

SOHN MODEL 6503 INSTALLATION & SERVICE MANUAL



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THIS MACHINE IS FOR INDUSTRIAL USE ONLY IN AN INDUSTRIAL ENVIRONMENT

Sohn has supplied guarding to its best ability on all electrical components, shafts, power drives, pulleys, belts and on objects that are designed to be objects in motion or considered by Sohn to be obvious operator danger points. However, due to the variances in OSHA Codes, which allows OSHA Inspectors to determine OSHA violations in accordance to their interpretation of OSHA Codes.

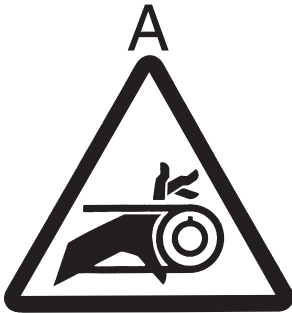
Sohn does not warrant the machine to meet all OSHA requirements, which can vary in accordance to the location and OSHA Inspectors. It is agreed that in accepting this proposal, the meeting of final OSHA requirements for operation in their facility is the responsibility of the customer.

ATTENTION

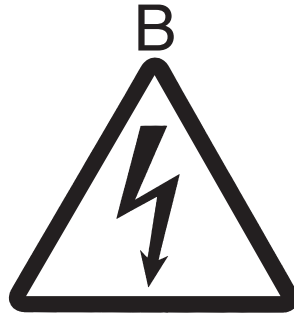
These warning symbols are used throughout this manual and on the machine.
Know and understand their meaning.



GENERAL WARNING



ENTANGLEMENT HAZARD (BELT DRIVE)



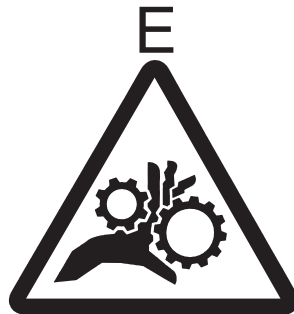
ELECTRIC SHOCK HAZARD



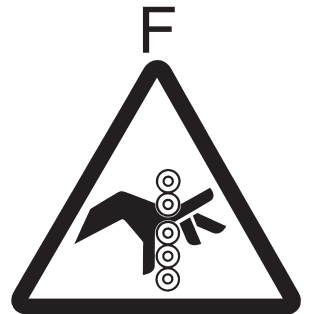
HAND ABRASION



HAND ENTANGLEMENT



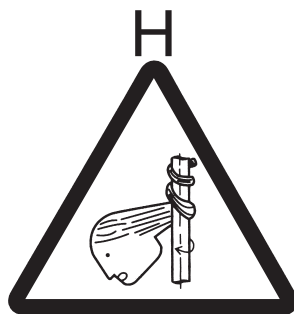
ENTANGLEMENT HAZARD (HAND IN GEARS)



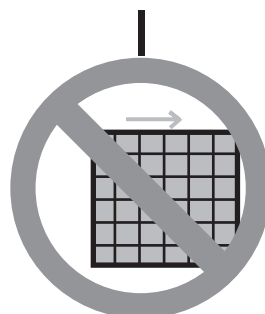
PINCH POINT (HAND IN ROLLERS)



CUT / SEVER HAZARD



HAIR ENTANGLEMENT



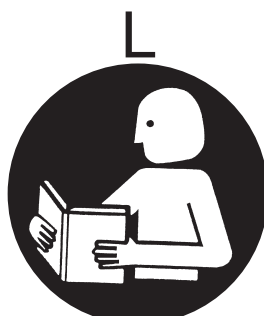
DO NOT REMOVE GUARD



NO ACCESS FOR
UNAUTHORIZED PERSONNEL



WEAR EYE PROTECTION



READ MANUAL



NOT A LIFT POINT



SERVICE MANUAL

GENERAL SAFETY RULES



READ THE FOLLOWING INSTRUCTIONS BEFORE OPERATING THIS MACHINE

This machine was designed for certain applications only. Sohn Manufacturing strongly recommends that this machine not be modified and/or used for any application other than that for which it was designed. If you have any questions relative to a particular application, DO NOT use the machine until you have first contacted Sohn Manufacturing to determine if it can or should be performed on the machine. As with all machinery, there are certain hazards involved with the operation of the product. Using the machine with respect and caution will considerably lessen the possibility of personal injury. However, if normal safety precautions are overlooked or ignored, personal injury to the operator may result. Safety equipment such as guards, goggles and hearing protection can reduce your potential for injury. But even the best guard won't make up for poor judgment, carelessness or inattention. Always use common sense and exercise caution in the workplace. **REMEMBER:** Your personal safety is your responsibility.



WARNING: FAILURE TO FOLLOW THESE RULES MAY RESULT IN SERIOUS PERSONAL INJURY

1. DO NOT OPERATE THIS MACHINE UNTIL it is assembled and installed according to the instructions. FOR YOUR OWN SAFETY, READ INSTRUCTION MANUAL BEFORE OPERATING THE MACHINE. Follow all wiring codes and recommended electrical connections. Learn the machine's application and limitations as well as the specific hazards peculiar to it. OBTAIN ADVICE from your supervisor, instructor, or another qualified person if you are not familiar with the operation of this machine.
2. DO NOT OPERATE MACHINE WITHOUT GUARDS IN PLACE.
3. KEEP WORK AREA CLEAN. Cluttered areas and benches invite accidents. NEVER START THE MACHINE before clearing the web of all objects (tools, scrap pieces, etc.)
4. DON'T USE IN DANGEROUS ENVIRONMENT. Don't use this machine in damp or wet locations, or expose them to rain. Keep work area well lighted.
5. KEEP CHILDREN AND VISITORS AWAY. Children and visitors should be kept a safe distance from work area.
6. WEAR PROPER APPAREL. No loose clothing, gloves, neckties, rings, bracelets, or other jewelry to get caught in moving parts. Nonslip footwear is recommended. Wear protective hair covering to contain long hair.
7. KEEP ARMS, HANDS, FINGERS away from all moving parts of the machine. DON'T OVERREACH. Keep proper footing and balance at all times.
8. USE RECOMMENDED ACCESSORIES. The use of accessories and attachments not recommended by Sohn Manufacturing may cause hazards or risk of injury to persons.

9. NEVER STAND ON MACHINE. Serious injury could occur if the machine is tipped or if the rotary die is accidentally contacted.
10. CHECK DAMAGED PARTS. Before further use of the machine, a guard or other part that is damaged should be carefully checked to ensure that it will operate properly and perform its intended function – check for alignment of moving parts, binding or moving parts, breakage of parts, mounting, and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.
11. TURN THE MACHINE “OFF” AND DISCONNECT THE MACHINE from the power source before installing or removing accessories, before adjusting or changing set-ups, or when making repairs.
12. NEVER LEAVE MACHINE RUNNING UNATTENDED. TURN POWER OFF. Don't leave machine until it comes to a complete stop.
13. CERTAIN MATERIALS will generate unusually high noise levels. When using such materials, test to determine the necessity of hearing protection.
14. CERTAIN DIES, i.e. dies with very deep engravings, could become a severing hazard.
15. STAY ALERT. WATCH WHAT YOU ARE DOING, AND USE COMMON SENSE WHEN OPERATING THIS MACHINE. DO NOT USE MACHINE WHILE TIRED OR UNDER MEDICATION. A moment of inattention while operating machinery may result in serious personal injury.

SAVE THESE INSTRUCTIONS

Refer to them often and use them to instruct others.

INSTALLATION MANUAL



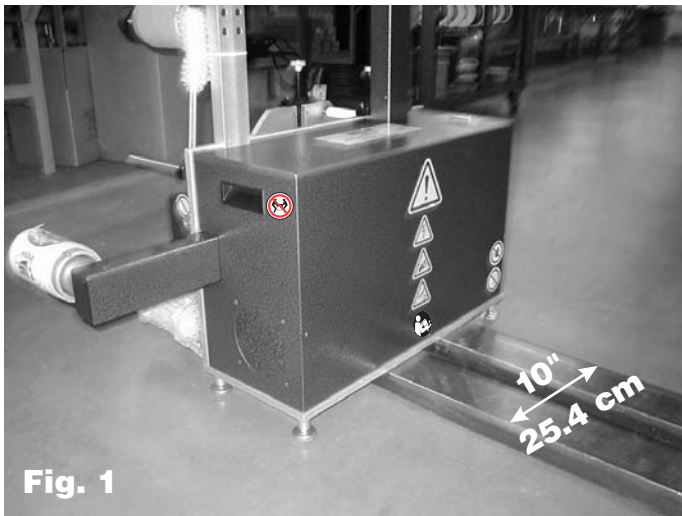


Fig. 1



Fig. 2

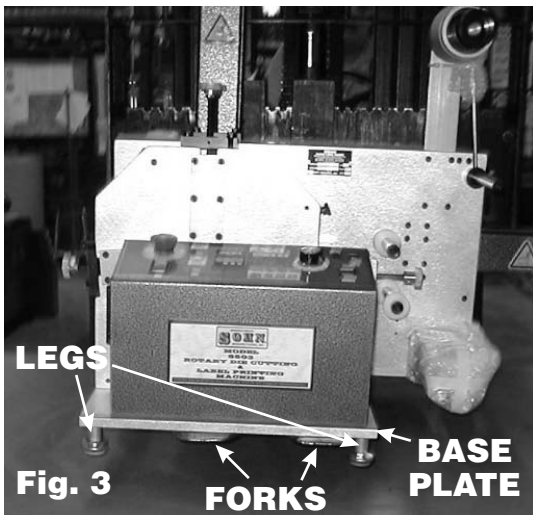


Fig. 3

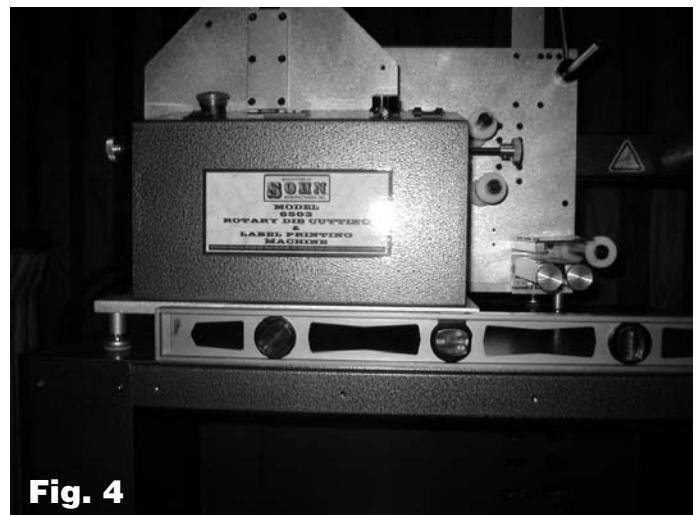


Fig. 4

The Sohn Model 6503 should be lifted from the back only (see Figure 1).

NOTE: DO NOT USE PANEL HANDLE AS A LIFTING POINT (see figure 2).

To stabilize the machine and avoid potential damage to the control panel, forks should be spread 10" (25.4 cm) apart from outside edge of fork to outside edge of fork. The forks should extend slightly past the front base plate and between the two front legs. (see Figure 3).

Figure 4 shows the machine being placed on the table in the correct position. The table and the machine should be leveled.

Connect power cord for the machine to control panel (see Figure 5).



Fig. 5

⚠ Be sure to connect machine to the proper source of power. The power rating is shown on the machine rating plate and on the inside cover of this manual.

Machine must be installed in a dry, clean, dust free and well-lighted area.

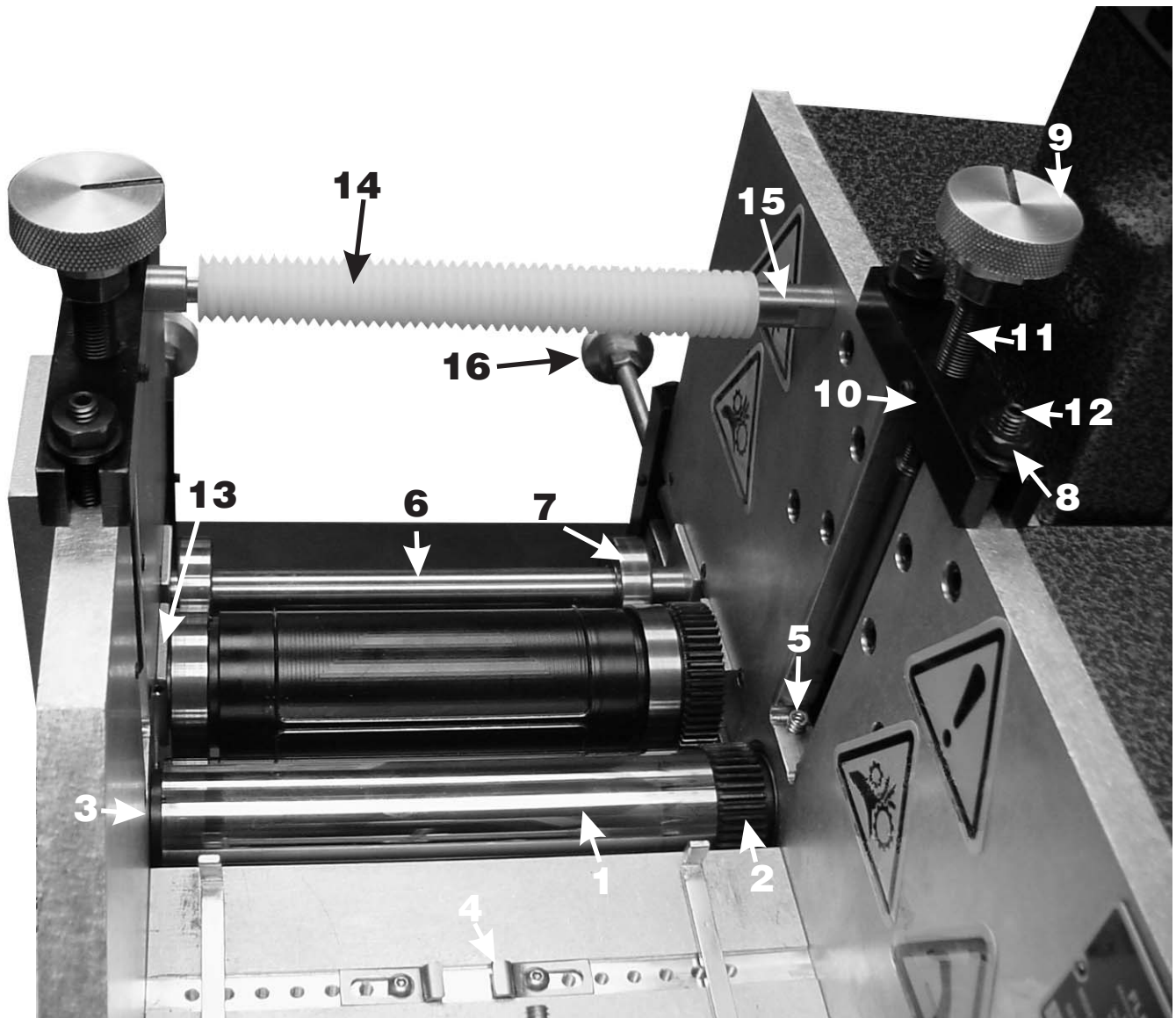


WARNING!

The following pages contain photographs and descriptions of replacement parts for the **Sohn Model 6503.**

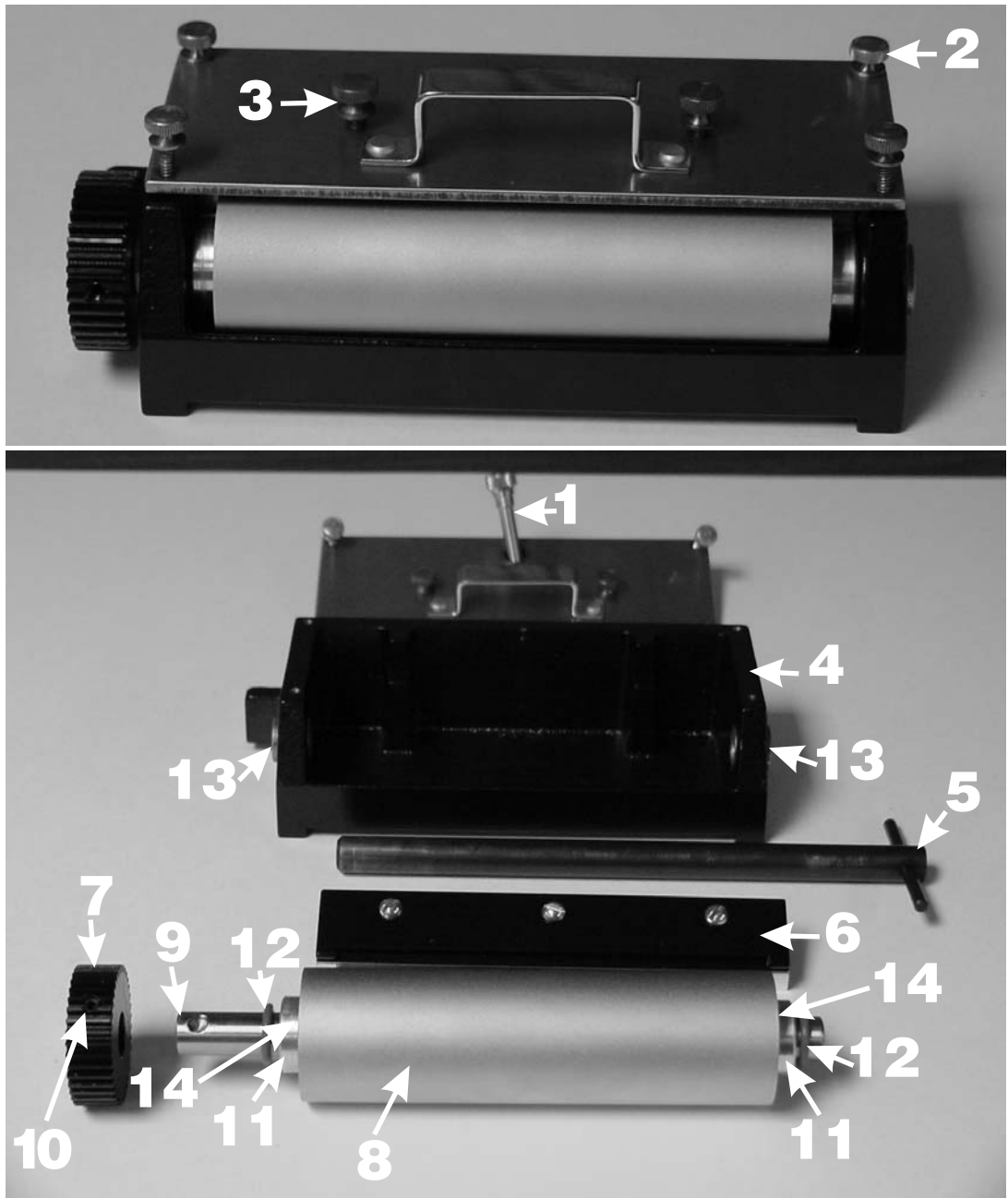
Only trained and authorized personnel should perform service.

***TURN THE MACHINE “OFF”
AND DISCONNECT THE MACHINE***
from the power source before installing or removing accessories, before adjusting or changing set-ups, or when making repairs.



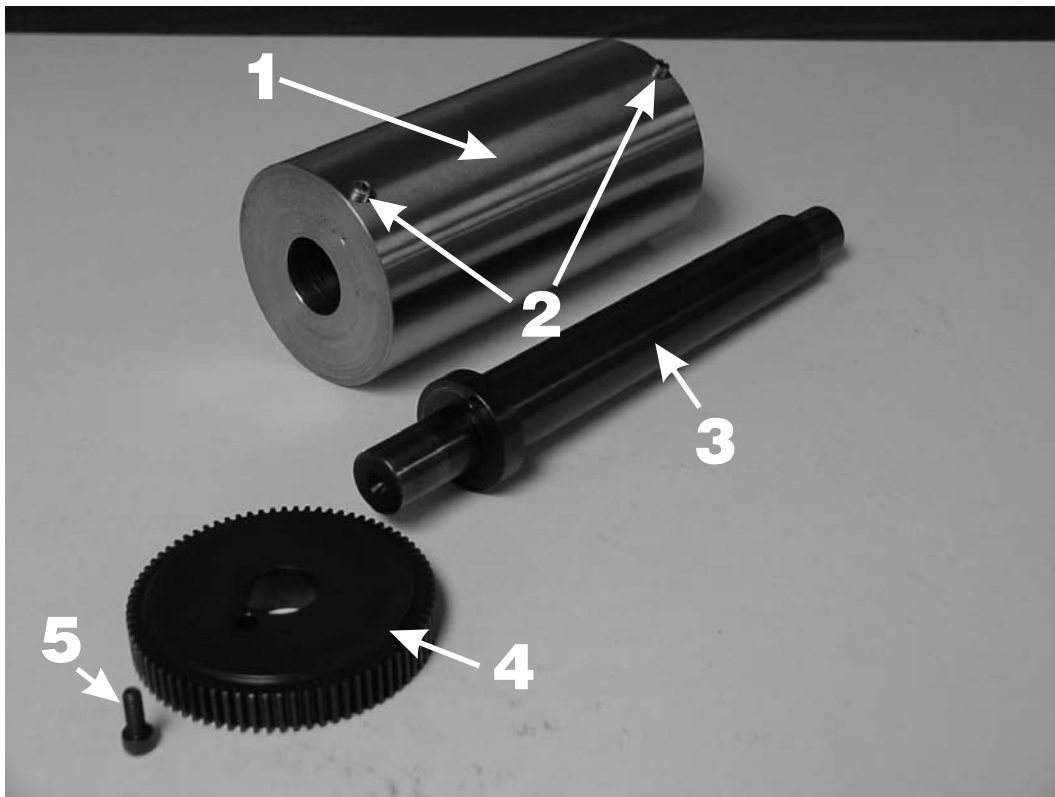
DIE CUTTING STATION

	PART NO.	DESCRIPTION	QTY.	PRICE / EA.
1	65-125 3	Anvil Shaft 1/8 Pitch.....	1	
	65-125 4	Anvil Shaft (32 Pitch-Option).....	1	
2	65-160 2	Anvil Gear 1/8 Pitch.....	1	
	65-160 3	Anvil Gear (32 Pitch-Option).....	1	
3	1001-13	Anvil Bearing.....	2	
4	65-306	Paper Guide.....	1	
5	1004-09	Spring (81-122 teeth 32 Pitch / 64-96 teeth 1/8 Pitch)....	4	
	1004-10	Spring (62-80 teeth 32 Pitch / 48-63 teeth 1/8 Pitch)....	4	
6	44-137	Bearer Shaft.....	1	
7	1001-02	Die Bearer Bearing.....	2	
	44-137-C	Die Bearer Assembly Complete.....		
8	2520 F	Flange Nut.....	8	
9	65-707	Pressure Knob.....	2	
10	65-716	Pressure Bar.....	2	
11	65-700	Adjusting Rod.....	2	
12	L252032	Set Screw.....	4	
13	65-117-R-C	Right Bearing Block Assembly.....	1	
	65-117-L-C	Left Bearing Block Assembly.....	1	
14	65-195 3	Waste Roller.....	1	
15	65-690	Tie Bar.....	1	
16	65-734	Die Pressure Screw.....	2	
	7110-1-C	Oil Wiper Assembly Gear Side (not shown).....		
	7110-2-C	Oil Wiper Assembly Operators Side (not shown).....		



INK FOUNTAIN

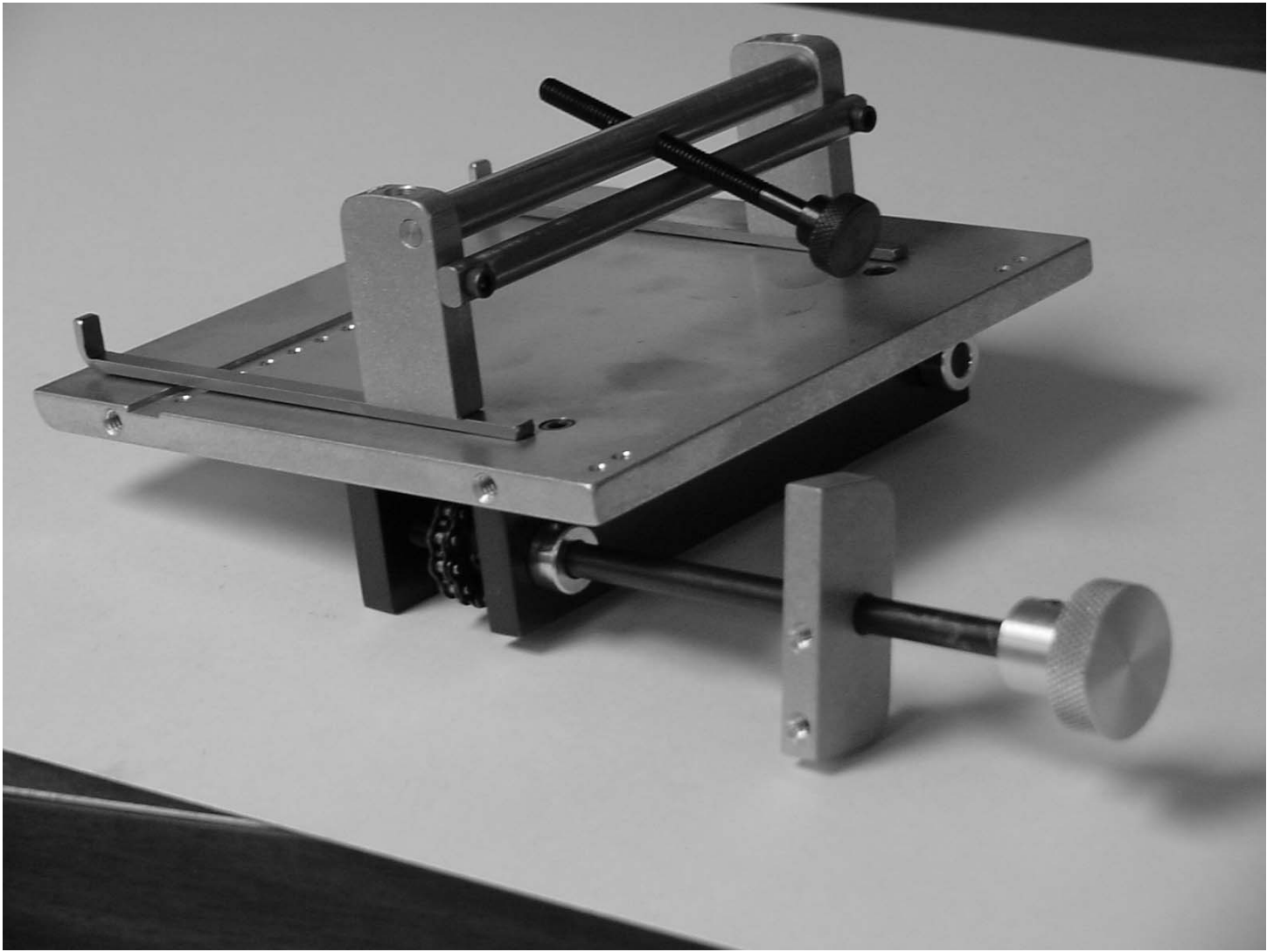
	PART NO.	DESCRIPTION	QTY.	PRICE / EA.
1	65-218	Dipstick.....	1	
2	K063206	Cover Thumb Screw.....	4	
3	K083208	Dr. Blade Thumb Screw.....	2	
4	65-200	Ink Fountain.....	1	
5	65-200-T-C	Fountain Line Up Tool.....	1	
6	65-203 C	Dr. Blade Assembly.....	1	
	65-203	Dr. Blade only.....	1	
7	65-215 1	Ink Roller Gear 1/8 Pitch.....	1	
	65-215	Ink Roller Gear (32 Pitch-Option).....	1	
8	65-201 3	Ink Roller 1/8 Pitch.....	1	
	65-201	Ink Roller (32 Pitch-Option).....	1	
9	65-206	Fountain Shaft 1/8 Pitch.....	1	
10	L102406	Fountain Gear Set Screw.....	1	
11	65-209	O-Ring Retainer.....	1	
12	1005-01	Fountain O-Ring.....	2	
13	1000-10	Fountain Bushing.....	2	
14	L102406	Ink Roller Set Screw.....	2	



PRINT CYLINDER

	PART NO.	DESCRIPTION	QTY.	PRICE / EA.
1	-----	Print Cylinder (various sizes).....	1	
2	LB252004	Brass Set Screw.....	2	
3	65-109 DS	Print Cylinder Shaft.....	1	
4	-----	Print Cylinder Gear (various sizes).....	1	
5	S102410	Screw.....	1	

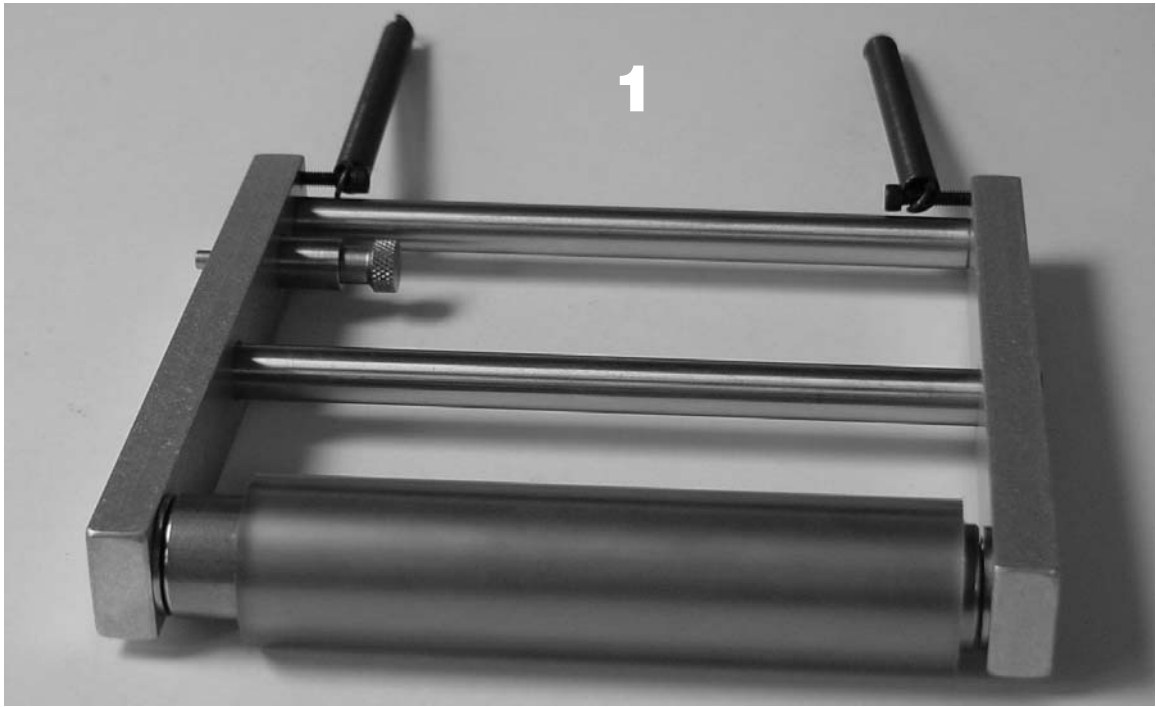




CENTER PLATE ASSEMBLY

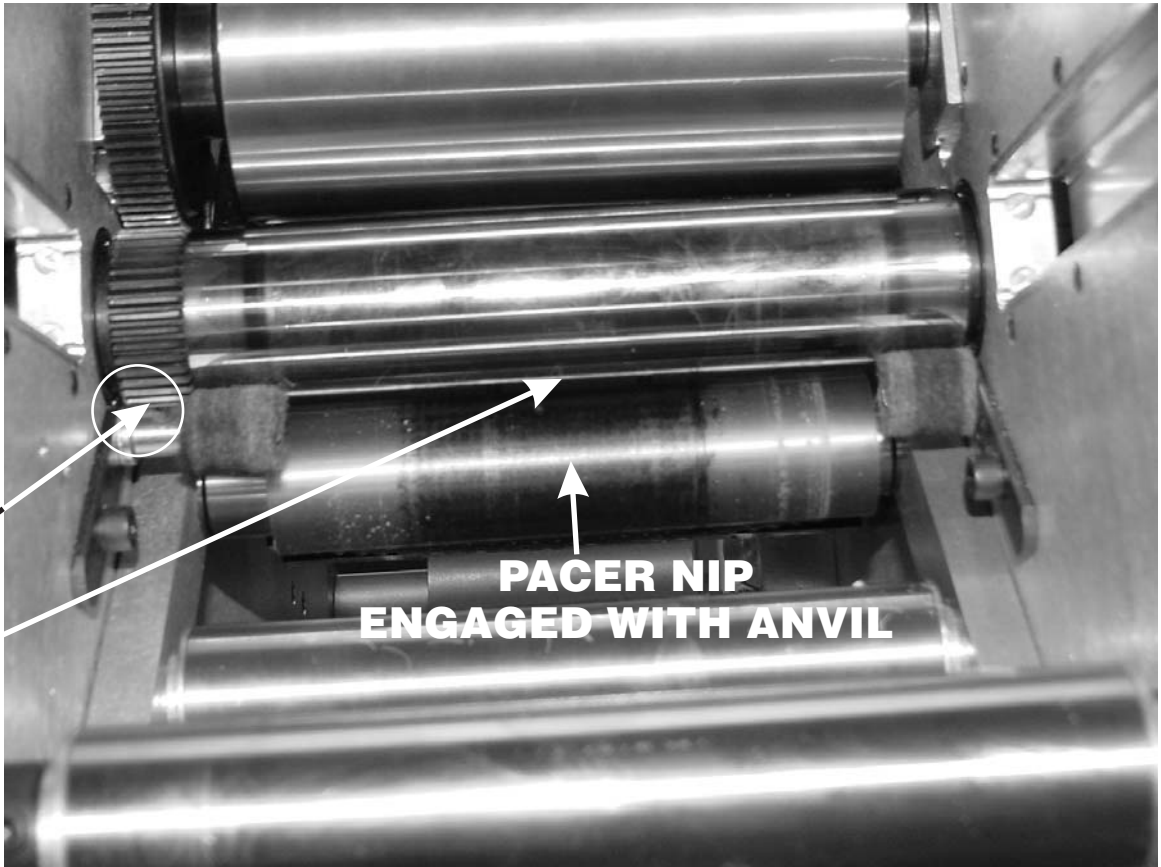
	PART NO.	DESCRIPTION	QTY.	PRICE / EA.
1	65-717	Center Plate Assembly.....	1	

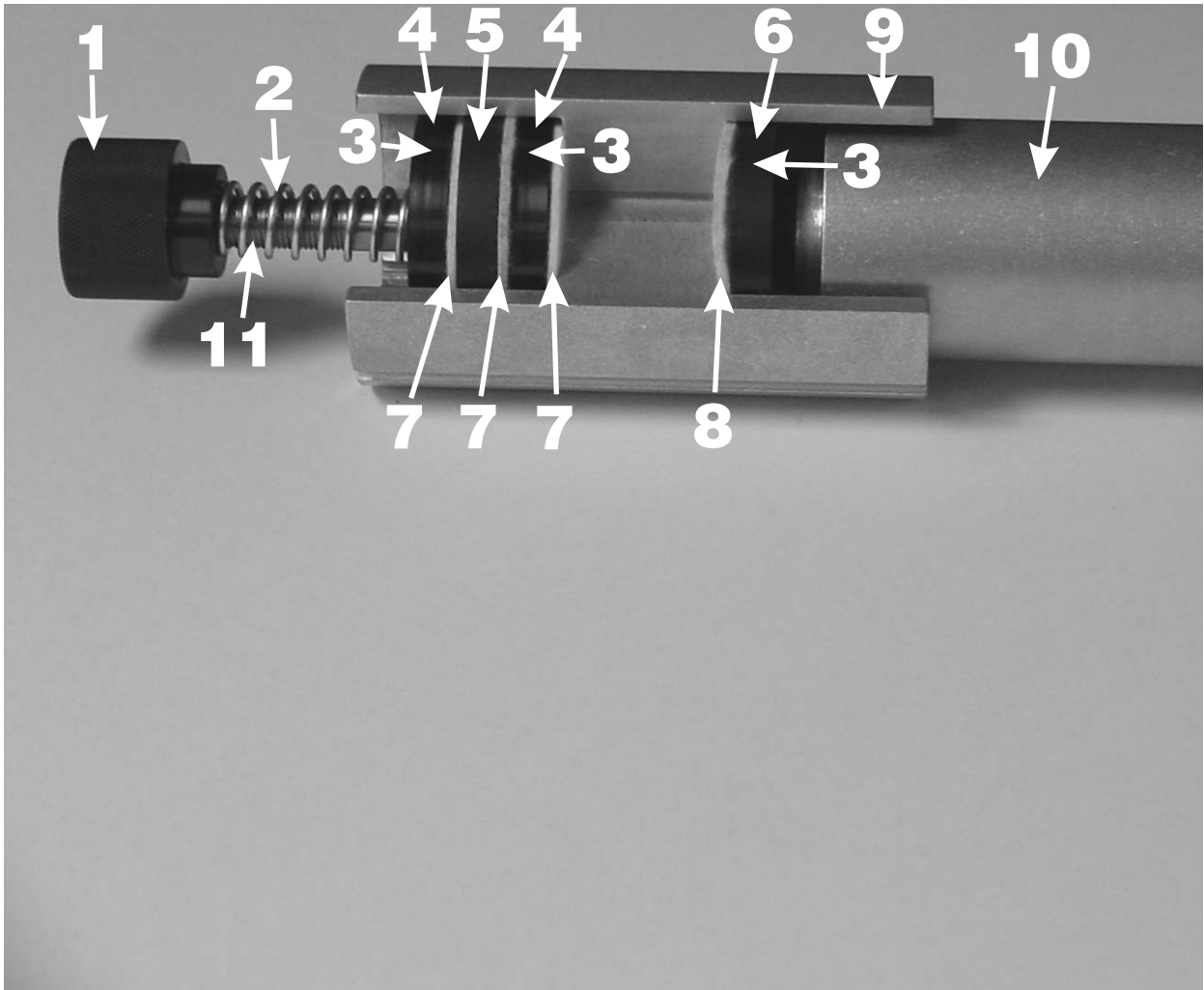
**DUE TO PRECISE ALIGNMENT REQUIREMENTS
THIS ITEM CAN ONLY BE SOLD AS A
COMPLETED ASSEMBLY.**



PACER NIP ASSEMBLY

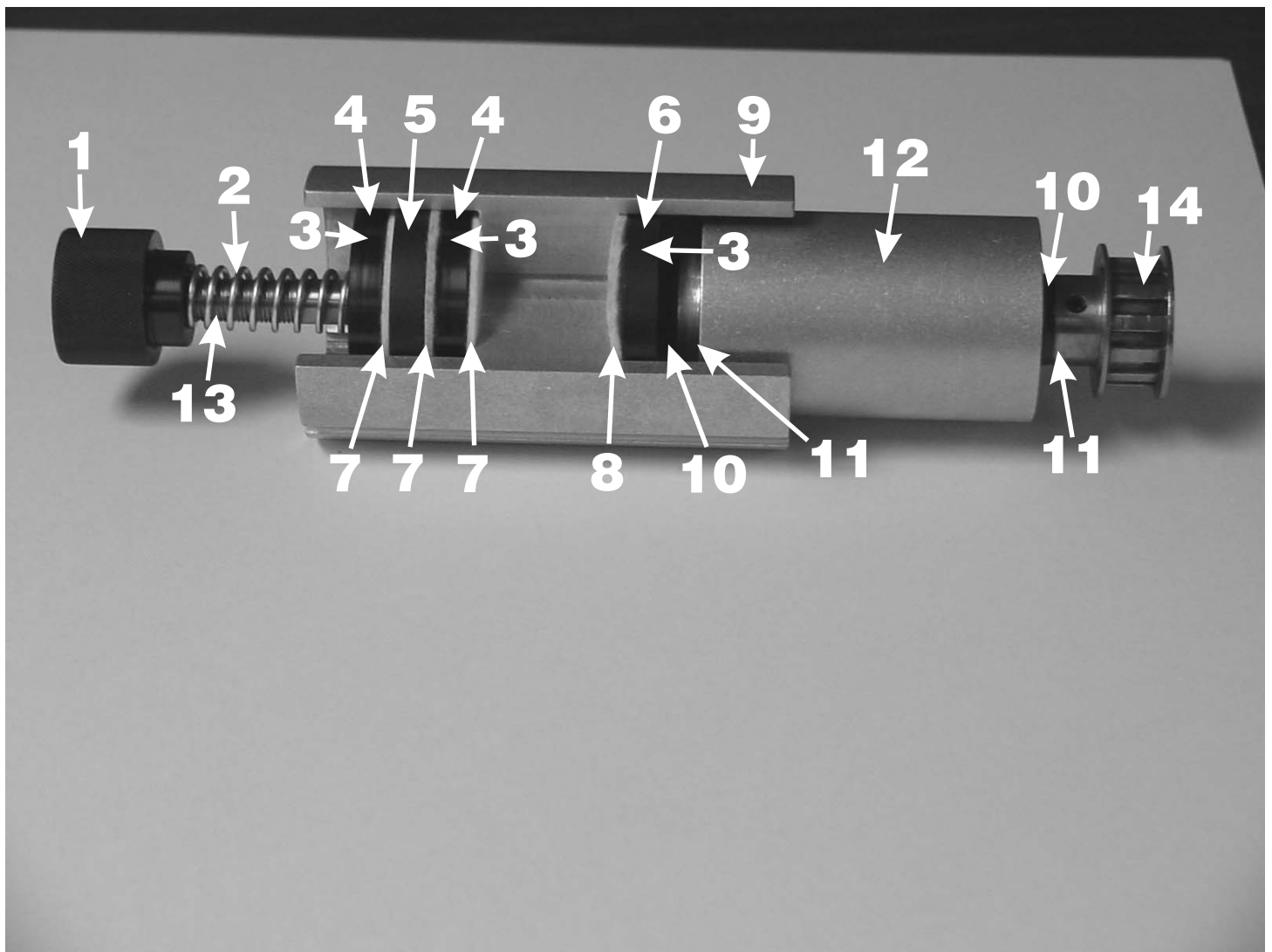
	PART NO.	DESCRIPTION	QTY.	PRICE / EA.
1	65-759	Pacer Nip Assembly.....	1	





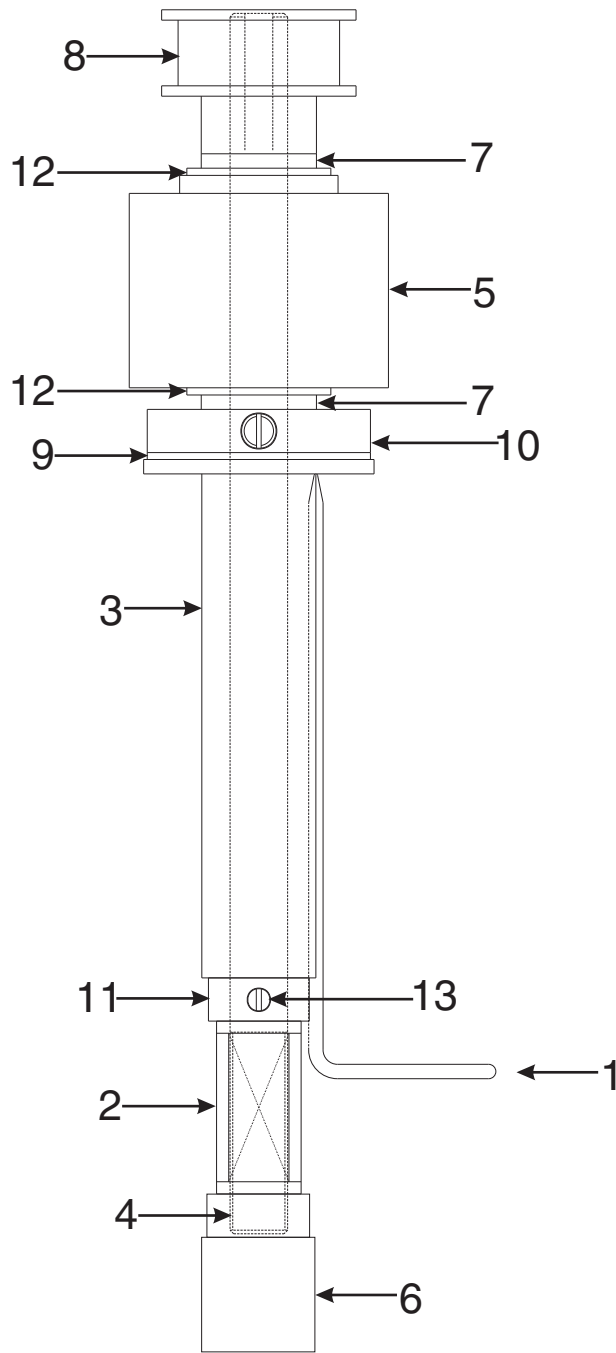
UNWIND ASSEMBLY

	PART NO.	DESCRIPTION	QTY.	PRICE / EA.
1	65-687 2	Tension Nut	1	
2	1004-12	Spring	1	
3	SL-302	Tension Collar Screw.....	3	
4	65-735	Clutch Collar.....	2	
5	65-738 1	Drive Clutch Collar.....	1	
6	65-735 1	Clutch Collar.....	1	
7	99-437 3	Clutch Disk.....	3	
8	99-437 2	Clutch Disk.....	1	
9	65-732 1	Core Holder.....	1	
10	65-664	Unwind Shaft Mount.....	1	
11	65-595	Unwind Shaft.....	1	
12	65-417	Core Lock Pin (not shown).....	1	



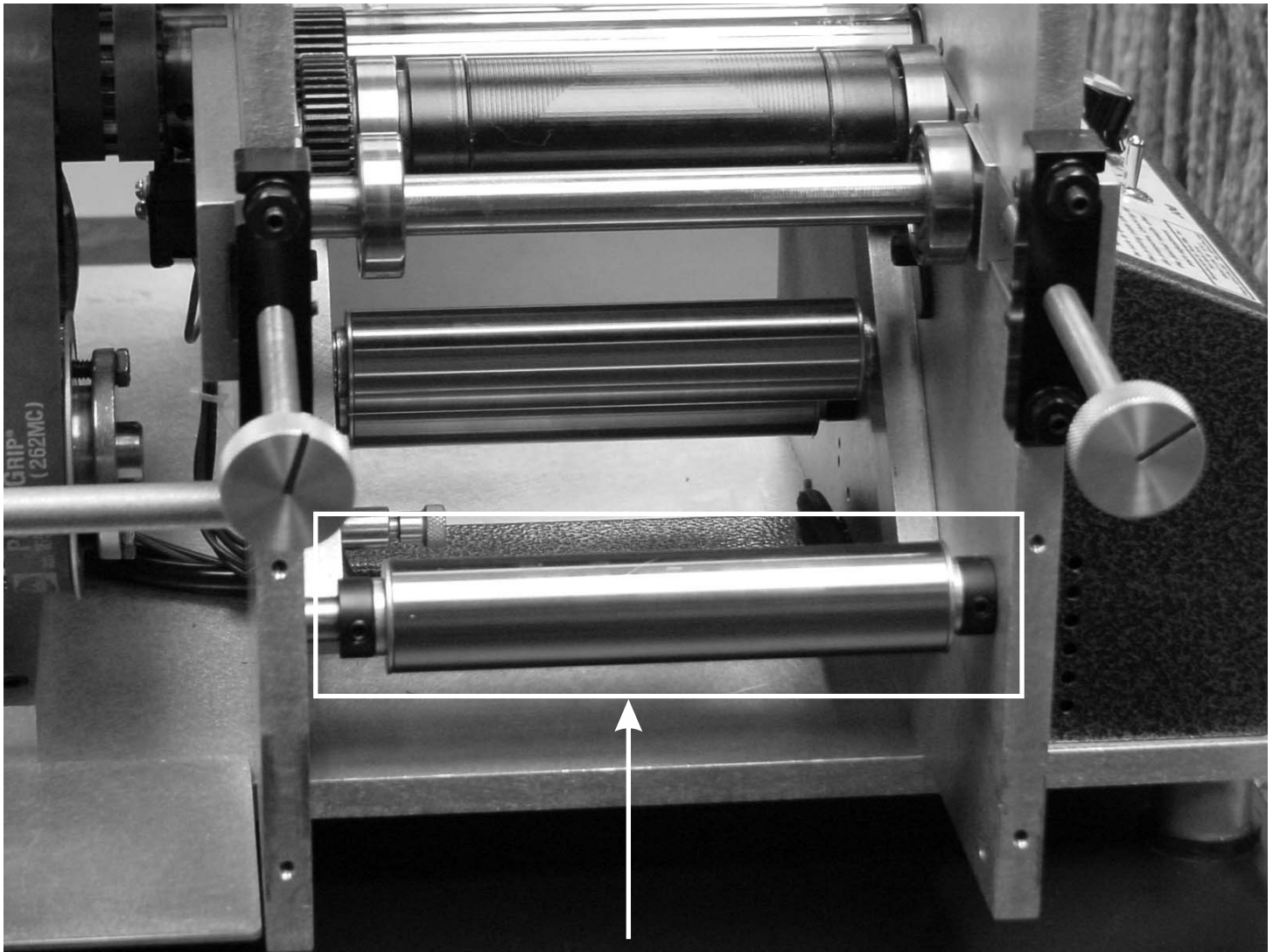
REWIND ASSEMBLY

	PART NO.	DESCRIPTION	QTY.	PRICE / EA.
1	65-687 1	Tension Nut	1	
2	1004-11	Spring	1	
3	SL-302	Tension Collar Screw.....	3	
4	65-735 3	Clutch Collar.....	2	
5	65-738	Drive Clutch Collar.....	1	
6	65-735 2	Clutch Collar.....	1	
7	99-437 1	Clutch Disk.....	3	
8	99-437	Clutch Disk.....	1	
9	65-732	Core Holder.....	1	
10	65-740	Core Holder Spacer.....	2	
11	1001-12	Core Holder Bearing.....	2	
12	65-664 1	Waste Rewind Mount.....	1	
12a	65-664 2	Product Rewind Mount.....	1	
13	65-595 1	Waste Rewind Shaft.....	1	
13a	65-595 2	Product Rewind Shaft.....	1	
14	2000-19	Drive Pulley.....	1	
15	65-417	Core Lock Pin (not shown).....	1	



1" DIA. COREHOLDER OPTION

	PART NO.	DESCRIPTION	QTY.	PRICE / EA.
1	65-159 1	Core Lock Pin.....	1	
2	1004-11	Spring.....	1	
3	65-579 1	Coreholder.....	1	
4	65-595 3	Rewind Shaft.....	1	
5	65-664 5	Rewind Shaft Mount.....	1	
6	65-687 1	Tension Nut.....	1	
7	65-740	Coreholder Spacer.....	2	
8	2000-20	Drive Pulley.....	1	
9	7655 2	Felt Washer.....	1	
10	7656	Rewind Tension Collar.....	1	
11	7682	Tension Collar.....	1	
12	1001-12	Bearing.....	2	
13	D054003	Screw.....	1	



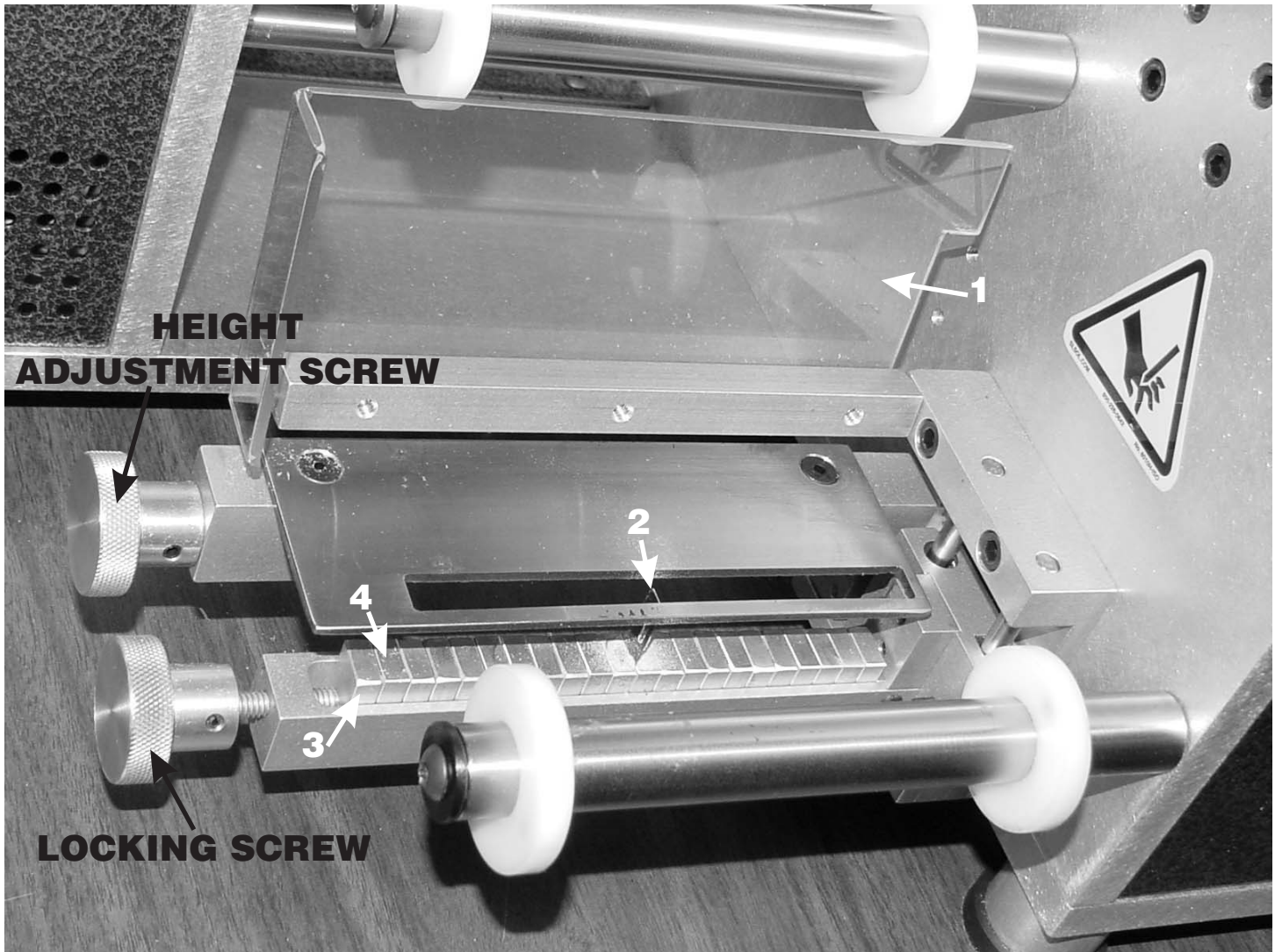
IDLER ROLLER ASSEMBLY

	PART NO.	DESCRIPTION	QTY.	PRICE / EA.
1	65-760	Idler Roller Assembly.....	1	

SLITTER ASSEMBLY (OPTIONAL)

SLITTER HEAD: Slitting is accomplished by removable blades held in the head by pressure from the outboard locking screw. To insert blades, loosen the locking screw and position the spacers as required and insert the blades in the groove. Also insert a blade at the inside end of the spacers where it will serve as an edge guide. Tighten the locking screw. The blades may also be cut in two and inserted vertical to the web.

When slitting paper, the web normally slides across the top edge of the slitting head. When slitting pressure-sensitive tape, the head should be adjusted downward to provide 1/16" clearance between the head and the web. Vertically mounted blades can be used on this operation.

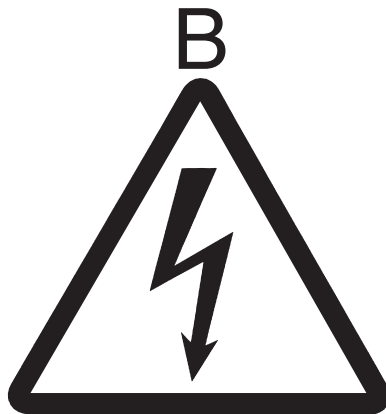
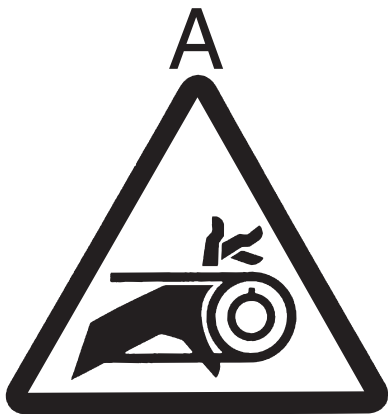
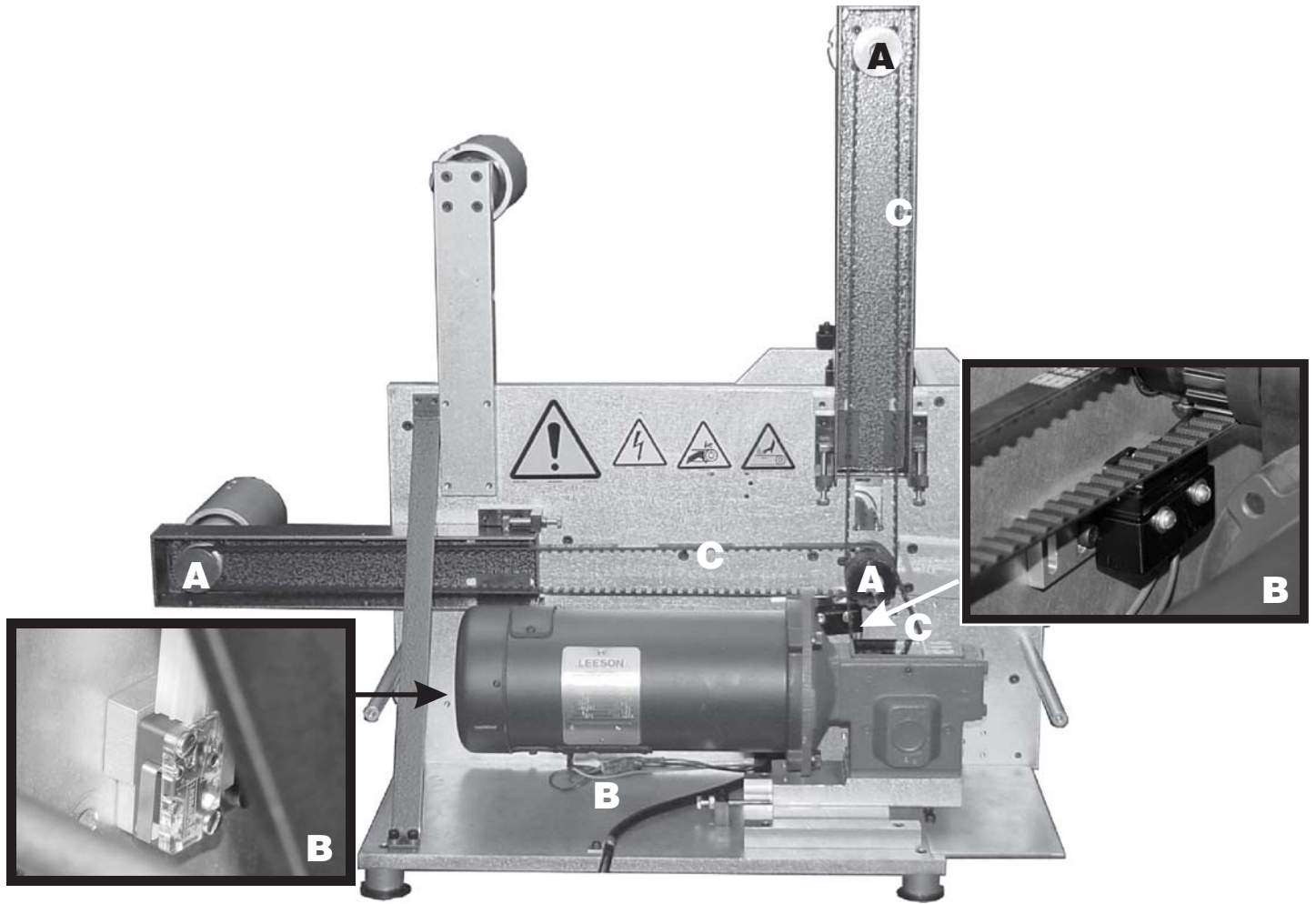


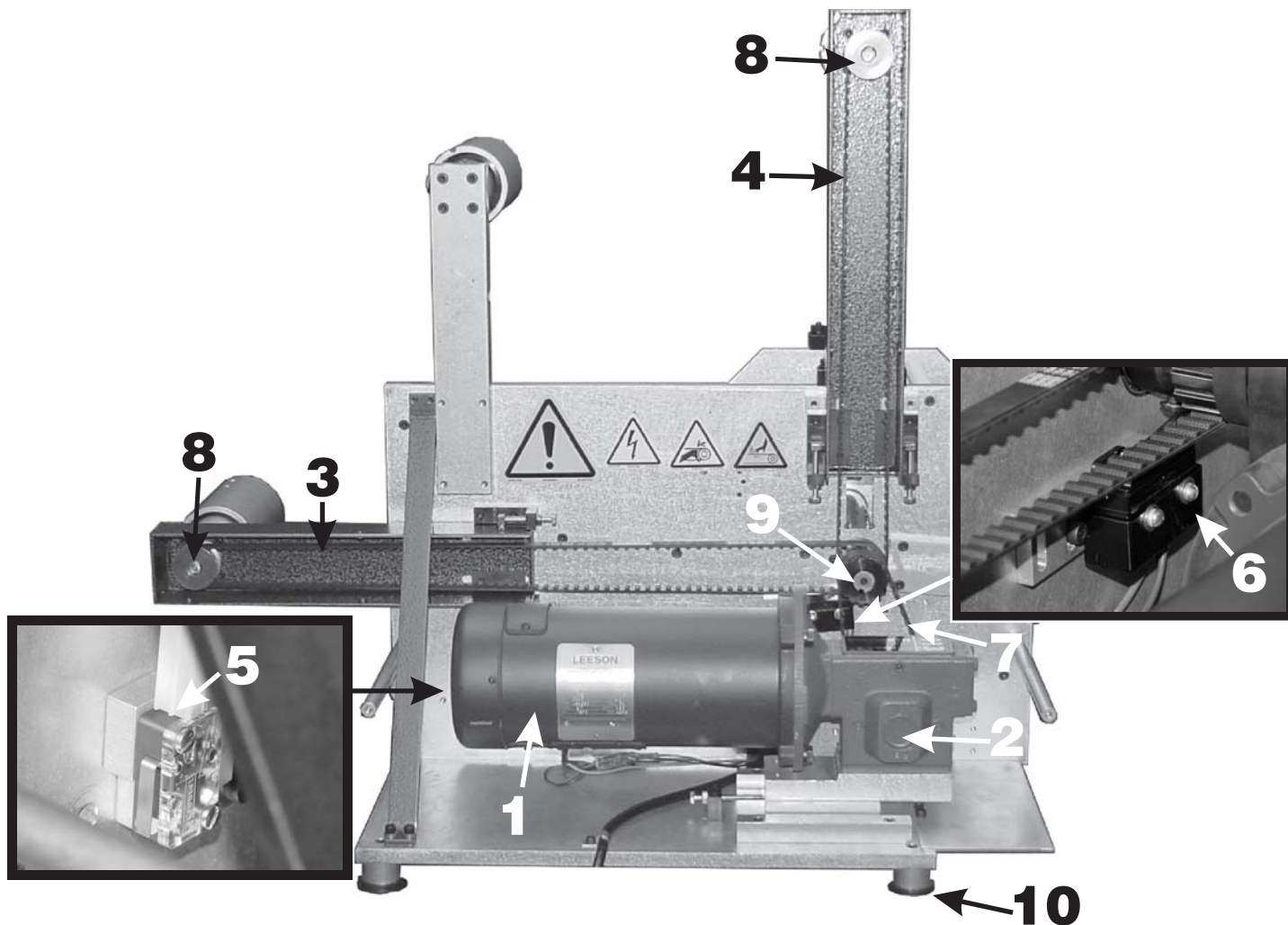
	PART NO.	DESCRIPTION	QTY.	PRICE / EA.
1	65-714	Slitter Guard.....	1	
2	3021	Slitter Blade.....	1	
3	65-737 4	Slitter Spacer, Steel.....	1	
4	65-737	Slitter Spacer.....	1	
(Note: Call Sohn Mfg., Inc. for stock sizes)				





BACK GUARD





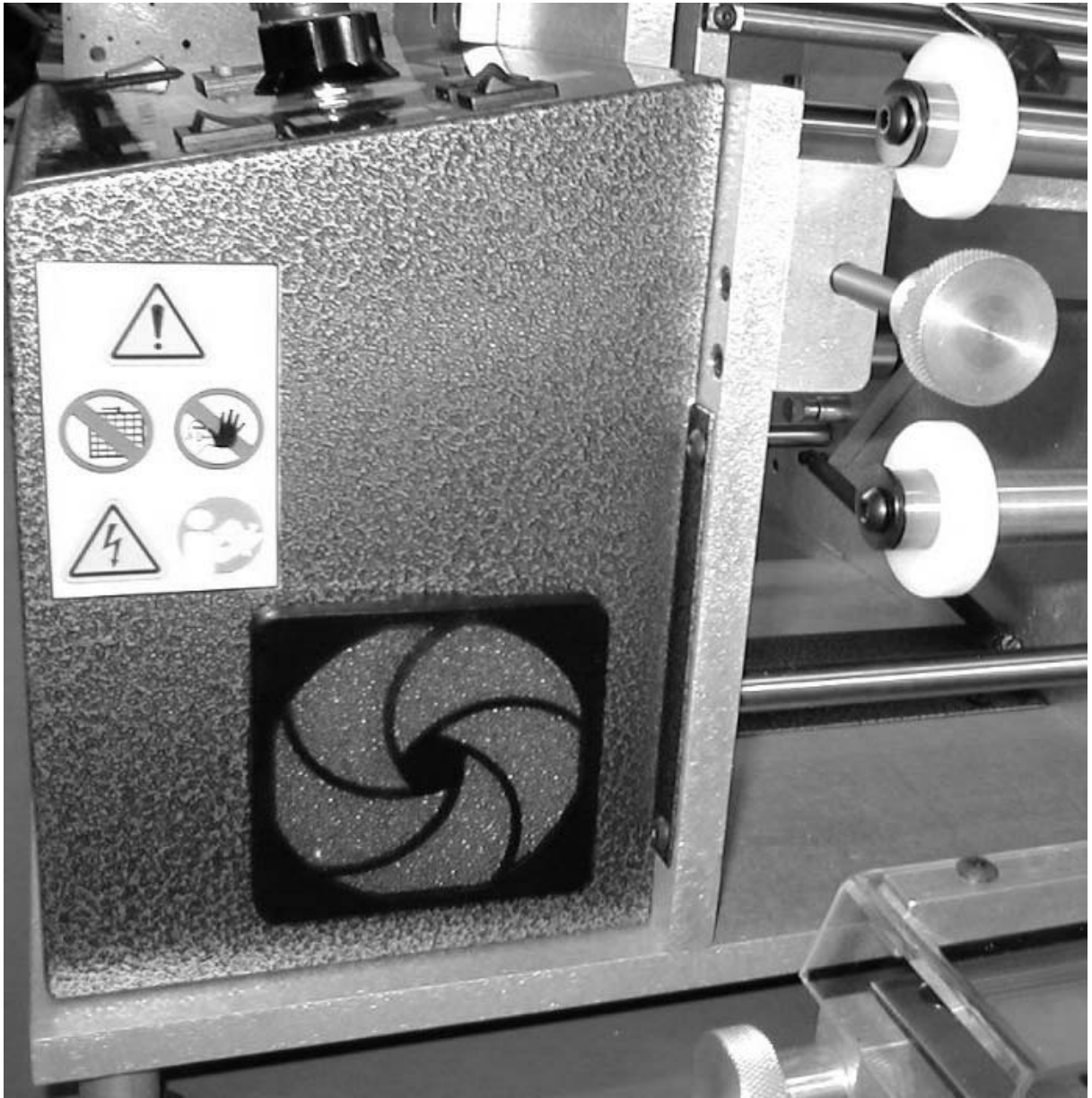
MAIN DRIVE ASSEMBLY

	PART NO.	DESCRIPTION	QTY.	PRICE / EA.
1	5144	Drive Motor.....	1	
2	2000-02	Gear Box.....	1	
3	2000-16	Product Rewind Belt.....	1	
4	2000-17	Waste Rewind Belt.....	1	
5	5108	Slitter Guard Switch.....	1	
6	5145	Counter Micro Switch.....	1	
7	2002-18	Main Drive Belt.....	1	
8	2002-19	Drive Pulley.....	2	
9	65-665	Main Drive Pulley.....	1	
10	65-750-1	Foot Assembly.....	5	

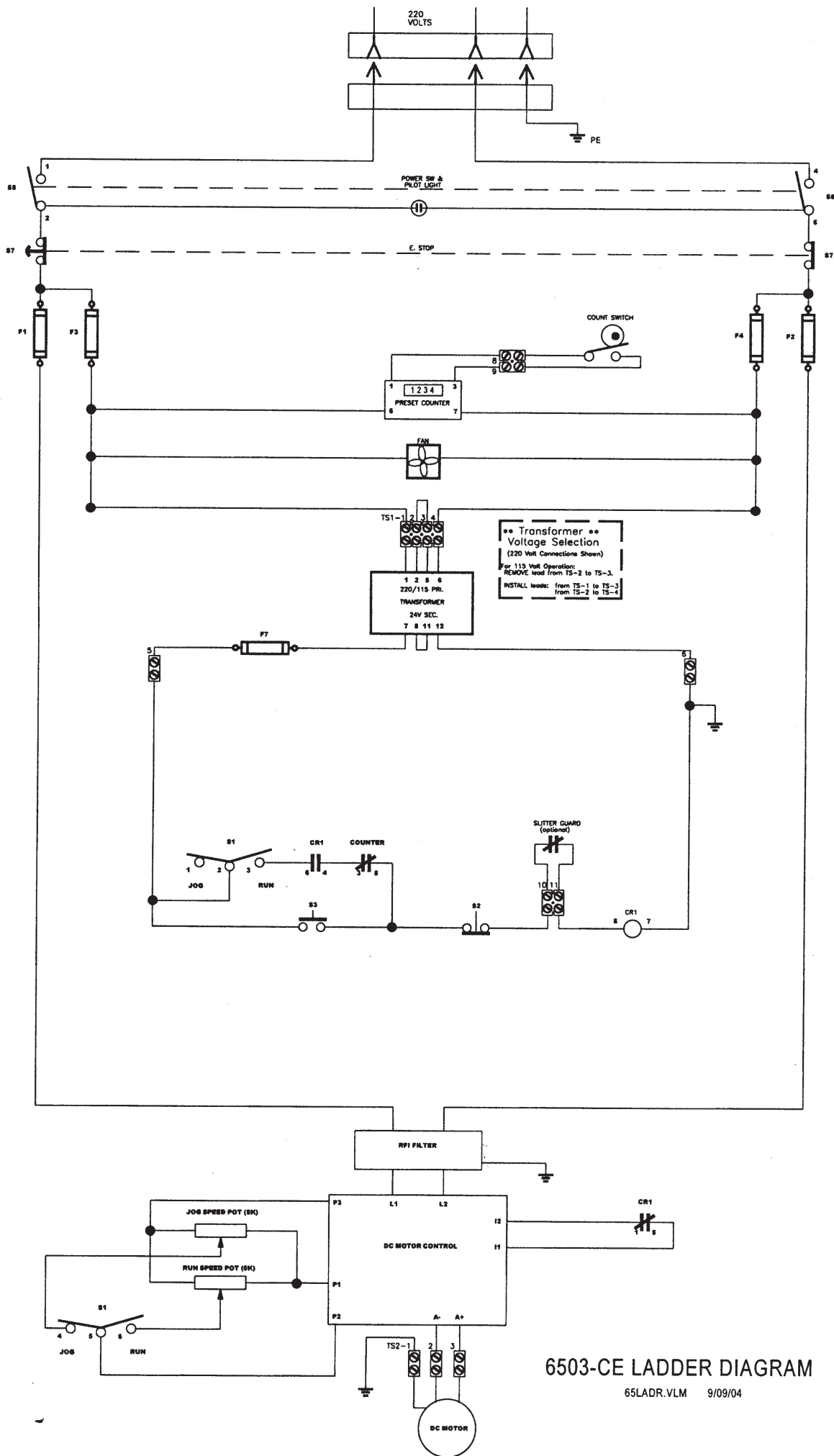


WARNING!

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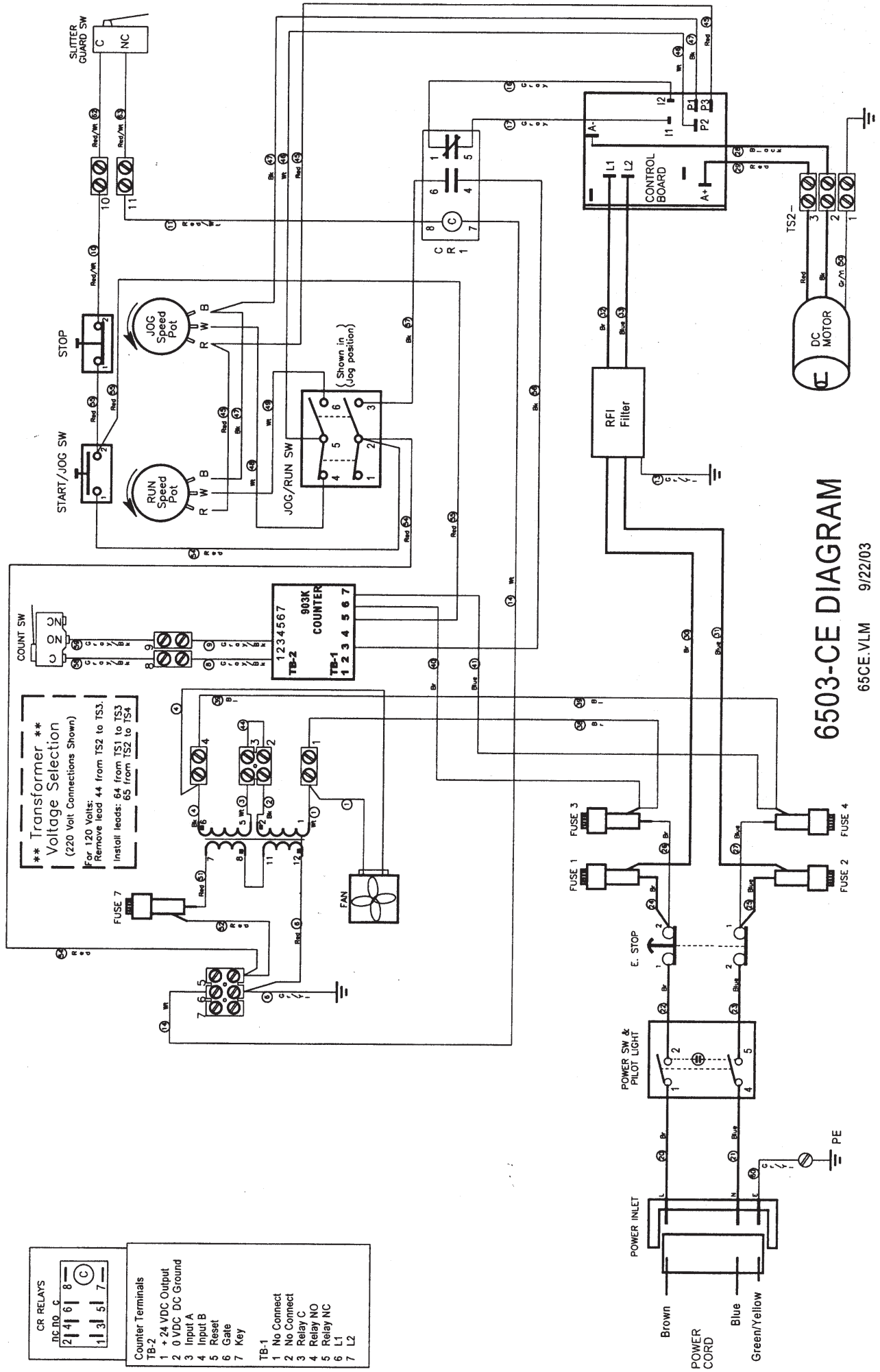


FRONT GUARD



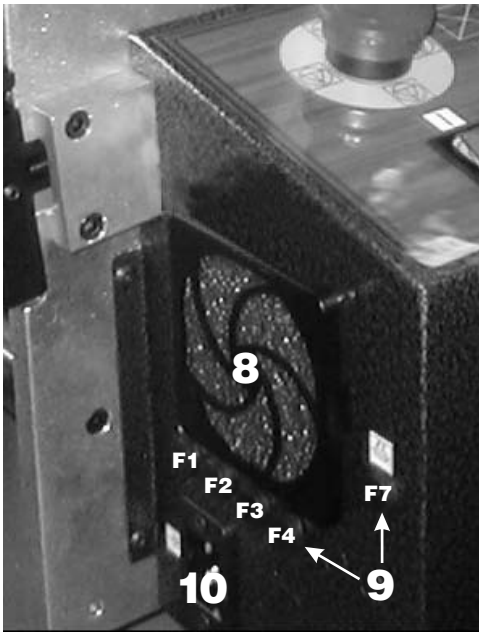
6503-CE LADDER DIAGRAM

65LADR.VLM 9/09/04



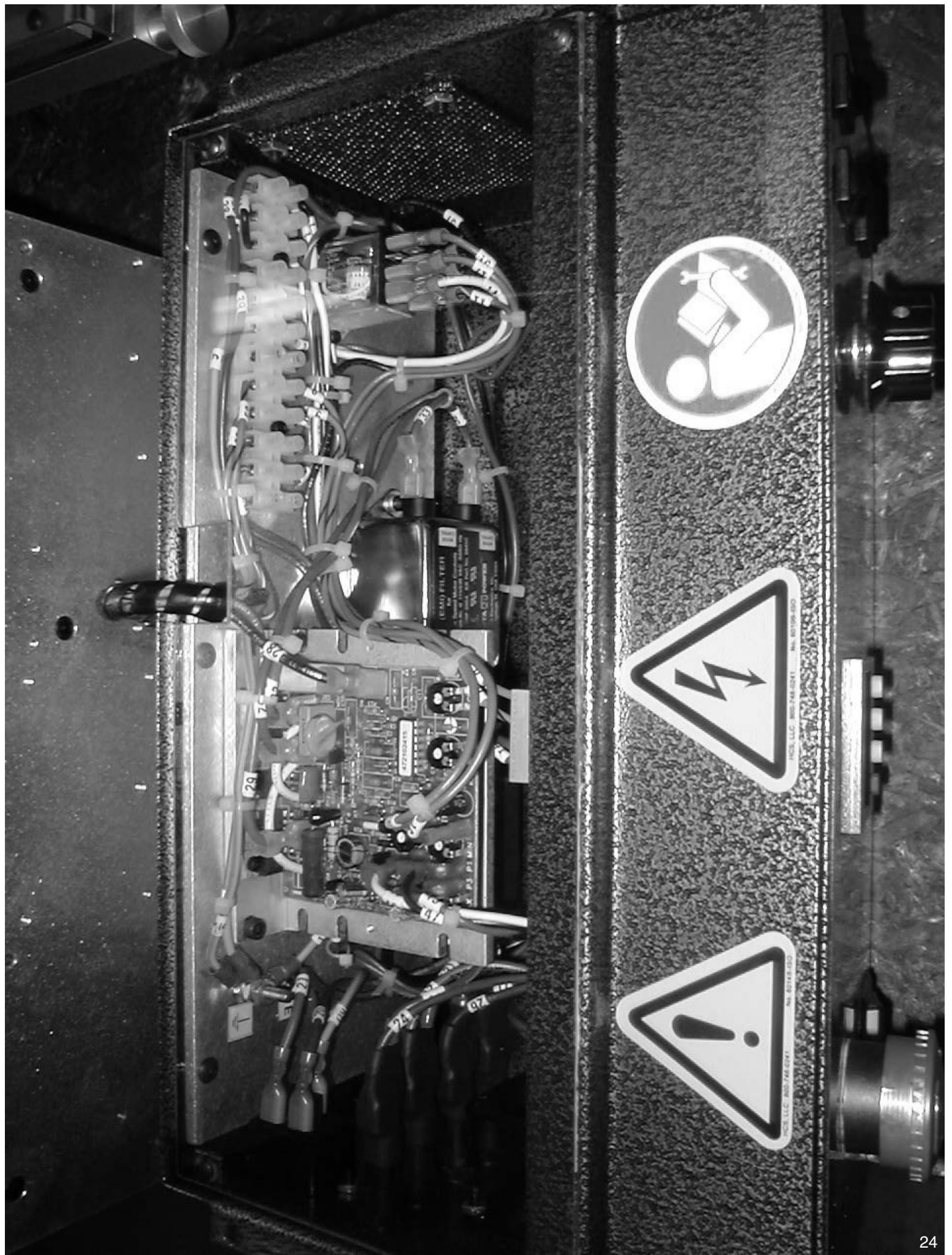
6503-CE DIAGRAM

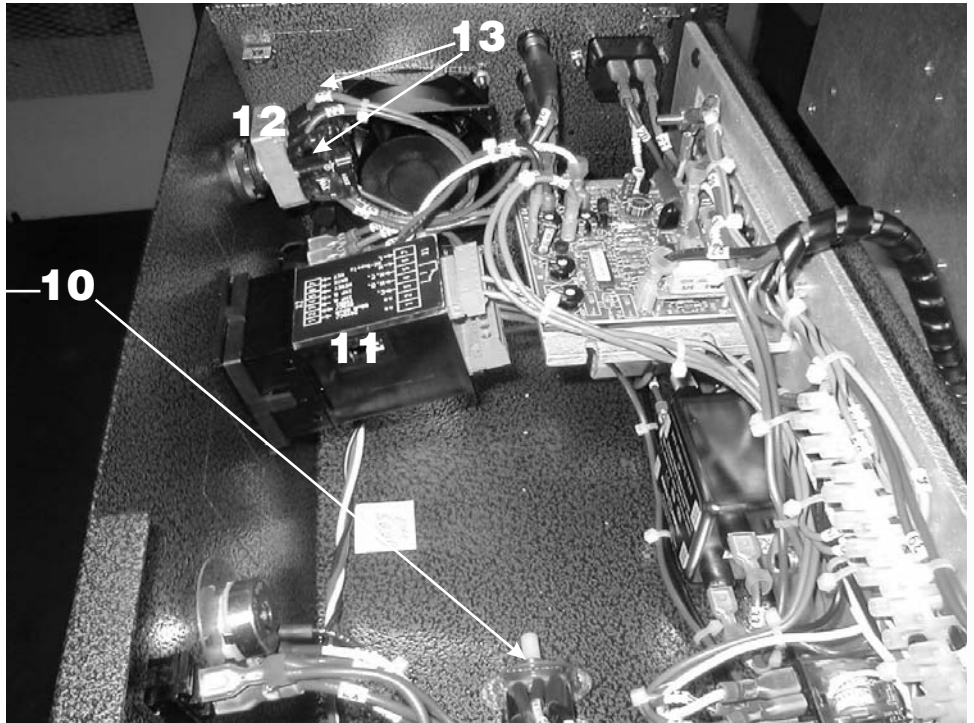
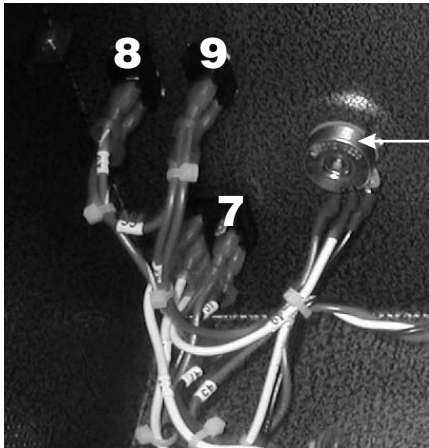
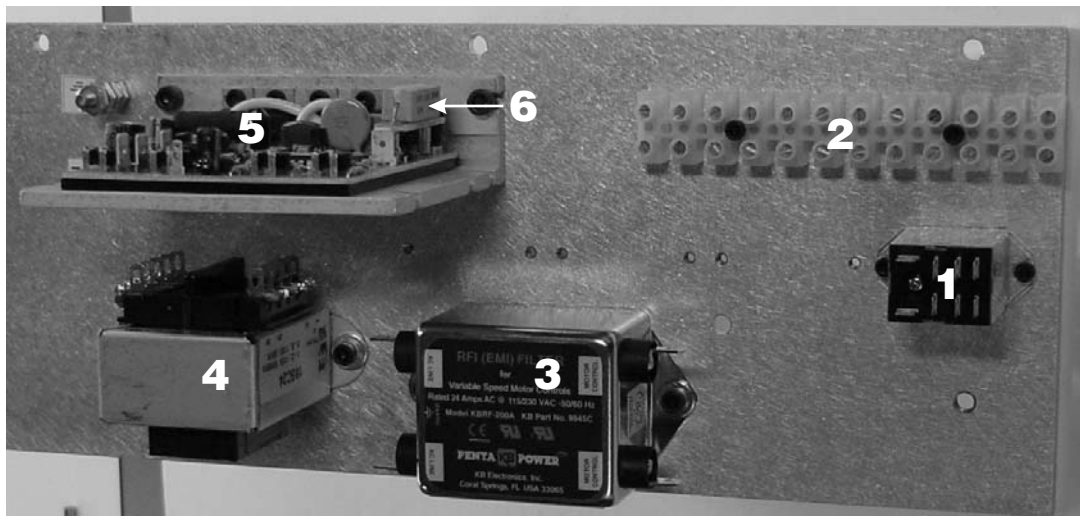
65CE.VLM 9/22/03



EXTERNAL ELECTRICAL ASSEMBLY

	PART NO.	DESCRIPTION	QTY.	PRICE / EA.
1	5120	Switch (run/jog).....	1	
2	5119	Switch (stop).....	1	
3	5118	Switch (start).....	1	
4	5013	Knob.....	1	
5	5061	Counter (200-230V).....	1	
	5069	Counter (120V).....	1	
6	5096	Switch (E stop button).....	1	
7	5123	Switch (power 220V).....	1	
	5122	Switch (power 120V).....	1	
8	5127	Fan (220V).....	1	
	5128	Fan (120V).....	1	
	5129	Fan Guard.....	2	
	5130	Fan Filter.....	2	
9	5112	Fuse Holder (5 x 20mm).....	5	
	5124	Fuse (10A) F1, F2.....	2	
	5125	Fuse (5A) F3, F4.....	2	
	5126	Fuse (0.8A) F7.....	1	
10	5133	Power Inlet.....	1	
	5134	Power Cord (not shown) 110 Volts.....	1	
	5137	Power Cord (not shown) 220 Volts International.....	1	





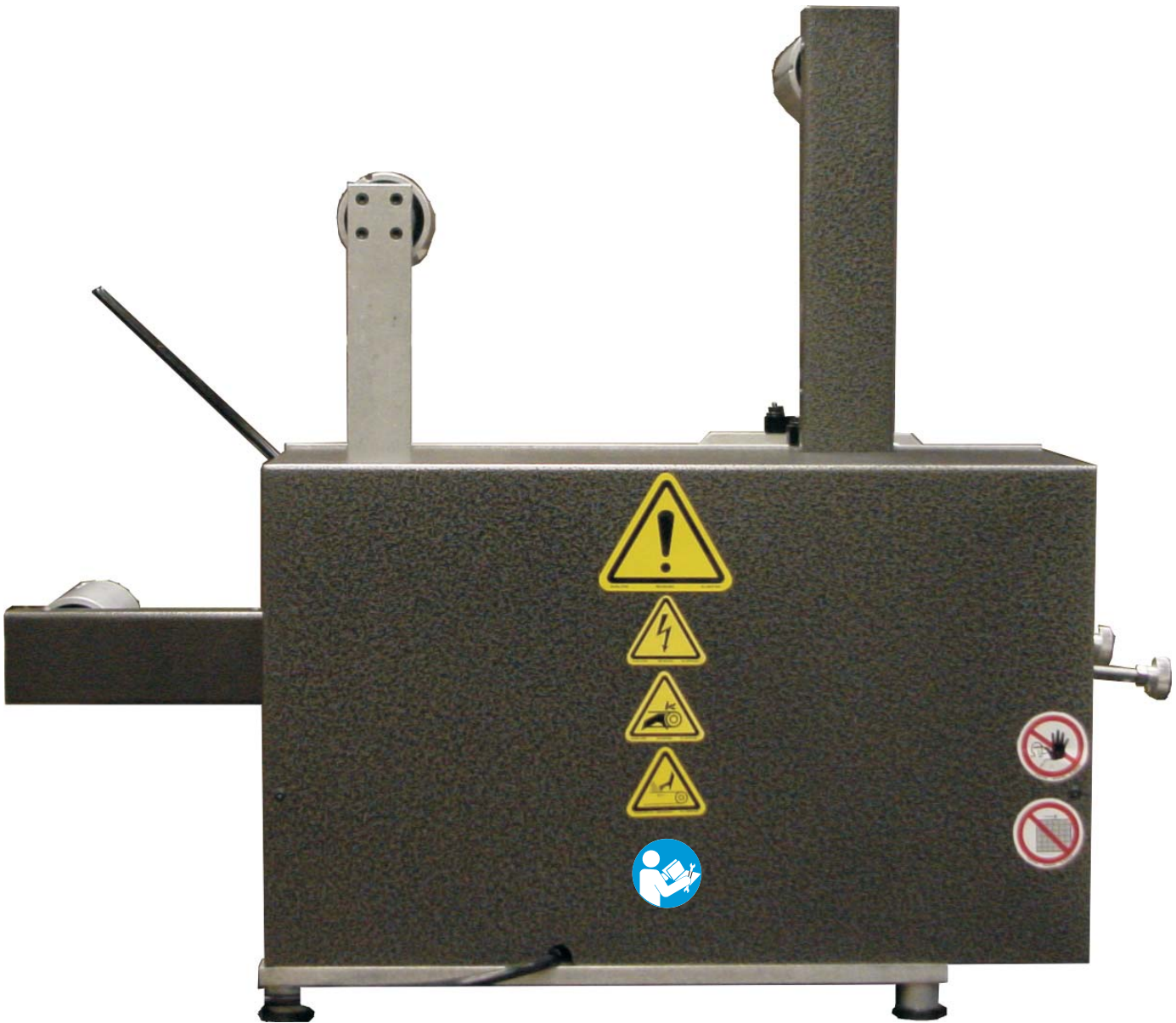
INTERNAL ELECTRICAL ASSEMBLY

	PART NO.	DESCRIPTION	QTY.	PRICE / EA.
1	5115	Relay.....	1	
2	5116	Terminal Strip.....	1	
3	5104	RFI Filter.....	1	
4	5113	Transformer.....	1	
5	5087	Motor Control.....	1	
6	5036	3/4 HP Resistor.....	1	
7	5120	Switch (run/jog).....	1	
8	5119	Switch (stop).....	1	
9	5118	Switch (start).....	1	
10	5074	Potentiometer.....	2	
11	5061	Counter (200-230V).....	1	
	5069	Counter (120V).....	1	
12	5098	Switch (E stop) contact block mount.....	1	
13	5097	Switch (E stop) contact assembly.....	2	
	5135	Fan Cord (not shown).....	1	

SERVICE LOG

[illegible]

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