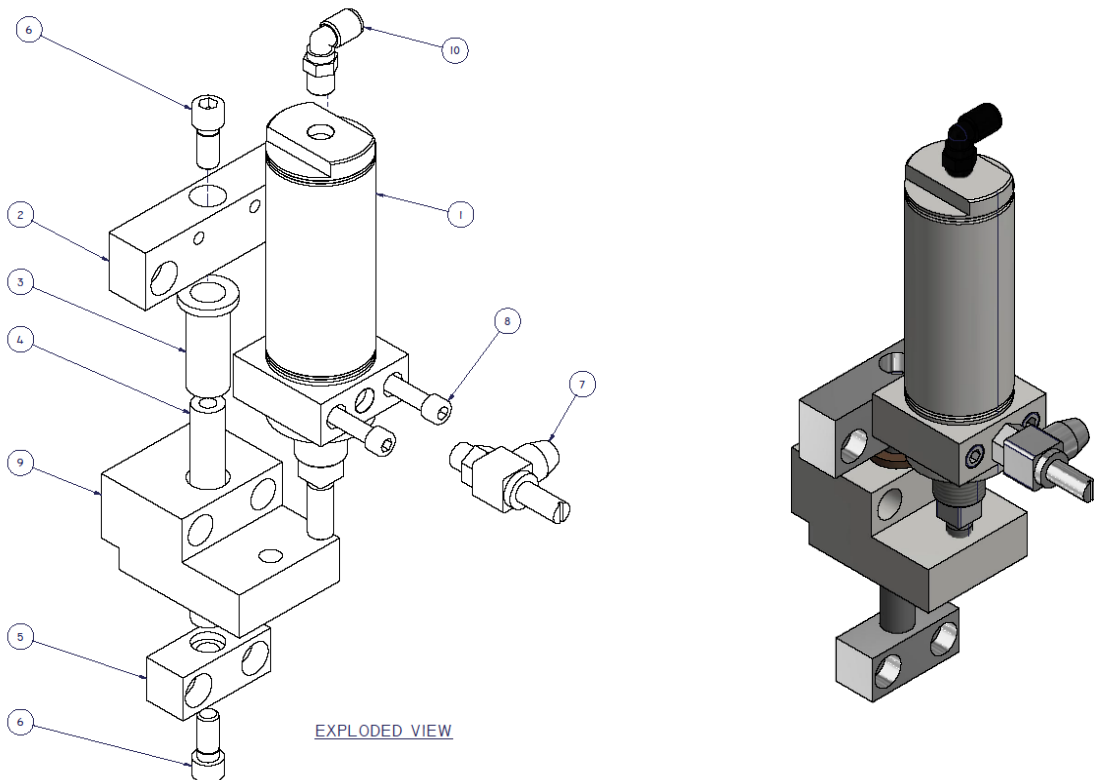


Fuse
52-FLM2A

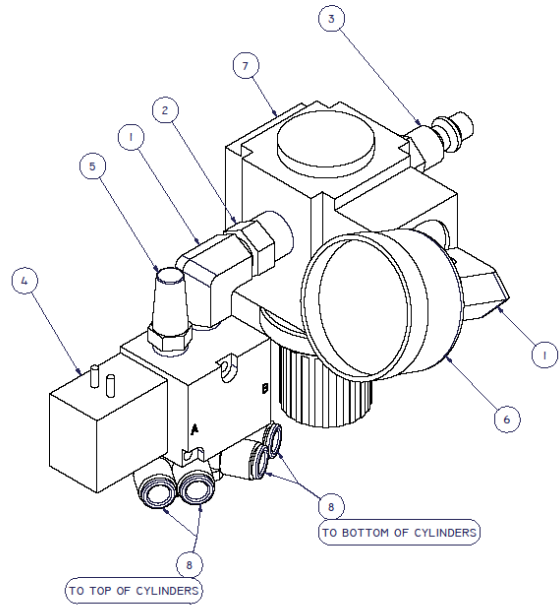
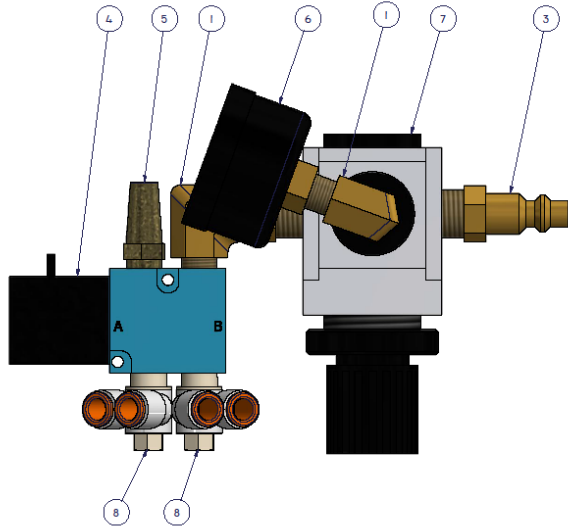
Assembly Part Number 52-2743350		KNIFE CYLINDER ASSEMBLY	
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	52-2444280	REWORK PNEUMATIC CYLINDER
2	1	52-2444248	KNIFE
3	2	52-5779K151	TUBE ELBOW, 1/8 PIPE x 1/4 TUBE



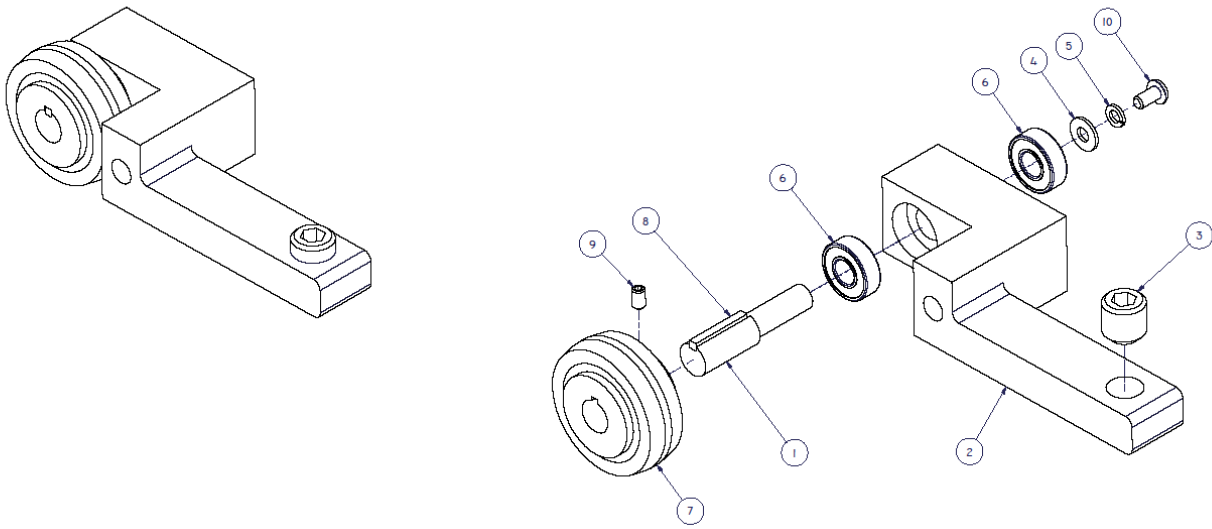
Assembly Part Number 55-2515001		CYLINDER ASSEMBLY, STAMPING BLOCK	
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	52-D90345A2	AIR CYLINDER, 1.5 BORE, 2.0 STROKE
2	1	52-2444123	SLIDE ROD SUPPORT
3	1	52-FB81012	BUSHING
4	1	55-2515022	GUIDE ROD
5	1	52-2444129	SLIDE ROD BASE SUPPORT
6	2	52-5161834CH	HEXAGON SOCKET HEAD CAP SCREW
7	1	52-FQP2K	BIMBA VALVE FQP2K
8	2	52-14202CH	HEXAGON SOCKET HEAD CAP SCREW
9	1	55-2515027	SLIDING BLOCK
10	1	52-5779K151	FITTING, ELBOW 1/8" PIPE TO 1/4" TUBE



Assembly Part Number 55-2019016060			PNEUMATIC ASSEMBLY
ITEM	QTY	PART NUMBER	DESCRIPTION
1	2	52-126B02	90 ELBOW
2	1	52-123B0402	NIPPLE, REDUCING 1/8" - 1/4" #6AZF1
3	1	52-6534K46	QUICK CONNECT COUPLER
4	1	52-45AAA2DDAA1BA	SOLENOID VALVE 4-WAY, 1/8"NPTF
5	1	52-46020002	MUFFLER EM12 1/8" MPT
6	1	52-13524	PRESSURE GAUGE 0-160 psi
7	1	52-PR2-N02B1	REGULATOR 1/4", 150 psi
8	2	55-KQ2Z07-34AS	BRANCH UNIVERSAL MALE ELBOW 1/4 T, 1/8 NPT

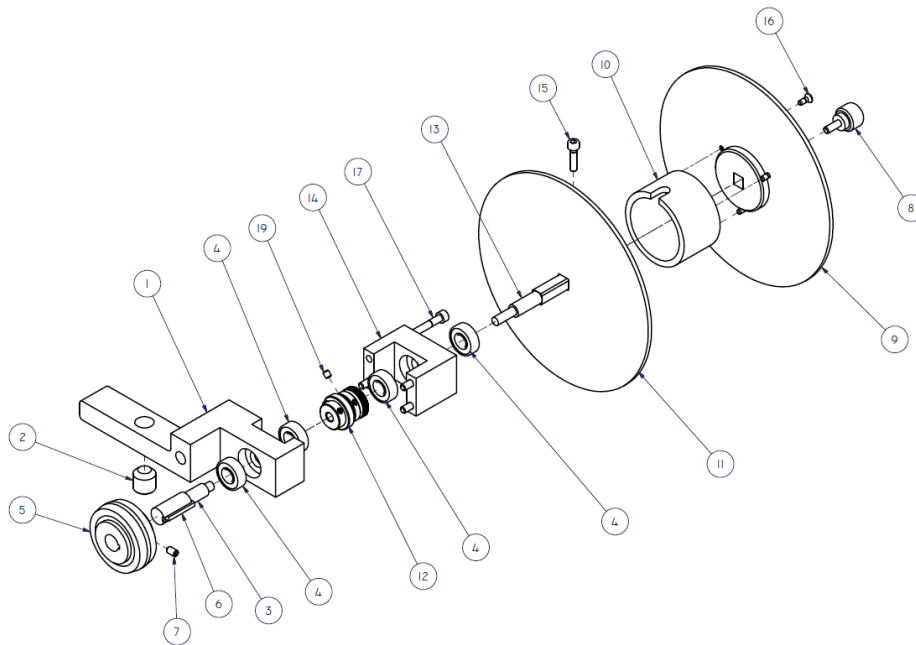
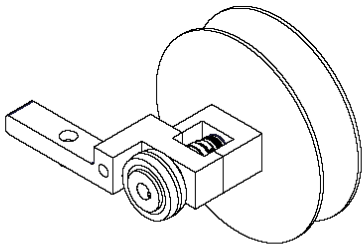


Assembly Part Number 52-2743205		TOP ARM ASSEMBLY	
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	52-2444204	NIP SHAFT
2	1	52-2444213	TOP ARM
3	1	52-581158SS	SCREW, SOCKET SET 5/8-11 x 5/8
4	1	52-10FW	WASHER, FLAT #10
5	1	52-10LW	WASHER, LOCK #10
6	2	52-S3PP	BEARING S3PP
7	1	52-2743025	SILICONE FEED ROLLER
8	1	52-2444256	1/8 x 1.0 KEY
9	1	52-1032516SS	SCREW, SOCKET SET 10-32 x 5/16
10	1	52-102438BH	BUTTON HEAD 10-24 x 3/8



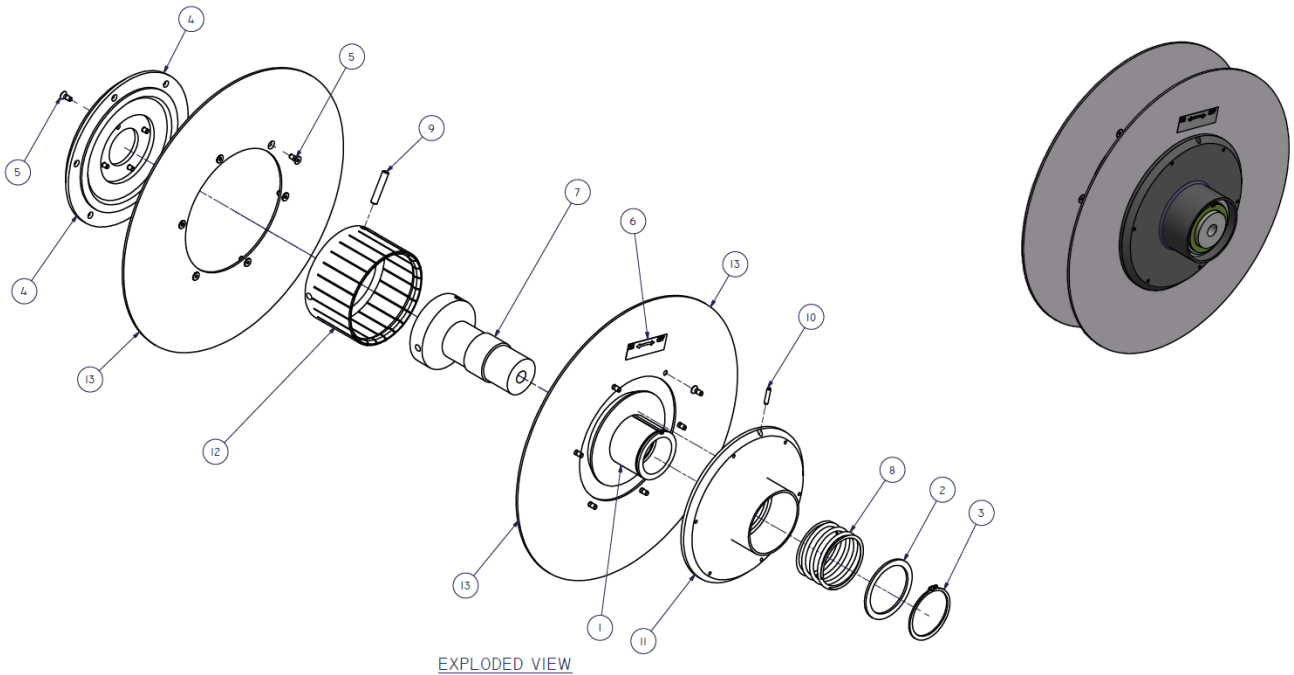
EXPLODED VIEW

Assembly Part Number 52-2743219		BOTTOM ARM ASSEMBLY	
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	52-2444218	BOTTOM LINER ARM
2	1	52-581158SS	5/8-11 x 5/8
3	1	52-2444224	NIP SHAFT
4	4	52-S3PP	BEARING
5	1	52-2743025	SILICONE FEED ROLLER
6	1	52-2444256	1/8 x 1.0 KEY
7	1	52-1032516SS	HEXAGON SOCKET SET SCREW 1.0
8	1	52-JCL685	THUMB SCREW
9	1	52-2444238	FRONT FLANGE PLATE
10	1	52-2444227	SPOOLER CORE
11	1	52-2444226	INSIDE SPOOLER PLATE
12	1	52-T251642S	SLIP CLUTCH
13	1	52-2444225	SPOOLER SHAFT
14	1	52-2444262	CLUTCH SUPPORT
15	1	52-102434CH	HEXAGON SOCKET HEAD CAP SCEW NO.10
16	3	52-63238FH	HEXAGON SOCKET FLAT COUNTERSUNK HED CAP SCREW NO.6
17	4	52-1024138CH	HEXAGON SOCKET HEAD CAP SCEW NO.10
18	1	52-2444278	SPOOL DIRECTION LABEL
19	4	52-832316SS	HEXAGON SOCKET SET SCREW NO. 8, FLAT POINT

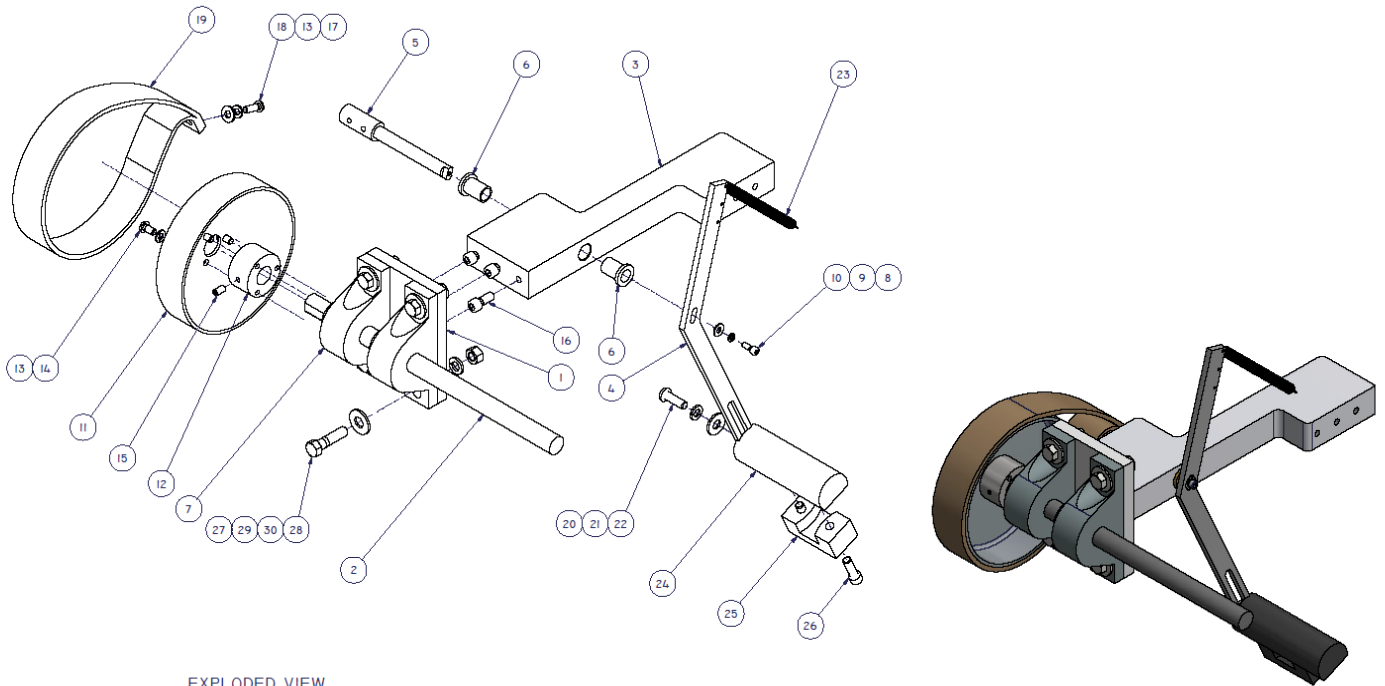


EXPLODED VIEW

Assembly Part Number 52-2743030		SPOOL ADAPTER ASSEMBLY	
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	52-302372	EXPANDER, LEFT HAND
2	1	52-200754	WASHER 3" ID
3	1	52-23100306ST	RETAINING RING
4	1	52-500006	HUB, STATIONARY
5	16	52-142058FH	HEXAGON SOCKET FLAT CONTERSUNK HEAD CAP SCREW 1/4
6	1	52-LABEL	ON/OFF LABEL LH
7	1	52-500001	ARBOR ADAPTER, LEFT-HAND
8	1	52-202271	COMPRESSION SPRING
9	2	52-38162SS	HEXAGON SOCKET SET SCREW 3/8
10	1	52-7321TP	PIN, TENSION 7/32 X 1
11	1	52-500008	HUB FOR FLOATING FLANGE
12	1	52-500005	SLEEVE, COLLET
13	2	35-1793461	FLANGE-SPOOL ADAPTER

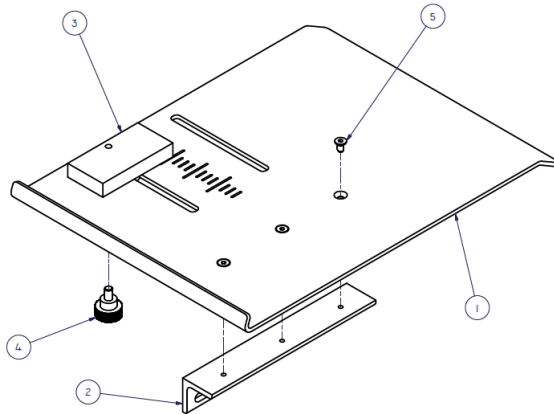


Assembly Part Number 52-2743180		SPOOL PAYOUT ASSEMBLY	
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	52-2444164	SPOOL BEARING PLATE
2	1	52-2444163	SPOOL SHAFT
3	1	52-2743057	PAYOUT RISER
4	1	52-2743033	CANCER ARM
5	1	52-2444177	BRAKE CAM
6	2	52-FB8108	BRASS BUSHING
7	2	52-RAK34	PILLOW BLOCK BEARING
8	1	52-10FW	WASHER
9	1	52-10LW	LOCK WASHER
10	1	52-102412CH	HEXAGON SOCKET HEAD CAP SCREW NO.10
11	1	52-2444261	REWORK, BRAKE HUB
12	1	52-2444260	HUB
13	5	52-14LW	LOCK WASHER
14	3	52-142012BH	HEXAGON SOCKET BUTTON HEAD CAP SCREW 1/4
15	1	52-142012SS	HEXAGON SOCKET SET SCREW FLAT POINT 1/4
16	3	52-5161834CH	HEXAGON SOCKET HEAD CAP SCREW 5/16
17	2	52-14FW	WASHER
18	2	52-142034BH	HEXAGON SOCKET BUTTON HEAD CAP SCREW 1/4
19	1	52-2444279	LEATHER BRAKE
20	1	52-516FW	WASHER
21	1	52-516LW	LOCK WASHER
22	1	52-516181BHCS	HEXAGON SOCKET BUTTON HEAD CAP SCREW 5/16
23	1	52-570	EXTENSION SPRING
24	1	52-2743022	DANCER GUIDE TOP
25	1	52-2743023	DANCER GUIDE BOTTOM
26	2	52-516181CH	SOCKET HEAD CAP SCREW 5/16
27	4	52-3816N	HEX NUT
28	4	52-3816112HH	HEX BOLT 3/8
29	4	52-38LW	WASHER, LOCK
30	4	52-38FW	WASHER, FLAT

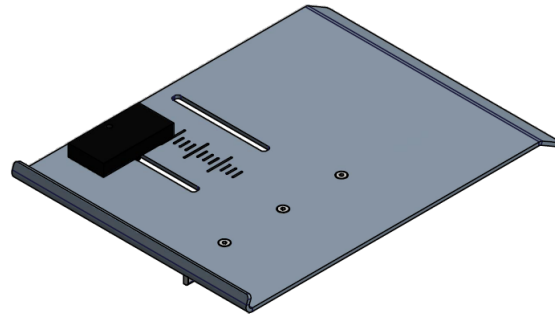


EXPLODED VIEW

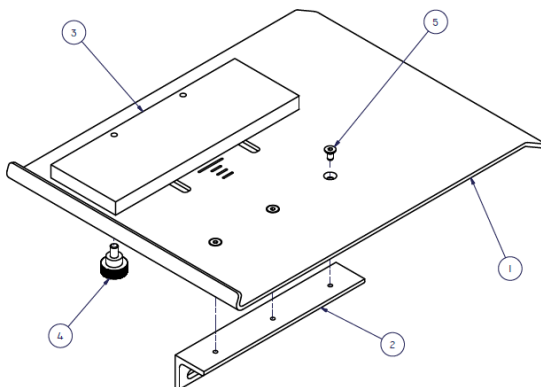
Assembly Part Number 55-2019016030		BAG TRAY ASSEMBLY Model 55-A	
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	55-2019016033	BAG TRAY
2	1	55-2019016031	BRACKET
3	1	55-2019016032	BAG STOP, model 55-A
4	1	52-JCL515	THUMB KNOB
5	3	52-102438FH	FLAT HEAD, 10-24 x 3/8"



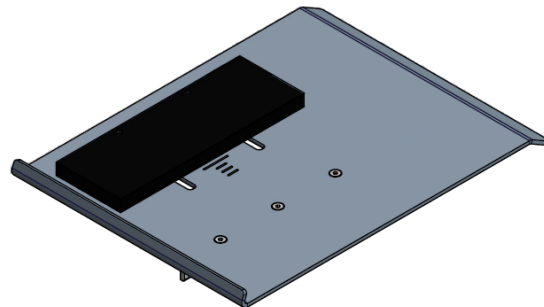
EXPLODED VIEW



Assembly Part Number 55-2019016830		BAG TRAY ASSEMBLY Model 55-F	
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	55-2019016033	BAG TRAY
2	1	55-2019016031	BRACKET
3	1	55-2019016822	BAG STOP, model 55-F
4	2	52-JCL515	THUMB KNOB
5	3	52-102438FH	FLAT HEAD, 10-24 x 3/8"



EXPLODED VIEW

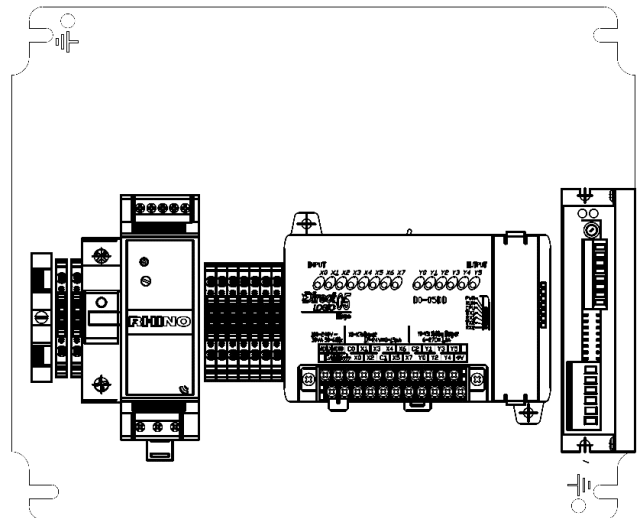
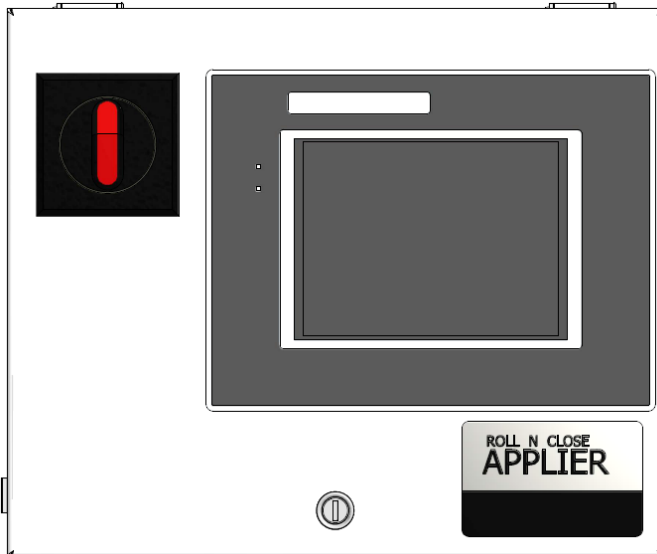


7.0 Electrical

7.1 Electrical Enclosure

Assembly Part Number: 55-2019016E01 CONTROL PANEL

Qty	Description	Supplier	Manufacturer	Manufacturer #
1	HOFFMAN BOX INLINE Hinged-Door Enclosures	BEDFORD	BEDFORD	52-2743275
1	HOFFMAN PANEL LP3025 : Panel, 281x231mm	ECHO	HOFFMAN	52-LP3025
1	Panel Decal, LABEL, RNC APPLIER BRANDING		BEDFORD	52-2019016017
1	CORD, POWER (120 vac), 12', 16-3	Grainger		52-2W687
1	ABB handles, 1SCA105213R1001	POWER/MATION	ABB	52-OHBS-2PJ
1	ABB switch-disconnect 1SCA104940R1001	POWER/MATION	ABB	52-AP-OT40FT3
2	BLA LUG CU 1 HOLE F/4	ECHO		52-BLA-L70
8'	SJO CORD	ECHO		52-SJOCORD16-3
1	FOOT SWITCH	Grainger		52-5A287
1	8 DC IN / 6 DC OUT MICRO PLC W/AC P/S	Automation Direct	Automation Direct	52-D0-05DD
1	TOUCH PANEL 6in COLOR TFT 320x240 QVGA USB EA9 C-MORE SER	Automation Direct	Automation Direct	52-EA9-T6CL-R
1	MEMORY CARTRIDGE	Automation Direct	Automation Direct	52-D0-01MC
1	STEPPER DRIVE 7.5A 24-65VDC MICROSTEPPING	Automation Direct	Automation Direct	52-STP-DRV-6575
1	CABLE MOTOR EXTENSION 20ft W/CONNECTOR FOR STP	Automation Direct	Automation Direct	52-STP-EXT-020
1	POWER SUPPLY, 24VDC, 90W	Automation Direct	Automation Direct	52-PSM24-090S
8	TERM BLK 100/PK GRY 30A 10AWG 600V	Automation Direct	Automation Direct	52-AP-DN-T10-A
1	END BRACKET 50/PK FOR 35mm RAIL	Automation Direct	Automation Direct	52-DN-EB35
3	END COVER 100/PK FOR DN-T12-A & DN-T10-A	Automation Direct	Automation Direct	52-DN-EC1210
1	JUMPER 24-POLE 5/BAG	Automation Direct	Automation Direct	52-DN-24J4Y
10"	DIN RAIL 35mm x 7.5mm 10/PK 1m (3.3ft) SLOTTED STEEL	Automation Direct	Automation Direct	52-DN-R35S1
1	FUSE HOLDER, 30A, 600V, 1 POLE	Automation Direct	Automation Direct	52-EHM1DU
1	CABLE M12 2m (6.5ft) Q/D 4-POLE AXIAL FEMALE GRY PVC	Automation Direct	Automation Direct	52-CD12L-0B-020-A0
1	CABLE, SCREEN	Automation Direct	Automation Direct	52-EA-2CBL
2	TERM BLK 100/PK GRN 30A 10AWG 600V	Automation Direct	Automation Direct	52-A-DN-T10GRN-A
4	CONNECTOR, CORD GRIP #69915K47	MCMMASTER	HEYCO	52-69915K47
3	CABLE CLAMP	MCMMASTER	HEYCO	52-3231
1	Fuse, FLM, 2A,	ECHO	LITTLEFUSE	52-FLM2A
1	ADPT, DB15M/F ORIENTATION 3			52-DG9015MF3





8.0 Spare Parts List and Replacement Schedule

This list includes parts that are common wear items and will need to be replaced over time. The replacement schedule is the manufacturers (Bedford Industries) estimate of when each part will need to be replaced based on machine cycles. The life of these parts may vary based on maintenance care and use. (*Reference Section 6.2 for parts drawings*)

PART NUMBER	QTY	DESCRIPTION	REPLACE
*52-2444248	1	KNIFE	1,000,000 cycles
*52-2743241	1	ANVIL	1,000,000 cycles
52-2743025	3	SILICONE FEED ROLLER	2,000,000 cycles
52-T251642S	1	CLUTCH	2,000,000 cycles
55-2019016012	4	ROUND GUIDE, model 55-A	3,000,000 cycles
52-2743018	4	ROUND GUIDE, model 55-F	3,000,000 cycles
55-2019016010	1	TOP GUIDE BLOCK, model 55-A	3,000,000 cycles
55-2019016810	1	TOP GUIDE BLOCK, model 55-F	3,000,000 cycles
55-2019016002	1	BOTTOM GUIDE BLOCK	3,000,000 cycles
52-S3PP	6	BEARING	5,000,000 cycles
52-45AAA2DDAA1BA	1	SOLENOID VALVE	10,000,000 cycles
52-2444280	1	PNEUMATIC CYLINDER FOR KNIFE	10,000,000 cycles
52-D90345A1	1	PNEUMATIC CYLINDER FOR STAMPER BLOCK	10,000,000 cycles
52-FLM2A	1	FUSE	

**NOTE: Bedford offers sharpening services for the Knife and Anvil.*

When ordering parts, locate the machine nameplate on the back of the machine (*Reference Section 6.0 for nameplate location*) and provide the model number and serial number with your request for parts. This information will aid in providing quick and accurate service from Bedford Industries or any machine distributor that provides parts for the Bedford Roll N Close® Applier machine.

