



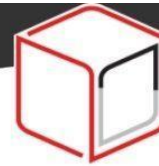
# STEP Band 1000 Banding Machine ( Manual )



CE

322010000 Manual UK 011222  
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## **COMPANY INTRODUCTION**

"We believe packaging solutions for our customers should be simple, easy to use, ergonomic and sustainable.

We offer a wide range of packaging products and solutions, and web design and engineer production lines specifically built to your needs.

Our motto is simple: Sal-Tech Easy Packaging makes your life simpler through engineering and good design, and your job less stressful. We Keep Things Together."

**Gunnar Salbæk**  
Owner/CEO

## **About Sal-Tech Easy Packaging**

Sal-Tech Easy Packaging offers a wide range of solutions for simple and reliable packaging of your products.

If it is a standard or a special solution that's needed for your assignment, we have a creative input to solve your needs, securing you an up-to-date packaging application.

Sal-Tech Easy Packaging is 100% owned by Gunnar Salbæk,

CVR no.: DK18429098 Salbæk Easy Packaging v/Gunnar Bjørn Salbæk.

Our team works together on a 100% virtual platform and therefore please forward all correspondence to [support@sal-tech.com](mailto:support@sal-tech.com).

Bank connection: Nordea Denmark.

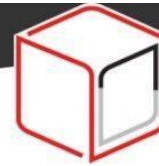




## Table of Content

1. PREFERENCE	5
1.1 Safety Instruction	5
1.2 Warning Label	3
1.3 Installation Attention	6
1.4 Usage Attentions	6
1.5 Accessory	7
2. OPERATION	7
2.1 Machine Specification	8
2.2 Machine Dimension	8
2.3 Band Specification	8
2.4 Band Loading	9
2.5 Band Jam Clearance	10
2.6 Feed Tension	10
2.7 Tension Adjustment	11
2.8 Cutter Adjustment	11
2.9 Band Ends Adjustment	12
2.10 Instruction Of Controller	13
3. CIRCUIT DIAGRAM	20
4. SPARE PARTS LIST	21
4.1 Machine Head Unit( ERP No: 10402000)	21
4.2 Guide Plate Unit	23
4.3 Driving Wheel Unit	24
4.4 Driven Wheel Unit	25
4.5 Middle Knife Unit	26
4.6 Rear Knife Unit	27
4.7 Front knife Unit	28
4.8 Cam Shaft Unit	29
4.9 Clevis Unit	30
4.10 Top Sliding Plate Unit	31
4.11 Bottom Sliding Plate Unit	32
4.12 Steel Wire Guiding Roller Unit	33
4.13 Micro Switch Unit	34
4.14 Sliding Plate Swing Arm Unit	35
4.15 Arch Frame Swing Arm	36
4.16 Banding Swing Arm Unit	37
4.17 Sliding Plate Supporting Bracket Unit	38
4.18 Tension Unit	39
4.19 Machine Frame	41
4.20 Left arch frame cover	43
4.21 Right arch frame cover	44
4.22 Top arch frame cover	44
4.23 Left Door Unit	45
4.24 Control Box	46





4.25	Right Door Unit	47
4.26	Guiding Plate Unit	48
4.27	Band Roll Plate	49
4.28	Door safety switch bracket	49
4.29	Band Roll Core Unit	50
4.30	Dispenser Unit	51
4.31	Armature Unit	52
4.32	Magnet Yoke Unit	53
4.33	Machine Bottom Plate Unit	54
4.34	Arch Unit	55
4.35	Band Way Unit	57
5.	TROUBLESHOOTING	58
6.	MAINTENANCE	60



## 1. PREFERENCE

This operation manual is intended to introduce the automatic banding machine. A copy should be kept with the machine at all times. Anyone who works with or on this machine should read and understand the operator manual and follow the instruction carefully.

### 1.1 Safety Instruction

This manual records important instruction and cautions, please read carefully

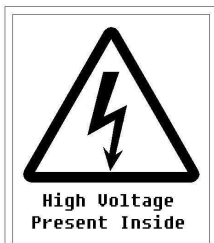
Definition: " ⚠ Warning" or " ⚠ Caution"

Warning ⚠ Can cause injure to yourself or severely damage the product.

Caution ⚠ The product can be severely damaged.

### 1.2 Warning Label

The following labels are on the machine. Caution labels should be kept in good condition.



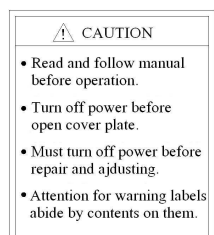
#### Labels about electrical components

Turn off power and pull out plug during any repair or adjustment.



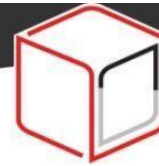
#### Labels about Heater

Heater temperature can reach 230degree. Avoid touching any element.  
Turn off power and wait for heater to cool.



#### Warning on working machine

Never insert hands, head or any other part of body into the arch way during strapping operation







### General Warning



- \*Read operation manual carefully.
- \*Cut off power and pull out plug before any repair, maintenance and adjustment.
- \*Abide by notes, caution, warning labels on the machine

## 1.3 Installation Attention


### 【Location】

-  **Warning** Electrical wire should be kept well. Any damage or disconnection of wire may cause an electrical shock.
-  **Warning** Electrical wire must be kept from moving parts which may damage wire surface and cause an electrical shock.
-  **Warning** Electrical wire must be kept away from oil and water or any other substance Which may cause malfunction.
-  **Warning** Application temperature: -10°C ~ +40°C

### 【Setting】






-  **Warning** Please use the wire which comes with the machine.
-  **Warning** Please use a grounded plug.

### 【Move】

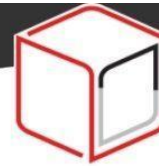
-  **Warning** Cut off power supply and pull out the plug before moving the machine.

## 1.4 Usage Attentions

### 【Operation】

-  **Warning** Don't open cover plate during operation, moving parts may hurt you.
-  **Warning** Don't remove safety guards and control panel during operation.
-  **Warning** Don't touch rotating part which may hurt you.
-  **Warning** Don't touch the heater and its accessories when powered on.
-  **Warning** There is a cooling period(heater) after powered off.





**⚠ Warning** Don't place your hand or fingers into strapping arch

**⚠ Warning** Please cut off power supply during lightning, which may damage electronic components..

**⚠ Warning** Maximum loading weight is 30kg for the table top.

**[Repair·Other]**

**⚠ Warning** Only trained technician can repair, maintenance and adjustment the machine.

**⚠ Warning** Power must be turned off, during repair, check, clearing etc

**⚠ Warning** Don't modify the machine by yourselves.

**⚠ Warning** Please clear tape residue from time to time.

**⚠ Warning** Don't use work method, material and tools not referred in manual.

**Accessory**

Following accessories are packed with the machine

- Manual and parts lists** 1pc
- Kits tool** 1set
- Others** Certificate、wearing parts etc

**2. OPERATION**

**2.1 Machine Specification**

Model No	STEP Band 1000 Banding
Band Material	W 19.2mm X TH 0.12mm X L150m
Band Specification	Kraft Paper /OPP film
Banding Speed	≤ 3s
Banding Tension	5~40N
Package Dim.	Max : 460X200 Min : 30X10

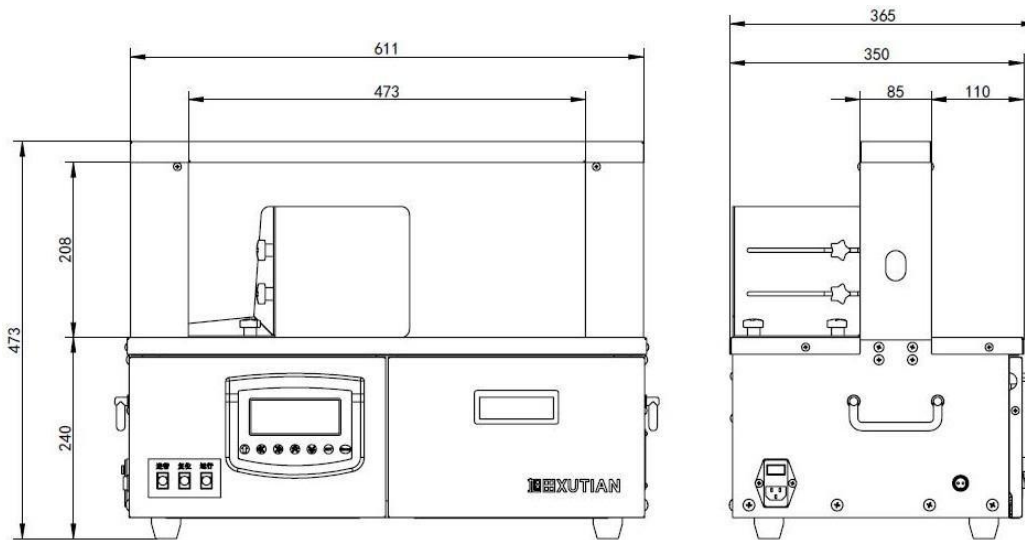




Machine dim(LXWXH)	630X364X474
Power Supply	220V 50Hz/60Hz ;110V 60Hz
Electrical Power	80W
Net Weight	32.5Kg

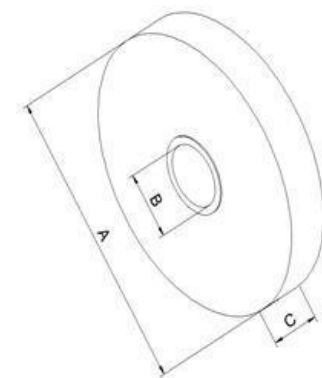
Note : Any modifications for out dimension, power supply won't be informed in advance.

### 2.2 Machine Dimension



### 2.3 Band Specification

ITEM	SIZE A (max)	SIZE B	SIZE C	MATERIAL
PW(B)8029150	160mm	40mm	29.2mm	Kraft Paper
FTP12029150	160mm	40mm	29.2mm	OPP





### Band Requirement:

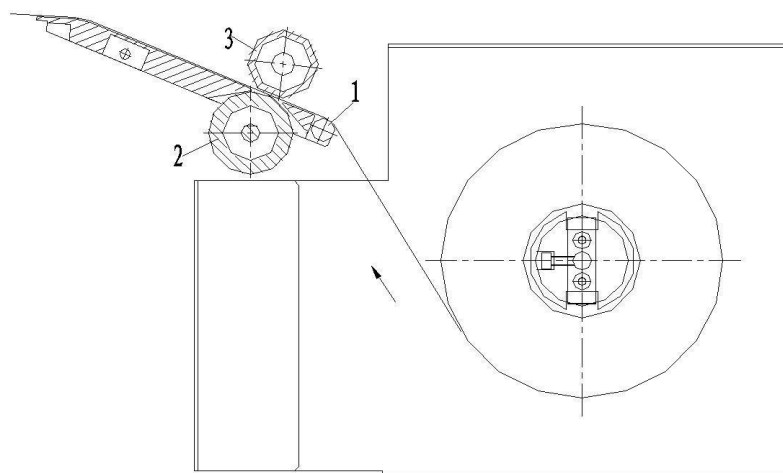
1. Band must be straight with correct width in any places. It Could not be wrinkled otherwise it will case feeding problem.
2. The tolerance for Core diameter Size B must be smaller than 1mm, otherwise it could not hold the core tight.

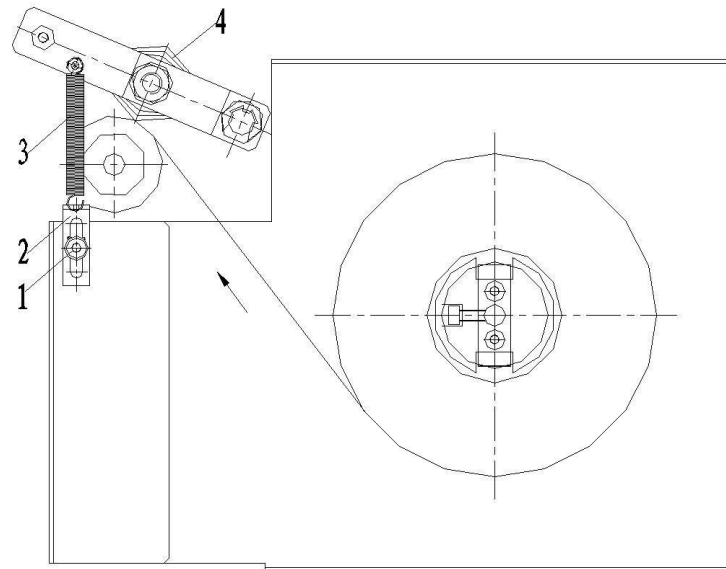
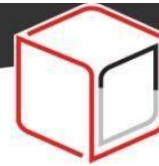
### 2.4 Band Loading

**Warning** ⚠ Please check band width and thickness to insure they are compatible with the requirements of the machine.

**Caution** ⚠ Feeding direction should be the same as the following figure.

- ★ Open the right door.
- ★ Put band roll onto the nylon wheel,take attention to feeding direction.
- ★ Find the band end on the roll and begin threading.
- ★ Follow the figure, pull band over transition wheel 1.
- ★ Feed band manually until band end pass through driver 2 driven wheel 3.
- ★ Press feed button





## 2.5 Band Jam Clearance

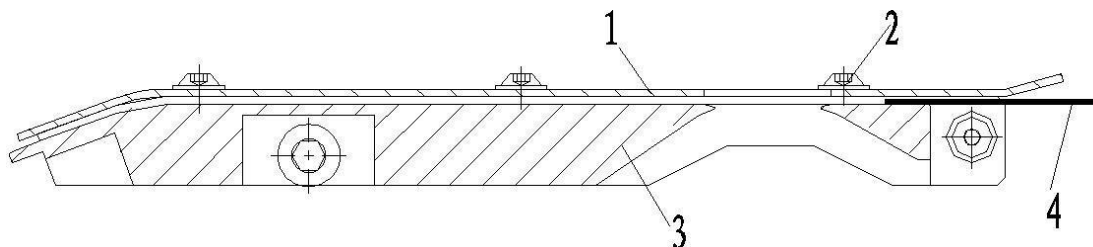
**Warning** ⚠ When adjusting, power must be turned off, plug must be pulled out.

When band blocks the feeding guide, please take the jammed band out as following and restart

Method 1 Push the jammed tape out of the guide way with a plate

(width less than 30mm, thickness less than 0.8mm) by threading it between 1 and 3.

Method 2 Failed in method 1, loosen screw 2 and open cover 1, take jammed band out

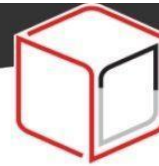


## 2.6 Feed Tension

★ Indicated in following figure, loosen screw 1.


★ Adjust the position of part 2 to increase or reduce band-feeding spring, The tension of spring affects feeding-tension.

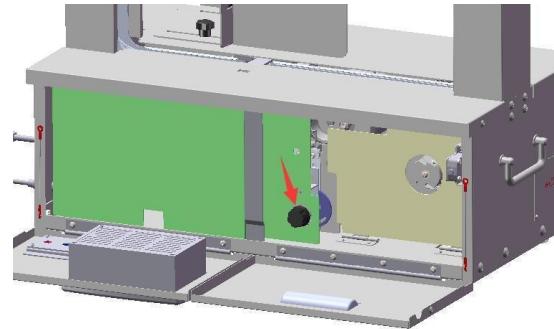




## 2.7 Tension Adjustment

★ Indicated in right figure, rotating black knob to adjust tighten tension. Clockwise to increase tension, Counterclockwise to reduce tension. There is some tension tolerance if the band thickness is different.


 **Caution:** When use paper band, it's suggested to take a medium to small tension, or paper band may break and fail to weld.



## 2.8 Cutter Adjustment

 **Warning:** Before adjustment, you must turn off power supply and pull out electrical plug.

The cutter is a kind of wearing part, we adopt separate style for front knife and cutter for an easy replacement and a low cost.

 **Attention:** Check the figure of front knife and cutter below. Part 3 is front knife. Part 2 is cutter. Part 1 is a tightening screw which supplies part 2 and 3 cutting power. Suitable compressing force between Part 2 and Part 3 is very important. If too tight, it will cause front knife and cutter can not drop down. If too loose, it will cause cutting failure.

### Adjusting method:

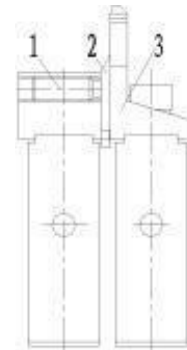
1. Remove the band from guide plates
2. Remove the machine top cover
3. Press "Enter" button on control box, when cutter comes to the top position turn off the power immediately.
4. Use wrench to rotate part 1 to adjust the compressing force between part 2 and part 3. Please adjust 90 degree each time.
5. If it fails to cut the band after rotating part 1, please replace cutter.



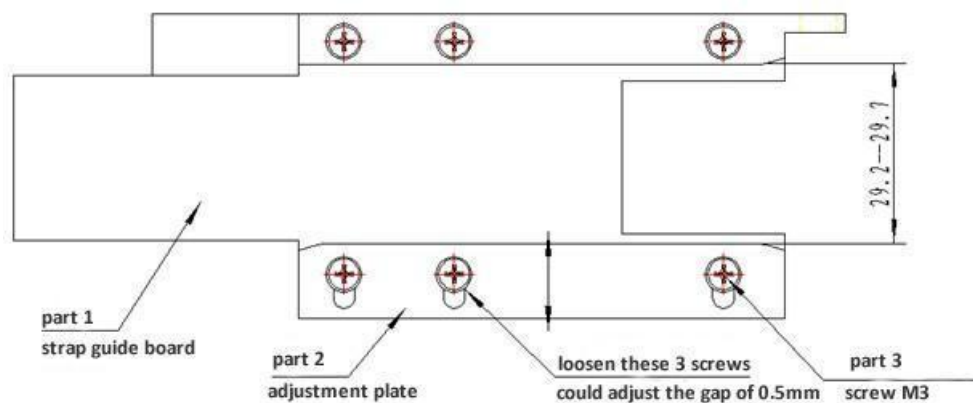


### Follow below steps to replace the cutter:

1. Turn off the power
2. Open the table top cover
3. Remove the springs of the three knives
4. Remove the screw of the heater cable.
5. Press down the plate (part 4) inside a hole which located on the left arch to open the tape guide, then take out the end knife, cutter in proper order.
6. Take out the cutter
7. Tighten the screw of part 1 about 3-5 turns. Assemble the springs and the cutter together and put them back to the original position and make sure they can move up and down smoothly.



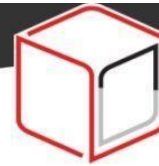
### 2.9 Band Ends Adjustment



### As show in the figure:

- A. The default band guide width is 29.7.
- B. If your band width is less than 29.7, you should follow instructions below to adjust the band guide width to make a good seal.
  1. Turn off the power, open the table top cover.
  2. Counter-clockwise release the cross head screws(part 3) for one cycle
  3. Put tape into the band guide.
  4. Adjust the guide plate (part 2) slightly, which should be 0.5mm wider than the band
  5. Tighten the 3 screws(part 3)
  6. Close the table top cover and tighten the screws





### **Important Notification**

Anytime, while the band is stuck or need to be removed from the band guide, please make sure do not pull the band from band guide too aggressively, which will damage the machine and deform the band guide . Please follow steps as below:

1. Press "ENTER" twice on the control box,
2. Take away the stuck band
3. Press "ENTER" again
4. Press"FEED"

## **2.10 Instruction Of Controller**

This machine adopts AC power(220V/50/60Hz), there is a gate switch besides main power switch.When open the tape gate,machine will turn power itself;

**2 work modes:** manual model and automatic model(System Default)

**Automatic mode:** starting signal comes from a sensor under the cover plate. Machine starts and finishes a banding cycle when it receives a signal from sensor and will be ready for next cycle after the package left sensor.

**Manual mode:** machine is manual operated by buttons on control panel. Press "Start" for a banding cycle. After a waiting interval, machine enters into standby mode for the next cycle.

3 buttons on the left are respectively"Feed, Reset,Start"from left to right.

1. Feed : In standby state, press down for tape feeding,leave it for stopping.
2. Reset: Press down to reset original state.
3. Start: Under manual model,press down for banding circles.



- ✧ **When machine is not at home position or band is not fed to sealing position, machine can not start banding process properly. Please press "Reset" button to make machine back to original state and feed band to sealing position.**

**7 keys on controller, read carefully for their function as follows**



- 1. Up Arrow:** Back to previous menu.
- 2. Left Double Arrow:** move cursor to left.
- 3. Right Double Arrow:** move cursor to right.
- 4. Up Double Arrow:** when setting parameter value, press this key to increase value. **5. Down Double Arrow:** when reset parameter, press this key for decreasing value. **6. SET:**
  - (1) After entering into parameter setting page, press "set", relative value begins to flash, then press double arrows to increase or decrease the value, and press "enter" to input the value setting.
  - (2) Press "set" when in main menu to enter system settings including Language setting and Factory default setting

**7. Enter:**

- (1) When machine is not in parameter setting state, Press "enter" to use machine Step function to make movements step by step. It will help to check machine working state and remove jammed band in the feeding guide.
- (2) When in reset parameter,press"enter" to confirm a value input.

### 2.10.1 Parameter Setting

Brand and model appear on the main screen when power is on to change parameters setting. press the "right" button at the bottom of the main screen to enter set-up menu.

#### Setup interface :



Press buttons according to the arrow direction to enter sub-menu

Press"Up Arrow"button to go back to previous menu.

Press"Right"button to enter into mode selection page

Press"Left"button to enter into running parameters setting interface.

Press"Down"button ,control box will give a warning notice "buzz". Then it goes back to homepage and parameters will be restored to factory default settings.(Press "Set" button in setup menu page will enter system menu.)

1. **Working Mode Selection:** Press "Right" button to enter into work mode selection page (shows as below)



The mode that is currently selected will be shown by a black dot. Press "Left" or "Right" button to choose the work mode, press "Up Arrow" to go back to previous menu.

2. **Parameter Setting :** Press "Left" button to enter into running parameters setting page. (Shows as below):



#### Parameters Definition :

① **Pre-heat time :** time for heating the heater element. To make heater temperature reach working temperature quickly-default setting 0.5 means 5 seconds (value range: 0-99.9)

**Note:** Please increase warm-up time accordingly when working environment temperature is low

② **Heater on time:** Heater heating time--default setting: 0.12 stands for 0.12s(value range 0-9.99)

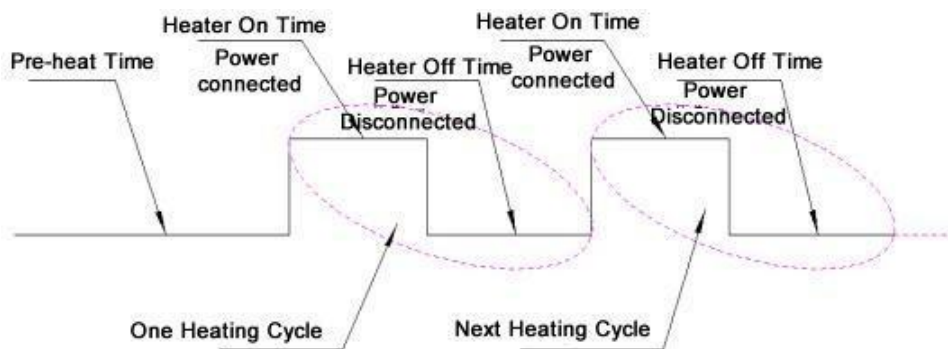
**Note:** If the band is coated with thick plastic, please decrease the value setting to 0.08-0.10 for kraft paper band.

If it is OPP plastic band, the best value setting is 0.11-0.13.

③ **Heater off time:** Heater without power connected time-default setting :0.3s(value range 0-9.99)

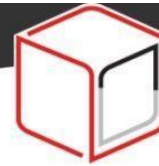
**Note:** If heater temperature is too high, Please **decrease** heater on time or **increase** heater off time. Range in one second is preferred.

If heater temperature is too low, Please **increase** heater on time or **decrease** heater off time.



④ **Band-feeding time:** default setting: 1.2s(value range: 0-9.9)

**Note:** if band material is changed or band feeding fails frequently due to machine wearing, increase or decrease band feeding time accordingly. The best value setting is 0.5-1.0



⑤ **Band-Banding time:** default setting: 0.7s (range 0-9.9)

**Note:** If band material is changed or banding tension is not tight enough, increase or decrease band feeding time accordingly. The best value setting is 0.3-0.5.

⑥ **Waiting time:** Under manual Mode, this is the time to remove the packaged goods from the table top. The machine goes back to home position automatically when setting time is reached. default setting: 1.50s (range: 0-9.9)

**Note:** If you won't remove the bundled goods from the table top immediately, increase or decrease waiting time accordingly.

\*\*\*All parameters are well set at the factory, please don't adjust parameter setting if unnecessary. If machine fails to operate because of wrong parameter setting, please enter into "set up menu" press "Reset" to go back to factory fault parameter setting.

#### **Adjustment Method :**

Press "left" or "right" button to choose the parameters, parameter in black shadow is the one which is currently selected

Press "SET" button, Flashing parameter is ready to set. Press "up" or "down" arrow to adjust value.

Press "Enter" to confirm a parameter setting. If don't press "Enter", parameter won't be input.

### **2.10.2 System Setup Menu**

At system setup menu page, press "set" to enter system setup menu, this menu is used for language setting and port detecting. This menu doesn't affect the working parameters, just for better machine debugging.



1. **System system interface shown as below :**



Press "right" button to enter language setting menu according to the sign.

2. **Port checking:**

Press left arrow to enter port checking page. You can check if every sensor and switch work properly.

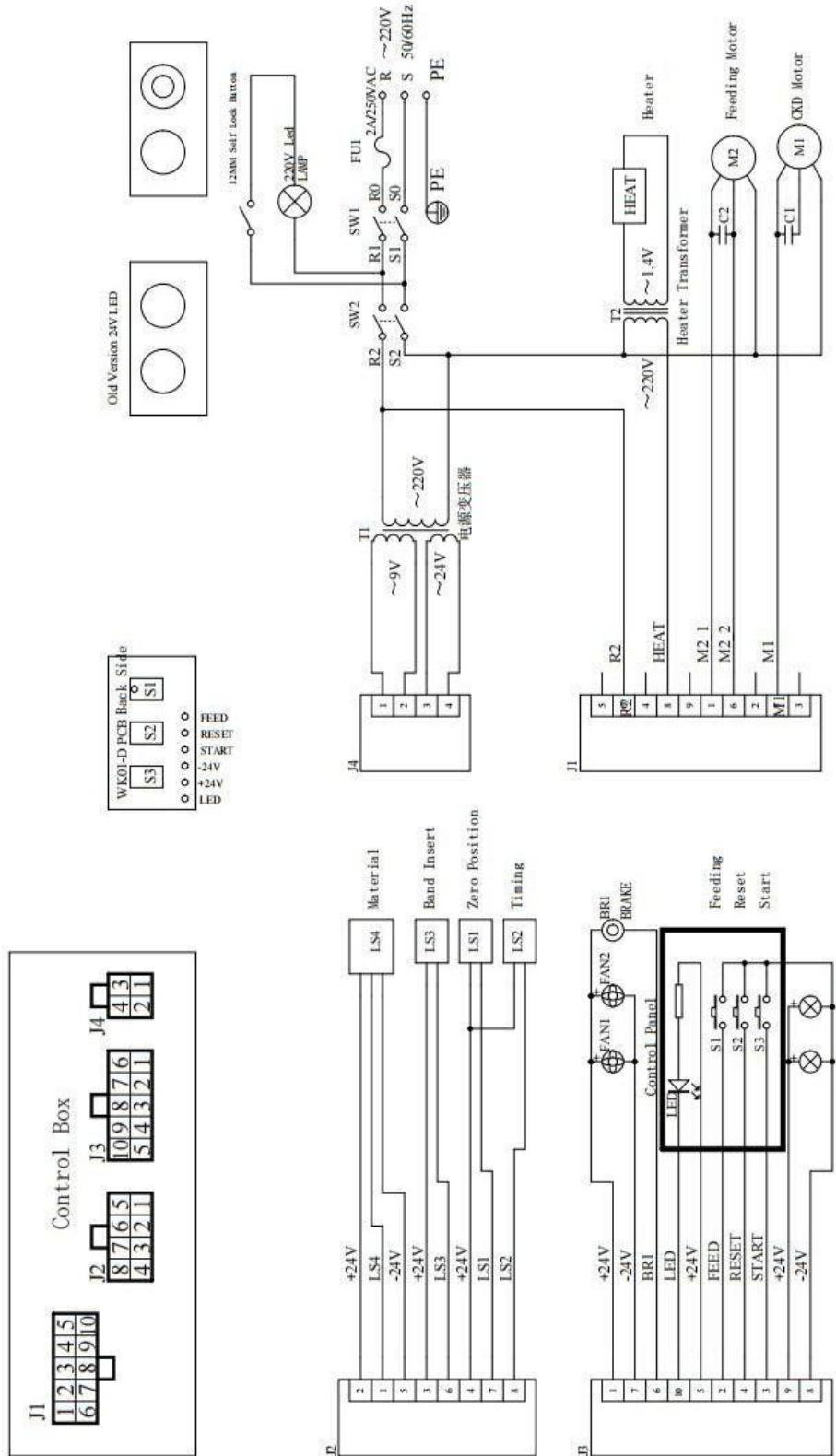


When switch detect the signal, the icon becomes black color. Press back to previous page.

3. **Language Setting**

If your machine is allowed for language exchange, you can select after press "Set".

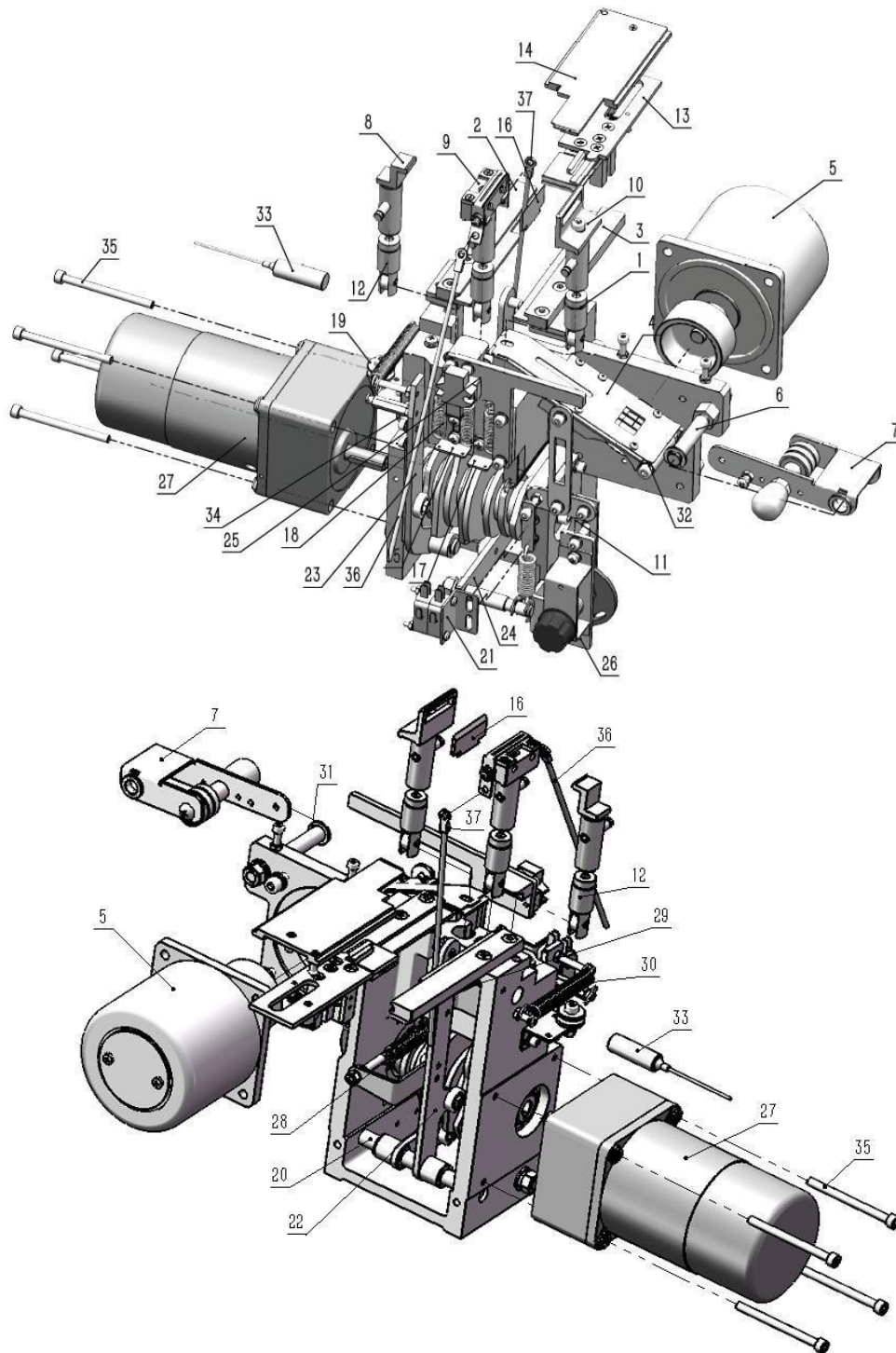
### 3. CIRCUIT DIAGRAM

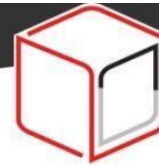




## 4. SPARE PARTS LIST

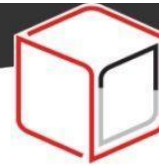
### 4.1 Machine Head Unit( ERP No: 10402000)





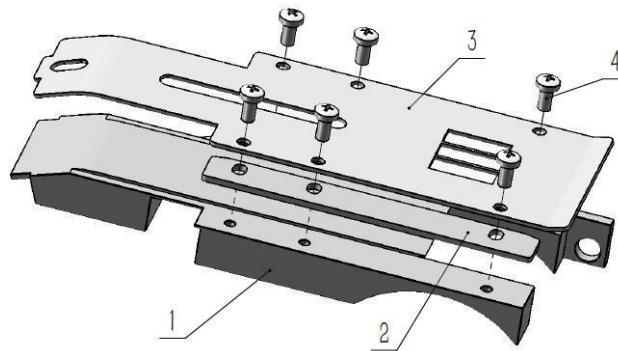
No	ERP NO	Part No	Name	QTY
1	10404043	WK02-14-14-V1	Machine heart base	1
2	10404047	WK01-14-31	Left sliding slot	1
3	10404046	WK01-14-30	Right sliding slot	1
4	10402000A 10302004	WK02-14-18-00 WK02-20-14-18-0 0	Guide way unit (30MM) Guide way unit (20MM)	1
5	10402001	WK02-14-19	Driving wheel unit	1
6	10404022 10304001	WK01-14-08-05-V1 WK01-14-08-05A-V 1	Driven wheel rotating shaft(30MM) Driven wheel rotating shaft(20MM)	1
7	10402008 10302002	WK01-14-08A WK02-20-14-08 A	Driven wheel bracket unit (30MM) Driven wheel bracket unit (30MM)	1
8	10402007	WK01-14-15	Rear knife unit	1
9	10402006	WK01-14-16	Middle blade base unit	1
10	10402005	WK01-14-17	Front knife unit	1
11	10402002	WK02-14-21A	Cam shaft unit	1
12	10402004	WK01-14-20	Clevis Unit	3
13	10402012	WK02-14-27	Bottom sliding plate unit	1
13	10302005	WK02-20-14-27	(30MM) Bottom sliding plate unit (20MM)	1
14	10402011	WK01-14-26	Top sliding plate unit	1
15	10405017	WK01-14-03-V1	Knives Spring holding bracket A	1
16	10406043	WK01-14-16-01-V3	Middle Blade	1
17	10405018	WK01-14-05	Knives Spring holding bracket B	1
18	10406012	WK01-14-02-V1	Knife Spring	3
19	10402010	WK02-14-01	Steel wire guide roller unit	1
20	10404048	WK01-14-23-V1	Swing arm shaft	1
21	10402003	WK01-14-07-00	Micro switch unit	1
22	10402013	WK01-14-25A	Sliding swing arm unit	1
23	10402014	WK02-14-28	Arch frame swing arm unit	1
24	10402015	WK01-14-29	Banding swing arm unit	1
25	10402018	WK02-14-06-00	Sliding plate supporting bracket unit	1
26	10402009	WK02-30DC-14-32-00	Tension Unit	1
27	60220007	YN80-25/80JB30G10	Reduction Motor	1
28	10406015	WK01-14-04	Sliding plate swing arm spring	1
29	10406014	WK01-14-09	Sliding plate tension spring	1
30	10406016	WK01-14-10	Arch frame swing arm tension spring	1
31	60630052		Spacer 16x10x0.2	2





32	10404045	WK01-14-18-04-V1	Transition Wheel	1
33	60210602	FL7M-3J6HD	Approximate switch	1
34	10406013	WK01-14-11	Cushion B	2
35	60615048-1	GB/T70.1-2000	Hexagon Bolt M5x65	4
36	10406039	L=650x6 平	Long heating cable	1
37	10406040	L=300x6 平	Short heating cable	1

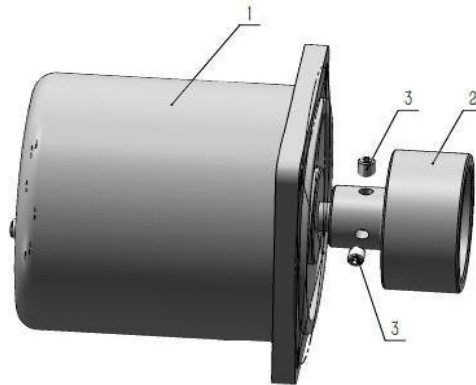
#### 4.2 Guide Plate Unit



No	ERP NO	Part No	Name	QTY
1	10404044	WK02-14-18-01-V4	Guide Plate (30MM)	1
	10304005	WK02-20-14-18-01-V2	Guide Plate (20MM)	
2	10405020	WK02-14-18-03	Adjusting Plate	1
3	10405019	WK02-14-18-02-V3	Guide plate cove (30MM)	1
	10305029	WK02-20-14-18-02-V2	Guide plate cove (20MM)	
4	60616016-1	GB/T818	Cross pan head screw M3x6	6

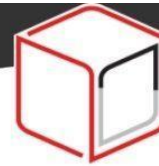


### 4.3 Driving Wheel Unit

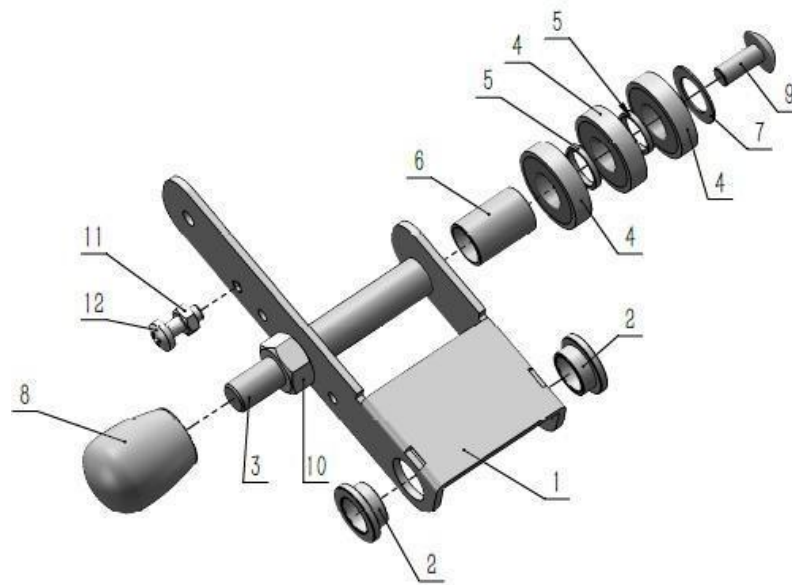


No	ERP NO	Part No	Name	QTY
1	60220003	YN90-40Z	1Phase Motor	1
2	10404033-1 10304006-1	WK02-14-19-01-V2 WK02-20-14-19-01-V 2	Driving wheel (30MM) Driving wheel (20MM)	1
3	60613008	GB/T77-2000	Hexagon socket set screw with flat head M5x6	2



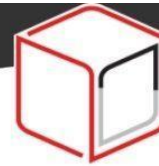


#### 4.4 Driven Wheel Unit

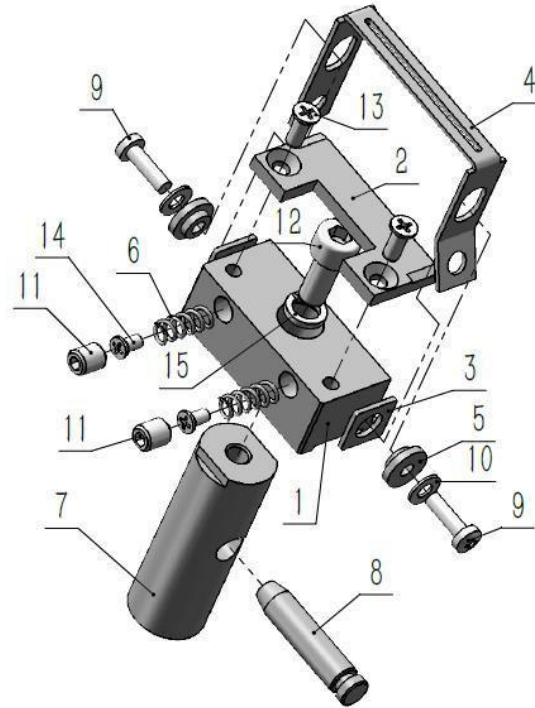


No	ERP NO	Part No	Name	QTY
1	10405001	WK01-14-08-04-V2	Driven wheel bracket	1
2	10406002	WK01-14-08-11	Driven wheel bracket rotating sleeve	2
3	10404021	WK01-14-08-07-V2	Driven wheel fixing shaft	1
4	10406001	WK01-14-08-08A-V2	Driven wheel	3
5	10404019	WK01-14-08-07-01-V2	Short spacer bush	2
6	10404020	WK01-14-08-07-02-V2	Long space bush	1
7	60630052		Adjust washer D16x10x0.2	1
8	10406003	JB/T 7271.4-1994	Handle A type M8×25	1
9	60616087		Cross flat head bolt M5x12	1
10	60620009-1	GB/T6170-2000	Hexagon Nut M8	1
11	60620001-1	GB/T6170-2000	Hexagon Nut M4	1
12	60616045-1	GB/T818	Cross pan head screw M4x16	1





#### 4.5 Middle Knife Unit

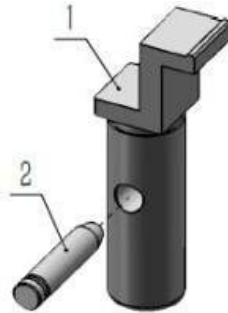


No	ERP NO	Part No	Name	QTY
1	10404025	WK01-14-16-03-V1	Middle blade base	1
2	10405005	WK01-14-16-04	Top insulating plate	1
3	10405004	WK01-14-16-02-V1	Left insulating plate	2
4	10405006	WK01-14-16-05-V1	Heater	1
5	10404026	WK01-14-16-07-V1	Insulating sleeve	2
6	10406005	WK02-14-16-09-V2	Middle blade compressing spring	2
7	10404002	WK01-14-16-08-V1	Clevis	1
8	10404001	WK01-14-15-02	Tension Spring Pin	1
9	60616020-1	GB/T818	Cross pan head screw M3x10	2
10	60630001	GB/T97.1	Plain Washer 3x7	2
11	60613008	GB/T77-2000	Hexagon socket set screw with flat head M5x6	2
12	60615033-1	GB/T70.1-2000	Hexagon socket screw with cap head M5x14	1
13	60616095-1	GB/T819	Cross countersunk head screw M3x8	2
14	60616093	GB/T819	Cross countersunk head screw M2.5x5	2
15	60640002-1	GB/T93	Spring Washer 5	1



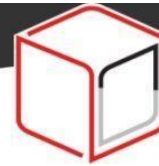


#### 4.6 Rear Knife Unit

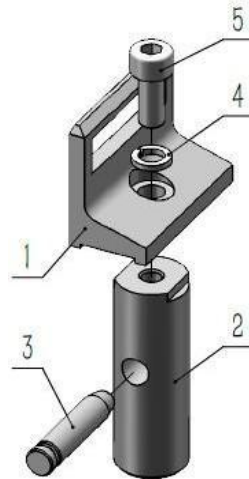


No	ERP NO	Part No	Name	QTY
1	10404000	WK01-14-15-01	Rear Knife	1
2	10404001	WK01-14-15-02	Spring Pin	1





#### 4.7 Front knife Unit

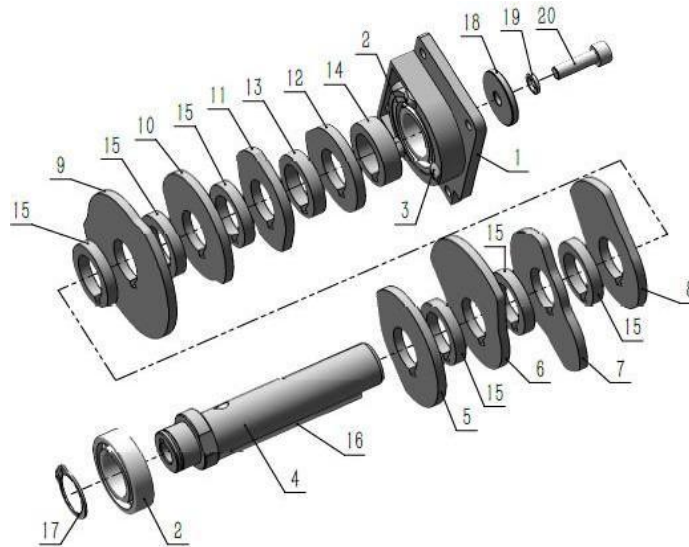


No	ERP NO	Part No	Name	QTY
1	10404027	WK01-14-17-01-V1	Front Knife	1
2	10404002	WK01-14-16-08-V1	Clevis	1
3	10404001	WK01-14-15-02	Tension Spring Pin	1
4	60640002-1	GB/T93	Spring Washer 5	1
5	60615033-1	GB/T70.1-2000	Hexagon socket screw with cap head M5x14	1



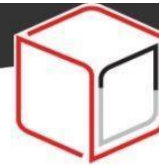


#### 4.8 Cam Shaft Unit



No	ERP NO	Part No	Name	QTY
1	10404018	WK01-14-22	Cam Compressing Cover	1
2	60660074	GB/T276	Bearing 61904	2
3	60616082-1	GB/973	Cross flat head screw M4x6	3
4	10404006	WK01-14-21-01-V1	Cam Shaft	1
5	10404007	WK02-14-21-02	1# Cam	1
6	10404009	WK01-14-21-03	2# Cam	1
7	10404010	WK01-14-21-04	3# Cam	1
8	10404011	WK01-14-21-05	4# Cam	1
9	10404012	WK01-14-21-06	5# Cam	1
10	10404013	WK01-14-21-07	6# Cam	1
11	10404014	WK01-14-21-09	7# Cam	1
12	10404016	WK01-14-21-10	8# Cam	1
13	10404015	WK01-14-21-11	Cam Spacer B	1
14	10404017	WK01-14-21-12	Cam Spacer C	1
15	10404008	WK01-14-21-08	Cam Spacer A	6
16	60682016	GB/T1096	Plain Key A5x5x75	1
17	60651020	GB/T894.1	Shaft Ring 20	1
18	10405000	ZK01-04-10-02	Big Washer	1
19	60640003-1	GB/T93	Spring Washer 6	1
20	60615059-1	GB/T70.1-2000	Hexagon socket cap head screw M6x20	1





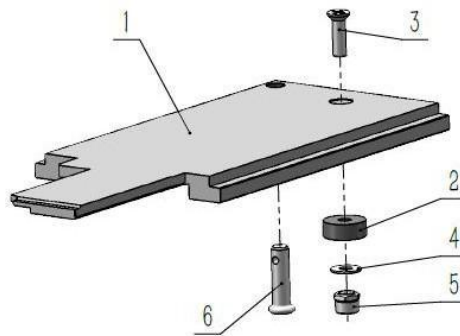
#### 4.9 Clevis Unit



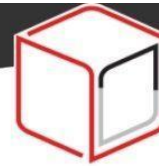
No	ERP NO	Part No	Name	QTY
1	10404003	WK01-14-20-01	Clevis	1
2	60681011	GB/T879.1	Tension pin 5x12	1
3	60660064	GB/T276	Bearing 605	1
4	10404004	WK01-14-20-02-V2	Inner Spring Washer	1



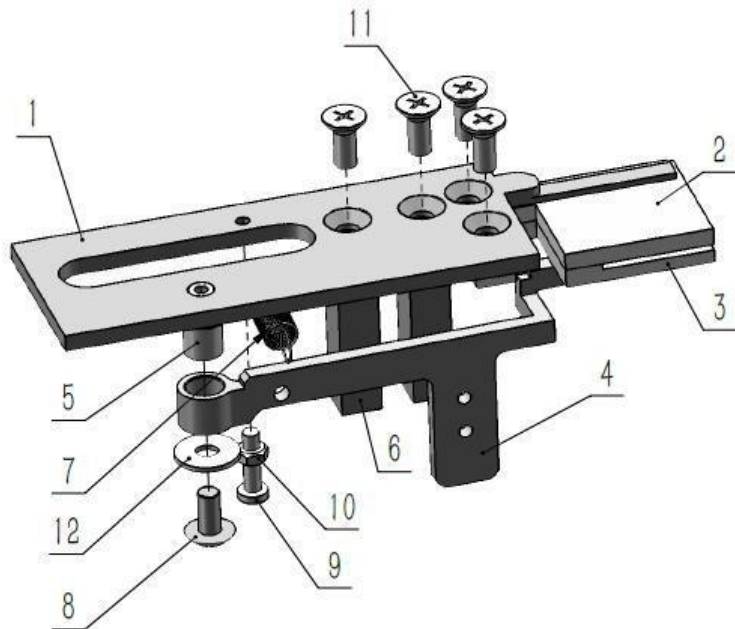
#### 4.10 Top Sliding Plate Unit



No	ERP NO	Part No	Name	QTY
1	10404005	WK01-14-26-01-V 3	Top Sliding Plate	1
2	10406000	WK01-14-26-03-V 1	Sliding Wheel	1
3	60616097	GB819.1-2000	Cross countersunk head screw M3x10	1
4	60630001	GB/T97.1	Plain Washer 3x7x0.5	1
5	60620036	GB/T 889.1-2000	Non Metal Hexagon fixing nut M3	1
6	60681018	GB/T882	Shaft 4x14	1



#### 4.11 Bottom Sliding Plate Unit

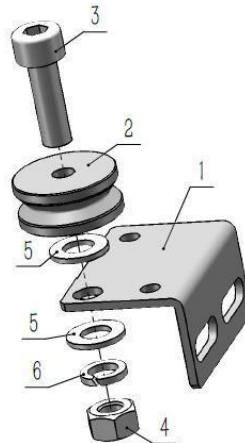


No	ERP NO	Part No	Name	QTY
1	10404034	WK02-14-27-04-V1	Bottom Sliding Plate	1
2	10404038	WK01-14-27-06-V1	Top guide plate	1
3	10404039	WK02-20-14-27-07-V2	Bottom guide plate	1
4	10404035	WK02-14-27-011-V1	Contacting Lever	1
5	10404036	WK02-14-27-02	Rotating Shaft	1
6	10404037	WK01-14-27-03-V1	Sliding Slot	1
7	10406007	WK02-14-27-05	Lever Tension Spring	1
8	60616083		Cross flat head screw M4x8	1
9	60616023-1	GB/T818-2000	Cross pan head screw M3x14	1
10	60620000	GB/T6170-2000	Hexagon Nut M3	1
11	60616104-1	GB/T819	Cross countersunk head screw M4x10	4
12	60630005	4x12x1GB/T96.1	Big Plain Washer 4x12x1	1





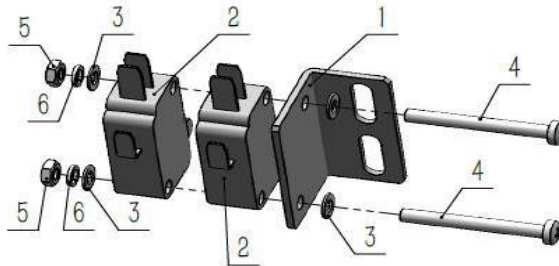
#### 4.12 Steel Wire Guiding Roller Unit



No	ERP NO	Part No	Name	QTY
1	10405013	WK02-14-01-01-V1	Guiding Roller Bracket	1
2	60660142	0621UU625	Guiding Roller With Bearing	1
3	60615034-1	GB/T70.1-2000	Hexagon socket cap head screw M5x16	1
4	60620005-1	GB/T6170-2000	Hexagon NutM5	1
5	60630010-1	GB/T97.1	Plain Washer 5	2
6	60640002-1	GB/T93	Spring Washer5	1

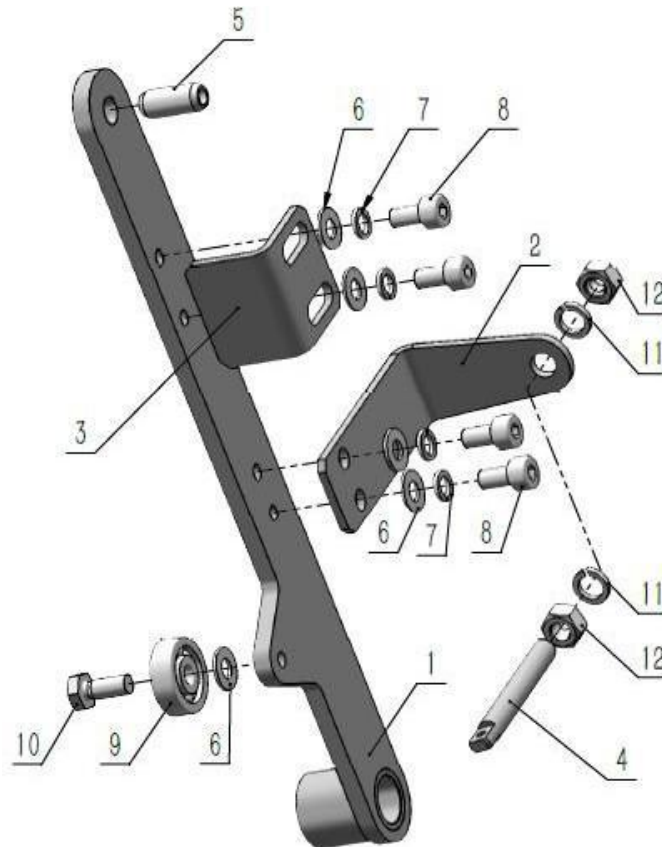


#### 4.13 Micro Switch Unit

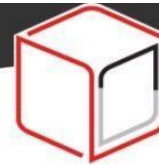


No	ERP NO	Part No	Name	QTY
1	10405015	WK01-14-07	Micro Switch Bracket	1
2	60210566	E42AL-BA12AG-01	Micro Switch	2
3	60630001	GB/T97.1	Plain Washer 3x7	4
4	60616030-1	GB/T818	Cross pan head screw M3x30	2
5	60620000	GB/T6170-2000	Hexagon Nut M3	2
6	60640000	GB/T93	Spring Washer 3	2

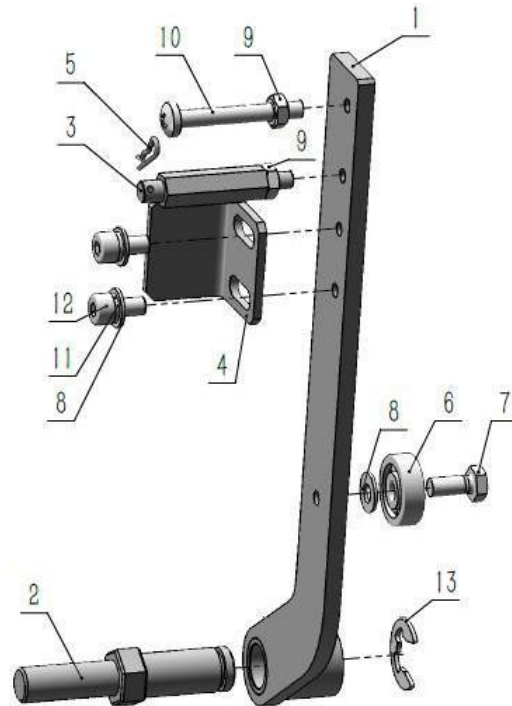
#### 4.14 Sliding Plate Swing Arm Unit



No	ERP NO	Part No	Name	QTY
1	10401000-1	WK01-14-25-01	Sliding Plate Swing Arm	1
2	10405009	WK01-14-25-03	Spring Bracket	1
3	10405008	WK01-14-25-04	Buffer Stop Plate	1
4	10404029	WK01-14-25-05-V1	Spring Screw	1
5	60681003	GB/T879.1	Cylinder Pin 6x14	1
6	60630007	GB/T97.1	Plain Washer 4	5
7	60640001	GB/T93	Spring Washer 4	4
8	60615007-1	GB/T70.1-2000	Hexagon socket cap head screw M4x8	4
9	60660095	GB/T276	Bering 634	1
10	60611003-1	GB/T5782-2000	Hexagon Bolt M4x10	1
11	60640002-1	GB/T93	Spring Washer 5	2
12	60620005-1	GB/T6170-2000	Hexagon Nut M5	2

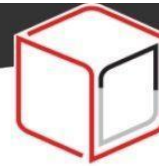


#### 4.15 Arch Frame Swing Arm

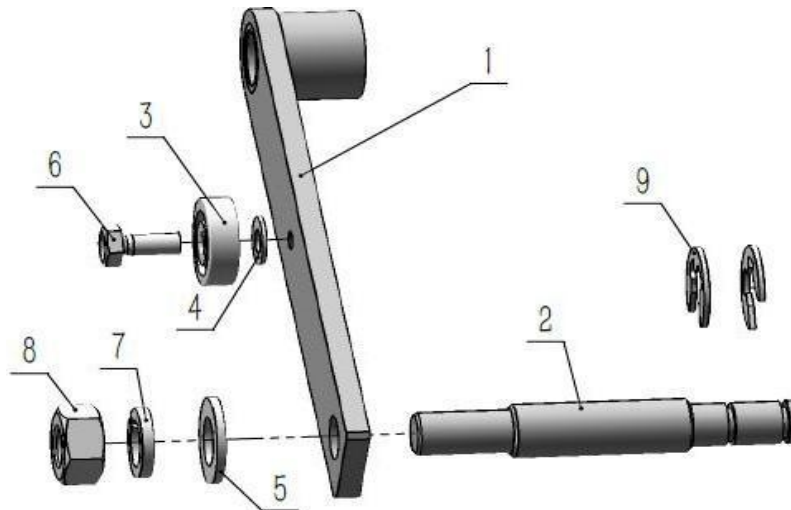


No	ERP NO	Part No	Name	QTY
1	10401001-1	WK02-14-28-02	Arch frame swing arm	1
2	10404030	WK01-14-28-01-V1	Rotating Shaft	1
3	10404031	WK01-14-28-03-V1	Hexagon Stud	1
4	10405008	WK01-14-25-04	Buffer Stop Plate	1
5	60681025	GB/T4329-2001	R Type latch D1.0x16	1
6	60660095	GB/T276	Bearing 634	1
7	60611003-1	GB/T5782-2000	Hexagon Bolt M4x10	1
8	60630007	GB/T97.1	Plain Washer 4x9x0.8	3
9	60620001-1	GB/T6170-2000-1	Hexagon Nut M4	2
10	60616050-1	GB/T818	Cross pan head screw M4x30	1
11	60640001	GB/T93-1987	Spring Washer 4	2
12	60615007-1	GB/T70.1-2000	Hexagon socket cap head screw M4x8	2
13	60651032	GB/T896-1986	Split Washer 8	1





#### 4.16 Banding Swing Arm Unit

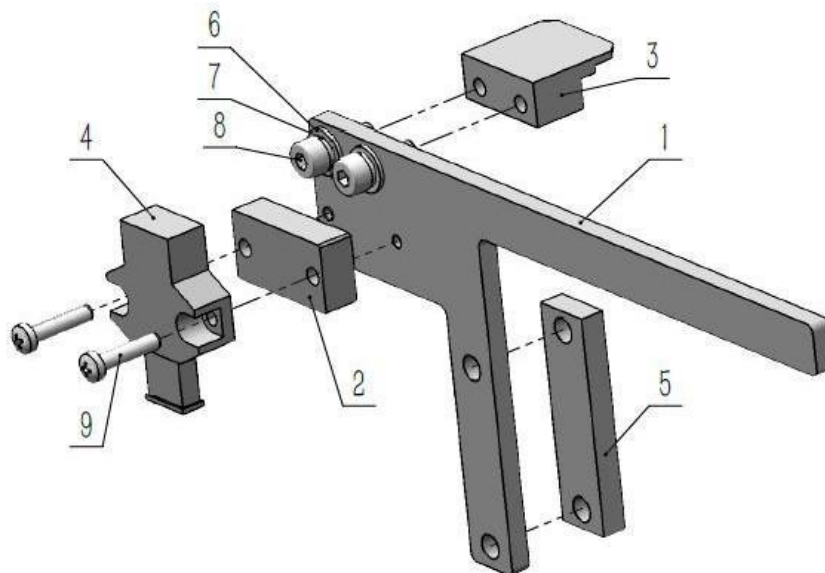


No	ERP NO	Part No	Name	QTY
1	10401002-1	WK01-14-29-01	Banding Swing Arm	1
2	10404056-1	WK02-30DC-14-29-02	Spring Connecting Rod	1
3	60660095	GB/T276	Bearing 634	1
4	60630007	GB/T97.1	Plain Washer 4x9x0.8	1
5	60630020-1	GB/T97.1	Plain Washer 8x16x1.6	1
6	60611003-1	GB/T5782-2000	Hexagon Bolt M4x10	1
7	60640004-1	GB/T93-1987	Spring Washer 8	1
8	60620009-1	GB/T6170-2000	Hexagon Nut M8	1
9	60651032	GB/T896-1986	Split Washer 8	2



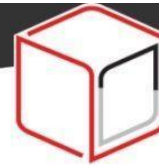


#### 4.17 Sliding Plate Supporting Bracket Unit

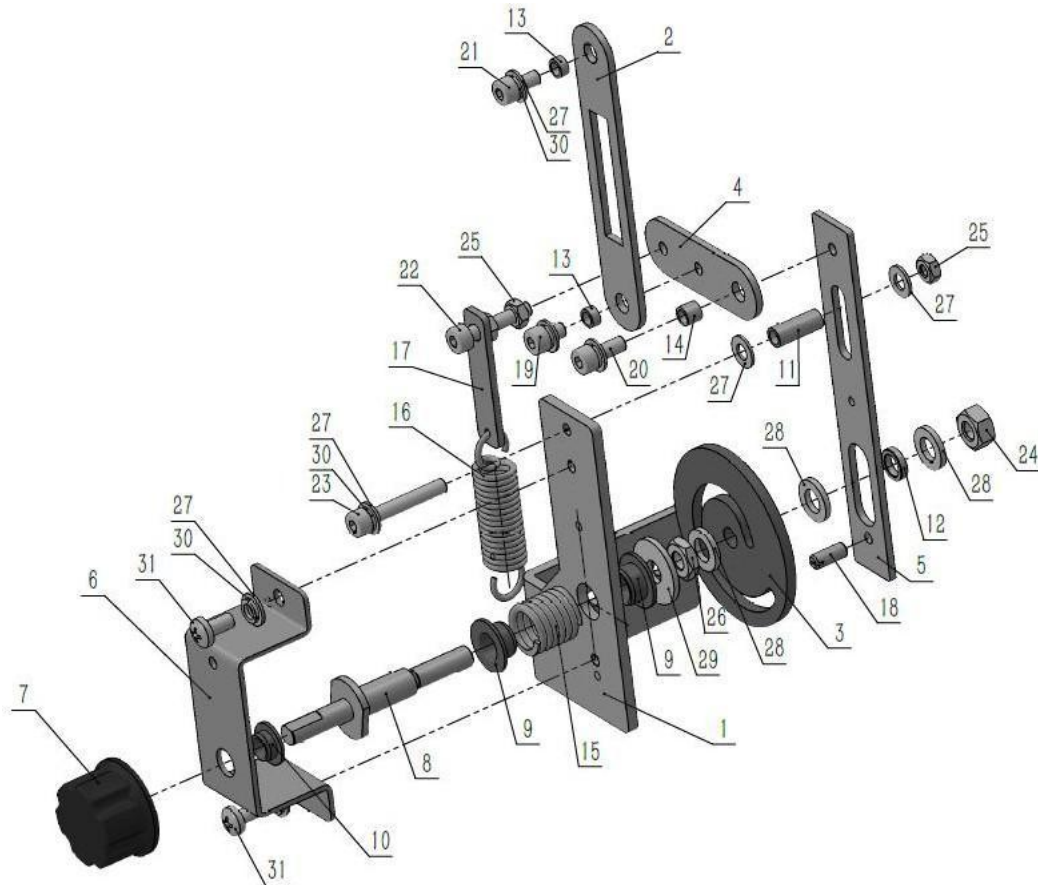


No	ERP NO	Part No	Name	QTY
1	10405014-1	WK01-14-06-V1	Sliding Plate Bracket	1
2	10404041	WK01-14-13-V1	Senor Plate	1
3	10404040	WK02-14-12	Sliding plate supporting block	1
4	60210600	PM2-LH10	Sensor	1
5	10404042	WK02-01-05	Supporting Block	1
6	60630007	GB/T97.1	Plain Washer 4	2
7	60640001	GB/T93-1987	Spring Washer 4	2
8	60615012-1	GB/T70.1-2000	Hexagon socket cap head screw M4x12	2
9	60616023-1	GB/T818	Cross pan head screw M3x14	2



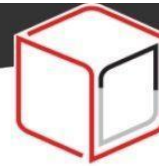


### 4.18 Tension Unit



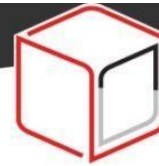
No	ERP NO	Part No	Name	QTY
1	10405075	WK02-30DC-14-32-01	Tension Bracket	1
2	10405076	WK02-30DC-14-32-02	Connecting Pole 1	1
3	10405077-1	WK02-30DC-14-32-03	Tightening Cam	1
4	10405078	WK02-30DC-14-32-04	Connecting Pole 2	1
5	10405079	WK02-30DC-14-32-05	Tightening Pole	1
6	10405081	WK02-30DC-14-32-06	Bracket 1	1
7	60210258	MF-A03 Inner Hole 6	Tension Knob	1
8	10404057	WK03-14-03-09-V1	Small shaft	1
9	10604044	WK03-14-03-10	Plastic Washer	2
10	10604045	WK03-14-03-12	Plastic Spacer 6	1
11	10604046	WK03-14-03-17	Locating Bush 4x14	1



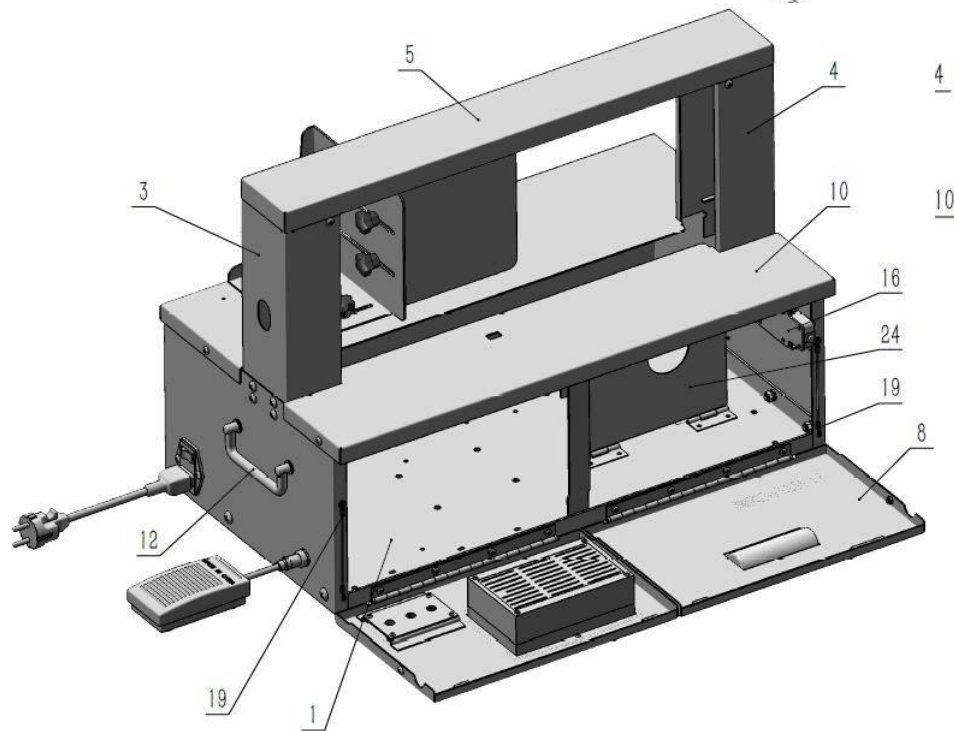


12	10604047	WK03-14-03-18	Washer 692	1
13	10604048	WK03-14-03-19	Washer Bush 4X2.5	2
14	10604049	WK03-14-03-20	Washer Bush 4X5X4.5	1
15	10406042	WK03-14-03-23-V1	Compressing Spring 14	1
16	10406041	WK02DC-14-08-01	Tightening Spring	1
17	10405080	WK02DC-14-08-03	Tightening Pole	1
18	10406049	GB/T 878—1986	Slot screw without head M4x10	1
19	60615006-1	GB/T70.1-2000	Hexagon socket cap head screw M4X6	1
20	60615011-1	GB/T70.1-2000	Hexagon socket cap head screw M4X10	1
21	60615007-1	GB/T70.1-2000	Hexagon socket cap head screw M4X8	1
22	60615019-1	GB/T70.1-2000	Hexagon socket cap head screw M4x20	1
23	60615021-1	GB/T70.1-2000	Hexagon socket cap head screw M4x25	1
24	60620007-1	GB/T6170-2000	Nut M6	1
25	60620001-1	GB/T6170-2000	Nut M4	3
26	60620006-1	GB/T6172-2000	Thin Nut M6	1
27	60630007-1	GB/T95	Plain Washer 4	8
28	60630015-1	GB/T97.1	Plain Washer 6	3
29	60630018-1	GB/T96	Big Washer 6	1
30	60640001-1	GB/T93	Spring Washer 4	6
31	60616039-1	GB/T818	Cross pan head screw M4X8	2





#### 4.19 Machine Frame



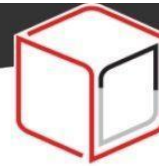
No	ERP NO	Part No	Name	QTY
1	10405062-1	WK02-15-V3	Bottom Cover	1
2	10401009-1	WK02-04-V1	Machine Case	1
3	10401013-1	WK02-03-02	Left arch frame cover	1
4	10401012-1	WK02-03-03	Right arch frame cover	1
5	10401011-1	WK02-03-01	Top arch frame cover	1
6	10405070-1	WK01-13-V1	Supporting Plate	1
7	10402026	WK02-01	Left Door	1
8	10402025	WK02-02	Right Door	1
9	10406035	WK02-19	Horizontal Supporting Plate L=610	1
10	10405071 10305000	WK02-08-V2 WK02-20-08-V2	Front table top (30MM) Front table top (20MM)	1
11	10405072 10305027	WK02-05-01-V2 WK02-20-05-01-V2	Rear table top (30MM) Rear table top (20MM)	1
12	60320008	B-020201	Folding Handle	2
13	60210398	RS6025S24L	6025DC24 Fan	2



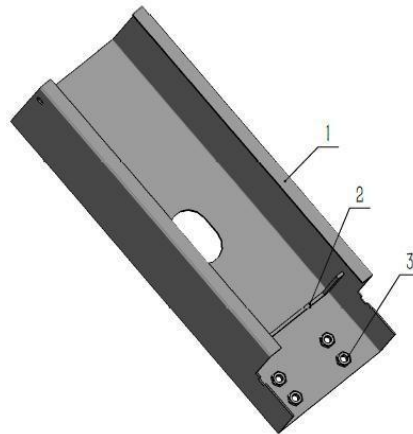


14	10402035	WK02-05	Guiding Plate Unit	1
15	60210389	XD-110-C	IEC Socket	1
16	10402019	WK01-18-00	Door safety switch bracket	1
17	60931028	WK02-BT-117-A	Name Plate	1
18	60210231		Power Cord	1
19	10402024	WK02-06	Door Steel Wire	2
20	60616082-1	GB/973	Cross flat head screw M4x6	12
21	60616087		Cross flat head bolt M5x12	8
22	60210140	Gx16-2 Core	Aviation Plug	1
23	60210586	TFS-201	Pedal switch (Wire 1.9meters)	1
24	10401010	WK02-10	Band roll plate	1



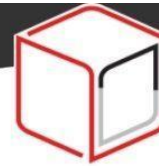


#### 4.20 Left arch frame cover

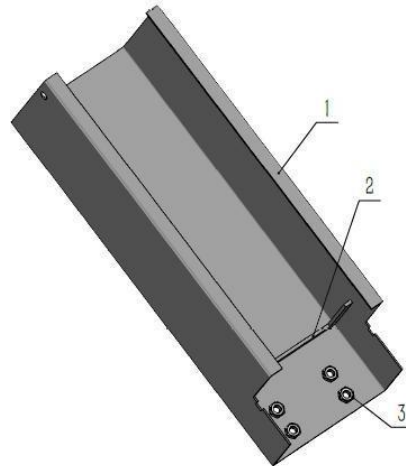


No	ERP NO	Part No	Name	QTY
1	10405068	WK02-03-02A	Left Arch frame cover A	1
2	10405067	WK02-03-02C	Left Arch frame cover C	1
3	60620005	GB/T6170	Hexagon Nut M5	4



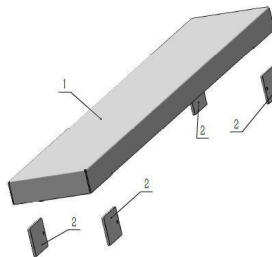


#### 4.21 Right arch frame cover



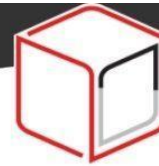
No	ERP NO	Part No	Name	QTY
1	10405066	WK02-03-03A	Right Arch frame cover A	1
2	10405067	WK02-03-02C	Right Arch frame cover C	1
3	60620005	GB/T6170	Hexagon Nut M5	4

#### 4.22 Top arch frame cover

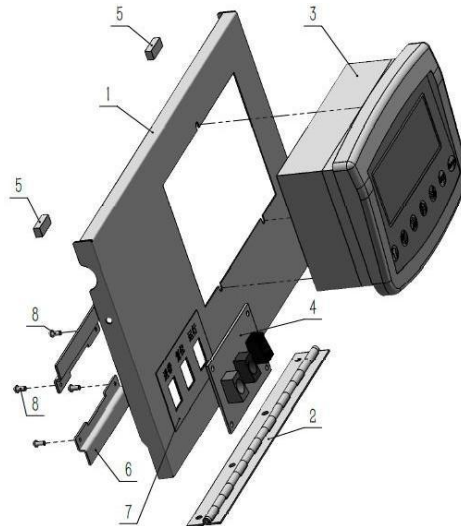


No	ERP NO	Part No	Name	QTY
1	10405064	WK02-03-01A	Top arch frame cover A	1
2	10405065	WK02-03-01B-V1	Top arch frame cover B	4



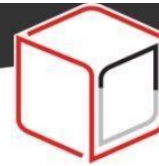


#### 4.23 Left Door Unit

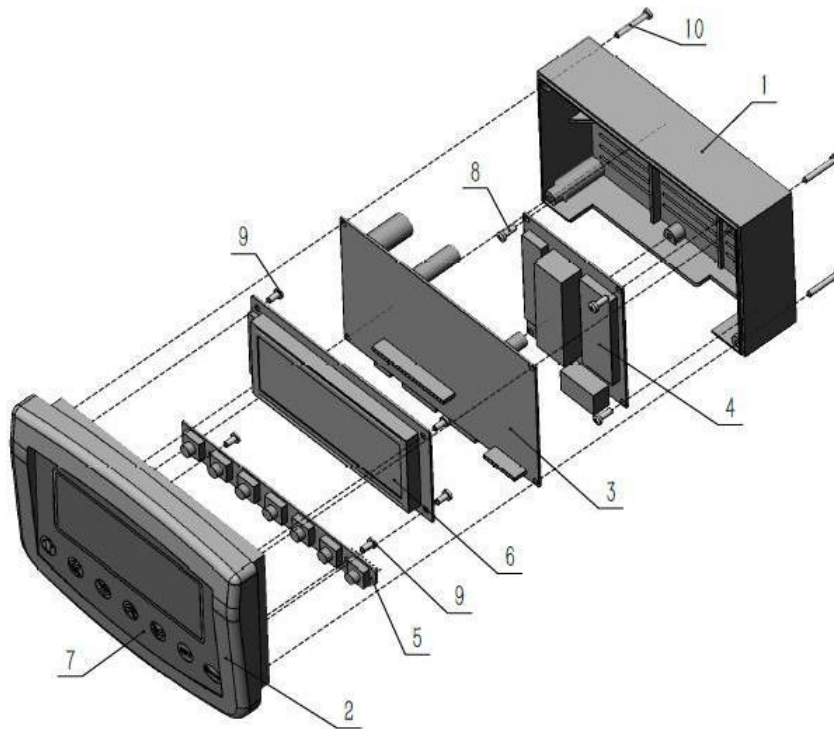


No	ERP NO	Part No	Name	QTY
1	10405021	WK02-01-01A-V1	Left Door	1
2	10406018	WK01-102	Hinge L=230	1
3	60242025	WK01-01-02	Control Box	1
4	60242003	WK01-01-03	Button PCB D Board	1
5	10406019	WK01-02-04	Strong Magnetic 5x7x18	2
6	10405022	WK01-01-012	PCB Bracket	2
7	60921067	WK01-BT-002-V2	Button Film	1
8	60616036-1	GB/T818	Cross pan head screw M4x6	4



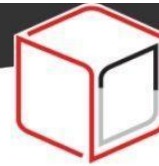


#### 4.24 Control Box

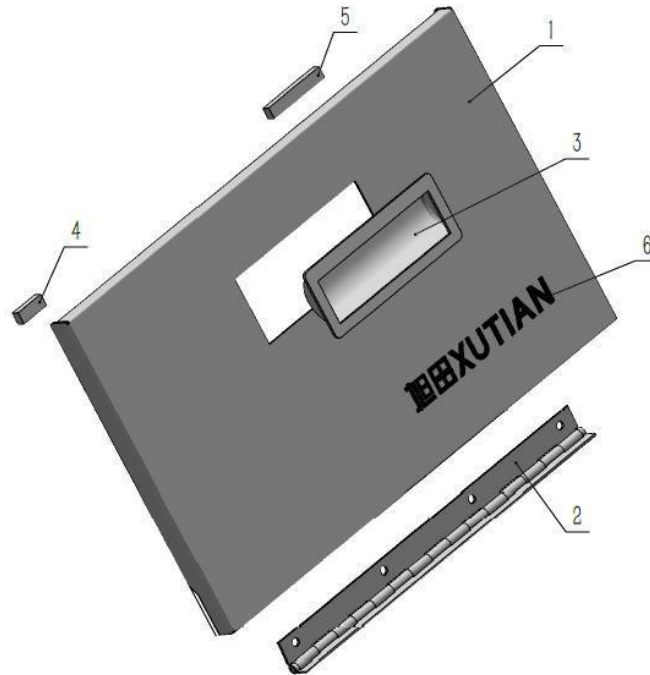


No	ERP NO	Part No	Name	QTY
1	10406010	WK01-01-02-01	Control box rear cover	1
2	10406009	WK01-01-02-02	Control box front panel	1
3	60242004	WK01-A-V1.5	Main control board	1
4	60242005	WK01-B-V1.5	Motor driving board	1
5	60241002	WK01-C-V1.5	Key board	1
6	60260108	WK01-E	Display screen	1
7	60921143	WK01-BT-003-V1	Control panel film	1
8	60616019-1	GB/T818	Cross pan head screw M3*8	4
9	60616016-1	GB/T818	Cross pan head screw M3*6	6
10	60616028-1	GB/T818	Cross pan head screw M3*20	4





#### 4.25 Right Door Unit

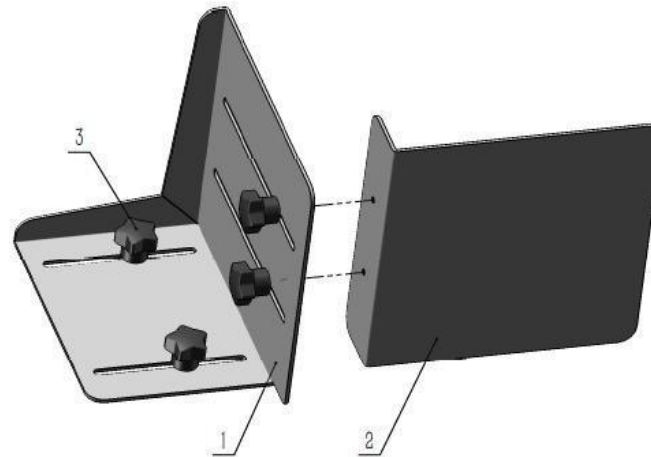


No	ERP NO	Part No	Name	QTY
1	10405023	WK02-02-01A-V2	Right Door	1
2	10406018	WK01-102	Hinge L=230	1
3	TZ0997	S86-05-044	Door Handle	1
4	10406019	WK01-02-04	Strong Magnetic 5x7x18	1
5	10406020	WK01-02-03	Door magnetic 5x7x40	1
6	60921191	WK01-BT-014-V1	Brand Sticker	1



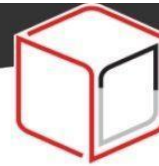


#### 4.26 Guiding Plate Unit

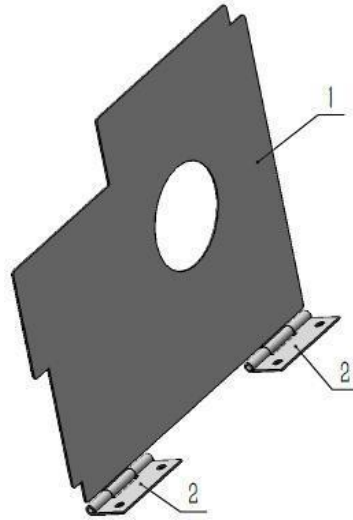


No	ERP NO	Part No	Name	QTY
1	10405073	WK04-05-02-V1	Left guiding plate	1
2	10405074	WK04-05-03-V1	Rear guiding plate	1
3	10406036	M4x8x25	Star knob screw	4



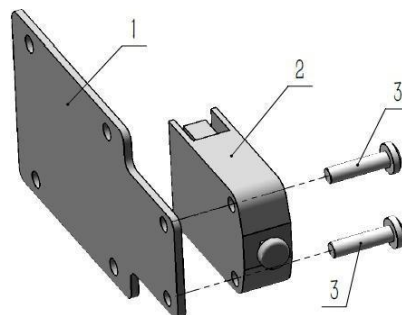


#### 4.27 Band Roll Plate



No	ERP NO	Part No	Name	QTY
1	10405063	WK02-101-V1	Band protecting plate	1
2	10406034	1.2x50x38x36	Hing-hole distance 36	2

#### 4.28 Door safety switch bracket

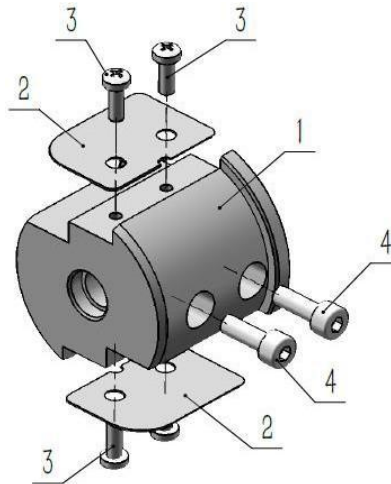


No	ERP NO	Part No	Name	QTY
1	10405016	WK01-18	Safety switch bracket	1
2	60210582	KW-88	Limit Switch	1
3	60616045-1	GB/T818	Cross pan head screw M4X16	2





#### 4.29 Band Roll Core Unit

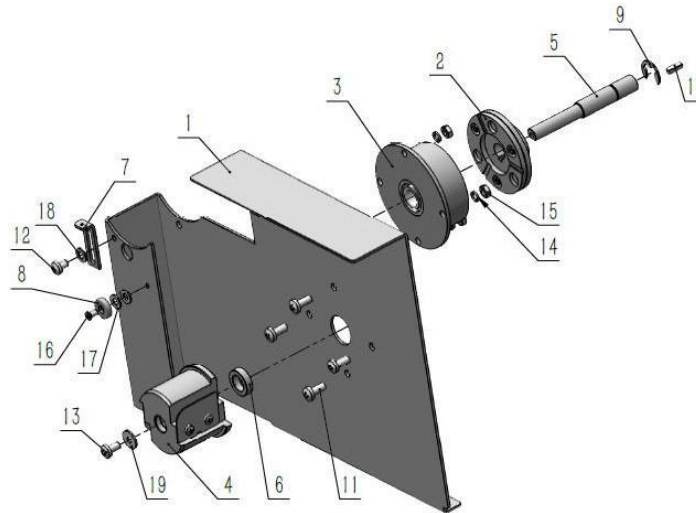


No	ERP NO	Part No	Name	QTY
1	10404051	WK01-11-05V3	Dispenser Core D40	1
2	10405025-1	WK01-11-06-V5	Spring plate	2
3	60616019-1	GB/T818	Cross pan head screw M3x8	4
4	60615012-1	GB/T70.1	Hexagon socket cap head screw M4x12	2





### 4.30 Dispenser Unit

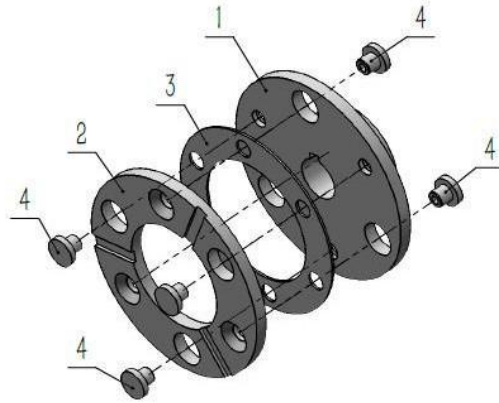


No	ERP NO	Part No	Name	QTY
1	10405024	WK02-11-01-V1	Dispenser Bracket	1
2	10406022A	DL-01-02A	Armature Unit	1
3	10406021A	WK01-11-04B	Magnet Yoke Unit	1
4	10402031 10302001	WK02-11A WK02-20-11A	Band Roll Core (30MM) Band Roll Core (20MM)	1
5	10404049 10304010	WK01-11-03-V1 WK01-11-03A-V1	Dispenser Shaft (30MM) Dispenser Shaft (20MM)	1
6	10404050	WK01-11-07	Dispenser Shaft Spacer	1
7	10405026	WK01-11-02	Band feeding spring bracket	1
8	10406026	WK01-11-08	Magnet 15x3.5x3	1
9	60651032	GB/T896	Split Ring 8	1
10	60682041	GB/T1096	Plain Key C3x10	1
11	60616040-1	GB/T818	Cross pan head screw M4x10	4
12	60616036-1	GB/T818	Cross pan head screw M4x6	1
13	60616083	GB/973	Cross flat head screw M4x8	1
14	60640001	GB/T93	Spring Washer 4	4
15	60620001-1	GB/T6170	Hexagon Nut M4	4
16	60616095-1	GB/T819	Cross countersunk head screw M3x8	1
17	60630001	GB/T97.1	Plain Washer 3	2
18	60630007	GB/T97.1	Plain Washer 4	1
19	60630005	GB/T96.1	Big plain washer 4x12x1	1





### 4.31 Armature Unit

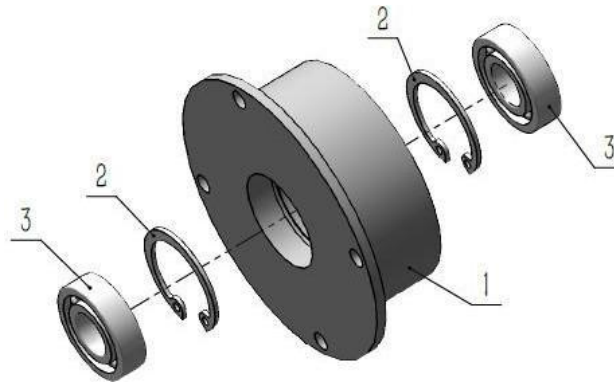


No	ERP NO	Part No	Name	QTY
1	10406024	DL-01-04	Connecting Wheel	1
2	10406022	DL-01-02	Armature	1
3	10406023	DL-01-03	Spring Plate	1
4	10406025	XT8020-0316	Rivet	6





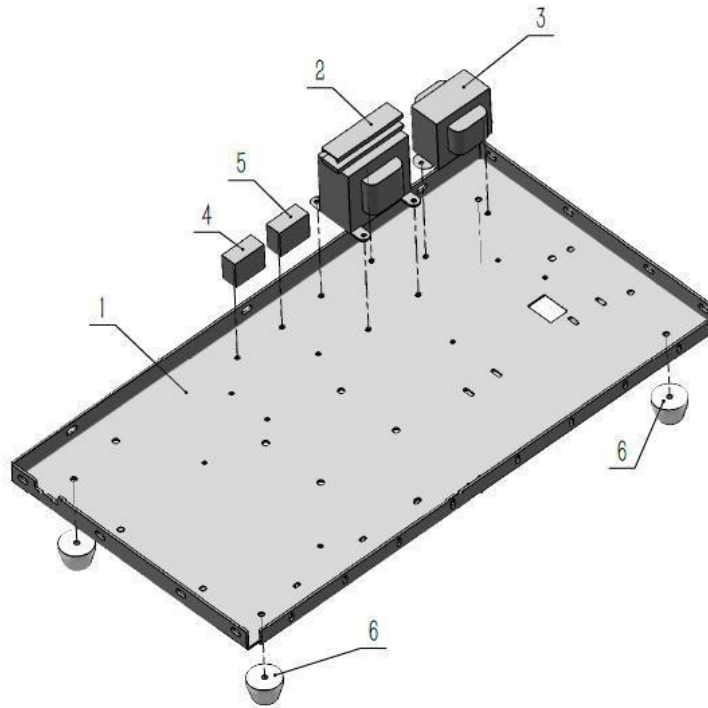
### 4.32 Magnet Yoke Unit



No	ERP NO	Part No	Name	QTY
1	10406021	WK01-11-04-01	Magnet Yoke	1
2	60652001	GB/T893.1	Hole Ring 22	2
3	60660071	GB/T276	Bearing 61900	2



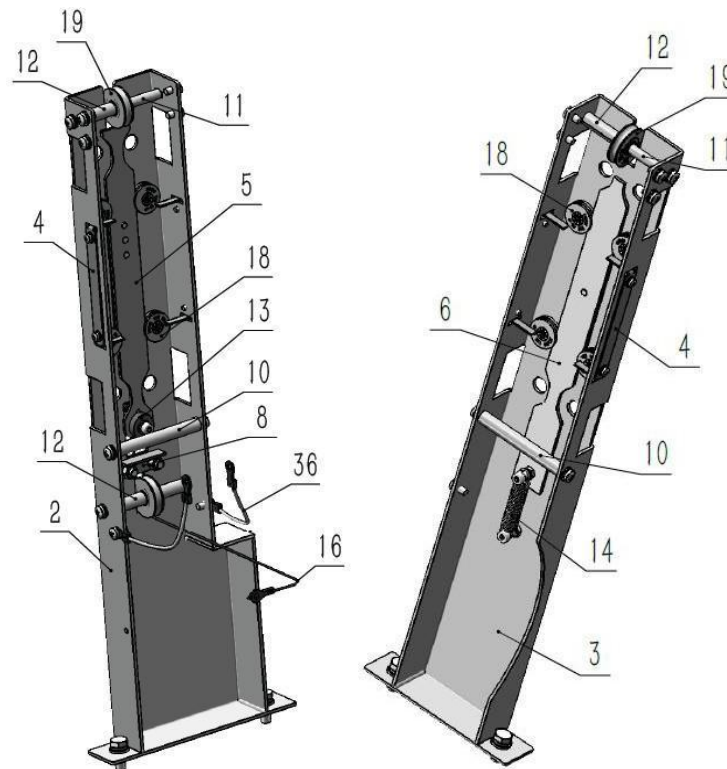
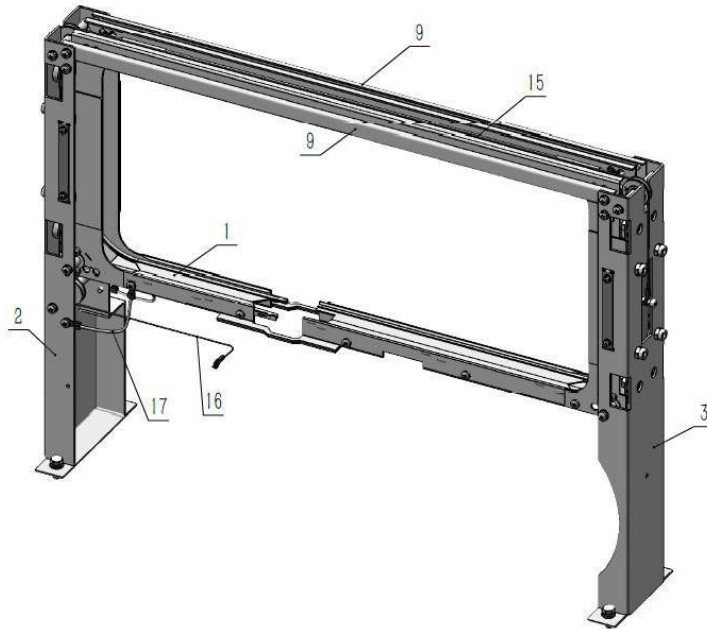
### 4.33 Machine Bottom Plate Unit



No	ERP NO	Part No	Name	QTY
1	10405062-1	WK02-15-V3	Machine bottom plate	1
2	10406038	T-45-10	Big transformer	1
3	10406037	T-23-1	Small transformer	1
4	60210680	2UF	Motor Capacitor	1
5	60220133	3UF	Motor Capacitor	1
6	10406033	WK01-03	Bottom Gasket	4



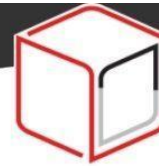
### 4.34 Arch Unit



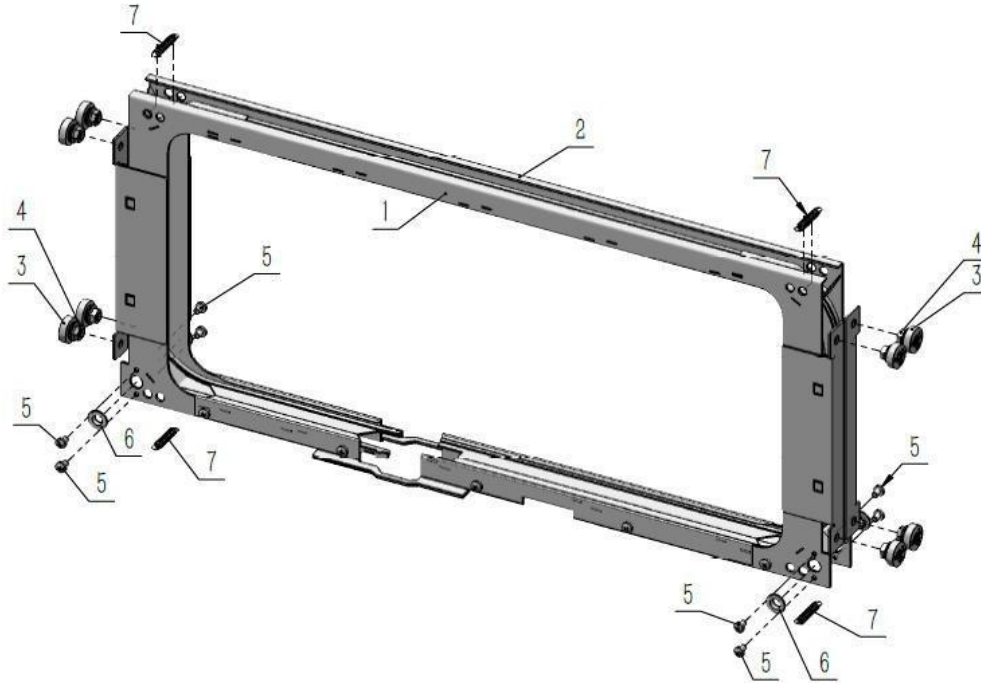


No	ERP NO	Part No	Name	QTY
1	10402027A	WK02-30-03U	Guide way unit	1
2	10401007-1	WK02-03-04HJ-V1	Left arch	1
3	10401008-1	WK02-03-05-V1	Right arch	1
4	10405055 10305001	WK02-03-06 WK02-20-03-06	Band Stop Plate(30MM) Band Stop Plate(20MM)	4
5	10405048 10305002	WK02-03-08 WK02-20-03-08	SS Left sliding plate (30MM) SS Left sliding plate (20MM)	1
6	10405052 10305003	WK02-03-09 WK02-20-03-09	SS Right sliding plate (30MM) SS Right sliding plate (20MM)	1
7	10405053	WK02-03-10	SS Button	1
8	10405051	WK02-03-11	Stopping Plate	1
9	10405054	WK02-03-12	Connecting fix plate	2
10	10404053	WK02-03-20	D8 Shaft	2
11	10404055	WK02-03-21	D6 Shaft	3
12	10404054	WK02-03-22	Bearing Sleeve	6
13	10404052	WK02-03-23-V1	Cushion	1
14	10406030	WK02-03-25	Sliding plate tension spring	1
15	10402030	WK02-03-26	SS long steel wire	1
16	10402029	WK02-03-27	SS short steel wire	1
17	10402028	WK02-03-28	Ground Cable	1
18	10406029	WK02-03-30-V1	Guide roller bearing	8
19	10406032	WK02-03-31	Guide roller bearing	3



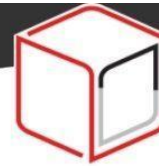


### 4.35 Band Way Unit



No	ERP NO	Part No	Name	QTY
1	10401005 10301000	WK02-30U-17 WK02-20-03U-17	Front guide way(30MM) Front guide way (20MM)	1
2	10401006 10301001	WK02-30U-18 WK02-20-03U-18	Rear guide way(30MM) Rear guide way(20MM)	1
3	10406027	WK02-03-29-V1	Guide roller bearing	8
4	60620040	GB/T 889.1	Non metal hexagon fixing nut M6	8
5	60616082-1		Cross flat head screw M4*6	8
6	10406028	WK02-03-19	Nylon sleeve	4
7	10406031 10306000	WK02-03-24 WK02-20-03-24	Tension Spring (30MM) Tension Spring (20MM)	4





## 5. TROUBLE SHOOTING

### NO.1: Failure to start

NO.	Fault	Remedy
1	safety switch is not closed	close right door,tighten safety switch terminal
2	no fuse in socket or damaged	Replace fuse
3	socket,plug or power circuit loose	power and connection parts inspection
4	PCB problems	examine or replace

### NO.2: Cutting problem

NO.	Fault	Remedy
1	middle cutter blade or front cutter wears	Replace middle cutter blade or front cutter
2	front cutter bolt is loose	tighten front cutter bolt
3	low pressure between middle cutter blade and front cutter	Increase the pressure by tightening the spring of middle cutter blade

### NO.3: Tape gets wrinkled inside the feeding guide

NO.	Fault	Remedy
1	banding tension is too much	decrease banding tension
2	gap between tape guide and driving wheel is too big	adjust gap to be less than 0.2
3	rag or scraps in tape guide	clean tape guide
4	rag or burrs in tape feeding guide	clean tape guide

### NO.4: Banding failure

NO.	Fault	Remedy
1	approachin switch could not g detect signal	1. Contacting plate doesn't reach the furthest position 2. approaching switch position is too low
2	Motor problem	check motor or cable connection

### NO.5 Tape feeding problem

NO.	Fault	Remedy
1	approximate switch could not detect signal	1. Contacting plate doesn't reach the furthest position 2. approaching switch position is too low
2	rag or burrs in tape guide	clean tape guide
3	Motor problem	check motor or cable connection
4	Too much friction between Guide plate and driving wheel	Adjust the gap





**NO.6: Tape loops out of the arch**

NO.	Fault	Remedy
1	Guide way is deformed	adjust space to less than 2.0
2	The connection of the guide plate is not even	outfeed slot connector should be higher than infeed slot connector
3	The space between guide plate is too large	adjust space to less than 2.0

**NO.7: Could not open guide frame**

NO.	Fault	Remedy
1	Guide way is no action or space too small	1.tighten steel wire properly 2.check parts abrasion
2	Guide arch imbalanced	1.tighten steel wire on both sides of guide arch properly

**NO.8: Wrong movement of Cams**

NO.	Fault	Remedy
1	micro-switch loosed or damaged	adjust or replace it
2	Wearing of cams or related parts	Replace
3	PCB programs faults	Replace PCB

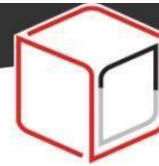
**NO.9: Bad sealing**

NO.	Fault	Remedy
1	heater head is not heating up	1. heater or circuit problem 2. screws connected with wire and heater head get loosened
2	temperature too low	extend heating time by control box(refer to controller OI)
3	temperature too high	shorten heating time by control box(refer to controller OI)
4	pressure between cam and sliding plate not enough	1.sliding plate supporting block loosen 2.cam abrasion 3.elastic spacer under cutter get bent
5	heater head surface not flat	change middle cutter

**NO.10: Feeding button or detecting switch fault**

NO.	Fault	Remedy
1	micro-switch loosed or damaged	adjust or replace it





### NO.11:Sliding plate stuck

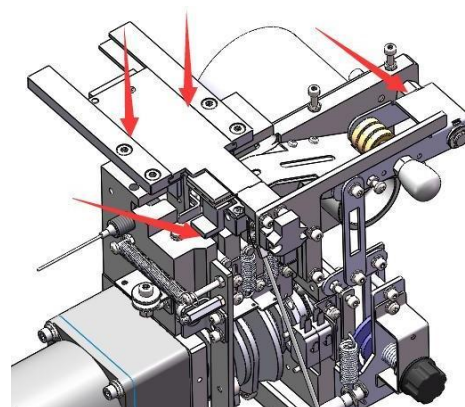
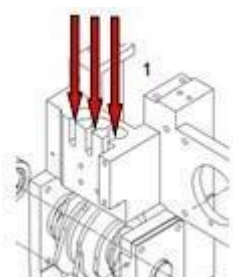
NO.	Fault	Remedy
1	micro-switch loosed or damaged	adjust or replace it

## 6. MAINTENANCE

1. Please cut off power first
2. Clear the inside of machine after daily use.
3. Check power cord and other electronic parts after 4-5 weeks.
4. Check welding cutter, swing arm, guide plate, cutter lever and all moving parts every 1-2 weeks.
5. Check if bolt ,nut are loose every 1-2 weeks.
6. Lubricate moving parts every 4-5 weeks with oil.

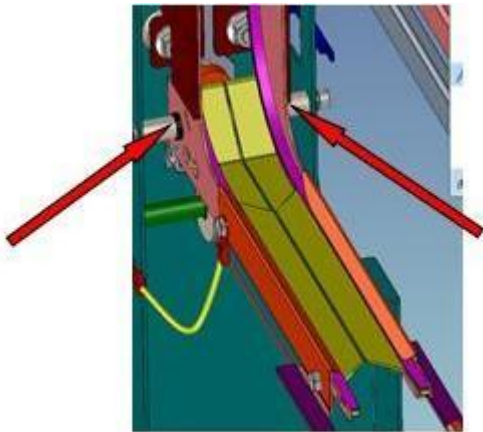
Lubricating parts as below

1. Lubricate cutter lever and guide once a week. Or when cutter is stuck





2. Lubricate shaft sleeve and shaft moving plate Once a week or when guide arch is moving stiffly.





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