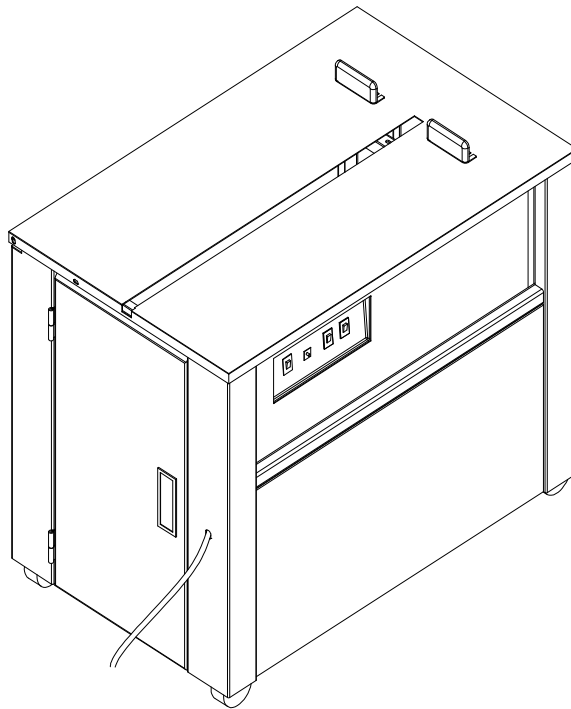


SEMI-AUTOMATIC POLYPROPYLENE STRAPPING MACHINE

OPERATION MANUAL & SPARE PARTS LIST



PLEASE READ ALL INSTRUCTIONS BEFORE OPERATING THIS PRODUCT

1. General information

1.1 Safety instruction

This manual gives you information on safety instructions, Specifications, Operation and maintenance of semi-automatic strapping machine.

Before operating or servicing the machine, please review the entire manual and follow the safety instructions.

1) Operation

- a. Do not operate the machine with the table tops or covers removed
- b. Make sure the proper voltage is being used to operate the machine
- c. Never put any part of your body near, under or into a moving machine
- d. Do not operate the machine with any safety devices removed or disabled.
- e. Follow instructions provided in this manual
- f. Only trained workers should operate this machine
- g. Do not attempt to strap any part of your body
- h. Do not overload the machine by exceeding the performance limitations specified in this manual.

2) Maintenance

- a. Shut off and lock out all electrical power before performing any maintenance procedure.
- b. Use the correct tools and parts to repair the machine
- c. Only trained people should service the machine
- d. Follow instructions provided in this manual.

3) Additional considerations

- a. Do not touch the heater and surrounding area. The heater operates at approximately 340 degree. Allow sufficient time for the heater to cool down.
- b. The machine should be placed on a level floor and the surrounding area should be kept free of debris and discarded strap.

1.2 Main Features

1) Portable

This is a compact and light-weight machine, allow easy transportation and only requiring little space for installation.

2) Single motor operation

A single motor powers the machine. Reliable operation is assured even if voltage drops.

3) Easy adjustment for changing strap width

Adjustment for using of 6mm up to 15.5mm can be made by loosening only four screws

4) No strap damage

The feeding system, strap tensioning device and cams are designed to prevent splitting, bending and scratching.

5) Applicable to any shape

The width of the slide table is small, allowing easy bundling of pipes and irregularly shaped objects.

6) Simple operation

The free end of the strap appears on the table which can be placed around this article by hand for strapping. NO training is required.

Applicable material: PP

Strap width: 6mm~15mm, Max $\pm 1.0\text{mm}$

Strap thickness: 0.6mm~1.0mm

Reel height: 170mm~190mm

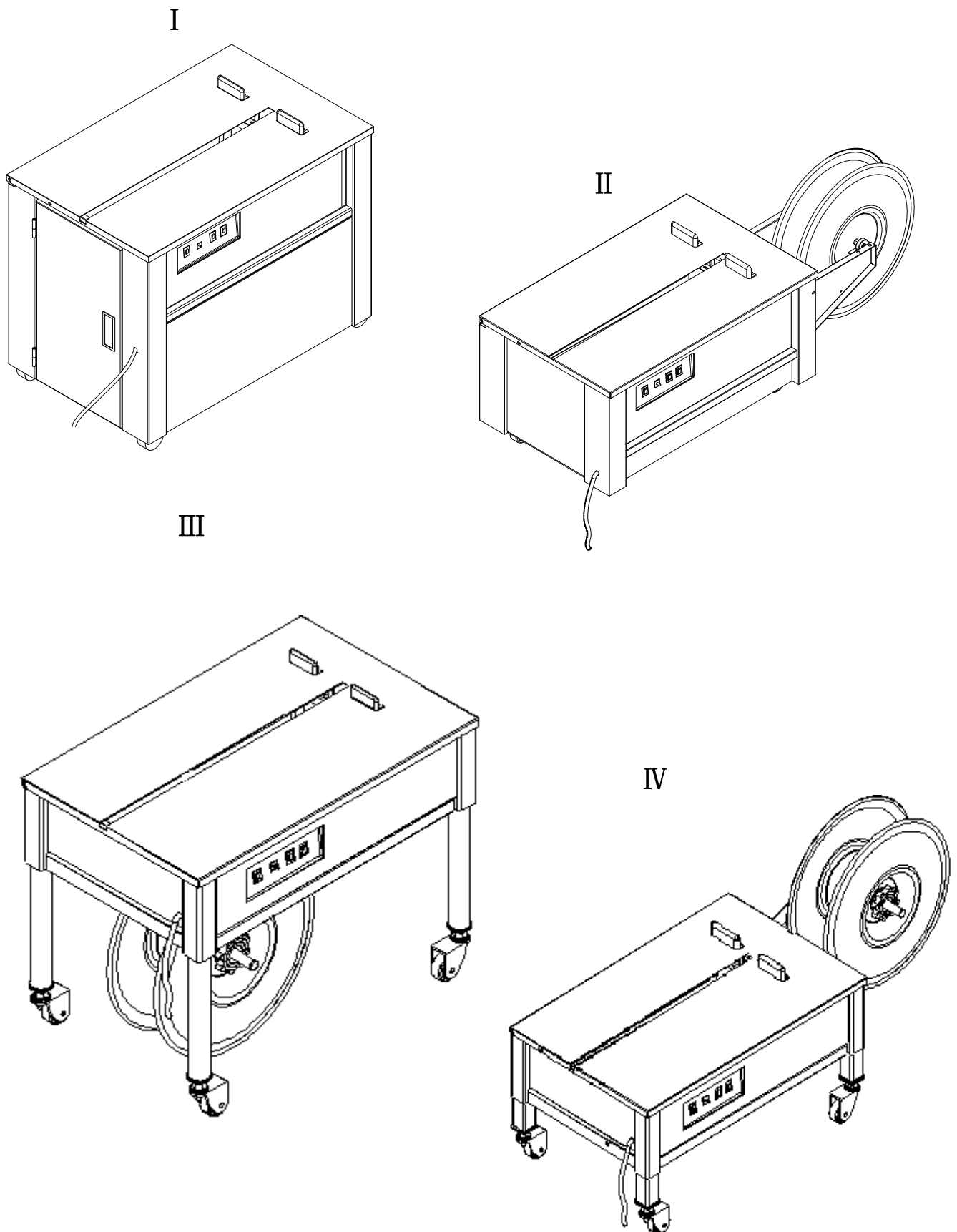
Reel inner diameter: 200mm

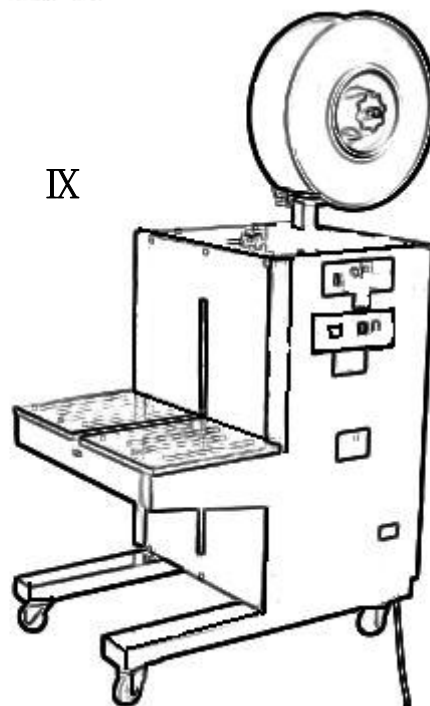
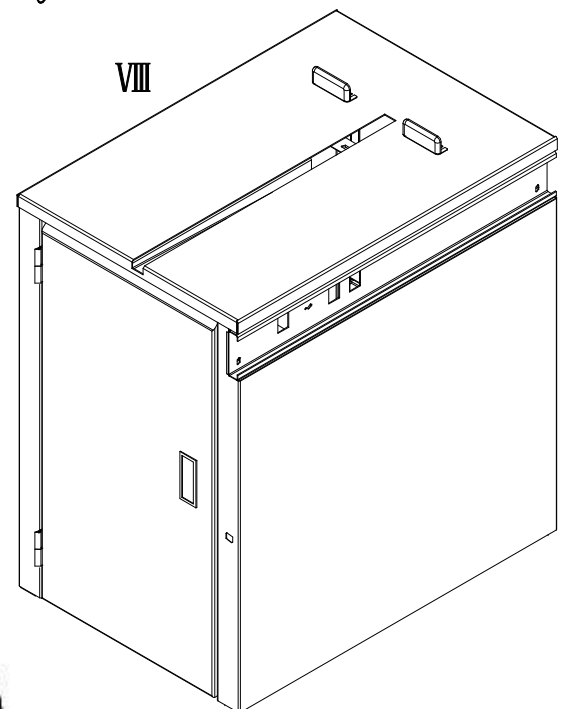
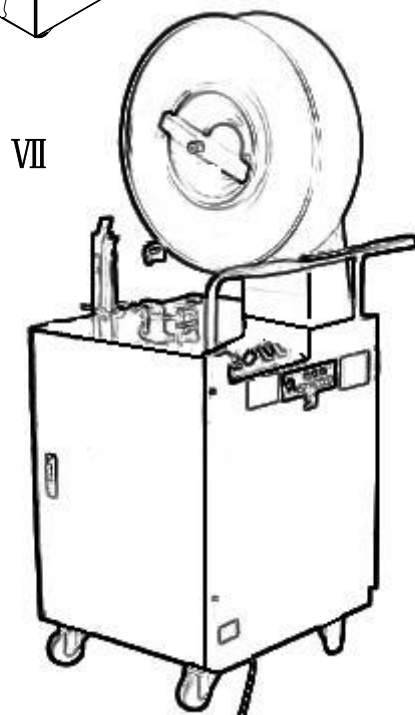
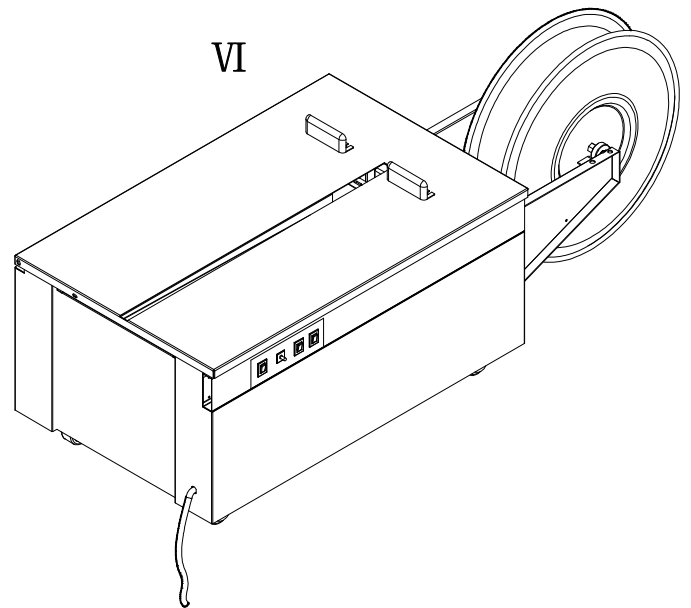
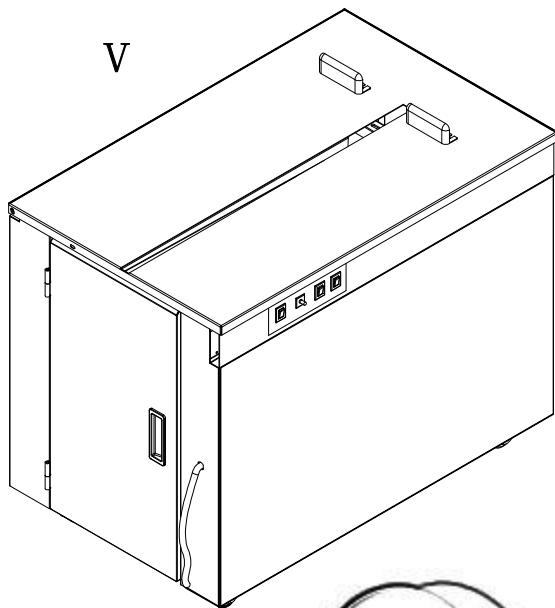
7) Parts with machine:

— Stopper	2pcs
— 8A Fuse	2pcs
— 2A Fuse	4pcs
— Phillips head screwdriver	1pc
— 8-10 Open end Wrench	1pc
— Allen wrench	1pc
— Brush	1pc
— Scissor	1pc
— Tool kit	1pc
— Manual	1pc

2.Specification

2-1Specification



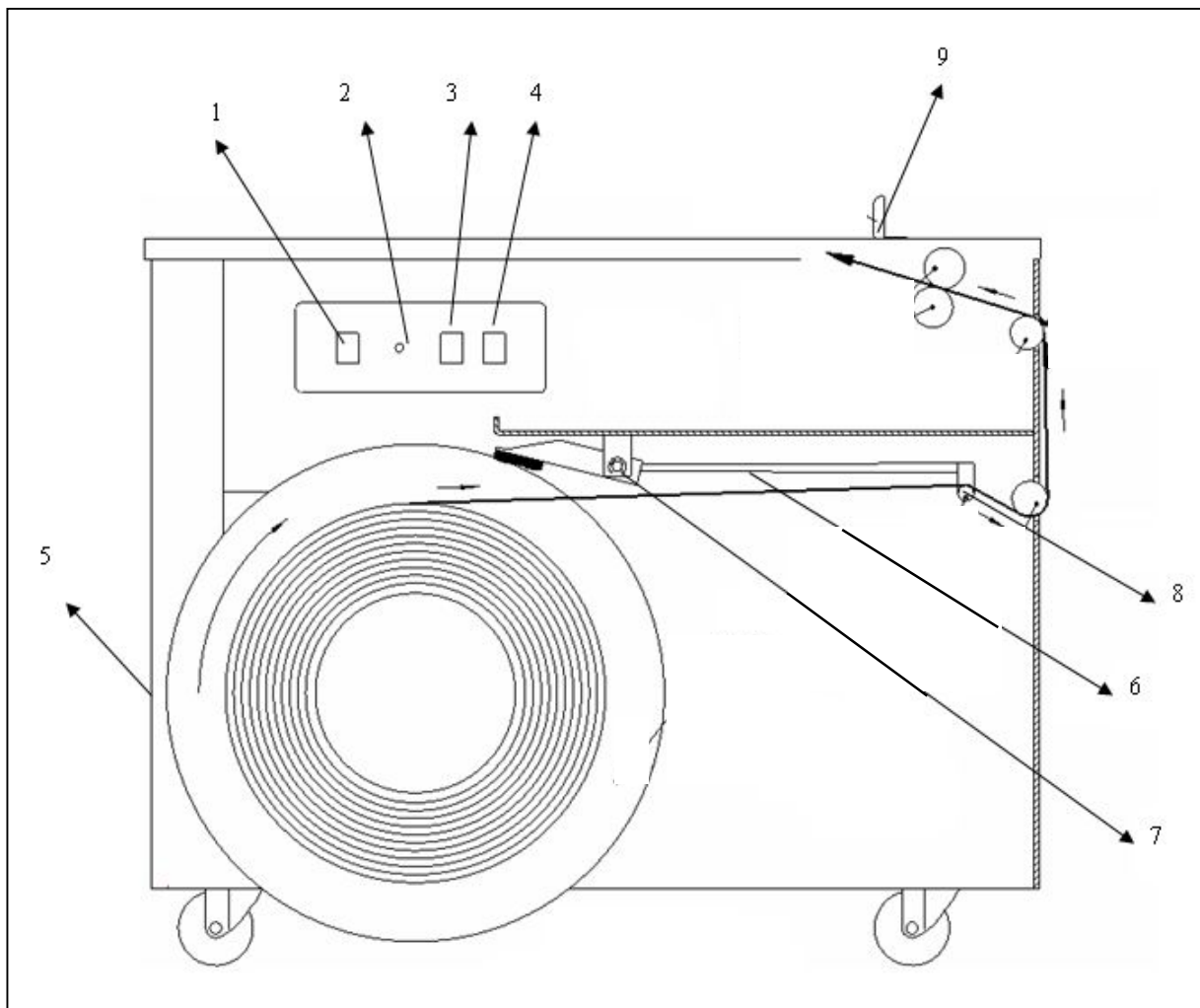


2-2 Technical specification

			I	II	III	IV	V	VI	VII	VIII	IX	X	XI
Reel	Width	mm	6~15mm										
	Inner diameter	mm	200										
	Height	mm	170~190										
Min strapping size		mm	60(W)×30(H)						>520H	60(W)×30(H)	>100H	60(W)×30(H)	
Max strapping size		mm	Free										
Strapping Speed		Min	22										
Tension		kg	5~60										
Joint way			Heating										
Table height		mm	730	460	730	460	730	460	120	730	330~845	730	730
Power supply			110、220、240V/50、60Hz										
Power		kw	0.35										
Loading capacity		kg	180						Free	180	Free	180	
Net weight		kg	90	80	85	80	100	85	88	85	100	90	90
Options		Plug, Input power, instant heating plate, temperature control, tension arm, brake											

3. Functional Description

- 1) **Power switch:** The motor starts rotating when this switch is turned ON
- 2) **Feeding length knob:** Strap is automatically fed during the time preset by the knob.
- 3) **Reset switch:** To pull strap back into machine and/or to cut off strap
- 4) **Strap feed switch:** To feed strap out of machine freely
- 5) **Power plug:** To be connected to a 110V or 220V/230V/240V source
- 6) **Brake:** Stops the over-rotation of the band reel
- 7) **Strap guide for brake:** The strap is threaded through this guide
- 8) **Strap bypass guide:** The strap is passed through this guide



- 9) **Packaging stopper:** This is to stop the package put on table top

Picture 1

4. Operation

1) Turn on/off power switch

◆ ON--The motor starts rotating as the power switch is in the ON position. Indicator ON, Hot knife gets heat

◆ OFF--Make sure to turn OFF the power switch after operation is completed for the day.

2) Set strap feeding length

The strap feeding length knob is located on the front of the control panel. This knob controls the length of strap that will feed out of the machine after each cycle. The knob is to set the feeding time from 0 to 6 seconds. Each second equals about 1 meter of strap feed. If you require 2 meters of strapping to secure your package, then set the knob at 2.

4) Manual switches

A. Reset-- Press down RESET button, It will complete cutting, the heat sealing process, and return to the ready position.

B. Feed—Fees strap

5) To strap the package

Place the package on the machine and pass the strap around the package by inserting the leading edge of the strap into the strap inlet to activate the strapping cycle. Strap tension starts as soon as the cycle is activated and the heat sealing process takes place automatically after the tension cycle is completed. The timer is activated, strap is fed out and the machine is ready for the next cycle.

6) Prefeed the strap

Press the strap feed button on the control panel and hold it down until the desired length of the strap is fed out.

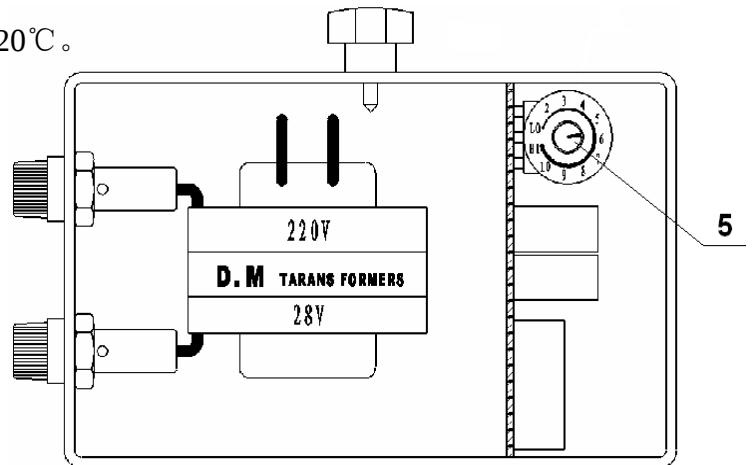
5. Adjustment

1) Hot knife temperature adjustment (Picture 4)

Hot knife temperature range 180°C ~ 320°C .

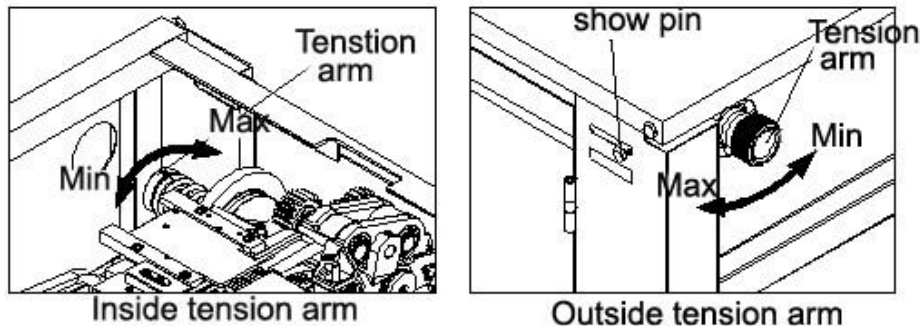
◆ “LO”—Min temperature 180°C .

◆ “HI”—Max temperature 320°C



Picture 4

2) Tension adjustment



Picture 5

The adjustment is made by tensioning adjustment nut which is located at the back of the machine. Tensioning adjustment nut is turned clockwise to increase the strength and counter-clockwise to decrease strength.

Max tension: 60kg. Set at 15kg in factory. (Picture 5)



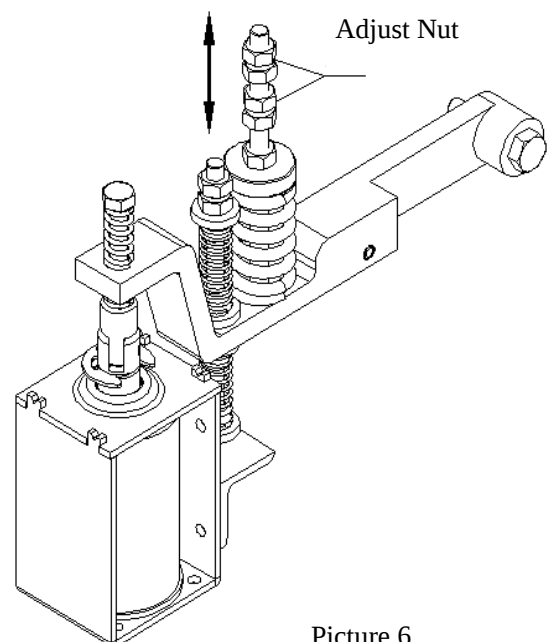
Warning: Too much tension will damage your package.

Adjustment nut is turned clockwise to increase the strength and counterclockwise to decrease stretch.(picture 6)



Warning:

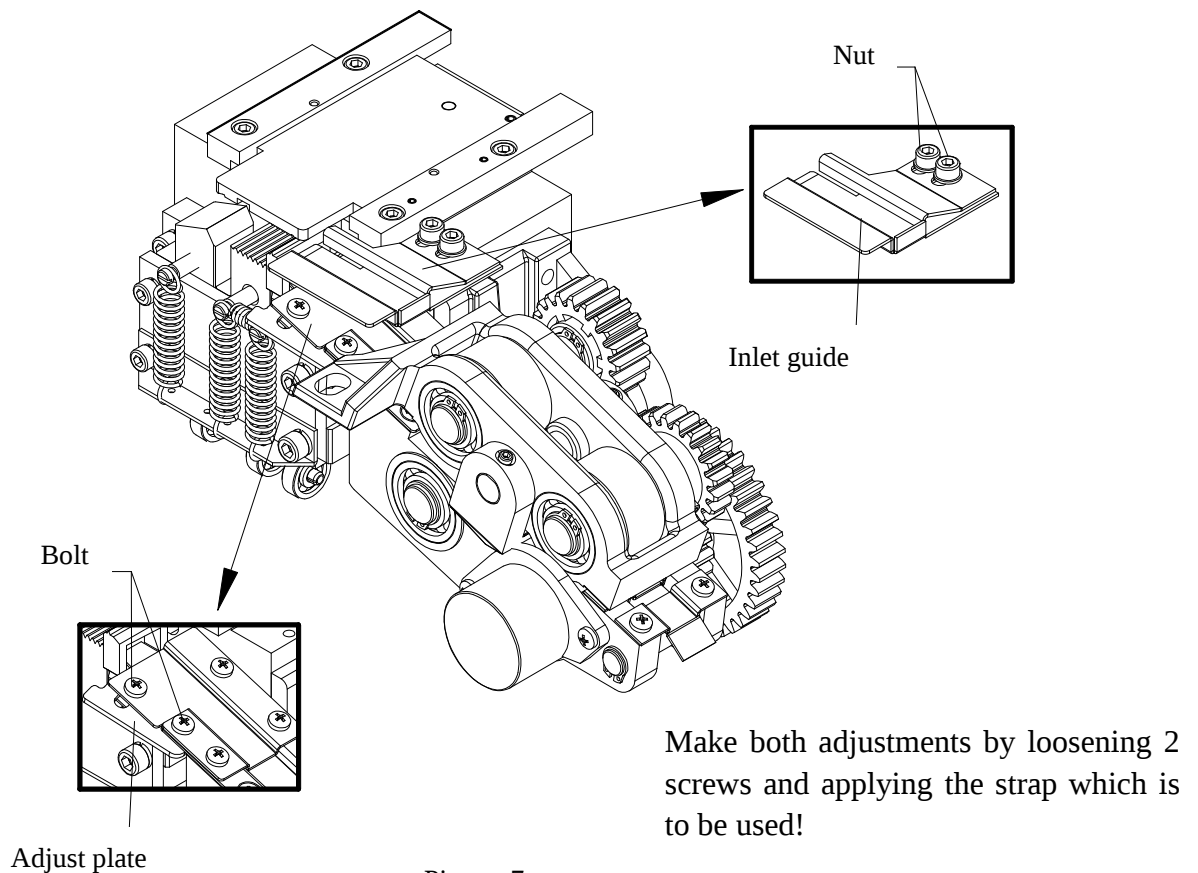
Upper bearing house is located between 2 adjustment nut. Gap between 2 adjustment nuts should be 0.3~0.5mm.



Picture 6

3) Strap width

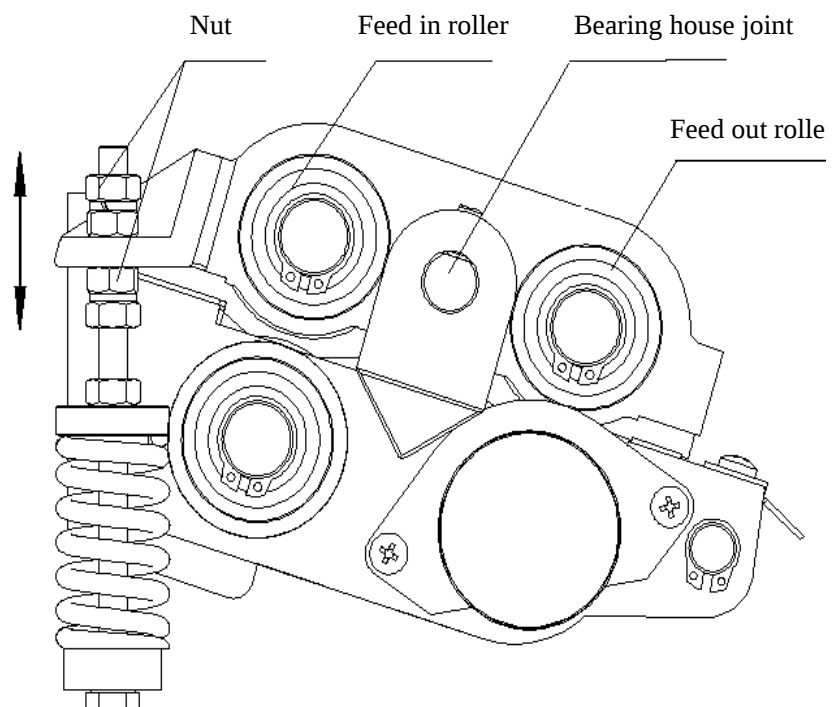
Adjustment for straps in different width can be done with only one Phillips recess screw driver and a hex spanner. The adjustment must be made in strap outlet and strap inlet as show below.



Picture 7

Strap outlet, the width of strap guide should be at 12.5mm to 13.0mm when using 12mm strap and the width of strap guide should be at 15.5mm to 16mm when using 15mm strap.

Strap inlet, the width of strap guide should be wider by 0.5mm to 1.0mm than the actual strap width to be used.



Picture 8

4) Adjustment for Gap between Feed in roller and Feed out roller

Keep the gap between Feed in roller and Feed out roller 0.05~0.10mm thicker than strap.



Warning:

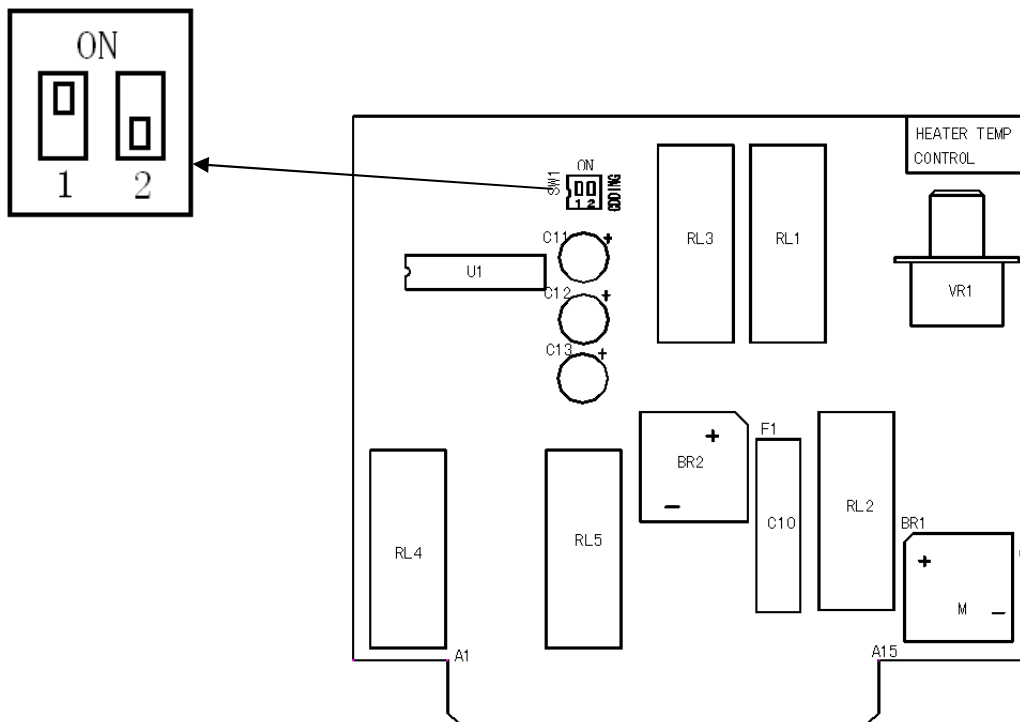
Do not lock the nuts. Leave 0.3-0.5mm gap

5) Cool time adjustment

Adjust 1 switch and 2 switch to ON, Max cool time.

Adjust 1 switch and 2 switch off to ON, Min cool time

Adjust 1 or 2 switch to On, Middle cool time



Picture 9

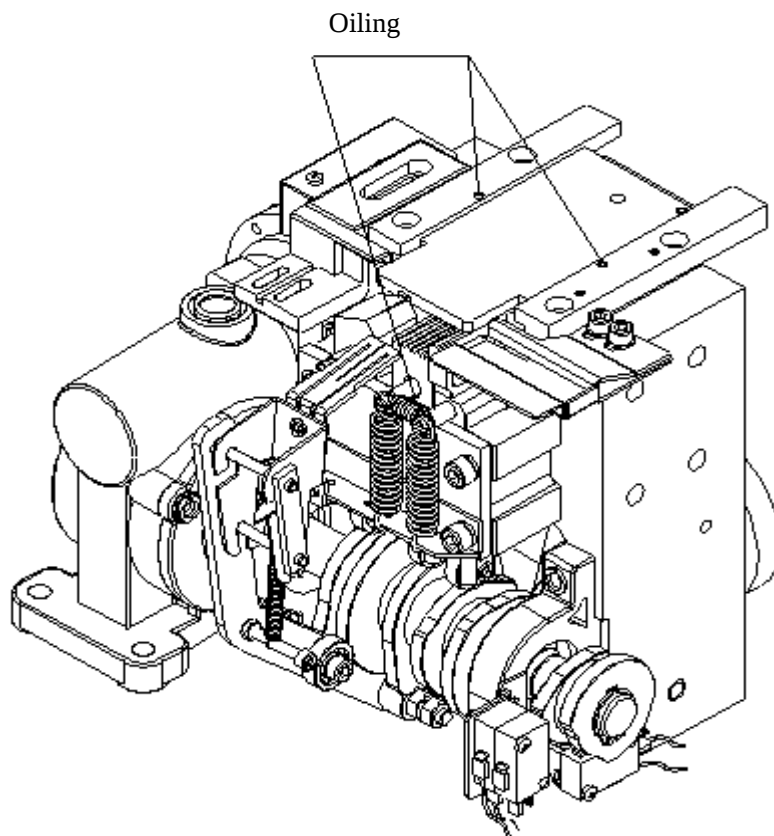
6.Maintenance

1) Clean the machine

- Keep the machine clean and neat at all times. Never leave the machine uncleaned after use.
- Do not leave any tools and/or parts on the machine. Keep them properly stored in their prearranged places.
- After completion of operation for the day, clean the machine and make necessary oiling and ensure that the machine is protected by a cover.

2) Lubrication

- Apply a few drops of light lubricant (Daphne mechanic oil or equivalent) into oil holes and on sliding parts prior to and after daily operation. (such as cam surface, upper bearing house joint, top cover holder, end gripper and welding clamp.
- Change the oil of the Gear box once every year. 150ml of Daphne oil or equivalent should be used.



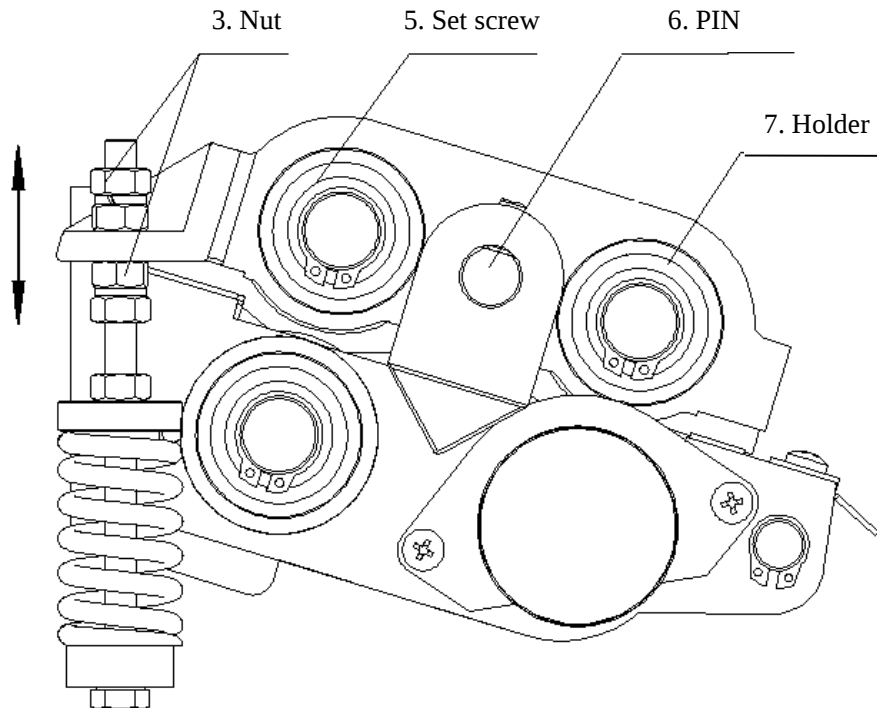
Picture 10

7. Troubleshooting

1) Strap jams in the Groove

Step 1. Turn the power switch off and pull out the band strongly in tensioning direction.

Step 2. In case this remedy dose not work due to a major jam, follow the instructions listed below.



Picture 8

- a) Loosen M5 set screw(Part No 5)
- b) Remove Pin (Part no 6) then lift holder (part No 7) and repeat step 1. If this is not successful continue
- c) Remove strap inlet guides
- d) Loosen adjustment nuts (Part no 3)
- e) Remove holder (Part no 7) and eliminate jam
- f) Reassemble from e back to a

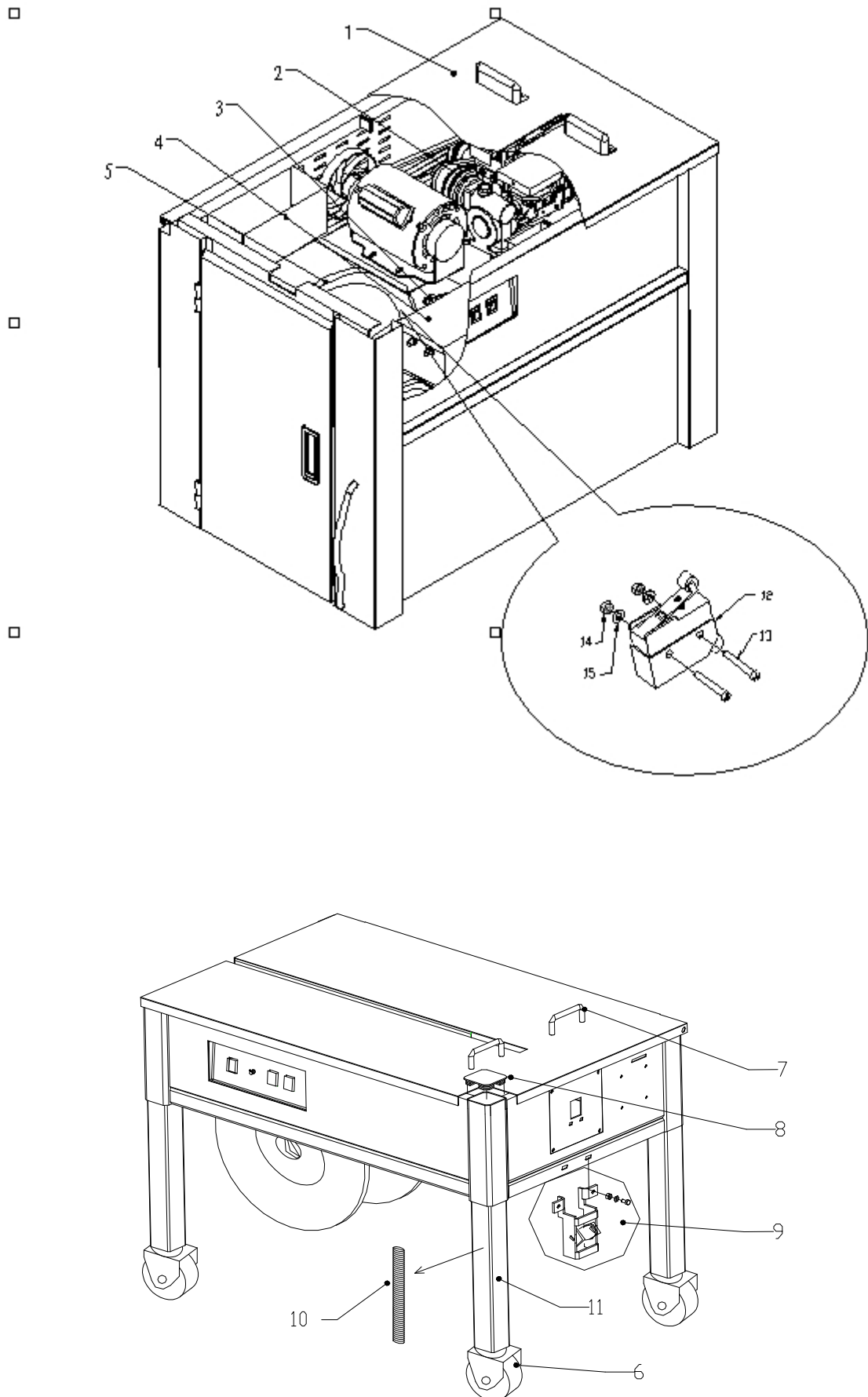
2) The strap dose not feed past the infeed guide

The failure is caused if the holding gripper is in the raised position (previous cycle has not been completed). Turn the motor switch “off”, then “on” again. If this dose not eliminate the failure, adjust the lever for LS1 to allow LS1 to energize and de-energize correctly.

3) Trouble table

Trouble	Cause	Remedy
Not feed back	1.Remains between upper & Lower bearing house 2.Tension lever bearing is broken 3.PCB is broken 4.Feed back roller gap is wrong	1. lift up upper bearing house, lean it 2. Replace bearing 3. Replace PCB 4. Adjust the gap
Bad sealing	1.Wong temperature 2.Power supply is not stable; 3.Heater arm spring is loosen 4.Hot knife is deformed 5.Wrong hot knife position 6.Welding clamp bearing is broken 7.Compression spring is loosen 8.High Temperature 9.PCB is broken 10.Instant heating cable badly connected 11.Too much tension; 12.Bad quality strapping band	1. Readjust the hot knife temperature. 2. Check power supply 3. replace spring 4. remove the jams on hot knife, adjust the deformed parts 5. Adjust hot knife position 6. replace bearing 635 7. replace compression spring 8. inspect smoke fan 9. replace PCB 10. inspect and/or replace instant heating cable 11. Readjust tension 12. Use better strap
Cut before full tension	1. Less tension 2. LS3&LS5 position is wrong 3. Magnetic switch is broken 4. PCB is broken	1. Put more tension. 2. Readjust LS3&LS5 position 3. Replace Magnetic switch 4. Replace PCB

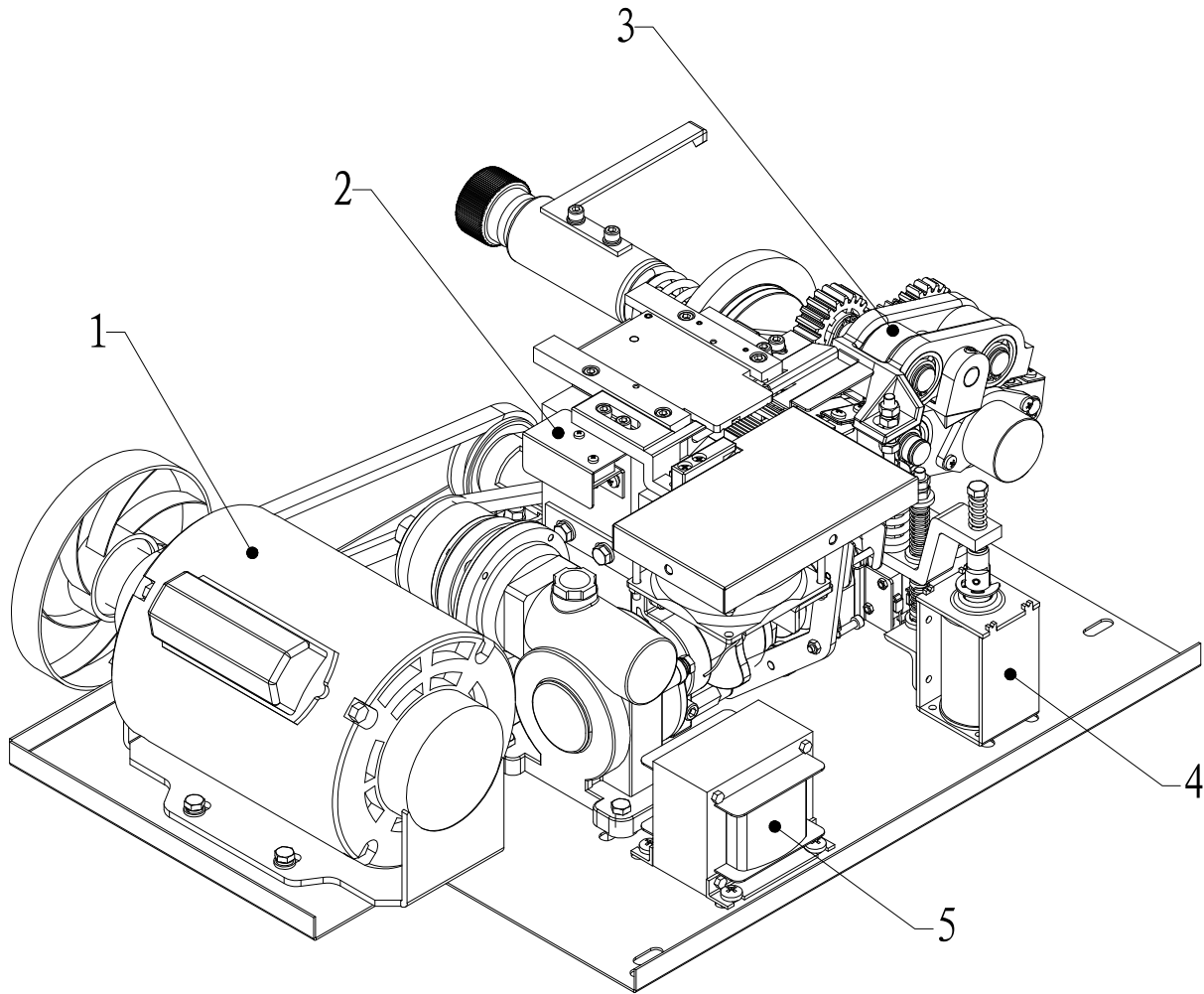
8. Main parts list and cabinet parts



NO	Drawing No	Description	QTY	Part No
1	-04.0	Cabinet Unit	1	660500
2	-01.0	CKD Unit	1	010
3	-02.0	Brake Unit for XT8022	1	23-0200
		Brake unit for XT8020	1	1300
4	-DK	Control box Unit	1	5002
5	-03.0	Dispenser Unit	1	1200
6		Swivel 5/8" Wheel	2	660620
		Fixed 5/8" Wheel	2	660628
7		Package Stopper	2	660092
8		Leg plastic cover	4	660622
9		Plastic roller bracket	1	660091
10		Leg screw	4	
11		Leg	4	
12		Safety switch TM1703	1	660247

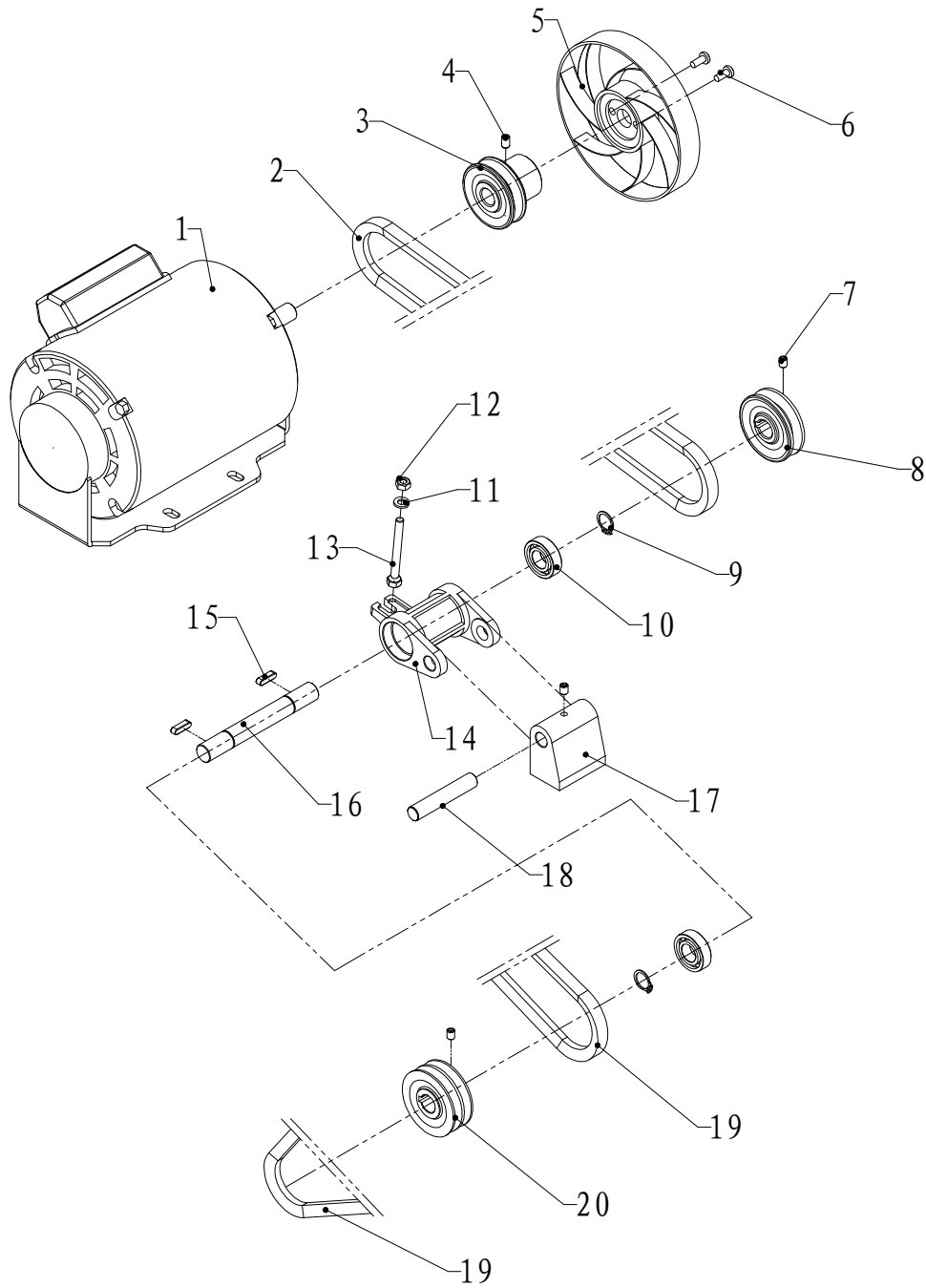
9. Spare parts list

9-1 CKD (-01.0)



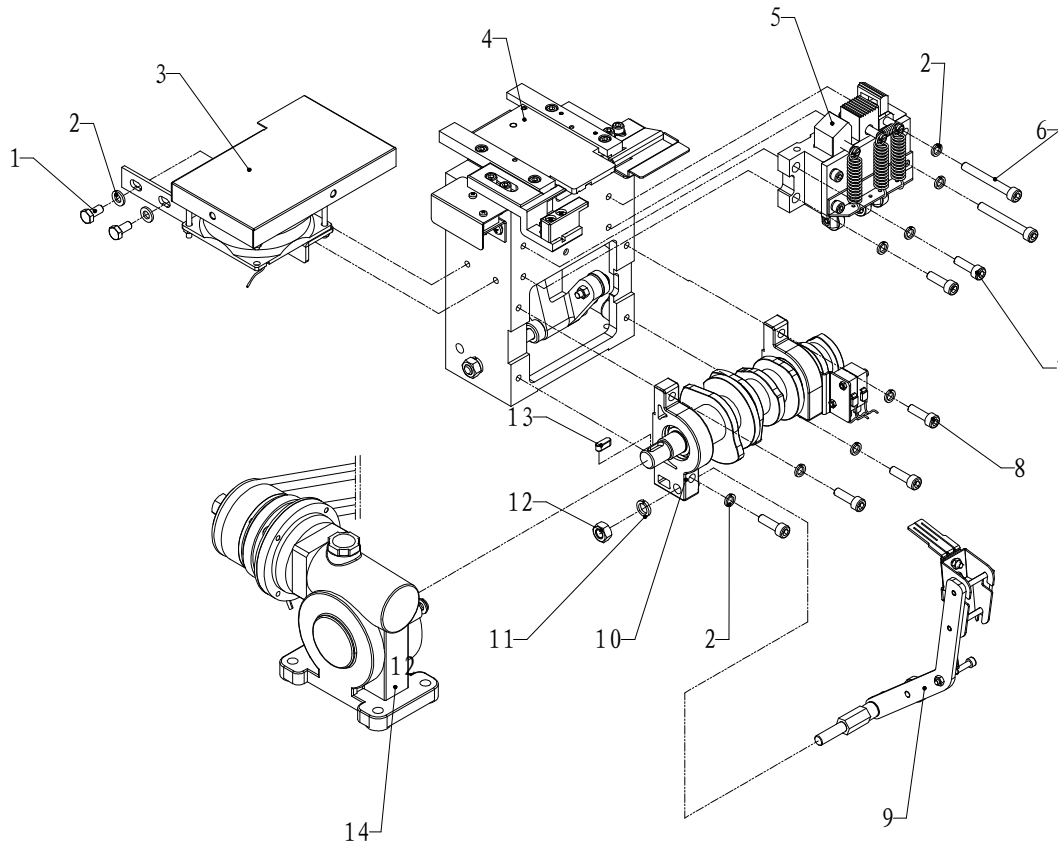
No	Drawing No	Description	QTY	Part No
1	-01.1	Motor 110V	1	660165
		Motor 220V	1	660165A
2	-01.2	Main machine unit	1	
3	-01.3	Feed in and Feed out unit	1	
4	-01.4	Heater arm unit	1	
5	T1	Transformer 110V	1	660212
		Transformer 220V	1	660212A
		100VA、Uout1.1V (Use with hot knife I)		
		45VA、Uout1.5V (Use with hot knife II)		

9-1-1 Motor (-01.1)



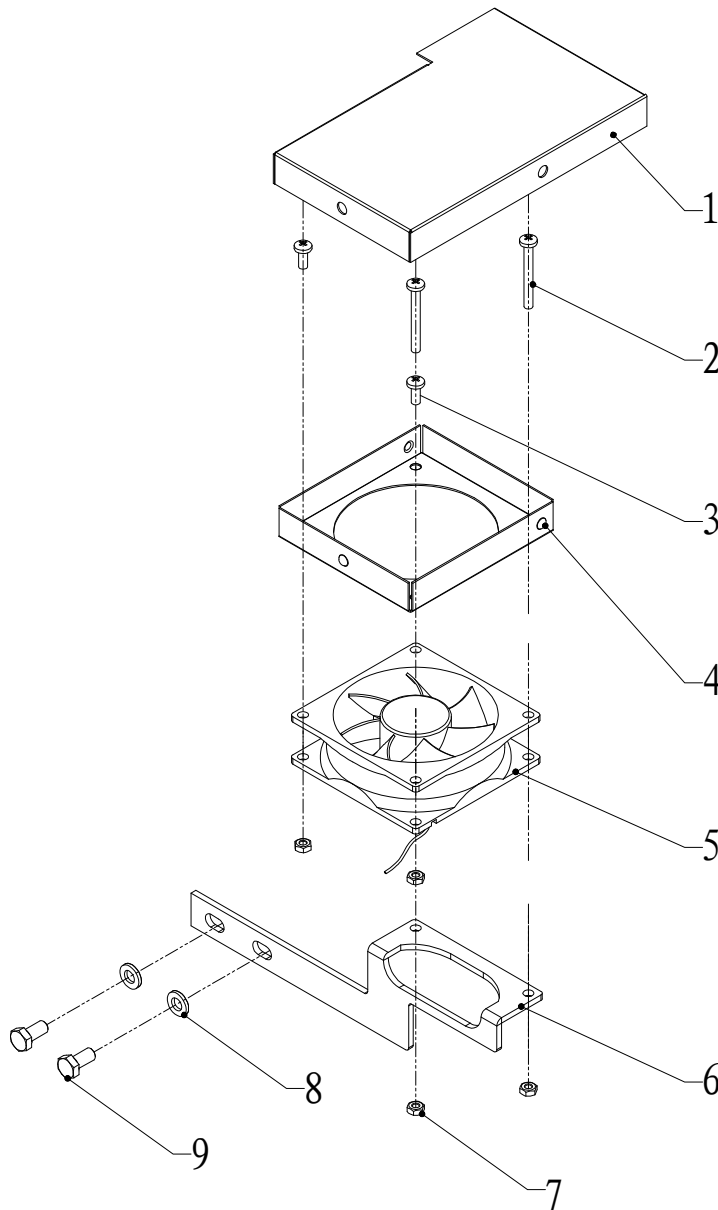
No	Drawing No	Description	QTY	Part No
1	M1	Motor(0.25Kw 220V/110 1450rpm)	1	660165A
		Motor 110V	1	660165
2	GB/T11544-1997	Belt M27.5	1	660496
3	-0001	Motor Pulley	1	660141
4	GB/77-2000	Bolt M6*10	1	660361
5	-0002	Motor Fan	1	660140
6	GB/T818-2000	Phillips head screw M5*12	2	660316
7	GB/77-2000	Bolt M6*8	3	660365
8	-0804	Single Pulley	1	660049
9	GB/T894.2-1986	Flexible ring 15	2	660465
10	GB/T276-1994	Bearing 6002-2Z	2	660439
11	GB97.1-2002	Plain Washer M6	1	660412
12	GB/T6170-2000	Nut M6	1	660401
13	GB/T5783-2000	Hex bolt M6*55	1	660360
14	-0802	Transmission bracket	1	660047
15	GB1096-1997	Key 5*18	2	660488
16	-0805	Transmission bracket shaft	1	660050
17	-0801	Transmission seat	1	660046
18	-0806	Transmission bracket pin	1	660051
19	GB/T11544-1997	Belt K19	2	660495
20	-0803	Double Pulley	1	660048

9-1-2 Main machine unit(Welding components and tension lever assembly) (-01.2)



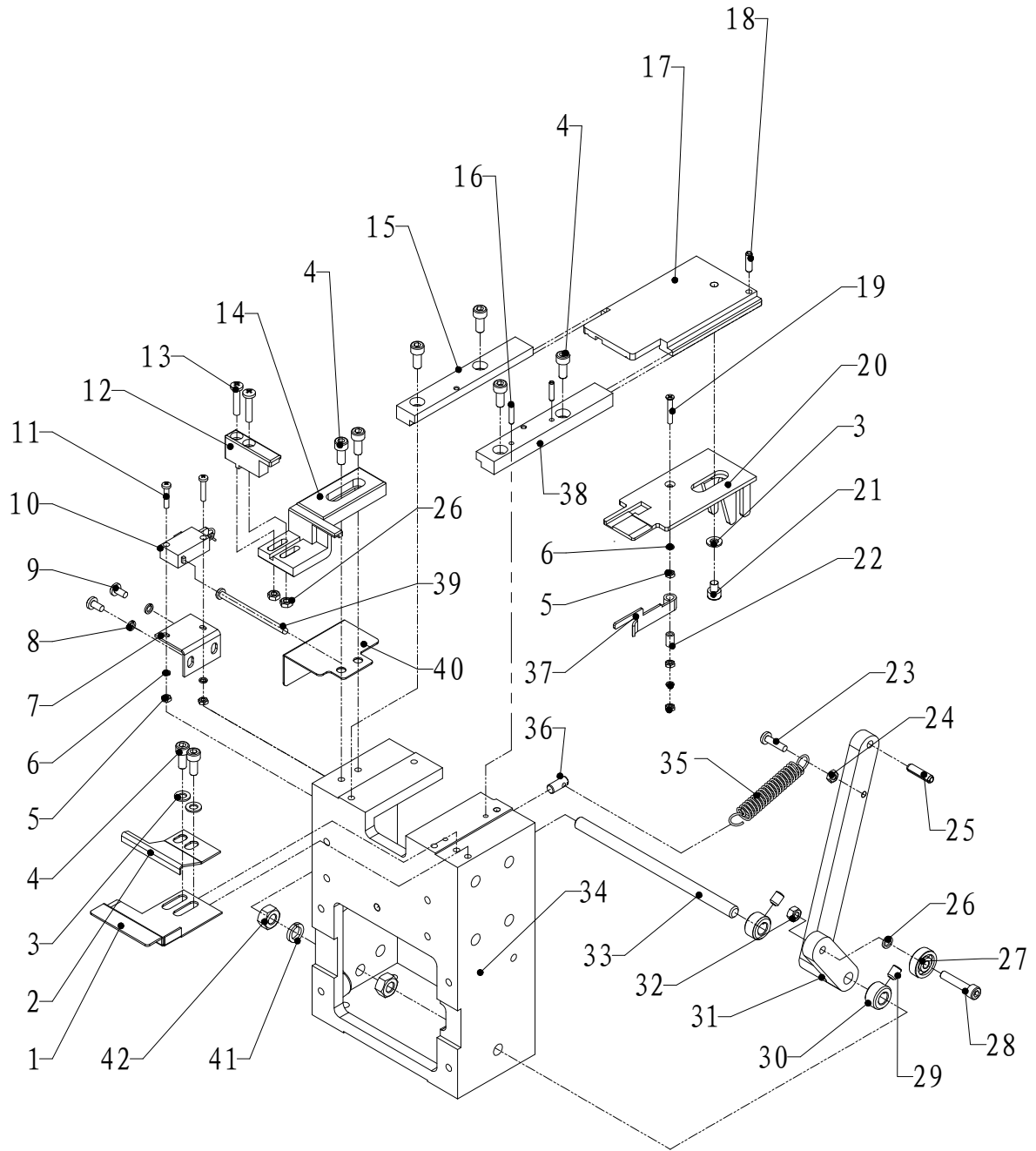
No	Drawing NO	Description	QTY	Part No
1	GB/T5783-2000	Hex Bolt M6*12	2	660351
2	GB97.1-2002	Plain washer M6	10	660412
3	-01.2.1	Smoke fan unit	1	0121
4	-01.2.2	Main body block unit	1	0100A
5	-01.2.3	Knife assembly	1	0200
6	GB/T70.1-2000	Socket head screw M6*50	2	660334
7	GB/T70.1-2000	Socket head screw M6*20	2	660329
8	GB/T70.1-2000	Socket head screw M6*16	4	660328
9	-01.2.4	Cam assembly	1	0906Z
10	-01.2.5	Hot knife unit	1	0400
11	GB/T93-1987	Spring washer 8	1	660423
12	GB/T6172.1-2000	Hex Nut M8	1	660402
13	GB1096-1997	Plain key 5*14	1	600484
14	-01.2.6	Gear box unit	1	0300A

1.Smoke Fan (-01.2.1)



No	Drawing No	Description	QTY	Part No
1	-0119	Protect cover	1	660276
2	GB/T818-2000	Phillips head machine screw M4*35	2	660387
3	GB/T818-2000	Phillips head machine screw M4*10	2	660381
4	-0120	Fan cover	1	660212B
5	24V/1.2W	Smoke Fan	1	660272
6	-0118	Fan bracket	1	0118
7	GB/T6170-2000	Nut M4	4	660399
8	GB/T93-1987	Spring washer 6	2	660422
9	GB/T5783-2000	Hex Bolt M6*12	2	660351

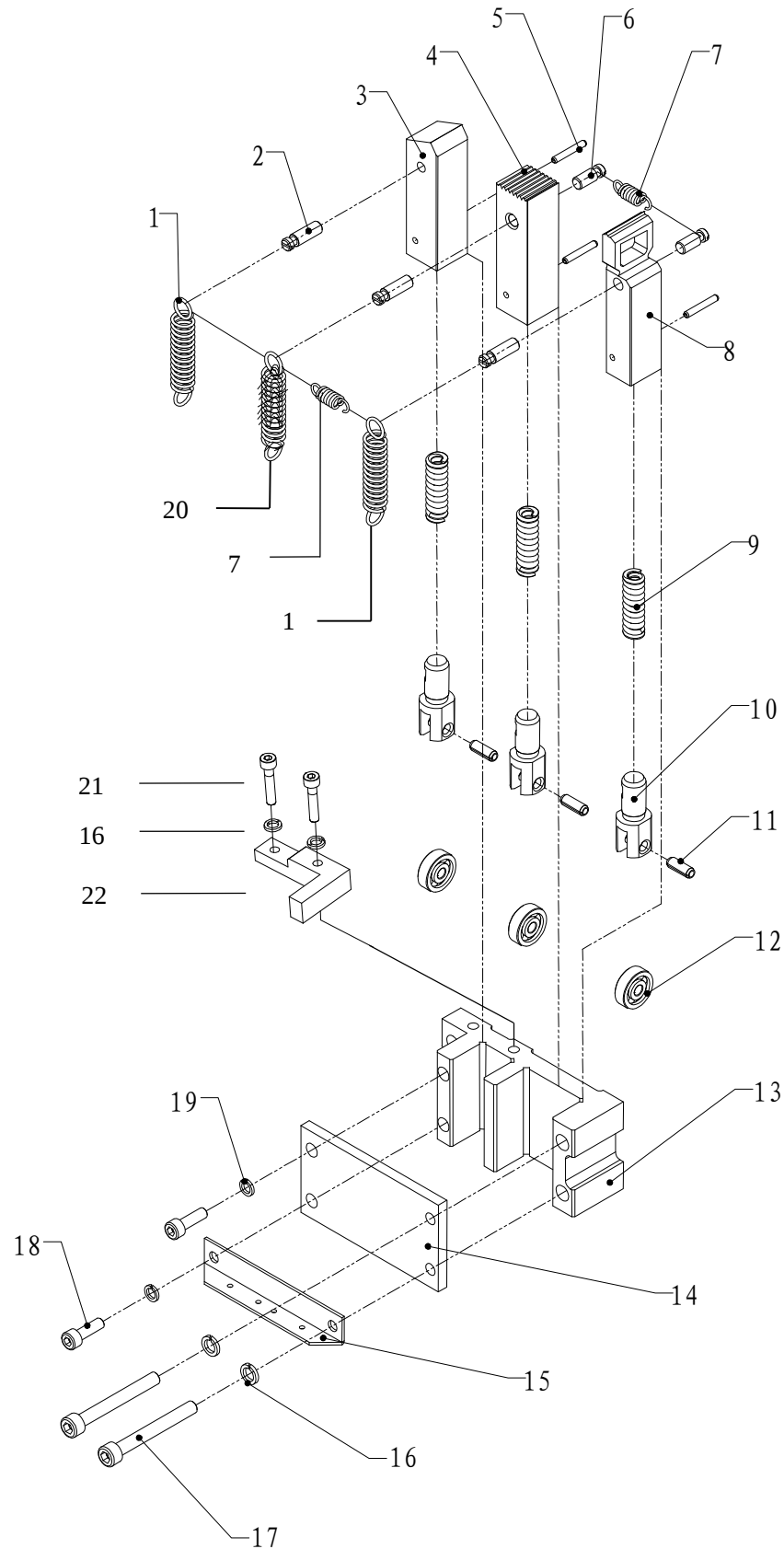
2.Main body block unit (-01.2.2)



No	Drawing No	Description	QTY	Part No
1	-0112	Entrance guide 1 (adjustable)	1	660076-79
2	-0113	Entrance guide 2 (adjustable)	1	660076-79
3	GB97.1-2002	Plain washer M5	3	660421
4	GB/T70.1-2000	Socket head screw M5*12	8	660316
5	GB/T6170-2000	Hex Nut M3	4	660398
6	GB/T93-87	Lock washer M3	4	660419

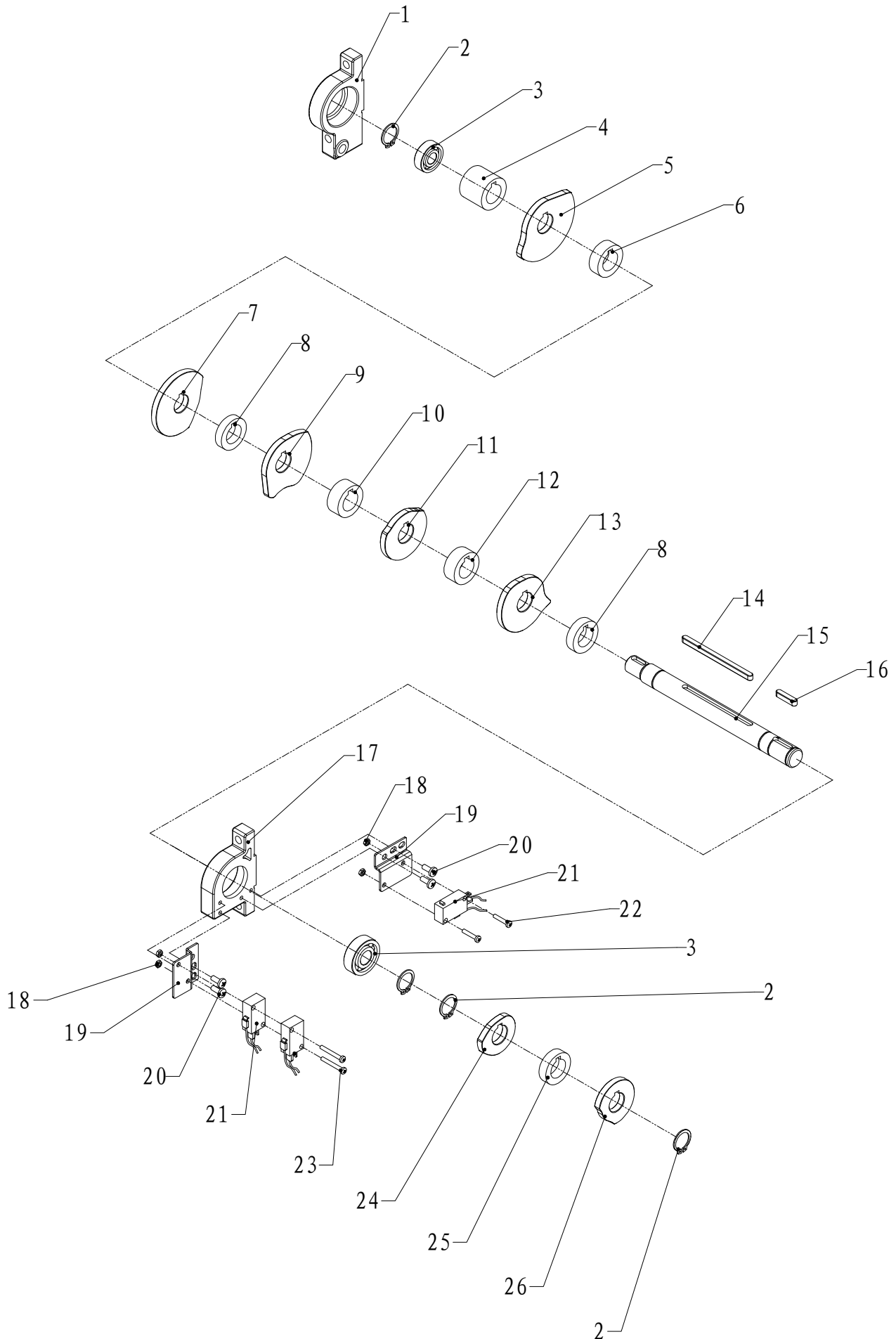
No	Drawing No	Description	QTY	Part No
7	-0122	Microswitch bracket	1	0122
8	GB/T93-87	Spring washer 4	2	660420
9	GB/T70.1-2000	Socket head screw M4*8	2	660377
10	LS1	Microswitch LS1	1	660224
11	GB/T818-2000	Phillips head screw M3*16	2	660370
12	-0115	Exist guide 2 (adjustable)	1	660080-83
13	GB/T818-2000	Phillips head screw M4*20	2	660386
14	-0114	Exist guide 1 (adjustable)	1	660080-83
15	-0106	Left guide plate	1	660136
16	GB/T119.1-2000	Pin 3*14	2	660472
17	-0102	Top cover holder	1	660134
18	GB/T119.1-2000	Pin 4*14	1	660475
19	GB/T819-2000	Flat head cap screw M3*20	1	660390
20	-0100-1	Separating plate	1	660135
21	GB/T70.1-2000	Socket head screw M5*8	1	660363
22	-0108	Sleeve	1	660155
23	GB/T818-2000	Phillips head screw M4*16	1	660378
24	GB/T6170-2000	Nut M4	3	660399
25	GB/T119.1-2000	Pin 5*20	1	660478
26	GB/T93-87	Spring washer 5	1	660421
27	GB/T276-1994	Bearing 635-2Z	1	660436
28	GB/T70.1-2000	Socket head screw M5*25	1	660320
29	GB/T77-2000	lock bolt M6*8	2	660362
30	-0111	Separating arm ring	2	660118
31	-0110	Separating arm	1	660130
32	GB/T6170-2000	Nut M5	1	660400
33	-0109	Separating arm pin	1	660117
34	-0101	Main body block	1	660124
35	-0116	Separating arm spring	1	660132
36	-0117	Hollow Screw	1	0117
37	-0107	Microswitch detector lever	1	660115
38	-0105	Right guide plate	1	660116
39	-0121	Microswitch pin	1	0121
40	-0123	Microswitch protect cover	1	0123
41	GB/T93-87	Spring wahser 8	1	660423
42	GB/T6170-2000	Nut M8	1	660402

3、 Knife assembly (-01.2.3)



No	Drawing No	Description	QTY	Part No
1	-0209	Tension spring long	2	660132
2	-0211	Spring hook	3	660129
3	-0206	Holding gripper	1	660122
4	-0205	Welding gripper	1	660121
5	GB/T119.1-2000	Pin 3*20	3	660480
6	-0212	Spring bolt	3	0212
7	-0213	Small spring	2	0213
8	-0204	End gripper	1	660120
9	-0208	Compression spring	3	660128
10	-0207	Clevis	3	660119
11	GB/T119.1-2000	Pin 5*14	3	660477
12	GB/T276-1994	Bearing 635	3	660436
13	-0201	Guide slot	1	660125
14	-0202	Guide plate	1	660126
15	-0203	Spring hook plate	1	660127
16	GB/T93-87	Spring washer 6	2	660422
17	GB/T70.1-2000	Socket head screw M6*50	2	660334
18	GB/T70.1-2000	Socket head screw M5*16	2	660318
19	GB/T93-87	Spring washer 5	2	660421
20		Tension spring short	1	660131
21	GBT7001	Socket head screw M5*16	2	660318
22		L type plate	1	660123

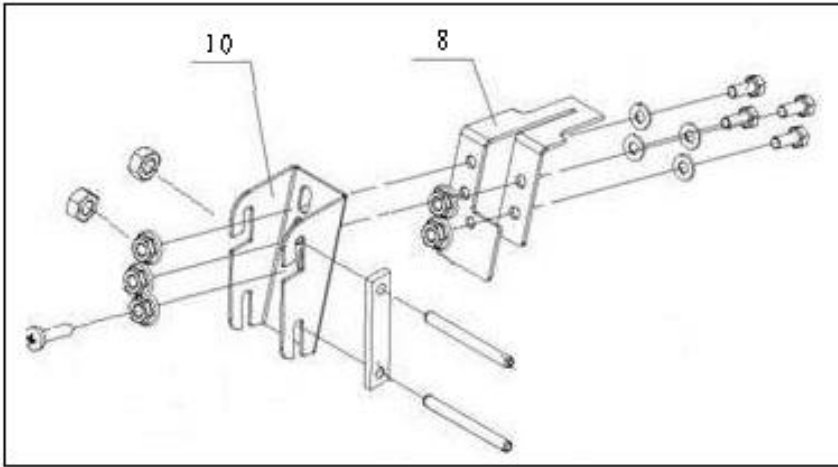
4、Cam assembly (-01.2.4)



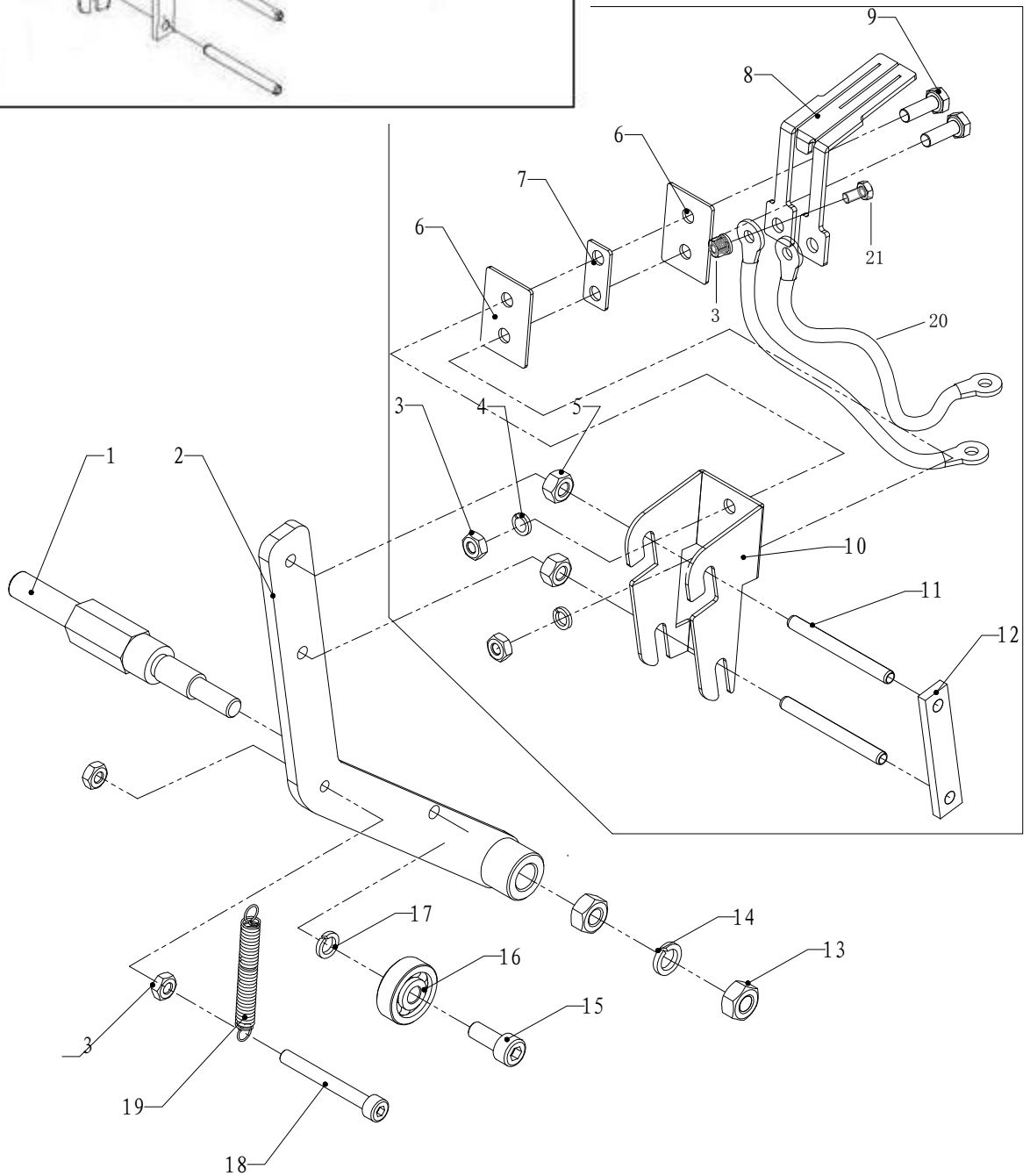
No	Drawing No	Description	QTY	Part No
1	-0401	Right bearing bracket	1	660142
2	GB/T894.1-1986	Ring 17	4	660460
3	GB/T276-1994	Bearing 6003-2Z	1	660440
4	-0411	Spacer 1 (ø29*25.2)	1	0411
5	-0406	Holding gripper cam	1	660540
6	-0412	Spacer 2 (ø29*10)	1	0412
7	-0408	Heater arm cam	1	660541
8	-0413	Spacer 3 (ø29*7)	2	0413
9	-0405	Welding gripper cam	1	660538
10	-0414	Spacer 4 (ø29*12.4)	1	0414
11	-0404	End gripper cam	1	660539
12	-0415	Spacer 5 (ø29*11.8)	1	0415
13	-0407	Separating arm cam	1	660151
14	GB1096-79	Pin 5*80	1	660499
15	-0403	Cam shaft	1	660542
16	GB1096-79	Pin 5*18	1	660485
17	-0402	Left bearing bracket	1	660143
18	GB/T6170-2000	Nut M3	4	660398
19	-0419	Microswitch seat	2	660148
20	GB/T818-2000	Phillips head screw M4*10	4	660381
21		Microswitch	3	660149
22	GB/T818-2000	Phillips head screw M3*16	2	660370
23	GB/T818-2000	Phillips head screw M3*25	2	660376
24	-0409	Tension lever cam	1	0409
25	-0416	Spacer 6 (ø29*7.8)	1	0416
26	-0410	Microswitch cam	1	0410

5. Hot knife unit (-01-2.5)

I type hot knife

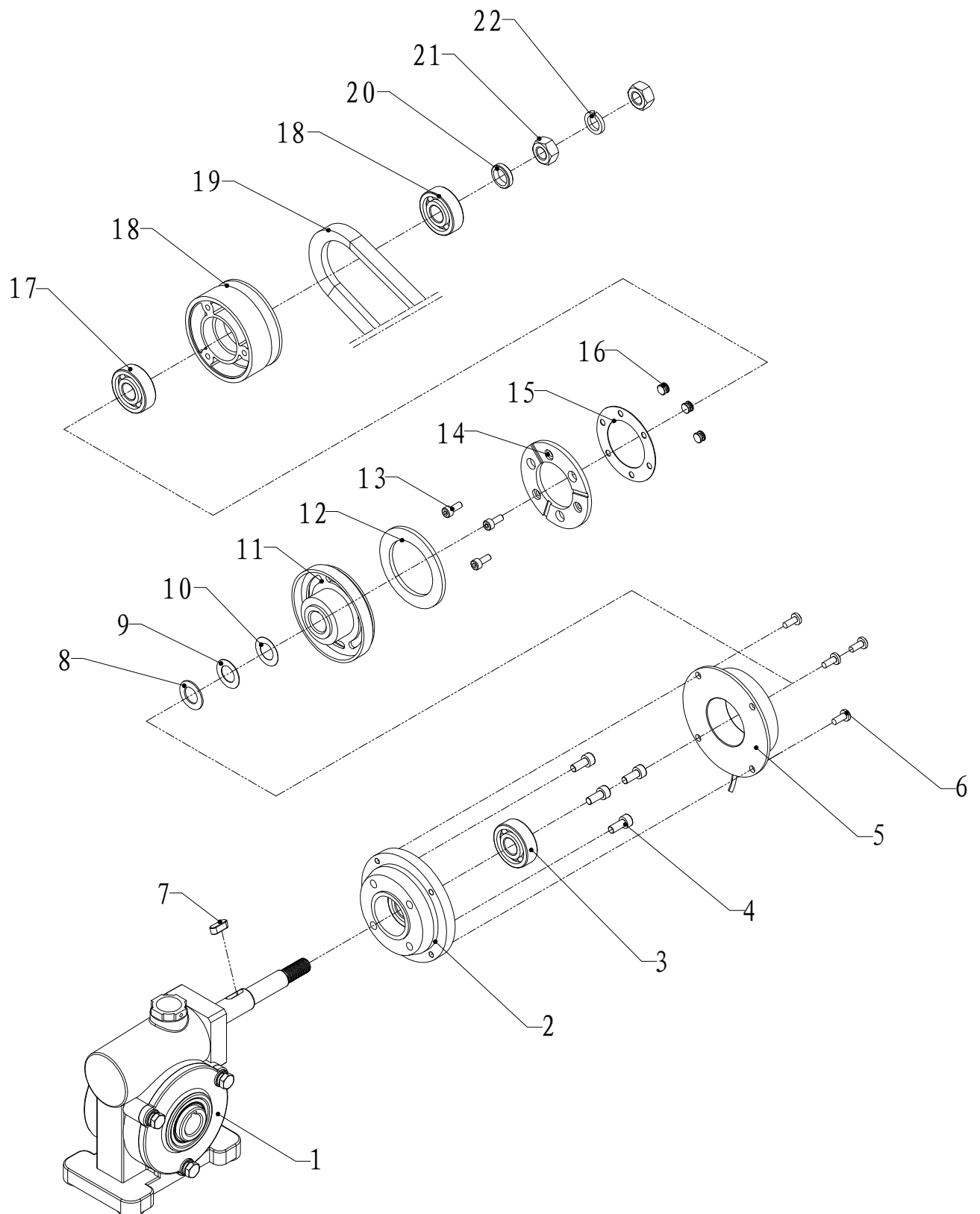


II type hot knife



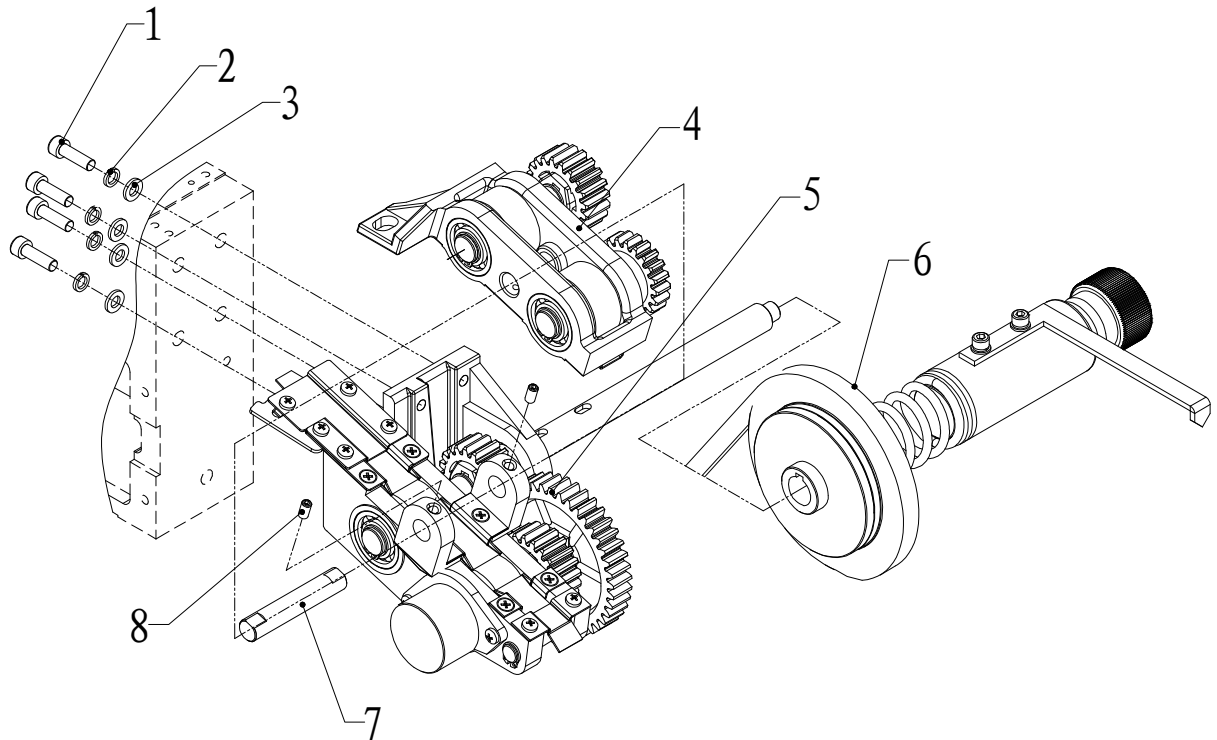
No	Drawing NO	Description	QTY	Part No
1	-0907	Heater arm screw	1	660073
2	-0901	Heater arm	1	660075
3	GB/T6170-2000	Nut M4	4	660399
4	GB/T93-87	Spring washer 4	2	660420
5	GB/T6170-2000	Nut M5	2	660400
6	-0910	Insulating plate	2	0910
7	-0911	Small insulating plate	1	0911
8	-0906	Instant heating heater plate	1	660084
9	GB/T70.1-2000	Socket head screw M4*12	2	660398
10	-0904	Heater blade holder	1	660072
11	GB/T119.1-2000	Pin 4*40	2	660476
12	-0903	Heater arm side plate	1	660074
13	GB/T6170-2000	Nut M6	2	660401
14	GB/T93-87	Spring washer 6	1	660422
15	GB/T70.1-2000	Socket head cap screw M5*12	1	660317
16	GB/T276-1994	Bearing 635	1	660436
17	GB/T93-87	Spring washer 6	1	660422
18	GB/T70.1-2000	Socket head screw M4*35	1	660393
19	-0905	Heater Spring	1	660132
20	-0909	Instant heating cable	2	660271
21	GB/T70.1-2000	Hex bolt, M4*12	2	660398

6.Gear box unit (-01.2.6)



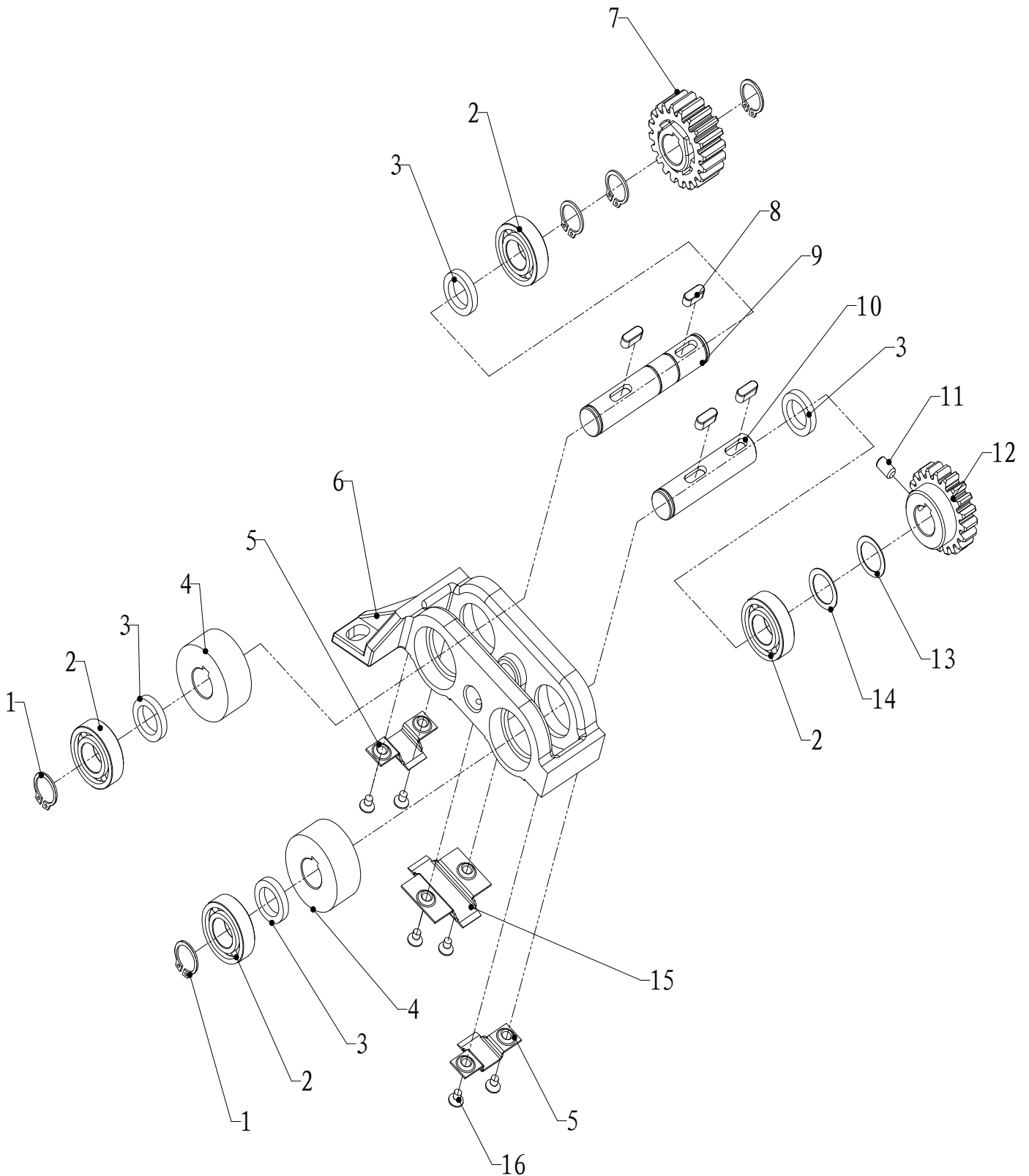
No	Drawing no	Description	QTY	Part No
1	i=28	Gear box	1	660137
2	-0309	Side cover	1	0309
3	GB/T276-1994	Bearing 6202-2Z	1	660442
4	GB/T70.1-2000	Socket head set screw M5*12	4	660316
5	-0311	Magnetic plate	1	0311
6	GB/T818-2000	Phillips head screw M4*10	4	660381
7	GB/T1096-79	Pin 5*14	1	660484
8	-0321	Washer	1	0321
9	-0322	Washer	1	0322
10	-0323	Washer	1	0323
11	-0313	Starting plate	1	0313
12	-0314	Friction plate	1	0314
13	GB/T70.1-2000	Socket head screw M4*10	3	660388
14	-0315	Tin Slice	1	0315
15	-0317	Spring plate	1	0317
16	-0316	Pin	3	0316
17	GB/T276-1994	Bearing 6201	2	660441
18	-0318	Clutch pulley	1	0318
19	GB/T11544-1997	Belt M27.5	1	660496
20	-0320	Circlet	1	0320
21	GB/T6170-2000	Nut M10	2	660403
22	GB/T93-87	Spring washer 10	1	660424

9-1-3 Feeding unit (Feed in and feed out parts) (-01.3)



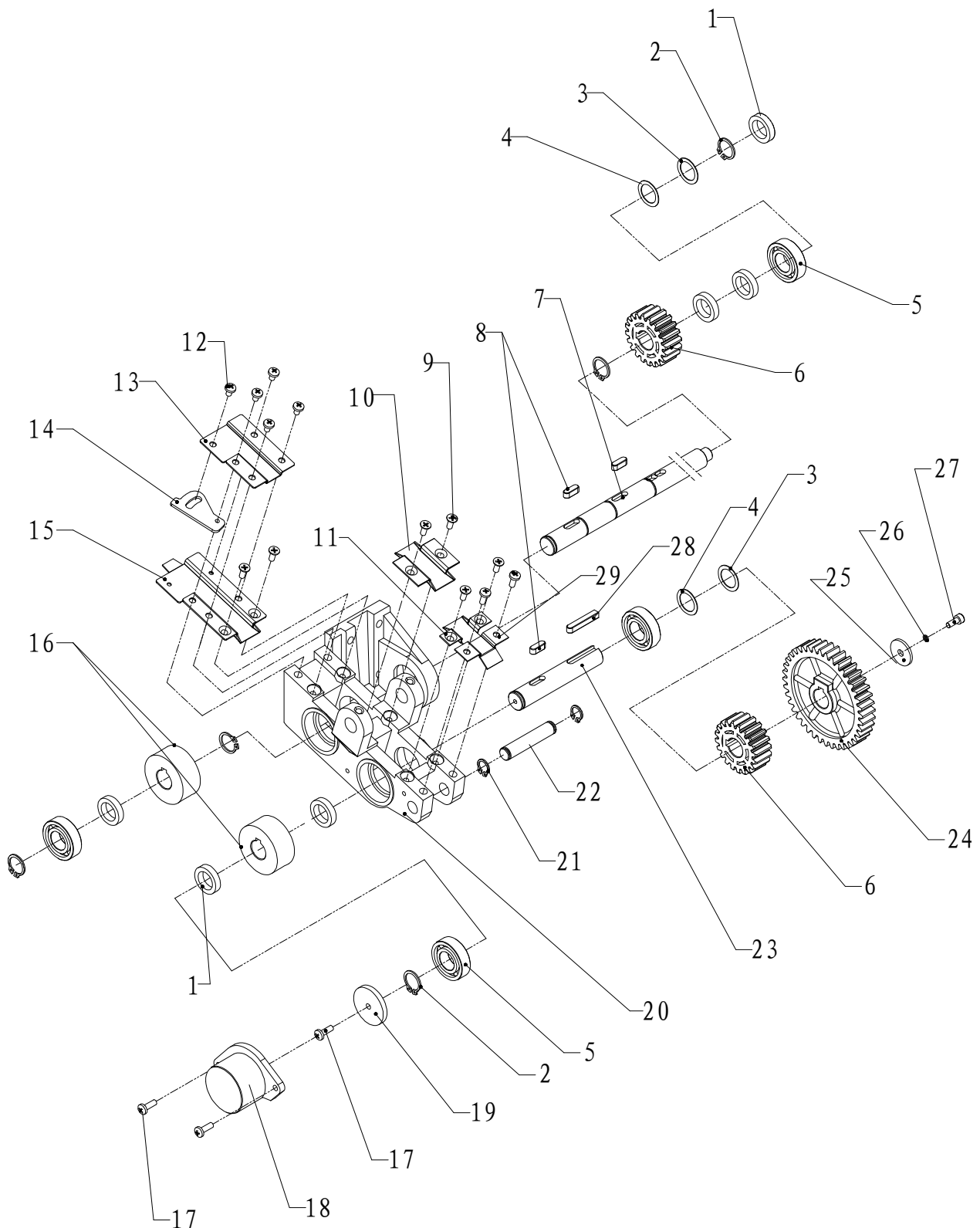
No	Drawing No	Description	QTY	Part No
1	GB/T70.1-2000	Socket head screw M6*20	4	660329
2	GB/T93-87	Spring washer 6	4	660422
3	GB/T97.1-2002	Plain washer 6	4	660623
4	-01.3.1	Upper bearing house assly	1	0500
5		Upper bearing housing	1	660012
6	-01.3.2	Lower bearing house assly	1	0600
7		Lower bearing housing	1	660013
8	-01.3.3	Tightness adjustment assly	1	0700
	-0605	Connection pin	1	660019
	GB/T77-2000	Lock bolt M5*10	2	660361

1.Upper bearing house assembly (-01.3.1)



No	Drawing NO	Description	QTY	Part No
1	GB/T894.1-1986	Washer 15	5	660463
2	GB/T276-1994	Bearing 6002-2Z	4	660439
3	-0510	Circlet	4	660006
4	-0506	steel roller	2	660004
5	-0507	Strap guide 1	2	660009
6	-0501	Upper bearing house	1	660012
7	-0504	Plastic gear 20 teeth	1	660001
8	GB1096-79	Key 5*14	4	660484
9	-0503	Feed roller shaft	1	660017
10	-0502	Roller shaft	1	660016
11	GB/T77-2000	Lock bolt M6*10	1	660367
12	-0505	Steel gear 20 teeth	1	660002
13	-0512	Washer	1	0512
14	-0511	Washer	1	0511
15	-0508	Strap guide 2	1	660010
16	GB/T819-2000	Flat head screw M4*6	6	660391

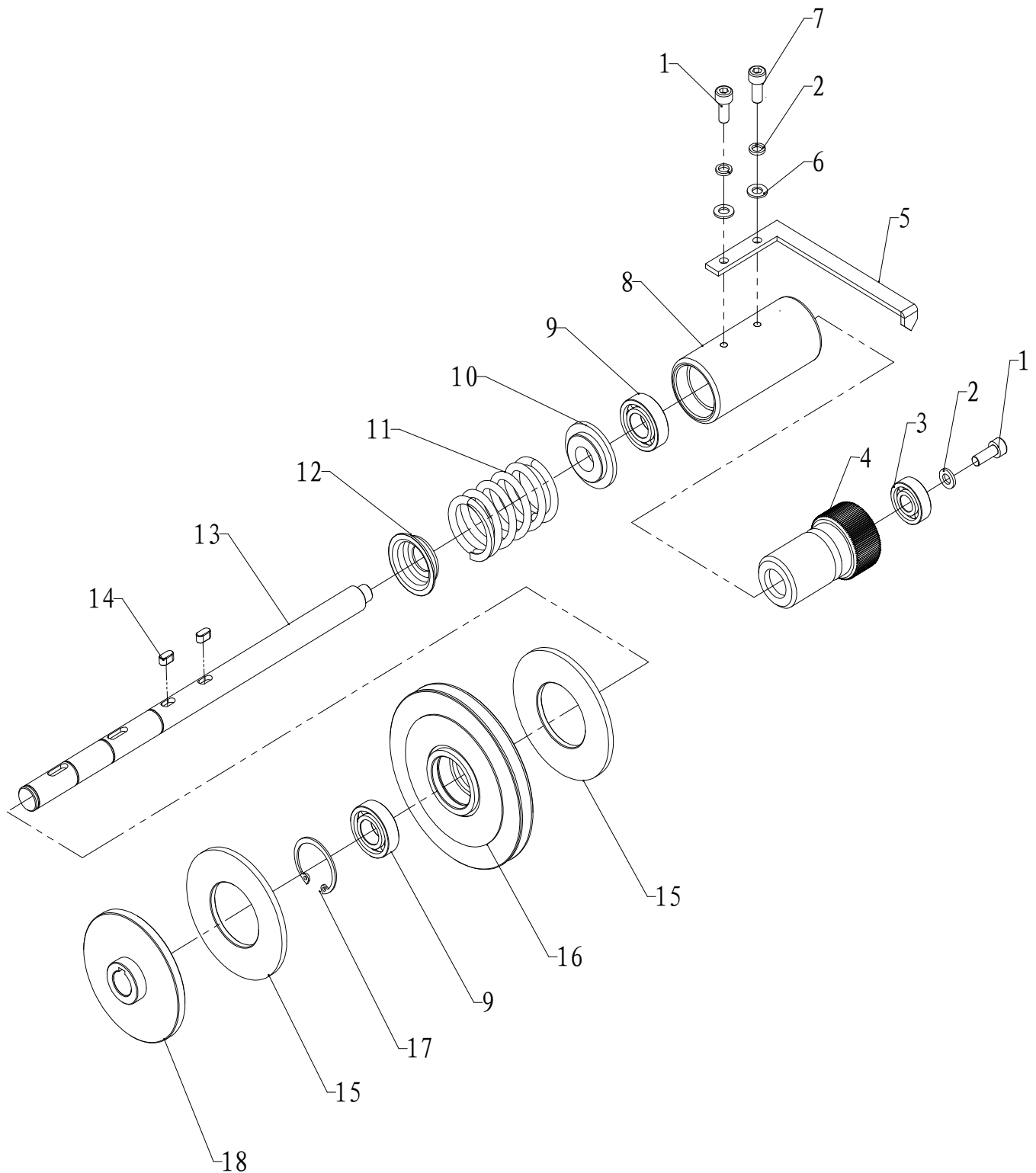
2.Lower bearing house assembly (-01.3.2)



No	Drawing NO	Description	QTY	Part No
1	-0614	Circlet	6	660006
2	GB/T894.1-1986	Ring 15	5	660463
3	-0512	Washer	2	660007
4	-0511	Washer	2	660008
5	GB/T276-1994	Bearing 6002-2Z	4	660439
6	-0504	Plastic gear 20 teeth	2	660001
7	-1501	Tightness adjustment shaft	1	660014
8	GB/T1096-79	Key A5x12	3	660491
9	GB/T819-2000	Flat head cap screw M4x6	6	660391
10	-0610	Strap guide 4	1	660023
11	-0609	Strap guide 3	1	660024
12	GB/T818-2000	Phillips head screw M4x10	8	660381
13	-0612	Strap guide 6	1	660022
14	-0618	Adjust plate	1	0618
15	-0611	Strap guide 5	1	660021
16	-0607	Steel roller	2	660004
17	GB/T818-2000	Phillips head screw M4x12	3	660580
18		Electron tension detector	1	660556
19	-0616	Magnet	1	660556
20	-0601	Lower bearing house	1	660013
21	GB/T894.1-1986	Ring 10	2	660461
22	-0604	Roller shaft	1	660018
23	-0603	Roller shaft	1	660015
24	-0606	Plastic gear 40 teeth	1	660020
25	-0615	Washer	1	660411
26	GB/T93-87	Spring washer 5	1	660421
27	GB/T70.1-2000	Socket head screw M5x12	1	660316
28	GB/T1096-79	Key C5x30	1	660489
29	-0613	Strap guide 7	1	660025

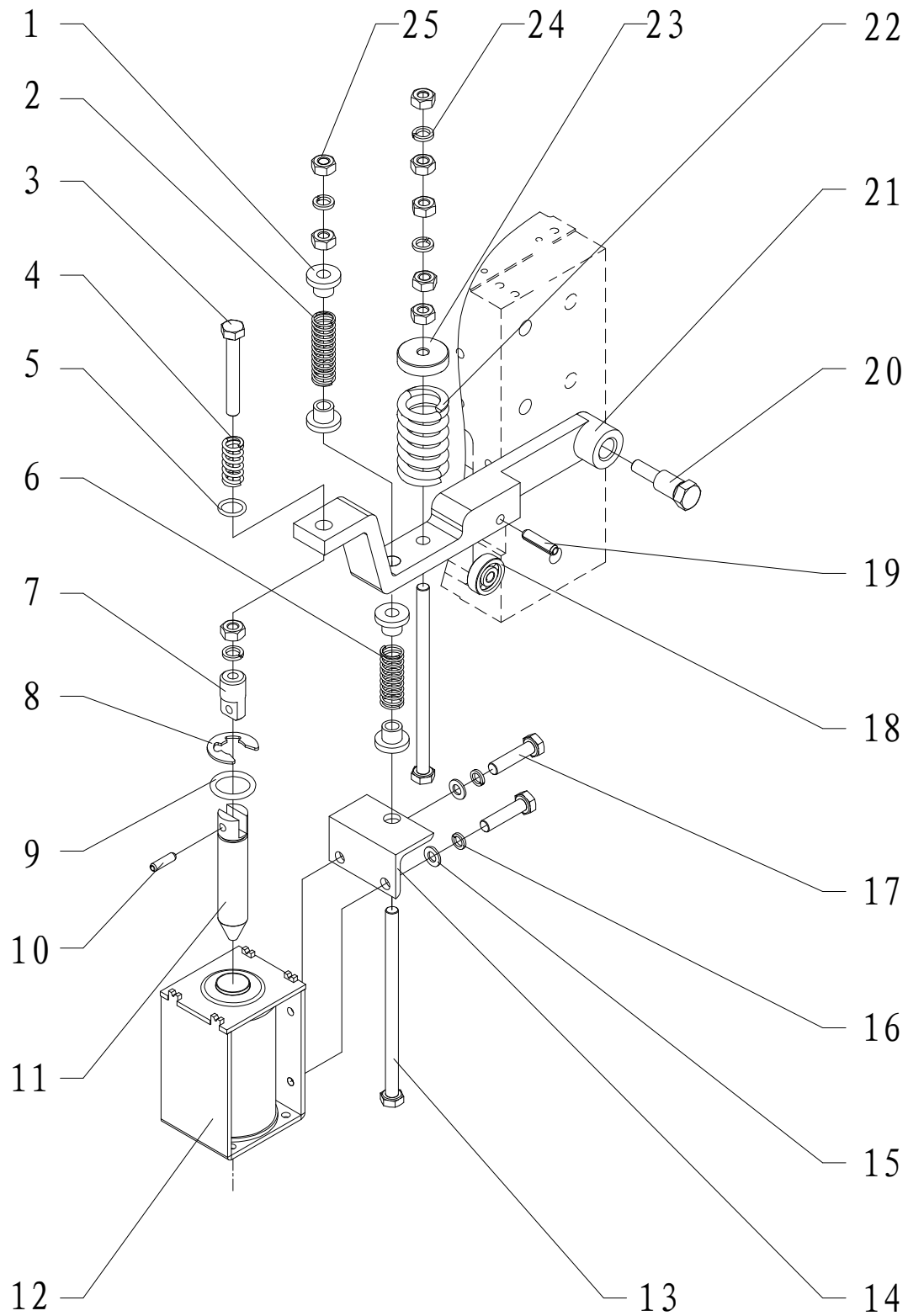
Note: NO.13.14.15 together to be an adjustable strap guide

3.Tension adjustent unit (-01.3.3)



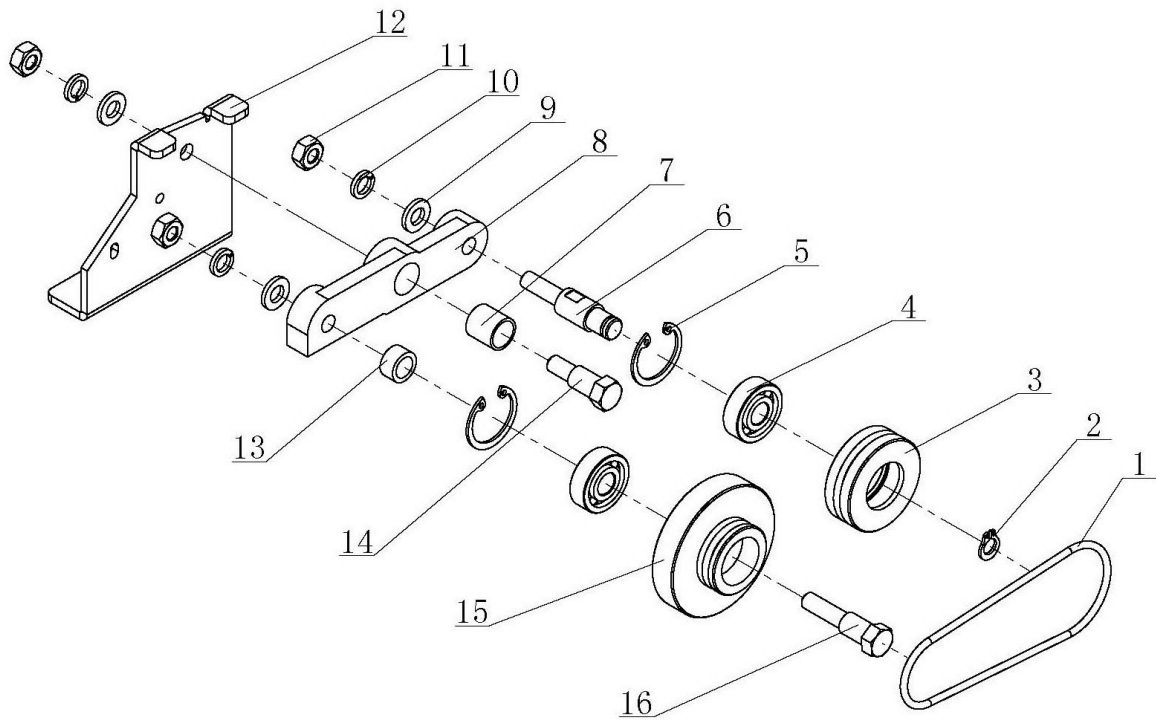
No	Drawing No	Description	QTY	Part No
1	GB/T70.1-2000	Socket head screw M6*12	2	660327
2	GB/T93-87	Spring washer 6	3	660422
3	GB/T276-1994	Bearing 6000-2Z	1	660437
4	-1502	Tightness adjustment nut	1	660030
5	-1504	Tightness adjustment L bar	1	661111
6	GB/T97.1-2002	Washer 6	1	660422
7	GB/T70.1-2000	Socket head screw M6*10	2	661113
8	-1503	Tightness adjustment sleeve	1	660029
9	GB/T276-1994	Bearing 6002-2Z	2	660439
10	-1505	Tightness adjustment cover	1	660028
11	-0706	Compression Spring	1	660031
12	-0705	Spring guide	1	660032
13	-1501	Roller shaft	1	661114
14	GB1096-79	Key 5*10	2	661115
15	-0704	Clutch disc	2	660033
16	-0701	Tightening pulley	1	660036
17	GB/T893.1-1986	Ring	1	660468
18	-0703	Tightening pulley	1	660034

9-1-4 Tension lever assembly (-01.4)



No	Drawing No	Description	QTY	Part No
1	-1017	Spring cover	3	660065
2	-1014	Compression spring	1	660064
3	GB/T5783-2000	Hex bolt M6*45	1	661116
4	-1014	Arm compression spring	1	661117
5	GB/T3452.1	O Ring 9*2.65	1	661118
6	-1016	Compression spring	1	660060
7	-1016	Solenoid shaft	1	660062
8	GB/T896-1986	Ring 12	1	660456
9	GB/T3452.1	O Ring 16*2.65	1	661119
10	GB/T119.1-2000	Pin 4*14	1	660475
11	-1007	Solenoid shaft head	1	660066
12		DC Solenoid 220V	1	660053A
		DC Solenoid 110V	1	660053
13	GB/T5783-2000	Hex bolt M6*105	2	661120
14	-1009	Solenoid angle plate	1	660067
15	GB/T97.1-2002	Plain washer 5	2	660409
16	GB/T93-87	Spring washer 5	2	660421
17	GB/T5783-2000	Socket head screw M6*25	1	660330
18	GB/T276-1994	Bearing 635	1	660436
19	GB/T119.1-2000	Pin 5*20	1	660477
20	-1011	Feed back arm screw	1	660058
21	-1010	Tension lever	1	660059
22	-1013	Compression Spring	1	660056
23	-1012	Adjusting nut	1	660057
24	GB/T93-87	Spring Washer 6	3	660422
25	GB/T6170-2000	Nut M6	8	660401

9-1-5 Round belt assly (-01.5)



No	Drawing No	Description	QTY	Part NO
1		Round belt $\phi 2.5 \times 190$	1	6600556A8
2	GB/T894.1-1986	Ring 8	1	660556A10
3	-1609	Pulley	1	6600556A4
4	GB/T276-1994	Bearing 608-2Z	2	6600556A9
5	GB/T893.1-1986	Ring 22	2	6600556A11
6	-1608	Small shaft	1	6600556A5
7	-1605	Copper sleeve	1	661122
8	-1604	Arm	1	6600556A2
9	GB/T97.1-2002	Plain washer 6	3	660422
10	GB/T93-87	Spring washer 6	3	661123
11	GB/T6173-2000	Hex nut M6	3	660401
12	-1607	Bracket	1	6600556A1
13	-1602	Washer	1	661124
14	-1606	Arm screw	1	6600556A3
15	-1601	Pulley	1	6600556A6
16	-1603	Shaft	1	6600556A7

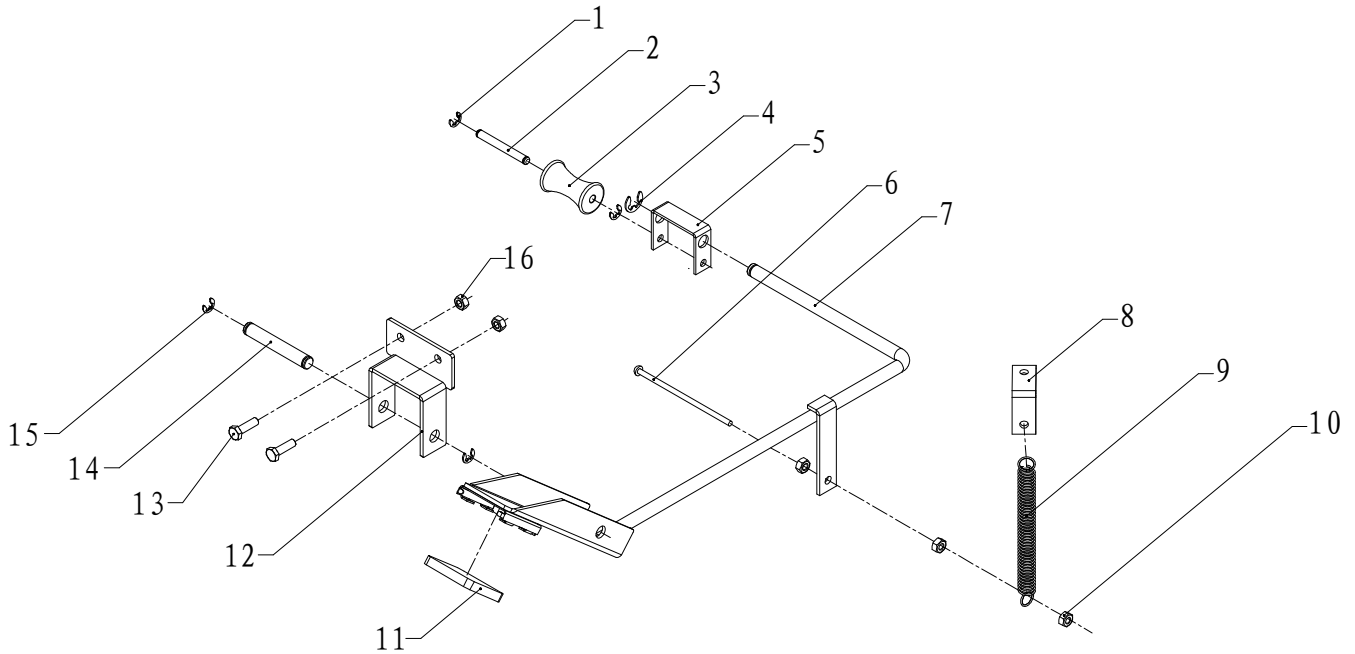
9-2 Brake assembly (-02)

Optional Mechanical brake assembly or Electrical brake assembly

Optional Normal model and luxury model for mechanical dispenser.

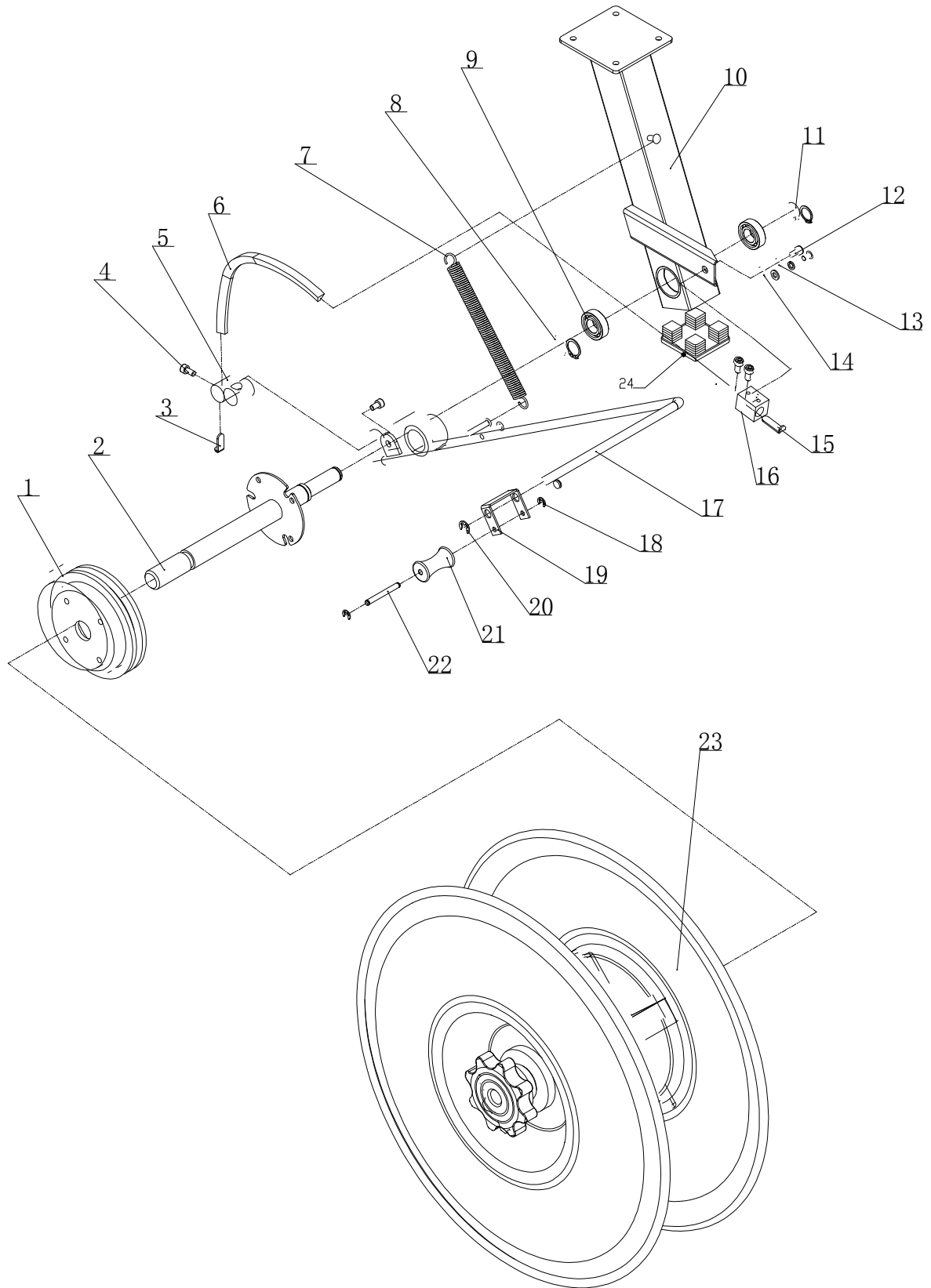
9-2-1 Mechanical brake assembly (-02-1)

1. Normal model



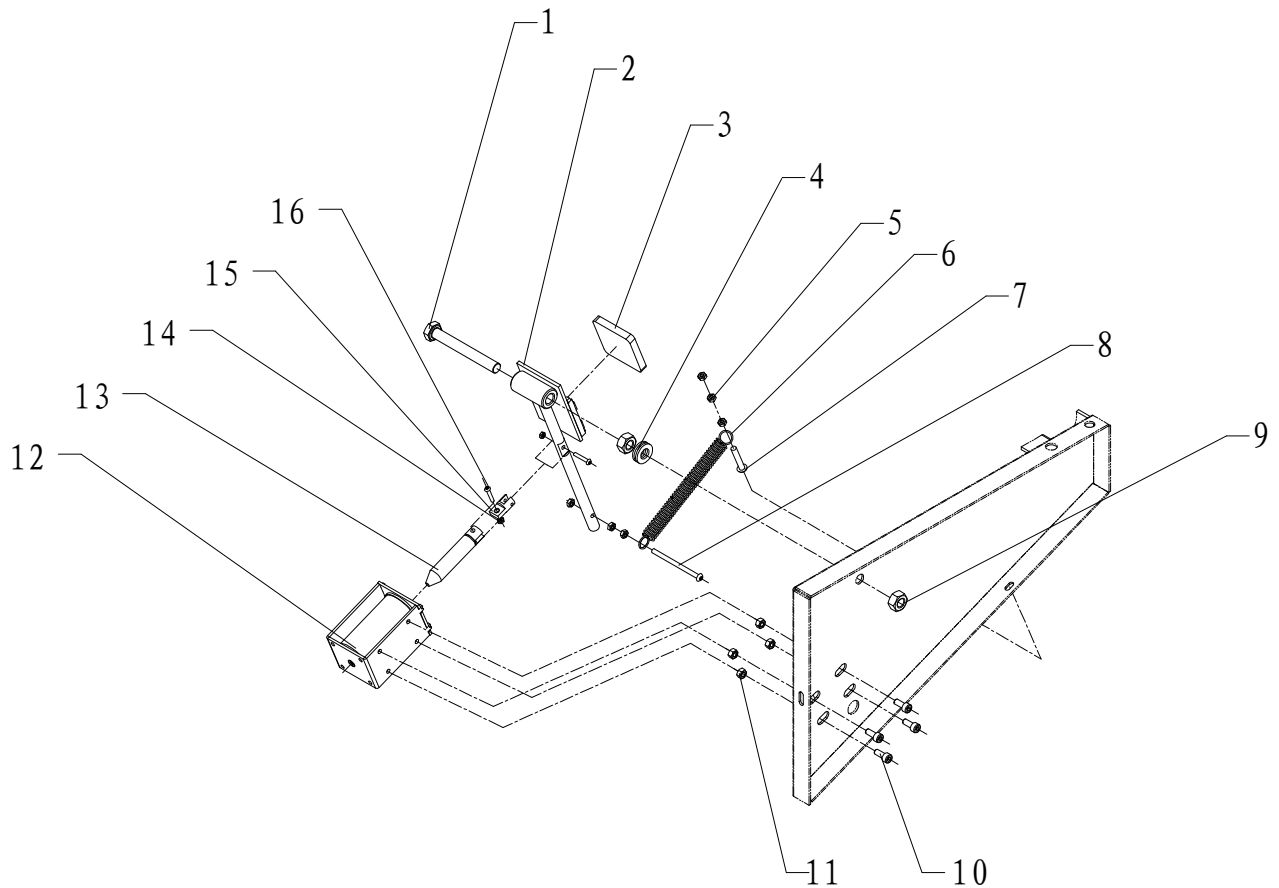
No	Part No	Description	QTY	Remark
1	GB/T896-1986	Ring E-6	2	660454
2	-1306	Brake pin	1	660110
3	-1307	Brake plastic roller	1	660109
4	GB/T896-1986	Ring E-11	1	661125
5	-1305	Brake roller frame	1	660108
6	GB/T5783-2000	Bolt M6x25	2	661126
7	-1300-1	Brake arm	1	660105
8	-1308	Brake L angle plate	1	660111
9	-1311	Brake Spring	1	660112
10	GB/T6172.1-2000	Nut M6	4	660401
11	-1310	Brake rubber	1	660106
12	-1300-2	Brake connection plate	1	661127
13	GB/T5783-2000	Bolt M6x20	2	660353
14	-1309	Brake fixed pin	1	660107
15	GB/T896-1986	Ring E-8	3	661129
16	GB/T6170-2000	Bolt M6	6	660401

2. Luxury model



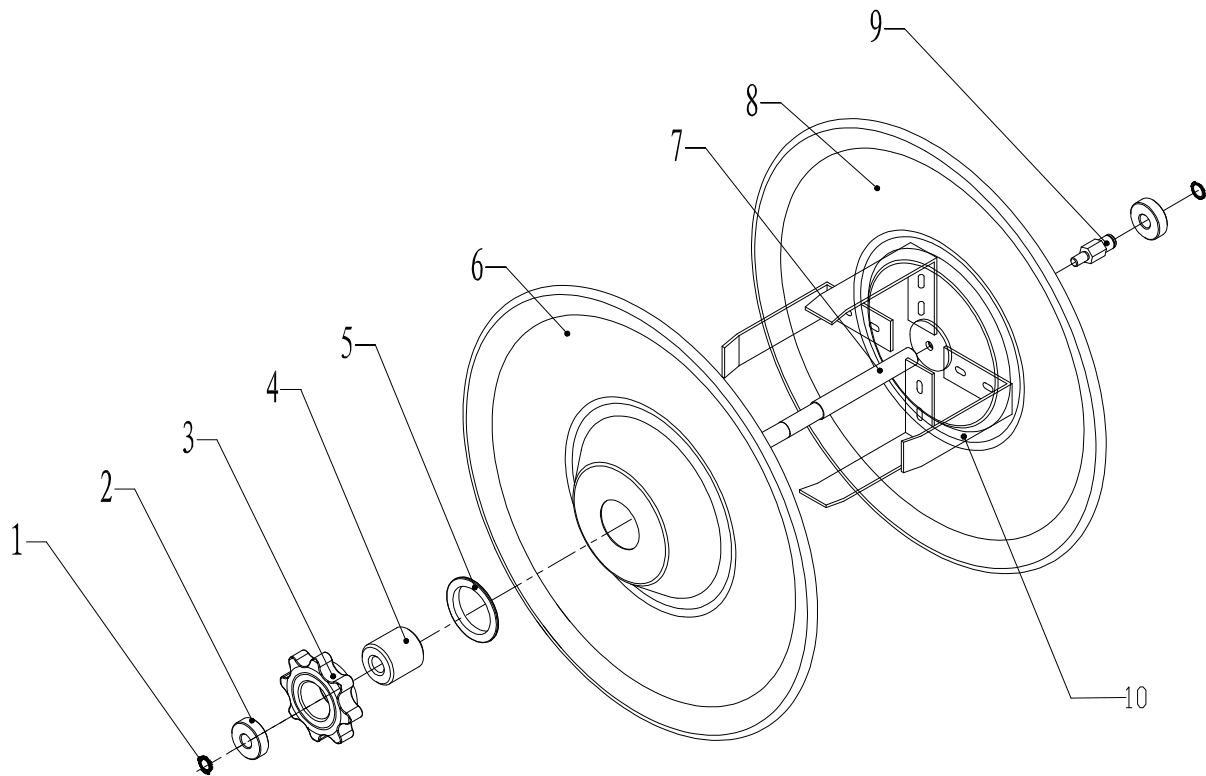
No	Drawing No	Description	QTY	Part No
1	XT8024-0213	Brake pulley	1	661131
2	XT8024-0200-2	Bracket	1	661132
3	XT8024-0207	Plate	1	661133
4	GB/T70.1-2000	Hex bolt M6×12	3	660351
5	XT8024-0206	Round joint	1	661135
6	GB/T11544	K-belt A260	1	661136
7	XT8024-0205	Spring	1	660618
8	GB/T894.1-1986	Ring 20	1	660464
9	GB/T276-1994	Bearing 6003-2Z	2	660440
10	XT8024-0200-1	Bracket	1	661138
11	GB/T894.1-1986	Ring 17	5	660460
12	GB/T70.1-2000	Hex bolt M6*10	2	661140
13	GB93-1987	Spring washer 6	1	661141
14	GB/T97.1-2002	Plain washer 6	1	661142
15	XT8024-0214	Plate	1	661143
16	XT8024-0215	Joint	1	661144
17	XT8024-0200-3	Bracket	1	661145
18	GB/T896-1986	Open Ring 6	2	661146
19	-1305	Roller frame	1	660108
20	GB/T896-1986	Open Ring E-10	1	660461
21	-1307	Brake roller	1	660109
22	-1306	Brake roller shaft	1	661147
23	XT8024-0200-4	Dispenser assly	1	1200
24		Plastic cover	1	

9-2-2 Brake assembly (-02-2)



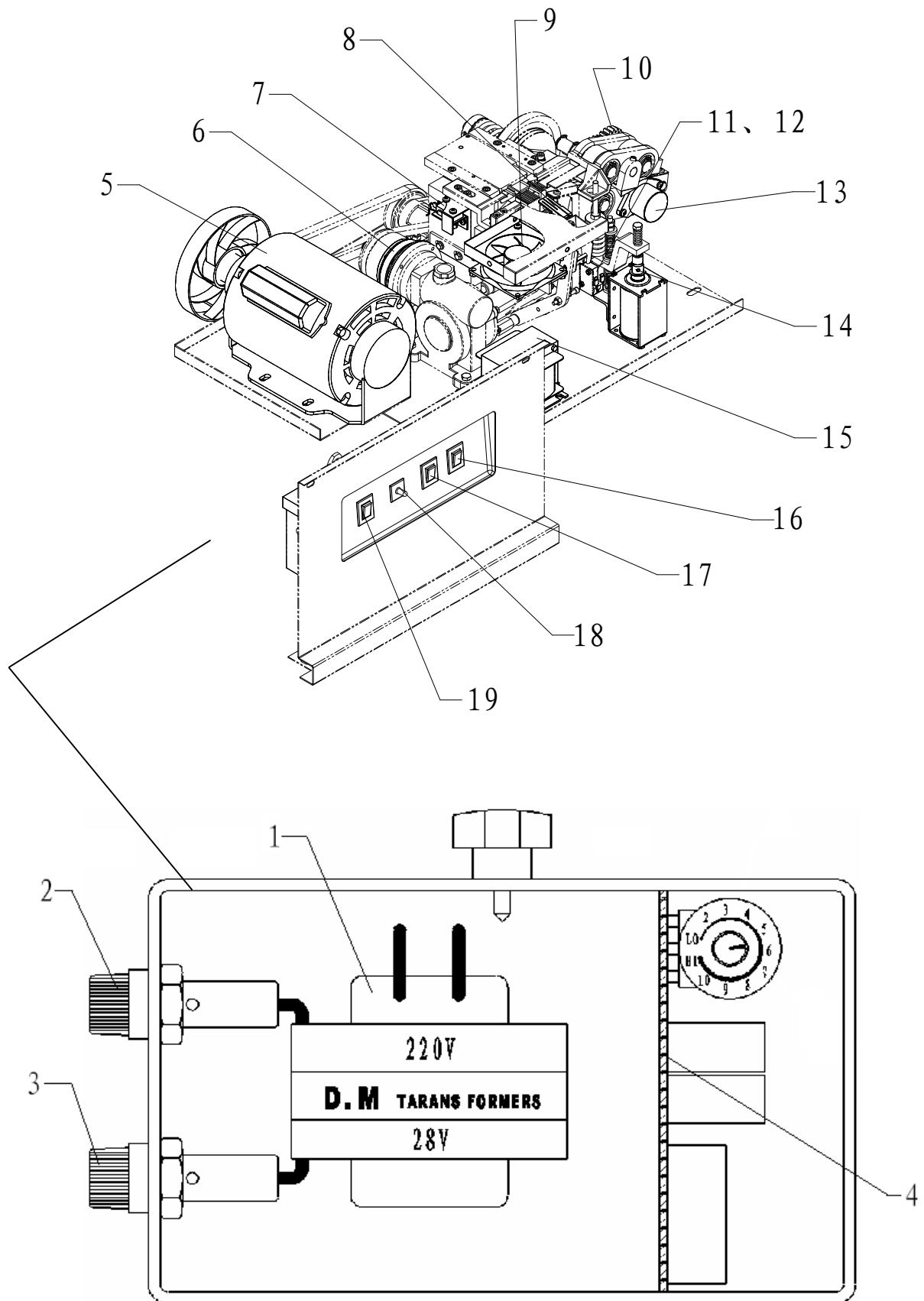
No	Drawing NO	Description	QTY	Part No
1	GB/T5783-2000	Bolt M10x80	1	660360
2	XT8021-0213	Brake Plate	1	660549
3	-1310	Brake rubber	1	660106
4	GB/T97.1-2000	Washer 10	2	660424
5	GB/T6172.1-2000	Nut M4	3	660399
6	-1311	Brake spring	1	660560
7	GB/T818-2000	Bolt M4x40	1	660368
8	GB/T818-2000	Bolt M4x50	1	660369
9	GB/T6170-2000	Nut M10	2	660403
10	GB/T70.1-2000	Bolt M5x12	4	660347
11	GB/T6172.1-2000	Nut M5	5	660400
12	-1000-1	DC Solenoid 220V	1	660053A
13	-1007	Solenoid shaft head	1	1007
14	GB/T6170-2000	Nut M3	2	660398
15	-0302	Solenoid shaft	1	0302
16	GB/T819-2000	Bolt M3x20	2	660367

9-3 Dispenser assembly (-03)



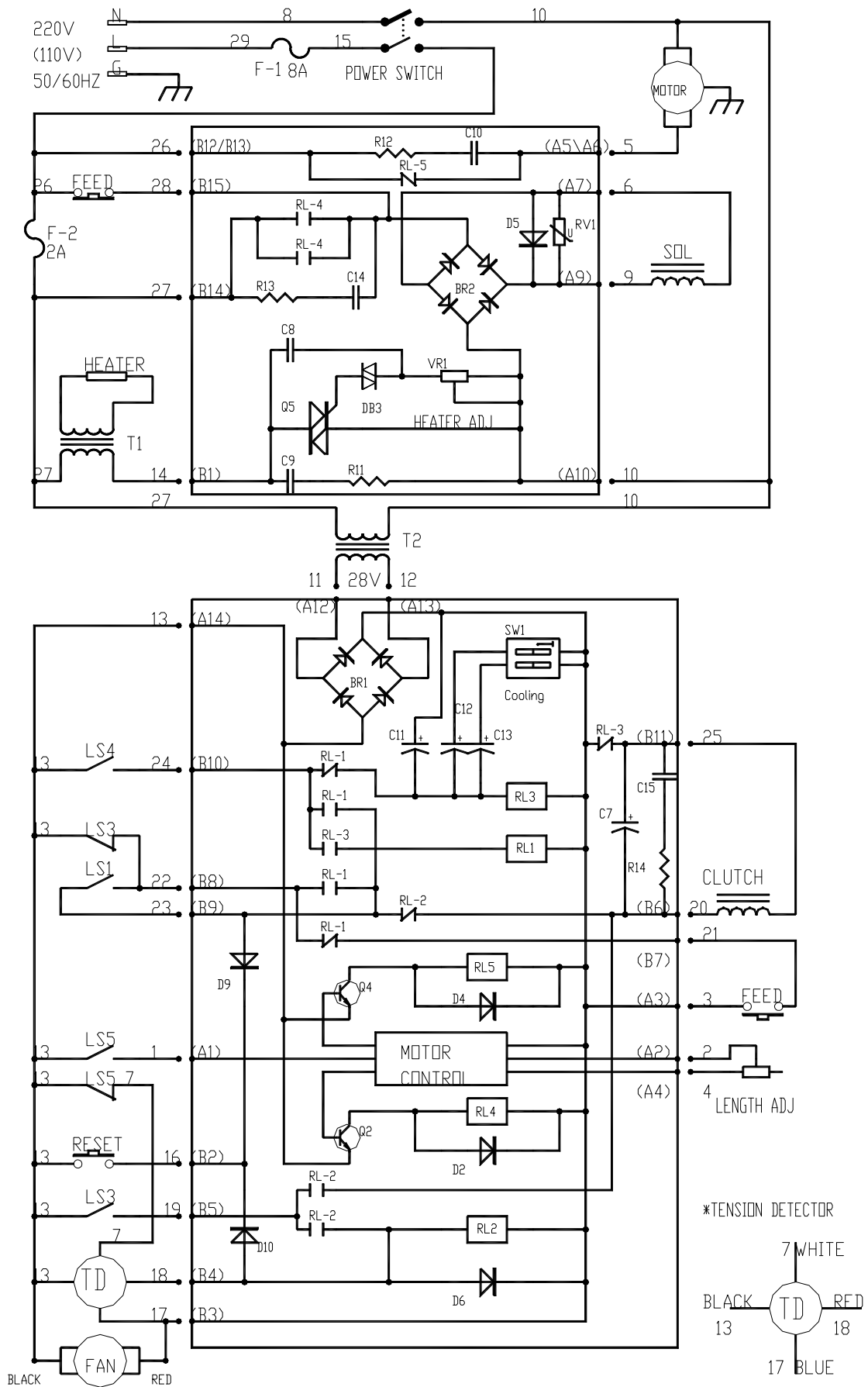
No	Drawing No	Description	QTY	Part No
1	GB/T894.1-1986	Washer 15	2	660550
2	-1212	Bearing	2	1212
3	-1210	Reel nut handle	1	660607
4	-1208	Screw	1	1208
5	-1209	Sleeve	1	1209
6	-1211	Left flange	1	660501
7	-1207	Reel shaft	1	660605
8	-1200-2	Right flange	1	660201
9	-1206	Screw	1	1206
10		Reel center drum	4	660502

9-4Electrical components (-DK)



No	Drawing No	Description	QTY	Part No
1		Transformer 110V	1	660179A
		Transformer 220V	1	660179
2	F-1	8A Fuse	1	660512A
3	F-2	2A Fuse	1	660207
4		PCB 110V	1	660519
		PCB 220V	1	660519A
5	4824	Motor 220V/0.25Kw/1450rpm	1	660165A
		Motor 110V	1	660165
6	Clutch	Clutch	1	660138
7	LS1	Microswitch LS1	1	660224
8	HEATER	Instant heating plate	1	660084
9	FAN	Smoke fan 24V/1.2W	1	660220
10	LS4	Microswitch LS4	1	660224
11	LS3	Microswitch LS3	1	660224
12	LS5	Microswitch LS5	1	660224
13	TD	Electron tension detector	1	660556
14	SOL	DC Solenoid 110V	1	660053
		DC Solenoid 220V	1	660053A
15	T1	Instant heating transformer 110V	1	660179
		Instant heating transformer 220V	1	660179A
16	FEED	Feed switch	1	660232
17	RESET	Reset switch	1	660231
18	Length ADJ	Potentiometer ,length adjust knob	1	660260
19	Power switch	Power switch	1	660225

10. Electrical schematic



ELECTRICAL SCHEMATIC