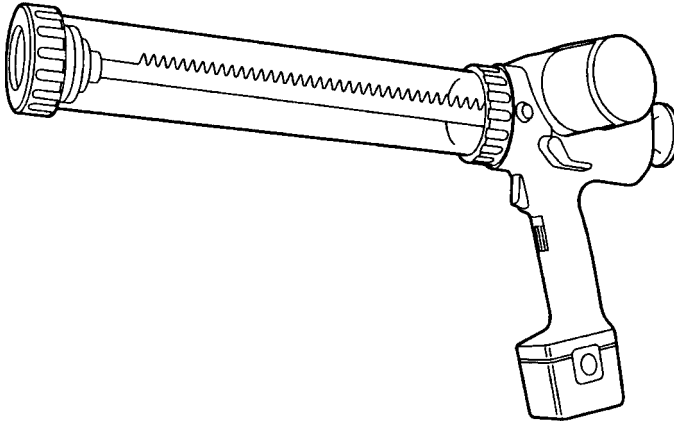


Service Manual

Variable Speed Cordless Sealing Gun

EY3654



SPECIFICATIONS

Motor voltage	: DC Motor 7.2V
Ejection pressure	: 2,500N (250kgf)
Length overall	: max. 892mm (35"), min. 550mm (22")
Weight (with battery pack)	: 2.1kg (4.6 lbs)

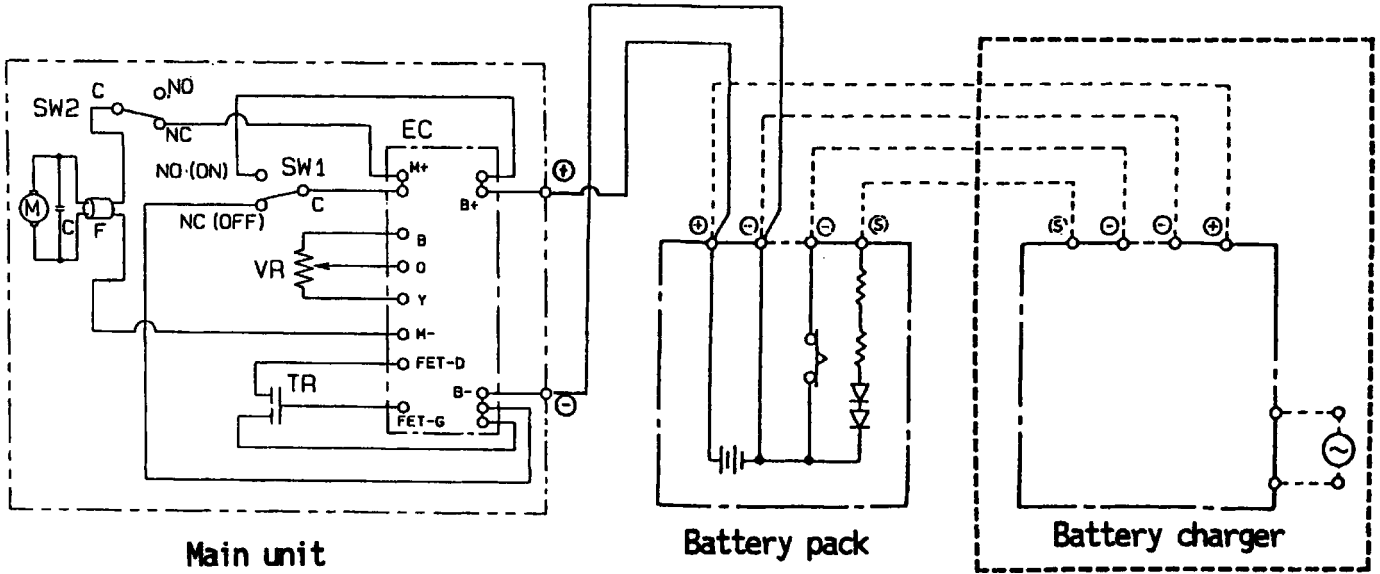
⚠ WARNING

This service information is designed for experienced repair technicians only and is not designed for use by the general public. It does not contain warnings or cautions to advise non-technical individuals of potential dangers in attempting to service a product. Products powered by electricity should be serviced or repaired only by experienced professional technicians. Any attempt to service or repair the product or products dealt with in this service information by anyone else could result in serious injury or death.

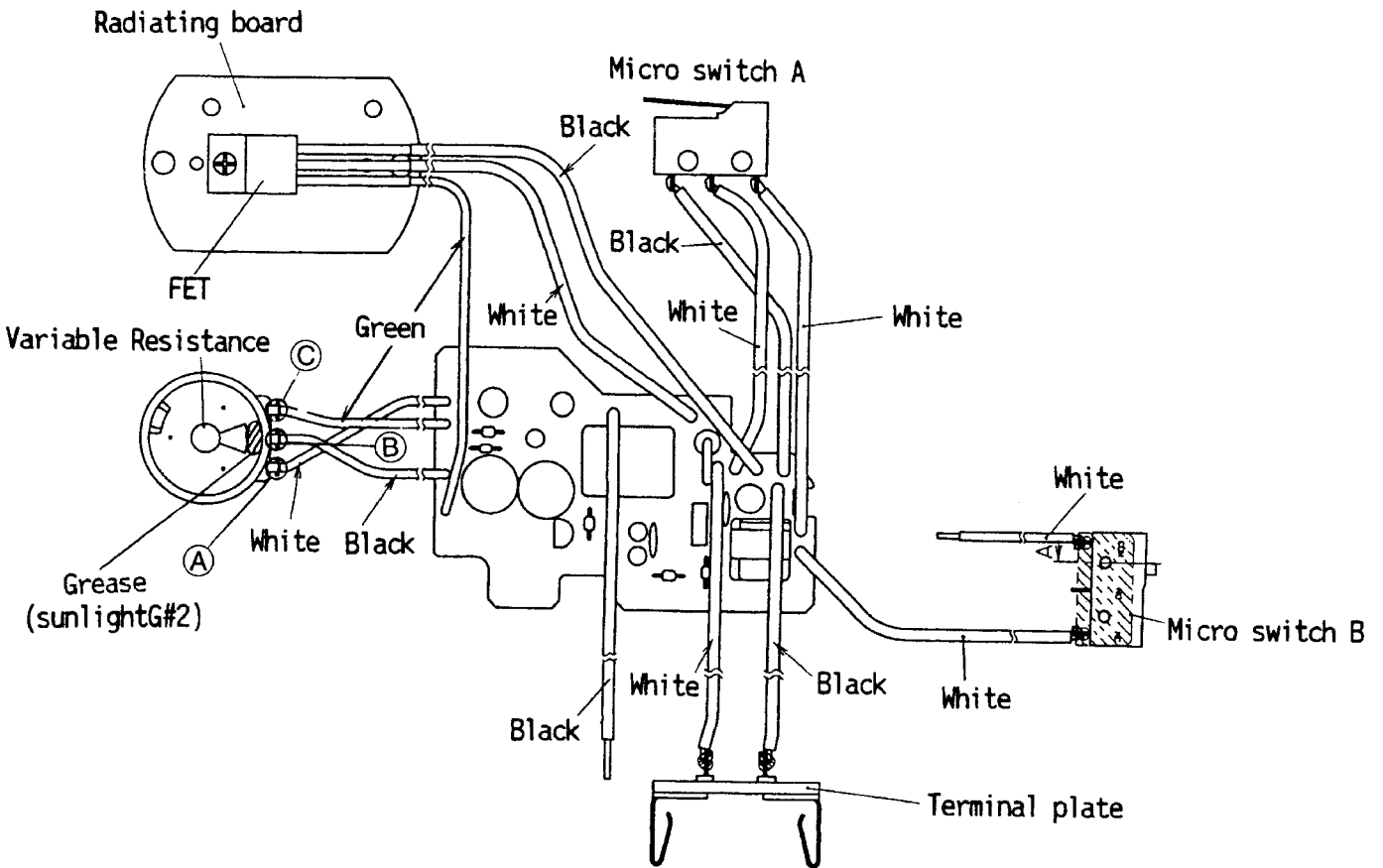
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1 SCHEMATIC DIAGRAM

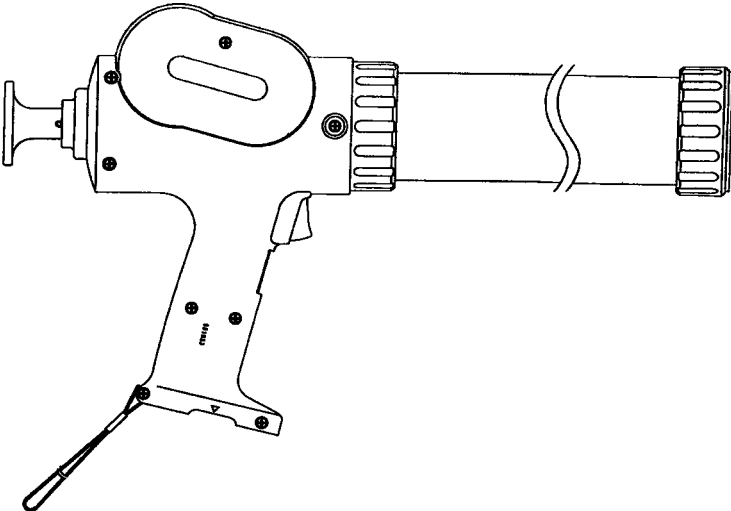
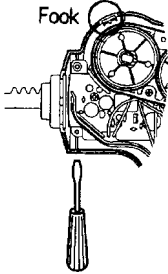


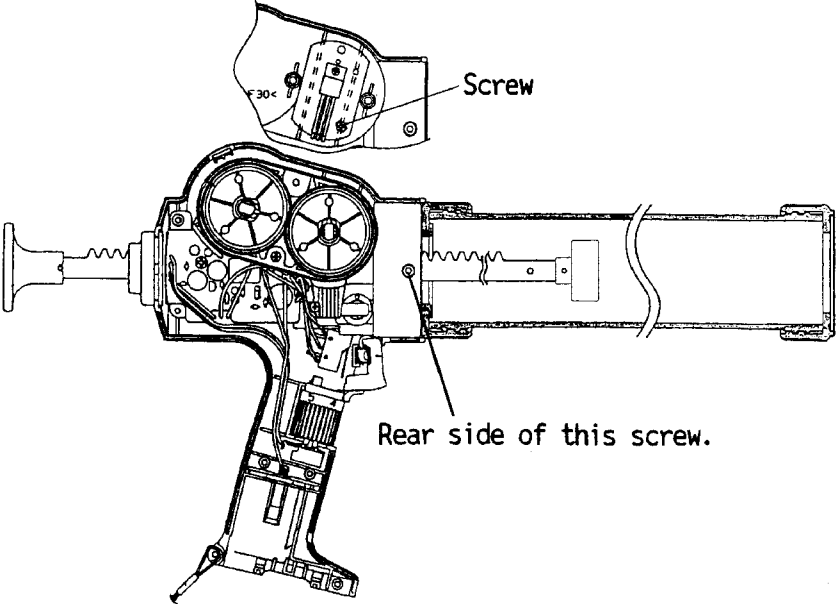
2 WIRING CONNECTION DIAGRAM

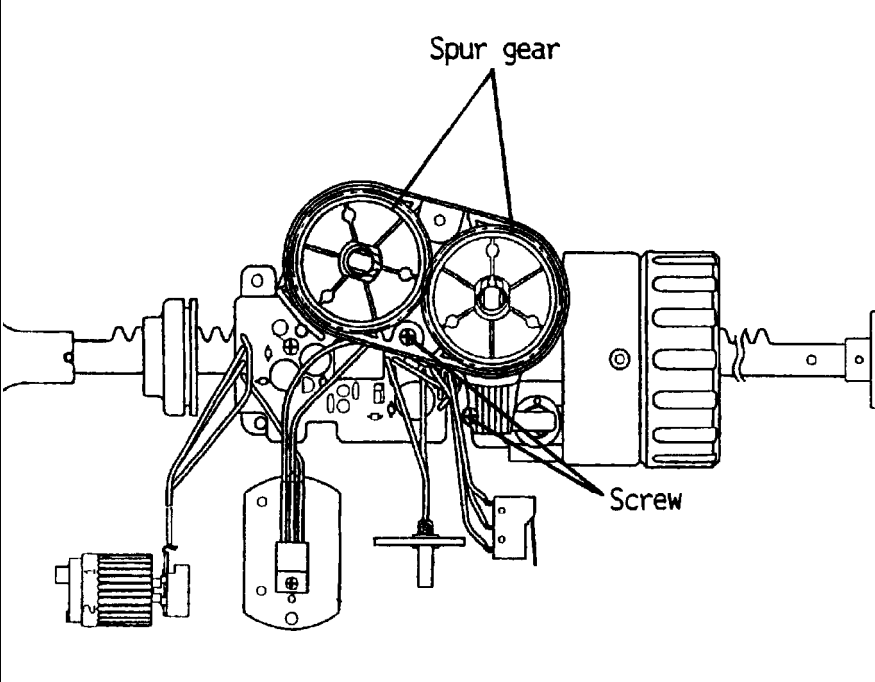


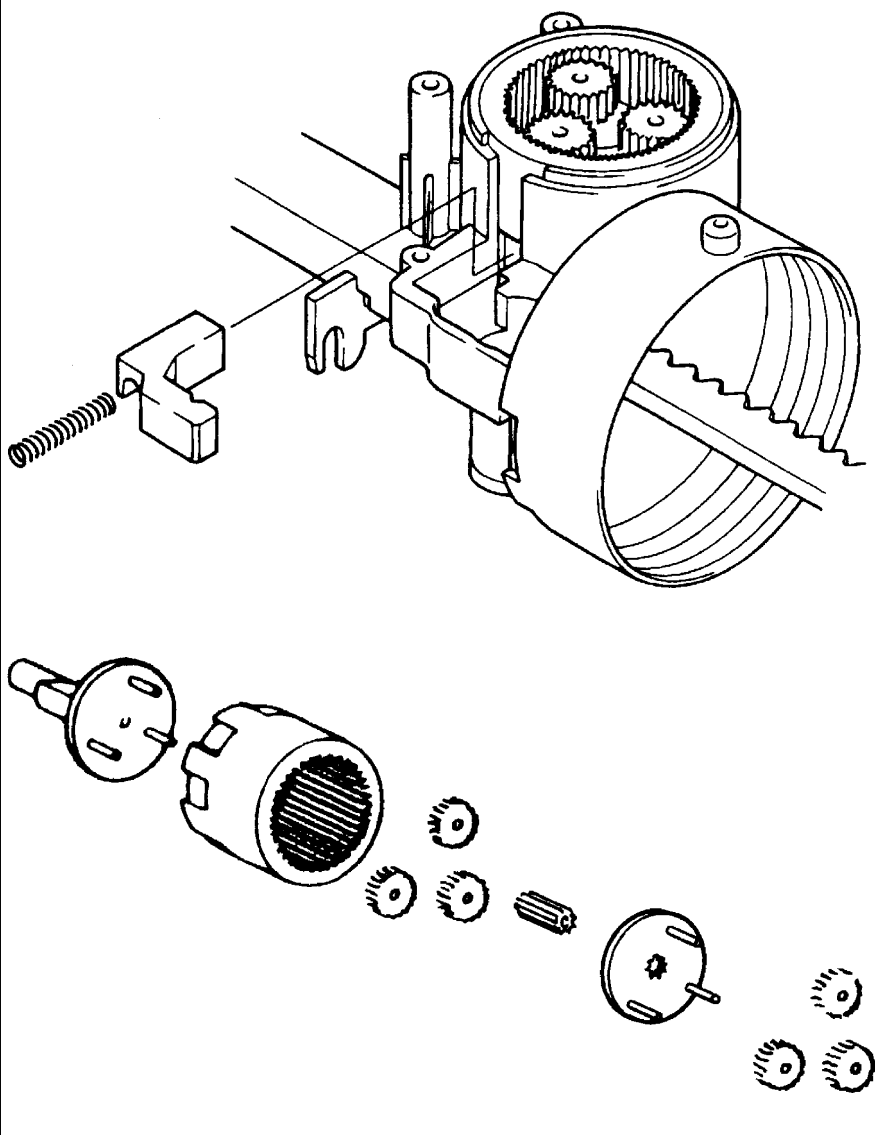
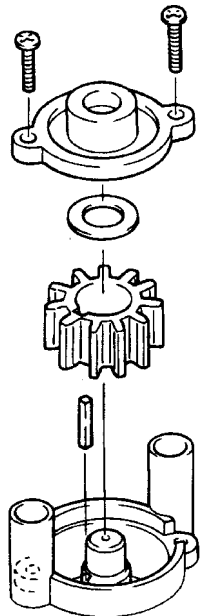
3 DISASSEMBLY / ASSEMBLY INSTRUCTIONS

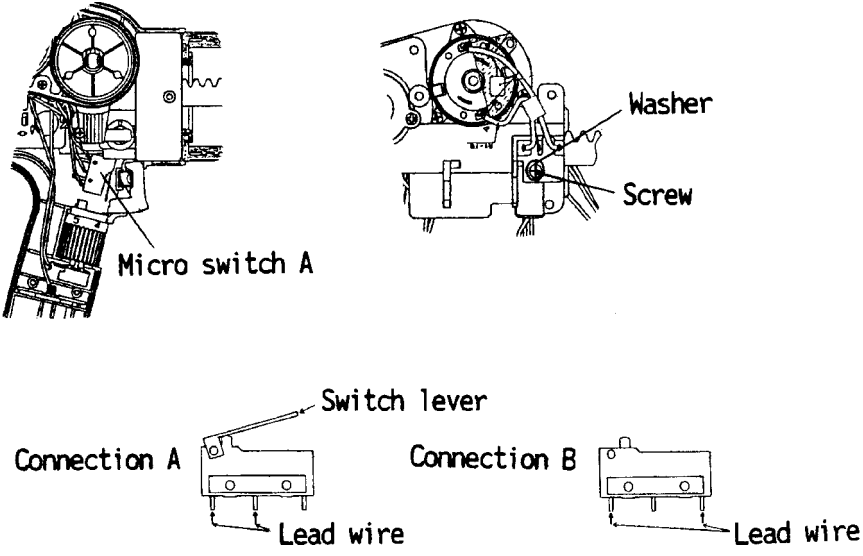
■HOW TO DISASSEMBLE MAIN UNIT.

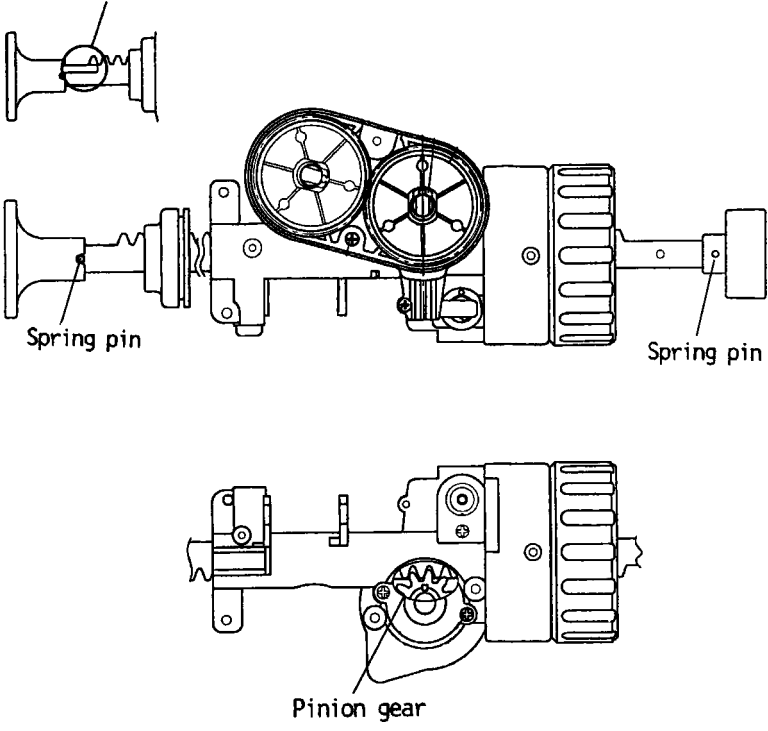
Ref. No. 1A	Procedure 1A	Removal of housing.
		<p>1.Remove 7 housing screws.</p> <p>NOTE : To open housing A and B, unhook one part of housing using a flatted screw driver.</p> <p>NOTE : When assembling housing A and B, fit housing hooks each other, first.</p> 

Ref. No. 1B	Procedure 1A → 1B	Removal of driving block.
 <p>Screw</p> <p>Rear side of this screw.</p>		<p>1.Remove one housing screw and one release lever screw.</p> <p>2.Take driving block out.</p> <p>3.Remove one screw on radiating board.</p>

Ref. No. 1C	Procedure 1A → 1B → 1C	Removal of motor block.
		<p>(Removal of motor.)</p> <ol style="list-style-type: none"> 1.Remove two screws on driving holder. 2.Remove three screws of motor block. <p>(Assembly of motor.)</p> <ol style="list-style-type: none"> 3.Assemble spur gears with driving holder first. 4.Rotate spur gears manually after assembling motor with driving holder. <p>NOTE : If spur gears may not rotate, one tooth may be shifted and it will cause low speed.</p>

Ref. No. 1D	Procedure 1A → 1B → 1C → 1D	Removal of driving block.
		<ol style="list-style-type: none"> 1.Remove counter gear, transfer gear and internal gear. <p>NOTE : Check proper direction of internal gears when assembling.</p> <ol style="list-style-type: none"> 2.Remove driving shaft. <p>NOTE : Do not lose stick.</p> <ol style="list-style-type: none"> 3.Remove clutch key and coil spring. <p>NOTE : Check proper positioning and direction of clutch key and coil spring when assembling.</p> <ol style="list-style-type: none"> 4.Remove two screws of pinion cover. 5.Remove pinion cover, thrust plate and pinion gear. <p>NOTE : Confirm to set thrust plate between pinion cover and pinion gear when assembling. (It may cause abnormal sounds.)</p> 

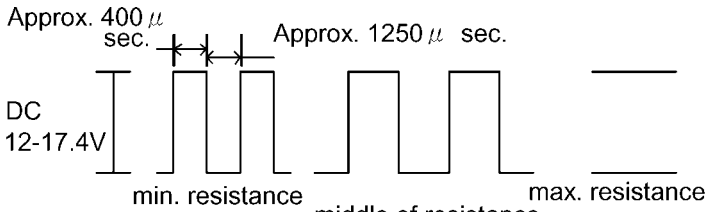
Ref. No. 1E	Procedure 1A → 1B → 1C → 1D → 1E	Removal of micro switch.
		<p>1.Remove one screw on switch frame. 2.Remove micro switches from driving holder.</p> <p>(Assembly of micro switch) There are two connecting methods for micro switch. The micro switches themselves are all same. For connection A, confirm position or deformation of switch lever. For connection B, take switch lever off.</p>

Ref. No. 1F	Procedure 1A → 1B → 1C → 1D → 1E → 1F	Removal of rack.
<p>Check this part goes along the rack. Bowling or extra space does not acceptable.</p> 		<p>1.Take out spring pin using $\varnothing 3\text{mm}$ stick. NOTE : When taking pinion gear out, rack may move freely. 2.Pull out rack forward.</p> <p><CHECK POINT> When rack does not move pushing release lever, there is a possibility to cause that the part of pinion breaks off or deformation of stick.</p>

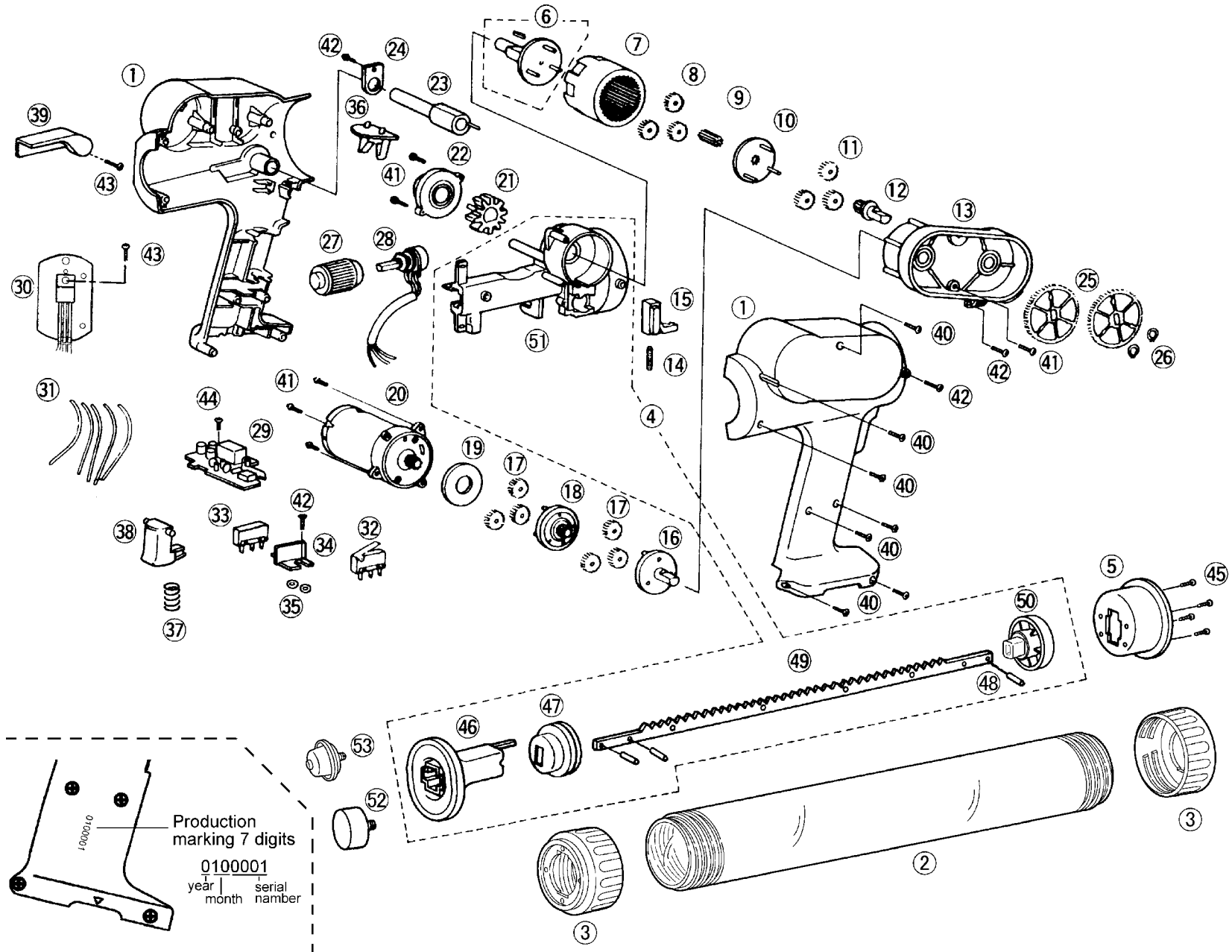
4 TROUBLE SHOOTING GUIDE

(Refer to WIRING CONNECTION DIAGRAM.)

■CHECK POINTS FOR ELECTRICAL PARTS.

< TROUBLE >	< CHECK >	< REMEDY >
Does not operate.	<p align="center"><CHECK BATTERY PACK.></p> <p>If no less than 7.2 V DC is available across the (+) and (-) terminals, the battery pack is OK.</p> <p>Note: The battery pack is sold separately as an optional accessory. See the nearest sales dealer for details. The battery pack has a limited life. The pack should be replaced if</p> <ul style="list-style-type: none"> - after being charged for the rated charging time the battery voltage is less than 7.2 V DC or the usable time is extremely short. - the battery leaks. Check battery for leaks and terminals for corrosion. 	NO → Replace battery pack.
	↓ OK	
	<p align="center"><CHECK TERMINAL CONNECTIONS BETWEEN MAIN UNIT AND BATTERY PACK.></p> <p>Check for proper terminal contacts.</p>	NO → Repair contacts.
	↓ OK	
	<p align="center"><CHECK MICRO SWITCH.></p> <p align="center">(See WIRING CONNECTION DIAGRAM.)</p> <p>1. When lever is slightly depressed; * There should be continuity between (1) and (3). * There is no continuity between (1) and (2) or (2) and (3).</p> <p>2. When lever is not depressed; * There should be continuity between (1) and (2). * There is no continuity between (1) and (3) or (2) and (3).</p>	NO → Replace micro switch.
Does not speedcontrol.	<p align="center"><CHECK VAROAB;ERESOSTAMCE.></p> <p>Disconnect white leae wire coming from variable resistance.</p> <ul style="list-style-type: none"> ● There should be $50 \pm 10k\Omega$ between (A) and (C). ● There should be $0 - 50 \pm 10k\Omega$ between (A) and (B). 	NO → Replace variable resistance.
	↓ OK	
	<p align="center"><CHECK MODULE.></p> <p>Disconnect blue lead wire coming from module, if it shows wave form as follows with (-) terminal and blue lead wire connected to 7.2V DC.</p> <div style="text-align: center;">  </div>	NO → Replace drivingshaft or cam A.
	↓ OK	
	<p align="center"><CHECK FET CIRCUIT BLOCK.></p> <p>Check lead wire terminals. Disconnect lead wire.</p>	NO → Replace FET circuit.
	↓ OK	
	<p align="center"><CHECK MOTOR.></p> <p>The motor normally operates with its white (+) and black (-) lead wires connected to 7.2 V DC. Ref.: motor rotating speed 13,700-18,000.</p>	NO → Replace motor.

5 EXPLODED VIEW



L

6 REPLACEMENT PARTS LIST

NOTE:

*A = available as an optional accessory

*B = only available as set

*C = available individually

Ref. No.	Part No.	Part Name & Description	Remarks	Per Unit
1	WEY3654K3078	HOUSING AB SET		1
2	WEY3654X3718	TUBE HOLDER		1
3	WEY3654H3228	HOLDER CAP	*C	2
4	WEY3654K1068	RACK BLOCK		1
5	WEY3653S3538	CONNECTOR CAP		1
6	WEY3653L1128	DRIVING SHAFT		1
7	WEY3650B1427	INTERNAL GEAR		1
8	WEY3653L1358	PLANET GEAR	*B (3PCS/PACK)	3
9	WEY3653L1368	GEAR		1
10	WEY3653L1108	CARRIER		1
11	WEY580S1457	COUNTER-GEAR	*B (3PCS/PACK)	3
12	WEY580S1527	DRIVING SHAFT B		1
13	WEY3650B1207	DRIVING HOLDER		1
14	WEY3650B0917	COIL SPRING A		1
15	WEY3650B1967	CLUTCH KEY		1
16	WEY580S0537	DRIVING SHAFT C		1
17	WEY3650B1457	COUNTER-GEAR A	*B (3PCS/PACK)	6
18	WEY580S1397	TRANSFER-GEAR B		1
19	WEY580S0847	THRUST PLATE		1
20	WEY3653L1008	MOTOR		1
21	WEY3653L1448	PINION GEAR		1
22	WEY3650B0587	PINION COVER		1
23	WEY3653H3568	RELEASE BUTTON		1
24	WEY3653L0208	CROSS-ARM BRACE		1
25	WEY580C1277	SPUR GEAR	*C	2
26	WEY580S0417	LOCK RING	*C	2
27	WEY3653H3288	APPLICATION SPEED CONTROL		1
28	WEY3653L2548	VARIABLE RESISTANCE		1
29	WEY3653L2128	MODULE		1
30	WEY3653L2108	FET		1
31	WEY3653L2948	LEAD WIRE SET	*B	6
32	WEY3652L2008	MICRO SWITCH A		1
33	WEY3652L2018	MICRO SWITCH B		1
34	WEY3650B0577	SWITCH FRAME		1
35	WEY3653L6438	WASHER	*C Ø3.0	2
36	WEY3790L2157	TERMINAL PLATE		1
37	WEY30070927	LOCK SPRING		1
38	WEY3653Y3208	SWITCH HANDLE		1
39	WEY3653H3238	RACK RELEASE LEVER		1
40	WEY508B9617	TAPPING SCREW (K3-20)	*C	7
41	WEY563B9217	TAPPING SCREW (K3-16)	*C	6
42	WEY3652K9378	TAPPING SCREW (K3.5-8)	*C	5
43	WEY561S9037	TAPPING SCREW (K3-12)	*C	2
44	WEY3652K9478	TAPPING SCREW (K3-6)		1
45	WEY3653L6248	TAPPING SCREW (K4-12)	*C	4
46	WEY3653H3538	RACK KNOB		1
47	WEY3653K3188	PROTECTIVE COVER		1
48	WEY3653K0598	SPRING PIN	*B (3PCS/PACK)	3
49	WEY3653S1348	RACK		1
50	WEY3654K0488	PISTON JOINT		1
51	WEY3653K1208	DRIVING HOLDER		1
52	WEY3654K7208	CARTRIDGE ADAPTOR		1
53	WEY3654K0498	SAUSAGE PACK ADAPTOR		1
-	WEY3654K8008	INDIVIDUAL BOX		1
-	WEY3654K8108	OPERATING INSTRUCTIONS		1

** Battery Pack is available as an optional accessory. See the nearest sales dealer for details.

*** For replacement parts of charger, see the charger service manual.

Charger complete set is available as an optional accessory. See the nearest sales dealer for details.