



Grand Rapids, Michigan, U.S.A. 49504-5298

USER'S OPERATING AND INSTRUCTION MANUAL

MODEL 1508-NLG

SELF-ACTUATING TRAY LIDDER



1508-NLG SELF-ACTUATING LIDDER

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1508-NLG SELF-ACTUATING LIDDER

SAFETY

Various safety devices and methods of guarding have been provided on this machine. It is essential, however, that machine operators and maintenance personnel observe the following safety precautions. Improper installation or operation of this equipment may cause injury to personnel or damage to equipment.

- Before operating the *Self-Actuating Lidder* read through this manual. Never allow an untrained person to operate this machine.

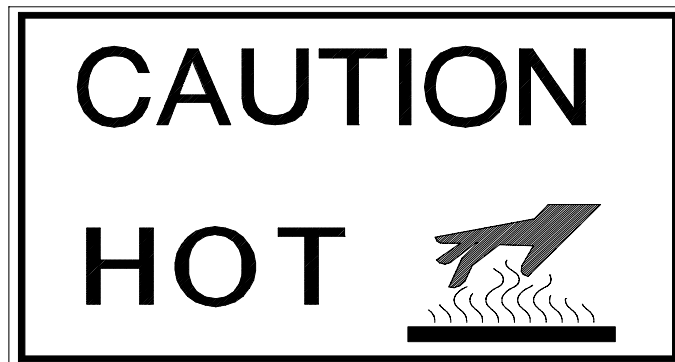
WARNING

- **WARNING PINCH POINT: Keep hands out of machine.** Always be sure the machine has been unplugged from power and air before cleaning or servicing.



CAUTION

- **CAUTION HOT:** The heater cover and upper platen are very **HOT!** Caution must be used to protect yourself and others.



- In addition to these general safety instructions, follow the specific instructions given through out this manual.

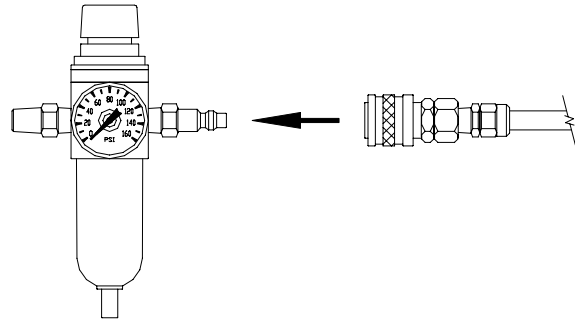


1508-NLG SELF-ACTUATING LIDDER

SET UP

1. Unpack and carefully remove the *Self-Actuating Lidder*. Check for completeness of your order and that none of the items have been damaged during shipment.
2. Screw the four rubber feet in to place on the bottom of the machine.
3. Place the *Self-Actuating Lidder* in a suitable location that provides adequate working space. The location must be sturdy, level, and capable of holding 50 lbs. per machine.

4. Use the quick detachable coupler to connect air pressure to the filter/regulator. The *Self-Actuating Lidder* requires a minimum of 0.1 CFM at 90 PSI.



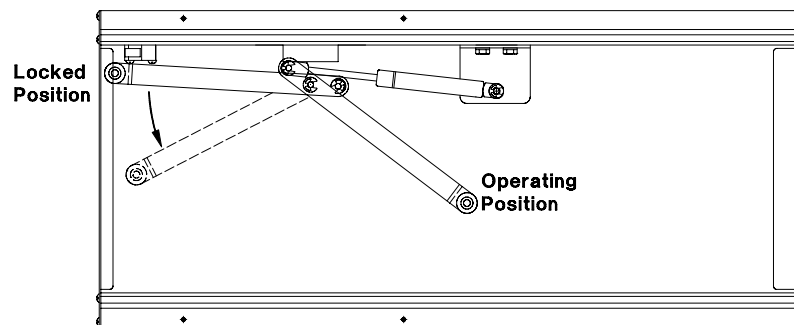
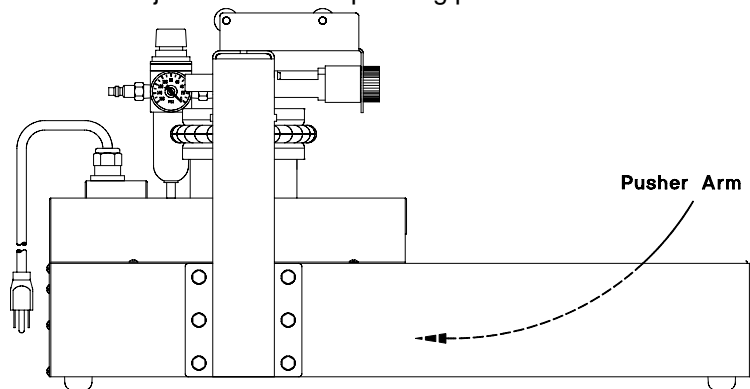
NOTE

- DO NOT USE AN OILER OR LUBRICATOR WITH THIS MACHINE.

NOTE

- DO NOT CONNECT TO AIR PRESSURE ABOVE 140 PSI.

5. Pull the ejector bar to its operating position as shown.

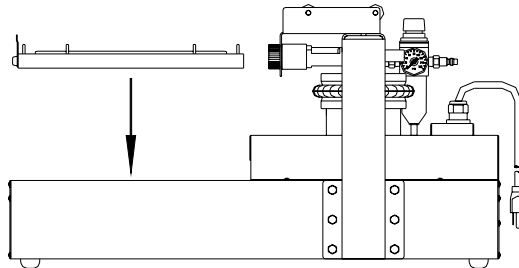




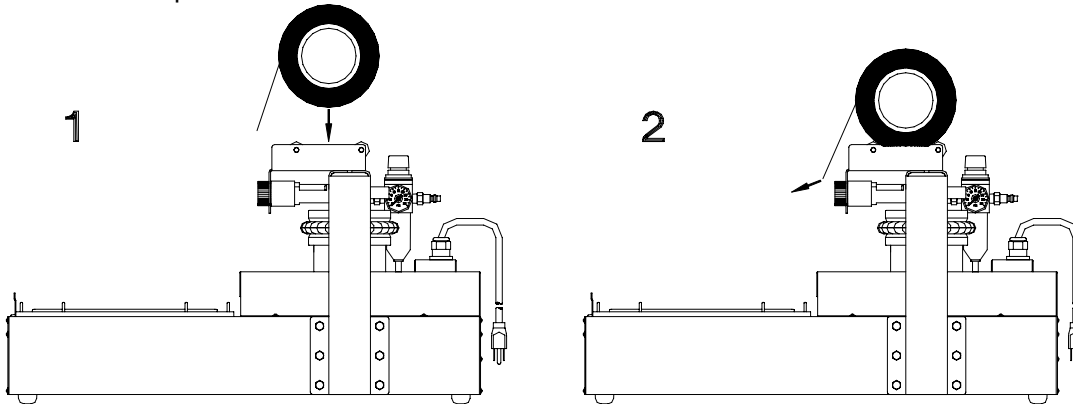
1508-NLG SELF-ACTUATING LIDDER

6. SET UP (continued)

6. Plug the power cord into a grounded electrical outlet. The *Self-Actuating Lidder* requires single phase 110 VAC, 60 Hertz with 10 ampere (minimum) circuit breaker protection.
7. Install the tray carrier:



8. Load lid dispenser:





1508-NLG SELF-ACTUATING LIDDER

OPERATING PROCEDURE

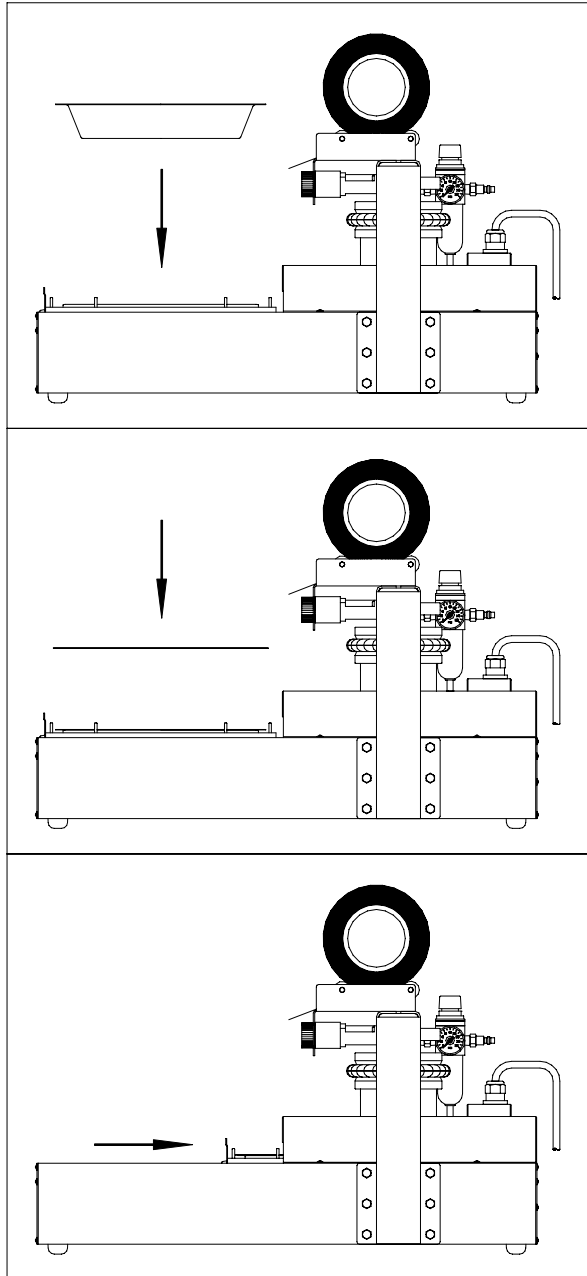
1. To turn the machine on plug in the power cord. **Wait 40 minutes** to allow the heated upper platen to reach temperature.
2. Place a tray in the tray carrier.
3. Position a single lid on the tray. Use the retractable pins on the tray carrier to center the lids over the tray. **Be sure the adhesive side of the lid is down.**

NOTE

- The adhesive side of the lid can be determined by pinching a fold and rubbing the lid material against itself. Test both sides of the lid. The rough or tacky side of the lid will be the adhesive side.
4. Push the tray carrier into the *Self-Actuating Lidder* until it stops. This will cycle the heated upper platen down, applying pressure on the film and tray flanges. As the heated upper platen lifts back to the open position, the tray carrier will automatically reopen.

NOTE

- Actuating machine with no tray or lid in place may cause the tray carrier to stick closed.
5. To remove the lidded tray push up on the bottom of the tray with your hand and lift from tray carrier.





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ADJUSTMENTS

Your *Self-Actuating Lidder* was tested at the factory, using the same trays and film as you will use. Regulated pressure, temperature, and dwell time were adjusted during this test to provide a good seal. Our test results indicate the following:

| | | |
|--------------------|-------|---------|
| Regulated Pressure | _____ | PSI |
| Temperature | _____ | °F |
| Dwell Time | _____ | Seconds |

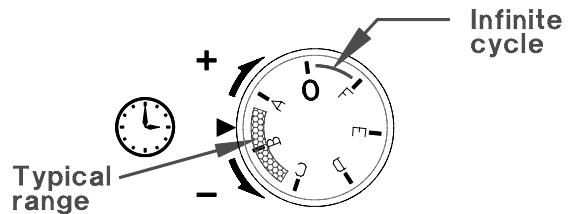
When checking for a good seal look for seal completeness and reasonable seal strength. A poor seal will occur if the product in the tray contaminates the tray flanges. Moisture will have the same negative affect. Trays that have irregular flanges or are deformed also seal poorly. Defective trays should be discarded.

Under different operating conditions, you may find it necessary to adjust one or all of the sealing parameters. When making adjustments; change only one parameter at a time, make small incremental adjustments, and record the change made. This is one situation where **"MORE IS NOT BETTER"**! In other words, more heat plus more pressure plus longer dwell time does not necessarily equal better seals.

REGULATED PRESSURE: To adjust the regulated pressure simply pull up the knob on the top of the filter/regulator and rotate until the gauge shows the desired pressure (40 PSI min.). Push the knob back down to lock.

DWELL TIME:

The dwell time adjustment knob is on the front of the machine. The dwell time can be adjusted from .1 seconds to 30 seconds. Rotate the knob between the "0" and "F" knob markings until the desired dwell time is found. The greater the angle (clockwise direction), the greater the dwell time setting.



NOTE

- **AVOID MAKING CHANGES TO THE TEMPERATURE SETTING.**

TEMPERATURE: The temperature of the heated upper platen can be adjusted through an access hole on the top of the electrical cover. Use a slotted blade screwdriver to remove the plug and make the adjustment.

Once the right combination of the three parameters is found, no further adjustments should be necessary - so long as you do not change the film or tray material.



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TECHNICAL SPECIFICATIONS

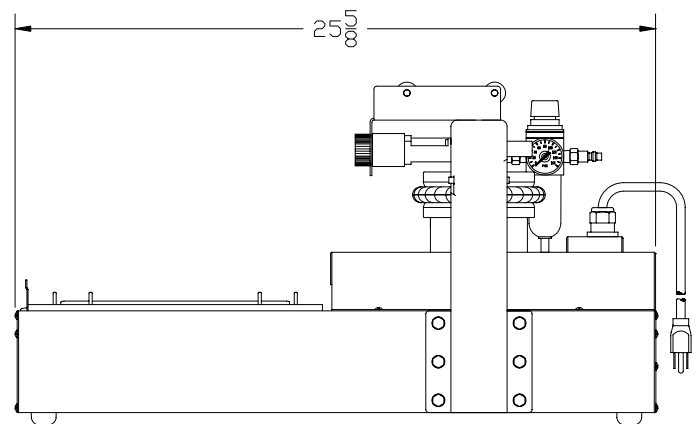
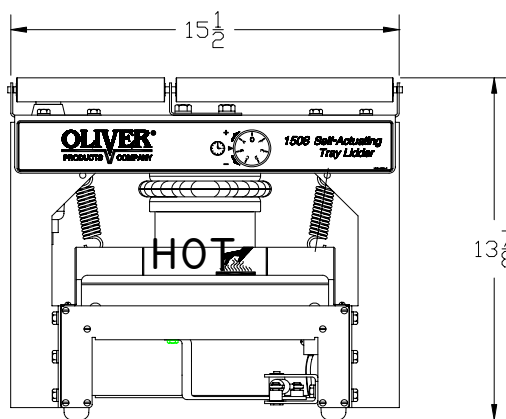
Tray Capacities:

8" (203mm) by 9.75" (248mm) maximum top-outside-dimension tray.

Temperature Range:

50°F (10°C) to 300°F (149°C)

Machine Dimensions:



Weight:

55 lbs. (22.7 kg)

Electrical:

115 VAC, 8 Amps, Single Phase, 50/60 Hz **OR**
230 VAC, 4 Amps, Single Phase, 50/60 Hz



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CLEANING

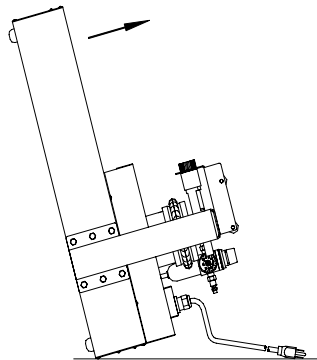
- If the machine has been operating, allow the unit to cool before cleaning.

CAUTION

- **CAUTION HOT:** The heater cover and upper platen are very **HOT!** Caution must be used to protect yourself and others.

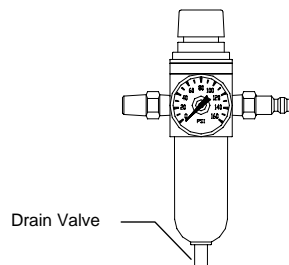
WARNING

- **WARNING PINCH POINT: Keep hands out of machine.** Always be sure the machine has been unplugged from power and air before cleaning or servicing.
- Make sure the unit has been unplugged from power and air before cleaning.
- Clean the *Self-Actuating Lidder* with a mild cleaner and a damp cloth.
- To clean or access the heated upper platen: remove the the tray carrier and lidding material, tip machine back, and rotate tray carrier return arm back to locked position (see setup).



CAUTION

- **MAKE SURE UNIT IS SECURE AND WILL NOT TIP OVER**
- Use a copper scouring pad to clean heated upper platen. Allow platen to cool before attempt to clean.
- Accumulated sludge and moisture should be drained from the filter/regulator. Sediment should not be permitted to fill above the filter element.





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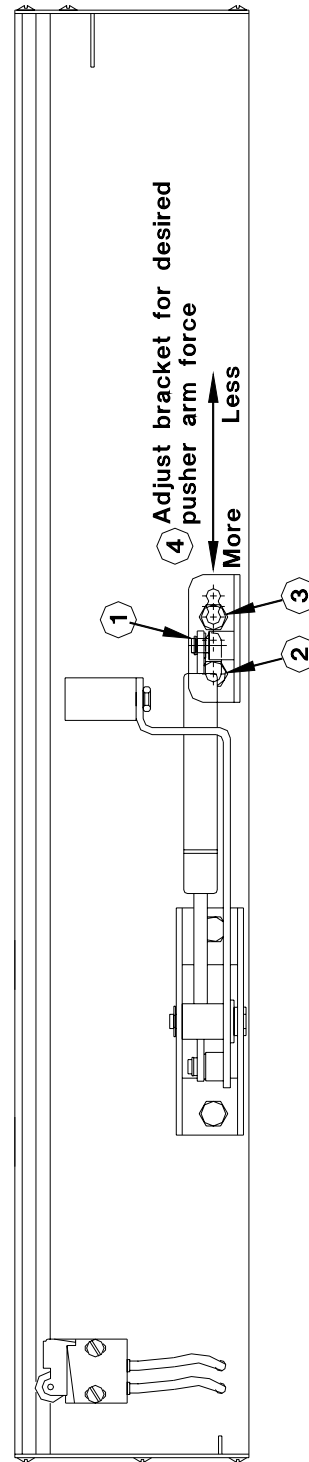
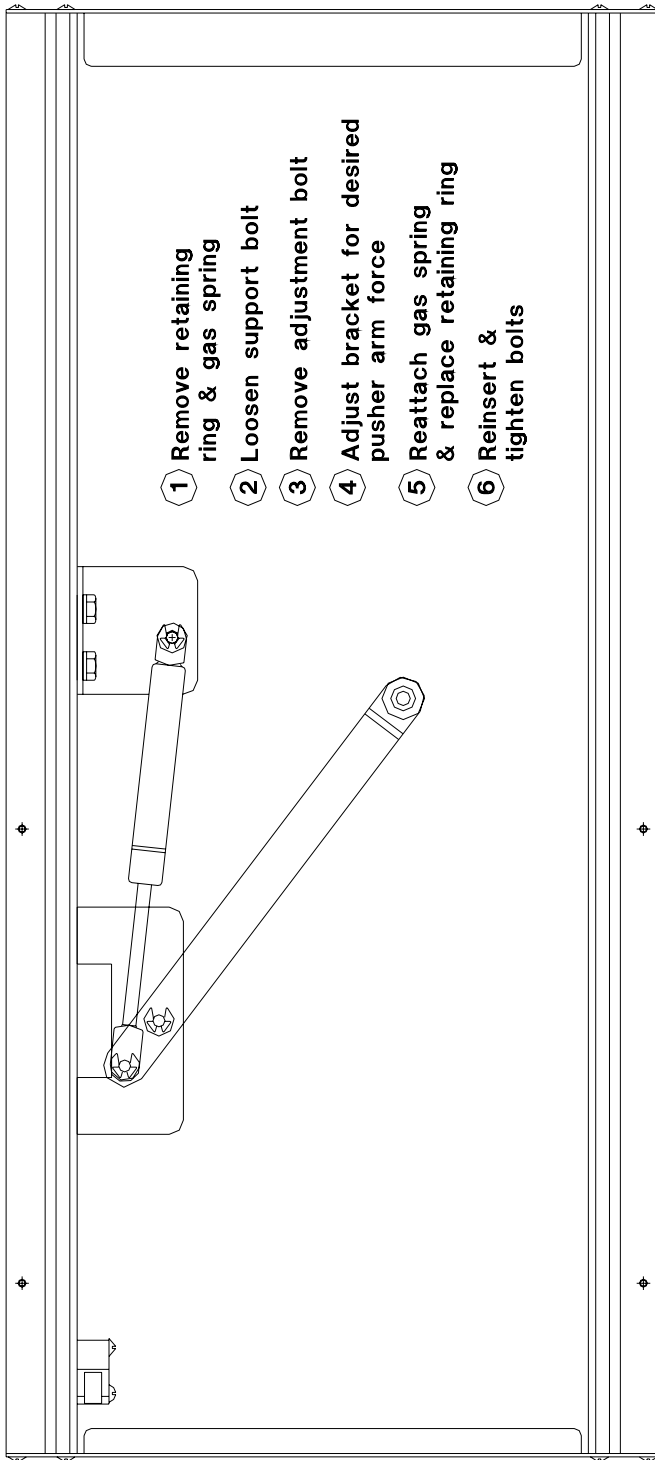
TROUBLE SHOOTING

| SYMPTOM | CORRECTIVE ACTION |
|---|--|
| Heater will not power up | 1. Verify that the power cord is plugged in 2. Press Reset on the circuit breaker |
| Heated upper platen won't cycle | 1. Verify that the air line is plugged in 2. Verify that the air compressor is on 3. Verify air pressure at the filter/regulator |
| Lid folding, shifting or sliding off machine | 1. Verify that the adhesive side of the lid is down 2. Verify that the trays are not over fillet 3. Clean the heated upper platen |
| Poor seal quality ↻ Allow seal to cool before checking quality | 1. Verify the pressure setting (adjustments) 2. Verify the dwell time setting (adjustments) 3. Verify the temperature setting (adjustments) 4. Clean the upper platen (cleaning) |
| Upper platen will not release the tray carrier | 1. Verify the dwell time setting (adjustments) |
| Tray does not eject properly | 1. Take pusher arm out of Locked position (setup) 2. Wipe clean both the white nylon wear strips, and the matching wear surface on the tray carrier with a light mineral oil or vegetable oil 3. Make adjustment to gas spring bracket (see 1508S200012-2) |

Oliver Products Company 24 hr emergency service (800) 554-5603



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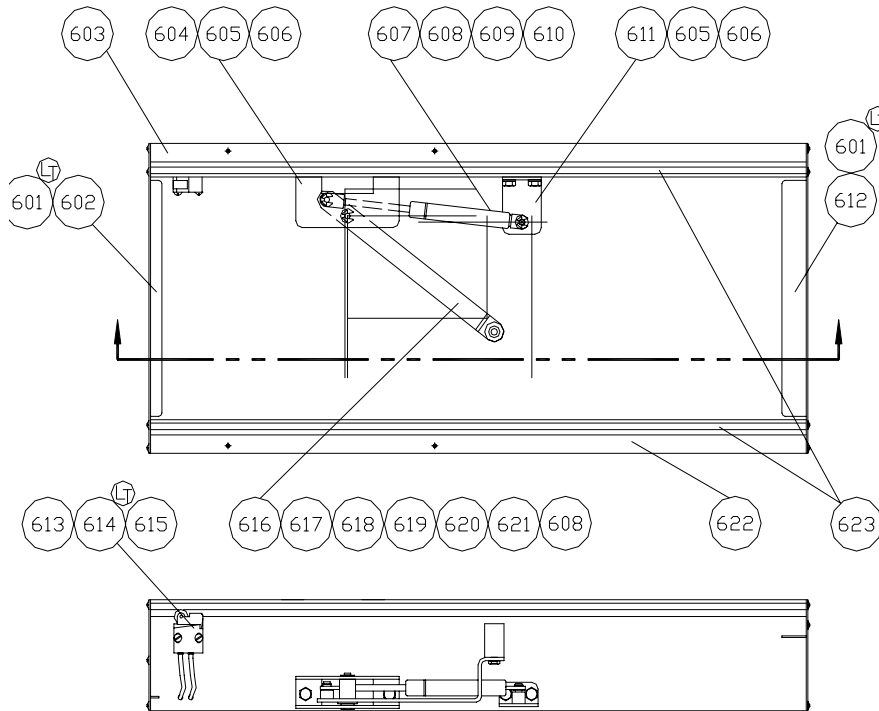


1508-NLG SELF-ACTUATING LIDDER

BASE ASSEMBLY

| ITEM | PART NUMBER | DESCRIPTION | QUAN. | DWG |
|------|----------------|-----------------------|-------|-----|
| 601 | 5843-5210 | SCREW-RND HD 6-32x1/4 | 20 | PUR |
| 602 | 1508-0006-1 | COVER - REAR | 1 | C |
| 603 | 1508-0001-1001 | BASE - RIGHT HAND | 1 | D |
| 604 | 1508-0011-1 | PIVOT BRACKET PUSHER | 1 | C |
| 605 | 5843-1002 | SCREW-HEX 1/4-20x5/8 | 4 | PUR |
| 606 | 5851-9357 | WASHER-LOCK 1/4" | 4 | PUR |
| 607 | 6084-8706 | SPRING GAS 15# CYL. | 1 | C |
| 608 | 5840-1273 | RING-RETAINING TRUARC | 3 | PUR |
| 609 | 1508-0007-1023 | BUSHING HOUSING | 1 | C |
| 610 | 5257-0205 | BRNG-FLG NYLNR THDM | 2 | PUR |
| 611 | 1508-0008-1 | BRACKET-GAS SPRING | 1 | C |
| 612 | 1508-0005-1 | COVER - FRONT | 1 | C |
| 613 | 5148-5339 | VALVE-AIR ROLLER | 1 | B |
| 614 | 5843-5227 | SCREW-RND HD #8-32 | 2 | PUR |
| 615 | 6528-5505 | TUBING-NYLON | 46' | PUR |
| 616 | 1508-0007-1 | PUSHER ARM | 1 | C |
| 617 | 1508-0028 | PIN-HEX HINGE | 1 | C |
| 618 | 1508-0010 | ROLLER - PUSHER | 1 | C |
| 619 | 5831-9113 | NUT-FLX LK FLHT 10-24 | 1 | C |
| 620 | 5257-0574 | BRNG-FLG NYLON BUNT | 2 | PUR |
| 621 | 5842-8989 | SCREW-SHOULDER 1/4x1" | 1 | PUR |
| 622 | 1508-0001-1002 | BASE - LEFT HAND | 1 | D |
| 623 | 1508-0024-1 | RDD SLD. 25-3/8" LONG | 4 | C |

Ⓛ - REQUIRE LOCKTITE (THREADLOCKER 242)

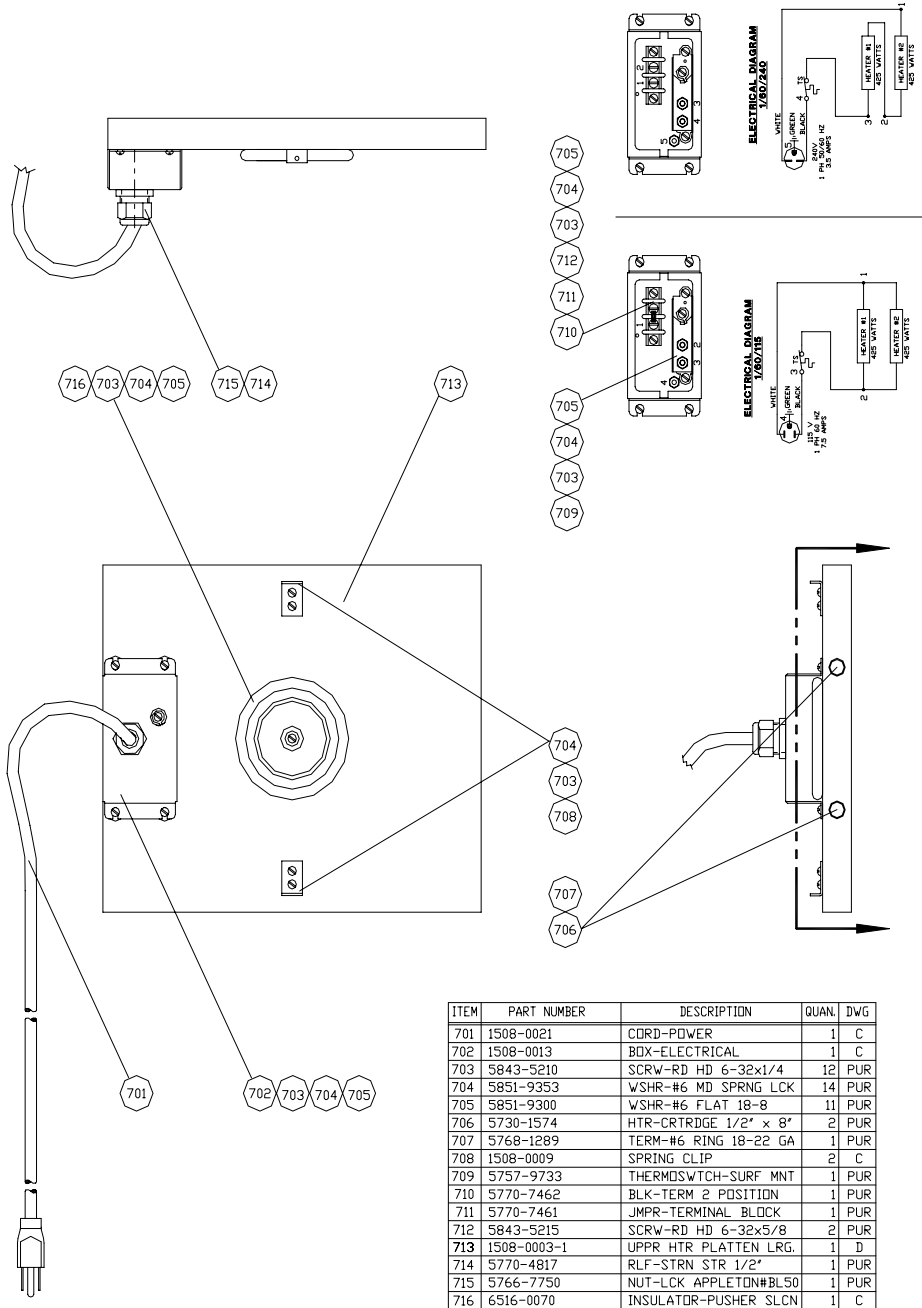


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HEATER PLATEN ASSEMBLY

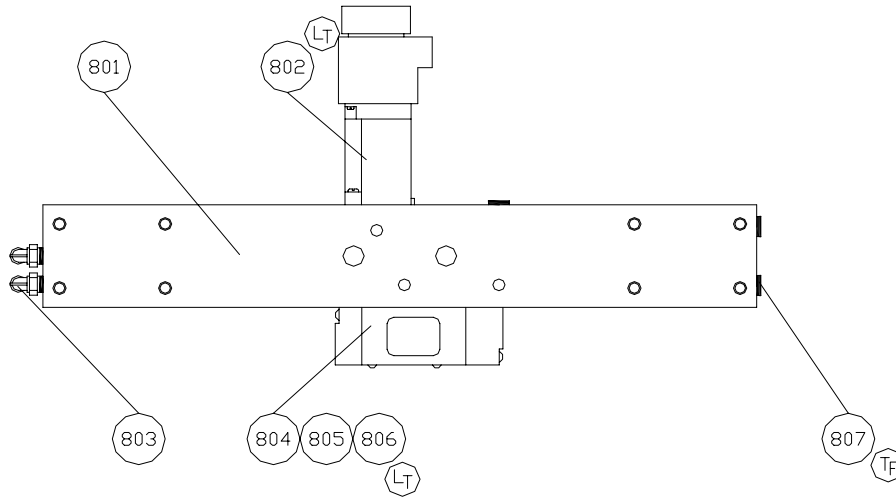


Rev. 12/17/97



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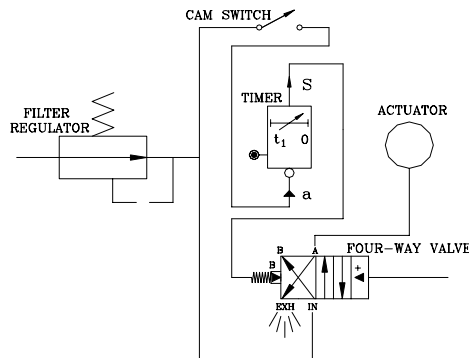
MANIFOLD ASSEMBLY



| ITEM | PART NUMBER | DESCRIPTION | QUAN. | DWG |
|------|-------------|-----------------------|-------|-----|
| 801 | 5130-0023 | MNFLD-MAIN PNEUMATIC | 1 | PUR |
| 802 | 5148-6510 | TIMER- PNEUMATIC | 1 | PUR |
| 803 | 5115-1775 | FTNG-ELB 90 SVL | 2 | PUR |
| 804 | 5148-5531 | VALVE-4WAY PNL MNTE.D | 1 | PUR |
| 805 | 6909-3006 | □-RING #568-006 | 1 | PUR |
| 806 | 5843-5196 | SCREW-RND HEAD | 2 | PUR |
| 807 | 5115-1427 | PLUG-PIPE BR CSNK 1/8 | 5 | PUR |
| xxx | 5130-7005 | MUFFLER-EXHAUST1/8NPT | 2 | PUR |

Ⓛₜ - REQUIRE LOCKTITE (REMOVABLE THREADLOCKER 242)

Ⓣₑ - REQUIRE TEFLON TAPE PNEUMATICS DIAGRAM

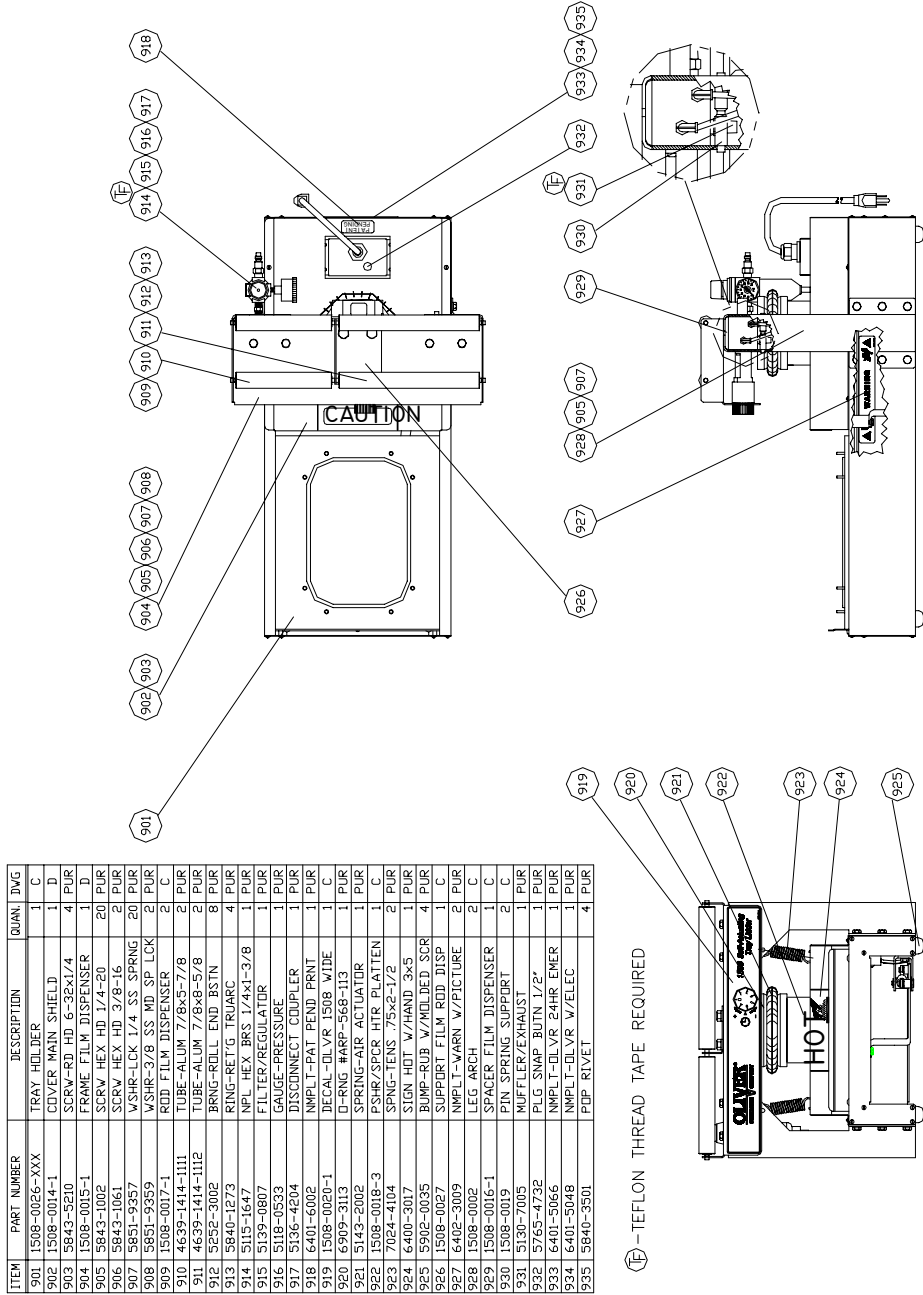


Rev. 01/15/09



1508-NLG SELF-ACTUATING LIDDER

FINAL ASSEMBLY



| ITEM | PART NUMBER | DESCRIPTION | QUAN. | IMG. |
|------|----------------|-------------------------|-------|------|
| 900 | 1508-0026-XXX | TRAY HOLDER | 1 | C |
| 902 | 1508-0014-1 | COVER MAIN SHIELD | 1 | D |
| 903 | 5843-3520 | SCRW-RD HD 6-32X1/4 | 4 | PUK |
| 904 | 1508-0015-1 | FRAME FILM DISPENSER | 1 | D |
| 905 | 5843-1002 | SCRW HEX HD 1/4-20 | 20 | PUK |
| 906 | 5843-1061 | SCRW HEX HD 3/8-16 | 2 | PUK |
| 907 | 5851-9357 | W-SHR-LOCK 1/4 SS SPRNG | 20 | PUK |
| 908 | 5851-9359 | W-SHR-3/8 SS MD SP LCK | 2 | PUK |
| 909 | 1508-0017-1 | ROD FILM DISPENSER | 2 | C |
| 910 | 4639-1414-1111 | TUBE-ALUM 7/8X3-7/8 | 2 | PUK |
| 911 | 4639-1414-1112 | TUBE-ALUM 7/8X8-5/8 | 2 | PUK |
| 912 | 5252-3002 | BRNG-ROLL END B5TN | 8 | PUK |
| 913 | 5840-1273 | RING-RET'G TRIARC | 4 | PUK |
| 914 | 5115-1647 | NPL HEX BRS 1/4X1-3/8 | 1 | PUK |
| 915 | 5139-0807 | FILTER-REGULATOR | 1 | PUK |
| 916 | 5118-0533 | GAUGE-PRESSURE | 1 | PUK |
| 917 | 5136-4204 | DISCONNECT COUPLER | 1 | PUK |
| 918 | 6401-6002 | NMPL-PAT PEND PRINT | 1 | PUK |
| 919 | 1508-0020-1 | DECAL-OLVR 1508 WIDE | 1 | C |
| 920 | 6909-3113 | O-RING #ARP-568-113 | 1 | PUK |
| 921 | 5143-2002 | SPRING-AIR ACTUATOR | 1 | PUK |
| 922 | 1508-0018-3 | PSHR/SPCR HTR PLATTEN | 1 | C |
| 923 | 7024-4104 | SPNG-TENS .75X2-1/2 | 2 | PUK |
| 924 | 6400-3017 | SIGN HOT W/HAND 3x5 | 1 | PUK |
| 925 | 5902-0035 | BUMP-RUB W/MELDED SCR | 4 | PUK |
| 926 | 1508-0027 | SUPPORT FILM ROD DISP | 1 | C |
| 927 | 6402-3009 | NMPL-WARN W/PICTURE | 2 | PUK |
| 928 | 1508-0002 | LEG ARCH | 2 | C |
| 929 | 1508-0016-1 | SPACER FILM DISPENSER | 1 | C |
| 930 | 1508-0019 | PIN SPRING SUPPORT | 2 | C |
| 931 | 5130-7005 | MUFFLER/EXHAUST | 1 | PUK |
| 932 | 5765-4732 | PLG SNAP BUTN 1/2" | 1 | PUK |
| 933 | 6401-5066 | NMPL-OLVR 24HR EMER | 1 | PUK |
| 934 | 6401-5048 | NMPL-OLVR W/ELEC | 1 | PUK |
| 935 | 5840-3501 | PIP-RIVET | 4 | PUK |

Ⓣ - TEFLON THREAD TAPE REQUIRED

REV 2/24/09