

Ishida WM-Ai Preventative Maintenance and Lubrication Guide



Customer: _____
 Contact: _____
 Model: _____ WM-Ai / WM-Ai-P
 Serial Number: _____

Inspection Date: _____
 Technician(s): _____
 Cycle Count: _____
 Installation Date: _____

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This WM-Ai Preventative Maintenance Guide is divided into three intervals - **DAILY, 6-MONTH, YEARLY**. The DAILY maintenance is generally the responsibility of the end-user. It is recommended that the servicing technician review these daily maintenance checks with the appropriate manager, especially if it is evident these checks are not being performed properly.

** Allow 2-3 hours for a 6-MONTH inspection and 4-6 hours for a YEARLY inspection. **

	Sections		Sections		Sections
1	LIFT HEAD	10	FILM TRANSPORT/INSERTION	19	CAMERA & LIGHTING
2	WRAPPING: FRONT / REAR	11	LIFT DRIVE	20	TOUCHSCREEN DISPLAY
3	WRAPPING: LEFT / RIGHT	12	LIFT SIZE CHANGE	21	KEYBOARD ASSEMBLY
4	SEAL HEATERS	13	FILM ROLL HOLDERS	22	SAFETY SWITCHES
5	DISCHARGE PUSHER	14	FILM FEEDER MOVEMENT	23	FILE BACK-UP
6	INFEED	15	LABEL APPLICATOR - MAIN	24	ADJUSTMENTS, PARTS REPLACED,
7	CENTERING UNIT	16	LABEL APPLICATOR - POP	25	SAMPLE LABELS
8	SCALE	17	PRINTER - MAIN	26	REFERENCE DRAWINGS
9	FILM FEEDER ASSEMBLIES	18	PRINTER - POP		

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Required materials:

- Grease: White, Yellow, and Black (see table below for specifications)
- Disposable brushes, small or cotton swabs (for grease application)
- Wrench set, metric
- Socket set, metric (optional)
- Screwdrivers, assorted
- Allen wrench set, metric
- Sandpaper (100 grit)
- Clean, lint-free rags
- Compressed Air / Vacuum
- Isopropyl Alcohol
- Adhesive remover (for labels)
- Thermal head cleaning kit
- Weight set (30 lb, or 15 Kg)
- Key, interlock bypass, 2 pieces (p/n 95540)
- Machinist Ruler
- USB flash drive (8 GB or smaller, FAT32 format, USB 3.0)

Lubrication for WM-Ai

Color of grease	RLWS Part Number	Description	Industry Reference Number
(Y) Yellow	77932	General Purpose Lithium Grease (323916) [Shell Alvania Grease "No2"]	Sta-Lube SL3310
(W) White	77933	White Food-Grade Grease (380059) [Sumico White Alcom Grease "No2"]	CRC SL35600
(B) Black	77934	Multi-Purpose Grease (371219) [Daizo Nichimori "L-210"]	Sta-Lube SL3330

The parts listed in the Check Points and Replacement Parts columns on pages 3~9 are identified by a drawing number and part number. The drawing number refers to the parts drawings on pages 11~34. For example, in section 4: Seal Heaters on page 4, the orange seal heater rollers are identified as #8, p/n 174923. This refers to #8 on the Seal Heaters drawing on page 14.

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	Section	Check Points	Comments	Tool/Grease/ Program	Replacement Parts	Check			✓	
						D	6 mo	Y		
1	LIFT HEAD	Loose Screws	Tighten screws- Fingers and Handle				X	X		
		Cleaning	Clean the Lift Head Assembly	Soap & Water		X	X	X		
		Surface friction of Lift Heads -Center & Front Left (#7), Front Right (#8), Left (#9), Right (#10), Rear Center (#14), Rear Left (#15), Rear Right (#16),	If the Heads are worn smooth (polished) roughen with sandpaper. Replace worn out or damaged heads or finger assemblies.	Sandpaper (100 grit)	125697 (#7) 171831 (#8) 125698 (#9) 125699 (#10) 171832 (#14) 171833 (#15) 171834 (#16)			X	X	
		Lift Heads Movement - See above	Replace broken assemblies that are too weak to operate and spring back.		See above			X	X	
		Latch Pin Assembly -Spring (#6)	Replace broken or weak compression spring.		172335 (#6)			X	X	
		Lubrication	Grease all springs, as needed. After working in the grease, wipe off excess.	White Grease				X	X	
2	WRAPPING: FRONT/REAR	Loose Screws	Tighten screws as needed. Listen for odd noises.	Adjust Menu, Unit Action, 12: Back Plate					X	
		Condition of Rear Wrap Plate	Clean any food, dirt, oil, or label adhesive. If worn smooth (polished) roughen with sandpaper.	Soap & Water (Daily) Adhesive Remover Sandpaper (#100)		X	X	X		
		Plastic bushings - Leading Roller Mounting Brackets (#2) - Square Shaft Mounts (#4)	Replace bushings if worn out. Note: Roller brackets can be swapped right / left side.		172528 (#2) 172530 (#4)					X
		Wrap Plate and Roller Shaft alignment	Roller Shaft should be parallel with the fixed Rollers at the exit. (Loosen and adjust Shaft Holders [#2] – page 11)	#2 Phillips driver						X
		Roller Shaft condition - Stepped Roller Shaft (#3)	Roller Shaft must be straight - not bent. Replace if necessary.		172529 (#3)			X	X	
		Roller Shaft movement - Shaft Holder (#2)	Roller Shaft must turn freely. Apply grease at plastic mounting brackets - 2 places. Swap left & right brackets or replace worn plastic brackets as needed.	White grease	172528 (#2)			X	X	
		Square mounting shafts	Clean debris and old grease, apply new grease	Black grease						X
		Photo sensor - Home Position, B102 (#503)	Clean as needed. Sensor is located at the rear right of the Rear Wrap plate.	Compressed Air	171837 (#503)					X

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	Section	Check Points	Comments	Tool/Grease/ Program	Replacement Parts	Check			✓	
						D	6 mo	Y		
3	WRAPPING: LEFT/RIGHT	Loose screws	Tighten screws as needed. Listen for odd noises.	Adjust Menu, Unit Action, 11: Side Plate				X		
		Linear Bushings	Clean debris and old grease, apply new grease	Yellow grease			X	X		
		Linear Bushings movement - Linear Bearing Block, front (#1) - Linear Bearing, rear (#2)	Replace if worn out - excessive resistance.		172514 (#1) 157900 (#2)				X	
		Photo sensor - Home Position, B101 (#503)	Clean as needed. Sensor is located at the rear of the Left Wrap plate.	Compressed Air	171837 (#503)				X	
		Condition of Side Wrap Plates	Clean any food, dirt, oil, or label adhesive. If worn smooth (polished) roughen with sandpaper.	Soap & Water (Daily) Adhesive Remover Sandpaper (#100)		X	X	X		
4	SEAL HEATERS	Heater Guard solenoid	Check smooth operation					X		
		Heater Guard photo sensor	Clean	Compressed Air				X		
		Sealing Heater Rollers - cleaning	Caution rollers are hot . Allow to cool down before cleaning. Remove burnt on film (black) with a Degreaser (ex. Totally Awesome Orange). DO NOT use abrasive cleaning tools that will damage the roller surface.	Damp cloth (Daily) Degreaser (PM)		X	X	X		
		Sealing Heater Rollers - movement - Roller Assy (#8) - Bushing (#22)	Clean or replace		174923 (#8) 153654 (#22)				X	
		Temperature adjustment	Confirm higher and lower temperature adjustment is possible						X	
5	DISCHARGE PUSHER	Loose screws	Tighten screws as needed. Listen for odd noises.	Adjust Menu, Unit Action, 13: Pusher				X		
		Drive Belts - tension	Right and Left side belts must be balanced					X		
		Square mounting shafts	Clean debris and old grease, apply new grease	Black grease					X	
		Photo sensor - Home Position, B100 (#503)	Clean as needed. Sensor is located at the rear right of the Discharge Pusher.	Compressed Air	171837 (#503)				X	
		Discharge Pusher clearance - home position	Confirm the Discharge Pusher does not contact drive gears, etc. at the home position. Listen for noise from contact.						X	
		Green tape - Green Grip Tape, Sheet (#999)	Replace if loose or peeling		172536 (#999)			X	X	
		Discharge Pusher - cleaning	Remove labels, food, etc.			X	X	X		

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	Section	Check Points	Comments	Tool/Grease/ Program	Replacement Parts	Check			✓
						D	6 mo	Y	
6	INFEED	Loose screws	Tighten screws as needed. Listen for odd noises.	Adjust Menu, Unit Action, 4: Feed				X	
		Drive Chains - Chain (#23)	Check for damage, cracks, etc.		171835 (#38)		X	X	
		Infeed Rail Drawer Slides	Confirm easy in/out movement. Clean debris and old grease, apply new grease.	Yellow grease				X	
		Photo sensor – Home position [front, left] (#502)	Clean. Check for any contact damage.	Compressed Air	104239 (#502)			X	
		Thumb screws	Confirm the thumb screw shafts are positioned correctly and locking jam nuts are tight.	10mm wrench	47159 (#22) 125462 (M6 nut)		X	X	
7	CENTERING	Centering Shaft	Listen for odd noises. Clean debris and old grease, apply new grease.	Yellow grease			X	X	
		Green Belt assy	Remove, disassemble, clean. Ensure smooth movement.				X	X	
		Blue Belt	Clean with soap and water.			X	X	X	
8	SCALE	Check zero and calibration		30 lb. test weights				X	
		Four corner check		5 lb. test weight				X	
		Weighing	Correct weighing	1 lb. test weight		X	X	X	
		Blue Scale Platter - Platter (#15)	No bleach. Replace if color has changed or surface is worn smooth.	Soap & Water (Daily)	170292 (#15)	X	X	X	
		Confirm Label data matches Display						X	
		Check level						X	
9	FILM FEEDER ASSEMBLIES	White Film Feed belts - White Belt (#9)	Check for broken wires, yellowing, worn surface, or other damage	Inspection and test wrapping	171838 (#9)			X	
		Green Film Feed belts - Long Green Belt (#10)	Check for polished surface, slipping, meandering, or other damage	Inspection and test wrapping	171839 (#10)			X	
		Film Centering: Upper and Lower rolls	Adjust centering. Verify consistency.	Adjust Menu, Wrapping Machine, Film tab				X	
		Film pieces on belts	Remove pieces. Clean belts with soap and water if needed. DO NOT use alcohol.	Inspection and test wrapping			X	X	
		Film Clamps - 6 places	Ensure all clamps operate properly and provide sufficient grip strength.	Adjust Menu, Unit Action, 17: Front Clamp & 18: Rear Clamp				X	

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	Section	Check Points	Comments	Tool/Grease/ Program	Replacement Parts	Check			✓
						D	6 mo	Y	
9	FILM FEEDER ASSEMBLIES (Cont.)	Film Detect & Film Over "Claw" Sensor - Spring Plate, Film Detect (#33) - Coil Spring, Film Detect (34) - Spring Plate, Film Over (#29) - Film Detect Photo Sensor (#502) - Film Over Photo Sensor (#501)	Verify sensor operation. Remove any film pieces or build up. If worn smooth (polished) roughen with sandpaper.	Compressed Air. Sand Paper (100 grit)	175364 (#33) 175369 [F] (#34) 175365 [R] (#34) 175367 (#29) 171837 (#502) 104239 (#501)		X	X	
10	FILM TRANSPORT (INSERTION PLATE & CUTTER)	Stop position for Insertion Unit	Verify clearance.	Adjust Menu, Unit Action, 24: Film Change				X	
		One-Way Roller (clear plastic) - Roller Clutch Assy, 1-Groove (#5) - Roller Clutch Assy, 5-Groove (#6)	Verify one-way, smooth movement. Check for scratches. Remove film pieces and clean with alcohol.	Isopropyl Alcohol	172563 (#5) 172565 (#6)		X	X	
		Sensors - Cutter, home (#503) - Insertion, home (#503) - Insertion, open [green] (#505, #506) - Magnet [green] (#504)	Clean. Verify operation. Cutter (home), Insertion Plate (home), and Insertion Plate (open).	Compressed Air. Adjust Menu, Unit Action, 1: Sensor Check	104239 (#503) 175361 (#505) 175362 (#506) 105979 (#504)			X	
		Cutter Blade - Blade (#4)	Check for corrosion or rust	Visual inspection	176682 (#4)		X	X	
		Cutter Blade Guard - Blade Guards (#1) [Outer] (#2) [Inner] - Leaf Spring (#5) - Coil Spring (#11) [Front] (#12) [Rear]	Check movement. Clean film pieces. Check for cracks.	Visual inspection	178891 (#1) 178892 (#2) 178893 (#5) 172560 (#11) 172561 (#12)		X	X	
		Cutter Blade Solenoids	Check movement. Check return spring operation.	Adjust Menu, Unit Action, 15: Cutter				X	
		Feeder movement home position sensor - Photo Sensor	Clean as needed. Sensor is located at the lower right side of the Film Feeder assy.	Compressed Air	104239			X	
11	LIFT DRIVE	Lower limit photo sensor. - Photo Sensor (#502)	Clean. Verify operation.	Compressed Air	157856 (#502)		X	X	
		Up / Down operation	Listen for odd noises during operation	Adjust Menu, Unit Action, 2: Lift				X	
		Linear Bushings - Linear Bushing Bearing (#11)	Clean debris and old grease, apply new grease.	Yellow grease	157900 (#11)		X	X	
12	LIFT SIZE CHANGE	Lift Size Change movement	Listen for odd noises during operation	Adjust Menu, Unit Action, 3: Lift Change				X	
		Lift Size Change photo sensor - Photo Sensor, B214 (#501)	Clean off any debris	Compressed Air	104239 (#501)			X	

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	Section	Check Points	Comments	Tool/Grease/ Program	Replacement Parts	Check			✓	
						D	6 mo	Y		
13	FILM ROLL HOLDERS	Film Roll Holding Spikes	Check if the spikes hold the rolls	2.5mm Allen wrench			X	X		
		Film position	Shaft end hub --> front edge of film is even blade or farther bac				X	X		
		Film Roll Brake - Brake Assy (#27)	Confirm film roll stops and does not over turn. Stop position, full roll: 10:00-11:00	Adjust Menu, Wrapping Machine, Roll tab	172604 (#27)			X	X	
14	FILM FEEDER MOVEMENT	Movement (Front & Rear Feeders)	Confirm smooth movement. Listen for odd noises during operation	Adjust Menu, Unit Action, 9: Front Feeder Move 10: Rear Feeder Move				X		
		Belt tension (2 black drive belts)	Verify belt tension and condition					X		
		Drive Shafts	Clean debris and old grease, apply new grease.	Yellow grease					X	
		Home & Limit Photo Sensors (4 places) - Front Limit (#502) - Feeder Position, 3 places (#503)		Compressed Air	171837 (#502) 104239 (#503)				X	
		Main Hex Drive Shaft	Clean debris and old grease, apply new grease.	Black grease					X	
15	LABEL APPLICATOR - MAIN	Movement: three directions - Photo Sensors, 8 places (#501)	No unusual sounds. Clean with compressed air. Confirm beep in Adjust menu.	Compressed air. Adjust Menu, Unit Action, Label App. Tab, 1: Appl Control Sensor	104239 (#501)			X		
		Applicator End (Spring loaded assy)	Push the Applicator up. Verify free movement and vibration/bounce when lowered is not excessive.	White grease				X		
		Fan suction - Fan Suction Assy (#608)	Verify the Applicator Suction Fan can hold a 0.015 lb. tray.		172624 (#608)				X	
		Applicator Shafts: Left/Right (2), Back/Front (2), Up/Down (1)	Check for rust. Clean debris and old grease, apply new grease.	Yellow grease				X	X	
		Applicator Shoe (black) (#59)	Replace if worn or cracked		171864 (#59)			X	X	
		Label Detection sensor (inside applicator shoe) (#607)	Clean dust from sensor	Cotton swab	172623 (#607)	X	X	X		

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	Section	Check Points	Comments	Tool/Grease/ Program	Replacement Parts	Check			✓
						D	6 mo	Y	
16	LABEL APPLICATOR - POP	Movement: three directions - Photo Sensors: 5 places (#509), 1 place (#510)	No unusual sounds. Clean with compressed air. Confirm beep in Adjust menu.	Compressed air. Adjust Menu, Unit Action, Label App. Tab, 1: Appl Control Sensor	104239 (#509) 171837 (#510)			X	
		Applicator End (Spring loaded assy)	Push the Applicator up. Verify free movement and vibration/bounce when lowered is not excessive.	White grease				X	
		Fan suction - Fan Suction Assy (#606)	Verify the Applicator Suction Fan can hold a 0.015 lb. tray.		178215 (#606)			X	
		Applicator Shafts: Left/Right (2), Up/Down (1)	Check for rust. Clean debris and old grease, apply new grease.	Yellow grease		X	X		
		Applicator Shoe (black) (#44)	Replace if worn or cracked		178204 (#44)	X	X		
		Label Detection sensor (inside applicator shoe) (#605)	Clean dust from sensor	Cotton swab	178214 (#605)	X	X	X	
17	PRINTER - MAIN	Printing Quality - Print Head (#501)	Verify print is complete and legible. Clean print head.	Adjust Menu, Printer, Printer 1, Head tab, PRINT. Isopropyl alcohol	178188 (#501)		X	X	
		Label Feeding - Print Rollers (#42)	Check if printing expands or contracts. Check and clean 2 print rollers. Remove paper dust.	Adjust Menu, Printer, Printer 1, Head tab, PRINT. Label & Isopropyl alcohol	171873 (#42)			X	
		"Head Up" sensor - Sensor (#601) - Magnet (#502)	Verify sensor operation	Adjust Menu, Printer, Printer 1, Head tab, "Head Up"	172669 (#601) 105979 (#502)			X	
		Label Gap sensor - Gap Sensor Assy (#601) Peel sensor - Transmitter, Left Side (#503) - Receiver, Right Side (#504)	Check sensor readings are normal. Clean, calibrate, or replace sensors as needed.	Adjust Menu, Printer, Printer 1, Label Feed tab & Peel Sensor tab	172669 (#601) 171876 (#503) 171877 (#504)		X	X	
		Label Pickup Roller Table - Roller Table O-Rings (#2) - Roller Table O-Rings, End	Clean adhesive from rollers. Verify smooth turning		157891 (#2) 178190 [End]		X	X	
		Drive Gears	Clean debris and old grease, apply new grease. Examine gears for cracks or chips.	White grease				X	
		Magnet (home position) - Catch Magnet (#37)	Inspect catch magnet for wear. Verify magnet holds and printer drive gears mesh well at home position		172642 (#37)			X	

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	Section	Check Points	Comments	Tool/Grease/ Program	Replacement Parts	Check			✓
						D	6 mo	Y	
18	PRINTER - POP	Printing Quality - Print Head (#502)	Verify print is complete and legible. Clean print head.	Adjust Menu, Printer, Pop, Head tab, PRINT. Isopropyl alcohol	178188 (#502)		X	X	
		Label Feeding - Print Rollers (#32)	Check if printing expands or contracts. Check and clean 2 print rollers. Remove paper dust.	Adjust Menu, Printer, Pop, Head tab, PRINT. Label & Isopropyl alcohol	178218 (#32)			X	
		"Head Up" sensor - Sensor (#601) - Magnet (#503)	Verify sensor operation	Adjust Menu, Printer, Pop, Head tab, "Head Up"	178227 (#601) 105979 (#503)			X	
		Label Gap sensor - Gap Sensor Assy (#601) Peel sensor - Transmitter, Left Side (#505) - Receiver, Right Side (#504)	Check sensor readings are normal. Clean, calibrate, or replace sensors as needed.	Adjust Menu, Printer, Pop, Label Feed tab & Peel Sensor tab	178227 (#601) 171877 (#505) 171876 (#504)		X	X	
		Label Pickup Roller Table - Roller Table O-Rings (#2) - Roller Table O-Rings, End	Clean adhesive from rollers. Verify smooth turning		157891 (#2) 178190 [End]		X	X	
19	CAMERA & LIGHTING	Camera - P-1107 Camera Controller (#501) - CMOS Camera (#502)	Verify tray recognition. Place trays in four corners in operation mode. Calibrate as needed.	Adjust Menu, Camera	171865 (#501) 172626 (#502)			X	
		LED Lights - LED Assy, Left side (#503) - LED Assy, Right side (#504)	Confirm both LED lights are lit	Operation Mode	172627 (#503) 172628 (#504)			X	
		Camera and light lens cover	Clean clear plastic lens cover	Cloth		X	X	X	
20	TOUCH SCREEN DISPLAY	Contrast - LCD Display (#504) - P-1102 Display Control Bd (#501)	Verify brightness of the display. Replace Invertor or Display as needed.	Adjust Menu, Display Check	158278 (#504) 171882 (#501)			X	
		Touchscreen operation - Touch Panel (#503)	Confirm accuracy. Calibrate or replace as needed.	Adjust Menu, Touch Screen	171883 (#503)		X	X	
		Touchscreen cleaning	Clean touchscreen display	Cloth		X	X	X	
21	KEYBOARD ASSEMBLY	Keyboard - Keyboard Assy (#501)	Confirm all keys function and show as dark squares	Adjust Menu, Key Check	171884 (#501)			X	
		Keyboard Transparent cover - Cover (#999)	Clean keyboard cover. Replace as needed.	Cloth	98400 (#999)	X	X	X	
22	SWITCHES	Check eight (4) Door Safety Switches.						X	
		Check Emergency Stop.						X	

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	Section	Check Points	Comments	Tool/Grease/ Program	Replacement Parts	Check			✓
						D	6 mo	Y	
23	DATA BACKUP	Backup WM-Ai wrapper memory.	USB flash drive backup is the preferred method as this method captures more than the software backup.	Setup Menu, File Save/Load, USB > Scale tab and/or SLP-5 / Maintenance Utility				X	

24. Adjustments, Comments, Parts Required, etc.

Section	Inspection Items and Contents	Comments	Replacement Parts

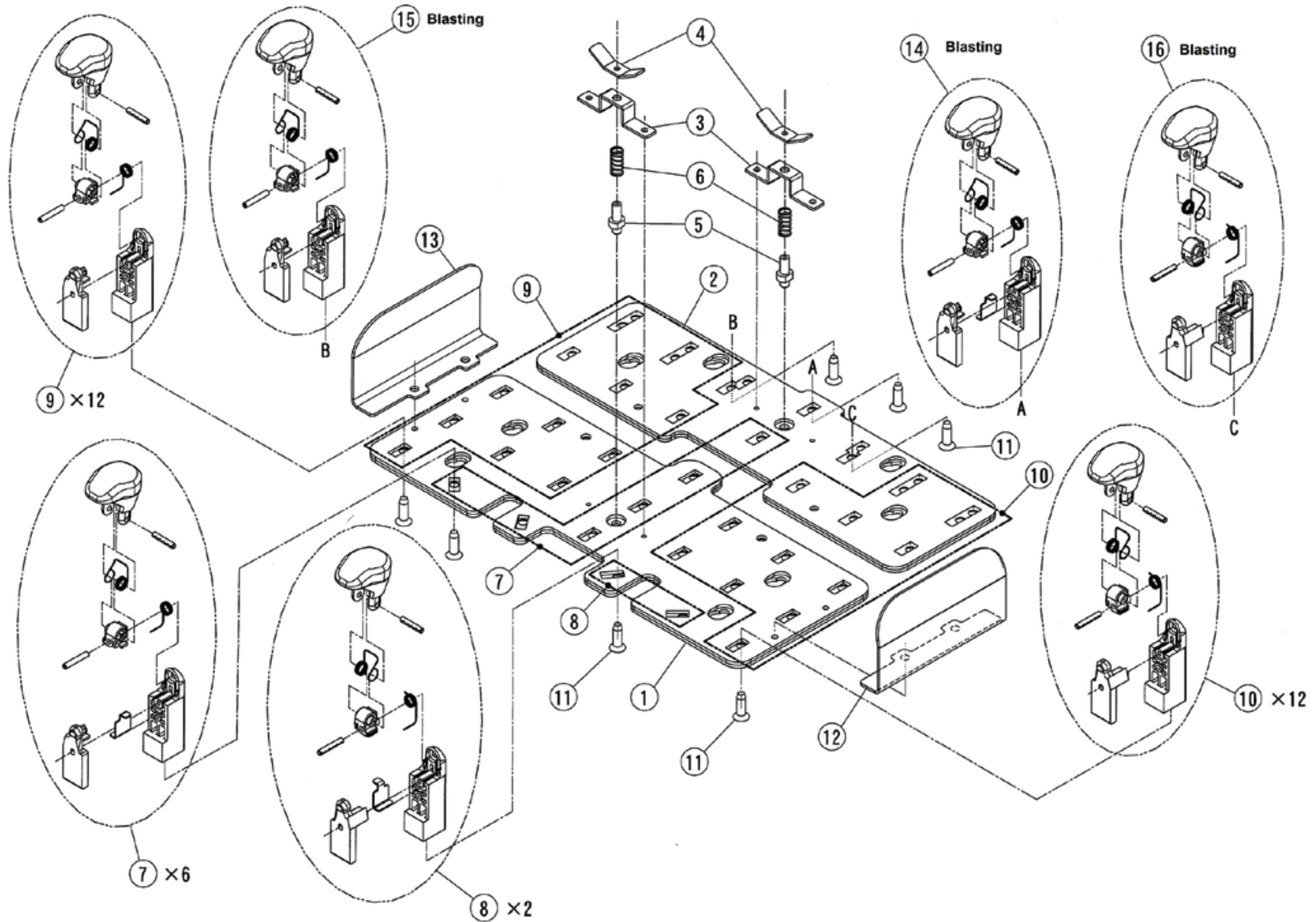
25. SAMPLE LABELS

[SAMPLE LABELS]

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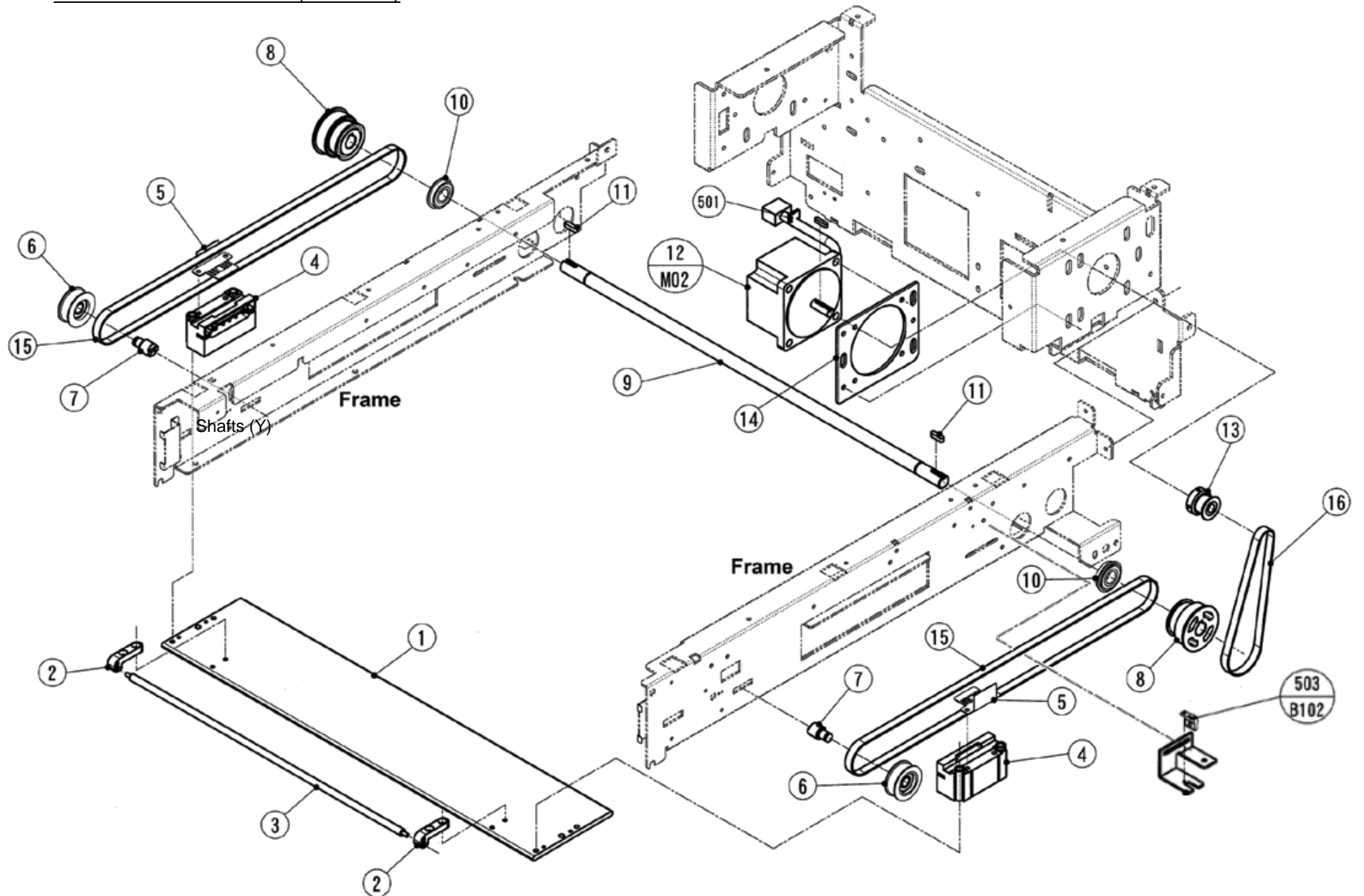
26. Reference Drawings

LIFT HEAD ASSEMBLY (Section 1)



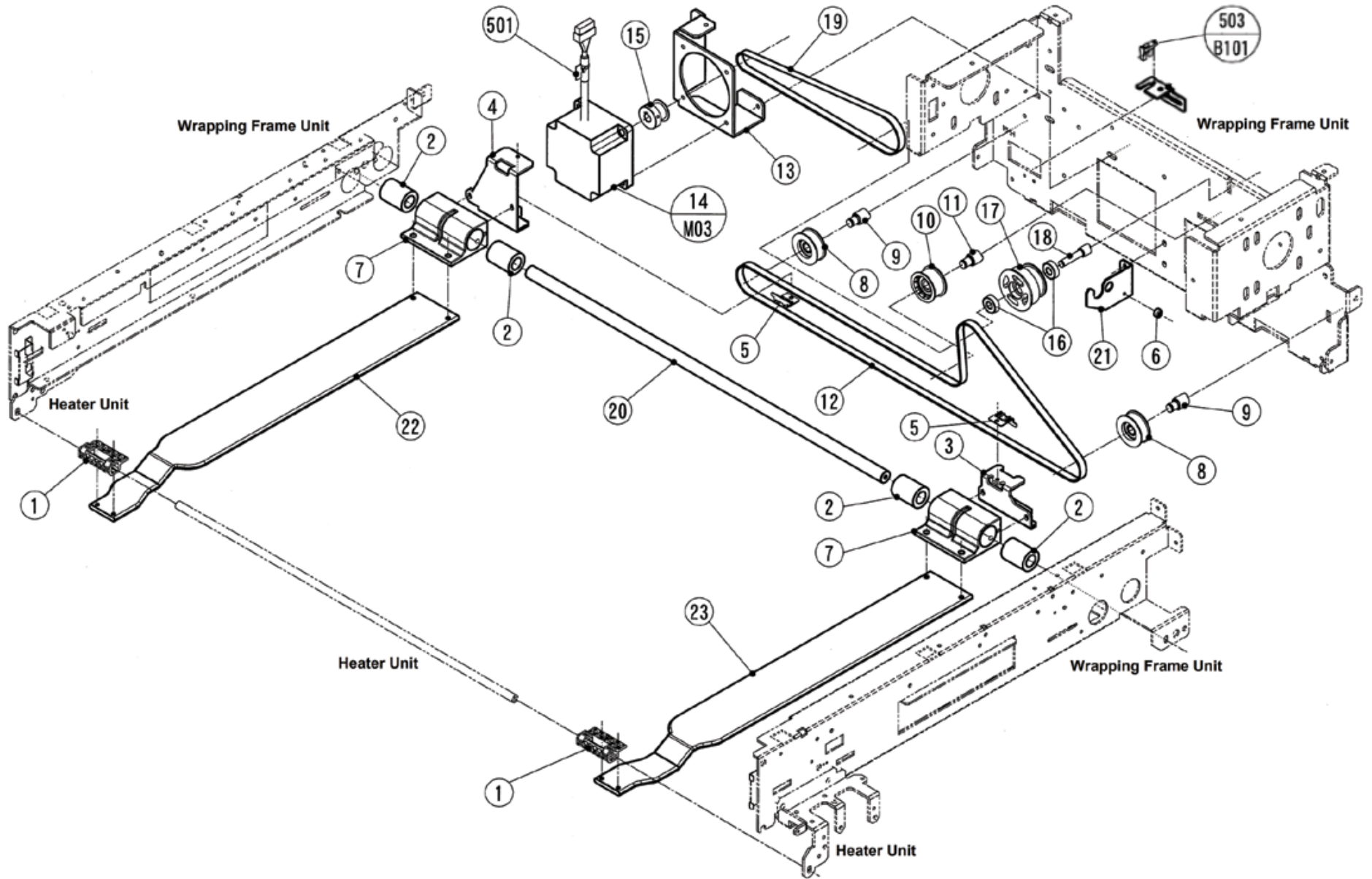
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WRAPPING: FRONT/REAR (Sections 2)



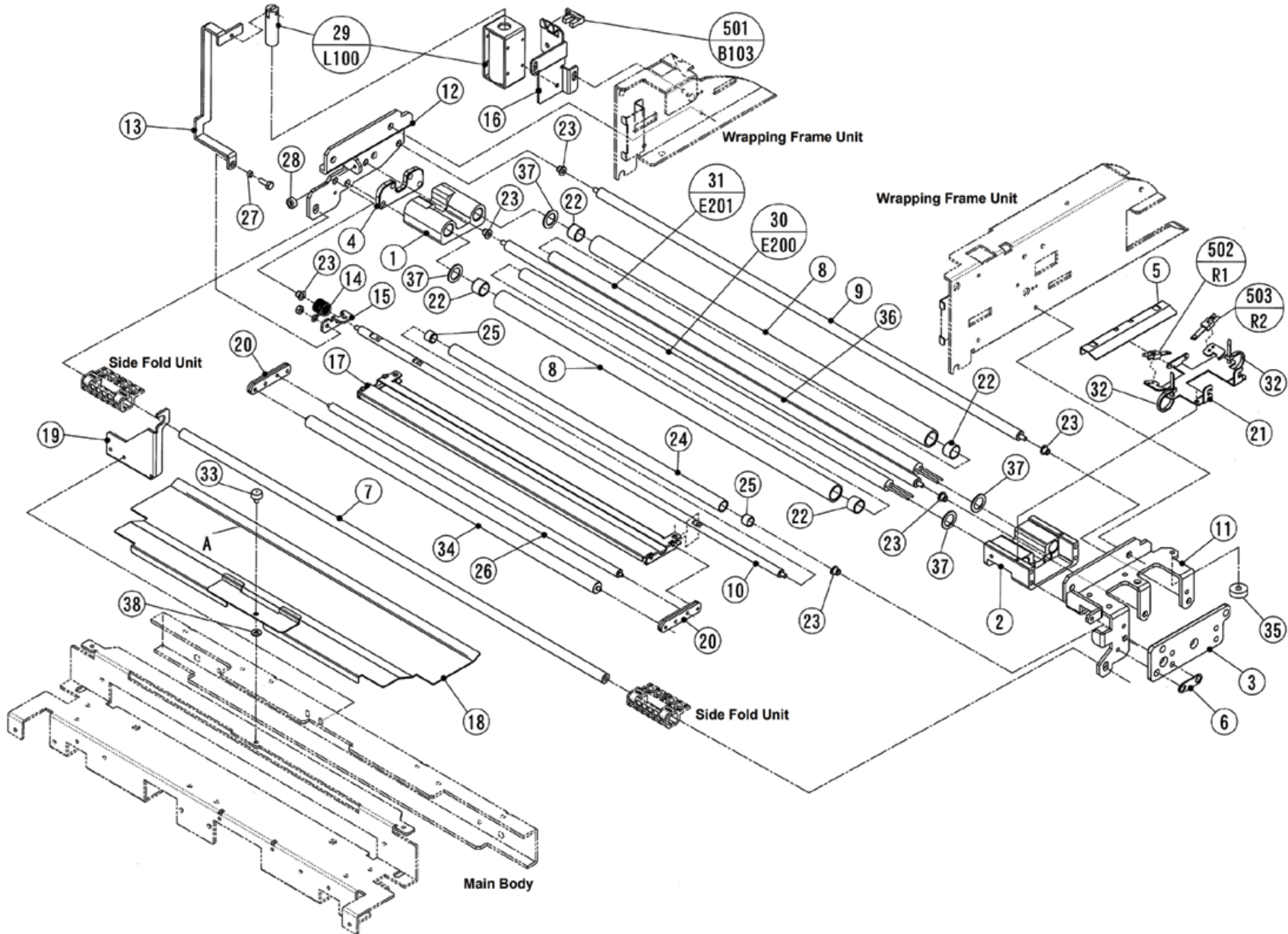
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WRAPPING: LEFT/RIGHT (Section 3)



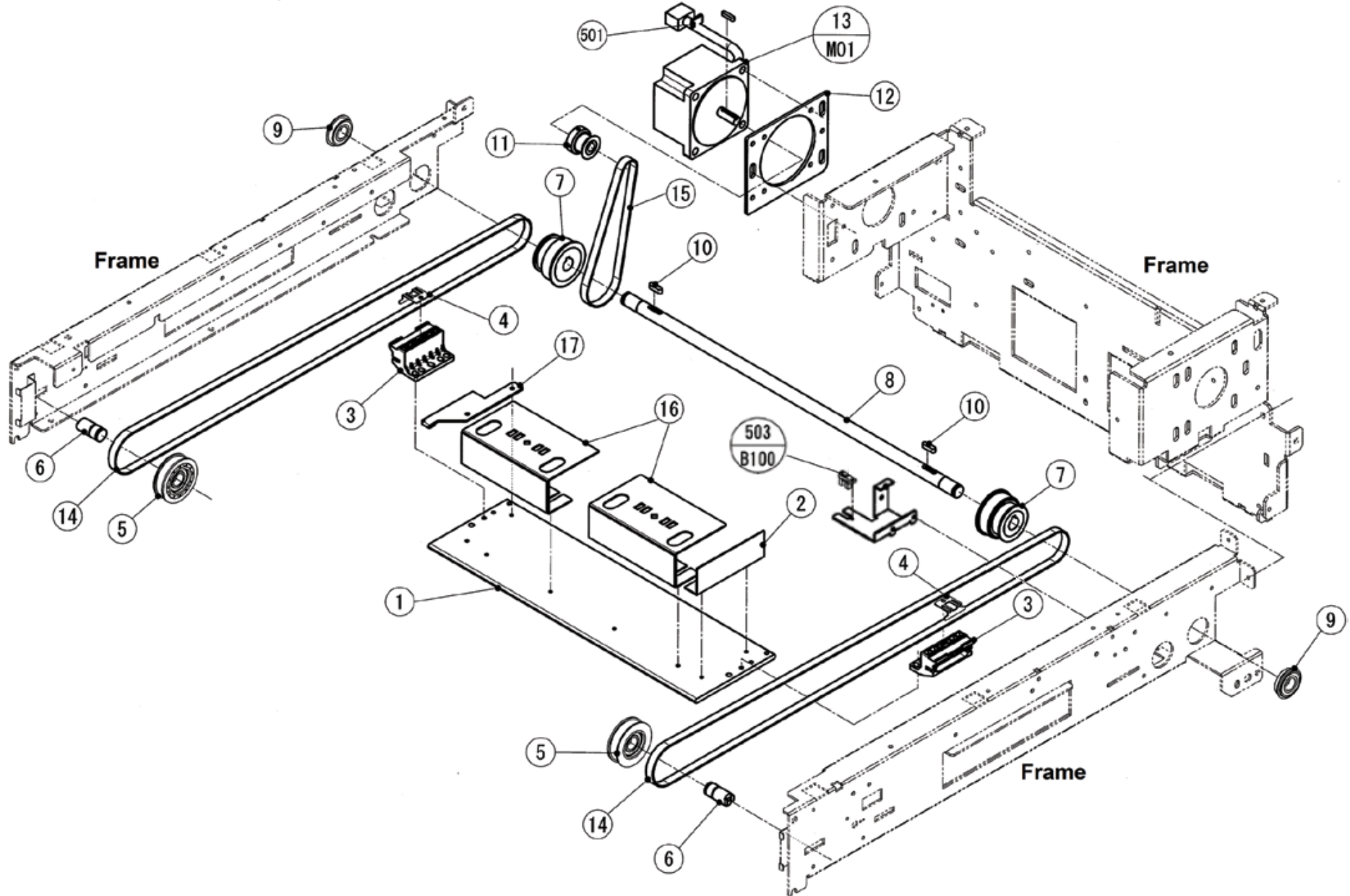
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SEAL HEATERS (Section 4)



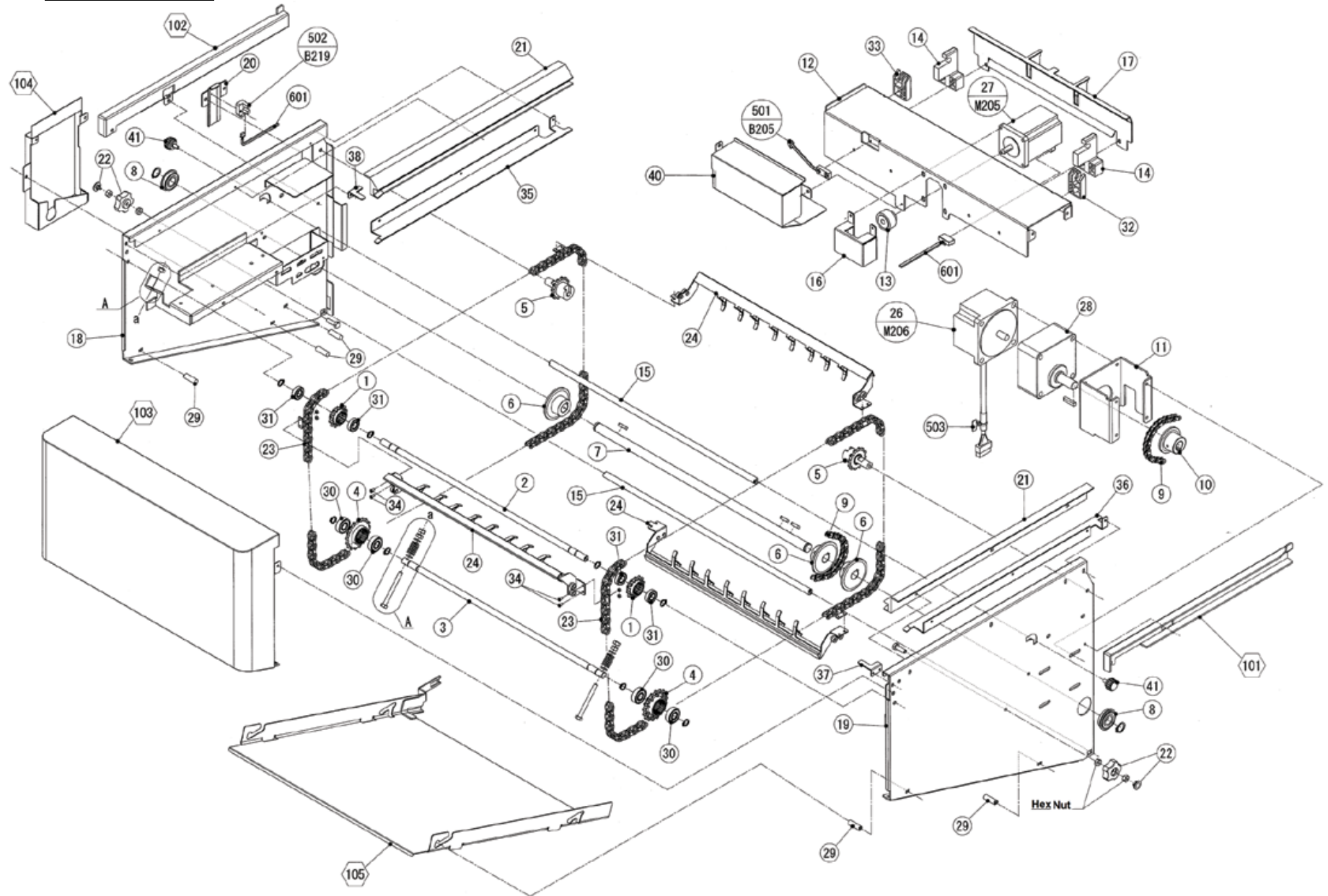
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DISCHARGE PUSHER (Section 5)



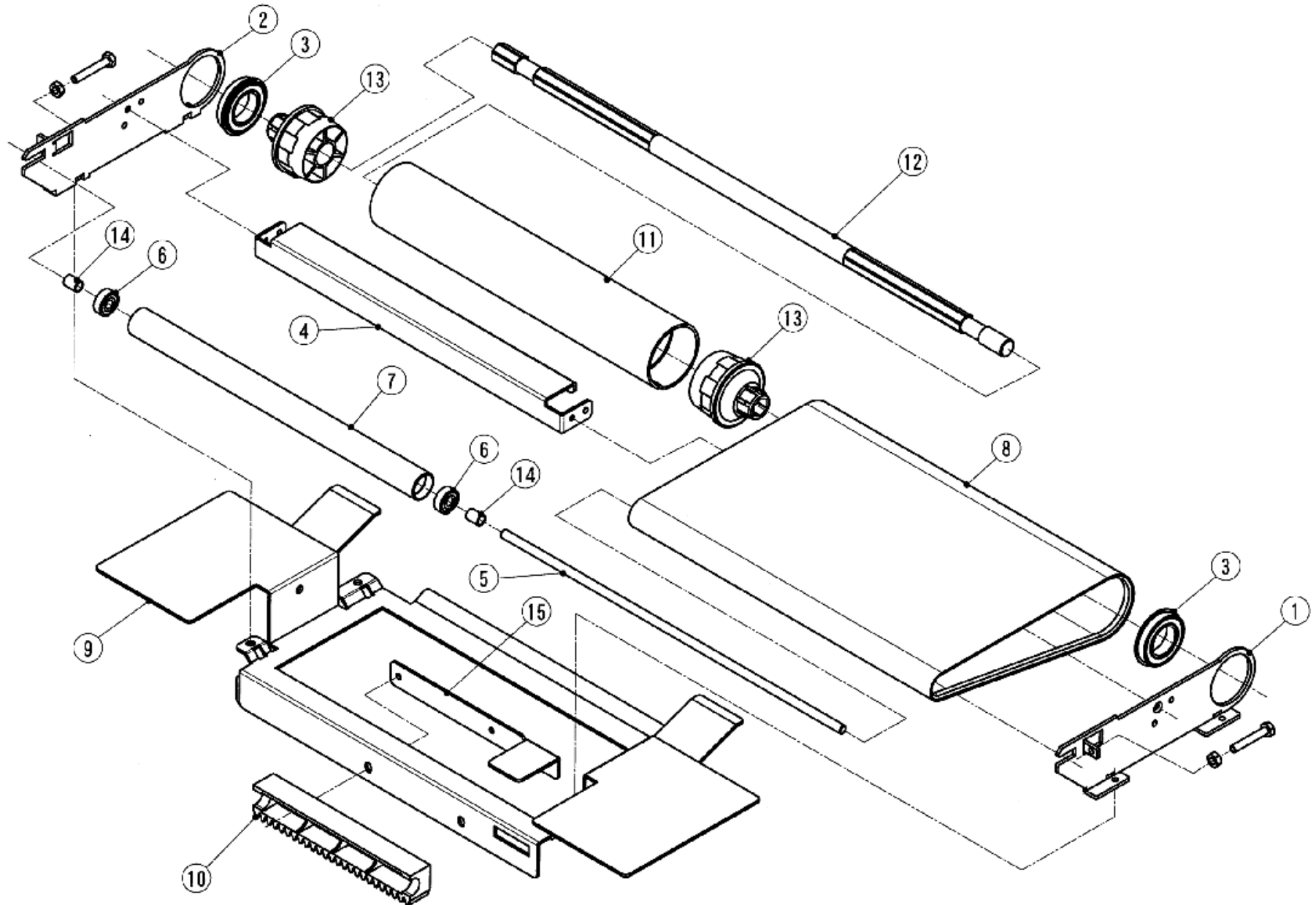
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INFEED (Section 6)



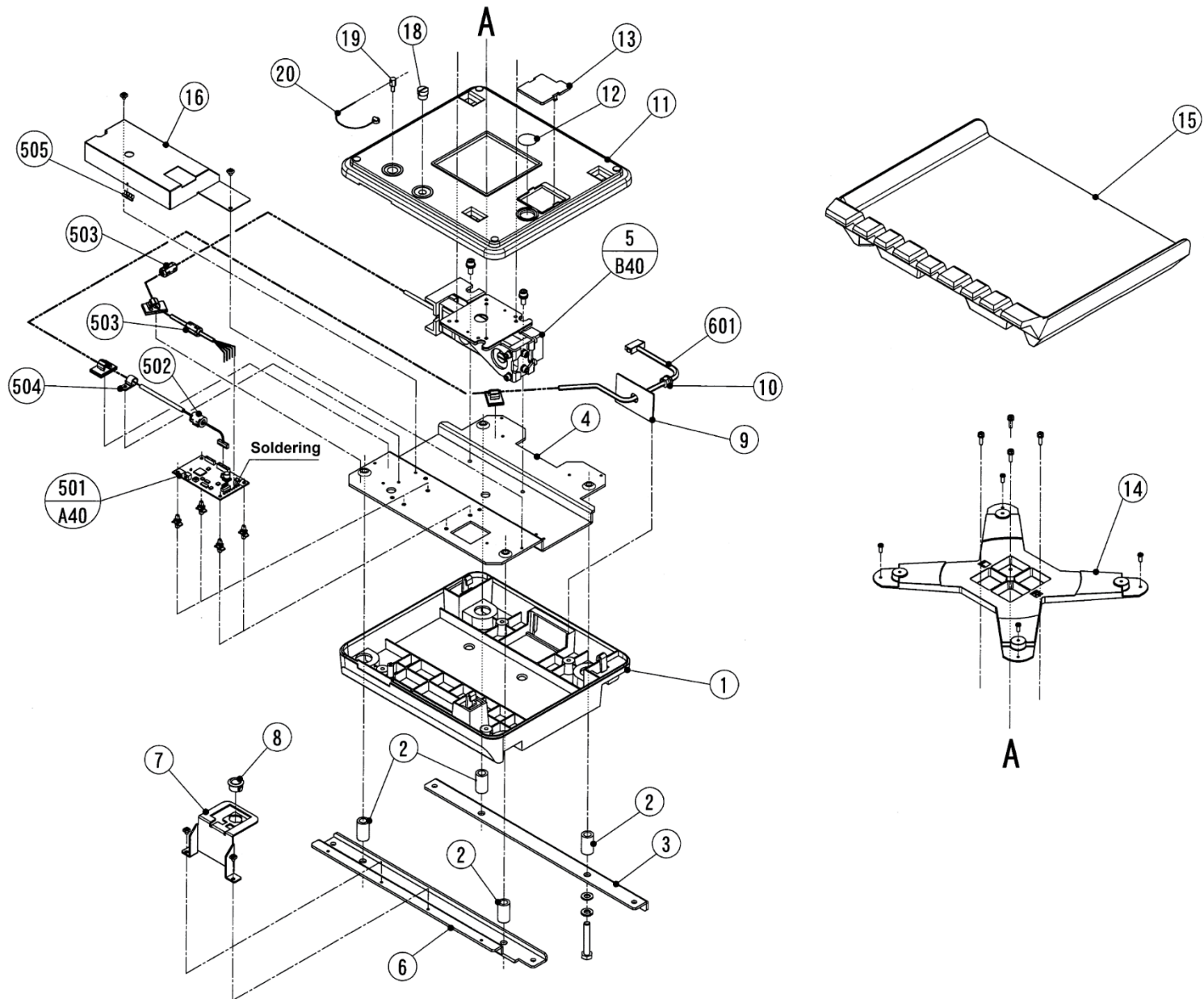
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CENTERING (Section 7)



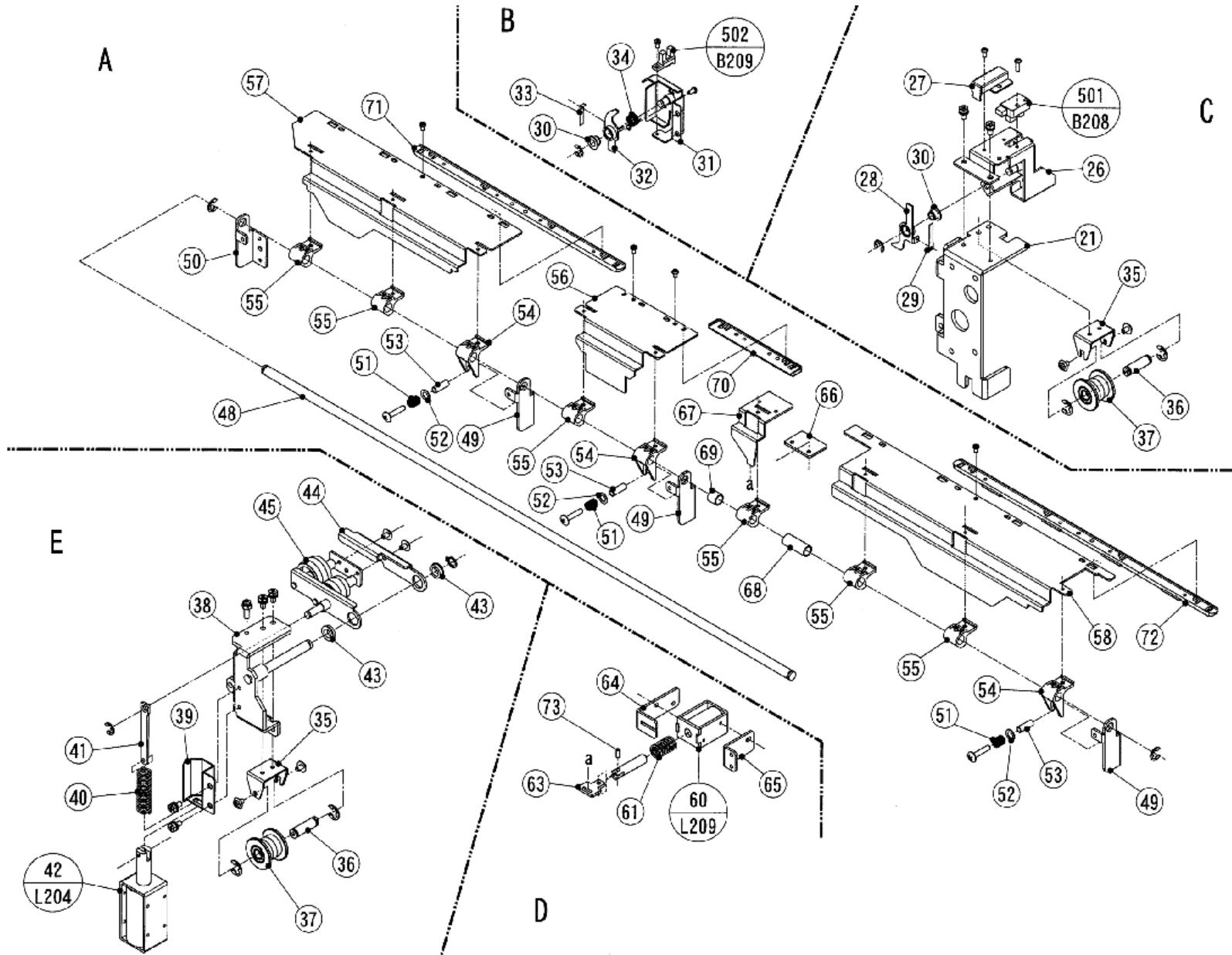
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SCALE (Section 8)



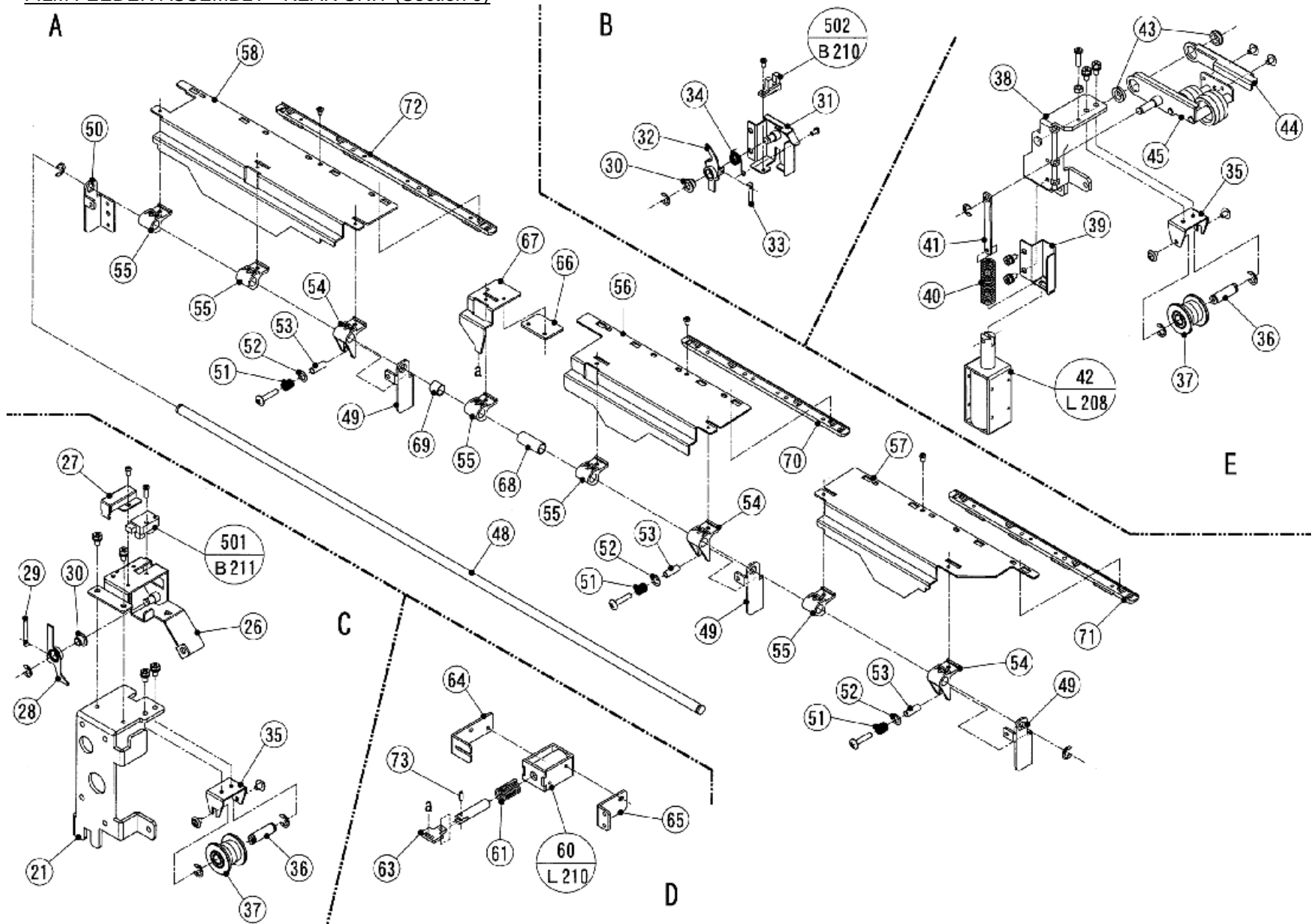
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FILM FEEDER ASSEMBLY - FRONT UNIT (Section 9)



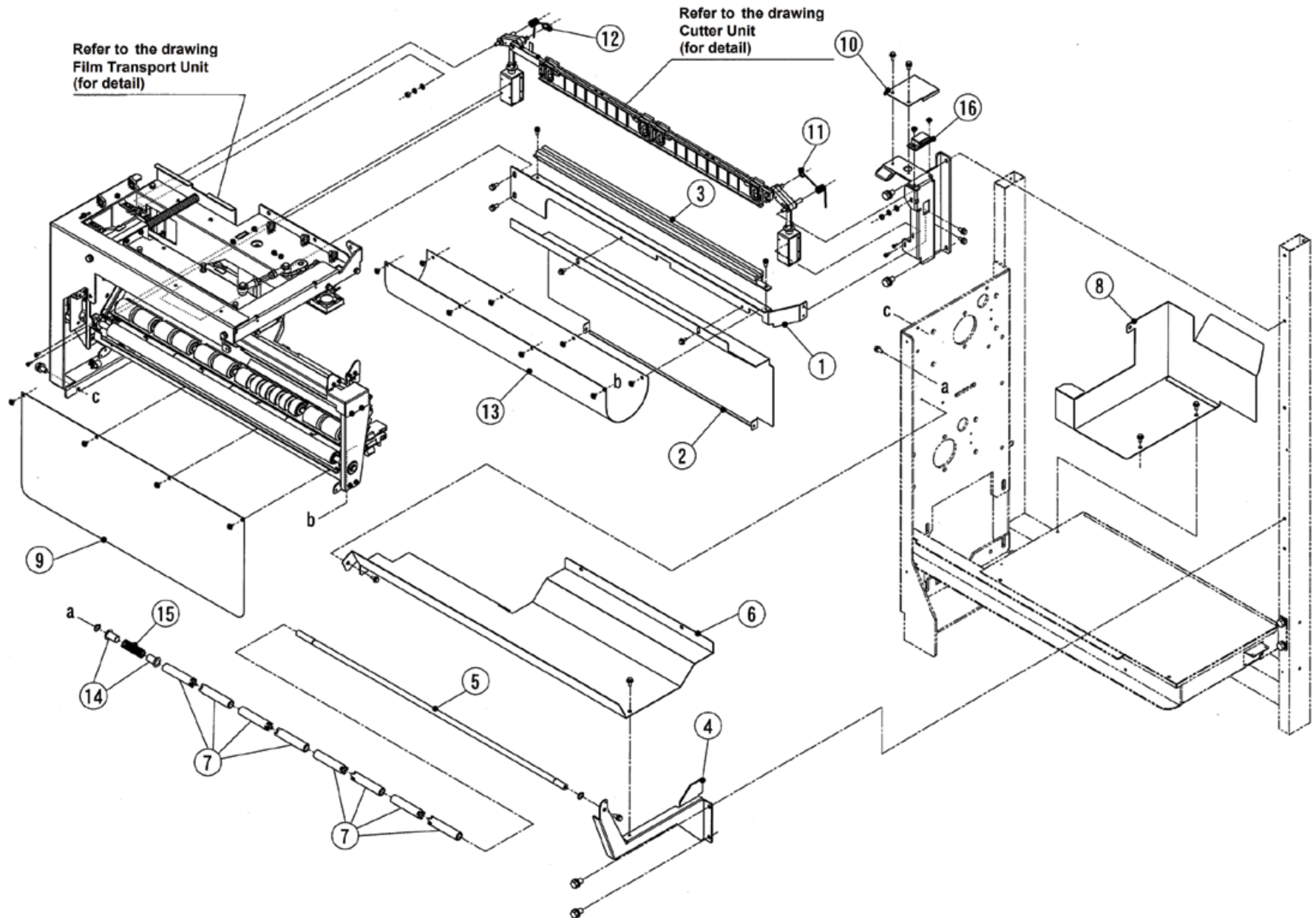
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FILM FEEDER ASSEMBLY - REAR UNIT (Section 9)



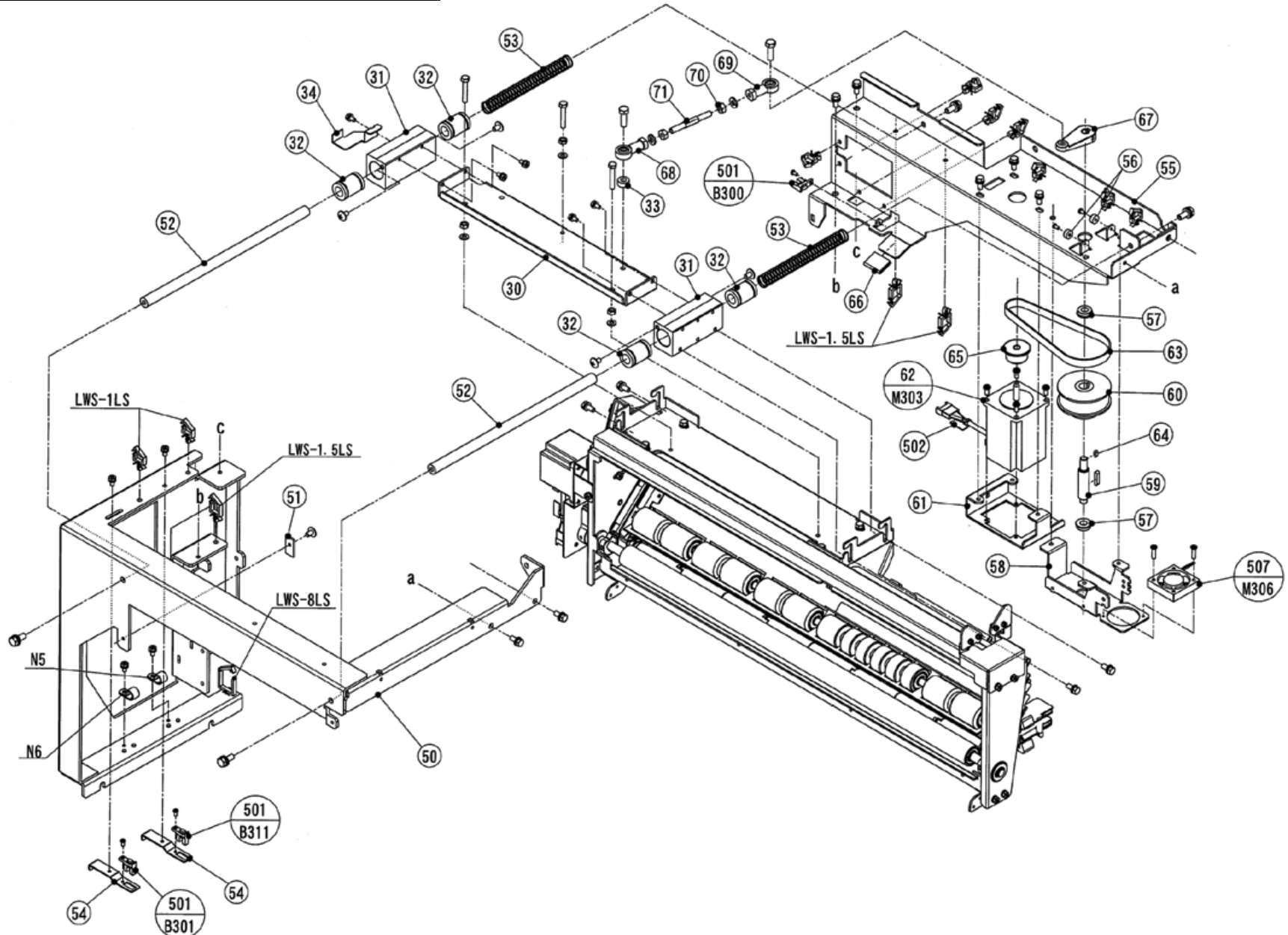
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FILM TRANSPORT ASSEMBLY #1 (Section 10)



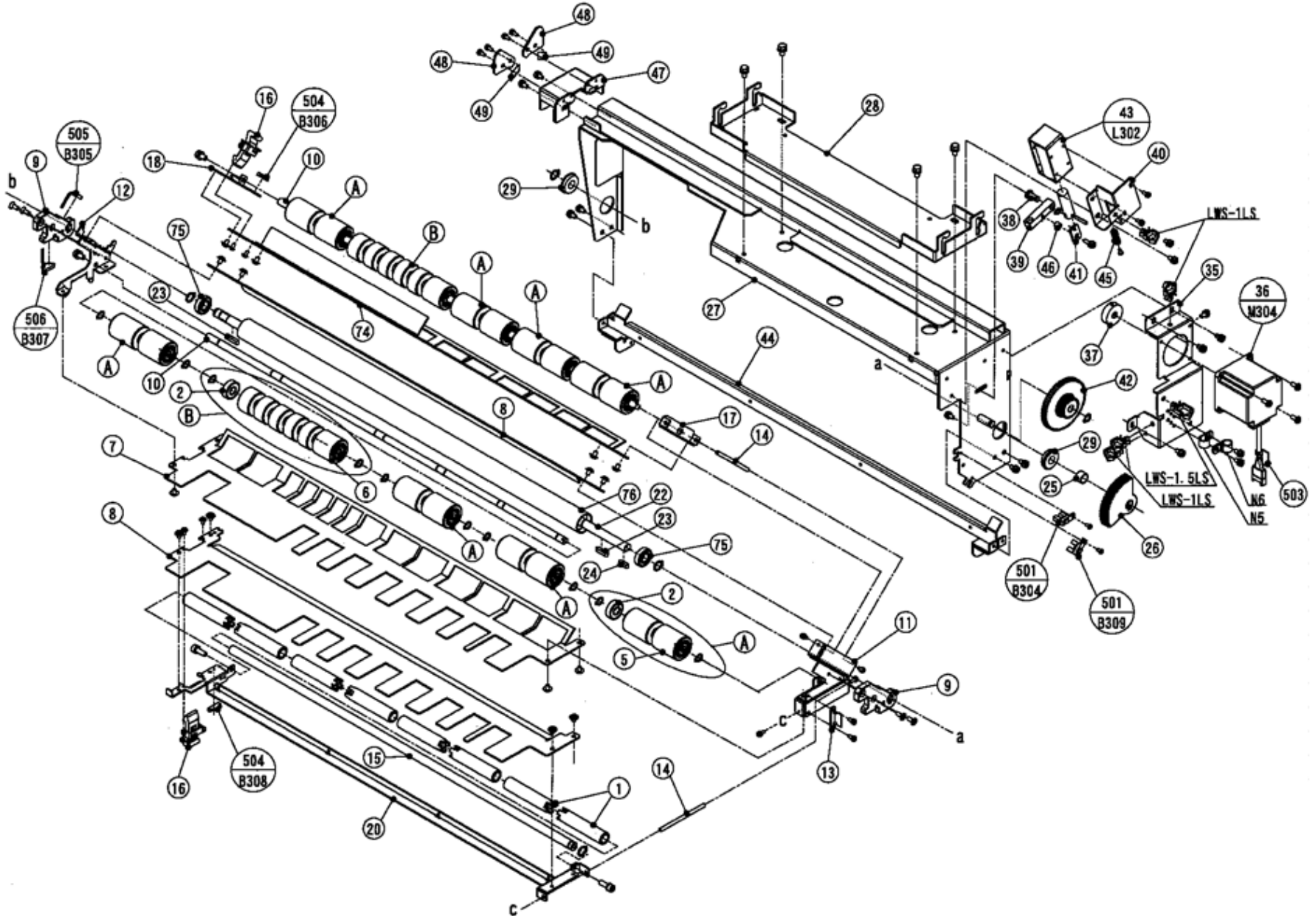
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FILM TRANSPORT ASSEMBLY - #2 (Section 10)



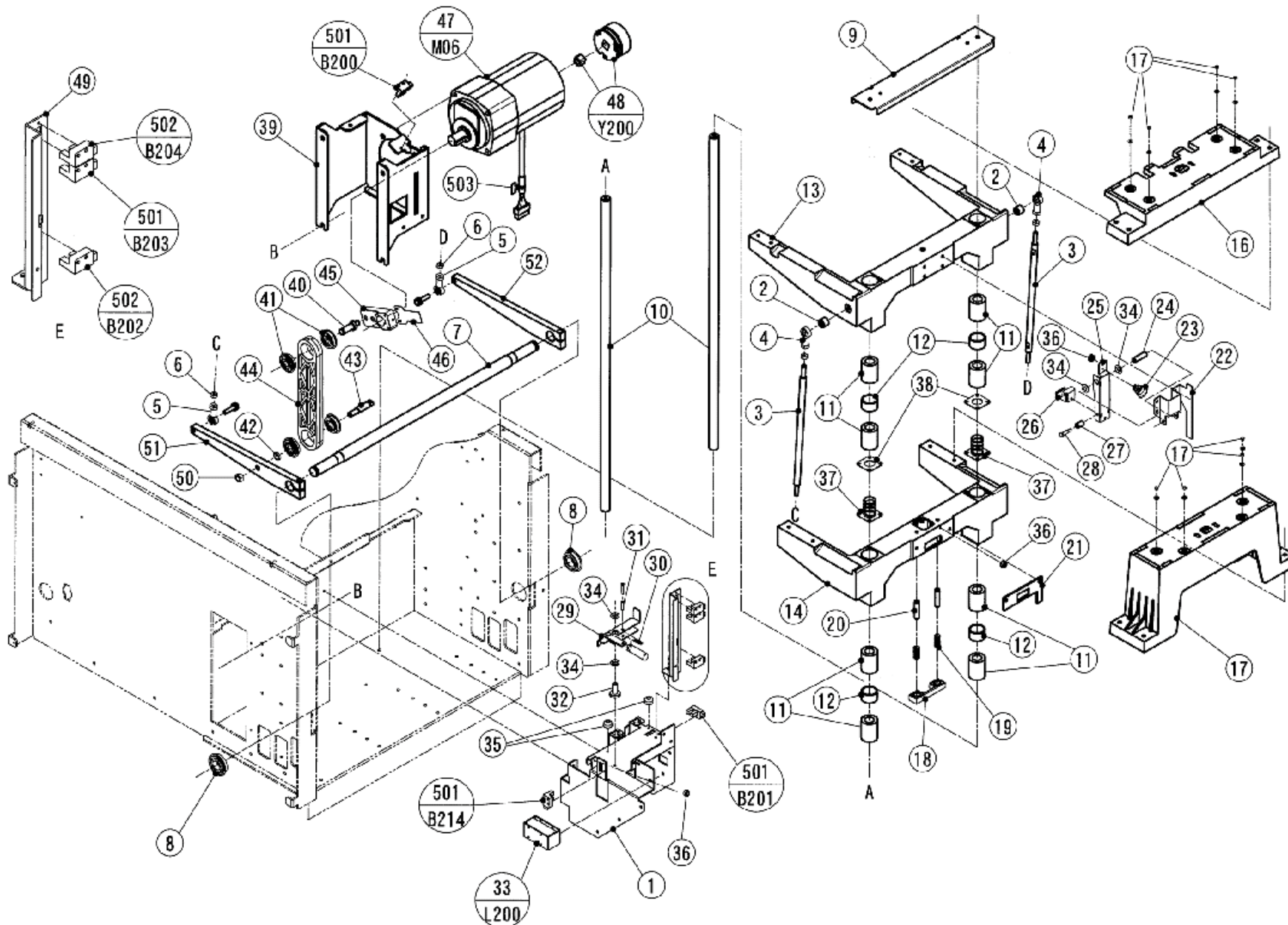
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FILM TRANSPORT ASSEMBLY - #3 (Section 10)



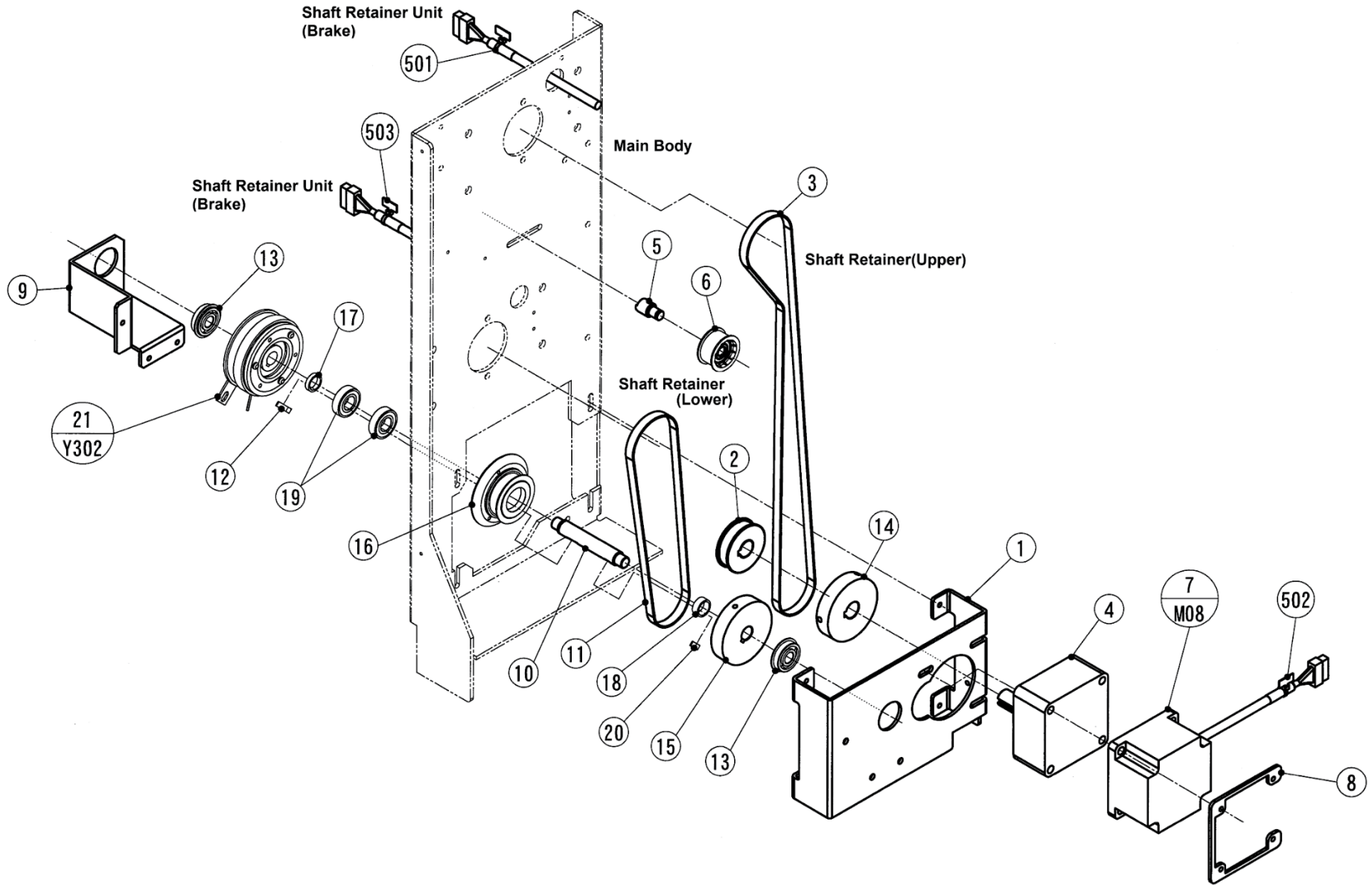
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LIFT DRIVE (Section 11) & LIFT SIZE CHANGE (Section 12)



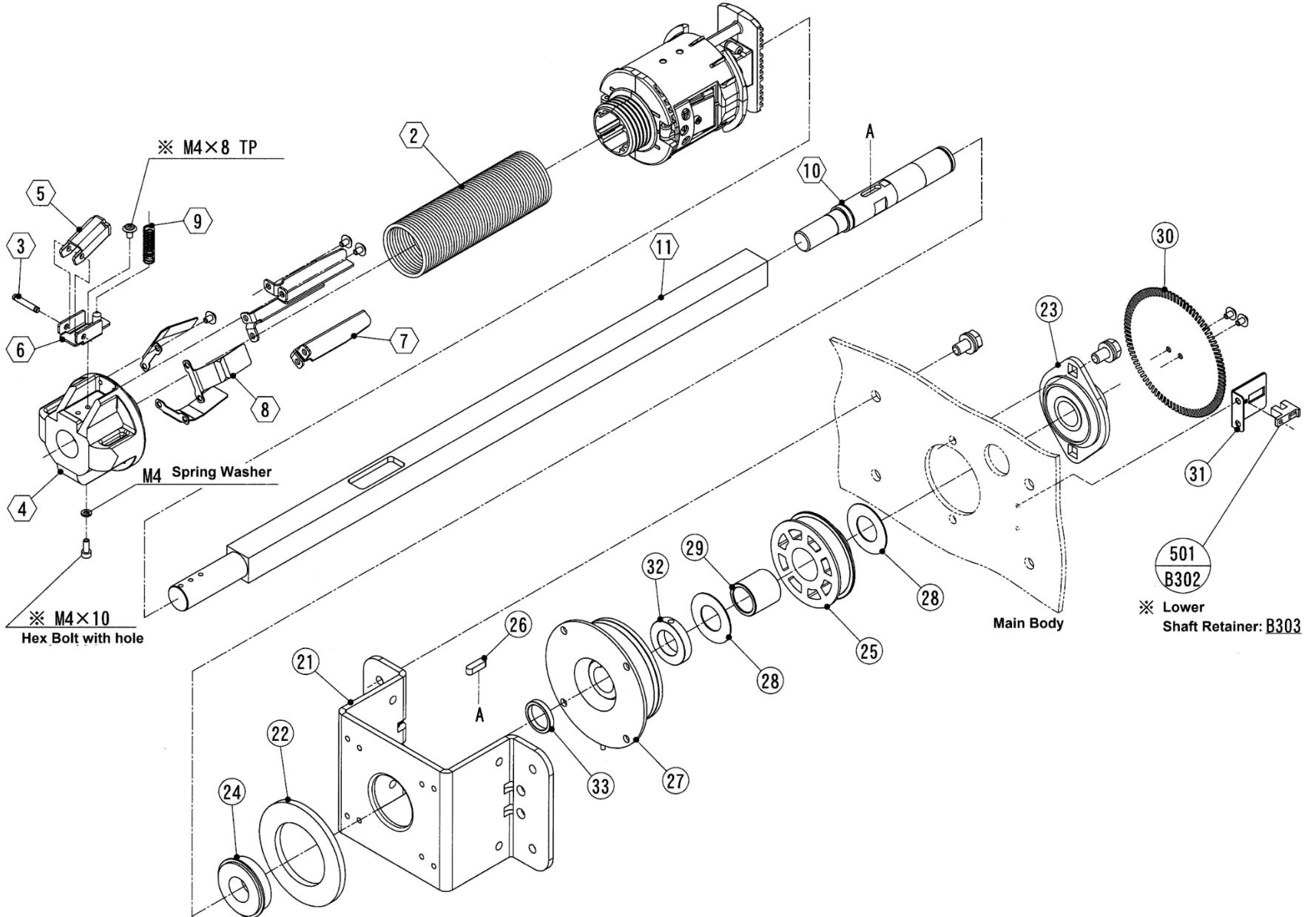
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FILM ROLL DRIVE - (Section 13)



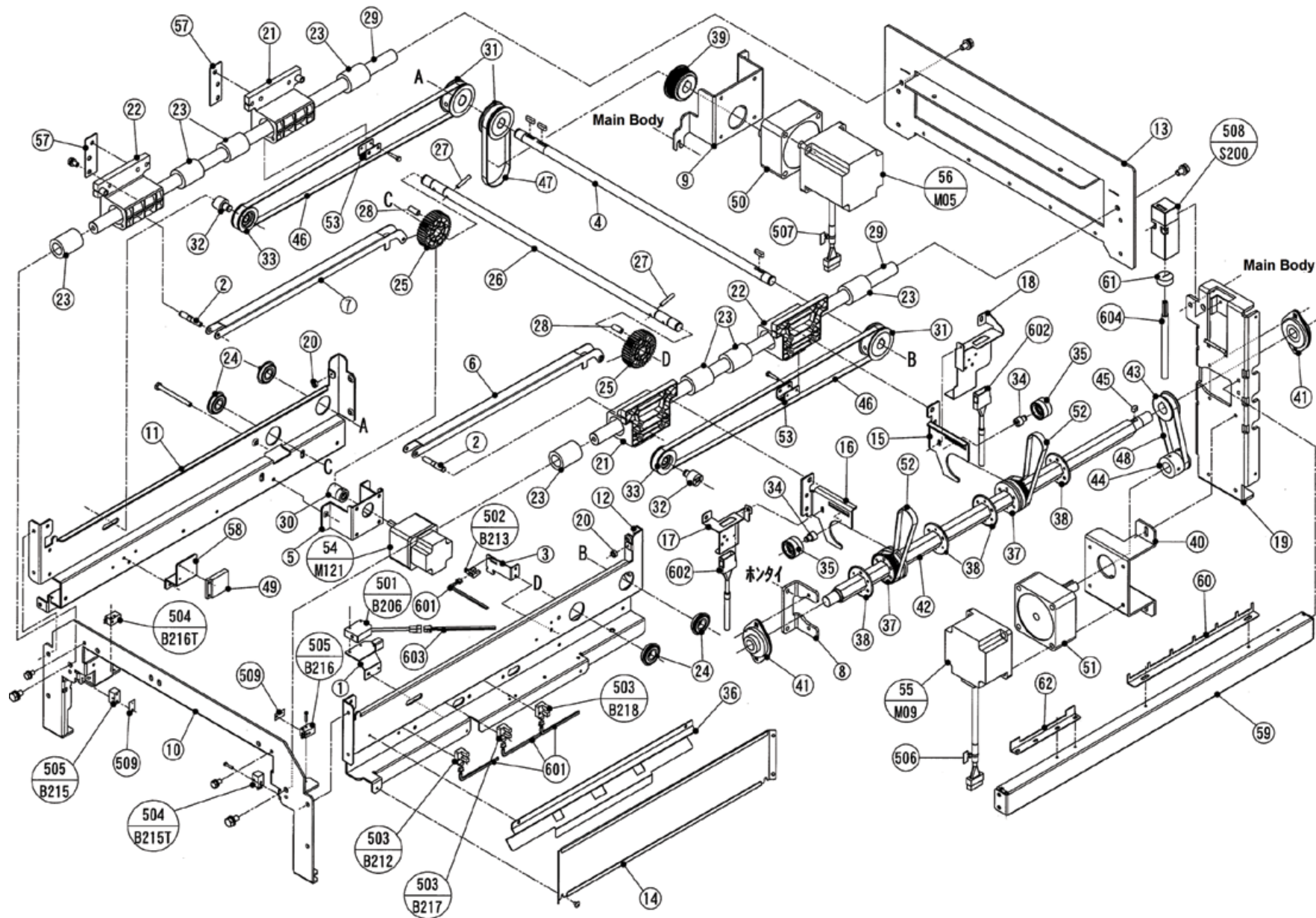
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FILM ROLL HOLDERS - (Section 13)



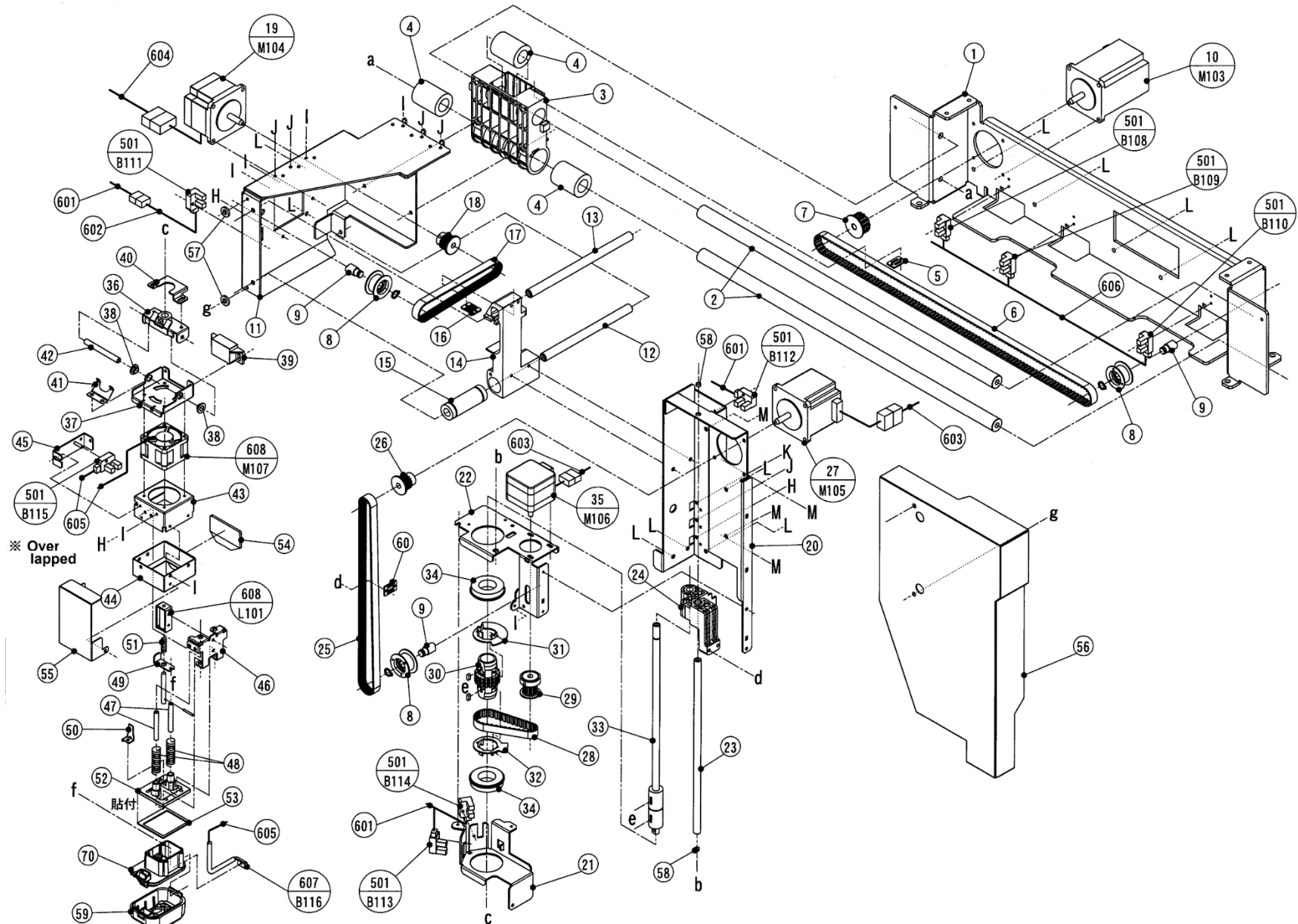
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FILM FEEDER MOVEMENT (Section 14)



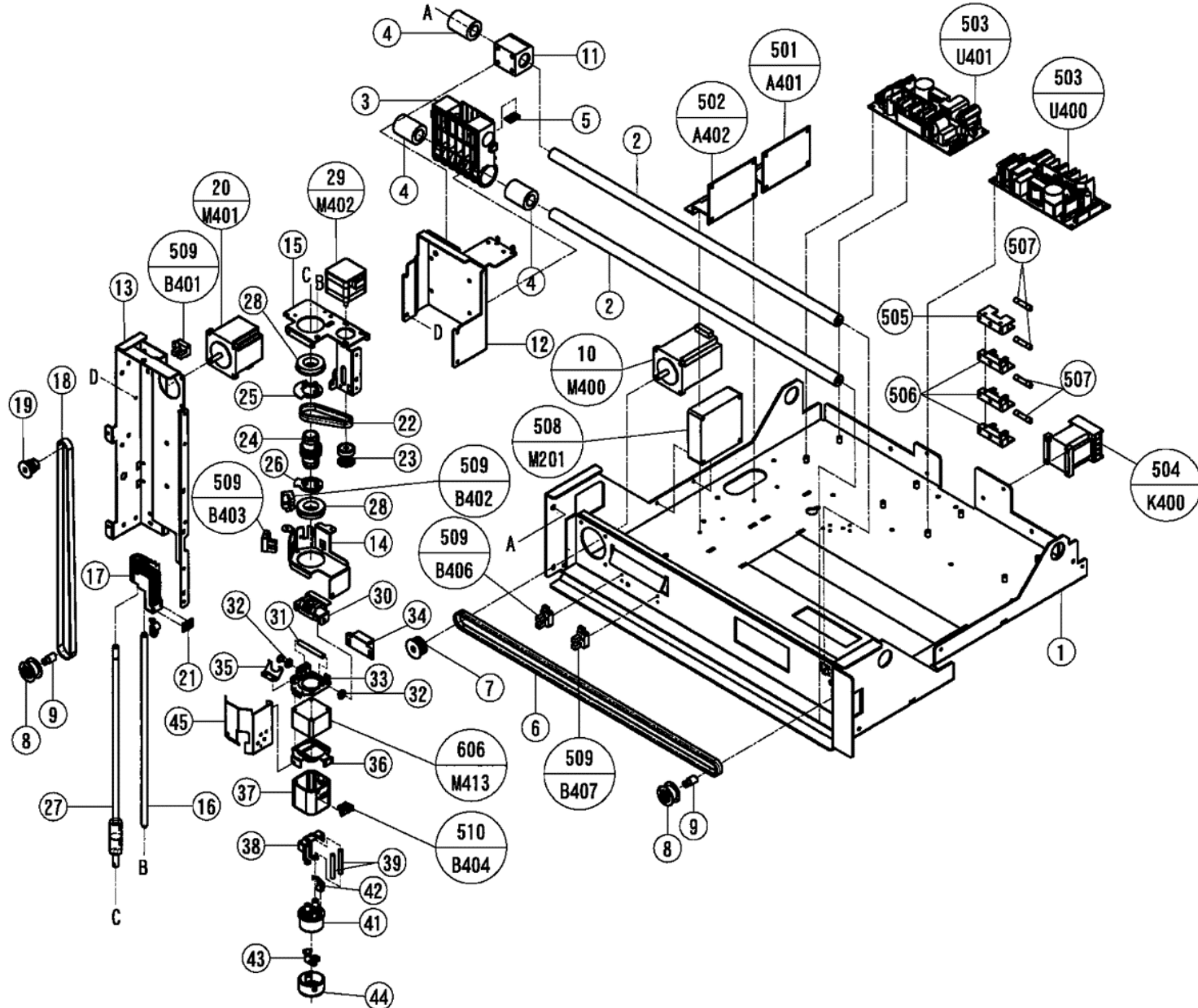
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LABEL APPLICATOR - MAIN (Section 15)



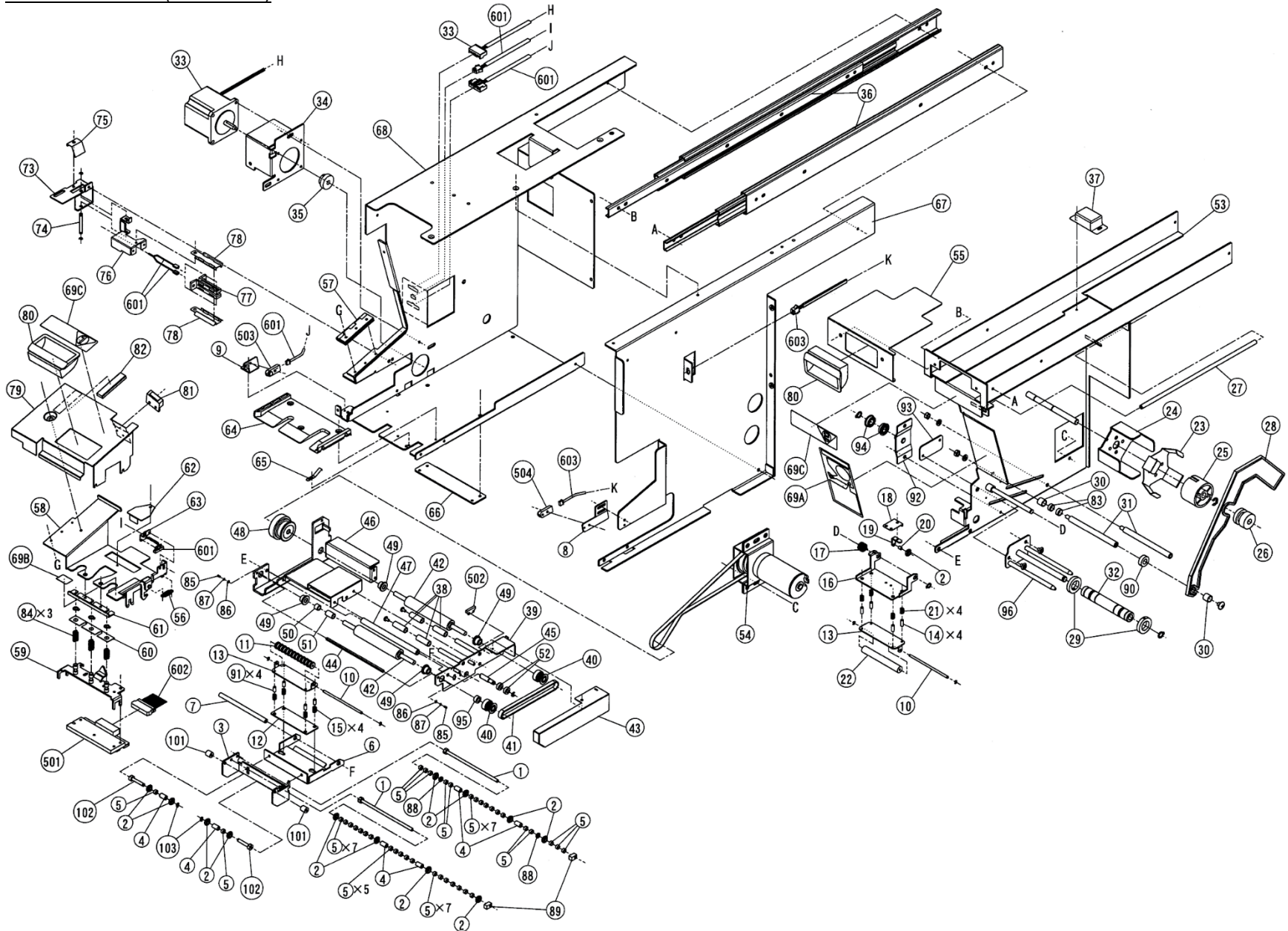
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LABEL APPLICATOR - POP (Section 16)



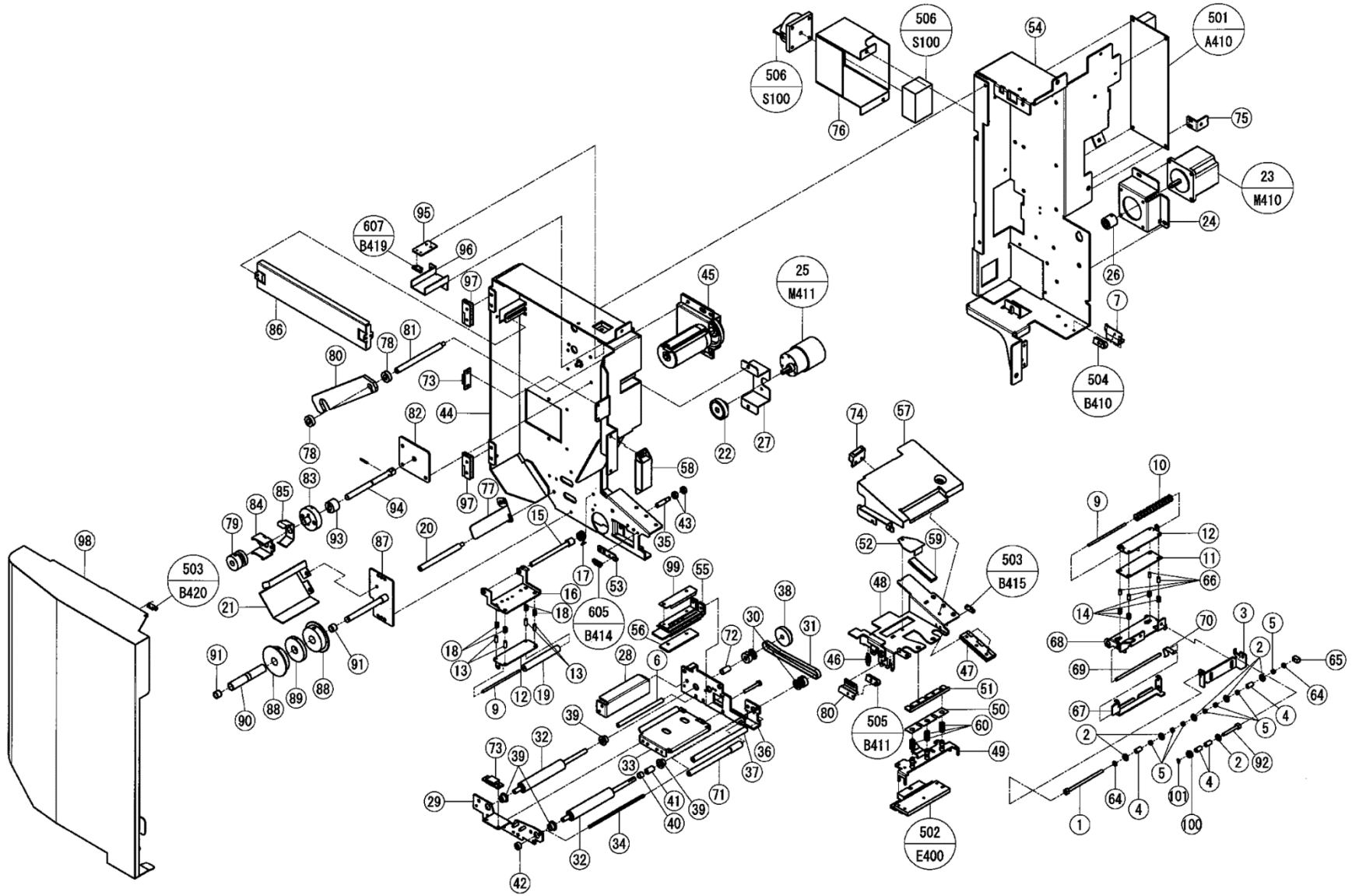
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PRINTER - MAIN (Section 17)



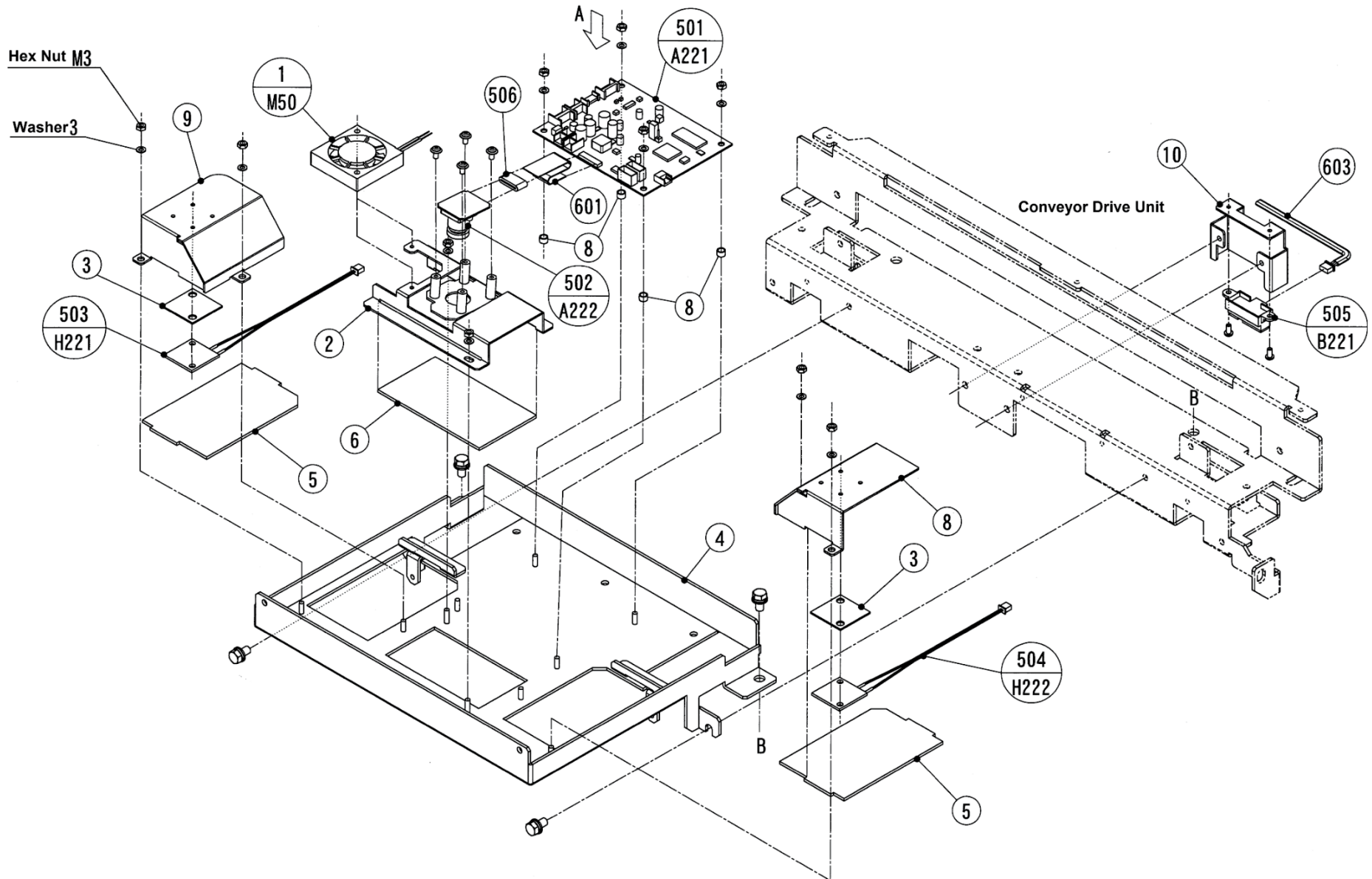
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PRINTER - POP (Section 18)



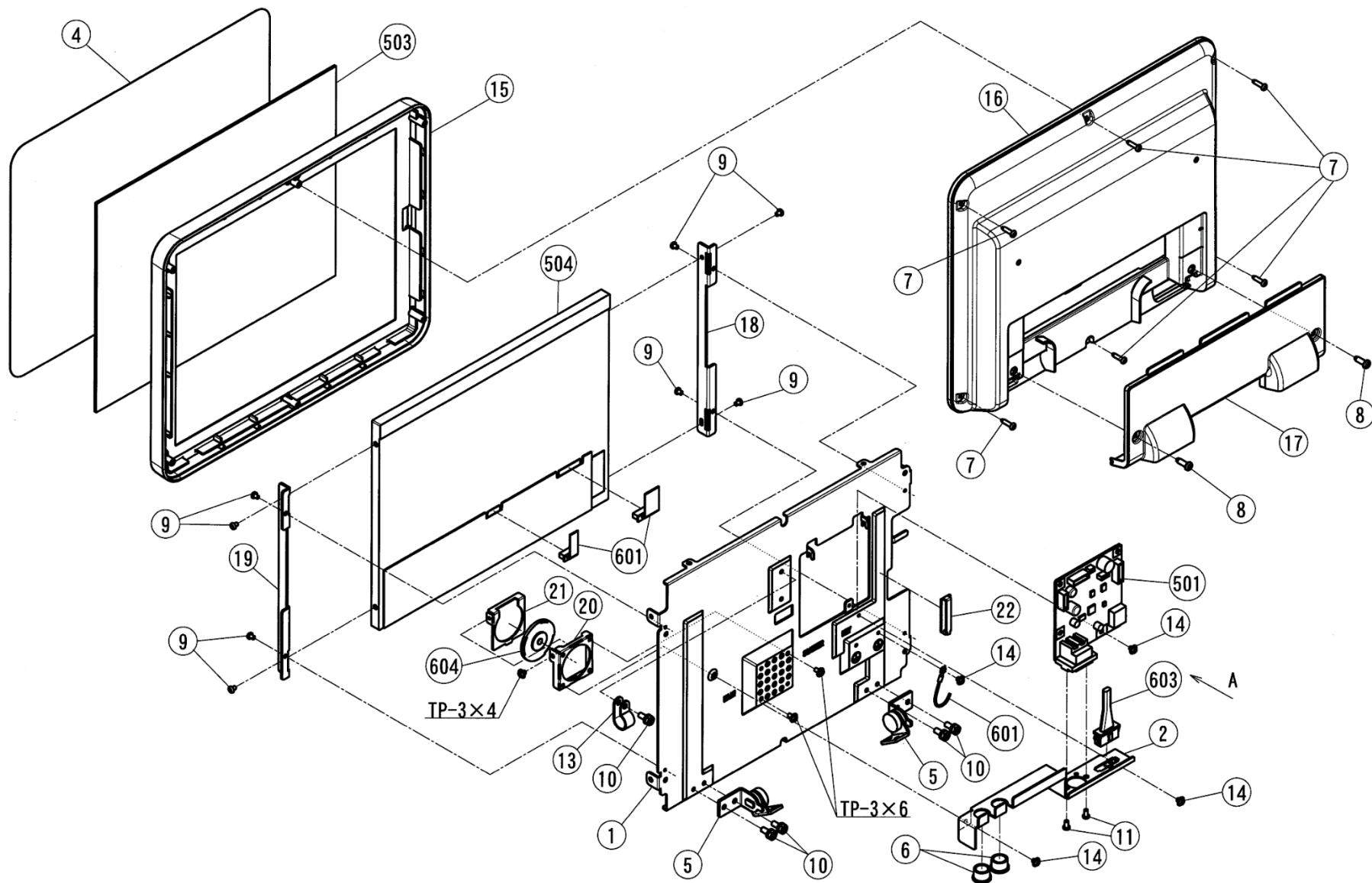
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CAMERA & LIGHTING (Section 19)



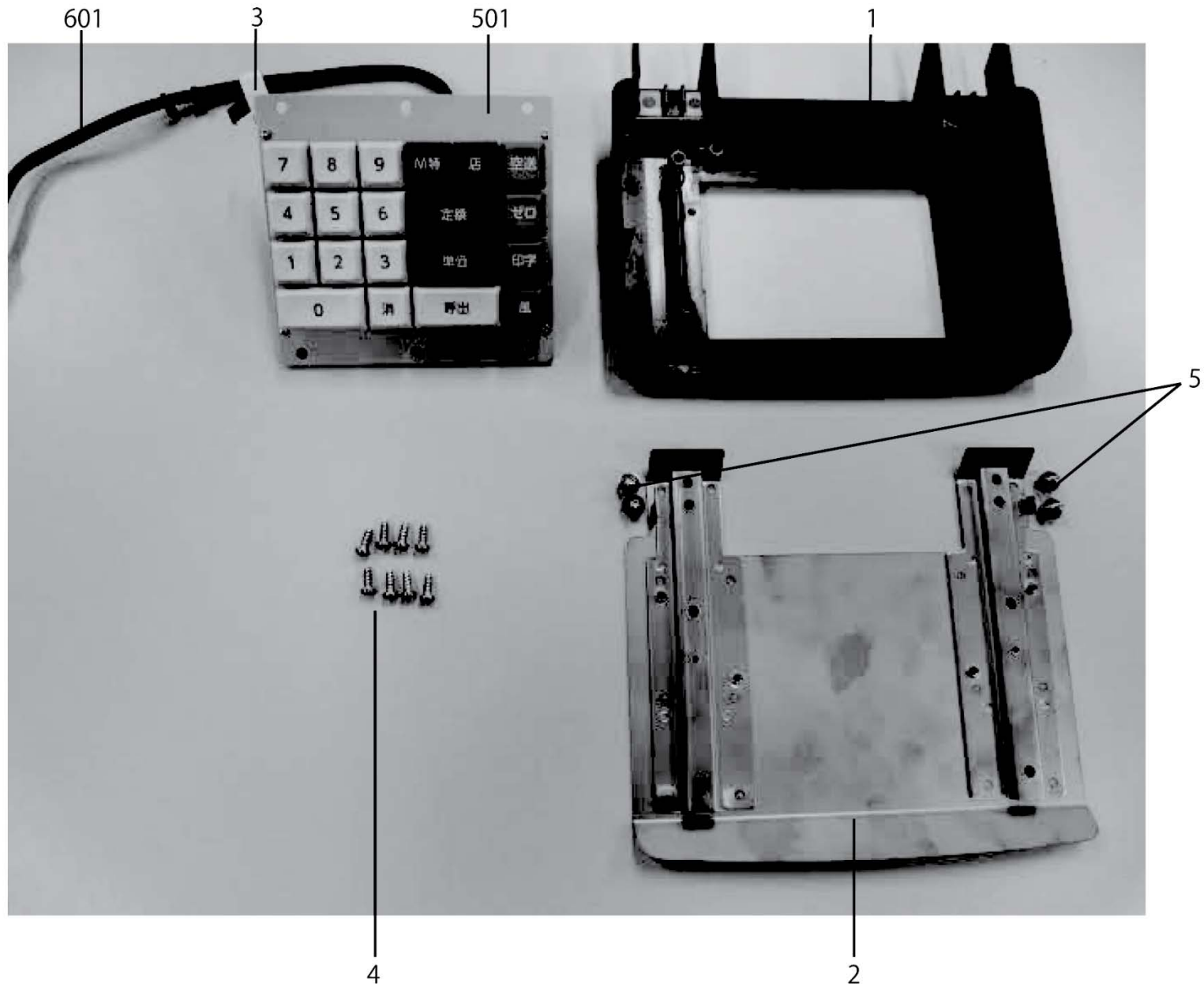
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TOUCH SCREEN DISPLAY (Section 20)



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KEYBOARD ASSEMBLY (Section 21)



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