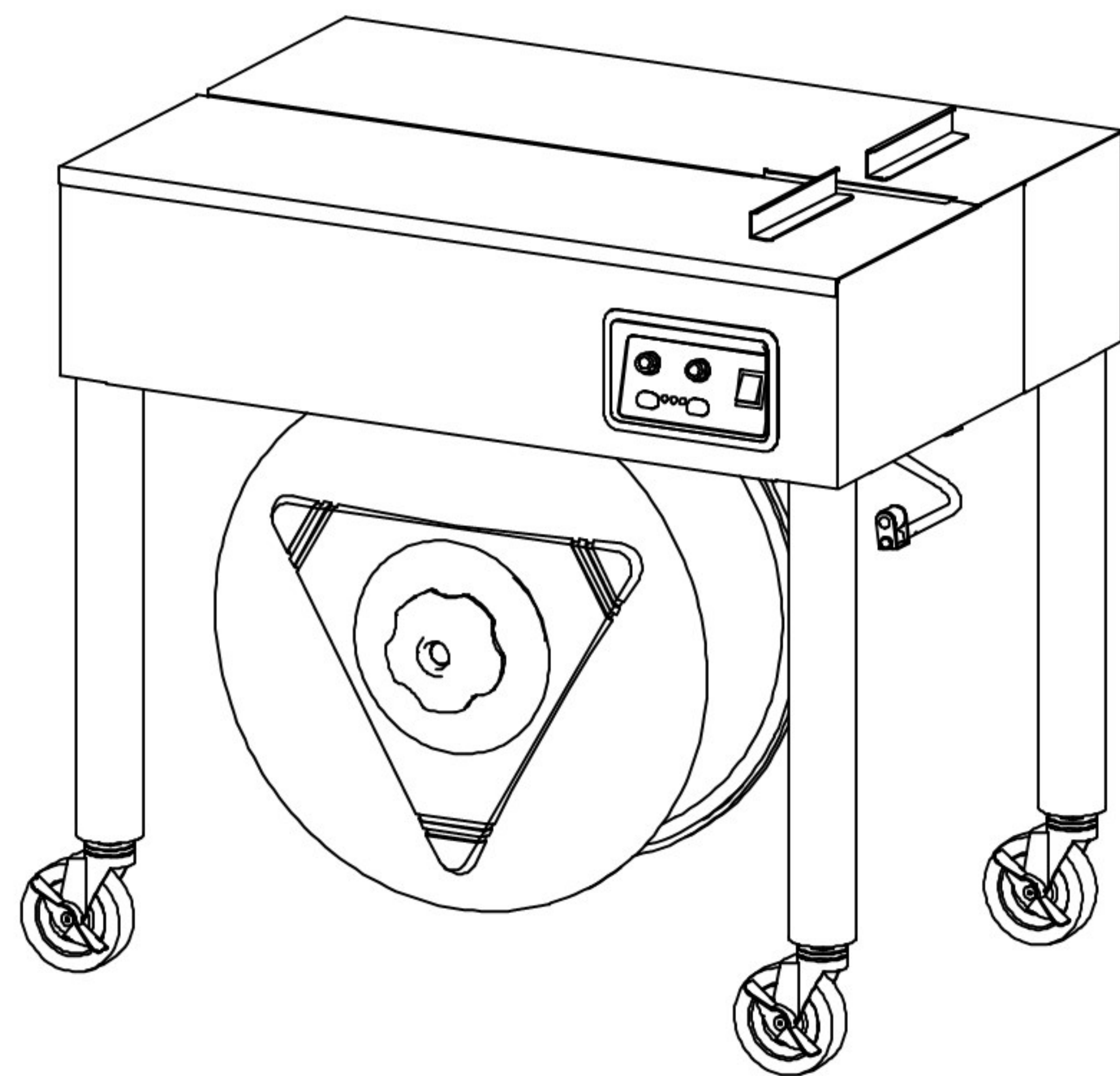


AS

PACK

A 55X

ORIGINAL INSTRUCTION MANUAL
PARTS LIST



**IMPORTANT
DO NOT DESTROY**

- Read Carefully and understand safety Instructions before operating your strapping machine.
- Keep this instruction manual in a convenient location for us at any way.

NO.1

656-1F-02001-01

Preface

Thank you very much for your purchase of a ASIPTPACK STRAPPING MACHINE. We are prepared to offer extensive after sales service for our products through our distribution network.

To effectively maintain and use this strapping machine, daily maintenance and proper operation are critical. Please carefully read and follow all of the instructions outlined in this instruction manual for proper long term use and maintenance of the machine.

Also, please carefully read the separate leaflet “Check that Seal!” to prevent any accidents during operation.

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Safe Operation

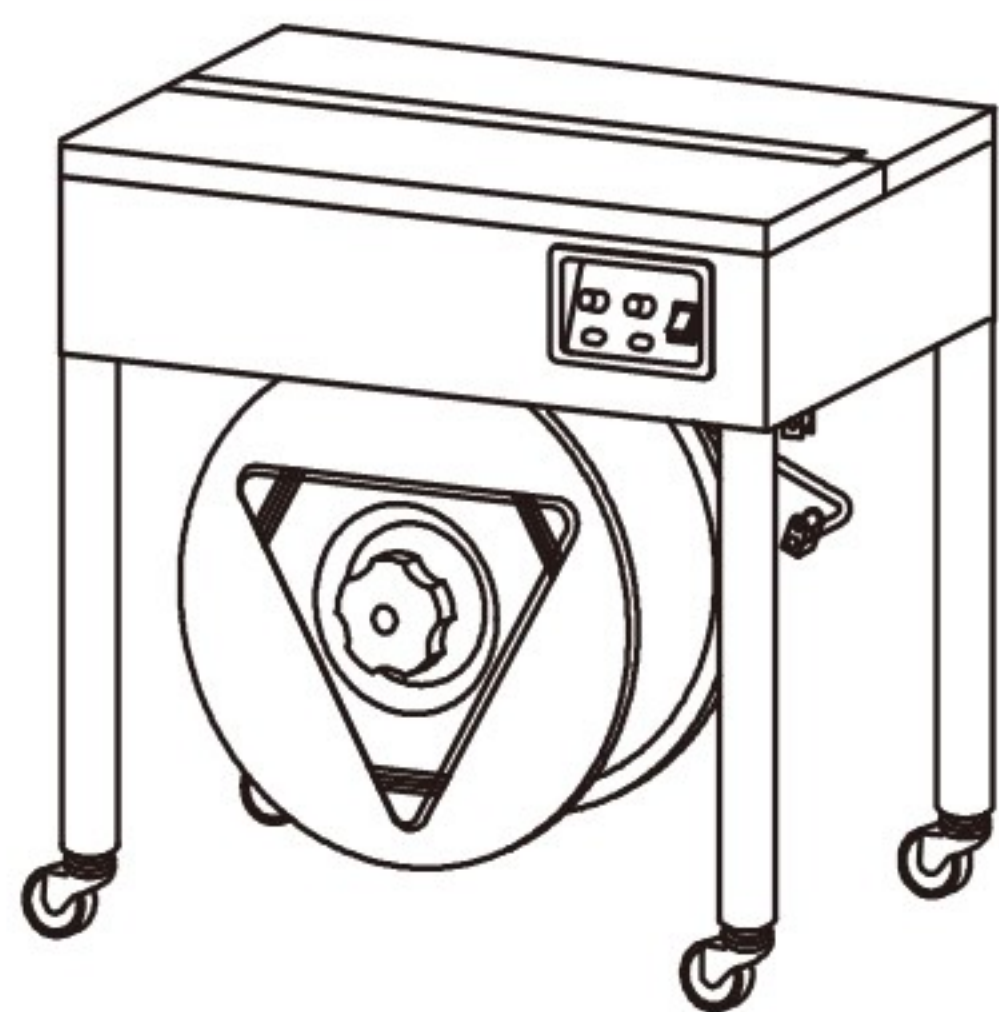
This Instruction Manual has been prepared in order to provide you with important operational, maintenance and safety information relating to your machine. It is essential that you read and understand this paragraph carefully before you attempt to operate your machine. The Symbol  is used as a safety warning mark. Carefully read and follow the remarks and instructions given with this symbol.





Warning Marks  in this manual are defined as follows:

 DANGER	Personal danger: DANGER indicates a potentially hazardous situation which, if not avoided, could result in death.
 WARNING	Personal danger: WARNING indicates a potentially hazardous situation which, if not avoided, could result in serious injury
 CAUTION	Possible damage to equipment: CAUTION indicates a potentially hazardous situation which, if not avoided, may result in minor or moderate injury

Safety Warning Labels

The warning labels shown below are affixed to the machine. The contents of these labels are defined below. Carefully read and understand this instruction manual and follow the accompanying the warning labels and instructions. If they are damaged or become illegible, you are required to replace them as soon as possible.



<p>DANGER from electric parts</p> 	<p>Do not touch the Control Box, Main Transformer or Heater Transformer while power is on. Do not touch exposed Power Supply Cable, wires or terminals.</p>
<p>WARNING Heater in Sealing Unit</p> 	<p>High temperature (about 400°C) of the Heater can burn. Do not touch Heater. After turning off the Power Supply Switch, it is necessary to avoid heater until it has cooled down.</p>
<p>CAUTION</p> 	<p>Once a strap cycle is activated, immediately let go of the strap. Your hand may get caught between the strap and package, which may cause injury.</p>
<p>GENERAL CAUTION</p> 	<p>Carefully read and understand Manual. Before removing the upper tables, repairing or adjusting anything, turn off the Power Select Switch and unplug the Power Supply Cable. Follow all instructions on the warning labels.</p>

Precautions during Installation

[Location]

⚠ WARNING

- Never leave the Power Supply Cord on the ground where equipment, such as forklift trucks or trolleys will pass. An exposed or damaged cord can cause electrical shock.
- Do not place the Power Supply Cord near the strapping, strap coil, or Reel Unit. Fast moving strap and rotating Reel can damage or break the cord. An exposed or broken cable cord can cause electrical shock. Replace any damaged cord immediately.
- Do not place the machine in a place where water and oil might splash. Water or oil can cause electrical shock or malfunction.
- Do not place the machine in a freezer room or in a place where the temperature may change drastically. Drastic temperature changes can cause electrical shock or malfunction.
- Locate and operate the machine within the appropriate temperature range (-10C - +40C). If the temperature is too low, electrical components may freeze or condensation may occur, which can cause electrical shock or malfunction. Excessively high temperature can cause malfunction.

[Installation]

⚠ WARNING

- Always use the Power Supply Cord provided with the machine.
- Make sure to connect to an electrical outlet which is equipped with an Ground Leakage Breaker.
- Never connect or disconnect the Power Supply Plug with wet hands. It can cause electrical shock.
- Make sure that a ground wire is properly connected. In case you cannot use a 3-prong plug, attach the 2-prong Plug Attachment (found inside the Tool Box) to the plug and connect the ground wire to the ground terminal. If the outlet has no ground terminal, be sure to connect the ground wire to a ground terminal on the floor.
- Before connecting or disconnecting the ground wire, make sure to unplug the Power Supply Cord first. Connecting and disconnecting the ground wire while the power is connected can cause electrical shock.

- Never connect the ground wire to a gas pipe. It may cause an explosion or fire.
- Do not connect the ground wire to a water pipe. The ground wire may not work properly.
- Be careful while handling strap. Strap can cause injury.

⚠ CAUTION

- Do not connect the ground wire to a phone cable. It may cause static noise on the phone line.

[Moving]

⚠ WARNING

- Before moving the machine, make sure to turn off the Power Select Switch and unplug the Power Supply Cord.
- Do not pull on the Power Supply Cord to move the machine. It will damage or break the Cord.
- Move the machine by pushing. When machine is moved by pulling, legs may get caught in the bottom of the machine, causing injury.

⚠ CAUTION

- Lift the machine over uneven ground such as bumps, steps, gutters, etc.

Precautions during Operation

[Operation]

⚠ WARNING

- Never open Upper Tables while the machine is operating. Rotating parts can cause injury.
- Do not touch the drive parts in the Sealing Unit while the machine is operating. They can cause injury.
- Do not remove any safety covers or panels while the machine is operating.
- Do not touch any rotating parts in machine. They can cause injury.
- Do not touch the Heater or other parts close to the Heater while the machine is operating. High temperature (about 400°C) of the Heater can burn.
- Heater remains hot even after the power has been turned off. Do not touch Heater until it has completely cooled down.
- Do not put your hand, finger and any other body part into a loop of strap while the machine is operating. Fast moving strap can cause injury.
- Insert the tip of strap beneath the Slide Table along the Right Bandway to activate a strap cycle. Strap is then automatically reversed into the machine. Release the strap immediately after the strap starts reversing. Do not hold onto the strap. Your fingers might get caught between the strap and package. Carefully review the “CHECK THAT SEAL” insert and check the condition of seals as necessary. Adjust the heater temperature as necessary to maintain the best sealing condition.

⚠ CAUTION

- Stop operating the machine, turn off the Power Supply Switch and unplug Power Supply Cord during the occurrence of lightening. Lightening can damage the IC board.
- Do not strap a package heavier than 80kg (176 lbs.).
- Do not drop or throw a package onto the machine creating a strong impact.
- The measured sound power level at a distance of 1 metre from the surface of the machinery and at a height of 1.6 metres from the floor is less than 70dB.

Peak Noise Level

Front side of the machine	66dB
Back side of the machine	69dB
Right side of the machine	67dB
Left side of the machine	66dB

[Repair, etc.]

⚠ WARNING

- Only trained personnel should service the machine.
- Before repairing, inspecting or cleaning, turn off the Power Supply Switch and unplug the Power Supply Cord.
- Do not alter machine. An altered machine can cause injury.

⚠ CAUTION

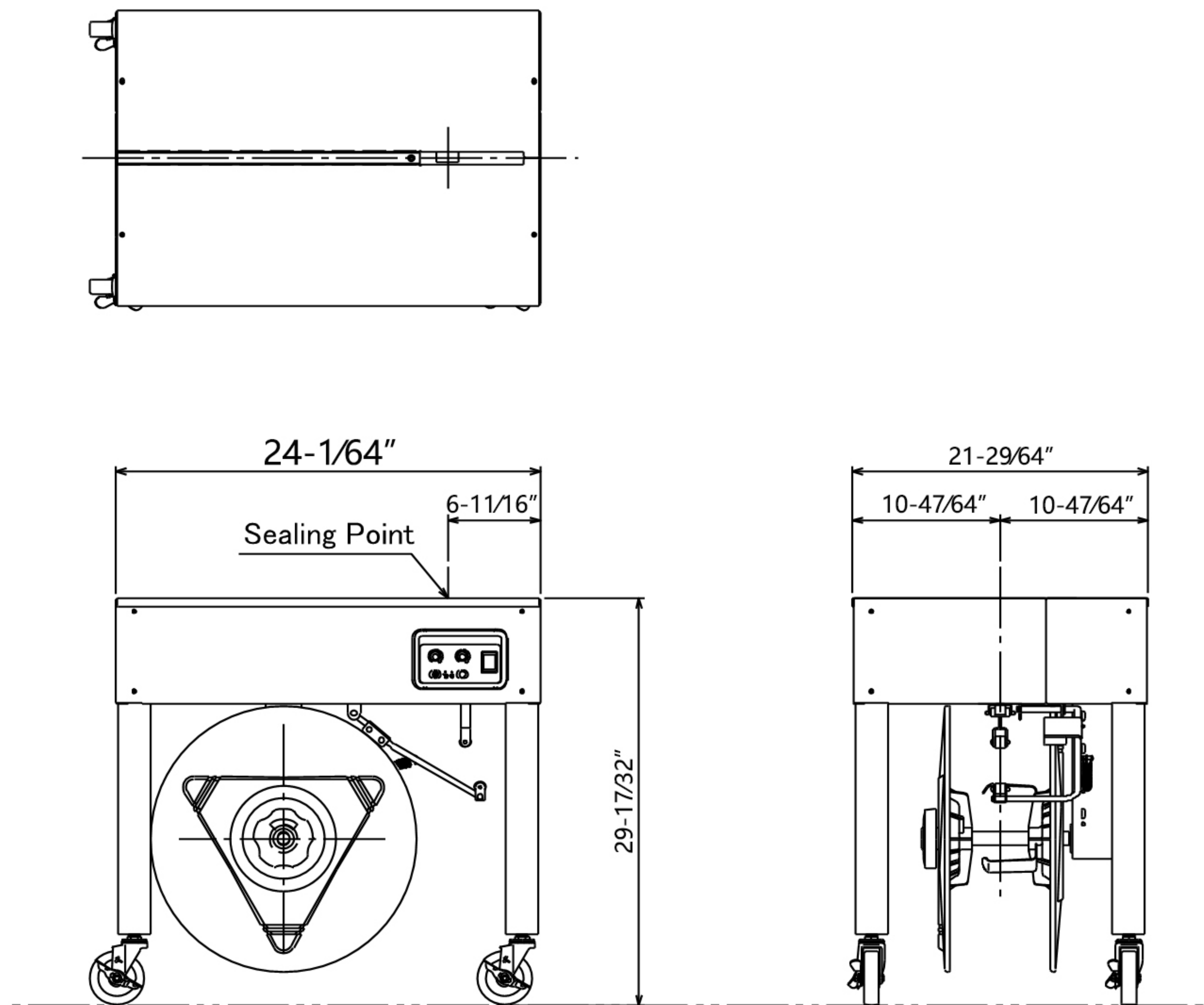
- Clean the machine regularly.
- Do not operate the machine in any manner which is not specified in this manual. Do not use other strapping material or tools not designed for this machine.

Standard Specification

Model	A55X
Dimension : Width	24-1/64"
: Body Width	24-1/64"
: Depth	21-29/64"
: Table Height	29-17/32"
: Height	29-17/32"
Weight	≒ 55 kg
Package Size : Minimum	W3-15/16" X H1-3/16"
: Maximum	Unlimited
Sealing Method	Heat Seal
Tension System	Torque System
Max. Tension	500N (50kgf)
Strap Width	13/64" ~ 39/64"
Strap Coil	OD17-23/32" × ID 7-7/8" × Width 7-7/8"
Power Supply	110 V-240V 50HZ/60HZ
Power Rating	0.4kw

The specification and outline are subject to change without prior notice.

Dimensional Drawing



Standard Accessories

Please store in a safe and secure place for future use.

The following accessories are supplied with the machine.

Original Instruction Manual & Parts List-----1 ea.
 CHECK THAT SEAL-----1 ea.
 Tools -----1 set

Operation Panel

① Power Select Switch

This is the main power supply switch for the machine. It will illuminate when the switch is in the ON position.

② Reset Switch

By pressing this Reset Switch, the Sealing Unit will operate one strap cycle and stop at its original (home) position. The next strap length will feed forward according to the position of the Feed Length Dial.

③ FEED Switch

This switch feeds the strap forward. If the strap length available is insufficient, press this switch to forward an extra length of strap as required.

④ Feed Length Dial

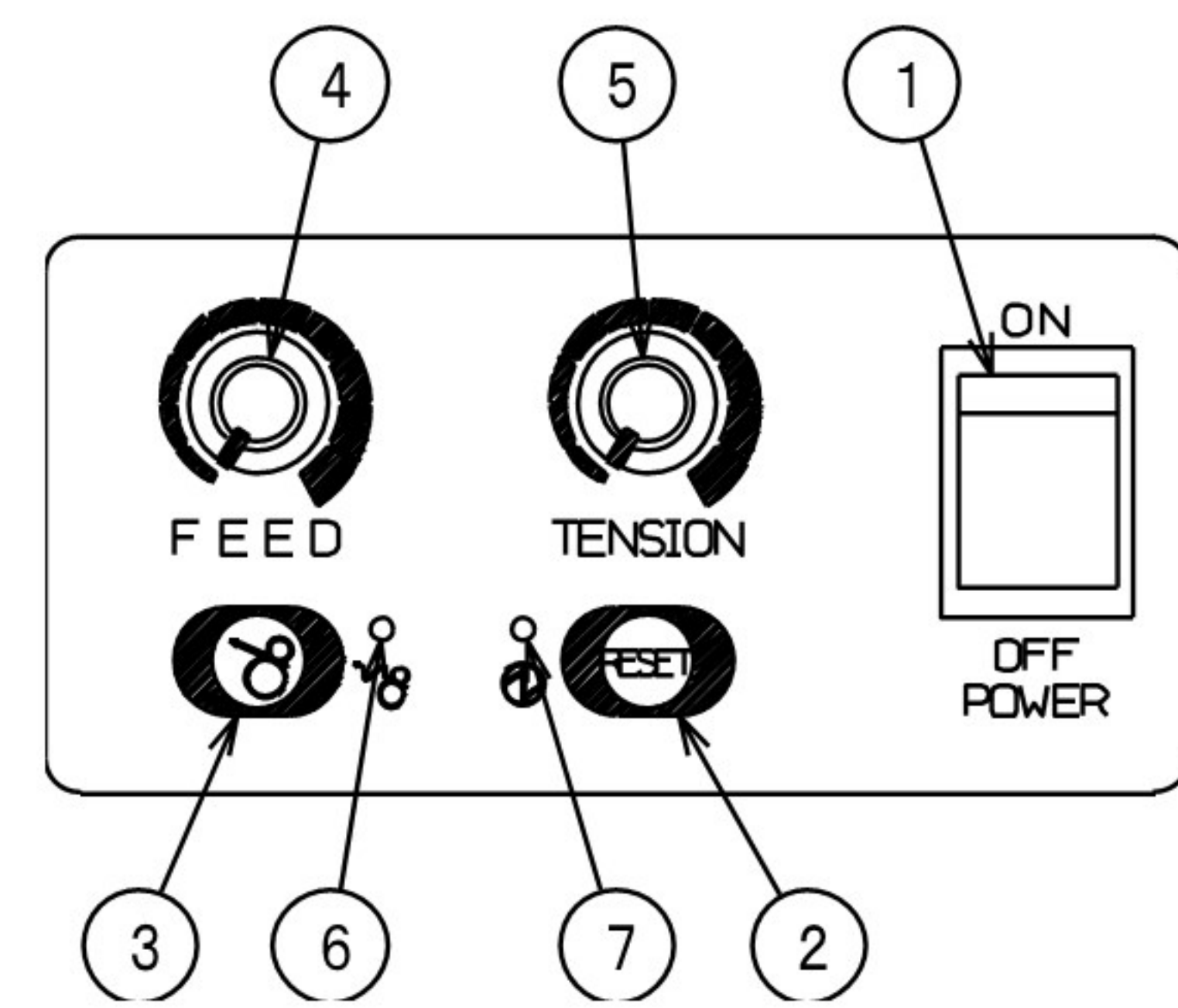
Turning clockwise feeds a longer length of strap after an operation cycle. Turning counter-clockwise causes a shorter length of strap to be fed. For easy operation, adjust the dial to feed a length of strap best suited to the size of the package you want to strap. Set the dial to fix the length of strap required.

⑤ Tension Dial

This dial is to adjust the tensioning strength. It should be set according to the nature and size of package.

⑥ Strap Jam Indicator Lamp: Refer to the “Indicator Lamps” section below.

⑦ Power and Overload Indicator Lamp: Refer to the “Indicator Lamps” section below.



Indicator Lamps

Indicator		Status	Measures
Strap Jam Indicator	Steady Light	Strap is jammed inside the machine.	Pull out the jammed strap and remove any deformed part of the strap. When this lamp is still on after drawing out the strap, remove the remaining strap from the inside of the machine. Refer to “Removing Jammed Strap”.
	Flashing Light	Sealing Motor (M1) will not activate.	Turn off the Power. Check and reconnect each connector and Condenser Terminal. Check around Cam Shaft. Turn on Power Switch and press the Reset Switch.
Power and Overload Indicator Lamp	Steady Light	Power is ON.	Normal
	Flashing Light	Feed Motor (M2) does not activate.	Turn off the Power. Check and reconnect each connector and Condenser Terminal. Check around Feed Roller. Turn on Power Switch and press the Reset Switch.

② Minimum Tension Adjustment Dial

Refer to “Minimum Tension Adjustment.”

③ Forward Touch Pressure Adjustment Dial

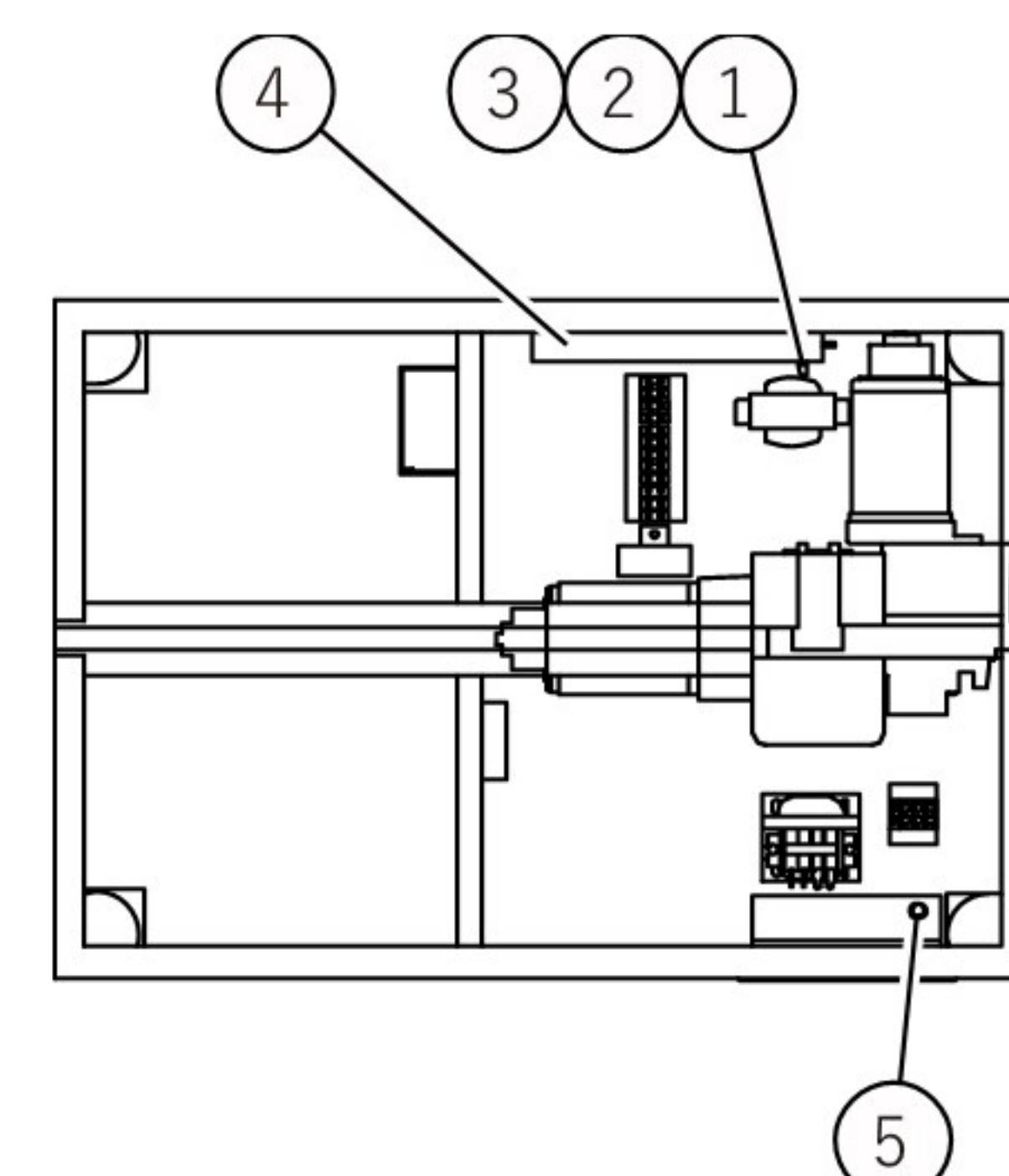
Refer to “Forward Touch Pressure Adjustment.”

④ IC Board Label

It indicates the type of IC Board installed.

⑤ Fuse and Capacity Label

Refer to “Fuse”



Fuse

To avoid any accident by overcurrent, a fuse is installed in the rear side of the Operation Panel. When the fuse has blown, turn off the power switch and disconnect the plug. Then, replace the fuse according to the following specification chart.

Voltage	Description of Fuse	Size	Capacity
100 – 120V	Midget Fuse	φ 6.4 × 30	250V 8A
200 – 240V	Midget Fuse	φ 6.4 × 30	250V 4A

Tension System

The tension strength is determined by the setting of the Tension Dial.

It will achieve the same tension strength for all packages regardless of varying circumferences.

It allows for a wide tension range of 50 – 500 N (approx. 5 – 50 Kg).

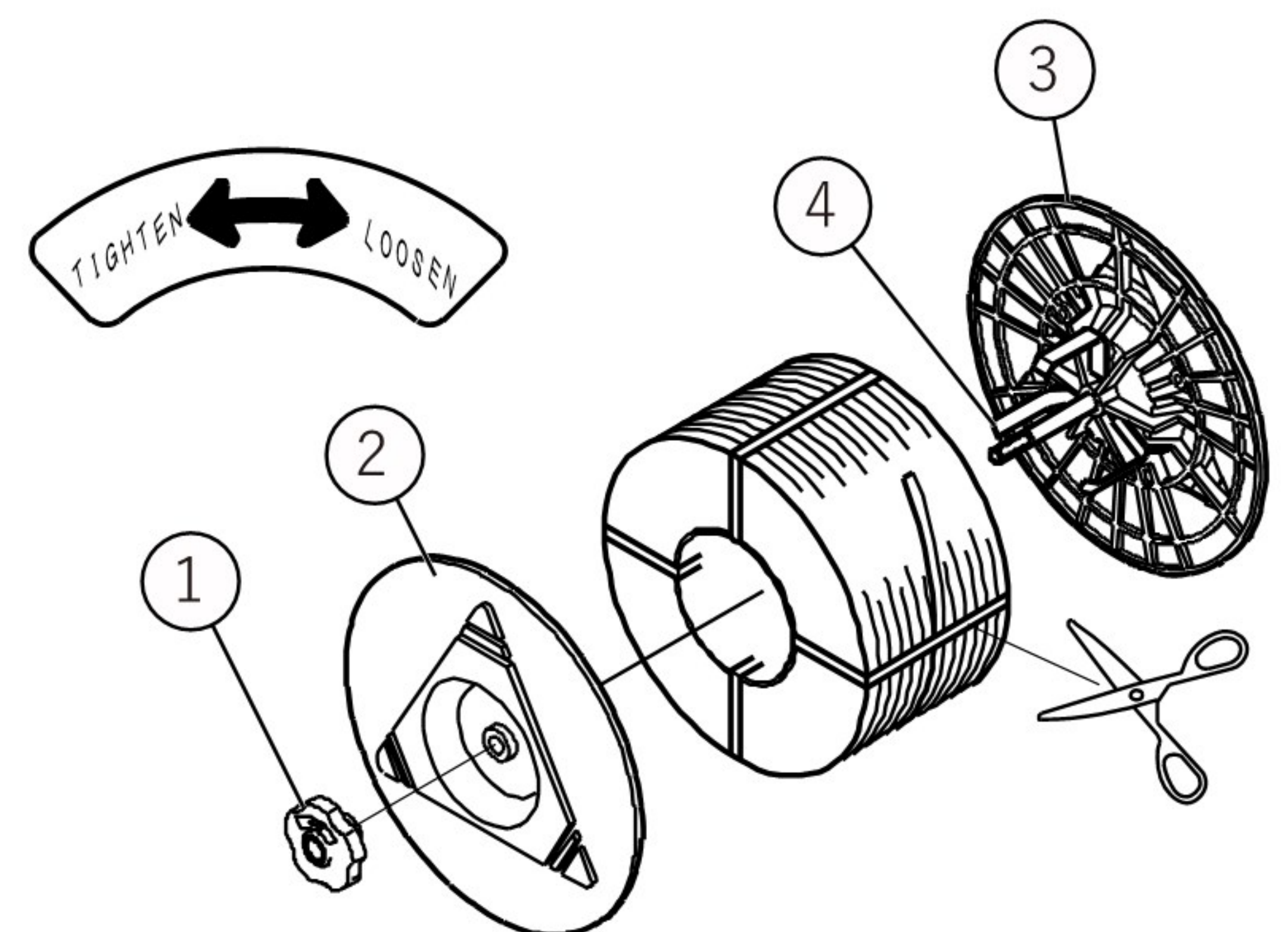
It is ideally suited for medium to high tension requirements.

Loading a Strap Coil

⚠ WARNING	Before loading strap turn off the Power Supply Switch and unplug the Power Supply Cord.
⚠ CAUTION	Make sure that the type and width of strap match the specification of the machine.

Load the strap coil onto the Reel Unit without cutting the strings (strap) tied around the coil.

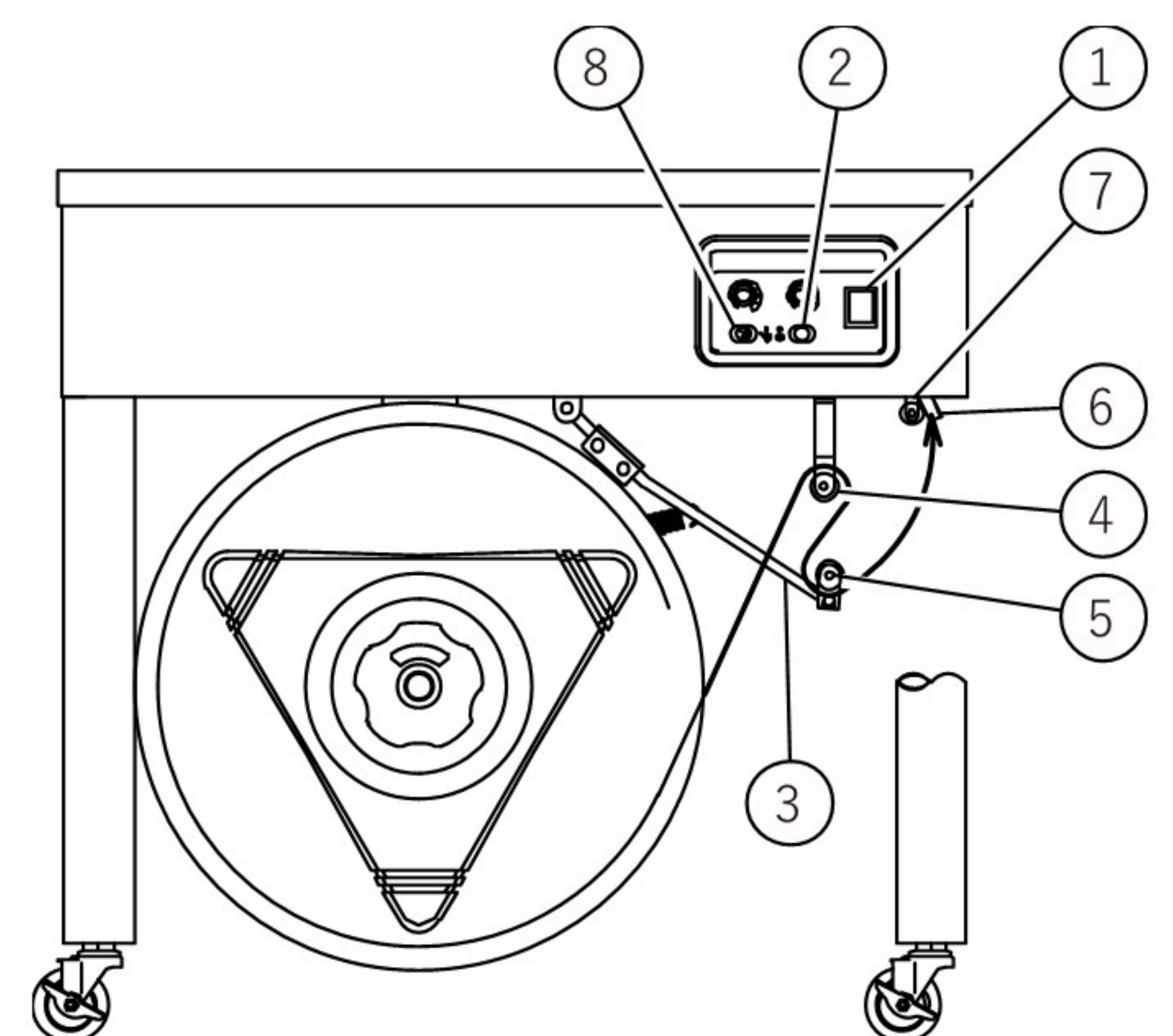
1. Remove Reel Outer-Circular ② by rotating Reel Nut Handle ① clockwise.
2. Mount the strap coil onto the Center Guide ④ of the Reel Inner-Circular ③ so that the tip of the strap is points counterclockwise.
3. Put the coil between the Reel Inner-Circular ③ and the Reel Outer-Circular ② and lock it in by tightening Reel Nut Handle ① counterclockwise.
4. Cut the strings (straps) tied around the coil



Strap Threading

⚠ WARNING	Make sure that the ground wire is connected.
------------------	--


1. Insert the Plug into the appropriate outlet.
2. Turn ON the Power Select Switch ① and press the Reset Switch ②. The machine will initiate a cycle and stop at Home Position. Confirm that the machine has stopped and continue with the next step.
3. Pull the strap tip to get a length of strap about 1 meter or 3 feet by lifting the Brake Arm ③.
4. Thread the strap through the Roller ④ on the Lifting Bracket and then through the Roller ⑤ on the Brake Arm ③.
5. After threading strap through Roller ⑥, insert the strap into the inlet ⑦ (which is locating at lower part of body) until it hits Feed Roller.
6. While holding strap, press the Feed Switch ⑧.



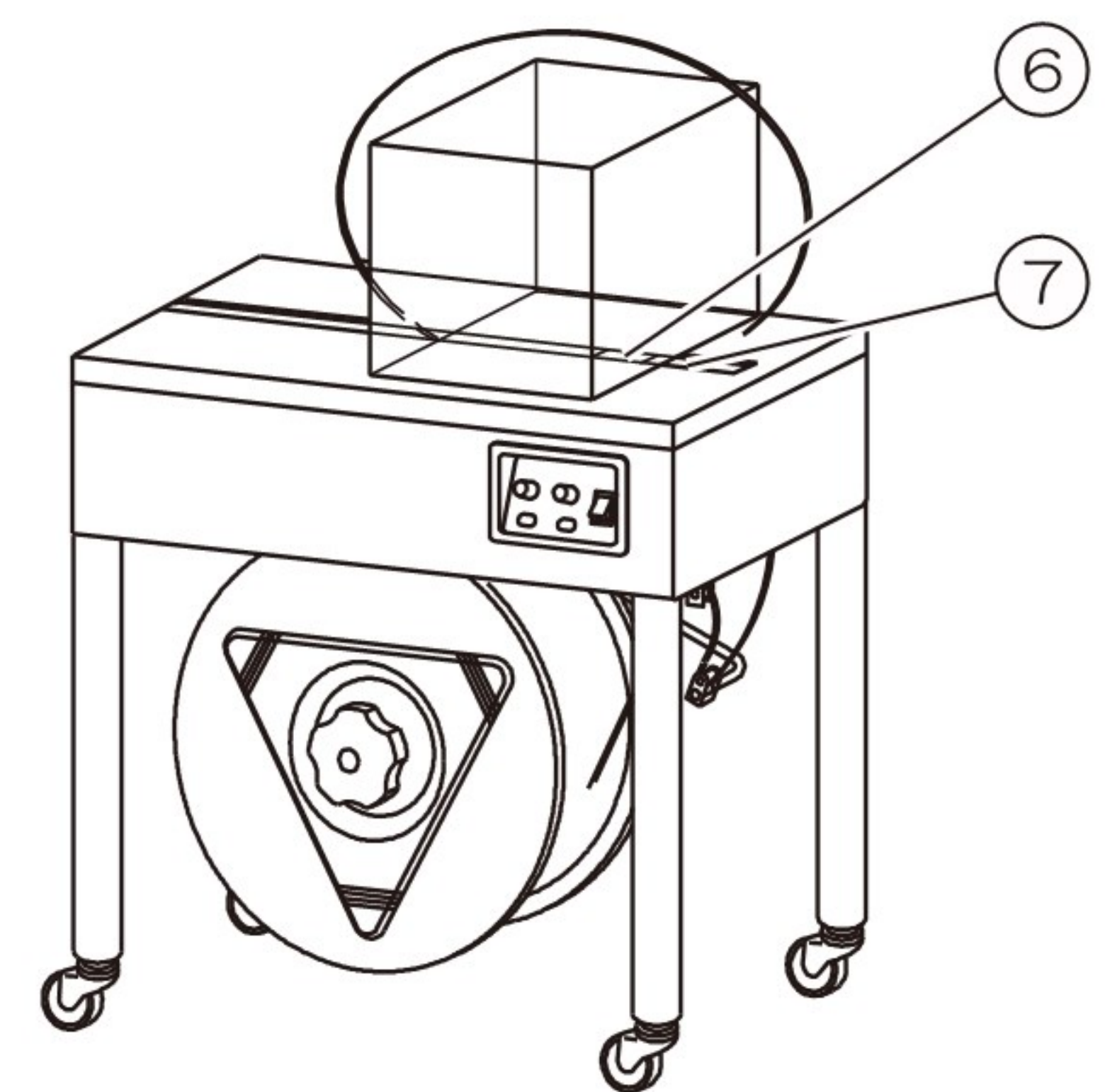
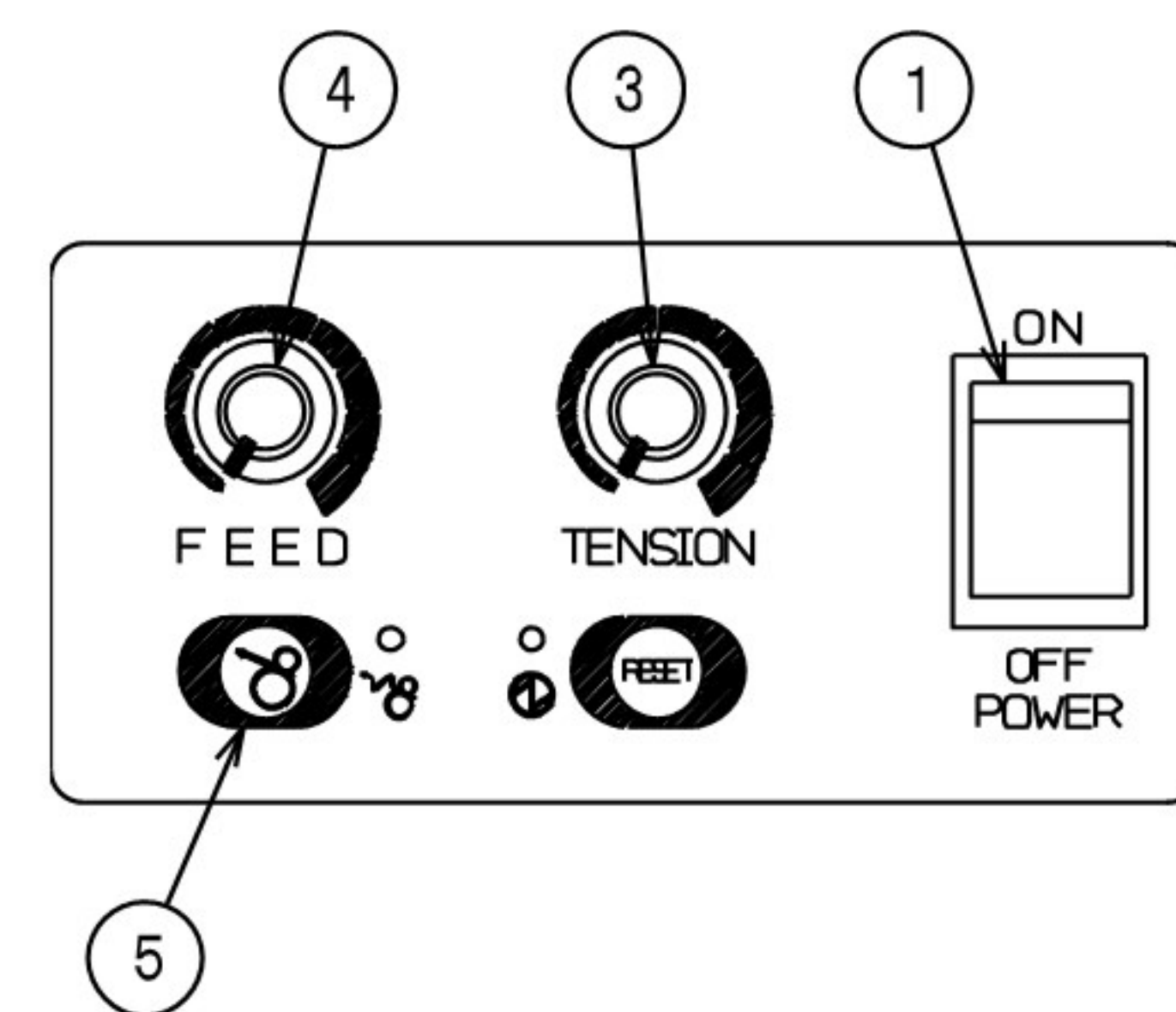
⚠ WARNING	Release strap immediately when the machine starts feeding strap.
------------------	--

Strap continues to be fed while the Feed Switch ⑧ is depressed.




Operation

 WARNING	<p>Insert the tip of strap beneath the Slide Table along the Right Bandway^⑦ to activate the machine. Strap is then automatically reversed into the machine. Release the strap immediately after the strap starts reversing. Do not hold onto the strap. Your fingers might get caught between the strap and package.</p>
--	---

1. After turning ON the Power Select Switch ^①, the heater will reach the operating temperature in approximately 30 seconds.
 2. Place a package on the Upper Table (over Slide Table ^⑥) and adjust Tension Dial ^③ at an appropriate tension level for your package.
- ☆ To avoid damaging your package, first test the strapping operation at a low tension setting. Gradually increase the tension if necessary. Repeat this process until a desired tension level is achieved.
3. Insert the tip of the strap into the Right Bandway groove. This will start the strap reversing operation around the package. After one strapping cycle (tensioning, cutting and sealing) is completed, a fixed length of strap will automatically be fed out for the next strapping operation.
 4. The strap length is adjustable by the Feed Dial ^④.
- ☆ Commonly, 200mm (8 in.) more than the overall circumference of your package is considered easiest to handle. Try strapping several times to find an appropriate length for your package.
- ☆ When the pre-fed length of strap is too short, push the Feed Switch ^⑤ to feed out more strap.

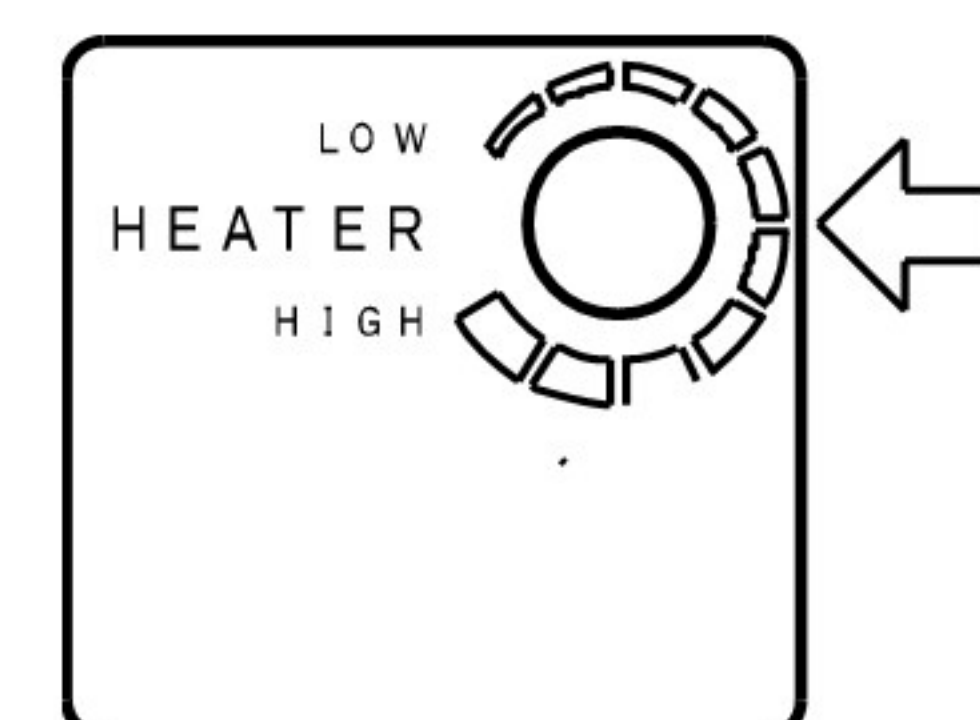


Heater Temperature Adjustment

 WARNING	Before adjusting machine, turn off the Power Supply Switch and unplug the Power Supply Cord
 WARNING	Heater plate remains hot even after the Power is turned off. Do not touch it directly until it has completely cooled down.
 CAUTION	Carefully read the separate insert "Check That Seal!" in order to maintain the appropriate heater temperature

【Heater Temperature Adjustment】

- The temperature should be adjusted according to the climate, area and location where the machine is being operated. Occasionally verify and maintain the appropriate heater temperature by following the guidelines outlined in the "Check That Seal!" leaflet.
- Turning the internal Heater Adjustment Dial clockwise will raise the heater temperature. Turning the dial counterclockwise will lower the temperature.



【Adjustment according to individual strap type】

The temperature of the heater is pre-adjusted at our factory based upon a standard polypropylene strap. However, depending on the type of strap to be used, adjustment may be required. Refer to the "CHECK THAT SEAL!" leaflet to achieve the appropriate heater temperature for your strap.

【Lower Heater Temperature due to strap residue buildup】

After a long period of usage, strap residue will build up on the heater plate and lower the heater temperature. When it is no longer possible to adjust the temperature on the Heater Dial to achieve a proper seal, turn off the power and pull out the plug. Wait until the Heater plate has sufficiently cooled down. Then remove the residue with a flat blade. The Heater temperature will be higher after removing the residue. Therefore, make sure to readjust Heater temperature with the Heater Dial.

Strap Size Change Adjustment

⚠ WARNING

Before adjusting machine, turn off the Power Supply Switch and unplug the Power Supply Cord

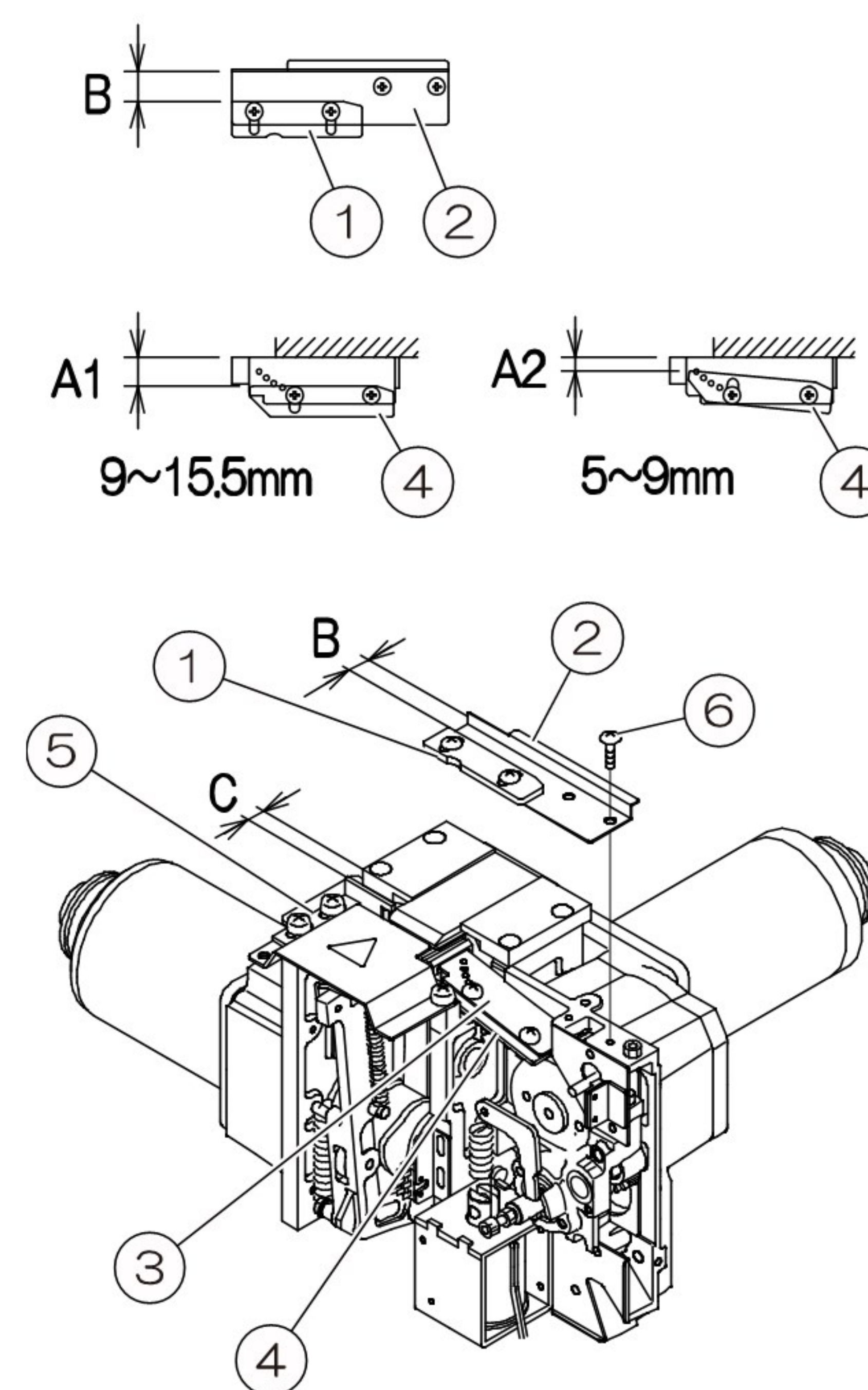
The following adjustments are required to accommodate a change in the Strap size.

【Parts Necessary to be Adjusted】

Right Band Guide ① • Feed Shooter Guide ④ • Left Band Guide ⑤.

【Adjustment Procedure】

1. Remove the Right Band Guide ① and the Right Band Guide Plate ② without disassembling them.
2. Loosen the lock screws, TMS M4x10, on the Feed Shooter Upper Plate ③, and adjust the Feed Shooter Guide ④ to the width of the new strap plus +1 ~ 2mm (A) extra clearance. Then, re-tighten TMS M4x10 bolts.
3. Loosen the lock screws TMS M4x8 and adjust the Right Band Guide ① to the new strap width plus +0.5~1mm (B) extra clearance. Re-tighten screws.
4. Loosen the fixing bolt HBS M4x8 on the Left Band Guide ⑤ and adjust to the width of the new strap size plus +1~2mm (C) extra clearance. Re-tighten HBS bolt.
5. Assemble Right Band Guide ① and Right Band Guide Plate ② with bolt TMS M4x8 ⑥.
 - ☆ Insert the plug in the outlet, and turn the Power switch ON. Check the alignment of the sealed strap by operating the machine several times. If the alignment is off, adjust the position of Right Band Guide Plate ② by loosening the bolt ⑥.



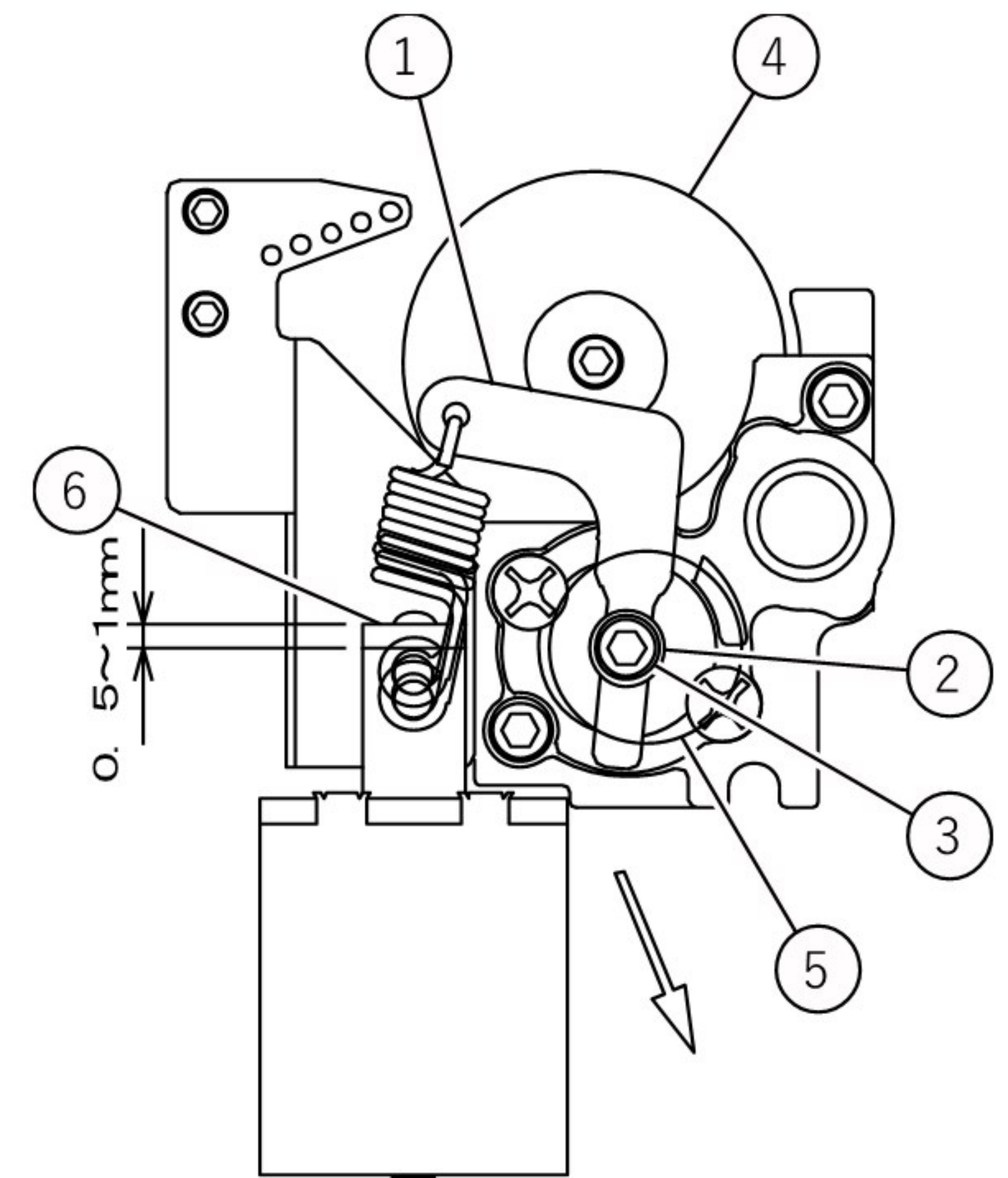
Reverse Touch Pressure Adjustment

⚠ WARNING

Before adjusting machine, turn off the Power Supply Switch and unplug the Power Supply Cord

When operating the machine under high tension for an extended period of time, the Feed Roller may start slipping, resulting in broken or damaged strap. If this occurs, the following adjustment is required.

1. Remove the Upper Table
2. Pull the strap out in the direction indicated by the arrow while holding up the Upper Roller Shaft Arm ①.
3. First, loosen the fixing bolt ③ of Upper Roller Shaft ② and Upper Roller Shaft Arm ①. Solenoid Plunger should be raised 0.5 – 1mm (the distance to reach to the bottom by pushing Plunger top downward) when making a slight contact of Feed Roller ④ and Upper Roller ⑤ (without any strap). When this is confirmed, tighten the fixing bolt ③ back firmly.



- ⊙ When Higher Tension is required, Solenoid Plunger should be raised 1.0 – 1.5mm.
- ⊙ Confirm the Solenoid Plunger ⑥ is at its stroke end during the reversing cycle.

Removing Jammed Strap

⚠ WARNING

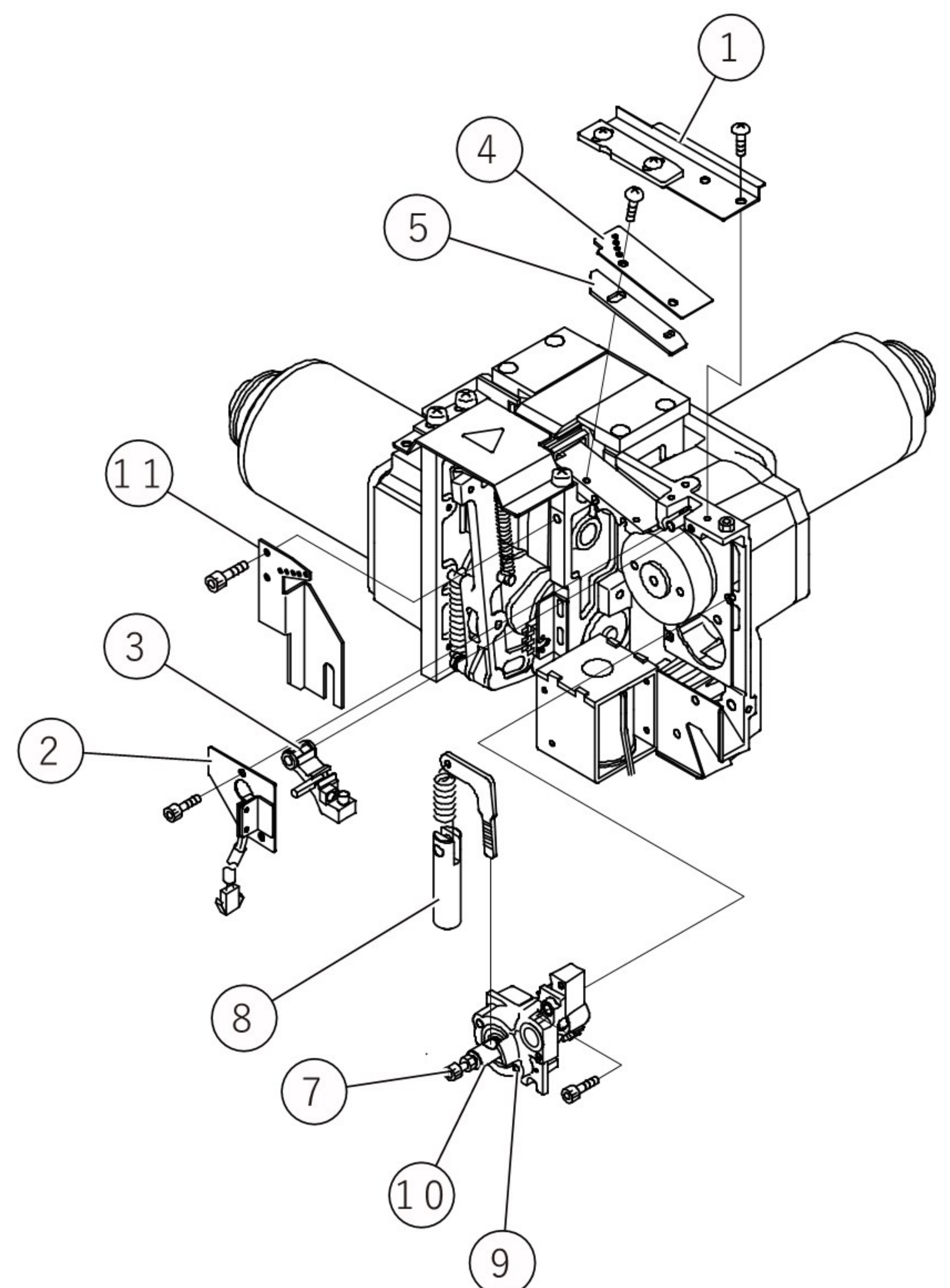
Before adjusting machine, turn off the Power Supply Switch and unplug the Power Supply Cord

⚠ CAUTION
















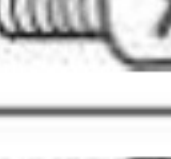
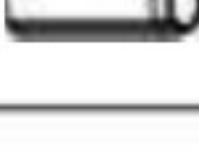

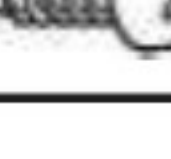
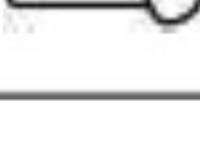

Be cautious not to damage the LS5 switches.

When strap is jammed causing the machine to stop operating, the Strap Jam Indicator Lamp will illuminate. If this occurs, pull the strap out of the machine. If the jammed strap cannot be completely removed, disassemble and remove by the following procedure.

1. Remove the Upper Table
2. Disassembling the Right Band Guide Plate ①, LS5 Bracket ②, Upper Shooter ③, Plunger Guide ⑪, Feed Shooter Upper Plate ④ and Band Guide ⑤ will expose jammed section. Remove the jammed strap.
 - ☆ If jammed strap is caught between Rollers, continue disassembly with following procedure.
3. Remove the Upper Roller Shaft Arm, Touch Spring and Plunger ⑧ as a complete set by loosening the fixing screw ⑦.
4. Pull out the Shaft ⑩ of the Upper Roller Shaft Holder ⑨ by turning right/left and shifting towards to right.
 - ☆ After removing jammed strap, reassemble in reverse order according to the above procedure.

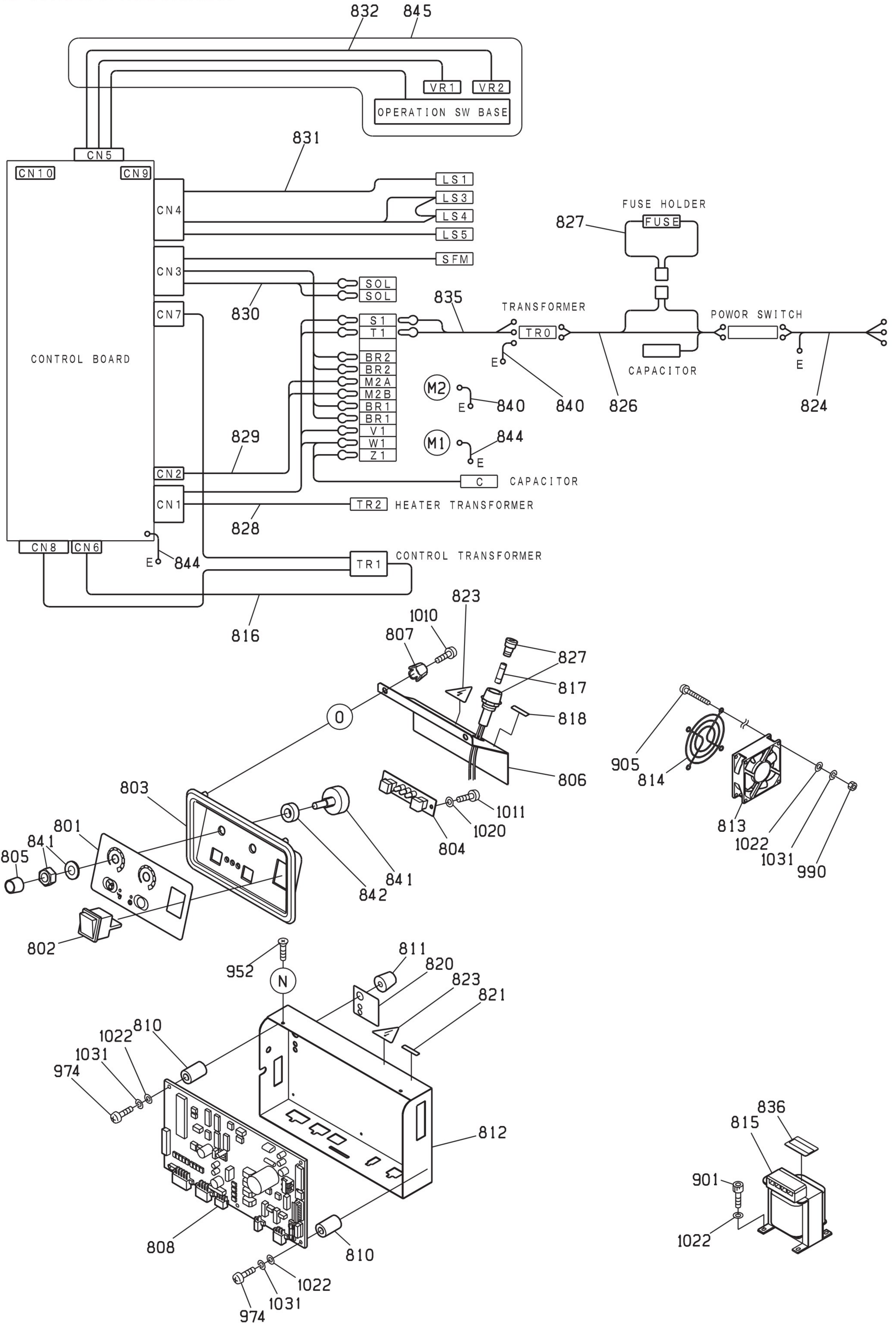


使用ねじ類
SCREWS

略称 Abbreviation	名称 Designation	形状 Appearance	略称 Abbreviation	名称 Designation	形状 Appearance	略称 Abbreviation	名称 Designation	形状 Appearance
HBS	六角穴付きボルト Hexagon Socket Head Cap Screws		HN	六角ナット Hexagon Nuts		SNPIN	スナップピン Snap Pin	
HSS	六角穴付き止めねじ Hexagon Socket Set Screws		HN-3	六角ナット(3種) Hexagon Nuts (Thin)		E	E形止め輪 Retaining Rings E Type	
HB	六角ボルト Hexagon Head Screws		PW	平座金 Plain Washers		H	C形止め輪(穴用) Retaining Rings C Type,Hole	
FMS	十字穴付きサラ小ネジ Cross Recessed Flat Head Screws		SW	バネ座金 Spring Washers		S	C形止め輪(軸用) Retaining Rings C Type,Shaft	
TMS	十字穴付きトラス小ネジ Cross Recessed Truss Head Screws		BWW	ウェーブワッシャー Wave Washers		PN	プッシュナット Push Nuts	
PMS	十字穴付きナベ小ネジ Cross Recessed Pan Head Screws		SPPIN	スプリングピン Spring Pin		CN	袋ナット Cap Nuts	
PBS	プラスチック用タッピングねじ Tapping Screws for Plastic		RIV	冷間成形リベット Cold Headed Rivets		G	グリップリング Grip Rings	

番号 No.	部品番号 Parts No.	部品名称 Description	番号 No.	部品番号 Parts No.	部品名称 Description	番号 No.	部品番号 Parts No.	部品名称 Description
900	0112-004006	HBS,M4x6,SUS	1000	0192-004002	CN,M4,SUS			
901	0112-004008	HBS,M4x8,SUS	1010	0292-003254	PBS,3x10,SUS			
902	0112-004010	HBS,M4x10,SUS	1011	0292-003231	PBS,3x8,SUS			
903	0112-004015	HBS,M4x15,SUS	1020	0312-030705	PW,M3,SUS			
904	0112-004025	HBS,M4x25,SUS	1021	0312-040808	PW,M4,D8,SUS			
905	0112-004035	HBS,M4x35,SUS	1022	0312-040908	PW,M4,SUS			
906	0112-005008	HBS,M5x8,SUS	1023	0312-051010	PW,M5,SUS			
907	0112-005010	HBS,M5x10,SUS	1024	0312-051210	PW,M5,D12,SUS			
908	0112-005012	HBS,M5x12,SUS	1025	0312-061316	PW,M6,SUS			
909	0112-005015	HBS,M5x15,SUS	1026	0312-102120	PW,M10,SUS			
910	0112-005020	HBS,M5x20,SUS	1030	0322-030607	SW,M3,SUS			
911	0112-005025	HBS,M5x25,SUS	1031	0322-040810	SW,M4,SUS			
912	0112-006010	HBS,M6x10,SUS	1032	0322-050913	SW,M5,SUS			
913	0112-006015	HBS,M6x15,SUS	1033	0322-061215	SW,M6,SUS			
915	0112-006020	HBS,M6x20,SUS	1040	0341-212736	BWW,6001C			
916	0112-006025	HBS,M6x25,SUS	1051	0412-005014	SPPIN,5x14,SUS			
917	0112-006040	HBS,M6x40,SUS	1052	0412-005016	SPPIN,5x16,SUS			
921	0112-004012	HBS,M4x12,SUS	1053	0412-006025	SPPIN,6x25,SUS			
924	0112-006022	HBS,M6x22,SUS	1054	0412-006012	SPPIN,6x12,SUS			
930	0122-005005	HSS,M5x5,SUS	1055	0412-006022	SPPIN,6x22,SUS			
931	0122-005010	HSS,M5x10,SUS	1056	0412-005022	SPPIN,5x22,SUS			
932	0122-006005	HSS,M6x5,SUS	1060	0422-006030	RIV,6x30,SUS			
933	0122-008015	HSS,M8x15,SUS	1061	0422-006050	RIV,6x50,SUS			
940	0132-005010	HB,M5x10,SUS	1070	0492-121000	SNPIN,10,SUS			
950	0142-003008	FMS,M3x8,SUS	1090	0512-121910	H-19,SUS			
952	0142-004008	FMS,M4x8,SUS	1100	0512-131210	S-12,SUS			
953	0142-005010	FMS,M5x10,SUS	1101	0512-132512	S-25,SUS			
960	0151-105005	TMS,M5x5,SUS	1131	0512-210600	PN-6,SUS			
961	0152-004008	TMS,M4x8,SUS	1140	0292-005253	HBB,M5x8,SUS			
963	0152-004010	TMS,M4x10,SUS						
964	0152-005008	TMS,M5x8,SUS						
965	0152-005010	TMS,M5x10,SUS						
969	0162-004006	PMS,M4x6,SUS						
970	0162-003006	PMS,M3x6,SUS						
971	0162-003008	PMS,M3x8,SUS						
972	0162-003022	PMS,M3x22,SUS						
973	0162-004008	PMS,M4x8,SUS						
974	0162-004016	PMS,M4x16,SUS						
975	0162-004018	PMS,M4x18,SUS						
977	0162-005012	PMS,M5x12,SUS						
978	0162-006020	PMS,M6x20,SUS						
979	0162-006040	PMS,M6x40,SUS						
980	0162-006050	PMS,M6x50,SUS						
981	0162-003015	PMS,M3x15,SUS						
983	0162-002516	PMS,M2.5x16,SUS						
986	0162-006010	PMS,M6x10,SUS						
990	0182-004001	HN,M4,SUS						
991	0182-005001	HN,M5,SUS						
992	0182-006001	HN,M6,SUS						
993	0182-008001	HN,M8,SUS						
994	0182-008003	HN-3,M8,SUS						

Electric Control & Wire Harness



Sealing Unit									
No.	Parts No.	Description	Q'ty	Note	No.	Parts No.	Description	Q'ty	Note
101	518-01-10140	Cam Shaft	1		162	518-01-50130	LS-3,4 Bracket	1	
102	0611-060001	Ball Bearing, 60/22zz	2		163	518-01-70111	F.R. Base	1	
103	0499-004073	Key □5 × 73	1		164	518-01-70160	Feed Shooter Lower Plate	1	
104	518-01-10211	Left Block Cam	1		165	526-01-70170	Feed Shooter Guide	1	
105	518-01-10221	Heater Cam	1		166	518-01-70180	Feed Shooter Upper Plate	1	
106	518-01-10231	Center Block Cam	1		167	518-01-70281	LS-5 Bracket	1	
107	518-01-10241	Band Guide Cam	1		168	518-01-70430	Gear Cover A	1	
108	518-01-10251	Right Block Cam	1		169	518-01-70440	Base Cover	1	
109	518-01-10410	Limit Switch Cam	1		170	518-01-70520	Gear Cover B	1	
110	518-01-10261	Collar A	1		171	518-01-70530	Upper Shooter Shaft	1	
111	518-01-10271	Collar B	4		172	518-01-70130	Guide Roller	1	
112	518-01-10150	Cam Shaft Gear	1		173	518-01-70140	Guide Roller Shaft	1	
113	0499-004012	Key □5 × 12	1		174	518-01-70240	Feed Roller Gear	1	
114	518-01-10280	End Plate A	2		175	0611-026002	Ball Bearing, 6002zz	1	
115	518-01-10190	Second Gear	1		177	0611-026001	Ball Bearing, 6001zz	3	
116	0611-020608	Ball Bearing, 608zz	2		178	518-01-70230	M2 Gear Box Plate	1	
117	518-01-10130	M1 Gear Case	1		179	518-01-70350	M2 Gear Box Packing	1	
119	518-01-10320	M1 Gear Case Packing	1		180	518-01-70310	Feed Roller Collar	1	
120	518-01-20140	Arm Shaft	1		181	0499-004020	Key □5 × 20	1	
121	518-01-20150	Arm Spring	2		182	526-01-70230	Feed Roller	1	
122	518-01-20110	Guide Rail L	1		183	518-01-70480	End Plate B	1	
123	518-01-21130	Left Block Band Guide	1		184	526-01-70110	Upper Roller	1	
124	518-01-20120	Guide Rail R	1		185	0611-021980	Ball Bearing, R1980zz	2	
125	518-01-20130	Slide Table Spring	2		186	526-01-70130	Upper Roller Shaft	1	
126	518-01-21110	Slide Table	1		187	527-01-70140	Upper Roller Shaft Holder PLT	1	
127	518-01-21120	Slide Table Stopper	1		188	518-01-70150	Upper Roller Shaft Arm	1	
128	518-01-22110	Band Guide	1		189	518-01-70470	Touch Spring	1	
129	518-01-22120	Striker	1		192	526-01-31220	SPPIN,4x19.2,SUS	3	
130	518-01-22160	Striker Pin Collar	1		198	518-01-70340	Plunger Guide	1	
131	518-01-23110	Band Guide Arm	1		199	518-01-73111	Upper Shooter	1	
132	0611-060085	Ball Bearing, 635zz C	5		200	518-01-70250	Upper Shooter Spring	1	
133	518-01-30110	Block Tension Spring	3		201	0520-140606	Bush 80F0606	2	
134	518-01-30120	Spring Hook Pin	1		202	0750-130004	Magnet MFT-2021	1	
135	526-01-30130	Lfft Shooter Bracket	1		203	518-01-74111	Right Band Guide Plate	1	
136	518-01-30140	Cutter Tension Spring	2		204	518-01-74120	Right Band Guide	1	
137	518-01-31150	Right Block	1		205	518-07-10130	Label LS1,2,5	1	
138	631-01-31160	Upper Cutter	1		206	518-07-10560	Label LS3,4	1	
139	518-01-31170	Spacer Block	1		207	518-07-10261	Label M1 Sealing Motor	1	
140	518-01-31120	Right Block Spring	1		208	518-07-10271	Label M2 Feed Motor	1	
141	518-01-31130	Cam Follower Holder	3		209	518-07-10291	Label Solenoid	1	
142	518-01-32120	Center Block	1		210	518-07-10311	Label Magnetic Brake	2	
143	631-01-32130	Cutter Lower	1		211	0890-480257	Warning Label Higt Temperature	1	
144	518-01-32140	Left & Center Block Spring	2		212	0750-110045	Micro Switch	1	
145	518-01-33110	Left Block	1		213	0750-110098	Micro Switch ABS111654	2	
146	518-01-33120	Left Block Jaw	1		214	518-06-10160	Lead Switch,LS5	1	
147	518-01-34110	Block Case	1		216	518-06-23131	Solenoid DC24V	1	
148	518-01-40110	Left Band Guide	1		217	518-06-23120	M1 Sealing Motor(KU)	1	
149	526-01-40120	Heater Cover	1		218	518-06-23200	M2 Feed Motor (J)	1	
150	518-01-40150	Heater Tension Spring	1			631-81-10301	M2 Feed Motor (CE)	1	
151	518-01-41110	Heater Nichrome Plate	1		219	518-06-23301	Magnetic Brake BR1	1	
152	518-01-41120	Heater Base	1		220	518-06-23401	Magnetic Brake BR2	1	
153	518-01-41130	Insulation Board A	2		221	518-06-23151	Hub & Armature for Brake	(2)	
154	518-01-41140	Insulation Board B	1		223	518-01-50140	LS3,4 Spacer	1	
155	518-01-41150	Harness for Heater	2		225	518-01-31180	Right Block Spacer	1	
156	518-01-41160	Heater Fixing Plate	1		296	615-01-31003	Right Block Assembly	(1)	
157	518-01-41170	Heater Bolt	2		297	615-01-32003	Center Block Assembly	(1)	
158	518-01-42110	Heater Arm	1		298	518-01-33000	Left Block Assembly	(1)	
159	525-01-42120	Heater Bracket	1		299	518-01-41000	Heater Set	(1)	
160	518-01-50110	Sealing Unit Frame L	1		300	518-01-70360	Feed Roller Spacer	(1)	
161	518-01-50120	Sealing Unit Frame R	1						

Body Unit									
No.	Parts No.	Description	Q'ty	Note	No.	Parts No.	Description	Q'ty	Note
301	656-04-10110	Reel Bracket	1		334	656-05-10210	Upper Table F	1	
302	0611-056205	Ball Bearing 6205ZZ NR	2		335	656-05-10220	Upper Table R	1	
303	526-04-10130	Reel Shaft SU	1		336	518-80-10150	Work Guide	2	
304	N11-04-10112-1	Reel In Circular	1		338	518-07-10380	Warning Label general E	1	
305	526-04-10180	Reel Center Guide SU	3		339	518-07-10421	Warning Label Upper Table E	1	
306	518-04-10211	Rear Plate Washer	3		340	518-07-10440	Label Earth	1	
307	518-07-10220	Arrow Label Left	1		343	0890-480273	Label Manufacture Number SEM	1	
308	N11-04-10122-1	Reel Out Circular	1		344	518-07-10480	Label How to load strap EX	1	
309	518-04-10390	Reel Nut Handle	1		345	525-06-10210	Terminal 12P M	1	
310	518-07-10240	Label Nut Handle Left E	1		346	525-06-10221	Heater Terminal	1	
311	675-04-10160	Reel Brake Spring	1		347	518-06-10190-631	Harness Support	1	
312	526-04-20110	Reel Brake Arm SU	1		348	521-06-10110	Wiring Duct NA 200	1	
313	518-04-20120	Brake Liner	1		349	0770-240059	Condenser for M1 200V 27 μ F	1	
314	526-04-20180	Washer for Brake Liner SU	1		350	518-06-10241	Grommet D14d10t2	1	
315	526-04-20140	Brake Bracket SU	1		355	518-07-10640	Label MADE IN CHINA	1	
316	518-04-10290	Band Guide Roller	2		356	0890-480287	Label STR Patent	1	
317	526-04-20210	Lifting Roller Bracket SU	1		357	518-05-10870	Washer 18x12.5x2	4	
318	521-04-20150	Guide Roller B	1		358	518-07-10550	Label CE	1	
319	526-04-20160	Guide Roller Bracket SU	1		359	518-04-10410	Reel Shaft Cap	2	
321	656-05-10110	Body SU	1		361	656-05-10290	D-53XS2 Seal	1	
325	656-05-10170	Leg SU	4		362	656-05-10230	Leg Reinforcement Board SU	4	
328	0890-130353	Caster 320EA-R65	2		363	656-05-10150	Control Box Bracket SU	1	
329	0890-130354	Caster 315EA-R65	2						
330	518-05-10190	Band Guide	1						
331	526-05-10180	Table Bandway SUS	1						

Electric Control & Harness									
No.	Parts No.	Description	Q'ty	Note	No.	Parts No.	Description	Q'ty	Note
801	518-80-10131	Operation Panel Seat E	1		823	518-07-10360	Warning Label Electric Shock	3	
802	0710-130043	Power Switch RL2-1-21/N-C	1		824	518-80-10110	Power Supply Cord EX	1	
803	518-80-10381	Operation Panel Fixing Plate	1		826	518-06-21120	Harness Power Switch	1	
804	518-06-10142	IC Board for Operation Switch	(1)		827	0730-130029	Fuse Holder F-85	(1)	
805	0710-180023	Dial K-6	2		828	526-06-21140	Harness CON1 SU	1	
806	526-06-10150	Operation Panel Cover	1		829	526-06-21150	Harness CON2 SU	1	
807	518-06-10280	Cap	4		830	526-06-21160	Harness CON3 SU	1	
808	518-26-20150	IC Board PB133E STR	1		831	518-80-10590	Harness CON4	1	
810	518-06-20150	Spacer	5		832	518-80-10610	Harness CON5	(1)	
811	0710-180034	Dial (6S-2)	1		835	656-06-21130	Harness Power Transformer	1	
812	518-06-20131-631	Control Box	1		836	518-07-10341	Label Heater Transformer	1	
813	518-06-23240	Fan □60,DC24V	1		837	518-07-10592	Label Control Transformer	1	
814	0780-170048	Fan Guard □60	1		838	518-07-10321	Label Transformer 200-240V	1	200-240V CE
815	518-06-23180	Heater Transformer	1		838	518-07-10331	Label Transformer 110-120V	1	110-120V CE
816	518-06-20121	Control Transformer	1		839	518-06-23160	Power Transformer 200-240V	1	200-240V
817	0730-170080	Fuse 6.4x30 8A	1	100-120V	839	518-06-23170	Power Transformer 110-120V	1	110-120V
	0730-170040	Fuse 6.4x30 4A	1	200-240V	840	518-81-10120	Harness Earth 250	2	
818	518-07-10110	Label Fuse 8A	1	100-120V	841	0770-220011	Volume RV24YN20SB	(2)	
	518-07-10120	Label Fuse 4A	1	200-240V	842	518-06-10220	Volume Collar	2	
820	518-07-10180	Label Heater Volume E	1		844	518-81-10130	Harness Earth 150	2	
821	518-07-10660	Label STR Type B	1		845	518-80-10620	Operation SW Set STR	1	