

SECTION I: General Information

INTRODUCTION

The operating procedures outlined in this manual are prepared to facilitate the Tie-Matic HD twist tying machine.

WARRANTY

Purchaser acknowledges that there are no warranties, expressed or implied, made by **PLAS-TIES**, its distributors or sales representatives related to the Tie-Matic HD except the manufacturer's warranty against defective materials and workmanship as follows:

PLAS-TIES warrants the Tie-Matic HD to be free from defects in materials and workmanship at time of delivery. Liability under this warranty is limited to the repair or exchange of any defective part or parts of the unit providing the same is returned to **PLAS-TIES**, transportation prepaid, within 1 year or 300,000 ties (*whichever comes first and based on machine counter*). **THE WARRANTY BEGINS FROM THE DATE OF INSTALLATION AT CUSTOMER SITE AND NOT DATE OF PURCHASE. IN ORDER TO ACTIVATE THE WARRANTY, THE COMPANY NAME, CONTACT, CITY/STATE, AND SERIAL NUMBER MUST BE REGISTERED WITH PLAS-TIES or PROOF OF PURCHASE MUST BE PROVIDED. FAILURE TO DO SO WILL RESULT IN LIMITATION OF THE FULL WARRANTY. THIS IS TO INSURE TOTAL QUALITY ASSURANCE AND 800 TOLL FREE TECHNICAL SUPPORT.**

The warranty is void on any Tie-Matic HD that has been subject to negligence, accident, misuse, failure to use the equipment as instructed in the manual, or that has been tampered with.

This warranty is void if the Tie-Matic HD is used with anything other than genuine **PLAS-TIES** twist-tie material.

IMPORTANT: If your Tie-Matic® HD does not operate properly, please bring it to the attention of **PLAS-TIES**, or the dealer or distributor from whom it was purchased. If repairs are needed, the dealer, distributor or other representative of **PLAS-TIES** will arrange to repair or replace parts within the terms of the warranty.

Warranty coverage is limited to the Continental US, Alaska, Hawaii, Puerto Rico, and Canada.

SECTION II: Specifications

MODEL DESIGNATION

This manual covers all models of the Tie-Matic HD Series. The models are identical in their operation.

Models HD38, HD58 and HD78 are equipped with a 2 amp circuit breaker for overload protection U.L. approved for the United States.

SPECIFICATIONS

HD38-Maximum Tying Diameter Capacity - 3/8"

HD58-Maximum Tying Diameter Capacity - 5/8"

HD78-Maximum Tying Diameter Capacity - 7/8"

PERFORMANCE

Up to 60 ties per minute

2-1/2 full twists on product tied

POWER REQUIREMENTS

110-120 VAC, 60Hz

60 cycle

DIMENSIONS/WEIGHT

Length: 22"

Height: 11"

Width at top: 5-1/2"

Width at front feet: 9-1/2"

Weight: 16 pounds / 19 pounds with shipping container (no spools)

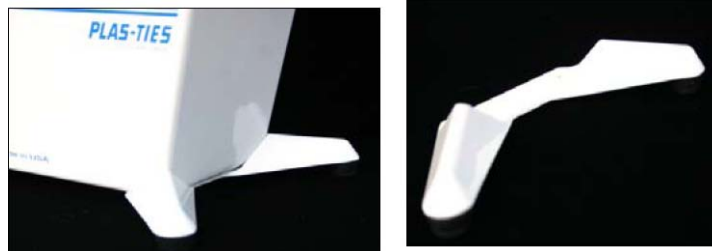
SECTION III: Operation

MOUNTING AND START-UP

The Tie-Matic HD should be secured to your work table by:

1. Installing the front stabilizer on the unit. (Figure III-1)
2. Rubber suction cup feet are available for complete stability on a stainless steel table or flat surface area (Figure III-2).
3. Also for a permanent position, you can bolt the Tie-Matic to a work table with 10-32 screws to the bottom of the unit.
4. To start the machine, plug the machine into a power source and flip the "ON/OFF" switch to "ON" position.
5. Cover must be closed to activate machine.

Front Stabilizer



(Figure III-1)

Suction Cup Feet

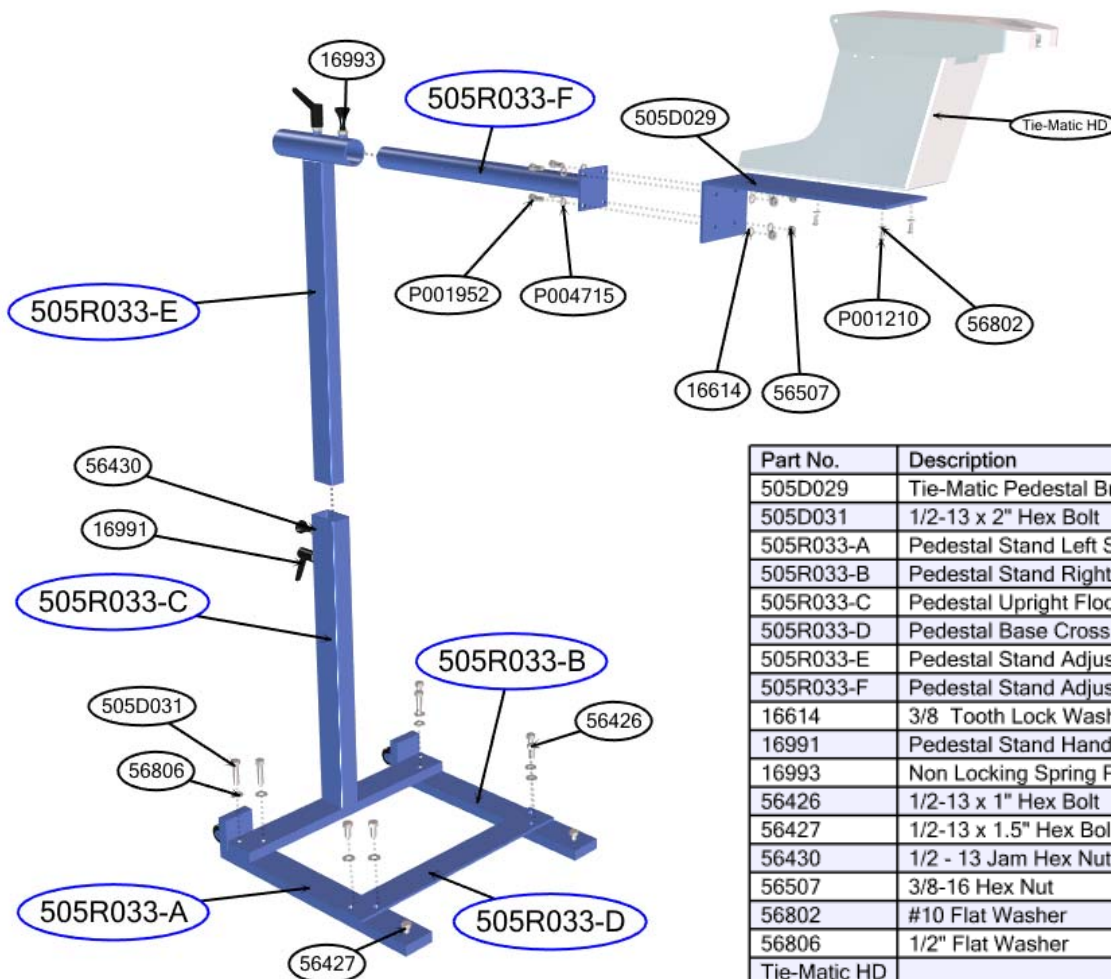


(Figure III-2)

SECTION III: Operation

PEDESTAL STAND ASSEMBLY

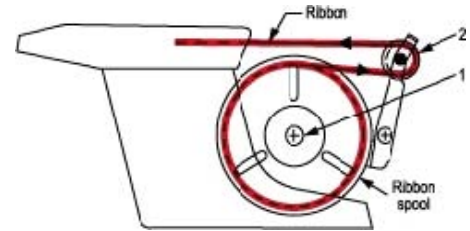
1. Lay out all the parts on the floor. Place legs (A&B) with the wheels, parallel to each other as shown
2. Attach the upright (C) to the legs (A&B) using 4 bolts (505D031)
3. Attach cross bar (D) to the legs using 4 bolts (56426) to the front of the legs
4. Place the adjustment upright (E) inside the stationary upright (C). The adjustment upright is held in place by the non-locking spring plunger and secured by the lever clamp.
5. Place the support plate tube (F) inside the tube on the adjustment upright and secure the lever clamp
6. Mount the pedestal stand bracket (505D029) to the support plate (F).
7. Add the pedestal stand bracket (505D029) to (F) using 4 screws (P001952) and 4 washers (P004715)
8. Screw 4 washers (16614) and 4 Hex Nuts (56507) to secure the bracket to (F)
9. Add HD machine to bracket with 3 washers (56802) and 3 screws (P001210).



| Part No. | Description | Qty |
|--------------|-------------------------------------|-----|
| 505D029 | Tie-Matic Pedestal Bracket | 1 |
| 505D031 | 1/2-13 x 2" Hex Bolt | 4 |
| 505R033-A | Pedestal Stand Left Side Base | 1 |
| 505R033-B | Pedestal Stand Right Side Base | 1 |
| 505R033-C | Pedestal Upright Floor Stand | 1 |
| 505R033-D | Pedestal Base Cross Bar | 1 |
| 505R033-E | Pedestal Stand Adjustable Upright | 1 |
| 505R033-F | Pedestal Stand Adjustable Gooseneck | 1 |
| 16614 | 3/8 Tooth Lock Washer | 4 |
| 16991 | Pedestal Stand Hand Assembly | 2 |
| 16993 | Non Locking Spring Plunger | 2 |
| 56426 | 1/2-13 x 1" Hex Bolt | 4 |
| 56427 | 1/2-13 x 1.5" Hex Bolt | 2 |
| 56430 | 1/2 - 13 Jam Hex Nut | 4 |
| 56507 | 3/8-16 Hex Nut | 4 |
| 56802 | #10 Flat Washer | 3 |
| 56806 | 1/2" Flat Washer | 8 |
| Tie-Matic HD | | 1 |
| P001210 | 10-32 X 1/2 For Foot Stabilizers | 3 |
| P001952 | 3/8-16 x 7/8" Socket Head Cap Screw | 4 |
| P004715 | 3/8 Split Lock Washer | 4 |

SECTION III: Operation

LOADING MATERIAL (HD38/HD58/HD78)



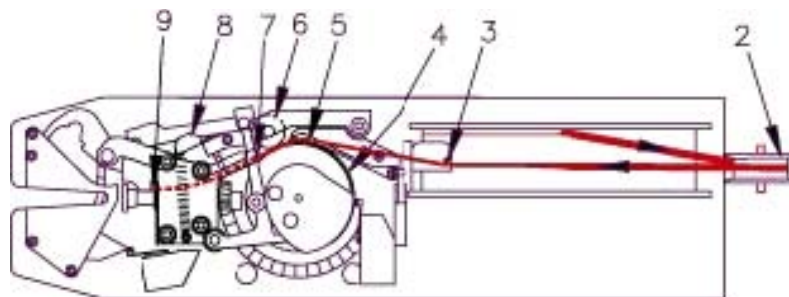
1. Turn OFF machine before loading material. Place spool with label facing out onto Spindle (1). Then tighten Knurled Nut snugly onto the spindle to secure spool.
2. Feed tie material under, then over small roller (2) on Brake Arm and pull toward machine. **(Make sure the ribbon is not twisted)**

VERY IMPORTANT (SEE IMAGE—>)

Check tie material and look for the flat side and the wire side
MAKE SURE THE FLAT SIDE OF THE MATERIAL IS POSITIONED TOWARD THE INSIDE OF THE MACHINE THROUGHOUT THE LOADING PROCESS.



3. Feed material through the Pin on Brake Arm (3), and pull approx 4 inches. Then pull the Idler Wheel (6) out using lever (8) and guide material into the Pinion Sup port Channel (7). (The entry is marked in bright orange with a black stripe over the opening.) Continue slowly inserting the ribbon into Pinion Support Channel (7) (for approx 2 inches) until the ribbon appears just beyond the cutter (9). **Make sure that the ribbon is under the lip of the white plastic ribbon guide at (5).** Close cover and machine is now set and ready to operate.



Note: Make sure material is straight or curved slightly towards machine (11) when inserted into Pinion Support Channel (7), not kinked or curved as per (10).



SECTION III: Operation

LOADING MATERIAL (MODELS HD38/HD58/HD78)



- 1) Unscrew Knurled Nut, then place spool of tie material in right hand with label facing palm.



- 2) Place spool on spindle and tighten Knurled Nut snugly onto the spindle to secure spool



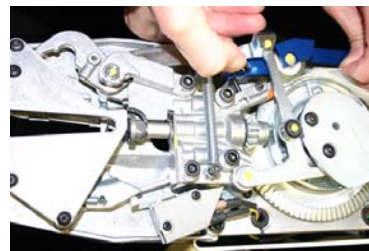
- 3) Feed tie material under small roller on brake arm, then over top of roller and pull towards machine.



- 4) Feed material through the Pin on Brake Arm and pull approx 4 inches.



- 5) Pull the Idler Wheel out, using lever and guide material into the Pinion Support Channel.



- 6) Continue slowly inserting the ribbon into Pinion Support Channel until the ribbon appears just beyond the cutter. Make sure that the ribbon is under the lip of the ribbon guide.

SECTION III: Operation

FUNCTIONAL INFORMATION FOR THE TIE-MATIC MACHINE

HOW IT WORKS

When a product is inserted into the throat of the machine, it depresses a trigger which activates solid state timer, starting the drive gear motor. The gear motor causes the gear segment to operate through one revolution. This one revolution feeds tie material, wraps it around the product, cuts material to required length and twists ends together.

The product has now been tied and is removed by pulling toward the operator. The Tie-Matic HD will repeat tying cycle **ONLY** after tied product is removed and another product inserted into the throat.

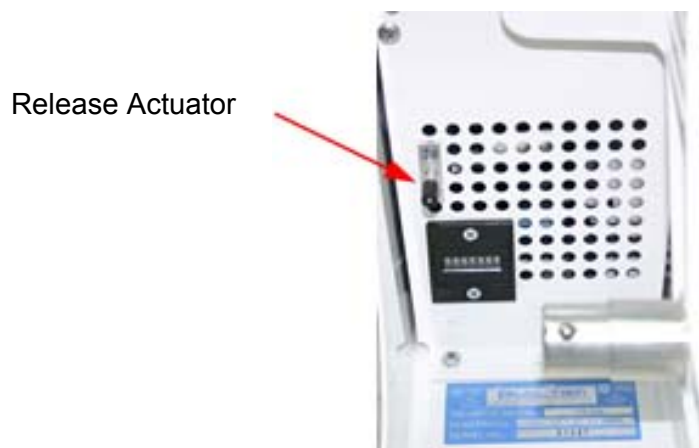
MANUAL RESET TO START POSITION

As a safety precaution, the power switch should **ALWAYS** be turned to the OFF position when inspecting the mechanism for any reason, such as: unloading or reloading twist tie material, cleaning the machine, removing material or performing adjustments.

To manually turn mechanism, you will need to push the Release Actuator in and hold as you manually turn mechanism.

REMOVING JAMS

Pull Idler Wheel lever (blue arm) out and then remove material.



(Figure III-10)

SECTION IV: Maintenance

GENERAL

The Tie-Matic HD machine is designed for simple operation and, with reasonable care and maintenance, will provide long service.

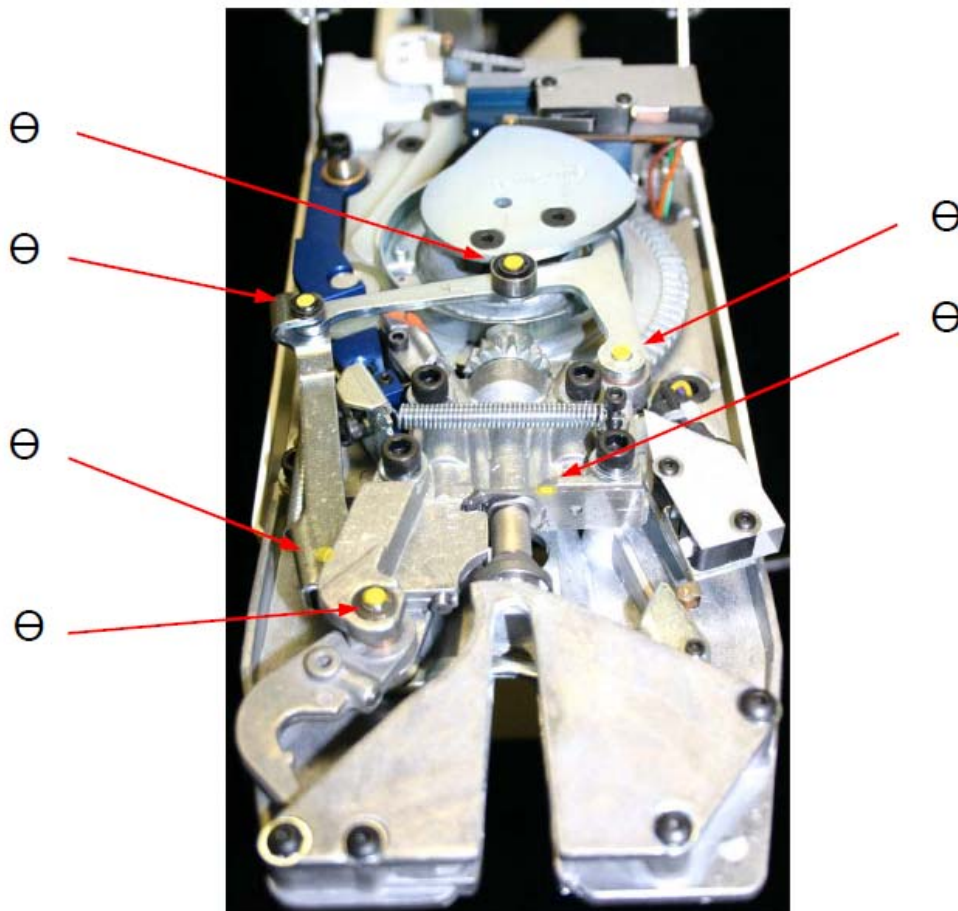
CAUTION

DO NOT OVER-OIL OR OVER-LUBRICATE MACHINE

It is important that the material feed drum and idler pressure wheel be kept free of lubricants. Excess lubrication to the drum will result in an improper tie due to material slippage, requiring a thorough cleaning of the material feed drum and idler wheel before reuse. Excess oil lubrication could damage the motor.

LUBRICATION

1. Turn OFF the machine
2. Air hose the dust from the machine
3. Lubricate the machine with 1 to 2 drops of 3-in-one multi-purpose oil every 50,000 ties. Apply to areas marked with yellow dots or Θ as shown in Figure IV-1 (6 locations).
4. Lubricate gear segment with food machinery lubricant (Bel Ray).



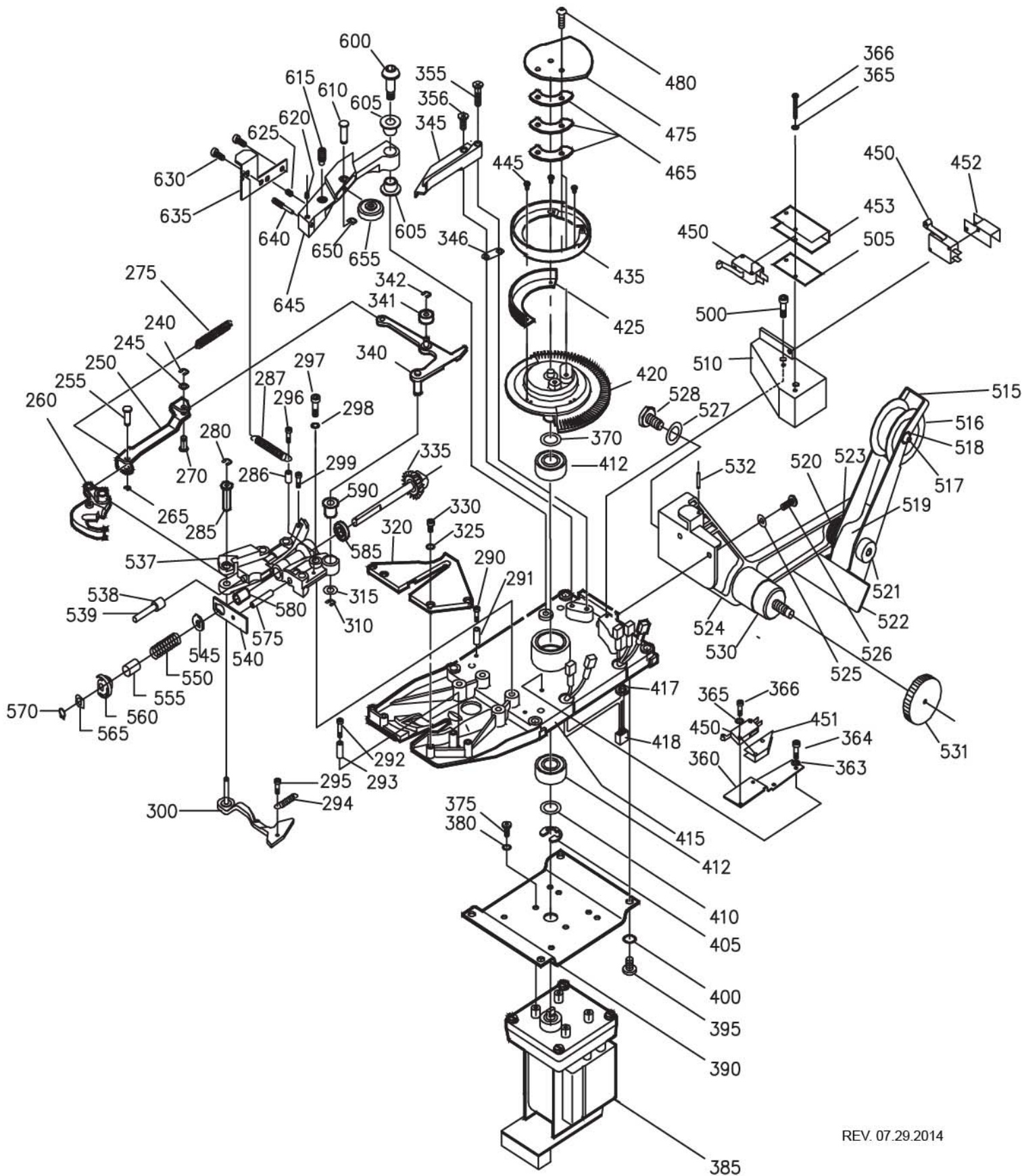
(Figure IV-1)

SECTION V: Troubleshooting

| <u>Condition</u> | <u>Cause</u> | <u>Correction</u> |
|----------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| A. Machine jammed | <ul style="list-style-type: none"> a. Using non-Plas-Ties material b. Improper threading of material c. Oversized bundle to be tied d. Material jammed at throat of machine | <ul style="list-style-type: none"> a. Use Plas-Ties material only b. Check spool & ribbon threading c. Do not exceed capacity diameter of the machine d. Press Release Actuator (See figure III-10 on page 12) to allow the motor to rotate, then remove the jammed material. |
| B. Machine circuit breaker trips | <ul style="list-style-type: none"> a. Motor locked due to jamming | <ul style="list-style-type: none"> a. Press circuit breaker (#90 on Appendix A) and remove material causing the jam |
| C. Material end crushed | <ul style="list-style-type: none"> a. Cutters dull or worn out b. Improperly installed movable cutter | <ul style="list-style-type: none"> a. Replace worn cutter b. b. Install properly |
| D. Machine won't start | <ul style="list-style-type: none"> a. Power cord not connected b. Circuit breaker tripped c. Motor malfunction d. Machine switched off e. Cover micro switch not activated. | <ul style="list-style-type: none"> a. Connect to outlet b. Reset circuit breaker c. Replace motor d. Check ON/OFF switch e. Check switch connection |
| E. Missing Ties | <ul style="list-style-type: none"> a. Loosely wound ribbon on spool b. Oil or grease on material or feed drum c. Defective spool brake spring d. Pinion channel obstructed e. Package too big | <ul style="list-style-type: none"> a. Rethread material taut b. Clean material feed drum c. Replace spring d. Clean channel f. Use larger model of machine |
| F. Tie length short | <ul style="list-style-type: none"> a. Oil or grease on material feed drum b. Brake arm binding c. Material snag in spool | <ul style="list-style-type: none"> a. Clean with appropriate solvent b. Check material alignment on spool c. Take out snag and rethread |
| G. Machine won't stop at end of cycle | <ul style="list-style-type: none"> a. Defective limit switch b. Defective motor | <ul style="list-style-type: none"> a. Replace switch b. Replace motor |

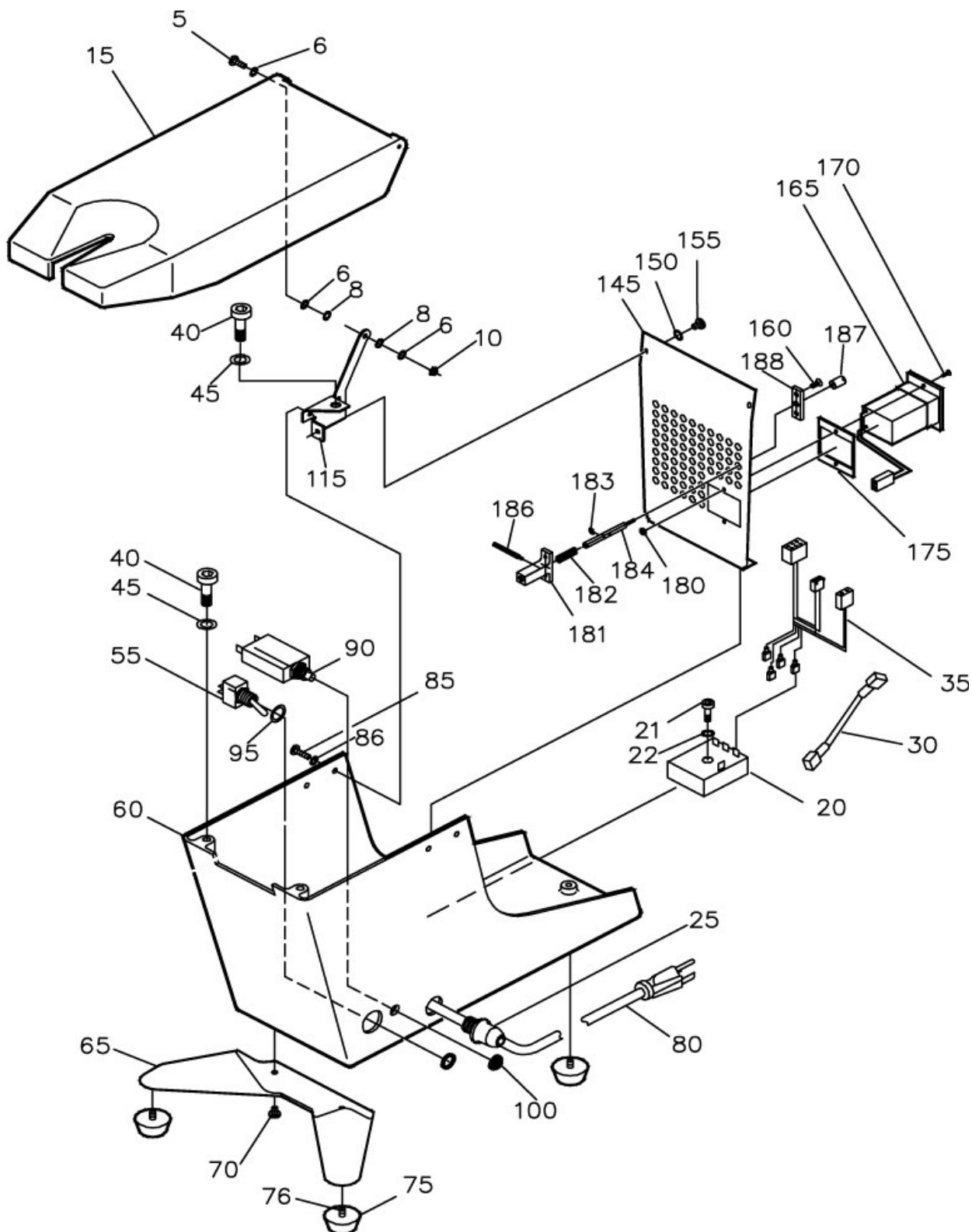
SECTION VI: Machine Drawing

Explosion Chart



SECTION VI: Machine Drawing

Case & Cover



SECTION VII: Parts List

| Item # | Part # | Description | Qty |
|--------|-----------|--------------------------------------------------|-----|
| 5 | P004868 | 1/4-20x3/4 Button Head Cap Screw Stainless Steel | 2 |
| 6 | P001450 | Lockwasher - Internal Tooth .250 | 6 |
| 8 | P005200 | Wave Disc Washer | 4 |
| 10 | P004869 | 1/4-20 Nylon Insert Locknut | 2 |
| 15 | A002045 | Cover / Label - Assembly (HD 38) | 1 |
| 15 | A002050 | Cover / Label - Assembly (HD 58) | 1 |
| 15 | A002055 | Cover / Label - Assembly (HD 78) | 1 |
| 20 | P005265 | Solid State Timer | 1 |
| 21 | P004716 | 10-32 x 1 1/4 Socket Head Cap Screw | 1 |
| 22 | P005354 | # 10 Flat Washer | 1 |
| 25 | M001497 | Strain Relief | 1 |
| 30 | A301160 | 5" Wire Assembly | 1 |
| 35 | A601020 | Bottom Harness | 1 |
| 40 | P004856 | 1/4-20x1 Socket Head Cap Screw | 4 |
| 45 | P001450 | Lockwasher - Internal Tooth .250 | 4 |
| 55 | P001560 | Switch - On / Off | 1 |
| 60 | M002060 | Tie-Matic HD Case | 1 |
| 65 | A101040 | Foot Stabilizer - Assembly | 1 |
| 70 | P001290 | 10-32 x 1/2 PHP Screw | 2 |
| 75 | P001540 | Foot - Rubber | 3 |
| 76 | P001210 | 10-32 x 1/2 PHP Type F Screw | 3 |
| 80 | A301010 | Power Cord - Assembly | 1 |
| 85 | P005295 | 10-32 X 5/16 Button Head Socket Cap Screws | 4 |
| 86 | P001480 | Lockwasher - Internal Tooth No. 10 | 4 |
| 90 | P001580 | Circuit Breaker - 115v 2 amp | 1 |
| 95 | P005355 | Lockwasher - 7/16 | 1 |
| 100 | P001080 | 1/4-20 Hex Nut | 2 |
| 115 | S001180 A | Hinge - Support Bracket L.H. | 1 |
| 115 | S001180 B | Hinge - Support Bracket R.H. | 1 |
| 145 | S001220 | Divider - Case | 1 |
| 150 | P001480 | Lockwasher - Internal Tooth No. 10 | 4 |
| 155 | P001320 | 10-32 x 1/4 Pan Head Screw | 4 |
| 160 | P001940 | 6-32 x 3/16 Flat Head Phillips Screw | 2 |
| 165 | A301020 | Counter - Assembly | 1 |
| 170 | P001630 | 4-40 x 3/8 Flat Head Screw | 2 |
| 175 | M001040 | Seal - Counter | 1 |
| 180 | P001640 | 4-40 Hex Nut | 2 |
| 181 | M001660 | Housing | 1 |

SECTION VII: Parts List

| Item # | Part # | Description | Qty |
|--------|---------|-----------------------------------------------------------|-----|
| 182 | P001970 | Spring | 1 |
| 183 | P001160 | External Snap Ring | 1 |
| 184 | M001670 | Shaft | 1 |
| 186 | M001680 | Shaft | 1 |
| 187 | M001160 | Cushion | 1 |
| 188 | M001650 | Plate | 1 |
| 240 | P001190 | Snap Ring | 1 |
| 245 | P001500 | Curved Spring Washer No. 10 | 1 |
| 250 | S001230 | Link - Needle Operating | 1 |
| 255 | M001260 | Pin - Idler Wheel | 1 |
| 260 | A401590 | Needle - Assembly (HD 38) | 1 |
| | A401595 | Needle - Assembly (HD 58) | 1 |
| | A401600 | Needle - Assembly (HD 78) | 1 |
| 265 | P001170 | Crescent External Ring | 1 |
| 270 | M001080 | Pin - Clevis | 1 |
| 275 | M001488 | Spring, Needle Return | 1 |
| 280 | P001140 | E- Ring | 1 |
| 285 | M001220 | Sleeve, Needle Pivot | 1 |
| 286 | P005352 | 6-32 x 3/8 Hex Nut | 1 |
| 287 | M001489 | Idler Arm Tension Spring (HD38 & HD58) | 1 |
| 287 | M001475 | Idler Arm Tension Spring (HD78) | 1 |
| 290 | P005328 | 4-40 x 5/8 Socket Head Cap Screw | 1 |
| 291 | M001496 | Spacer, Needle Return Spring | 1 |
| 292 | M005328 | 4-40 x 5/8 Socket Head Cap Screw | 1 |
| 293 | M001498 | Spring Spacer for Trigger Spring | 1 |
| 294 | M001490 | Spring - Trigger Return | 1 |
| 295 | P004368 | 440 X 1/4 Socket Head Cap Screw Stainless Steel 0404 CSSS | 1 |
| 296 | P005357 | 6-32 x 1/2 Socket Head Cap Screw | 1 |
| 297 | P004856 | 1/4-20 X 1 Socket Head Cap Screw | 4 |
| 298 | P001450 | Lockwasher - Internal Tooth .250 | 4 |
| 299 | P005326 | 6-32 x 1/4 Socket Head Cap Screw | 1 |
| 300 | S001025 | Trigger | 1 |
| 310 | P001160 | External Snap Ring | 1 |
| 315 | P001730 | Shim - Pinion Support | 1 |
| 320 | M001340 | Cover - Trigger (HD 38) | 1 |
| | M001600 | Cover - Trigger (HD 58) | 1 |
| | M001610 | Cover - Trigger (HD 78) | 1 |
| 325 | P001470 | Lockwasher - Internal Tooth No. 8 | 4 |

SECTION VII: Parts List

| Item # | Part # | Description | Qty |
|--------|---------|-----------------------------------------------------------|-----|
| 330 | P005235 | 8-32 x 3/8 Button Head Cap Screw | 4 |
| 335 | A301075 | HD Pinion / Shaft - Assembly | 1 |
| 340 | A401610 | Needle, Actuating Assembly | 1 |
| 341 | P001510 | Roller Bearing | 1 |
| 342 | P001190 | Snap Ring | 1 |
| 345 | M001021 | Guide - Tape Feed Modified | 1 |
| 346 | S001050 | Shim - Material Guide | A/R |
| 355 | P005220 | 10-32 x 3/4 Flat Head Socket Screw | 1 |
| 356 | P005210 | 10-32 x 5/8 Flat Head Socket Screw | 1 |
| 360 | M029285 | Bracket, Trigger Limit Switch | 1 |
| 363 | P001460 | Lock Washer - Internal Tooth #4 | 2 |
| 364 | P005326 | 6-32 x 1/4 Socket Head Cap Screw | 2 |
| 365 | P005353 | # 4 Flat Washer | 2 |
| 366 | P004867 | 4-40 x 5/8 Button Head Cap Screw | 2 |
| 370 | P001720 | Shim - Gear Segment | A/R |
| 375 | P005320 | 8-32 x 5/16 Soc Cap Stainless | 4 |
| 380 | P001470 | Lockwasher - Internal Tooth No. 8 | 4 |
| 385 | P001740 | Motor - Gear | 1 |
| 390 | S001170 | Plate - Motor Mount | 1 |
| 395 | P005310 | 1/4-20 x 3/8 Socket Head Cap Stl Blk | 4 |
| 400 | P001450 | Lockwasher - Internal Tooth .250 | 4 |
| 405 | P001150 | E- Ring Bowed | 1 |
| 410 | P001720 | Shim - Frame | A/R |
| 412 | P001030 | Bearing - Radial Ball | 2 |
| 415 | M002030 | Frame - Gear Support (HD 38) | 1 |
| | M002035 | Frame - Gear Support (HD 58) | 1 |
| | M002040 | Frame - Gear Support (HD 78) | 1 |
| 417 | P001550 | Grommet | 2 |
| 418 | A701060 | Limit Switch Harness | 1 |
| 420 | A501035 | HD Gear Segment - Assembly | 1 |
| 425 | S001145 | Drum - Material Feed (HD 38) | 1 |
| | S001245 | Drum - Material Feed (HD 58) | 1 |
| | S001255 | Drum - Material Feed (HD 78) | 1 |
| 435 | S001155 | Guard - Cam Return | 1 |
| 445 | P004368 | 440 X 1/4 Socket Head Cap Screw Stainless Steel 0404 CSSS | 3 |
| 450 | P001570 | Micro Switch | 3 |
| 451 | M001501 | Insulator, Trigger Limit Switch | 1 |
| 452 | M001499 | Insulator, Cover Limit Switch | 1 |
| 453 | M001500 | Insulator, Cam Limit Switch | 1 |

SECTION VII: Parts List

| Item # | Part # | Description | Qty |
|--------|----------|-----------------------------------------|-----|
| 465 | S001210 | Cam - Laminate | 3 |
| 475 | S001200B | Cam - Needle | 1 |
| 480 | P005210 | 10-32 x 5/8 Flat Head Socket Screw | 2 |
| 500 | P005328 | 4-40 x 5/8 Socket Head Cap Screw | 2 |
| 505 | M001200 | Insulator, Spacer - Switch | 1 |
| 510 | M021012 | Switch Mount | 1 |
| 515 | S001090 | Spool, Brake Arm | 1 |
| 516 | M001315 | Roller, Brake | 1 |
| 517 | M001120 | Shaft, Brake Arm | 1 |
| 518 | P001090 | Nut-Push .188 Shaft Diameter | 2 |
| 519 | S001280 | Shield, Brake Arm | 1 |
| 520 | M001550 | Spring - Brake Arm | 1 |
| 521 | P001350 | 3/8 - 16 x 1/2 x 1-1/2 Shoulder Screw | 1 |
| 522 | M001030 | Plate, Brake Arm | 1 |
| 523 | P001040 | Bushing, Plastic | 2 |
| 524 | M001101 | Beam, Brake Arm | 1 |
| 525 | P001480 | Lockwasher - Internal Tooth No. 10 | 2 |
| 526 | P001290 | 10-32 x 1/2 PHP Screw | 2 |
| 527 | P001490 | Washer - Nylon .296 ID x .750 OD x .032 | 1 |
| 528 | P001360 | 1/4-20 x 1/2 Hex Head Cap Screw | 1 |
| 530 | M001470` | Spindle | 1 |
| 531 | M001471 | Knob, Knurled Nut | 1 |
| 532 | P001130 | Spring Pin .125 x .563 | 2 |
| 537 | M001135 | Pinion Support | 1 |
| 538 | M001160 | Cushion | 1 |
| 539 | M001170 | Pin, Needle Stop | 1 |
| 540 | M001380 | Stationary Cutter Plate | 1 |
| 545 | M001620 | Cutter, Movable | 1 |
| 550 | M001150 | Spring, Cutter | 1 |
| 555 | M001190 | Cover, Spring | 1 |
| 560 | M001330 | Twister, Ribbon | 1 |
| 565 | S001060 | Deflector | 1 |
| 570 | P001180 | Snap Ring | 1 |
| 575 | M001180 | Locator Pin | 1 |
| 580 | P001620 | Bushing | 1 |
| 585 | P001020 | Bearing | 1 |
| 590 | P001010 | Bushing | 1 |
| 600 | M001491 | Shoulder Bolt, Modified 5/16 x 5/8 | 1 |
| 605 | M001495 | Flange Sleeve Bearing | 2 |

SECTION VII: Parts List

| Item # | Part # | Description | Qty |
|--------|---------|-------------------------------------|-----|
| 610 | M001260 | Pin, Idler Wheel | 1 |
| 615 | M001485 | Modified Set Screw | 1 |
| 620 | P005351 | 8/32 x 1/4 Socket Set Screw | 1 |
| 625 | P005350 | 8/32 x 3/16 Hex Socket Set Screw | 1 |
| 630 | P005320 | 8/32 x 5/16 Socket Head Cap Screw | 2 |
| 635 | M001486 | Spring Bracket, Pivot Drive | 1 |
| 640 | M001494 | Modified, 8/32 x 1 Socket Set Screw | 1 |
| 645 | M001480 | Pivot Drive Arm | 1 |
| 650 | P001160 | External Snap Ring | 1 |
| 655 | A401075 | Drive Wheel Assembly | 1 |

SECTION VIII: Sub Assembly Parts List

| Item # | Part # | Sub-Assemblies | Qty |
|--------|-----------|-----------------------------------------------------------|-----|
| | A401535 / | Master Pinion Support Assembly (HD38) | |
| | A401536 / | Master Pinion Support Assembly (HD58) | |
| | A401537 | Master Pinion Support Assembly (HD78) | |
| 240 | P001190 | Snap Ring | 1 |
| 245 | P001500 | Curved Spring Washer No. 10 | 1 |
| 250 | S001230 | Link - Needle Operating | 1 |
| 255 | M001260 | Pin - Idler Wheel | 1 |
| 260 | A401590 | Needle - Assembly (HD 38) | 1 |
| | A401595 | Needle - Assembly (HD 58) | 1 |
| | A401600 | Needle - Assembly (HD 78) | 1 |
| 265 | P001170 | Crescent External Ring | 1 |
| 270 | M001080 | Pin - Clevis | 1 |
| 275 | M001488 | Spring, Needle Return | 1 |
| 280 | P001140 | E- Ring | 1 |
| 285 | M001220 | Sleeve, Needle Pivot | 1 |
| 286 | P005352 | 6-32 x 3/8 Hex Nut | 1 |
| 287 | M001489 | Idler Arm Tension Spring (HD38 & HD58) | 1 |
| 287 | M001475 | Idler Arm Tension Spring (HD78) | 1 |
| 290 | P005328 | 4-40 x 5/8 Socket Head Cap Screw | 1 |
| 291 | M001496 | Spacer, Needle Return Spring | 1 |
| 292 | M005328 | 4-40 x 5/8 Socket Head Cap Screw | 1 |
| 293 | M001498 | Spring Spacer for Trigger Spring | 1 |
| 294 | M001490 | Spring - Trigger Return | 1 |
| 295 | P004368 | 440 X 1/4 Socket Head Cap Screw Stainless Steel 0404 CSSS | 1 |
| 296 | P005357 | 6-32 x 1/2 Socket Head Cap Screw | 1 |
| 297 | P004856 | 1/4-20 X 1 Socket Head Cap Screw | 4 |
| 298 | P001450 | Lockwasher - Internal Tooth .250 | 4 |
| 299 | P005326 | 6-32 x 1/4 Socket Head Cap Screw | 1 |
| 300 | S001025 | Trigger | 1 |
| 310 | P001160 | External Snap Ring | 1 |
| 315 | P001730 | Shim - Pinion Support | 1 |
| 335 | A301075 | HD Pinion / Shaft - Assembly | 1 |
| 340 | A401610 | Needle, Actuating Assembly | 1 |
| 341 | P001510 | Roller Bearing | 1 |
| 342 | P001190 | Snap Ring | 1 |
| 537 | M001135 | Pinion Support | 1 |
| 538 | M001160 | Cushion | 1 |
| 539 | M001170 | Pin, Needle Stop | 1 |
| 540 | M001380 | Stationary Cutter Plate | 1 |
| 545 | M001620 | Cutter, Movable | 1 |

SECTION VIII: Sub Assembly Parts List

| Item # | Part # | Sub-Assemblies | Qty |
|--------|-------------------------------------|-----------------------------------------------------|-----|
| | A401535 / A401536 / A401537 / | Master Pinion Support Assembly (CONTINUED) | |
| 550 | M001150 | Spring, Cutter | 1 |
| 555 | M001190 | Cover, Spring | 1 |
| 560 | M001330 | Twister, Ribbon | 1 |
| 565 | S001060 | Deflector | 1 |
| 570 | P001180 | Snap Ring | 1 |
| 575 | M001180 | Locator Pin | 1 |
| 580 | P001620 | Bushing | 1 |
| 585 | P001020 | Bearing | 1 |
| 590 | P001010 | Bushing | 1 |
| | A401540 | Pinion Support - Assembly | |
| 299 | P005326 | 6-32 x 1/4 Socket Head Cap Screw | 1 |
| 335 | A301075 | HD Pinion / Shaft - Assembly | 1 |
| 537 | M001135 | Pinion Support | 1 |
| 538 | M001160 | Cushion | 1 |
| 539 | M001170 | Pin, Needle Stop | 1 |
| 540 | M001380 | Stationary Cutter Plate | 1 |
| 545 | M001620 | Cutter, Movable | 1 |
| 550 | M001150 | Spring, Cutter | 1 |
| 555 | M001190 | Cover, Spring | 1 |
| 560 | M001330 | Twister, Ribbon | 1 |
| 565 | S001060 | Deflector | 1 |
| 570 | P001180 | Snap Ring | 1 |
| 575 | M001180 | Locator Pin | 1 |
| 580 | P001620 | Bushing | 1 |
| 585 | P001020 | Bearing | 1 |
| 590 | P001010 | Bushing | 1 |
| | A401545 | Pinion Support | |
| 299 | P005326 | 6-32 x 1/4 Socket Head Cap Screw | 1 |
| 537 | M001135 | Pinion Support | 1 |
| 538 | M001160 | Cushion | 1 |
| 539 | M001170 | Pin, Needle Stop | 1 |
| 580 | P001620 | Bushing | 1 |
| 585 | P001020 | Bearing | 1 |
| 590 | P001010 | Bushing | 1 |

SECTION VIII: Sub Assembly Parts List

| Item # | Part # | Sub-Assemblies | Qty |
|--------|----------|---------------------------------------------------------|-----|
| | A401520 | Gear Support Frame - Assembly (HD 38) | |
| 415 | M002030 | Frame - Gear Support (HD 38) | 1 |
| 412 | P001030 | Bearing - Radial Ball | 2 |
| 417 | P001550 | Grommet | 2 |
| | A401525 | Gear Support Frame - Assembly (HD 58) | |
| 415 | M002035 | Frame - Gear Support (HD 58) | 1 |
| 412 | P001030 | Bearing - Radial Ball | 2 |
| 417 | P001550 | Grommet | 2 |
| | A401530 | Gear Support Frame - Assembly (HD 78) | |
| 415 | M002040 | Frame - Gear Support (HD 78) | 1 |
| 412 | P001030 | Bearing - Radial Ball | 2 |
| 417 | P001550 | Grommet | 2 |
| | A401510 | Master Gear Segment Assembly (HD38) | |
| | A401511 | Master Gear Segment Assembly (HD58) | |
| | A401512 | Master Gear Segment Assembly (HD78) | |
| 420 | A501035 | HD Gear Segment - Assembly | 1 |
| 425 | S001145 | Drum - Material Feed (HD 38) | 1 |
| | S001245 | Drum - Material Feed (HD 58) | 1 |
| | S001255 | Drum - Material Feed (HD 78) | 1 |
| 435 | S001155 | Guard - Cam Return | 1 |
| 445 | P004368 | 440 X ¼ Socket Head Cap Screw Stainless Steel 0404 CSSS | 3 |
| 465 | S001210 | Cam - Laminate | 3 |
| 475 | S001200B | Cam - Needle | 1 |
| 480 | P005210 | 10-32 x 5/8 Flat Head Socket Screw | 2 |
| | A401550 | Idler Wheel Assembly | |
| 287 | M001489 | Idler Arm Tension Spring (HD38 & HD58) | 1 |
| 287 | M001475 | Idler Arm Tension Spring (HD78) | 1 |
| 600 | M001491 | Shoulder Bolt, Modified 5/16 x 5/8 | 1 |
| 605 | M001495 | Flange Sleeve Bearing | 2 |
| 610 | M001260 | Pin, Clevis | 1 |
| 615 | M001485 | Modified Set Screw | 1 |
| 620 | P005351 | 8-32 x 1/4 Socket Set Screw | 1 |
| 625 | P005350 | 8-32 x 3/16 Hex Socket Set Screw | 1 |
| 630 | P005320 | 8/32 x 5/16 Socket Head Cap Screw | 2 |
| 635 | M001486 | Spring Bracket, Pivot Drive | 1 |
| 640 | M001494 | Modified, 8/32 x 1 Socket Set Screw | 1 |
| 645 | M001480 | Pivot Drive Arm | 1 |
| 650 | P001160 | External Snap Ring | 1 |
| 655 | A401075 | Drive Wheel Assembly | 1 |

SECTION VIII: Sub Assembly Parts List

| Item # | Part # | Sub-Assemblies | Qty |
|----------------|----------|-----------------------------------------------|-----|
| A401555 | | Brake - Complete Assembly | |
| 515 | S001090 | Spool, Brake Arm | 1 |
| 516 | M001315 | Roller, Brake | 1 |
| 517 | M001120 | Shaft, Brake Arm | 1 |
| 518 | P001090 | Nut-Push .188 Shaft Diameter | 2 |
| 519 | S001280 | Shield, Brake Arm | 1 |
| 520 | M001550 | Spring - Brake Arm | 1 |
| 521 | P001350 | Shoulder - Screw #5024ss 3/8-16 x 1/2 x 1-1/2 | 1 |
| 522 | M001030 | Plate, Brake Arm | 1 |
| 523 | P001040 | Split Bearing, Nyliner 8L1-FF | 2 |
| 524 | M001101 | Beam, Brake Arm | 1 |
| 525 | P001480 | Lockwasher - Internal Tooth No. 10 | 2 |
| 526 | P001290 | 10-32 x 1/2 PHP Screw | 2 |
| 527 | P001490 | Washer, Nylon .296 ID x .750 OD x .032 | 1 |
| 528 | P001360 | 1/4-20 x 1/2 Hex Head Cap Screw | 1 |
| 530 | M001470` | Spindle Assembly | 1 |
| 531 | M001471 | Knob, Knurled Nut | 1 |
| 532 | P001130 | .125 x .563 Roll Spring Pin | 2 |
| A301150 | | Brake Arm, Complete Spool Assembly | |
| 515 | S001090 | Spool, Brake Arm | 1 |
| 516 | M001315 | Roller, Brake | 1 |
| 517 | M001120 | Shaft, Brake Arm | 1 |
| 518 | P001090 | Push Nuts | 2 |
| 519 | S001280 | Shield, Brake Arm | 1 |
| 522 | M001030 | Plate, Brake Arm | 1 |
| 523 | P001040 | Split Bearing, Nyliner | 2 |
| A301152 | | Brake Arm – Spool Sub Assembly | |
| 515 | S001090 | Spool, Brake Arm | 1 |
| 519 | S001280 | Shield, Brake Arm | 1 |
| 522 | M001030 | Plate, Brake Arm | 1 |

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TOLL-FREE: (800) 854-0137

PHONE: (714) 542-4487

FAX: (714) 972-2978

Email: info@plasties.com

Website: www.plasties.com

14272 Chambers Road

Tustin, CA 92780

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