

OPERATION, PARTS AND SAFETY MANUAL



SIGNODE®

**LBX-2000
POWER STRAPPING MACHINE**

**IMPORTANT!
DO NOT DESTROY**

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

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

READ ALL INSTRUCTIONS BEFORE OPERATING THIS SIGNODE PRODUCT

SIGNODE • 3620 WEST LAKE AVENUE • GLENVIEW, ILLINOIS 60025 U.S.A.

CONGRATULATIONS

Thank you for purchasing your LBX-2000 Walk-Up Strapping Machine. The LBX-2000 Strapping Machine was designed and built in the USA by Signode, Glenview, Illinois and West Union, Iowa. The LBX-2000 has been designed to be the most reliable, maintenance free strapping machine ever produced for customers with your packaging needs. The revolutionary design of the LBX-2000 eliminates many of the adjustments and tuning required by strapping machines of the past. The innovative design of this machine allows for every maintenance part to be replaced easily and quickly with very little or no instruction.

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

Thank you for your help.

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

SECTION 1. GENERAL MACHINE INFORMATION

SECTION 2. MACHINE SET-UP & INSTALLATION

SECTION 3. OPERATING THE LBX-2000

SECTION 4. MAINTENANCE & TROUBLESHOOTING

SECTION 5. ELECTRICAL INFORMATION

SECTION 6. FRAME & DISPENSER INFORMATION

SECTION 7. STRAPPING HEAD INFORMATION

SECTION 8. SUPPLEMENTAL INFORMATION

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

SAFETY INSTRUCTIONS

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

OPERATING INSTRUCTIONS

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

MAINTENANCE

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

MOVING MACHINE PARTS



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

MACHINE INSTALLATION

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

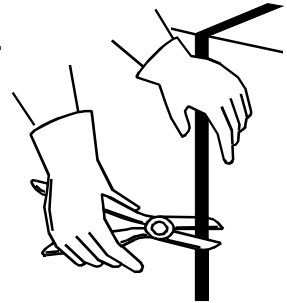
SAFETY INSTRUCTIONS

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

PERSONAL PROTECTION



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



ENVIRONMENTAL INFORMATION

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

LOCKOUT/TAGOUT



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

MOVING THE MACHINE

Wheel kits are standard for Signode general purpose machines. Do not hoist or move the machine using a forklift.

MACHINE SPECIFICATIONS (1-1)

MAJOR MACHINE COMPONENTS (1-2)

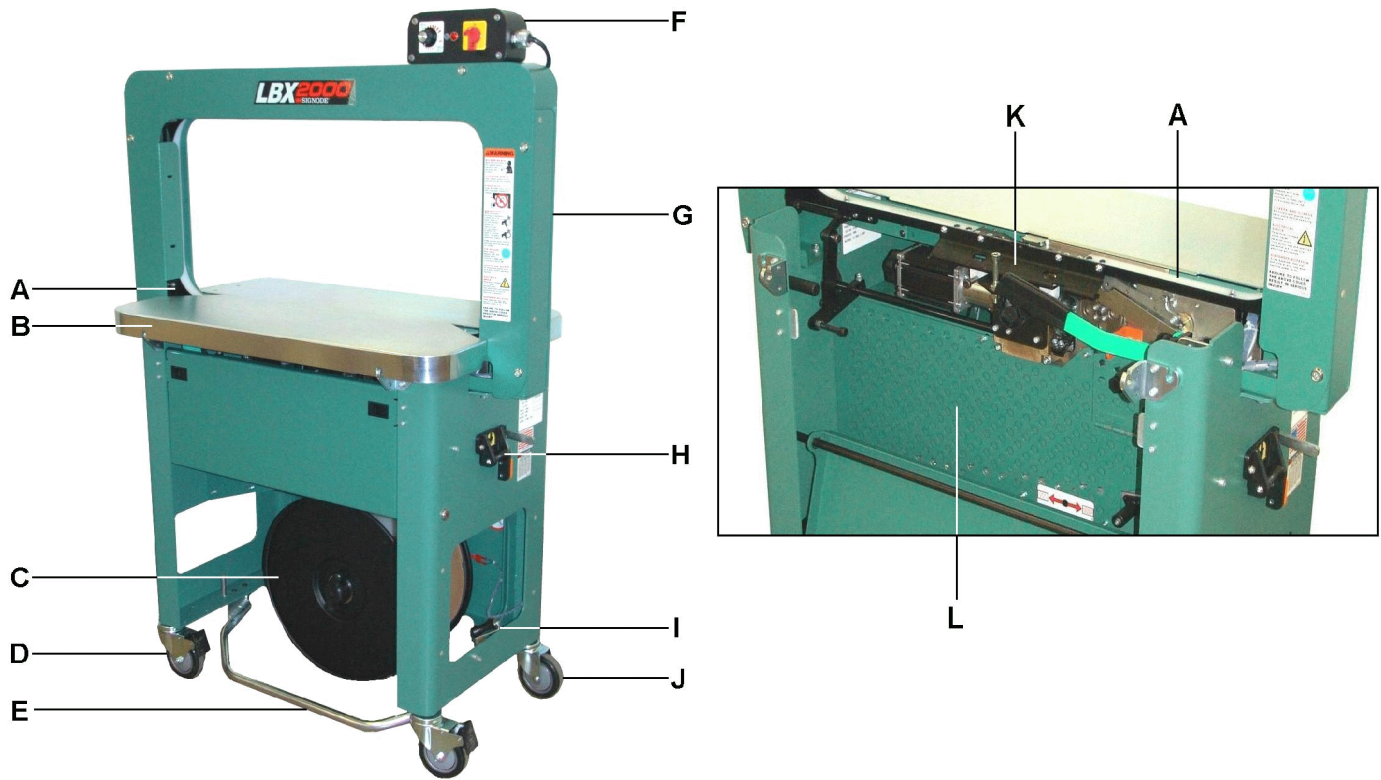
DISCONNECT AND LOCK OUT PROCEDURES (1-3)

SECTIONS-1

LBX-2000 WALK-UP MACHINE SPECIFICATIONS

STRAP SIZES:	100 Series Strapping, 5mm wide.
CYCLE RATE:	Will depend upon size of chute, package and machine options.
PACKAGE SIZE:	Maximum package size depends upon the size of the chute. See section 2.
MACHINE DIMENSIONS:	See Section 2.
STRAP TENSION RANGE:	Variable from 2 to 60 lbs.
AC INPUT VOLTAGE:	<ul style="list-style-type: none">● 115 Volt, 60 Hertz● 230 Volt, 50 Hertz
SYSTEM FAULT PROTECTION:	Fused
SYSTEM DISCONNECT:	HP Rated switch
DRIVE MOTORS:	<ul style="list-style-type: none">● Infeed: 3000 RPM (GR63x25)● Camshaft: 4000 RPM, 100W (BG65050SI & PLG52 36:1)● Tension: 4000 RPM, 100W (BG65x50 & PLG52 8:1)● Feed & Take-Up: 4000, 100W (BG65x50SI)
OPERATING HEIGHT:	See Section 2

MAJOR MACHINE COMPONENTS



A - Chute Track

B - Table Top

C - Strap Dispenser

D - Locking Swivel Caster

E - Foot Pedal

F - Operator Controls

G - Chute Arch

H - Strap Infeed & Cutter

I - Strap Guide

J - Swivel Caster

K - Strapping Head

L - Accumulator Box

MACHINE DISCONNECT AND LOCK-OUT PROCEDURES

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

WARNING

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

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

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

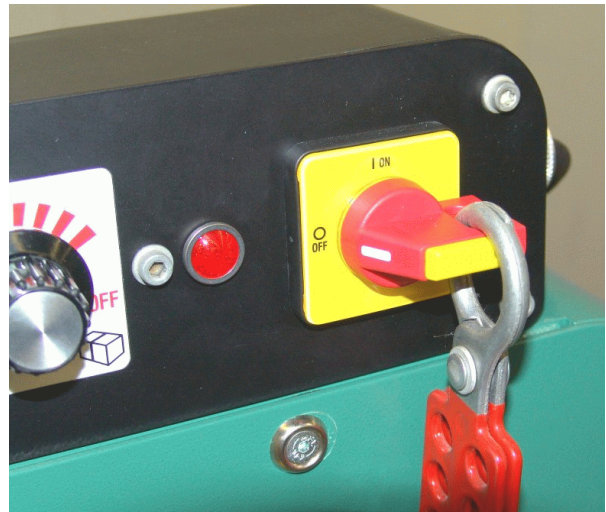
ELECTRICAL

DISCONNECT SWITCH - The main disconnect switch is located with the operator control panel.

To disconnect/lock-out electrical power to the machine proceed as follows.

- Turn the main disconnect switch to the OFF position.
- Locate an appropriate locking hole on the switch, more than one may be provided, and apply a locking device.

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



INSTALLATION & SET-UP:

MAJOR MACHINE DIMENSIONS (2-1)

HOT KNIFE TEMPERATURE (2-2)

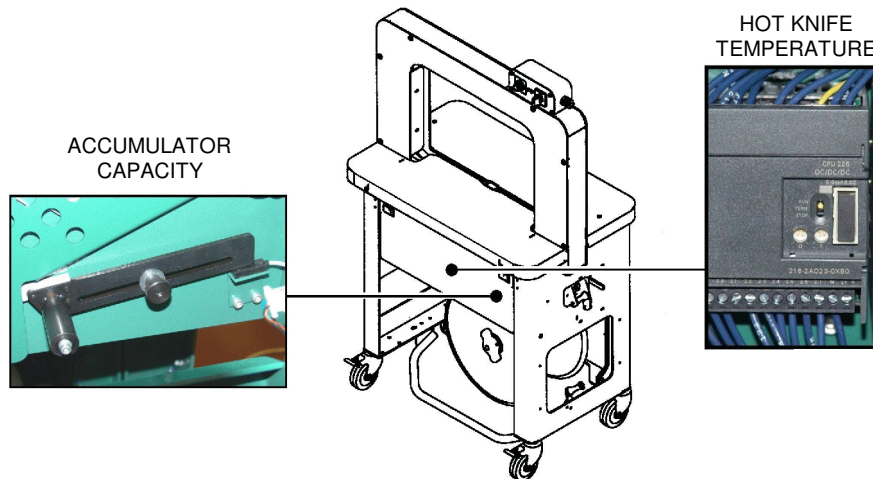
ACCUMULATOR BOX (2-2)

SECTIONS-2

INSTALLATION & SET-UP

Upon arrival of the LBX-2000, the following steps should be taken:

1. Machine should be uncrated.
2. Visually inspect the machine for any possible transit damage.
3. Move the machine to the location for the strapping operation.
4. Identify the accumulator capacity and hot knife temperature adjustment locations. Continue to make any necessary inspections or changes described in the following topics.



MACHINE DIMENSIONS & CLEARANCE REQUIREMENTS

Floor space requirements are governed by the overall dimensions of the machine, plus adequate working clearances.

A - Table top height: 865mm (34")

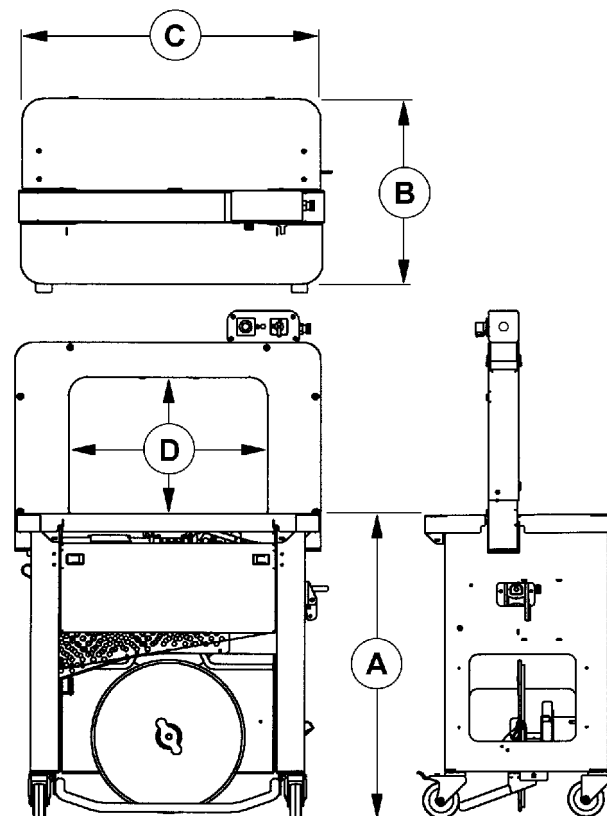
B - Table top length: 510mm (20")

C - Table top width: 840mm (33")

D - Chute Sizes (Maximum Package):

20"W x 15"H (510mm x 380mm)

28"W x 15"H (710mm x 380mm)



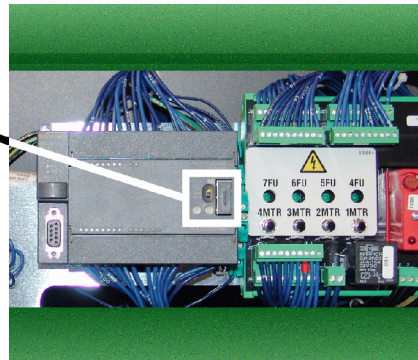
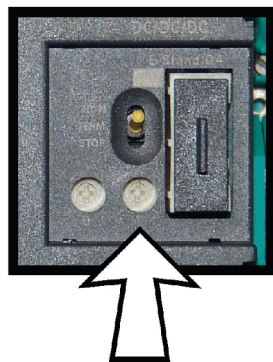
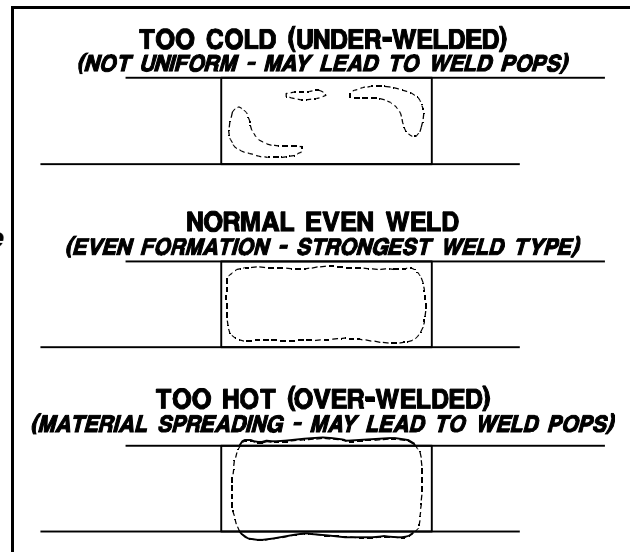
HOT KNIFE TEMPERATURE CONTROL

The Hot Knife temperature control is used to adjust the hot knife temperature if necessary due to the application environment and/or the strap type being used. The temperature control is found on the main PLC as indicated by "1".

NOTE: Turning the Hot Knife Temperature control to the hottest position does not produce the best strap welding.

Turn the temperature control clockwise to increase the hot knife temperature. Turn the temperature control counter-clockwise to decrease the hot knife temperature.

Adjust the hot knife temperature to achieve the best possible strap joint.



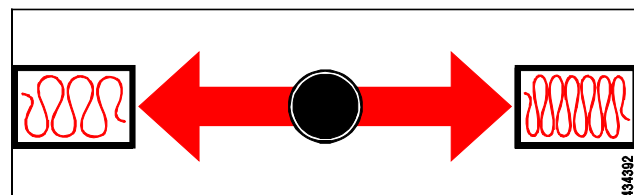
ACCUMULATOR BOX

The purpose of the accumulator box is to store/reserve strapping to be used when the machine is rapidly cycling. The amount of strap in the accumulator box should be initially adjusted for the size/type of packages being strapped and the strap being used. The amount of strap in the accumulator box is controlled by changing the thumbscrew's position for more or less strap.

Generally, for smaller packages the adjustment knob should be adjusted for less strap to be in the accumulator box. Larger packages should have the accumulator set for more strap.

The accumulator box should also be re-adjusted when changing from one strap size to another to compensate for the weight of the strap.

NOTE: Too much strap sitting in the accumulator box over an extended period could lead to strap jams or mis-feeds. Not enough strap in the accumulator box could lead to short feeds when continuously strapping larger packages. If either of these situations occur, readjust the accumulator box capacity as required.



OPERATOR CONTROLS (3-1)

STRAPPING A PACKAGE (3-1)

LOADING & THREADING STRAP (3-2)

SECTIONS-3

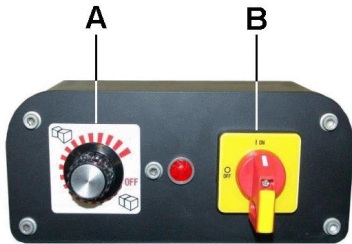
OPERATING CONTROLS

A - VARIABLE TENSION CONTROL

Rotate this control clockwise for more tension. Rotate counter-clockwise to decrease tension or to turn the tension off (full CCW position).

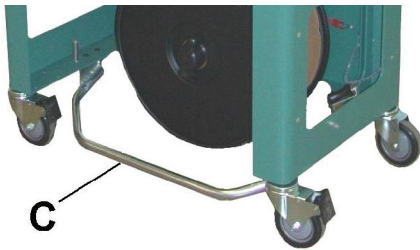
B - MAIN DISCONNECT SWITCH

The Main Disconnect Switch is operated by rotating between ON (I) and OFF (0) as needed.



C - CYCLE START BAR

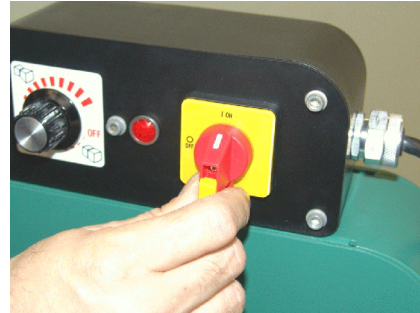
To apply a strap to a package, step on and off the Cycle Bar.



STRAPPING A PACKAGE

Review Operating Controls on the previous page to efficiently operate this machine.

1. Turn on the Main Power (B) for the machine.



2. Wait a minimum of 20 seconds for the Hot Knife and other machine components to properly warm up.
3. Place a bundle on the table top of the machine centered within the chute arch.



4. Set the Variable Tension (A) control knob if required.
5. Step on the Cycle Bar (C) to apply a strap to the package.



6. Turn OFF the machine when not in use.

LOADING & THREADING STRAP

To install a coil in the dispenser flange assembly proceed as follows:

! WARNING

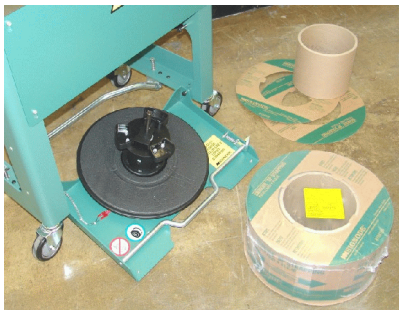
Disconnect electrical power to machine before proceeding.

NOTE: Coils of strap are typically packaged in transparent shrink wrap and should be left intact during installation.

1. Open the dispenser access door by pulling on the handle which releases the door lock.



2. Remove the locking nut and outer flange from the dispenser. Discard the used core from the machine. Machine is now ready for a new coil of strapping.



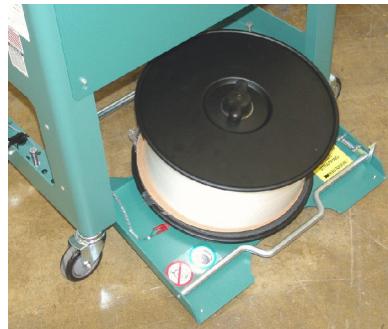
3. Place a new coil of strapping on the rear mounting flange of the coil assembly.



Reinstall the outer flange and locking nut.



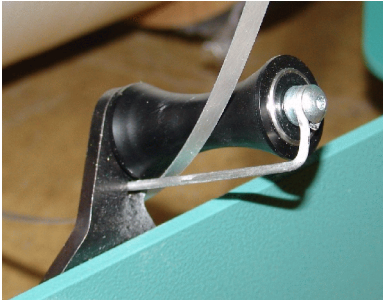
4. Remove the plastic film and corrugated band from the coil.



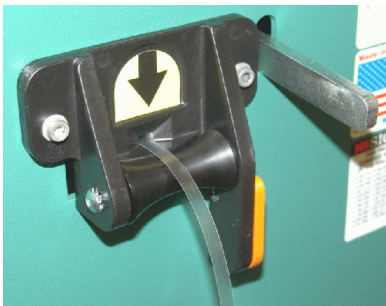
Close the dispenser access door. Make sure that the door latch locks the door in the upright position.

... Continued

5. Thread the strap end under the roller guide on the frame.



Lift the loading lever and insert the strap end into the machine.



6. Turn the machine power back to ON.



The machine will automatically fill the accumulator box with strap.

7. Step once on the Cycle Bar once to finish the auto loading sequence.



The machine will thread the strap chute and place itself into Home Position. Regular strapping can now be performed.

SCHEDULED MAINTENANCE (4-1)

LUBRICATION (4-1)

TROUBLE SHOOTING (4-2)

SECTION-4

SCHEDULED MAINTENANCE

DAILY

No Daily maintenance is required for the LBX-2000 strapping machine.

WEEKLY

1. Inspect for proper strap weld and cut off.
2. Clean the machine of all debris especially around the sealing head, hot knife area, strap guides, infeed wheels and accumulator box. Use compressed air or a stiff brush when cleaning.

MONTHLY

1. Clean the hot knife, anvil, platen, grippers and surrounding area. Use compressed air or a stiff brush when cleaning.
2. Inspect the feed and tension wheels for wear and /or damage. Replace if necessary.
3. Check the chute assembly for proper operation. Inspect the chute for the following:
 - Correct stripper finger action and strap release.
 - Chute track should be fully seated against chute arch.
 - Chute opener should operate smoothly.

MACHINE LUBRICATION

The LBX-2000 machine is constructed entirely of self lubricating components and does not require any additional lubrication of any form.

TROUBLESHOOTING

The following items are the most common machine symptoms if problems occur. For symptoms or remedies not shown, contact your Signode service representative for additional information and details. The following machine symptoms are shown in this manual:

- #1 - Minor strap jam.
- #2 - Moderate strap jam.
- #3 - Severe strap jam.
- #4 - Strap escapes chute during operation.
- #5 - No weld or poor weld.
- #6 - Strapping head pre-seals.

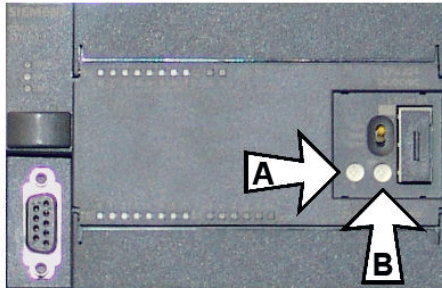
#1 SYMPTOM: Minor strap jam, noted by strap ends/loops sticking out from table top.	
CAUSE	REMEDY
Strap jammed in anvil head or chute track.	Lift front table top to gain access to chute track. Remove all jammed strap. Close table top and turn power back ON.

#2 SYMPTOM: Moderate strap jam, noted by no strap feed or take-up.	
CAUSE	REMEDY
Strap jammed in head guides.	Turn machine power OFF. Pull out all strapping from side of machine and discard. Reload strap per loading instructions.

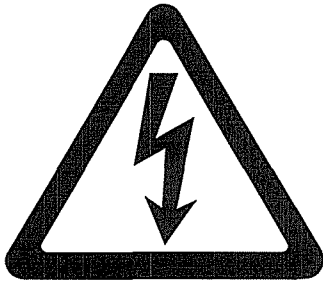
#3 SYMPTOM: Severe strap jam, strap cannot be pulled out from machine.	
CAUSE	REMEDY
Strap jammed in head guides and/or around feed and take-up wheels.	Lift front table top to gain access to strap guide. Open front door of machine if necessary. Open strap guide by lifting the release latch. Cut off jammed strapping. Align remaining strap back into strap path and close strap guide. Close table top and step on Cycle Bar.

#4 SYMPTOM: Strap escapes chute during operation.	
CAUSE	REMEDY
1. Chute spring clip not in place.	1. Replace clip back into chute track.
2. Stripper finger not operating properly.	2. Inspect the stripper finger for correct action, adjust as required.

TROUBLESHOOTING, Continued

#5 SYMPTOM: No weld or poor weld.	
CAUSE	REMEDY
<ol style="list-style-type: none"> 1. Hot knife cold. 2. Loose connection, broken wire or blown fuse. 3. The hot-knife is dirty. 4. Incorrect operating temperature. 5. Hot knife not being properly inserted between straps. 6. Welds are not completely solidified or strap joints occasionally fail from not being properly solidified. 	<ol style="list-style-type: none"> 1. Allow machine to properly warm up. 2. Tighten all connections and screws. Replace wires and fuse as required. 3. Turn machine power OFF, clean the hot-knife surface with fine grit emery paper. 4. Adjust hot-knife temperature setting up or down to produce a better weld. 5. Inspect the hot knife area for debris or a possible obstruction - clean as required. Check for a broken hot knife spring or bent hot knife. 6A. Adjust hot-knife temperature setting (B) up or down to produce a better weld. 6B. Adjust the Weld Cool Timer on the PLC of the main electrical enclosure. Turn adjustment screw (A) clockwise (CW) to increase weld cool time. <div style="text-align: center; margin: 10px 0;">  </div> <p>NOTES:</p> <ol style="list-style-type: none"> 1. Run/Stop switch must be in the RUN position.

#6 SYMPTOM: Strapping head pre-seals.	
CAUSE	REMEDY
1. Stripper pin not operating properly.	1. Inspect the stripper pin and spring action. Replace as required.
2. Chute opener mechanism not operating properly.	2. Inspect the chute opener for proper operation and/or binding. Adjust or clean as required to correct operation.
3. Chute brushes too stiff for strap to be pulled out.	3. Loosen brush mounting screws and slide brushes away from arch to increase gap. Tighten screws.



**PLEASE NOTE - ANY ELECTRICAL ENCLOSURE
OR MACHINE COVER WHICH IS MARKED
WITH THE SYMBOL SHOWN ABOVE SHOULD
BE SERVICED WITH EXTREME CAUTION.**

PLC & PROXIMITY SWITCH IDENTIFICATION (5-1)

PARTS LISTS & VIEWS:

MAIN COMPONENTS (5-2)

OPERATOR ENCLOSURE (5-3)

ELECTRICAL CABINET, INTERNAL (5-5)

RELAY & FUSE MODULE (5-6)

ELECTRICAL SCHEMATIC (5-7)

**5-7
NOTICE
5**

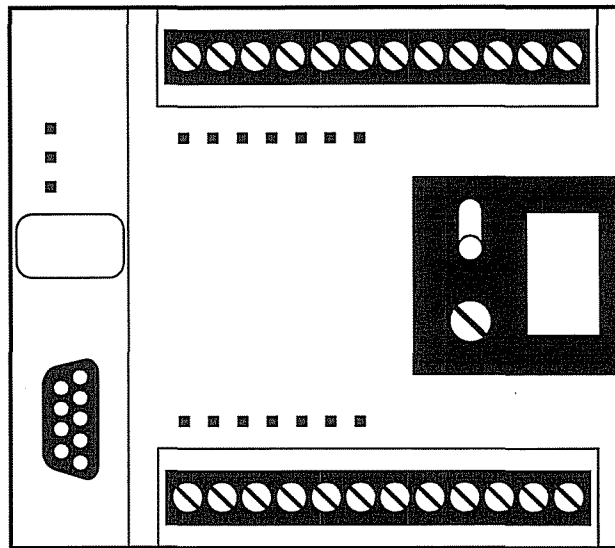
PLC & PROXIMITY SWITCH IDENTIFICATION

As the LBX-2000 operates per its program, the PLC's indicator lights will lite up as the input and output connections are signaled.

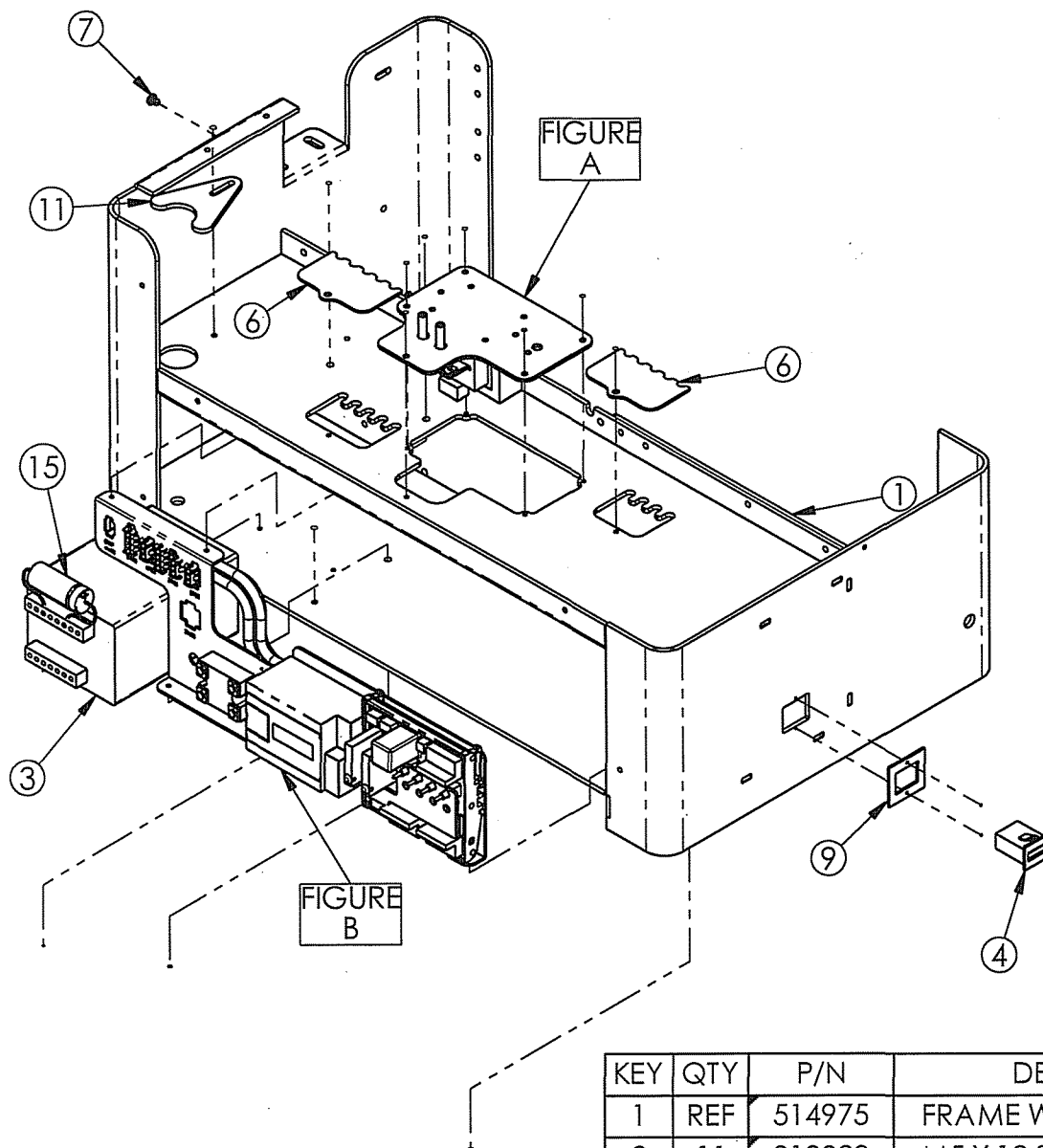
When inputs are received by the PLC, input lights I0.0, I0.1, I0.2, I0.3, I0.4, I0.5, I0.6, I0.7 will lite. When signals are sent by the PLC, output Q0.0, Q0.1, Q0.2, Q0.3, Q0.4, Q0.5, Q0.6, Q0.7, Q1.0 lights will lite.

The LBX-2000 can be monitored (or diagnosed) as each of the inputs or outputs triggers a lite on the PLC. Refer to the electrical schematic for additional information on PLC inputs and outputs.

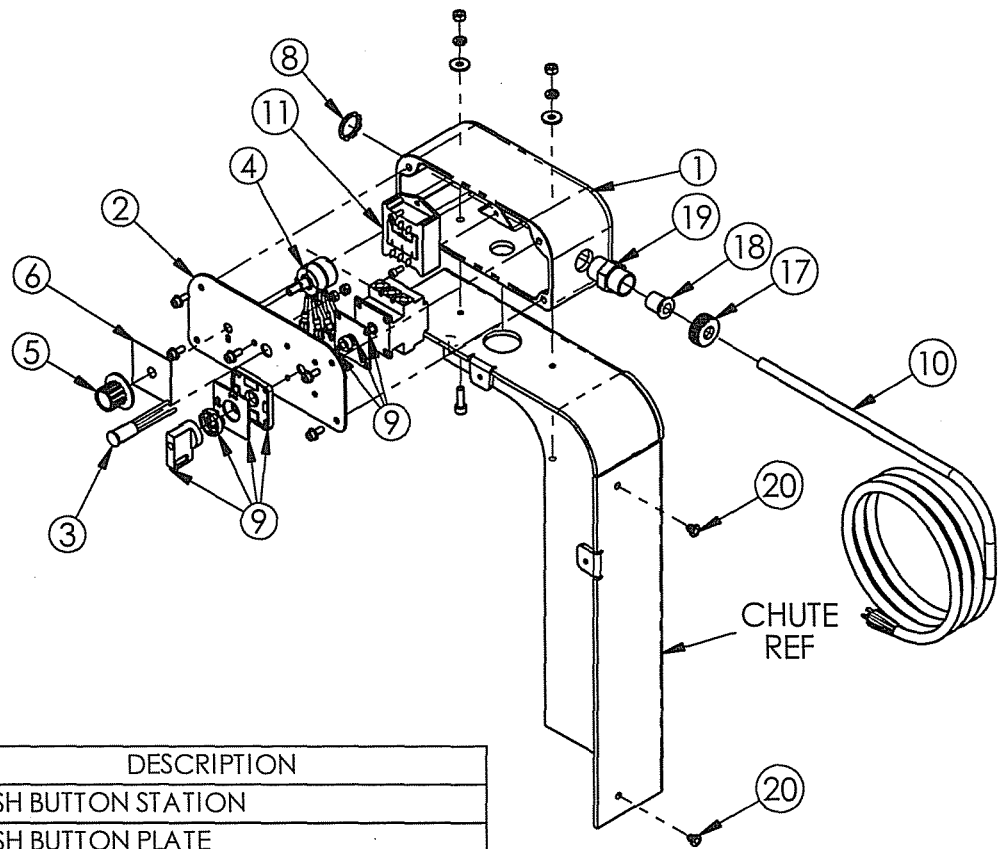
Other beneficial lights on the PLC are the run, stop and system fault (SF). Review the information below on identifying the PLC's indicator lights.



● SF	PLC System Fault	● I0.0	High Tension & ULT	● Q0.0	Not Used
● RUN	Run	● I0.1	Stall Prox (3PRS)	● Q0.1	Dispenser Motor (4MTR)
● STOP	Stop	● I0.2	Home Prox (2PRS)	● Q0.2	Feed Motor (2MTR)
		● I0.3	Cycle Prox (5PRS)	● Q0.3	Take-Up Motor (2MTR)
		● I0.4	Position Prox (6PRS)	● Q0.4	Tension Motor Rev (3MTR)
		● I0.5	Feed Limit (1PRS)	● Q0.5	Tension Motor (3MTR)
		● I0.6	Not Used	● Q0.6	Index Motor (1MTR)
		● I0.7	Interlock Closed	● Q0.7	Not Used
		● I1.0	Disp Prox (4PRS)	● Q1.0	Hot Knife
		● I1.1	Out of Strap (7PRS)	● Q1.1	Dispenser Brake
		● I1.2	Strap PES / Footswitch		

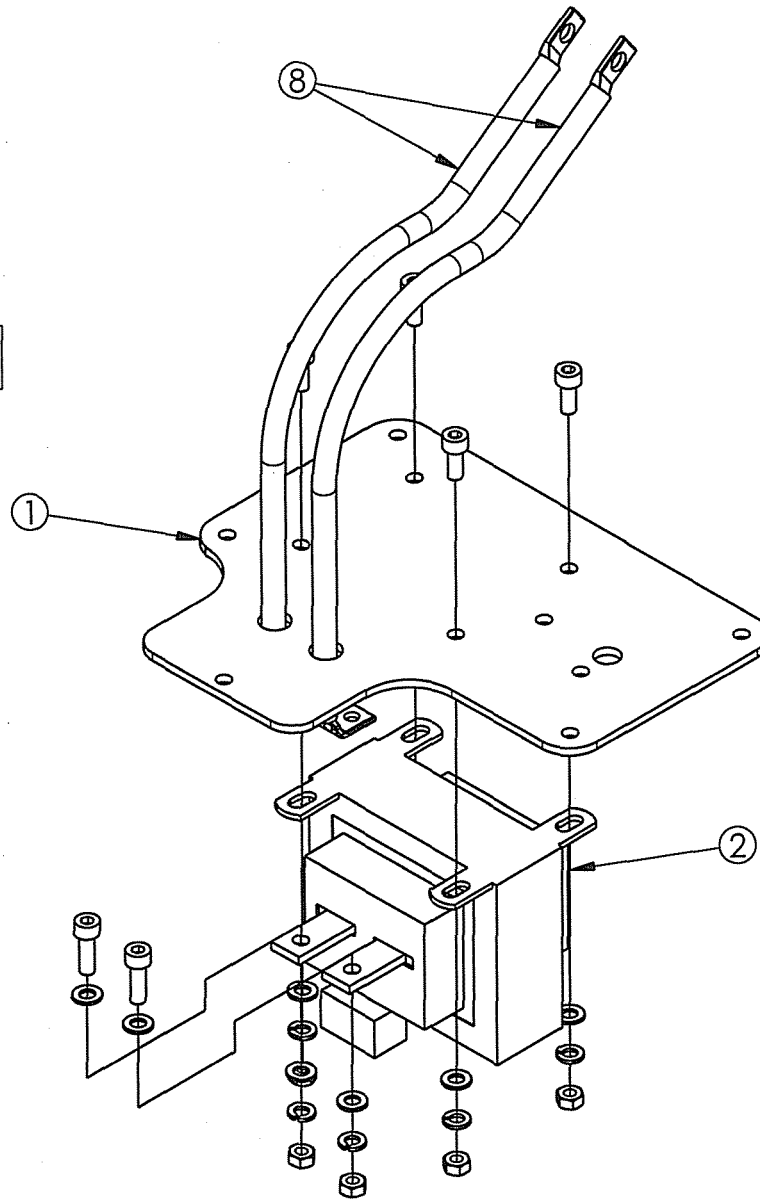


KEY	QTY	P/N	DESCRIPTION
1	REF	514975	FRAME WELDMENT
2	11	010028	M5 X 12 SHCS (ZINC)
3	1	514313	POWER SUPPLY
4	1	439433	COUNTER
5	6	262551	M3 X 8 SHCS (ZINC)
6	2	514331	5 WIRE GROMMET HOLDER
7	1	434498	CABLE PUSH MOUNT
8	11	010076	M5 LOCKWASHER (ZINC)
9	1	439434	COUNTER BRACKET
10	2	162568	M3 LOCKWASHER (ZINC)
11	1	514982	CORD GRIP PLATE
12	2	481889	M6 LOCKWASHER
13	2	421876	M6 FENDERWASHER
14	2	165438	M6 X 16 SHCS
15	1	514375	CAPACITOR ASSEMBLY



KEY	QTY	P/N	DESCRIPTION
1	1	514320	PUSH BUTTON STATION
2	1	514321	PUSH BUTTON PLATE
3	1	514322	POWER (SAFETY) LIGHT
4	1	515139	DUAL 10K OHM POTENTIOMETER ASY.
5	1	420418	ADJUSTMENT KNOB
6	1	434446	TENSION CONTROL DECAL
7	5	272418	M5 X 12 SHCS FLANGED (ZINC)
8	1	014797	LOCKNUT
9	1	514965	MAIN POWER SWITCH
10	A/R	434434	POWER CORD (US)
		434478	POWER CORD (UK)
		434479	POWER CORD (EURO)
		434228	POWER CORD (AUS)
11	1	514342	VOLTA GE FREQUENCY CONVERTER
12	2	252551	M3 X 8 SHCS (ZINC)
13	2	433920	M6 X 20 SHCS (ZINC)
14	2	421876	M6 FENDERWASHER (ZINC)
15	2	481889	M6 LOCK WASHER (ZINC)
16	2	005465	M6 HEXNUT (ZINC)
17	1	070859	1/2" GLAND NUT/ SLIP RING
18	1	434451	GROMMET (DOM)
19	1	071940	CONNECTOR (POWER CORD)
20	2	434498	CABLE PUSH MOUNT
21	1	434664	M5 KEPS NUT (ZINC)

FIGURE A



KEY	QTY	P/N	DESCRIPTION
1	1	516193	HOT KNIFE GROMMET PLATE
2	1	514861	HOT KNIFE TRANSFORMER
3	4	010028	M5 X 12 SHCS (ZINC)
4	8	171571	M5 FLATWASHER
5	6	169440	M5 HEX NUT (ZINC)
6	6	010076	M5 LOCKWASHER (ZINC)
7	2	011214	M5 X 16 SHCS (ZINC)
8	2	516771	HOT KNIFE CABLE

KEY	QTY	P/N	DESCRIPTION
1	1	514942	ELECTRICAL PANEL
2	1	516935	CIRCUIT BOARD
3	1	515640	PLC (LBX-2000)
4	1	514337	SOLID STATE RELAY SEDD/1V12
5	5	170118	M5 X 10 SBHCS
6	2	433946	M4 X 10 SBHCS
7	1	514328	HORIZONTAL DIN RAIL
8	1	519362	LBX-2000 MAIN HARNESS

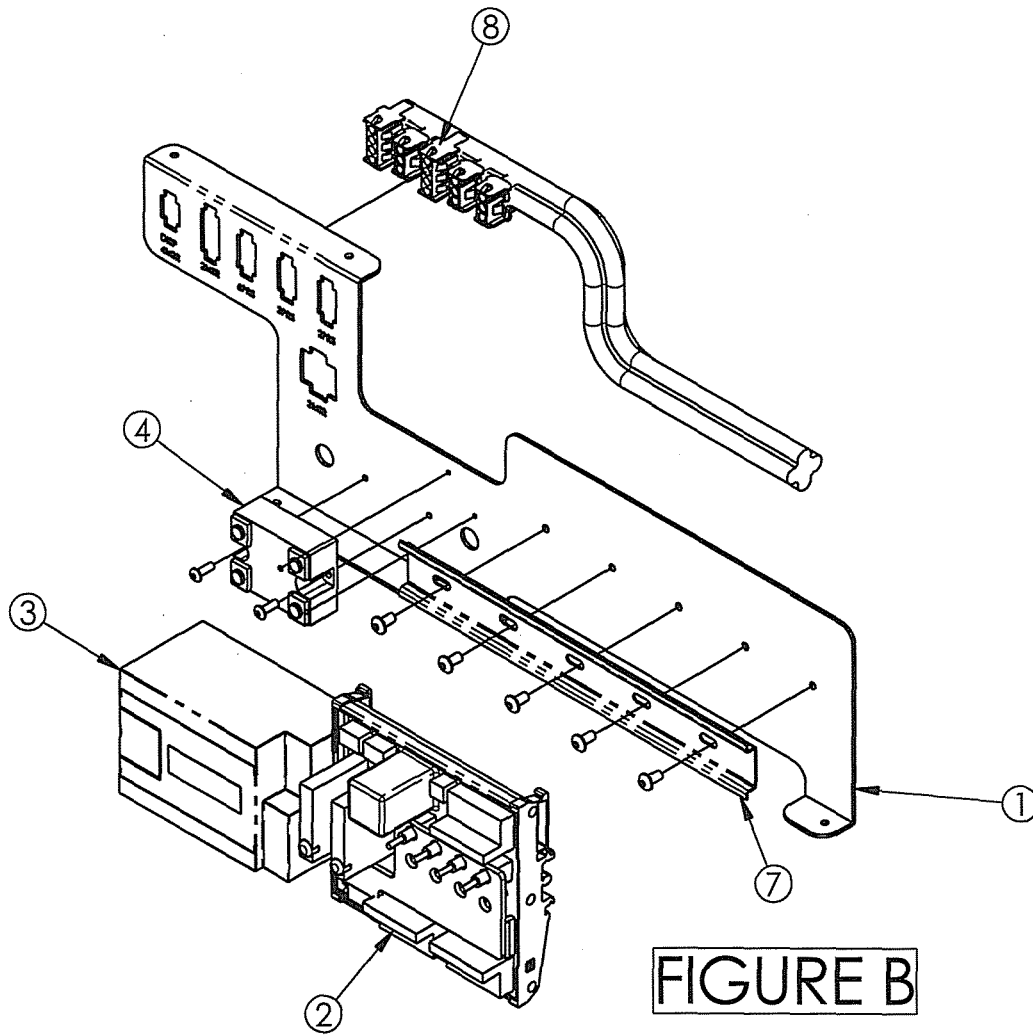
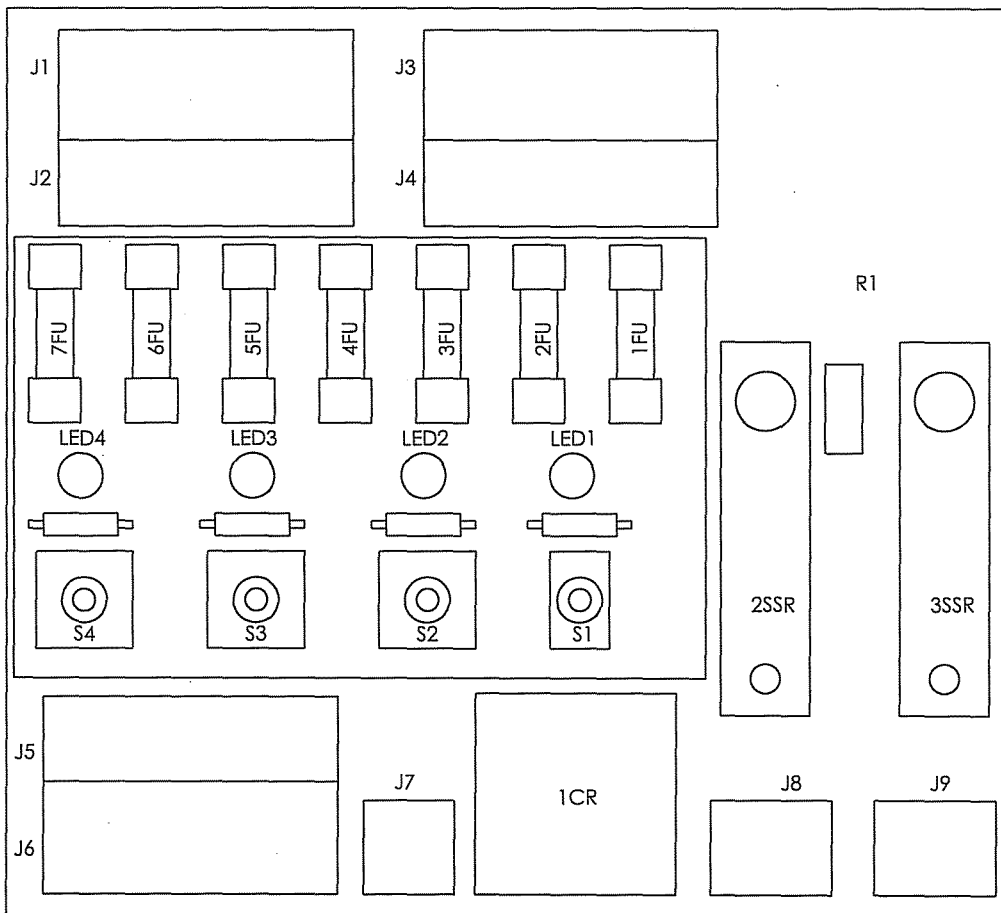


FIGURE B

RELAY AND FUSE MODULE

516935-4

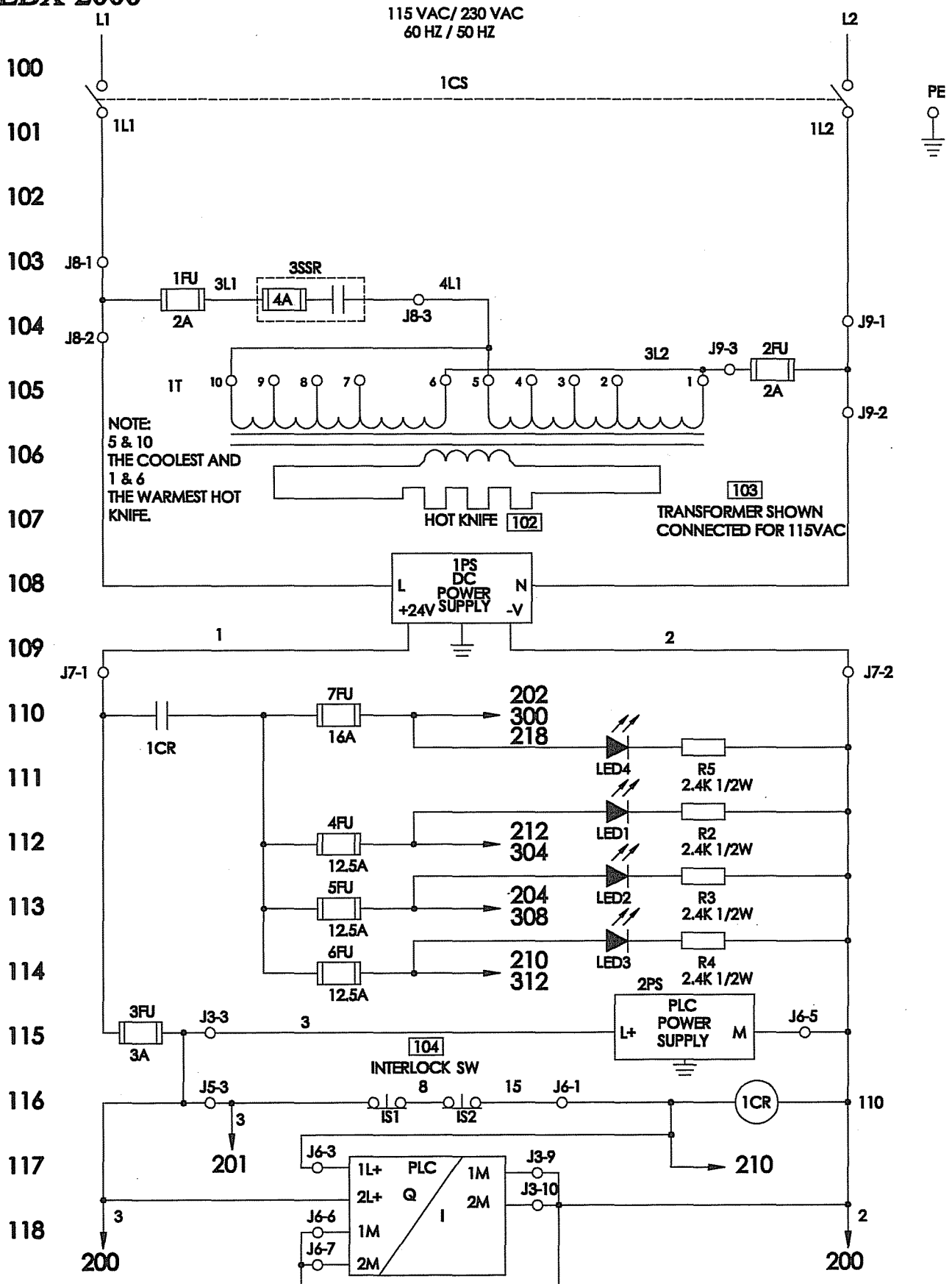
PART NO.	QTY	DESCRIPTION
514391	1	OUTPUT MODULE DC (2SSR)
514392	1	OUTPUT MODULE AC (3SSR)
514393	REF	FUSE (OUTPUT MODULE)
514394	3	FUSE 12.5A SLO BLO (4FU, 5FU & 6FU)
519338	1	FUSE 16A SLO BLO (7FU)
514364	REF	TERMINAL BLOCK (J1, 2, 3, 4, 5 & 6)
514365	REF	TERMINAL BLOCK (J7)
514366	REF	TERMINAL BLOCK (J8 & 9)
514398	1	RELAY (1CR)
434425	1	FUSE (3FU)
516770	2	FUSE (1FU, 2FU)
515554	1	LABEL
515110	1	PLASTIC COVER



ELECTRICAL SCHEMATIC 100

519361-2

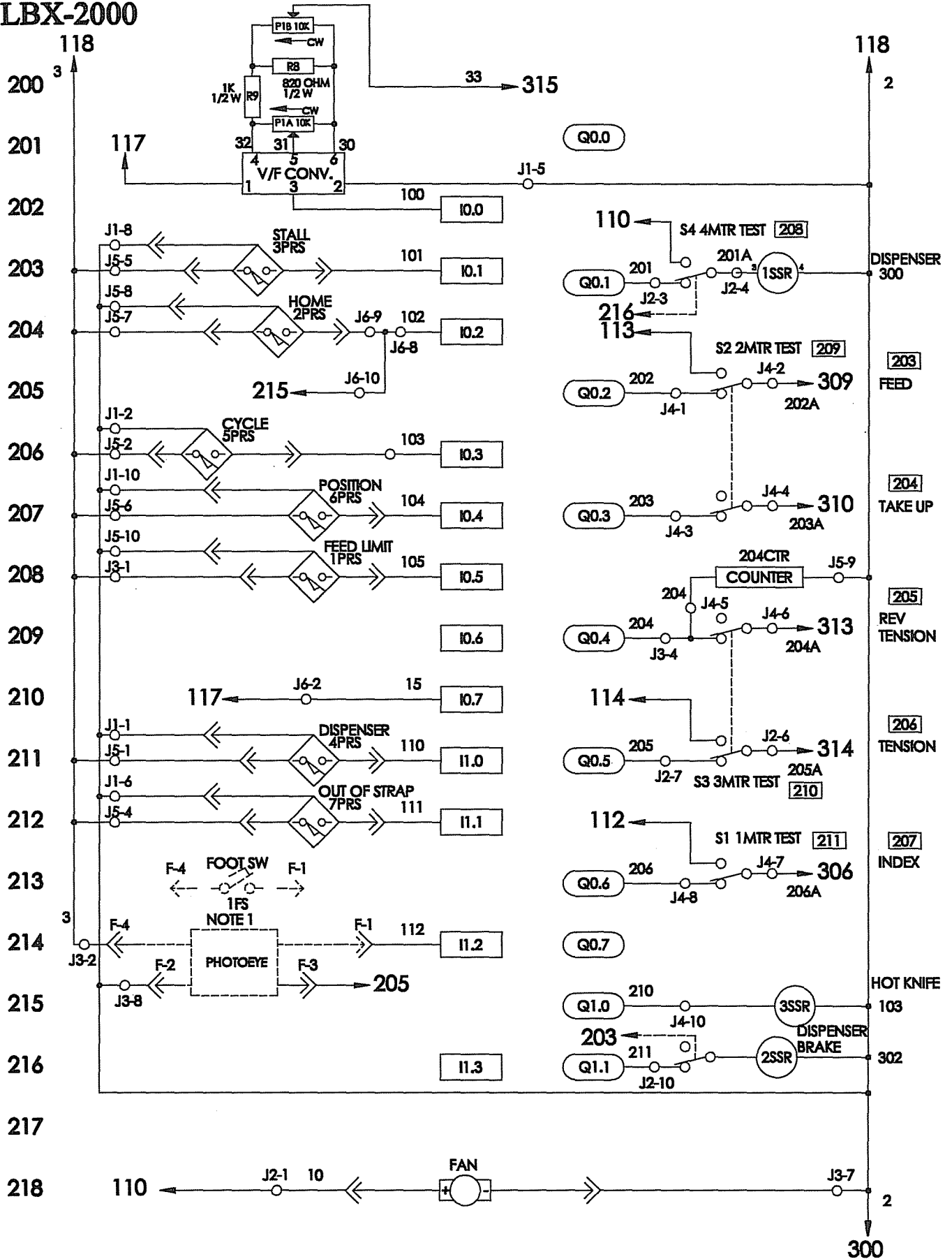
LBX-2000



ELECTRICAL SCHEMATIC 100

519361-2

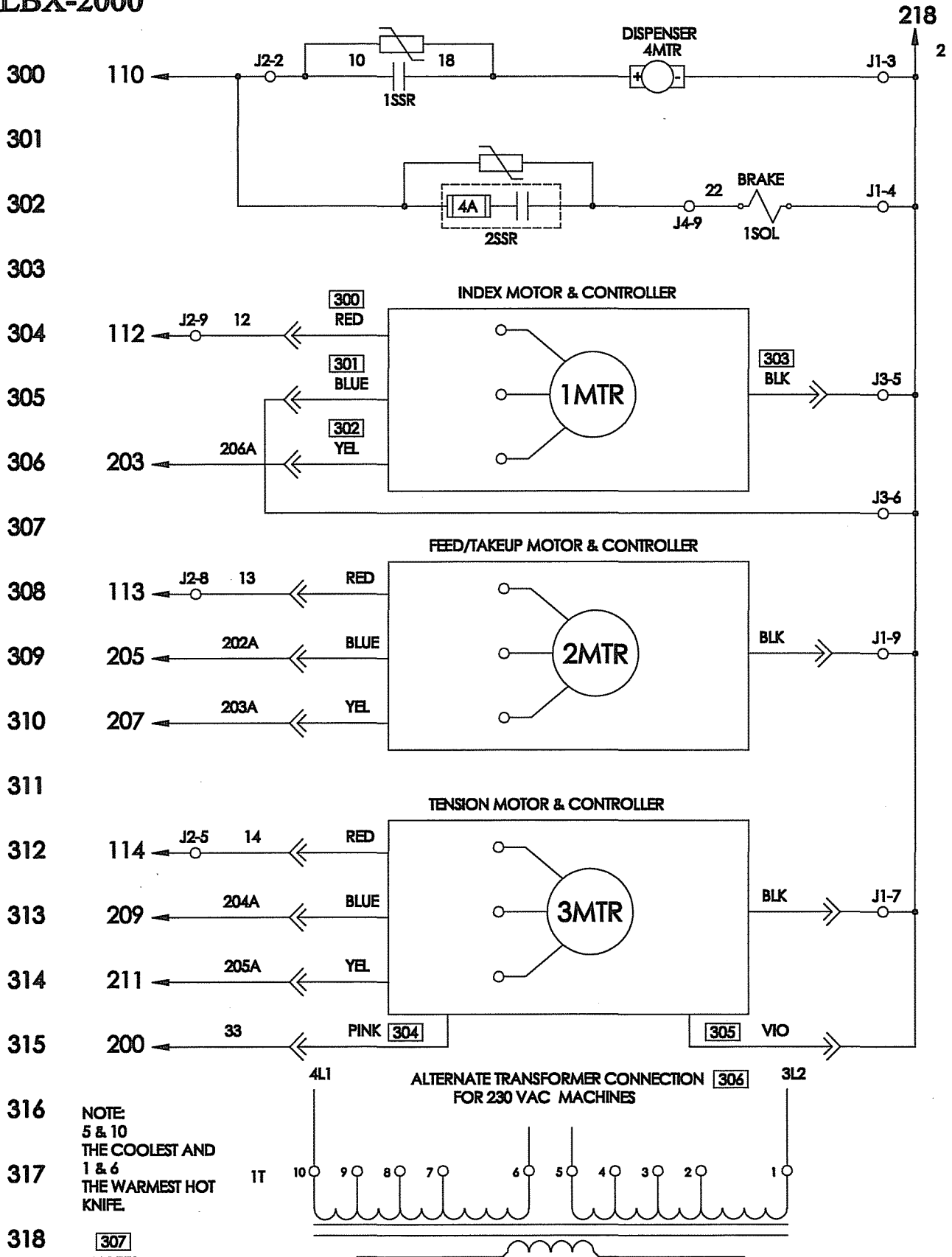
LBX-2000



ELECTRICAL SCHEMATIC 100

LBX-2000

519361-2



NOTE:
5 & 10
THE COOLEST AND
1 & 6
THE WARMEST HOT
KNIFE.

307

NOTES:

1 - Components shown with dashed lines are optional.

The foot switch or the photoeye option can not be used simultaneously.

100-118		
	Français	Deutsch
100	Schéma électrique des connexions	SCHALTPLAN
102	Lame Chaffante	HEIZKEL
103	115 VAC MONTRÉ	abgebildeter Transformator mit Anschluss für 115 VWS
104	Interrupteur de verrouillage	Zum Anhalten drücken
1PS	Alimentation	STROMVERSORGUNG
1T	REMARQUES:5 & 10 est le plus frais & 1& 6 est le chaud le plus chaud Lame Chaffante	ANMERKUNG:5 & 10 IST DAS KÜHLSTE UNDSCHWARZES & 1& 6 IST DAS WÄRMSTE HEISSE HEIZKEL.
2PS	Alimentation PLC Autom ate	STROMVERSORGUNG PLC
200-218		
	Français	Deutsch
203	MOTEUR DEBIT LIEN	Enschuß
204	MOTEUR DE RAVALEMENT	Rückzugs
205	INVERSION MOTEUR TENSION LIEN	Rückwärts Bandspann Antrieb
206	MOTEUR TENSION LIEN	Bandspann Antrieb
207	MOTEUR DE TETE DE CERCLAGE	Aggregat
208	S4 4MTR ESSAI	S4 4MTR TEST
209	S2 2MTR ESSAI	S2 2MTR TEST
210	S3 3MTR ESSAI	S3 3MTR TEST
211	S1 1MTR ESSAI	S1 1MTR TEST
3PRS	FIN DE RAVALEMENT	Stillstand
2PRS	TETE EN P.O.	Grundstellung
5PRS	DEPARTE CYCLE	Fußschalter
6PRS	DETECTEUR DE PROXIMITE	Position
1PRS	FIN DE DEBIT	Einlauf Ende
4PRS	ACCUMULATEUR LIEN	Zufuhr
7PRS	HORS DE LA LIEN	Aus Spule heraus
1SSR	MOTEUR DEVIDOIR	Bandspeicher
204CTR	COMPTEUR	Zähler
PHOTOEYE	PHOTO-OEIL	Foto-Auge
1FS	PIED COMMUTATEUR	Fuß Schalter
3SSR	LAME CHAFFANTE	Heiß Heizkel
2SSR	FREIN DE DEVIDIOR	Bandspeicher Brem se
FAN	VENTILATEUR	Gebälse
300-318		
	Français	Deutsch
300	ROUGE	Rot
301	BLEU	Blau
302	JAUNE	Gelb
303	NOIR	Schwarz
304	PNK	Pink
305	VIO	Violett
306	RACCORDEMENTS ALTERNATIFS DE TRANSFORMATEUR DE COMMANDE	Alternative steuerung transform ator anschlüsse
307	REMARQUES: 1 - Composants montré avec à tiret lignes soyez facultatif. Le pied commutateur ou photo-oeil option ne peut pas être utilisé simultanément.	ANMERKUNGEN: 1 - Bestandteile dargestellt mit gestrichelt linien seien wahlweise wahl. Der Fuß schalter oder foto-auge wahl können nicht verwendet gleichzeitig.
4MTR	DISTRIBUTEUR	Bandspeicher
1SOL	FREIN	Bremse
1MTR	MOTEUR DE TETE DE CERCLAGE & COMMANDE	Aggregatm otor & Steuerung
2MTR	MOTEUR DEBIT LIEN & COMMANDE	Einschußm otor-Rückzugsm otor & Steuerung
3MTR	MOTEUR TENSION LIEN & COMMANDE	Bandspann-Antrieb & Steuerung

PARTS LISTS & VIEWS:

FRAME ASSEMBLIES:

- CASTERS (6-1)**
- FOOT PEDAL (6-2)**
- STRAP DISPENSER (6-3)**
- INFEED GUIDE (6-6)**
- TABLE TOPS & COVERS (6-8)**
- ACCUMULATOR BOX (6-9)**
- BALANCE ARM & DOOR (6-10)**
- INFEED (6-11)**
- SIGN DISPOSITION (6-12)**

CHUTE ARCH ASSEMBLIES:

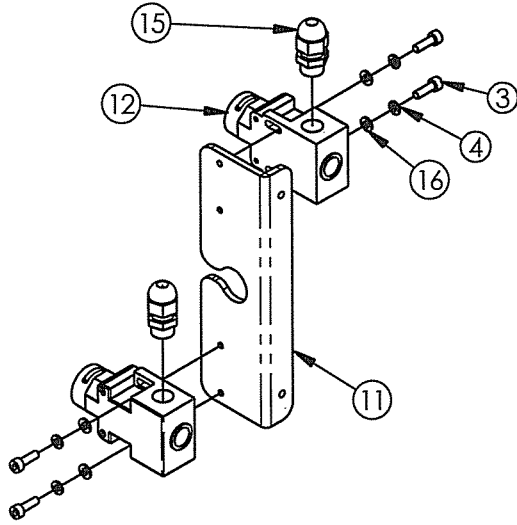
- BILL OF MATERIALS (6-13)**
- MAIN ARCH (6-14)**
- TRACK (6-15)**
- COVER & MOUNTING (6-16)**
- LINKAGE (6-17)**
- INTERLOCK & LINKAGE (6-18)**

- STRAP GUIDE KIT (6-19)**

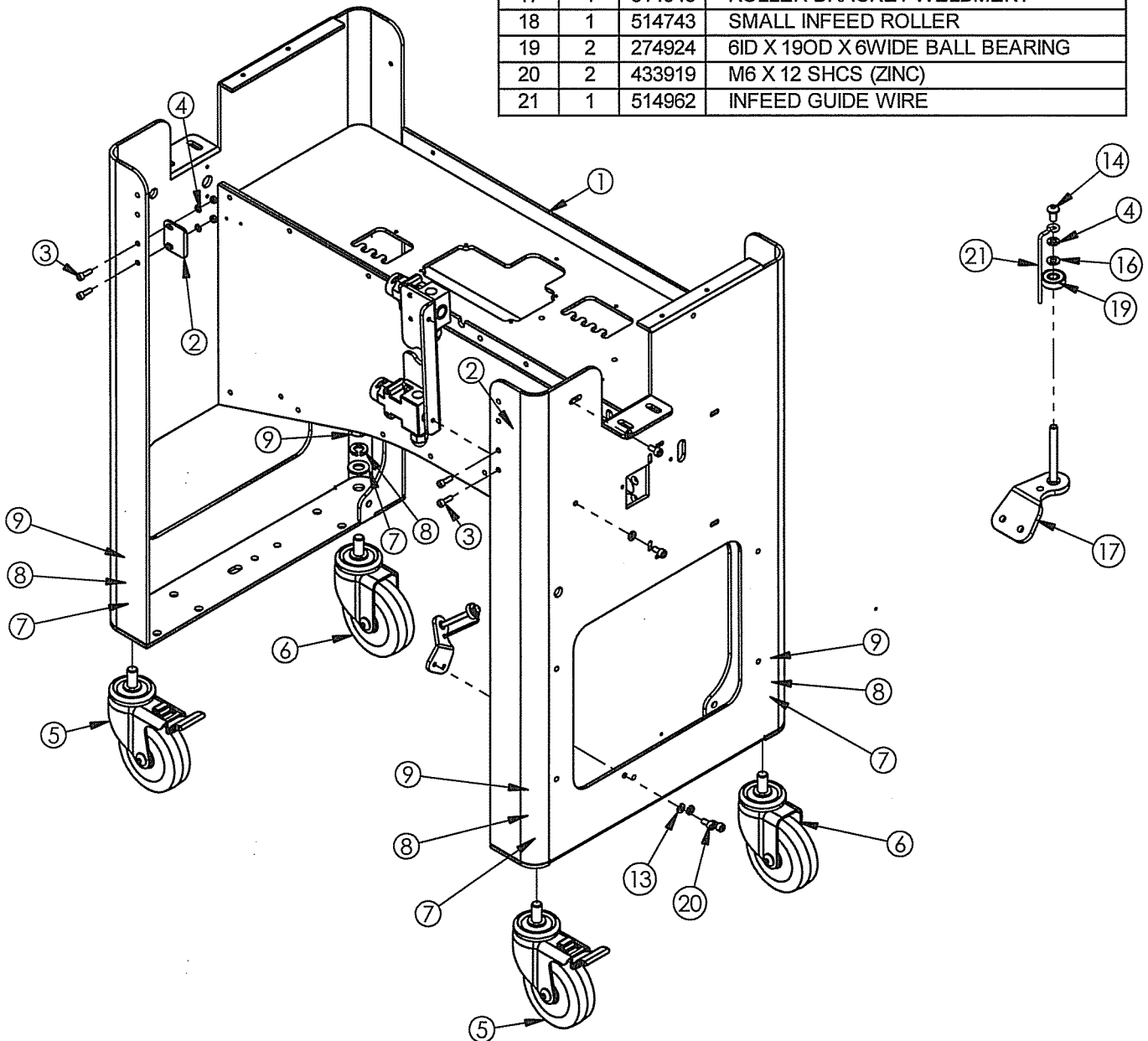
9-NOTICES

FRAME - CASTER AND FOOT PEDAL ASSEMBLY

514050-7



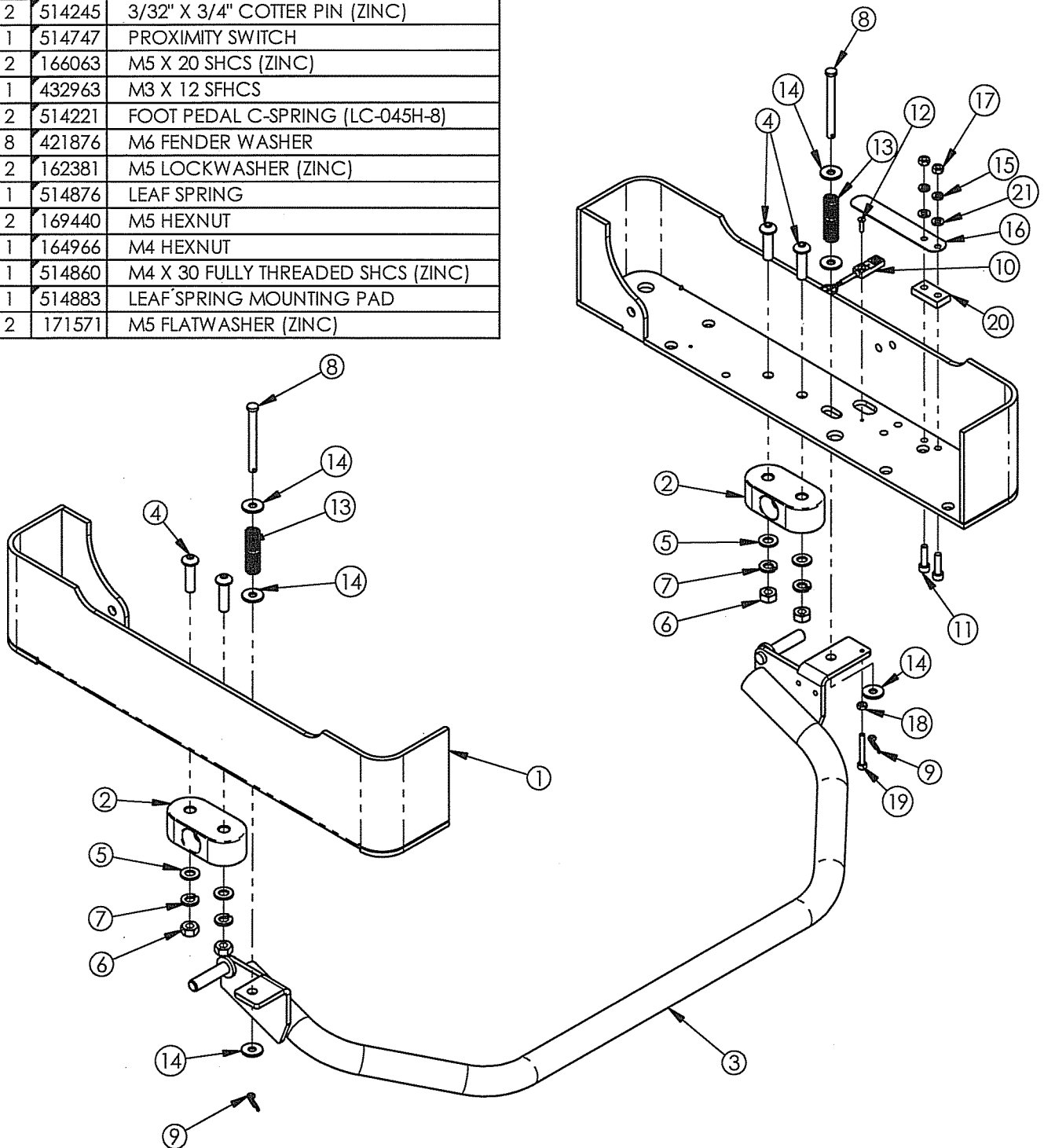
KEY	QTY	P/N	DESCRIPTION
1	1	514975	LBX-2000 FRAME WELDMENT
2	2	514983	FRONT PANEL LOCK BRACKET
3	8	011214	M5 X 16 SHCS (ZINC)
4	8	010076	M5 LOCKWASHER (ZINC)
5	2	514231	4" SWIVEL-TOTAL LOCK-STEM-CASTER
6	2	514232	4" SWIVEL-W/O LOCK-STEM CASTER
7	4	071806	1/2 FLATWASHER (ZINC)
8	4	002434	1/2 LOCKWASHER
9	4	013624	1/2-13 HEX NUT
10	4	169440	M5 HEX NUT (ZINC)
11	1	514985	INTERLOCK BRACKET
12	2	436243	INTERLOCK
13	2	5464	M6 LOCKWASHER
14	1	175914	M5 X 12 SFHCS (ZINC)
15	2	438295	CORD GRIP (PG 9)
16	9	171571	M5 FLATWASHER (ZINC)
17	1	514946	ROLLER BRACKET WELDMENT
18	1	514743	SMALL INFEED ROLLER
19	2	274924	6ID X 19OD X 6WIDE BALL BEARING
20	2	433919	M6 X 12 SHCS (ZINC)
21	1	514962	INFEED GUIDE WIRE



FRAME - CASTER AND FOOT PEDAL ASSEMBLY

514050-7

KEY	QTY	P/N	DESCRIPTION
1	REF	514975	LBX-2000 FRAME WELDMENT
2	2	514215	FOOT PEDAL PIVOT BLOCK
3	1	514216	FOOT PEDAL WELDMENT
4	4	438635	M8 X 30 SBHCS
5	4	251266	M8 FLATWASHER (ZINC)
6	4	164953	M8 HEX NUT (ZINC)
7	4	162381	M8 LOCKWASHER (ZINC)
8	2	514787	1/4" X 2.5" LONG SS CLEVIS PIN
9	2	514245	3/32" X 3/4" COTTER PIN (ZINC)
10	1	514747	PROXIMITY SWITCH
11	2	166063	M5 X 20 SHCS (ZINC)
12	1	432963	M3 X 12 SFHCS
13	2	514221	FOOT PEDAL C-SPRING (LC-045H-8)
14	8	421876	M6 FENDER WASHER
15	2	162381	M5 LOCKWASHER (ZINC)
16	1	514876	LEAF SPRING
17	2	169440	M5 HEXNUT
18	1	164966	M4 HEXNUT
19	1	514860	M4 X 30 FULLY THREADED SHCS (ZINC)
20	1	514883	LEAF SPRING MOUNTING PAD
21	2	171571	M5 FLATWASHER (ZINC)



FRAME - DISPENSER AND COVERS

514052-12

KEY	QTY	P/N	DESCRIPTION
1	1	515466	BEARING TUBE
2	1	511222	COMPRESSION SPRING (CENTURY 4185)
3	1	514277	LONG DISPENSER SHAFT
4	1	437467	PIN - DISPENSER KNOB
5	1	293310	M6 X6 SSS CUP (ZINC)
6	2	514283	DISPENSER SHAFT BEARING
7	1	510746	20mm EXT. RET RING (TA# 5100-78)
8	1	514278	DISPENSER BRAKE
9	1	514282	DISPENSER WASHER
10	1	435606	35mm EXT. RET. RING (BN 819)
11	4	175914	M5 X 12 SBHCS (ZINC)
12	1	514284	LONG DISPENSER TIP
13	6	010077	M6 LOCKWASHER HC (ZINC)
14	1	281108	M6 X25 SHCS (ZINC)
16	1	437458	OUTER FLANGE ASSEMBLY
17	1	437470	DISPENSER KNOB
18	1	437469	2" EXT. RET. RING (TA# 5100-200)
19	1	511177	INNER FLANGE ASSEMBLY
20	3	437424	COIL SUPPORT
21	8	433919	M6 X 12 SHCS
22	1	514914	DISPENSER DOOR
23	1	514917	DISPENSER DOOR HANDLE WELDMENT
24	1	514656	EXTENSION SPRING
25	1	162374	M6 X 30 SHCS (ZINC)
26	5	005465	M6 HEX NUT (ZINC)
27	4	162406	M6 X 40 SHCS (ZINC)
28	4	262617	M6 FLATWASHER (ZINC)
29	5	481889	M6 LOCKWASHER (ZINC)
30	1	514279	HEX BUSHING - BRAKE
31	1	515493	SS SHIM WASHER
32	2	515813	RUBBER BUMPER
33	2	433917	M4 X 16 SHCS (ZINC)
34	2	164966	M4 HEXNUT
35	REF	514885	DISPENSER STOP BRACKET
35	REF	516886	DISPENSER STOP BRACKET (109W ONLY)

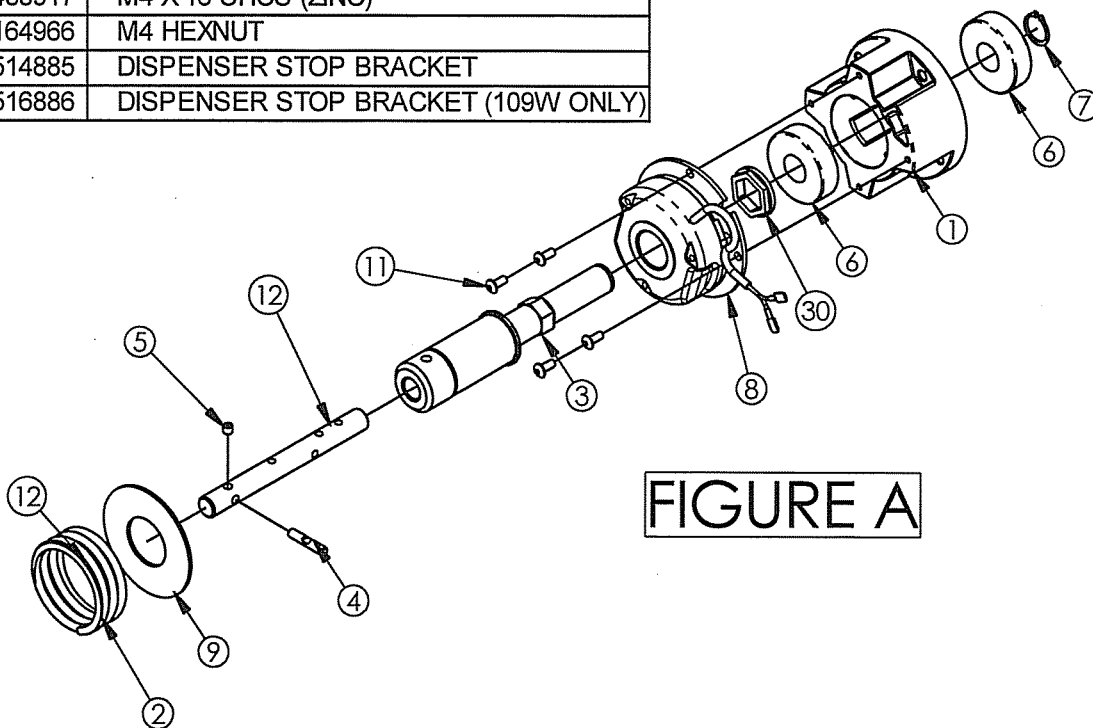


FIGURE B

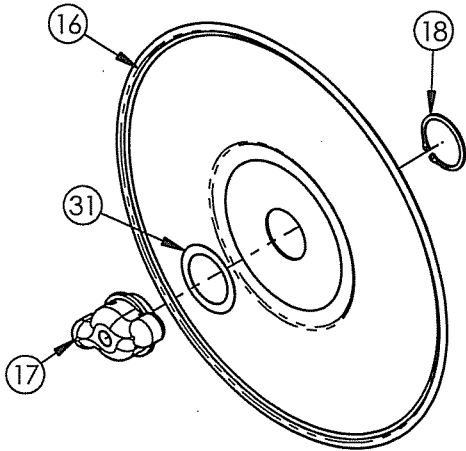


FIGURE C

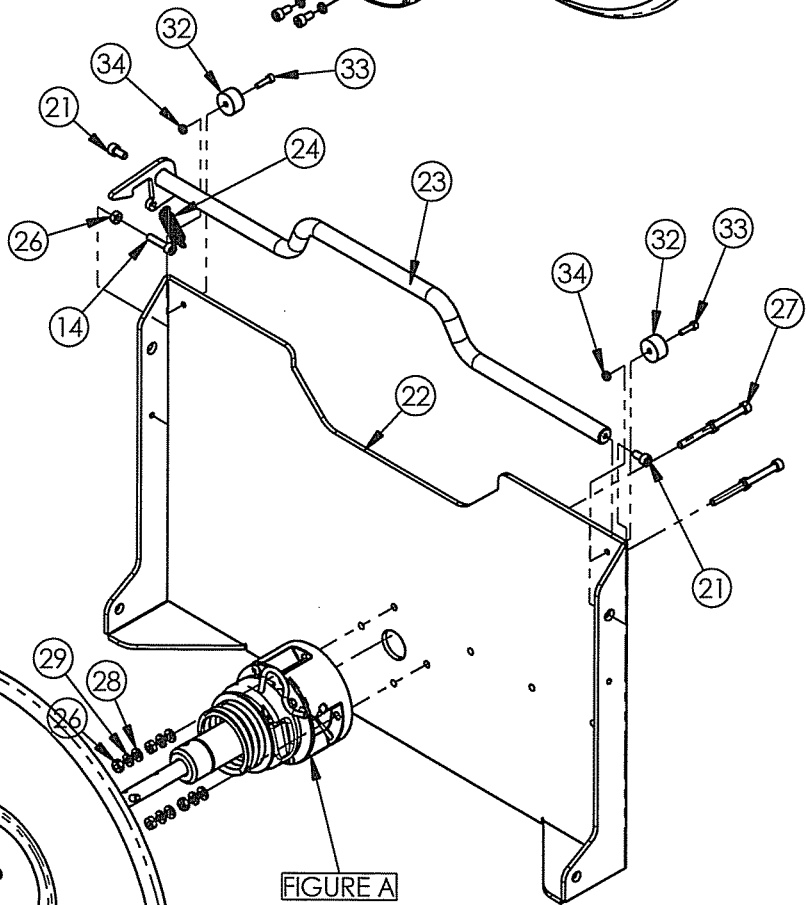
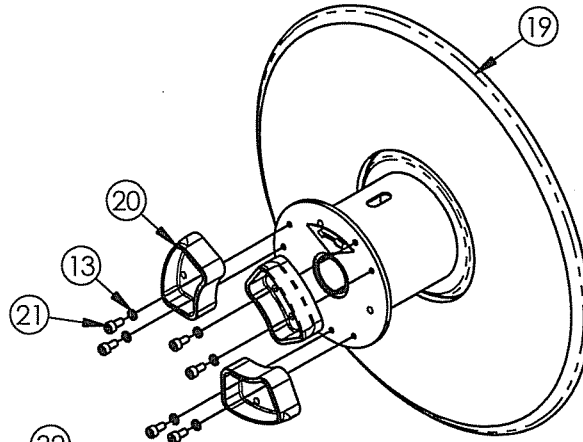


FIGURE B

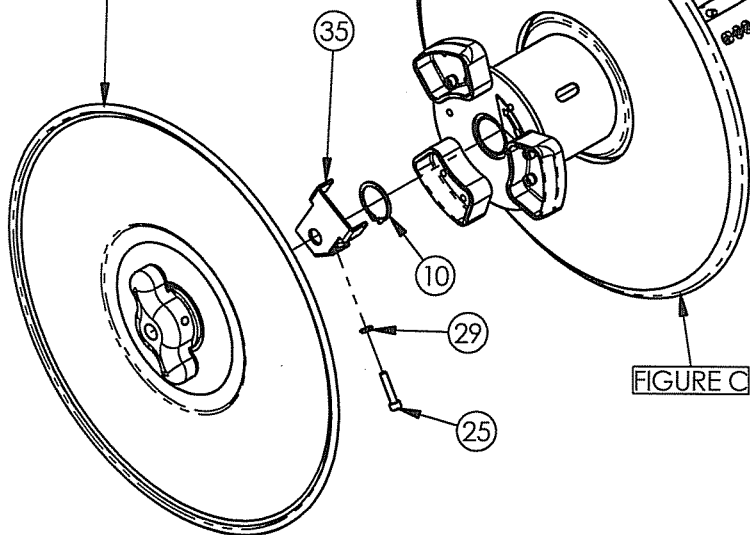
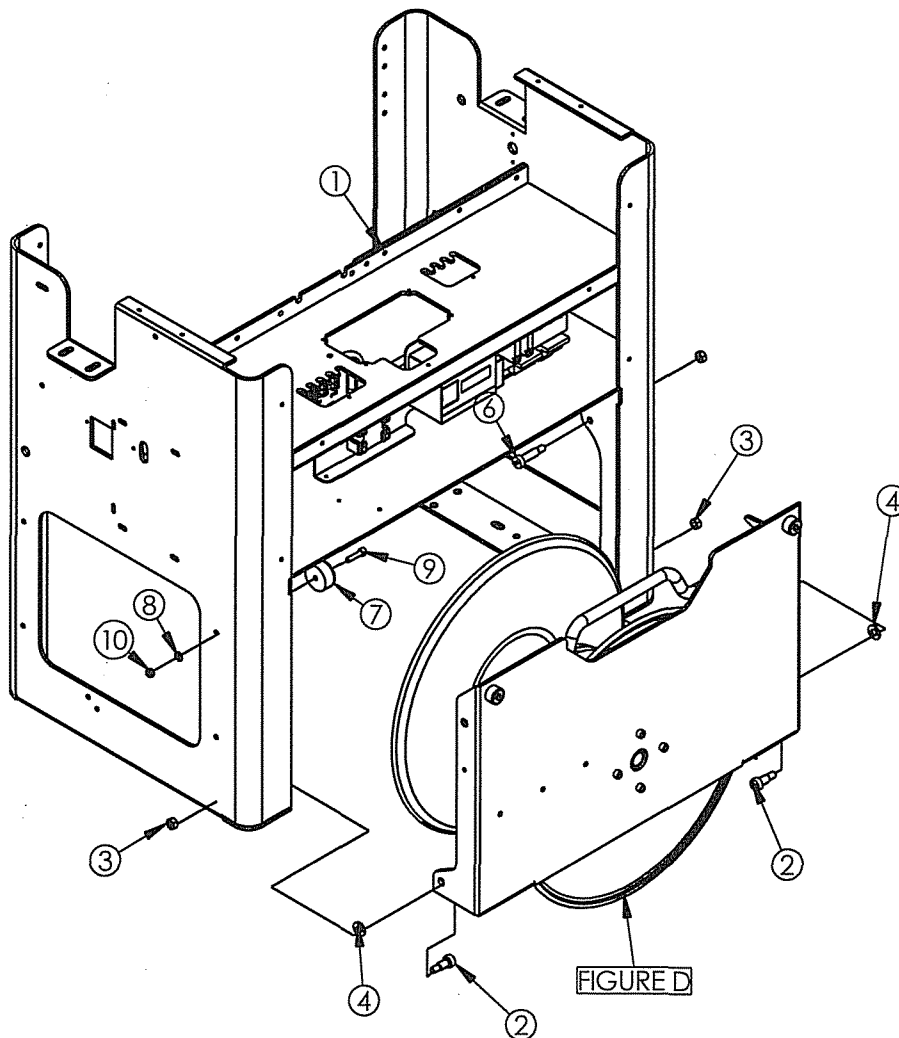
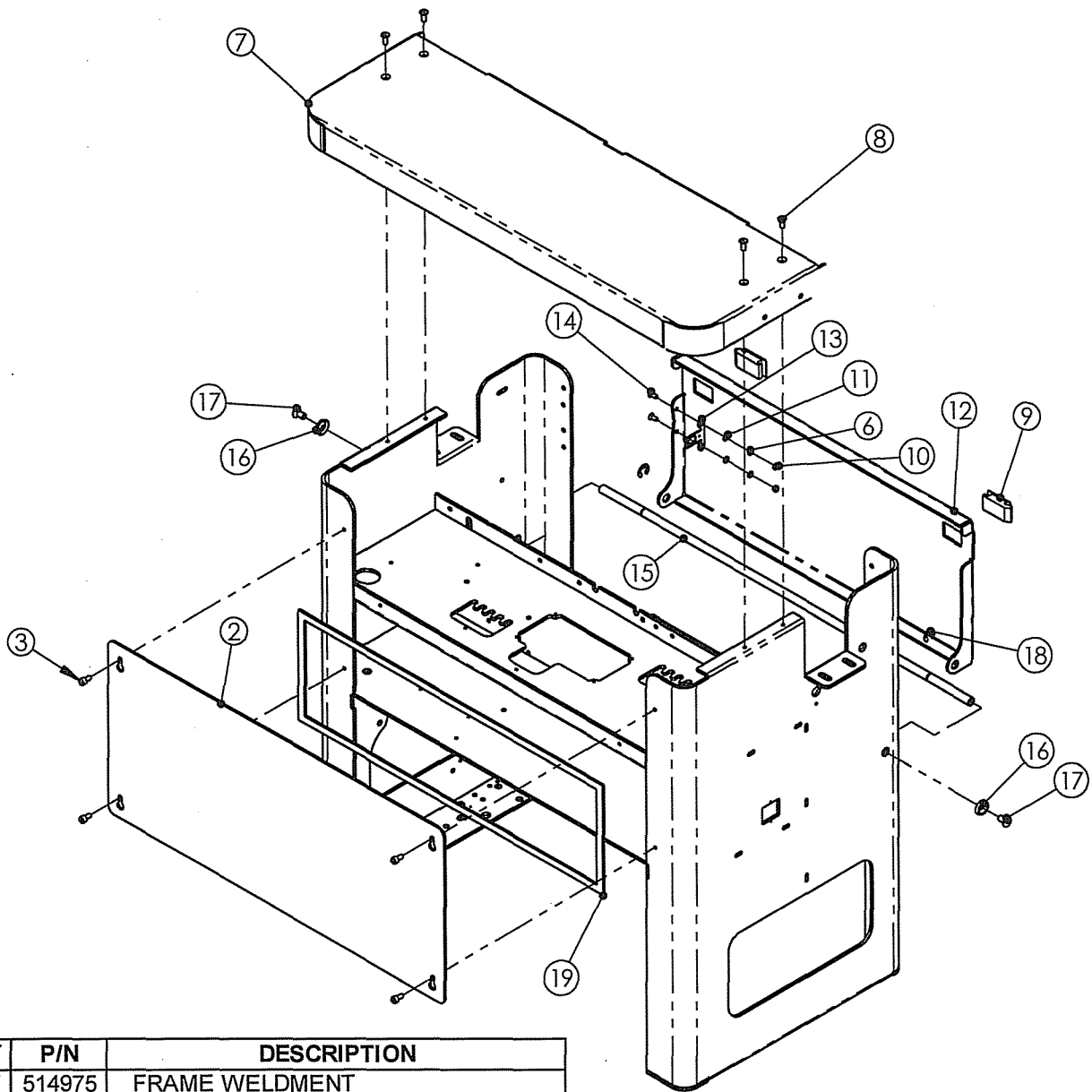


FIGURE A

FIGURE D

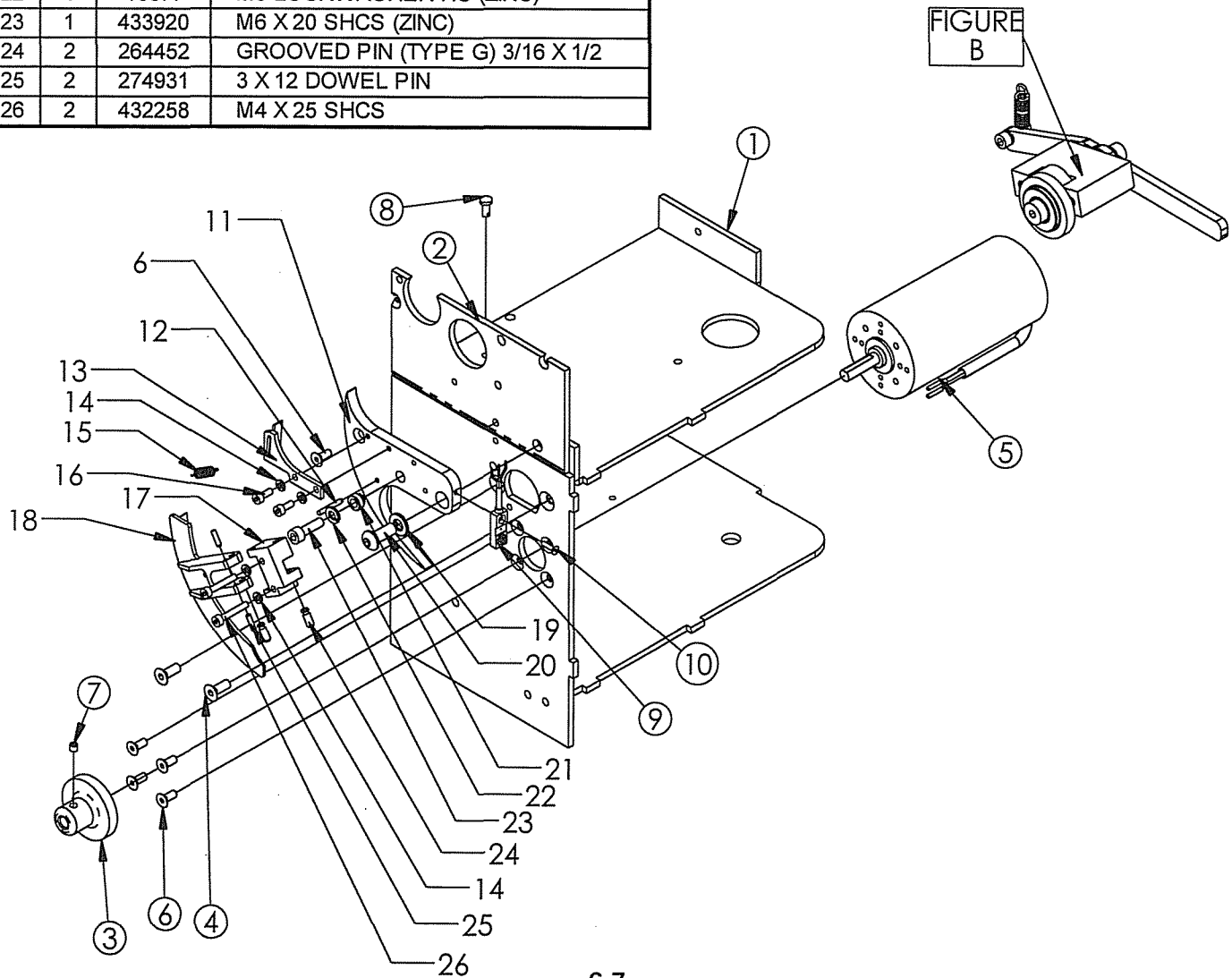
KEY	QTY	P/N	DESCRIPTION
1	REF	514975	LBX-2000 FRAME WELDMENT
2	2	436689	Ø10/M8 X 16 SHSS
3	3	164953	M8 HEX NUT (ZINC)
4	2	251267	M10 FLATWASHER (ZINC)
6	1	475308	Ø10/M8 X 30 SHSS
7	1	514875	1-1/2" RUBBER BUMPER
8	1	481889	M6 LOCKWASHER (ZINC)
9	1	281108	M6 X 25 SHCS (ZINC)
10	1	5465	M6 HEXNUT (ZINC)

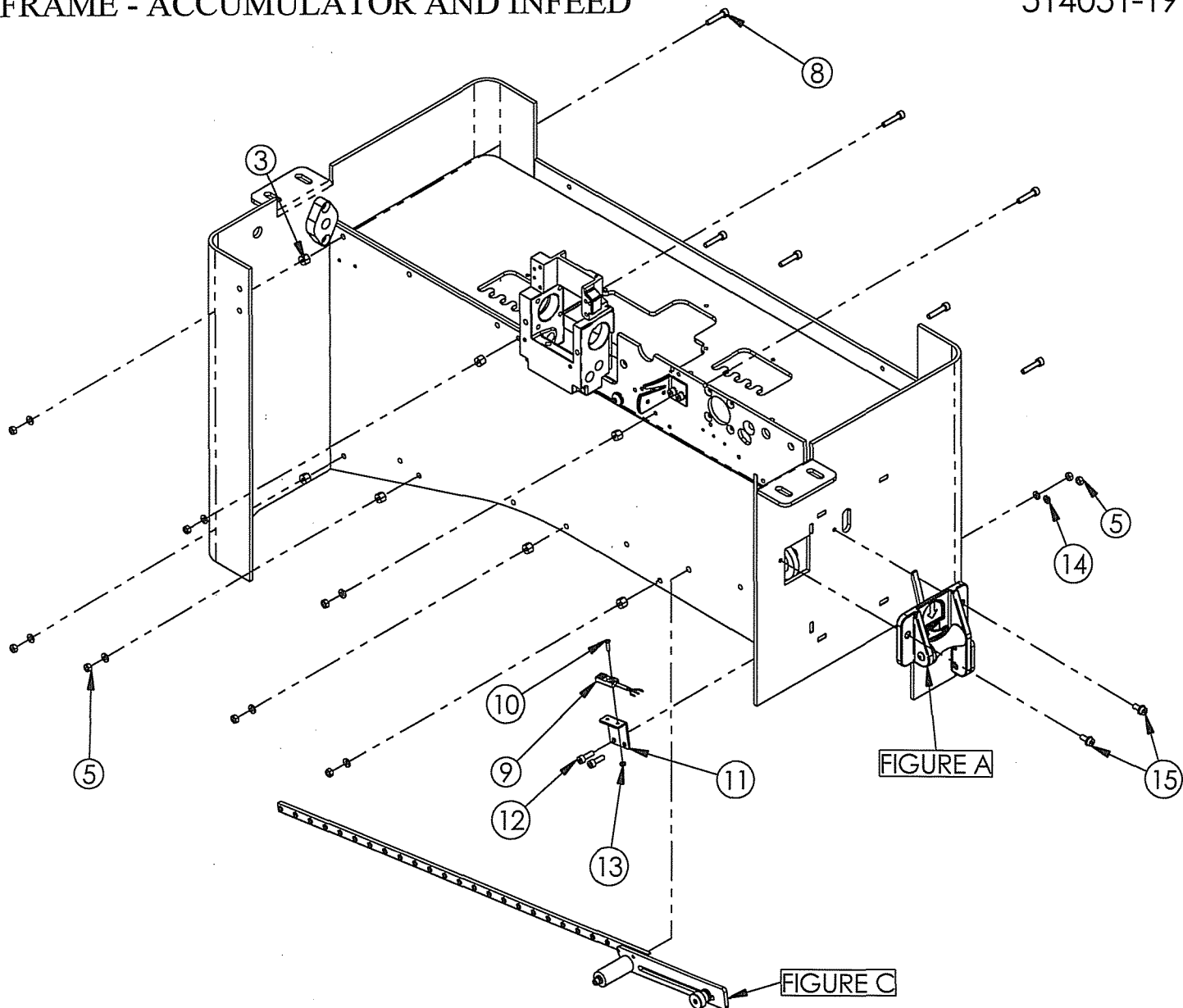




KEY	QTY	P/N	DESCRIPTION
1	REF	514975	FRAME WELDMENT
2	1	514984	REAR ELECTRICAL GUARD
3	4	433919	M6 X 12 SHCS (ZINC)
5	4	11214	M5 X 16 SHCS (ZINC)
6	2	10076	M5 LOCKWASHER (ZINC)
7	1	514317	REAR TABLE TOP
8	4	271010	M6 X 12 SFHCS (ZINC)
9	2	514298	FRONT PANEL LATCH (SOUTHCO #4)
10	2	169440	M5 HEXNUT
11	2	171571	M5 FLATWASHER
12	1	514296	FRONT PANEL
13	1	438752	INTERLOCK SWITCH ACTUATOR
14	2	437290	M5 X 12 SFHCS
15	1	514986	SPREADER SHAFT
16	2	514472	5/16" FINISHING WASHER
17	2	438057	M8 X 16 SFHCS
18	2	16538	1/2" E-RING
19	A/R	435344	FOAM STRIP

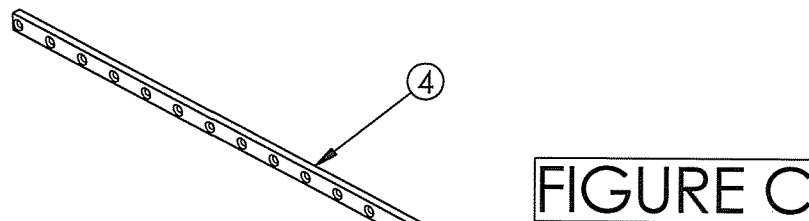
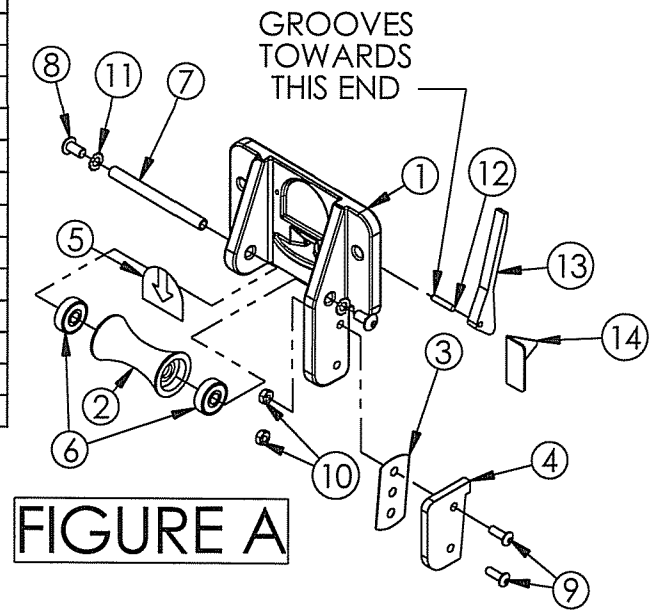
KEY	QTY	P/N	DESCRIPTION
1	REF	514975	FRAME WELDMNT
2	REF	514796	MAIN MOUNTING PLATE
3	1	514244	INFEED WHEEL
4	2	433922	M6 X 16 SFHCS (ZINC)
5	1	516942	MOTOR - INFEED
6	5	437290	M5 X 12 SFHCS
7	1	516482	M6 X 6 SSS KNURLED (ZINC)
8	1	434169	CLEVIS PIN
9	1	514978	PROXIMITY SWITCH
10	1	432963	M3 X 12 SFHCS
11	1	514259	INFEED GUIDE
12	1	514591	3 X 22 DOWEL PIN
13	1	514589	BLOCKER EDGE GUIDE WLDMNT.
14	4	518402	M4 LOCKWASHER (ZINC)
15	1	515257	LE-026C-00MW EXTENSION SPRING
16	2	420216	M4 X 10 SHCS (ZINC)
17	1	514582	STRAP GUIDE HINGE-F
18	1	514581	STRAP GATE
19	1	251266	M8 FLATWASHER (ZINC)
20	1	10051	M8 X 20 SBHCS
21	1	514584	SHOULDER WASHER
22	1	10077	M6 LOCKWASHER HC (ZINC)
23	1	433920	M6 X 20 SHCS (ZINC)
24	2	264452	GROOVED PIN (TYPE G) 3/16 X 1/2
25	2	274931	3 X 12 DOWEL PIN
26	2	432258	M4 X 25 SHCS



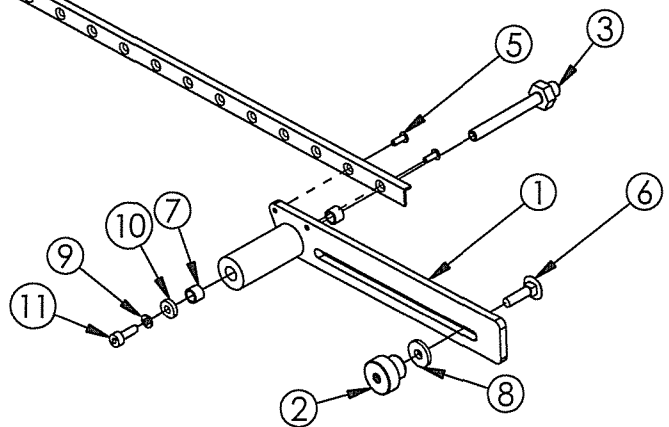


KEY	QTY	P/N	DESCRIPTION
1	REF	514975	LBX-2000 FRAME WELDMENT
2	REF	514796	MAIN MOUNTING PLATE
3	7	514948	SLACK BOX SPACER
4	4	272418	M5 X 12 SHCS (FLANGED ZINC)
5	9	169440	M5 HEXNUT
6	2	280279	M5 X 16 SFHCS (ZINC)
7	6	171571	M5 FLATWASHER (ZINC)
8	5	010031	M5 X 25 SHCS
9	1	514747	PROXIMITY SWITCH
10	1	432963	M3 X 12 SFHCS
11	1	514931	PROX MOUNTING BRACKET
12	2	011214	M5 X 16 SHCS
13	1	174364	M3 HEXNUT
14	2	010076	M5 LOCKWASHER
15	2	272418	M5 X 12 SHCS FLANGED

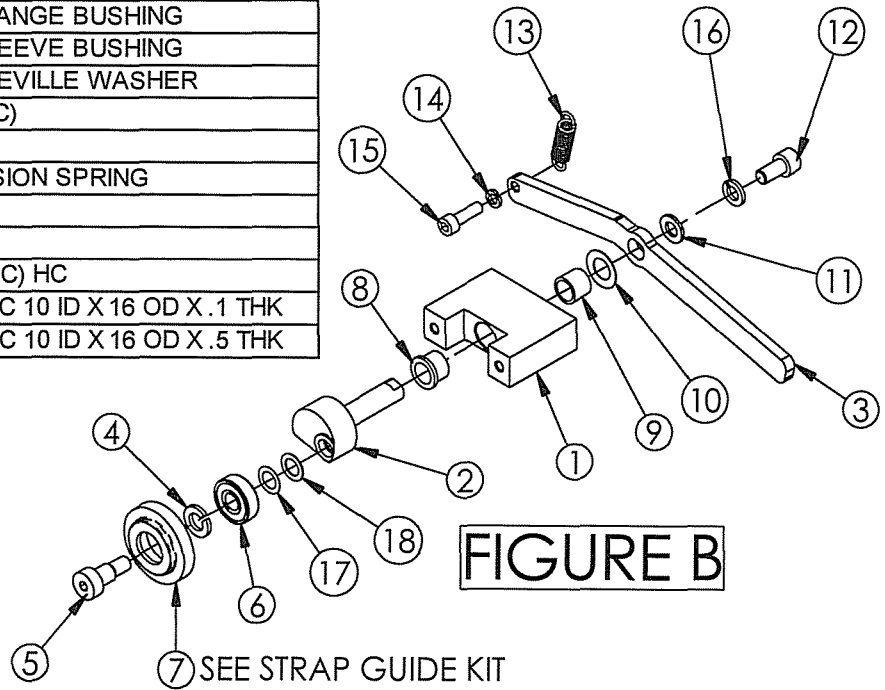
KEY	QTY	P/N	DESCRIPTION
1	1	514243	OUT OF STRAP INFEED HOUSING
2	1	514743	SMALL INFEED ROLLER
3	1	420804	DOUBLE EDGED SLITTER
4	1	514240	UPPER INFEED KNIFE COVER
5	1	434063	DIRECTION ARROW (THREADING)
6	2	274924	DIA 6 X 10 BUSHING
7	1	514241	ROLLER SHAFT
8	2	170118	M5 X 10 SBHCS (ZINC)
9	2	164967	M4 X 12 SBHCS
10	2	164966	M4 HEX NUT (ZINC)
11	2	439812	M5 EXT. TOOTH LOCKWASHER
12	1	514225	3 X 16 (HALF LENGTH GROOVED) DOWEL PIN
13	1	514884	OUT OF STRAP FINGER
14	1	514988	SHIM PLATE



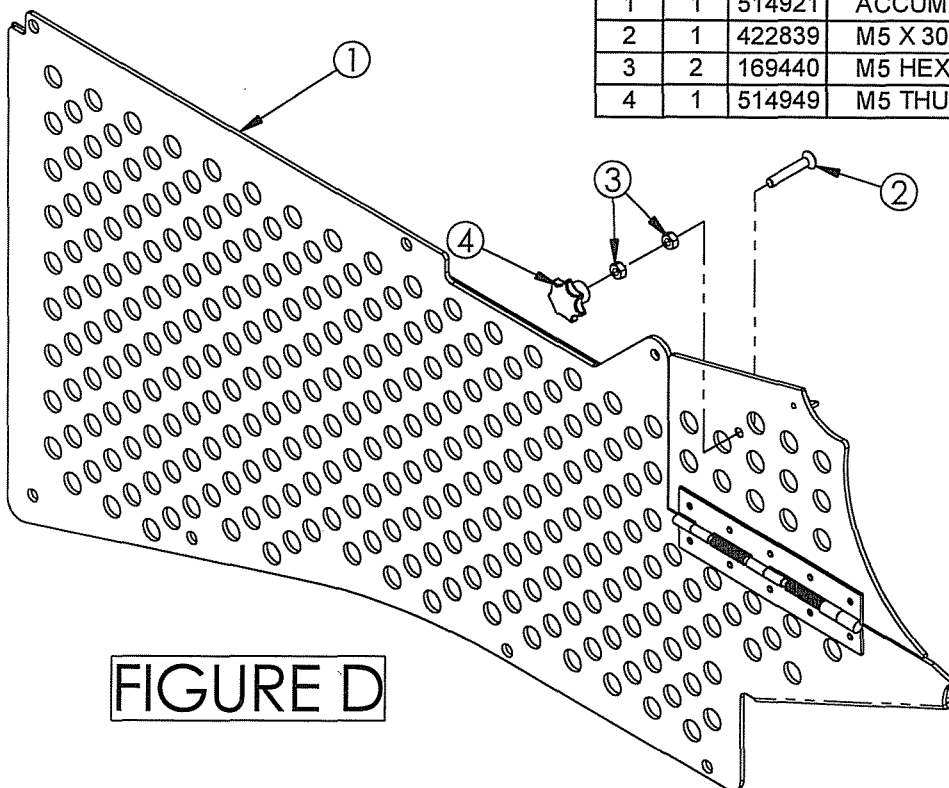
KEY	QTY	P/N	DESCRIPTION
1	1	514926	BALANCE ARM WELDMENT
2	1	514953	M5 KNURLED THUMBKNOB (WEIGHT)
3	1	514912	HEX STUD
4	1	514954	BALANCE ARM
5	2	150589	M3 X 8 SBHCS
6	1	515248	CARRIAGE SCREW
7	2	292448	8 X 6 X 6 DU BUSHING
8	1	432426	M5 CAR BODY WASHER (ZINC)
9	1	185700	M4 LOCKWASHER
10	1	516239	M4 HARDENED WASHER
11	1	162383	M4 X 8 SHCS



KEY	QTY	P/N	DESCRIPTION
1	1	514929	ECCENTRIC BEARING
2	1	516984	PINCH WHEEL ECCENTRIC
3	1	514928	ECCENTRIC HANDLE
4	1	010078	M10 LOCKWASHER (ZINC)
5	1	514078	Ø10 M8 X 12 SHSS
6	1	434655	BALL BEARING
7	1	REF.	PINCH WHEEL
8	1	514858	12ID X 15OD X 12LG FLANGE BUSHING
9	1	514857	12ID X 15OD X 12LG SLEEVE BUSHING
10	A/R	516472	12.3 ID X 21.8 OD BELLEVILLE WASHER
11	1	251266	M8 FLATWASHER (ZINC)
12	1	515731	M8 X 12 SHCS (ZINC)
13	1	434741	3/8OD X 1.5 LG EXTENSION SPRING
14	1	010077	M6 HC WASHER (ZINC)
15	1	433920	M6 X 20 SHCS (ZINC)
16	1	280813	M8 LOCKWASHER (ZINC) HC
17	A/R	516399	SHIM WASHER, METRIC 10 ID X 16 OD X .1 THK
18	A/R	516400	SHIM WASHER, METRIC 10 ID X 16 OD X .5 THK



KEY	QTY	P/N	DESCRIPTION
1	1	514921	ACCUMULATOR BOX WELDMENT
2	1	422839	M5 X 30 SFHCS (ZINC)
3	2	169440	M5 HEX NUT (ZINC)
4	1	514949	M5 THUMBKNOB

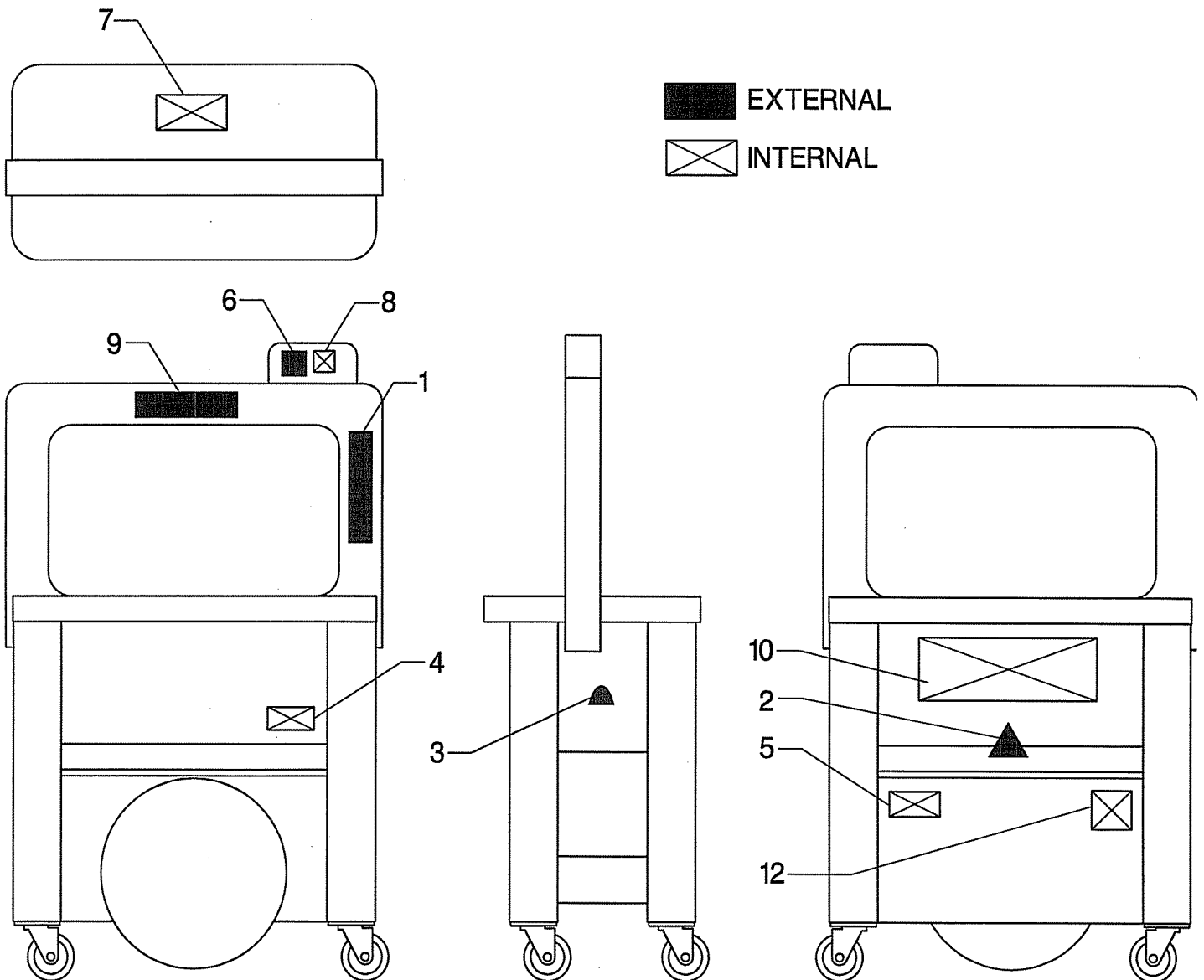


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LABEL DISPOSITION

514276-5

		CONFIG-1	CONFIG-2	
KEY	QTY	P/N	P/N	DESCRIPTION
1	1	264579	436353	GENERAL SAFETY DECAL
2	1	286207	286207	ELECTRICAL SHOCK DECAL
3	1	434063	434063	DIRECTIONAL ARROW INFEEED DECAL
4	1	434392	434392	BALANCE ARM DECAL
5	1	434395	434395	DISPENSER DECAL
6	1	434446	434446	TENSION DECAL
7	1	516728	516728	HOT KNIFE DECAL
8	1	514800	514800	TENSION TIMER DECAL
9	1	514801	514801	MAIN(SIGNODE) LOGO DECAL
10	1	514390	514390	ELECTRICAL DECAL
11	1	514803	514803	PLUG IDENTIFICATION DECAL
12	1	514805	514805	INFO SIGN (LB 112 & 212 STRAP)

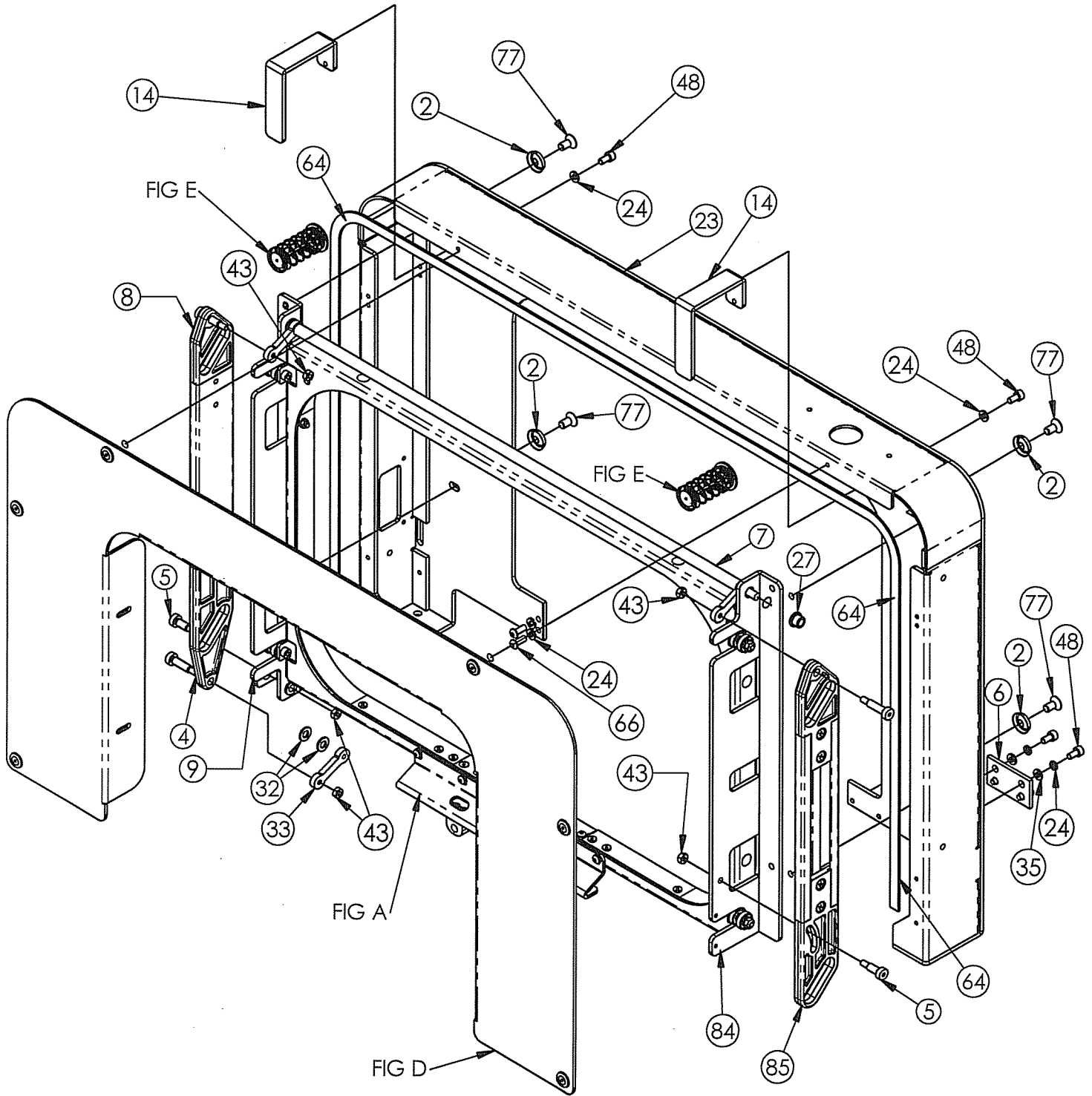


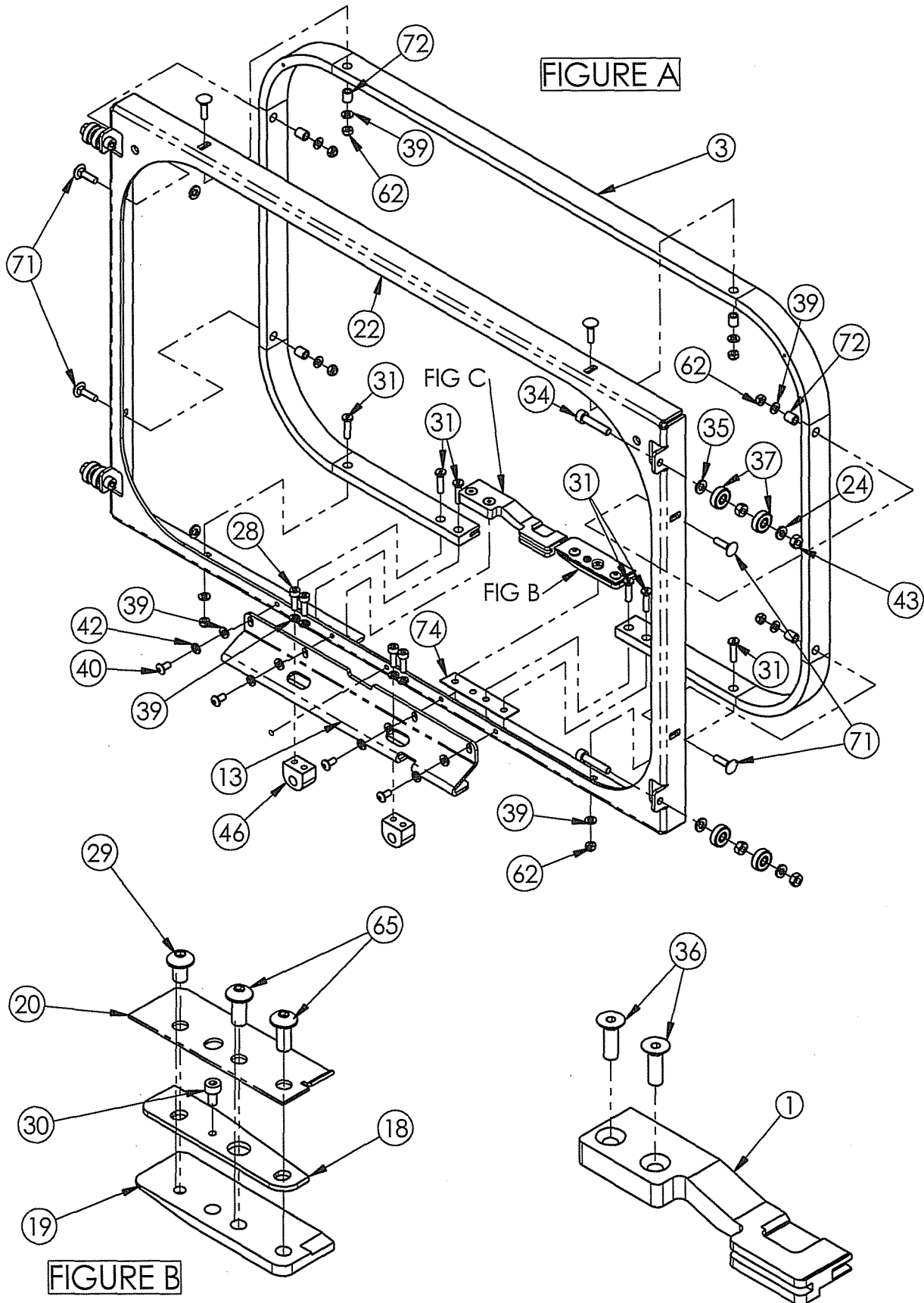
CHUTE ASSEMBLY

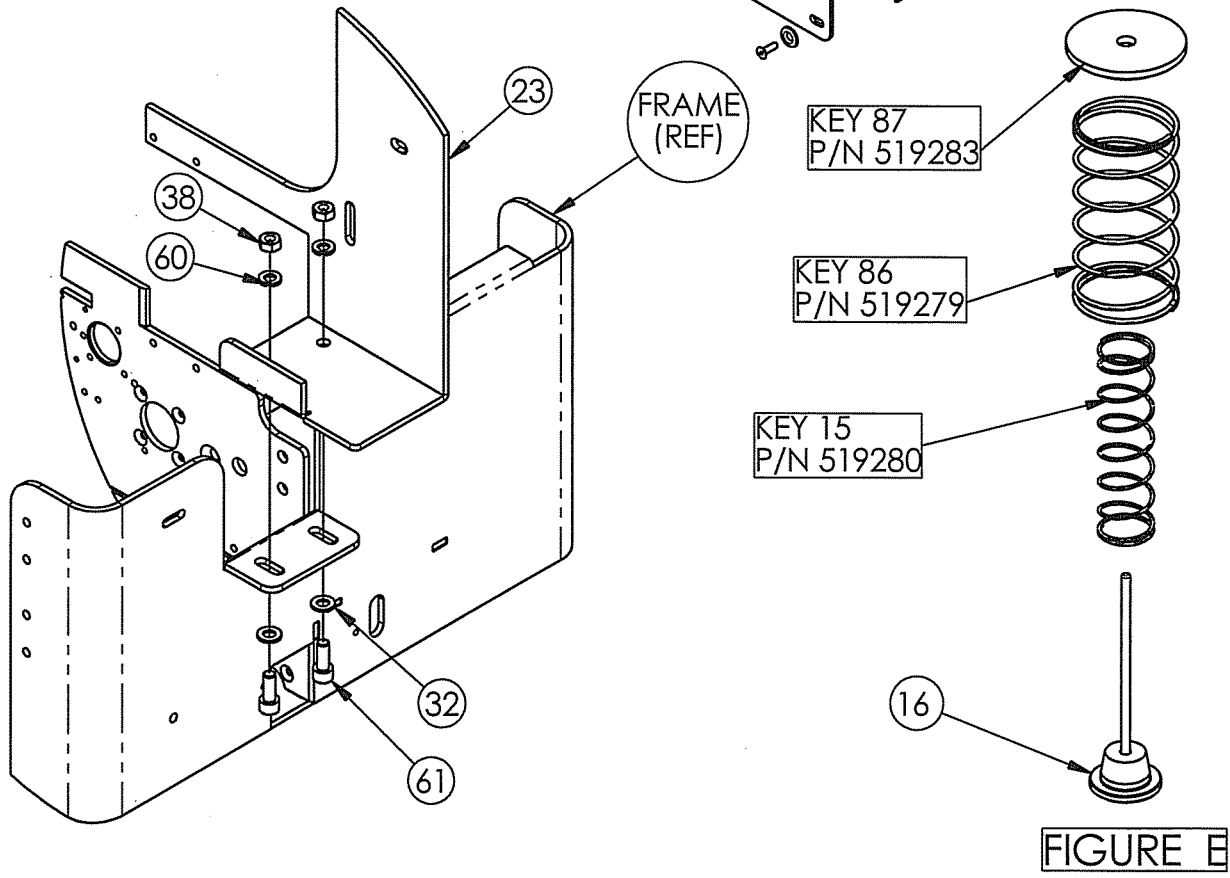
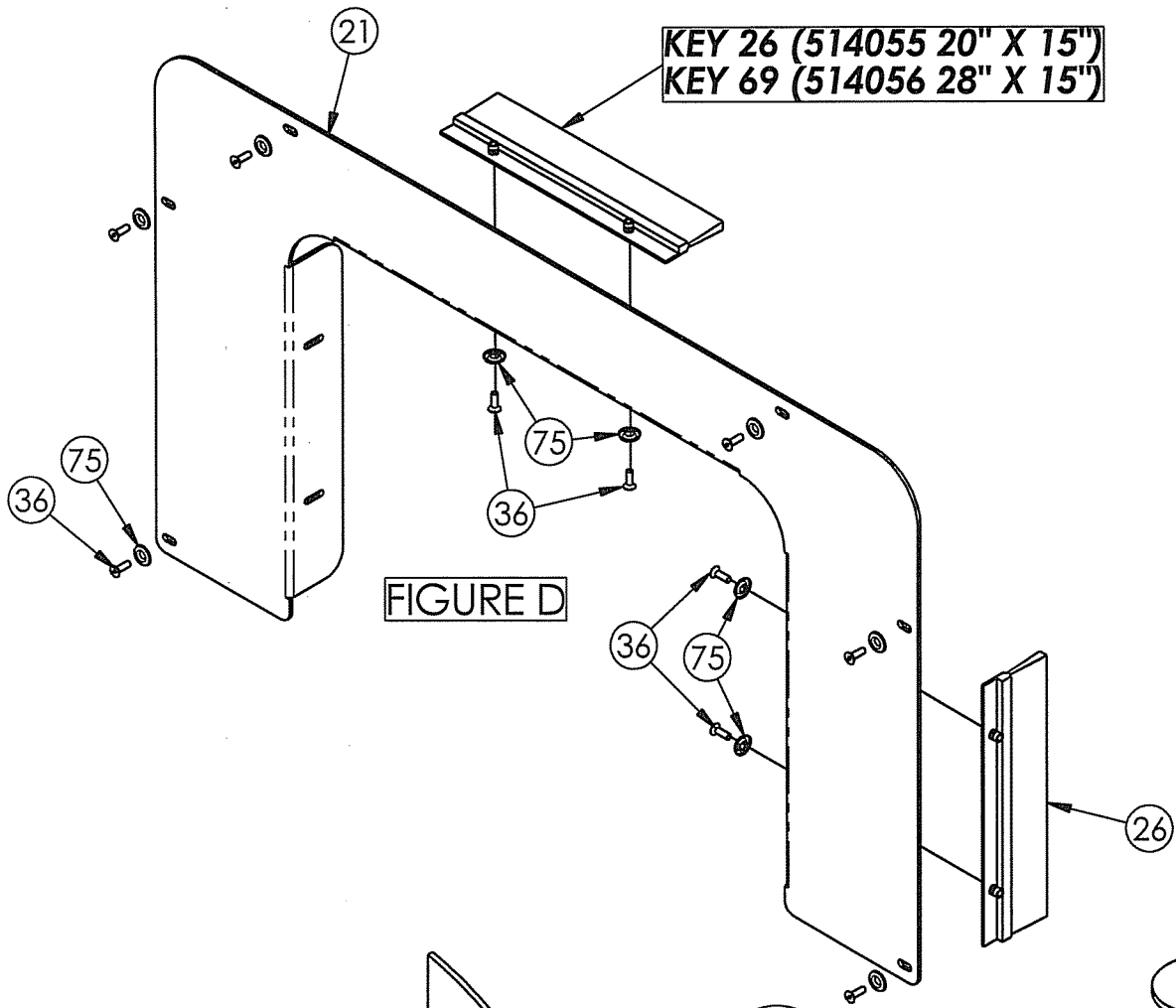
514054-9

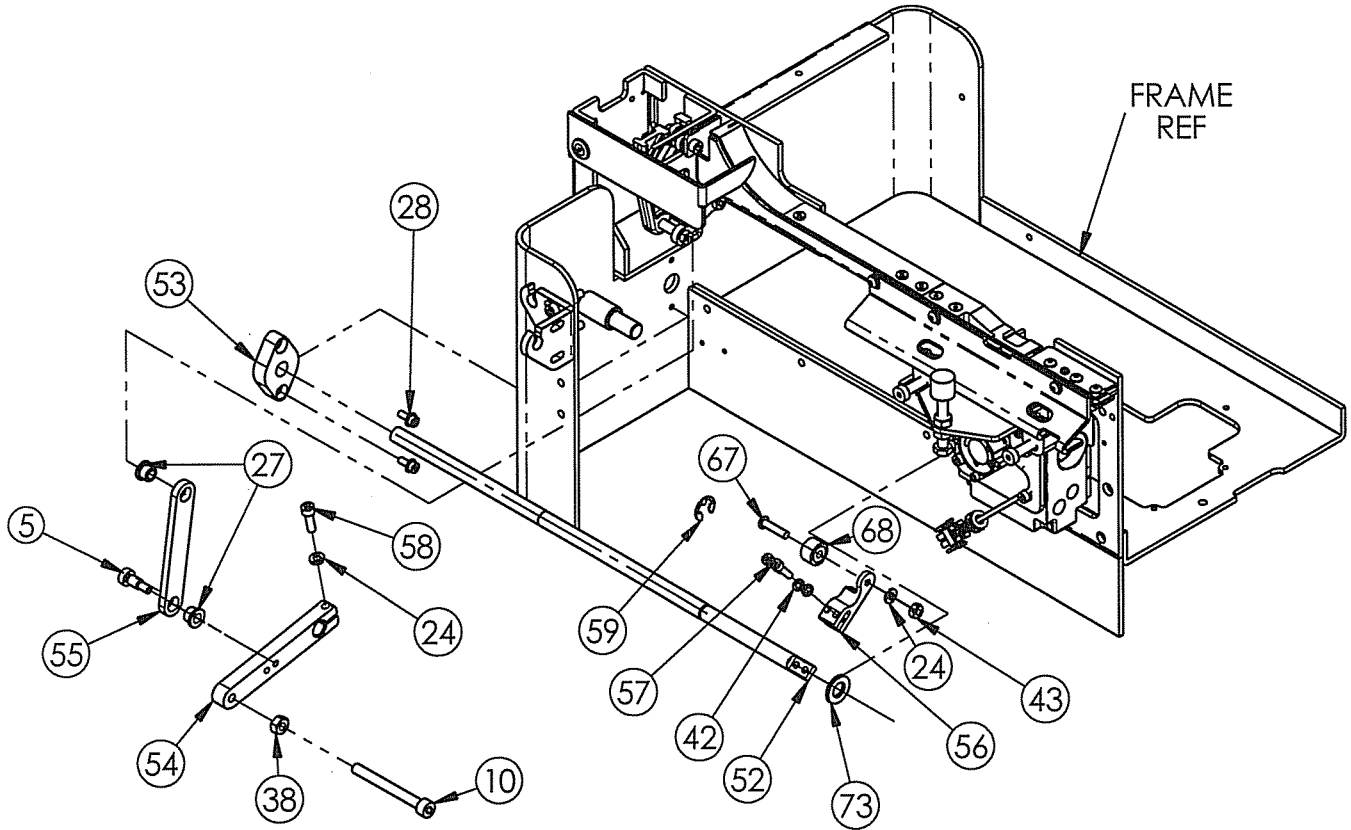
KEY	DESCRIPTION	514056 28" X 15" CHUTE		514055 20" X 15" CHUTE		KEY	DESCRIPTION	514056 28" X 15" CHUTE		514055 20" X 15" CHUTE	
		P/N	QTY	P/N	QTY			P/N	QTY	P/N	QTY
1	CHUTE ENTRY GUIDE	SEE FIGURE C				44	HINGE	514981	2	514981	2
2	5/16" FINISHING WASHER	514472	6	514472	4	45	INTERLOCK SWITCH ACTUATOR	438752	1	438752	1
3	CHUTE MATERIAL	514466	AR	514465	AR	46	CHUTE SLIDER BLOCK	437808	2	437808	2
4	Ø8/M6 X 25 SHSS	280999	3	280999	3	47	FRONT TABLE TOP	514477	1	514478	1
5	Ø8/M6 X 16 SHSS	435951	3	435951	3	48	M6 X 12 SHCS (ZINC)	433919	8	433919	8
6	ARCH/CHUTE MOUNTING PLATE	514445	1	514445	1	49	Ø6/M5 X 10 SHSS	171044	1	171044	1
7	TORSION BAR WELDMENT	514938	1	514940	1	50	M6 FENDERWASHER	421876	2	421876	2
8	DRIVING BAR	516959	1	516959	1	51	CHUTE OPENER HOOK	514888	1	514888	1
9	CHUTE OPENER GUIDE PLATE	519531	1	519531	1	52	PIVOT SHAFT - CHUTE OPENER	514418	1	514418	1
10	M8 X 60 SHCS	186983	1	186983	1	53	BUSHING BLOCK	514449	1	514449	1
11	JACK SHAFT	514935	1			54	CHUTE OPENER CLAMP LINK	514916	1	514916	1
12	JACK SHAFT BRACKET	514424	1			55	CONNECTING LINK	514423	1	514423	1
13	LOWER CHUTE SUPPORT	516009	1	516009	1	56	CAM LINK (MACHINING)	514437	1	514437	1
14	STRIPPER PIN BRACKET	514419	2	514419	2	57	M5 X 20 SHCS (ZINC)	166063	2	166063	2
15	C SPRING S1488	519280	2	519280	2	58	M6 X 20 SHCS (ZINC)	433920	5	433920	5
16	STRIPPER PIN WELDMENT	514459	2	514459	2	59	1/2" E-RING (TA# 5133-50)	16538	1	16538	1
17	M8 FENDERWASHER	420322	1	420322	1	60	M8 LOCKWASHER (ZINC)	162381	5	162381	5
18	RE-ENTRY STRAP SELECTOR	514740	1	514740	1	61	M8 X 20 SHCS (ZINC)	160331	5	160331	5
19	BOTTOM - RE-ENTRY TRACK	514845	1	514845	1	62	M5 HEX LOCK NUT	181255	9	181255	8
20	TOP - RE-ENTRY TRACK	514739	1	514739	1	63	HEAD COVER PLATE (FAN)	514439	1	514439	1
21	ARCH COVER	514408	1	514409	1	64	FOAM STRIP	435344	A/R	435344	A/R
22	CHUTE FRAME	514406	1	514407	1	65	M5 X 12 SBHCS (ZINC)	175914	4	175914	4
23	CHUTE ARCH	514913	1	514959	1	66	M6 X 16 SBHCS (ZINC)	10034	2	10034	2
24	M6 LOCKWASHER (ZINC)	481889	19	481889	19	67	M6 X 25 SPEC LOW HEAD SHCS	514413	1	514413	1
25	M8 THREADED RUBBER BUMPER	514889	1	514889	1	68	CAM FOLLOWER	514639	1	514639	1
26	10" BRUSH ASSEMBLY	515203	1	515203	2	69	18" BRUSH ASSEMBLY	437995	1		
27	FLANGED BEARING	514416	6	514416	6	70	TABLE TOP BRACKET	514844	1	514844	1
28	M5 X 12 SHCS FLANGED (ZINC)	272418	6	272418	6	71	M5 CARRIAGE BOLT	515248	9	515248	6
29	M5 X 8 SBHCS (ZINC)	421805	1	421805	1	72	CHUTE SPACER	515247	9	515247	8
30	M3 X 8 SHCS	262551	1	262551	1	73	1/2" FLATWASHER	71806	1	71806	1
31	M5 X 20 SHCS SPECIAL LOW	515255	6	515255	6	74	CHUTE RE-ENTRY PLATE	514438	1	514438	1
32	M8 FLAT WASHER (ZINC)	251266	4	251266	6	75	#12 FINISHING WASHER	514440	10	514440	10
33	TORSION BAR PLATE - SHORT			514470	1	76	PHOTOEYE HOLE COVER PLATE	514835	1	514835	1
34	M6 X 30 SHCS (ZINC)	162374	4	162374	4	77	M8 X 16 SFHCS (SS)	438057	7	438057	5
35	M6 FLATWASHER	262617	8	262617	8	78	M8 X 60 SHCS	164965	1	164965	1
36	M5 X 16 SFHCS (ZINC)	280279	16	280279	16	79	Ø8/M6 X 40 SHSS	434321	2	434321	2
37	BALL BEARING (6 X 19 X 6)	274924	8	274924	8	80	CHUTE OPENER STOP	514987	1	514987	1
38	M8 HEX NUT (ZINC)	164953	7	164953	7	81	M5 X 16 SHCS (ZINC)	11214	4	11214	4
39	M5 FLATWASHER (ZINC)	171571	21	171571	21	82	M4 X 25 SHCS (ZINC)	432258	2	432258	2
40	M5 X 10 SBHCS (ZINC)	170118	5	170118	5	83	FAN ASSEMBLY	514675	1	514675	1
41	M5 HEX NUT (ZINC)	169440	10	169440	10	84	CHUTE OPENER GUIDE RIGHT	519530	1	519530	1
42	M5 LOCKWASHER (ZINC)	10076	29	10076	29	85	DRIVE BAR RIGHT	516953	1	516953	1
43	M6 HEX NUT (ZINC)	5465	16	5465	16	86	C SPRING B17-150	519279	2	519279	2
						87	CHUTE SPRING PERCH	519283	2	519283	2

*WEAR PARTS ARE UNDERLINED

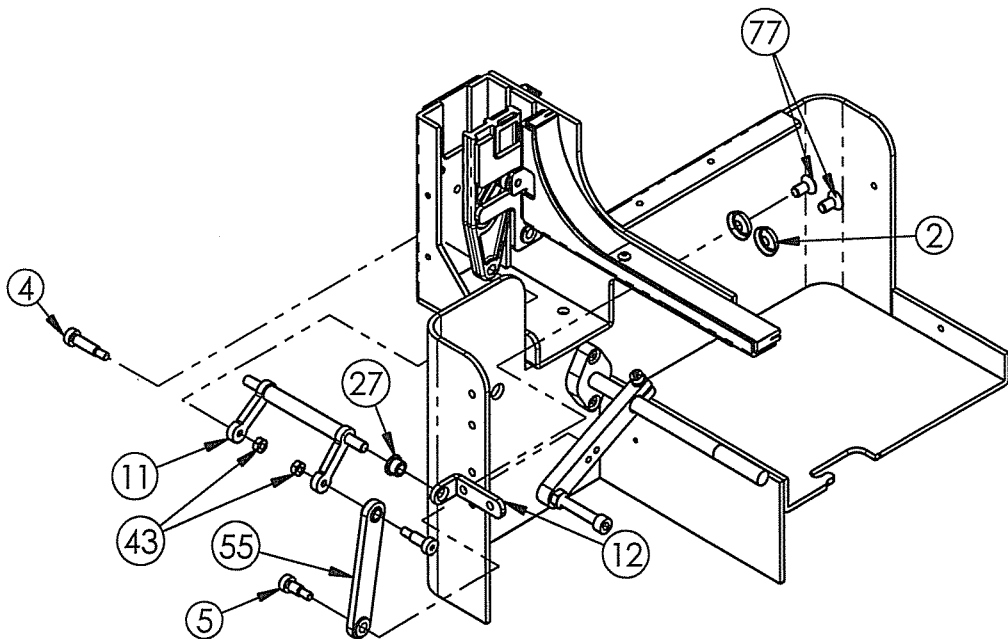




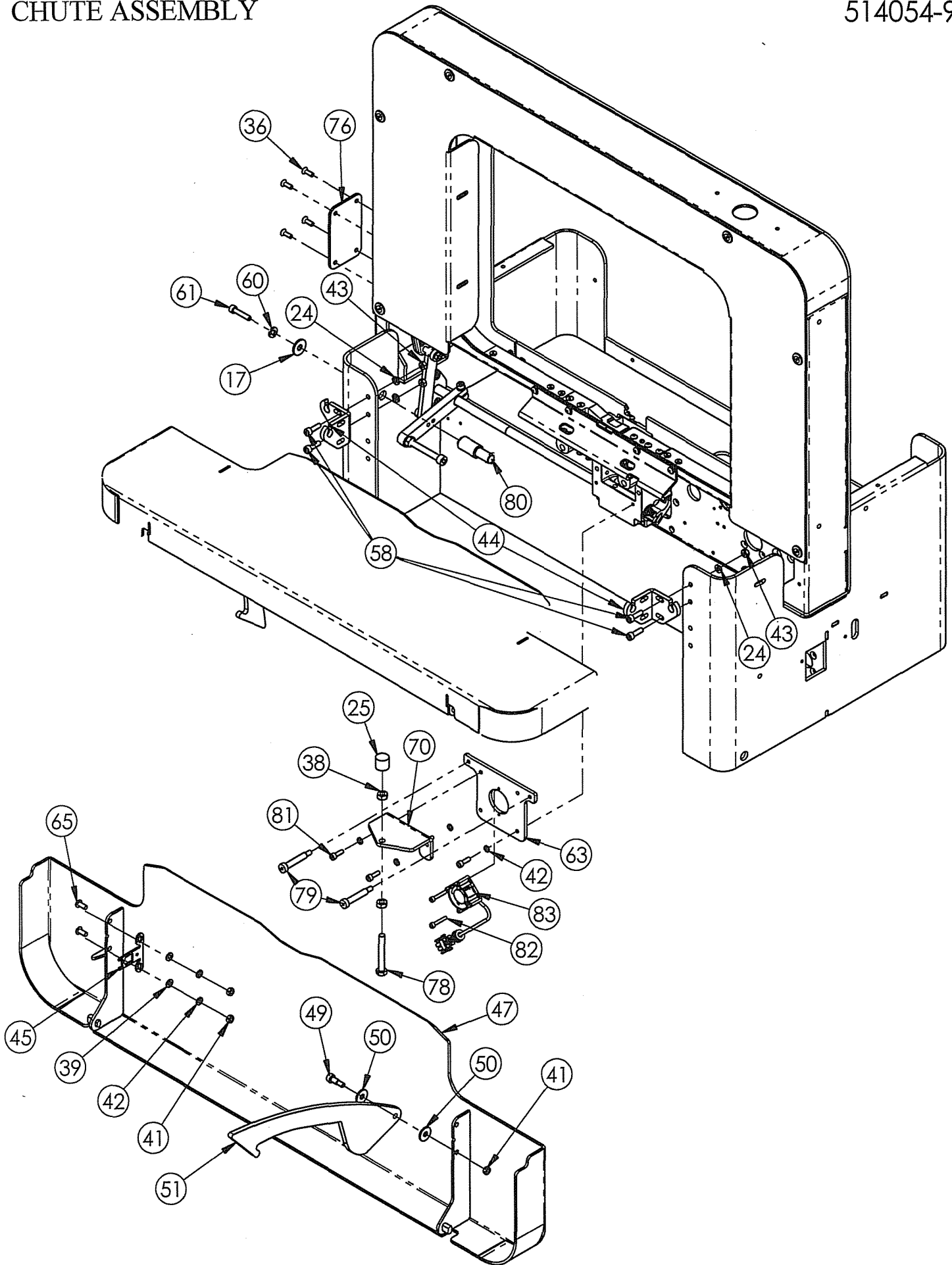




20" X 15" (SMALL CHUTE) OPENER CONFIGURATION

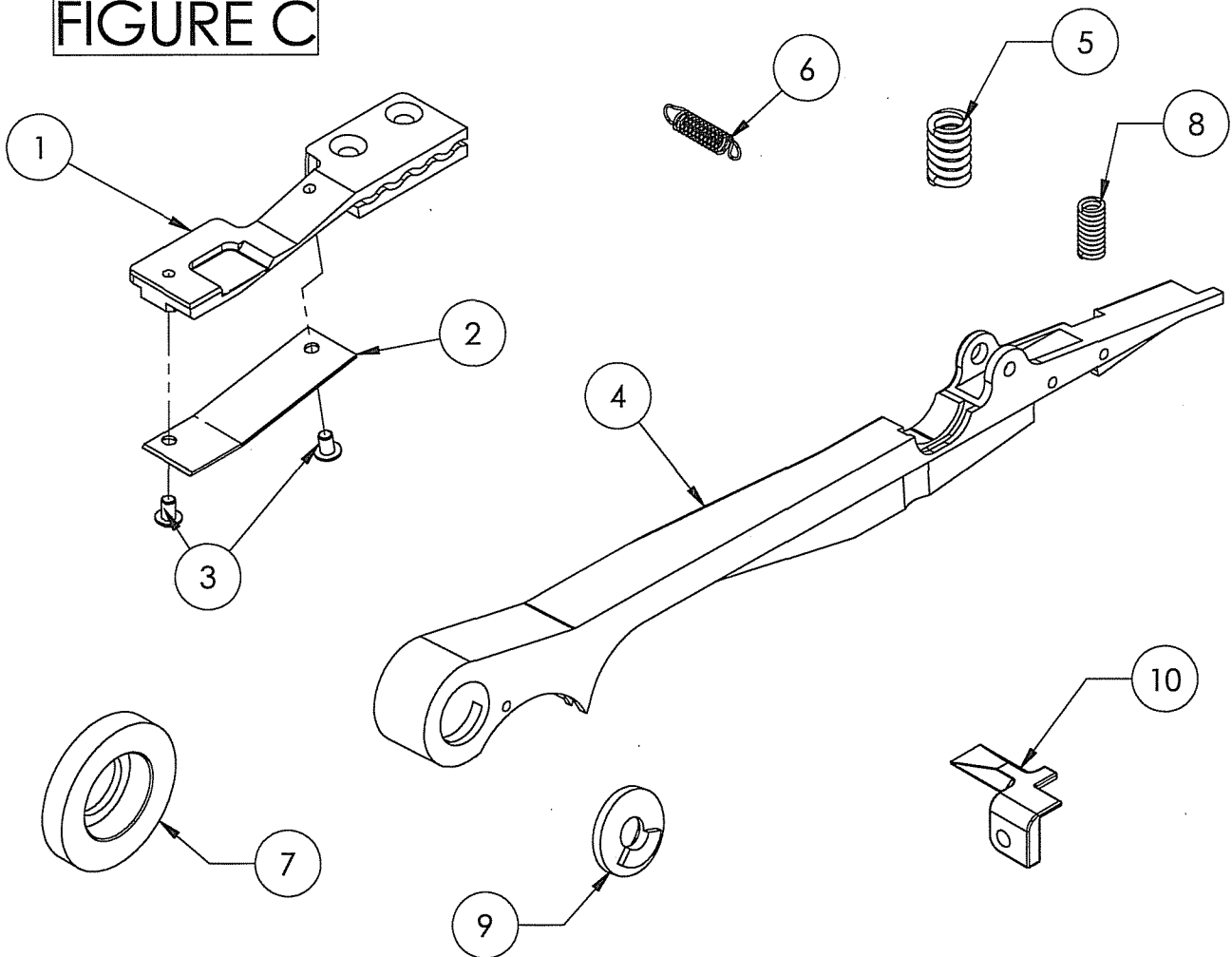


28" X 15" (LARGE CHUTE) OPENER CONFIGURATION



KEY	QTY	P/N	DESCRIPTION
1	1	514490	CHUTE ENTRY OPTIMIZER
2	1	514489	CHUTE ENTRY BOTTOM PLATE
3	2	438103	M4 X 6 SBHCS
4	1	516350	TRACK COVER
5	1	519165	FEED & TAKE-UP SPRING OUTER
6	1	434741	INFEED SPRING (LE-058D-5MW)
7	1	514252	PINCH WHEEL
8	1	514596	FEED & TAKE-UP SPRING INNER
9	1	514681	FEED & TAKE-UP PINCH WHEEL
10	1	514725	CUTTER TONGUE

FIGURE C



PARTS LISTS & EXPLODED VIEWS

MOUNTING PLATE (7-1)

SEALER (7-3)

END GRIP (7-7)

PLATEN (7-8)

LOOP GRIP (7-9)

CAMSHAFT MOTOR (7-10)

HOT KNIFE (7-11)

UPPER TRANSITION GUIDE (7-13)

⚠ WARNING

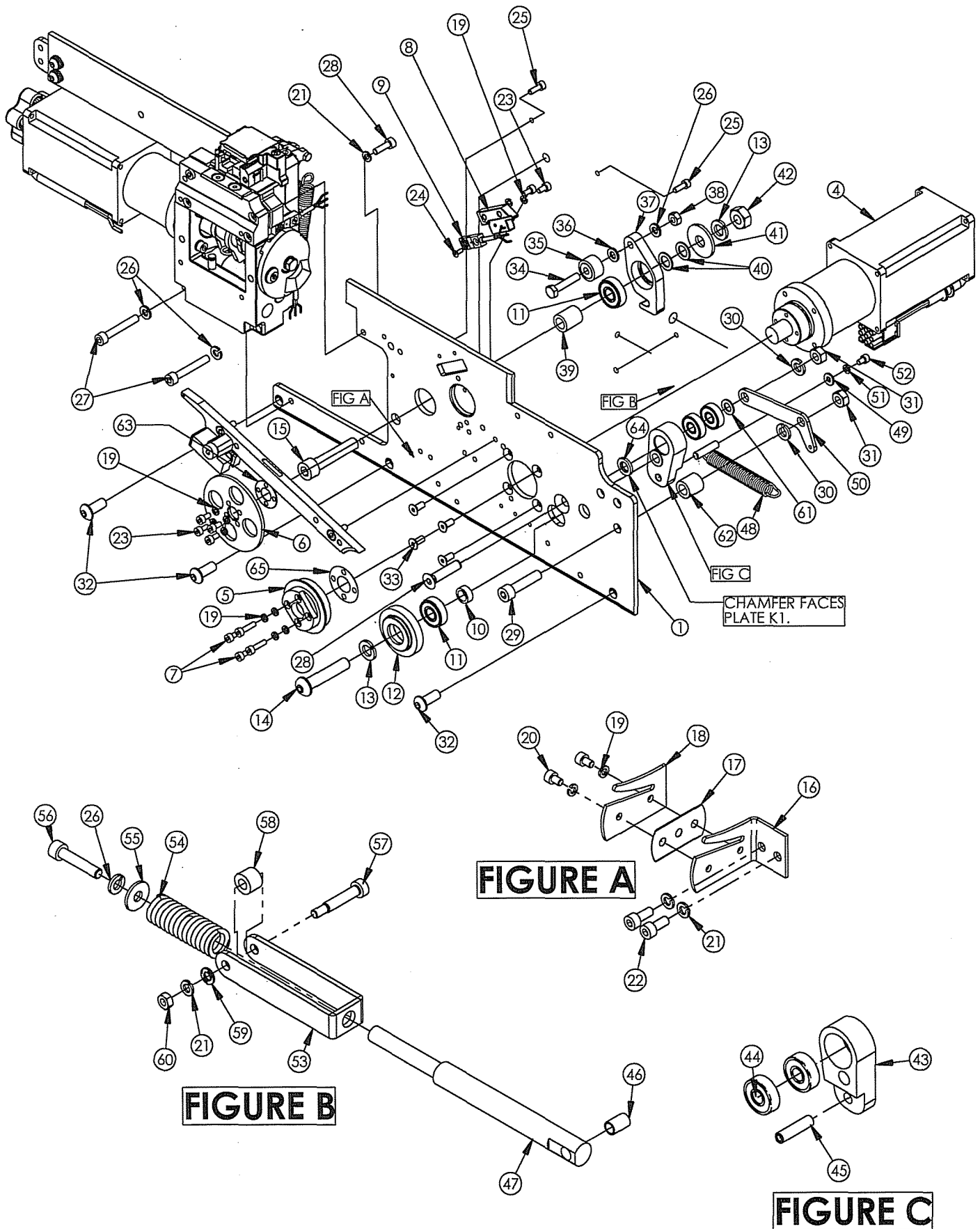
Inspect all parts daily and replace them if they are worn or broken. Failure to do this can affect a product's operation and could result in serious personal injury.

FUNCTIONS

MOUNTING PLATE ASSEMBLY

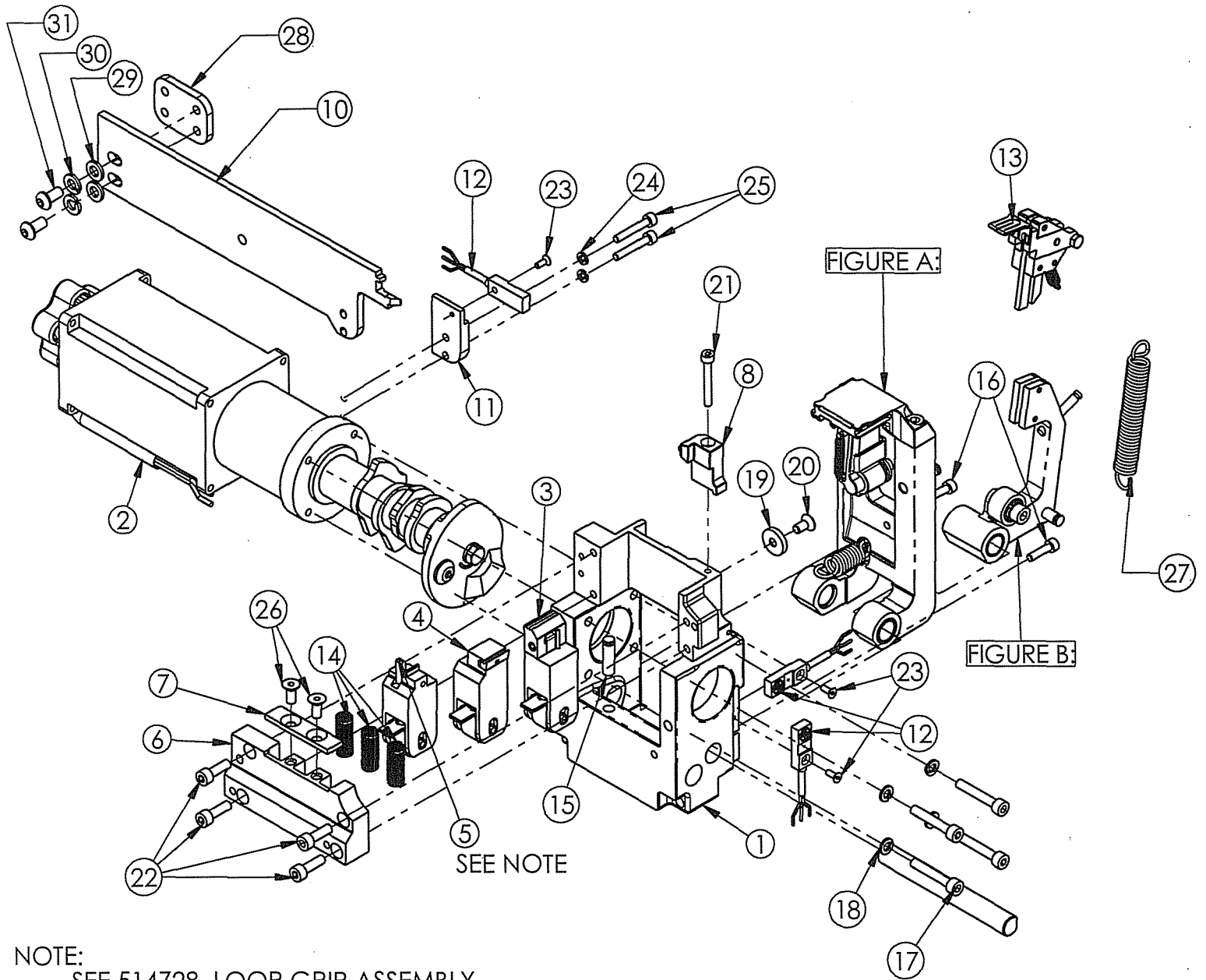
514060-8

KEY	QTY	P/N	DESCRIPTION	KEY	QTY	P/N	DESCRIPTION
1	1	515956	MAIN MOUNTING PLATE	32	3	010051	M8 X 20 SBHCS (ZINC)
2	1	516349	MOTOR - FEED & T/U	33	4	437290	M5 X 12 SFHCS (ZINC)
3	1	514061	SEALER -- ASSEMBLY	34	1	011030	M6 X 30 HHCS (ZINC)
4	1	514349	TENSION MOTOR	35	1	514639	19 OD X 6 ID X 12 WIDE CAM FOLLOWER
5	1	516496	TENSION WHEEL	36	1	262617	M6 FLAT WASHER (ZINC)
6	1	514774	FEED AND TAKE-UP WHEEL	37	1	514822	CAM FOLLOWER PLATE
7	4	433917	M4 X 16 SHCS (ZINC)	38	1	005465	M6 HEXNUT (ZINC)
8	1	515955	PROX MOUNTING PLATE	39	1	514840	CAM FOLLOWER SPACER
9	1	514747	SHIELDED PROXIMITY SWITCH	40	2	514821	10 ID X 16 OD X 1 THICK SHIM WASHER
10	1	514841	PINCH WHEEL SPACER	41	1	437227	M10 FENDER WASHER (ZINC)
11	2	434655	26 OD X 10 ID X 8 WIDE BALL BEARING	42	1	164962	M10 HEXNUT (ZINC)
12	2	514252	PINCH WHEEL	43	1	514798	TENSION WHEEL PLATE
13	1	010078	M10 LOCKWASHER (ZINC)	44	2	434092	22 OD X 8 ID X 7 WIDE BALL BEARING
14	1	514823	M10 X 50 SBHCS (ZINC)	45	1	514842	Ø1/4 X 1 LG W/8-32 THD. PULL-OUT DOWEL
15	1	436827	M10 X 50 SHCS (ZINC)	46	1	514807	5/16 OD X 1/4 ID X 1/2 LG BRONZE BUSHING
16	1	434755	CUTTER BACK PLATE	47	1	514799	HIGH TENSION SPRING SHAFT
17	1	420804	DOUBLE EDGED SLITTER	48	1	438628	1/2 OD X 3/8 ID X 3 LG EXTENSION SPRING
18	1	420803	CUTTER FRONT PLATE	49	1	009392	#8 FLAT WASHER (ZINC)
19	12	185700	M4 LOCKWASHER HC (ZINC)	50	1	514797	HIGH TENSION BRACE
20	2	293903	M4 X 6 SHCS (ZINC)	51	1	421723	#8 LOCKWASHER (ZINC)
21	4	010076	M5 LOCKWASHER (ZINC)	52	1	014546	#8-32 X 1/4 LG SHCS (ZINC)
22	2	010028	M5 X 12 SHCS (ZINC)	53	1	514763	TENSION YOKE
23	6	162383	M4 X 8 SHCS (ZINC)	54	1	516497	3/4 OD X 3/8 ID X 3 LG DIE SPRING (PURPLE)
24	1	251967	M3 X 8 SFHCS	55	1	421876	M6 FENDER WASHER (ZINC)
25	2	165317	M4 X 12 SHCS (ZINC)	56	1	162374	M6 X 30 SHCS (ZINC)
26	4	481889	M6 LOCKWASHER (ZINC)	57	1	420676	Ø6-M5 X 25 SHSS
27	2	162406	M6 X 40 SHCS (ZINC)	58	1	514806	TENSION YOKE SPACER
28	1	514593	SQUARING SCREW	59	1	171571	M5 FLAT WASHER (ZINC)
29	1	172079	M8 X 40 SHCS (ZINC)	60	1	169440	M5 HEXNUT (ZINC)
30	2	162381	M8 LW (ZINC)	61	1	514820	8ID X 14OD X 1mm THICK SHIM WASHER
31	2	164953	M8 HEXNUT (ZINC)	62	1	514969	5/8" X 3/8" X 17mm LG. SPACER
				63	A/R	514598	SPACER
				64	1	514594	SQUARING SPACER
				65	A/R	516495	WHEEL SPACER



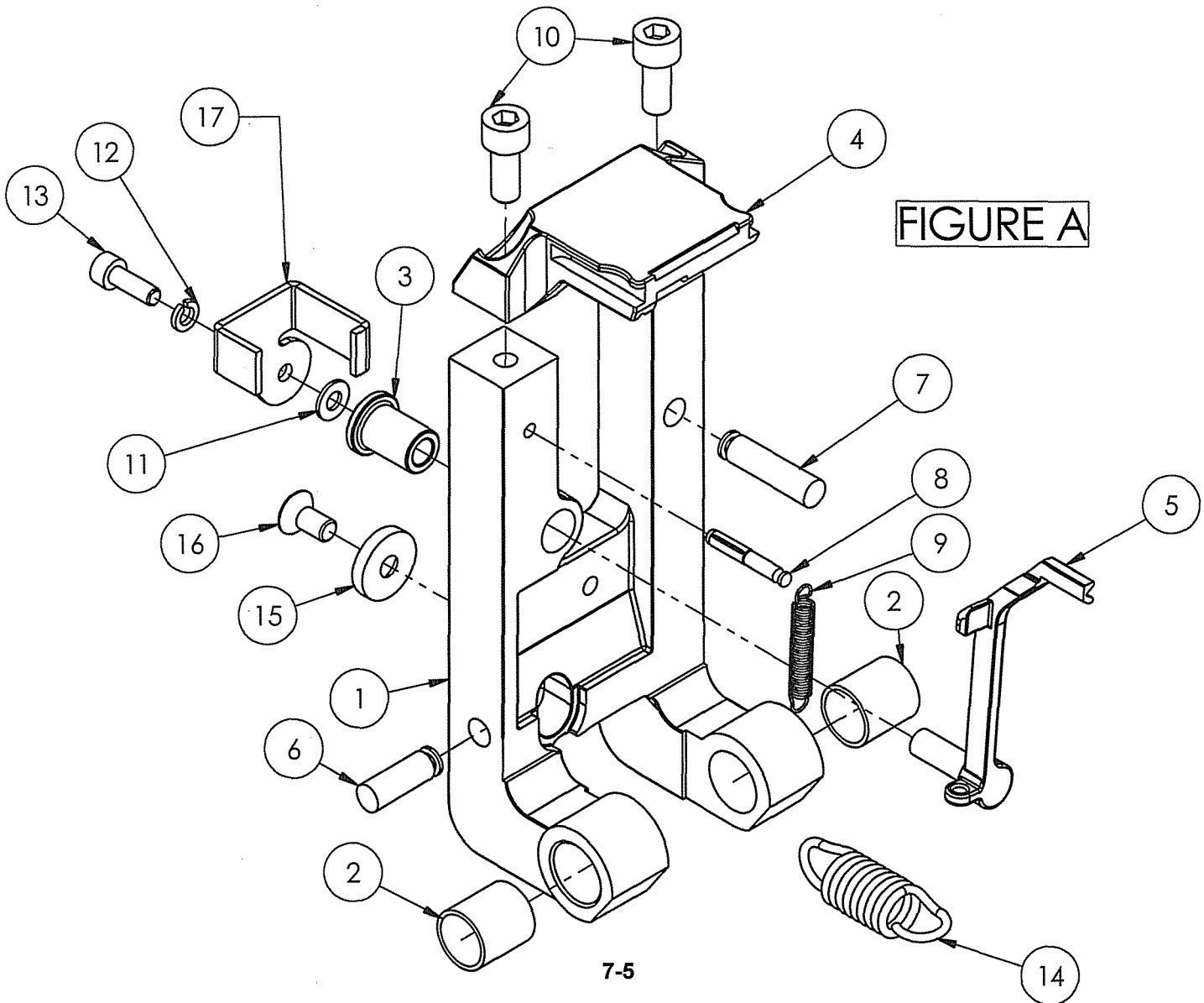
KEY	QTY	P/N	DESCRIPTION
1	1	514616	SEALER HOUSING
2	1	514062	SEALER -- CAM SHAFT MOTOR ASSEMBLY
<u>3</u>	<u>1</u>	<u>514080</u>	<u>SEALER -- END GRIP ASSEMBLY</u>
<u>4</u>	<u>1</u>	<u>514702</u>	<u>SEALER -- PLATEN ASSEMBLY</u>
5	1	514728	SEALER -- LOOP GRIP ASSEMBLY
6	1	514622	SLIDE COVER
7	1	514637	SPRING COVER
8	1	514630	R.H.STRIPPER
9	1	514638	SHAFT - PIVOT
10	1	519117	LEFT LOOP STRIPPER
11	1	514708	FLS PROX MOUNT
12	3	514747	PROXIMITY SWITCH
<u>13</u>	<u>1</u>	<u>514664</u>	<u>HOT KNIFE SUB ASSEMBLY</u>
14	3	514674	COMPRESSION SPRING
15	1	434688	GROOVED PIN
16	2	433917	M4 X 16 SHCS (ZINC)
17	4	421652	M5 X 30 SHCS (ZINC)
18	4	010076	M5 LOCKWASHER (ZINC)
19	1	514691	ANVIL STOP
20	1	280280	M5 X 10 SFHCS (ZINC)
21	1	434284	M4 X 30 SHCS
22	4	011214	M5 X 16 SHCS (ZINC)
23	3	251967	M3 X 8 SFHCS
24	2	185700	M4 LOCKWASHER HC (ZINC)
25	2	432258	M4 X 25 SHCS
26	2	437290	M5 X 12 SFHCS (ZINC)
27	1	438628	EXTENSION SPRING
28	1	519157	LEFT LOOP STRIPPER BACK-UP PLATE
29	2	262217	M6 FLAT WASHER (ZINC)
30	2	481889	M6 LOCKWASHER (ZINC)
31	2	165366	M6 X 12 BHCS (ZINC)

Wearing parts are those items which are underlined.



NOTE:
 SEE 514728, LOOP GRIP ASSEMBLY
 FOR SPECIAL INSTRUCTIONS WHEN
 USED ON LBX6520 CORRUGATED STRAPPING
 MACHINES

1	1	514628	ANVIL PIVOT MACHINING
2	2	514684	DU BUSHING
3	1	514667	FLANGED BUSHING
4	1	514626	ANVIL
5	1	514744	FEED LIMIT LEVER
6	1	439096	1/4 X 3/4" GROOVE PIN
7	1	514670	GROOVED PIN TYPE G
8	1	514668	GROOVED PIN
9	1	434657	EXTENSION SPRING
10	2	254411	M6 X 14 SHCS
11	1	171570	M4 FLATWASHER (ZINC)
12	1	185700	M4 LOCKWASHER HC (ZINC)
13	1	165317	M4 X 12 SHCS
14	1	514656	EXTENSION SPRING
15	1	514691	ANVIL STOP
16	1	280280	M5 X 10 SFHCS
17	1	514599	ARM LIMITER



KEY	QTY.	P/N	DESCRIPTION
1	1	514666	HOT KNIFE PIVOT MACH.
2	1	514639	CAM FOLLOWER
3	1	481889	M6 LOCKWASHER (ZINC)
4	1	10035	M6 X 18 SHCS
5	2	514684	DU BUSHING
6	1	434688	GROOVED PIN
7	1	264453	GROOVE PIN, 3/16-1 1/4 LG.
8	2	514688	Ø3 X 12 ROLL PIN

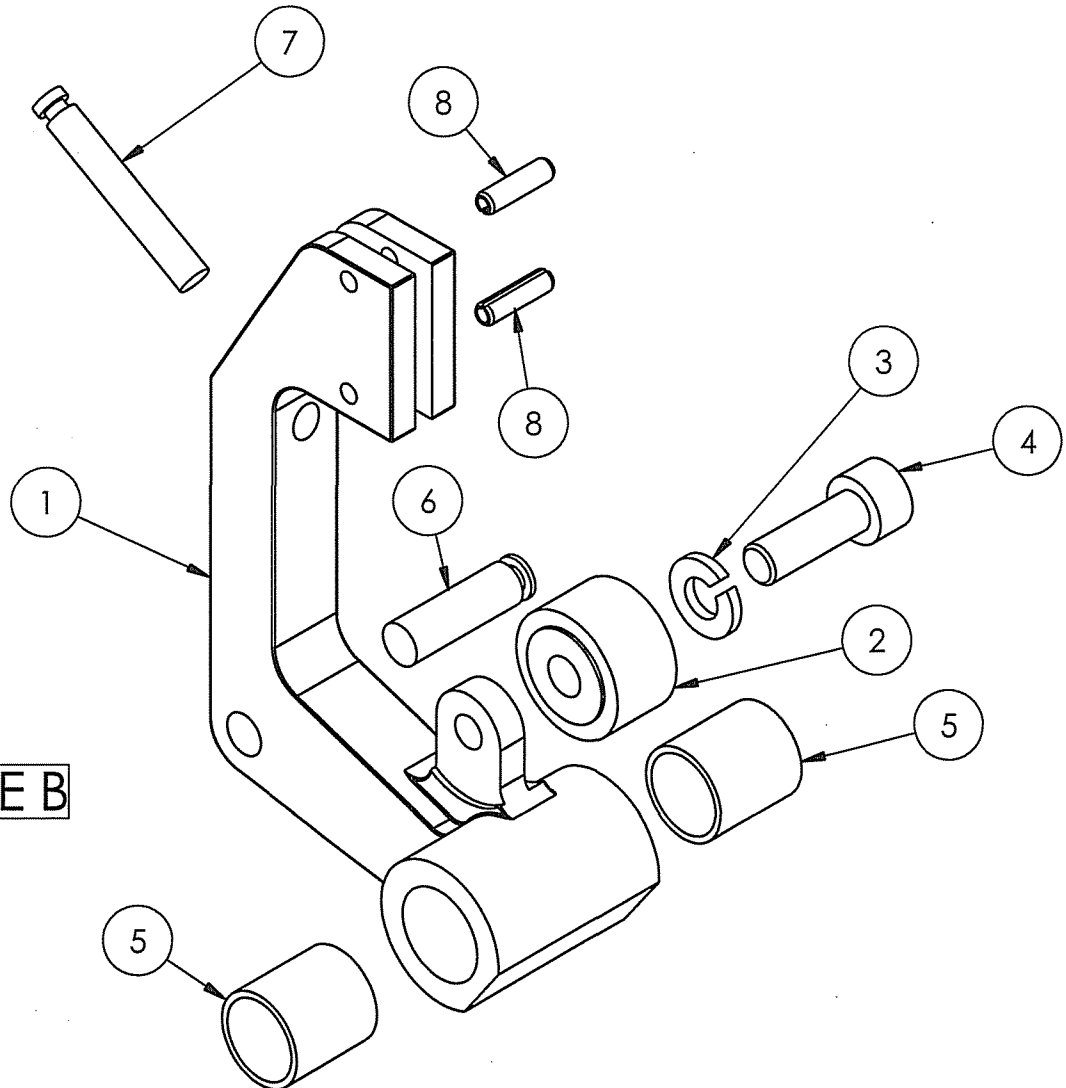
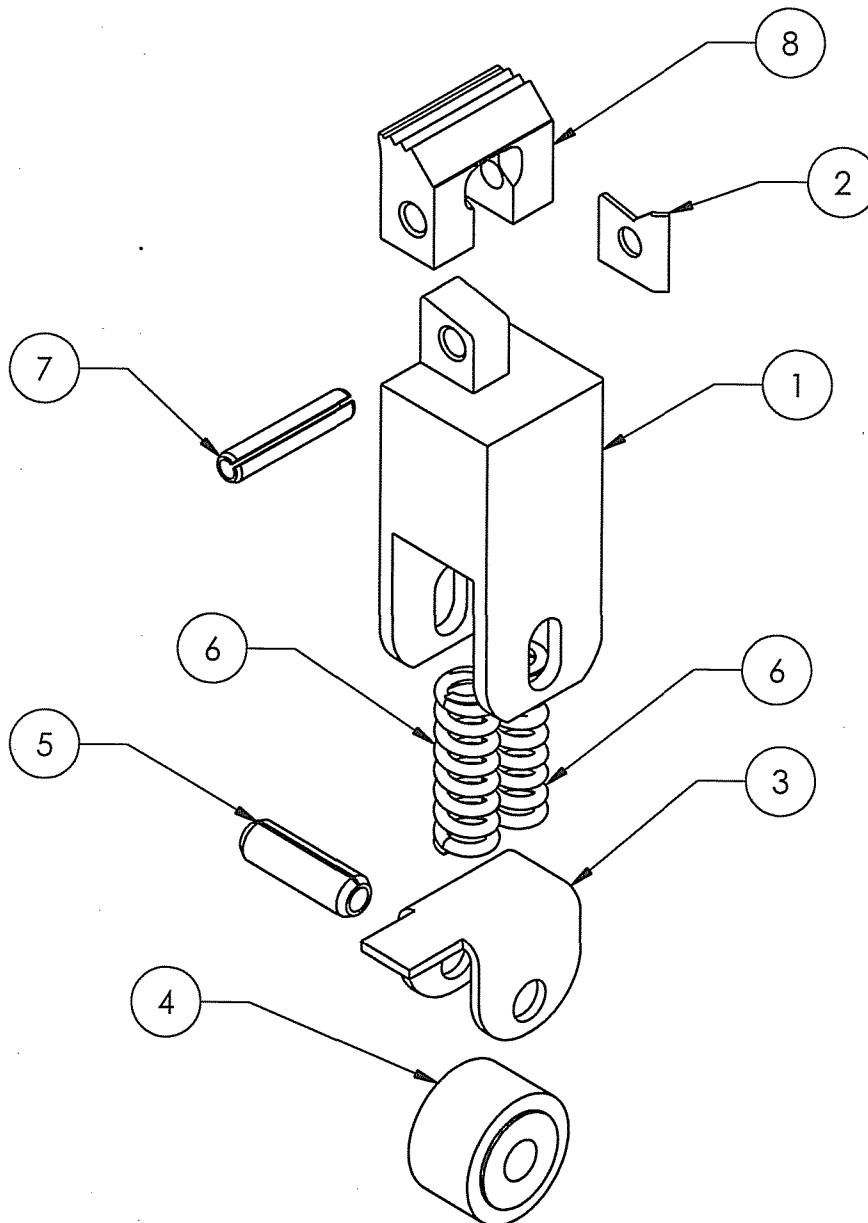


FIGURE B

KEY	QTY.	P/N	DESCRIPTION
1	1	514079	END GRIP BASE
2	1	514545	EDGE GUIDE
3	1	514620	SPRING SEAT
4	1	514639	CAM FOLLOWER
5	1	514692	ROLL PIN H.D. 6X20
6	2	434792	DIE SPRING LHL-375D-1
7	1	434255	Ø4 X 22 ROLL PIN
8	1	<u>514609</u>	<u>FULL WIDTH END-GRIP CUTTER</u>

Wearing parts are those items which are underlined.

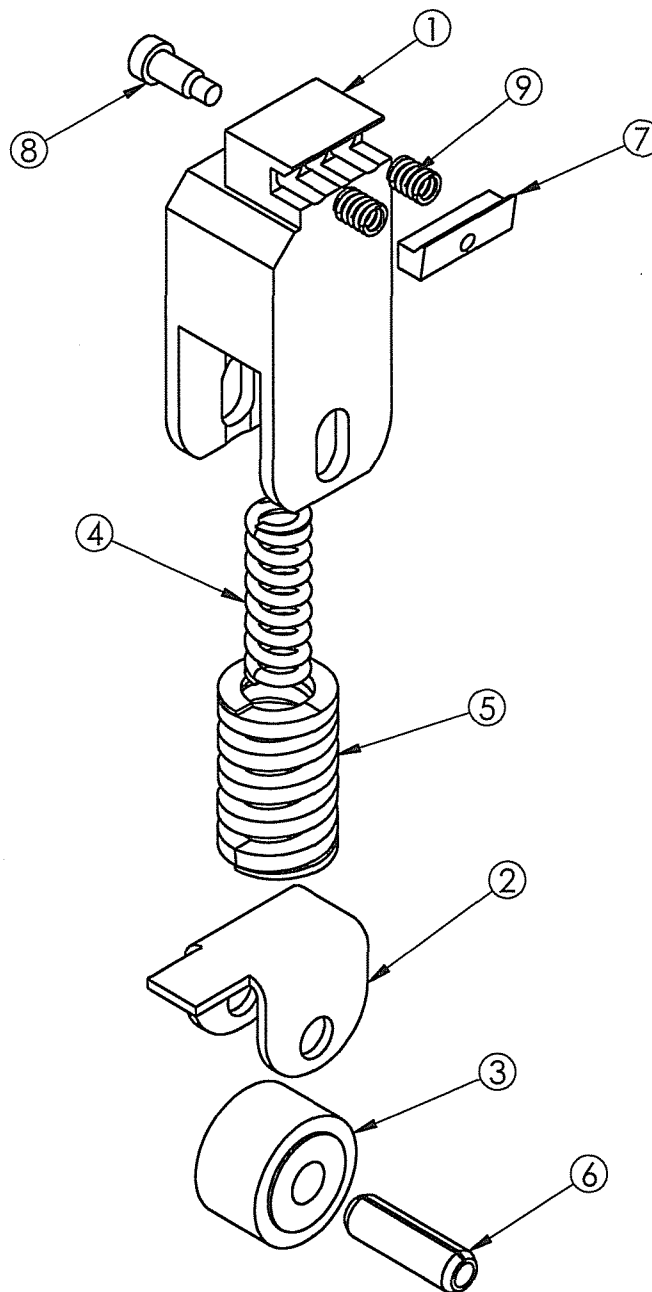


PLATEN ASSEMBLY

514702-2

KEY	QTY.	P/N	DESCRIPTION
1	1	514618	PLATEN
2	1	514620	SPRING SEAT
3	1	514639	CAM FOLLOWER
4	1	434792	DIE SPRING LHL-375D-1
5	1	439145	DIE SPRING, DANLY 9-1004-36
6	1	514692	ROLL PIN H.D. 6X20
<u>7</u>	<u>1</u>	<u>514635</u>	<u>CUTTER</u>
8	1	514636	CUTTER SCREW
9	2	514679	COMPRESSION SPRING

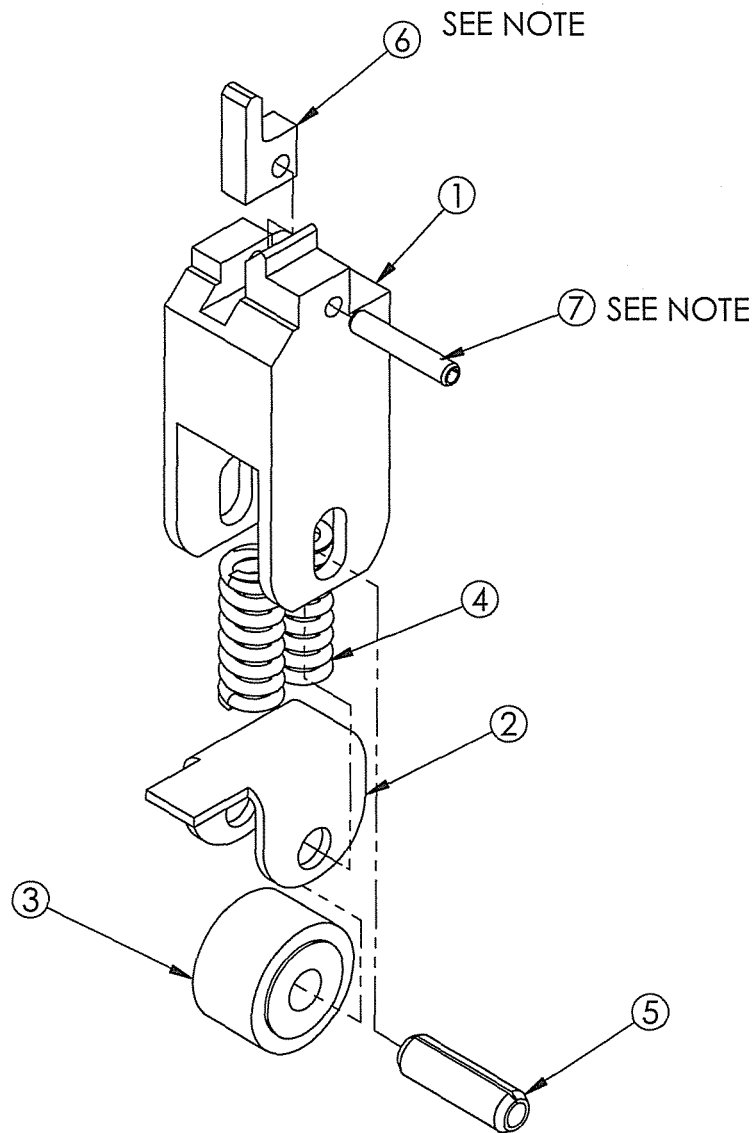
Wearing parts are those items which are underlined.



LOOP GRIP ASSEMBLY

514728-2

KEY	QTY.	P/N	DESCRIPTION
1	1	514737	S/A LOOP GRIP (108)
2	1	514620	SPRING SEAT
3	1	514639	CAM FOLLOWER
4	2	434792	DIE SPRING LHL-375D-1
5	1	514692	ROLL PIN H.D. 6X20
6	1	514738	L-G STRAP ALIGN FINGER
7	1	432311	Ø3 X 18 ROLL PIN

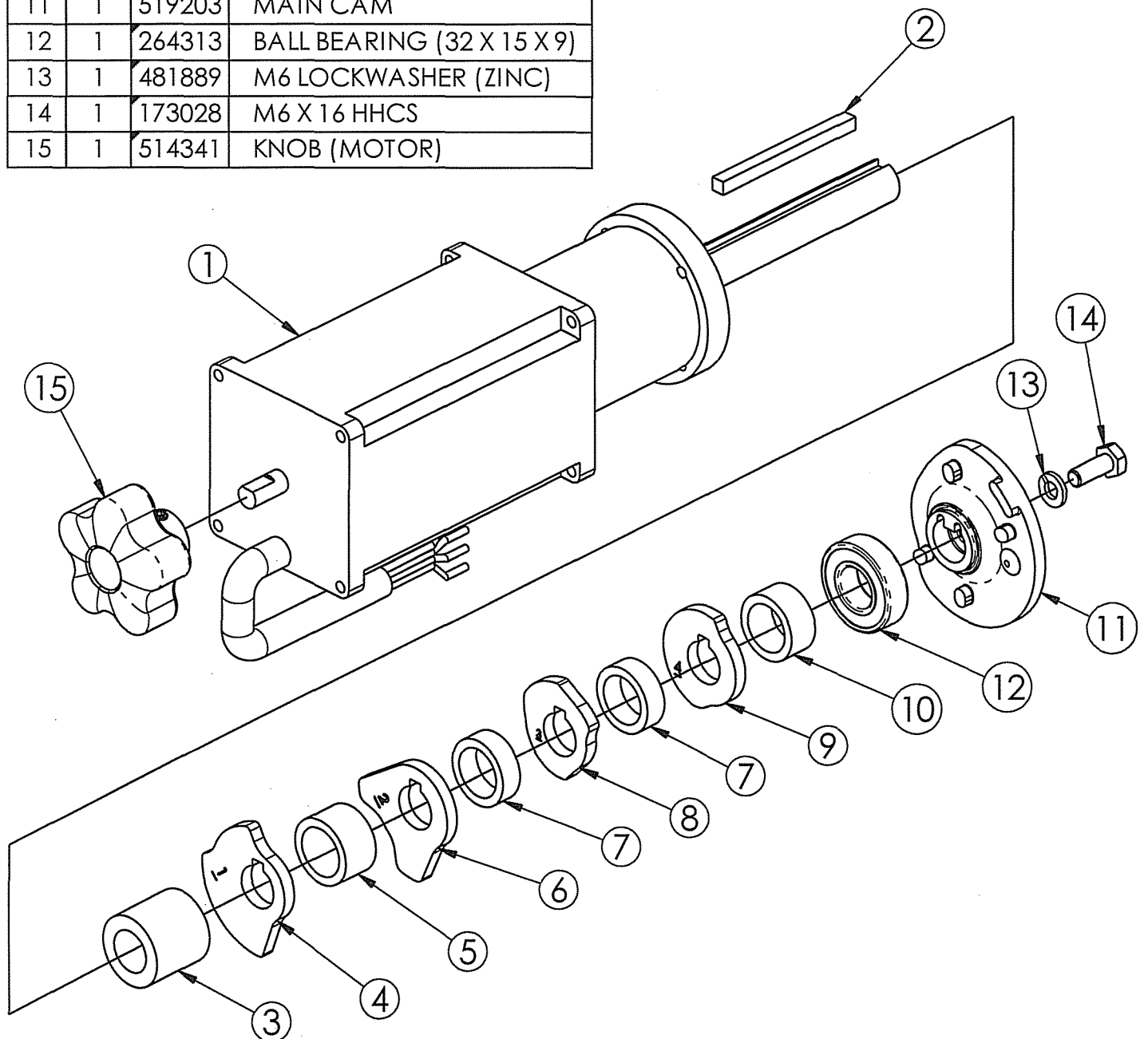


NOTE:
 REMOVE KEY 6 & 7 WHEN USED ON LBX6520
 CORRUGATED STRAPPING MACHINE

CAM SHAFT MOTOR ASSEMBLY

514062-4

KEY	QTY	P/N	DESCRIPTION
1	1	514611	MOTOR - CAMSHAFT
2	1	514677	5 X 5 X 62 KEY
3	1	514647	LEAD CAM SPACER
4	1	514731	CAM # 1 (LOOP GRIP)
5	1	514645	CAM SPACER (14.0)
6	1	514732	CAM # 2 (PLATEN)
7	2	514644	CAM SPACER (8.0)
8	1	680593	CAM # 3 (HOT KNIFE)
9	1	680594	CAM # 4 (END GRIP)
10	1	514646	END SPACER,CAM
11	1	519203	MAIN CAM
12	1	264313	BALL BEARING (32 X 15 X 9)
13	1	481889	M6 LOCKWASHER (ZINC)
14	1	173028	M6 X 16 HHCS
15	1	514341	KNOB (MOTOR)

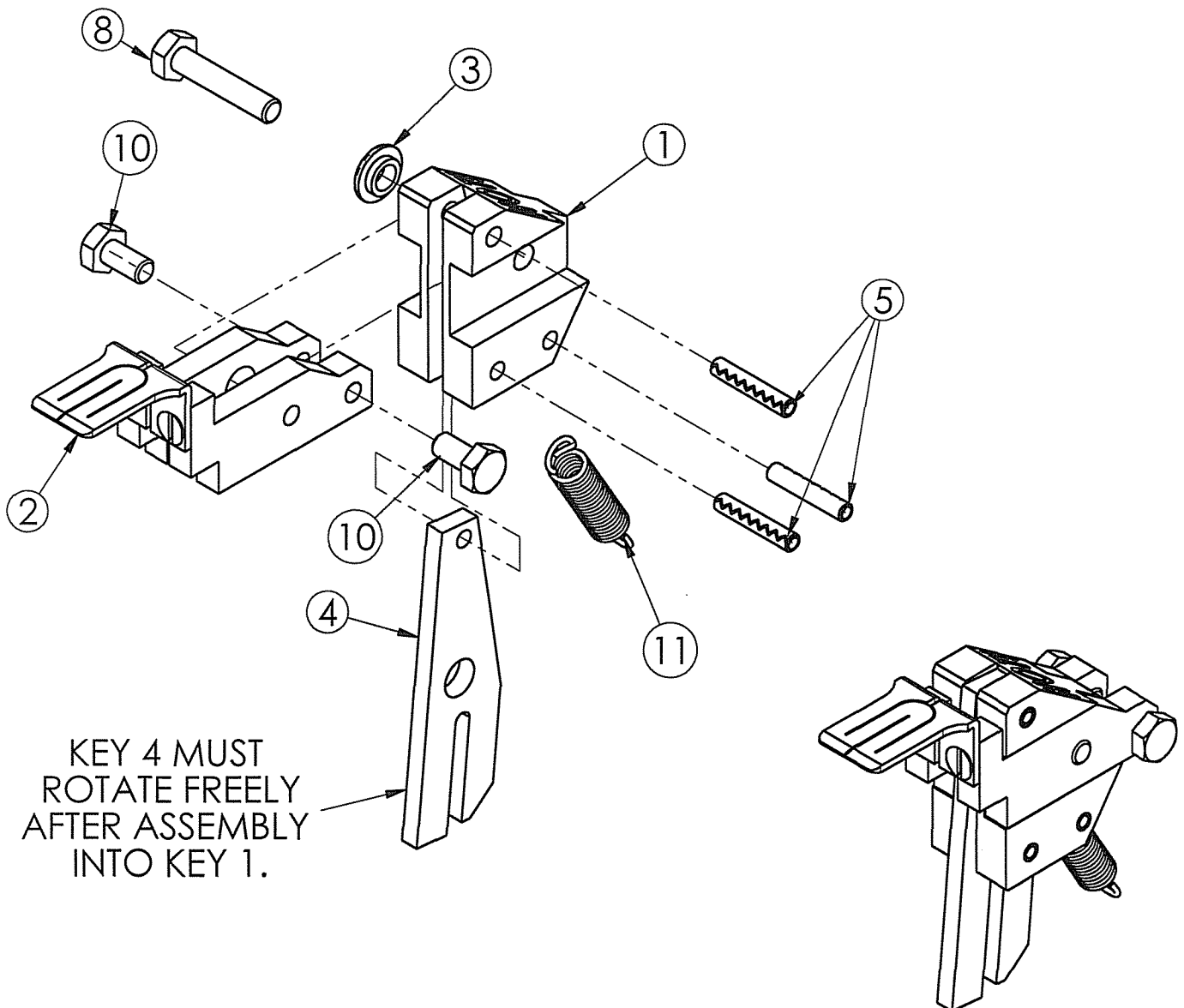


HOT KNIFE ASSEMBLY

514664-4

KEY	QTY.	P/N	DESCRIPTION
1	1	514654	TERMINAL BLOCK
2	1	514650	HOT KNIFE WELDMENT
<u>3</u>	<u>1</u>	<u>514655</u>	<u>PLASTIC SHOULDER WASHER</u>
4	1	514653	KNIFE FULCRUM
5	3	514718	3 X 16 HEAVY DUTY SPRING TENSION PIN
6	1	171570	M4 FLATWASHER (ZINC)
7	1	185700	M4 LOCKWASHER HC (ZINC)
8	1	514662	M4 X 20 HHCS (ZINC)
9	2	434665	M4 INT. LOCKWASHER (ZINC)
10	2	514663	M4 X 8 HHCS
11	1	514658	EXTENSION SPRING

Wearing parts are those items which are underlined.



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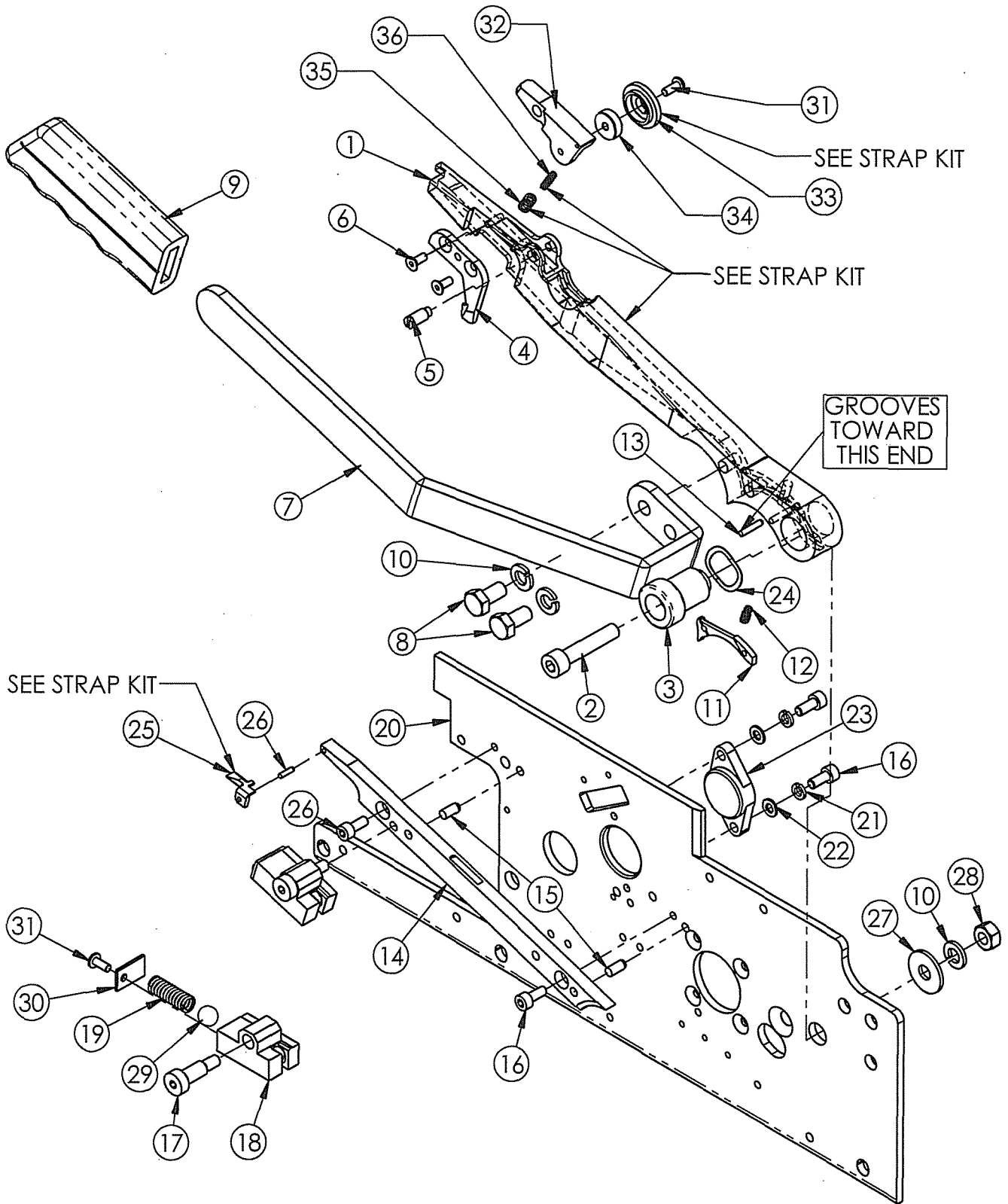
UPPER TRANSITION GUIDE ASSEMBLY

514063-12

KEY	QTY	P/N	DESCRIPTION
1	REF	SEE STRAP GUIDE KIT	TRACK COVER
2	1	172079	M8 X 40 SHCS (ZINC)
3	1	514700	TRACK COVER SLEEVE
4	1	514864	STRIKER DETENT
5	1	514783	BACK-UP ARM PIVOT PIN
6	2	278155	M4 X 10 SFHCS (ZINC)
7	1	514785	GUIDE OPENER HANDLE
8	2	162395	M8 X 16 SHCS
9	1	513175	VINYL GRIP (FITS 1" X 1/4" STK)
10	3	162381	M8 LOCKWASHER (ZINC)
11	1	514964	PICK-UP FINGER
12	1	434774	COMPRESSION SPRING
13	1	514225	3 X 16 HALF LENGTH TAPERED GROOVE PIN
14	1	514770	LOWER TRANSITION GUIDE
15	2	434778	5 X 10 GROOVED DOWEL PIN
16	4	010028	M5 X 12 SHCS (ZINC)
17	1	164956	8/M6 X 12 SHSS
18	1	514865	DETENT BLOCK
19	1	514868	COMPRESSION SPRING
20	REF	514796	MAIN MOUNTING PLATE
21	2	187415	M5 LOCK WASHER HC
22	2	171571	M5 FLAT WASHER
23	1	515284	ACR HEAD MOUNT PLATE PLUG
24	1	514717	3/4" WAVE WASHER
25	REF	SEE STRAP GUIDE KIT	CUTTER TONGUE
26	1	434136	DOWEL PIN 2.5 X 10
27	1	420322	M8 FENDER, DIN 9021 (ZINC)
28	1	164953	M8 HEXNUT (ZINC)
29	1	514867	DETENT BALL
30	1	514866	SPRING RETAINER
31	2	514694	M4 X 10 SPEC LOW HEAD SHCS
32	1	514897	STUB BACK-UP ARM
33	REF	SEE STRAP GUIDE KIT	FEED & TAKE-UP PINCH WHEEL
34	1	514693	BALL BEARING 16X4X5
35	REF	SEE STRAP GUIDE KIT	FEED & TAKE-UP OUTER SPRING
36	REF	SEE STRAP GUIDE KIT	FEED & TAKE-UP INNER SPRING

UPPER TRANSITION GUIDE ASSEMBLY

514063-12



LBX-2000 MACHINE OPTIONS

PALM BUTTON (8-1)

EXTENDED FRONT TABLE-TOP (8-2)

PHOTO-EYE, SEMI-AUTOMATIC

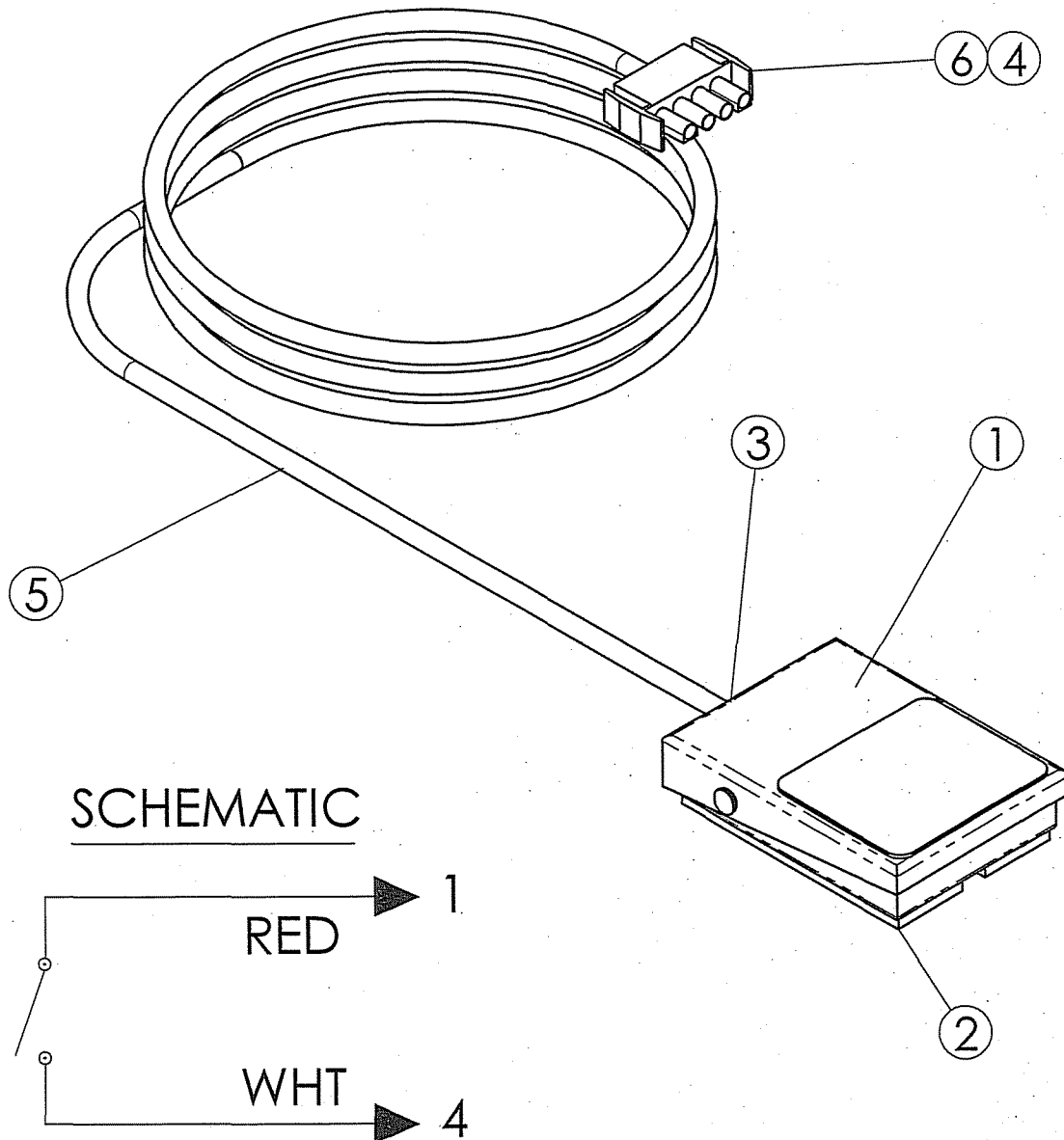
- **INSTALLATION (8-3)**
- **BILL OF MATERIAL & ASSEMBLY VIEW (8-4)**

HEIGHT ADJUSTMENT ASSEMBLY (8-7)

RECOMMENDED SPARE PARTS (8-9)

8-NOTICE

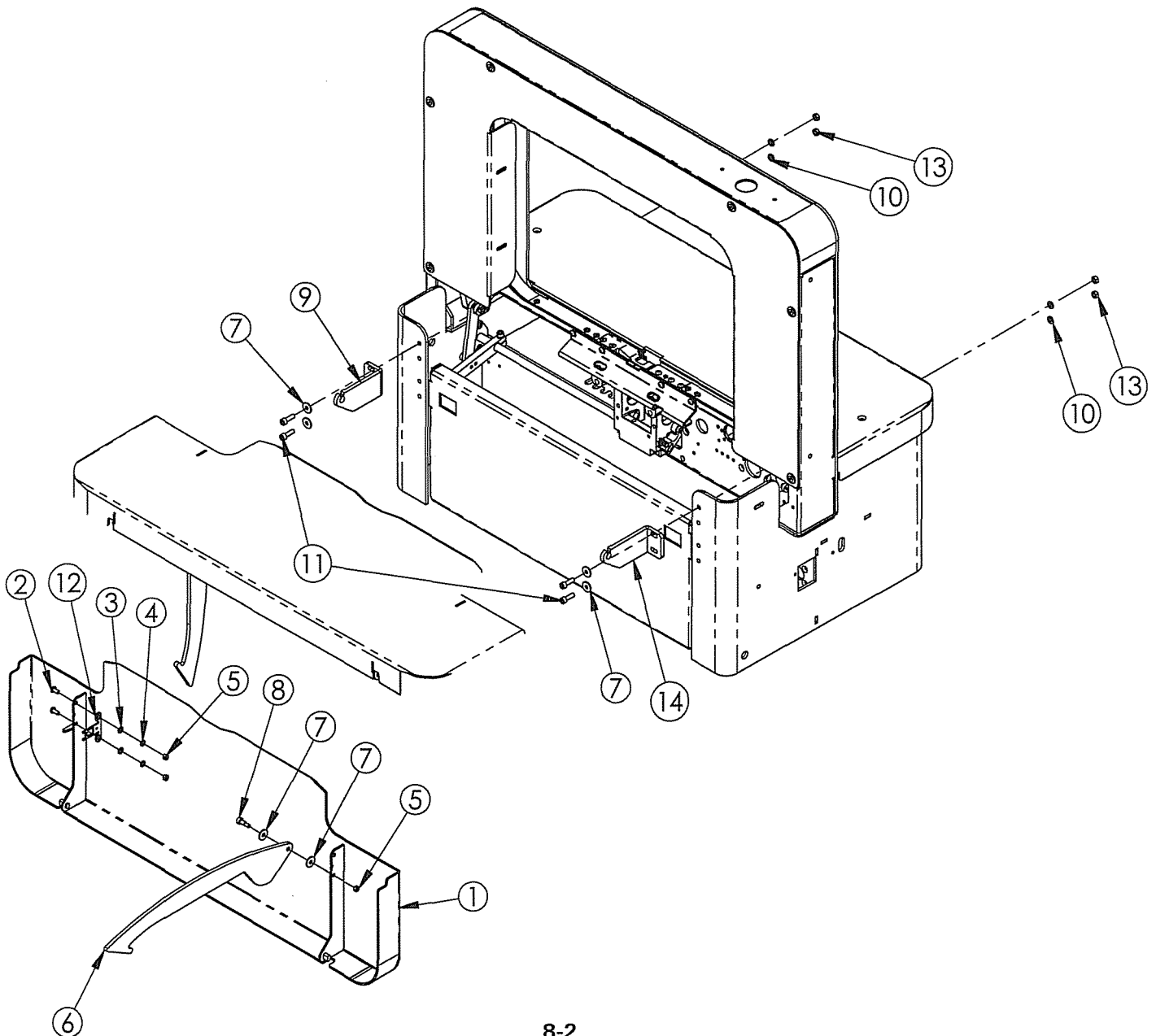
KEY	QTY	P/N	DESCRIPTION
1	1	434248	LINEMASTER SWITCH
2	A/R	434247	FLEXIBLE MAGNETIC STRIP
3	2	434246	18 GA. INSULATED FEMALE TERMINAL
4	2	292942	AMP PIN
5	1	434577	CABLE
6	1	436218	CONNECTOR PLUG



EXTENDED FRONT TABLE TOP OPTION

514847-4

KEY	DESCRIPTION	514848		514849	
		20" X 15" CHUTE		28" X 15" CHUTE	
		P/N	QTY	P/N	QTY
1	EXTENDED FRONT TABLE TOP	514850	1	514852	1
2	M5 X 12 SBHCS (ZINC)	175914	2	175914	2
3	M5 FLATWASHER	280868	2	280868	2
4	M5 LOCKWASHER (ZINC)	10076	2	10076	2
5	M5 HEX NUT (ZINC)	169440	3	169440	3
6	EXTENDED TABLE TOP CHUTE OPENER	514892	1	514892	1
7	M6 FENDER WASHER	421876	6	421876	6
8	Ø6/M5 X 10 SHSS	171044	1	171044	1
9	LEFT EXTENDED TABLE TOP PIVOT	514890	2	514890	2
10	M6 LOCKWASHER (ZINC)	481889	4	481889	4
11	M6 X 20 SHCS (ZINC)	174156	4	174156	4
12	INTERLOCK SWITCH ACTUATOR	438752	1	438752	1
13	M6 HEXNUT (ZINC)	5465	4	5465	4
14	RIGHT EXTENDED TABLE TOP PIVOT	514891	1	514891	1



INSTALLING THE OPTION:

1. DISCONNECT AND LOCKOUT ELECTRICAL POWER FROM MACHINE. REMOVE ALL PACKAGES FROM THE MACHINE.
2. UNPACK THE PHOTO-EYE ASSEMBLY AND INSPECT ALL PARTS FOR ANY POSSIBLE TRANSIT DAMAGE.
3. INSTALL MOUNTING BRACKET (KEY 3) TO THE MACHINE'S LEFT SIDE USING HARDWARE SHOWN (KEYS 4,5). INSTALL PHOTO-EYE ENCLOSURE TO BRACKET USING HARDWARE SHOWN (KEYS 4,5).
4. CONNECT THE PHOTO-EYE'S "F" CONNECTOR (KEY 16/22) INTO SOCKET MARKED "F" FOUND ON THE WIRE HARNESS BEHIND THE COVER PLATE (514331) ON THE MAIN CHANNEL.

OPERATING THIS OPTION:

THE CONTROL SWITCH ON TOP OF THE PHOTO-EYE ENCLOSURE HAS THREE (3) POSITIONS FOR OPERATING YOUR MACHINE. THE SWITCH CAN BE CHANGED AT ANY TIME WHILE OPERATING THE MACHINE.

FIRST POSITION (SINGLE STRAP MODE)

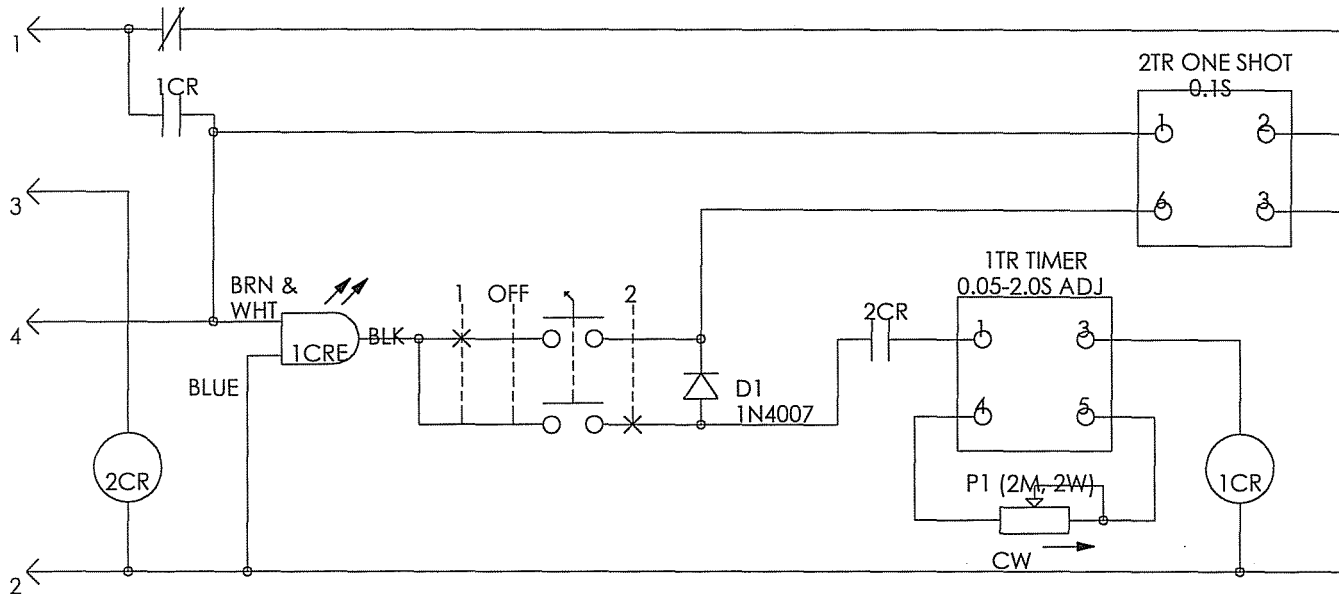
THIS POSITION, WHEN SELECTED, WILL PLACE ONLY ONE STRAP ON A PACKAGE FOR EVERY TIME THE PHOTO-EYE BEAM IS TRIGGERED. *NOTE: THE POTENTIOMETER HAS NO EFFECT, CYCLE STARTS AS SOON AS THE PHOTOEYE BEAM IS TRIGGERED.*

SECOND (MIDDLE) POSITION (OFF)

THIS POSITION, WHEN SELECTED, WILL DISABLE THE PHOTO-EYE ALLOWING THE MACHINE TO BE OPERATED WITH THE FOOT PEDAL.

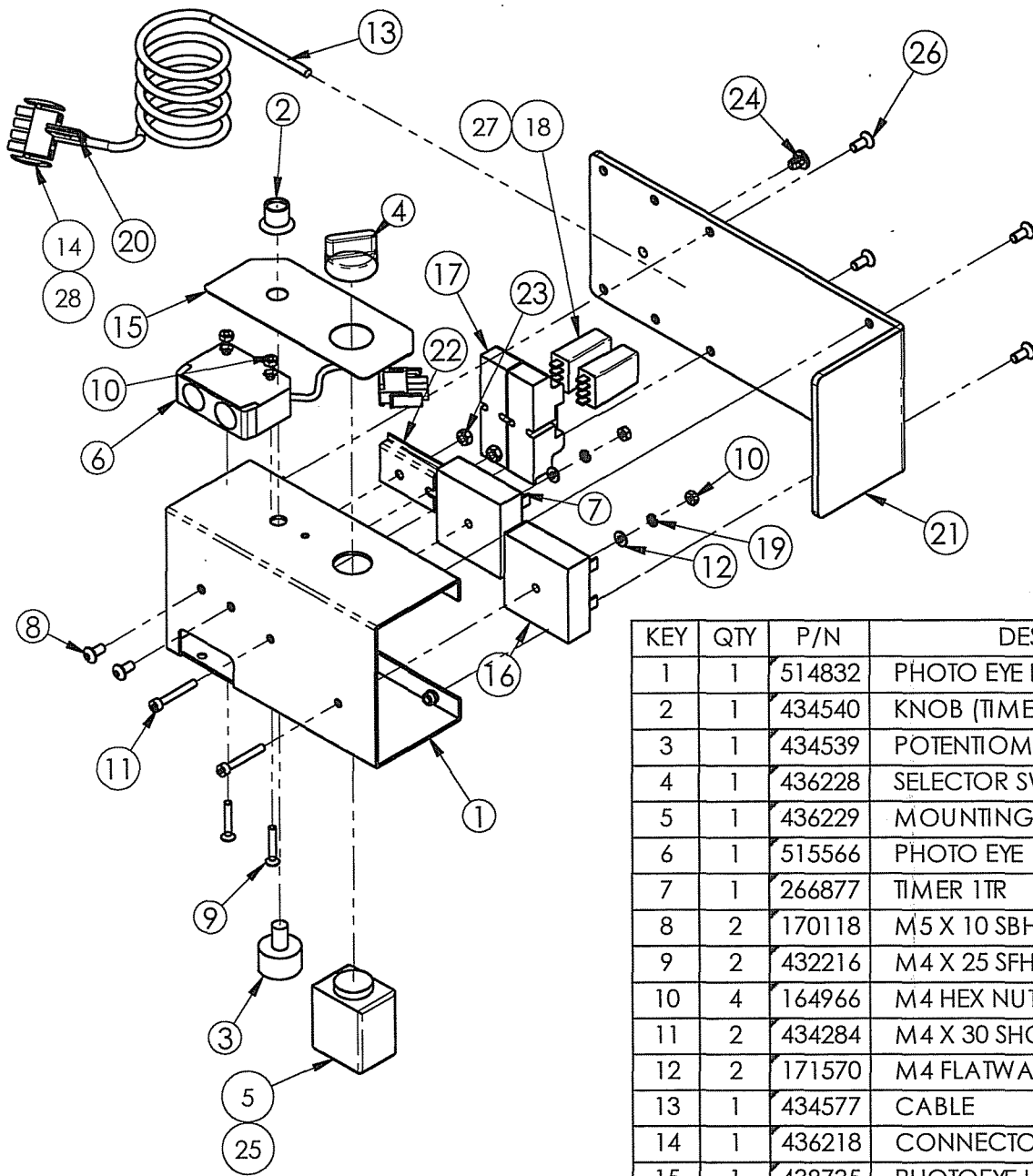
THIRD POSITION (MULTIPLE STRAP MODE)

THIS POSITION, WHEN SELECTED, WILL CONTINUOUSLY PLACE STRAPPING ON A PACKAGE FOR AS LONG AS THE PHOTO-EYE BEAM IS TRIGGERED. *NOTE: THE 1ST CYCLE STARTS AS SOON AS THE PHOTOEYE BEAM IS TRIGGERED. THE POTENTIOMETER ADJUSTS THE TIME BETWEEN SUBSEQUENT STRAPS.*

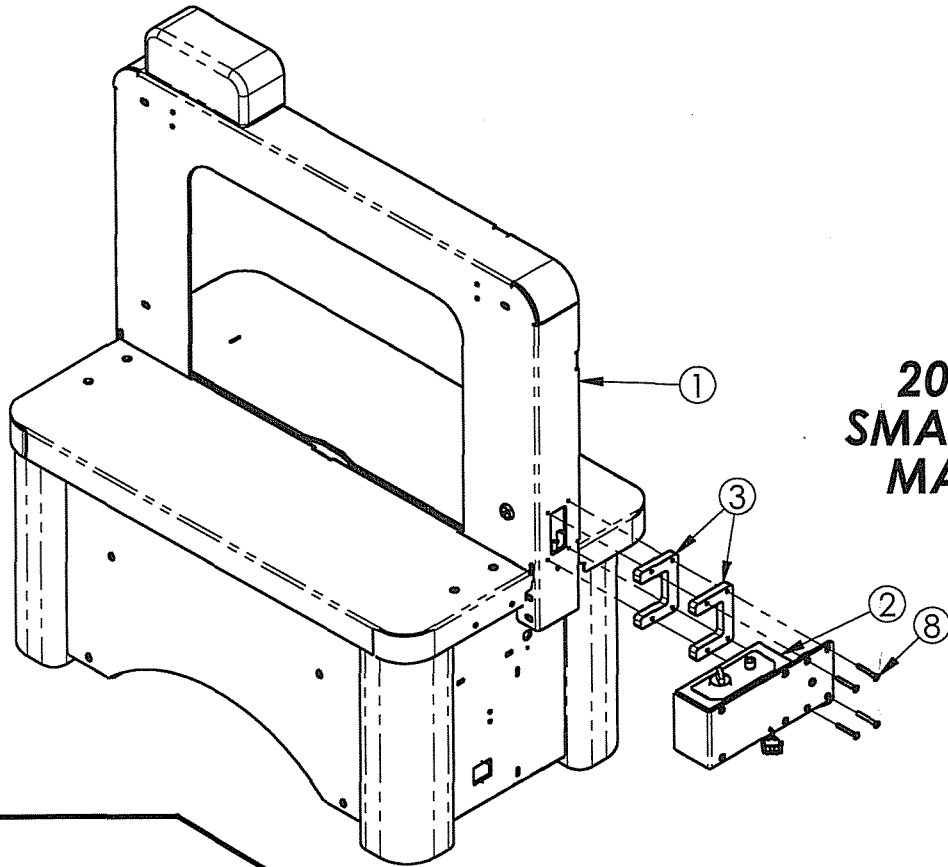


SEMI-AUTO PHOTO-EYE BOX ASSEMBLY

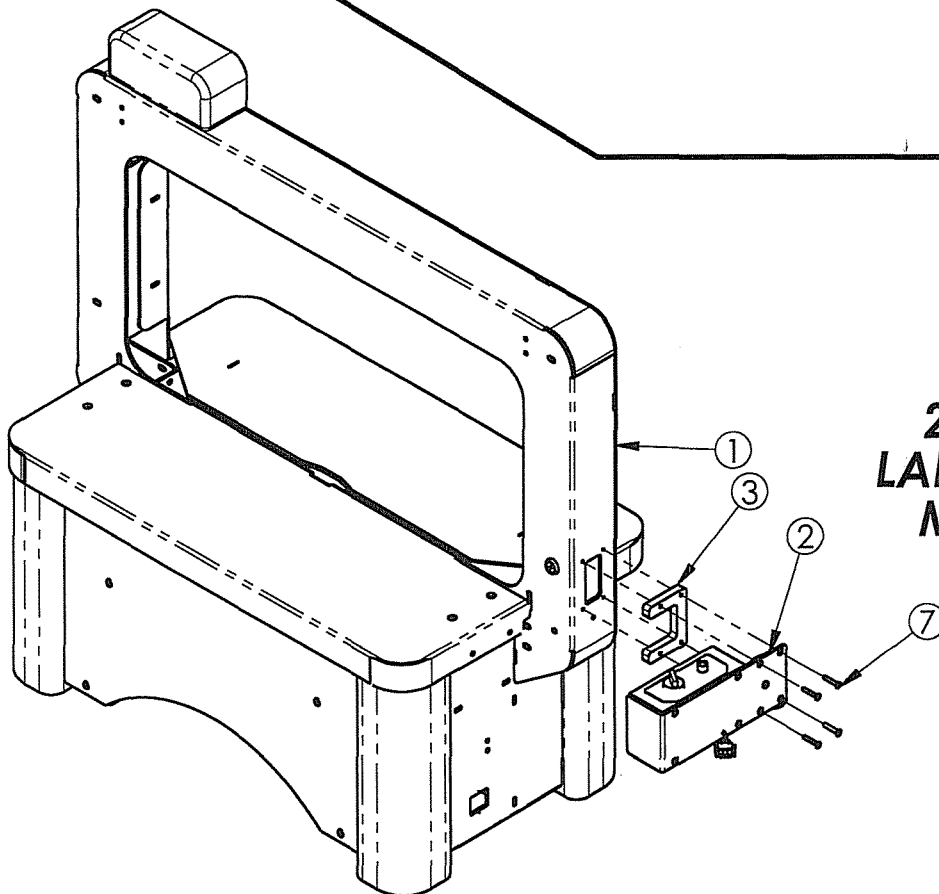
514836-6



KEY	QTY	P/N	DESCRIPTION
1	1	514832	PHOTO EYE PLATE ASSEMBLY
2	1	434540	KNOB (TIMERS)
3	1	434539	POTENTIOMETER (TIMERS)
4	1	436228	SELECTOR SWITCH (3 POS)
5	1	436229	MOUNTING BASE
6	1	515566	PHOTO EYE
7	1	266877	TIMER 1TR
8	2	170118	M5 X 10 SBHCS (ZINC)
9	2	432216	M4 X 25 SFHCS
10	4	164966	M4 HEX NUT (ZINC)
11	2	434284	M4 X 30 SHCS
12	2	171570	M4 FLATWASHER (ZINC)
13	1	434577	CABLE
14	1	436218	CONNECTOR PLUG
15	1	438735	PHOTOEYE LABEL
16	1	434598	TIMER 2TR
17	2	272487	SOCKET
18	2	272486	24 V RELAY
19	2	185700	M4 LOCKWASHER HC (ZINC)
20	1	434389	CABLE ID TAG "F"
21	1	514833	PHOTO EYE ENCLOSURE
22	1	514830	HORIZONTAL DIN RAIL
23	2	169440	M5 HEX NUT (ZINC)
24	1	434498	CABLE PUSH MOUNT
25	2	436231	CONTACT BLOCK
26	4	437290	M5 X 12 SFHCS (ZINC)
27	2	514838	HOLD DOWN CLIP (SY2S-02F1)
28	2	292942	PIN

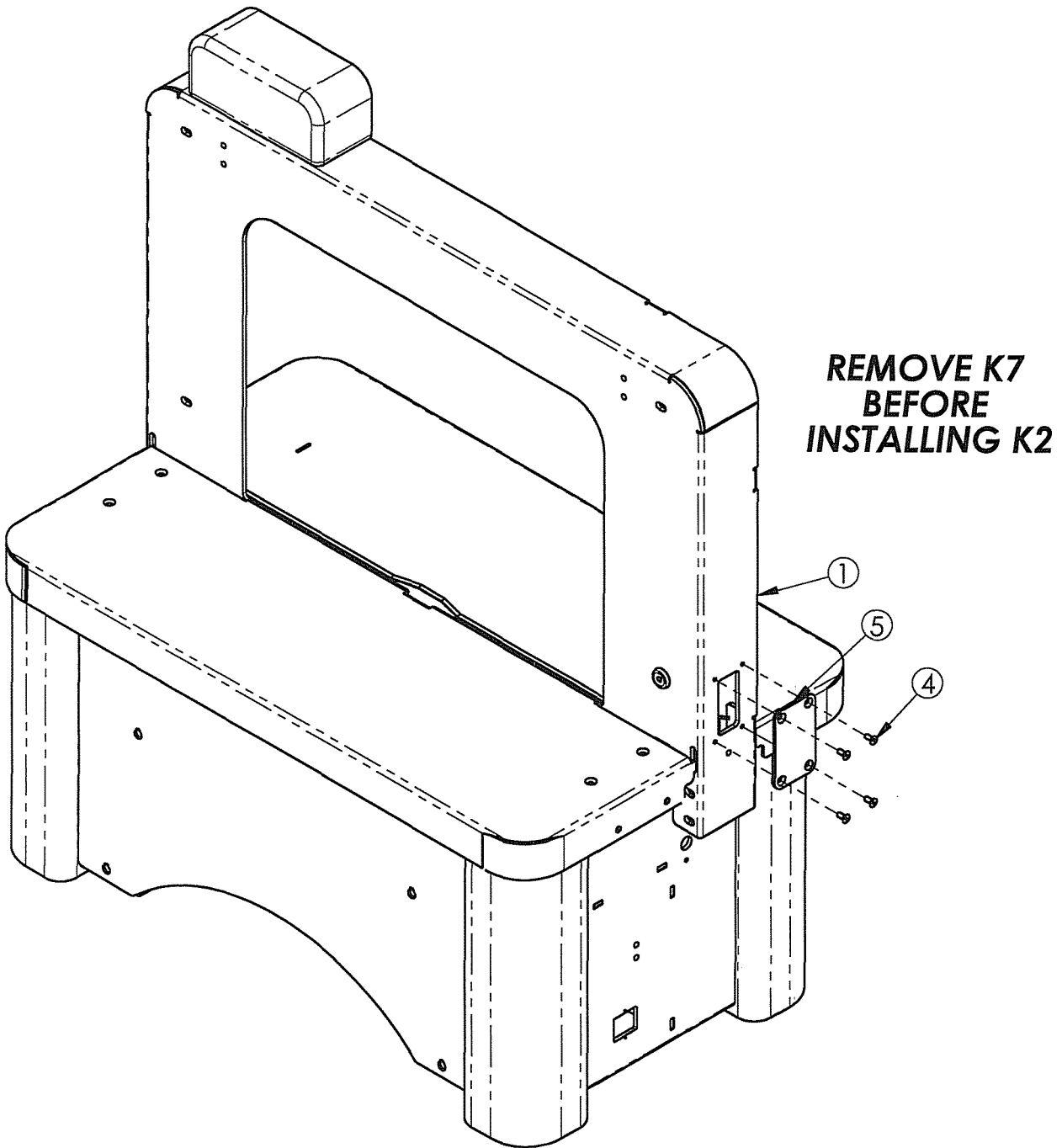


**20" X 15"
SMALL CHUTE
MACHINE**



**28" X 15"
LARGE CHUTE
MACHINE**

KEY	QTY	P/N	DESCRIPTION
1	REF	NA	LBX-2000 WALK-UP MACHINE
2	REF	514836	SEMI-AUTO PHOTO-EYE BOX ASSEMBLY
3	2	514834	PHOTO EYE SPACER PLATE
4	4	437290	M5 X 12 SFHCS (ZINC)
5	REF	514835	PHOTO-EYE HOLE COVER PLATE
6	1	514825	SEMI-AUTO PHOTO-EYE BOX INSTRUCTION SHEETS
7	4	514837	M5 X 30 SFHCS (ZINC)
8	4	514839	M5 X 40 SFHCS (DACROMET)



HEIGHT ADJUSTMENT ASSEMBLY

514809-4

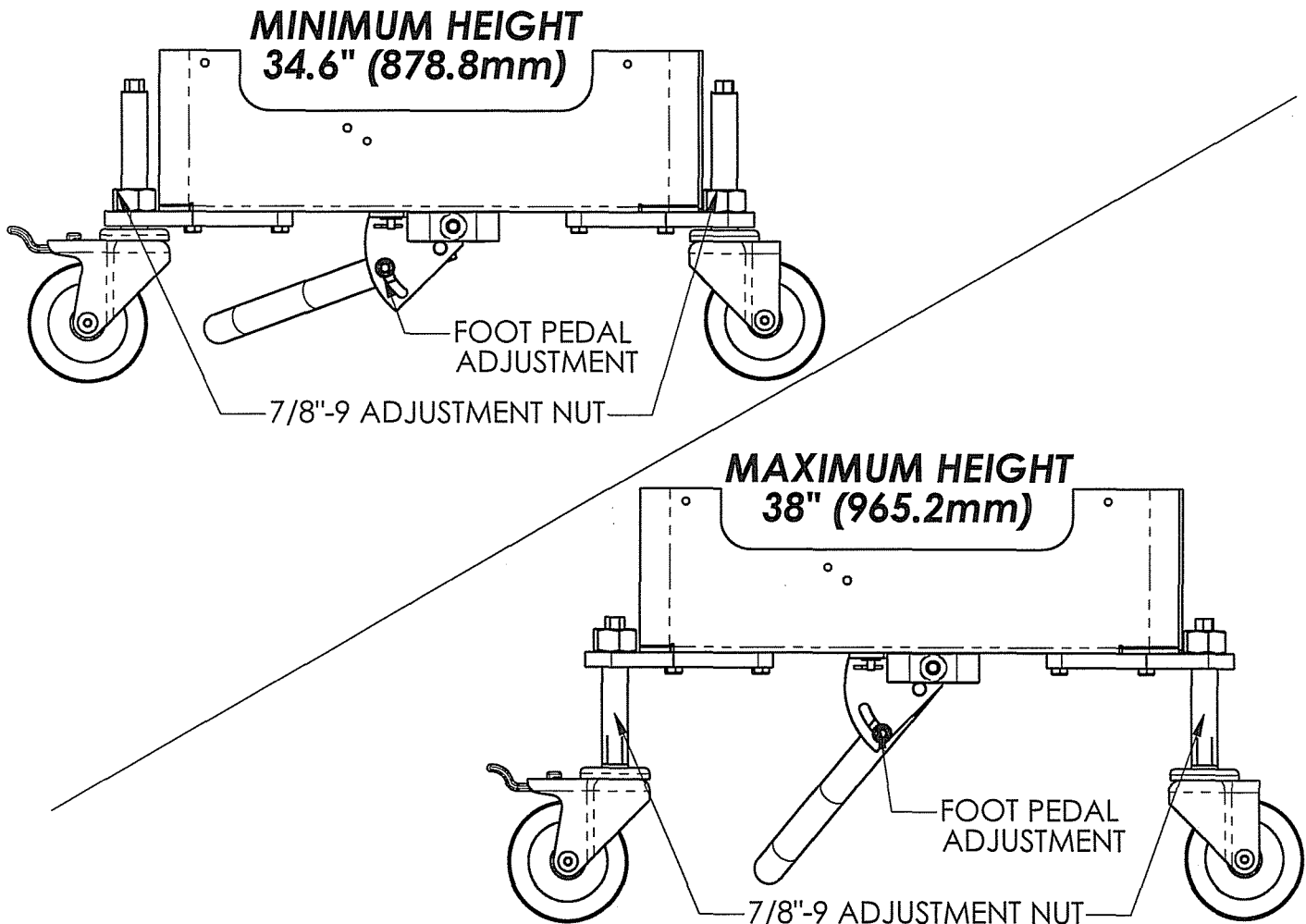
TO ADJUST HEIGHT OF LBX-2000 MACHINE:

1. LOOSEN KEY 2 (514808). ONE IN EACH CORNER OF THE FRAME.
2. WITH A 15mm (9/16") WRENCH ADJUST THE HEIGHT OF EACH CORNER BY TURNING KEY 9 CLOCKWISE OR COUNTER-CLOCKWISE.
3. TIGHTEN KEY 2 TO LOCK KEY 8 IN PLACE.

TO ADJUST FOOT PEDAL HEIGHT:

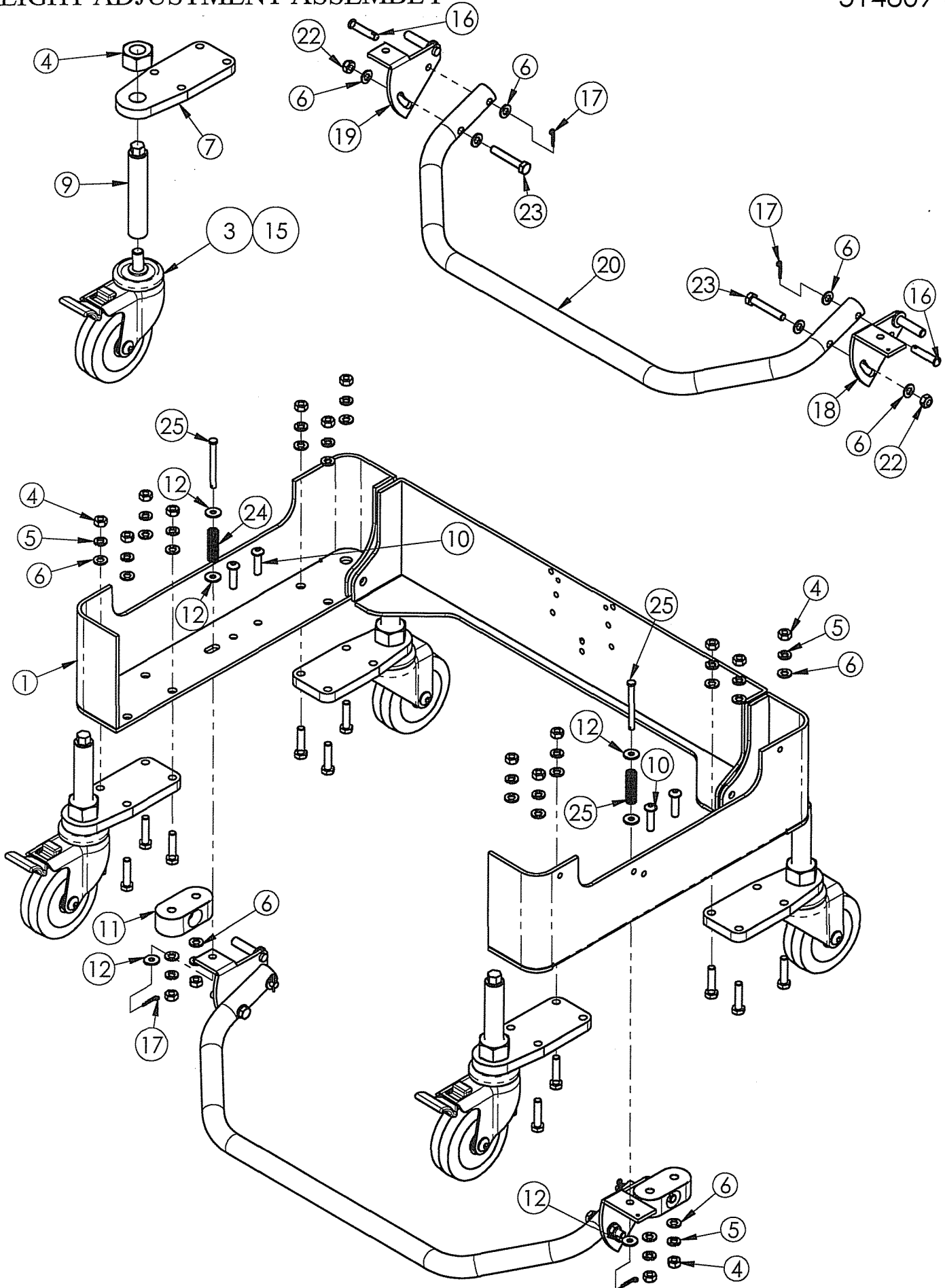
1. LOOSEN KEYS 6, 17, 21, 22 ON BOTH SIDES OF FOOT PEDAL ASSEMBLY KEY 24.
2. SLIDE FOOT PEDAL UP OR DOWN TO DESIRED HEIGHT. RECOMMENDED HEIGHT IS AT LEAST 15mm FROM GROUND. LOWER ADJUSTMENTS WILL INHIBIT MACHINE OPERATION.
3. TIGHTEN LOOSE HARDWARE.

KEY	QTY	P/N	DESCRIPTION
1	REF	514200	FRAME WELDMENT
2	4	514808	7/8-9 HEX NUT (ZINC)
3	2	515456	4" SWIVEL-TOTAL LOCK-STEM-CASTER
4	17	164953	M8 HEX NUT (ZINC)
5	17	162381	M8 LOCKWASHER (ZINC)
6	19	251266	M8 FLATWASHER (ZINC)
7	4	514819	HEIGHT ADJUSTMENT OUTRIGGER
8	13	278037	M8 X 35 HHCS (ZINC)
9	4	514810	HEIGHT ADJUSTMENT SHAFT
10	REF	438635	M8 X 30 SBHCS
11	REF	514215	FOOT PEDAL PIVOT BLOCK
12	REF	421876	M6 FENDERWASHER
13			
14			
15	2	515457	4" SWIVEL-W/O LOCK-STEM CASTER
16	2	514815	SS CLEVIS PIN
17	4	514245	3/32 X 3/4 HAMMERLOCK COTTER PIN
18	1	514816	RIGHT PIVOT WELDMENT
19	1	514817	LEFT PIVOT WELDMENT
20	1	514818	FOOT PEDAL
21			
22	2	433068	M8 HEX LOCKNUT
23	2	437286	M8 X 50 HHCS
24	REF	514221	FOOT PEDAL C-SPRING (LC-045H-8)
25	REF	514787	1/4" X 2.5" LONG SS CLEVIS PIN



HEIGHT ADJUSTMENT ASSEMBLY

514809-4



LBX-2000/2300 SPARE PARTS KIT

KEY	QTY.	P/N	DESCRIPTION
1	2	264313	15 x 32 x 9 BALL BEARING
2	4	274924	6 x 19 x 6 BEARING
3	2	514639	CAM FOLLOWER
4	2	434792	DIE SPRING LHL-375D-1
5	2	516770	FUSE - 2.0 A SLO BLO
6	2	434425	FUSE 3.0A FAST ACT (BUSSMANN GMA-3A)
7	1	438752	SWITCH ACTUATOR
8	2	514747	PROXIMITY SENSOR
9	1	514635	CUTTER
10	3	514674	COMPRESSION SPRING
11	1	514684	DU BUSHING
12	1	514807	5/16" OD X 1/4" ID X 1/2" LG BRONZE BUSHING
13	1	434657	EXTENSION SPRING
14	2	514679	COMPRESSION SPRING
15	2	514394	FUSE - 12.5A SLO BLO
16	1	514667	FLANGE BUSHING
17	1	514650	HOT KNIFE WELDMENT
18	2	516771	HOT KNIFE CABLE
19	1	514658	EXTENSION SPRING
20	1	514337	SSR
22	1	436243	INTERLOCK SWTICH
23	1	434655	BALL BEARING 6000-2RS
24	1	514693	BALL BEARING 634-ZZ
25	2	514393	FUSE - OUTPUT MODULE
26	2	519279	CHUTE SPRING, LARGE
27	2	519280	CHUTE SPRING, SMALL
28	2	519388	FUSE, 16 A SLO BLO