

**FREQUENTLY ORDERED PARTS
SEMI-AUTOMATIC TURNTABLE
ITW (LIBERTY) 4.4 SIGNODE SG 555/SG 550**

BASE - LOW PROFILE TURNTABLE

50-20000-003	Motor, ½ HP, 90VDC @ 1725 RPM, Leeson	Drive motor for turntable (all models)
50-35018-002*	Brush, Leeson #900116.02	Replacement brush, 2 req'd
40-81022-002	V-belt, standard base	Drives ring bearing, 192.41" lg. (ring bearing model)
40-81022-003	V-belt, extended base	Drives ring bearing, 216.41" lg. (ring bearing model)
40-88025-001	Pulley, flat, idler, 6" dia.	Guides V-belt along path and provides tension (ring bearing model)
40-88029-001	Pulley, V-belt, plastic	Idler, guides V-belt along path (ring bearing model)
40-81533-001	Cam roller	Turntable support wheels (pre 1997 chain driven model)
85-00599-001	Idler sprocket	Tensions chain drive (pre 1997 chain driven models)
40-84001-001	Chain, #50	Drive chain (pre 1997 chain driven models)
50-69038-006	Switch, proximity	Counts turntable revolutions and signals home position
05-00423-201	Kit, retrofit, proximity switch	Replaces photo-eyes on older style turntables

* Brushes are compatible with ¾ HP motors also (50-20000-005)

BASE - HIGH PROFILE TURNTABLE

50-20000-005	Motor, ¾ HP, 90VDC, 1725 RPM, Leeson	Drive motor for turntable
50-35018-002*	Brush, Leeson #900116.02	Replacement brush (2 req'd)
40-54016-001	Drive wheel w/keyway	Drives (rotates) and supports turntable
40-54018-001	Casters, wheel	Idlers, supports turntable (2 req'd)
85-00299-001	Bearing, flange	Turntable center rotating support
50-69038-006	Switch, proximity	Counts turntable revolutions and signals home position

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UPRIGHT (COLUMN)

50-20000-003	Motor ½ HP, 90VDC, 1725 RPM, Leeson	Drives the carriage up/down
50-35018-002*	Brush, Leeson #900116.02	Replacement brush (2 req'd)
85-02872-001	Wheel, phenolic, w/bearing	Wheels that roll up & down upright track interior, mounts to axle
85-02893-001	Glide.	Plastic bearing, mounts to axle
85-02892-001	Spacer	Wheel position shim, mounts to axle
85-02895-001	Axle	Shaft supporting wheels, glides, nuts, and spacers, mounts to carriage cart
05-00448-201	Carriage cart rebuild kit	Assembly including; 4 sets of wheels, glides, spacers, nuts, & screws
85-00070-001	Drive sprocket	Sprocket mounted on the elevator gearbox
85-00599-001	Idler sprocket	Sprocket with internal bearing, mounted to top plate of upright

PRE-STRETCH CARRIAGE (20" FILM)

50-20000-005	Motor ¾ HP, 90VDC 1725 RPM, Leeson	Drives the pre-stretch rollers
50-35018-002*	Brush, Leeson #900116.02	Replacement brush (2 req'd)
85-02226-001	Belt timing	Drive belt in upper (drive) section of pre-stretch
03-02286-201	Stretch roller	Rubber coated rollers that stretch the film (2 req'd)
03-02110-201	Bearing, 2 bolt flange	Stretch roller mounted bearings on top and bottom shafts
85-01846-001	Bearing 3/8" I.D. 7/8" O.D	Idler roller ball bearings pressed into the ends
08-04376-003	Idler roller, 25.75" L x 7/8" I.D.	Idler rollers located between pre-stretch rollers
85-02016-001	Strain gauges	Out feed roller mounted load cell sensors, triggers film feed rate
50-17075-002	AB-4 board *	Film feed DC motor drive control and strain gauge amplifier

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CONTROL PANEL

50-12019-001	Keypad, signature series	Operator control & display interface to micro controller
30-00009-201	Micro controller board (PC board)	Machine control interface of I/O (input/output), holds E-prom
50-48021-001	E-prom	Microprocessor, programming based on machine type and serial number
50-33041-001	Relay	Micro controller output relay
50-17062-002	Motor controller PWM	DC drive control board for both turntable and elevator motors
50-17075-002	AB-4 board *	Film feed DC motor drive control and strain gauge amplifier
50-00412-201	Retro film force kit (for AB-4 retrofits)	Updates older 4.4 analog film force control; includes programmed E-prom, relay, pot & hardware.

*NOTE: The AB-4 board supersedes previous models and replaces both the AB-3 board amplifier board and Dart DC motor drive if ordered; the AB-4 combines the function of these 2 boards into 1 unit, wiring change instructions are supplied.