

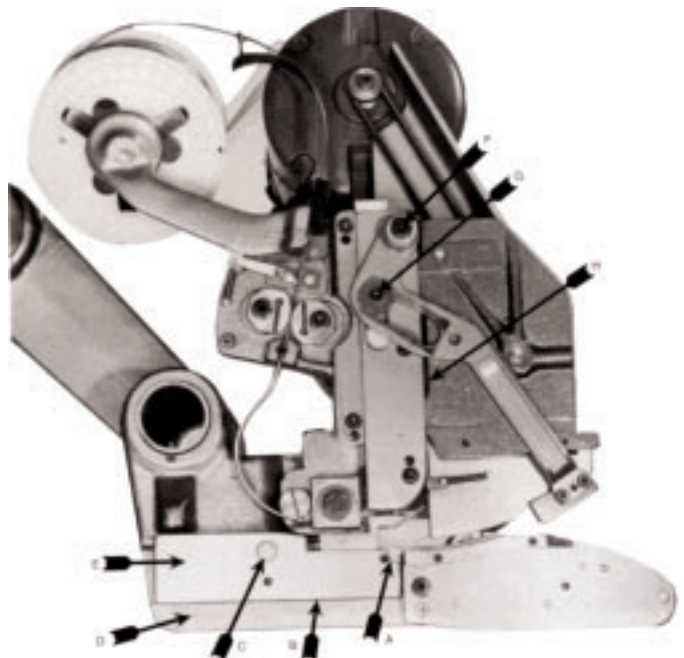
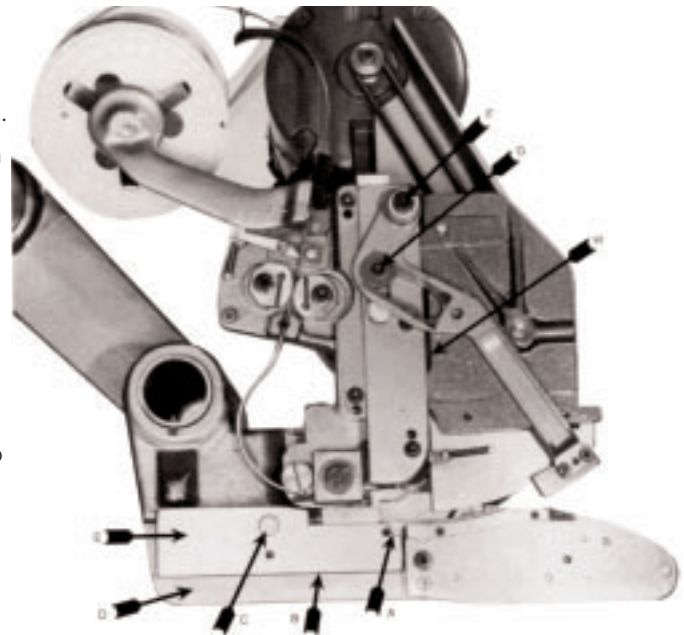
Uncrate machine and remove the rust preventative, which is used to protect the finished surfaces during shipment. Depress the solenoid armature G Fig. 3 and turn the machine over manually by means of the fly-wheel. The machine must turn freely at all times. **CAUTION** This machine is wired for 115 volts, 60 hertz, single-phase AC. Check line voltage before plugging in machine.

**WIRE**

Wire is furnished in coil form. It is wound on paper cores and a detachable spool is supplied for use with it. To put the wire on the spool, remove the wrapper (but do not cut the binding wires) and unscrew the loose flange of the spool. Put the wire in place with the end at the top pointing toward the left when looking at the threaded end of the spool hub. Securely tighten the loose flange. This machine can be supplied to operate with either #1 Hy-Bar (.020 x .060), #2 Hy-Bar (.024 x .060), #3 Hy-Bar (.028 x .060) or #18 Round wires. However, the wire feed must be adjusted when changing from one wire size to another. (See section under adjustments marked "Feed Rolls.")

**THREADING THE MACHINE**

NOTE: Figure 1 is an inverted view of the machine in the neutral position. Figure 2 is an inverted view of the machine in the threading position. Turn the machine over manually from the neutral position shown in Figure 1, until the feed rolls (C and C1) are open as shown in Figure 2. Caution: Always remove short end of wire from wire tube before threading wire from new spool. Place the spool on the spool stud so that the wire will unwind from the top with the end pointing toward the wire guide spring (A). Hold the end of the wire firmly, cut the binding wires and bend them back over the flanges. Clip off the end of the wire to remove kinks and to facilitate threading. Warning: Do not let go of the end of the wire as it will immediately unravel and become entangled. Pass the wire through the loop at the top of the wire guide spring (A) and under the oil pad (G) and then through the wire check (B). The purpose of the wire check is to prevent the wire from moving backward after feeding. It is of the utmost IMPORTANCE that the wire be in the wire check at all times to ensure even feeding. The wire check is opened by pushing the long end of the wire check pawl (B1). Push the wire through the wire tube (D) and into the slot in the stationary cutter clamp (E). Release the wire check pawl and the machine is ready for operation.

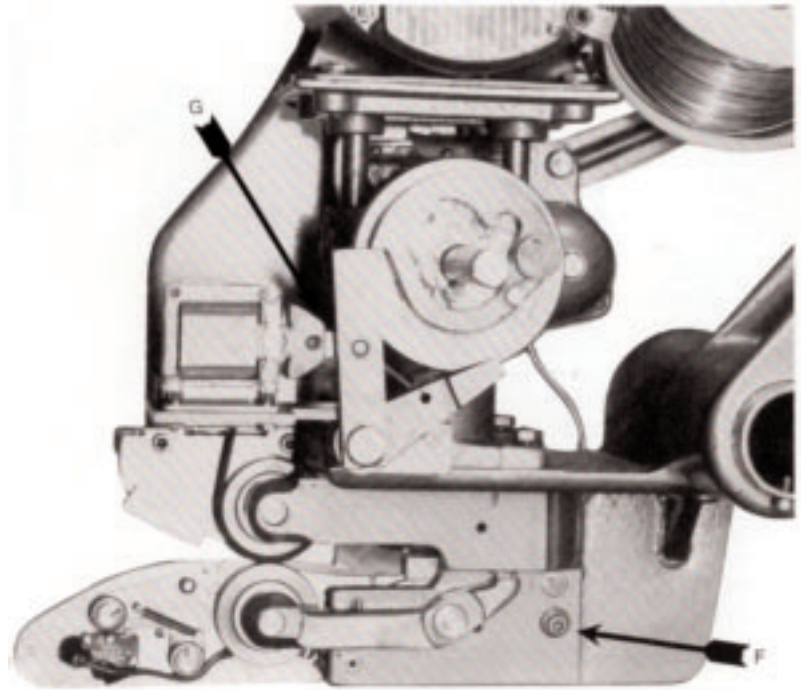
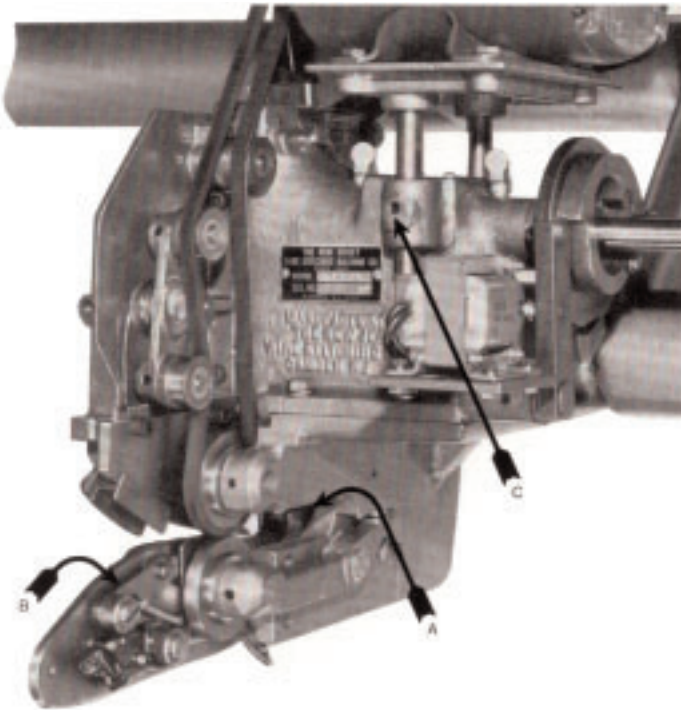


**SET UP AND OPERATION IN LINE**

For a satisfactory operation, the closer should be installed over a right angle take-away belt having a speed of 40 to 75 feet per minute. A variable speed drive is recommended. If the belt speed is too slow, one bag will not clear the closing head before the next bag enters. Adjust the height so the bottom of the closer head clears the product in the bag to be closed by about 1½". If the closer is too low, the product will jam at the entrance of the closer and cause torn bags. If adjusted too high, each bag must be lifted and will slip down in the closer causing a loose or partial closure. It is suggested the pedestal column be marked as the ideal adjustment for each bag is established.

### FEEDING THE BAG

With thumb and finger on each top corner of the bag, lift slightly (just enough to take the slack out of the top of the bag) and guide it into the closer. Do not force or push bag in - let the closer pull the bag in. The bag should be in a vertical position as it enters the closer. Do not tip it forward into the closer. Caution: If the machine should stall, turn off switch and rotate flywheel by hand to relieve jam.



### LUBRICATION

The right angle oilers in the head casting lubricate the internal mechanism in addition to the main shaft bearings. Be sure to lubricate regularly with a good grade of oil. The flywheel has a bronze bushing. An oil hole is provided at the hub.

The pusher arm travels at a relatively high speed, therefore, a light fibrous grease that will adhere to the parts is recommended for the roller and cam slot.

The micro switch actuating mechanism (B Fig. 4) is fitted with self-lubricating bearings. Because of its sensitivity, 3 in 1 oil or an equivalent should be used.

The function of the oil pad attached to the wire guide spring is to remove foreign matter and loose coating from the stitching wire and to lubricate the wire prior to the stitching operation. Oil the pad thoroughly once each eight (8) hour shift. Warning: If the pad is allowed to become dry or clogged up, the coating from the wire may charge in the former grooves and ultimately result in defective staples. Important: Whenever replacing parts, make certain that they are well lubricated.

### ADJUSTMENTS

Always turn the machine over manually after making adjustments or repairs. **This is IMPORTANT.** Be sure it turns freely before using power.

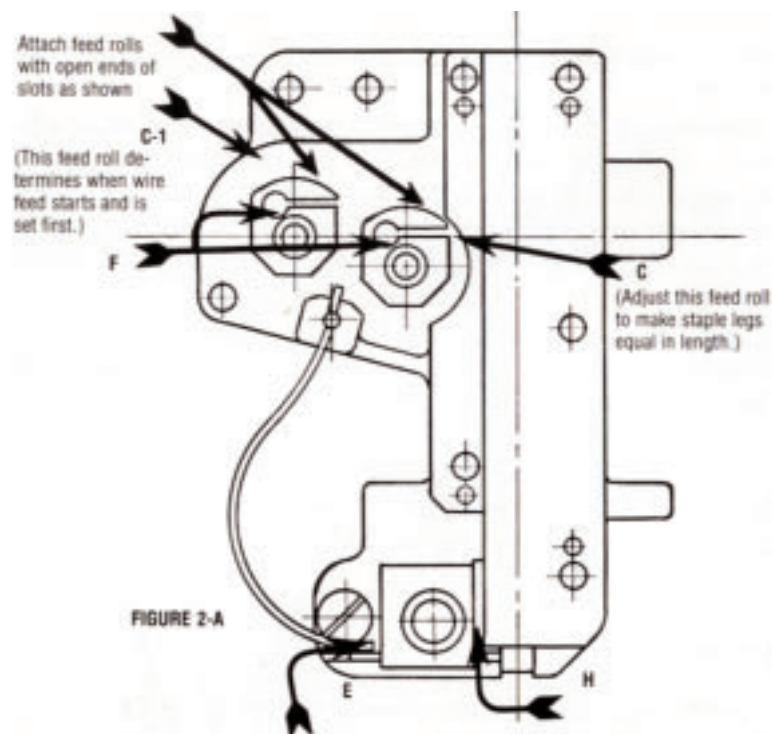
**Arm:** The arm (B Fig. 1) pivots on pin (C) and can readily be adjusted to accommodate various work thicknesses. The arm adjusting screw, Pt. No. 1411, is located at point "D", Fig. 1 and a lock screw at point "F", Fig. 3. To set the arm up (for tight staples), loosen the arm lock screw and set screw at point "E", Fig. 1, in the end of the arm. Turn the adjusting screw clockwise until the desired staple tightness is obtained. Then securely tighten the arm lock screw and set screw. To set the arm down (for loose staples) proceed as above except turn the arm adjusting screw counterclockwise.

**Clincher:** The clincher (A Fig. 1) is double-ended and fits in a slot in the end of arm (B Fig. 1). To align the clincher, set it in the slot in the arm and turn the machine manually until the legs of the staple strike the grooves in the clincher. Move the clincher to the right or left until the grooves are centered with the staple legs. Then, securely tighten the clincher set screw.

**Feed Rolls:** The left feed roll (C1 Fig. 2) starts the wire feed at the proper time. It is set at the factory and unless it must be replaced, should not be moved. The right feed roll (C Fig. 2) determines the length of the wire feed and therefore must be adjusted whenever the length of wire is changed. To adjust the length of wire feed, loosen the feed roll clamp screw (F Fig. 2). To increase the wire feed, turn the feed roll (C) clockwise. To decrease the length of feed, turn the feed roll (C) counterclockwise. When changing the wire feed, make certain that the staple legs are of equal length. When replacing the feed rolls, proceed as follows. Place the feed rolls on the shaft with slotted ends in the position shown in Fig. 2A. Do not tighten the feed roll clamp screws. Thread the machine. Then engage the clutch by depressing the solenoid armature (G. Fig. 3). Turn the machine manually until the lower end of the former cutter, Pt. No. 1004-3 1/2 (H Fig. 2 and 2A), is slightly above the wire slot in the stationary cutter clamp (E) on the upward stroke of the former assembly, Pt. No. 1004-201. Turn feed roll (C) until the ground surface is against the wire. Turn feed roll (C1) clockwise until the leading edge (slotted end) is in contact with the wire. Securely tighten feed roll (C1) in the position. The wire feed is now properly timed. Adjust feed roll (C) until the staple legs are equal in length and then securely tighten it. Do not attempt to move the feed rolls by inserting a tool in the slots - breakage will result.

**Cutters:** Both cutters, Pt. No. 1004-3 1/2 Former Cutter and Pt. No. 1004-201 Stationary Cutter, have four cutting edges and can readily be changed as they become dull. To change the cutters, turn the machine manually until the lower end of the former cutter (H Fig. 2) is below the stationary cutter (J). Remove stationary cutter clamp screw (K). The stationary cutter clamp (E) can then be detached and both cutters can be changed. When assembling the stationary cutter clamp, make certain that both the clamp and the stationary cutter are set tightly against the former cutter before tightening the stationary cutter clamp screw.

**Belts:** The upper belt, Pt. No. 1043 "V" Belt, should be adjusted occasionally to prevent slippage. This is accomplished by loosening the set screws at point "C", Fig. 4, and sliding the motor out until the belt is sufficiently tight. The lower belt, Pt. No. 1423 Feeder Belt, is equipped with a spring-actuated compensator and is self-adjusting.



### *FORMING & DRIVING UNIT*

When replacing the former assembly, driver or former and driver links, it is necessary to remove this unit. This is accomplished as follows:

1. Remove feeder belt, Pt. No. 1423.
2. Depress the anvil and supporter, Pt. No. 1407 (A Fig. 4), and insert a small pin between the supporter and the head casting to hold the anvil and supporter plunger, Pt. No. 1408, in place.
3. Remove pusher arm stud (F Fig. 1) and the pusher arm roller screw (G) and detach pusher arm assembly.
4. Remove the three screws which hold former guide plat (H Fig. 1) the former guide plate (H) and side plate, Pt. No. 1403, can be detached as one unit. The forming and driving unit can now be removed. The driver, Pt. No. 140<sup>5</sup>, can be replaced by removing the driver shoe pin, Pt. No. 1406. This pin should be driven out from right to left with the cutter side of the former assembly, Pt. No. 1<sup>5</sup>201, on the right. When inserting a new driver, make certain that the beveled end is up.

### *TROUBLE SHOOTING*

#### **If bag goes through without forming staple:**

Wire spool may be empty. Wire may be caught on spool. Spool may be binding. Wire may be bent or kinked. Feed rolls may be loose (see instructions for adjusting feed rolls).

#### **If staple is not formed properly:**

Check leg length - they must be equal. Check clincher alignment (see instructions). Be sure felt pad is oiled.

#### **If bag does not feed into closer easily:**

Closer may be too low. Feeder belt may be dirty or slippery. Feeder roller arm may not allow feed roll to contact feed belt.

#### **If machine continues to recycle without bag:**

Bearing in flywheel may be dirty (oil). Clutch trigger assembly may be stuck. Micro switch may be out of position.

#### **If machine will not cycle when bag is fed in:**

Micro switch or solenoid may be defective. There may be a break in the wire or connections from toggle switch to micro switch and solenoid.

#### **If bags tear -**

##### *The causes are:*

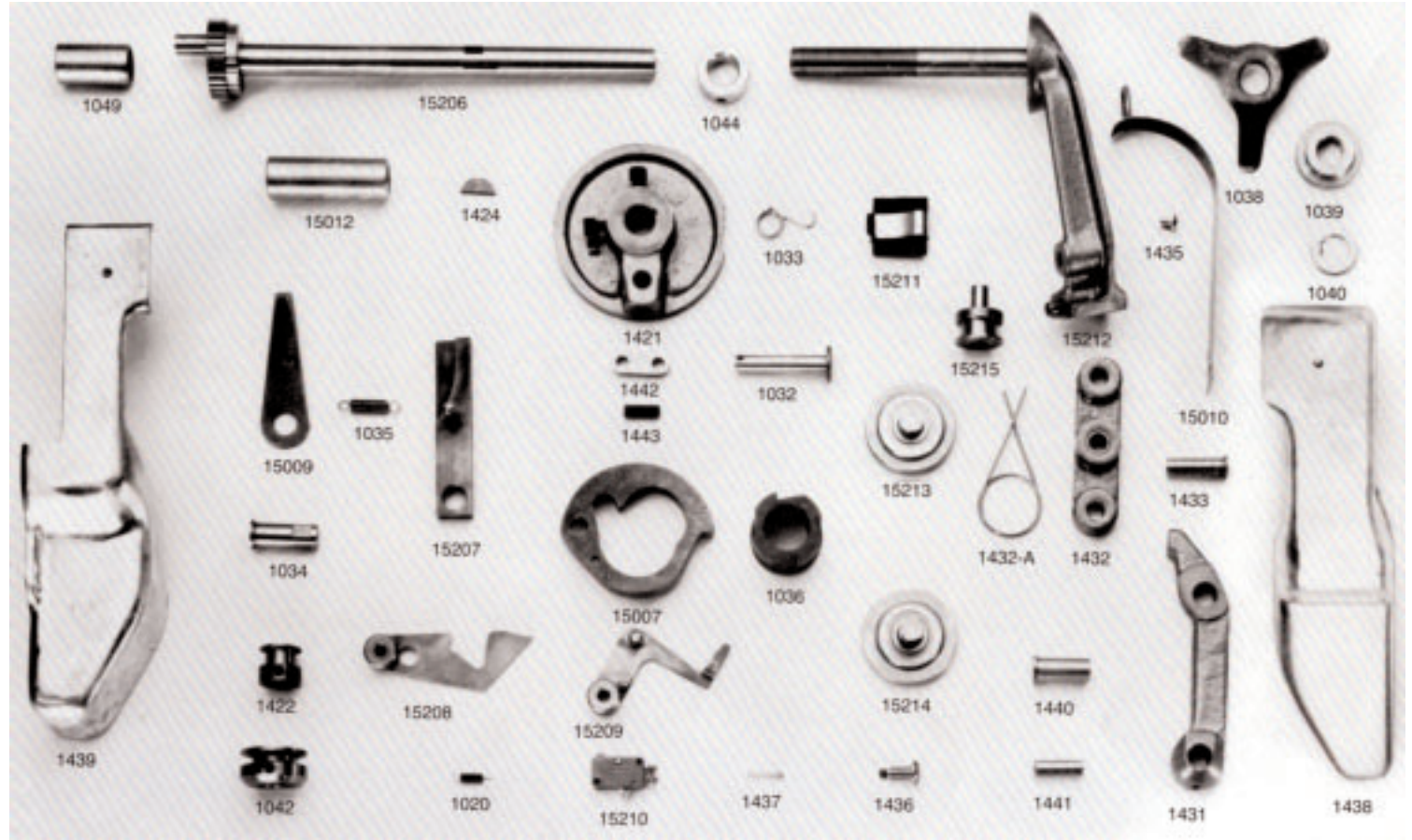
1. Bags closed too close to product
2. Staple clinched too tight.
3. A burr or rough edge on a part of the closer.

##### *The cures are:*

1. Raise the closer slightly so that product in bag clears the underside of the closer and pusher arm. As the pusher arm gathers the bag, the bag is tightened around the product. Don't make it too tight. When the correct height is established, mark the pedestal column so when next running the same size bag, the closer can be quickly set to the correct height. Do this for each size bag.
2. The staple should be clinched just tight enough to keep it from sliding off easily. If you adjust the arm (see instructions, top of page 4) so the staple is just tight enough for the smallest bag, the largest bag can also be closed with no further adjustment.
3. Every precaution is taken to eliminate burrs or sharp edges along the path of the bag through the machine. Occasionally, however, bag cutting or tearing will occur because of a sharp edge contacting the side of the bag as it is gathered and fed in the closer. Check for the exact line of cutting, and with fine emery cloth, remove the sharp edge and polish. Also check the feeder belt for sharp or rough edges.

NO.	NAME
1020	Latch & Guide Finger Spring
1421	Clutch Disc
1032	Clutch Ring Pin
1033	Clutch Ring Spring
1034	Clutch Trip Lever Pivot Pin
1035	Clutch Trip Lever Spring
1036	Clutch Ratchet
1038	Spool Spring
1039	Spool Stud Nut
1040	Spool Stud Lug Washer
1042	Pulley ("V" Belt)
1043-L	"V" Belt (5504) (not shown)
1043-S	"V" Belt (5589) (not shown)
1044	Main Shaft Collar
1049	Main Shaft Bushing
1422	Pulley (Feeder Belt)
1423	Feeder Belt (not shown)
1423-A	Feeder Belt (not shown)
1424	Main Shaft Key
1431	Feeder Roller Arm
1432	Feeder Belt Tightener
1432-A	Feeder Belt Tightener Spring
1433	Feeder Belt Tightener Pin

NO.	NAME
1435	Wire Guide Spring Screw
1436	Trigger & Latch Screw
1437	Micro Switch Screw
1438	Front Cover
1439	Rear Cover
1440	Feeder Roller Arm Pin
1441	Feeder Roller Arm Plunger
1442	Solenoid Link
1443	Solenoid Armature Pin
15007	Clutch Ring Assembly
15009	Clutch Retaining Lever
15010	Wire Guide Spring Assembly
15012	Driving Pulley Bushing
15206	Main Shaft Assembly
15207	Clutch Trip Lever Assembly
15208	Trigger Assembly
15209	Latch Assembly
15210	Micro Switch
15211	Oil Pad Assembly
15212	Spool Bracket Assembly
15213	Feeder Roller Assembly (Small)
15214	Feeder Roller Assembly (Large)
15215	Feeder Belt Tightener Pulley Assembly



**In ordering please give both name and number of part and wire size where specified, as well as serial number of machine.**

NO.	NAME
1402	Former Guide Plate
1403	Side Plate
1003	Former and Driver Link
1004-3	½ Former Cutter 7/32" thick
1005	Stationary Cutter
1006	Stationary Cutter Clamp (specify wire size)
1404	Stationary Cutter Clamp Screw
1008	Stationary Cutter Clamp Washer
1405	Driver (specify wire size)
1406	Drive Shoe Pin
1407	Anvil & Supporter (specify wire size)
1012	Anvil & Supporter Pivot Pin
1408	Anvil & Supporter Plunger
1014	Anvil & Supporter Plunger Spring
1016	Wire Check Body
1017	Wire Check Pawl (specify wire size)
1218	Wire Check Spring
1018	Wire Check Body Screw
1019	Wire Check Pawl Screw
1021	Wire Tube
1022	Wire Tube Adjusting Screw
1023	Wire Tube Clamp Screw
1024	Wire Tube Clamp Nut

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1012	Anvil & Supporter Pivot Pin
1408	Anvil & Supporter Plunger
1014	Anvil & Supporter Plunger Spring
1016	Wire Check Body
1017	Wire Check Pawl (specify wire size)
1218	Wire Check Spring
1018	Wire Check Body Screw
1019	Wire Check Pawl Screw
1021	Wire Tube
1022	Wire Tube Adjusting Screw
1023	Wire Tube Clamp Screw
1024	Wire Tube Clamp Nut

