



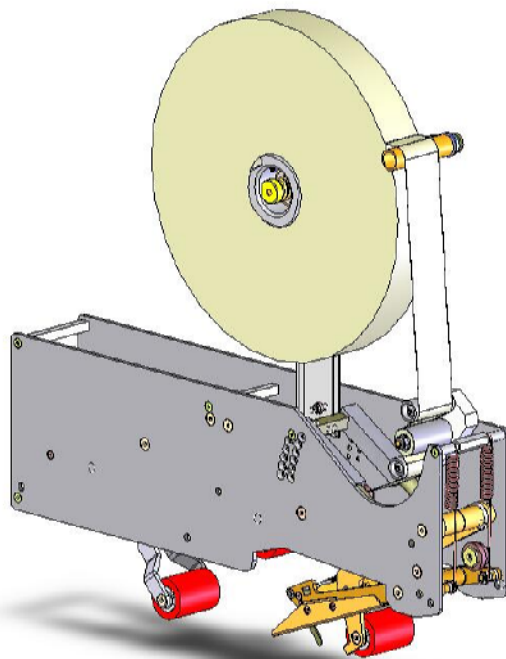
# INTERPACK

TAPE HEADS

## HSD2000 XS II 2" / 3" TAPE HEAD UH088 / UH588

### OPERATION MANUAL & PARTS LISTS

UDH10002 Rev. 0



# OPERATION MANUAL

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# **SERVICE INSTRUCTIONS**

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## **Service**

This is the manual for the Intertape HSD2000 XS II series Tape Head. It has been set up and tested in our factory with Intertape brand tapes. If any problems occur when operating this equipment and you desire a service call or phone consultation, call **Intertape Customer Service** at 1-800-972-4675.

Please provide the customer service representative with the Tape Head model number and serial number. If you have a technical question that does not require an immediate response, you may fax it to 1-813-621-9680.

## **Replacement Parts**

Order parts by item number, part name and quantity required. Replacement parts are available from your Authorized Interpack Distributor. Should you require assistance selecting the correct part, you may call:

Intertape Polymer Group  
Interpack Machinery Division  
9940 Currie Davis Drive, Suite 23B  
Tampa, FL, 33619

Tel: 1-800-972-4675  
Fax: 1-813-621-9680

MODEL:

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SERIAL NUMBER:

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DATE OF PURCHASE:

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## WARRANTY

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**EQUIPMENT WARRANTY AND LIMITED REMEDY:** The following warranty is made in lieu of all other warranties, express or implied, including, but not limited to, the implied warranty of merchantability, the implied warranty of fitness for a particular purpose, and any implied warranty arising out of a course of dealing, a custom or usage of trade: Intertape sells its HSD2000 XS II series Tape Heads with the following warranties:

1. The knife blades, springs and wipe down rollers will be free from all defects for a period of ninety (90) days. A lifetime warranty is available after delivery with an Annual Tape Agreement and completed Pioneering Protection Warranty form. Contact your Intertape representative for further details.
2. All other HSD2000 XS II Tape Head parts will be free from all defects for one (1) year after delivery.

If any part is proven defective within its warranty period, then the exclusive remedy and Intertape's and the seller's sole obligation shall be, at Intertape's option, to repair or replace the part, provided the defective part is returned immediately to Intertape's factory or an authorized service station designated by Intertape.

A part will be presumed to have become defective after its warranty period unless the part is received or Intertape is notified of the problem no later than five (5) calendar days after the warranty period.

If Intertape is unable to repair or replace the part within a reasonable time, then Intertape, at its option, will replace the equipment or refund the purchase price. Intertape shall have no obligation to install the repaired or replacement part.

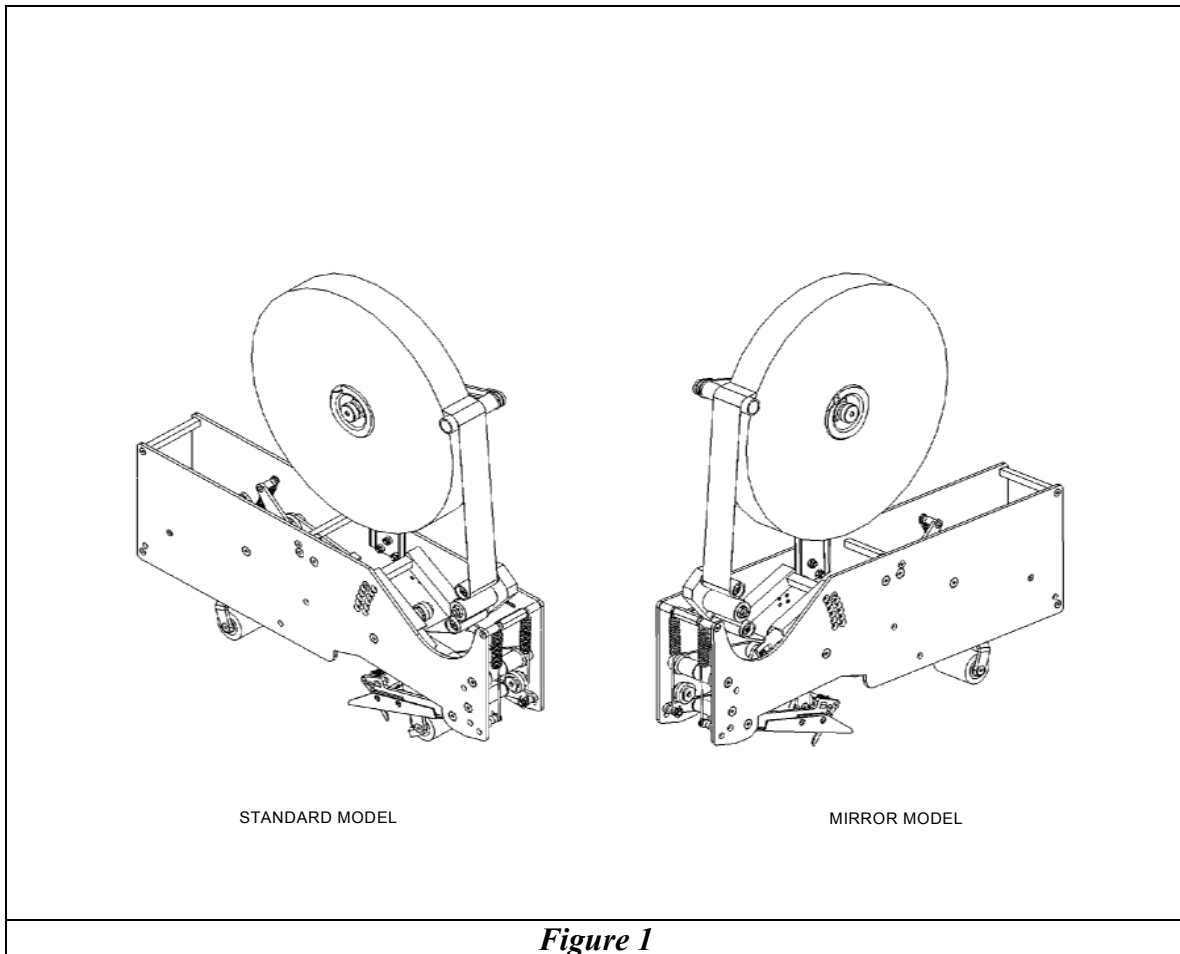
Intertape shall have no obligation to provide or pay for the labor required to install the repaired or replacement part. Intertape shall have no obligation to repair or replace (1) those parts failing due to operator misuse, carelessness, or due to any accidental cause other than equipment failure, or (2) parts failing due to inadequate cleaning, improper operating environment, improper utilities or operator error.

**LIMITATION OF LIABILITY:** Intertape and seller shall not be liable for direct, indirect, special, incidental or consequential damages based upon breach of warranty, breach of contract, negligence, strict liability or any other legal theory.

The foregoing Equipment Warranty and Limited Remedy and Limitation of Liability may be changed only by written agreement signed by authorized officers of Intertape and seller.

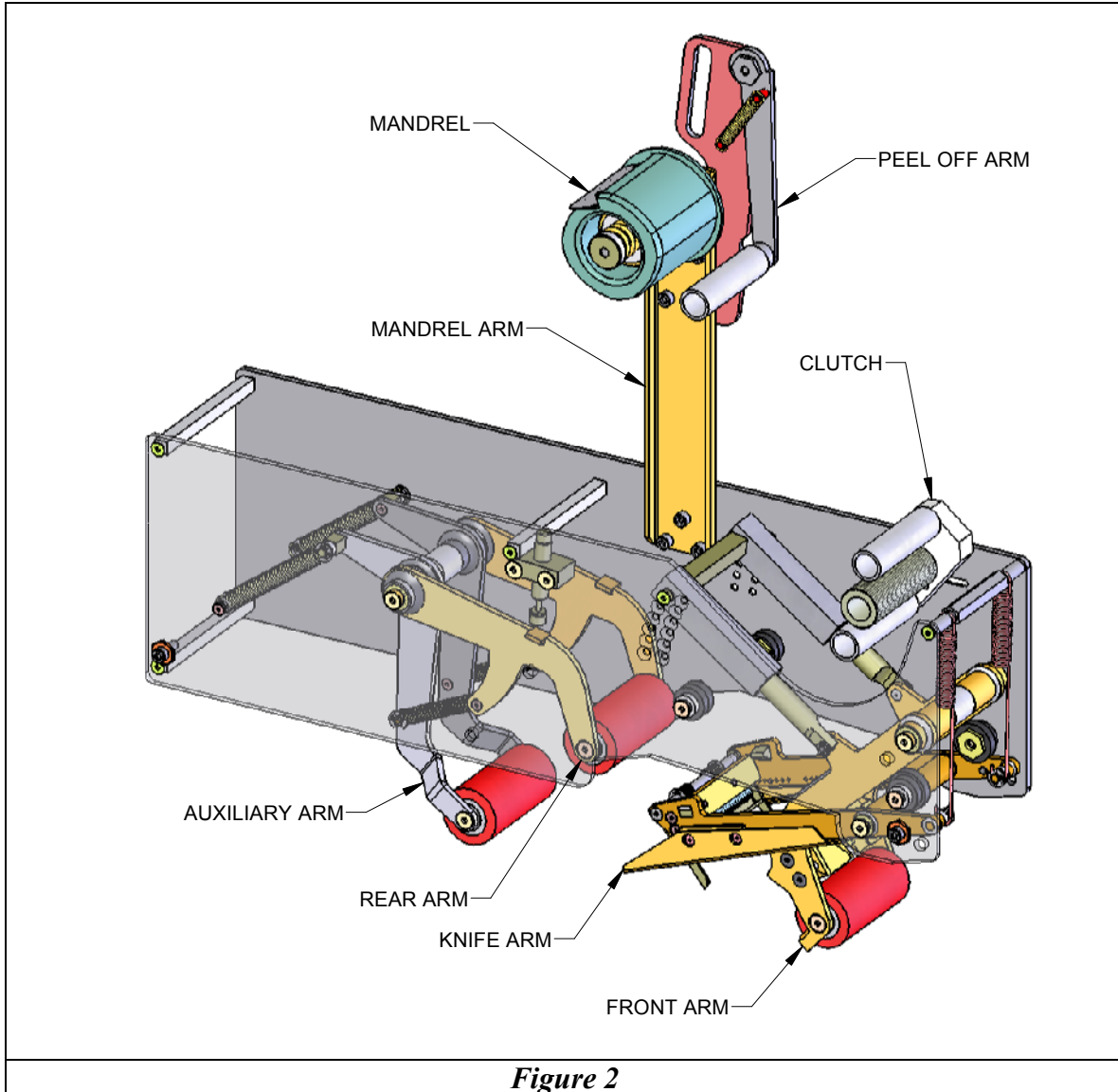
## DESCRIPTION OF TAPE HEADS

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The HSD2000 XS II Tape Head (figure1) is designed to apply Intertape brand pressure sensitive carton sealing tape to the top and bottom center seam of regular slotted corrugated cartons. It is easy to set-up and to operate. The model shown in this manual is a standard 2" Tape Head. Also available are the mirror models 2" or 3" wide.

## How the Tape Head Works



When the operator installs a new tape roll on the mandrel, the Tape Head is ready to operate. The tape leg catches the front side of the incoming carton. The tape is then applied to the top or bottom of the carton with pressure provided by the front arm. When the carton's rear edge advances passed the front arm and knife arms, both arms are snapped back into place and the knife cuts the tape. As the carton exits the tape head the rear arm snaps back into place wiping down the rear leg of the tape.

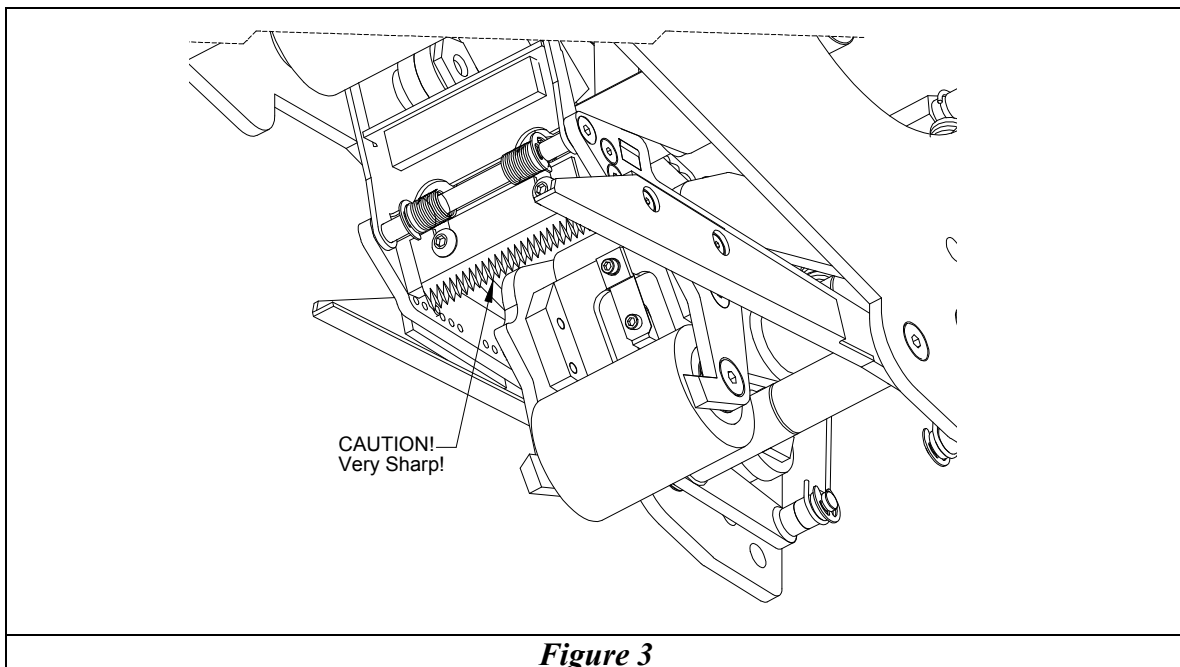
# SAFETY ISSUES

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## Safety Rules

The Tape Head has been designed to be extremely safe for operators and bystanders. Nevertheless, accidents can happen. Therefore, it is important to follow safe work practices. The operator must read and follow these safety rules when working on or near the device.

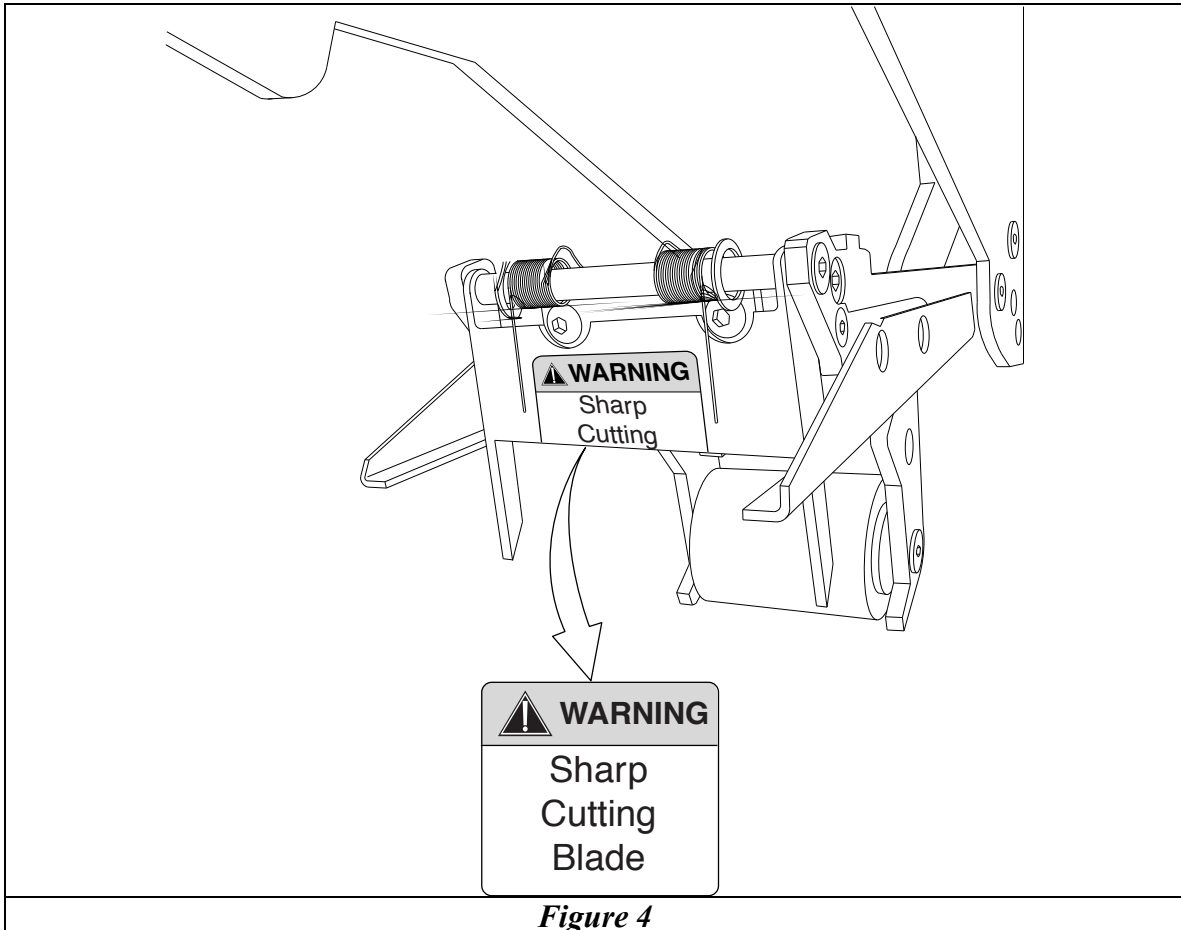
- Read this manual and its safety instructions thoroughly before operating.
- Only trained personnel are to operate, adjust or service the equipment.
- Shut off machine in case of emergency.
- Never wear loose clothing, jewelry or tie when operating machine.
- Wear safety glasses.
- All covers and guards must be in place before operating.
- Stay clear of moving parts which may shear and cut.
- Never operate the Tape Head with the knife flipper guard removed.
- Do not modify the equipment in any way. Unauthorized modification may impair the function and/or safety and could affect the life of the equipment.
- Carefully read all safety decals on the Tape Head. If they are damaged and become illegible, replace them immediately. (See section 2.2, figure 4 for safety decal location).
- Use caution when handling knife. Knife blade is very sharp. Do not touch blade with bare hand.



*Figure 3*

## Safety Decal Location

The figure below shows where the safety decal is located on the equipment. Replace decal if it is absent or becomes illegible. Replacement decals can be found in the Parts section of this manual.

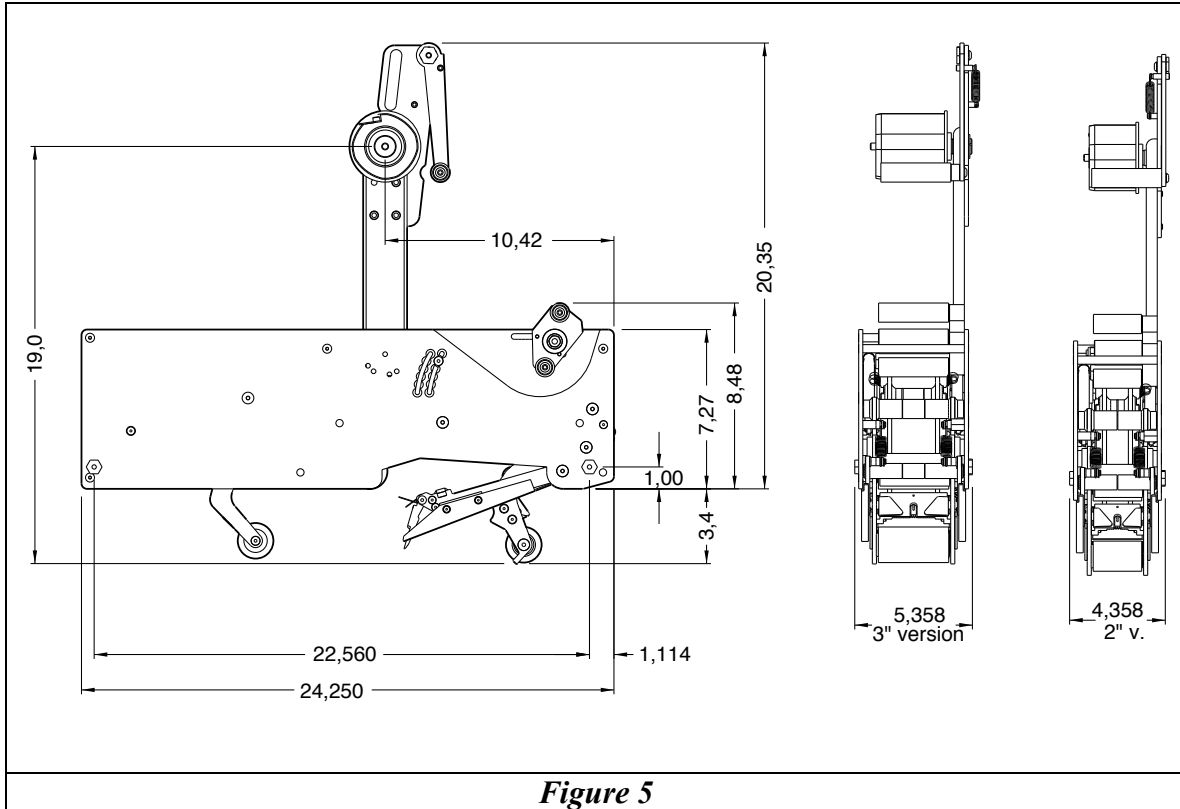


*Figure 4*



# SPECIFICATIONS

## Dimensions



*Figure 5*

## Tape Head Weight

Tape Head weight when shipped:  
2" model: 29 lbs (13 Kg)  
3" model: 32 lbs (14.5 Kg)

## Operating Conditions

Use in a dry, relatively clean environment at 40° to 105° F (5° to 40° C) with clean dry cartons.

**Note:** The Tape Head should never be washed down or subjected to conditions causing condensation on components.

## **Tape Requirements**

1. Type:  
Intertape brand Pressure Sensitive Carton Sealing Tape.
2. Tape Width:  
1 ½ to 2 inch wide tape maximum for the 2” model.  
2 ½ to 3 inch wide tape maximum for the 3” model.
3. Tape roll diameter:  
Maximum of 16 inches.
4. Tape Application Leg Length:  
From 2 3/8” to 2 ¾”.

# SET-UP PROCEDURES

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## Receiving and Handling

All contents must be verified upon reception. The following items must be in the box: HSD2000 XS II Tape Head with mandrel arm dismounted, this brochure, 4 mounting adaptors with M6 socket head cap screws, one extra blade flip-guard torsion spring, two knife arm extension springs, two compression springs and two extension springs for the rear arm.

**Note:** After unpacking the Tape Head, look for any damage that may have occurred during shipping. Should the Tape Head be damaged, file a claim with the transport company and notify your Intertape representative.

## Tape Head Installation

The tape heads require the installation of adapters to mount into the machines. Different length adapters are supplied with the 2 inch and 3 inch versions of the tape head and other lengths are available. For non-standard mounting adaptors consult technical support.

## Tape Loading

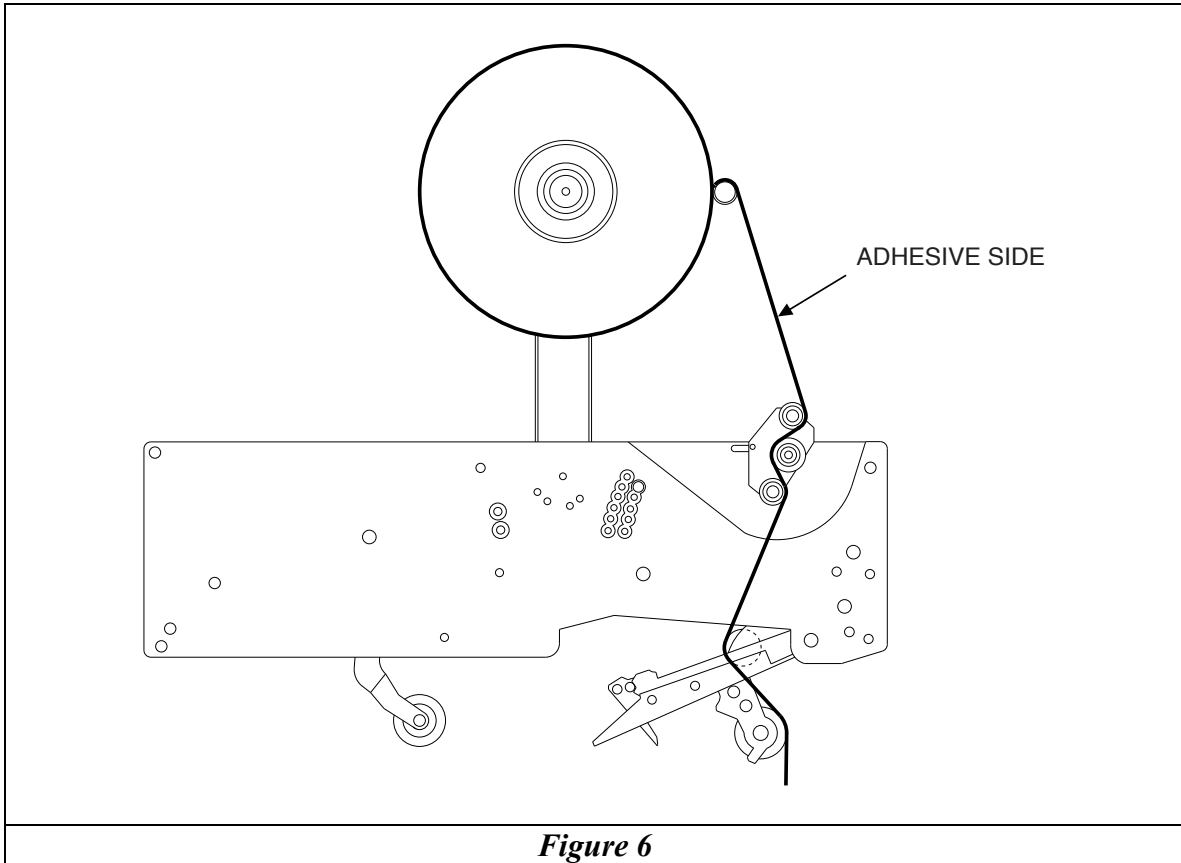
***WARNING! TURN OFF ELECTRICAL POWER SUPPLY AND DISCONNECT THE POWER CORD FROM THE ELECTRICAL SUPPLY BEFORE BEGINNING TO WORK ON THE TAPE HEADS OR TO LOAD TAPE. IF POWER CORDS ARE NOT DISCONNECTED, SEVERE INJURY TO PERSONNEL COULD RESULT.***

Push the roll of tape onto the mandrel with the adhesive side up (refer to Threading Diagram under Tape Threading in this manual) until the core seats against the mandrel flange. This ensures the tape will be aligned when feeding into the tape head.

## Tape Threading

***WARNING! THE KNIFE CONTAINED IN THE TAPE HEAD IS EXTREMELY SHARP. USE CAUTION WHEN REMOVING THE BLADE GUARD AND THREADING THE TAPE TO AVOID PERSONNEL INJURY.***

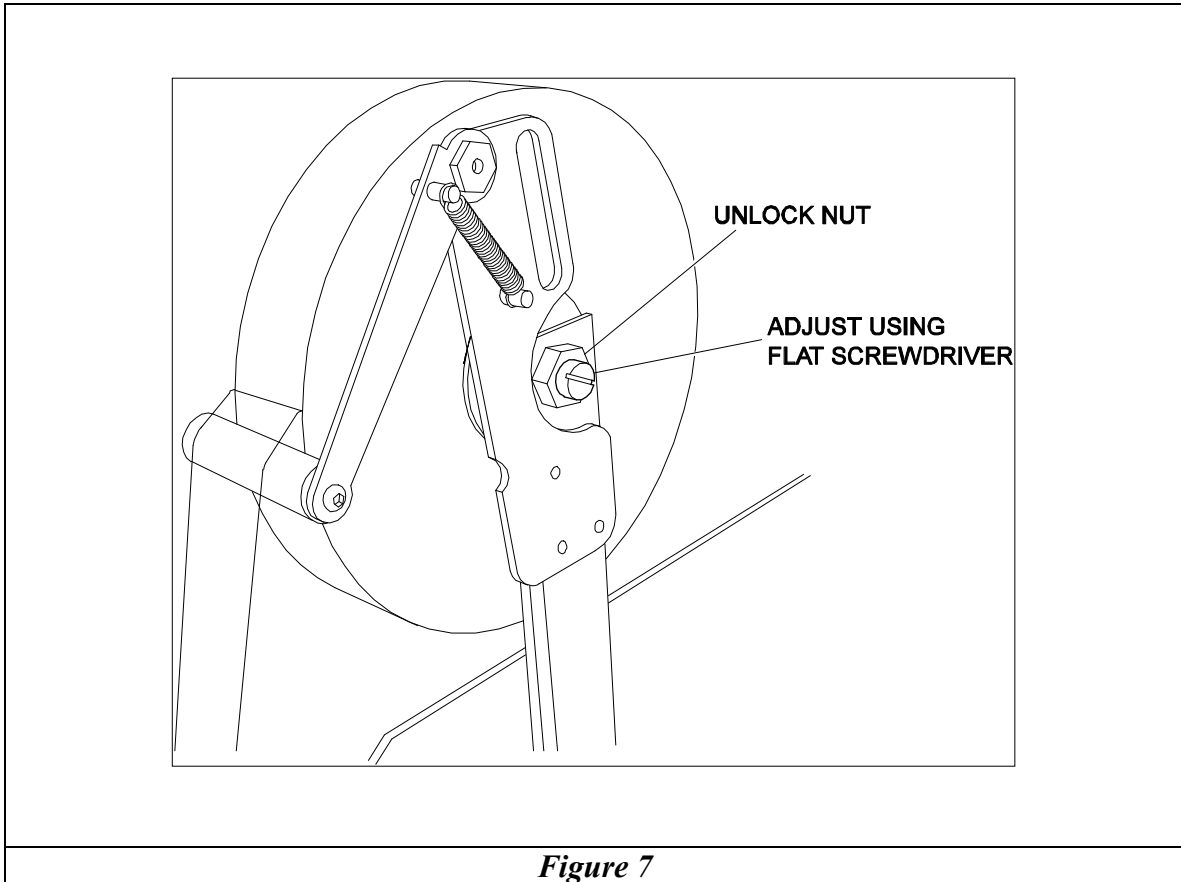
Figure 6 shows how the tape must be threaded. You can also refer to the diagram on the Tape Head plate for threading instructions. Use a knife to cut tape leg.



**Note:** Plastic blade guard must be removed before operating tape head.

## **Tape Centering**

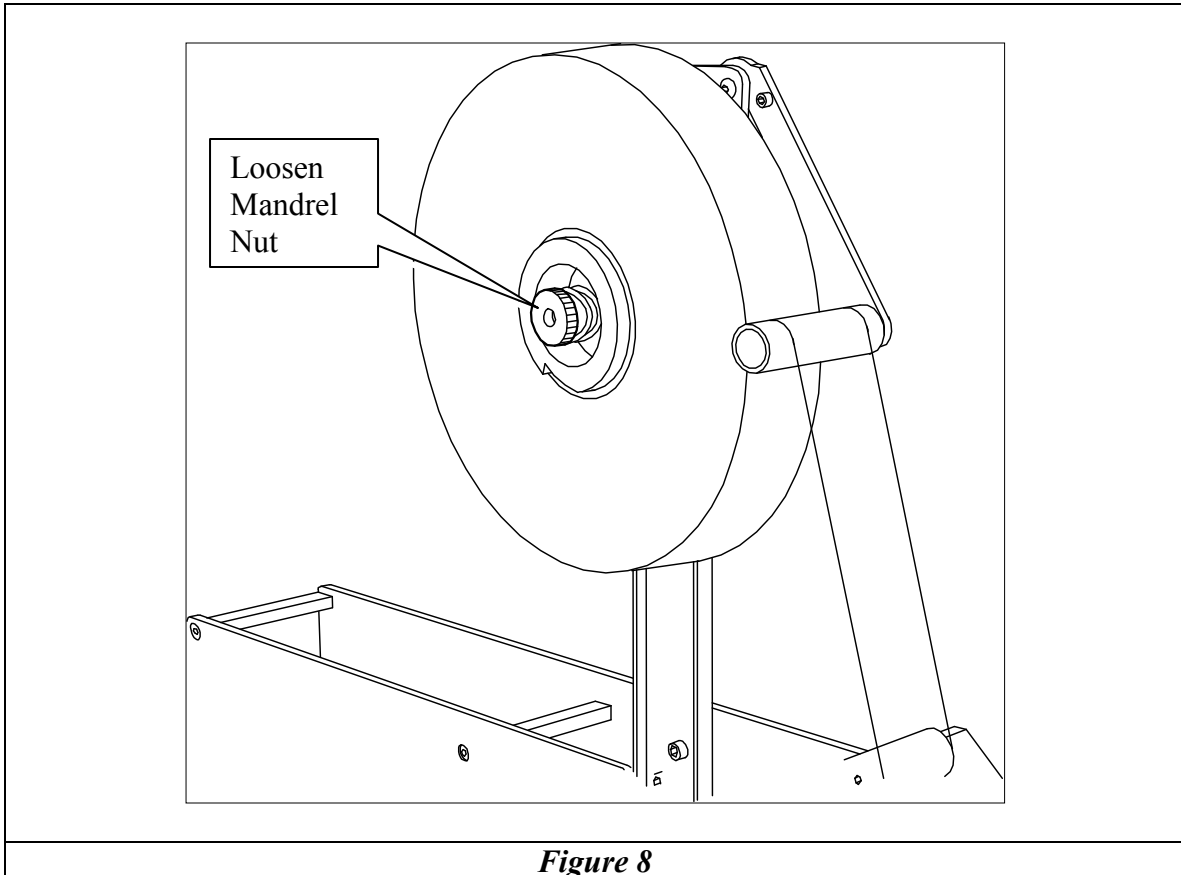
Should the tape require centering, the tape mandrel can be adjusted in and out. First loosen the 1" hex jam nut, then adjust the shaft in or out as required using a flat-head screwdriver. When the tape is centered, tighten the jam nut.



*Figure 7*

## **Tape Tension Adjustment**

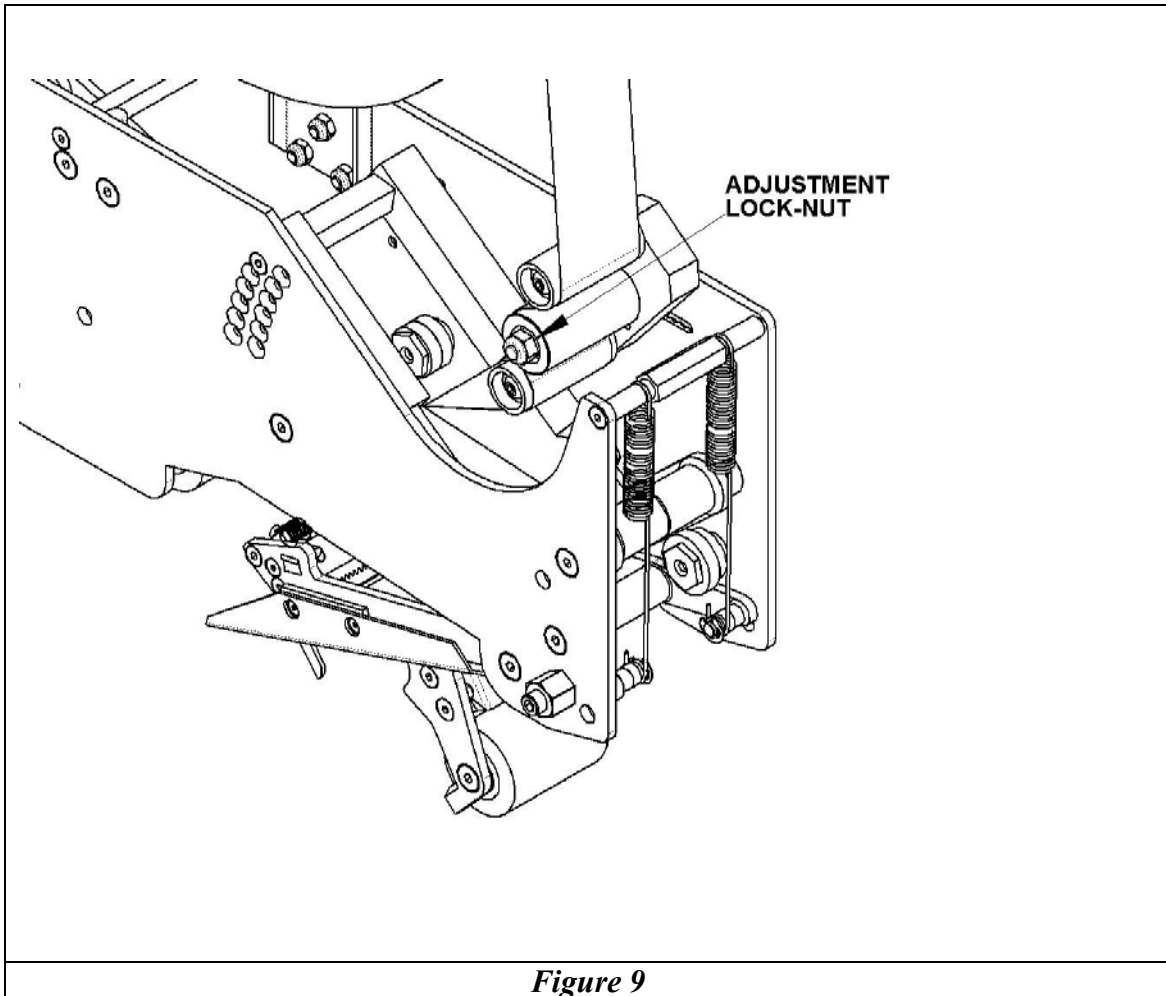
The roll of tape should turn with slight resistance provided by the mandrel. Mandrel tension may be adjusted by turning the mandrel nut (As shown in Figure 8). Turn clockwise for more tension or counter clockwise to loosen the tension.



***Figure 8***

## **Clutch Roller Tension Adjustment**

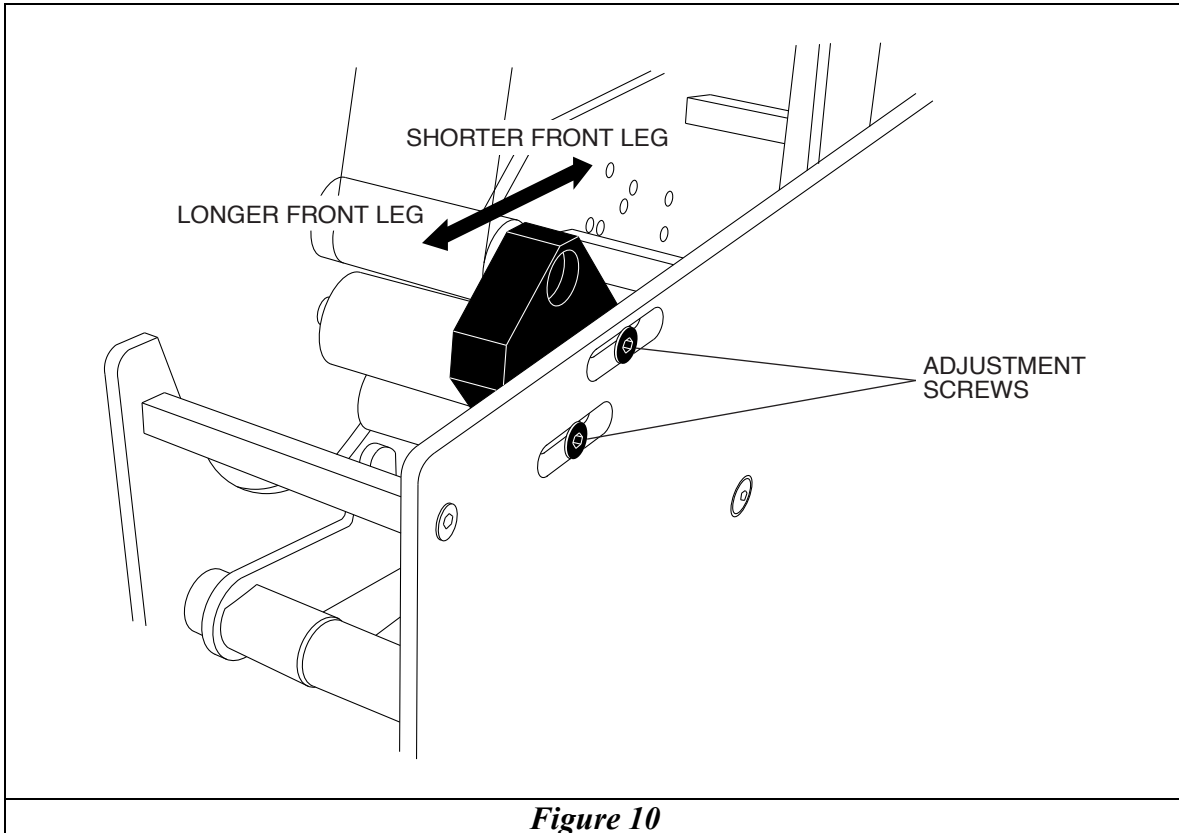
The clutch roller should be adjusted for very little tension. Use lock-nut to adjust tension as shown in figure 9.



*Figure 9*

## **Front Leg Length Adjustment**

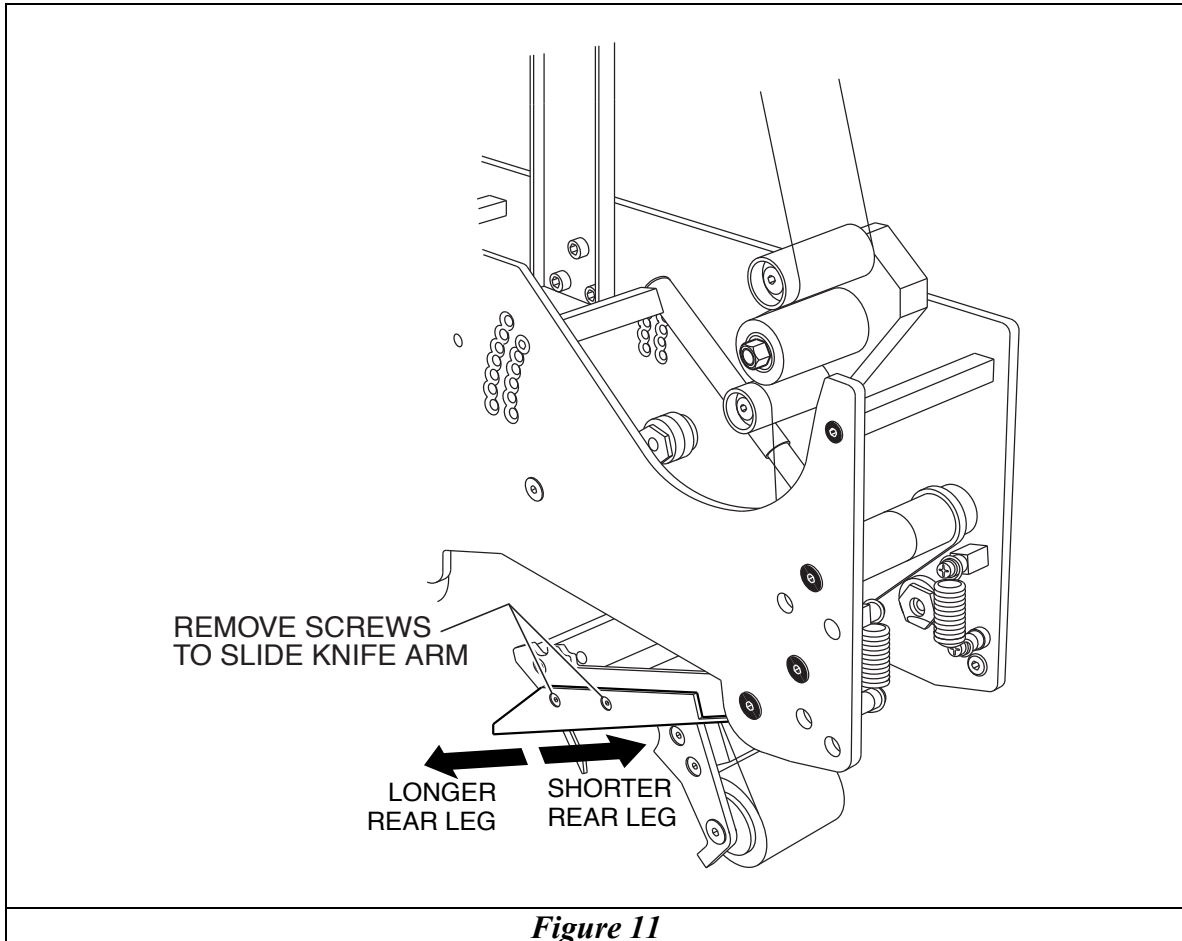
**To adjust the length of the front leg, slide the clutch forward or backward until leg length is satisfactory.** To move the clutch, first loosen the two adjustment screws as shown below. Retighten screws once clutch is adjusted.





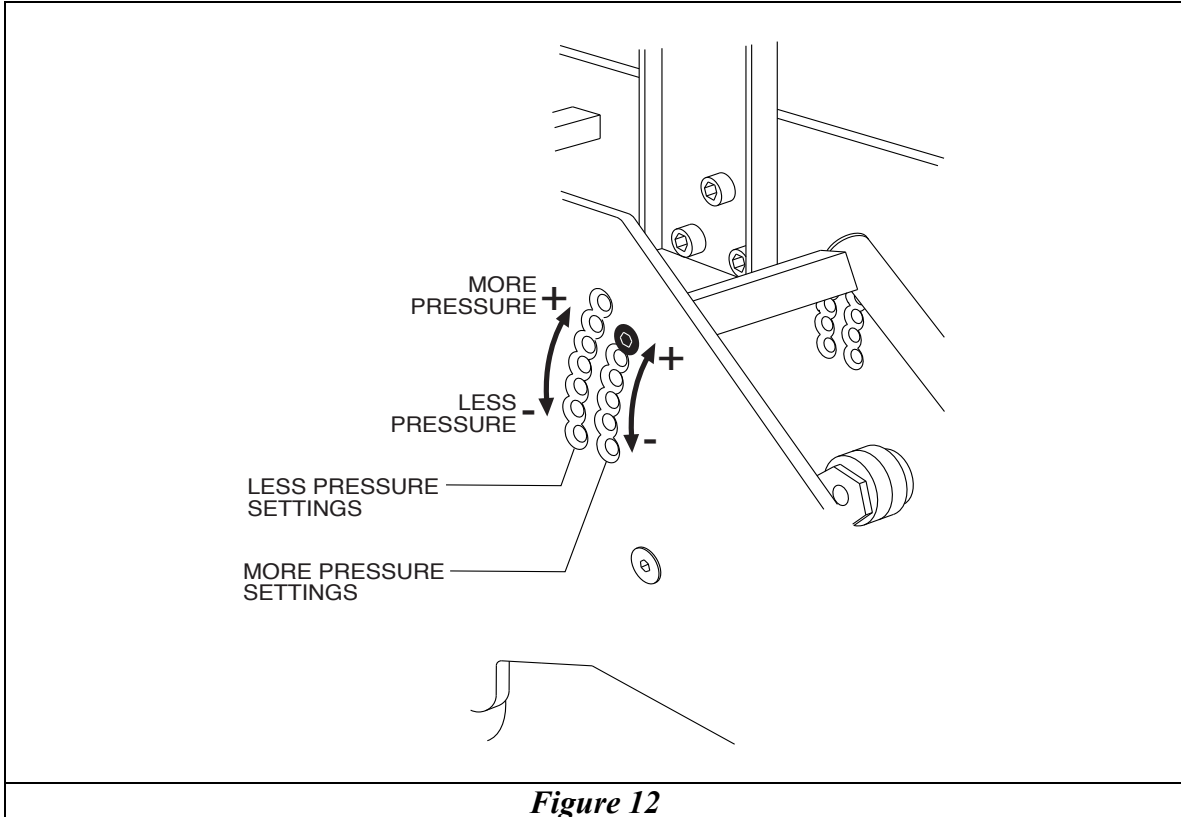
## **Rear Leg Length Adjustment**

To adjust the length of the rear tape leg, remove the four (4) knife arm screws and adjust length by moving the knife arm forward or backward, as shown in figure 11.



## Front Arm Compression Spring Tension Adjustment

This adjustment is done to insure gradual reduction in force as the roller travels up on the end of the carton panel to eliminate carton crushing and dog earring as the front arm's roller turns around the corner onto the center seam. There are two sets of adjustment holes, one for less pressure and one for more pressure. The pressure (or force) can also be adjusted by moving the adjustment screw up or down as shown in figure 12.



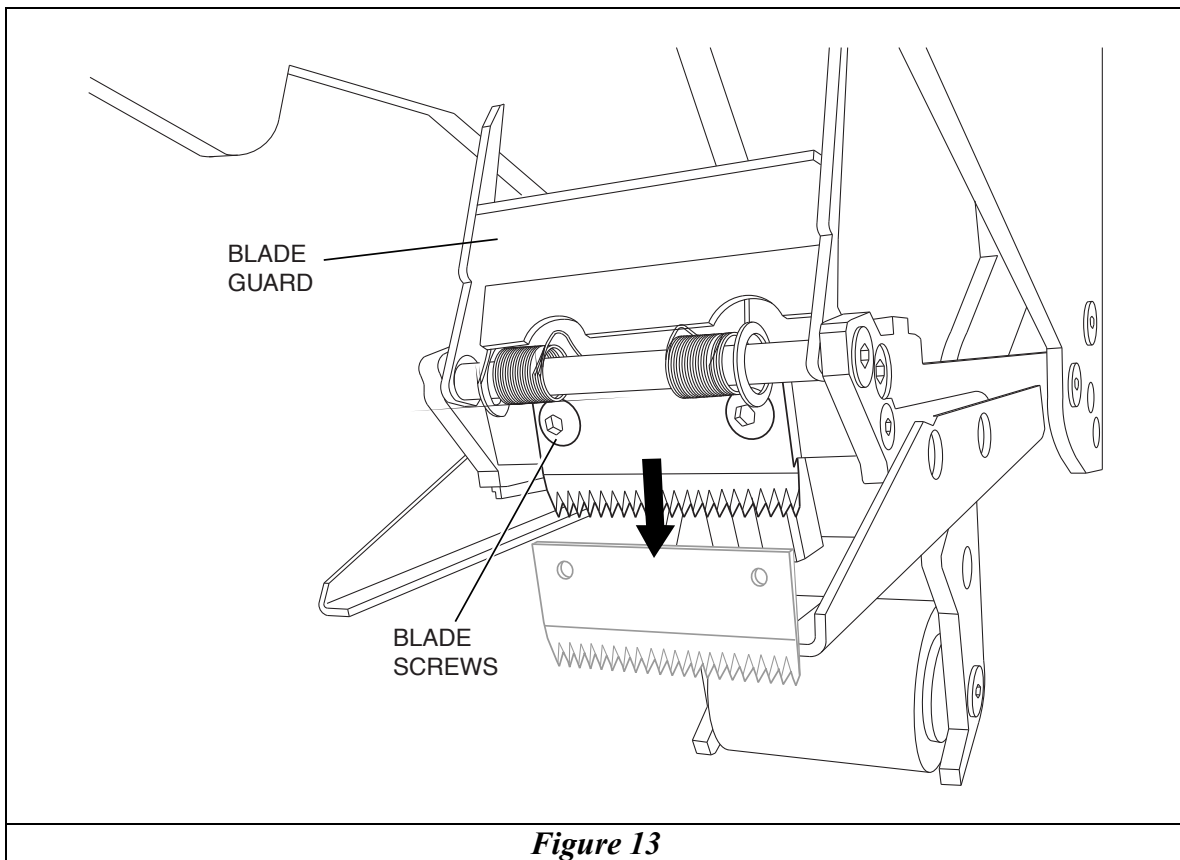
**Figure 12**

## **Blade Replacement**

***WARNING! THE BLADE CONTAINED IN THE TAPE HEAD IS EXTREMELY SHARP. USE CAUTION WHEN OPENING THE BLADE GUARD AND REPLACING THE BLADE TO AVOID PERSONAL INJURY.***

To replace the blade:

1. Open the blade flipper guard
2. Remove the two (2) button head screws
3. Remove and replace the blade. Make sure the flat part of the blade is facing the back plate
4. Ascertain that the blade flipper guard returns to cover the knife blade.



***Figure 13***

## **TROUBLESHOOTING**

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The Tape Head requires minimum maintenance. Simply replace the blade regularly to provide clean tape leg cuts.

<b>PROBLEM</b>	<b>POSSIBLE CAUSE AND SOLUTION</b>
Rear leg stretched or not cut	Blade does not cut. Replace blade.
Rear leg is not properly wiped down	The tape is overstretched by having too much friction on the mandrel or front arm roller.
	Dirt on rear arm causing friction. Clean or replace roller.
Dog ears on carton	Lower pressure by adjusting tension on the front arm compression springs (pivot assembly) as shown in Figure 12.

## RECOMMENDED SPARE PARTS

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### 2" Model:

PART NUMBER	DESCRIPTION	QTY
UPE0199	HX II ROLLER SHELL 2"	3
UPH107	CUT-OFF BLADE 48 mm	1
UPH9002	KNIFE SPRING .50 x .059 x 1.75	2
UPH9010	HX II COMPRESSION SPRING	2
UPH3704	HX II AUXILIARY EXT. SPRING	2
UPM2206	EXTENSION SPRING FLOATING 222	2
UPH3729	KNIFE GUARD SPRING	1
UPH0142	MOUNTING ADAPTOR	4
UF6737	SHCS M6 x 18 mm	4

### 3" Model:

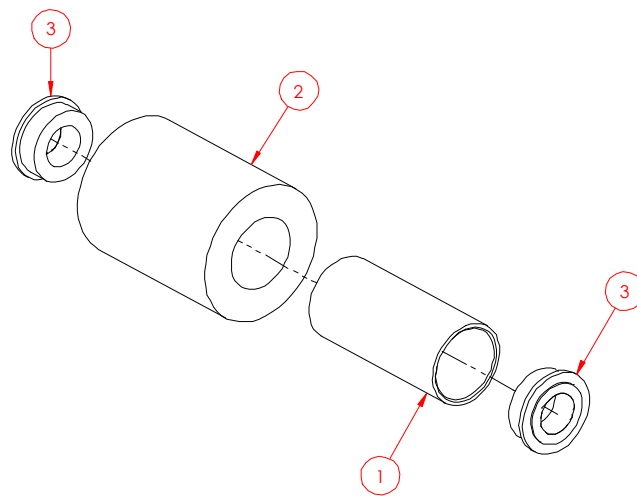
PART NUMBER	DESCRIPTION	QTY
UPE0198	HX II ROLLER SHELL 3"	3
UPH108	CUT-OFF BLADE 72MM	1
UPH9002	KNIFE SPRING .50 x .059 x 1.75	2
UPH9010	HX II COMPRESSION SPRING	2
UPH3704	HX II AUXILIARY EXT. SPRING	2
UPM2206	EXTENSION SPRING FLOATING 222	2
UPH3729	KNIFE GUARD SPRING	1
UPH0139	MOUNTING ADAPTOR	4
UF0810	SHCS M6 x 8 mm	4

BLANK

## PARTS LIST

<b>URETHANE ROLLER ASSEMBLY .....</b>	<b>24</b>
<b>CLUTCH GUIDE ROLLER ASSEMBLY .....</b>	<b>26</b>
<b>AUXILIARY ARM ASSEMBLY .....</b>	<b>28</b>
<b>CLUTCH ASSEMBLY .....</b>	<b>30</b>
<b>MAIN FRAME ASSEMBLY .....</b>	<b>32</b>
<b>COVER FRAME ASSEMBLY .....</b>	<b>34</b>
<b>FRONT ARM ASSEMBLY .....</b>	<b>36</b>
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<b>KNIFE ARM ASSEMBLY .....</b>	<b>40</b>
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<b>MANDREL ASSEMBLY 3" .....</b>	<b>46</b>
<b>MANDREL ASSEMBLY 2" .....</b>	<b>48</b>

## URETHANE ROLLER ASSEMBLY (UAH0045) (UAH0044)

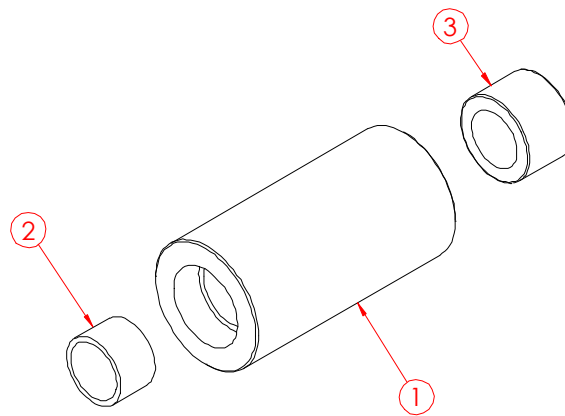




**URETHANE WIPE ROLLER ASSEMBLY  
(UAH0045) (UAH0044)**

ITEM	PART #	DESCRIPTION	UAH0045 2" XS II QTY.	UAH0044 3" XS II QTY.
1	UPH0577	FRONT ROLLER CORE	1	-
1	UPH0741	FRONT ROLLER CORE	-	1
2	UPE0199	XS II ROLLER SHELL 2"	1	-
2	UPE0198	XS II ROLLER SHELL 3"	-	1
3	UPH0582	FRONT ROLLER BEARING #1	2	2

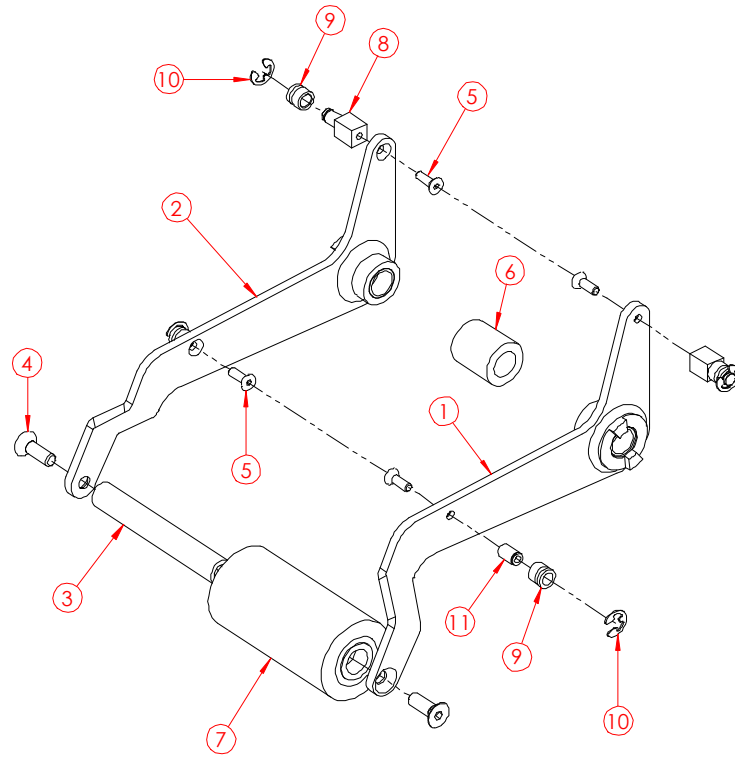
**CLUTCH GUIDE ROLLER ASSEMBLY  
(UAH0059) (UAH0058)**



**CLUTCH GUIDE ROLLER ASSEMBLY  
(UAH0059) (UAH0058)**

ITEM	PART #	DESCRIPTION	UAH0059 2" XS II QTY.	UAH0058 3" XS II QTY.
1	UPH0327	CLUTCH GUIDE ROLLER	1	-
1	UPH0325	CLUTCH GUIDE ROLLER	-	1
2	UPH0089	BEARING GLYCODUR .50 x .38 LG	1	1
3	UPH0091	CLUTCH BEARING	1	1

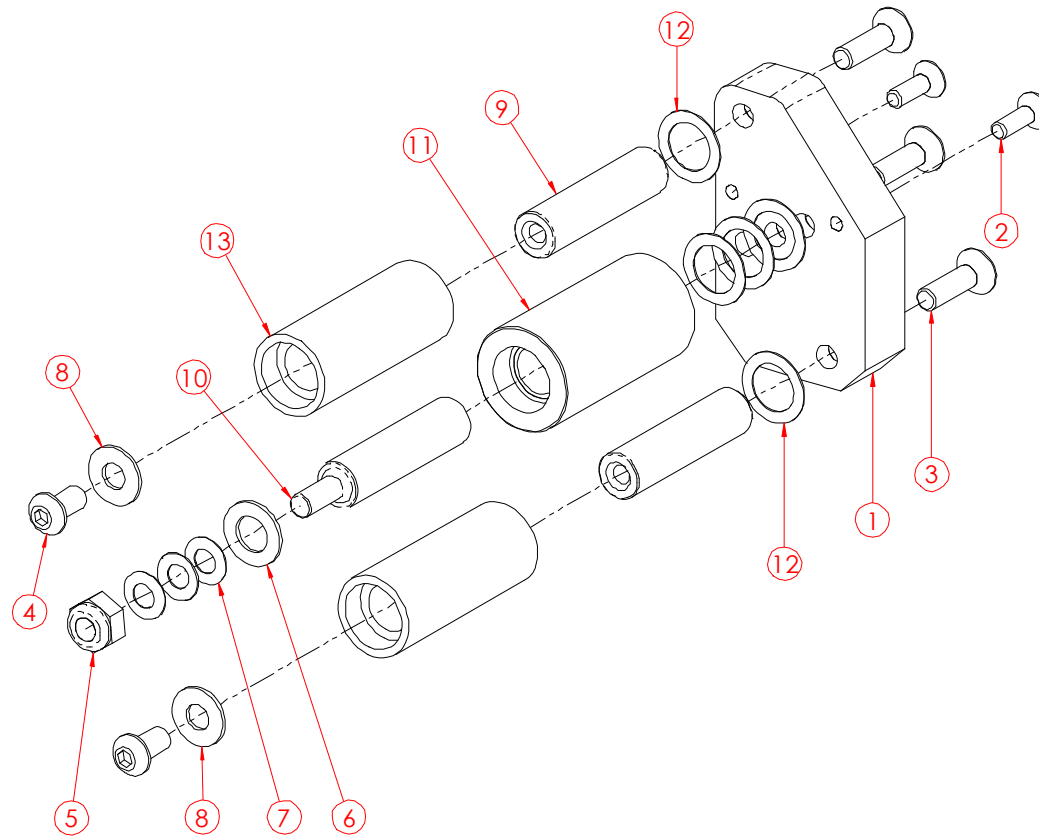
**AUXILIARY ARM ASSEMBLY  
(USH0814) (USH0808)**



**AUXILIARY ARM ASSEMBLY  
(USH0814) (USH0808)**

ITEM	PART #	DESCRIPTION	USH0814 2" XS II QTY.	USH0808 3" XS II QTY.
1	UAH0057	AUXILIARY ARM LEFT	1	1
2	UAH0056	AUXILLIARY ARM RIGHT	1	1
3	UPH1281	FRONT ROLLER SHAFT	-	1
3	UPH3688	FRONT ROLLER SHAFT	1	-
4	UF0960	FHCS HK 1/4-20 X 3/4"	2	2
5	UF0902	FHCS #8-32 X 1/2	4	4
6	UPH0032	SPACER	-	1
7	UAH0044	URETHANE ROLLER ASS'Y 3"	-	1
7	UAH0045	URETHANE ROLLER ASS'Y 2"	1	-
8	UPH3863	SPRING RETAINER #2 Hi	2	2
9	UPH0563	SPRING RETAINER SLEEVE	4	4
10	UF5500	EXTERNAL RETAINING RING	4	4
11	UPH3703	AUX. ARM'S SPRING RETAINER	2	2

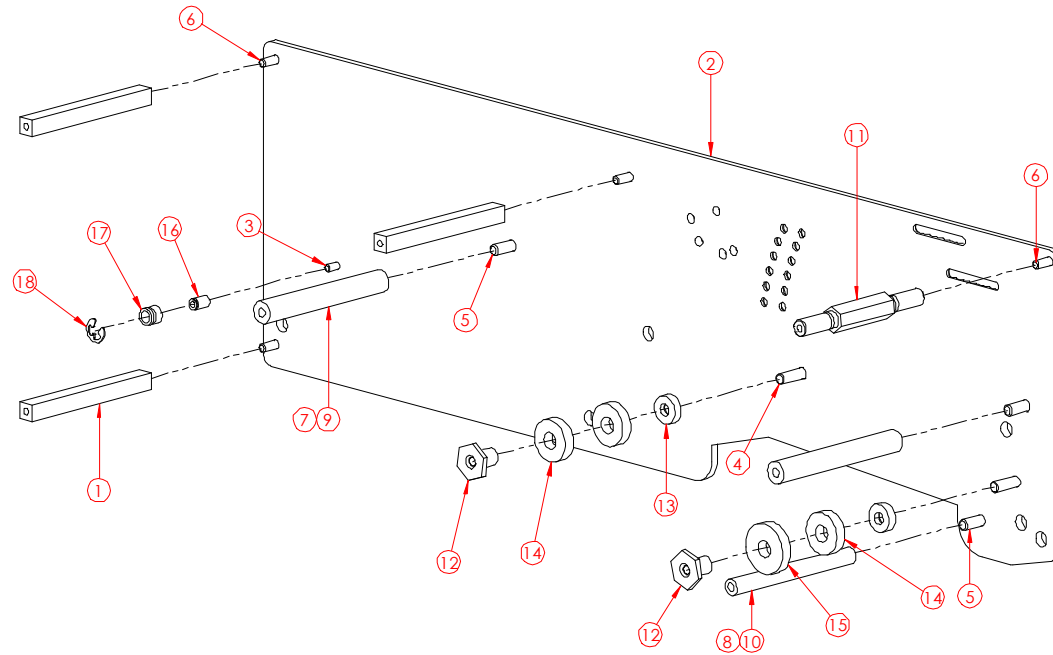
# CLUTCH ASSEMBLY (USH0805) (USH0817)



## CLUTCH ASSEMBLY (USH0805) (USH0817)

ITEM	PART #	DESCRIPTION	USH0805 2" XS II QTY.	USH0817 3" XS II QTY.
1	UPH1276	CLUTCH BRACKET	1	1
2	UF0905	FHCS HK 10-24 X 5/8"	2	2
3	UF1250	FHCS HK 1/4-20 X 7/8"	3	3
4	UF1240	BHCS HK 1/4-20 X 1/2"	2	2
5	UF1670	NYLON LOCK NUT 1/4-20	1	1
6	UF1721	REG F.W. ZINC .390X.682X.05 BS	1	1
7	UF1870	BELLEVILLE W .257 X. 5 X .036	3	3
8	UF1970	F.W. 1/4 X 5/8 X .046 B1526	2	2
9	UPH0075	GUIDE ROLLER SHAFT	2	2
10	UPH0175	CLUTCH SHAFT	-	1
10	UPH0076	CLUTCH SHAFT	1	-
11	UAH0059	CLUTCH GUIDE ROLLER ASS'Y 2"	-	1
11	UAH0058	CLUTCH GUIDE ROLLER ASS'Y 3"	1	-
12	UF1960	NYLON F.W. .515 x .759 x .015	5	5
13	UPH123	FIRST TAPE GUIDE ROLLER	-	2
13	UPH124	FIRST TAPE GUIDE ROLLER	2	-

# MAIN FRAME ASSEMBLY (USH0818) (USH0803)

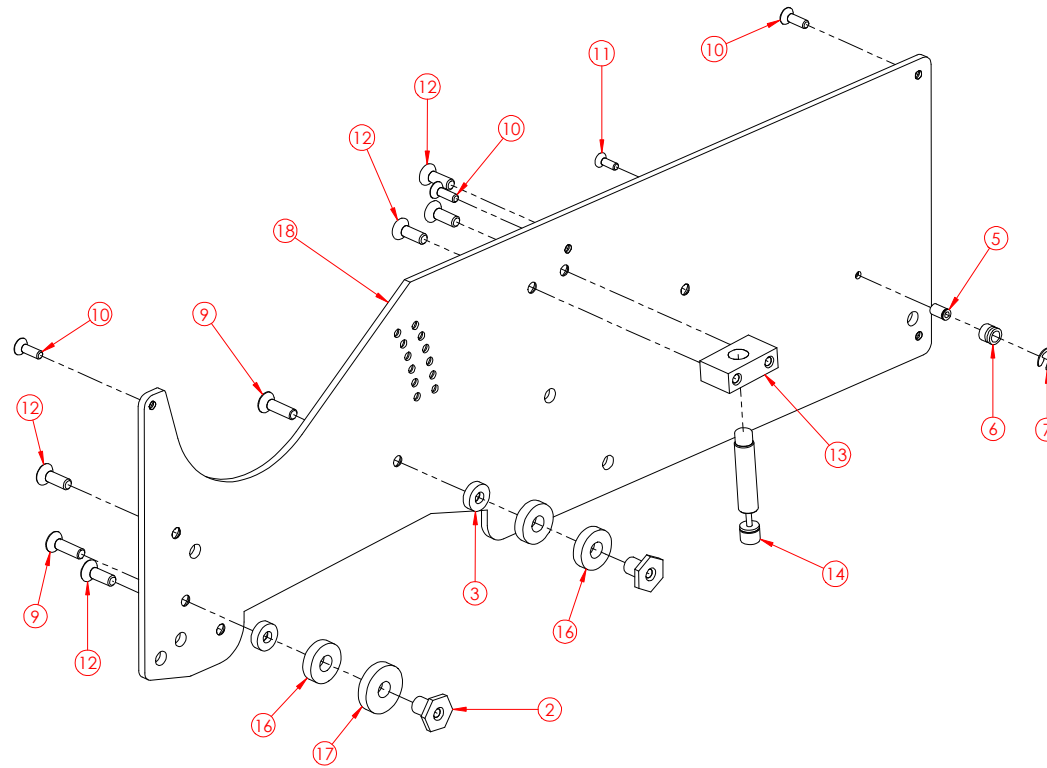




**MAIN FRAME ASSEMBLY  
(USH0818) (USH0803)**

ITEM	PART #	DESCRIPTION	USH0818 2" XS II QTY.	USH0803 3" XS II QTY.
1	UPH1278	SPACER BAR	-	3
1	UPH3682	SPACER BAR	3	-
2	UPH1258	MAIN ASSEMBLY FRAME	1	1
3	UF0902	FHCS #8-32 X 1/2	1	1
4	UF1250	FHCS HK 1/4-20 X 7/8"	2	2
5	UF0960	FHCS HK 1/4-20 X 3/4"	3	3
6	UF0905	FHCS HK 10-24 X 5/8"	4	4
7	UPH1279	PIVOT SHAFT	-	2
8	UPH1280	PIVOT SHAFT	-	1
9	UPH3683	PIVOT SHAFT	2	-
10	UPH3684	PIVOT SHAFT	1	-
11	UPH9006	SPRING, SPACER BAR HX - II	-	1
11	UPH9005	SPRING, SPACER BAR HX - II	1	-
12	UPH0794	STOP RETAINER HX	2	2
13	UPH0082	MAIN STOP SPACER	2	2
14	UPH133	STOP, URETHANE KNIFE ARM	3	3
15	UPH134	STOP, URETHANE KNIFE ARM	1	1
16	UPH3703	AUX. ARM'S SPRING RETAINER	1	1
17	UPH0563	SPRING RETAINER SLEEVE	1	1
18	UF5500	EXTERNAL RETAINING RING	1	1

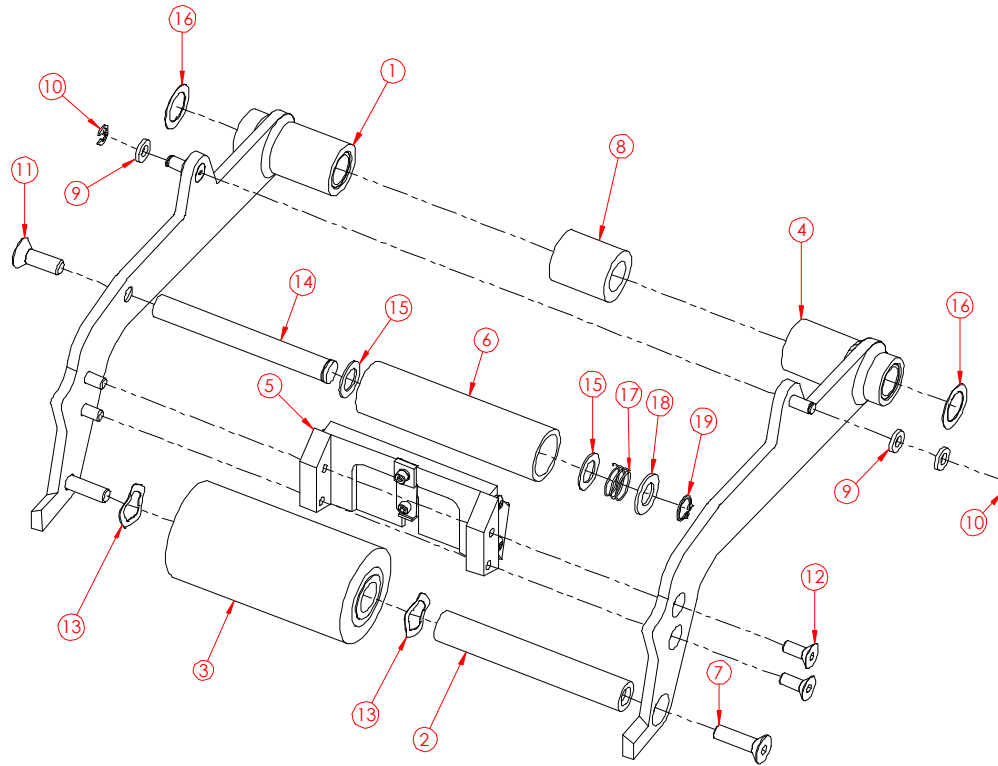
# COVER FRAME ASSEMBLY (USH0804)



**COVER FRAME ASSEMBLY  
(USH0804)**

ITEM	PART #	DESCRIPTION	QTY.
2	UPH0794	STOP RETAINER HX	2
3	UPH0082	MAIN STOP SPACER	2
5	UPH3703	AUX. ARM'S SPRING RETAINER	1
6	UPH0563	SPRING RETAINER SLEEVE	1
7	UF5500	EXTERNAL RETAINING RING	1
9	UF1250	FHCS HK 1/4-20 X 7/8"	2
10	UF0905	FHCS HK 10-24 X 5/8"	4
11	UF0902	FHCS #8-32 X 1/2	1
12	UF0960	FHCS HK 1/4-20 X 3/4"	5
13	UPH3818	SHOCK ABSORBER BRACKET	1
14	UPH3819	XS II SHOCK ABSORBER	1
16	UPH133	STOP, URETHANE KNIFE ARM	3
17	UPH134	STOP, URETHANE KNIFE ARM	1
18	UPH1257	COVER FRAME HX II	1

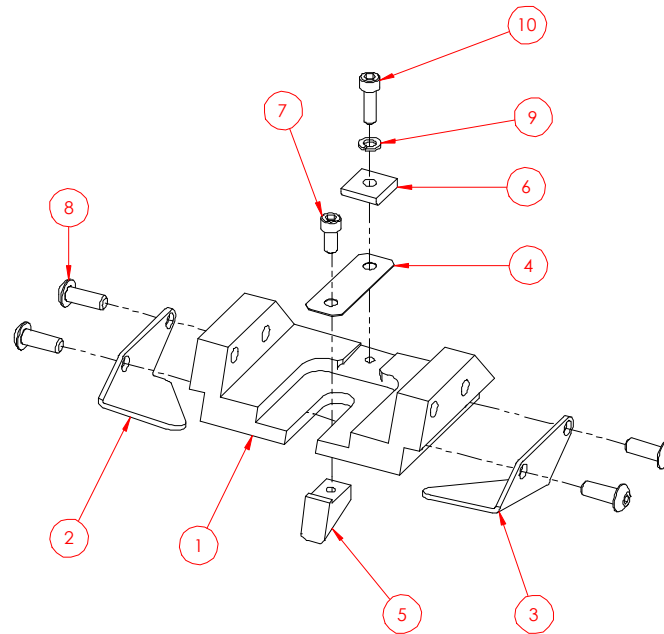
# FRONT ARM ASSEMBLY (USH0887) (USH0888)



**FRONT ARM ASSEMBLY  
(USH0887) (USH0888)**

ITEM	PART #	DESCRIPTION	USH0887 2" XS II QTY.	USH0888 3" XS II QTY.
1	UAH0060	FRONT ARM RIGHT WITH BEARINGS	1	1
2	UPH1281	FRONT ROLLER SHAFT	-	1
2	UPH3688	FRONT ROLLER SHAFT	1	-
3	UAH0044	URETHANE ROLLER ASS'Y 3"	-	1
3	UAH0045	URETHANE ROLLER ASS'Y 2"	1	-
4	UAH0061	FRONT ARM LEFT WITH BEARINGS	1	1
5	UAH0040	TAPE SHOE ASS'Y	-	1
5	UAH0041	TAPE SHOE ASS'Y	1	-
6	UAH0042	GUIDE ROLLER WITH BEARINGS	-	1
6	UAH0043	GUIDE ROLLER WITH BEARINGS	1	-
7	UF1250	FHCS HK 1/4-20 X 7/8"	2	2
8	UPH0032	SPACER	-	1
9	UF2300	PLASTIC WASHER	4	4
10	UF4005	RETAINING RING 3/16	2	2
11	UF0960	FHCS HK 1/4-20 X 3/4"	1	1
12	UF0907	FHCS 10-24 X 1/2	4	4
13	UPH0703	WAVE DISC SPRING	2	2
14	UPH0255	TAPE GUIDE ROLLER SHAFT	-	1
14	UPH0344	TAPE GUIDE ROLLER SHAFT	1	-
15	UF1930	NYLON F.W. .38 ID X .030	2	2
16	UF1960	NYLON F.W. .50 ID X .015	2	2
17	UPH0281	SPRING-TAPE GUIDE ROLLER T.H	1	1
18	UF1721	REG F.W. ZINC .390X.682X.05 BS	1	1
19	UF2160	RETAINING RING 3/8 DIA	1	1

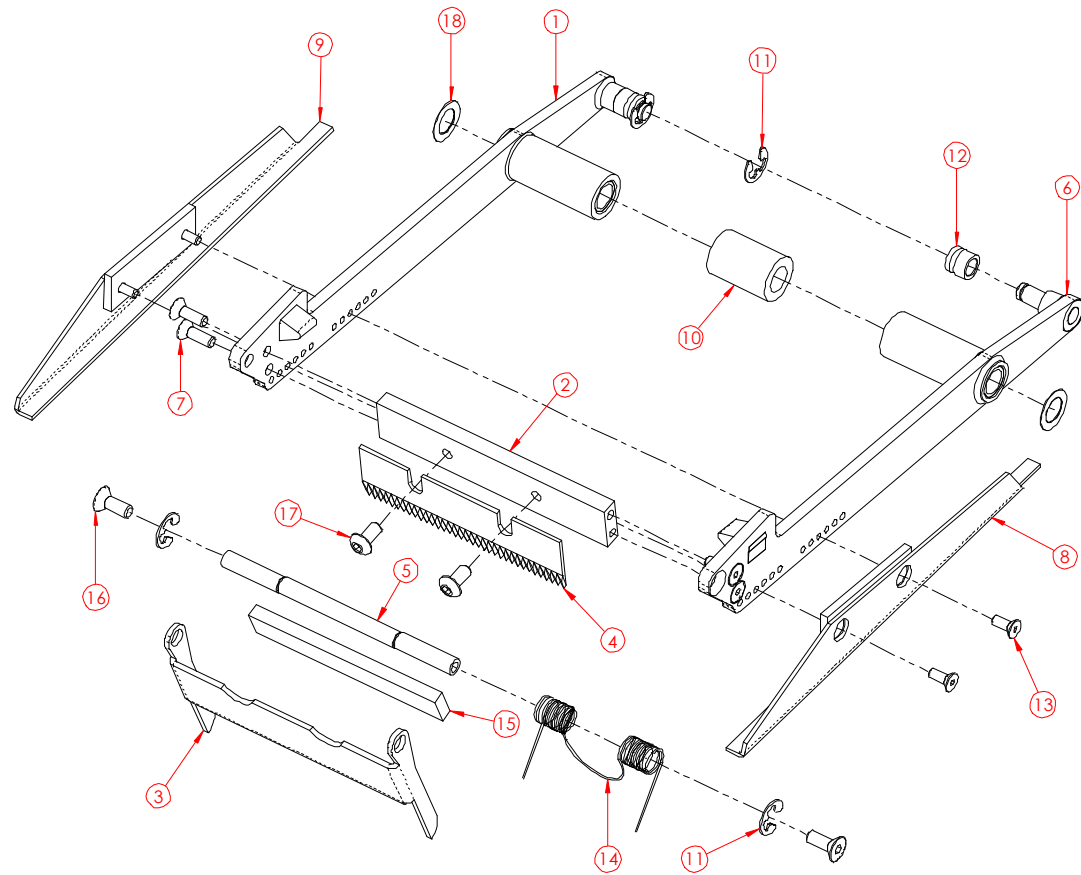
**TAPE SHOE ASSEMBLY  
(UAH0041) (UAH0040)**



**TAPE SHOE ASSEMBLY  
(UAH0041) (UAH0040)**

ITEM	PART #	DESCRIPTION	UAH0041 2" XS II QTY.	UAH0040 3" XS II QTY.
1	UPH3695	TAPE HEAD SHOE XS II 2"	1	-
1	UPH1275	TAPE HEAD SHOE XS II 3"	-	1
2	UPH3716	TAPE SHOE GUIDE RIGHT	1	-
2	UPH3692	TAPE SHOE GUIDE RIGHT	-	1
3	UPH3717	TAPE SHOE GUIDE LEFT	1	-
3	UPH3693	TAPE SHOE GUIDE LEFT	-	1
4	UPH0669	SPRING BLADE	1	1
5	UPH0667	FINGER	1	1
6	UPH0668	SQUARE WASHER HI	1	1
7	UF0460	SHCS 4-40 X 1/4"	1	1
8	UF1202	BHCS HK 6-32 X 3/8"	4	4
9	UF6349	L.W. ZINC # 4	1	1
10	UF0467	SHCS HK 4-40 x 3/8" LG	1	1

# KNIFE ARM ASSEMBLY (USH0890) (USH0889)

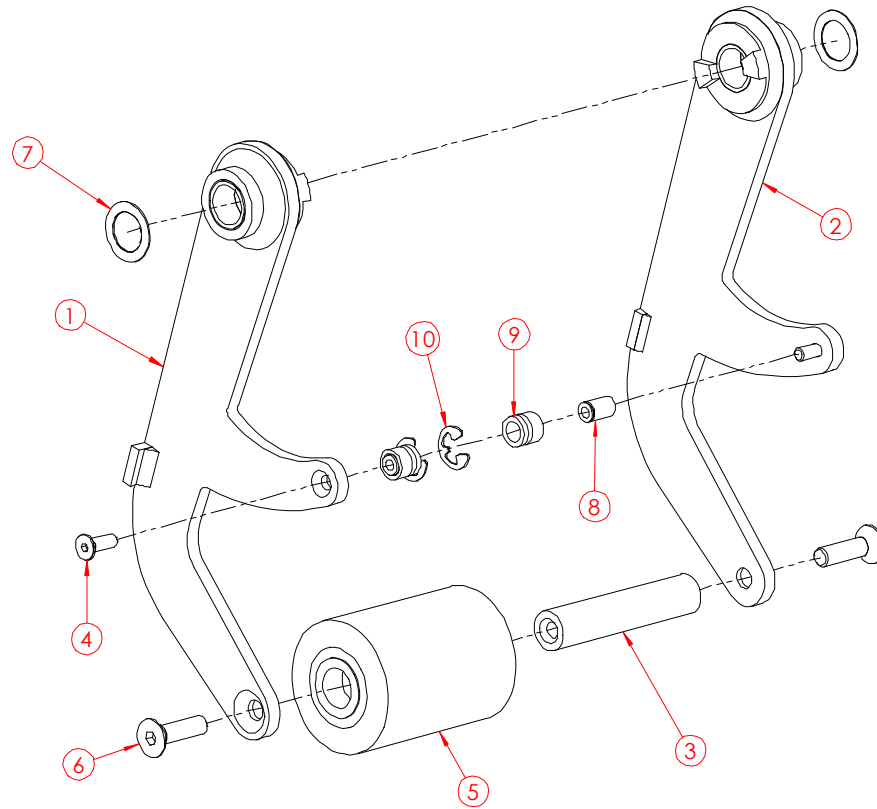




## KNIFE ARM ASSEMBLY (USH0890) (USH0889)

ITEM	PART #	DESCRIPTION	USH0890 2" XS II QTY.	USH0889 3" XS II QTY.
1	UAH0062	KNIFE ARM RIGHT WITH BEARINGS	1	1
2	UPH1273	KNIFE SUPPORTS	-	1
2	UPH3691	KNIFE SUPPORTS	1	-
3	UPH1272	KNIFE FLIP GUARD	-	1
3	UPH3689	KNIFE FLIP GUARD	1	-
4	UPH108	KNIFE BLADE	-	1
4	UPH107	KNIFE BLADE	1	-
5	UPH1271	KNIFE GUARD SHAFTS	-	1
5	UPH3690	KNIFE GUARD SHAFTS	1	-
6	UAH0063	KNIFE ARM LEFT WITH BEARINGS	1	1
7	UF0902	FHCS #8-32 X 1/2	4	4
8	UPH1268	KNIFE ARM EXTENSION LEFT	1	1
9	UPH1267	KNIFE ARM EXTENSION	1	1
10	UPH1277	SPACER	-	1
11	UF5500	EXTERNAL RETAINING RING	4	4
12	UPH0563	SPRING RETAINER SLEEVE	2	2
13	UF0875	FHCS HK 6-32 X 3/8"	4	4
14	UPH3729	HX II KNIFE GUARD SPRING	1	1
15	UPI0068	BLADE CLEANER	-	1
15	UPI0067	BLADE CLEANER	1	-
16	UF0921	FHCS 10-32 X 1/2" ZINC	2	2
17	UF1220	BHCS HK 10-32 X 3/8"	2	2
18	UF1950	NYLON F.W. .38 ID X .015	2	2

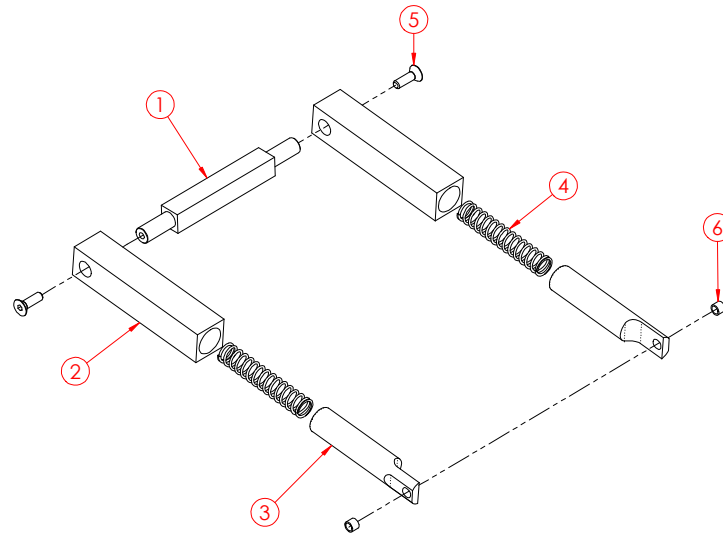
**REAR ARM ASSEMBLY  
(USH0815) (USH0807)**



**REAR ARM ASSEMBLY  
(USH0815) (USH0807)**

ITEM	PART #	DESCRIPTION	USH0815 2" XS II QTY.	USH0807 3" XS II QTY.
1	UAH0055	REAR ARM RIGHT SUB.	1	1
2	UAH0054	REAR ARM LEFT SUB.	1	1
3	UPH1281	FRONT ROLLER SHAFT	-	1
3	UPH3688	FRONT ROLLER SHAFT	1	-
4	UF0902	FHCS #8-32 X 1/2	2	2
5	UAH0044	URETHANE ROLLER ASS'Y 3"	-	1
5	UAH0045	URETHANE ROLLER ASS'Y 2"	1	-
6	UF1250	FHCS HK 1/4-20 X 7/8"	2	2
7	UF1960	NYLON F.W. .50 ID X .015	2	2
8	UPH3703	AUX. ARM'S SPRING RETAINER	2	2
9	UPH0563	SPRING RETAINER SLEEVE	2	2
10	UF5500	EXTERNAL RETAINING RING	2	2

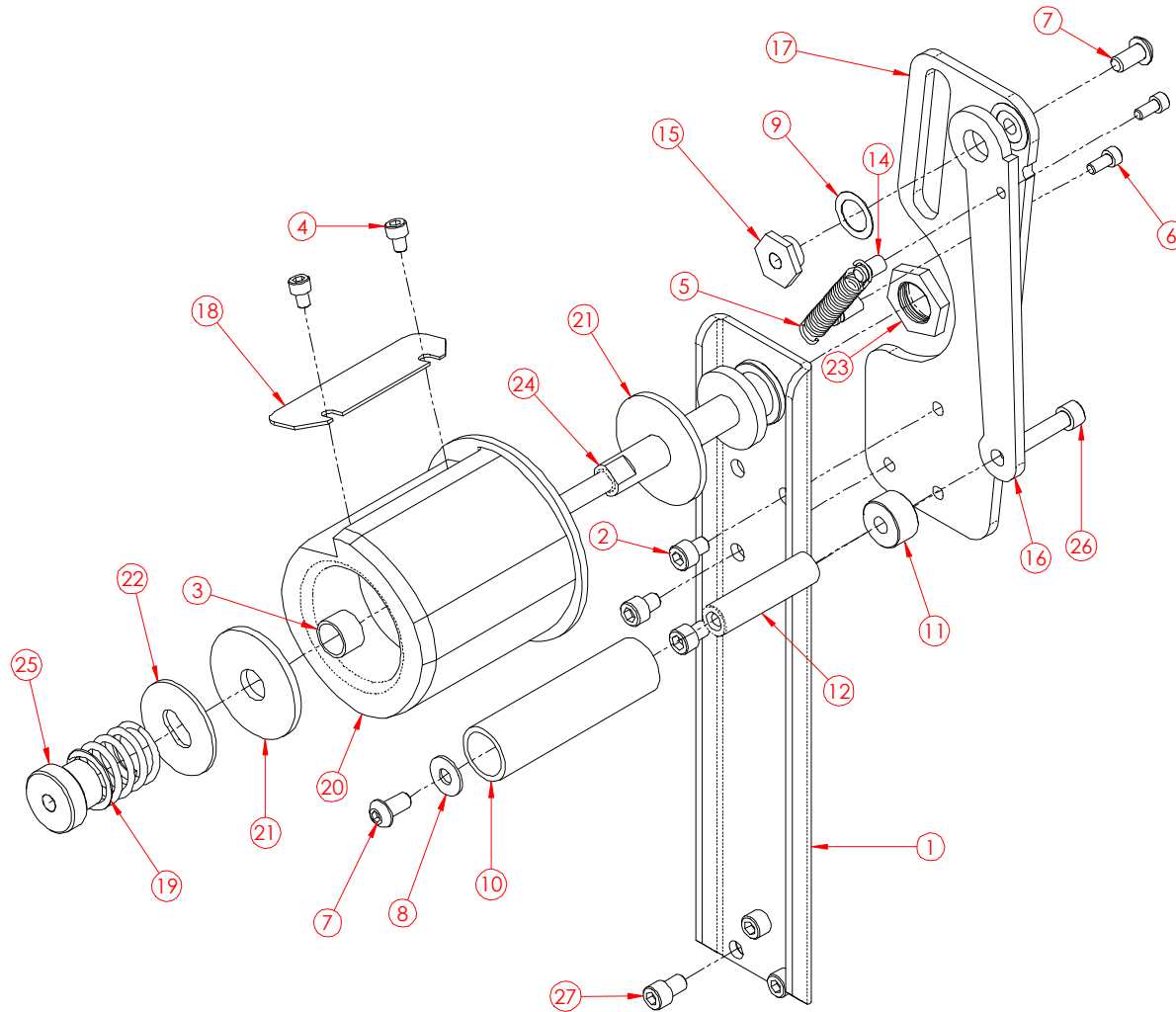
**PIVOT**  
**(USH0479) (USH0478)**



PIVOT  
 (USH0479) (USH0478)

ITEM	PART #	DESCRIPTION	USH0479 2" XS II QTY.	USH0478 3" XS II QTY.
1	UPH9008	PIVOT BAR - HX-II	-	1
1	UPH9007	PIVOT BAR - HX-II	1	-
2	UPH9009	COMPRESSION SPRING TUBING	2	2
3	UPH9011	COMPRESSION SPRING PIN	2	2
4	UPH9010	COMPRESSION SPRING 2.5"LG.	2	2
5	UF0905	FHCS HK 10-24 X 5/8"	2	2
6	UPH3675	BUSHING 3/16 ID	2	2

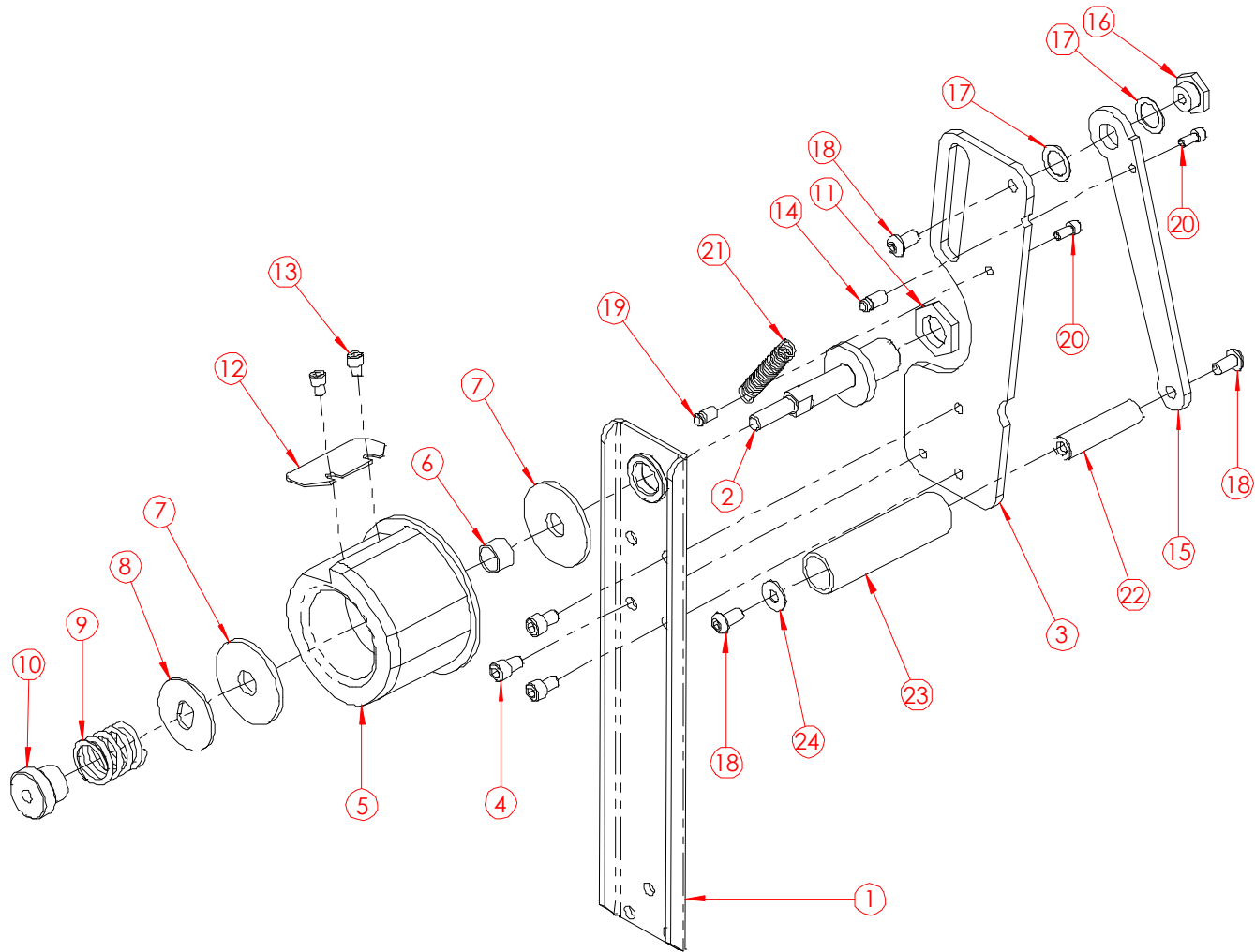
# MANDREL ASSEMBLY 3" (USH0317)



**MANDREL ASSEMBLY 3”  
(USH0317)**

ITEM	PART #	DESCRIPTION	QTY.
1	UPH0711	MANDREL ARM	1
2	UF0810	SHCS HK M6-1 X 8MM	3
3	UPH0089	BEARING GLYCODUR .50 x .38 LG	2
4	UF0550	SHCS HK T0-32 X 1/4"	2
5	UPH0693	KNIFE ARM SPRING	1
6	UF0490	SHCS HK #8-32 x 3/8	2
7	UF1240	BHCS HK 1/4-20 X 1/2"	2
8	UF1970	F.W. 1/4 X 5/8 X .046 B1526	1
9	UF1960	NYLON F.W. .515 x .759 x .015	2
10	UPH124	FIRST TAPE GUIDE ROLLER	1
11	UPH0242	CLUTCH SPACER, NC	1
12	UPH0075	GUIDE ROLLER SHAFT	1
13	UPH0399	MAIN ARM PLATE SPRING RETAINER	1
14	UPH0400	ARM PLATE SPRING RETAINER	1
15	UPH0650	PEEL OFF ROLLER SHAFT	1
16	UPH0146	PEEL OFF ARM PLATE	1
17	UPH0114	PEEL OFF MAIN ARM PLATE	1
18	UPH019	MANDREL CORE LOCK 3"/75MM	1
19	UPH022	MANDREL SPRING	1
20	UPH029	TAPE MANDREL	1
21	UF1920	FIBRE WASHER 1/2 x 1-3/4 x 1/8	2
22	UF1820	OVALE HOLE 3/8 x 0.89 x .75	1
23	UPH0016	MANDREL LOCK NUT	1
24	UPH0008	MANDREL SHAFT	1
25	UPH023	MANDREL ADJUSTMENT NUT	1
26	UF0640	SHCSHK 1/4-20 X 1-1/4"	1
27	UF1280	SHCS 1/4-28 X 3/8	3

# MANDREL ASSEMBLY 2" (USH0308)





## MANDREL ASSEMBLY 2" (USH0308)

ITEM	PART #	DESCRIPTION	QTY.
1	UPH0711	MANDREL ARM	1
2	UPH0007	MANDREL SHAFT	1
3	UPH0114	PEEL OFF MAIN ARM PLATE	1
4	UF0649	SHCS HK 1/4-28 X 3/8"	3
5	UPH028	TAPE MANDREL	1
6	UPH0089	BEARING GLYCODUR .50 x .38 LG	2
7	UF1920	FIBRE WASHER 1/2 x 1-3/4 x 1/8	2
8	UF1820	OVALE HOLE 3/8 x 0.89 x .75	1
9	UPH022	MANDREL SPRING	1
10	UPH023	MANDREL ADJUSTMENT NUT	1
11	UPH0016	MANDREL LOCK NUT, NC	1
12	UPH018	MANDREL CORE LOCK 2"/48MM	1
13	UF0550	SHCS HK 10-32 X 1/4"	2
14	UPH0399	MAIN ARM PLATE SPRING RETAINER	1
15	UPH0146	PEEL OFF ARM PLATE	1
16	UPH0650	PEEL OFF ROLLER SHAFT	1
17	UF1960	NYLON F.W. .515 x .759 x .015	2
18	UF1240	BHCS HK 1/4-20 X 1/2"	3
19	UPH0400	ARM PLATE SPRING RETAINER	1
20	UF0490	SHCS HK #8-32 x 3/8	2
21	UPH0297	KNIFE ARM SPRING	1
22	UPH0075	GUIDE ROLLER SHAFT	1
23	UPH124	FIRST TAPE GUIDE ROLLER	1
24	UF1720	FW 1/4 x 5/8 x 0.046	1