



02 9452-3566

sales@getpacked.com.au

Automatic Strapping Machine 3-GPTD-601D

OPERATION MANUAL & SPARE PARTS LIST



READ ALL INSTRUCTIONS BEFORE OPERATING THIS PRODUCT

Explanations for Each Model NO. :

TP-601D1 : Standard Single Phase Model

TP-601D3 : Standard Three Phase Model

TP-601L1 : Low Table Single Phase Model

TP-601L3 : Low Table Three Phase Model



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PART I

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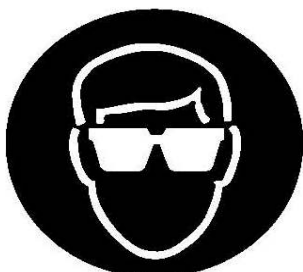
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1. Safety Instructions

(1) Before Operating

- a. Read the instruction manual.
- b. Wear eye protection and safety gloves before operating this machine.



Eye protection must be worn Safety gloves must be worn Ear-protector must be worn

- c. Verify that the power line voltage is correct.
- d. The machine must be properly grounded to avoid a shock hazard. All wiring must be in accordance with local wiring standards.
- e. The strapping machine can only be operated with polypropylene (P.P.) strapping; do not use polyester (PET) strapping or polyethylene (PE) cord strap.

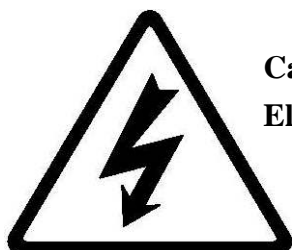
(2) During operating

- a. The weight of the package cannot exceed 100 kg (220 lbs),
- b. The size of the package should not be less than 130mm (width) × 20mm (high) (5.1" × 0.79").
- c. Check if the machine emits any smokes or unusual sound when it is running.
- d. Keep away from the inside of the arch while the machine is operating; do not put your hands or body into the arch when the machine is running.

(3) After operating

- a. Remove dust and dirt from the unit; pay particular attention to the interior of the arch.
- b. Turn off the power when the machine is not in use.

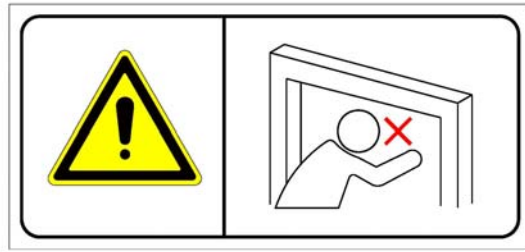
(4) Signs



Caution!
Electric Shock Hazard



Caution!
Hot!
Do not touch!



Warning for danger!
Do not put your hands or body into arch working area when machine is operating.

(5) Maintenance

- a. Turn off the power before removing either of the top covers.
- b. The heater tongue is very hot; do not touch it.

(6) Storage

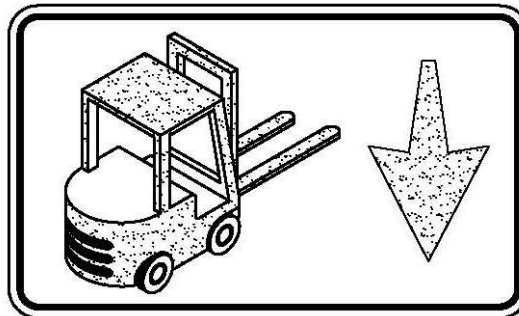
- a. The store room must be dry.
- b. Do not expose the machine to extreme cold or heat environment.
- c. Place the machine on an even floor in order to avoid any distortion.

(7) Other Reminders

- a. A operation manual must remain attached to the machine at all times.
- b. Do not alter the equipment or circuitry unless authorized to do so by the manufacturer.

(8) Attention

When the machine arrives in your warehouse, you need to use a forklift to take it off from the pallet. If you could go down to the bottom side of the machine, you would see an indication sticker as follows: (TP-601L)



Follow this sticker and lead the teeth of a forklift to that indicated position. After making few distance adjusting, you then could drive the teeth in and take off the machine.

2. Construction and Function of Units

a. TP-601D

1 Strapping head unit

This unit is the most important part of the machine for cutting and sealing of P.P.

2 Bandway unit

This is the arch track through which P.P. strap forwards or reverses.

5 Body frame unit

4 Reel unit

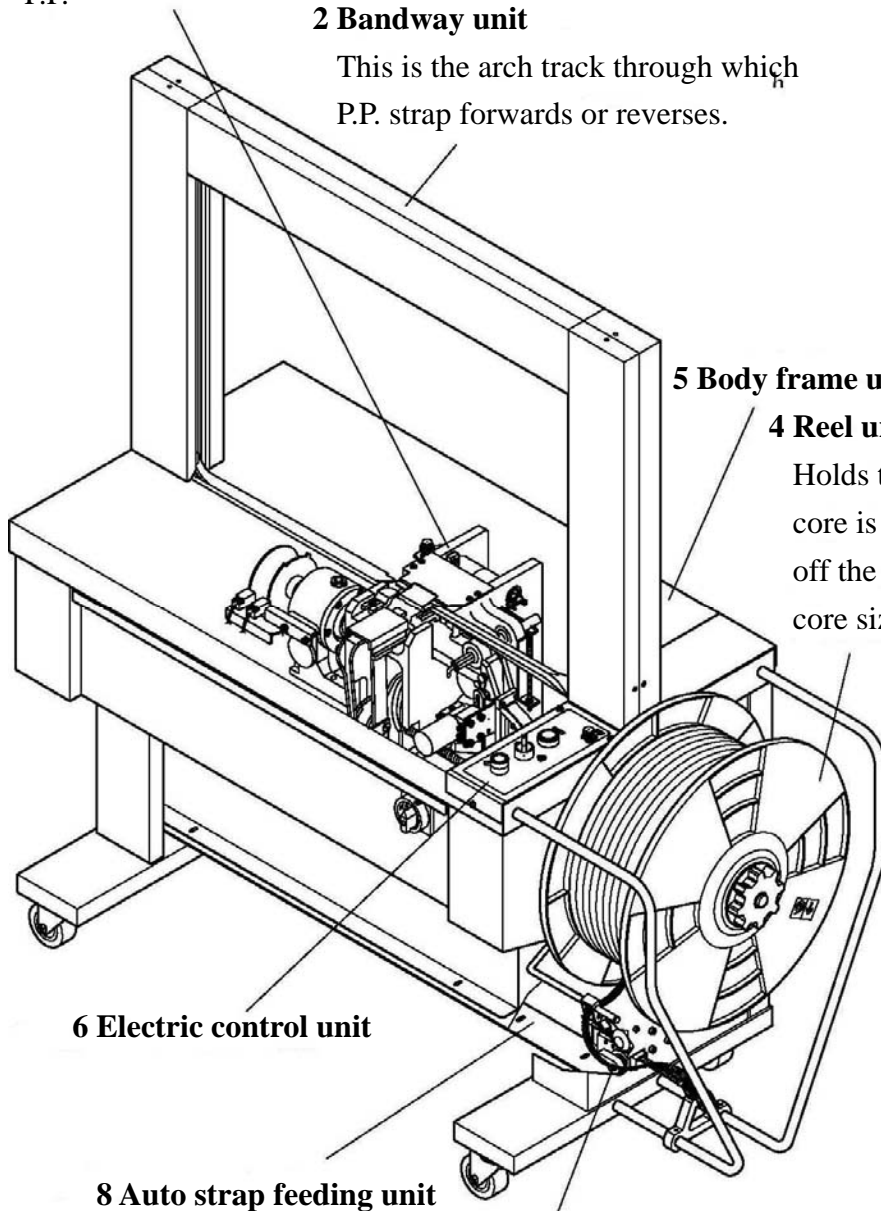
Holds the strap coil. (If strap core is 280mm, you can take off the center drum to have core size 200mm.)

6 Electric control unit

8 Auto strap feeding unit

3 Accumulator unit

This unit accumulates the quantity of strap required for smooth feeding into the chute track.



b. TP-601L

4 Reel unit

Holds the strap coil.

(If strap core is 280mm, you can take off the center drum to have core size 200mm.)

3 Accumulator unit

This unit accumulates the quantity of strap required for smooth feeding into the chute track.

2 Bandway unit

This is the arch track through which P.P. strap forwards or reverses.

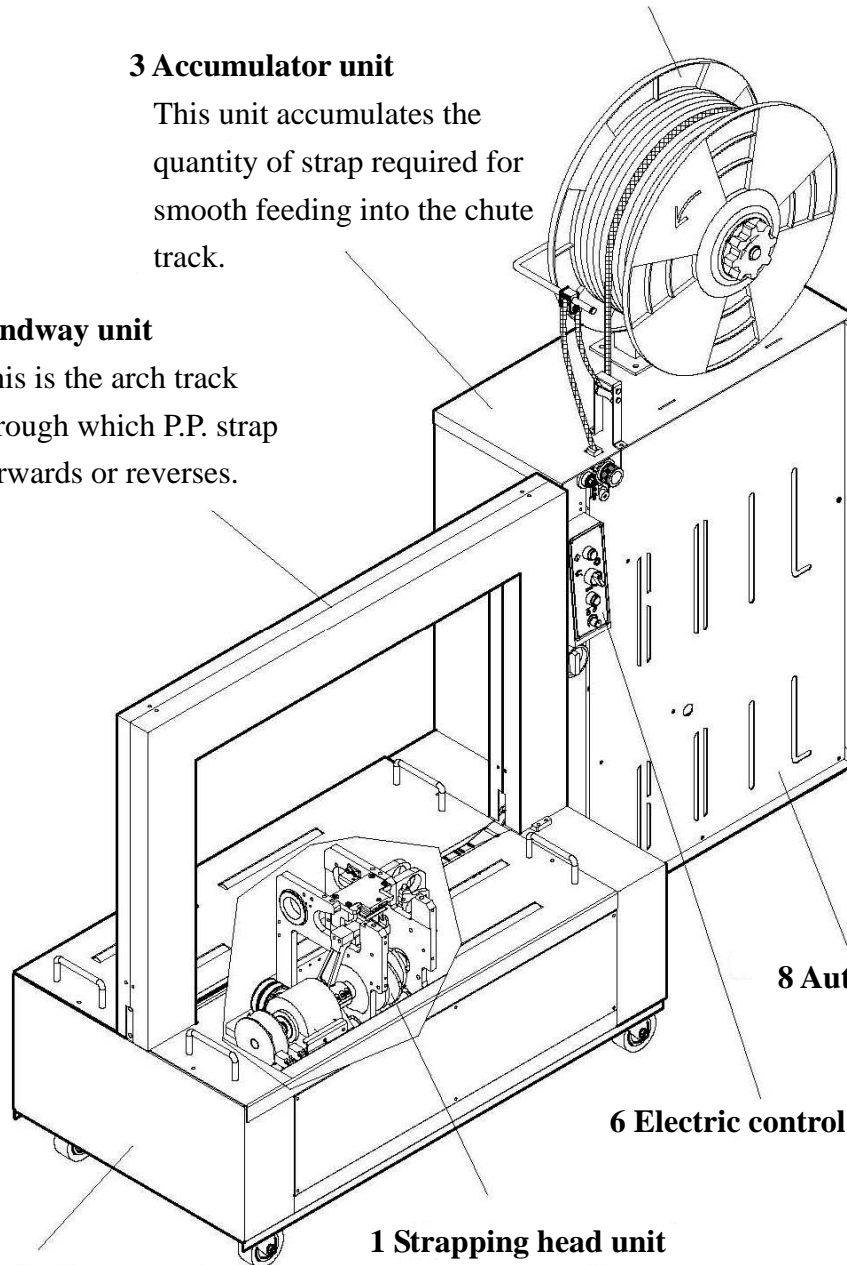
5 Body frame unit

1 Strapping head unit

This unit is the most important part of the machine for cutting and sealing of P.P. strap.

6 Electric control unit

8 Auto strap feeding



3. General Safety Remarks

(1) Basic Operation

The machine is only to be operated when in good running condition and in accordance with the instructions provided in the operation manual. Operators must be trained in proper operation and safety of the equipment.

The machine may only be operated in accordance with its designated use.

(2) Basic Safety Precautions

In addition to the instructions for operation, the user is to be instructed in all generally applicable legal or mandatory regulations relevant to safety or the environment.

Long hair, loose-fitting garments, or jewelry can be a safety hazard. These items must be secured prior to equipment operation.

Use protective equipment whenever appropriate or when required by law.

Carefully observe all safety instructions and warnings attached to the machine. Keep safety labels clean and legible.

People that are being trained to operate or service the equipment must be supervised by experienced personnel.

Any electrical work performed on the equipment must be conducted by a skilled electrician or under the supervision of a skilled electrician. All work must observe good electrical engineering practice and follow safety rules and local wiring standards.

(3) Safety Instructions Governing Specific Operational Phases

Avoid unsafe operation of the equipment.

The machine is only to be operated when it is in good running order. Only operate the equipment in a safe manner; all protective and safety devices must be in place and fully functional. This includes removable safety devices, emergency shut-off equipment, noise-protection devices and exhaust fans.

The machine is to be checked for damage and defects at least once each work shift. Any changes, including the working behavior of the machine, are to be reported immediately. If necessary, the machine is to be stopped and locked-out immediately.

In case of a malfunction, the strapping machine is to be immediately stopped and locked-out until the fault has been eliminated.

Before starting the strapping machine, make sure that the area is clear and safe.

Operating personnel need to be briefed before executing special operations and maintenance work; this work needs to be done with the proper supervision.

Always check and tighten connections after maintenance or repair.

After completing maintenance or repair, all safety devices must be replaced and checked for functionality before operating the equipment.

To minimize the environmental impact, all consumables and replaced parts must be disposed of safely.

Before starting the machine, check that the accessories have been stowed away safely.

Avoid operating the machine in a fashion that could upset its stability.

(4) Warning of Electrical Dangers

Electrical Energy

Immediately remove power to the machine in case of trouble in the electrical system. Replace a fuse with one with the same style and ratings; pay particular attention to matching the specified current.

Any electrical work performed on the equipment must be conducted by a skilled electrician or under the supervision of a skilled electrician. All work must observe good electrical engineering practice and follow safety rules and local wiring standards.

Inspect the electrical equipment of the machine at regular intervals. Tighten any loose connections. Check wiring for scorch marks; replace scorched wiring and determine and correct the reason for the overheating.

When working on live equipment, ensure that a second person is available to cut power in case of an emergency. When appropriate, secure the working area with safety tape and a warning sign. Use insulated tools for electrical work.

Before working on high-voltage assemblies, turn off the power supply. Carefully discharge the supply cable and short-circuit any energy-storage components such as capacitors.

If the equipment was moved, carefully refit and refasten all parts removed for transport before reapplying power.

Before moving the machine, remember to disconnect the power cable.

(5) Grounding Instructions Shall Include the Following

This product must be grounded. In the event of an electrical short circuit, grounding reduces the risk of electric shock. This product is equipped with a cord that has a grounding wire and an appropriate grounding plug. The plug must be plugged into an outlet that is properly installed and grounded in accordance with all local codes and ordinances.

If repair or replacement of the cord or plug is necessary, connect the ground wire to the ground terminal of the plug. The wire with green insulation (with or without yellow stripes) is the grounding wire.

Check with a qualified electrician or service person if the grounding instructions are not clear or if in doubt about the proper grounding of the machine. Do not modify the plug provided; if it will not fit the power outlet, have the proper outlet installed by a qualified electrician.

DANGER!

Improper installation of the grounding can result in electrocution.

4. Machine Information

(1) Areas of Application and Machine Description

This plastic strapping machine can be used for all types of strapping applications with package sizes of 130 mm(width) × 20 mm(height) and up.

This machine is particularly suitable for heavy packaged goods as well as printed products, boxes, etc.

Machine Description

Automatic plastic strapping machine for use with polypropylene strapping

Extra tough construction

Simple, safe and user-friendly operation

Automatic feeding-system

Automatic strap-end detection

Loop ejection

Mobile, with large table area and high capacity strap reel

Table surface made of stainless steel

Strap tension adjustable from soft to extremely high

Environment Information

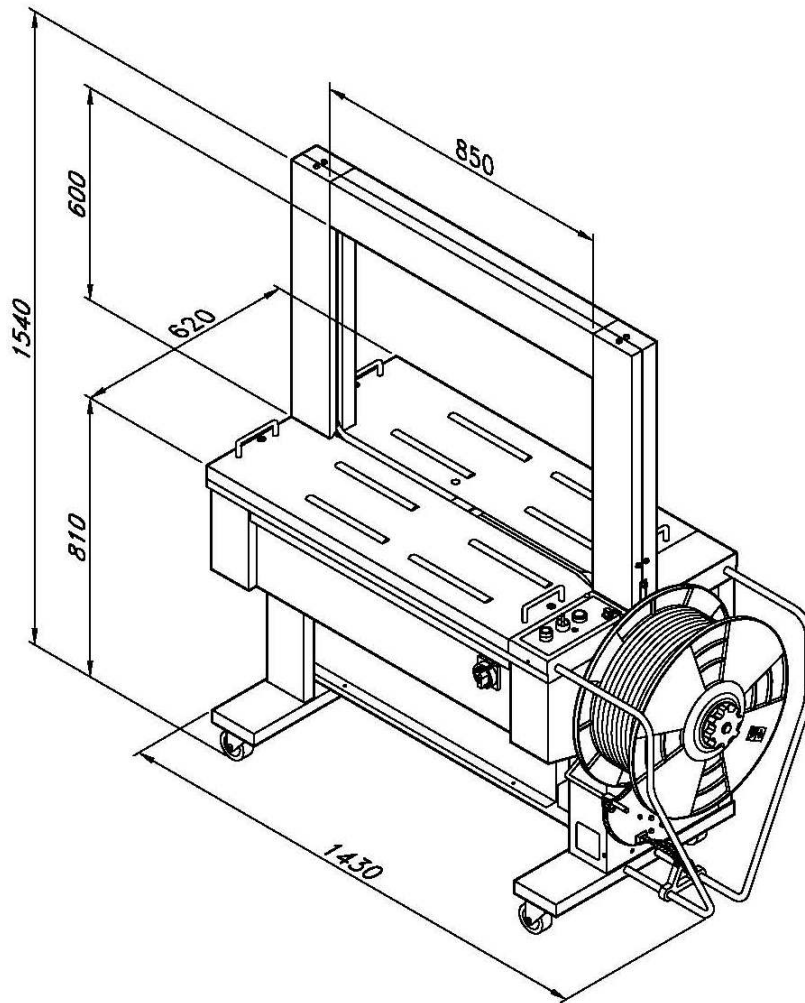
The strapping machine shall be installed in the following conditions:

- Supply voltage: 0.9 - 1.1 nominal supply voltage
- Source frequency: 0.99 - 1.01 nominal frequency
- Ambient temperature: 5°C - 40°C (41°F-104°F).
- Relative humidity: not exceed 50% at 40°C.
- Please provide a suitable illumination around the machine for safety operation.



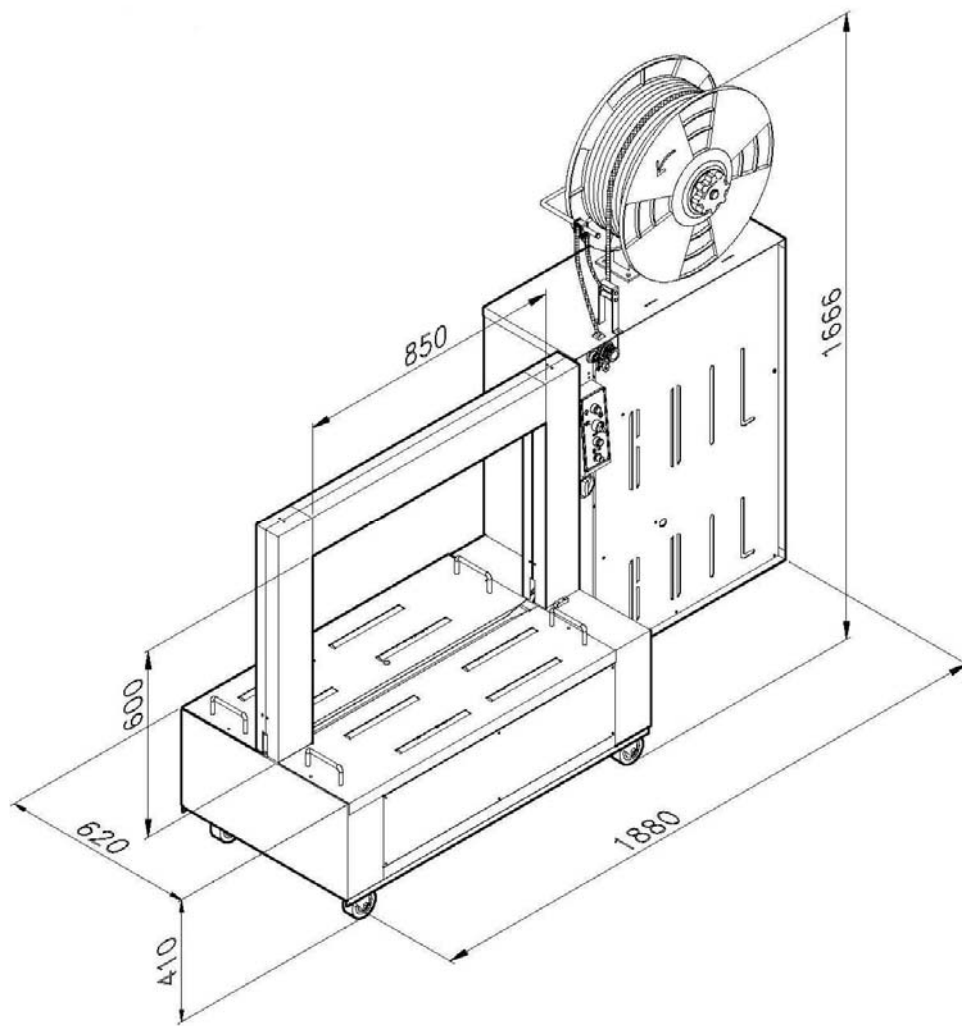
(2) Technical Data

a. TP-601D



Sealing method :	Heat
Strap width :	8 mm to 12 mm (3/8" - 1/2")
Strap thickness :	0.55 mm up to 0.75 mm (0.022" - 0.03")
Strap reel diameter :	200 mm (8" nominal)
Width :	1430 mm (56.3")
Depth :	620 mm (24.4")
Table height :	810 mm (31.9")
Electrical connection :	AC 110V/220V/230V/240V (50/60Hz), 1PH AC 220V/380V/400V (50/60Hz), 3PH
Weight :	220 kg (485 lbs.)
Noise emission :	83 dB (A)
Ambient temp :	5°C ~ 40°C (41°F ~104°F)

b. TP-601L



Sealing method :	Heat
Strap width :	8 mm to 12 mm (3/8" - 1/2")
Strap thickness :	0.55 mm up to 0.75 mm (0.022" - 0.03")
Strap reel diameter :	200 mm (8" nominal)
Width :	1880 mm (74")
Depth :	620 mm (24.4")
Table height :	410 mm (16.1")
Electrical connection :	AC 110V/220V/230V/240V (50/60Hz), 1PH AC 220V/380V/400V (50/60Hz), 3PH
Weight :	235 kg (518.1 lbs.)
Noise emission :	83 dB (A)
Ambient temp :	5°C ~ 40°C (41°F ~104°F)

(3) Control Panel

① Start Switch

This is the switch to start a strapping operation. A strapping cycle is completed only after actuation of this switch. (Indicator for strap goes to ready position)

② Reset switch

This is the switch to activate auto strap feeding. In addition, it is used for troubleshooting. If the strap is mis-fed, you can push this button to solve the problem.

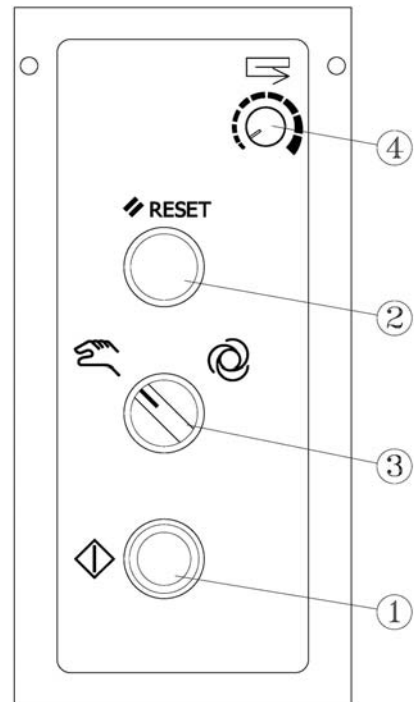
③ @/👉 selector switch

While selector switch is placed to the position @ , the machine will automatically strap the package when it is placed on the table and passes the chute arch, if the package remains under the arch, the strapping cycle will continue. While the selector switch is placed to the position 👉 , after positioning the package under the arch, push the "START" switch, then one strap will be applied.

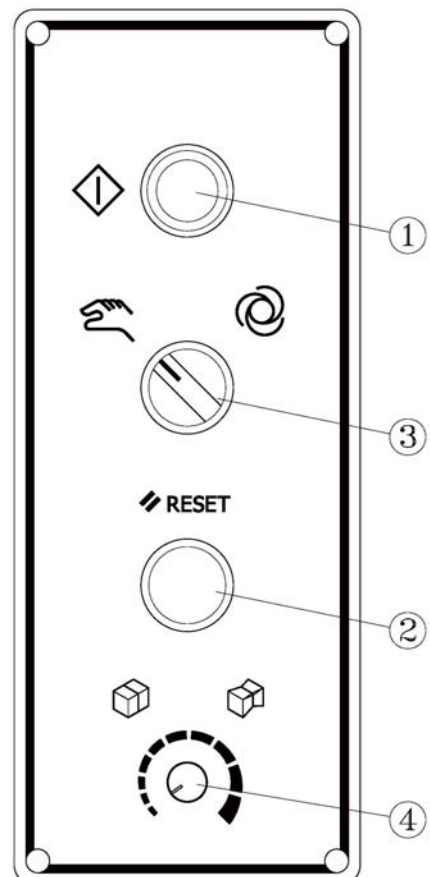
④ Tension Adjustment Knob

External adjustment of strap tension by step-by-step rotation of this knob.

TP-601D



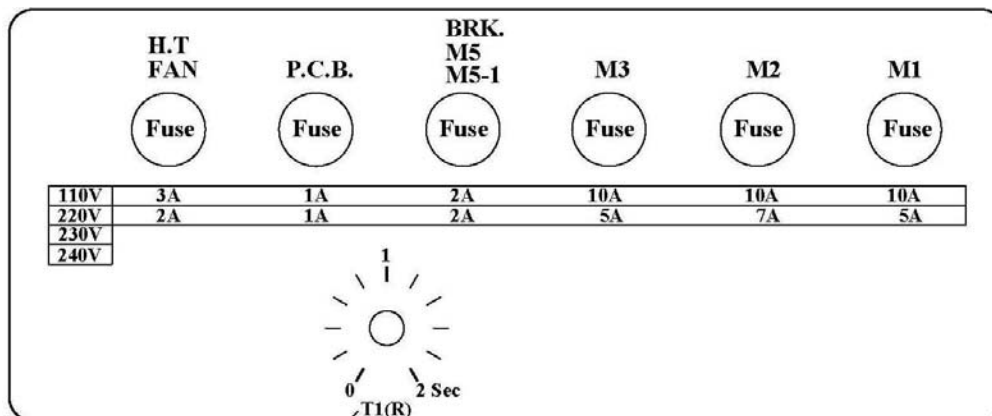
TP-601L



(4) Electric Control Unit

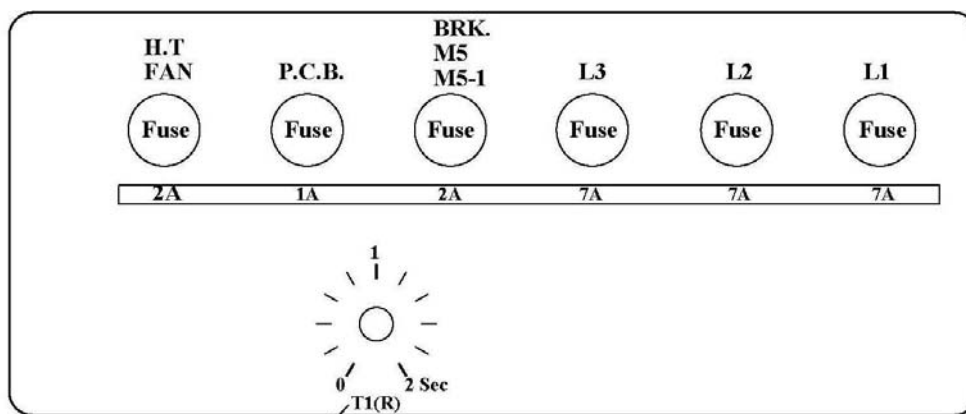
Timer, T1 (30) :

T1 timer determines the time necessary for strap take-up. While setting, please test with the minimum sized package. Normally, Timer T1 is set at about 0.5 second, but may have to be adjusted depending on arch size & actual package size.



TP-601D1

TP-601L1



TP-601D3

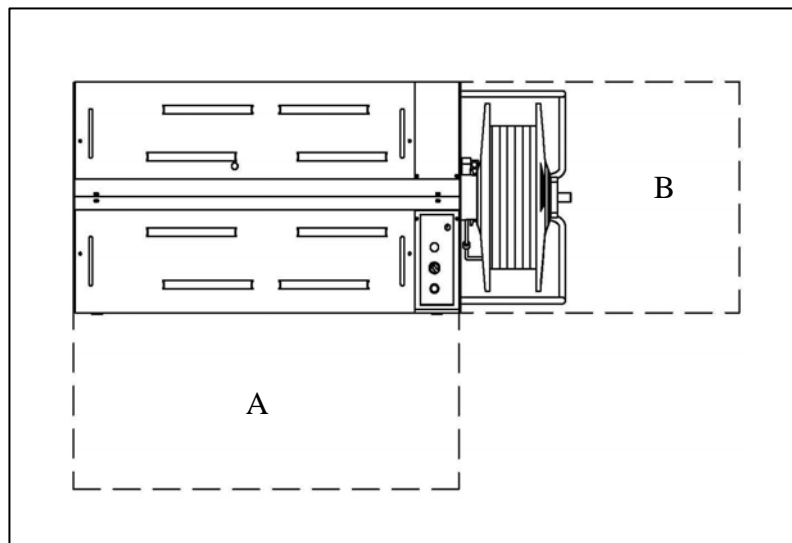
TP-601L3

5. Operating the Machine

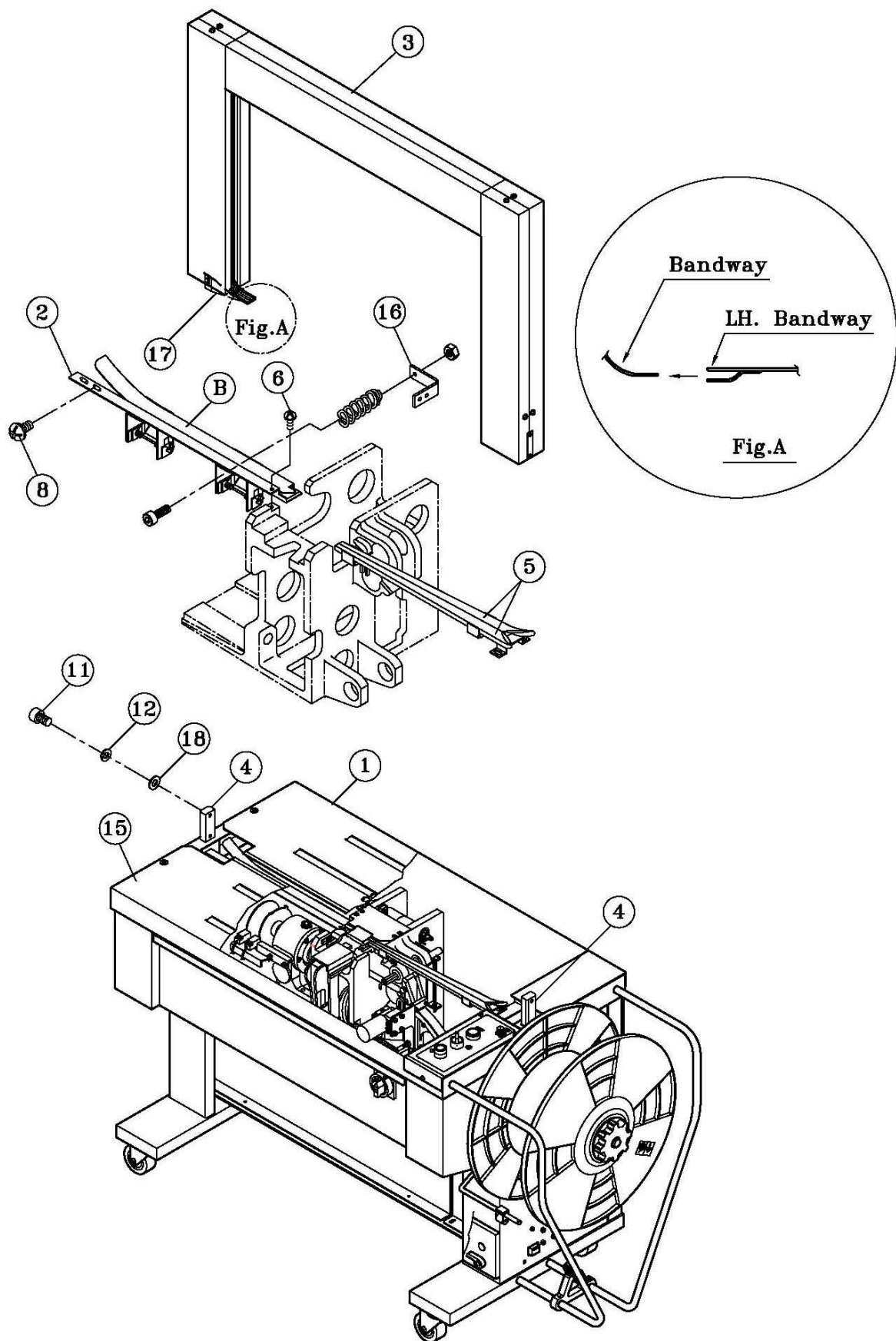
(1) Operation Space

Keep the area (A) and (B) free for the operator.

The area (A) is necessary for operation strapping machine and the area (B) is necessary for changing the strap or adjusting strap amount in the accumulator.



(2) Installation of Arch Unit (For TP-601D)



a. Take the upper table ① , ⑮ off.

b. Take the LH bandway ② off.

⑥ TMS, M5×8 1PC

⑧ TMS, M6×8 2PC

⑪ HBS, M8×15 4PC

⑫ SW, M8 4PC

⑰ PW, M8 (A) 4PC

c. Slide the arch unit ③ into the fixing brackets ④ and fix both sides of the arch frame with ⑪ ⑫ ⑰.

* Please note that is imperative to open the flaps of RH bandway ⑤ to protect them when installing the arch unit in. (open the flaps, before inserting the arch unit in)

d. Set the LH bandway ②, with ⑥ and ⑧.

d-1. Please note that the arch bandway (refer Fig. A) should be positioned between LH bandway and its fixing bracket.

d-2. Please set the LH bandway ② closely to ⑰ guiding angle (PART NO. T6-2-21260).

d-3. Push the ⑰ Band guide Spring Bracket backward to check if B will be automatically turned open. If so, the installation is OK.

e. Position the upper table ① ⑮ onto the machine body.

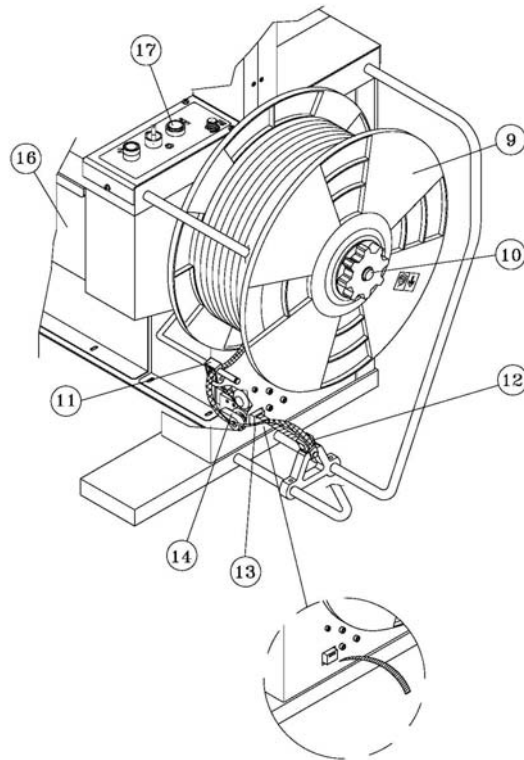
(3) How to Load P.P. Strap

a. TP-601D

- Ensure that the power switch is turned off before loading P.P. strap.

Step 1

Place a strap coil on the reel drum in according to the arrow direction as indicated on the Reel Out Circular ⑨. After placing it, put the Reel Out Circular on the strap coil and tighten it by the Reel Nut Handle ⑩.



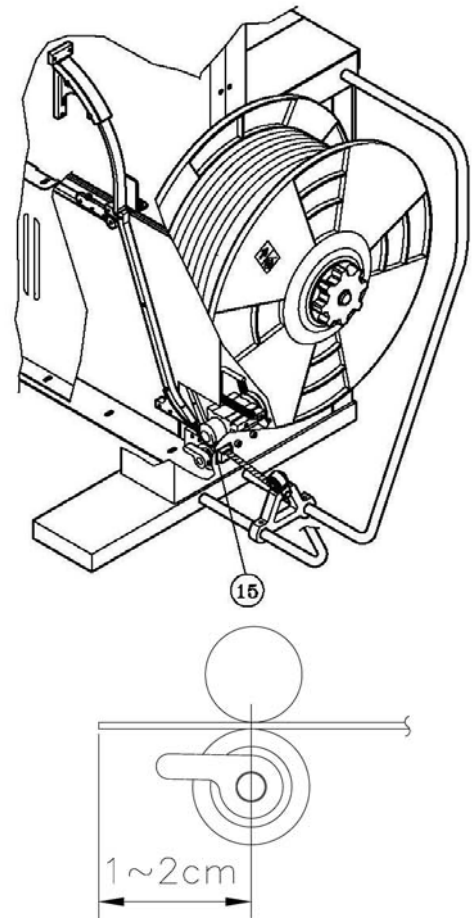
Step 2

Thread the tip of P.P. strap into the Band Guide Roller ⑪. After that, push it through the Free Angle ⑫.

At this moment, twist the strap so that the inside part of the P.P. strap turns out downward and outside surface touches on the roller. See the drawing.

Step 3

Insert P.P. strap into the Pool Feed Shooter ⑬, pushing the lever ⑭ down and feed P.P. strap about 1-2 cm beyond Pool roller ⑮



Step 4

Turn on the power supply switch, and then push Reset Switch ⑰. After about 4 seconds, the strap will automatically go into the arch and pool.

b. TP-601L

- **Ensure that the power switch is turned off before loading P.P. strap.**

Step 1

Place a strap coil on the reel drum in according to the arrow direction as indicated on the Reel Out Circular ⑨. After placing it, put the Reel Out Circular on the strap coil and tighten it by the Reel Nut Handle ⑩.

Step 2

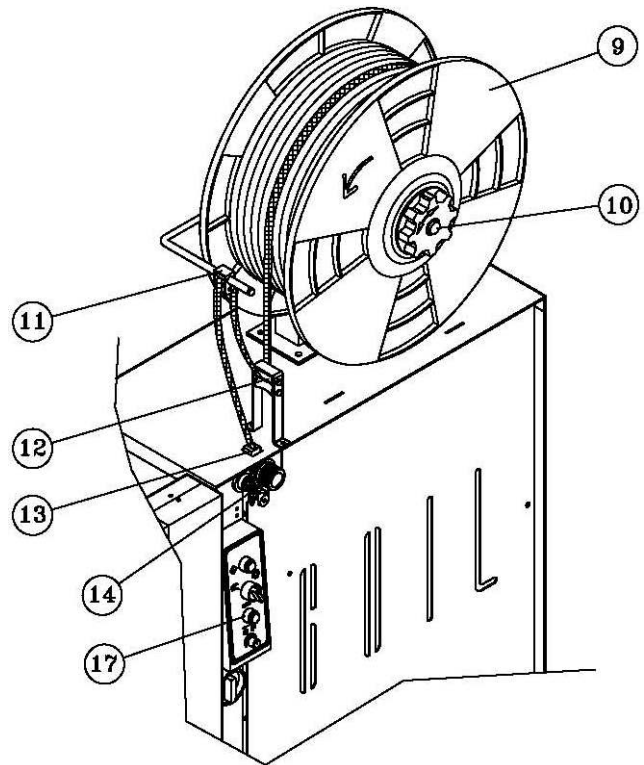
Thread the tip of P.P. strap into the Roller Bracket Ass'y ⑫. After that, thread it through the Band Guide Roller ⑪.

Step 3

Insert P.P. strap into Pool Feed Shooter ⑬ and turn Accumulator Main Roller ⑭ until the P.P. strap about 1-2 cm beyond the Main Roller ⑭.

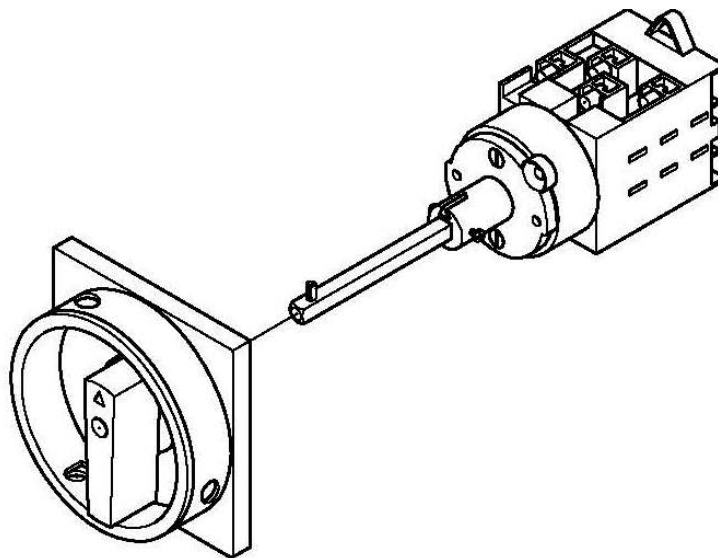
Step 4

Turn on the power supply switch, and then push Reset Switch ⑰. After about 4 seconds, the strap will automatically go into the arch and pool.



(4) How to Operate

- a. Turn on the Main power switch (make a 90-degree clockwise turn). The front door will be locked at the same time. [If you want to open the front door, turn off the main power switch first (make a 90-degree counterclockwise turn). In this way, the operator can open the front door without risk.] (See drawing below)
- b. Wait for about 3 minutes until the heater element reaches its required operating temperature.
- c. Place a package in the middle of the chute.
- d. Set tension with Tension Adjustment Knob (VR)(see page part I P11 ④)
- e. Push start switch (see page part I P11 ①) or actuate foot pedal switch to start strapping. The strapping operation is repeated if the start switch is pushed again.



6. Adjustments

(1) Heater temperature mechanism

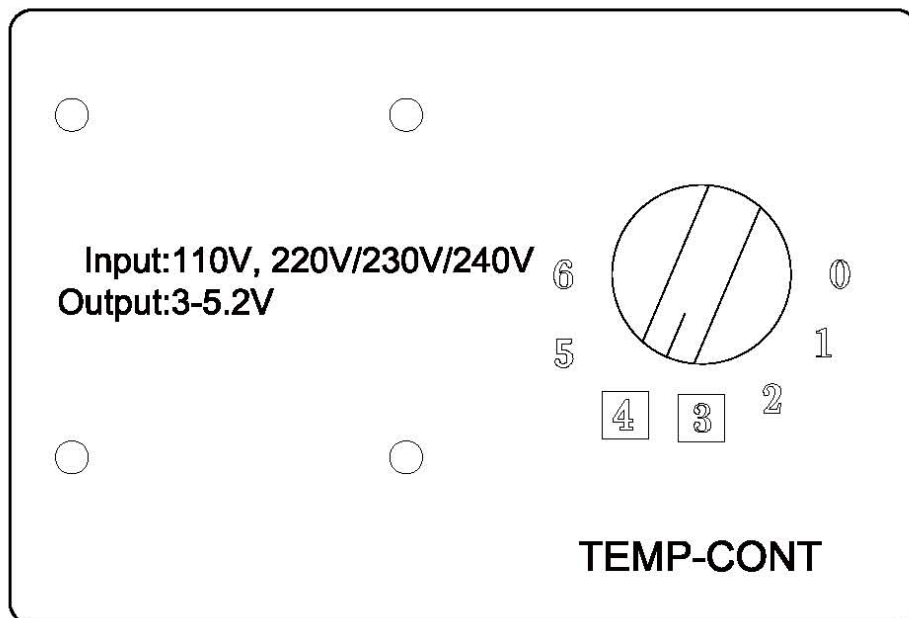
Set the knob to position 3 or 4

Adjust the heater temperature by selecting a value between 1 and 6.

Choose the suitable temperature, bearing in mind the environmental conditions of the machine.

If the heater temperature is too high or too low, a proper seal will not be obtained.

Gradually increase or reduce the heater-knob value until obtaining an optimum seal.



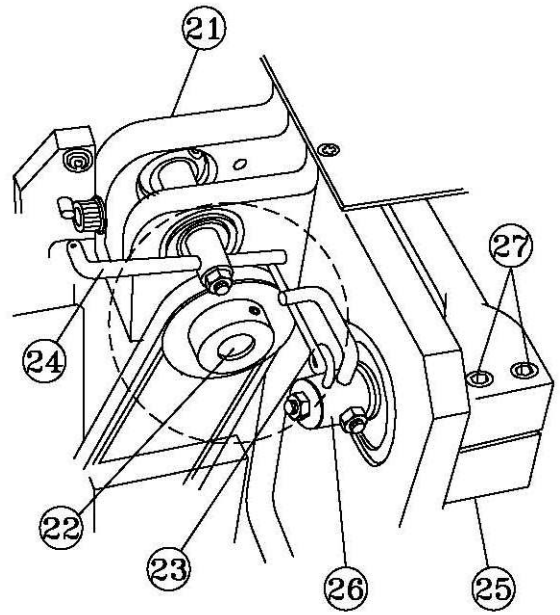
(2) Feed and take-up mechanism

If this unit is not correctly adjusted, strap feed and take-up will become irregular.

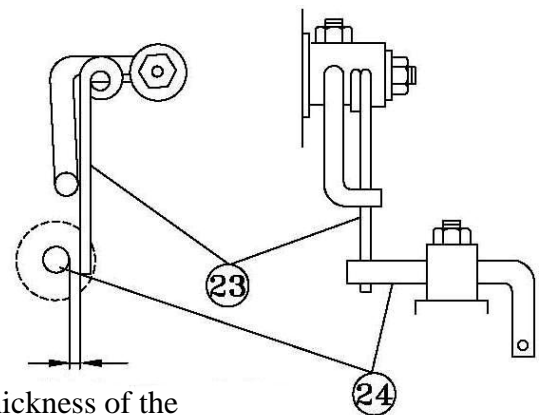
Normally, this unit is set to accept P.P. strap with the thicknesses of 0.55mm-0.75mm. If a different strap thickness is used, adjust the section marked by a circle in the drawing so that the clearance between the Upper Roller Spring

②③ and the Upper Shaft Spring Hook ②④

should be the thickness of the strap you are using. Strap can only be taken up properly if this unit is precisely adjusted. (If not, strap will be sealed before being tightened around the package) Moreover, strap will leave the chute arch track when feeding into it if there is no clearance.



- Check if the control unit returns to its original position. Insert the strap between Feed Roller ②② and Upper Feed Roller ②①.
- Loosen 2 Bolts ②⑦ holding the right-hand Block Arm ②⑤ with the Press Arm Shaft ②⑥. Press Arm Shaft can then easily be moved by hand.
- Adjust so that there is a clearance between the Upper Roller Spring ②③ and the Upper Shaft Spring Hook ②④ the same as the thickness of the strap you are using.
- Tighten 2 Bolts ②⑦ .



The thickness of the strap you are using

(3) How to adjust LS3, LS2

Figure 1: LS-3 Home Position

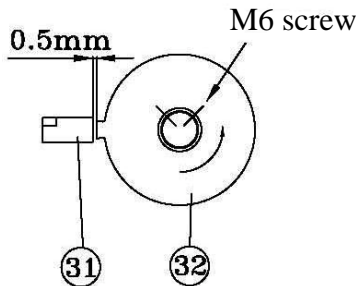


Figure 1-1

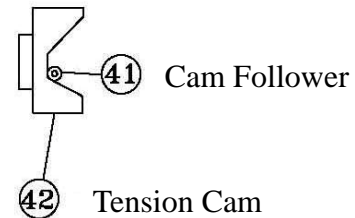


Figure 1: LS-2

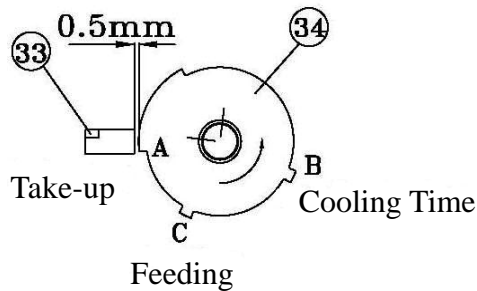


Figure 2-1

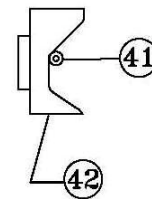


Figure 1 shows the correct position for LS3 Proximity Sensor (31) and the Limit Switch Cam (32) while the machine is in home position.

The machine will stop as soon as the LS3 Proximity Sensor (31) detects that Limit Switch Cam (32) is activated. At this time, the Cam Follower (41) must stop at the corner position on the Tension Cam (42) as shown in **figure 1-1**. If not, please adjust according to the following instructions.

Adjustment

If Cam Follower (41) stops *before* the correct position:

- Loosen the two M6 screws and turn the Cam Roller slightly clockwise, then tighten the M6 screws.
- Reset the machine and allow it to cycle again to ensure that the Cam Follower (41) stops at the correct position.
- If the problem has not been eliminated, please repeat the "Step One" until the Cam Follower (41) stops at the correct position.

If Cam Follower ④① stops beyond the correct position:

Please also loosen the M6 screws but turn the Cam Roller slightly counterclockwise until the Cam Follower ④① stops at the correct position.

Figure 2 shows the correct position for LS2 Proximity Sensor ③③ against the lobes of the Limit Switch Cam ③④ while machine is running.

When LS2 Proximity Sensor ③③ detects Lobe A of the activated running Limit Switch Cam ③④, the machine will stop about 0.3 seconds so that the machine can switch to take-up. In the meantime, Cam Follower ④① has to stay on the corner position of the Tension Cam ④② as shown in figure 2-1. If the Cam Follower is not at the correct position, please make the same adjustment as for LS3.

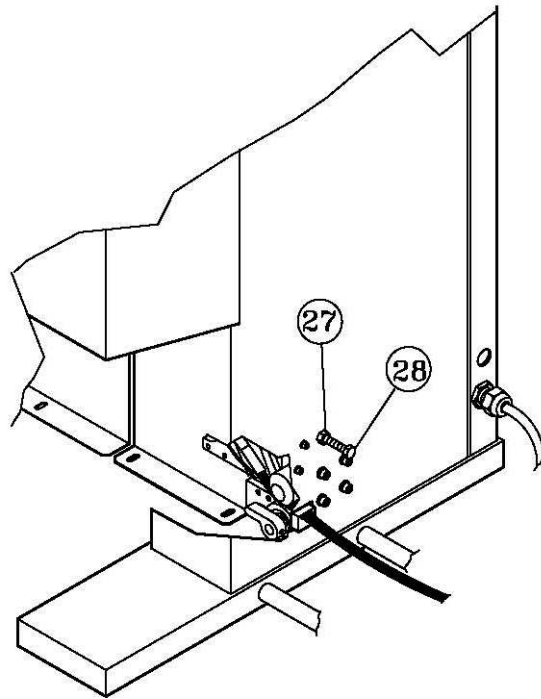
(4) Amount of strap in Accumulator Box

a. TP-601D

The machine has already been set in its Accumulator Box.

However, some adjustment may be required, depending on the actual quality or thickness of the strap used. If adjustment is necessary, proceed as shown in the following drawing.

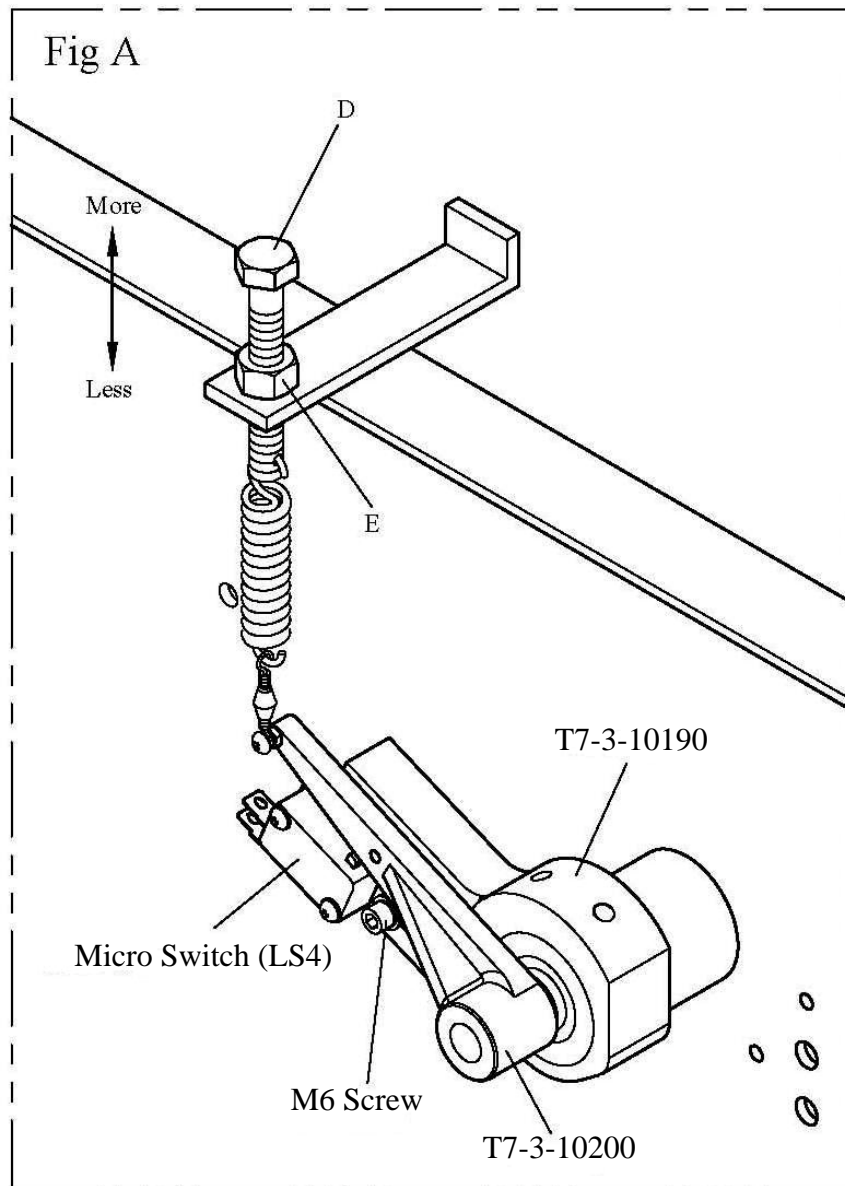
- a-1. In case that there is an insufficient amount of strap in the Accumulator Box, loosen the Nut (27) and turn the Screw Bolt (28) counterclockwise.
- a-2. In case that there is an excessive amount of strap in the Accumulator Box, loosen the Nut (27) and turn the Screw Bolt (28) clockwise.



b. TP-601L

Fig A:

If you have moved the LS4 Micro Switch to the left up to the bottom but you still do not have enough P.P. strap in the accumulator box, you can loosen nut E and turn the bolt D C.C.W. increase the amount of P.P. strap in the accumulator box. Finally tighten the nut E.



7. Maintenance

Warning:

Before any maintenance or repairs on the machine, set the Main Power Switch to "O" (OFF). Wait about 5 minutes for cooling down the heater to avoid burns with this area.

(1) Cleaning and Lubrication

The high reliability and long service life of the strapping machine will depend on regular cleaning and maintenance.

ATTENTION!

All the important strap transport components, such as the feeding rollers and the strap guides, must be kept free from oil and grease. (lubricant)

The lubricant has to be non-resinous.

The lubricant is SAE 30

(2) Maintenance

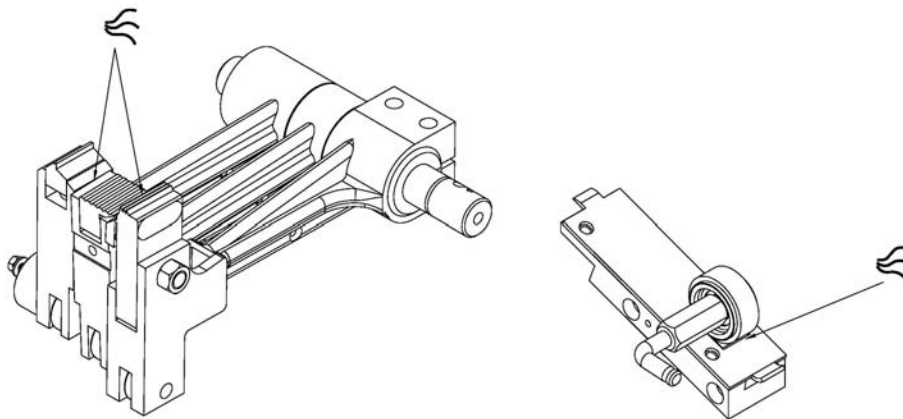
Only use original spare parts supplied by manufacturer.



Daily:

Use air gun to clean the circled positions (nearby the cutters, strap guide and accumulating feeding rollers) daily

Remove plastic residue in the machine.



Monthly :(or 50,000 strapping cycles)

Clean both sides of heater plate and polish with fine sandpaper if necessary

ATTENTION: Make sure the welding plate is cool first!!

Check supporting and cam rollers of strapping head for easy movement. The slide table must be moved back to home position automatically by the spring tension.

Be sure to clean any debris in the tension jaw.

6 Months: (or 300,000 strapping cycles)

Check heater plate, replace and readjust it if necessary.

Check strap cutter in strapping head, replace it if necessary.

Check that connector at wiring loom to printed circuit board is firmly fixed.

Make machine ready for operation. Strap one bundle manually several times, paying attention to mal-functions, repeat procedure.

Check strap accumulating function. Do proper adjustments to accumulating feeding pressure or the reel brake belt

1 year :(or 600,000 strapping)

Replace deflection roller if it shows visible changes.

In case of loud noise at bearings: locate them, replace the bearings.

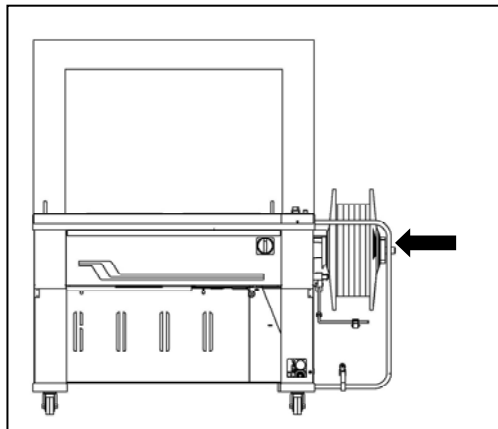
Get machine ready for operation again, strap one bundle manually several times, paying attention to malfunctions.

NOTE: Any other service must be performed by an authorized service representative.

8. How to Safely move the Machine

- a. Before moving the machine, be sure to unplug the power cord and put it in safe place to avoid any damage.
- b. Moving the machine by holding the Reel Guard to pull or push the machine.

Note: Don't move the machine by pulling or pushing the arch unit.



9. Troubleshooting

(1) Incorrect strap feed and take-up

Probable Causes	Remedy
a. Incorrect strap threading direction on reel holder	a. Reload strap correctly (see page 16)
b. Incorrect loading of strap	b. Check if strap is twisted in loading section (see page 16)
c. Strap gets in between strap coil and Reel Flange	c. Reload strap
d. Insufficient or excessive strap	d. Adjust amount of strap accumulated (see page 23)
e. Dust and strap residues in Feed Unit	e. Check and clean unit
f. Strap end is split	f. Adjust Cutter Tension Spring or change cutter
g. Loose strap at Reel Unit	g. Adjust or change Brake Tension Arm Spring
h. Strap jumps out of arch track	h. Adjust F/R mechanism (see page 20)
i. Poor quality of strap	i. Cut off the damaged part of strap or change the roll
j. Improper positioning of package on Table Top	j. Replace the package in the center of the Sealing Head

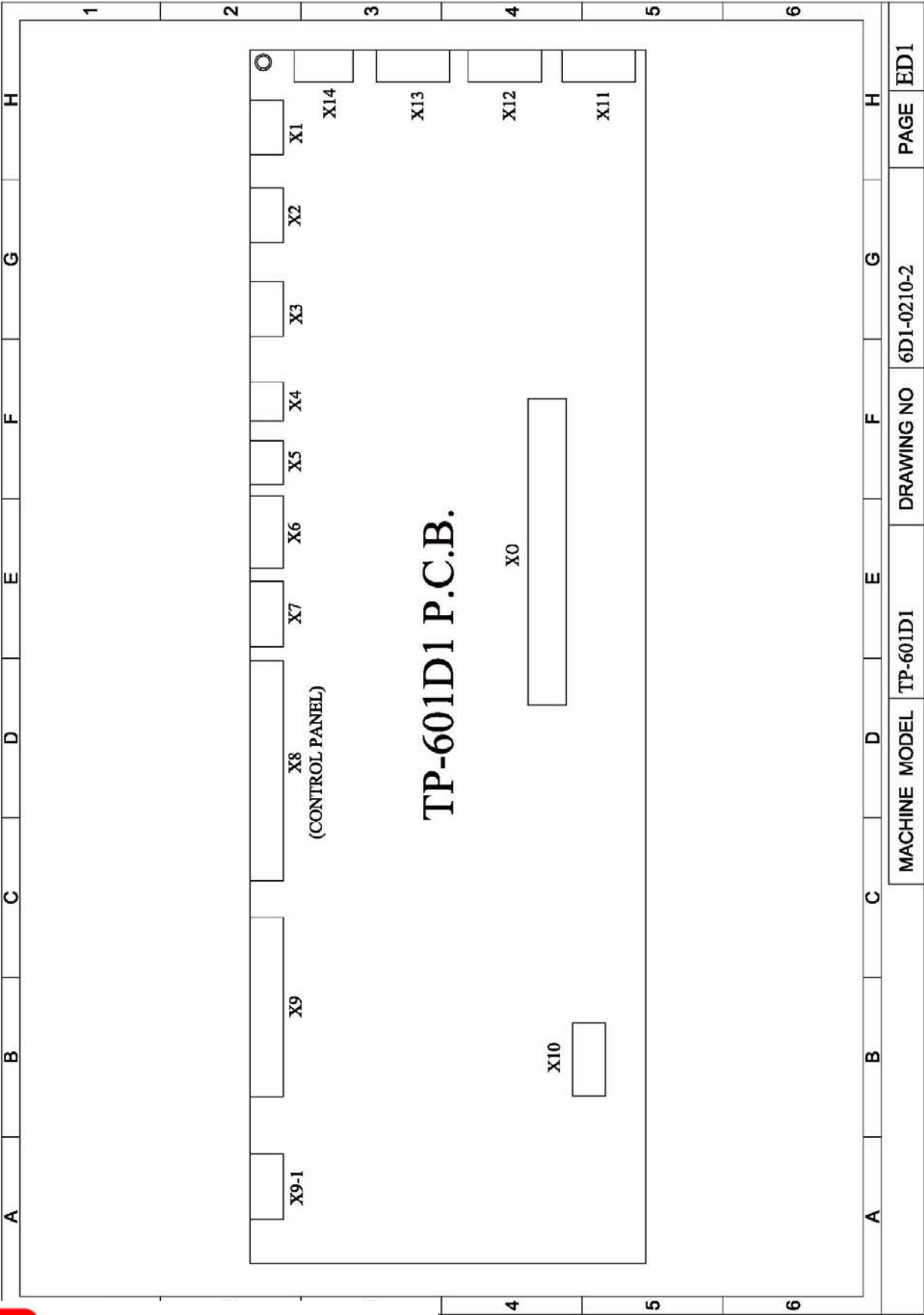
(2) Strap unsealed

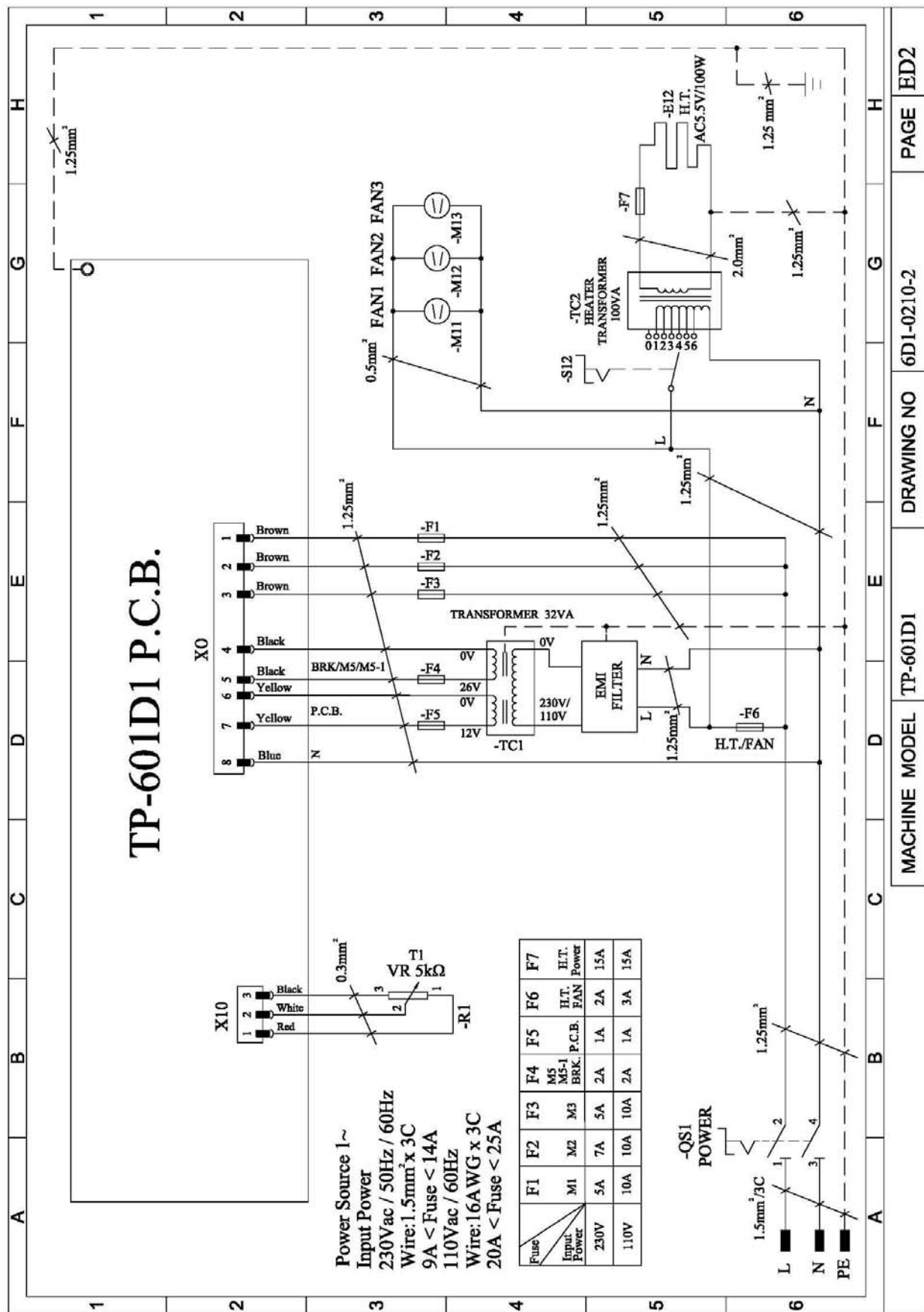
Probable Causes	Remedy
a. Wire inside or outside of Heater is broken, loose or out of connect	a. Check wire or change Heater
b. Improper setting of temperature	b. Adjust Heater Temperature (see page 19)
c. Value set at Tension knob is too high	c. Adjust Tension Knob (see page 11) or increase weld cooling time

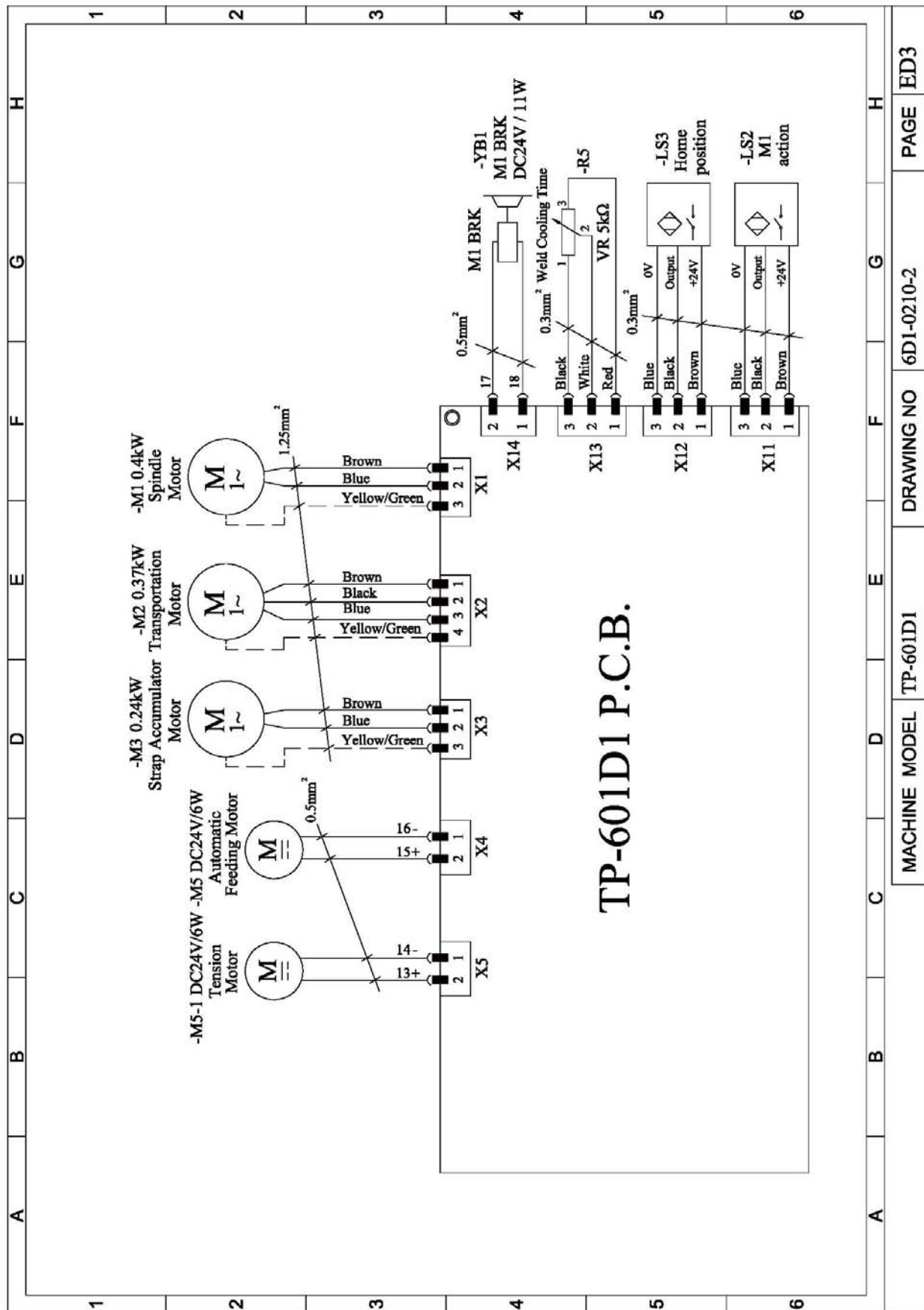
(3) Improper strap tensioning

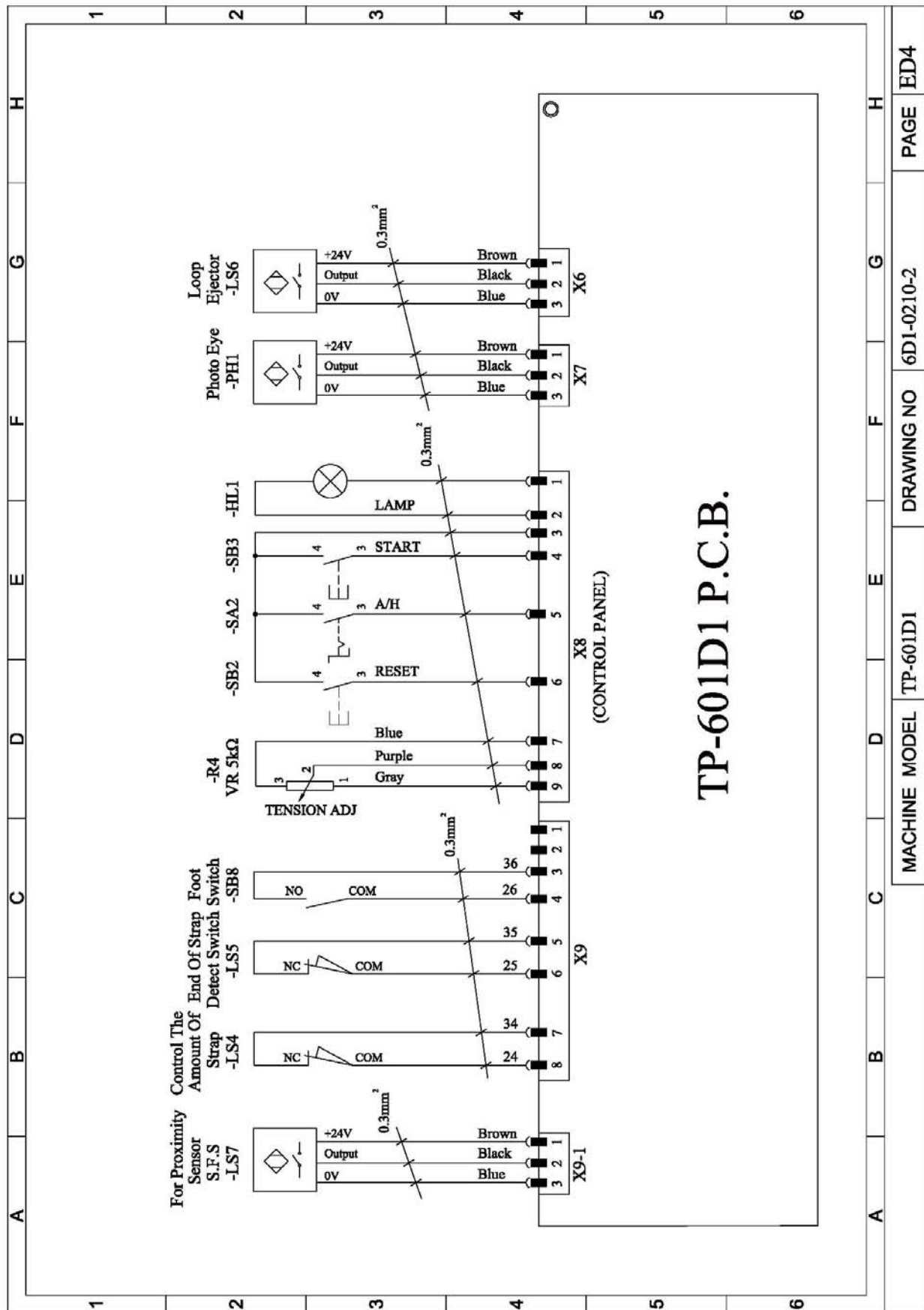
Probable Causes	Remedy
Value set for Timer T1 is too short	Adjust Timer T1 (see page 12)

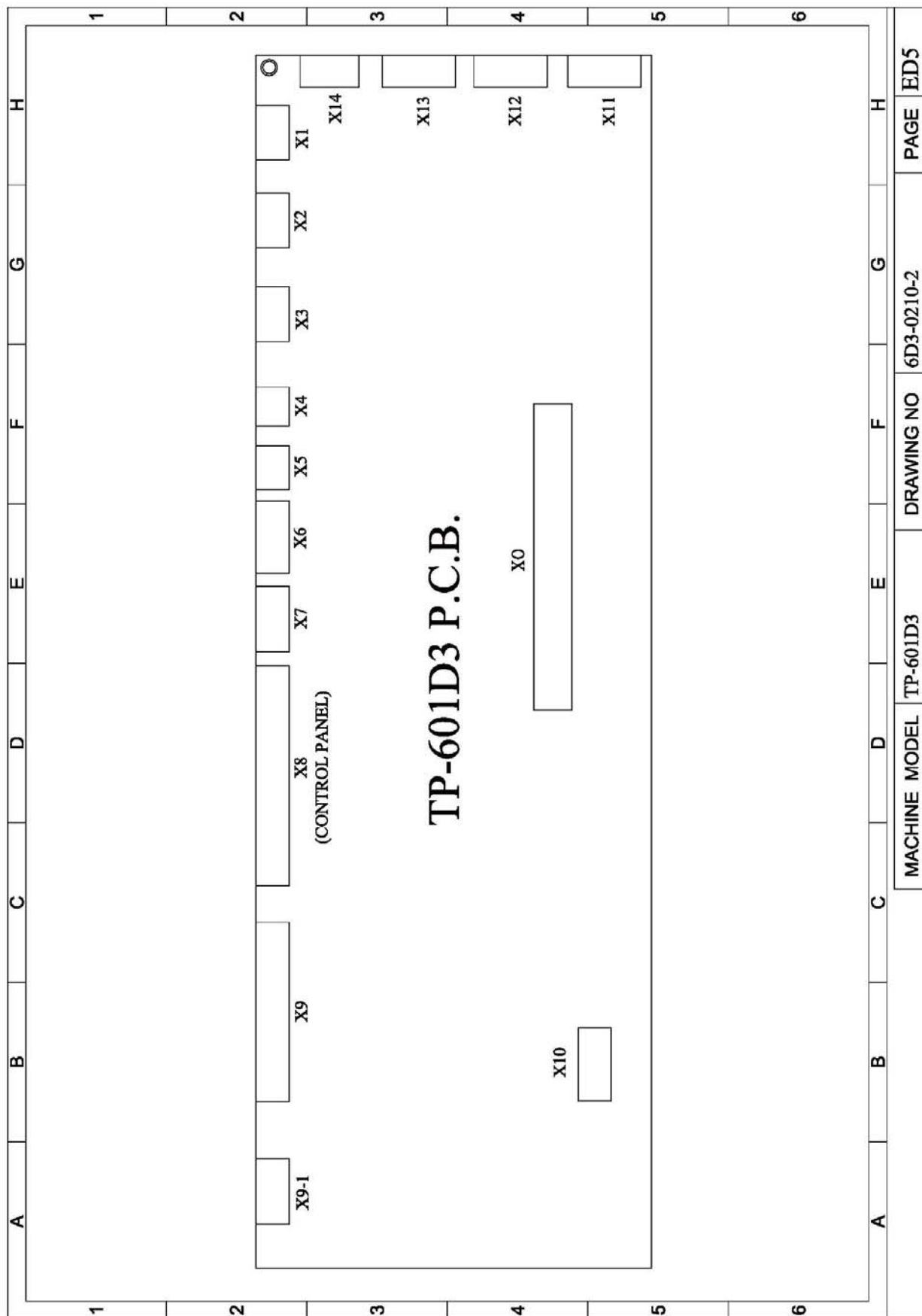
10. Wiring Diagram











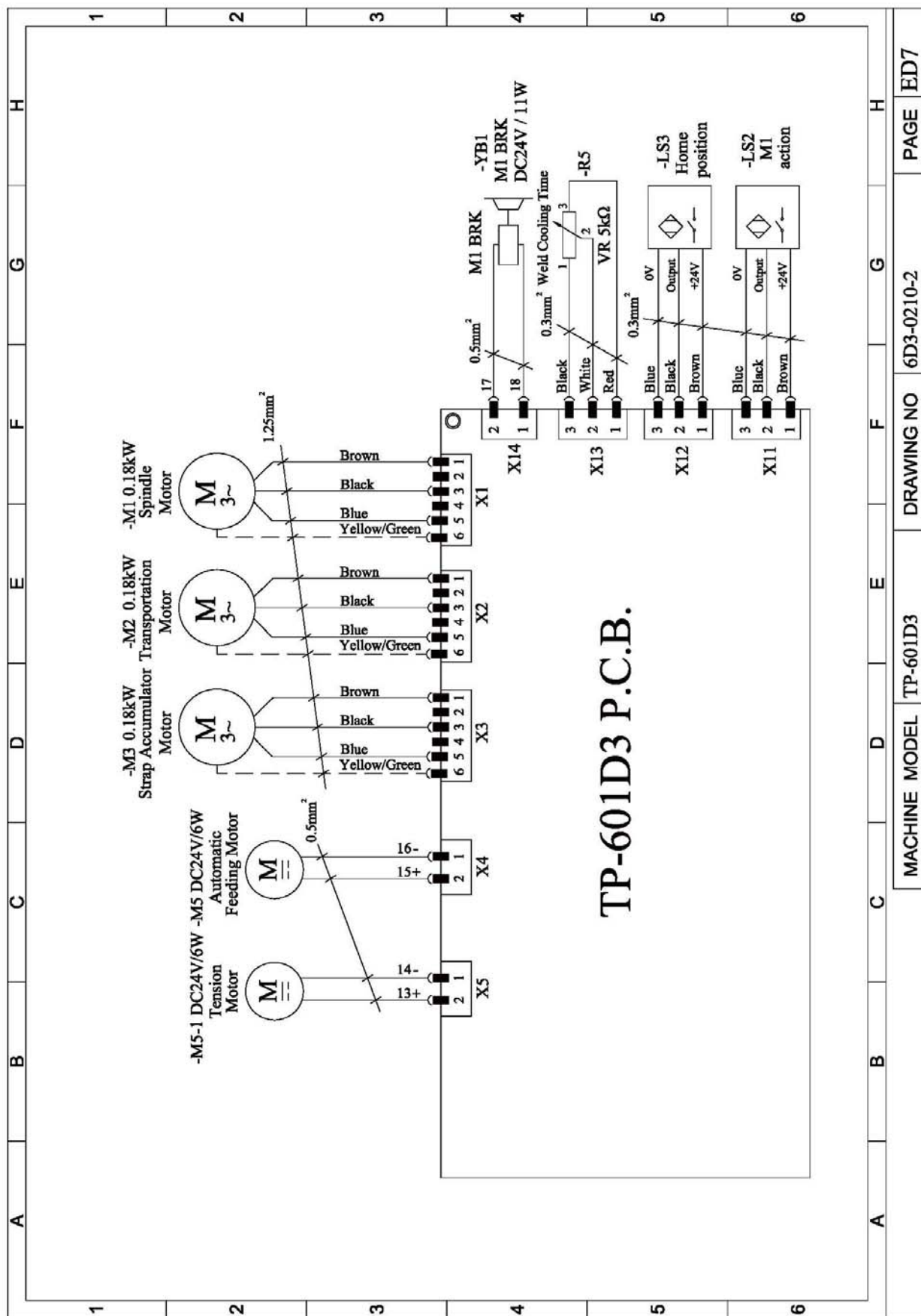
PAGE BD5

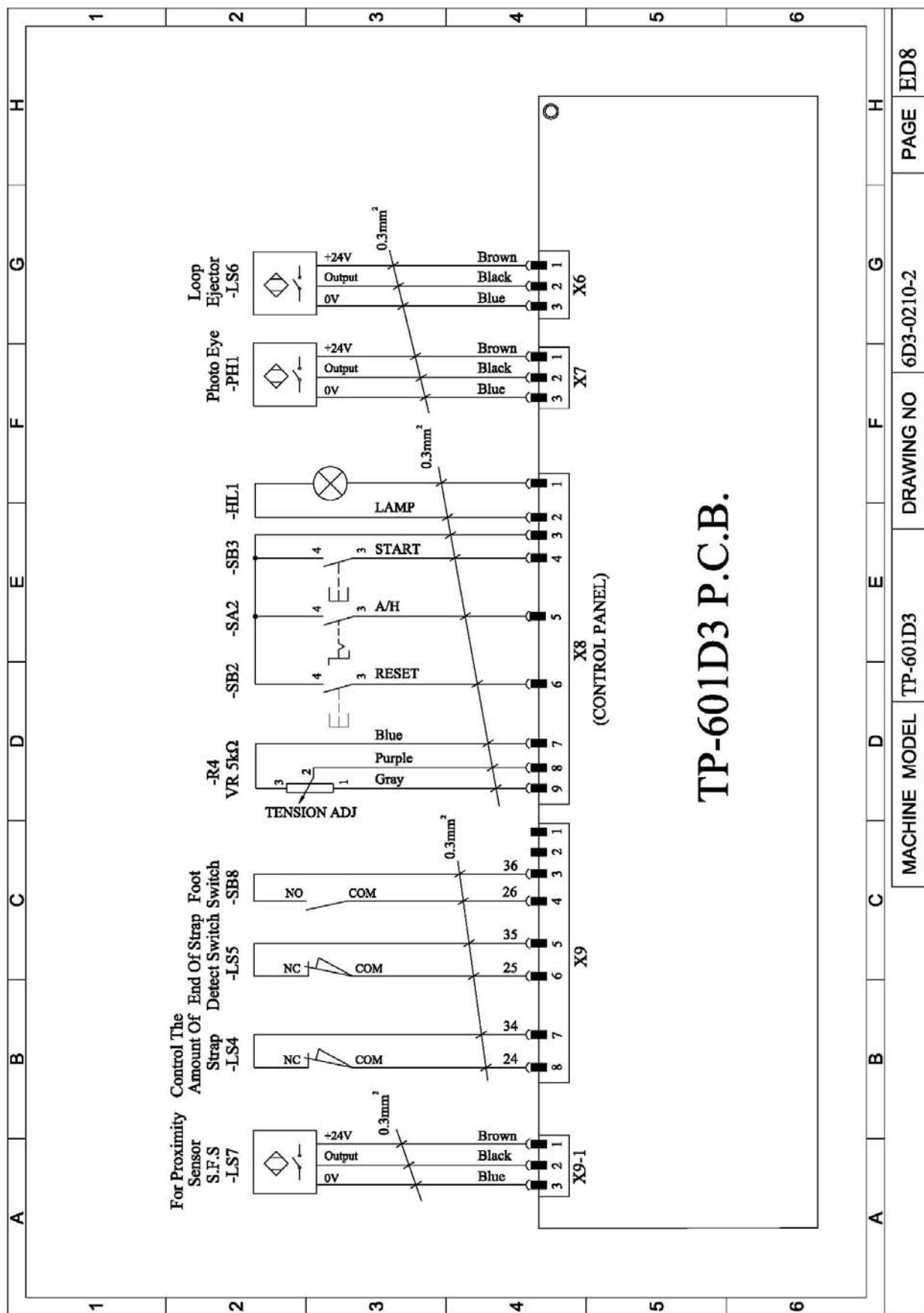
DRAWING NO 6D3-0210-2

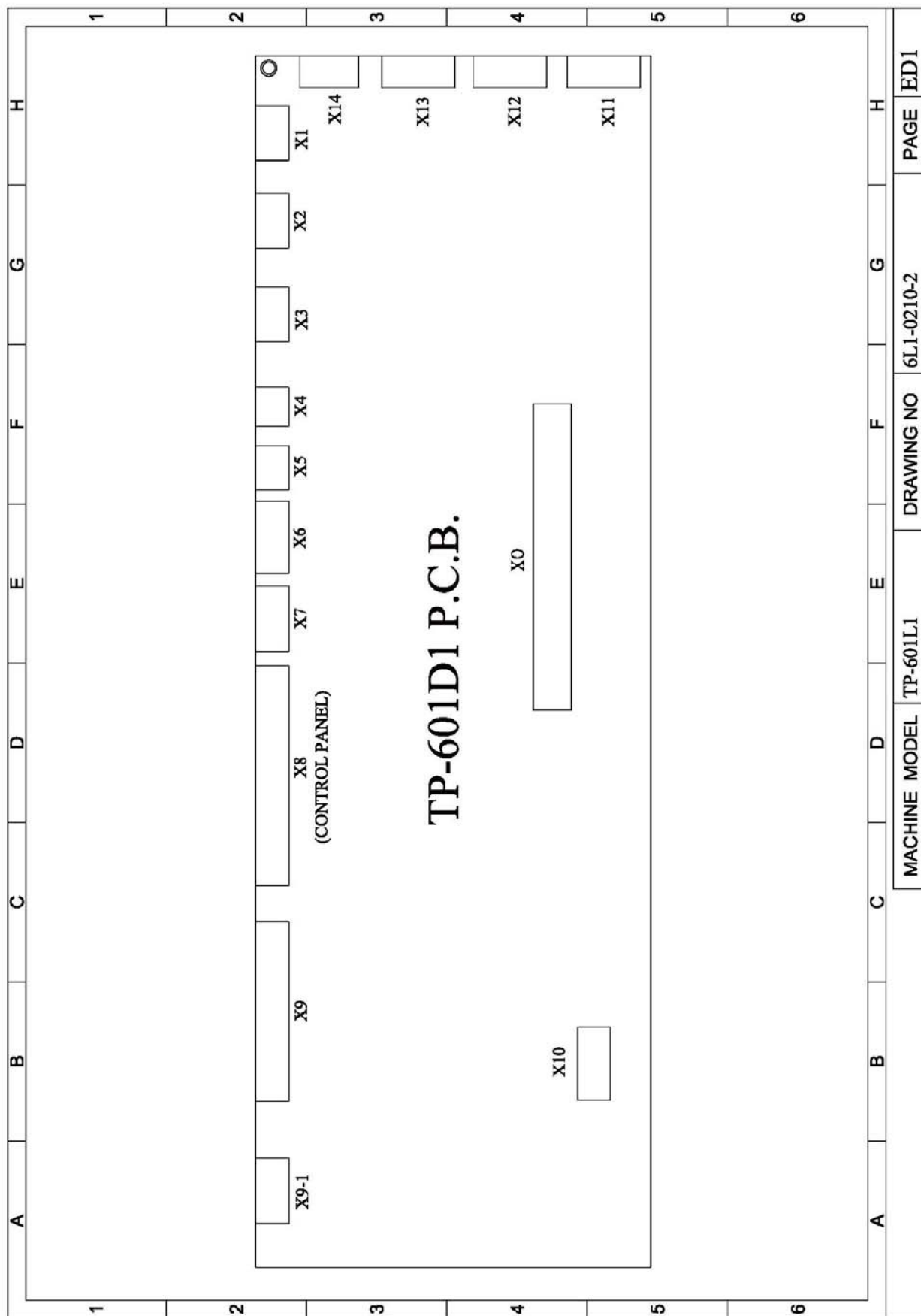
MACHINE MODEL TP-601D3





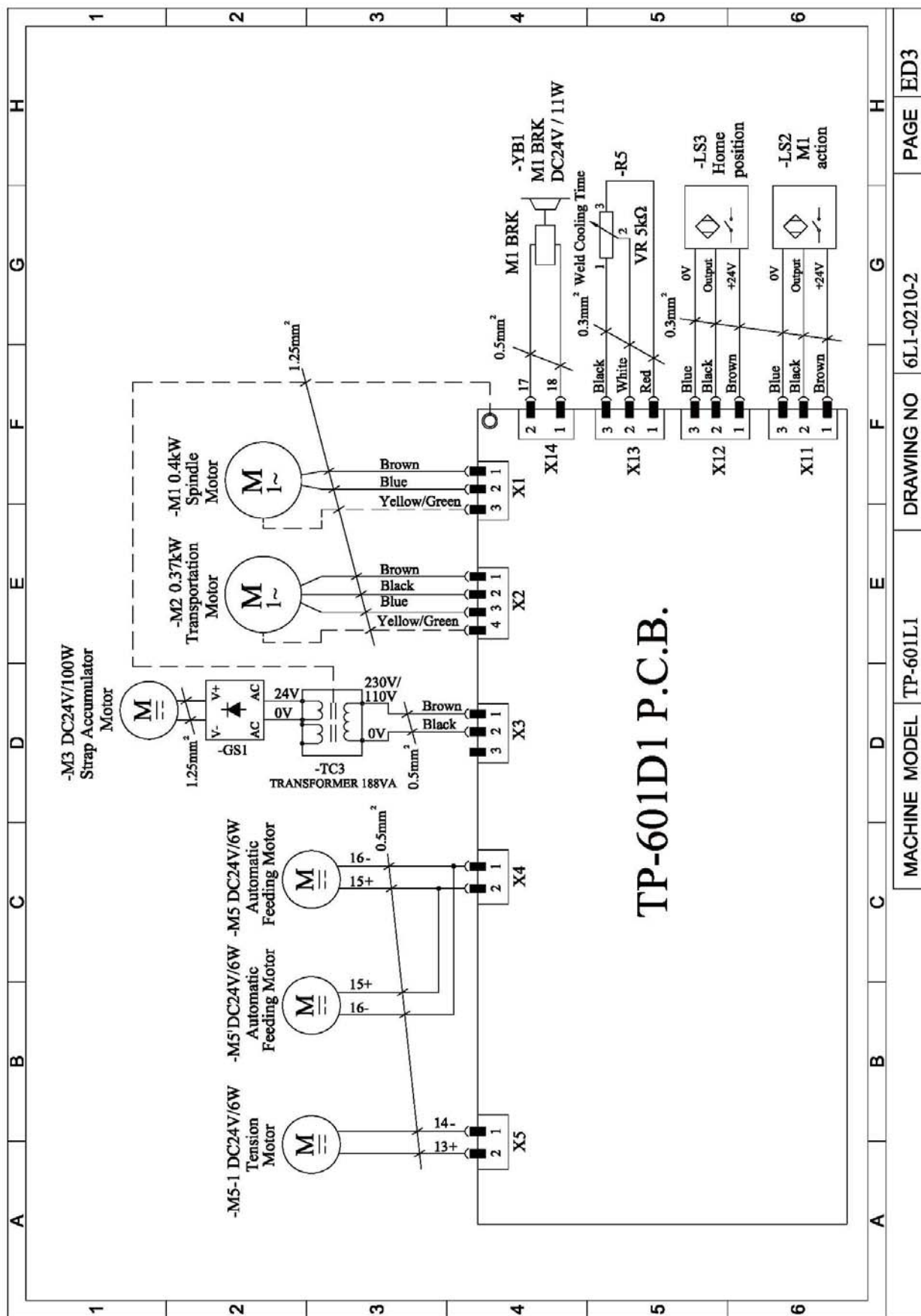




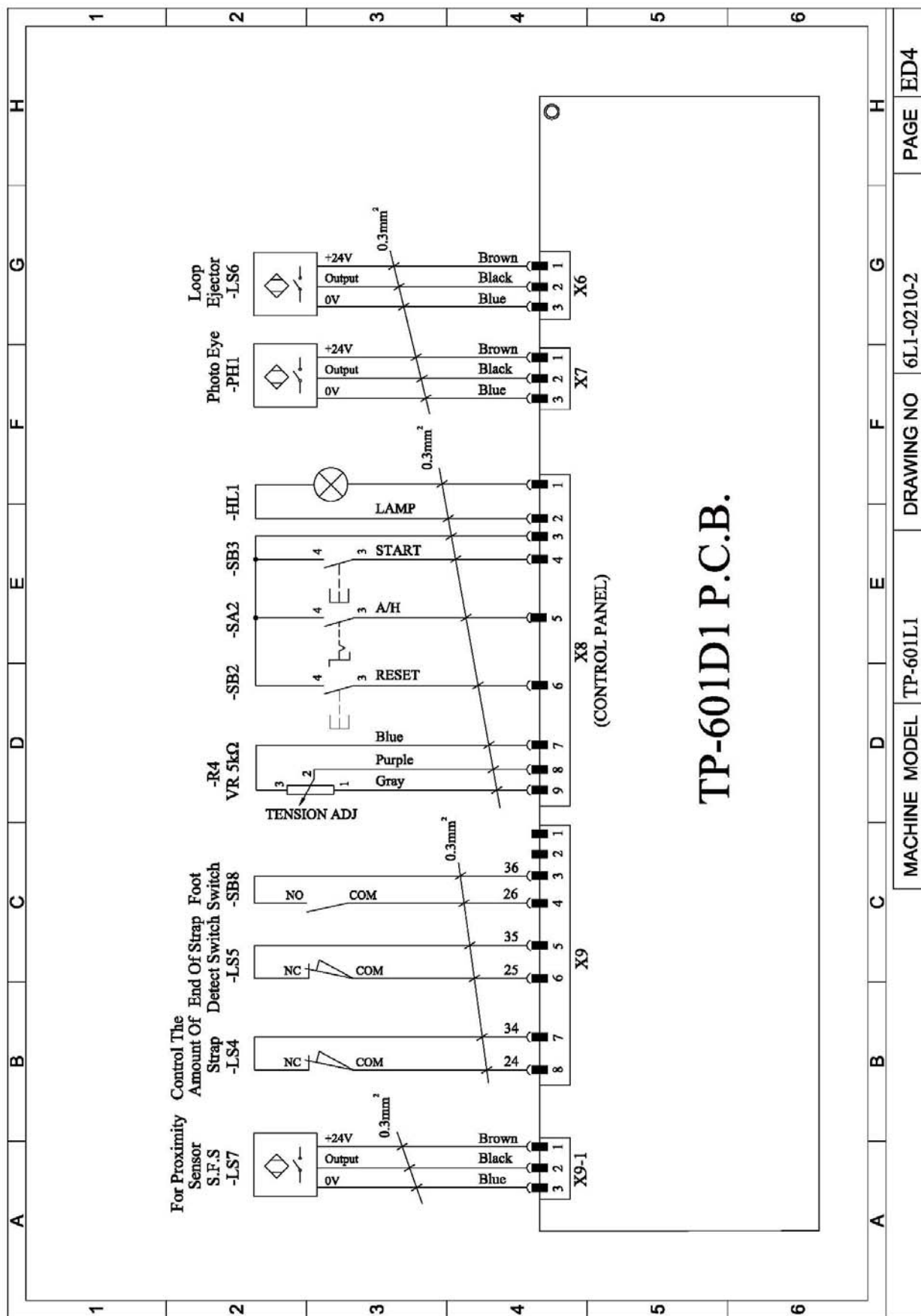


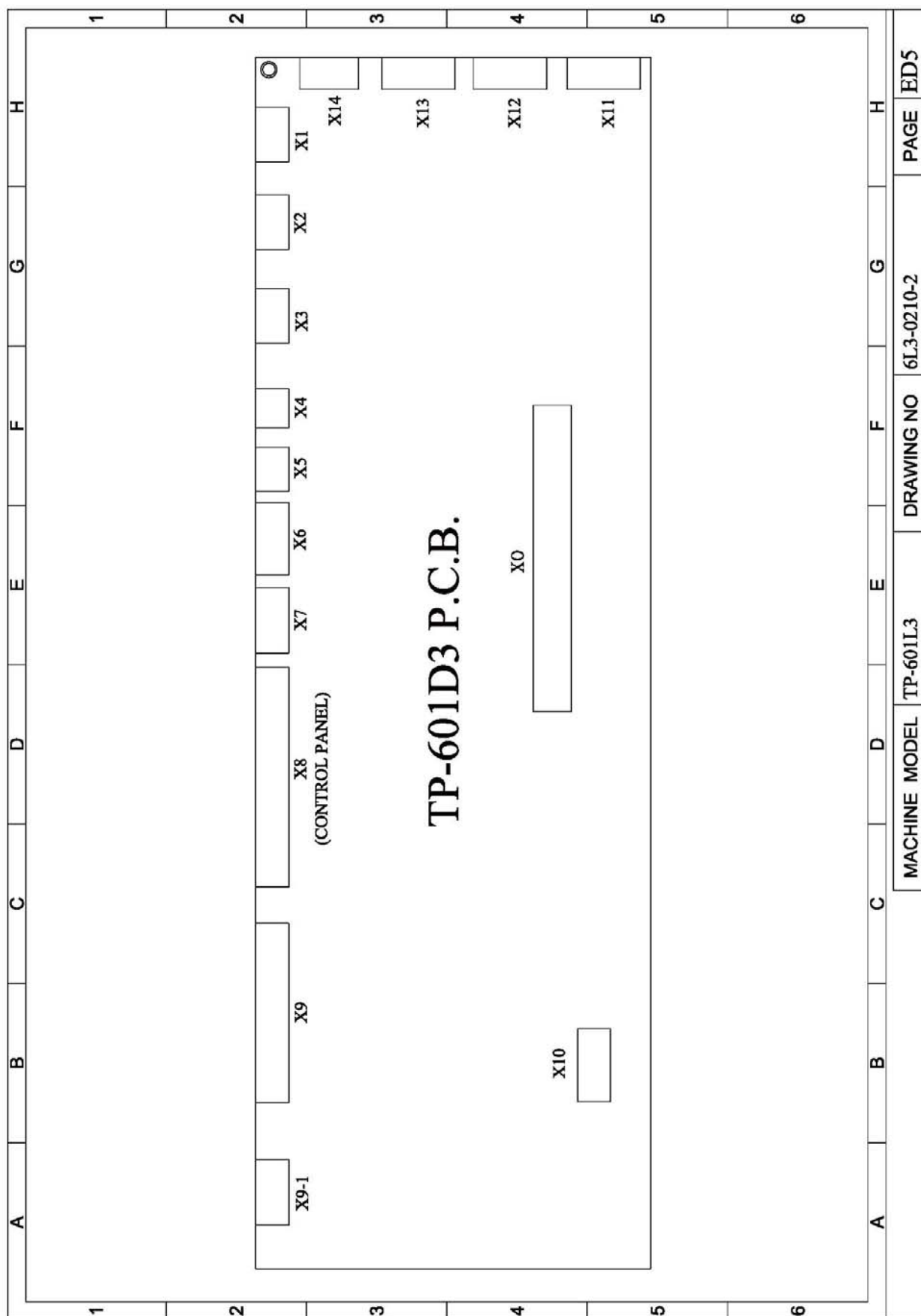
MACHINE MODEL	TP-601L1	DRAWING NO	6L1-0210-2	PAGE	ED1
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TP-601D1 P.C.B.



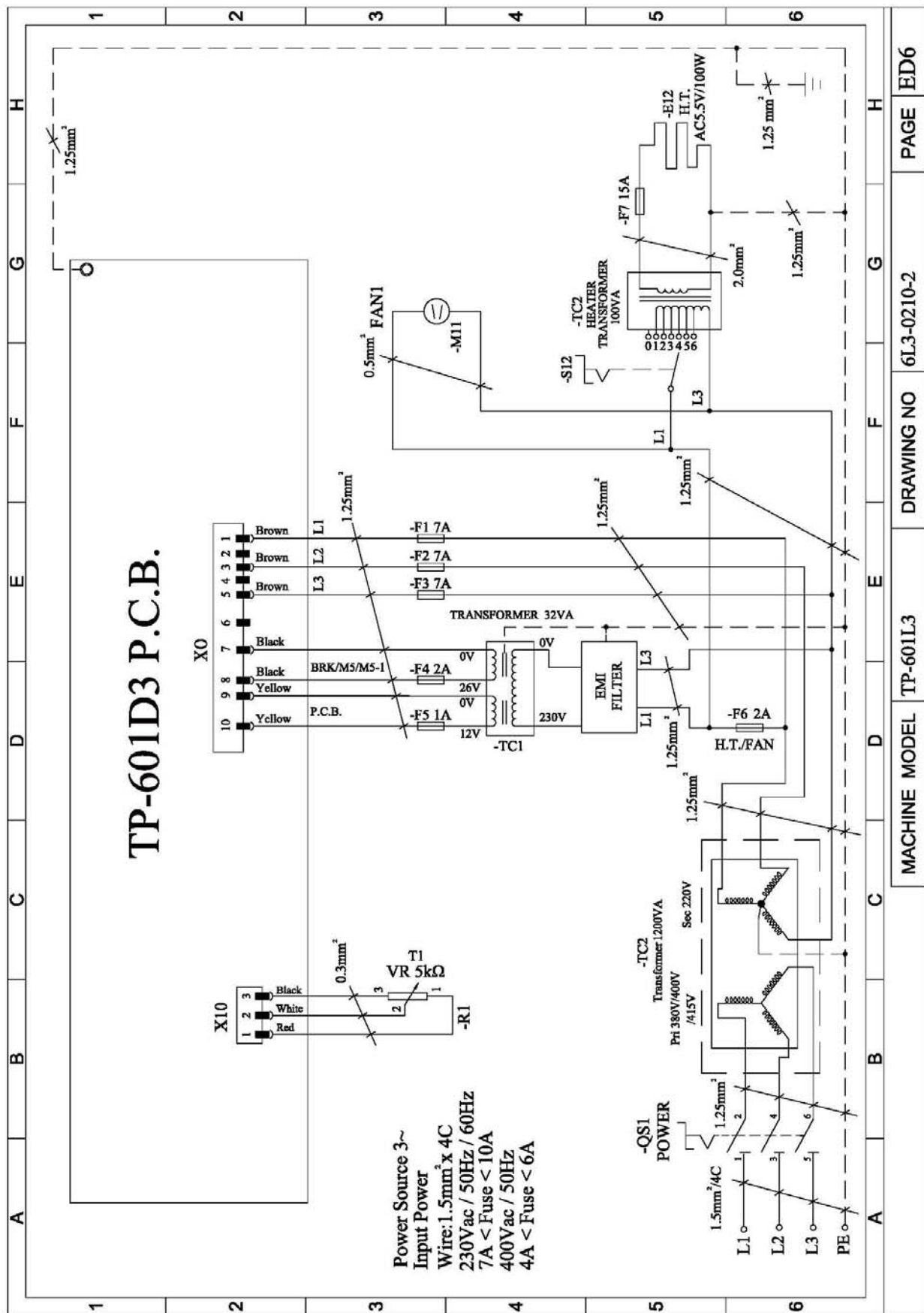


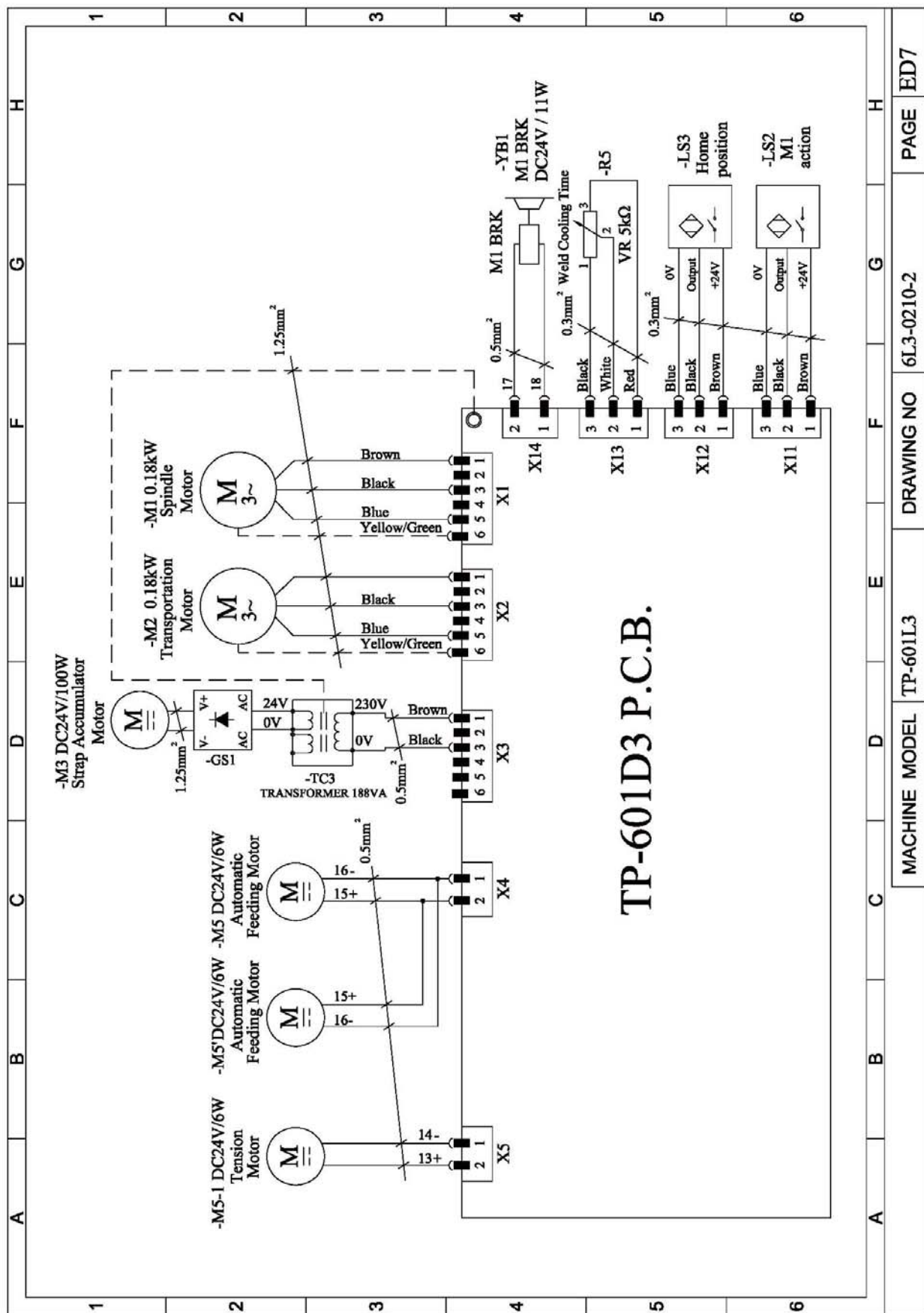
PAGE ED5

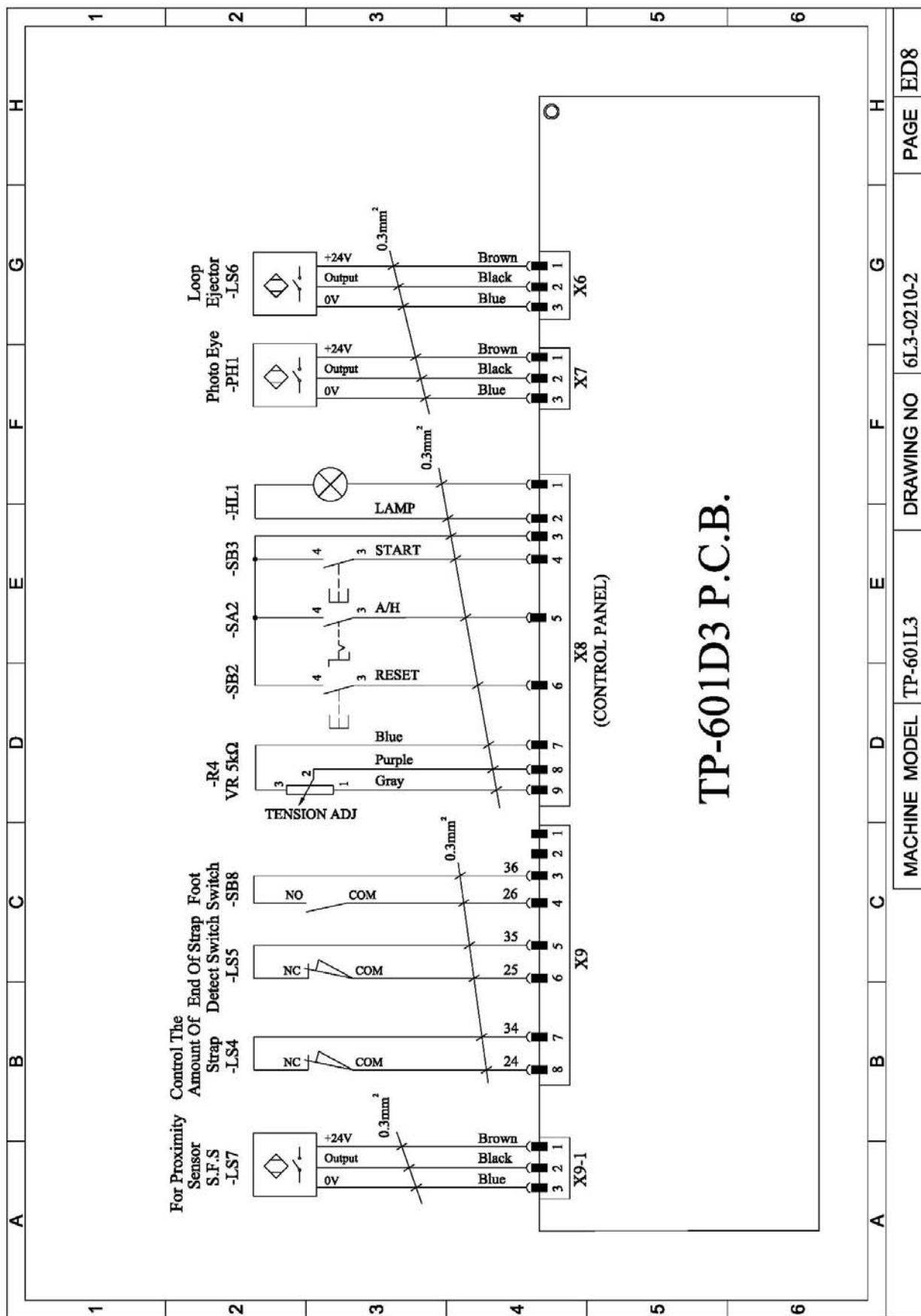
DRAWING NO 6L3-0210-2


































MACHINE MODEL TP-601L3









shape	classification	shape	classification
	HBS		ER
	TMS		RR
	PMS		SR
	FMS		SP
	HB		BR
	THS		MB
	HSS		KYA
	CAP		KYB
	HN		KYC
	WN		HBW
	FLG		PWA \$ 8x \$ 12~ \$ 16x0.4~0.8t \$ 6x \$ 13~ \$ 14x0.8~1.5t
	NTE		PWB \$ 8x \$ 14~ \$ 16x1.3~1.5t \$ 6x \$ 15~ \$ 16x1.0~1.5t
	PN		PWC \$ 8x \$ 20~ \$ 23x2.0t \$ 6x \$ 16~ \$ 19x2.0t
	PW		DS
	SW		TTP
	TW		FTP
	BWW		



PART II

CONTENTS

1. Strapping Head Unit	1
2. Bandway Unit	31
3. Accumulator Unit	45
4. Reel Unit	59
5. Body Frame Unit	70
6. Electric Control Group	98
7. Auto Strap Feeding Unit	109



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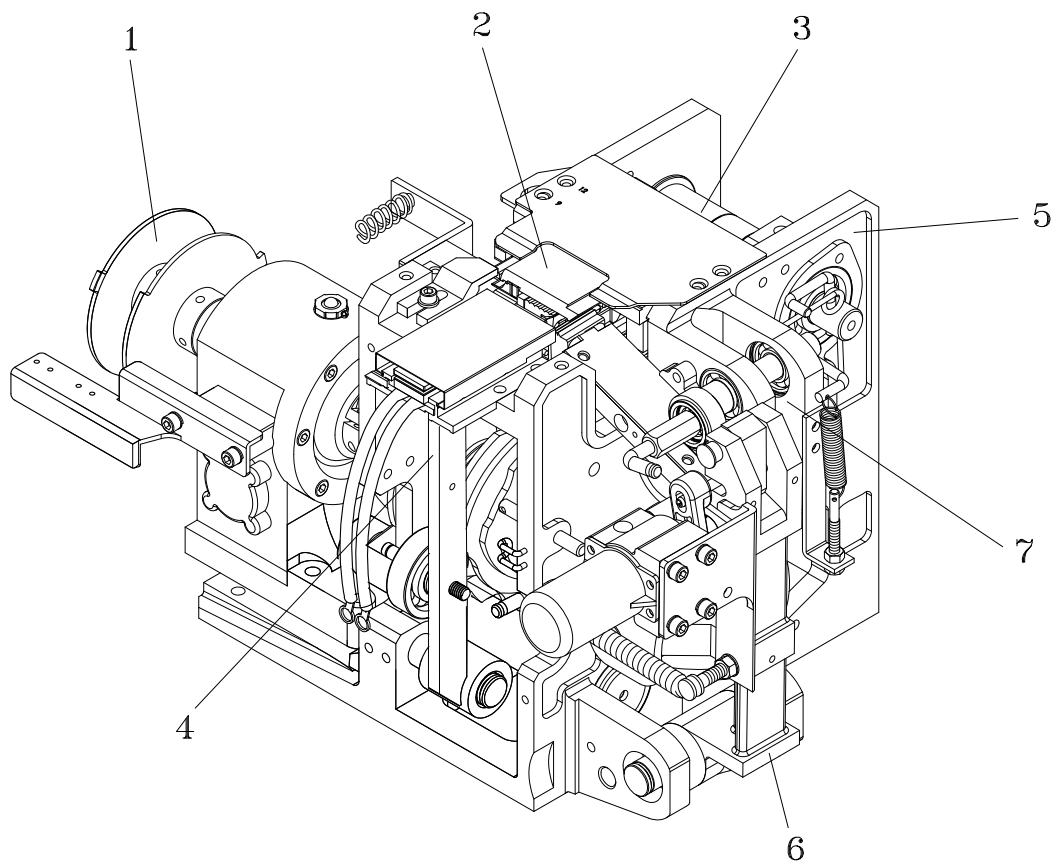
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1

STRAPPING HEAD UNIT

T6-1-90051

T6-1-90052



02 9452-3566

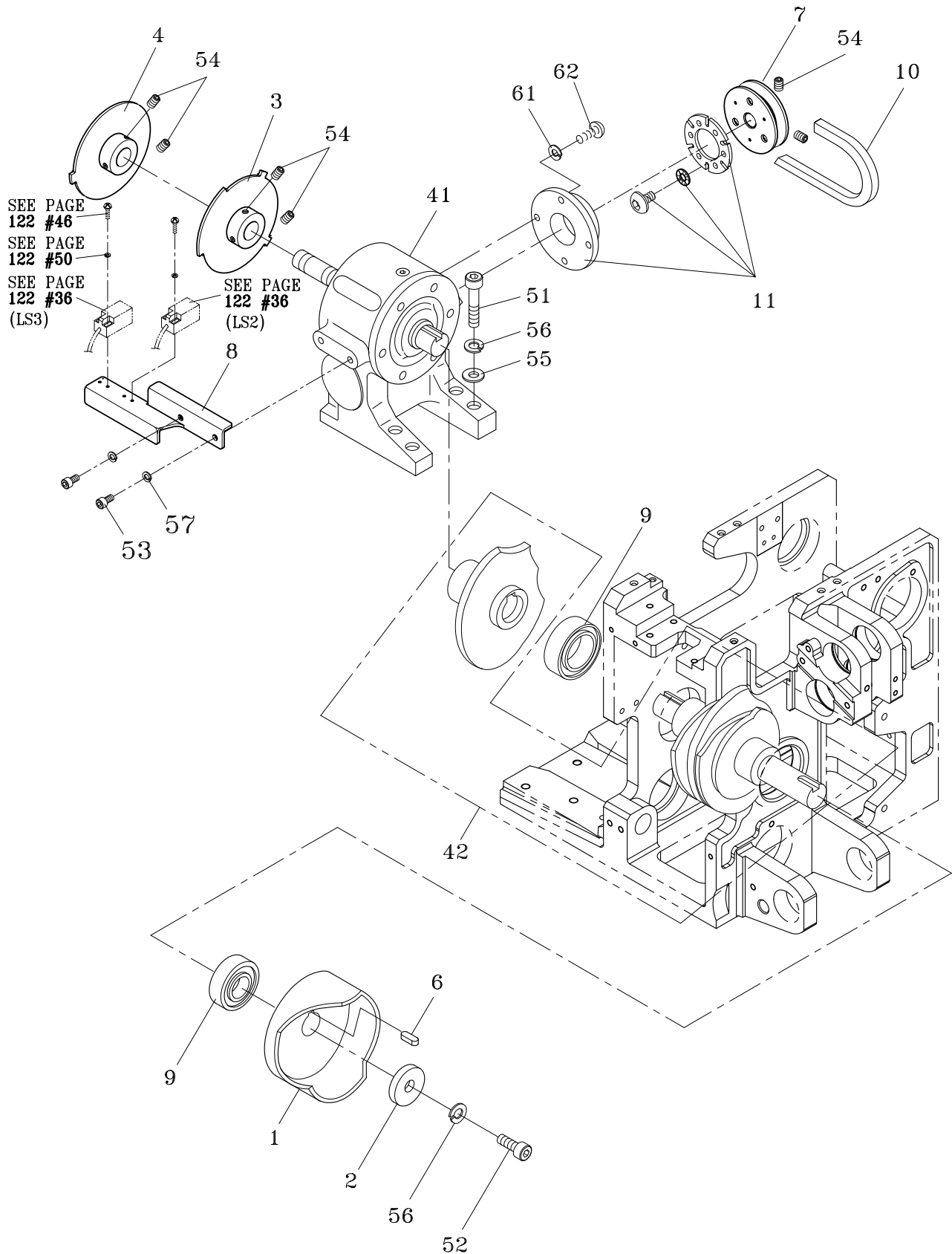
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1**STRAPPING HEAD UNIT****T6-1-90051****T6-1-90052**

REF. NO.	PART NO.	DESCRIPTION	Q'TY	REMARKS
	T6-1-90051	Strapping Head Unit (For TP-601D1, 12mm)	1	
	T6-1-90051S	Strapping Head Unit (For TP-601D1, 12mm)(Stainless Steel Model)	1	
	T6-1-90052	Strapping Head Unit (For TP-601D1, 9mm)	1	
	T6-1-90052S	Strapping Head Unit (For TP-601D1, 9mm)(Stainless Steel Model)	1	
	T6-1-90053	Strapping Head Unit (For TP-601D3, 12mm)	1	
	T6-1-90053S	Strapping Head Unit (For TP-601D3, 12mm)(Stainless Steel Model)	1	
	T6-1-90054	Strapping Head Unit (For TP-601D3, 9mm)	1	
	T6-1-90054S	Strapping Head Unit (For TP-601D3, 9mm)(Stainless Steel Model)	1	
	T6-1-90061	Strapping Head Unit (For TP-601L1, 12mm)	1	
	T6-1-90061S	Strapping Head Unit (For TP-601L1, 12mm)(Stainless Steel Model)	1	
	T6-1-90062	Strapping Head Unit (For TP-601L1, 9mm)	1	
	T6-1-90062S	Strapping Head Unit (For TP-601L1, 9mm)(Stainless Steel Model)	1	
	T6-1-90063	Strapping Head Unit (For TP-601L3, 12mm)	1	
	T6-1-90063S	Strapping Head Unit (For TP-601L3, 12mm)(Stainless Steel Model)	1	
	T6-1-90064	Strapping Head Unit (For TP-601L3, 9mm)	1	
	T6-1-90064S	Strapping Head Unit (For TP-601L3, 9mm)(Stainless Steel Model)	1	
1	T6-1-10003	Cam Group	1	SEE PAGE 4

REF. NO.	PART NO.	DESCRIPTION	Q'TY	REMARKS
2	T6-1-20020	Slide Table Group	1	SEE PAGE 7
	T6-1-20020S	Slide Table Group (Stainless Steel Model)	1	SEE PAGE 7
3	T6-1-30000	Press Group	1	SEE PAGE 11
	T6-1-30000S	Press Group (Stainless Steel Model)	1	SEE PAGE 11
4	T6-1-40000	Heater Group	1	SEE PAGE 16
5	T6-1-50031	Strapping Head Group (For TP-601D)	1	SEE PAGE 19
	T6-1-50032	Strapping Head Group (For TP-601L)	1	SEE PAGE 19
6	T6-1-60003	Tension Group	1	SEE PAGE 21
	T6-1-60003S	Tension Group (Stainless Steel)	1	SEE PAGE 21
7	T6-1-70002	Feed Group (For TP-601D1/TP-601L1, 12mm)	1	SEE PAGE 25
	T6-1-70002S	Feed Group (For TP-601D1/TP-601L1, 12mm)(Stainless Steel Model)	1	SEE PAGE 25
	T6-1-70003	Feed Group (For TP-601D1/TP-601L1, 9mm)	1	SEE PAGE 25
	T6-1-70003S	Feed Group (For TP-601D1/TP-601L1, 9mm)(Stainless Steel Model)	1	SEE PAGE 25
	T6-1-70004	Feed Group (For TP-601D3/TP-601L3, 12mm)	1	SEE PAGE 25
	T6-1-70004S	Feed Group (For TP-601D3/TP-601L3, 12mm)(Stainless Steel Model)	1	SEE PAGE 25
	T6-1-70005	Feed Group (For TP-601D3/TP-601L3, 9mm)	1	SEE PAGE 25
	T6-1-70005S	Feed Group (For TP-601D3/TP-601L3, 9mm)(Stainless Steel Model)	1	SEE PAGE 25





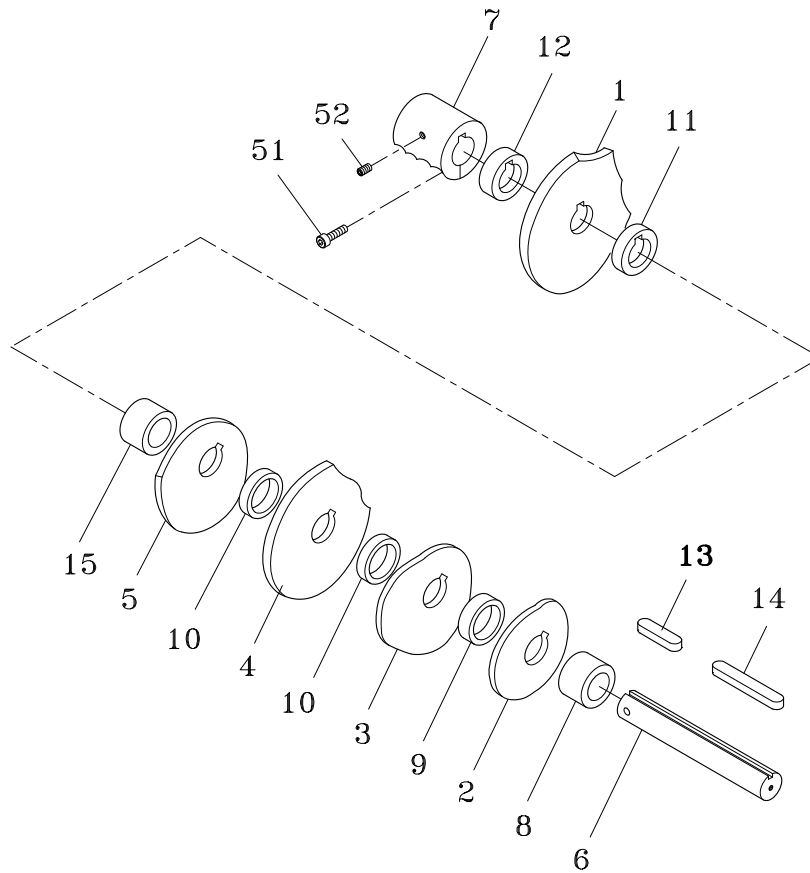
1-1**CAM GROUP****T6-1-10003**

REF. NO.	PART NO.	DESCRIPTION	Q'TY	REMARKS
1	T6-1-10110	Tension Cam	1	
2	T6-1-10120	Cam Shaft End Plate	1	
3	T6-1-10131	Limit Switch Cam (LS2)	1	
4	T6-1-10142	Limit Switch Cam (LS3)	1	
6	KYA070720	Key, 7×7×20	2	
7	T6-1-10171	Gear Box Pulley	1	
8	T6-1-10181	Limit Switch Bracket	1	
9	BR6205ZZ	Bearing, 6205ZZ	2	
10	T6-1-10200	V-Belt (A26)	1	
11	T6-6-10180	Magnet Brake	1	
41	T6-1-11000	Gear Box	1	SEE PAGE 6
42	T6-1-12000	Cam Ass'y	1	
51	HBS0845H	HBS, M8×45 (H)	4	
52	HBS0825	HBS, M8×25	1	
53	HBS0612	HBS, M6×12	2	
54	HSS0610G	HSS, M6×10 (G)	6	
55	PW08B	PW, M8 (B)	4	
56	SW08	SW, M8	5	
57	SW06	SW, M6	2	
61	SW04	SW, M4	4	
62	PMS0408	PMS, M4×8	4	

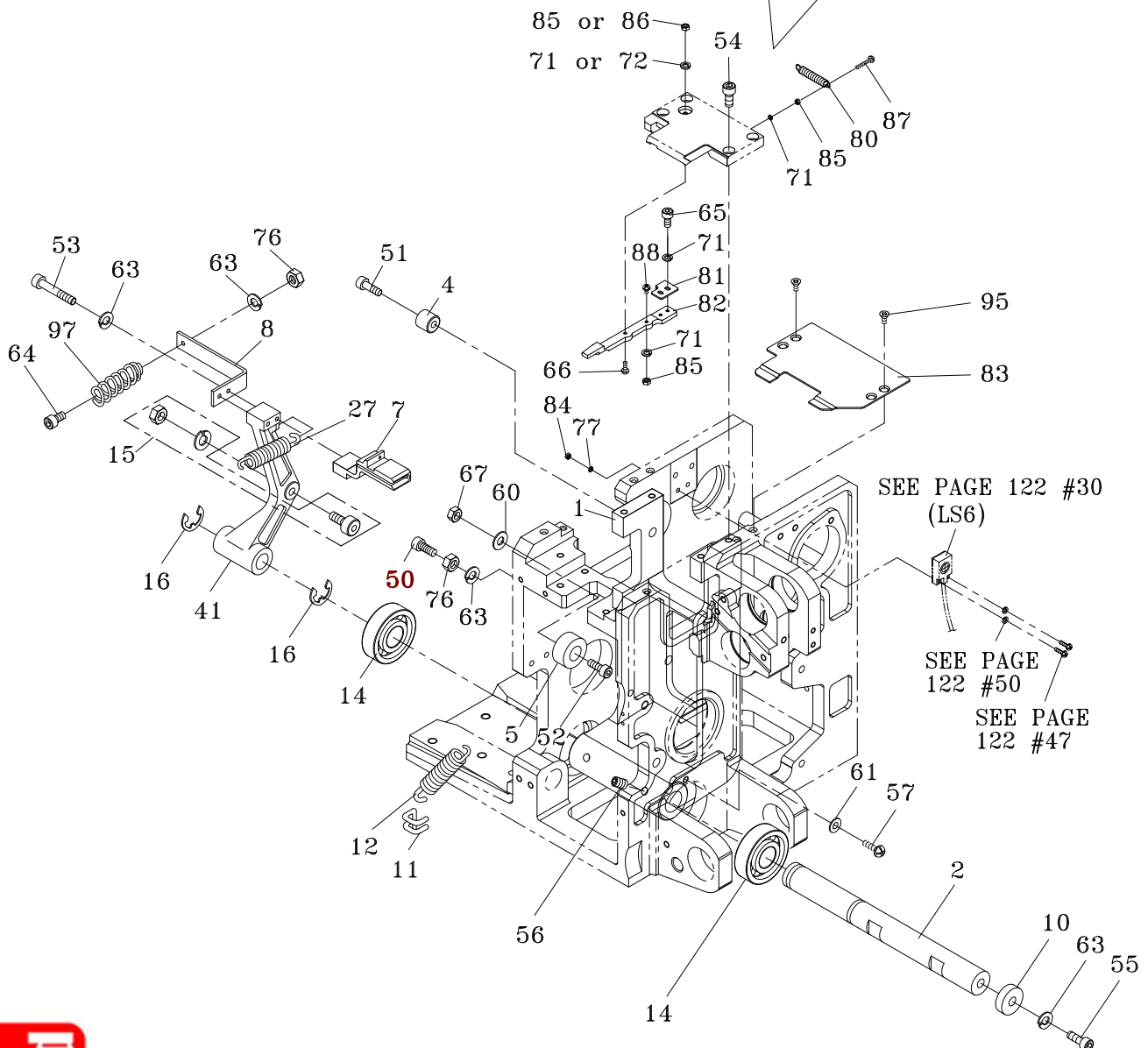
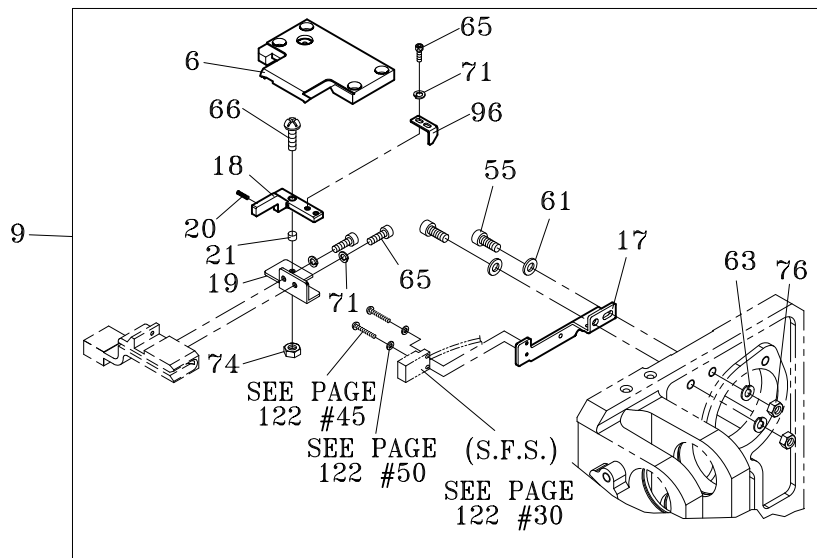
1-1-1

CAM ASS'Y

T6-1-12000



REF. NO.	PART NO.	DESCRIPTION	Q'TY	REMARKS
1	T6-1-12110	Slide Table Cam	1	
2	T6-1-12120	RH Press Cam	1	
3	T6-1-12130	Center Press Cam	1	
4	T6-1-12140	Heater Cam	1	
5	T6-1-12150	LH Press Cam	1	
6	T6-1-12160	Cam Shaft	1	
7	T6-1-12170	Cam Shaft Coupling	1	
8	T6-1-12180	Collar, 29.2×34×28.3	1	
9	T6-1-12190	Collar, 29.2×34×20	1	
10	T6-1-12210	Collar, 29.2×34×8	2	
11	T6-1-12220	Collar, 29.2×34×5.5	1	
12	T6-1-12230	Collar, 29.2×34×14	1	
13	KYA070750	Key, 7×7×50	1	
14	KYA070790	Key, 7×7×90	1	
15	T6-1-12350	Collar, 29.2×34×27.8	1	
51	HBS0620	HBS, M6×20	4	
52	HSS0810G	HSS, M8×10 (G)	1	



1-2**SLIDE TABLE GROUP****T6-1-20020**

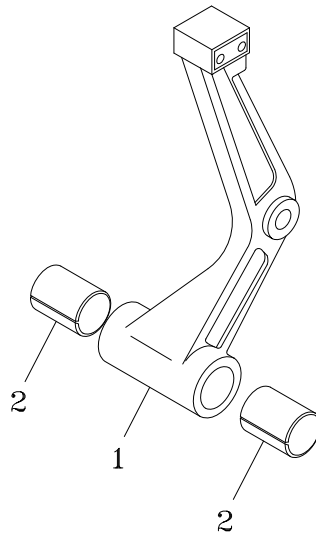
REF. NO.	PART NO.	DESCRIPTION	Q'TY	REMARKS
	T6-1-20020	Slide Table Group	1	
	T6-1-20020S	Slide Table Group (Stainless Steel Model)	1	
1	T6-1-20110	Slide Table Frame	1	
2	T6-1-20120	Slide Table Frame Shaft	1	
4	T6-1-20141	Slide Table Back Adjuster	1	
5	T6-1-20150	Slide Table Stopper	1	
6	T6-1-20163	Slide Table	1	
	T6-1-20163S1	Slide Table (Stainless Steel Model)	1	
7	T6-1-20170	Strap Guide	1	
8	T6-1-20180	Flap Connecting Spring Bracket	1	
9	T6-1-20193	S.F.S. Ass'y	1	
	T6-1-20193S	S.F.S. Ass'y (Stainless Steel Model)	1	
10	T6-1-30170	Press Arm End Plate	1	
11	T6-1-20220	Slide Table Spring Hook	1	
12	T6-1-20230	Slide Table Tension Spring	1	
14	BR6304ZZ	Bearing, 6304ZZ	2	
15	T6-1-20250	Cam Follower, KR22×LL	1	
16	ER15	Snap Ring, E-15	2	
17	T6-1-20311	Support	1	
18	T6-1-20323	Lever	1	
19	T6-1-20340	Bracket	1	
20	T6-1-20351	Spring	1	
21	T6-1-20450	Bushing	1	
27	T6-1-20372	Spring	1	
41	T6-1-21000	Strap Guide Arm Ass'y	1	SEE PAGE 10
50	HBS0630	HBS, M6×30	1	
51	HBS1025H	HBS, M10×25 (H)	1	
52	HBS0830	HBS, M8×30	1	
53	HBS0650H	HBS, M6×50 (H)	2	
54	HBS0620N	HBS, M6×20 (N)	4	
	HBS0620S	HBS, M6×20 (Stainless Steel Model)	4	
55	HBS0625	HBS, M6×25	3	
56	HSS0810G	HSS, M8×10 (G)	2	
57	TMS0610	TMS, M6×10	2	
60	PW08A	PW, M8 (A)	1	
61	PW06A	PW, M6 (A)	4	

1-2**SLIDE TABLE GROUP****T6-1-20020**

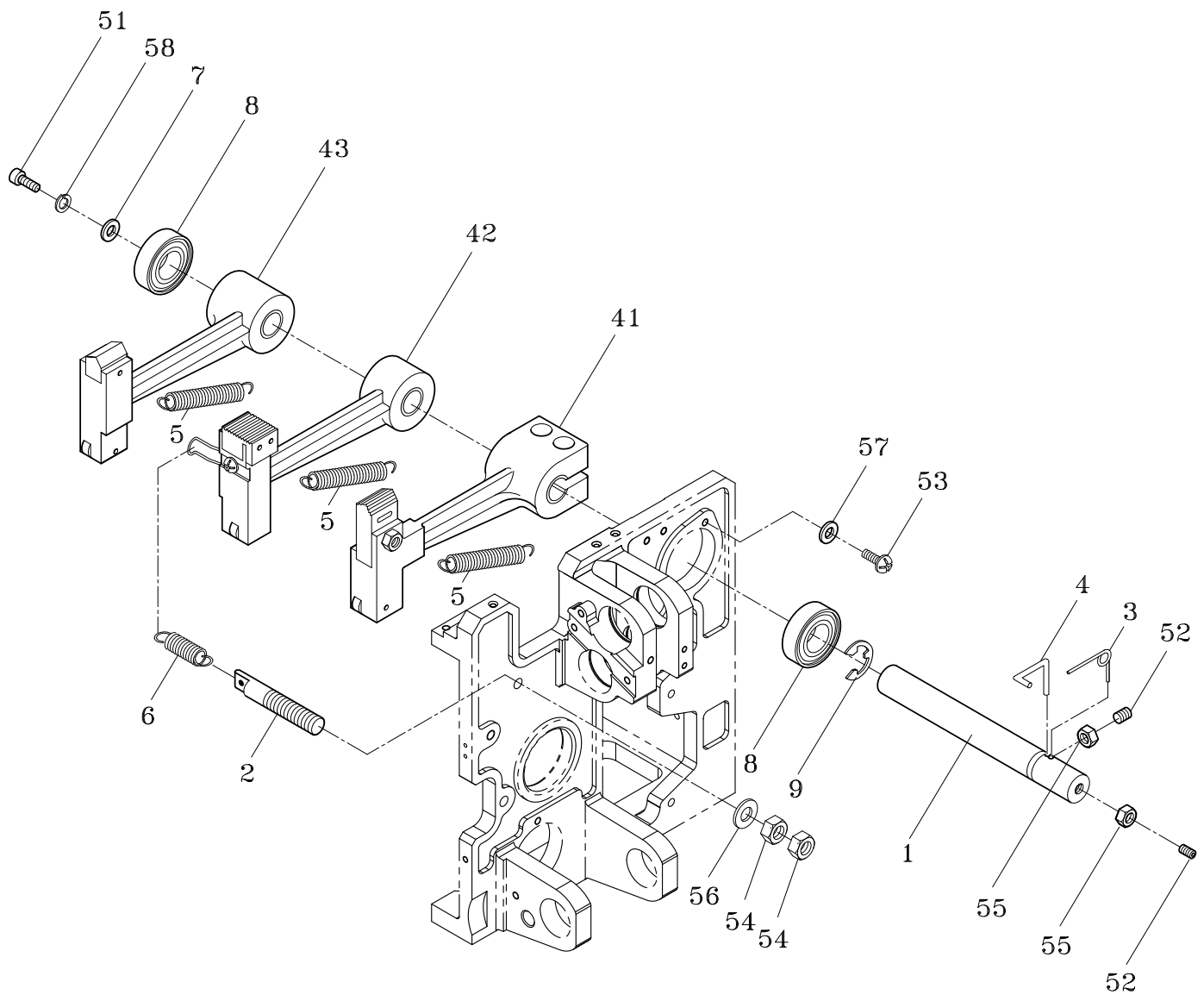
REF. NO.	PART NO.	DESCRIPTION	Q'TY	REMARKS
63	SW06	SW, M6	7	
64	HBS0616	HBS, M6×16	1	
65	HBS0408	HBS, M4×8	6	
66	TMS0412	TMS, M4×12	2	
67	HN08	HN, M8	1	
71	SW04	SW, M4	9	
72	SW04S	SW, M4 (Stainless Steel Model)	1	
74	NTE04	NTE, M4	1	
76	HN06	HN, M6	4	
77	SW03	SW, M3	2	
80	TA-071	Return Spring	1	
81	T6-1-20910	Sensor Plate	1	
82	T6-1-20920	Loop-eject Lever	1	
83	T6-1-20930	Loop-eject Plate	1	
	T6-1-20930S	Loop-eject Plate (Stainless Steel Model)	1	
84	HN03	HN, M3	2	
85	HN04	HN, M4	3	
86	HN04S	HN, M4 (Stainless Steel Model)	1	
87	PMS0416	PMS, M4×16	1	
88	PMS0412	PMS, M4×12	1	
95	FMS0508	FMS, M5×8	2	
	FMS0508S	FMS, M5×8 (Stainless Steel Model)	2	
96	T6-1-20840	Detector Plate	1	
97	T6-2-10130	LH Bandway Stop Spring	1	

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1-2-1

STRAP GUIDE ARM ASS'Y**T6-1-21000**

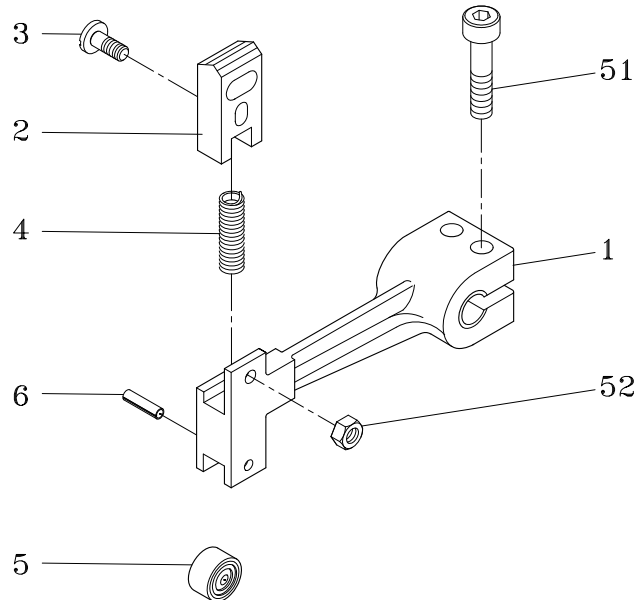
REF. NO.	PART NO.	DESCRIPTION	Q'TY	REMARKS
1	T6-1-21110	Strap Guide Arm	1	
2	MB2025	Metal Bushing, 2025	2	



1-3**PRESS GROUP****T6-1-30000**

REF. NO.	PART NO.	DESCRIPTION	Q'TY	REMARKS
	T6-1-30000	Press Group	1	
	T6-1-30000S	Press Group (Stainless Steel Model)	1	
1	T6-1-30110	Press Arm Shaft	1	
2	T6-1-30120	Cutter Tension Spring Hook	1	
3	T6-1-30130	Upper Roller Spring	1	
4	T6-1-30140	Upper Shaft Spring Adjuster	1	
5	T6-1-30150	Press Tension Spring	3	
6	T6-1-30160	Cutter Tension Spring	1	
7	T6-1-30170	Press Arm End Plate	1	
8	BR6304ZZ	Bearing, 6304ZZ	2	
9	ER15	Snap Ring, E-15	1	
41	T6-1-31000	RH, Block Arm Ass'y	1	SEE PAGE 13
	T6-1-31000S	RH, Block Arm Ass'y (Stainless Steel Model)	1	SEE PAGE 13
42	T6-1-32000	Center Block Arm Ass'y	1	SEE PAGE 14
	T6-1-32000S	Center Block Arm Ass'y (Stainless Steel Model)	1	SEE PAGE 14
43	T6-1-33000	LH, Block Arm Ass'y	1	SEE PAGE 15
51	HBS0620	HBS, M6×20	1	
52	HSS0615G	HSS, M6×15 (G)	2	
53	TMS0610	TMS, M6×10	2	
54	HN08	HN, M8	2	
55	HN06	HN, M6	2	
56	PW08A	PW, M8 (A)	1	
57	PW06B	PW, M6 (B)	2	
58	SW06	SW, M6	1	

1-3-1

RH, BLOCK ARM ASS'Y**T6-1-31000**

REF. NO.	PART NO.	DESCRIPTION	Q'TY	REMARKS
	T6-1-31000	RH, Block Arm Ass'y	1	
	T6-1-31000S	RH, Block Arm Ass'y (Stainless Steel Model)	1	
1	T6-1-31110	RH, Block Arm	1	
2	T6-1-31120	Upper Cutter	1	
	T6-1-31120S	Upper Cutter (Stainless Steel Model)	1	
3	T6-1-31130	Upper Cutter Pin	1	
4	T6-1-31140	RH, Block Spring	1	
5	BR628ZZ	Bearing, 628ZZ	1	
6	SP0824	Spring Pin, 8×24	1	
51	HBS0835H	HBS, M8×35(H)	2	
52	HN10	HN, M10	1	