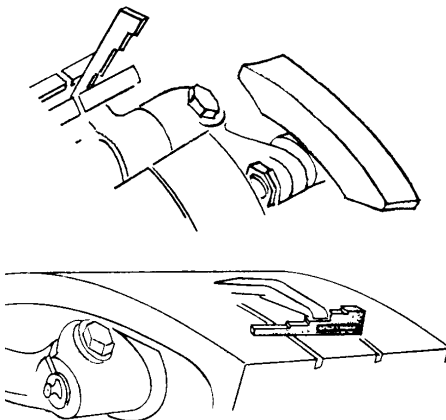
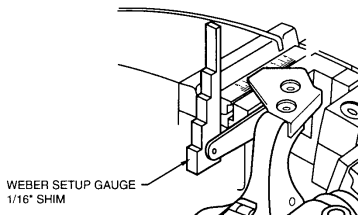
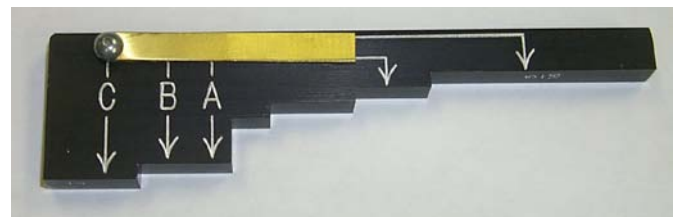
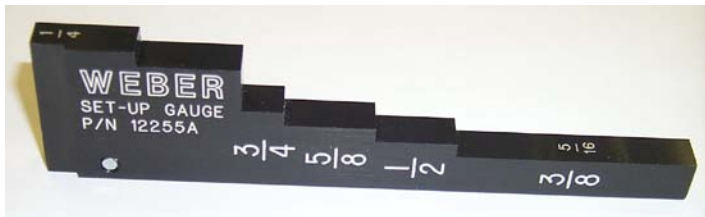


SERVICE BULLETIN

70-1

Drum Setup Gauge Specifications

BAG MACHINE SIZE	2-3	5	7	9	10-11	Single Size
Gauge Part No.	12255A	12255A	12255A	12255AA	12255AA	No gauge no.
First Clamp Opening	1/4"	1/4"	5/16"	1/2"	3/8"	1/4"
Second Clamp Opening	1/4" – 5/16"	5/16"	3/8"	1/2"	1/2"	5/16"
Center Gripper Opening	5/8"	5/8" – 3/4"	5/8" – 3/4"	1-1/4"	3/4"	None
Tuck Blade Centering	A	B	C	Spring Loaded	Spring Loaded	Spring Loaded
Distance Between Clamps = Bottom Width minus	3/8" (Model 3)	7/16"	1/2"	3/4"	1/2"	Fixed



Drum Finger Clearance

Insert the proper gauge to maintain clearance between the finger and drum.

Clamp Adjustment

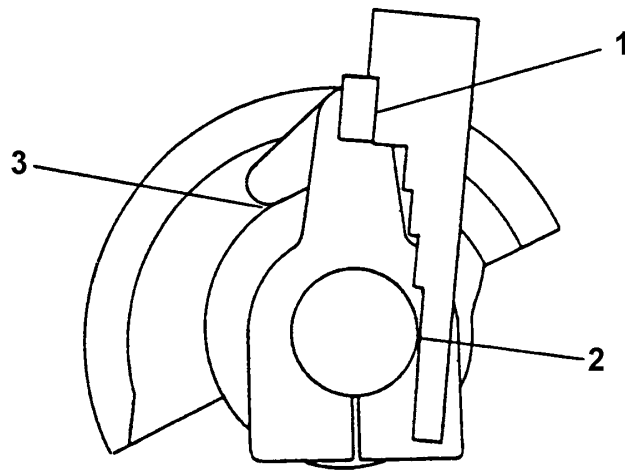
Insert required gauge between clamp jaws. Loosen the cam follower lever while holding cam follower against the high portion of the cam. Retighten cam follower lever cap screw.

Center Gripper Opening Height

Insert required gauge under center gripper finger. Loosen the cam follower lever while holding the cam follower against the high portion of the cam. Retighten cam follower lever cap screw.

Tuck Blade Setup

Position the blade support bar perpendicular to shaft center.



1. Remove the tucking blade and clamp plate.
2. Turn the machine until the tucking bar being adjusted is pointed straight up.
3. Refer to the Drum Setup Gauge Specifications chart for the proper surfaces to use for your machine size.
4. Loosen the cam follower lever clamp bolt.
5. Lay the proper surface of the gauge flat against the leading surface of the blade support bar (1 in diagram above).
6. Rotate the support bar and gauge until the leg of the gauge contacts the shaft (2 in diagram above).
7. Holding the support bar and gauge in this position, push the cam follower against the inner cam surface (3 in diagram above).
8. Tighten the cam follower clamp bolt.
9. The blade must be mounted on the leading surface of the support bar.