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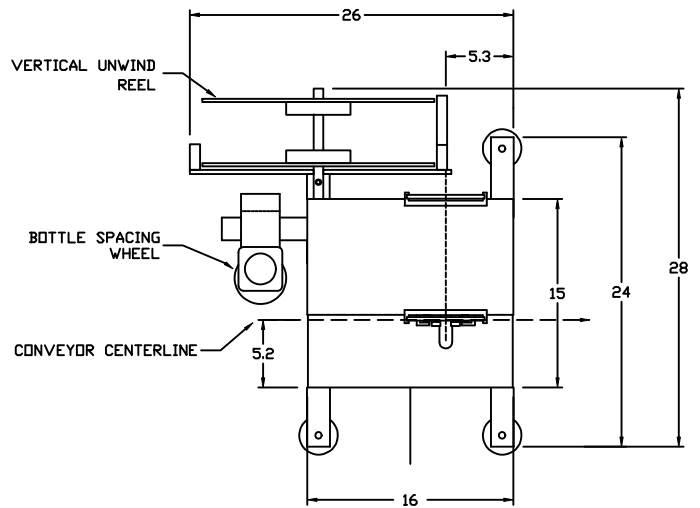
<u>Doc. No.</u>	<u>Title</u>	<u>No. of Pages</u>
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NB1-AD1178-PM	Preventative Maintenance	1
NB1-0012	Setup Reference Drawings (Last page is blank Setup Record for copying)	14

Addendums or additional technical data

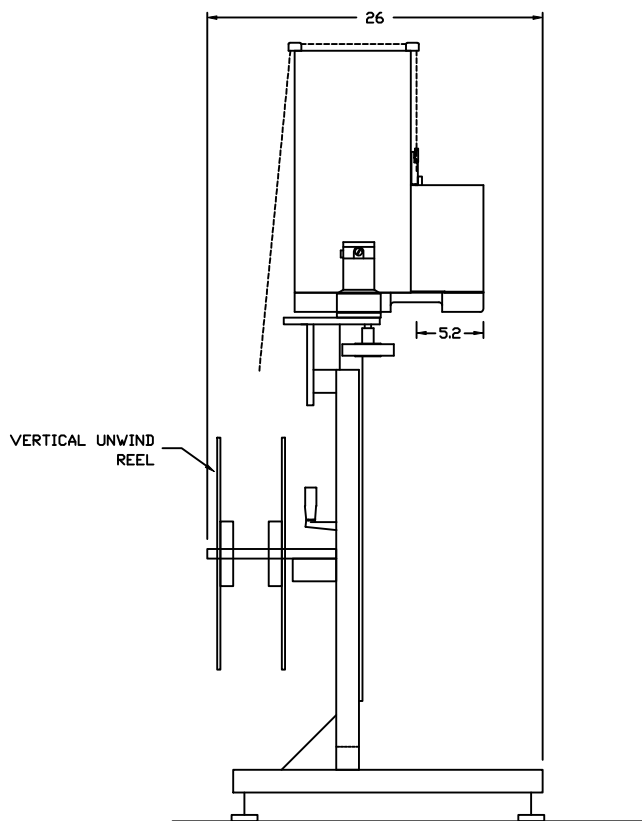
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PHARMAFILL MODEL NB1 (Series II) NECK BANDER

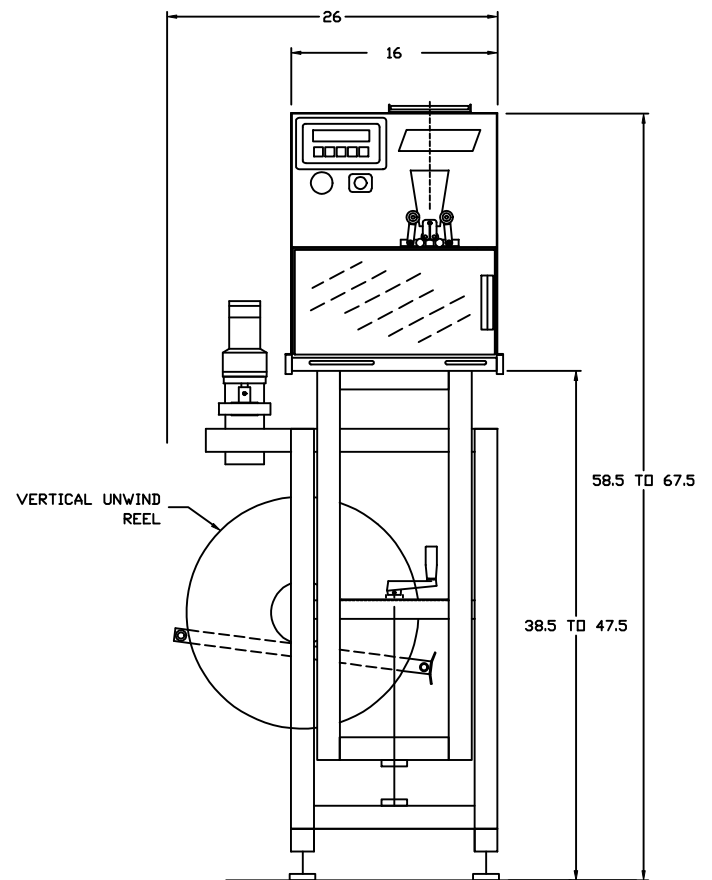
- SPEEDS UP TO 100 PER MINUTE
- SIZE RANGE 25-123mm LAY FLAT
- BAND LENGTHS UP TO 4"
- SPACING WHEEL INCLUDED
- UNWIND REEL INCLUDED
- AIR FILTER REGULATOR INCLUDED
- CHANGE PARTS INCLUDED (1 SET)
- 110 VAC 60 HZ 3A, 0.5 CFM AIR
- 90 LBS NET WEIGHT



OVERHEAD



LEFT SIDE



FRONT

DIMENSIONS ARE IN INCHES. SPECIFICATIONS ARE PRELIMINARY AS 9/16/2013 AND MAY BE SUBJECT TO CHANGE AT ANY TIME.



JOHN DEITZ
President

Deitz Company Inc.
1750 Route 34 PO Box 1108
Wall, NJ USA 07719

Tel 732-681-0200
Fax 732-681-8468
Email sjd2@deitzco.com

AD1178 Model NB1 Neck Bander – Preventative Maintenance

Monthly

1. Knife Assembly (must be disconnected from air pressure)
 - a. Inspect condition of suction cup. Replace if worn.
 - b. Check spring action of suction cup ass'y, by opening and closing blade assembly by hand. Suction cup ass'y should spring up against knife blade when knife is open. Replace spring if faulty.
 - c. Inspect condition of blades for wear or nicks. Rotate, replace or sharpen as needed.
 - d. Inspect condition of knife air cylinder, by opening and closing blade assembly by hand. It should move smoothly. If jumpy or difficult to move, replace or rebuild air cylinder.
2. Plunger Assembly (must be disconnected from air pressure)
 - a. Inspect condition of plunger air cylinder, by extending and retracting by hand. It should move smoothly. If jumpy or difficult to move, replace or rebuild air cylinder.
3. Roller Drive (internal, remove rear cover)
 - a. Inspect condition of drive gearbelt. If loose, tighten. If worn, replace.
 - b. Inspect roller spur gears for presence on lubricant. Apply standard lithium grease if needed.
4. Spacer Wheel Assembly
 - a. Inspect condition of urethane crush wheel. If worn, replace.
5. Miscellaneous
 - a. Inspect air filter/regulator clear bowl. If moisture is present, drain. Find cause of moisture within compressor system.
 - b. Check all external hardware for tightness.
 - c. Check condition of all external electrical wires and sensor cables for wear or damage. Replace if necessary.

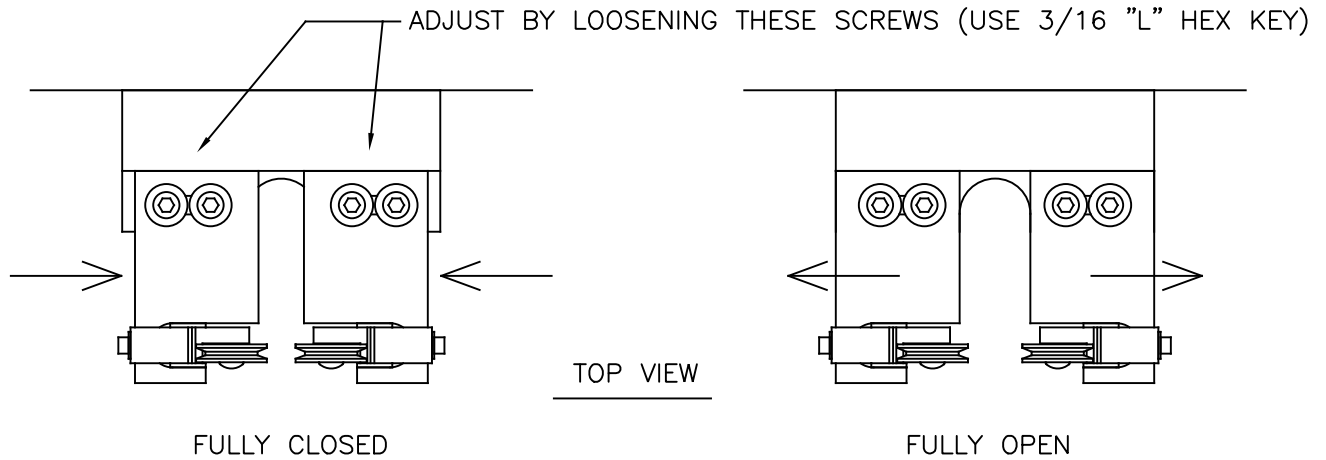
Annually

6. Roller Drive (internal, remove rear cover)
 - a. Replace drive gearbelt, if it has 2000+ operating hours (or one year of normal daily operation).

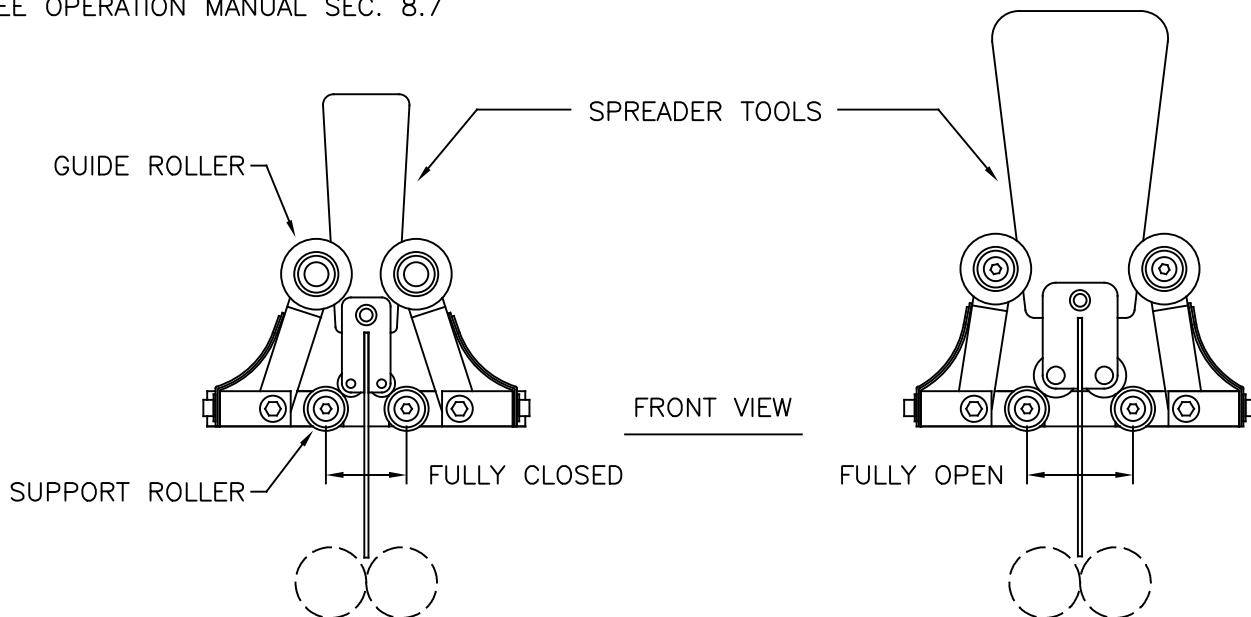
SUPPORT ROLLER SPACING (SRS) – ADJUST ACCORDING TO SPREADER TOOL SIZE

CLOSED FOR SMALL TOOL UP TO 60 MM

OPEN FOR LARGE TOOL 61 MM & UP

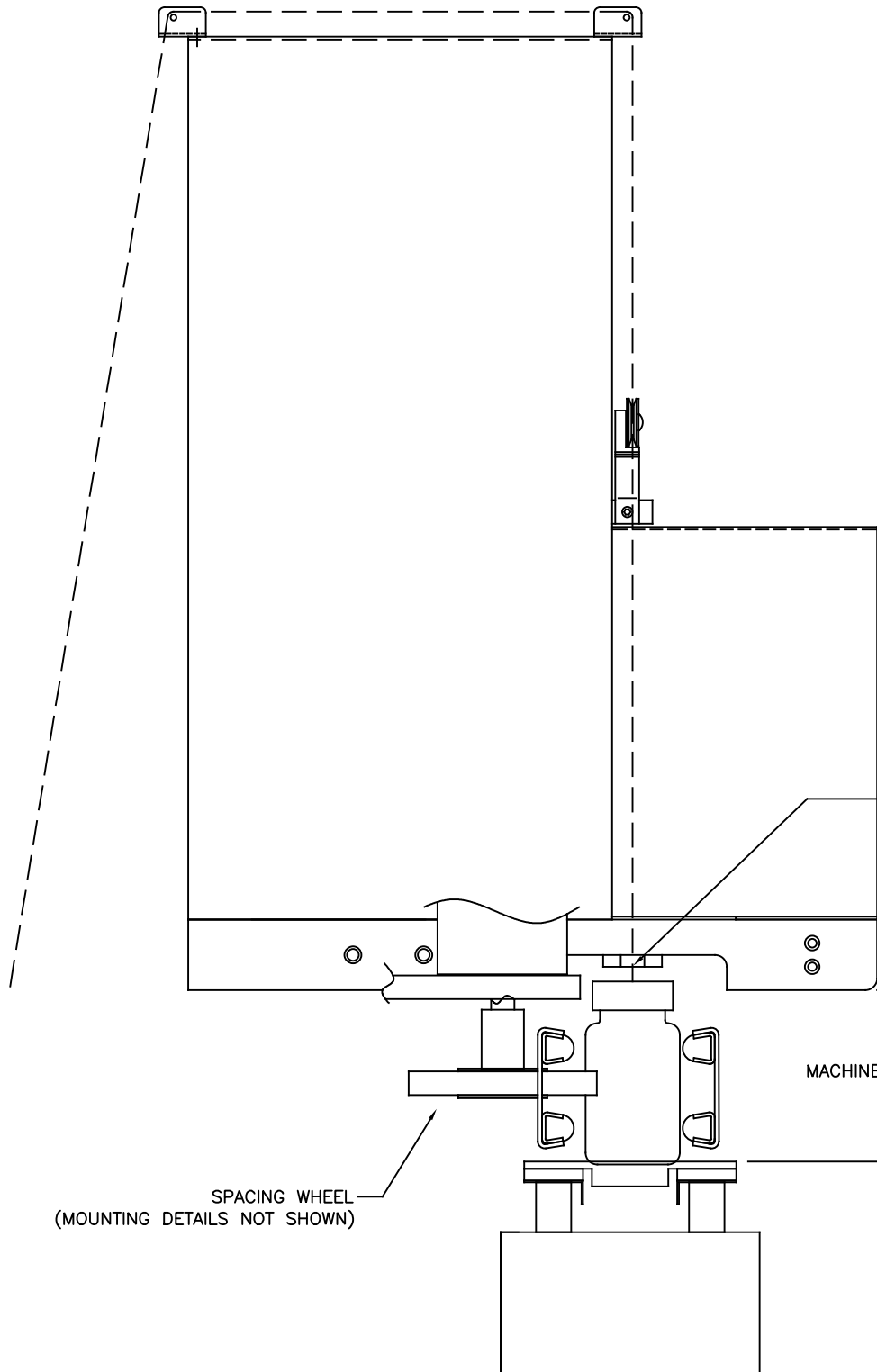


TO ADJUST GUIDE ROLLERS
FOR DIFFERENT TOOLS SIZES
SEE OPERATION MANUAL SEC. 8.7



1. SRS

<p>DEITZ COMPANY, INC. ROUTE 34, WALL, N.J. TECHNICAL DRAWING - PRODUCT INFO</p>	<p>PRODUCT -</p>	<p>BY SJD DATE: 2019-02-04</p>
	<p>TITLE MODEL NB1 NECK BANDER SET UP REFERENCE SUPPORT ROLLER SPACING</p>	<p>SHEET 1 OF 13</p>
	<p>NUMBER NB1-0012</p>	<p>REVISION A</p>



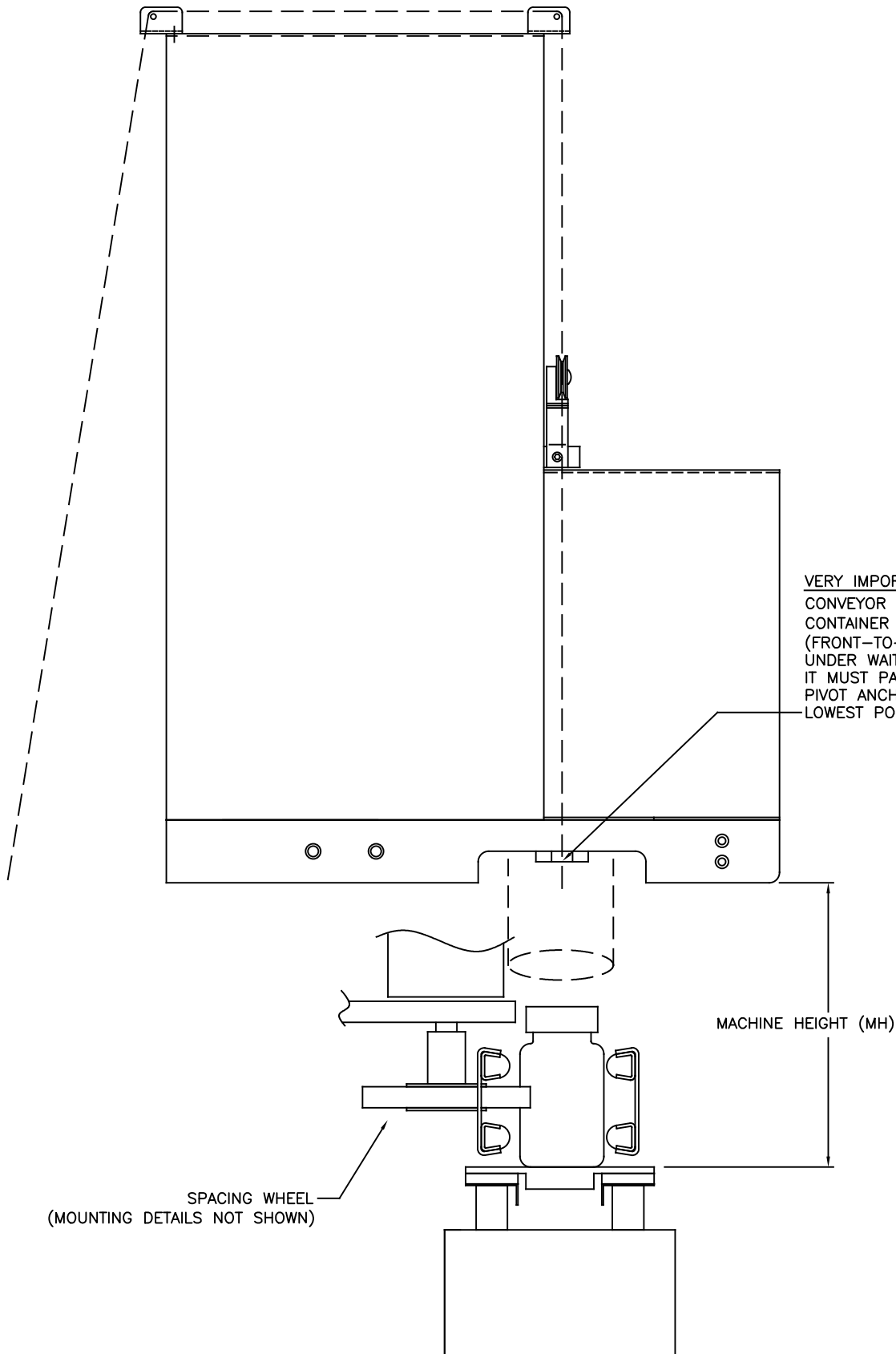
VERY IMPORTANT:
 CONVEYOR RAILS MUST BE SET SO
 CONTAINER WILL BE CENTERED
 (FRONT-TO-BACK) WHEN PASSING
 UNDER WAITING BAND OR SLEEVE.
 IT MUST PASS DIRECTLY UNDER
 PIVOT ANCHOR BLOCK, WHICH IS THE
 LOWEST POINT OF KNIFE ASSEMBLY.

SPACING WHEEL
 (MOUNTING DETAILS NOT SHOWN)

MACHINE HEIGHT (MH)

2. MH
 (NECK BANDS)

DEITZ COMPANY, INC. ROUTE 34, WALL, N.J. TECHNICAL DRAWING - PRODUCT INFO	PRODUCT -	BY SJD DATE: 2019-02-04
	TITLE MODEL NB1 NECK BANDER SET UP REFERENCE MACHINE HEIGHT 1	SHEET 2 OF 13
	NUMBER NB1-0012	REVISION A



VERY IMPORTANT:
 CONVEYOR RAILS MUST BE SET SO
 CONTAINER WILL BE CENTERED
 (FRONT-TO-BACK) WHEN PASSING
 UNDER WAITING BAND OR SLEEVE.
 IT MUST PASS DIRECTLY UNDER
 PIVOT ANCHOR BLOCK, WHICH IS THE
 LOWEST POINT OF KNIFE ASSEMBLY.

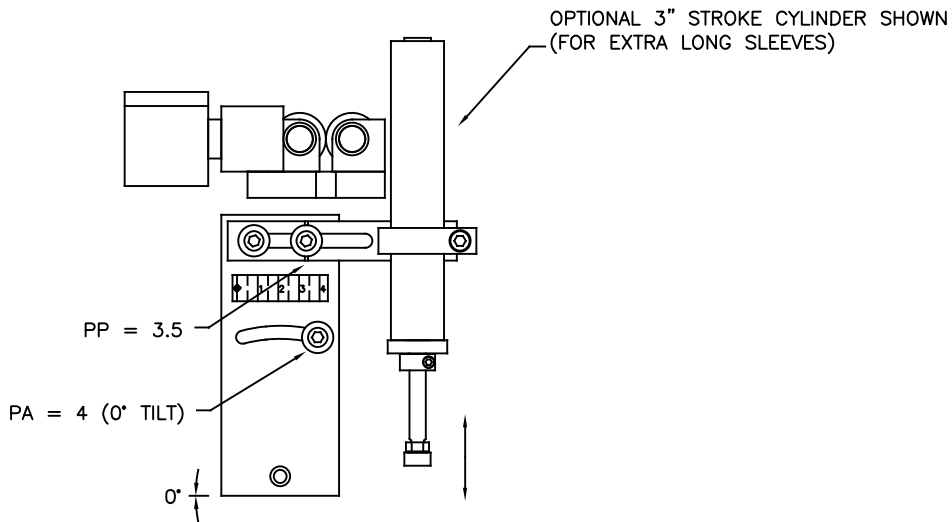
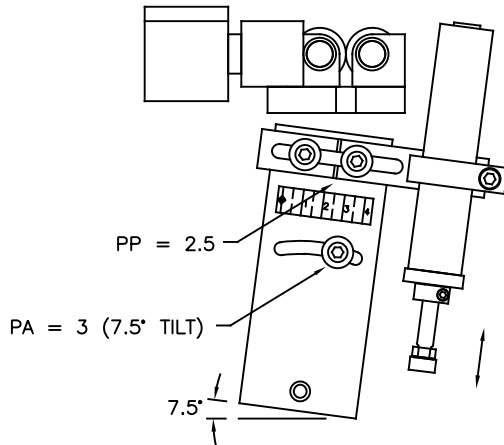
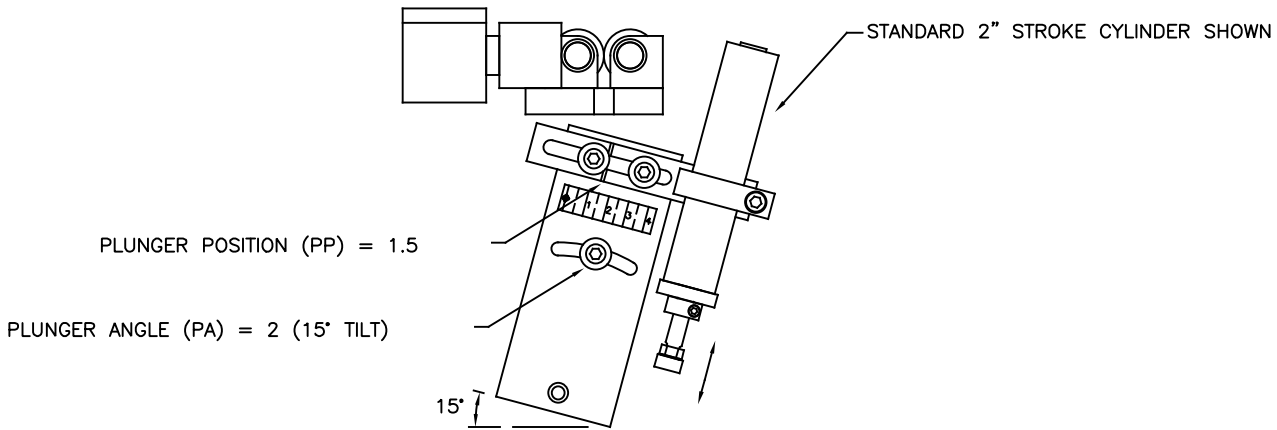
SPACING WHEEL
 (MOUNTING DETAILS NOT SHOWN)

MACHINE HEIGHT (MH)

2. MH
 (SLEEVES)

DEITZ COMPANY, INC. ROUTE 34, WALL, N.J. TECHNICAL DRAWING - PRODUCT INFO	PRODUCT -	BY SJD DATE: 2019-02-04
	TITLE MODEL NB1 NECK BANDER SET UP REFERENCE MACHINE HEIGHT 2	SHEET 3 OF 13
	NUMBER NB1-0012	REVISION A

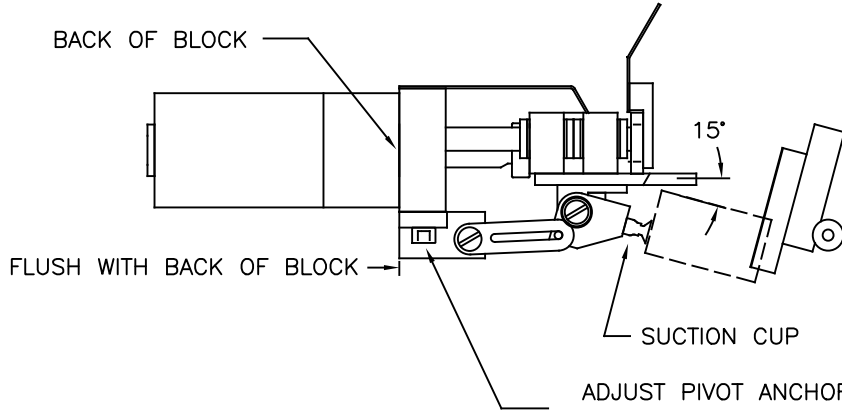
ADJUST THE PLUNGER POSITION (SIDE-TO-SIDE) AND PLUNGER ANGLE (TILT) USING THE SUPPLIED "LONG T" 3/16 HEX KEY



3. PA
4. PP

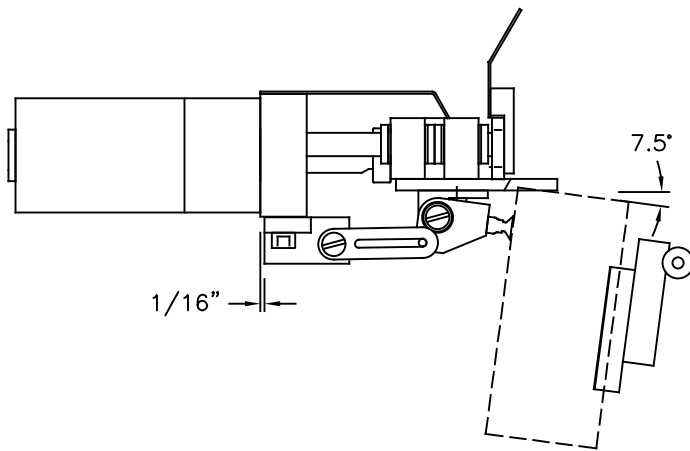
<p>DEITZ COMPANY, INC. ROUTE 34, WALL, N.J. TECHNICAL DRAWING - PRODUCT INFO</p>	PRODUCT -	BY SJD DATE: 2019-02-04
	TITLE MODEL NB1 NECK BANDER SET UP REFERENCE PLUNGER SETUP	SHEET 4 OF 13
	NUMBER NB1-0012	REVISION A

THE SUCTION CUP TILTING DOWN CAN AID IN PLACEMENT OF NECK BANDS AND SLEEVES



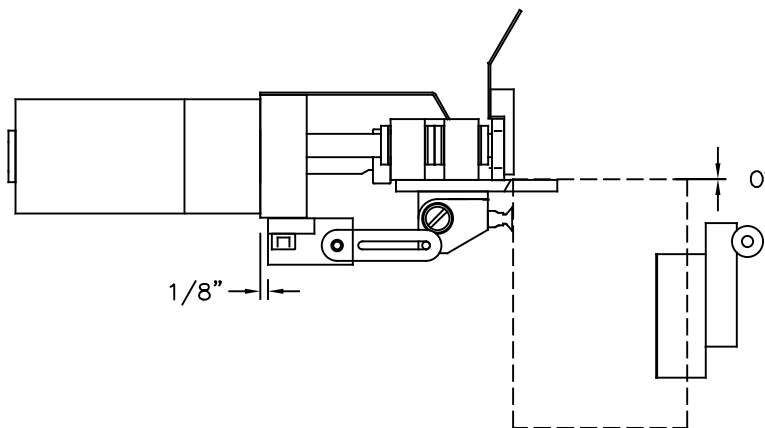
SUCTION CUP ANGLE (SCA)
 FLUSH WITH BLOCK = 15° TILT
 THIS IS THE STANDARD SETTING,
 GOOD FOR MOST APPLICATIONS

ADJUST PIVOT ANCHOR BLOCK BY LOOSENING TWO (2) SCREWS
 (FRONT & BACK) (USE 3/16 "L" HEX KEY)



1/16" = SCA 7.5°

SOMETIMES SLEEVES REQUIRE LESS ANGLE,
 OR NO ANGLE AT ALL

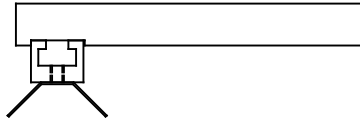


1/8" (NO SPRING TENSION) = SCA 0°

5. SCA

DEITZ COMPANY, INC. ROUTE 34, WALL, N.J. TECHNICAL DRAWING - PRODUCT INFO	PRODUCT —	BY SJD DATE: 2019-02-04
	TITLE MODEL NB1 NECK BANDER SET UP REFERENCE SUCTION CUP ANGLE	SHEET 5 OF 13
	NUMBER NB1-0012	REVISION A

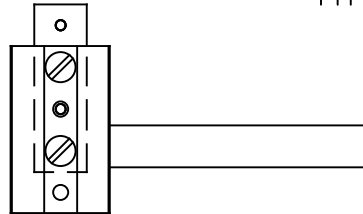
TOP VIEW



ADJUST THE POSITION (HIGH OR LOW) USING THE SUPPLIED 7/16 OR 11 MM NUT DRIVER

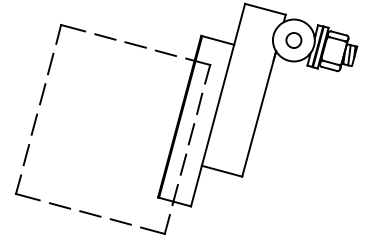
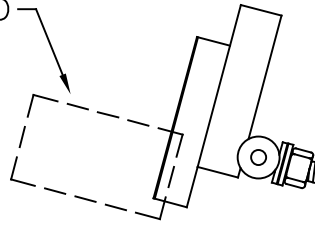
FRONT VIEW
HIGH POSITION

FRONT VIEW
LOW POSITION



SIDE VIEW

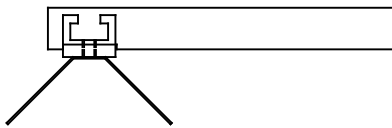
TYPICAL BAND



SMALL BAND HOLDER

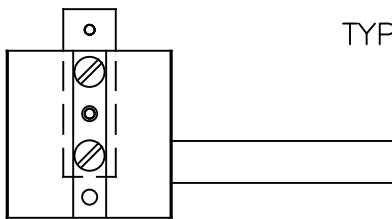
TOP VIEW

LARGE BAND HOLDER



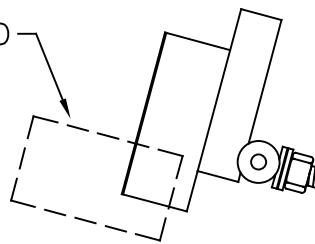
FRONT VIEW
HIGH POSITION

FRONT VIEW
LOW POSITION

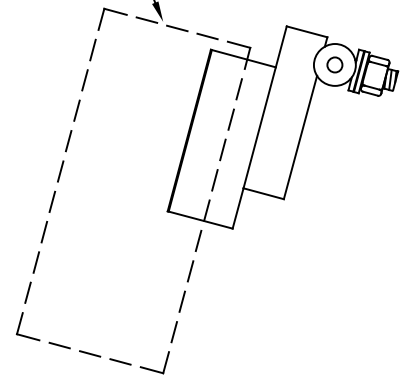


SIDE VIEW

TYPICAL BAND



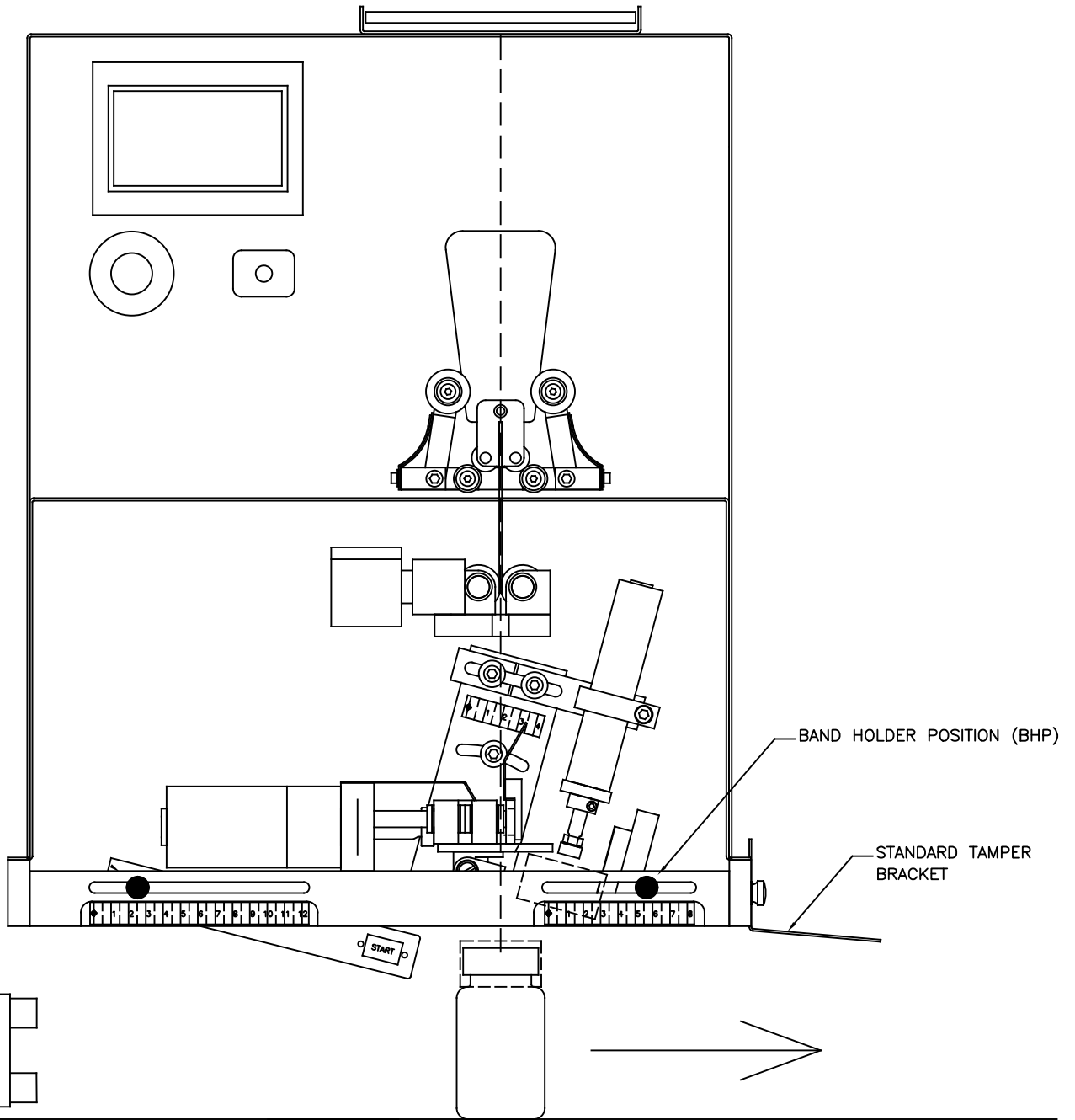
TYPICAL SLEEVE



NOTE: THE BAND HOLDER ANGLE SHOULD MATCH THE SUCTION CUP ANGLE

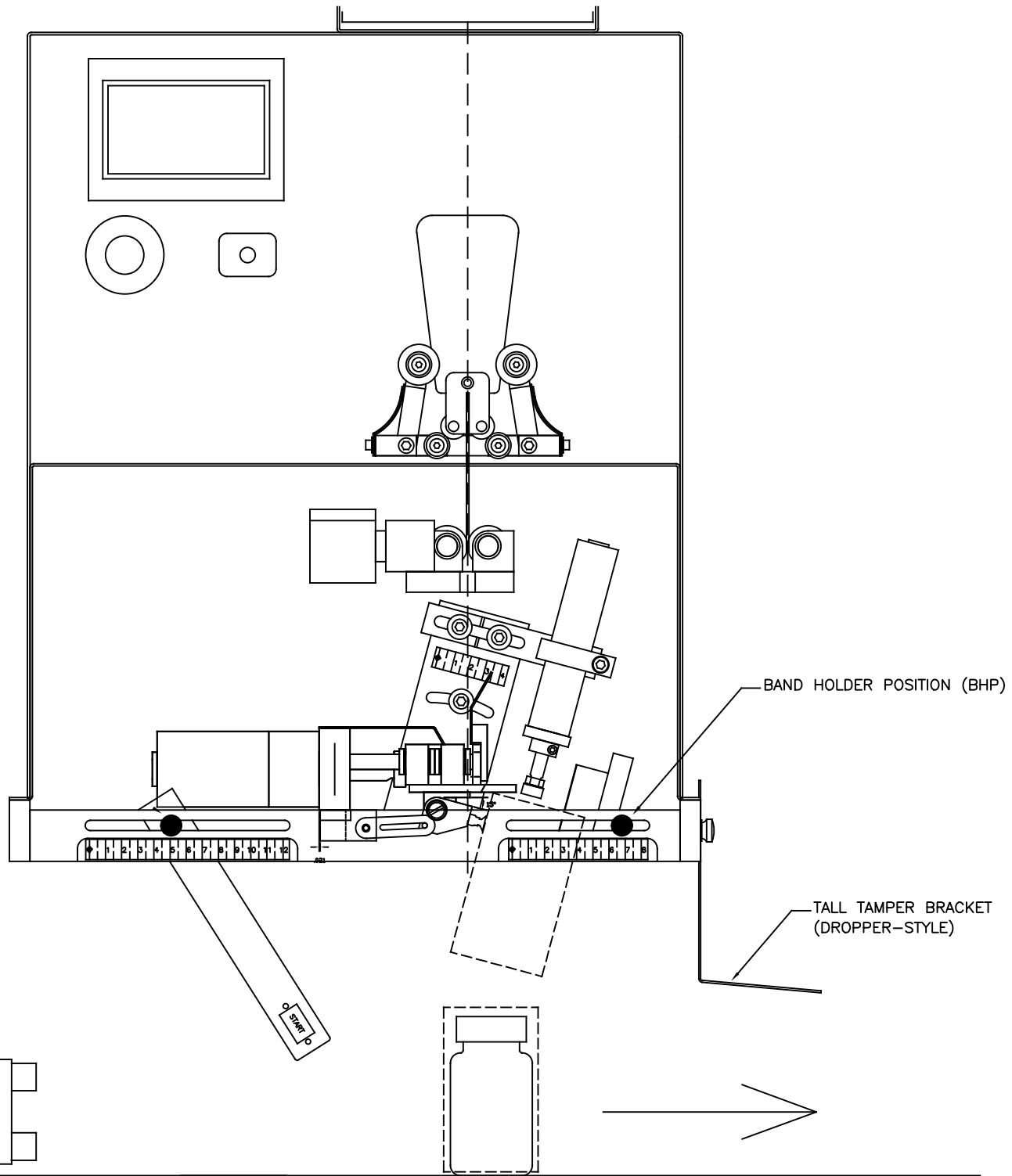
6. BHS

<p>DEITZ COMPANY, INC. ROUTE 34, WALL, N.J. TECHNICAL DRAWING - PRODUCT INFO</p>	PRODUCT -	BY SJD DATE: 2019-02-04
	TITLE MODEL NB1 NECK BANDER SET UP REFERENCE BAND HOLDER SETUP	SHEET 6 OF 13
	NUMBER NB1-0012	REVISION A



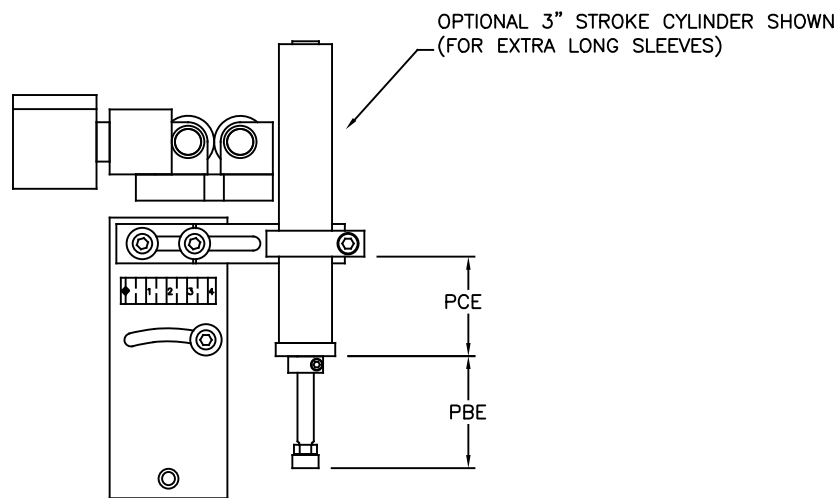
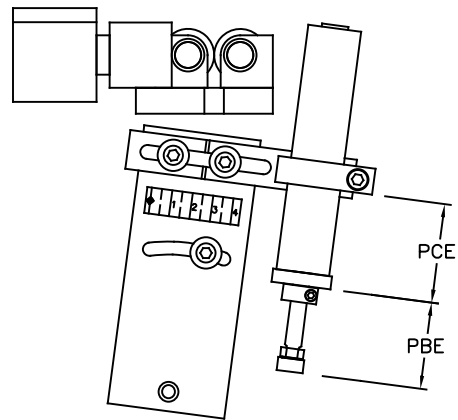
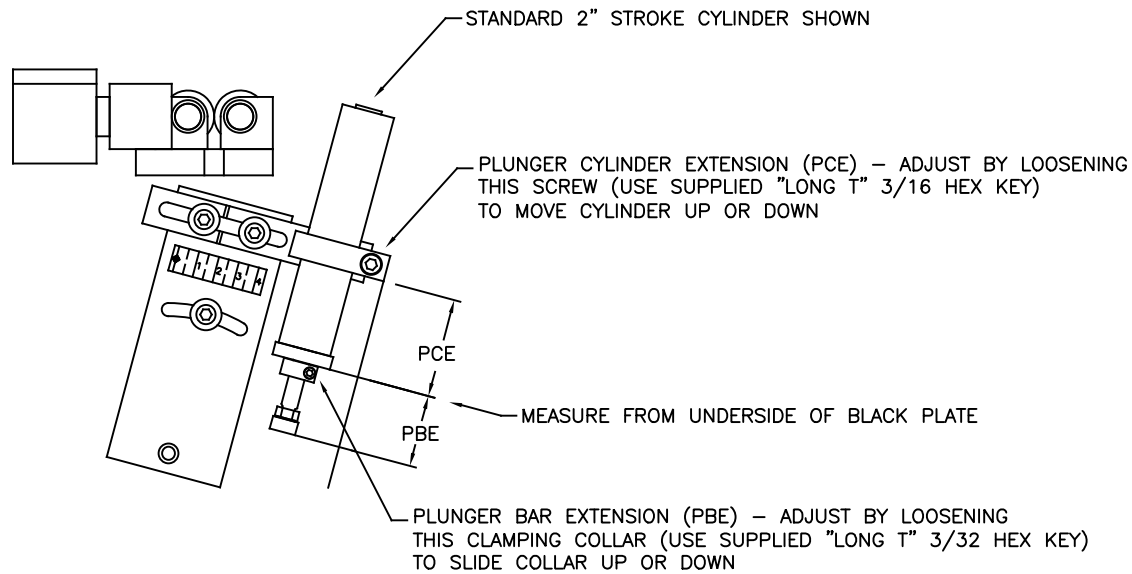
7. BHP
(NECK BAND)

DEITZ COMPANY, INC. ROUTE 34, WALL, N.J. TECHNICAL DRAWING - PRODUCT INFO	PRODUCT —	BY SJD DATE: 2019-02-04
	TITLE MODEL NB1 NECK BANDER SET UP REFERENCE BAND HOLDER POSITION 1	SHEET 7 OF 13
	BAND HOLDER POSITION 1	NUMBER NB1-0012 REVISION A



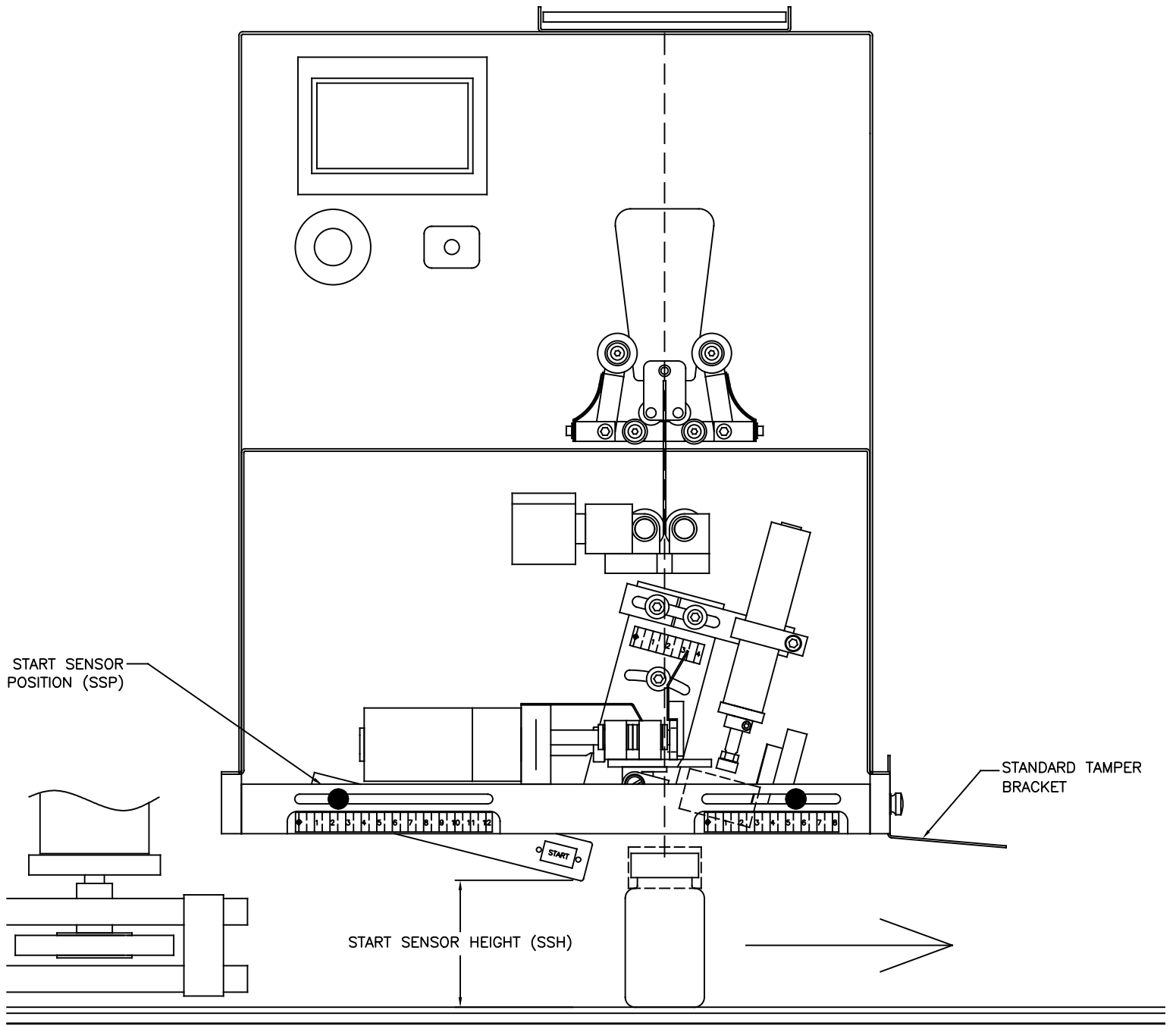
7. BHP
(SLEEVE)

DEITZ COMPANY, INC. ROUTE 34, WALL, N.J. TECHNICAL DRAWING - PRODUCT INFO	PRODUCT —	BY SJD DATE: 2019-02-04
	TITLE MODEL NB1 NECK BANDER SET UP REFERENCE BAND HOLDER POSITION 2	SHEET 8 OF 13
	NUMBER NB1-0012	REVISION A



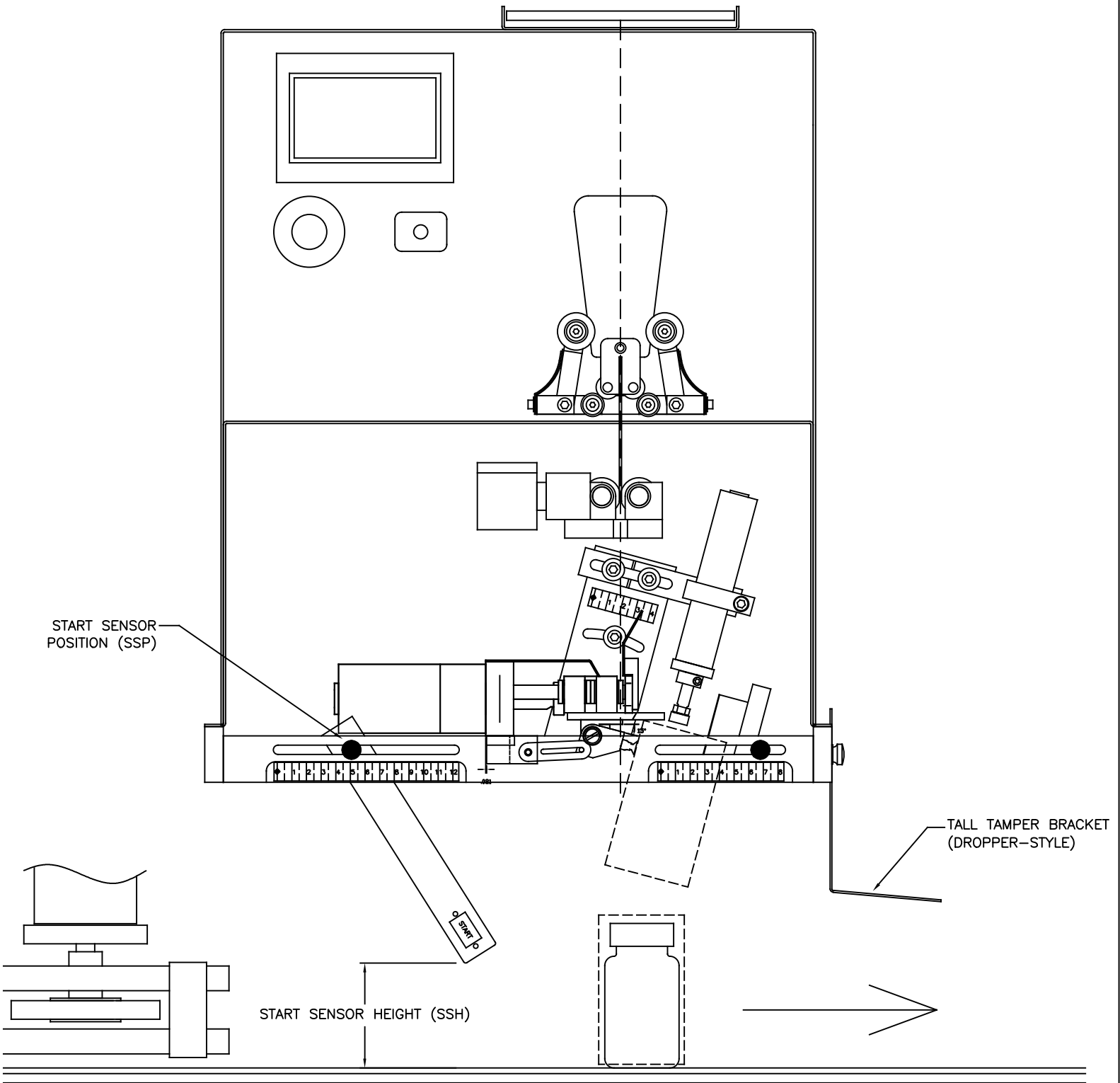
8. PCE
9. PBE

DEITZ COMPANY, INC. ROUTE 34, WALL, N.J. TECHNICAL DRAWING - PRODUCT INFO	PRODUCT —	BY SJD DATE: 2019-02-04
	TITLE MODEL NB1 NECK BANDER SET UP REFERENCE PLUNGER EXTENSION SETUP	SHEET 9 OF 13
	NUMBER NB1-0012	REVISION A

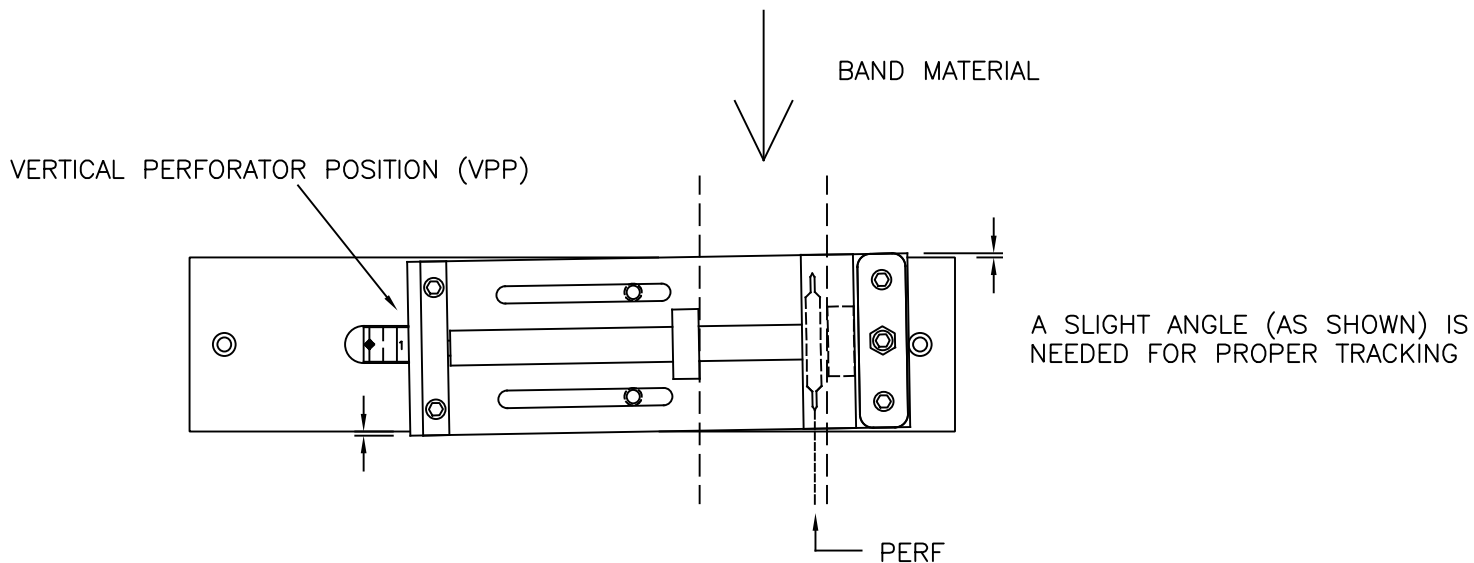


10. SSP
 11. SSH
 (NECK BAND)

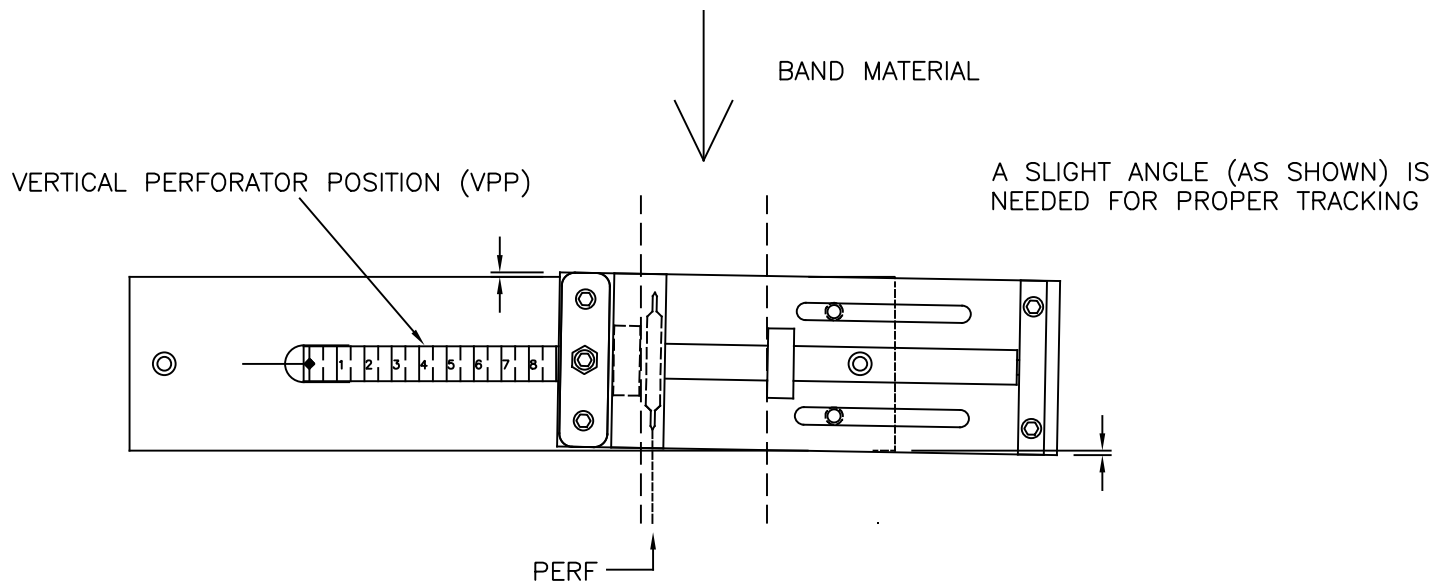
DEITZ COMPANY, INC. ROUTE 34, WALL, N.J. TECHNICAL DRAWING - PRODUCT INFO	PRODUCT	-		BY	SJD	DATE:	2019-02-04		
	TITLE	MODEL NB1 NECK BANDER SET UP REFERENCE START SENSOR SETUP 1				SHEET	10	OF	13
					NUMBER	NB1-0012			
						REVISION	A		



DEITZ COMPANY, INC. ROUTE 34, WALL, N.J. TECHNICAL DRAWING - PRODUCT INFO	PRODUCT -	BY SJD DATE: 2019-02-04
	TITLE MODEL NB1 NECK BANDER SET UP REFERENCE START SENSOR SETUP 2	SHEET 11 OF 13
	NUMBER NB1-0012	REVISION A



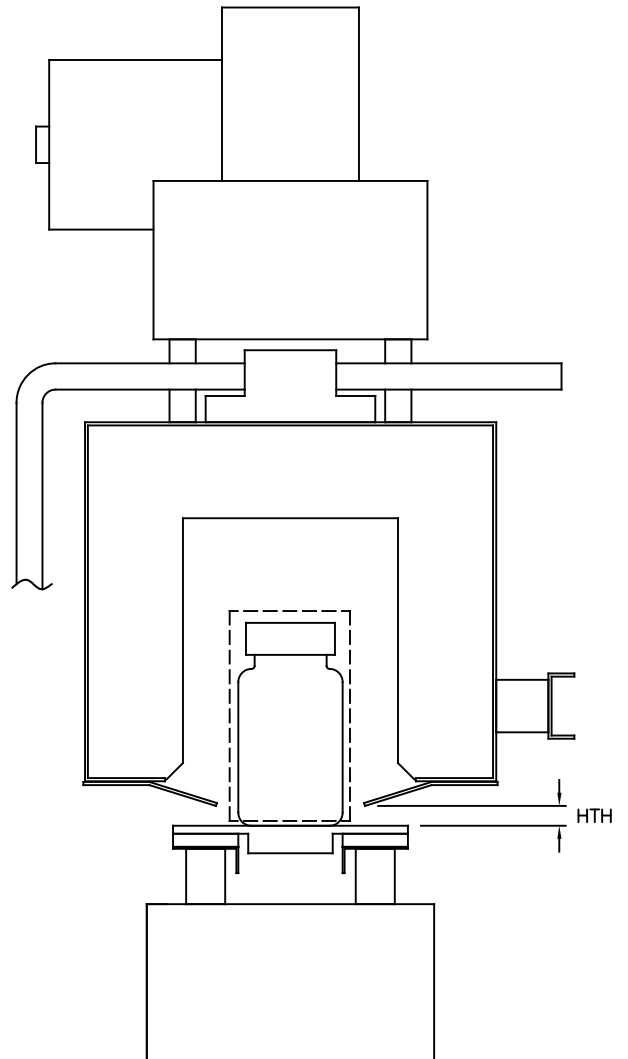
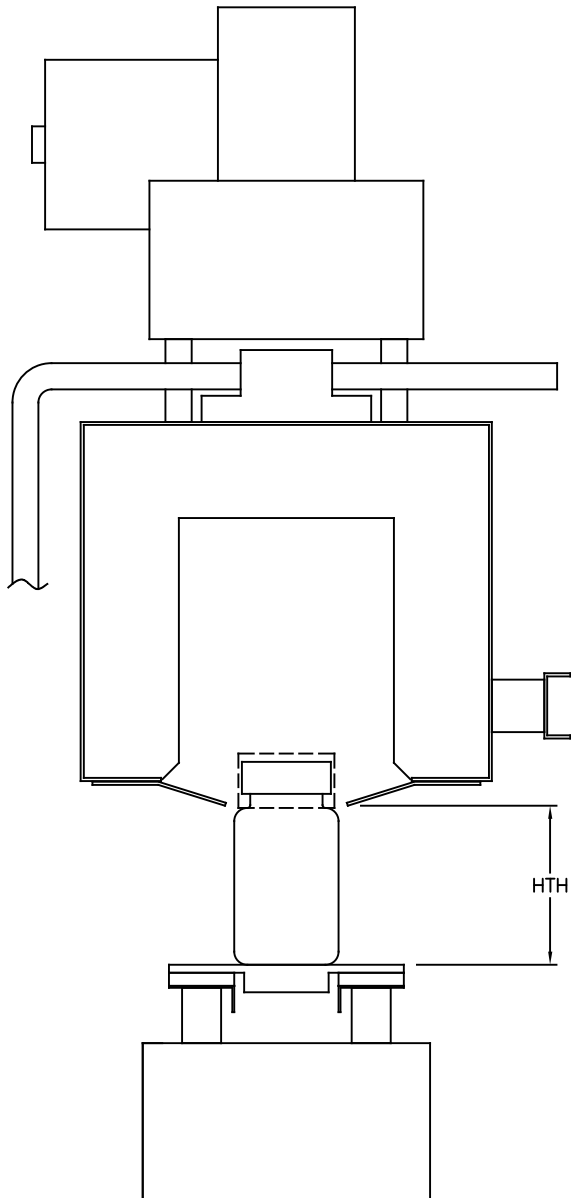
VERTICAL PERFORATOR – OVERHEAD VIEW – SET UP FOR RIGHT HAND PERF



VERTICAL PERFORATOR – OVERHEAD VIEW – SET UP FOR LEFT HAND PERF

12. VPP

DEITZ COMPANY, INC. ROUTE 34, WALL, N.J. TECHNICAL DRAWING - PRODUCT INFO	PRODUCT —	BY SJD DATE: 2019-02-04
	TITLE MODEL NB1 NECK BANDER SET UP REFERENCE VERTICAL PERFORATOR SETUP	SHEET 12 OF 13
	NUMBER NB1-0002	REVISION A



HEAT TUNNEL HEIGHT (HTH)
ABOVE CONVEYOR

13. HTH

DEITZ COMPANY, INC. ROUTE 34, WALL, N.J. TECHNICAL DRAWING - PRODUCT INFO	PRODUCT	-		BY	SJD	DATE:	2019-02-04
	TITLE	MODEL NB1 NECK BANDER SET UP REFERENCE HEAT TUNNEL HEIGHT		SHEET	13	OF	13
				NUMBER	NB1-0002		REVISION

NB1 SET-UP RECORD	Date _____	Serial No. _____			Pg ___ of ___
Customer:					
		1	2	3	4
Container					
Seal Type (Neck or Sleeve)					
Band Material LFW (mm)					
Band Spreader Tool (mm)					
Seal Length (inches)					
Start Time (secs)					
CV Speed (feet/min)					
Spacing Wheel Speed (dial)					
Perforator (Y/N & Right/Left)					
<u>See setup drawings</u>	* measured with ruler in inches			** set to number on machine	
1. Support Roller Spacing	SRS				
2. NB Height	NBH*				
3. Plunger Angle Setting	PAS**				
4. Plunger Position (L-to-R)	PP**				
5. Suction Cup Angle (visual)	SCA				
6. Band Holder Setup (visual)	BHS				
7. Band Holder Positon	BHP**				
8. Plunger Cyl Extension	PCE*				
9. Plunger Bar Extension	PBE*				
10. Start Sensor Position	SSP**				
11. Start Sensor Height	SSH*				
12. Vertical Perforator Pos.	VPP**				
13. HT Height	HTH*				