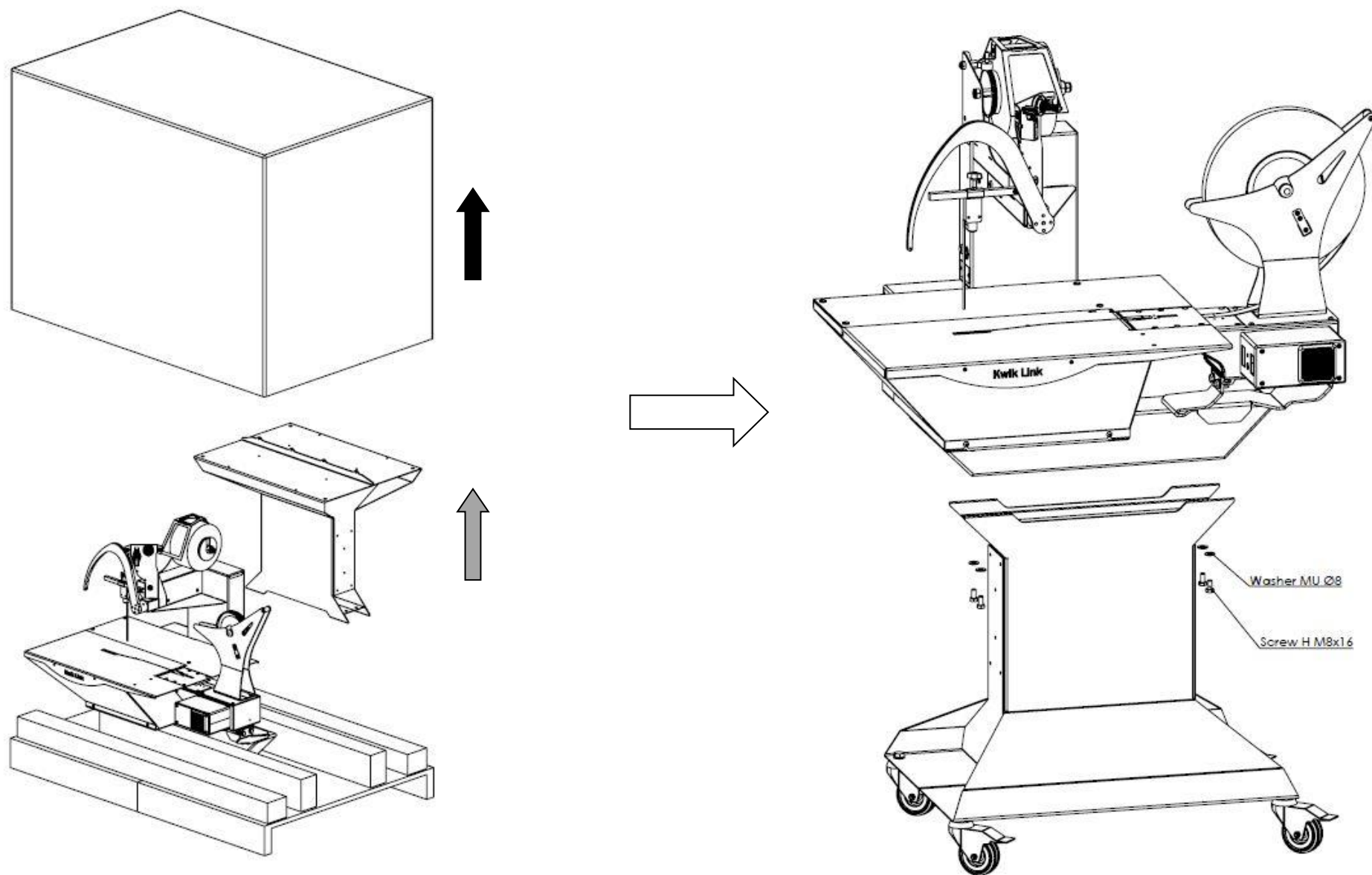


CONTENTS

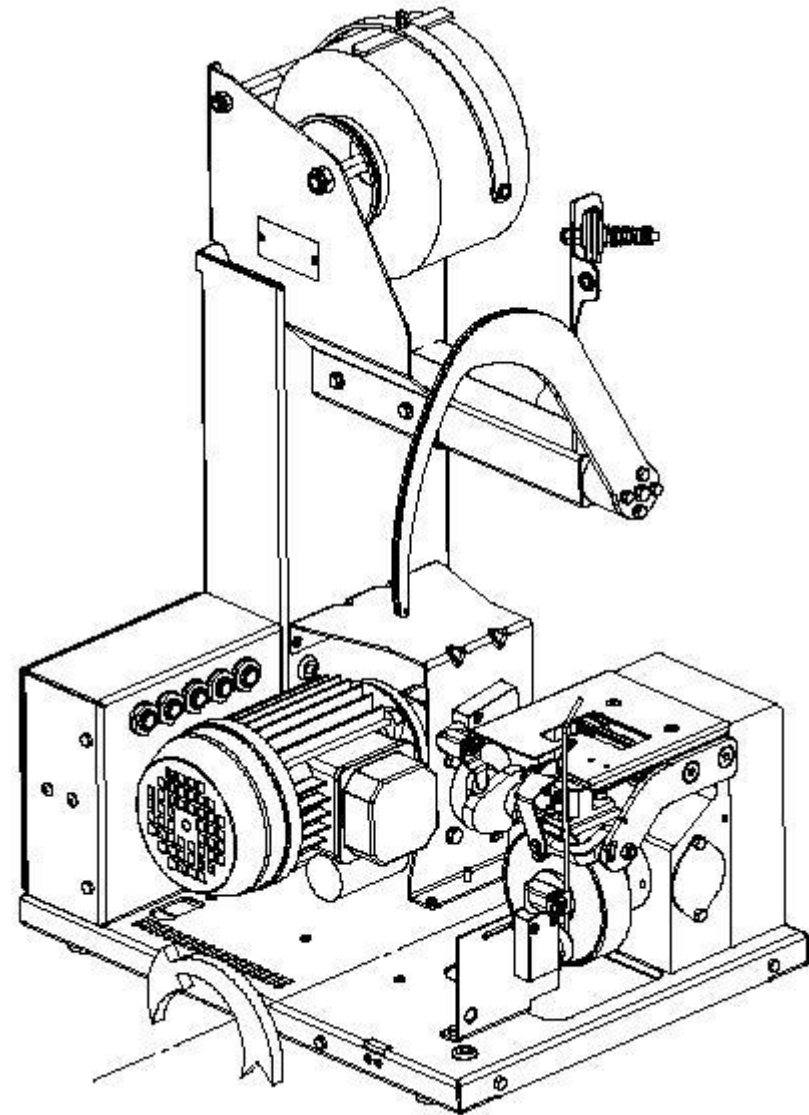
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UNPACKING & STAND ASSEMBLY



PLUGGING THE MACHINE

- The machine is designed to be connected to a standard wall socket (grounded).
- The cables are insulated for up to 500 V.
- Plug the machine in after making sure that the voltage of the machine corresponds to the supply voltage.



1 - "ON/OFF" button

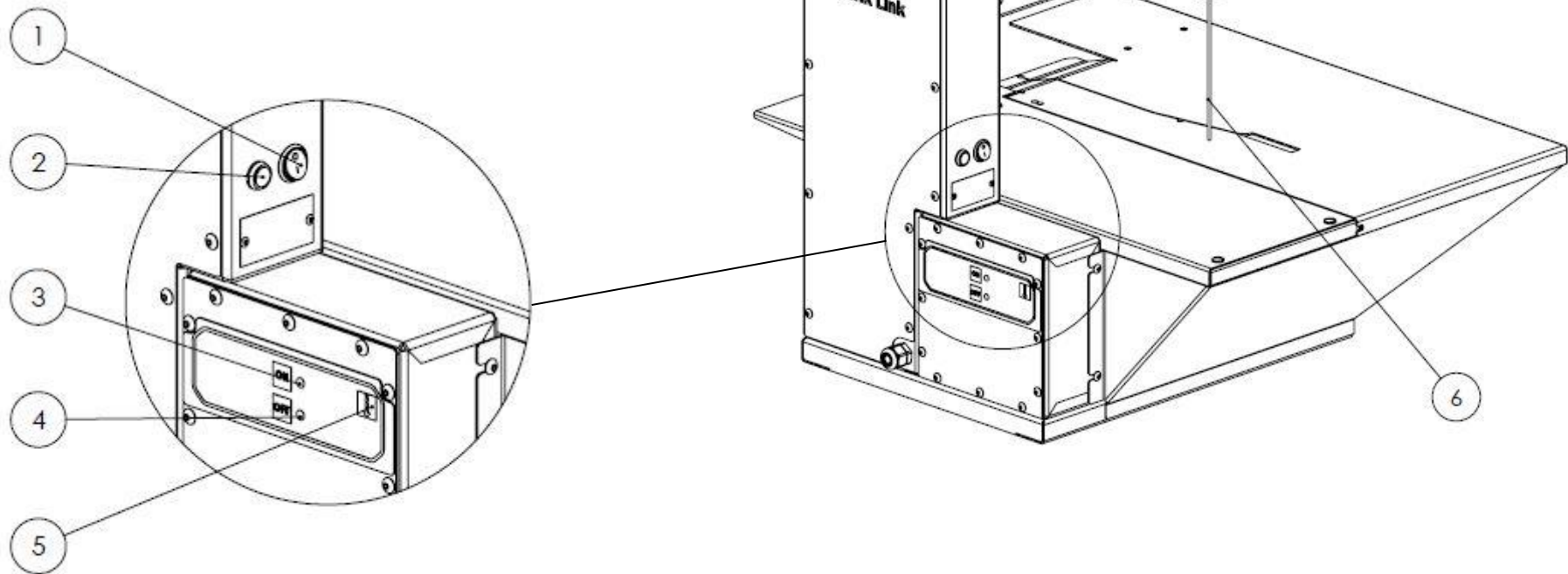
2 - Cycle button "green"

3 - Light "ON"

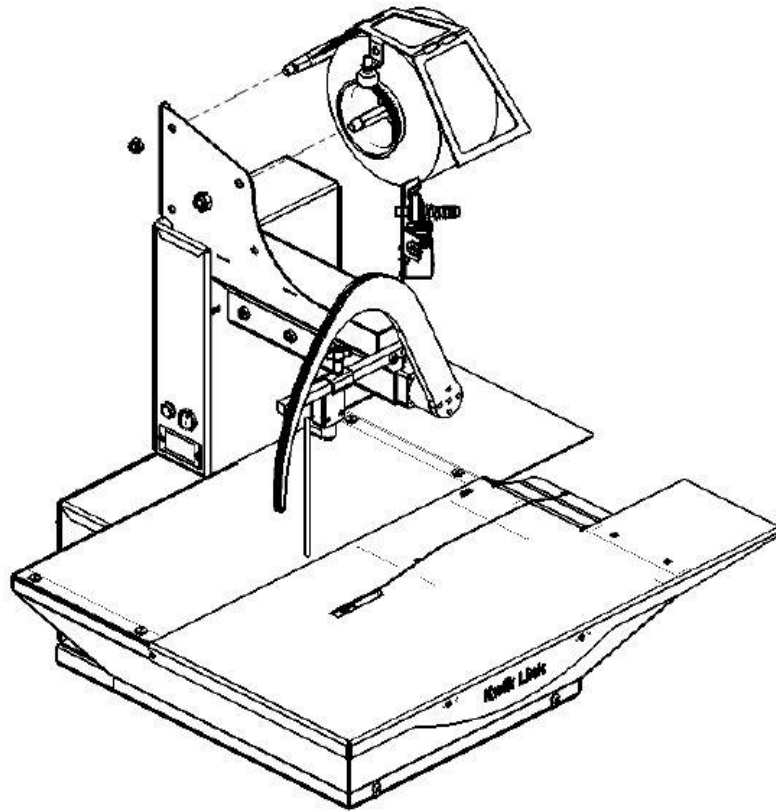
4 - Light "OFF"

5 - Step by step

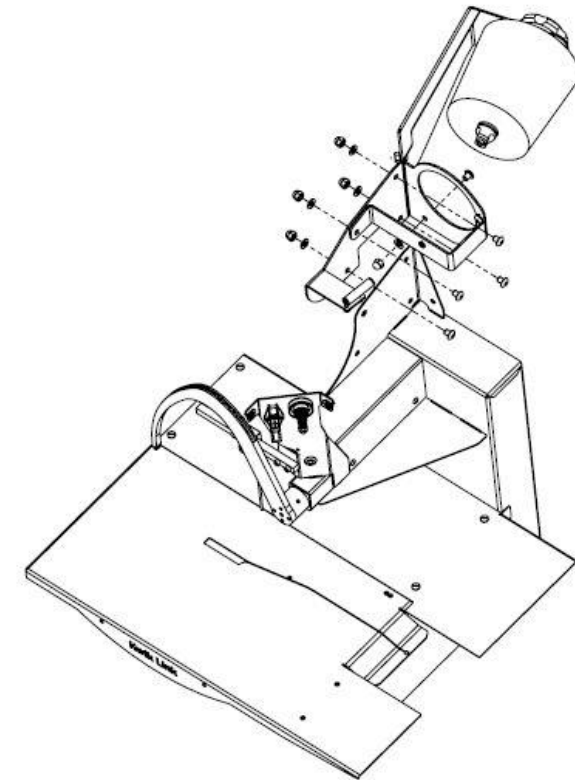
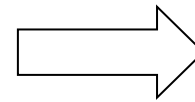
6 - Automatic release (following version)



MOUNTING OF THE KNITTED TWINE SPOOL SUPPORT



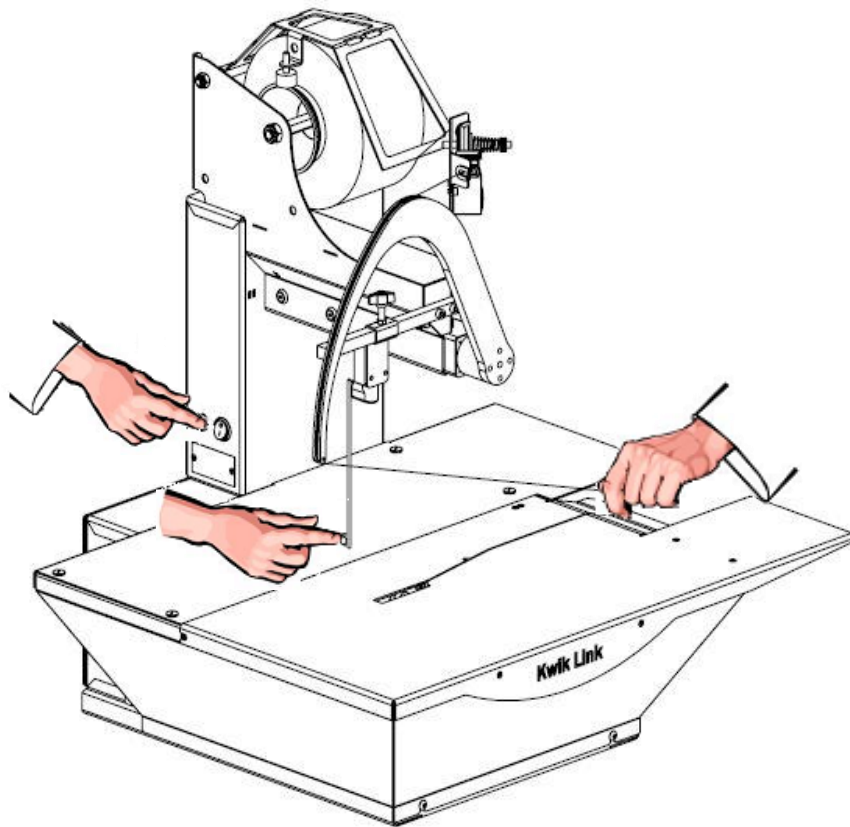
Step 1: remove the single elastic spool support



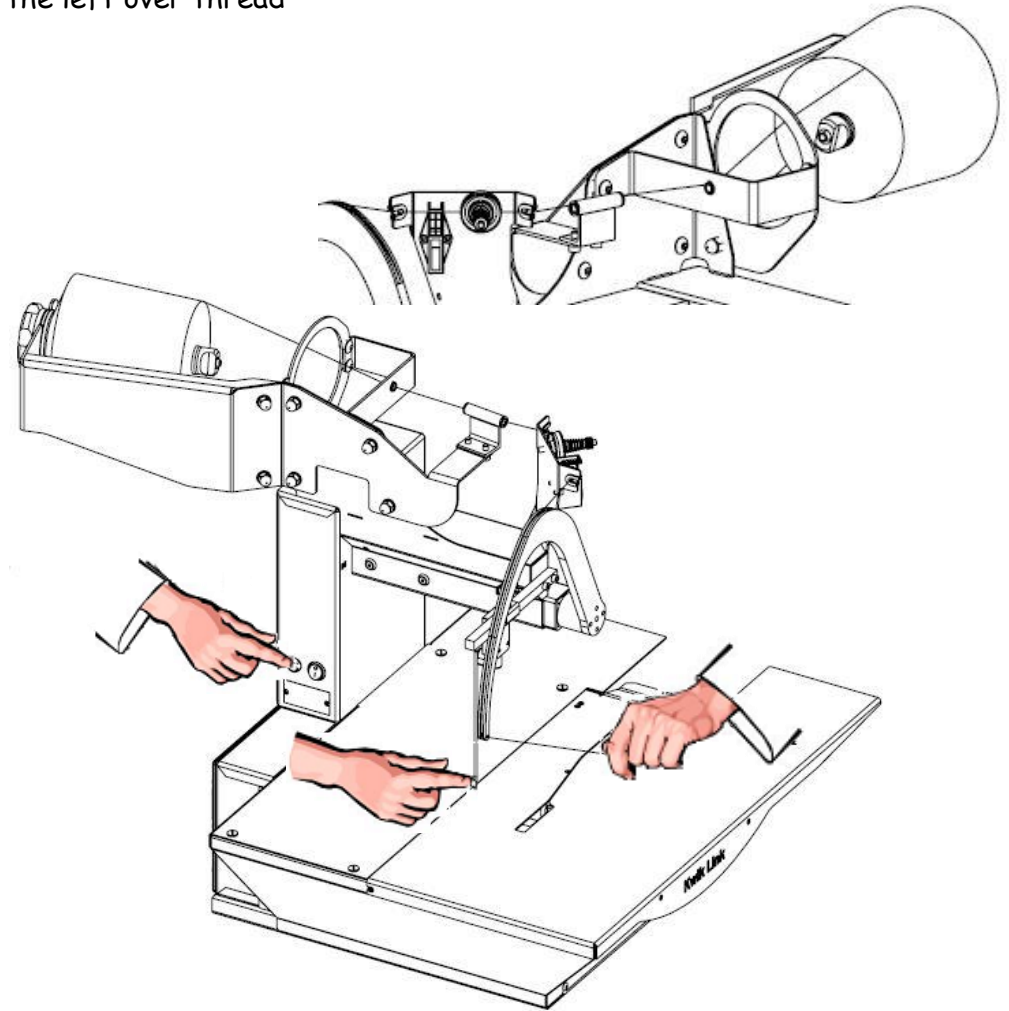
Step 2: mount the knitted twine spool support as shown

BEGINNING OF ROLL OF ELASTIC

- Follow the drawing for the installation of the spool and threading the tying material into the arm.
- Take the end of the tying material coming out of the arm and hold it firmly towards the back of the machine.
- Activate the start switch or the cycle button (green).
- Pull towards the back during the whole cycle of the machine in order to take the left over thread of the first tie off.
- The lower threading occurs automatically.
- The machine is now ready to go.



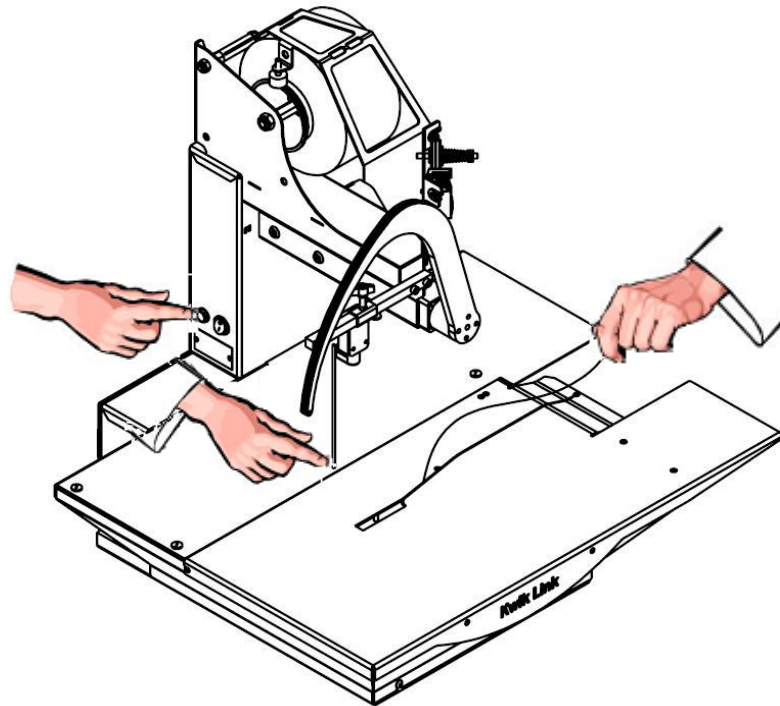
THREADING THE TYING MATERIAL (Elastic string version)



THREADING THE TYING MATERIAL (knitted twine version)

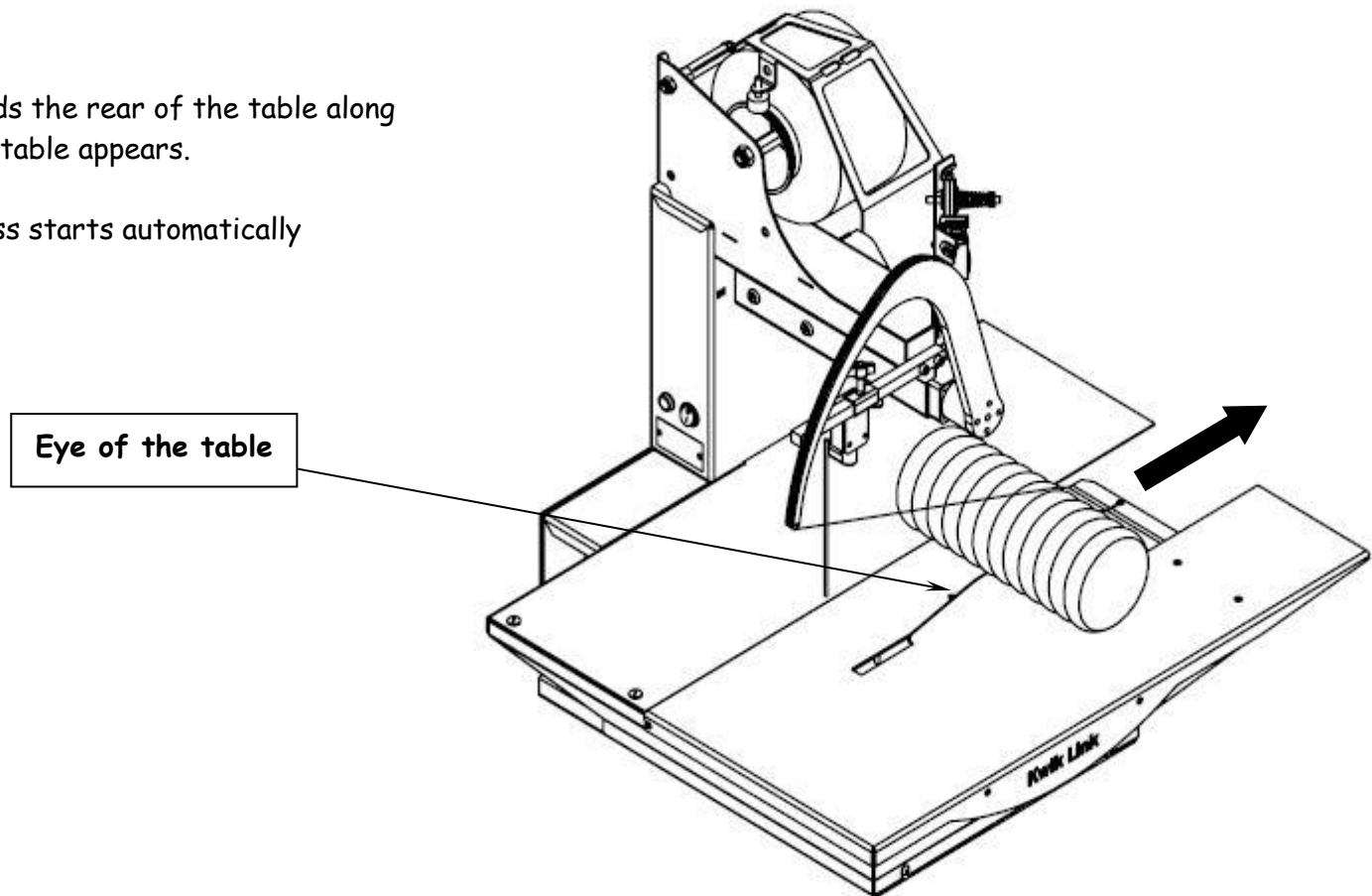
END OF ROLL OF ELASTIC

- Take the end of the tying material and hold it firmly towards the back of the machine.
- Activate the start switch or the cycle button (green).
- Pull towards the back during the whole cycle of the machine in order to take the left over thread of the first tie off.
- The machine is ready to go with a new roll.



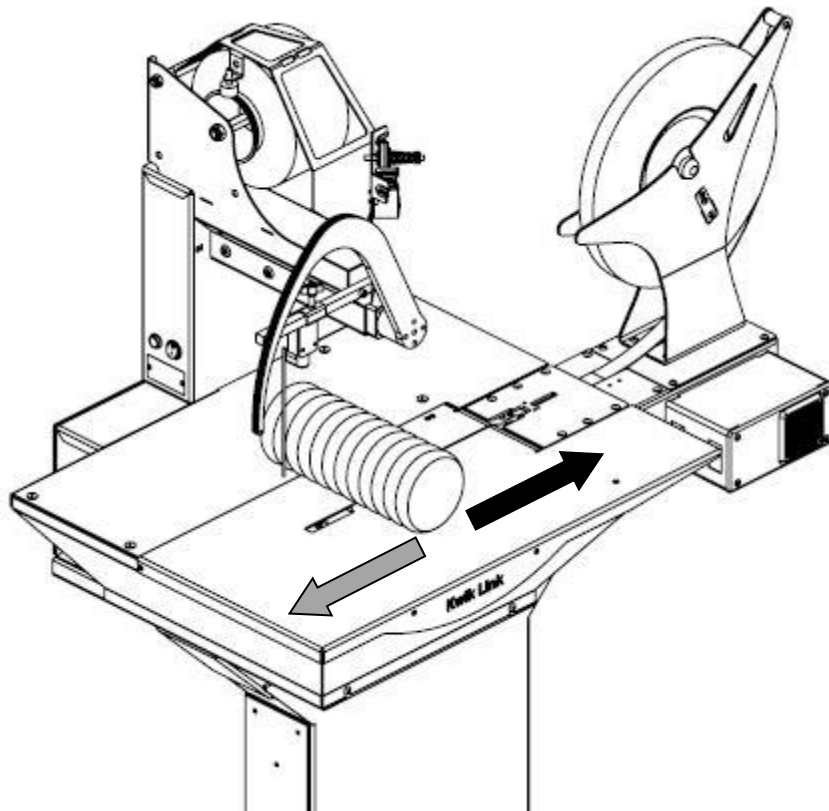
POSITIONING THE BUNCH

- Push the bunch to be tied towards the rear of the table along with the tie until the eye of the table appears.
- At this moment, the tying process starts automatically through the adjustable starter.

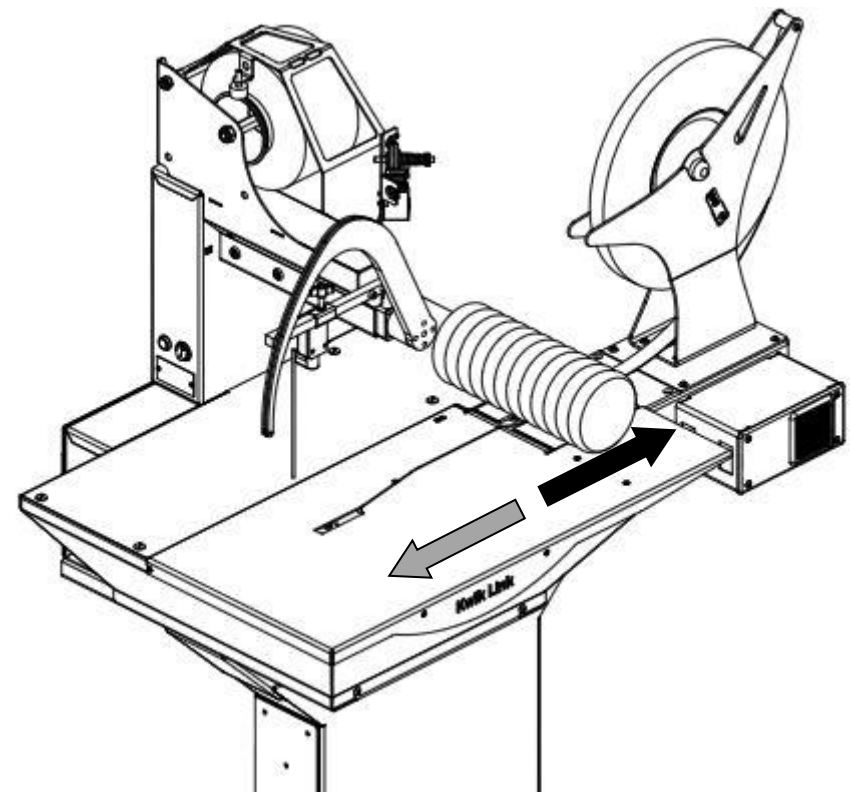


TYING WITHOUT LABEL

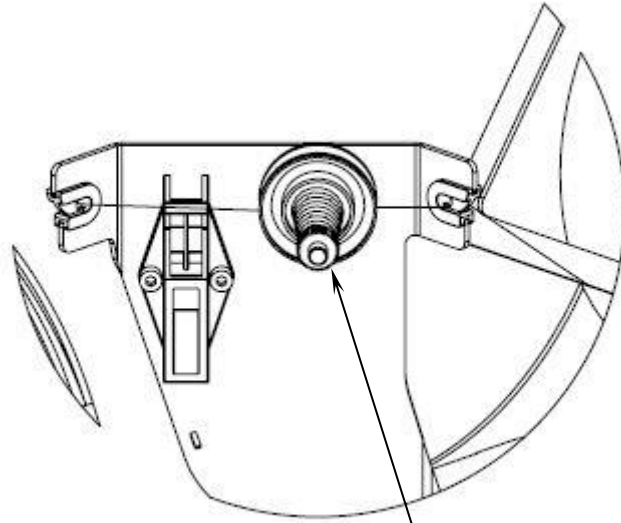
- Push the bunch towards the rear of the table along with the tie until the eye of the table appears.
- At this moment, the tying process starts automatically through the adjustable starter.
- Pull the bunch in the opposite direction : the knot goes out the eye.

**TYING WITH LABEL**

- Push the bunch towards the rear of the table along with the tie until the eye of the table appears.
- At this moment, the tying process starts automatically through the adjustable starter.
- Push the bunch toward the Kwik Lok machine until the knot is being hooked the closure.
- Then, pull the bunch in the opposite direction : the closure goes out the Kwik Lok machine.



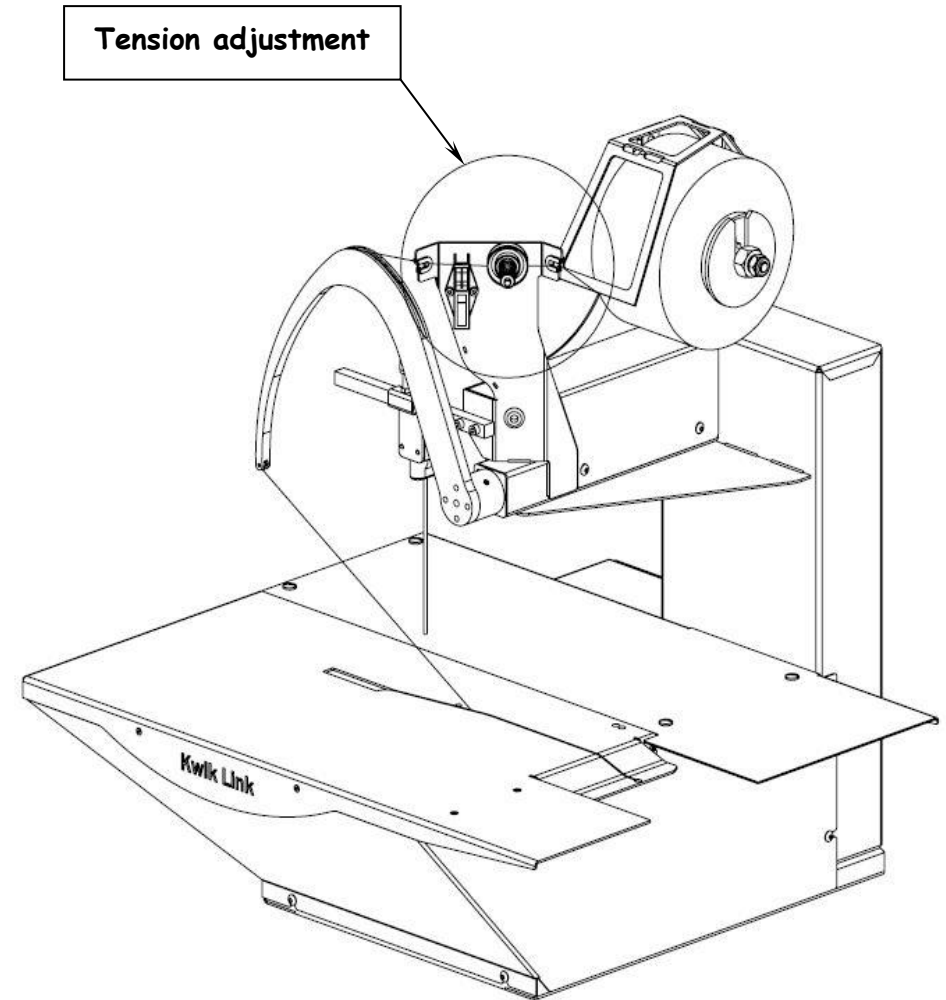
BASIC ADJUSTMENT



Tension adjustment

TENSION ADJUSTMENT

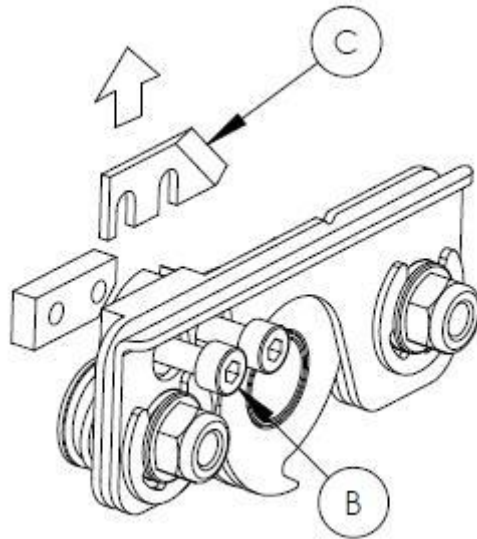
- It can be done using the black streaked nut on the clamping block.
- This adjustment is very delicate and is done a quarter of a turn at a time until the proper tension is obtained.
- The size of the bunch has an effect on the tightening. With an identical tension, a large bunch will be bound tighter than a small one.
- Too much tension will cause the tying material to break, and a loose tension will prevent the tying material from freeing itself from the knotter.



Tension adjustment

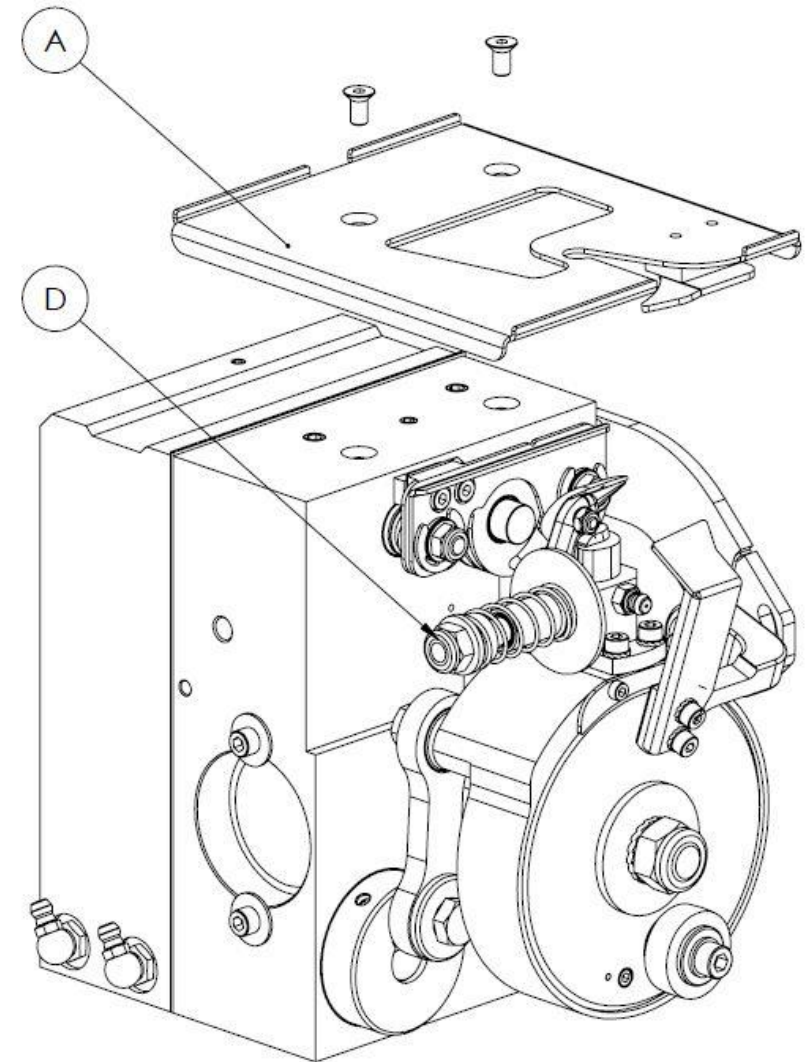
CUTTING KNIFE REPLACEMENT

- Remove knotter table A, unscrew the two bolts B.
- Pull up the knife C and replace it. It has open slots to make the replacement easier. There's only one position : max into the slots
- Make sure the knife is always in good condition.



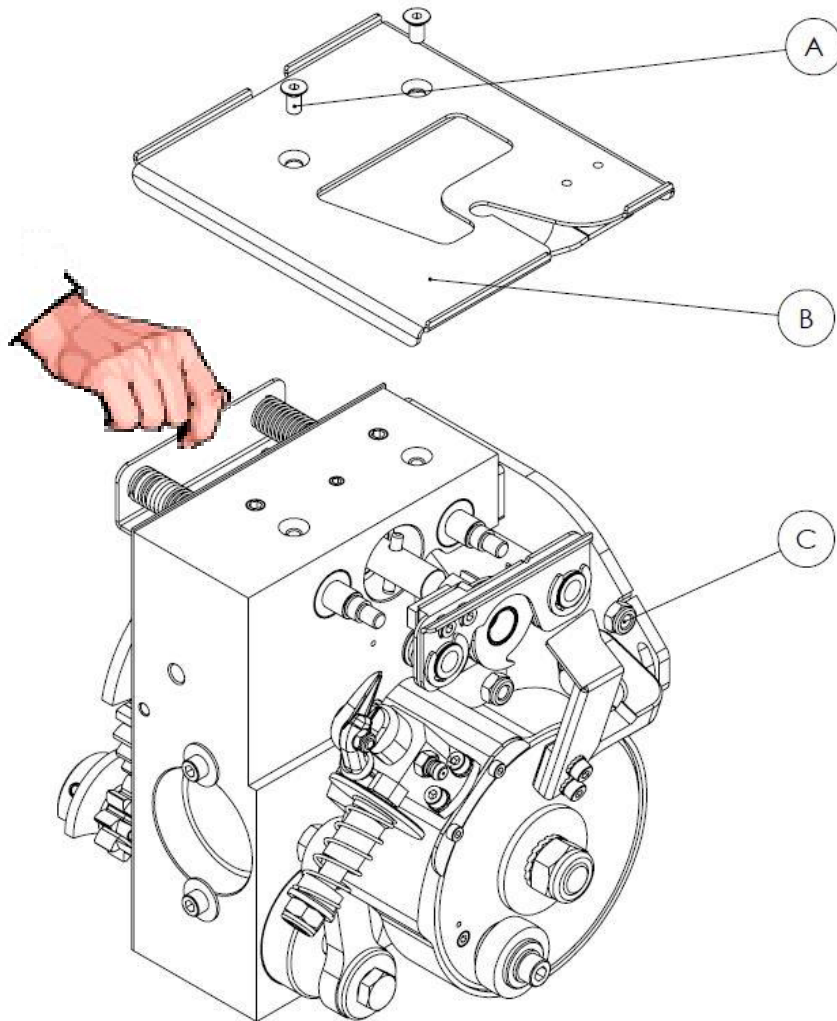
ADJUSTMENT OF THE KNOTTER TIGHTNER

- If the knots have a tendency to slide, tighten up slightly the nut D of the knotter-tightener

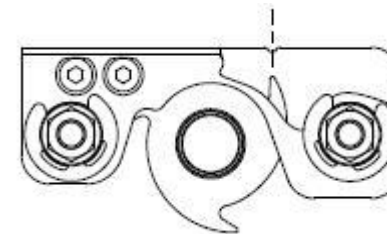
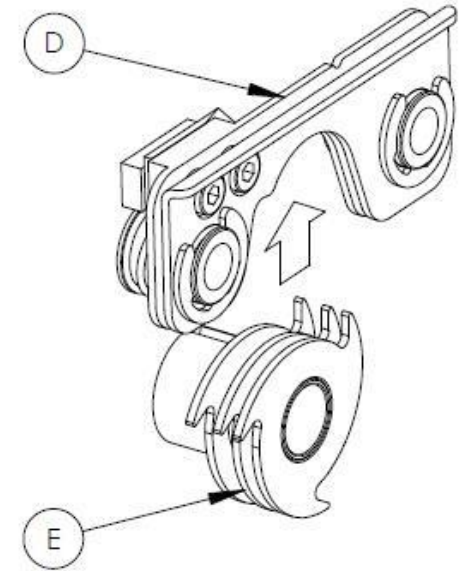


REPLACEMENT OF STRING HOLDER PLATES AND ROTARY HOLDER

- Remove work table and outer box.
- Run the machine with the step button till it stops with the knotter laid down to the max angle as shown on the picture.



- Unplug the machine.
- Remove knotter table B and its two screws A as well as the rear box.
- Loosen the two nuts "C" while holding the stopping plate.
- The set of fixed string holder plate D and the rotating holder E come out together.
- After replacement of either one of the two components or both of them make sure the tooth of the rotary holder is facing the gage of the back string holder plate, as shown on the following drawing.
- Reverse procedure for rebuilding.



MAINTENANCE

In order to have the machine running with best efficiency, it's very important to regularly clean and service the machine.

CAUTION : For any maintenance operating, unplug the machine

1. UNPLUG the machine.
2. UNSCREW the nuts and take the work table off, undo the 4 clips using a screwdriver through holes.
3. CLEAN the inside of the machine using compressed air. It's important to clean the machine before lubrication.
4. GREASING and lubrication. (see below).

WEEKLY

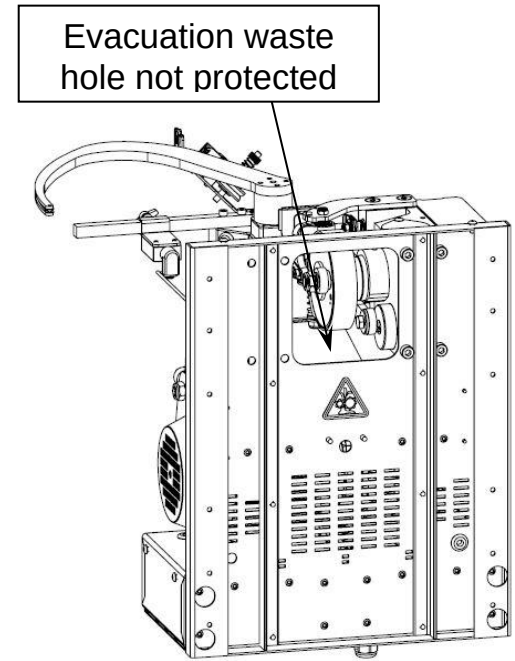
OIL:

- ❖ String holder axle D and E.
- ❖ Tightening knotter axle A.
- ❖ Knotter roller B and knotter jaw axle C.
- ❖ Linear bushings J et K

MONTHLY

GREASE:

- ❖ Knotter housing F.
- ❖ Nipple G.
- ❖ Cams and gears L--->Q.
- ❖ Conical gear H et I.



If the machine is used intensively or is used in a dirty environment the maintenance of the machine should take place daily.

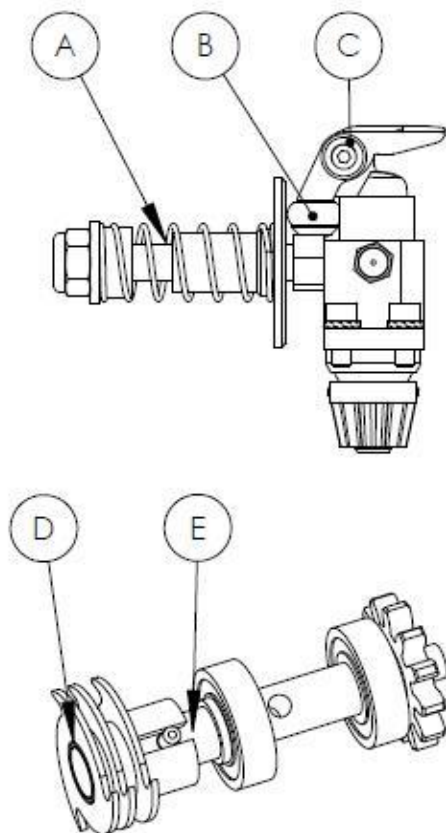
5. PLACE the table on the clips and use the screw.
6. REPLUG the machine.

RECOMMENDED LUBRICANTS

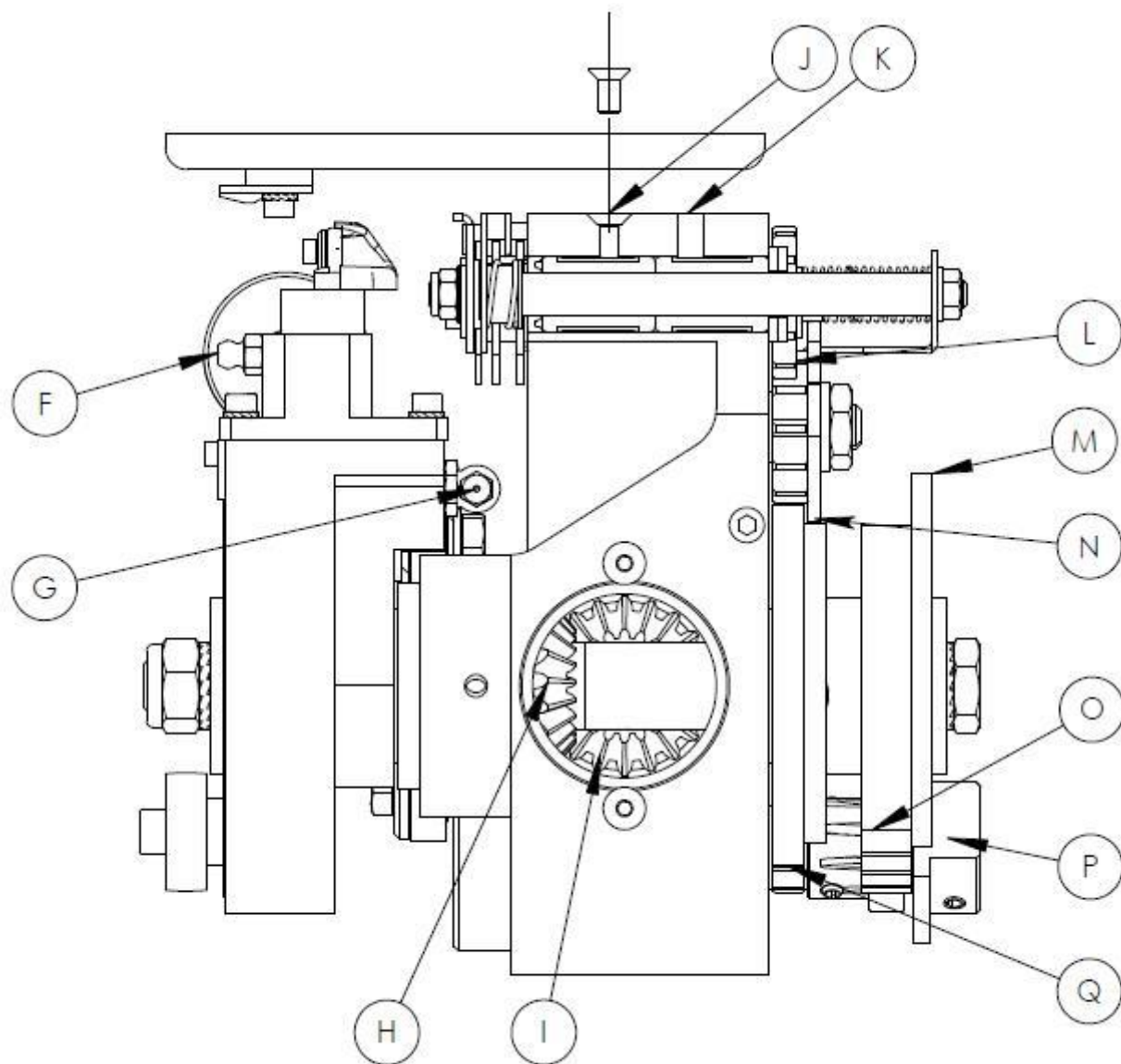
OIL type HL: with a viscosity $10 < \text{ISO VG} < 22$.

Grease: LMX GREASE High performance.

MAINTENANCE



OIL	GREASE
A	F
B	G
C	H
D	I
E	L
J	M
K	N
	O
	P
	Q



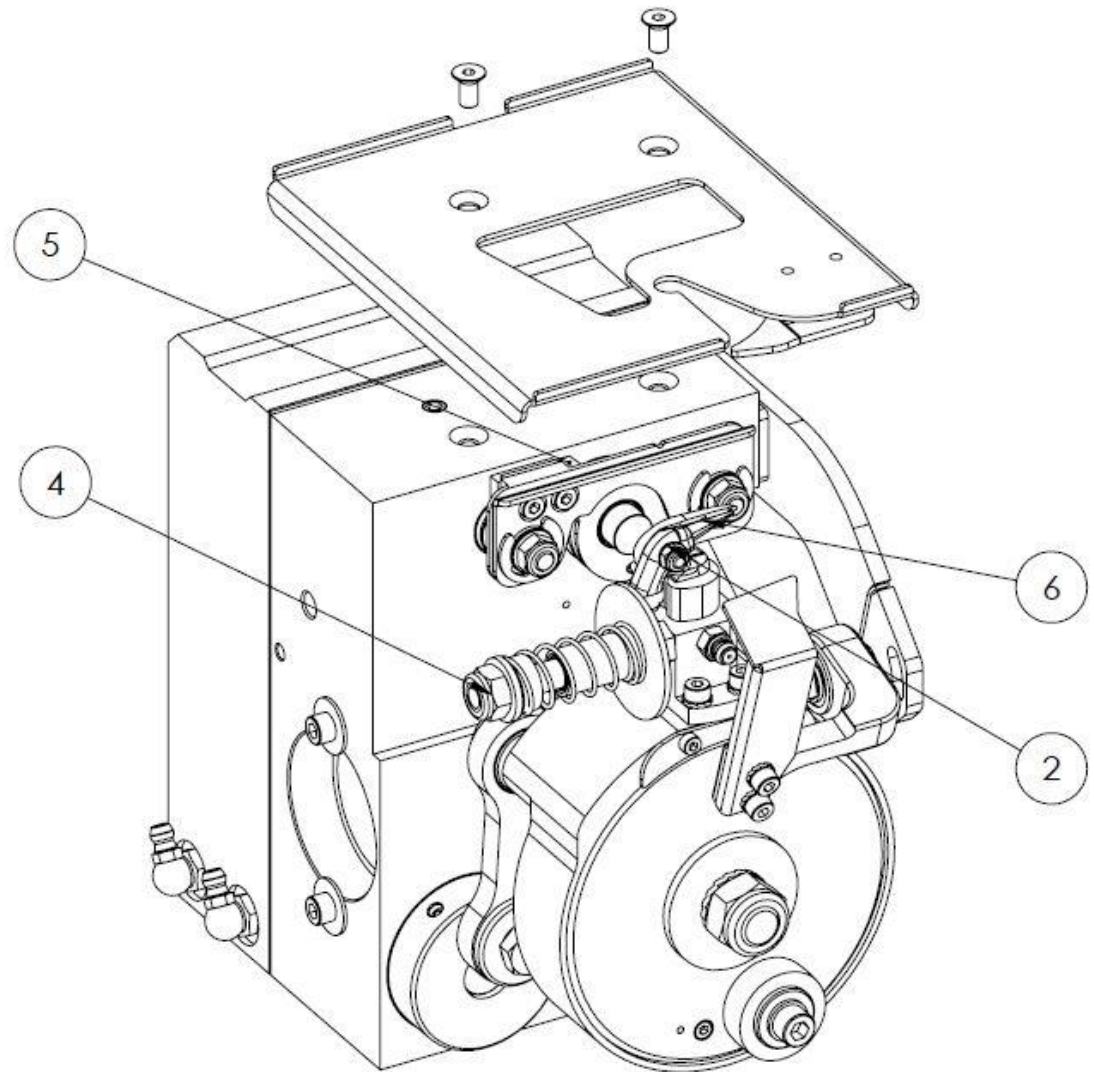
TROUBLE SHOOTING

THE MACHINE DOES NOT WORK

- A. Check the power supply, plug and socket.
- B. Check that the On/OFF button is activated.
- C. Check the fuses.

THE TYING PROCESS DOES NOT OCCUR

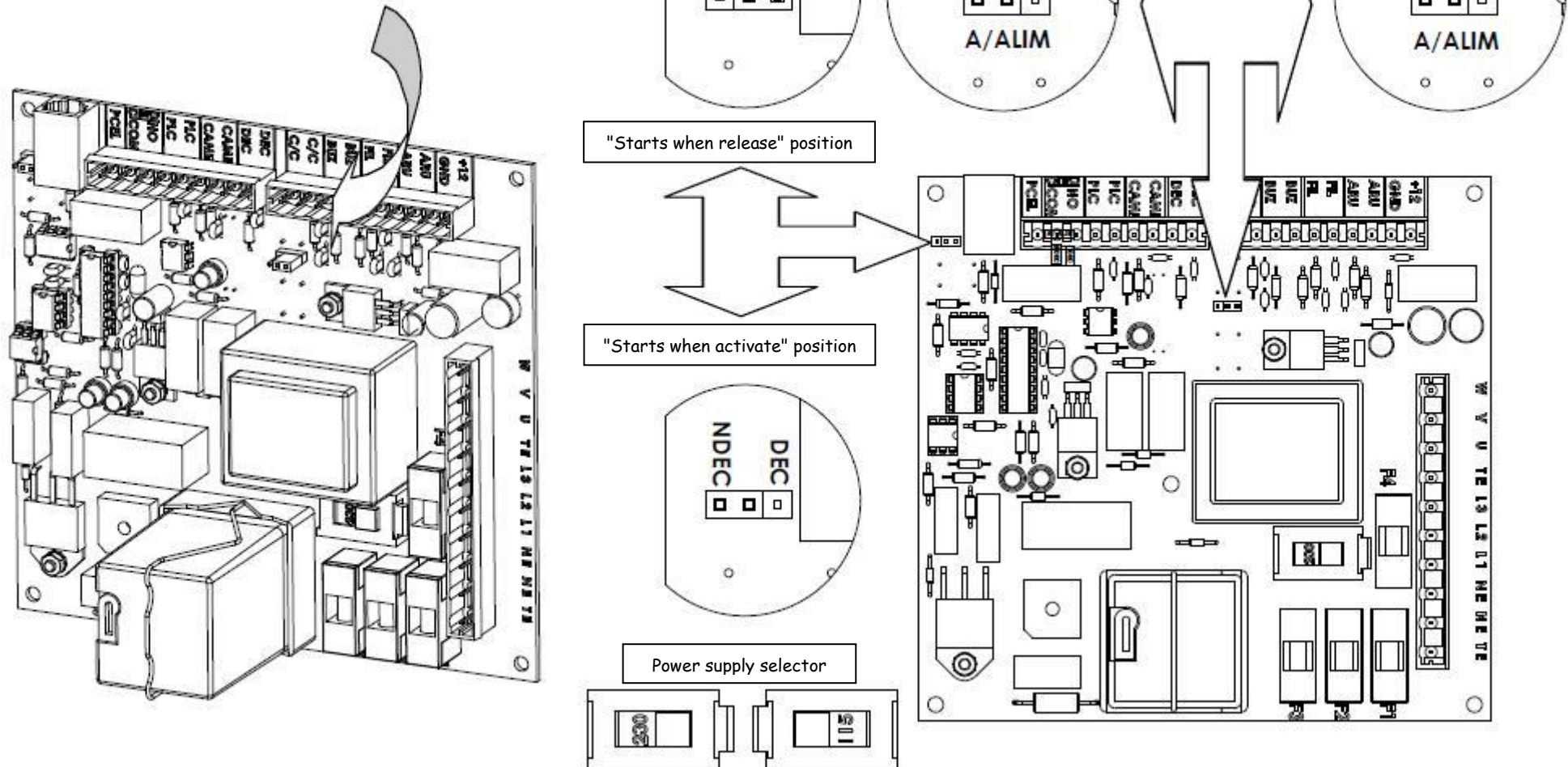
- 1. Check that the threading of the tying material is correct.
- 2. Check the working order of the knotter (the tightening of the knotter jaw).
- 3. Make sure that the knotter jaw is the correct one for the tying material used.
- 4. Check the pressure of the knotter-tightener.
- 5. Check that the knife is in good condition.
- 6. Check the cleanliness of the knotter jaw. There mustn't be any left-over elastic in the jaw.
- 7. Check the tension of the thread.



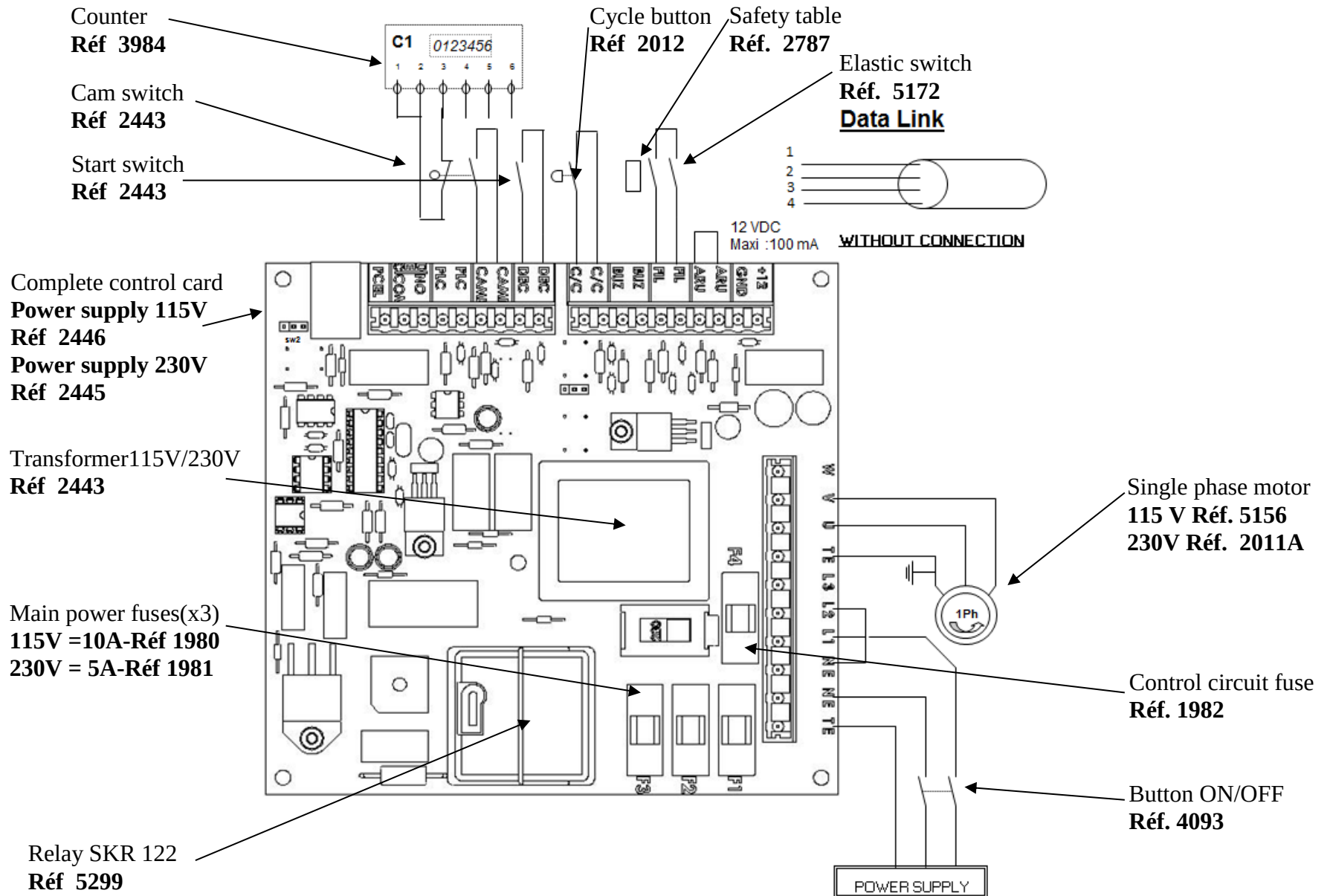
CONFIGURATIONS OF THE CONTROL CARD

It is possible to configure the binder with 4 options
These configurations can be set with two micro switches.

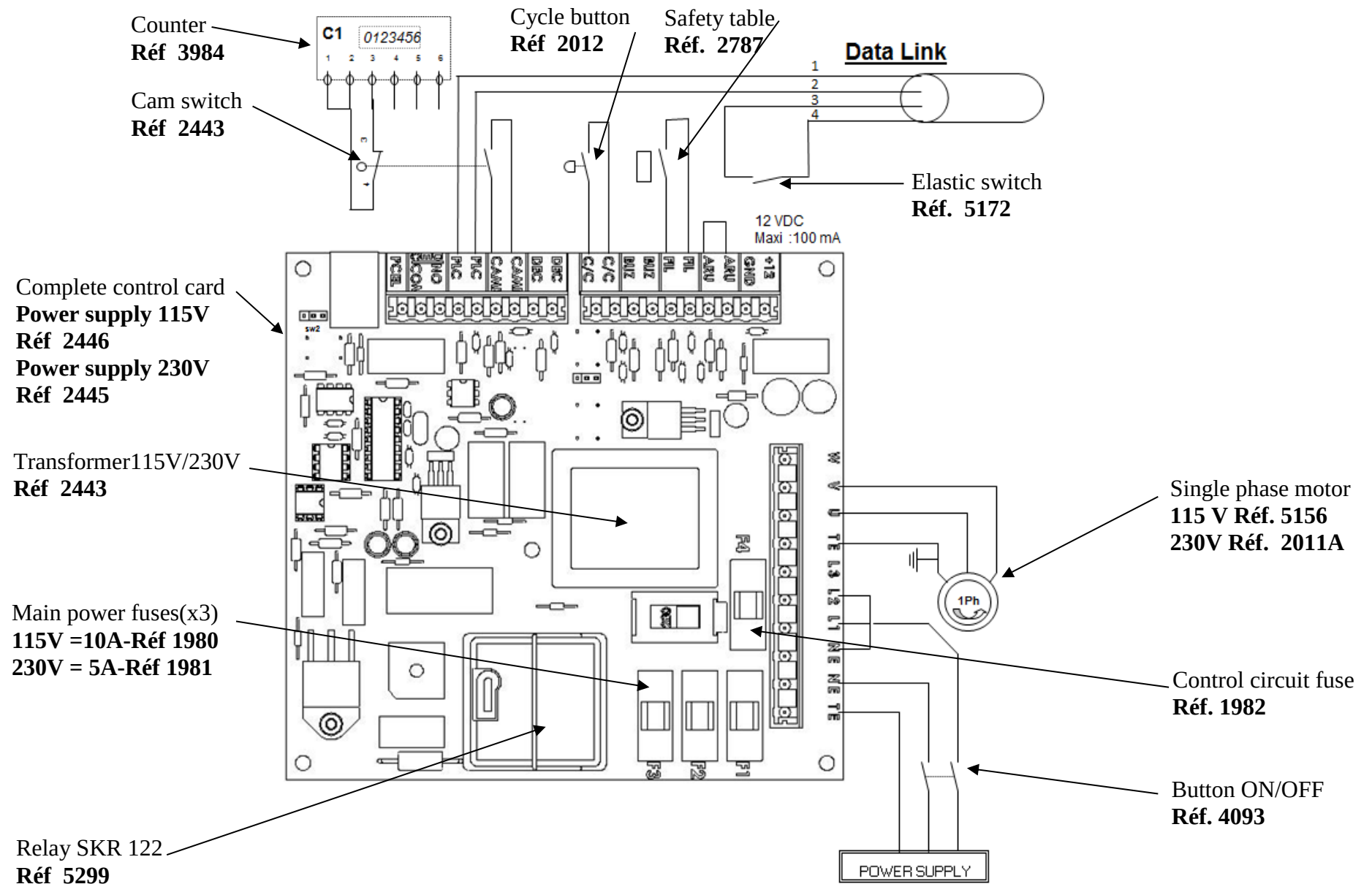
- Switchable power supply ON/OFF.
- Auto power-on when ON position.
- Start cycle when activating the start switch.
- Start cycle when releasing the start switch.



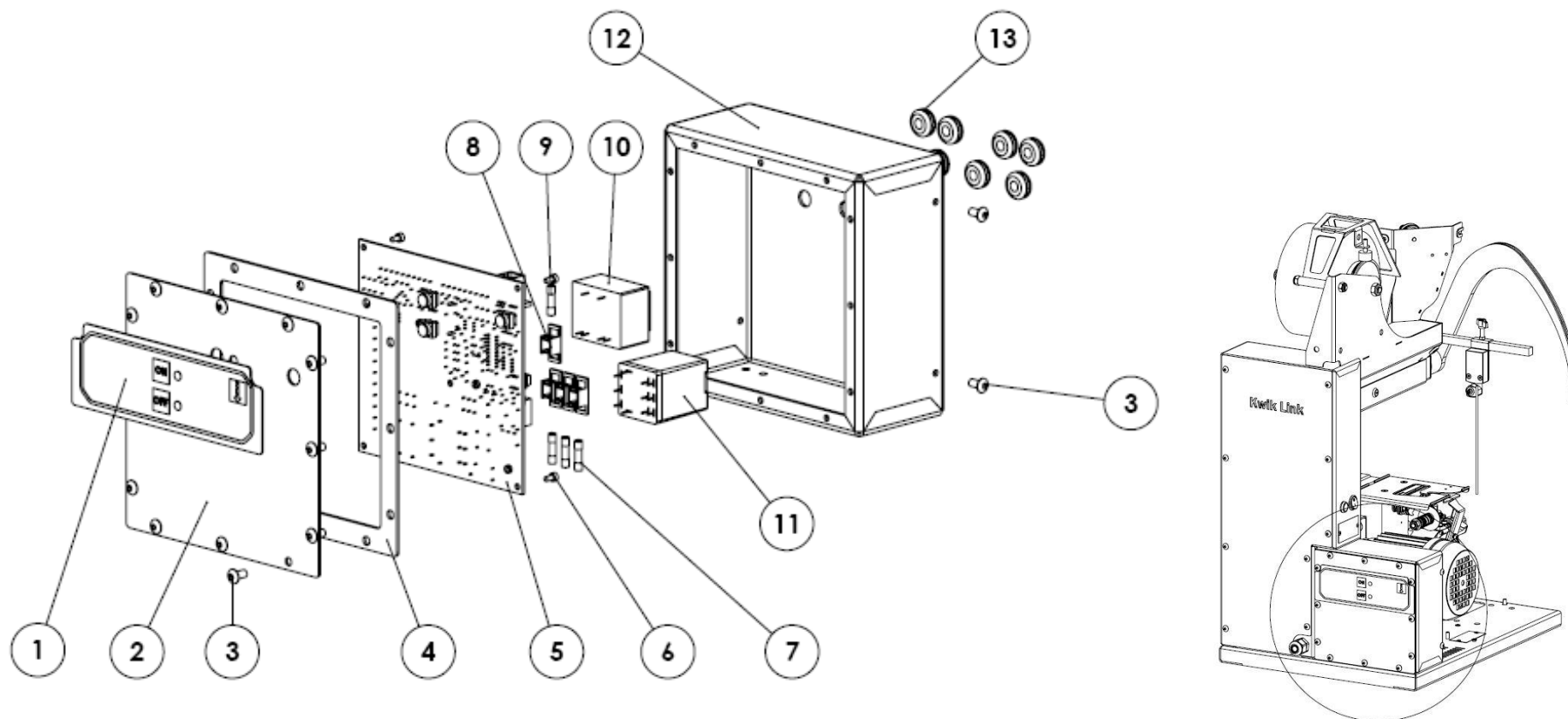
WIRING DIAGRAM : STANDARD VERSION



WIRING DIAGRAM : PULSE DETECTION

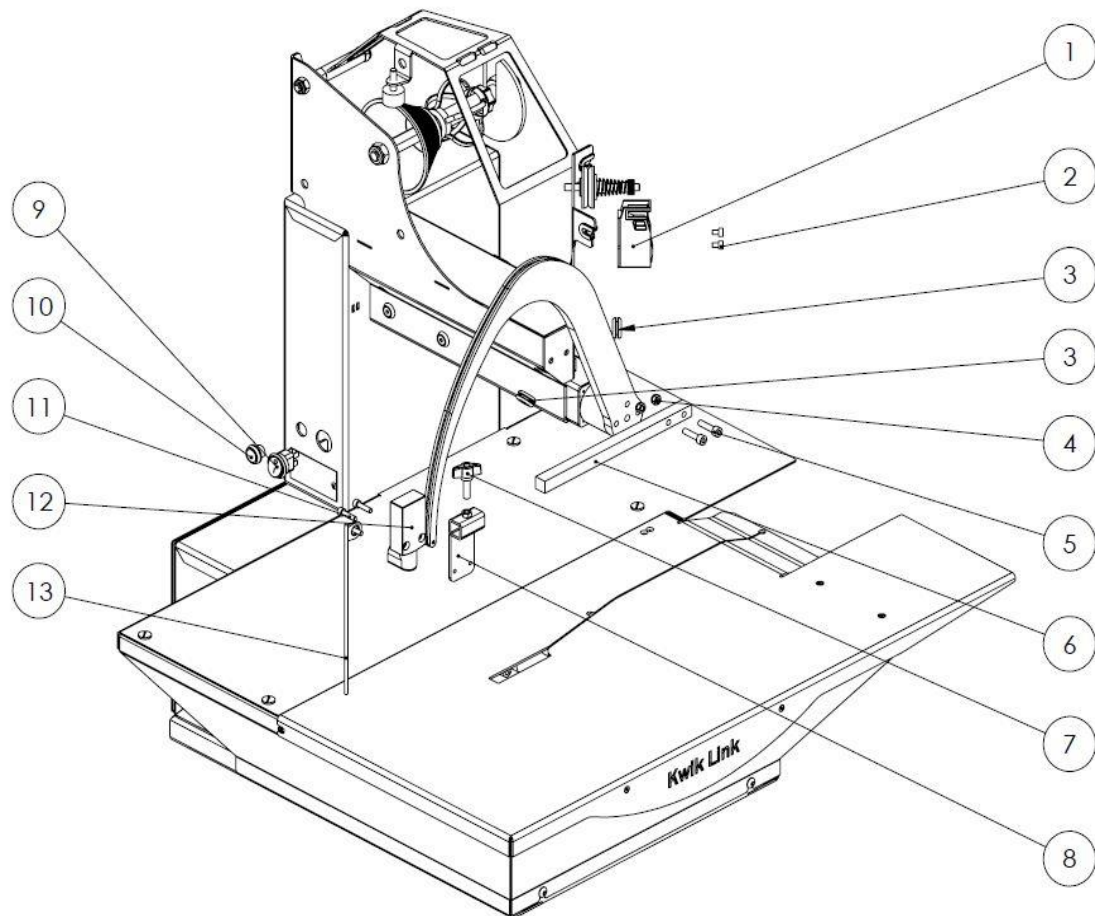


SPARE PARTS LIST - DRAWING

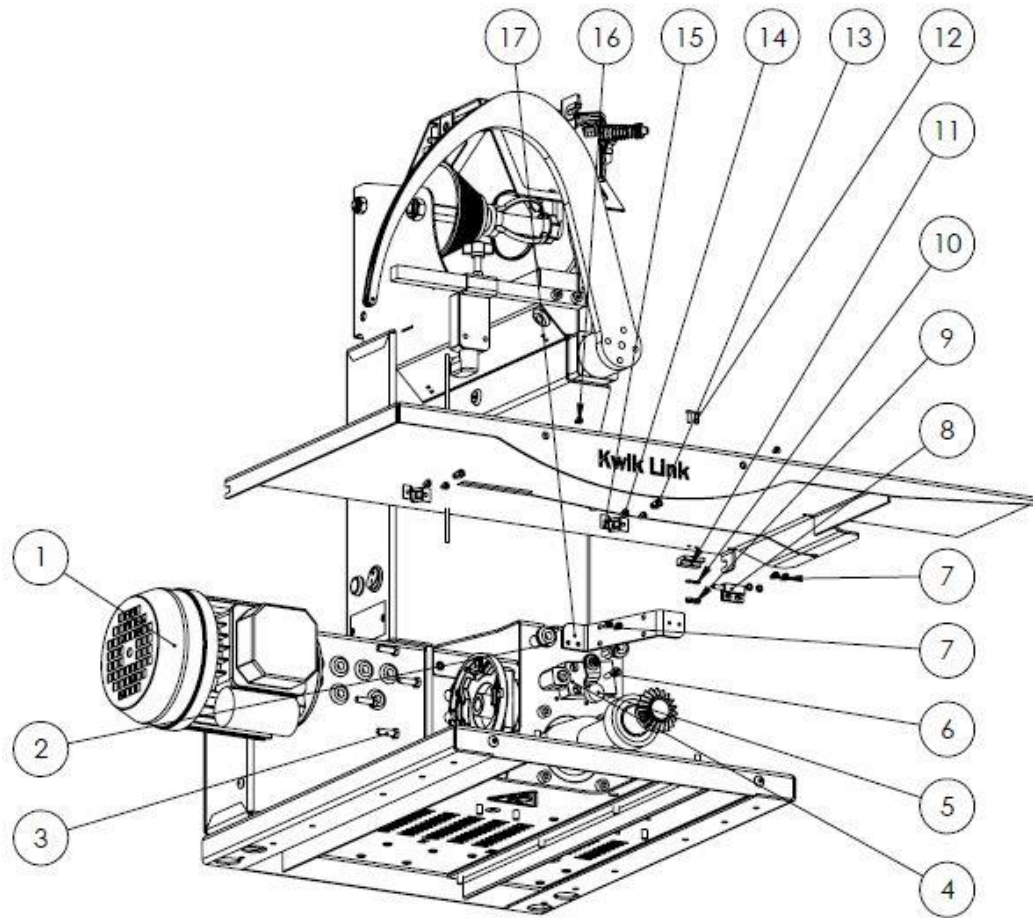


Rep	Order Ref	Description	Qty
1	2781	Sticker	1
2	2709	Electrical box cover	1
3	2696	Screw BHc M5x10	14
4	2401B	Seal	1
5	2445	Complete card 230 V	1
5	2446	Complete card 115 V	1
6	5178	Screw CHc M3x6	5
7	1981	Power fuse 230 V / 5 A	3

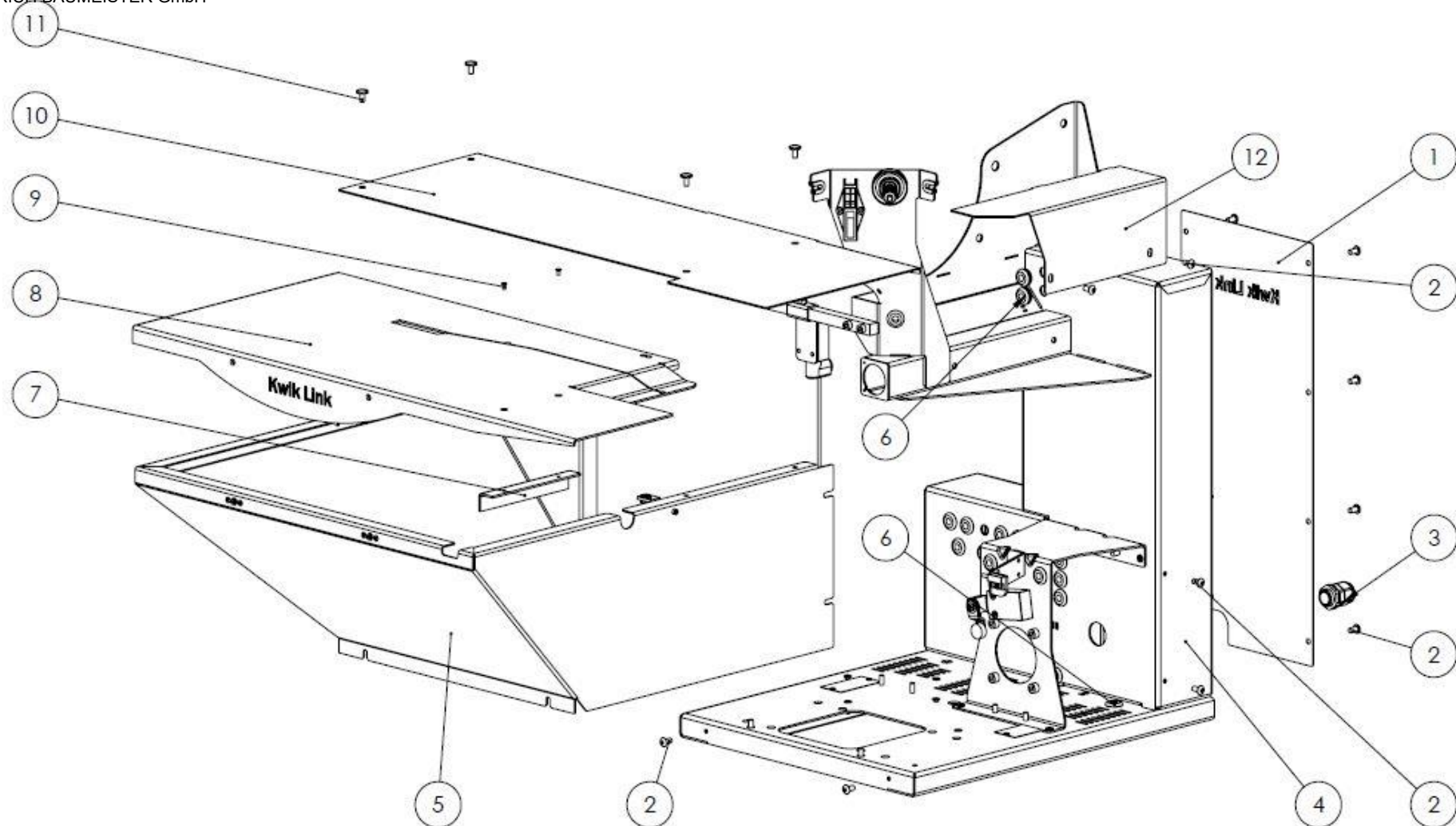
Rep	Order Ref	Description	Qty
7	1980	Power fuse 115 V / 10 A	3
8	2924	Fuse support 5x20	4
9	1982	Control fuse 150 mA	1
10	1899	Transformer 115 V / 230 V	1
11	5299	Relay SKR 122	1
12	2379B	Electrical box	1
13	2434	Rubber grommet	8



Rep	Order Ref	Description	Qty
1	5172	Missing elastic switch	1
2	2005	Screw CHc 4X 6	2
3	2434	Rubber grommet	2
4	2173	Nut M5 (Nylstop)	2
5	2196	Screw CHc M5x20	2
6	4101	Square support	1
7	2221	Plastic screw M6 x 20	1
8	4102	Switch support	1
9	4093	ON/OFF button	1
10	2012	Cycle button	1
11	2733	Screw CHc M4x16	1
12	2443	Body switch	1
13	2442	Head of switch	1



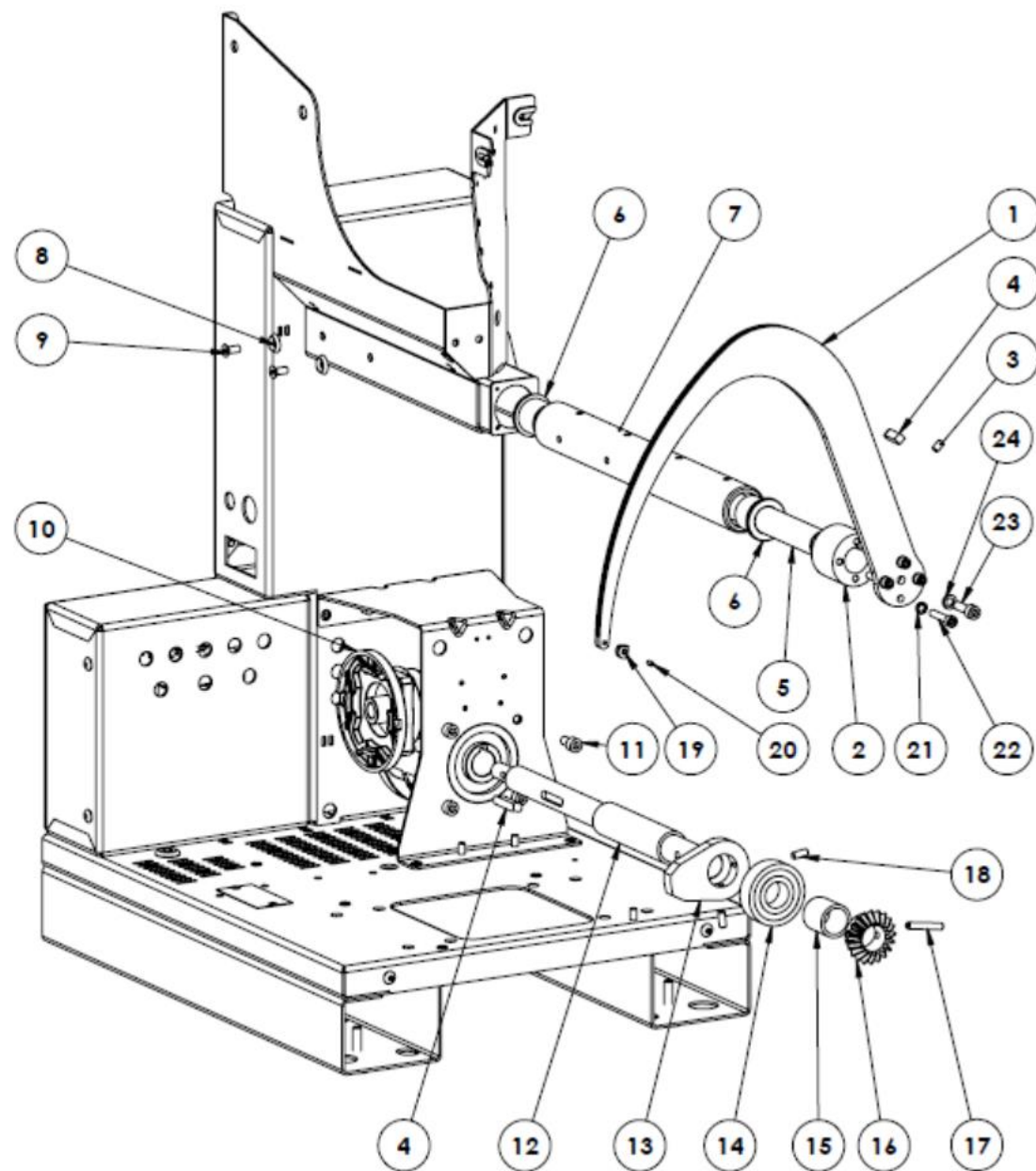
Rep	Order Ref	Description	Qty
1	2011A	Single phase motor 230V / 50 Hz	1
1	5156	Single phase motor 115 V / 60 Hz	1
2	2434	Rubber grommet	2
3	5187	Screw H M5x16	4
4	2443	Body switch	1
5	2444	Switch roller	1
6	2733	Screw CHc M4x16	2
7	2187	Screw CHc M3x6	4
8	2787	Magnetic proximity switch	1
9	2543	Nut M3 (Nylstop)	2
10	2790	Washer ZU Ø3	2
11	2788	Magnet for proximity switch	1
12	2789	Screw FHc M3x10	2
13	5224	Male clip	2
14	4114	Countersand head Rivet Ø3.2 x 6	4
15	4113	Female clips	2
16	5176	Screw FHc M3x6	2
17	4406	Switch support.	1

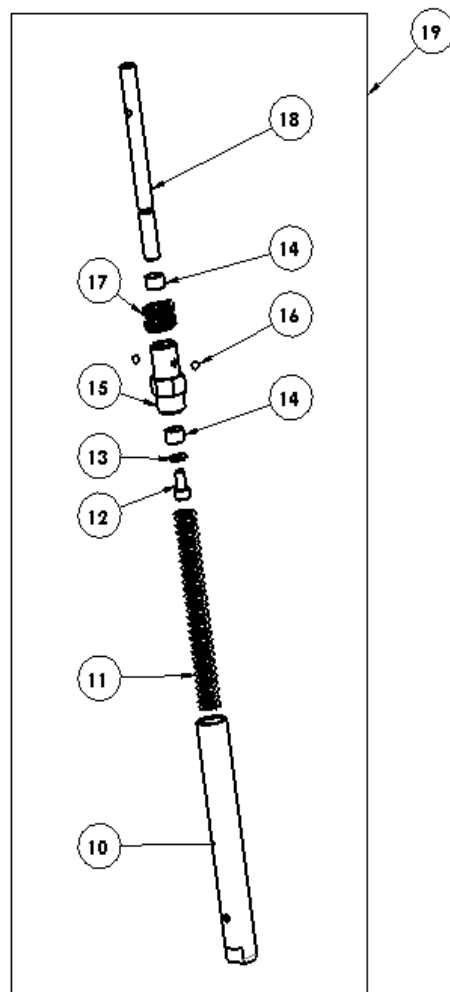


Rep	Order Ref	Description	Qty
1	4393	Mechanical box cover	1
2	2696	Screw BHc M5x10	12
3	2435	Screw on cable bushing PG11	1
4	4030C	Assembled structure	1
5	4391A	Mechanism cover	1
6	2434	Rubber grommet	9

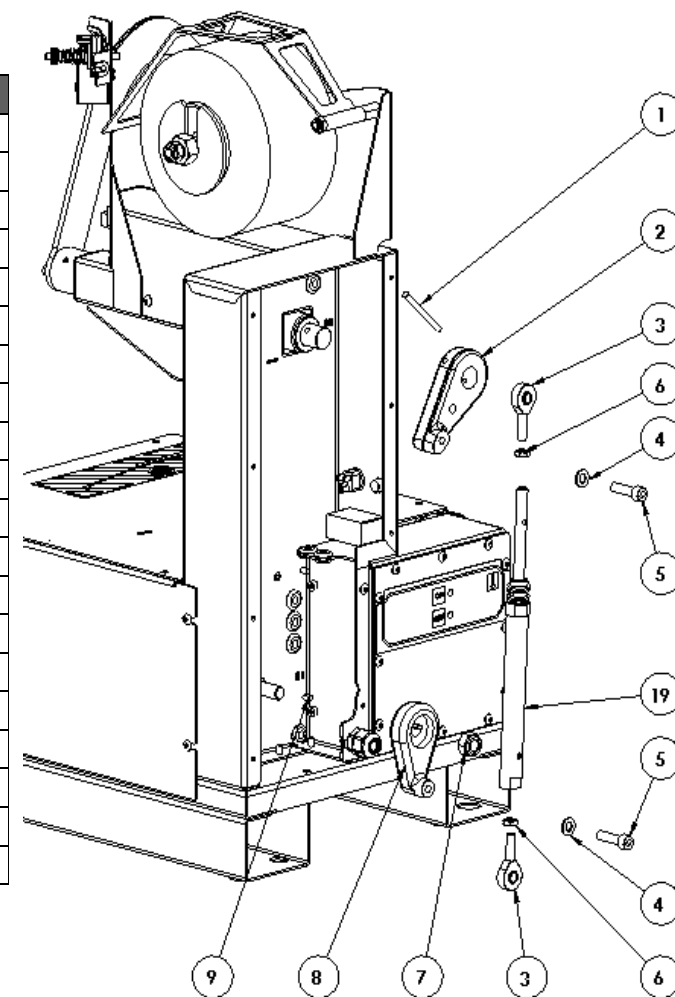
Rep	Order Ref	Description	Qté
7	4390	Mobile table angle	1
8	4389B	Mobile table	4
9	4114	Countersand head Rivet Ø3.2 x 6	2
10	4388	Fixed table	1
11	2689	Screw TRFL M5x10	1
12	4018B	Protection cover	1

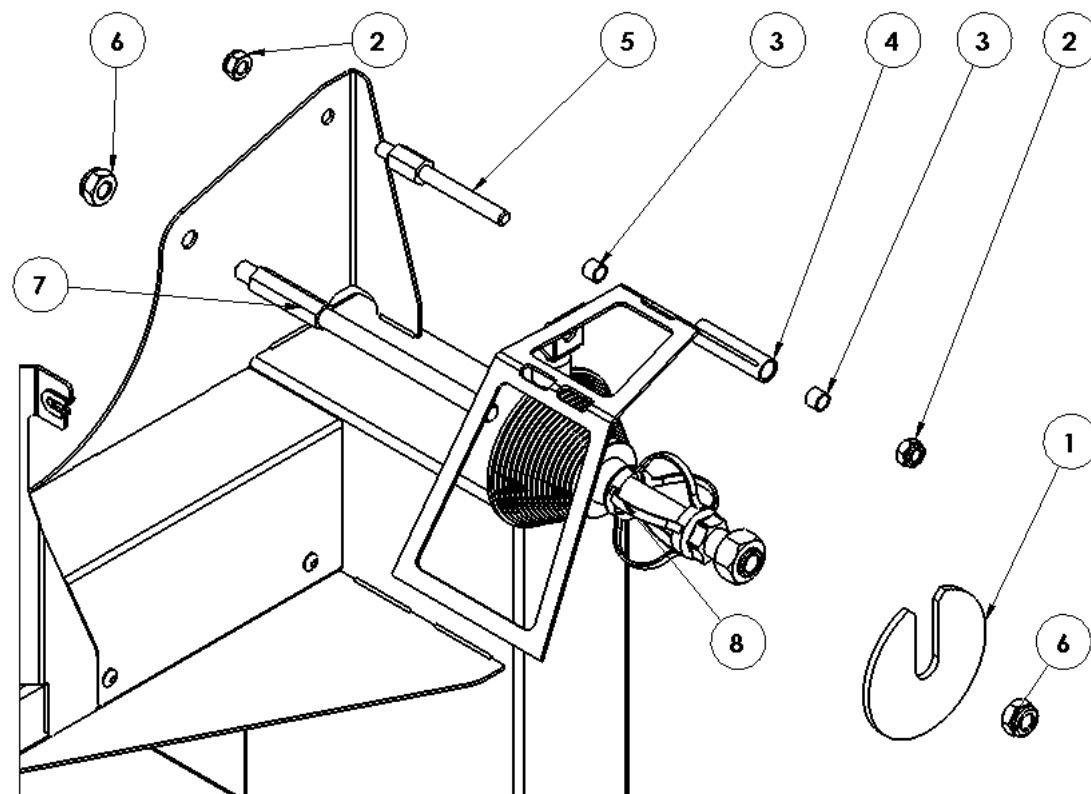
Rep	Order Ref	Description	Qty
1	4097A	Needle	1
2	5540	Needle hub	1
3	1979	Screw Hc M5 x 8	1
4	2003	Key way 6 x 6 x 30 BR	2
5	2388B	Needle Shaft (Right)	1
5	2436A	Needle shaft (Left)	1
6	2004	Bronze bushing BP25 C 20-26-25	2
7	2387A	Tube (Right)	1
7	2392A	Tube (Left)	1
8	2657	Specific washer Ø 5	4
9	2210	Screw Fhc M5 x 12	4
10	2437	Gear reducer 1/15	1
11	2198	Screw CHc M6 x 12	4
12	2389A	Secondary shaft (Right)	1
12	2439	Secondary shaft (Left)	1
13	6086B	Cam	1
14	2009	Bearing 6204 2RS	1
15	5537	Secondary shaft spacer (Right)	1
15	5603	Secondary shaft spacer (Left)	1
16	5506	Conical gear	1
17	1960	Pin Ø 5 x 30	1
18	1957	Screw Hc M5 x 12	1
19	5592	Needle stainless steel insert	1
20	2879	Pin Ø 3 x 6	1
21	2181	Washer grower Ø 5	4
22	2197	Screw CHc M5 x 25	4
23	2499	Screw CHc M6 x 20	1
24	2182	Washer grower Ø 6	1





Rep	Order Ref	Description	Qty
1	5291	Conical pin Ø 6x60	1
2	4107	Upper crank	1
3	2007	Ball and socket joint KA 8D	2
4	5209	Washer Ø 8 ZU	2
5	2008	Screw CHc M 8X 30	2
6	5208	Nut Hm M 8	2
7	1953	Nut Nylstop M 12	1
8	4033	Lower crank	1
9	5136	Key way 4x4x10 BR	1
10	5553	Connecting rod body	1
11	5256	Main spring	1
12	2438	Screw CHc M 6X 12	1
13	2662	Washer Ø 6 MU	1
14	5251	Bushing MB 10 08 DU	2
15	5554	Closure	1
16	2023	Ball Ø 4.763	2
17	5306	Lock spring	1
18	4098	Inner bar	1
19	4099	Assembled discharge connecting rod	1

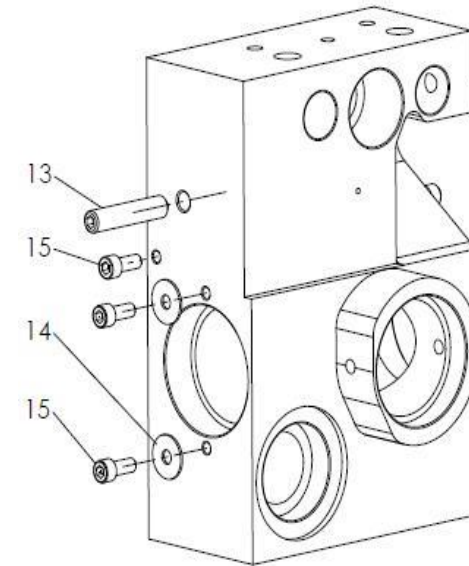
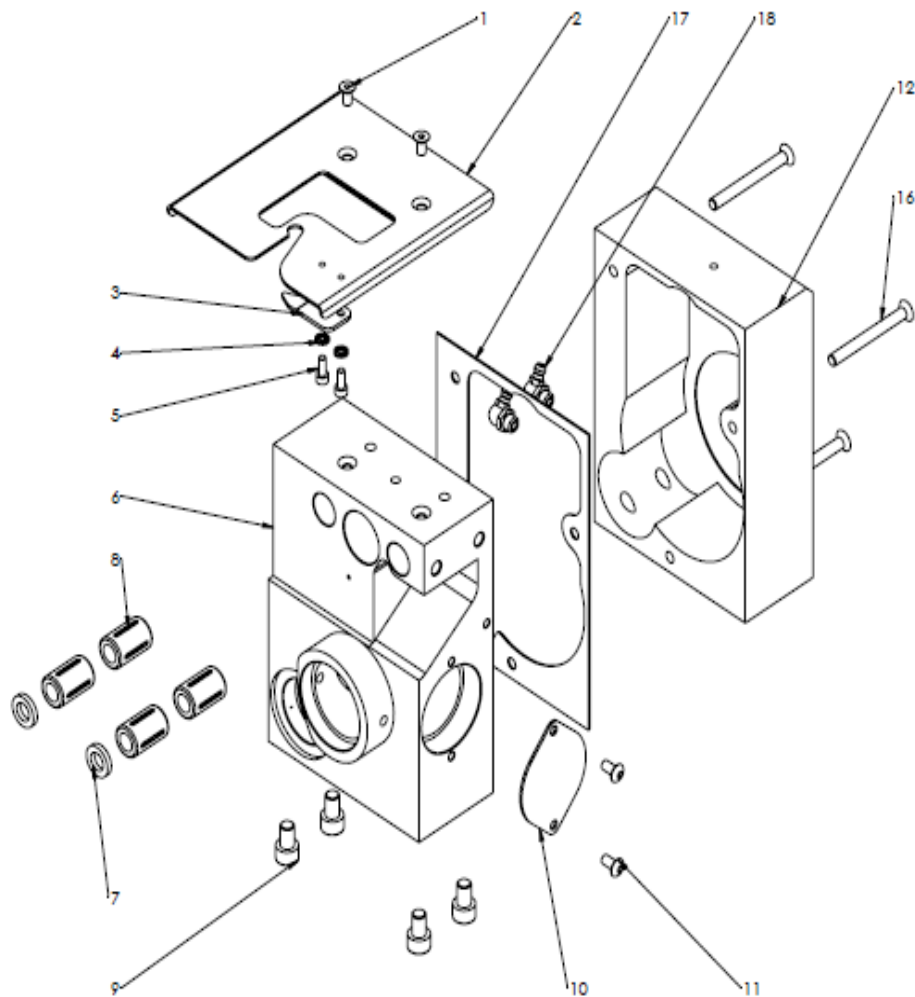




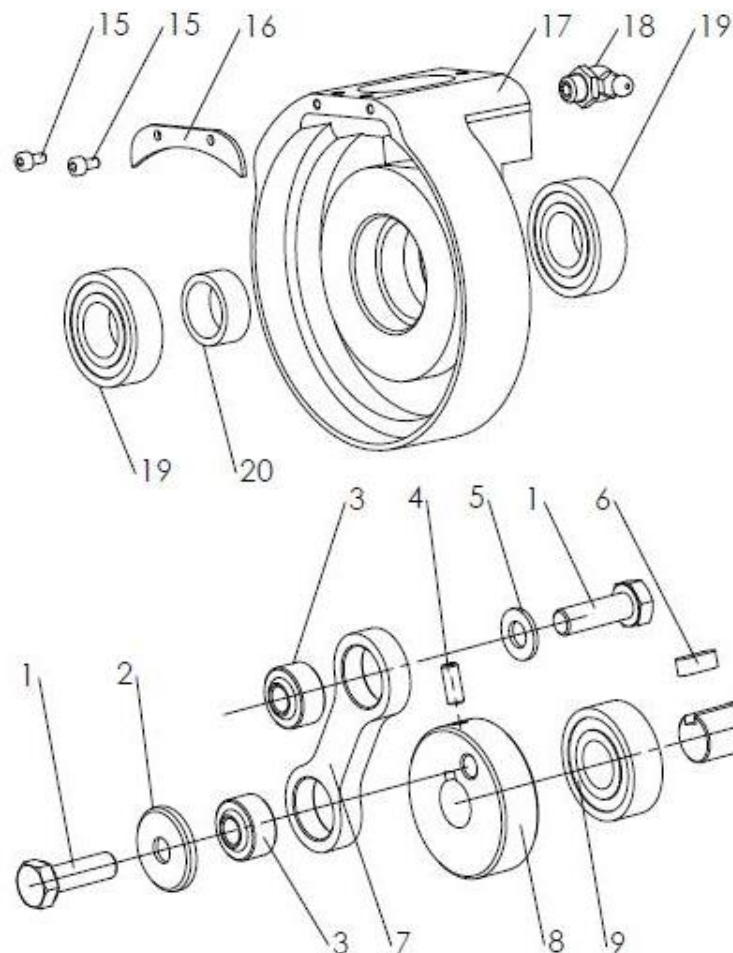
For standard binding machine equipped for 1 core or 3 cores elastic string

Rep	Order Ref	Description	Qty
1	5166	Lock spool washer	1
2	2736	Nut Nylstop M 8	2
3	5107A	Bushing GSM 0810-08	2
4	4111	Anti spinning spool (Right)	1
4	4112	Anti spinning spool (Left)	1

Rep	Order Ref	Description	Qty
5	4026	Anti spinning spool shaft	1
6	2546	Nut Nylstop M 10	2
7	4025	Spool shaft	1
8	5170	Spool holder + nut	1



Rep	Order Ref	Description	Qty
1	4115	Screw FHc 5x 10	2
2	5324D	Knotter table	1
3	5528B	String recall plate	1
4	1949	Washer Ø4	2
5	5179	Screw CHc 4X 10	2
6	5501C	Main block	1
7	2422	Seal G 10-17-3	2
8	1973	Linear bearing KH 1026	4
9	1970	Screw CHc 8 X 12	4
10	5588	Hole cover	1
11	2423	Screw BHc 5X 10	2
12	5529B	Mechanism cover	1
13	1967	Screw Hc 8x 40 (Pointed)	1
14	5195	Washer Ø 5 LU	2
15	1964	Screw CHc 5X 12	4
16	2797	Screw Fhc 6x 60	3
17	4080	Specific seal	1
18	4087	Nipple 45°M8	1

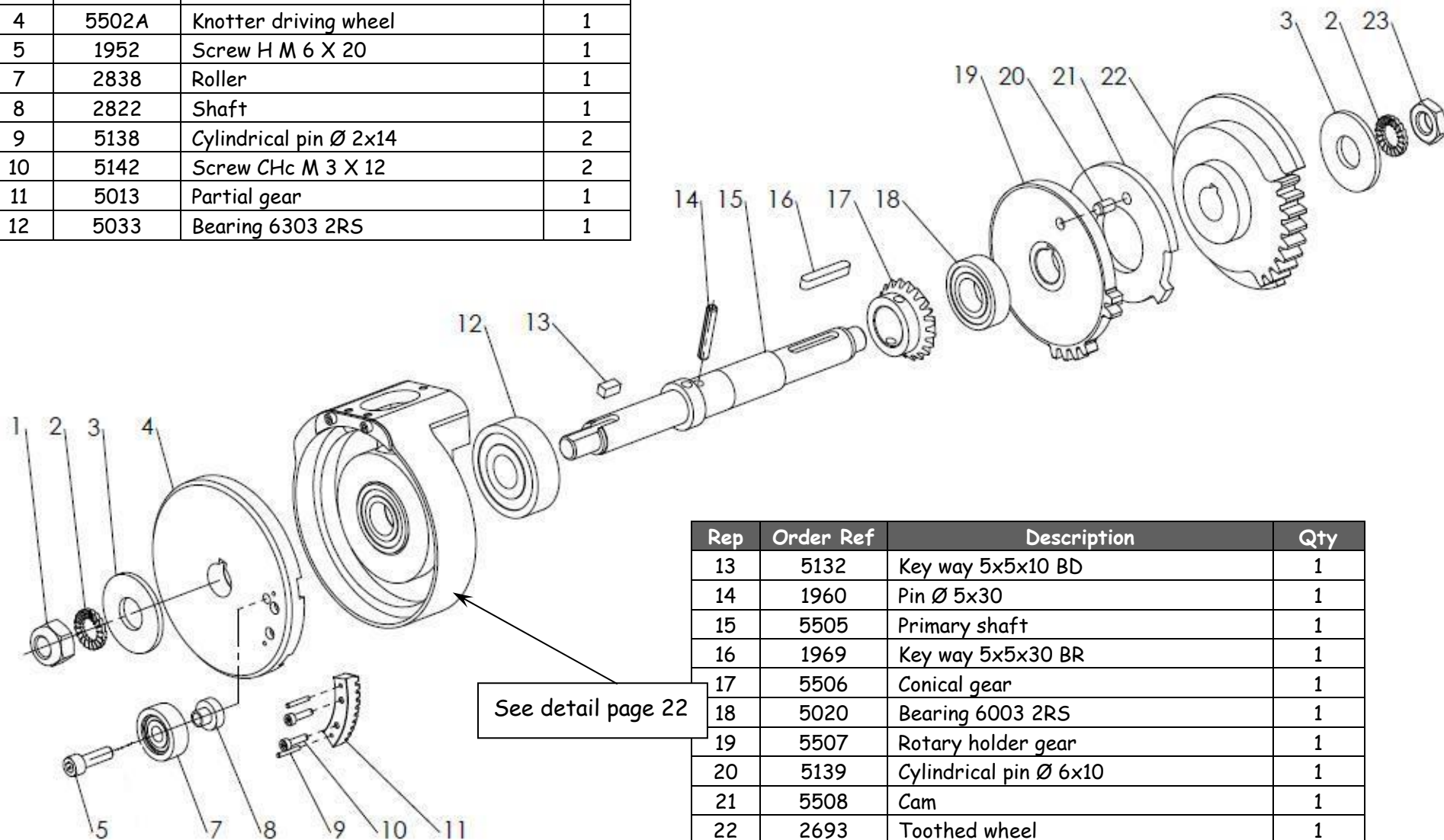


Rep	Order Ref	Description	Qty
15	5178	Screw H M3x6	2
16	5564	Closing sheet	1
17	5503	Knotter unit support	1
18	2421	Nipple 90° M8	1
19	5020	Bearing 6003 2RS	2
20	5009	Primary shaft spacer	1
21	2866	Pin Ø 5x25	1

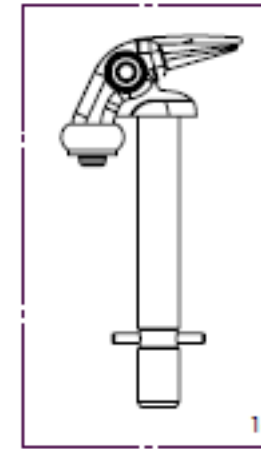
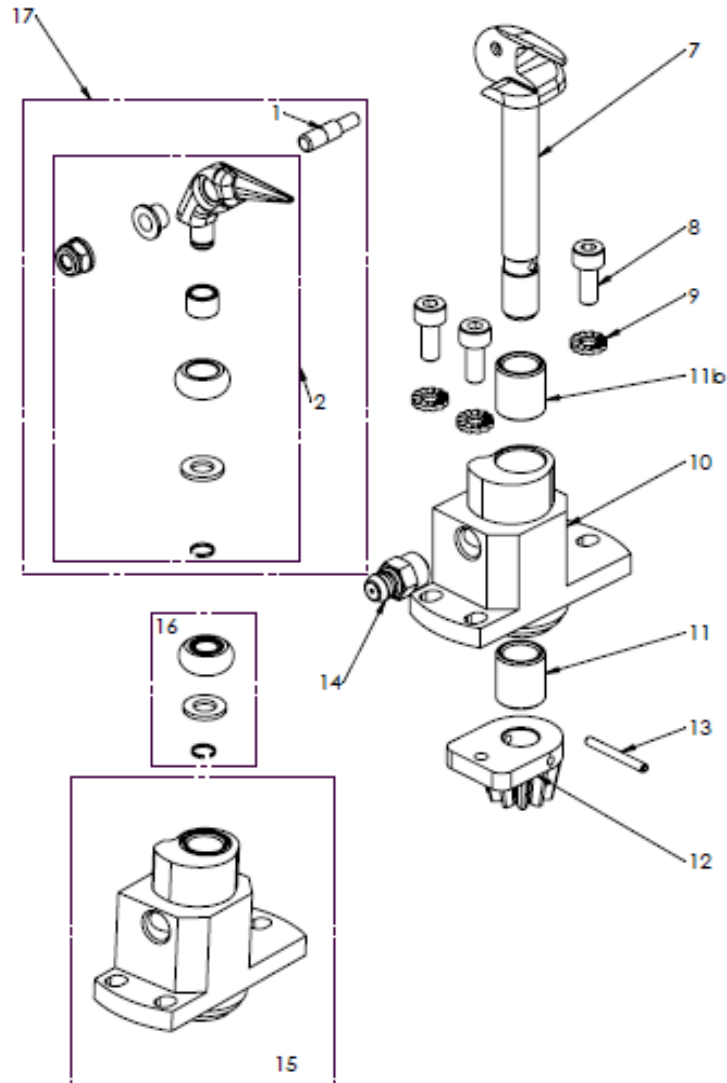
Rep	Order Ref	Description	Qty
1	1955	Screw H M8 x 25	2
2	5558	Stopping washer	1
3	1956	Ball and socket joint G8D	2
4	1957	Screw Hc M5 x 12	1
5	5209	Washer Ø 8 LU	1
6	1959	Key way 5x5x14 BR	1
7	5552B	Rod	1

Rep	Order Ref	Description	Qty
8	5518A	Hub rod	1
9	1958	Bearing 6202 2RS	2
10	5516A	Toppler shaft	1
11	5517	Bearing spacer	1
12	5515A	Gear	1
13	5514A	Toppler cam	1
14	1960	Pin Ø 5x30	2

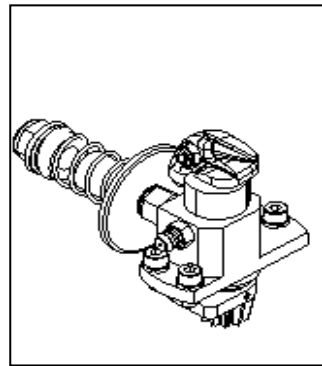
Rep	Order Ref	Description	Qty
1	1953	Nut Nylstop M12	1
2	1954	Washer Ø12	2
3	1961	Washer Ø 16 LU	2
4	5502A	Knotter driving wheel	1
5	1952	Screw H M 6 X 20	1
7	2838	Roller	1
8	2822	Shaft	1
9	5138	Cylindrical pin Ø 2x14	2
10	5142	Screw CHc M 3 X 12	2
11	5013	Partial gear	1
12	5033	Bearing 6303 2RS	1



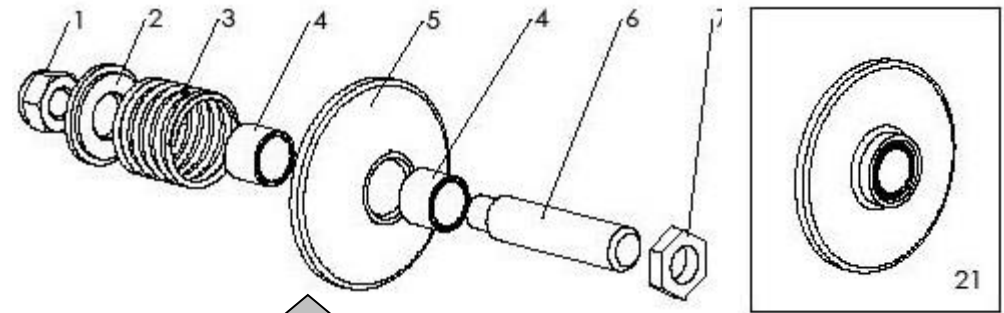
Rep	Order Ref	Description	Qty
13	5132	Key way 5x5x10 BD	1
14	1960	Pin Ø 5x30	1
15	5505	Primary shaft	1
16	1969	Key way 5x5x30 BR	1
17	5506	Conical gear	1
18	5020	Bearing 6003 2RS	1
19	5507	Rotary holder gear	1
20	5139	Cylindrical pin Ø 6x10	1
21	5508	Cam	1
22	2693	Toothed wheel	1
23	1998	Nut Hm M12 Z	1



Rep	Order Ref	Description	Qty
1	4032B	Knotter jaw shaft	1
2	4081	1 core string knotter jaw assembled without shaft	1
7	2316C	Knotter + pin	1
8	5179	Screw CHc 4X 10 Z	3
9	1949	Washer Ø4	3
10	5504	Knotter housing	1
11	11023	Bronze bushing BP 25 8-11-20	1
11b	5084	Bronze bushing BP 25 8-11-12	1
12	5063	Knotter gear	1
13	2867	Pin Ø2x18	1
14	5160	Nipple M8	1
15	5240	Knotter housing + Bushing assembled	1
16	4084	Bearing	1
17	4086	Single core string knotter jaw set	1
18	4085	Single core string knotter assembled	1

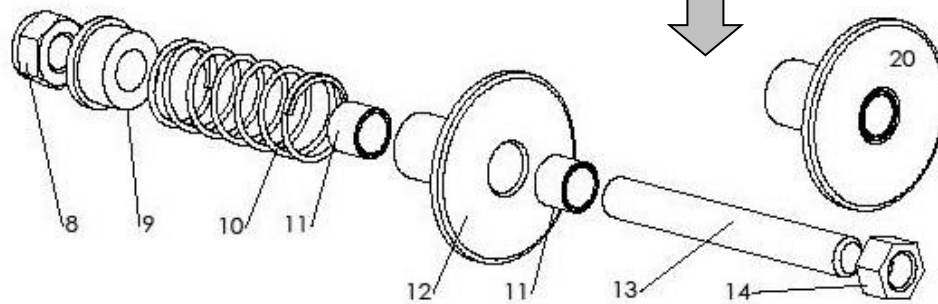


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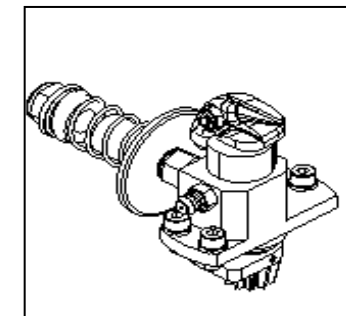


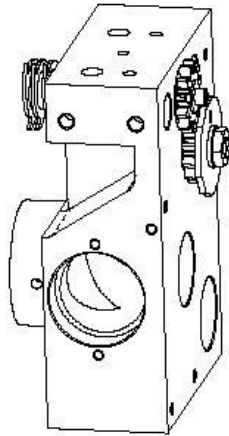
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Rep	Order Ref	Description	Qty	LEFT VERSION			
8	5207	Nut Nylstop M 8	1	Rep	Order Ref	Description	Qty
9	5287	Spring cup (Right)	1	1	5202	Nut Nylstop M 6	1
10	5286	Spring (Right)	1	2	5612	Spring cup (Left)	1
11	5107A	Bushing GSM 0810-08	2	3	5286A	Spring (Left)	1
12	5030	Knotter tightener (Right)	1	4	5107A	Bushing GSM 0810-08	2
13	5031A	Knotter tightener Shaft (Right)	1	5	5611	Knotter tightener (Left)	1
14	5250	Knotter tightener nut (Right)	1	6	5609	Knotter tightener Shaft (Left)	1
20	5239A	Knotter tightener with bushing (Right)	1	7	5610	Knotter tightener nut (Left)	1
30	4088	Assembled knotter unit 1 core string (Right)	1	21	2416A	Knotter tightener with bushing (Left)	1
				40	4089	Assembled knotter unit 1 core string (Left)	1
RIGHT VERSION							

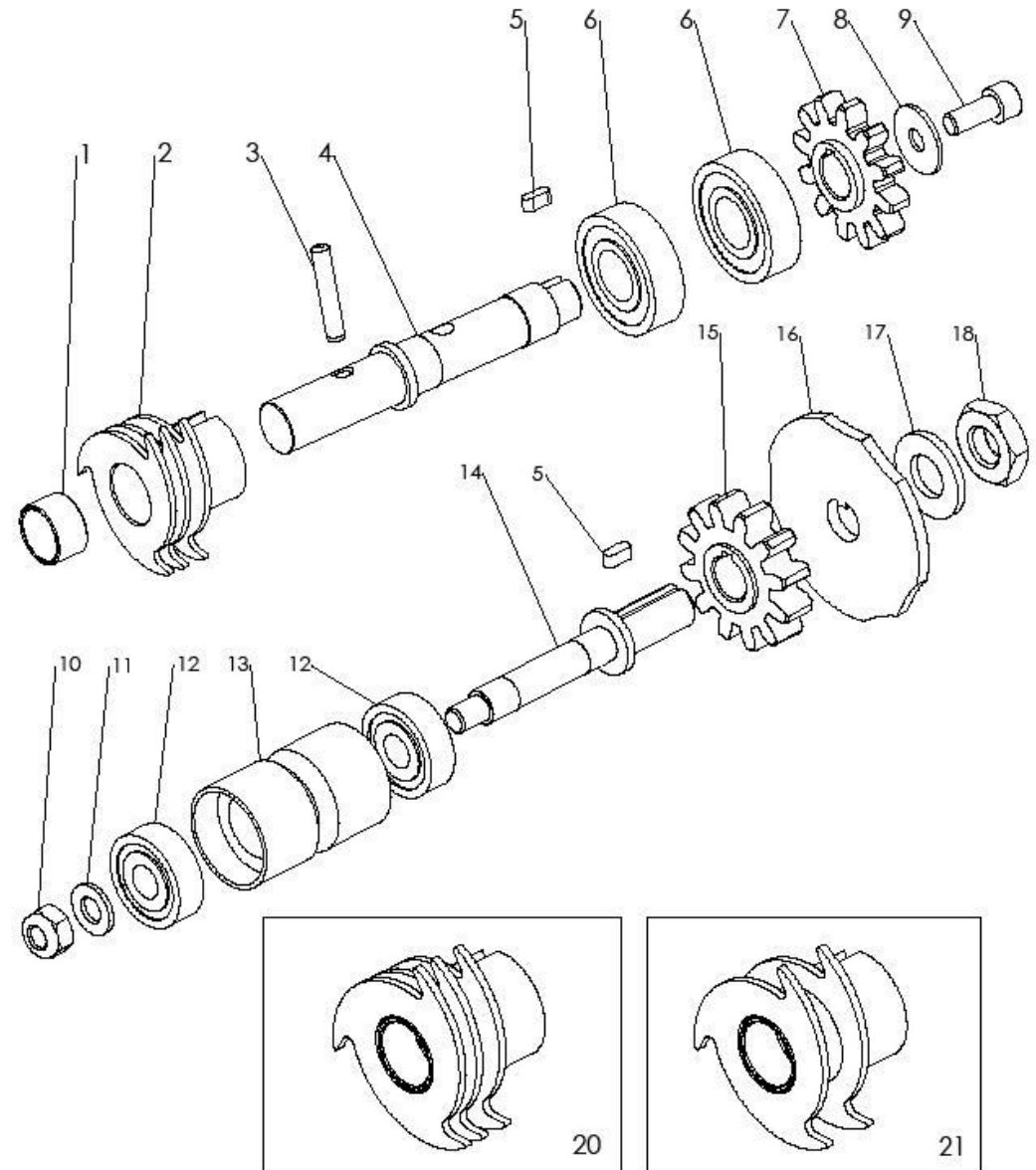


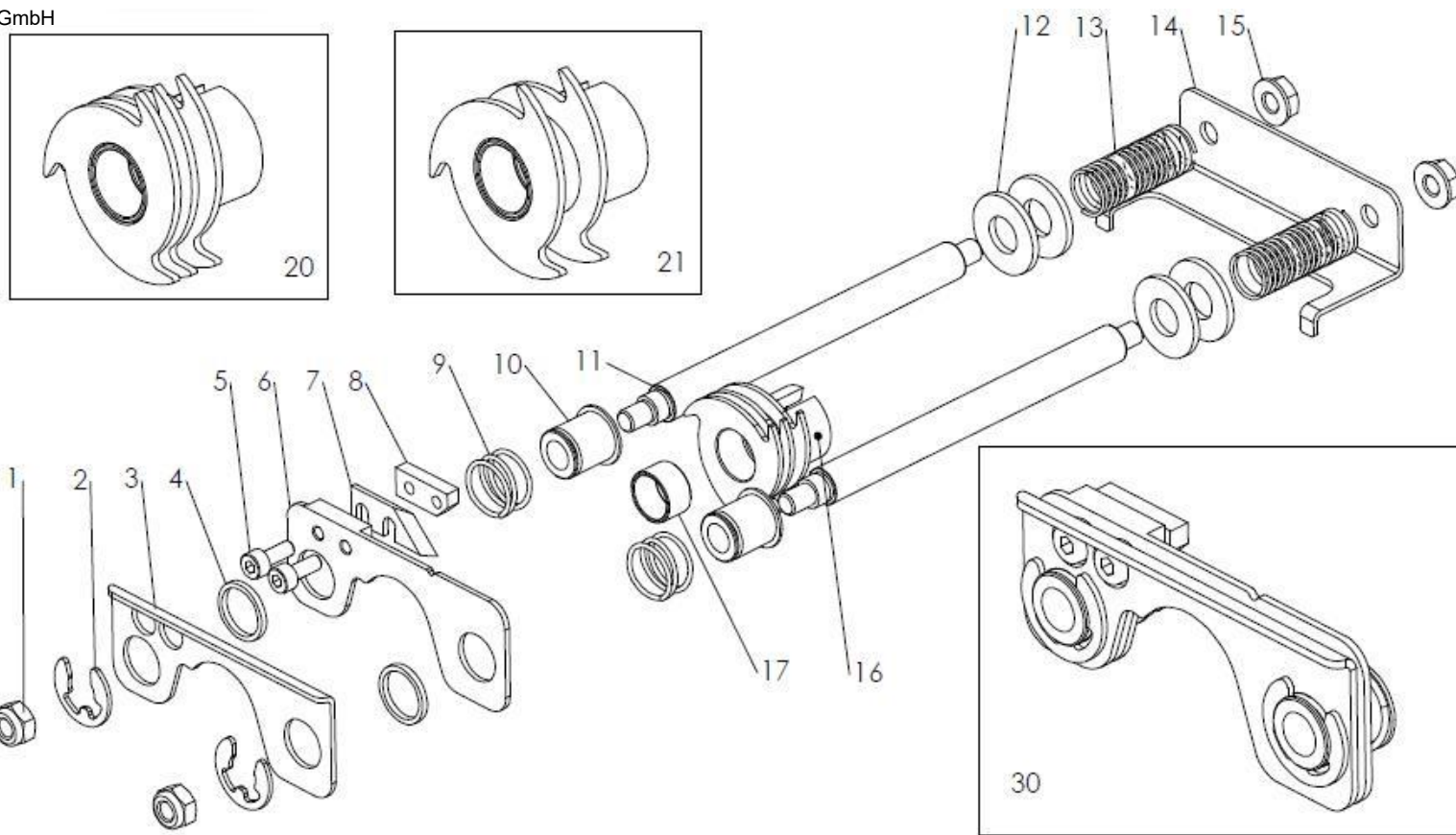
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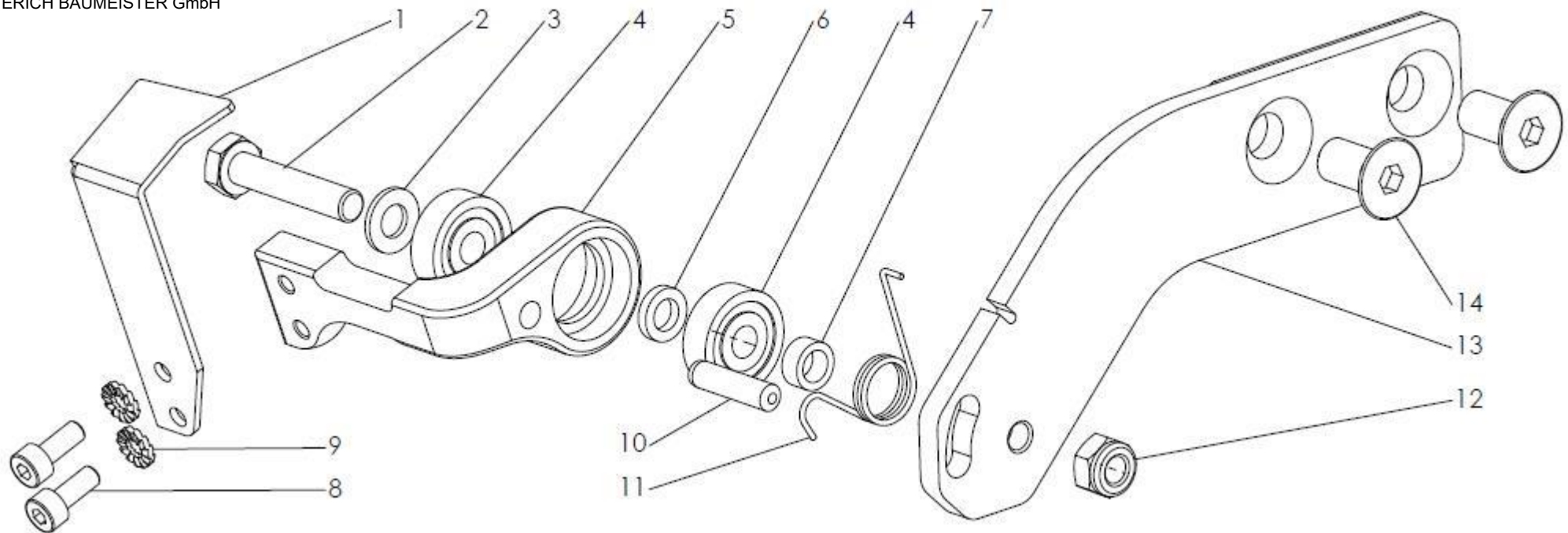
Rep	Order Ref	Description	Qty
1	5128A	Bushing JSM 1214-08	1
2	5015A	Rotary string holder 3 flange	1
2	2844	Rotary string holder 2 flange	1
3	5140	Pin G06 Ø 4 x 22	1
4	5521D	Rotary string holder shaft	1
5	5131	Key way 3x3x 7 BR	2
6	5038	Bearing 6001 2RS	2
7	5511	Rotary string holder gear	1
8	5195	Washer Ø 5 LU	1
9	1964	Screw CHc M5X 12	1
10	5202	Nut Nylstop M 6	1
11	2662	Washer Ø 6 MU	1
12	1966	Bearing 608 2RS	2
13	5520	Intermediate gear housing	1
14	5519B	Intermediate gear shaft	1
15	5509	Intermediate gear	1
16	5510	Rotary holder anti spinning cam	1
17	5212	Washer Ø 10 ZU	1
18	1965	Nut Hm M10 Z	1
20	2424A	Rotary holder 5015A +bushing	1
21	2845A	Rotary holder 2844 + bushing	1





Rep	Order Ref	Description	Qty
1	2152	Nut Serpress M6	2
2	2153	Circlips E type	2
3	5626	Front holder plate	1
4	5628	Spacer	2
5	5179	Screw Chc M4x10	2
6	5627	Rear holder plate	1
7	5034A	Knife	1
8	5524	Knife plate	1
9	5630	Spring	2
10	5629	Bushing holder plate	2
11	5525A	Shaft "elastic string"	2

Rep	Order Ref	Description	Qty
12	1963	Nylon washer Ø 10 MU	4
13	5583A	Spring	2
14	5526	Stopper plate	1
15	5202	Nut Nylstop M6	2
16	5015A	Rotary string holder 3 flange	1
16	2844	Rotary string holder 2 flange	1
17	5128A	Bushing JSM 1214-08	1
20	2424A	Rotary holder 5015A +bushing	1
21	2845A	Rotary holder 2844 +bushing	1
30	5631	Holder plates set	1



Rep	Order Ref	Description	Qty
1	5534C	Feed-in	1
2	1986	Screw H M6 x 30-20	1
3	1951	Washer Ø 6 ZU	1
4	1985	Bearing 626 2RS	2
5	5530B	Feed-in support	1
6	5533	Bearing spacer	1
7	5581	Spring spacer	1
8	5179	Screw H M 4x 10	2
9	1949	Washer Ø 4 ZU	2
10	1987	Cylindrical pin Ø 5x20	1
11	5582	Spring	1
12	5202	Nut Nylstop M 6	1
13	2780	Bracket	1
14	1984	Screw FHc M 8 x 16	2
20	2426	Complete bracket set	1

