

XtraCoat

UV ROLLER COATER

OPERATING AND SAFETY MANUAL



For the following models:

**XC18-1-3D, XCF18-1-3D
XC25-1-3A, XCF25-1-3A
XC29-1-3D, XCF29-1-3A**

S/N_____.

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Read the following section carefully. Failure to operate this or any type of machine without a full understanding of the possible dangers will result in serious injury.

1. ALWAYS disconnect / lockout input power to the coater and UV conveyor system before opening electrical panel / box or working within machine.
2. DO NOT touch any moving parts or attempt to make adjustments while machine is operating or has power flowing through it.
3. DANGER, High voltage and current are used to energize UV lamp in UV processors.
4. This machine has rotating rollers and can cause serious injury. The machine is only as safe as the employer and operator make it.
5. DO NOT remove or modify safety covers – guards, safety switches.
6. DO NOT operate machine while wearing a neck tie, loose fitting clothing or long hair. Loose articles may get caught in the machine.
7. DO NOT look directly into the UV light; it can cause severe burns to the eyes and skin. You must wear protective UV blocking eyewear.
8. DO NOT make modifications to the machine without written agreement from TEC Lighting.
9. DO NOT leave tools or other equipment or any material lying on the machine.
10. Keep metal container near by the system for sheet disposal.
11. Authorized TEC Lighting service technicians should do all service / repairs.
12. ONLY trained qualified personnel may operate this equipment.
13. Read and understand all safety decal that are posted In this machine.
14. Never leave rollers engaged when not in operation. This will cause a flat spot on the rubber roller and affect coating quality.
15. All parts must be replaced with manufacturer's original parts.
16. YOU MUST wear safety goggles and gloves at all times when you are setting-up, operating or cleaning the UV coating machine.

Failure to follow these safety guidelines can result in serious injury or fatality.

TEC Lighting will not be responsible for damage or accidents caused by irresponsible operation of this equipment.

SECTION: 1.2

SAFETY DECALS



Safety Decals:

It is very important that you read, understand and follow all safety guidelines and operating instruction.

Any Machine with rotating rollers can be dangerous.

Be sure all safety guards are in place and fully secured before operating the system.

Introduction

Section: 2

General Overview

The purpose of the unit is to transfer UV coating to the sheet, in a continuous fashion, either off-line or in-line with your current production processes.

Note: the sheets “ink” must be 100% dry before sending through the UV coater.

Sheets are hand-fed or Auto-fed into an input table, which sends the substrate through an applicator and impression roller point that applies coating. The coating is dispensed or pumped in automatically from a UV coating container. A generous amount of coating stays between the two rollers when the metering roller adjustment knobs apply pressure. The sheets then exit the roller coater and are transported with a conveyor system to the IR and UV lamps.

Production speed will be determined by a number of factors, including;

Note: sheet stock thickness must be greater than 100lb text.

- ◆ Sheet size
- ◆ Sheet thickness (minimum thickness 100lb text)
- ◆ Sheet Quality
- ◆ Sheet Feeding
- ◆ Coating Viscosity
- ◆ Coating Temperature
- ◆ Sheet Temperature
- ◆ Dwell Time (Time the sheet spends on the conveyor after coating but prior to curing)
- ◆ Lamp and IR Quality.
- ◆ Required Gloss Level

The importance of each of these factors cannot be overlooked.

SECTION: 2.1

DESCRIPTION

This machine consists of several major sub-assemblies functioning together to instantly “apply” and “dry” or “cure” UV coatings.

All XtraCoat systems are 100% tested and inspected before shipping.

The sub-assemblies are:

UV Coater / Conveyor System:

Roller drive assembly with adjustment controls.

UV coating pump system, with re-circulating system.

Control panel.

In feed table.

Safety covers.

Lamp housing - with mercury vapor arc lamp and elliptical reflector.

IR Lamp housing – with (3) IR lamp and elliptical reflector.

Air moving plenum system / blower.

Enclosed power supply cabinet.

Conveyor belt system with speed control.

Catch tray station.

Deep-pile vacuum cup feeder.

Exhaust pipe / hose system – (option)

Starter Kit / Plus – (option)

Your system may include some or all of these components, depending on your model.

SECTION 3.0

WARRANTY POLICY

The lamp housing assemblies, power supply, control panel, blowers and related components are warranted for twelve (12) months, from the date of shipment. Any manufacturing defects in workmanship, equipment failure, or operational performance below reasonable tolerances are covered by this warranty.

This does not include physical damage, abuse, neglect, wiring or unauthorized installation.

TEC Lighting, Inc. reserves the right to make the final determination of all warranty claims and product dispositions. Tec Lighting Inc. is not responsible for any lost production time due to machine downtime.

Note: Please fill out the **Warranty Form (XCWF)** and fax's to TEC Lighting, inc. 714-529-0344

EXCEPTIONS TO THIS AGREEMENT

- Conveyor belts
- Exhaust tubing
- Reflector inserts
- Capacitors
- UV Lamp (see below)
- IR Lamp (see below)

UV COATER SYSTEM

The UV Coater assembly, motor and motor drive and related components are warranted for twelve (12) months from the date of shipment. Any manufacturing defects in workmanship, equipment failure, or operational performance below reasonable tolerances are covered by this warranty. **This does not include physical damage, abuse, neglect, wiring or unauthorized installation.**

TEC Lighting, Inc. reserves the right to make the final determination of all warranty claims and product dispositions.

EXCEPTIONS TO THIS AGREEMENT

- Rubber Applicator Roll
- Doctor Blade

UV and IR LAMPS

All lamps are warranted for **1,000 hours**. Refer to the hour meter for changing the lamp. (See picture below) Lamps that fail due to physical damage, abuse, neglect, wiring or unauthorized installation, will not receive credit. Make sure that the lamp is well packed prior to its return - **broken lamps will not receive credit.**



Lamp hour meter.

RETURNED / REPLACEMENT PARTS

Please contact TEC Lighting Inc. or your sales representative for repair or warranty replacements. **Make sure that the item is well packed prior to its return** – broken items will not receive warranty replacement.

TEC Lighting must receive the defective part, - test and evaluate before shipping any replacement. **Warranty replacement parts will be ship “via. Ground”**

If customer, require replacement parts sooner, customer needs to provide the shipping account number. All parts must be replaced with manufacture’s original parts. TEC Lighting Inc. reserves the right to make the final determination of all warranty claims and product dispositions.

INSPECTION

TEC Lighting UV Coater /Conveyor system are inspected before crating to insure safe shipping.

Upon receipt of shipment inspect outer crate for any damages caused by shipping. After uncrating and removing your machine, inspect your UV system carefully for any damages.

Report any damages caused by shipping to the truck driver (Transport Company) and to your sales representative. **(Please take pictures and document all damages)**

Section: 4.0 18" ELECTRICAL SPECIFICATIONS

Lamp arc length	18"
Number of lamps	1
Wattage per inch	200 W.P.I.
Wattage K.W	3,600 K.W.
Primary input voltage	208-220vac 60Hz 3ph
Total system running amperage	40A no feeder 45A with feeder
Service Disconnect:	50A no feeder. 60A with feeder.
Conveyor Belt size	18.50 x 98.50 BELT-341
UV Lamp	XC18L
IR Lamp	XC18IRL

Section: 4.1 25" ELECTRICAL SPECIFICATIONS

Lamp arc length	25"
Number of lamps	1
Wattage per inch	200 W.P.I.
Wattage K.W	5,000 K.W.
Primary input voltage	208-220vac 60Hz 3ph
Total system running amperage	45A no feeder 50A with feeder
Service Disconnect:	60A
Conveyor Belt size	25.50 x 98.50 BELT-342
UV Lamp	XC25L
IR Lamp	XC25IRL

Section: 4.2 29" ELECTRICAL SPECIFICATIONS

Lamp arc length	29"
Number of lamps	1
Wattage per inch	200 W.P.I.
Wattage K.W	5,800 K.W.
Primary input voltage	208-220vac 60Hz 3ph
Total system running amperage	50A no feeder 55A with feeder
Service Disconnect:	75A
Conveyor Belt size	29.50 x 98.50 BELT-345
UV Lamp	XC29L
IR Lamp	XC29IRL

Section: 5.0 PANEL CONTROL TERMINOLOGY



LED Display Panel

E-Stop control

Green Start - Stop Button

Fluid Pump ON-OFF

UV Lamp ON - OFF Switch

IR Lamp control knob

UV Coater Clutch Selector

UV Coater and Belt Speed



Feeder Air Pump ON-OFF

Feeder Speed

Section 6.0

PRE SET-UP

- A. Read and understand all safety warning decals.
- B. Check for damages caused by shipping – report damages to shipping carrier and your dealer.
- C. Carefully uncrate your systems. A forklift is required.
- D. Check and ensure that all sheet metal bolts are not loosened from transport vibration. Use proper tools for tightening.
- E. Make sure your work area is clean and ready for set-up.

6.1 Feed table



Feed table



attach mounting screw, under feed table.

6.2 Catch tray station



Catch tray



Set into holder



Legs are straight



Set height adjustment



Add paper holder brackets

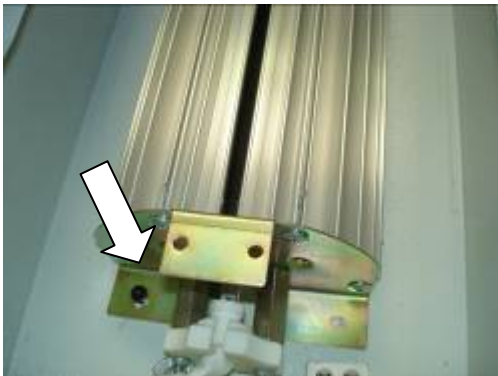
6.3 UV Lamp – Note: Safety Glass and Gloves are required.

UV lamps are packaged in its own container, open box and inspect the lamp for shipping damages. Clean UV lamp glass body with TEC Lighting cleaning kit - #99-0950. **(Handle the UV lamp carefully)**

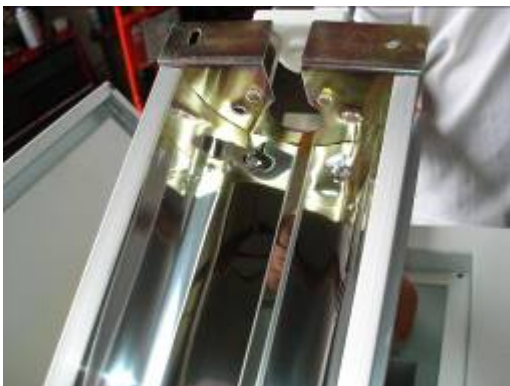
1. The UV lamp compartment door is locked with mounting screw, remove the screw to open the compartment.



2. Remove reflector mounting hardware (2 screw) one on each end.



3. Remove reflector assembly, rotate assembly to expose reflector mirror.
Note: Extra cleaning of the reflector mirrors maybe required, use TEC Lighting Cleaning kit - #99-0950.

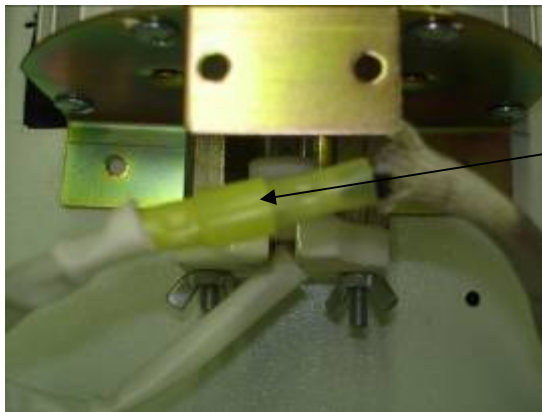


4. Loosen wing nut from the lamp holder bracket, insert UV lamp into lamp holder. Tighten the wing nuts, secure UV lamp.

NOTE: Do not touch UV lamp glass body with bare fingers, if touched clean with cleaning kit #99-0950.



5. Carefully set reflector assembly with UV lamp, back into its compartment – re-attach mounting screws. (see step 2.)
6. Connect the UV lamp terminal lug, both ends.



Male and female terminal lugs.

7. Close compartment door, re-attach locking screw. (see step 1.)

6.4 UV Coating Fluid – Gloves and eye goggles are required.

1. Open cabinet doors.

Note: Only 5 gallons pails are to be used.



2. Open UV coating container, install funnel on top of coating container.



3. Move the 5 gallon container into position, make sure funnel is inline with the coating pan spout.



4. TEC Lighting provides you with 2 faucets – one for (A) coating, the other for (B) coating. **Note:** When changing coating you must wear gloves and safety goggles.



5. Engage (close) the coating pump head on the hose.



Open



Close

6. Insert coating pump tubing into the pail; make sure the tubing is fully inserted into the pail.



6. Close the cabinet door.

6.5 Feeder set-up – only if you have a feeder.

1. Move feeder to position.



WARNING
MAIN POWER MUST BE
“OFF” BEFORE
CONNECTING FEEDER
INPUT PLUGS.

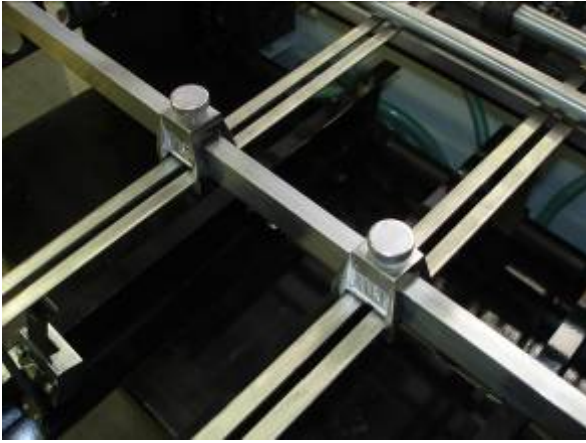
2. Connect the feeder input plugs into conveyor socket



3. Carefully push the feeder into position, make sure the cables do not get pinched, at the same time carefully move the feeder over the doctor blade control knob (the feeder has a large slot to go over) move the feeder next to the UV coater system.



4. Set rear paper guide into position and sheet support brackets.



6.6 Electrical Input power

1. Open cabinet doors – (unlock latch inside door)

WARNING - Make sure your main power disconnect box is “OFF”

2. Insert your input power wires thru port hole.

3. Connect input wires to (N) (L) and ground wire to terminal block.



Cabinet doors



Locking latch



Input wire port hole



Hook-up input wires



Conveyor disconnect switch

4. If you are using TEC Lighting feeder you must check the blower rotation.

5. **Blower rotation test:** - only if the system is 3ph.

- A) Check all electrical wiring connection, close cabinet doors and disengage E-stop switches ensure all control switches are in **OFF** position.
- B) Turn **ON** your main power disconnect box.
- C) Push the **RUN** button.
- D) Push the green start button.
- E) Turn the UV lamp selector switch to: **Cool down**, then back to **OFF**.
- F) Check blower rotation, the fan blade should rotate in clockwise. (fan blades moving toward you)
- G) If, the blower rotation is incorrect – turn **OFF all power**, reverse input wires (white and black) and re-test.



Fan blade.

7.0

Start-up – UV and IR Lamps

DANGER – HIGH VOLTAGE AND CURRENT ARE USED TO ENERGIZE UV AND IR LAMPS. DO NOT LOOK DIRECTLY AT THE UV LIGHT.

1. Check all controls and safety features.(e-stops, interlock switches)
2. Turn **ON** your main power.
3. Press **RUN** button on the LED display to start the conveyor belt.
4. Press the Green Start button.
5. Turn The UV Lamp selector switch to **ON** Position, the switch will light up green. Note: The UV lamp takes 90 SEC to warm-up.
6. To turn on the IR lamps – rotate the IR Lamp knob **CLOCKWISE**. Zero position is IR lamp **OFF**, as you turn the knob **CLOCKWISE** the IR lamps will increase in intensity.

8.0

Shut Down – UV and IR Lamps

1. Rotate the IR intensity knob counter-clockwise, “0%” – **OFF** position.
2. Turn UV lamp selector knob to **COOL DOWN** position, the UV lamp will take approx. 5 minutes to cool down and will automatically turn off.
3. After cool down is completed, set the UV selector switch to **OFF** position.
4. Push green start button, your system will shut OFF.

You have completed the shut down for the UV and IR lamp ONLY.

WARNING: THIS MACHINE HAS ROTATING ROLLERS AND CAN CAUSE SERIOUS INJURY. YOU MUST WEAR SAFETY GOGGLES AND GLOVES AT ALL TIMES WHEN YOU ARE SETTING-UP, OPERATING OR CLEANING THE UV COATING MACHINE.

Never leave rollers engaged when not in operation. This will cause a flat spot on the rubber roller and affect coating quality.

NOTE: Make sure the rollers are clean.
Minimum stock thickness is 100lb text.
The UV and IR Lamps should be ON.

Start-up

1. Engage the impression roller until it touches the applicator roller. Please note decal for rotation direction.

For THICK STOCK allow rollers to touch (impression roller only) plus one complete clockwise turn of pressure.

For THIN STOCK allow rollers to touch (impression roller only) plus two complete clockwise turns of pressure. Extra turns maybe required for thinner stock and production results.

2. Engage metering roller until it touches the applicator roller. Please note decal for rotation direction. For less coating increase pressure and for more coating decrease pressure.



WARNING: Make sure the belt speed is set at 6.6 Hz



3. Turn **ON** fluid pump and wait until the UV coating reaches the ends of the roller train.
4. Turn the **CLUTCH** switch to the right, the rollers will start to move
5. Engage the doctor blade by turning the knob counter clockwise until it is finger tight. Please note decal for rotation direction. If a high pitched noise becomes evident you have applied too much pressure, reduce pressure by turning the knob clockwise.



6. If your system does not have a feeder - Set system to your production running speed and begin.
If you have TEC Lighting feeder ref. section 6.5 and 12.0

WARNING: THIS MACHINE HAS ROTATING ROLLERS AND CAN CAUSE SERIOUS INJURY. YOU MUST WEAR SAFETY GOGGLES AND GLOVES AT ALL TIMES WHEN YOU ARE SETTING-UP, OPERATING OR CLEANING THE UV COATING MACHINE.

Never leave rollers engaged when not in use. This will cause flat spot on the rubber roller and affect coating quality.

1. Turn **OFF** the UV coating fluid pump.
2. Continue to run the rollers until coating is almost drained from the roller train.
3. Turn down roller speed to 6.6 Hz.
4. Turn the **CLUTCH** switch to the **LEFT**, the rollers will stop.
5. **Disengage** the doctor blade, note decal for rotation direction.
6. **Disengage** the impression and metering rollers, note decal for rotation direction.
7. Turn OFF all power to the system
8. You are now ready to clean, ref to section 11.0

You have complete the shut down for the UV Coater ONLY.



WARNING: TURN OFF MAIN POWER TO THE MACHINE BEFORE CLEANING.

WARNING: THIS MACHINE HAS ROTATING ROLLERS AND CAN CAUSE SERIOUS INJURY. YOU MUST WEAR SAFETY GOGGLES AND GLOVES AT ALL TIMES WHEN YOU ARE SETTING-UP, OPERATING OR CLEANING THE UV COATING MACHINE.

Never leave rollers engaged when not in used. This will cause flat spot on the rubber roller and affect coating quality.

Note: Before cleaning allow excesses UV Coating to drain back into 5-gallon pail.

1. Make sure your main input power is **OFF**.
2. To clean the rollers you must have TEC Lighting – Cleaning kit #**XCSK** and UV wash #**TEC501**.
3. Apply a small amount of UV wash to a cleaning cloth and wipe clean all UV coating. Do this to all 3 rollers.
4. Clean splash guard, bottom catch tray and front feed table.



5. **NOTE:** avoid UV wash to drain back into UV coating, 5-gallon pail.
6. Open coating pump head, (see section 6.4 par. 5) this will extend the life usage of the tubing.

12.0

Start-up – Feeder

WARNING: THIS MACHINE HAS ROTATING ROLLERS AND MOVING MECHANICAL GEARS THAT CAN CAUSE SERIOUS INJURY.

(Feeder set-up, ref. to section 6.5)



Crank Handle &
Auto / standby control

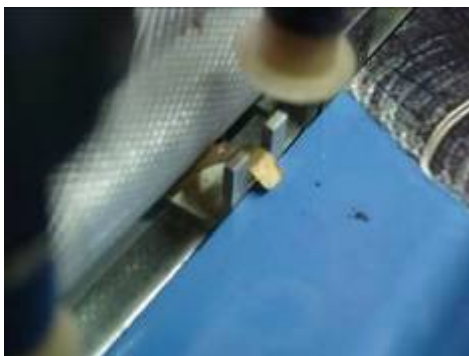


Air suction control
Suction Cup & Sheet separators

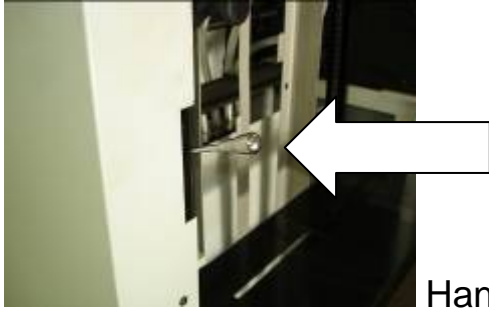
1. Load paper on to feeder tray.



2. Lift the paper with crank handle into position. Leave approx ¼ inch from paper to sheet separators fingers.

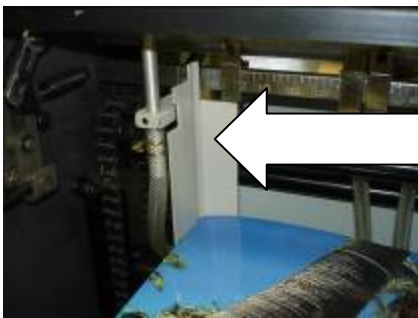


3. Unlock (open) the sheet separator corner bracket.

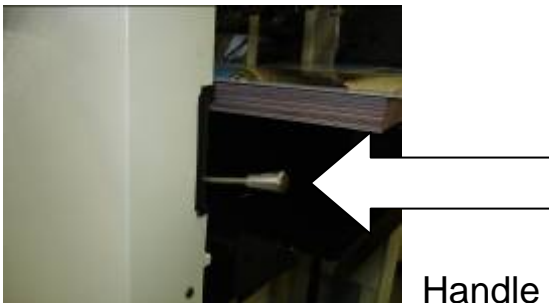


Handle – up is unlocked (open)

4. Set the sheet separator corner brackets into position. (2)



5. Close (lock) the sheet separator corner bracket.



Handle – down is locked, (closed)

6. Set the paper side guides into position. (2)



7. Set the paper back guides into position. Place rear paper weights on top of the paper stack.



8. Make sure the paper is positioned under the correct number of suction feet. If a sucker foot is only partially on the sheet, the feeder will not operate properly.



9. Close air suction feet that are not being used, by pulling upward on the plastic housing. Pull downward to open.



10. Set the sheet air separators so that the top 7-8 sheets are being separated.



9. Check and ensure that the feeder speed control knob is at its low position "0".
10. Double check and ensure all other controls are set correctly, i.e. UV lamp, IR lamp, UV coater and conveyor belt speed.
11. Select the paper delivery, automatically or manually. The automatically selection will crank and rise the paper. Manually selection will require you to crank the handle and raise the paper.



12. Turn **ON** air pump, the paper will not move until you increase the feeder speed control knob.

13. Double sheet detector is set by running the feeder at a slow speed while turning the knob counterclockwise until the double sheet detector is activated and turn it the opposite direction a half a turn and it will be set.



14. Slowly increase the feeder speed knob until your production requirement speed is reached.

13.0

Feeder shut down

WARNING: THIS MACHINE HAS ROTATING ROLLERS AND MOVING MECHANICAL GEARS THAT CAN CAUSE SERIOUS INJURY.

1. Turn **OFF** air pump switch.
2. Decrease the feeder speed control knob to “0” position.
3. Crank down the unfinished paper and remove.

You have completed the shut down for the Feeder ONLY.

14.0

Manufacture pre-setting

Manufacturer's Pre-set items listed below and are calibrated and should not be changed without authorized personnel and TEC Lighting approval. TEC Lighting will not be responsible for damage or accidents caused by irresponsible operation of this equipment.

1. Do not tamper with any of the machinery and electrical components.



2. Do not change the belt speed low setting. (6.6)



15.0

Conveyor Belt Replacement

WARNING: TURN OFF MAIN POWER.

WARNING: THIS MACHINE HAS ROTATING ROLLERS AND CAN CAUSE SERIOUS INJURY.

Conveyor model no.

Conveyor Belt p/n

XCF18-1-3E

BELT-341

1. Turn **OFF** main power.
2. Open the front cabinet doors.



3. Remove the rear panel.

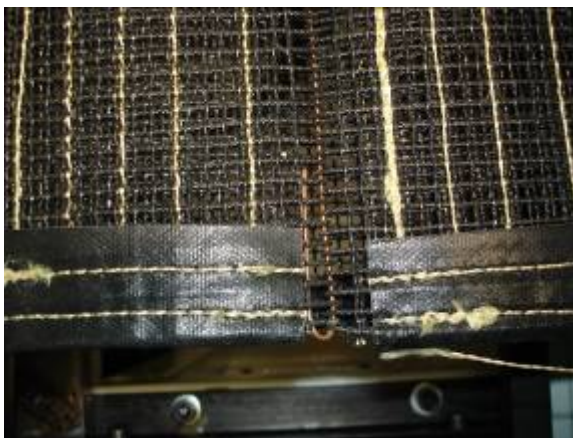


4. With the front cabinet doors open, located on the left side is the roller bearing. Loosen the two mounting bolts and pull on the roller, this will loosen the belt.

Note: loosen one side only. **Do not loosen the opposite side.**



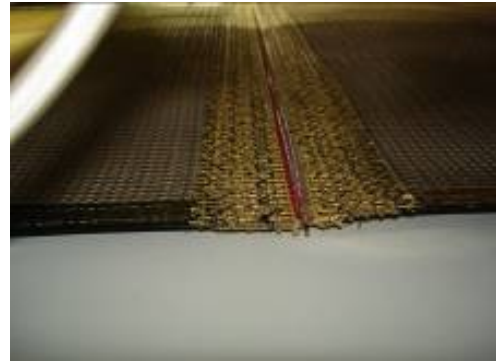
5. Locate the conveyor belt connecting joint and remove insertion pin. The conveyor belt will separate and allow you to remove it.



6. Conveyor belts have a top side and bottom side. The new conveyor belt are roll-up with the top side facing outward. The top side of the conveyor belt will be facing upward to the UV light.



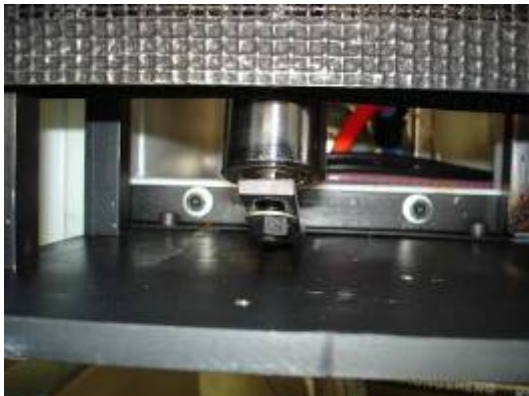
7. Remove the new conveyor belt insertion pin.
8. Carefully layout the conveyor belt over the conveyor rollers.
9. Connect the belt together insert the pin thru the loops. (You may require a 2nd person to help you with this assembly)



10. Push conveyor roller back into position, re-tighten the mounting bolts.



11. Make sure the conveyor belt is centered with the rollers.
12. Some adjustment maybe required to the belt tracking guide.



13. Close the rear panel and attach the mounting screws.
14. Close and lock the front doors.
15. Turn **ON** your main power.
16. Set the belt speed control knob too "0" zero.
17. Press **RUN** button on the LED display the conveyor belt will start moving.
18. Watch the conveyor belt; it may start to track off the roller.
Some adjustment maybe required to the belt tracking guide.
Increase the belt speed, watch the belt.
Note: New belts may require more tracking adjustments.
UV lamp will also cause the belt to move.

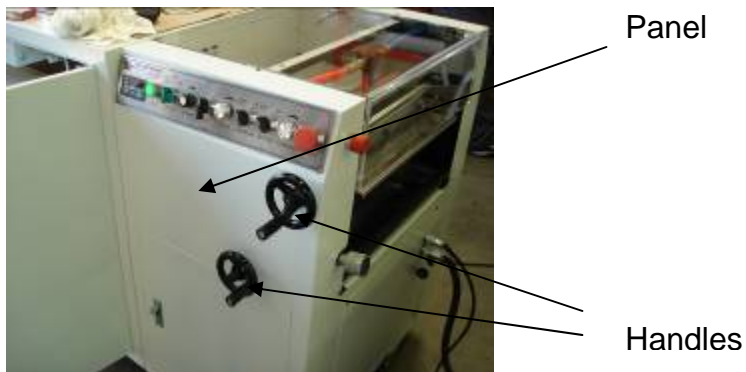
16.0

Doctor Blade Replacements

WARNING: TURN OFF MAIN POWER TO THE MACHINE. HIGH VOLTAGE AND CURRENT ARE USED TO ENERGIZE UV AND IR LAMPS.

WARNING: DOCTOR BLADE HAS SHARP EDGES, GLOVES ARE REQUIRED.

1. Turn OFF main power. Remove roller adjustment handles and control side panel.



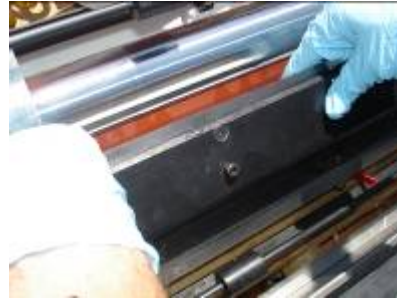
2. **Engage** the doctor blade, to touch the impression roller.



3. Loosen the clamp set screw. Rotate doctor blade, locate mounting screws, (socket head and flat head).



Clamp
Set screw



4. Re-tighten clamp set screw. This will help you to remove the mounting screws. Remove all mounting screws.

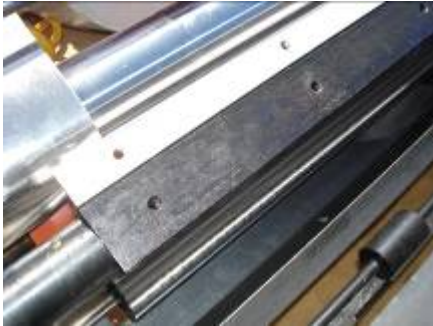


5. Carefully remove aluminum plate and doctor blade.
6. Carefully separate the blade from the aluminum plate.

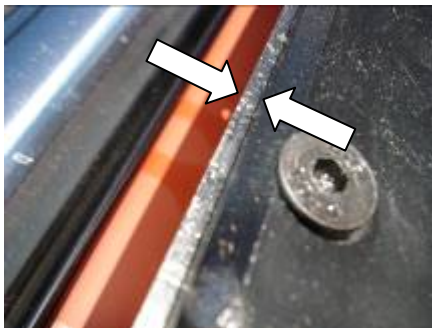
WARNING: DOCTOR BLADE HAS SHARP EDGES, GLOVES ARE REQUIRED.



7. Clean the aluminum plate and doctor blade base holder.



8. Set the new doctor blade on base holder, aligned screw holds. Set the aluminum plate on top of the doctor blade and secure with mounting screws.
9. Make sure that the doctor blade is at an **even height**.



Height should be Even.

10. Loosen the clamp set screw and rotate the doctor blade back into its original position against the impression roller. Re-tighten the set screw.



11. Re-attach side panel and roller adjustment handles. Process is now completed.

17.0

I.R. Lamp Replacement

WARNING: TURN OFF MAIN POWER TO THE MACHINE. HIGH VOLTAGE AND CURRENT ARE USED TO ENERGIZE UV AND IR LAMPS.

Each system has qty 3, I.R. lamps. These lamps are pre-assembled inside the machine. Do not touch the I.R. lamp with your bare fingers, safety glasses and gloves are required. Use TEC Lighting cleaning kit - #99-0950.

I.R Lamp part number - **XC18IRL** 18" IR Lamp

1. Turn **OFF** main power.
2. Open front door and rear panel.



3. Remove all ceramic caps, hex nuts and cable assembly.



4. Remove hex nut and separate C-clamp holder, both ends.



C-Clamp

5. After removing the old I.R lamp, clean the reflector surface with alcohol.
6. Install the new I.R lamp. Clean with alcohol. Re-attach c-clamp, hex nuts cable assembly and ceramic cap.

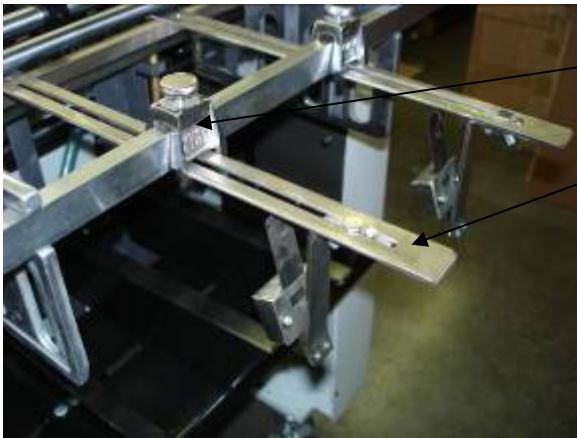
18.0

BOM for XCF18Feeder



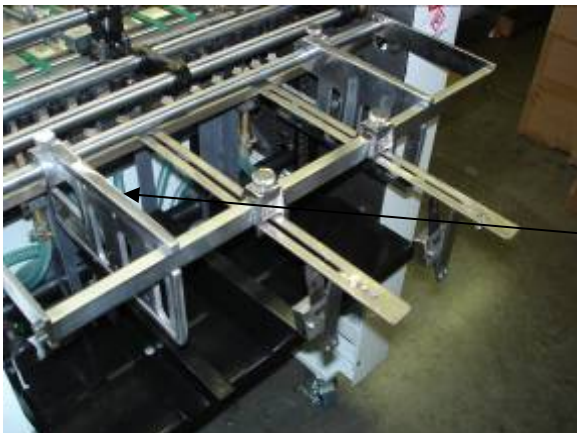
Crank Handle – **XC-020**

Air control Knob – **XC-021**



Guide holder – **XC-023**

Paper weight guide – **XC-022**



Fence paper guide – **XC-024**



Double sheet detector – **XC-025**



Sheet support rails – **XC-026**



X1 Roller Guide Assembly – **XC-027**

X2 Roller Guide Assembly – **XC-028**



X2 Roller – **XC-029**
(long bracket)



X1 Roller – **XC-030**
(short bracket)



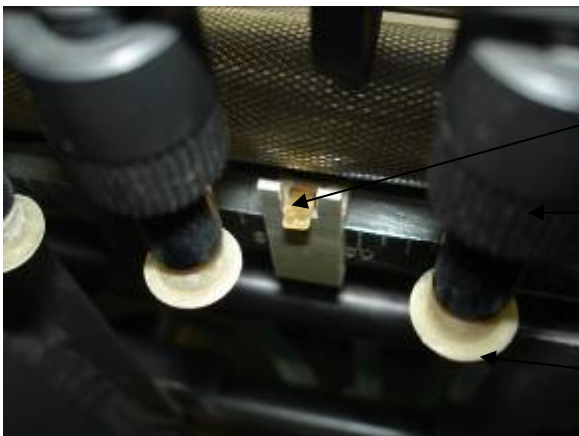
X1 Roller guide holder –
XC-031



Paper finger strap – **XC-032**



Feeder conveyor belt – **BELT-348**



Sheet Separator Finger - **XC-039**

Suction cup assembly – **XC-033**

Suction cup – **XC-040**



p/n for XCF18

Compressor motor – **MOT-111**

Air Compressor – **MOT-110**

Gear motor – **MOT-106**



p/n for XCF25&29

Compressor motor – **MOT-112**

Air Compressor – **MOT-110**

Gear motor – **MOT-108**



P1 pulley belt – **GR-047**

P2 gear belt – **GR-048**

P3 motor belt – **GR-049**



XCF18

P4 Air compressor belt – **GR-046**

XCF25/29

P5 Air Compressor belt – **GR-050**

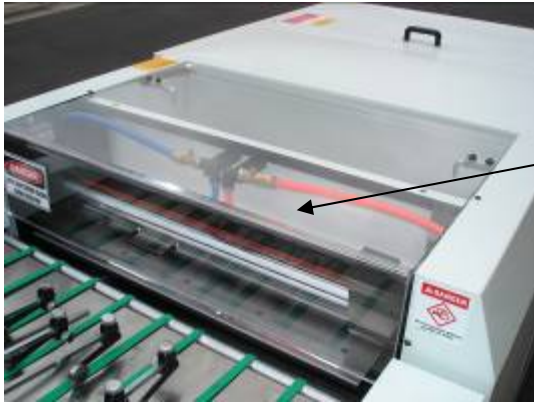


C1 Chain – **GR-051**



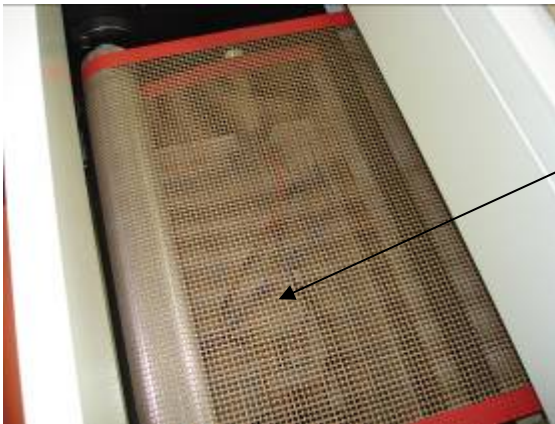
C2 Chain – **GR-052**

19.0 BOM for XCF18/25/29 Conveyor / Coater



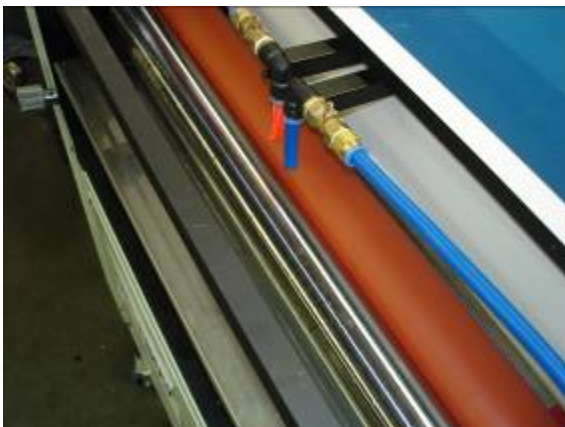
Plastic Cover:

XCF18: #40-5000
XCF25: #40-5001
XCF29: #40-5002



Conveyor Belt:

XCF18: BELT-341
XCF25: BELT-342
XCF29: BELT-345



XCF18:

Rubber – XC18RR
Metering – XC18MR
Bottom – XC18BR

XCF25:

Rubber – XC25RR
Metering – XC25MR
Bottom – XC25BR

XCF29:

Rubber – XC29RR
Metering – XC29MR
Bottom – XC29BR



XCF18:

UV Lamp – **XC18L**

Extrusion w/ Liner - **XC18EL**

Reflector Liner - **XC18RL**

XCF25:

UV Lamp – **XC25L**

Extrusion w/ Liner – **XC25EL**

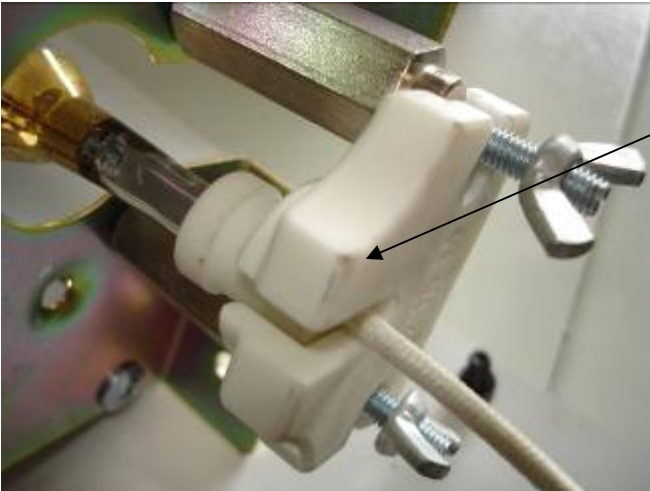
Reflector Liner – **XC25RL**

XCF29:

UV Lamp – **XC29L**

Extrusion w/ Liner – **XC29EL**

Reflector Liner – **XC29RL**



XC Lamp holder bracket – **XC-034**



XCF18:

Doctor Blade – **XC18DB**

XCF25:

Doctor Blade – **XC25DB**

XCF29:

Doctor Blade – **XC29DB**



XCF18:
I.R Lamp – **XC18IRL**

XCF25:
I.R Lamp – **XC25IRL**

XCF29:
I.R Lamp – **XC29IRL**

I.R Ceramic lamp holder – **XC-035**

Steel C-Clamp – **XC-036**



Blue Tubing – **TBG-035**

Orange Tubing – **TBG-034**

Hose fitting connection – **XC-037**

Black UV Hose – **TBG-033**

UV Pump assembly – **MOT-100**

**WARNING: TURN OFF MAIN POWER, LOCKOUT INPUT POWER TO THE MACHINE.
THIS MACHINE HAS ROTATING ROLLERS AND CAN CAUSE SERIOUS INJURY.**

Any machinery with movable gears and rotating rollers require lubrication. The XC Coater and Feeder has many movable parts and needs to be grease and lubricated **Every 30 days**. The grease type should be **SKF** brand, **LGEP, LGHP** or equiv. The lubricant oil, should be Hydraulic oil **DTE-25** or equiv.

CAUTION: Lubricating oil and grease are hazardous material – please review MSDS sheet. – Both hazardous materials can tarnish the paint finish.



Hydraulic oil – Tec Lighting p/n **XCHO**

1. Remove UV coater and Feeder front / rear side panel.



UV COATER



FEEDER

2. The pictures shown below are components that need to be lubricated.



Conveyor roller bearing



Conveyor belt tracking guide

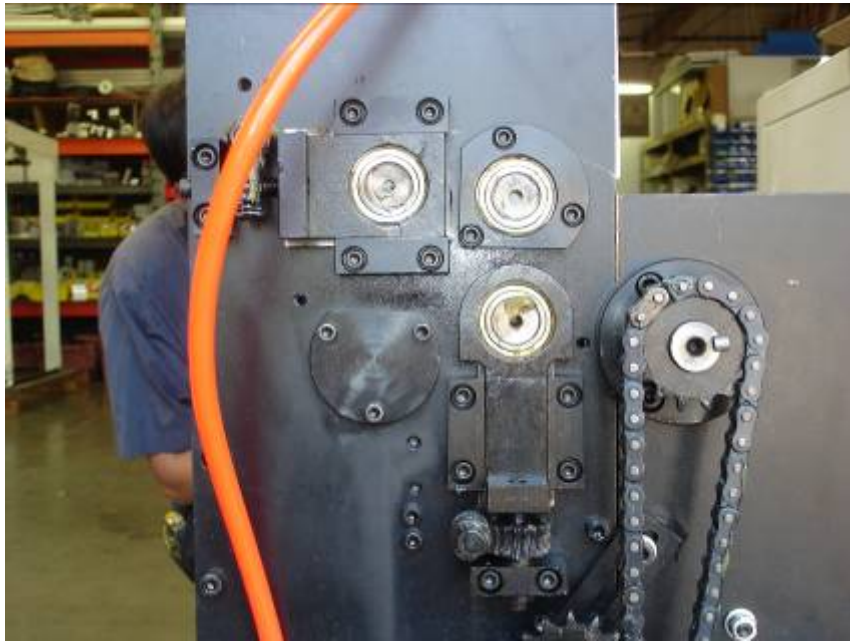


UV COATER (front side) – all moving parts need to be lubricated.

NOTE: SOME PARTS ARE IDENTIFIED BY A RED DOT, THESE ITEMS MUST BE LUBRICATED.



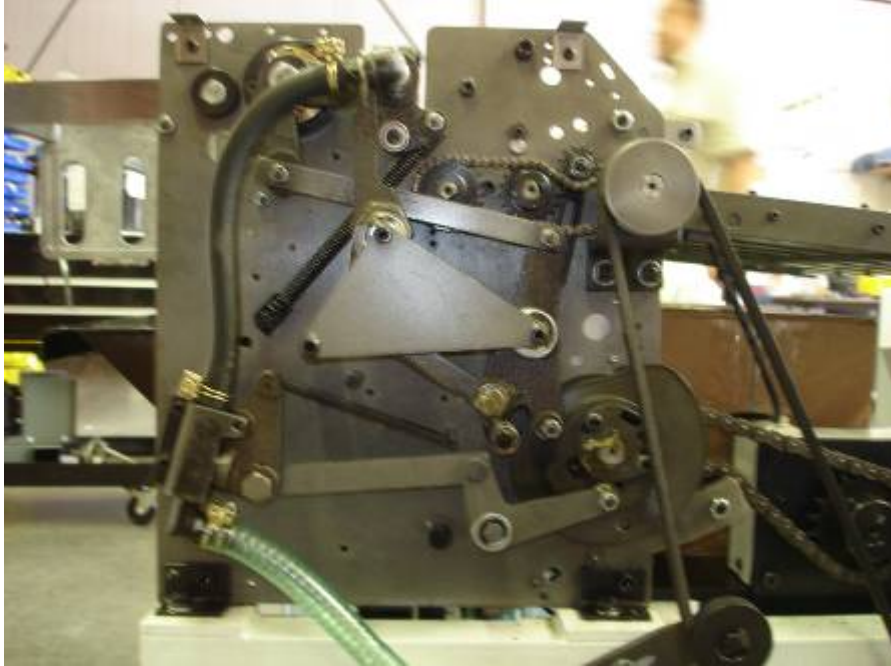
Red Dot



UV COATER (rear side) – all moving parts need to be lubricated.
**NOTE: SOME PARTS ARE IDENTIFIED BY A RED DOT,
THESE ITEMS MUST BE LUBRICATED.**



FEEDER (front side) – all moving parts need to be lubricated.
**NOTE: SOME PARTS ARE IDENTIFIED BY A RED DOT,
THESE ITEMS MUST BE LUBRICATED.**



FEEDER (rear side) – all moving parts need to be lubricated.
**NOTE: SOME PARTS ARE IDENTIFIED BY A RED DOT,
THESE ITEMS MUST BE LUBRICATED.**

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