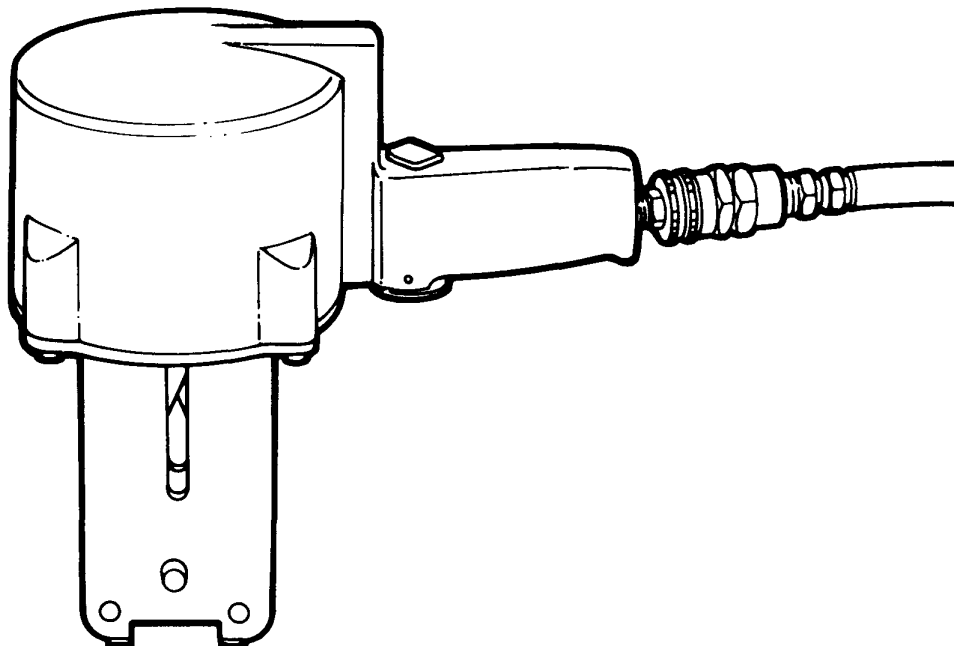


PARTS LIST/OPERATION/MAINTENANCE

MODEL PHDS

AIR SEALER

PHDS-1	Item No. 2621900
PHDS-2	Item No. 2628900
PHDS-2H	Item No. 2625900
PHDS-3	Item No. 2620900
PHDS-3H	Item No. 2620901
PHDS-4	Item No. 2625901
PHDS-5	Item No. 2626900



STRAPPING PRODUCTS

ACME PACKAGING CORPORATION
A SUBSIDIARY OF ACME METALS INCORPORATED

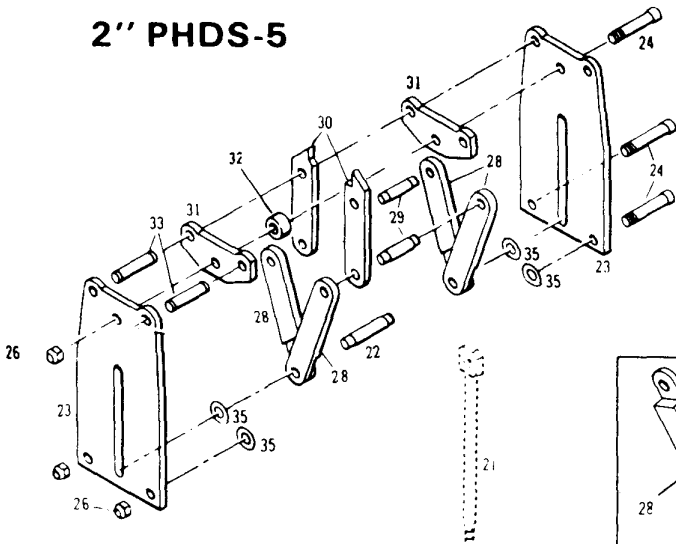
100 BURRITT STREET
NEW BRITAIN, CT 06050-6500
(011) 708-849-2500

SEALING HEADS

3/4" PHDS-1

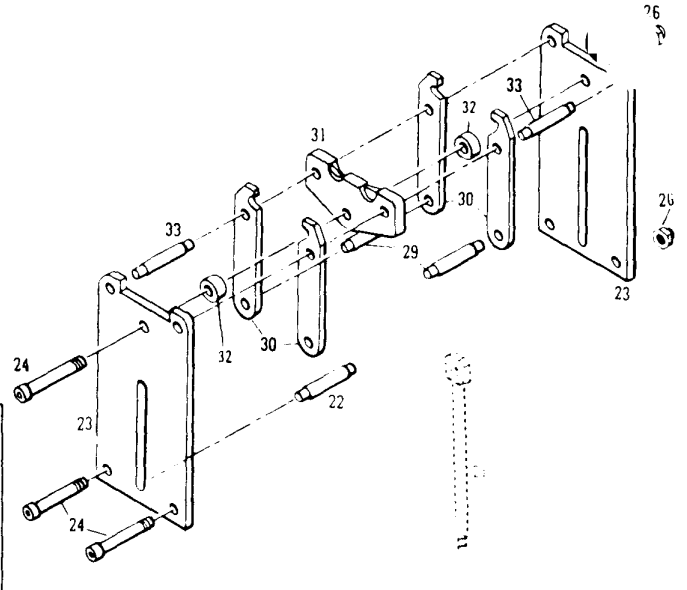
1 1/4" PHDS-2 & 2H

2" PHDS-5

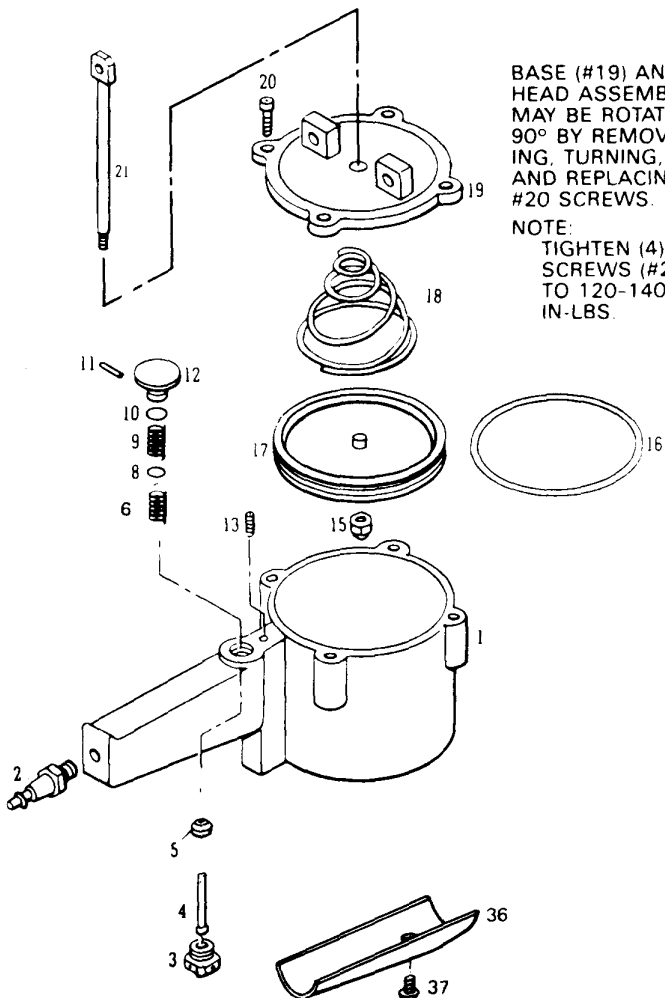


SEALING HEADS

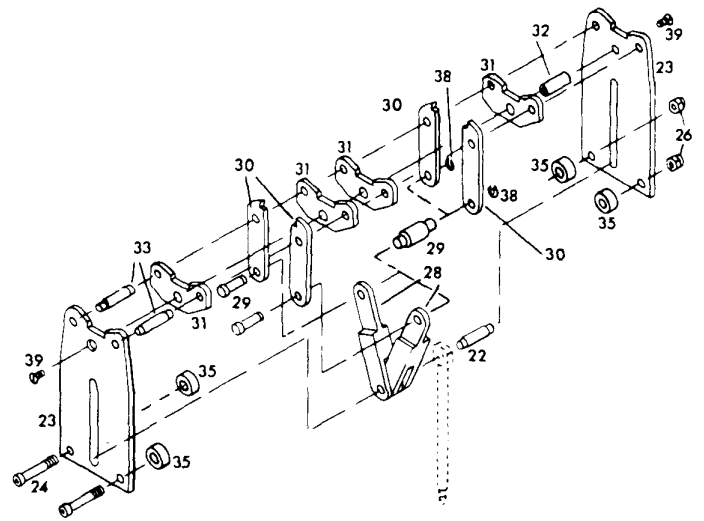
1 1/4" PHDS-3 & 3H



CYLINDER-VALVE-HANDLE ASSEMBLY



SEALING HEAD PHDS-4



PARTS LIST

COMMON PART NO'S FOR ALL TOOLS

<u>Index No.</u>	<u>Part Number</u>	<u>No. Req'd.</u>	<u>Part Name</u>
2	5401036	1	Airline Fitting 1/4 Hansen No. 40
3	5401030	1	Valve Plug
4	5401019	1	Valve Stem
5	5401020	1	Washer
6	5401023	1	Spring
8	5401024	1	0" Ring (Parker #2—8) or Equiv
9	5401022	1	Valve Spring
10	5407036	1	'0" Ring
11	5462042	1	Roll Pin (ESNA 59-012-062-0500)
12	5401021	1	Valve Button
13	5407012	1	Pipe Plug 1/16 NPT Hex.Soc.
18	5435094	1	Cylinder Spring
**20	5435066	4	Soc. Hd. Cap Screw 1/4 - 20 x 7/8
26	5201024	3	Stop Nut (ESNA No. 21-TU-058)
36	5401033	2	Deflector
37	5401034	2	Button Hd. Scr. #8-32 X 3/8
	5435166		Label
	5425204	2	Drive Screw

PARTS COMMON TO PHDS-2H

<u>Index No.</u>	<u>Part Number</u>	<u>No. Req'd.</u>	<u>Part Name</u>
1	5410800	1	Cylinder Handle and Valve Assy
21	5406001	1	Piston Rod
19	5406004	1	Base
1]	5410003	1	Piston
23	5415001	2	Side Plate
31	5415002	2	Anvil
28	5415003	4	Link
32	5415004	1	Spacer
33	5415005	2	Jaw Pin
29	5415006	2	Link Pin
22	5415007	1	Piston Rod Pin
30	5491034	2	
15	5491011	1	Stop Nut (ESNA~21-TE.064)
16	5410017	1	Cylinder Ring Parker No. 2-348
24	5511019	3	Soc Hd. Cap Scr. 5/16 - 18 x 1.3/4
39	5731178	2	Fl. Hd. Sock. Cap Scr. Nylock 1/4 -20 x 1/21

PARTS COMMON TO PHDS-1

1	5401800	1	Cylinder, Handle and Valve Assy.
19	5401002	1	Base
17	5401003	1	Piston
21	5401004	1	Piston Rod
28	5401005	4	Link
22	5401006	1	Piston Rod Pin
23	5401007	2	Side Plate
29	5401008	2	Link Pin
33*	5401009	2	Jaw Pin
30*	5401010	2	Jaw
32	5412024	1	Anvil Spacer
31	5401012	2	Anvil
24	5407027	3	Soc. Hd. Cap Scr. 5/16 - 18 x 1-3/8
16	5401017	1	Cylinder "O" Ring (Parker No. 2-341)
15	5407021	1	Stop Nut (ESNA-21-TE-064)

PARTS COMMON TO PHDS-3

21	5401004	1	Piston Rod
15	5407021	1	Stop Nut (ESNA-21-TE-064)
1	5410800	1	Cylinder, Handle and Valve Assy
17	5410003	1	Piston
16	5410017	1	Cylinder "O" Ring (Parker No. 2-348)
24	5511019	3	Soc. Hd. Cap Scr. 5/16.18 x 1.3/4
19	5410002	1	Base
28	5410005	2	Link
22	5410006	1	Piston Rod Pin
23	5410007	2	Side Plate
29	5410008	2	Link Pin
33	5410009	2	Jaw Pin
30	5410010	4	Jaw
32	5410011	2	Anvil Spacer
31	5410012	1	Anvil

PARTS COMMON TO PHDS-2 ne

1	5401800	1	Cylinder, Handle and Valve Assy.
19	5401002	1	Base
17	5401003	1	Piston
22	5401006	1	Piston Rod Pin
24	5407027	3	Soc. Hd. Cap Screw 5/16 - 18 X 1-3/8
16	5401017	1	Cylinder "O" Ring (Parker No. 2-341)
15	5407021	1	Stop Nut (ESNA-21-TE-064)
21	5401004	1	Piston Rod
28	5408005	4	Link
23	5408007	2	Side Plate
29	5408008	2	Link Pin
33	5408009	2	Jaw Pin
30	5408010	2	Jaw
32	5408011	1	Anvil Spacer
31	5408012	2	Anvil

PARTS COMMON TO PHDS-3H

No.	Number	Req'd	Part Name
21	5401004	1	Piston Rod
15	5407021	1	Stop Nut (ESNA-21-TE-064)
1	5410800	1	Cylinder, Handle and Valve Assy.
17	5410003	1	Piston
16	5410017	1	Cylinder "O" Ring (Parker No. 2.348)
24	5511019	3	Soc. Hd. Cap Scr. 5/16. 18 x 1-3/4
19	5410002	1	Base
28	5410005	2	Link
22	5410006	1	Piston Rod Pin
29	5410008	2	Link Pin
33	5410009	2	Jaw Pin
30	5410010	4	Jaw
32	5410011	2	Anvil Spacer
23	5410013	2	Side Plate
31	5410014	1	Anvil

MUST BE TIGHTENED TO 120-140 IN-LBS

PARTS COMMON TO PHDS-4

Index No.	Part Number	No. Req'd.	Part Name
21	<u>5401004</u>	1	Piston Rod
16	<u>5401017</u>	1	Cylinder "O" Ring IParker No. 2-341)
15	<u>5407021</u>	1	Stop Nut (ESNA-21-TE-064)
1	<u>5410800</u>	1	Cylinder, Handle and Valve Assy.
19	<u>5406004</u>	1	Base
17	<u>5410003</u>	1	Piston
16	<u>5410017</u>	1	Cylinder "O" Ring (Parker No. 2-348)
24	<u>5511019</u>	3	Soc. Hd. Cap Scr. 5/16- 18 x 1-3/4
39	<u>5731178</u>	2	Fl. Hd. Soc. Cap Scr. (Nylock 1/4 - 20 x 1/21
22	<u>5410006</u>	1	Piston Rod Pin
28	<u>5405005</u>	2	Link
29	<u>5405008</u>	2	Link Pin
32	<u>5405011</u>	1	Spacer
23	<u>5405007</u>	2	Side Plate
30	<u>5405013</u>	4	Jaw
31	<u>5405012</u>	4	Anvil
33	<u>5405009</u>	2	Jaw Pin

PARTS COMMON TO PHDS-5

Index No.	Part Number	No. Re'd.	Part Name
15	<u>5407021</u>	1	Stop Nut (ESNA-21-TE-064)
29*	<u>5491035</u>	2	Link Pin
32	<u>5491036</u>	1	Anvil Spacer
15	<u>5491011</u>	1	Stop Nut
25	<u>5407014</u>	1	Soc. Hd. Cap Scr. 3/8 - 24 x 2
24	<u>5440119</u>	3	Soc. Hd. Cap Scr. 5/16 - 18 x 2-1/4
1	<u>5410800</u>	1	Cylinder, Handle and Valve Assy.
21	<u>5406001</u>	1	Piston Rod
19	<u>5406004</u>	1	Base
17	<u>5410003</u>	1	Piston
30*	<u>5491034</u>	2	Jaw
16	<u>5410017</u>	1	Cylinder "O" Ring (Parker No. 2-348)
23	<u>5406002</u>	2	Side Plate
35	<u>5406003</u>	4	Plate Spacer
22	<u>5407018</u>	1	Piston Rod Pin
33	<u>5407022</u>	2	Jaw Pin
28	<u>5491031</u>	2	Link, RH.
28	<u>5491032</u>	2	Link, L.H.
31	<u>5491033</u>	2	Anvil

OPERATION

1. Regulate air pressure of Filter-Regulator-Lubricator Unit for these tools at the following PSI:

PHDS-1	65 PSI Minimum, 110 PSI Maximum
PHDS-2, 3	70 PSI Minimum, 110 PSI Maximum
PHDS-4,5	75 PSI Minimum, 110 PSI Maximum

- To notch or crimp the seal, place jaws (No. 30) over seal with side plate flush with end of seal.
- Squeeze button (No. 12) to activate jaws.
- Repeat sealing action at other end of seal.
- If more than one seal applied repeat steps 2-3-4 on every seal.

TOOL MAINTENANCE

Your Acme Representative will assist you in becoming familiar with the maintenance procedures of this tool. Most worn or broken parts are easily replaceable by your Tool Repair Shop in less than 30 minutes. These few maintenance tips will help insure trouble-free operation:

- ONCE-A-DAY . . . blow or brush off accumulated dirt.
- ONCE-A-WEEK . . . clean and lubricate all moving parts.
- Check at regular intervals for deep or well defined notches or crimps on the seal. If notches or crimps are shallow or poorly defined, check:
 - Valve Button (No. 12) is being depressed completely.
 - Check for wear on jaws (No. 30) or anvils (No. 31).
- If jaws or anvils are worn or broken . . . REPLACE ALL JAWS (No. 30), ANVILS (No. 31) and JAW PINS (No. 33).

ORDERING PARTS

When ordering parts specify as shown below:

TOOL NAME PHDS-1
 TOOL NUMBER 2621900
 PART NUMBER 5401010
 QUANTITY 2
 PURCHASE ORDER NUMBER ... P.O. 1234