

# OPERATION, PARTS AND **SAFETY** MANUAL

 **SIGNODE®**

**TABLE-TYER**  
POWER STRAPPING MACHINES

**IMPORTANT!**  
**DO NOT DESTROY**

It is the customer's responsibility to  
have all operators and servicemen  
read and understand this manual.

Contact your local Signode representative  
for additional copies of this manual.

***READ ALL INSTRUCTIONS BEFORE OPERATING THIS SIGNODE PRODUCT***

# CONGRATULATIONS

Thank you for purchasing your Table-Tyer Strapping Machine. The Table-Tyer has been designed to be a reliable, maintenance free strapping machine. The innovative design of this machine allows for every maintenance part to be replaced easily and quickly with very little or no instruction.

Considerable effort has been made to ensure that this product conforms to our high quality standards. However, should you experience any difficulties, please contact your Signode Representative with your machine model and serial number.

Thank you for your help.

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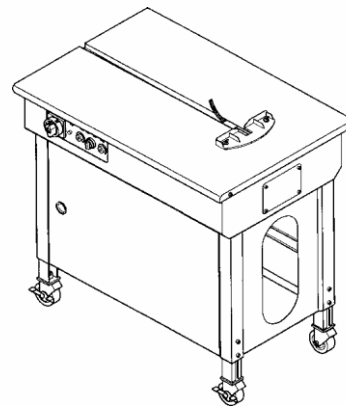


TABLE-TYER  
STRAPPING MACHINE  
PART NO. 500998

All conditions and options have been detailed in this manual to guide and alert operating and service personnel with respect to safety, operation and maintenance procedures. A complete parts listing, with exploded views, has been included in this manual in the event replacement parts must be ordered. Please review each section of this manual before operating your machine.

**PLEASE NOTE:** Most of the fasteners in this machine are metric. Before removing and replacing any part, refer to the parts listing to determine the proper tools to use and the correct size hardware that may have to be replaced.

# **SAFETY INSTRUCTIONS**

**WARNING - READ AND FOLLOW THESE INSTRUCTIONS - FAILURE TO DO THIS COULD RESULT IN SEVERE PERSONAL INJURY.**

## OPERATING INSTRUCTIONS

1. Only people trained in the use of strapping machines are to operate or service this machine.
2. Read all signs on machine. Do not remove, modify or deface any sign. Replace all damaged signs.
3. Inspect the machine for unsafe conditions - DAILY - and replace all worn or broken parts.
4. Keep work area uncluttered and well lit.
5. If you require safety instructions in another language, contact your local Signode representative.

## MAINTENANCE

1. Establish a preventive maintenance program for your machine by following the preventive maintenance program in this manual.
2. To ensure proper machine operation, use the specified power sources listed in this manual.
3. Do not overload the machine by exceeding the package size specification.
4. Remove all packages from the machine before performing service.
5. Unless otherwise noted in this manual, disconnect and lockout all power before servicing your machine.
6. Follow all maintenance and service instructions in this manual.

## MOVING MACHINE PARTS



1. Disconnect and lock out all power to Signode's machines before entering the strap chute area.
2. Never put any part of your body into the strap chute area or machine enclosure with machine power on.
3. Never stand on the machine table-top.

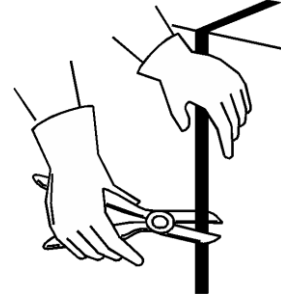
## MACHINE INSTALLATION

1. All customer interlocks must be connected as shown in this manual's electrical drawings. Failure to properly connect interlocks can result in improper machine operation and/or personal injury.
2. Be familiar with the locations of safety interlocks/guards and Emergency Stop Devices - refer to machine manual topic "Disconnect & Lockout Procedures".
3. Do not defeat any safety interlock or safety device. Do not operate machine with any safety devices/guards removed.
4. Before operating the machine, ensure that all safety interlocks and Emergency Stop buttons are operating properly.
5. Unauthorized modifications can present a safety hazard to machine personnel and will void the machine warranty.
6. Secure the machine in place using the locking casters.

## PERSONAL PROTECTION



1. To prevent back or other body injuries, your employer must provide proper lifting and/or handling instructions. Your employer may also contact the National Safety Council, Itasca, IL 60143-0558 for information on lifting techniques.
2. When removing tensioned strap from a package, proceed as follows:
  - a. Wear eye, face and hand protection
  - b. Before cutting strap, make sure all personnel are at a safe distance.
  - c. Hold the strap against the load above the cutter as shown.
  - d. Using the proper Signode strap cutter, cut strap as pictured.
  - e. Stand clear of unheld strap end which will spring out if under pressure.
3. Always wear steel reinforced safety shoes.
4. Always wear safety glasses with side shields which conform to ANSI Standard Z-87.1 or EN 166
5. Wear protective gloves when handling strap.



## ENVIRONMENTAL INFORMATION

The emissions produced during the heat sealing process may be an irritant to some people. Use this machine in areas that are externally ventilated. Should you be affected by these fumes, move away from machine to fresh air.

## LOCKOUT/TAGOUT



1. Follow OSHA 1910.147 (Lockout/Tagout Regulation) for machine lockout procedures and other important lockout/tagout guidelines.
2. Be familiar with all lockout sources on this machine, refer to the "Lockout & Tagout" section of this manual.
3. Even after a machine has been locked out, there may be stored energy in the system. To ensure that all stored energy is relieved, wait at least one minute before servicing electrical capacitors and wait 5 minutes for hot knife to cool.
4. Before performing service in the strap chute area, disconnect and lockout machine power.

## MOVING THE MACHINE

Wheel kits are standard for Signode general purpose machines. A forklift may be used to transport the machine from one location to another. Consult your employer for proper lifting and handling methods.

**TABLE-TYER, MACHINE SPECIFICATIONS**

**STRAP SIZES:** Signode Empax 1/4" (6mm), 3/8" (9mm), 1/2" (12mm)

**PACKAGE SIZE (Minimum):** 3 1/2" W x 1-1/2" H

**VOLTAGE SPECIFICATIONS:** Rated current: 3A  
Rated voltage: 110V  
Rated frequency: 60Hz  
Type of current: AC

**FAULT PROTECTION:** Fused

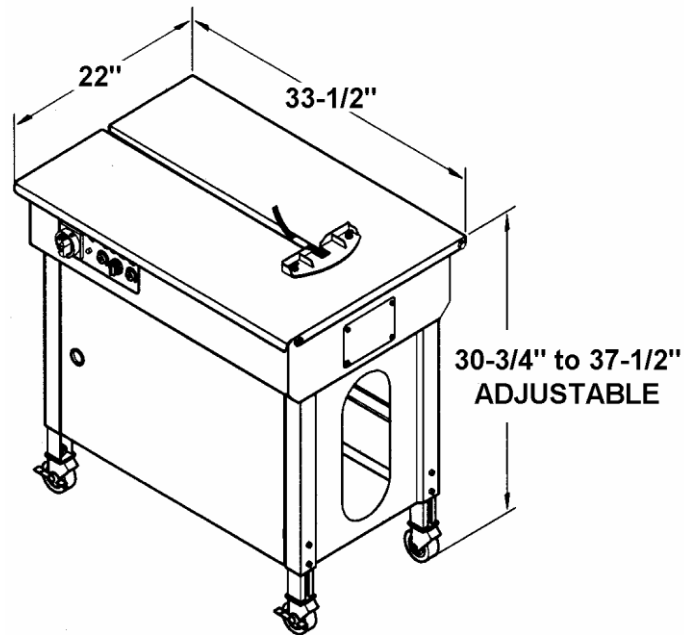
**SYSTEM DISCONNECT:** HP Rated switch

**OPERATING HEIGHT:** Minimum 30-3/4", Maximum 37-1/2"

**WEIGHT:** 168 lbs.

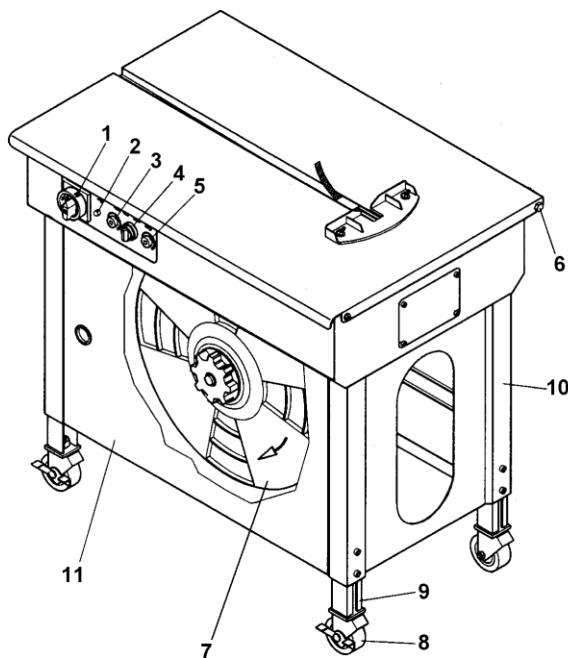
**NOISE EMISSIONS:** 55dB

**MACHINE DIMENSIONS:**



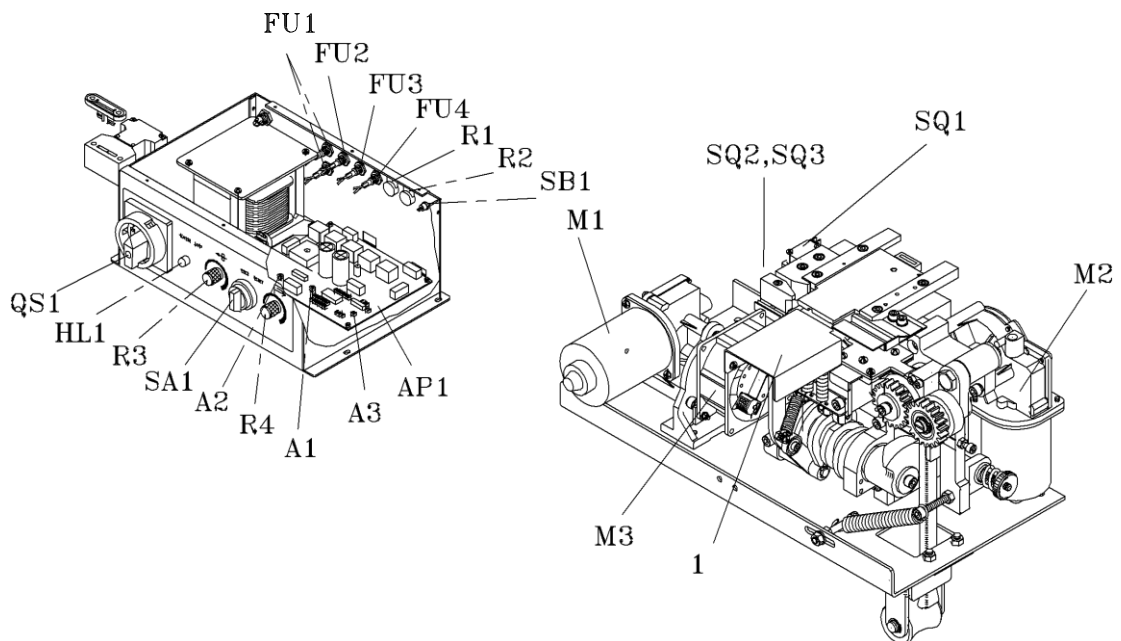
## MAJOR COMPONENTS - EXTERNAL

1. Main switch
2. Heater lamp, lamp will light on when proper sealing temperature is reached
3. Potentiometer, strap feed length
4. Button, strap feed and reset
5. Potentiometer, strap tension adjustment
6. Table top, hinge
7. Strap reel
8. Caster (2 locking)
9. Adjustable legs (Table-Tyer)
10. Frame
11. Access Door



## MAJOR COMPONENTS - INTERNAL

QS1	Main switch
HL1	Heater lamp
R3	Strap feed length
R4	Strap tension adjustment
SA1	Button, strap feed and reset
SQ1	Switch, start
SQ2	Switch, home position
SQ3	Switch, Sealing position
AP1	P.C.B. Unit control
FU1	Fuse 115V, 3A (For power)
FU2	Fuse 1A (For P.C.B.)
FU3	Fuse 1 OA (For Motor)
FU4	Fuse SA (For Heater)
R1	Weld Cooling Timer
R2	Heater Temperature adjustment
SB1	Jog Switch
A1	High Tension Knob
A2	Feed Length Knob
A3	Heater Temperature knob
M1	Motor 1, unit drive
M2	Motor 2, strap feed and reverse
M3	Fan
I	Heating unit



## MACHINE DISCONNECT AND LOCK-OUT PROCEDURES

This machine is equipped with shut off devices which satisfy OSHA Regulation 1910.147 (control of hazardous energy sources - lock out/tag out).

### **WARNING**

Become familiar with the location, and operation of each shutoff device.

Disconnect/Lock-Out all power sources before servicing machine.

Never use machine operating controls as a means for locking out power.

## ELECTRICAL

The machine is ready to operate when connected to the main power supply and the main switch QS 1 is switched to ON position. It takes approximately 1 minute for the heating element to reach its operating temperature.

The machine is switched on and off with the main switch QS 1 located on the machine front operating panel.

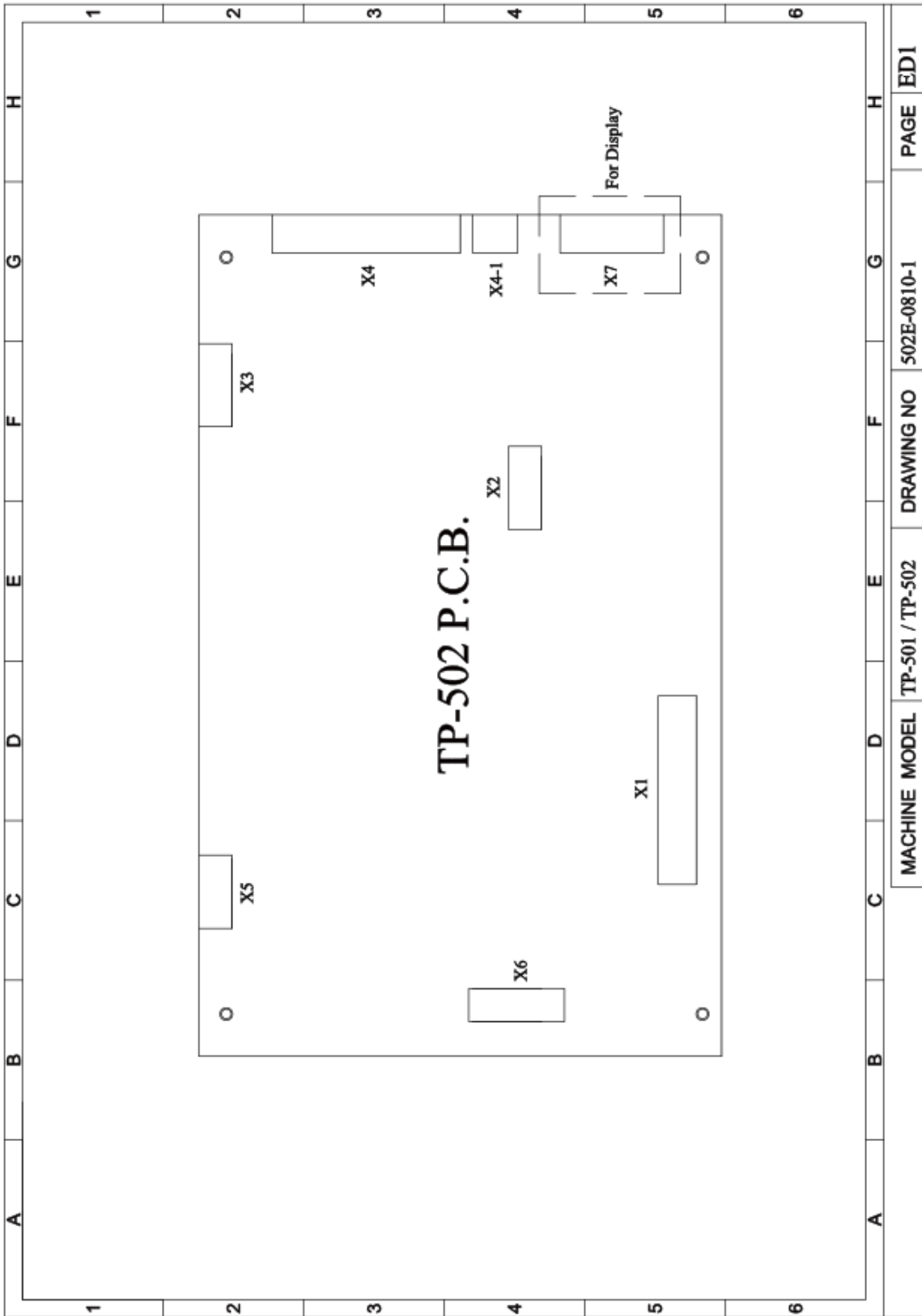
P Turn the main disconnect switch to the OFF position.

P Locate the appropriate locking hole on the switch, and apply a locking device.

**NOTE:** Some electrical components in the machine may be electrically charged after the power is shut off. Wait no less than one minute after the power has been disconnected before servicing the panel.



# ELECTRICAL SCHEMATIC, TABLE TYER



ED1

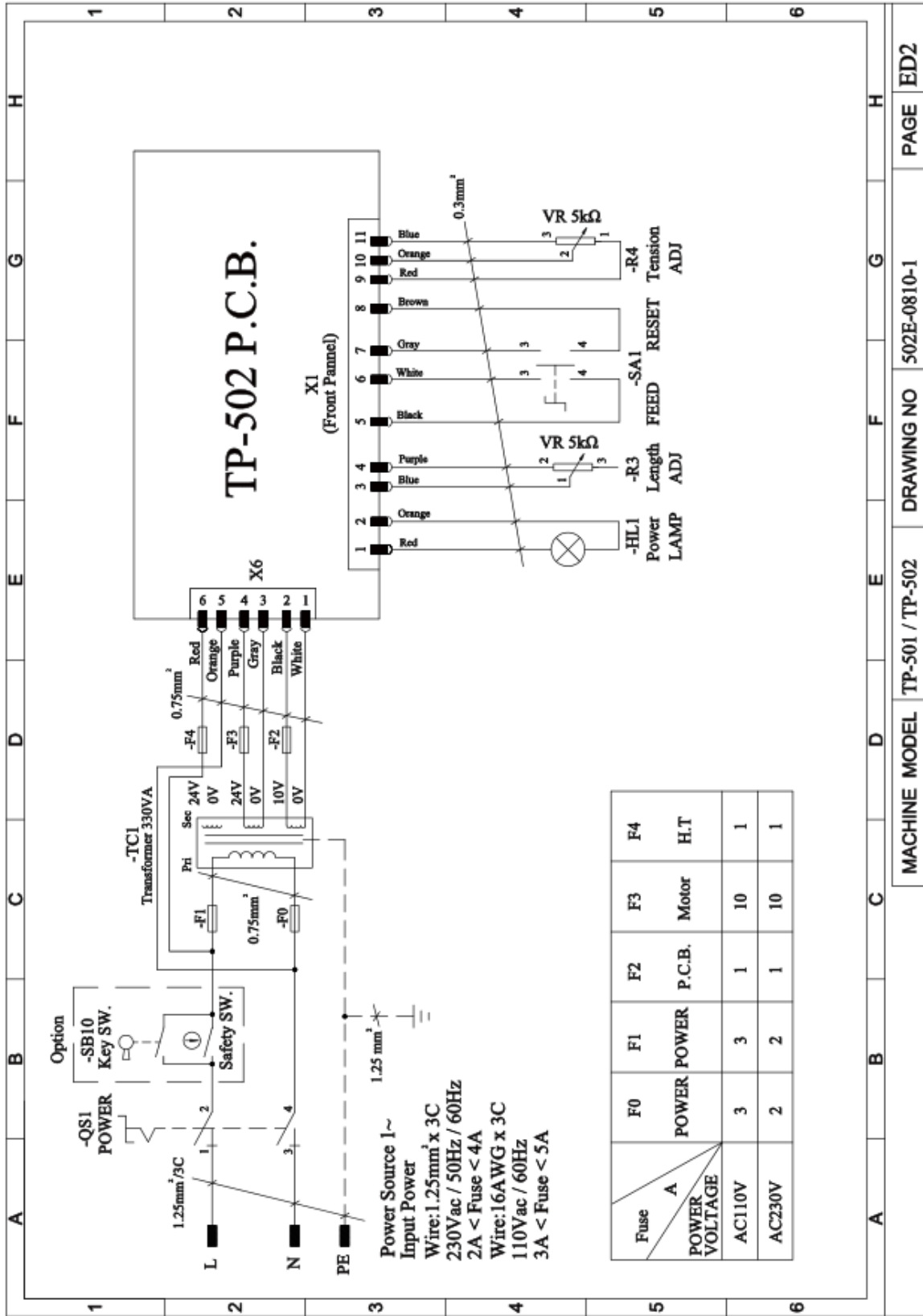
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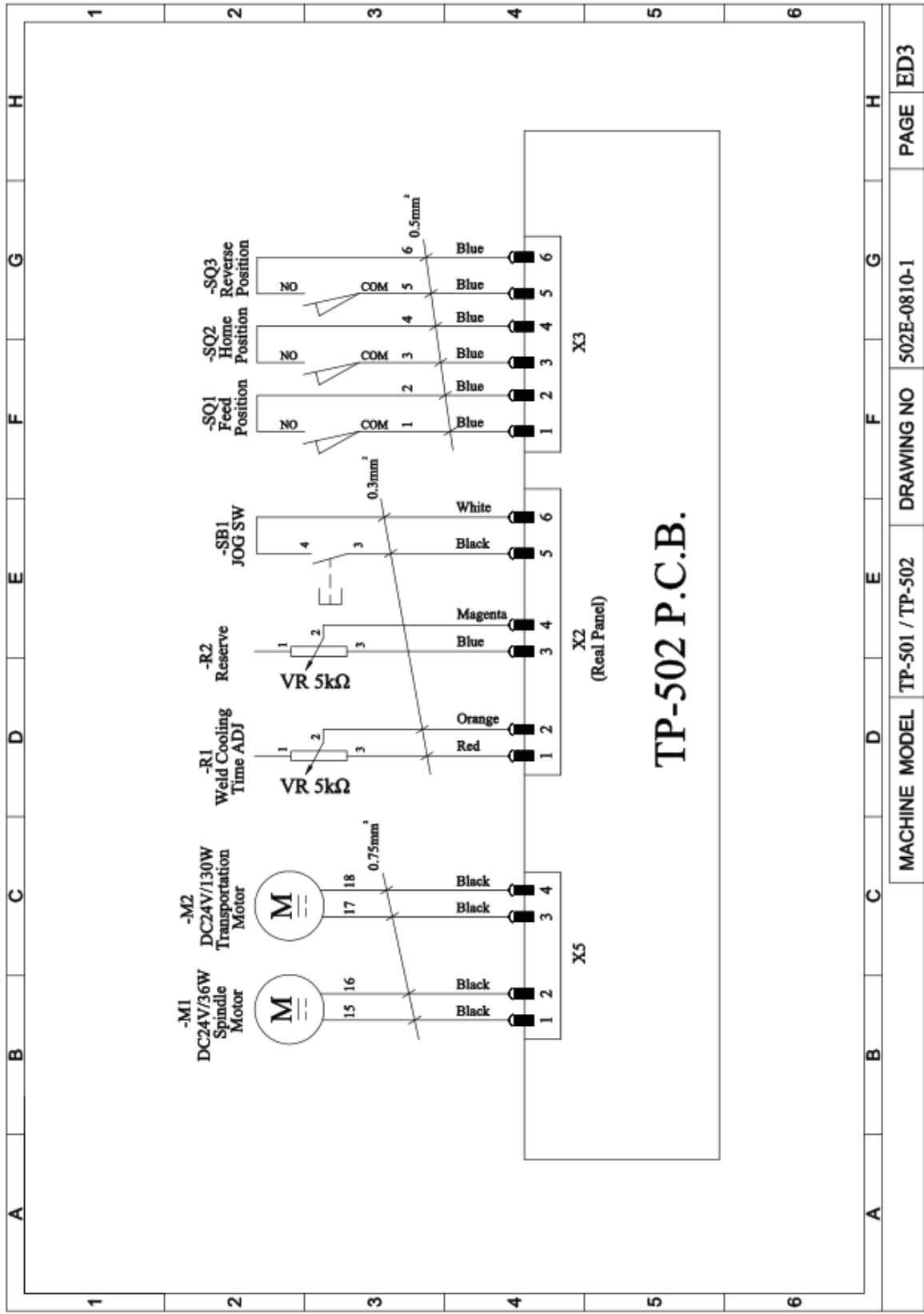
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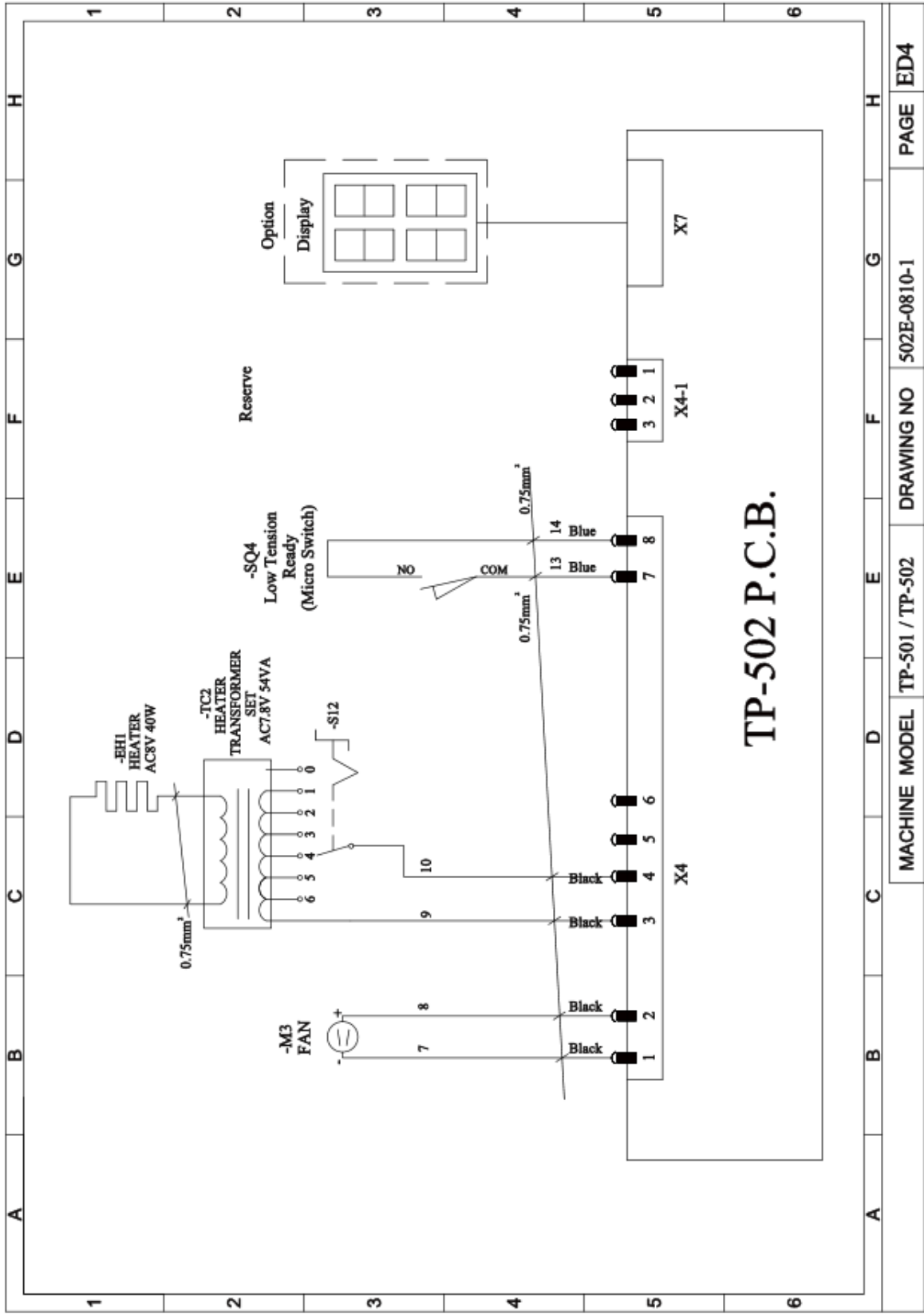
DRAWING NO

TP-501 / TP-502

MACHINE MODEL







**TP-502 P.C.B.**

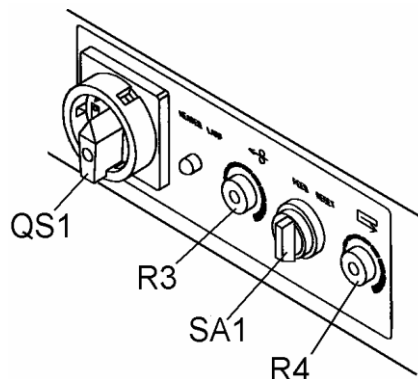
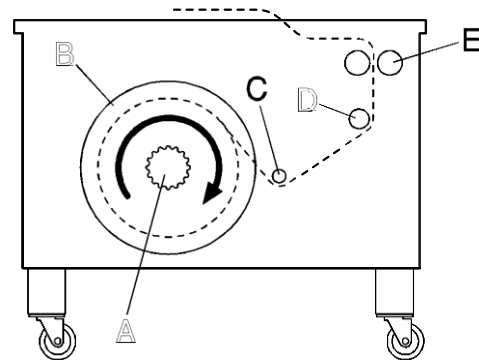
## MACHINE OPERATION

### START-UP AND OPERATING SEQUENCE

1. Put strap on the strap reel and thread the strap.
2. Turn main switch QS1 to ON. The heating element reaches the working temperature in approximately 1 minute.
3. Use potentiometer R3 to adjust the strap length.
4. Place the strap around the package to be strapped and insert the strap into the strapping head until it stops.
5. The strapping and welding sequence should complete.
6. At end of strapping sequence the strap end is fed automatically.
7. R4 adjusts the strap tension.

### THREADING STRAP

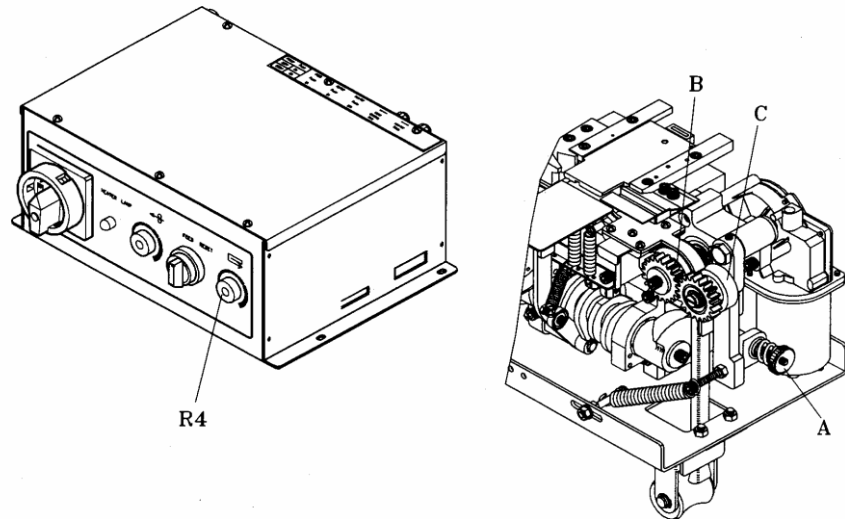
1. Turn reel nut handle (A) left and remove it.
2. Remove the cover of the reel (B) and install the strap reel.
3. Make sure that the payoff rotation matches directional arrows when unrolling.
4. Put the reel cover back on and tighten reel nut handle (A) to the right.
5. Remove all adhesive strips or other adhesive material.
6. Unroll about 1.5 m strap and make sure that it is not twisted.
7. Thread the strap in direction of arrow over (C) to roller (D). Continue to thread strap into rollers (E).
8. Turn left button SA1 (strap feed) until the length you need.



## STRAP TENSION

If R4 (strap tension adjustment) is on MAX position make sure that A is turned clockwise until the strap is not sliding between rollers B and C.

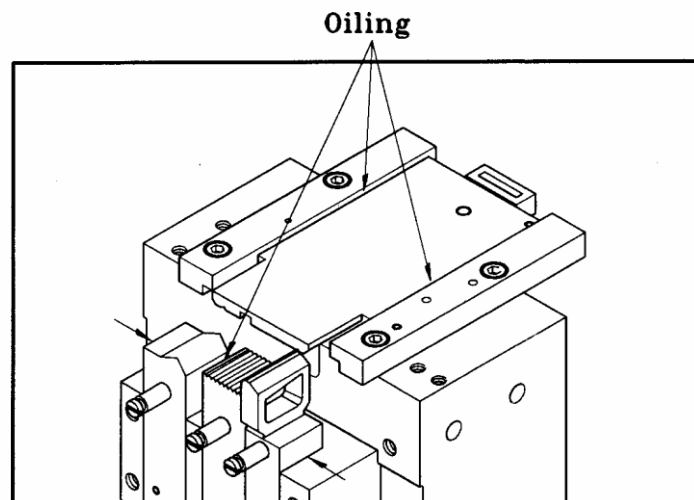
Reverse action to achieve lower strap tension.



## MAINTENANCE AND LUBRICATION

To ensure that the semi-automatic strapping machine is always ready for proper and reliable operation keep to regular and attentive maintenance. Keep the machine clean and take care particularly of the strap guides. All small particles of loose strap should always be removed from all parts of the machine. In addition to the strap guides, the strap feed devices of the unit, the top of the dies and the feed devices on the strap magazine have to be blown free of any dust at least once per week. The dies on the unit have to be lightly lubricated weekly.

Lubricate the marked points weekly. Use only resin-free brand name oil for lubrication. All other assemblies are maintenance free. The strap guides and the sealing unit have to be kept clean! Do not oil feedrollers.



**PARTS LISTS & EXPLODED VIEW**

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**CONTROL UNIT ASSEMBLIES**

<b>Key</b>	<b>Description</b>
1	Control Head Group Heater
2	Feed Group
3	Transmission Group

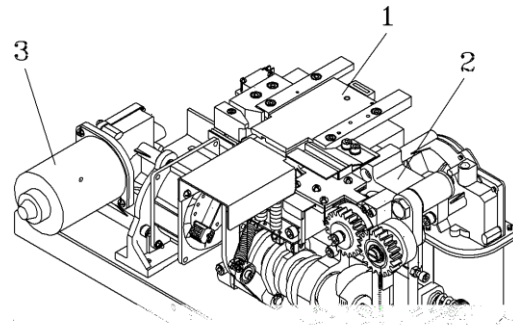


Table-Tyer Strapping Head

## CONTROL HEAD GROUP ASSEMBLY

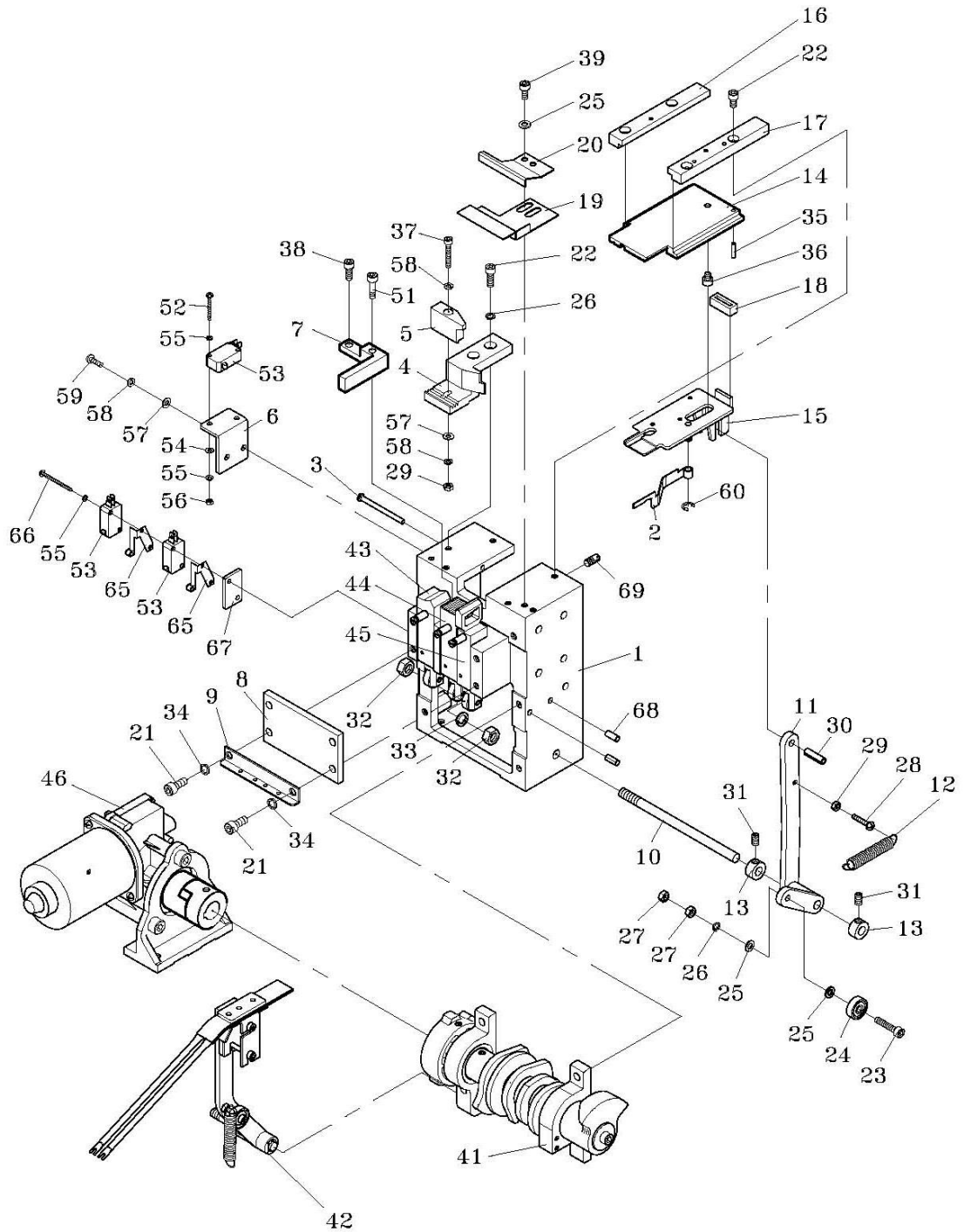
KEY	QTY	PART NO.	DESCRIPTION
1	1	500475	Main Body Block
2	1	500476	Switch Lever
3	1	500477	Switch Pin
4	1	500478	Strap Guide (A)
5	1	500479	Strap Guide (B)
6	1	500480	Switch Bracket
7	1	500481	Cutter Holder
8	1	500482	Bar Guide Lid
9	1	500483	Spring Hook
10	1	500484	Shaft
11	1	500485	Arm
12	1	500486	Return Spring
13	2	500487	Collar
14	1	500488	Slide
15	1	500489	Separator
16	1	500490	Guide (L)
17	1	500491	Guide (R)
18	1	500492	Gum
19	1	500493	Front Plate
20	1	500494	Guide Front
21	4	500495	HBS, M6x16
22	4	500496	HBS, M5x12
23	1	500497	HBS, M5x25
24	1	500498	Bearing 635ZZ
25	4	500499	PW,M5
26	1	500500	SW,M5
27	2	500501	HN, M5
28	1	500502	PMS, M4x20
29	1	500503	HN,M4
30	1	500504	Spring Pin, 6x20
31	2	500505	HSS, M6x6
32	2	500506	HN,M8
33	1	500507	SW,M8
34	4	500508	SW,M6
35	3	500509	Spring Pin, 3x12
36	1	500510	HBS, M5x5
37	1	500511	HBS, M4x25
38	3	500512	HBS, M5x16
39	2	500513	HBS, M5x8
41	1	500514	Cam Group
42	1	430733	Assy
43	1	500516	Rear Bar Assy
44	1	500517	Press Bar Assy
45	1	500518	Front Bar Assy
46	1	500519	Transmission Group
51	1	500520	HBS,M5
52	2	500521	PMS, M3x20
53	3	500522	Micro Switch
54	2	500523	PW, M3
55	4	500524	SW, M3
56	2	500525	HN, M3
57	2	500526	PW, M4
58	2	500527	SW, M4
59	2	500528	PMS, M4x12
60	1	500529	Snap Ring E3


**WARNING**

Inspect all parts dally and replace them if they are worn or broken. Failure to do this can affect a product's operation and could result in serlous personal injury.

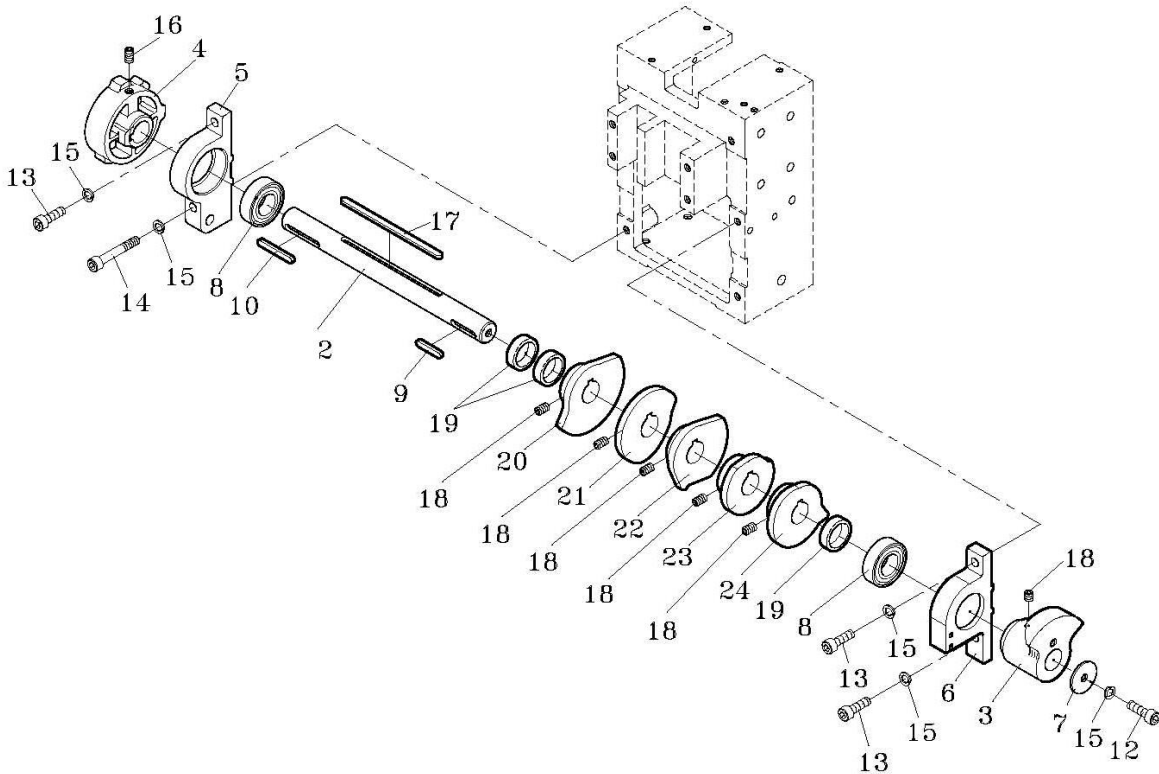


KEY	QTY	PART NO.	DESCRIPTION
65	2	500534	Switch Trigger
66	2	500535	PMS, M3x35
67	1	500536	Plate
68	2	500537	Spring Pin, 5x12



CAM ASSEMBLIES

KEY	QTY	PART NO.	DESCRIPTION
2	1	500543	Cam Shaft
3	1	500544	Tension Cam
4	1	500545	Limit Switch Contactor
5	1	500546	Bearing Support (L)
6	1	500547	Bearing Support (R)
7	1	500548	Washer
8	2	500549	Ball Bearing, 6003ZZ
9	1	500550	Key, 5x5x20
10	1	500551	Key, 5x5x35
11	5	500505	HBS, M6x6
12	1	500495	HBS, M6x16
13	3	500552	HBS, M6x20
14	1	500553	HBS, M6x45
15	5	500508	SW, M6
16	1	500899	HSS, M6x10
17	1	500898	Key, 5x5x101
18	5	500897	HSS, M6x8
19	3	500896	Spacer
20	1	500895	Grip Cam
21	1	500894	Grip Cam
22	1	500893	Grip Cam
23	1	500892	Grip Cam </td
24	1	500891	Cam Separator
	1		Cam

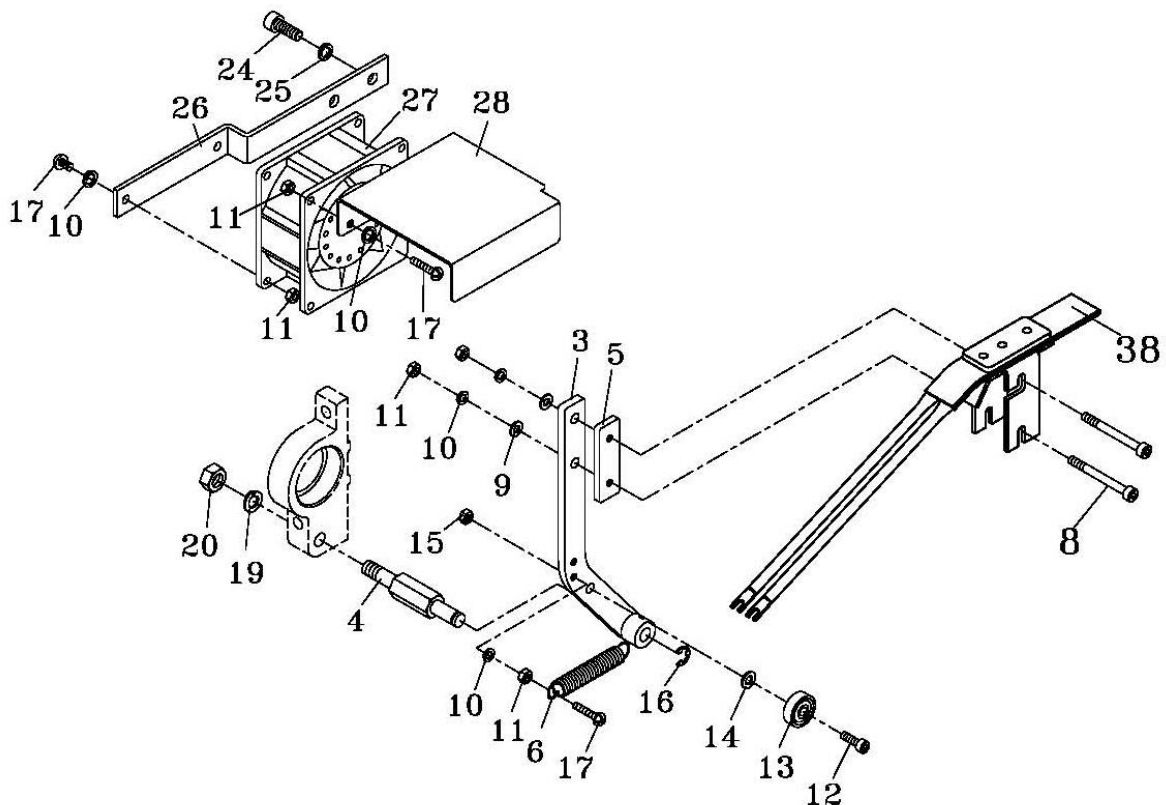


## HEATER ASSEMBLY

KEY	QTY	PART NO.	DESCRIPTION
3	1	500556	Heater Arm
4	1	500557	Pin
5	1	500558	Side Plate
6	1	500559	Return Spring
8	2	500561	HBS, M4x40 (SUS)
9	2	500526	PW, M4
10	7	500527	SW, M4
11	7	500503	HN, M4
12	1	500512	HBS, M5x16
13	1	500562	Bearing, 635ZZ
14	1	500499	PW, M5
15	1	500563	HN, M5
16	1	500564	Snap Ring E6
17	5	500528	PMS, M4x12
19	1	500566	PW, M8
20	1	500506	HN, M8
24	2	500495	HBS, M6x16
25	2	500508	SW, M6
26	1	500570	Fan Support
27	1	500571	Fan
28	1	430703	Fan Cover
38	1	430189	Heater Ass'y

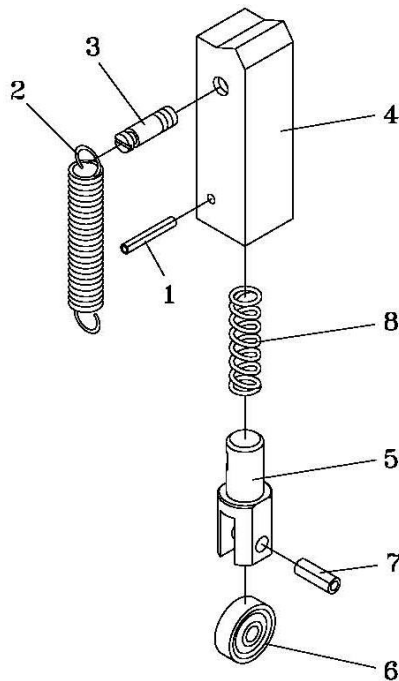

**WARNING**

Inspect all parts daily and replace them if they are worn or broken. Failure to do this can affect a product's operation and could result in serious personal injury.



**REAR BAR ASSEMBLY**

KEY	QTY	PART NO.	DESCRIPTION
1	1	500575	Spring Pin, 3x18
2	1	500576	Return Spring
3	1	500577	Spring Hook
4	1	500578	Rear Bar
5	1	430129	Plunger
6	1	500579	Bearing, 635ZZ
7	1	500580	Spring Pin, 5x14
8	1	500581	Spring

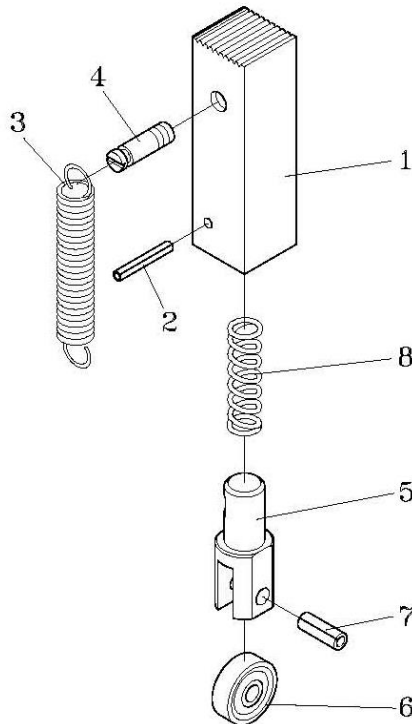


## **⚠ WARNING**

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**PRESS BAR ASSEMBLY**

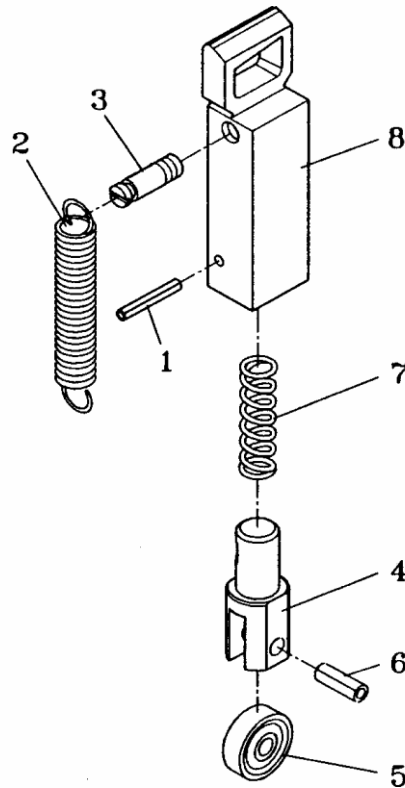
KEY	QTY	PART NO.	DESCRIPTION
1	1	500584	Press Bar
2	1	500575	Spring Pin, 3x18
3	1	500576	Return Spring
4	1	500577	Spring Hook
5	1	430129	Plunger
6	1	500579	Bearing, 635ZZ
7	1	500580	Spring Pin, 5x14
8	1	500581	Spring

**! WARNING**

Inspect all parts daily and replace them if they are worn or broken. Failure to do this can affect a product's operation and could result in serious personal injury.

## FRONT BAR ASSEMBLY

KEY	QTY	PART NO.	DESCRIPTION
1	1	500575	Spring Pin, 3x18
2	1	500576	Return Spring
3	1	500577	Spring Hook
4	1	430129	Plunger
5	1	500579	Bearing, 635ZZ
6	1	500580	Spring Pin, 5x14
7	1	500581	Spring
8	1	500587	Front Bar



## **⚠ WARNING**

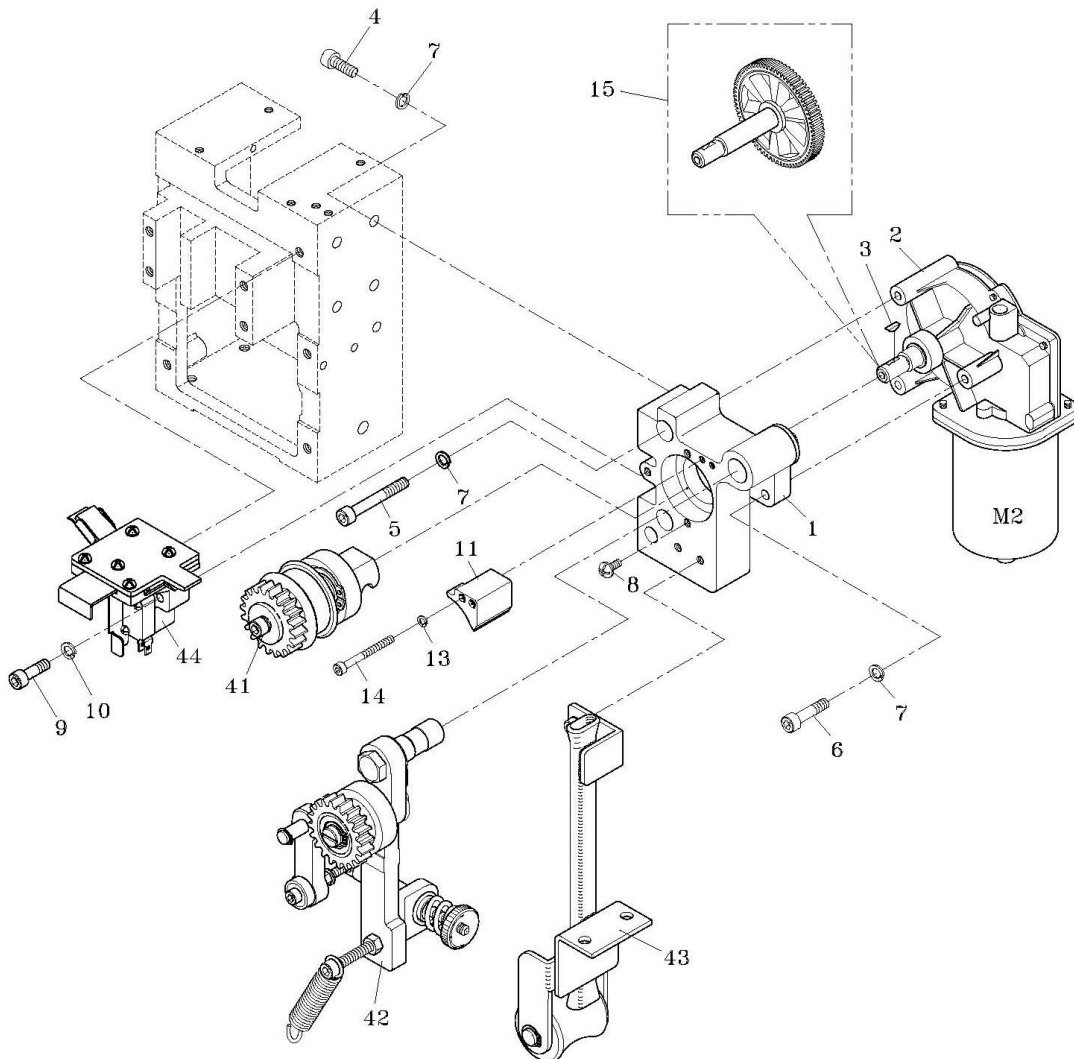
Inspect all parts daily and replace them if they are worn or broken. Failure to do this can affect a product's operation and could result in serious personal injury.

**FEED ASSEMBLY**

KEY	QTY	PART NO.	DESCRIPTION
1	1	500588	Bracket
2	1	500589	Motor Assy (M2)
3	1	500590	Key, 3x10
4	3	500552	HBS, M6x20
5	2	500591	HBS, M6x50
6	1	500592	HBS, M6x35
7	6	500508	SW, M6
8	2	500593	TMS, M5x10
9	2	500594	HBS, M5x25
10	2	500500	SW, M5
41	1	500595	Main Roller Assy
42	1	500596	Roller Arm Assy
43	1	500597	Feed Shooter Assy
44	1	430704	Strap Guide Assy
45	1	500889	Plastic drive gear w/ shaft (only)

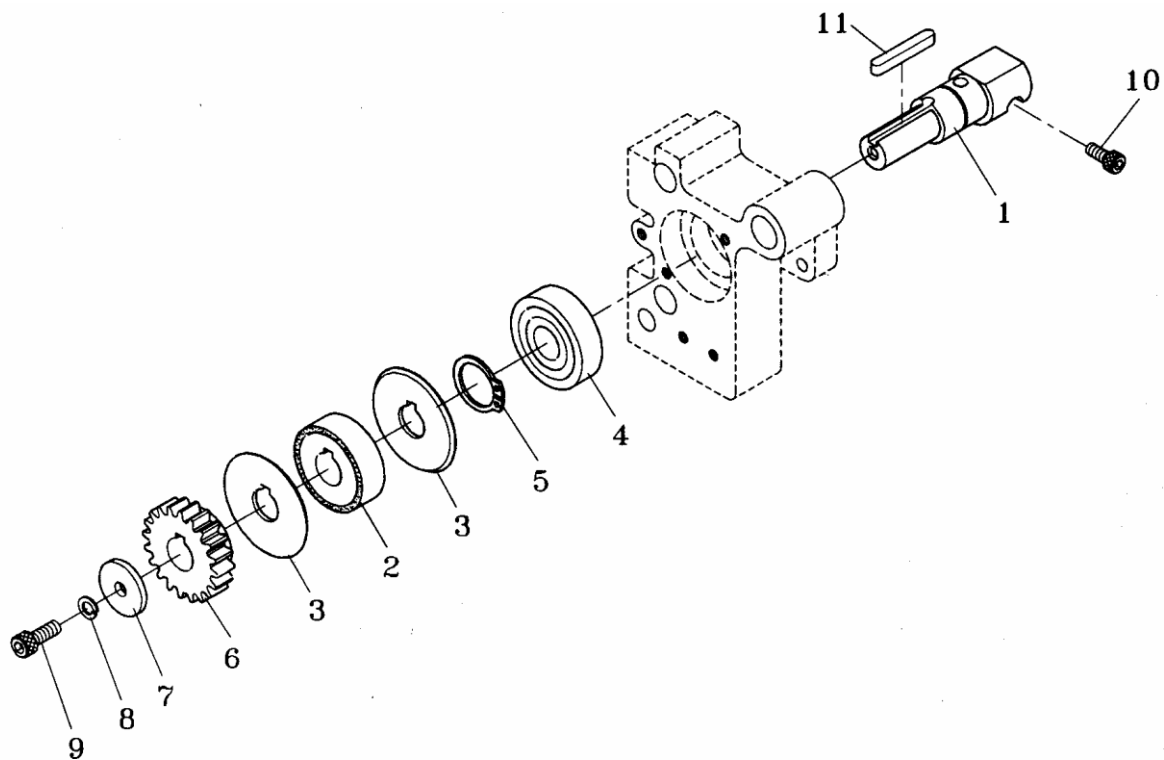
**⚠ WARNING**

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**MAIN ROLLER ASSEMBLY**

KEY	QTY	PART NO.	DESCRIPTION
1	1	500599	Main Roller Shaft
2	1	500600	Main Roller
3	2	500601	Side Plate
4	1	500602	Bearing, 6004ZZ
5	1	500603	Stop Ring, S-20
6	1	500604	Gear
7	1	500605	Washer
8	1	500508	SW, M6
9	1	500495	HBS, M6x16
10	1	500496	HBS, M5x12
11	1	500606	Key 5x5x35

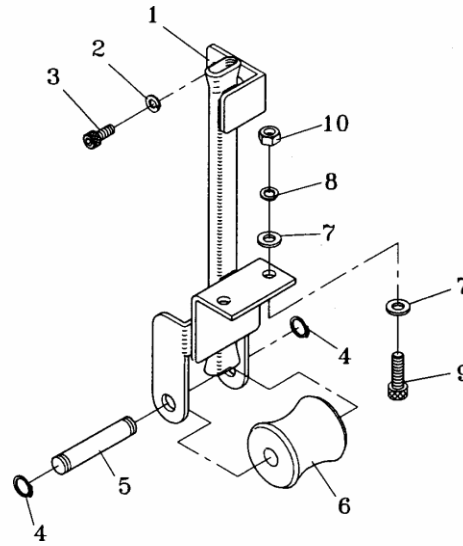
**! WARNING**

Inspect all parts daily and replace them if they are worn or broken. Failure to do this can affect a product's operation and could result in serious personal injury.



**FEED SHOOTER ASSEMBLY**

KEY	QTY	PART NO.	DESCRIPTION
1	1	500628	Feed Shooter
2	2	500500	SW,M5
3	2	500512	HBS, M5x16
4	2	500629	Ring, S10
5	1	500630	Shaft
6	1	500631	Roller
7	4	500632	PW,M6
8	2	500508	SW,M6
9	2	500495	HBS, M6x16
10	2	500633	HN,M6

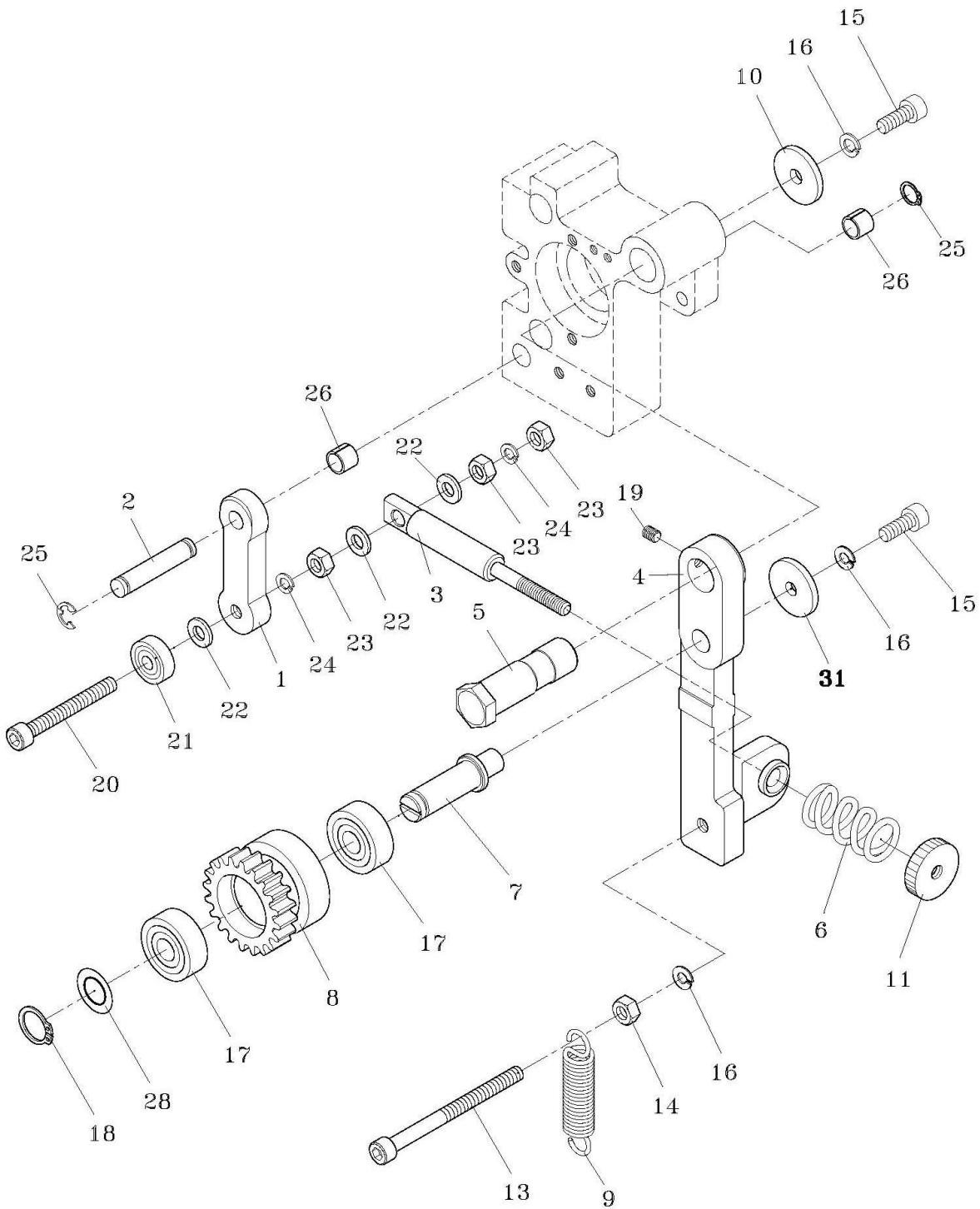


## ROLLER ARM ASSEMBLY

KEY	QTY	PART NO.	DESCRIPTION
1	1	500607	Tension Arm
2	1	500508	Shaft
3	1	500609	Connect Rod
4	1	500610	Roller Arm
5	1	500611	Shaft
6	1	500612	Spring
7	1	500613	Roller Shaft
8	1	500614	Roller
9	1	430705	Feed Spring
10	1	500616	Washer
11	1	500617	Nut
13	1	500619	HBS, M6x75
14	1	500620	HN, M6
15	2	500495	HBS, M6x16
16	3	500508	SW, M6
17	2	500621	Bearing, 6001ZZ
18	1	500622	Snap Ring S12
19	1	500505	HSS, M5x5
20	1	500623	HBS, M5x40
21	1	500624	Bearing, 635ZZ
22	3	500499	PW, M5
23	4	500563	HN, M5
24	2	500500	SW, M5
25	2	500625	Snap Ring E6
26	2	500626	Bushing
27	1	500627	HBS, M5x30
28	1	430718	Spacer
31	1	430719	PW, M6 (C)

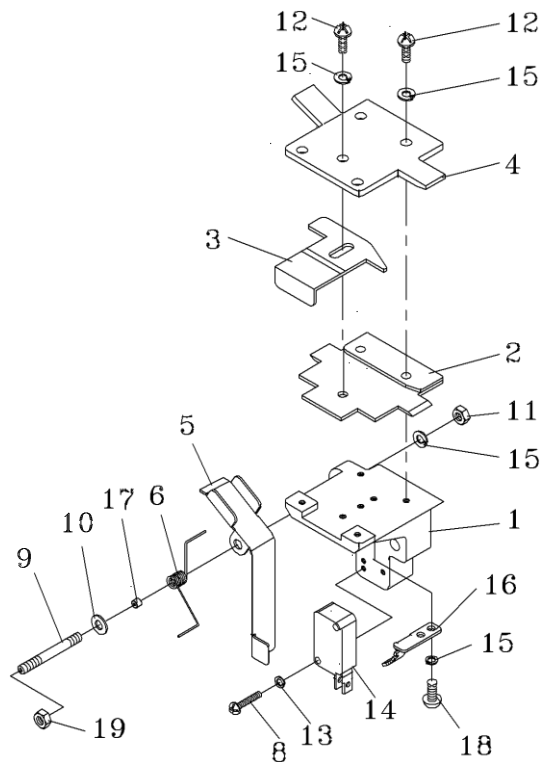
### **WARNING**

Inspect all parts daily and replace them if they are worn or broken. Failure to do this can affect a product's operation and could result in serious personal injury.



## STRAP GUIDE ASSEMBLY

KEY	QTY	PART NO.	DESCRIPTION
1	1	500634	Strap Guide Support
2	1	500635	Strap Guide (A)
3	1	500636	Strap Guide (B)
4	1	500637	Strap Guide Cover
5	1	500638	Strap Guide (C)
6	1	500639	Spring
8	2	500641	PMS, M3x15
9	1	500642	HBS, M4x40
10	1	500526	PW, M4
11	1	500503	HN, M4
12	5	500528	PMS, M4x12
13	2	500524	SW, M3
14	1	500643	Micro Switch
15	5	500527	SW, M4
16	1	430720	Stop
17	1	430721	Insert
18	2	430722	Screw
19	1	430723	Nut

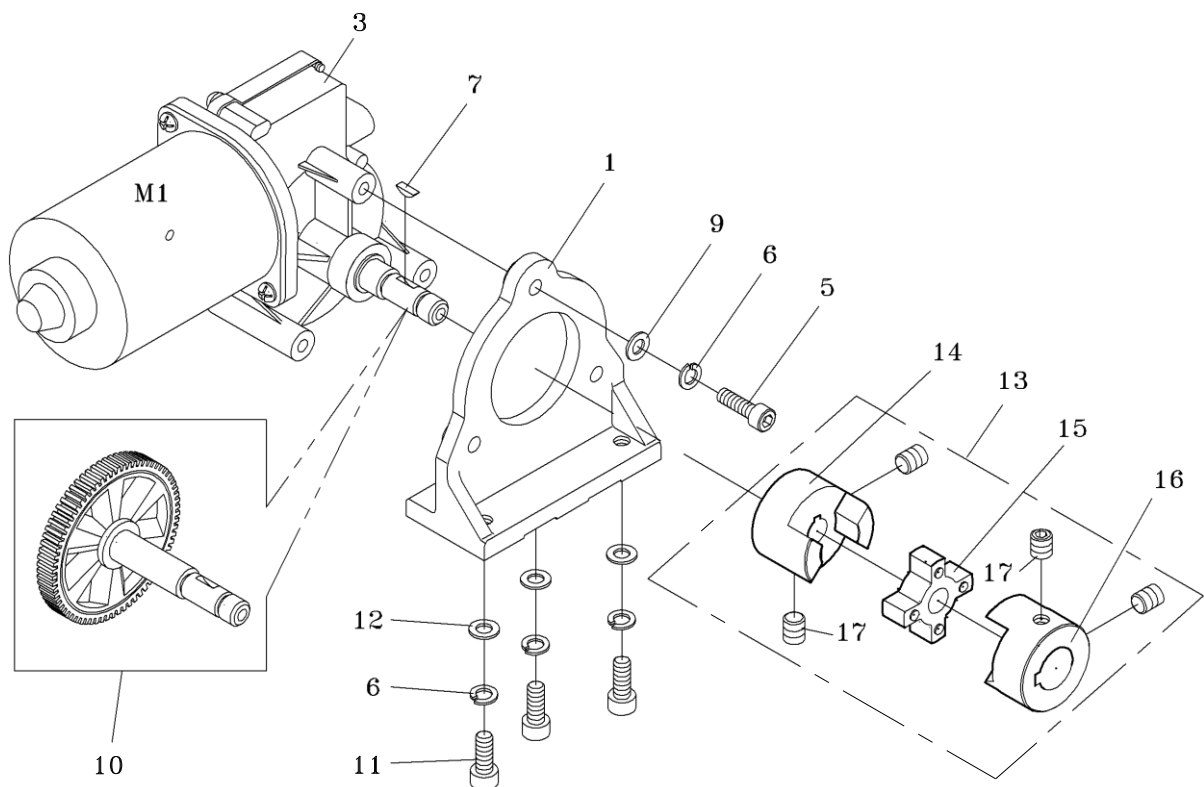


## WARNING

Inspect all parts daily and replace them if they are worn or broken. Failure to do this can affect a product's operation and could result in serious personal injury.

## TRANSMISSION ASSEMBLY

KEY	QTY	PART NO.	DESCRIPTION
1	1	500644	Main Motor Support
2	1	500645	Shaft Coupling
3	1	500646	Main Motor Assy (M1)
4	4	500512	HBS, M5x16
5	3	500647	HBS, M6x25
6	6	500508	SW, M6
7	1	500648	Key, 3x10
8	4	500500	SW, M5
9	3	500649	PW, M6 (A)
10	1	500890	Plastic drive gear w/ shaft
11	3	430557	HBS, M6x16
12	3	430558	PW, M6 (C)
13	1	430559	Flexible Coupling
14	1	430560	Hub (L.H.)
15	1	430561	Flexible Spacer
16	1	430562	Hub (R.H.)
17	4	430563	HSS, M6x8

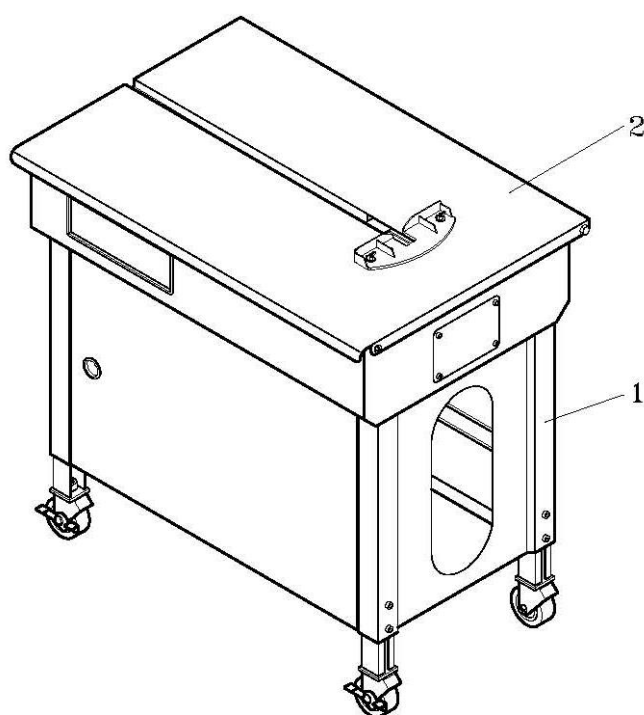


**⚠ WARNING**

Inspect all parts daily and replace them if they are worn or broken. Failure to do this can affect a product's operation and could result in serious personal injury.

**FRAME ASSEMBLY**

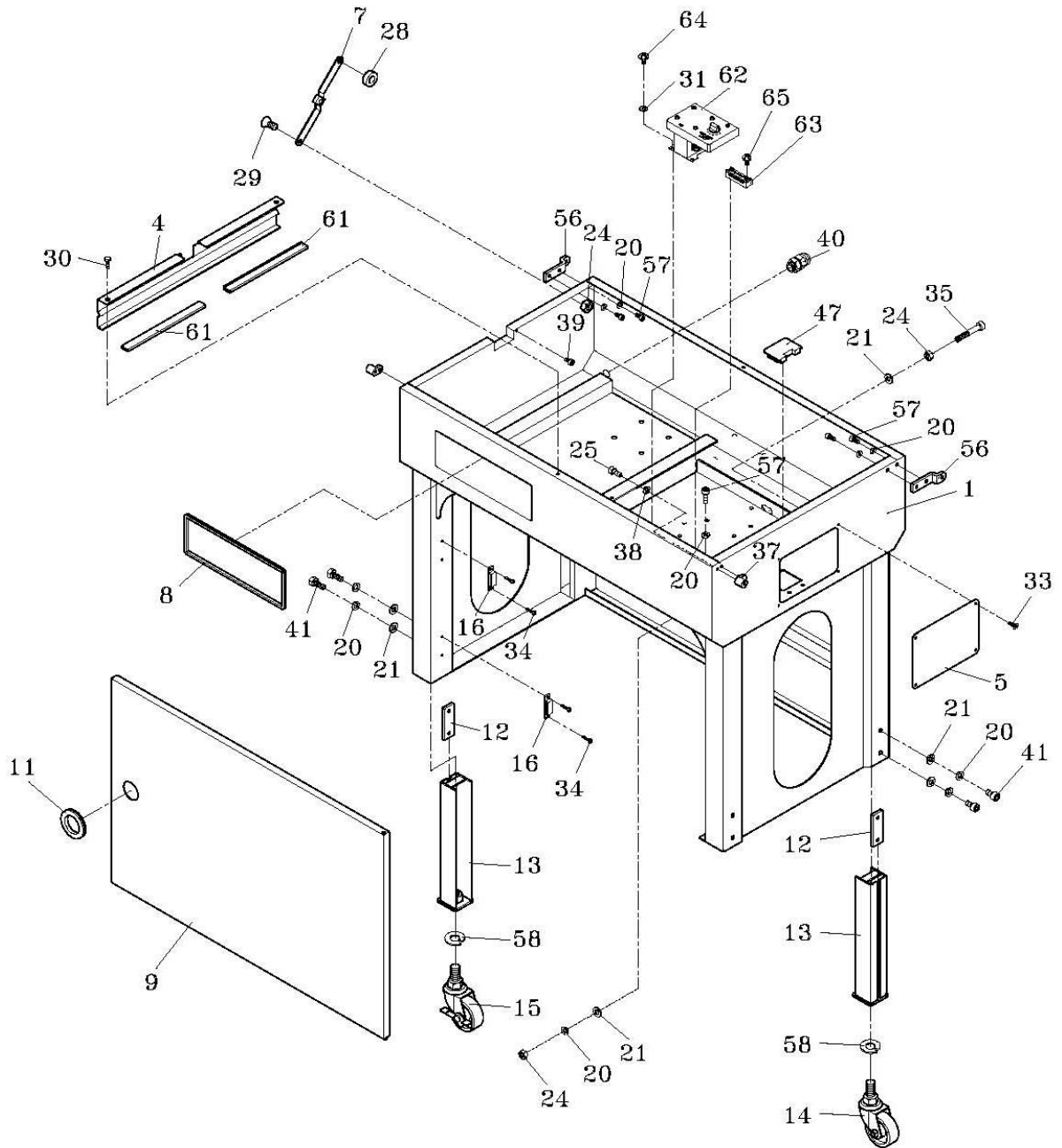
KEY	QTY	PART NO.	DESCRIPTION
1	1	500650	Base assembly
2	1	500651	Top plate assembly
3	1	500762	Operation, Parts & Safety Manual (not shown)

**⚠ WARNING**

Inspect all parts daily and replace them if they are worn or broken. Failure to do this can affect a product's operation and could result in serious personal injury.

## BASE ASSEMBLY

KEY	QTY	PART NO.	DESCRIPTION
1	1	500652	Frame
4	1	500656	Support
5	1	500657	Side cover
7	1	500658	Hinge
8	1	500659	Grommet
9	1	500660	Front Door
11	1	500662	Grommet
12	4	500663	Fix Plate
13	4	430706	Adjustable Leg
14	2	500665	Caster (Free)
15	2	500666	Caster (Brake)
16	2	500667	Magnet Catch
20	14	500508	SW, M6
21	10	500649	PW, M6
24	3	500633	HN, M6
25	4	500496	HBS, M5x12
28	1	500668	Collar
29	1	500669	FMS, M6x8
30	2	500670	FMS, M4x8
31	4	500527	SW, M4
32	2	500503	HN, M4
33	4	500671	TMS, M4x8
34	4	500672	TMS, M3x8
35	1	430726	HBS, M6x35
37	2	500674	Collar
38	8	500500	SW, M5
39	1	500675	HBS, M4x8
40	1	500676	Grommet
41	8	500495	HBS, M6x16
47	1	500682	Grommet
51	8	500499	PW, M5
56	2	500683	Top Plate Holder
57	4	500684	HBS, M6x12
58	4	430724	SW, M16
61	2	430725	Cushion
62	1	430484	Heater Transformer Ass'y (110V)
63	1	430518	Terminal Bracket
64	4	430340	TMS, M4x6
65	2	430100	PMS, M4x8



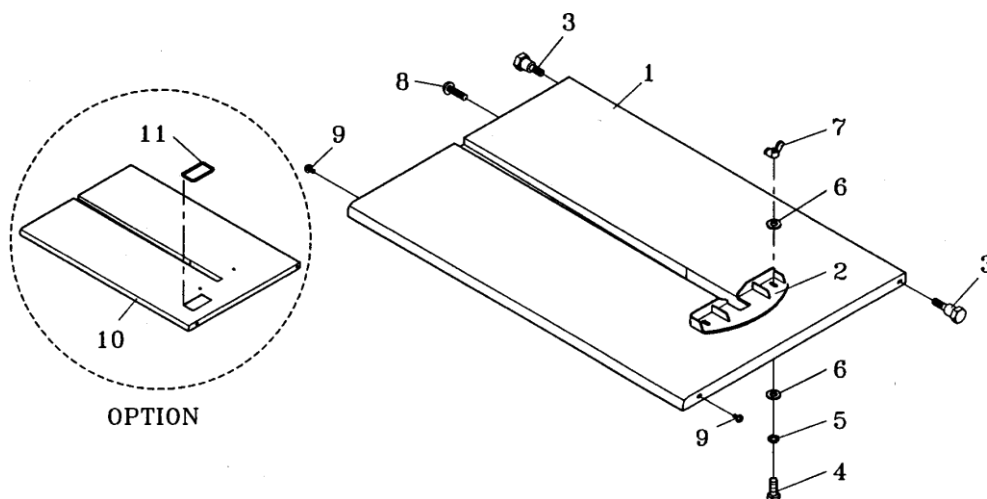
## **⚠ WARNING**

Inspect all parts daily and replace them if they are worn or broken. Failure to do this can affect a product's operation and could result in serious personal injury.



## TOP PLATE ASSEMBLY

KEY	QTY	PART NO.	DESCRIPTION
2	1	500686	Package Guide
3	2	500687	Shaft
4	2	500688	HBS M6x12
5	2	500508	SW,M6
6	4	500649	PW,M6
7	2	500689	WN, M6
8	1	500690	TMS, M6x8
9	2	500691	TMS, M5x8
10	1	500692	Top Plate (OPTION For with Readout)
11	1	500693	Grommet (OPTION For with Readout)

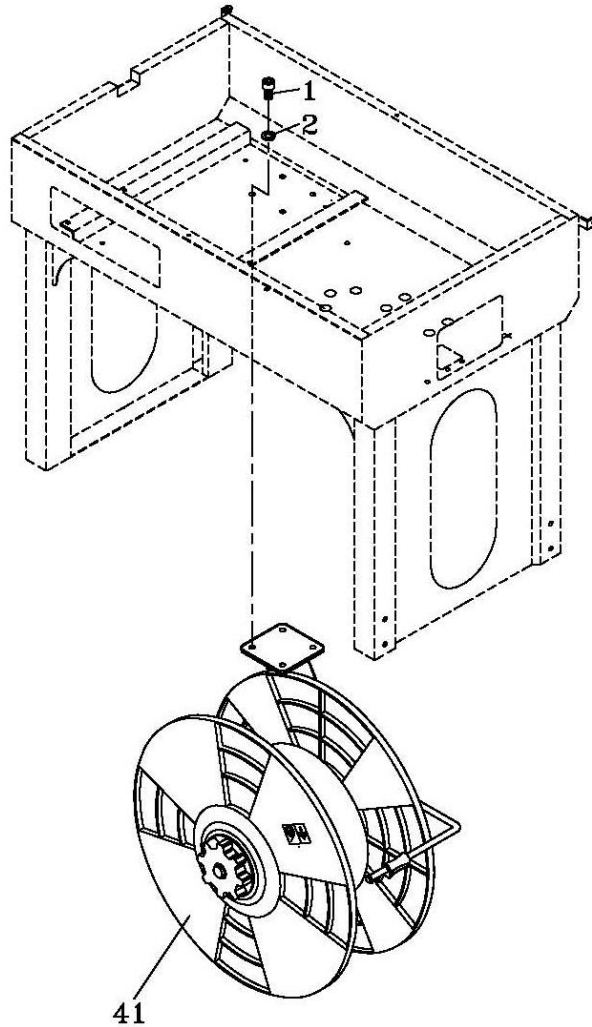


## **⚠ WARNING**

Inspect all parts dally and replace them if they are worn or broken. Failure to do this can affect a product's operation and could result in serlous personal injury.

**REEL UNIT ASSEMBLY**

KEY	QTY	PART NO.	DESCRIPTION
1	4	500694	HBS, M8x16
2	4	500507	SW, M8
41	1	500695	Reel Control Group



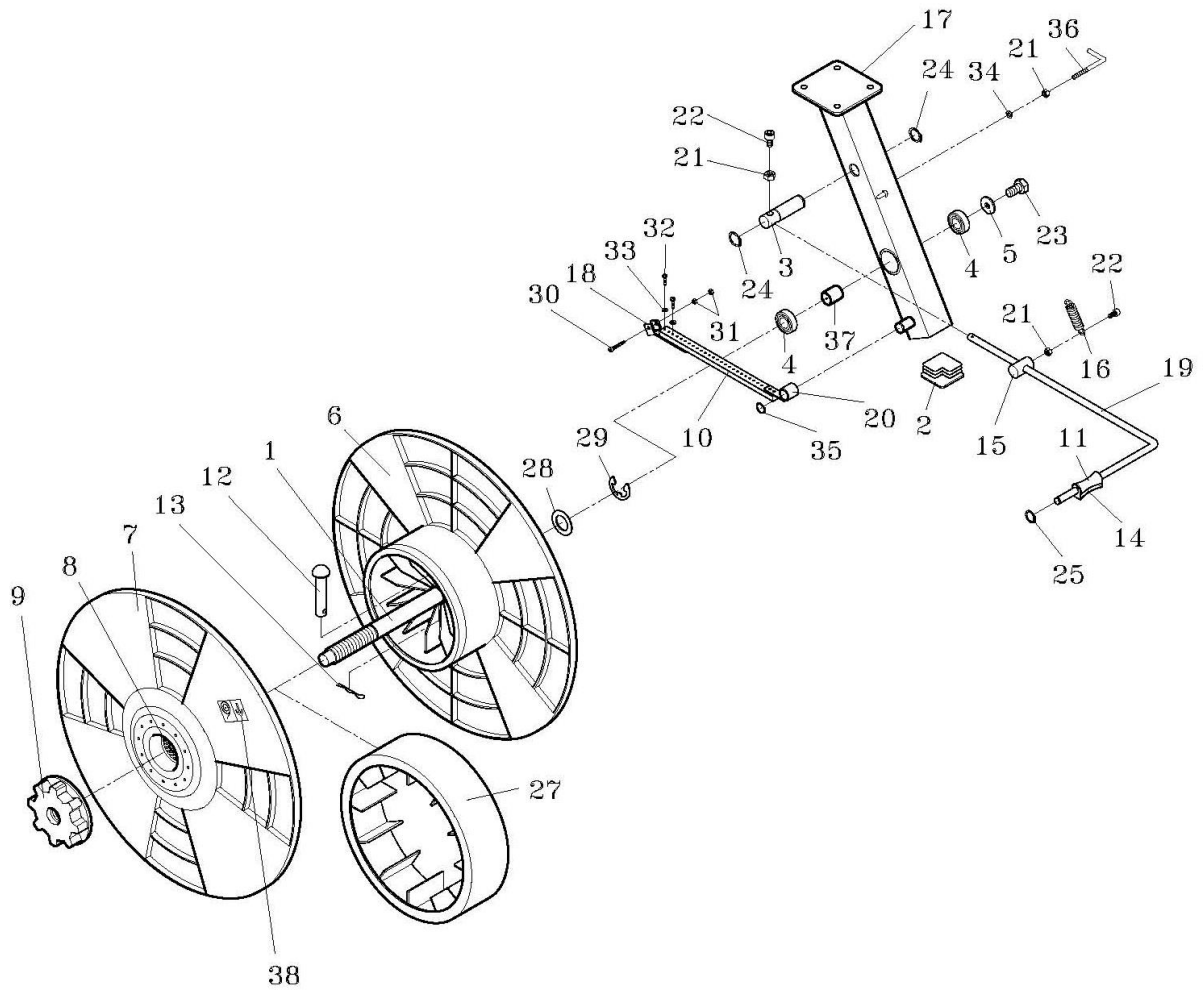
41

**⚠ WARNING**

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## REEL CONTROL ASSEMBLY

KEY	QTY	PART NO.	DESCRIPTION
2	1	500697	Lid
3	1	500698	Brake Shaft
4	2	500699	Bearing
5	1	500700	Washer
6	1	500701	Reel In Circular
7	1	500702	Reel Out Circular
8	1	500703	Protector
9	1	500704	Reel Nut Handle
10	1	500705	Brake Lining
11	1	500706	Roller
12	1	500707	Pin
13	1	500708	Split Pin
14	1	500709	Roller Holder
15	1	500710	Brake Adjuster
16	1	500711	Spring
17	1	500712	Reel Support
18	1	500713	Lining Fixed Bracket
19	1	500714	Arm
20	1	500715	Lining Holder
21	3	500633	HN, M6
22	2	500495	HBS, M6x16
23	1	500716	HBS M8x16
24	2	500717	Stop Ring S-20
25	1	500718	Stop Ring S-10
27	1	500720	Center Drum 280MM
28	1	500721	Washer
29	1	500722	E Ring E19
30	1	500623	HBS, M4x25
31	2	500724	14N, M4
32	3	500725	PMS, M4x16
33	3	500526	PW, M4
34	1	500508	SW, M6
35	1	500726	Stop Ring S-15
36	1	500727	Holder

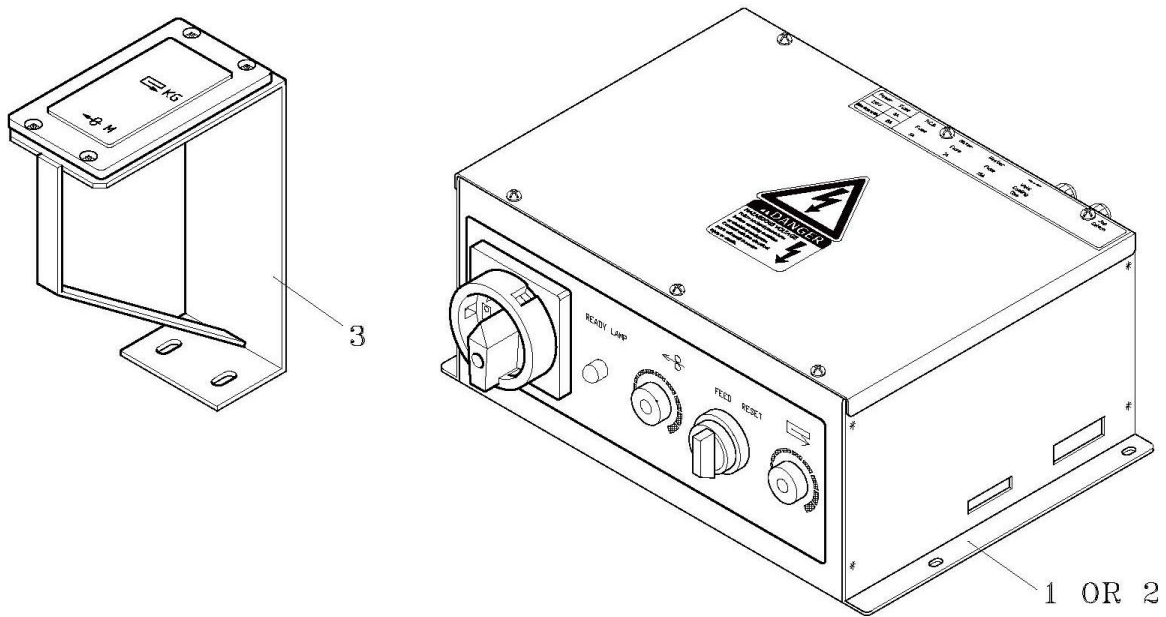


## **⚠ WARNING**

Inspect all parts dally and replace them  
If they are worn or broken. Failure to do  
this can affect a product's operation and  
could result in serlous personal injury.

## ELECTRONIC CONTROL ASSEMBLY

KEY	QTY	PART NO.	DESCRIPTION
1	1	500728	Electric Control Unit
2	1	500729	Electric Control Unit w/ read out
3	1	500730	Indicator Unit (Option)



**⚠ WARNING**

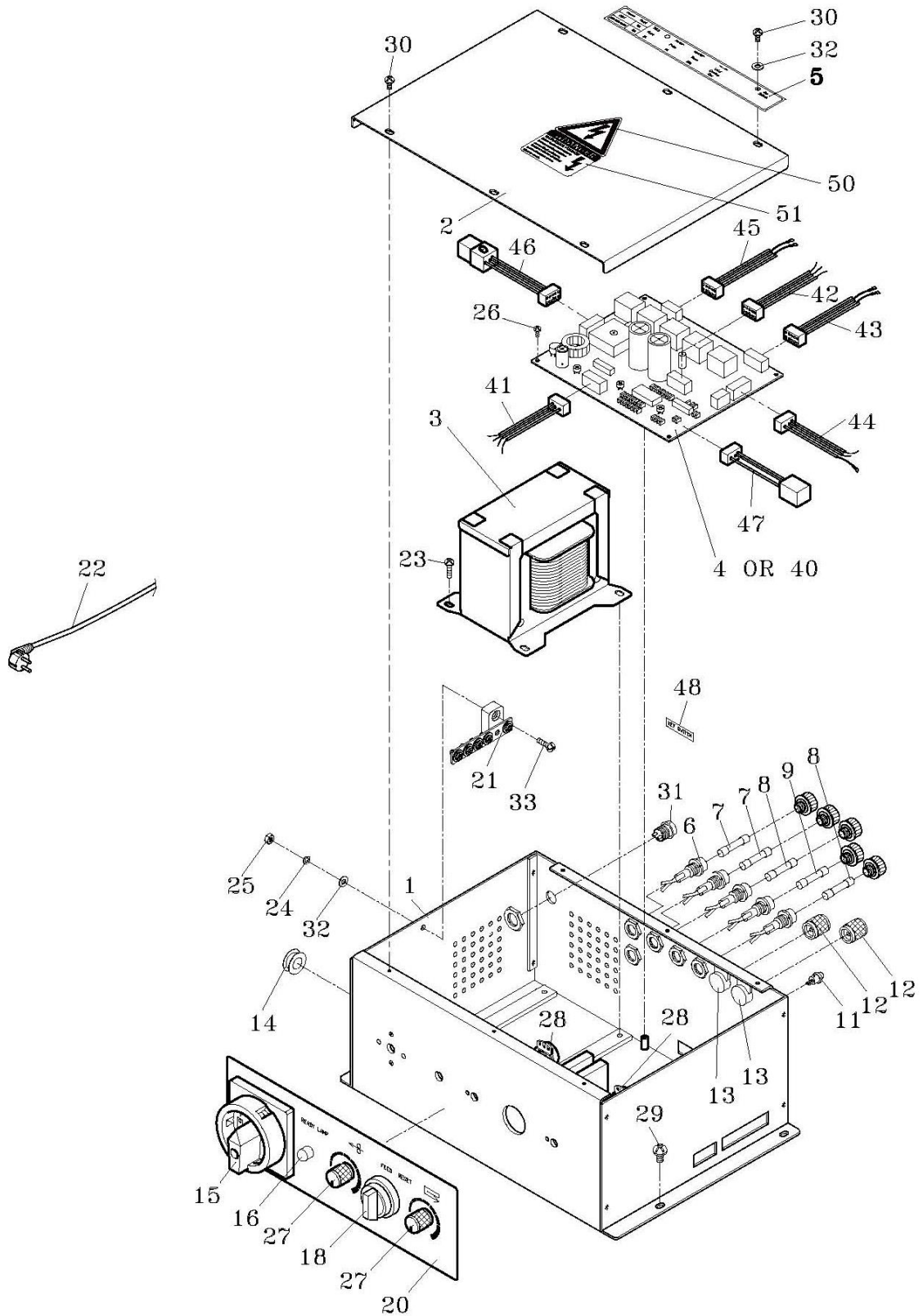
Inspect all parts daily and replace them if they are worn or broken. Failure to do this can affect a product's operation and could result in serious personal injury.

## ELECTRONIC CONTROL COMPONENTS

KEY	QTY	PART NO.	DESCRIPTION
1	1	500731	Box
2	1	500732	Cover
3	1	500733	Transformer (110V)
4	1	430727	P.C.Board
5	1	430728	Panel
6	3	500736	Fuse Holder
7	1	500737	Fuse (115V/3A)
8	1	500738	Fuse (1A)
9	1	500739	Fuse (10A)
10	1	500740	Fuse (7A)
11	11	500741	Knob
12	2	500742	Knob
13	4	500743	Variable Resistor
14	1	500744	Grommet
15	1	500745	Power Switch
16	1	500746	Heater Lamp
17	1	500747	Knob
18	1	500748	Selector Switch (Feed/Reset)
19	1	500749	Knob
20	1	500750	Panel
21	1	430715	Earth Plate (5P)
22	1	500751	Power Cord
23	4	500528	PMS, M4x12
24	4	500527	SW, M4
25	4	500503	HN, M4
26	4	500752	Bolt
27	8	500524	SW, M3
28	8	500525	HN, M3
29	4	500753	PMS, M6x10
30	6	500754	PMS, M4x8
32	2	430716	PW, M4
33	1	430717	TMS, M4x12
40	1	430729	P.C.B. For Machine With Readout (Optional)
41	1	500888	X1 Wire harness
42	1	500887	X2 Wire harness
43	1	500886	X3 Wire harness
44	1	430730	X4 Wire harness
45	1	500884	X5 Wire harness
46	1	500883	X6 Wire harness
47	1	500882	X7 Wire harness
50	1	430731	Label
51	1	430732	Label

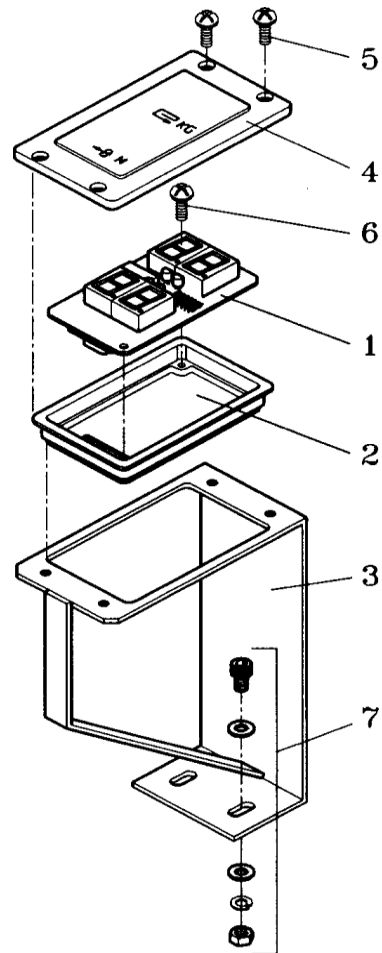

**WARNING**

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## INDICATOR UNIT ASSEMBLY OPTION

KEY	QTY	PART NO.	DESCRIPTION
2	1	500756	Indicators Under Cover
3	1	500757	Indicators Support
4	1	500758	Indicators Upper Cover
5	4	500759	PMS, M4x8
6	2	500760	Screw
7	1	500761	Bolt



## **⚠ WARNING**

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**SPARE PARTS KIT (P/N 500765)**

<b>QTY</b>	<b>PART NO.</b>	<b>DESCRIPTION</b>
2	500579	Bearing, 635ZZ
2	500522	Micro Switch
1	430189	Heater
2	500576	Return Spring
1	500600	Main Roller
1	500734	P.C. Board
2	500737	Fuse, 3 AMP
2	500738	Fuse, 1 AMP
2	500739	Fuse, 10 AMP
2	500740	Fuse, 7 AMP

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