

Sampson

Sampson's Insole Rib and Insole Rib Attaching Machinery

Parts & Service Manual

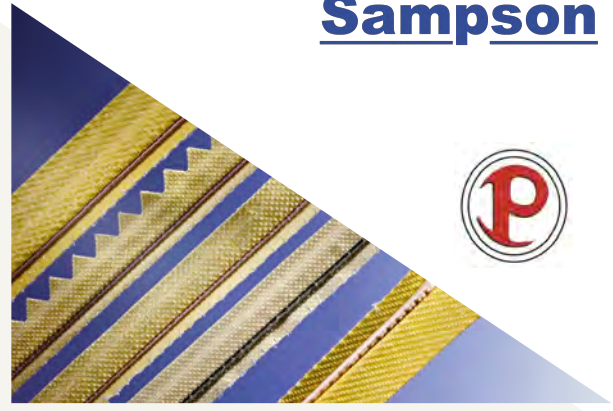
MODEL: S/PCM

*Sampson's Prime Cabinet Model
Rib Layer*

SERIAL NUMBER



Sampson



Worthen Industries, Inc.

34 Cellu Drive

Nashua NH 03063 USA

Telephone: 603-821-5955

Fax: 603-888-8466

www.SampsonsRib.com

March 2013

For Sales and Technical Support Please Contact:
Visit us online at SampsonsRib.com for user and parts manuals.

USA CORPORATE HEADQUARTERS:

Worthen Industries, Inc.

3 East Spit Brook Rd.

Nashua, NH 03060

Sales

Telephone: 603-821-5955

Fax: 603-888-84666

cwright@worthenind.com

USA MANUFACTURING LOCATION:

Worthen Industries, Inc.

34 Cellu Drive

Nashua, NH 03063

Technical Service

Robert Sampson

Business Unit Manager

Telephone: 603-821-5901

Fax: 603-821-6331

bsampson@worthenind.com

Troy Medeiros

Market Manager

Telephone: 603-821-5938

Fax: 603-821-6338

tmediros@worthenind.com

ASIA OFFICES

Upaco Asia Limited, China

Worthen Industries, Inc.

2/F, Commercial Building,

LongWangPu, HaDi, Southern City

DongGuan City

GuangDong Province, 523082

China

Tel: 86- 769-2242-3231 / 86-769-2241-8209

Fax: 86-769-2241-8206

Upaco Asia Limited, Hong Kong

Worthen Industries, Inc.

Unit B3-5, B8-10, Block B

15/F Kong Nam Ind Bldg

603-609 Castle Peak Road

Tsuen Wan, N.T.,

Hong Kong

Tel: 852-2148-6803

Fax: 852-2754-5538

Komplek Pergudangan Kosambi Permai

Jl. Raya Perancis, Block LL 17/18,

Kosambi, Dadap, Tangerang, Indonesia

Tel.: 92855911, 6611866, 55916618

Fax: 55916619, 6611867

Upaco Asia Limited, Vietnam

Worthen Industries, Inc.

Binh Y Hamlet, Tan Binh Commune,

Vinh Cuu District, Dong Nai Province,

Vietnam, 810000.

Tel: +84-613-971-222

Fax:+84-613-971-116

S/PCM RIB LAYER SAFE OPERATION

CAUTION: Please read carefully.

1. All operators and maintenance personnel should read this manual prior to operation or servicing.
2. Protective Eyewear is recommended during operation.
3. Hot Surfaces: The rib layer has a heater (SPC-008) located on the back of the head of the machine that runs very hot, which provides the hot air that flows through the silicone hose to the chute for adhesive activation. Keep hands clear of these surfaces. Wait for machine to cool down prior to servicing.
4. Sharp Knife: The cut off is very sharp and is air operated. Keep hands clear by keeping the insole between the guiding hand and the machine. If it is necessary to service the machine in or around the knife, make sure to shut off & lock out the air supply.
5. Pinch Points: There are several moving parts during operation that can create a pinch hazard. Keep hands clear of all moving parts by keeping the insole between the guiding hand and the machine.
6. Electrical Hazard: The rib layer is 220 V. The electrical enclosure should only be accessed by an authorized electrician. De-energize and lock out before servicing.
7. Machine Guards: DO NOT OPERATE the machine without all machine guards in place and secure.
8. Servicing: Always de-energize and disconnect electrical and compressed air sources, and lock out prior to servicing.
9. Inspect machine for worn parts and replace as needed.
10. Keep machine clean and clear of debris.





Prime Rib Layer Operator Instructions

Models: SRMP, SRMPA, SPCM



OPERATOR & MAINTENANCE

1. The operator should be seated directly in front and facing the Prime Rib Laying machine, within easy reach of both foot pedals and the margin guide handle.
2. To insure proper operation and up keep, please follow the general preventative maintenance & lubrication instructions located at the back of the Service Manual.
3. Prior to servicing or repairing the rib layer, please make sure to de-energize and lock out all power sources (compressed air and electric).

INSTRUCTIONS

1. Set operating air pressure to 80psi on the air regulator.
2. Turn on the rib laying machine and let it run for 5-10 minutes prior to start up to insure the proper heat level is attained. Make sure the toggle switch that is located on the side of the electrical box is in the ON position.
CAUTION: Do not touch the heater (SR-116 or SR-117) when in operation because it will become very hot.
3. Slide a spool of the insole rib, with the end of the rib coming over the top of the spool onto the SR-528A (spool holder) until it hits the shoulder. Insure the spool turns freely with minimal resistance by adjusting the side load of the T-72 against the leather break pad (SR-533).
4. Feed the rib into the Tape Guide Roll (SR-16) between the SR-254M and the roll, and slide the tape into the chute (SR-123BM). **Note: Do not leave the tape in the chute when not in use. A hot chute will activate the adhesive on the tape and will gum up the slot.**
5. Margin Adjustments: Depending on required outside margin, adjust the S100A screws on either side of the handle (SR-129A). Push down on the thumb lever (SR-136A) to shift margin guide left or right. You can set up to three margins.
6. With the table in the lowest position, the operator takes a cemented insole and places it against the margin guide (RL-91) at the desired starting point of the insole. Pull the handle up to lift the table and the hold the insole in place.
7. To operate the feet on the rib layer, step on the right foot pedal and guide the insole around with the left hand. Allow the feet to do the work of pulling the insole through and just guide the insole around. **Note: The pedal is a throttle and will speed up or slow down the feet when pressure is applied or released.**
8. To stop or slow down, release the right foot pedal.
9. To cut the rib, apply pressure to the left foot pedal, which activates the knife. This will lift the rib chute and fire the knife from right to left to cut the rib. Please make sure the SR-222M is in the correct position, which holds the chute cam in place during cutting (see figures 1 & 2 below). Once the knife cuts the rib, lightly press on the right foot pedal to finish pulling the insole through and drop the table to reset the knife back to the right.

CAUTION: Keep hands clear when from knife. Always lock out the air supply when serving the knife or parts in or around it.



Figure 1

Position of SR-222M
before firing knife

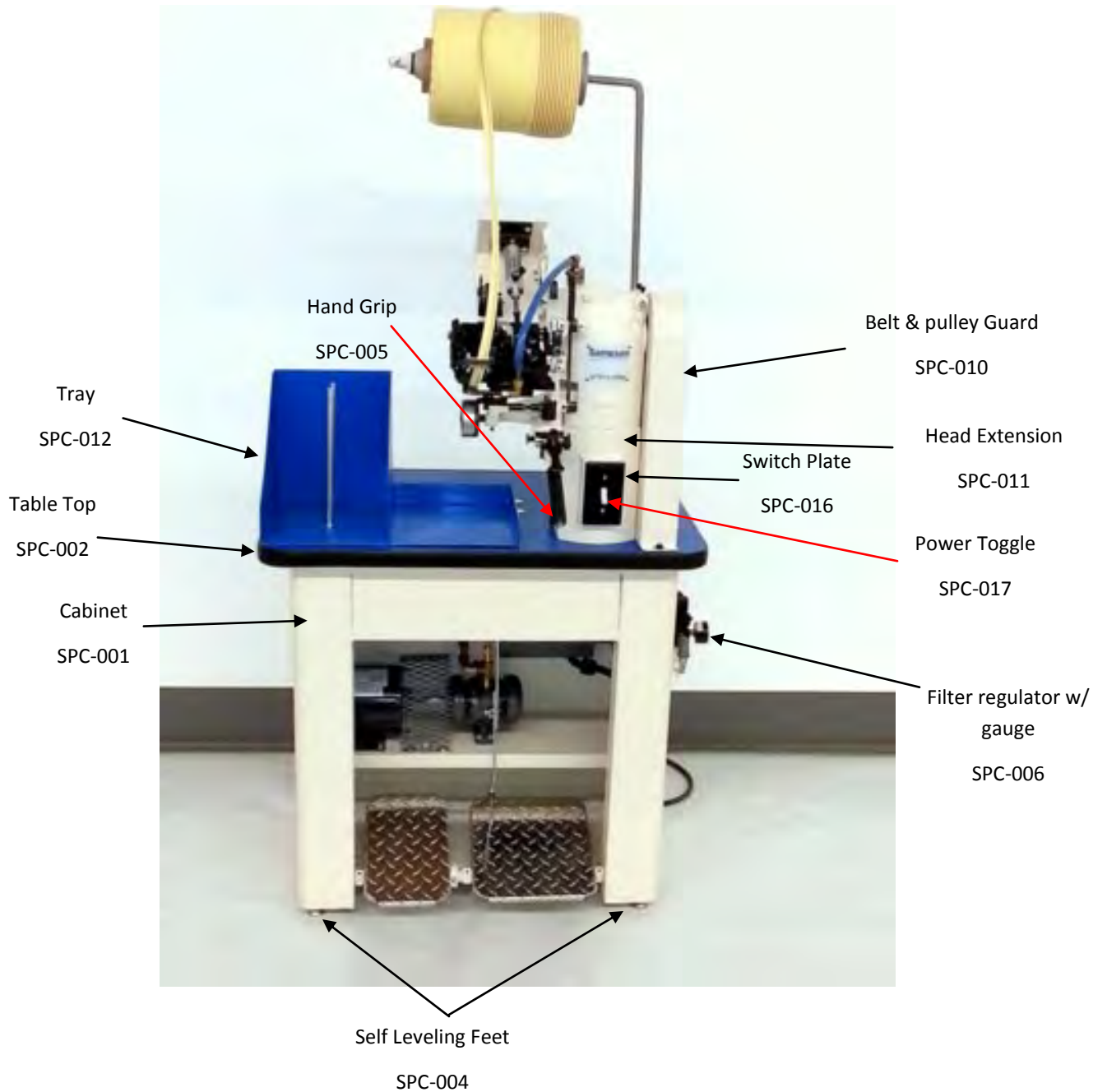


Figure 2

Position of SR-222M
after firing knife

S/PCM CABINET PARTS LIST

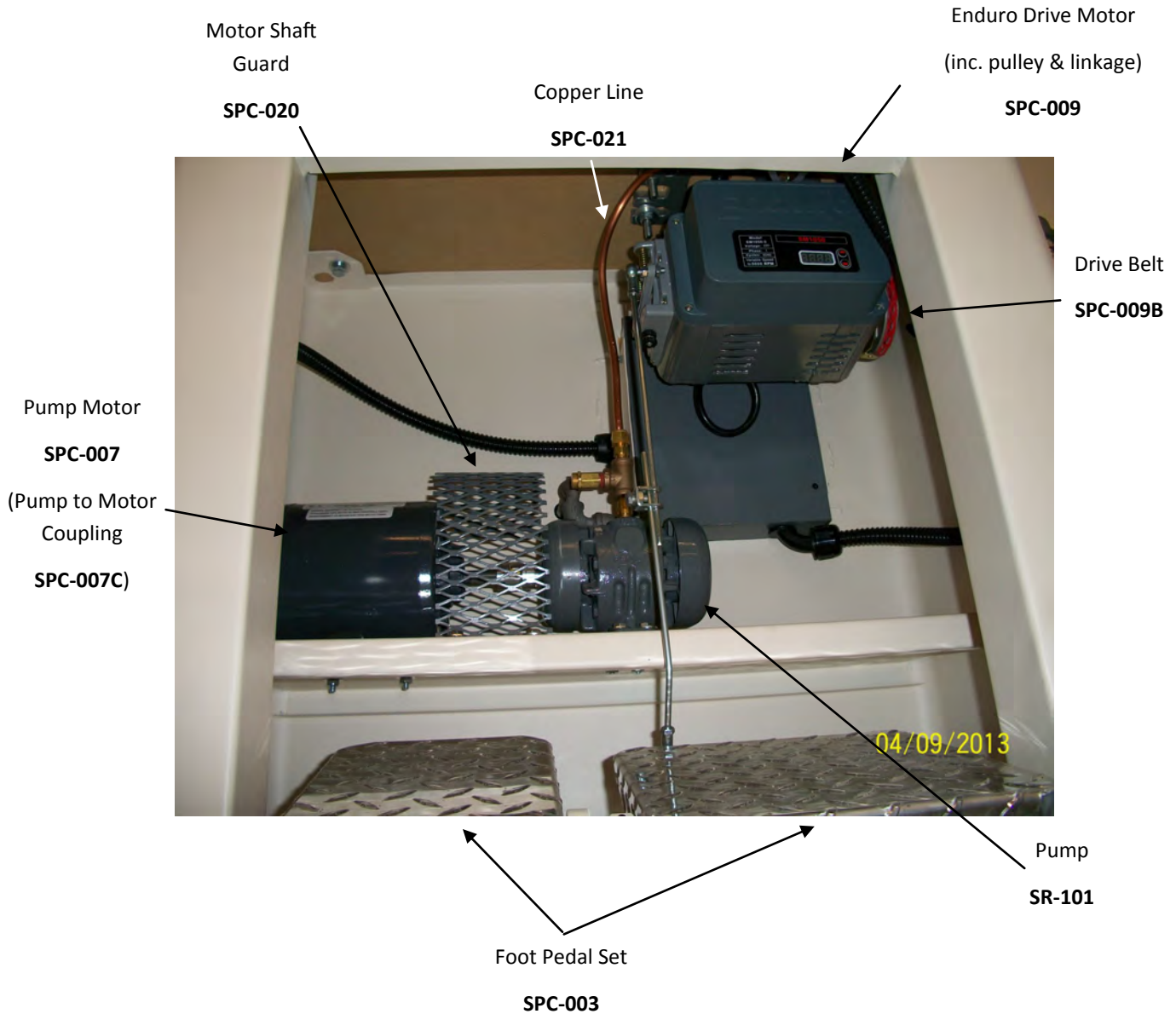
SPECIAL NOTE: Minimum operating pressure setting on the SPC-006 is 80psi.



S/PCM DRIVE COMPONENTS

SPECIAL NOTE: SR-101 is a maintenance free pump. **DO NOT** add oil into pump.

For information on the SPC-009 Drive Motor see the manual for the Enduro S-M1050-2 located on our website.



S/PCM ELECTRICAL COMPONENTS

Heating Element
400W 230V
SPC-008



Electrical Enclosure including
mounting panel
SPC-015



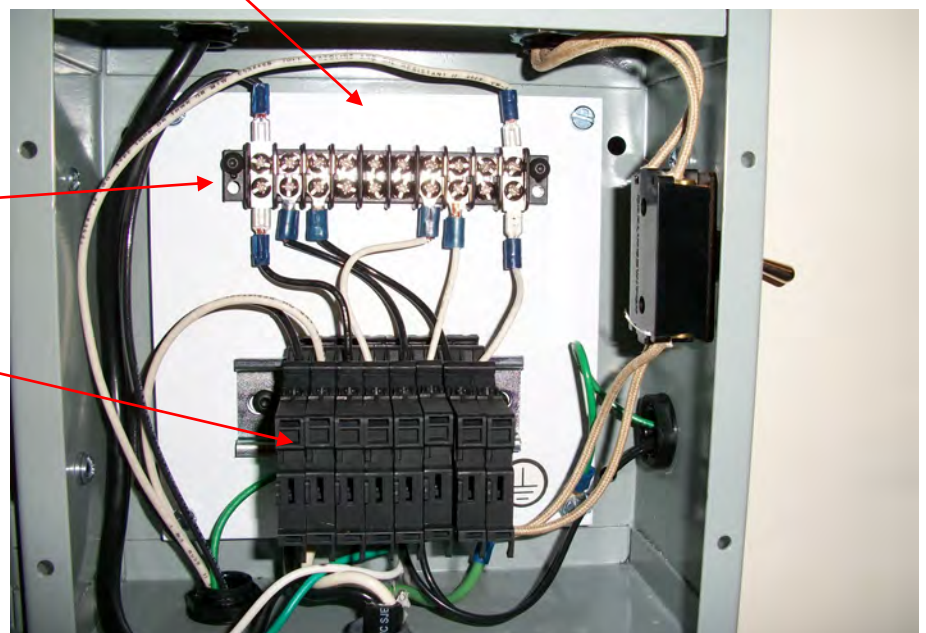
Plastic Filter Jar Only
SPC-019

Terminal Strip
SPC-013

Fuse Holders
SPC-014

FUSES

- (2) 2 AMP HEATER—SPC-014-F2
- (4) 3 AMP MOTOR—SPC-014-F3
- (2) 10 AMP MAIN—SPC-014-F10



S/PCM SPECIFIC PARTS LIST

Parts below are specific to the S/PCM model. All head parts are the same as the SRM Prime Models, which are listed on the pages for Plates 1A through 4A.

PART	DESCRIPTION
SPC-001	Cabinet Base
SPC-002	Cabinet Shelf Top with screw inserts
SPC-003	Diamond Plate Foot Pedal Set
SPC-003C	Foot Pedal Shaft Collars
SPC-004	Swivel Leveling Foot Mounts
SPC-005	Hand Grip (Black)
SPC-006	Stacked Filter Regulator
SPC-007	50Hz 1/3HP Motor for Pump
SPC-007C	Motor to Pump Coupling
SPC-008	Heating Element 400W 230V with 48" lead
SPC-008C	Heater to Conduit Coupling
SPC-009	Drive Motor SM1050-2 & pulley
SPC-009B	Drive Belt
SPC-009-P75	75mm Drive Motor Pulley w/mounting hardware
SPC-010	Belt & Pulley Guard
SPC-011	8" Prime Head Extension
SPC-012	Work Tray
SPC-013	10 Circuit Terminal Strip
SPC-013J	Terminal Jumpers
SPC-014	Fuse Holders
SPC-014-F2	2 amp FA Heater Fuse
SPC-014-F3	3 amp TD Motor Fuse
SPC-014-F10	10 amp TD Main Fuse
SPC-015	8 x 8 Electric Enclosure with Panel
SPC-016	Switch Plate
SPC-017	20amp 110/220V Power Toggle
SPC-019	Plastic Filter Jar
SPC-020	Exp Mtl Pump Motor Shaft Guard
SPC-021	18" 5/16" Copper Heater Tubing

These do not apply to Model S/PSM serial # 0001-13



Plate 3A

<u>PART NUMBER</u>	<u>PART NAME</u>	<u>QUANTITY</u>
<u>TAPE SHUTE PARTS (CONT.)</u>		
SR-210AM	Tape Adjusting Lever	1
S-295	Connecting Screw (Lever to hanger)	1
W-10	Screw Washer	1
S-292	Connecting Screw (Lever to Hanger)	1
N-2	Connecting Screw Nut	1
W-2	Nut Washer	1
S-14	Shute Hanger Adjusting Screw	1
N-8	Adjusting Screw Lock Nut	1
SR-4	Tape Guide	1
SR-8A	Tape Guide Hanger	1
S-86	Hanger Binding Screw	1
W-38	Binding Screw Lock Washer	1
S-277	Guide Hanger Adjusting Screw	1
SR-14	Guide Spring	1
S-55	Spring Binding Screw	1
S-167	Spring Adjusting Screw	1
SR-123BM #2	Heat Shute (Without Holes)	1
SR-123BM #3	Heat Shute (With 6 Holes) (Specify)	1
S-277	Heat Shute Binding Screw	1
W-4	Binding Screw Washer	1
SR-5	Heat Shute Key	1
S-12	Key Screws	2
SR-237M	Tape Roll Support	1
S-277	Support Screw	1
W-45	Support Screw Washer	1
SR-16	Tape Guide Roll	1
S-98	Guide Roll Stud	1
N-4	Stud Nut	1
SR-254M	Tape Roll Guide	1
SR-181	Tape Retaining Latch	1
SR-182	Retaining Latch Spring	1
SR-183	Retaining Latch Pin	1
<u>BASE PLATE ON FRAME SR-1M & PARTS</u>		
SR-206AM	Base Plate	1
SR-213M	Spacer Bar	1
S-281	Spacer Bar Screw	1
W-45	Screw Lock Washer	1
S-300	Spacer Bar Clamp Screw	1
N-29	Clamp Screw Lock Nut	1
W-45	Lock Nut Washer	1
SR-238M	Tape Shearing Plate Support (Left)	1
S-277	Plate Support Screw	1
W-45	Screw Washer	1
SR-223AM	Tape Retaining Plate	1
SR-252M	Retaining Plate Bearing	1
SR-321AM	Bearing Retainer	1
S-280	Retainer Screws	2
W-38	Screw Washers	2

PLATE 1A

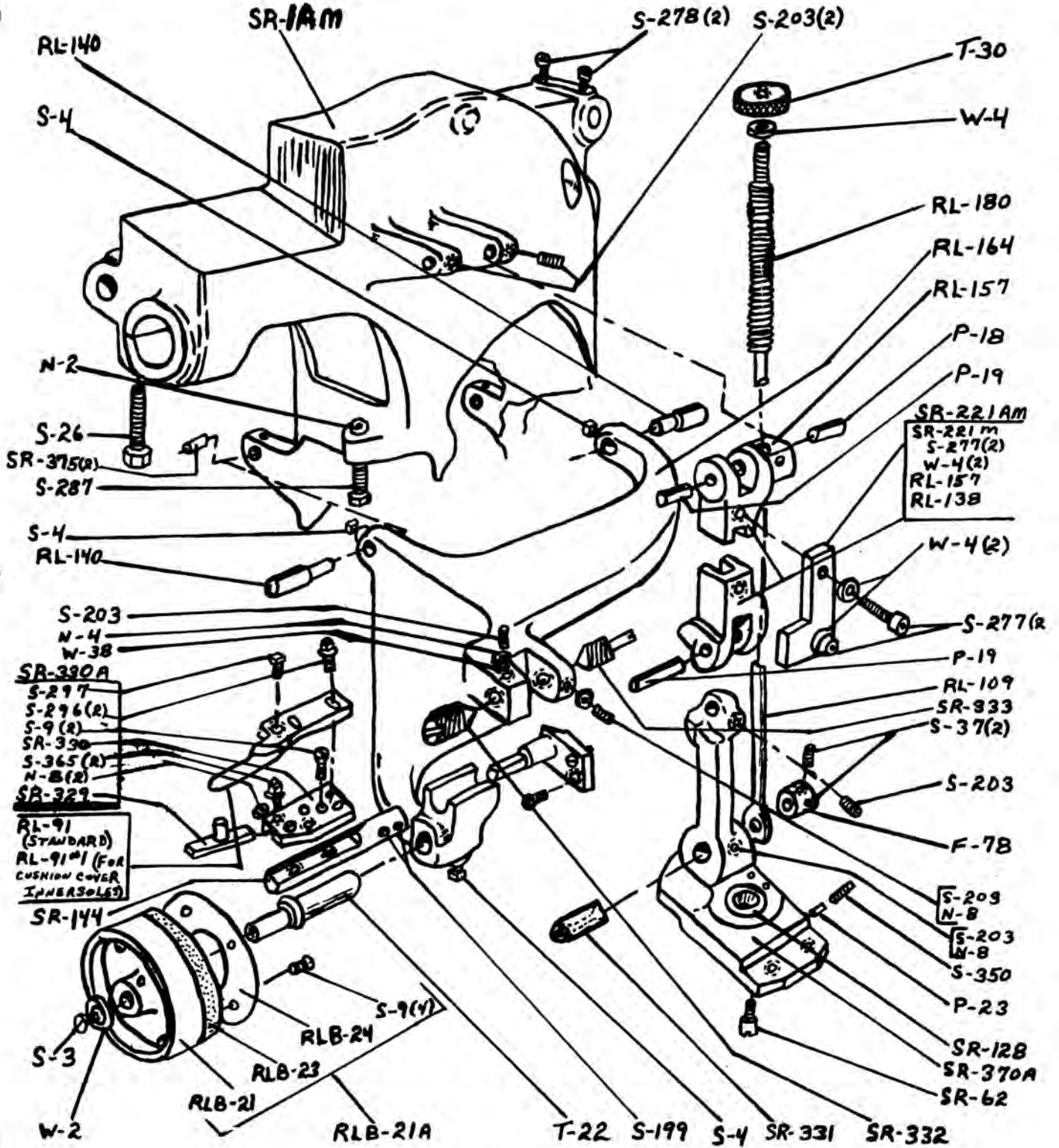


Plate 1A

<u>PART NUMBER</u>	<u>PART NAME</u>	<u>QUANTITY</u>
<u>LOWER ARM PARTS (CONT.)</u>		
P-18	Toggle Hinge Pin (Right)	1
P-19	Toggle Hinge Pin (Left)	1
S-203	Pin Set Screws	2
RL-109	Pressure Rod	1
RL-180	Pressure Rod Spring	1
T-30	Spring Adjusting Nut	1
W-4	Spring Washer	1
<u>BALTIMORE ATTACHMENT PARTS</u>		
SR-370A	Lower Toggle Arm	1
SR-128	Lower Toggle Arm Bushing	1
SR-331	Lower Toggle Arm Stud	1
S-203	Stud Locking Screw	1
N-8	Stud Locking Screw Nut	1
SR-62	Arm Stop Screw	1
P-23	Arm Stop Screw Locking Plug	1
S-350	Arm Stop Screw Locking Screw	1
SR-144	Guide Slide	1
S-199	Slide Screws	2

Plate 2A

<u>PART NUMBER</u>	<u>PART NAME</u>	<u>QUANTITY</u>
<u>SOLENOID AIR VALVE & AIR CUT OFF CYLINDER PARTS</u>		
SR-493	Solenoid Air Valve 230/60 or SR-490 110/60	1
SR-407	Reducer Bushing for Elbow	1
SR-411	Solenoid Air Valve Elbow	1
SR-495	Inlet Hose for Solenoid Air Valve	1
SR-407	Reducer Bushing for Half Union	1
SR-412	Half Union	1
SR-487	Air Cylinder Fulcrum Brackets	2
S-184	Air Cylinder & Air Valve Connecting Screws	4
W-36	Air Cylinder & Air Valve Connecting Screw Washers	4
N-26	Air Cylinder & Air Valve Connecting Screw Nuts	4
SR-489	Air Cut Off Cylinder	1
SR-411	Air Cut Off Cylinder Elbow	1
SR-494	Solenoid Valve Hose to Air Cut Off Cylinder	1
SR-488	Air Cylinder Adjusting Stud	1
N-43	Air Cylinder Adjusting Stud Lock Nuts	2
SR-203M	Air Cylinder Connecting Rod Block	1
S-273	Connecting Rod Block Stud	1
N-13	Block Stud Nuts	3
W-49	Stud Nut Washers	1
<u>BASE PLATE ON FRAME SR-1AM & PARTS</u>		
JR-206AM	Base Plate	1
S-84	Connecting Screw (Base Plate to Frame)	1
W-49	Screw Washer	1
S-277	Base Plate to Head Screw	1
W-45	Screw Washer	1
SR-274M	Base Plate Adjusting Bracket	1
S-277	Bracket Screws	2
S-300	Adjusting Screw	1
N-2	Adjusting Screw Lock Nut	1
SR-268M	Base Plate Latch	1
S-300	Latch Screw	1
N-2	Lock Nut	1
SR-269AM	Latch Fulcrum Pin	1
P-116	Cotter Pin	1
SR-226M	Shute Cam Return Stop	1
S-266	Return Stop Screws	2
W-38	Screw Lock Washers	2
SR-222M	Tape Shute Latch	1
S-180	Latch Screw	1
N-2	Latch Screw Nut	1
W-4	Nut Washers	2
SR-196AM	Shute & Knife Operating Cam (Assembly)	1
SR-196M	Shute Cam	1
SR-291M	Knife Operating Cam	1
S-266	Cam Connecting Screws	2
W-38	Screw Lock Washers	2
SR-214AM	Tape Retaining Plate Cam Gear & Shaft	1

Plate 2A

<u>PART NUMBER</u>	<u>PART NAME</u>	<u>QUANTITY</u>
<u>BASE PLATE ON FRAME SR-1AM & PARTS (CONT.)</u>		
S-285	Shaft Screw	1
W-38	Lock Washer	1
N-37	Cam Gear Screw Nut	1
SR-235M	Cam Gear Timing Cap	1
S-266	Timing Cap Screws	2
W-10	Screw Washers	2
SR-219M	Knife Bar Gear Plate	1
S-266	Gear Plate Screw	1
W-38	Screw Washer	1
SR-218M	Plate Cam Rack Gib	1
S-266	Gib Screw	1
W-38	Gib Screw Washer	1
SR-233AM	Tape Retainer Plate Cam	1
SR-225M	Knife Bar Slide Plate	1
S-266	Slide Plate Screws	3
W-38	Screw Washers	3
SR-200M	Knife	1
SR-201AM	Knife Bar (assembly)	1
SR-292M	Cam Follower	1
S-299	Knife & Knife Bar Connecting Screw	1
N-37	Screw Nut	1
SR200BM	Knife & Knife Bar (Complete)	1
SR-217M	Knife Bar Retainer	1
S-280	Knife Bar Retainer Screws	2
<u>ELECTRICAL PARTS FOR SRMP-A</u>		
SR-94	Handy Box Upper	1
SR-93	Handy Box Bracket	1
S-19	Bracket Connecting Screws	2
N-4	Connecting Screw Nuts	2
S-277	Screw-Handy Box to Frame (Short)	1
S-278	Screw-Handy Box to Frame (Long)	1
SR-239M	Handy Box Toggle Switch	1

PLATE 3A

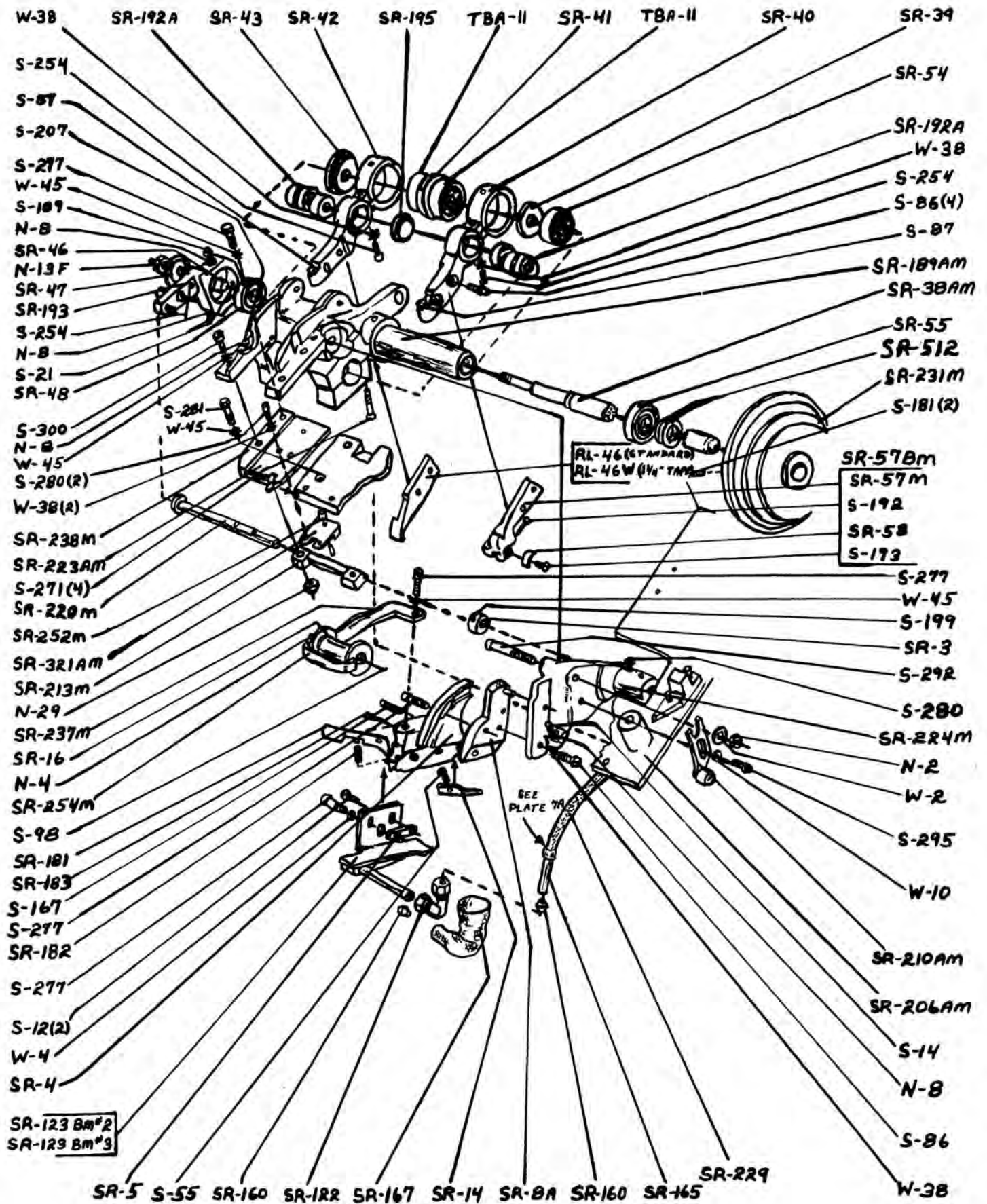


Plate 3A

<u>PART NUMBER</u>	<u>PART NAME</u>	<u>QUANTITY</u>
<u>HEAD & DRIVING PARTS</u>		
SR-189AM	Head	1
S-271	Head Bearing Cap Connecting Screws	4
S-207	Connecting Screw (Head to SR-238M)	1
N-8	Screw Nut	1
SR-231M	Cone Pulley	1
S-181	Pulley Set Screws	2
SR-38AM	Driving Shaft	1
SR-54	Head Shaft Bearing	1
SR-55	Frame Shaft Bearing	1
SR-512M	Frame Bearing Washer (Inside)	1
<u>HEAD FEED PARTS</u>		
SR-39	Inside Spacing Washer	1
SR-40	Feed Arm (Right)	1
S-254	Arm Ball Bearing Binding Screws	2
W-38	Binding Screw Lock Washers	2
TBA-11	Arm Ball Bearings	2
SR-41	Ball Bearing Eccentric	1
SR-42	Feed Arm (Left)	1
SR-43	Outside Spacing Washer	1
SR-193	Shaft Support	1
S-254	Support Screws	2
SR-48	Support Ball Bearing	1
SR-46	Ball Bearing Bushing	1
S-189	Ball Bearing Locating Screw	1
S-21	Ball Bearing Adjusting Screws	2
N-8	Screw Check Nuts	3
SR-47	Ball Bearing Washer	1
N-13F	Shaft Nut	1
SR-192A	Arm Rocker Eccentrics	2
SR-195	Arm Spacer	1
SR-57BM	Inside Feed Finger (Standard) Complete	1
SR-57M	Inside Feed Finger	1
SR-58	Circular Knife	1
S-192	Knife Adjusting Screw (Long)	1
S-193	Knife Pressure Screw (Short)	1
S-86	Inside Finger Binding Screws	2
RL-46	Outside Feed Finger (Standard)	1
RL-46W	Outside Feed Finger (1 1/4" Tape) (Specify)	1
S-86	Outside Finger Binding Screws	2
S-87	Finger Adjusting Screws	2
<u>TAPE SHUTE PARTS</u>		
SR-224M	Shute Hanger	1
SR-220M	Hanger Hinge Pin	1
S-280	Hanger Set Screw	1
SR-3	Hinge Pin Collar	1
S-199	Collar Set Screw	1

Plate 3A

<u>PART NUMBER</u>	<u>PART NAME</u>	<u>QUANTITY</u>
<u>TAPE SHUTE PARTS (CONT.)</u>		
SR-210AM	Tape Adjusting Lever	1
S-295	Connecting Screw (Lever to hanger)	1
W-10	Screw Washer	1
S-292	Connecting Screw (Lever to Hanger)	1
N-2	Connecting Screw Nut	1
W-2	Nut Washer	1
S-14	Shute Hanger Adjusting Screw	1
N-8	Adjusting Screw Lock Nut	1
SR-4	Tape Guide	1
SR-8A	Tape Guide Hanger	1
S-86	Hanger Binding Screw	1
W-38	Binding Screw Lock Washer	1
S-277	Guide Hanger Adjusting Screw	1
SR-14	Guide Spring	1
S-55	Spring Binding Screw	1
S-167	Spring Adjusting Screw	1
SR-123BM #2	Heat Shute (Without Holes)	1
SR-123BM #3	Heat Shute (With 6 Holes) (Specify)	1
S-277	Heat Shute Binding Screw	1
W-4	Binding Screw Washer	1
SR-5	Heat Shute Key	1
S-12	Key Screws	2
SR-237M	Tape Roll Support	1
S-277	Support Screw	1
W-45	Support Screw Washer	1
SR-16	Tape Guide Roll	1
S-98	Guide Roll Stud	1
N-4	Stud Nut	1
SR-254M	Tape Roll Guide	1
SR-181	Tape Retaining Latch	1
SR-182	Retaining Latch Spring	1
SR-183	Retaining Latch Pin	1
<u>BASE PLATE ON FRAME SR-1M & PARTS</u>		
SR-206AM	Base Plate	1
SR-213M	Spacer Bar	1
S-281	Spacer Bar Screw	1
W-45	Screw Lock Washer	1
S-300	Spacer Bar Clamp Screw	1
N-29	Clamp Screw Lock Nut	1
W-45	Lock Nut Washer	1
SR-238M	Tape Shearing Plate Support (Left)	1
S-277	Plate Support Screw	1
W-45	Screw Washer	1
SR-223AM	Tape Retaining Plate	1
SR-252M	Retaining Plate Bearing	1
SR-321AM	Bearing Retainer	1
S-280	Retainer Screws	2
W-38	Screw Washers	2

Plate 3A

<u>PART NUMBER</u>	<u>PART NAME</u>	<u>QUANTITY</u>
	<u>HEATING ATTACHMENT</u>	
SR-167	Flexible Tubing Loom	1
SR-122	Tubing Compression Elbow	1

PLATE 3B

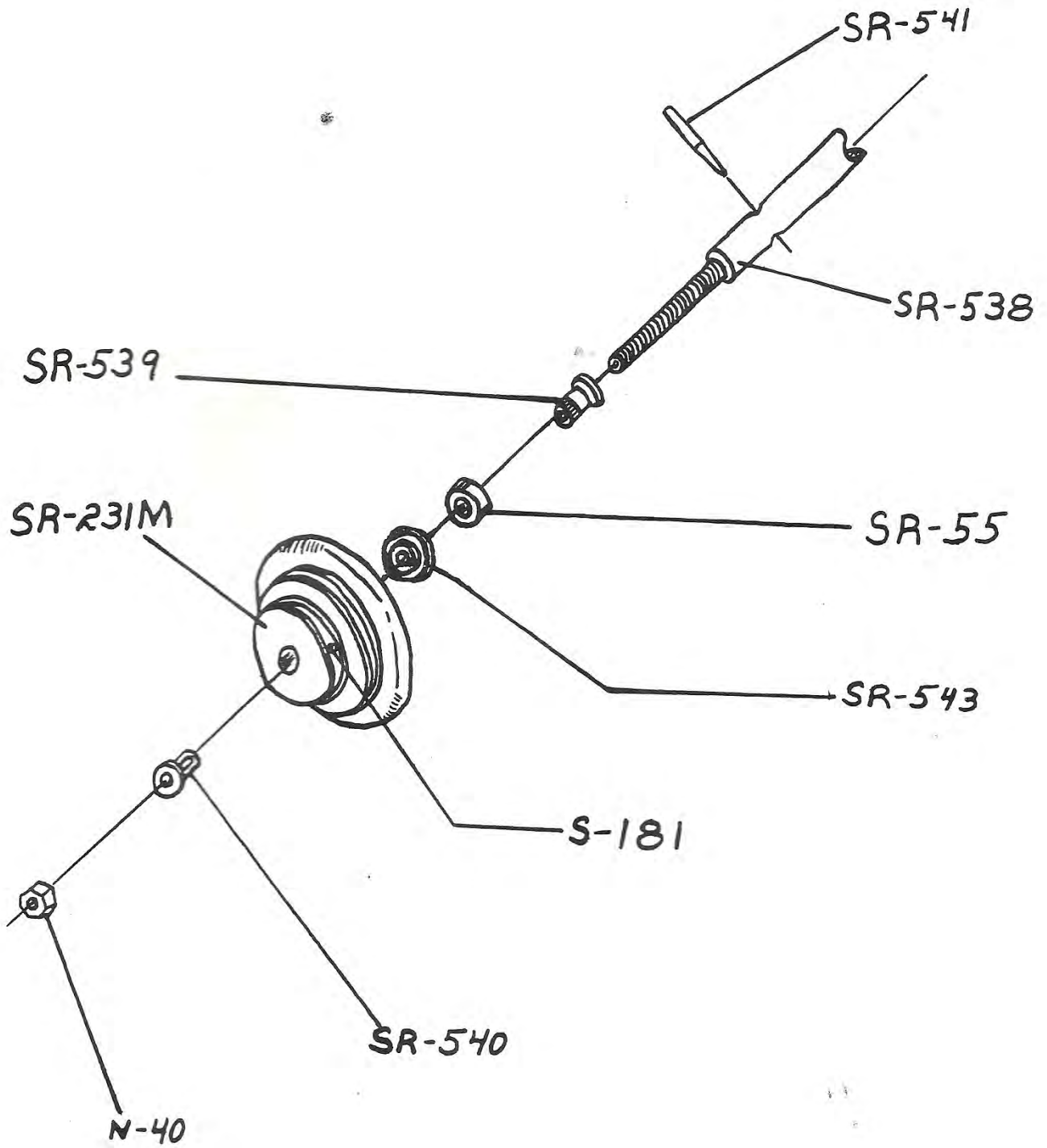


PLATE 4A

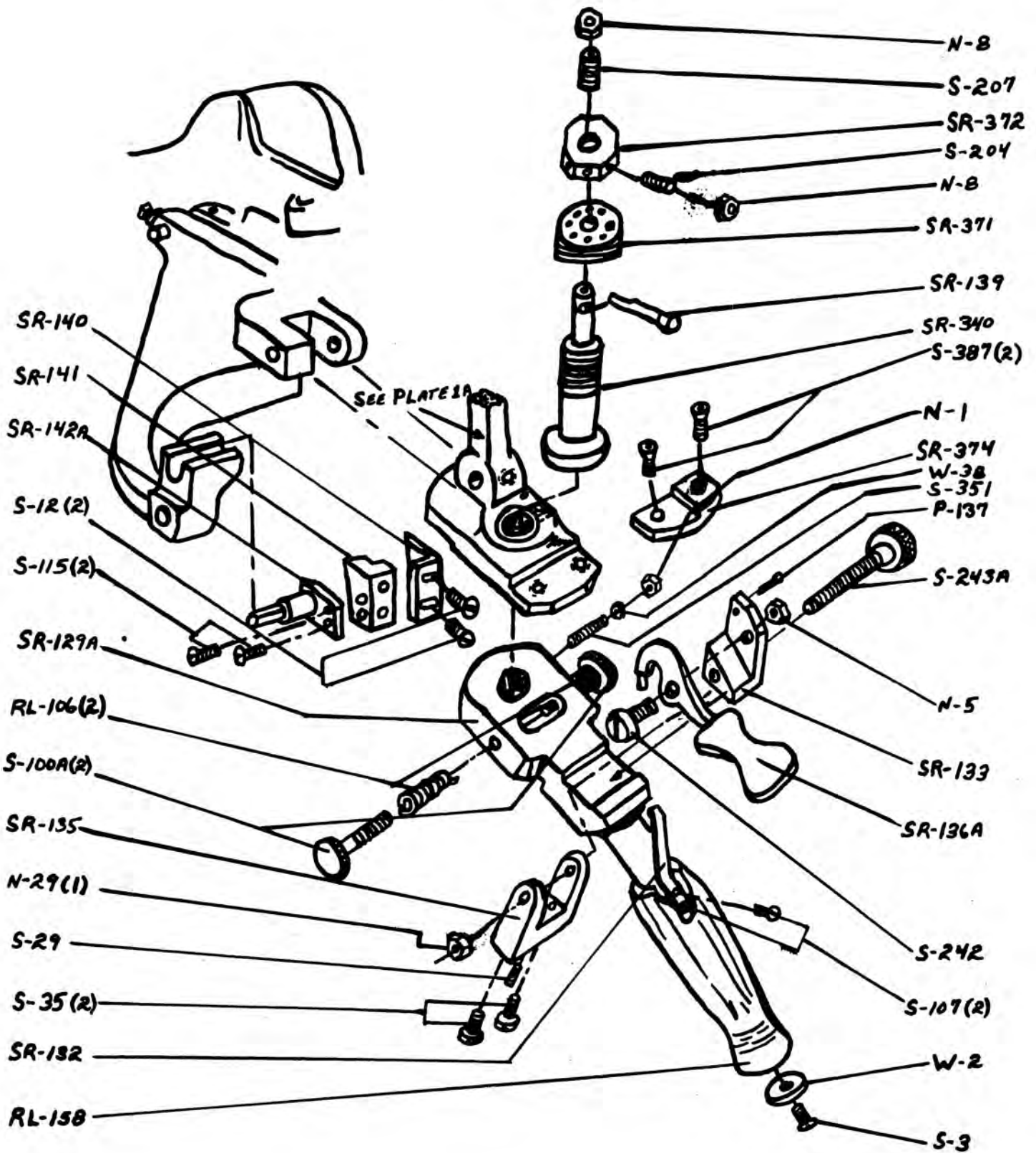
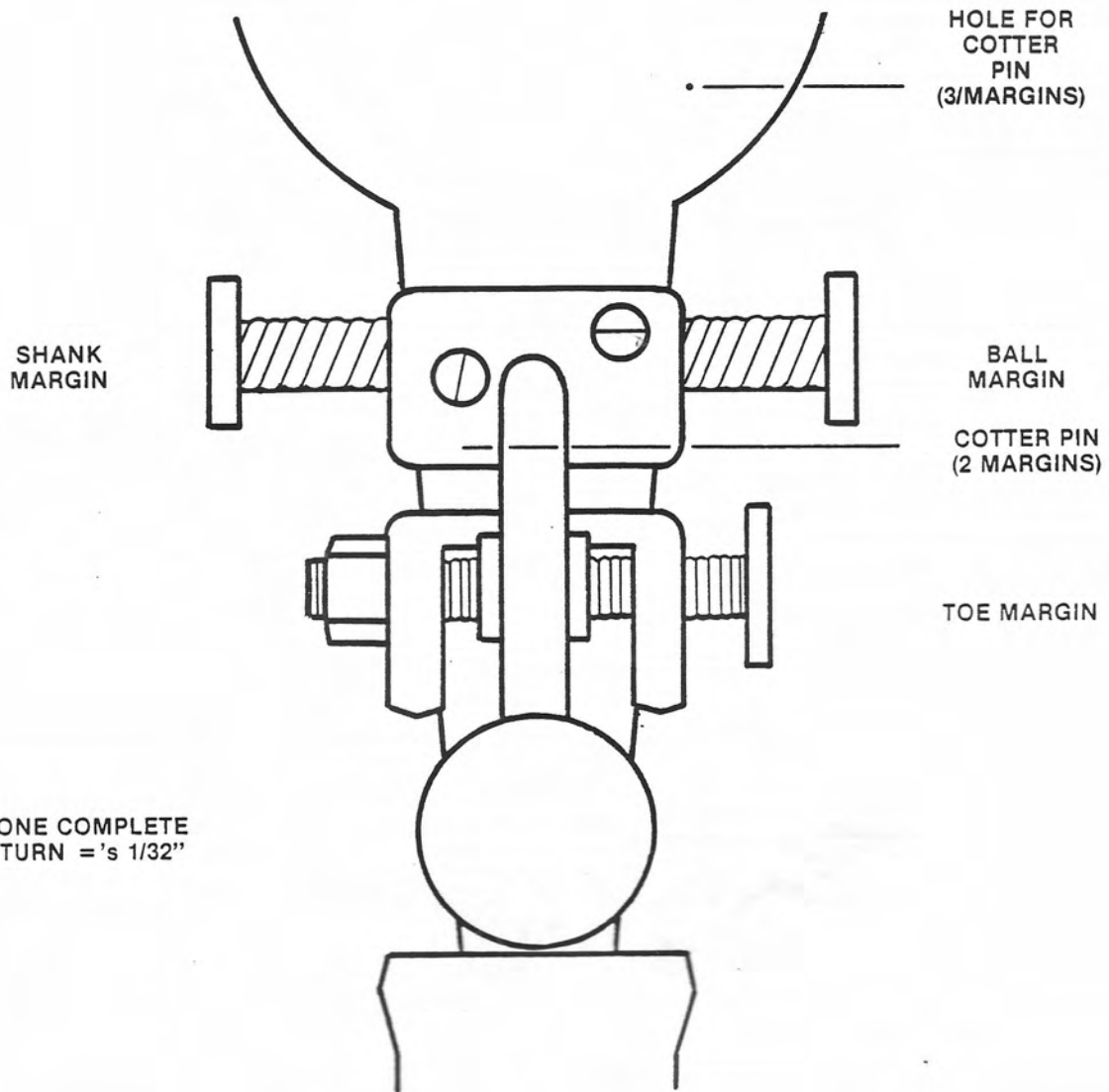


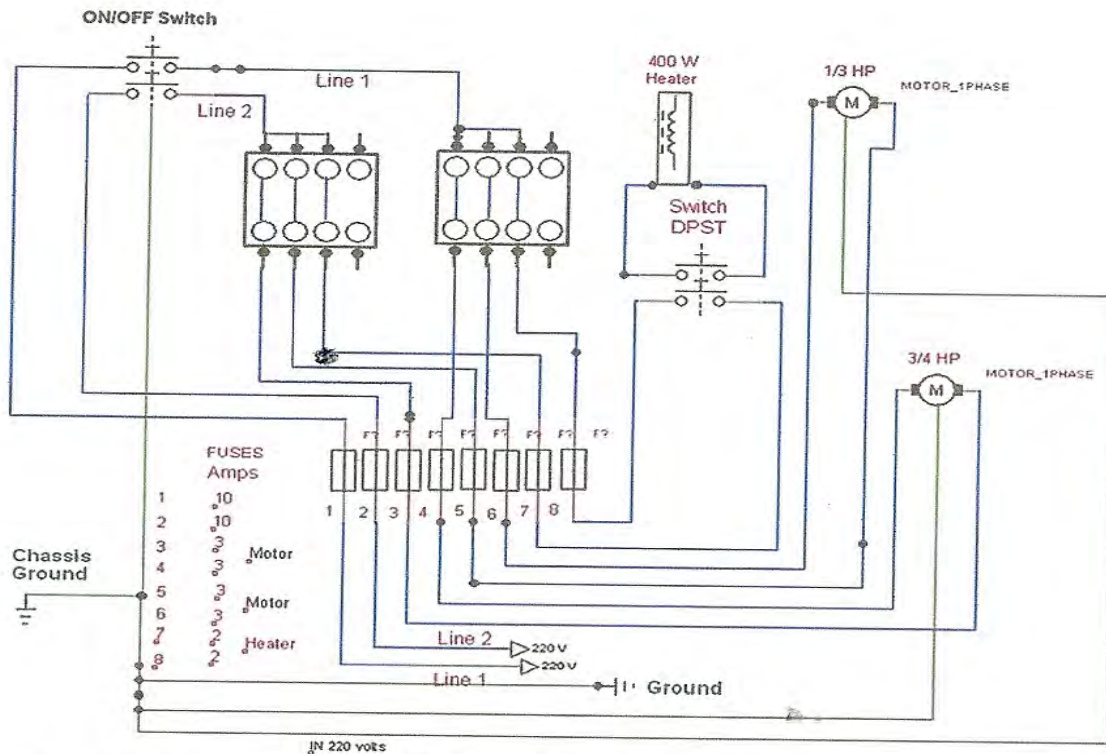
Plate 4A

<u>PART NUMBER</u>	<u>PART NAME</u>	<u>QUANTITY</u>
<u>BALTIMORE ATTACHMENT PARTS</u>		
SR-374	Trigger Stop	1
S-387	Trigger Stop Locking Screws	2
SR-129A	Shift Handle New Style	1
S-351	Shift Handle Stud Lock Screw	1
W-38	Shift Handle Stud Lock Screw Washer	1
N-1	Shift Handle Stud Lock Screw Nut	1
S-100A	Arm Adjusting Screws	2
RL-106	Adjusting Screw Springs	2
SR-132	Trigger Tension Spring	1
S-107	Spring Connecting Screws	2
RL-158	Handle Grip	1
W-2	Handle Grip Washer	1
S-3	Handle Grip Screw	1
SR-133	Toe Adjusting Block	1
S-243A	Adjusting Block Screw	1
N-29	Screw Locking Nut	1
SR-135	Block Support	1
S-35	Support Connecting Screws	2
S-29	Support Adjusting Screw	1
SR-136A	Trigger	1
S-242	Trigger Binding Screw	1
N-5	Binding Screw Nut	1
P-137	Trigger Lock Pin	1
SR-340	Shift Handle Stud	1
SR-371	Shift Handle Stud Thrust Bearing	1
SR-372	Bearing Retaining Nut	1
S-204	Bearing Retaining Nut Lock Screw	1
N-8	Bearing Retaining Nut Lock Screw Nut	1
SR-139	Margin Pawl	1
S-207	Pawl Locking Screw	1
N-8	Pawl Locking Screw Nut	1
SR-140	Pawl Guide Block (Right)	1
SR-141	Pawl Guide Block (Left)	1
S-12	Guide Block Connecting Screws	2
SR-142A	Slide Adjusting Stud Plate	1
S-115	Stud Plate Adjusting Screws	2



ADJUSTMENTS FOR CONTROL OF THREE MARGIN INSOLES. TWO MARGIN INSOLE REQUIRES THE COTTER PIN UNDER THE BUTTON LEVER. THEN YOU ONLY USE SHANK & BALL CONTROL.

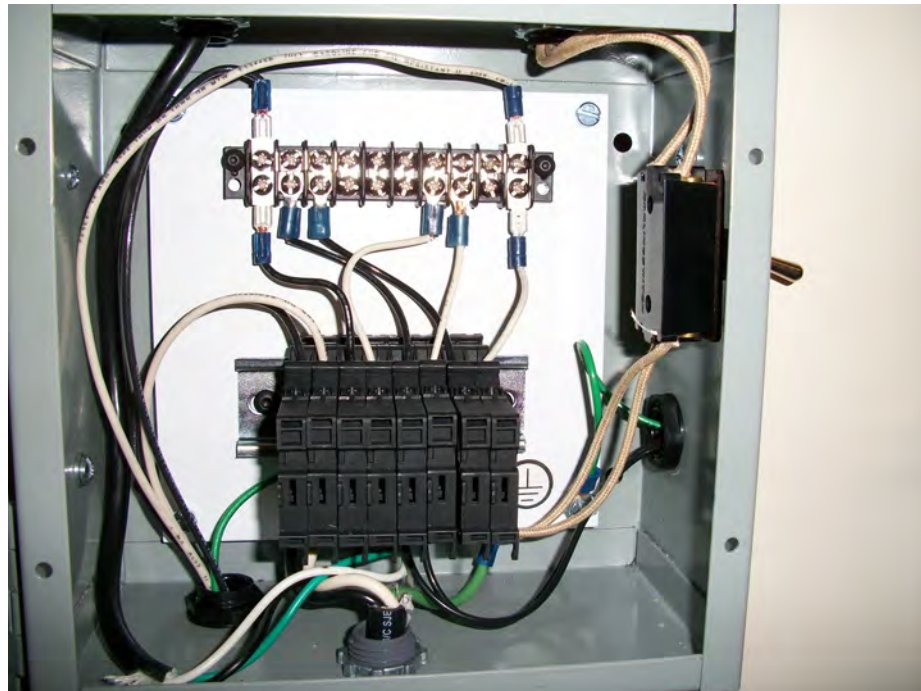
S/PCM Electrical Wiring Diagram



March 19th 2013 **Wiring Diagram for the New Style Prime Table Model**

Line Voltage 220 Volts Single Phase

New Style Prime Table Model 3/19/13



THANK YOU FOR YOUR BUSINESS

感謝您為您的企業

Cảm ơn bạn cho doanh nghiệp của bạn

Gracias por su negocio

Obrigado para o seu negócio



For more information, please visit us at

InsoleRib.com