

TYPE 086B

SEMIAUTOMATIC BAG CLOSER INSTRUCTION MANUAL



TYPE	MODEL	SERIAL NO.
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GENERAL SAFETY INFORMATION

Be sure the following safety instructions are read, understood and become a part of daily practice when operating or maintaining the closer.

1. Do not attempt to operate the closer until you understand its function. Study the manual carefully.
2. Keep all foreign material away from the drive system.
3. Keep fingers out of the closer and printer and away from any moving parts.
4. The printer cover must be in the closed position before applying power to and operating the closer / printer. Electrical power should be disconnected from the closer while the printer cover is open.
5. Disconnect the power cord before making any adjustments or maintenance. Moving the switch to the “STOP” position does not remove power from many electrical components, nor does it disable the motor. All adjustments, except as noted, are to be made with power disconnected.
6. The closer is normally operated from a counter or table. While the closer is very stable when operated from a flat a solid surface, care should be taken not use it in a way that could cause it to tip or fall from the operating surface.

Kwik Lok 086B Models 100, 200, 200P, 600, 600P Closers are  and  certified.
The 086B Model 700P is not  certified.

For technical support during regular business hours, call your local Kwik Lok distributor. For 24/7 technical support call Kwik Lok Corporation at 1 800-688-5945 if you are in the continental U.S. For those outside the U.S., please dial + 1-509-248-4770.

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THE TYPE 086B MACHINE SEMIAUTOMATICALLY CLOSES PLASTIC BAGS WITH THE STRIOPLOK® CLOSURE OR CLOSURE - LABEL.

- A. The 086B machine has various model options available. Models with the suffix "P" include printers. Model 100 utilizes Series RJ (medium duty) closures. Model 200 utilizes Series R (medium duty) and series S (heavy duty) closures with no adjustments required. Model 200P utilizes Series RL, SL, RLP, and SLP closures. With the addition of the optional label conversion kits, Models 200 and 200P have the ability to use closure - labels. Models 600 and 600P are designed for use with an ARC binding machine. Model 700P is a closure - printer separator. Refer to the Specification Chart for details on all models.
- B. The system will close a wide range of product size variations. The Strioplok closures are available in many closure opening sizes to accommodate a large number of variations in bag width and film material thickness.
- Upon request and upon receipt of sample bags, the factory will gladly recommend the proper closure opening sizes. Use the bag length formula found in the appendix of this manual to help determine the proper bag length needed.
- C. A suggested spare parts inventory is listed in the appendix. To save valuable time, it is recommended that an adequate supply of these parts be kept on hand for needed repairs.

SECTION I

Specifications

086B SEMIAUTOMATIC BAG CLOSING MACHINE SPECIFICATIONS

TYPE	MODEL		CLOSURE	PLASTIC THICKNESS	SPEED (Bags/Min)
	PREFIX	PRINTER TYPE			
086B	100	No Printer	Series RJ	Medium Duty	30
086B	*200	No Printer	Series R & S	Medium & Heavy Duty	30
086B	**600	No Printer	Series L & U	Medium & Heavy Duty	30
086B	*200P	B, C, D, E	Series RL & SL RLP & SLP	Medium & Heavy Duty	30
086B	**600P	B, C, D, E	Series L & U	Medium & Heavy Duty	30
086B	***700P	B, C, D, E	Series RL & SL RLP & SLP	Medium & Heavy Duty	54

*CONVERSION KITS

With the addition of the optional label conversion kits, Models 200 and 200P have the ability to use closure - labels. Three conversion kits are available:

Z0086071 KIT - L LABEL CONVERSION - MODEL 200 AND 200P ONLY
 Z0086072 KIT - U LABEL CONVERSION - MODEL 200 AND 200P ONLY
 Z0086073 KIT - CR LABEL CONVERSION - MODEL 200 AND 200P ONLY

**Model 600 and 600P are equipped with the necessary parts needed to use both the Series "L" and "U" closure - labels.

***Model 700P runs continuously, printing and dispensing separated closures for hand applying to bagged products.

PRINTER TYPE

B: Band Printer - non European
 C: Band Printer - Europe
 D: Type Block Printer - non European
 E: Type Block Printer - Europe

1. The 086B Model P prints on closures or closure - labels as defined in the chart above. The printer uses a type band printhead or a block with grooved rubber type. Contact your distributor or Kwik Lok Corporation for printing supplies.
2. The standard closer is supplied with a table top stand including feet, suction cups or a combination of the two. An optional floor stand is available as well as mounting brackets for an Oliver Slicer.

ADDITIONAL OPTIONS:

Bag Trimmer kits
 Oliver Slicer mounts
 Mount post
 Floor Stand

3. The 086B is available for use with the following electrical power:

115VAC, 60 Hz, 1 amp, single phase
 220 - 250VAC, 50/60 Hz, 0.38 amp, single phase

SECTION I Specifications

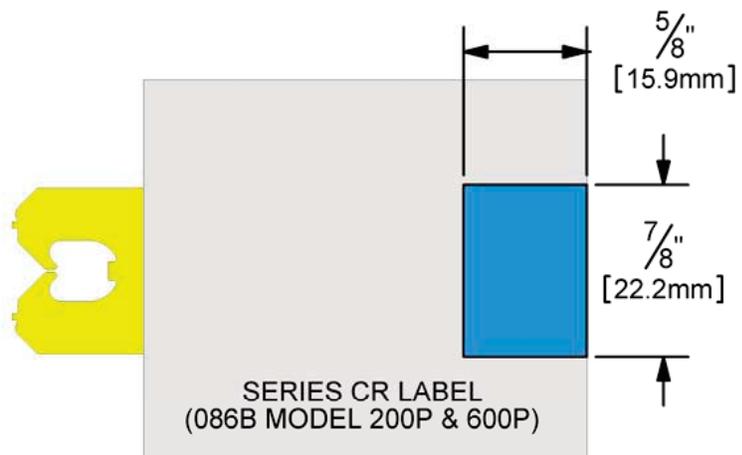
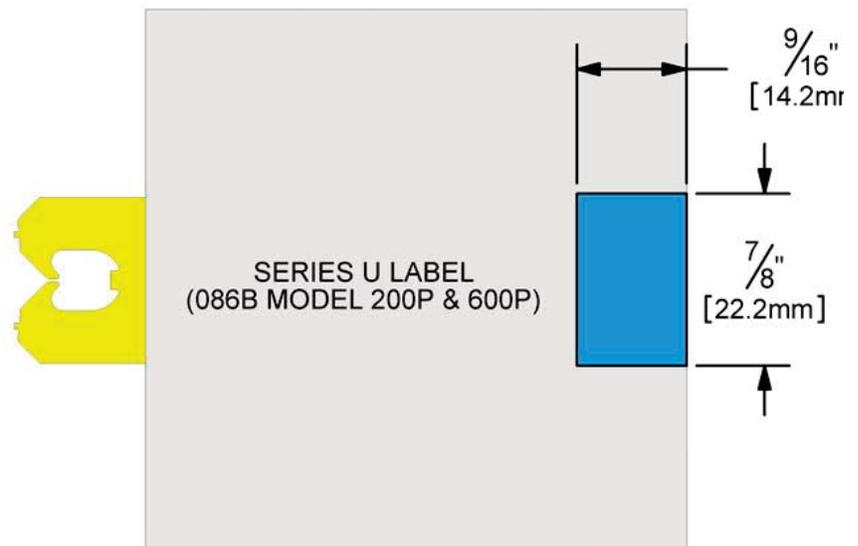
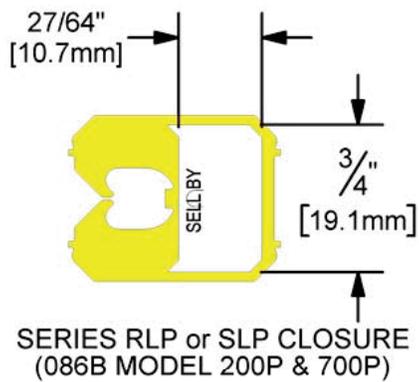
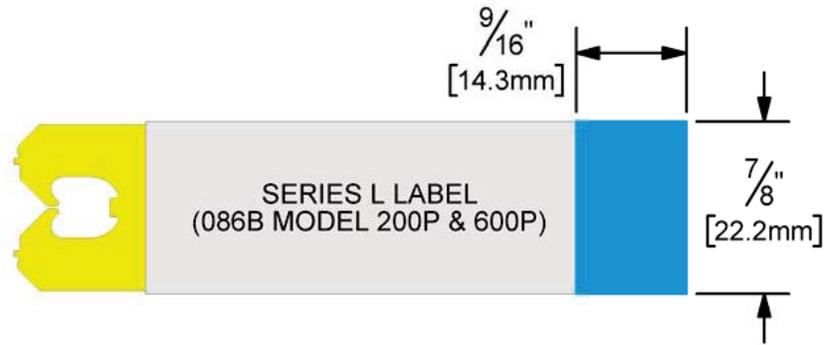
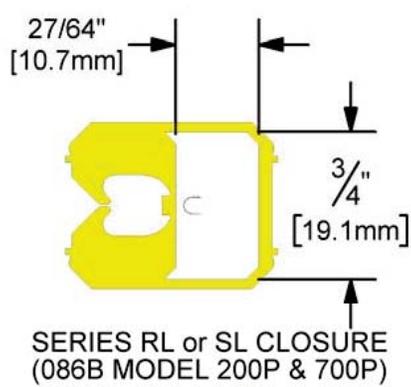
The following is a list of available printer part numbers, closer models used on and their description.

PRINTER PART NUMBER	MODEL	PRINTER TYPE (DESCRIPTION)
P18-00098	PB	Date band (USA and countries other than Japan, European countries and Canada)
P18-00099	PB	Numerical band (USA and countries other than Japan, European countries and Canada)
P18-00100	PB	Date band (Canada)
P18-00101	PB	Date band (Mexico [Spanish])
P18-00102	PB	Date Band (Europe and Russia)
P18-00120	PB	Numerical band (Canada)
Contact® band	PC	Contact band (available in Europe only)
00-001138	PD	Block - 2 line
00-001138	PE	Block - 2 line (utilizes a contact ink roll available in Europe only)

SECTION I Specifications

TYPE 086BP PRINT AREAS

CLOSURE AND CLOSURE - LABELS ARE SHOWN AT FULL SCALE



SECTION II Operation

A. OPERATING SEQUENCE: (Figure 2.1)

The closer is ready to run when the closure is in closing position, with both the power switch and the run switch in the "ON" position, and the "READY" light is on. When the closed bag and closure are removed from the closure track, the machine completes the closing cycle placing the next closure in the closing position. The machine is again ready for the next bag. During the completion of the closing cycle the "READY" light will go off momentarily.

If no closure is available to move into the closing position, the machine will continue to cycle and the "READY" light will flash repeatedly until the run switch is turned to the "STOP" position.

The 086B Model 700P operating sequence is different from the other 086B Models in that it prints, feeds, and breaks off the closure continuously while the run switch is in the "RUN" position. The closer will stop cycling when the run switch is in the "STOP" position or the last closure is manually removed from the track assembly. When a new strip of closures is inserted into the track and the "RUN" switch is in the run position, a press of the green button, located on the side access cover, will begin the continuous cycle of the machine.

THE PRINTER COVER MUST ALWAYS BE IN THE CLOSED POSITION WHEN OPERATING THE CLOSER.

The power switch and light must be off to cut off power to the two sensor switches. Utilizing the power switch instead of the run switch may result in the machine not stopping in the neutral position as required for loading the closure strip. Use the power switch when clearing the machine of debris or performing minor service work.

1. Plug in the closer.
2. Press the power switch to "ON".

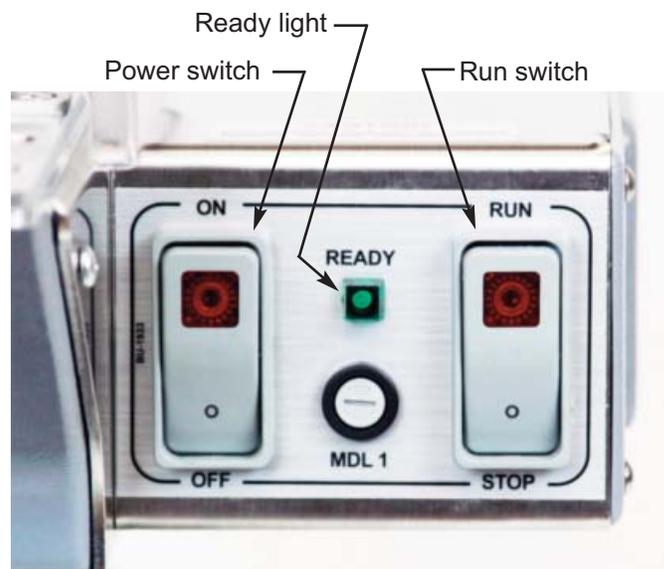


Figure 2.1

3. Slide the closure strip into the closure track until the strip stops (refer to Part B, LOADING A ROLL OF CLOSURES in this section).
4. Press the run switch to "RUN". A closure will move into the closing position, if one is not already there, and the "READY" light goes on indicating the closer is ready for use.
5. Close the bag and remove it from the closer (refer to Part E, CLOSING BAGS in this section).
6. The closer cycles, prints a closure (If a printer Model) and positions a new closure into the closing position, ready for the next bag. The "READY" light will go off momentarily as the closure is loading.
7. If no closure is available to move into the closing position, the machine will continuously cycle and the "READY" light will flash on and off repeatedly until the run switch is pressed to "STOP". Closures can now be loaded into the machine.

SECTION II

Operation

B. LOADING A ROLL OF CLOSURES:

1. Cycle the closer until the closures stop advancing. Avoid cycling the closer more than necessary when there is no closure in the closing position. This will avoid a buildup of ink residue on the closure track.
2. Move the run switch to "STOP" so the mechanism is properly positioned.
3. When closing with closures, insert the closure hub into a new roll of closures. Be certain the closures feed forward from the bottom of the roll.

When closing with labels, insert the closure hub so that the label of the closure is right side up when the closure strip is in the closure track.

4. Install the hub and roll.
5. Open the printer cover and check to see if there is any ink residue on the bottom of the closure track within the printing area. Use a soft cloth or tissue to wipe any ink off the closure track so the ink will not smear on the underside of the closure.
6. Remove the masking tape and feed the end of the strip into the closure track until the first closure has passed the check and is against the stop. Close the printer cover.
7. With the Power switch in the "ON" position, press the run switch to "RUN". The closer will cycle once and move a closure into the closing position. Remove the first three unprinted closures by hand. The closer is now ready to close bags.

C. PREPARING THE PRINTER:

Figure 2.2 & 2.3

(If the machine is a non printer Model, skip to Part E, CLOSING BAGS)

1. Open the printer cover.
2. Select the print image.
 - a. For the band printer, rotate the top of the print-head toward the front of the closer so the selected type characters can be easily viewed through the window on the top of the print head. Slide the selector knob out to select the desired band and rotate the knob to select the desired character. When finished, rotate the bandhead back against the spacer.
 - b. For the typeholder block, remove the knurled knob and slide the printer block off the shaft and spring pin. Place the selected type in the grooves that are the farthest away from the holes in the mounting block. For normal viewing on the closure the bottom edge of the characters should be toward the middle of the block. Center the type from side to side. Replace the block on the shaft and pin so the type is close to the ink roll arm. If the type or typeholder block is not installed correctly, the type will not be inked properly.
3. Unscrew the knob (Ink roll) and position the ink roll between the knob and the cam follower.
4. Mate the ink roll to the end of the cam follower and screw in the knob to secure it. Under most conditions the ink roll can be left on the printer until the ink is used up. The ink roll will not dry out.
5. Close the printer cover.
6. Cycle the printer and discard the unprinted closures.

SECTION II Operation

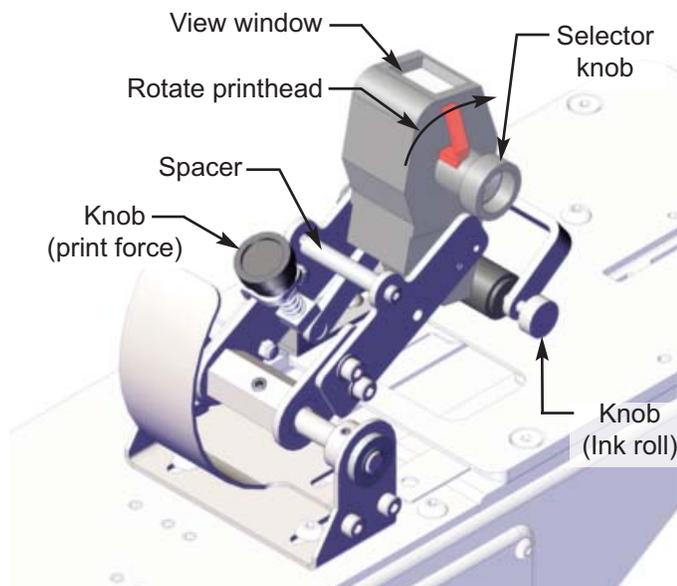


Figure 2.2

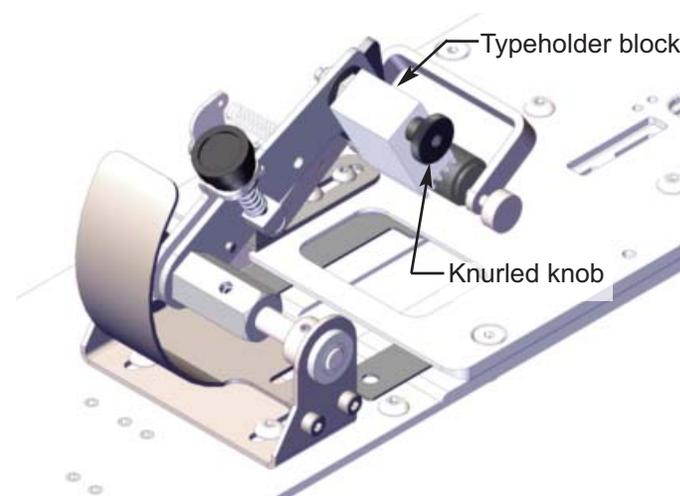


Figure 2.3

D. ADJUSTING THE PRINT FORCE: Figure 2.2 & 2.3

DO NOT USE EXCESSIVE PRINT FORCE TO COMPENSATE FOR PRINTING IMPERFECTIONS.

The operator can adjust the print force.

Always operate the printer with the minimum print force that will produce acceptable printing. A quarter turn of the knob is a large adjustment. If a significant change in print quality is not noticed, return to the previous setting and refer to Section III, Adjustments and Section IV, Trouble Shooting to correct any problems.

When the ink roll will no longer adequately ink the type, replace it. Do not attempt to extend the life of the ink roll by increasing the printing force.

To increase the print force, turn the knob counter-clockwise. If the effort to turn the knob suddenly decreases, the maximum print force has been reached.

To decrease the print force, turn the knob clockwise.

E. CLOSING BAGS: Figure 2.4

1. Grasp the bag as shown. Spin the bag to twist the bag neck. Twisting the bag helps the material to enter the closure smoothly.
2. The lower hand should form a "V" to trap all of the bag material. This helps to completely insert the bag material into the closure opening.
3. Do not jam the bag material straight into the closure opening. The top hand should lead the bottom hand. Follow up with the lower hand until all of the bag neck is in the closure. A tight package is accomplished by holding the contents of the bag snugly up against the underside of the closure track.
4. Remove the closed bag with a horizontal motion.

SECTION II

Operation

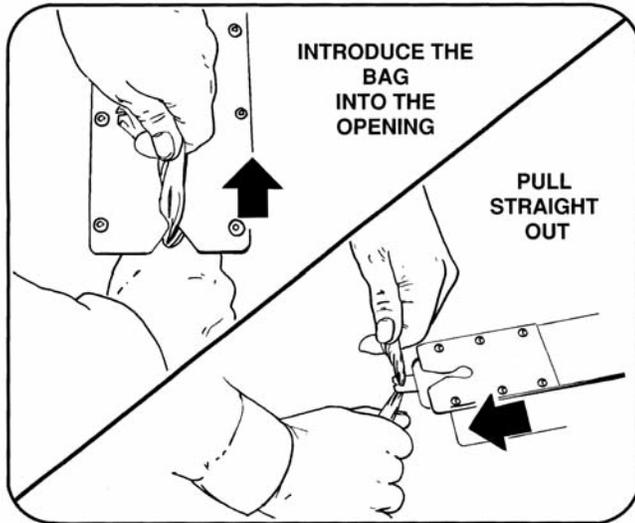


Figure 2.4

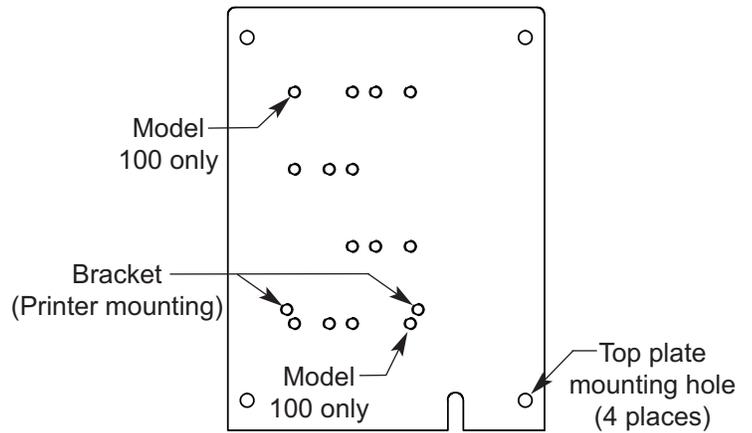


Figure 2.5

F. SETUP: Figure 2.5 - 2.7

Refer to the Specifications section for additional details on model setup.

The Model 100 is set up to run Series RJ closures.

The standard configuration for Models 200 and 200P is to utilize closures with optional conversion kits. They are also capable of using L closure - labels, U closure - labels, or CR closure - labels. The conversions are simple to execute and can easily be done by the user. The closer can be converted back to the standard configuration.

The only tool needed for the conversion is a 3mm hex wrench, which is included with the closer. A tool holder on the back of the closer frame next to the power cord connection provides a convenient place to keep the wrench. The closer comes with two removable shims. One or two of the shims may need to be removed for a specific configuration. There are two studs located inside the closer stand to hang the shims when not in use.

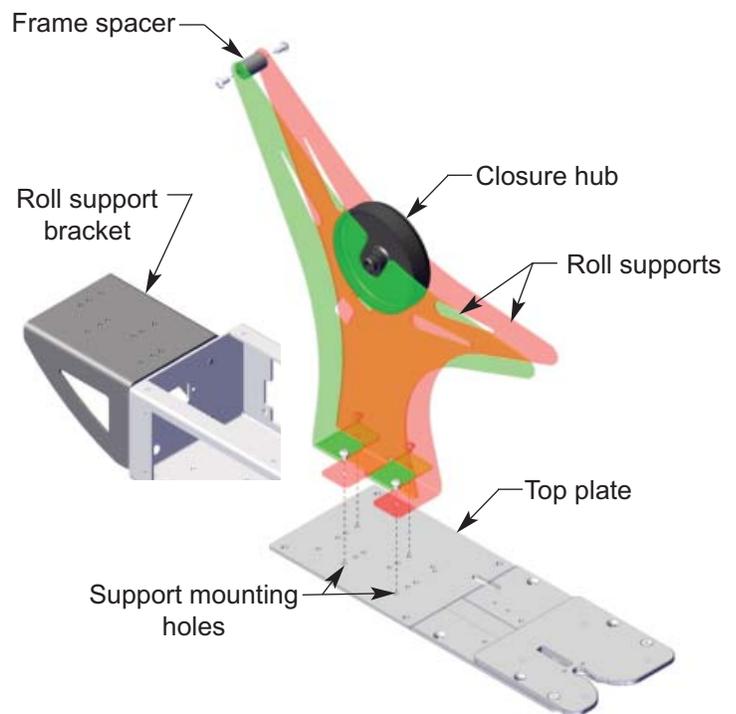


Figure 2.6

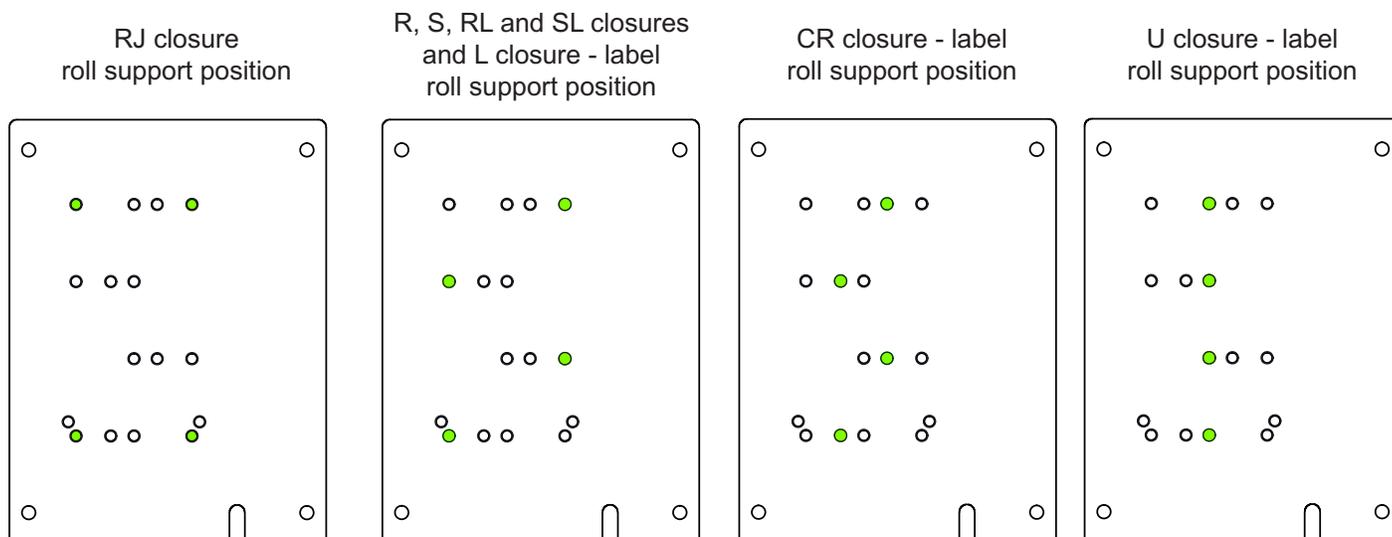


Figure 2.7

GREEN indicates mounting position of roll supports.

The hole patterns shown apply to 086B (without printer) and 086BP (printer) closers. The roll support bracket (for the optional printer Figure 2.6) has the same pattern of holes to correctly position the roll supports.

G. CONVERSION PROCEDURE: Figure 2.5 - 2.8

Remove the closure or closure - label strip and hub from the closer. The closer can be easily cleared of closures or closure - labels by pressing the Lok pick and stop down. The closer can be more easily cleared of the closure strip by breaking the strip and then running the closer until the closure track is empty.

DISCONNECT THE CLOSER FROM POWER.

The roll supports can be positioned in three different locations (Widths) to accommodate the three hubs available. Threaded holes are located in the closer top plate (Closer with no printer) or on the roll support bracket (Closer with printer). The support mounting holes to be used depends on which Closure / Closure - label is to be used.

CLOSURE TO SERIES L CLOSURE - LABEL CONVERSION:

1. The roll supports are not relocated.
2. From the front of the closer, identify and remove the right M5 button head screw securing the right lok guide shim to the track (Figure 2.8 Shim Position Series L Closure - Label). There are two threaded holes in the closer stand to keep unused M5 screws.
3. Remove the right shim and hang it on the studs located inside of the closer stand.
4. Insert the L label hub into a roll of L closure - labels and place them in the closer.
5. Insert the closure - label strip, label side up, into the closure track. Feed the strip into the track until the strip engages the closure stop.

SECTION II

Operation

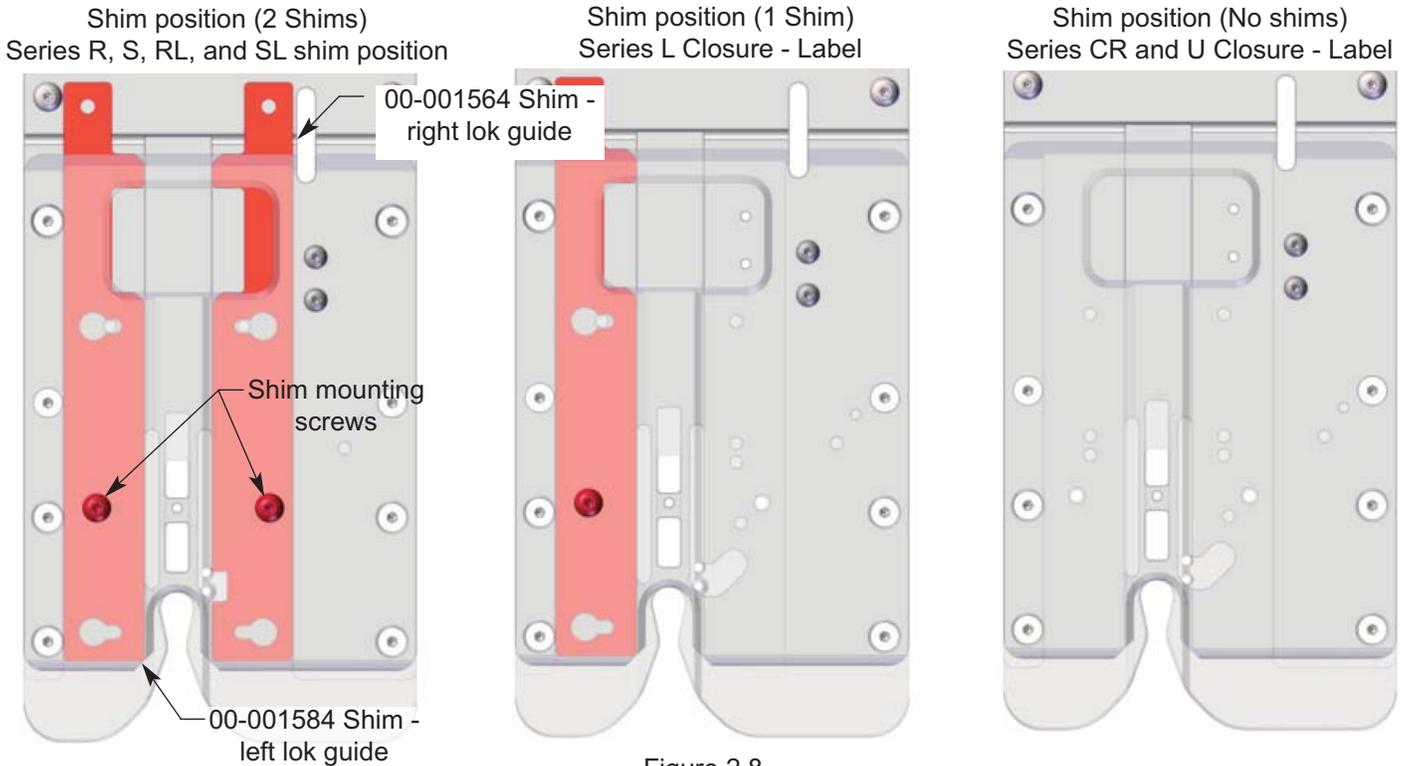


Figure 2.8

Lok track shim position

CLOSURE TO SERIES CR CLOSURE - LABEL CONVERSION:

1. Remove the two M5 screws securing the two lok guide shims. There are two threaded holes in the closer stand to keep unused M5 screws.
2. Remove both shims (Figure 2.8 Shim Position Series CR and U Closure - Label) and hang them on the studs located inside of the closer stand.
3. Remove the two frame spacer mounting screws and remove the spacer from between the two roll supports.
4. Remove the four screws securing the two roll supports to the closer.
5. Fasten the CR closure - label spacer between the two roll supports with the two M5 screws that were used for the previous spacer.
6. Align the mounting holes of the roll supports to the appropriate threaded holes on the closer (Figure 2.7).
7. Fasten the two roll supports to the closer using the four M5 screws that were removed earlier.
8. Insert the CR closure - label hub into a roll of CR series closure - labels and place them in label side up.
9. Insert the end of the closure - label strip, label side up, into the closure track. Feed the strip into the track until the strip engages the closure stop.

SECTION II Operation

CLOSURE TO SERIES U CLOSURE - LABELS CONVERSION:

1. Remove the two M5 screws securing the two shims (Figure 2.8 Shim position Series CR and U Closure - Label). There are two threaded holes in the closer stand to keep unused M5 screws.
2. Remove both shims and hang them on the studs located inside of the closer stand.
3. Remove the two frame spacer mounting screws and remove the spacer from between the two roll supports.
4. Remove the four screws securing the two roll supports to the closer.
5. Fasten the U closure - label spacer between the two roll supports with the two M5 screws that were used for the previous spacer.
6. Align the mounting holes of the roll supports to the appropriate threaded holes on the closer (Figure 2.7).
7. Fasten the two roll supports to the closer using the four M5 screws that were removed earlier.
8. Insert the U closure - label hub into a roll of U series closure - labels and place them in the closer.
9. Insert the end of the closure - label strip, label side up, into the closure track. Feed the strip into the track until the strip engages the closure stop.

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SECTION III Adjustments

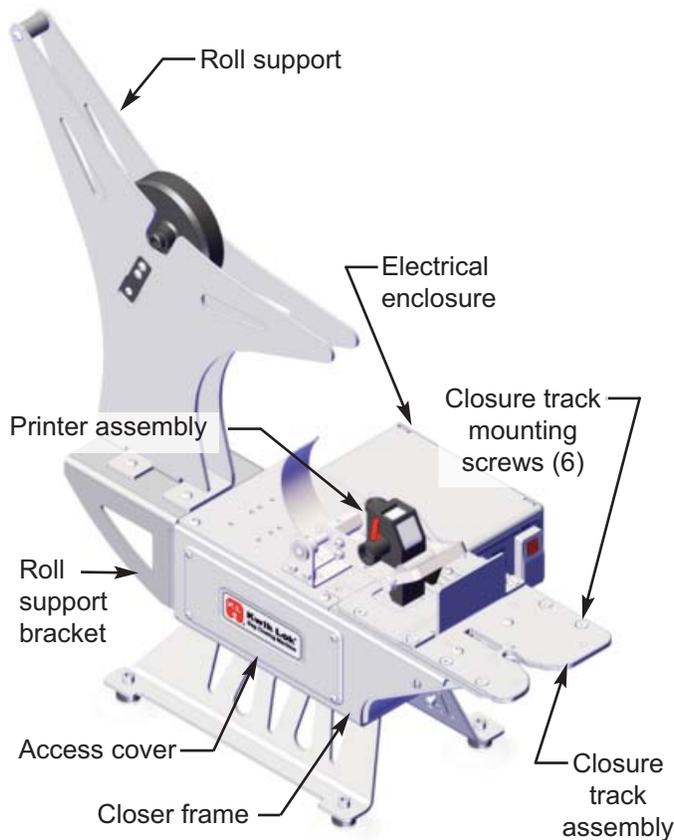


Figure 3.1

THE FOLLOWING ADJUSTMENTS ARE TO BE PERFORMED WITH THE CLOSER ELECTRICAL POWER DISCONNECTED.

A. CLOSURE TRACK ASSEMBLY REMOVAL: Figures 3.1 - 3.3

Some of the adjustments described in this section require removal of the closure track assembly.

1. Remove the access cover.
2. Disconnect the two gold colored closure stop springs from the spring anchor screw. When the springs are reattached be careful not to stretch them.
3. Disconnect the ink roll arm spring (Printer Model only).

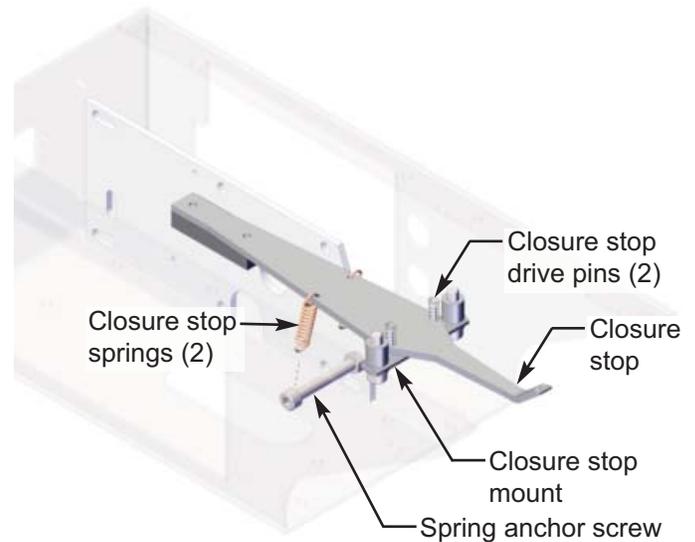


Figure 3.2

4. Remove the flat head mounting screws which attach the closure track assembly to the closer main frame. Note the closure track assembly can be removed from the closer without removing the ink roll assembly or the printer cover from the closure track (Printer Model only).

When remounting the track assembly, tighten the mounting screws evenly.

5. Lift the closure track assembly slightly and depress the tip of the pick to disengage it from the closure track.
6. Lift the closure track assembly slightly off the frame and disconnect the two wire leads from the sensor lever limit switch.

To remount the closure track assembly, reverse the above procedure. Before closing the access cover, check to see that there are no pinched wires or wires routed close to moving parts.

SECTION III Adjustments

B. TOP CLOSURE TRACK REMOVAL:

Figure 3.1

The top of the closure track can be removed from the closer while the closure track assembly remains attached to the closer mainframe. This can be done to expose the slot that the closures move through. The closure track can be inspected and cleaned if needed.

1. Disconnect the 0S-006 spring from the ink roll arm of the printer assembly (Printer Model only).
2. Remove the flat head screws from the track. Note the different screw lengths upon removal.
3. Remove the top track from the remaining lok track assembly.

C. REMOVE THE FRONT SHIELD:

Some of the adjustments described in this section require removal of the front shield.

DISCONNECT POWER

1. Remove the side access cover from the closer frame.
2. Remove the two self tapping phillips screws used to fasten the sides of the shield to the closer frame
3. Loosen (turn clockwise) the two shield mounting screws on the underside of the closer frame.
4. Press lightly from the inside of the closer frame on the backside of the shield to remove it.

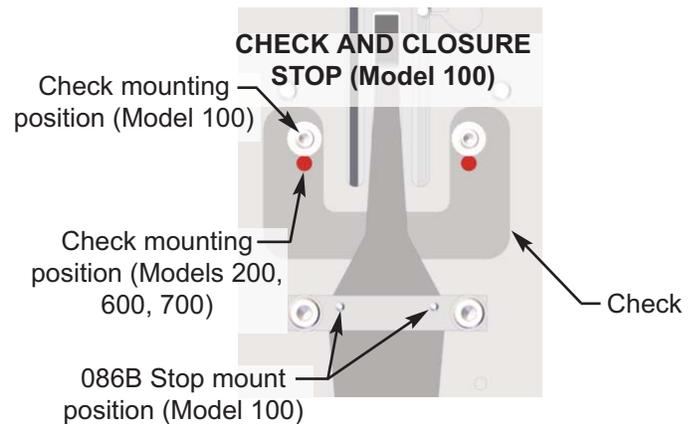
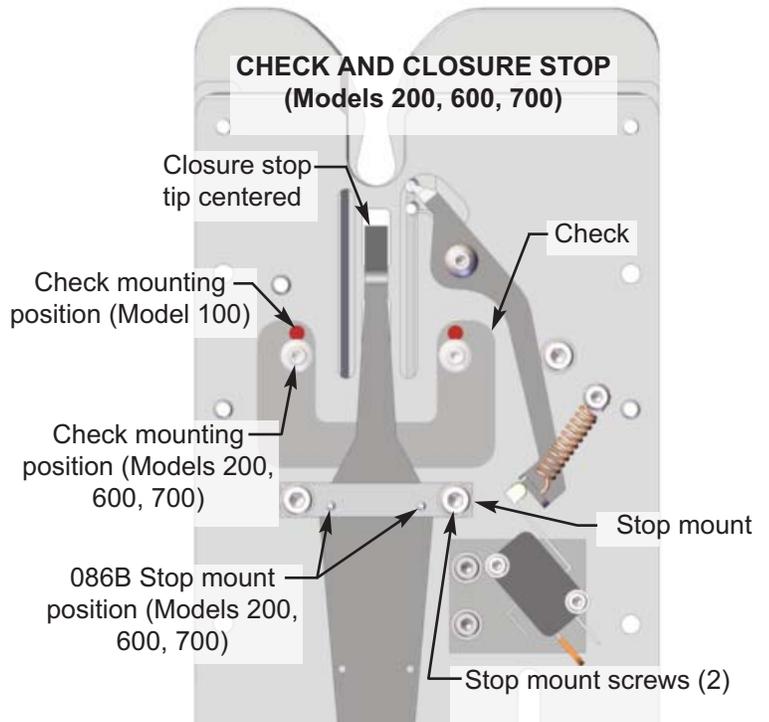


Figure 3.3

SECTION III Adjustments

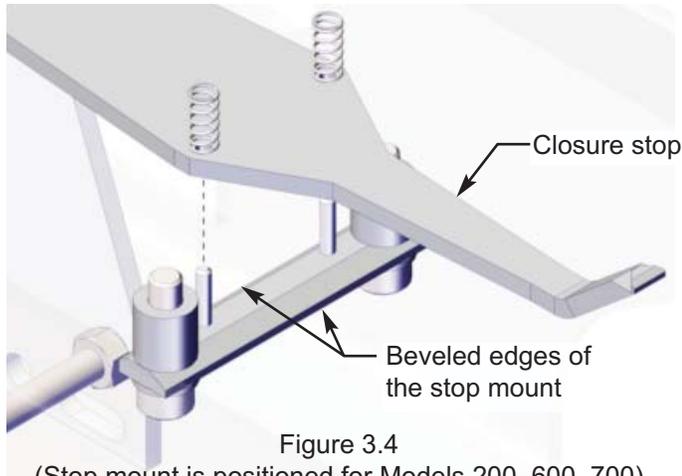


Figure 3.4

(Stop mount is positioned for Models 200, 600, 700)

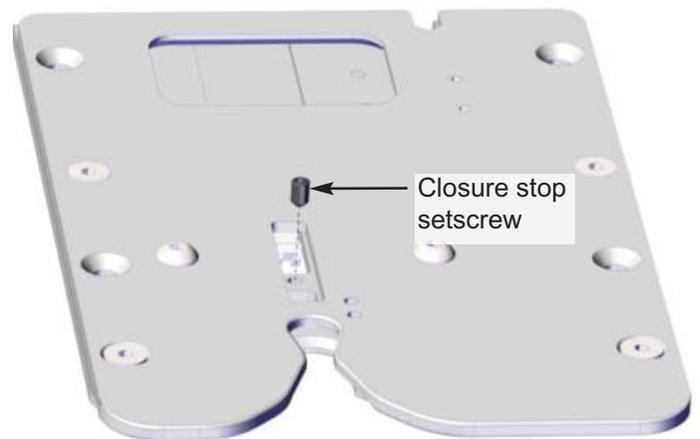


Figure 3.5

D. CHECK POSITION: Figure 3.3

The check stops the closure strip from moving backward while the pick retracts.

Refer to Figure 3.3 to further understand the check mounting position. For this adjustment the closure track must be removed from the closer.

For models 200, 600, and 700 the check is mounted in the back mounting holes (farthest from the front of the closure track). For Model 100, the check is mounted in the front mounting holes.

1. With the check mounted in the correct holes, and the mounting screws loose, slide the check forward toward the front of the closure track to the end of the mounting slots and tighten the mounting screws.

E. CLOSURE STOP POSITION: Figure 3.3 and 3.4

The end closure is separated from the closure strip while the closure stop limits the travel of the second closure in the strip as the pick continues to advance the first closure. As with the position of the check, the stop mount is located in a specific way depending on the closer model being adjusted.

1. The stop mount is mounted as shown.
2. Be sure the beveled edges of the mount are facing the closure stop.

The closure stop tip must be centered in the slot located in the bottom track for it.

3. Slightly loosen the stop mount mounting screws.
4. Move the closure stop tip side to side until it is centered in the slot.
5. Tighten the mounting screws.
6. Turn the closure track assembly over so it is right side up. Again check the position of the closure stop tip as this is the way the track assembly is oriented during operation. Readjust if needed.

SECTION III Adjustments

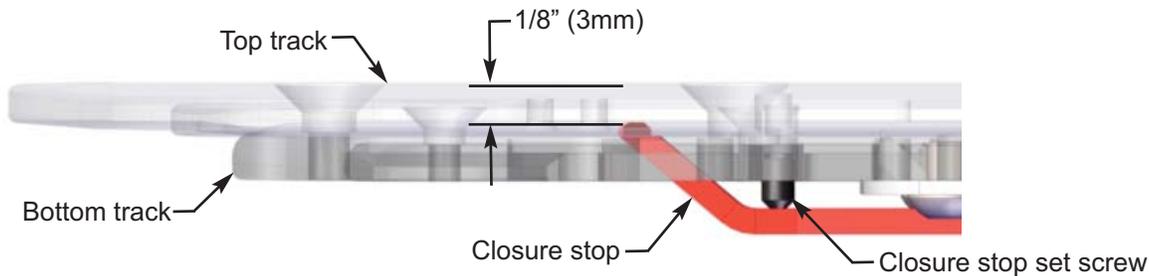


Figure 3.6

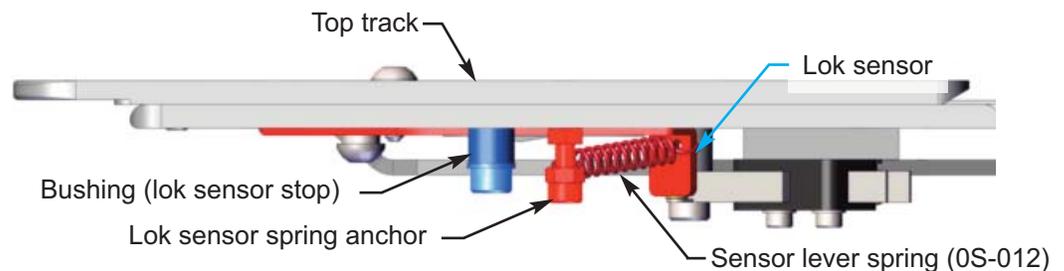


Figure 3.7

F. CLOSURE STOP SET SCREW ADJUSTMENT: Figure 3.5 and 3.6

When properly adjusted, the closure stop set screw sets the height of the closure stop. As the closure strip advances, the second closure in the strip is stopped. The leading closure continues to move forward and is then separated from the closure strip.

1. Remove any closures from the track assembly.
2. Locate the top of the set screw.
3. Turn the sets crew in or out to lower or raise the tip of the closure stop until it is 1/8" (3mm) below the top of the top track. If the tip of the stop will not raise as the set screw is turned out, the stop may be bowed. If so, the stop must be removed from the machine and the part straightened. It is recommended that remove-able threadlocker be used on the set screw.

G. LOK SENSOR SPRING: Figure 3.7

The lok sensor spring is designed to apply force to the lok sensor tip keeping it against the side of the closure, as well as upward against the underside of the closure track. For the spring to operate correctly, it must be mounted as shown in Figure 3.7.

H. SENSOR LEVER STOP ADJUSTMENT: Figure 3.7 - 3.9

The lok sensor stop is a bushing which limits the travel of the sensor lever when no closures are present. The bushing is secured under an M5 socket head screw. The bushing (sensor lever stop) can be adjusted to set the lok sensor stop position. When no closures are present, the lok sensor tip should be centered below the inspection hole in the top track (Figure 3.8).

1. Loosen the mounting screw and move the bushing as needed.
2. Retighten the mounting screw.

SECTION III Adjustments

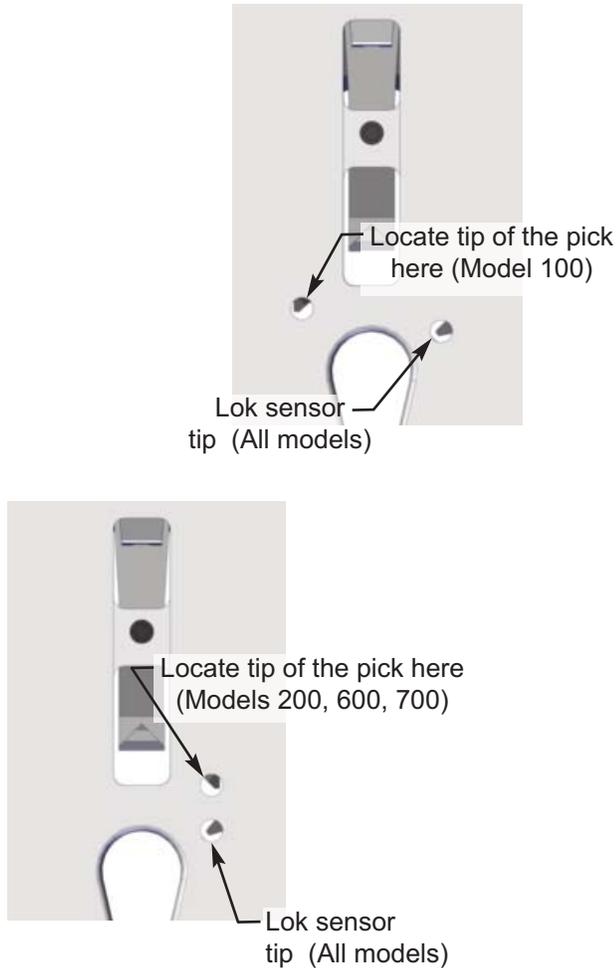


Figure 3.8

I. LOK SENSOR SWITCH ADJUSTMENT: Figure 3.9

The sensor switch detects whether or not there is a closure in closing position. When a closure moves into the closing position, the sensor switch stops the motor at the end of the cycle. When the closure is removed, the switch starts the motor.

1. Check to see if the sensor lever stop is adjusted correctly, refer to Part H, this section.
2. Turn the closure track upside down.

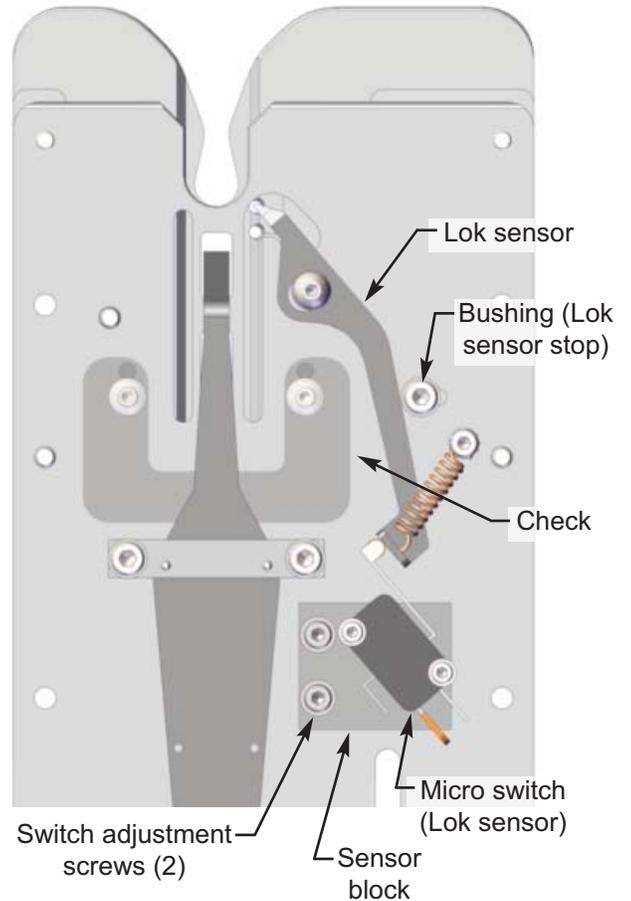


Figure 3.9

3. Feed a short strip of closures (4 or 5) through the track until the leading edge of the first closure just slides past the lok sensor then back out until the closure is free of the lok sensor. Continue to slide the strip back and forth while listening for an audible "click" indicating that the lok sensor switch is turning on and off. If the strip of closures moves forward so far that it can't back up, push it out of the front of the track and start over. Adjust if needed as follows.
4. Slightly loosen the two mounting screws in the sensor block (Figure 3.9).

SECTION III Adjustments

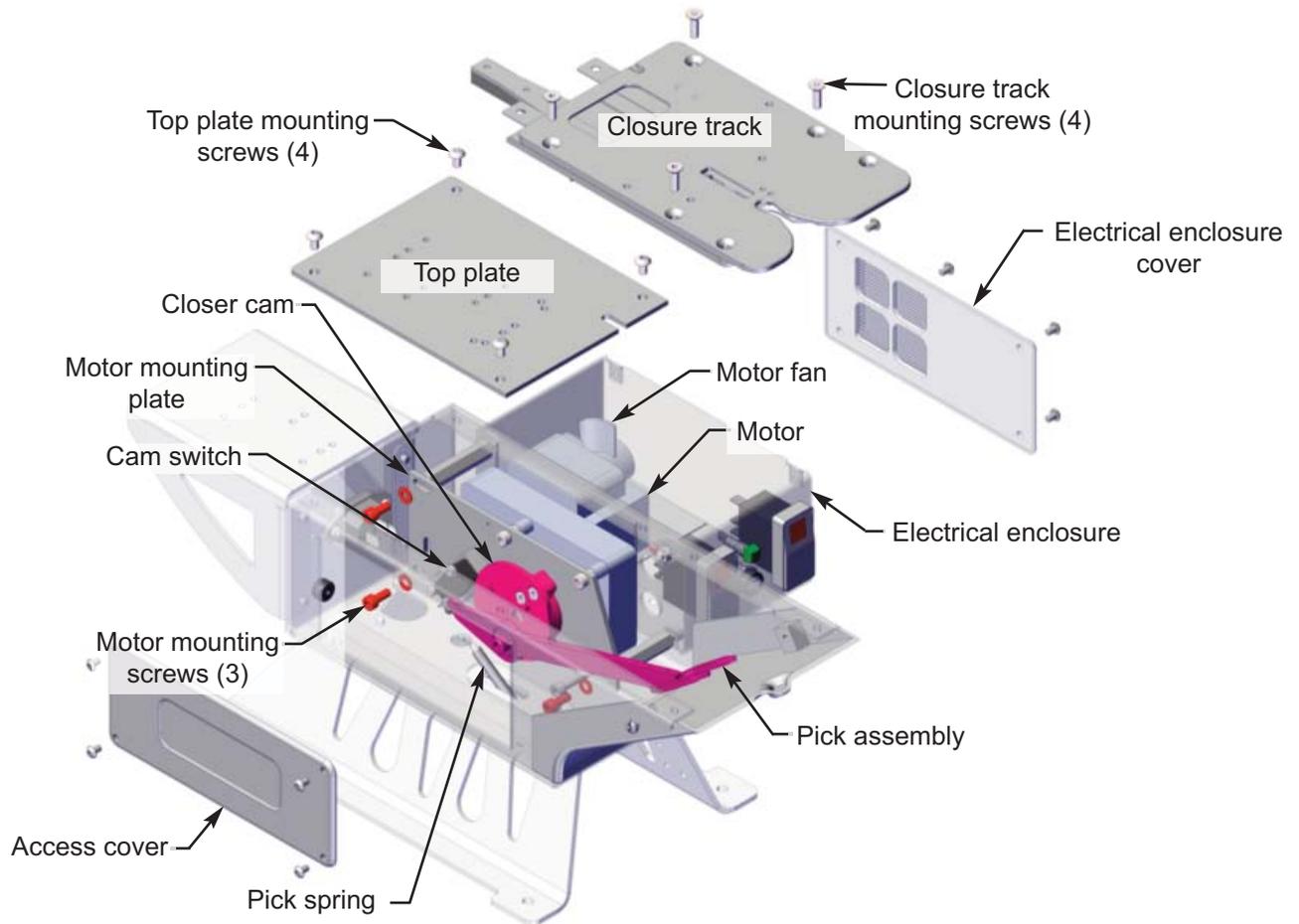


Figure 3.10

5. Move the switch and sensor block toward or away from the lok sensor. Listen for an audible "click" of the switch as it turns on and off.

6. Tighten the mounting screws when the switch actuates as described above.

SECTION III Adjustments

J. MOTOR REMOVAL: Figure 3.10

If the three motor mounting plate screws are disturbed, the pick position must be checked. Refer to Part K, this section.

The motor, motor mounting plate, cam assembly, cam switch block, printer cam arm and limit switch can be removed and reinstalled as an assembly. Component adjustment to this assembly can be made while the assembly is out of the frame of the closer. Remove the motor assembly as follows:

1. Disconnect power to the closer.
2. If the optional printer is being used, then disconnect the OS-006 spring from the ink roll arm and proceed.
3. Remove the pivot mount from the printer link.
4. Remove the four mounting screws that fasten the top plate to the closer main frame. Lift the top plate and printer mechanism from the mainframe.
5. Remove the access cover.
6. Disconnect the pick spring from the pick.
7. Remove the electrical enclosure cover.
8. Carefully remove the fan from the motor shaft. Note the clamp on the inside of the fan. When the fan is reinstalled be sure to press the fan onto the motor shaft clamp side first. The end of the motor shaft should extend 1/16" to 1/8" (1.6mm-3.2mm) beyond the hub of the fan.
9. Disconnect the motor wires.
10. Disconnect the cam switch electrical leads.
11. Remove the three motor mounting screws from the slotted holes in the motor mounting plate. Refer to Part K, this section for readjustment of the pick.

12. Remove the motor assembly through the top of the closer frame.

13. To reinstall the motor assembly, reverse these steps.

K. PICK / CLOSURE LOCATION: Figure 3.8

The pick advances the closure strip and locates the leading closure in the bag closing position. Verify whether the pick stops in the correct position, check and adjust as follows:

1. Remove any closures from the closure track.
2. Verify that the pick is at the end of its travel. To do this, plug in the closer. Turn the rocker switch to "RUN" and then to "STOP". The motor will stop with the cam and pick in their proper "parked" positions.
3. With the motor stopped, disconnect the power cord.
4. The tip of the pick should be visible in half of the inspection hole as shown (Figure 3.8). Reposition the pick if needed as follows:

BE SURE THE POWER IS DISCONNECTED.

5. Remove the side access cover.
6. Loosen the three motor mounting screws mounted in the slots at the corners of the motor mounting plate.
7. Slide the motor assembly until the pick is in the proper position when viewed through the inspection hole (Figure 3.8).
8. Tighten the motor mounting screws and again check the pick position. Reattach the access cover.

SECTION III

Adjustments

L. CAM ASSEMBLY: Figure 3.11 - 3.14

The cam assembly drives the pick through its cycle and raises the closure stop at the proper time to stop the closure strip so the leading closure can be separated from the remaining strip. The print cam operates the printer mechanism and is only installed on a closer with a printer. The stop cam and the print cam fasten to either side of the cam hub. Additionally, the switch cam contacts the cam switch which stops the motor and cam assembly when the pick is in the parked or neutral position. The cam assembly should remain on the motor shaft with no need for adjustment. If, however, the cam assembly is disassembled, the following information is helpful to reassemble it.

There are three ways the cam assembly can be assembled depending on the model and if a printer is to be used.

The printer version of the cam and hub assembly is shown in Figure 3.13. The standard position is identical to the printer version but without the print cam. The Model 100 operates with the Series RJ closure and is similar to the cam position described earlier but with the stop cam reversed (flipped over on the cam hub Figure 3.12).

The hub is designed with a shoulder on either side at the center. One shoulder is larger than the other. If no printer is being used, proceed to step 4.

1. Turn the hub so the small shoulder is face up. This is the print cam side. Set the print cam onto the hub with the countersunk hole in the printer cam facing up. Turn the cam on the hub until one countersunk hole in the print cam aligns with the M4 Threaded hole of the cam hub.
2. Fasten the print cam to the hub with one M4X12 flathead and one M6X12 button head screw.
3. Turn the hub over so the print cam is down.

 Blue indicates removable threadlocker

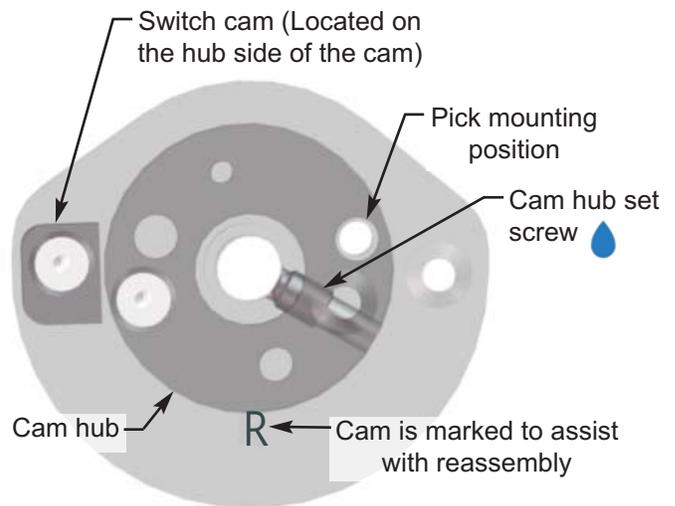


Figure 3.11
Models 200, 600, 700, 200P, 600P, 700P

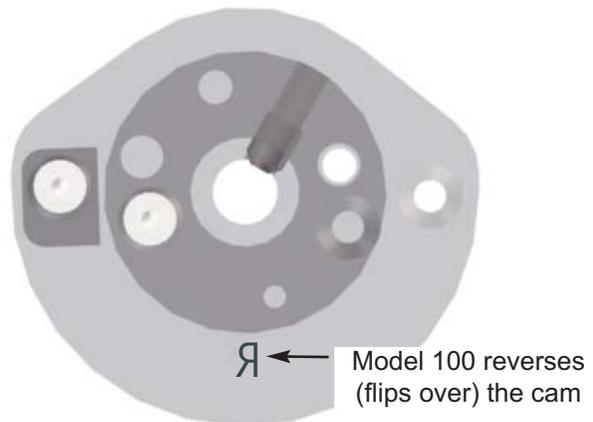


Figure 3.12
Model 100

SECTION III Adjustments

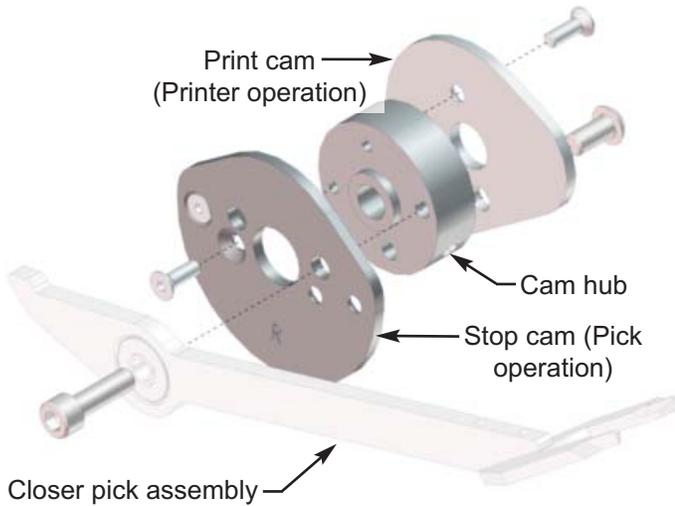


Figure 3.13

Notice that the stop cam has an “R” stamped on one side (Figure 3.11)

4. Place the stop cam onto the larger shoulder side of the hub. The “R” side of the cam should be facing out for the Models listed as shown in Figure 3.11. For Model 100 the cam is flipped over so the “R” is facing the cam hub as shown in Figure 3.12. Rotate the stop cam until its countersunk hole aligns with the M4 threaded hole in the cam hub.
5. Fasten the stop cam to the hub with one M4X12 flat head. The second hole is to mount the pick arm after the cam assembly is remounted and fixed to the motor shaft.
6. If the switch cam (Figure 3.15) has been removed, remount it after the cam and hub have been connected. Square up the switch cam to the cam hub and then tighten into place.
7. Refer to Part M, this section to adjust the lateral position of the cam assembly to the motor shaft.

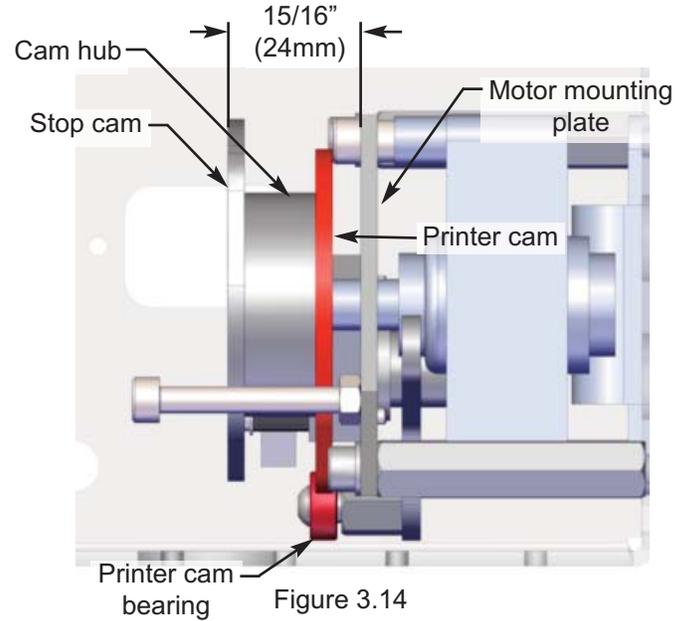


Figure 3.14

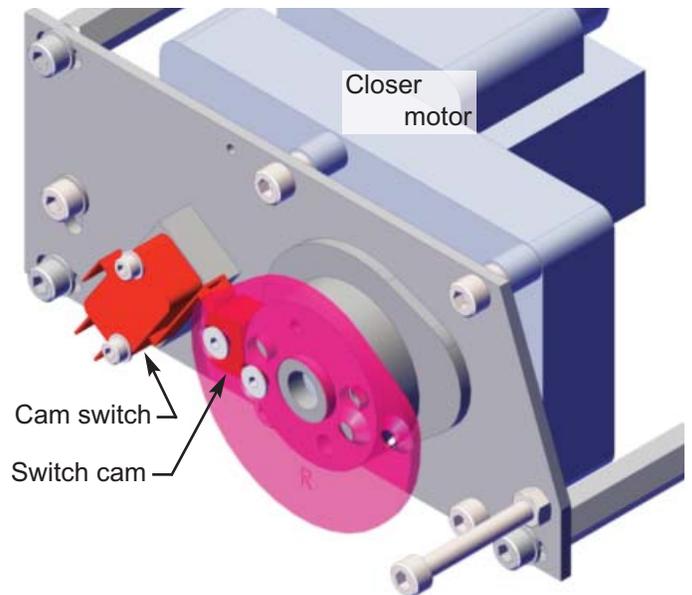


Figure 3.15

SECTION III Adjustments

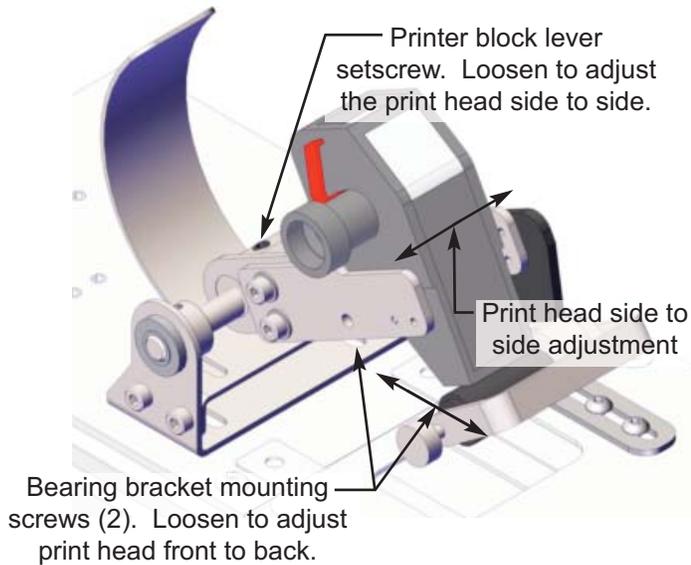


Figure 3.16

M. CAM ASSEMBLY LATERAL ALIGNMENT: Figure 3.14 and 3.15

1. Set the lateral (side to side) position of the cam assembly so the outside edge of the stop cam measures 15/16" (24mm) from the outside edge of the motor plate.
2. Rotate the cam assembly to position the set screw over the flat on the motor shaft and tighten the set screw. The angular position of the cam assembly is not important because the motor will stop with the cam in the correct position when the switch cam contacts the limit switch. Threadlocking compound should be used to lock the set screw in place.
3. Tighten the set screw.

N. CAM SWITCH MOUNTING: Figure 3.15

The cam switch allows the cam assembly to rotate and only stop when a closure reaches the bag closing position. The switch cam actuates the switch. If the toggle switch is in the "RUN" position, the "READY" light will be on while the cam switch is actuated. The cam switch should not need adjustment.

CAUTION MOTOR ROTATION.

Inadvertently rotating the motor shaft manually can damage the cam switch (Figure 3.25). If the motor is to be manually rotated **ONLY ROTATE THE MOTOR CLOCKWISE FROM THE FAN END OF THE MOTOR** (Figure 3.25). If the motor shaft is turned in the opposite direction (counterclockwise from the fan end of the motor) the cam switch will likely be damaged.

THE REMAINING ADJUSTMENTS IN THIS SECTION ARE FOR THE 086B PRINTER OPTION.

O. PRINthead LOCATION - SIDE TO SIDE: Figure 3.16

The printhead should be centered between the sides of the closure strip. If it is not, it will not align properly with the ink roll. The printhead can be manually pressed against the closure to determine where the image will be on the closure. The band printhead must be rotated back against the spacer at all times. To center the printhead, loosen the set screw in the printer block lever and slide the printhead assembly along the printer shaft. When the set screw is tightened, it should bear against a flat on the printer shaft. The two set screws in the set collars and the set screw in the printer lever should be in line.

SECTION III Adjustments

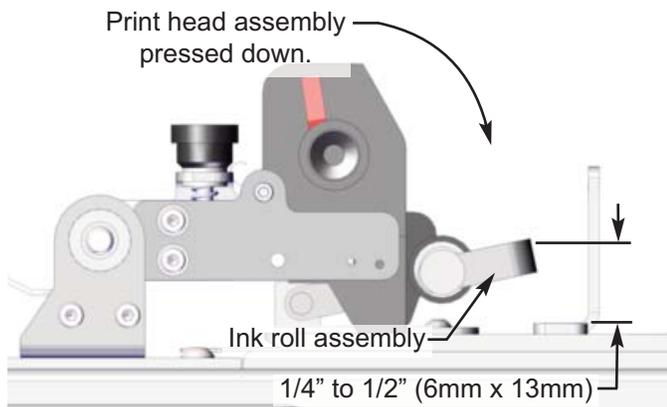


Figure 3.17

P. PRINTHEAD LOCATION - FRONT TO BACK: Figure 3.16

The printhead assembly can be moved backward or forward to locate the printed image on the closure. Before adjusting be sure the top of the bandhead is rotated back against the spacer (Refer to Figure 3.18)

1. Loosen the two button head screws that secure the bearing bracket to the top plate. Slide the assembly as needed. Use a square along the back edge of the bearing bracket and the side of the top plate. Whenever the printhead is moved, the ink roll arm mount will need to be repositioned. If the printhead assembly is moved forward (toward the bag closing location), the ink roll arm mount may have to be moved out of the way first. Do not run the machine under power until the ink roll arm is repositioned properly. Refer to Part Q, this section.

Q. INK ROLL ARM POSITION: Figure 3.17 - 3.20

The ink roll arm must be positioned so the mechanism does not bind and the type face is completely inked. Manually depress and release the ink roll arm to determine if it operates freely. Use only the 0S-006 spring. If needed, clean and oil the shaft of the ink roll arm.

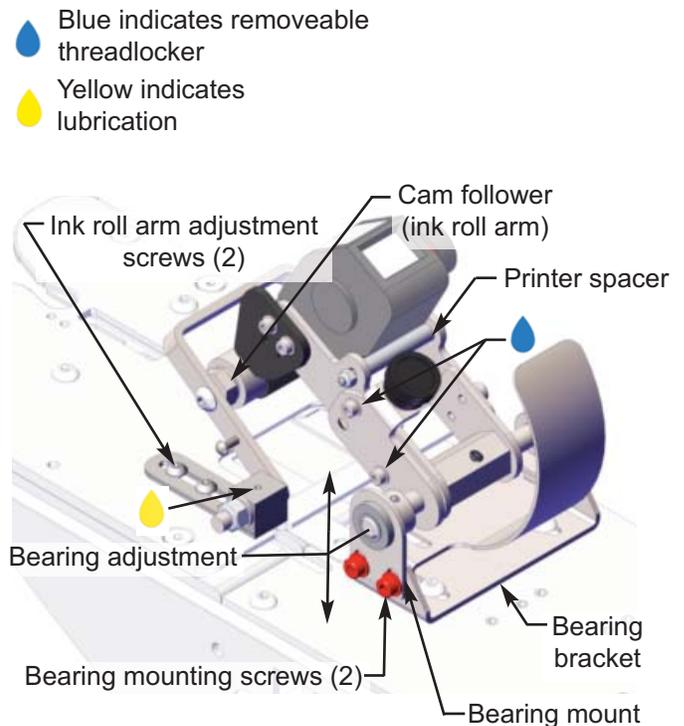


Figure 3.18

When the printhead is manually depressed, the ink roll arm should clear the flange of the cover mount bracket by 1/4" to 1/2" (6mm to 13mm).

1. To adjust, loosen the two screws, which secure the ink roll arm mount to the top track (Figure 3.18).
2. Slide the mount as needed. Force the side of the slot against the two screws to square it. Verify that the ink roll is centered side to side with the closure strip.
3. After tightening the screws, check the adjustment by manually depressing the printhead before applying power to the machine.

SECTION III Adjustments

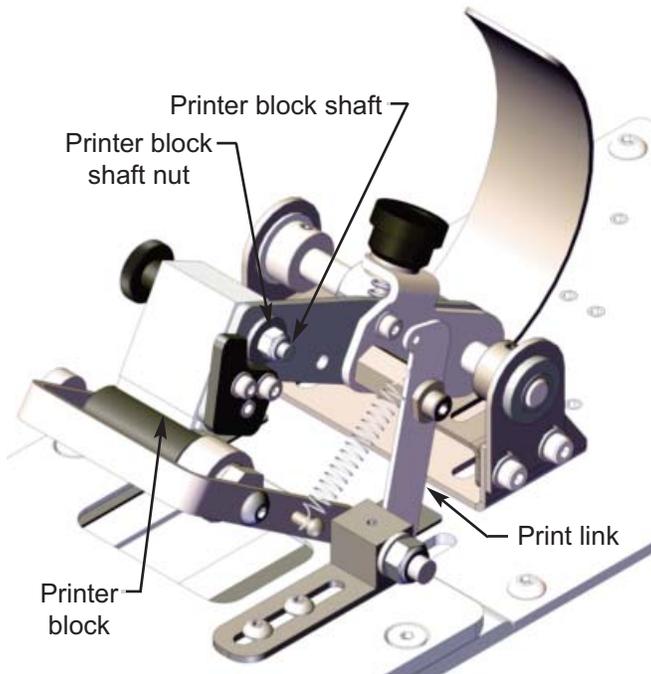


Figure 3.19

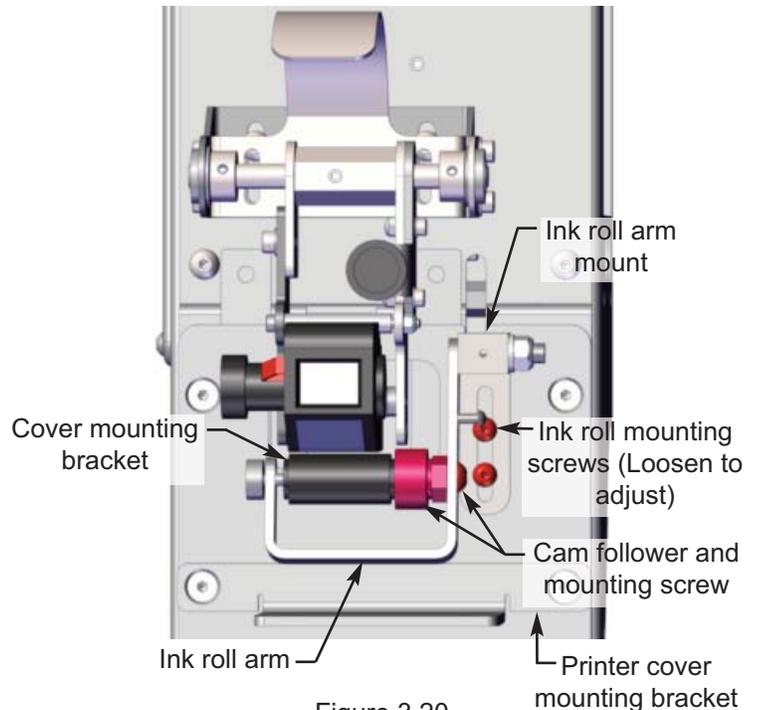


Figure 3.20

R. INKING FORCE- SIDE TO SIDE: Figure 3.18 - 3.20

As the ink roll moves across the typeface, the OS-006 spring on the ink roll arm determines the inking force. The surface of the ink roll must align parallel to the typeface so all the type is properly inked. To verify this adjustment, it is necessary to jog the machine until the ink roll is in contact with the typeface. (Refer to Part V, this section)

1. With the ink roll in contact with the typeface, depress the ink roll arm slightly to see if the ink roll contacts the typeface uniformly.

2. If the ink roll is tipped, align it by slightly loosening the screw that attaches the cam follower to the ink roll arm (Figure 3.20).

The screw hole in the cam follower is offset from center, so as the cam follower is rotated slightly, the end of the ink roll will move up or down.

3. Position the cam follower so the ink roll is parallel to the typeface and retighten the screw.

SECTION III Adjustments

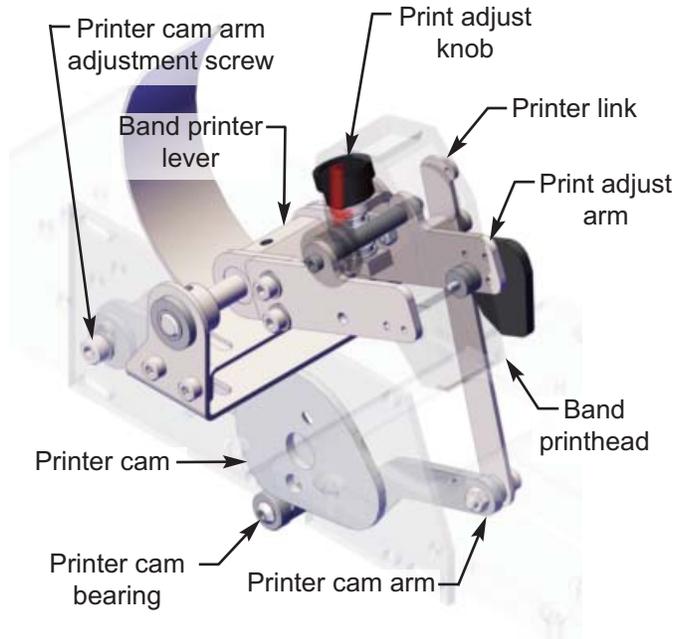


Figure 3.21

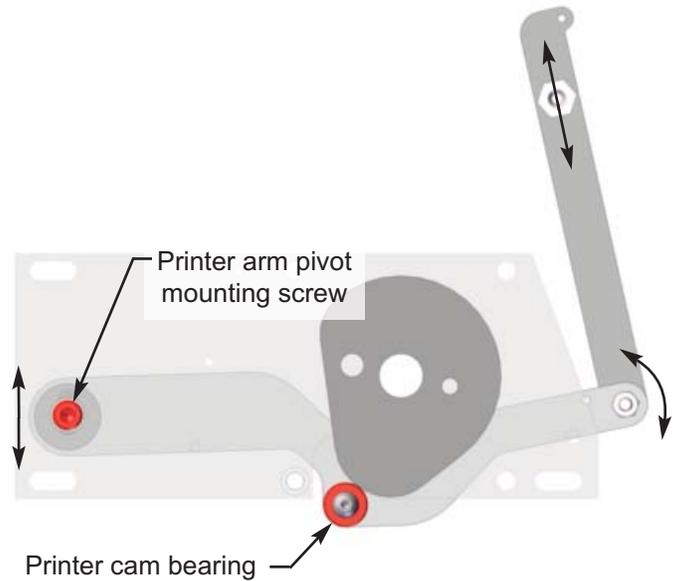


Figure 3.22

S. PRINT FORCE- SIDE TO SIDE: Figure 3.18

The print head must be aligned so the typeface contacts the closure uniformly from side to side. Verify that the type is properly inked. (Refer to Part Q, and Part R this section).

1. Adjust the print force to a very light setting to accentuate the variation in the print quality. This indicates how flat the typeface is to the print surface. Verify that the type is being properly inked. If the line of printing is not uniform, the bearing mount can be moved vertically to raise or lower that end of the printer shaft as shown in Figure 3.18.
2. Slightly loosen the two socket head screws that hold the bearing mount.

3. Move the bearing mount only about 1/32" (1mm) and then reevaluate the print force.
4. Verify that the side-to-side location of the printhead has not changed and that the inking force is still uniform across the typeface.

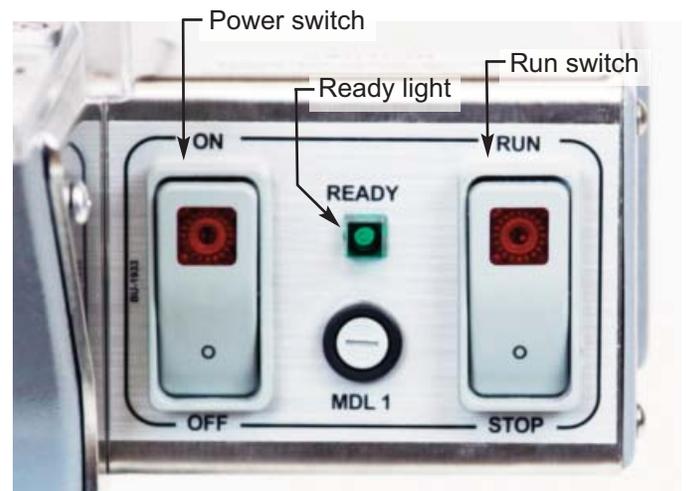


Figure 3.23

SECTION III

Adjustments

T. PRINT FORCE- TOP TO BOTTOM:

If the force is not uniform from the top to the bottom of the typeface, the printed image will not be uniform. Verify that the typeface is being inked properly before proceeding.

For the band printer, check that the top of the band-head has been rotated against the spacer (Figure 3.18). If needed, the spacer can be moved slightly on its mounting screw.

The block printer can be tipped by loosening the nut on the printer block mount shaft (Figure 3.19). When the shaft is positioned properly, retighten the nut. Check to see that the printer block can be removed and replaced easily.

U. PRINT FORCE RANGE: Figure 3.21 and 3.22

THIS PROCEDURE SHOULD ONLY BE PERFORMED BY SOMEONE WHO IS QUALIFIED TO WORK IN THE PRESENCE OF CHARGED ELECTRICAL CONTACTS AND UNGUARDED MACHINERY.

The print adjust knob has a limited range of adjustment. It can be rotated clockwise (decreasing printing force) until it will not turn any further when a moderate torque is applied. It can be rotated counterclockwise (increasing printing force) until the turning resistance abruptly decreases, at which time turning the knob further will have no effect on the print force. The full range is about 2 1/2 turns.

If the range is more limited, the printer adjust arm is not moving freely against the lever. The two screws on the printer adjustment arm need to be adjusted to allow free movement with minimum space between the lever and printer adjust arm. The screws are secured with thread locking compound, so they will not work loose.

Normally, good print quality should be attainable near the mid-point of the adjustment. If not, first verify that the type is being properly inked and that the side-to-side print force is uniform.

DO NOT USE EXCESSIVE PRINT FORCE TO COMPENSATE FOR OTHER DEFECTS.

To adjust the range of the print force:

1. Disconnect the power.
2. Remove the access cover from the side of the closer.
3. Identify the printer cam bearing (Figure 3.22) which is behind the stop cam. While looking below the stop cam, manually press and release the printhead. The cam bearing will move as the printhead moves.
4. Jog the mechanism until the printer cam bearing (Figure 3.22) is contacting the highest point on the lobe of the printer cam (Refer to Part V, this section).
5. Turn the print adjust knob clockwise until it stops.
6. Turn the knob counterclockwise 1 1/4 turns.
7. Verify there is a closure in the print position.
8. Identify the printer arm pivot mounting screw (Figure 3.22) on the motor mounting plate attaching the pivot to the motor mounting plate. (The pivot is behind the motor mounting plate). Loosen the screw. As the screw (and pivot) is moved up and down, the printhead will move in the opposite direction.
9. Move the screw as high as it can go when moderate force is applied and tighten it. Check that the printhead is resting firmly on the closure by pressing downward on the printhead.
10. Replace the access cover.
11. Verify the proper print force is attainable within the range of the adjustment knob by operating the machine. Readjust as needed.

SECTION III Adjustments

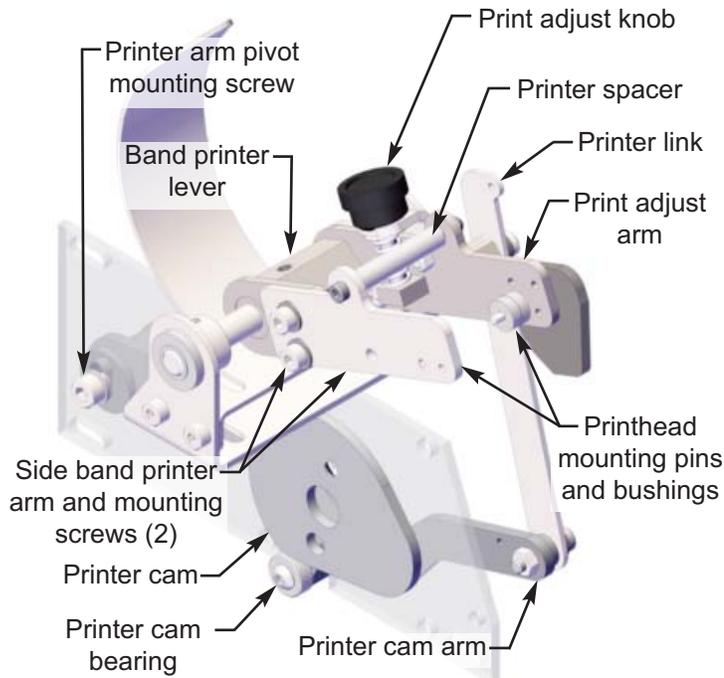


Figure 3.24

V. JOGGING THE CLOSER AND PRINTER MECHANISM: (Figures 3.22 and 3.23)

For the following adjustments -

Part O. PRINT HEAD LOCATION SIDE TO SIDE

Part P. PRINT HEAD LOCATION - FRONT TO BACK

Part Q. INK ROLL ARM POSITION

Part R. INKING FORCE - SIDE TO SIDE

Part U. PRINT FORCE RANGE

- the printer mechanism must be in a position different from the normal parked position. Since the motor has an automatic brake, it can be rotated only by applying electrical power.

Use the following procedure to jog the printer mechanism to the position shown in Figure 3.22:

1. Remove the side access cover from the closer.
2. Plug the closer in and slide a strip of closures into the closure track.
3. Set the power switch to "ON".
4. Set the run switch to "RUN". The closer will cycle one time and bring a closure into closing position and the "READY" light will be on.
5. Turn the power switch to "OFF" and leave the run switch set to "RUN".
6. Remove the closure from the closing position.
7. **Quickly** toggle the power switch from "ON" to "OFF" to jog the closer through the closing cycle.

Continue to jog the closer until the printer cam is in the position shown in Figure 3.22.

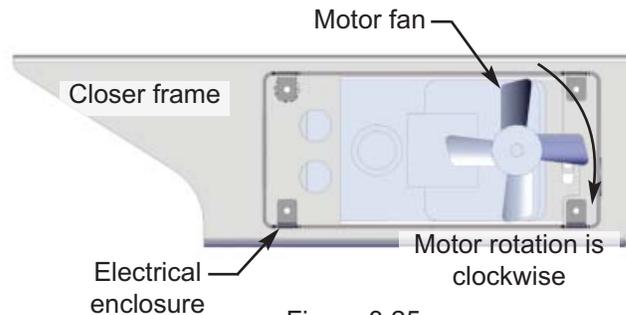
If the mechanism moves past the desired position, continue on around and start again. If another closure moves into the closing position, remove it.

8. When finished with the adjustment, move the RUN/STOP switch to the "STOP" position and turn the ON/OFF switch to "ON". The closer will stop in the parked position and again be ready to close.

CAUTION MOTOR ROTATION.

Inadvertently rotating the motor shaft manually can damage the cam switch (Figure 3.25). If the motor is to be manually rotated **ONLY ROTATE THE MOTOR CLOCKWISE FROM THE FAN END OF THE MOTOR** (Figure 3.25). If the motor shaft is turned in the opposite direction (counterclockwise from the fan end of the motor) the cam switch will likely be damaged.

SECTION III Adjustments



W. BANDHEAD REPLACEMENT: Figure 3.24

To replace the bandhead:

1. Remove the printer spacer, nut and screw.
2. Note the position of the printhead mounting pins and bushings (Refer to the parts section "086BP BAND PRINTER ARM" for pins and bushing positions). There are two sets of mounting holes for the two pins. The forward pin mounting position is for the European printhead, the rear mounting location is for the non-European printhead. The bushings set against the printhead. For a non-European printhead there are two bushings on the right-hand side of the printhead and one on the left. For a European printhead there is one bushing on each side of the printhead. When the printer lever is removed be careful not to lose the bushings.
3. Remove the two screws that connect the side band printer arm to the band printer lever.
4. Slide the arm and bushing away from the printhead and remove the printhead.
5. To mount the printhead, place the bushings on the printhead mounting pins and reattach the side band printer arm to the printer lever. Pinch the printer arm and the band printer lever together with the printhead between them. Tighten the two button head mounting screws so the printer arm and printer lever are parallel.
6. Reconnect the spacer and printer linkage.
7. Refer back to parts O through U to adjust for print quality if needed.

SECTION IV Troubleshooting

MECHANICAL TROUBLE SHOOTING

PROBLEM	SYMPTOM	CORRECTION
1. The closer does not cycle to advance a closure into the closing position. The light and motor are off.	A. Electrical power is not available (no light on power switch).	Connect the electrical plug to an appropriate power source.
	B. The power switch is in the "STOP" position (the ready light is not on).	Press the switch to the "RUN" position.
	C. The fuse is burned out.	Check the fuse and replace as needed.
2. The closer does not cycle to advance a closure to the closing position. The light is off and the motor is humming. CAUTION: IMMEDIATELY DISCONNECT THE POWER TO AVOID DAMAGING THE MOTOR. After the problem is corrected, the machine will complete its cycle when the power switch is turned on.	A. Closures are jammed in the closure track.	Remove any jammed closures by hand. Do not gouge or pry on the closure track. The top of the closure track can be removed if needed. Refer to Section III Adjustments, Part B. TOP CLOSURE TRACK REMOVAL for instructions.
3. The closer does not cycle to advance a closure to the closing position. The power switch light is on and the run switch is set to "ON". The "READY" light should be off.	A. The motor brake is jammed.	Disconnect the power cord. Remove the electrical enclosure cover. Check to see that the brake spring is properly connected.

For technical support during regular business hours, call your local Kwik Lok distributor. For 24/7 technical support call Kwik Lok Corporation at 1 800-688-5945 if you are in the continental U.S. For those outside the U.S., please dial + 1-509-248-4770.

SECTION IV

Troubleshooting

PROBLEM	SYMPTOM	CORRECTION
4. The closer cycles and the "READY" light blinks repeatedly. There is no closure between the check and pick.	A. The closer is operating properly.	Move the switch to the "STOP" position. Refer to Section II Operation, Part B. LOADING A ROLL OF CLOSURES.
5. The closer cycles and the "READY" light blinks repeatedly. There is a closure between the check and pick that does not advance.	A. The wrong closures are being used.	The 086 is available in six models. Refer to Section I Specifications to determine the correct closure for your model closer.
	B. The check is not adjusted properly.	Refer to Section III, Adjustments, Part C. REMOVE THE FRONT SHIELD, and Part D. CHECK POSITION.
	C. The pick does not advance the closure.	Refer to Section III, Adjustments, Part C. REMOVE THE FRONT SHIELD, and Part D. CHECK POSITION. Look under the front of the closure track to see if the tips of the pick are located in the slots at the bottom of the closure track. If it is not, center the pick by hand. The pick is held up by the pick spring located at the back of the pick assembly. The pick should move down when a light force is applied to it. When released, the pick should move back up due to the spring tension. Some side play is normal when the pick is out of the closure track slots.
6. The closer continues to cycle while the switch is in the "STOP" position. The "READY" light does not blink.	A. The cam switch is not functioning properly.	The cam switch stops the motor in the proper position and turns on the "READY" light. See Section III, Adjustments, Part N. CAM SWITCH MOUNTING and SECTION VI, Wiring Diagram. The lever of the cam switch may be bent, the cam switch may be defective, or the switch cam may not be mounted properly. Correct as needed.
7. The closer cycles even though a closure is in the bag-closing position. One or more closures are pushed out the front of the closure track.	A. The sensor lever is not detecting the closure.	See Section III, Adjustments, Part G. SENSOR LEVER SPRING, Part H. SENSOR LEVER STOP ADJUSTMENT, and Part I. LOK SENSOR SWITCH ADJUSTMENT.

SECTION IV

Troubleshooting

PROBLEM	SYMPTOM	CORRECTION
8. The closure in the bag-closing position is hard to remove because it is not separated from the closure strip.	A. The pick is not advancing to the correct position because the mechanism is loose.	Refer to Section III, Adjustments, Part C. REMOVE THE FRONT SHIELD. With the power cord disconnected, reach under the front of the closure track and move the pick downward. Grasp the pick firmly and attempt to move it backward and forward. Sideplay is normal. The pick assembly should feel solid. If not, the screws which mount the pick to the pick arm or the screw that attaches the pick arm to the closer cam may be loose or the pick bearing may need replacement.
	B. The pick is not advancing to the correct position because the pick is out of adjustment.	See Section III, Adjustments, Part K. PICK / CLOSURE LOCATION.
	C. The height of the closure stop is not correct.	If the closure stop is not adjusted to the proper height, the closures may slip over it. Refer to Section III, Adjustments, Part F. CLOSURE STOP SETSCREW ADJUSTMENT. Examine the closer stop to see that it is centered in the slot in the closure track. Refer to Section III, Adjustments, Part E. CLOSURE STOP POSITION.
	D. The closure stop is not functioning correctly.	The closure stop may move downward under load, and may allow the closure to pass. Verify that the two gold springs are extended between the stop and mounting screw. Approximately 1/2 lb. (200 g) of force should be required to depress the tip of the stop. If the upward force is not adequate, the forward force of the closure on the tip of the stop will cause the tip to rotate downward and allow the closure to slide over it. The gold springs may become stretched while they are being attached if they are not handled carefully. Replace them if needed.

SECTION IV

Troubleshooting

PROBLEM	SYMPTOM	CORRECTION
9. The closure strip will not slide freely through the closure track.	A. The closures are snagging on the closure stop setscrew.	See Section III, Adjustments, Part F. CLOSURE STOP SETSCREW ADJUSTMENT.
	B. The closure track is fouled with foreign material.	See Section III, Adjustments, Part B. TOP CLOSURE TRACK REMOVAL to open the track and clean it.
10. The closure strip dislodges from the closure track.	Closure track shims are not installed or not in proper position.	See Section II, Operation, Part G. CONVERSION PROCEDURE for correct shim position(s).

PRINT QUALITY TROUBLE SHOOTING

1. The entire printed image is light.	A. The ink roll is depleted.	Replace the ink roll. If the print force has been increased, readjust it to the minimum setting for good print quality.
	B. The inking force is inadequate.	Verify that the silver colored spring (0S-119) is in good condition and is connected between the ink roll arm and the printer link.
	C. The print force is too light.	Turn the print force knob 1/4 turn counterclockwise. If both RL and SL series closures are being used in the same 086-200, the print force should be readjusted at each changeover. If the knob turns easily and the printed image does not improve, refer to Section III, Adjustments, Part U. PRINT FORCE RANGE.
2. The top of the line of printed image is light.	A. The type is not completely inked.	Refer to Section III, Adjustments, Part Q. INK ROLL ARM POSITION. Also for the gripline printer, the type may not be properly installed. Refer to Section II, Operation, Part C. 2, b.
	B. The printhead is tipped.	Refer to Section III, Adjustments, Part T. PRINT FORCE-TOP TO BOTTOM.

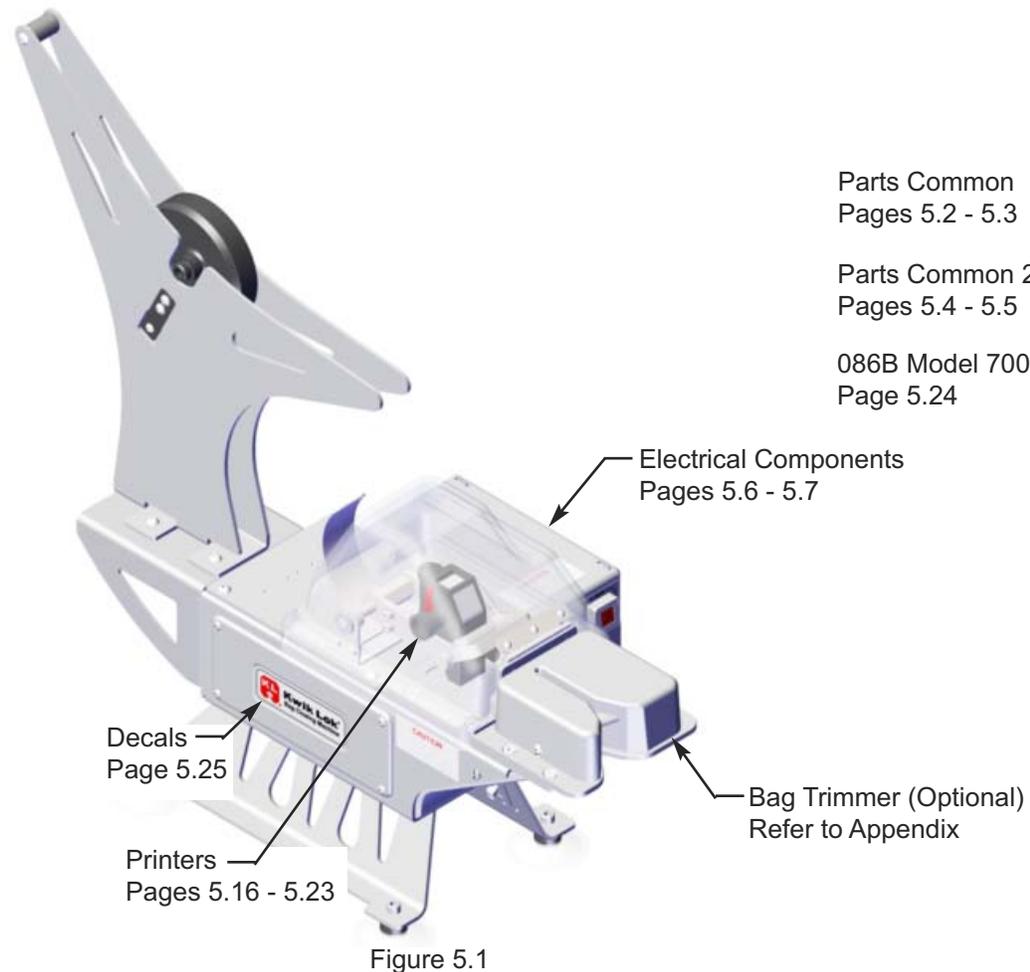
SECTION IV Troubleshooting

PROBLEM	SYMPTOM	CORRECTION
3. The printed image is light on one end.	A. The ink roll is tipped.	Refer to Section III, Adjustments, Part R. INKING FORCE-SIDE TO SIDE.
	B. The printhead is tipped.	Refer to Section III, Adjustments, Part S. PRINT FORCE-SIDE TO SIDE.
4. The printed image has light or missing characters.	A. The height of the type is uneven.	With usage type wears. For the bandheads, some of the most-used characters are repeated on some bands. Replace the bandhead if needed. For the type block, replace worn type.
5. The printed characters have wide lines which also may be dark on the edges and light in between.	A. The print force is too heavy.	Turn the print force knob 1/4 turn clockwise at a time and test the results. Continue adjusting the print pressure until the printed image becomes light and then back up the knob 1/4 turn.
6. The printed characters are irregular and fuzzy.	A. The type is dirty.	Clean the type with a cloth or tissue. Isopropyl alcohol swabs work well. For the gripline block printer, remove the block from the printer lever. For the band printer, remove the ink roll while cleaning the type or rotate the printhead by hand to gain better access to the typeface. Store the closures in an area where they will stay clean and not gather dust and debris. Always keep the printer cover closed. Do not soak type in alcohol or other solvents as it will swell the type and make it unusable.
7. The print image is smeared.	A. The closure track is dirty.	If the print image extends to the edge of the closure, it will smear in the closure track. Once the ink starts to smear, the problem will worsen rapidly. Refer to Section III, Adjustments, Part B. TOP CLOSURE TRACK REMOVAL and clean the top and bottom of the closure track grooves with a tissue or soft cloth. Isopropyl alcohol works well for this.
	B. The ink roll is not working properly.	Do not attempt to recondition a used ink roll by adding solvent or stamp pad ink to the roll.
8. The ink is smeared on the back side of the closure.	A. The type is printing on the closure track when no closure is at the print location.	Refer to Section II, Operation, Part B. LOADING A ROLL OF CLOSURES.

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SECTION V

Parts Identification



PARTS ORDERING PROCEDURE

IMPORTANT: When ordering parts, **ALWAYS:**

- 1) Specify on the order the **TYPE, MODEL,** and **SERIAL NUMBER** of the machine for which the parts are being ordered. This information can be found on the machine nameplate.
- 2) **DO NOT** order by item number. Order by **PART** or **KIT** number.

To order individual parts, be sure to do the following:

- 1) Identify the needed parts by referring to the assembly illustrations. Each part is assigned an item number on the illustration.
- 2) Refer to the parts list. Locate the item number for the part to be ordered. Opposite the item number is the part number and description for that part.
- 3) Again, specify on the order the **TYPE, MODEL,** and **SERIAL NUMBER** for which the parts are being ordered. This information is located on the machine nameplate.

For technical support during regular business hours, call your local Kwik Lok distributor. For 24/7 technical support call Kwik Lok Corporation at 1 800-688-5945 if you are in the continental U.S. For those outside the U.S., please dial + 1-509-248-4770.

SECTION V Parts Identification

PARTS COMMON

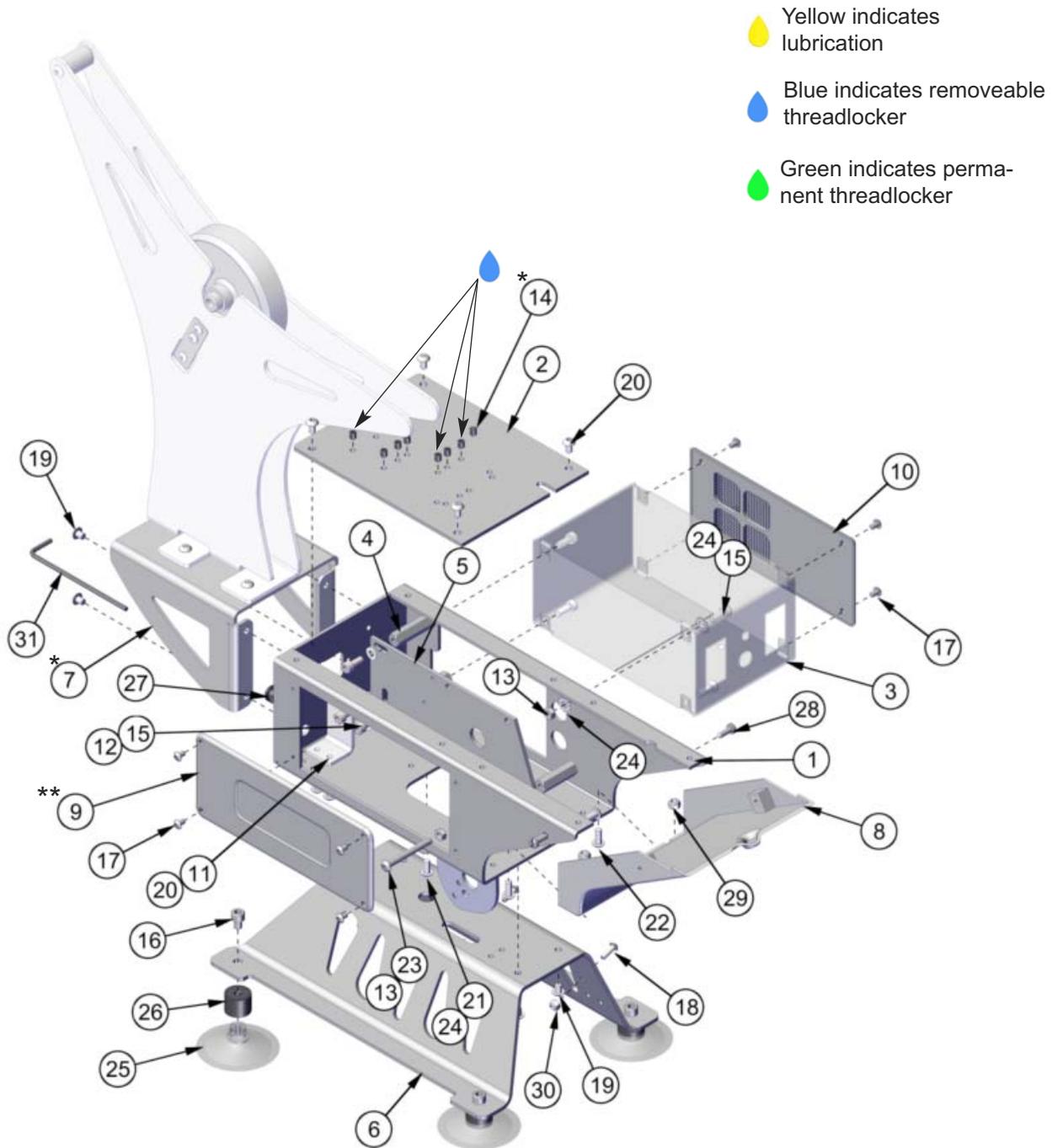


Figure 5.2

SECTION V

Parts Identification

PARTS COMMON

(Figure 5.2)

PARTS LIST

Item No.	Part No.	Description	Qty.
1	00-001491	FRAME - CLOSER	1
2	00-001492	PLATE - TOP	1
3	00-001498	ENCLOSURE - ELECTRICAL	1
4	00-001499	POST - 10MM HEX - M5	3
5	00-001505	PLATE - MOTOR MOUNTING	1
6	00-001525	STAND - CLOSER	1
7 *	00-001540	BRACKET - ROLL SUPPORT	1
8	00-001580	SHIELD	1
9 **	00-001581	COVER - ACCESS	1
10	00-001588	COVER - ELECTRICAL	1
11	00-001595	TAB - DEFLECTOR	1
12	F01-M05 S	WASHER - 5MM - FLAT - S/S	4
13	F03-M05 S	NUT - HEX	2
14 *	F06-M05X006 S	SCREW - 5MM X 6MM LG SKT SET	11
15	F10-M05X012 S	SCREW - 5MM X 12MM LG SKT HD CAP	8
16	F10-M06X008 S	SCREW - 6MM X 8MM SKT HD CAP	4
17	F11-M04X006 S	SCREW - 4MM X 6MM LG SKT BTN HD	8
18	F11-M04X012 S	SCREW - 4MM X 12MM LG SKT BTN HD	2
19	F11-M05X006 S	SCREW - 5MM X 6MM LG SKT BTN HD	8
20	F11-M05X008 S	SCREW - 5MM X 8MM LG SKT BTN HD S/S	6
21	F11-M05X010 S	SCREW - 5MM X 10 MM LG SKT BTN HD S/S	1
22	F11-M05X012 S	SCREW - 5MM X 12MM LG SKT BTN HD S/S	2
23	F11-M05X045S	SCREW - 5MM X 45MM LG SKT BTN HD-S/S	1
24	F17-250	WASHER - 1/4" EXTERNAL LOCK-S/S	3
25	P05-00128	CUP - SUCTION 2-1/2 WITH STUD/NUT	4
26	P05-00202	BUMPER - RUBBER 20MM DIA X 15MM TALL	4
27	P11-01072	GROMMET - 1/8ID, .094GROOVE	1
28	P23-00291	SCREW - NO 8 X 1/2 PAN HD - PLASTIC	2
29	P23-00386 S	NUT - 5MM ESNA	3
30	P23-00389 S	NUT - 4MM ESNA	2
31	P30-00215	WRENCH - SHORT-HEX KEY-3MM	1

* 00-001540 BRACKET - ROLL SUPPORT AND F06-M05X006 S are only used with a 086B Model 200P, 600P or 700P (closer with printer).

**086B See Page 5.24 for details of 086B Model 700P parts identification.

SECTION V

Parts Identification

PARTS COMMON 2

-  Yellow indicates lubrication
-  Blue indicates removeable threadlocker
-  Green indicates permanent threadlocker

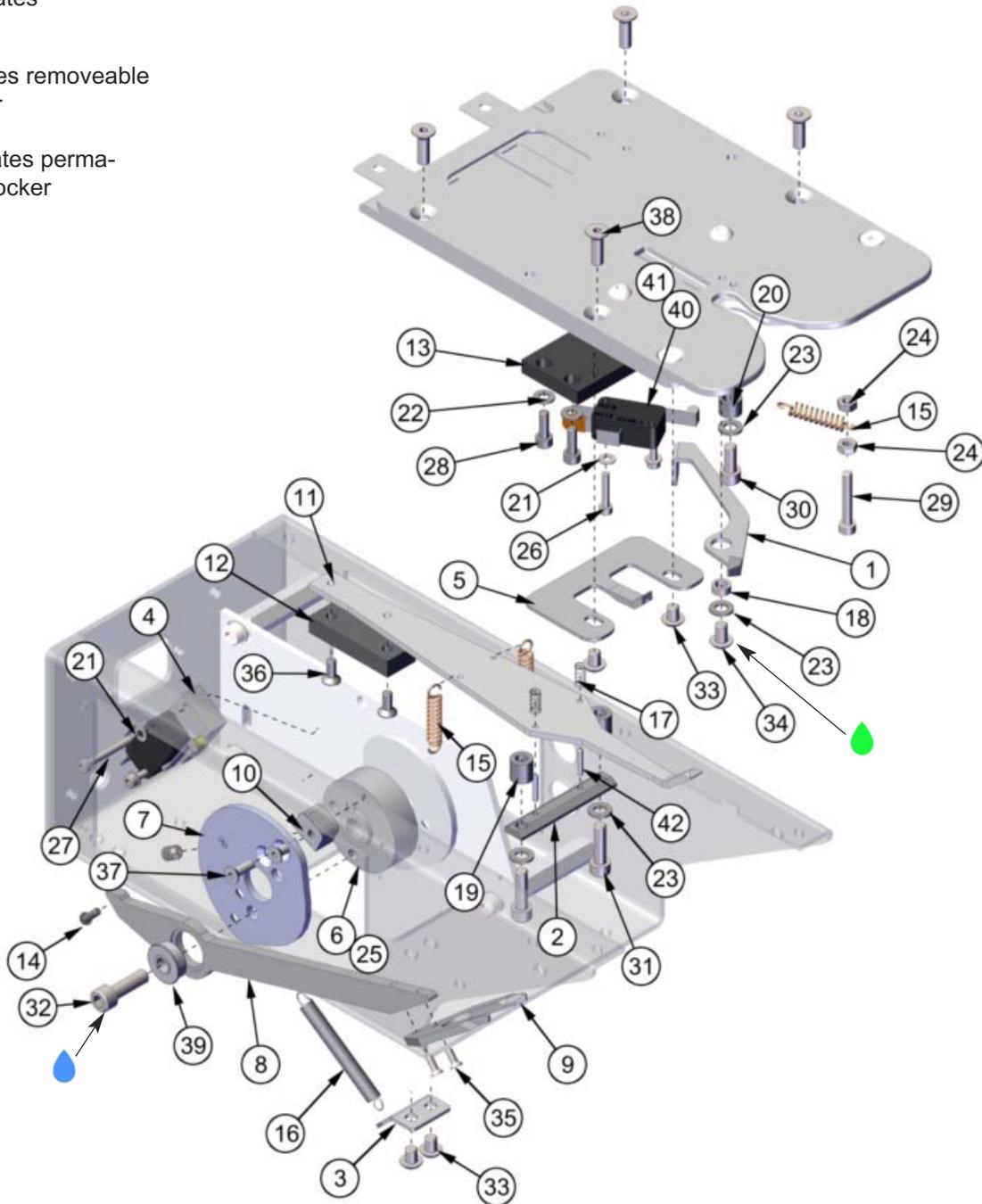


Figure 5.3

SECTION V

Parts Identification

PARTS COMMON 2

(Figure 5.3)

PARTS LIST

Item No.	Part No.	Description	Qty.
1	00-001012	SENSOR - LOK	1
2	00-001013	MOUNT - STOP	1
3	00-001024	BRACKET - SPRING	1
4	00-001025	BLOCK - CAM	1
5	00-001029	CHECK	1
6	00-001500	HUB - CAM	1
7	00-001501	CAM - STOP	1
8	00-001502	ARM - PICK	1
9	00-001503	PICK	1
10	00-001504	CAM - SWITCH	1
11	00-001507	STOP - CLOSURE	1
12	00-001508	PLATE - WEAR	1
13	00-001509	BLOCK - SENSOR	1
14	08-002026	PIN - DRIVE	1
15	0S-012	SPRING - ACTUATING LEVER RETURN	3
16	0S-117	SPRING - EXTENSION	1
17	0S-118	SPRING - COMPRESSION	2
18	BS 312 203 125	BUSHING	1
19	BS 375 203 375	BUSHING	2
20	BS 375 257 281	BUSHING	1
21	F01-M03 S	WASHER - 3MM FLAT - SS	4
22	F01-M04 S	WASHER - 4MM - FLAT - S/S	2
23	F01-M05 S	WASHER - 5MM - FLAT - S/S	4
24	F03-M04 S	NUT - HEX	2
25	F06-M06X008 S	SCREW - 6MM X 8MM LG SKT SET	1
26	F10-M03X016 S	SCREW - 3MM X 16MM LG SKT HD CAP	2
27	F10-M03X025 S	SCREW - 3MM X 25MM LG SKT HD CAP	2
28	F10-M04X012 S	SCREW - 4MM X 12MM LG SKT HD CAP	2
29	F10-M04X025S	SCREW - 4MM X 25MM LG SKT HD CAP-S/S	1
30	F10-M05X012 S	SCREW - 5MM X 12MM LG SKT HD CAP	1
31	F10-M05X018S	SCREW - 5MM X 18MM LG SKT HD CAP	2
32	F10-M06X020 S	SCREW - 6MM X 20MM LG SKT HD CAP S/S	1
33	F11-M05X006 S	SCREW - 5MM X 6MM LG SKT BTN HD	4
34	F11-M05X008 S	SCREW - 5MM X 8MM LG SKT BTN HD S/S	1
35	F12-M03X008 S	SCREW - 3MM X 8MM LG SKT FLT HD	2
36	F12-M04X010 S	SCREW - 4MM X 10MM SKT FLT HD	2
37	F12-M04X012 S	SCREW - 4MM X 12MM LG SKT FLT HD	2
38	F12-M05X016 S	SCREW - 5MM X 16MM SKT FLT HD S/S	4
39	P02-00064	BEARING - FLANGE	1
40	P12-00085	SWITCH - MICRO	2
41	P17-00033	CAP	1
42	P23-00169	PIN - DRIVE	2

SECTION V

Parts Identification

ELECTRICAL COMPONENTS

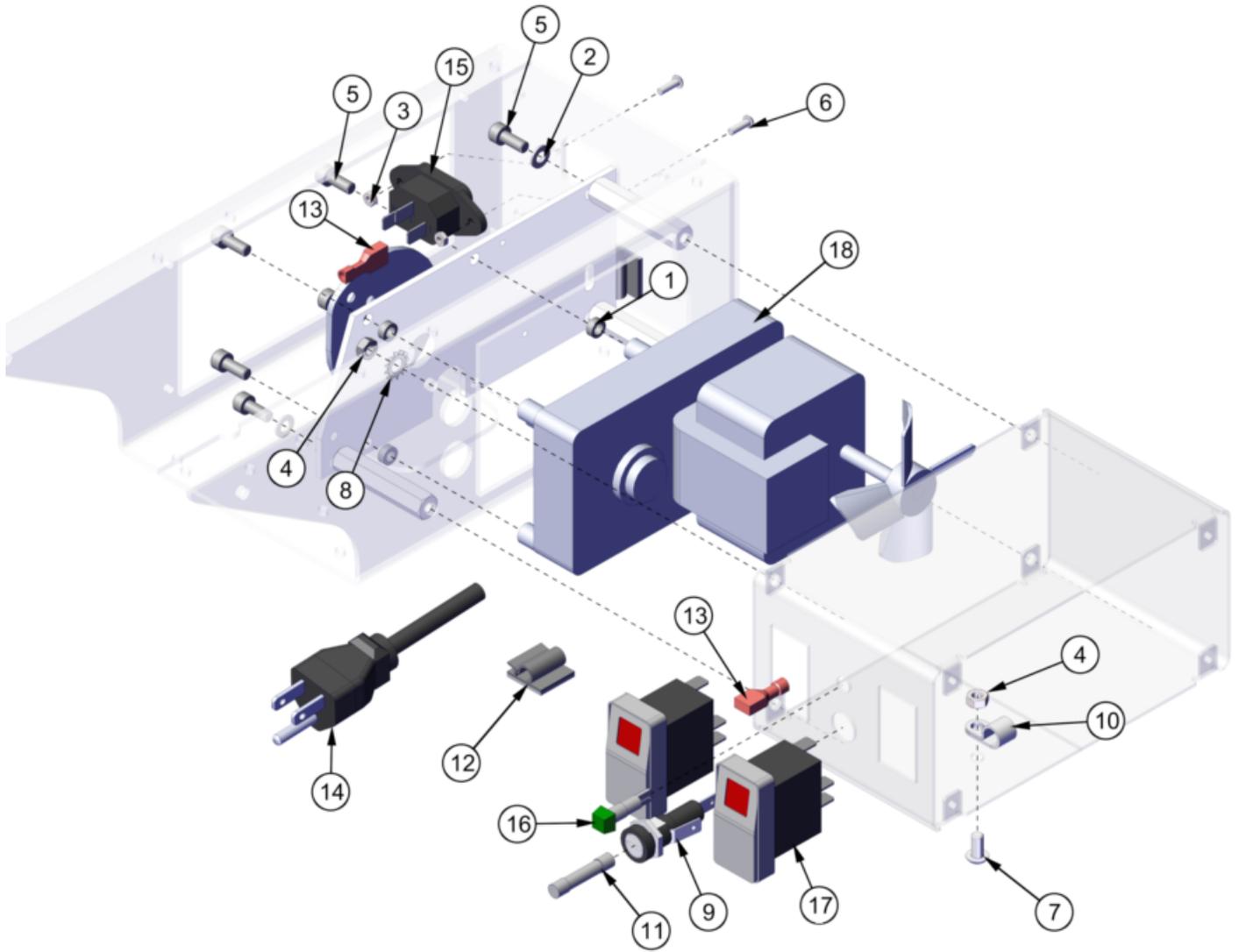


Figure 5.4

SECTION V

Parts Identification

ELECTRICAL COMPONENTS

(Figure 5.4)

PARTS LIST

Item No.	Part No.	Description	Qty.
1	BS 312 203 125	BUSHING	4
2	F01-M05 S	WASHER - 5MM - FLAT - S/S	3
3	F03-M03 S	NUT - HEX	2
4	F03-M05 S	NUT - HEX	2
5	F10-M05X012 S	SCREW - 5MM X 12MM LG SKT HD CAP	7
6	F11-M03X010 S	SCREW - 3MM X 10MM LG SKT BTN HD	2
7	F11-M05X010 S	SCREW - 5MM X 10 MM LG SKT BTN HD S/S	1
8	F17-250	WASHER- 1/4" EXTERNAL LOCK-S/S	1
9	P11-00042	HOLDER - FUSE	1
10	P11-00139	CLAMP - CORD	1
11	P11-00270	FUSE - 115VAC	1
11.	P11-00616	FUSE - 220-250VAC	1
12	P11-00271	CLAMP	2
13	P11-00274	TERMINAL - QUICK CONNECT	2
14	P11-00943	CORD - POWER N. AMERICA 115VAC TO IEC	1
14.	P11-01020	CORD - POWER N. AMERICA 220VAC TO IEC C13	1
14..	P11-00606	CORD - POWER EUROPEAN SCHUKO PLUG TO ROJ	1
14...	P11-01007	CORD - POWER INDIA/S. AFRICA BS546 TO ROJ	1
14....	P11-01019	CORD - POWER U.K. BS1363 TO ROJ	1
14.....	P11-00946	CORD - POWER AUSTRALIA AS3112 TO ROJ	1
14.....	P11-00944	CORD - POWER JAPAN 100V TO IEC	1
14.....	08-007276	CORD - POWER - 200V IEC - JAPAN	1
14.....	P11-01055	CORD - POWER CHINA GB15934 TO IEC C13	1
15	P11-01018	RECEPTACLE - POWER INLET	1
16	P12-00193	LIGHT - 115VAC	1
16.	P12-00194	LIGHT - 200-240VAC	1
17	P12-00287	SWITCH - ROCKER - 115VAC	2
17.	P12-00288	SWITCH - ROCKER - 230VAC	2
18	P21-00257	GEARMOTOR - 115VAC	1
18.	P21-00258	GEARMOTOR - 230VAC	1

SECTION V
Parts Identification

086B MODEL 100 LOK TRACK

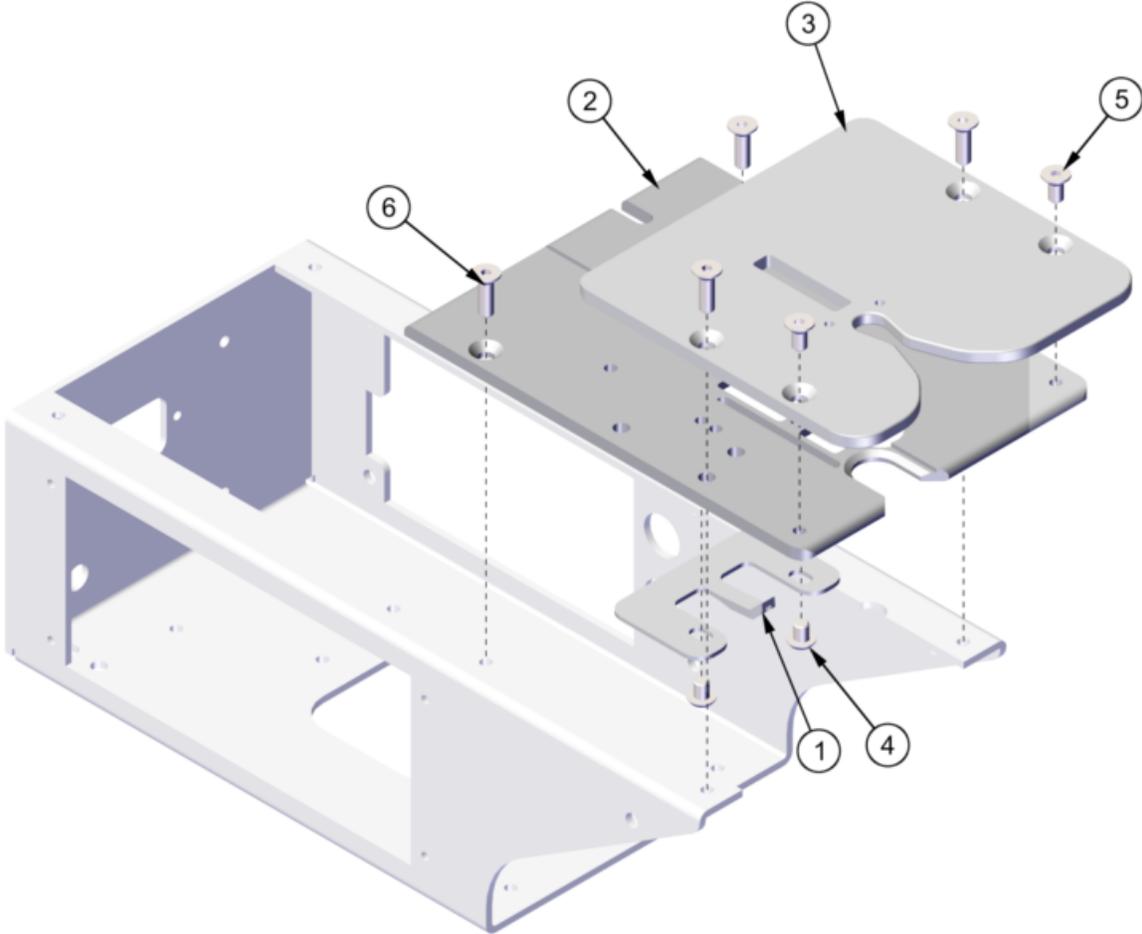


Figure 5.5

SECTION V

Parts Identification

086B MODEL 100 LOK TRACK

(Figure 5.5)

PARTS LIST

Item No.	Part No.	Description	Qty.
1	00-001029	CHECK	1
2	00-001493	TRACK - BOTTOM	1
3	00-001563	TRACK - RJ TOP LOK	1
4	F11-M05X006 S	SCREW - 5MM X 6MM LG SKT BTN HD	2
5	F12-M05X010 S	SCREW - 5MM X 10MM LG SKT FLT HD	2
6	F12-M05X016 S	SCREW - 5MM X 16MM SKT FLT HD S/S	4

SECTION V

Parts Identification

086B MODEL 200, 200P, 600, 600P LOK TRACKS

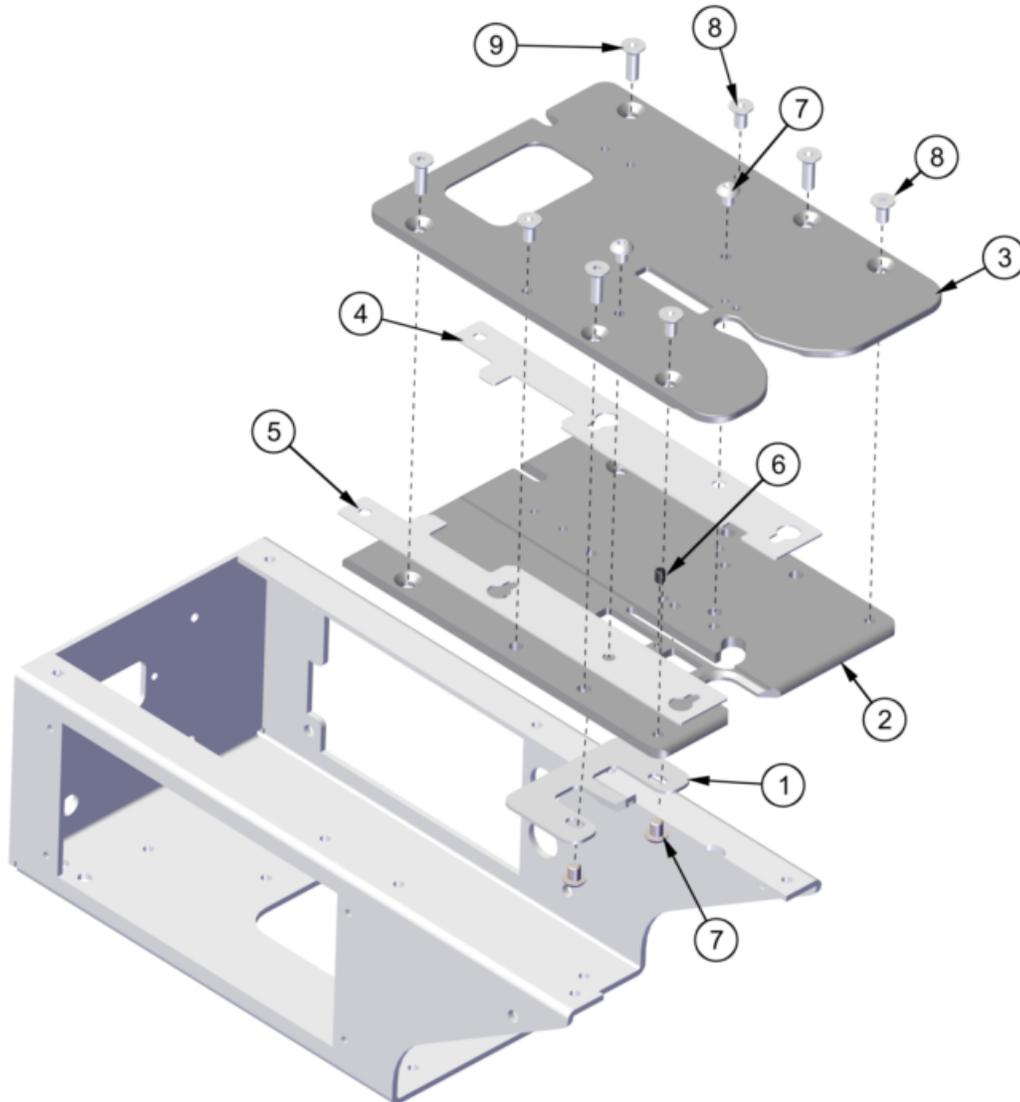


Figure 5.6

SECTION V

Parts Identification

086B MODEL 200, 200P, 600, 600P LOK TRACKS

(Figure 5.6)

PARTS LIST

Item No.	Part No.	Description	Qty.
1	00-001029	CHECK	1
2	00-001493	TRACK - BOTTOM	1
3	00-001496	TRACK - TOP - MODEL 200	1
3.	00-001600	TRACK - TOP - MODEL 600	1
4	00-001564	SHIM - RIGHT LOK GUIDE	1
5	00-001584	SHIM - LEFT LOK GUIDE	1
6	F06-M04X006NS	SCREW - 4MMX6MM SOCKET NYLOK SET	1
7	F11-M05X006 S	SCREW - 5MM X 6MM LG SKT BTN HD	4
8	F12-M05X010 S	SCREW - 5MM X 10MM LG SKT FLT HD	4
9	F12-M05X016 S	SCREW - 5MM X 16MM SKT FLT HD S/S	4

SECTION V
Parts Identification

086B MODEL 100 ROLL SUPPORTS

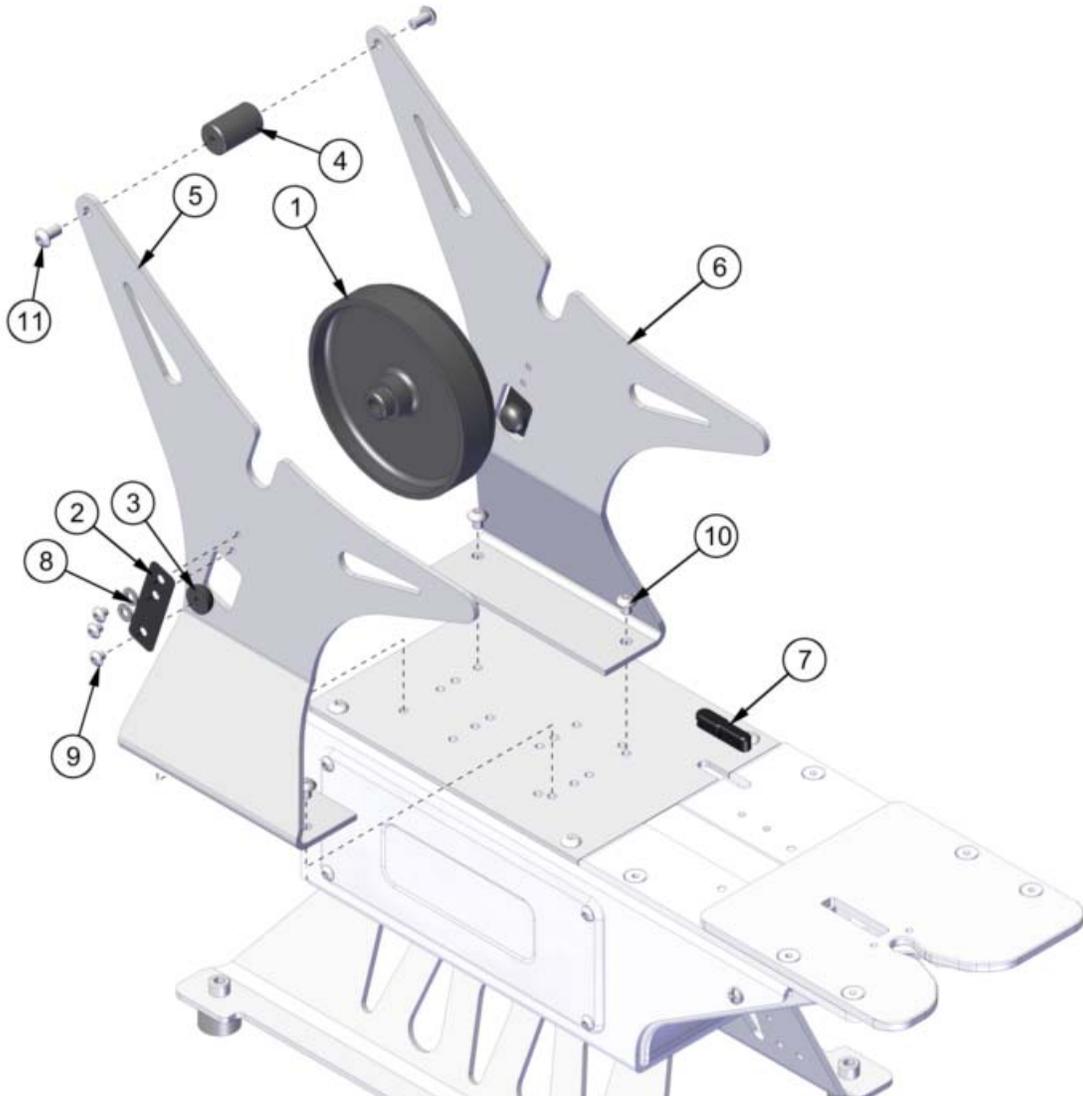


Figure 5.7

SECTION V

Parts Identification

086B MODEL 100 ROLL SUPPORTS

(Figure 5.7)

PARTS LIST

Item No.	Part No.	Description	Qty.
1	00-000594	HUB - CLOSURE	1
2	00-000684	SPRING - BRAKE	2
3	00-001497	PAD - BRAKE	2
4	00-001519	SPACER - FRAME - STANDARD	1
5	00-001562L	SUPPORT - RJ ROLL	1
6	00-001562R	SUPPORT - RJ ROLL	1
7	00-001579	PLUG - TOP PLATE	1
8	F01-M04 S	WASHER - 4MM - FLAT - S/S	4
9	F11-M04X004 S	SCREW - 4MM X 4MM LG SKT BTN HD	6
10	F11-M05X006 S	SCREW - 5MM X 6MM LG SKT BTN HD	4
11	F11-M05X010 S	SCREW - 5MM X 10 MM LG SKT BTN HD S/S	2

SECTION V

Parts Identification

086B MODEL 200, 200P, 600, 600P, AND 700P ROLL SUPPORTS

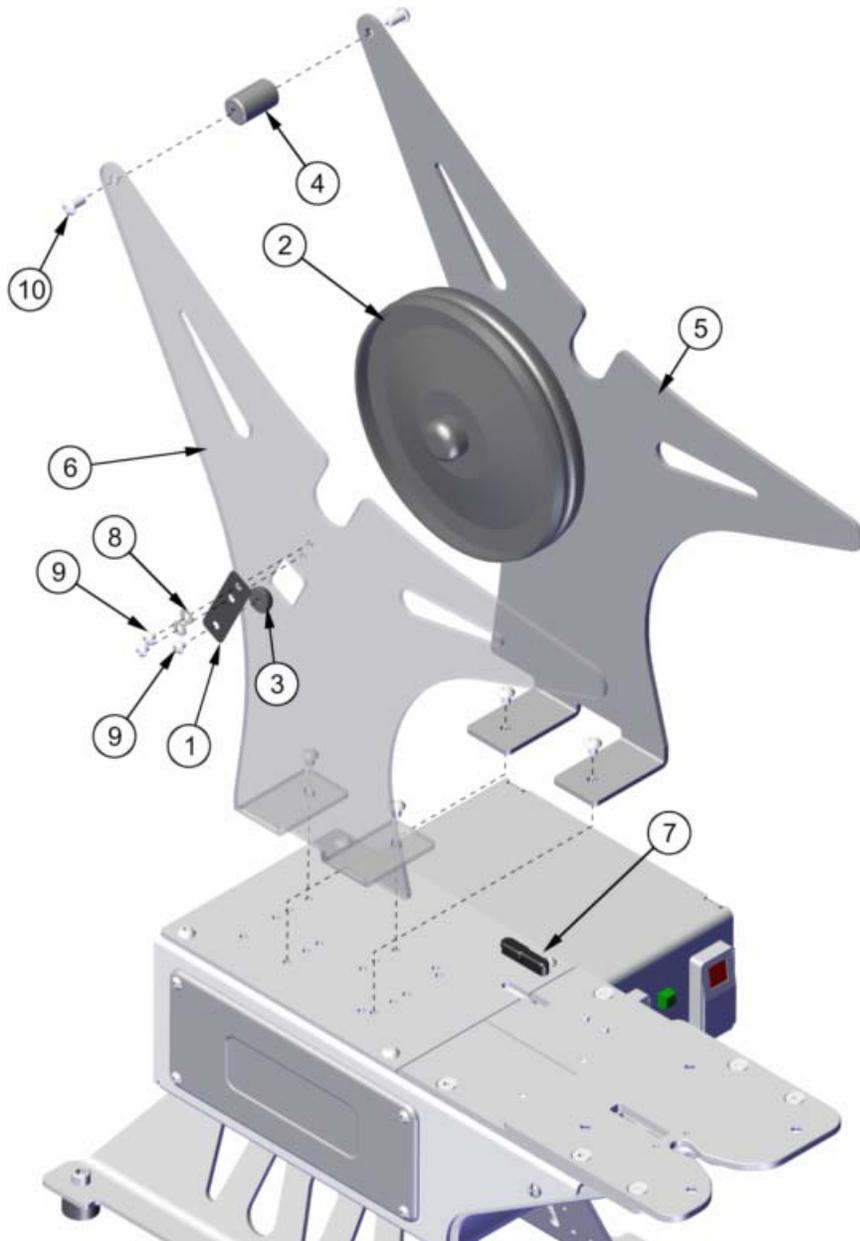


Figure 5.8

SECTION V Parts Identification

086B MODEL 200, 200P, 600, 600P, AND 700P ROLL SUPPORTS

(Figure 5.8)

PARTS LIST

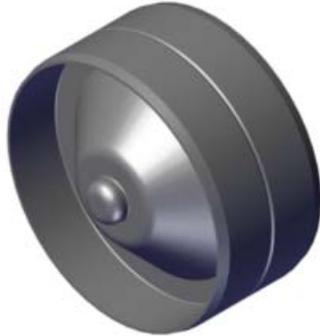
Item No.	Part No.	Description	Qty.
1	00-000684	SPRING - BRAKE	2
2	00-000890	HUB UNIT - L LABELS	1
2.	00-000891	HUB UNIT - U LABELS	1
2..	00-001075	HUB UNIT - CR LABELS	1
2...	00-000594	HUB - CLOSURE	1
3	00-001497	PAD - BRAKE	2
4	00-001519	SPACER - FRAME - STANDARD	1
4.	00-001520	SPACER - FRAME - U LABELS	1
4..	00-001521	SPACER - FRAME - CR LABELS	1
5	00-001542	SUPPORT - RIGHT ADJ ROLL	1
6	00-001543	SUPPORT - LEFT ADJ ROLL	1
7	00-001579	PLUG - TOP PLATE	1
8	F01-M04 S	WASHER - 4MM - FLAT - S/S	4
9	F11-M04X004 S	SCREW - 4MM X 4MM LG SKT BTN HD	6
10	F11-M05X010 S	SCREW - 5MM X 10 MM LG SKT BTN HD S/S	2



00-000594 HUB
UNIT - RJ CLOSURE



00-000890 HUB UNIT -
L LABELS



00-000891 HUB UNIT -
U LABELS



00-001075 HUB UNIT -
CR LABELS

Z0086071 KIT - L LABEL CONVERSION. CONSISTS OF 00-000890 HUB UNIT - L LABELS (1).

Z0086072 KIT - U LABEL CONVERSION. CONSISTS OF 00-000891 HUB UNIT - U LABELS (1) AND 00-001520 SPACER - FRAME - U LABELS (1).

Z0086073 KIT - CR LABEL CONVERSION. CONSISTS OF 00-001075 HUB UNIT - CR LABELS (1) AND 00-001521 SPACER - FRAME - CR LABELS (1).

SECTION V

Parts Identification

086BP BAND PRINTER ARM

-  Yellow indicates lubrication
-  Blue indicates removeable threadlocker
-  Green indicates permanent threadlocker

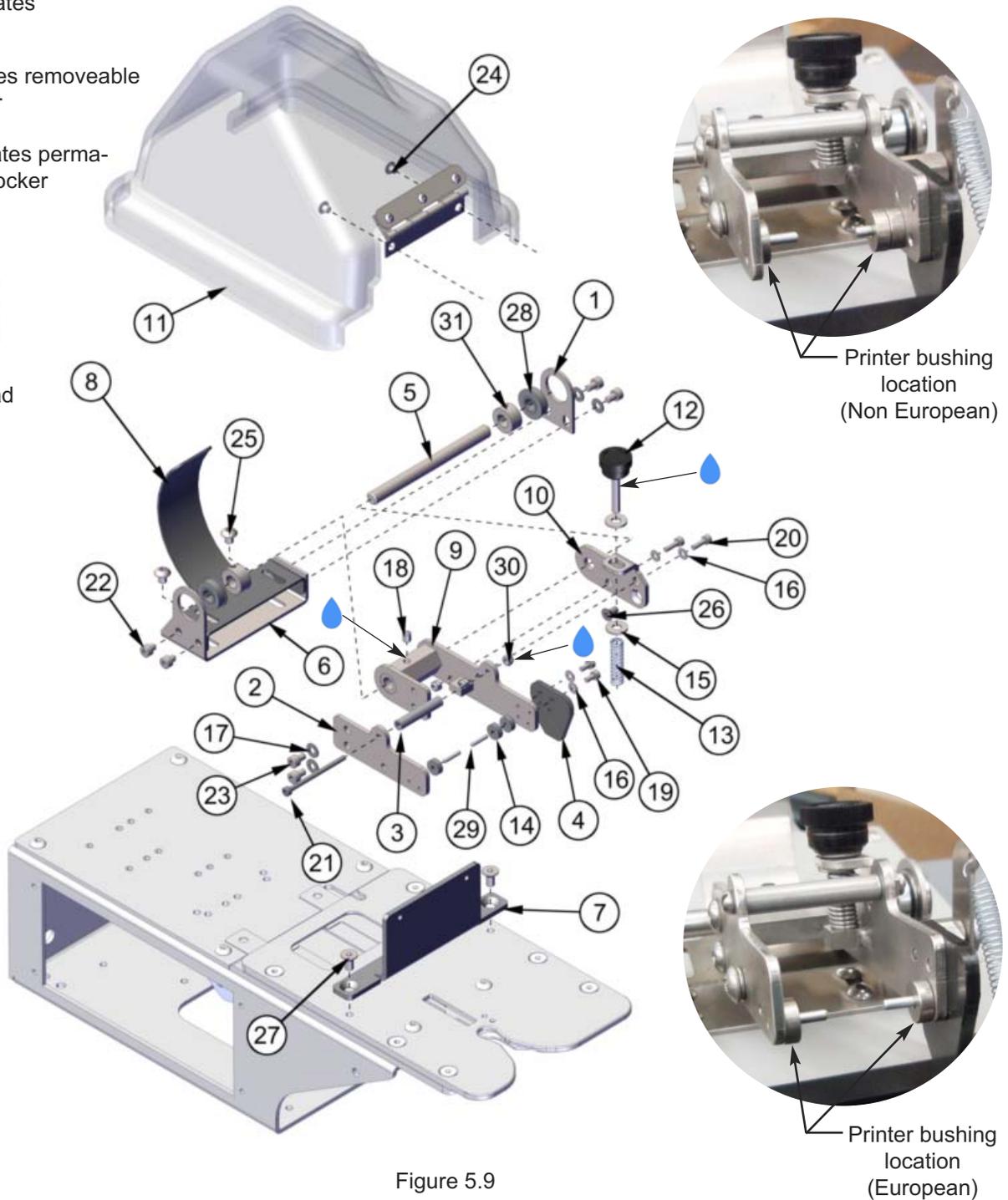


Figure 5.9

SECTION V

Parts Identification

086BP BAND PRINTER ARM

(Figure 5.9)

PARTS LIST

Item No.	Part No.	Description	Qty.
1	00-000513 S	MOUNT - BEARING	1
2	00-001053	ARM - SIDE BAND PRINTER	1
3	00-001055	SPACER	1
4	00-001056	CAM - INK ROLL	1
5	00-001077	SHAFT	1
6	00-001078	BRACKET	1
7	00-001541	BRACKET - COVER MT	1
8	00-001544	SHOE - STRIP	1
9	00-001545	LEVER UNIT - BAND PRINTER	1
10	00-001546	ARM - PRINTER ADJUST	1
11	00-001553	COVER UNIT - PRINTER	1
12	00-001554	KNOB - #10 MALE ADJ	1
13	0S-119	SPRING - COMPRESSION	1
14	BS 375 109 125	BUSHING	3
15	F01-190 S	WASHER - NO 10 FLAT	2
16	F01-M03 S	WASHER - 3MM FLAT - SS	4
17	F01-M04 S	WASHER - 4MM - FLAT - S/S	4
18	F06-M05X006 S	SCREW - 5MM X 6MM LG SKT SET	1
19	F10-M03X006 S	SCREW - 3MM X 6MM LG SKT HD CAP	2
20	F10-M03X010 S	SCREW - 3MM X 10MM LG SKT HD CAP	2
21	F10-M03X045S	SCREW - 3MMX45MM LG SKT HD CAP S/S	1
22	F10-M04X004S	SCREW - 4MM X 4MM LG SKT HD CAP	2
23	F10-M04X006 S	SCREW - 4MM X 6MM LG SKT HD CAP	4
24	F11-M04X004 S	SCREW - 4MM X 4MM LG SKT BTN HD	2
25	F11-M05X006 S	SCREW - 5MM X 6MM LG SKT BTN HD	2
26	F12-M04X008 S	SCREW - 4MM X 8MM LG SKT FLT HD	1
27	F12-M05X010 S	SCREW - 5MM X 10MM LG SKT FLT HD	2
28	P02-00066	BEARING - CAM	2
29	P23-00169	PIN - DRIVE	2
30	P23-00384 S	NUT - 3MM ESNA	3
31	P29-00035 S	COLLAR - SET-8MM ID	2

SECTION V

Parts Identification

086BP BAND PRINTER INK ROLL ARM

-  Yellow indicates lubrication
-  Blue indicates removeable threadlocker
-  Green indicates permanent threadlocker

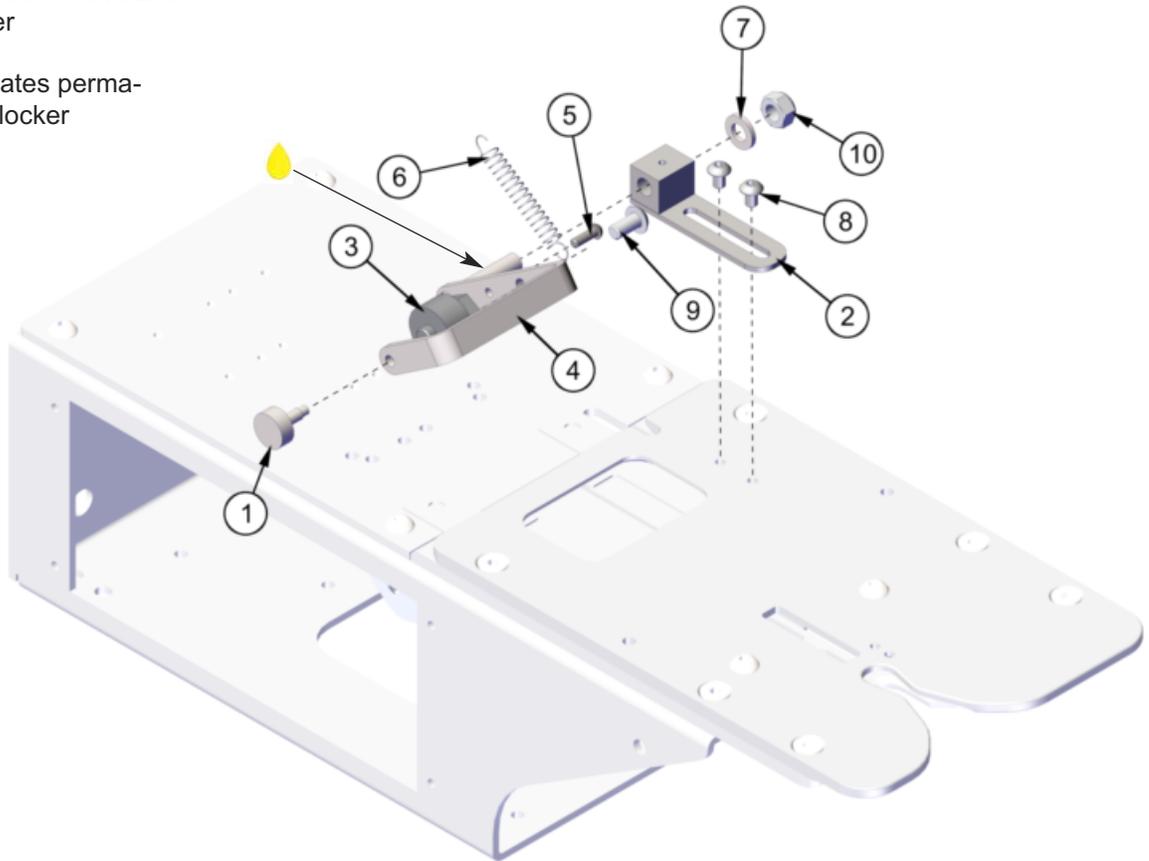


Figure 5.10

SECTION V

Parts Identification

086BP BAND PRINTER INK ROLL ARM

(Figure 5.10)

PARTS LIST

Item No.	Part No.	Description	Qty.
1	00-000721	KNOB - INK ROLL - NON EUROPE	1
1.	00-000723	KNOB - INK ROLL - EUROPE	1
2	00-001062	MOUNT UNIT - INK ROLL ARM	1
3	00-001550	CAM FOLLOWER - NON-EUROPE	1
3.	00-001549	CAM FOLLOWER - EUROPE	1
4	00-001551	ARM UNIT - INK ROLL	1
5	08-002026	PIN - DRIVE	1
6	0S-006	SPRING - EXTENSION	1
7	F01-M06 S	WASHER - 6MM - FLAT - S/S	1
8	F11-M04X006 S	SCREW - 4MM X 6MM LG SKT BTN HD	2
9	F11-M05X010 S	SCREW - 5MM X 10 MM LG SKT BTN HD S/S	1
10	P23-00382 S	NUT - 6MM ESNA	1

SECTION V

Parts Identification

086BP BLOCK PRINTER

-  Yellow indicates lubrication
-  Blue indicates removeable threadlocker
-  Green indicates permanent threadlocker

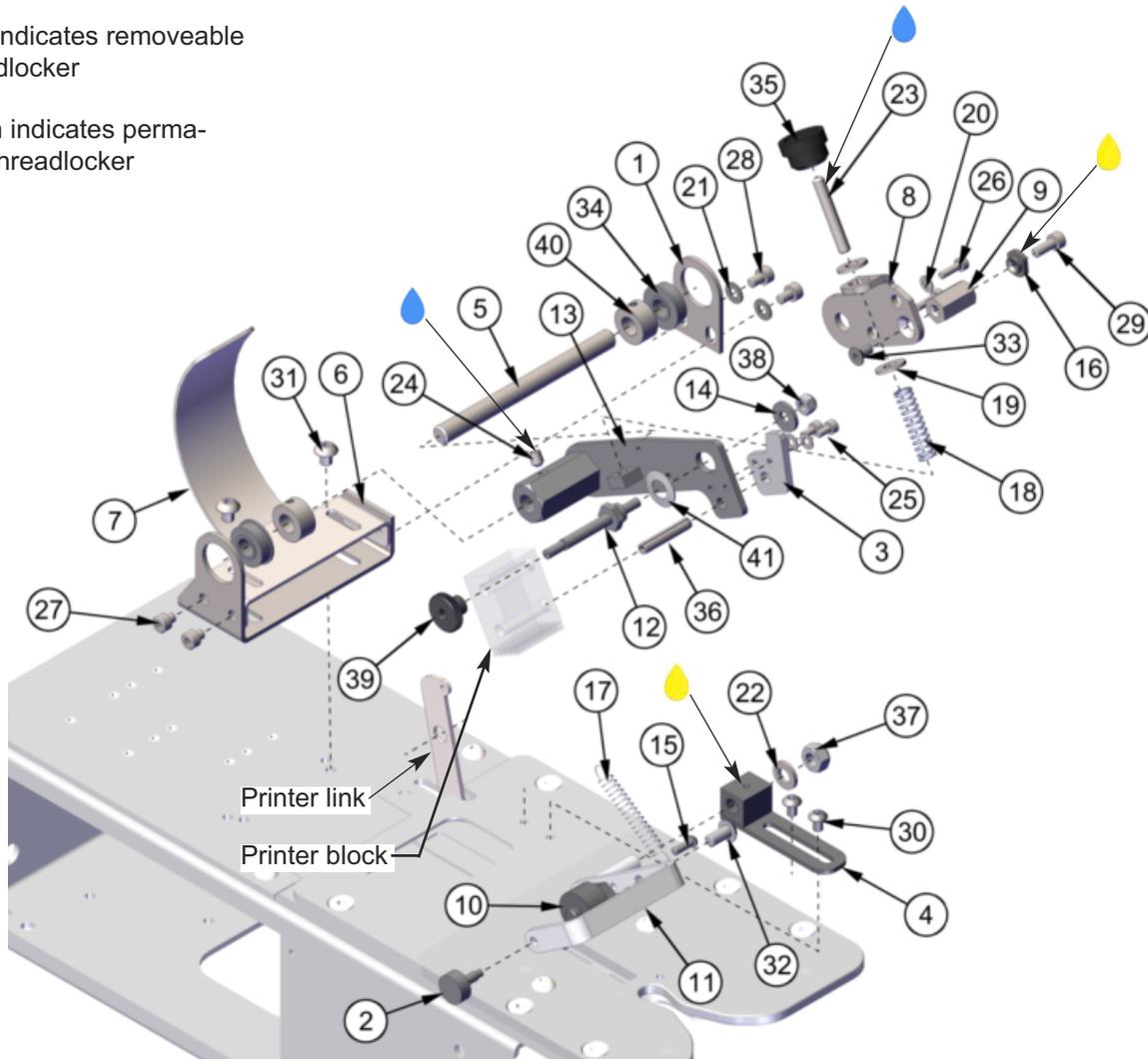


Figure 5.11

SECTION V

Parts Identification

086BP BLOCK PRINTER

(Figure 5.11)

PARTS LIST

Item No.	Part No.	Description	Qty.
1	00-000513 S	MOUNT - BEARING	1
2	00-000721	KNOB - INK ROLL- NON EUROPE	1
2.	00-000723	KNOB - INK ROLL - EUROPE	1
3	00-001057	CAM - INK BLOCK PRINTER	1
4	00-001062	MOUNT UNIT - INK ROLL ARM	1
5	00-001077	SHAFT	1
6	00-001078	BRACKET	1
7	00-001544	SHOE - STRIP	1
8	00-001546	ARM - PRINTER ADJUST	1
9	00-001547	SPACER - 11/16 LG LINK	1
10	00-001550	CAM FOLLOWER - NON-EUROPE	1
10.	00-001549	CAM FOLLOWER - EUROPE	1
11	00-001551	ARM UNIT - INK ROLL	1
12	00-001555	SHAFT - PRINTER BLOCK MT	1
13	00-001556	LEVER UNIT - BLOCK	1
14	08-000076	WASHER - LOK CHECK	1
15	08-002026	PIN - DRIVE	1
16	08-007360	MOUNT - BREAKOFF	1
17	0S-006	SPRING - EXTENSION	1
18	0S-119	SPRING - COMPRESSION	1
19	F01-190 S	WASHER - NO 10 FLAT	2
20	F01-M03 S	WASHER - 3MM FLAT - SS	4
21	F01-M04 S	WASHER - 4MM - FLAT - S/S	2
22	F01-M06 S	WASHER - 6MM - FLAT - S/S	1
23	F06-190F20 S	SCREW - 10-32UNF X 1 1/4 LG SKT SET	1
24	F06-M05X006 S	SCREW - 5MM X 6MM LG SKT SET	1
25	F10-M03X006 S	SCREW - 3MM X 6MM LG SKT HD CAP	2
26	F10-M03X010 S	SCREW - 3MM X 10MM LG SKT HD CAP	2
27	F10-M04X004S	SCREW - 4MM X 4MM LG SKT HD CAP	2
28	F10-M04X006 S	SCREW - 4MM X 6MM LG SKT HD CAP	2
29	F10-M04X010 S	SCREW - 4MM X 10MM LG SKT HD CAP	1
30	F11-M04X006 S	SCREW - 4MM X 6MM LG SKT BTN HD	2
31	F11-M05X006 S	SCREW - 5MM X 6MM LG SKT BTN HD	2
32	F11-M05X010 S	SCREW - 5MM X 10 MM LG SKT BTN HD S/S	1
33	F12-M04X008 S	SCREW - 4MM X 8MM LG SKT FLT HD	1
34	P02-00066	BEARING - CAM	2
35	P17-00125	KNOB	1
36	P23-00007S	PIN - SPRING	1
37	P23-00382 S	NUT - 6MM ESNA	1
38	P23-00389 S	NUT - 4MM ESNA	1
39	P23-00407	NUT - KNURLED M4	1
40	P29-00035 S	COLLAR - SET-8MM ID	2
41	P36-00014	WASHER - BELLEVILLE	1

SECTION V

Parts Identification

086BP PRINTER LINKAGE

-  Yellow indicates lubrication
-  Blue indicates removeable threadlocker
-  Green indicates permanent threadlocker

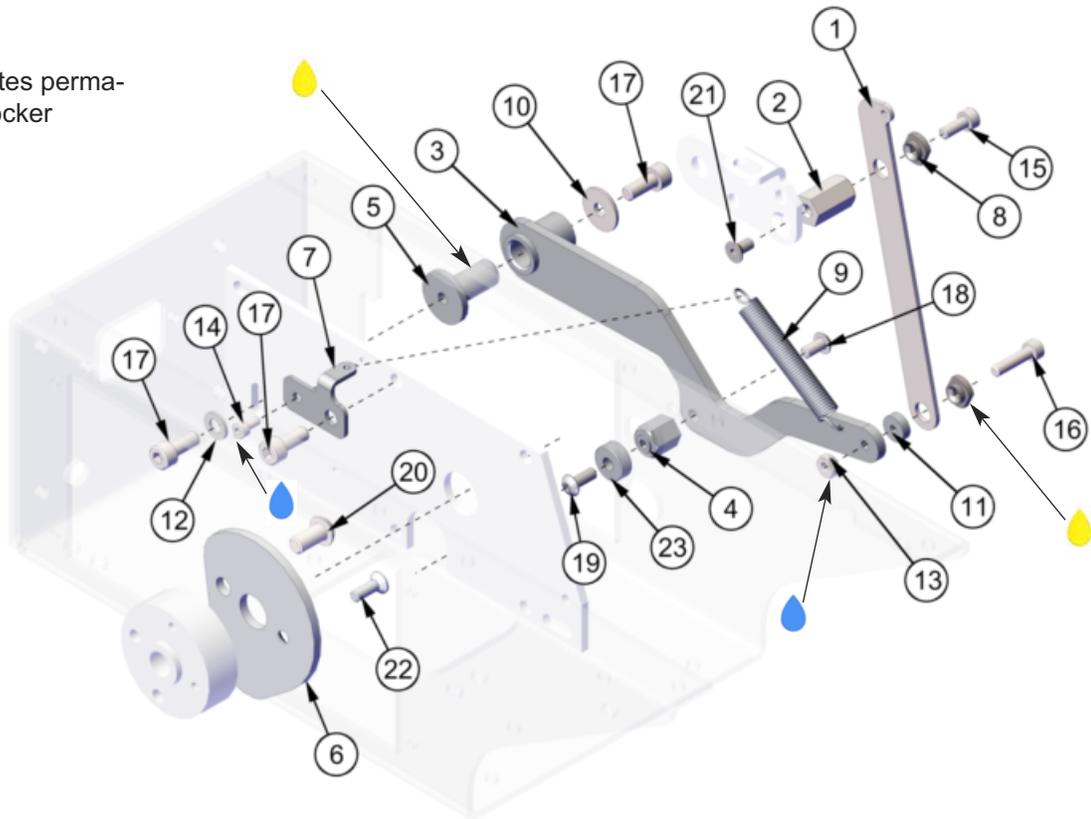


Figure 5.12

SECTION V

Parts Identification

086BP PRINTER LINKAGE

(Figure 5.12)

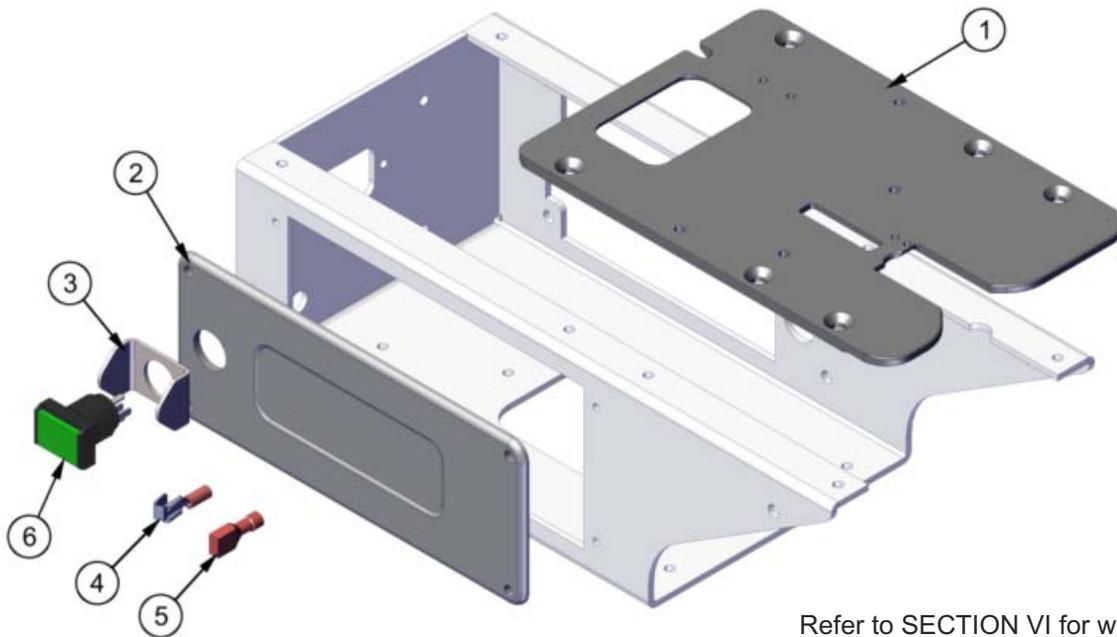
PARTS LIST

Item No.	Part No.	Description	Qty.
1	00-001072	LINK - PRINT	1
2	00-001547	SPACER - 11/16 LG LINK	1
3	00-001557	ARM - PRINTER CAM	1
4	00-001558	POST - BEARING MOUNT	1
5	00-001559	PIVOT - PRINTER ARM	1
6	00-001560	CAM - PRINTER	1
7	00-001561	BRACKET - PRINTER SPRING	1
8	08-007360	MOUNT - BREAKOFF	2
9	0S-120	SPRING - COMPRESSION	1
10	0W-001 SP	WASHER	1
11	BS 375 109 125	BUSHING	1
12	F01-M05 S	WASHER - 5MM - FLAT - S/S	1
13	F03-M04 S	NUT - HEX	1
14	F10-M03X006 S	SCREW - 3MM X 6MM LG SKT HD CAP	1
15	F10-M04X010 S	SCREW - 4MM X 10MM LG SKT HD CAP	1
16	F10-M04X016 S	SCREW - 4MM X 16MM LG SKT HD CAP	1
17	F10-M05X012 S	SCREW - 5MM X 12MM LG SKT HD CAP	3
18	F11-M04X008 S	SCREW - 4MM X 8MM LG SKT BTN HD	1
19	F11-M04X010 S	SCREW - 4MM X 10MM LG SKT BTN HD	1
20	F11-M06X012 S	SCREW - 6MM X 12MM LG SKT BTN HD	1
21	F12-M04X008 S	SCREW - 4MM X 8MM LG SKT FLT HD	1
22	F12-M04X012 S	SCREW - 4MM X 12MM LG SKT FLT HD	1
23	P02-00187	BEARING	1

SECTION V

Parts Identification

086B MODEL 700P PARTS IDENTIFICATION



Refer to SECTION VI for wiring details.

Figure 5.13

PARTS LIST

Item No.	Part No.	Description	Qty.
1	00-001598	TRACK - TOP - MODEL 700	1
2	00-001599	COVER - ACCESS - MODEL 700P	1
3	08-004680	SHIELD - PUSHBUTTON	1
4	P11-00588	TERMINAL - QC PIGGYBACK	1
5	P11-01073	TERMINAL - QUICK CONNECT	1
6	P12-00359	SWITCH - MANUAL ACTUATING	1

SECTION V Parts Identification

DECALS AND DECAL PLACEMENT

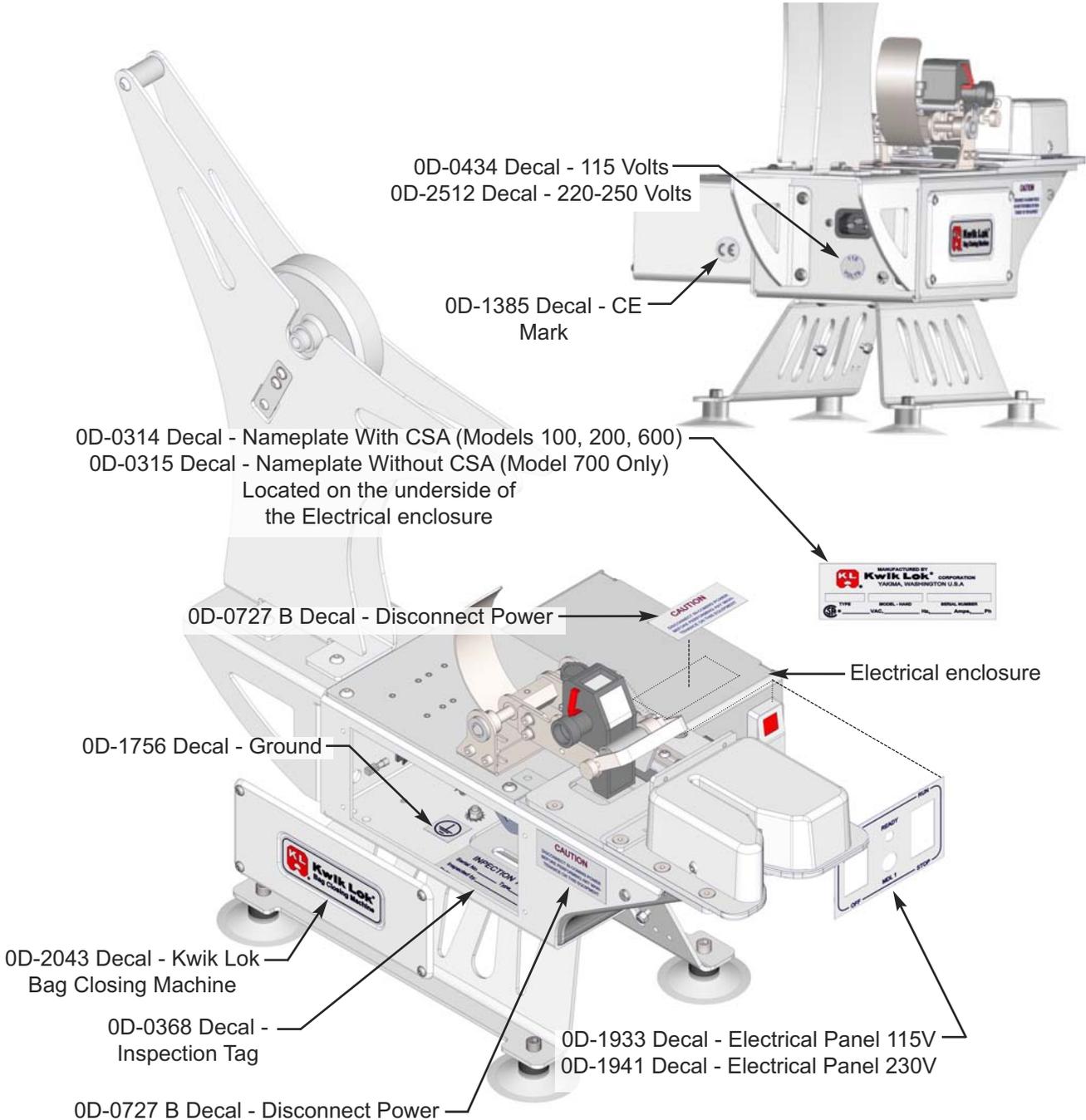
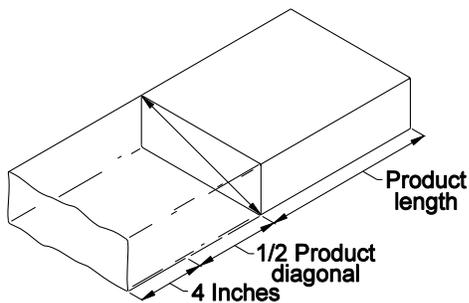
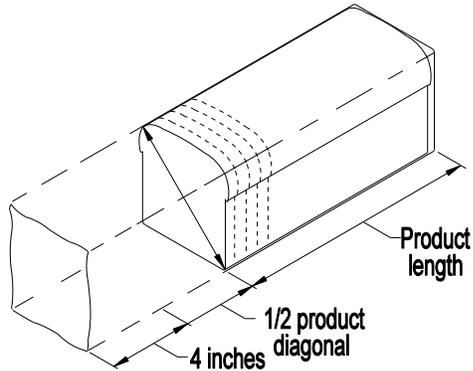


Figure 5.14

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BAG LENGTH FORMULAS

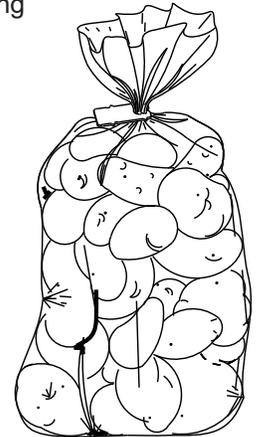


TO DETERMINE THE PROPER BAG LENGTH * FOR A CONSISTENTLY SHAPED PRODUCT (E.G. Bread, Bun Clusters, Trays, English Muffins, etc.) FOLLOW THIS FORMULA:

TOTAL BAG LENGTH EQUALS LENGTH OF PRODUCT PLUS 1/2 OF THE DIAGONAL OF THE PRODUCT END PLUS 4 INCHES.

TO DETERMINE THE PROPER BAG LENGTH FOR A LOOSE BULK PRODUCT (E.G. Oranges, Potatoes, Sugar, Ice, Macaroni, etc.) FOLLOW THIS PROCEDURE:

1. Fill bag to desired weight using samples of the product to be closed.
2. Close bag with the proper Striplok closure.
3. Check length of the bag above the closure. The proper bag length allows 4" of bag above closure (not including Lip of bag).



* Normal variations in size and density of products will occur. Oranges, grapefruit and potatoes dehydrate as the season progresses; bakery products vary due to over proofing; and density of ice will change because of certain manufacturing techniques. Therefore, the above bag length formulas take into account these variations to give maximum semi-automatic bag closing dependability.

APPENDIX

BAGNECK TRIMMER OPERATION AND MAINTENANCE



Figure A.2



Figure A.3

The bagneck trimming accessory described here is for use with the 086 Semiautomatic bag closing machine. Its purpose is to shear off the upper bag neck material during the closing cycle. The following information explains how to correctly operate and maintain this optional feature.

A. BAGNECK TRIMMER OPERATION:

To operate the trimmer follow these suggestions.

1. Grasp the product with one hand at the base of the bagneck nearest the product. Grasp the top of the bag with the other.
2. Insert the top of the bagneck into the end of the trimmer slot first, slightly ahead of the lower part of the bagneck (Figure A.2). Be sure the shear blade swivels into the shearing position.
3. Press the lower bagneck into the closure to close the package (Figure A.3).
4. Pull back on the top of the bagneck with a slight upward pressure to shear the bag (Figure A.4).
5. The bagneck is smoothly sheared, closed and the closer is ready for the next cycle (Figure A.5).



Figure A.4



Figure A.5



Guard mounting screws (2)

Figure A.6

B. REMOVE THE TRIMMER GUARD: (Figure A.6 & A.7)

1. Loosen the two guard mounting screws located on the side of the trimmer assembly.
2. Use the end of a pencil to push the front of the carriage backward away from the front of the closer and lift the trimmer cover off. This exposes the trimmer shear blade (Figure A.7).

CAUTION: THE SHEAR BLADE IS MADE OF A CERAMIC MATERIAL AND IS EXTREMELY SHARP. EXTRA CARE SHOULD BE TAKEN TO ENSURE THE SAFE HANDLING OF THIS BLADE.

C. SHEAR BLADE “LOCKOUT”

The shear blade mechanism can be “locked out” of its operating position. This is an option if the operator wants to close a product without shearing off the top of the bag.

1. Remove the trimmer guard as described in “B” above.
2. Carefully swivel the blade assembly fully open and turn the set screw into the carriage until it is flush with the top of the hole (Figure A.8). The blade assembly is now in the locked-out position.

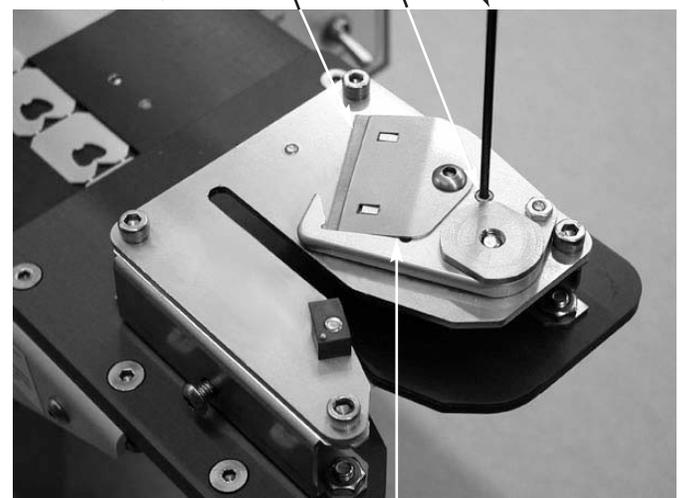
Shear blade in operating position



Figure A.7
(cover removed)

3. Replace the guard and tighten the mounting screws.

Lockout set screw
Shear blade in lock-out position
Allen hex key



Blade retainer

Figure A.8

APPENDIX

D. REMOVING AND INSTALLING A NEW BLADE (Figures A.8 & A.9):

Note: The shear blade is made of a ceramic material. This material is very hard and therefore quite brittle. Do not attempt to flex the blade as it will break.

1. Remove the trimmer guard as described in “B” above.
2. Locate the locking set screw located just in back of the blade retaining screw.
3. Carefully swivel the blade assembly fully open and turn the set screw into the carriage until it is flush with the top of the hole. The set screw locks the carriage assembly preventing it from moving while the shear blade is being changed.
4. Loosen and remove the blade retaining screw. Lift the blade retainer from the open (right-hand) side of the carriage assembly.

The shear blade is double edged. When in the operating position only one half of one edge of the blade is used to shear the bag. The shear blade can be mounted in four different positions to get the most out of a single blade. To keep track of the used blade positions, use a felt pen to mark the used portion and or side of the blade being changed (Figure A.9).

5. To remove the shear blade, lift **ONLY** from the right side of the blade. Turn the blade so it uses one of the three remaining unused blade surfaces and set it back onto the carriage surface. Be sure the blade slots are over the two mounting posts provided in the carriage assembly.

Mark used portion
of blade.



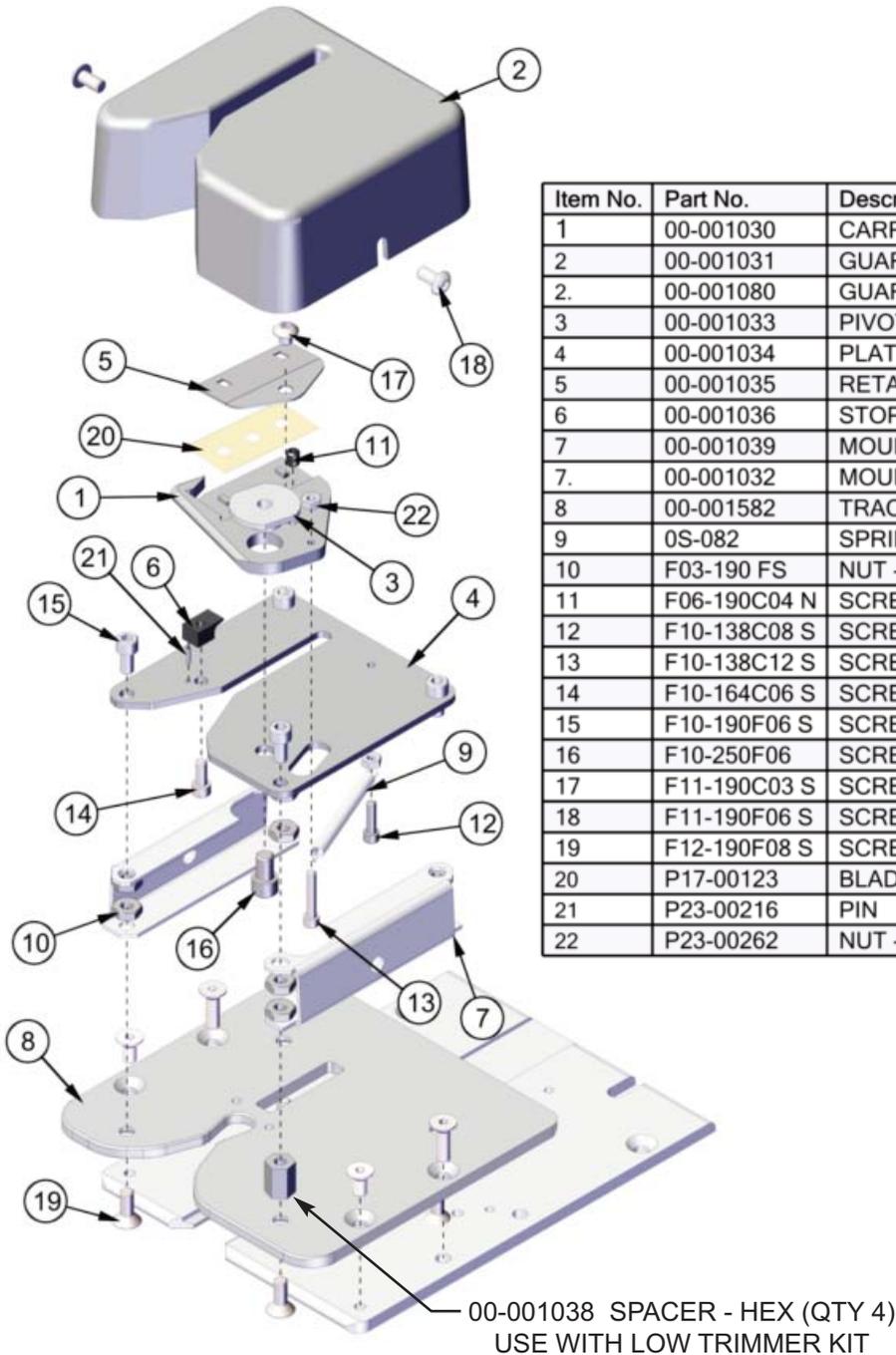
Figure A.9

Use thumb and forefinger to safely replace shear blade.

6. Carefully replace the blade retainer onto the carriage and tighten the mounting screw.
7. Screw the locking set screw out of the carriage allowing the carriage assembly to swivel into shearing position.
8. Replace the trimmer guard over the trimmer assembly and retighten the guard mounting screws.

CAUTION: NEVER OPERATE THE TRIMMER WITHOUT ALL GUARDS IN PLACE. THE SHEAR BLADE IS EXTREMELY SHARP.

TRIMMER - BAG NECK



Item No.	Part No.	Description	Qty.
1	00-001030	CARRIAGE - BLADE	1
2	00-001031	GUARD - HIGH TRIMMER	1
2.	00-001080	GUARD - LOW TRIMMER	1
3	00-001033	PIVOT - CARRIAGE	1
4	00-001034	PLATE - SHEAR - BASE	1
5	00-001035	RETAINER - BLADE	1
6	00-001036	STOP - CARRIAGE	1
7	00-001039	MOUNT - GUARD - HIGH TRIMMER	2
7.	00-001032	MOUNT - GUARD - LOW TRIMMER	1
8	00-001582	TRACK - TRIMMER RJ TOP LOK	1
9	0S-082	SPRING	1
10	F03-190 FS	NUT - 10-32UNF HEX	8
11	F06-190C04 N	SCREW - 10-24UNC X 1/4 LG SKT SET	1
12	F10-138C08 S	SCREW - 6-32UNC X 1/2 LG SKT HD CAP	1
13	F10-138C12 S	SCREW - 6-32UNC X 3/4 LG SKT HD CAP	1
14	F10-164C06 S	SCREW - 8-32UNC X 3/8 LG SKT HD CAP	1
15	F10-190F06 S	SCREW - 10-32UNF X 3/8 LG SKT HD CAP	4
16	F10-250F06	SCREW - 1/4-28UNF X 3/8 LG SKT HD CAP	1
17	F11-190C03 S	SCREW - 10-24UNC X 3/16 LG SKT BTN HD	1
18	F11-190F06 S	SCREW - 10-32UNF X 3/8 LG SKT BTN HD	2
19	F12-190F08 S	SCREW - 10-32UNF X 1/2 LG SKT FLT HD	4
20	P17-00123	BLADE - CERAMIC	1
21	P23-00216	PIN	1
22	P23-00262	NUT - 6-32UNC HEX X 1/4 FLAT	2

Figure A.10

APPENDIX



Kwik Lok[®] CORPORATION

EXECUTIVE OFFICE P.O. BOX 9548 YAKIMA, WA. 98909

TELEPHONE: 1-800-688-5945 or (509) 248-4770

FAX: (509) 457-6531

Internet: www.kwiklok.com

SUGGESTED SPARE PARTS INVENTORY FOR THE TYPE 086B CLOSER

Part no.	Description	Qty.
0S-006	Spring (silver in color)	2
0S-012	Spring (gold in color)	2
0S-117	Spring	1
0S-118	Spring	2
0S-119	Spring	1
0S-120	Spring	1
P11-00270	Fuse - 115VAC	5
P11-00616	Fuse - 220 - 250VAC	5

NOTE: Specify on the order the TYPE, MODEL, and SERIAL NUMBER of the machine for which the parts are ordered. This information will be found on the machine's nameplate.

**CONTACT THE FACTORY FOR
CURRENT PRICES.**

Kwik Lok Corporation

WARRANTY POLICY

Seller warrants to its end user customers that, for a period of one (1) year following shipment from Seller's factory, Seller's equipment will be free from material defects in workmanship or materials. In the event of a breach of the foregoing warranty, the end user customer's sole and exclusive remedy will be to return the defective equipment or component parts to Seller's factory prior to the end of such one (1) year period, freight prepaid, for repair or replacement. Seller will repair or replace the defective equipment or component parts as determined in Seller's sole discretion, and Seller return the equipment or component parts to the end user customer, freight prepaid, at the same location.

This warranty does not apply to equipment problems or failures resulting from abuse, neglect or failure to operate or maintain equipment in accordance with Seller's recommendations and instructions, or resulting from the use of any parts, supplies or services not manufactured, supplied or provided by Seller.

The disassembly of electric motors, gear motors or clutches in Seller's equipment will void this warranty as to such equipment. Whether a particular equipment or component part contains material defects in workmanship or materials, and whether this warranty is applicable to a contended defect, will be determined by Seller in its reasonable judgment.

SELLER HEREBY EXPRESSLY DISCLAIMS ALL OTHER WARRANTIES, EXPRESSED OR IMPLIED, INCLUDING ANY AND ALL WARRANTIES AS TO DESCRIPTION, QUALITY, MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE. UNDER NO CIRCUMSTANCES SHALL SELLER BE LIABLE FOR LOSS PROFITS OR OTHER CONSEQUENTIAL DAMAGES, OR FOR ANY OTHER DIRECT OR INDIRECT COSTS OR EXPENSES.

APPENDIX

KWIK LOK CORPORATION RETURNED MATERIALS AUTHORIZATION POLICY AND PROCEDURES

Prior to any products being returned, a **Return Materials Authorization** (RMA) must be obtained from *Kwik Lok Corporation*. The RMA number must be issued from the facility that the parts were originally invoiced from. Contact *Kwik Lok Corporation* requesting authorization, and an RMA number will be granted for parts initially deemed returnable.

1. Parts returned without an RMA number will be refused and returned at the shipper's expense.
2. The RMA number must be clearly marked on the return carton.
3. All returned parts must be clearly marked with the appropriate *Kwik Lok Corporation* part number.
4. Proof of purchase (*Kwik Lok Corporation* invoice number) must be provided with all returns.
5. Return for credit will not be allowed if it has been more than 120 days after the original invoice date.
6. Credit will not be issued for parts returned in excess of, or not listed on the prior approved RMA.
7. An RMA will not be issued for parts deemed obsolete, special order, non-returnable and non-cancelable items.
8. All packages must be returned freight prepaid, unless collect freight was approved at the time the RMA was issued.
9. All risks of loss and/or damage of goods in transit are the responsibility of the customer.
10. Incorrect parts shipped due to *Kwik Lok Corporation's* error are returnable, transportation collect.
11. Parts rejected by the customer due to a valid quality problem are returnable, transportation collect, for full credit or replacement under the product warranty. Refer to *Kwik Lok Corporation's* warranty policy.
12. All returns are subject to inspection so as to determine the usability of the parts. Upon completion of the inspection, *Kwik Lok Corporation* will notify the customer (within 15 days) of the results.
 - a. If the parts are determined ineligible for credit or replacement, the customer may elect to have the item(s) returned, freight collect, or discarded by *Kwik Lok Corporation* and credit will not be issued.
 - b. If the parts are determined eligible for credit, it will be issued in the amount of the *Kwik Lok Corporation* invoice less a 20% restocking charge.