

Web Leader Combination Folder (Model 61)



Parts Catalog

WebPress
Revolutionary™

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Revision 9/5/18

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Head Roll

Half Fold

General Assembly

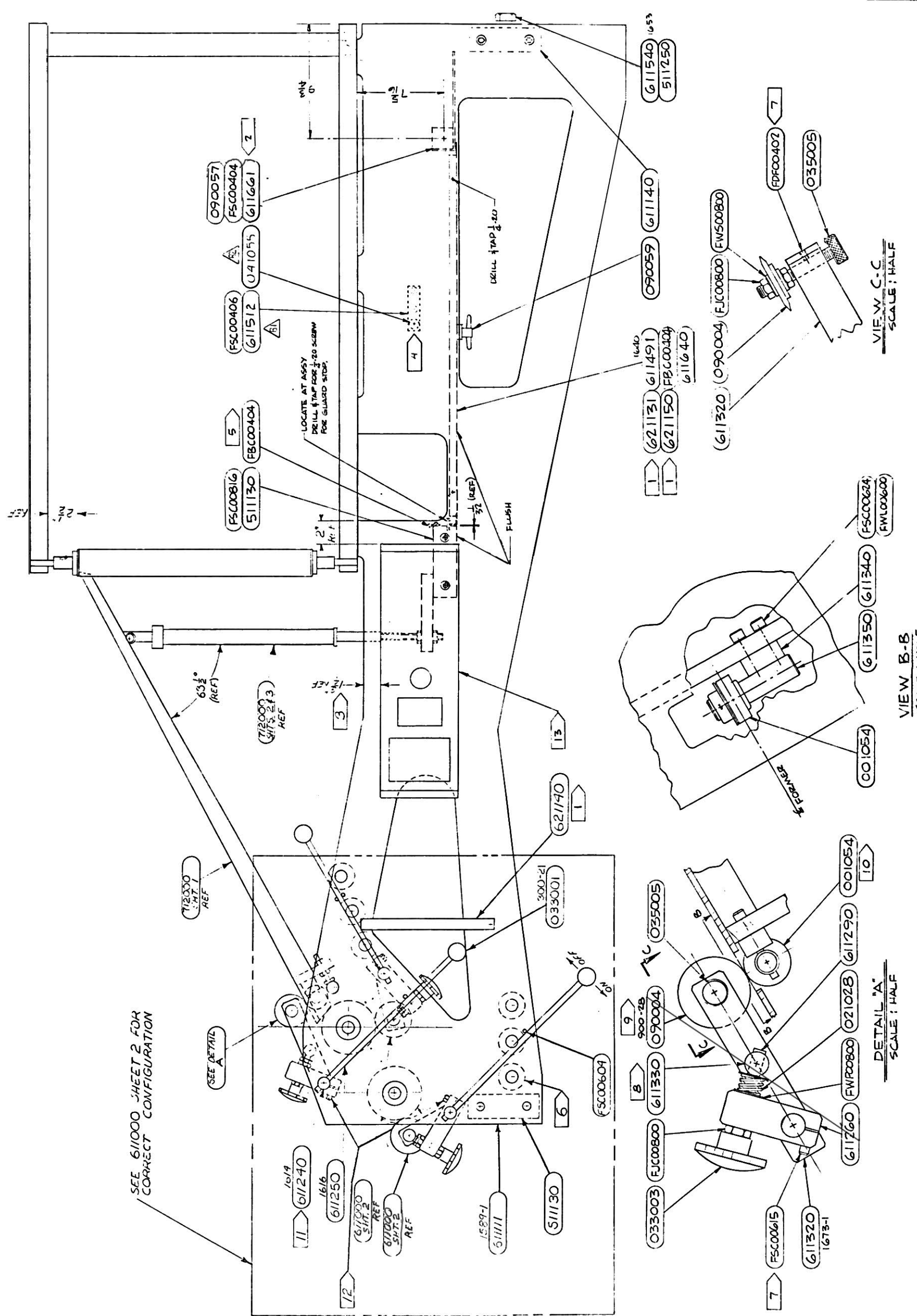
**WEB LEADER FOLDER
HEAD ROLL STAND ASSEMBLY 611000**

PART NO.	DESCRIPTION	QTY. REQ'D
001054	BEARING, ER-16 (prev. 001001)	4
001054	BEARING, ER-16X	7
021028	SPRING, 1" OD x 1" LG (BLUE)	7
032003	SET COLLAR, 1" x 1-5/8	6
033001	KNOB, 1-3/8 OD, 3/8-16 UNC	3
033003	KNOB, 3-1/8 OD, 1/2-13 UNC	7
035005	THUMB SCREW, 1/2-13 UNC x 3-1/2 LG.	1
041002	JAM SWITCH, 15 AMP, 125V	1
041055	PROXIMITY SWITCH	1
048004	1/2" EF LIQUID TIGHT FLEX STL. CONDUIT	2
048005	1/2" EF LIQUID TIGHT STRAIGHT CONNECTOR	3
060006	BELT, 1/2 P x 2" W x 63" LG	1
061001	PULLEY, 24T x 1/2P x 2"W W/TPR BUSHING	1
061003	PULLEY, 32T x 1/2P x 2"W W/TPR BUSHING	2
062003	TAPER BUSHING, 1" BORE SK-1	2
062004	TAPER BUSHING, 1" BORE SD-1	2
067001	GEAR BOX, 1/8:1, MODEL 11	1
067009	GEAR BOX, 1:1, STYLE F, MODEL 11	1
068003	COUPLING, 1" BORE	2
069003	PULLEY, IDLER 4" DIA. GROOVE 1" HOLE	1
090004	SLITTER WHEEL W/BRG	1
090057	MAGNETIC LATCH	3
090059	LATCH	1
511130	STIFFENER, LOWER	2
511260	LEVELING BOLT	2
511480	SHAFT, STIFFENER	6
511490	ROLLER CORE	6
521460	STIFFENER	1
611113	FRAME, HEAD ROLL G.S.	1
611123	FRAME, HEAD ROLL O.S.	1

**WEB LEADER FOLDER
HEAD ROLL STAND ASSEMBLY 611000**

PART NO.	DESCRIPTION	QTY. REQ'D
611150	HEAD ROLL	2
611230	BRACKET, TROLLEY CLAMP	6
611240	SHAFT, TROLLEY	3
611250	HANDLE TROLLEY SHAFT	3
611260	BRACKET, SLITTER CLAMP	1
611271	BRACKET, TROLLEY PIVOT	6
611280	AXLE, TROLLEY	6
611290	SLITTER ADJUST SCREW	7
611310	TROLLEY WHEEL	6
611320	ARM, SLITTER	1
611330	SLITTER, AXLE	1
611340	ANVIL, SLITTER STUD SPACER	1
611350	SLITTER, ANVIL BEARING STUD	1
611450	SHAFT, GEAR BOX	1
611460	PLATE, IDLER SUPPORT	1
611470	SHAFT, IDLER TIGHTENER	1
611512	BRACKET, PROXIMITY SWITCH	1
611531	SHEAVE, LOWER DRIVE	1
OPTIONAL BASIC PADS / TIE DOWN 611000B1		
511250	WEB LEADER LEVELING PAD	6
611841	MOUNT LAG BOLT	4

DR DATE REVISION BY RP
 A 7-10-78 REPAIR, UPDATE
 B 6/19/18 001001 changed to 001054



- 1 USED ON DP ONLY
- 2 LOCATE GUARD SUPPORT ANGLE AS SHOWN, DRILL TAP 1/4-20 LOCATE MAGNETIC LATCH (2 Pcs) ON TOP OF ANGLE SUPPORT.
- 3 INSTALL OPERATOR STATION AS HIGH AS FLAME CUT ALLOWS - KEEP IN VERTICAL POSITION. REF. DIM. ARE APPROX.
- 4 UTILIZE UPPER COUNTING SWITCH MNTG. HOLE FOR WATER TUBING CLAMP
- 5 ATTACH WATER TUBING CLAMP UNDER MIDDLE STIFFENER
- 6 INSTALL WEB GUIDE SHAFTS FLUSH WITH OPERATOR SIDE OF HRS
- 7 USE NYLON INSERTS UNDER ALL SET SCREWS ON TROLLEYS AND SLITTERS
- 8 USE THRUST WASHERS 005005 BETWEEN SNAP RING AND BLOCK TO REDUCE EXCESSIVE PLAY
- 9 SLITTER WHEEL SHALL RIDE ON CENTER OF BEARING - MNT ON GROOVE
- 10 BEARING SHALL BE 1" ABOVE THE FACE OF THE FORMER SET SCREW IN BEARING MUST BE ACCESSIBLE FROM FACE OF FORMER
- 11 ANTI-SEIZE TROLLEY BORES
- 12 POSITION BOLTS TO BE ACCESSIBLE
- 13 TO ADD ONE KEY RESET COUNTER - SEE DRAWING 5000-40

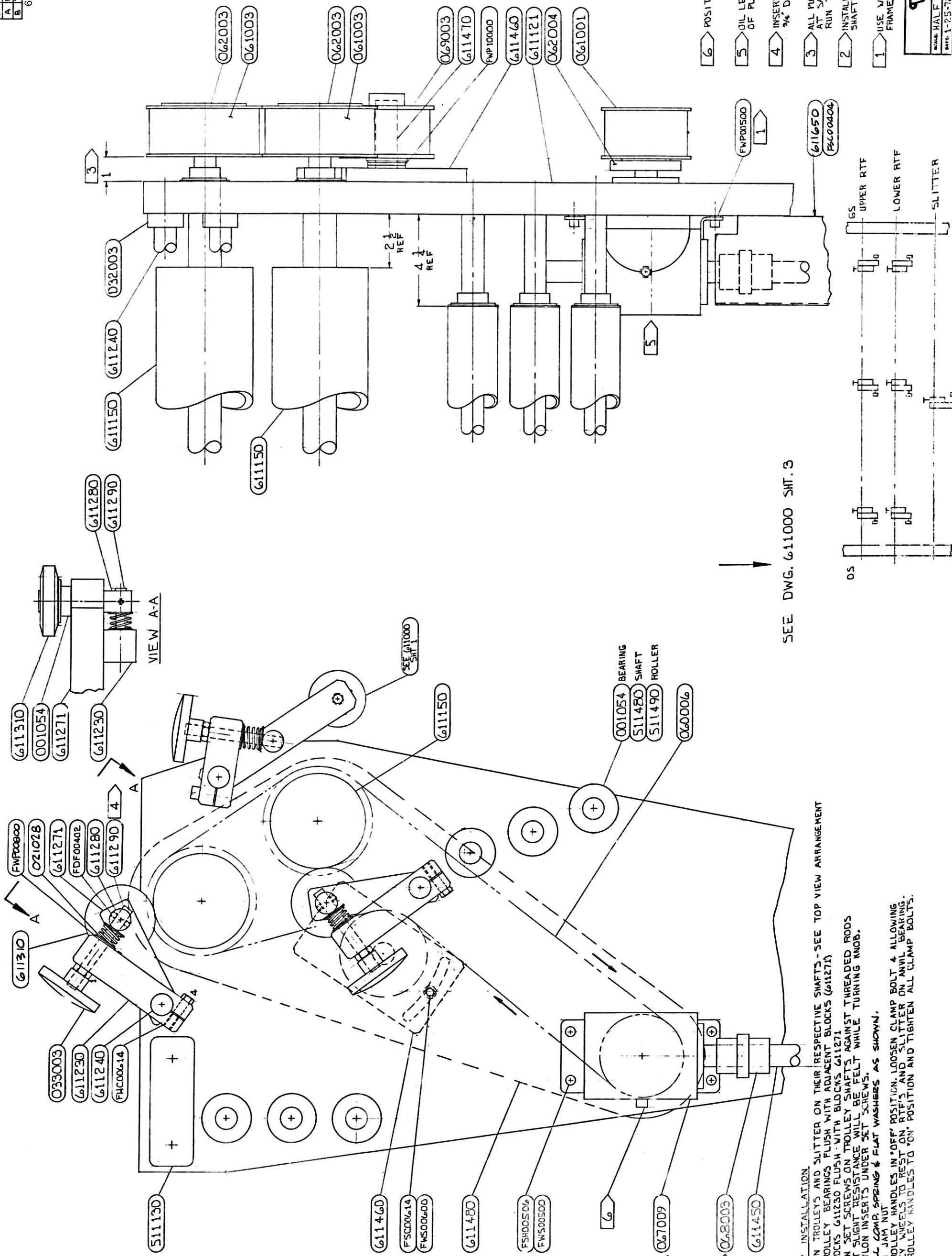
WEB PRESS LLC
 701 EAST D ST., TACOMA, WA 98002
 APPROVED BY: [Signature]
 DATE: 7-10-78
 ASSY: HEAD ROLL STAND, OPERATOR SIDE
 SHEET 1 OF 4
 611000

VIEW C-C
 SCALE: HALF

VIEW B-B
 SCALE: HALF

DETAIL A
 SCALE: HALF

SYN DATE	DESCRIPTION	BY	CHK
A 12-28-18	GEN REV SEE FILE COPY	DN	KC
B 6-19-18	001001 changed to 001054	DN	KC



SEE DWG. 611000 SHIT. 3

- TROLLEY INSTALLATION**
1. POSITION TROLLEYS AND SLITTER ON THEIR RESPECTIVE SHAFTS - SEE TOP VIEW ARRANGEMENT
 2. SET TROLLEY BEARINGS FLUSH WITH ADJACENT BLOCKS (611271)
 3. SET BLOCKS 611230 FLUSH WITH BLOCKS 611271
 4. TIGHTEN SET SCREWS ON TROLLEY SHAFTS AGAINST THTHREADED RODS SO THAT SLIGHT RESISTANCE WILL BE FELT WHILE TURNING KNOB. USE NYLON INSERTS UNDER SET SCREWS.
 5. INSTALL COMP. SPRING & FLAT WASHERS AS SHOWN.
 6. TIGHTEN JAM NUT
 7. PUT TROLLEY HANDLES IN "OFF" POSITION. LOOSEN CLAMP BOLT 4 ALLOWING TROLLEY WHEELS TO REST ON RTF'S AND SLITTER ON ANVIL BEARING. PUT TROLLEY HANDLES TO "ON" POSITION AND TIGHTEN ALL CLAMP BOLTS.

- 1 USE WASHERS BETWEEN GEARBOX AND SIDE FRAME TO OBTAIN BELT ALIGNMENT
- 2 INSTALL COUPLINGS SO THAT VERTICAL SHAFT HAS .010 END PLAY
- 3 ALL PULLEYS AND IDLER MUST BE SET AT SAME DISTANCE FOR BELT TO RUN TRUE
- 4 INSERT THREADED ROD INTO HANDLE.
- 5 OIL LEVEL TO BE EVEN WITH BOTTOM OF PLUG - BOTH GEARBOXES
- 6 POSITION VENT PLUG ON THIS SIDE

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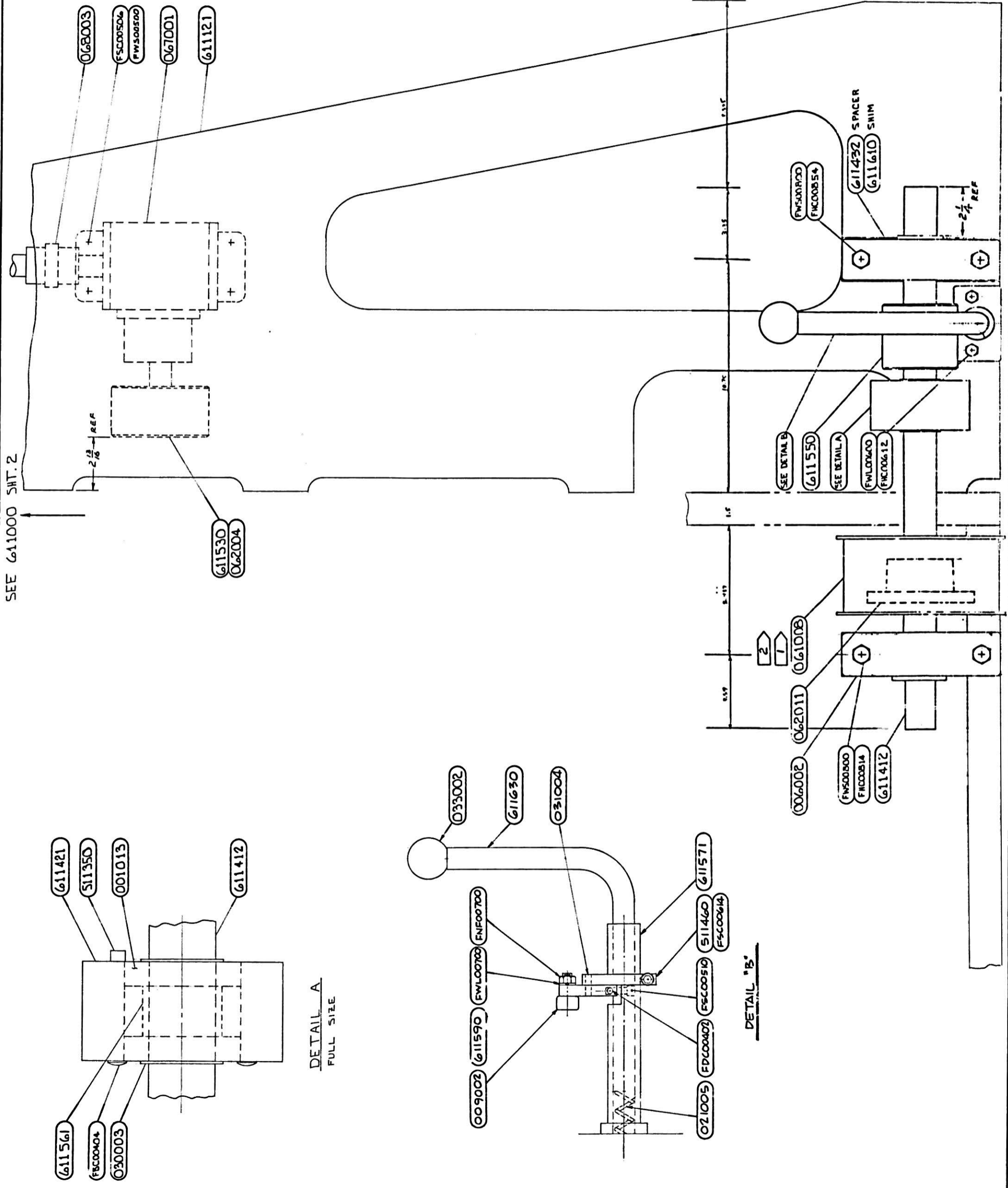
DATE: 1-25-18
 DRAWN BY: [Name]
 REVISED BY: [Name]

ASSY, HEAD ROLL STAND, GS, UPPER

SHEET 2 OF 4 611000

TROLLEY & SLITTER ARRANGEMENT
 TOP VIEW - NO SCALE

DATE	REVISION
10-11-17	611000 SHT. 2



DETAIL A
FULL SIZE

DETAIL B

2 PULLEY ON THE MOTOR (NOT SHOWN) TO BE SET AS CLOSE TO THE MOTOR AS POSSIBLE. USE SOCKET HEAD CAP SCREWS FOR INSTALLATION.

1 USE STRAIGHT EDGE TO LINE THIS PULLEY WITH THE ONE ON THE MOTOR.

WEB PRESS LLC
701 EAST 10 ST., TACOMA, WA 98002

DATE: 6-16-17
DRAWN BY: [Name]
CHECKED BY: [Name]

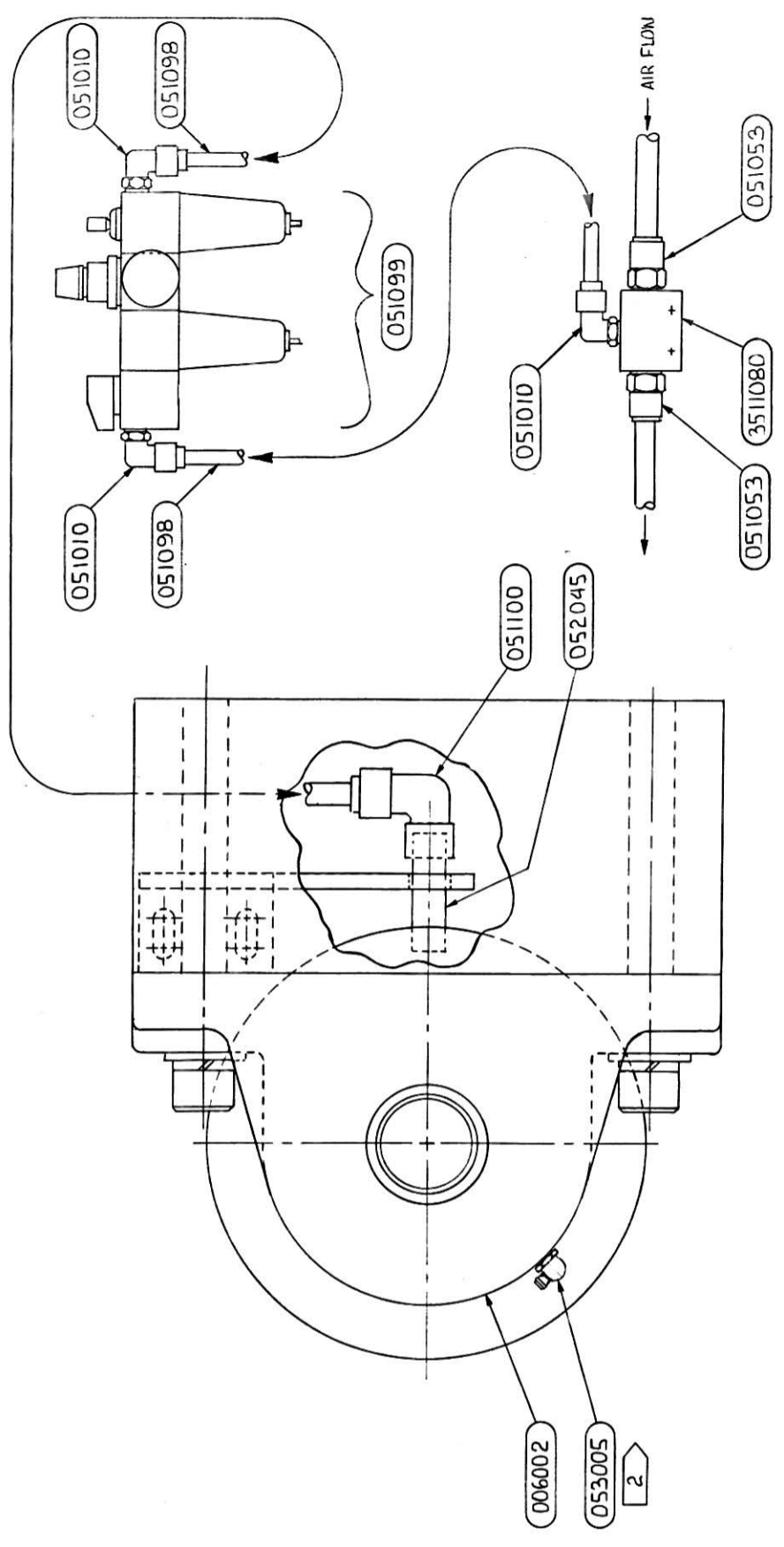
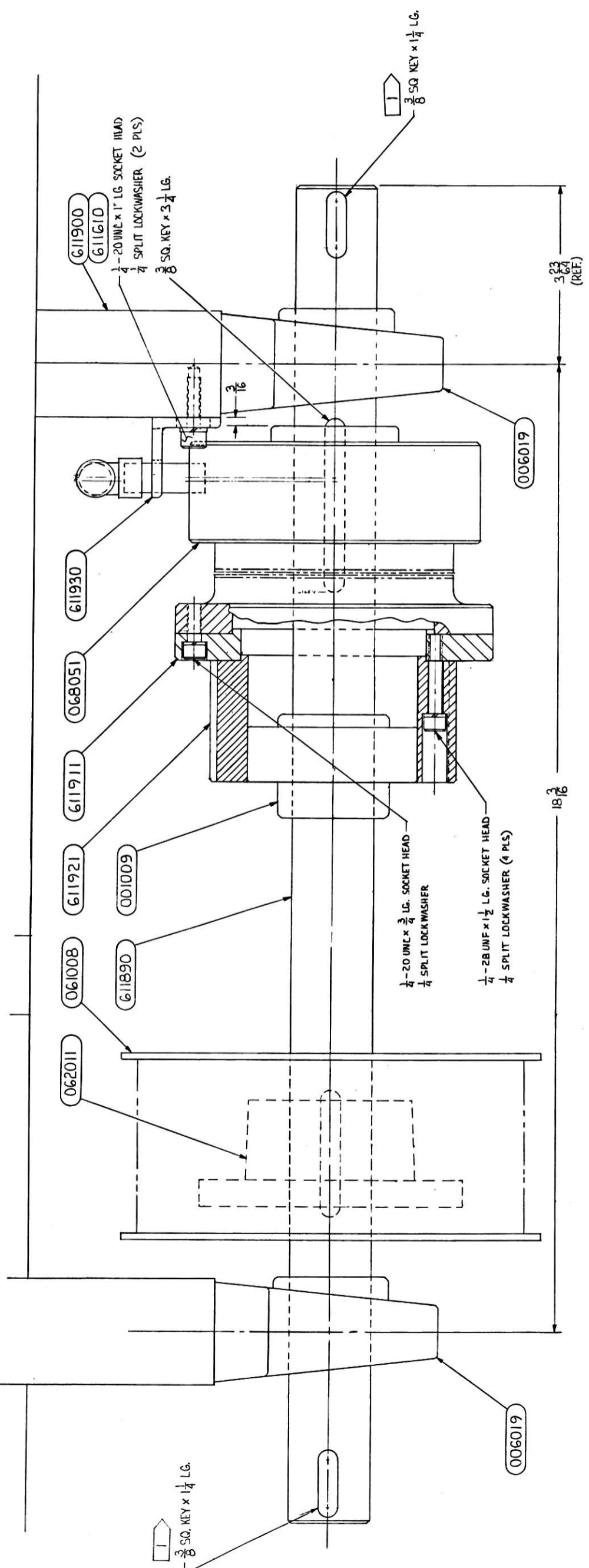
HEAD ROLL STAND ASSY, G.5

SHT 3 OF 4
611000

**WEB LEADER FOLDER
FOLDER 5H45 DRIVE AIR CLUTCH 611001A5**

PART NO.	DESCRIPTION	QTY. REQ'D
001009	ER-24 BEARING	1
006019	PILLOW BLOCK, 1-1/2" CENTRIK-LOK	2
051010	SWIBEL ELBOW 1/4NPT X 1/4T 2F	3
051098	1/8 X 1/4 OD TUBING (FEET) 2I	10
051099	FILTER / REGULATOR / LUBE 2I	1
051100	FEMALE ELBOW 1/4T OD X 1/8 2I	1
052045	NIPPLE 1/8 X 1-1/2 STEEL 2J	1
053005	GREASE FITTING 1/8 X 90 DEGREE NA	2
068051	AIR CLUTCH, 5H 45 1-1/2" BORE	1
611891	SHAFT 5H45	1
611911	ADAPTER 5H45 CLUTCH	1
611921	SHEAVE WEB LEADER FOLDER 5H45	1
611930	BRACKET	1
611610	SHIM	1
3511080	MANIFOLD	1

DATE	BY	REVISION



- 1 INSTALL KEY TO SHIFTS & TAPE IN PLACE
- 2 REPLACE GREASE FITTING WITH 90° FITTINGS.

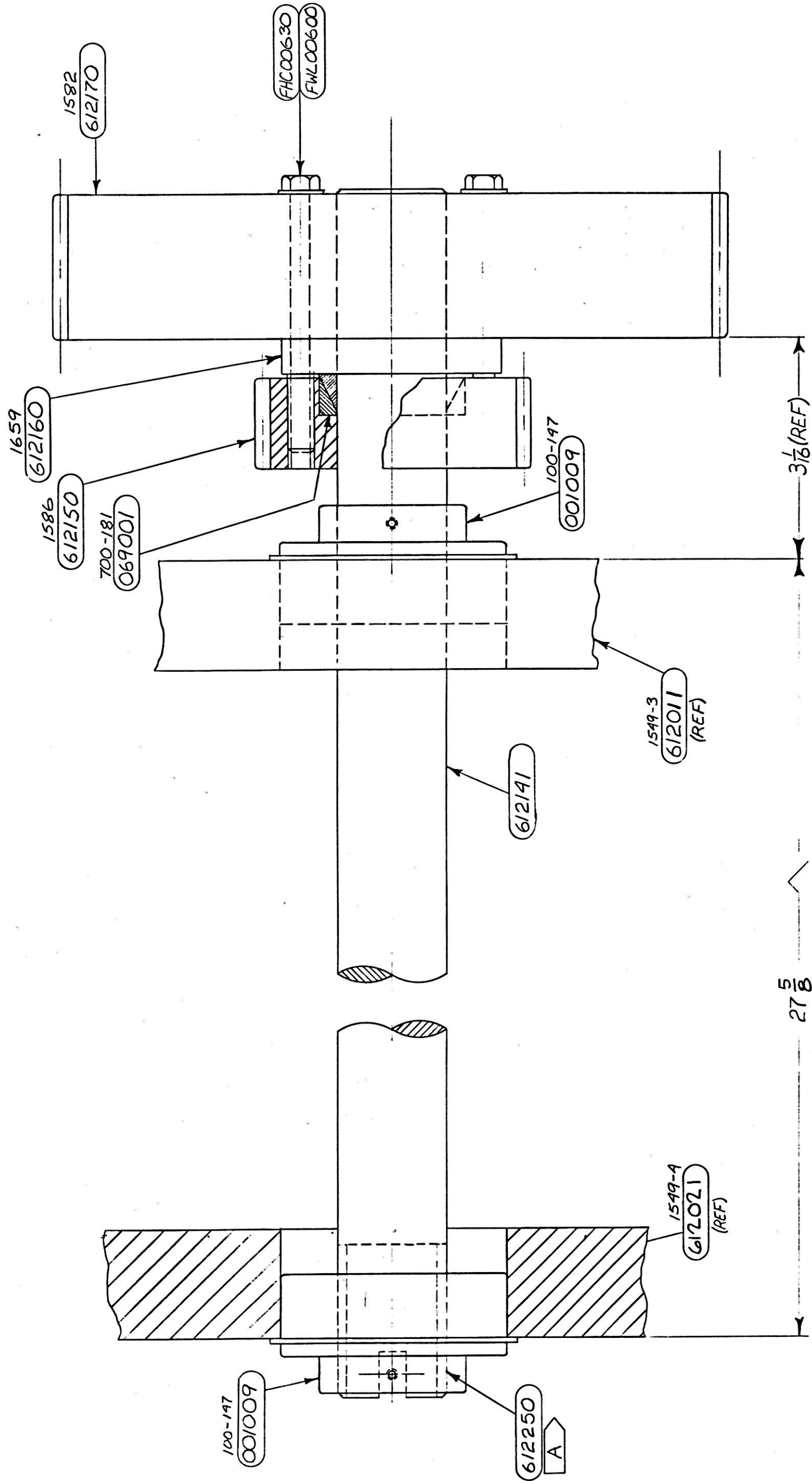


Half Fold Frames & Drive

**WEB LEADER FOLDER
HALF FOLD FRAMES AND DRIVE 612000**

PART NO.	DESCRIPTION	QTY. REQ'D
001009	BEARING, ER-24	2
001054	BEARING, ER -16X	2
060003	BELT, 1/2P x 2" W x 140" LG	1
069001	RINGFEDER 38 x 44	2
069002	BRACKET, IDLER, 3-1/8	2
069003	IDLER, 4" DIA. 1" HOLE	2
069004	IDLER SHAFT, 1" DIA x 3-1/8	2
511260	LEVELING BOLT	4
612013	HALF FOLD FRAME, G.S.	1
612022	HALF FOLD SIDE FRAME, O.S.	1
612030	STIFFENER, HALF FOLD FRONT	1
612040	STIFFENER, HALF FOLD MIDDLE	1
612110	SCREW PAD TAKE UP	1
612130	SPACER, IDLER	2
612141	SHAFT, MAIN INPUT	1
612150	PINION GEAR	1
612160	SPACER, MAIN INPUT PULLEY	1
612170	PULLEY, MAIN INPUT	1
612210	DECAL, "DO NOT REVERSE"	2
612220	SHAFT, Q.F. PIVOT	1
612250	SLEEVE, MAIN INPUT SHAFT	1
612260	SCREW PAD TAKE UP	1
613010	PREFORM ROLLER	1
616410	SHAFT, STIFFENER	1

WK DATE: A 7-17-78
 REVISION: REDRAWN
 BY: MH
 APP: MH



A USE LOCKTIGHT #271 TO ATTACH SLEEVE 612250 TO SHAFT 612141

WEB PRESS LLC
 701 EAST D ST., TACOMA, WA 98002
 SCALE: FULL
 DATE: 7-17-78
 DRAWN BY: MH
 REVISED: DFL/KATE
 APPROVED BY:
 ASSEMBLY: MAIN INPUT SHAFT
 DRAWING NUMBER: 612000

WEB LEADER FOLDER
HALF FOLD ASSEMBLY OPTION: 25K 612000A3B

PART NO.	DESCRIPTION	QTY. REQ.D
061044	24T X 7/8P X 3" W WITH TAPER BUS2N	1
060021	7/8"P X 3"W X 56" LONG TIMING BELT 2L	1

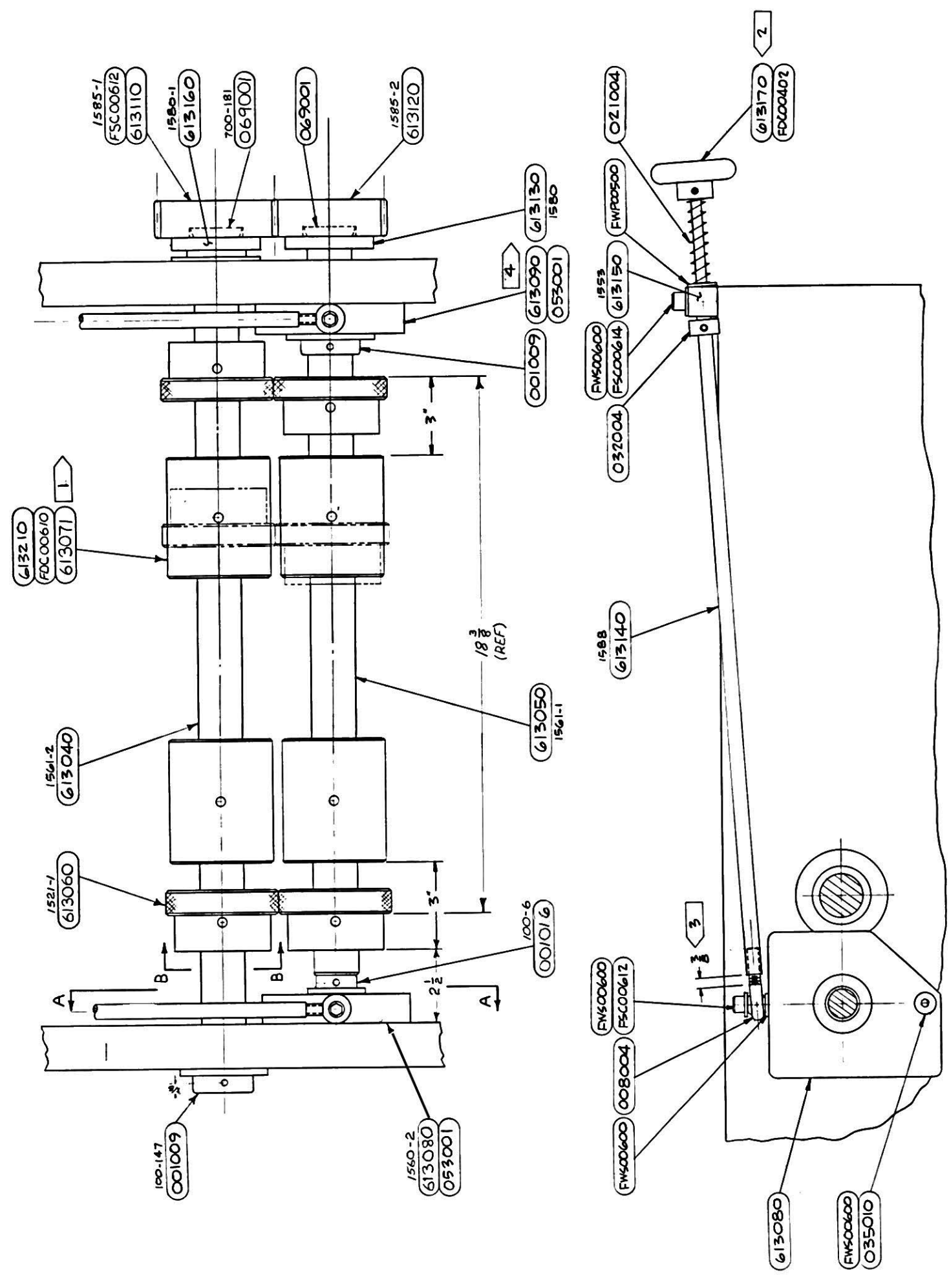


Pre-Form

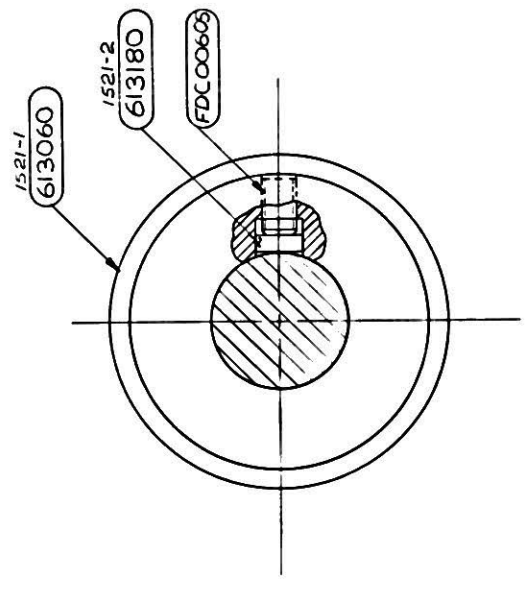
Nip Rolls

**WEB LEADER FOLDER
PREFORM NIP ROLLS 613001**

PART NO.	DESCRIPTION	QTY. REQ'D
613040	SHAFT, NIP ROLL STATIONARY	1
613050	SHAFT, NIP ROLL MOVEABLE	1
613060	NIP ROLL	4
613071	SPACER, PINCH ROLL H.F.	4
613080	PLATE, NIP ROLL SWING O.S.	1
613090	PLATE, NIP ROLL SWING G.S.	1
613110	GEAR, NIP ROLL	1
613120	GEAR, NIP ROLL R.H.	1
613130	CAP, NIP ROLL GEAR	1
613160	CAP, NIP ROLL GEAR	1
613180	PELLET, NIP ROLL	4
613210	ROD, INSERT PINCH ROD	4
001016	BEARING, ER-16	1
001009	BEARING, ER-24	3
035010	SHOULDER BOLT, 1/2 x 1-1/8 LG	2
053001	LUBE FITTING, 1/4-28	2
069001	RINGFEDER 38 X 44	4
STANDARD PREFORM AND NIP 613001A1		
613140	ROD, NIP ROLL ADJUST	2
613150	BAR, NIP ROLL ADJUST	1
613170	KNOB, NIP ROLL ADJUST	2
008004	3/8 ID 3/8-24 MALE	2
021004	SPRING (BLUE) 5/8 x 4" LG	2
032004	SET COLLAR, 1/2 x 1"	2



VIEW B-B
 (FULL SCALE)
 TYP



- 1 USE BRASS INSERT (613210) UNDER SET SCREWS
- 2 PUSH HANDLE TO END OF ROD AND FASTEN SET SCREW.
- 3 TURN HANDLE UNTIL DIM. AS SHOWN IS REACHED. SLIDE SET COLLAR AGAINST BAR 613150 AND FASTEN.
- 4 USE UPPER TAP HOLE (FOR GREASE FITTING) WHEN USING SEALMASTER BEARING, USE LOWER TAP HOLE FOR NTN BEARING. PLUG EXTRA HOLE WITH 1/4-28 X 1/16 SET SCREW.

NOTE:
 1. FOR LINEAR PERFORATOR ASSY. SEE 724000

VIEW A-A

WEB PRESS LLC
 701 EAST ST., TACOMA, WA 98002

DATE: 1-18-18
 DRAWN BY: JHP
 APPROVED BY: [Signature]
 PART NUMBER: 613001
 ASSEMBLY: NIP ROLLS, H.F.



Knife

Cylinder

**WEB LEADER FOLDER
KNIFE CYLINDER 614000**

PART NO.	DESCRIPTION	QTY. REQ'D
614020	GEAR, KNIFE CYLINDER	1
614050	BRACKET, KNIFE CYLINDER TIMING	1
614101	KNIFE BOX ASSEMBLY	1
614111	BAR, CUTTING KNIFE	1
614121	BAR, CUTTING KNIFE	1
614131	CHEEKWOOD	1
614140	CHEEKWOOD, CUTTING KNIFE	1
614150	CHEEKWOOD, CUTTING KNIFE	1
614160	CHEEKWOOD, CUTTING KNIFE	1
614170	CHEEKWOOD, CUTTING KNIFE	4
021012	COMPRESSION SPRING	16
090322	CUT OFF KNIFE, 20" X 2-1/8" (SINGLE PIECE)	1
001014	BEARING, ER-36	2
611621	COUNTER PICK-UP	1
80640213	BOLT / HEX SCREW	8

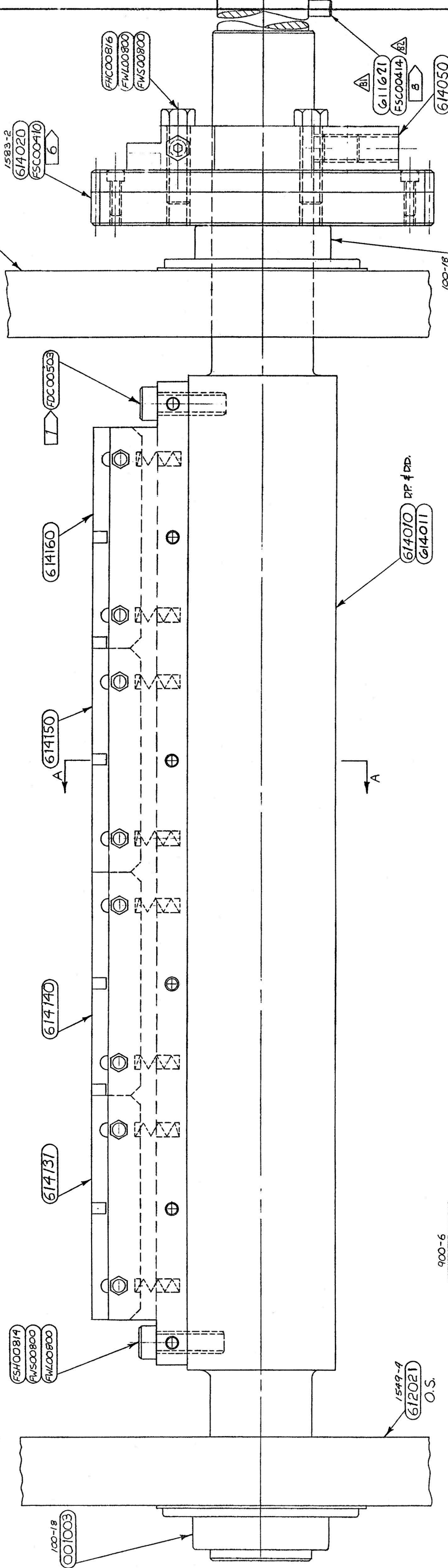
STANDARD KNIFE CYLINDER 614000A1

614011	CYLINDER, CUTTING KNIFE	1
614080	COUNTER WEIGHT	1

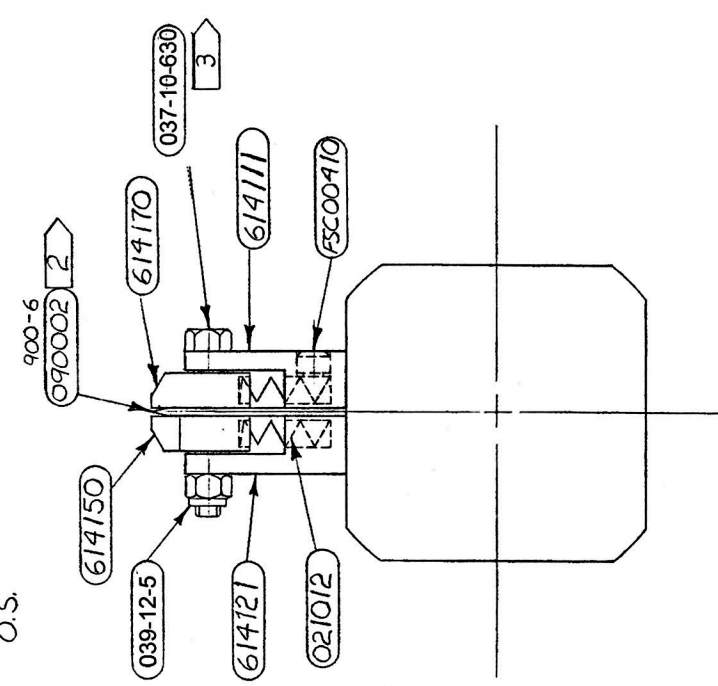
NOTE:

090002 4-PIECE CUTTING KNIFE (REPLACES 090322) MUST ORDER 4 FOR A SET

REV	DATE	DESCRIPTION
A	8-27-78	PERF. DRAWING - SEE FOLDER COPY
B	1/10/88	(1) WAS 611620 (2) WAS FSC00414
C	12/19/17	Removed note 7; added 037-10-630 & 038-12-5



- 1 INSERT PIECES OF NYLON ROD UNDER THE SET SCREWS
 - 2 INSTALL KNIVES FLUSH WITH BOTTOM OF BOX
 - 3 BOLTS TO BE TIGHT, BUT CHEEK WOOD TO MOVE FREELY
 - 4 UPON ATTACHING KNIFE BOX TO CYLINDER, ENSURE THAT SLOTS IN CHEEK WOOD LINE UP WITH PICKER PINS. MOVE ENTIRE CYLINDER IF NECESSARY. CHECK IF GEAR & TIMING BRACKET ARE IN PLACE. INSTALL RETAINING RING.
 - 5 KNIFE CYLINDER TO BE INSTALLED AFTER JAW FOLDER DRUM AND JAW CYLINDER ARE IN PLACE.
 - 6 ROTATE THE RING AND TAKE BACKLASH OUT OF GEAR AFTER IT IS TIMED PROPERLY
- (7 removed 12/17)
- 8A USE RED LOCITE ON INSTALLATION.



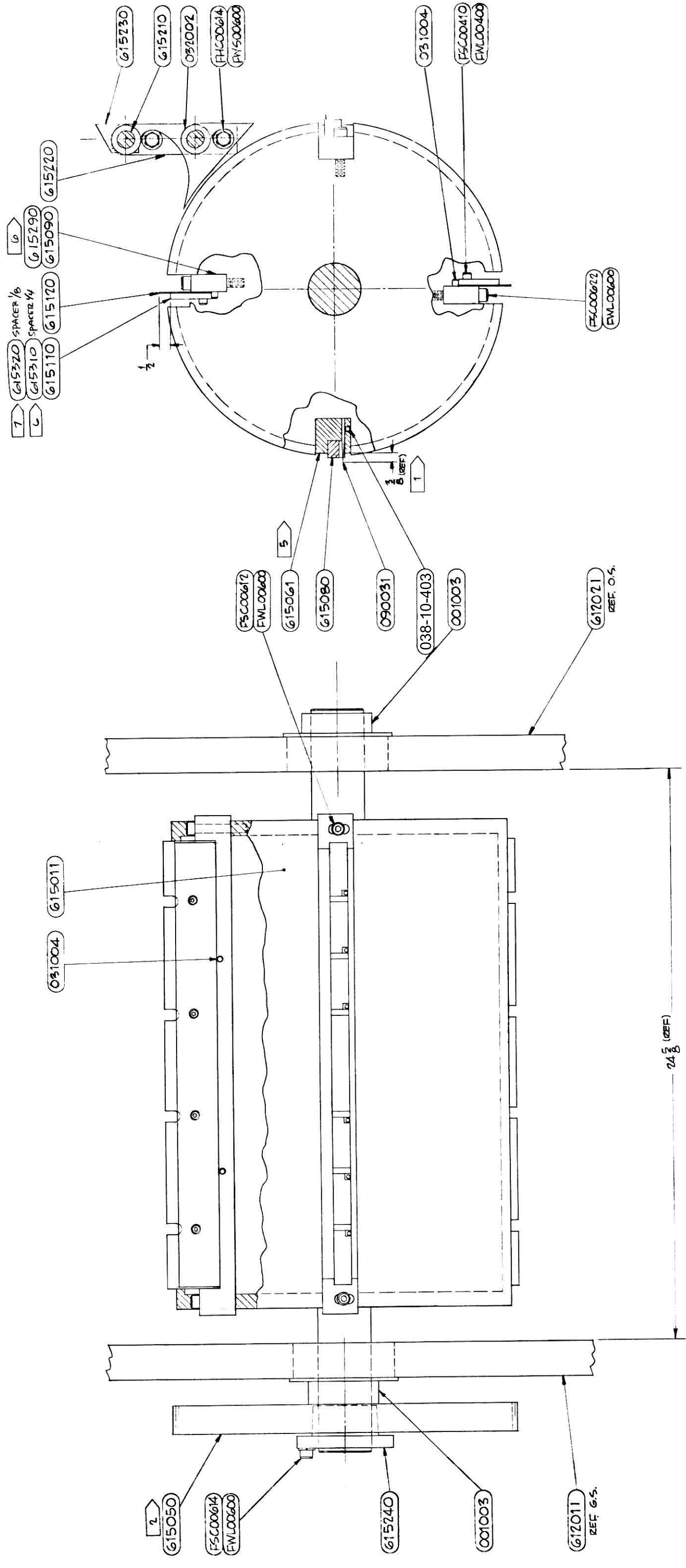
WebPress
Revolutionary™

Pin

Cylinder

**WEB LEADER FOLDER
PIN CYLINDER 615000**

PART NO.	DESCRIPTION	QTY. REQ'D
615050	BULL GEAR	1
615080	CUTTING RUBBER (YELLOW)	2
615090	BAR, TUCKER BLADE SUPPORT	2
615110	BAR, TUCKER BLADE BACKING	2
615210	SHAFT, PICKER PIN STRIPPER	2
615220	BRACKET, PICKER PIN STRIPPER	2
615240	BUSHING, BULL GEAR	1
001014	BEARING, ER-16	2
031004	ROLL PIN, 1/4 DIA x 1" LG	4
032002	SET COLLAR, 3/4 x 1-1/4	28
090031	PICKER PIN	12
STANDARD PIN CYLINDER 615000A1		
615011	DRUM, PIN CYLINDER	1
STANDARD PIN CYLINDER 615000A2		
615061	BAR, PIN MOUNTING	2
STANDARD PIN CYLINDER 615000A3		
615120	TUCKER BLADES	2
615230	STRIPPER, PICKER PIN	6



- 3 ADJUST DRUM POSITION SO THAT PICKER PINS ARE CENTERED IN THE SLOTS OF THE JAW CYLINDER.
- 2 INSTALL GEAR FLUSH WITH THE BENDING 3/8 AFTER DRUM IS ADJUSTED AND SET.
- 1 PICKER PINS TO PROTRUDE 3/8 ABOVE PIN BOX TOP AND BE CENTERED IN RUBBER CUTOUTS.
- 7 FOR 1/8 LAP TRIM
- 6 REPLACES G15090 FOR 1/4 REVERSE LAP
- 5 ENSURE EASY REMOVAL OF PIN MTG. RINGS.
- 4 JAW FOLDER DRUM TO BE SET AFTER THE JAW CYLINDER IS INSTALLED (BUT BEFORE KNIFE CYL.)

WEB PRESS LLC
 701 EAST 10 ST., TACOMA, WA 98002

SCALE: HALF
 DATE: 6-5-75
 APPROVED BY:
 DRAWN BY:
 REVISED:

DRUM ASSY - JAW FOLDER

615000

WebPress
Revolutionary™

1st Jaw

Cylinder

**WEB LEADER FOLDER
JAW CYLINDER 616000A1**

PART NO.	DESCRIPTION	QTY. REQ'D
616111	JAW CYLINDER	1

JAW CYLINDER 616000A2

053001	LUBE FITTING, 1/4-28 STRAIGHT	1
090298	O-RING, 3" ID x 1/8 WALL	1
090272	O-RING, 4-1/8 ID x 1/8 WALL	1
616160	BUSHING	2
616170	SUPPORT, JAW BAR CAM SIDE	1
616180	SUPPORT, JAW BAR GEAR SIDE	1
616190	JAW BLADE	8
616210	JAW, STATIONARY	1
616430	BRACKET, JAW CAM FOLLOWER	1
636120	JAW BAR	1
636130	PLUNGER, JAW CYLINDER	2
616440	BLADE, JAW	8
009002	CAM FOLLOWER, 7/16-20 x 1" OD	1
021050	BLUE SPRING, 5/8 x 2-1/2	2
031022	DOWEL PIN, 5/16 x 1-3/4	2
616280	GEAR, JAW CYLINDER	1
616290	PULLEY, MAIN DRIVE Q.F.	1
616310	CAM, JAW CYLINDER	1
616320	CAP, JAW CYLINDER CAM	1
001002	BEARING, ER-18	1
001014	BEARING, ER-36	1
616410*	SHAFT, STIFFENER	2
616420*	STRIPPER, JAW CYLINDER	7
032003*	SET COLLAR, 1" x 1-5/8	28

* Reference Sheet 3 of Assembly Drawing 617000



Quarter

Fold

**WEB LEADER FOLDER
QUARTER FOLD ASSEMBLY 617000**

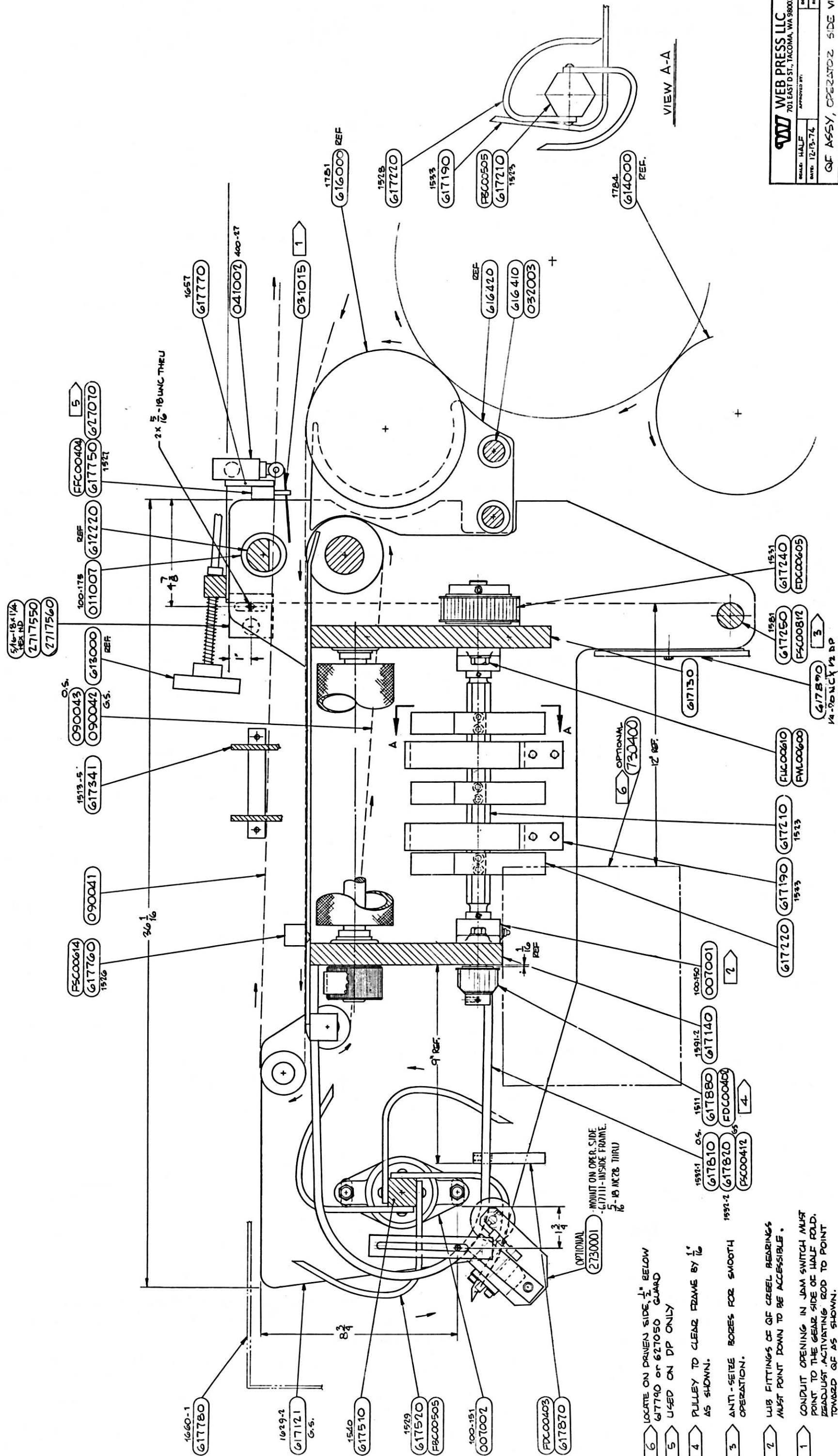
PART NO.	DESCRIPTION	QTY. REQ'D
001016	BEARING, ER-16	6
001006	BEARING	2
001008	BEARING	4
003001	BEARING	3
007001	FLANGE BEARING, 3/4 ID	2
007002	FLANGE BEARING, 1-1/4 ID	2
009003	CAM FOLLOWER, 3/8-24 x 3/4 OD	1
009004	CAM FOLLOWER, 3/4-16 x 1-3/4 OD	1
011007	BUSHING, 1-1/2 x 2 x 1" LG	2
011008	BUSHING, 1-1/4 x 1-1/2 x 1"	2
011016	BUSHING, 5/8 ID x 1" OD x 1" LG	2
011057	BUSHING, 3/8 x 1/2 x 1/2 LG.	1
031002	ROLL PIN, 1/4 x 5/8	4
031014	ROLL PIN, 3/8 x 2"	2
031015	ROLL PIN, 1/4 x 1-3/4 LG	4
032005	SET COLLAR, 5/16 x 5/8	4
032006	SET COLLAR, 1-1/4 x 2"	2
041002	MICRO SWITCH, BZE6-2RQ62	1
060004	BELT, 3/8P x 1"W x 24" LG	1
060005	BELT, 3/8P x 1/2W x 48 LG	1
513270	KNOB	2
617111	SIDE PLATE, Q.F. OS	1
617121	SIDE PLATE, Q.F. GS	1
617130	END PLATE, Q.F. REAR	1
617140	END PLATE, Q.F. FRONT	1
617150	BLOCK, Q.F. PLATE	1
617160	SUPPORT, TOP PLATE	2
617190	STRIPPER, Q.F.	2
617210	SHAFT, Q.F. CREEL	1
617220	BLADE, Q.F. CREEL	6
617230	PINION, CREEL DRIVE Q.F.	1
617240	PULLEY, CREEL DRIVE Q.F.	1

**WEB LEADER FOLDER
QUARTER FOLD ASSEMBLY 617000**

PART NO.	DESCRIPTION	QTY. REQ'D
617250	SHAFT, SIDE FRAME STOP	1
617260	PINCH ROLL, Q.F.	2
617270	PLATE, PINCH ROLL SWING	2
617290	PIN, PINCH ROLL SWING PLATE	2
617310	PULLEY, Q.F. PINCH ROLL	2
617320	SHAFT, CHOPPER DRIVE	1
617330	PULLEY, CHOPPER DRIVE	1
617341	ARM, CHOPPER	1
617351	PLUG, CLAMPING CHOPPER ARM	2
617361	PLUG, TIE IN CHOPPER ARM	2
617390	SUPPORT, CHOPPER BLADE	1
617410	CHOPPER BLADE	1
617420	SHAFT, CHOPPER PIVOT	1
617430	ARM, CHOPPER ARM	1
617440	KEY, CHOPPER PIVOT SHAFT	1
617450	BRACKET, WIDE IDLER	1
617460	IDLER, WIDE DRIVE BELT Q.F.	1
617470	STUD, WIDE IDLER	1
617480	SPACER, WIDE IDLER	1
617540	PULLEY, CREEL DRIVE	1
617550	SPACER, CREEL BEARING	2
617560	SHAFT, BOTTOM TAPE DRIVE	1
617570	PULLEY, BOTTOM TAPE DRIVE	1
617590	STUD, TAPE TENSION SHORT	1
617610	STUD, TAPE TENSION LONG	1
617620	PLATE, BELT TENSION Q.F.	1
617630	SHAFT, BELT IDLER Q.F.	1
617640	BELT, TENSIONER PULLEY	2
617650	SPACER, Q.F. BELT IDLER	4
617670	BRACKET, TENSION LOWER TAPE	2
617680	HANDWHEEL, SIDE MOVEMENT	1
617690	SCREW, SIDE MOVEMENT	1

**WEB LEADER FOLDER
QUARTER FOLD ASSEMBLY 617000**

PART NO.	DESCRIPTION	QTY. REQ'D
617710	BRACKET, CREEL IDLER	1
617720	STUD, CREEL IDLER LONG	1
617730	STUD, CREEL IDLER SHORT	1
617740	BRACKET, Q.F. TAPE IDLER	1
617760	Q.F. STOP BAR	1
617770	JAM SWITCH BRACKET	1
617810	STRIPPER, H.F. OS	1
617820	STRIPPER, H.F. GS	1
617831	SHAFT, PINCH ROLL ADJUST Q.F.	2
617870	SQUARING STOP, DELIVERY CREEL	4
617880	PINION, CREEL DRIVE Q.F.	1
OPTION: STANDARD QUARTER FOLD CREEL 617000A1		
617510	SHAFT, CREEL DELIVERY	1
617520	BLADE, CREEL HALF FOLD DELIVERY	12
OPTION: STANDARD FOLDER 617000A2		
617170	TOP PLATE QUARTER FOLD, OPERATOR SIDE	1
617180	TOP PLATE QUARTER FOLD, GEAR SIDE	1
617580	PULLEY, BOTTOM TAPE	2
617750	BAR, TAPE GUIDE	1
021013	COMPENSATOR SPRING 5/8" O.D. X 3" LG 1G	2
060007	½" P X 1" W X 125" LONG BELT 2K	1
090041	PRE-SKIVED TOP TAPE TP-10	2
090042	LOWER TAPE GEAR SIDE, QUARTERFOLD DELIVERY TAPE	1
090043	LOWER TAPE OPERATOR SIDE, QUARTERFOLD DELIVERY TAPE	1



VIEW A-A

- 6 LOCATE ON DRIVEN SIDE, 1/2" BELOW 61790 OR 627050 GUARD USED ON DP ONLY
- 5 PULLEY TO CLEAR FRAME BY 1/16" AS SHOWN.
- 4 ANTI-SLIP ROSES FOR SMOOTH OPERATION.
- 3 LUB FITTINGS OF QF REEL BEARINGS MUST POINT DOWN TO BE ACCESSIBLE.
- 2 CONDUIT OPENING IN JAM SWITCH MUST POINT TO THE GEAR SIDE OF HALF FOLD. ADJUST ACTIVATING ROD TO POINT TOWARD QF AS SHOWN.

WEB PRESS LLC
 701 EAST ST., TACOMA, WA 98002

DESIGNED BY: Y.L.P.C.
 DRAWN BY: Y.L.P.C.
 DATE: 12-13-74
 APPROVED BY: [Signature]

QF ASSY, OPERATOR SIDE VIEW
 PART: 617000



Delivery Table

**WEB LEADER FOLDER
6' DELIVERY TABLE 618003**

PART NO.	DESCRIPTION	QTY. REQ'D
618110	TUBE DELIVERY TABLE	1
618082	PLATE, ADJUST DELIVERY TABLE	1
618090	SHAFT ROLLER	2
618131	SPACER	4
618141	FINGERS, DELIVERY CATCHER	3
618180	DELIVERY TABLE	1
618251	SPROCKET, DELIVERY TABLE	1
618260	TUBE ASSEMBLY	1
618230	TUBE ROLLER	1
618240	SPROCKET, DRIVEN	1
064009	SPROCKET, 20T X ½" P	1
618270	GUARD	1
001016	BEARING, ER-16	4
031004	ROLL PIN, ¼" DIAMETER X 1" LONG BS	8
040410	¼ HP MOTOR, 180 RMP, 90 VOLT, 3XA84	1
063005	CONNECTING LINK #41 CHAIN 2P	1
063008	#41CHAIN ½ P (LINKS).	26
090046	DEXON TAPE 1-1/2" W X 142" L	4
OPTION: WEB LEADER DELIVERY TABLE 618002A2		
618041	LEG – DELIVERY TABLE	2
618011	LEG ASSEMBLY, DELIVERY TABLE	4
618280	LEG – DELIVERY TABLE	2

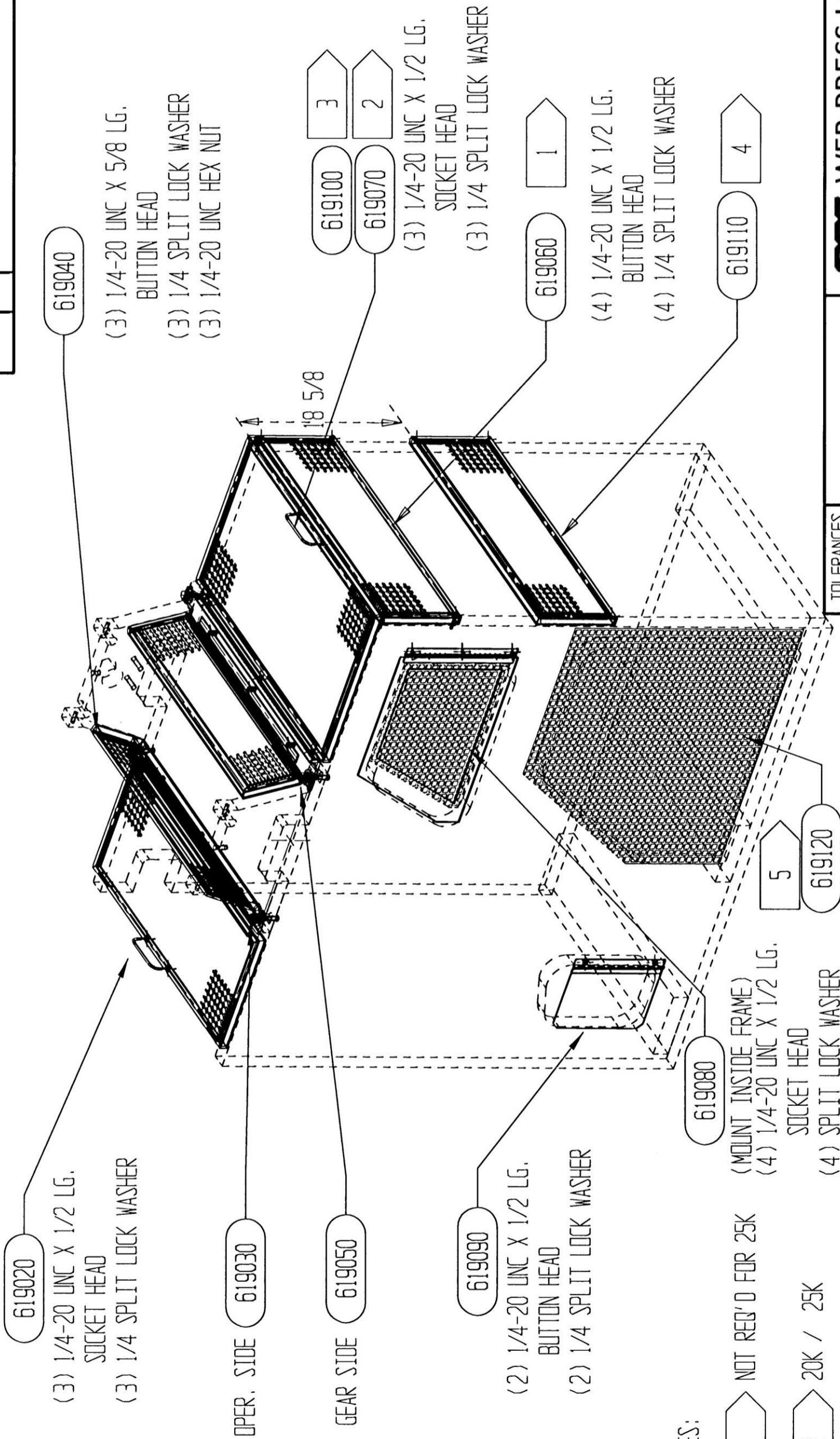


Guards

**WEB LEADER FOLDER
FOLDER GUARDS 619000**

PART NO.	DESCRIPTION	QTY. REQ.D
611650	GUARD, HRS GEAR BOX CONNECTOR	1
611661	SUPPORT, HRS BOTTOM GUARD	1
617780	GUARD, DELIVERY (HALF FOLD CREEL)	1
617790	GUARD	1
617860	CHOPPER GUARD	1
OPTION: STANDARD / DD. 20K GUARDS 619000A1		
611480	GUARD, RTF DRIVE	1
611491	GUARD, HRS OPERATOR SIDE HINGED DOOR	1
611640	GUARD HRS GEAR SIDE HINGED DOOR	1
612181	GUARD, HALF FOLD, TOP	1
612190	GUARD, DRIVELINE & CLUTCH	1
OPTION: NIP GUARDS 619000A4		
090057	MAGNETIC LATCH	2
619020	GUARD, HALF FOLD TAPES	1
611123	MOUNT NIP GUARDS, OPERATOR SIDE	1
619040	GUARD, NIP ROLL	2
619050	MOUNT, NIP GUARDS, GEAR SIDE	1
619080	GUARD, DOOR TOP, HALF FOLD	1
619090	GUARD, DOOR	1
OPTION: GUARD 20K – 25K 619000A4B3		
619060	GUARD, HALF-FOLD, GEAR SIDE	1

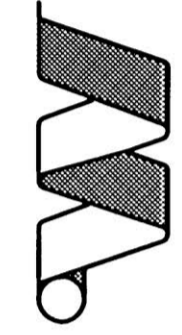
REVISION RECORD		DR.	CK.
DATE	SYM		
1/17/01	A	SAME AS A1548-10. CN#1439	WEN



NOTES:

- 1 NOT REQ'D FOR 25K
- 2 20K / 25K
- 3 25K ONLY WITH STIFFENER
- 4 LINE 2 20K/25K
- 5 USED WITH MOTOR OUT OF FRAME

TOLERANCES (EXCEPT AS NOTED)	
DECIMAL	± .01
.XX ±	± .005
FRACTIONAL	± 1/32
ANGULAR	± 1 Deg



WEB PRESS LLC
701 EAST D ST., TACOMA, WA 98002

TITLE
NIP GUARDS, W.L. FLDR.

WEB LEADER
DRAWN BY **W.E.N.**

DWG NO. **61900A4**

SCALE XXXXX DATE 1-17-01 SIZE B REV A

Web Press Corporation Proprietary Information
This document contains trade secrets protected by the Uniform Trade Secrets Act (REV. 19.108).



Droop Snoot

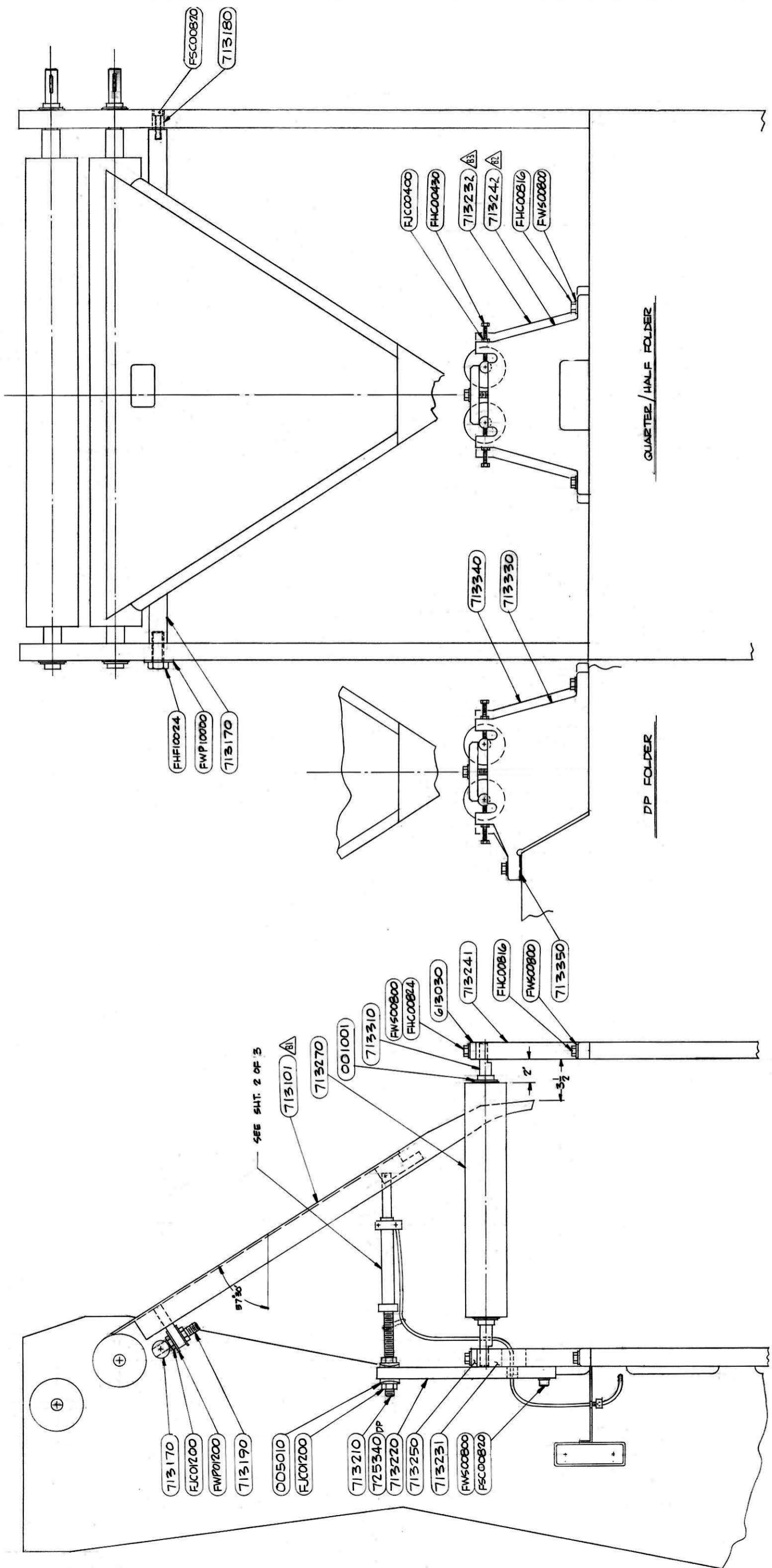
Former

WEB LEADER FOLDER
DROOP SNOOT FORMER 713000

PART NO.	DESCRIPTION	QTY. REQ'D
613030	PREFORM ROLL BRACKET	1
713170	SHAFT, FORMER MOUNTING	1
713180	MOUNTING SHAFT BOSS	1
713190	FORMER MOUNTING SCREW	2
713210	SHAFT, FORMER ADJUST	1
713220	PLATE, BAR ANCHOR	1
713250	BRACKET, PREFORM ROLL G.S.	1
713270	ROLLER, DROOP SNOOT FORMER	2
001054	BEARING, ER-16	4
713101	FORMER ASSEMBLY	1
1713140	BRACKET, FORMER BOARD MOUNT	2
1713150	SLEEVE, FORMER BOARD CENTERING	2
051016	TUBING	A/R
050005	MALE CONNECTOR, 1/4 T x 1/8 NPT	3
050023	ADAPTER, WATER HOSE	1
050038	REDUCER BUSHING, 1/8 x 1/2 NPT	1
052001	VALVE, PANEL MOUNT	1
052002	MICRO VALVE, 2 WAY	1
053001	LUBE FITTING, 1/4-28	1
712190	SUPPORT BLOCK	1
712210	SUPPORT BLOCK, WATER INJECTION	1
050003	NEEDLE, WATER INJECTION, 1-1/4 LG.	2
050004	NEEDLE ADAPTER	1
050031	ELBOW, MALE 1/8 NPT x 1/4 x 90	

**WEB LEADER FOLDER
STANDARD FOLDER 713000A**

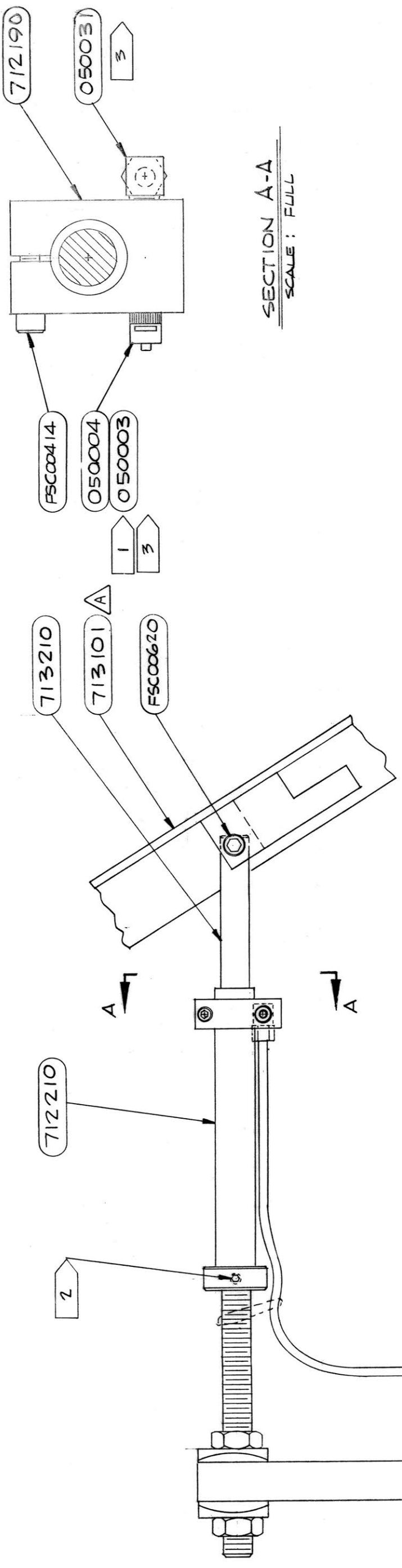
PART NO.	DESCRIPTION	QTY. REQ'D
713232	PLATE, DROOP SNOOT RISER, G.S.	1
713242	PLATE, DROOP SNOOT RISER, O.S.	1
DOUBLE PARALLEL FOLDER 713000B		
713330	PLATE, RISER, O.S.	1
713340	PLATE, RISER, G.S.	1
713350	SHIM, PLATE RISER	2
725340	FORMER, SUPPORT PLATE	1
DROOP SNOOT FORMER 61 SERIES 713000A1		
713310	SHAFT	2
DROOP SNOOT FORMER (EXTENDED) 65 SERIES 713000A2		
713370	SHAFT, FORMING ROLL	2



TOLERANCES UNLESS SHOWN OTHERWISE		WEB PRESS LLC 701 EAST D. ST. TACOMA, WA 98002	
DECIMAL	FRACTIONAL	DATE	APPROVED BY
		1/4/11	KL
TITLE		DRAWING NUMBER	
ASSY., DECOOP SNOOT FORMER		8-91-81	
SHEET		SHEET TOTAL	
1		10 OF 3	

713000

DATE	BY	REVISION
10/1/01	A	WAS 713100



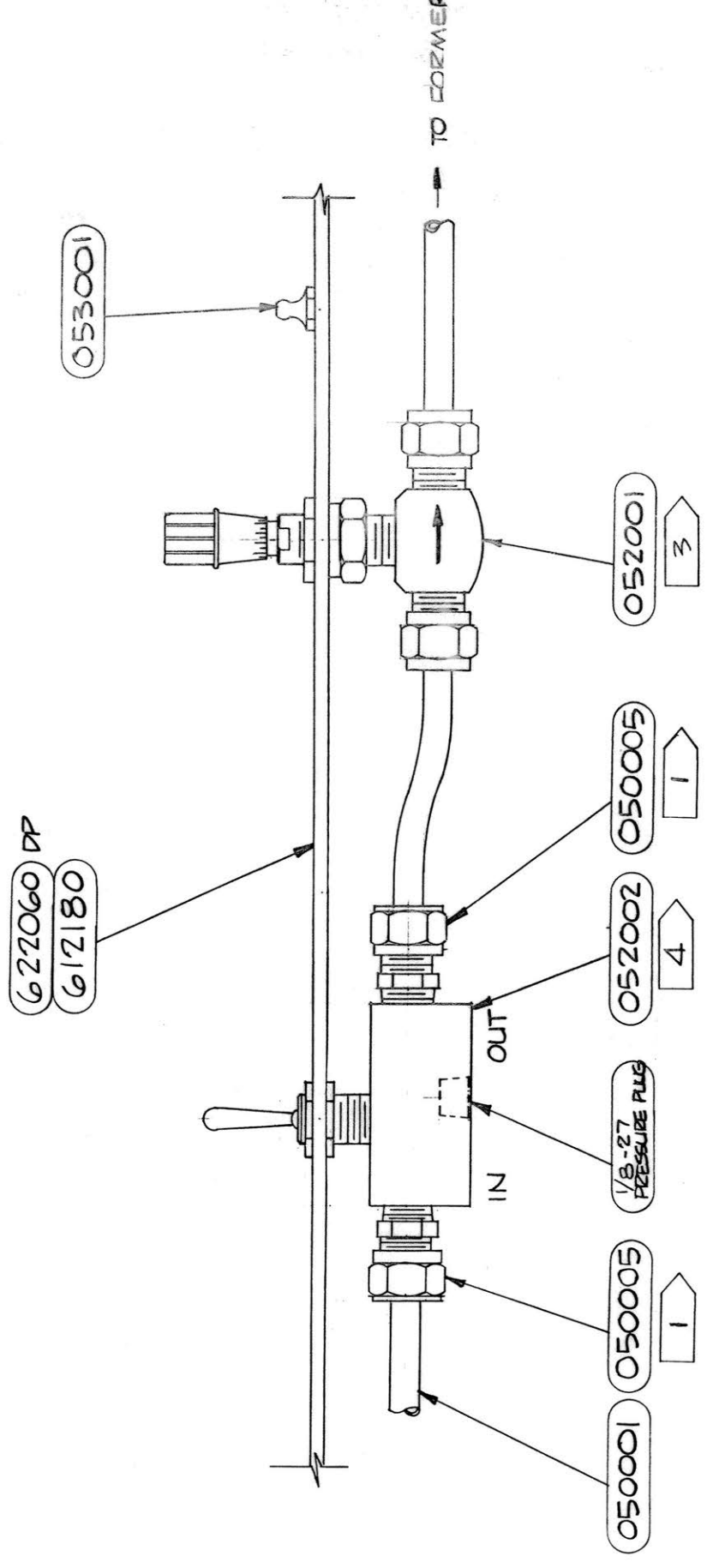
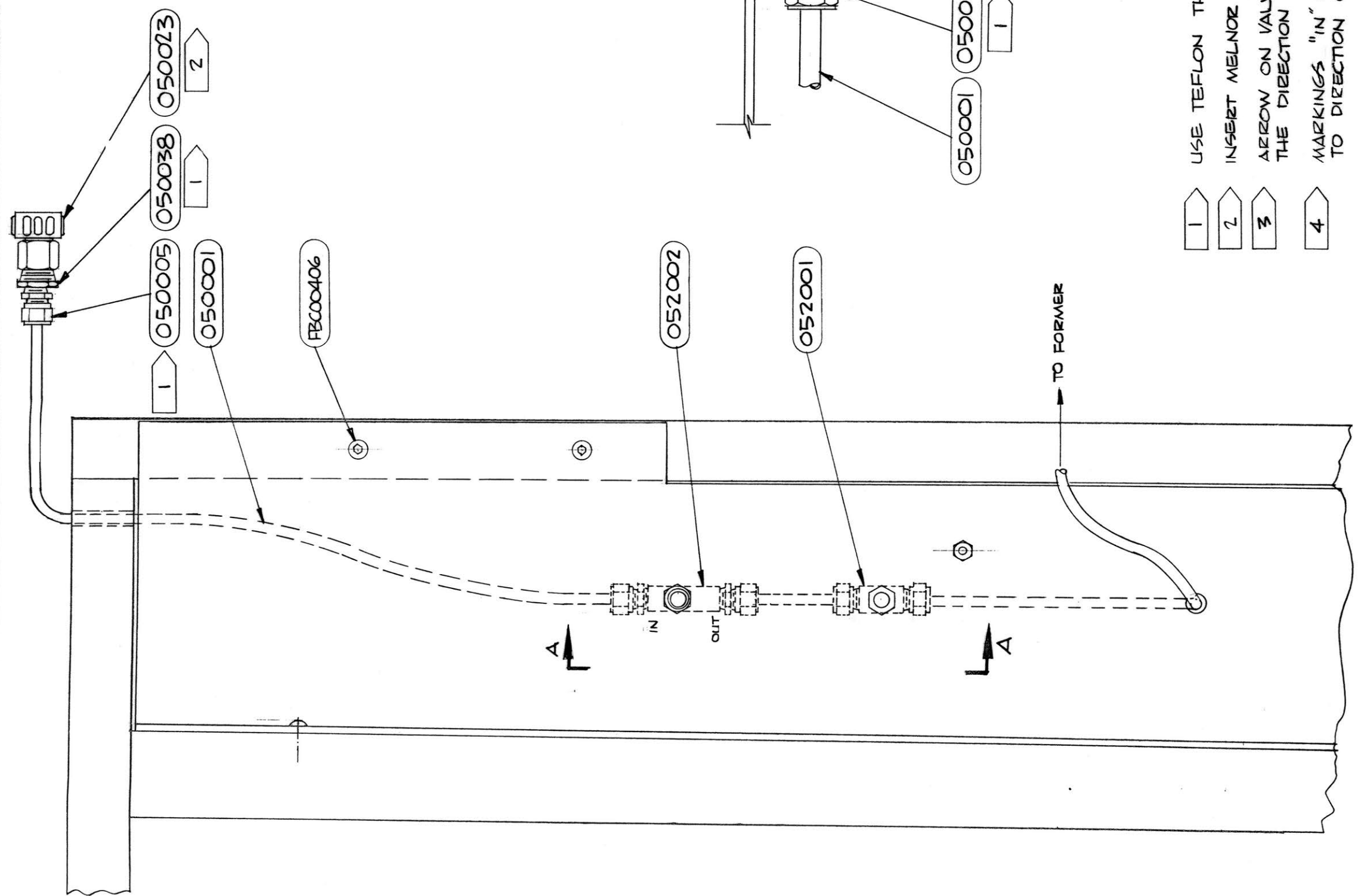
SECTION A-A
SCALE: FULL

- 1 TAPE TO 712210
- 2 USE NYLON ROD INSERT UNDER SET SCREW
- 3 USE TEFLON THREADING TAPE

1/4" WATER TUBING
SEE SHT. 3 OF 3

WEB PRESS LLC 701 EAST D ST., TACOMA, WA 98002		DRAWN BY APPROVED BY
TOLERANCES (EXCEPT AS NOTED)	DECIMAL ±	SCALE HALF
FRACTIONAL ±	TITLE ASSY DROOP SNOOT FORMER	DRAWING NUMBER 713000
ANGULAR ±	DATE 9-1-81	SHT. 2 OF 3

DATE	BY	REVISION	RECORD	DWG.



VIEW A-A
SCALE: FULL

- 1 USE TEFLON THREADING TAPE.
- 2 INSERT MELNOR FILTER WASHER
- 3 ARROW ON VALVE MUST POINT TO THE DIRECTION OF FLOW
- 4 MARKINGS "IN" & "OUT" MUST CORRESPOND TO DIRECTION OF FLOW

TOLERANCES (EXCEPT AS NOTED)	WEB PRESS LLC 701 EAST D ST., TACOMA, WA 98002		
DECIMAL	±	SCALE	HALF
FRACTIONAL	±	TITLE	ASSY WATER INJECTION CONTROL
ANGULAR	±	DATE	9-2-81
		DRAWING NUMBER	712000 713000
		SHT	3 OF 3
		DRAWN BY	BC
		APPROVED BY	



Plate Bender

**WEB LEADER FOLDER
PLATE BENDER 816003**

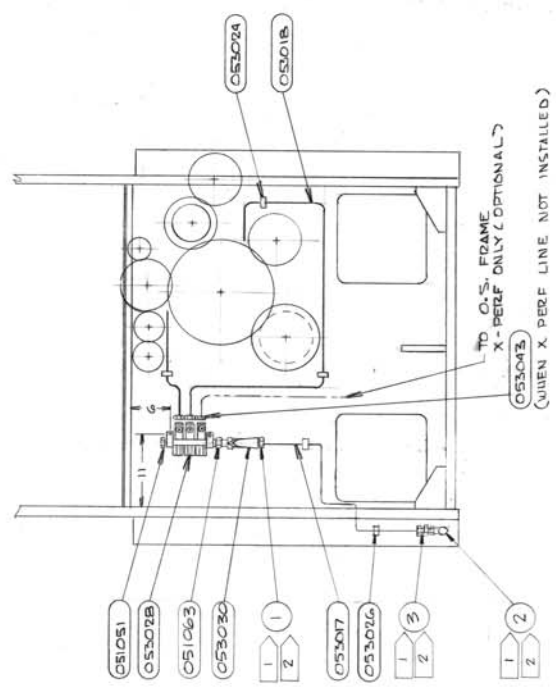
PART NO.	DESCRIPTION	QTY. REQ.D
2816022	PLATE BENDER, 22-3/4"	1
816080	BRACKET, PIVOT RIGHT	2
816090	BRACKET PIVOT LEFT	2
816110	BRACKET, SWING	4
816120	BAR BEND	2
816130	BAR, HOLD DOWN	2
816180	PUNCH, FRONT	1
816191	PUNCH, PLATE BENDER, REAR	1
816210	DIE, REAR PLATE BENDER	1
816221	ECCENTRIC STOP	1
816230	DIE, PLATE BENDER, REAR	1
816241	PLATE STOP	4
033006	3-1/4" LONG 3/8-16 THREADED HANDLE 1I	4
035006	SHOULDER SCREW 3/8 X 5/8 LGBS	4
090024	DRILL BUSHING 1/4" X 1/2" LONG 4A	2
033014	T-PIN 1/4" DIAMETER	2
090124	RUBBER BUMPER	4



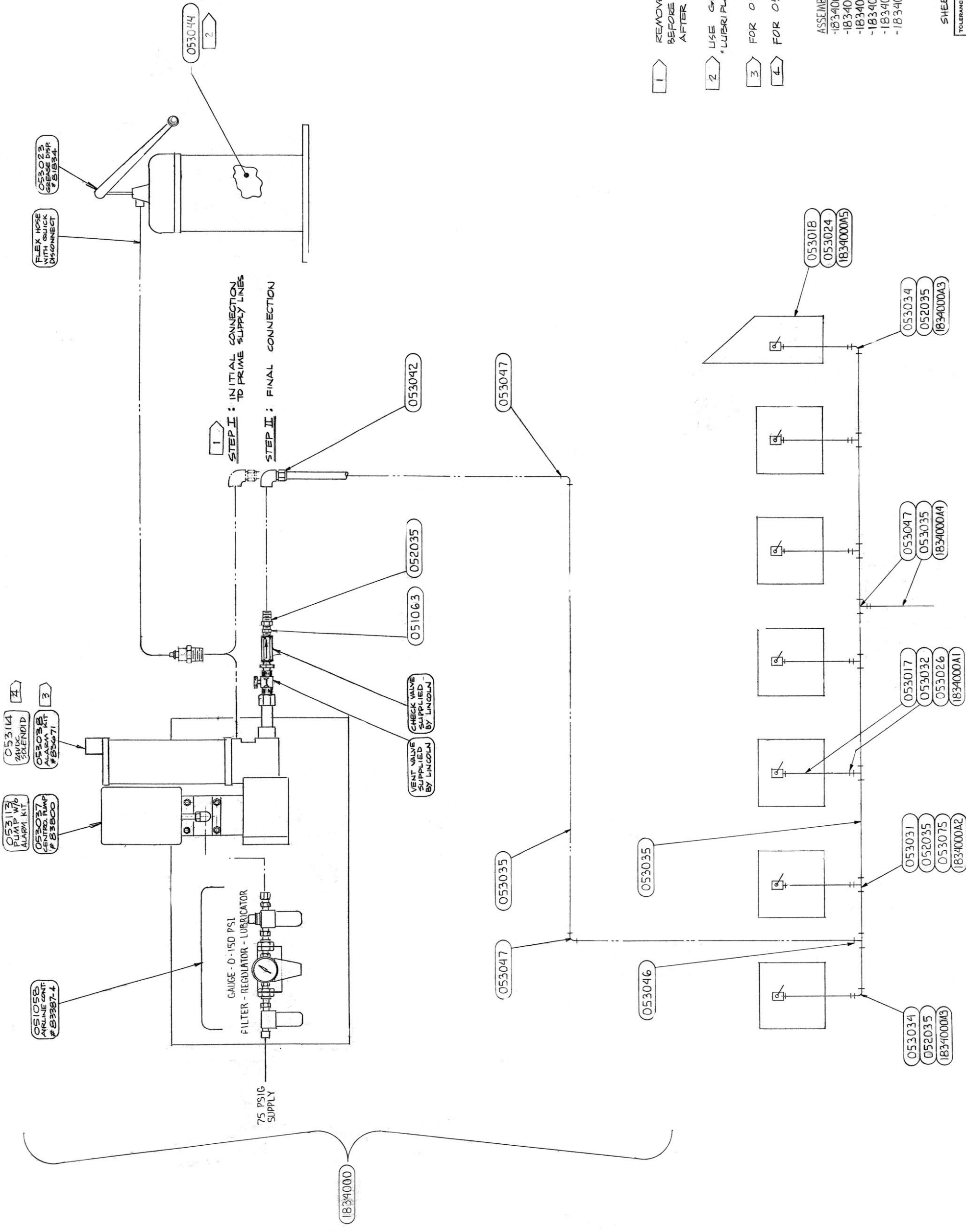
Auto-Lube

ITEM NO.	LINCOLN PARTS	PARKER PARTS	DESCRIPTION
1	053032	053054	MALE CONNECTOR 5/8" x 1/4" NPT
2	053034		FEMALE ELBOW 5/8" x 1/4" NPT
2		053058	FEMALE ELBOW 5/8" x 1/2" NPT
3	053032		MALE CONNECTOR 3/8" x 1/4" NPT
3		053056	MALE CONNECTOR 5/8" x 1/2" NPT

NOTES:
 1 LINCOLN PARTS ONLY WHERE INDICATED.
 2 SUBSTITUTE PARKER PARTS WHERE INDICATED.



WebPress LLC Tacoma, WA	
2024	GP
2-25-24	1.833.000



- 1 REMOVE INJECTOR PLUGS BEFORE PRIMING. REPLACE PLUGS AFTER GREASE COMES OUT.
- 2 USE GREASE "LUBRI PLATE GEARSHIELD #15006 NLGI #1"
- 3 FOR 053037 PUMP (STANDARD)
- 4 FOR 053113 PUMP (OPTIONAL)

ASSEMBLIES INCLUDED
 -1834000 AUTOLUBE SYSTEM
 -1834000A1 OPTION: UNIT HOOK-UP
 -1834000A2 OPTION: LINE JUNCTION
 -1834000A3 OPTION: END UNIT OR FOLDER
 -1834000A4 OPTION: T-4 AUTOLUBE
 -1834000A5 OPTION: CROSS PERF AUTOLUBE

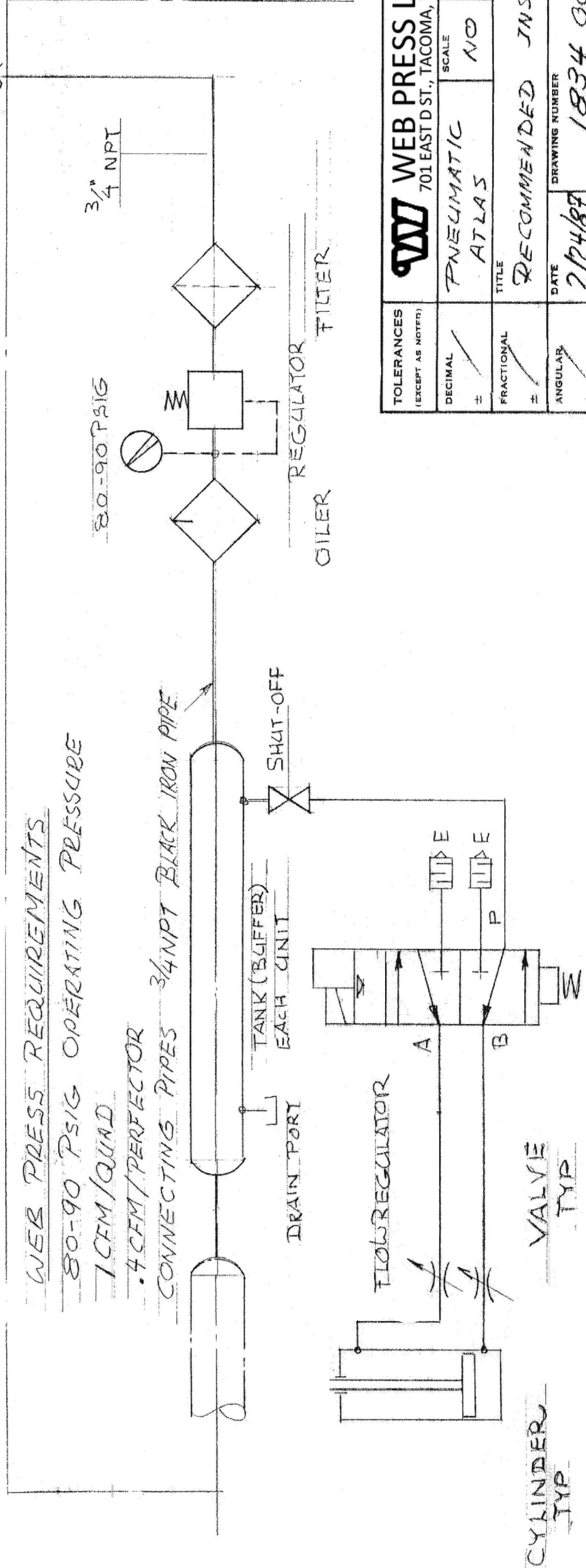
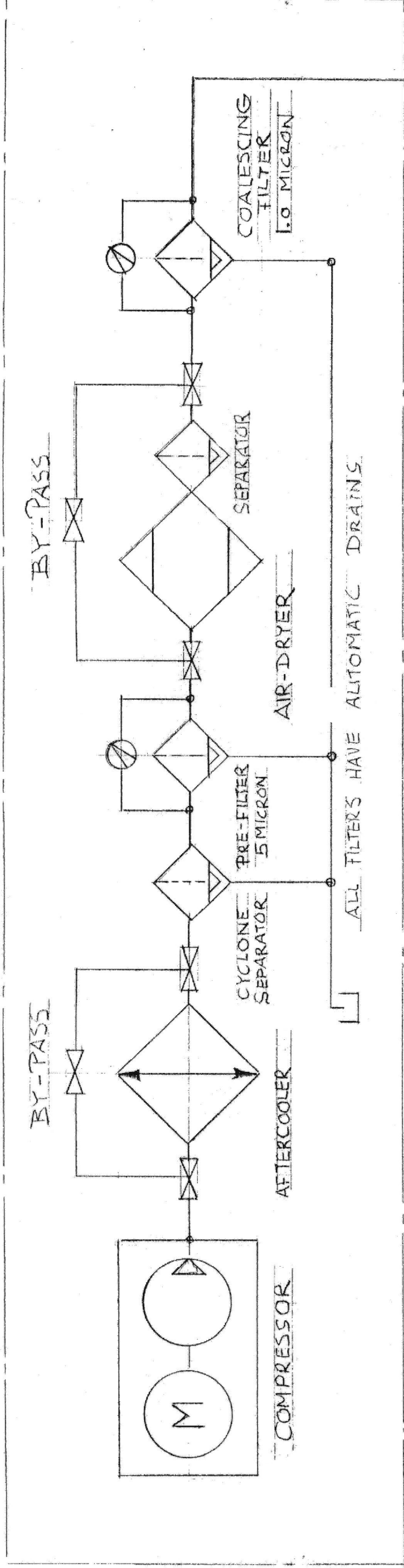
SHEET 2 OF 2 "B" SIZE

TOLERANCES (EXCEPT AS NOTED)	
DIMENSIONAL	± .005
FRACTIONAL	± .005
ANGULAR	± .005

WEB PRESS LLC
 701 EAST D ST. TACOMA, WA 98002
 ATLAS PERFECTOR
 151, 251 AND 451
 DATE: 8-11-92
 DRAWING NUMBER: 1834000
 SHEET 2 OF 2

TYPICAL AIR COMPRESSOR INSTALLATION -

DATE	SYMBOL	REVISION RECORD	DR.	CK.



WEB PRESS REQUIREMENTS
80-90 PSIG OPERATING PRESSURE
1 CFM/QUAD
.4 CFM/PERFECTOR
CONNECTING PIPES 3/4" NPT BLACK IRON PIPE

TOLERANCES (EXCEPT AS NOTED) DECIMAL ± / FRACTIONAL ± / ANGULAR ±		WEB PRESS LLC 701 EAST D ST., TACOMA, WA 98002	
PNEUMATIC ATLAS		SCALE NO	DRAWN BY <i>OB</i>
RECOMMENDED INSTALLATION.		DATE 2/24/87	APPROVED BY
CYLINDER TYP		DRAWING NUMBER 1834 000	SHEET 2 OF 2