

Replacing Plate Shuttle on a WASP Plate Sealer

Remove WASP Plate sealer from all power and pneumatic supplies, situate on a clear work area for access. Ensure the WASP has 'cooled down' to enable safe handling of the unit before starting any actions.

Take the left hand service panel off (a flat headed screwdriver is required). Then proceed to taking the display bezel off (a 2.5mm allen key is required); you can then carefully remove the display from the cover. It may be easier to angle the display out with the heater block pushed down. Then take out the four screws holding the cover on (a 3mm allen key is required). When taking the cover off, apply a small amount of pressure at the bottom (pulling outwards) of the cover to allow for easier removal.



Fig. 1



Fig. 2



Fig. 3



Fig. 4

- Ensure plate sealing heater block is 'up' and not resting on plate shuttle. (Push heater block up out of the way if not up. Using screwdriver, place it in between the heater block and the aluminium support plate and pull the heater block up).
- Pull plate shuttle forward out of the interior of unit to gain access.
- Unscrew the shoulder bolt that the large cylinder (plate shuttle) is fixed to and leave the knuckle in place on the cylinder (a 3mm allen key is required). **Fig. 5**
- Unscrew end stop (washer) off end of the shuttle rod (a 3mm allen key is required).
- Unscrew the shoulder bolt that the small cylinder is connected (foil gripper), (a 2.5mm allen key is required). **Fig. 6**



Fig. 5



Fig. 6

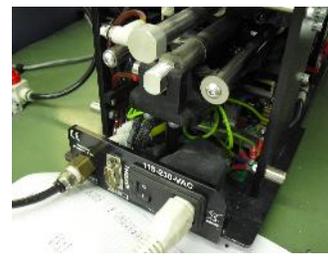


Fig. 7

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- Disconnect the drag chain from the plate shuttle and the cylinder will drop down. Leaving the fittings in the cylinder, remove both the red and the blue pipes.
- Disconnect the two black pipes from the two pin cylinders on the extended plate shuttle and also disconnect the wire (red and black) that connects to the solenoid valve (SYJ5120-5LOU-M5-Q). Cut the pipes back to the drag chain (that have just been disconnected), they are redundant now.
- You should be able to remove the extended plate shuttle assembly and replace it with the standard plate shuttle assembly supplied. Pull the plate shuttle outwards and it will come off the bearings and the cutter block, the standard plate shuttle will just slide onto the four bearings and you will likely have to line the cutter block up. If for any reason it seems slightly tighter than the previous shuttle, loosen the eight screws that fix the rods move the plate shuttle directly over the bearings and tighten the screws again (a 3mm allen key is required).
- Replace the red and the blue pipes, make sure they are secure and the knurled nuts are tight.
- Replace the shoulder bolt to hold the small cylinder (foil gripper) in place (a 2.5mm allen key is required). **Fig. 6**
- Replace the large cylinder (plate shuttle) screwed into the knuckle with the shoulder bolt (a 3mm allen key is required). **Fig. 5**
- Replace end stop (washer) to right hand shuttle rod as you look at the front of machine (a 3mm allen key is required). **Fig. 7**
- Apply the plate shuttle holder labelled 28121-012 with the countersink screws supplied (a 2.5mm allen key is required).



Fig. 8

- Ensure heater block is in the 'up' position and push the plate shuttle into the unit.
- Reapply the cover ensuring all wires and cables are out of the way.
- Once cover is on the left hand service panel can be screwed on (a flat headed screwdriver is required), and also the cover can be screwed up (a 3mm allen key is required). **Fig. 3 & 4**

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- Apply all the wires and cables to the display and then carefully angle it into the cover. It may be easier to angle the display in with the heater block pushed down. When putting the display in the cover, ensure all wires and cables are placed towards the top. Screw on the display bezel (a 2.5mm allen key is required). Open the door and lift the heater block up.



Fig. 9

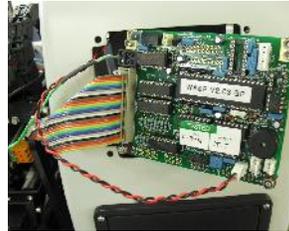


Fig. 10

- Reapply WASP Plate sealer with power and pneumatic supplies and wait for unit to reach optimum temperature.
- You may need to adjust the flatness of the plate shuttle; if so you will need to remove the plate shuttle holder (a 2.5mm allen key is required) **Fig. 8**. Look very closely at the seal that was just run through and if there is a weaker/stronger corner/side then use the jacking screws in the four corner positions of the plate shuttle to even the seal **Fig.11**. Once you believe this is achieved, replace the plate shuttle holder and run another cycle. Repeat until desired outcome is achieved. In this case it is best to do a flash seal so you get a worse case scenario. The settings I would suggest are 165°C and 0.5 seconds.

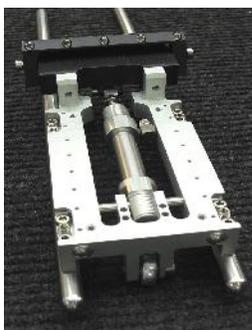


Fig. 11